

# Leakages In The Roof Platform On Citroën DS And ID Model Cars

## Citroën Technical Bulletin Number 51

This was an official Citroën Factory service bulletin, written during the era of the DS's production. It covers completely the process of removing and replacing the roof on older DS's and ID's. It does not cover removal of the roof on newer cars with a roof that was glued on rather than bolted on. I may cover this in a later version of these pages.

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Parts Information for 1966-1969 models:

- [DLF, DYF, DJF, DXF models](#)
- [DV, DT models](#)
- [DX, DJ, DY, DL models](#)
- [Tony's roof clip drawings](#) Thanks to Tony Jackson for these fine drawings. The clips are an important but hard to find part. Tony suggests that the drawings are not exact, so be sure to model the original clip for curvature. On most later cars, the roof is glued on rather than bolted. You will need to get or make more of them if you are converting from a bonded to a bolted roof. See this for detailed instructions on making your own clips.

Some of the materials and procedures are dated, or may not be suitable for cars that are no longer in like new condition. The following should be observed:

1. When paper tape is mentioned you can use masking tape.
2. A modern replacement for "mastic" is urethane adhesive. Beige color has been suggested as the original color, but it would be wise to simply match the stuff found on your car.
3. When doing this or any other restoration work, it is highly advisable to have a parts manual on hand to obtain part numbers. This makes it much easier to find them.

These pages are image heavy. Please be patient during download.

**Thanks to Rick Levy for sending me this article!**

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# Leakages In The Roof Platform

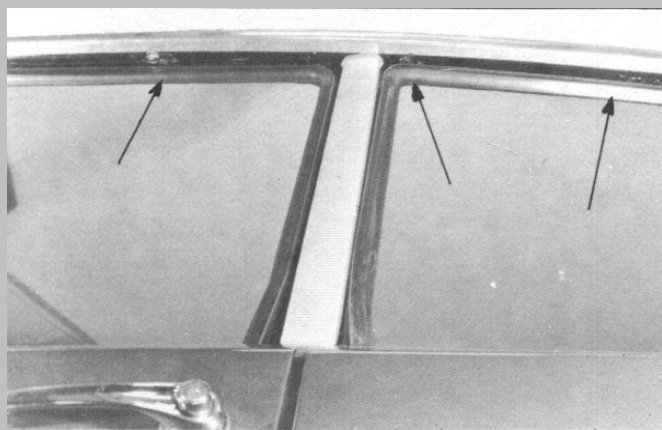
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### 1st Case

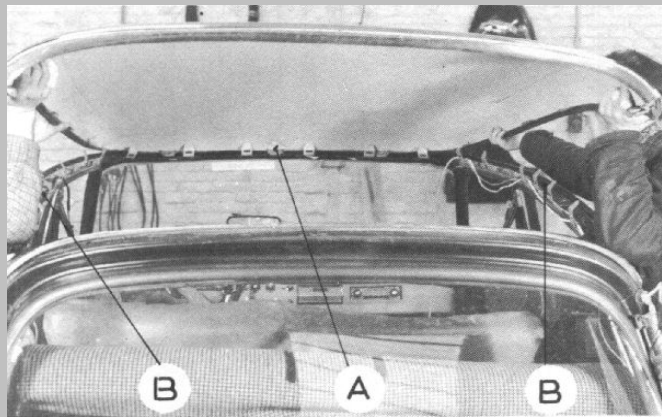
The water appears in the bottom of the roof platform and runs mainly through the passage hole of the roof antenna at the right front side of the front passenger seat.

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In the majority of these cases (and if the headlining is not soaked), it is a matter of imperfect mounting of the roof.



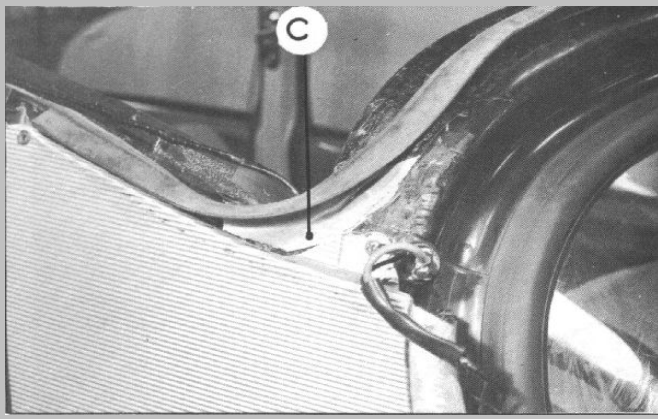
In order to be sure, laterally spray the car with a jet, particularly at the right of the roof mounting screw. If the water does not penetrate around the screw, then the roof is mounted improperly.



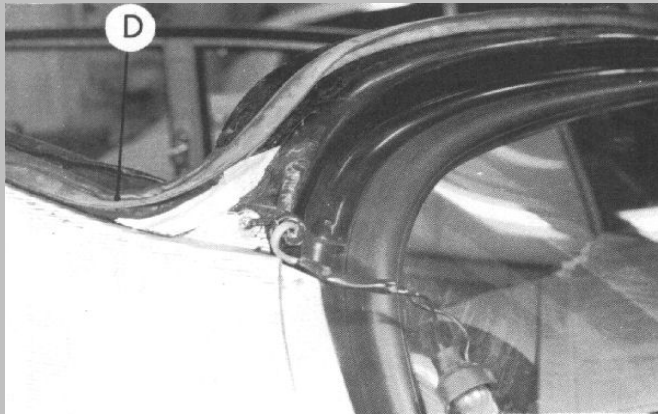
Remove the roof. Clean the platform.

Mount the roof as indicated below:

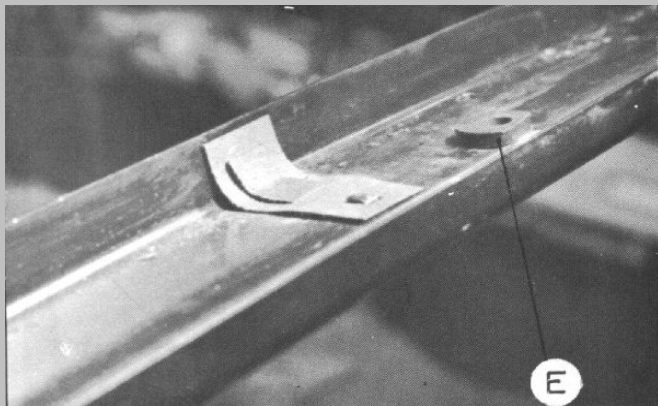
Catch three pilot screws, the first (A) at the front, in line with the axis of the car, and the two others (B) on the side rails of the platform, approximately above the center post. Lock these screws with nuts having a maximum thickness of 4 mm.



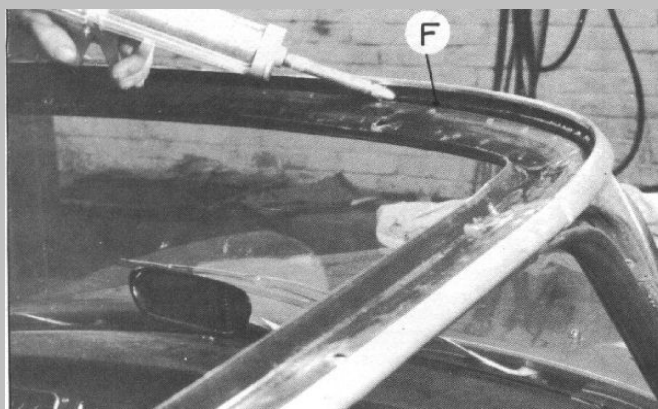
Correctly position the rear rubber sealing strip. Carefully glue it to the round rear section and hold it in place with the help of masking tape (C).



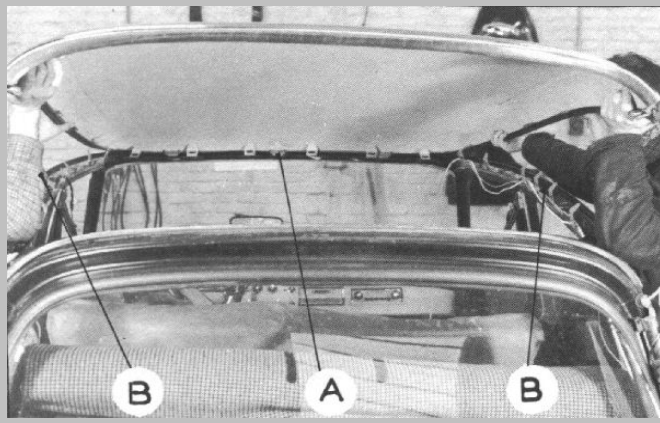
Apply a supplementary band of mastic at (D).



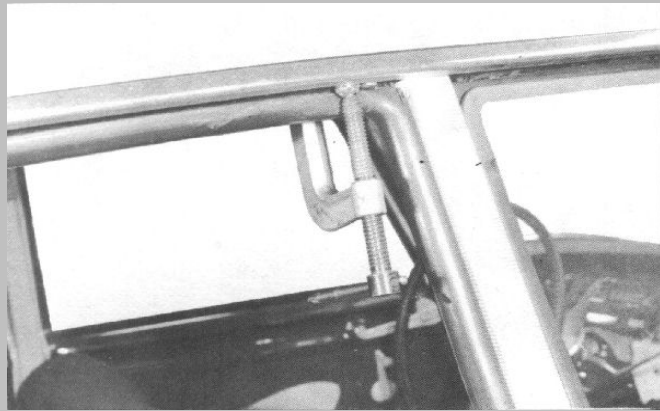
Glue the fourteen rubber spacer washers (E, Part# D825-90) on the platform at the holes for fastening the roof.



Deposit a continuous ribbon of mastic (semi-liquid plastic compound) in the front section of the roof platform (see F).  
Use a caulking gun.



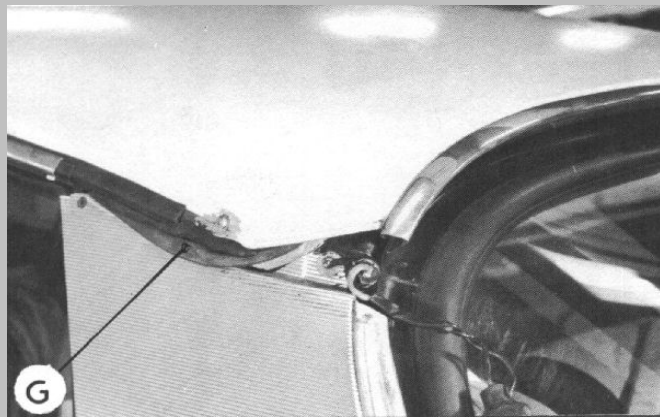
**Fit the roof at its front position on the pilot screw (A)**



**Set the roof on the platform, centralize it by lateral pilot screws (B).**

**Clamp it at the right and left as indicated in the picture.**

**Tighten the nuts on the three pilot screws without locking them.**



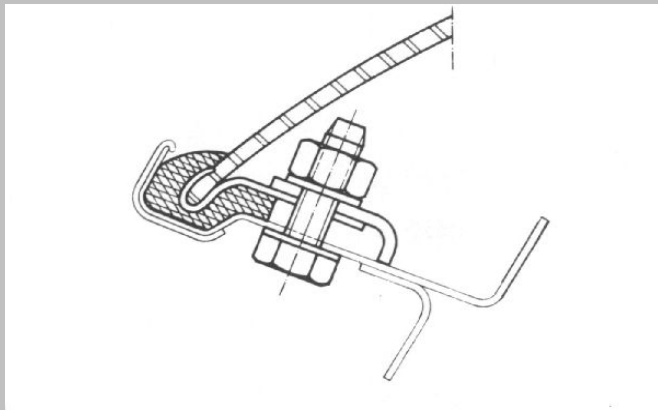
**Attach the other fourteen screws (put the washers under the heads). Catch the nuts without tightening them.**

**Start tightening the nuts beginning with the front center pilot screw (A).**

**Successively, tighten a screw to the right, then to the left, working progressively toward the rear.**



**Tamp the mastic into the two rear corners and see that the lips of the rubber strip are in correct position at (G).**



**Lay a ribbon of sealing mastic into the front gutter.**

**Carefully compress the mastic into the gutter, being sure to cover the upper part of the rubber lip.**



**Spread the mastic evenly, using a rag saturated with soapy water.**

**Thanks to Rick Levy for sending me this article!**

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# Leakages In The Roof Platform

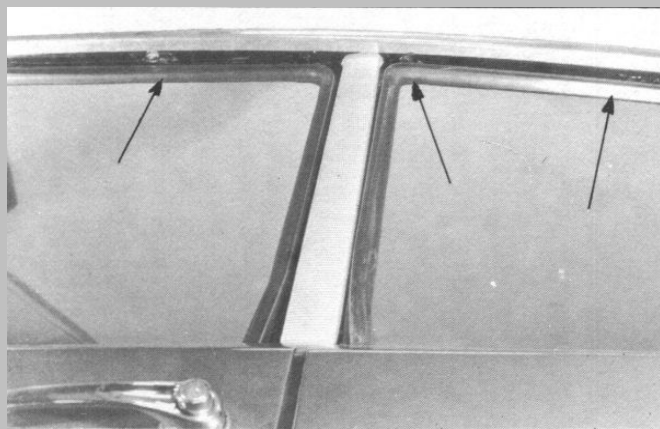
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### 2nd Case and Breaks

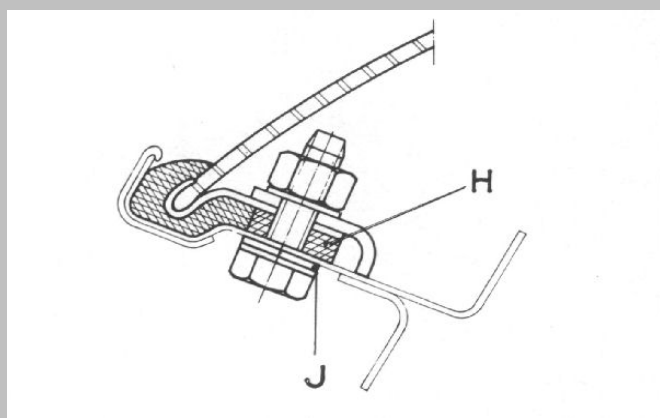
**Water appears in the bottom of the roof platform.**

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The water penetrates, by capillary action, through the roof mounting screws.

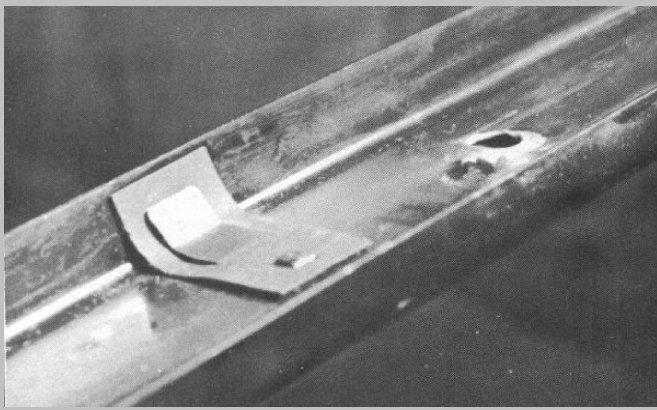


To detect this leak it is necessary to spray the car laterally to the right of the mounting screws.

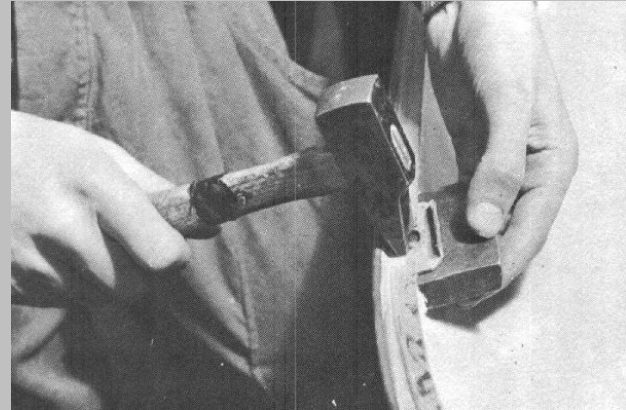


Remove the screw causing the leak. If the platform is not deformed, and if the washer under the head of the screw is not "dished", replace the screw, interposing a rubber washer (H) (D.825-90) into the platform and a 7mm diameter fiber washer (H), a plastic-metal washer (7 mm diameter) between the platform sheet metal and the steel washer under the head of the screw.

Cover the head of the screw with mastic.



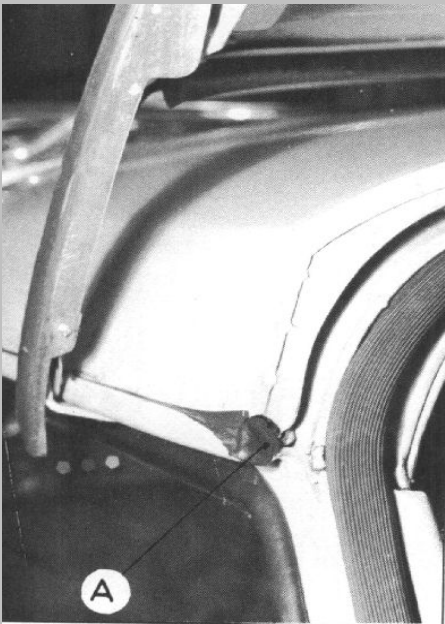
If, after removal of the screw, the platform is found to be deformed (bent upward), it is necessary to remove the roof in order to "correct" the platform and, sometimes, the roof attaching clips.



In case the roof clips need to be redressed, it is advisable to work with care in order to avoid any deformation of the roof frame.

Afterward, reinstall the roof as shown in the [1st Case](#).

## Mounting Of The Roof On The Station Wagon (Break)



**The mounting of the roof is done in the same manner as for the sedan.**

**However, it is advisable, after mounting, to place a ball of mastic at both ends of the rear of the roof as indicated (at A) in the picture.**

**Thanks to Rick Levy for sending me this article!**

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# Citroën ID/DS Roof Parts

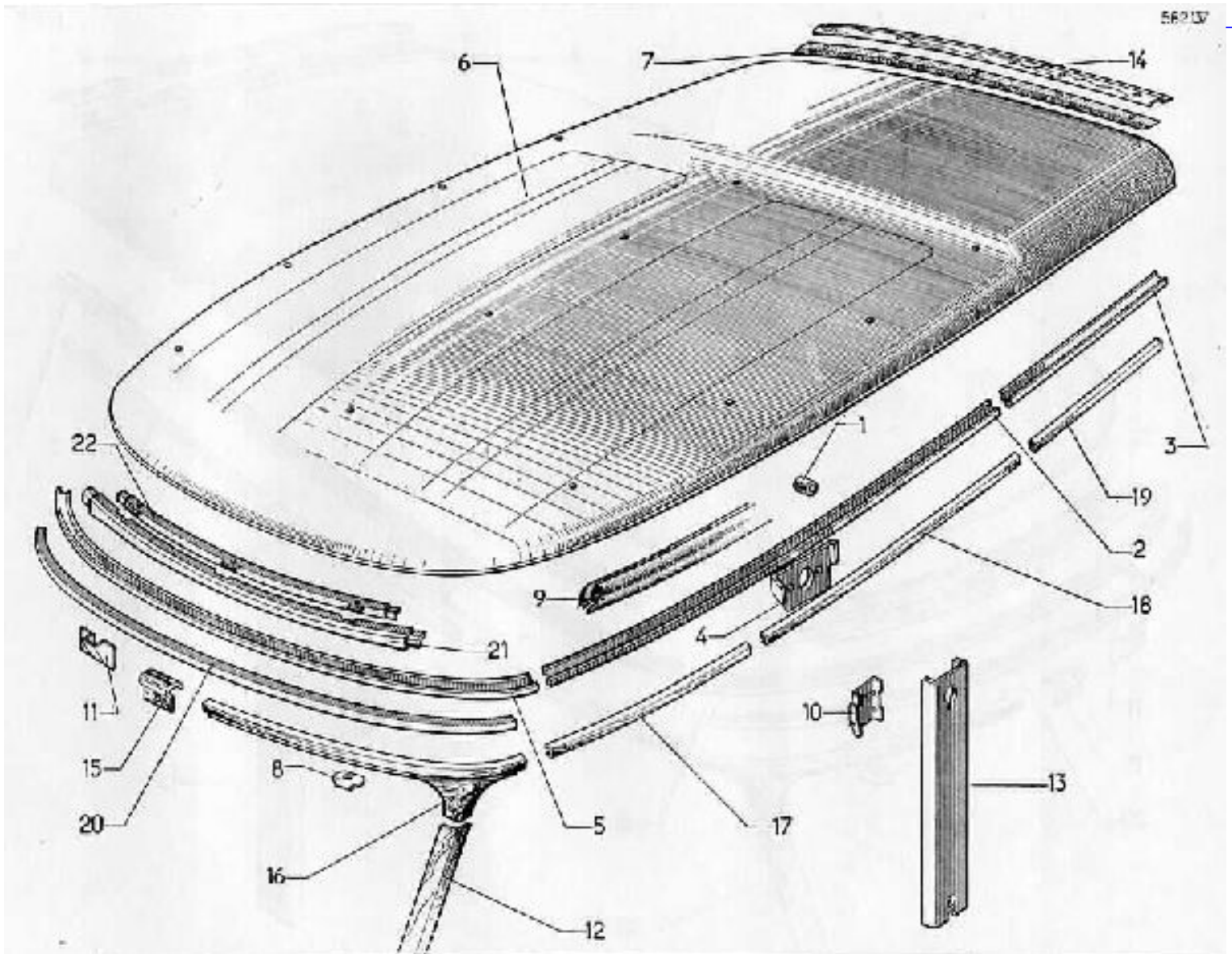
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*Yes it's crude, but it works!*

**Models: DLF, DYF, DJF, DXF**



I	NUMÉROS	K	DLF - DYF - DJF - DXF	Pavillon	Wagendach	Roof
1	D 521-96	1	8 × 22 × 20.	Bague sur brancard.	Hülse a. Wagendach.	Rubber bush.
2	DVF 811-3	1	G.	Brancard latéral.	Seitl. Unterzug.	Siderail.
	DVF 811-4	1	D → 3/67.	Brancard latéral.	Seitl. Unterzug.	Siderail.
	DF 811-67 —	1	D → 3/67.	Brancard latéral.	Seitl. Unterzug.	Siderail.
3				Rallonge de brancard.	Verläng. f. Unterzug.	Extension for siderail.
	DF 811-75 —	1	G → 3/67.	Rallonge de brancard.	Verläng. f. Unterzug.	Extension for siderail.
	DVF 811-75	1	G → 3/67.	Rallonge de brancard.	Verläng. f. Unterzug.	Extension for siderail.
	DF 811-86 A —	1	D → 3/67.	Rallonge de brancard.	Verläng. f. Unterzug.	Extension for siderail.
	DVF 811-86	1	D → 3/67.	Rallonge de brancard.	Verläng. f. Unterzug.	Extension for siderail.
4	DX 811-87	12	→ 3/68.	Plaquette entretoise.	Zwischenblech.	Distance plate.
	DX 811-87 C	12	→ 3/68.	Plaquette entretoise.	Zwischenblech.	Distance plate.
5	DX 811-91	1	AV.	Brancard.	Dachunterzug.	Siderail.
6	DF 825-3	1		Pavillon avec bordure, non peint.	Dach m. Leiste, nicht gestr.	Roof with rim, unpainted.
7	DF 825-67	1	L 1.200.	Caoutchouc AR.	Hint. Dichtgummi.	Rubber strip.
8	DS 825-75	2		Patte de fixat. sur pied AV.	Lasche a. vord. Pfosten.	Clip on front pillar.
9	DF 825-91	1	L 5.600.	Caoutchouc.	Dichtungsgummi.	Rubber strip.
10	DM 854-71	1	D int.	Applique de pied milieu.	Abschlussbl. f. Mittelpfosten.	Finishing trim.
	DM 854-100	1	G int.	Applique de pied milieu.	Abschlussbl. f. Mittelpfosten.	Finishing trim.
11	DS 854-73	1		Patte de couvre-joint.	Lasche f. Nahtabdeckung.	Plate for cover joint.
12	DM 854-82	1	G sup.	Applique de pied AV.	Abschlussblech f. vord. Pfosten.	Finishing trim.
	DM 854-82 A	1	D sup.	Applique de pied AV.	Abschlussblech f. vord. Pfosten.	Finishing trim.
13	DM 854-83	1	G.	Applique de pied milieu.	Abschlussblech f. Mittelpfosten.	Finishing trim.
	DM 854-83 A	1	D.	Applique de pied milieu.	Abschlussblech f. Mittelpfosten.	Finishing trim.
14	DF 854-85	1	AR.	Applique.	Abschlussblech.	Finishing strip.
15	DM 854-91	1	AV.	Couvre-joint.	Nahtabdeckung.	Cover joint.
16	DM 854-93	1	G AV.	Bordure.	Leiste.	Edge finisher.
	DM 854-93 A	1	D AV.	Bordure.	Leiste.	Edge finisher.
17	DF 854-103	2	AV L 510.	Bordure latérale.	Seitl. Leiste.	Edge finisher.

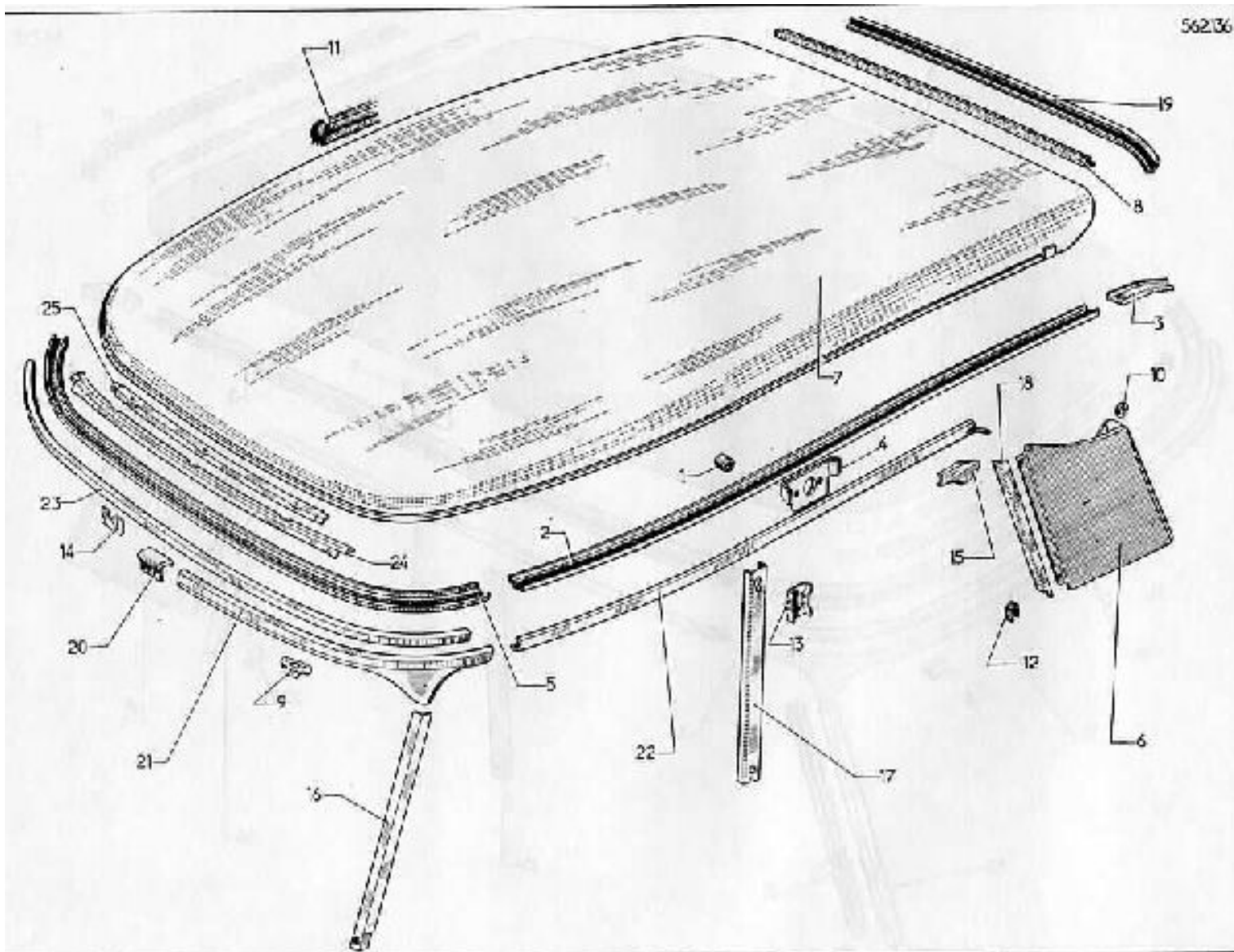
I	NUMÉROS	K	DLF - DYF - DJF - DXF	Pavillon (Suite)	Wagendach (Forts.)	Roof (Cont.)
18	DF 854-104 B	1	G - L 870.	Bordure latérale milieu.	Seitl. u. mittl. Leiste.	Edge finisher.
	DF 854-104 C	1	D - L 870.	Bordure latérale milieu.	Seitl. u. mittl. Leiste.	Edge finisher.
19	DF 854-105 B	1	AR G - L 440.	Bordure latérale.	Seitl. Leiste.	Edge finisher.
	DF 854-105 C	1	AR D - L 440.	Bordure latérale.	Seitl. Leiste.	Edge finisher.
20	D 961-53	1	sup.	Encadrement (tôle).	Rahmenblech.	Surround (metal).
21	D 961-115	1	ext.	Renfort central.	Mittl. Verstärkung.	Reinforcement.
22	D 961-147	1	int.	Renfort central.	Mittl. Verstärkung.	Reinforcement.
				<b>Fixation</b>	<b>Befestigung</b>	<b>Securing parts</b>
	D 825-90	19	7,5 × 20.	Rondelle de pavillon.	Scheibe f. Dach.	Washer for roof.
	D 825-92 A	5	TR 7 × 25.	Vis avec méplat, de fixat. de pavillon.	Schraube m. Abfas. f. Dach.	Screw with flats.
	487-S-30 —	14	TH 7 × 25.	Vis de pavillon.	Schraube f. Dach.	Screw for roof.
	2.482-S	17	7,5 × 14.	Rondelle de pavillon.	Scheibe f. Dach.	Washer for roof.
	2.489-S —	17	H 7 × 100.	Écrou de pavillon.	Mutter f. Dach.	Nut for roof.
	2.499-S ㄣ	6	TFB 3,52 × 9,5.	Vis d'applique sur pied milieu.	Schraube f. Blech a. Mittelposten.	Screw for finishing trim on centre pillar.
	2.514-S	17	Cr 7,3 × 12.	Rondelle de pavillon.	Scheibe f. Wagendach.	Washer for roof.
	2.762-S	17	7,5 × 20 × 2.	Rondelle de pavillon.	Scheibe f. Wagendach.	Washer for roof.

# Citroën ID/DS Roof Parts

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DV-DT





I	NUMÉROS	K	DV - DT	Pavillon	Wagendach	Roof
1	D 521-96	1	G 8 × 22 × 20.	Bague sur brancard.	Hülse am Dachunterzug.	Rubber bush.
2	DX 811-3	1	G.	Brancard latéral.	Seitl. Dachunterzug.	Siderail.
	DX 811-4	1	D.	Brancard latéral.	Seitl. Dachunterzug.	Siderail.
3	D 811-75	1	G.	Rallonge de brancard.	Verläng. f. Dachunterzug.	Extension for siderail.
	D 811-75 A	1	D.	Rallonge de brancard.	Verläng. f. Dachunterzug.	Extension for siderail.
4	DX 811-87	12	→ 3/67.	Plaquette entretoise.	Zwischenblech.	Distance plate.
	DX 811-87 C	12	→ 3/67.	Plaquette entretoise.	Zwischenblech.	Distance plate.
5	DX 811-91	1	AV.	Brancard.	Dachunterzug.	Siderail.
6	DS 821-9 F	1	G.	Panneau de custode :	Schalblech :	Quarter panel:
	DS 821-9 G	1	D.	- striures : l. 6	- Rippen 6 breit.	- corrugation: l. 6
	DM 821-104 F	1	G.	- striures : l. 6	- Rippen 6 breit.	- corrugation: l. 6
	DM 821-104 G	1	D.	- striures : l. 13	- Rippen 3 breit.	- corrugation: l. 3
		1	D.	- striures : l. 13	- Rippen 3 breit.	- corrugation: l. 3
7	DV 825-04 P	1		Pavillon avec garniture, non peint.	Wagendach m. Garnitur, nicht gestr.	Roof with trimming, unpainted.
8	DS 825-67	1	AR. L 1,180.	Caoutchouc.	Dichtungsgummi.	Rubber strip.
9	DS 825-75	2		Patte de fixat. sur pied AV.	Lasche z. Befest. a. vord. Pfosten.	Clip on front pillar.
10	D 825-90	17	7,5 × 20.	Rondelle avec méplat.	Scheibe m. Abfasung.	Washer with flats.
11	DS 825-91	1	L 4,100.	Caoutchouc.	Dichtungsgummi.	Rubber strip.
12	DS 842-17 B	1	G 1 9.	Butée entre custode et pied AR.	Anschlag zw. Schalbl. u. Pfosten.	Rubber buffer.
	DS 842-17 C	1	D 1 9.	Butée entre custode et pied AR.	Anschlag zw. Schalbl. u. Pfosten.	Rubber buffer.
13	DM 854-71	1	D int.	Applique de pied milieu.	Abschlussblech a. Mittelpfosten.	Finishing plate.
	DM 854-100	1	G int.	Applique de pied milieu.	Abschlussblech a. Mittelpfosten.	Finishing plate.
14	DS 854-73	1		Patte de couvre-joint.	Lasche f. Nahtabdeckung.	Plate for cover joint.
15	DM 854-75 B	1	sup. D.	Applique AR.	Abdeckblech, hinten.	Finishing trim.
	DM 854-76 B	1	sup. G.	Applique AR.	Abdeckblech, hinten.	Finishing trim.
16	DM 854-82	1	G - L 415.	Applique sup. de pied AV. :	Ob. Abschlussbl. f. vord. Pfosten.	Finishing trim.
	DM 854-82 A	1	D - L 415.	- sup. de pied AV.	Ob. Abschlussbl. f. vord. Pfosten.	Finishing trim.
	DS 854-82	1	G - U.S.A.	- sup. de pied AV.	Ob. Abschlussbl. f. vord. Pfosten.	Finishing trim.
	DS 854-82 A	1	D - U.S.A.	- sup. de pied AV.	Ob. Abschlussbl. f. vord. Pfosten.	Finishing trim.



I	NUMÉROS	K	DV - DT	Pavillon (Suite)	Wagendach (Forts.)	Roof (Cont.)
17	DM 854-83 F DM 854-83 G DS 854-83 DS 854-83 A	1 1 1 1	G. D. G - U.S.A. D - U.S.A.	Applique de pied milieu : - striures : 1,3. - striures : 1,3. - striures : 1,6. - striures : 1,6.	Abschlussbl. f. mittl. Pfosten. Abschlussbl., Rippen 3 breit. Abschlussbl., Rippen 3 breit. Abschlussbl., Rippen 6 breit. Abschlussbl., Rippen 6 breit.	Finishing trim. Finishing trim corrugation: 1 3. Finishing trim corrugation: 1 3. Finishing trim corrugation: 1 6. Finishing trim corrugation: 1 6.
18	DS 854-84 D DS 854-84 E	1 1	G - U.S.A. D - U.S.A.	Applique sup. de pied AR. Applique sup. de pied AR.	Ob. Abschlussbl. f. hint. Pfosten. Ob. Abschlussbl. f. hint. Pfosten.	Finishing trim. Finishing trim.
19	DM 854-85 DS 854-85 B	1 1	AR. AR - U.S.A.	Bordure de finition AR. Bordure de finition AR.	Abschlussleiste, hinten. Abschlussleiste, hinten.	Edge finisher. Edge finisher.
20	DM 854-91 DS 854-91 A	1 1	AV. AV - U.S.A.	Couvre-joint de bordure. Couvre-joint de bordure.	Nahtabdeckung f. Abschlussleiste. Nahtabdeckung f. Abschlussleiste.	Cover joint. Cover joint.
21	DM 854-93 DM 854-93 A DS 854-93 B DS 854-93 C	1 1 1 1	G. D. G - U.S.A. D - U.S.A.	Bordure AV. Bordure AV. Bordure AV. Bordure AV. Bordure AV.	Abschlussleiste, vorn. Abschlussleiste, vorn. Abschlussleiste, vorn. Abschlussleiste, vorn. Abschlussleiste, vorn.	Edge finisher, front. Edge finisher, front. Edge finisher, front. Edge finisher, front. Edge finisher, front.
22	DM 854-94 B DM 854-94 C DS 854-94 B DS 854-94 C	1 1 1 1	G. D. G - U.S.A. D - U.S.A.	Bordure latérale. Bordure latérale. Bordure latérale. Bordure latérale. Bordure latérale.	Abschlussleiste, seitlich. Abschlussleiste, seitlich. Abschlussleiste, seitlich. Abschlussleiste, seitlich. Abschlussleiste, seitlich.	Edge finisher, lateral. Edge finisher, lateral. Edge finisher, lateral. Edge finisher, lateral. Edge finisher, lateral.
23	D 961-53	1	sup.	Encadrement (tôle).	Blechrahmen.	Surround (metal).
24	D 961-115	1	ext.	Renfort central.	Mittl. Verstärkung.	Reinforcement.
25	D 961-147	1	int.	Renfort central.	Mittl. Verstärkung.	Reinforcement.
				<b>Fixation</b>	<b>Befestigung</b>	<b>Securing parts</b>
	D 825-92 A 487-S-30 — 490-S — 2.251-S	3 12 2 2	TR 7 × 25 TH 7 × 25. TH 7 × 32. TR 5 × 20.	Vis : - de pavillon. - de pavillon. - de pavillon. - de panneau de custode.	Schraube : - f. Wagendach. - f. Wagendach. - f. Wagendach. - f. Schalblech.	Screw: - for roof. - for roof. - for roof. - for quarter panel.

I	NUMÉROS	K	DV - DT	Pavillon (Suite)	Wagendach (Forts.)	Roof (Cont.)
	2.482-S	5	7,5 × 14.	Rondelle de pavillon.	Scheibe f. Wagendach.	Washer for roof.
	2.491-S —	3	H 7 × 100.	Écrou de pavillon.	Mutter f. Wagendach.	Nut
	2.493-S —	20	H 7 × 100.	Écrou de pavillon.	Mutter f. Wagendach.	Nut
	2.499-S ≧	10	TFB 3,5 × 9,5.	Vis d'applique sur pied milieu.	Schraube f. Blech a. Mittelpfosten.	Screw for finishing trim on centre pillar.
	2.514-S	5	Cr 7,3 × 12.	Rondelle de pavillon.	Scheibe f. Wagendach.	Washer for roof.
	2.762-S	15	7,5 × 20 × 2.	Rondelle de pavillon.	Scheibe f. Wagendach.	Washer for roof.
	39.827 W	?	5 × 20 × 2.	Rondelle de panneau de custode.	Scheibe f. Wagendach.	Washer for quarter panel.
	2.756-S ≧	2	TR 3,5 × 9,5.	Vis de panneau de custode.	Schraube f. Schalblech.	Screw for quarter panel.
	619-754	7		Agrafe de bordure de finition AR.	Klammer f. hintere Leiste.	Clip for edge finisher.
	619.869	6		Agrafe de fixat. de câblerie.	Klammer f. Befest. Kabelbündel.	Clip securing wiring.

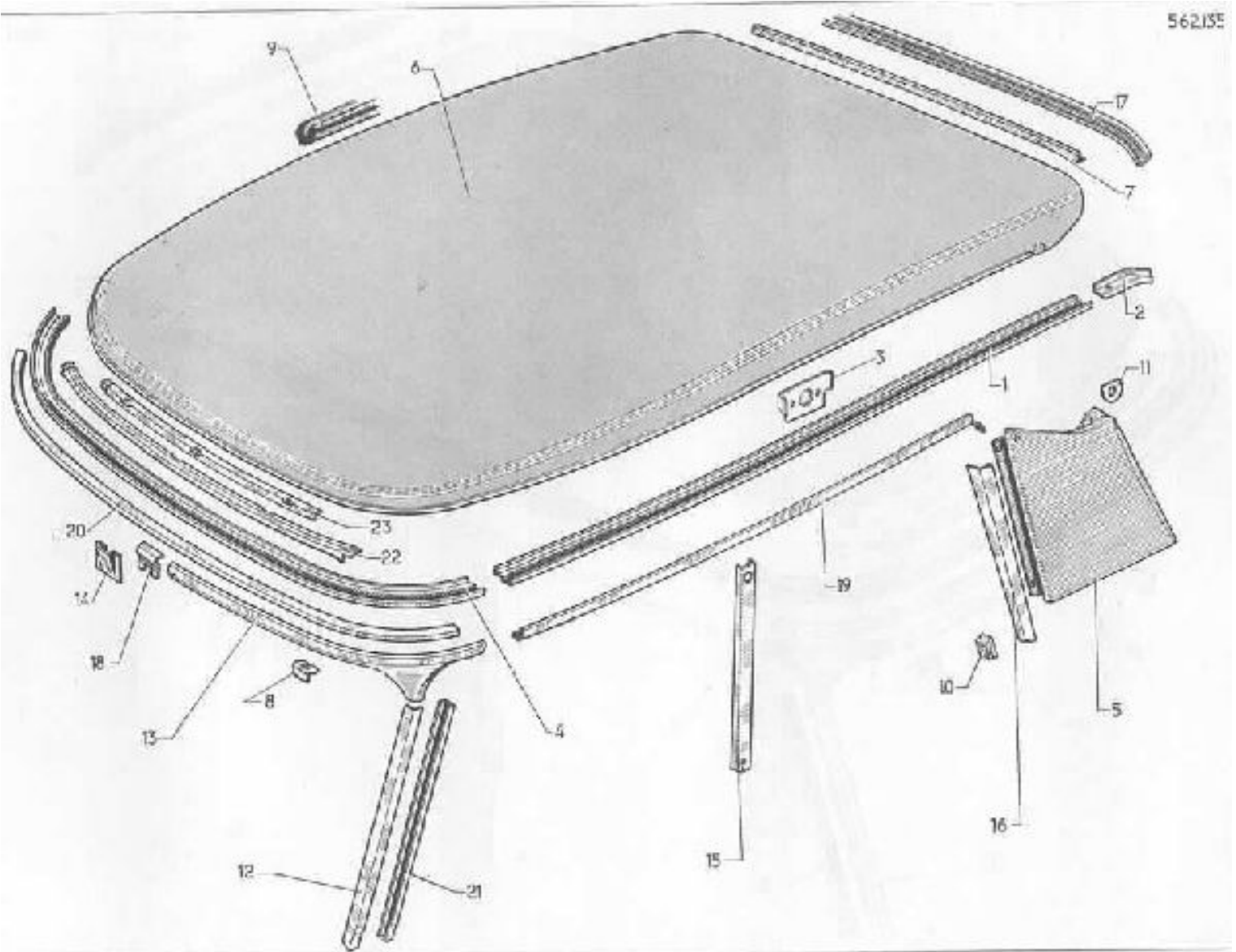
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**DX-DJ-DY-DL**



I	NUMÉROS	K	DX - DJ - DY - DL	Pavillon	Wagendach	Roof
1	DX 811-3 DX 811-4	1 1	G. D.	Brancard latéral. Brancard latéral.	Seitl. Dachunterzug. Seitl. Dachunterzug.	Siderail. Siderail.
2	D 811-75 D 811-75 A	1 1	G. G.	Rallonge de brancard AR. Rallonge de brancard AR.	Verläng. f. Dachunterzug. Verläng. f. Dachunterzug.	Extension for siderail. Extension for siderail.
3	DX 811-87 DX 811-87 A	12 12	→ 3/67. → 3/67.	Plaquette entretoise. Plaquette entretoise.	Dachunterzug. Dachunterzug.	Distance plate. Distance plate.
4	DX 811-91	1	AV.	Brancard.	Dachunterzug.	Siderail.
5	DS 821-9 F DS 821-9 G DM 821-104 B DM 821-104 C	1 1 1 1	G. D. G Prestige. D prestige.	Panneau de custode : - strié. - strié. - lisse. - lisse.	Schalblech : - geriffelt. - geriffelt. - glatt. - glatt.	Quarter panel: - corrugated. - corrugated. - smooth. - smooth.
6	D 825-3 B	1	d.e.o : 1 D 825-91 A.	Pavillon (alu) non peint remplace pavillon plastique.	Wagendach (Alu), nicht gestr. ersetzt Plastik-Dach.	Roof (aluminium) unpainted superseding roof (plastic).
7	DS 825-67	1	L 1,670.	Caoutchouc AR.	Hint. Dichtgummi.	Rubber strip.
8	DS 825-75	2		Patte de fixat. sur pied AV.	Lasche z. Befest. a. vord. Pfosten.	Clip on front pillar.
9	D 825-91 A DS 825-91	1 1	L 4,100. L 4,360.	Caoutchouc de pavillon (alu). Caoutchouc de pavillon (plastique).	Dichtgummi f. Dach (Alu). Dichtgummi f. Dach (Plastik).	Rubber for roof (aluminium). Rubber for roof (plastic).
10	DS 842-17 B DS 842-17 C	1 1	G 1 9. D 1 9.	Butée entre custode et pied AR. Butée entre custode et pied AR.	Anschlag zw. Schalblech u. hint. Pfosten Anschlag zw. Schalblech u. hint. Pfosten.	Rubber buffer. Rubber buffer.
11	D 851-58	4	5,5 × 28 × 2.	Rondelle.	Scheibe.	Washer.
12	DS 854-46 DS 854-46 A DS 854-82 DS 854-82 A	1 1 1 1	G sup. CAB. D sup. CAB. G. D.	Applique de pied AV. Applique de pied AV. Applique de pied AV. Applique de pied AV.	Abschlussblech a. vord. Pfosten. Abschlussblech a. vord. Pfosten. Abschlussblech a. vord. Pfosten. Abschlussblech a. vord. Pfosten.	Finishing trim. Finishing trim. Finishing trim. Finishing trim.
13	DS 854-47 DS 854-47 A DS 854-93 B DS 854-93 C	1 1 1 1	G sup. CAB. D sup. CAB. G. D.	Applique de pare-brise. Applique de pare-brise. Bordure AV. Bordure AV.	Abschlussblech an Windsch. - Scheibe. Abschlussblech an Windsch. - Scheibe. Leiste, vorn. Leiste, vorn.	Finishing trim. Finishing trim. Edge finisher. Edge finisher.
14	DS 854-73	1		Patte de couvre-joint.	Lasche f. Nahtabdeckung.	Plate for cover joint.

I	NUMÉROS	K	DX - DJ - DY - DL	Pavillon (Suite)	Wagendach (Forts.)	Roof (Cont.)
15	DM 854-83 DM 854-83 A DS 854-83 DS 854-83 A	1 1 1 1	G prestige. D prestige. G. D.	Applique de pied milieu. - (lisse). - (lisse). - (striée). - (striée).	Abschlussblech f. Mittelpfosten. - (glatt). - (glatt). - (geriffelt). - (geriffelt).	Finishing trim. - smooth. - smooth. - corrugated. - corrugated.
16	DS 854-84 D DS 854-84 E	1 1	G sup. D sup.	Applique de pied AR. Applique de pied AR.	Abschlussblech f. hint. Pfosten. Abschlussblech f. hint. Pfosten.	Finishing trim. Finishing trim.
17	DS 854-85 B	1	L 1,140.	Bordure AR.	Hintere Leiste.	Edge finisher.
18	DS 854-91 A	1	AV.	Couvre-joint de finition.	Nahtabdeckung.	Cover joint.
19	DS 854-94 B DS 854-94 C	1 1	G. D.	Bordure latérale. Bordure latérale.	Seitl. Leiste. Seitl. Leiste.	Edge finisher. Edge finisher.
20	D 961-53	1	Sup.	Encadrement (tôle).	Blechumrahmung.	Surround (metal).
21	D 961-75 D 961-75 A	1 1	G. D.	Encadrement (tôle) latéral. Encadrement (tôle) latéral.	Blechumrahmung, seitlich. Blechumrahmung, seitlich.	Surround (metal). Surround (metal).
22	D 961-115	1	ext.	Renfort d'encadrement central.	Verstärk. f. Rahmen.	Reinforcement.
23	D 961-147	1	int.	Renfort d'encadrement central.	Verstärk. f. Rahmen.	Reinforcement.
				<b>Fixation</b>	<b>Befestigung</b>	<b>Securing parts</b>
	D 825-92 A 487-S-30 — 490-S — 2.482-S 2.489-S — 2.490-S — 2.499-S $\approx$ 4 2.762-S 2.548-S-30 $\surd$	3 12 2 5 2 3 4 4 15 2	TR 7 $\times$ 25. TH 7 $\times$ 25. TH 7 $\times$ 32. 7,5 $\times$ 14. H 7 $\times$ 100. H 7 $\times$ 100. TFB 3,52 $\times$ 9,5. TFB 3,52 $\times$ 9,5. 7,5 $\times$ 20 $\times$ 2. TR 5 $\times$ 16,5.	Vis de pavillon. Vis de pavillon. Vis de pavillon. Rondelle de pavillon. Écrou de pavillon. Écrou de pavillon. Vis de panneau de custode. Vis d'applique AV et milieu. Rondelle de pavillon. Vis de panneau de custode.	Schraube f. Dach. Schraube f. Dach. Schraube f. Dach. Scheibe f. Dach. Mutter f. Dach. Mutter f. Dach. Schraube f. Schalblech. Schraube f. vord. u. mittl. Abschlussblech. Scheibe f. Wagendach. Schraube f. Schalblech.	Screw for roof. Screw for roof. Screw for roof. Washer for roof. Nut for roof. Nut for roof. Screw for quarter panel. Screw for finishing trim. Washer for roof. Screw for quarter panel.

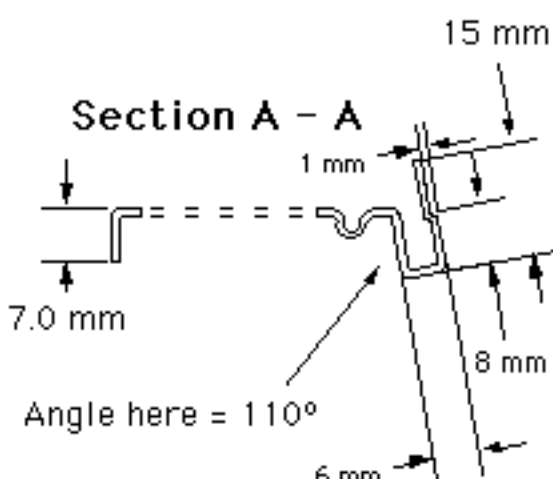
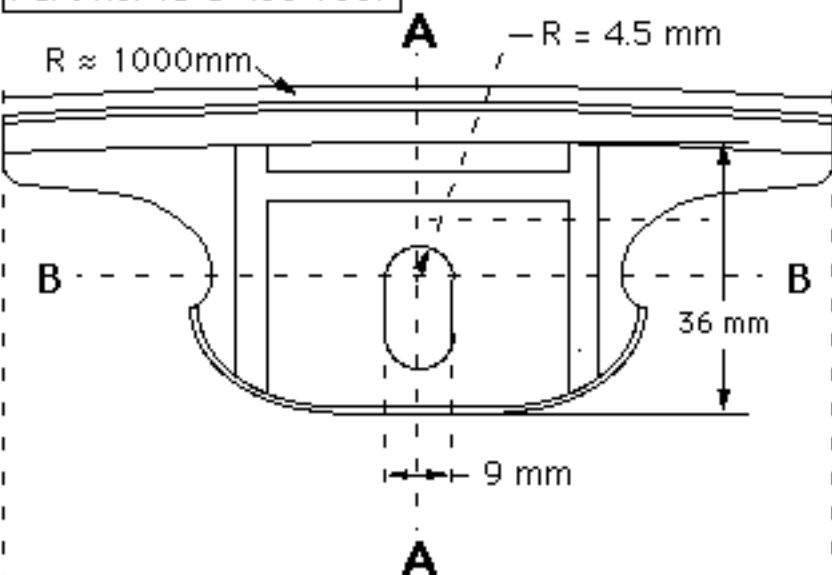


I	NUMÉROS	K	DX - DJ - DY - DL	Pavillon (Suite)	Wagendach (Forts.)	Roof (Cont.)
	39.827 W	?	5 × 20 × 2.	Rondelle de panneau de custode.	Scheibe f. Schalblech.	Washer for quarter panel.
	619.754	7		Agrafe de bordure de finition AR de pavillon (plastique).	Klammer f. hint. Leiste am Dach (Plastik).	Clip for rear edge finisher for roof (plastic).
	619.785	7		Agrafe de bordure de finition AR de pavillon (alu).	Klammer f. hint. Leiste am Dach (Alu).	Clip for rear edge finisher for roof (aluminium).
	619.869	6		Agrafe de fixation de câblerie	Klammer z. Befest. d. Kabelbündels.	Clip securing wiring.

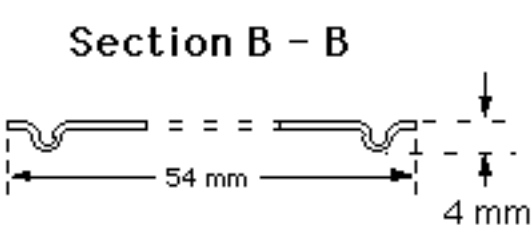
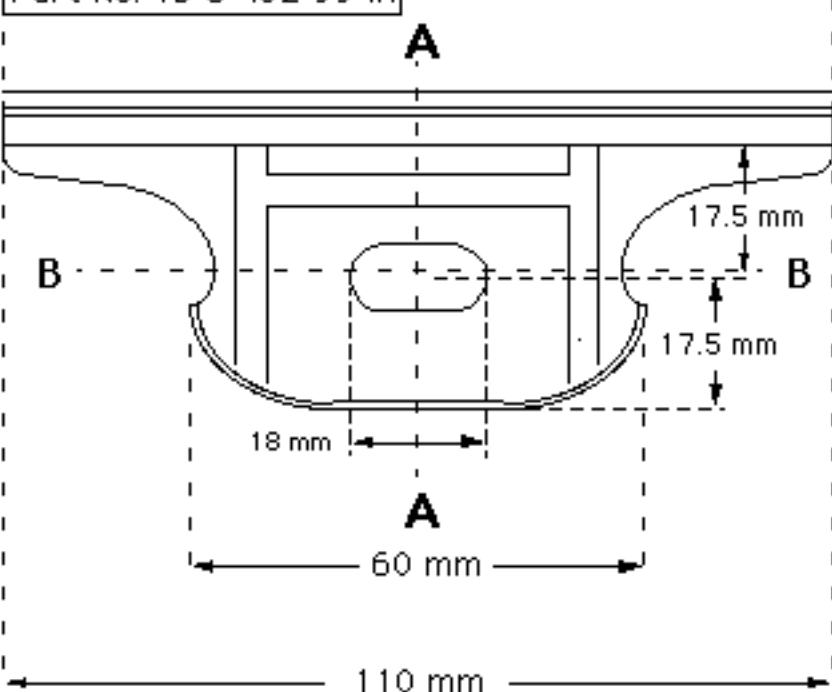
# Roof Clips for Citroën DS

(You will need two front, and ten side clips to convert a bonded roof to bolted, in addition to the five clips already fitted)  
The clips are identical, except for the orientation of the central fixing hole and the radius on the slot into which the roof fits

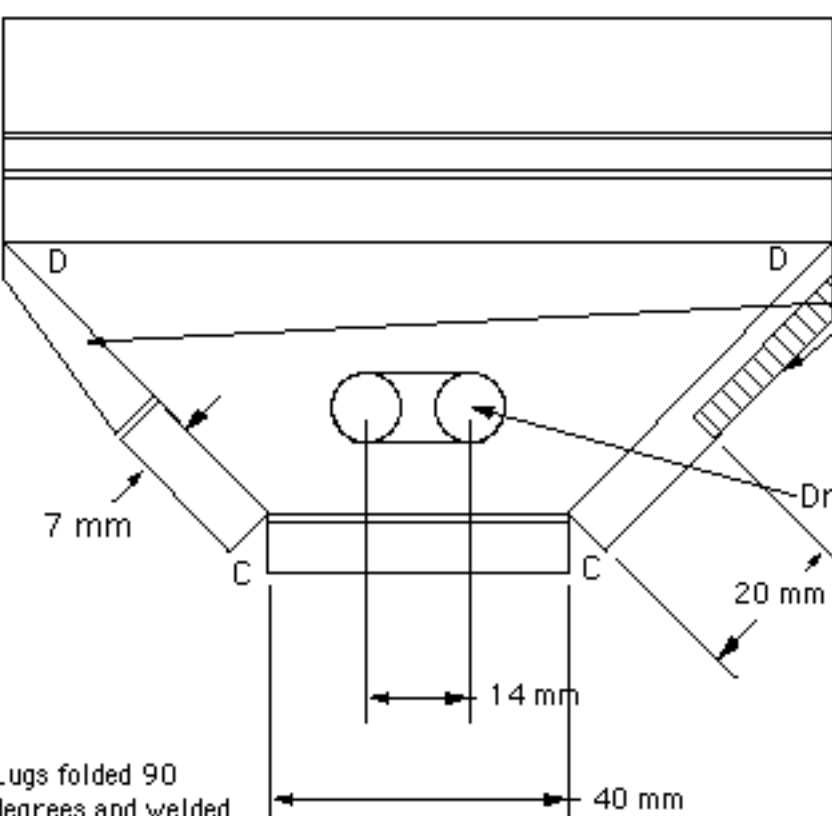
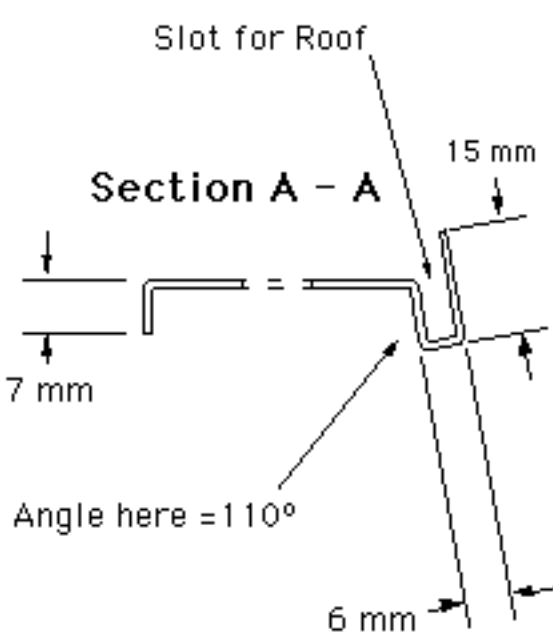
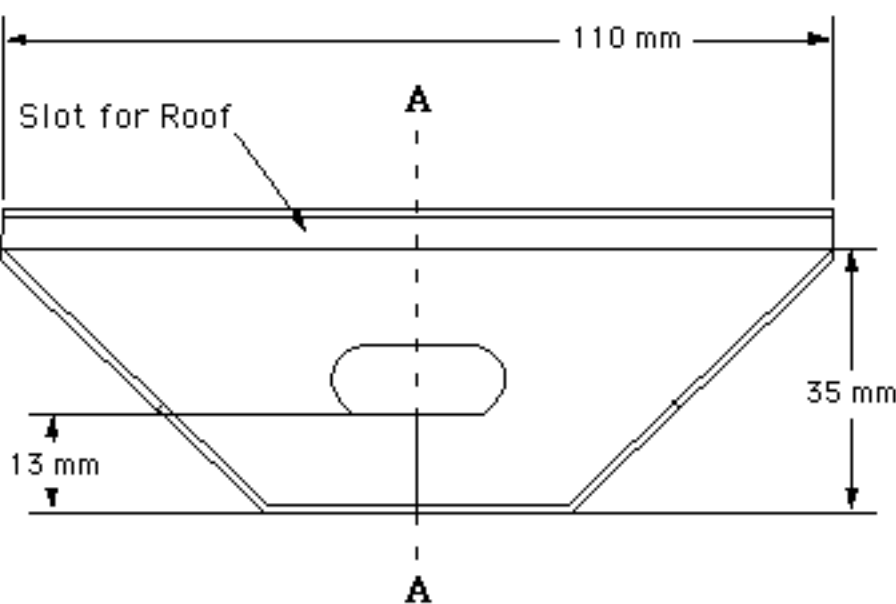
**Front Clip**  
Part No. 1D 5 433 739F



**Side Clip**  
Part No. 1D 5 432 994H



**Material: 1mm steel sheet, Cadmium plated**



These lugs folded through 90°, hatched area ground away, then welded at C and D.

Drill two 9mm holes and file out slot

Lugs folded 90 degrees and welded together at C

**Material: 1mm steel sheet, Galvanised**

## Folding process:

I started by folding the slot for the roof. Do the first fold in the vice, then move the work up and start the second fold using a drift made from a piece of 5mm plate. Then hold the work together with a piece of plate in the vice and finish the second fold. You probably won't have a piece of 4mm plate; use 5mm and chamfer its edge so the edge is 4mm. Adjust the width of the channel by squeezing it in the vice with a 3mm spacer in the slot. (the 3mm spacer made by folding up some 1mm scrap). With the scrap still in the slot, set the work back in the vice with the folded part uppermost and make the next fold.

At this point mark the folding lines for the lugs and cut them out. Find a suitable piece of thick scrap with an angle to it and clamp the work to it to fold the first two lugs on one angled side. The remaining lugs will either require suitable pieces of scrap to hold the work in the vice, or need to be folded with pliers. Complete the 180° fold of the top lugs in the picture by tapping them over with a hammer.

Weld where indicated. Drill holes where indicated and file out to form slot (high speed rotary file helpful here). Grind lugs to 7mm and check angle on roof; then weld at E, so that folded over lugs stabilise slot angle.