Installation of the Roof Stiffener Replacement System (RSR)

In most situations it is necessary to remove the vehicle roof stiffeners for installing a HOLLANDIA 700 or HOLLANDIA 600 sunroof. For keeping the legally required roof stiffness Webasto has developed a system that substitutes the original stiffener with the same (or an even better) safety effect. This new safety system is called Roof Stiffener Replacement System (RSR-System). It is placed between the roof cant rail construction and the sunroof cassette (on both sides of the cassette). It not only absorbs impact loads, but it also distributes loads on the sides of the sunroof.

The integration of the Roof Stiffener Replacement System with HOLLANDIA 700 or HOLLANDIA 600 takes place during the sunroof installation.
The Roof Stiffener Replacement System will be attached to the sunroof cassette. It is easy to assemble the kit to the sunroof cassette – there will be neither any change of the sunroof geometry, nor rattling or displacement after installation.

Note: For some vehicles it is absolutely necessary to use a RSR-system. Application information can also be found on http://info.webasto.nl.
Check if all parts are included:
- 2 brackets (L+R)
- 2 profiles
- 8 T-bolts M5x16.5
- 8 washer based nuts
- 4 washers
- 2 pieces of foam tape
- 1 Permabond glueing set
- 1 window sticker

Necessary tools (not included):
- eight spring clamps and
- four wooden blocks.

Preparation:
- Check if Hollandia 700 / Hollandia 600 is functioning correctly.
- Remove glass panel and sunshade.
- Slide mechanism fully backwards.

**Note:** Mount RSR-system before installing the Hollandia 700 / Hollandia 600 in the vehicle.

Put piece of tape onto aperture next to curve to protect rail from contacting glue.
Apply **initiator type 32** to roof cassette on contact surface with brackets.

**Note:** Use initiator type 32 from gluing set only (because of its enhanced filling capacities).

**WARNING!** Initiator liquid is poisonous! Do not let liquid touch skin!

Drill 3 holes (diameter: 5,5 mm) into bracket at shown positions. (If holes are already in bracket: go to next step.)

**WARNING!** Fumes from glue are poisonous! Make sure the working place is supplied with fresh air at all times!

Place brackets (L+R) and clamp them at the outside of the frame using wooden blocks and spring clamps.
Additional Installation Instruction

Sunroof: Hollandia 700, Hollandia 600
Doc No.: 0401042B (3309646C)
Date: 25th of May 2004

Turn frame upside down.
Place wooden blocks (L+R) and spring clamps on inside of frame.
Let glue dry for at least 30 minutes. Then remove all spring clamps.

Install Hollandia 700 / Hollandia 600 according to standard installation instructions.

Note: Do not install side brackets yet.

Measure distance between cant rail of car and bracket (L+R) at indicated length of profile as it will be installed later (see arrow in upper picture).

For doing this you will have to determine the exact position of the profile as it will be installed.

- Profile will have to be mounted as high as possible. Observe minimum height of 10.6 mm (0.33 inch) of RSR profile to support cant rail of car (see second picture).
- The maximum allowed contact angle is 30°. In certain cases it can be helpful to install the profile upside down.
- Flange of profile may not be below bracket (dotted line).

1) Profile; 2) Car roof; 3) Protective foam; 4) Cant rail
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<tr>
<td>1</td>
<td>Shorten profiles to this measurement minus 2mm.</td>
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<tr>
<td>2</td>
<td>Apply foam tape around ends of profiles.</td>
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<tr>
<td>3</td>
<td>Place profile (L + R) as close to B-pillar and as high as possible.</td>
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<td>4</td>
<td>Tighten nuts with spanner nr.8. Maximum torque is 5 Nm.</td>
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**Additional Installation Instruction**

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**Drill holes into roof cassette through holes of bracket and deburr edges. Apply primer on edges of holes.**

**Place and fasten bolts in drilled holes with maximum torque of 5 Nm.**

**Attach side brackets according to standard installation instructions.**

**Proceed with installation of Hollandia 700 / Hollandia 600.**

**Attach window sticker to inside of rear window in one corner.**

Help to improve our quality standard by filling out and sending us the questionnaire. Thank you in advance for your cooperation.