

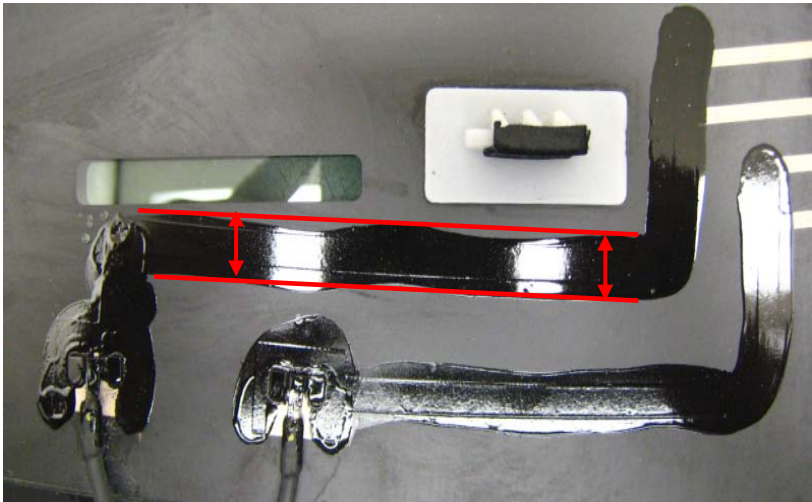
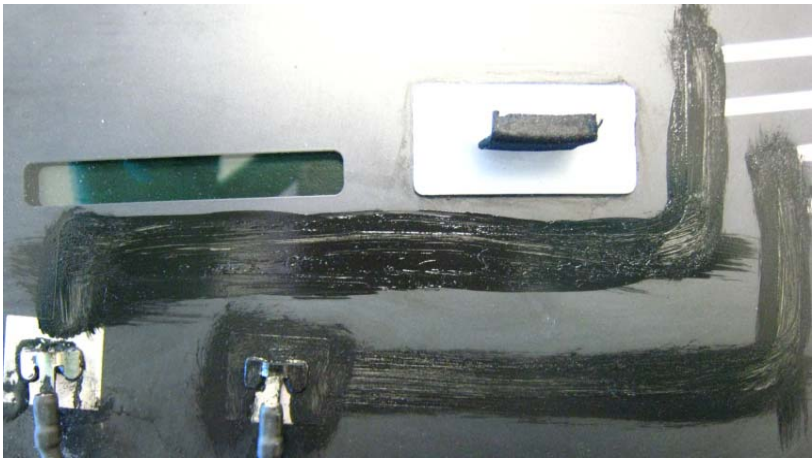
	GROUP Electrical	MODEL Sorento (XM)
	NUMBER PS168	DATE March 2011
 TECHNICAL OPERATIONS		
SUBJECT: SORENTO (XM) WINDSHIELD INSTALLATION - PRIMER APPLICATION WHEN EQUIPPED WITH DE-ICER GRID		

During replacement of the windshield glass the de-icer grid must be coated with a specific primer (DOW Betaprime 5500). Failure to properly insulate the de-icer grid may result in a cracked windshield. Please follow these detailed instructions during the installation to prevent future concerns.

This information should be provided to the glass installer **prior to the start of work**; Repeat repairs for the same condition (insufficient primer application) are subject to warranty claim chargeback

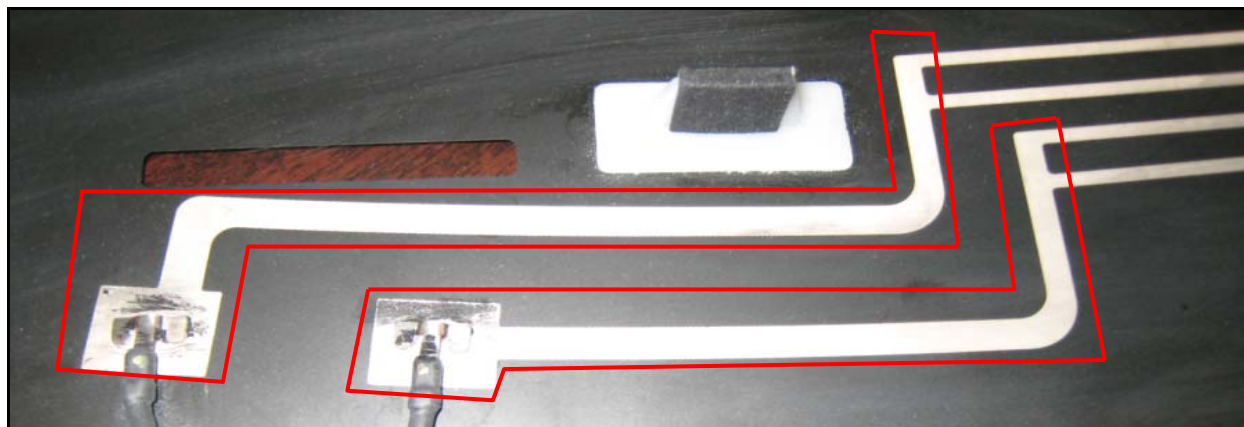
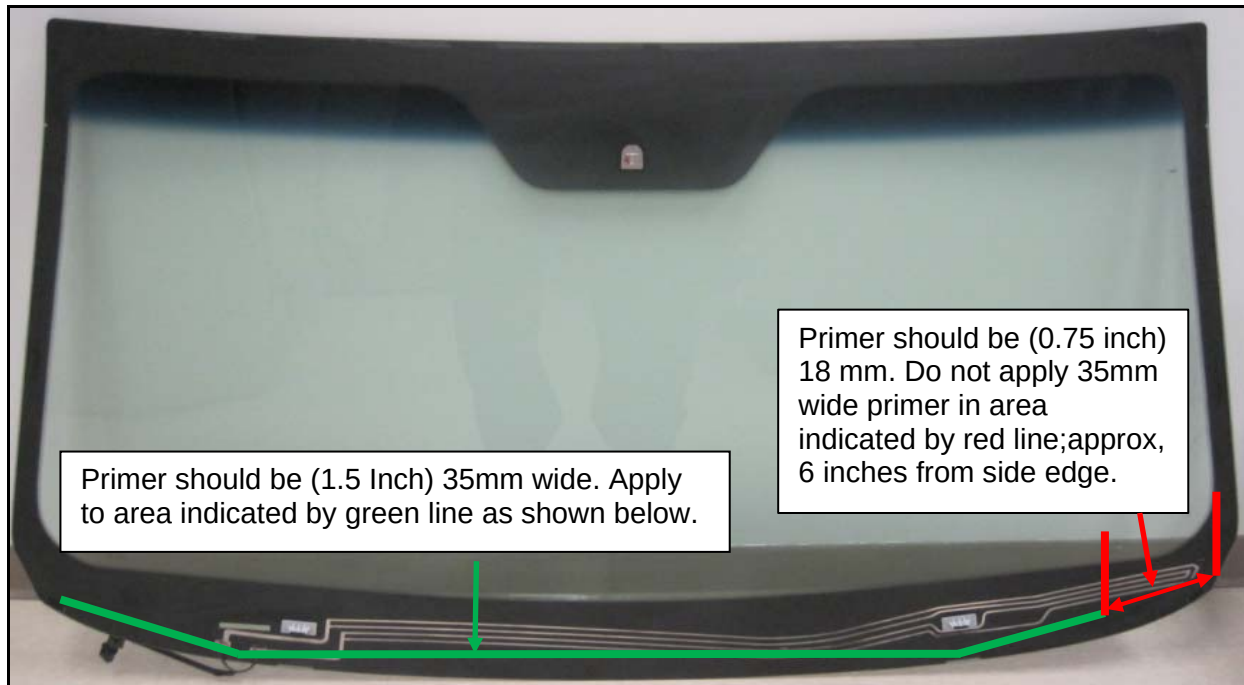
Use standard labor time guide for replacement time.

Part Name	Part Number	Remarks
Glass Assy- W/Shield	86110 1U060	
DOW Chemical Betaprime (Contact : Dow Chemicals; 1-800-453-3779, or http://www.dowautomotive.com/locator/locator.htm)	Beta prime 5500	

Sample Photos	Judgment
	Good Application <u>(No visible bare spots or brush marks)</u> VIN window is not covered
	Poor Application <u>(Visible spots/brush marks)</u> Make sure to keep primer away from VIN window

Installation Procedure:

1. Remove rear view mirror from windshield and remove the windshield from the vehicle.
2. Obtain replacement windshield (86110 1U060) and position on clean flat surface for primer application.
 - a. Shake Betaprime 5500 primer for at least one (1) minute before application.
3. Prime one (1) layer entire windshield perimeter with DOW Betaprime 5500 if not using primer less Urethane. Allow a minimum of six (6) minutes for primer to dry and then apply a second layer of primer in the areas shown below. Also allow a minimum of six (6) minutes for second layer of primer to dry.



Apply two layers of primer to de-icer terminal area as indicated by red lines. See photo for application area.

The primer must be applied in a manner to prevent direct contact between the urethane and deicer element. The primer should also be consistently applied with no bare spots or brush marks that allow the deicer element to be visible beneath the primer as shown in table above.

4. Ensure no primer covers VIN opening.
5. Allow primer to dry a minimum of six (6) minutes.
 - a. Apply urethane on entire edge per windshield installation process.
6. Install windshield per installation procedure and ensure VIN plate is visible.