

The following repair represents replacement and installation of a shaped part for the cavity bulkhead of the C-pillar.

When replacing shaped parts in other locations, adopt the procedure illustrated here and adapt to suit prevailing conditions.

Location of shaped parts,

refer to arrangement of shaped parts in cavity bulkhead.

Further scopes,

refer to Installation of cavity bulkhead for cover for side member,

refer to Installation of a cavity bulkhead with cavity foam.

Before this operation, the spare part to be fitted should be prepared ready for installation (adjusted to fit, cut to size, coated with zinc dust paint etc.).

**Caution!**

The open time of the original BMW window adhesive until a skin is formed is 30 minutes in a standard climate of 23 °C and 50 % relative humidity.

The open time of the adhesive until a skin is formed is determined by the relative humidity.

The higher the humidity, the faster the adhesive hardens.

**Note:**

First clean contact faces of foam residue.

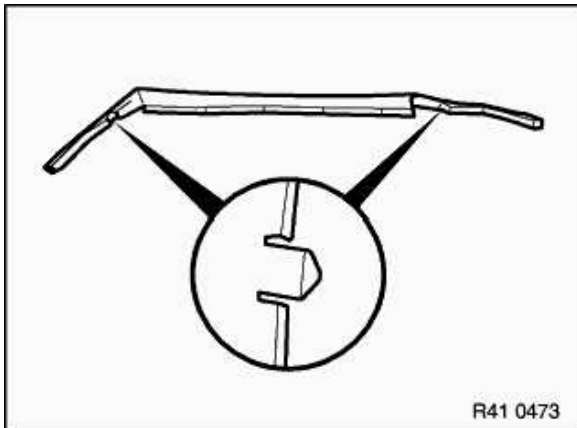
**Caution!**

If vapors are produced when the foam is removed, these must be extracted. Ensure the area is well ventilated.

### Caution!

Observe safety instructions when dealing with

- activator for original BMW windshield adhesive, refer to BMW Parts Service
- original BMW windshield adhesive, refer to BMW Parts Service

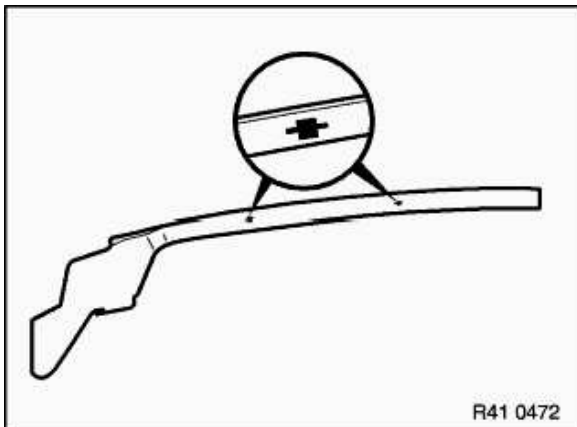


Shaped parts with clips:

### Caution!

If clips are fitted to shaped parts to secure them, do not allow clips to engage.

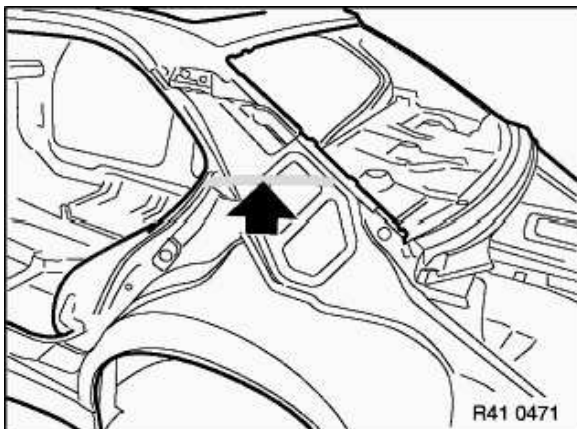
Fit shaped part and mark up contact face on body and spare part, fitting spare part if necessary.



Shaped parts with bore for retaining tabs:

Fit shaped part and allow retaining tabs to locate in bores.

Mark up contact face on body and spare part, fitting spare part if necessary.



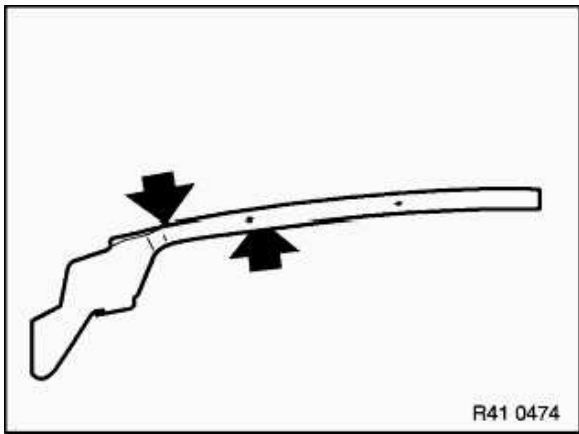
If necessary, remove spare part once again.

Remove shaped part.

Surface-sand flanging surfaces of shaped part with coarse sandpaper (50 - 100 grain).

Clean contact surfaces on the body and on the shaped part with activator for original BMW windshield adhesive.

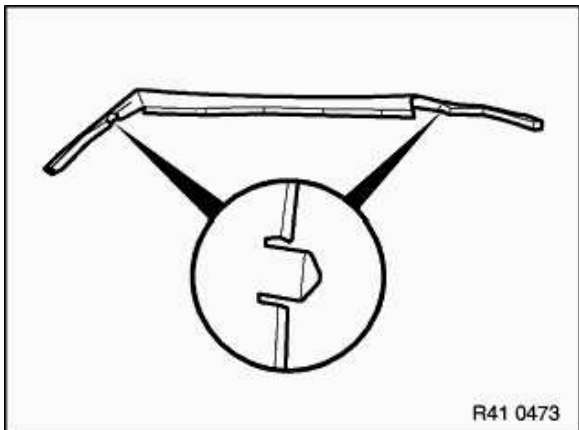
Apply an adhesive bead of original BMW windshield adhesive approx. 15 mm high within the marked contact surface of the shaped part.



Locate shaped part.

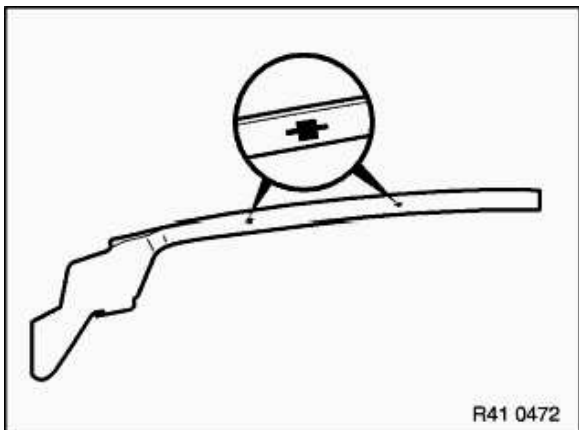
Shaped parts with clips:

If locating clips are fitted to shaped part, allow clips to engage.



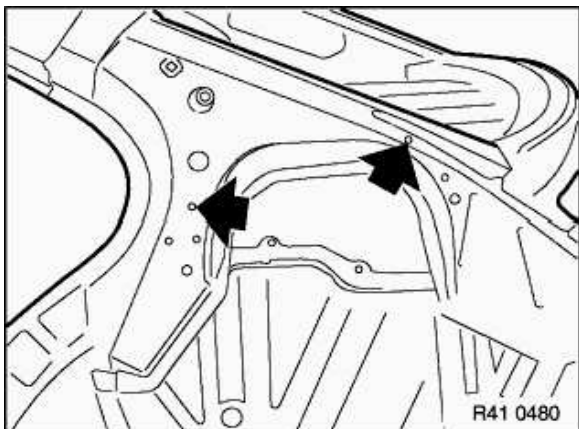
Shaped part with bore:

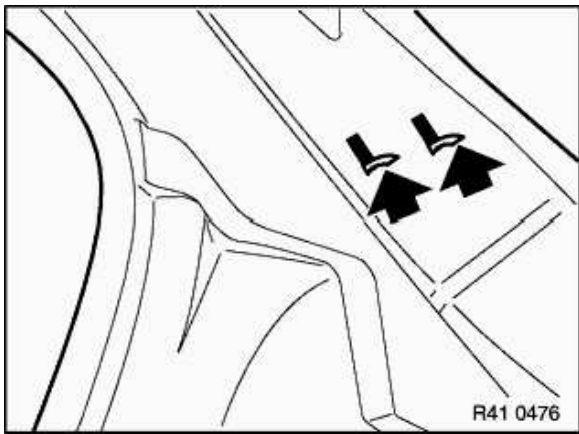
If the shaped part has bores for retaining tabs, allow bores in retaining tabs to engage in retaining tabs.



Shaped parts with clips:

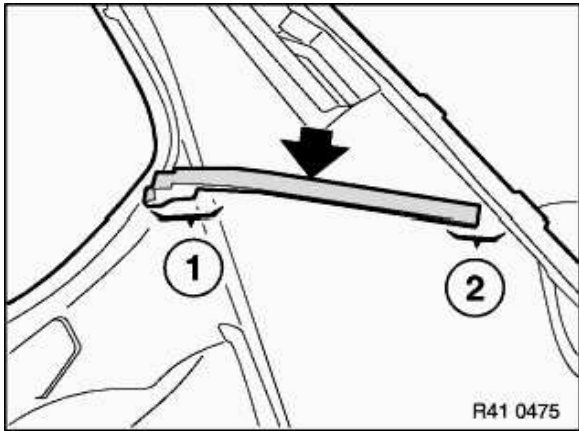
After locating the shaped part, ensure that bores for retaining clips are sealed and, if necessary, reseal them.





Shaped part with bore:

After locating the shaped part, ensure that recesses on retaining tabs are sealed and, if necessary, reseal them.



Apply an approx. 15 mm high bead of original BMW windshield adhesive on the contact surface of the shaped part.

**Caution!**

Increase height of glue bead to min. 20 mm at edges (1, 2) and other critical sealing points.

Fit, secure and weld up spare part.