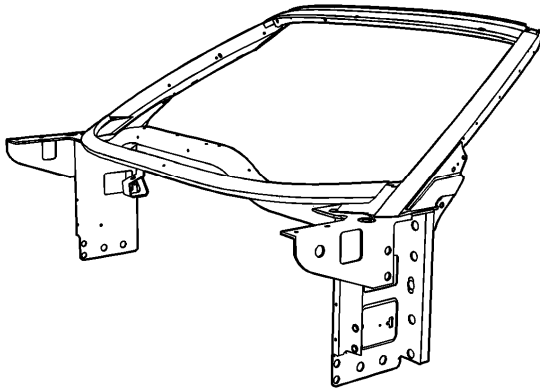


Windshield Frame Replacement

Tools Required

[J 42058](#) Frame Adapter Clamp

Removal Procedure



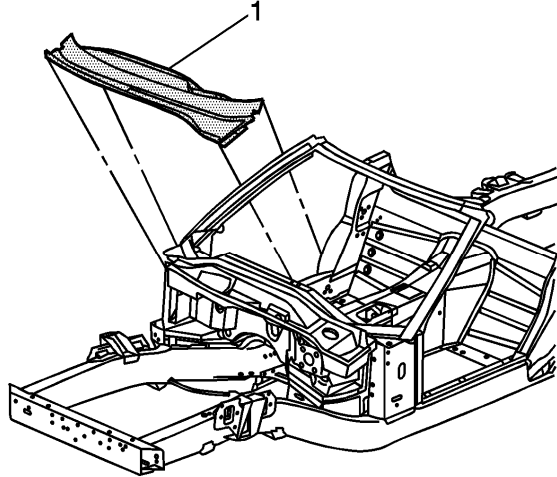
The windshield frame is made of cast aluminum components. The windshield frame is bonded and bolted to the front hinge pillars with structural adhesive. It is also braced to the tunnel assembly by a bolted and bonded cross car beam.

Caution: Refer to [Approved Equipment for Collision Repair Caution](#) in Cautions and Notices.

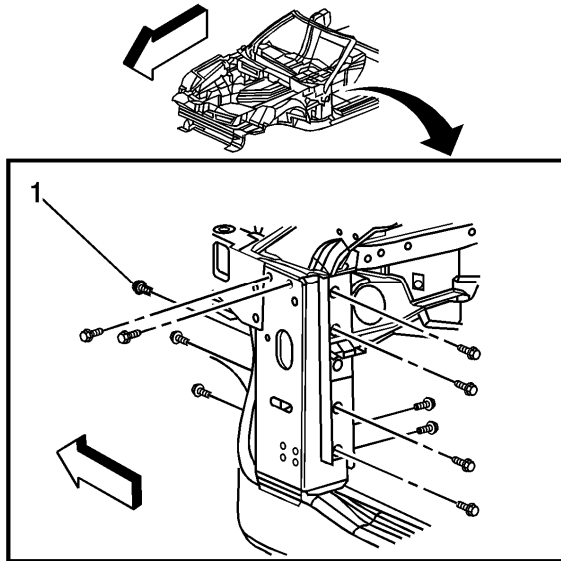
Important: An attempt to repair the windshield frame may compromise the structural integrity of the vehicle. Complete replacement is recommended.

1. Disable the SIR system. Refer to [SIR Disabling and Enabling](#).

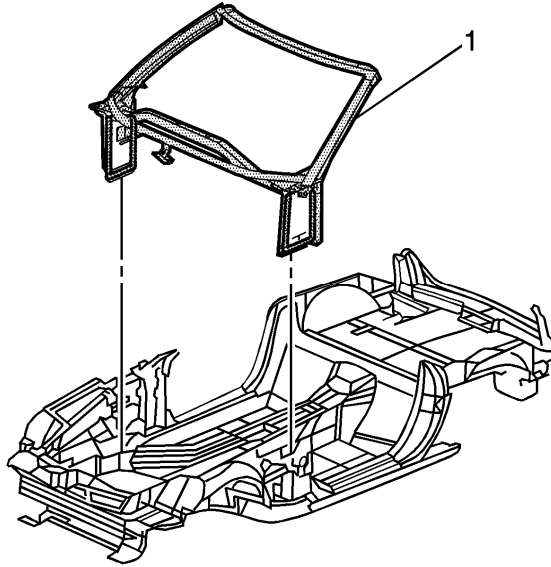
2. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection.](#)
3. Remove all related panels and components.
4. Drill out the close-end rivets securing the upper plenum to the windshield frame.



5. Remove the upper plenum (1) by applying heat and pry to detach the adhesive along the bonding surface.
6. Separate the lower plenum from the windshield frame by applying heat and pry to detach the adhesive along the bonding surface.
7. Remove the bolts attaching the cross-car brace.
8. Remove the cross car brace by applying heat and pry to detach the adhesive along the bonding surface.



9. Remove the bolts (1) attaching the windshield frame to the front hinge pillars.



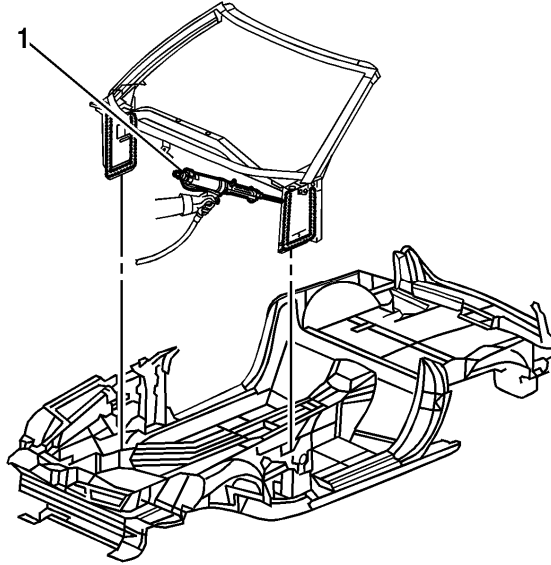
10. Remove the windshield frame (1) by applying heat and pry to detach the adhesive along the bonding surface.
11. Save any and all brackets, mounting studs, and accessories for transfer to the windshield frame.
12. Note the location of the adhesive and remove all remaining loose adhesive.
13. Inspect the structure and frame rails for damage.
14. Repair as much of the damage as possible to the factory specifications.
15. Use [J 42058](#) to secure the vehicle if pulling and straightening is required.

Installation Procedure

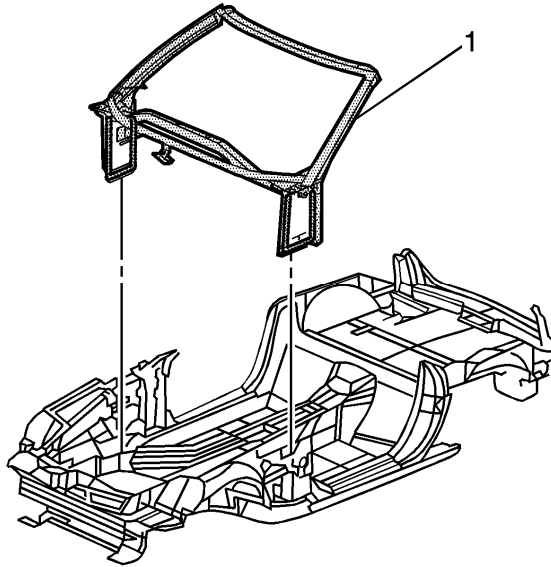
1. Before applying adhesive, dry fit the windshield frame for proper fit and alignment.

Important: DO NOT top coat any bonding surface. Use primer only on bonding surfaces. Refer to adhesive manufacturer's recommendations.

2. Clean and prepare all bonding mating surfaces according to adhesive manufacturer's recommendations.

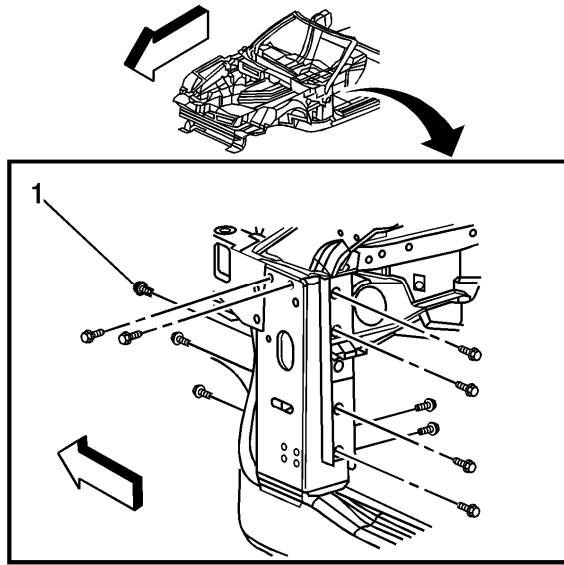


3. Apply a consistent bead of structural adhesive (1) 10 mm (3/8 in) in diameter to the windshield frame to mate with the bonding surfaces. Refer to [Sheet Molded Compound \(SMC\) Panel Bonding](#).



4. Install the windshield frame (1) to the vehicle.

Notice: Refer to [Fastener Notice](#) in Cautions and Notices.



5. Install the bolts (1) that attach the windshield frame to the front hinge pillar.

Tighten

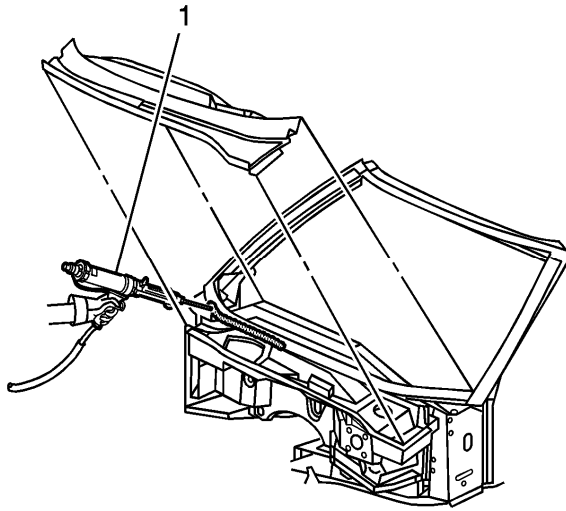
Tighten the bolts to 25 N·m (18 lb ft).

6. Clamp or mechanically fasten the windshield frame into place.
7. Apply structural adhesive to bond the lower plenum to the windshield frame. Refer to [Sheet Molded Compound \(SMC\) Panel Bonding](#).
8. Drill holes and use close-end rivets GM P/N 9418420 to secure the lower plenum to the windshield frame while adhesive cures.
9. Apply the structural adhesive to the area where the cross-car brace bonds to the center tunnel assembly. Refer to [Sheet Molded Compound \(SMC\) Panel Bonding](#).
10. Install the cross-car brace to the vehicle.
11. Install the cross-car brace bolts.

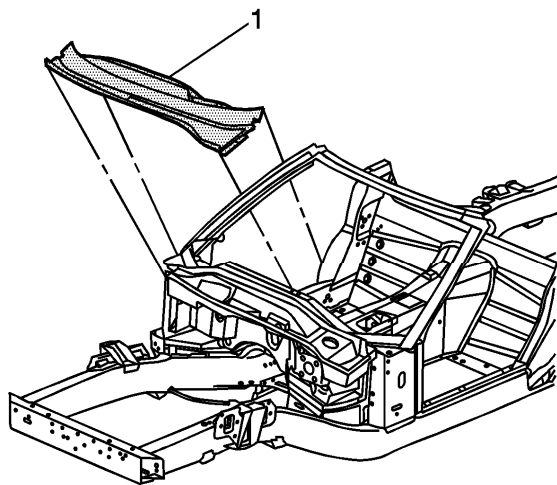
Tighten

Tighten the bolts to 25 N·m (18 lb ft).

12. Install all hardware attaching the instrument panel (I/P) supports to the windshield frame.



13. Apply a consistent bead of structural adhesive (1) to the bonding surfaces to mate with the upper plenum. Refer to [Sheet Molded Compound \(SMC\) Panel Bonding](#).



14. Install the upper plenum (1) to the windshield frame.
 15. Install the close-end rivets GM P/N 9418420, in the factory locations, securing the upper plenum to the windshield frame.
 16. Remove any excess adhesive.
 17. Install all related panels and components.
 18. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnection and Connection](#).
 19. Enable the SIR system. Refer to [SIR Disabling and Enabling](#).
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