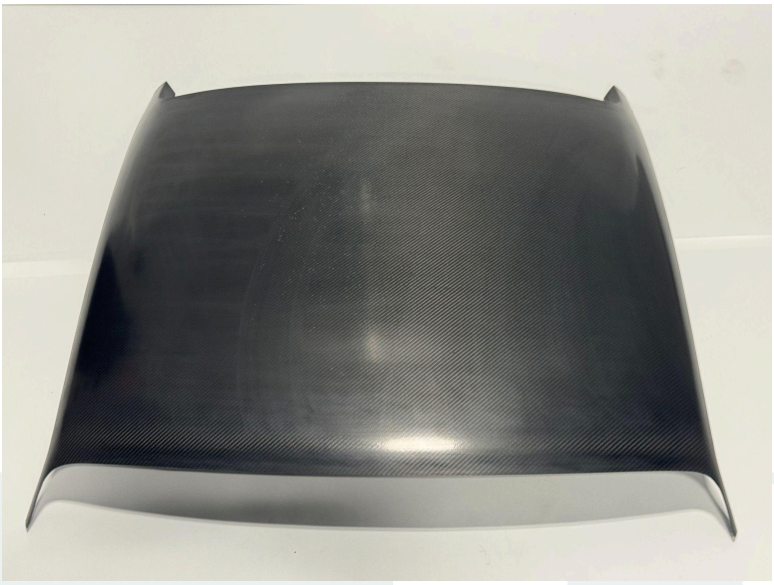
ZURLINDEN
GRUPPE

INSTRUCTIONS DOCUMENT

ROOF SKIN, 1965-1998
No. ZG3.503.087.00 v1



AUTOCLAVE CARBON FIBER ROOF SKIN REPLACEMENT PANEL FOR BONDING ONTO EXISTING COUPE ROOF STRUCTURES. ENABLES SUNROOF DELETE, WEIGHT REDUCTION, CHASSIS STRENGTHENING.

1. Remove front & rear windshields
2. Remove all sunroof system and mounting bracketry welded to the chassis
3. Mark off a perimeter about 1.5" from the top of the windshield and cutaway the middle area of the roof
4. **OPTIONAL For pre-964/993 models, trim-off the rear window flange to retain a ventilated headliner
5. Prepare the Roof Skin with a flap-wheel sander. Grind a tapered profile about 1.0-1.5" along the bonding edge around the entire perimeter of the autoclave carbon fiber roof skin -- this will give the carbon flexibility and a smooth termination line.

INSTRUCTIONS DOCUMENT

6. Test fit the roof skin; it should fall into position quite naturally, however some trimming is typically required.

7. After all trimming and grinding, the roof skin edges should line-up with the edge of the windshield and back glass frames, and die at the bottom of the drip rails

8. Make your "holding system" with a series of clamps and "hold-downs" around the entire perimeter. Use small C-type vice-grip pliers/clamps and wood paint sticks between the clamps to create uniform pressure around the entire 1.5" flange perimeter.

9. Prepare the flange base metal flange for bonding per 3M's instructions:
    a. Remove all paint, rust and contaminants from surfaces to be bonded using a 36 or 50 grit abrasive disc or a 3M™ Clean N Strip™ roll to bare metal.
    b. When using new part, remove from the surface to be bonded, all pre-treatment to bare metal.
    c. Clean all the areas to be bonded with general purpose 3M™ Adhesive Cleaner 08984 or similar.
    d. Place adhesive cartridge in applicator gun.
    e. Unscrew the cap from the cartridge and dispense enough adhesive to check if both parts emerge.
    f. Cut off the top of mixing nozzle to provide desired bead size.
    g. Attach and lock the mixing nozzle to adhesive cartridge.
    h. Apply adhesive to all areas to be bonded (all bare metal surfaces). Using a plastic spreader, tool out the adhesive to provide a base ("primer coat") for an additional adhesive bead and to ensure corrosion protection. It is important to completely cover all bare metal surface.
    i. Apply an additional adhesive bead to either the replacement panel or the inner structure.

10. Position roof skin into the adhesive bed and clamp the entire perimeter with your pre-made tooling.

11. Remove clamps after a 12-hour set.

12. Grind away excess adhesive and use good quality fillers to blend edges and tops of A and C pillars