

ACCESSORIES & EQUIPMENT**Glass, Window Regulators (Sedan)****GLASS, WINDOW REGULATORS****DESCRIPTION AND OPERATION****FLUSH-BONDED WINDOWS****MATERIALS**

• 2C Window adhesive Kit DA 004 600 A2 ⁽¹⁾
• 1K Window adhesive DH 009 100 03 ⁽²⁾
• Glass/paint primer D 009 200 02
• Cleaning solution D 009 401 04
• Applicator D 009 500 25
• Adhesive remover D 002 000 10
• Cutting wire 6452/2 or Cutting thread 357 853 999
(1) Note the minimum curing time (--> curing time), refer to MINIMUM CURING TIMES .
(2) Small cartridge (110 ml) for sealing and/or when a 400 ml double cartridge is not sufficient.

1. Double cartridge pistol VAS 5237 must be used to process this material.

1. Heat according to manufacturer's instructions using cartridge heater V.A.G 1939 A.

SERVICING WINDOWS USING WINDOW REPAIR Kit AND TALON REPAIR RESIN**Special tools and workshop equipment required**

- Window Repair Kit VAS 1993 or VAS 6092

NOTE:

- Windshields with stone chips can be repaired with window repair Kit VAS 6092 and repair resin, Talon VAS 1993/2.
- These damaged areas must not exceed a certain dimension or lie within the driver's field of sight.
- For further details on use, refer to User's Manual enclosed with each Kit.

MINIMUM CURING TIMES

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WARNING:

- For safety reasons, use only electrically non-conductive 2K-adhesive when installing windshield and rear window using the materials listed below.
- The vehicle can only be used after the minimum curing time has elapsed.

Window type	Vehicle	Adhesive Sealing Material	Curing Time In Hours
Windshield	With airbag	2K Window Adhesive Kit -D 004 660 M2-	2
Rear window		2K Window Adhesive Kit -D 004 660 M2-	2
Side windows		1K window adhesive -DH 009 100 03-	3

Adhesive Sealant, Removing from Window

It is recommended to use adhesive remover D 002 000 10 as a cleaning solution. Follow the safety precautions when using it.

CAUTION: When cleaning from vehicle interior out, the window just installed must not be pressed outward.

Paint Surfaces

-- Clean the painted surface with a dry cloth. Remove any remaining dirt with adhesive remover D 002 000 10.

Plastic Trim

-- Allow the adhesive sealant to harden (approximately 1 hour) and then peel it off.

WINDOWS, RESEALING

-- Allow leaky area to dry, and clean it.

-- Apply adhesive sealing material to leaking area between window and sheet metal flange and spread.

-- Allow the adhesive to harden.

-- Perform water test.

-- Perform visual inspection of vehicle interior.

WINDSHIELD OVERVIEW

NOTE: On vehicles equipped with lane assist, the camera must be recalibrated if the windshield has been replaced. Refer to [For engine(s) CAEB, CALA, CCBA] Removal and Installation .

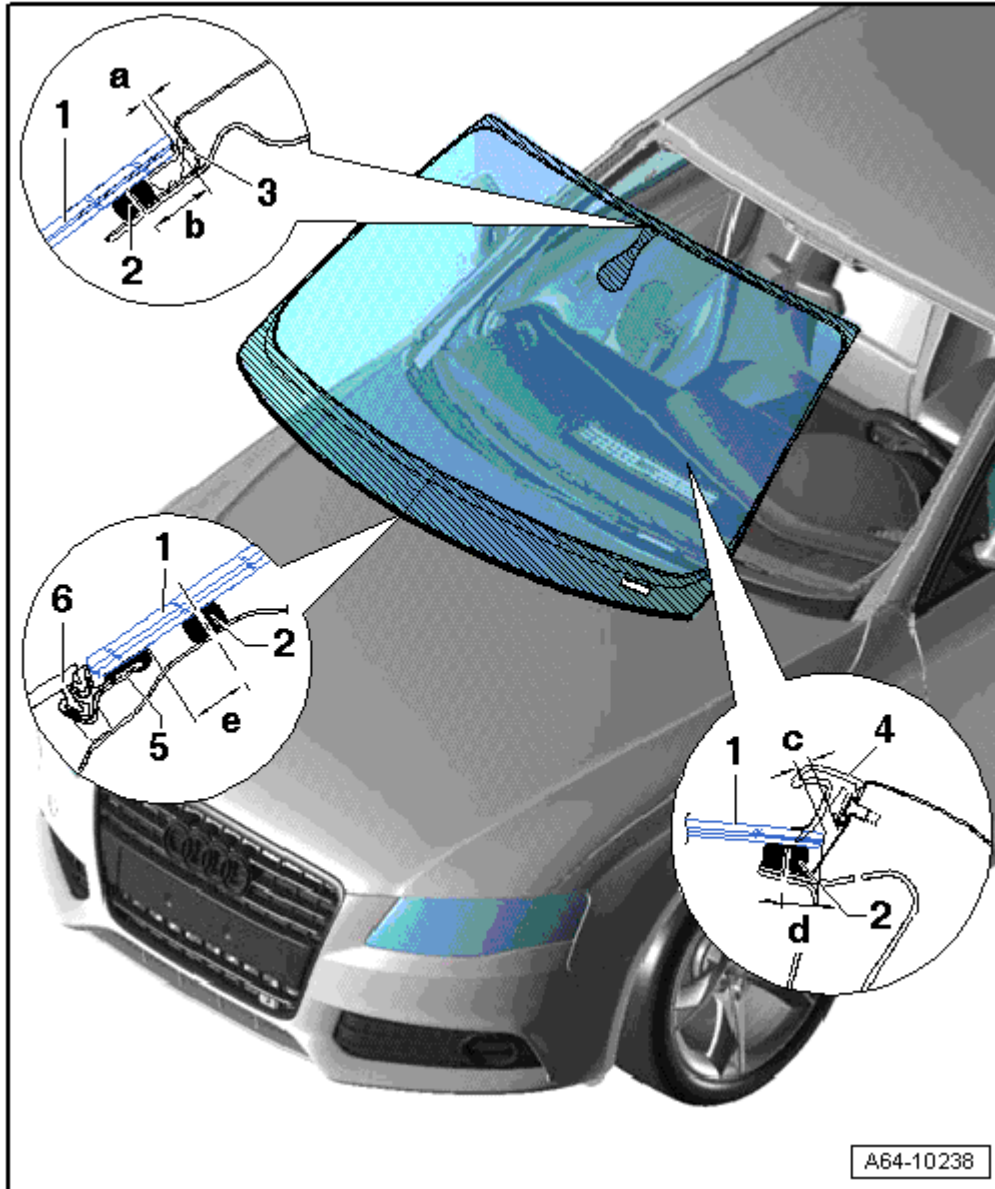


Fig. 1: Windshield Overview

Courtesy of AUDI OF AMERICA, LLC

1. Windshield
 - Distance to roof dimension -a- = 2 mm.
 - Align the side distance -c-.
2. Adhesive Sealing Material
 - Observe minimum curing time. Refer to MINIMUM CURING TIMES.

- Dimension -b- = 17 mm ± 2 mm
- Dimension -d- = 8 mm ± 2 mm
- Dimension -e- = 12 mm ± 2 mm

3. Gap Cover

- No replacement part
- When removing the window, the cutting wire must be pulled under the gap cover.

4. Drip Rail**5. Plenum Chamber Cover Molding**

- No replacement part
- With a new window, protective piping must first be removed before installing plenum chamber cover.

6. Plenum Chamber Cover

- Press into retaining strip only after window adhesive curing time is complete (3 hours).

Water Deflector, Removing

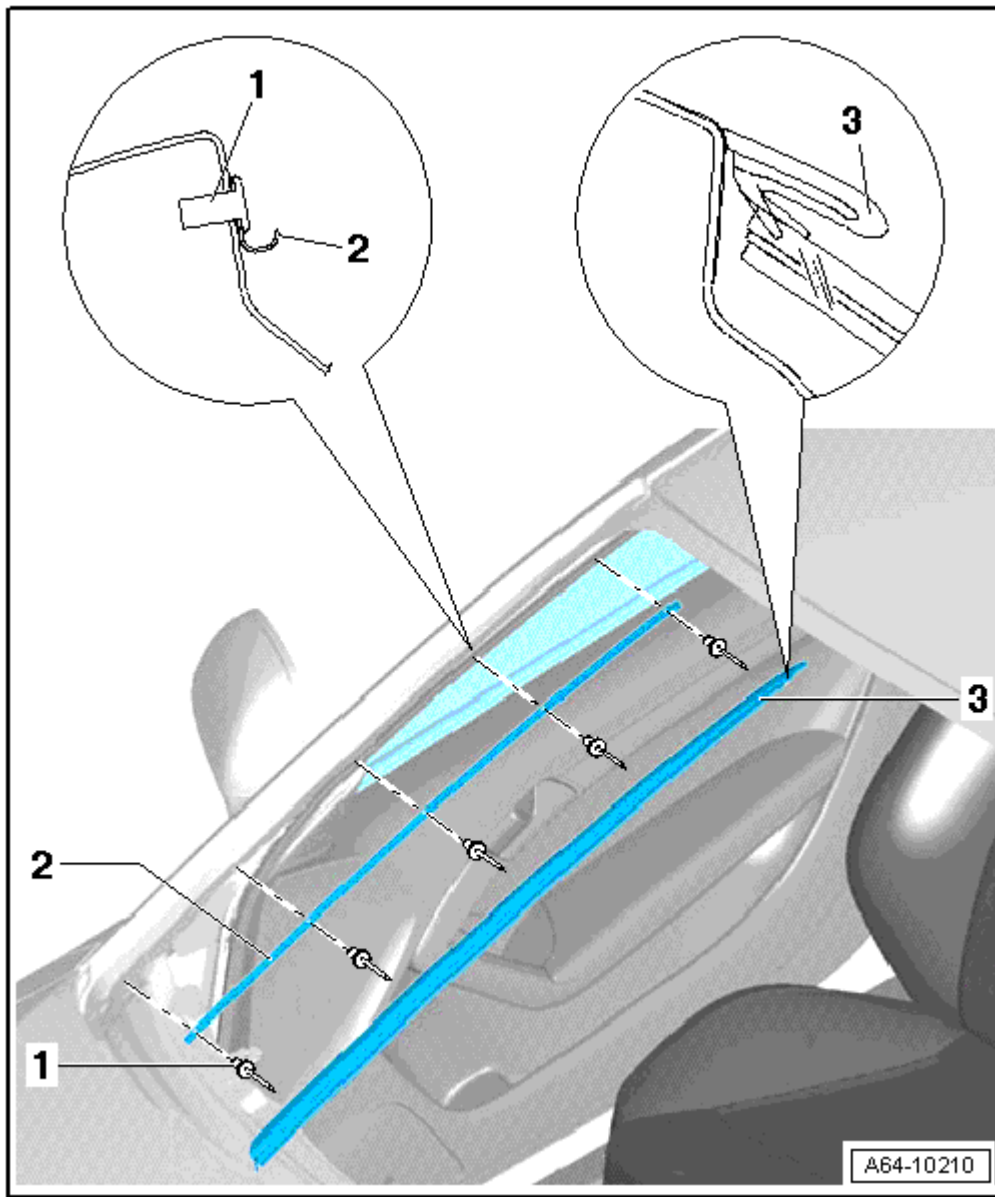


Fig. 2: Identifying Water Deflector Components

Courtesy of AUDI OF AMERICA, LLC

1. Pop Rivet
 - quantity: 5
 - Rivet the guide rails beginning at the top.
2. Guide Rail
 - To remove, drill out rivet heads -4- and drive out rivet shafts.
3. Drip Rail
 - Press into the guide rail as far as the stop, beginning at the top and working toward the bottom.
 - Check for flushness at the transition to the A-pillar.

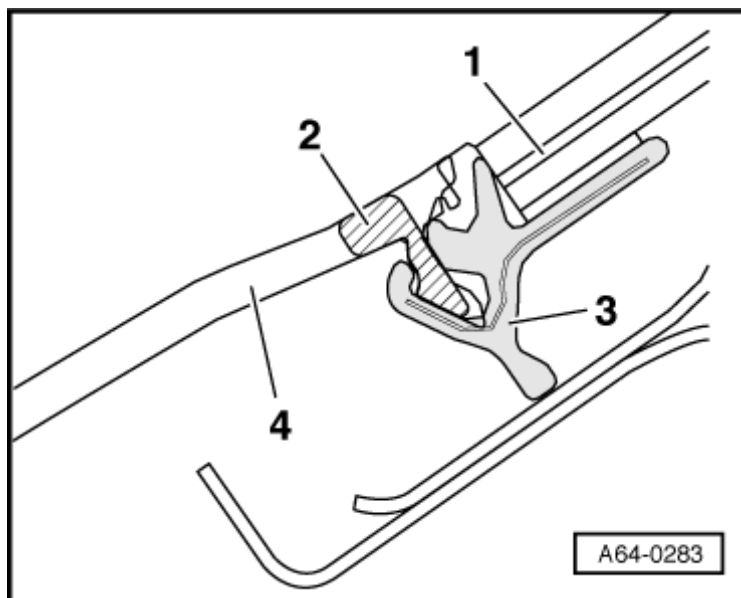


Fig. 3: Protective Tubing

Courtesy of AUDI OF AMERICA, LLC

-- With a new windshield -1-, protective piping -2- must be removed from molding -3- before installing plenum chamber cover -4-.

SIDE WINDOW OVERVIEW

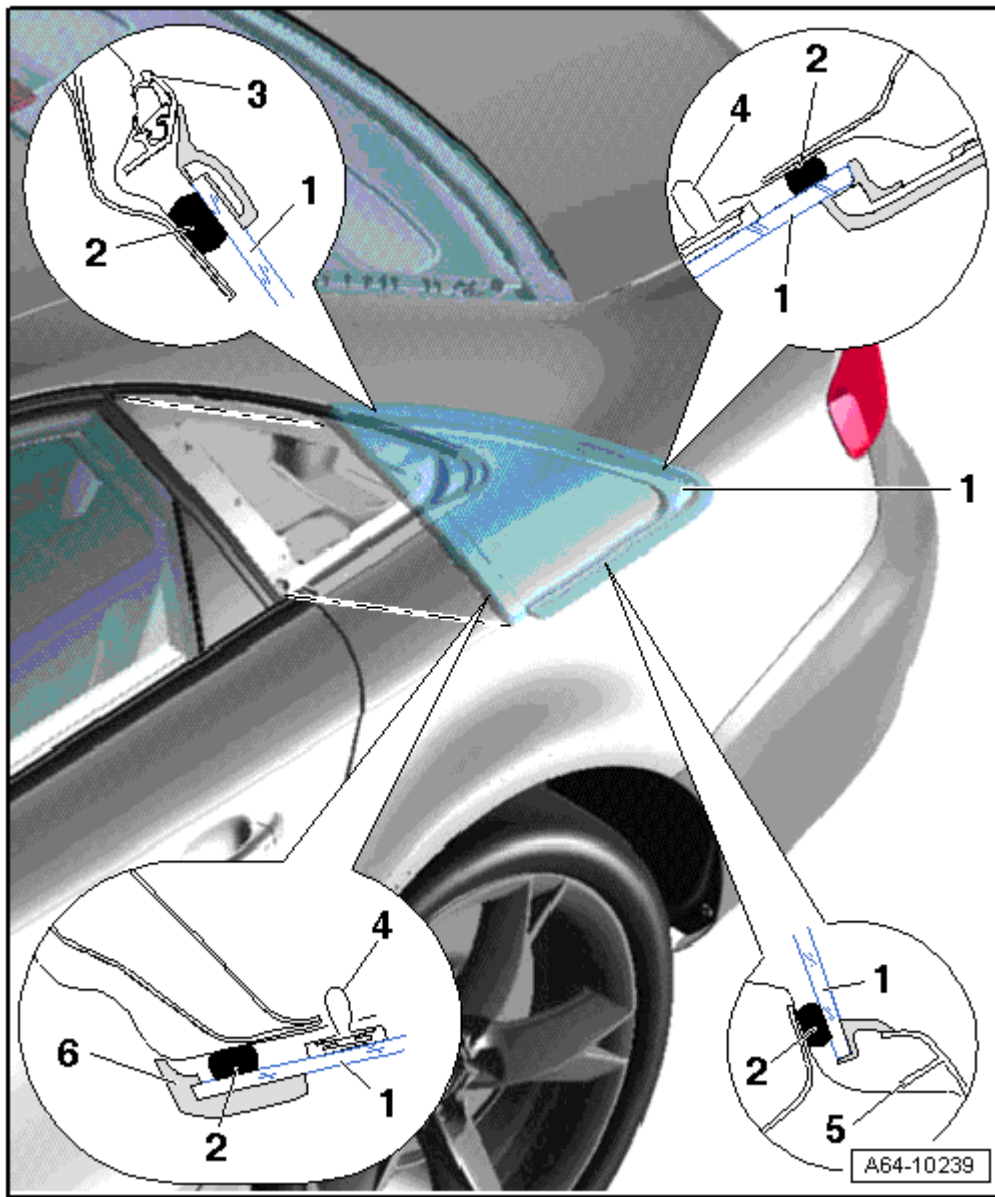


Fig. 4: Side Window Overview

Courtesy of AUDI OF AMERICA, LLC

1. Side Window

- Roof trim molding and side trim molding removed, refer to **ROOF TRIM STRIP OVERVIEW**.
- When installing a new window, first install securing pins on the C-pillar and D-pillar and then press the window into the cut-out.
- If a side window is going to be installed, then secure it to the C-pillar and D-pillar with adhesive tape.

2. Adhesive Sealing Material

-- Observe minimum curing time, refer to **FLUSH-BONDED WINDOWS => Minimum curing time (-> curing time)**.

3. Roof Trim Molding
 - The roof trim molding is clipped onto the body.
4. Securing Pin
 - No replacement part
 - Is cut through when removing window.
5. Decorative Trim Strip
 - Only vehicle with gloss package.
6. Molding
 - No replacement part.
 - Must not be damaged in field of vision.

REAR WINDOW OVERVIEW

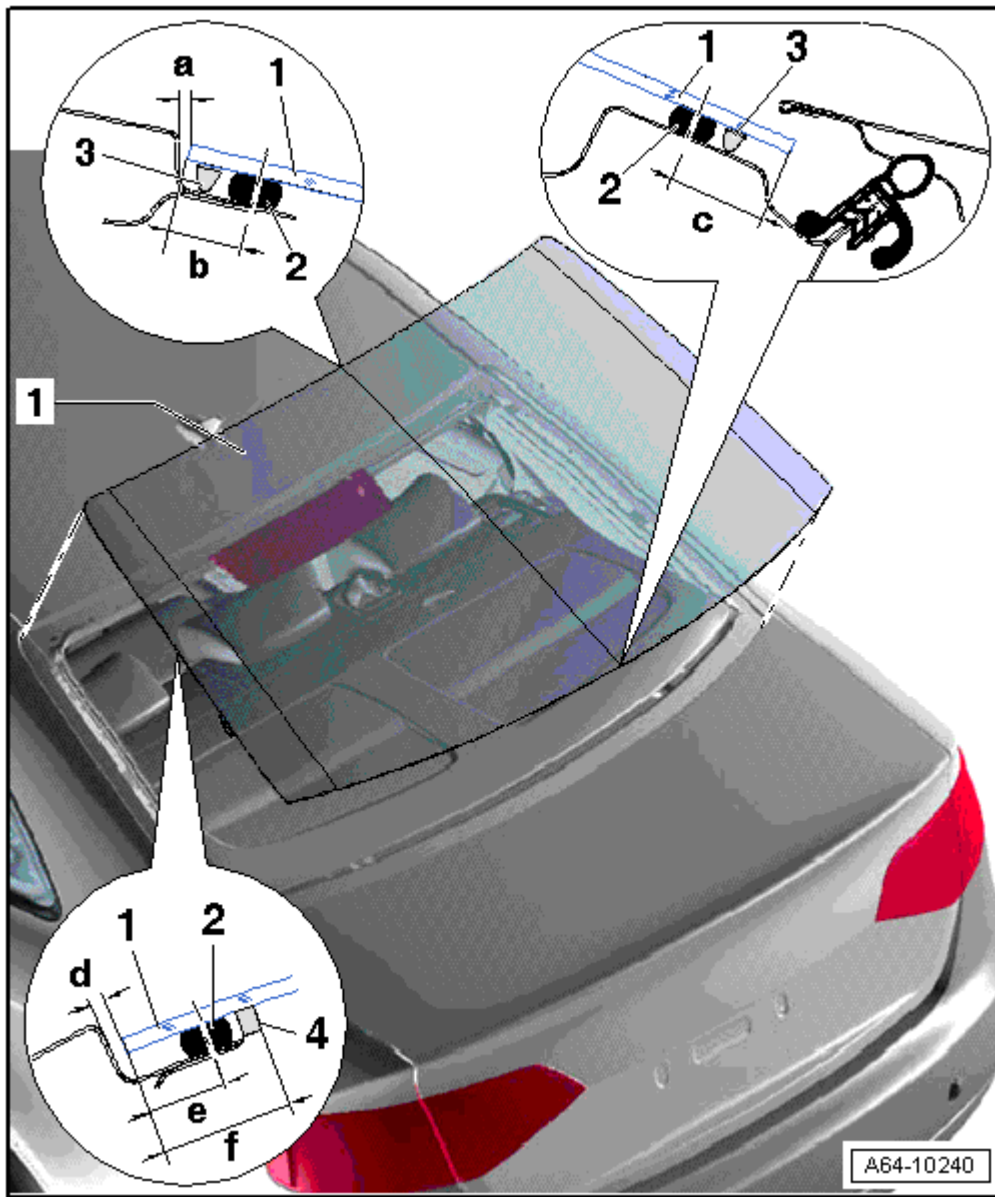


Fig. 5: Rear Window Overview

Courtesy of AUDI OF AMERICA, LLC

1. Rear Window

- Distance -a- to roof = 2 mm.
- Center the distance -d- to the D-pillar = 3 mm.
- Before removing, disconnect all electrical connectors and secure the terminals to the middle of the window on the inside using adhesive tape.

2. Adhesive Sealing Material

- Bead width = 8 mm ± 2 mm
- Bead height = 12 mm $+2$ mm
- Distances to the window edge:

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- Dimension -b- = 16.5 mm
- Dimension -c- = 21.5 mm.
- Dimension -e- = 16.5 mm.

3. Spacer

- Make 3 markings each on the top and bottom edges of the window.

4. Adhesive Stop Profile

- Distance to the edge of the window -dimension f- = 24 mm
- Bond the adhesive stop profile directly by the window defroster distributing wire.
- Window adhesive must not come into contact with the rear window defroster distributing wire.

BOLTED WINDOWS

FRONT DOOR WINDOW OVERVIEW

NOTE: **Window regulator must be installed before installing window.**



Fig. 6: Front Door Window Overview
Courtesy of AUDI OF AMERICA, LLC

1. Door Window
 - Removal, refer to **FRONT DOOR WINDOW**.
2. Window Regulator
 - Remains installed when removing the door window.
3. Door
4. Nuts
 - 6 Nm
5. Speaker
 - Removed, refer to **[For engine(s) CAEB, CALA, CCBA] Removal and Installation**.

1. Door Window
 - Removal, refer to **FRONT DOOR WINDOW**.
2. Window Regulator
 - Remains installed when removing the door window.
3. Door
4. Nuts
 - 6 Nm
5. Speaker
 - Removed, refer to **[For engine(s) CAEB, CALA, CCBA] Removal and Installation**.

6. Bolt
 - 1.5 Nm
7. Bolt
 - 6 Nm
8. Cover
 - Unclip

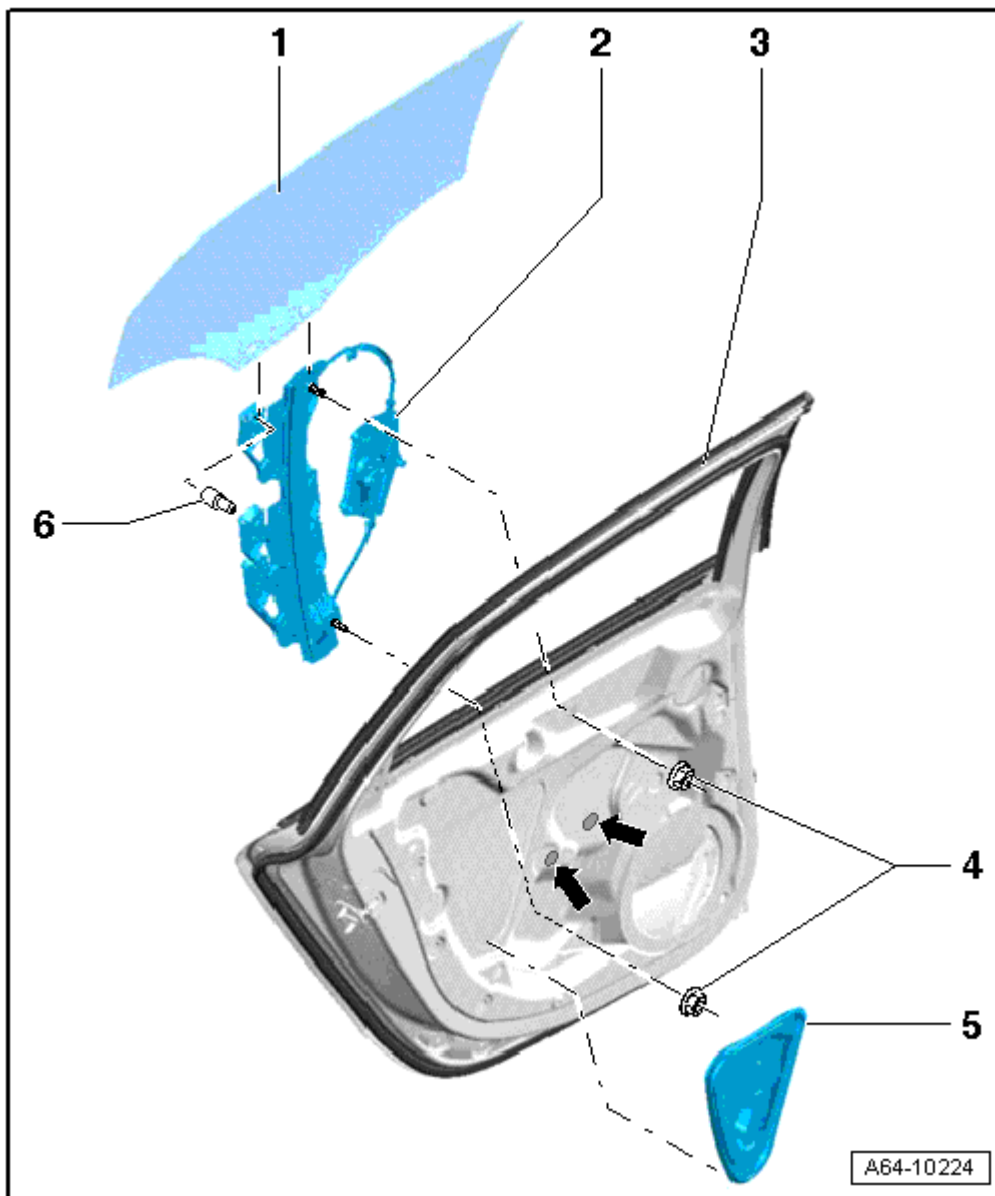
REAR DOOR WINDOW OVERVIEW

Fig. 7: Rear Door Window Overview
Courtesy of AUDI OF AMERICA, LLC

1. Door Window

- To remove, lower the door window into the door until the screws in the inner door panel are visible through the holes -arrow-.
- Push the bolt clamping pins.
- Push the bolts through, tilt the window inside the door and remove it.

NOTE: Remove the clamping pins and bolts from the door

2. Window Regulator

- The window regulator remains installed inside the door.

3. Door**4. Nut**

- 6 Nm

5. Cover

- Installed

6. Bolts

- Two-part with clamping pin.
- The bolts can be re-used.

REMOVAL AND INSTALLATION**FLUSH-BONDED WINDOWS****FLUSH-BONDED WINDOWS****Special tools and workshop equipment required**

- Cutting Tool Kit Vas 6452
- Wire Spool Vas 6452/1
- Cutting Tool Kit Wire Vas 6452/2
- Cutting Tools For Glass V.A.G 1351
- Pull Handle V.A.G 1351/1
- Suction Lifter V.A.G 1344
- Electric Cutter V.A.G 1561A
- Angled Blade V.A.G 1561/10
- Universal Cutting Blade V.A.G 1561/11
- Scraper (15+25 Mm) V.A.G 1561/7+8
- Double Cartridge Gun Vas 5237
- Cartridge Gun V.A.G 1628
- Cartridge Heater V.A.G 1939A

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Minimum curing time

WARNING:

- For safety reasons, use only electrically non-conductive 2K-adhesive when installing windshield and rear window using the materials listed below.
- The vehicle can only be used after the minimum curing time has elapsed.

Window type	Vehicle	Adhesive sealing material	Curing time in hours
Windshield	with/without airbag	2K Window Adhesive Kit DA 004 600 A2	3
Rear window		2K Window Adhesive Kit DA 004 600 A2	3
Side Windows		1K window adhesiveDH 009 100 03	3

Adhesive Sealant, Removing from Window

Using adhesive remover D 002 000 10 is recommended. Always follow the safety precautions when using adhesive remover.

CAUTION: When cleaning from vehicle interior out, the window just installed must not be pressed outward.

Paint Surfaces

-- Clean the painted surface with a dry cloth. Clean off any dirt with adhesive remover D 002 000 10.

Plastic Trim

-- Allow the adhesive sealant to harden (approximately 1 hour) and then peel it off.

RAIN/LIGHT RECOGNITION SENSOR

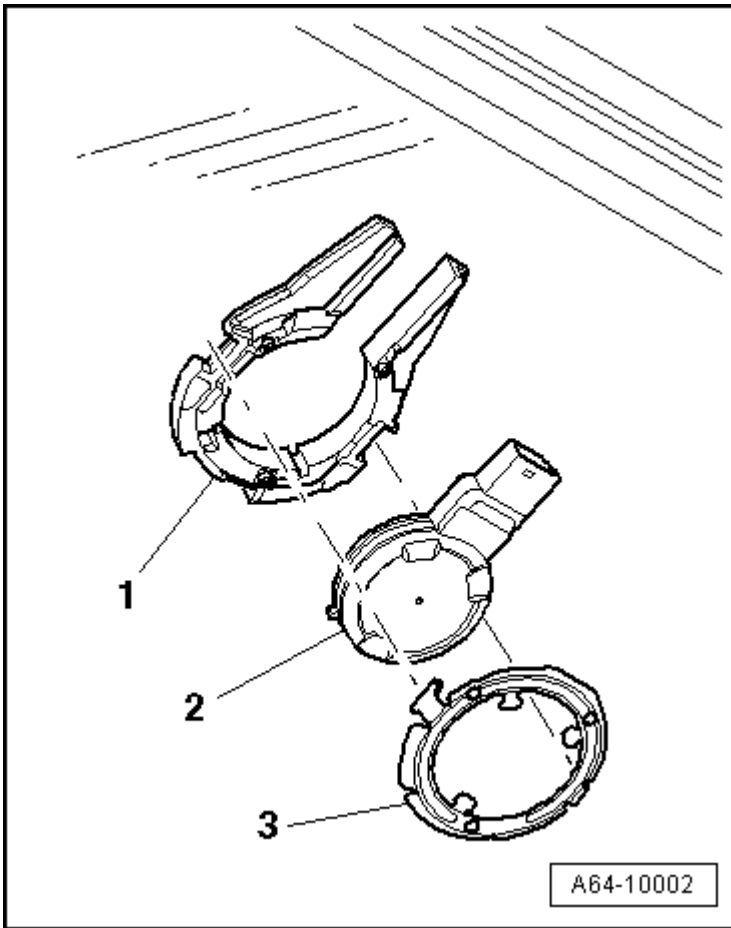


Fig. 8: Identifying Rain Sensor Components

Courtesy of AUDI OF AMERICA, LLC

NOTE: When removing the Rain/Light Recognition Sensor -G397-, a foil will be loosen; replace the foil before re-installing.

-- Remove the exterior mirror. Refer to **Removal and Installation**

- Retaining plate -1-
- Rain/light recognition sensor -G397- -2-
- Retaining clip -3-

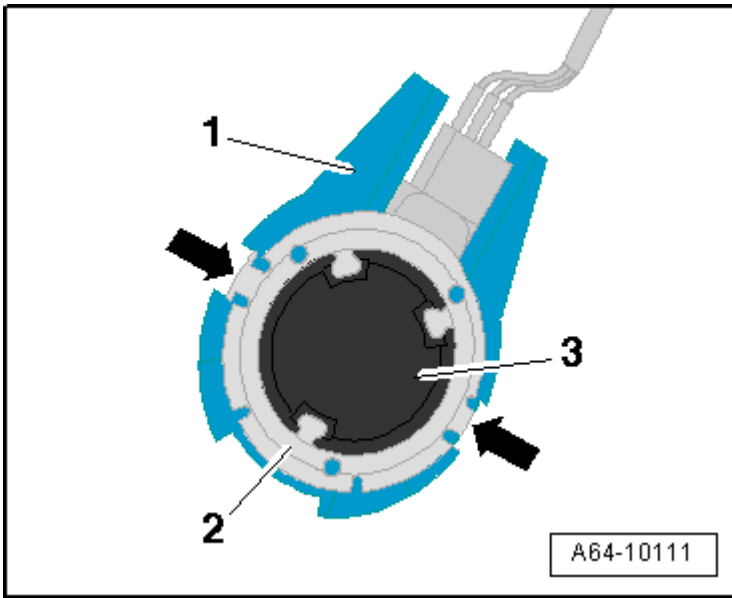


Fig. 9: Retaining clip, releasing

Courtesy of AUDI OF AMERICA, LLC

- Disconnect electrical connector.
- Press clip -2- outward at -arrows-, for example, with a small screwdriver.
- Remove clips -2- from mirror base -1-.
- Remove the rain/light recognition sensor -G397- -3- from the mirror base.
- A sensor foil remains affixed to the windshield.
- If the same windshield is being re-installed, remove the sensor foil from the glass including any remaining adhesive.
- Clean the surface with cleaning solution D 009 401 04.

Install the rain/light recognition sensor -G397-

CAUTION: If the same rain/light recognition sensor -G397- is being re-installed, then the sensor foil must be replaced.

- If necessary, also remove the sensor foil from the rain/light recognition foil -G397-.
- Carefully pull the sensor foil -2- from the rain/light recognition sensor -G397- -1-.

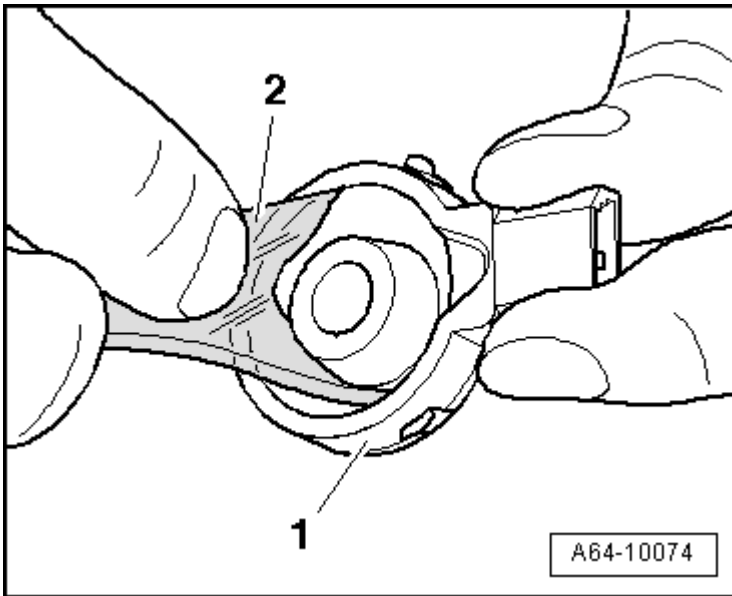


Fig. 10: Identifying Rest Of Sensor Foil From Rain Sensor
Courtesy of AUDI OF AMERICA, LLC

-- Clean the surface with cleaning solution D 009 401 04.

CAUTION: Sensor surface must be completely free of foil remnants.

-- Peel silicon paper -3- from sensor foil -2-.

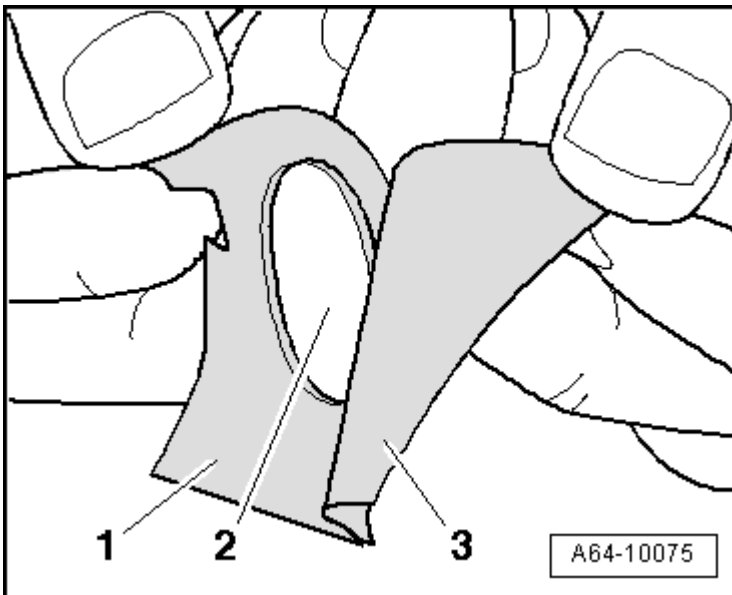


Fig. 11: Identifying Silicone Paper From Sensor Foil
Courtesy of AUDI OF AMERICA, LLC

-- The transparent protective film -1- remains on the sensor foil as an assembly aid.

-- Place the sensor foil -1- on the rain/light recognition sensor -G397- -2- using a transparent protective foil.

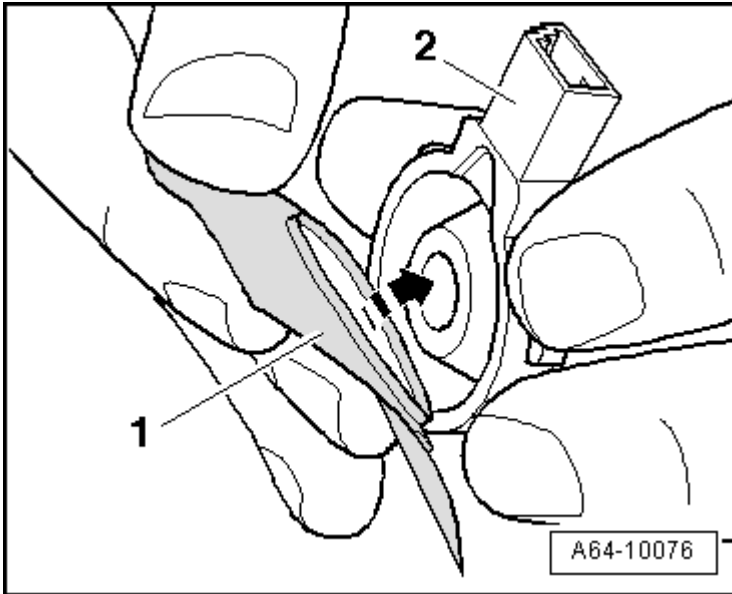


Fig. 12: Placing Sensor Foil On Rain Sensor With Help Of Transparent Protective Foil
Courtesy of AUDI OF AMERICA, LLC

-- Push the sensor foil through the protective foil -1- so that there are no air bubbles onto the rain/light recognition sensor -G397- -2- as illustrated.

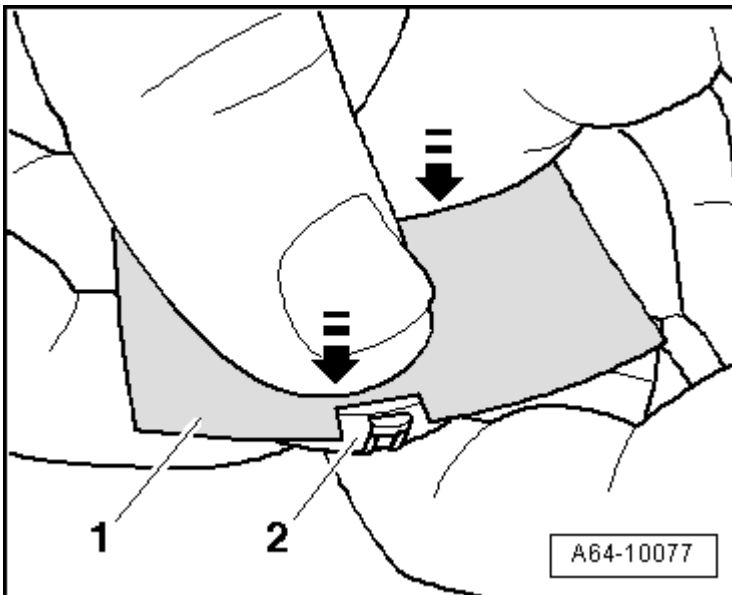


Fig. 13: Pressing Sensor Foil Onto Rain Sensor Without Bubbles
Courtesy of AUDI OF AMERICA, LLC

-- Now remove transparent protective foil -1- from sensor foil -2-.

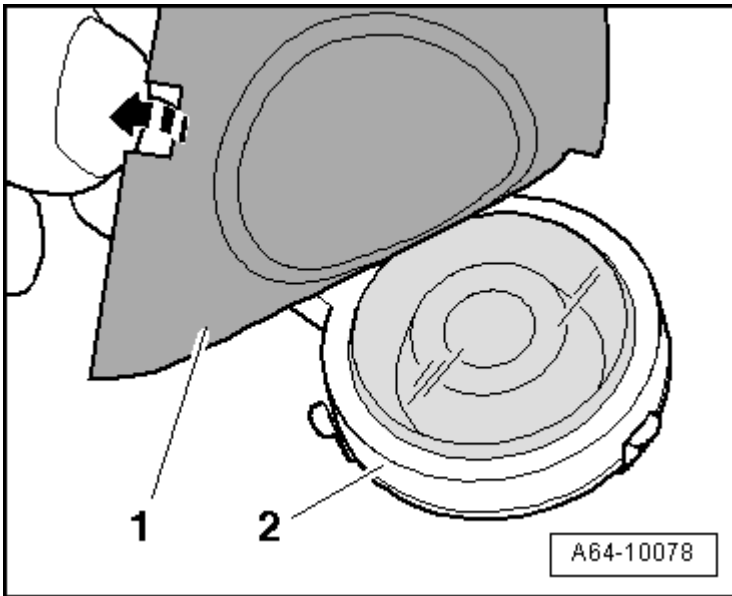


Fig. 14: Cleaning Sensor Contact Surface On Windshield With Cleaning solution D 009 401 04
Courtesy of AUDI OF AMERICA, LLC

-- Spray the sensor foil -1- completely with cleaning solution D 009 401 04 and install the rain/light recognition sensor -G397- into the mirror base.

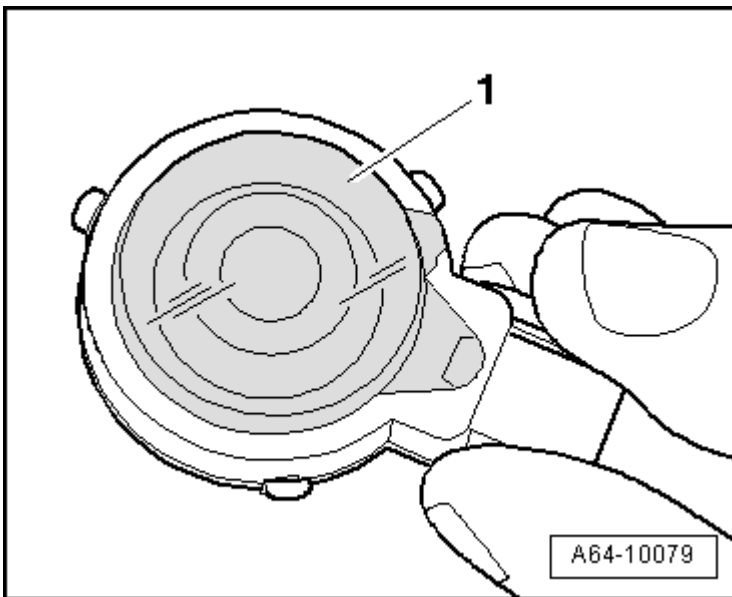


Fig. 15: Spraying Entire Surface Of Sensor Foil With Cleaning solution D 009 401 04 And Inserting Sensor In Mirror Base

Courtesy of AUDI OF AMERICA, LLC

CAUTION: The rain/light recognition sensor -G397- must be free of inclusions and bubbles on the windshield to function properly.

-- Press sensor clips on mirror base.

Replace the rain/light recognition sensor -G397-

NOTE: To remove sensor, proceed as described above.

-- If necessary, completely remove any foil from the old rain/light recognition sensor -G397- from the windshield.

-- Clean the contact surface on the windshield using cleaning solution D 009 401 04.

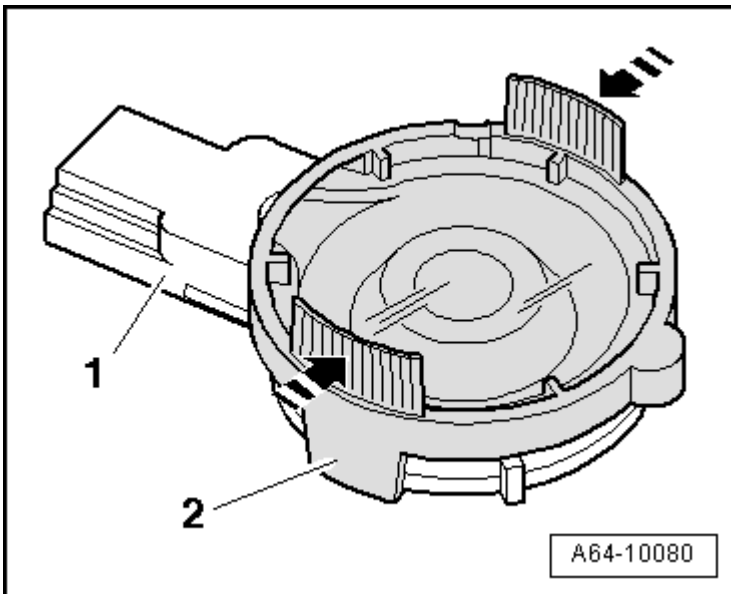


Fig. 16: Cleaning Sensor Contact Surface On Windshield With Cleaning solution D 009 401 04
Courtesy of AUDI OF AMERICA, LLC

-- Press the surface -arrows- on the cap -1- lightly together and pull it off the rain/light recognition sensor -G397- -2-.

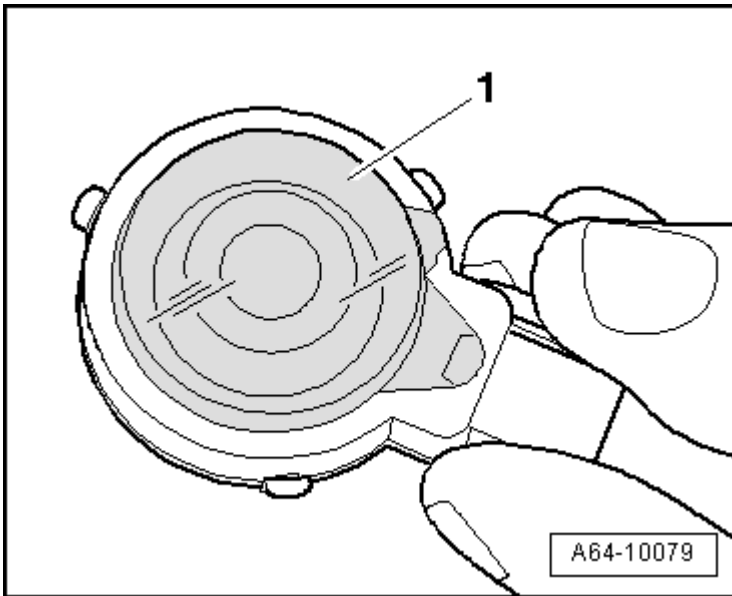


Fig. 17: Spraying Entire Surface Of Sensor Foil With Cleaning solution D 009 401 04 And Inserting Sensor In Mirror Base

Courtesy of AUDI OF AMERICA, LLC

-- Spray the sensor foil -1- completely with cleaning solution D 009 401 04 and install the rain/light recognition sensor -G397- into the mirror base.

-- Mount the rain/light recognition sensor -G397- on the windshield free of bubbles and press the clamp onto the mirror base.

CAUTION: The rain/light recognition sensor -G397- must be free of inclusions and bubbles on the windshield to function properly.

WINDSHIELD

-- Remove windshield wiper arms. Refer to **[For engine(s) CAEB, CALA, CCBA] Removal and Installation** .

-- Remove the plenum chamber cover. Refer to **PLENUM CHAMBER COVER** .

-- Remove left, center and right sun visors. Refer to **Removal and Installation** .

-- Remove the interior rearview mirror. Refer to **Removal and Installation** .

-- Remove upper A-pillar trim on left and right. Refer to **Removal and Installation** .

WARNING: When removing a window, always wear protective eyewear and leather gloves.

- From the wire spool VAS 6452/1, pull out approximately 6.5 meter of cutting wire (about 6 turns) and cut it.
- Cover the awl outlet under the body flange with tape -1- to prevent damaging it.
- Poke the awl through the bead of adhesive from the inside to the outside as illustrated.

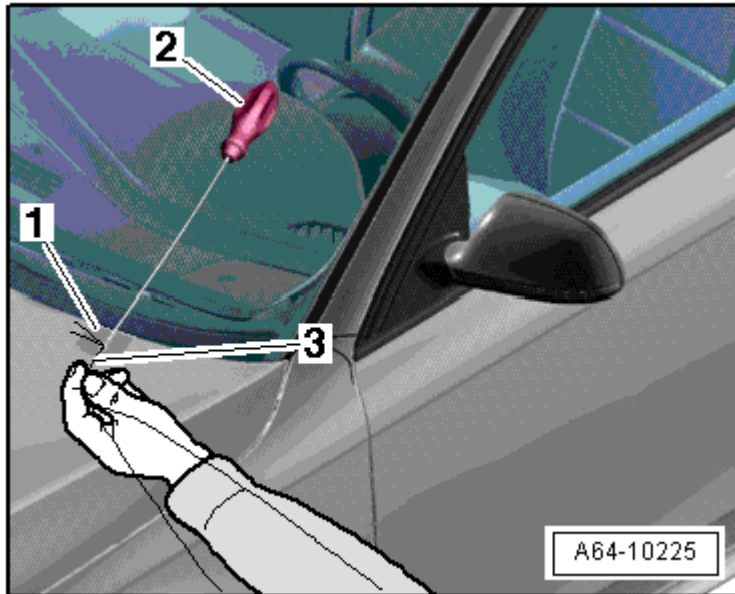


Fig. 18: Poking Awl Through Adhesive Bead
Courtesy of AUDI OF AMERICA, LLC

- Feed both cutting wire ends -3- into the awl -2- and pull it in.
- Place the cutting wire all the way around under the windshield as illustrated.

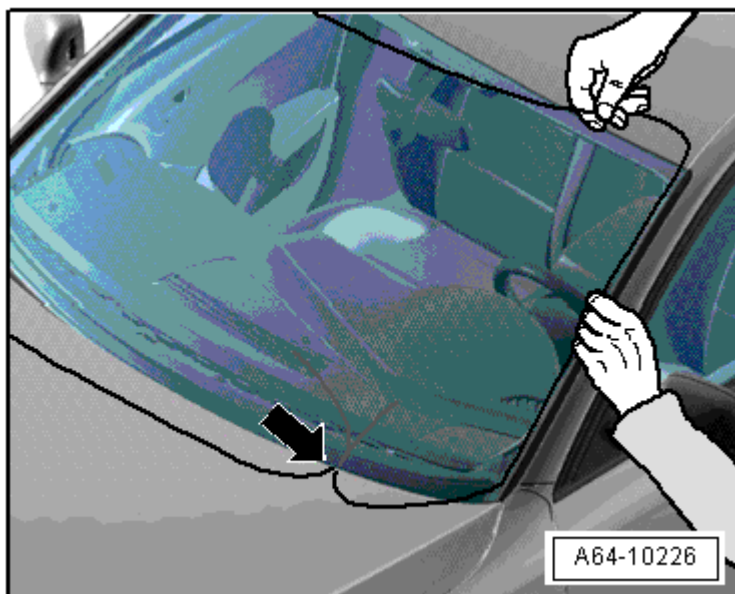


Fig. 19: Placing Cutting Wire All Around Under The Windshield
Courtesy of AUDI OF AMERICA, LLC

CAUTION: The ends of the wire must not be twisted when cutting through the adhesive -arrow-.

-- Mount both spools on the inside of the windshield as illustrated.

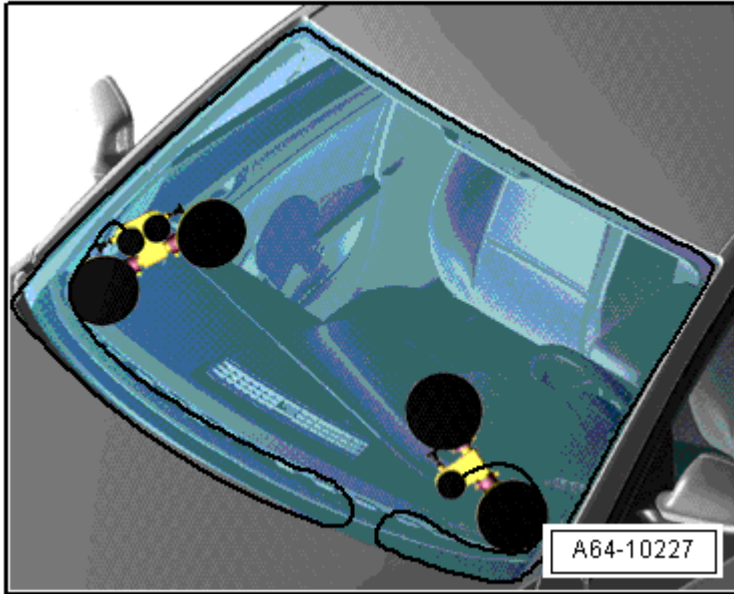


Fig. 20: Mounting Spools On Inside Of Windshield
Courtesy of AUDI OF AMERICA, LLC

-- Insert the ends of the cutting wire -1- into the spool -2-

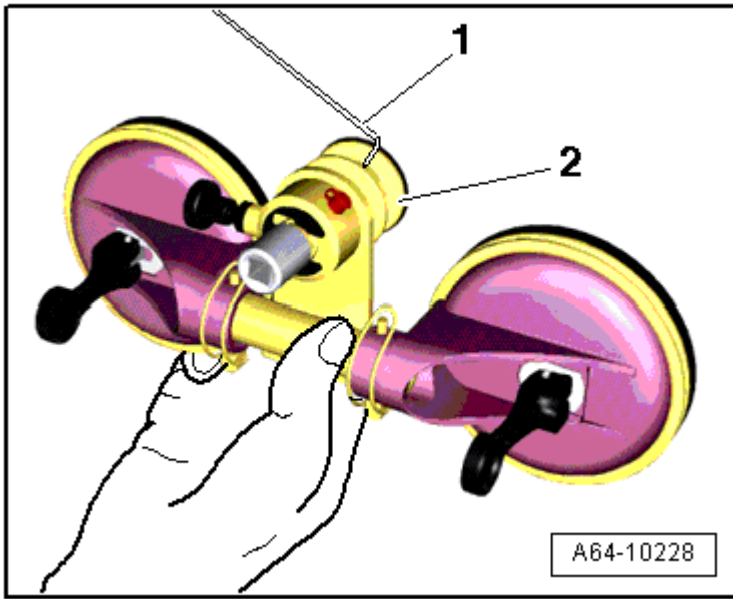


Fig. 21: Inserting Ends Of Cutting Wire Into Spool
Courtesy of AUDI OF AMERICA, LLC

-- Tension the cutting wire and place the protective foil -2- between the instrument panel and the wire

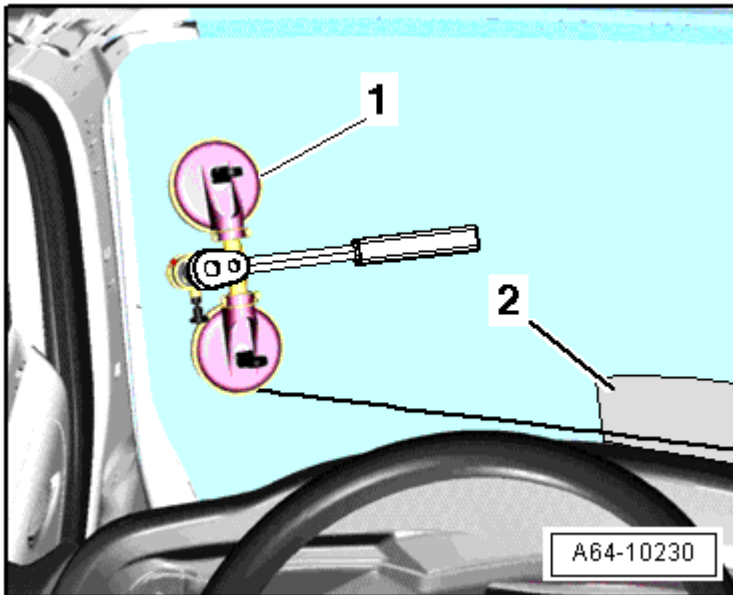


Fig. 22: Tensioning Cutting Wire And Placing Protective Foil Between Instrument Panel And Wire
Courtesy of AUDI OF AMERICA, LLC

-- Cut the first section open, while doing this, the wire is guided into the integrated roller -arrow- on the spool.

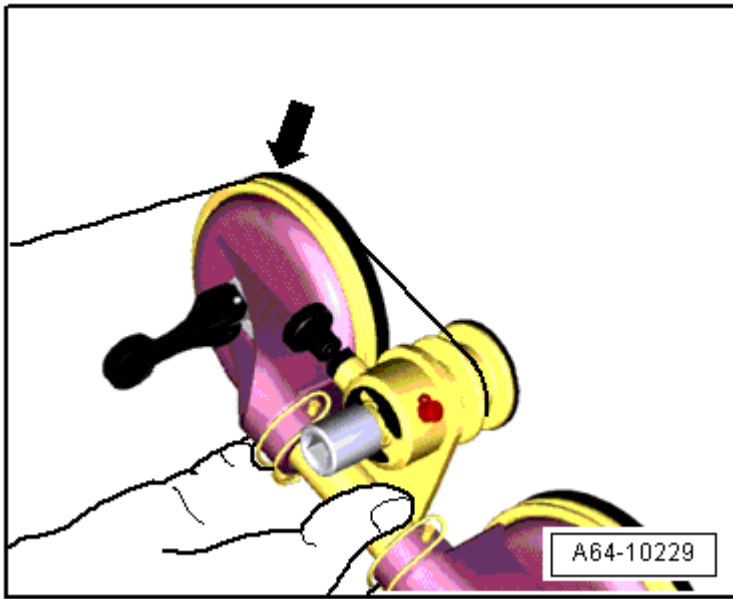


Fig. 23: Identifying Cutting Wire Integrated Roller
Courtesy of AUDI OF AMERICA, LLC

-- Insert an additional guide awl -2- into the adhesive and secure it to the windshield with the suction cup as illustrated to make sure that the wire runs as close to the windshield as possible.

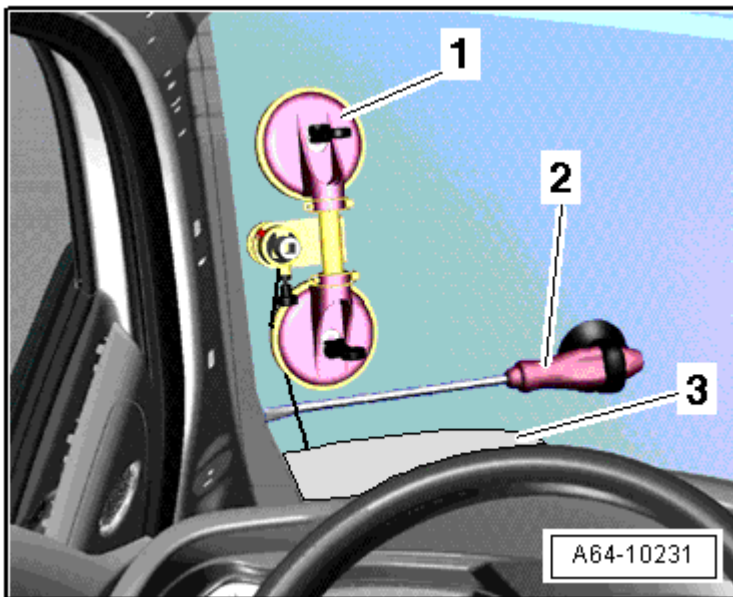


Fig. 24: Inserting Additional Guide Awl Into Adhesive And Securing Suction Cup To Windshield
Courtesy of AUDI OF AMERICA, LLC

- If necessary, move the protective foil -3- along with the wire and cut the windshield free with the spool -1-.
- Move the spool and the guide awl as illustrated and cut free the section along the A-pillar.

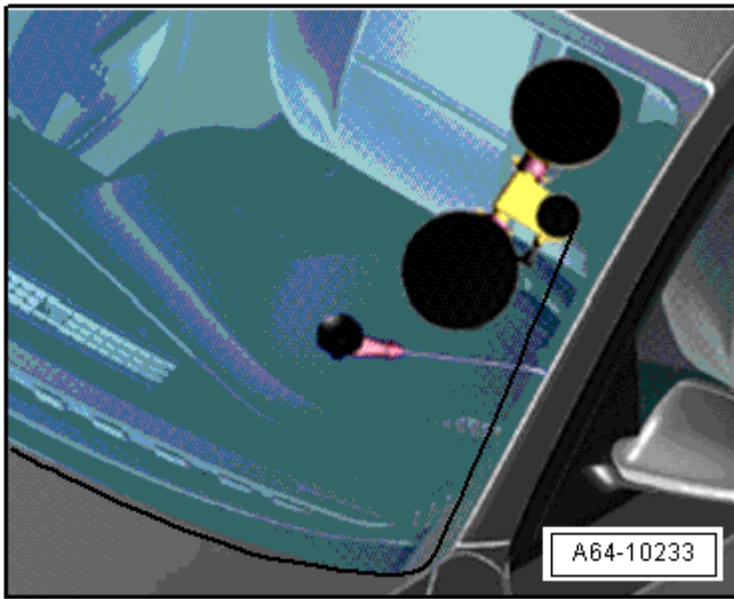


Fig. 25: Cutting A-Pillar Section

Courtesy of AUDI OF AMERICA, LLC

-- Moved the spool and guide awl approximately to the center of the windshield.

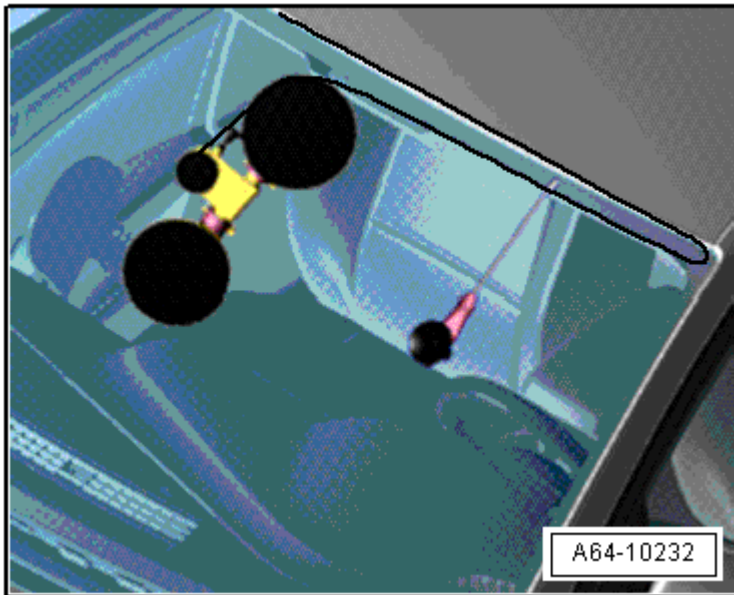


Fig. 26: Cutting Windshield To Center

Courtesy of AUDI OF AMERICA, LLC

-- Cut free the windshield up to about the center.

-- Cut free the bottom of the windshield with the second spool.

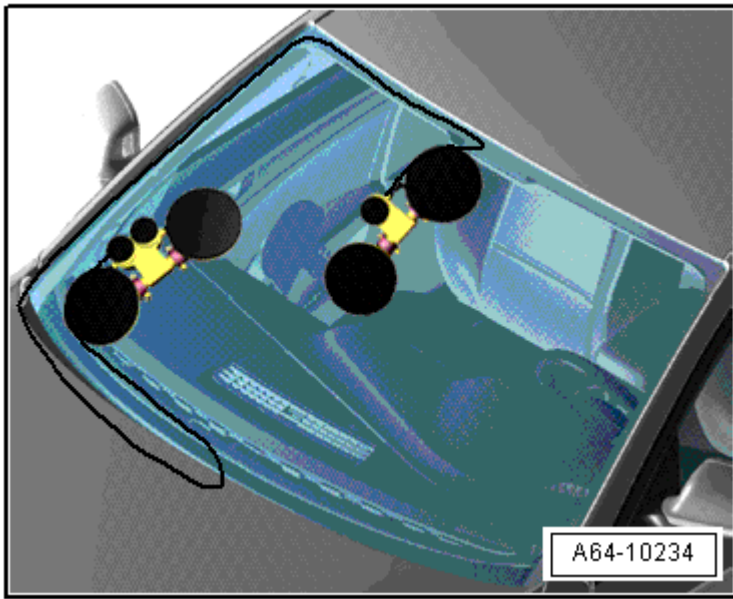


Fig. 27: Cutting Windshield Lower Section
Courtesy of AUDI OF AMERICA, LLC

-- Move the spool upward and insert the guide awl as illustrated.

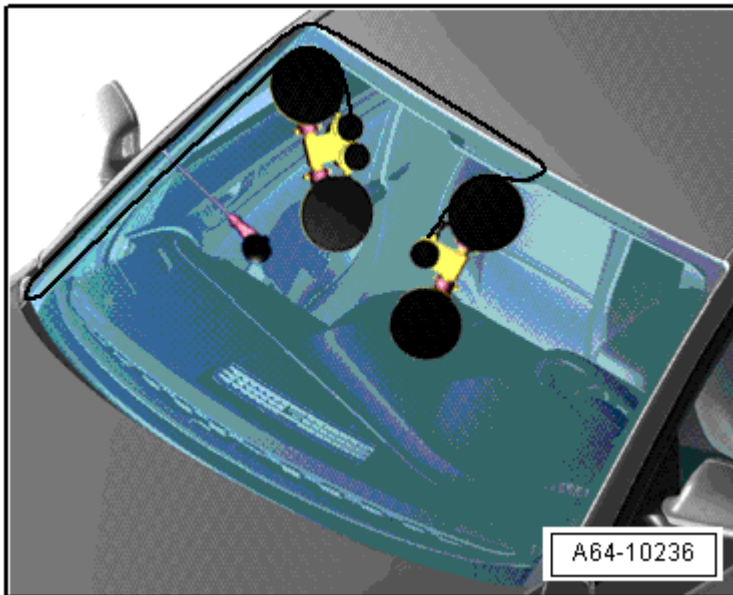


Fig. 28: Moving Spool Upward And Inserting Guide Awl
Courtesy of AUDI OF AMERICA, LLC

-- Cut free the windshield along the A-pillar upward.

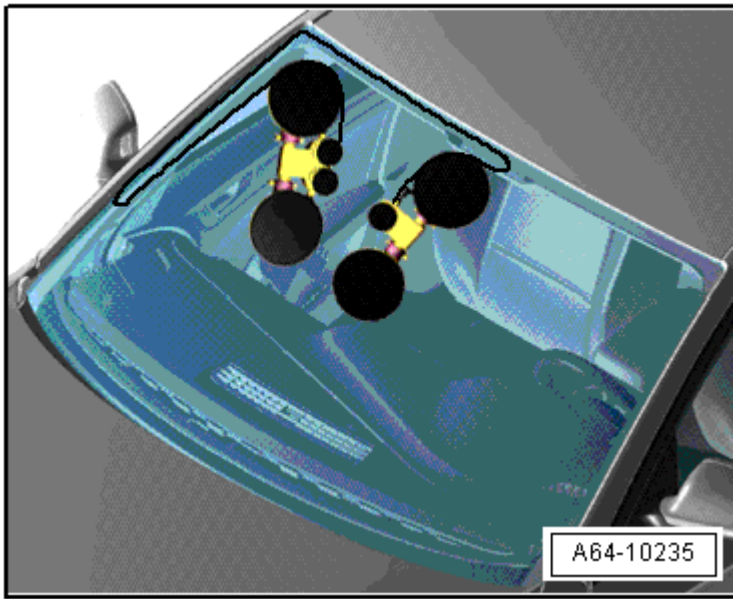


Fig. 29: Cutting Upward Along A-Pillar Windshield
Courtesy of AUDI OF AMERICA, LLC

-- Move the spool over the center of the windshield as well as over the first spool as illustrated and cut free the rest of the windshield along the top.

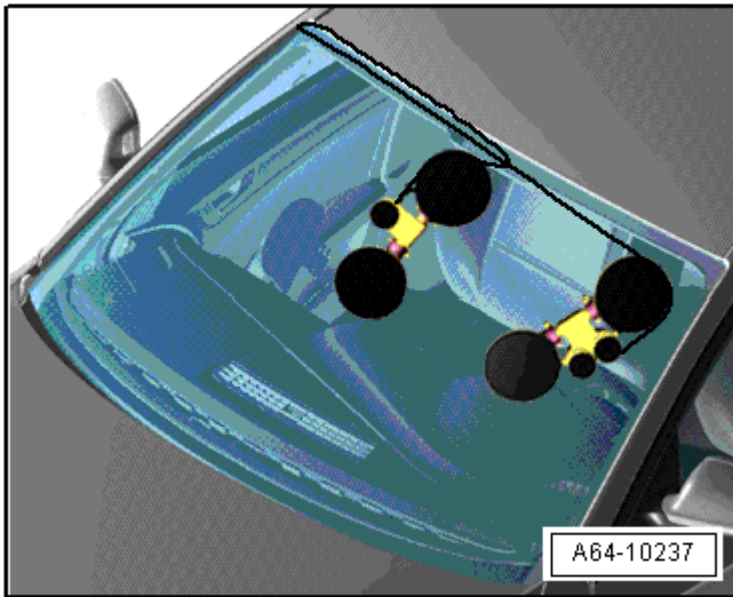


Fig. 30: Cutting Along Top Of Windshield
Courtesy of AUDI OF AMERICA, LLC

-- Remove the windshield from the vehicle with the suction cups.

Preparations for installing the windshield

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-- When reusing the undamaged windshield, cut rest of adhesive material on windshield and flange with Electric Cutter V.A.G 1561 A and Scraper (25 mm) V.A.G 1561/8 so it is even, but do not remove completely.

NOTE: **Residual material acts as a base for the new adhesive sealing material.**

- CAUTION:**
- **Keep adhesive surface free of dirt and grease.**
 - **Only cut back adhesive surface shortly before installation.**
 - **Do not prime or use a cleaning solution on the adhesive surface.**

With new window

-- Clean the adhesive surface all the way around with cleaning solution D 009 401 04.

-- Apply Glass and Paint primer D 009 200 02 as described below.

CAUTION: Ceramic application on window is not primer ! It must be primed before the application of adhesive sealing material!

Applying primer :

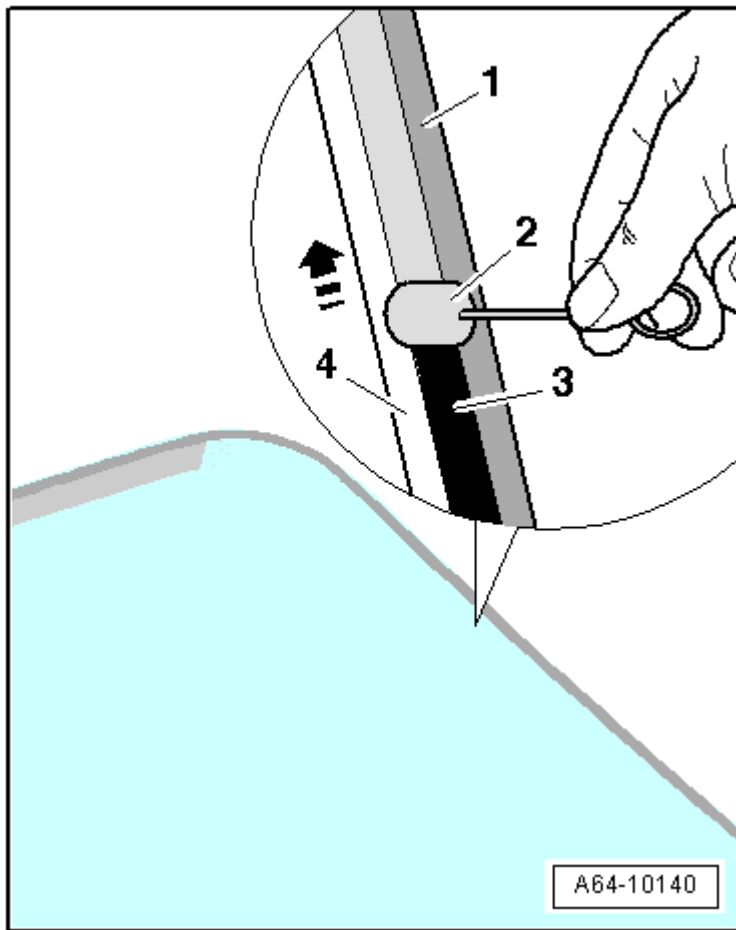


Fig. 31: Applying Primer To Window Molding
 Courtesy of AUDI OF AMERICA, LLC

-- Apply glass-/paint primer -3- with applicator -2- evenly in one stroke near the window molding -1- on the window -4-.

-- Beginning applying with saturated felt.

- primer width approximately 20 mm.
- The glass-/paint primer must be positioned in the center of the adhesive bead.
- Curing time 10 minutes

Window flange:

-- If the windshield flange was damaged, then it must be repainted.

-- First clean corrected area with Cleaning solution D 009 401 04 and then apply Glass and Paint primer D 009 200 02.

Windshield, Installing

NOTE: Cross-section thickness of adhesive bead is determined by dimension of opening in nozzle tip and rate of application.

Dimensions for adhesive application:

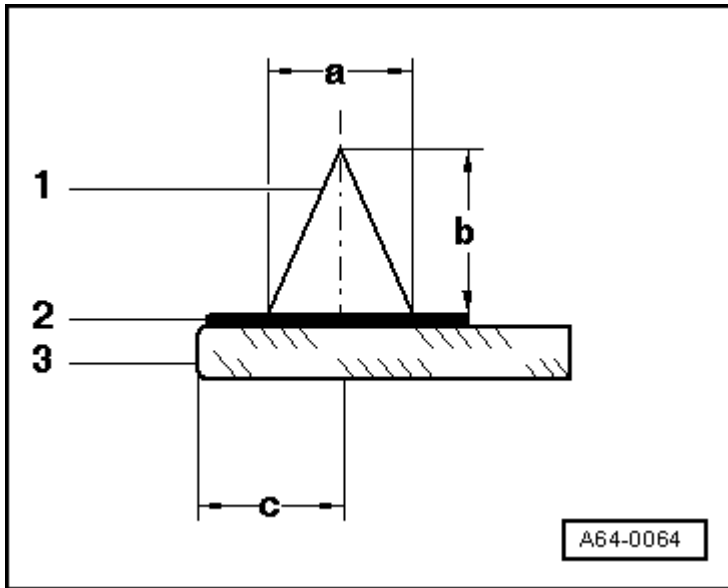


Fig. 32: Dimensions For Adhesive Application
Courtesy of AUDI OF AMERICA, LLC

1. Adhesive sealing material
 2. Glass/paint primer
 3. Window
- Dimension -a- = 8 mm
 - Dimension -B- = 12 mm
 - Dimension -c- = note varying spacing dimensions to window edge. Refer to item 2.

-- Position complete surface of nozzle -2- onto window.

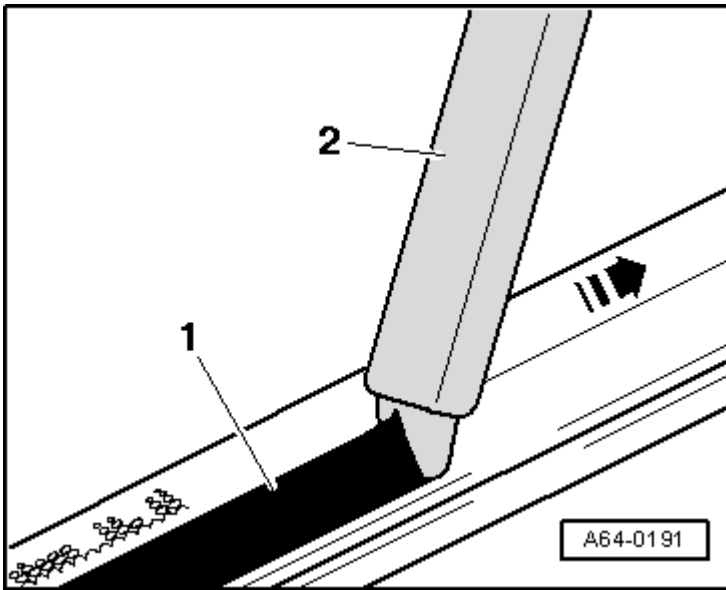


Fig. 33: Positioning Complete Surface Of Nozzle Onto Window
Courtesy of AUDI OF AMERICA, LLC

- Application direction -arrow- for adhesive bead -1-.

-- Apply adhesive sealing material -1- all around on window -2- according to illustration.

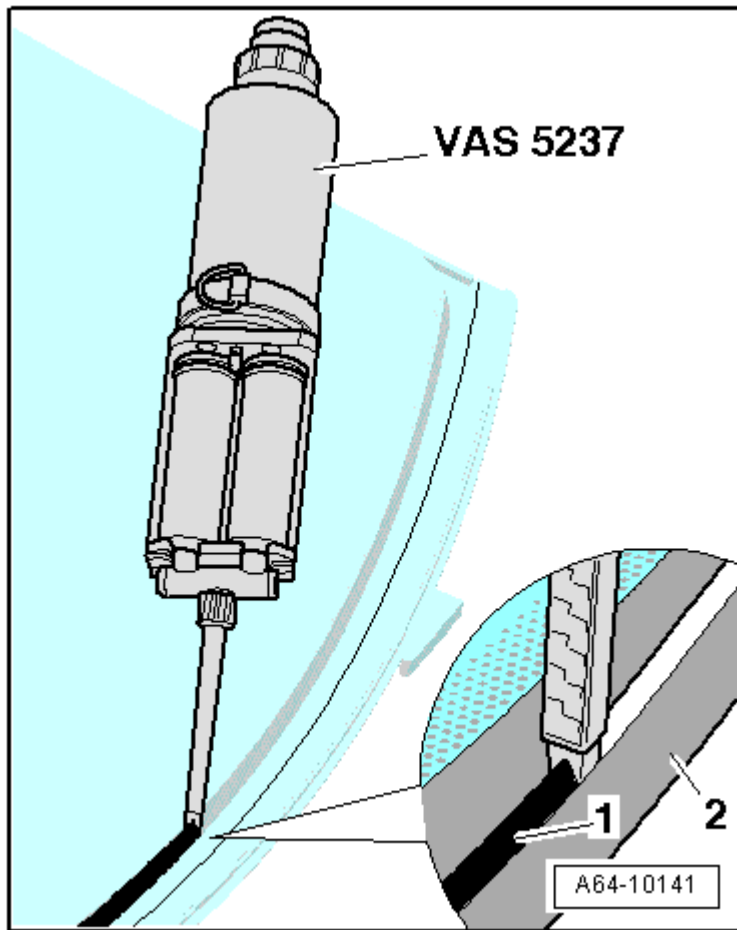


Fig. 34: Identifying VAS 5237

Courtesy of AUDI OF AMERICA, LLC

- With an undamaged removed window, apply adhesive to remaining bead.
- Using suction cups, install the windshield.

CAUTION: The window must be installed within 15 minutes or the adhesive sealing material will not adhere properly.

- Center window along sides.
 - Distance from the edge of the windshield to the roof frame. Refer to item 1.
 - Secure the window to the top of the roof with adhesive tape.
- Before installing plenum chamber cover, first remove protective profile -2- from the frame.
- Observe minimum curing time. Refer to **MINIMUM CURING TIMES**.

SIDE WINDOW

Undamaged side window, removing

CAUTION: In window separation area, protect side panel and roof against paint damage with adhesive tape.

Vehicles with gloss roof trim molding

-- Roof trim molding and side trim molding removed. Refer to **ROOF TRIM STRIP OVERVIEW** .

Vehicles with standard roof trim molding

-- Unclip the roof trim molding.

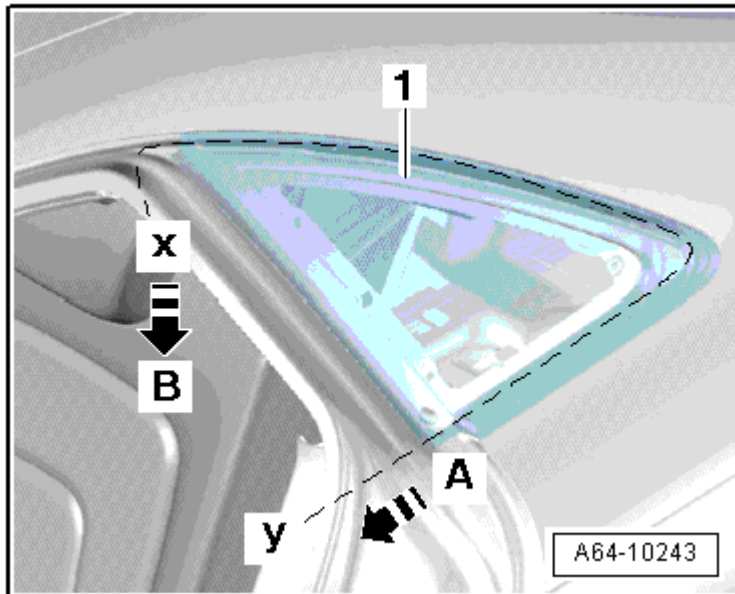


Fig. 35: Identifying Side Window
Courtesy of AUDI OF AMERICA, LLC

CAUTION: Roof trim molding must not be bent.

-- Route the cutting wire around the side window as shown in the illustration.

-- Secure X and Y ends in two pull grips from special tool Cutting Tools For Glass V.A.G 1351.

-- Pull cutting wire forward in direction of arrow -A- using light sawing motions and cut through lower adhesive sealing material at side panel and at roof frame.

-- In this way, first the securing pin on the rear of the window and then the adhesive bead are cut through.

- Then pull cutting cord through in direction of -arrow B- downward through adhesive sealing material.
- Remove window from window opening.

Broken Side Window, Removing

- Protect body and interior from glass splinters.
- Bond flange all around with fabric reinforced adhesive tape.
- Remove glass pieces from adhesive material.

WARNING: When removing a window, always wear protective eyewear and leather gloves.

- Remove adhesive material (with glass residue) from window opening using electric cutter V.A.G 1561A and knife V.A.G 1561/11 (with stopper roll).

Preparations for installing side window

- When reusing an undamaged window, cut remaining adhesive sealing material on window and flange using a carpet knife so that it is even, but do not remove completely!

NOTE: Residual material acts as a base for the new adhesive sealing material.

- CAUTION:**
- Keep adhesive surface free of dirt and grease.
 - Only cut back adhesive surface shortly before installation.
 - Do not prime or use a cleaning solution on the adhesive surface.

With new window:

- Clean the adhesive surface all the way around with cleaning solution D 009 401 04.
- Apply glass-/paint primer D 009 200 02 all around the adhesive surface.
 - Curing time 10 minutes.

Side Window, Installing

- The roof trim molding and side trim molding must be installed before installing the side window.

NOTE: Cross-section thickness of adhesive bead is determined by dimension of opening in nozzle tip and rate of application.

Dimensions for adhesive application:

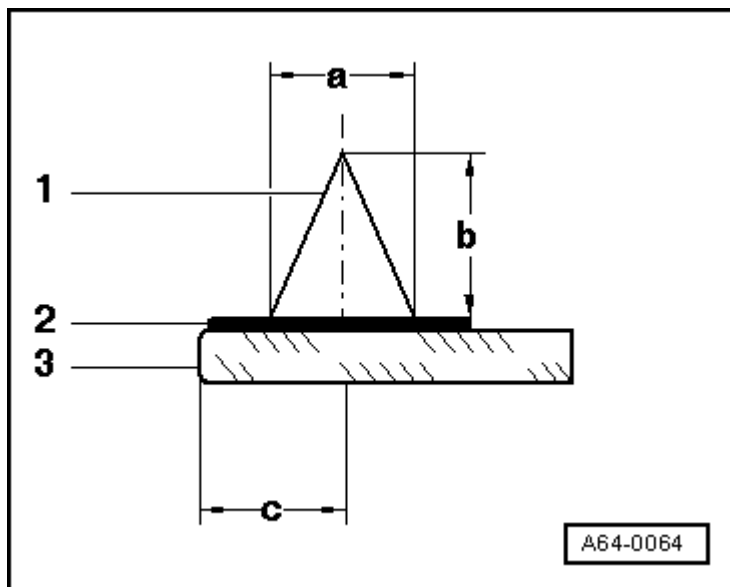


Fig. 36: Dimensions For Adhesive Application
 Courtesy of AUDI OF AMERICA, LLC

1. Adhesive sealing material
2. Glass/paint primer
3. Window

- Dimension -a- = 8 mm ^{+2 mm}
- Dimension -b- = 12 mm ^{+3 mm}
- Distance -c- = to window edge is given through the window molding.

-- Position complete surface of nozzle -2- onto window.

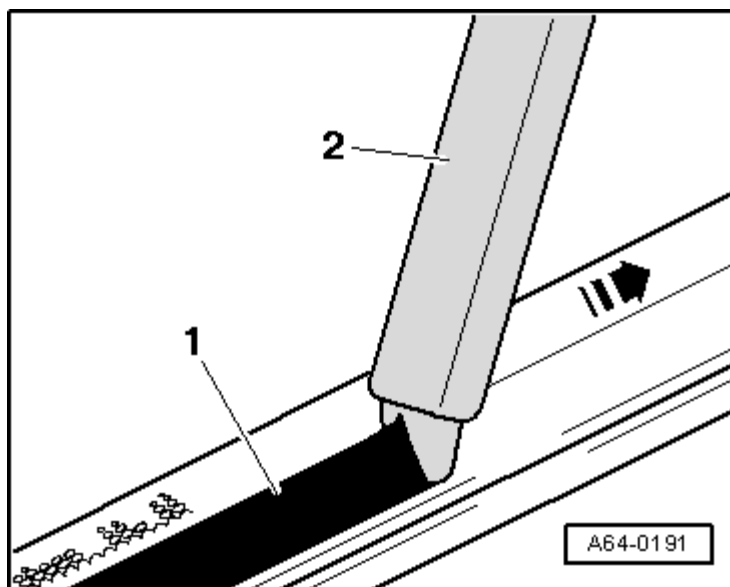


Fig. 37: Positioning Complete Surface Of Nozzle Onto Window
Courtesy of AUDI OF AMERICA, LLC

- Application direction -arrow- for adhesive bead -1-.

-- Apply adhesive sealing material all around near window molding.

-- With an undamaged removed window, apply adhesive to remaining bead.

NOTE: Use 1K Window Adhesive DH 009 100 03 (small cartridge), or 2K Window Adhesive Kit DA 004 600 A2 can also be used if more than one window must be bonded.

-- If the window is new, first insert the securing pin in the C-pillar, D-pillar and then press the window into the cut-out.

If a side window is going to be installed, then secure it to the C-pillar and D-pillar with adhesive tape.

-- Observe minimum curing time. Refer to **FLUSH-BONDED WINDOWS => Minimum curing time (--> curing time)**.

REAR WINDOW

Special tools and workshop equipment required

- Cutting Tool Kit VAS 6452

Undamaged Rear Window, Removing

- C-pillar trim removed.
- The high-mounted brake lamp is removed.

-- Disconnect rear window defroster and window antenna connectors and secure to center of window with tape.

WARNING: When removing a window, always wear protective eyewear and leather gloves.

-- From the wire spool VAS 6452/1, pull out approximately 6.5 meter of cutting wire (about 6 turns) and cut it.

-- Cover the awl outlet under the body flange with tape -1- to prevent damaging it.

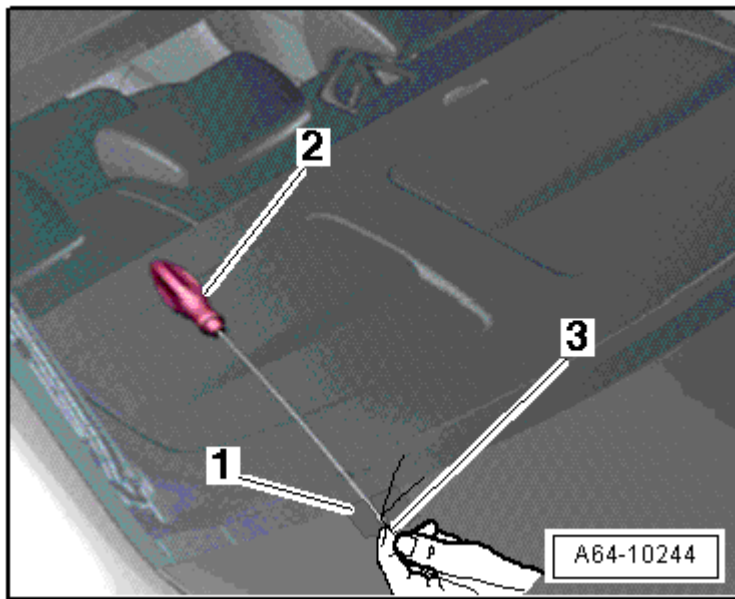


Fig. 38: Identifying Special Cutting Tool Kit VAS 6452
Courtesy of AUDI OF AMERICA, LLC

- Feed both cutting wire ends -3- into the awl -2- and pull it in.
- Place the cutting wire all the way around under the rear window as illustrated.

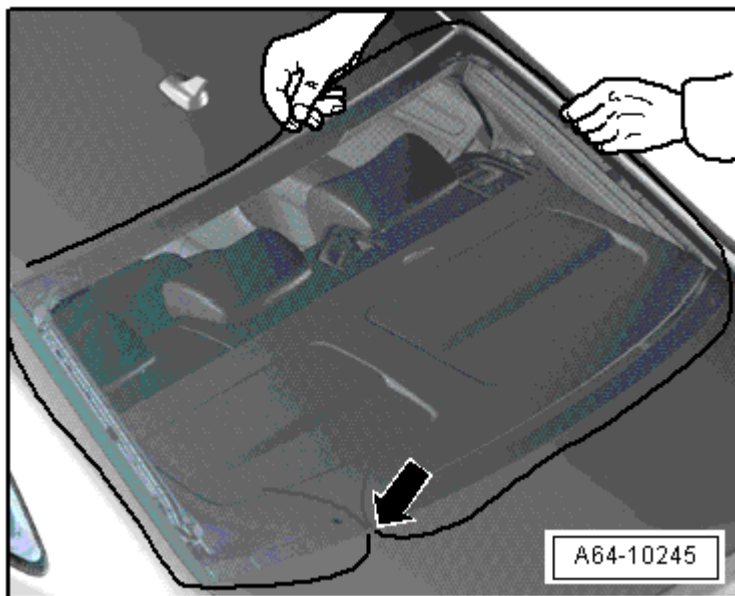


Fig. 39: Identifying Cutting Wire Location
Courtesy of AUDI OF AMERICA, LLC

- Route cutting wire around rear window under the glass as shown in the illustration.

CAUTION: The ends of the wire must not be twisted when cutting through the adhesive -arrow-.

-- Mount both spools on the inside of the windshield as illustrated.



Fig. 40: Identifying Spool Location

Courtesy of AUDI OF AMERICA, LLC

-- Insert the ends of the cutting wire -1- into the spool -2-.

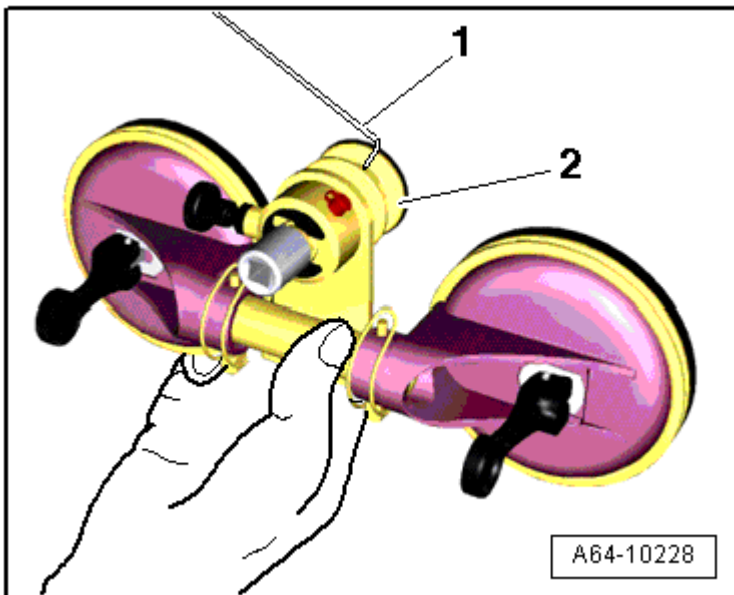


Fig. 41: Inserting Ends Of Cutting Wire Into Spool

Courtesy of AUDI OF AMERICA, LLC

-- Tension the cutting wire using the spool -1- and insert the plastic film -2- taken from the VAS 6452 to protect the wire and the rear shelf.

--

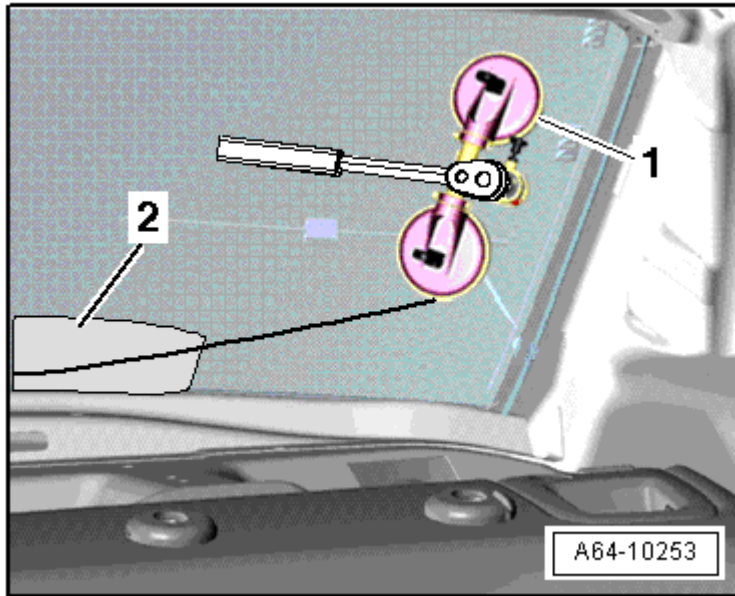


Fig. 42: Identifying Special Cutting Tool Kit Location
Courtesy of AUDI OF AMERICA, LLC

-- Cut the first section open, while doing this, the wire is guided into the integrated roller -arrow- on the spool.

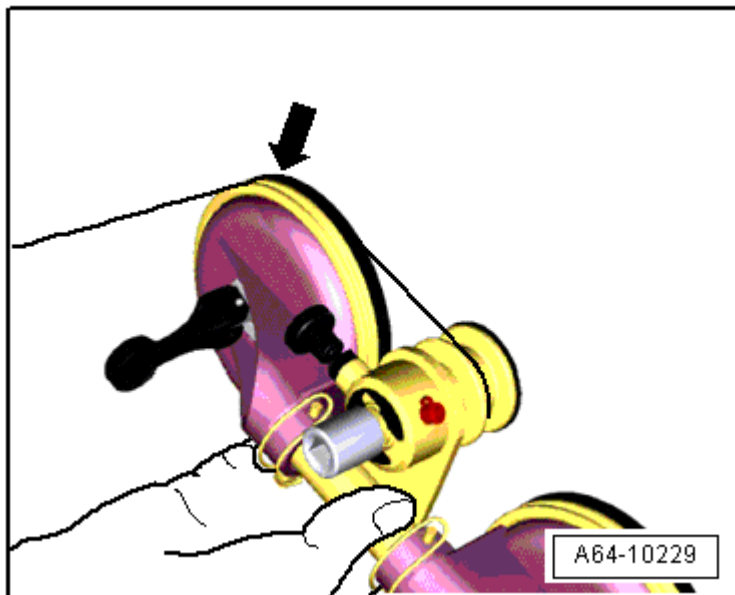


Fig. 43: Identifying Cutting Wire Integrated Roller
Courtesy of AUDI OF AMERICA, LLC

-- Insert an additional guide awl -2- into the adhesive and secure it to the windshield with the suction cup as illustrated to make sure that the wire runs as close to the windshield as possible.

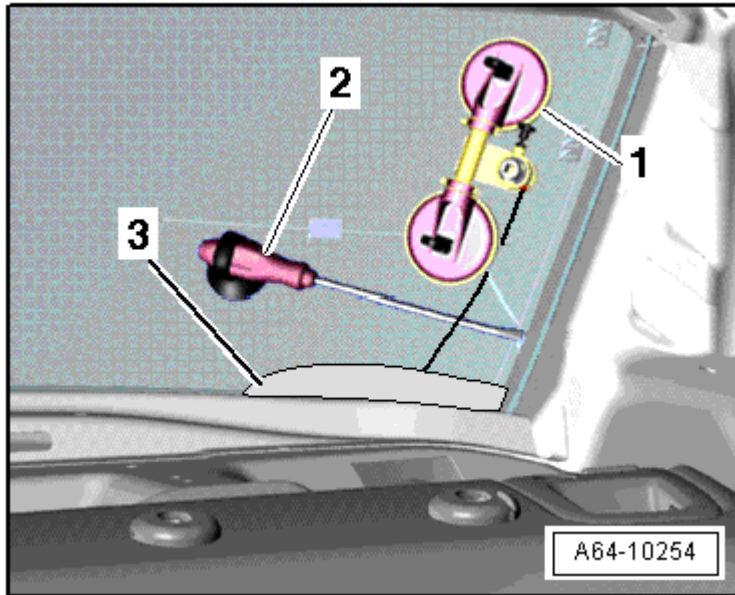


Fig. 44: Identifying Special Cutting Tool Kit Location
Courtesy of AUDI OF AMERICA, LLC

-- Move the reel device and the guide awl as illustrated and cut free the section along the D-pillar.

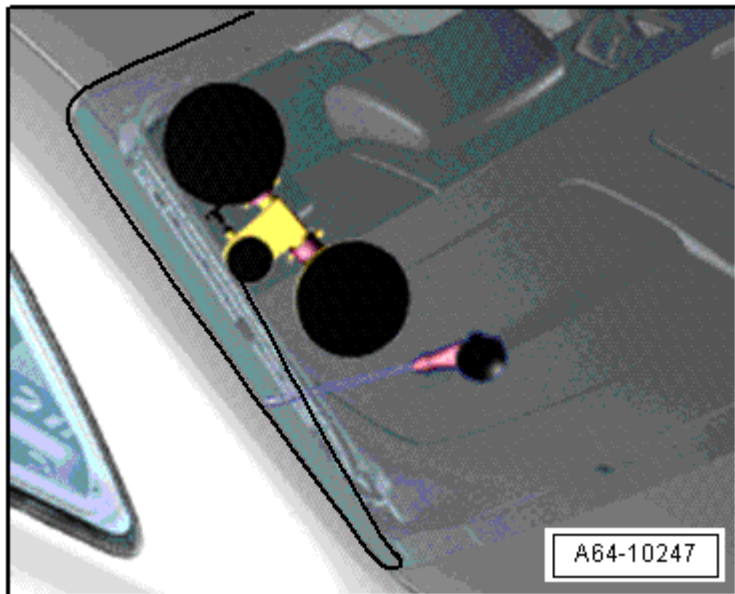


Fig. 45: Identifying Special Cutting Tool Kit D-Pillar Location
Courtesy of AUDI OF AMERICA, LLC

-- Move the reel device and the guide awl as illustrated.

-- Cut free the windshield further up to about the center.

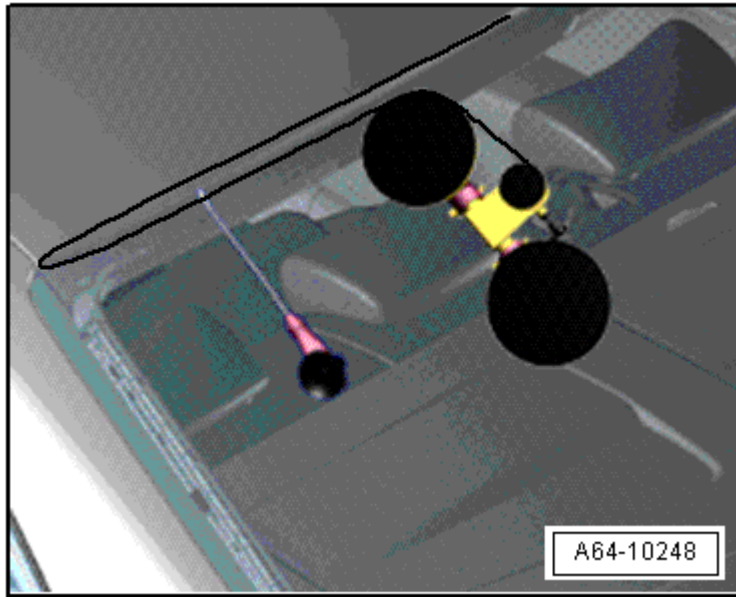


Fig. 46: Identifying Special Cutting Tool Kit Top Location
Courtesy of AUDI OF AMERICA, LLC

-- Cut free the bottom of the windshield with the second spool.

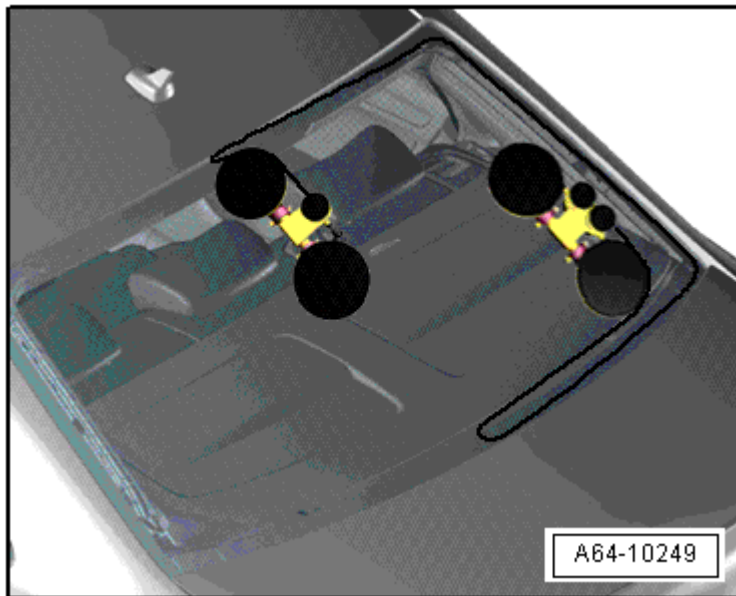


Fig. 47: Identifying Special Cutting Tool Kit Bottom Location
Courtesy of AUDI OF AMERICA, LLC

-- Move the spool upward and insert the guide awl as illustrated.

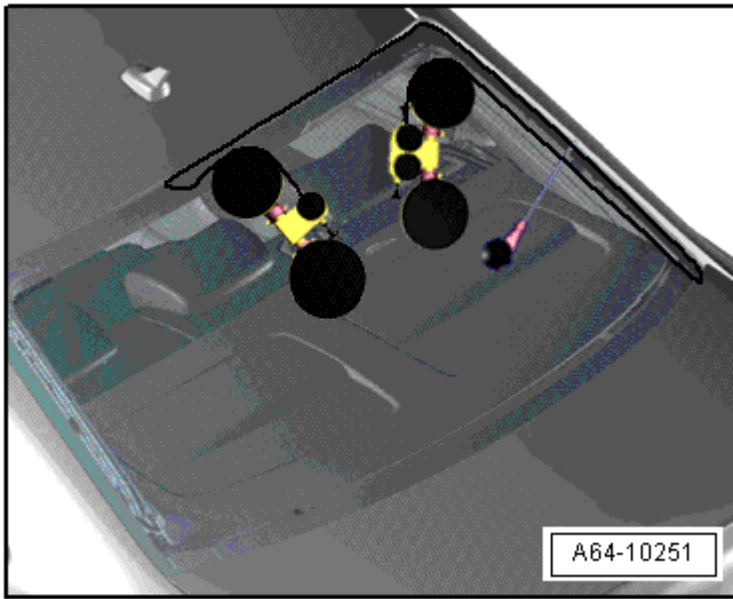


Fig. 48: Identifying Special Cutting Tool Kit D-Pillar Location
Courtesy of AUDI OF AMERICA, LLC

-- Cut free the windshield along the D-pillar upward.

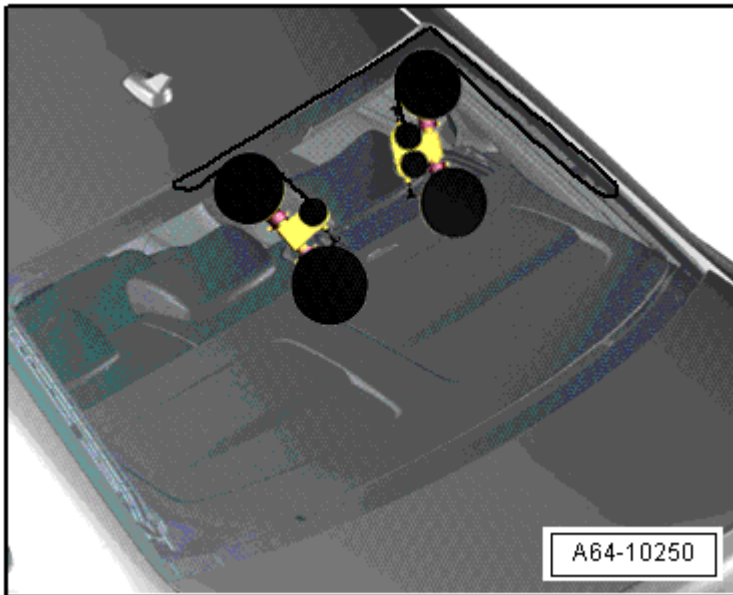


Fig. 49: Identifying Special Cutting Tool Kit D-Pillar Location
Courtesy of AUDI OF AMERICA, LLC

-- Move the spool over the center of the windshield as well as over the first spool as illustrated and cut free the rest of the windshield along the top.

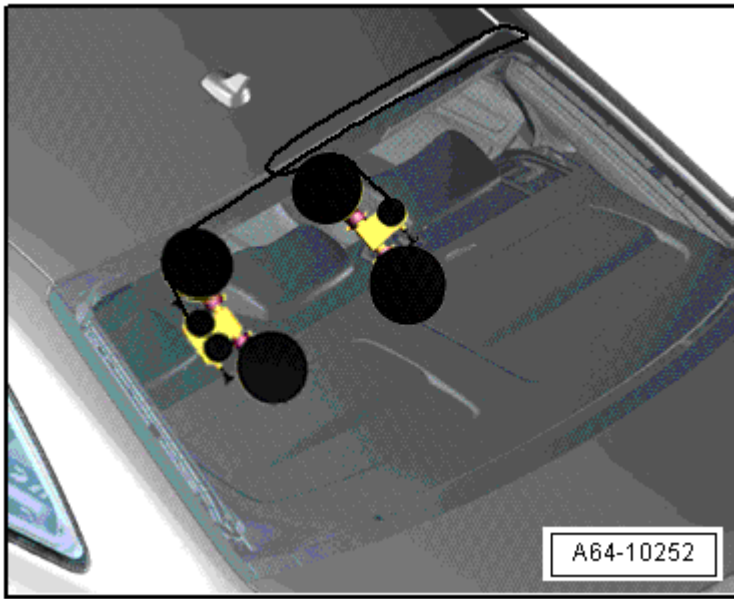


Fig. 50: Identifying Special Cutting Tool Kit Top Location
Courtesy of AUDI OF AMERICA, LLC

-- Remove the window glass using suction cups.

Damaged Rear Window, Removing

WARNING: When removing a window, always wear protective eyewear and leather gloves.

-- Protect body and interior from glass splinters.

-- Remove glass pieces from adhesive material.

-- Disconnect rear window defroster and window antenna connectors.

-- Bond flange all around with fabric reinforced adhesive tape.

-- Remove adhesive material (with glass residue) from window opening using electric cutter V.A.G 1561A and knife V.A.G 1561/10 (with stopper roll).

Preparations for the installing the rear window

NOTE:

- When reusing the undamaged window, cut rest of adhesive material on window and flange with Electric Cutter V.A.G 1561 A and Scraper (25 mm) V.A.G 1561/8 so it is even, but do not remove completely.
- Residual material acts as a base for the new adhesive sealing material.

CAUTION:

- Keep adhesive surface free of dirt and grease.
- Only cut back adhesive surface shortly before installation.
- Do not prime or use a cleaning solution on the adhesive surface.

With new window:

-- Clean the adhesive surface all the way around with cleaning solution D 009 401 04.

CAUTION:

- Ceramic application on window is not primer.
- It must be primed before the application of adhesive sealing material!

-- Apply the glass/paint primer D 009 200 02 as described.

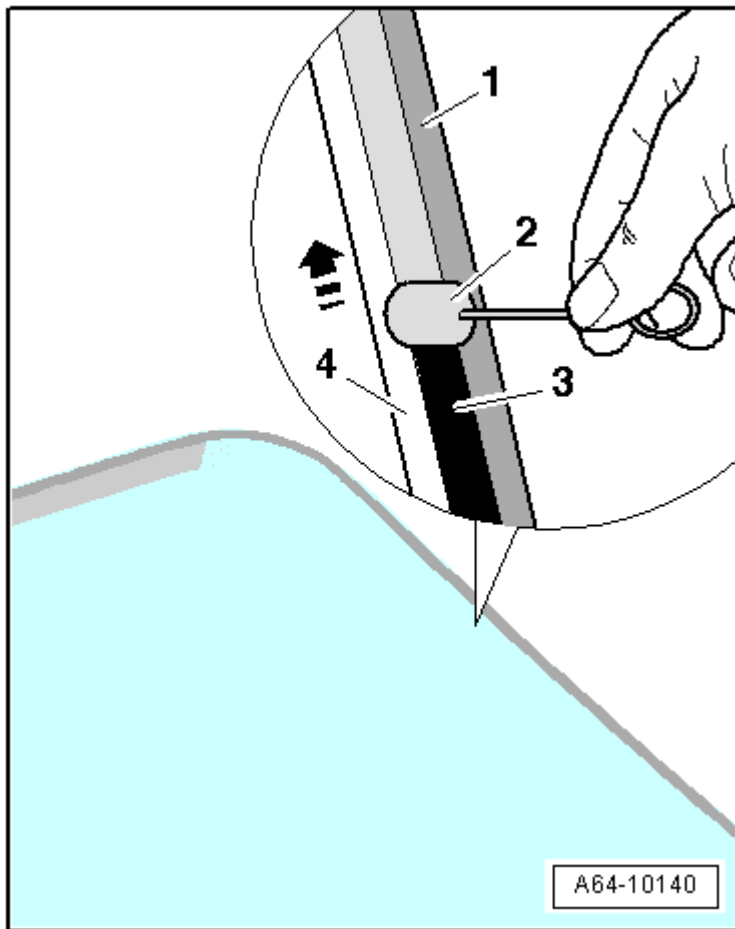
Applying primer :

Fig. 51: Applying Primer To Window Molding
Courtesy of AUDI OF AMERICA, LLC

-- Apply the glass/paint primer -3- evenly over the adhesive surface on the window glass -4- in a single wiping

motion using the applicator -2-.

-- Beginning applying with saturated felt.

- Curing time 10 minutes

CAUTION: Glass/paint primer conducts electricity and must not touch rear window defroster distributing wire.

Window flange:

-- If the windshield flange was damaged, then it must be repainted and if necessary, corrosion protected.

-- Clean the repaired area with cleaning solution D 009 401 04 and then apply glass/paint primer D 009 200 02.

Installation

NOTE: Cross-section thickness of adhesive bead is determined by dimension of opening in nozzle tip and rate of application.

Dimensions for adhesive application:

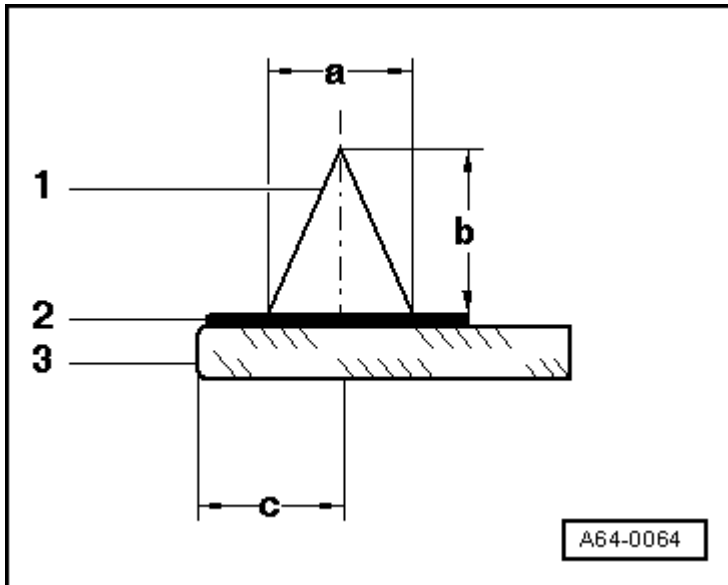


Fig. 52: Dimensions For Adhesive Application
Courtesy of AUDI OF AMERICA, LLC

1. Adhesive sealing material
2. Glass/paint primer
3. Window

- Dimension -a- = 8 mm ± 2 mm
- Dimension -b- = 12 mm ± 2 mm
- Dimension -c- = note spacing dimensions to window edge. Refer to item 2.

-- Position the entire nozzle surface -2- on the window.

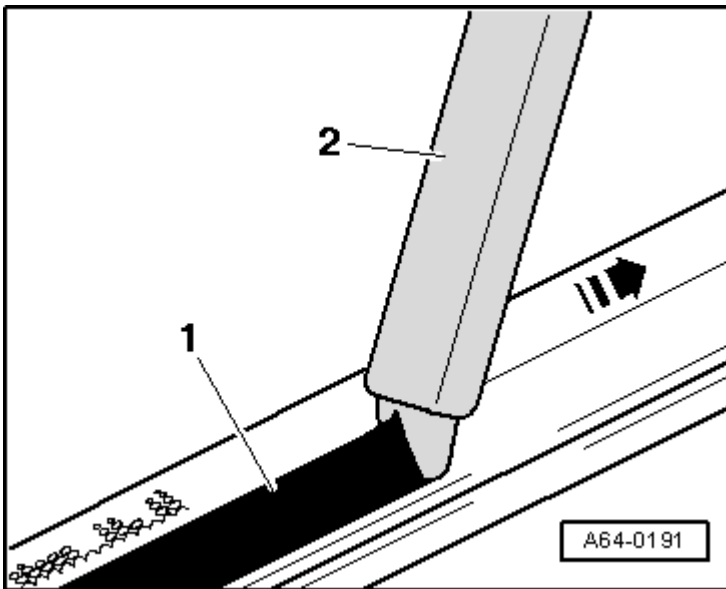


Fig. 53: Positioning Complete Surface Of Nozzle Onto Window
Courtesy of AUDI OF AMERICA, LLC

- Application direction -arrow- for adhesive bead -1-.

-- Apply adhesive sealing material all around.

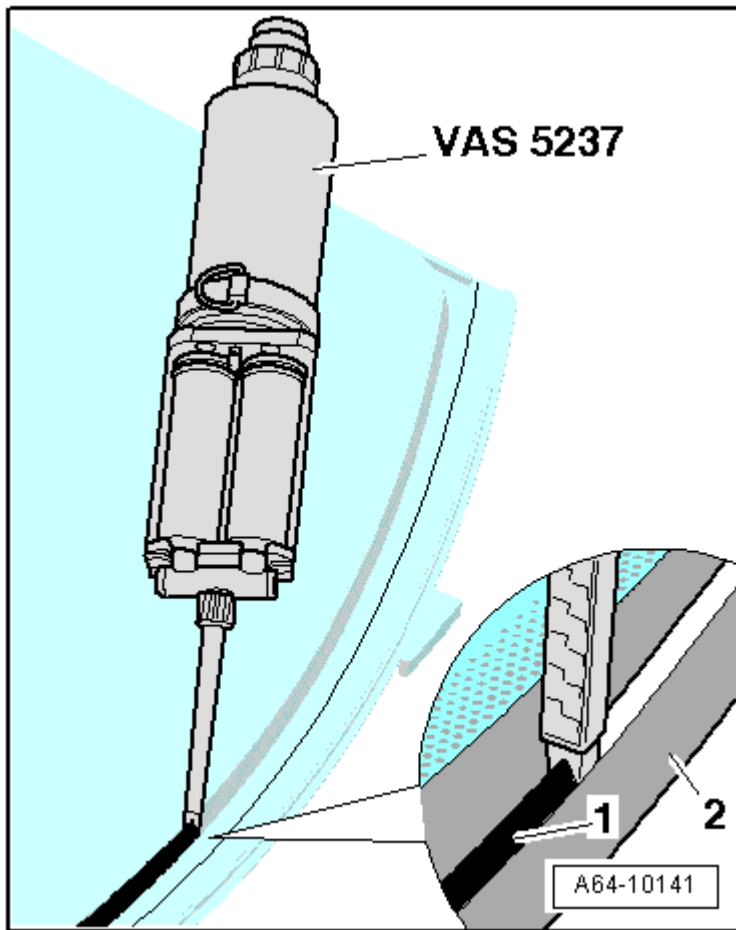


Fig. 54: Identifying VAS 5237

Courtesy of AUDI OF AMERICA, LLC

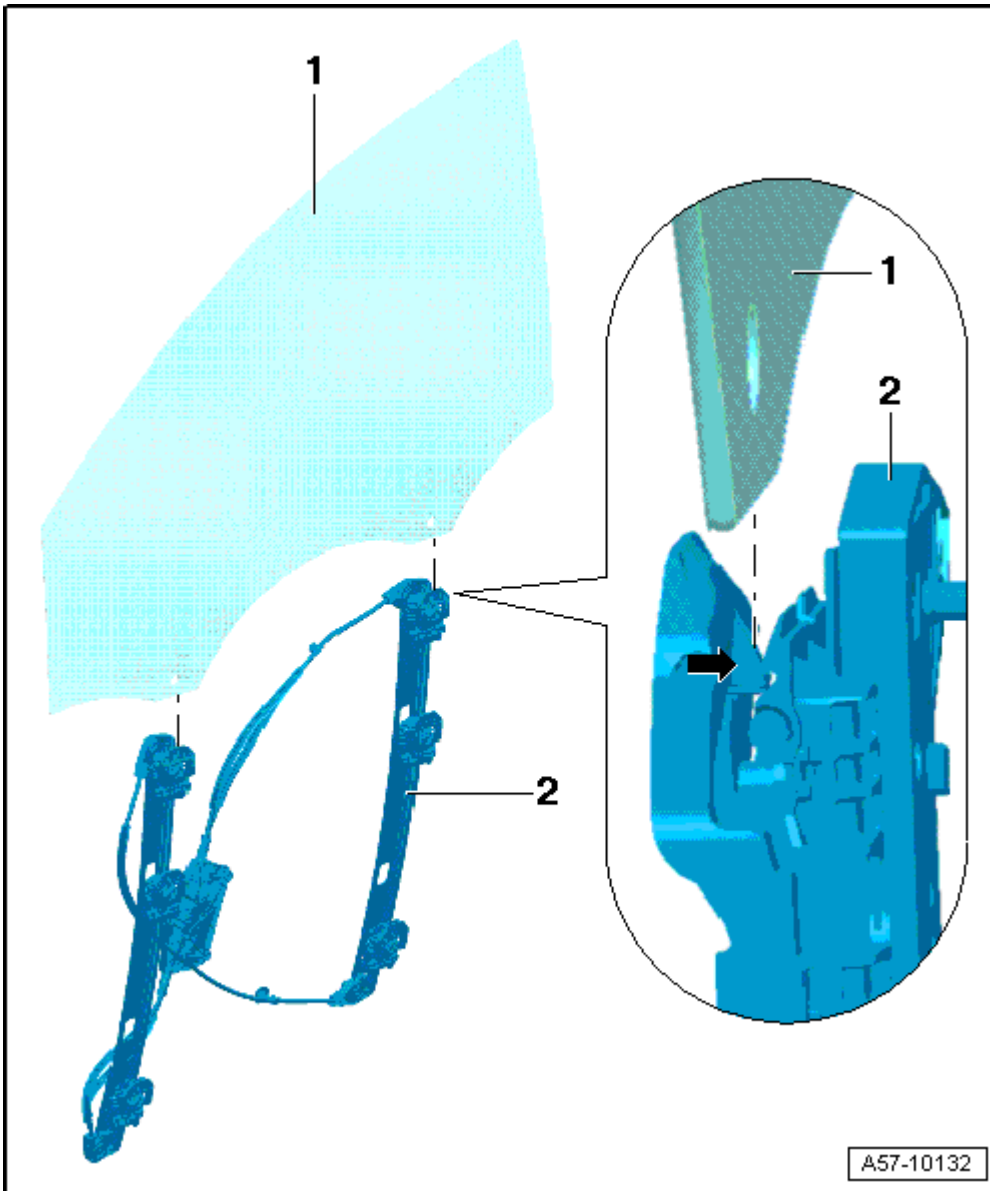
- With an undamaged removed window, apply adhesive to remaining bead.
- Insert the rear window into window opening using suction cups.

CAUTION: The window must be installed within 15 minutes or the adhesive sealing material will not adhere properly.

- Center window along sides.
- Pay attention to the distance to the roof. Refer to item 1.
- Observe minimum curing time. Refer to **MINIMUM CURING TIMES**.

BOLTED WINDOWS

FRONT DOOR WINDOW



A57-10132

Fig. 55: Identifying Front Door Window

Courtesy of AUDI OF AMERICA, LLC

1. Door Window

- The door panel. Refer to **Removal and Installation** and the speaker are removed. Refer to **Removal and Installation**

-- To remove, release catches -arrow- from coupling plate -2- with a screwdriver and pull window -1- in window guide up slightly.

-- Tip window forward and remove it upward from door.

2. Window Regulator

- The window regulator remains installed inside the door.

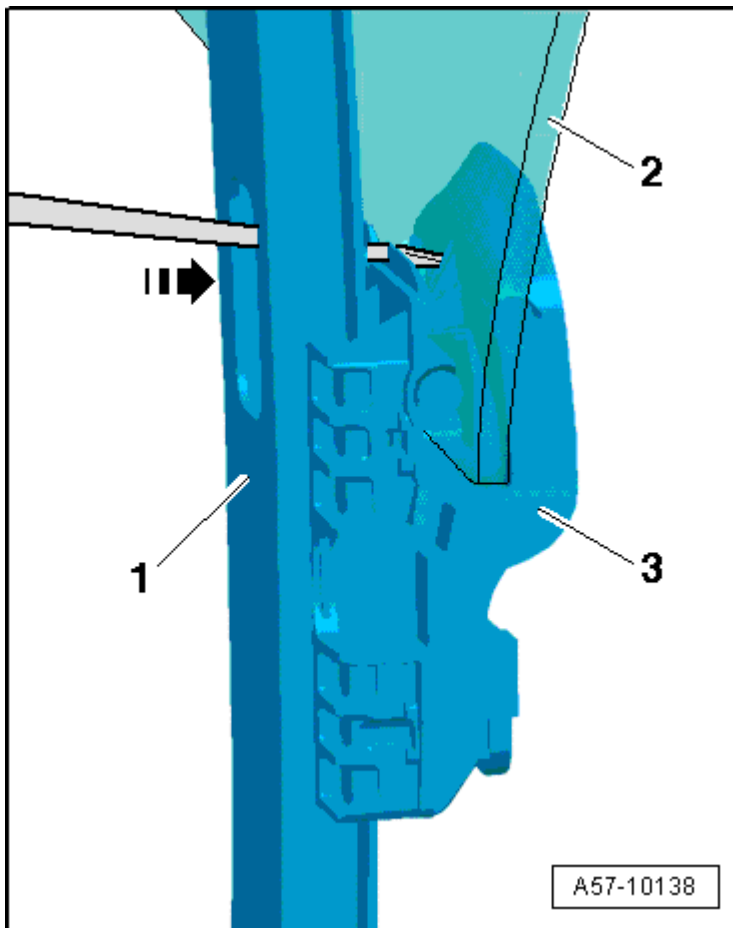
Door Window, Releasing

Fig. 56: Door Window, Releasing
Courtesy of AUDI OF AMERICA, LLC

- Run door window down.
- Using a screwdriver, press coupling plate -3- outward to release through cut-out in window guide -1- and hole in door window -2-.
- Remove window upward from coupling plate.
- Tilt the window forward and pull it straight upward and out of the window guide.

Door Window, Inserting

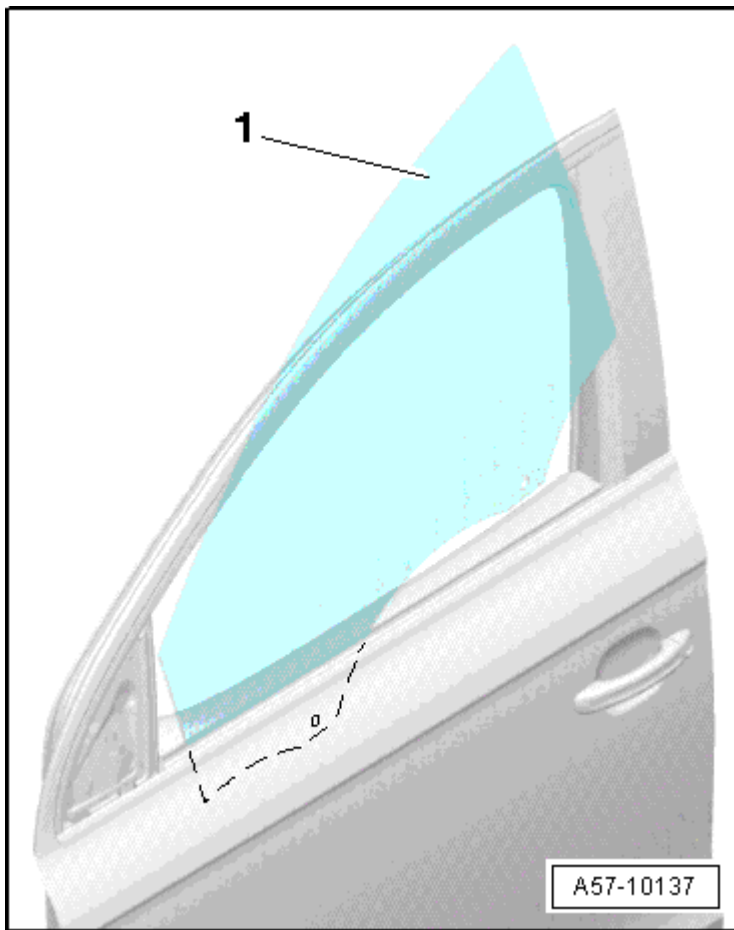


Fig. 57: Door Window, Inserting

Courtesy of AUDI OF AMERICA, LLC

- Insert door window -1- diagonally toward front in door window guide.
- Align window in front and rear window guides and slide it down.
- Press window down into coupling plate.
- This engages coupling plate in window.

REAR DOOR WINDOW

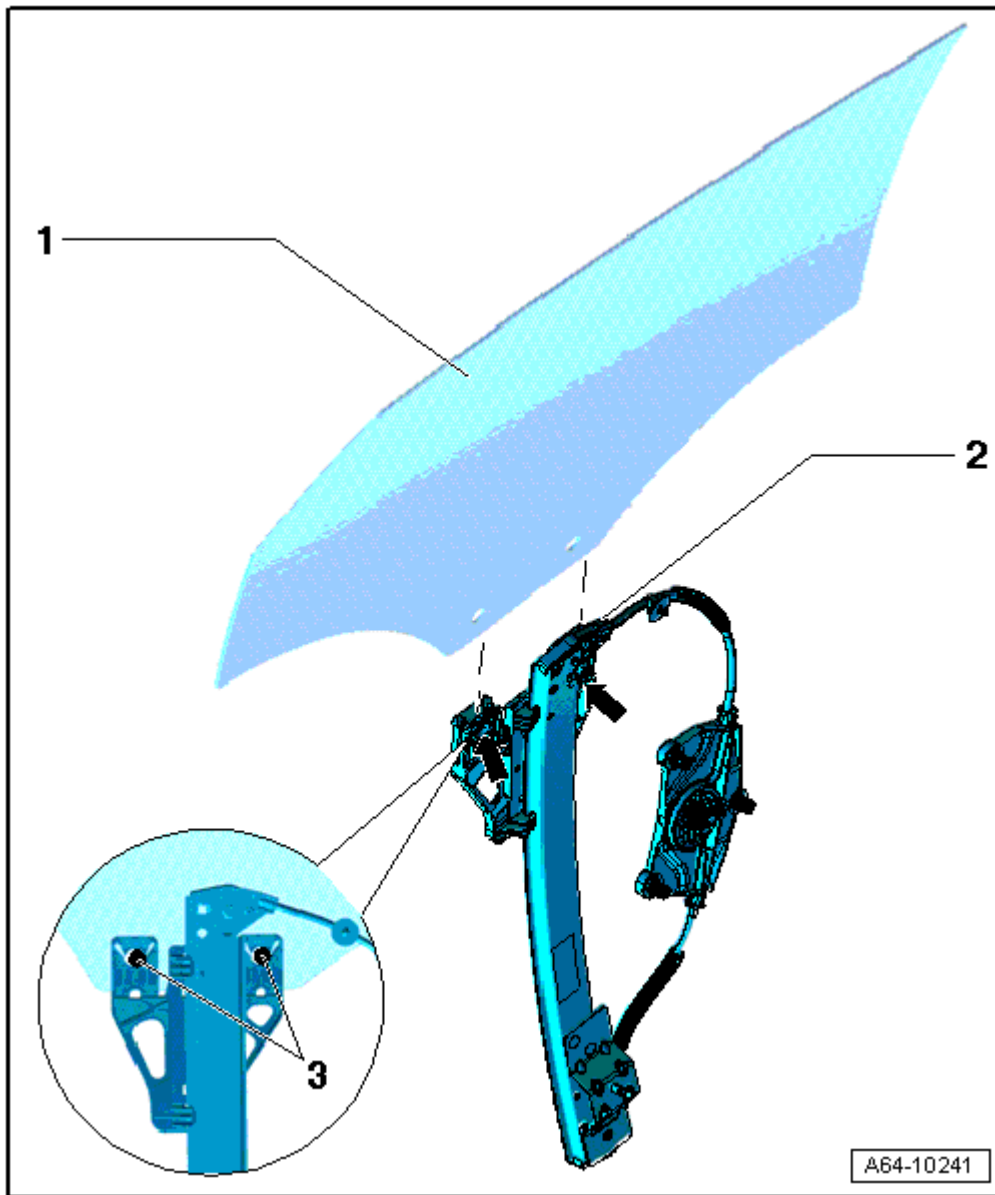


Fig. 58: Identifying Rear Door Window Components

Courtesy of AUDI OF AMERICA, LLC

1. Door Window

- Door trim removed. Refer to **Removal and Installation** .
- Loosen the door window frame trim near the C-pillar trim. Refer to **Removal and Installation** .
- C-pillar trim removed. Refer to **REAR B-PILLAR AND C-PILLAR TRIM** .
- Remove the door panel. Refer to **DOOR INNER PANEL COVER** .
- The power window motor and speaker are removed.
- Lower the door window into the removed position, refer to item 1.
- Push the clamping pins through the bolts and push the expanding sleeve through the glass.
- Tip the window slightly to the rear inside the door and lift it up and out.

- Installation occurs in reverse order.
- 2. Window Regulator
- 3. Bolts
 - Two-part
 - The bolts can be re-used.

SPECIAL TOOLS

Special tools and workshop equipment required

- Window Repair Kit VAS 1993 or VAS 6092



Fig. 59: Identifying Glass Repair Kit VAS 6092
Courtesy of AUDI OF AMERICA, LLC

- Cutting Tool Kit VAS 6452

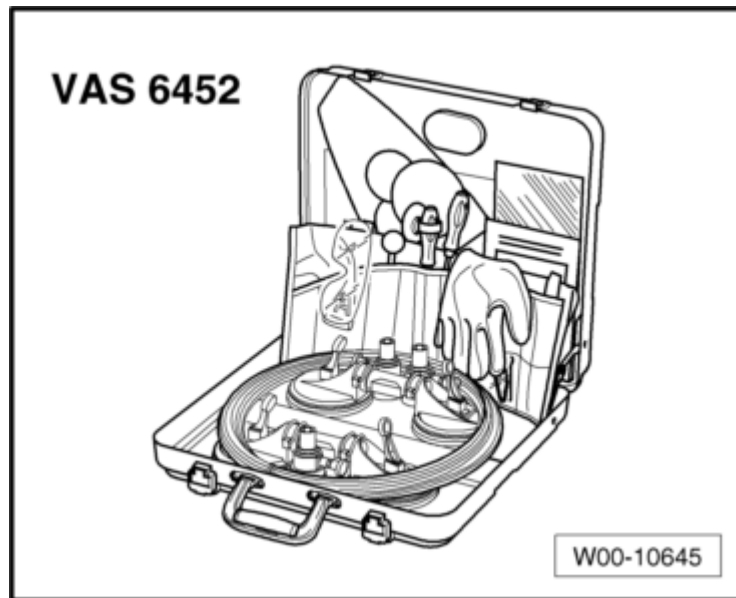


Fig. 60: Identifying Cutting Tool Kit VAS 6452
Courtesy of AUDI OF AMERICA, LLC

- Wire Spool VAS 6452/1

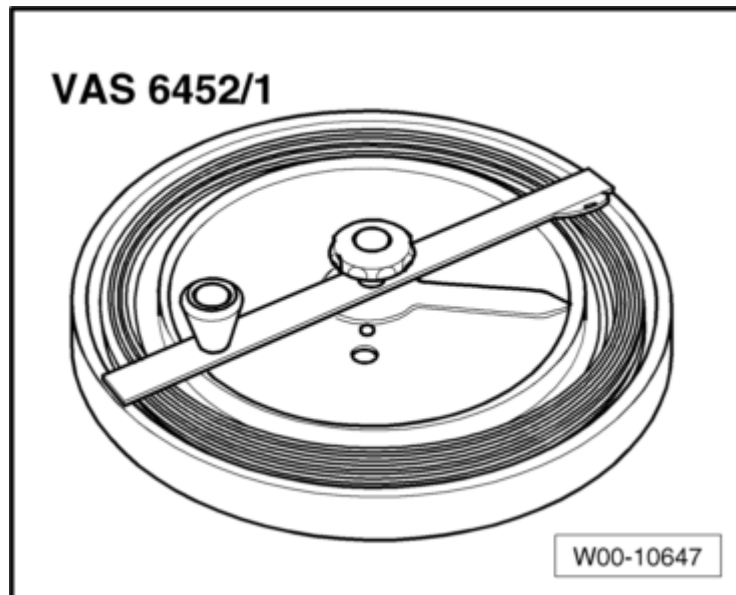


Fig. 61: Identifying Wire Spool VAS 6452/1
Courtesy of AUDI OF AMERICA, LLC

- Cutting Tool Kit Wire VAS 6452/2
- Cutting Tools For Glass V.A.G 1351

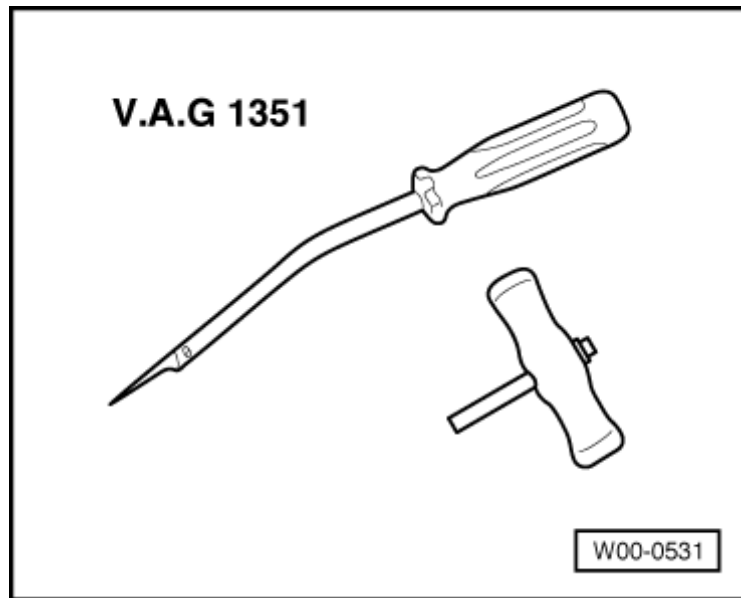


Fig. 62: Identifying Cutting Tool V.A.G 1351
Courtesy of AUDI OF AMERICA, LLC

- Pull Handle V.A.G 1351/1
- Suction Lifter V.A.G 1344

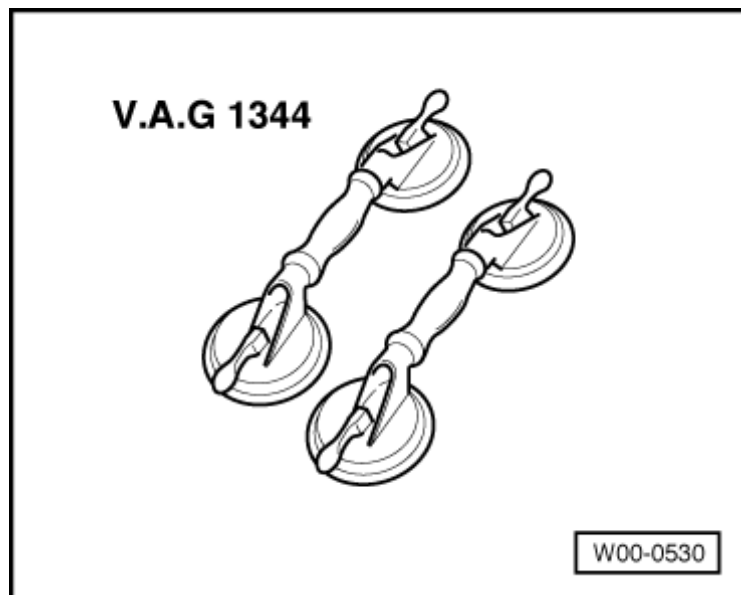


Fig. 63: Identifying Suction Lifter V.A.G 1344
Courtesy of AUDI OF AMERICA, LLC

- Electric Cutter V.A.G 1561A

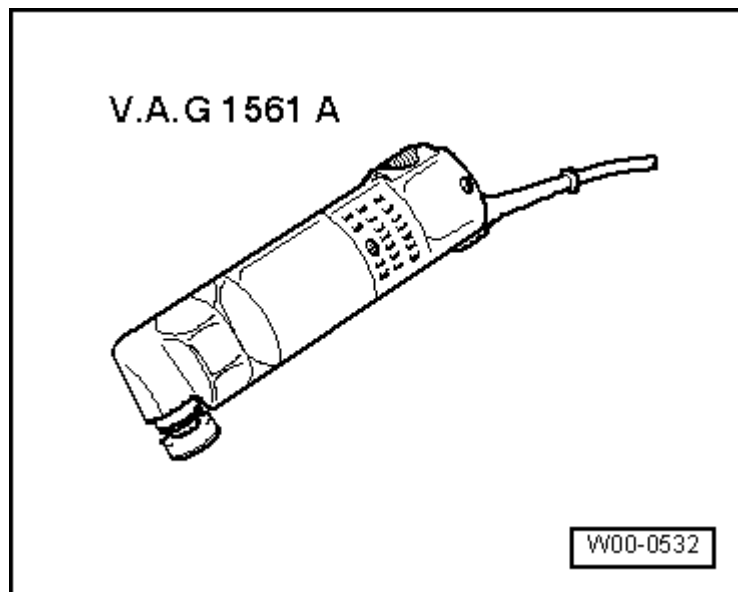


Fig. 64: Identifying Electric Knife V.A.G 1561 A
Courtesy of AUDI OF AMERICA, LLC

- Angled Blade V.A.G 1561/10

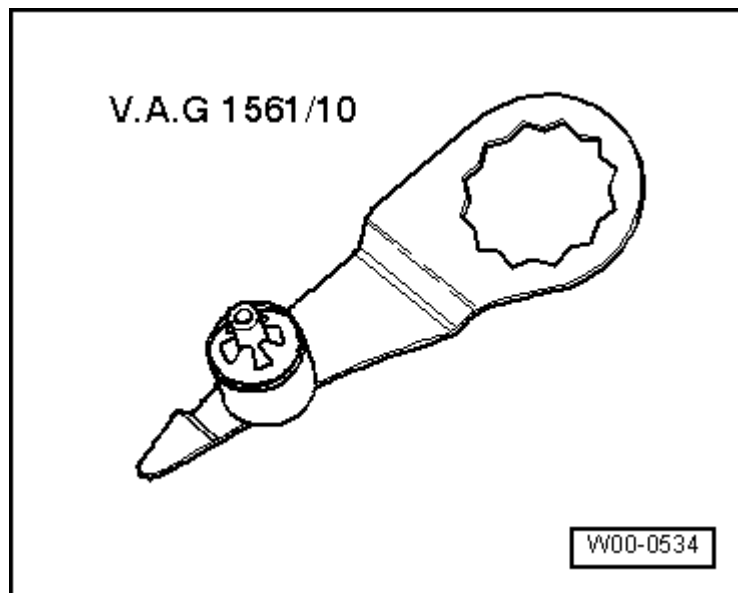


Fig. 65: Identifying Angled Blade V.A.G 1561/10
Courtesy of AUDI OF AMERICA, LLC

- Universal Cutting Blade V.A.G 1561/11

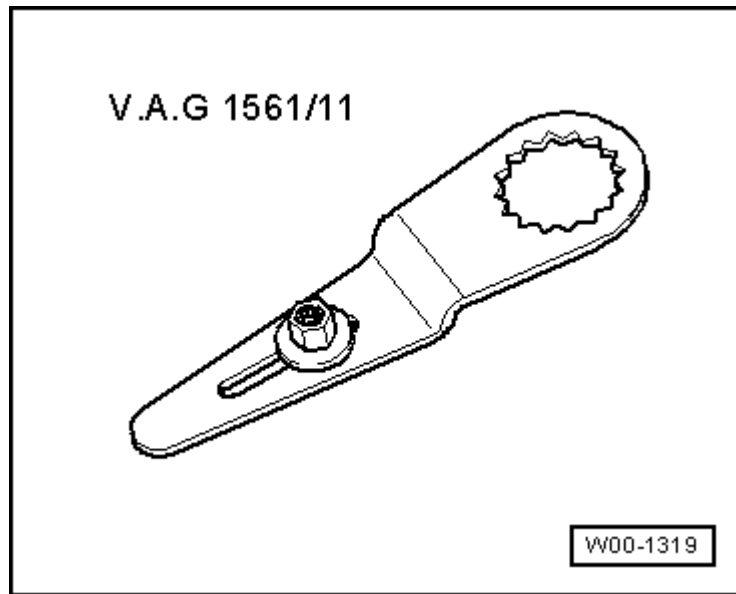


Fig. 66: Identifying Universal Cutting Blade V.A.G 1561/11
Courtesy of AUDI OF AMERICA, LLC

- Scraper (15+25 mm) V.A.G 1561/7+8

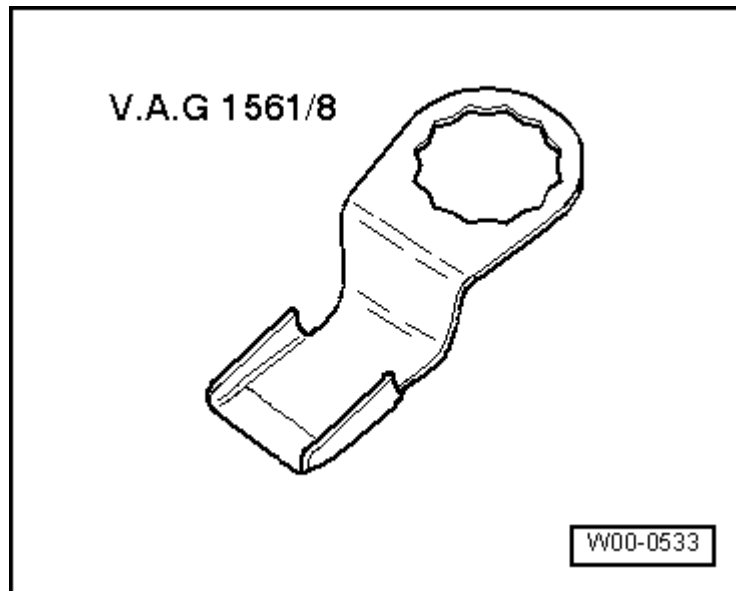


Fig. 67: Identifying Scraper (15+25 mm) V.A.G 1561/7+8
Courtesy of AUDI OF AMERICA, LLC

- Double Cartridge Gun VAS 5237

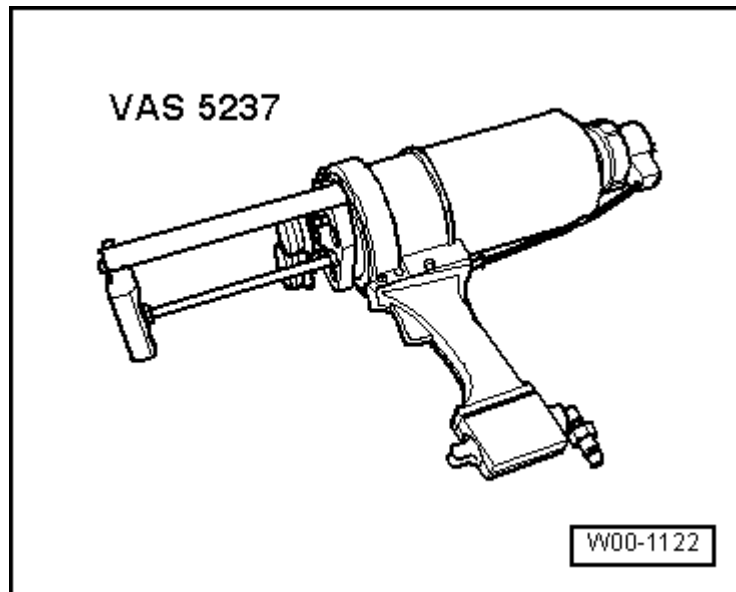


Fig. 68: Identifying Double Cartridge Gun VAS 5237
Courtesy of AUDI OF AMERICA, LLC

- Cartridge Gun V.A.G 1628

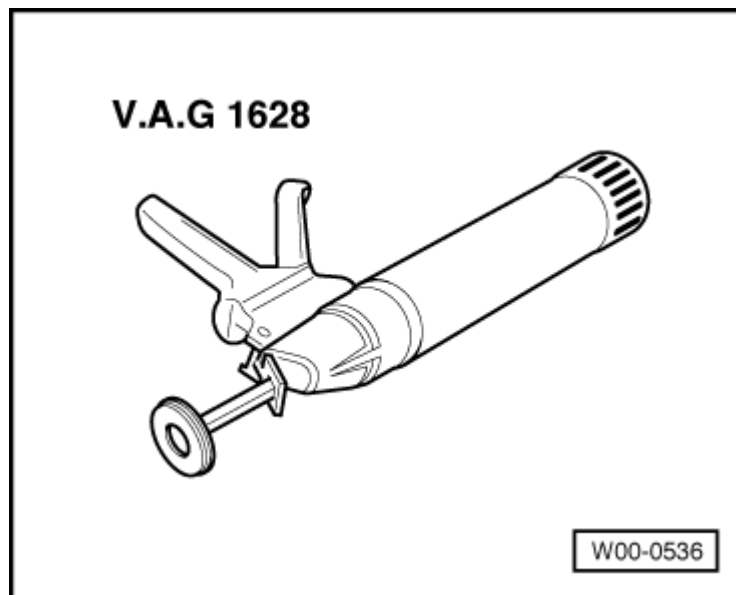


Fig. 69: Identifying Cartridge Gun V.A.G 1628
Courtesy of AUDI OF AMERICA, LLC

- Cartridge Heater V.A.G 1939A

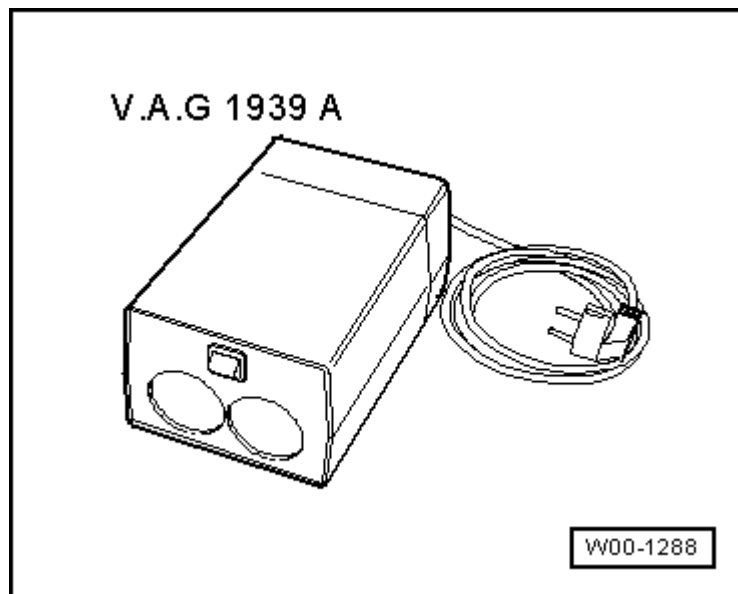


Fig. 70: Identifying Cartridge Heater V.A.G 1939A
Courtesy of AUDI OF AMERICA, LLC