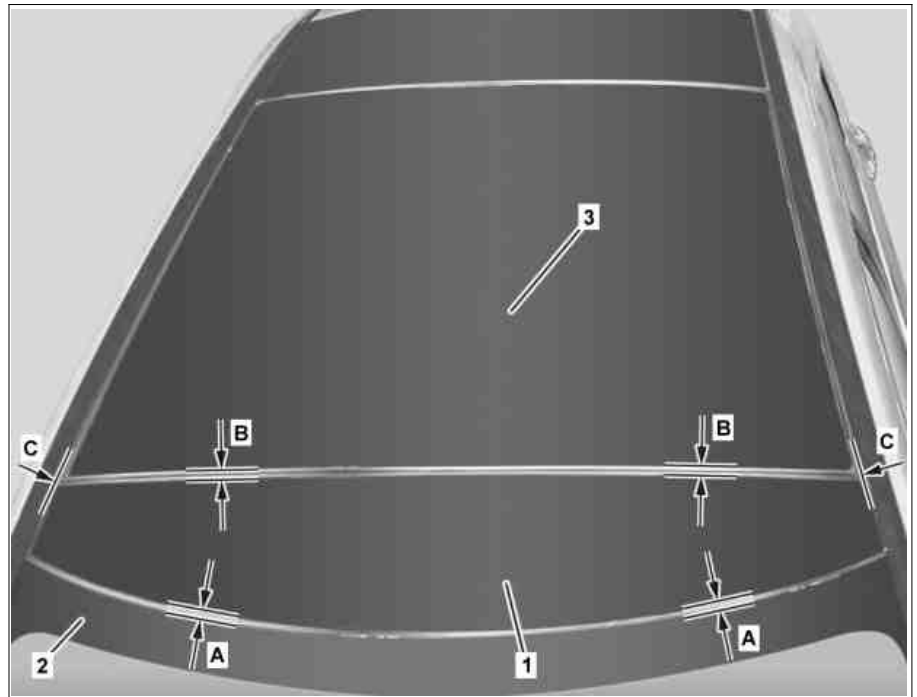


MODEL 205.0
with CODE 413 (Panoramic glass roof with top sliding roof)

MODEL 222
with CODE 413 (Panoramic glass roof with top sliding roof)

Shown on MODEL 222

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

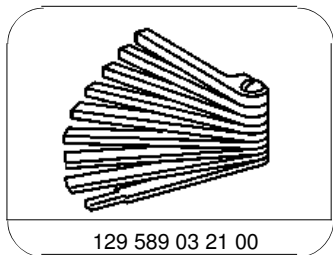


P77.21-2377-06

1	Preparation Prepare adhesive cartridge	TS adhesive (with heptane cleaner) Cartridge gun, electric, and preheater gotis://K_67.0_02.0 Adapter	AR67.10-P-1000-12SX *BR00.45-Z-1142-02A *000589866300
	Remove		
2	Remove left and right drip rail	MODEL 205.0 with CODE 413 (Panoramic glass roof with top sliding roof) MODEL 222 with CODE 413 (Panoramic glass roof with top sliding roof) MODEL 222 with CODE 413 (Panoramic glass roof with top sliding roof)	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 (A) between front glass cover (1) and panoramic sliding roof (3) and note	Feeler gauge	*129589032100
	Danger ! 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
	Danger ! Risk of injury caused by slipping when inserting blade in the multicutter and by glass splinters when cutting out bonded windows Saw an approx. 5 to 10 mm wide strip off of the front edge of the front glass cover (1)	Always interrupt air supply or power supply before inserting or removing blade. Wear protective gloves and safety glasses Saw carefully. Otherwise the upper seal on the windshield (2) can be damaged and the windshield (2) must be replaced. Observe cutting depth when sawing. Otherwise the paneling on the front roof frame can be damaged. Use oscillating saw with round sawing blade.	AS67.00-Z-0001-01A
5			

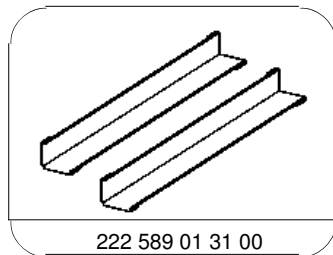
		Glass removal gotis://K_67.0_01.0	
6	Completely open panorama sliding roof (3)		
7	Mask paint surfaces on left and right next to front glass cover (1) with shields	<p>i To protect paint surfaces when cutting out front glass cover (1).</p> <p>S Set of shields</p>	*222589013100
⚠ Danger !	Risk of injury from cutting wire tearing or becoming hot and from splinters of glass when cutting out bonded windows	Wear protective gloves and safety glasses.	AS67.00-Z-0004-01A
8	Cut out front glass cover (1) with cutting wire and remove from panoramic sliding roof frame	Glass removal gotis://K_67.0_01.0	
✖	Install		
9	Prepare front glass cover (1) for glazing	<p>ⓘ Do not touch bonding surfaces on inside of front glass cover (1) with bare fingers. They must be free of dust, oil, wax, dirt residues and other adhesive components. Otherwise the strength of the adhesive connection can be impaired and proper adhesion of the adhesive material is not ensured.</p> <p>ⓘ Observe processing notes for primer. Flash-off time min. 10 minutes. Otherwise the strength of the adhesive connection can be impaired and proper adhesion of the adhesive material is not ensured.</p> <p>TS adhesive (with heptane cleaner) Cup suction tool/suspension equipment (for window removal/installation) gotis://K_67.0_03.0</p>	AR77.21-P-7010-03NKA *BR00.45-Z-1142-02A
10	Prepare panoramic sliding roof frame for installing front glass cover (1)	<p>ⓘ Do not touch present adhesive beads and bonding surfaces on panoramic sliding roof frame with bare fingers and they should be free of dust, oil, grease, wax and other adhesive components or dirt residues. Otherwise the strength of the adhesive connection can be impaired and proper adhesion of the adhesive material is not ensured.</p> <p>ⓘ Observe processing notes for primer. Flash-off time min. 10 minutes. Otherwise the strength of the adhesive connection can be impaired and proper adhesion of the adhesive material is not ensured.</p> <p>TS adhesive (with heptane cleaner) Wet and dry vacuum cleaner gotis://P_00.12_06.0</p>	AR77.21-P-7010-02NKA *BR00.45-Z-1142-02A
11	Apply adhesive material to front glass cover (1)	<p>ⓘ Do not touch bonding surfaces on inside of front glass cover (1) with bare fingers. They must be free of dust, oil, wax, dirt residues and other adhesive components. Otherwise the strength of the adhesive connection can be impaired and proper adhesion of the adhesive material is not ensured.</p> <p>ⓘ Observe processing notes for primer. Flash-off time at least 10 minutes. Otherwise the strength of the adhesive connection can be impaired and proper adhesion of the adhesive material is not ensured.</p> <p>TS adhesive (with heptane cleaner) Cartridge gun, electric, and preheater gotis://K_67.0_02.0</p>	AR77.21-P-7010-04NKA *BR00.45-Z-1142-02A
12	Close panoramic sliding roof (3)		
13	Glaze front glass cover (1)		AR77.21-P-7010-05CW

		<p>⚠ Insert front glass cover (1) within 5 minutes after applying adhesive to body and align. Otherwise the strength of the adhesive connection can be impaired and proper adhesion of the adhesive material is not ensured.</p> <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> <p>ℹ Observe gap dimensions (A) and transitions (C) determined previously during removal. The front glass cover (1) must be flush on the left and right with the panoramic sliding roof (3).</p> <p>Cup suction tool/suspension equipment (for window removal/installation) gotis://K_67.0_03.0</p> <p>🔍 Feeler gauge</p>	*129589032100
14	Install left and right drip rail	<p>MODEL 205.0 with CODE 413 (Panoramic glass roof with top sliding roof)</p> <p>MODEL 222 with CODE 413 (Panoramic glass roof with top sliding roof)</p> <p>MODEL 222 with CODE 413 (Panoramic glass roof with top sliding roof)</p>	AR88.80-P-4000LF
15	Remove adhesive strips for fastening front glass cover (1)	<p>⚠ Remove adhesive strips only after adhesive has cured. Otherwise the gap dimensions (A, B) and transitions (C) can change.</p>	



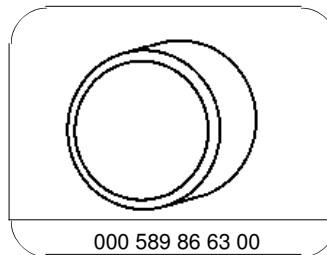
129 589 03 21 00

Feeler gauge



222 589 01 31 00

Set of shields



000 589 86 63 00

Adapter

Repair materials

Number	Designation	Order number
BR00.45-Z-1142-02A	TS adhesive (with heptane cleaner)	A 451 989 01 71