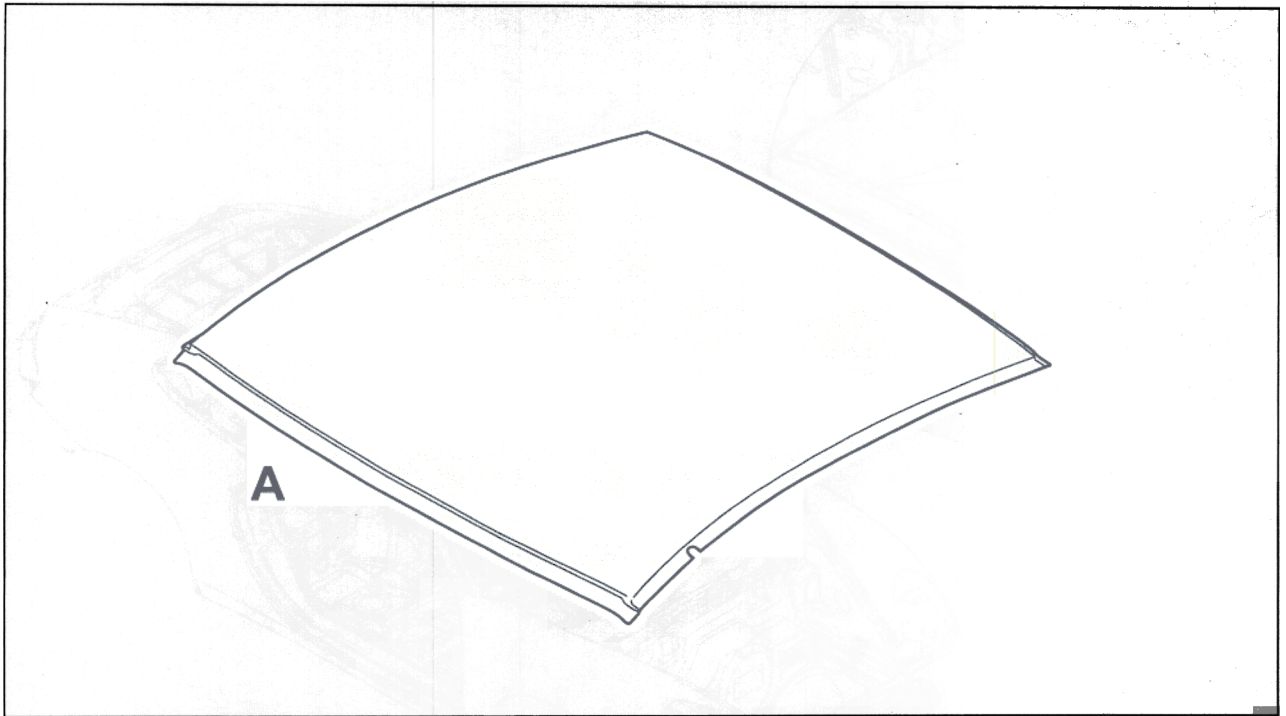


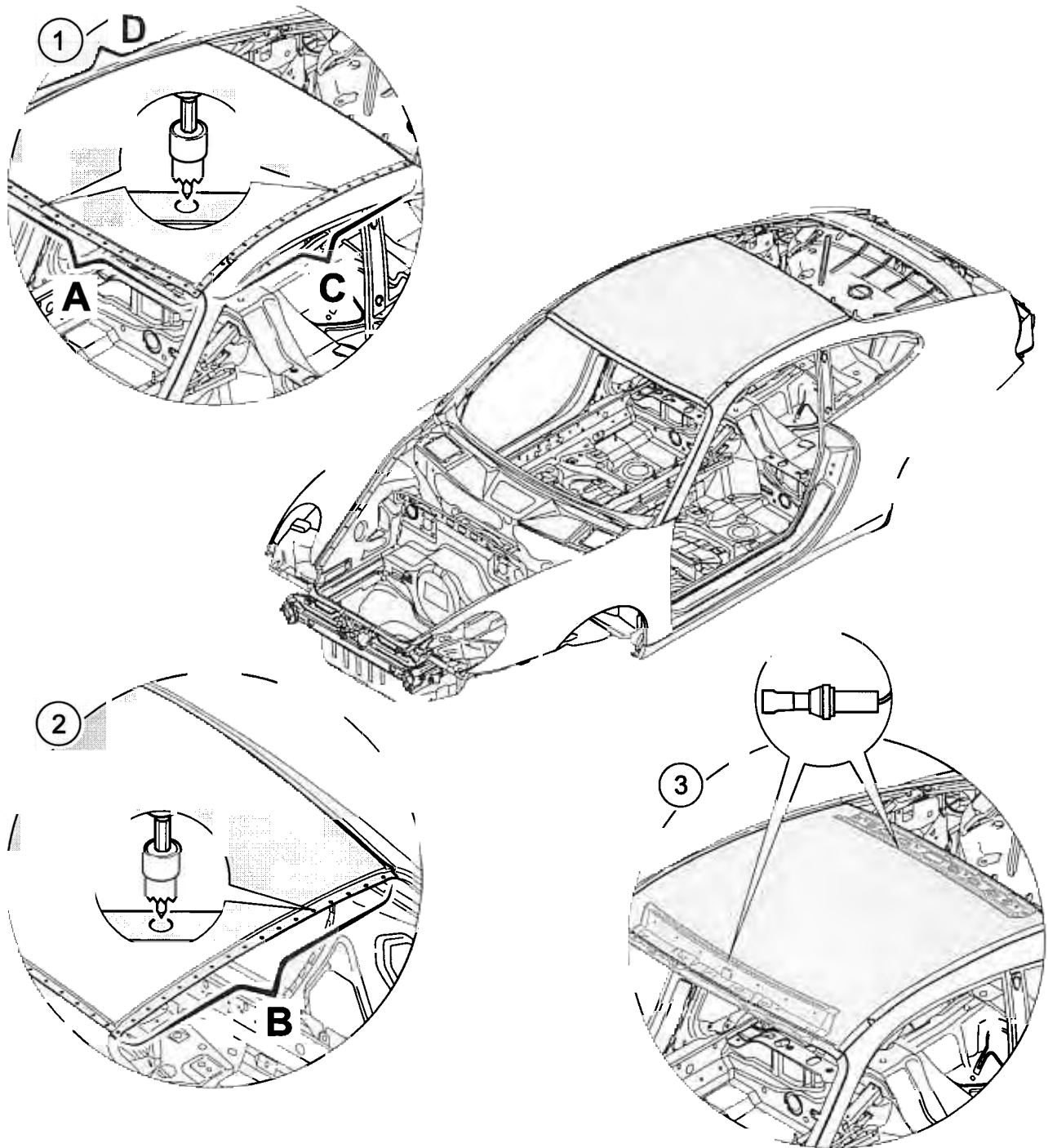
Replacing roof

The following spare body parts are required for the repair "Replacing roof":



A = Roof

Disconnecting roof



 **Warning!**

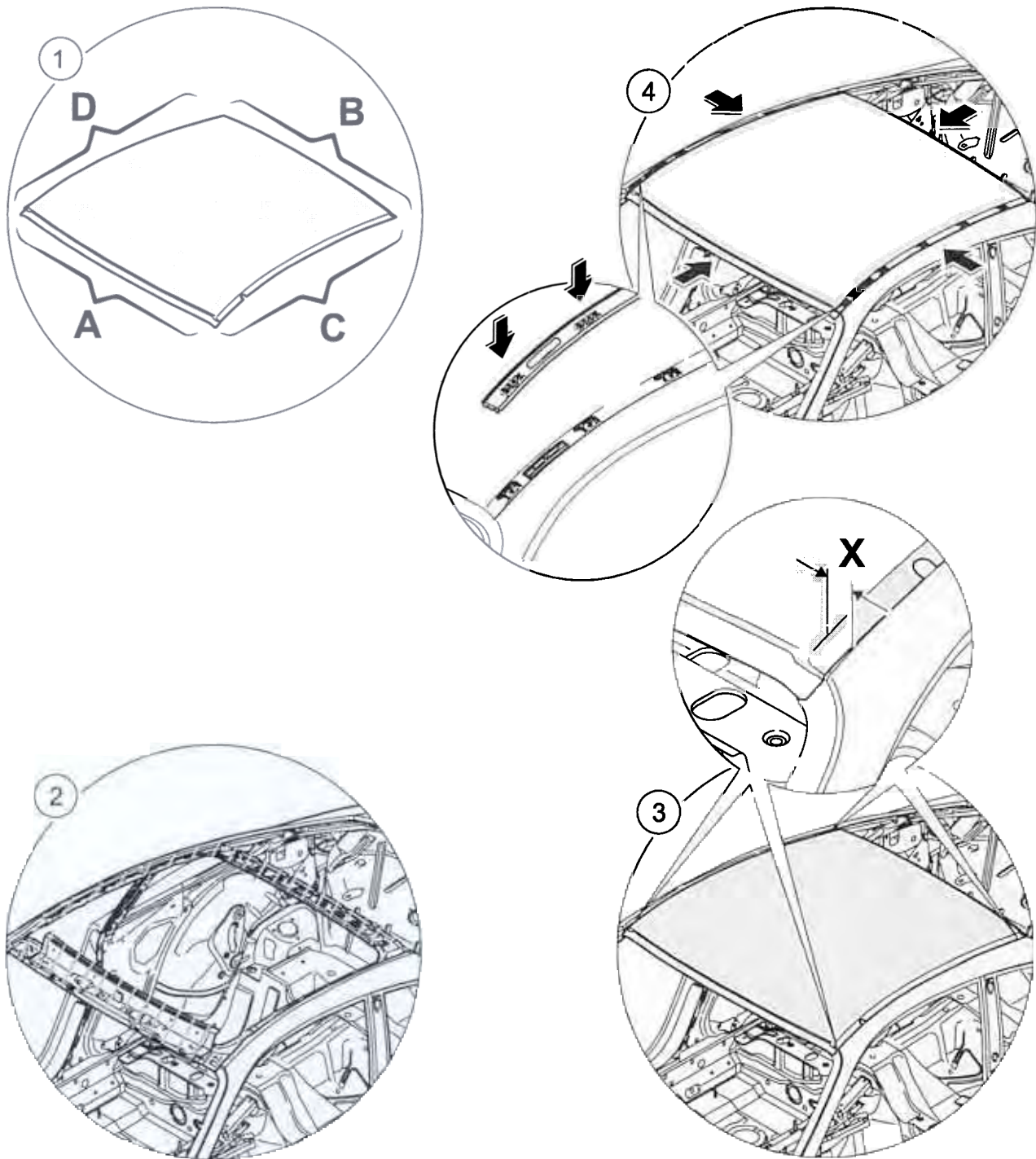
During body repairs, the following safety instructions and the general information and quality instructions must be followed. ⇒ Rep. Gr. 5; Safety instructions

 **Note!**

- ◆ *The accessories in the repair area should be removed, depending on the extent of the damage.*
- ◆ *All straightening work on the body in this area must have been completed before the damaged parts are removed.*

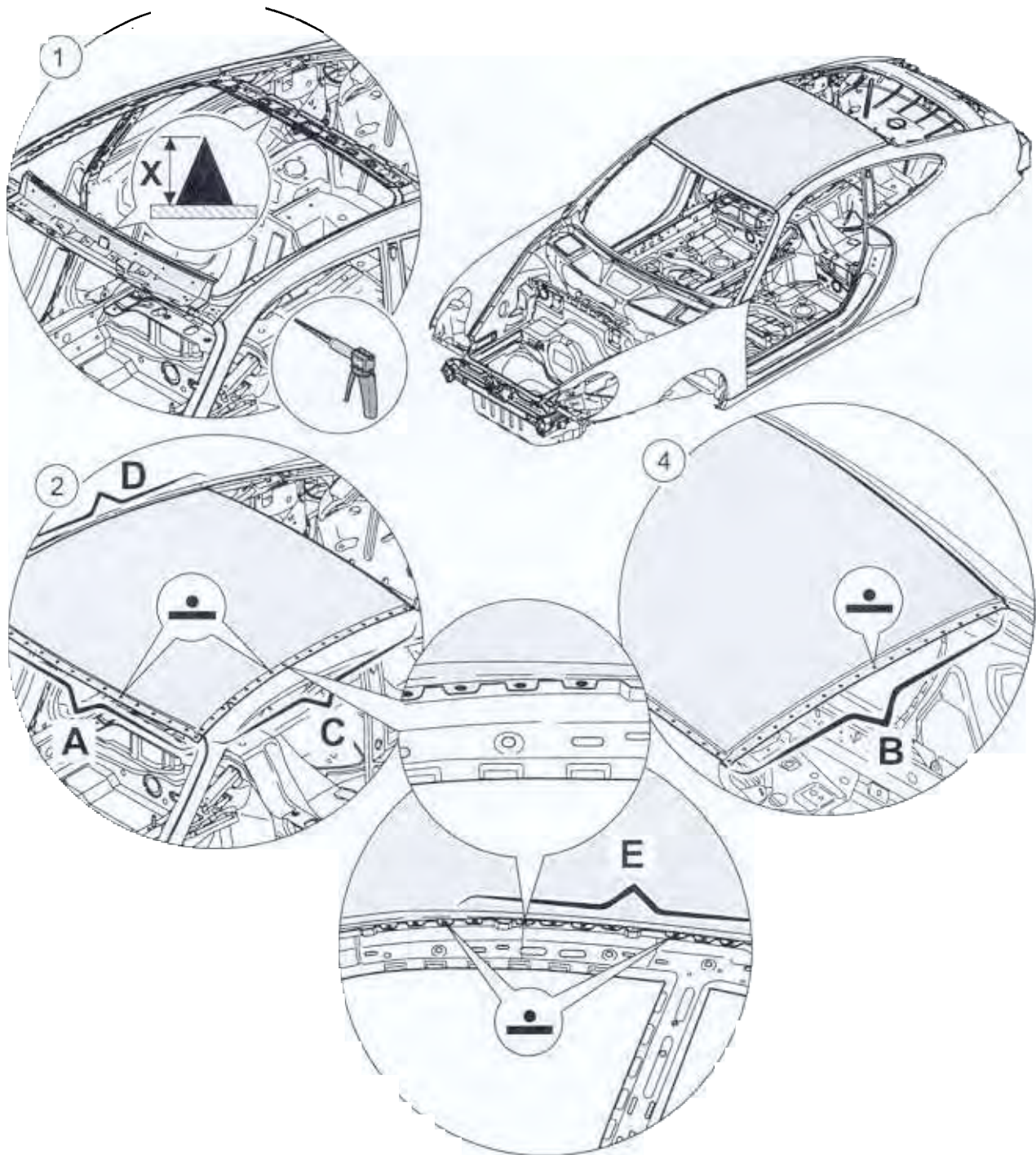
No.	Procedure	Instructions
	Separating the spot-welded joints between the outer roof panel/outer side section	Separate the spot-welded joints between the outer roof panel and the outer side section -C, D- and on the cowl panel frame -A- with the spotweld cutter.
2	Separating the spot-welded joints between the outer roof panel/rear roof frame	Separate the spot-welded joint between the outer roof panel and the rear roof frame -B- with the spotweld cutter.
3	Separating the bonded joint between the cowl panel frame on the outer roof panel/rear roof frame	Heat up the bonded joint between the outer roof panel and the cowl panel frame or the rear roof frame with the hot-air gun. Insert a metal spatula between the bonded joints and separate them. Lift the outer roof panel upwards out of the body.

Preparation of roof for installation and fitting



No.	Procedure	Instructions
2	Cleaning the welding areas	Remove the factory-applied primer on the welding areas of the spare part -A, B, C, D- using the rotary brush. Remove underbody coating and paint layers, etc. from the welding areas of the body with a hot-air gun or rotary brush.
3	Fitting the outer roof panel	Insert outer roof panel into the body. Measure the dimension -X = 25.2 mm- on the left and right of the roof channel. It is necessary to measure dimension X between four corner points on the outer roof panel and the outer side section.
4	Inserting roof joint strips	As a check, install the roof joint strips on the left and right. ⇒ Rep. Gr. 663619; Removing and installing roof joint strip. If necessary, centre the outer roof panel once more.

Welding in roof



No.	Procedure	Instructions
		Observe the working time of the adhesive: ⇒ 5-1 "Safety instructions for body repair" For ordering address, see: ⇒ "Tools and materials" in 51-15 page 7 Apply the adhesive evenly to the inside of the cowl panel frame and the rear roof frame as a triangular bead -dimension X = approx. 8 mm- .
2	Welding the outer roof panel/outer side section under shielding gas	Spot-weld the outer roof panel to the outer side section -C, D- . Ensure that the spot-welding is carried out within the corrugated cut-out of the inner roof frame -E- .
3	Welding the outer roof panel/rear roof frame under shielding gas	Spot-weld the outer roof panel to the rear roof frame -B- .

Tools and materials

Item	Designation of the special tool	Explanation
	Teromix-6700 2-component adhesive	Manufacturer: Henkel Teroson GmbH Postfach 10 56 20 69046 Heidelberg Hans-Bunte-Straße 4 Tel.: (066221) 7040 Fax: (066221) 704585
2	Teromix processing nozzle	Manufacturer: Henkel Teroson GmbH Postfach 10 56 20 69046 Heidelberg Hans-Bunte-Straße 4 Tel.: (066221) 7040 Fax: (066221) 704585
3	Basic straightening attachments for 911 Carrera (996)	⇒ Rep. Gr. 3; Workshop Equipment Manual
4	Star gauges Nr. 127-1	⇒ Rep. Gr. 2.4; Workshop Equipment Manual
5	MIG welder	⇒ Rep. Gr. 3; Workshop Equipment Manual
6	Multispot spotwelder	⇒ Rep. Gr. 3; Workshop Equipment Manual
7	Multispot spotweld cutter	⇒ Rep. Gr. 3; Workshop Equipment Manual
8	Pneumatic body saw	⇒ Rep. Gr. 3; Workshop Equipment Manual
9	Angle grinder	⇒ Rep. Gr. 3; Workshop Equipment Manual

Item	Designation of the special tool	Explanation
--	Oscillating body saw (special electrical cutter)	⇒ Rep. Gr. 3; Workshop Equipment Manual
11	Hole punch	⇒ Rep. Gr. 2.4; Workshop Equipment Manual
12	Hot-air gun	⇒ Rep. Gr. 3; Workshop Equipment Manual
13	Rotary brush	⇒ Rep. Gr. 3; Workshop Equipment Manual
14	Spotweld cutter Ø 7 mm Nr. 129	⇒ Rep. Gr. 2.4; Workshop Equipment Manual