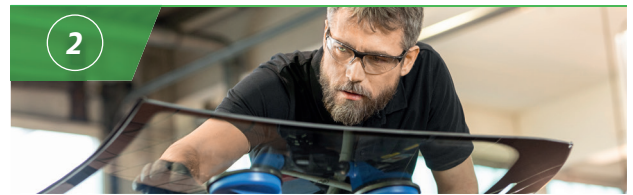


WINDSCREEN REPLACEMENT STEP-BY-STEP WORKING INSTRUCTIONS TEROSON BOND 60 TRUE PRIMERLESS



1 Clean new windscreen

Unpack the new windscreen. To remove dirt and grime, clean both sides using a professional cleaner such as **TEROSON BOND Glass Cleaner**.



2 Inspect new windscreen

Check the new windscreen for any sign of damage or scratches and make sure it fits.



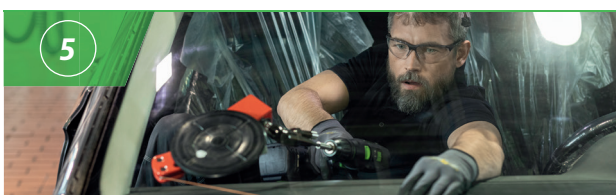
3 Abrade bondline

Abrade the bondline with wetted **TEROSON BOND Sponge**.



4 Clean bondline

Apply the **TEROSON BOND Glass Cleaner** again and dry off the bondline in one direction using a lint-free cloth.



5 Remove old windscreen

Remove the attachments from the car and cut out the windscreen. Using the **TEROSON BOND Easy Cut** makes it especially easy.



6 Prepare body frame

Remove all dirt from the frame using **TEROSON BOND Glass Cleaner** and a lint-free cloth. Then evenly trim back the remaining bead. Cover paint damage with primer if needed.



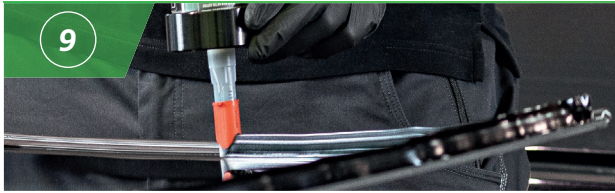
7 Determine bead height

Determine bead height in roof area. Where the roof is the same height as the pane, adjust the applicator nozzle to the correct height: final bead height = flange height (x) plus 2 mm.



8 Prepare adhesive cartridge

Remove its bottom lid and pierce the top membrane to open the cartridge beforehand. Insert into application gun.



Apply the adhesive bead

For best results, move the nozzle at a right angle to the horizontally positioned screen. It is recommended that the cartridge content is extruded evenly in one pass.



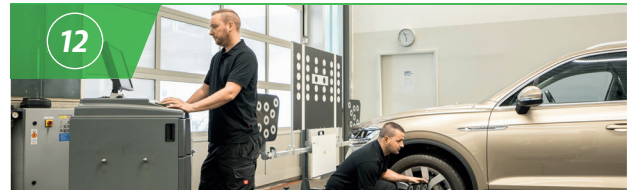
Install new windscreen

Carefully insert the new windscreen into the body frame. Use **TEROSON VR 5080 Fix & Repair Tape** to secure the correct positioning temporarily. Install attachments.



Observe Safe Drive-Away Time

Be sure to observe the Safe Drive-Away Time. For **TEROSON BOND 60 True Primerless** it is 60 minutes. After this time it is ensured that the vehicle meets the FMVSS requirements.



Calibrate ADAS

Make sure that all driving assistance systems are calibrated. Follow the car manufacturer's instructions for re-calibration of the safety systems.

INFO

TEROSON BOND 60 True Primerless windscreen adhesive is designed to meet not only the requirements FMVSS crash standards (212 / 208), but also the much stricter Henkel requirements. This means that safe drive-away is guaranteed even in a 40% overlap collision at a speed of 64 km/h (40 mph).

For further product information see technical data sheets and safety data sheets. Visit www.henkel-adhesives.com/uk

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The data contained herein are intended as reference only. Please contact Henkel Technical Support Group for assistance and recommendation on specifications for these products.

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