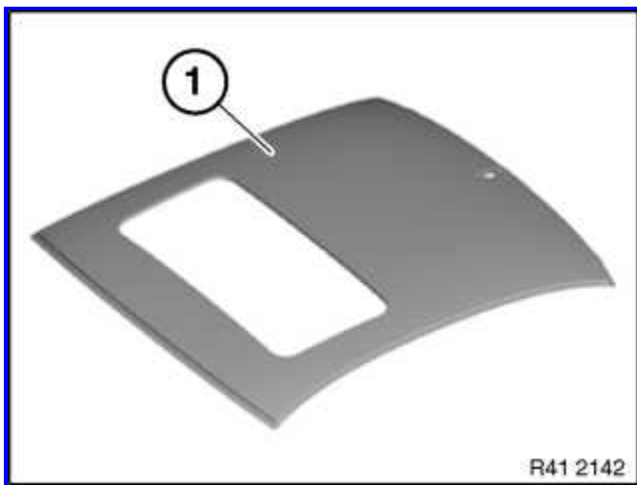


41 31 100**Replace roof outer skin with slide/tilt sunroof**

Read contents of [Body, General](#).
[Strip down vehicle](#).



Procedure [Observe](#) repair stage 2!



Following new body parts are required (refer to Electronic Parts Catalogue):

- (1) Roof outer skin, slide/tilt sunroof
- Star screws (4x, Order No. 07 14 7 153 767)

Following [consumables](#) are required:

Material	Quantity
Adhesive K5b	1
Adhesive K5a	1
Punch rivets N4	8

Punch rivets N5	12
EMC screws	2
Cleaning agent R1	1
Sealant D1	

Tools also required:

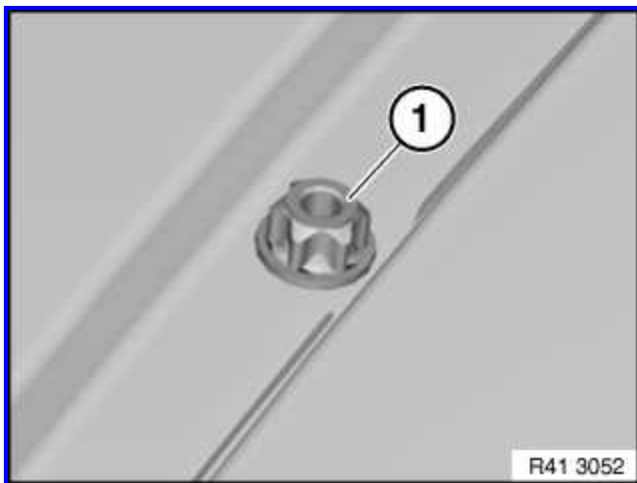
- Roof pliers set, order number: 81 43 2 158 707

Sourcing reference:

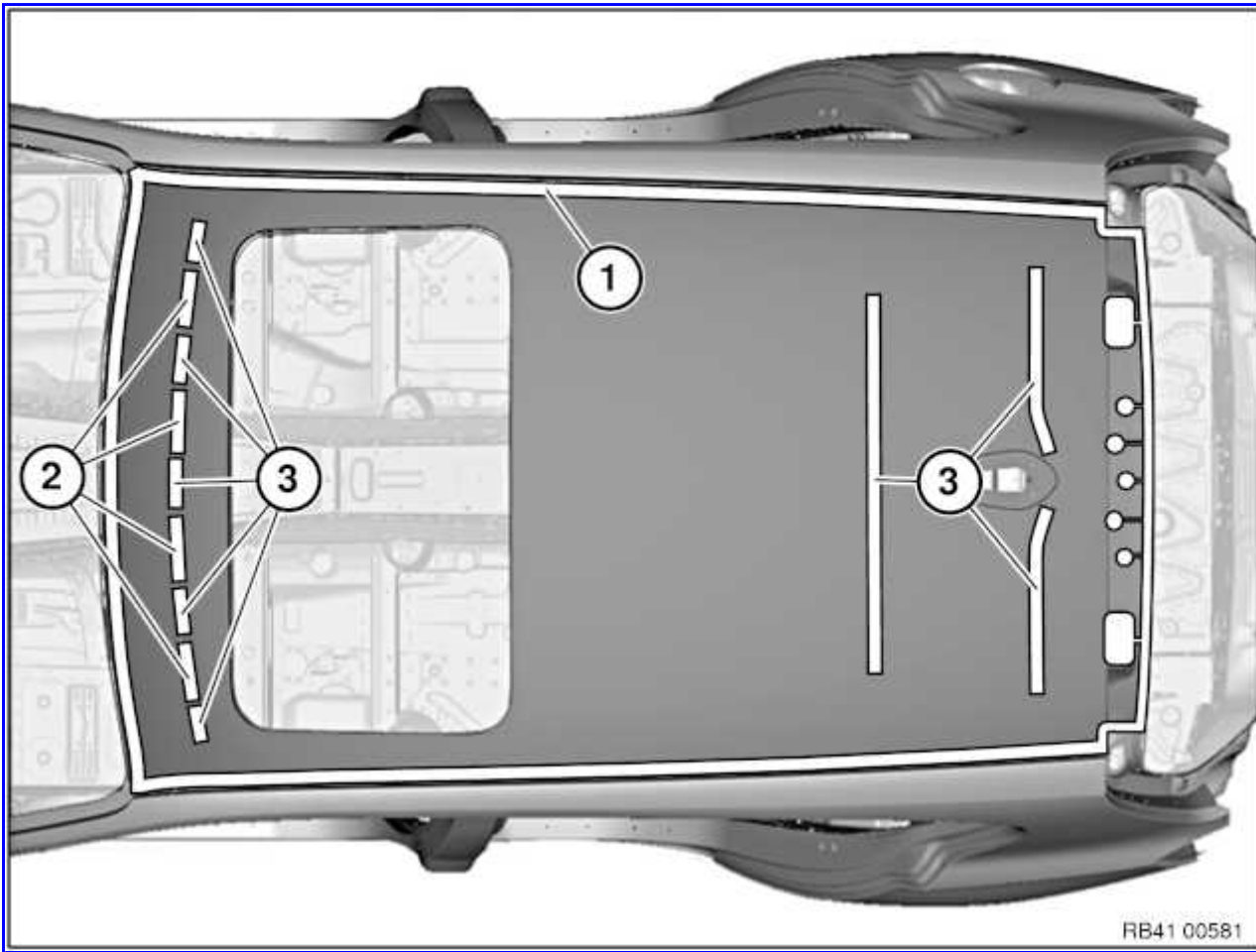
[BMW Workshop Equipment Catalogue](#)



Removal



Release 4 screws (1) in roof channel.



Open welded connections in areas (1).

[Detach](#) adhesive areas (adhesive) in area (2).

Loosen adhesive area (sealant) in area (3) and remove roof outer skin.



New part preparation

Place roof outer skin in position and fit in conjunction with roof trim strips.

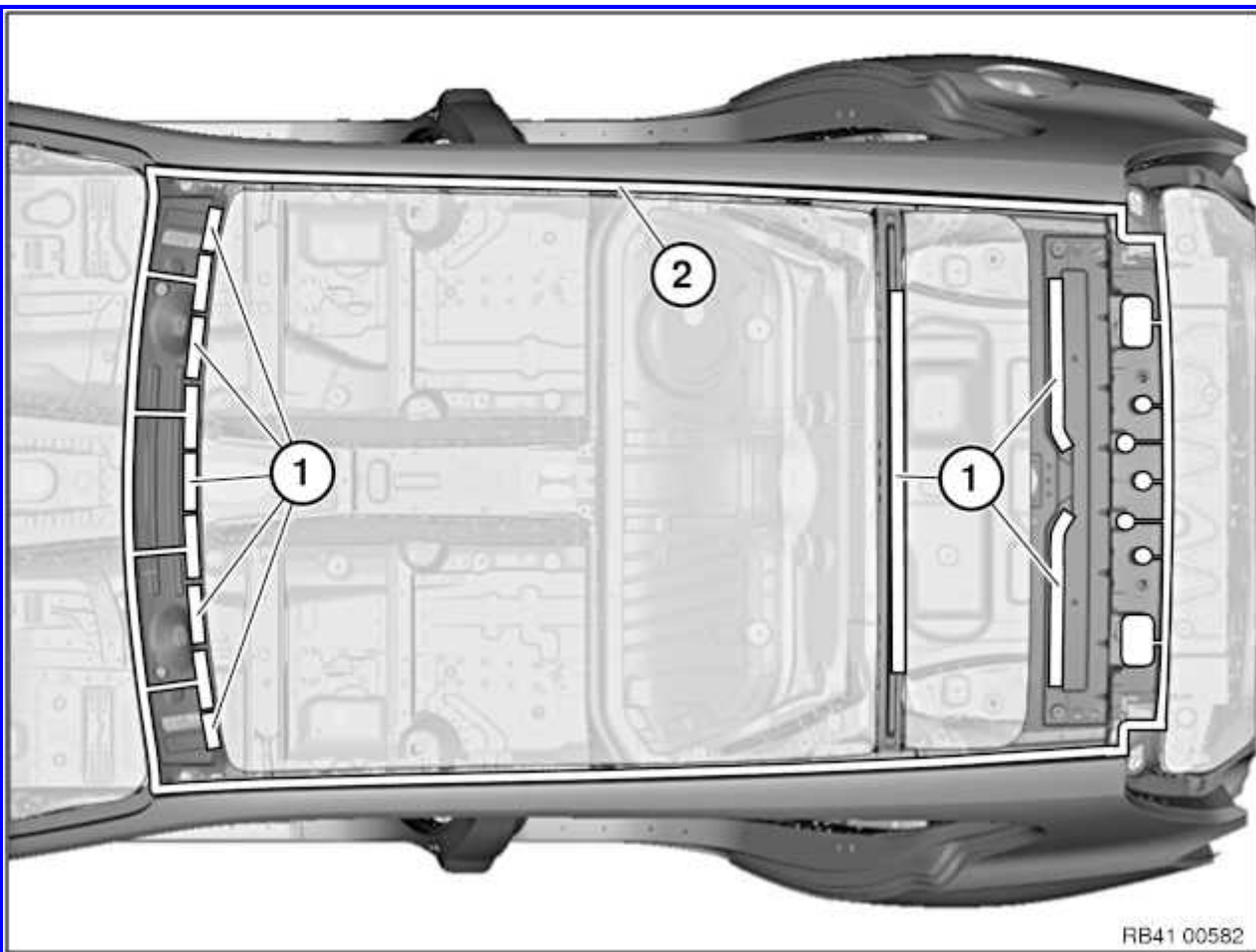
Important!

Bonding in outer skin area.

Do not grind/sand new part in area of bonding surfaces.



Installation



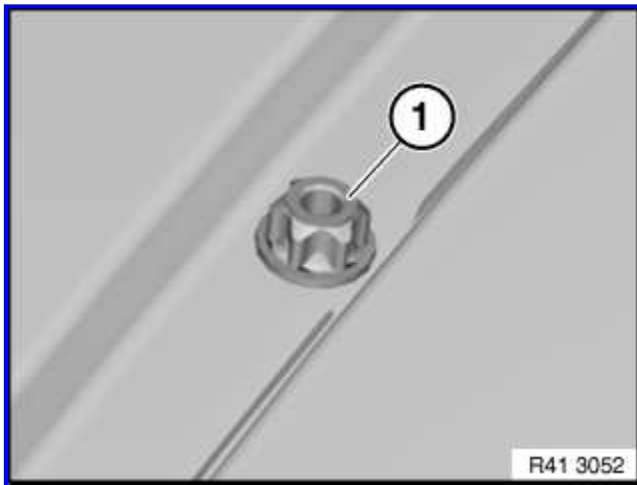
Clean all bonding surfaces on vehicle and on new part with cleaning agent R1.

Apply sealant D1 in areas (1) analogously to Series.

Apply adhesive in areas (2).

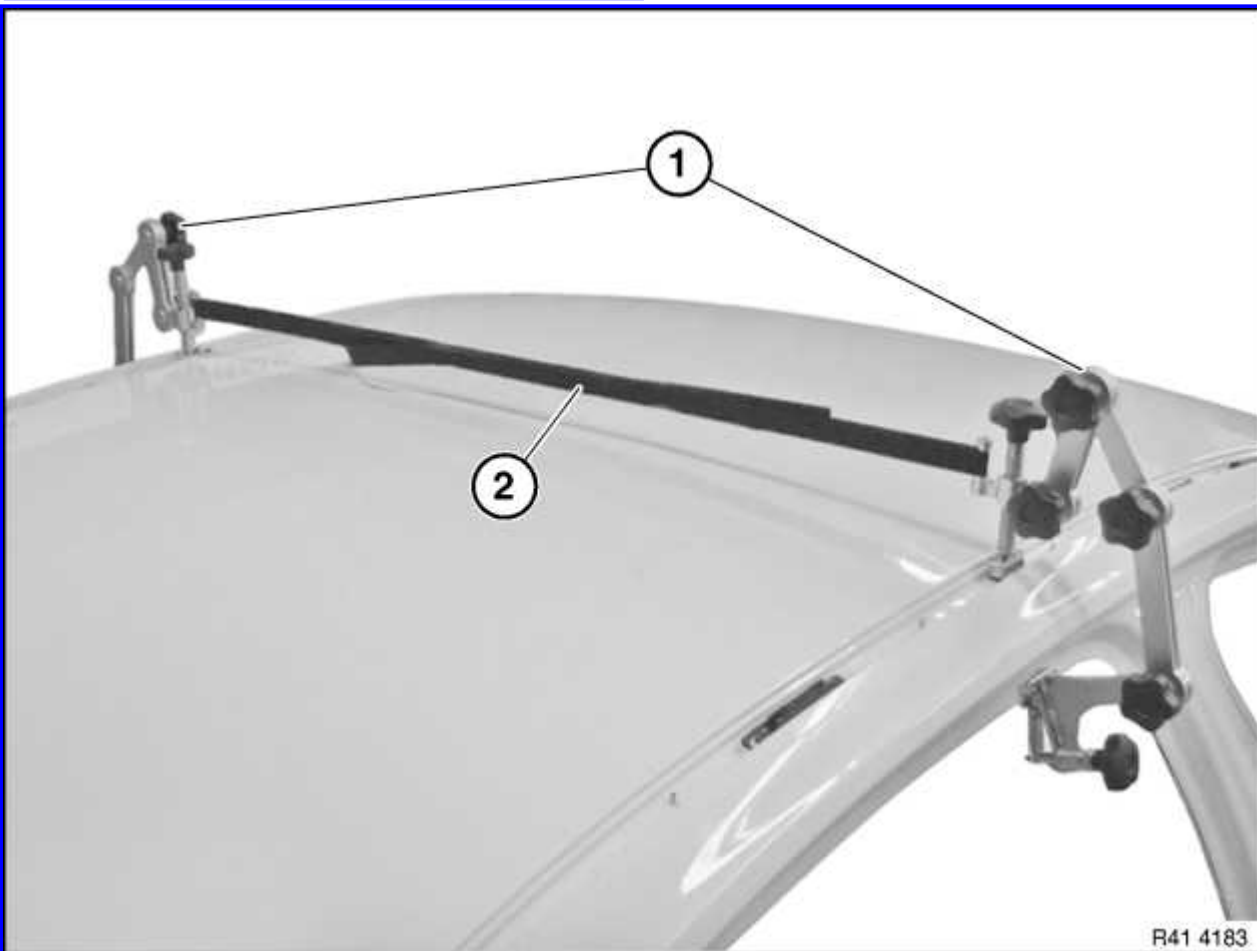
Apply a little more adhesive to nodes of A-pillar.

Note:
Excess material at the nodes is later used for spreading to side frame.



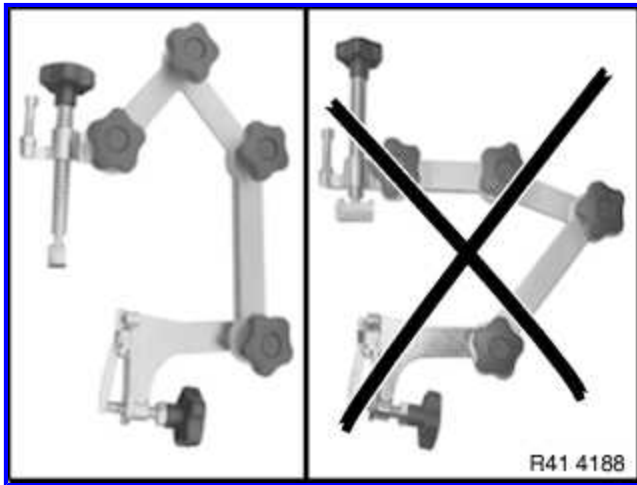
Place roof outer skin with helpers evenly and centrally on vehicle.

Insert 4 star screws (1) hand-tight.

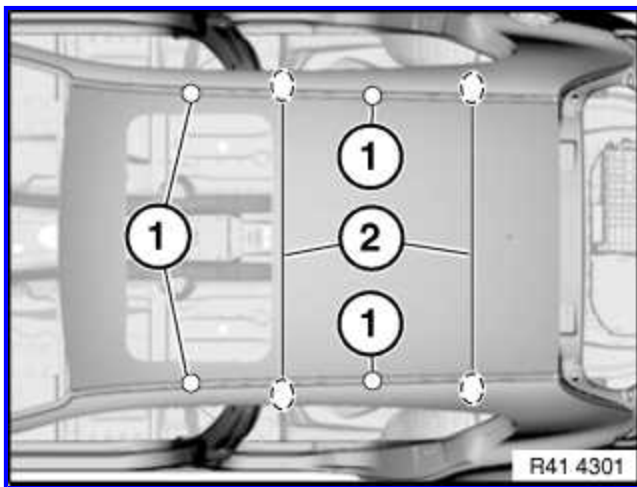


Mount roof pliers (1) and secure with tensioning strap (2).

Note:

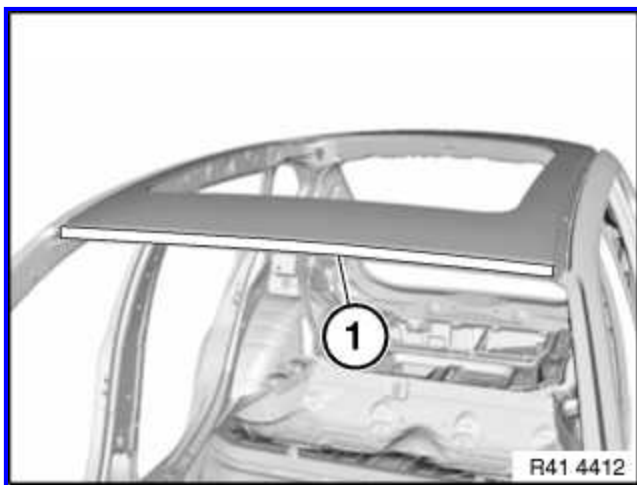


To generate an optimum contact pressure, mount roof pliers according to the graphics as left.

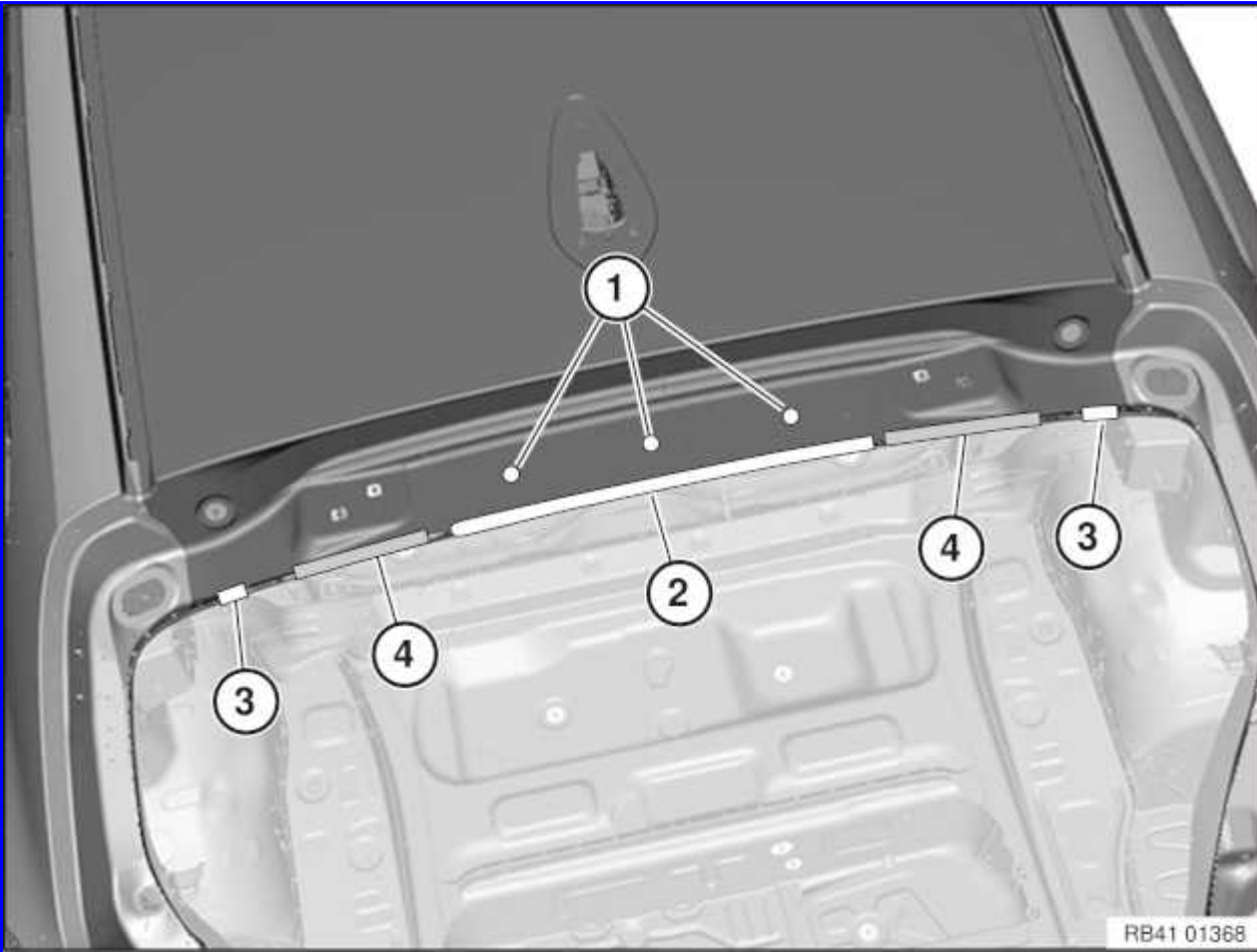


Secure roof outer skin at 2 areas with roof pliers and tensioning straps (2).

(1) Star screws



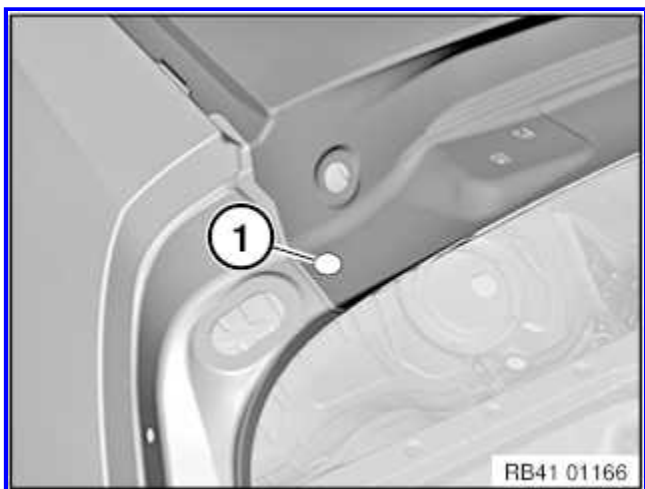
In area (1) rivet roof outer skin with 8 N5 punch rivets.



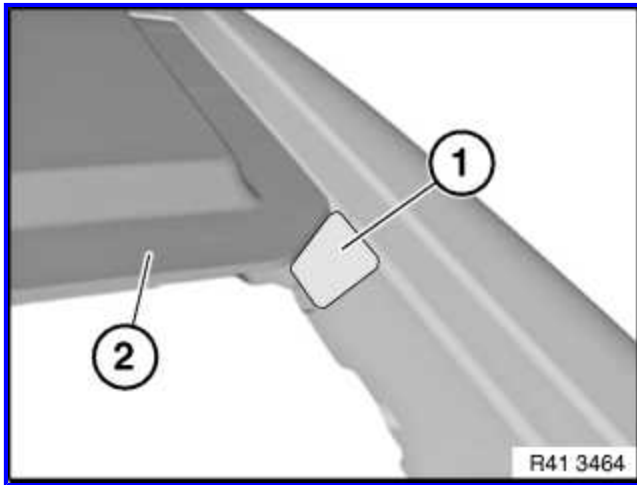
In areas (1) to (3) rivet roof outer skin with punch **N4** rivets.

In each of areas (4) install one punch rivet **N5**.

Area	Number
1	3
2	3
3	1



In area (1) use one punch rivet **N5**. Work operation identical on right side.



Adapt step (1) between roof outer skin (2) and A-pillar with emerging adhesive. Remove excess adhesive.

Important!

Do not use any cleaning agents containing solvents.

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



Important!

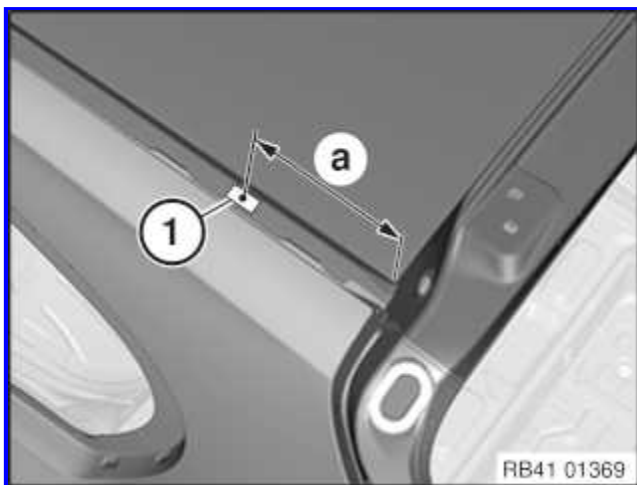
Spread excess adhesive in roof trim strip channel.

Mounting surfaces of clips for roof trim strips must not be coated with adhesive.

Tighten 4 star screws.

Tightening torque [41 31 1AZ](#).

Until the adhesive hardens: Mount hinge for tailgate.



Operation is described on the left side. Right side identical.

Fit an [EMC screw](#) after adhesive has hardened in position (1).

Dimension a = approx. 165 mm in front of corner of roof outer skin.

After hardening of the adhesive, seal adhesive areas, star screws and EMC screws with sealant D1.

Mounting surfaces of clips for roof trim strips must not be coated with sealant.

