

WINDSCREEN REPLACEMENT

STEP-BY-STEP WORKING INSTRUCTIONS **TEROSON BOND 180 TRUE PRIMERLESS**



1

Clean new windscreen

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



2

Inspect new windscreen

Check the new windscreen for damages or scratches and make sure it fits.



3

Abrade bondline

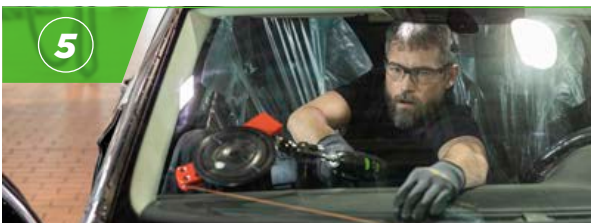
Abrade the bondline with the Teroson BOND Sponge or abrasive pad.



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

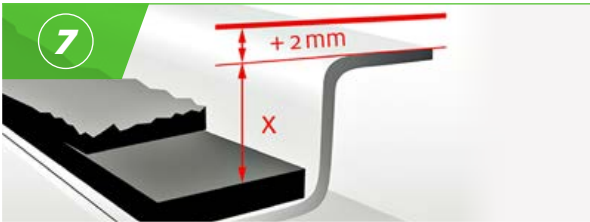
Remove the attachments from the car and cut out the windscreen. Using the Teroson BOND Easy Cut makes it especially easy.



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 damages with primer if needed.



Determine bead height

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



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 180 True Primerless** it is 3 hours. After this time it is ensured that it is safe to drive away.



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 180 True Primerless is a 1-component primerless polyurethane windscreen adhesive for highly convenient and efficient windscreen replacements. As no primer is needed the application process is both fast and safe.

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