

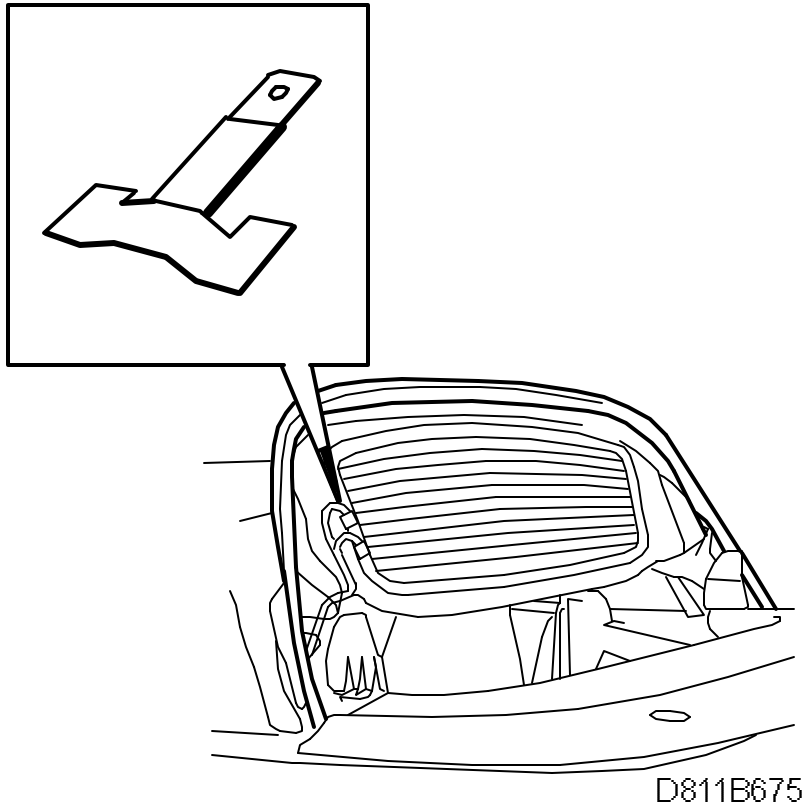
SERVICE INFORMATION

Bulletin Nbr: 811-1950

Date:.....Oktober 1999

Market: all

Replacing connecting tab on electrically heated rear window



D811B675

Cars affected

Saab 9-3 CV

Background

Previously, when the connecting tab on the electrically heated rear window had come loose, it was necessary to replace the entire rear window. It is now possible to fit a new connecting tab instead by using conductive adhesive.

Parts required

51 82 985 Connecting tab (CA: 30582153)

82 93 235 Adhesive (sufficient for 10 cars)

Special tools

83 95 238 Wedge (2 pcs.)

30 12 598 Pliers

Other materials

30 15 815 Cleaner, Teroson FL 875 (CA: 30559941)

Abrasive cloth, grade P1200


Clip (with weak spring)

Hot-air gun

Procedure

This service information assumes that fault diagnosis has been carried out and that the cause of the fault has been located to the electrically heated rear window connecting tab being loose. Always check both connecting tabs.

The following instructions apply to replacing one connecting tab. If both tabs require replacement, this should be carried out at the same time.

 **Warning**

This procedure involves the use of corrosive adhesive that emits harmful fumes and can irritate eyes and skin.

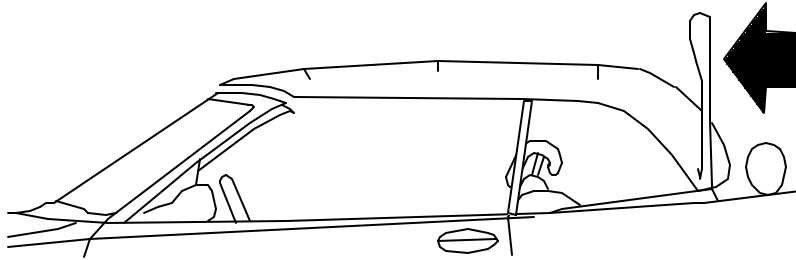
Therefore, perform the necessary safety procedures:

- Use protective gloves.
- Provide good ventilation.

Important

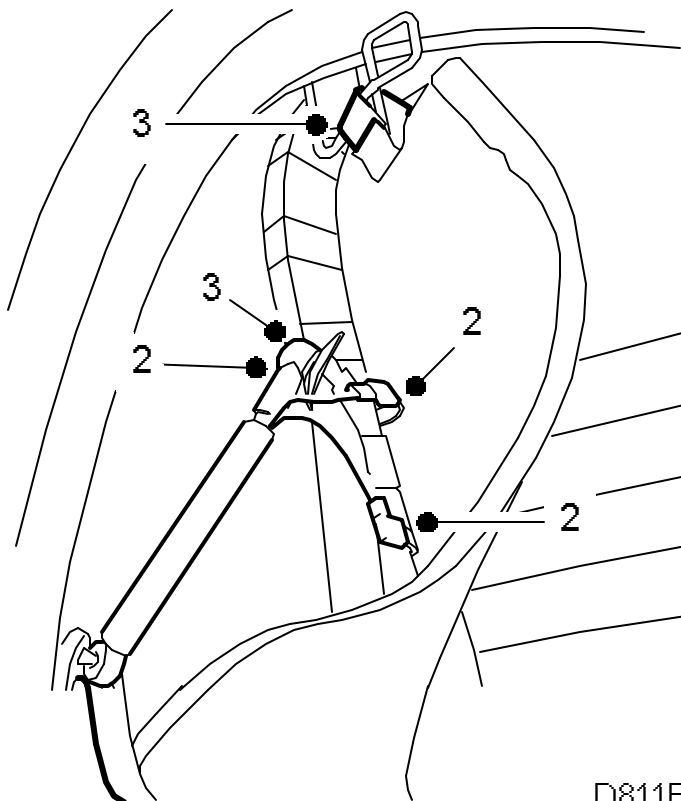
The ambient temperature must be at least 20 °C (68 °F) when gluing the electrically heated rear window connecting tab due to the curing time of the adhesive.

1. Operate the soft top so that the fifth bow rises.



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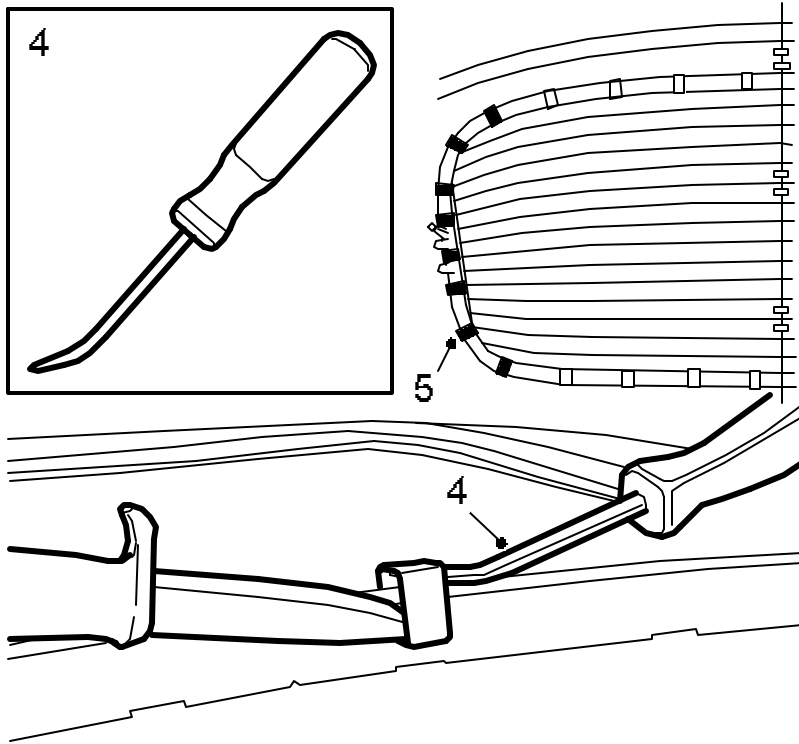
2. Cut off the cable ties and remove them. Unplug the two connectors from the connecting tabs.



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3. Loosen the window guide. Undo the straps on the fifth bow latch.

4.



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In order to reach the connecting tabs, a few of the window clips must be removed so that the window frame can be lifted. Make a tool similar to the one in the illustration. Loosen each clip as follows:

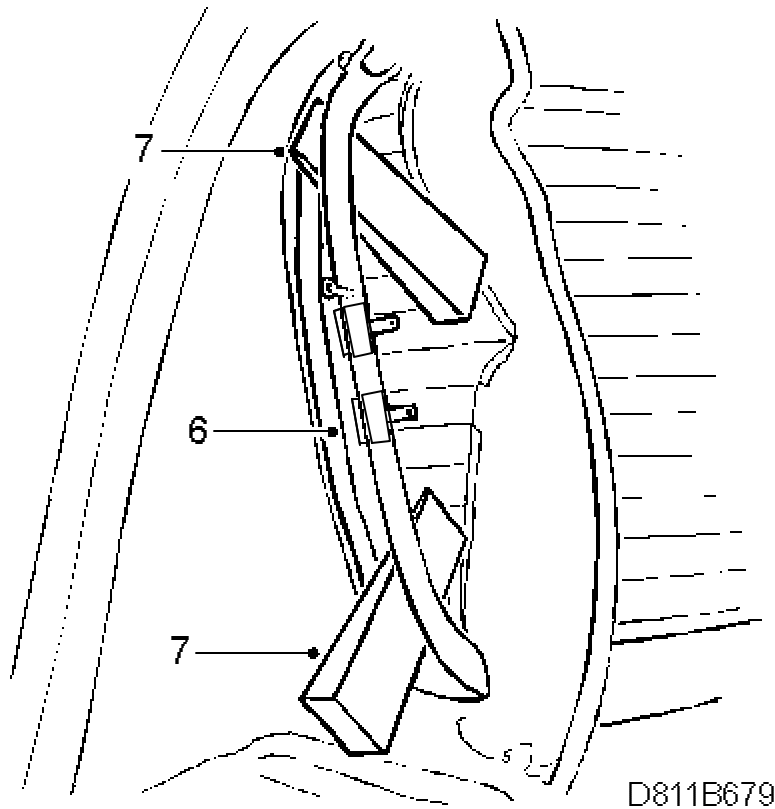
Important

Be careful with the knife so the headlining is not damaged.

- Lift up the clip with the tool and insert the knife underneath it.
- Pull up the clip using the tool and follow with the knife so that the window frame is not damaged.

5. Loosen eight of the clips on the window frame as described above.

6. Lift up the window frame. Pull off the rubber strip and bend it down to reveal the connecting points. See the illustration.

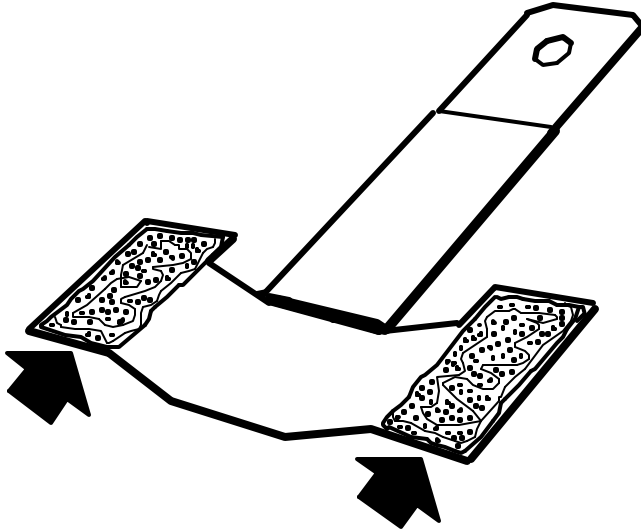


7. Carefully place two wedges 83 95 238 between the window and the frame.
8. Carefully remove as much of the old solder from the window as possible without damaging the plating (the conductive material). Use a sharp knife. Smooth off the surface of the window connecting points to make them level.
9. Rub the surface where the new connecting tab is to be fitted with the abrasive cloth (P1200).
10. Clean the new connecting tab and the window with cleaner, Teroson FL 875 (part no. 30 15 815).

Clean also the surface on which the adhesive is to be mixed so that it is not contaminated with foreign substances.

If the window frame has been scored or damaged by the clips during removal, the damaged areas may require corrosion protection.

11.

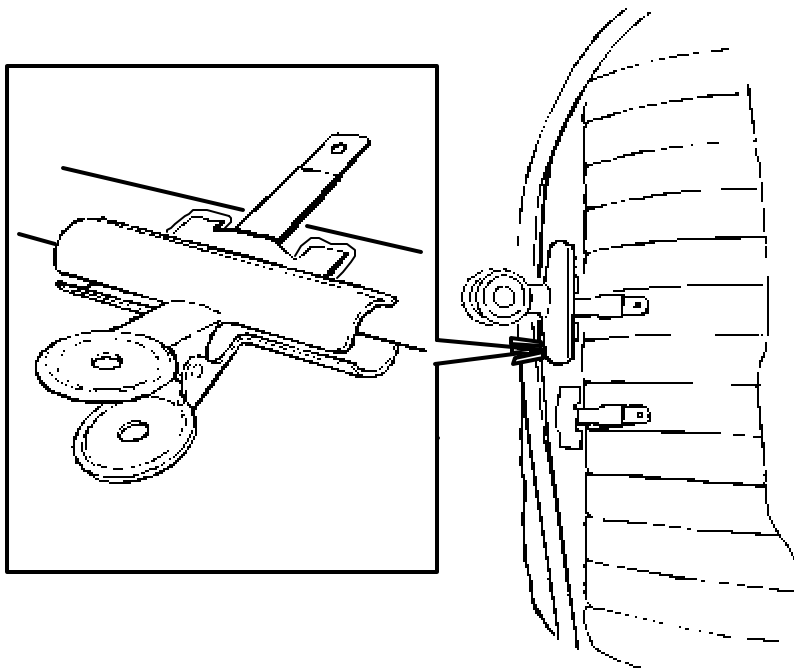


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Squeeze out about 1.5 centimetres (1/2") of each tube, "Part A" and "Part B". Mix thoroughly.

12. Apply the adhesive to the new connecting tab.

13. Place the new connecting tab in the same position as the old one. Make sure the adhesive flows up against the side of the connecting tab. See illustration.



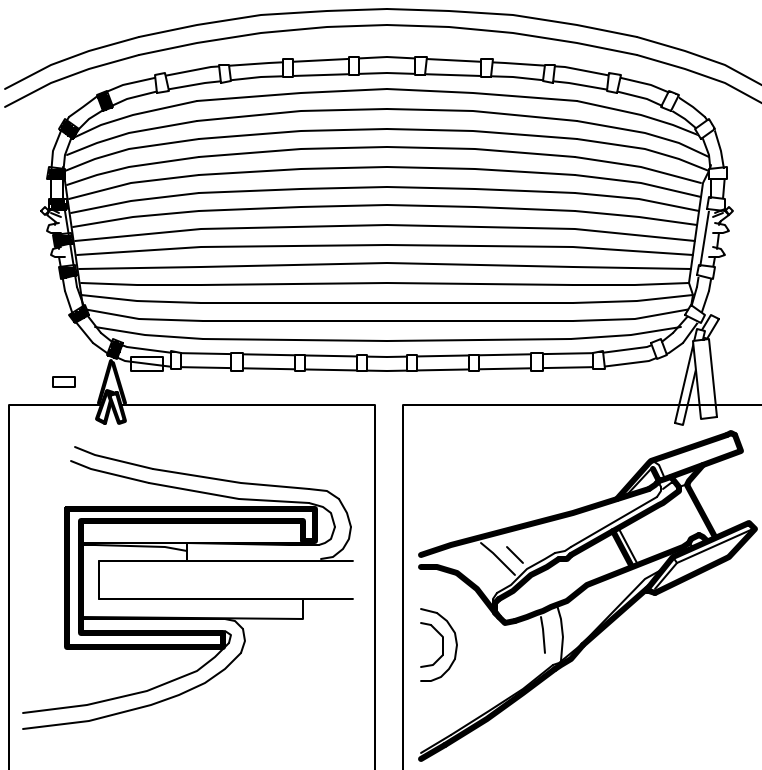
Important

It is essential that the connecting tab is not disturbed during curing.


The temperature of the connecting tab must not exceed approx. 55 °C (131 °F) when using the hot-air gun.

Hold the connecting tab in place using a clip with a weak spring. Heat carefully for 15 minutes with the hot-air gun. This time applies when the ambient temperature is at least 20 °C (68 °F).

14. Wait until the window and connecting tab have cooled down before refitting the removed parts and plugging in the connector for the electrically heated rear window.
15. Remove the clip and the wedges.
16. Refit the rubber strip.
17. Fit the window frame as follows.



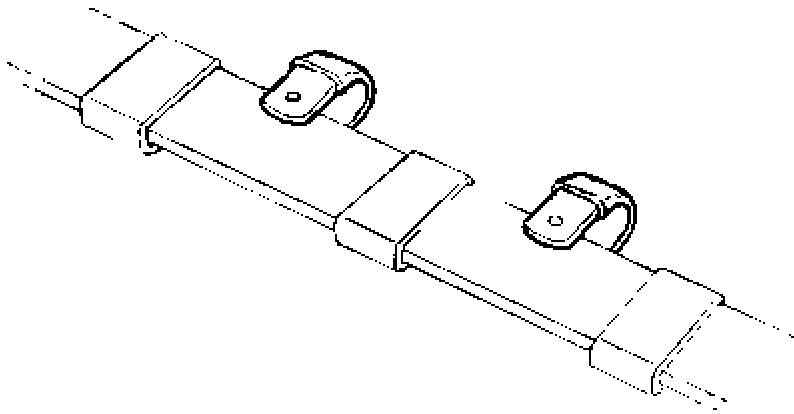
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 **Warning**

Use protective goggles as the clips can come loose from the pliers

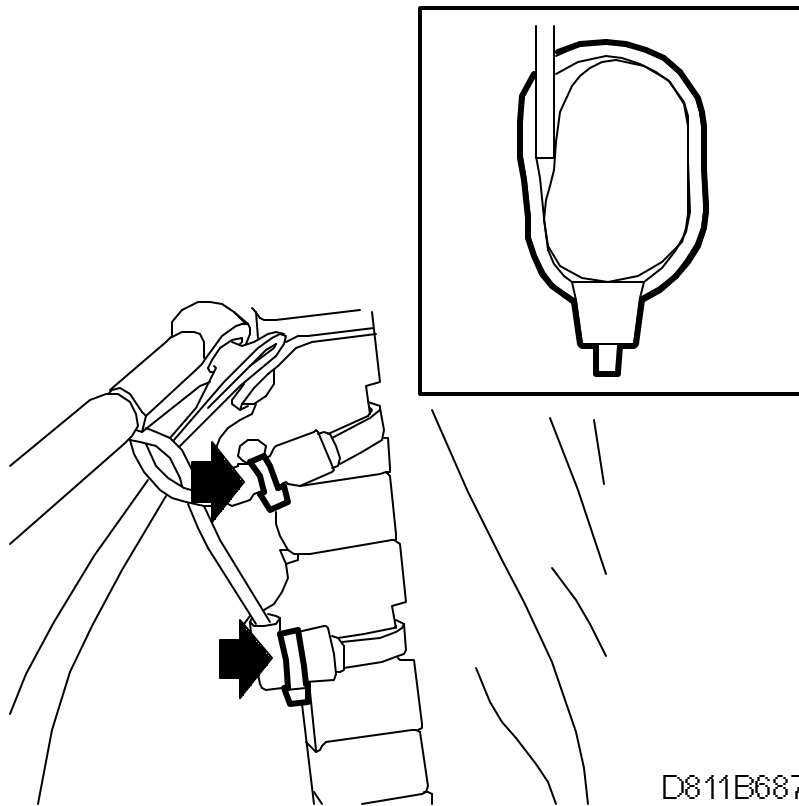
Use special tool 30 12 598 to expand the clips. Fit each clip to the frame. Make sure the headlining is not creased.

18. Bend up the insulated end of the connecting tab. The tab must not be against the window frame.



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19. Fit the two connectors to the connecting tab.
20. Fit the two cable ties. See illustration.



21. Fit the straps to the window guide and the fifth bow lock braces
22. Fit the window guide.
23. Secure the connector cables to the window frame with cable ties.
24. Close the soft top and check that the electrically heated rear window is working.

Warranty/Time information

Failed Object: 37166

Fault/Reason code: 35

Location code: 09

Warranty Type (US): 01

Repair/Action code: 01

Labour Operation (US): Straight time (CA: R2180)

Time: 1 tab - 1 hr; 2 tabs - 1.2 hrs