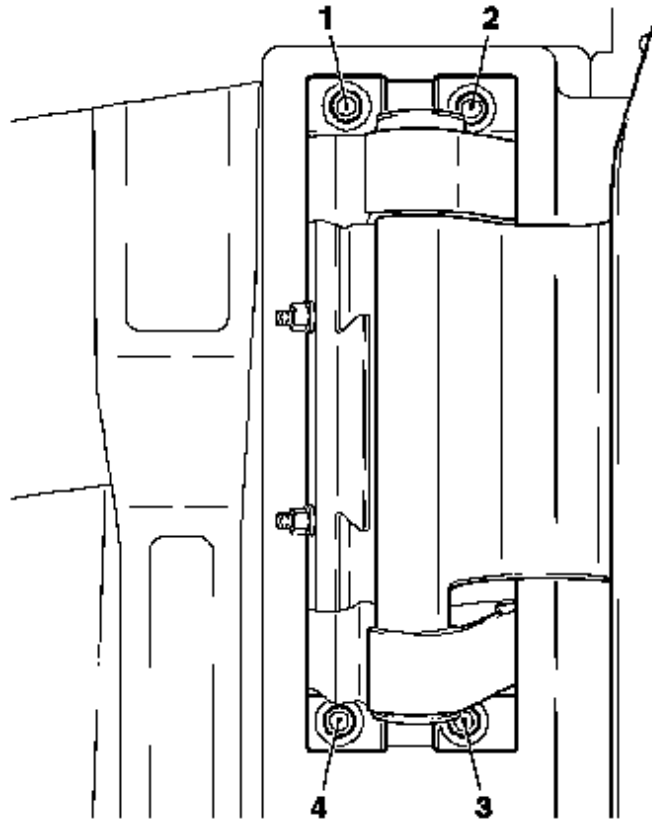


## Windscreen Frame, Replace



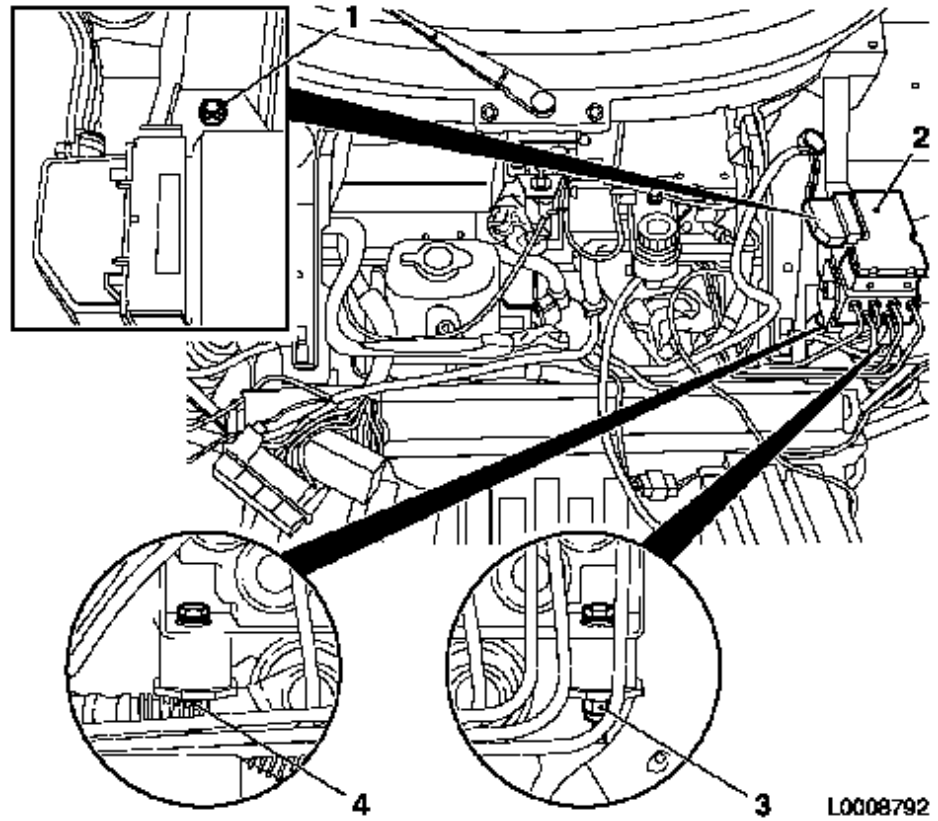
### Remove

1. Detach front clamshell
  - see operation "Front Clamshell, Remove and Install".
2. Includes disconnecting and connecting battery.
3. Remove right door
  - 4 screws (1 – 4) to A-pillar
4. Remove left door
  - 4 screws (1 – 4) to A-pillar



L0008791

5. Remove front wheels
6. Syphon off brake fluid
7. Remove ABS module (2)
  - 3 nuts (1, 3 and 4)
  - Move module to one side and fix in place



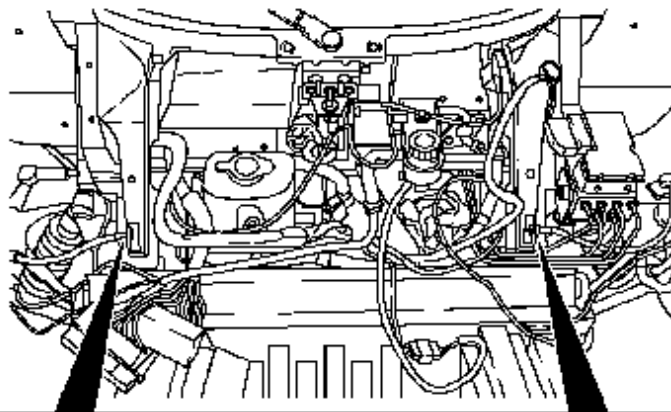
L0008792

**8. Disconnect left brake line duct (I)**

- Disconnect duct through windscreen frame base

**Note:** Do not damage ABS module

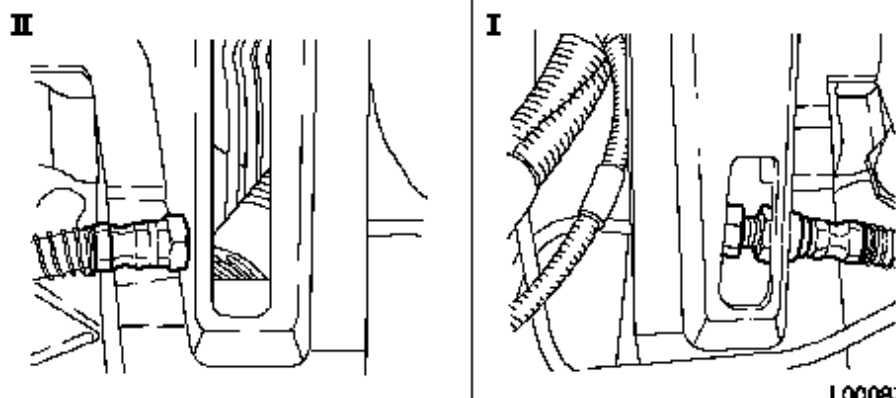
- Detach brake line
- Detach brake hose



**9. Disconnect right brake line duct (II)**

- Disconnect duct through windscreen frame base

- Detach brake line
- Detach brake hose

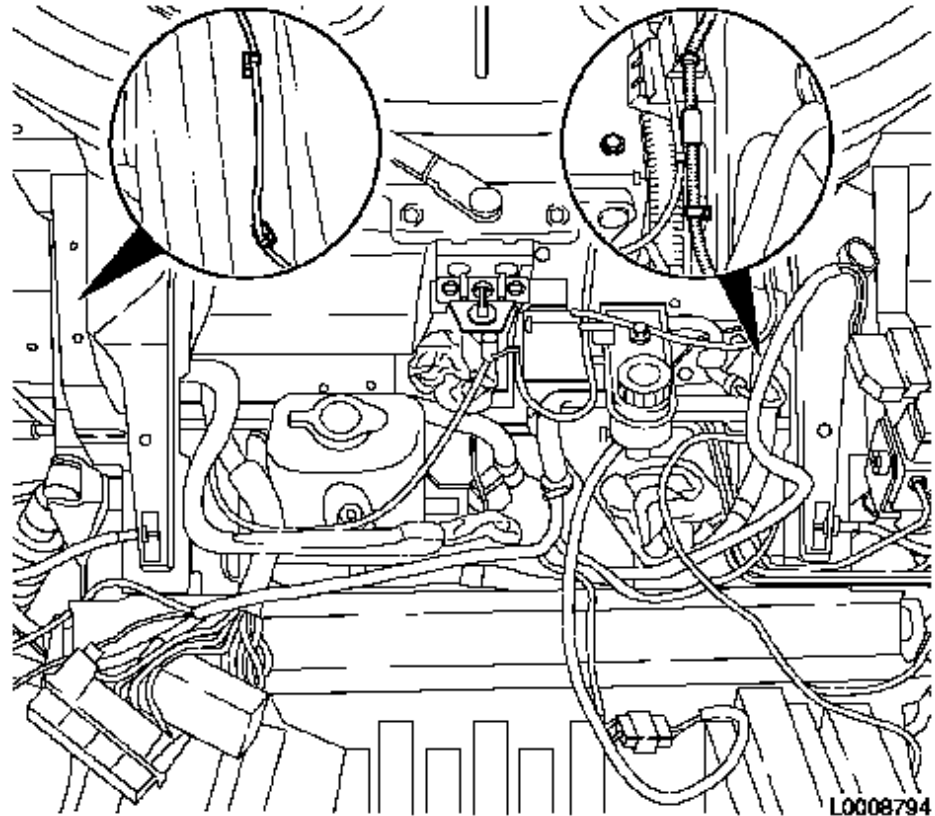


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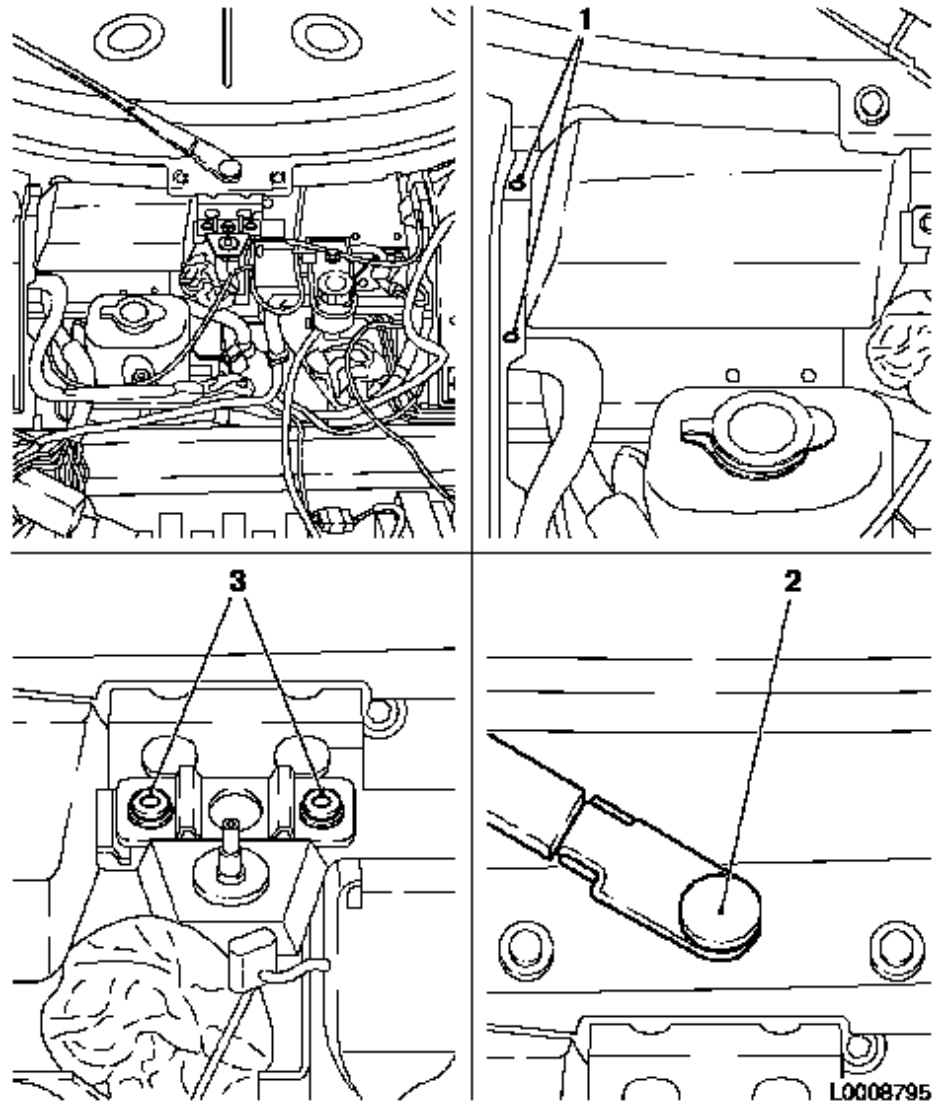
**10. Release front wiring**

harness (clips)

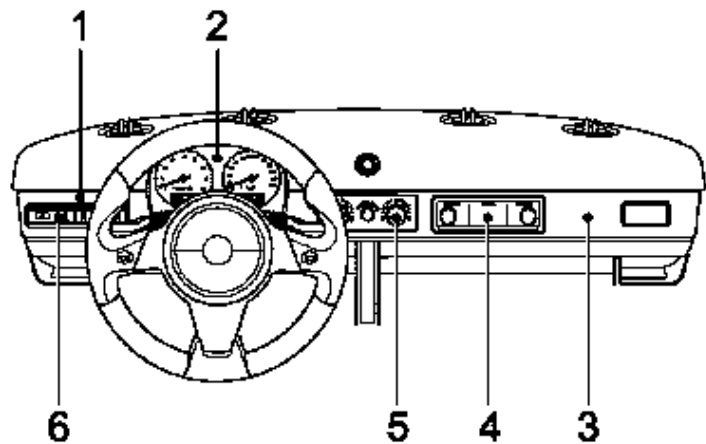
- KBS flashers left and right



11. Detach windscreen wiper motor panel
  - 2 cross head screws (1)
  - Disconnect relay and KBS plug
12. Remove front bonnet lock
  - 2 hexagon socket bolts (2)
13. Detach windscreen wiper arm
  - 1 nut (3)

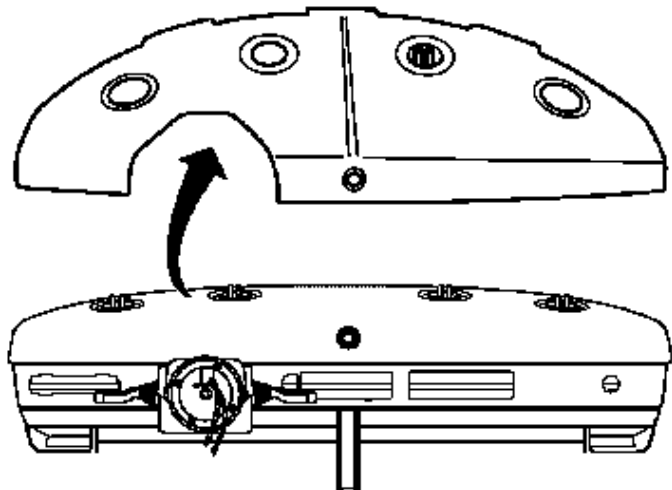


14. Detach steering wheel
  - see operation "Steering Wheel, Remove and Install".
15. Detach instrument panel controls
  - Detach panel (1 and 3)
    - fastened in place with double-sided adhesive tape
  - Remove radio (4)
  - Remove heater control panel (5)
    - 4 screws
    - Detach plate
  - Remove light switch centre (6)
    - 4 screws
  - Remove instrument panel (2)
    - 2 screws



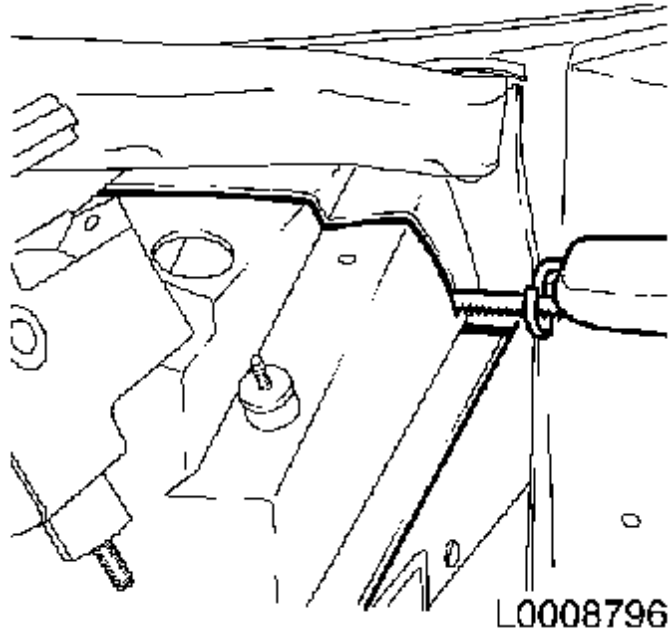
T 9575

16. Detach instrument panel upholstery
- Remove instrument cluster
    - 2 screws
    - Take out upwards
  - Disconnect starter button
  - Detach instrument panel upholstery
    - 4 screws

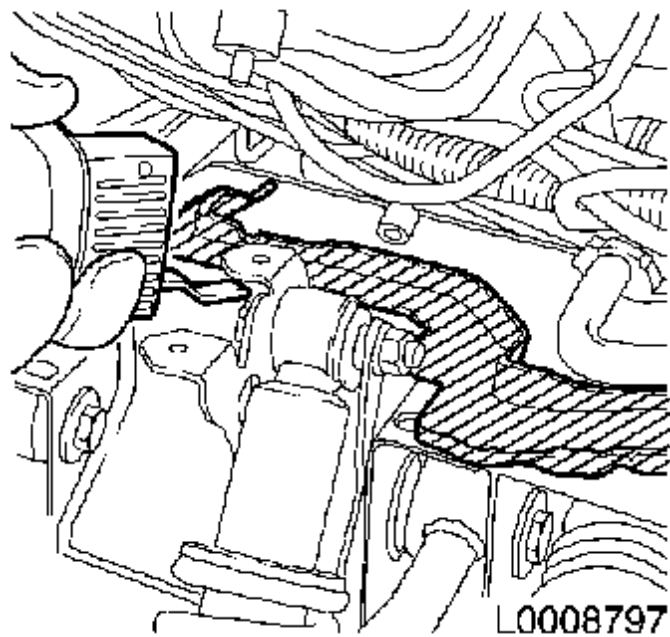


T 9577

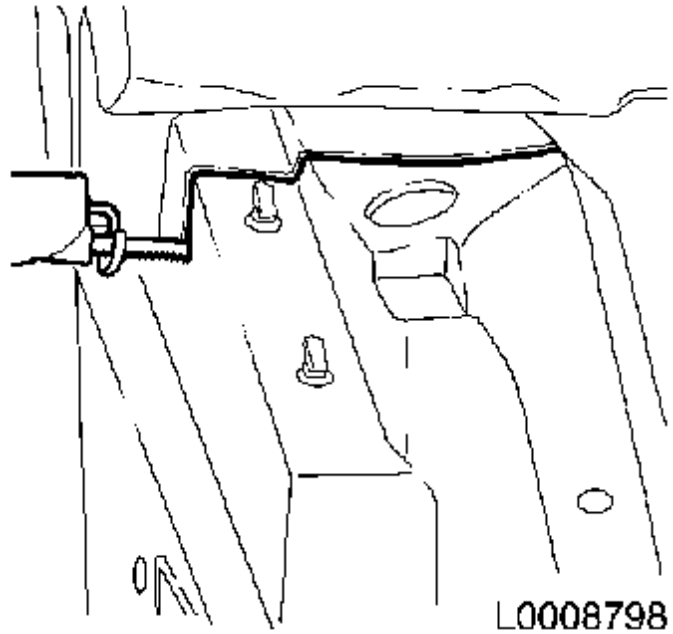
17. Remove instrument panel
- Remove aluminium strip
    - 4 screws
18. Detach left windscreen frame base
- Important:** Do not damage cables and coolant pipes
- Detach roughly using pneumatic saw



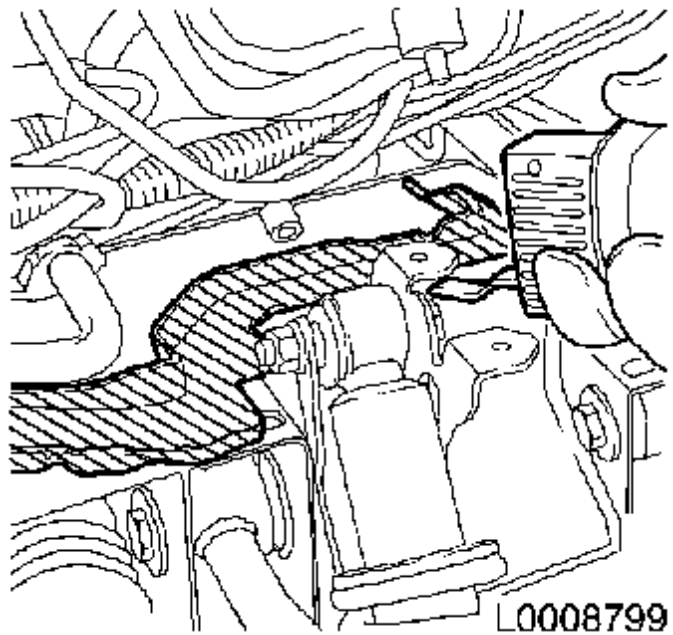
19. Remove adhesive residues on left side
- Important:** Do not damage cables and coolant pipes
- Cut adhesive with scalpel



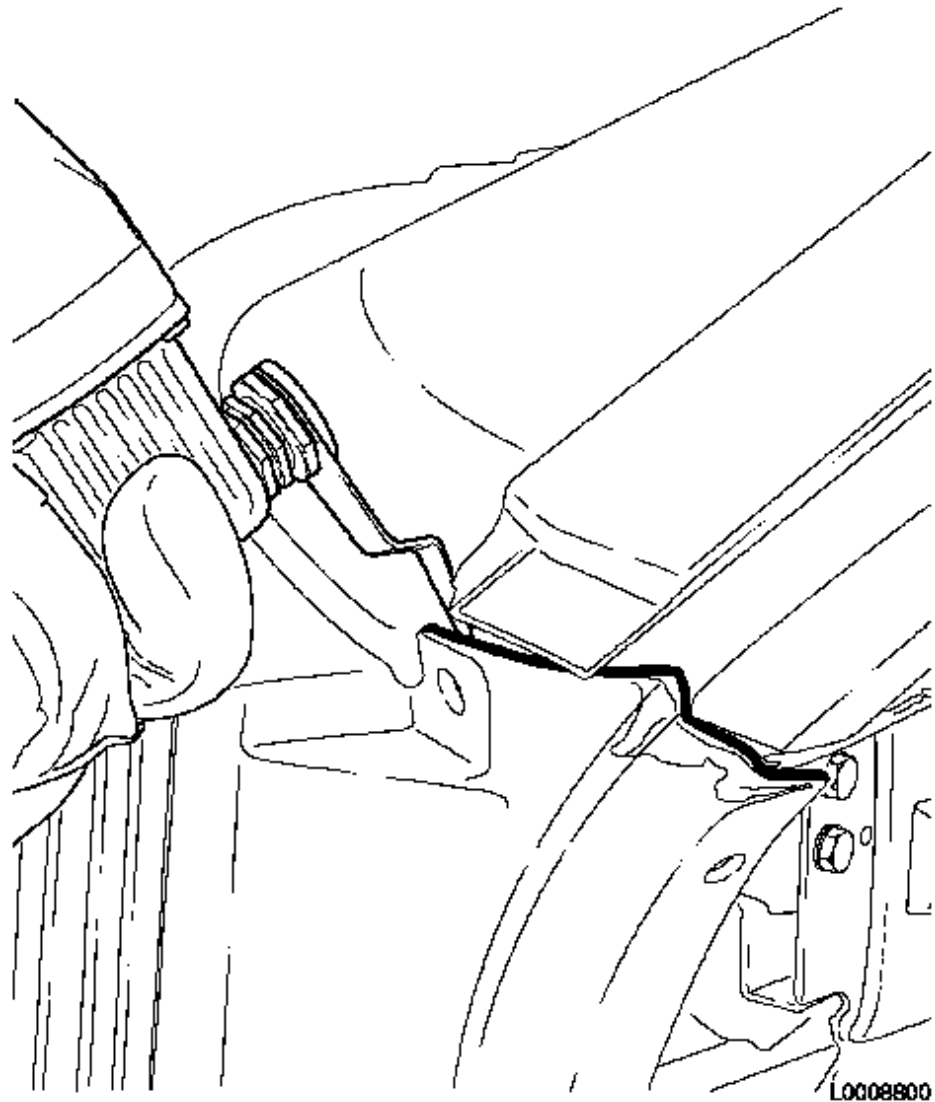
20. Detach right windscreen frame base



21. Remove adhesive residues on right side



22. Detach windscreen frame on outer left side
- Scalpel
23. Detach windscreen frame on outer right side



**24.** Cut out windscreen frame

- Roughly detach windscreen frame base using pneumatic saw

**Important:** Do not damage cables, coolant pipes and remaining body components

Do not damage air duct tunnel under windscreen frame

- Remove adhesive completely with scalpel
  - Detach windscreen frame at line shown (1)

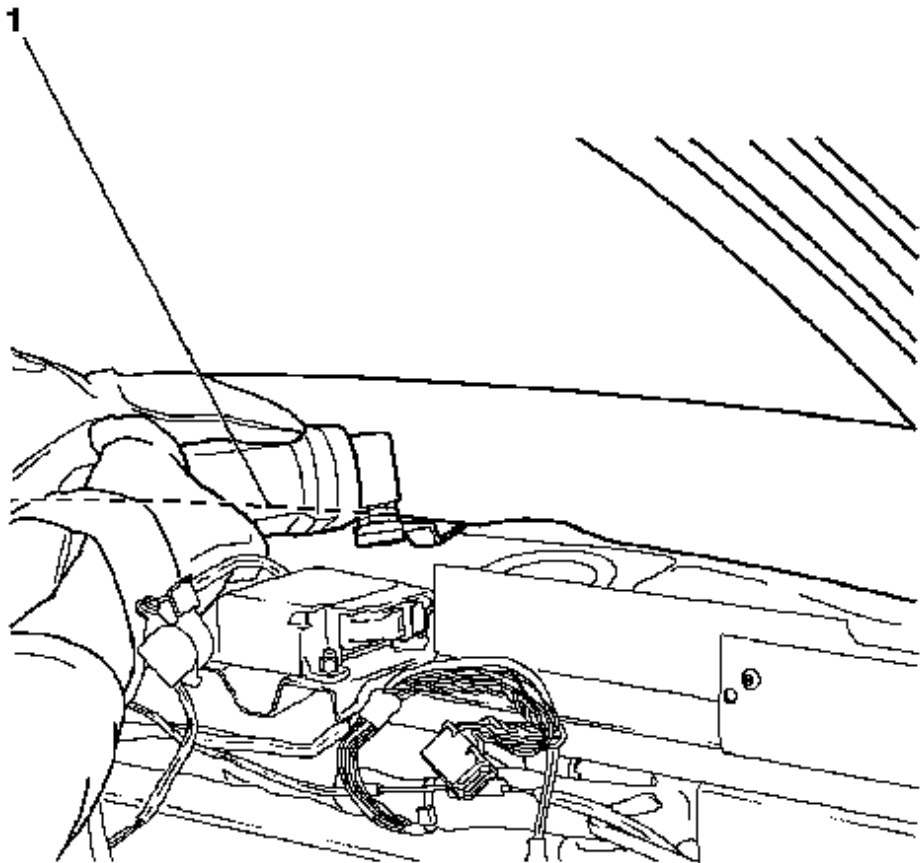
**25.** Remove windscreen



frame

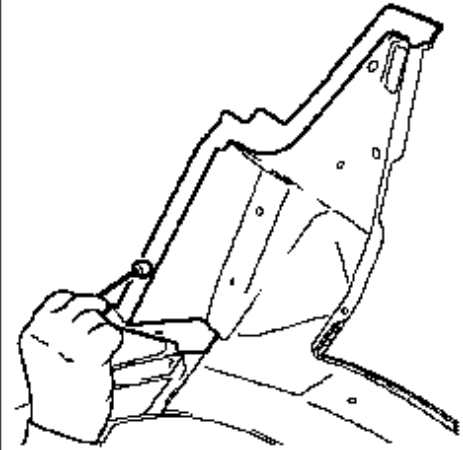
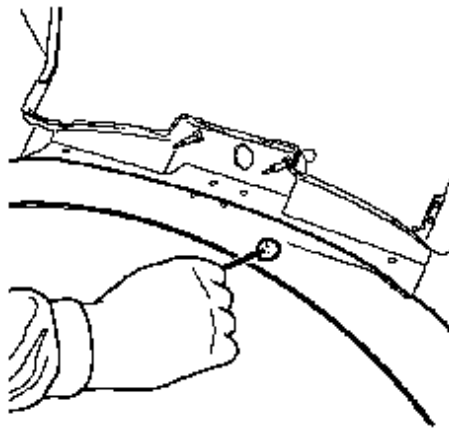
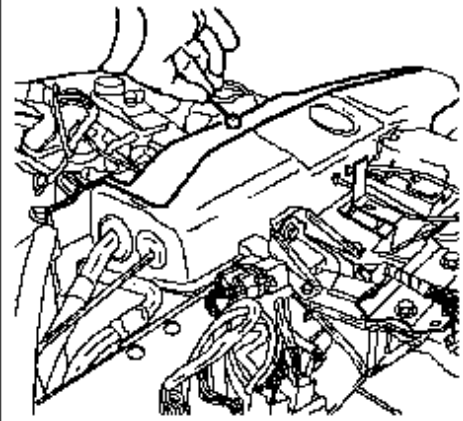
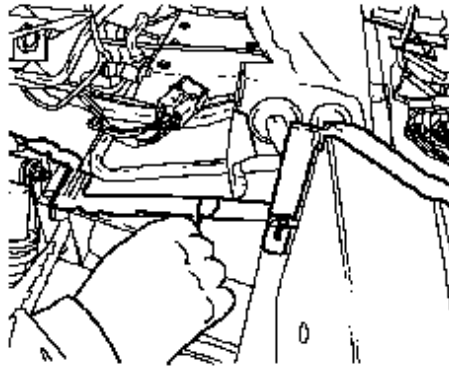
**Note:** 2nd technician required

26. Remove adhesive residues from windscreen frame
- Remove evenly using scalpel and scraper



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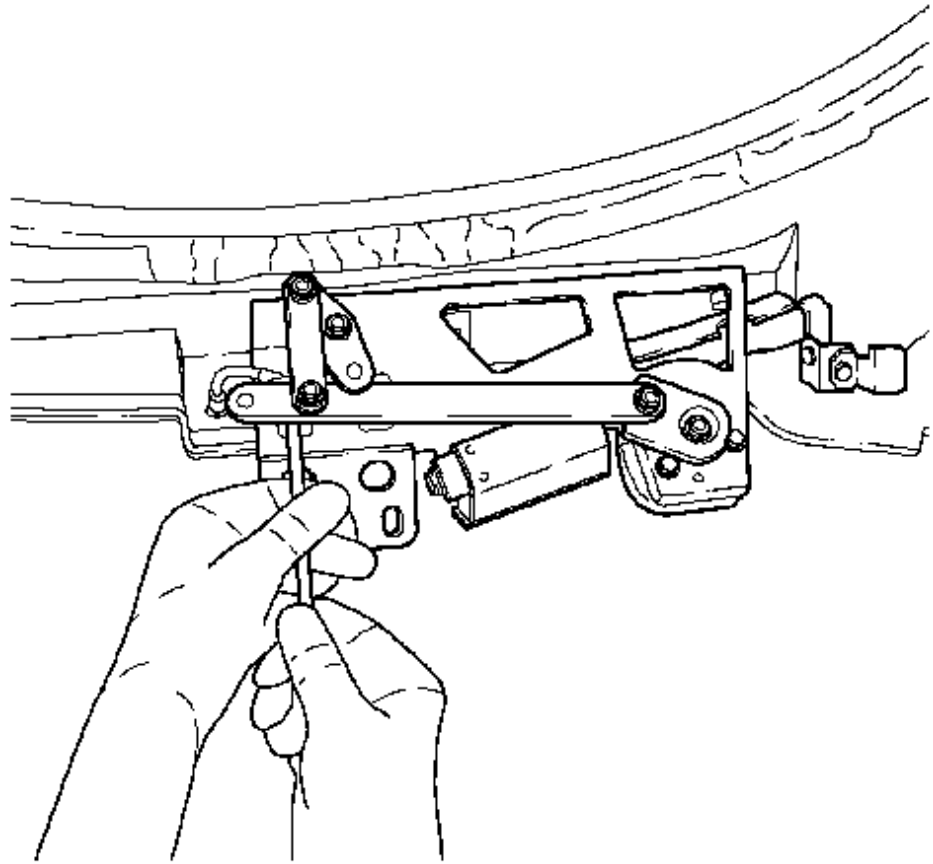
27. Clean adhesive areas of windscreen frame
- Clean adhesive areas on vehicle and windscreen frame
    - Use cleaner from the adhesive pack
28. Apply primer to adhesive areas of windscreen frame
- Coat adhesive areas with primer from the adhesive pack
- Note:** 15 min  
Observe drying time



L0008802

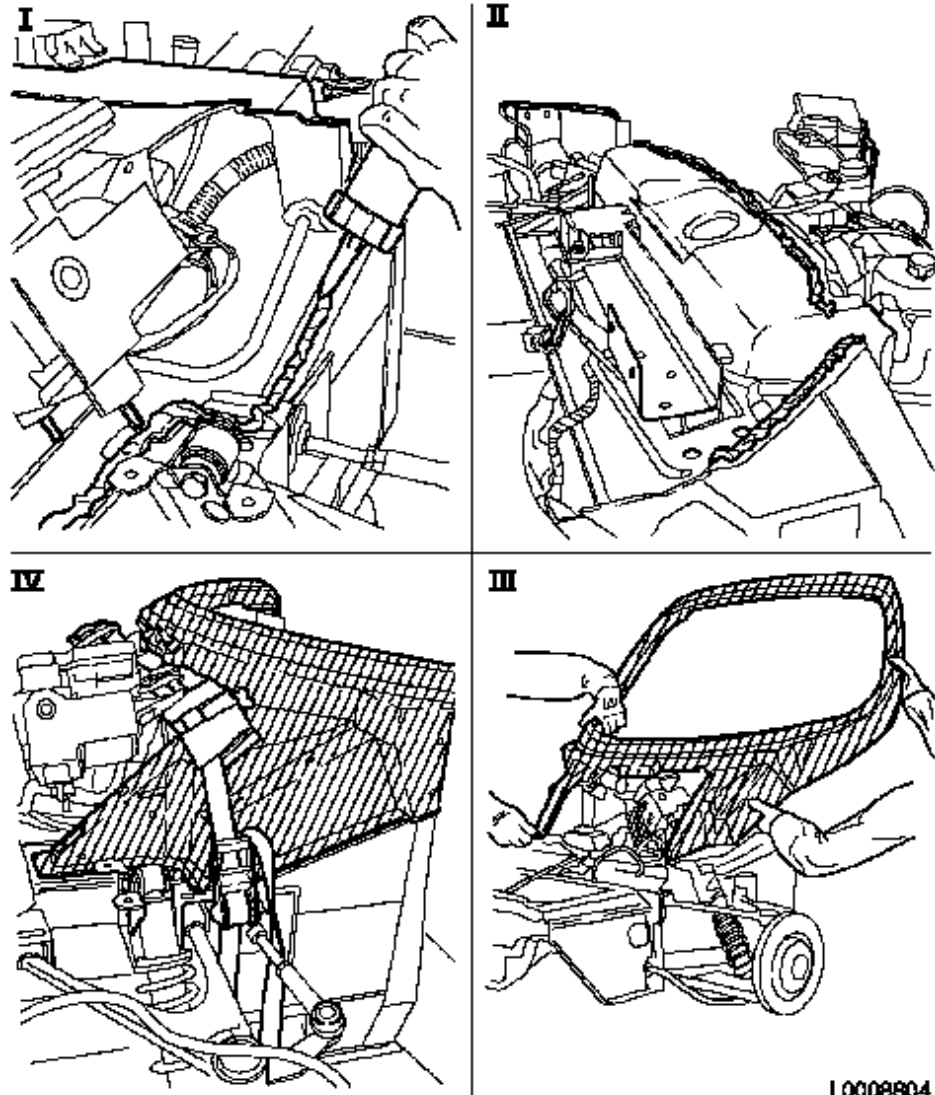
- 29.** Detach ancillary components from windscreen frame
- Detach fuse holders
    - 1 screw each
  - Detach windscreen wiper drive mechanism
    - 5 screws
  - Detach hose for windscreen washer jets and rubber seal
- 30.** Attach ancillary components to windscreen frame
- Attach fuse holders
    - 1 screw each

- Attach windscreen wiper drive mechanism
  - 5 screws
- Attach hose for windscreen washer jets



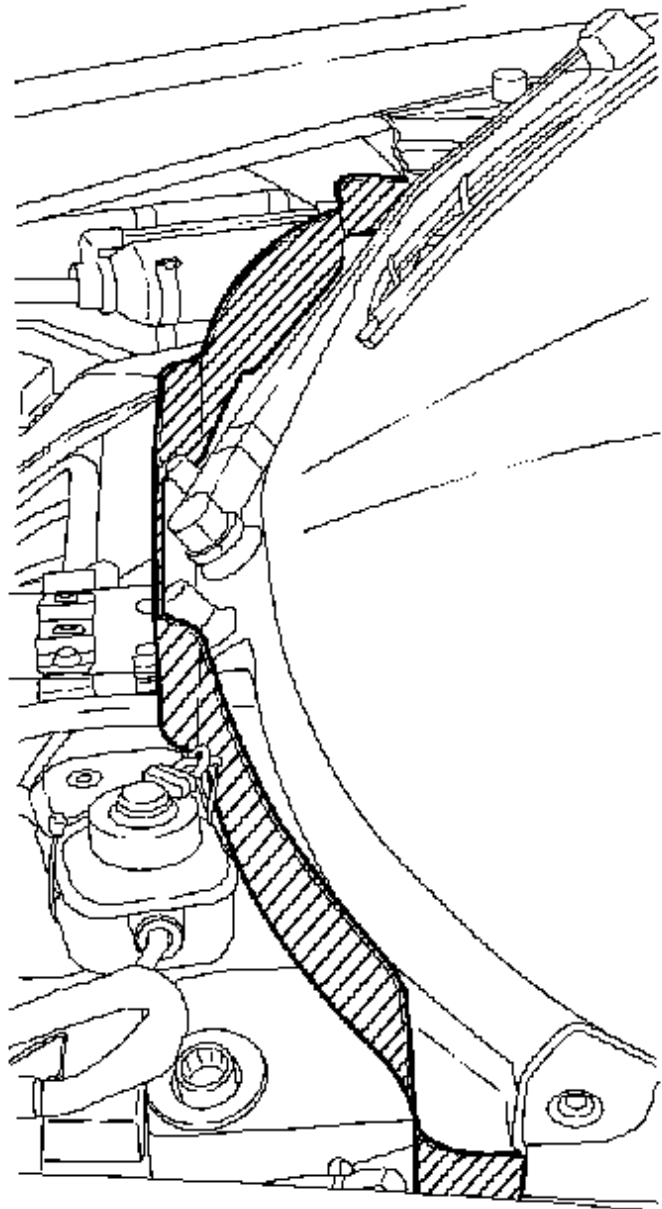
L0008803

31. Apply adhesive (I, II)
32. Insert windscreen frame (III)  
**Note:** 2nd technician required
33. Fix windscreen frame in place (IV)
  - Attach retaining straps
  - Note:** Observe drying time for glass adhesive
34. Remove windscreen frame clamp



L0008804

35. Glue on water deflector
- Clean adhesive areas and apply primer
  - **Note:** 15 min Observe drying time
  - Apply adhesive
  - Attach strip



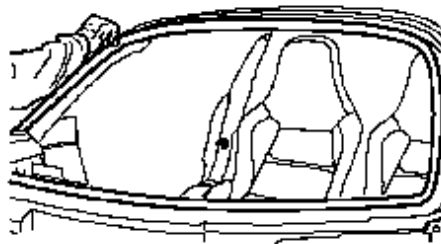
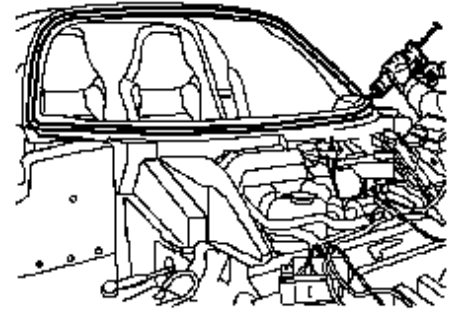
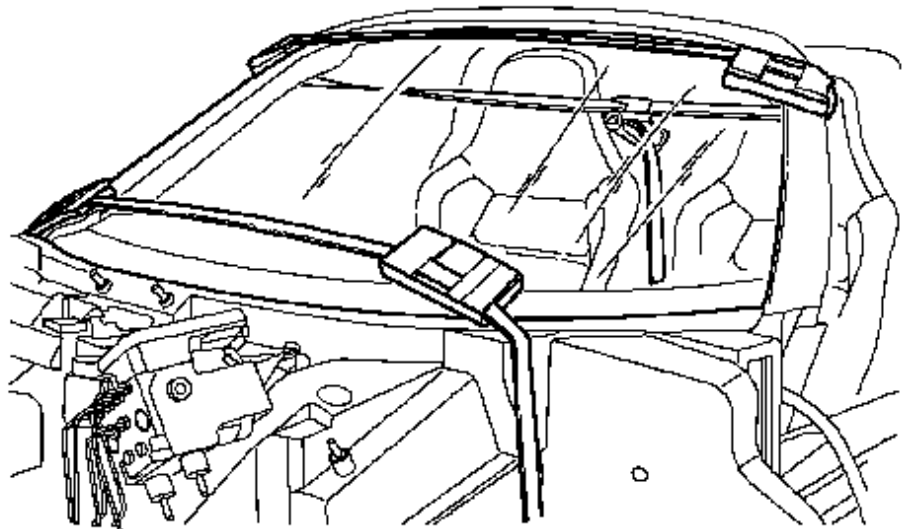
L0008824

36. Clean adhesive area of windscreen (I)
37. Apply primer to adhesive area of windscreen
  - Apply primer and activator to frame and windscreen

**Note:** 15 min  
Observe drying time
38. Apply windscreen adhesive (II)
39. Insert windscreen

**Note:** 2nd technician required

40. Fix windscreen in place (III)
- Attach retaining straps
- Note:** Observe drying time for glass adhesive

**I****II****III**

L0008826

**Install**

41. Attach windscreen wiper motor panel
- 2 cross head screws
  - Connect relay and KBS plug
  - Attach water hose
42. Install front bonnet lock
- 2 hexagon socket screws
    - Tightening torque **16 Nm**
43. Attach left brake line duct
- Important:** Do not damage ABS module
- Connect duct through windscreen frame base
- Note:** difficult access
- Detach brake line
  - Detach brake hose
44. Attach right brake line duct
- Connect duct through windscreen frame base

**Note:** difficult access

- Detach brake line
- Detach brake hose

45. Install ABS module
  - 3 nuts
46. Bleed braking system
47. Check braking system for leaks
48. Install front wiring harness
  - KBS flashers left and right
49. Attach instrument panel
  - Install aluminium strip
    - 4 screws
50. Attach instrument panel upholstery
  - Install instrument cluster
    - 2 screws
  - Install starter button
  - Attach instrument panel upholstery
    - 4 screws
51. Attach instrument panel controls
  - Attach panel.
    - fasten in place with double-sided adhesive tape
  - Install radio.
  - Install heater controls
    - 4 screws
    - Install light switch centre
    - 4 screws
  - Install instrument panel
    - 2 screws
52. Attach steering wheel
  - Attach steering wheel
    - 1 nut
    - 4 hexagon socket screws
    - 2 hexagon socket screws for airbag
  - Attach steering wheel trim
    - 6 screws
53. Attach mirror
  - see operation "Mounting Plate – Interior Mirror, Replace"
54. Install front wheels
  - Tightening torque **90 Nm**
55. Install right door
  - 4 screws to A-pillar
    - Tightening torque **45 Nm**
56. Install left door
  - 4 screws to A-pillar
    - Tightening torque **45 Nm**
57. Attach front clamshell
  - see operation "Front Clamshell, Remove and Install"

**58.** Cleaning work