

YOUR CURRENT VEHICLE

**2018 Chrysler Pacifica**

## Removal & Installation

### REMOVAL AND INSTALLATION

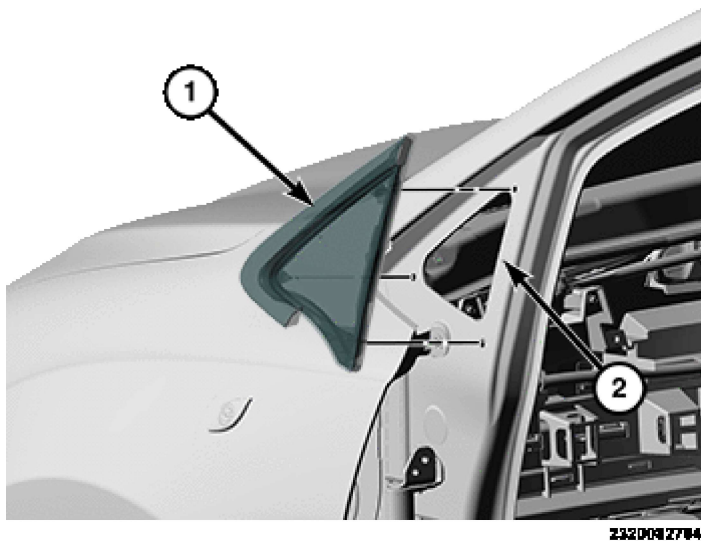
#### GLASS REMOVAL TOOLS



#### Common glass tools needed to remove Stationary Glass

- 1- Extractor® Express™ or equivalent, equipped with flat blade
- 2- Two handled wire type cut out tool
- 3- Cold knife equipped with a 25 mm (1 in.) blade
- 4 - Cold knife equipped with an 38 mm (1.5 in. ) blade
- 5 - Long knife

#### REMOVAL - FRONT QUARTER GLASS



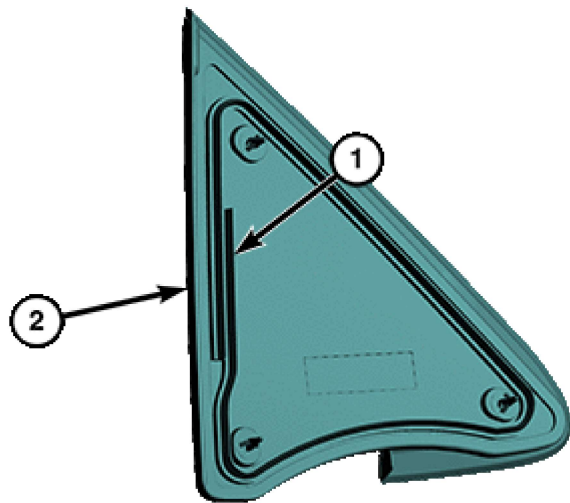
1. Before proceeding with the following repair procedure, review all warnings and cautions ([Refer to Body/Stationary Glass/Warning](#)).
2. Using an appropriate glass extraction tool, cut and separate the urethane adhesive and the alignment pins that secures the quarter glass (1) to window fence (2).

#### CAUTION

Be careful not to damage painted surfaces when removing moldings or cutting urethane around the fixed glass/windshield.

3. Carefully remove the quarter window glass (1) from the opening.

#### INSTALLATION - FRONT QUARTER GLASS



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**WARNING**

Do not operate the vehicle within 24 hours of quarter glass installation. It takes at least 24 hours for urethane adhesive to cure. If it is not cured, the quarter glass may not perform properly if the vehicle is in an accident.

**CAUTION**

To help prevent water leaks, partially roll down the left and right door glass before installing the quarter glass. This avoids pressurizing the passenger compartment if a door is slammed before the urethane is cured.

**CAUTION**

Protect all painted and trimmed surfaces from coming in contact with urethane or primers.

**NOTE**

To prevent corrosion, do not damage paint on the quarter glass fence when removing original urethane.

**NOTE**

The quarter glass fence should be cleaned of most of its old urethane adhesive. A small amount of old urethane, approximately 1 mm (.04 in) in height should remain on the fence. Do not completely remove all

old urethane from the fence, the paint finish and bonding strength will be adversely affected.

1. Using a razor knife, level the original bead of urethane on the fence to a thickness of approximately 1 mm (0.04 in).
2. If the quarter glass (2) is being reused, remove as much of the original urethane as possible from the glass surface using a razor knife.

### WARNING

Do not use solvent based glass cleaners to clean the quarter glass before applying glass prep and primer or poor glass adhesion may result.

3. Clean the inside of the quarter glass (2) with an ammonia based glass cleaner and a lint-free cloth.
4. Apply glass prep adhesion promoter 25 mm (1 in) wide around the perimeter of the glass and 5 mm (0.2 in) from the edge of the glass and wipe dry with a clean lint-free cloth until no streaks are visible.
5. Apply glass primer 25 mm (1 in) wide around the perimeter of the glass and 5 mm (0.2 in) from the edge of the glass. Allow at least three minutes drying time.
6. Using a flashlight, verify that the primer is completely and evenly installed along the perimeter of the quarter glass.
7. Re-prime any area that is not fully and evenly primed.
8. Clean the quarter glass fence with an ammonia based glass cleaner and a lint-free cloth.
9. Apply pinch weld primer 15 mm (0.75 in) wide around the quarter glass fence. Allow at least three minutes drying time.
10. Using a flashlight, verify that the primer is completely and evenly installed along the quarter glass fence.
11. Re-prime any area that is not fully and evenly primed.

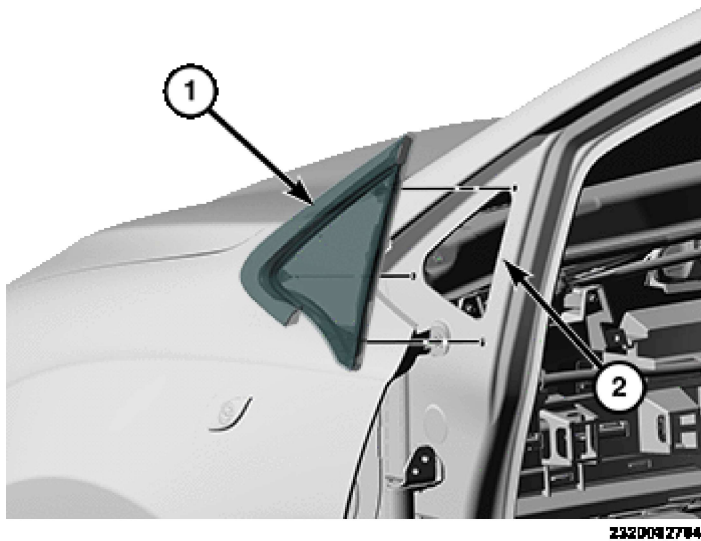
### CAUTION

Always apply the bead of adhesive to the quarter glass. Always install the quarter glass within 5 minutes after applying the adhesive.

### NOTE

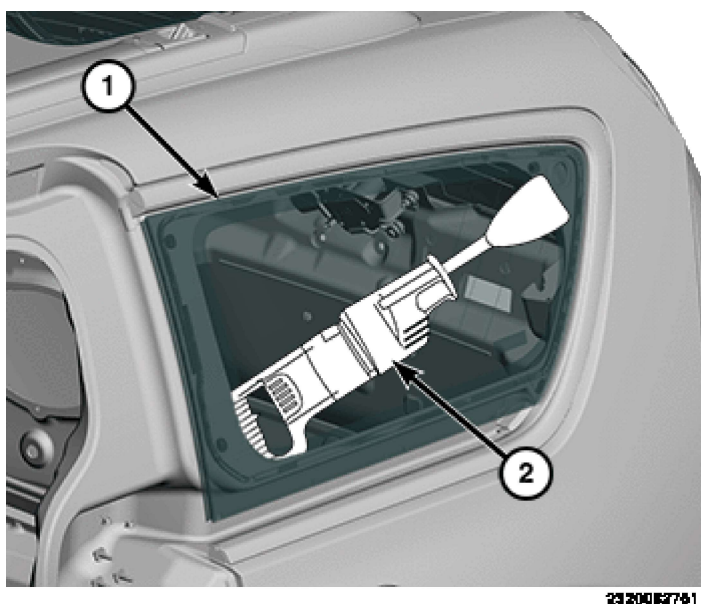
If the original urethane adhesive has been exposed for more than 12 hours, the entire adhesive area will need to be re-primed prior to installing new adhesive.

12. Apply approximately a 10 mm (0.4 in) wide bead of adhesive with a triangular nozzle approximately 6 mm (0.230 in) from the edge of the glass starting at the bottom center of the quarter glass.
13. Run the end of the adhesive bead (1) on the quarter glass (2) parallel to the start of the bead and smooth the ends flush.

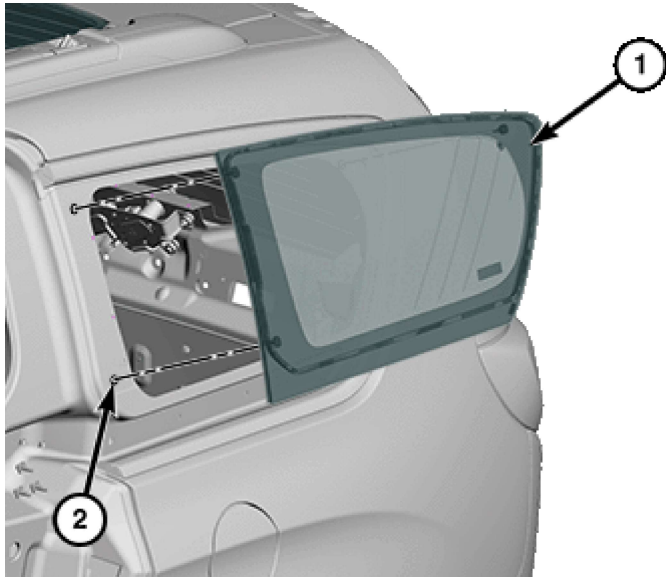


14. Place the quarter glass (1) into the window opening and insert mounting studs through the holes (2) in the window fence.

#### REMOVAL - REAR QUARTER GLASS



1. Before proceeding with the following repair procedure, review all warnings and cautions ([Refer to Body/Stationary Glass/Warning](#)).
2. Remove the quarter trim panel, ([Refer to Body/Interior/PANEL, Quarter Trim, Rear/Removal and Installation](#)).
3. Using a glass extraction tool (2) or equivalent, cut and separate the urethane adhesive and the alignment pins that secures the quarter glass (1) to window fence.



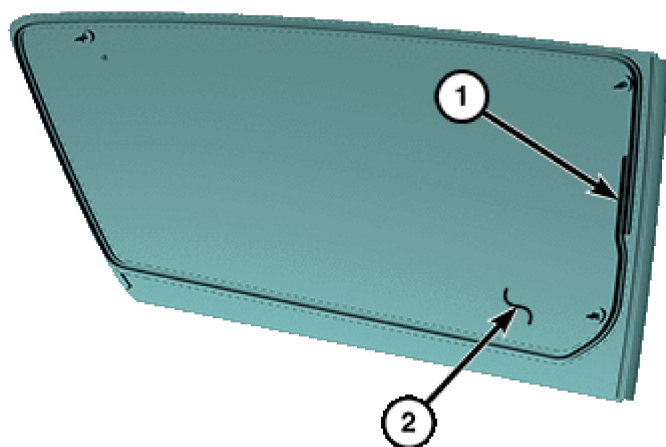
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**CAUTION**

Be careful not to damage painted surfaces when removing moldings or cutting urethane around the fixed glass/windshield.

4. Carefully push the quarter window glass (1) from the opening.

**INSTALLATION - REAR QUARTER GLASS**

**232002549****WARNING**

Do not operate the vehicle within 24 hours of quarter glass installation. It takes at least 24 hours for urethane adhesive to cure. If it is not cured, the quarter glass may not perform properly if the vehicle is in an accident.

**CAUTION**

To help prevent water leaks, partially roll down the left and right door glass before installing the quarter glass. This avoids pressurizing the passenger compartment if a door is slammed before the urethane is cured.

**CAUTION**

Protect all painted and trimmed surfaces from coming in contact with urethane or primers.

**NOTE**

To prevent corrosion, do not damage paint on the quarter glass fence when removing original urethane.

**NOTE**

The quarter glass fence should be cleaned of most of its old urethane adhesive. A small amount of old urethane, approximately 1 mm (.04 in) in height should remain on the fence. Do not completely remove all

old urethane from the fence, the paint finish and bonding strength will be adversely affected.

1. Using a razor knife, level the original bead of urethane on the fence to a thickness of approximately 1 mm (0.04 in).
2. If the quarter glass (2) is being reused, remove as much of the original urethane as possible from the glass surface using a razor knife.

### WARNING

Do not use solvent based glass cleaners to clean the quarter glass before applying glass prep and primer or poor glass adhesion may result.

3. Clean the inside of the quarter glass (2) with an ammonia based glass cleaner and a lint-free cloth.
4. Apply glass prep adhesion promoter 25 mm (1 in) wide around the perimeter of the glass and 5 mm (0.2 in) from the edge of the glass and wipe dry with a clean lint-free cloth until no streaks are visible.
5. Apply glass primer 25 mm (1 in) wide around the perimeter of the glass and 5 mm (0.2 in) from the edge of the glass. Allow at least three minutes drying time.
6. Using a flashlight, verify that the primer is completely and evenly installed along the perimeter of the quarter glass.
7. Re-prime any area that is not fully and evenly primed.
8. Clean the quarter glass fence with an ammonia based glass cleaner and a lint-free cloth.
9. Apply pinch weld primer 15 mm (0.75 in) wide around the quarter glass fence. Allow at least three minutes drying time.
10. Using a flashlight, verify that the primer is completely and evenly installed along the quarter glass fence.
11. Re-prime any area that is not fully and evenly primed.

### CAUTION

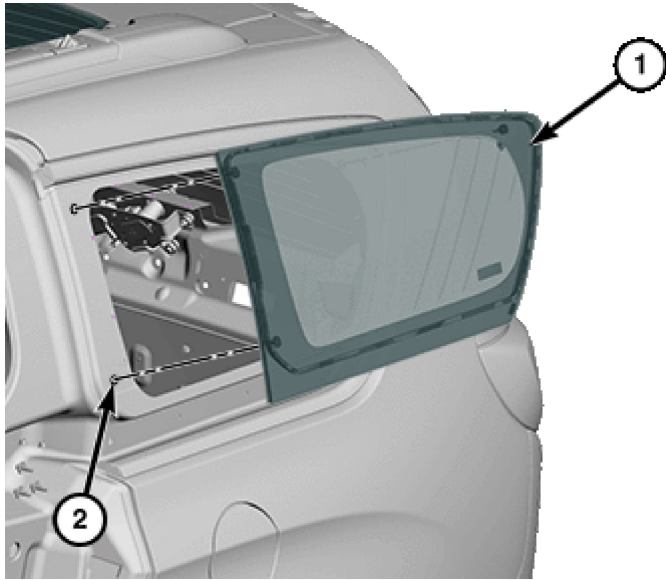
Always apply the bead of adhesive to the quarter glass. Always install the quarter glass within 5 minutes after applying the adhesive.

### NOTE



If the original urethane adhesive has been exposed for more than 12 hours, the entire adhesive area will need to be re-primed prior to installing new adhesive.

12. Apply approximately a 10 mm (0.4 in) wide bead of adhesive with a triangular nozzle approximately 6 mm (0.230 in) from the edge of the glass starting at the bottom center of the quarter glass.
13. Run the end of the adhesive bead (1) on the quarter glass (2) parallel to the start of the bead and smooth the ends flush.



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14. Place the quarter glass (1) into the window opening and insert mounting studs through the holes (2) in the window fence.
15. Install the quarter trim panel, ([Refer to Body/Interior/PANEL, Quarter Trim, Rear/Removal and Installation](#)).