

Body Side Stationary Window Replacement Pontiac Coupe

Tools Required

- [J 24402-A](#) Glass Sealant Remover (Cold Knife)
- [J 39032](#) Stationary Glass Removal Tool
- Urethane Adhesive Kit GM P/N 12346392 or Equivalent
- Isopropyl Alcohol or Equivalent
- Cartridge-type Caulking Gun
- Commercial-type Utility Knife
- Razor Blade Scraper
- Suction Cups
- Plastic Paddle

Removal Procedure

Important

Before cutting out a stationary window, apply a double layer of masking tape around the perimeter of the painted surfaces and inner trim of the window.

1. Remove the rear quarter trim panel. Refer to [Trim Panel Replacement - Rear Quarter](#) in Interior Trim.

Caution

When working with any type of glass or sheet metal with exposed or rough edges, wear approved safety glasses and gloves in order to reduce the chance of personal injury.

2. Use safety glasses and gloves.
3. Remove the quarter window applique.

Important

Keep the cutting edge of the tool against the window. This will allow the urethane adhesive to be separated from the window and leave a base of urethane on the pinchweld flange. The only suitable lubrication is clear water.

4. From the inside of the vehicle, cut around the entire perimeter of the quarter window using one of the following tools:
5. Use the [J 24402-A](#) or [J 39032](#) in order to remove the window. Do this from inside the vehicle to protect the outer surface of the paint.
6. Remove the window from the vehicle with the aid of an assistant.

Installation Procedure

1. Verify all primers and urethane adhesive are within expiration dates.

Caution

When replacing stationary windows, use Urethane Adhesive Kit GM P/N 12346392 (Canadian P/N 10952983), or a urethane adhesive system meeting GM Specification GM3651G, to maintain original installation integrity. Failure to use the urethane adhesive kit will result in poor retention of the window which may allow unrestrained occupants to be ejected from the vehicle resulting in personal injury.

2. Inspect the following components for possible causes of a broken window:
 - The flange of the window opening
 - The window reveal molding
3. Inspect for any of the following problems in order to help prevent future breakage of the stationary window:
 - High weld
 - Solder spots
 - Hardened spot weld sealer
 - Any other obstruction or irregularity in the pinchweld flange.

Important

If corrosion of the pinchweld flange is present, or if sheet metal repairs or replacements are required, the pinchweld flange must be refinished in order to restore the bonding area strength. If paint repairs are required, mask the flange bonding area prior to applying the color coat in order to provide a clean primer only surface. Materials such as BASF DE17®, DuPont 2610®, Sherwin-Williams PSE 4600 and NP70® and Martin-Semour 5120 and 5130® products are approved for this application.

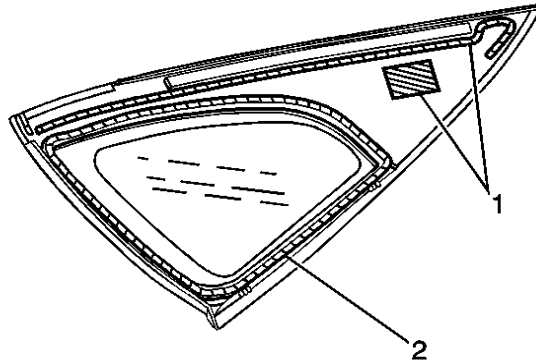
Make any necessary repair to the pinchweld flange.

4. After repairing the opening as indicated, perform the following steps:
 - Inspect the condition of the window opening and the adhesive bead to determine which installation method should be used.
 - Remove no more of the urethane adhesive from the pinchweld than necessary in order to maintain the original shape. This will ensure the proper clearance between the window and the pinchweld flange.
 - Clean around the edge of the inside surface of the window with a 50/50 mixture of isopropyl alcohol and water by volume on a dampened lint free cloth.
5. After repairing the opening as indicated, shake the pinchweld primer (black #3) for at least 1 minute.

Caution

Failure to prep the area prior to the application of primer may cause insufficient bonding of urethane adhesive. Insufficient bonding of urethane adhesive may allow unrestrained occupants to be ejected from the vehicle resulting in personal injury.

6. Use a new dauber to apply the pinchweld primer (black #3) to the surface of the bonding area.



7. Allow the primer to dry for approximately 10 minutes, also check to ensure that all nicks and scratches are covered.



8. With the aid of an assistant, dry fit the stationary window (1) into the opening.
9. Use masking tape in order to mark the location of the stationary window in the opening.
10. Slit the masking tape at the top edge of the stationary window.
11. Remove the stationary window from the opening.
12. Place the stationary window on a clean, protected surface.
13. If the original window is being reused, remove all but a thin film of the existing urethane adhesive from the window surface by using a clean utility knife or razor blade scraper.

Important

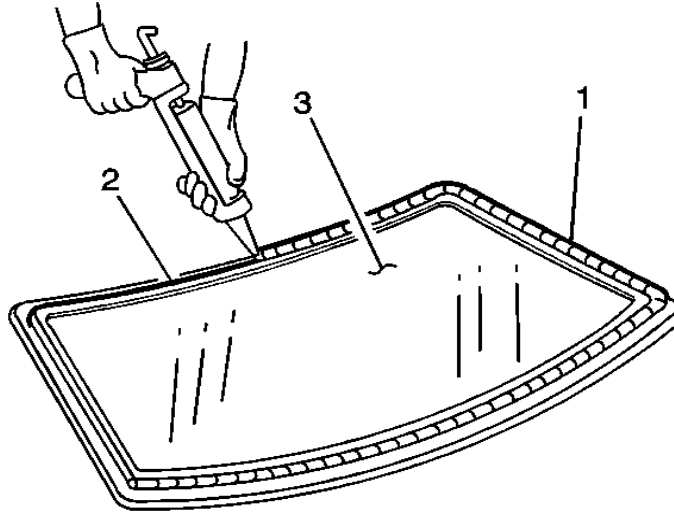
Do not remove all traces of the adhesive. Remove all mounds or loose pieces of urethane adhesive.

14. If the extended method is being used remove all but approximately 2 mm (3/64 in) of the existing bead of adhesive from the pinchweld flange.
15. Clean around the edge of the inside surface of the window with a 50/50 mixture of isopropyl alcohol and water by volume on a dampened lint free cloth.

Important

Do not apply the (black #3) primer to the existing bead of the urethane adhesive. Apply the primer only to nicks, scratches or the primed surfaces.

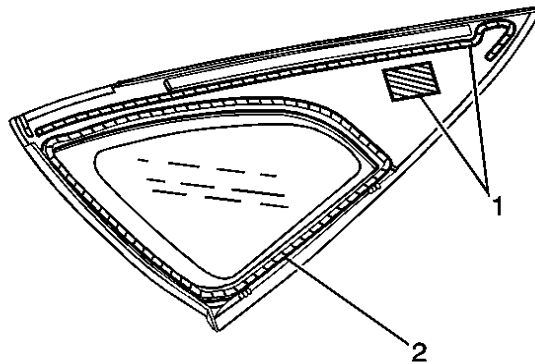
16. Shake the pinchweld primer (black #3) for at least one minute.
17. Use a new dauber to apply the primer to the surface of the pinchweld flange.



18. Allow the glass primer to dry for approximately 10 minutes.



19. Use a cartridge type caulking gun to apply a smooth, continuous bead of urethane adhesive (1) to the edge (2) of the stationary window (3).

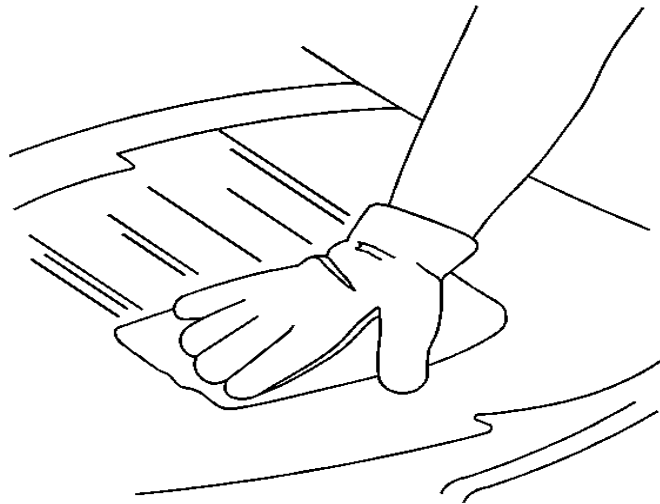


20. When using the short method, apply the urethane adhesive to the existing bead of urethane adhesive on the body.



21. When using the extended method, use the edge of the stationary window as a guide for the nozzle in order to apply the urethane adhesive (2) to the inner surface of the stationary window (1).

22. Use suction cups and, with the aid of an assistant, install the stationary window into the opening.
23. Align the tape on the stationary window and the body.
24. Press the stationary window firmly into place.



25. Tape the stationary window to the body in order to minimize movement.



26. Clean any excess urethane adhesive from the body.

Important

Do not direct a hard stream of high pressure water to the freshly applied urethane adhesive.

27. Use a soft spray in order to water test the stationary window immediately.
28. If any leaks are found, use a plastic paddle in order to apply extra urethane at the leak point.
29. Retest stationary window for leaks.

Caution

Insufficient curing of urethane adhesive may allow unrestrained occupants to be ejected from the vehicle resulting in personal injury.

- **For the moisture-curing type of urethane adhesive, allow a minimum of 6 hours at 21°C (70°F) or greater and with at least 30 percent relative humidity. Allow at least 24 hours for the complete curing of the urethane adhesive.**
- **For the chemical-curing type of urethane adhesive, allow a minimum of 1 hour .**

Do NOT physically disturb the repair area until after these minimum times have elapsed.

30. The following conditions must be maintained to properly cure the urethane.
 - Partially lower a door window in order to prevent pressure buildups when closing doors before the urethane adhesive cures.
 - Do not drive the vehicle for 24 hours which will allow the urethane adhesive to fully cure.

- Do not use compressed air in order to dry the urethane adhesive.
31. Install the rear quarter trim panel. Refer to [Trim Panel Replacement - Rear Quarter](#) in Interior Trim.
 32. Remove the protective coverings and tape from the vehicle and the headliner.
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