

Interior transverse support ribs seperating from roof skin / structural adhesive seeping

Topic number	LI65.10-N-068734
Version	1
Function group	65.10 Roof paneling
Date	09-11-2018
Validity	906.xxx / 447.6/7
Reason for change	
Reason for block	

Complaint:

Client states roof in cargo area is detaching from the transverse support ribs / structural adhesive seeping

Attachments	
File	Description
Cross Member Separation.jpeg	Cross member separation

Cause:

Adhesive failure

Remedy:

1. Photo documentation for warranty claim – take pictures incl. tape measure to document the gap size between roof and substructure
2. If necessary, carefully lift the roof panel 2-5mm by inserting plastic wedges
3. Remove the old adhesive between outer panel and substructure using a plastic wedge
4. Prepare for new adhesive (clean with silicon remover A005 989 1971)
5. Apply activator A000 989 31 00 (alternative Teroson SB 450)
6. Apply new adhesive (blue body shop masking tape and a plastic razor blade can be used to help create a clean professional appearance, see (Final Repair Example.jpg)
7. Use the adhesive kit A005 989 61 71 (alternative Teroson MS 930)
8. Remove plastic wedges
9. Remove excessive adhesive that squeezed out
10. Park the vehicle for 10-12 hours to allow for curing

Attachments	
File	Description
Final Repair Example.jpg	Example of what final repair should look like

Symptoms

Body / Body/Cab / Trim strip/cover / Detaches

Parts

XENTRY TIPS

Part number	ES1	ES2	Designation	Quantity	Note	EPC
A 005 989 19 71			Silicon remover	1		X
A 000 989 31 00			Activator	1	alternative Teroson SB 450	X
A 005 989 61 71			Adhesive kit	1	alternative Teroson MS 930	X

Operation numbers/damage codes				
Op. no.	Operation text	Time	Damage code	Note
65-5827	ROOF PANEL ON REAR SUPER-STRUCTURE REPAIR	ZM	6504P 38	

Validity		
Vehicle	Engine	Transmission
Sprinter III	*	*
Vito/Metris 447 - 447.603	*	*
Vito/Metris 447 - 447.703	*	*

Attachments

Cross Member Separation.jpeg:



XENTRY TIPS

Final Repair Example.
jpg:

