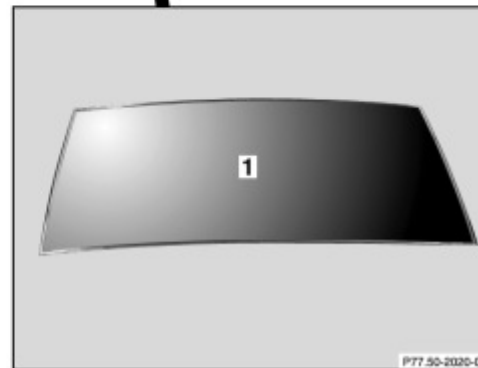
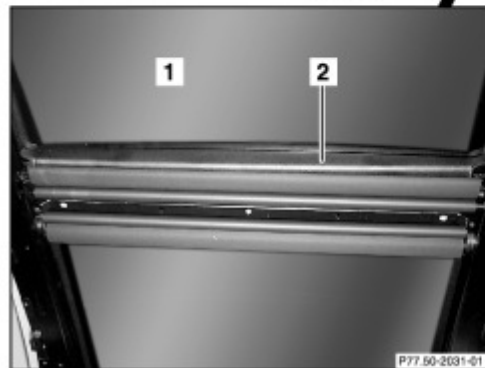
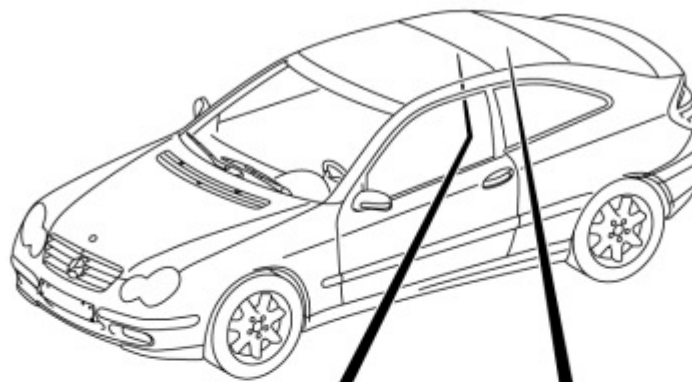


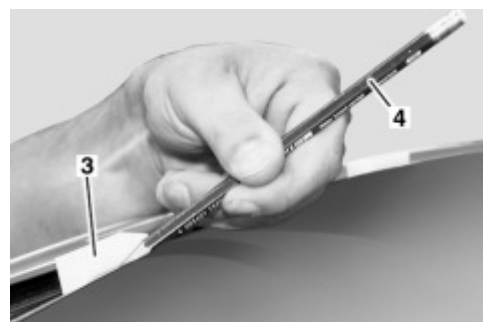
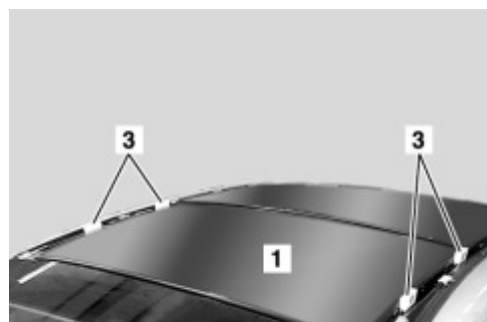
AR77.50-P-1001PB	Remove/install rear glass roof	20.12.05
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MODEL 203.7 with CODE (413) Panoramic sliding roof

- 1 Rear glass roof
- 2 Cover



P77.50-2030-06



P77.50-2033-01

P77.50-2032-01

P77.50-2034-01








1 Glass roof  
3 Spacers











4 Pencil  
5 Adhesive tape











6 Rear window

**Modification notes**

13.12.05	Repair products modified	Work step 1	AR77.21-P-0010-01T
	Repair products modified	Work step 15	AR67.10-P-1501-01PC
	Repair products modified	Work step 17	AR77.21-P-0600-02PB
	Repair products modified	Work step 18	AR77.21-P-0600-03T

	<b>Remove</b>		
1	Prepare adhesive cartridge	 Heat-up time at least 60 minutes at 60 °C.	<a href="#">AR77.21-P-0010-01T</a>
		 Cartridge heater	<a href="#">WH58.30-Z-1005-20A</a>
		1K repair kit for glazing without booster	<a href="#">BR00.45-Z-1003-02B</a>
2	Open side window in driver door.		
3	Remove headliner		<a href="#">AR68.30-P-4300PB</a>
4	Unclip cover (2)	 Mounting wedge	<a href="#">110 589 03 59 00</a>
5	Remove rear glass roof seal	 Left and right side	<a href="#">AR77.20-P-1370PB</a>
6	Insert spacers (3) into side retaining rails.	 Spacer	<a href="#">203 589 11 23 00</a>
7	Mark height of glass roof (1) with pencil (4) on spacers (3).		
8	Remove spacers (3)	 Note position of spacers (3) using corresponding number.	
9	Move tilting/sliding roof to tilt position		

10	Unscrew telephone antenna		
11	Install adhesive tape (5) between rear window (6) and glass roof (1)	 Otherwise seal on rear window (6) can be damaged.	
 <b>Danger!</b>	<b>Risk of injury</b> caused by slipping when clamping blade in the multicutter and by glass splinters when cutting out bonded windows	Always interrupt air supply when inserting or removing blade. Wear protective gloves and safety glasses.	<a href="#">AS67.00-Z-0001-01A</a>
12	Cut out rear glass roof (1) with cutting blade.	 This will destroy the rear glass roof (1) which must be replaced.	<a href="#">AR67.20-P-3550-01PB</a>
		 Multicutter	<a href="#">WH58.30-Z-1007-20A</a>
		 Cutting blade	<a href="#">124 589 21 63 00</a>
		 Cutting blade, straight, 35 mm blade length	<a href="#">202 589 17 63 00</a>
13	Remove rear glass roof (1) from body with cup suction tool.	 Cup suction tool	<a href="#">WH58.30-Z-1010-02A</a>
	<b>Install</b>		
14	Remove adhesive tape (5) between rear window (6) and rear glass roof (1)		
15	Prepare body flange for glazing		<a href="#">AR67.10-P-1501-01PC</a>
		 Multicutter	<a href="#">WH58.30-Z-1007-20A</a>
		 Cutting blade	<a href="#">124 589 21 63 00</a>
		1K repair kit for glazing without booster	<a href="#">BR00.45-Z-1003-02B</a>
16	Align rear glass roof (1) in body opening.		<a href="#">AR67.20-P-3550-04PB</a>
		Height adjustment, rear glass roof to rear-end door window	<a href="#">BE77.20-P-1006-01A</a>
		Gap dimensions	<a href="#">BE77.20-P-1007-01A</a>
			<a href="#">203 589 11 23 00</a>

		 Spacer	
		 Feeler gauge	<a href="#">129 589 03 21 00</a>
17	Prepare rear glass roof (1) for glazing		<a href="#">AR77.21-P-0600-02PB</a>
		 Cup suction tool	<a href="#">WH58.30-Z-1010-02A</a>
		1K repair kit for glazing without booster	<a href="#">BR00.45-Z-1003-02B</a>
18	Apply adhesive material for rear glass roof	 Install window within five minutes before adhesive force of glue starts to decrease.	<a href="#">AR77.21-P-0600-03T</a>
		 Height of glue bead approx. 14 mm.	
		 Electric cartridge gun Pressofix 108 Elektronik	<a href="#">WH58.30-Z-1006-20A</a>
		1K repair kit for glazing without booster	<a href="#">BR00.45-Z-1003-02B</a>
19	Remove protective foil from rubber spacers.		
20	Install rear glass roof (1).	 Curing time is approx. two hours from the time rear glass roof (1) is installed.	<a href="#">AR67.20-P-3550-05PB</a>
		Height adjustment, rear glass roof to rear-end door window	<a href="#">BE77.20-P-1006-01A</a>
		 Cup suction tool	<a href="#">WH58.30-Z-1010-02A</a>
21	Screw in telephone antenna		
22	Install rear glass roof seal	 Left and right side	<a href="#">AR77.20-P-1370PB</a>
23	Install cover (2) on rear roller sun blind.		
24	Install headliner		<a href="#">AR68.30-P-4300PB</a>
	<b>Check</b>		
25	Check height adjustment of		

	tilting/sliding roof cover, adjust if necessary. See ↓		
	Adjust tilting/sliding roof cover		<a href="#">AR77.20-P-1100PB</a>

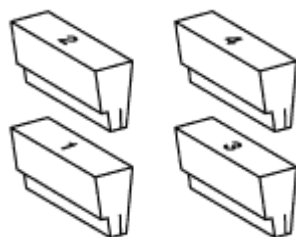
### Test and adjustment values for tilting/sliding roof

Number	Designation	Model 203.7		
BE77.20-P-1006-01A	Height adjustment glass roof, rear to rear-end door window	Rear glass roof higher than rear-end door window	mm	0 (+2)
BE77.20-P-1007-01A	Gap dimensions	Wind deflector to tilting/sliding roof	mm	2 (±1)
		Tilting/sliding roof to rear glass roof	mm	2 (±1)
		Rear glass roof to rear-end door window	mm	9 (±1)
		Windshield to outer mounting clamp of trim strip	mm	7 (±1)



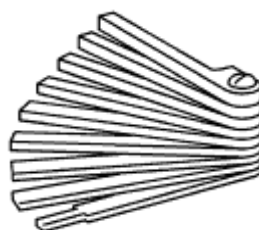
110 589 03 59 00

Mounting wedge



203 589 11 23 00

Spacer



129 589 03 21 00

Feeler gauge



124 589 21 63 00

Cutting blade



202 589 17 63 00

Cutting blade, straight, blade  
length 35 mm

**Commercially available tools** (see Workshop Equipment Manual)

<b>Number</b>	<b>Designation</b>	<b>Make (e.g.)</b>	<b>Order number</b>
WH58.30-Z-1005-20A	Cartridge heater	Beyer & Otto D-63798 Kleinostheim	KVG-2/220
WH58.30-Z-1007-20A	Multicutter	Chicago Pneumatic Hagenauerstr. 57 D-65203 Wiesbaden	CP 838-12
WH58.30-Z-1010-02A	Cup suction tool	Karl Assfalg KG Buchstr. 149 D-73525 Schwäbisch- Gmünd	602-2
WH58.30-Z-1006-20A	Pressofix 208 E electric cartridge gun	Weiler GmbH Druckluft-Technik Postfach 1269 D-76277 Rheinstetten  Tel.:0721 / 95178-0	WSDF-208E

**Auxiliary repair materials**

<b>Number</b>	<b>Designation</b>	<b>Order number</b>
BR00.45-Z-1003-02B	1K repair kit for glazing without booster	A 221 670 21 01