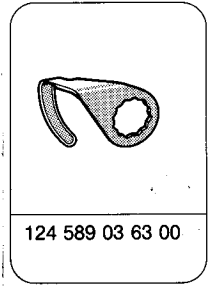
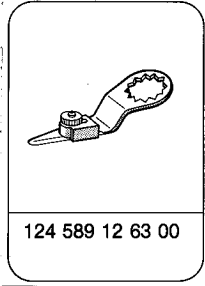


67-200 Removal and installation of back window

A. Sedan

Special tools



Conventional tools

e.g. Company, Order no.

Multi-cutter

Chicago Pneumatic
D-65366 Geisenheim
CP 838-12

Suction lifter

Karl Assfalg KG, Buchstraße 149
D-73525 Schwäbisch Gmünd
602-2

Electric gun with battery

Weiler & Co.
Postfach 1269
D-76287 Rheinstetten, Baden
Pressofix 108, Electronic, SDF-108 E

Parts

Repair pack for glazing
windshield or back window glass

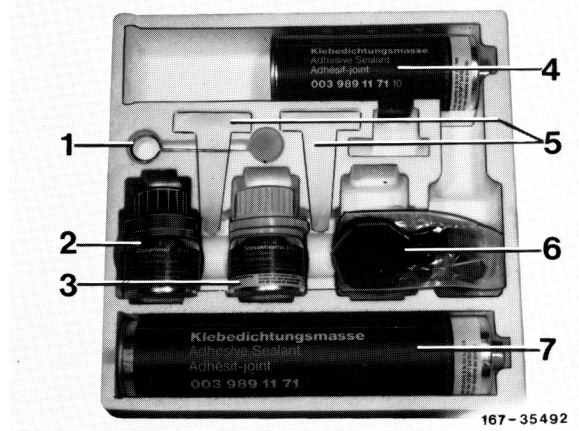
124 670 01 93

MB parting compound

000 986 39 36

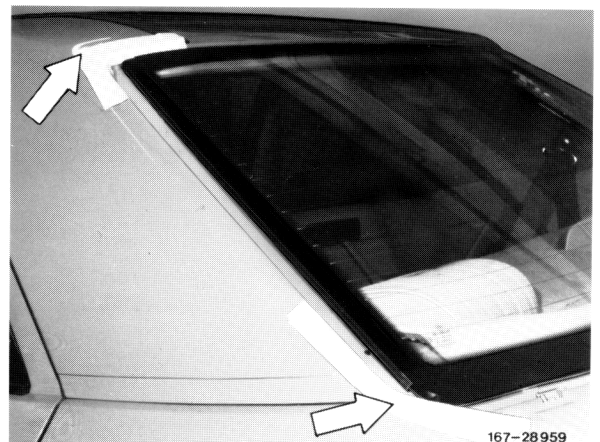
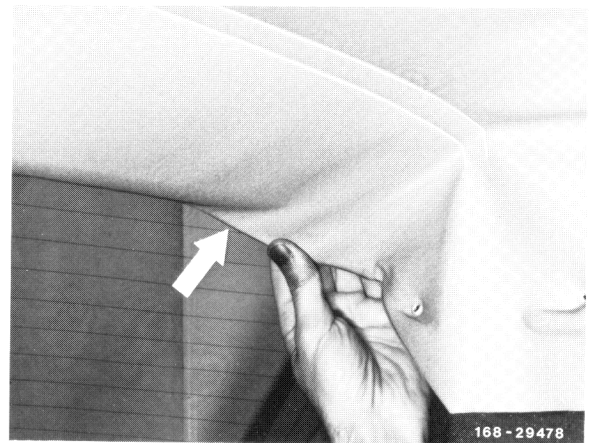
Scope

- 1 Coating brush
- 2 Glass primer
- 3 Glass activator (cleaner)
- 4 Betaseal glueing material 150 ml
- 5 Coating nozzles
- 6 Cutting wire, spacing blocks, spacing angle brackets, spacing rubber and cleaning cloth
- 7 Betaseal glueing material 300 ml



Removal

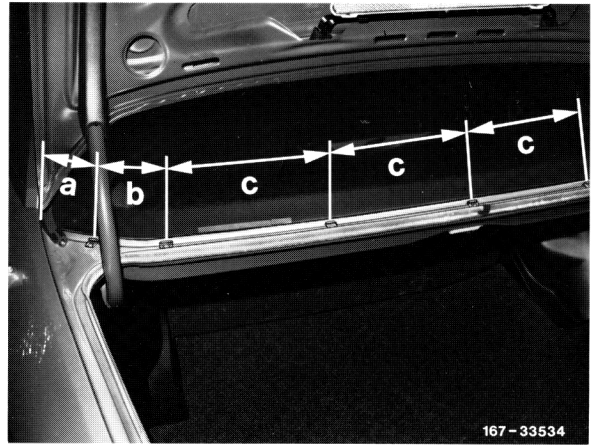
- 1 Remove trim on rear pillar left and right (68-449, do not unscrew end fitting of belt).
- 2 Disconnect electric connections on lefthand and righthand rear pillar.
- 3 Disconnect headlining at holding rail on back window, top.
- 4 Remove trunk lid (88-500).
- 5 Protect corners at pane cutout of body against damage by means of adhesive tape.



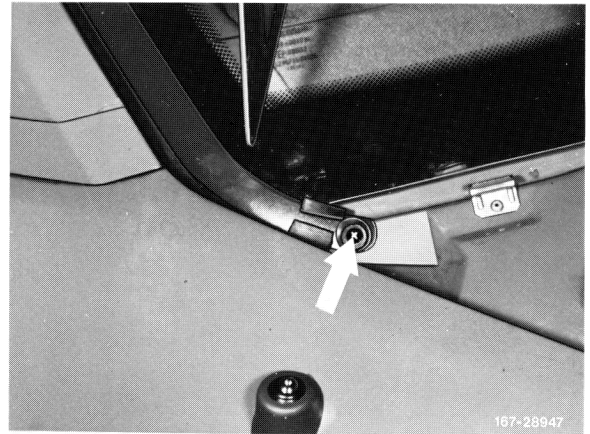
6 Force off lower cover.

Note: To make sure that the cover is not damaged when forced off, position plastic wedge only in range of clips (7 each).

a = 100 mm
b = 120 mm
c = 260 mm



7 Unscrew screw at left and right.

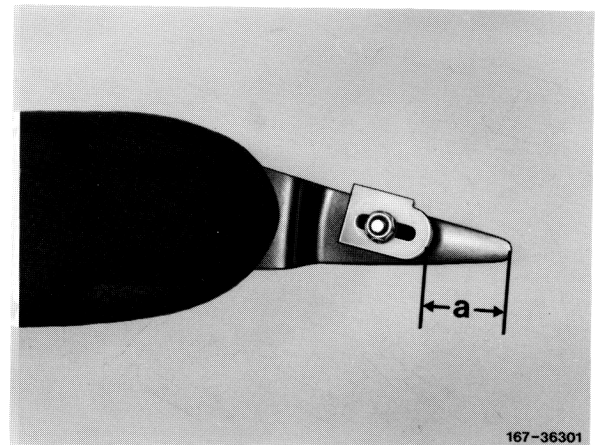


8 Locate multi-cutter available for use (air supply interrupted).

9 Clamp knife no. 1 into multi-cutter and set stop as required (dimension a = 18 mm).

10 Moisten oil stone, connect air supply and sharpen both sides of knife with machine switched on.

11 Switch off multi-cutter.



Attention!

Wear goggles.

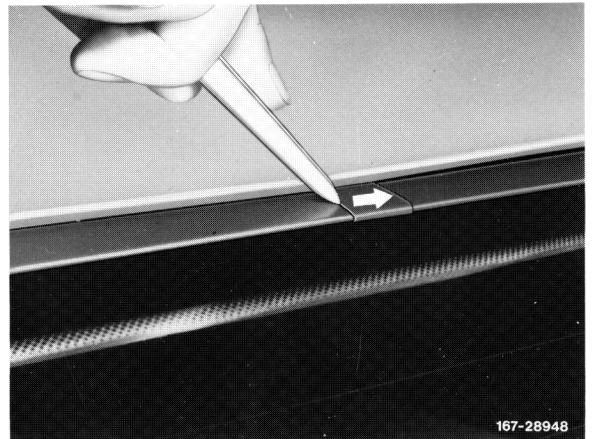
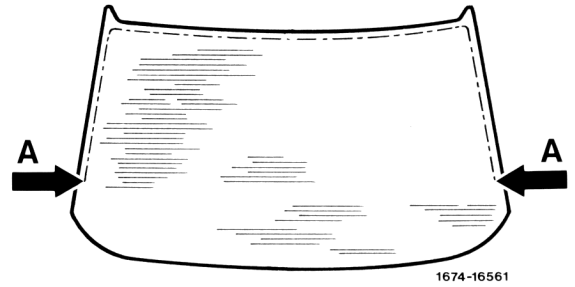
12 Move into operating position on rear seat.

13 Switch on multi-cutter, plunge-cut with knife at starting point "A" and cut through adhesive bead, guiding knife in parallel with glass, in upward direction toward vehicle center.

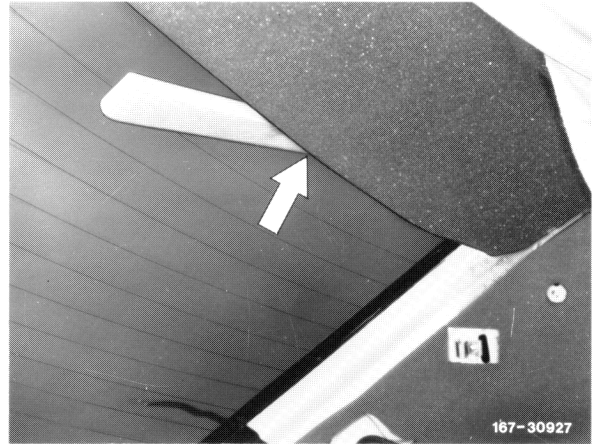
14 Switch off multi-cutter.

15 Change knife no. 1 for knife no. 2 and sharpen (item 9).

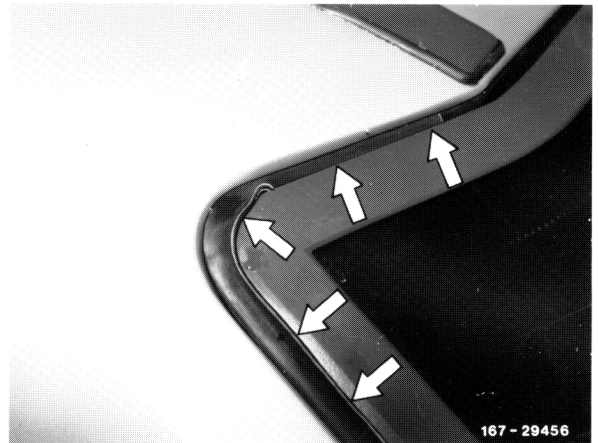
16 Push connecting link aside.



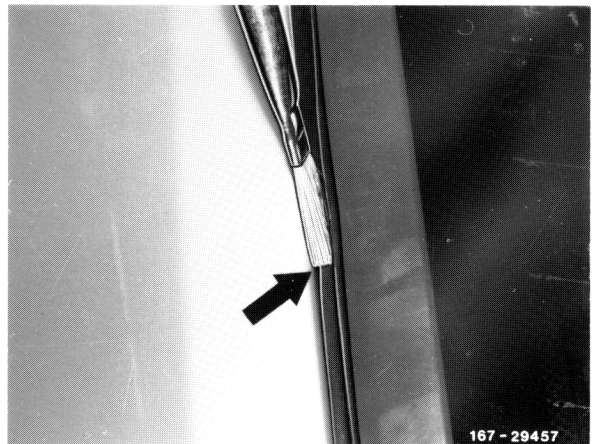
17 Push glass pane in upper range carefully in outward direction and slip plastic wedges in-between glass and glue flange.



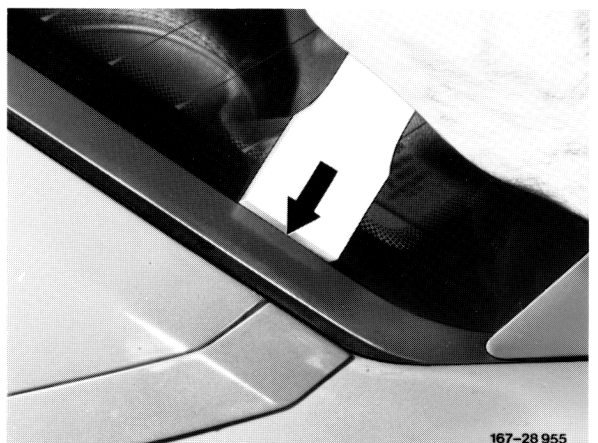
18 Place rubber lip at upper corners over trimstrip.



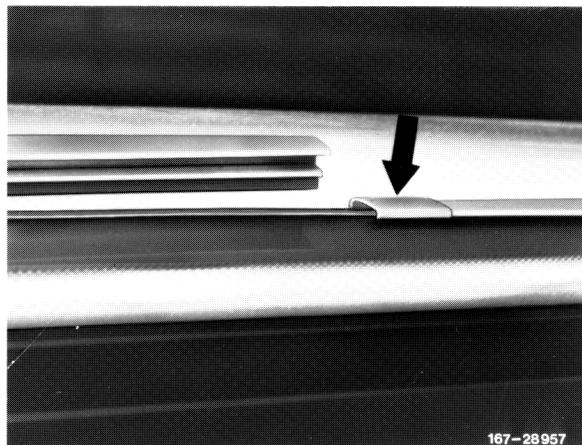
19 Push rubber cover on trimstrip aside and apply soap solution all-around between rubber and body.



20 Starting from below, push trimstrip with punch outwards up to upper corner. Then push trimstrip at top from connecting link toward corner in upward direction away from glass pane.



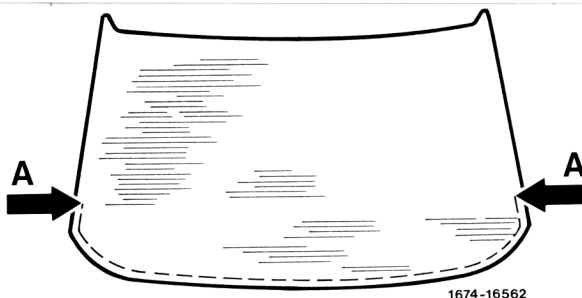
21 Pull out trimstrip at top starting at center.
Remove link (arrow).



22 Remove wedges (item 20).

23 Move into operating position adjacent to rear fender.

24 Lift glass in upper range from body and introduce knife from outside into gap.



25 Switch on multi-cutter and cut through glueing bead, beginning at starting point "A".

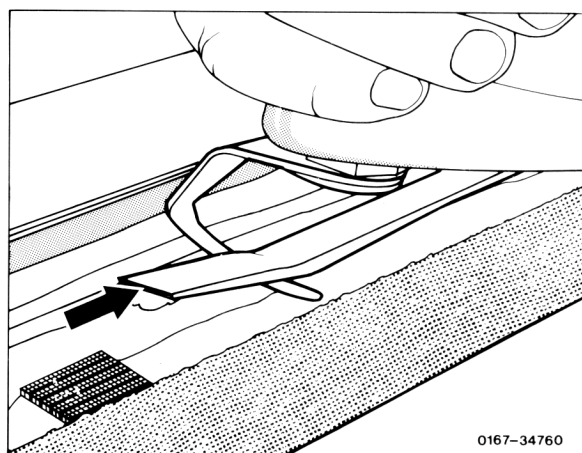
Note: If the glueing material cannot be completely cut through with the available knives, use cutting wire.

26 Remove pane with suction lifter.

Installation

27 Cut off remaining glue material on body flange with blade no. 2. Max. 2 mm may remain. Pull off loose glue material (residual pieces not completely cut off).

28 Do not cover damaged paint spots on body flange with glue material, brush over with priming pencil part no. 000 986 06 50.



Shown on model 124 coupe

29 Prepare glass for glazing.

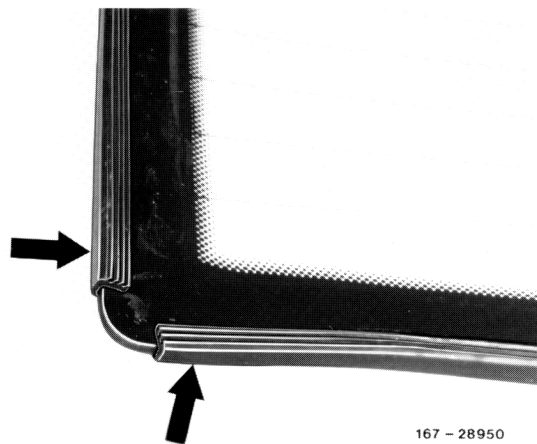
When using the previously installed glass pane:

30 Cut off residual glueing material on glass down to a few tenths of a millimeter.

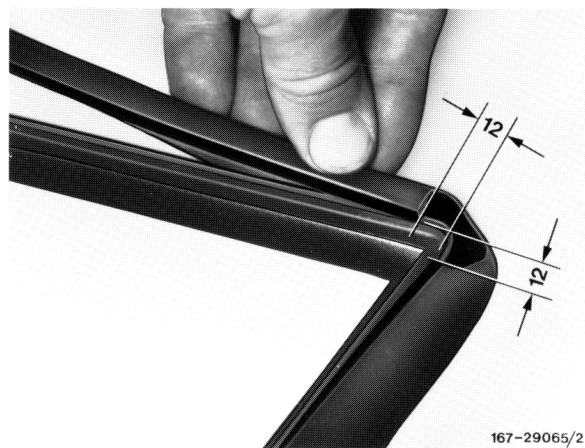
31 Pull off loose glueing material and rub off glueing range with non-fluffy rag. Do not use cleaning compound.

32 Slip profilated rubber on pane.

Note: Serrations should be at inside of pane.



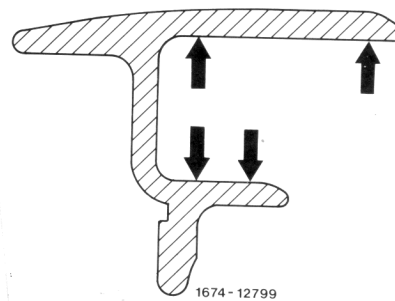
33 Slip rubber cover on trimstrip.



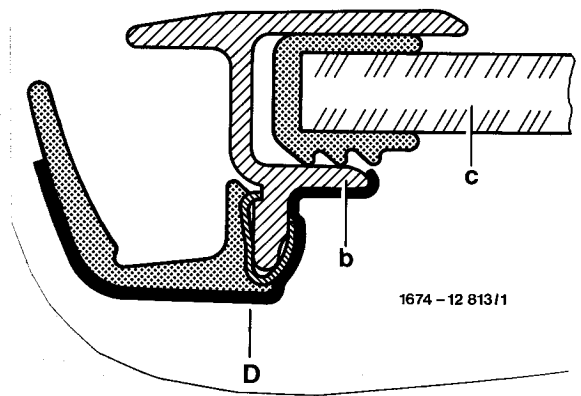
34 Coat holding groove in trimstrip with soap water and push trimstrip on pane, starting at upper corner.

Attention!

Keep glueing range free of soap water so that perfect glueing is assured. After mounting trimstrip, remove excessive soap water.



35 Apply parting compound to rubber cover and trimstrip (range D).



b = Trimstrip
c = Pane

36 Repair damaged primer coat.

37 Let primer air-dry for at least 5 minutes.

When installing a new glass pane:

Check pane for scratches and damage. Apply glass activator (cleaner) from repair pack with non-fluffy rag in glueing range, then rub dry with a second rag.

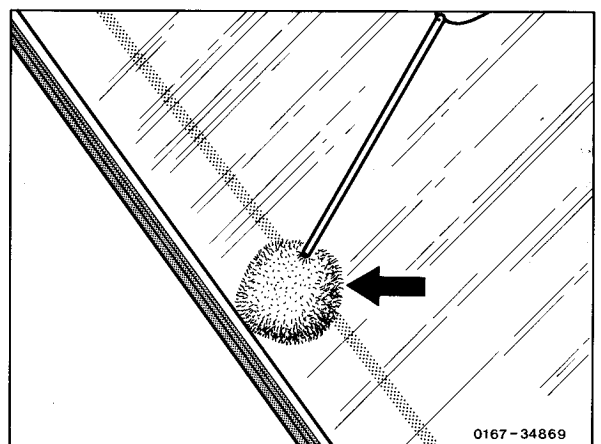
Attention!

Do not use cleaning compound in visibility range of glass, since this may lead to clouding.

38 Preassemble trimstrip on glass (items 35-38).

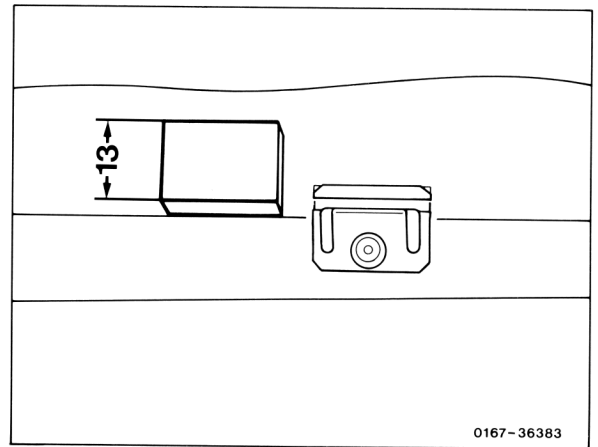
39 Shake primer energetically and apply within glueing range (max. width 30 mm).

40 Let primer air-dry for at least 5 minutes.



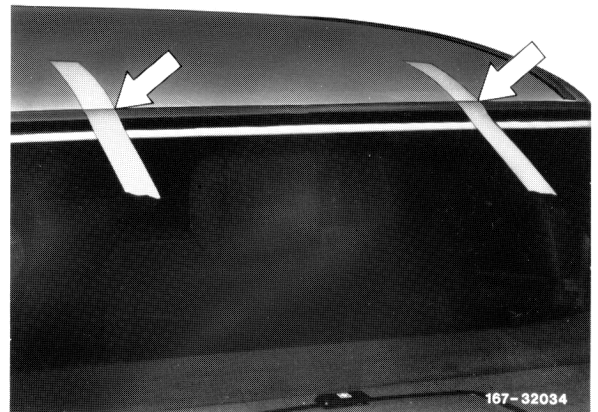
2008

41 Insert rubber pads 10x20x13 from repair pack into pane cutout, below.



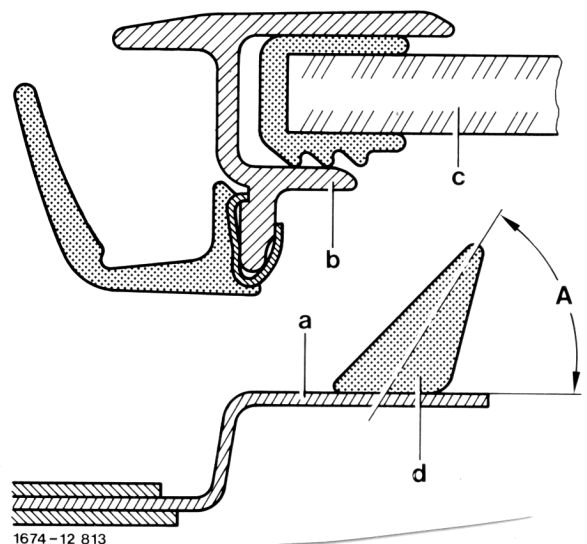
Assembly note

Prior to applying glue, center glass pane in body opening. For this purpose, mount suction lifter, position pane with second mechanic assisting at the rubber pads (item 43) and align. Glue on two adhesive tape strips, cut through at upper edge of pane (arrow) and again remove pane.



42 Remove cartridge with glue from repair pack, cut through diaphragm, remove cartridge bottom and dump chemicals. Screw on application nozzle and insert cartridge in processing gun.

Guide nozzle along on residual glueing material on body flange, while simultaneously pressing glue out (height of glue bead approx. 10 mm). Hold cartridge gun on lateral flanges in joining direction of pane (A = approx. 50°).

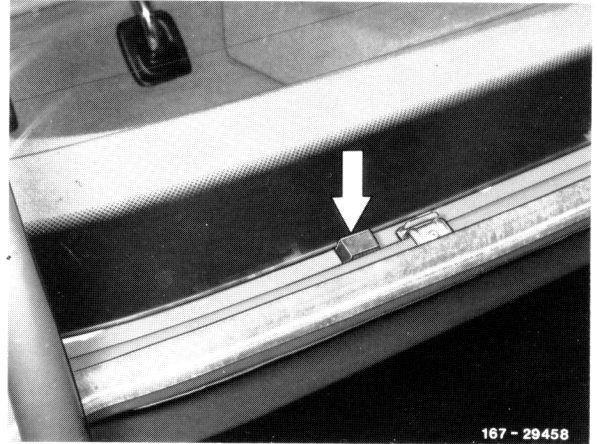


- a Body flange
- b Trimstrip
- c Pane
- d Glue bead
- A approx. 50°

43 Place pane on lower rubber pads, align, place on glue bead and push down all-around until the trimstrip is flush with body.

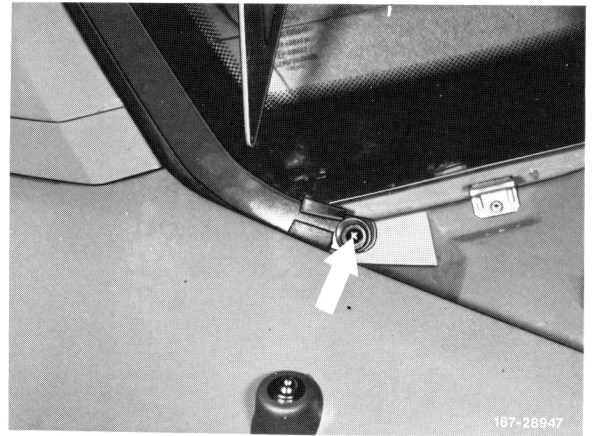
Attention!

Pane must be mounted within 15 minutes, since otherwise the adhesive characteristics of the glueing material will be impaired.



44 Screw on trimstrip below.

45 Open crank window on driver's door so that the rear window pane cannot be pushed outward by the accumulating air while closing the doors during the drying period.

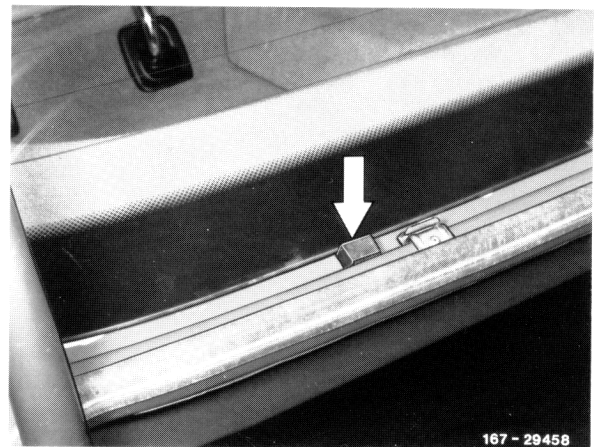


46 Remove rubber pads.

47 For further installation proceed vice versa.

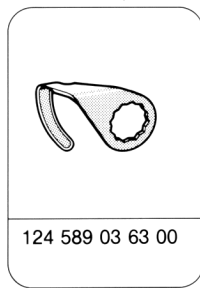
Note: The drying time (stationary period of vehicle) amounts to approx. 4 hours. The rain test can be made upon completion of assembly jobs.

In the event of leaks, refer to 97-850.



B. Coupe

Special tool



Conventional tools

e.g. Company, Order no.

Multi-cutter

Chicago Pneumatic
D-65366 Geisenheim
CP 838-12

Suction lifter

Karl Assfalg KG, Buchstraße 149
D-73525 Schwäbisch Gmünd
602-2

Electric gun with battery

Weiler & Co.
Postfach 1269
D-76287 Rheinstetten, Baden
Pressofix 108, Electronic, SDF-108 E

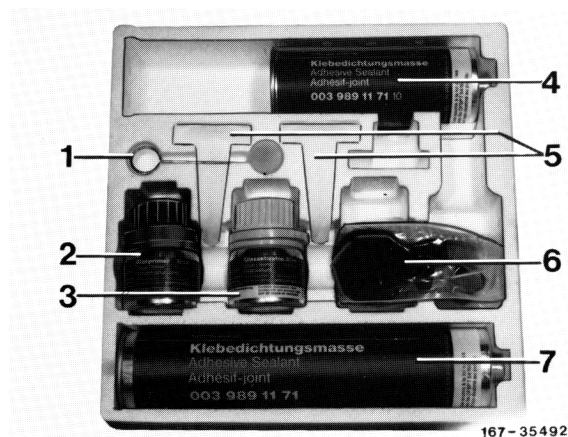
Parts

Repair pack for glazing
windshield or back window glass

124 670 01 93

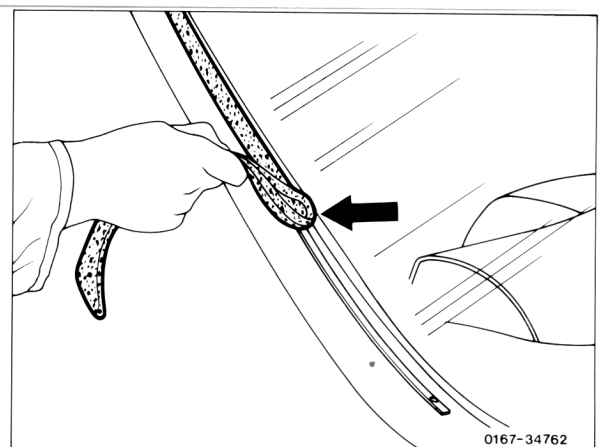
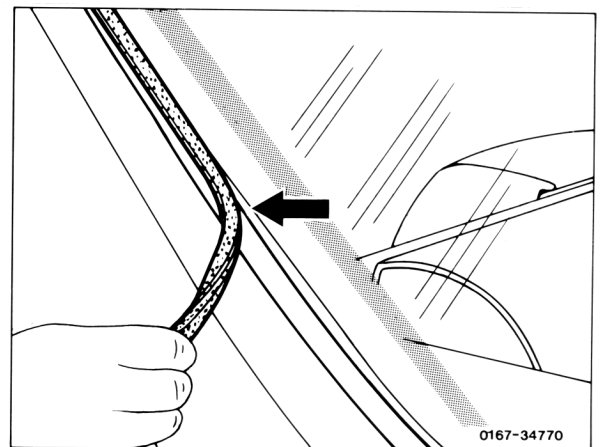
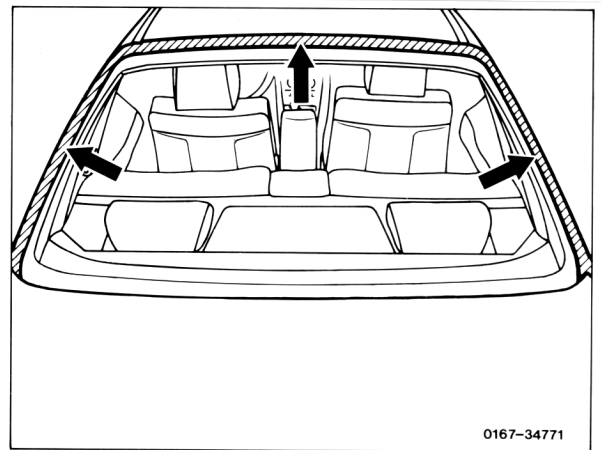
Scope

- 1 Coating brush
- 2 Glass primer
- 3 Glass activator (cleaner)
- 4 Betaseal glueing material 150 ml
- 5 Coating nozzles
- 6 Cutting wire, spacing blocks, spacing angle, spacing rubber and cleaning cloth
- 7 Betaseal glueing material 300 ml



Removal

- 1 Remove trim on rear pillar left and right (68-449, do not unscrew end fitting of belt).
- 2 Disconnect electric connections on lefthand and righthand rear pillar.
- 3 Protect pane cutout of body against damage, by means of adhesive tape.
- 4 Remove ornamental frame on back window. (67-220).
- 5 Pull molded rubber strip from pane.
- 6 Pull making from body.
- 7 Remove trunk lid (88-500).
- 8 Remove expanding rivet on trim in trunk, left and right. Disengage springs on trunk lid hinges.



9 Locate multi-cutter available for use (air supply interrupted).

10 Clamp knife into multi-cutter.

11 Moisten oil stone, connect air supply and sharpen both sides of knife with machine switched on.

12 Switch off multi-cutter.

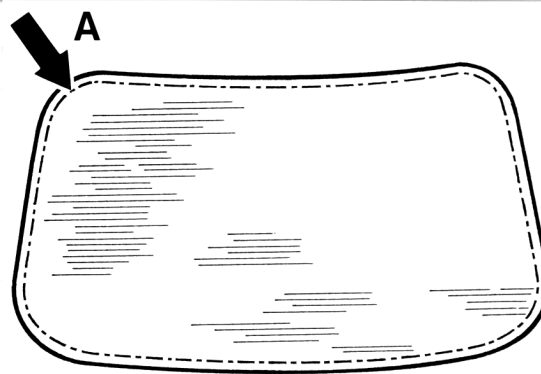


Attention!

Wear goggles.

13 Move into operating position adjacent to rear fender.

14 Switch on multi-cutter, plunge-cut knife at starting point "A" and cut through adhesive bead all-around with knife guided in parallel with glass.



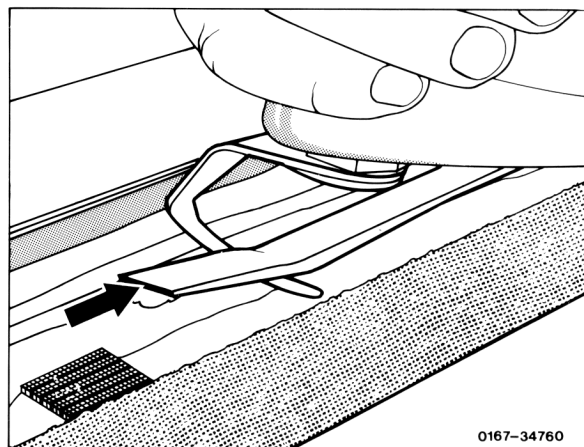
Note: If adhesive material cannot be completely cut through with the available knives, use cutting wire.

15 Lift off glass with suction lifter.

Installation

16 Cut off residual glueing material on body flange with knife. Max. 2 mm may remain. Pull off loose glueing material (not completely cut-off residual pieces).

17 Paint damage on body flange not covered by glueing material with priming pencil, part no. 000 986 06 50.



18 Prepare pane for glazing.

When using the previously installed glass pane:

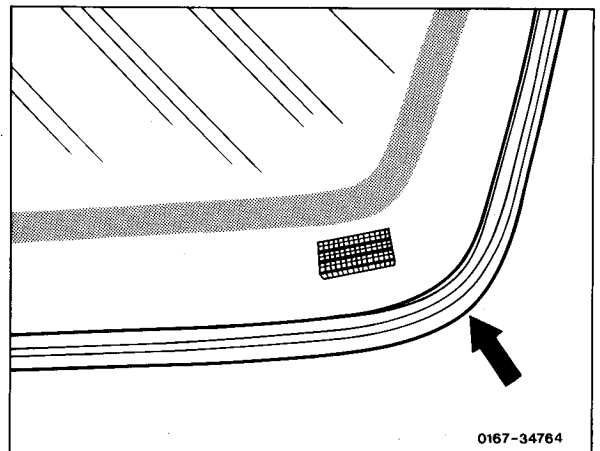
19 Cut off residual glueing material on glass down to a few tenths of a millimeter.

20 Renew holding strips, if damaged.

21 Pull off loose glueing material and rub glueing range with non-fluffy rag. Do not use cleaning compound.

22 Mount molded rubber strip on pane.

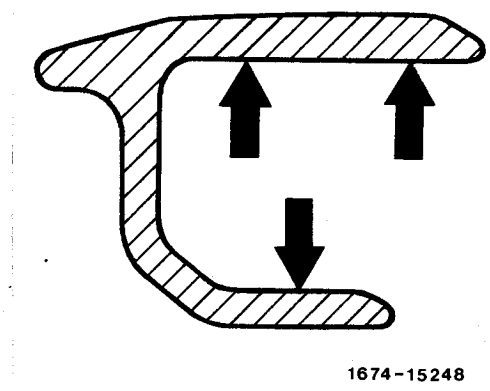
Note: Serrations should be on inner side of pane.



23 Coat holding groove in trimstrip with soap solution and press trimstrip on pane starting at upper corner.

Attention!

Keep glueing range free of soap solution to guarantee perfect glueing. Remove excess soap solution after mounting trimstrip.



- 24 Repair damaged primer layer.
- 25 Let primer air-dry for min. 5 minutes.

When installing a new glass pane:

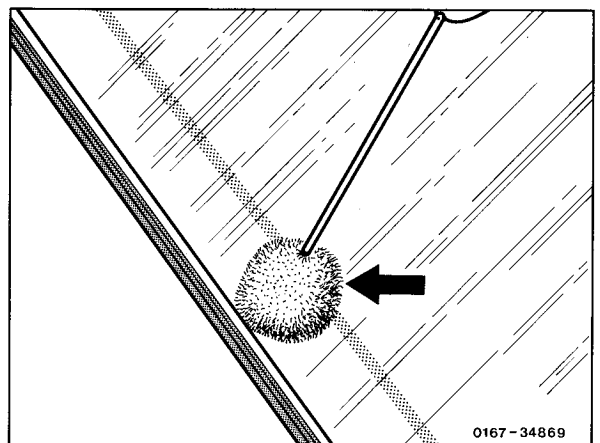
Note: On spare part glass panes, the holding strips are already glued on.

Check pane for scratches and damage. Apply glass activator (cleaner) from repair pack with non-fluffy rag in glueing range, then rub dry with a second rag.

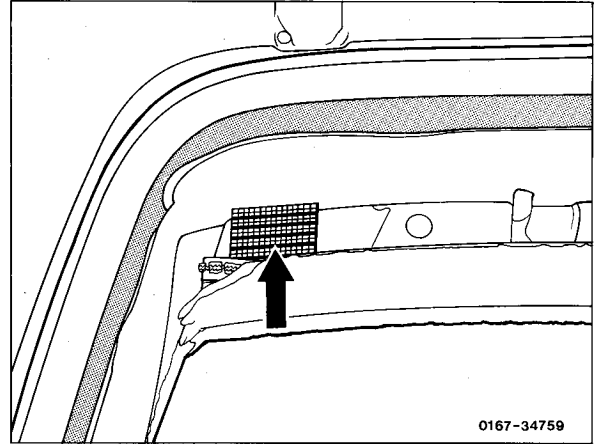
Attention!

Do not use cleaning compound in visibility range of glass, since this may lead to clouding.

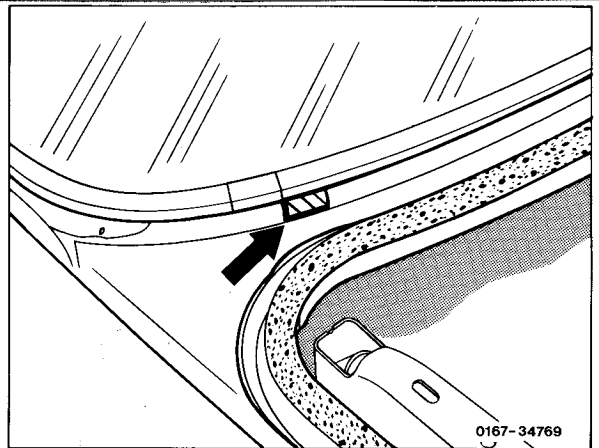
- 26 Premount trimstrip on glass pane (items 22–23).
- 27 Shake primer energetically and apply (max. width 30 mm).
- 28 Let primer air-dry for at least 5 minutes.



29 Renew holding strips (4 each) on body top which may have suffered damage.

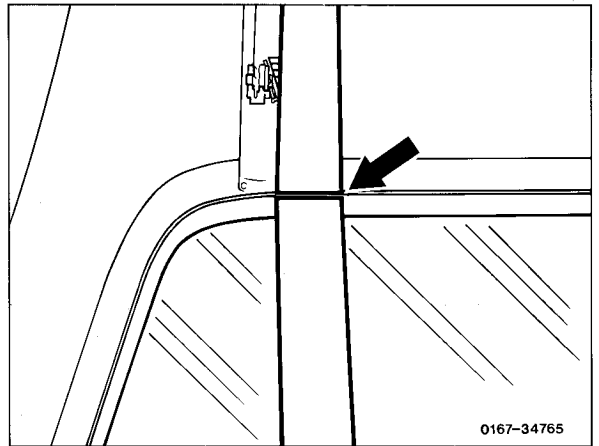


30 Insert rubber pads 10x20x13 from repair pack into glass cutout, below (arrow).



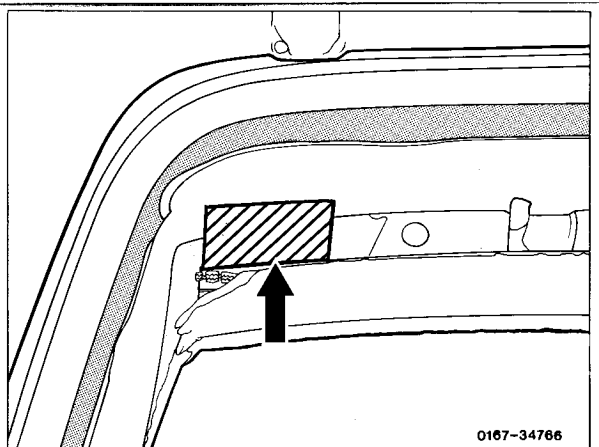
Assembly note

Prior to applying glue, center glass pane in body opening. For this purpose, mount suction lifter, position pane with second mechanic assisting at the rubber pads (item 30) and align. Glue on two adhesive tape strips, cut through at trimstrip (arrow) and remove pane again.

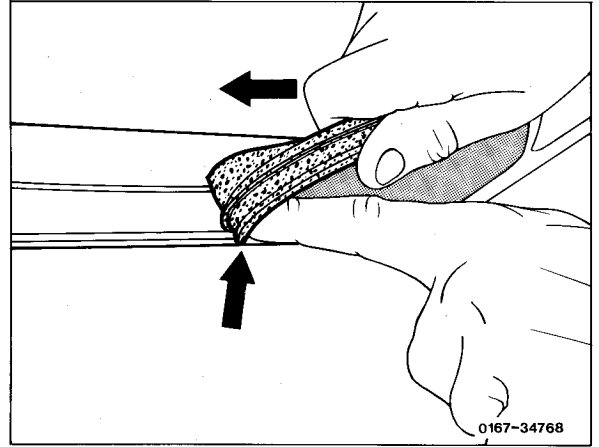


Note: To permit displacement of windshield glass during alignment, mask holding strip with adhesive tape.

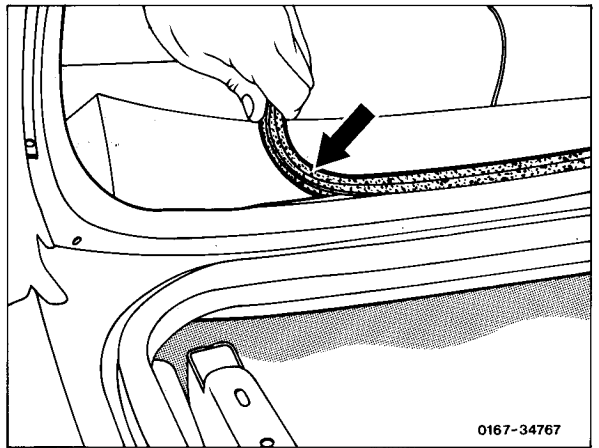
Pull off adhesive tape prior to inserting windshield pane.



31 Apply masking.

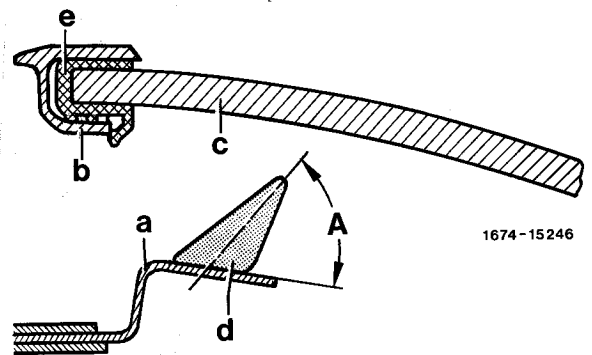


32 Check molded rubber strip in pane cutout below, renew rubber, if damaged.



33 Remove cartridge with glue from repair pack, cut through diaphragm, remove cartridge bottom and dump chemicals. Screw on application nozzle and insert cartridge in processing gun.

Guide nozzle along on residual glueing material on body flange, while simultaneously pressing glue out (height of glue bead approx. 10 mm). Hold cartridge gun on lateral flanges in joining direction of pane (A = approx. 50°).



- a Body flange
- b Trimstrip
- c Pane
- d Glue bead
- e Molded rubber
- A approx. 50°

34 Place on lower rubber pads (item 30) and align according to adhesive tape strip at top. Place on adhesive bead and push into holding strips.

Press against pane below.

Note: Minimum distance from body is assured by holding strip at top and by molded rubber strip below.

Attention!

Pane must be mounted within 15 minutes, since otherwise the adhesive characteristics of the glueing material will be impaired.

35 Remove rubber pads at end of drying period.

36 For further installation proceed vice versa.

Note: The drying time (stationary period of vehicle) amounts to approx. 4 hours. The rain test can be made upon completion of assembly jobs.

In the event of leaks, refer to 97-850.