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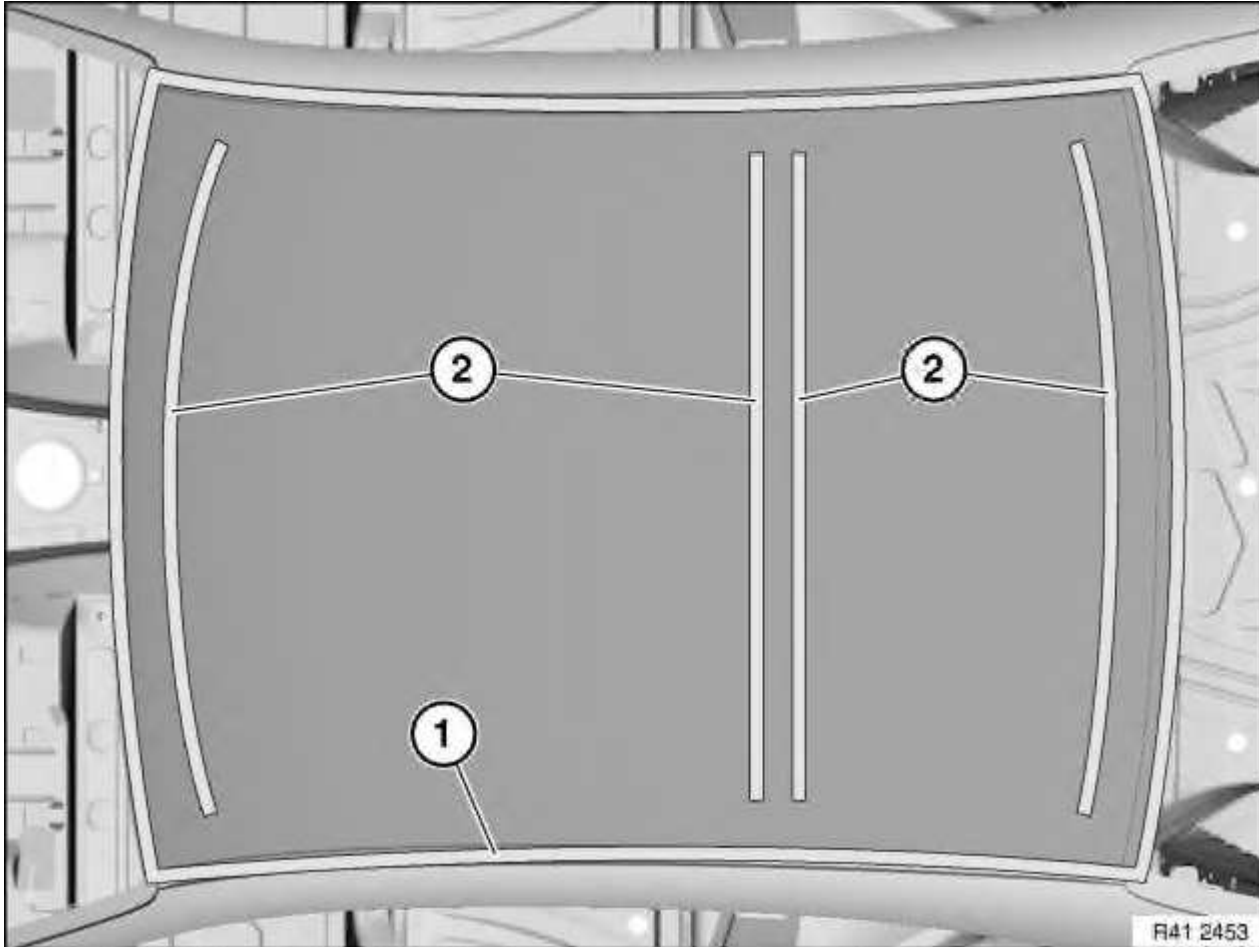
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BMW TIS - 41 31 000 Replacing roof outer skin (CFK roof version)

Read contents of Body, General .

Read and comply with General cementing instructions .

Refer to the description texts of the KSD CD (FRU [41 31 000](#) E46/M3) for details of stripping-down and rigging work.



Set hot air blower to 500° C and heat roof surface in area (1) to approx. 240° C (object temperature). The correct temperature is reached when the adhesive detaches from the paint.

Lift off roof outer skin with plastic wedge from body in area (1).

Remove all traces of adhesive residue.

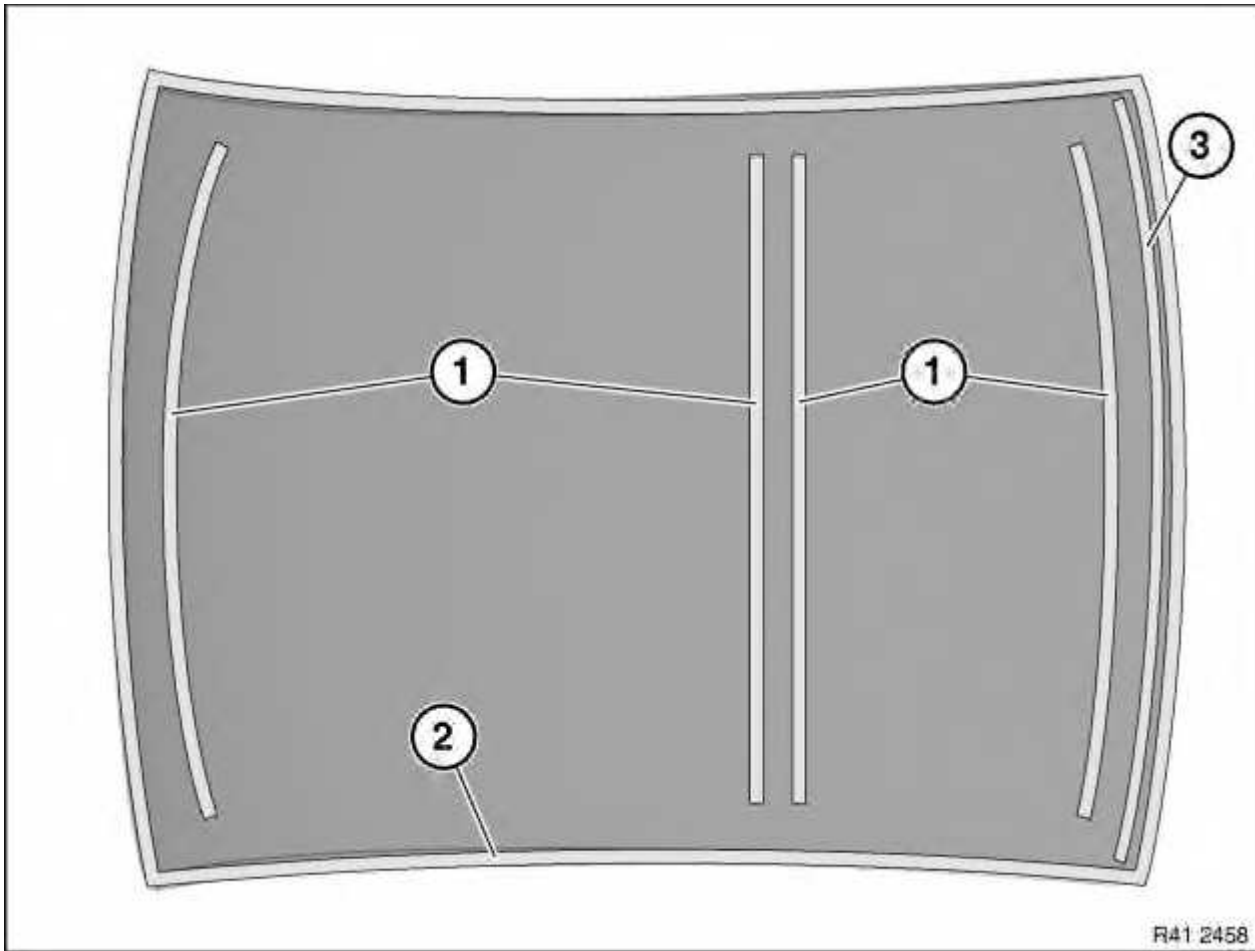
Open adhesive bonds of underlining in areas (2).

Caution!

Paintwork damage in area (1) must be ground down to the steel and then prepared up to the primer as specified in the painting manual.

Cover roof frame in area (1) with adhesive tape before painting.

Bonding may only be carried out on the primer!



Preparation of adhesive flanges on new part:

1. Roughen in areas (2 and 3) with grinding pad.
2. Clean in areas (1 and 3) with spirit.

Preparation of adhesive flanges on car:

1. Clean in areas (1 and 3) with spirit.

Important!

Read and comply with adhesive manufacturer's instructions.

It is absolutely essential to follow the correct order of adhesive application!

The following steps 1 to 3 must be completed within 15 minutes !

1. Underlining in areas (1):

The position of the underlining bead is identified by a mark on the inside of the roof.

Apply body sealing compound in a triangular shape to inside of roof (width 8 ± 2 mm, height 10 ± 2 mm)

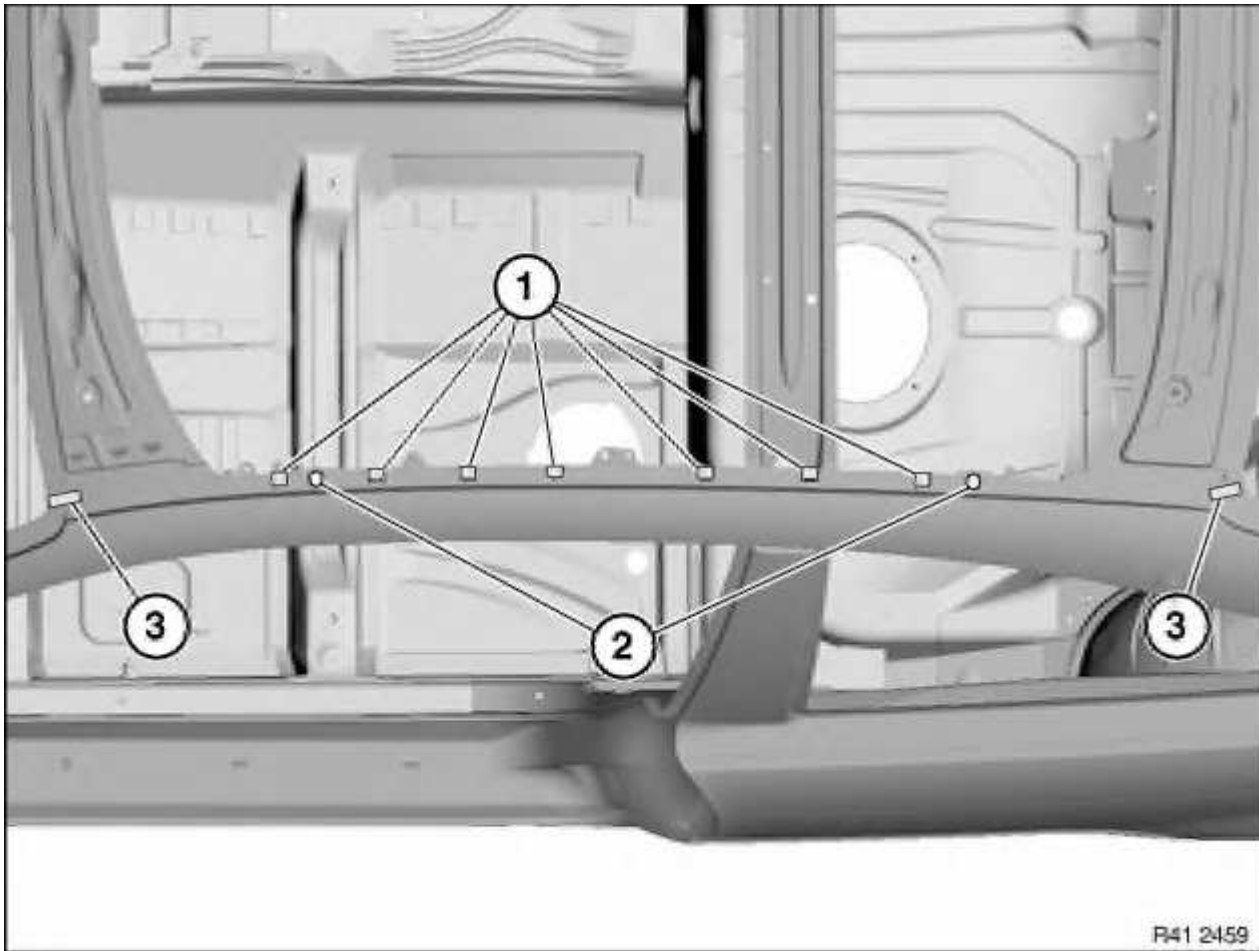
(sourcing reference via BMW Parts Service (EPC- Accessories- Dealers/Workshops- Picture Board 83-0074)).

2. Structure adhesive (contained in clamping fixture set (41 3 000)) on CFK roof in areas (2) and (3):

Apply adhesive in a bead shape along outside edge of roof (bead width 5-8 mm).

Apply a second bead parallel to the first in area (3).

Only one wide adhesive bead (dia. approx. 8 mm) is applied to the windshield adhesive flange.



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Installation:

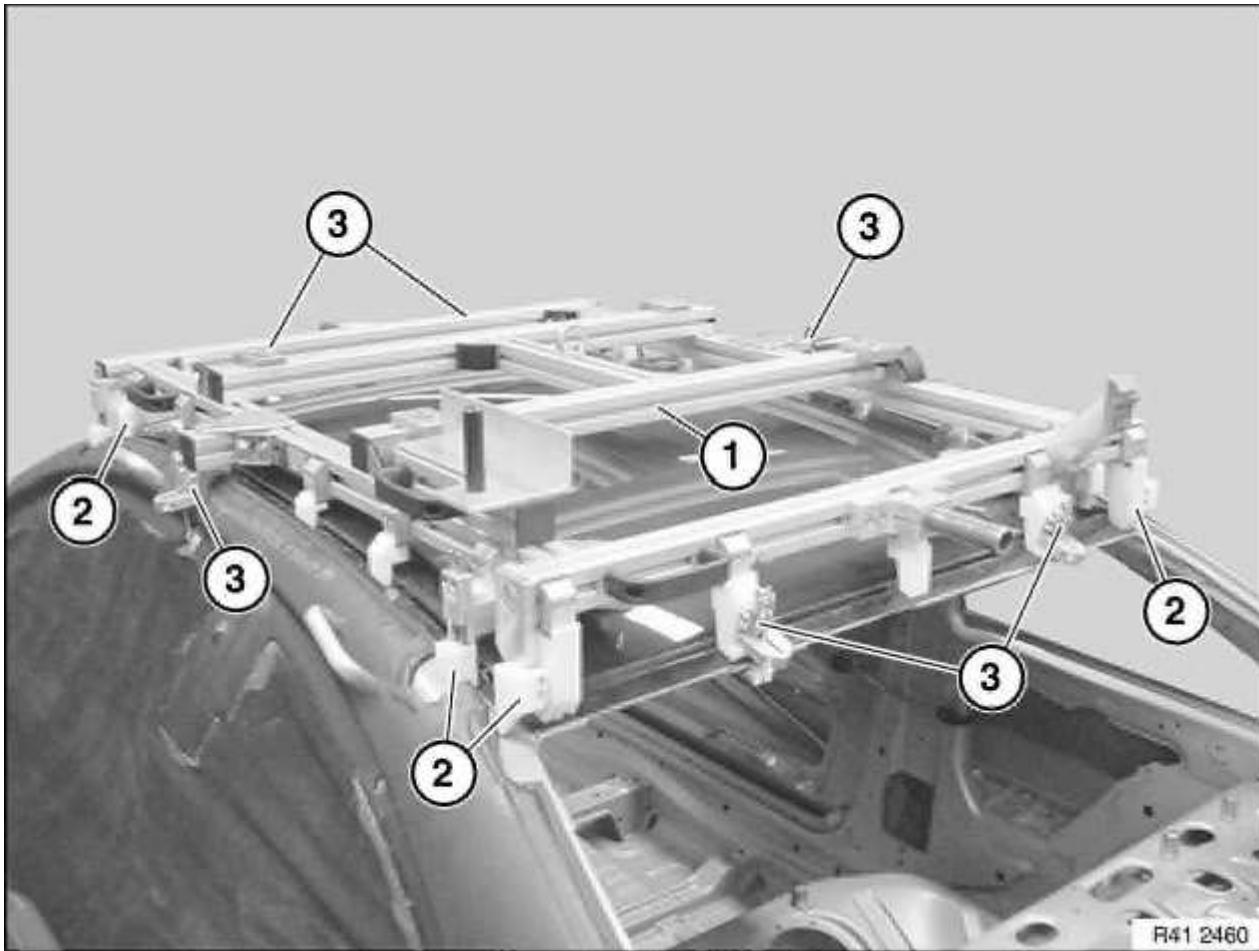
Carry over the work step shown symmetrically to the other side of the car

3. Application of structure adhesive (contained in clamping fixture set (41 3 000)) on body:

Fill flange steps with adhesive (bead width 5-8 mm) in areas (1).

Apply a thin adhesive bead (3-5 mm) in areas (2) around screw connection for roof luggage rack.

Apply a 25 mm long adhesive bead in areas (3) (step compensation).



Position clamping fixture (1) with guides (2) on roof.

Installation:

Place clamping fixture in position with either 4 persons or a crane.

Center roof.

Lock clamping elements (3) by repositioning levers.

Align step between roof and A-pillar or roof and C-pillar with emerging adhesive. Remove excess adhesive.

Important!

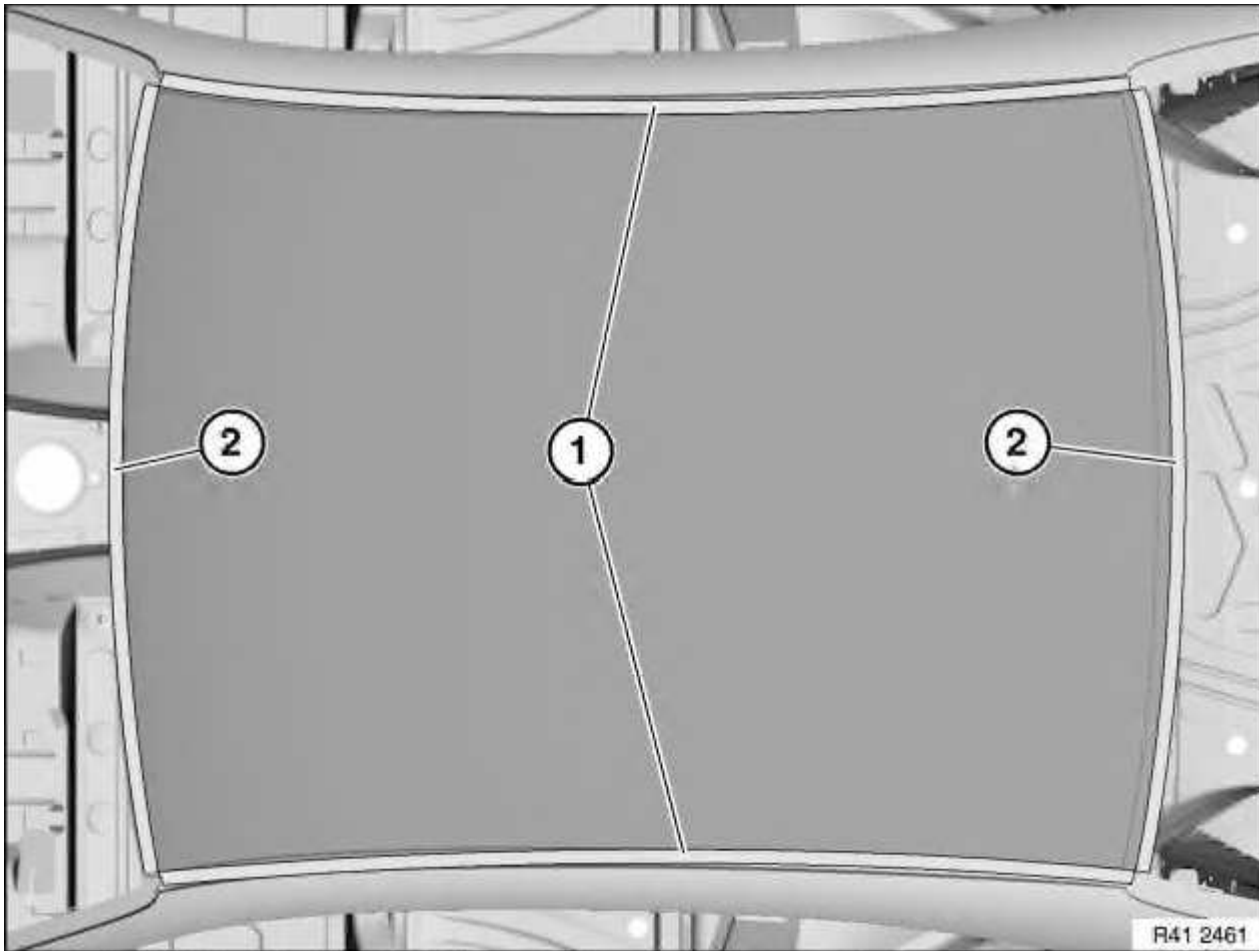
Never use cleaning agents!

Do not leave any traces of sharp edges as this could compromise the tightness of the subsequent bond.

Installation:

The clamping fixture remains on the car for 100 minutes.

Do not move the car during this period.



Remove clamping fixture after 100 minutes.

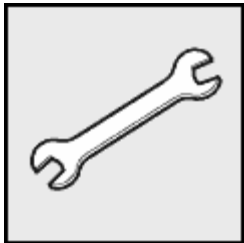
Remove vertically protruding adhesive from roof trim strip channel in areas (1).

Remove adhesive that has escaped in areas (2).

The endurance strength of the structural bond is achieved after 12 hours at 20° C.

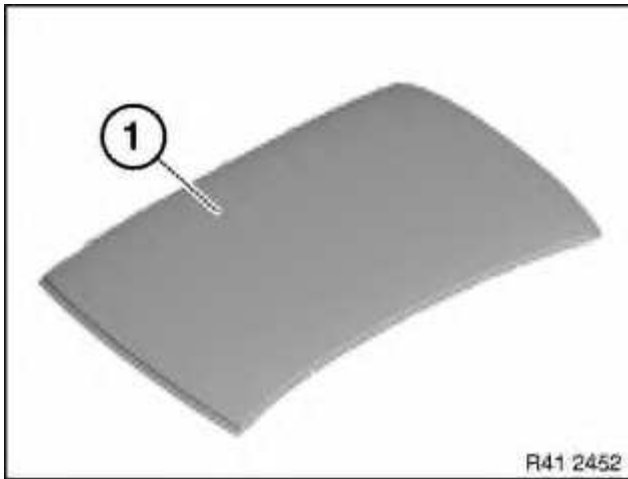
41 31 000

Replacing roof outer skin (CFK roof version)



Special tools required:

- 41 3 000



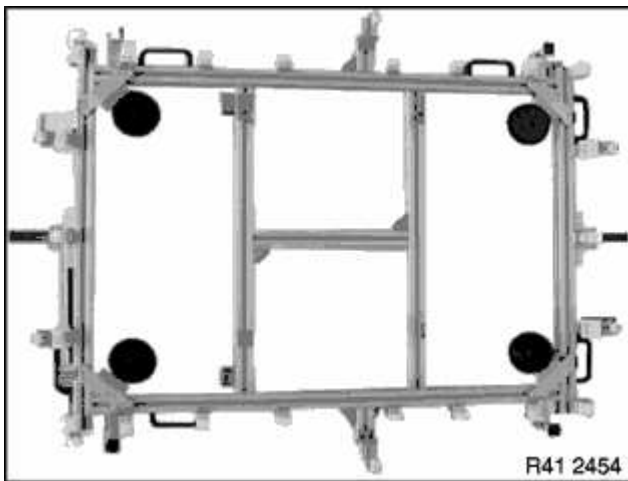
Following new body parts are required (refer to EPC):

- Roof outer skin (1)

Installation:

Prior to installation, the new component must be stored for at least 12 hours at 15° C to 25° C.

Place the car for at least 6 hours in a heated room (>15° C).



Clamping fixture (41 3 000) is a hire tool (sourcing reference: Cartool).

The set contains:

- Clamping fixture
- Adhesive gun
- Adhesive cartridges (3 x)

Preparation of new part:

Insert new part in clamping fixture. Make sure part is correctly aligned (front/rear).

Secure new part with suckers.

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