

WINDSCREEN REPLACEMENT

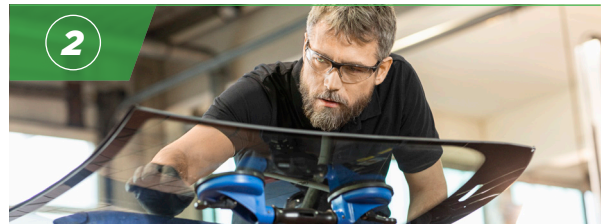
STEP-BY-STEP WORKING INSTRUCTIONS TEROSON BOND 120



1

Clean new windscreen

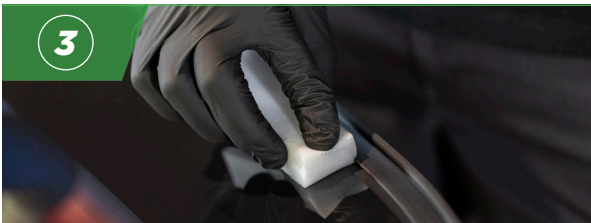
Unpack the new windscreen. To remove dirt and grime, clean it from both sides using a professional cleaner such as Teroson Bond Glass Cleaner.



2

Inspect new windscreen

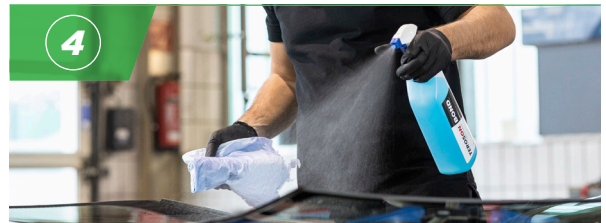
Check the new windscreen for damages or scratches and make sure it fits.



3

Abrade bondline

Abrade the bondline with wetted Teroson Bond Sponge or abrasive pad.



4

Clean bondline

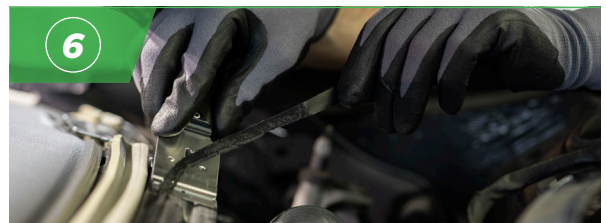
Apply the Teroson Bond Glass Cleaner again and dry off the bondline in one direction using a lint-free cloth.



5

Remove old windscreen

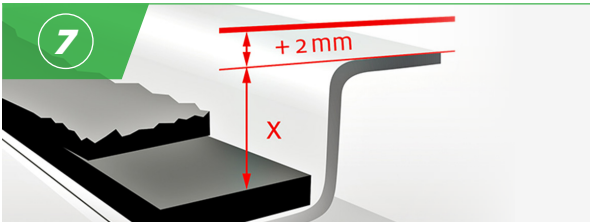
Remove the attachments from the car and cut out the windscreen. Using the Teroson Bond Easy Cut makes it especially easy.



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.



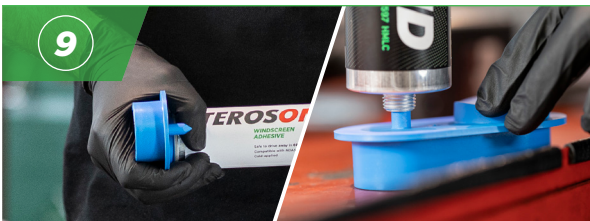
Determine bead height

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



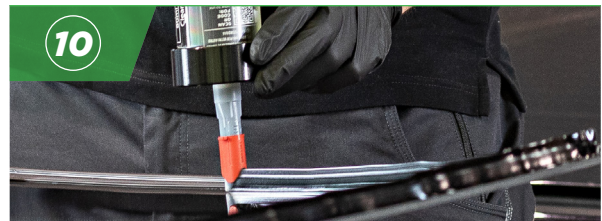
Apply Primer

Before opening the bottle, shake primer bottle well (at least 1 minute). Apply primer with wool dauber in one pass on the bondline (allow to flash off for 2 minutes).



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.



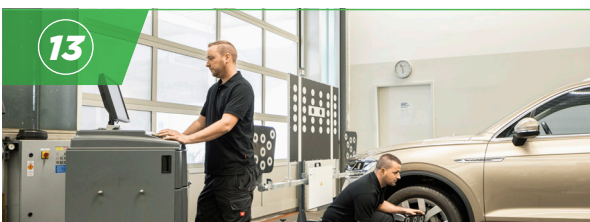
Install new windshield

Carefully insert the new windshield 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 120 it is 2 hours. After this time it is ensured that the vehicle meets the FMVSS requirements as well as the New Henkel Crash Test Standard.



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 120 is designed to meet not only the requirements FMVSS crash standards (212/208), but also the much stricter Henkel requirements. This means that safe windshield adhesion 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/windscreenadhesives.com