

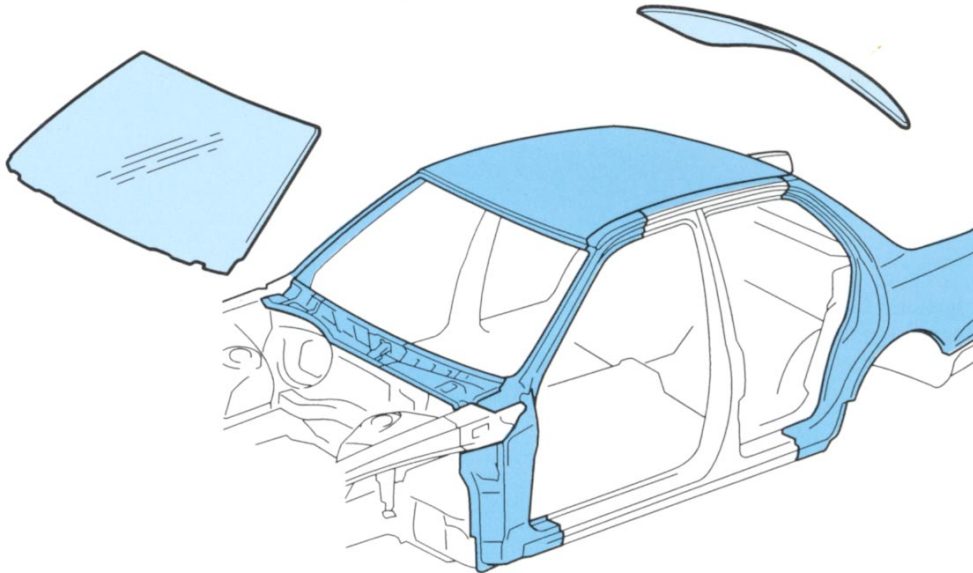
# COLLISION REPAIR INFORMATION

## FOR THE TOYOTA DEALER

TITLE: WINDSHIELD AND FIXED GLASS BONDING PAGE 1 OF 2  
SECTION: EXTERIOR BULLETIN #127  
MODELS: ALL TOYOTA & LEXUS  
DATE: MAY 2003

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During windshield and fixed glass removal or replacement, it is crucial to follow proper installation procedures. These specific procedures are outlined in Toyota and Lexus model-specific repair manuals. The manuals provide detailed instructions and illustrations for removal and installation procedures for windshields, backlights and other fixed glass.



**Note:** Proper glass bonding procedures and materials are fundamental to occupant safety and are essential in order to restore the vehicle to OEM standards and meet Federal Motor Vehicle Safety Standards (FMVSS).

**PLEASE ROUTE THIS BULLETIN TO YOUR COLLISION REPAIR CENTER MAN-  
AGER AND COLLISION REPAIR TECHNICIANS**

**Replacement Information**

The following recommendations are provided as *supplemental information to model-specific Repair Manual* documented procedures.

- **Technicians performing glass installations should be well trained and/or certified in glass installation methods. If training is needed, glass installation courses are available through I-CAR or through the National Glass Association (NGA).**
- **Always inspect glass opening bonding surface for damage or corrosion that may negatively impact proper glass installation.**
- **Consult manuals and disassemble as recommended for removal.**
- **Cover interior and exterior panels and components to protect them from glass and bonding debris.**
- **Remove glass making sure not to damage painted finishes.**
- **Body filler materials should NOT be used on bond surfaces.**
- **Apply a two-part epoxy primer to properly prepared bare metal on the bonding surface and allow to dry.**
- **Test fit replacement glass.**
- **Clean, prep, and prime glass as required by adhesive manufacturer.**
- **Select proper urethane adhesive with an American National Standards Institute (ANSI) minimum lap-shear strength rating of 500-750 PSI.**
- **Apply urethane bead to glass as specified (width and height) and set glass.**
- **Vacuum or blow (with low pressure air) to clean debris from interior and air ducts and then re-assemble.**
- **Allow recommended cure time for urethane bond before delivering vehicle.**
- **Always use OEM or manufacturers approved replacement glass and equivalent bonding materials.**