

### All Models – Updated Primer Substance and Application Guidelines For Glass Installation/ Windshield and Glass Roof (USA, ONLY)

#### Vehicles Affected

Models	Model Year	Model Type	VIN Range	Vehicle-Specific Equipment
All models	All	All	N/A	N/A

#### Revision History

Revision	Release Date	Changes
0	May 29, 2025	Original document

#### Condition

Due to regulatory changes in the United States, only, the primer substance used for glass installation changed as well. Therefore, effective immediately, the instruction contained herein shall be used in conjunction with the existing workshop manual instruction. Until further notice, in the event of any conflicting information, this document shall take precedence.

#### Technical Background

The existing workshop instructions must be modified in accordance with manufacturers' requirements to ensure adequate bonding of the primer and adhesive for operational/fatigue strength. To this end, please heed the changes highlighted below when following the corresponding workshop instructions for the desired application of the primer and adhesive. Present development work is underway to hopefully minimize the curing times required below.

## Advanced Technical Information

Bulletin #: 2514

Part ID: 6006,6040,6412

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### Service Information



*Information: In order to meet the quality requirements for bonding processes, the bonding process described in these processing instructions must be documented. For this reason, a bonding log must be prepared every time the described adhesive is used, which can then be provided for verification purposes whenever required. Ref: 5X00IN08 Bonding Log*

In all applications of the primer, please refer to the following modifications:

1. After application of the primer on the marked areas (as noted by the current, respective workshop instruction), **allow the primer to dry for 30 minutes**. A maximum drying time of 8 hours for the primer must not be exceeded.
2. After application of the adhesive and installation of the windscreen, the adhesive and primer require a **curing time of at least 96 hours at 23 °C (≈ 73.4 °F)**. The vehicle must remain stationary during this curing time, prior to operation of the vehicle.

Applicable Parts:

Part Number	Description
<b>PAD181220*</b>	<b>Primer</b>
PAD004660	2K Pane Adhesive
D 181802M1	Activator
D 00940104	2K Cleaning Solution
9A700950000	Adjusting Tool

**Table 1 – Bill of Adhesive Materials for 2K Adhesive**

\*Affected Part Number

### Search Items

2K adhesive, 2k windshield adhesive, primer, windscreen, windshield, glass roof, roof panel, primer curing

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