



## General Procedures

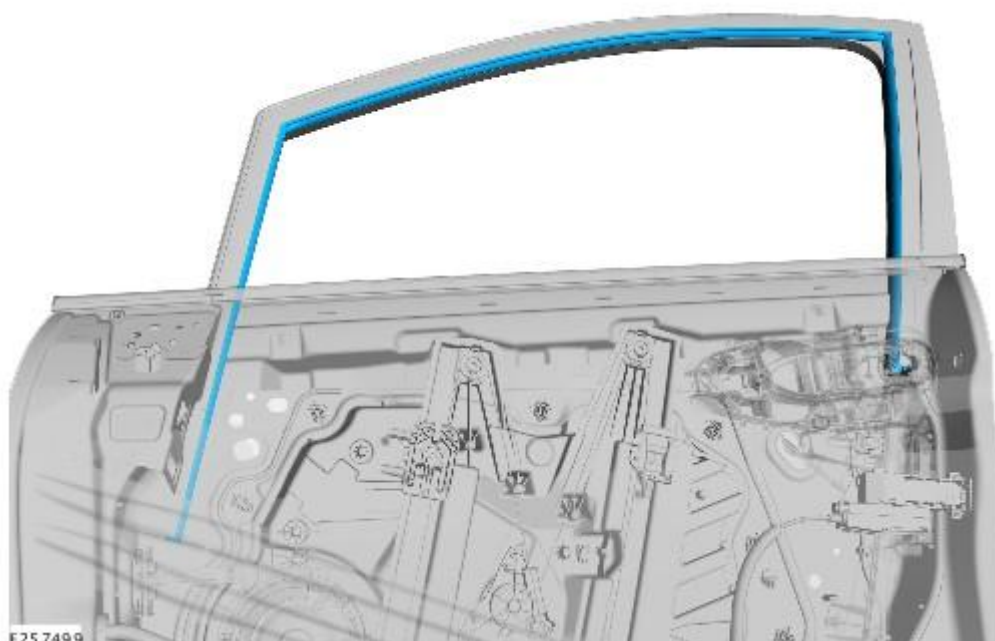
### Activation

1.  **WARNING:** Before beginning any service procedure in this manual, refer to health and safety warnings in section 100-00 General Information. Failure to follow this instruction may result in serious personal injury.  
  
Refer to: [Health and Safety Precautions](#) (100-00 General Information, Description and Operation).
2.  **WARNING:** Keep objects and body parts clear of the glass panel when carrying out the initialization procedure. During the initialization procedure, the glass panel closes with high force and cannot detect objects in its path. Failure to follow this instruction may result in serious personal injury.  
**NOTE:** Make sure that the window runs are correctly installed and free of foreign material.  
Carry out all steps within 30 seconds of starting the sequence.
3. Close the window.
4. Press and hold the switch until the window is fully open. Keep the switch pressed for a few seconds.
5. Release the window control switch.
6. Lift and hold the switch until the window is fully closed. Keep the switch held for a few seconds.
7. Release the window control switch.
8. Press and hold the switch until the window is fully open. Keep the switch pressed for a few seconds.
9. Release the window control switch.
10. Lift and hold the switch until the window is fully closed. Keep the switch held for a few seconds.
11. Test for correct window operation by carrying out the one-touch down and one-touch up features.

## Removal and Installation

### Removal

1. Refer to: [Front Door Window Glass](#) (501-11 Glass, Frames and Mechanisms, Removal and Installation).
- 2.



### Installation

1. To install, reverse the removal procedure.

## Removal and Installation

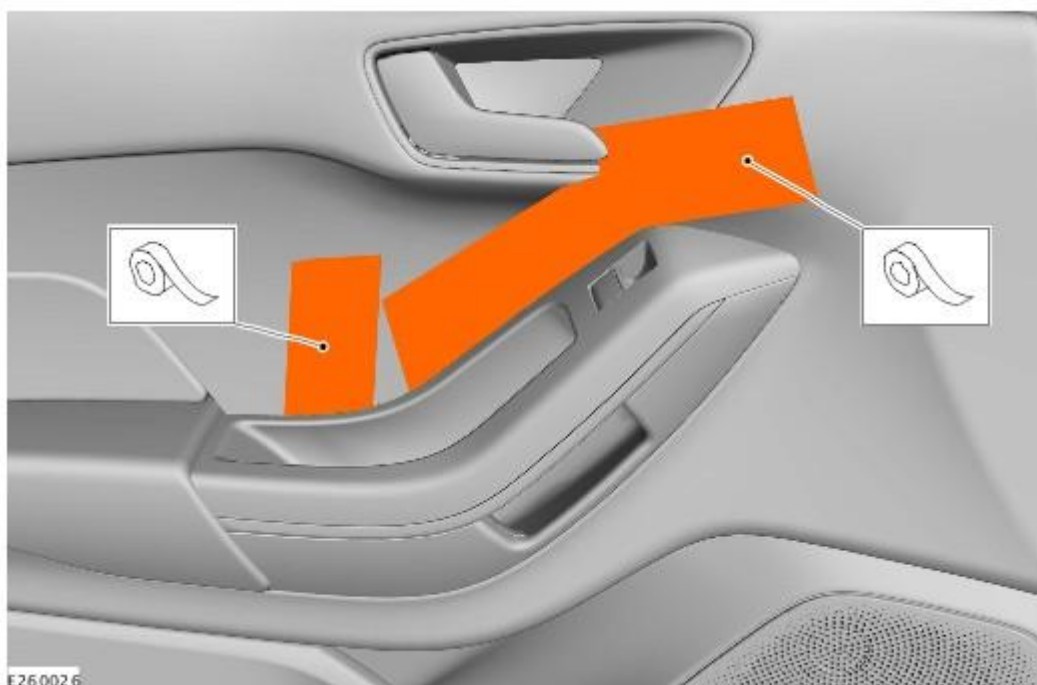
### Special Tool(s) / General Equipment

 E845 II	501-125 Remover, Grab Handle Cover
Adhesive Tape	


### Removal

**NOTE:** Follow the removal procedure instructions carefully to avoid damage.

1. Use the General Equipment: [Adhesive Tape](#)



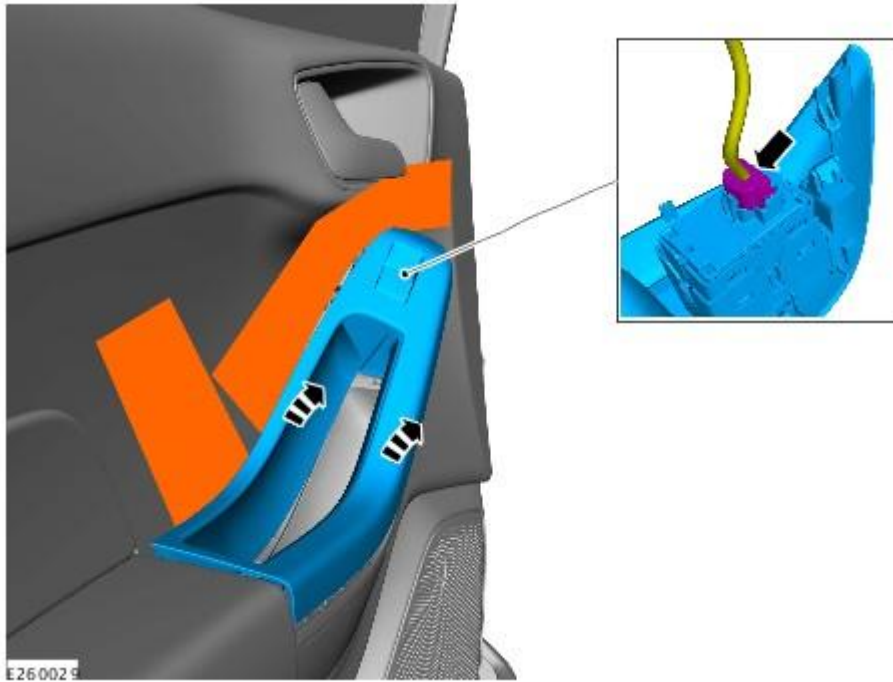
2. **NOTICE:**

 Take extra care not to damage the component.

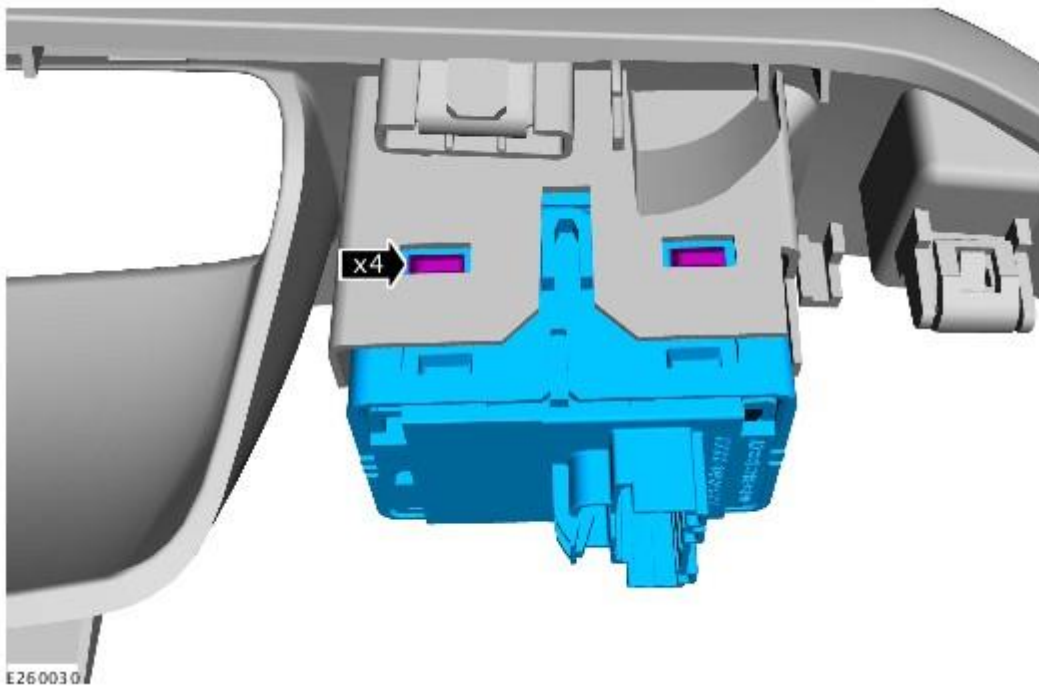
 Only use moderate force.

Use Special Service Tool: [501-125](#).

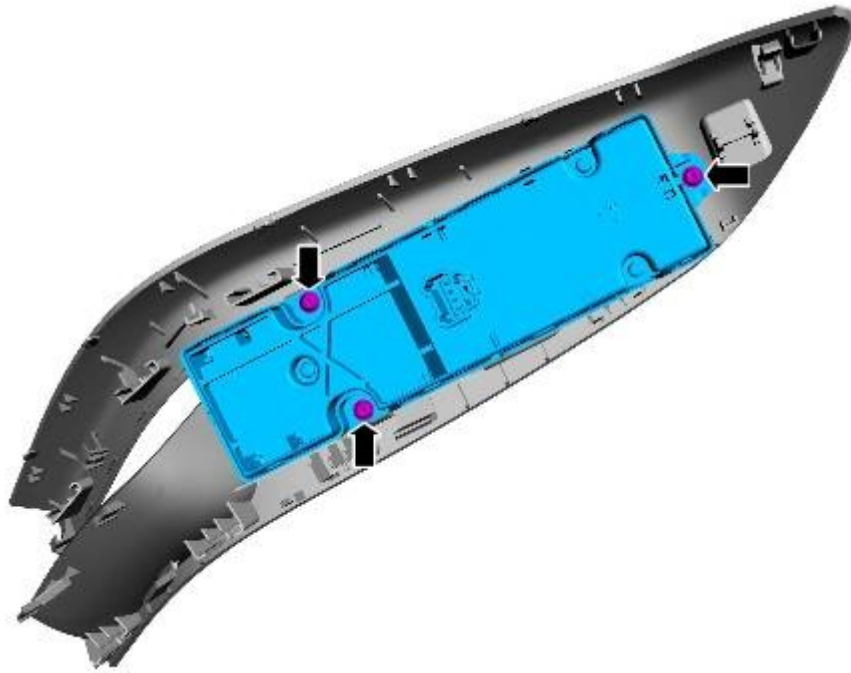




5. NOTE: This step is only necessary when installing a new component.



6. NOTE: This step is only necessary when installing a new component. If equipped.



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### **Installation**

1. To install, reverse the removal procedure.

## Removal and Installation

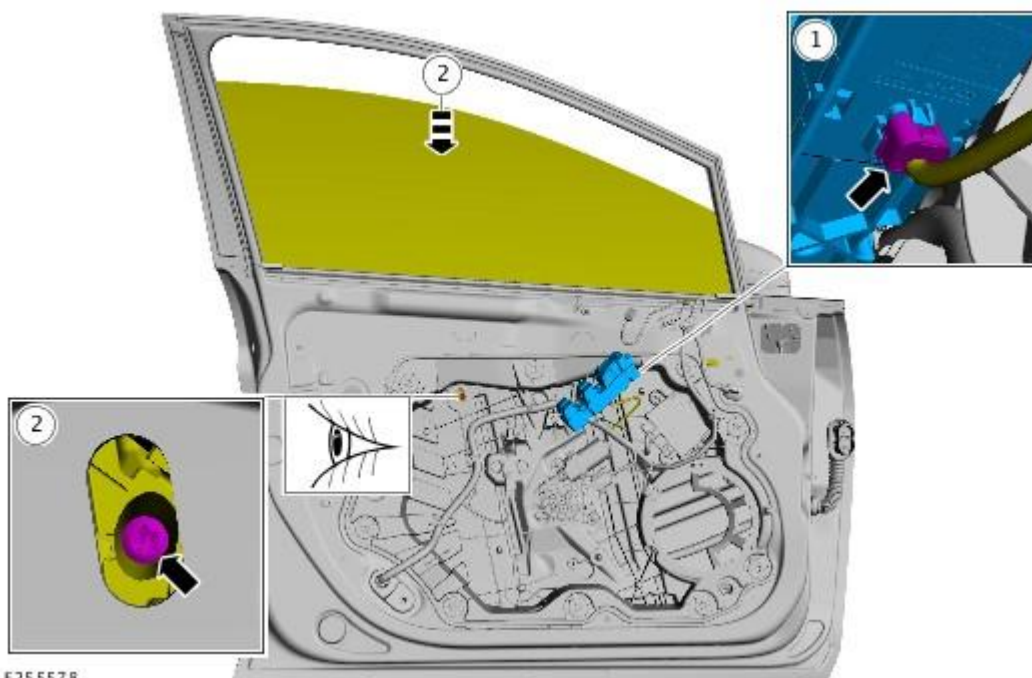
### Removal

NOTE: Removal steps in this procedure may contain installation details.

1. Refer to: [Front Door Speaker](#) (415-01 Information and Entertainment System, Removal and Installation).

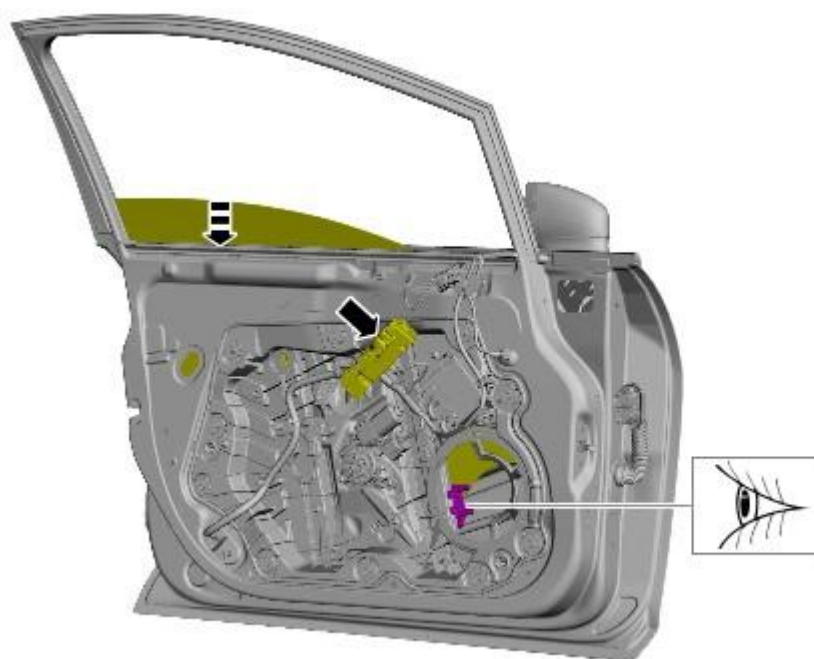
5-Door

2.



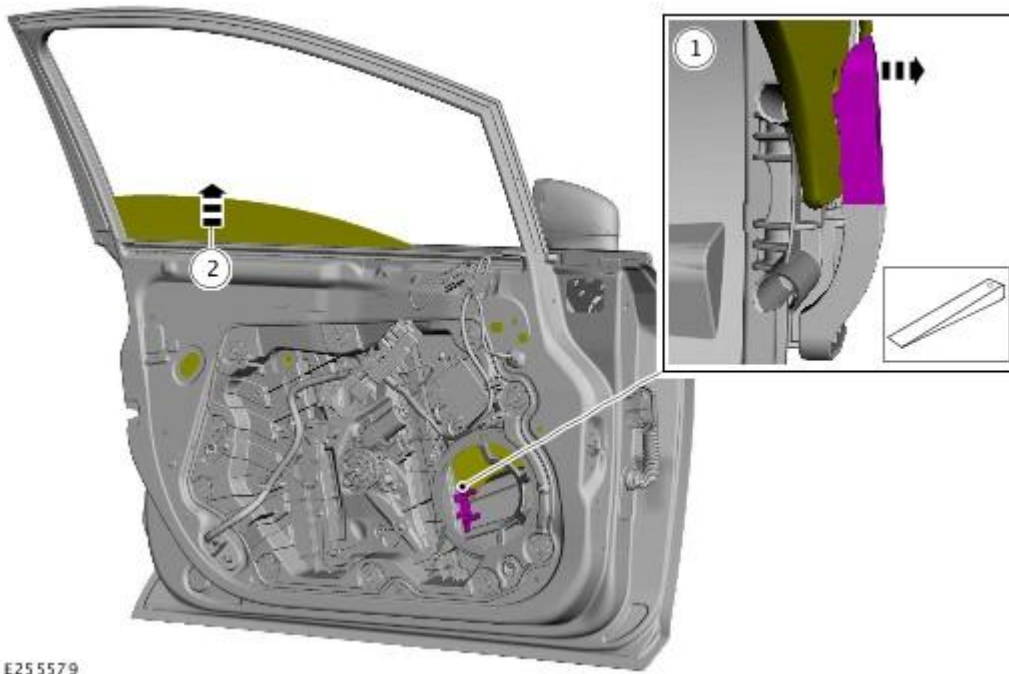
E255578

3.



E255590

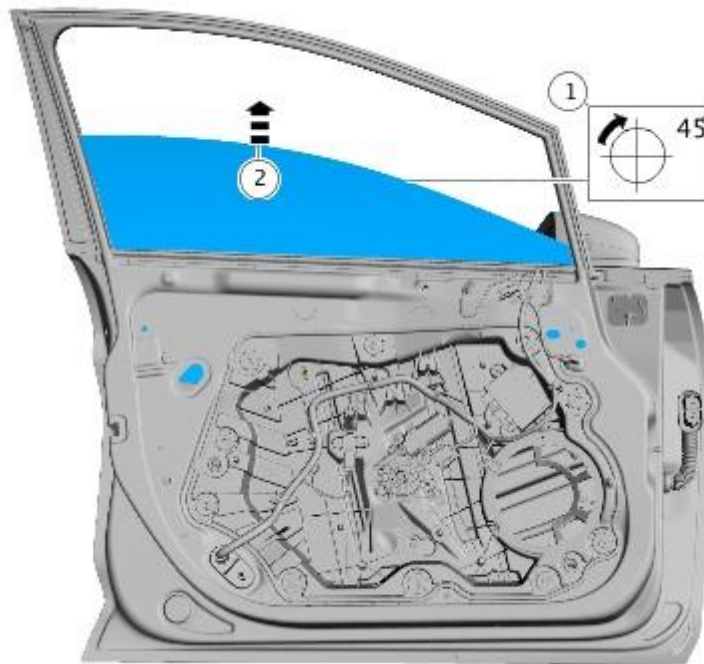
4.



E255579

All vehicles

5.



E255582

### Installation

1. To install, reverse the removal procedure.

5-Door

2. **NOTE:** The front door window glass should be adjusted in reference to GSB 19-7040.

All vehicles

3. Refer to: [Power Door Window Initialization](#) (501-11 Glass, Frames and Mechanisms, General Procedures).

## Removal and Installation

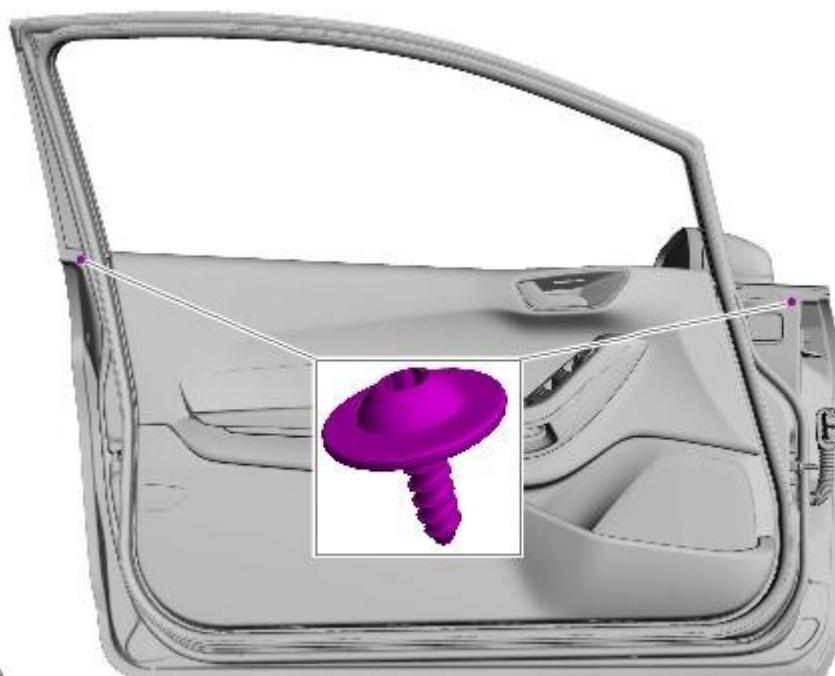
### Removal

1.



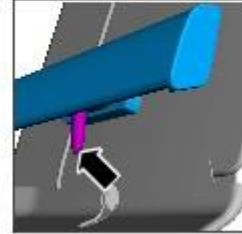
E257238

2.



E257239

3.



E257240

### Installation

1. To install, reverse the removal procedure.

## Removal and Installation

### General Equipment

Adhesive Tape

### Removal

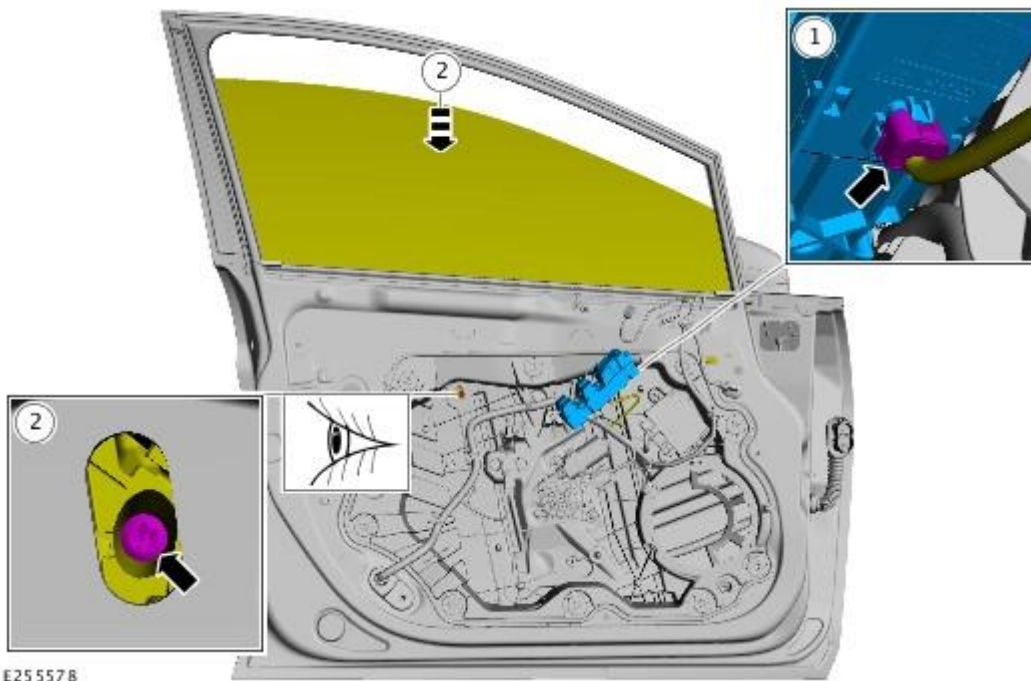
NOTE: Removal steps in this procedure may contain installation details.

All vehicles

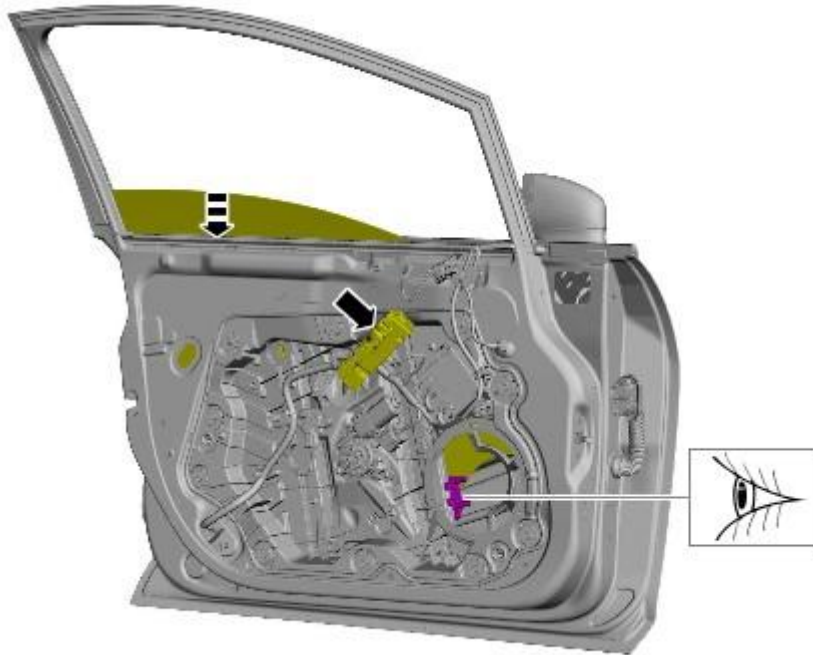
1. Refer to: [Front Door Speaker](#) (415-01 Information and Entertainment System, Removal and Installation).

5-Door

- 2.

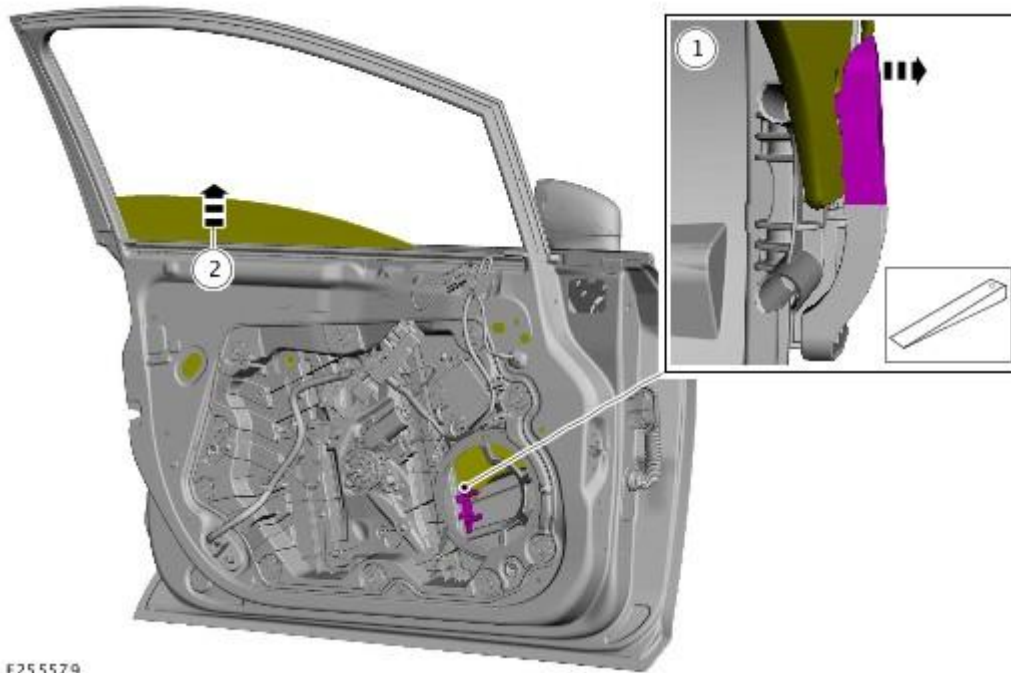


- 3.



E255590

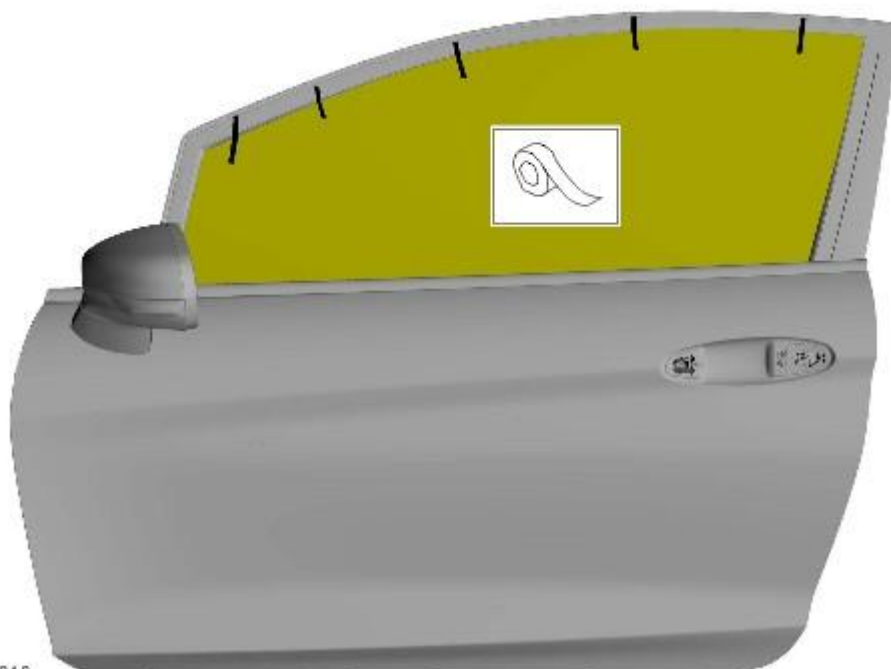
4.



E255579

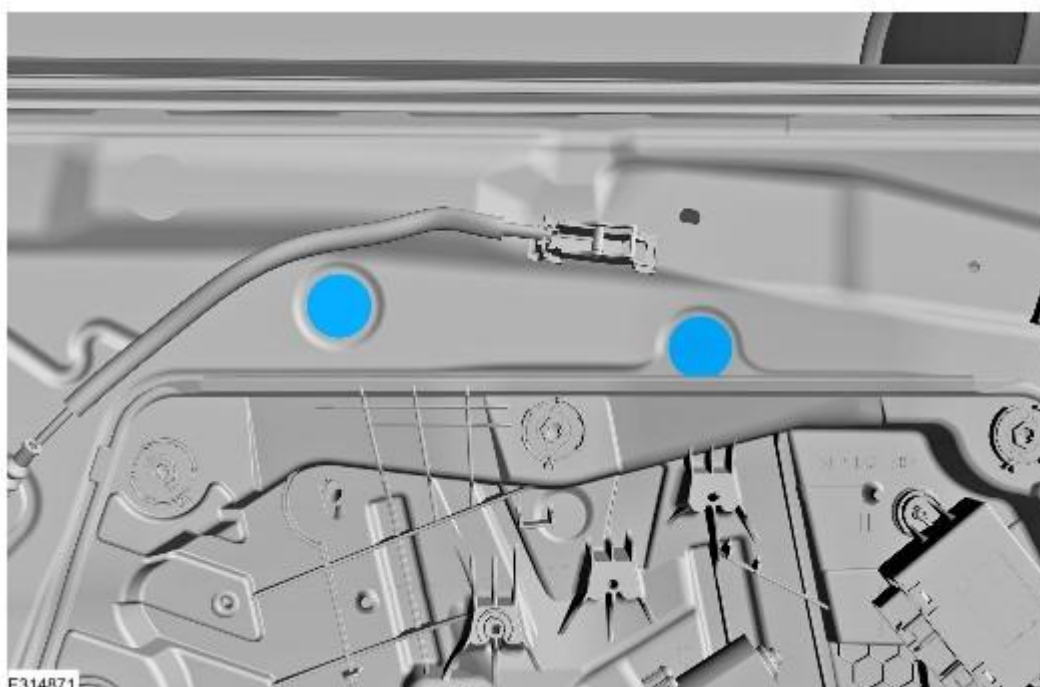
All vehicles

5. Use the General Equipment: [Adhesive Tape](#)



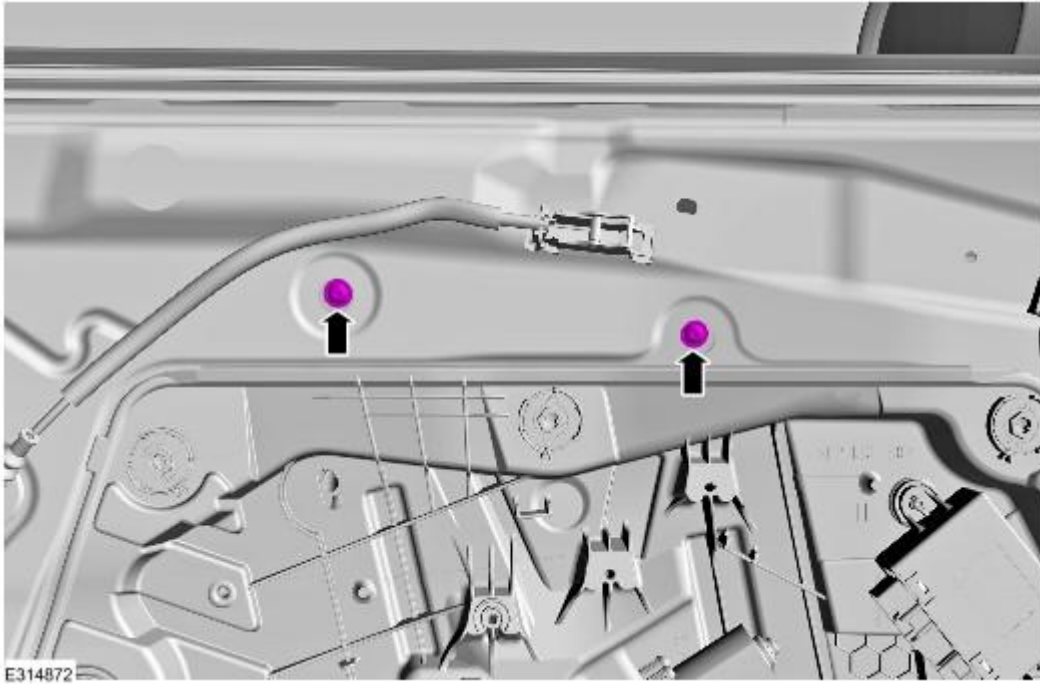
E256848

6.



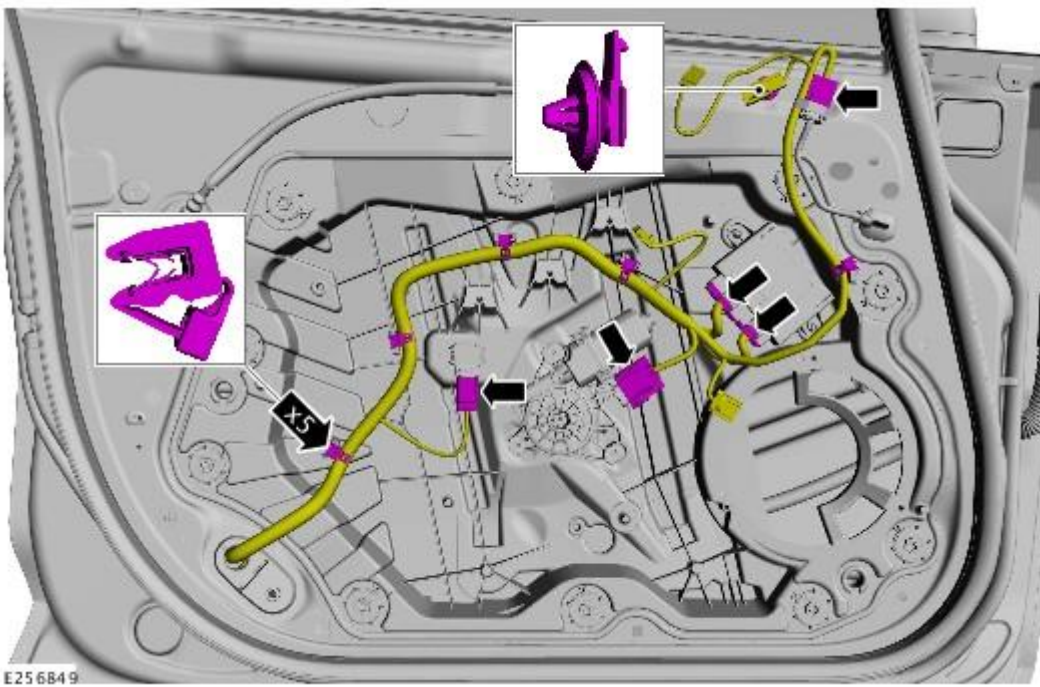
E314871

7. Torque: 8 Nm



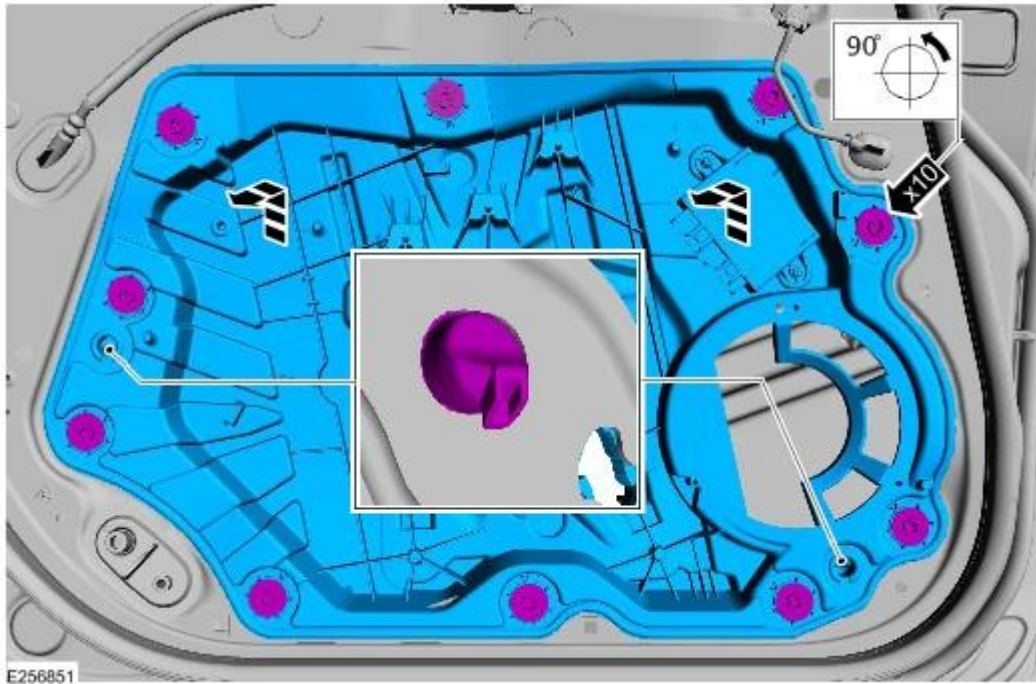
5-Door

8.



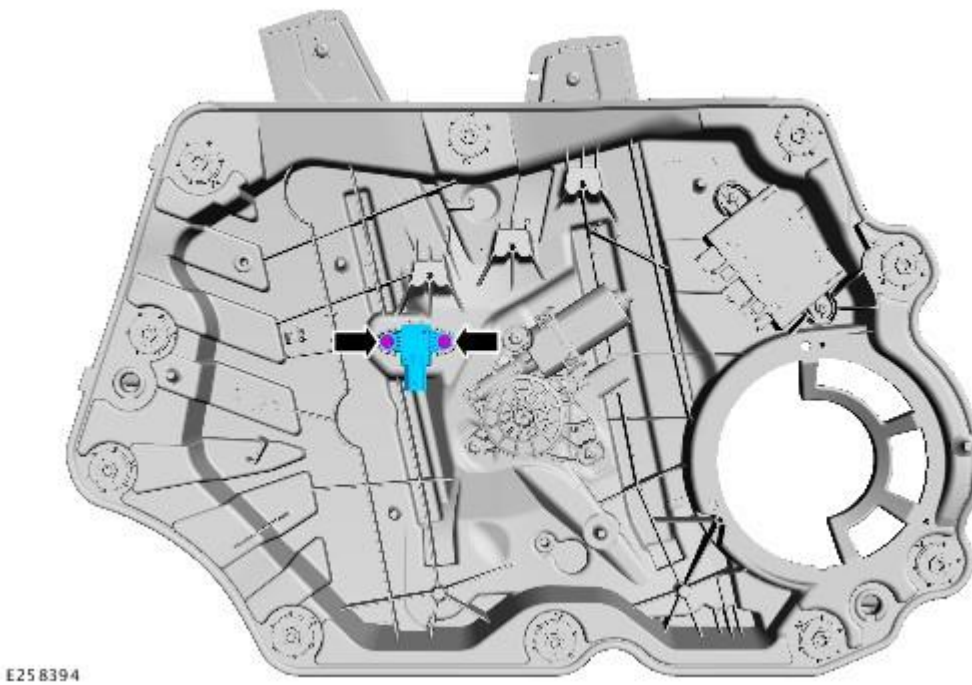
5-Door

9.

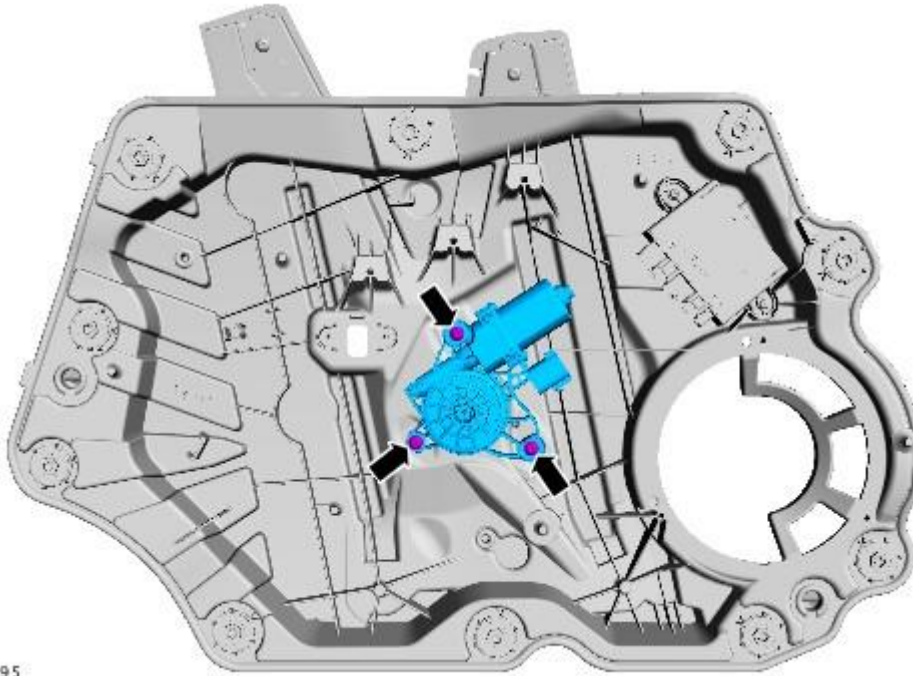


All vehicles

10. NOTE: This step is only necessary when installing a new component.

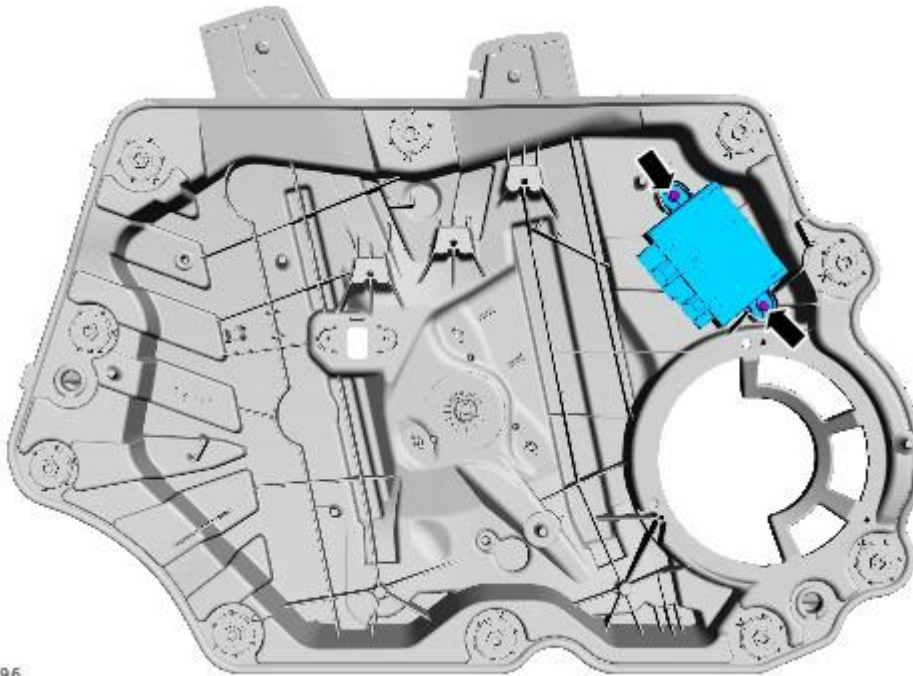


11. NOTE: This step is only necessary when installing a new component.



E258395

12. NOTE: This step is only necessary when installing a new component.



E258396

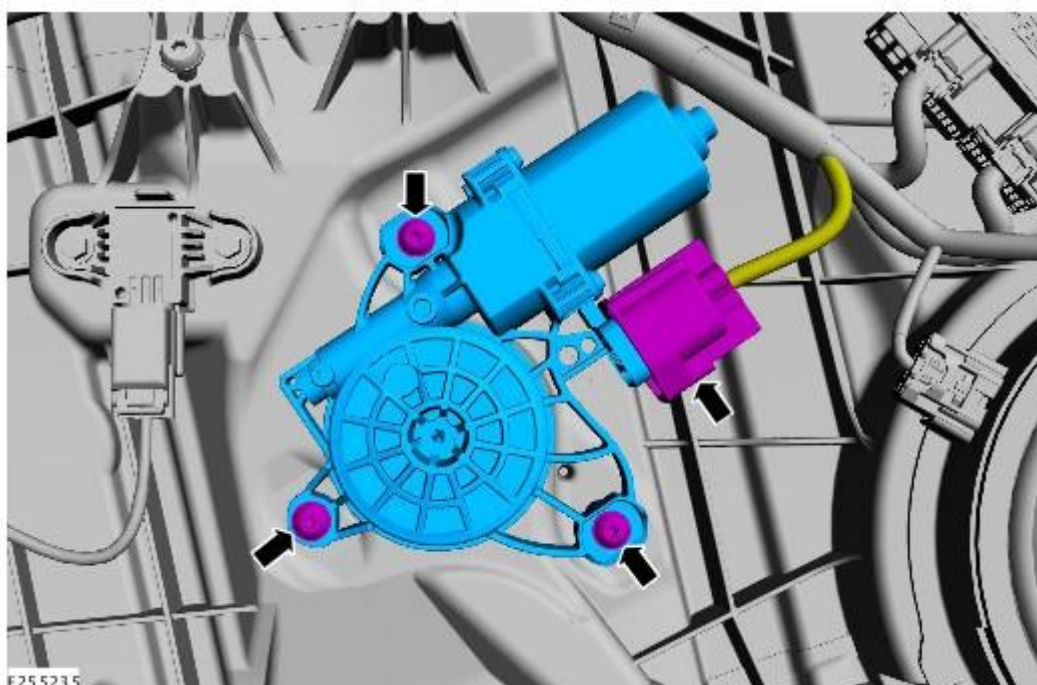
### Installation

1. To install, reverse the removal procedure.
2. Refer to: [Power Door Window Initialization](#) (501-11 Glass, Frames and Mechanisms, General Procedures).

### Removal and Installation

#### Removal

1. Refer to: [Front Door Trim Panel - 3-Door](#) (501-05 Interior Trim and Ornamentation, Removal and Installation).  
Refer to: [Front Door Trim Panel - 5-Door](#) (501-05 Interior Trim and Ornamentation, Removal and Installation).
- 2.



#### Installation

1. To install, reverse the removal procedure.
2. Refer to: [Power Door Window Initialization](#) (501-11 Glass, Frames and Mechanisms, General Procedures).

## Removal and Installation


### Special Tool(s) / General Equipment

 <p>E845 II</p>	<p>501-125 Remover, Grab Handle Cover</p>
<p>Adhesive Tape</p>	
<p>Direct Glazing Removal/Replacement Equipment</p>	
<p>Glass Cut-Out Wire</p>	
<p>Knife</p>	

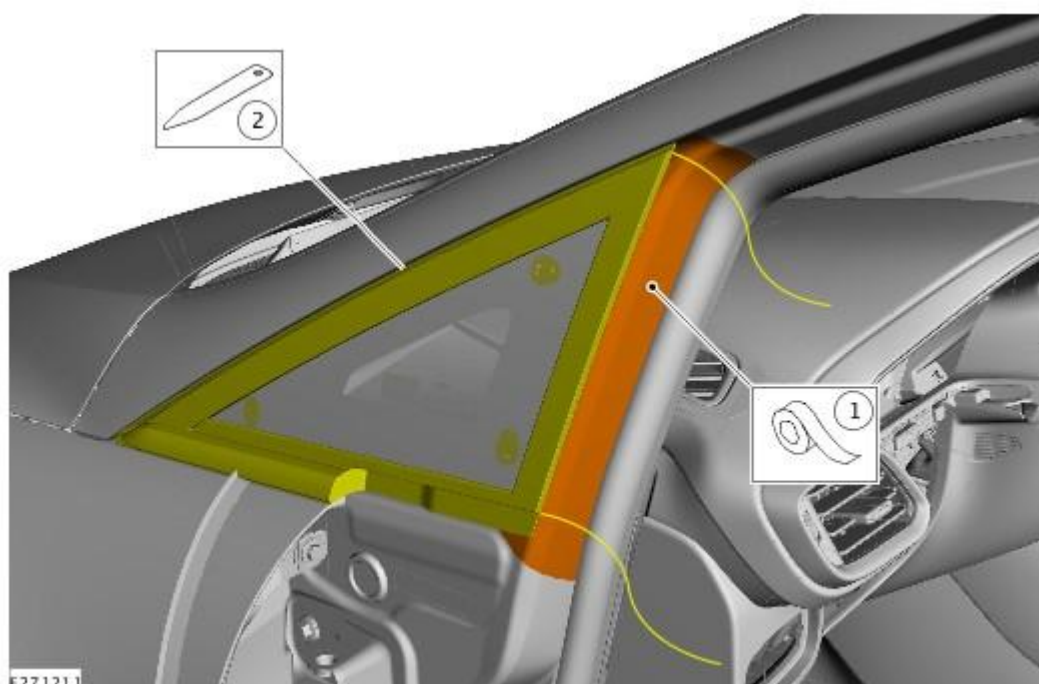
### Materials

Name	Specification
Adhesive	-
Adhesive	WSS-M11P57-A5

### Removal

1.  **NOTICE:** Make sure that the component paintwork is not damaged.
  1. Use the General Equipment: [Adhesive Tape](#)
  2. Thread the cutting wire.

Use Special Service Tool: [501-125](#).  
 Use the General Equipments: [Glass Cut-Out Wire](#), [Direct Glazing Removal/Replacement Equipment](#)



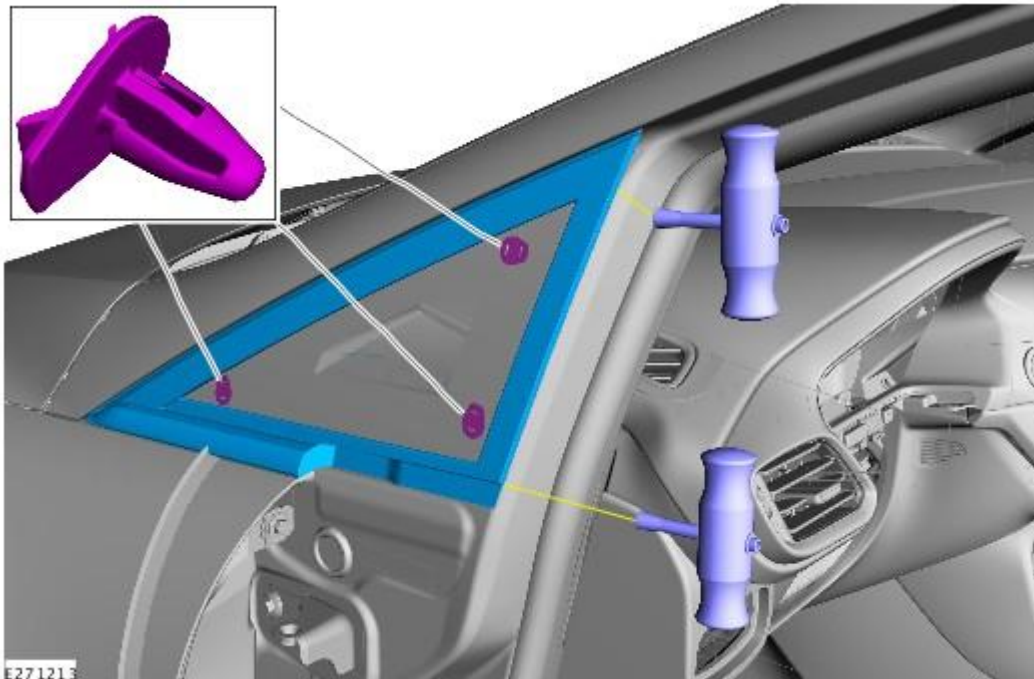
2.



 **NOTICE:** Make sure that the component paintwork is not damaged.  
**NOTE:** Some resistance may be encountered when cutting through the glass locating spacers.

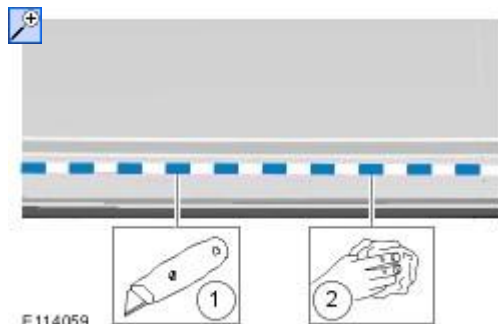
Use a suitable adhesive tape or a laminated card to prevent paintwork damages.

Use the General Equipments: [Direct Glazing Removal/Replacement Equipment](#), [Glass Cut-Out Wire](#)

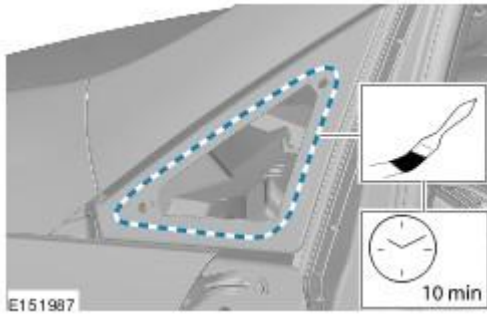


## Installation

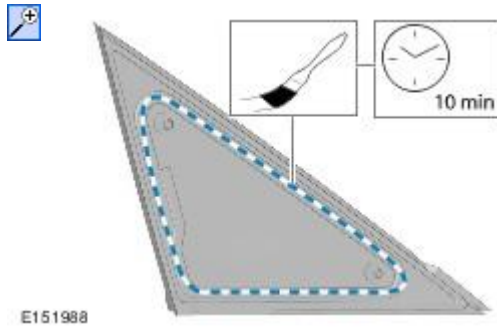
1. **NOTE:** Minimum 1 mm bead thickness.  
*Use the General Equipment:* [Knife](#)
2. **NOTE:** Make sure that the mating faces are clean and free of foreign material.
3. **NOTE:** Touching the adhesive surface will impair rebonding.  
Prepare the front quarter window glass, front quarter window glass flange and trimmed PU adhesive in accordance with the instructions supplied with the glass adhesive kit.



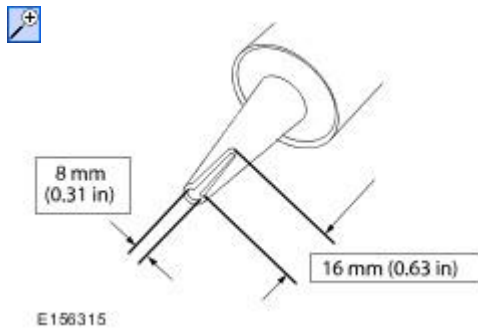
2.
  - Apply the activator/ primer in accordance with the instructions supplied with the glass adhesive kit.
  - Check the area for paintwork damage and repair if necessary.



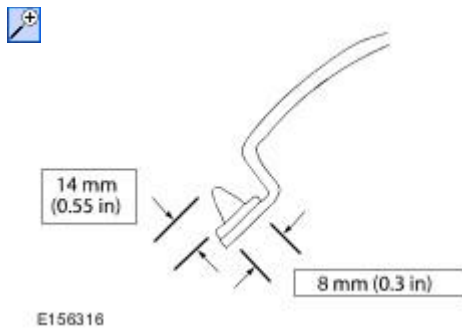
3. Apply the activator/ primer in accordance with the instructions supplied with the glass adhesive kit.



- 4.



- 5.

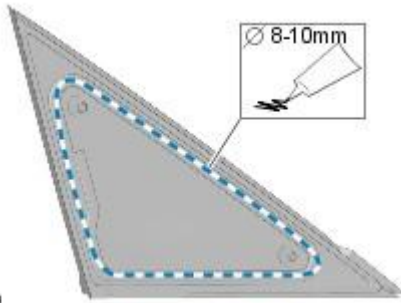


6.
  - NOTE: Discard the first 100 mm of adhesive as this may have a reduced working time.
  - NOTE: Make sure that any breakage in the continuous bead of adhesive is overlapped by 20 mm.


*Use the General Equipment: [Direct Glazing Removal/Replacement Equipment](#)  
Material: - (Adhesive)*

- Repairs under warranty:

Material: [WSS-M11P57-A5 \(Adhesive\)](#)

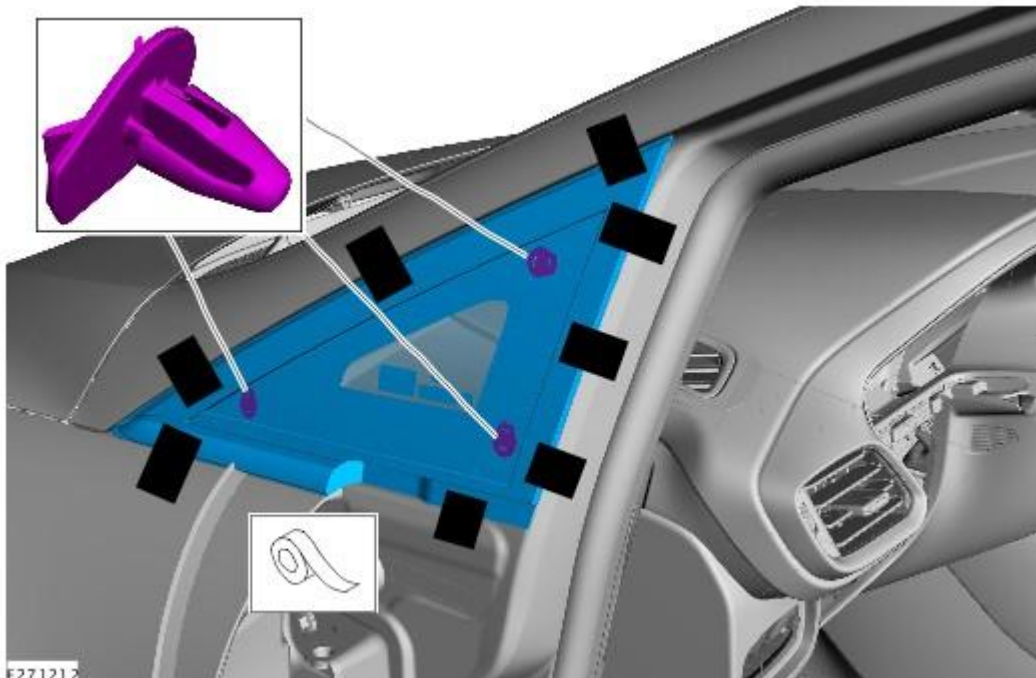


E151989

7.
  - Press firmly and evenly into position.
  -  **NOTICE:** During the curing time of the polyurethane (PU) adhesive, the door windows must be left open.

Using tape, secure the front quarter window glass in the correct position until the PU adhesive has cured.

Use the General Equipment: [Adhesive Tape](#)



E271212

## Removal and Installation

### General Equipment

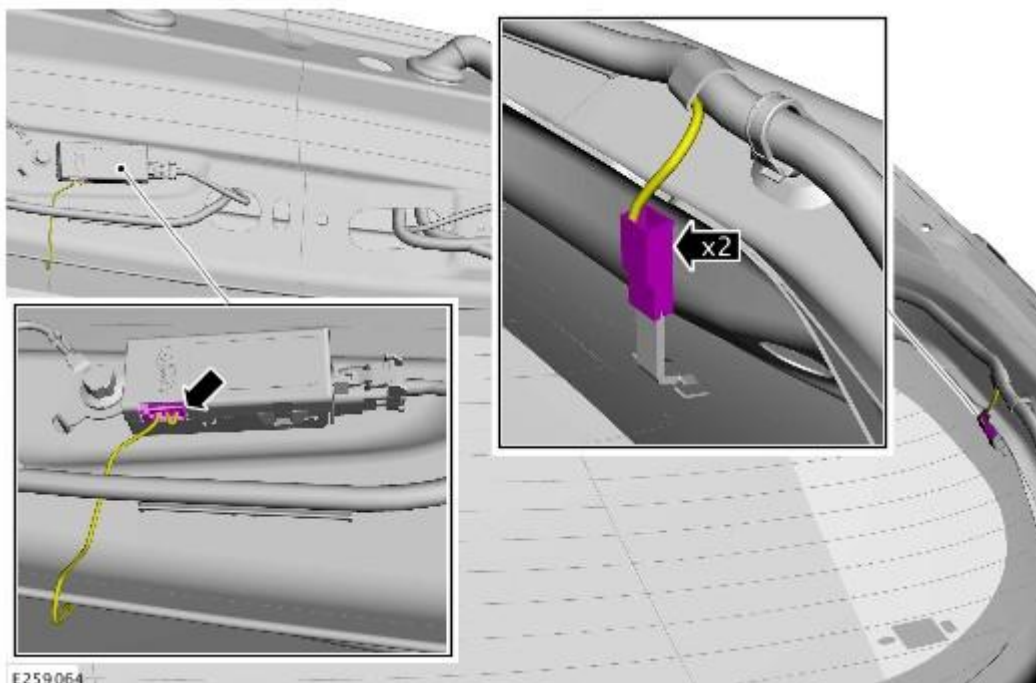
Adhesive Tape
Direct Glazing Removal/Replacement Equipment
Glass Cut-Out Wire
Glass Removal Suction Cup
Knife

### Materials

Name	Specification
Adhesive	-
Adhesive	WSS-M11P57-A5

### Removal

1. Refer to: [Rear Spoiler](#) (501-08 Exterior Trim and Ornamentation, Removal and Installation).  
Refer to: [Rear Window Wiper Motor](#) (501-16 Wipers and Washers, Removal and Installation).
- 2.

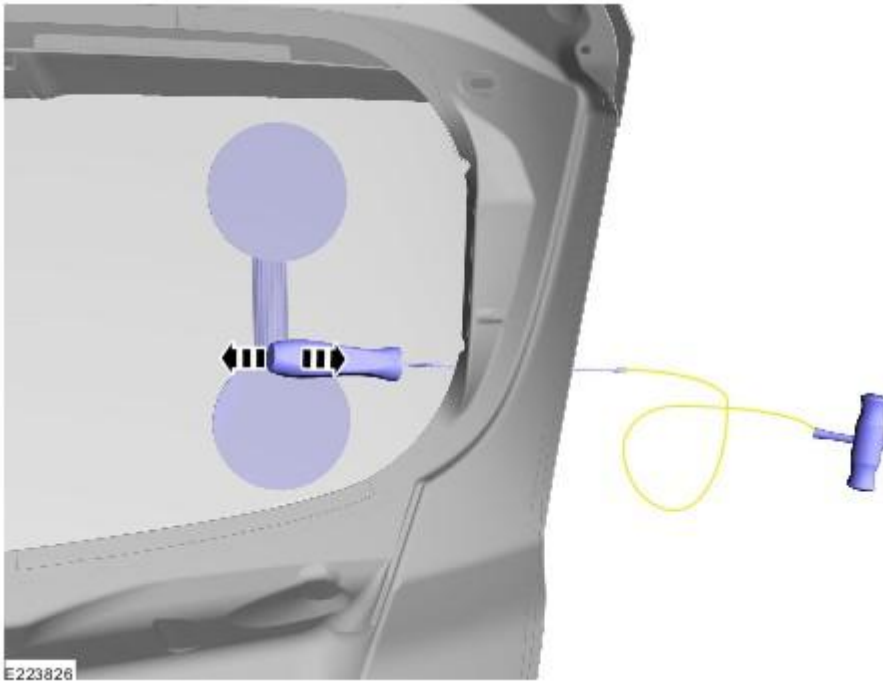


3.



**NOTICE:** Make sure that the component paintwork is not damaged.  
Use a suitable awl to thread the cutting wire.

Use the General Equipments: [Glass Removal Suction Cup](#), [Direct Glazing Removal/Replacement Equipment](#), [Glass Cut-Out Wire](#)



E223826

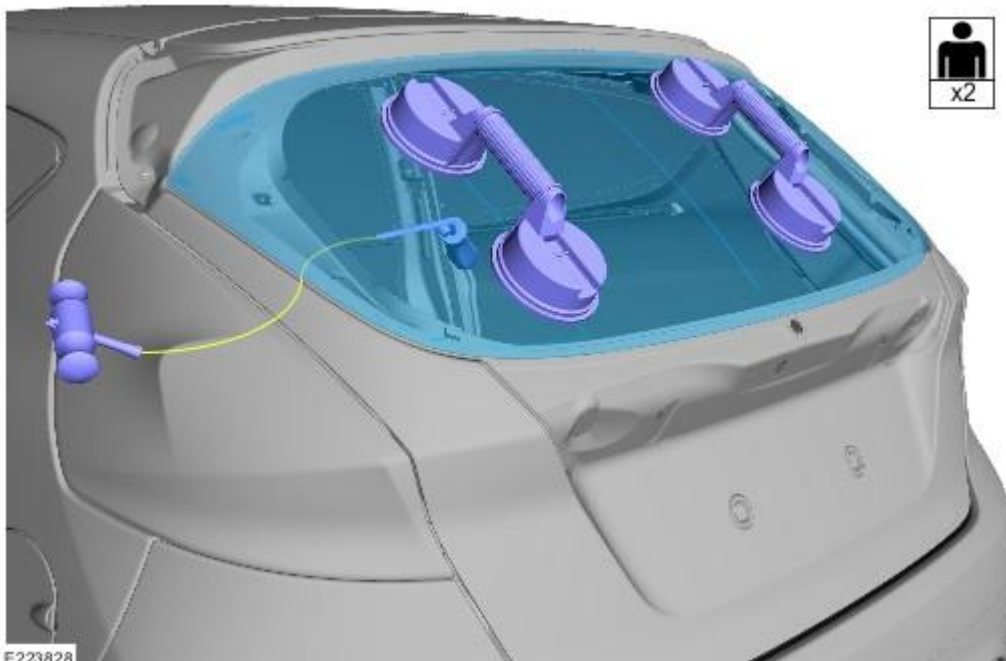


4.

**!** NOTICE: Make sure that the component paintwork is not damaged.  
NOTE: Some resistance may be encountered when cutting through the glass locating spacers.

Use a suitable adhesive tape or a laminated card to prevent paintwork damages.

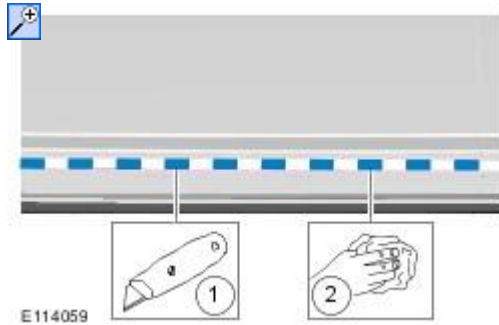
Use the General Equipments: [Glass Removal Suction Cup](#), [Direct Glazing Removal/Replacement Equipment](#), [Glass Cut-Out Wire](#)



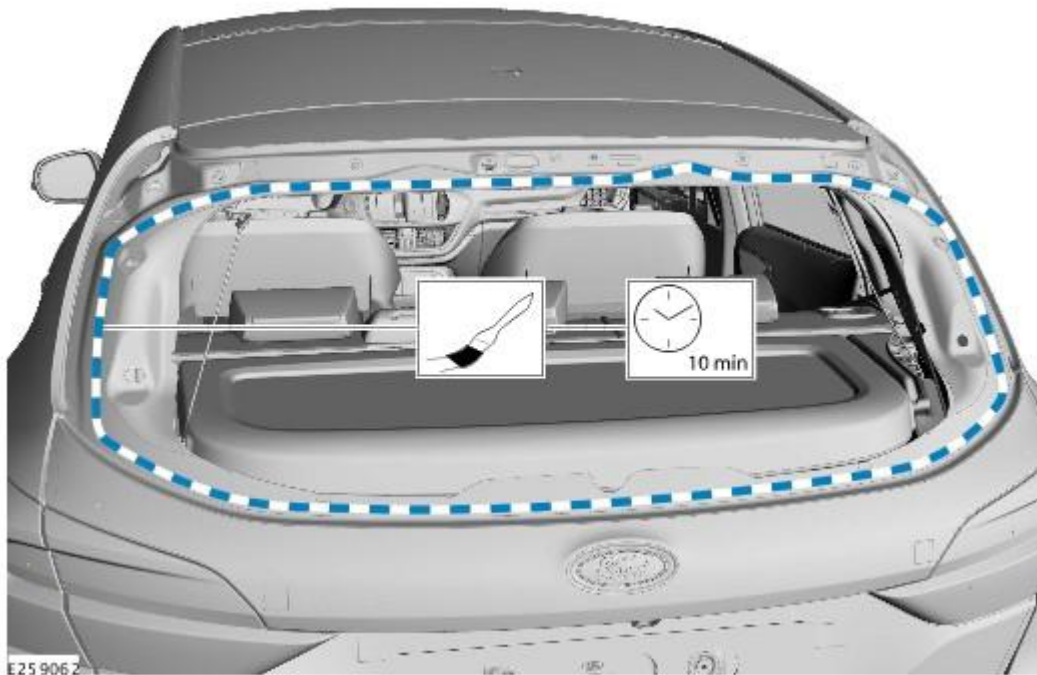
E223828

## Installation

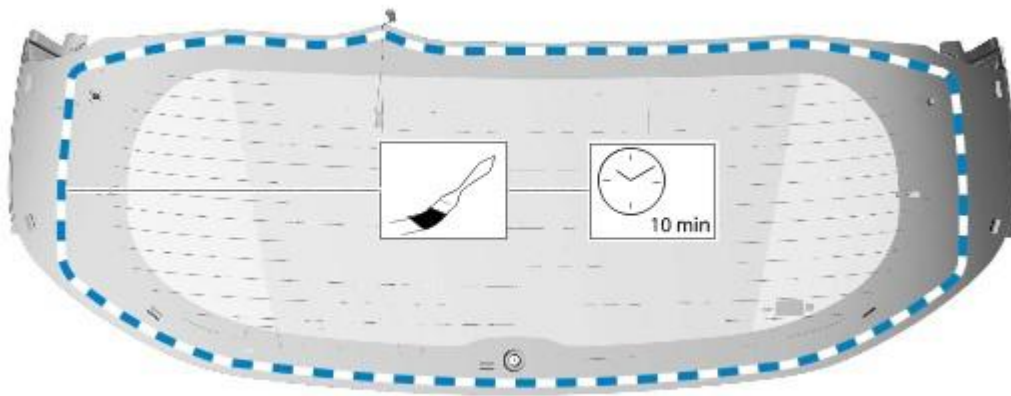
1. NOTE: Minimum 1 mm bead thickness.  
*Use the General Equipment: Knife*
2. NOTE: Make sure that the mating faces are clean and free of foreign material.
3. NOTE: Touching the adhesive surface will impair rebonding.  
Prepare the liftgate window glass, liftgate window glass flange and trimmed PU adhesive in accordance with the instructions supplied with the glass adhesive kit.



2.
  - Apply the activator/ primer in accordance with the instructions supplied with the glass adhesive kit.
  - Check the area for paintwork damage and repair if necessary.

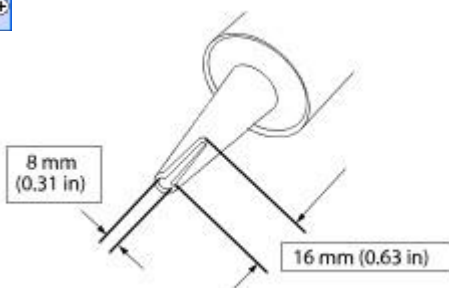


3. Apply the activator/ primer in accordance with the instructions supplied with the glass adhesive kit.



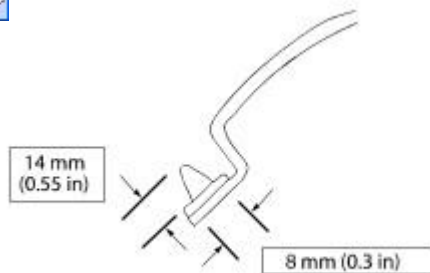
E259061

4.



E158315

5.



E158318

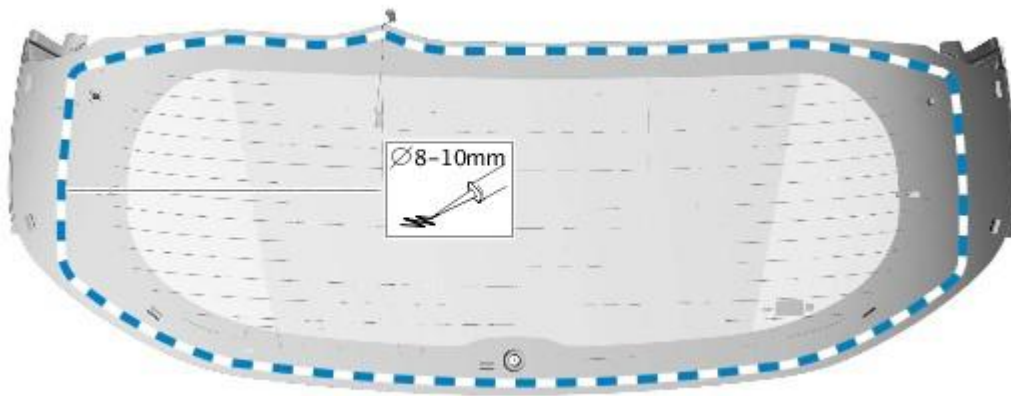
6.

- NOTE: Discard the first 100 mm of adhesive as this may have a reduced working time.  
NOTE: Make sure that any breakage in the continuous bead of adhesive is overlapped by 20 mm.

*Use the General Equipment:* [Direct Glazing Removal/Replacement Equipment](#)  
*Material:* - (Adhesive)

- Repairs under warranty:

*Material:* [WSS-M11P57-A5 \(Adhesive\)](#)



E259074

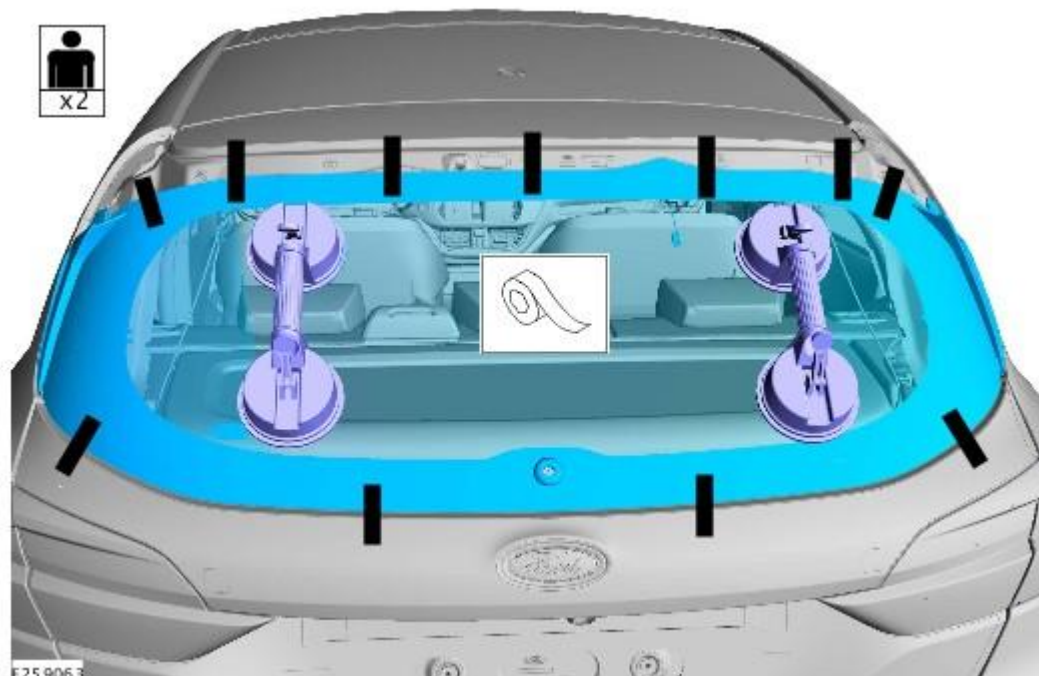
- 7.
- Press firmly and evenly into position.

*Use the General Equipment:* [Glass Removal Suction Cup](#)

-  **NOTICE:** During the curing time of the polyurethane (PU) adhesive, the door windows must be left open.

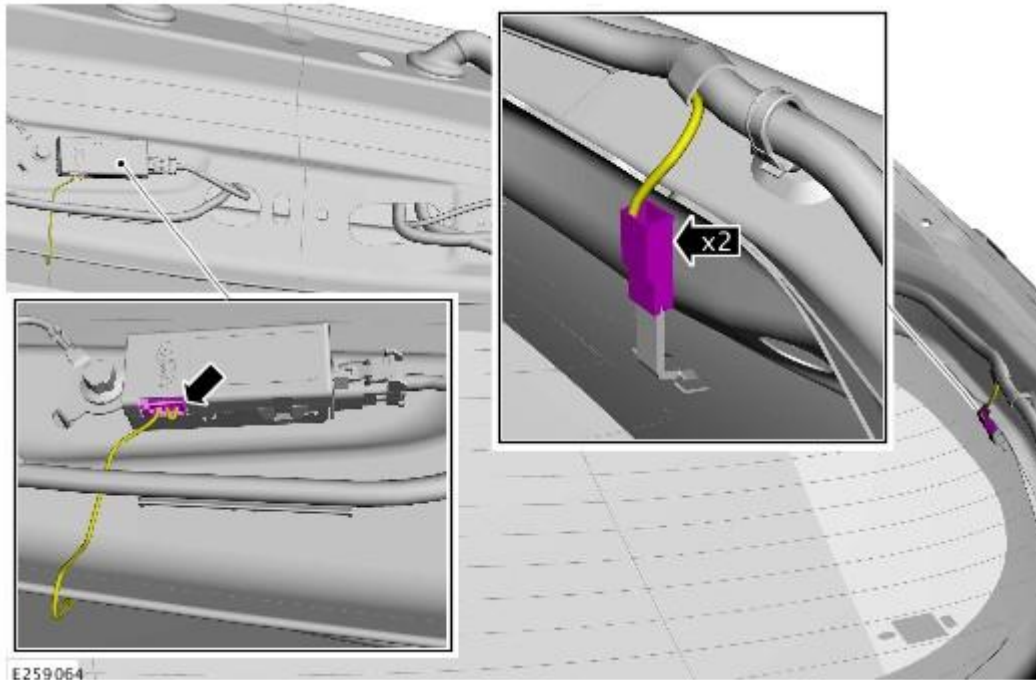
Using tape, secure the liftgate window glass in the correct position until the PU adhesive has cured.

*Use the General Equipment:* [Adhesive Tape](#)



E259063

- 8.

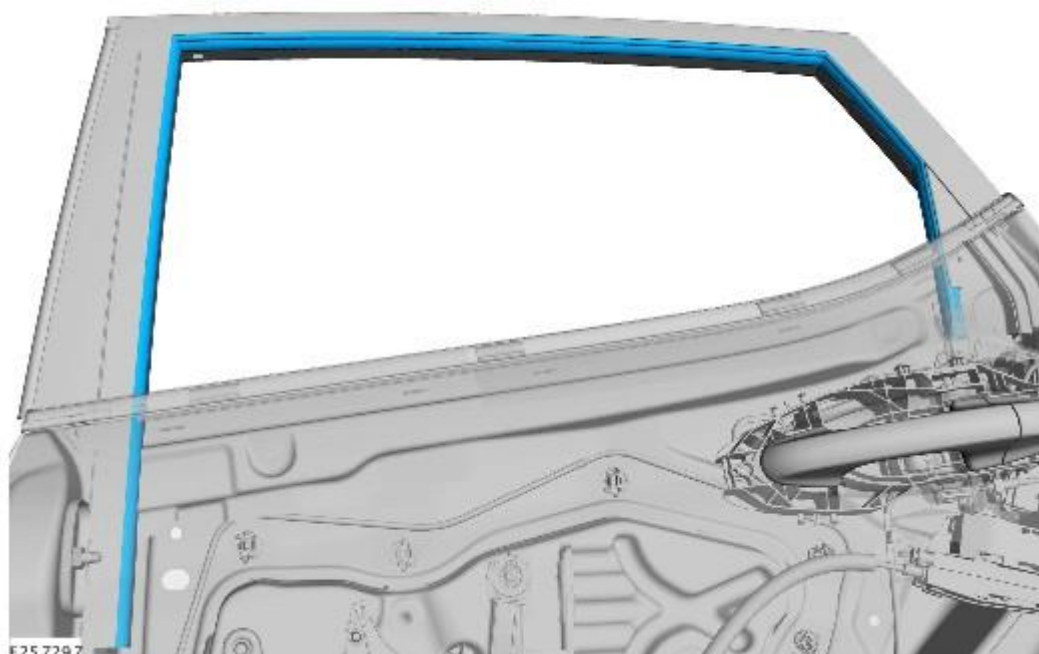


9. Refer to: [Rear Spoiler](#) (501-08 Exterior Trim and Ornamentation, Removal and Installation).  
Refer to: [Rear Window Wiper Motor](#) (501-16 Wipers and Washers, Removal and Installation).

## Removal and Installation

### Removal

1. Refer to: [Rear Door Window Glass](#) (501-11 Glass, Frames and Mechanisms, Removal and Installation).
- 2.

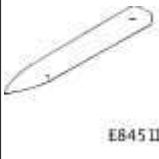


### Installation

1. To install, reverse the removal procedure.

## Removal and Installation

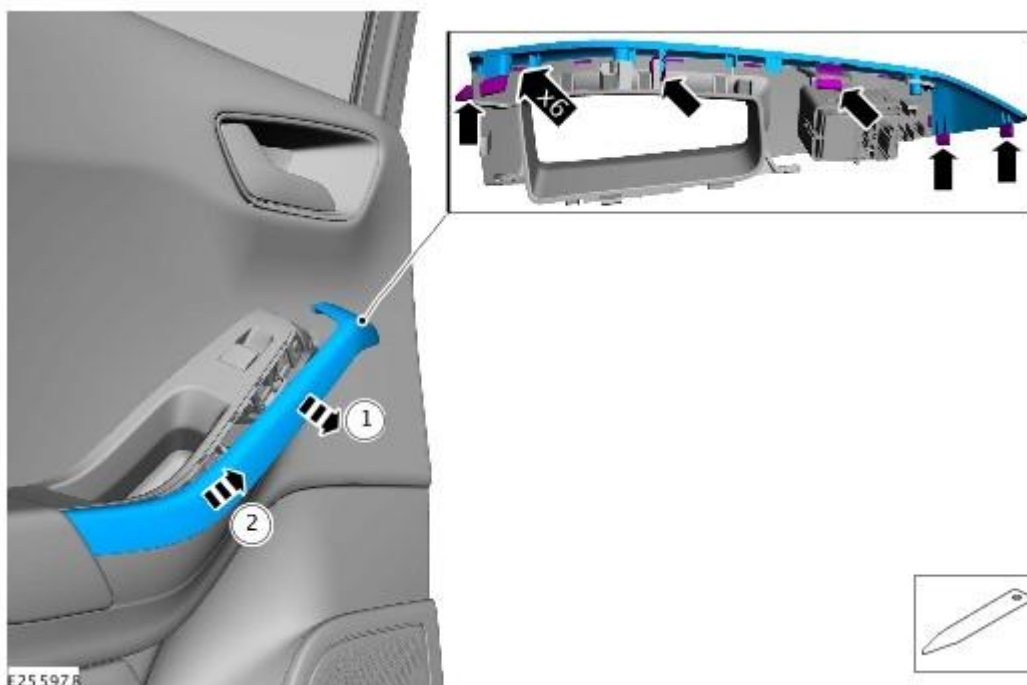
### Special Tool(s)

 E845 II	501-125 Remover, Grab Handle Cover
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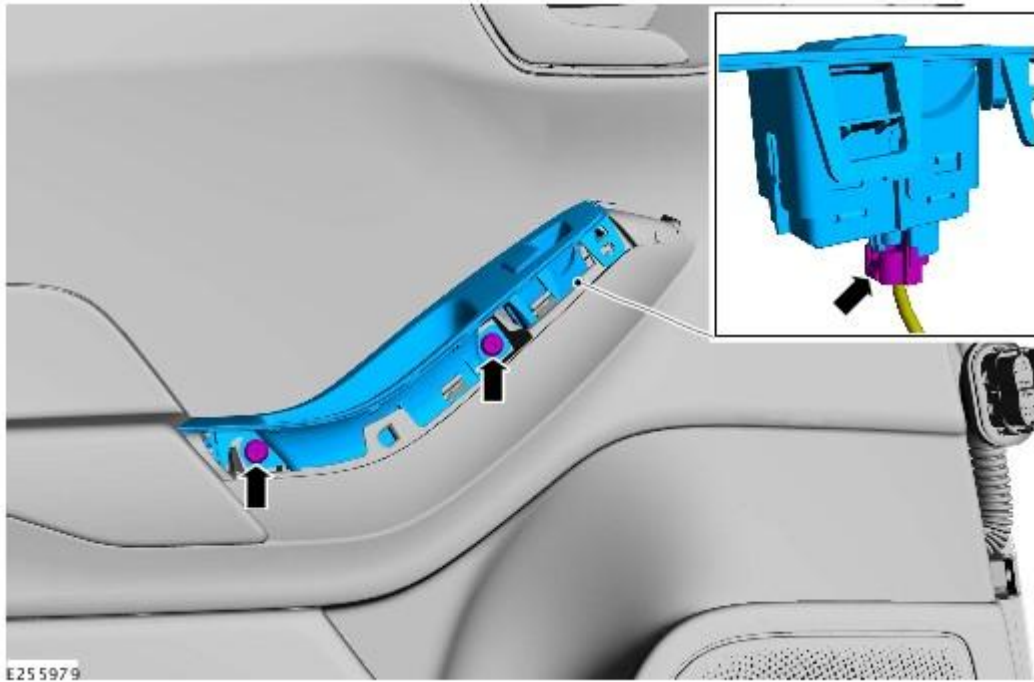
### Removal

NOTE: Removal steps in this procedure may contain installation details.

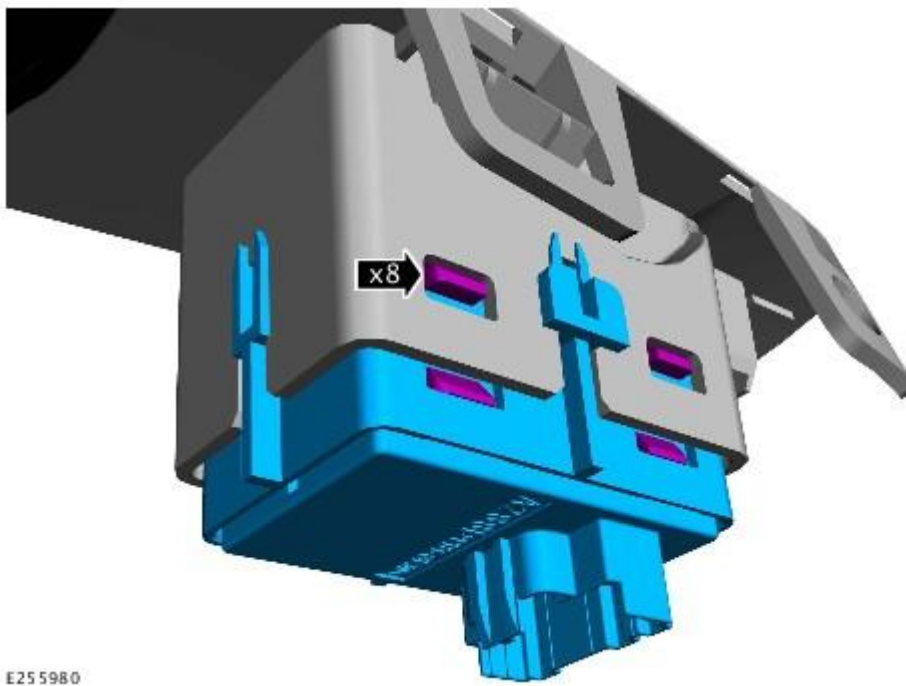
1. Use Special Service Tool: [501-125](#).



- 2.



3. NOTE: This step is only necessary when installing a new component.



### Installation

1. To install, reverse the removal procedure.

## Removal and Installation

### General Equipment

Flat Headed Screw Driver

### Removal

NOTE: Removal steps in this procedure may contain installation details.

1. Refer to: [Rear Door Trim Panel](#) (501-05 Interior Trim and Ornamentation, Removal and Installation).

All vehicles

2.

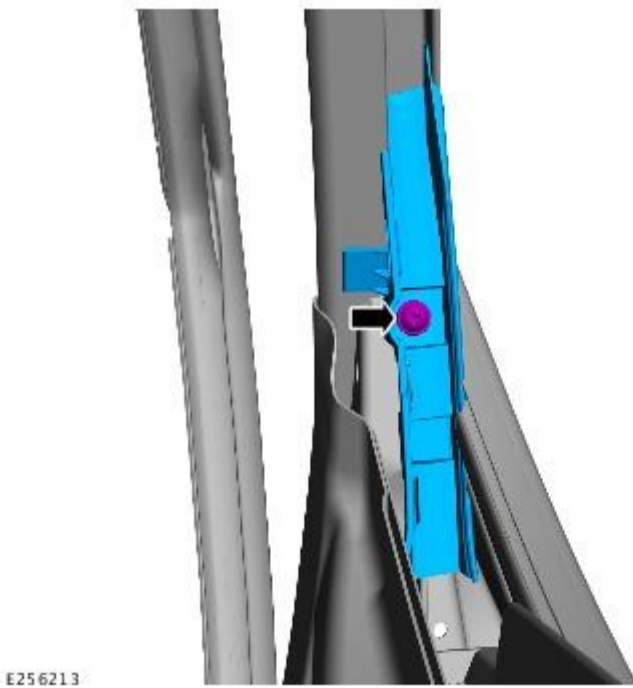


E256211

3.

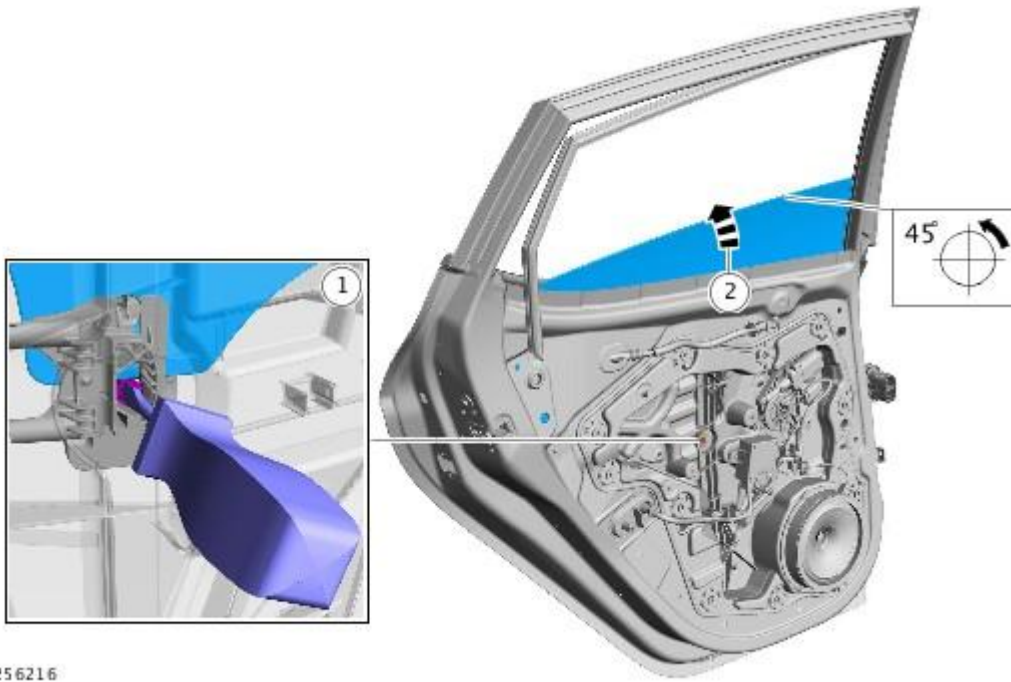


4.



All vehicles

5. Use the General Equipment: [Flat Headed Screw Driver](#)



E256216

### Installation

1. To install, reverse the removal procedure.

## Removal and Installation

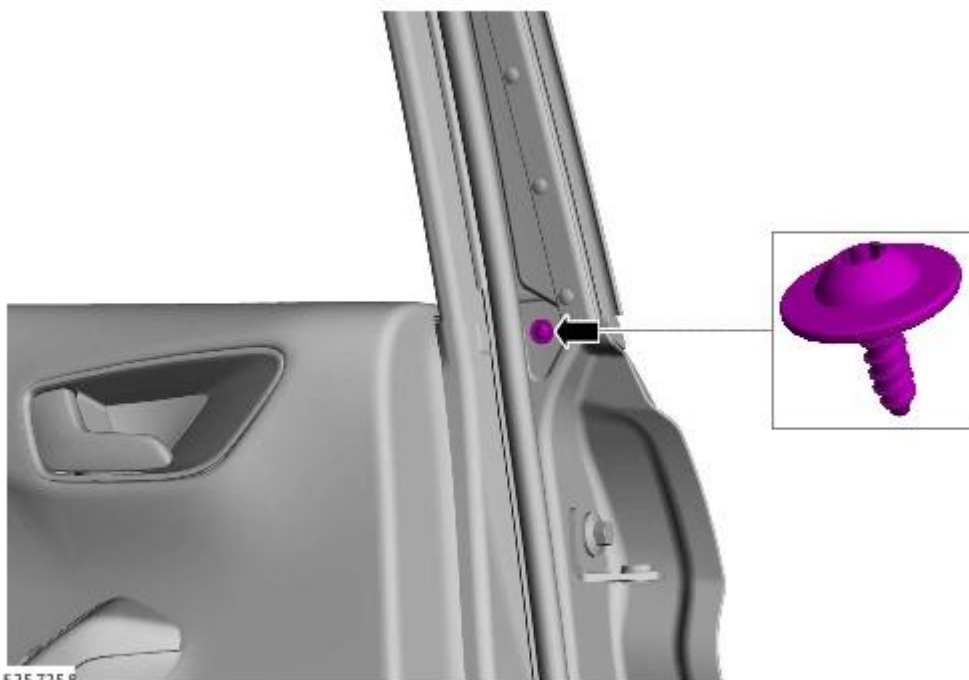
### Removal

1.



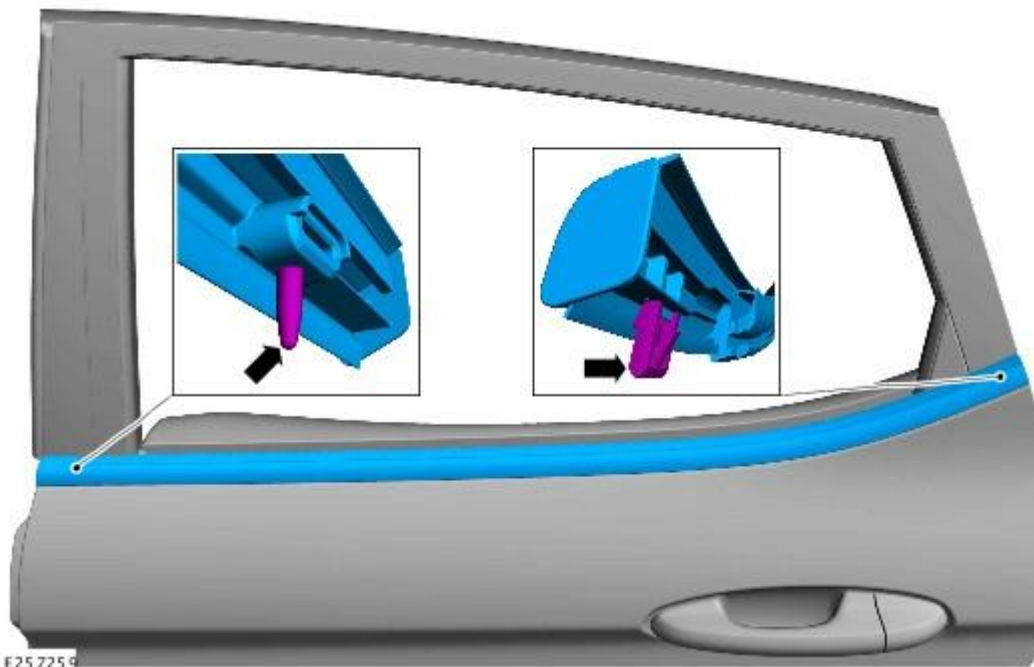
E257257

2.



E257258

3.



E257259

### **Installation**

1. To install, reverse the removal procedure.

## Removal and Installation

### General Equipment

Adhesive Tape
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Flat Headed Screw Driver
--------------------------

### Removal

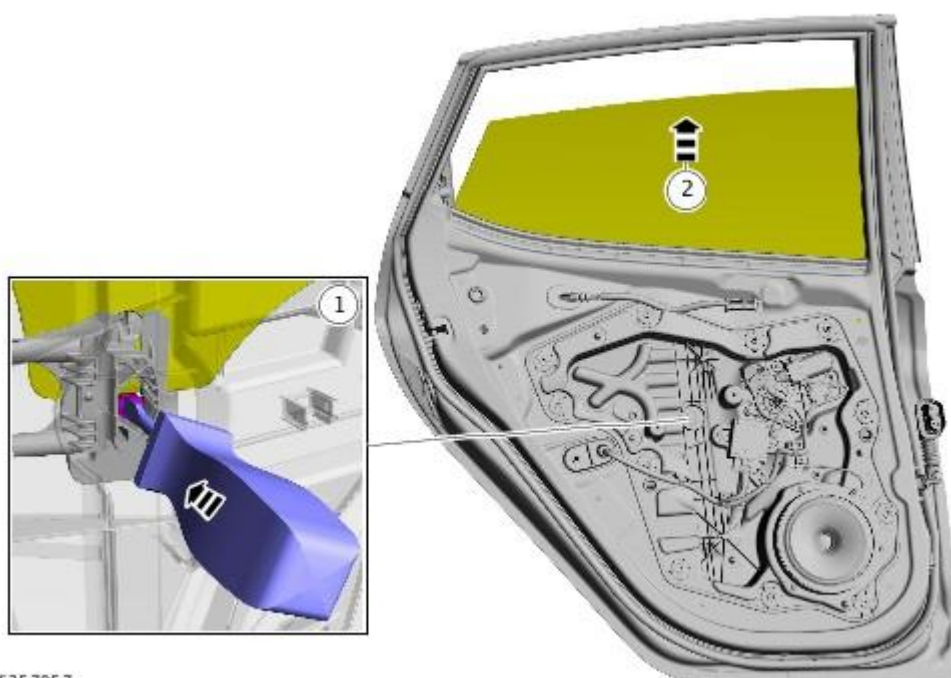
NOTE: Removal steps in this procedure may contain installation details.

All vehicles

1. Refer to: [Rear Door Trim Panel](#) (501-05 Interior Trim and Ornamentation, Removal and Installation).

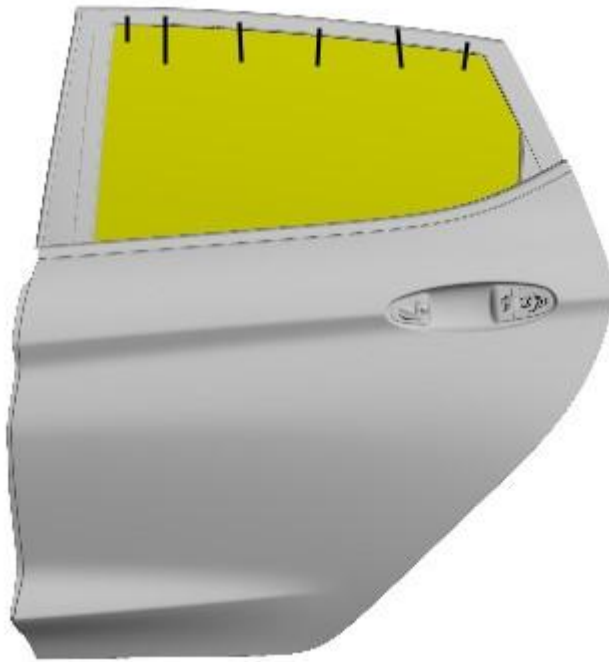
All vehicles

2. Use the General Equipment: [Flat Headed Screw Driver](#)



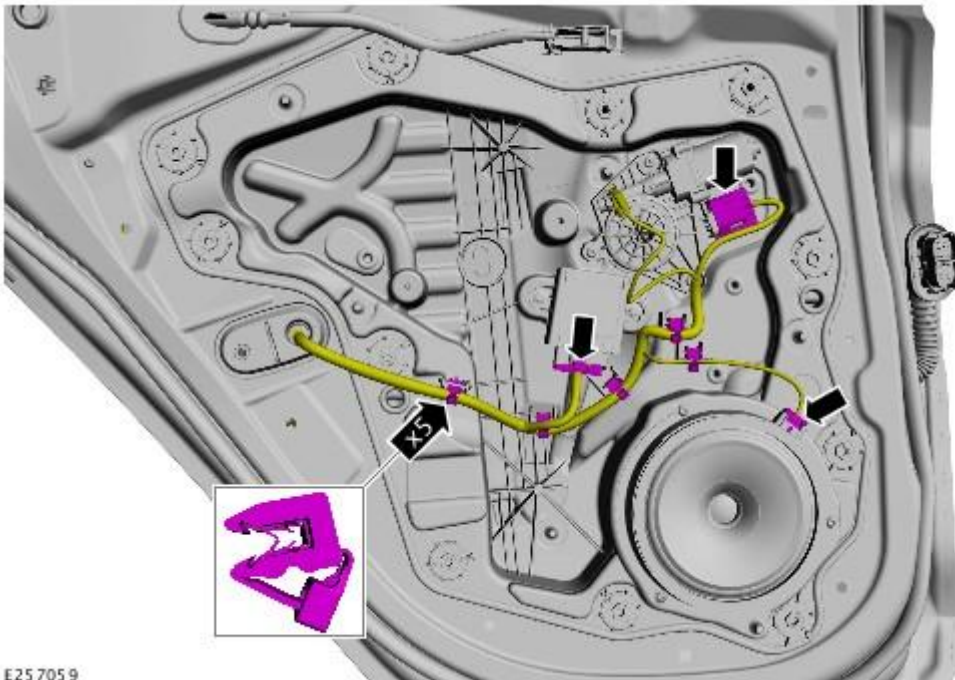
E257057

3. Use the General Equipment: [Adhesive Tape](#)



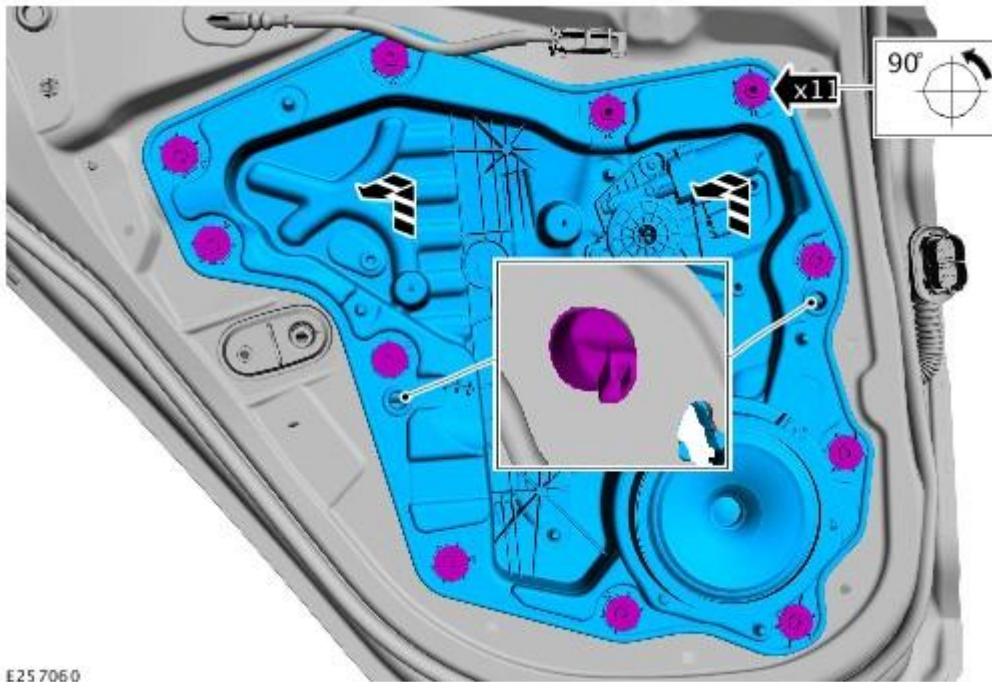
E257058

4.



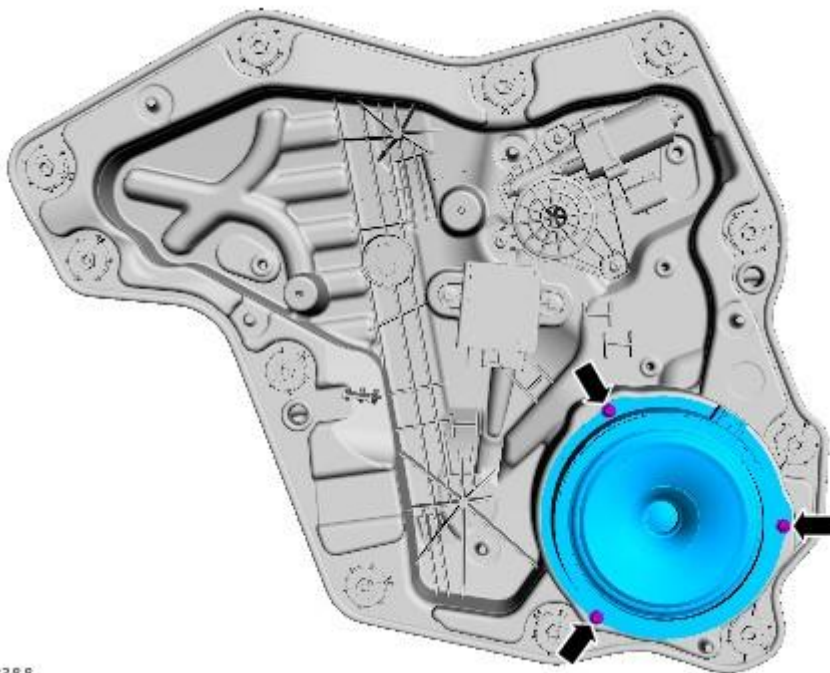
E257059

5.



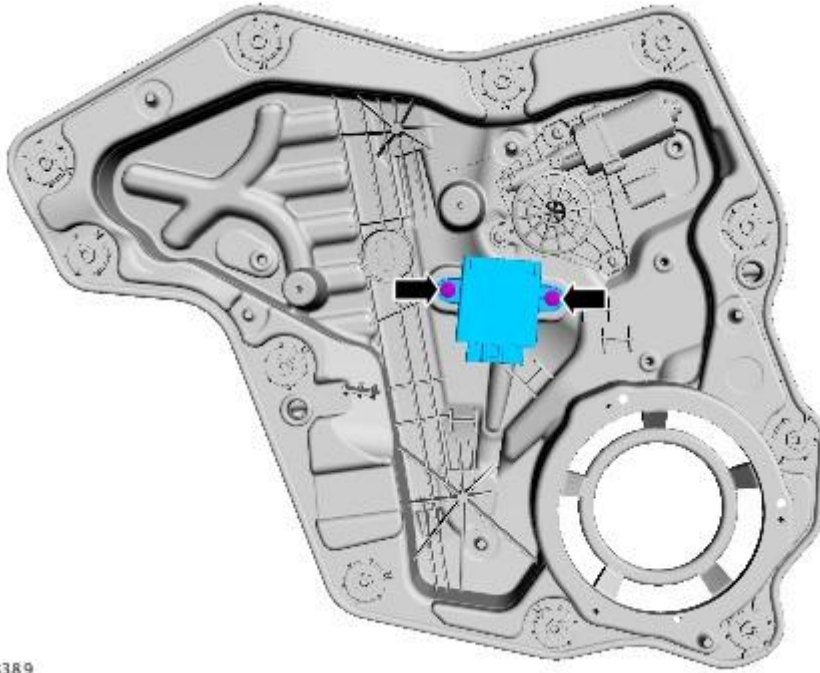
E257060

6. NOTE: This step is only necessary when installing a new component.



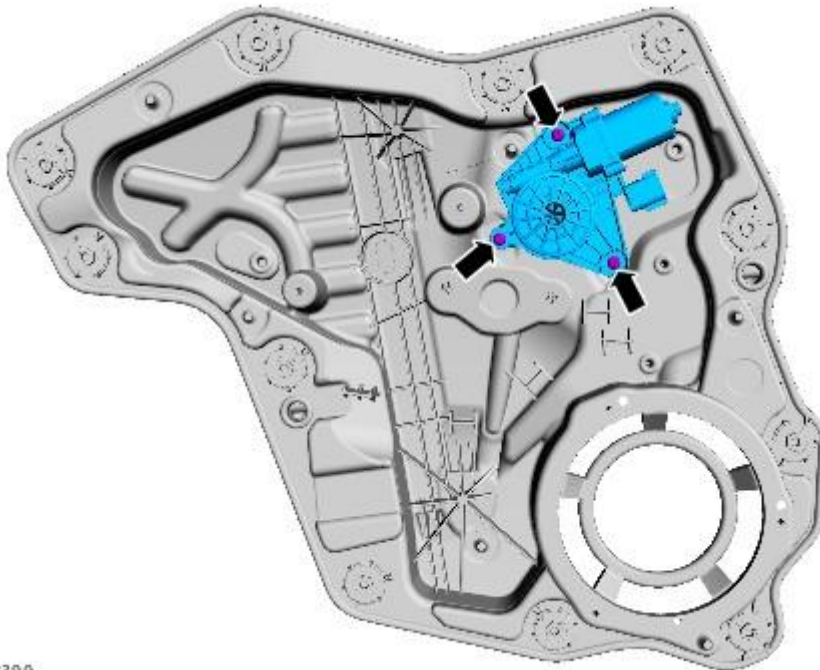
E258388

7. NOTE: This step is only necessary when installing a new component.



E258389

8. NOTE: This step is only necessary when installing a new component.



E258390

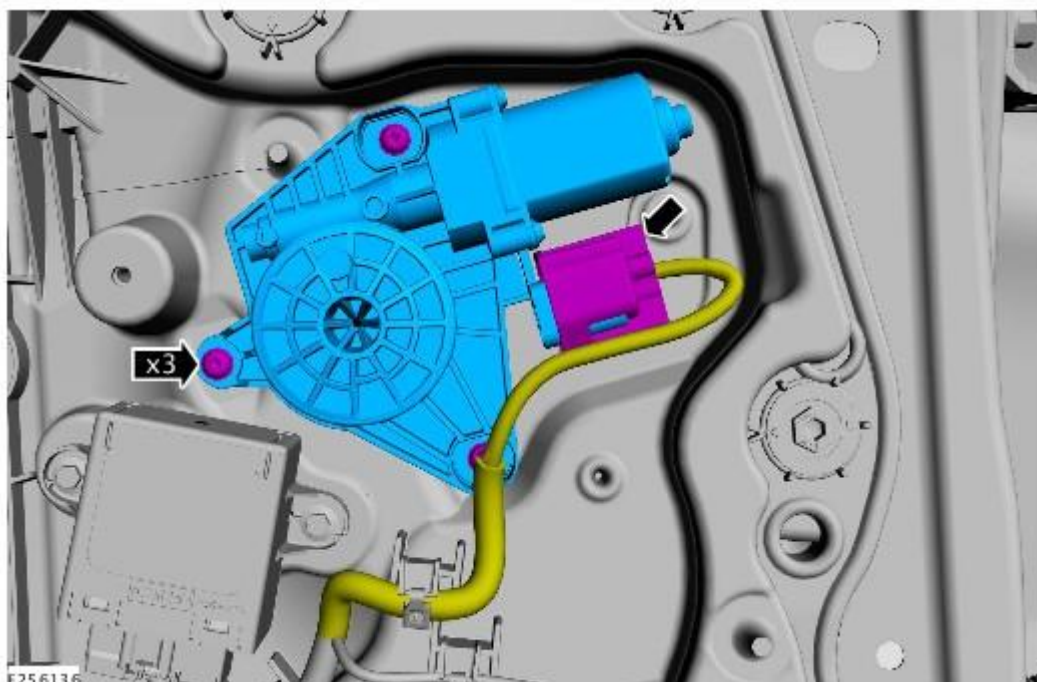
### Installation

1. To install, reverse the removal procedure.
2. Refer to: [Power Door Window Initialization](#) (501-11 Glass, Frames and Mechanisms, General Procedures).

## Removal and Installation

### Removal

1. Refer to: [Rear Door Trim Panel](#) (501-05 Interior Trim and Ornamentation, Removal and Installation).
- 2.



### Installation

1. To install, reverse the removal procedure.
2. Refer to: [Power Door Window Initialization](#) (501-11 Glass, Frames and Mechanisms, General Procedures).

## Removal and Installation

### General Equipment

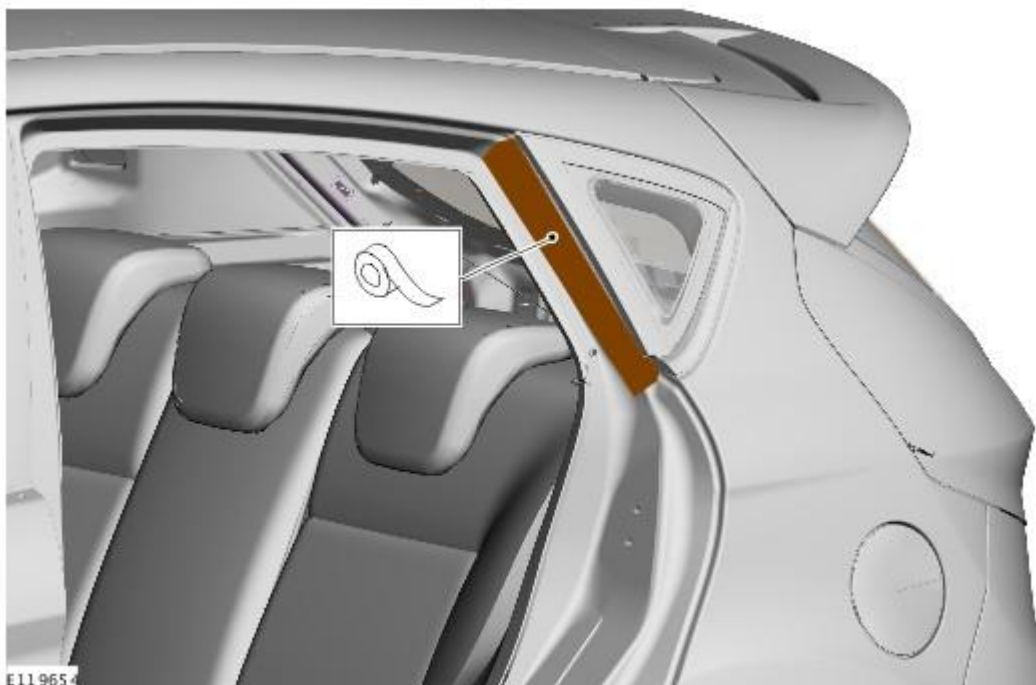
Adhesive Tape
Direct Glazing Removal/Replacement Equipment
Glass Cut-Out Wire
Knife

### Materials

Name	Specification
Adhesive	-
Adhesive	WSS-M11P57-A5

### Removal

1. Use the General Equipment: [Adhesive Tape](#)



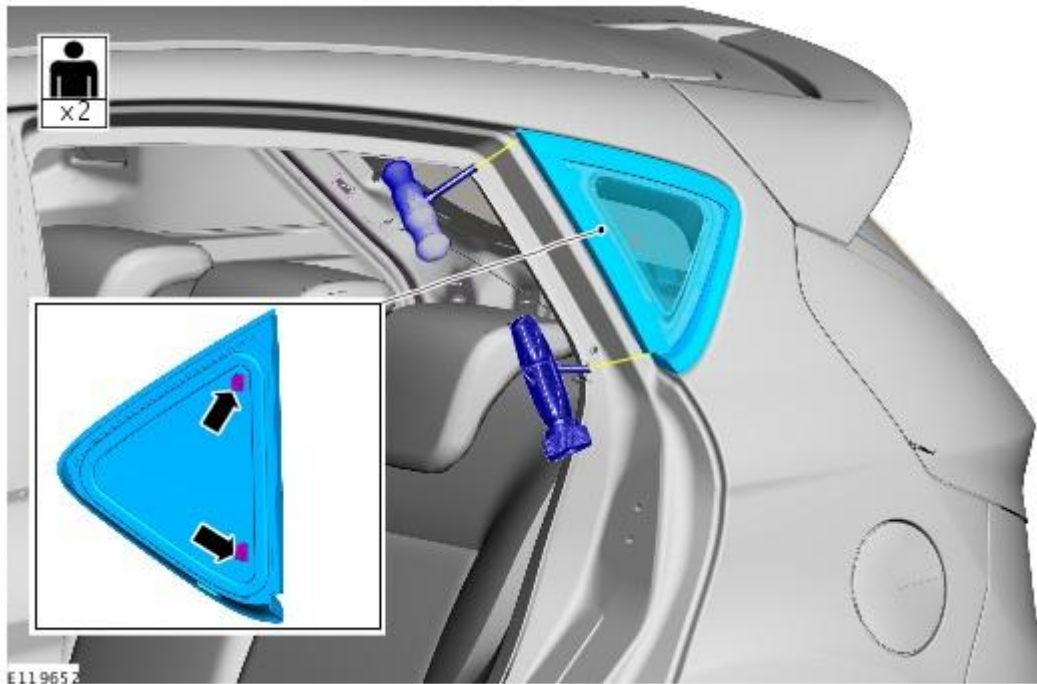
2.



**NOTICE:** Make sure that the component paintwork is not damaged.  
**NOTE:** Some resistance may be encountered when cutting through the glass locating spacers.

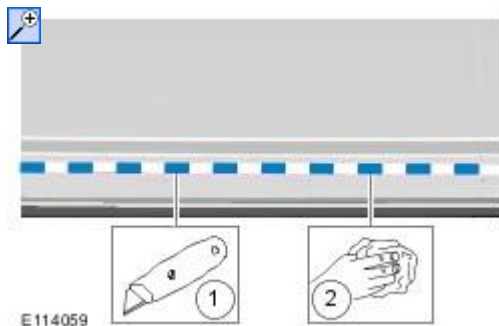
Use suitable adhesive tape or a laminated card to prevent paintwork damages.

Use the General Equipments: [Direct Glazing Removal/Replacement Equipment](#), [Glass Cut-Out Wire](#)

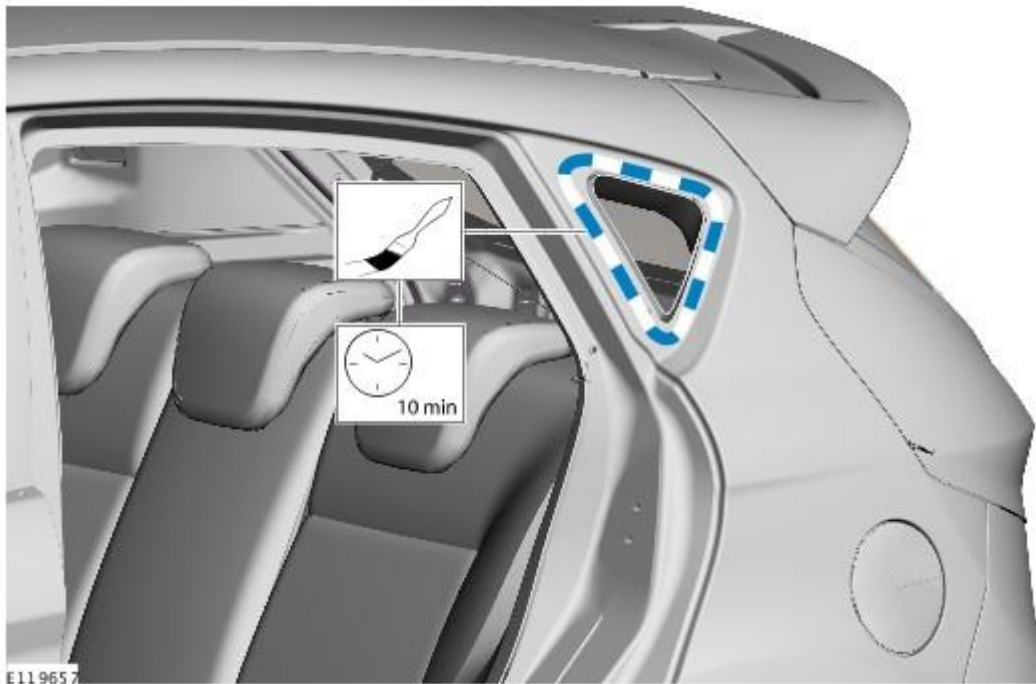


## Installation

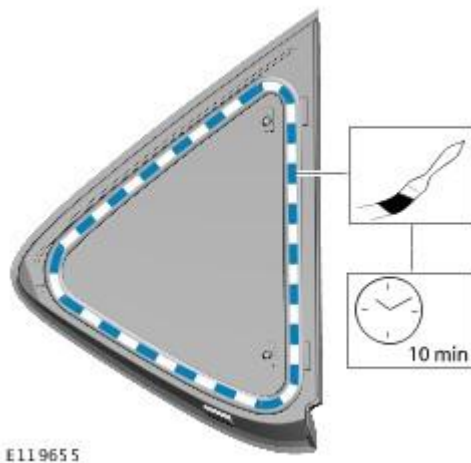
1.
  1. NOTE: Minimum 1 mm bead thickness.  
Use the General Equipment: *Knife*
  2. NOTE: Make sure that the mating faces are clean and free of foreign material.
  3. NOTE: Touching the adhesive surface will impair rebonding.  
Prepare the rear quarter window glass, rear quarter window glass flange and trimmed PU adhesive in accordance with the instructions supplied with the glass adhesive kit.



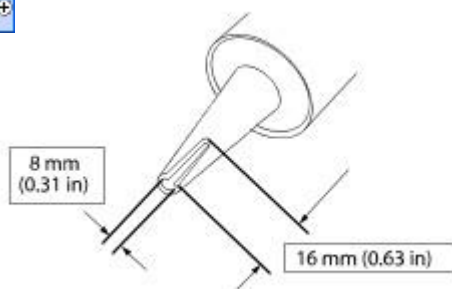
2.
  - Apply the activator/ primer in accordance with the instructions supplied with the glass adhesive kit.
  - Check the area for paintwork damage and repair if necessary.



3. Apply the activator/ primer in accordance with the instructions supplied with the glass adhesive kit.

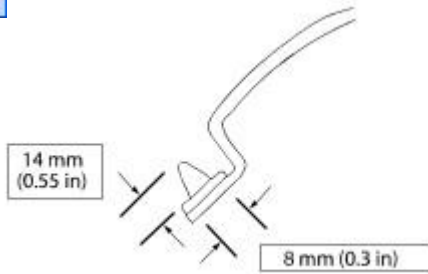


- 4.



E158315

- 5.



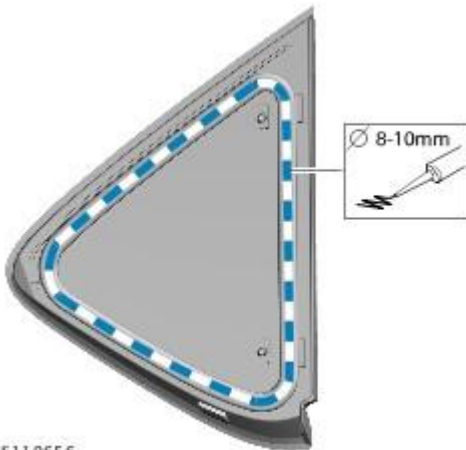
E158318

- 6.
- NOTE: Discard the first 100 mm of adhesive as this may have a reduced working time.  
NOTE: Make sure that any breakage in the continuous bead of adhesive is overlapped by 20 mm.


*Use the General Equipment:* [Direct Glazing Removal/Replacement Equipment](#)  
*Material:* - (Adhesive)

- Repairs under warranty:

*Material:* [WSS-M11P57-A5 \(Adhesive\)](#)

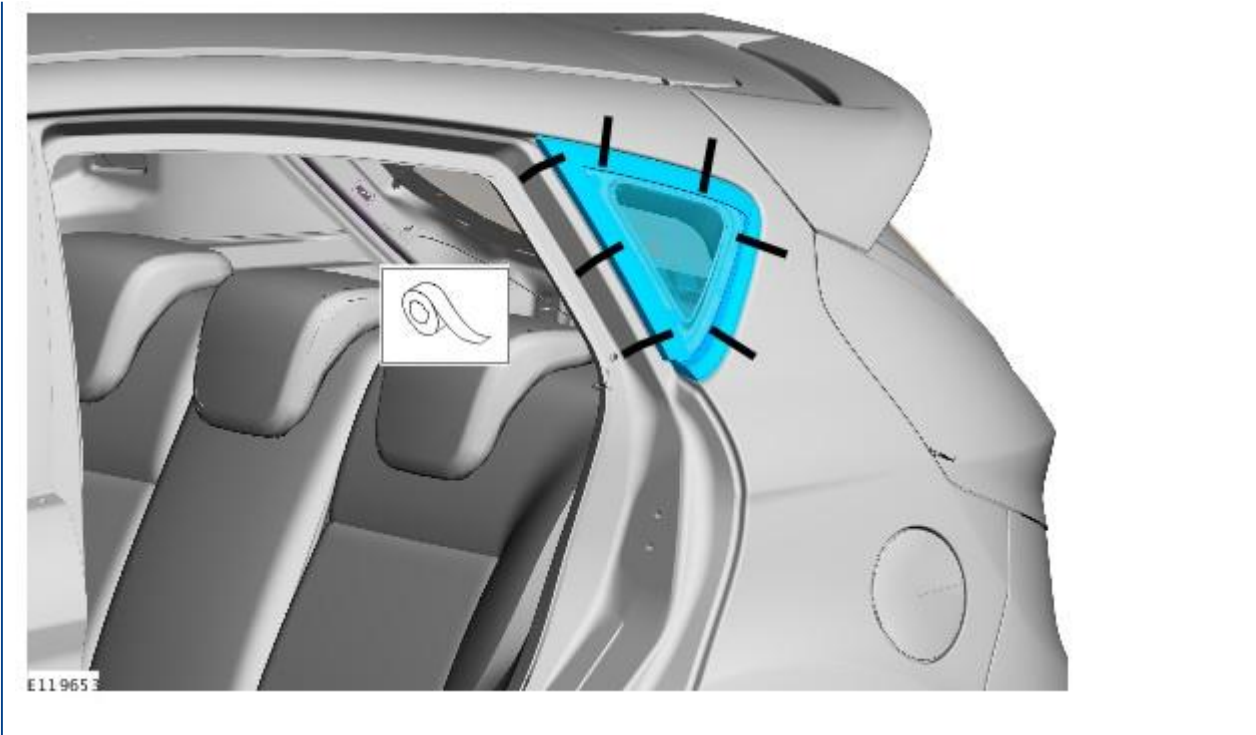


E119656

- 7.
- Press firmly and evenly into position.
  -  NOTICE: During the curing time of the polyurethane (PU) adhesive, the door windows must be left open.

Using tape, secure the rear quarter window glass in the correct position until the PU adhesive has cured.

*Use the General Equipment:* [Adhesive Tape](#)



## Removal and Installation

### General Equipment

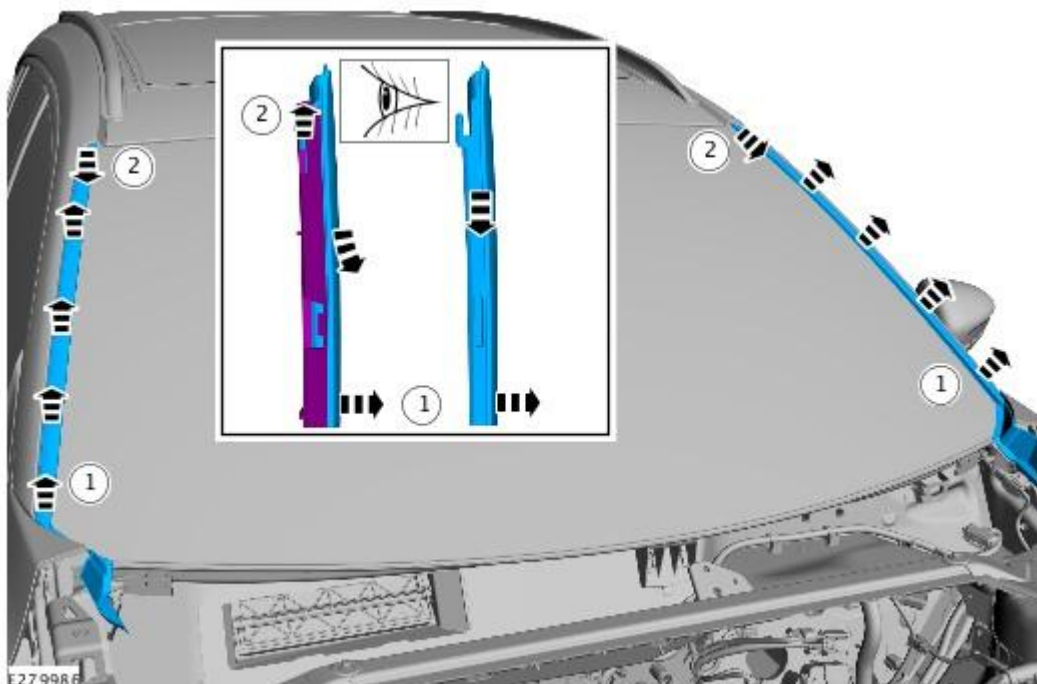
Adhesive Tape
Direct Glazing Removal/Replacement Equipment
Knife

### Materials

Name	Specification
Adhesive	-
Adhesive	WSS-M11P57-A5

### Removal

1.



2. Refer to: [Cowl Panel Grille](#) (501-02 Front End Body Panels, Removal and Installation).  
Refer to: [A-Pillar Trim Panel](#) (501-05 Interior Trim and Ornamentation, Removal and Installation).

Vehicles With: Lane Keeping Aid

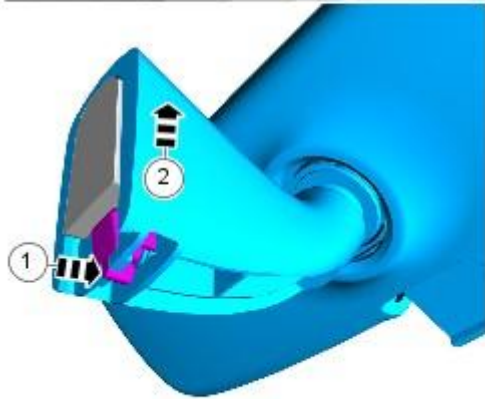
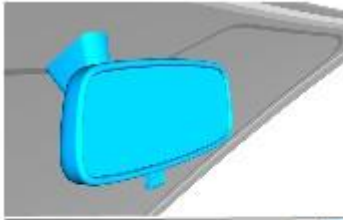
3. Refer to: [Image Processing Module A \(IPMA\)](#) (419-07 Lane Keeping System, Removal and Installation).  
Refer to: [Rain Sensor](#) (501-16 Wipers and Washers, Removal and Installation).

Vehicles With: Autolamps

4. Refer to: [Rain Sensor](#) (501-16 Wipers and Washers, Removal and Installation).

Vehicles Without: Auto-Dimming Interior Mirror

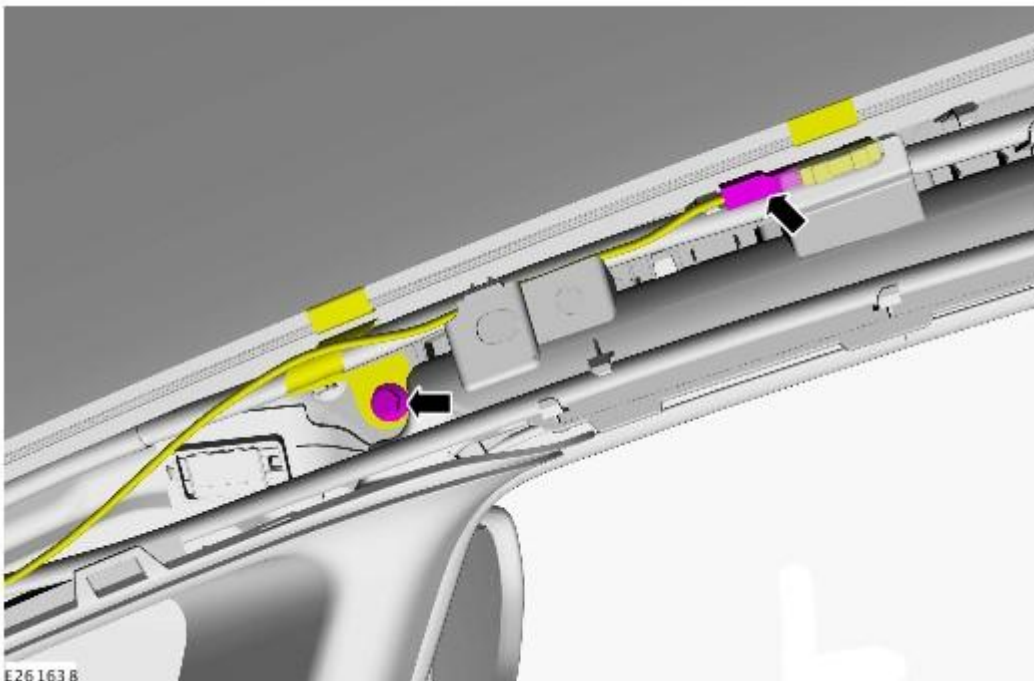
5.



E 103429

Vehicles With: Heated Windshield

6. On both sides.



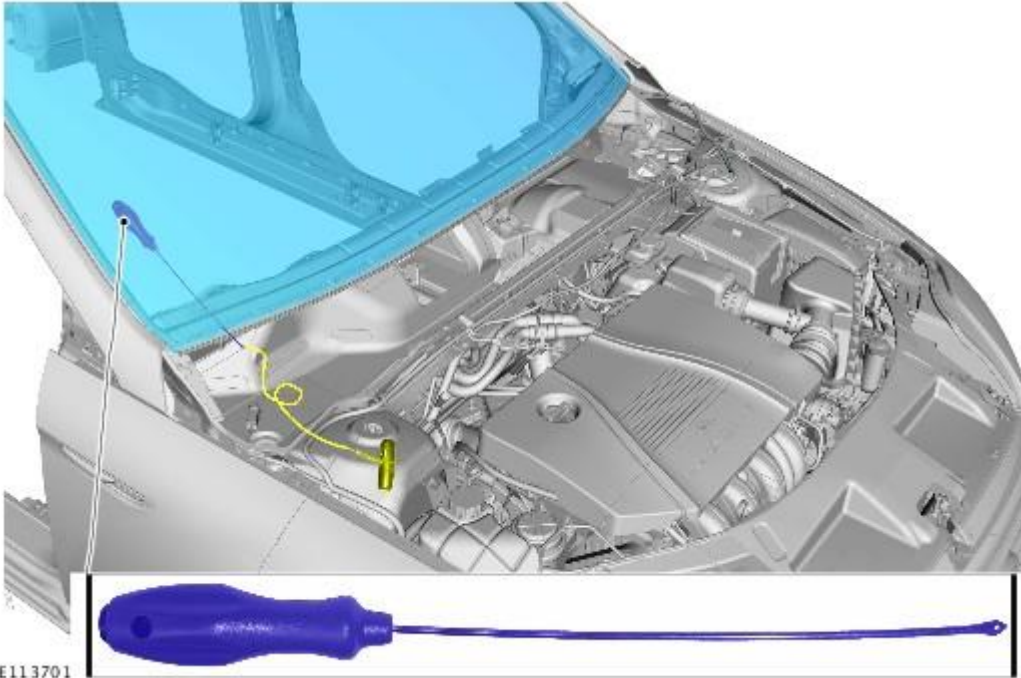
E261638

All vehicles



Use a suitable awl to thread the cutting wire.

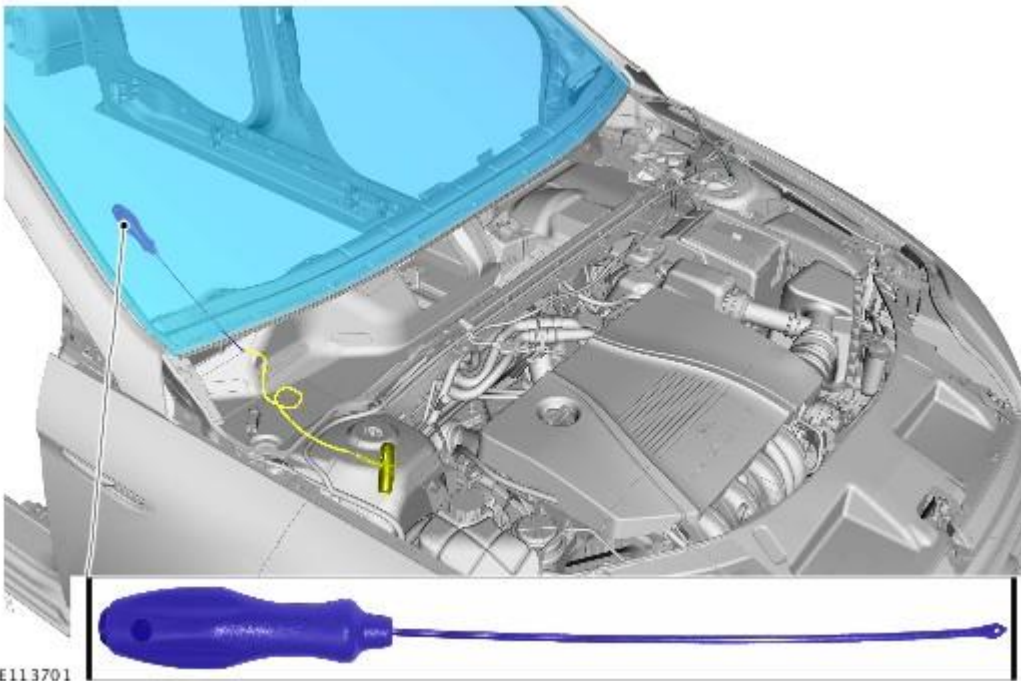
Use the General Equipment: [Direct Glazing Removal/Replacement Equipment](#)



8.

**!** NOTICE: Make sure that the component paintwork is not damaged.  
Use a suitable awl to thread the cutting wire.


*Use the General Equipment:* [Direct Glazing Removal/Replacement Equipment](#)



9.

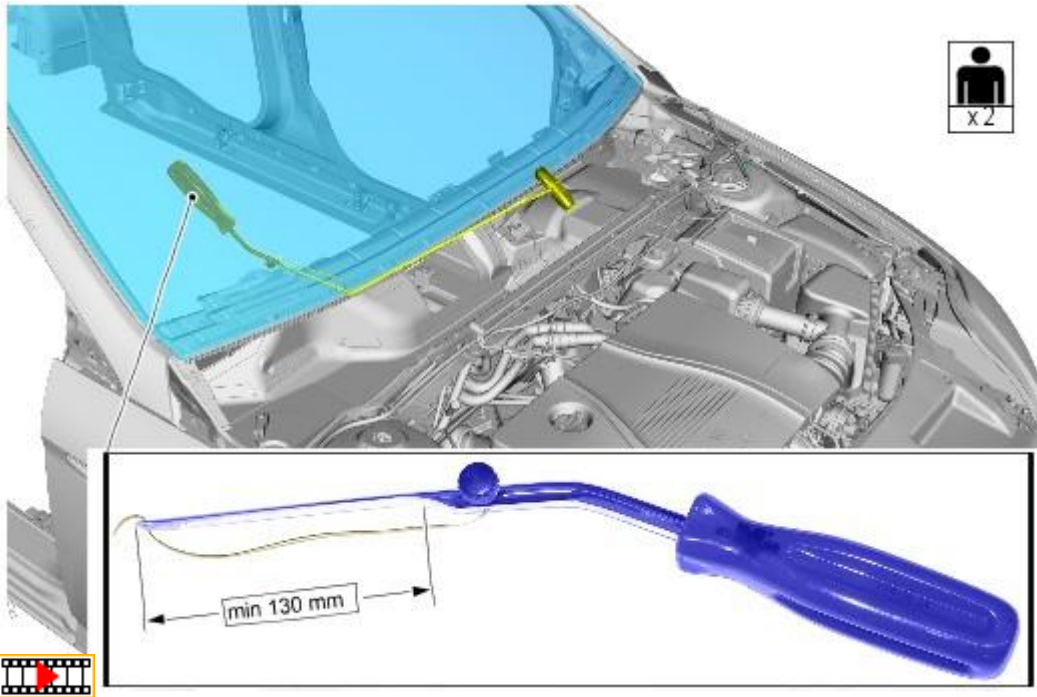
NOTICE:

 Make sure that the component paintwork is not damaged.

 If the original window glass is to be installed, take care not to damage the electrical connectors and the weatherstrip (if equipped).

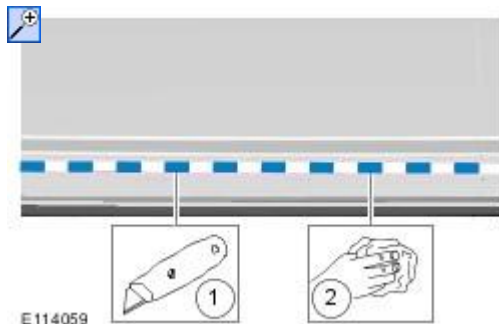
Use a suitable brace to prevent trim damages.

Use the General Equipment: [Direct Glazing Removal/Replacement Equipment](#)

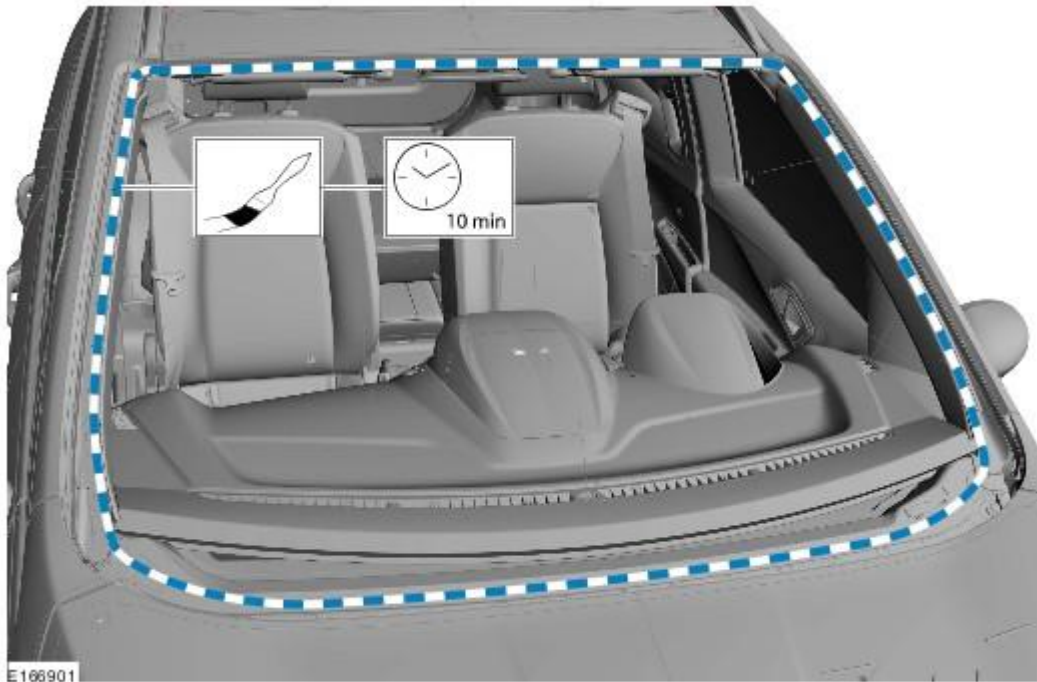


## Installation

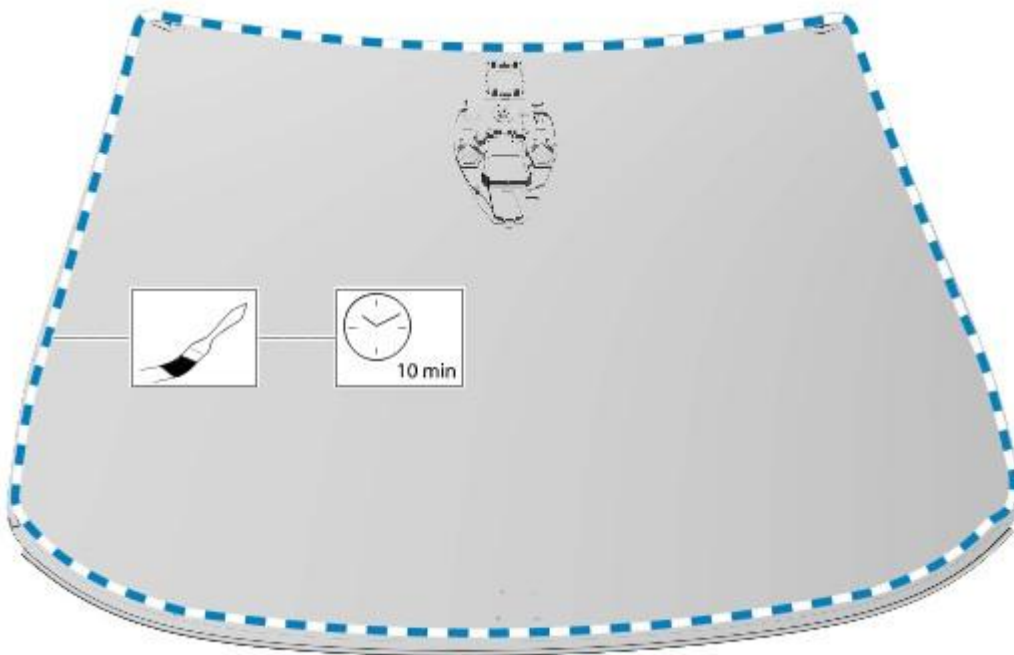
1. **NOTE:** Minimum 1 mm bead thickness.  
*Use the General Equipment:* [Knife](#)
2. **NOTE:** Make sure that the mating faces are clean and free of foreign material.
3. **NOTE:** Touching the adhesive surface will impair rebonding.  
Prepare the windshield glass, windshield glass flange and trimmed PU adhesive in accordance with the instructions supplied with the glass adhesive kit.



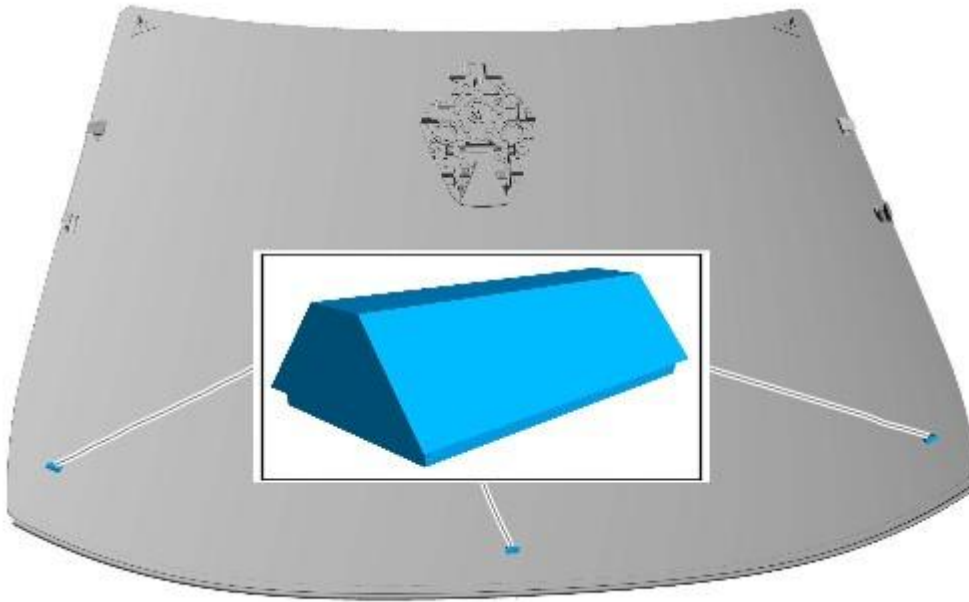
2. Apply the activator/ primer in accordance with the instructions supplied with the glass adhesive kit.



3. Apply the activator/ primer in accordance with the instructions supplied with the glass adhesive kit.

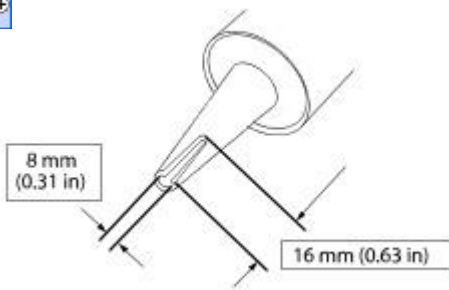


4. **NOTE:** Make sure that the components are installed to the position noted before removal.



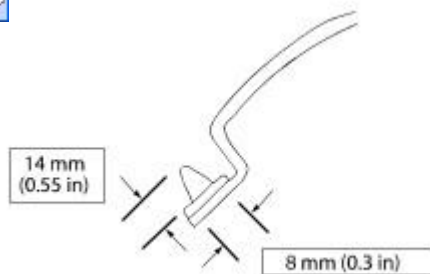
E261729

5.



E158315

6.



E158316

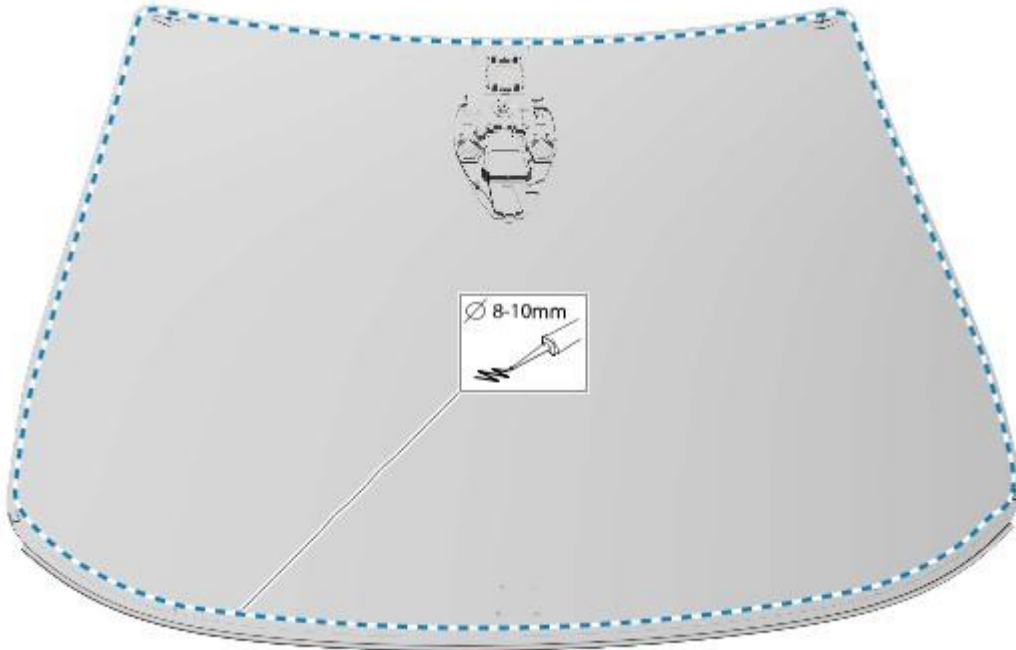
7.

- NOTE: Discard the first 100 mm of adhesive as this may have a reduced working time.  
NOTE: Make sure that any breakage in the continuous bead of adhesive is overlapped by 20 mm.

*Use the General Equipment: Direct Glazing Removal/Replacement Equipment*  
*Material: - (Adhesive)*

- Repairs under warranty:

*Material: WSS-M11P57-A5 (Adhesive)*



E261730

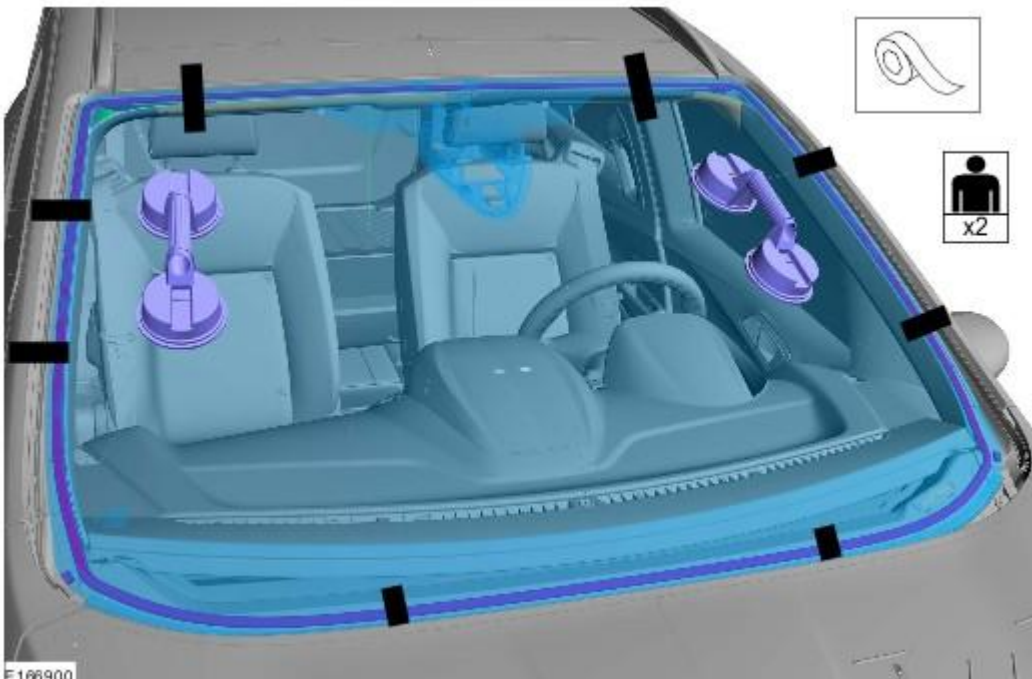
- 8.
- Press firmly and evenly into position.

*Use the General Equipment: [Direct Glazing Removal/Replacement Equipment](#)*

-  **NOTICE:** During the curing time of the polyurethane (PU) adhesive, the door windows must be left open.

Using tape, secure the windshield glass in the correct position until the PU adhesive has cured.

*Use the General Equipment: [Adhesive Tape](#)*

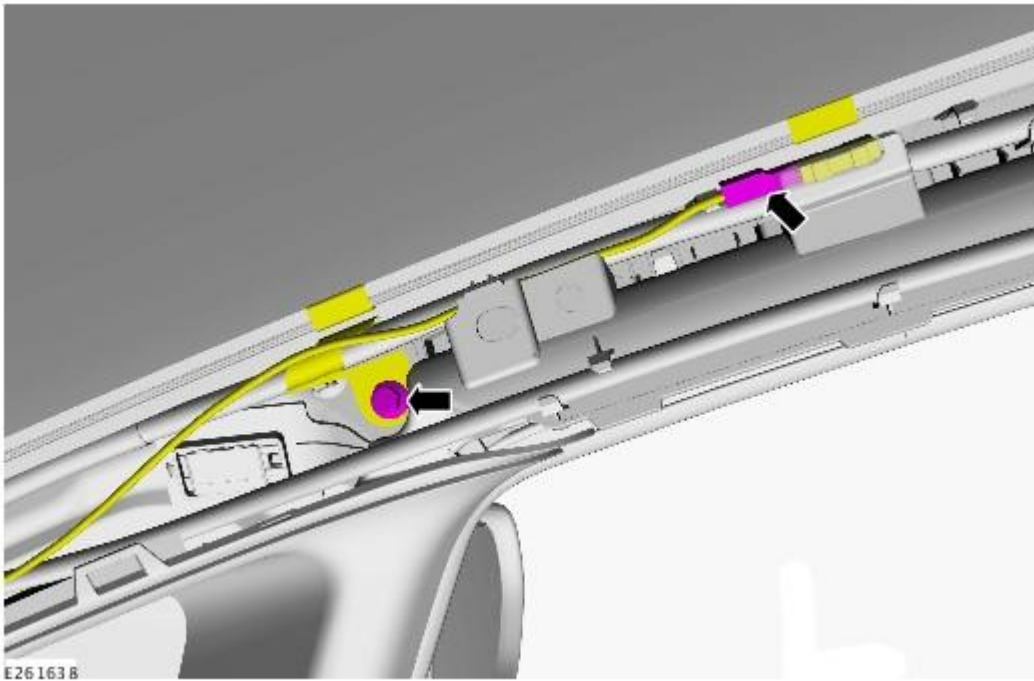


E166900

Vehicles With: Heated Windshield

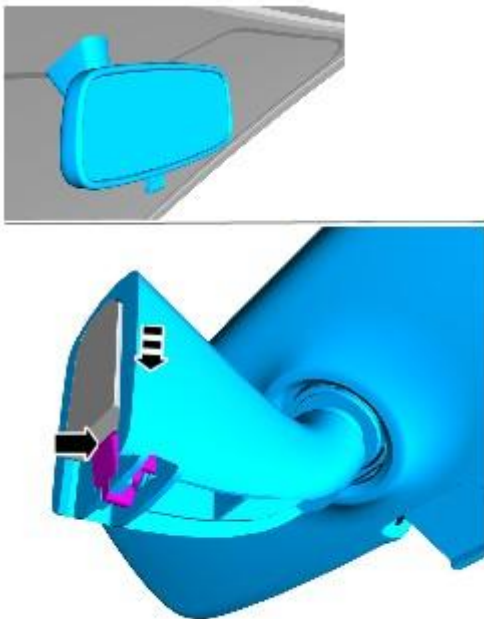
9. On both sides.

*Torque: 11 Nm*



Vehicles Without: Auto-Dimming Interior Mirror

10.



Vehicles With: Autolamps

11. Refer to: [Rain Sensor](#) (501-16 Wipers and Washers, Removal and Installation).

Vehicles With: Lane Keeping Aid

12. Refer to: [Image Processing Module A \(IPMA\)](#) (419-07 Lane Keeping System, Removal and Installation).

Refer to: [Rain Sensor](#) (501-16 Wipers and Washers, Removal and Installation).

All vehicles

13. Refer to: [Cowl Panel Grille](#) (501-02 Front End Body Panels, Removal and Installation).  
Refer to: [A-Pillar Trim Panel](#) (501-05 Interior Trim and Ornamentation, Removal and Installation).

14.

