

## Window Glass - Rear Quarter, 4-Door

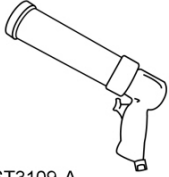
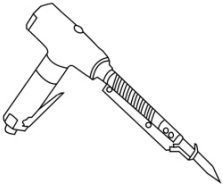
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**WARNING:** Before beginning any service procedure in this section, REFER to [Safety Warnings](#). Failure to follow this instruction may result in serious personal injury.

## Special Tool(s)

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Illustration	Name	Number	TKIT Number
 ST3109-A	Air Gun	AST405	-
 ST3274-A	Deluxe Air Knife	300-AST1770E	-

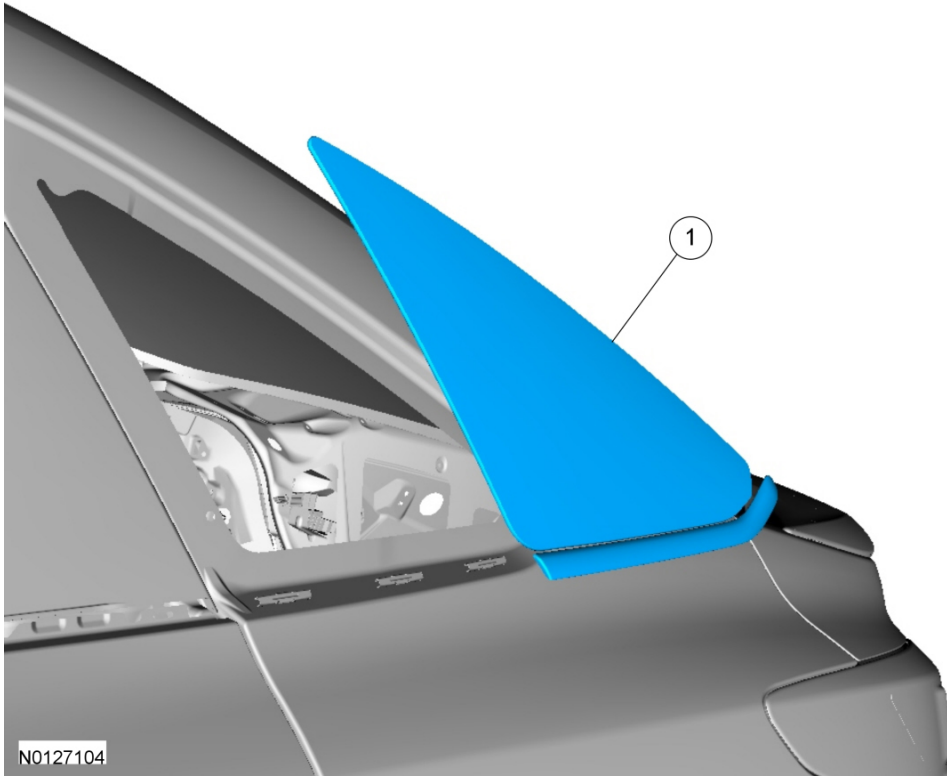
## Material(s)

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Name	Part Number	Ford Specification	Fill Capacity/Quantity
Dow Urethane Adhesive	Betaseal™ Express	-	-
Dow Urethane One Step Glass Primer	Betaprime™ 5500 / 5500A / 5500SA	-	-
Sika Urethane Adhesive	Sika Tack ASAP	-	-
Sika Urethane Metal and Glass Primer	Sika 206 G+P	-	-
Motorcraft® Ultra-Clear Spray Glass Cleaner	ZC-23	ESR-M14P5-A	-

## Exploded View

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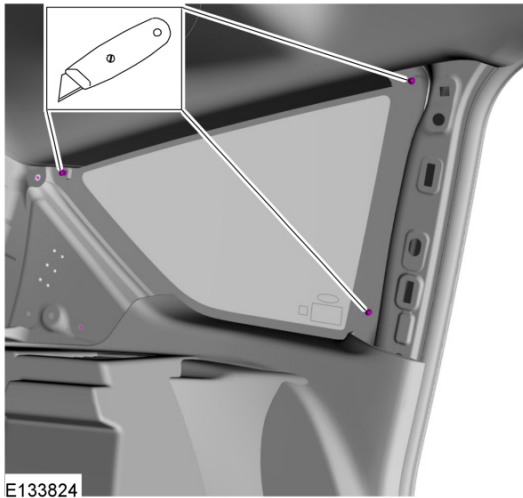
Item	Service Part Number	Description
1	297B00 Right Hand (RH)/ 297B01 Left Hand (LH)	Rear quarter window glass

## Removal

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1. Remove the D-pillar trim panel. REFER to [D-Pillar Trim Panel - 4-Door Sedan](#).
2. Remove the upper quarter glass trim panel. REFER to [Quarter Glass Trim Panel - Upper](#).
3. **NOTE:** Some resistance may be encountered when cutting through the glass locating spacers.

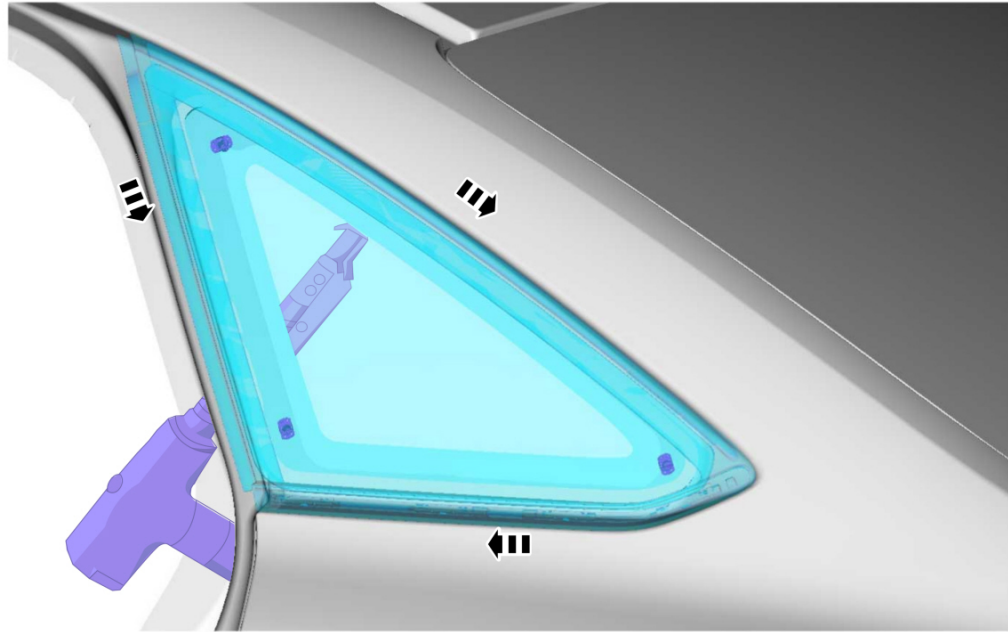
Using a utility knife, cut the glass locating spacers.



4. **WARNING:** Always wear eye protection when servicing a vehicle. Failure to follow this instruction may result in serious personal injury.  
**WARNING:** Wear protective gloves when handling components or parts that have pointed or sharp edges. Failure to follow this instruction may result in serious personal injury.

**NOTE:** Lubricate the existing urethane adhesive with water to aid the Deluxe Air Knife while cutting.


Using the 300-AST1770E and working from inside the vehicle, cut the urethane adhesive from the rear quarter glass starting at the top center and working toward the bottom corners then across the bottom and remove the rear quarter window.



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# Installation

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1. **NOTE:** For additional material guidelines, refer to the manufacturer's installation information.  
Dry fit the rear window glass to the existing urethane adhesive bead on the body pinch weld. Align the rear quarter glass in the opening for a uniform fit.
2. Use a non-permanent pencil to make alignment marks on the rear quarter glass at the setting blocks (if equipped) and the body to aid in the installation alignment of the rear quarter glass.
3. Remove the rear quarter glass and place on a stable surface.
4.  **WARNING:** Repair any corrosion found on the pinch weld. The pinch weld is a structural component of the vehicle. Corrosion left unrepaired may reduce the structural integrity of the vehicle. Failure to follow this instruction may result in serious injury to vehicle occupant(s).

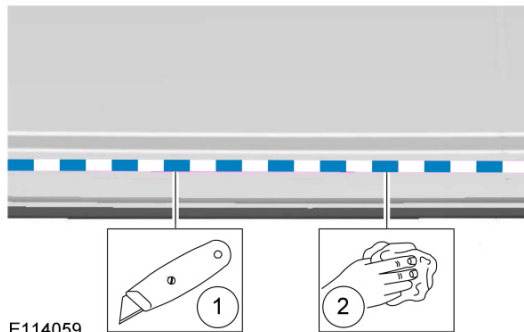
**NOTE:** Avoid scratching the pinch weld. Repair all minor scratches or exposed metal on the pinch weld following manufacturer's instructions. Use the same brand pinch weld primer, glass primer and urethane adhesive.

**NOTE:** Minimum 1 mm (0.04 in) bead thickness.

**NOTE:** Touching the adhesive surface will impair rebonding.

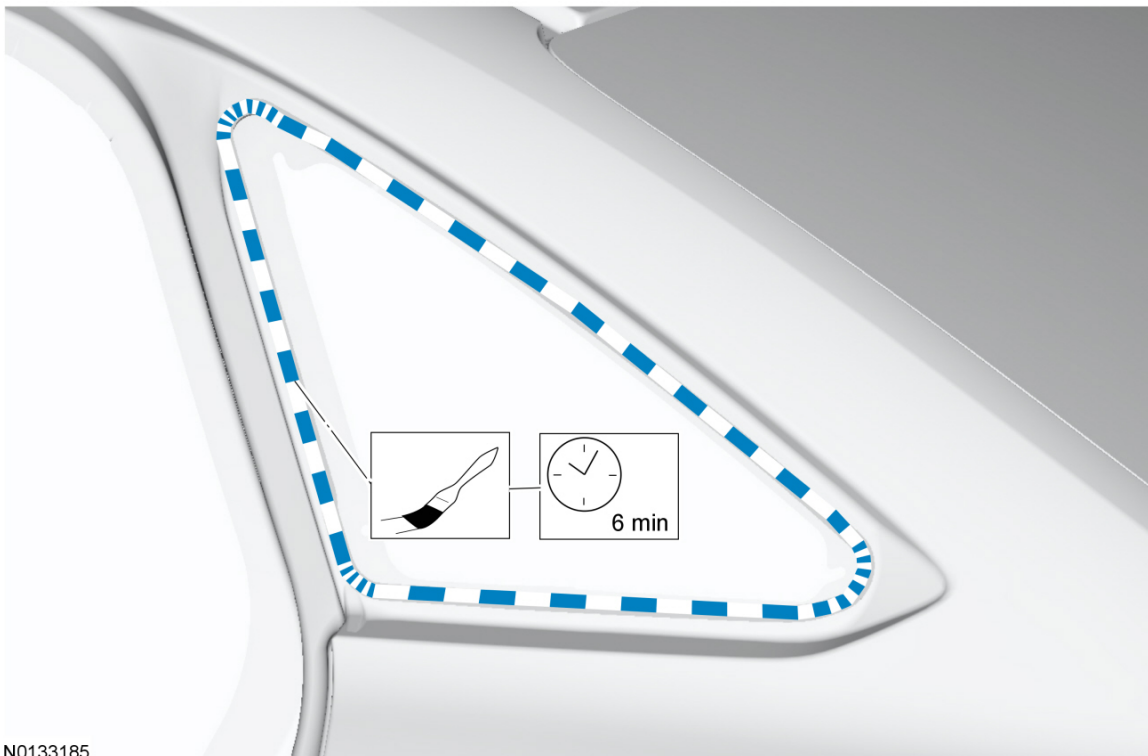
**NOTE:** Make sure that the mating faces are clean and free of foreign material.

Using an appropriate tool, trim the urethane adhesive leaving a 1-2 mm (0.04-0.08 in) base of original equipment urethane adhesive on the pinch weld.

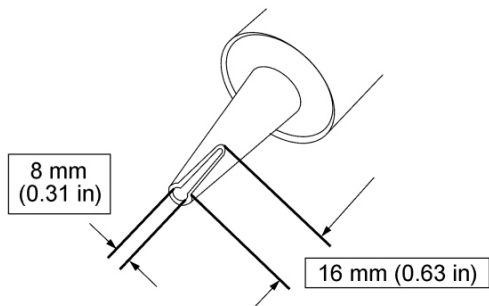


5. Using a soft brush or vacuum, remove any dirt or foreign material from the pinch weld.
6. If installing the original rear quarter glass, remove the excess urethane adhesive.
7. **NOTE:** Be sure to use the same brand and cure-rate products for the urethane adhesive and glass primer. Do not mix different brands of urethane adhesive and glass primer. For additional information, refer to the Material Chart in this procedure.

If installing a new rear quarter glass, apply glass primer according to manufacturer's instructions. Allow at least 6 minutes to dry.

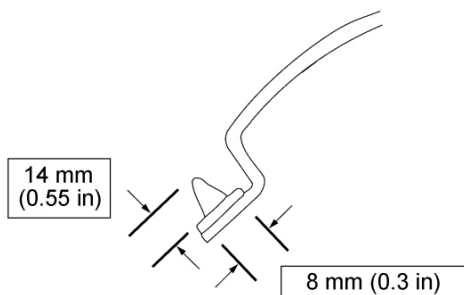


8. Cut the urethane adhesive applicator tip to specification.



9. **NOTE:** Use either a high-ratio, electric or battery-operated caulk gun that will apply the urethane adhesive with less effort and continuous bead.

Apply urethane adhesive on top of the existing trimmed urethane adhesive bead on the pinch weld, starting and ending at the bottom of the rear quarter glass near the center, making sure there are no gaps in the bead.



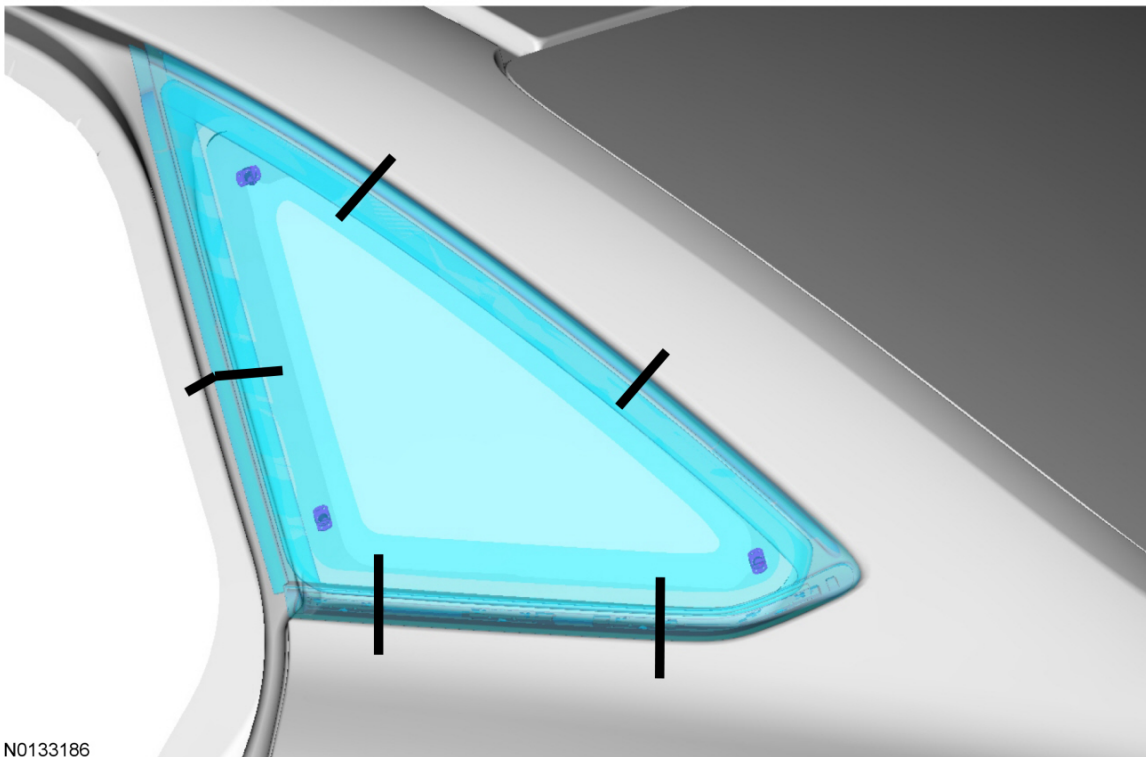
- 10.

1) Press firmly and evenly into position.




2) **NOTICE:** During the curing time of the adhesive, the door windows must be left open.

Using tape, secure the rear quarter glass in the correct position until the adhesive has cured.



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11.  **WARNING:** Do not drive vehicle until the urethane adhesive seal has cured. Follow urethane adhesive manufacturer's curing directions. Inadequate or incorrect curing of the urethane adhesive seal will adversely affect glass retention. Failure to follow these instructions may result in serious injury to vehicle occupant(s).

After the urethane adhesive has cured, check the rear quarter glass seal for air or water leaks through the urethane adhesive bead and add urethane adhesive as necessary.

12. Install the upper quarter glass trim panel. REFER to [Quarter Glass Trim Panel - Upper](#).
13. Install the D-pillar trim panels. REFER to [D-Pillar Trim Panel - 4-Door Sedan](#).