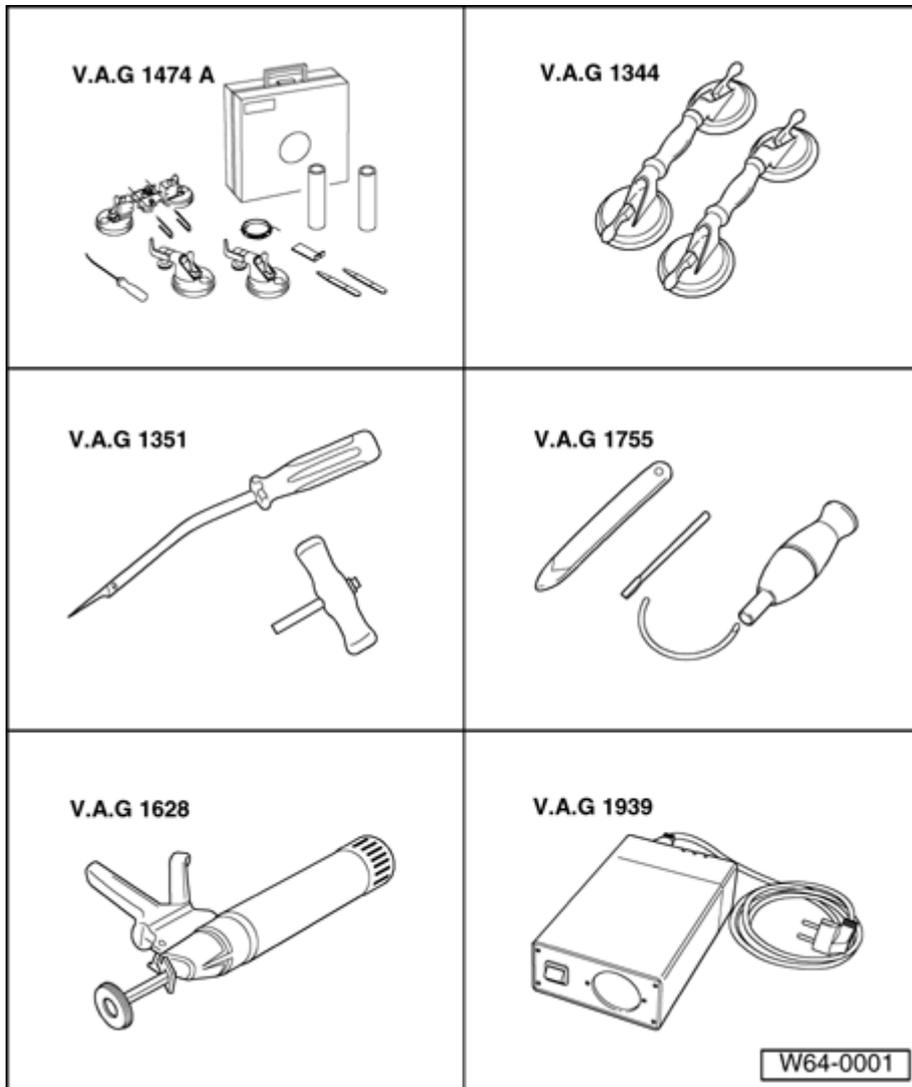


# Volkswagen Jetta 2005-> (A5)

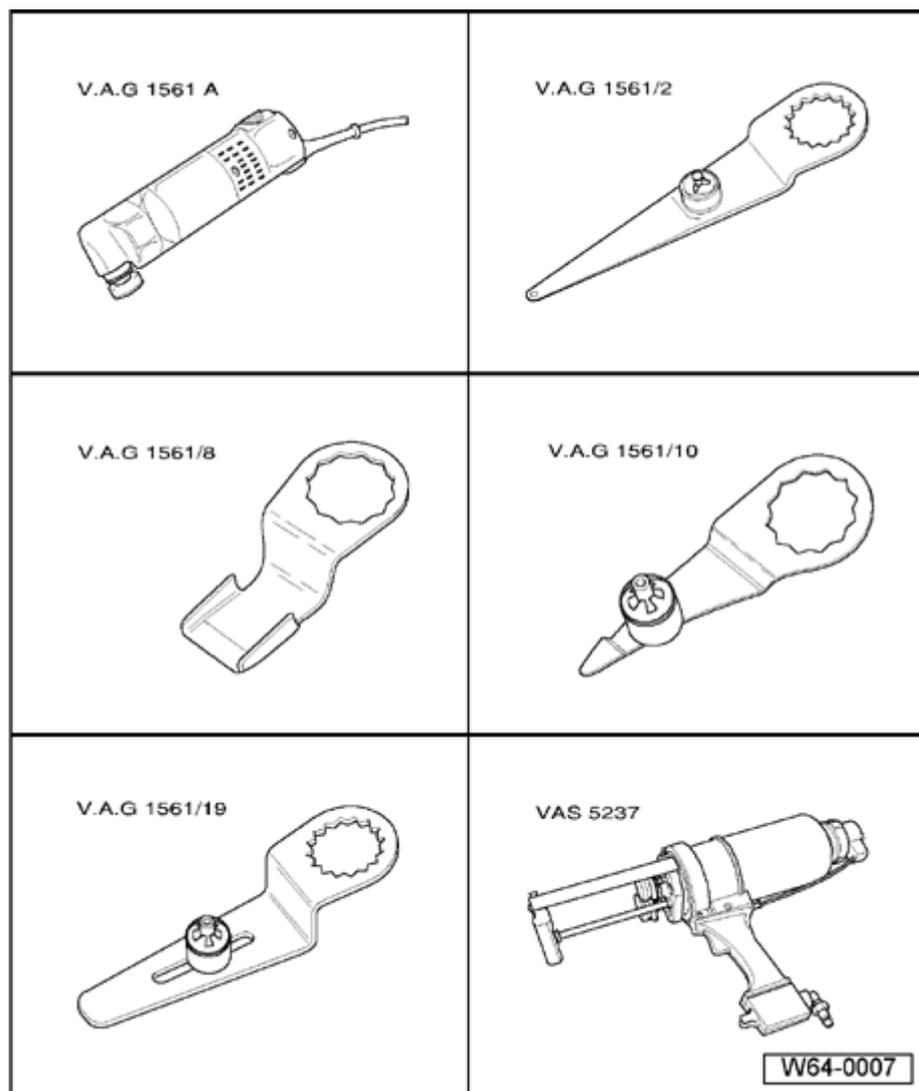
## Flush-bonded windows

### Tools



### Special tools, testers and auxiliary items required

- Cutting tool kit V.A.G 1474 A
- Suction lifter V.A.G 1344
- Cutting tools for glass V.A.G 1351
- Window removing kit V.A.G 1755
- Cartridge gun V.A.G 1628
- Cartridge heater V.A.G 1939 A



**Special tools, testers and auxiliary items required**

- Electric cutter V.A.G 1561 A
- Cutting blade V.A.G 1561/2
- Scraper V.A.G 1561/8
- Cutting blade, bent at right angle V.A.G 1561/10
- Cutting blade V.A.G 1561/19
- Double cartridge gun VAS 5237

**Materials**

■ 2C- window adhesive	DA 004 600 A2 <sup>1) 2)</sup>
■ 1C- window adhesive	DH 009 100 03 <sup>3) 4)</sup>
■ Activator	D 181 801 A1 <sup>5)</sup>
■ Glass primer/paint primer	D 009 200 02 <sup>5)</sup>
■ Cleaning solution	D 009 401 04 <sup>5)</sup>
■ Primer applicator	D 009 500 25 <sup>5)</sup>
■ Adhesive remover	D 002 000 10 <sup>5)</sup>
■ Cutting cord	357 853 999

1) Observe minimum curing time ⇒ [64-1, Minimum curing time](#)

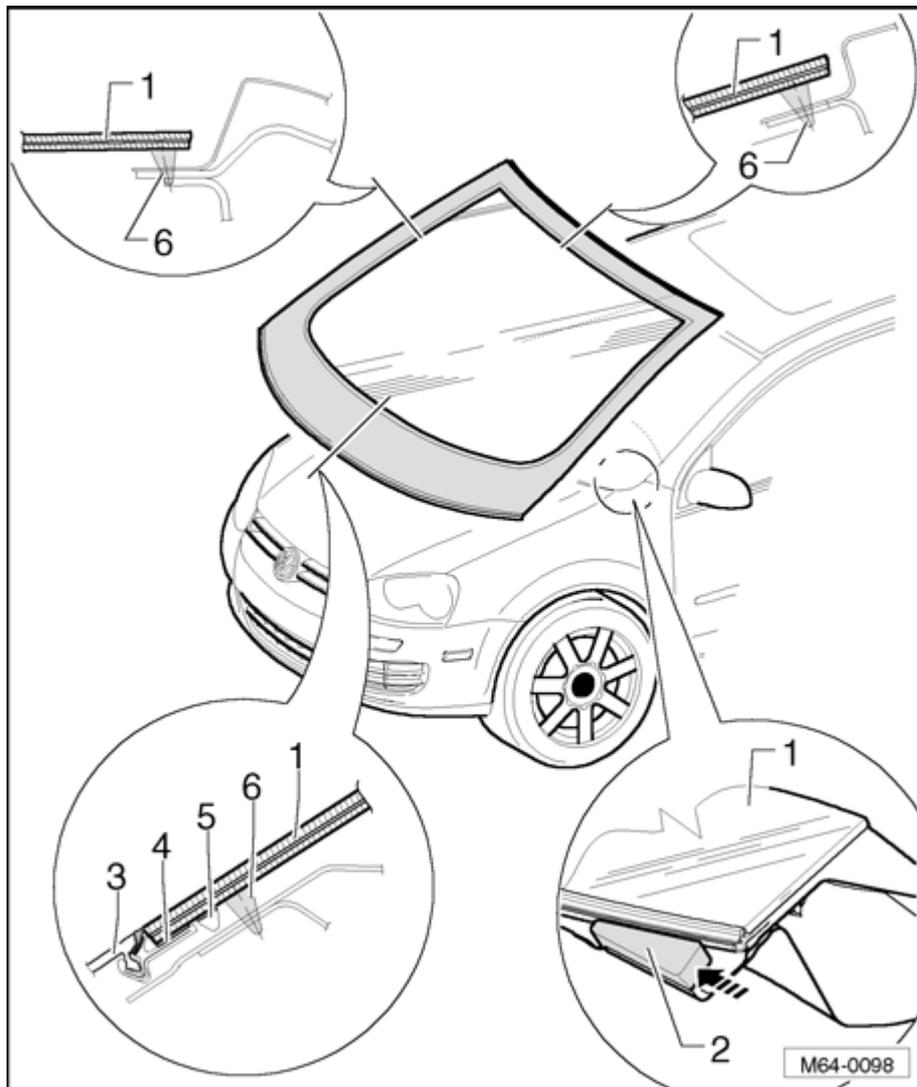
2) Double cartridge gun VAS 5237 must be used to process this material.

3) Small cartridge (110 ml) for sealing and/or when a 400 ml double cartridge is not sufficient

4) Heat according to manufacturers instructions using cartridge heater V.A.G 1939 A

5) Materials are stored in box D 004 700

## Windshield - assembly overview



- **Windshield**

- Removing and installing ⇒ [64-1, Windshield, removing and installing](#)

- **Window adjuster**

- 443 845 631 A

- **Plenum chamber cover**

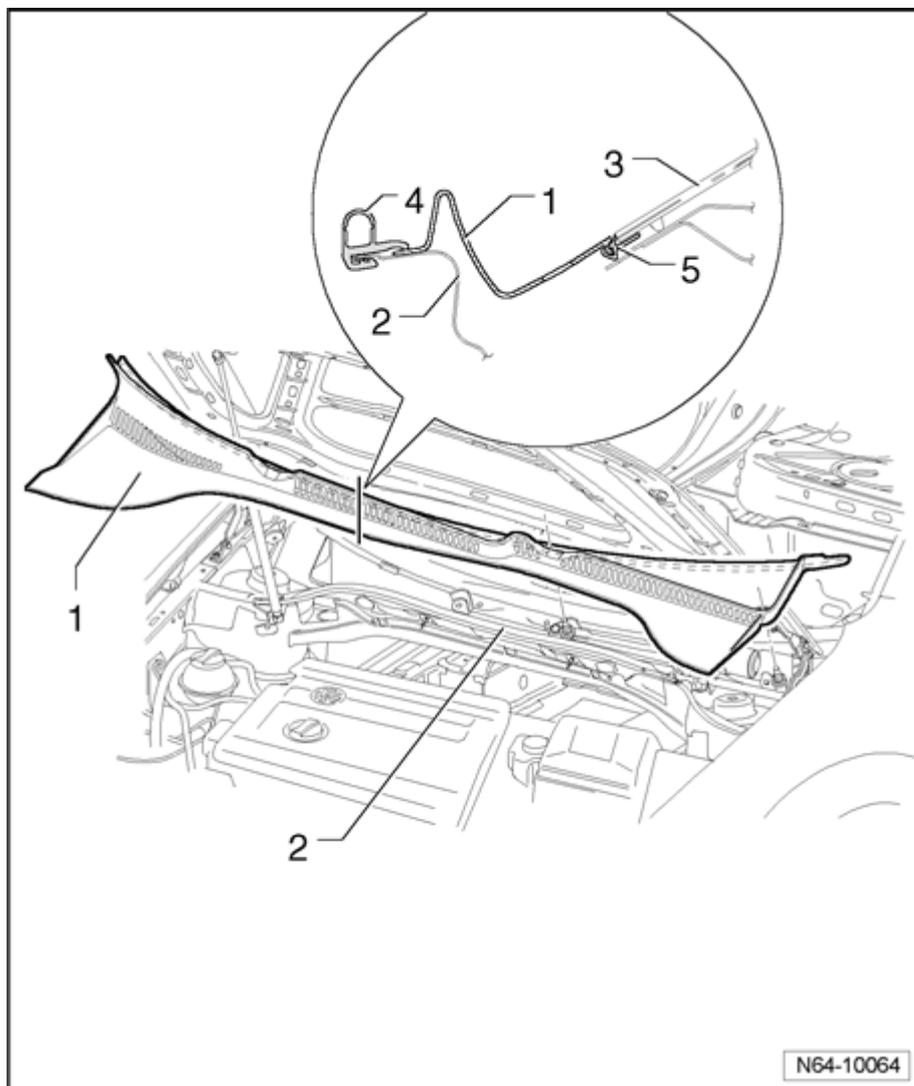
- Pull out of binding profile only by hand
- Removing and installing ⇒ [64-1, Plenum chamber cover, removing and installing](#)

- **Binding profile**

- Component of windshield

- **Spacer**
  - Component of windshield
  
- **PUR adhesive sealant**
  - Bead cross section: Width = 6.5 mm, height = 10 mm (including residual material on window glass and window flange)
  - Minimum curing time ⇒ [64-1, Minimum curing time](#)

### Plenum chamber cover - assembly overview



- **Plenum chamber cover**
  - Pull out of binding profile only by hand
  - Removing and installing ⇒

[64-1, Plenum chamber cover, removing and installing](#)

- **Plenum chamber bulkhead**
  - Removing and installing ⇒ [50-5, Plenum chamber bulkhead - assembly overview](#)
- **Windshield**
  - Removing and installing ⇒ [64-1, Windshield, removing and installing](#)
- **Plenum chamber seal**
- **Binding profile**
  - Component of windshield

## Plenum chamber cover, removing and installing

### Plenum chamber cover, removing

- Unscrew wiper arms

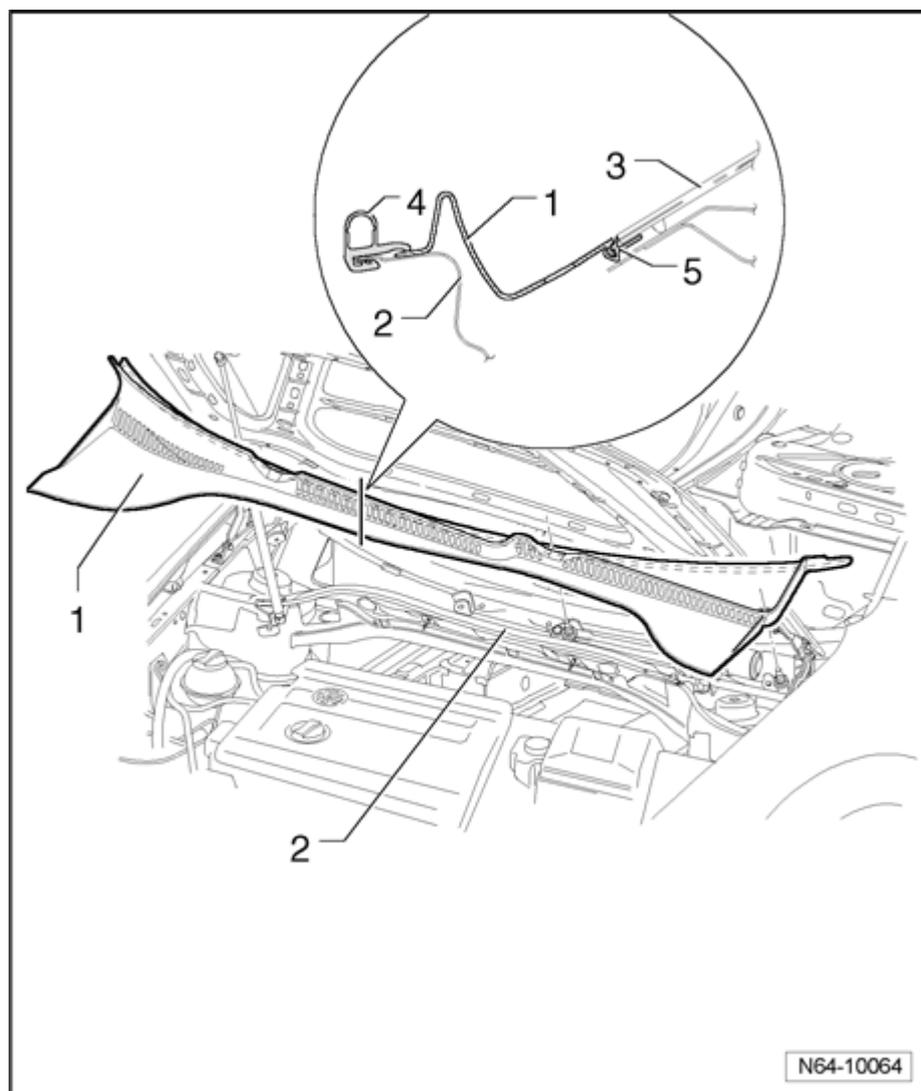
⇒ [Repair Manual, Electrical Equipment, Repair Group 92, Windshield wiper system](#)

.

### **Caution!**

**The plenum chamber cover must not be pried off using a tool (wedge). Window will be damaged and may crack later.**

- Pull off seal of plenum chamber - **4** - on the entire length of facing wall - **2** - of plenum chamber.



- Carefully pull out plenum chamber cover - 1 - upward from binding profile - 5 - starting at right.

#### Plenum chamber cover, installing

#### **Caution!**

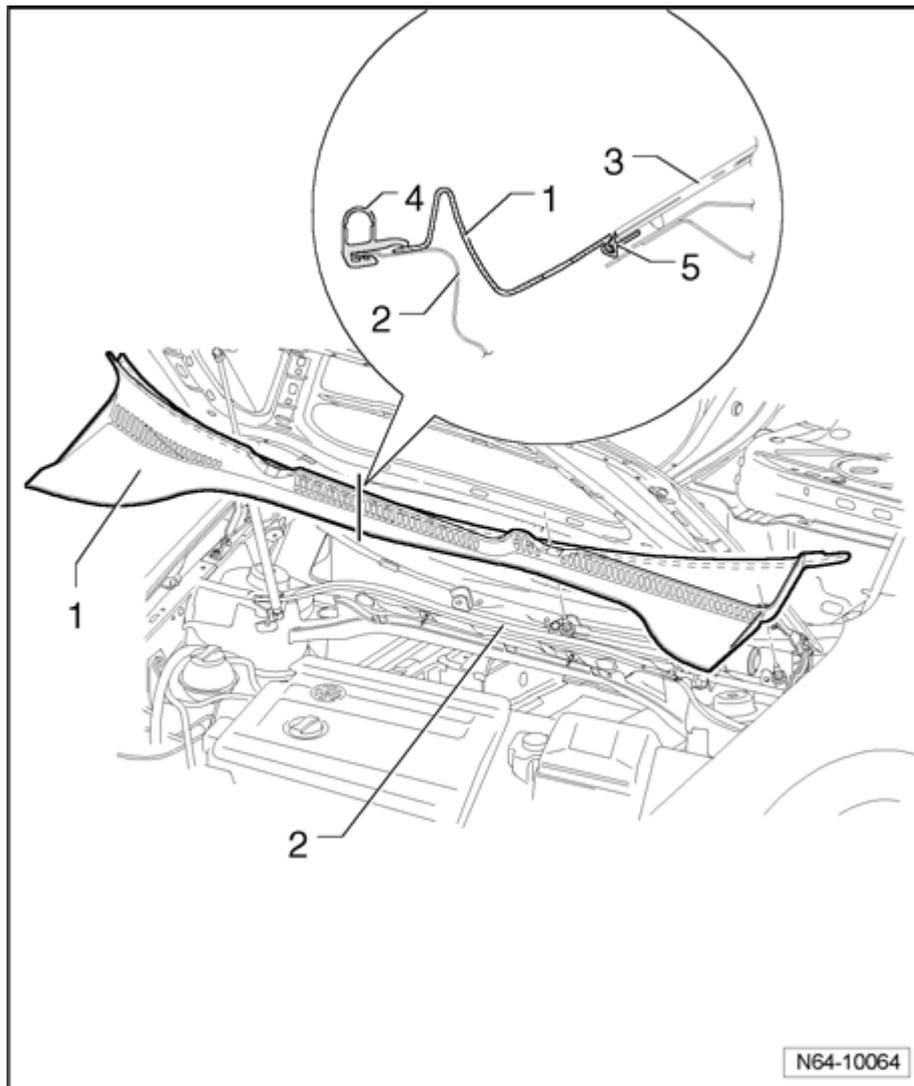
**Striking the plenum chamber cover can cause cracks in the windshield.**

- Spray binding profile - 5 - with soap solution so that plenum chamber cover - 1 - can be pressed in more easily.
- Place plenum chamber cover - 1 - onto binding profile - 5 - and engage it with binding profile - 5 - starting from center using light pressure.
- Install plenum chamber seal - 4 - and windshield wipers

⇒ [Repair Manual, Electrical Equipment, Repair Group 92, Windshield wiper system](#)

**Note :**

- *In new windshields, an insert is installed in the binding profile. This insert must be removed before installing the plenum chamber cover.*



**Windshield, removing and installing**

**Windshield, removing**

- Remove plenum chamber cover ⇒ [64-1, Plenum chamber cover, removing and installing](#) .
- Remove A-pillar trim

⇒ [Repair Manual, Body Interior, Repair Group 70, Pillar](#)

Flush-bonded windows

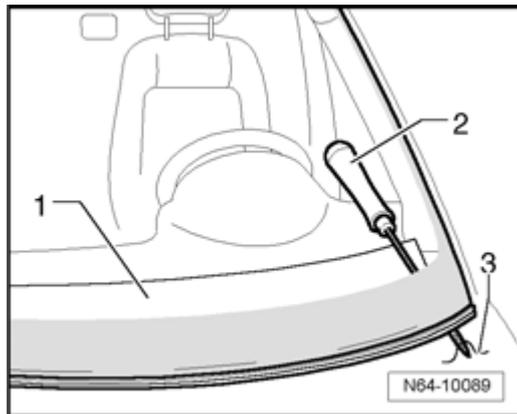
and side trim

- Remove sun visors

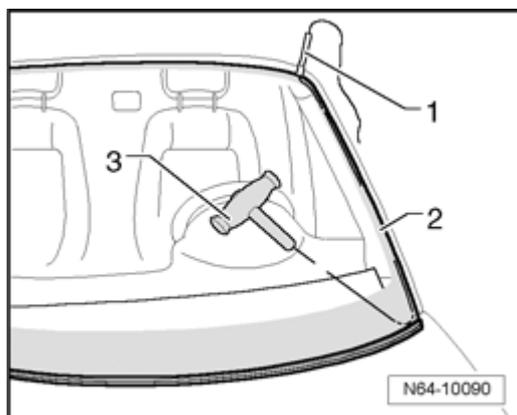
⇒ [Repair Manual, Body Interior, Repair Group 68, Storage compartments, covers and trim](#)

- Remove interior mirror

⇒ [Repair Manual, Body Interior, Repair Group 68, Interior mirror](#)



- Slide in foil V.A.G 1474/8 - 1 - between windshield and instrument panel.
- Thrust awl V.A.G 1474/2 - 2 - through adhesive bead.
- Push cutting cord end - 3 - using awl V.A.G 1474/2 - 2 - through adhesive sealing material into the vehicle interior.

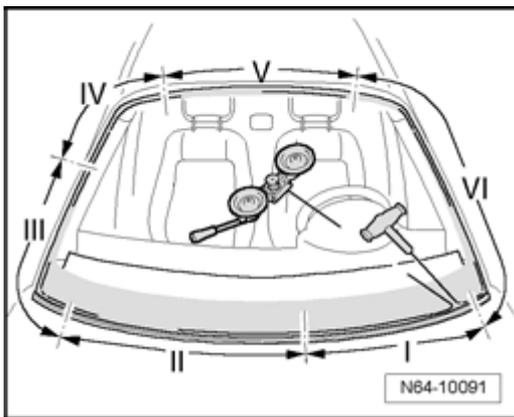


- Secure cutting cord end on the inside against pulling out using pull handle V.A.G 1351/1 - 3 - .

- Insert cutting cord - 2 - in upper area of windshield by aid of small tube - 1 - .
- Lay cutting cord - 2 - around the window and also guide inside the second cord end.

Make sure that cutting cord - 2 - is inserted under the window at the corners.

- Secure second cutting cord end onto spooling tool V.A.G 1654 .



- Position spooling tool V.A.G 1654 at "position I" .
- Move spooling tool V.A.G 1654 according to position required and cut window free.
- While cutting free, press cutting cord against window using a wedge V.A.G 1474/5 to prevent damage to instrument panel and to have clearance at window flange.

### Windshield, installing

Preparing undamaged window for glazing ⇒ [64-1, Undamaged window, preparing for glazing](#)

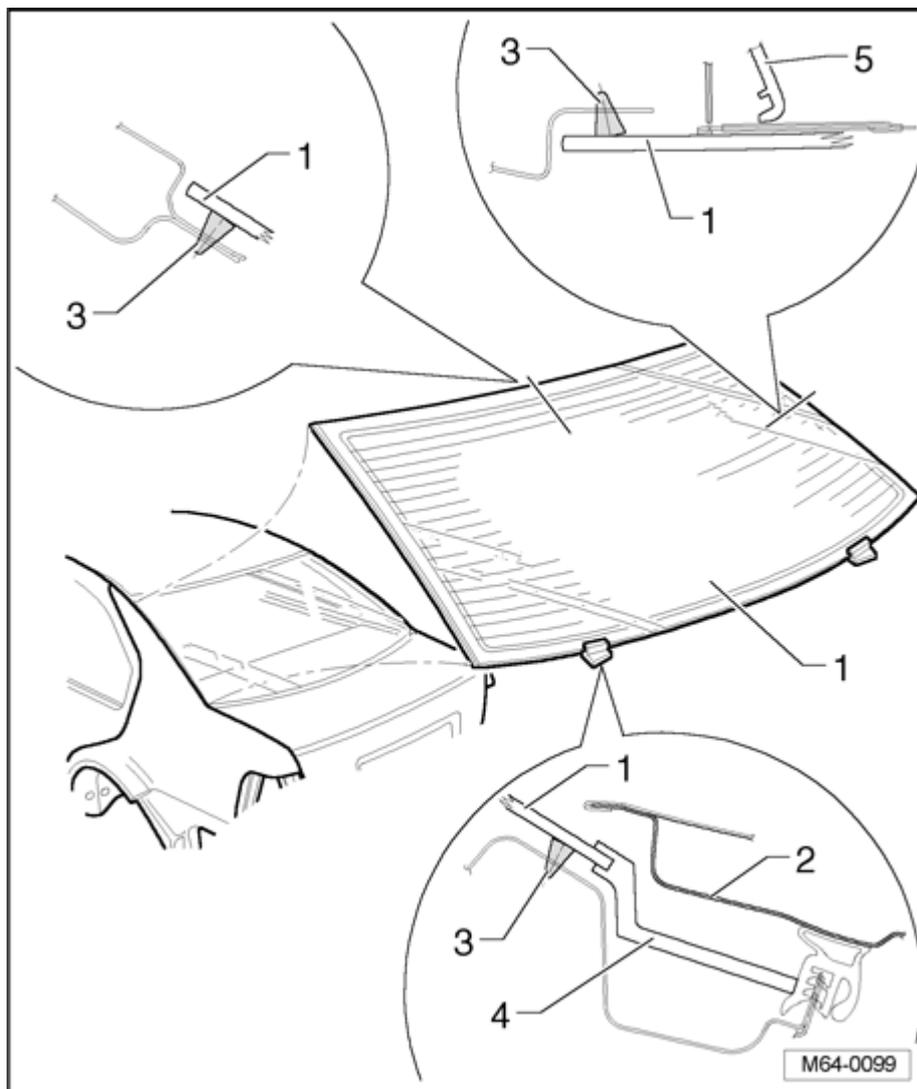
Preparing new window for glazing ⇒ [64-1, New window, preparing for glazing](#)

Preparing window flange for glazing ⇒ [64-1, Window flange, preparing for glazing](#)

Installation notes ⇒ [64-1, Installation notes](#)

Minimum curing time ⇒ [64-1, Minimum curing time](#)

### Rear window - assembly overview



- **Rear window**

- Removing and installing ⇒ [64-1, Rear window, removing and installing](#)

- **Rear lid**

- **PUR adhesive sealant**

- Bead cross section: Width = 6.5 mm, height = 10 mm (including residual material on window glass and window flange).
- Minimum curing time ⇒ [64-1, Minimum curing time](#)

- **Window adjuster**

- **C-pillar trim**

- Removing

Flush-bonded windows

⇒ [Repair Manual, Body Interior, Repair Group 70, Pillar and side trim](#)

.

## **Rear window, removing and installing**

### **Undamaged rear window, removing**

- Remove C-pillar trim

⇒ [Repair Manual, Body Interior, Repair Group 70, Pillar and side trim](#)

.

- Remove roof end strip

⇒ [Repair Manual, Body Interior, Repair Group 70, Roof trim panels](#)

.

- Remove rear parcel shelf

⇒ [Repair Manual, Body Interior, Repair Group 70, Luggage compartment trim](#)

.

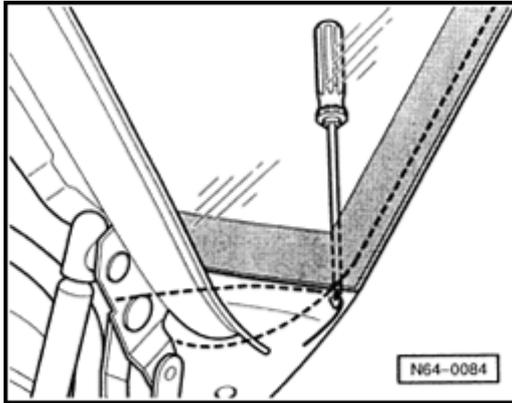
- Remove high mount brake light

⇒ [Repair Manual, Electrical Equipment, Repair Group 94, Lights, Switches - exterior](#)

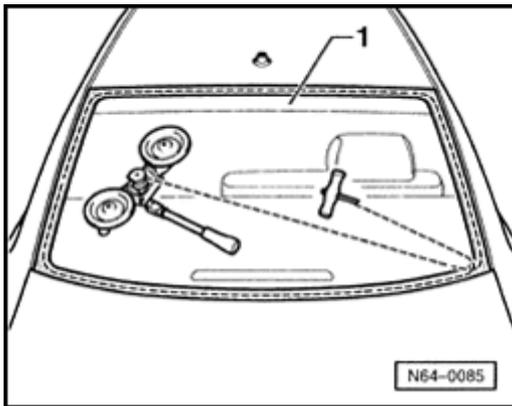
.

- Disconnect connections for heater rear window and window antenna.
- Insert cutting cord into window flange using small tube.

## Flush-bonded windows



- Push cutting cord through adhesive sealant into vehicle interior using awl V.A.G 1474/2 .

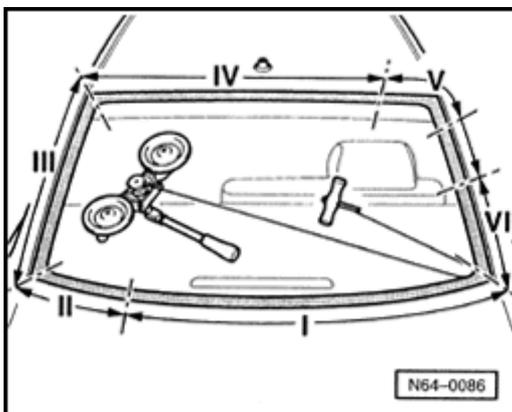


- Pull through outer cord end inward and counterhold using pulling handle V.A.G 1351/1 .

- Secure inner cord end to spooling tool V.A.G 1654 .

- Position spooling tool V.A.G 1654 .

- Carefully slide foil V.A.G 1474/8 - 1 - between rear window and molded headliner, unscrew mounting bolts for molded headliner to do so.

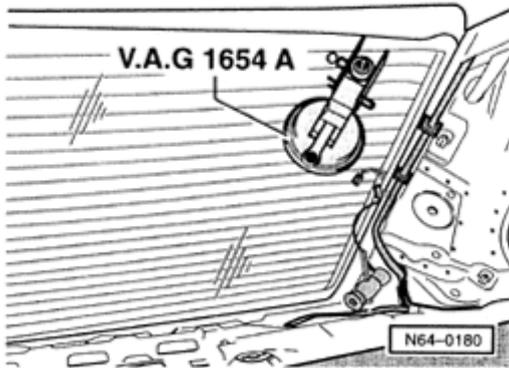


- Position spooling tool V.A.G 1654 at "position I" .

- Move spooling tool according to position required and cut windshield free.

- While cutting free, press cutting cord against window using plastic wedge in order to have clearance at window

flange.



- In place of spooling tool V.A.G 1654 , the spooling tool V.A.G 1654 A can also be used.

- As shown in illustration, one suction cup can be removed from spooling tool. By doing this, the roller of the spooling tool can be placed closer to window flange.

#### **Damaged rear window, removing**

- Protect body and interior from glass splinters.
- Remove glass pieces up to adhesive material.
- Remove C-pillar trim

⇒ [Repair Manual, Body Interior, Repair Group 70, Pillar and side trim](#)

- .
- Remove roof end strip

⇒ [Repair Manual, Body Interior, Repair Group 70, Roof trim panels](#)

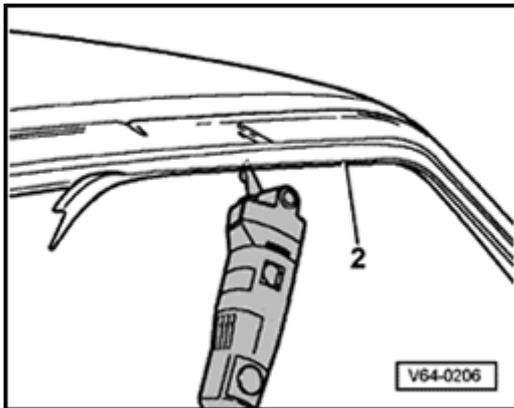
- .
- Remove rear parcel shelf

⇒ [Repair Manual, Body Interior, Repair Group 70, Luggage compartment trim](#)

- .
- Remove high mount brake light

⇒ [Repair Manual, Electrical Equipment, Repair Group 94, Lights, Switches - exterior](#)

- Disconnect harness connectors for window defroster and window antenna.



- Bond flange - 2 - all around with fabric reinforced adhesive tape.
- Cut through adhesive sealing material (with glass residue) from window opening using electric cutter V.A.G 1561 A and cutting blade, bent at right angle V.A.G 1561/10 (with stopper roll).

**Warning!**

**Always wear protective goggles and leather gloves.**

**Rear window, installing**

Preparing undamaged window for glazing ⇒ [64-1, Undamaged window, preparing for glazing](#)

Preparing new window for glazing ⇒ [64-1, New window, preparing for glazing](#)

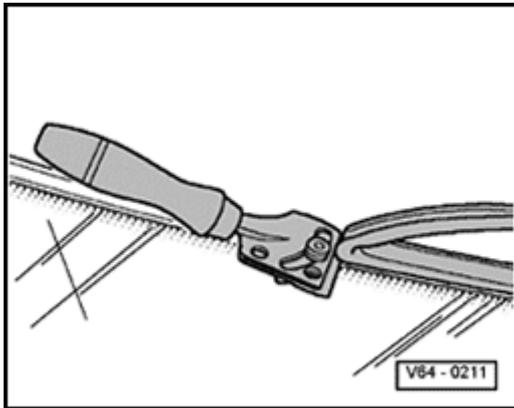
Preparing window flange for glazing ⇒ [64-1, Window flange, preparing for glazing](#)

Installation notes ⇒ [64-1, Installation notes](#)

Minimum curing time ⇒ [64-1, Minimum curing time](#)

**Undamaged window, preparing for glazing**

**Note:**



- *When re-using an undamaged window, cut back remaining adhesive sealant to 12 mm shortly before re-adhering, do not damage primer and ceramic coating.*
- *Residual material acts as a base for the new adhesive sealing material.*

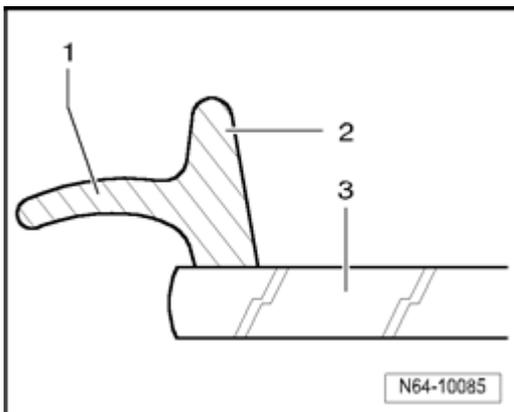
**Caution!**

**Do not prime or use a cleaning solution on the adhesive surface. Keep adhesive surface free of dirt and grease.**

Exception: If bonding is not performed immediately after cutting back, the remaining material must be activated using the activator D 181 801 A1 .

**New window, preparing for glazing**

Ceramic coating is only still applied on all new windows and sprayed on sealing lips with spacer.



Exception: Rear window has no sealing lip and no spacer.

- 1 - Sealing lip
- 2 - Spacer
- 3 - Window

**Note:**

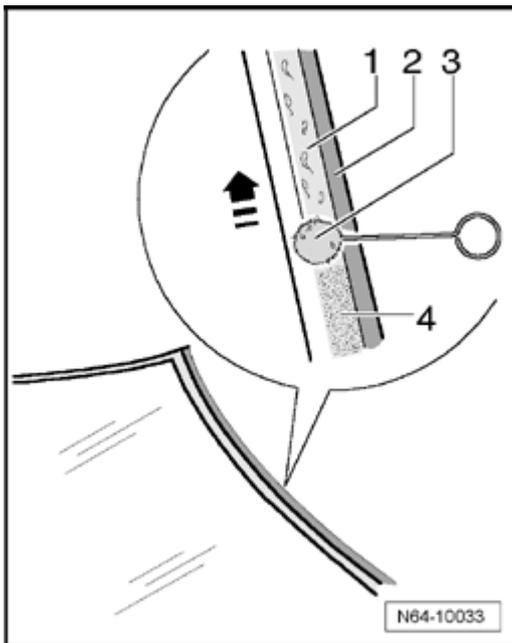
- *The application area for adhesive bead is not pre-coated and not primed.*

- Clean window circumference to width of 20 mm all around using cleaning solution D 009 401 04 .

- Then rub window circumference dry using a lint-free rag.

**Warning!**

**Ceramic application on window is not primer! It must be primed before the application of adhesive sealing material! Only use primer D 009 200 02 !**

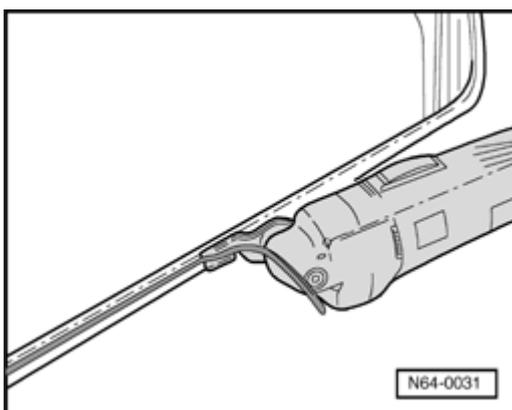


- Now apply primer - 4 - using applicator D 009 500 25 - 3 - evenly in one stroke on the previously cleaned area of the window - 1 - .

Make sure that window adhesive is applied onto primed area at a distance of approx. 2 mm to sealing lip - 2 - .

Air dry time approx. 10 minutes

**Window flange, preparing for glazing**



## Flush-bonded windows

- Cut back remaining material on body flange using electric cutter V.A.G 1561 A and scraper V.A.G 1561/8 , do not remove all residue under any circumstances.

### **Note:**

- *Residual material acts as a base for the new adhesive sealing material. Keep adhesive surfaces free of dirt and grease.*

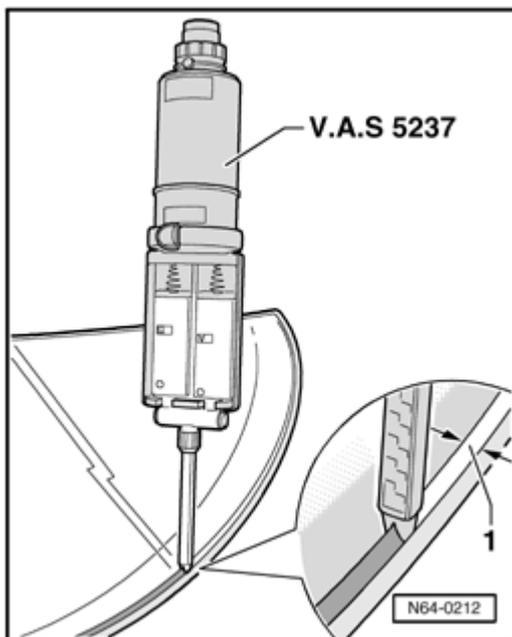
Exception: If bonding is not performed immediately after cutting back, the remaining material must be activated using the activator D 181 801 A1 .

### **Caution!**

**Activator must not come into contact with the paint - otherwise paint will be damaged.**

If body flange is being worked on or is partially replaced, it must be cleaned and primed again after painting the corresponding area.

### **Installation notes**



- Using double cartridge gun VAS 5237 , apply adhesive material all around on primed area - **1** - and onto cut back adhesive head at right angle to window.

### **Warning!**

**Window must be installed within 10 minutes, otherwise bonding properties of window adhesive will be impaired.**

- Insert window into window cut out using two suction lifters V.A.G 1344 , center and press in up to spacer.

- During curing time, secure windshield and rear window using window adjusters.
- Plenum chamber must be installed exactly as described ⇒ [64-1, Plenum chamber cover, installing](#) .
- Re-affix any stickers (e.g. for airbag).
- Activator must not be applied onto distributing wire for window heater.
- If the adhesive bead has been applied too thick and the adhesive expands onto the area of the window heating, then the excess adhesive must be removed.

### Minimum curing time

#### ***Warning!***

***Special requirements must be fulfilled for replacing bonded windows. This includes that e.g. a newly bonded windshield is safe for vehicle operation also in case of an accident after a specified minimum curing time.***

The minimum curing time for 2C adhesive DA 004 600 A2 is 3 hours for all windows.

Minimum curing time means the time from bonding window until bringing vehicle into use. During this time, the vehicle must stand on an even surface at room temperature (at least 15 ° C).

#### ***Warning!***

***The vehicle is ready for operation only after the minimum curing time has elapsed.***

### Paint damage, repairing

The paint construction must be re-established according to specifications of Repair Manual "Paint" .

The following repair method applies to paint damage in an area which is not visible:

Paint twice (wet on wet) using glass/paint primer D 009 200 02 - minimum air drying time 10 minutes.

### **Cleaning when soiled by adhesive sealing material**

- Adhesive removal solution D 002 000 10 is the recommended cleaning solution. Observe safety precautions when processing.

#### ***Warning!***

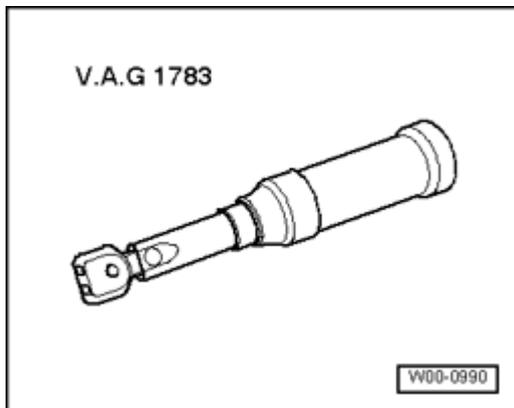
***When cleaning from vehicle interior out, the window just installed must not be pressed outward.***

- First clean paint surface coarsely using a dry rag. Eliminate remaining soiling using adhesive removal solution D 002 000 10 .
- Clean plastic trim: Allow adhesive sealing material to harden (about 1 hour) and then peel off.

## Front door window

### Tools

#### Special tools, testers and auxiliary items required

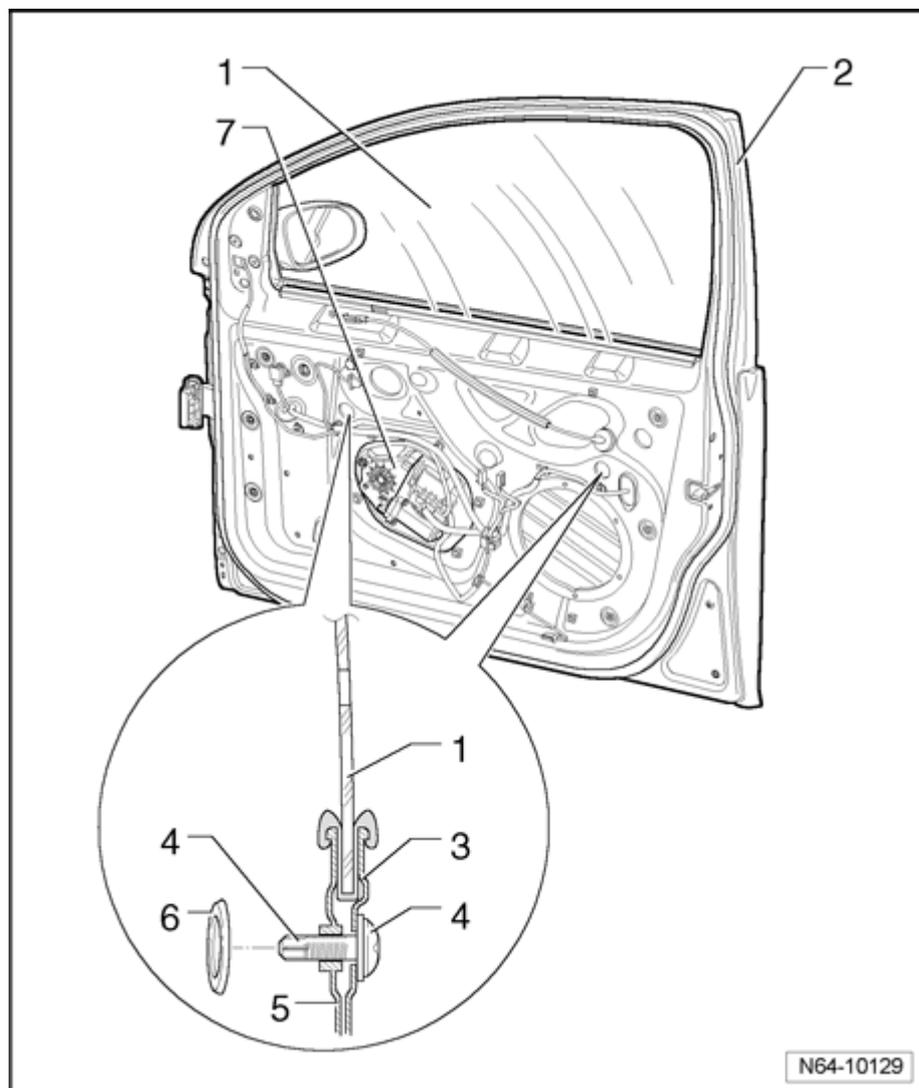


- Torque wrench (560Nm) V.A.G 1783

### Front door window - assembly overview

#### Note :

- *The description applies to the right side. The left side is derived accordingly from this.*
- *Bolt - 4 - is accessible from inside and outside. The bolt as viewed from the outside has a right-hand thread. This means: seen from the outside, bolt is loosened by turning toward left, seen from the inside, bolt is loosened by turning toward right.*



- **Door window**

- Removing and installing ⇒ [64-2, Door window, removing and installing](#)

- **Window guide**

- Removing and installing ⇒ [64-2, Window guide, removing and installing](#)

- **Mount**

- **Bolt**

- Accessible from outside (right-hand thread), loosen by turning toward left (it is necessary to remove outer door plate ⇒ [58-1, Outer door plate, removing and installing](#) )
- Accessible from inside,

loosen by turning toward  
right (it is necessary to  
remove front door trim

⇒ [Repair Manual, Body Interior, Repair  
Group 70, Door trim](#)

)

- Qty. 2
- 8 Nm

#### ■ Window regulator

- Removing and installing ⇒  
[64-2, Window regulator,  
removing and installing](#)

#### ■ Concealment cap

- Qty. 2

#### ■ Window regulator motor

- Removing and installing ⇒  
[64-2, Window regulator  
motor, removing and  
installing](#)

### Door window, removing and installing

#### **Note:**

- *Removing and installing is described only for the right door window. Removing and installing the left door window is derived accordingly from this.*

#### Removing

#### **Note :**

- *Bolt - 3 - is accessible from inside and outside. The bolt as viewed from the outside has a right-hand thread. This means: seen from the outside, bolt is loosened by turning toward left, seen from the inside, bolt is loosened by turning toward right.*

- Remove front door trim

⇒ [Repair Manual, Body Interior, Repair Group 70, Door trim](#)

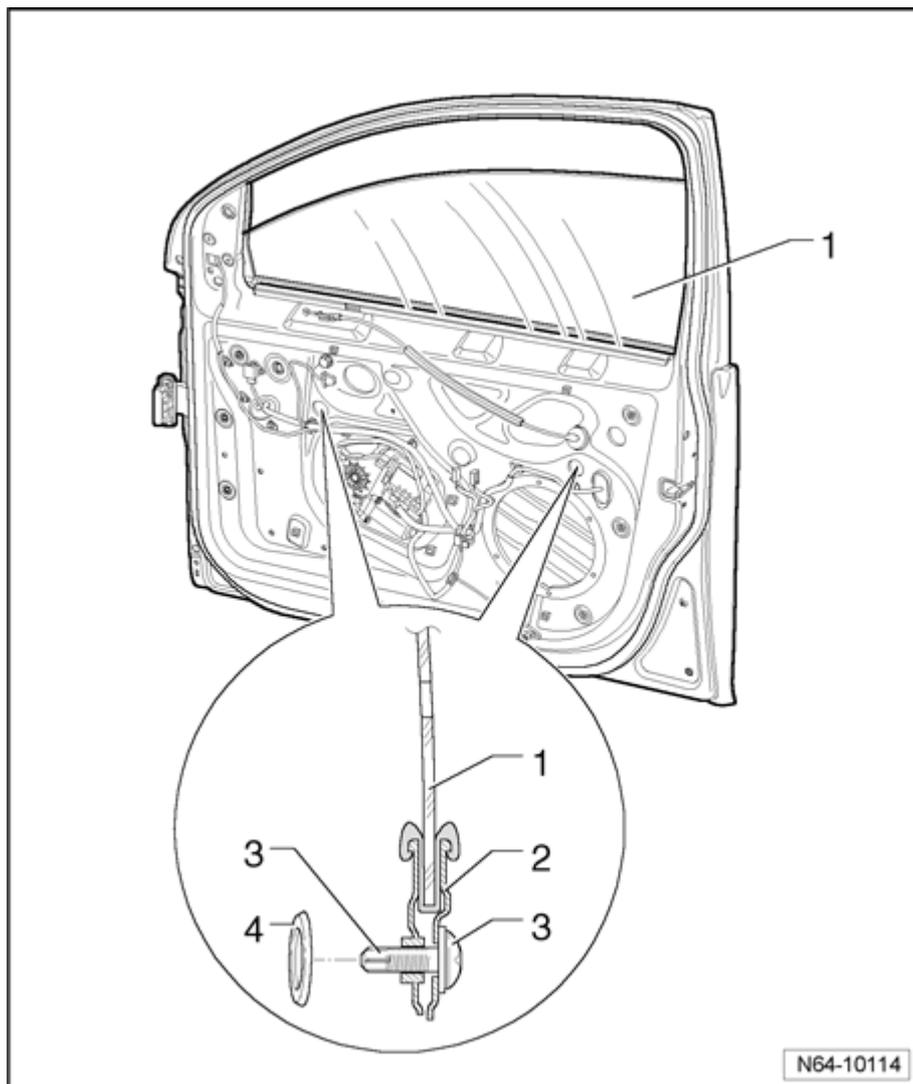
- Pry out cover caps - 4 - .
- Lower door window - 1 - until clamping screws - 3 - for mount - 2 - are accessible.

**Note :**

- *If the work step is not possible due to a malfunction via the electrical window regulator, window regulator motor can be unscrewed to be able to slide window down.*

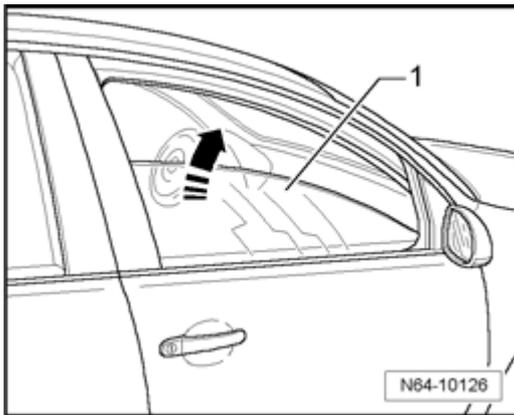
**Caution!**

**Loosen screw - 3 - from inside by turning toward right.**



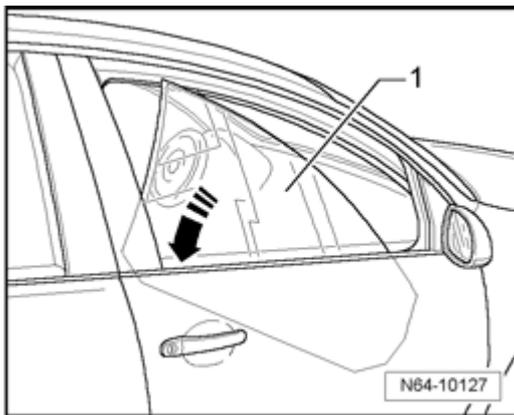
- Loosen bolts - 3 - (do not remove)

from inside by turning toward right and press apart clamping brackets.



- Raise rear door window - **1** - and swing out of door toward front in - **direction of arrow** - .

### Installing



- Insert door window - **1** - into door in - **direction of arrow** - .

Make sure that door window - **1** - is inserted correctly in window guide.

- Now bolt must be tightened by turning toward left.

Tightening torque for bolt: 8 Nm

The rest of the installation is performed in the reverse order of removal.

Then, perform a function test.

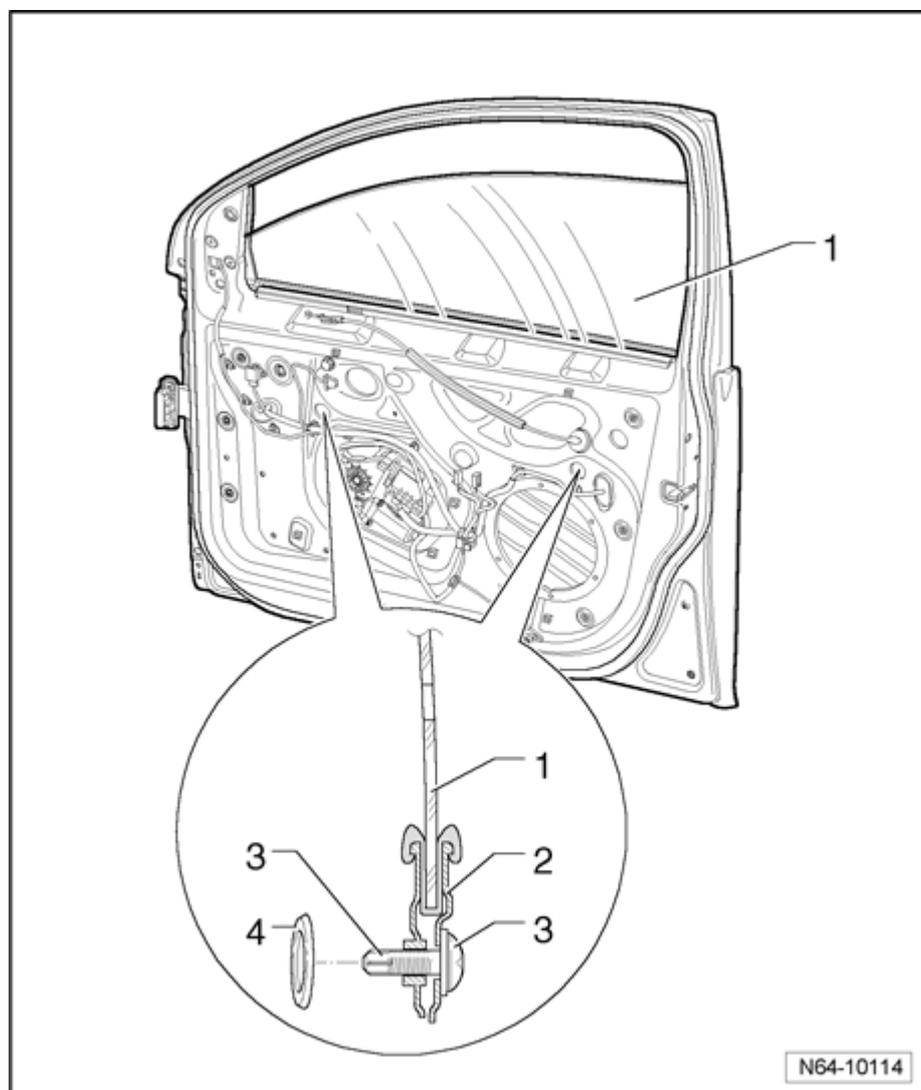
### Door window, adjusting

- Remove front door trim

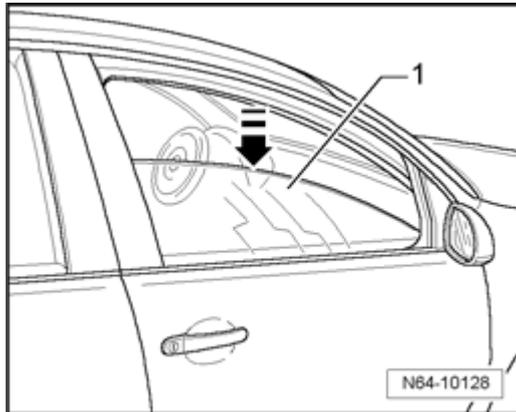
- Pry out cover caps - 4 - .
- Lower door window - 1 - until clamping screws - 3 - for mount - 2 - are accessible.

**Caution!**

**Loosen screw - 3 - from inside by turning toward right.**



- Loosen bolts - 3 - (do not remove) from inside by turning toward right and press apart clamping brackets.



- Press door window - **1** - using light pressure into clamping brackets - **direction of arrow** - and align door window to rear window guide without exerting pressure.

While doing this, make sure that door window - **1** - stands parallel to window guide.

- Tighten clamping brackets with bolts from inside by turning toward left.

Tightening torque for bolt: 8 Nm

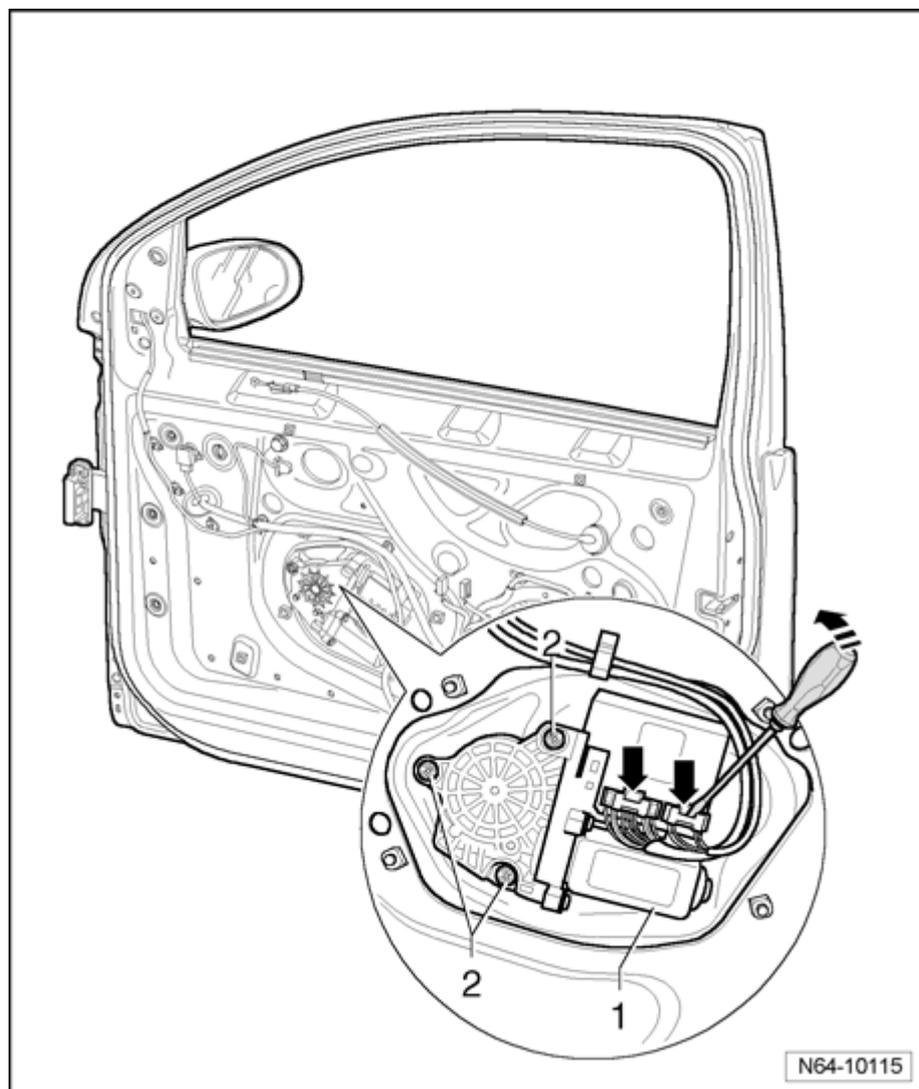
Then, perform a function test.

The rest of the installation is performed in the reverse order of removal.

### **Window regulator motor - assembly overview**

#### **Note :**

- *The description applies to the right side. The left side is derived accordingly from this.*



- **Window regulator motor**

- Removing and installing ⇒ [64-2, Window regulator motor, removing and installing](#)

- **Bolt**

- Qty. 3
- 3.5 Nm

### Window regulator motor, removing and installing

**Note:**

- *Removing and installing is described only for the right window regulator motor. Removing and installing the left window regulator motor is derived accordingly from this.*

## Front door window

- *Window regulator motor can also be removed with mounting plate when outer door plate has been removed.*

### Removing

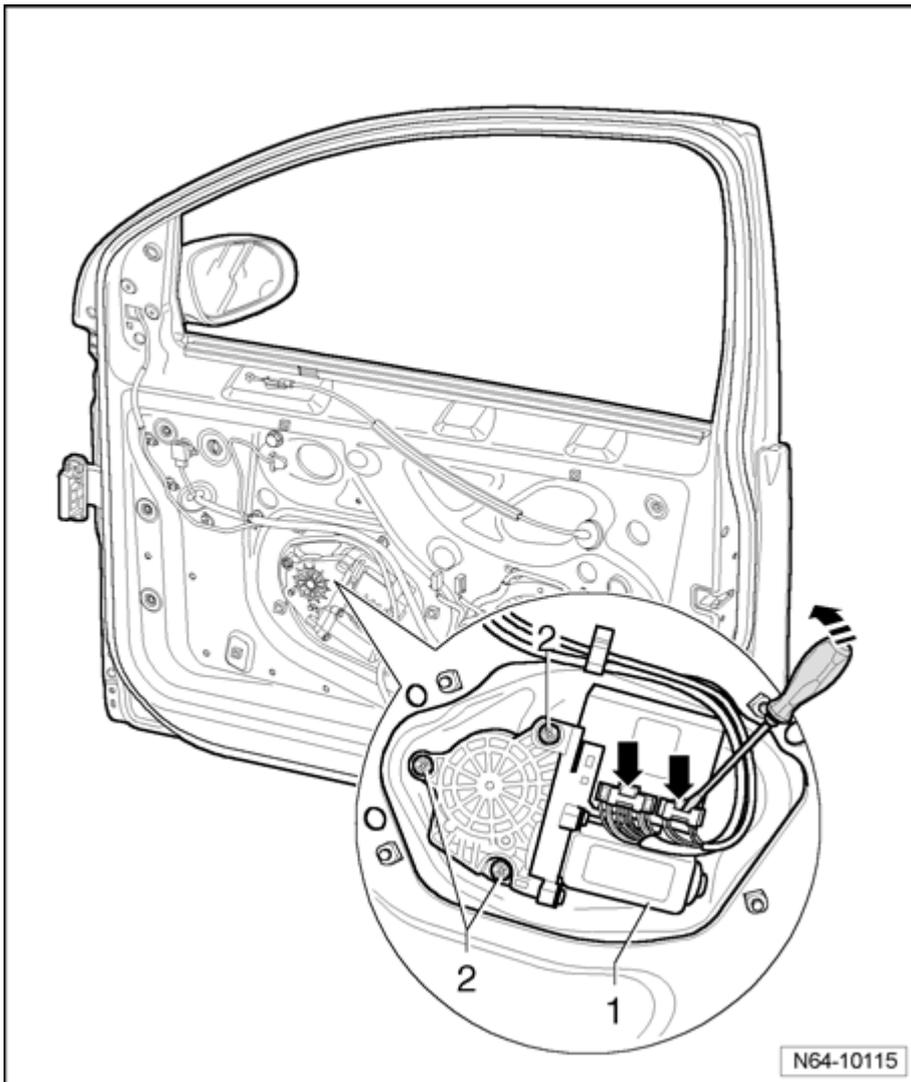
- Remove front door trim

⇒ [Repair Manual, Body Interior, Repair Group 70, Door trim](#)

- Fix window using adhesive tape so that it does not slip down.

- Disconnect harness connectors - **arrows** - using a screwdriver in - **direction of arrow** - .

- Remove three bolts - **2** - .



- Remove window regulator motor with control module - **1** - from mounting

plate.

### Installing

- Attach window regulator motor - **1** -  
and connect harness connector - **arrows**

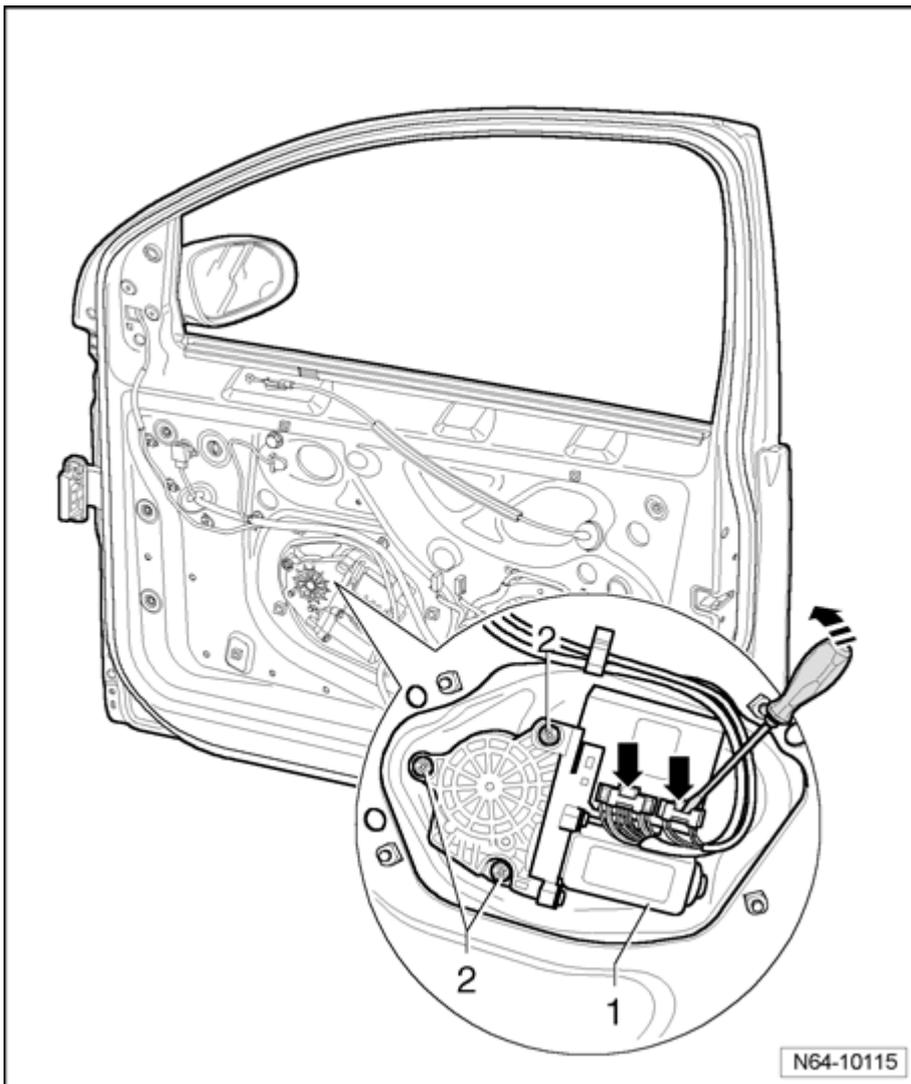
- .

- Pull door window lightly up and down  
so that splines are located better  
between motor and cable drum.

- Tighten bolts - **2** - for window regulator  
motor.

Tightening torque: 3.5 Nm

- Drive window regulator twice upward  
and downward to stop. By doing this,  
window regulator motor is initialized and  
ready for operation and activates pinch  
protection.

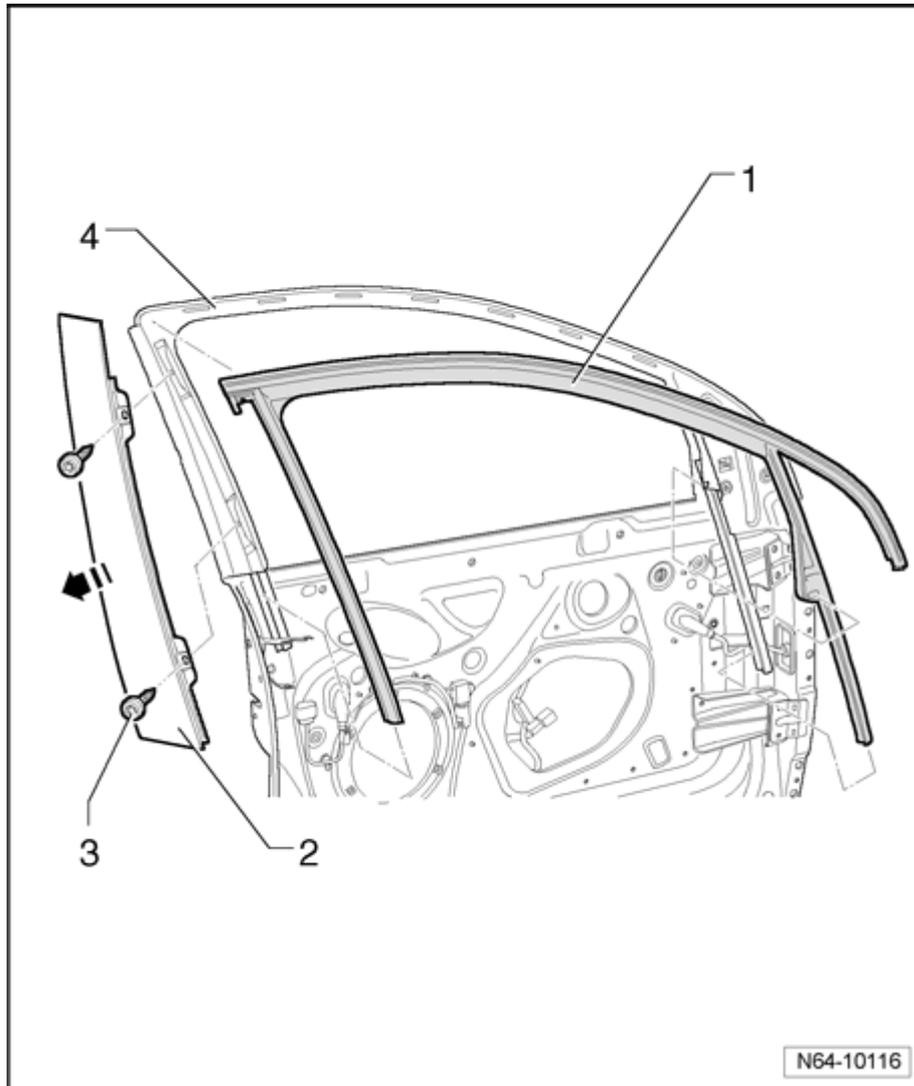


The rest of the installation is performed in  
the reverse order of removal.

## Window guide - assembly overview

### Note :

- *The description applies to the right side. The left side is derived accordingly from this.*
- *For reasons of clarity, outer door plate is not depicted in the illustration.*



- **Window guide**
- **Face plate**
- **Bolt**
  - Qty. 2
  - 2 Nm
- **Window frame at door inner part**

## Window guide, removing and installing

**Note:**

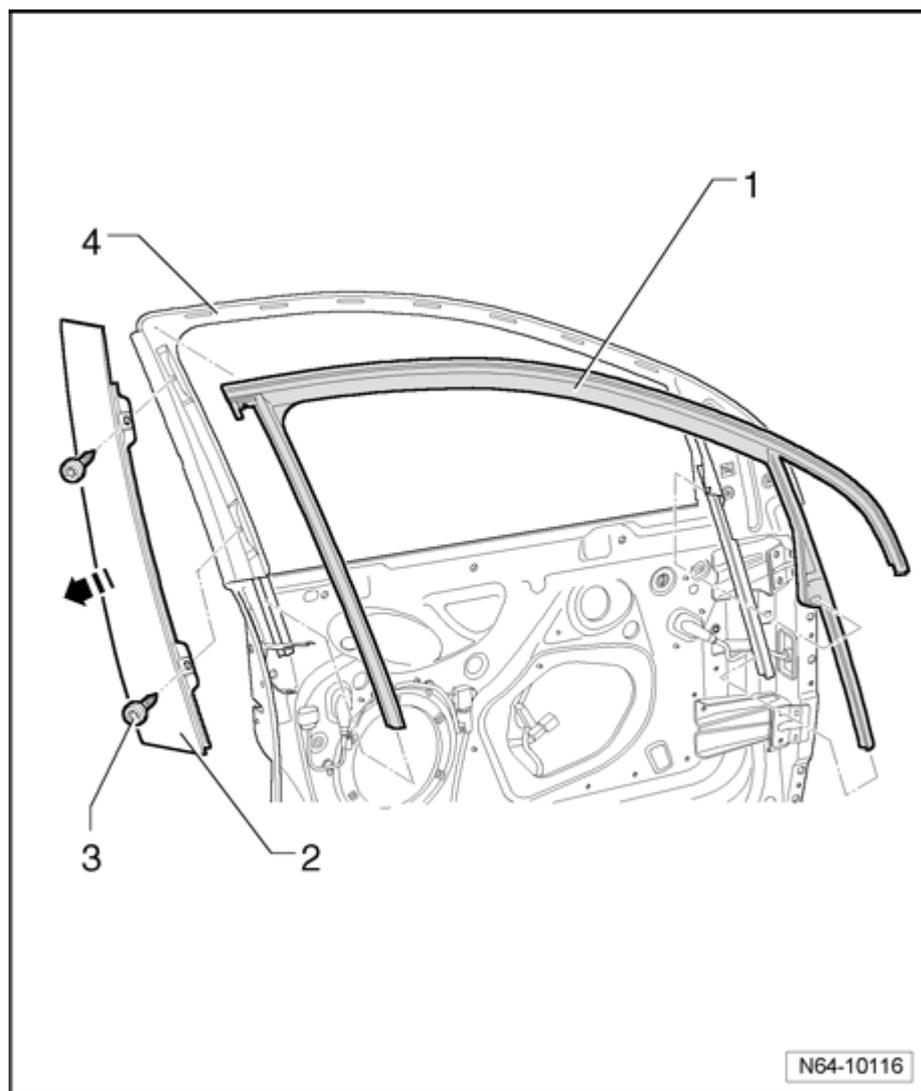
- *Removing and installing is described only for the right window guide. Removing and installing the left window guide is derived accordingly from this.*
  
- *For reasons of clarity, outer door plate is not depicted in the removal and installation.*

**Removing**

- Remove front door trim

⇒ [Repair Manual, Body Interior, Repair Group 70, Door trim](#)

- Remove rearview mirror ⇒ [66-2, Rearview mirror, removing and installing](#) .
  
- Remove door window ⇒ [64-2, Door window, removing and installing](#) .
  
- Pull window guide - **1** - out of mount.
  
- Remove bolts - **3** - (qty. 2) and pull off panel - **2** - in direction of B-pillar - **direction of arrow** - .



- Pull window guide - 1 - all around from window frame - 4 - and upward out of window shaft.

### Installing

Installation is performed in the reverse order of removal.

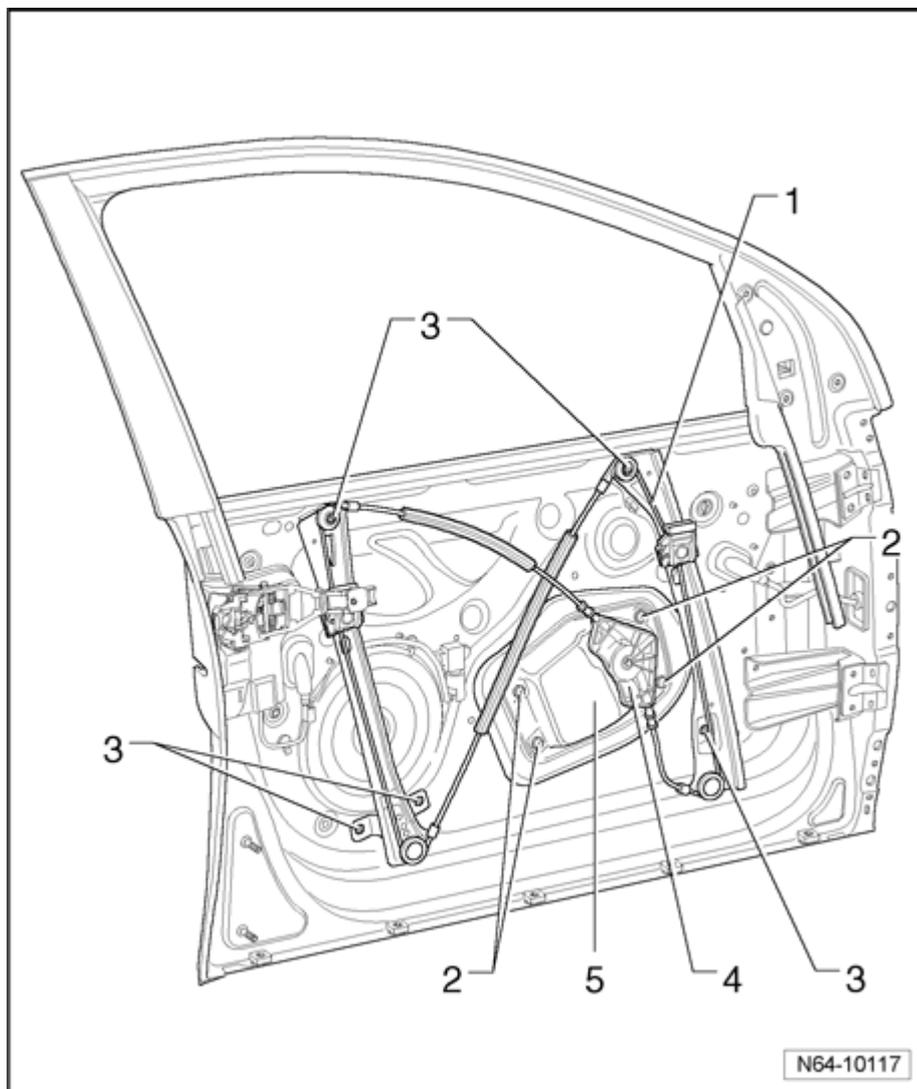
### Note:

- *While installing window guide, make sure it is seated evenly (wind noise).*

### Window regulator - assembly overview

### Note :

- *The description applies to the right side. The left side is derived accordingly from this.*



- **Window regulator**

- Removing and installing ⇒ [64-2, Window regulator, removing and installing](#)

- **Bolt**

- 4x
- 8 Nm

- **Bolt**

- 5x
- 8 Nm

- **Drive motor**

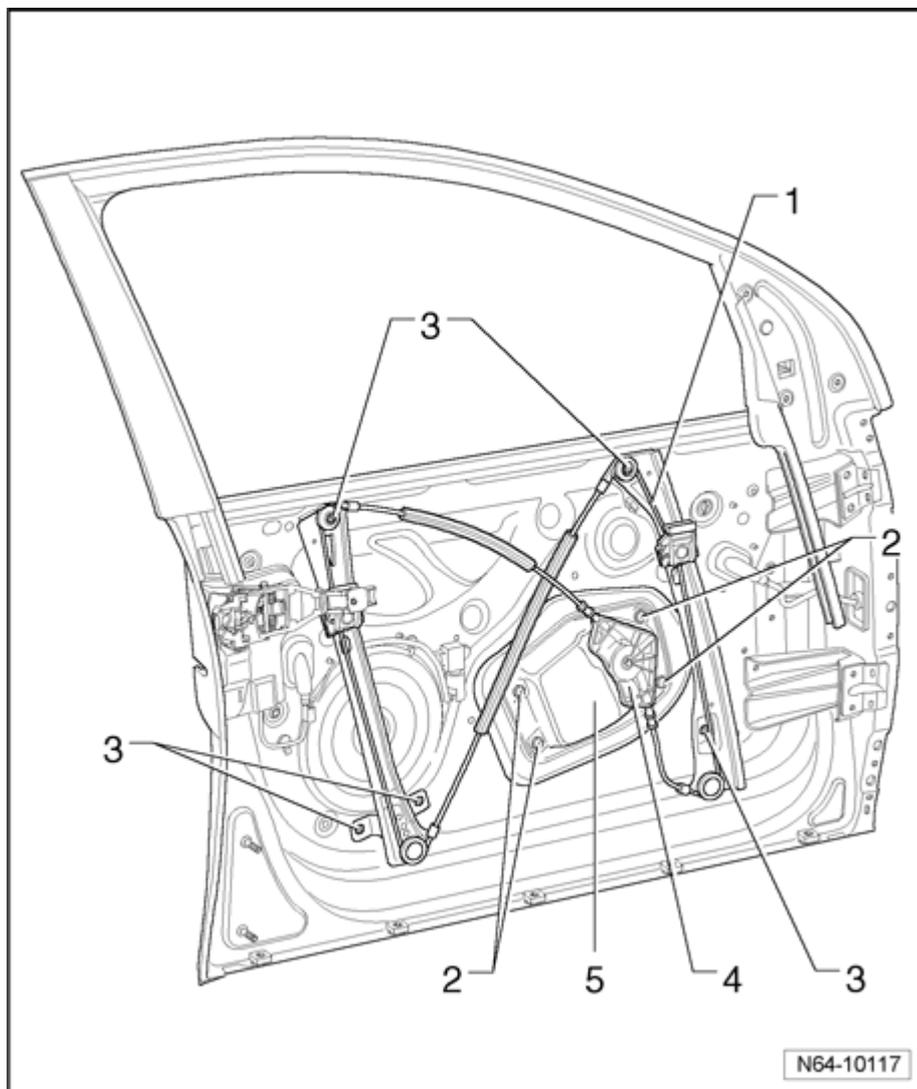
- **Mounting plate**

**Note:**

- *Removing and installing is described only for the right window regulator. Removing and installing the left window regulator is derived accordingly from this.*

**Removing**

- Remove outer door plate ⇒ [58-1, Outer door plate, removing and installing](#) .
- Remove side impact protection ⇒ [57-1, Side impact protection - assembly overview](#) .
- Remove door window ⇒ [64-2, Door window, removing and installing](#) .
- Remove bolts - **2** - from mounting plate  
- **5** - .
- Remove bolts - **3** - for window regulator.
- Remove window regulator - **1** - with drive motor - **4** - and mounting plate - **5**  
- for window regulator motor from door inner part.



- Disconnect harness connectors for window regulator motor ⇒ [64-2, Removing](#) .

### Installing

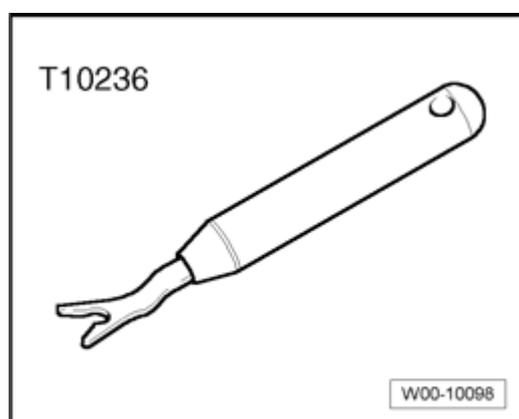
Installation is performed in the reverse order of removal.

A function test must be performed before outer door plate is installed.

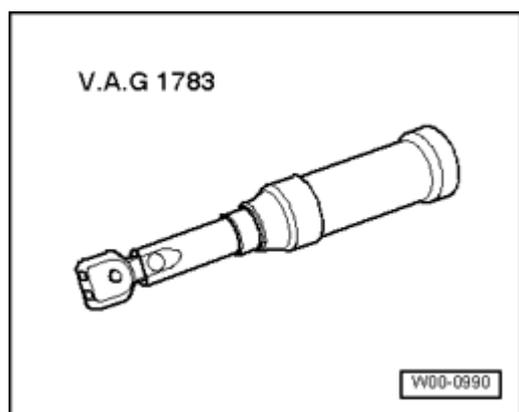
## Rear door windows

### Tools

#### Special tools, testers and auxiliary items required



- Release tool T10236

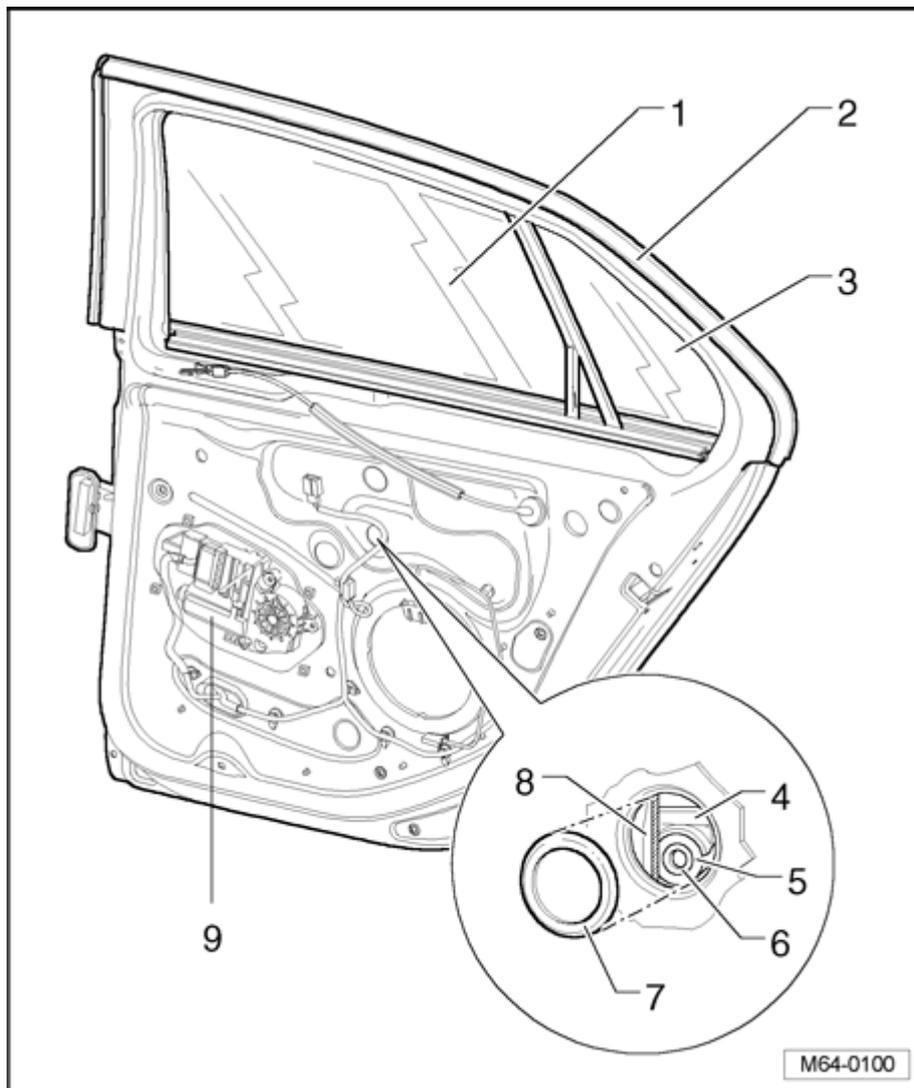


- Torque wrench (560Nm) V.A.G 1783

### Rear door windows - assembly overview

#### Note :

- *The description applies to the right side. The left side is derived accordingly from this.*



- **Door window**

- Removing and installing ⇒ [64-3, Door window, removing and installing](#)

- **Window guide**

- Component of fixed door window
- Removing and installing ⇒ [64-3, Fixed door window with window guide, removing and installing](#)

- **Fixed door window**

- Component of window guide
- Removing and installing ⇒ [64-3, Fixed door window with window guide, removing and installing](#)

- **Window regulator guide**
- **Spreader plug**
  - Always replace when performing assembly work at door window
- **Spreader pin**
  - Always replace when performing assembly work at door window
- **Concealment cap**
- **Window regulator**
  - Removing and installing ⇒ [64-3, Window regulator, removing and installing](#)
- **Window regulator motor**
  - Removing and installing ⇒ [64-3, Window regulator motor, removing and installing](#)

## Door window, removing and installing

### **Note:**

- *Removing and installing is described only for the right rear door window. Removing and installing the left rear door window is derived accordingly from this.*

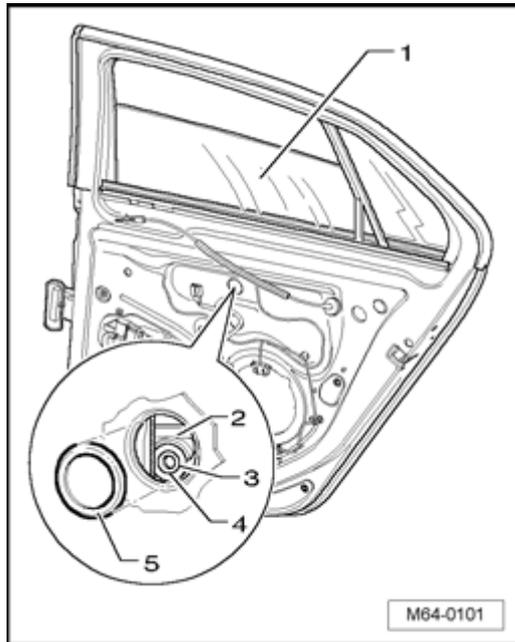
### Removing

### **Note:**

- *When removing and installing door window, spreader pin and spreader plug are also accessible from outside when outer door plate has been removed.*

- Remove rear door trim

⇒ [Repair Manual, Body Interior, Repair Group 70, Door trim](#)



- Pry out cover caps - **5** - .
- Lower door window until spreader pin - **3** - and spreader plug - **4** - are accessible in window regulator cut-out.

**Note:**

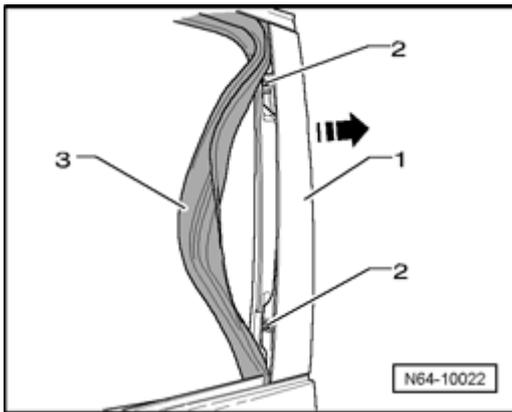
- *If the work step is not possible due to a malfunction via the electrical window regulator, window regulator motor can be unscrewed to be able to slide window down.*

- Screw in a 5 mm bolt (approx. 70 mm long) into spreader pin - **3** - and pull bolt out of spreader plug - **4** - .
- Screw a 8 mm bolt (approx. 80 mm long) into spreader plug - **4** - .

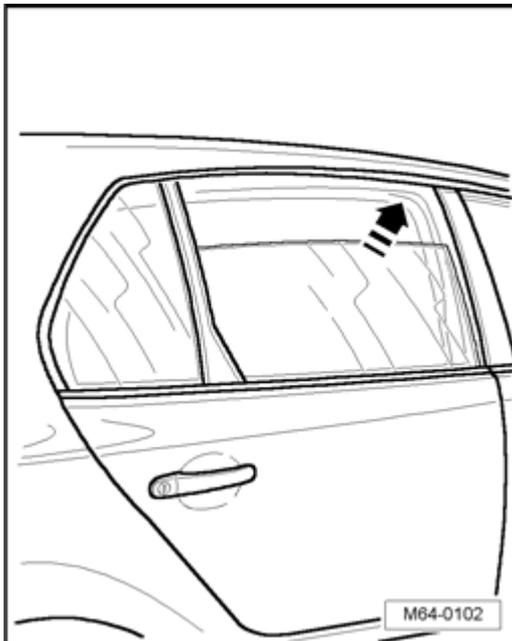
**Note:**

- *When screwing the bolt into spreader plug, do not use excessive force on the plug otherwise it may fall inside into the door.*

- Pull spreader plug - **4** - out of clamping bracket - **2** - and thereby out of door window.
- Remove window regulator motor ⇒ [64-3, Window regulator motor, removing and installing](#) .
- Slide door window down completely.



- Pull window guide - **3** - out of mount.
- Remove bolts - **2** - and pull off panel - **1** - in direction of B-pillar - **direction of arrow** - .

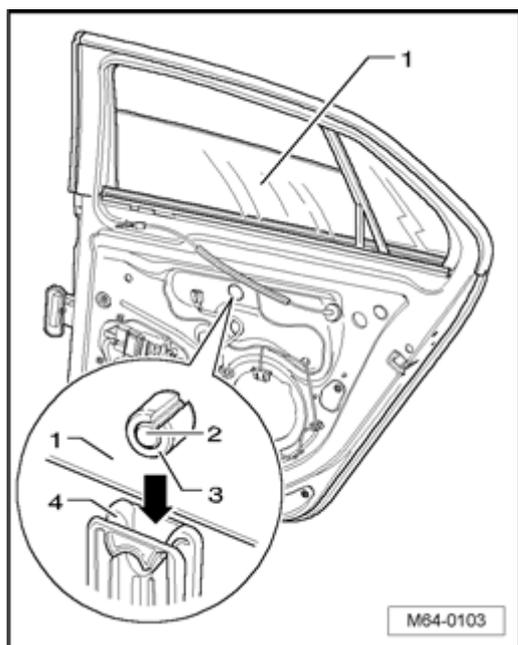


- Pull door window upward - **arrow** - out of window shaft.

### Installing

#### **Note:**

- *Spreader plug and spreader pin must always be replaced when performing assembly work on door window.*
- *Before inserting spreader plug and spreader pin, check window for damage.*



- With door window - **1** - removed, insert spreader plug - **3** - centered.
- Press spreader pin - **2** - flush into spreader plug - **3** - .
- Remove window shaft seal ⇒ [Item - 1 -](#) .
- Guide door window - **1** - into door and insert door window onto mount of window regulator guide - **4** - .
- Using a light pressure from above - **arrow** - , engage door window - **1** - into mount of window regulator guide - **4** - .
- Reinstall window shaft seal ⇒ [Item - 1 -](#) .

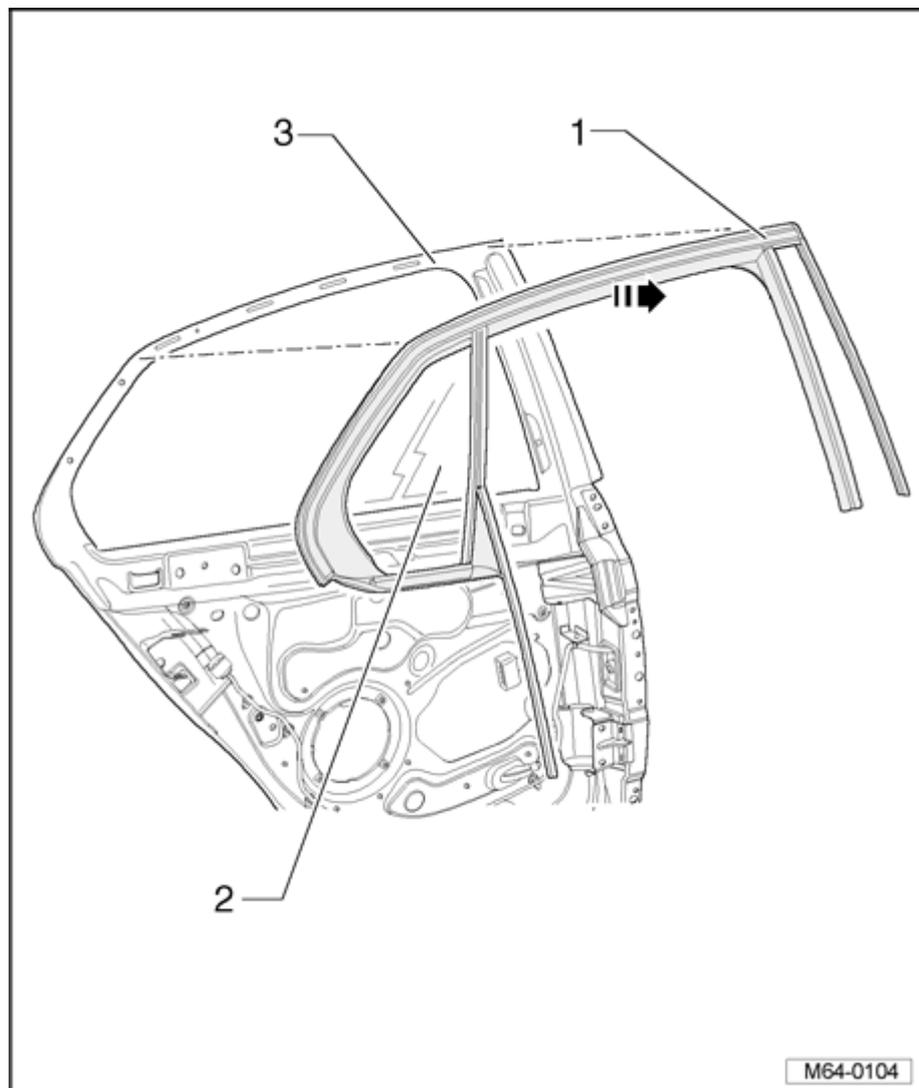
The rest of the installation is performed in the reverse order of removal.

A function test must be performed before door trim is installed.

### **Fixed door window with window guide - assembly overview**

#### **Note :**

- *The description applies to the right side. The left side is derived accordingly from this.*



- **Window guide**

- Component of fixed door window
- Removing and installing ⇒ [64-3, Fixed door window with window guide, removing and installing](#)

- **Fixed door window**

- Component of window guide
- Removing and installing ⇒ [64-3, Fixed door window with window guide, removing and installing](#)

- **Window frame at door inner part**

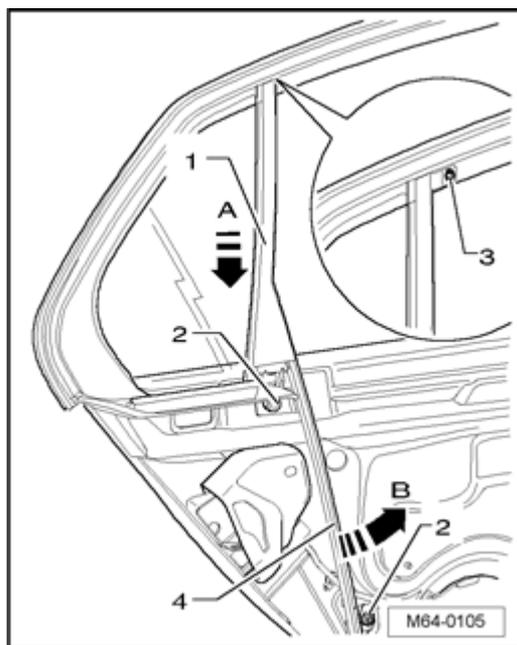
**Fixed door window with window guide, removing and installing**

**Note:**

- *Removing and installing is described only for the right fixed window with window guide. Removing and installing the left fixed window with window guide is derived accordingly from this.*
- *When removing and installing door window, spreader pin and spreader plug are also accessible from outside when outer door plate has been removed.*

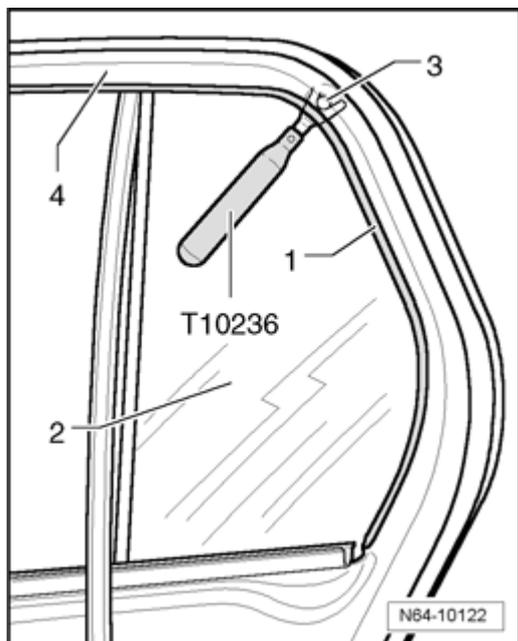
**Removing**

- Remove outer door plate ⇒ [58-1, Outer door plate, removing and installing](#) .
- Remove door window ⇒ [64-3, Door window, removing and installing](#) .

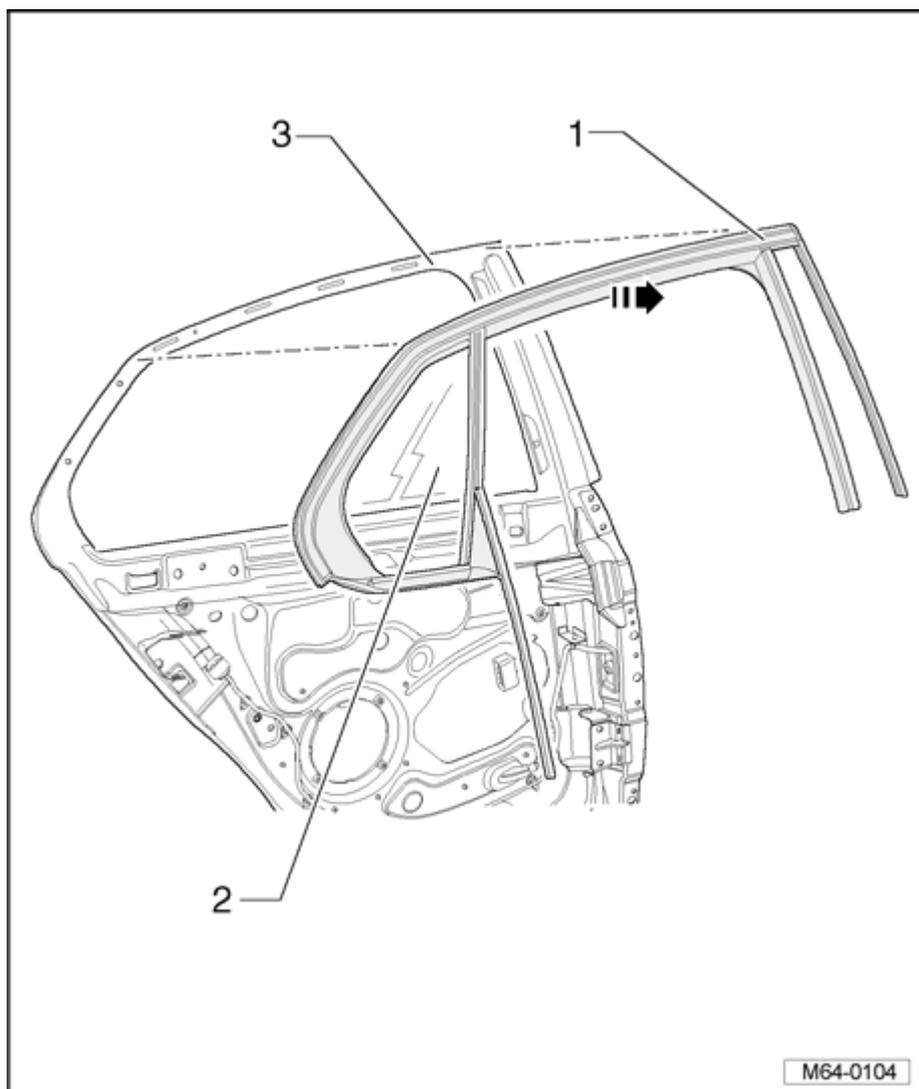


- Pull window guide - **4** - out of center bar - **1** - and guide window guide inward.
- Remove bolts - **2** - and - **3** - and slide center bar - **1** - downward - **arrow A** - .
- Remove center bar - **4** - from seal of fixed door window - **arrow B** - .

## Rear door windows



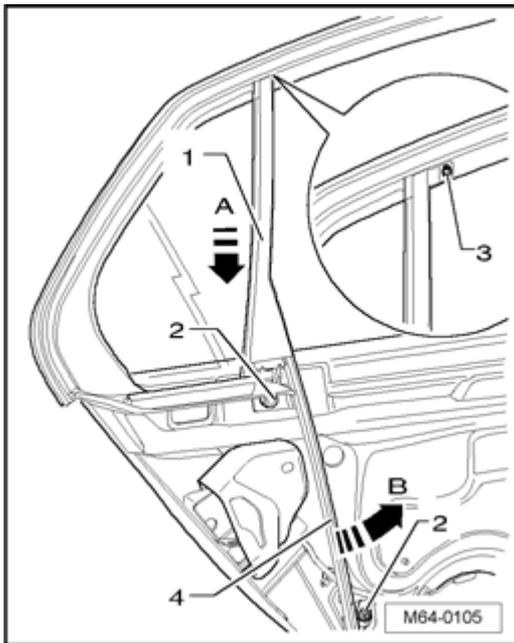
- Disengage window guide - 1 - with fixed door window - 2 - on inside and outside all around from window frame - 4 - .
- Using release tool T10236 , disengage retaining tab on guide pin - 3 - in window frame - 4 - .



- Remove complete window guide - **1** - with fixed door window - **2** - from window frame - **3** - in - **direction of arrow** - .

### Installing

Installation is performed in the reverse order of removal.



Tightening torque for bolts - **2** - on center bar: 5.5 Nm

Tightening torque for bolt - **3** - on center bar: 4.5 Nm

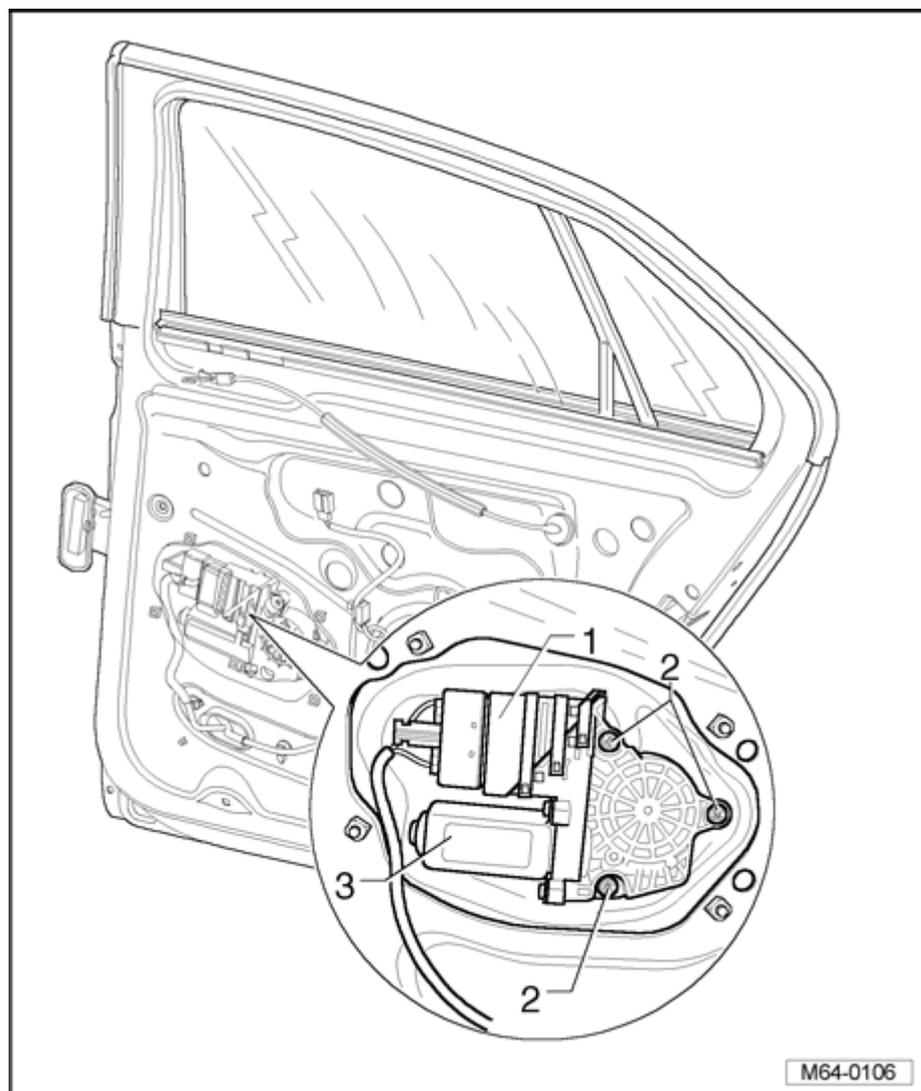
### Note:

- *While installing fixed door window with window guide, make sure it is seated evenly (wind noise).*

### Window regulator motor - assembly overview

### Note :

- *The description applies to the right side. The left side is derived accordingly from this.*



- **Harness connector**
- **Bolt**
  - Qty. 3
  - 3.5 Nm
- **Window regulator motor**
  - Removing and installing ⇒ [64-3, Window regulator motor, removing and installing](#)

### Window regulator motor, removing and installing

**Note:**

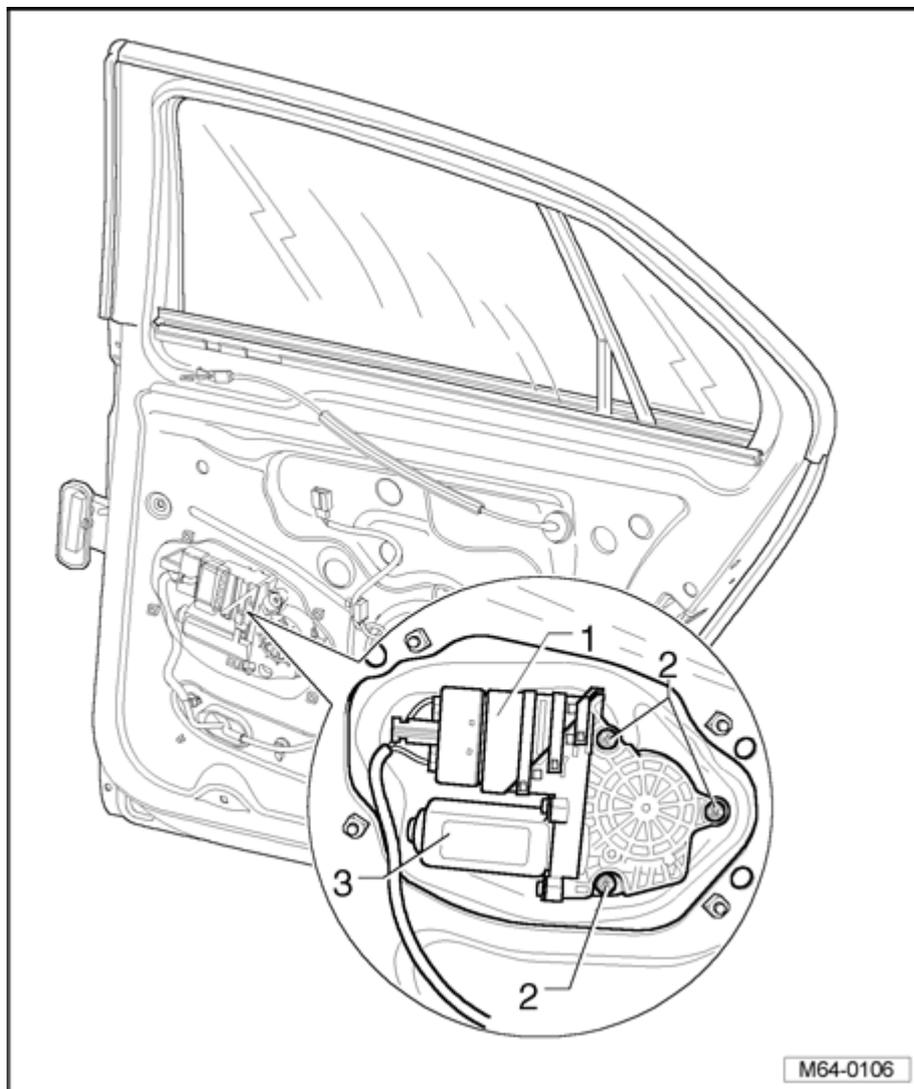
- *Removing and installing is described only for the right window regulator motor. Removing and installing the left window regulator motor is derived accordingly from this.*

## Removing

- Remove door trim

⇒ [Repair Manual, Body Interior, Repair Group 70, door trim](#)

- Fix window using adhesive tape so that it does not slip down.
- Remove three bolts - **2** - .
- Disconnect harness connector - **1** - .



- Remove window regulator motor with control module - **3** - from mounting plate.

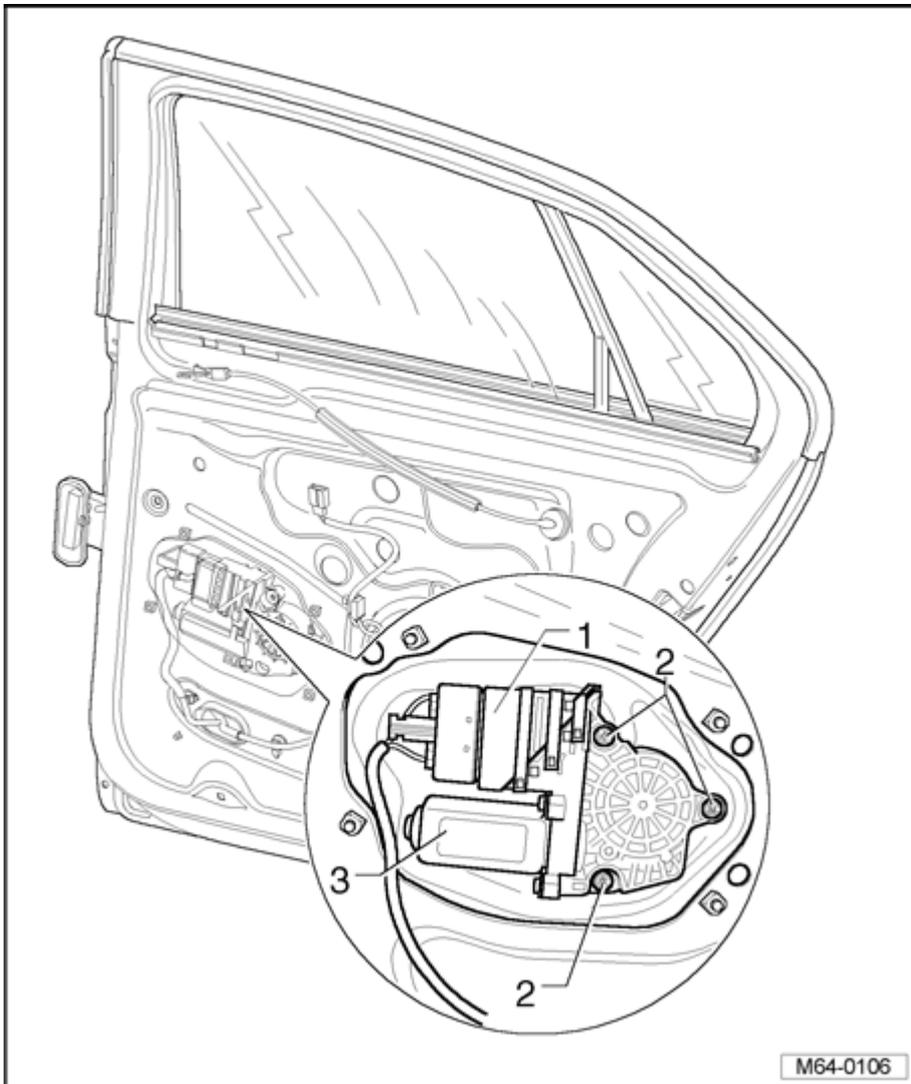
## Installing

## Rear door windows

- Attach window regulator motor - **3** - and connect harness connector - **1** - .
- Pull door window lightly up and down so that splines are located better between motor and cable drum.
- Tighten bolts - **2** - for window regulator motor.

Tightening torques for bolts - **2** - : 3.5 Nm

- Drive window regulator twice upward and downward to stop. By doing this, window regulator motor is initialized and ready for operation and activates pinch protection.

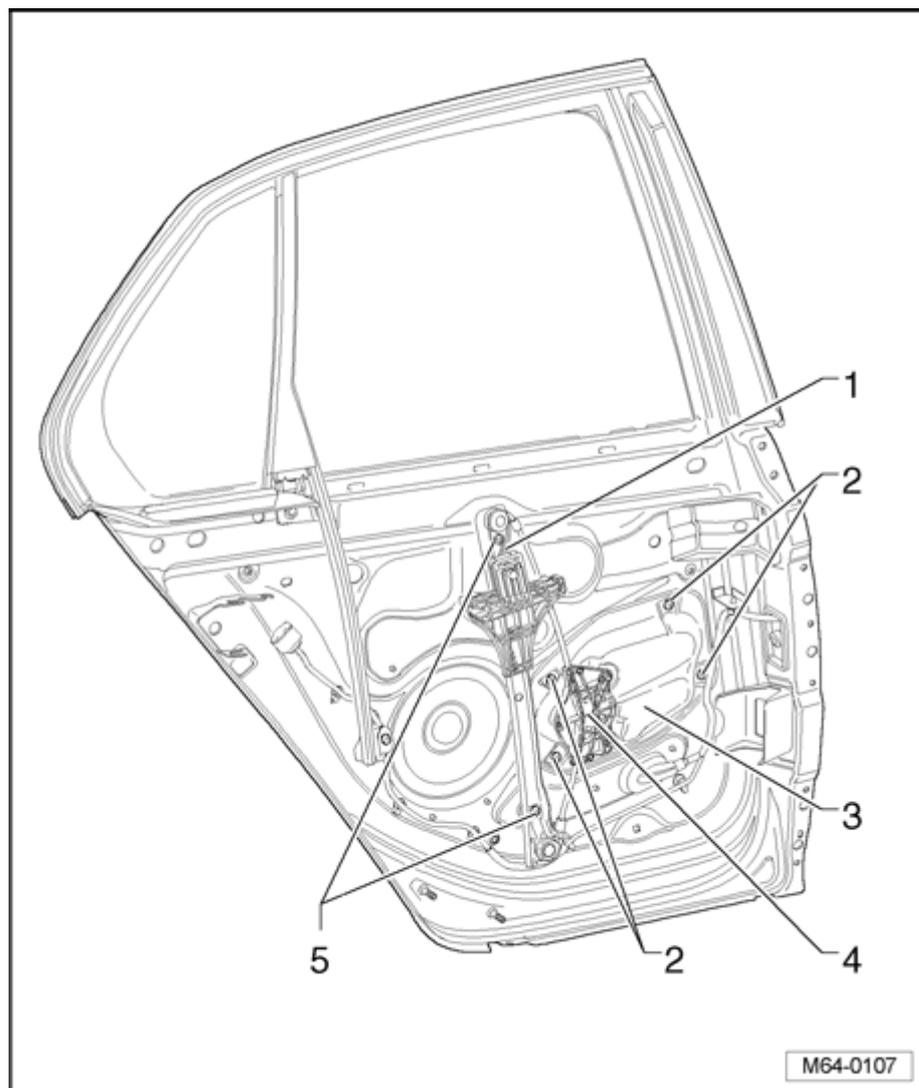


The rest of the installation is performed in the reverse order of removal.

### Window regulator - assembly overview

**Note :**

- *The description applies to the right side. The left side is derived accordingly from this.*



- **Window regulator**

- Removing and installing ⇒ [64-3, Window regulator, removing and installing](#)

- **Bolt**

- 4x
- 8 Nm

- **Mounting plate**

- **Drive motor**

- **Bolt**

- Qty. 2
- 8 Nm

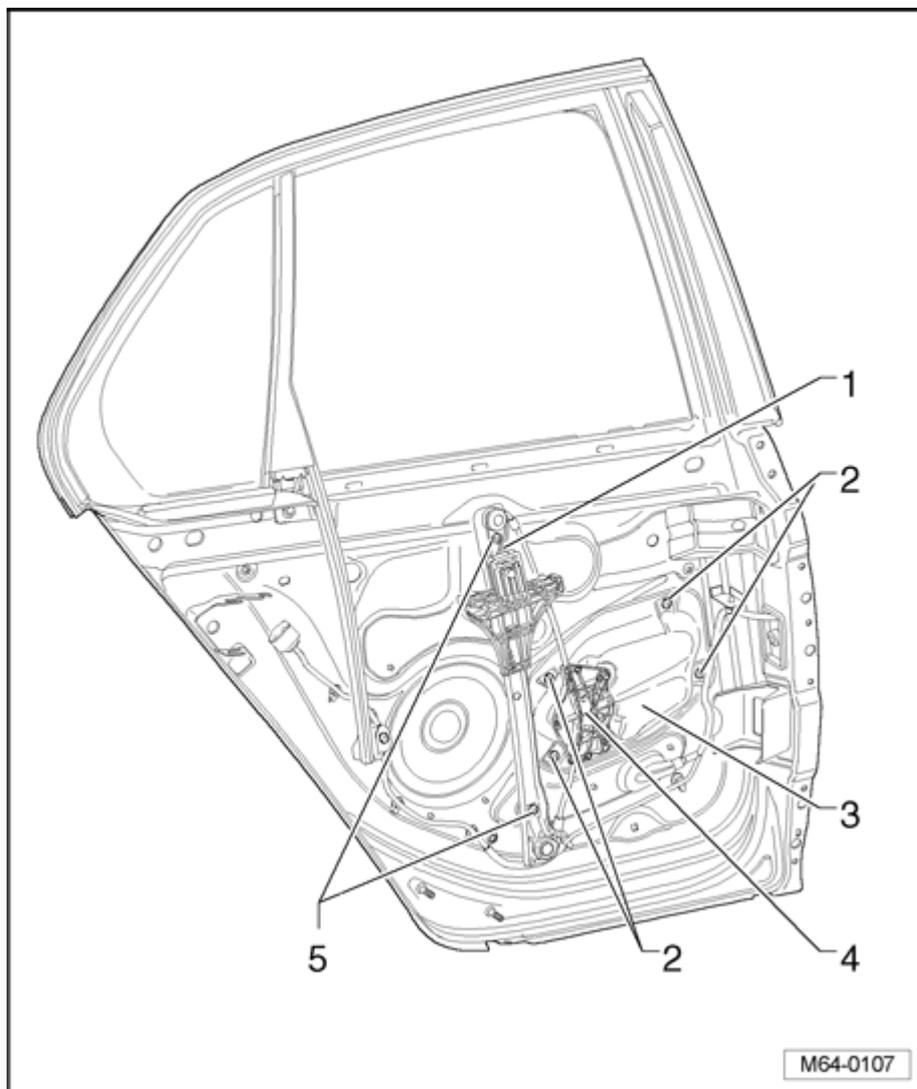
## Window regulator, removing and installing

### **Note:**

- *Removing and installing is described only for the right window regulator. Removing and installing the left window regulator is derived accordingly from this.*
- *For reasons of clarity, side impact protection is not depicted.*

### **Removing**

- Remove outer door plate ⇒ [58-1, Outer door plate, removing and installing](#) .
- Remove door window ⇒ [64-3, Door window, removing and installing](#) .
- Remove bolts - **2** - from mounting plate
- **3** - .
- Remove bolts - **5** - for window regulator.



- Remove window regulator - **1** - with drive motor - **4** - and mounting plate - **3**
- for window regulator motor from door inner part.

### **Installing**

Installation is performed in the reverse order of removal.

A function test must be performed before outer door plate is installed.