

## Fitting instructions

Follow these instructions carefully, to achieve the correct result

Handling precautions:

- Refer to the safely data sheets supplied by the manufacturer for the correct handling and storage of the primer and PU.
- Do not inhale fumes.
- Avoid contact with skin and eyes.
- Wear protective gloves and glasses  
Primer is inflammable. - Keep away from sources of ignition fire.
- Take note of safety measures for working with chemicals in general.

## Preparation of the aperture.

1. Remove the windscreen according to vehicle manufacturers Instructions.
2. Remove any dirt lodged between the sealing strip and the aperture, using cloth, towel or solvent (Not alcohol).
- 3 Cut back the remaining PUR bead on the aperture to a thickness of 1-2 mm
4. Any damage to the aperture must be coated with glass and paint primer.

Note:

- Bare metal apertures must be primed with glass and paint primer. Allow drying time or flash off for at least 10 mins

## Preparation of the windscreen:

1. Remove silicone contamination on the frit with a suitable silicone remover.
2. Clean the glass and remove residue of the silicone remover with a suitable glass cleaner. Take particular care round the black ceramic border of the windscreen.
3. Shake the glass and paint primer vigorously for about 1min after loosening the steel ball in the bottle.

4. Apply the glass and paint primer to the cleaned ceramic border in one layer with a felt applicator. Please allow at least a drying or flash off time of 10 mins

`Keep primed surface clean, do not touch after priming.

#### Bonding:

1. Apply the adhesive evenly on either the primed ceramic border on top of the remaining cutback PUR on the aperture.
2. Fit the windscreen using suckers or a one man lifting device. Don not fit using bare hands in case of contaminating the edge off the frit.
3. Refit trims and other parts.
  - a. Do not slam the doors in case of pressure building up resulting in the screen moving.

#### Note:

- Adhesives react to humidity. Final joint strength is obtained only after complete hardening, which relies on temperature and air humidity.
- Note the safe drive away time for HT917 is one hour after installation of the glass.

Attention correct result is only achieved by using a silicone contamination remover, glass cleaner and glass and paint primer with this system.

For non-standard applications, contact your supplier for advice

The manufacturer of this system accepts no responsibility for injury or damage unless the instructions are fully complied with.