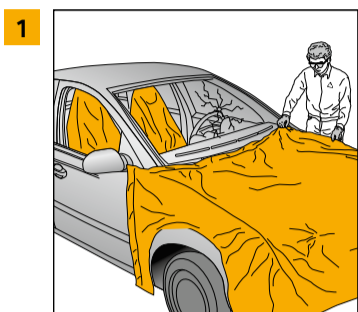
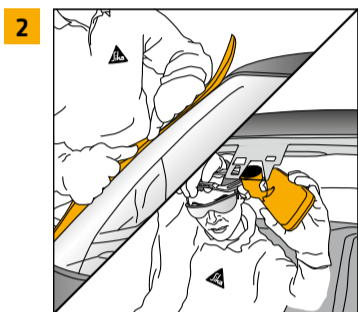


# CLEAR AKTIVATOR PROCESS

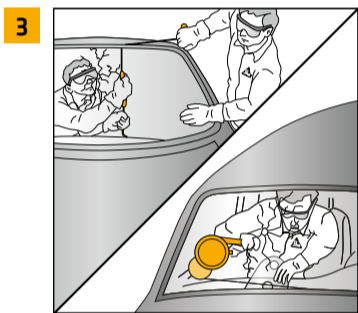
## Sika® Aktivator PRO: WIPE ON ONLY AUTO GLASS REPLACEMENT INSTALLATION GUIDELINE



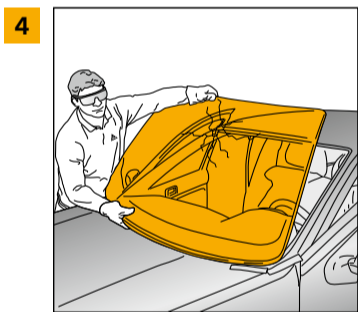
- Wear personal protective equipment
- Cover parts to be protected
- Use seat covers



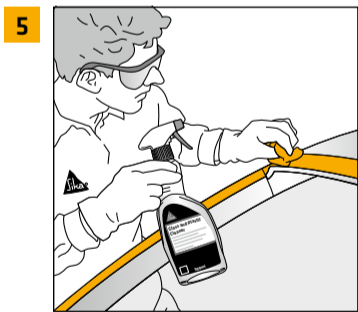
- Carefully remove all trims and accessories
- Carefully remove ADAS related sensors and cameras



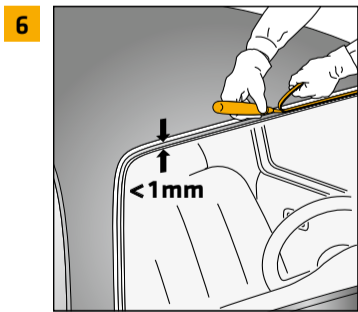
- Cut out damaged windshield using Sika® SmartCut, electrical knife, cutting wire, cold knife etc.
- Remove dirt with a vacuum cleaner or brush



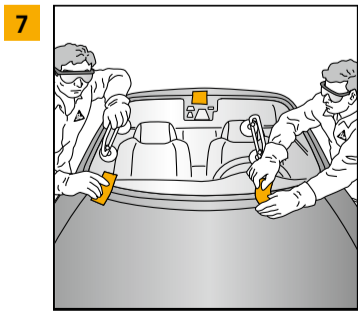
- Remove the damaged windshield



- Remove debris with a vacuum cleaner or brush
- Clean the entire pinch weld with Sika® Cleaner G+P or another suitable glass cleaner, making sure the surface is completely dry and no moisture remains



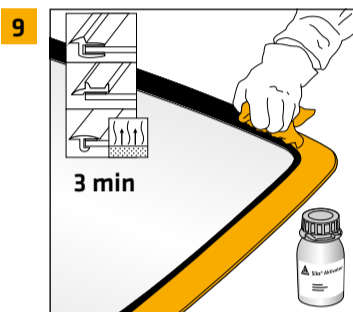
- Trim back the remaining PUR bead and try to cause as little damage as possible
- The remaining PUR must be under 1 mm before it is safe to apply fresh adhesive



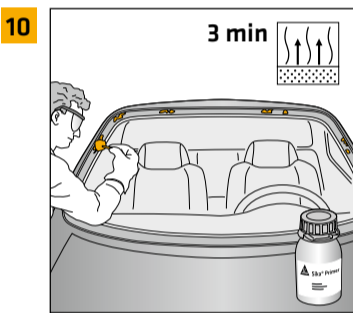
- Dry fit the windshield
- To ensure a quick and precise installation of the windshield once the adhesive is applied, add fitting marks



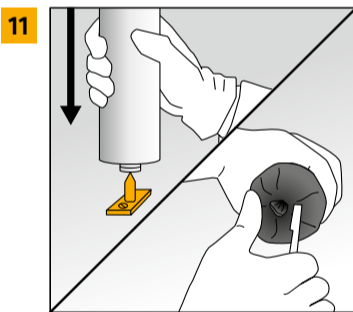
- Clean the windshield with Sika® Cleaner G+P or another suitable glass cleaner and check for contamination
- If contaminated, scrub the bonding surface with Sika® Cleaner PCA
- Wipe the window dry with a paper towel



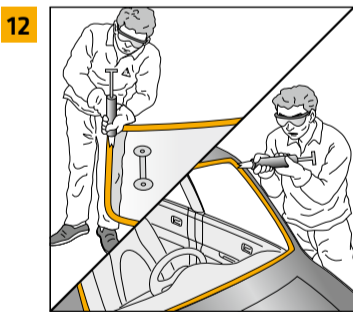
- Wet a lint free tissue with Sika® Aktivator PRO
- Wipe the bonding surface of the glass
- Tightly close the can immediately after use
- Allow to flash-off for at least 3 minutes



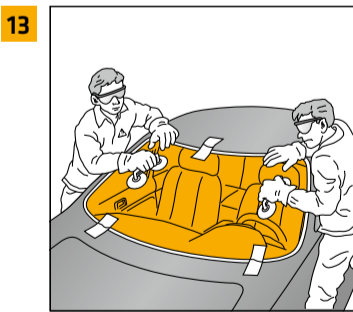
- Cover any minor damage to paint work using Sika® Primer-507
- Tightly close the can immediately after use
- Allow to flash-off for at least 3 minutes
- In case of larger areas, contact a paint shop or refer to the car manufacturer's specification



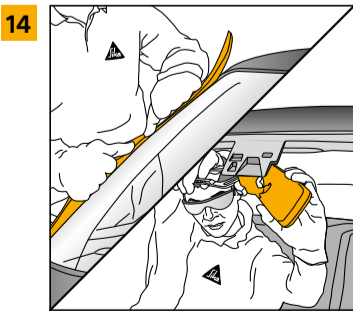
- Cartridge: open by piercing the membrane
- Unipack: open by simply slicing the end of the unipack approx. 1 cm between the clip and the shoulder. Avoid the foil weld
- PowerCure: charge the Dispenser, no need to open manually



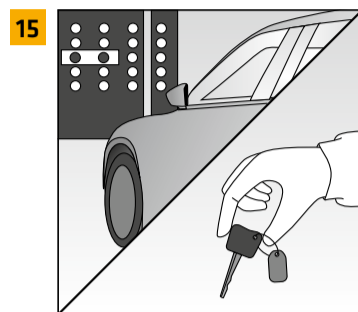
- Prepare a "V" noched nozzle that has the same height as the pinch weld mounting surface and the roof of the car
- Apply a triangular bead of adhesive either to the glass or the pinch weld
- It is important that the adhesive matches both the activated surface on the glass and the fresh cut bead of urethane



- Place the windshield in position within the open time of the adhesive
- Caution:** the open time may be significantly shorter at elevated temperature



- Remount trim and moldings so that they fit properly, secure all cowlings under the bonnet and affix wipers
- Ensure that all dismantled parts are installed correctly
- Refit and rear-view mirror and check if all ADAS related sensors and cameras work correctly



- Conduct and record ADAS recalibration according to OEM specification
- Record all batch numbers on job card to insure full traceability
- Complete paperwork and hand back keys to customer after the minimum safe drive away time is achieved



### BONDING SURFACE

Float Glass and Ceramic coated Glass<sup>a</sup>

Fresh Cut Bead

Bare Metal Scratch < 5 cm<sup>2</sup>

Bare Metal Scratch < 150 cm<sup>2</sup>

Intact OEM Paint

Repair Paint (after complete curing of paint)<sup>b</sup>

PVC/RIM Encapsulation, Pre-applied Adhesive System<sup>b</sup>

Pre-applied OEM Primer

PC / PMMA glass<sup>c</sup>

● Sika® Aktivator PRO

● Sika® Primer-507 (Sika® Primer-207 can be used as an alternative)

### SURFACE PREPARATION STEPS

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<sup>a</sup> Windshield must be clean of dirt and dust. Potential contamination must be removed by wet scrubbing with Sika® Cleaner PCA

<sup>b</sup> Scuff surface

<sup>c</sup> Anti Scratch Coating must be removed prior to use, scuff surface (only for temporary glazing, UV-protection required)

**Our most current General Sales Conditions shall apply. Please consult the most current local Product Data Sheets prior to any use.**