

## Standard Operating Procedure:

### Replacing a Car Windshield

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#### Purpose

A guide for safely and effectively replacing a car windshield.

#### Scope

Standard replacement for most modern automobiles

#### Materials and Equipment

- Vehicle's Service Manual
- New windshield
- Windshield adhesive Ex. Urethane
- Primer
- Personal Protective Equipment Ex. Gloves, Safety glasses
- Utility knife
- Old Windshield removal tool
- Painter's tape
- Suction cups
- Alcohol-based cleaner
- Sealant gun

#### Steps

1. **Preparation**
  - **Safety First:** Wear protective gloves and safety glasses.
  - **Choose a Location:** To prevent dust and debris from contaminating the adhesive, perform the replacement in a controlled environment, ideally indoors.
2. **Remove the Old Windshield**
  - **Protect the Vehicle:** Use painter's tape to protect the vehicle's paint and interior.
  - **Remove Wipers and Trim:** Remove the windshield wipers and any exterior trim or molding around the windshield.
  - **Cut the Adhesive:** Use a windshield removal tool to cut through the adhesive around the windshield. Work slowly and carefully to avoid damaging the surrounding areas.
  - **Lift the Windshield:** Use suction cups to lift and remove the old windshield from the vehicle. Have a helper assist you if needed.
3. **Prepare the New Windshield**
  - **Clean the Edges:** Clean the edges of the new windshield with an alcohol-based cleaner to remove any dirt or residue.
  - **Apply Primer:** Apply primer to the edges of the windshield and the vehicle's frame where the adhesive will be applied. Allow it to dry according to the manufacturer's instructions.
4. **Apply Adhesive**
  - **Load the Sealant Gun:** Load the windshield adhesive (urethane) into the sealant gun.

- **Apply the Adhesive:** Apply a continuous, even bead of adhesive around the perimeter of the windshield frame on the vehicle. Ensure the bead is thick enough to provide a strong seal.
5. **Install the New Windshield**
    - **Position the Windshield:** With the help of suction cups and an assistant, carefully position the new windshield over the adhesive bead.
    - **Press Firmly:** Press the windshield firmly into place to ensure good contact with the adhesive.
    - **Secure the Windshield:** Use painter's tape to secure the windshield while the adhesive cures.
  6. **Reassemble the Vehicle**
    - **Reinstall Trim and Wipers:** Once the adhesive has cured according to the manufacturer's instructions, reinstall any trim or molding around the windshield and the windshield wipers.
  7. **Final Inspection and Clean-Up**
    - **Check for Gaps:** Inspect the windshield installation for any gaps or uneven areas in the adhesive.
    - **Clean the Windshield:** Clean the new windshield with a suitable glass cleaner.
    - **Test for Leaks:** After fully cured adhesive, spray water around the windshield's edges to check for leaks.
  8. **Allow Cure Time**
    - Follow the adhesive manufacturer's recommended cure time before driving the vehicle. This step is crucial to ensure the windshield is securely in place and the adhesive has been set correctly.

## Review and Approval

- **Reviewed by:** [John Smith]
- **Approved by:** [Jane Doe]
- **Date:** [Date]

## Version History

- **Version 1.0:** [Date]