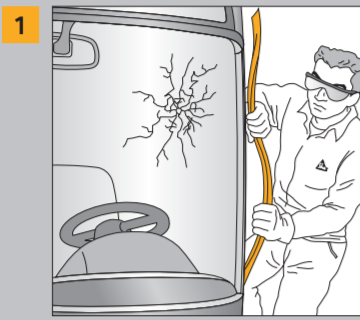
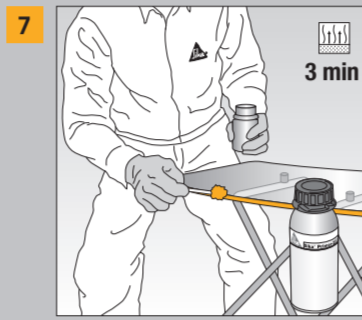


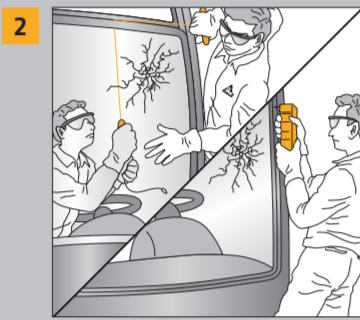
ALL BLACK PROCESS BUS AND COACH GLASS REPLACEMENT



■ Remove all decorative trims.



■ In case of laminated safety glass, apply a protecting layer of Sika® Primer-207 onto the edge of the glass and let it dry for a minimum of 3 minutes



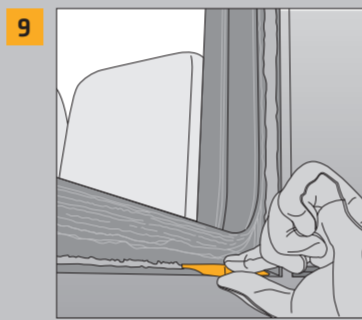
■ Cut out damaged windscreen using electrical knife, cutting wire, cold knife, etc.



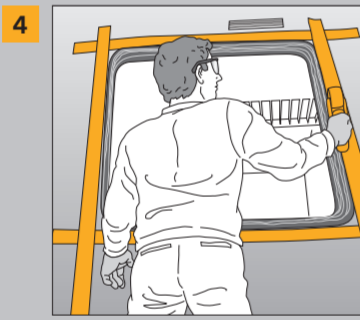
■ Using a brush apply a thin continuous coat of Sika® Primer-207 on the damaged area and let it dry for a minimum of 3 minutes.



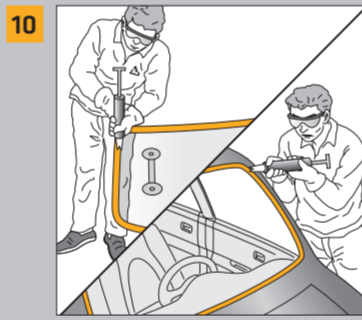
■ Trim back remaining adhesive bead to 1-2 mm.



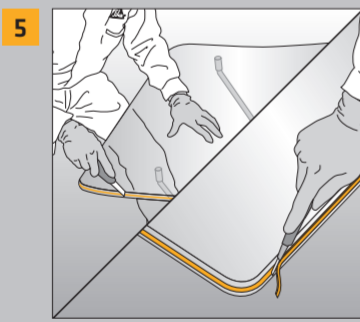
■ Position suitable spacers on the lower edge of the frame to support the glass weight during adhesive curing.



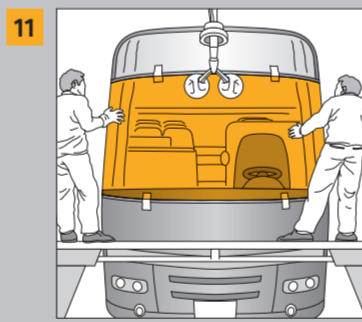
■ If the installation requires a backfilling it is advisable to mask the edge of the flange adjacent to the backfilling with suitable masking tape during this phase.



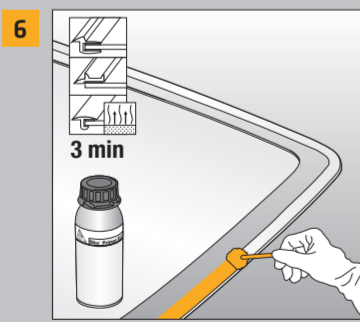
■ Using a triangular nozzle apply the adhesive on the glass or on the body.



■ In case of laminated safety glass cut back the protruding layer of PVB foil.



■ Place windscreen in position within open time of adhesive.



■ Prime bonding surface with Sika® Primer-207. Let it dry for a minimum of 3 minutes.



BONDING SURFACE	PRETREATMENT STEPS
Float Glass and Ceramic coated Glass*	●
Bare Metal Scratch < 5cm ²	●
Bare Metal 5 cm ² to 150cm ²	●●
Intact OEM Paint	●
Repair Paint (after complete curing of paint)	●
PVC/RIM Encapsulation	●
Fresh Cut Bead	Optional / ●
Pre-applied adhesive system	Optional / ●
Polycarbonate**	●
PMMA**	●

● = Sika® Primer-207

* Glass pad must be clean of dirt and dust. Potential contamination must be removed, eg. by using Sika® PowerClean Aid.

** Coating must be removed prior to use, only for temporary glazing, UV-protection required.

Our most current General Sales Conditions shall apply. Please consult the most current local Product Data Sheet prior to any use.
For more detailed information please consult Sika Technicians Handbook for Commercial Vehicles.

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