

2006 Scion xA

Vehicle information



Vehicle type: Four-door hatchback

NAGS® numbers*: Windshield part number FW2397

Helpful tools or supplies: Windshield might require new moldings.

*With permission from National Auto Glass Specifications. Call NAGS at 800/551-4012 or visit 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 FW2397.

2. Remove the rearview mirror by forcing it up and off the mirror pad.

3. Remove the windshield-wiper nut covers using an installation stick.

4. Remove the windshield-wiper nuts using a 15-millimeter wrench or socket.

5. To remove the two-piece cowl, remove the two faux Phillips-screw retainers from the center of the leading edge of the panel.



6. Remove the two 10-millimeter screws in the two corners of the panel. Lift up the panel and remove.

7. The top and side molding is a U-channel wraparound molding that will be replaced with the glass. Grasp the bottom corner and pull from the edge of the glass.

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

15. Place your vacuum cups on the windshield in the appropriate location.

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

17. Set the windshield onto the old urethane.

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

19. 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.

20. 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.

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

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

23. Attach the top and side molding to the glass edge.

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

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

26. 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.

27. 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 of your nozzle with a nozzle cutter. With the cut nozzle, measure to the top of the roofline, and at 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.

28. Lift the windshield from the windshield stand or workstation using vacuum cups and 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.

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

30. 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 or apply more urethane to the area. Then check your seal.

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

32. 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.

33. You have completed the removal and replacement of the windshield. **AG**

Notes:

Multiple horizontal lines for taking notes.



Always verify urethanes and primers are current. Never use outdated products as this could jeopardize the structural integrity of the vehicle.