Bulletin:
Sprinter - Retrofitting of roof hatch

EVS Charleston, 8/15/2017
Mercedes-Benz Vans, LLC

Mercedes-Benz

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This bulletin is not intended to serve as a work instruction, but merely to provide some helpful information for upfitters to take into consideration before retrofitting or modifying a Mercedes-Benz or Freightliner Sprinter.

Prior to making any modification to or installing any equipment in or on a Mercedes-Benz or Freightliner Sprinter, you should review and insure compliance with all applicable laws and regulations, consult with Vans Engineering Support for Upfitter Management for additional and updated information, and read the Body & Equipment Guidelines for Sprinter Model Series 906.

Upfitter Management Vans Contacts:

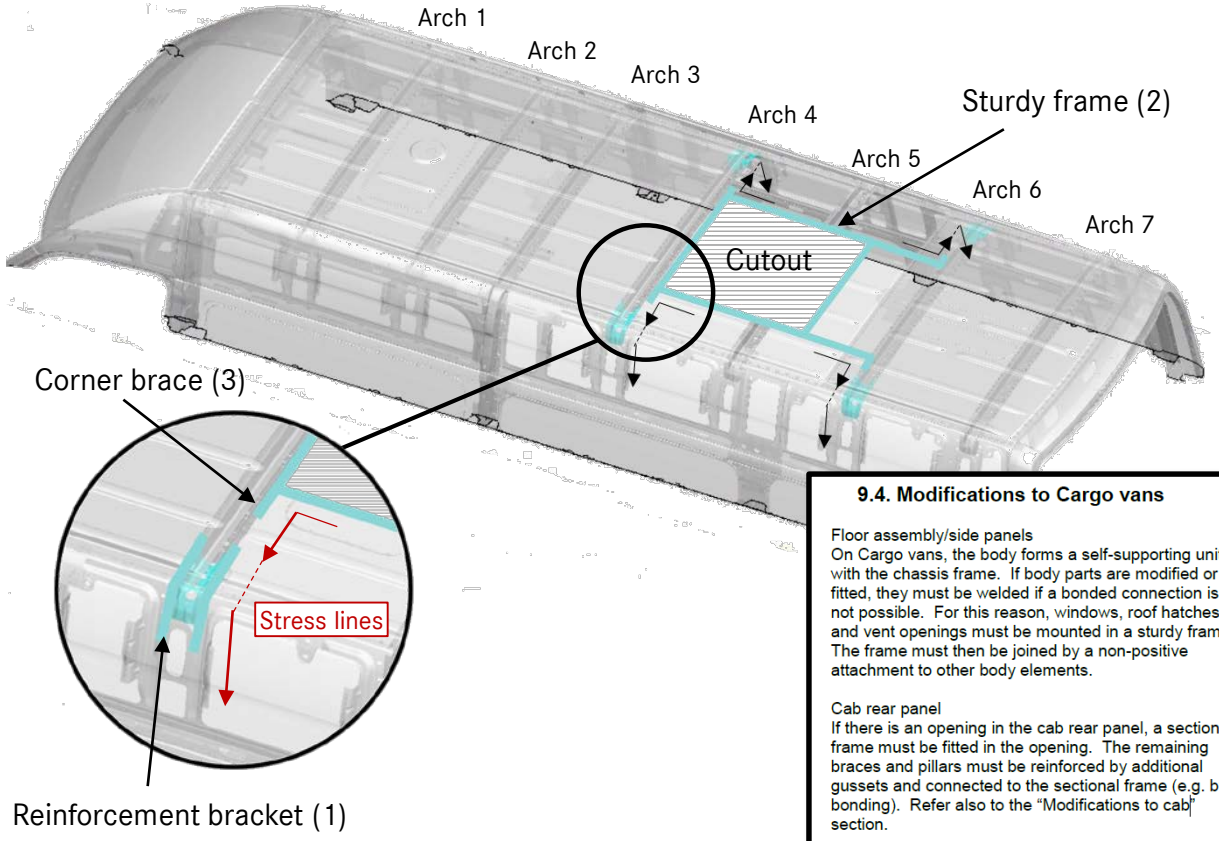
For information or upfitter inquiries
please submit a request via our website:
www.upfitterportal.com

Sprinter - Retrofitting of Roof Hatch

Technical Bulletin

Retrofitting roof hatch (Cargo/Passenger Van)

To retrofit a roof hatch and to be compliant with the Body and Equipment Guideline (BEG), the following aspects have to be considered:



9.4. Modifications to Cargo vans

Floor assembly/side panels
On Cargo vans, the body forms a self-supporting unit with the chassis frame. If body parts are modified or fitted, they must be welded if a bonded connection is not possible. For this reason, windows, roof hatches and vent openings must be mounted in a sturdy frame. The frame must then be joined by a non-positive attachment to other body elements.

Cab rear panel
If there is an opening in the cab rear panel, a sectional frame must be fitted in the opening. The remaining braces and pillars must be reinforced by additional gussets and connected to the sectional frame (e.g. by bonding). Refer also to the "Modifications to cab" section.

- Referring to the BEG the roof is part of the body which forms a self-supporting unit.
- To insert a roof hatch, it might be necessary to have a cutout in the roof (skin and arch) of the Van.
- If you are cutting the roof, ensure corrosion protection. (BEG Chapter: 6.3.)
- To ensure a stabile structure, it is important to reinforce the remaining body and consider the extra weight of the added parts.
- Reinforcement brackets (1) have to be installed at both ends of the arches which are located next to the cutout. (see "Stress lines")
- Install a sturdy frame (2) and corner braces (3) which are connected to the arches next to the cutout.
- The sturdy frame (1) has to be integrated without deforming the arches next to the cutout. Avoid tension or pressure.
- Ensure leak tightness