

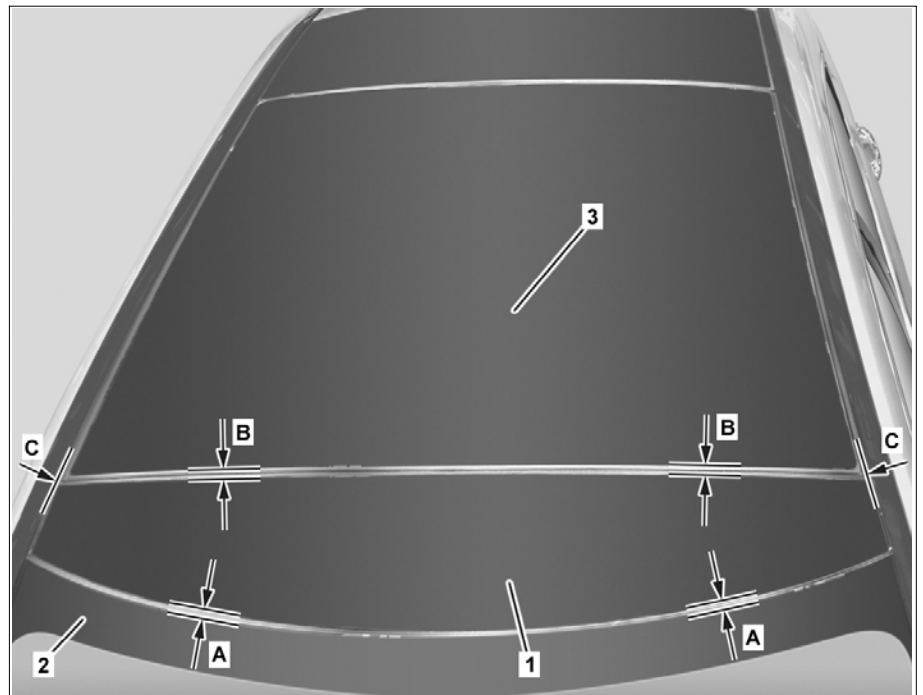
- Model 205.0/1/2/3**
with code 413 (Automatic panoramic sliding sunroof)
- Model 222**
with code 398 (Panoramic roof with MAGIC SKY CONTROL)
- Model 222**
with code 413 (Automatic panoramic sliding sunroof)
- Model 253**
with code 413 (Automatic panoramic sliding sunroof)

Modification notes

19.04.2018	Warning notice and notes on removal/installation of bonded elements of panoramic roof added.		
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












Shown on MODEL 222 with CODE 413 (Panoramic sliding roof)






- 1 Front glass cover
2 Windshield
3 Panoramic sliding sunroof
A Gap dimension
B Gap dimension
C Transition

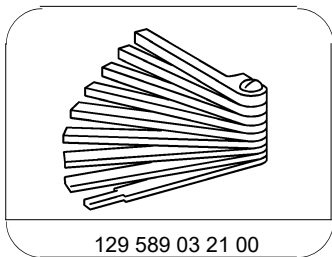


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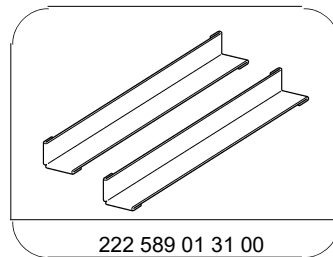
Caution	Risk of injury caused by scraping or cutting body parts on sharp vehicle parts	Always wear protective gloves when working on or near sharp and non-deburred vehicle parts. Deburr repair panels.	AS00.00-Z-0017-01A
Warning	Risk of injury caused by fingers being jammed or pinched when removing, installing or aligning hoods, doors, trunk lid/rear-end door or sliding roof.	No parts of the body or limbs should be within the operating area when the components are moving.	AS00.00-Z-0011-01A
	Notes on removal/installation of bonded elements of panoramic roof		AH77.21-P-0001-01A
	Preparation		
1	Prepare adhesive cartridge.	Adapter	AR77.21-P-1000-01A *000589866300
	Remove		
Warning	Risk of injury caused by slipping when clamping blade in the multicutter and by splinters when cutting out bonded components	Wear cut-proof gloves and safety glasses. Always interrupt air or current supply when changing the cutting blade.	AS58.00-Z-0001-01A
2	Remove left and right drip rail.	Model 205.0/1/3 with code 413 (Automatic panoramic sliding sunroof) Model 222 with code 398 (Panoramic roof with MAGIC SKY CONTROL) Model 222 with code 413 (Automatic panoramic sliding sunroof)	

		Model 222 with code 398 (Panoramic roof with MAGIC SKY CONTROL) Model 222 with code 413 (Automatic panoramic sliding sunroof)	AR88.80-P-4000LF
3	Determine gap dimension (A) between front glass cover (1) and windshield (2) and note.	 Feeler gauge	*129589032100
4	Determine gap dimension (B) between front glass cover (1) and panoramic sliding sunroof (3) and note.	 Feeler gauge	*129589032100
5.1	Cover paint surfaces on left and right in area of front glass cover (1) with shields.	Model 205.0/1/3 with code 413 (Automatic panoramic sliding sunroof) Model 222 with code 413 (Automatic panoramic sliding sunroof)  Set of shields	*222589013100
5.2	Mask off left and right roof railing in area next to front glass cover (1) with suitable fabric tape.	Model 205.2 with code 413 (Automatic panoramic sliding sunroof) Model 253 with code 413 (Automatic panoramic sliding sunroof)	
6	Saw off an approx. 5 mm to 10 mm wide strip from front edge of front glass cover (1).	 Saw carefully. Otherwise the seal on the windshield (2) can be damaged.  Observe cutting depth when sawing. Otherwise, front panoramic sliding sunroof frame can be damaged.  Use oscillating saw with round sawing blade.	
7	Saw off an approx. 5 mm to 10 mm wide strip from left and right edge of front glass cover (1).	Model 205.2 with code 413 (Automatic panoramic sliding sunroof)  Saw carefully. Otherwise, left or right roof railing can be damaged.  Observe cutting depth when sawing. Otherwise, front panoramic sliding sunroof frame can be damaged.  Use oscillating saw with round sawing blade.	
8	Completely open panoramic sliding sunroof (3).		
 Warning	Risk of injury due to snapping or warming up of cutting wire and due to splinters when cutting out glued panoramic roofs Cut out front glass cover (1) with cutting wire and remove from panoramic sliding sunroof frame.	Wear cut-proof gloves and safety glasses.  Model 205.2 with code 413 (Automatic panoramic sliding sunroof) Model 253 with code 413 (Automatic panoramic sliding sunroof) Carefully insert cutting wire in area of left and right roof railing. Otherwise, left or right roof railing can be damaged.  Helper required.	AS77.21-Z-0002-01A
	Install		
10	Prepare front glass cover (1) for installing glass.		AR77.21-P-7010-03NKA
11	Prepare panoramic sliding sunroof frame for installing glass of front glass cover (1).		AR77.21-P-7010-02NKA
12	Apply adhesive material for front glass cover (1).		AR77.21-P-7010-04NKA
13	Close panoramic sliding sunroof (3).		
14	Install glass in front glass cover (1) with a helper.		AR77.21-P-7010-05CW

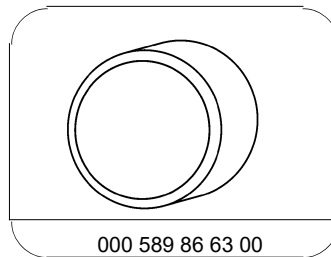
		 <p>Use weights with large surfaces such as sandbags to put load on front glass cover (1). Otherwise the front glass cover (1) can be damaged.</p>  Observe dimensions noted when aligning.  Feeler gauge	*129589032100
15	Install left and right drip rail.	Model 205.0/1/3 with code 413 (Automatic panoramic sliding sunroof) Model 222 with code 398 (Panoramic roof with MAGIC SKY CONTROL) Model 222 with code 413 (Automatic panoramic sliding sunroof) Model 222 with code 413 (Automatic panoramic sliding sunroof)	AR88.80-P-4000LF
16.1	Remove shields.	Model 205.0/1/3 with code 413 (Automatic panoramic sliding sunroof) Model 222 with code 398 (Panoramic roof with MAGIC SKY CONTROL) Model 222 with code 413 (Automatic panoramic sliding sunroof)	
16.2	Remove tape strips from left and right roof railing.	Model 205.0/2 with code 413 (Automatic panoramic sliding sunroof) Model 253 with code 413 (Automatic panoramic sliding sunroof)	
17	Remove tape strips and weights for weighing down front glass cover (1).	 <p>Only remove tape strips and weights once adhesive material has cured. Otherwise the position of the front glass cover (1) can change.</p>	
	Clean		
18	Clean working area.		



Feeler gauge



Set of shields



Adapter