



Repair-40x01x34-02x60-1-1-1.xml



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BONDINGSUNROOFOPERATINGMECHANISMS:DESCRIPTION

1. PREPARATION AND BONDING PROCEDURE

Special notes on the preparation and bonding operation for sunroof mechanisms.

For cutting operations (see the MR for the vehicle concerned).

On sunroof mechanism	
New sunroof mechanism(Parts Department)	Procedure 1
Removed sunroof mechanism(with residual beading)	Procedure 2

2. PROCEDURE 1: ON NEW SUNROOF MECHANISM (PARTS DEPARTMENT)

Clean the bonding area carefully with heptaneVehicle: [Parts and consumables for the repair](#) (04B, Consumables - Products).

Wipe the bonding area using a lint-free clothVehicle: [Parts and consumables for the repair](#) (04B, Consumables - Products).

Place indexing guides and positioning shims onto the sunroof mechanism.

Carry out a test assembly of the sunroof mechanism on the vehicle.

Apply the primer (green and red marking) with a single, uniform stroke onto the entire bonding area.

Let it dry for a minimum of 10 minutes.

Apply the cement bead.

Bond the sunroof mechanism immediately.

3. PROCEDURE 2: ON REMOVED SUNROOF MECHANISM (WITH RESIDUAL BEADING)

Carefully clean the bonding area with heptaneVehicle: [Parts and consumables for the repair](#) (04B, Consumables - Products), avoiding the cement bead.