

A. Roadster

**Data**

---

Rim for primer on windshield	Width: 10 mm
------------------------------	--------------

---

**Conventional tools**

---

Syphon	e.g. made by Karl Assfalg KG Buchstr. 149 D-7070 Schwäbisch Gmünd order No.: 602-2
Removing tool (Glas-Ex and cutting wire)	e.g. made by Manfred Herrmann Johann-Sebastian-Bach-Str. 6 D-8023 Pullach im Isartal order No. 58 671 Glas-Ex order No. 58 672 cutting wire filling-up package 200 m

---

**Note**

---

The rear window on model 107 can be glued-in with varying glueing materials: Solbit, Betaseal or Butyl.

**Solbit:** Solbit is an electrothermically fully curing synthetic rubber profile with inserted heating wire.

**Characteristics:** Firm glueing compound, inserted heating wire. This material has been used in series production.

**Betaseal:** Betaseal is a pumpable polyurethane single-compound adhesive compound for making very firm, but elastic connections.

**Characteristics:** Permanently elastic glueing compound, without heating wire. This material is included in repair package 107 586 03 67 available up to now.

**Butyl:** Butyl is a permanently elastic adhesive molding with inserted heating wire (adhesive cord).

**Characteristics:** Permanently elastic glueing compound, with heating wire. This material is included in repair package 126 586 00 67.

Prior to removing glass, check in accordance with characteristics named above which type of glueing material has been used for installation. For removal, use method fitting the respective adhesive material.

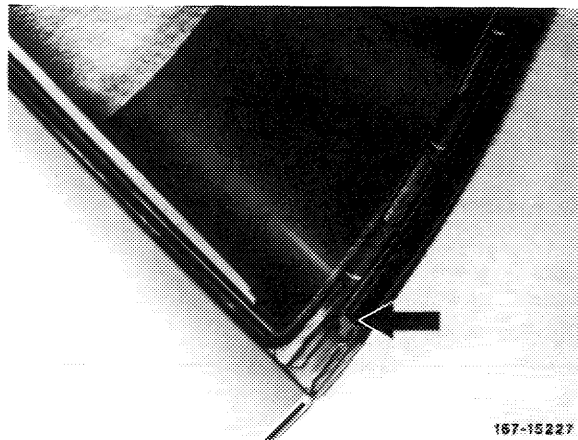
- Removal with cutting wire (Solbit and Betaseal).
- Removal by heating resistance wire (Butyl).

## Removal with cutting wire

---

1 Remove ornamental frame on rear window (68–560).

2 Remove rubber molding (arrow).



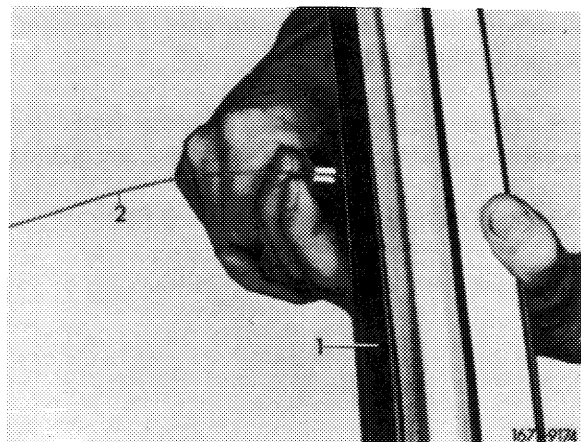
3 Remove reveal molding in range of rear window (68–420 and 425).

4 To avoid damaging paintwork, cover painted surfaces on rear window cutout with adhesive tape.

5 Cut off cutting wire to approx. 900 mm.

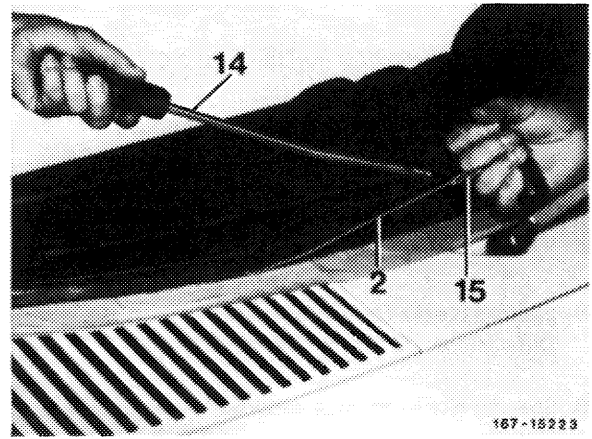
6 Introduce cutting wire (2) on long removing tool (14) laterally into end of handle and clamp down with knurled nut. Guide cutting wire (2) at lower end through bore in outward direction (Fig, refer to item 8).

7 Stick end of cutting wire (2) with pliers from inside through adhesive cord (1) (if possible, close to flange).



8 Thread other end of cutting wire at short handle (15) and clamp down with knurled screw.

9 Tension cutting wire (2) inside with removing tool (14).



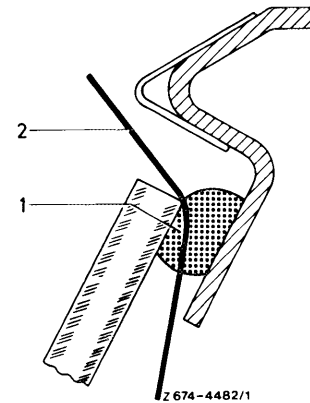
Shown on windshield

10 Let a second person pull on short handle and cut adhesive cord (1), while guiding cutting wire (2) in such a manner that the glass edge is not damaged. If required, push cutting wire (2) at cutting edge against body flange by means of a wedge. Cut carefully at glass corners in steps of 10 mm.

11 Remove rear window.

12 Mechanically clean body flange by means of a wooden or plastic wedge.

**Note:** When using removed glass again, clean likewise.



#### Removal by heating-up resistance wire

---

##### Note

---

The rear window is glued to body by means of an adhesive cord. For removal and installation of a rear window, the adhesive cord is converted into a plastic condition by heating. This is done best by connecting the copper wire located in center of adhesive cord to a source of electric energy. Such a source is a well charged 12-volt vehicle battery.

The heating-up period of the adhesive cord generally amounts to approx. 15 minutes for a wire dia. of 0.3 mm. At the end of this period, the adhesive cord has a temperature of approx. 50°C in connection range of copper wire. This temperature is enough for removing the glass free of damage.

The following factors are influencing the heating-up period:

- a) Diameter of copper wire: 0.3, 0.4, 0.7 mm (the thicker, the shorter the heating period).
- b) Aging of adhesive cord (the older, the longer the heating period).
- c) Temperature of glass and body (the colder, the longer the heating period).
- d) Condition of glass (glass already damaged can be pushed out by applying increased force after a short heating-up period).

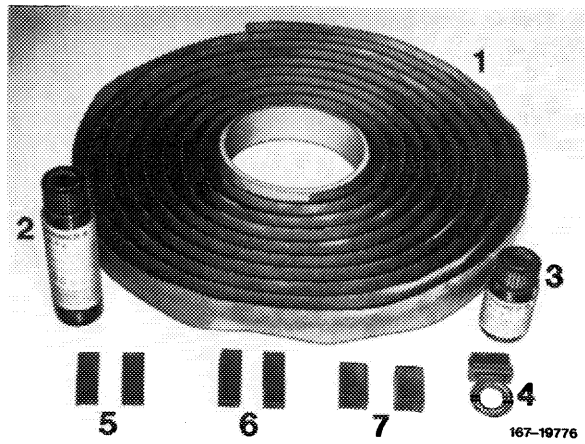
Replacement of rear window glass requires kit for glazing, part No. 126 586 00 67.

The contents of the repair kit are selected for use both on model 126 and on model 107.

**Contents of repair kit:**

1. Adhesive cord, 4200 mm long,  $10 \pm 0.7$  mm dia.
2. Glass bottle with primer, component part A.
3. Glass bottle with primer, component part B.
4. Sponge for applying primer.
5. Spacing blocks for windshield.\*  
Dimensions: 30 mm x 10 mm x 3.5 mm.
6. Spacing blocks for side window.\*  
Dimensions: 30 mm x 10 mm x 6 mm.
7. Spacing blocks for rear window.\*  
Dimensions: 20 mm x 13 mm x 10 mm.

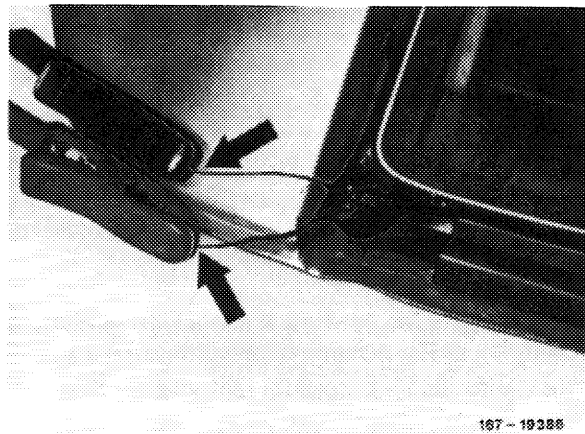
\* These parts are required for model 107 only.



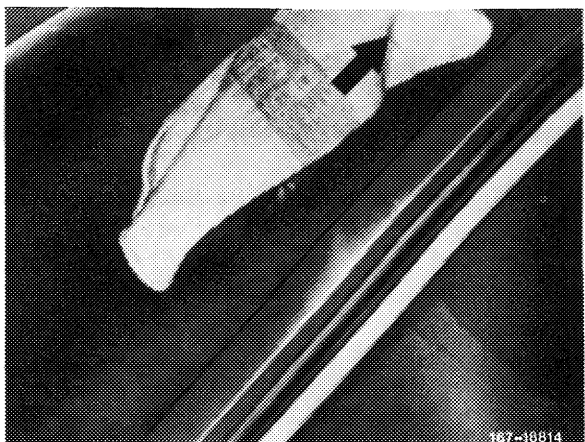
1 Remove ornamental frame on rear window (68–560).

2 Expose copper wire in adhesive cord on rear pillar left bottom and bare ends with emery paper.

3 Connect copper wire to vehicle battery (12 V) (connection should result in a spark to start current flow). Heat copper wire of 0.3 mm dia. for approx. 10 minutes.



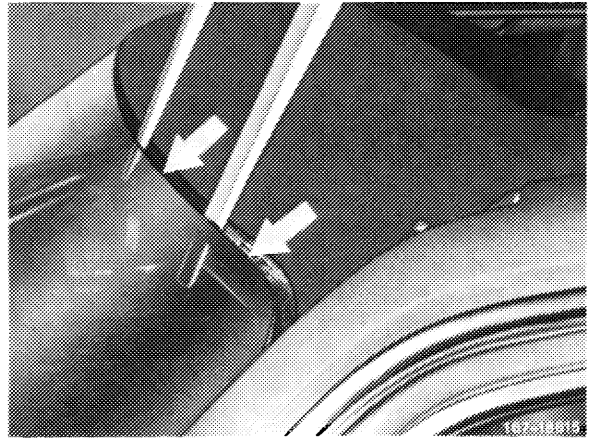
4 Push glass in upper range outwards (e.g. with foot).



Shown on model 126 windshield

5 Insert assembly wedges into gap established between glass and body.

Shown on model 126 windshield

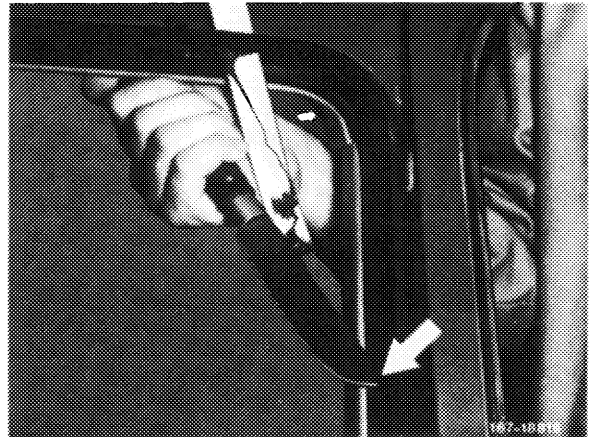


6 Carefully cut all-around through adhesive cord by means of an industrial knife, while inserting additional assembly wedges at cut spots to prevent renewed glueing down.

7 Remove rear window.

8 Disconnect vehicle battery.

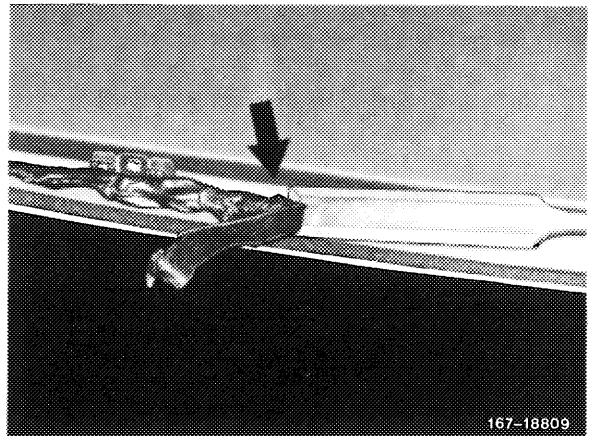
Shown on model 126 windshield



### Installation

9 Remove remains of adhesive cord from body flange by means of a scraper or the like, while making sure that the paintwork is not damaged.

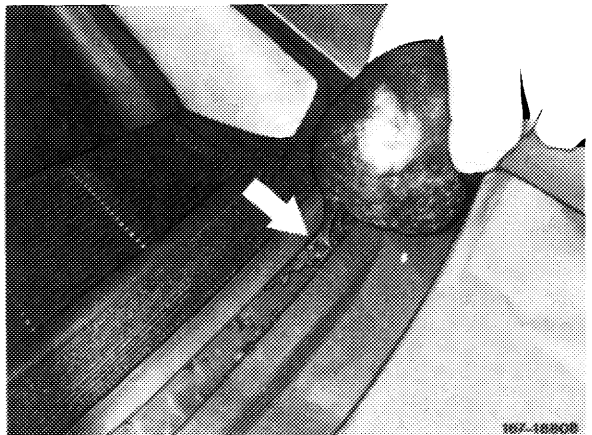
Shown on model 126 windshield



10 If Butyl has been used for the previous job, glue cut-off adhesive cord into a ball and dab the remaining adhesive on body flange with ball.

**Note:** When the removed windshield glass is used again, clean in a similar manner.

Shown on model 126 windshield



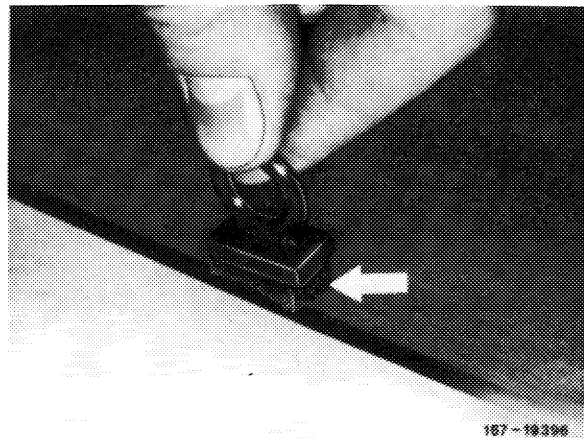
11 Clean adhesive surface on body flange and on rear window with benzine.

12 Check body flange for damage to paintwork, if any, and touch up, if required (pay attention to drying time).

13 Mix primer from repair kit. For this purpose, fill contents of small bottle with component B into large glass bottle with component A and shake energetically.

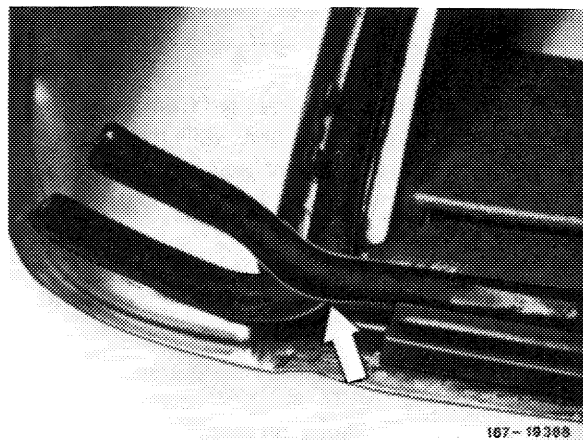
14 Apply primer to rear window and body flange with coating sponge from repair kit. Width of primer rim approx. 10 mm.

**Note:** Air-dry primer for 5 minutes.



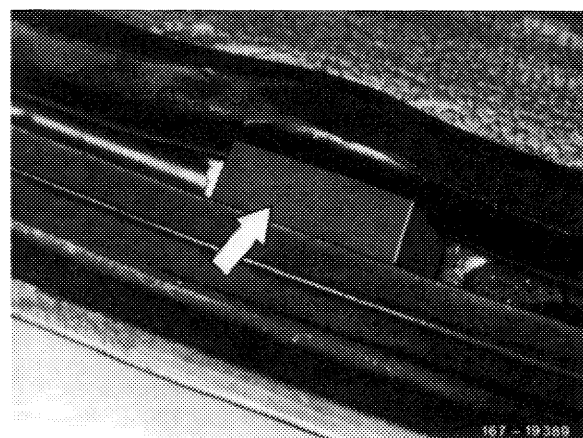
15 Place adhesive cord from repair kit into center of body flange. Start at rear pillar bottom left.

16 Cut off remaining length of adhesive cord.



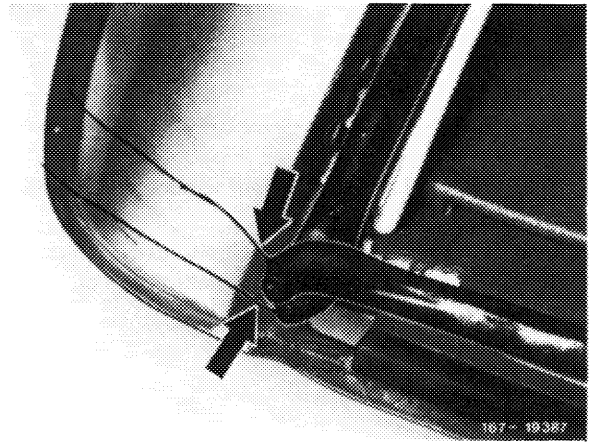
17 Insert two spacing blocks (7), 20 mm x 13 mm x 10 mm, from repair kit into lower channel.

18 Taper adhesive cord in range of spacing blocks so that the glueing compound cannot be visibly pushed out in upward direction when applying pressure to glass.



19 Expose copper wire at end of adhesive cord and bare.

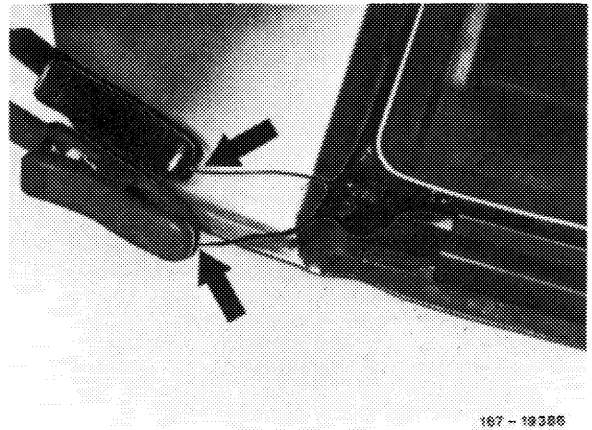
20 Center rear window and place on adhesive cord.



21 Connect vehicle battery (12 V) at both wire ends and heat-up adhesive cord. Push-in glass uniformly and mount ornamental frame. (The immersion depth is determined when the ornamental frame is fitted).

22 Disconnect vehicle battery.

23 Place wire ends of adhesive cord into gap between glass and rear pillar (do not cut off).



24 For further installation proceed vice-versa.

**Note:** Glueing requires no drying time. The rain test can be made at end of assembly jobs. Any leaks can be sealed by means of MB universal sealing compound, part No. 003 989 01 71 (tube) or 002 989 98 71 (cartridge).

## B. Coupe

### Removal

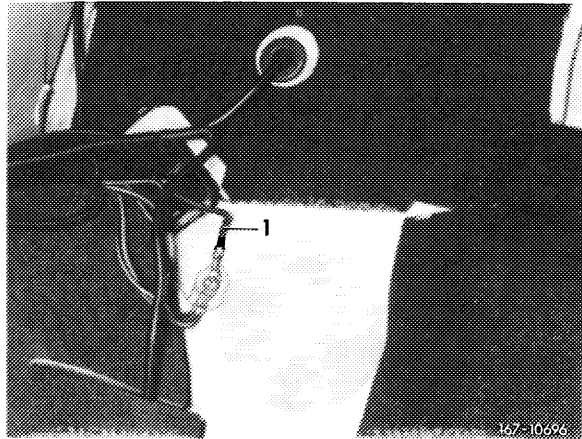
---

1 Remove reveal molding on rear window (68–410).

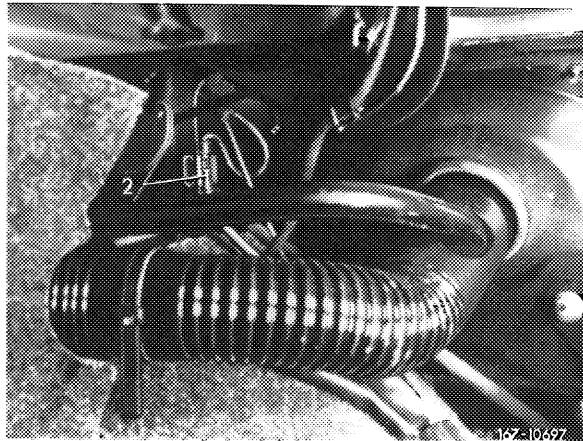
2 Loosen rubber frame inside vehicle with a plastic wedge and push back behind spot-weld flange of window cutout.

3 If rear window is heatable, remove rear seat and rear seat backrest (91–170).

4 Unscrew ground cable (1) on rear wall at the right and slip-through into trunk.



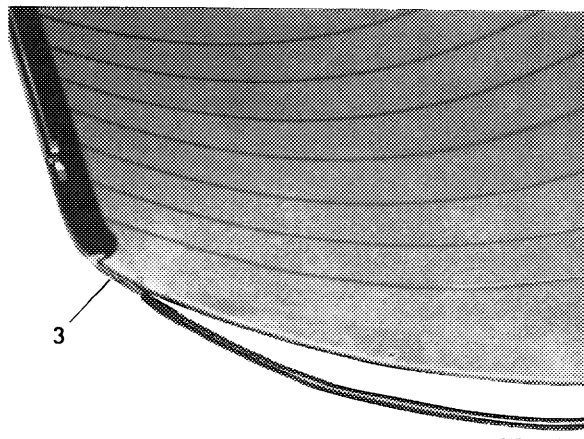
5 Disconnect positive cable on coupler (2) (accessible from trunk).



6 Push rear window from inside carefully in outward direction and remove.

7 Remove ornamental frame on rear window (68–575).

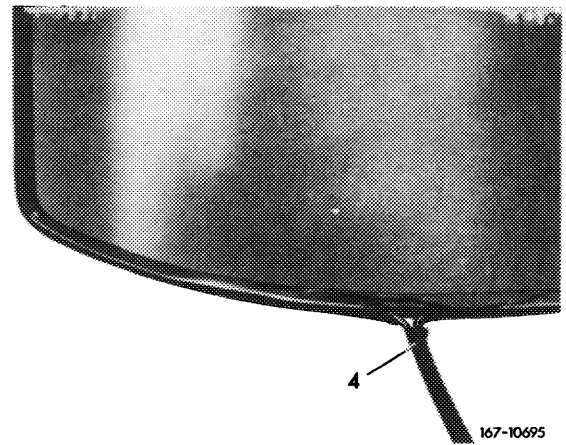
8 Remove sealing frame from rear window.





**Attention!**

When removing sealing frame from a heatable rear window, make sure that the lateral contact rails (3) for single-pane safety glass or the contact wires (4) for compound glass are not broken off.



167-10695

**Installation**

---

- 9 Place rear wall window with crown in downward direction on a pertinent support.
  - 10 Mount sealing frame to rear window.
  - 11 Insert two greased cords into holding slot of sealing frame and coat sealing frame with glycerin or tallow.
  - 12 Insert pre-assembled rear window including sealing frame from outside into window cutout and align.
  - 13 Then install rear window under slight pressure, while simultaneously — using a helper — lifting the rubber lip of the sealing frame beginning from **below** over spot-weld flange of window cutout, while carefully pulling-out greased cord.
- Note:** Pull cord always in parallel with glass to prevent damaging rubber lip.
- 14 Seal with MB glass sealing compound, part No. 001 989 31 20, between glass- and sealing frame, as well as between spot-weld flange and sealing frame.
  - 15 For further installation proceed vice-versa.