

## 2006 Ford Fusion, 2006 Mercury Milan

### Vehicle information



**Vehicle type:** Four-door sedan

**NAGS® numbers\*:** Windshield part number DW1622 solar, bonded and back glass DB10927 solar, heated, bonded, antenna

\*With permission from National Auto Glass Specifications. Call NAGS at 800/551-4012 or visit [www.nags.com](http://www.nags.com).

### A. Windshield

#### Preparation

1. Cover the front seats, floorboards, dash and steering wheel with a clean drop cloth or disposable plastic covers. **Note:** Always wear eye and hand protection when working with glass. Make sure that you have the right glass and moldings, and that the urethane systems you are about to use are current. Windshield part number is DW1622.

2. Grasp the rearview mirror at the base and peel it off the pad. It slides back on for replacement.

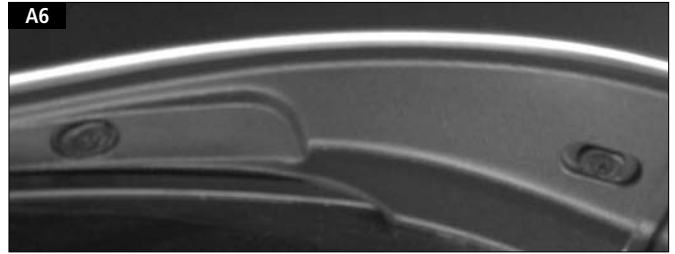
3. Remove the windshield-wiper nut covers using an installation stick. **Note:** The covers are unique to each side. The driver-side wiper is marked DL.

4. Remove the windshield-wiper nuts using a 12-millimeter wrench or socket.

5. Remove the two center sandwich clips of the cowl, two faux Phillips-screw retainers and two 30T Torx screws located in the corners on the leading edge of the panel. Lift and slide the cowl out from under the bottom edge of the glass.

6. There are two fender moldings held in place by two faux Phillips-screw retainers. Remove the retainers and slide the fender moldings out from under the top of the fender.

**Note:** The top of the glass is exposed and has a close tolerance to the roof.



7. The side moldings are a U-channel type and will be damaged upon removal. Pull them off the edge of the glass prior to cutout.

#### Removal

8. Make sure cutting blades are sufficiently sharp.

9. Before cutting out the windshield, remove contaminants from the glass and pinchweld. This step will prevent contaminants from making contact with the urethane.

10. If using a cold knife, use a 3/4-inch cold-knife blade. Cut three sides; then use a long knife or power tool to cut the bottom of the windshield. **Caution:** Be careful not to hit or cut the gravity stops; mark their location with a marking pencil or retention tape.

11. Spray the bottom of the windshield with water 5 inches above the urethane on the glass, so that the water flows down into the urethane while you make your final cut across the bottom of the windshield.

12. Take the windshield out of the opening using a set of vacuum cups. Lift the glass and place it on a windshield stand or suitable workstation.

#### Installation

13. After cutting the windshield out, remove contaminants such as dirt, moisture and debris from the pinchweld. Clean the dashboard.

14. Attach the side moldings to the glass edge.

15. Dry fit the new glass to the opening. Mark your glass using a grease pencil or retention tape.

16. Place your vacuum cups on the windshield in the appropriate locations.

17. Lift the windshield from the windshield stand using vacuum cups.

18. Set the windshield onto the old urethane.

19. With the windshield resting in the opening, make sure it is in the right spot.

20. Adjust both sides to the correct setting, marking the passenger's side, then the driver's side. Lift the glass and place it on a windshield stand or suitable workstation.

21. Follow the urethane manufacturer's recommendations for installation. **Note:** It is crucial to verify that the urethanes and primers are current. Never use outdated products as this could jeopardize the structural integrity of the vehicle and the safety of its passengers.

22. Remove the side moldings from the glass.

23. Clean the inside of the windshield using a urethane manu-

facturer-recommended product. **Note:** Do not touch the bonding area after cleaning, prepping or priming it.

24. Wear powder-free Nitrile gloves to keep off chemicals.

25. Re-attach the side moldings to the glass edge.

26. Prep the glass following the urethane manufacturer's recommendations.

27. Using a pinchweld scraper, remove as much of the original urethane as the urethane manufacturer recommends. **Caution:** Before removing the old urethane, make sure there are no contaminants and do not touch the pinchweld after you have prepped the area.

28. Apply the pinchweld primer only to the needed areas and follow the urethane manufacturer's recommendations. **Caution:** Make sure to allow preps and primers to dry as recommended by the urethane manufacturer.

29. Apply a triangular bead of urethane to the same path as the freshly cut urethane on the pinchweld. Before cutting your V-notch, cut the tip off your nozzle with a nozzle cutter. With the cut nozzle, measure to the top of the roofline, and at  $\frac{1}{16}$  inch higher than the roofline, make a mark on the nozzle with a pen or marker. Notch the nozzle up to the marked line; this will give you the appropriate triangular bead.

30. Lift the windshield from the windshield stand or workstation using vacuum cups. Set the windshield on the urethane at the mark you made during your dry fit. Lower the driver's side of the windshield onto the urethane and line it up with the dry-fit mark; it is now in place.

31. The windshield is now ready to be decked. Press firmly to ensure a good seal.

32. Before re-installing the parts, check for leaks. Use a leak detector to go over the perimeter of the windshield. If you find a leak, apply more pressure to the spot and ensure that the glass makes contact with the wet urethane.

33. Re-install the removed parts in reverse order.

34. Allow the urethane to cure according to the urethane manufacturer's recommended cure time before returning the vehicle to the customer. **Warning:** Disregarding this step could jeopardize the structural integrity of the vehicle and the safety of its passengers.

35. You have completed the removal and replacement of the windshield.

## B. Back glass

### Removal

1. Make sure that you have the right glass. Back glass part number is DB10927.

2. Check for continuity of the defroster grid using an ohmmeter. **Note:** The back glass has exposed edges on all sides, but the bottom of the glass has an underside molding that acts as the trunk weatherstrip.

3. Disconnect the antenna in the top interior corner of the back glass.

4. Use a small slot screwdriver to open the screw cover on the quarter panel and remove the 7-millimeter screw. Pry outward with your fingers to release the quarter-panel retainers. Remove the quarter panel for access to the defroster connectors.

5. Disconnect the defroster connectors.

6. Cut out the glass using your tool of choice. **Caution:** Be aware of the exposed painted surfaces.

### Installation

7. After cutting the glass out, remove contaminants such as dirt, moisture and other debris from the pinchweld.

8. Place your vacuum cups on the glass in the appropriate location.

9. Follow the urethane manufacturer's recommendation for installation. **Note:** It is crucial to verify that the urethanes and primers are current. Never use outdated products as this could jeopardize the structural integrity of the vehicle and the safety of its passengers.

10. Clean the inside of the glass using a urethane manufacturer-recommended product. **Note:** Do not touch the bonding area after cleaning, prepping or priming it.

11. Wear powder-free Nitrile gloves to keep off chemicals.

12. Prep the glass following the urethane manufacturer's recommendations.

13. Using a pinchweld scraper, remove as much of the original urethane as the urethane manufacturer recommends. **Caution:** Before removing the old urethane, make sure there are no contaminants and do not touch the pinchweld after you have prepped the area.

14. Apply the pinchweld primer only to the needed areas and follow the urethane manufacturer's recommendations. **Caution:** Make sure to allow preps and primers to dry as recommended by the urethane manufacturer.

15. Apply a triangular bead of urethane to the same path as the freshly cut urethane on the pinchweld. Before cutting your V-notch, cut the tip off your nozzle with a nozzle cutter. With the cut nozzle, measure to the top of the roofline, and at  $\frac{1}{16}$  inch higher than the roofline and bodyline, make a mark on the nozzle with a pen or marker. Notch the nozzle up to the marked line; this will give you the appropriate triangular bead.

16. Place your vacuum cups on the back glass in the appropriate locations.

17. Lift the glass from the windshield stand or workstation using your vacuum cups.

18. Set the glass in the opening.

19. The glass is now ready to be decked. Press firmly to ensure a good seal.

20. Before re-installing the parts, check for leaks. Use a leak detector to go over the perimeter of the glass. If you find a leak, apply more pressure to the spot and ensure that the glass makes contact with the wet urethane.

21. Re-install the removed parts in reverse order.

22. Check operation of the defroster and antenna.

23. Allow the urethane to cure according to the urethane manufacturer's recommended cure time before returning the vehicle to the customer. **Warning:** Disregarding this step could jeopardize the structural integrity of the vehicle and the safety of its passengers.

24. You have completed the removal and replacement of the back glass. **AG**