

Note:

For gluing the rear window, cements for cold and hot processing are permitted.

**Cold processing:**

Comply with instructions on gluing windows,
refer to 51 31 ...

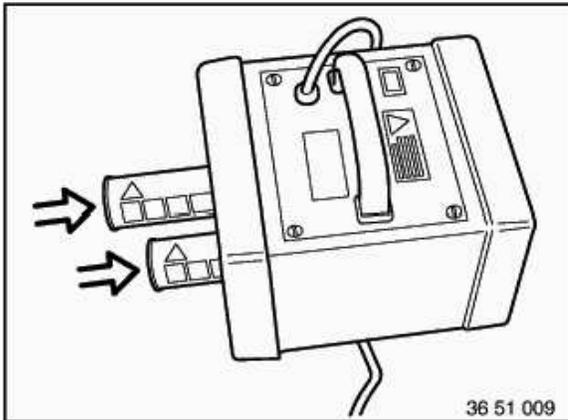
Warm processing:

Open aluminum membrane at rear end of cartridge.

Place cartridge in cartridge oven.

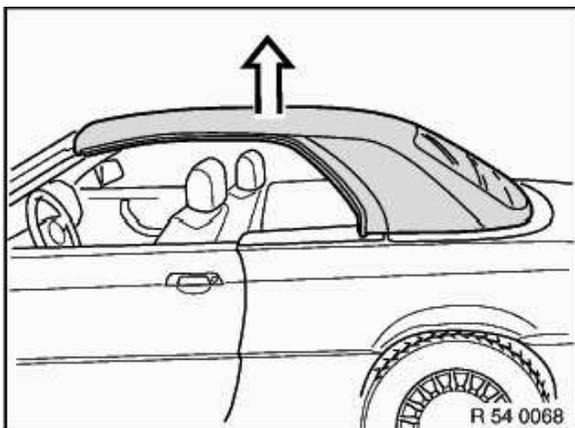
Heat glue cartridges to 80° C for one hour in oven (sourcing
reference: BMW Parts Service).

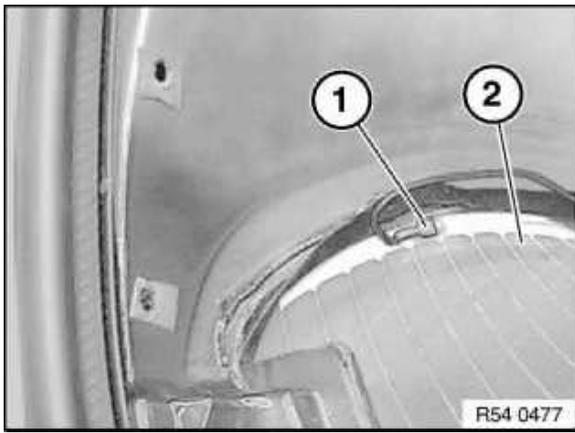
Comply with instructions on gluing windows,
refer to 51 31 ...



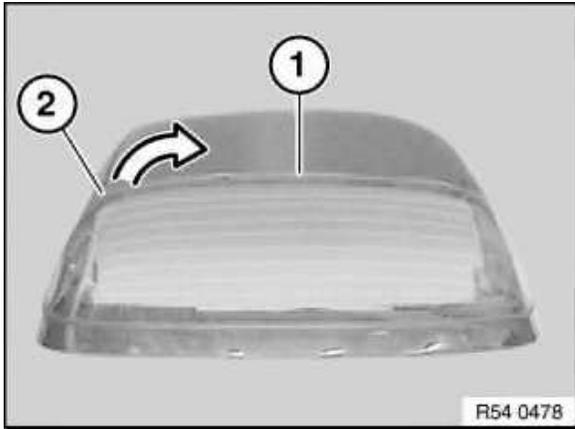
Remove hard top,
refer to 54 21 001.

Remove molded roof lining from hard top,
refer to 54 21 100.

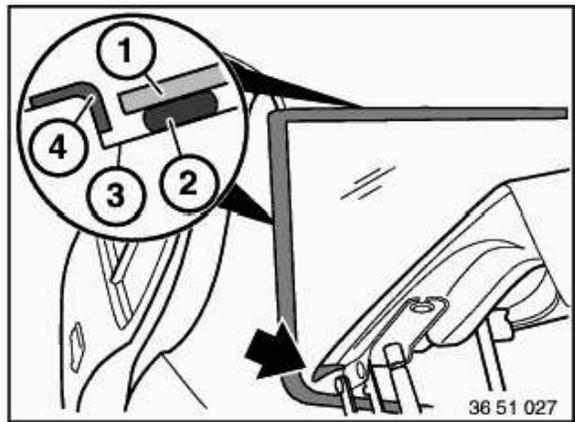




Disconnect plug (1) for rear window heater (2) on left and right.

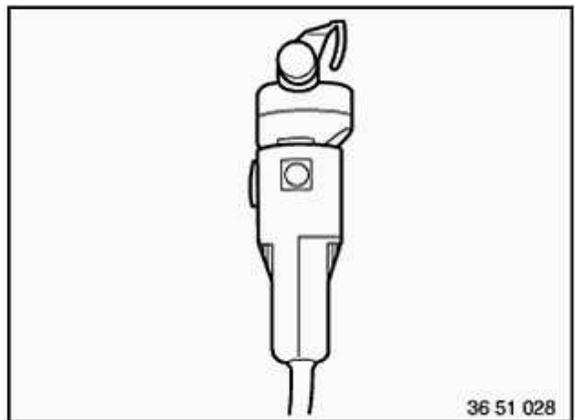


Pull out seal (1) from transition area of gutter (2).



Mask trunk lid corners and hard top with fabric adhesive tape (e.g. Tesa).

1. Rear window
2. Glue bead
3. Hard top flange
4. Fabric adhesive tape



Fit knife (24 mm blade length, sourcing reference: BMW Parts Service) to the tool.

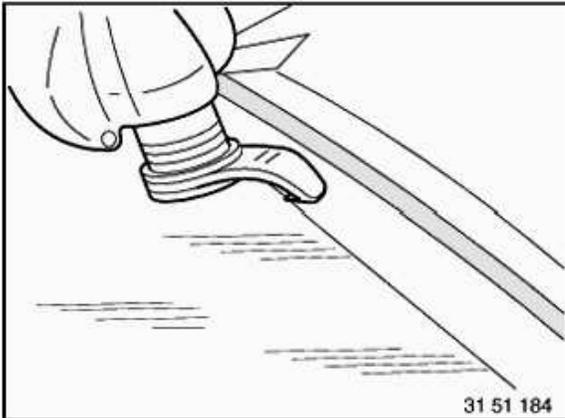
Note:

If necessary, sharpen knife with machine running.

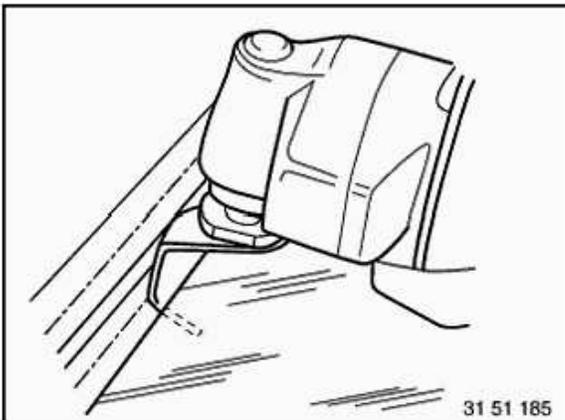


Caution!

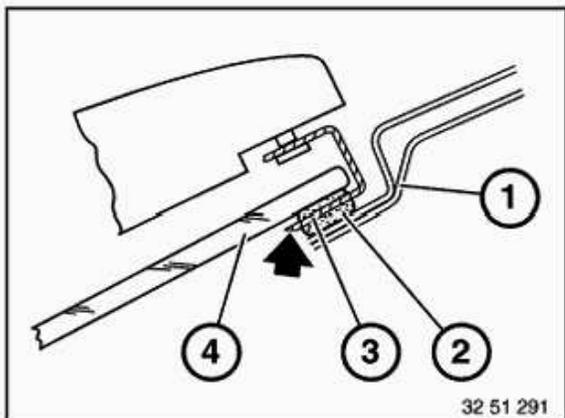
When reusing the rear window:
Do not damage wires for rear window heater.



Carefully insert knife between hard top and rear window.



Guide web of knife parallel to rear window.

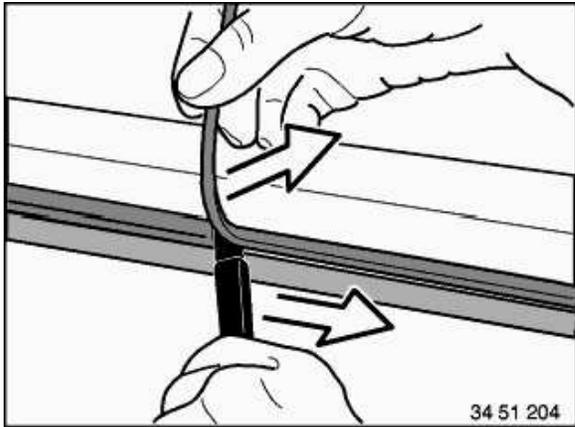


Cut through glue bead all around as close as possible to the rear window glass.

1. Hard top cutout
2. Glue bead
3. Knife
4. Rear window



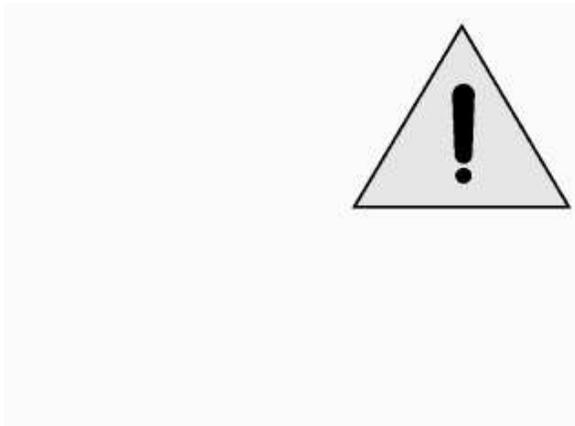
Lift out rear window with special tool 51 3 010.



Remove residual adhesive in hard top cutout to a thickness of approx. 0.5 mm.

To avoid damage to paintwork in hard top cutout, cut off residual adhesive with universal knife (razor sharp).

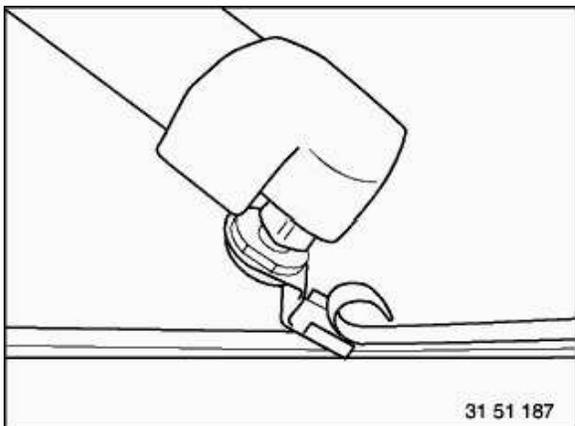
Pull off adhesive tapes all round.



Caution!

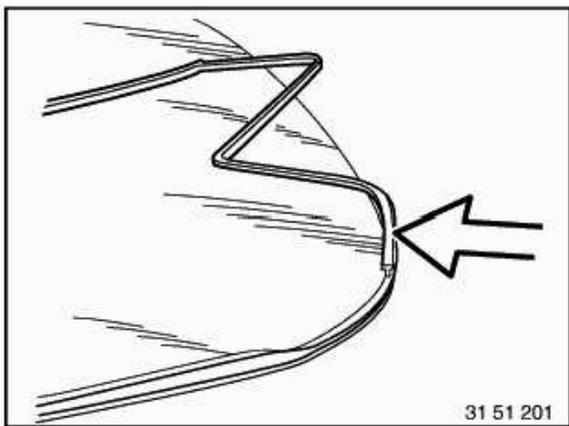
To ensure long-term corrosion protection, it is essential to touch up damage to paintwork (scratches and large-surface damage).

Refer to 51 31 ...

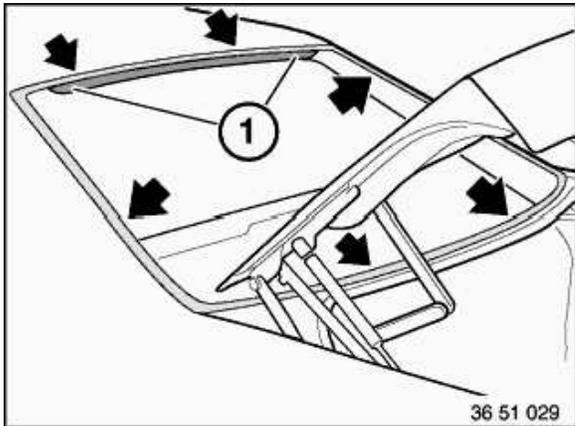


When reusing the rear window:

Scrape away glue residue on rear window to depth of 0.5 mm with scraper (sourcing reference: BMW Parts Service).



Mount and press seal on to rear window glass at bottom.
Mount and press seal on to rear window glass at top and sides.



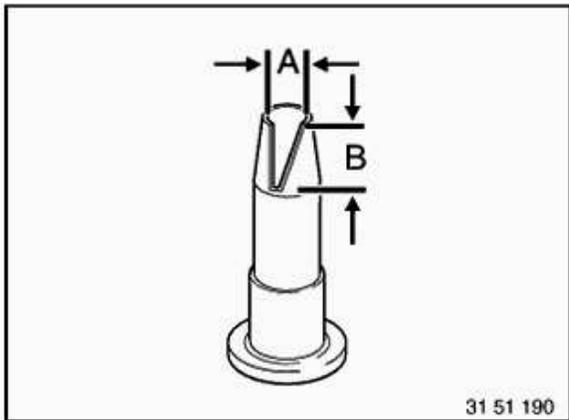
Caution!

The basic filler must have hardened!

Treat rear window and hard top in adhesive area with BMW-approved materials (repair kit, sourcing reference: BMW Parts Service), refer to 51 31 ...

Note:

Note specified ventilation time.



Cut nozzle to size.

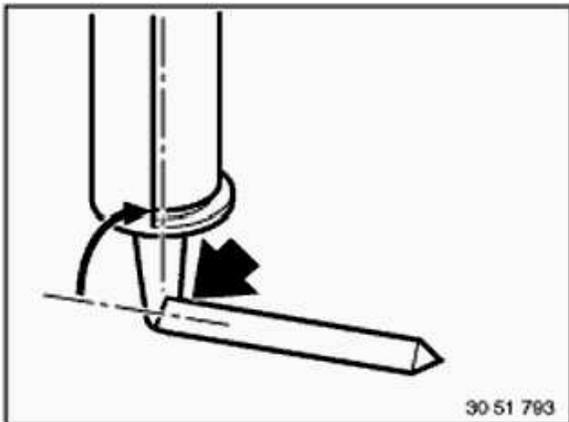
(A) = 9 mm

(B) = 6 mm

Note:

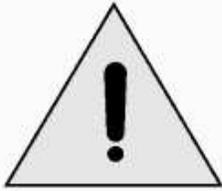
To apply a uniform glue bead, use cartridge pistol (operated by compressed air or electrically-powered, sourcing reference: BMW Parts Service).

Check expiry date of glue!



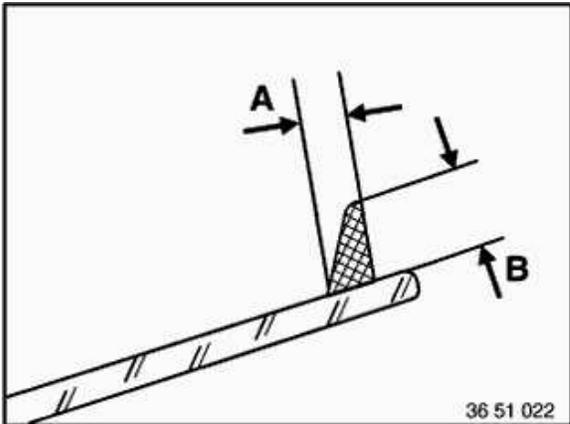
If necessary, apply a test bead before gluing.

Cartridge must be arranged vertically against rear window.



Caution!

There must be no adhesive on the connection contacts of the rear window heater.



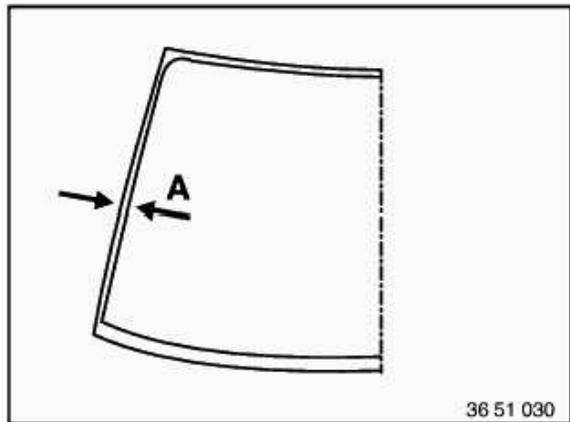
Shape of adhesive bead:

(A) = 9 mm

(B) = 6 mm

Caution!

Apply glue bead quickly and insert window. Skin formation time of glue, maximum 10 minutes.



Maintain uniform distance (A) between glue bead and seal.

Distance (A) = 3 mm



Install rear window carefully using special tool 51 3 010.

Seal must fit uniformly on the sides. Push up rear window glass until seal bears uniformly on the roof flange.

Align rear window to roof flange and evenly at sides. Press-fit rear window and secure in this position with fabric adhesive tape (e.g. Tesa).

**Caution!**

Before hardening, remove contamination by residual adhesive with Sika remover 208 (sourcing reference: BMW Parts Service). Do not press out rear window glass again for this purpose. Hardened glue can only be removed by machine.



Assemble car.

After the hardening time, remove adhesive tapes.

Note:

Leaks can be found by spraying water on the sealing lips or with an ultrasonic leak detector (refer to BMW Parts Service) and then eliminated by using a suitable nozzle.