

## 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 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.

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, adjust 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 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.

For further product information see technical data sheets and safety data sheets. Visit [www.henkel-adhesives.com](http://www.henkel-adhesives.com)