

SECTION 501-28 Roof Sheet Metal Repairs

VEHICLE APPLICATION: 2011.00 Focus

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SPECIFICATIONS**Lubricants, Sealers and Adhesives**

	Part number	Specification
PU glass adhesive (150 ml)	1 102 109	WSK-M11 P57-A1

REMOVAL AND INSTALLATION

Roof Panel

1. Repair parts

- Roof panel
- Middle roof rail

Removal

1. General Notes

- Required removal operations: Windshield, side windows, tailgate, headliner, interior trim panels and rear lights.

2. NOTE:

- Release the screw fixings (4 off) at the sides on the middle roof rail.
- Warm the bonded areas of the roof panel from outside (front and rear roof crossmembers) before removal. The middle roof rail will be removed with the roof.

Roof

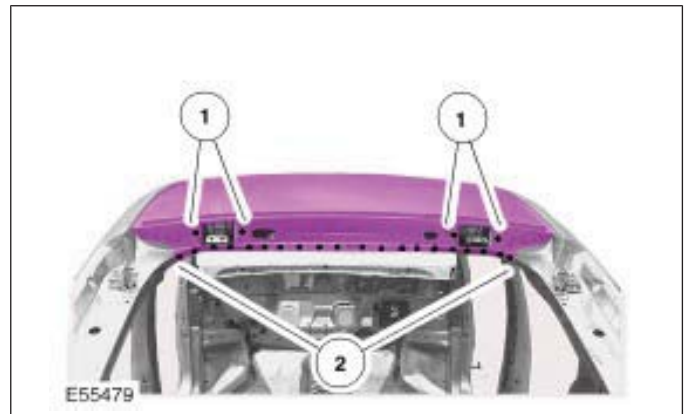
- Mill out the spot welds.



3. Rear roof panel

1. Mill out the spot welds.

2. Grind out the spot welds from the rear.



Installation

NOTE: Before resistance spot welding of body panels with a total panel thickness of 3 mm and greater, the welding equipment instructions contained in sub-section 501-25 must be followed.

1. Roof panel rear

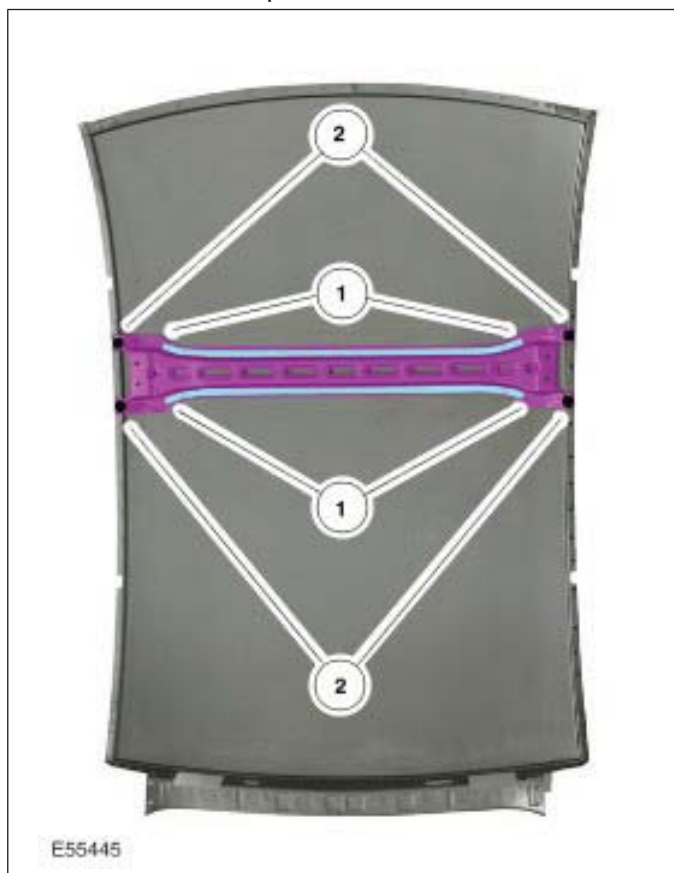
- Drill holes for puddle welding.



2. **NOTE:** Measure out the correct installation position of the roof rail on the vehicle.

REMOVAL AND INSTALLATION**Install the middle roof rail**

1. Apply PU glass adhesive.
2. Resistance spot weld.

**3. Prepare the bonded areas**

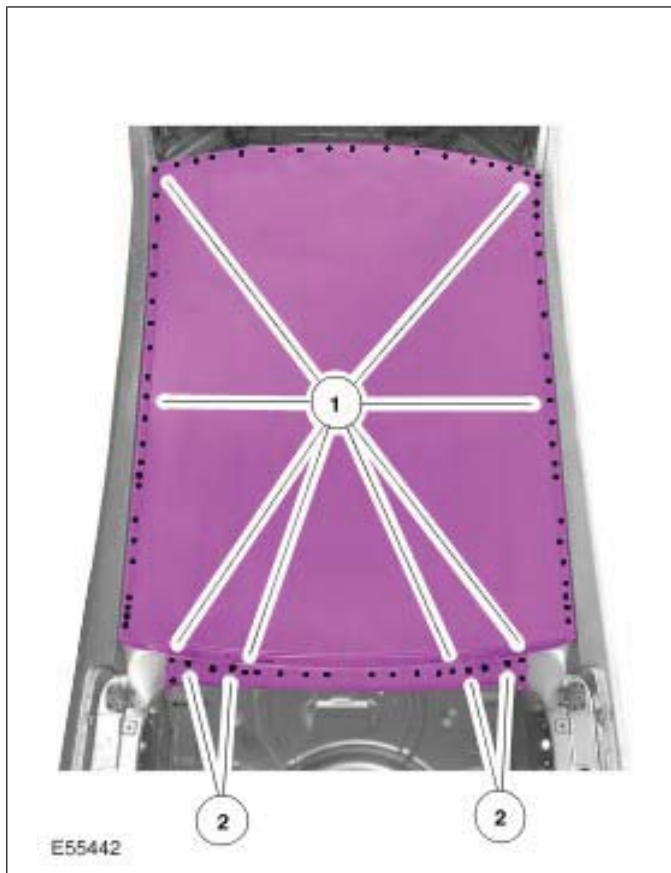
- Apply PU glass adhesive.

**4. Offer up the roof panel and weld in place.**

1. Resistance spot weld.

REMOVAL AND INSTALLATION

2. Puddle weld.

**5. Weld the roof into place**

1. Puddle weld.
2. Resistance spot weld.

