

Roof trim

Installing moulded headliner

- ☐ Shorten cartridge nozzle by half in wedge-shaped part, and cut into it at an angle.
- ☐ Process adhesive at temperatures not below 20 °C.

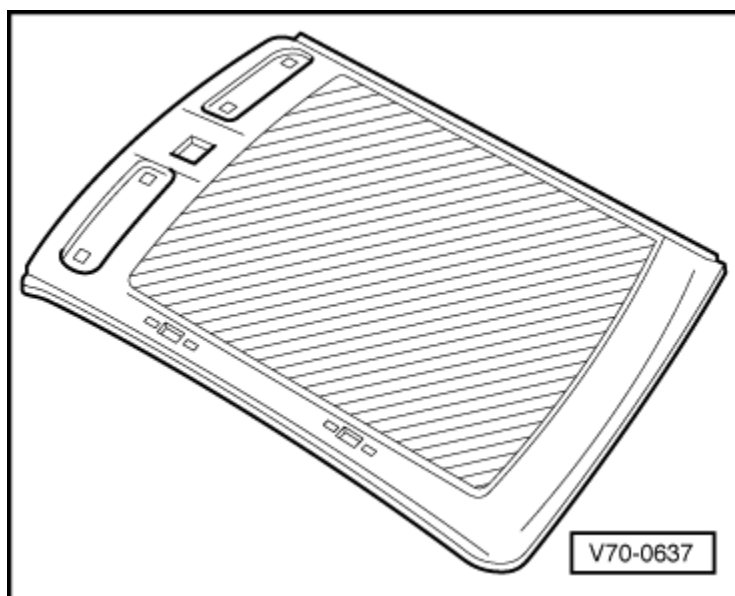
Note:

The content of a cartridge -320 ml- is not sufficient to affix a moulded headliner. Before starting bonding work, always make sure a second cartridge is to hand.

- ☐ Apply adhesive in adjacent, thick beads, and spread with a serrated stopping knife (doctor blade).
- ☐ Allow adhesive to flash at 20 °C for at least 30 minutes. Finger test: no stringing.

→ **Bonding surface in vehicles without sliding/tilting roof.**

- ◆ Bonding surface shown as shaded area in the illustration.

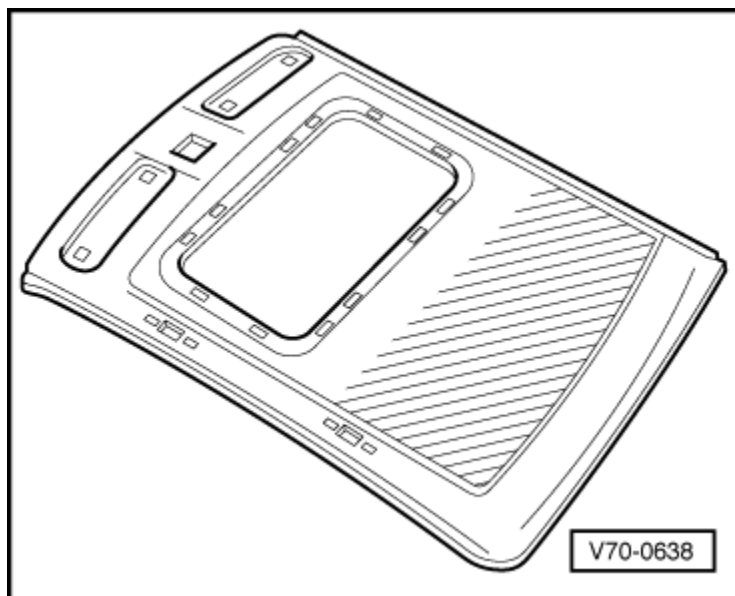


→ **Bonding surface in vehicles with sliding/tilting roof**

- ◆ Bonding surface shown as shaded area in the illustration.

Notes:

- ◆ If work cannot be continued during application of the adhesive, the adhesive must be scratched off. The moulded headliner can then be re-used.
- ◆ Excess adhesive must be immediately cleared away with water.
- ◆ Partially set adhesive can be removed with stain remover (e.g. ethyl acetate).
- ◆ Set adhesive can no longer be removed.



- ☐ Immediately before affixing the headliner, heat the applied adhesive with

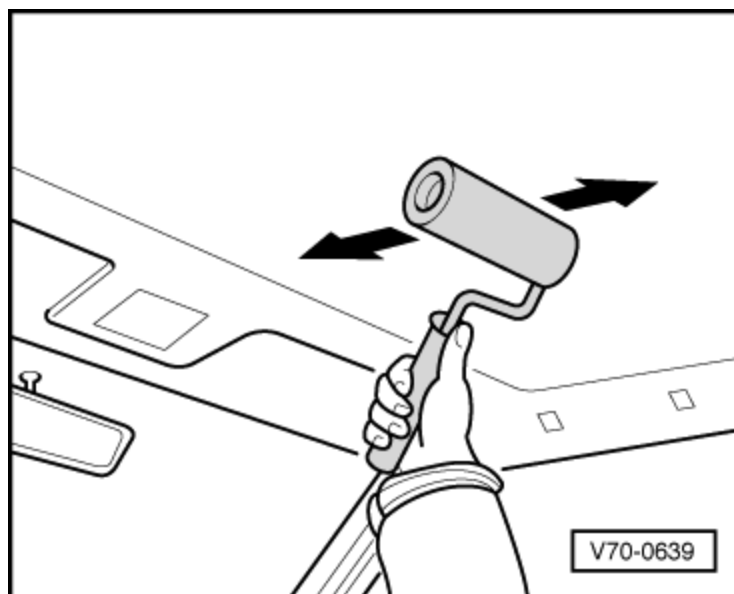
a hot-air blower at approx. 60 °C for 2 ... 3 minutes. The blower should be kept at a distance of 200 ... 300 mm from the headliner.

- Introduce moulded headliner diagonally into the vehicle through an open door and engage it in the centring lugs => Page [70-32](#).

- → Stick headliner to roof using a wallpaper roller, starting in the middle. It sticks in seconds.

Note:

When applying with the roller, exert only sufficient force on the headliner to stick it to the roof, without leaving press marks on it.



- → In vehicles with sliding /tilting roof, clip masking frame -1- into clips -3- of moulded headliner -2-.

