

# Technical Bulletin

World leader in after market vehicle defroster solutions

## Repairing broken rear window defroster tabs and missing defroster pulled off by tab.

When a metal tab separates from the defroster it can pull away some of the defroster coating from the glass. Sometimes the tab breaks leaving the base of the tab still attached to the defroster.

Fortunately this damage is easy to repair and something you can do yourself to save the high cost of glass replacement.

### Repair missing defroster pulled off by tab

It is common for some of the defroster coating to be pulled off with the tab as it separates from the defroster. In these cases the damaged area can be repaired and the tab re attached using the 2000 Tab Bonding Kit's highly conductive silver adhesive.

This type of damage is especially common if multiple repair attempts



Defroster tab separation

using solder or Brand X repair kit.

The first step is to create a small pad of conductive coating over the damaged area on the defroster.

First clean up and smooth the damaged area. A screw driver can be used to scrape the area and then sandpapered for a relatively smooth surface. The goal is a good conductive bond between the defroster and the replacement tab.

Using masking tape mask off an area that covers the damaged area on

the defroster and incorporates some of the undamaged defroster. Add a second layer of tape on top of the original making tape so there are TWO tape thicknesses around the bonding site.

### New tab or not?

If the defroster tab is not damaged, remove it from the connector and sand the base to bare metal so a good contact can be made. If the tab is broken or damaged then see the Frost Fighter website for replacement defroster tabs.

### Time to bond

Once the damaged area is clean and masked off and the tab is prepared it is time to bond. Follow the illustrated instruction on the tab kit for mixing the Frost Fighter Tab Bonding adhesive. Apply some of the silver adhesive in the masking area and, using a smooth edge of the mixing pad, "squeegee" the adhesive into the masked off area using the masking tape as a guide to set the depth of the silver adhesive.

Immediately remove the making tape while wet. The adhesive starts to cure quickly in 5-8 minutes so time is important here.

## Bulletin 116



Badly damaged defroster occurred when the tab pulled some of the defroster material away from the glass.



Damaged defroster pad



Mask off damaged area



**Planned Products LLC**  
4699 Nautilus Court S.  
Suite 201  
Boulder, CO 80301-5307  
303.682.0274 Tel  
info1@frostfighter.com

### Time to bond, Continued

Make sure the bonding pad is smooth and even and then dip the tab base in the adhesive and position it on top of the bonding area while wet. Be sure to check the orientation of the tab so it can be re-reconnected to the connector when the time comes.

### Cure and done!

Next, hold the connector in place (light pressure with screw driver or pliers) and using a hair dryer, heat lamp or other heater warm up the bond site for several minutes until the adhesive starts to lock down. Then keep the area warm (100-130 F) for at least 30 minutes and your back on the road with a working defroster.

### What if the defroster tab is bent or broken?

If the tab is damaged beyond repair the first step is to get a new tab. See the Frost Fighter website for Uni-Clip tabs and Uni-Con Connectors as factory replacements which work with all vehicle defrosters and connectors including Ford, Honda, Toyota, Nissan, Subaru, GM, Chrysler and almost any other make, model or manufacturer.



*Damage repaired*



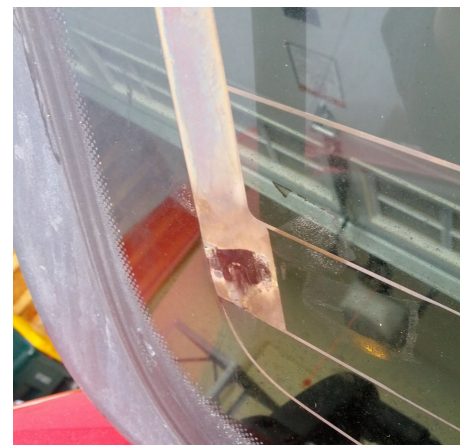
If the tab base is still on the defroster there are two options. If there is enough defroster material around the tab it is appropriate to bond the new tab to the defroster close by the broken tab base.

The other option is to remove the tab base and bond the replacement tab in its place.

There are several techniques for removing the tab base. Since most tabs are soldered in place it is relatively easy to re-flow the solder and remove the tab using a soldering iron. Be careful not to break the glass when soldering or applying spot heat to rear windows. A wet towel on the outside of the window can help reduce over heating.

### Removing the tab base

A screw driver blade, pliers or a dremel tool can be used to remove the tab base. Do not worry about causing additional damage to the defroster as it can be repaired using the technique shown above.



*More defroster damage*

### Silver makes the difference bonding rear window defroster tabs

The 2000 Tab Bonding kit is a highly conductive two part silver adhesive that cures quickly, bonds aggressively and forms the electrical and structural connection to the defroster in one simple operation.

The adhesive's high silver loading provides maximum electrical conductivity ideal for the high amperage bonds needed in defroster tab repair.



*2000 Tab Bonding Kit*



**Planned Products LLC**  
4699 Nautilus Court S.  
Suite 201  
Boulder, CO 80301-5307  
303.682.0274 Tel  
info1@frostfighter.com