

COLLISION REPAIR INFORMATION

FOR THE COLLISION REPAIR PROFESSIONAL

TITLE: GLASS REPLACEMENT

SECTION: EXTERIOR BULLETIN #127

MODELS: ALL TOYOTA, LEXUS and SCION

DATE: REVISED MARCH 2013

During glass installation or replacement it is critical to follow proper procedures. Removal and installation procedures are provided in model-specific repair manuals. Procedures provide detailed information and illustrations for removal and installation of all OEM glass.

Note: Proper stationary glass bonding procedures and materials are fundamental to occupant safety and are essential to restore the vehicle to OEM standards.

The following precautions and recommendations are provided as a supplement to Repair Manual information:

- Technicians performing glass installation should be trained and certified by an accredited organization. Training and Certification is available through AGRR (The Automotive Glass Repair & Replacement Safety Council), and training through I-CAR (The Inter-Industry Conference on Automotive Collision Repair).
- OEM glass is the only recommended replacement for stationary and moveable glass.
- When removing stationary glass do not damage painted surfaces.
- Closely inspect stationary glass openings and bond surfaces, and repair any paint damage that may lead to corrosion with a high-quality two-part epoxy primer.
- Body filler materials should NOT be used on bond surfaces.
- Apply a high-quality two-part epoxy primer to properly prepared bare metal bond surfaces.
- Bond surfaces should NOT be refinished with color and clear coat.
- Use a urethane adhesive with an ANSI (American National Standards Institute) lap-shear strength rating of 500-750 PSI.
- Allow adhesive to cure fully before vehicle operation or delivery.

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