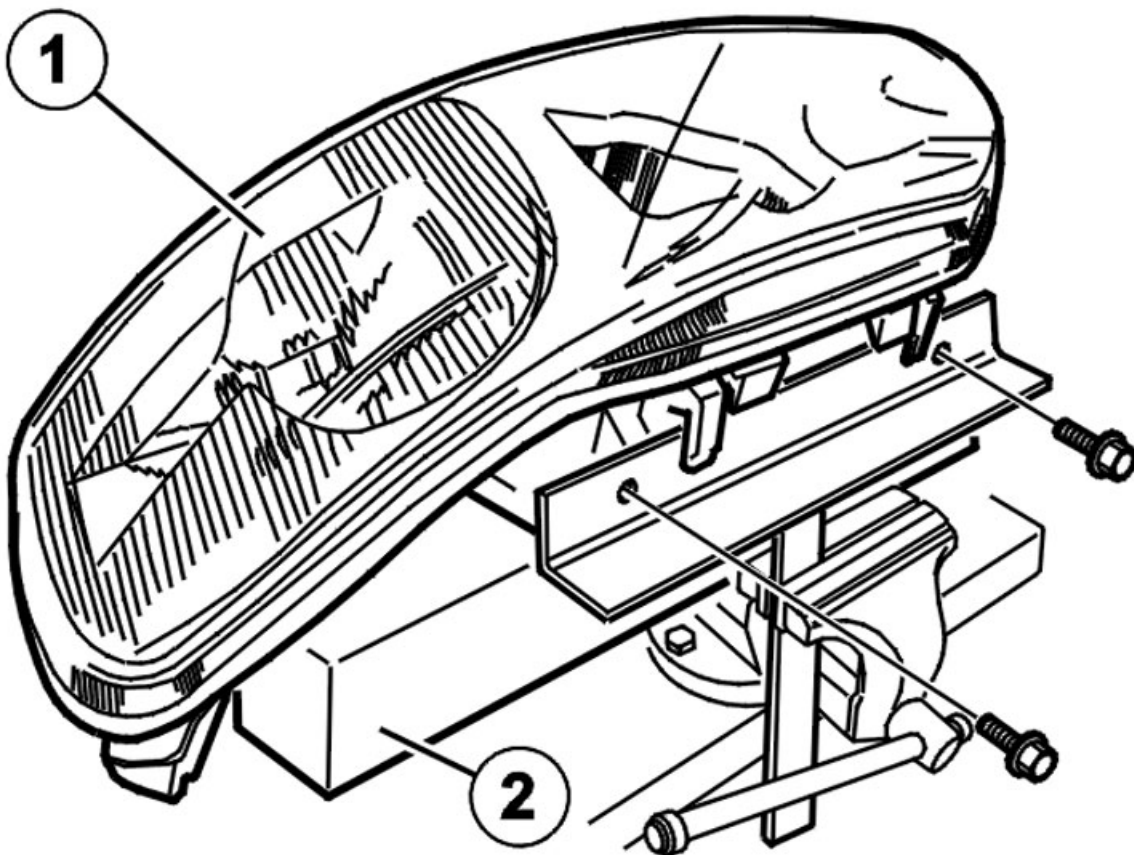


Instructions to Replacing Headlamp Lenses

Required Tools

- A tool for removing adhesive residue
- A tool for spreading out the adhesive
- Hot-air gun
- Knife
- Masking tape / paper as protection (the reflector)
- Protective goggles
- Leather gloves
- Isopropanol cleaning agent (Volvo Part Nr 1161721)
- Bonding adhesive (Volvo Part Nr 1161377)
- Glass Primer (Volvo Part Nr 1161515)
- Window cleaner
- Can of compressed air

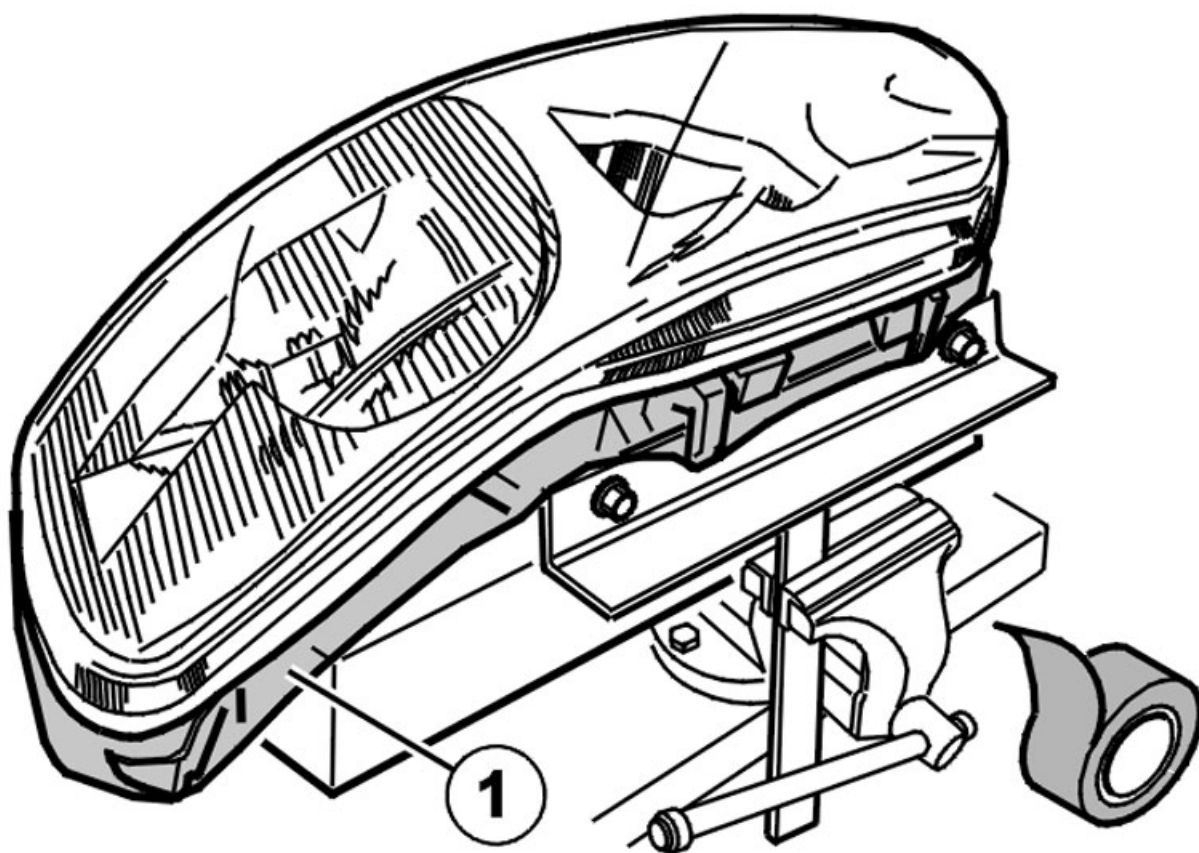


Using a mounting

Secure the mounting in the vise.

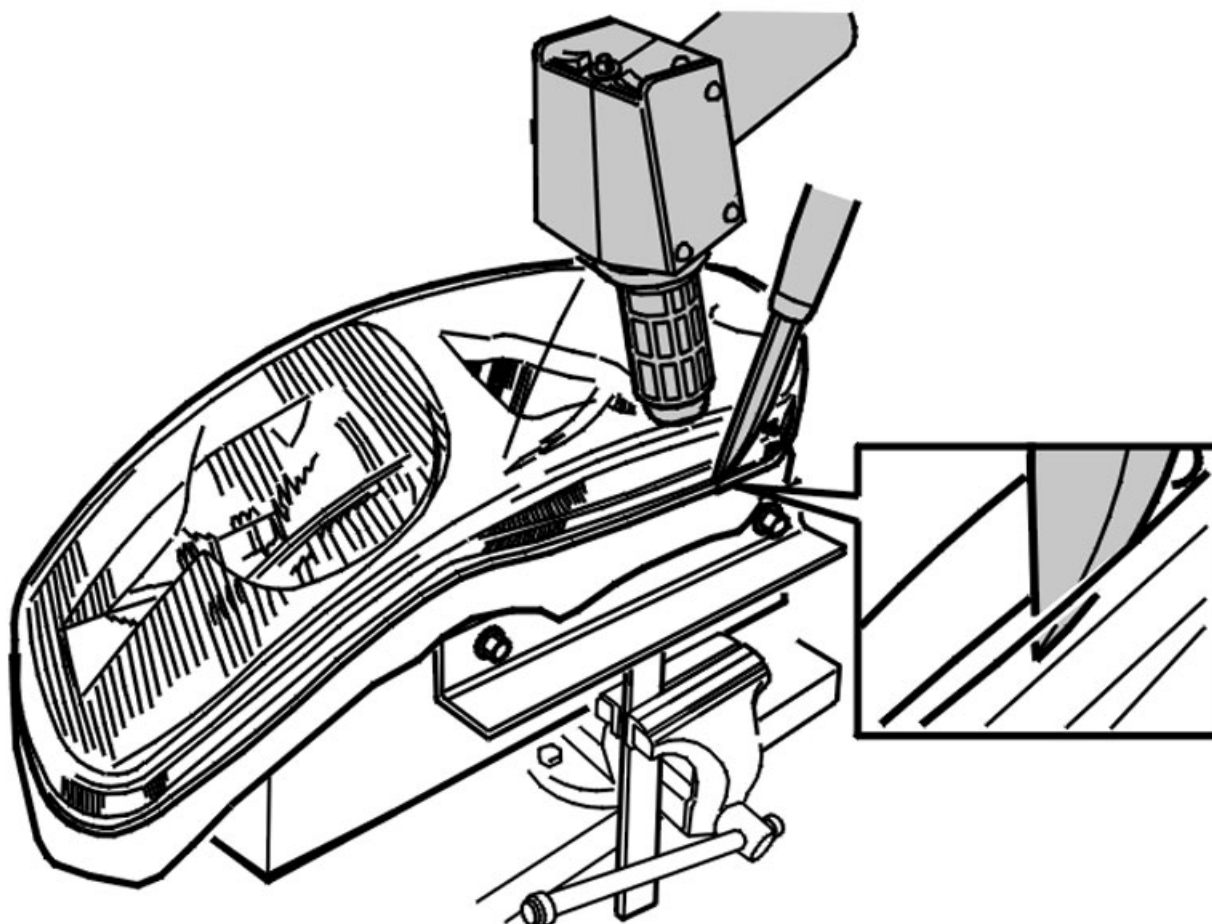
Secure the mounting on the top of the headlamp housing using the screws in the nuts (tighten carefully). Place a piece of wood (2) under the housing as support. Remove the trim strip.

Remove the clips (1) holding the glass. Mark the position of the clips for reinstallation.



Using masking tape

This protects the housing from adhesive residue when removing the lense (adhesive residue is difficult to remove). Tape around the housing, the black area in the illustration (1) towards the edges of the lense. Also tape the mounting points for the trim strip.



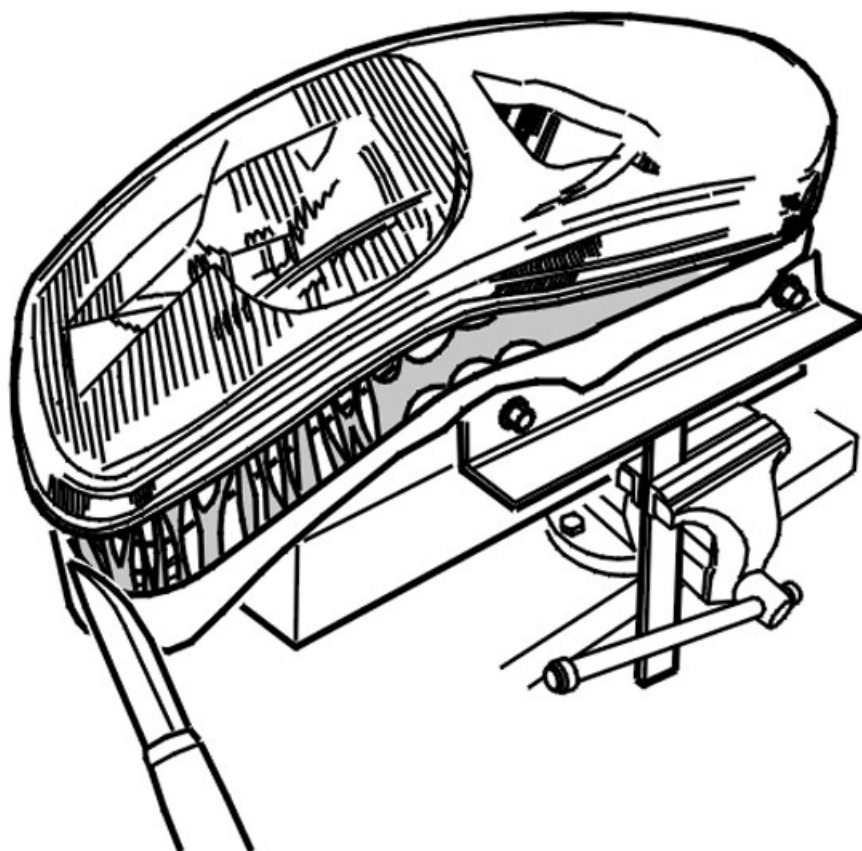
Removing the headlamp lens

Note! Do not heat the edge or groove on the housing; it may deform.

Wear protective gloves.

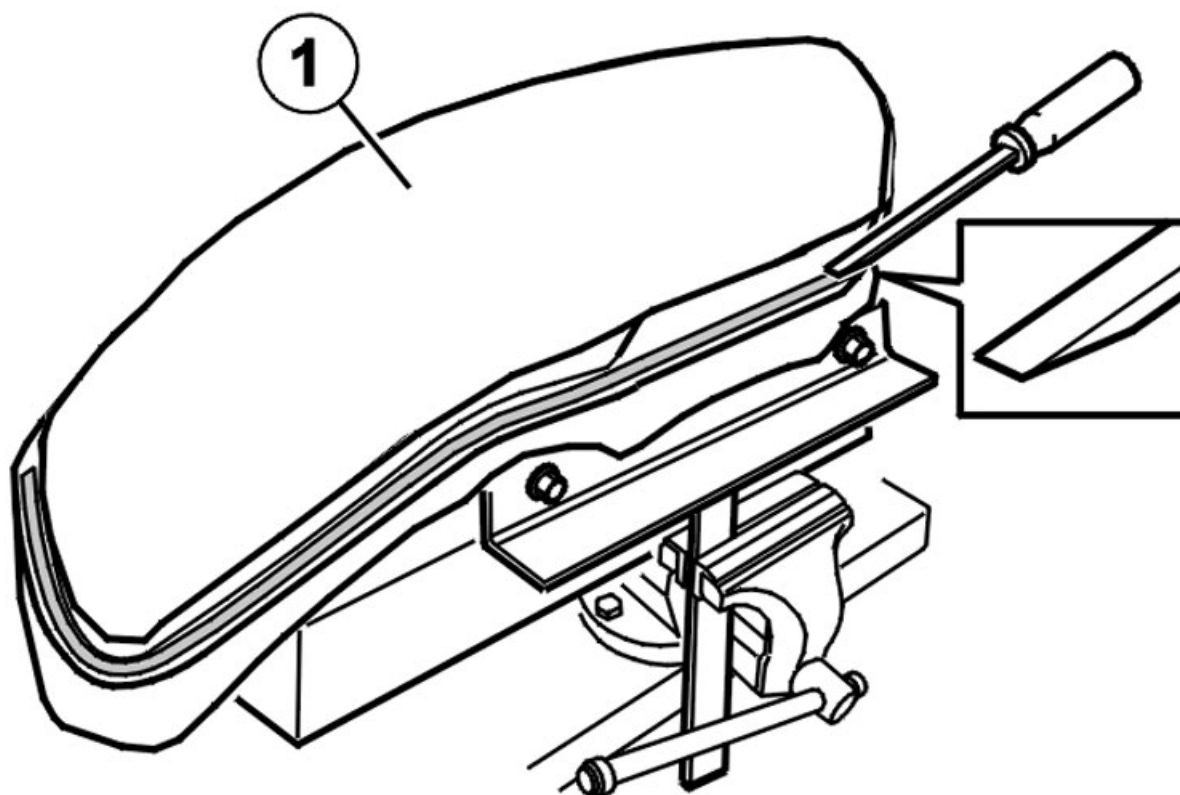
Begin by heating around the top of the lense towards the bonding in the housing. Use a high heat setting so that the lense become very hot (the hotter it is, the easier it is for the knife to penetrate the adhesive).

Insert the knife between the lense and the plastic edge. Carefully run the knife through the adhesive all the way around the housing a couple of times while heating the top of the lense. Do not damage the plastic edge with the knife.



Note! The adhesive leaves strings which will stick to the base and are difficult to remove. Pry the glass straight up approximately 5 cm. Start at the side of the outer end. Do not damage the plastic edge on the housing. Lift and hold up the lense.

Using the knife, gradually remove the adhesive from the inside of the housing all the way around, ensuring that no adhesive residue gets on the black trim panel when the lense is lifted straight up from the housing.



Removing adhesive residue from the groove

Caution! Use protective goggles. Protect reflectors / black trim panel using paper and masking tape.

Let the adhesive cool a little in the groove. This will make it easier to remove.

Cut the adhesive along both sides using the tool. Then remove the adhesive residue from the groove using tool 999 7066 until there is an even surface in the groove.

Remove the adhesive residue from the tool using a piece of paper.

The groove does not need to be completely clean. Any remaining residue will be evened out using a hot-air gun and screwdriver.

Remove the adhesive residue from the panel on the inside of the housing. Use denatured alcohol.

Preparations before bonding

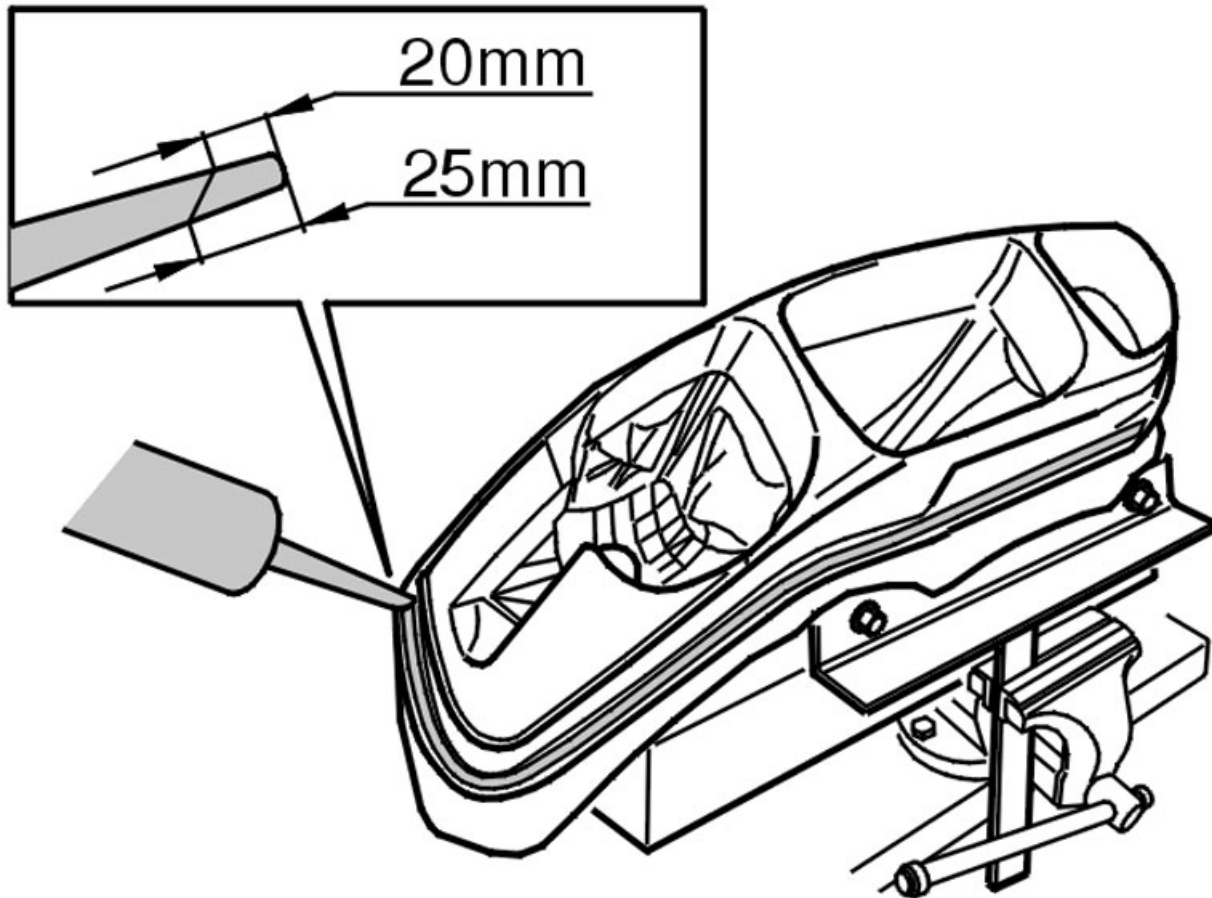
Insert the adhesive tube in the adhesive gun.

Cut the tip of the adhesive tube at an angle.

Treat the mating surface using glass activator (P/N 1161 514) before bonding.

- Bonding adhesive P/N: 1161377 (BLACK)
- Glass primer 1161515
- Brush (10-15 mm wide)
- Isopropanol cleaning agent (P/N 1161 721)
- Window cleaner.
- Remove the backing and masking tape from the reflector / black trim panel
- Carefully blow clean around the reflector and in the housing if necessary
- Remove the clips. Compress the clips slightly using pliers.

Re-tape the lower section of the housing if necessary.



Installing the headlamp lens

Lense bonding

Fill the groove with adhesive all the way around so that it is about a millimeter lower than the height of the groove. Carefully smooth out the adhesive using a brush.

Installing the headlamps lense

Apply glass primer all around the edge of the lense.

Position the lense in the groove and press it into place.

Position and press the clips into place. A further 2 clips must installed at the serrated mountings at the marking.

Wipe away any excess adhesive from the housing.

Remove the masking tape around the housing.

Position the headlamp housing with the lense upwards (leave it in the mounting if applicable) while it cures. This takes approximately 12hours because the adhesive is a one-part cure adhesive.

Clean the headlamp lense using denatured alcohol and window cleaner.

Reinstall the trim strip over the housing.

Installing the headlamp lense

Remove the housing from the mounting.

Install the headlamp.

Check the light and align the headlamp.

Removing a broken/cracked headlamp lense

If the lense is completely broken or cracked but the reflector is intact, tape the lense (2) as illustrate so that the glass shards cannot damage the reflector.

