

Body Repairs Karoq 2018 ➤ Edition 10.2017

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Repair Group overview for Body Repairs

Repair Group

00 - Technical data

50 - Body - front

51 - Body - centre

53 - Body - rear

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Technical information should always be available to the foremen and mechanics, because their careful and constant adherence to the instructions is essential to ensure vehicle road-worthiness and safety. In addition, the normal basic safety precautions for working on motor vehicles must, as a matter of course, be observed.

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Contents

00	Technical data	1
1	Basic instructions	1
1.1	Basic instructions	1
2	Vehicle identification data	2
2.1	Vehicle identification number	2
3	Safety measures	3
3.1	Safety measures	3
4	Foam moulds	4
4.1	Position of the moulded foam parts	4
4.2	Replace the moulded foam part	4
5	Vibration damping	5
5.1	Damping	5
6	Galvanised body parts, high/ultra high-strength and hot-formed body panels	6
6.1	Body	6
7	Laser welding	7
7.1	Laser welding	7
8	Gap sizes	8
8.1	Front body	8
8.2	Middle body	9
8.3	Rear body	10
9	Vehicle body dimensions	12
9.1	Front body	12
9.2	Middle body	13
9.3	Rear body	15
9.4	Body platform at the front	17
9.5	Body platform in the middle	18
9.6	Body platform at the rear	19
10	Tools	21
10.1	List of tools	21
11	Straightening square set	22
11.1	Straightening square set	22
12	Portal gauge	23
12.1	Portal gauge	23
50	Body - front	24
1	Replace engine mount	24
1.1	Removing	24
1.2	Preparing the new part	25
1.3	Part welding	26
2	Replacing support block for assembly carrier	28
2.1	Summary of components	28
2.2	Removing	29
2.3	Preparing the new part	30
2.4	Part welding	31
3	Replacing the front bumper holder	33
3.1	Summary of components	33
3.2	Removing	34
3.3	Part welding	35
4	Replacing the outer top frame side rail -part-	37
4.1	Removing	37



4.2	Preparing the new part	38
4.3	Part welding	39
5	Replacing the inner top frame side rail	41
5.1	Removing	41
5.2	Preparing the new part	42
5.3	Part welding	43
6	Replacing the front wheelhouse	45
6.1	Summary of components	45
6.2	Removing	46
6.3	Preparing the new part	47
6.4	Part welding	49
7	Replacing the front wheelhouse -part-	51
7.1	Summary of components	51
7.2	Removing	52
7.3	Preparing the new part	52
7.4	Part welding	53
8	Replacing front frame side rail -part-	55
8.1	Removing	55
8.2	Preparing the new part	56
8.3	Part welding	57
9	Replacing front frame side rail -part-	59
9.1	Summary of components	59
9.2	Removing	60
9.3	Preparing the new part	61
9.4	Part welding	62
51 - Body - centre		64
1	Replacing the roof	64
1.1	Tools	64
1.2	Removing	64
1.3	Preparing the new part	66
1.4	Setting roof countersinking	68
1.5	Gluing in the roof	69
1.6	Part welding	81
2	Replacing the roof rail	82
2.1	Removing	82
2.2	Preparing the new part	83
2.3	Part welding	84
3	Replacing outer A pillar -cutoff part-	87
3.1	Removing	87
3.2	Preparing the new part	88
3.3	Moulded foam parts	90
3.4	Part welding	90
4	Replace front mudguard bracket	92
4.1	Removing	92
4.2	Preparing the new part	93
4.3	Part welding	93
5	Replacing reinforcement of A-pillar - part-	95
5.1	Removing	95
5.2	Preparing the new part	96
5.3	Moulded foam parts	97
5.4	Part welding	98
6	Replacing outer B-pillar -cutoff part-	99
6.1	Removing	99

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6.2	Preparing the new part	100
6.3	Moulded foam parts	101
6.4	Part welding	101
7	Replacing reinforcement of B pillar	103
7.1	Removing	103
7.2	Preparing the new part	104
7.3	Moulded foam parts	106
7.4	Part welding	107
8	Replacing the outside bottom side rail -cutoff part-	108
8.1	Removing	108
8.2	Preparing the new part	109
8.3	Moulded foam parts	110
8.4	Part welding	111
9	Replace the bottom side rail reinforcement	112
9.1	Removing	112
9.2	Preparing the new part	113
9.3	Part welding	114
53 - Body - rear		115
1	Replacing outer rear side part -cutoff part-	115
1.1	Removing	115
1.2	Preparing the new part	117
1.3	Moulded foam parts	118
1.4	Part welding	118
2	Replacing the outer wheelhouse -part-	121
2.1	Removing	121
2.2	Part welding	122
3	Replacing the support of the tail light	123
3.1	Removing	123
3.2	Preparing the new part	124
3.3	Part welding	124
4	Replacing sealing channel -part-	127
4.1	Removing	127
4.2	Preparing the new part	128
4.3	Part welding	129
5	Replacing the end cover cross member	130
5.1	Removing	130
5.2	Preparing the new part	131
5.3	Part welding	132
6	Replacing the end cover plate	134
6.1	Removing	134
6.2	Preparing the new part	135
6.3	Part welding	137
7	Replace luggage compartment, four-wheel drive	139
7.1	Removing	139
7.2	Preparing the new part	140
7.3	Moulded foam parts	142
7.4	Part welding	142
8	Replacing the end cover plate	145
8.1	Removing	145
8.2	Part welding	146
9	Replacing rear frame side rail -part-	147
9.1	Removing	147
9.2	Preparing the new part	149



9.3 Part welding 150

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00 – Technical data

1 Basic instructions

(SKI000047; Edition 10.2017)

⇒ [“1.1 Basic instructions”, page 1](#)

1.1 Basic instructions



Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs

Only selected work steps are described in this Workshop Manual.

For the steps not described, undo the original welding and replace it with a repair part.

The repairs are described with repair procedures which vary from the series design.

If cut-to-size parts are delivered, unless described otherwise, these will need to be adjusted and butt welded, GS continuous seam (inert gas shielded).

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2 Vehicle identification data

⇒ "2.1 Vehicle identification number", page 2

2.1 Vehicle identification number

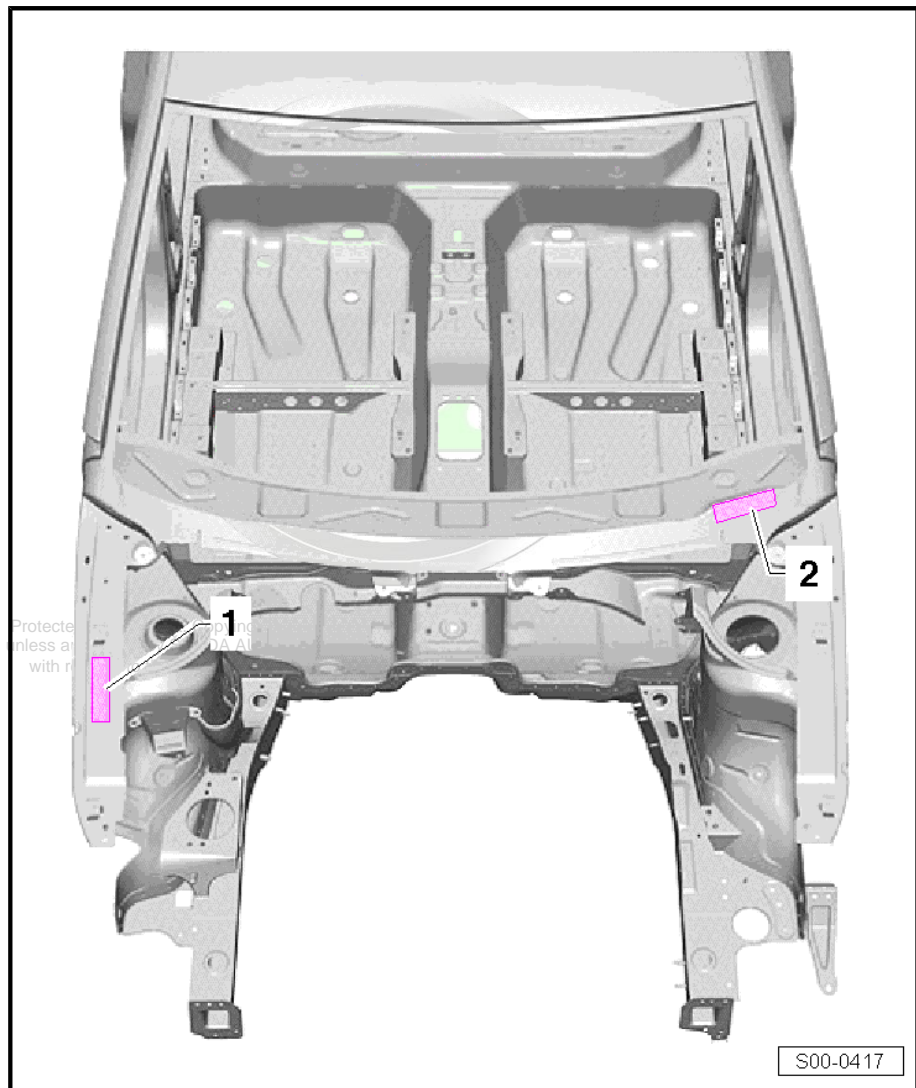


Note

If a corresponding body part with vehicle identification number must be replaced in case of damage, the repair must be documented according to the market-specific, legal regulations.

1 - Vehicle identification number at the top right frame side rail

2 - Vehicle identification number on the bottom left wind-screen frame





3 Safety measures

⇒ "3.1 Safety measures", page 3

3.1 Safety measures



Caution

Observe the safety instructions in the binder general notes, body repair and body work before commencing any cutting, straightening and body panelling work. ⇒ General Information; Body Repairs, General Body Repairs ; Safety measures

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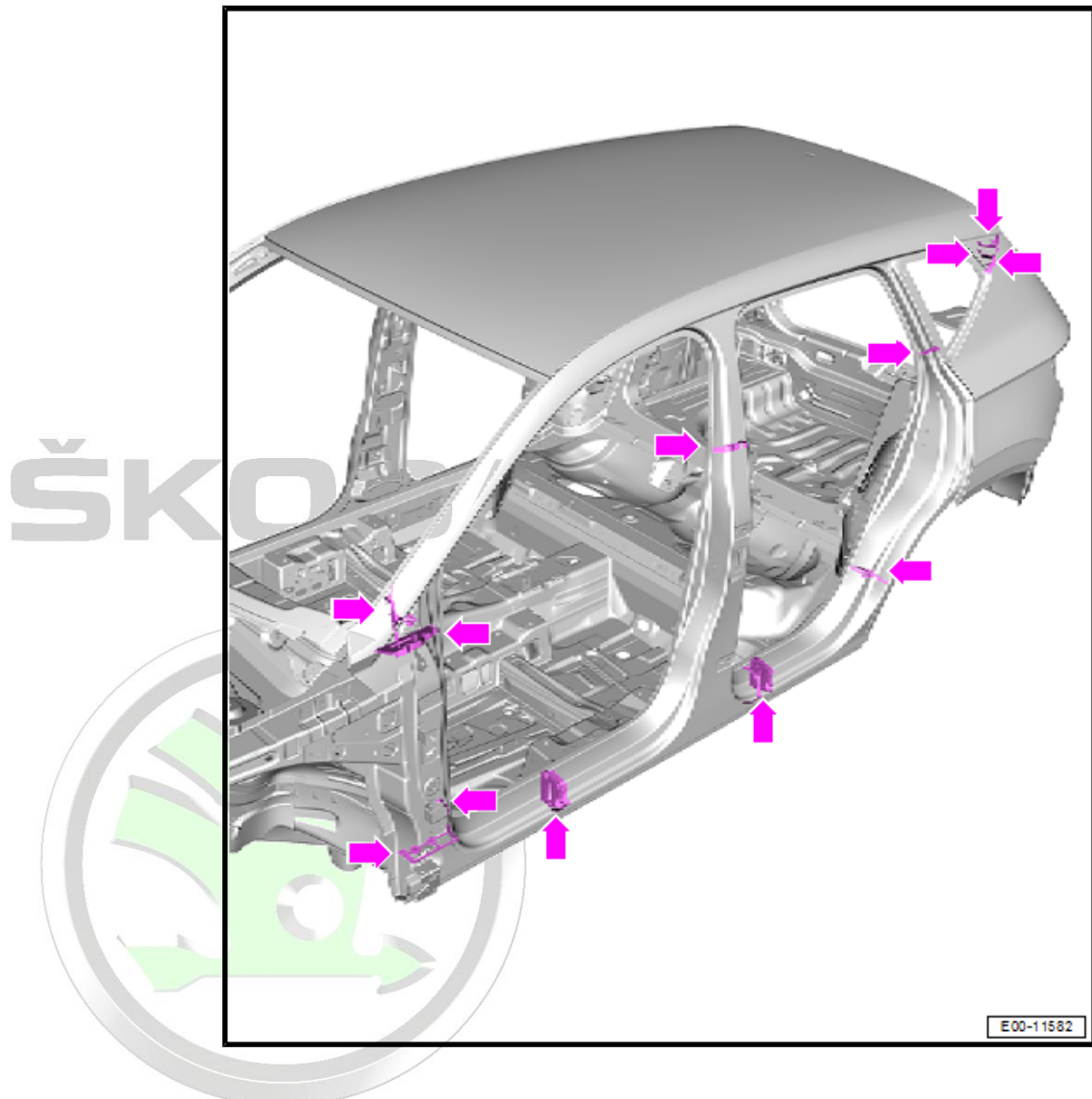


4 Foam moulds

⇒ "4.1 Position of the moulded foam parts", page 4

⇒ "4.2 Replace the moulded foam part", page 4

4.1 Position of the moulded foam parts



Various hollow spaces in this vehicle are filled with moulded foam parts.

The moulded foam parts reduce the transmission of vehicle noises into the passenger compartment.

The moulded foam parts are fitted during the manufacturing of the body structure and expand in volume after the primer is applied in the drying chamber of the paint shop at approx. 180 °C.

4.2 Replace the moulded foam part

⇒ General Information; Body Repairs, General Body Repairs ; Fundamentals of bodywork repairs; moulded foam parts



5 Vibration damping

⇒ ["5.1 Damping", page 5](#)

5.1 Damping

⇒ Paint - vehicle-specific information

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6 Galvanised body parts, high/ultra high-strength and hot-formed body panels

⇒ "6.1 Body", page 6

6.1 Body



Note

Repairs may only be carried out in accordance with the instructions of the manufacturer in the relevant Workshop Manual. High-strength hot-formed steels can only be repaired with modern inverter technology, otherwise optimum occupant protection is not guaranteed following the repair. Panels made of tempered steel must be used in areas that are exposed to extreme forces. These panels offer significantly greater strength than standard high-strength panels at a lower weight.

The structure of this vehicle is made for the most part out of galvanised steel sheet.

Follow the basic Instructions⇒ General Information; Body Repairs, General Body Repairs ; Basic instructions; High-strength/ ultra-strength and warm-formed body panels .

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7 Laser welding

⇒ ["7.1 Laser welding", page 7](#)

7.1 Laser welding

On this vehicle, the roof and in places also the bodyshell is laser welded.

When laser welding, a highly-energised beam of light is directed onto the position of the welding seam with optical glasses, or where necessary, optical fibres.

When performing welding work when melting through the top sheet and melting onto the bottom sheet, the welding seam is executed without additional material.

During repair work, the laser seams (except for when repairing the roof) are replaced by inert gas seam welds or, where necessary, by welding points.



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8 Gap sizes

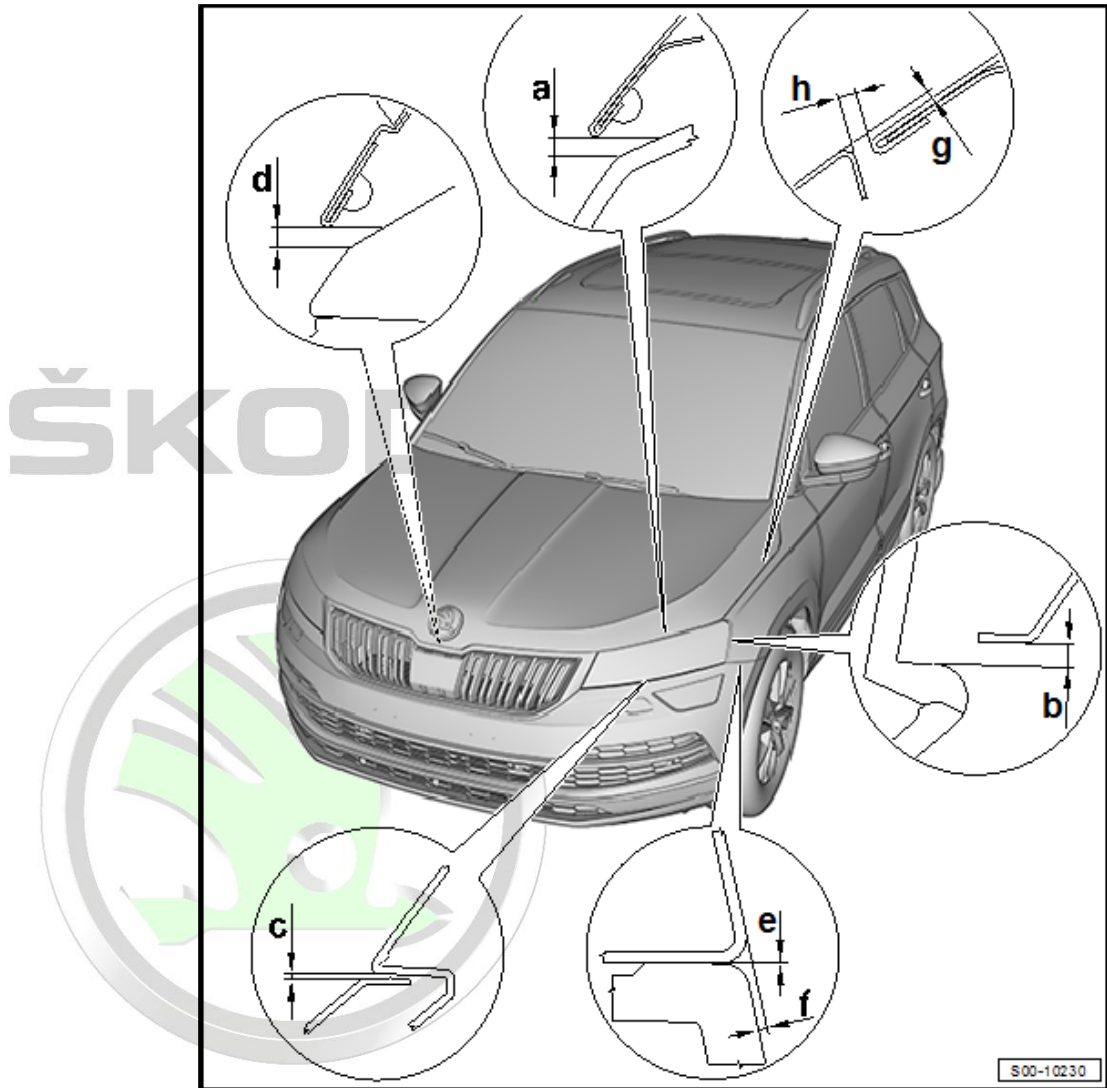
⇒ ["8.1 Front body", page 8](#)

⇒ ["8.2 Middle body", page 9](#)

⇒ ["8.3 Rear body", page 10](#)

8.1 Front body

- For example the setting gauge - 3371- can be used to set or inspect.

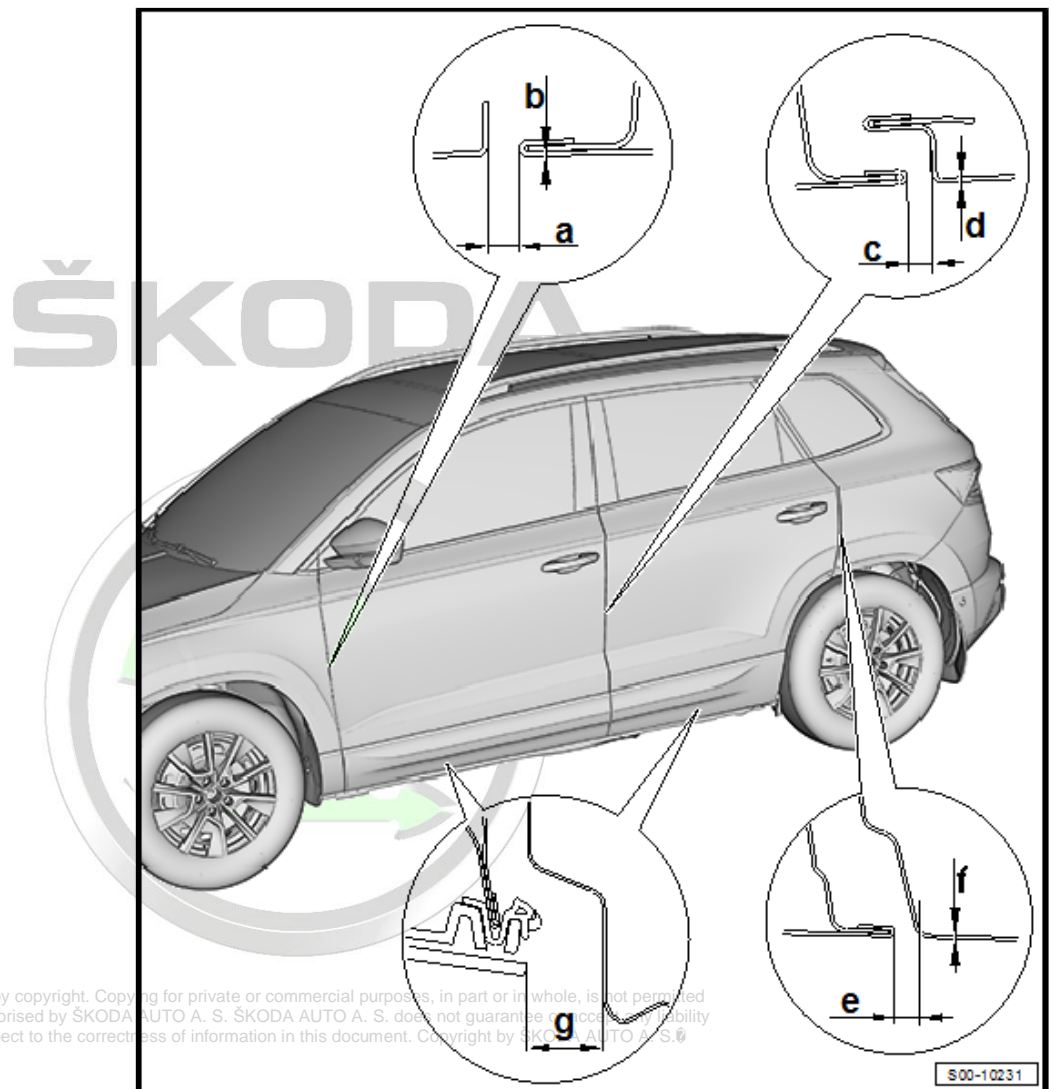


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- a- = 3.4 mm
- b- = 2 mm ± 0.5 mm
- c- = 1.5 mm ± 0.5 mm
- d- = 3.4 mm
- e- = 0 + 0.5 mm
- f- = 0.5 mm ± 0.5 mm
- g- = 1.4 mm ± 0.5 mm
- h- = 2.8 ± 0.5 mm

8.2 Middle body

- For example the setting gauge - 3371- can be used to set or inspect.



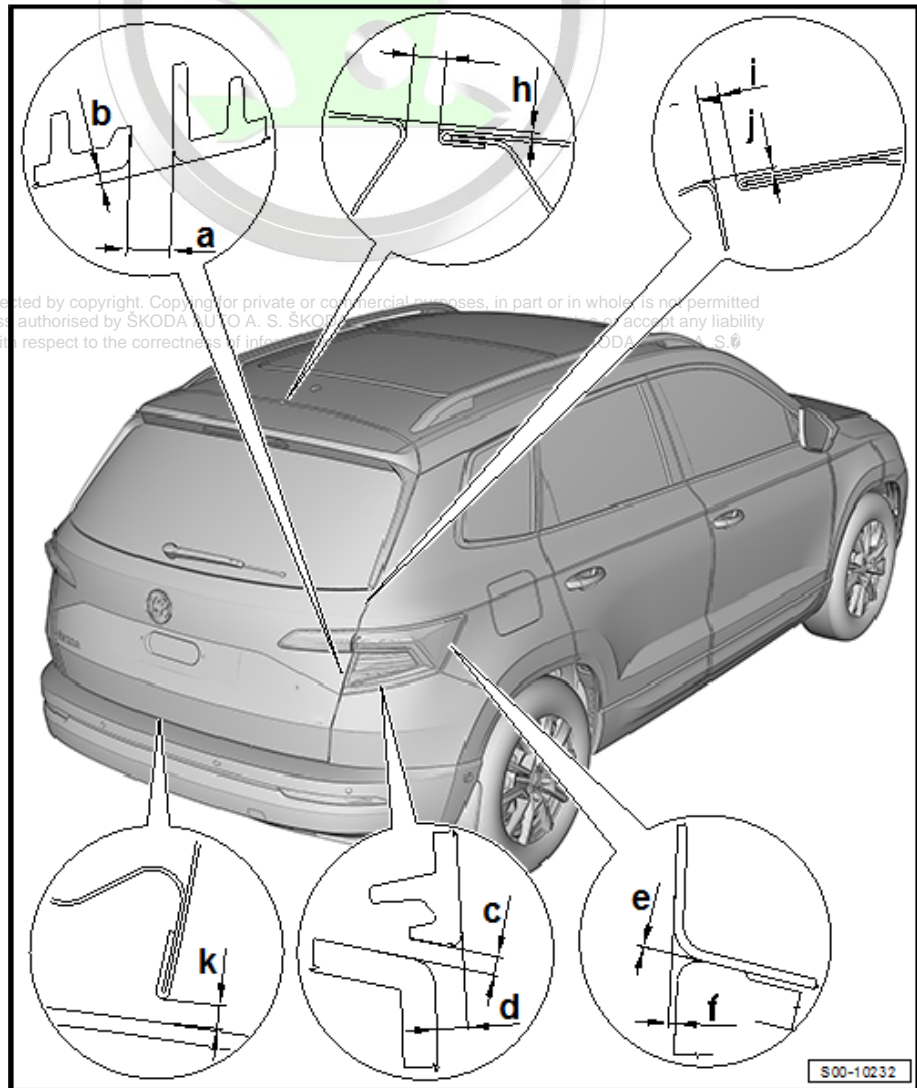


- a- = 3.5 mm ± 0.5 mm
- b- = 0 mm + 1 mm
- c- = 4.2 mm ± 0.5 mm
- d- = 0 mm + 1 mm
- e- = 3.5 mm ± 0.5 mm
- f- = 0 mm + 1 mm
- g- = 9.8 mm ± 0.8 mm

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8.3 Rear body

- For example the setting gauge - 3371- can be used to set or inspect.





-a- = 3.5 mm ± 0.5 mm

-b- = 1 mm ± 0.5 mm

-c- = 1 mm ± 0.5 mm

-d- = 1.5 mm ± 0.5 mm

-e- = 1 mm + 0.5 mm

-f- = 0.5 mm ± 0.5 mm

-g- = 4.5 mm ± 0.5 mm

-h- = 1.5 mm + 0.5 mm

-i- = 3.5 mm ± 0.5 mm

-j- = 1.3 mm ± 0.5 mm

-k- = 5 mm ± 0.5 mm

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9 Vehicle body dimensions

⇒ [“9.1 Front body”, page 12](#)

⇒ [“9.2 Middle body”, page 13](#)

⇒ [“9.3 Rear body”, page 15](#)

⇒ [“9.4 Body platform at the front”, page 17](#)

⇒ [“9.5 Body platform in the middle”, page 18](#)

⇒ [“9.6 Body platform at the rear”, page 19](#)

9.1 Front body

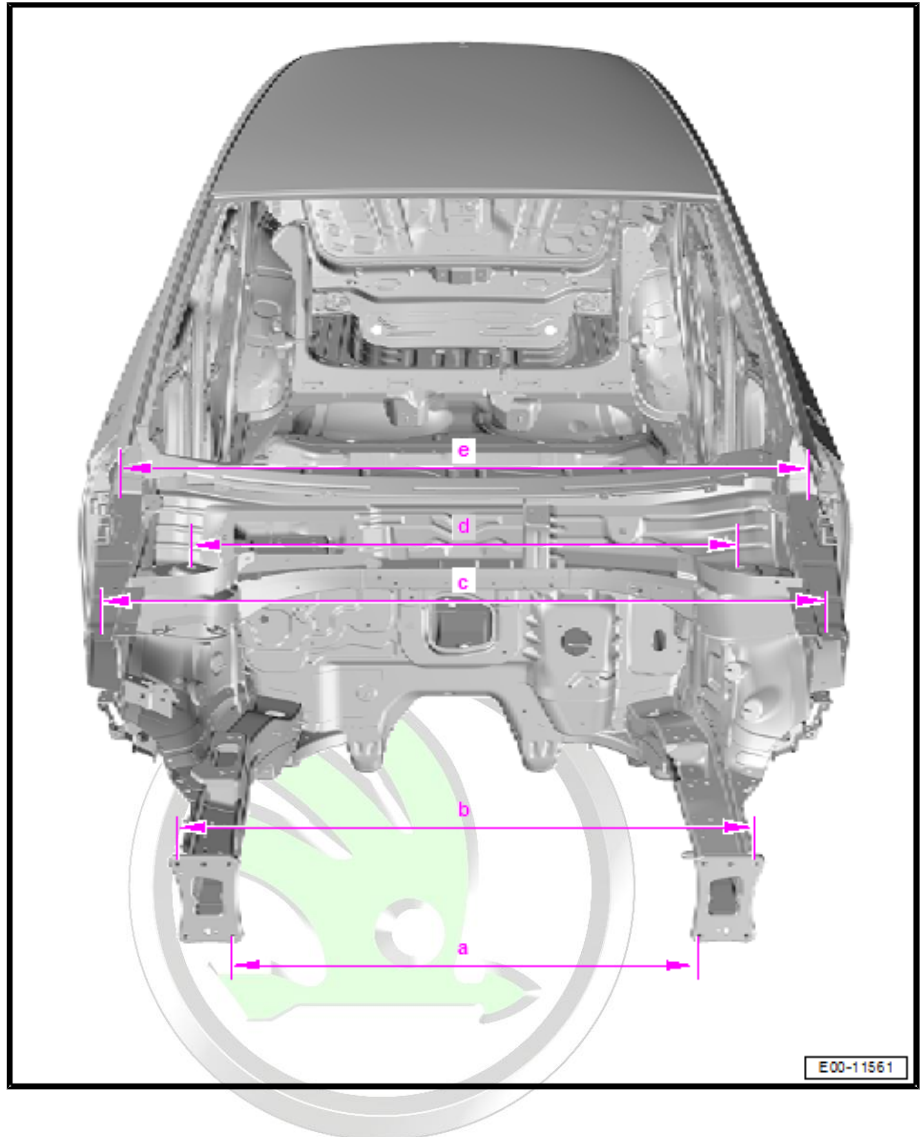


Note

- ◆ *The vehicle body dimensions are only relevant for the inspection. The straightening bracket set is used as standard.*
- ◆ *Screws, plugs, trim panels and components parts must be removed before the measurement.*
- In order to determine the body dimensions, use for example the telescopic dipstick - VAS 5159- or the telescopic dipstick - VAS 5160- .
- Ensure that the measuring tips are always the same length in order to avoid inaccuracies during the measurement.



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- a- = 879 mm ± 2.0 mm
- b- = 1072 mm ± 2.0 mm
- c- = 1416 mm ± 2.0 mm
- d- = 1153 mm ± 2.0 mm
- a- = 1519 mm ± 2.0 mm

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9.2 Middle body

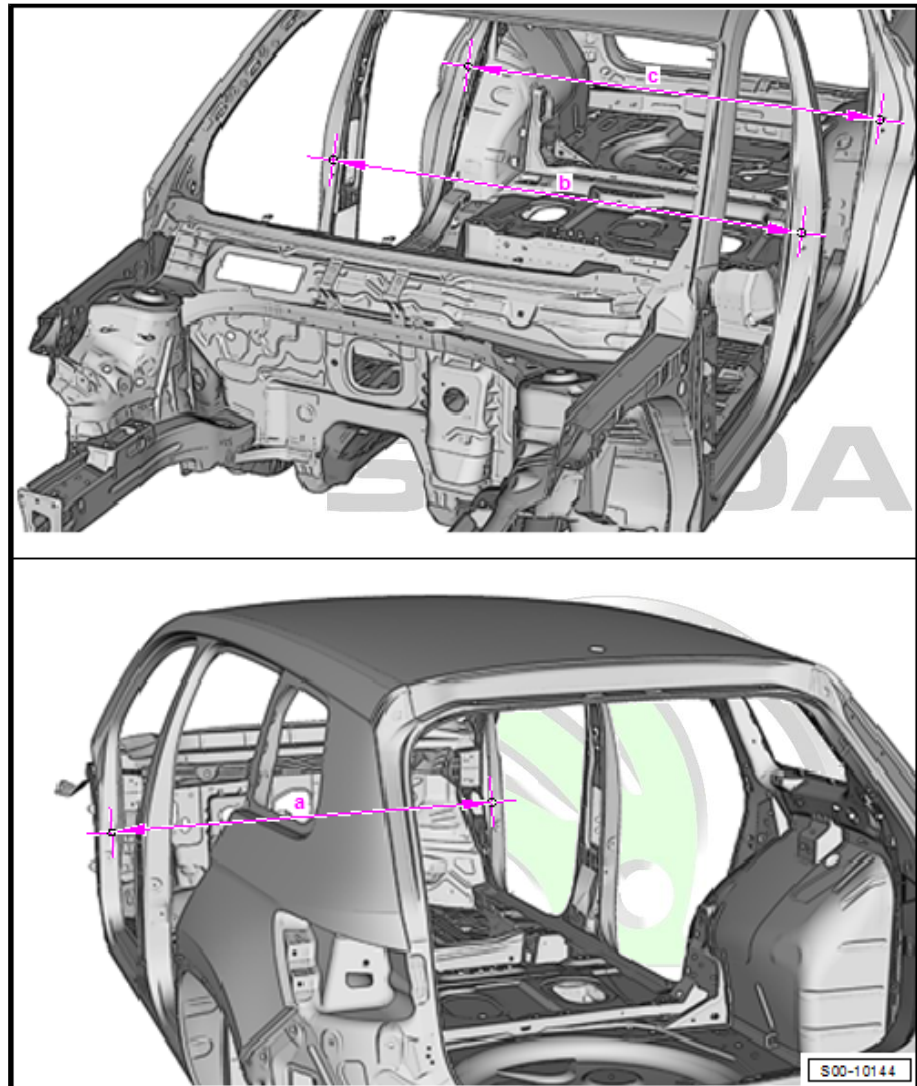


Note

- ◆ *The vehicle body dimensions are only relevant for the inspection. The straightening bracket set is used as standard.*
- ◆ *Screws, plugs, trim panels and components parts must be removed before the measurement.*
- In order to determine the body dimensions, use for example the telescopic dipstick - VAS 5159- or the telescopic dipstick - VAS 5160- .
- Ensure that the measuring tips are always the same length in order to avoid inaccuracies during the measurement.



Dimension between the A-, B- and C-pillars



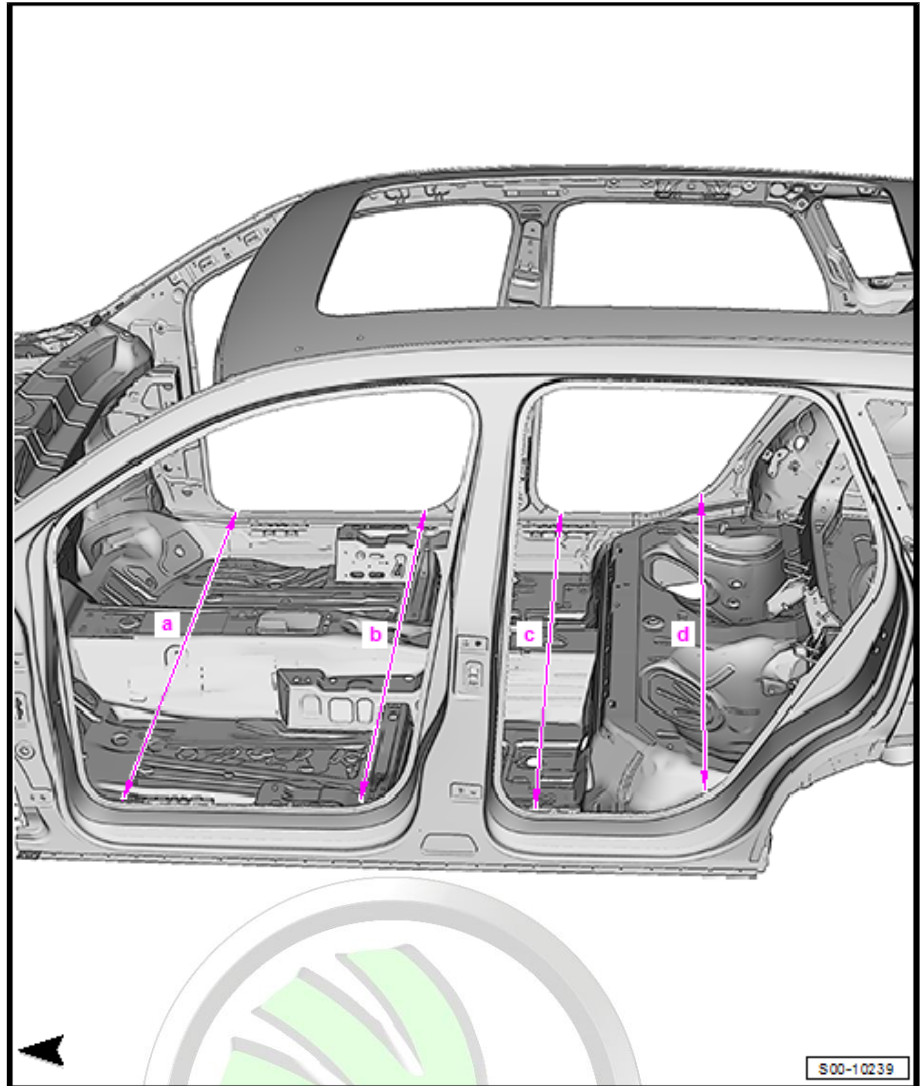
-a- = 1499 mm ± 2.0 mm

-b- = 1537 mm ± 2.0 mm

-c- = 1481 mm ± 2.0 mm

Dimension between the A-, B- and C-pillars

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-a- = 1464 mm ± 2.0 mm

-b- = 1469 mm ± 2.0 mm

-c- = 1469 mm ± 2.0 mm

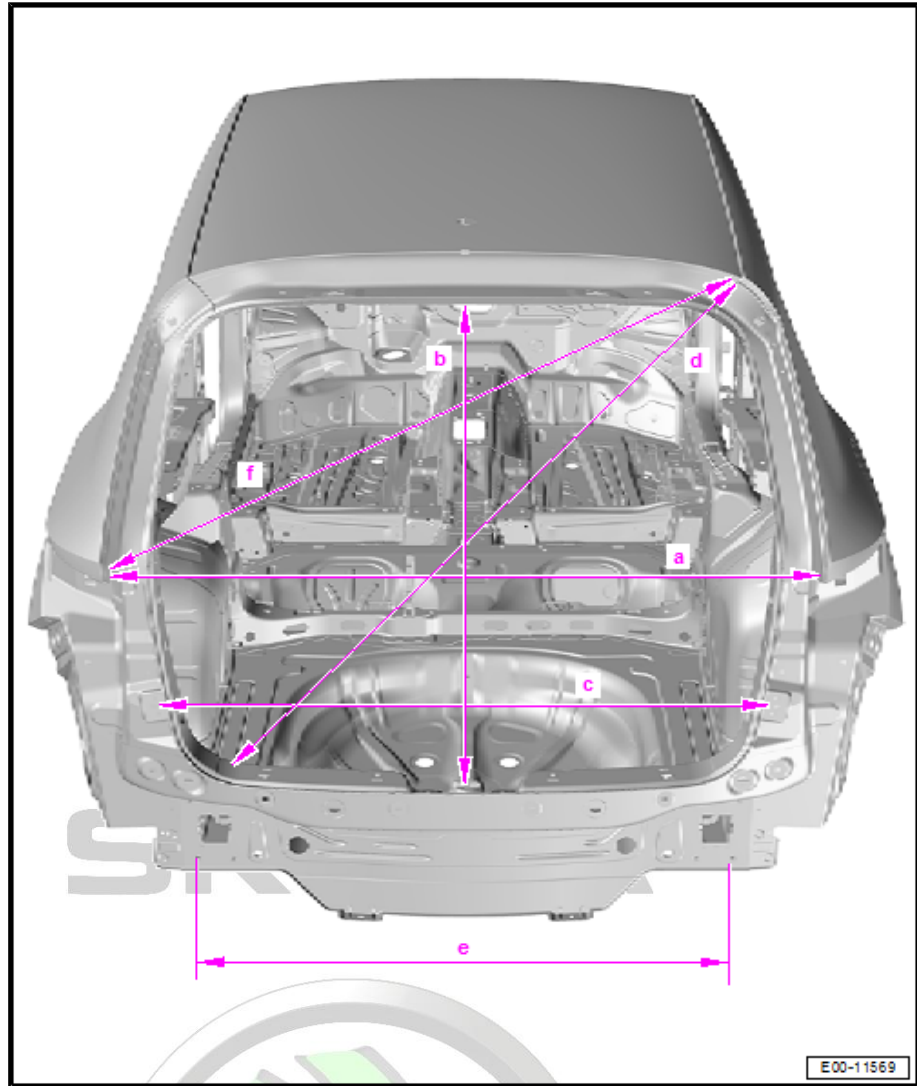
-d- = 1464 mm ± 2.0 mm

9.3 Rear body

i Note

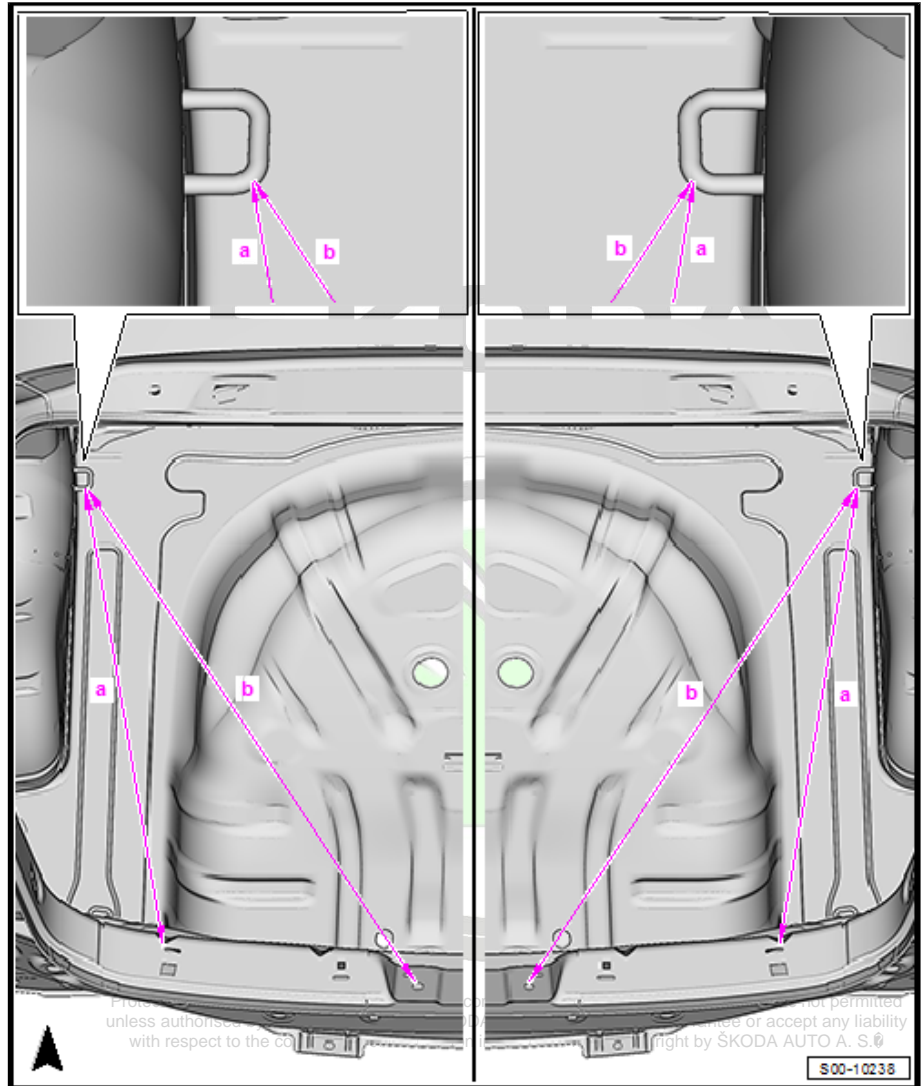
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- ◆ *The vehicle body dimensions are only relevant for the inspection. The straightening bracket set is used as standard.*
- ◆ *Screws, plugs, trim panels and components parts must be removed before the measurement.*
- In order to determine the body dimensions, use for example the telescopic dipstick - VAS 5159- or the telescopic dipstick - VAS 5160- .
- Ensure that the measuring tips are always the same length in order to avoid inaccuracies during the measurement.



- a- = 1309 mm ± 2.0 mm
- b- = 923 mm ± 2.0 mm
- c- = 1170 mm ± 2.0 mm
- d- = 1353 mm ± 2.0 mm
- e- = 1060 mm ± 2.0 mm
- f- = 1327 mm ± 2.0 mm

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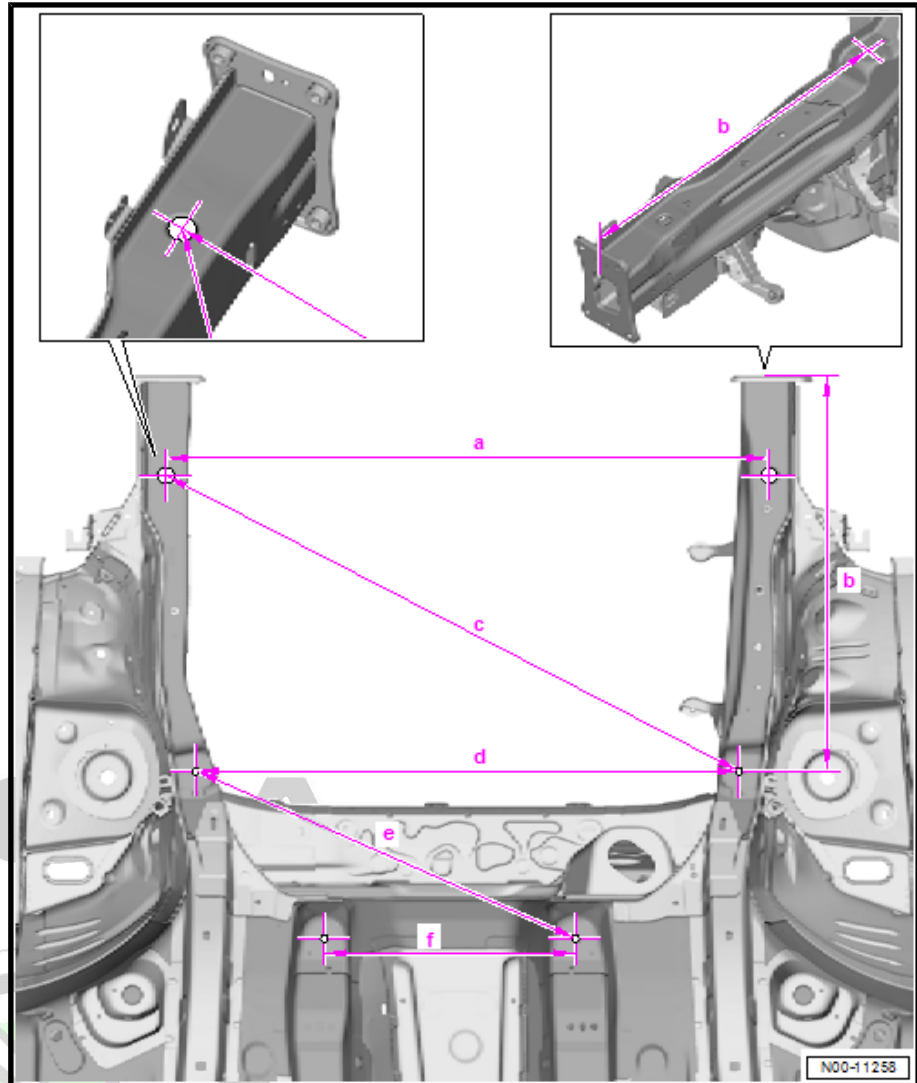
-a- = 684 mm ± 2.0 mm

-b- = 833 mm ± 2.0 mm

9.4 Body platform at the front

Note

- ◆ *The vehicle body dimensions are only relevant for the inspection. The straightening bracket set is used as standard.*
- ◆ *Screws, plugs, trim panels and components parts must be removed before the measurement.*
- In order to determine the body dimensions, use for example the telescopic dipstick - VAS 5159- or the telescopic dipstick - VAS 5160- .
- Ensure that the measuring tips are always the same length in order to avoid inaccuracies during the measurement.



- a- = 970 mm ± 2.0 mm
- b- = 630 mm ± 2.0 mm
- c- = 1040 mm ± 2.0 mm
- d- = 874 mm ± 2.0 mm
- e- = 730 mm ± 2.0 mm
- f- = 404 mm ± 2.0 mm

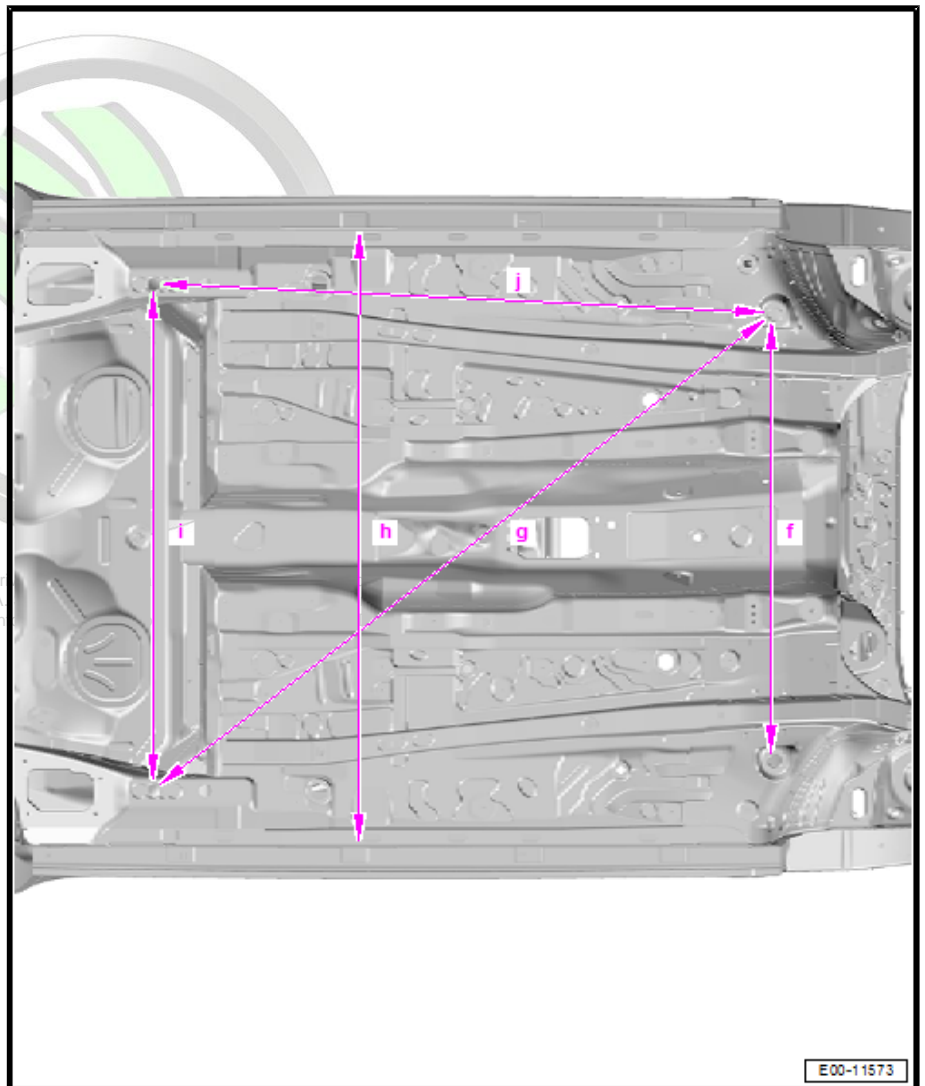
9.5 Body platform in the middle

i Note

- ◆ *The vehicle body dimensions are only relevant for the inspection. The straightening bracket set is used as standard.*
- ◆ *Screws, plugs, trim panels and components parts must be removed before the measurement.*
- In order to determine the body dimensions, use for example the telescopic dipstick - VAS 5159- or the telescopic dipstick - VAS 5160- .



- Ensure that the measuring tips are always the same length in order to avoid inaccuracies during the measurement.



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E00-11573

- f- = 1076 mm ± 2.0 mm
- g- = 1885 mm ± 2.0 mm
- h- = 1447 mm ± 2.0 mm
- i- = 1220 mm ± 2.0 mm
- j- = 1497 mm ± 2.0 mm

9.6 Body platform at the rear

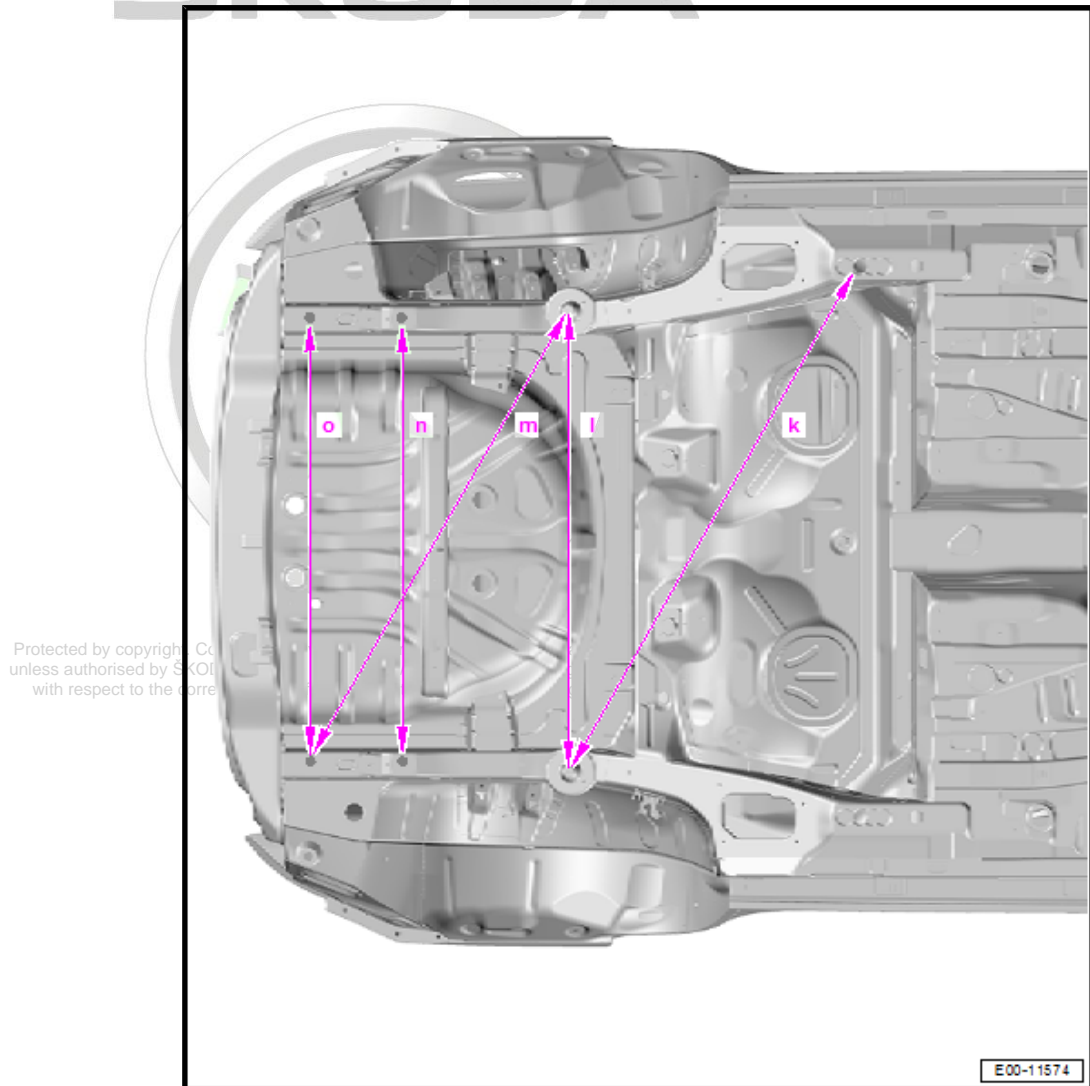


Note

- ◆ The vehicle body dimensions are only relevant for the inspection. The straightening bracket set is used as standard.
- ◆ Screws, plugs, trim panels and components parts must be removed before the measurement.



- In order to determine the body dimensions, use for example the telescopic dipstick - VAS 5159- or the telescopic dipstick - VAS 5160- .
- Ensure that the measuring tips are always the same length in order to avoid inaccuracies during the measurement.



- k- = 1306 mm ± 2.0 mm
- l- = 1021 mm ± 2.0 mm
- m- = 1146 mm ± 2,0 mm
- n- = 987 mm ± 2.0 mm
- o- = 986 mm ± 2.0 mm

10 Tools

⇒ ["10.1 List of tools", page 21](#)

10.1 List of tools

Special tools and workshop equipment required

- ◆ Resistance-spot welding unit (Inverter) e.g. -VAS 6530A- or -VAS 6545A- or -VAS 6755-
- ◆ Right angle grinder and wire brush
- ◆ Welding point loosening tool e.g. -V.A.G 1731- and replacement breaker for high-strength panels e.g. -V.A.G 1731/2- or -V.A.G 1731/3-
- ◆ Body saw e.g. -V.A.G 1523 A-
- ◆ Extraction device
- ◆ Door tension adjuster, e.g. -V.A.G 1438-
- ◆ Telescopic dipstick e.g. -VAS 5159- or -VAS 5160-
- ◆ Underbody sealant gun, e.g. -V.A.G 1379-
- ◆ Double cartridge gun - VAS 5237-
- ◆ Compressed air gun e.g. -V.A.G 2005B- for adhesive e.g. -DA 001 730 A2-
- ◆ Pressure beaker gun for hollow space sealing e.g. -V.A.G 1538-
- ◆ Inert gas shielded welding tool
- ◆ Burring pliers - burr panels e.g. for overlapping seams
- ◆ Punch pliers, e.g. -V.A.G 1329- - To punch holes in panels e.g. for GS plug welding
- ◆ Panel nibbler - To cut out panels without warpage or burring, e.g. when subsequently fitting a glass sun roof.
- ◆ Compressed air pistol e.g. -V.A.G 1761/1- - Compressed air pistol for creating seals and underbody protection with original factory finish- all 310 ml cartridges can be used with this gun.
- ◆ Electric knife e.g. -V.A.G. 1561/A- and cutting discs e.g. -V.A.G. 1561/25- or -V.A.G. 1561/26- - For precisely cutting through the panel or the welding seam e.g. when removing the roof
- ◆ E.g. milling machine for cutting the laser welding seam - VAS 6319- - for accurate grinding of the weld seam e.g. when removing the roof

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11 Straightening square set

⇒ ["11.1 Straightening square set", page 22](#)

11.1 Straightening square set

⇒ ["11.1.1 Measuring and guidance system, version 1", page 22](#)

⇒ ["11.1.2 Straightening square set, version 2", page 22](#)

11.1.1 Measuring and guidance system, version 1

Special tools and workshop equipment required

- ◆ Measurement and straightening system, Basic - VAS 6526- or
- ◆ Measurement and straightening system, Profi - VAS 6527- or
- ◆ Measurement and straightening system, Profi Plus - VAS 6528- or

11.1.2 Straightening square set, version 2

Special tools and workshop equipment required

- ◆ Straightening bracket set - VAS 6789 (2579.500)- +
- ◆ Straightening bracket plug-in extension, Karoq - VAS 801 031 (2579.515)-
- The detailed information for removal can be found in the design plan enclosed with the straightening square set.

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12 Portal gauge

⇒ **"12.1 Portal gauge", page 23**

12.1 Portal gauge

Special tools and workshop equipment required

- ◆ Portal gauge - VAS 802 001 (9113.063)- +
- ◆ Straightening bracket set - VAS 6789 (2579.500)- +
- ◆ Straightening bracket plug-in extension, Karoq - VAS 801 031 (2579.515)- +
- ◆ Portal gauge extension, Karoq - VAS 802 031 (2579.80J)-
- The detailed information for removal can be found in the design plan enclosed with the straightening square set.



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50 – Body - front

1 Replace engine mount

⇒ "1.1 Removing", page 24

⇒ "1.2 Preparing the new part", page 25

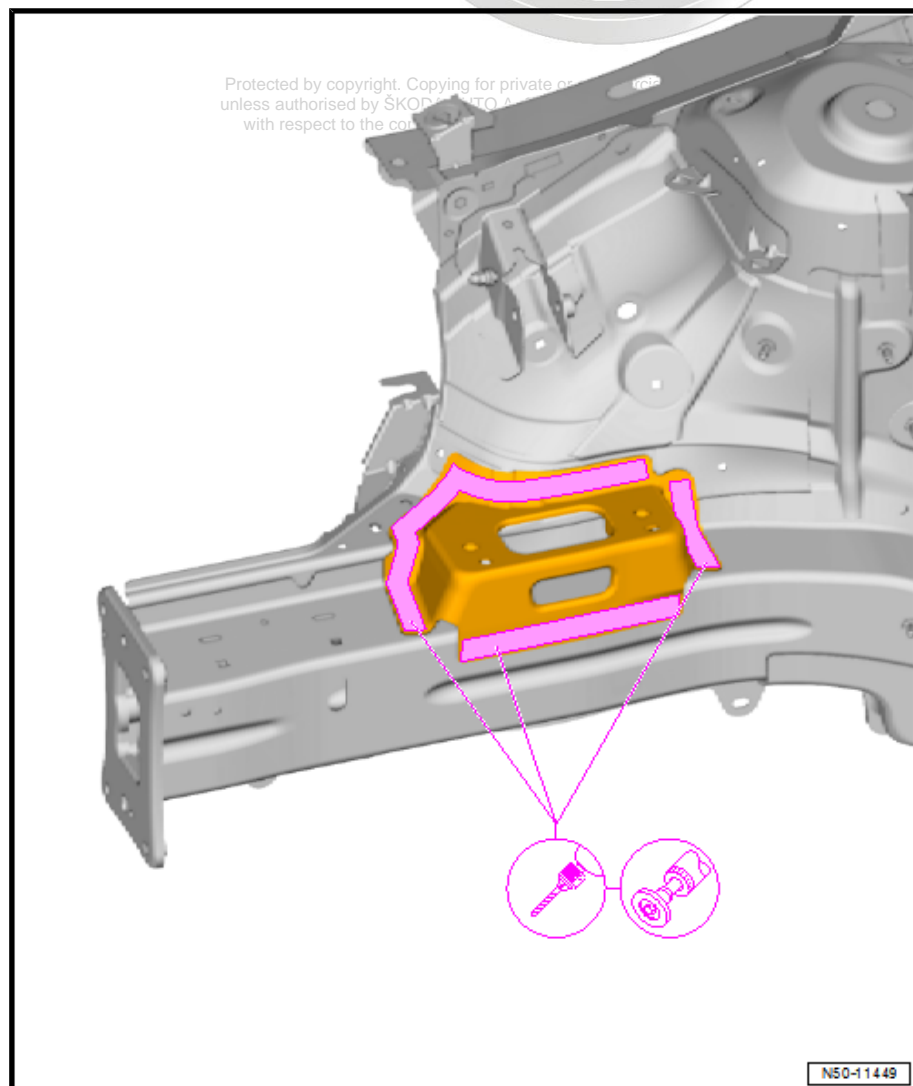
⇒ "1.3 Part welding", page 26

1.1 Removing

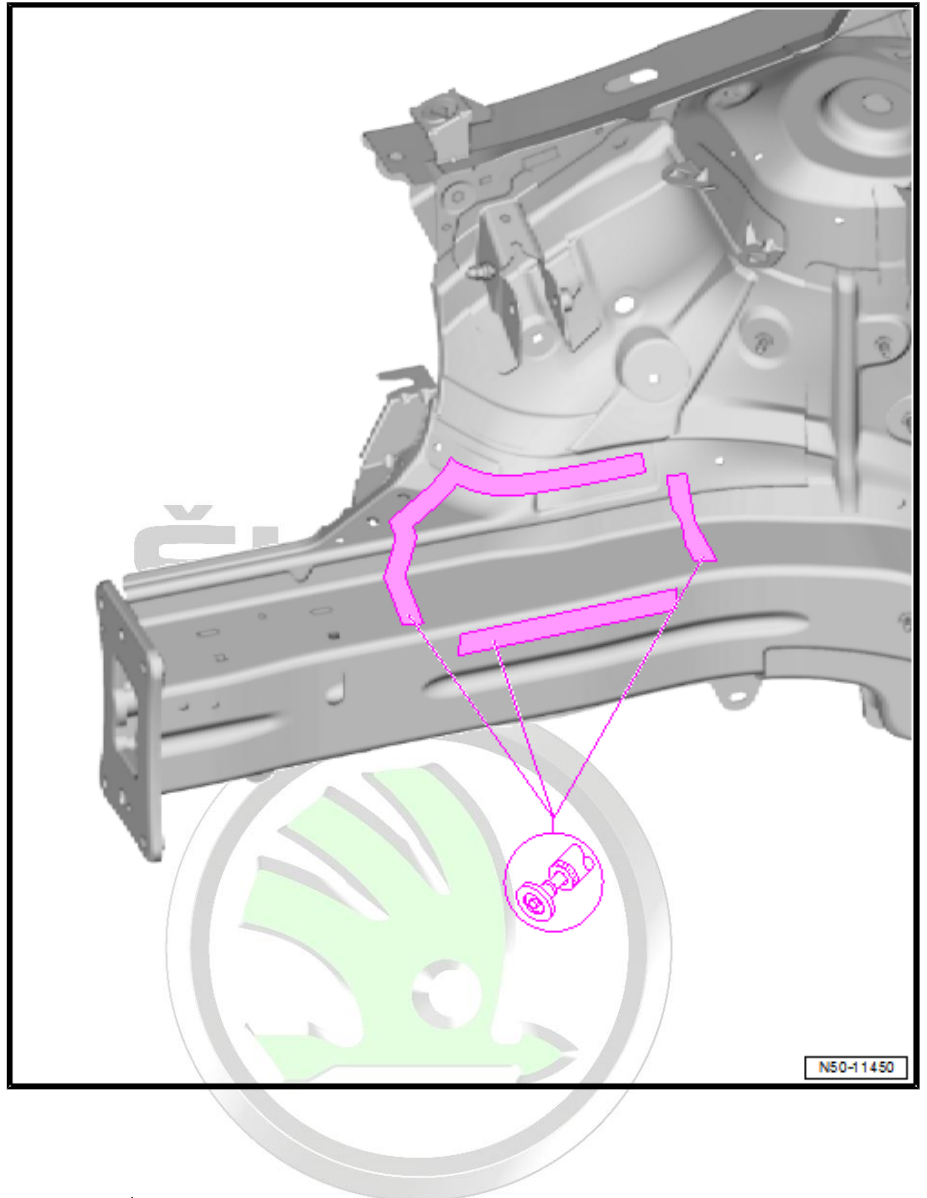


Caution

Follow the general notes! → General Information; Body Repairs, General Body Repairs



- Loosen the original welding.
- Remove the mount from the body.



- Remove any residues.

1.2 Preparing the new part

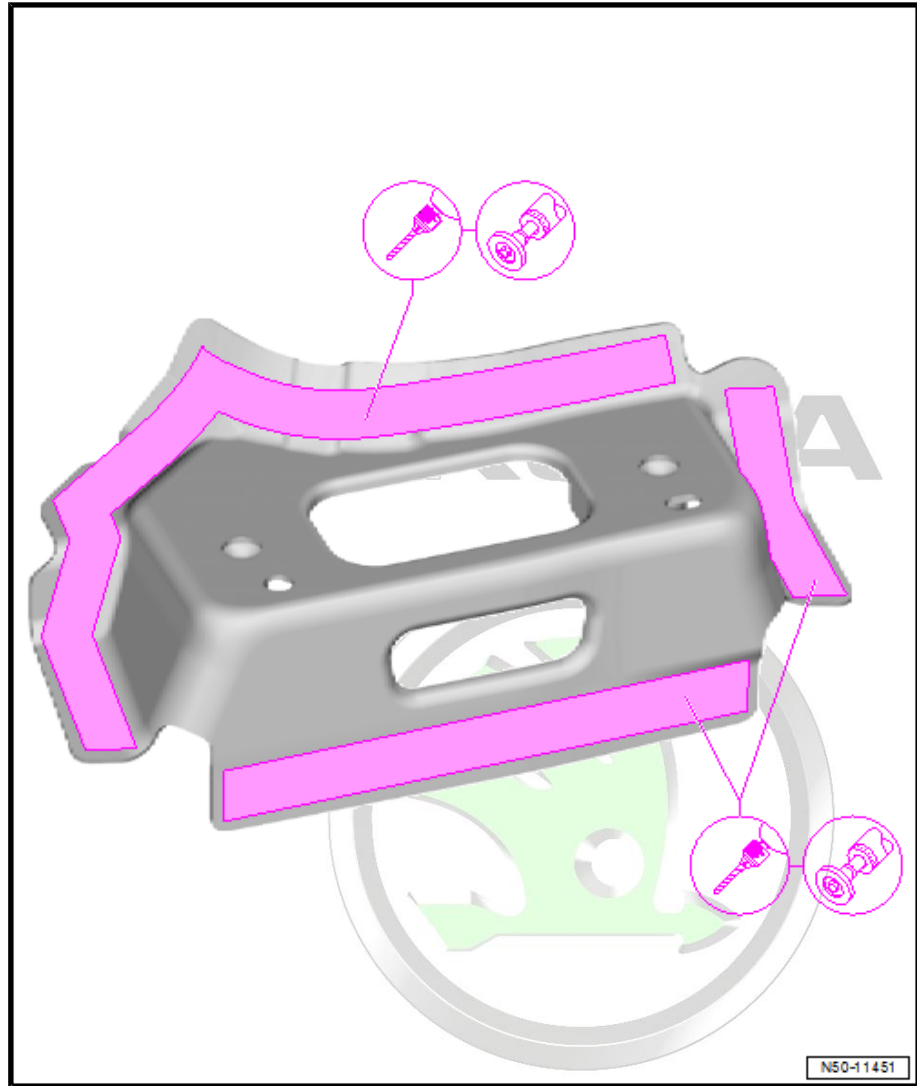


Caution

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New part

- ◆ Engine mount



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- Drill holes for the GS plug weld seam, 8 mm Ø.
- Slightly grind out the welding surfaces.

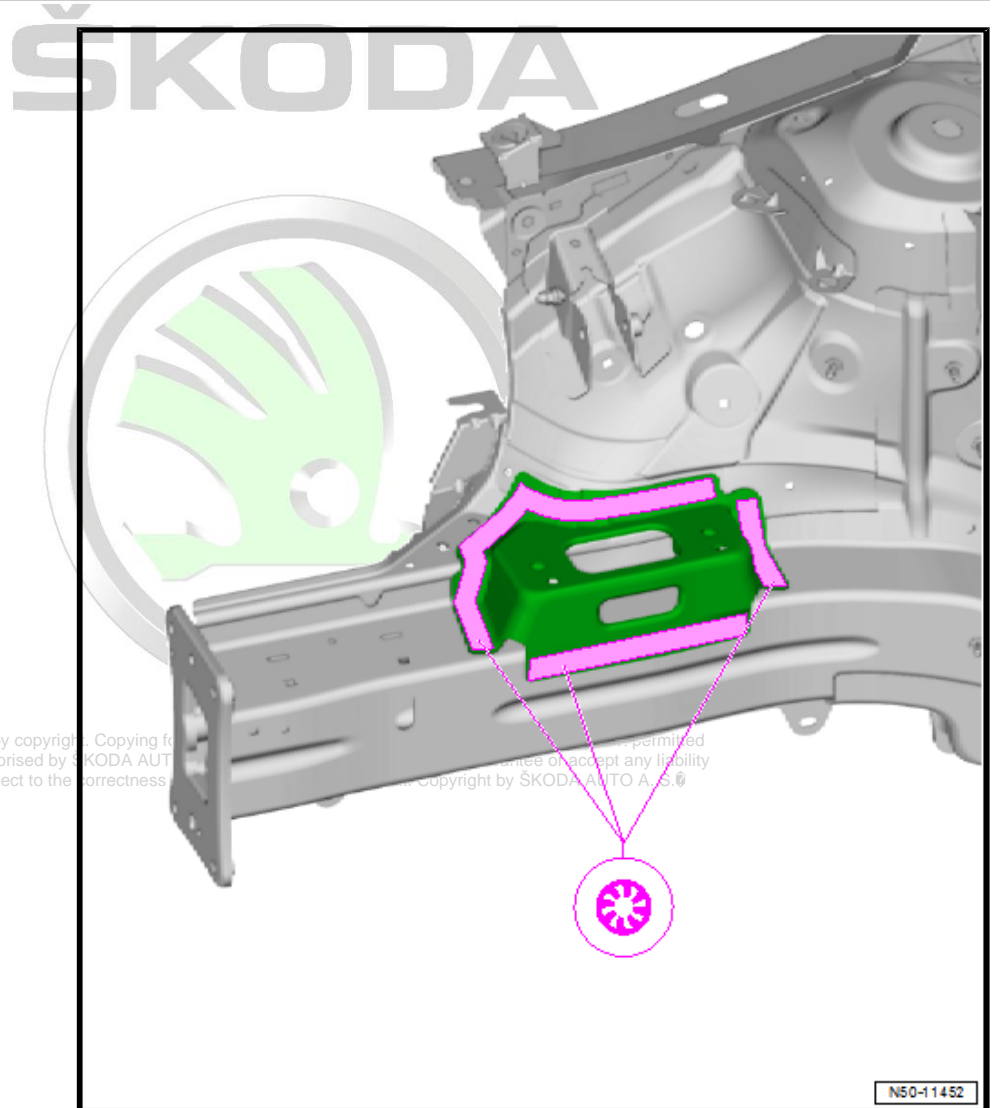
1.3 Part welding



Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs

- Adjust the new part and fix. For this purpose, the vehicle is standing on the straightening bracket set .



- Adjust the new part and fix. For this purpose, the vehicle is standing on the straightening bracket set .
- Check the fit with adjoining components.
- Weld in the new part, GS plug weld seam.



2 Replacing support block for assembly carrier

⇒ [“2.1 Summary of components”, page 28](#)

⇒ [“2.2 Removing”, page 29](#)

⇒ [“2.3 Preparing the new part”, page 30](#)

⇒ [“2.4 Part welding”, page 31](#)

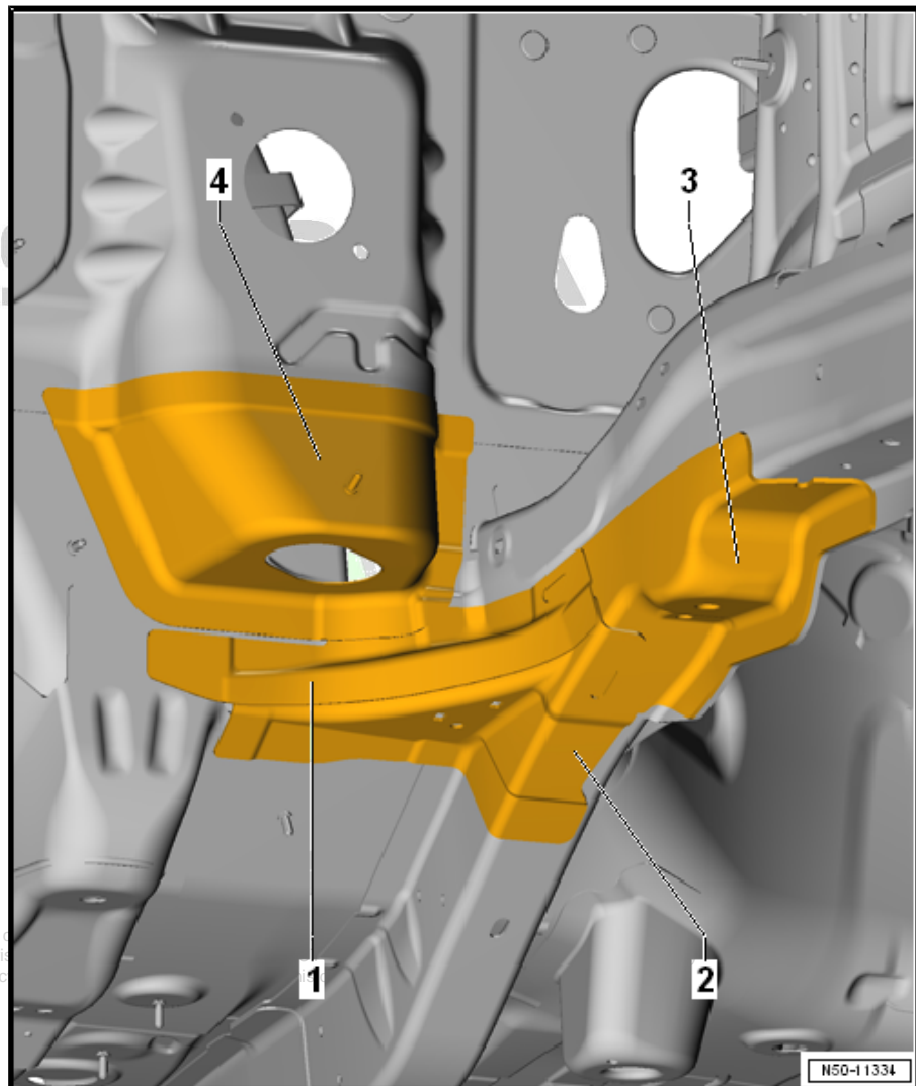
2.1 Summary of components



Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs

- 1 - Corner reinforcement top
- 2 - Corner reinforcement bottom
- 3 - Support block for assembly carrier
- 4 - End part



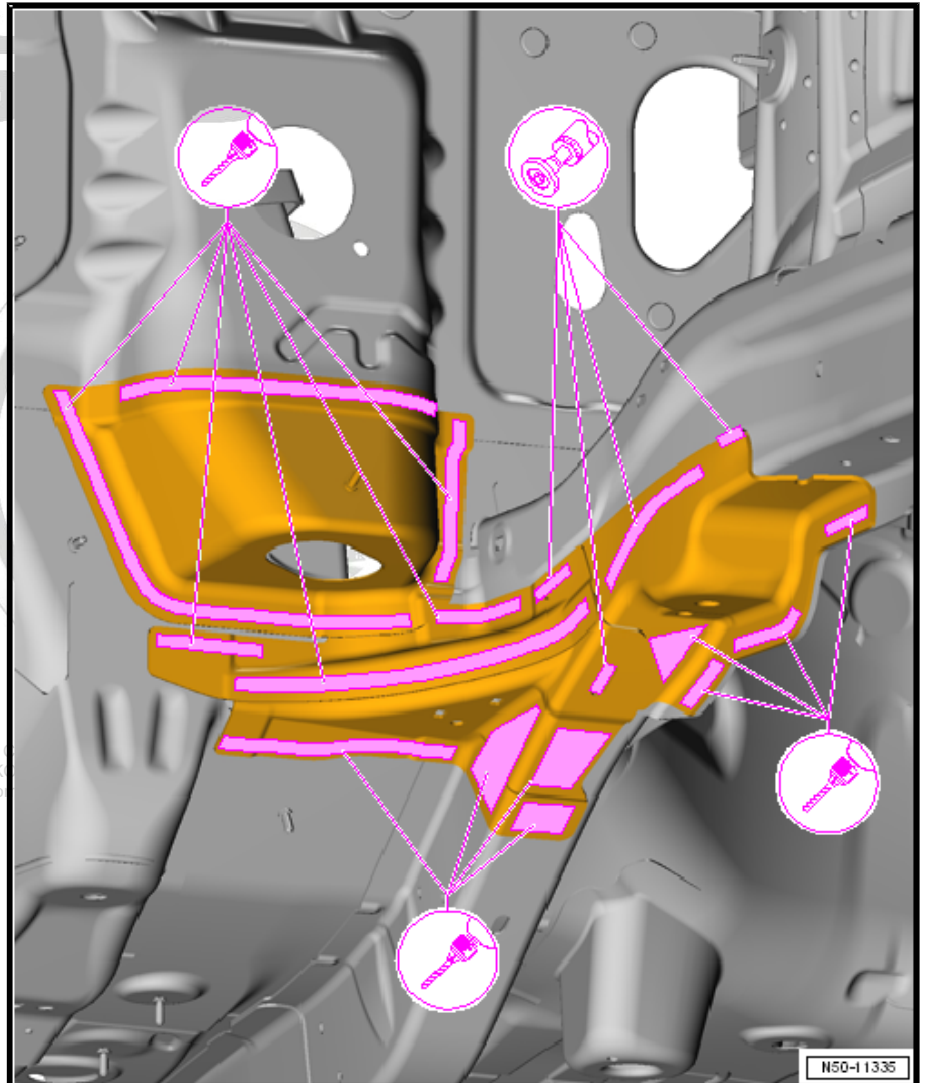
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2.2 Removing



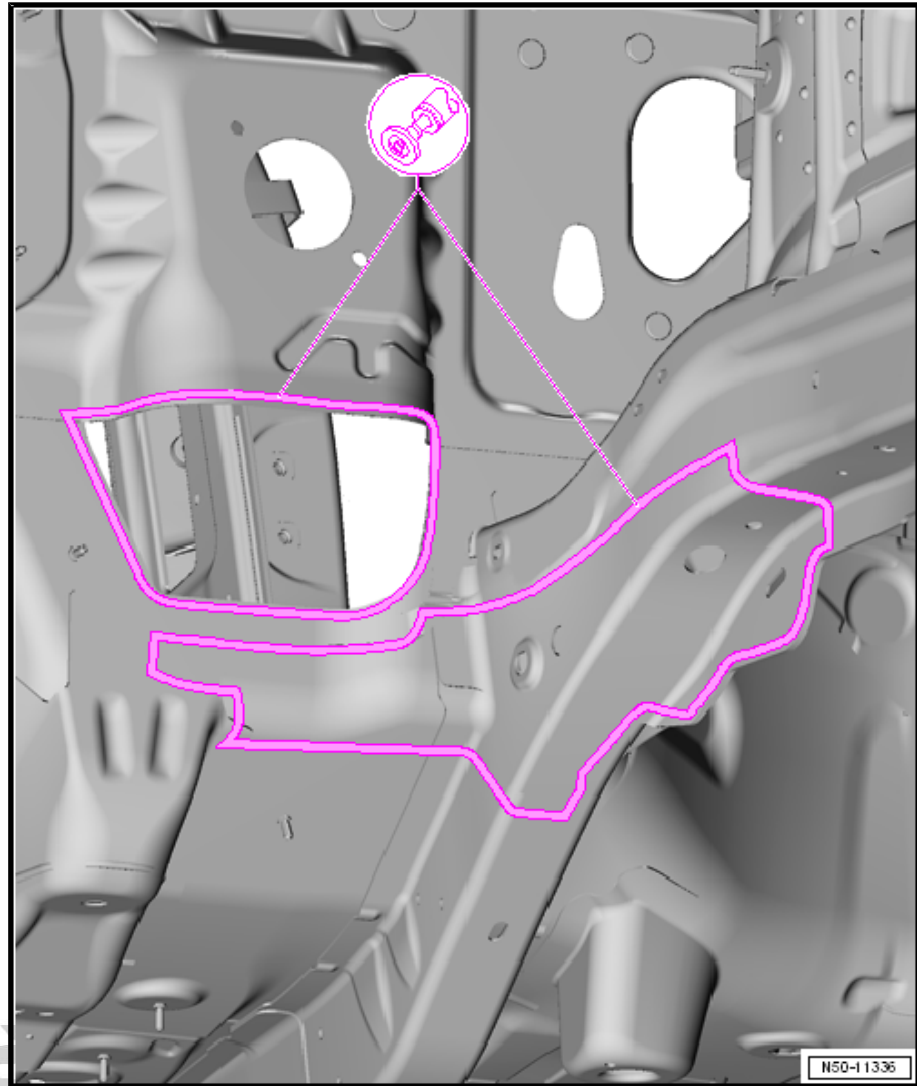
Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs



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- Loosen the original welding.



- Remove any residues.

2.3 Preparing the new part



Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs

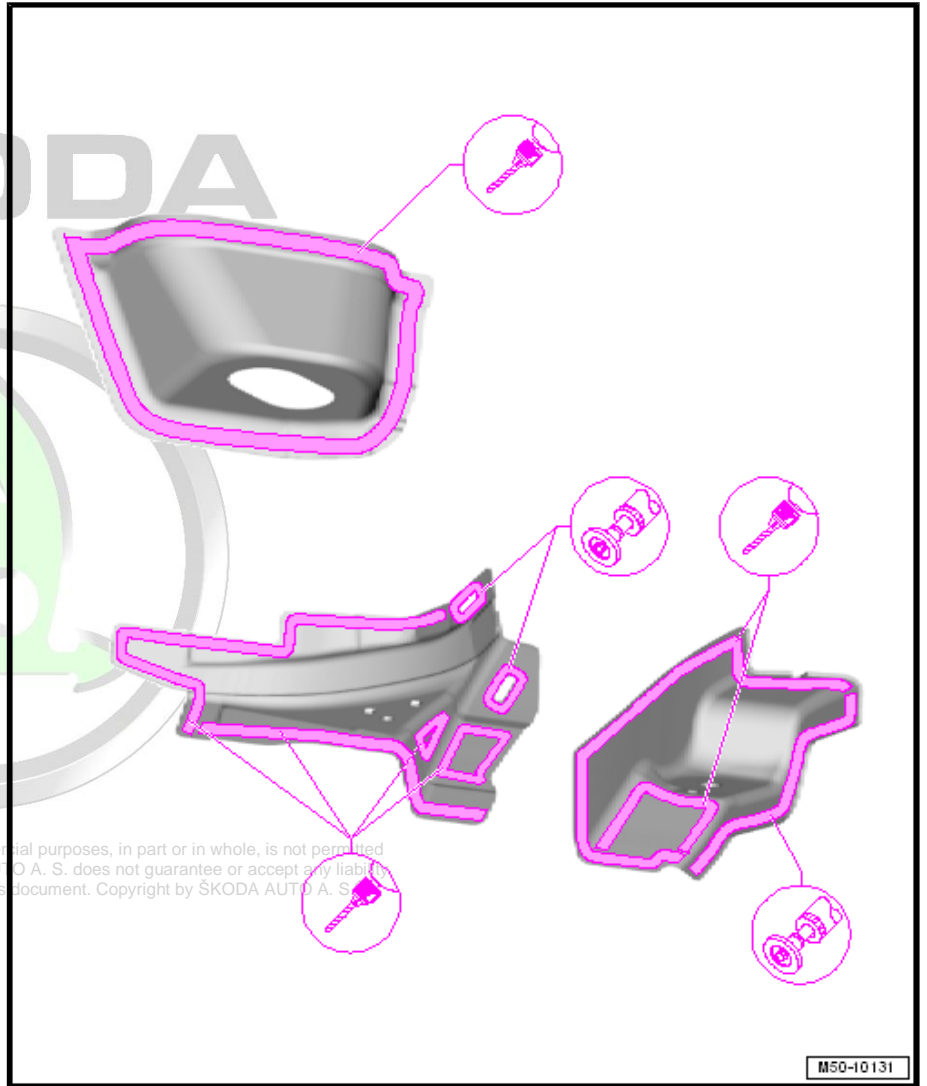
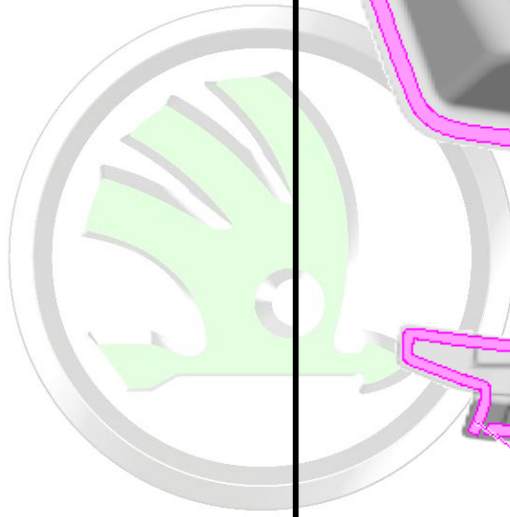
New part

- ◆ Corner reinforcement top
- ◆ Corner reinforcement bottom
- ◆ Support block for assembly carrier
- ◆ End part

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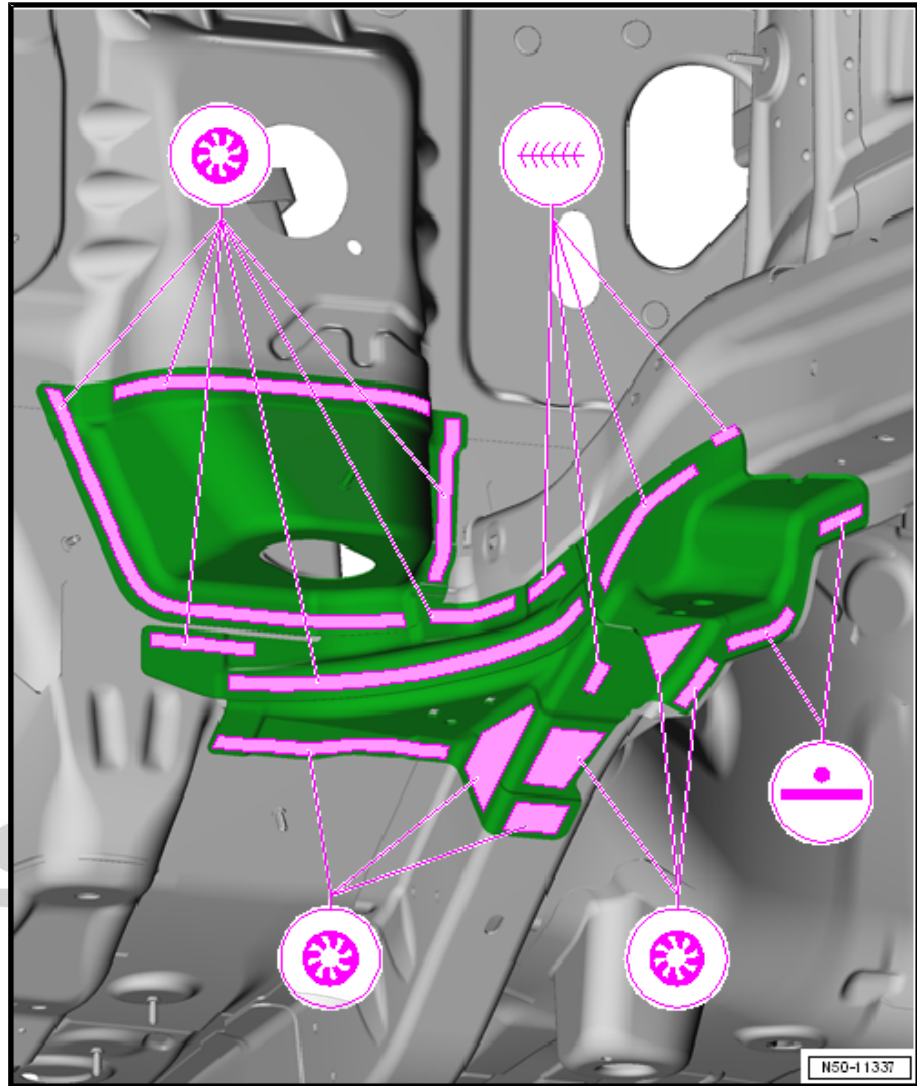
- Grind through and drill holes for the GS plug weld seam, 8 mm Ø.
- Slightly grind out the welding surfaces.

2.4 Part welding



Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs



- Adjust the new part and fix. For this purpose, the vehicle is standing on the straightening bracket set .
- Weld in the new part, RP spot weld seam, GS plug weld seam and GS continuous seam.

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3 Replacing the front bumper holder

⇒ "3.1 Summary of components", page 33

⇒ "3.2 Removing", page 34

⇒ "3.3 Part welding", page 35

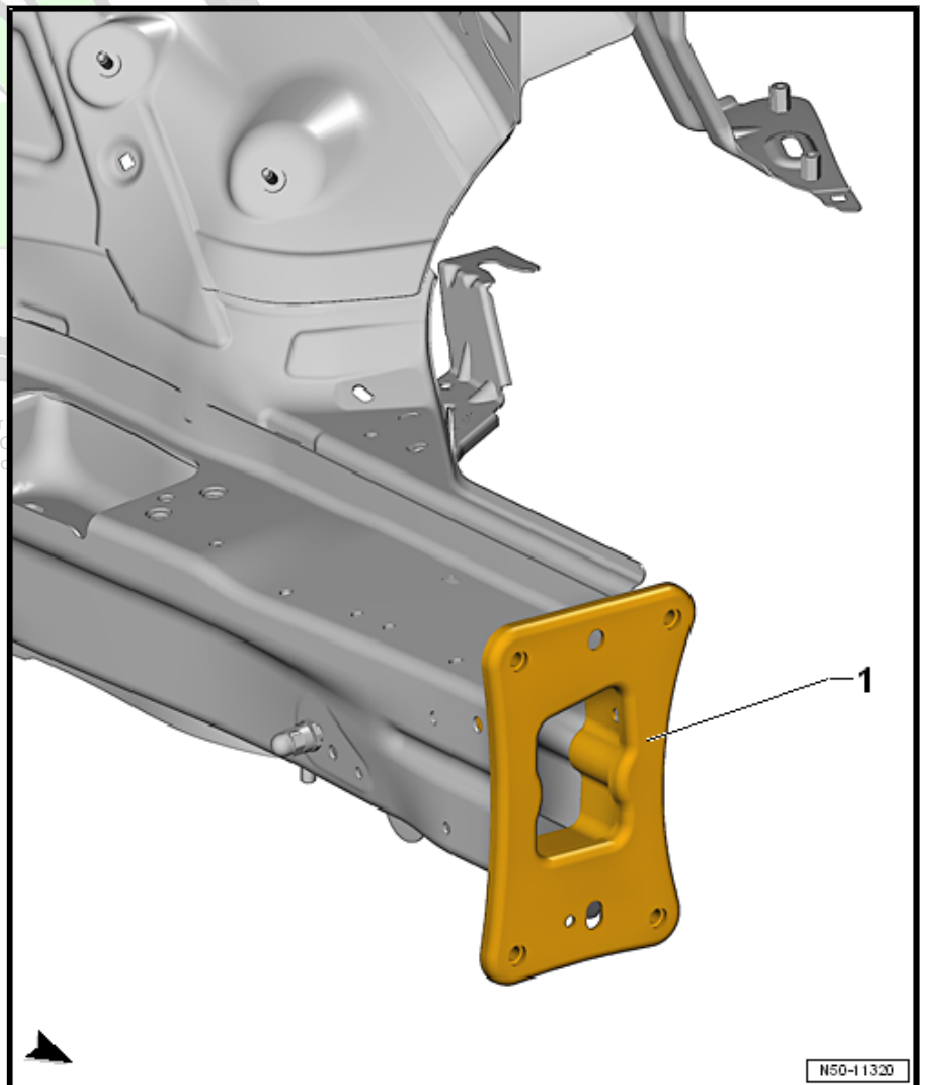
3.1 Summary of components



Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs

1 - Bumper mount



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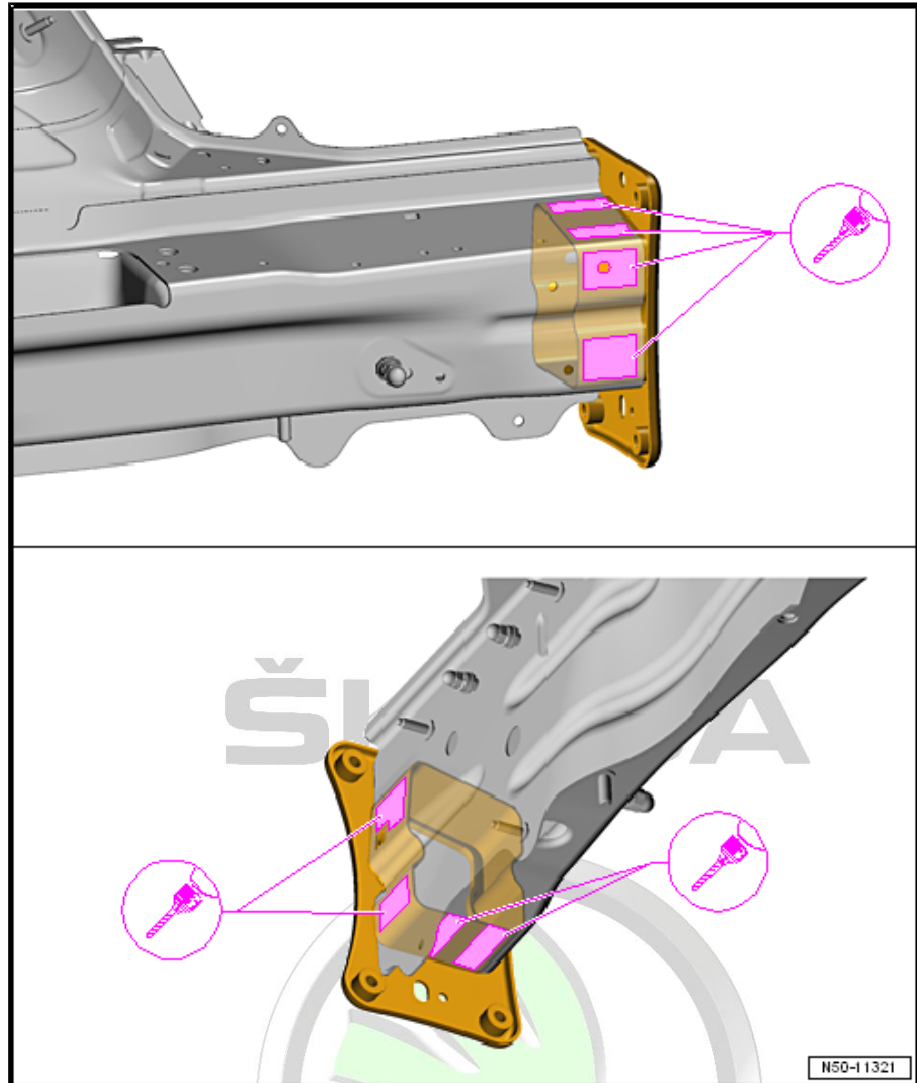


3.2 Removing

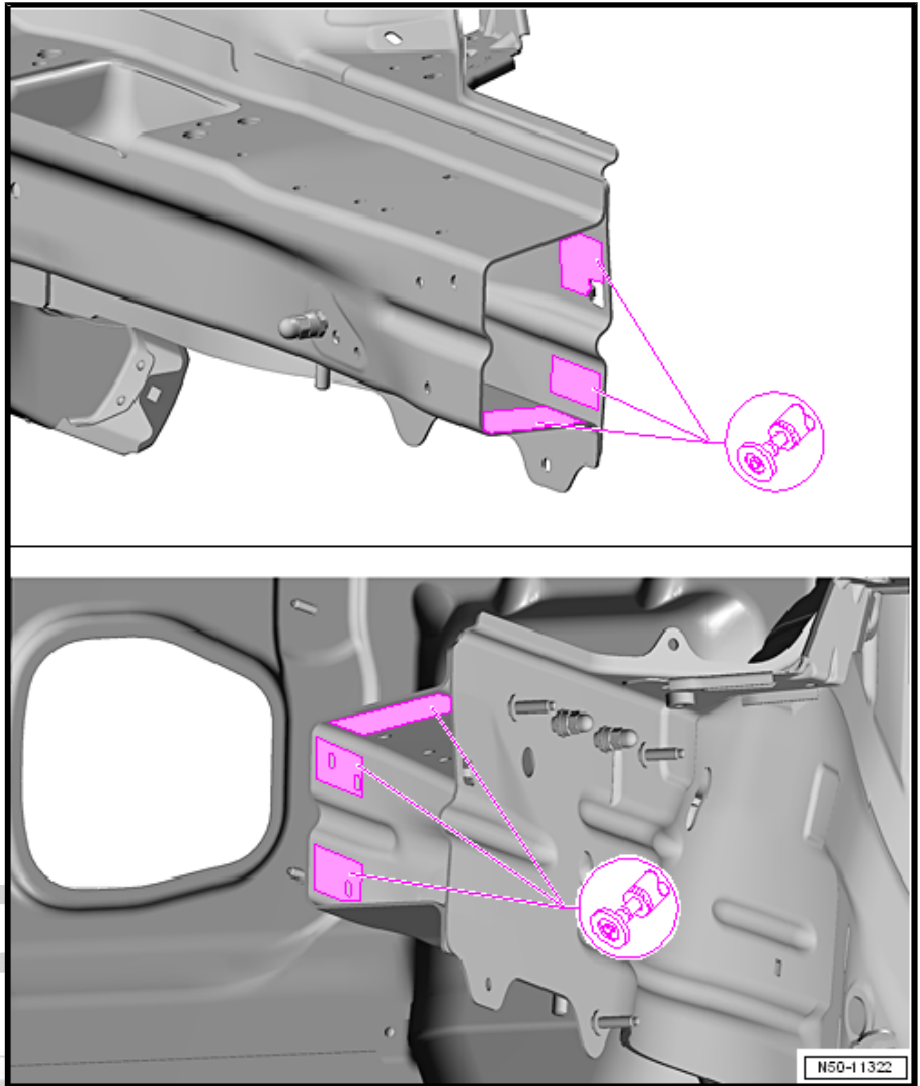


Caution

Follow the general notes! => General Information; Body Repairs, General Body Repairs



- Loosen the original welding.



- Remove any residues.

3.3 Part welding



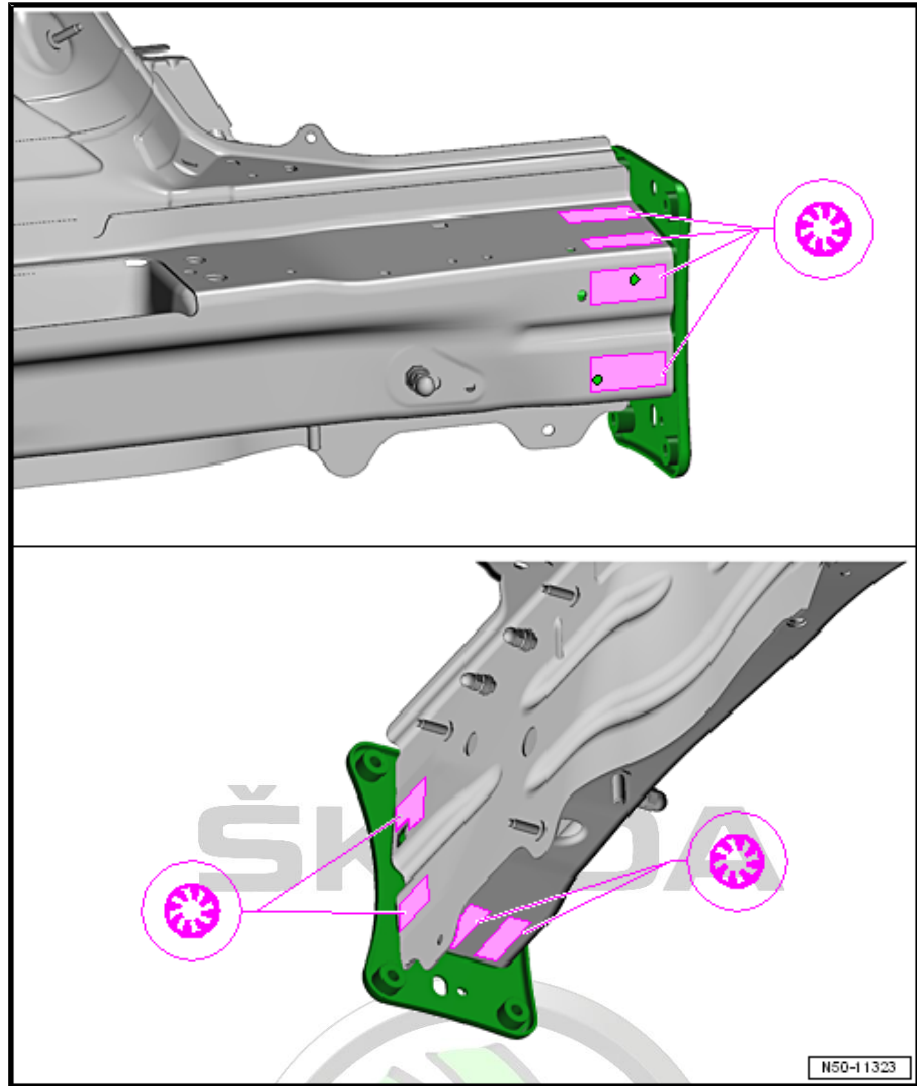
Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs

New part

- ◆ Front bumper holder

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- Adjust the new part and fix. For this purpose, the vehicle is standing on the straightening bracket set .
- Weld in the bumper holder, GS plug weld seam.

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4 Replacing the outer top frame side rail -part-

⇒ ["4.1 Removing", page 37](#)

⇒ ["4.2 Preparing the new part", page 38](#)

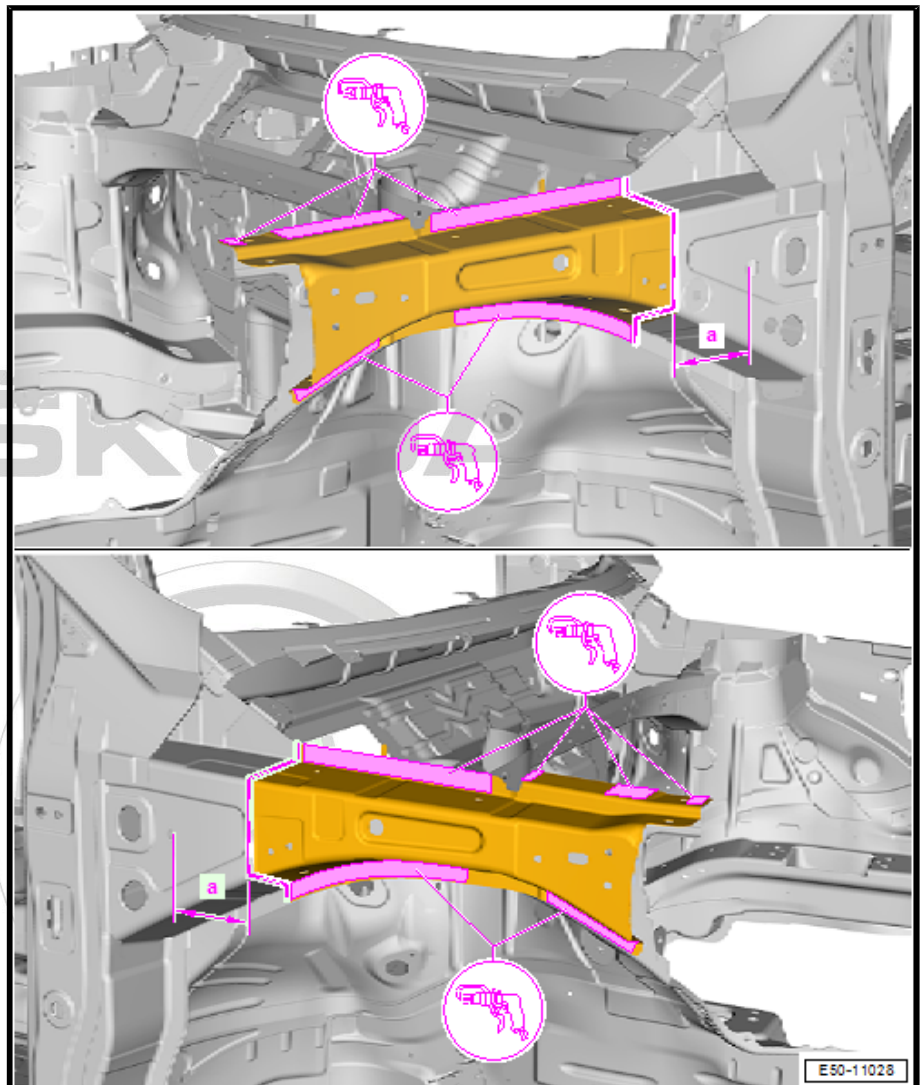
⇒ ["4.3 Part welding", page 39](#)

4.1 Removing



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Follow the general notes! → General Information; Body Repairs, General Body Repairs



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- Loosen the original welding or cut the part to size according to the damage e.g. -a-
- Remove any residues.



4.2 Preparing the new part

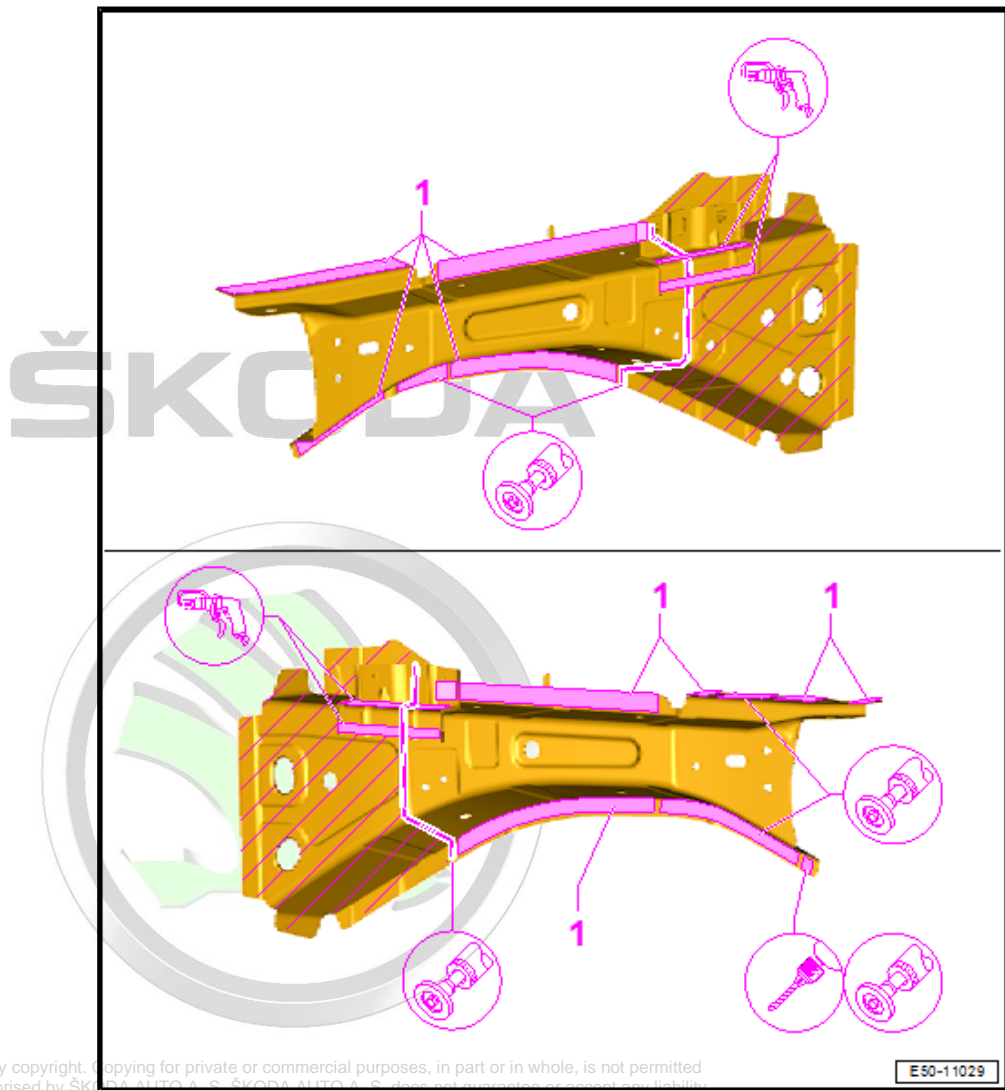


Caution

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New part

- ◆ Outer top frame side rail
- ◆ 2K epoxy adhesive - DA 001 730 A2-



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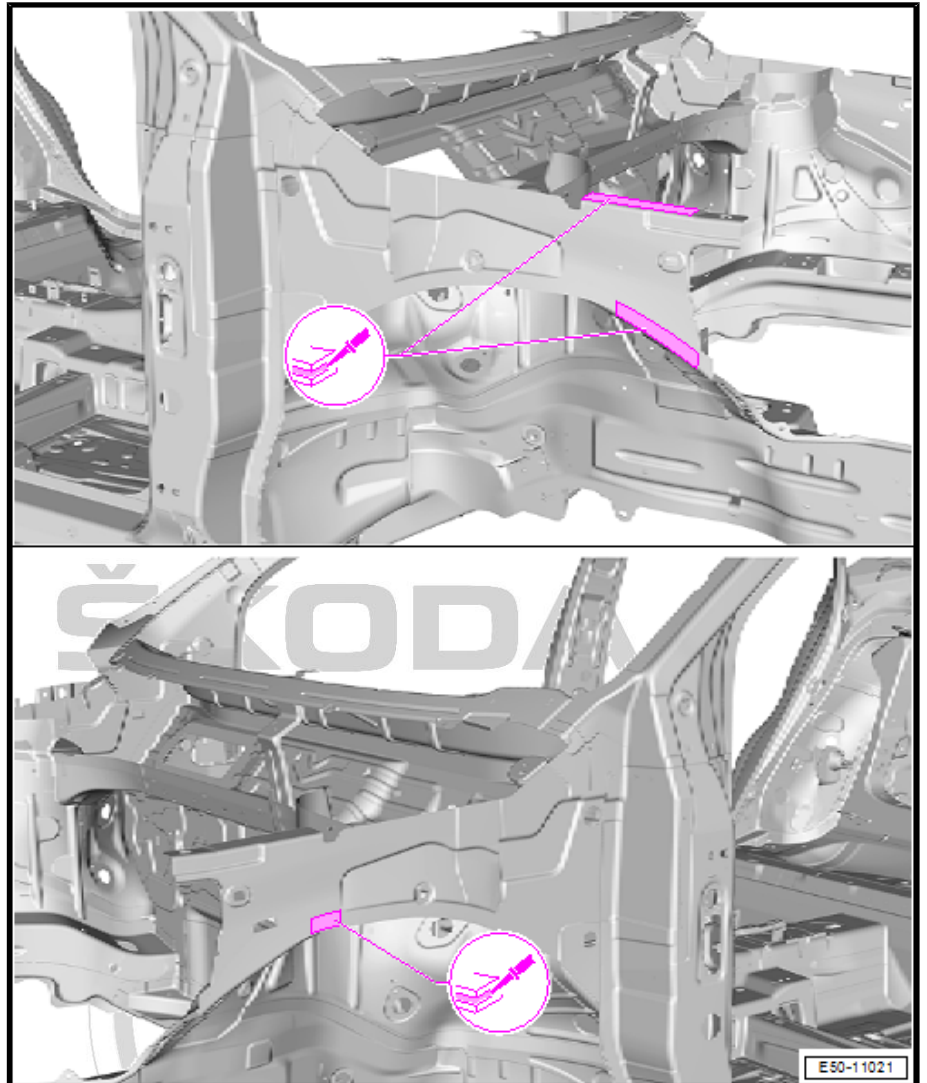
E50-11029

- Make holes for the GS plug weld seam or cut the new part to size depending on the damage.
- Slightly grind out the welding surfaces -1-.



Note

The new part must be welded within 90 minutes as otherwise the adhesion of the glue may be poor.



- Make sure the adhesive areas are free of dust and grease.
- Apply 2K epoxy adhesive - DA 001 730 A2- .

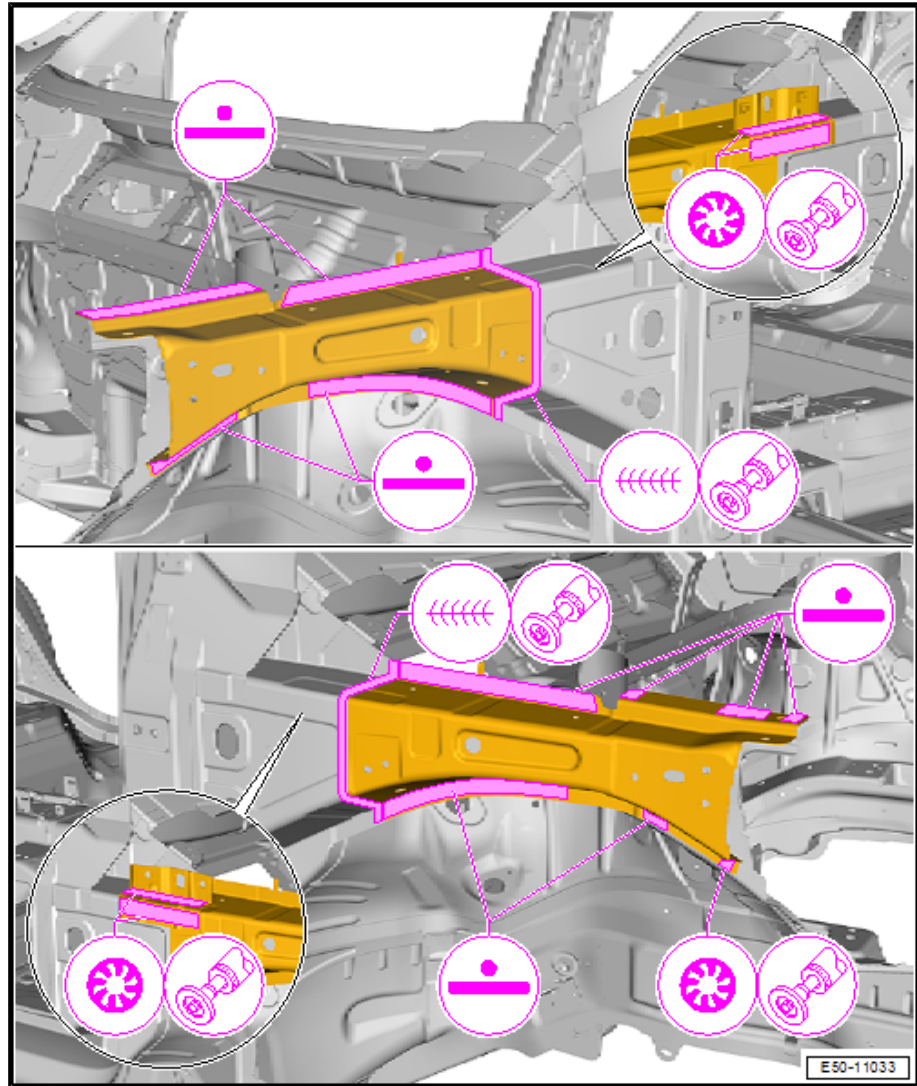
4.3 Part welding



Caution

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- Adjust the new part and fix. For this purpose, the vehicle is standing on its wheels or on the straightening bracket set .
- Weld in outside top frame side rail, RP spot weld seam and GS plug weld seam. Or weld the separation line, GS continuous seam.



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5 Replacing the inner top frame side rail

⇒ "5.1 Removing", page 41

⇒ "5.2 Preparing the new part", page 42

⇒ "5.3 Part welding", page 43

5.1 Removing

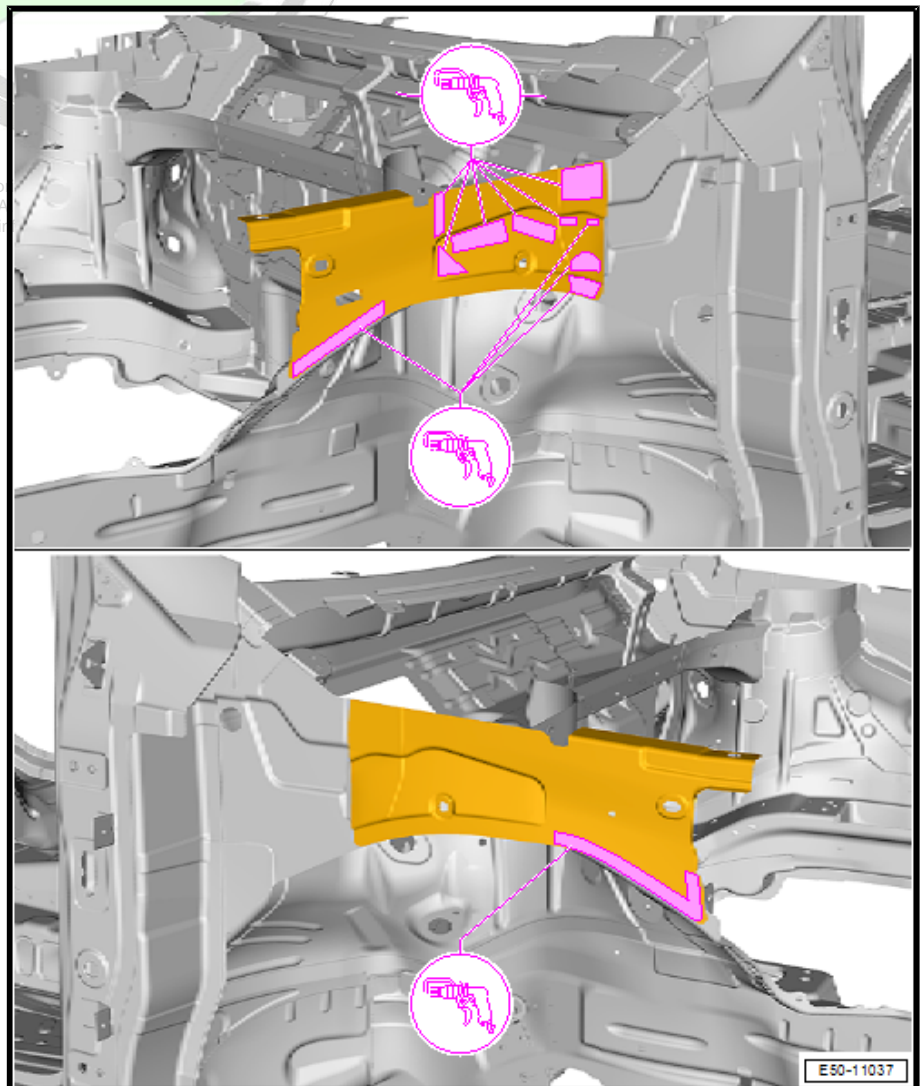


Caution

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Outer top frame side rail already separated.

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- Loosen the original welding.
- Remove any residues.



5.2 Preparing the new part

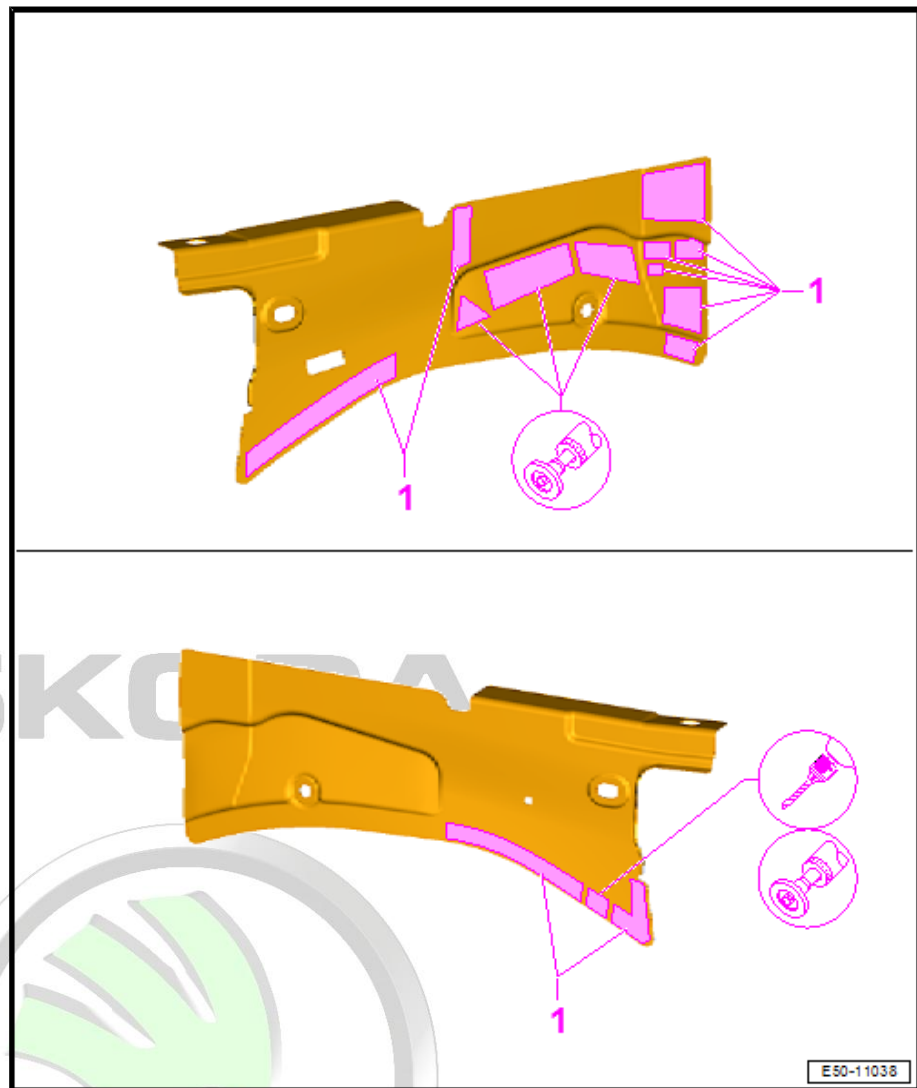


Caution

Follow the general notes! → General Information; Body Repairs, General Body Repairs

New part

- ◆ Inner top wheelhouse frame side rail
- ◆ 2K epoxy adhesive - DA 001 730 A2-



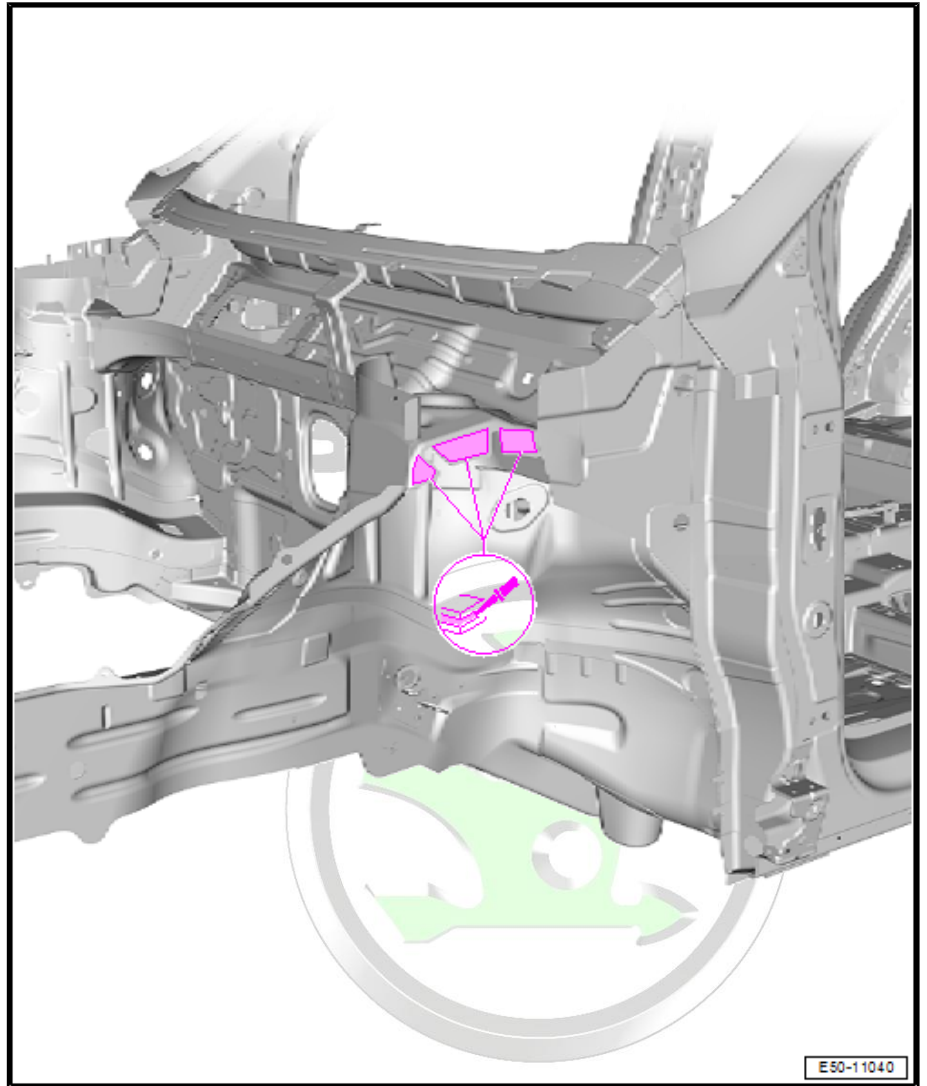
- Make holes for the GS plug weld seam.
- Slightly grind out the welding surfaces -1-.



Note

The new part must be welded within 90 minutes as otherwise the adhesion of the glue may be poor.

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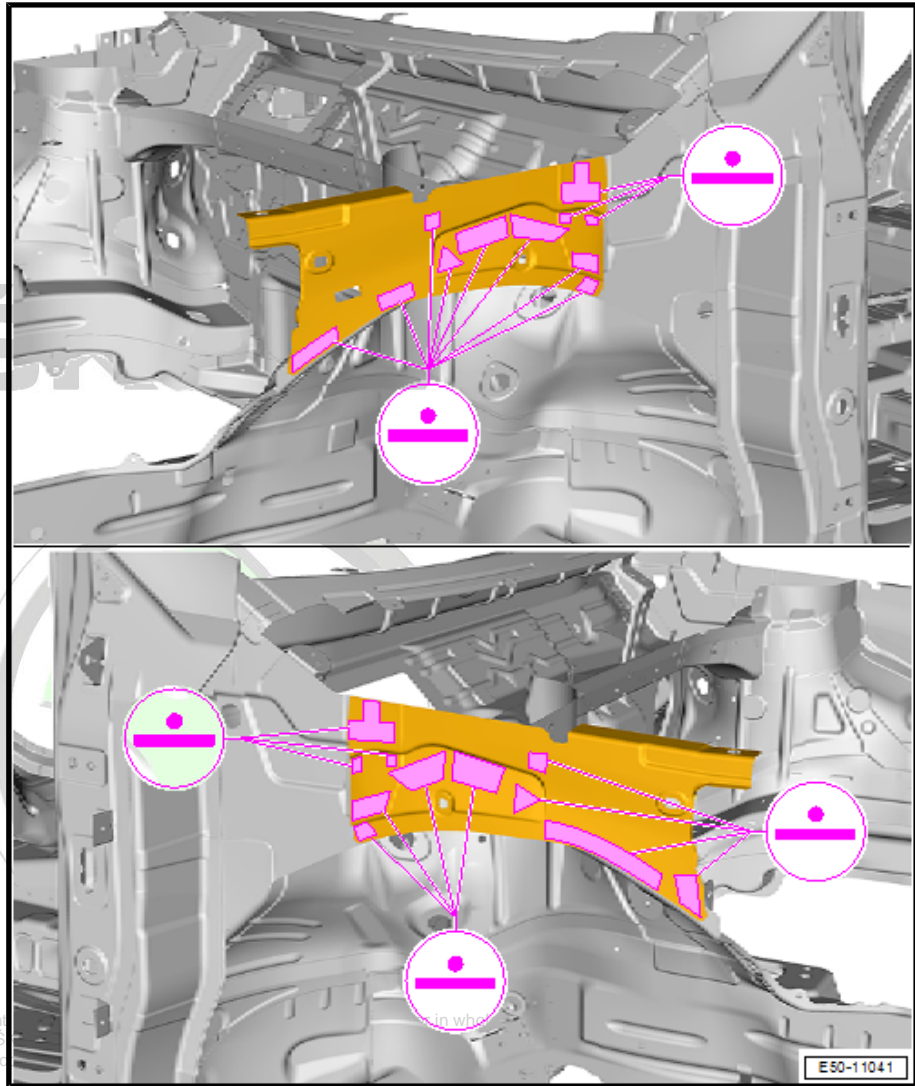
- Make sure the adhesive areas are free of dust and grease.
- Apply 2K epoxy adhesive - DA 001 730 A2- .

5.3 Part welding



Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs



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- Adjust the new part and fix. For this purpose, the vehicle is standing on its wheels or on the straightening bracket set .
- Check the fit with adjoining components.
- Weld in rear frame side rail, RP spot seam.

6 Replacing the front wheelhouse

⇒ "6.1 Summary of components", page 45

⇒ "6.2 Removing", page 46

⇒ "6.3 Preparing the new part", page 47

⇒ "6.4 Part welding", page 49

6.1 Summary of components



Caution

Follow the general notes! → General Information; Body Repairs, General Body Repairs

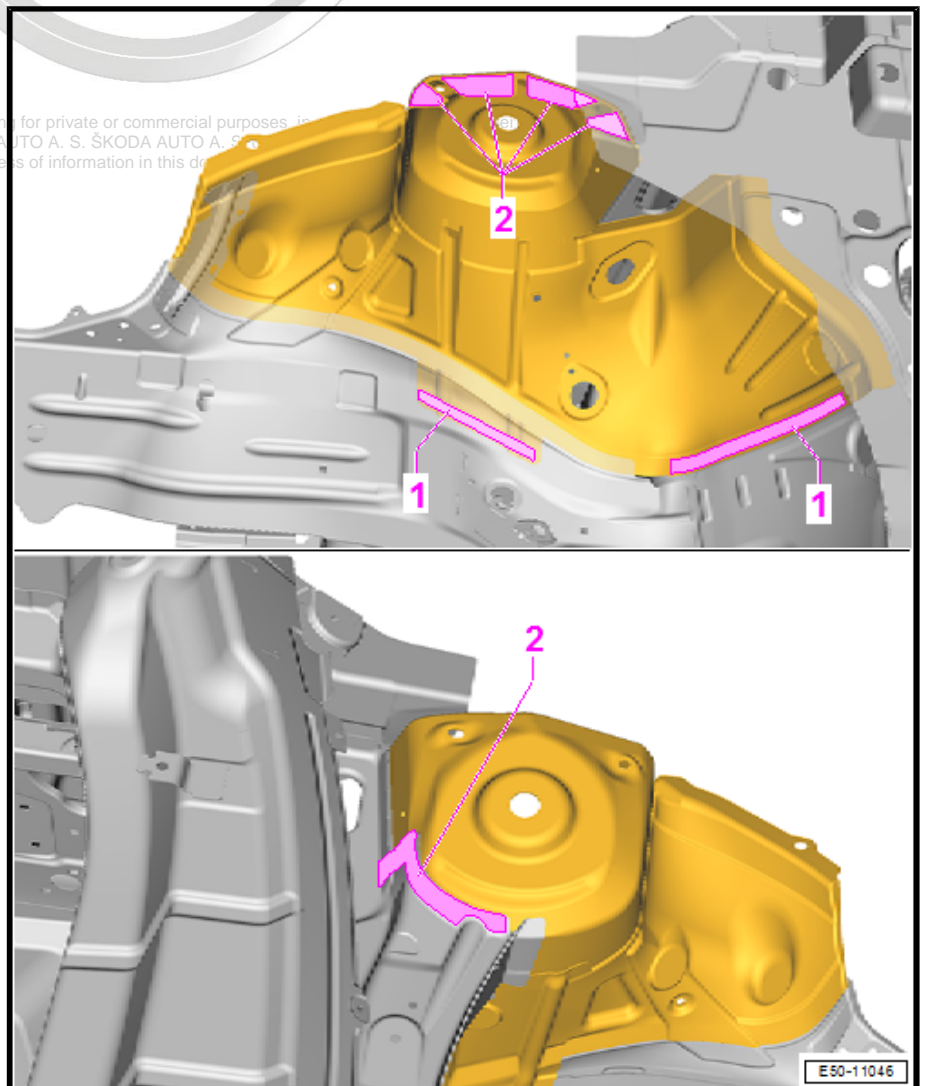
Inner upper frame side rail already separated.

1 - Adhesive area

- Front longitudinal member area

2 - Adhesive area

- Water box area



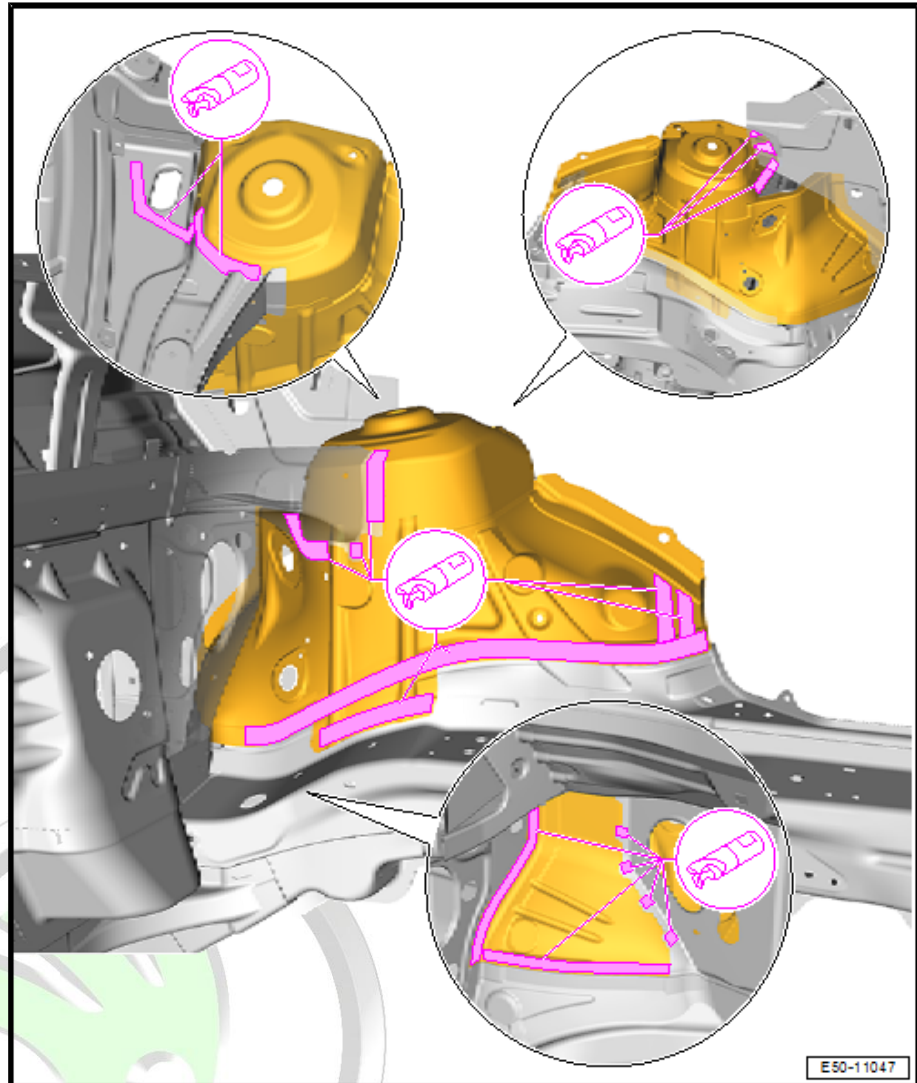


6.2 Removing



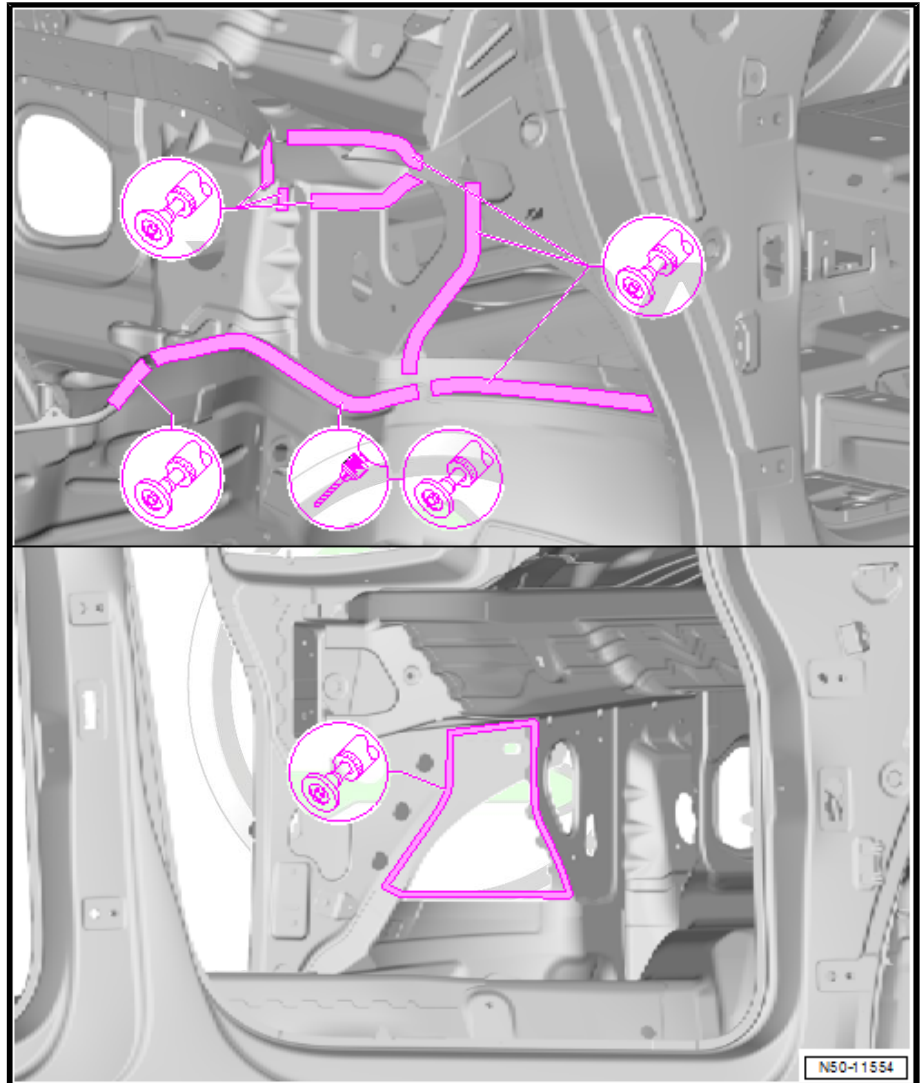
Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs



- Loosen the original welding.

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- Remove any residues.
- Slightly grind out the welding surfaces.
- Completely remove glue residues.
- Drill holes for the GS plug weld seam, \varnothing 8 mm.

6.3 Preparing the new part



Caution

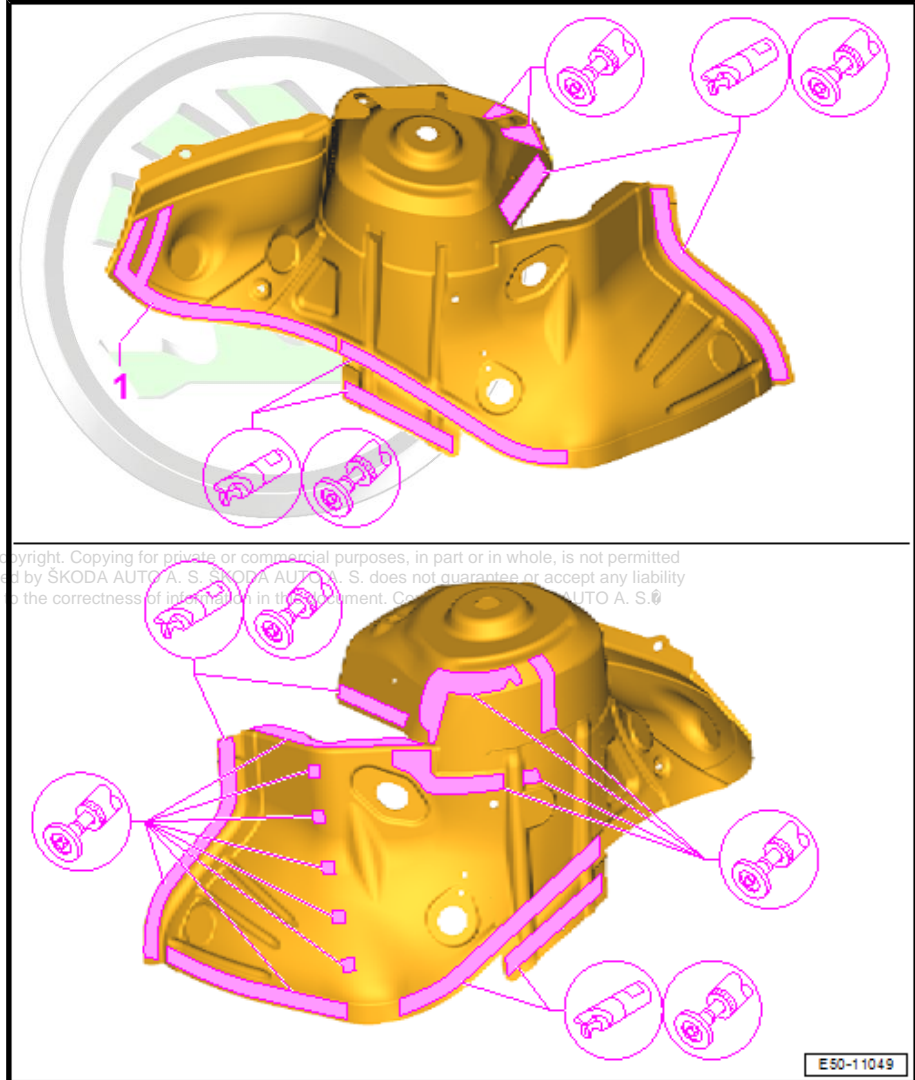
Follow the general notes! \Rightarrow General Information; Body Repairs, General Body Repairs

New part

- ◆ Front wheelhouse
- ◆ Reinforcement, wheelhouse
- ◆ 2K epoxy adhesive - DA 001 730 A2-

**Note**

The new part must be welded within 90 minutes as otherwise the adhesion of the glue may be poor.



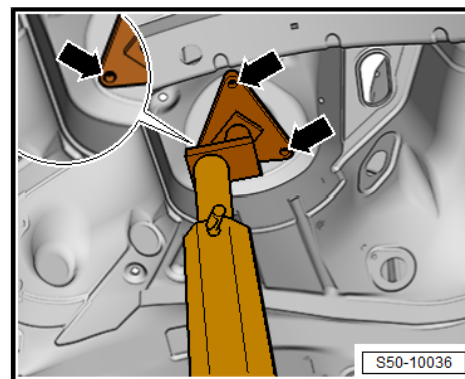
- Make holes for the GS plug weld seam.
- Slightly grind out the welding surfaces -1-.
- Make sure the adhesive areas are free of dust and grease.
- Apply 2K epoxy adhesive - DA 001 730 A2- in factory-set areas.
- Adjust the new part and fix. For this purpose, the vehicle is standing on the straightening bracket set .

**Note**

The detailed information can be found in the design plan enclosed with the straightening bracket set.

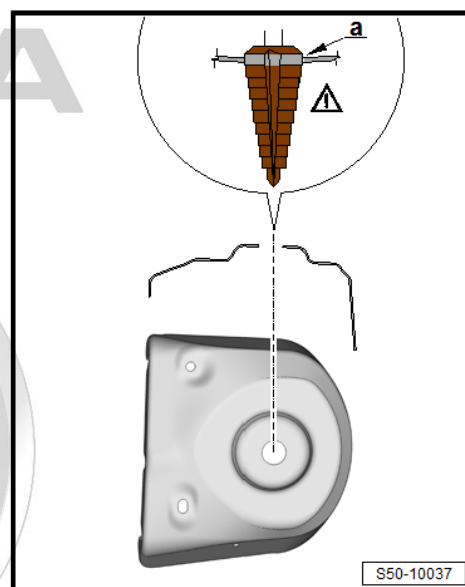
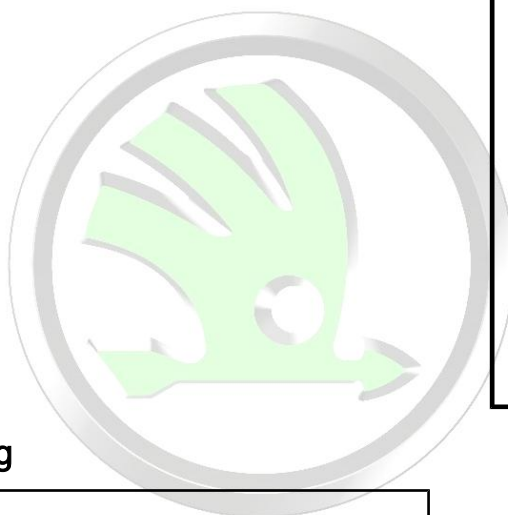


- Mark 3 holes -arrows- for shock absorber mounting straightening bracket set .
- Remove straightening bracket set .
- Drill 3 holes for shock absorber mounting, \varnothing 10 mm.



- Increase size of hole e.g. with a step drill, -a- \varnothing 34 mm.

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6.4 Part welding

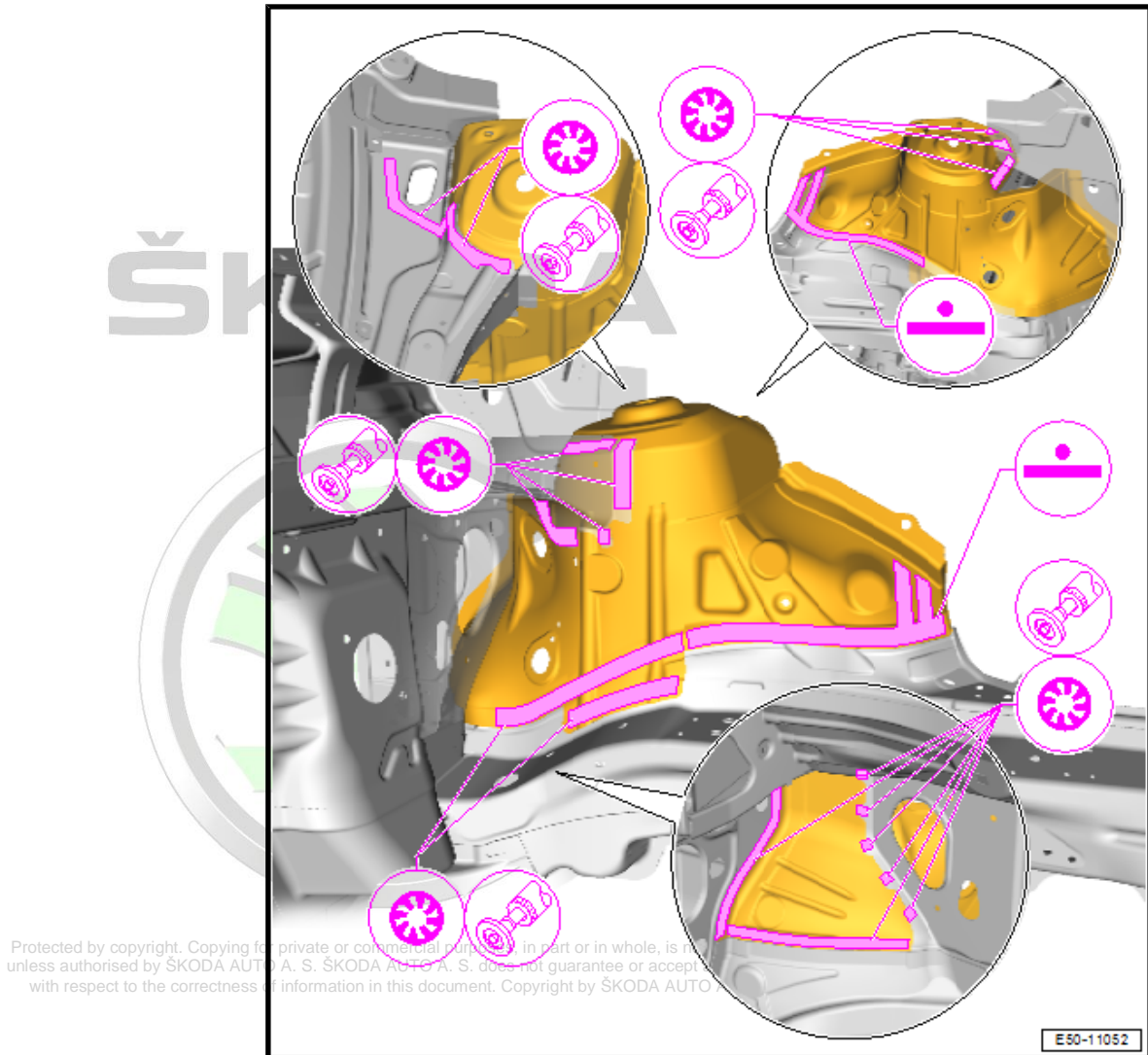


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- Adjust the new part and fix. For this purpose, the vehicle is standing on the straightening bracket set .



- Adjust the new part and fix. For this purpose, the vehicle is standing on the straightening bracket set .
- Check the fit with adjoining components.
- Weld in the new part, RP spot seam and inert gas shielded plug weld.



7 Replacing the front wheelhouse - part-

⇒ [“7.1 Summary of components”, page 51](#)

⇒ [“7.2 Removing”, page 52](#)

⇒ [“7.3 Preparing the new part”, page 52](#)

⇒ [“7.4 Part welding”, page 53](#)

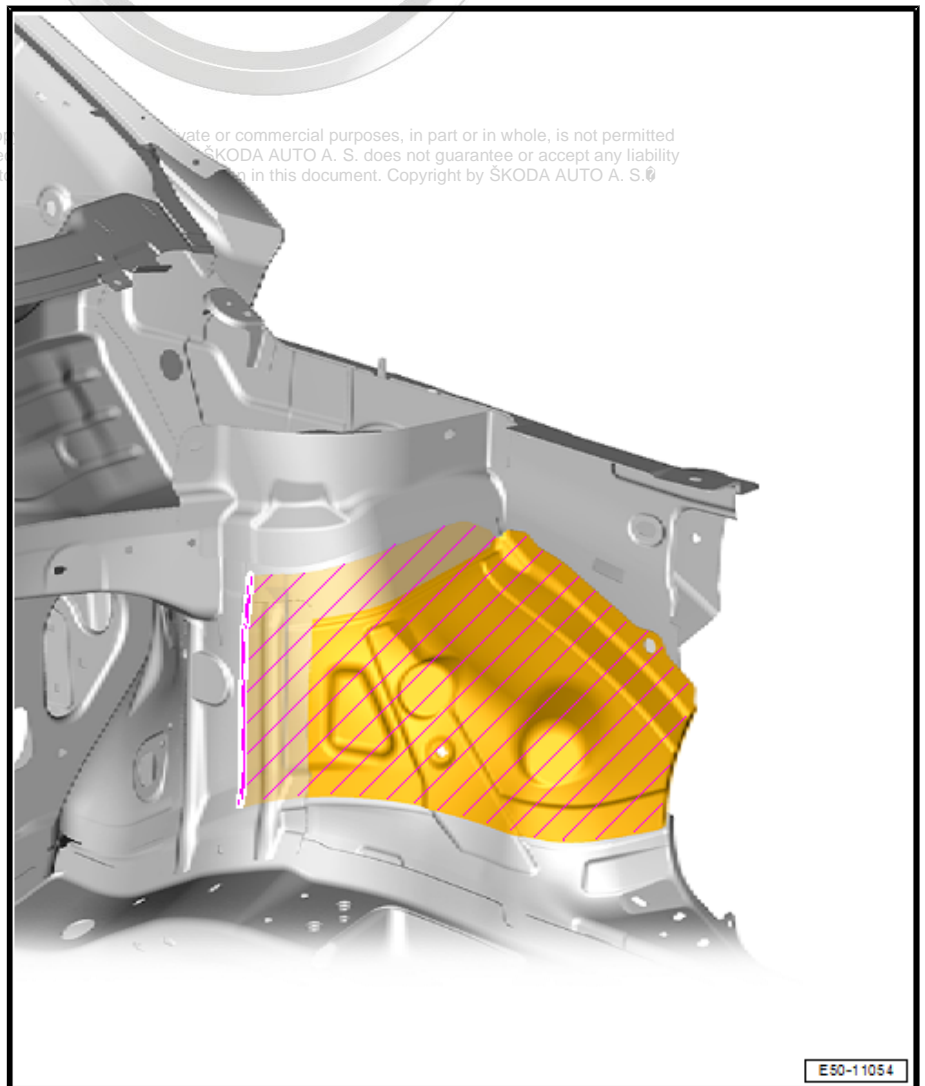
7.1 Summary of components



Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs

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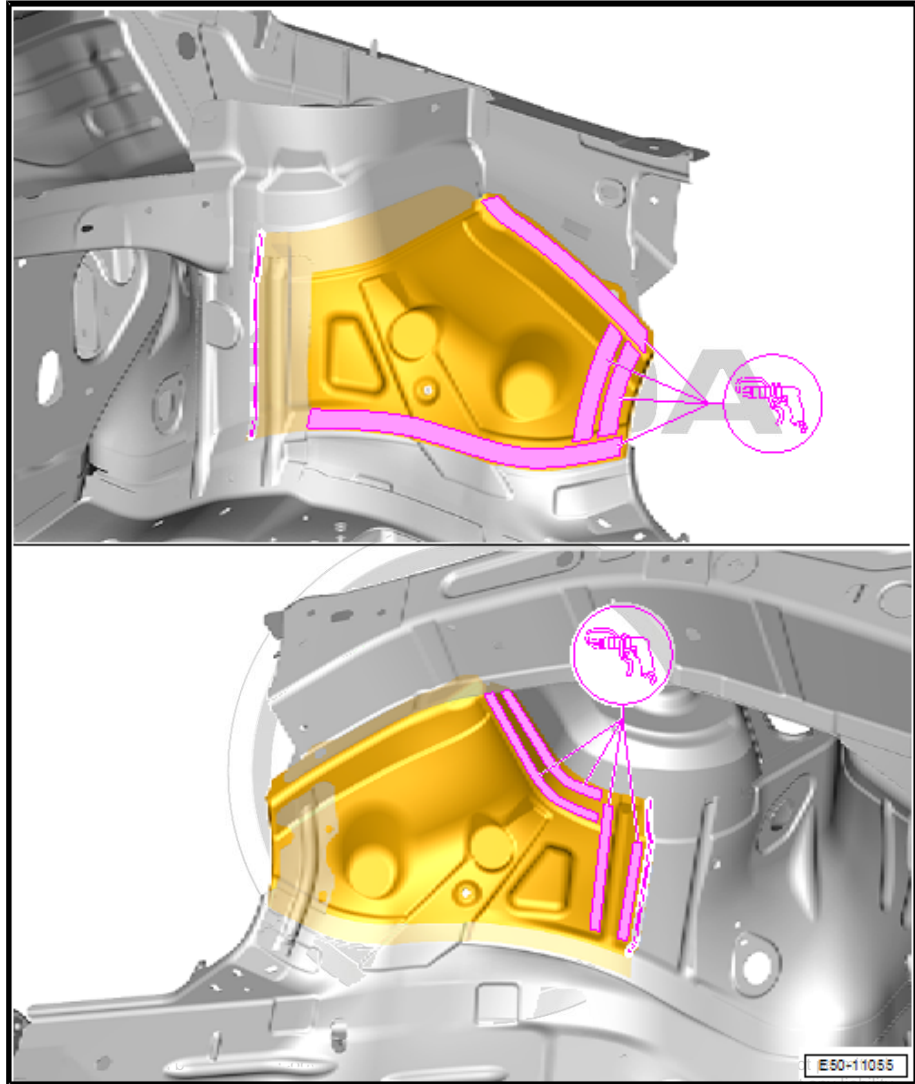


7.2 Removing



Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs



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- Loosen the original welding.
- Remove any residues.

7.3 Preparing the new part

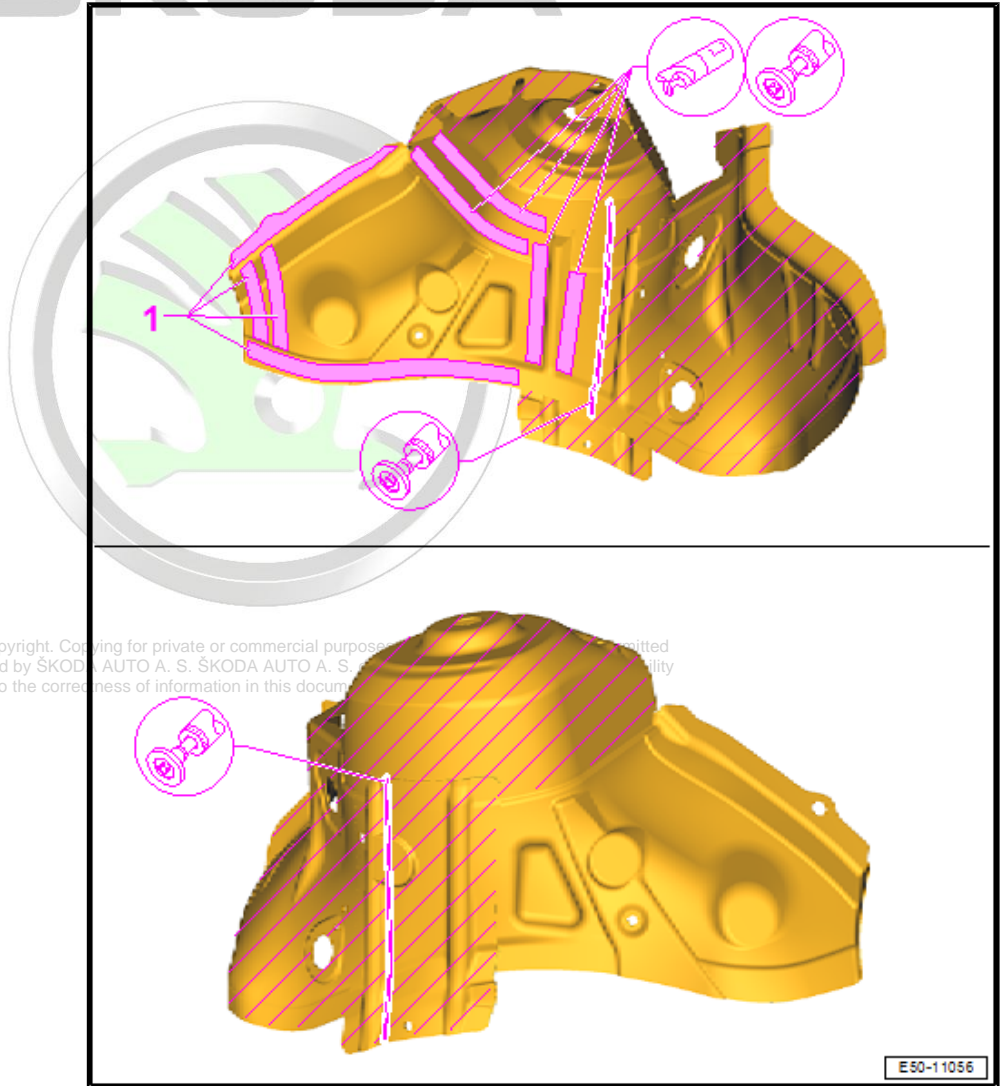


Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs

New part

- ◆ Front wheelhouse, part



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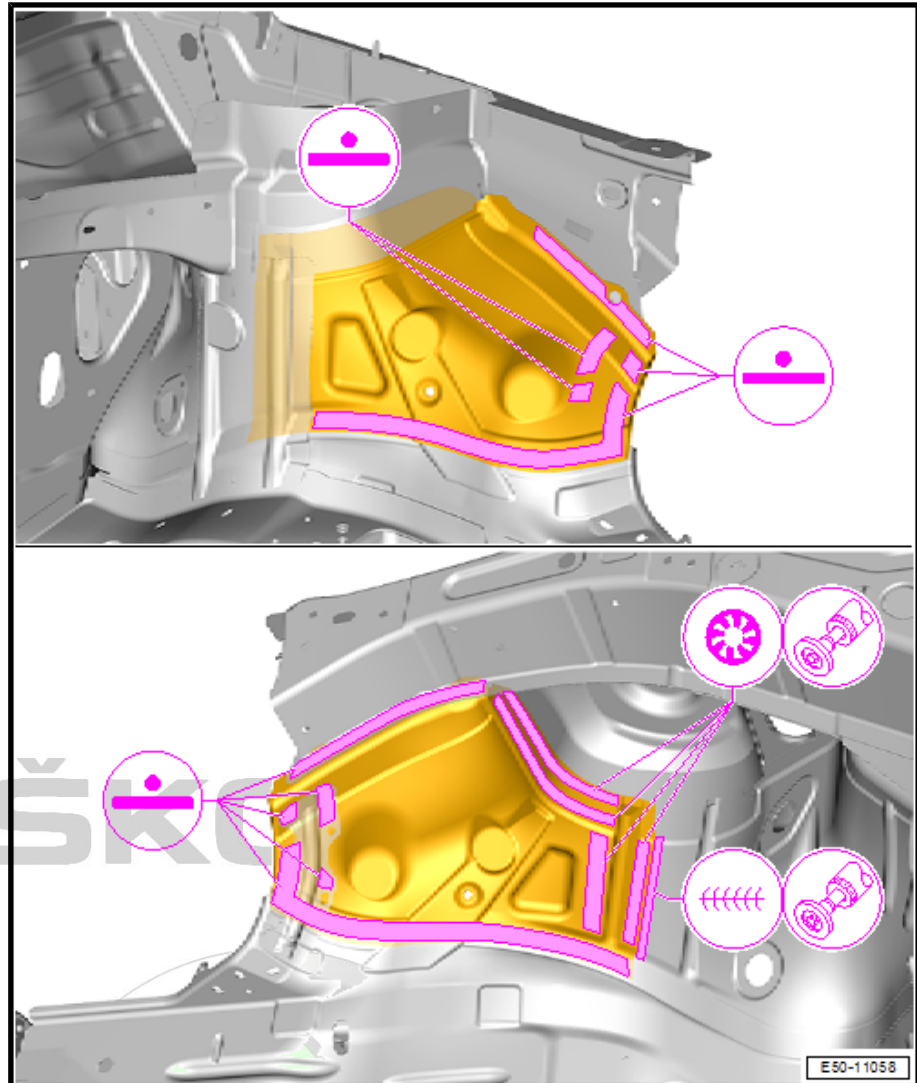
- Create holes for the GS plug weld seam, \varnothing 8 mm.
- Slightly grind out the welding surfaces -1-.

7.4 Part welding



Caution

Follow the general notes! \Rightarrow General Information; Body Repairs, General Body Repairs



- Adjust the new part and fix. For this purpose, the vehicle is standing on the straightening bracket set .
- Check the fit with adjoining components.
- Weld in the new part, RP spot seam and GS plug weld seam (inert gas shielded).
- Butt weld the separation cut as a GS continuous seam.

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8 Replacing front frame side rail -part-

⇒ "8.1 Removing", page 55

⇒ "8.2 Preparing the new part", page 56

⇒ "8.3 Part welding", page 57

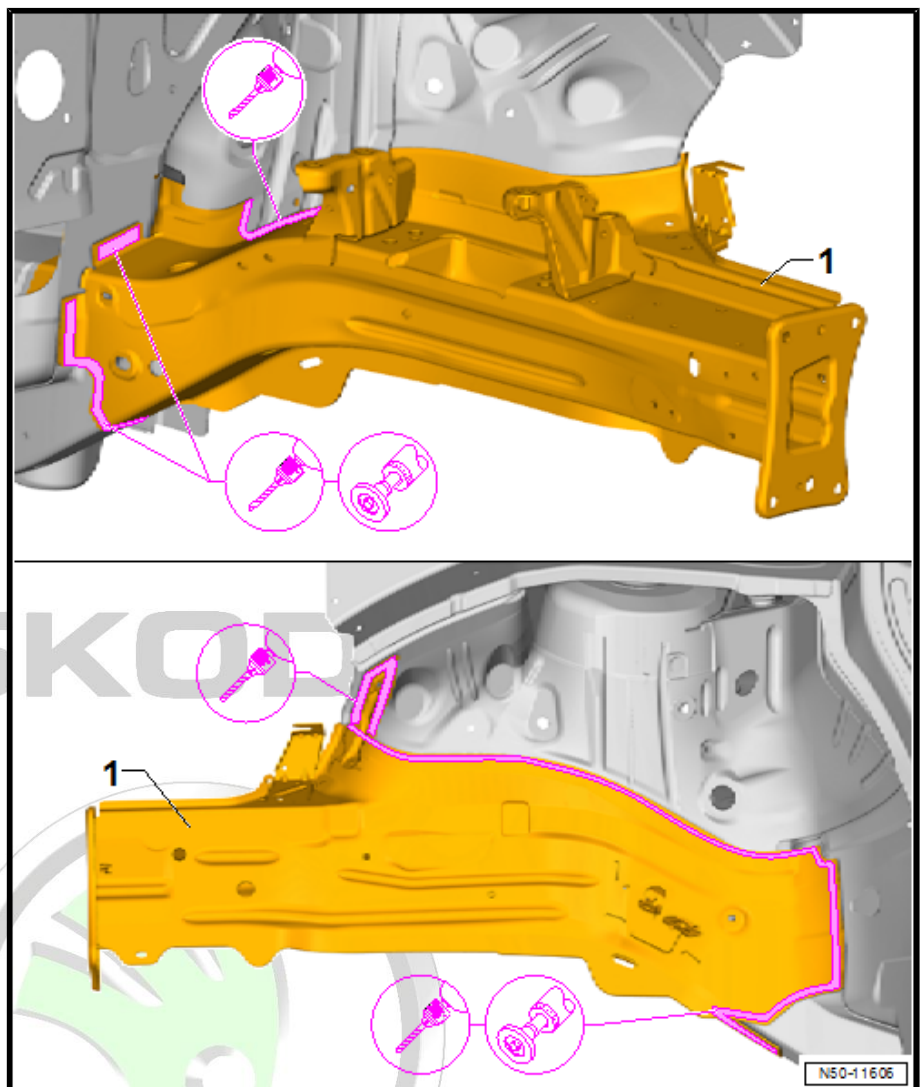
8.1 Removing



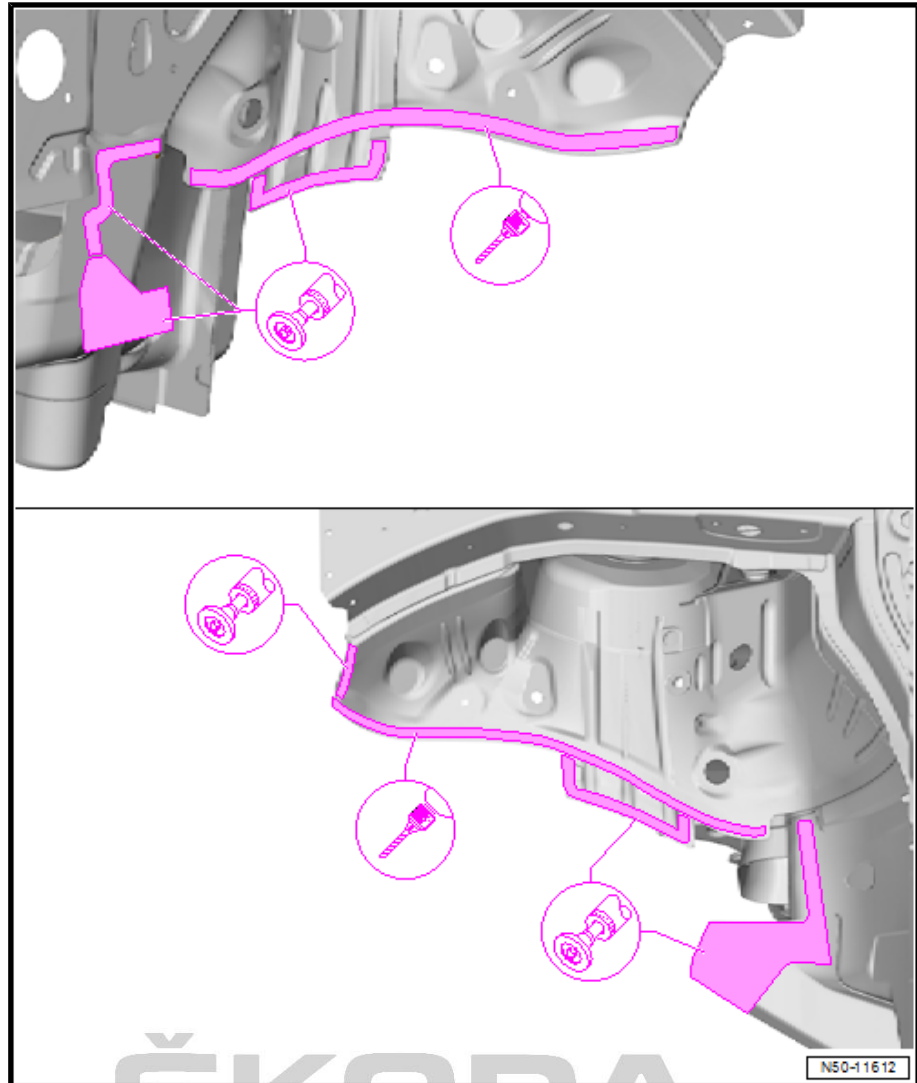
Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs

Support block for assembly carrier already removed.



– Detach original welding for front frame side rail -1-.



- Remove any residues.
- Slightly grind out the welding surfaces.
- Drill holes for the GS plug weld seam, \varnothing 8 mm.

8.2 Preparing the new part



Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs

New part

- ◆ Frame side rail

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1 - Front frame side rail

- Carefully detach frame side rail reinforcement -4- and support block for assembly carrier -3-. Use these parts for reinstallation.
- Separate rear section.

2 - Headlight holder

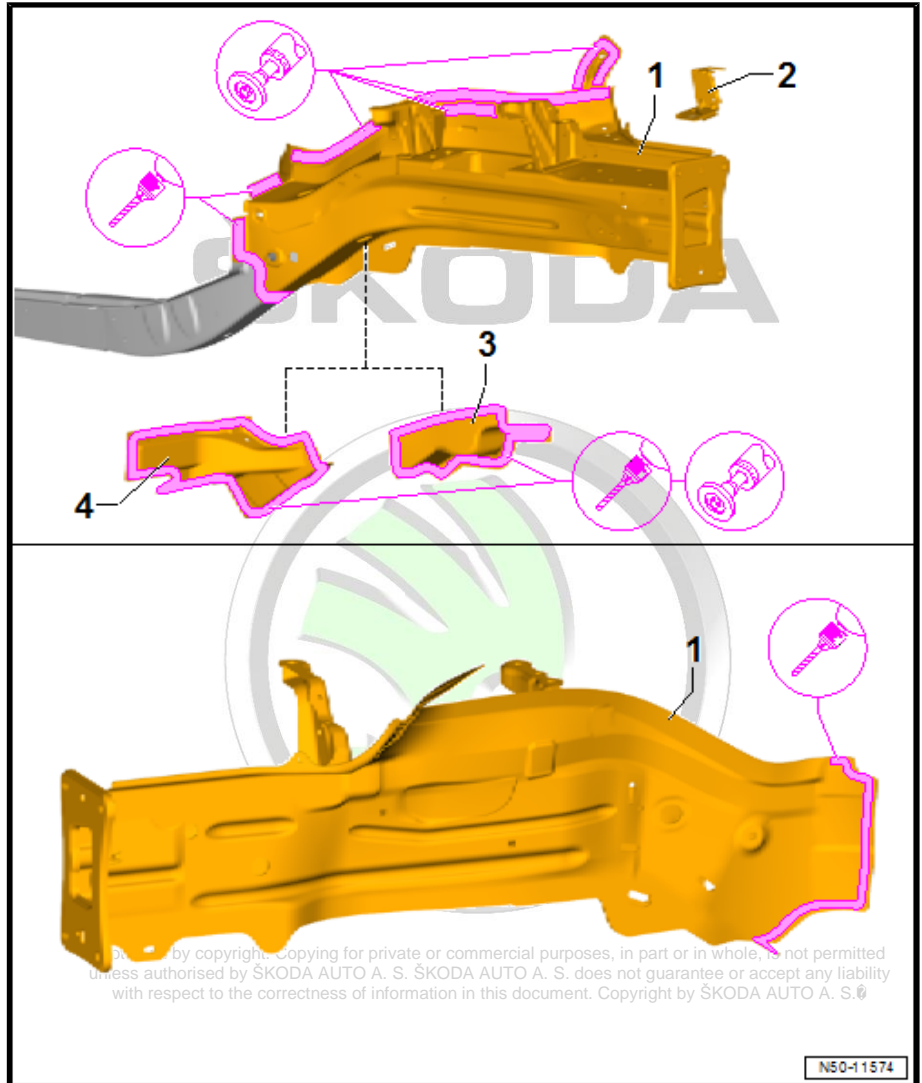
- Not included under spare parts for frame side rail, use if necessary

3 - Support block for assembly carrier

- Detach from frame side rail.
- cannot be detached from frame side rail without being destroyed.
- to install the front frame side rail unit again, order separately and also use
- Drill holes for the GS plug weld seam, \varnothing 8 mm.

4 - Frame side rail reinforcement

- Detach from frame side rail.
- cannot be detached from frame side rail without being destroyed.
- to install the front frame side rail unit again, order separately and also use
- Drill holes for the GS plug weld seam, \varnothing 8 mm.

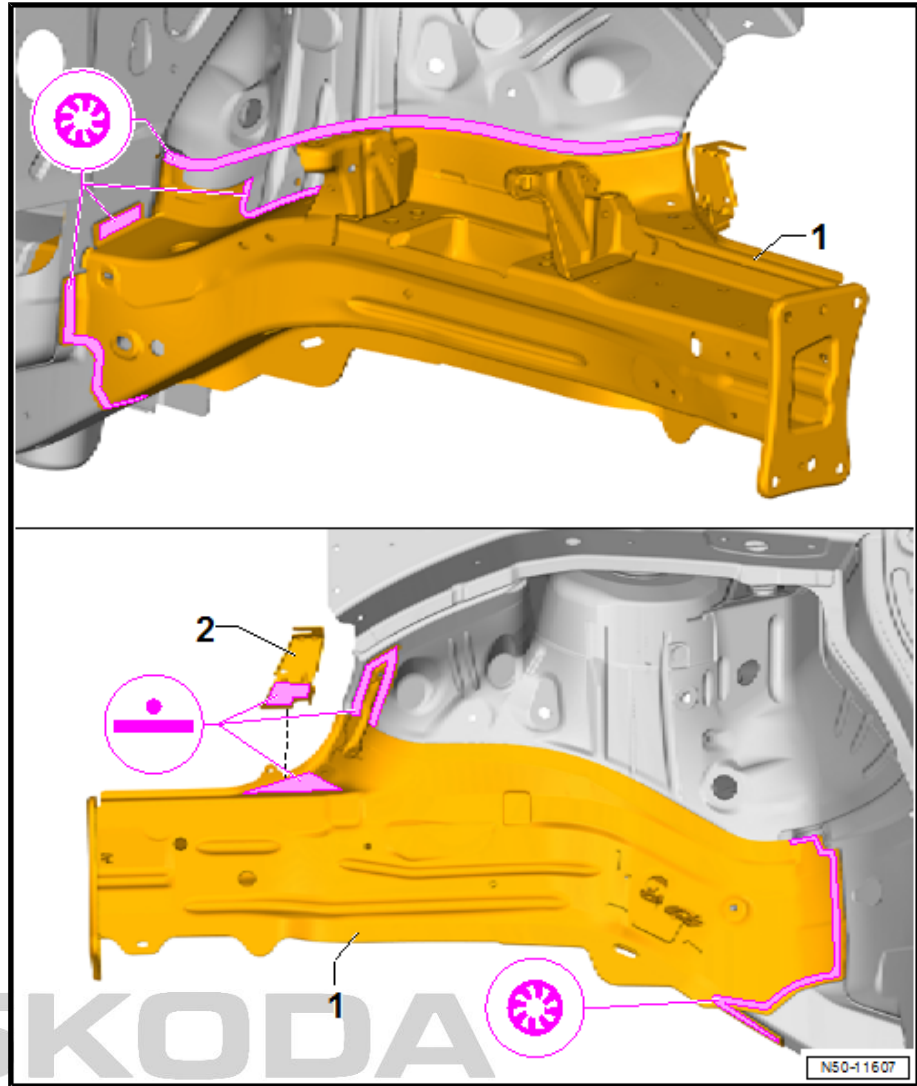


8.3 Part welding



Caution

Follow the general notes! \Rightarrow General Information; Body Repairs, General Body Repairs



- Adjust the new part and fix. For this purpose, the vehicle is standing on the straightening bracket set .
- Check the fit with adjoining components.
- Weld in front frame side rail -1-, GS plug weld seam (shielding gas) and RP spot weld seam.
- Fit and attach the headlight holder -2-.
- Weld in headlight holder -2-, RP spot weld seam.

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9 Replacing front frame side rail -part-

⇒ ["9.1 Summary of components", page 59](#)

⇒ ["9.2 Removing", page 60](#)

⇒ ["9.3 Preparing the new part", page 61](#)

⇒ ["9.4 Part welding", page 62](#)

9.1 Summary of components



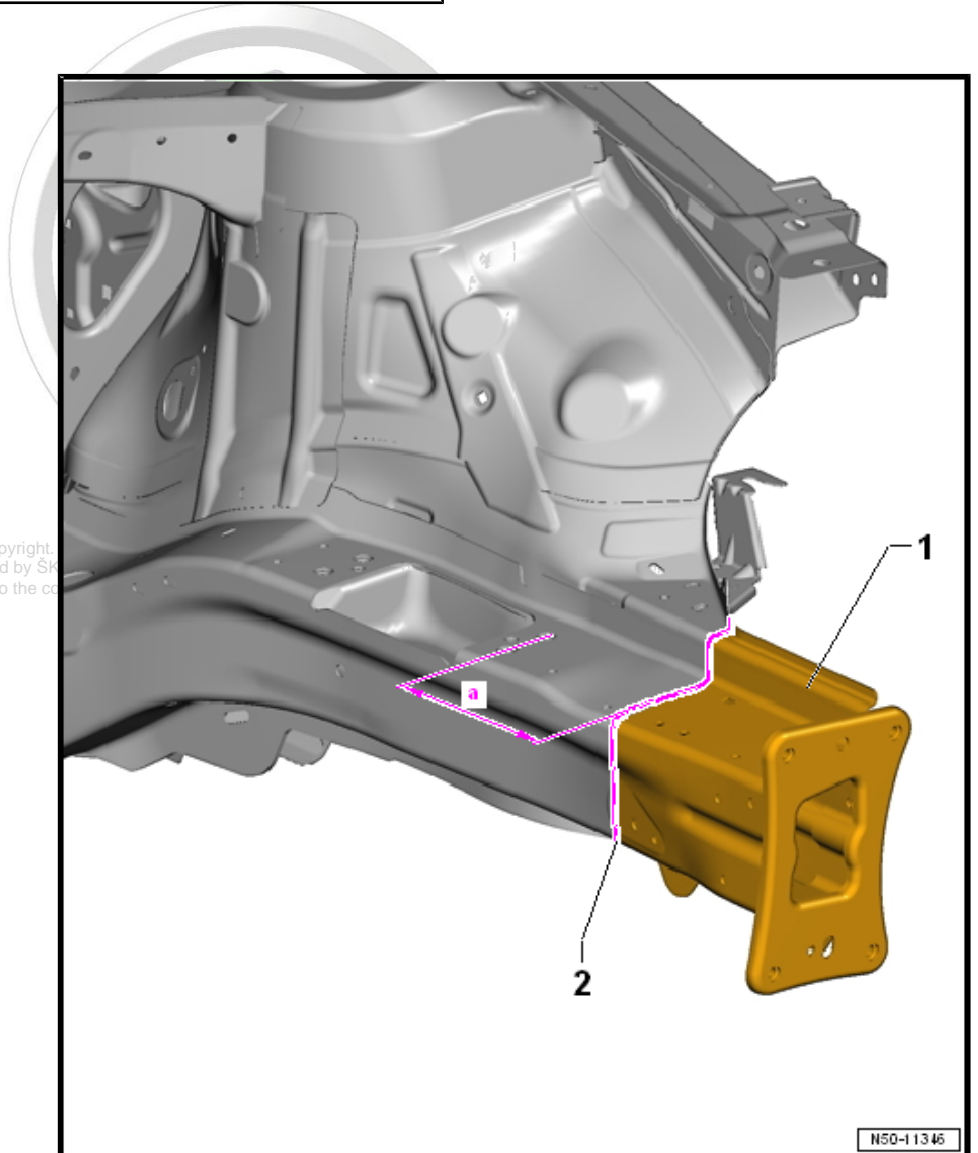
Caution

Follow the general notes! → General Information; Body Repairs, General Body Repairs

1 - Front frame side rail

2 - Separation cut

□ -a- = 110 mm



N50-11346

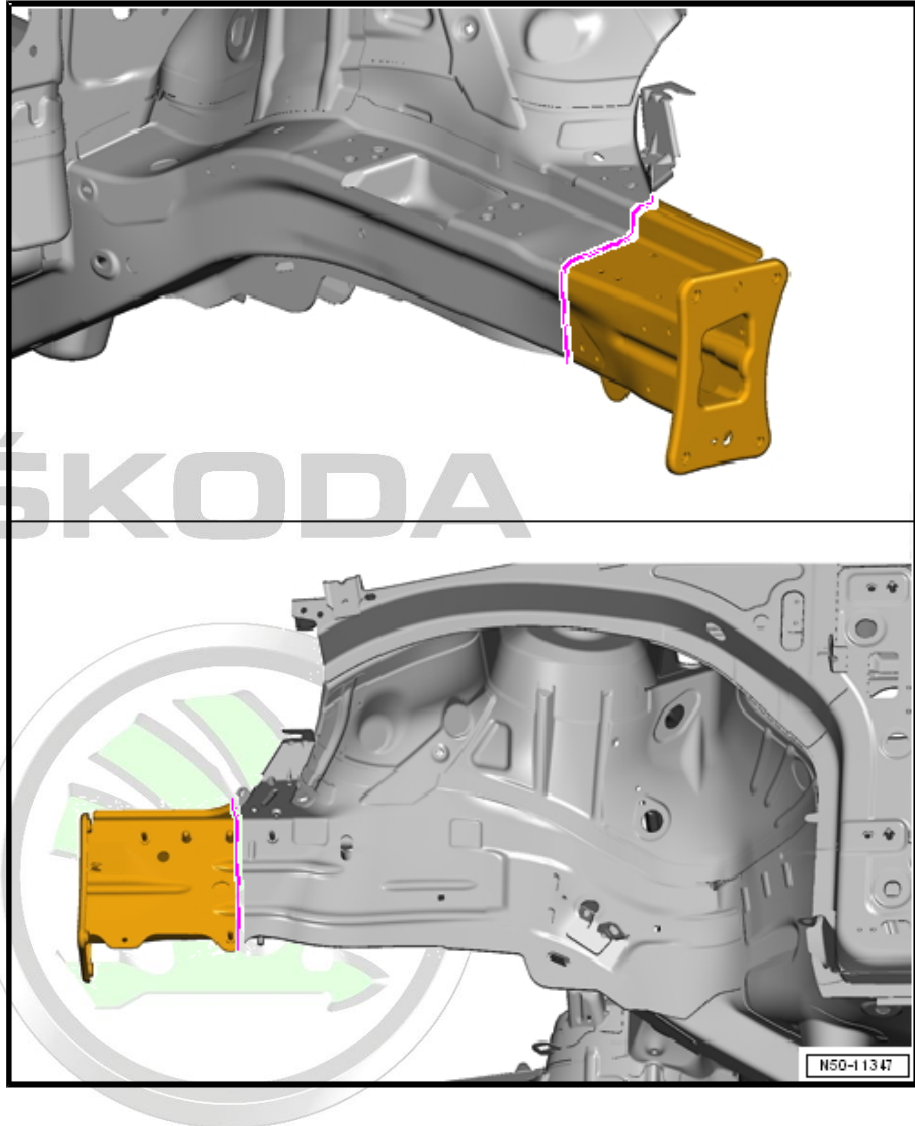


9.2 Removing



Caution

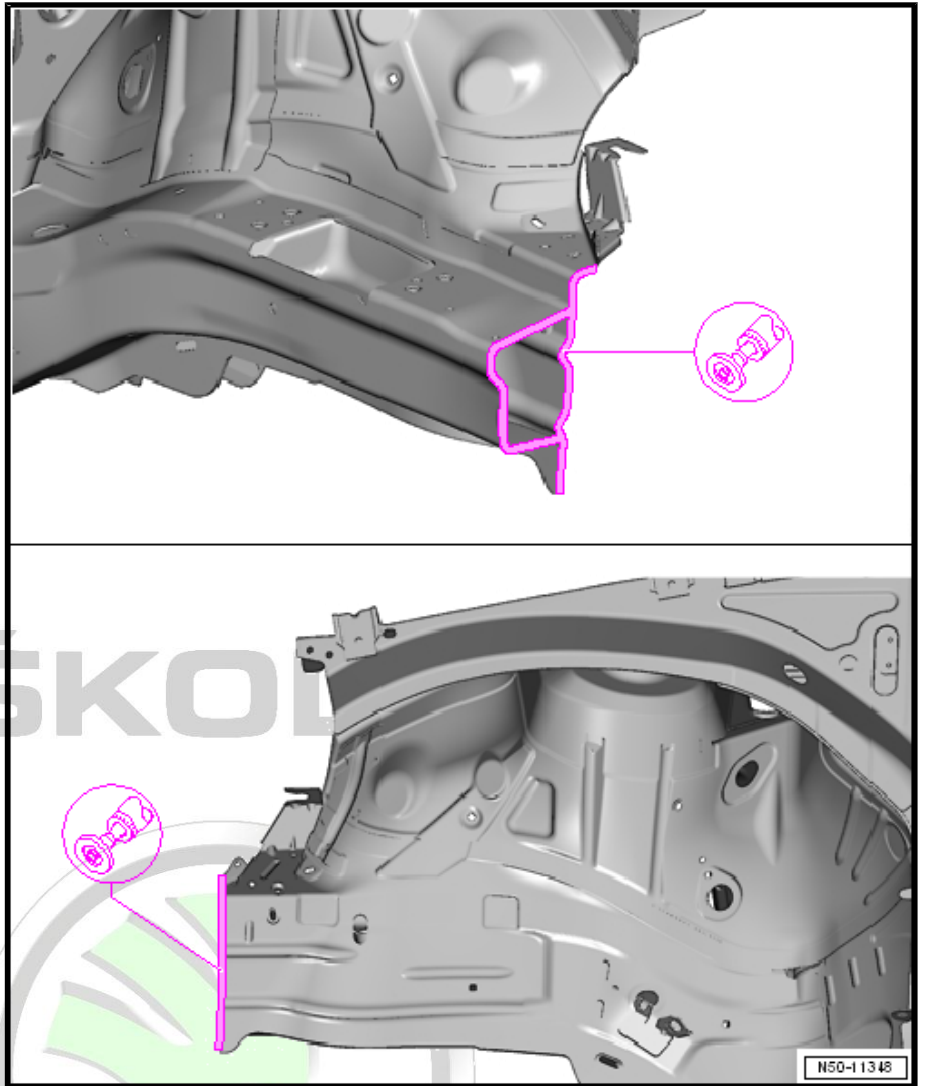
Follow the general notes! => General Information; Body Repairs, General Body Repairs



- Place and carry out the separation cuts.

110 mm

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- Remove any residues.

9.3 Preparing the new part

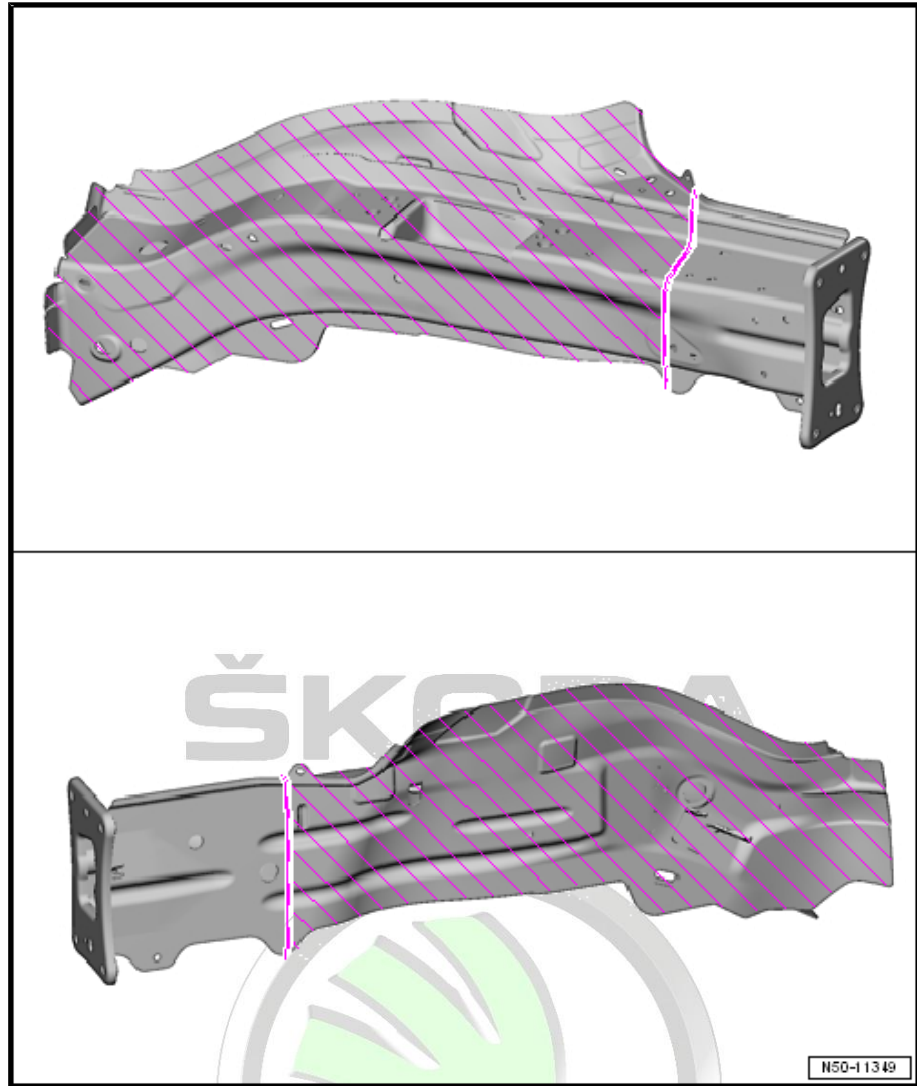


Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs

New part

- ◆ Front frame side rail



- Transfer separating cut to new part and cut to the required dimensions.

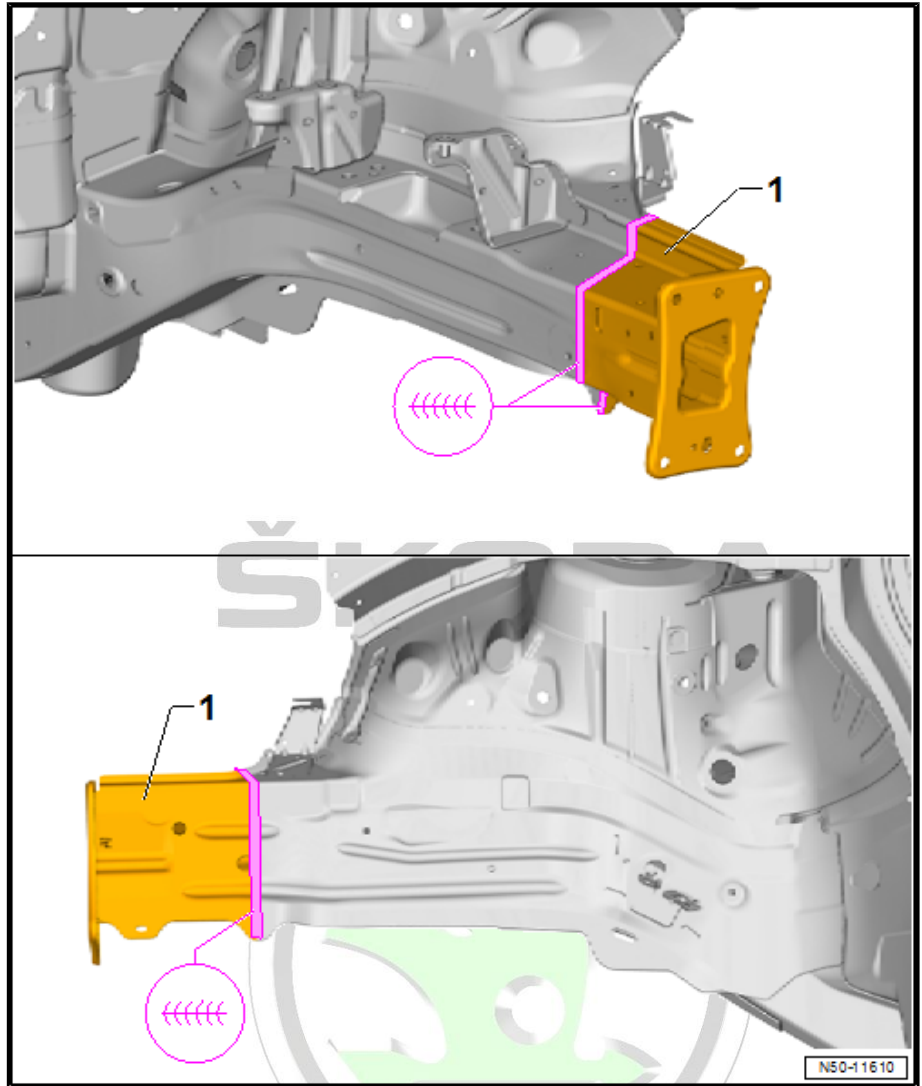
9.4 Part welding



Caution

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- Fit and fix the new part -1-. For this purpose, the vehicle is standing on the straightening bracket set .
- Butt weld the separation cut as a GS continuous seam.
- Weld the remaining joint, RP spot seam.

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51 – Body - centre

1 Replacing the roof

⇒ [“1.1 Tools”, page 64](#)

⇒ [“1.2 Removing”, page 64](#)

⇒ [“1.3 Preparing the new part”, page 66](#)

⇒ [“1.4 Setting roof countersinking”, page 68](#)

⇒ [“1.5 Gluing in the roof”, page 69](#)

⇒ [“1.6 Part welding”, page 81](#)

1.1 Tools

Special tools and workshop equipment required

- ◆ E.g. compressed air pistol - V.A.G 1761/1-
- ◆ E. g. cartridge heater - V.A.G 1939 A-
- ◆ E. g. double cartridge gun - VAS 5237-
- ◆ E.g. setting gauge - 3371-
- ◆ E.g. tensioning strap - T10038-
- ◆ E.g. suction cup - V.A.G 1344-
- ◆ E.g. electric knife - V.A.G 1561/A- and e.g. cutting discs - V.A.G 1361/25- if required. -V.A.G 1361/26- .
- ◆ E.g., milling machine for cutting the laser welding seam - VAS 6319- .

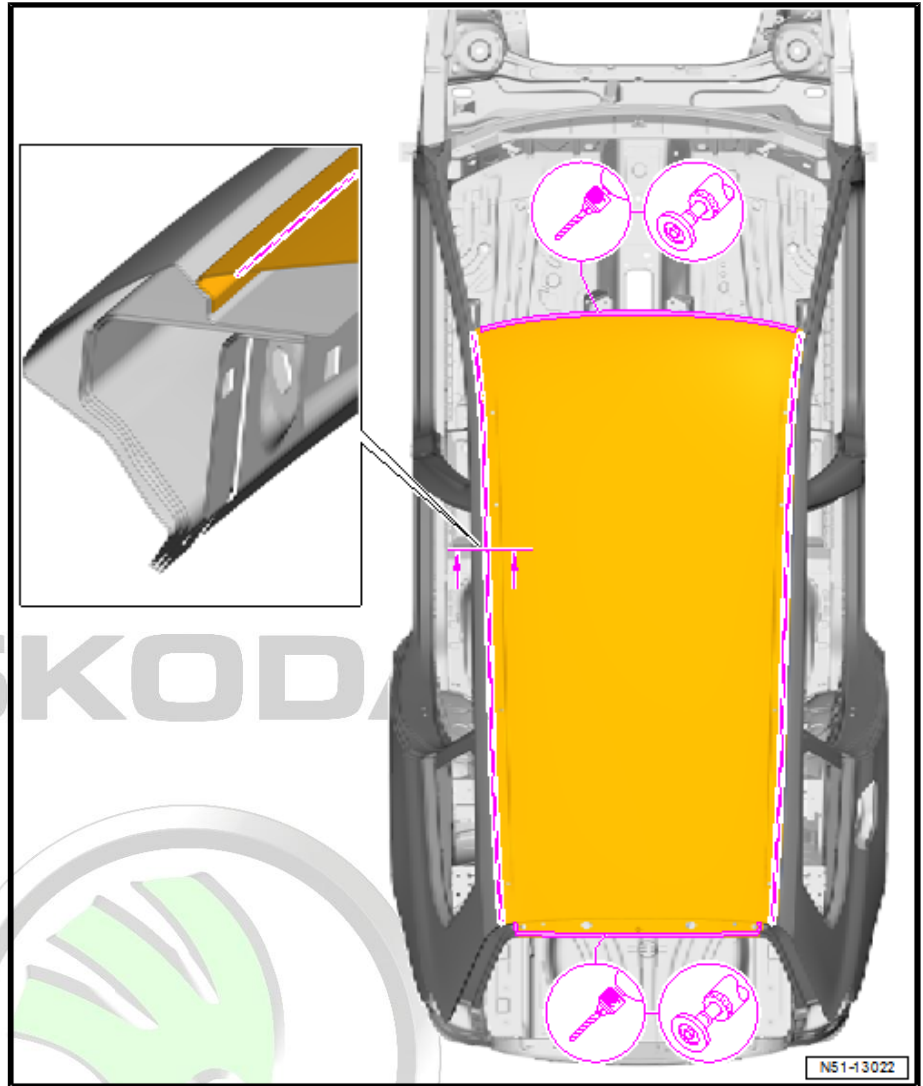
1.2 Removing



Note

- ◆ *Attach textile adhesive tape to the left and right of the roof frame rail parallel to the laser soldered seams. This reduces the risk of damage and contamination during the repair.*
- ◆ *When cutting, observe a distance of 15 mm from the roof frame rail so that it is not damaged during work.*
- ◆ *When carrying out the separation cuts, ensure that the panels located at the rear are not damaged.*

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- Cut out the roof roughly parallel to the laser soldered seams.
- Loosen the original welding with centre roof cross member.
- Loosen the original welding with the rear roof cross member.
- Remove the roof from the body.



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- ◆ *When removing the rest of the roof, the roof frame rail must not be damaged.*
- ◆ *Do not use any cutting or grinding discs.*
- Carefully cut through laser welding seam with cutter with sawing disk across the entire length.
- Remove roof residues on both sides.
- Carefully remove the material residue from the soldered seams on the left and right of the roof frame rails.
- Remove all residues of adhesive and sealing compound from the roof cross members and roof reinforcements.



1.3 Preparing the new part



Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs

New part

- ◆ Roof
- ◆ 1K assembly glue - D 190 MKD A3- (approx. 2 cartridges)
- ◆ 2K body glue - D 180 003 M2- (approx. 4 sets of cartridges)
- ◆ Glue sealing mass - AKD 476 KD5 05-
- ◆ Hollow space sealing - AKR 321 M15 4-



Note

- ◆ *In order to ensure a perfect and permanent roof repair, it is absolutely essential to comply with the following work procedure.*
- ◆ *At this point, we must emphasise the duty of care while carrying out this repair in order to exclude any possible faulty workmanship.*

- Thoroughly degrease contact surfaces to be ground before grinding.
- Grind off the adhesive surfaces on the left and right of the door frame that come into contact with the 2K body adhesive to achieve flawless adhesive adhesion.
- Carefully degrease the contact surfaces on the door frame after grinding.

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- Thoroughly degrease contact surfaces to be ground on the roof before grinding.
- Slightly grind the left and right adhesive surfaces on the roof that come in contact with 2K body adhesive .

This ensures that the 2K body glue - D 180 003 M2- can form a good bonding with the adhesive surfaces.

- Thoroughly degrease the contact surfaces after grinding.
- 2 Attach the suction cup - V.A.G 1344- to the outside of the roof.
- Place the roof on the roof frames.
- Check fit of roof with sliding roof and tailgate.

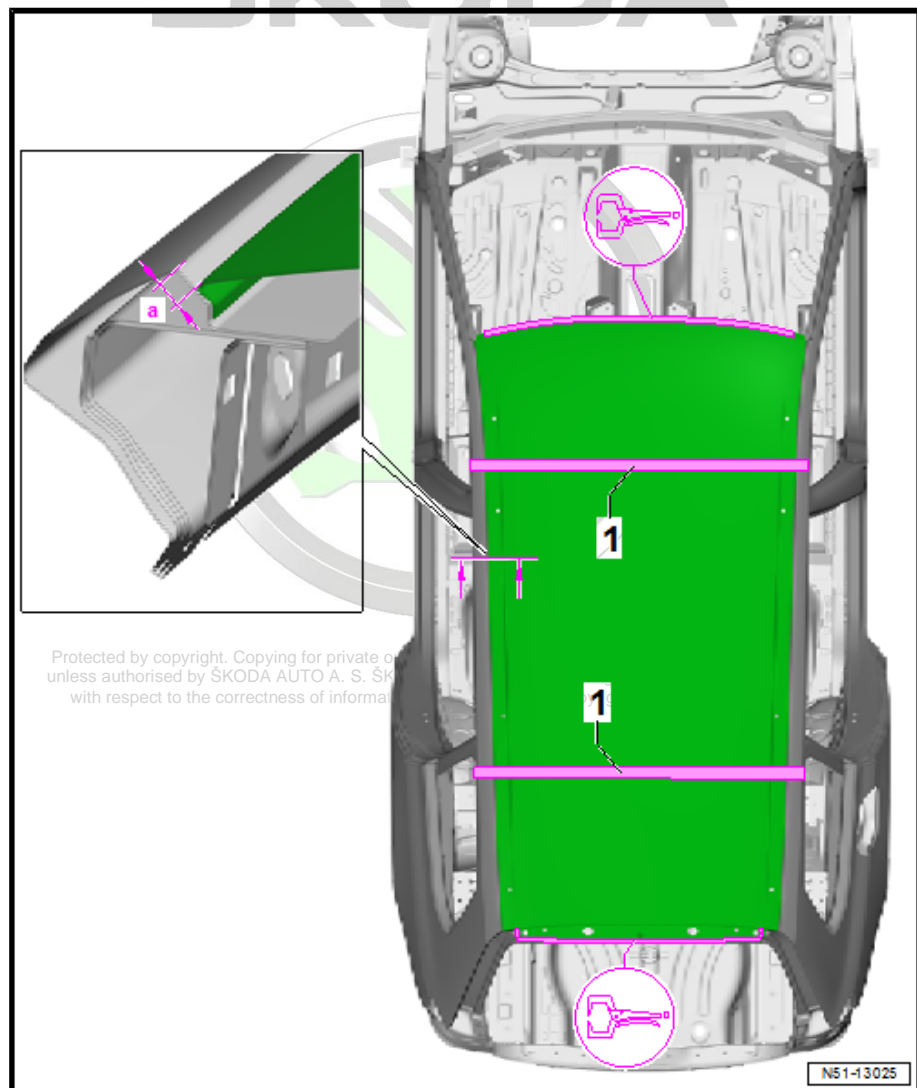


1.4 Setting roof countersinking



Note

- ◆ The tensioning straps -1- prevent the roof from lifting off the roof frame or sliding during the gluing procedure.
- ◆ The tensioning straps must not be tightened too firmly, in order to avoid damage.
- ◆ The dimension -a- can be determined by tensioning or loosening the tensioning straps because the roof must lie lower in relation to the side parts.
- ◆ Use the setting gauge - 3371- to check dimension -a-.



- Adjust the new part and fix. For this purpose, the vehicle is standing on its wheels or on the straightening bracket set .
- Check the fit with component parts.
- Tension for example the tensioning straps - T10038- at right angles across the roof in the areas shown in order to vary the height of the roof.
- Fix roof on the window cutout for sliding roof and on the rear using the clamping tongs.



- Check the roof line to the roof rails.

Dimension -a- = 4.0 mm ± 0.5 mm

- If necessary put a few pieces of felt in place to balance the roof frame.

1.5 Gluing in the roof

⇒ "1.5.1 Without sliding roof", page 69

⇒ "1.5.2 With sliding roof", page 75

1.5.1 Without sliding roof



Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs

- Remove the roof.
- Thoroughly degrease and clean adhesive surfaces on the roof and the vehicle with silicone remover - LVM 020 100 A5- .



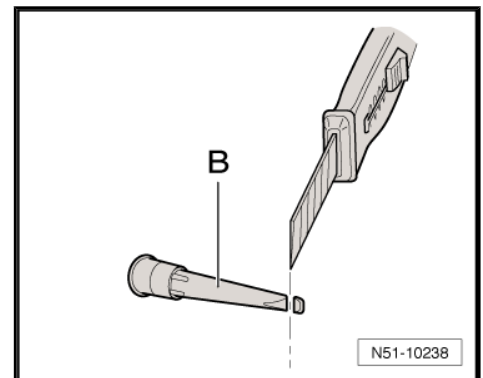
Note

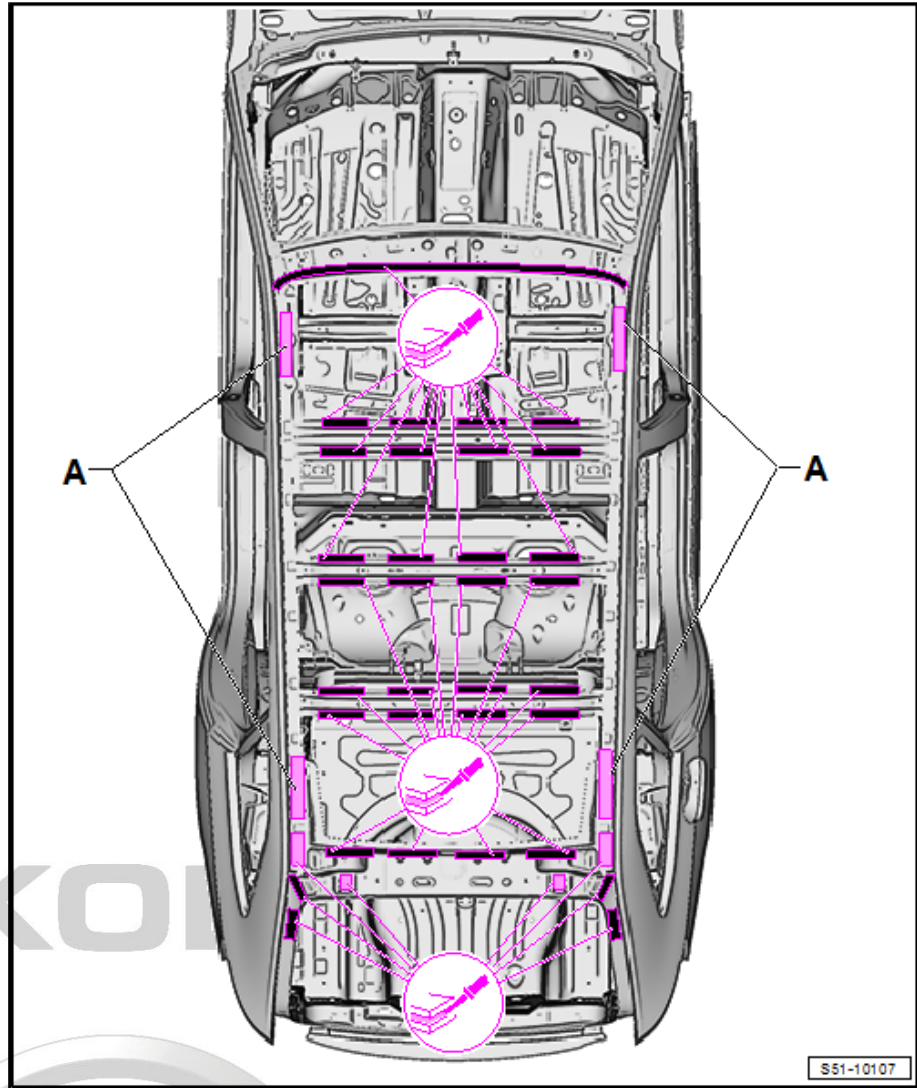
- ◆ *The adhesives must be applied very quickly.*
 - ◆ *The processing time must absolutely be observed.*
 - ◆ *Use the compressed air or electrical cartridge guns in order to apply the adhesive.*
- Cut off approx. 2 mm from the nozzle -B- for the corresponding glue bead geometry.



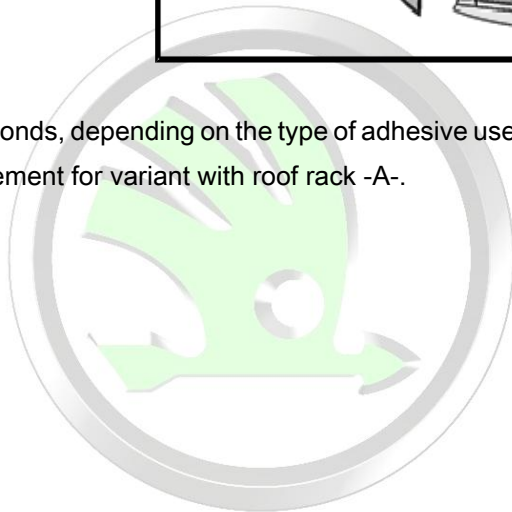
Note

At this point, we must emphasise the duty of care while carrying out this repair in order to exclude any possible faulty workmanship.

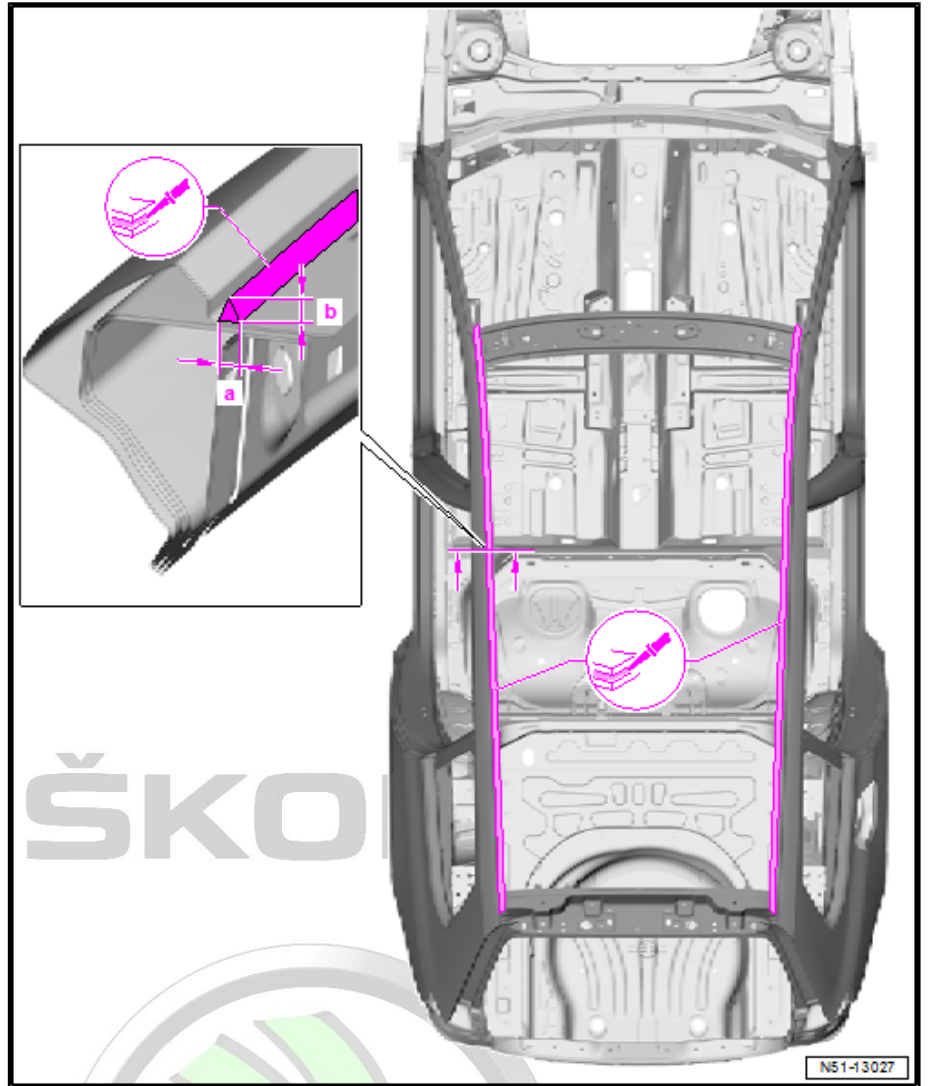




- Adhesive body bonds, depending on the type of adhesive used.
- Area with reinforcement for variant with roof rack -A-.



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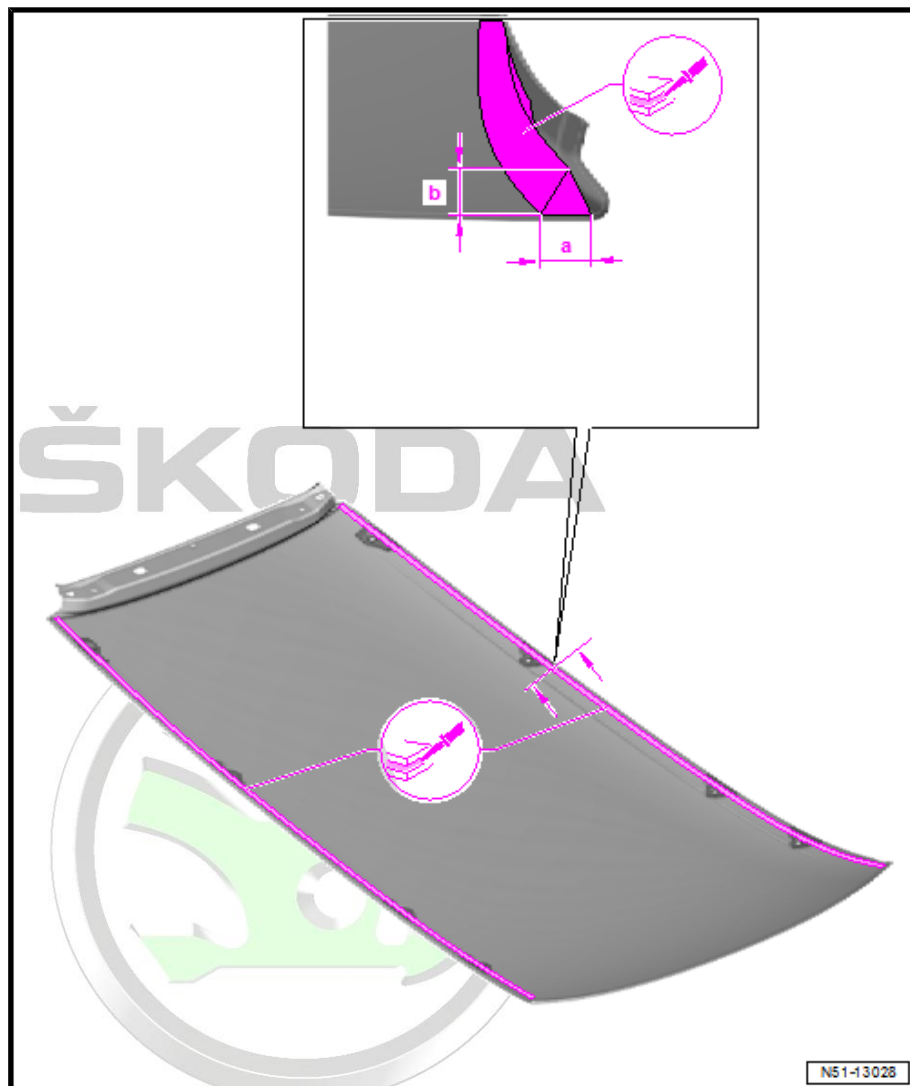


- Apply the 1K assembly glue - D 190 MKD A3- -1- e.g. with the compressed air gun - V.A.G 1761/1- , in the area of the roof rails.

Dimension -A- = approx. 12 mm

Dimension -b- = approx. 14 mm

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- Apply the 1K assembly glue - D 190 MKD A3- for example with the compressed air gun - V.A.G 1761/1- on the inside of the roof parallel to the left and right roof flange.

Dimension -A- = approx. 6 mm

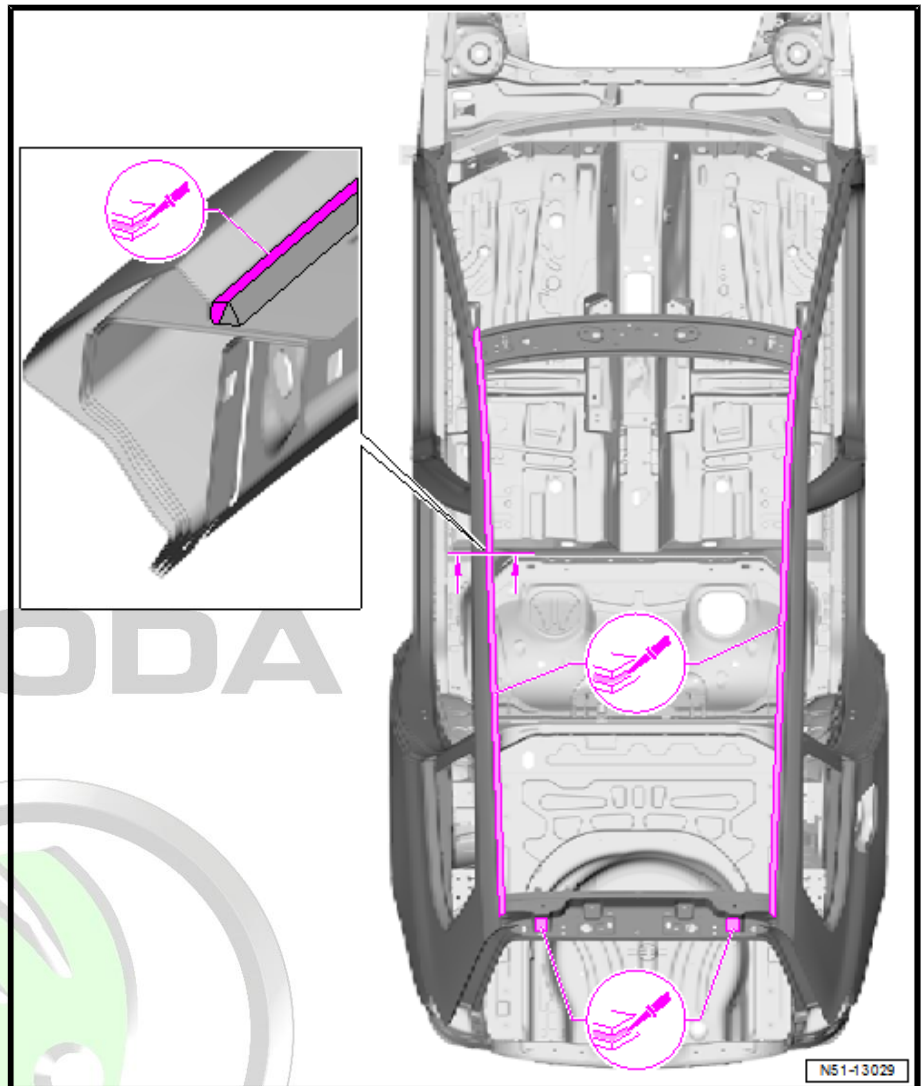
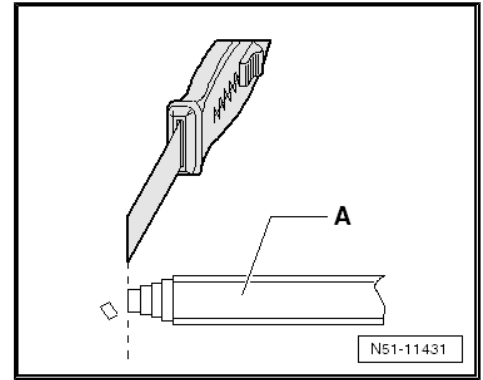
Dimension -b- = approx. 14 mm



Note

- ◆ The processing time of the 2K body glue - D 180 003 M2- is approximately 90 min.
- ◆ Immediately remove the excess 2K body glue - D 180 003 M2- on the adhesive surfaces. The 2K body glue - D 180 003 M2- can only be removed mechanically after hardening.

- Cut off the first level of the static mixer -A- in order to obtain the corresponding glue bead cross section.
- For example, operate the double cartridge gun - VAS 5237- without static mixer until the adhesive evenly flows out of both chambers of the cartridge connector.
- Screw the static mixer onto the cartridge connector.
- Apply the first 100 mm of glue on a piece of adhesive tape and only then begin to apply it on the vehicle.



- Fill up the area with the 2K body glue - D 180 003 M2- using for example the double cartridge gun - VAS 5237- .

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- Moisten the roof ridges with 2K body glue - D 180 003 M2- .
- Immediately place on the roof and align.
- Fix the roof at the window cutout for sliding roof using the gripping pliers and in the tailgate cutout as well as in the centre area using the tensioning straps.
- Check the roof line to the roof rails and adjust if necessary
⇒ [“1.4 Setting roof countersinking”, page 68](#) .
- Immediately remove the excess 2K body glue - D 180 003 M2- on the roof edge with a cloth soaked in silicone remover - LVM 020 100 A5- .



Note

- ◆ *After gluing in, the vehicle must stand on a flat surface for 8-10 hours at ambient temperature (at least 15 ° C) so that the glue components can harden (minimum hardening time).*
- ◆ *Only after the end of the minimum hardening time, it is possible to continue working on the vehicle.*



1.5.2 With sliding roof



Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs



Note

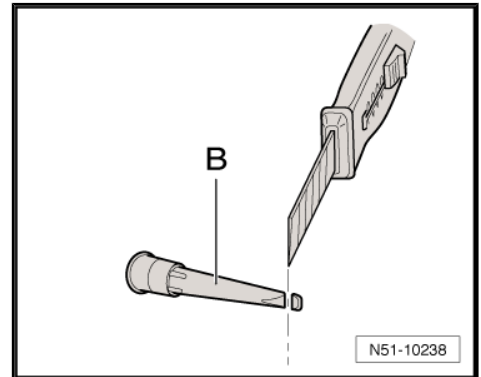
- ◆ *The vehicles with a sliding roof have no individual central reinforcements. In these vehicles, the reinforcement is part of the roof.*
 - ◆ *The adhesives must be applied very quickly.*
 - ◆ *The processing time must absolutely be observed.*
 - ◆ *Use the compressed air or electrical cartridge guns in order to apply the adhesive.*
- Remove the roof.
 - Clean the adhesive surface on the roof and the vehicle with silicone remover - LVM 020 100 A5- .

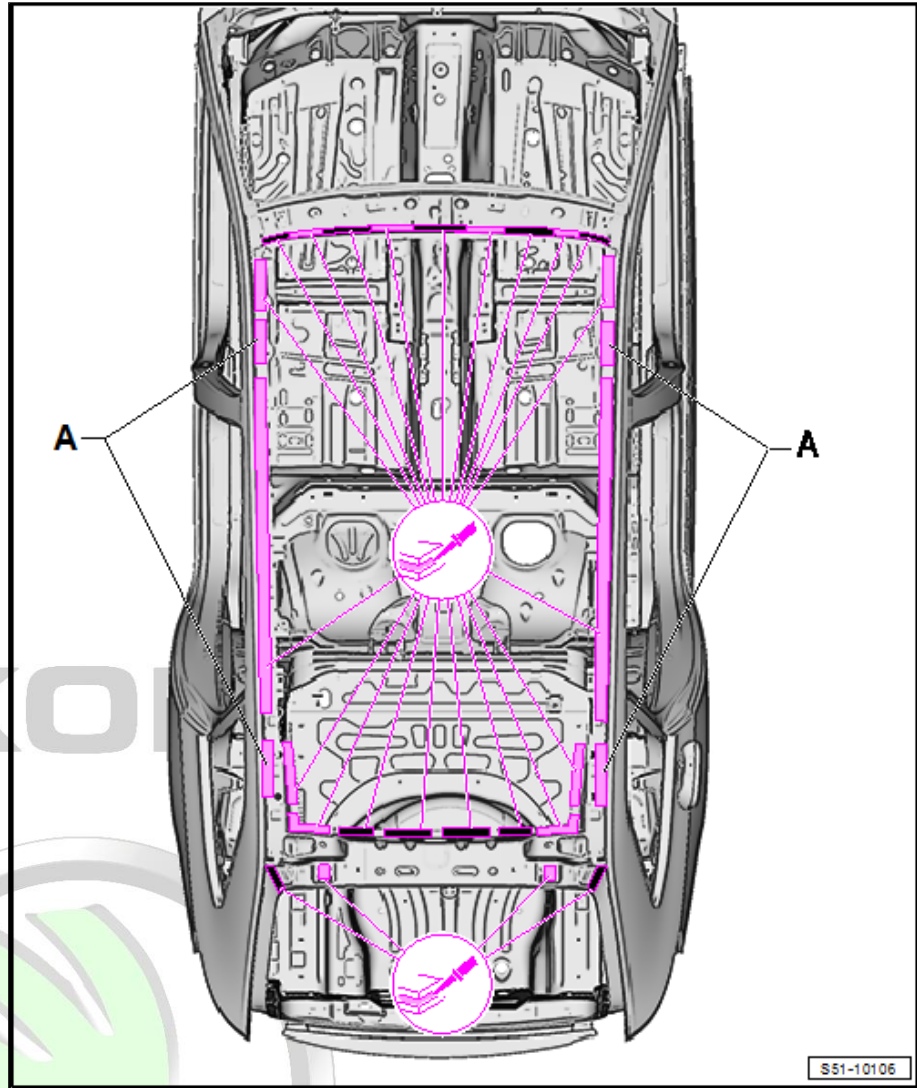
- Cut off approx. 2 mm from the nozzle -B- for the corresponding glue bead geometry.



Note

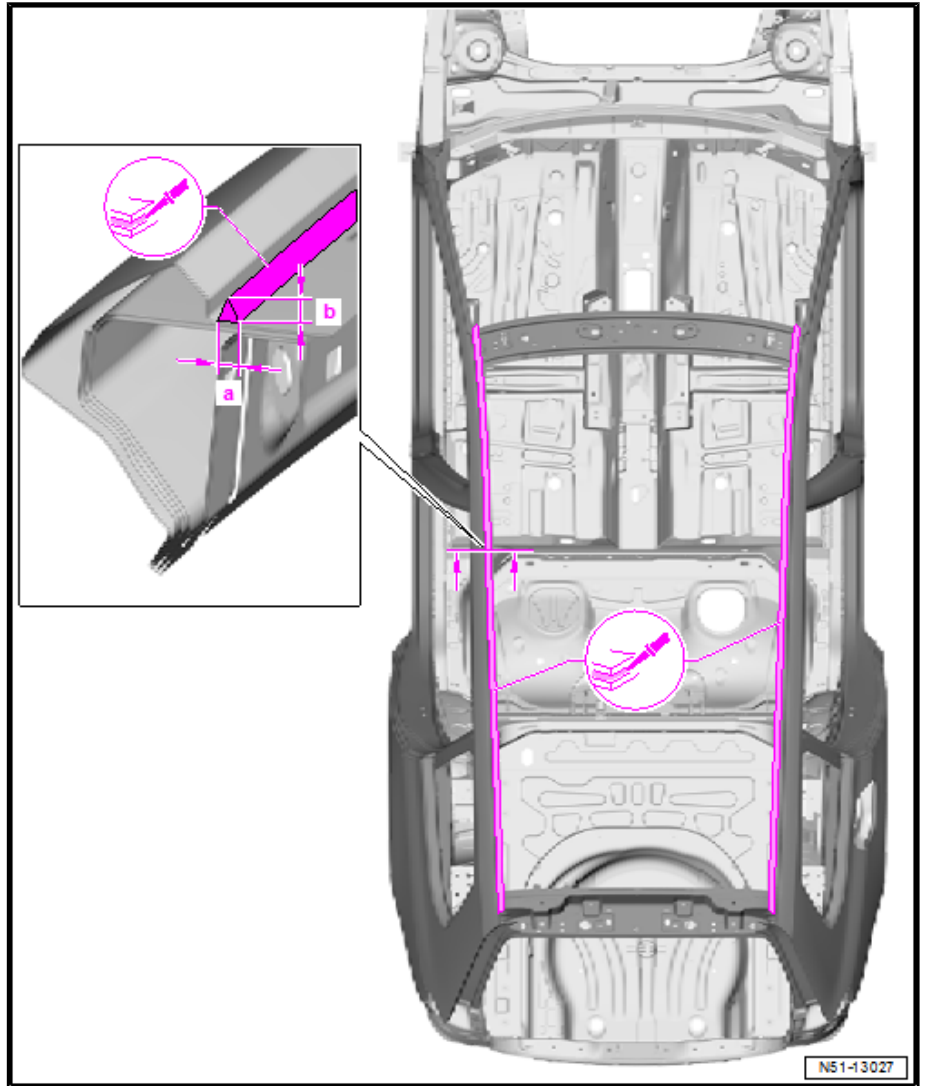
At this point, we must emphasise the duty of care while carrying out this repair in order to exclude any possible faulty workmanship.





- Adhesive body bonds, depending on the type of adhesive used.
- Area with reinforcement for variant with roof rack -A-

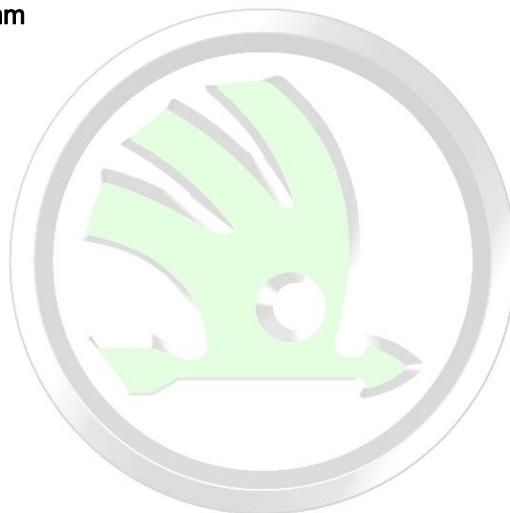
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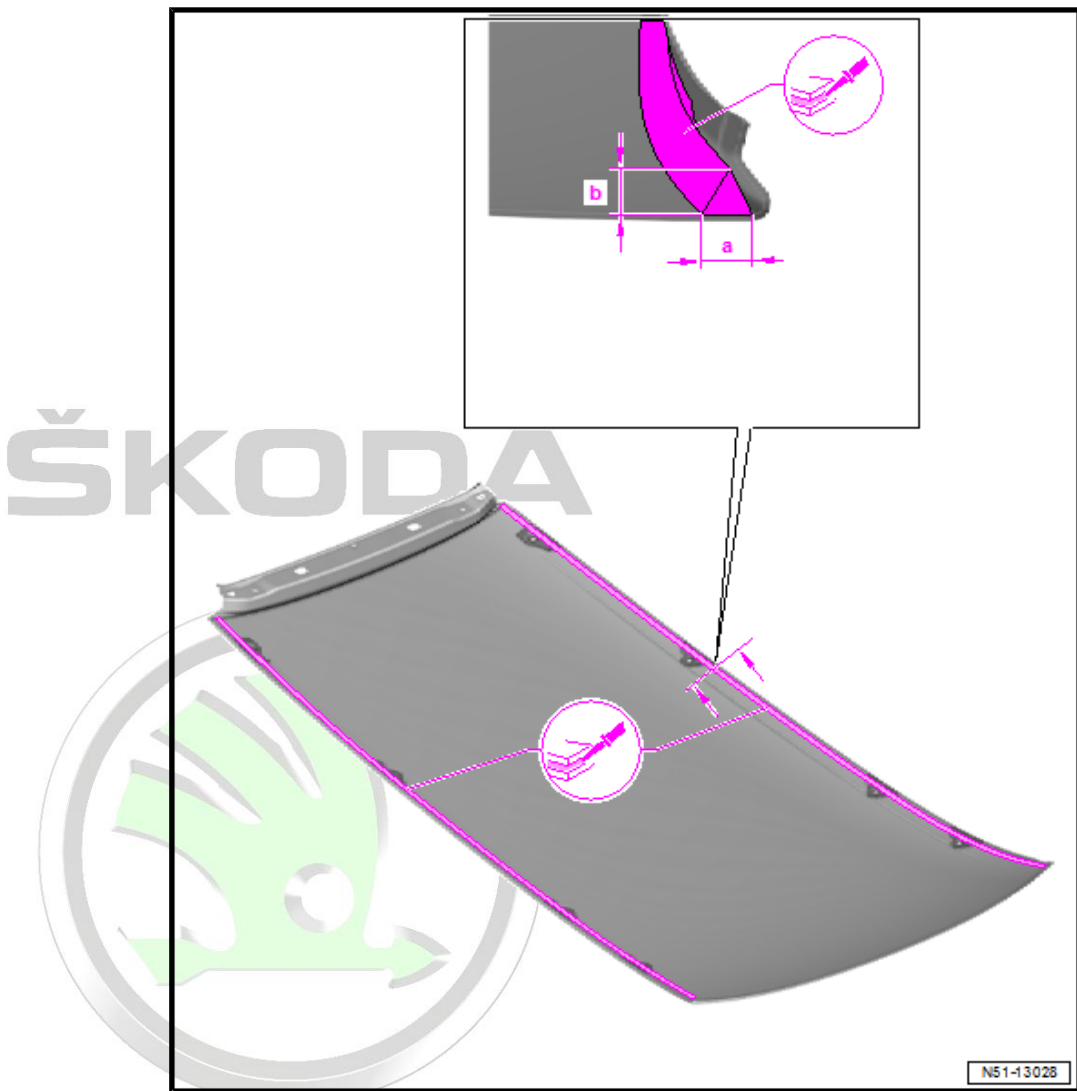


- Apply the 1K assembly glue - D 190 MKD A3- -1- e.g. with the compressed air gun - V.A.G 1761/1- , in the area of the roof rails.

Dimension -A- = approx. 12 mm

Dimension -b- = approx. 14 mm





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- Apply the 1K assembly glue - D 190 MKD A3-, for example with the compressed air gun - V.A.G 1761/1- on the inside of the roof parallel to the left and right roof flange.

Dimension -A- = approx. 6 mm

Dimension -b- = approx. 14 mm

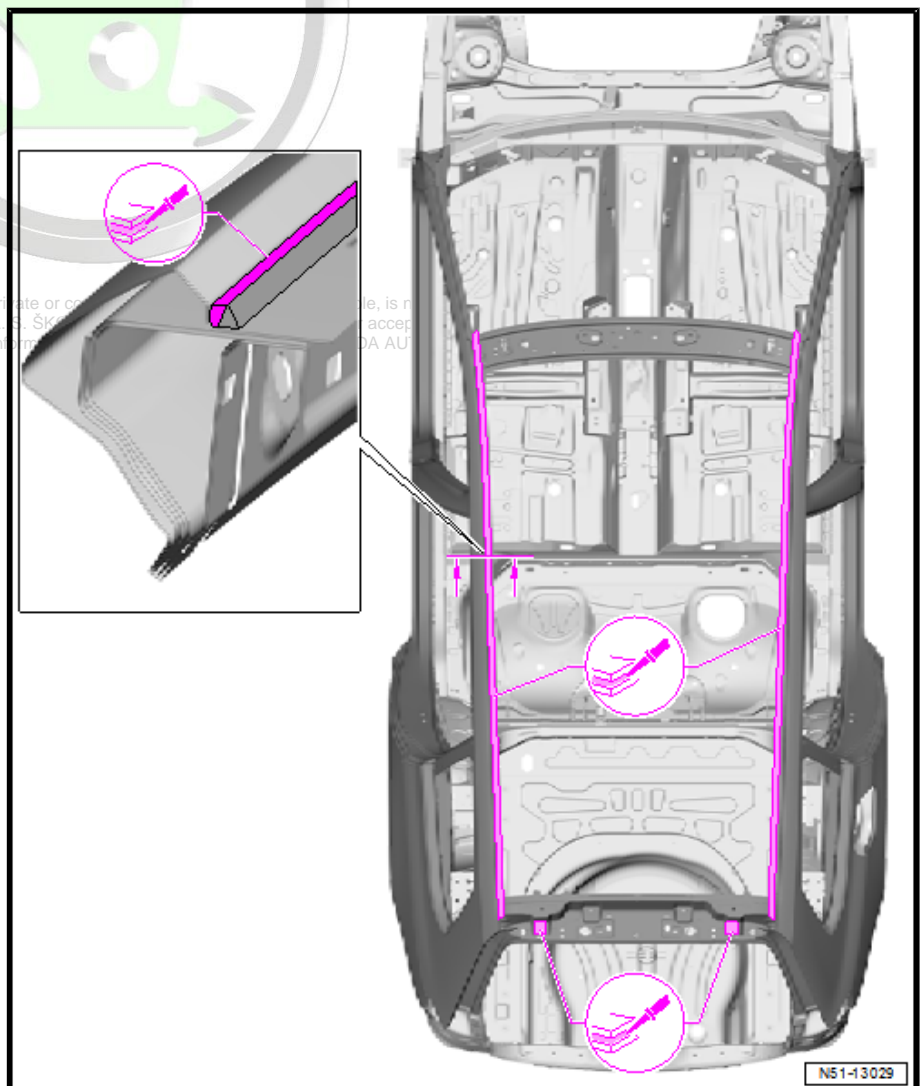
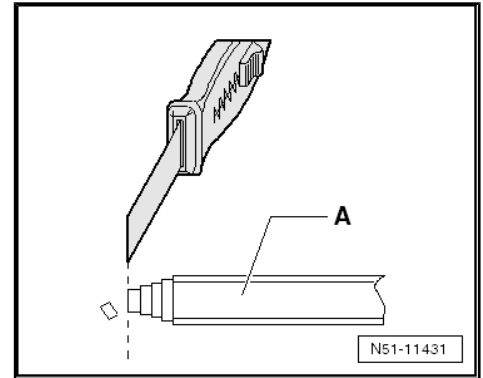


Note

- ◆ The processing time of the 2K body glue - D 180 003 M2- is approximately 90 min.
- ◆ Immediately remove the excess 2K body glue - D 180 003 M2- on the adhesive surfaces. The 2K body glue - D 180 003 M2- can only be removed mechanically after hardening.



- Cut off the first level of the static mixer -A- in order to obtain the corresponding glue bead cross section.
- For example, operate the double cartridge gun - VAS 5237- without static mixer until the adhesive evenly flows out of both chambers of the cartridge connector.
- Screw the static mixer onto the cartridge connector.
- Apply the first 100 mm of glue on a piece of adhesive tape and only then begin to apply it on the vehicle.



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- Fill up the area with the 2K body glue - D 180 003 M2- using for example the double cartridge gun - VAS 5237- .



- Moisten the roof ridges with 2K body glue - D 180 003 M2- .

- Immediately place on the roof and align.

- Fix the roof at the window cutout for sliding roof using the gripping pliers and in the tailgate cutout as well as in the centre area using the tensioning straps.

- Check the roof line to the roof rails and adjust if necessary
 ⇒ "1.4 Setting roof countersinking", page 68 .

- Immediately remove the excess 2K body glue - D 180 003 M2- on the roof edge with a cloth soaked in silicone remover - LVM 020 100 A5- .



Note

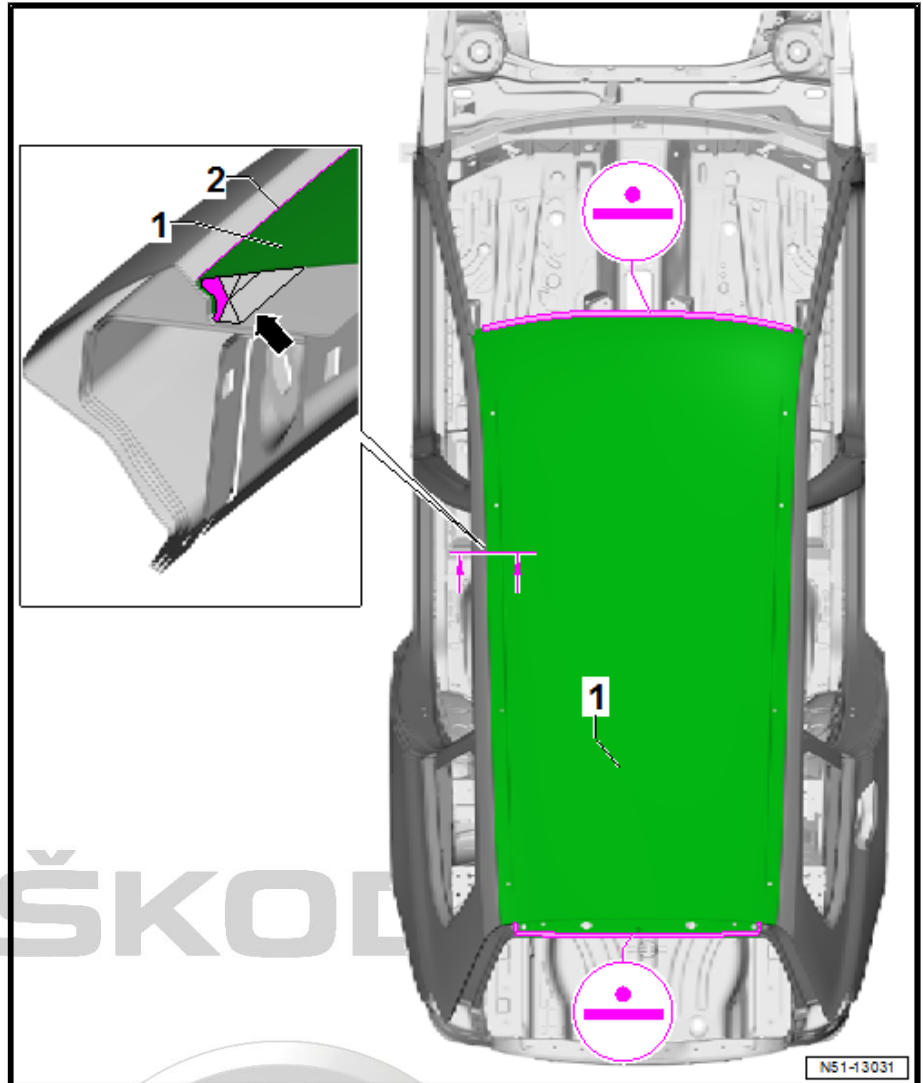
- ◆ After gluing in, the vehicle must stand on a flat surface for 8-10 hours at ambient temperature (at least 15 °C) so that the glue components can harden (minimum hardening time).
- ◆ Only after the end of the minimum hardening time, it is possible to continue working on the vehicle.

1.6 Part welding



Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs



- Weld in the roof -1-, RP spot seam.
- Perform precision sealing of the connection -2- with adhesive sealant - AKD 476 KD5 05- in the original form at the bonded joint between roof and roof frame rail.
- After painting, perform cavity sealing on the roof -arrow- with preservation wax - AKR 321 M15 4- .



2 Replacing the roof rail

⇒ "2.1 Removing", page 82

⇒ "2.2 Preparing the new part", page 83

⇒ "2.3 Part welding", page 84

2.1 Removing



Caution

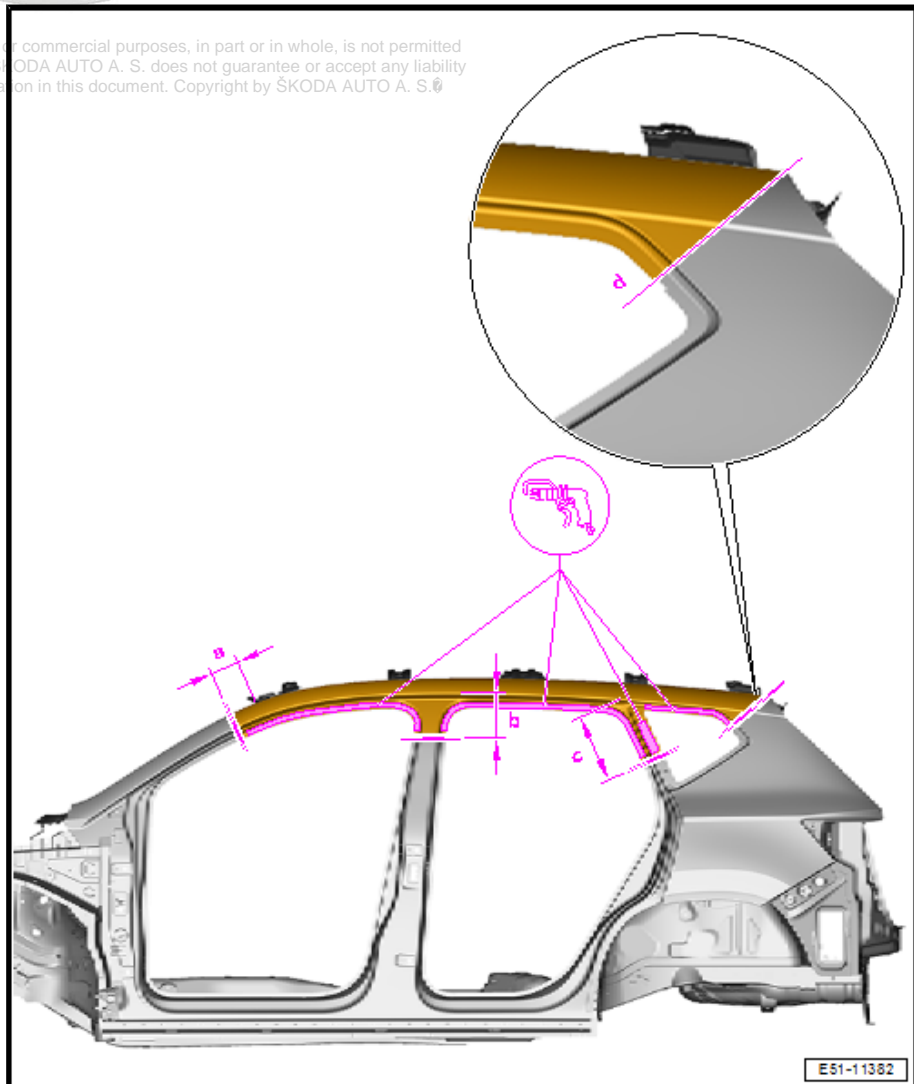
Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs



Note

When carrying out the separation cuts, ensure that the panels located at the bottom are not damaged.

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- Position and make the separating cuts according to the damage e.g. as shown in the figure.

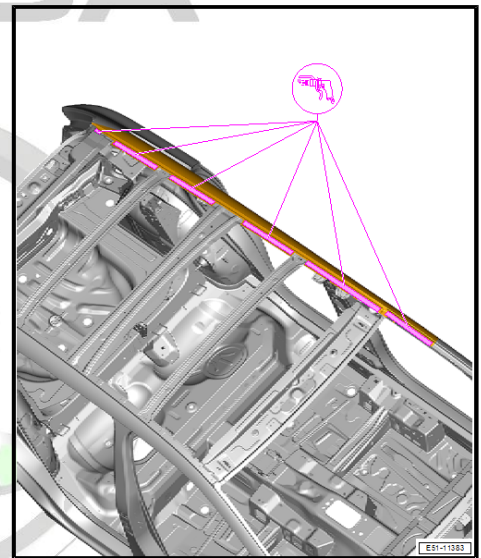


- a- = 130 mm.
- b- = 120 mm.
- c- = 120 mm.
- If the roof is not removed, make the separating cut parallel to the roof, depending on the damage.
- Loosen the original welding.
- Remove any residues.

When removing the roof

- Loosen the original welding.
- Remove any residues.

ŠKODA



2.2 Preparing the new part



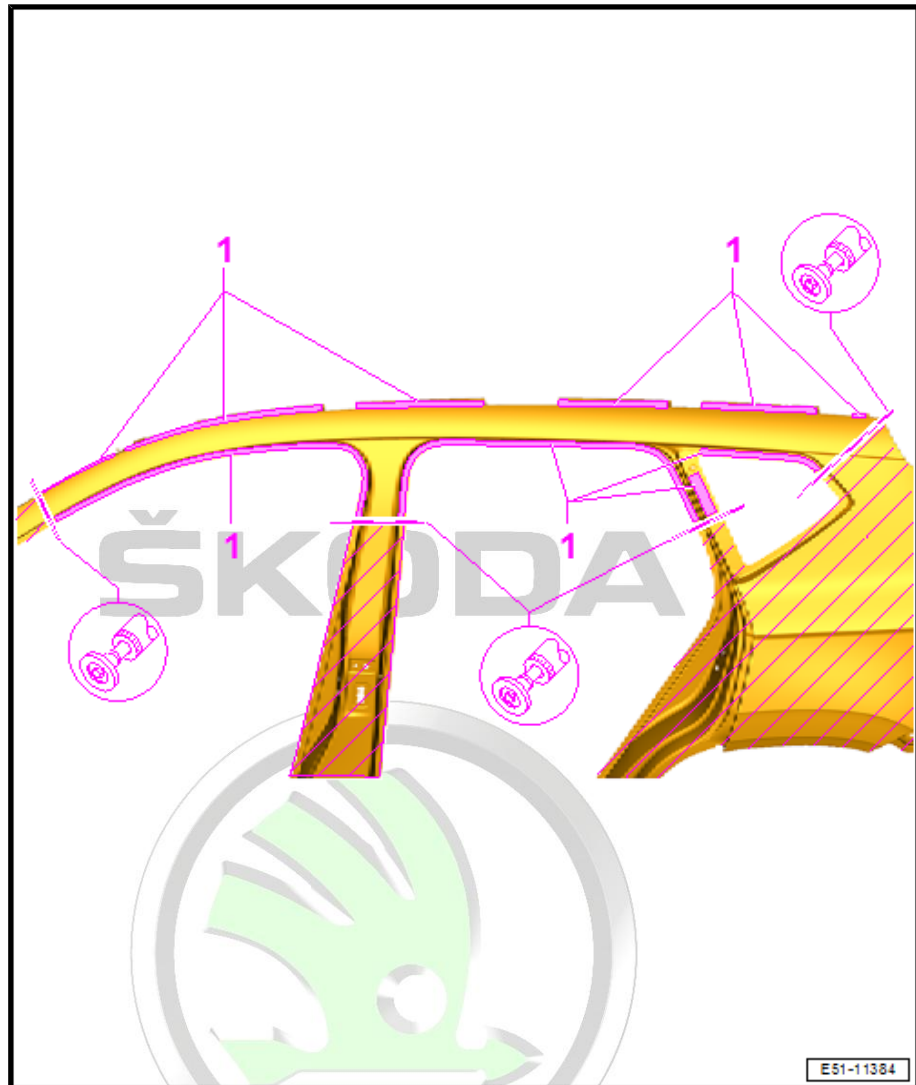
Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs

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New part

- ◆ Outside side part
- ◆ 2K epoxy adhesive - DA 001 730 A2-
- ◆ Moulded foam part



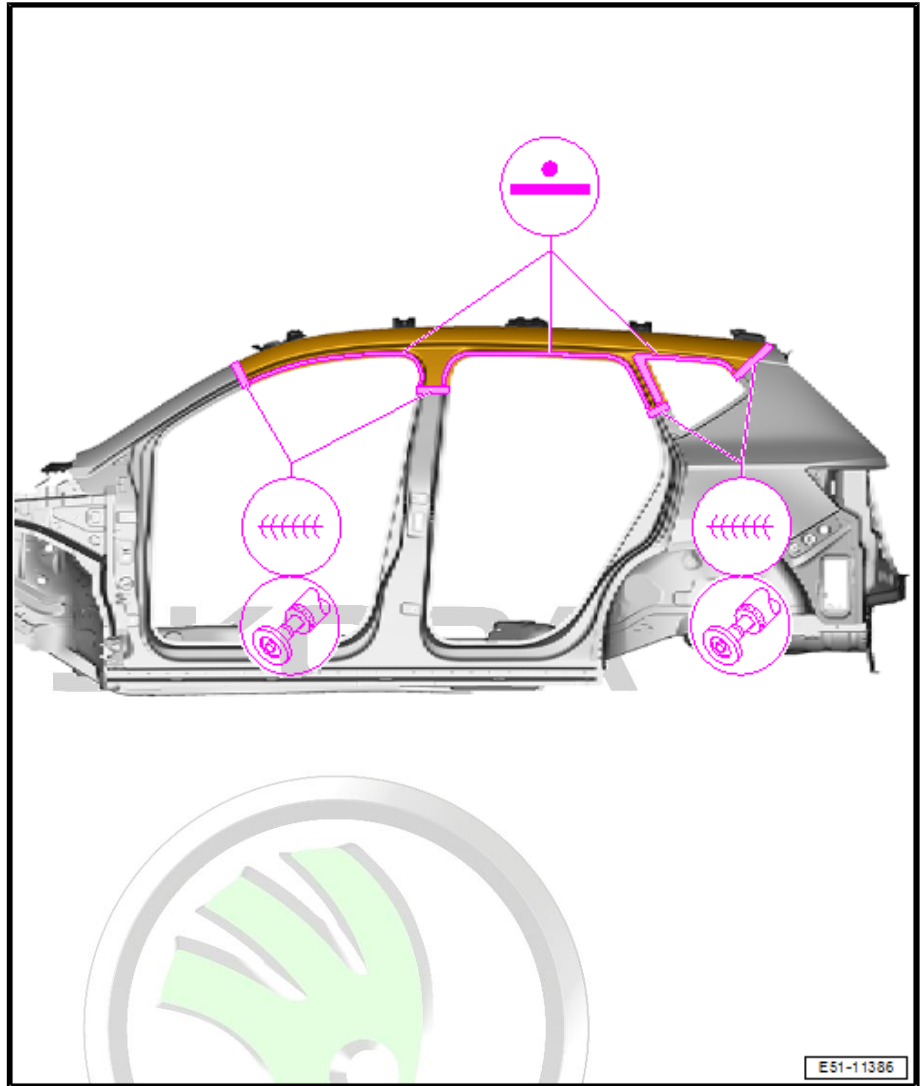
- Transfer separating cut to new part and cut to the required dimensions.
- If the roof is not removed, cut the new part to size parallel to the roof, depending on the damage.
- Prepare surfaces -1- For RP spot weld seam.

2.3 Part welding



Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs



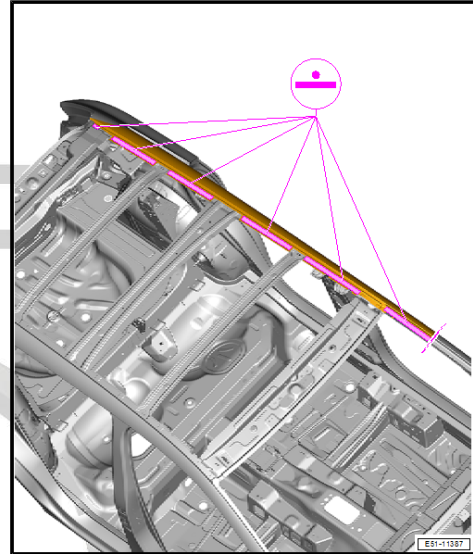
- Adjust the new part and fix. For this purpose, the vehicle is standing on its wheels or on the straightening bracket set .
- Check the fit with component parts.
- Weld the separation cuts, an inert gas shielded full seam.
- If the roof is not removed, weld the separating cut parallel to the roof, depending on the damage, GS continuous seam.
- Weld in the new part, an RP spot seam.

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When removing the roof

- Weld in the new part, an RP spot seam.



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3 Replacing outer A pillar -cutoff part-

⇒ ["3.1 Removing", page 87](#)

⇒ ["3.2 Preparing the new part", page 88](#)

⇒ ["3.3 Moulded foam parts", page 90](#)

⇒ ["3.4 Part welding", page 90](#)

3.1 Removing



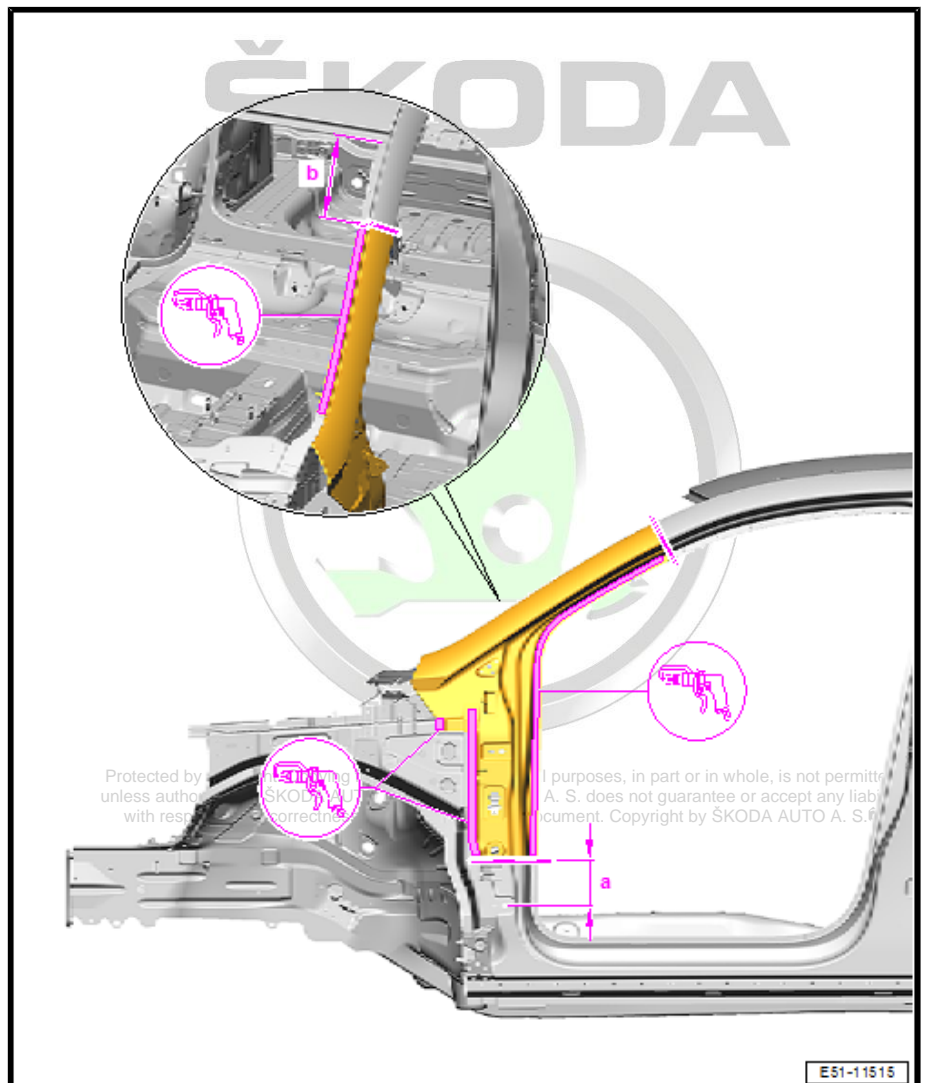
Caution

Follow the general notes! → General Information; Body Repairs, General Body Repairs



Note

When carrying out the separation cuts, ensure that the panels located at the bottom are not damaged.





- Position and make the separating cuts according to the damage e.g. as shown in the figure.
- a- = 105 mm.
- b- = 130 mm.
- Loosen the original welding.
- Remove any residues.

3.2 Preparing the new part

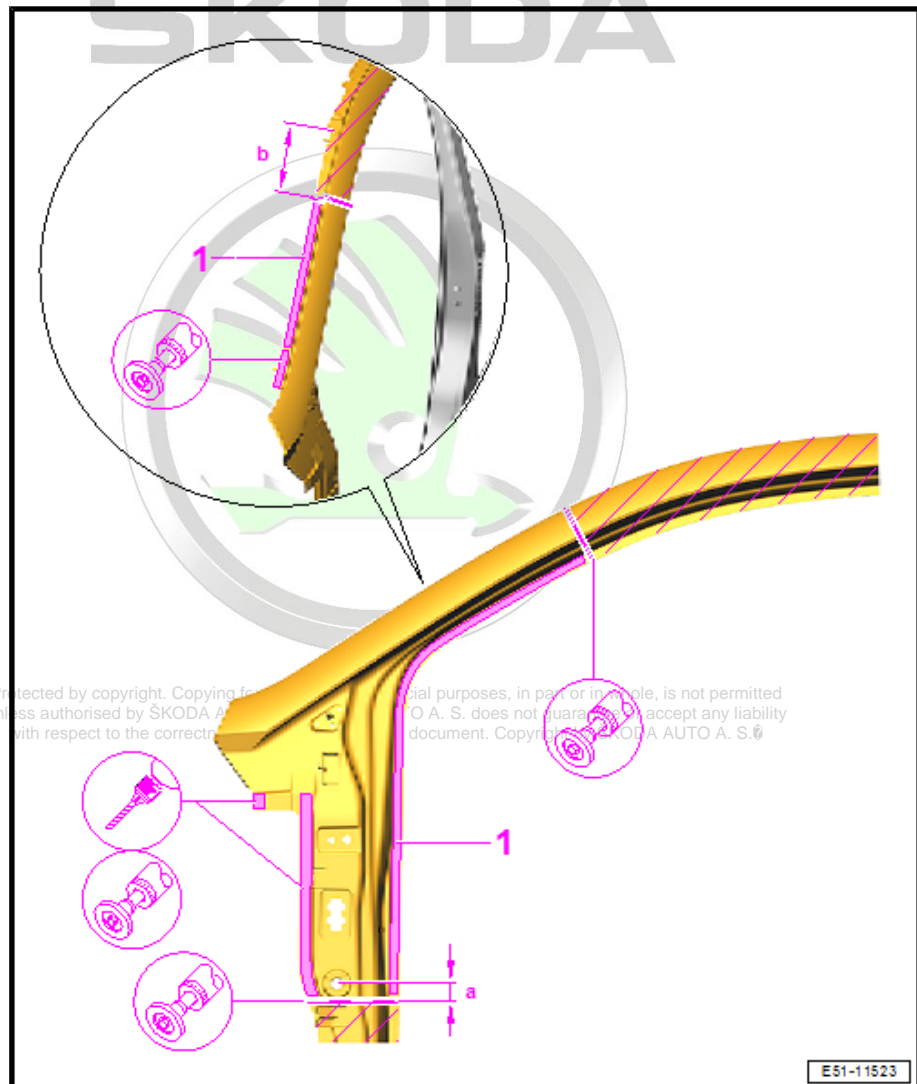


Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs

New part

- ◆ A-pillar
- ◆ 2K epoxy adhesive - DA 001 730 A2-
- ◆ Moulded foam part

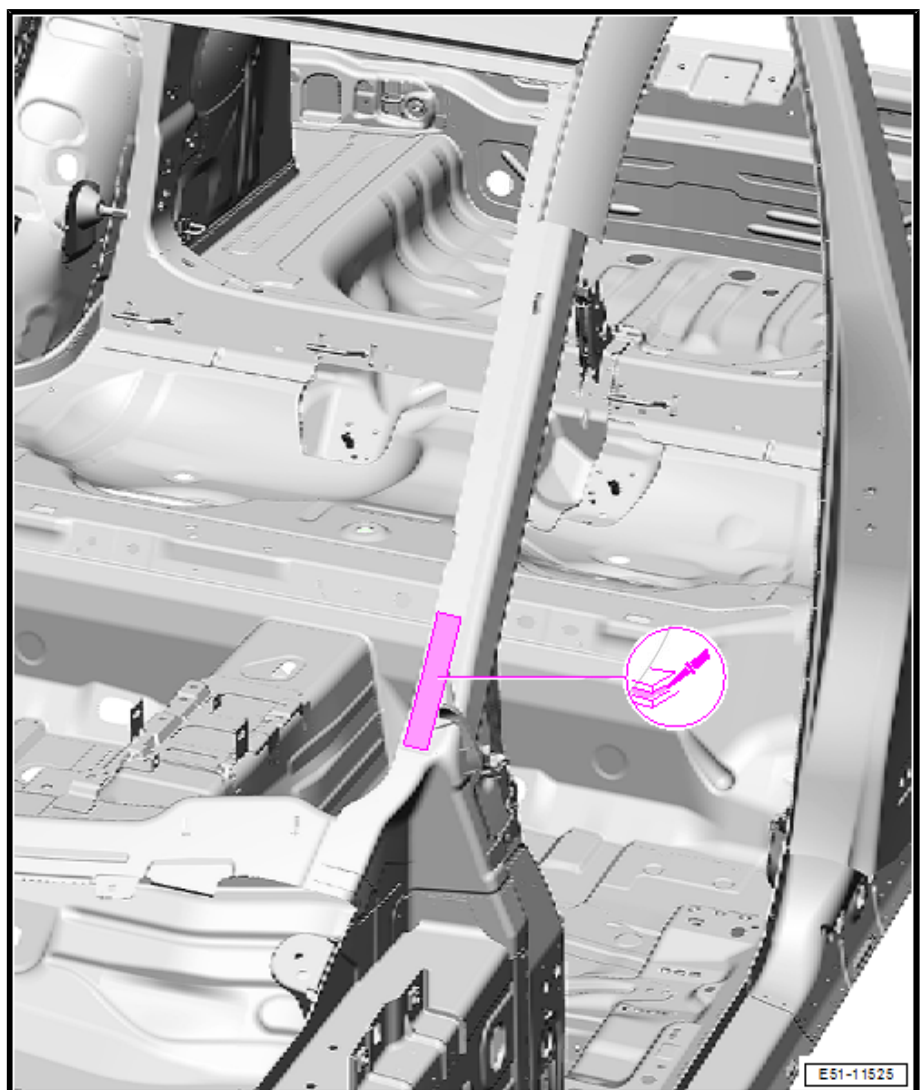


E51-11523

- Transpose cut to new part and cut part to size according to the damage, as shown in the figure.
- a- = 30 mm
- b- = 130 mm.
- Prepare surfaces -1- For RP spot weld seam.
- Create holes for the GS plug weld seam, \varnothing 8 mm.

 Note

- ◆ *The new part must be welded within 90 minutes as otherwise the adhesion of the glue may be poor.*
- ◆ *The holes for the hinge attachment must be cleaned from adhesive after gluing in.*



- Apply 2K epoxy adhesive - DA 001 730 A2- .



3.3 Moulded foam parts



Caution

Follow the general notes! → General Information; Body Repairs, General Body Repairs

Observe the repair instructions.

Moulded foam parts: ⇒ General Information; Body Repairs, General Body Repairs ; Basic Instructions, moulded foam parts

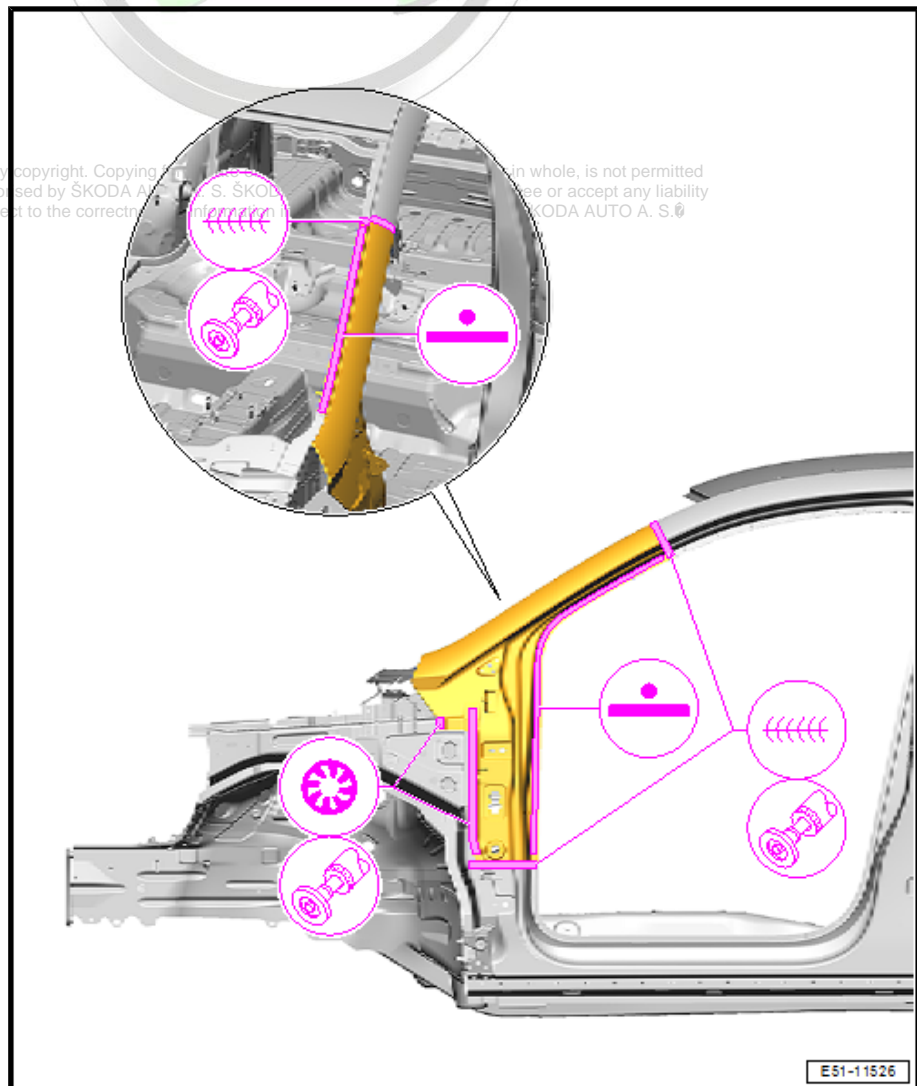
- Replace moulded foam part ⇒ ["4 Foam moulds", page 4](#) .

3.4 Part welding



Caution

Follow the general notes! → General Information; Body Repairs, General Body Repairs



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- Adjust the new part and fix. For this purpose, the vehicle is standing on its wheels or on the straightening bracket set .
- Check the fit with component parts.
- Weld the separation cuts, an inert gas shielded full seam.
- Weld in the new part, RP spot seam and inert gas shielded plug weld.

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4 Replace front mudguard bracket

⇒ "4.1 Removing", page 92

⇒ "4.2 Preparing the new part", page 93

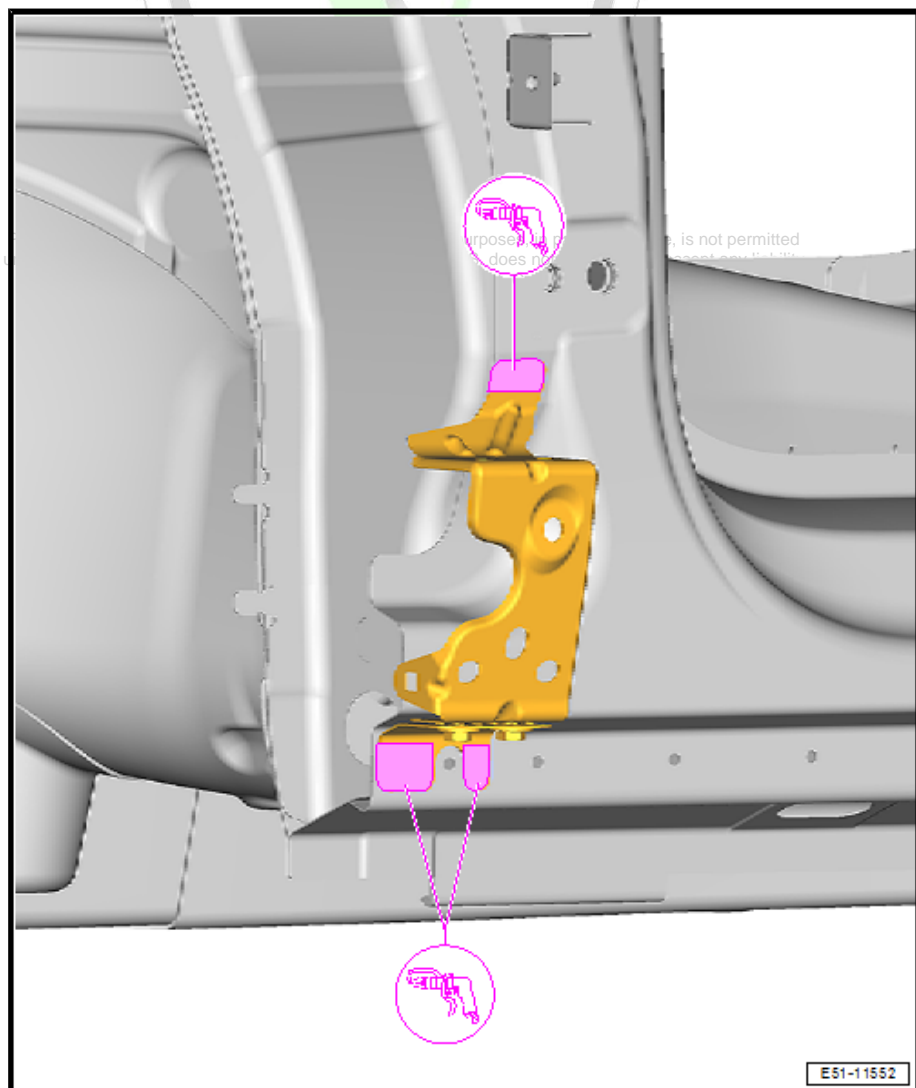
⇒ "4.3 Part welding", page 93

4.1 Removing



Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs



- Loosen the original welding.
- Remove any residues.

4.2 Preparing the new part

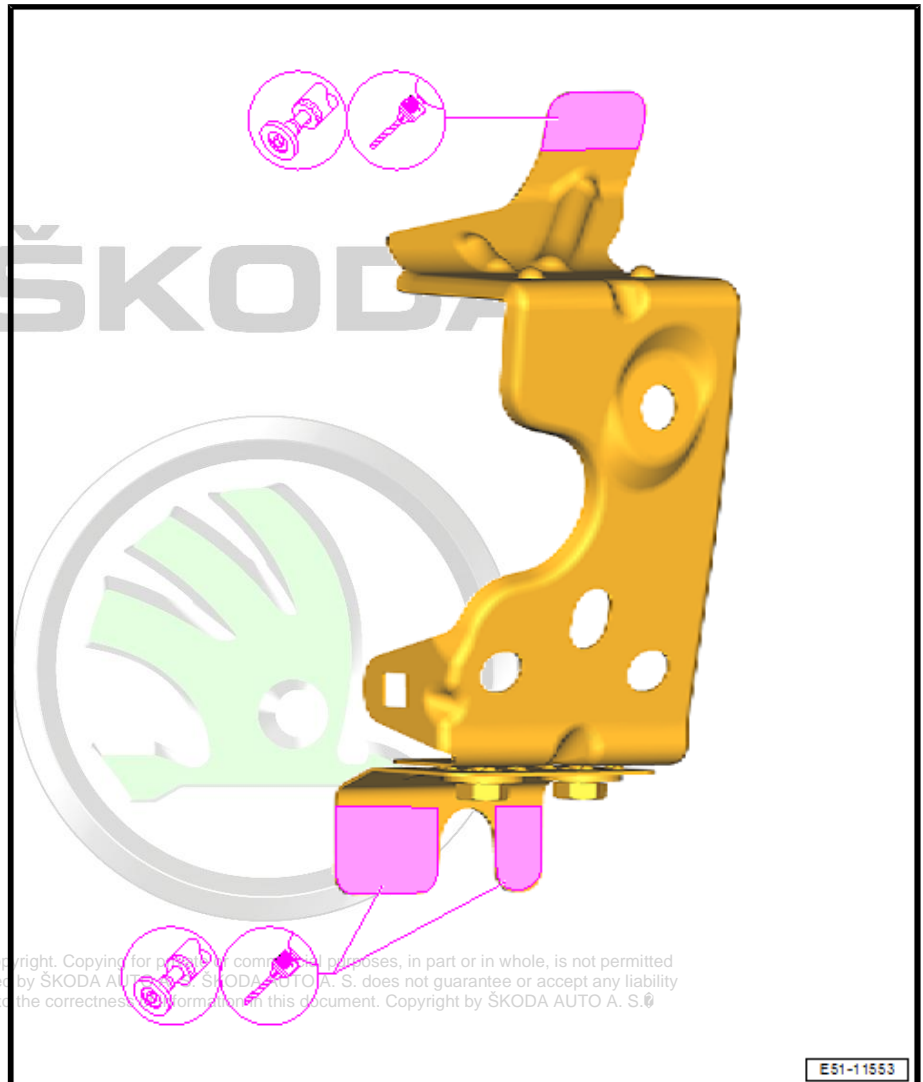


Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs

New part

- ◆ Front mudguard mount



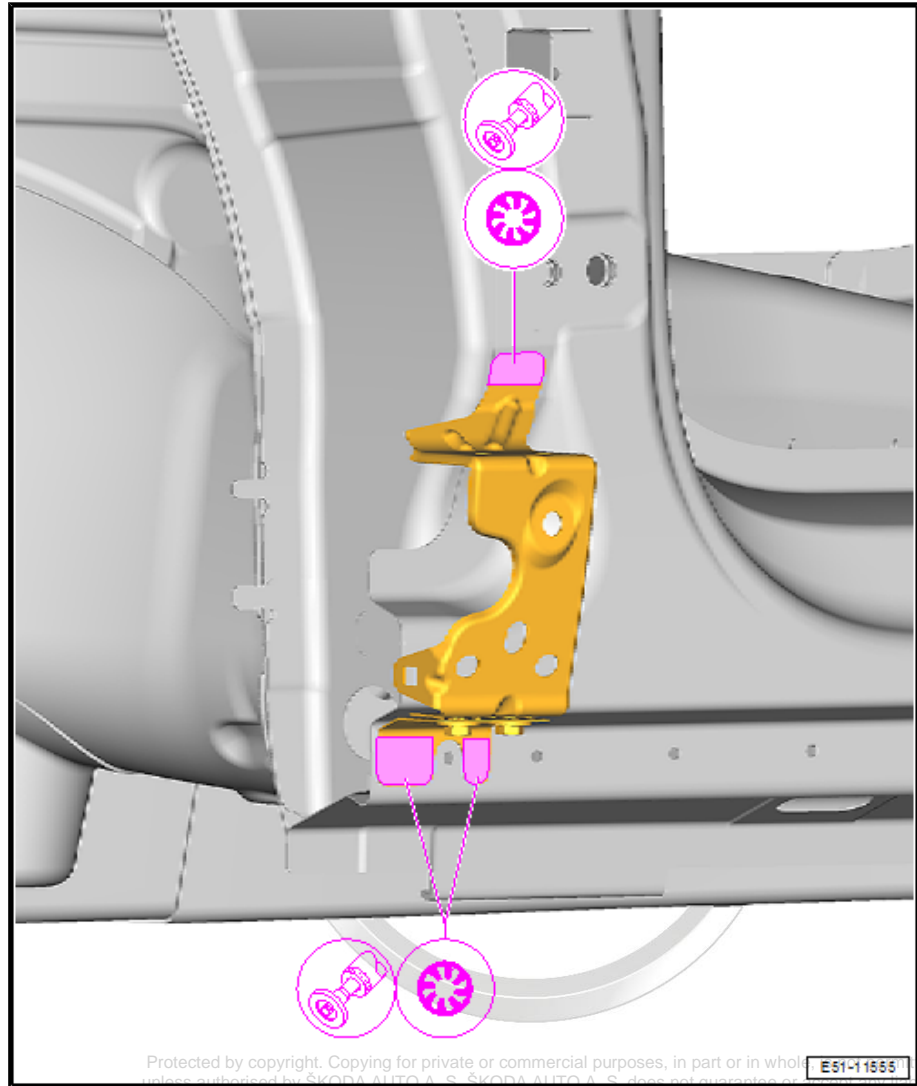
- Create holes for the GS plug weld seam, \varnothing 8 mm.

4.3 Part welding



Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs



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- Adjust the new part and fix. For this purpose, the vehicle is standing on its wheels or on the straightening bracket set .
- Check the fit with component parts.
- Weld in the new part, GS plug weld seam.

5 Replacing reinforcement of A-pillar - part-

⇒ ["5.1 Removing", page 95](#)

⇒ ["5.2 Preparing the new part", page 96](#)

⇒ ["5.3 Moulded foam parts", page 97](#)

⇒ ["5.4 Part welding", page 98](#)

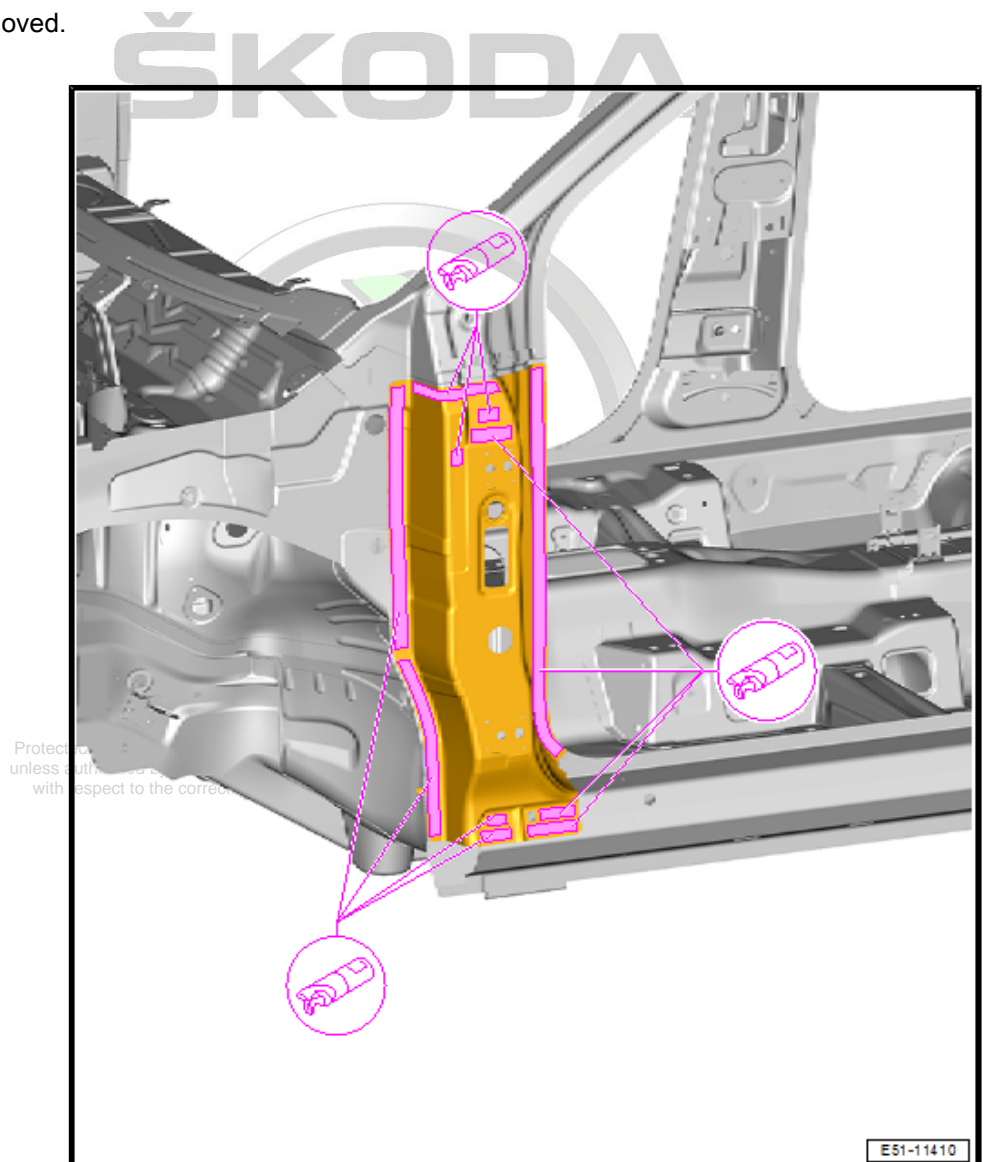
5.1 Removing



Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs

Outer A-pillar already removed.



- Loosen original welding from inside and outside.
- Remove reinforcement of A-pillar.



- Remove any residues.

5.2 Preparing the new part

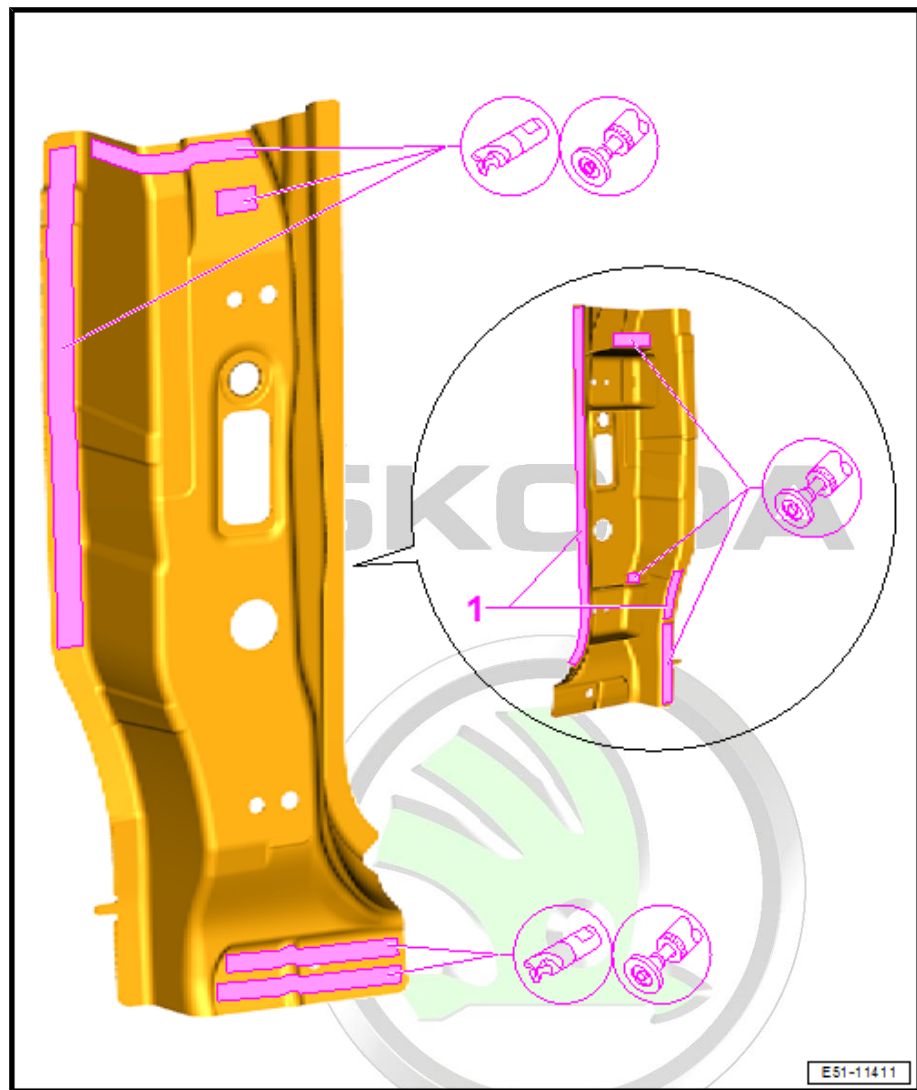


Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs

New part

- ◆ Reinforcement of A-pillar
- ◆ 2K epoxy adhesive - DA 001 730 A2-
- ◆ Moulded foam parts

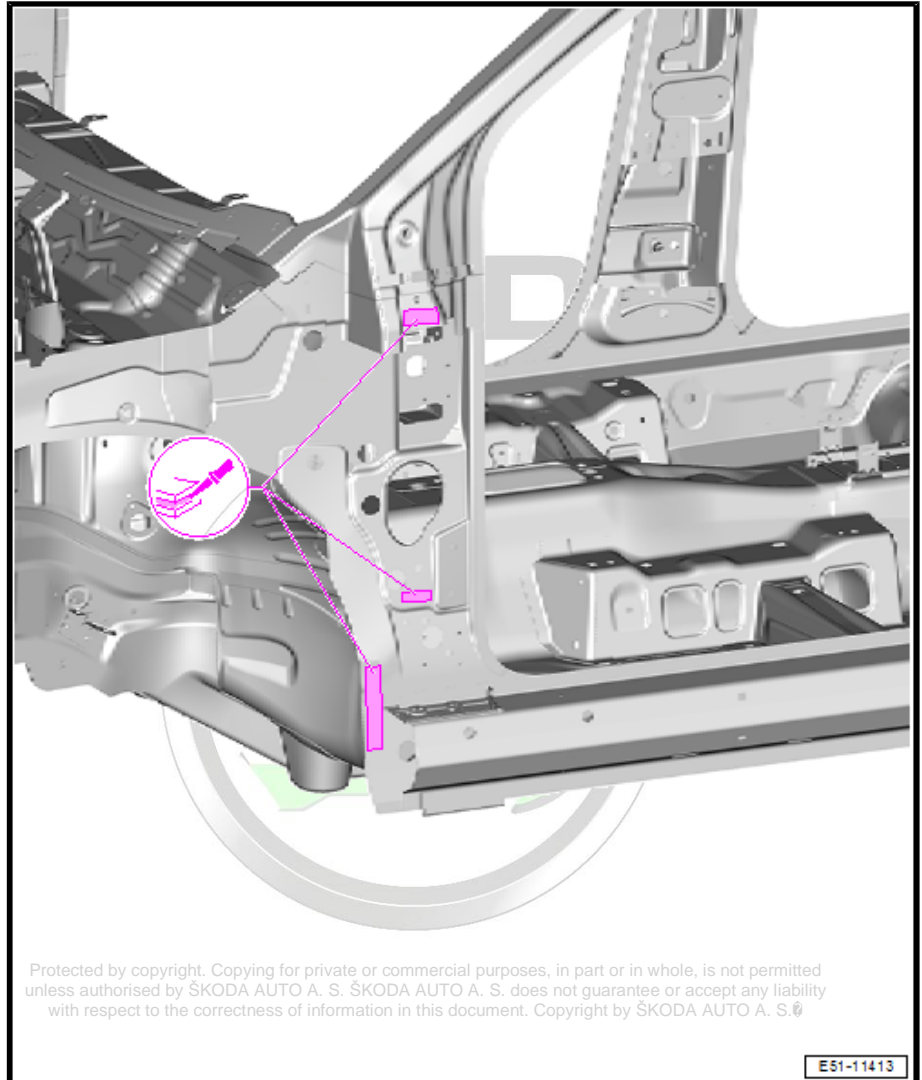


- Drill holes for the GS plug weld seam, 8 mm Ø.
- Prepare surfaces -1- For RP spot weld seam.

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Note

The new part must be welded within 90 minutes as otherwise the adhesion of the glue may be poor.



- Make sure the adhesive areas are free of dust and grease.
- Apply 2K epoxy adhesive - DA 001 730 A2- .

5.3 Moulded foam parts

Caution
Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs

Observe the repair instructions.

Moulded foam parts: ⇒ General Information; Body Repairs, General Body Repairs ; Basic Instructions, moulded foam parts

- Replace moulded foam part ⇒ [“4 Foam moulds”, page 4](#) .

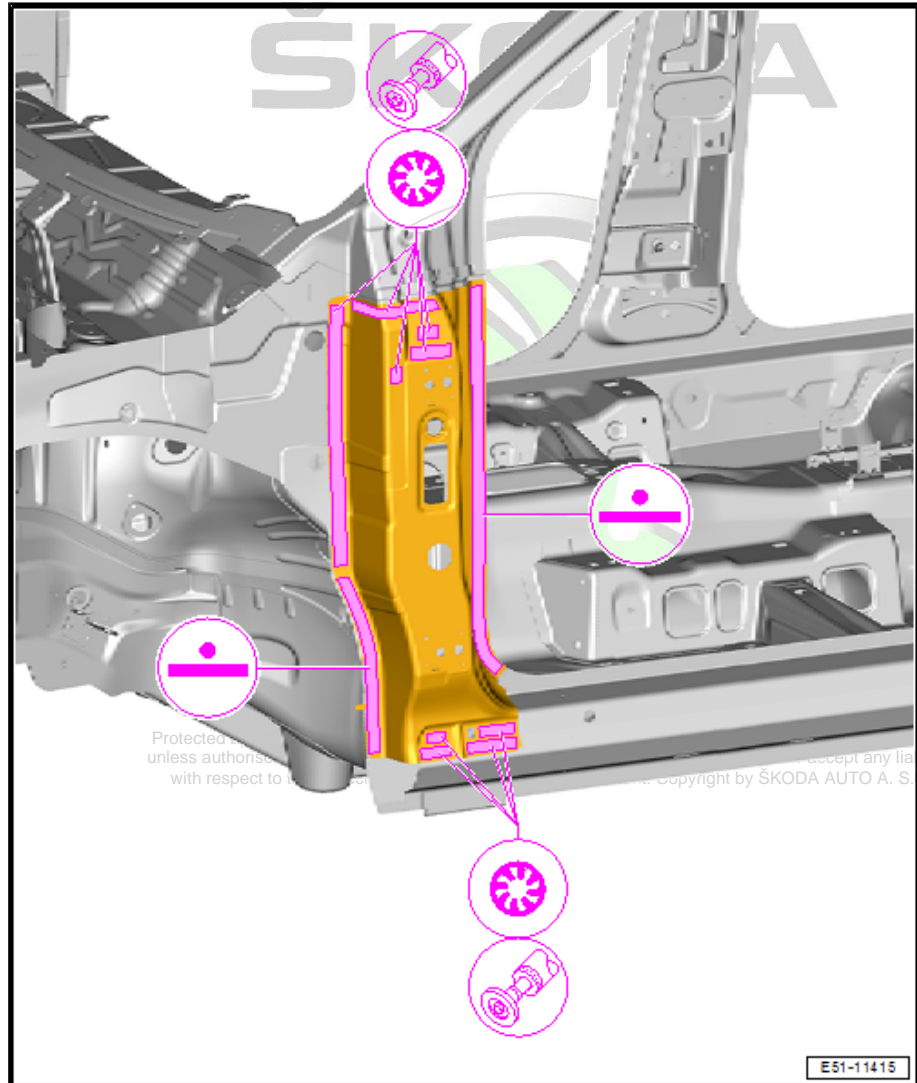


5.4 Part welding



Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs



- Adjust the new part and fix. For this purpose, the vehicle is standing on its wheels or on the straightening bracket set .
- Weld in the new part, GS plug weld seam and RP spot seam inverter.



- Position and make the separating cuts according to the damage e.g. as shown in the figure -1-.
- Loosen the original welding.
- Remove residues.
- Remove any residues.

6.2 Preparing the new part

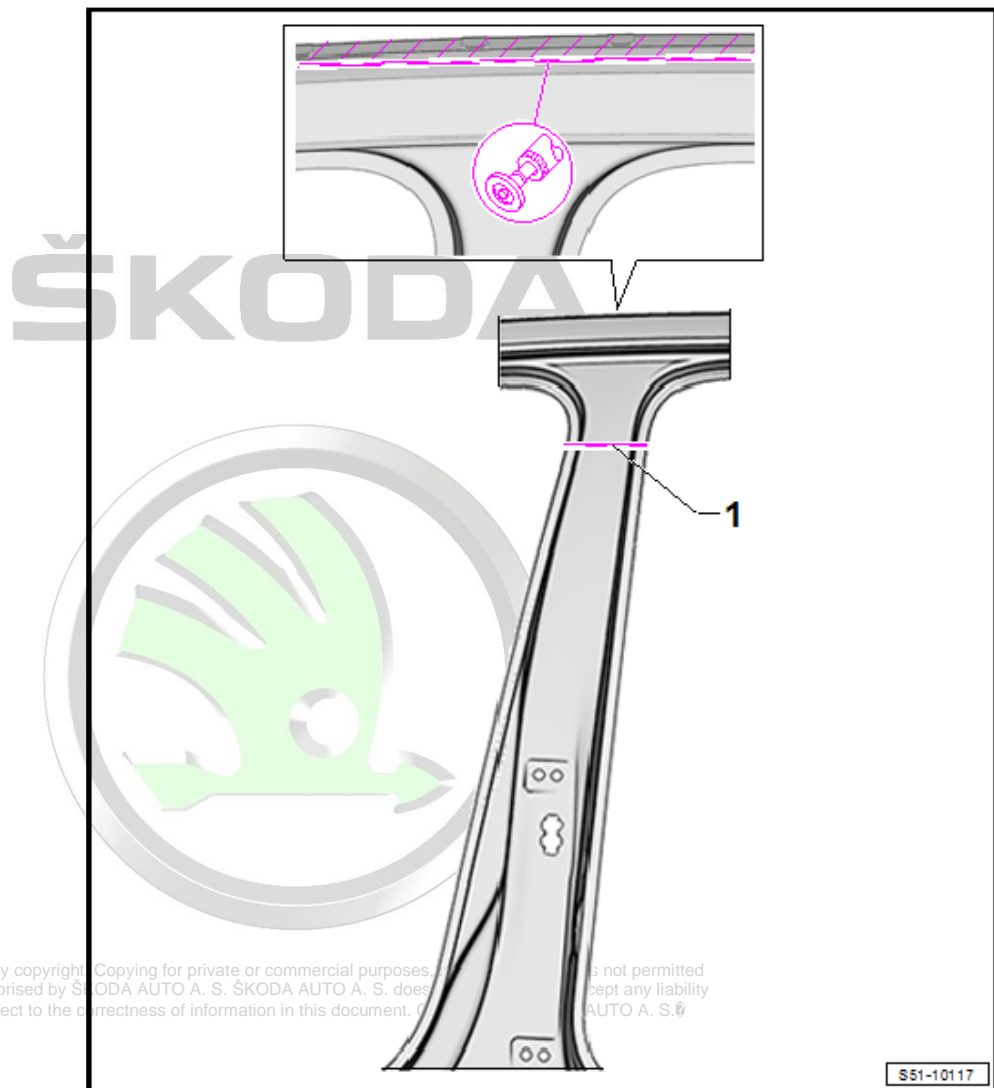


Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs

New part

- ◆ Outer B-pillar
- ◆ 2K epoxy adhesive - DA 001 730 A2-



- Transpose the separation cut onto the new part and cut or cut depending on damage, e.g. -1-.

6.3 Moulded foam parts



Caution

Follow the general notes! → General Information; Body Repairs, General Body Repairs

Observe the repair instructions.

Moulded foam parts: → General Information; Body Repairs, General Body Repairs ; Basic Instructions, moulded foam parts

- Replace moulded foam part ⇒ [“4 Foam moulds”, page 4](#) .

6.4 Part welding



Caution

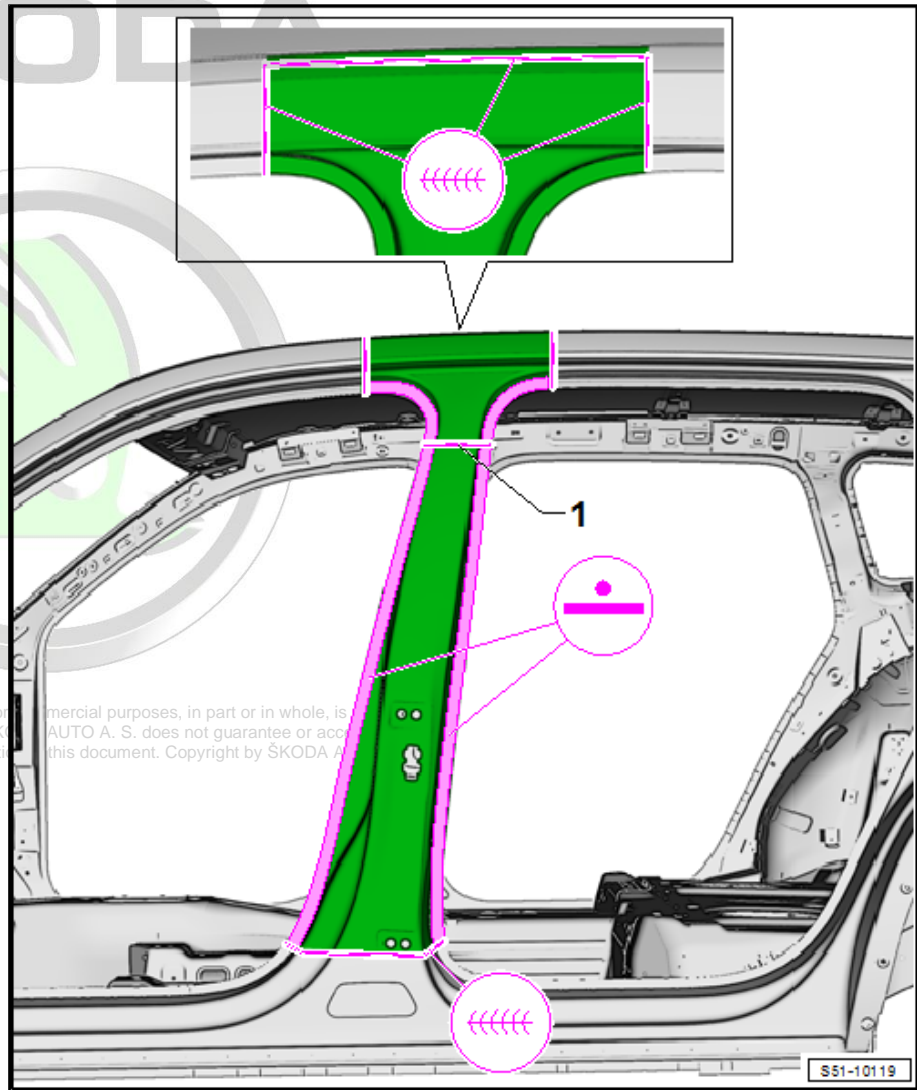
Follow the general notes! → General Information; Body Repairs, General Body Repairs



Note

- ◆ *The new part must be welded within 90 minutes as otherwise the adhesion of the glue may be poor.*
- ◆ *The holes for the hinge attachment and the locking clamp must be cleaned of adhesive after gluing in.*
- Apply 2K epoxy adhesive - DA 001 730 A2- in the original areas.

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- Adjust the new part and fix. For this purpose, the vehicle is standing on its wheels or on the straightening bracket set .
- Check the fit with component parts.
- Weld in the B-pillar, RP spot seam inverter.
- Weld the separation cuts or cut, e.g. -1-, GS continuous seam.



7 Replacing reinforcement of B pillar

⇒ [“7.1 Removing”, page 103](#)

⇒ [“7.2 Preparing the new part”, page 104](#)

⇒ [“6.3 Moulded foam parts”, page 101](#)

⇒ [“7.4 Part welding”, page 107](#)

7.1 Removing



Caution

Follow the general notes! → General Information; Body Repairs, General Body Repairs

Outer panels already removed.

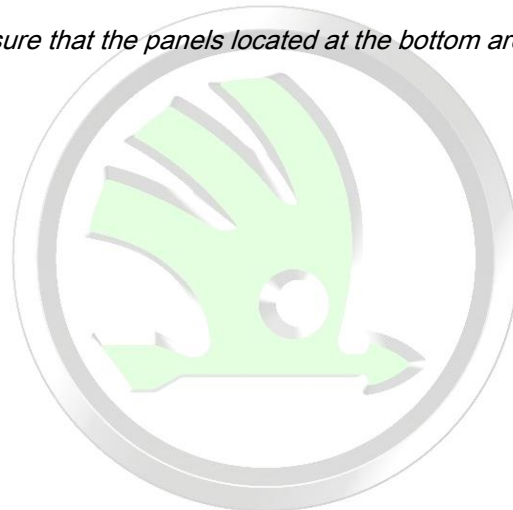
Special tools and workshop equipment required

- ◆ Welding point loosening tool e.g. -V.A.G 1731- and replacement breaker for high-strength panels e.g. -V.A.G 1731/3-

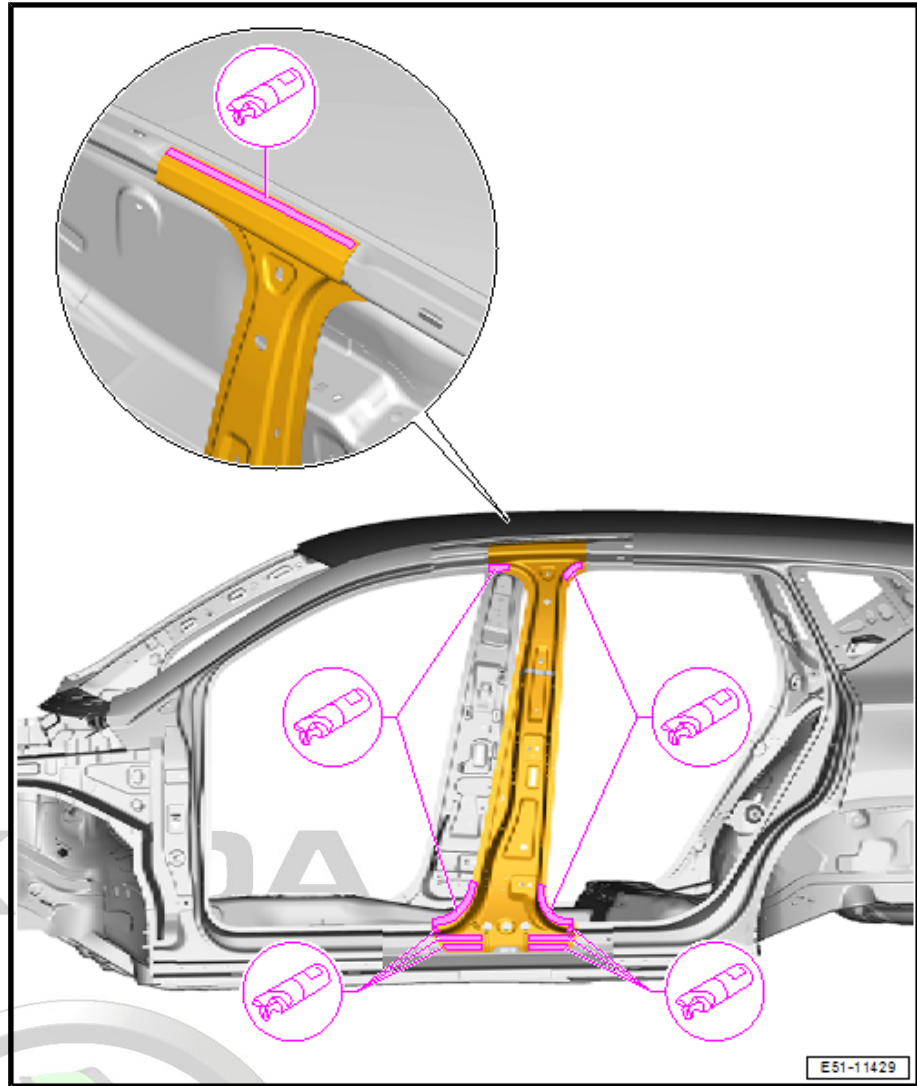


Note

When carrying out the separation cuts, ensure that the panels located at the bottom are not damaged.



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- Loosen the original welding.

7.2 Preparing the new part

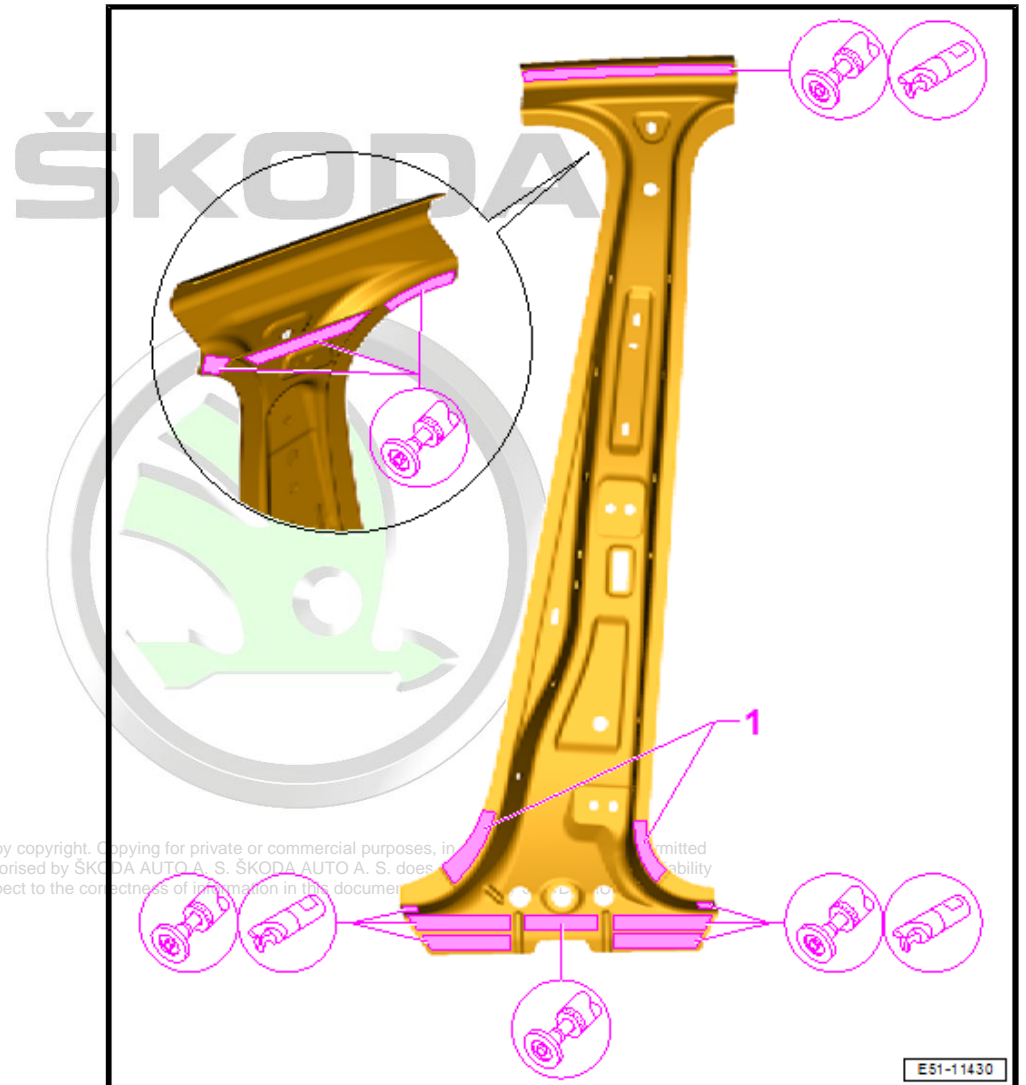


Caution

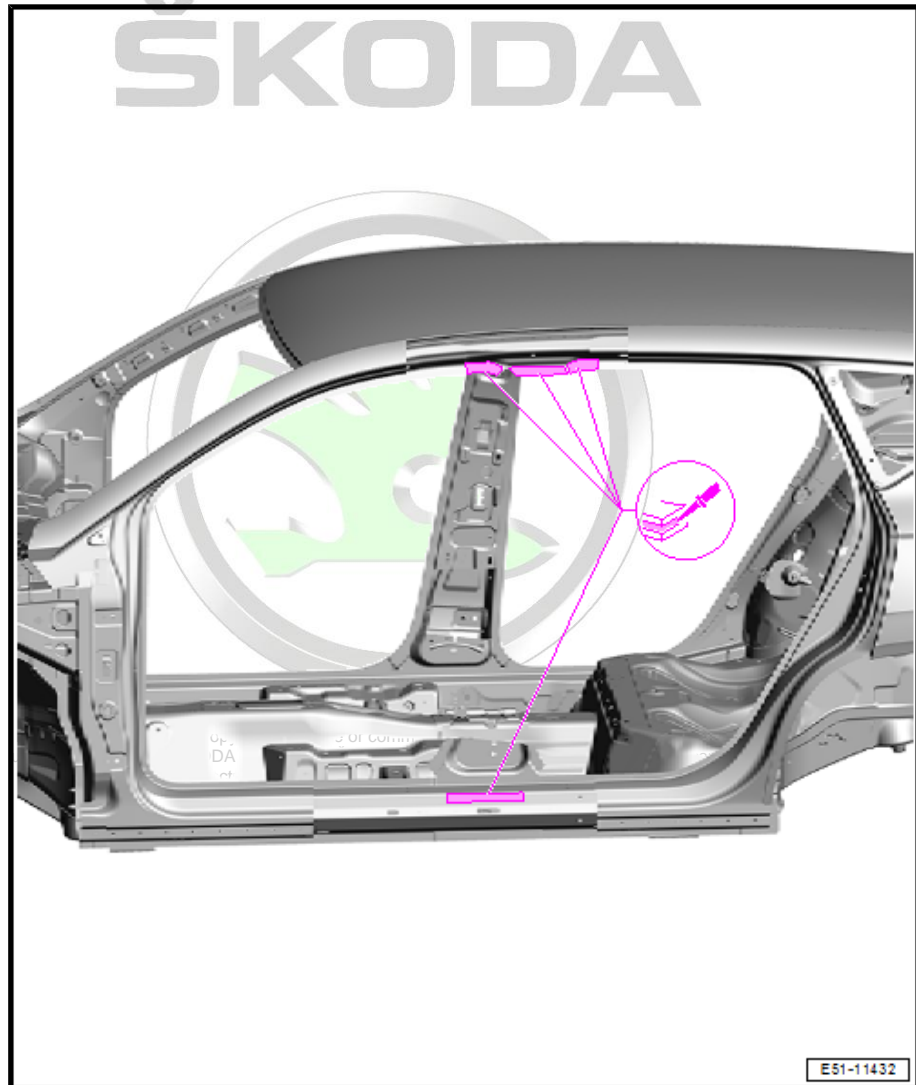
Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs

New part

- ◆ Reinforcement of B-pillar
- ◆ 2K epoxy adhesive - DA 001 730 A2
- ◆ Moulded foam parts



- Drill holes for the GS plug weld seam, 10 mm Ø.
- Prepare surfaces -1- For RP spot weld seam.



- Make sure the adhesive areas are free of dust and grease.
- Apply 2K epoxy adhesive - DA 001 730 A2- .

7.3 Moulded foam parts



Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs

Observe the repair instructions.

Moulded foam parts: ⇒ General Information; Body Repairs, General Body Repairs ; Basic Instructions, moulded foam parts

- Replace moulded foam part ⇒ [“4 Foam moulds”, page 4](#) .

7.4 Part welding



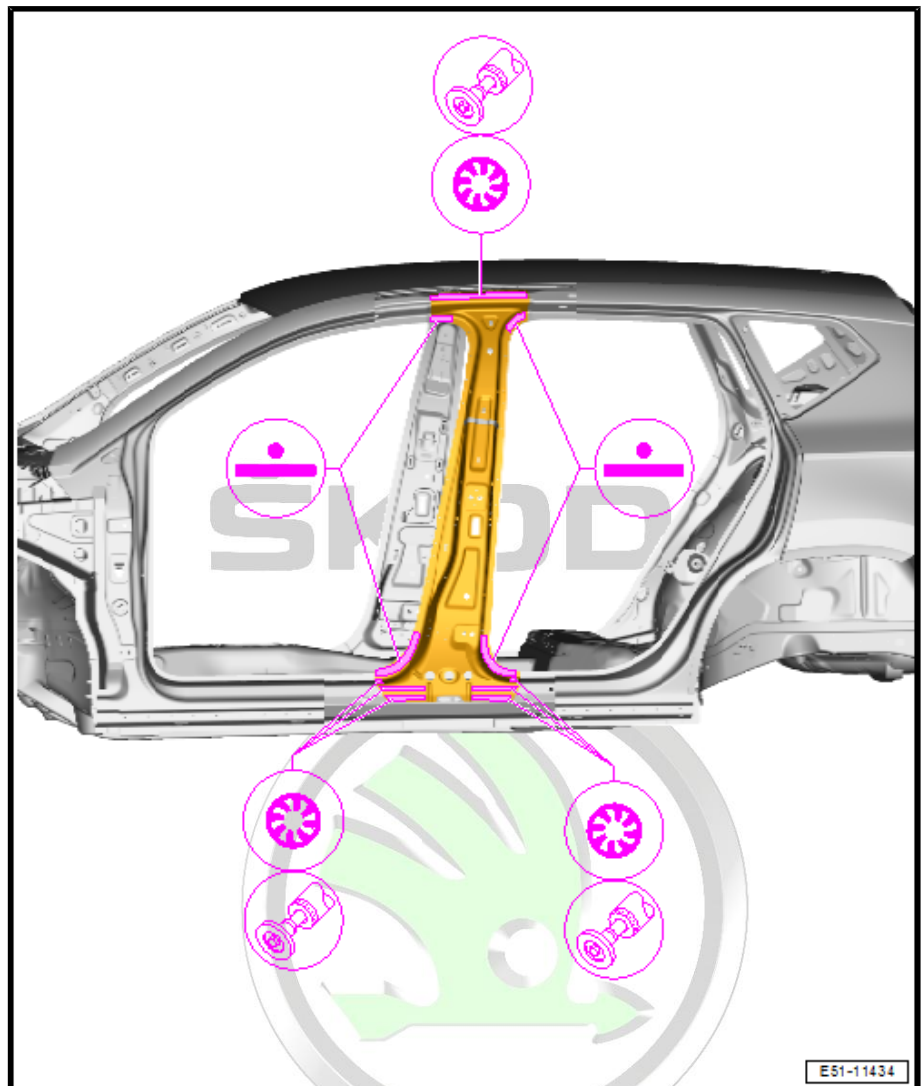
Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs



Note

The new part must be welded within 90 minutes as otherwise the adhesion of the glue may be poor.



- Adjust the new part and fix. For this purpose, the vehicle is standing on its wheels or on the straightening bracket set.
- Check the fit with component parts.
- Weld in the new part, GS plug weld seam and RP spot seam inverter.



8 Replacing the outside bottom side rail -cutoff part-

⇒ ["8.1 Removing", page 108](#)

⇒ ["8.2 Preparing the new part", page 109](#)

⇒ ["8.3 Moulded foam parts", page 110](#)

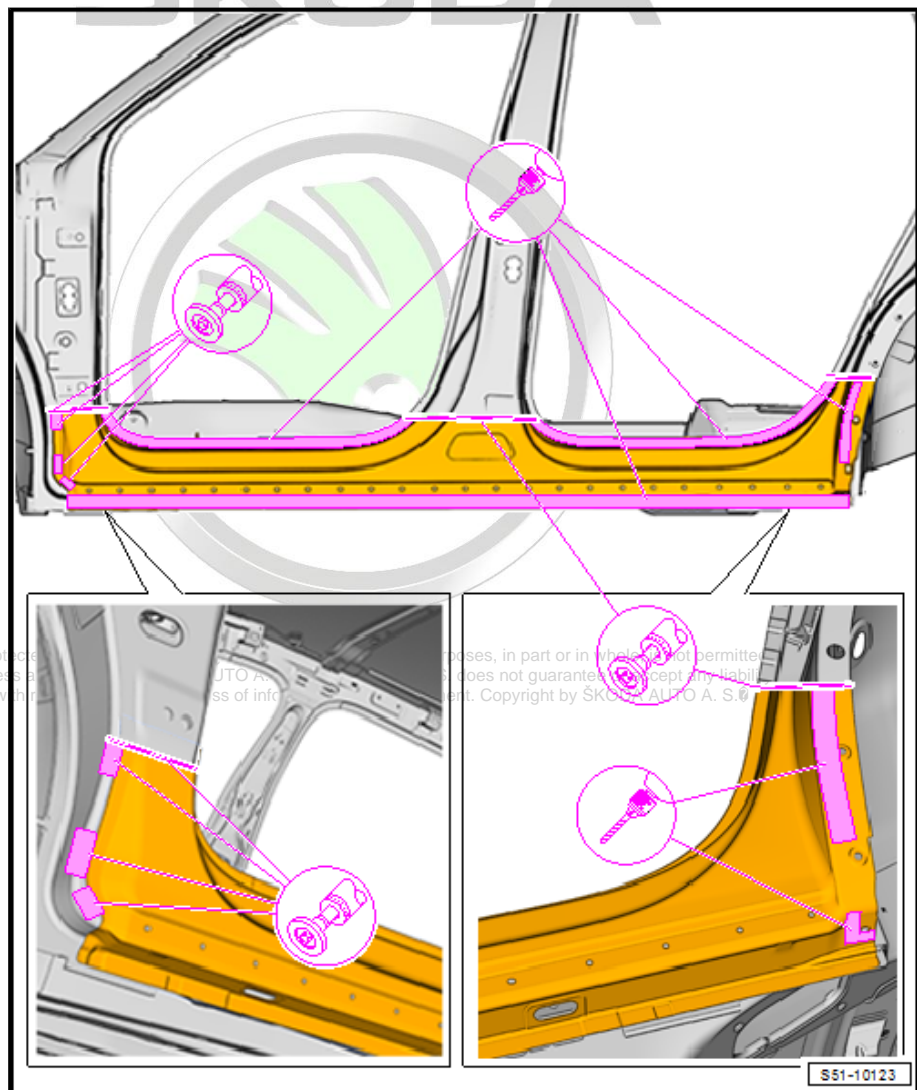
⇒ ["8.4 Part welding", page 111](#)

8.1 Removing



Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs



- Position and make the separating cuts according to the damage e.g. as shown in the figure.
- Grind through the outer side on the rear wheel arch.



- Loosen the original welding.
- Remove residues.
- Remove any residues.

8.2 Preparing the new part



Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs

New part

- ◆ Outer side rail
- ◆ 2K epoxy adhesive - DA 001 730 A2-
- Transpose the cut points onto the new part and cut to the required dimensions.
- Make sure the adhesive areas are free of dust and grease.

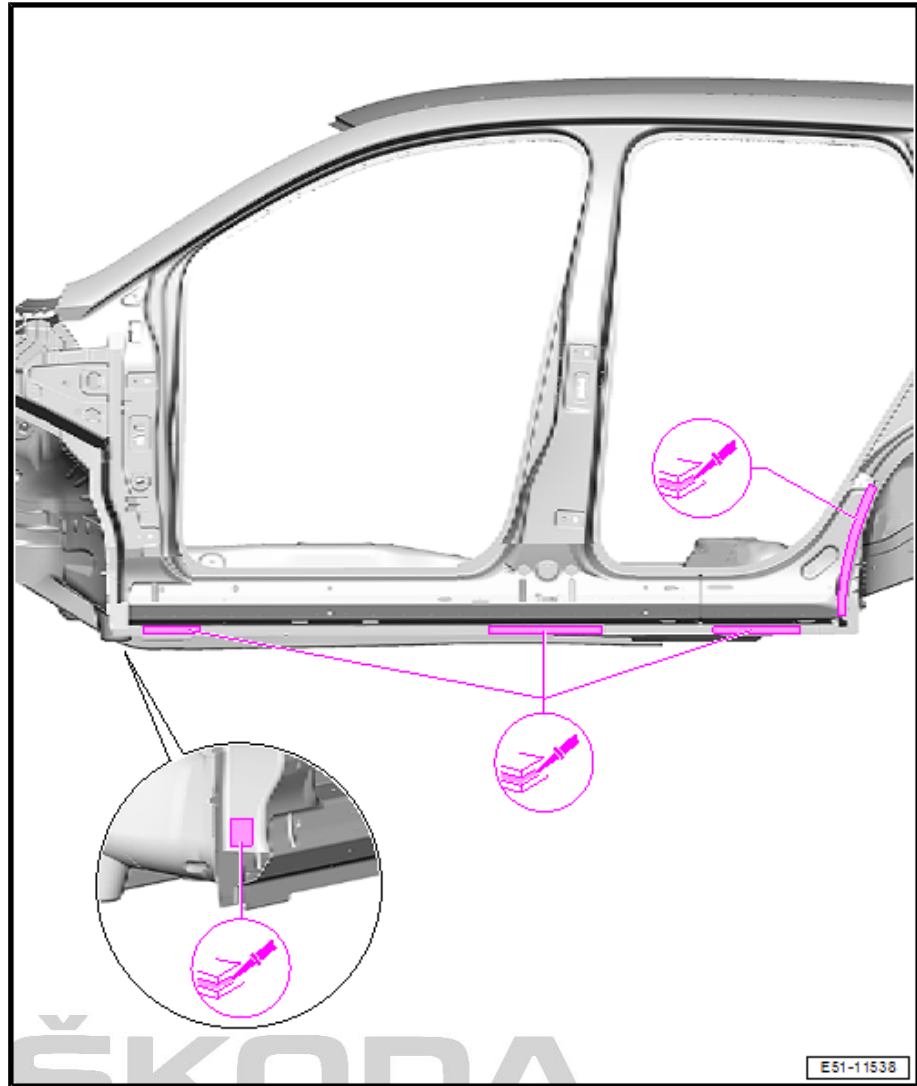


Note

The new part must be welded within 90 minutes as otherwise the adhesion of the glue may be poor.

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- Apply 2K epoxy adhesive - DA 001 730 A2- in the original areas.

8.3 Moulded foam parts



Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs

Observe the repair instructions.

Moulded foam parts: ⇒ General Information; Body Repairs, General Body Repairs ; Basic Instructions, moulded foam parts

- Replace moulded foam part ⇒ [“4 Foam moulds”, page 4](#) .



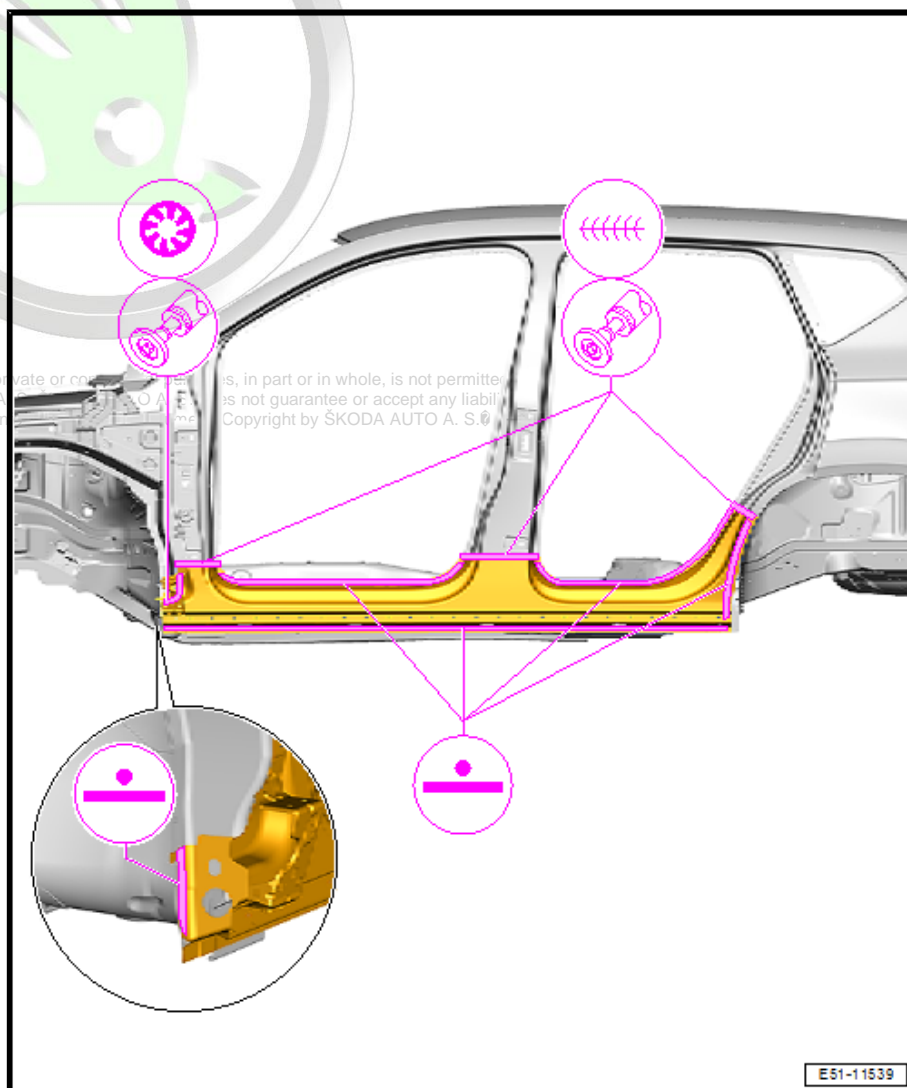
8.4 Part welding



Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs

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- Adjust the new part and fix.
- Check the fit with component parts.
- Weld in the bottom side rail, RP spot seam and inert gas shielded plug weld.
- Weld the separation cuts, an inert gas shielded full seam.
- Flange rear wheel arch strip.
- Wipe off excess glue and seal rear wheel arch.



9 Replace the bottom side rail reinforcement

⇒ ["9.1 Removing", page 112](#)

⇒ ["9.2 Preparing the new part", page 113](#)

⇒ ["9.3 Part welding", page 114](#)

9.1 Removing

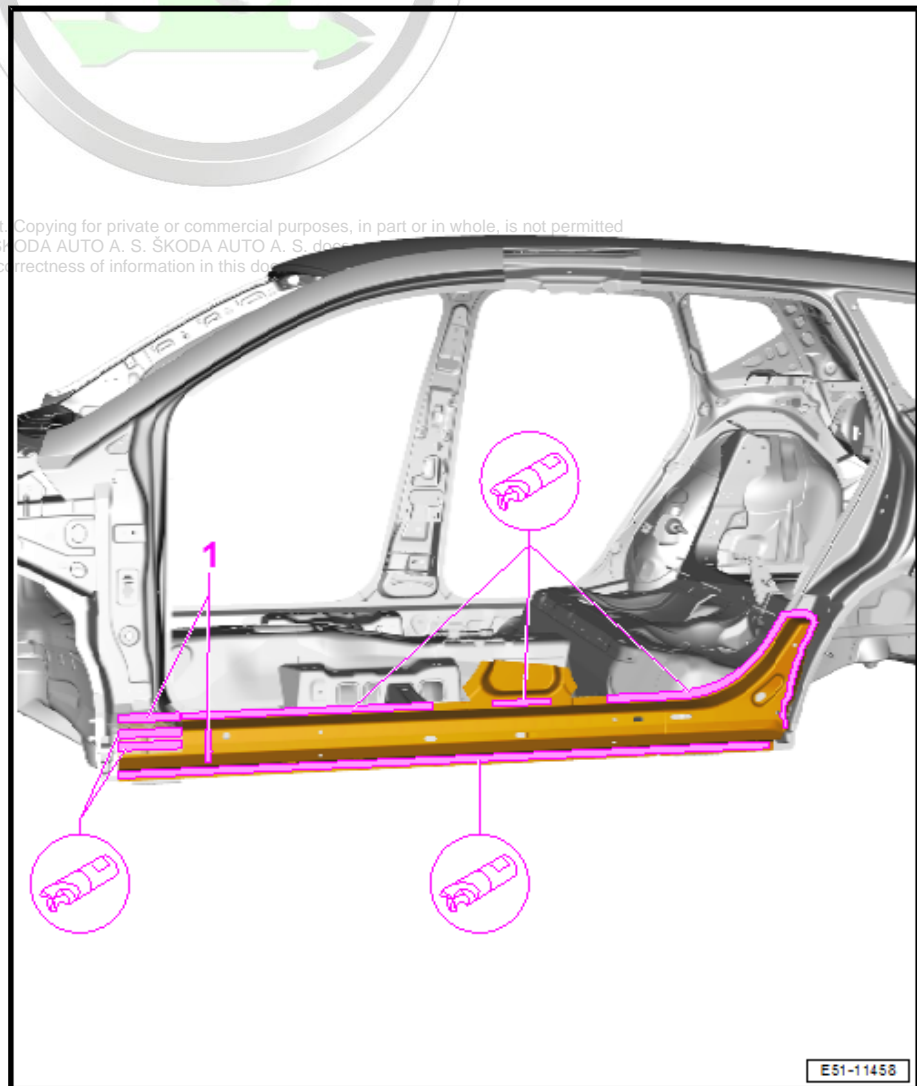


Caution

Follow the general notes! → General Information; Body Repairs, General Body Repairs

Exterior panels and reinforcement B-pillar already removed.

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– Loosen the original welding.

Lower back reinforcement can be removed separately and on an individual basis.

- Remove the front area and inner part -1-.
- Remove residues.
- Remove any residues.

9.2 Preparing the new part

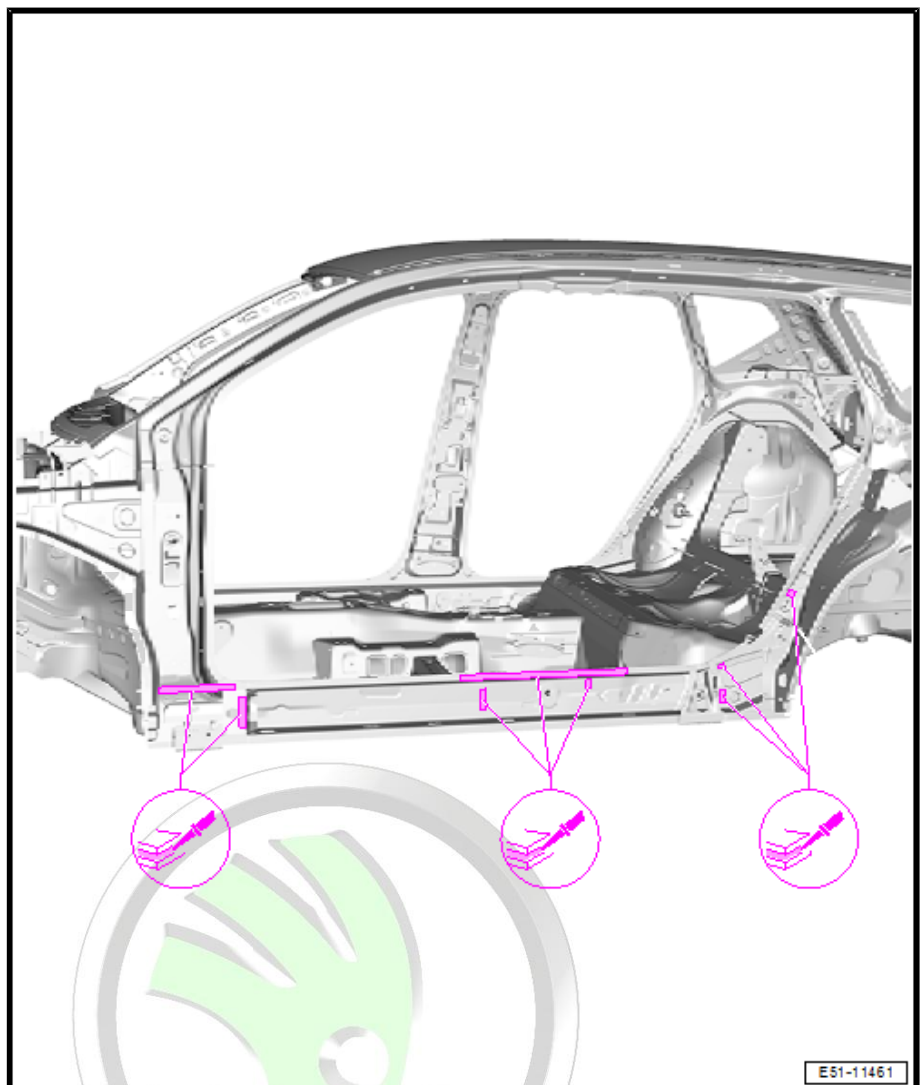


Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs

New part

- ◆ Reinforcement of bottom side rail
- ◆ 2K epoxy adhesive - DA 001 730 A2-



- Apply 2K epoxy adhesive - DA 001 730 A2- in the original areas.

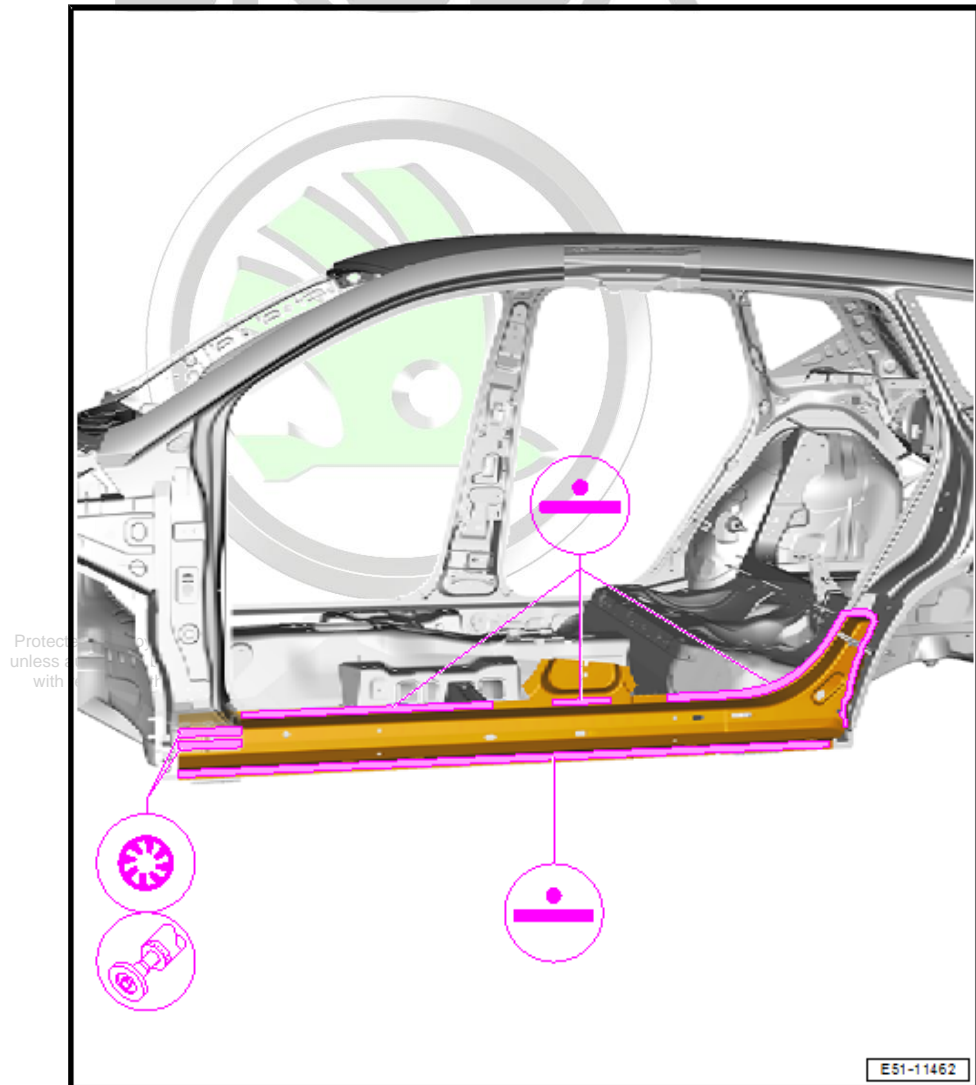


9.3 Part welding



Caution

Follow the general notes! → General Information; Body Repairs, General Body Repairs



- Adjust the new part and fix.
- Check the fit with component parts.
- Weld in the new part, GS plug weld seam and RP spot seam inverter.



53 – Body - rear

1 Replacing outer rear side part -cutoff part-

⇒ [“1.1 Removing”, page 115](#)

⇒ [“1.2 Preparing the new part”, page 117](#)

⇒ [“1.3 Moulded foam parts”, page 118](#)

⇒ [“1.4 Part welding”, page 118](#)

1.1 Removing



Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs



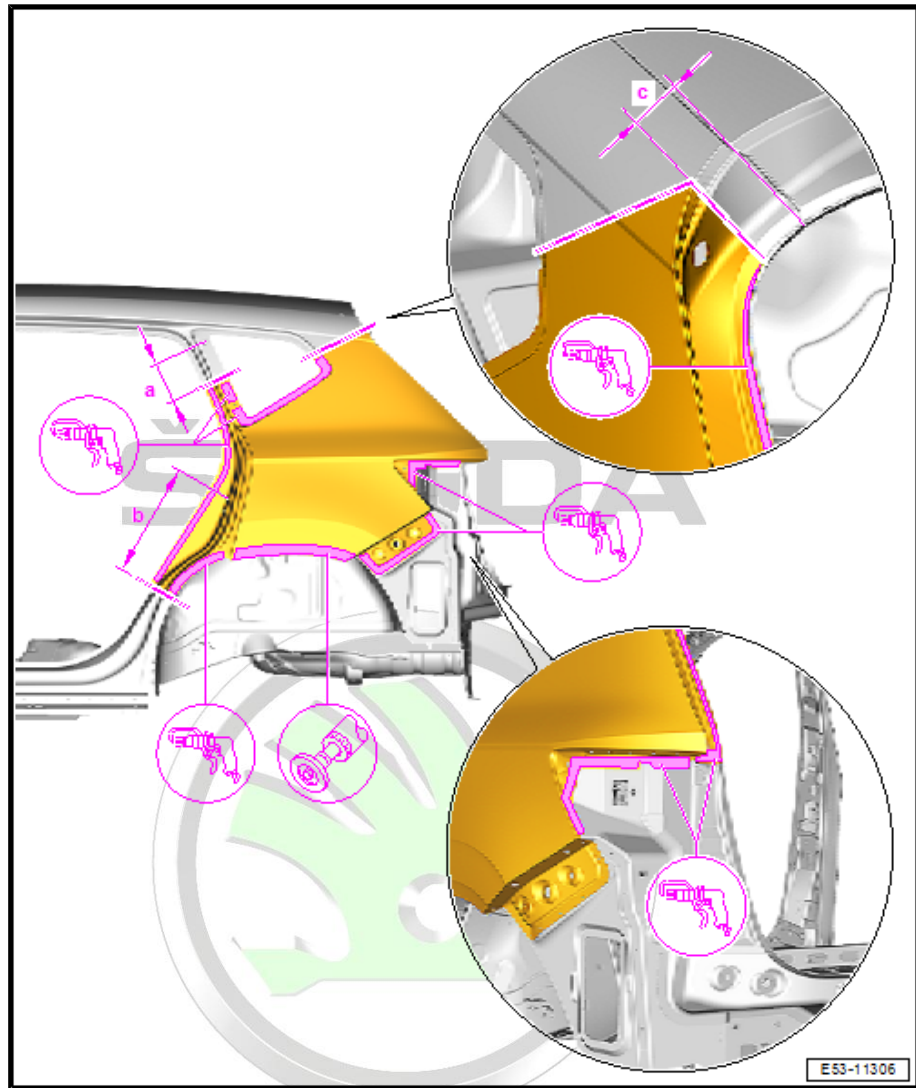
Note

When carrying out the separation cuts, do not damage the inside panels.

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- Position and make the separating cuts according to the damage e.g. as shown in the figure.

-a- = 60 mm.

-b- = 310 mm

-c- = 50 mm

- Grind through the outer edge of the wheel arch.
- Loosen the original welding.
- Loosen the original welding in the tailgate cutout.
- Remove residues.
- Remove any residues.
- Make sure that the border area on the wheel arch is free from dust and grease.

1.2 Preparing the new part

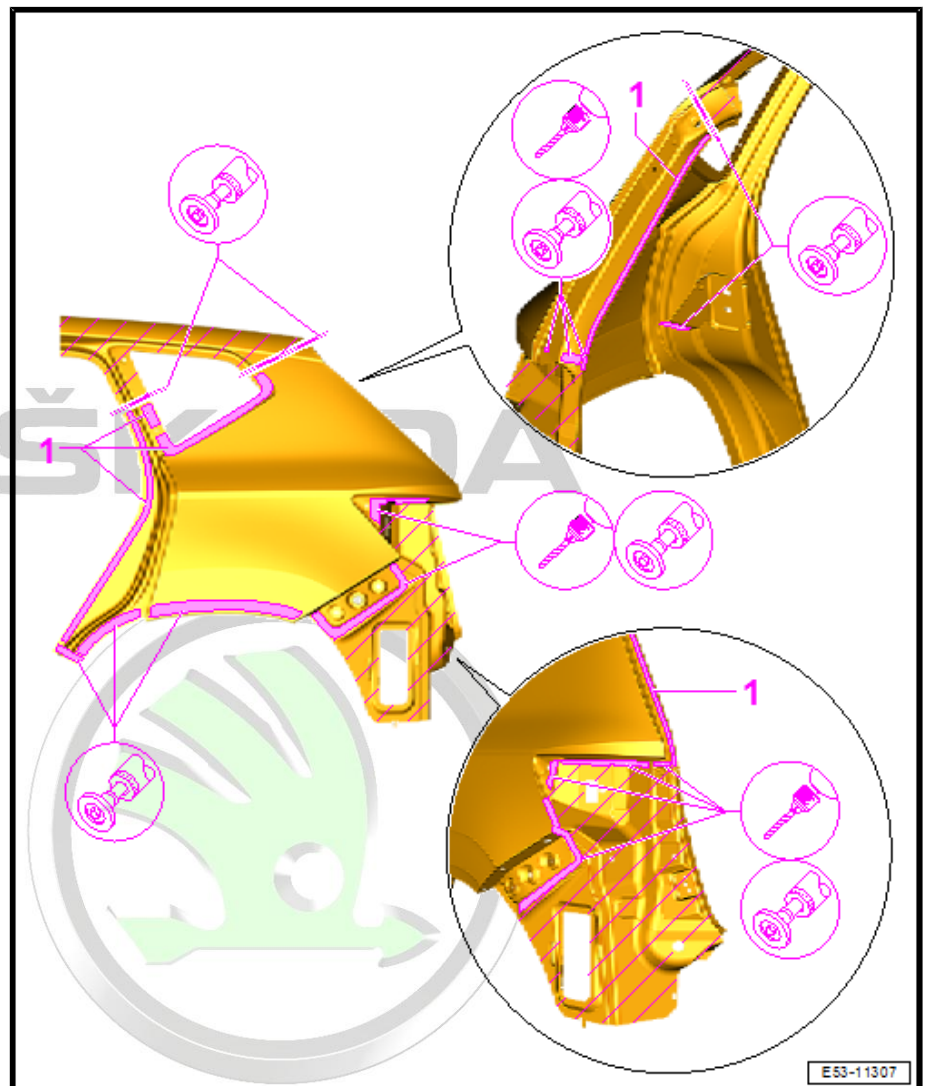


Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs

New part

- ◆ Outer rear side part – wing
- ◆ 2K epoxy adhesive - DA 001 730 A2-
- ◆ Butyl adhesive sealing cord



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- Transpose the cut points onto the new part and cut to the required dimensions.
- Make holes \varnothing 8 mm for GS plug weld seam.
- Prepare surfaces -1- For RP spot weld seam.
- Slightly grind out the adhesive surfaces.
- Make sure the border areas are free of dust and grease.



1.3 Moulded foam parts



Caution

Follow the general notes! → General Information; Body Repairs, General Body Repairs

Observe the repair instructions.

Moulded foam parts: ⇒ General Information; Body Repairs, General Body Repairs ; Basic Instructions, moulded foam parts

- Replace moulded foam part ⇒ [“4 Foam moulds”, page 4](#) .

1.4 Part welding



Caution

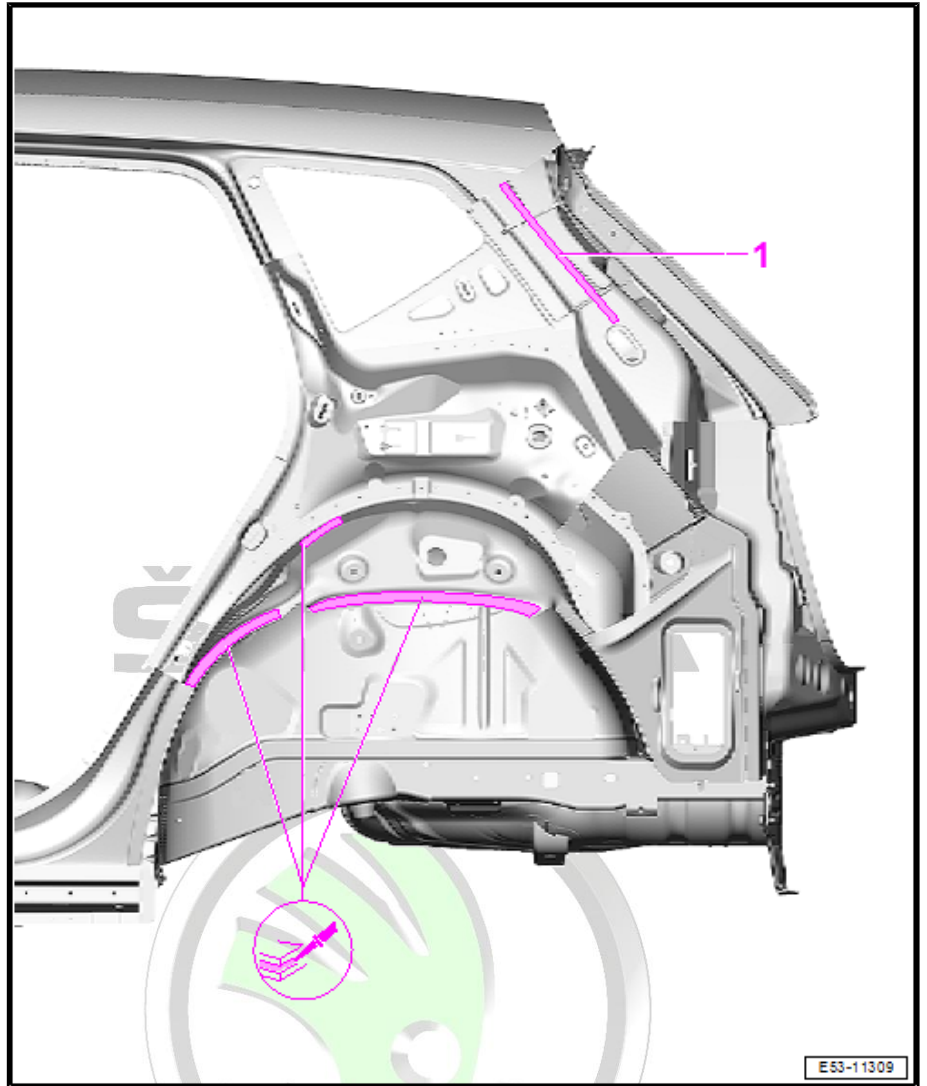
Follow the general notes! → General Information; Body Repairs, General Body Repairs



Note

- ◆ *The new part must be welded within 90 minutes as otherwise the adhesion of the glue may be poor.*
 - ◆ *2K epoxy adhesive - DA 001 730 A2- must be applied on the right side part wing in the area of the fuel filler neck before welding in.*
- Adjust the new part and fix. For this purpose, the vehicle is standing on its wheels or on the straightening bracket set .

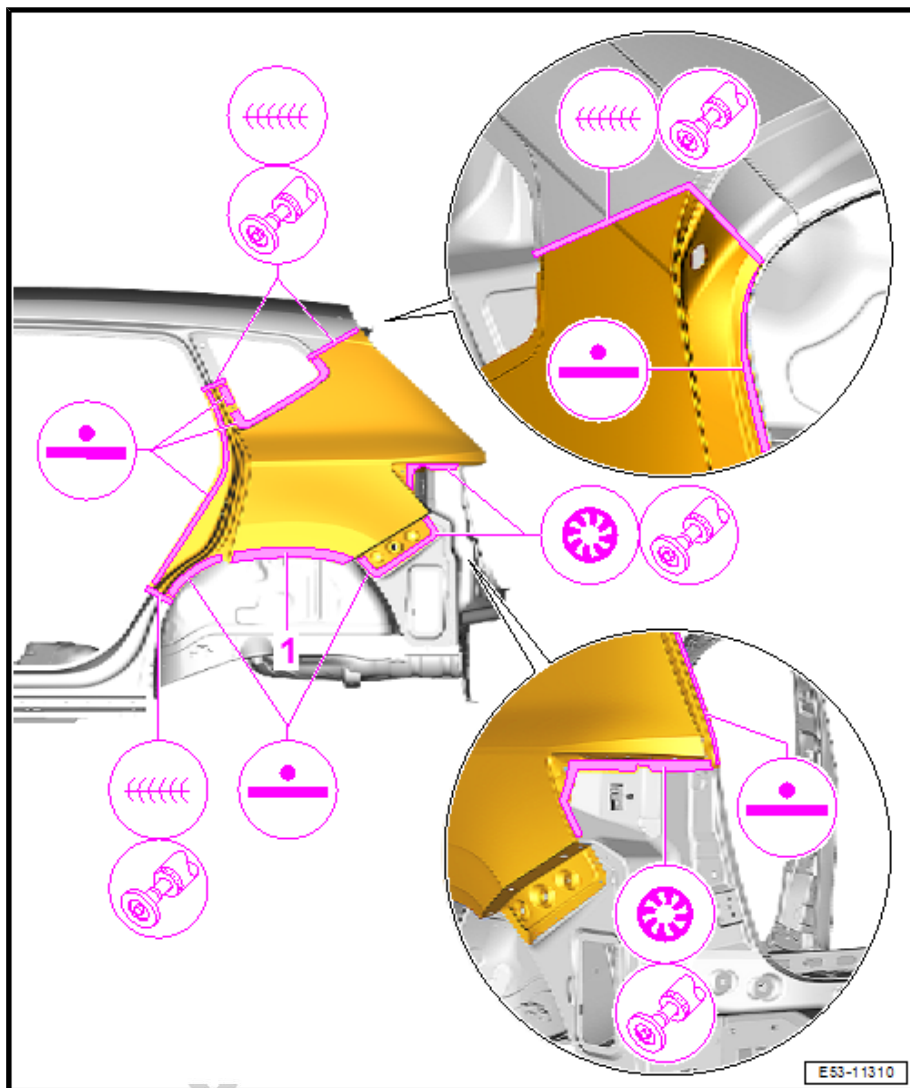
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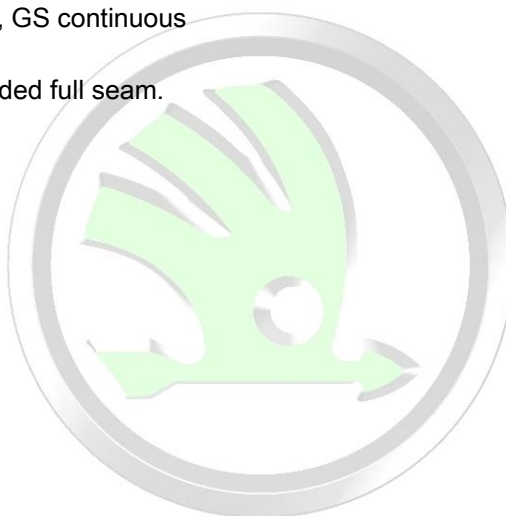
Apply butyl adhesive sealing cord in the original area -1-.

- Apply 2K epoxy adhesive - DA 001 730 A2- in the original adhesive areas on the production side.

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- Adjust the new part and fix. For this purpose, the vehicle is standing on its wheels or on the straightening bracket set .
- Check the fit with component parts.
- Weld in the side panel, GS plug weld seam, GS continuous seam and RP spot weld seam.
- Weld the separation cuts, an inert gas shielded full seam.
- Flange wheel arch strip -1-.
- Wipe off excess glue and seal wheel arch.



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2 Replacing the outer wheelhouse - part-

⇒ ["2.1 Removing", page 121](#)

⇒ ["2.2 Part welding", page 122](#)

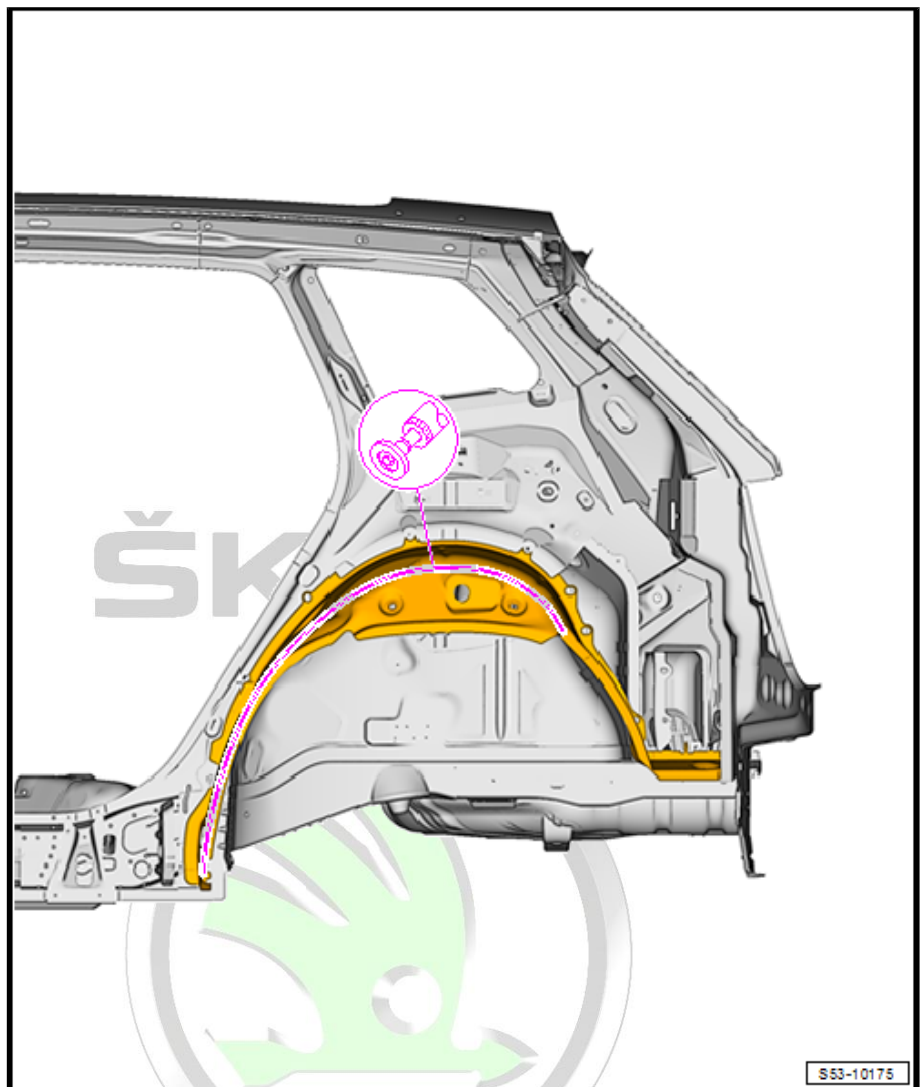
2.1 Removing



Caution

Follow the general notes! → General Information; Body Repairs, General Body Repairs

Outer panels already removed.



- Make the cut point according to the severity of the damage.
- Remove residues.
- Remove any residues.

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2.2 Part welding

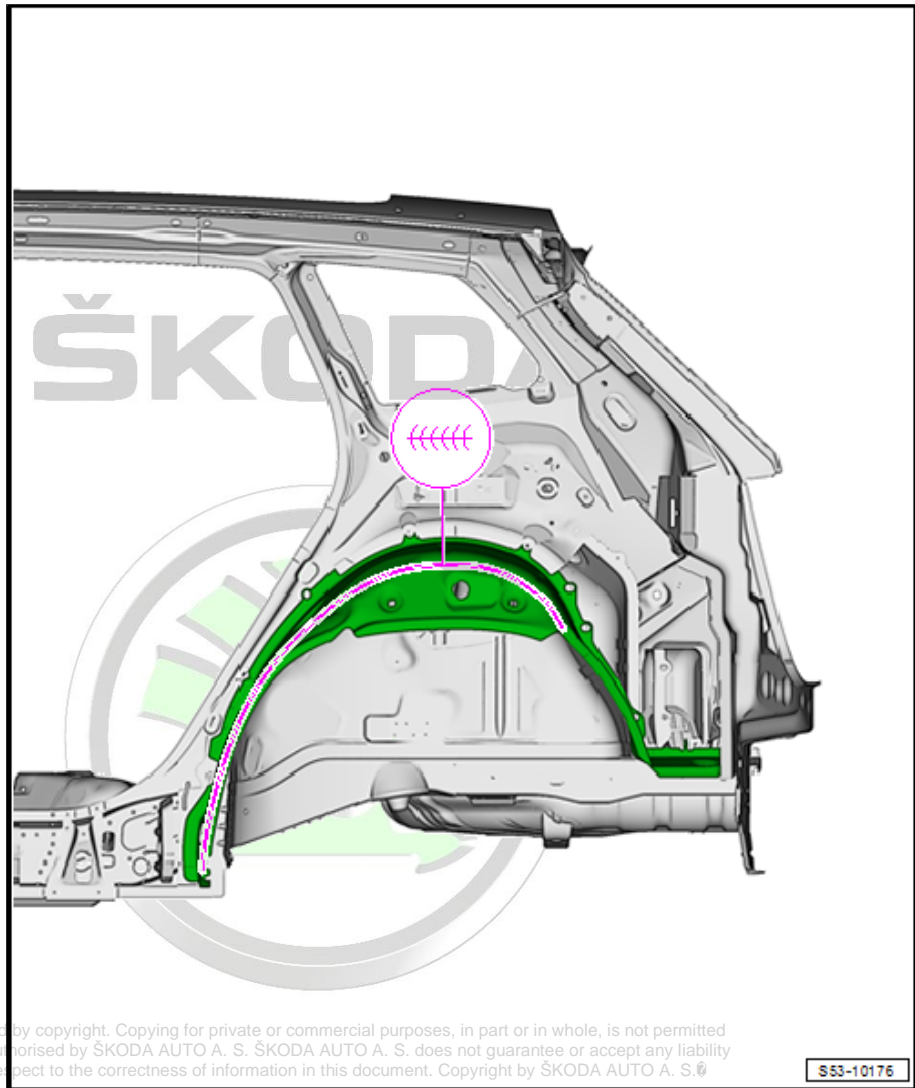


Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs

New part

- ◆ The wheel house on the outside
- Transfer separating cut to new part and cut to the required dimensions.



- Attach the wheel house on the outside
- Attach the wing at the rear and check the size of the gap with the vehicle unloaded.
- Remove the rear wing.
- Weld the separation cuts, an inert gas shielded full seam.

3 Replacing the support of the tail light

⇒ "3.1 Removing", page 123

⇒ "3.2 Preparing the new part", page 124

⇒ "3.3 Part welding", page 124

3.1 Removing

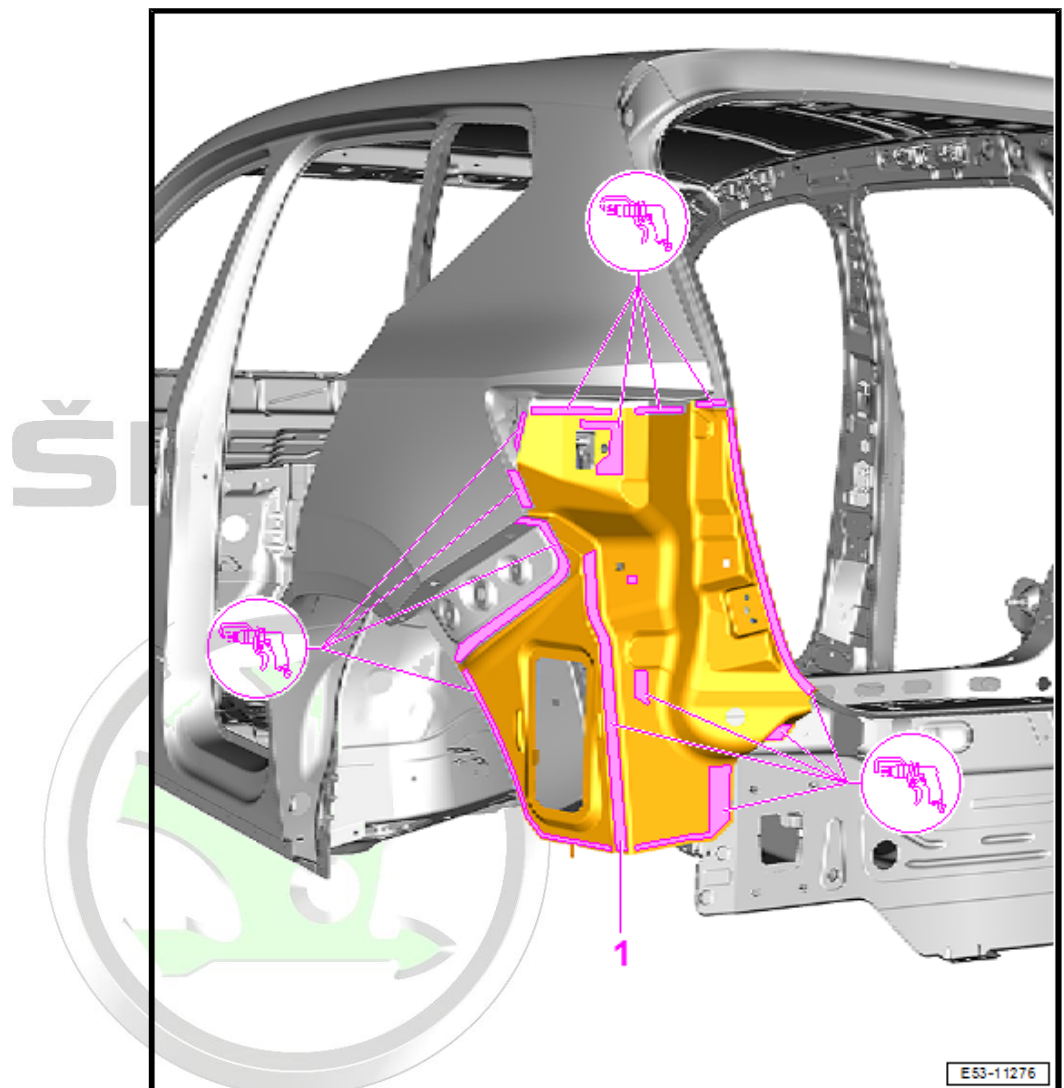


Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs

End cover cross member already removed.

Part can be cut to size, depending on damage.



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- Loosen the original welding.
 - Remove residues.
 - Remove any residues.



3.2 Preparing the new part

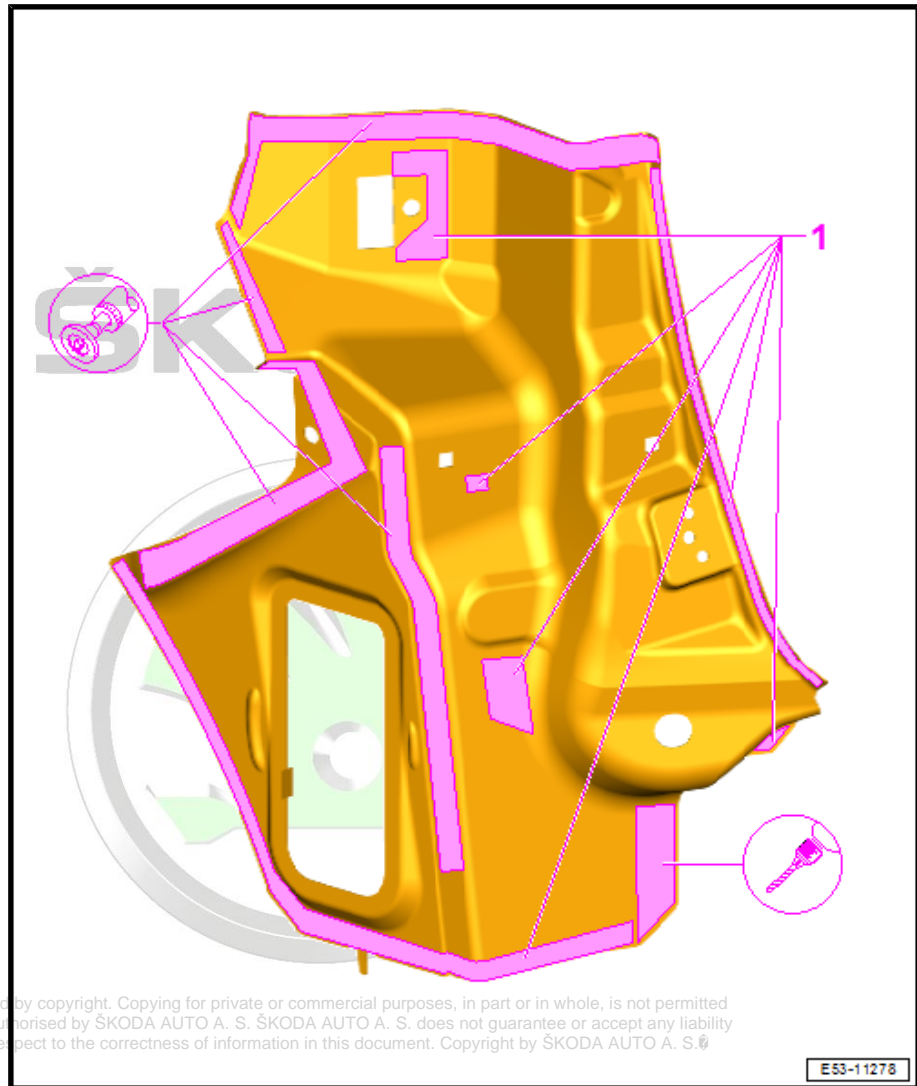


Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs

New part

- ◆ Support of tail light



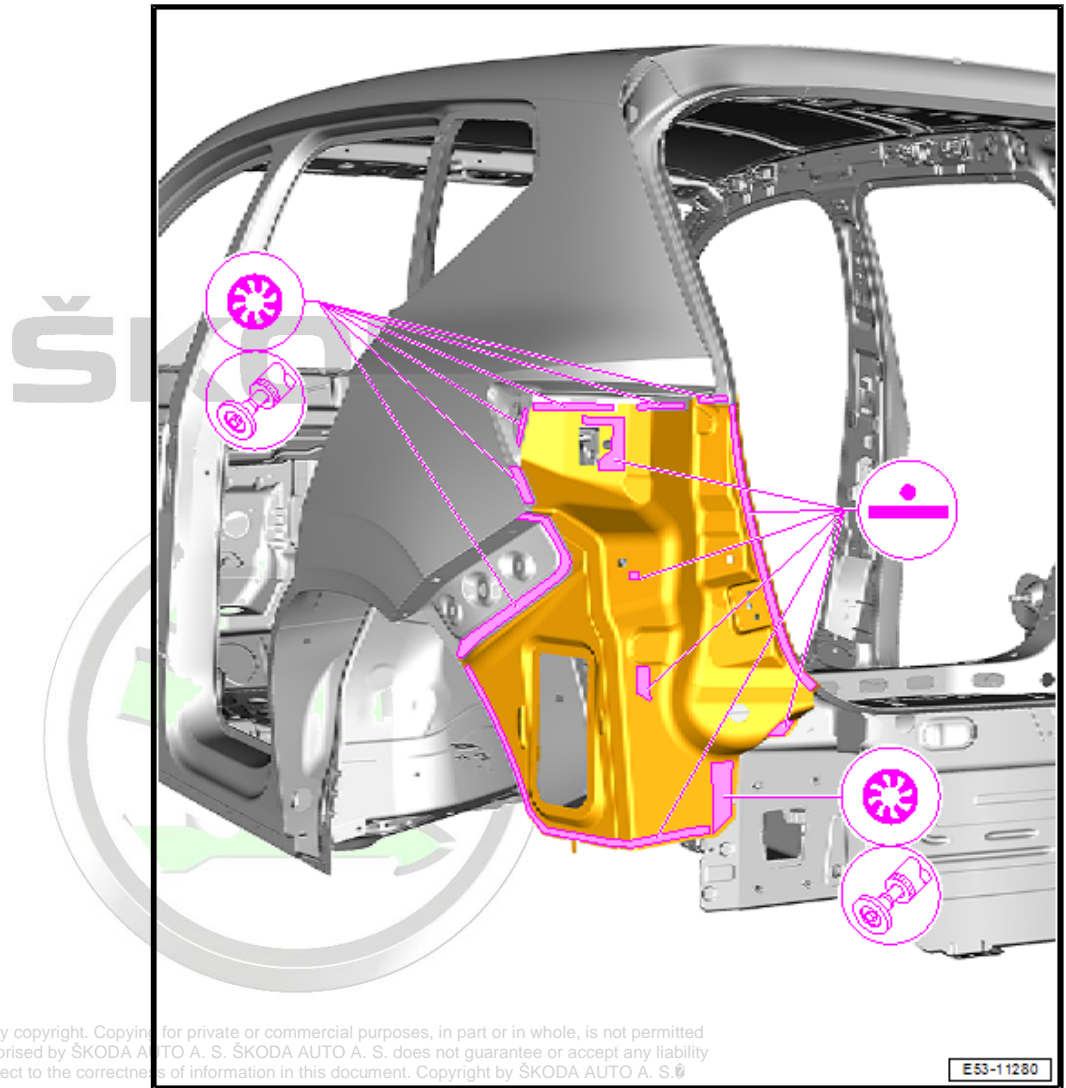
- Create holes for the GS plug weld seam, \varnothing 8 mm.
- Prepare surfaces -1- For RP spot weld seam.

3.3 Part welding

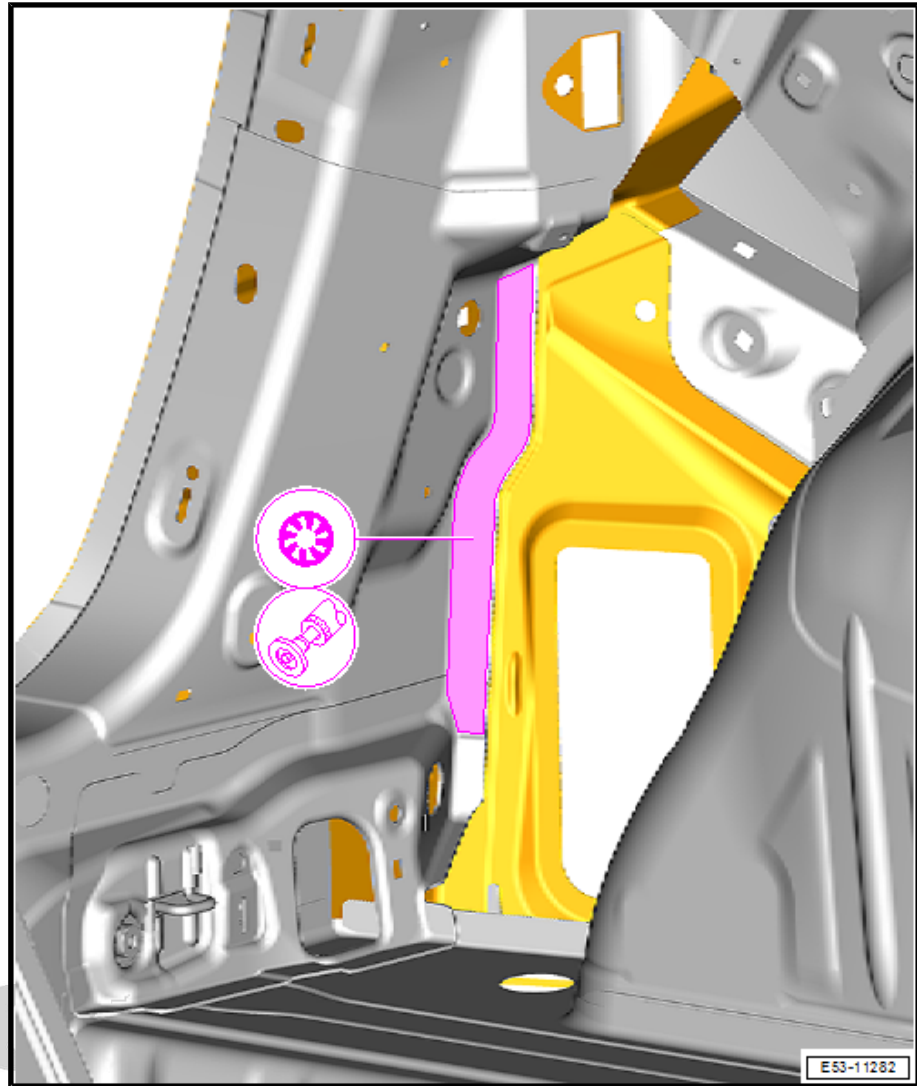


Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs



- Adjust the new part and fix. For this purpose, the vehicle is standing on its wheels or on the straightening bracket set .
- Check the fit with component parts.
- Check the fit of the tail light with the tailgate and the side part.
- Weld in the new part, RP spot seam and inert gas shielded plug weld.



- Weld in the new part from inside, GS plug weld seam.



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4 Replacing sealing channel -part-

⇒ [“4.1 Removing”, page 127](#)

⇒ [“4.2 Preparing the new part”, page 128](#)

⇒ [“4.3 Part welding”, page 129](#)

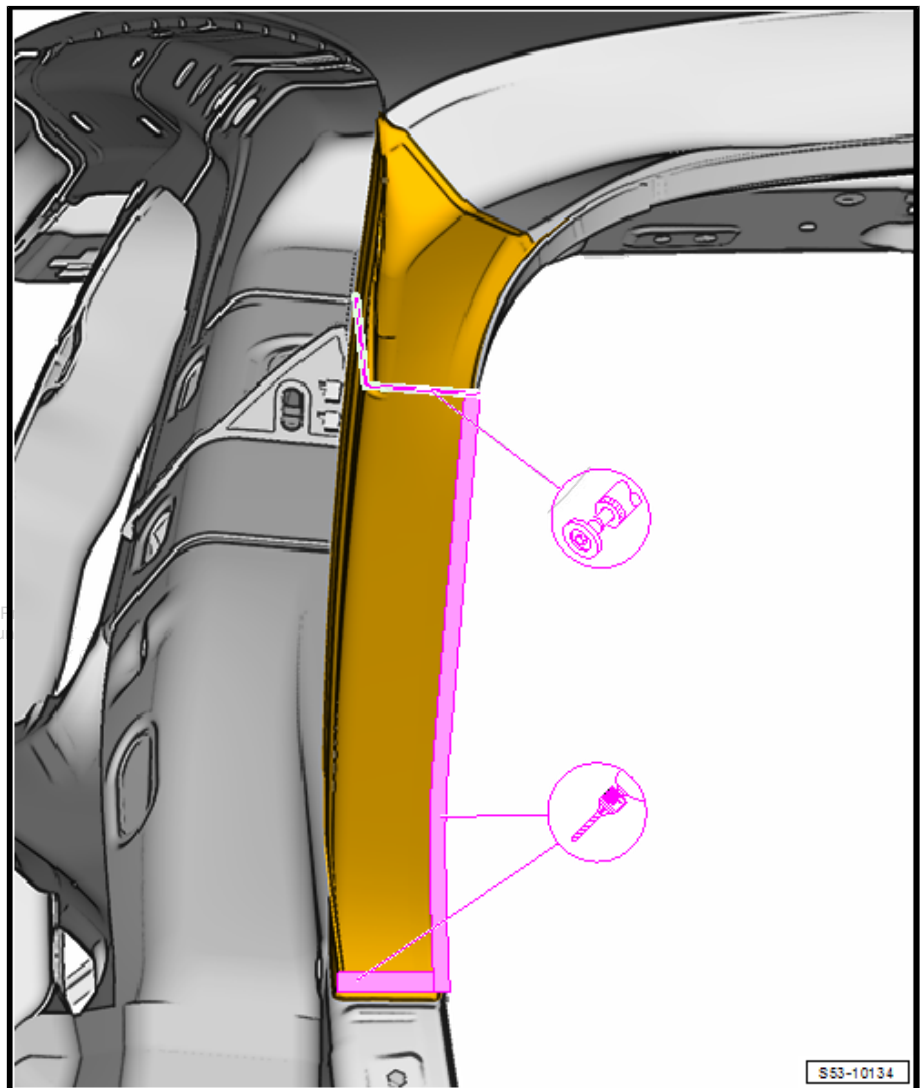
4.1 Removing



Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs

Outer rear side part - wing already separated.



- Perform separation cut of sealing channel, depending on damage.
- Loosen the original welding.
- Remove residues.



- Remove any residues.

4.2 Preparing the new part



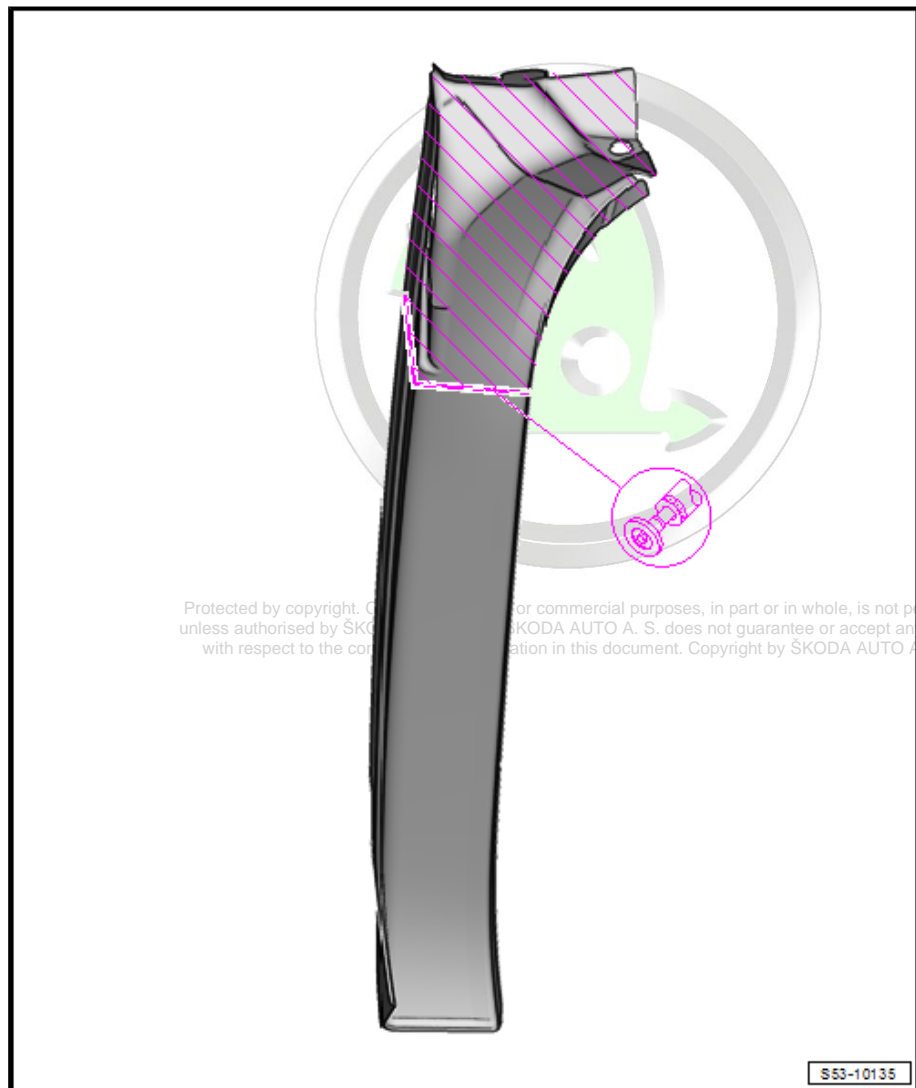
Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs

New part

- ◆ Sealing channel

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- Transfer separating cut to new part and cut to the required dimensions.

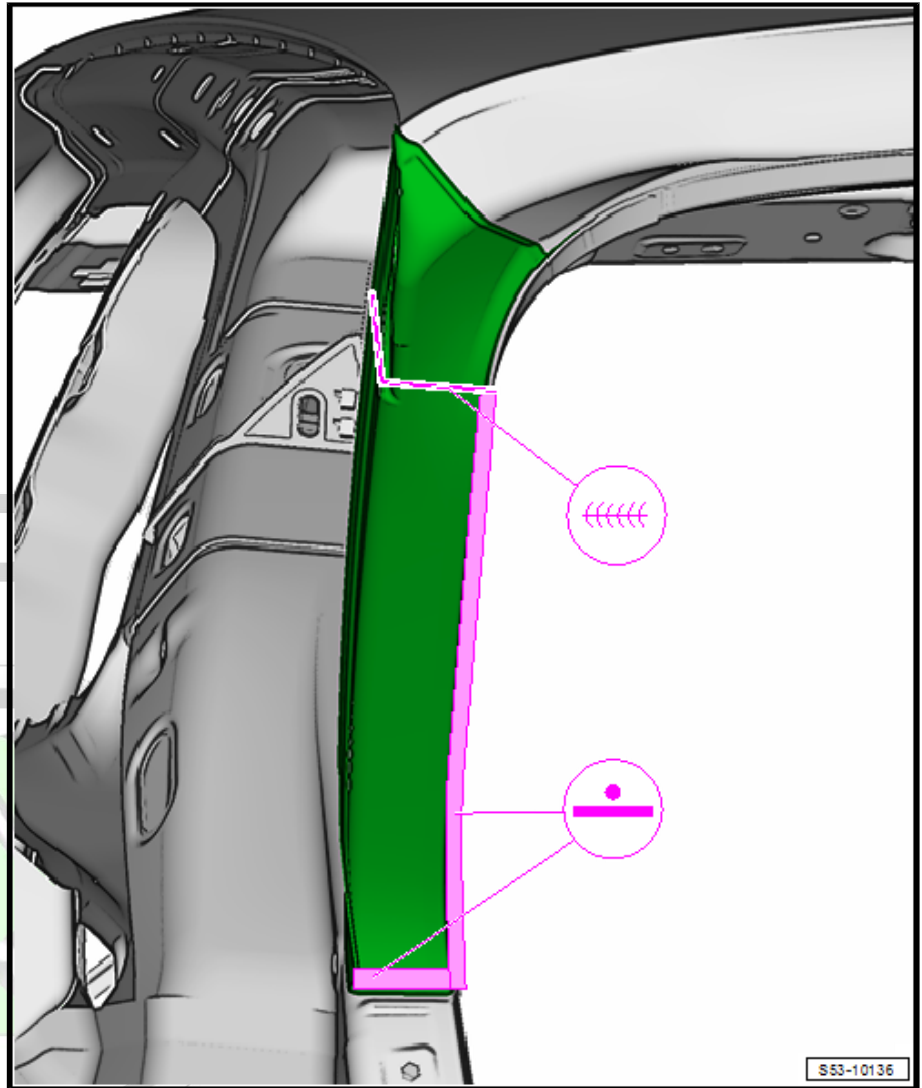


4.3 Part welding



Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs



- Fit the new parts and fix.
- Check the fit with component parts.
- Weld the separation cuts, an inert gas shielded full seam.
- Weld in the part, RP spot weld seam.

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5 Replacing the end cover cross member

⇒ ["5.1 Removing", page 130](#)

⇒ ["5.2 Preparing the new part", page 131](#)

⇒ ["5.3 Part welding", page 132](#)

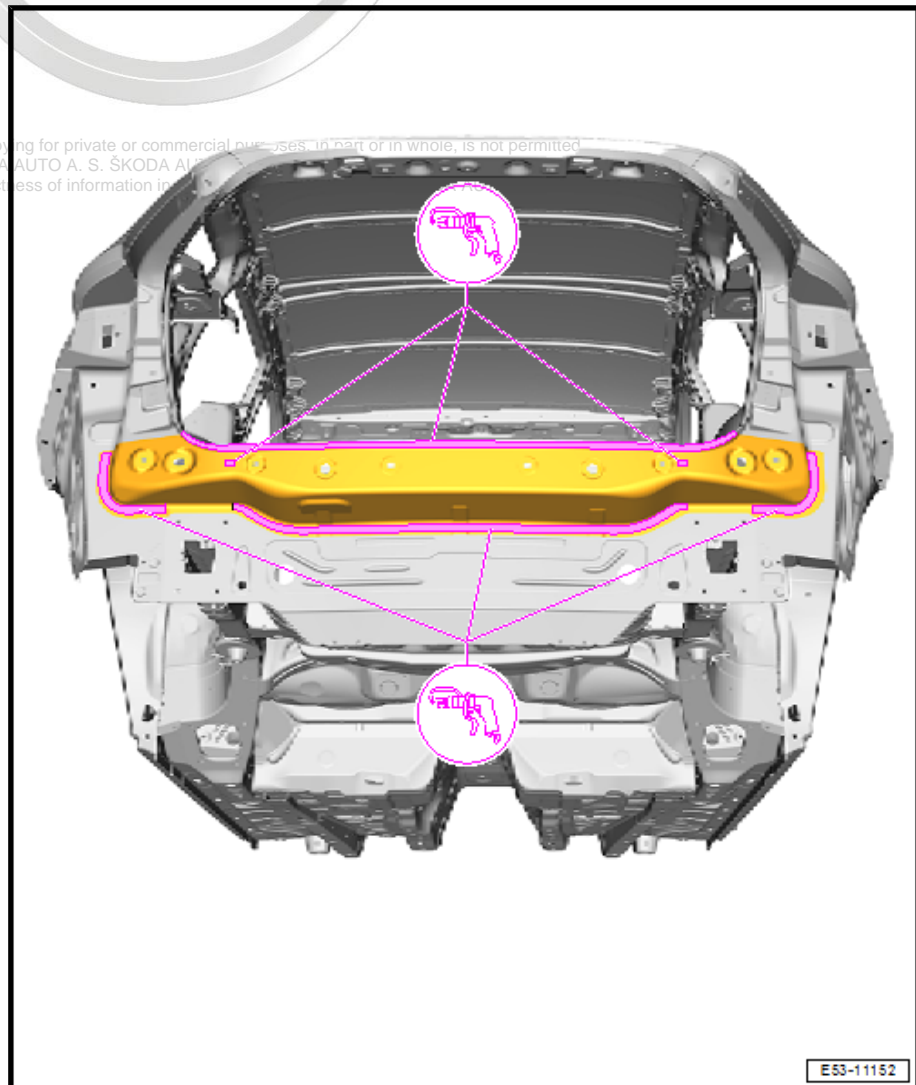
5.1 Removing



Caution

Follow the general notes! → General Information; Body Repairs, General Body Repairs

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- Loosen the original welding.
- Part can be cut to size, depending on damage.
- Remove residues.
- Remove any residues.

5.2 Preparing the new part

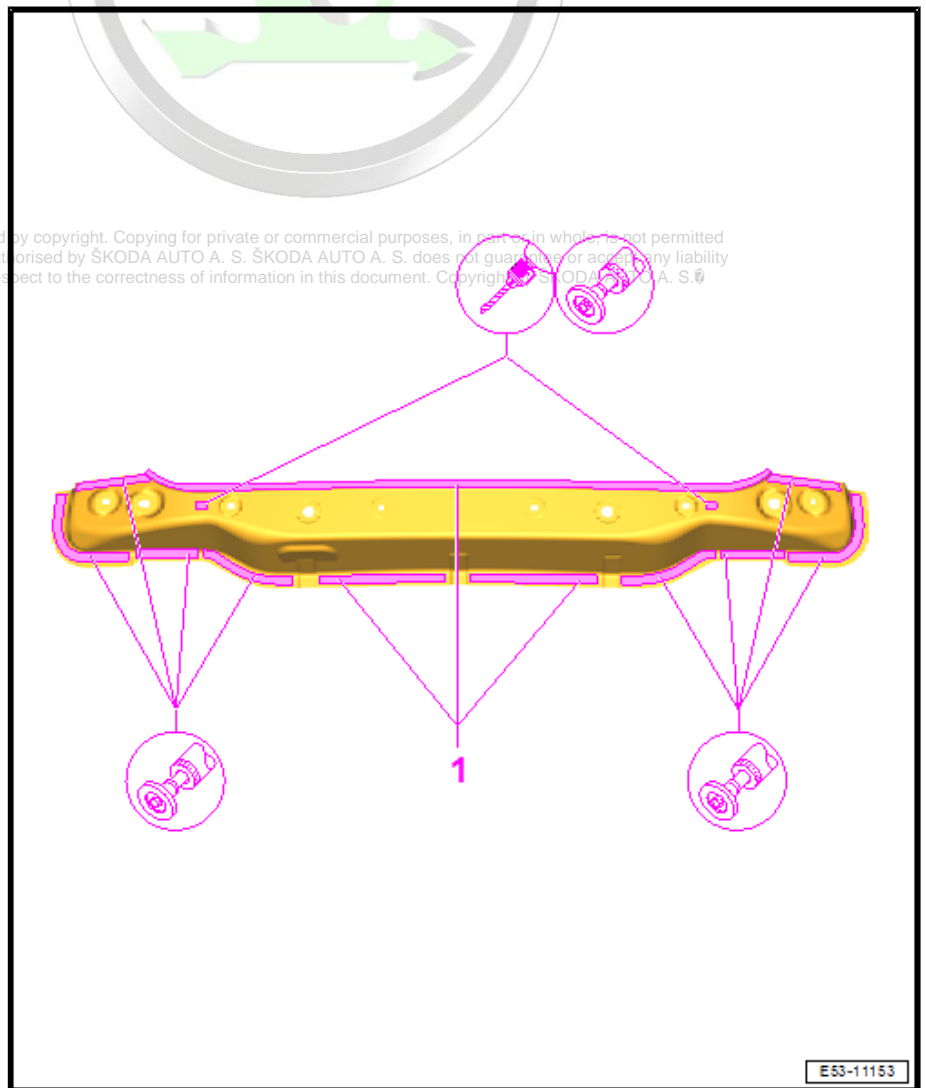


Caution

Follow the general notes! → General Information; Body Repairs, General Body Repairs

New part

- ◆ End cover cross member
- ◆ 2K epoxy adhesive - DA 001 730 A2-

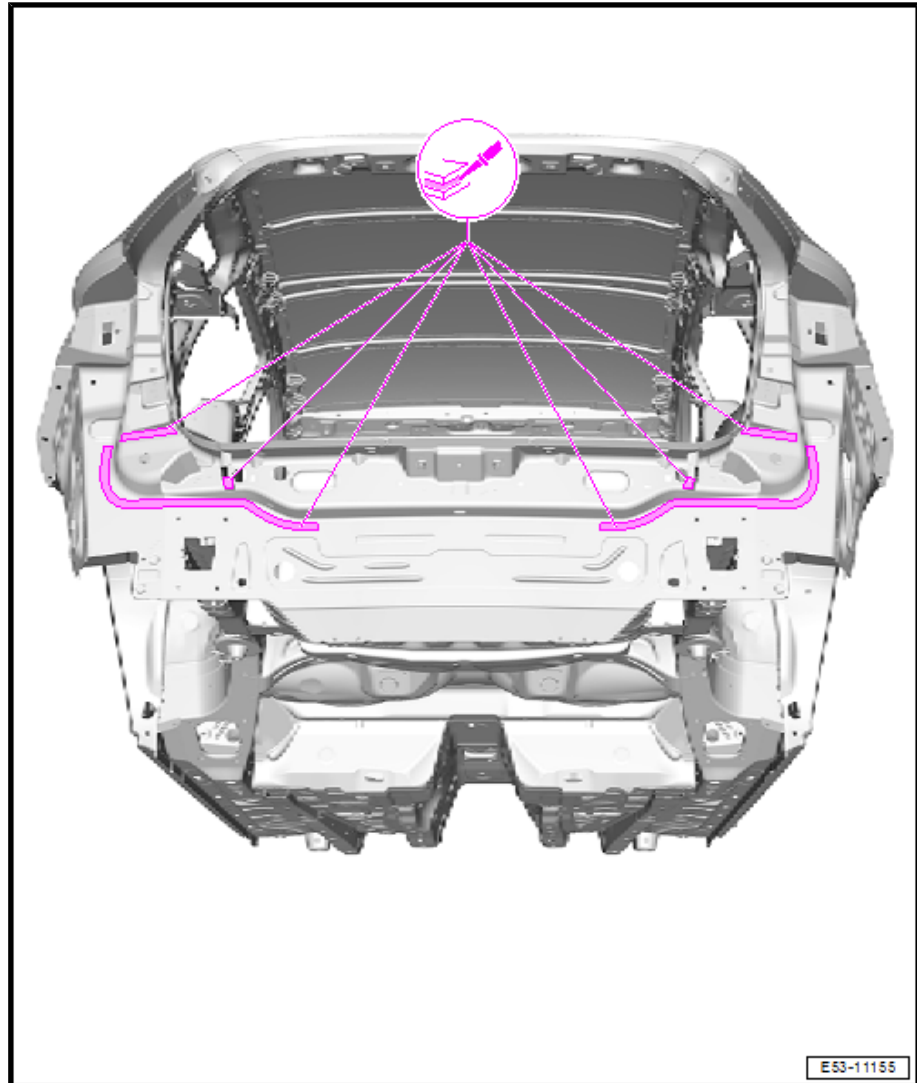


- Create holes for the GS plug weld seam, \varnothing 8 mm.
- Prepare surfaces -1- For RP spot weld seam.



Note

The new part must be welded within 90 minutes as otherwise the adhesion of the glue may be poor.



- Apply 2K epoxy adhesive - DA 001 730 A2- in the original areas.

5.3 Part welding

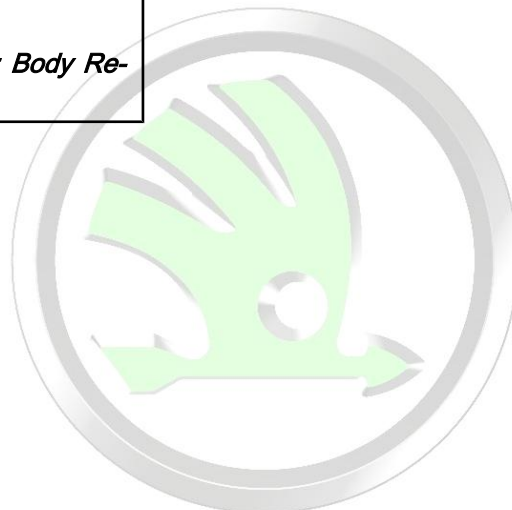


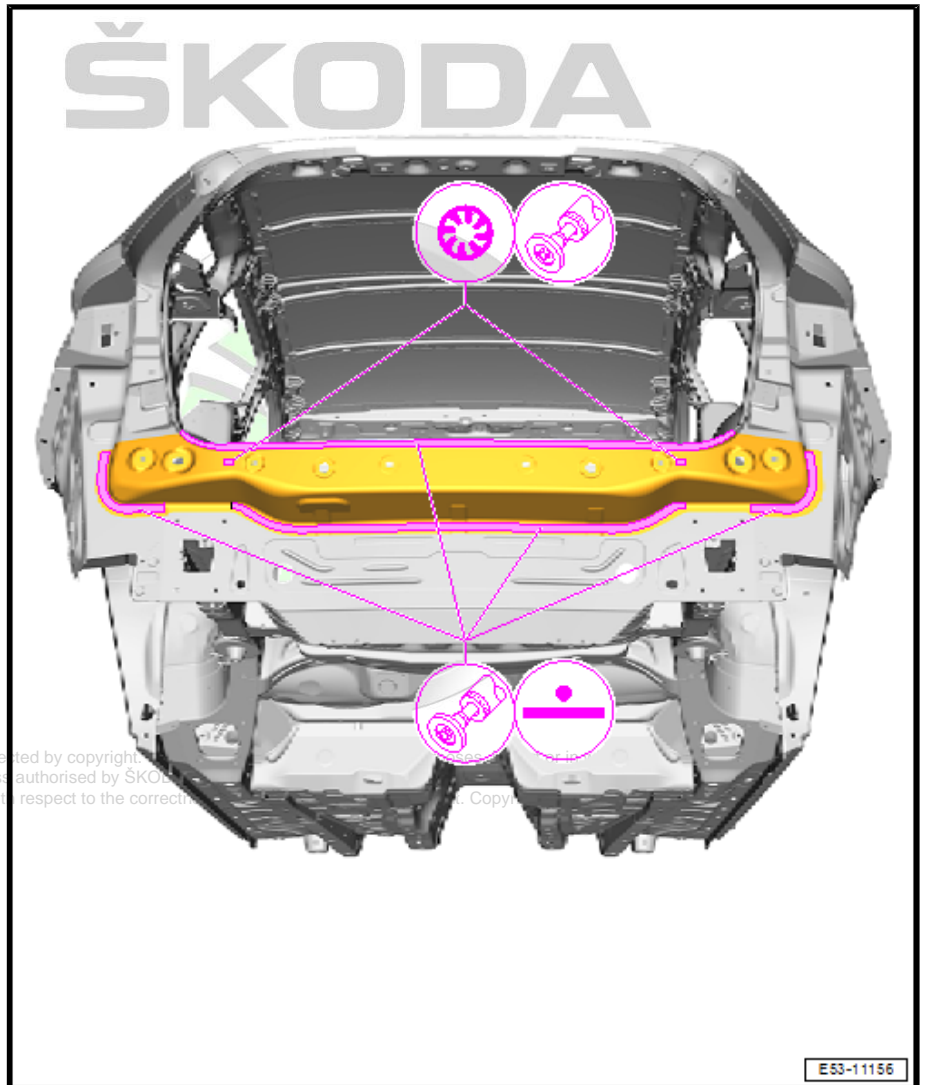
Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs

New part

- ◆ End cover cross member





- Fit the new parts and fix.
- Check the fit with component parts.
- Weld in the new part, GS plug weld seam and RP spot seam.



6 Replacing the end cover plate

⇒ ["6.1 Removing", page 134](#)

⇒ ["6.2 Preparing the new part", page 135](#)

⇒ ["6.3 Part welding", page 137](#)

6.1 Removing



Caution

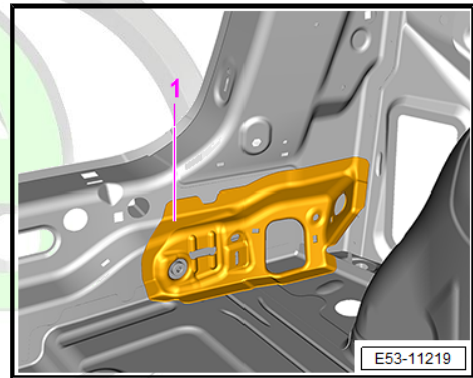
Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs



Note

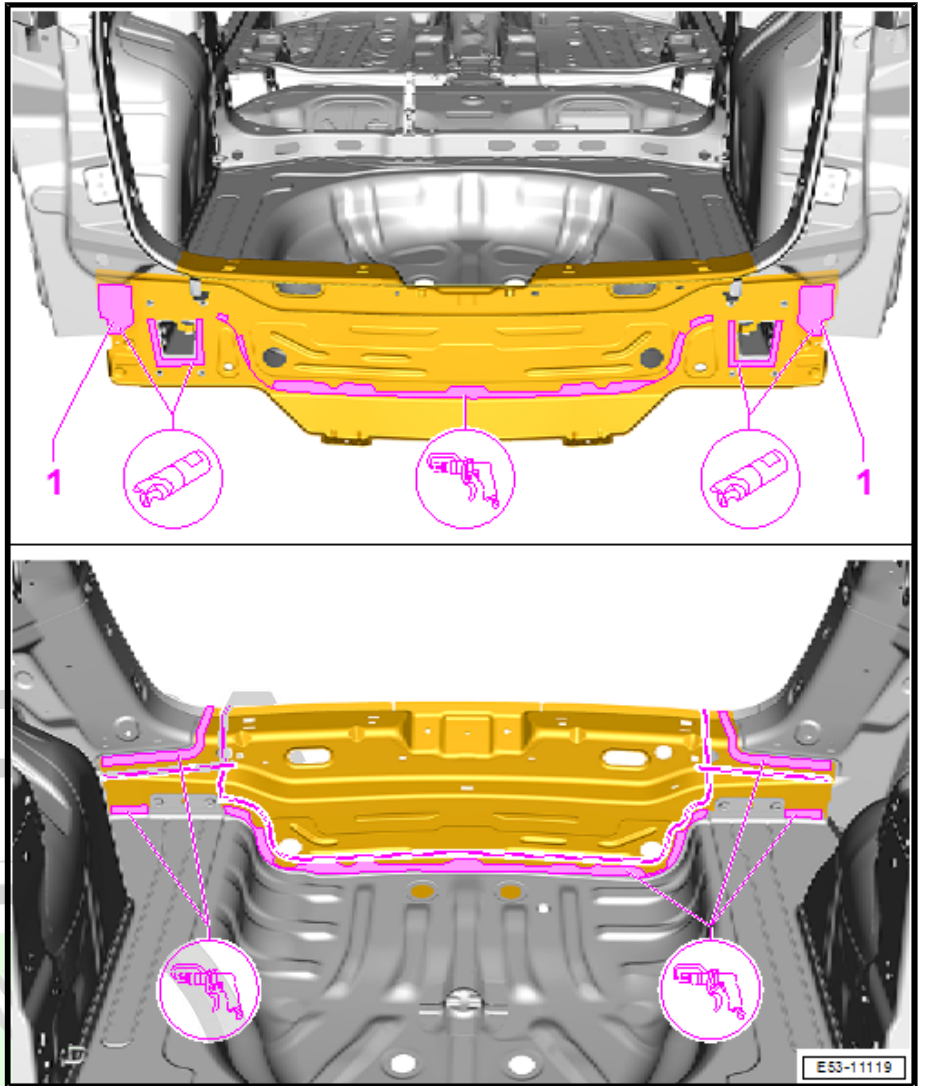
The work procedure for vehicles with four-wheel drive is identical.

End crossbeams and inner reinforcements (on both sides) -1- already removed.



A new part can be cut to size, depending on damage.

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- Loosen the original welding.
- Remove residues.

6.2 Preparing the new part

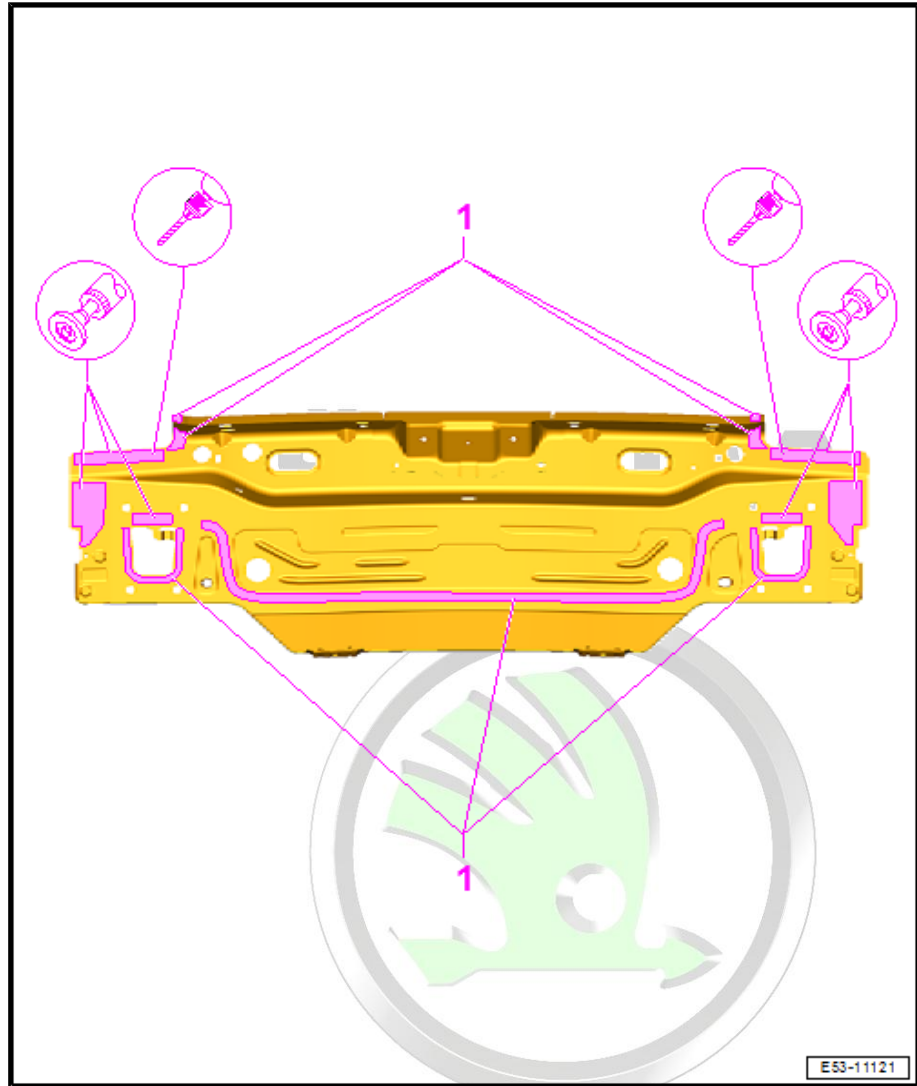


Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs

New part

- ◆ Rear panel
- ◆ 2K epoxy adhesive - DA 001 730 A2-

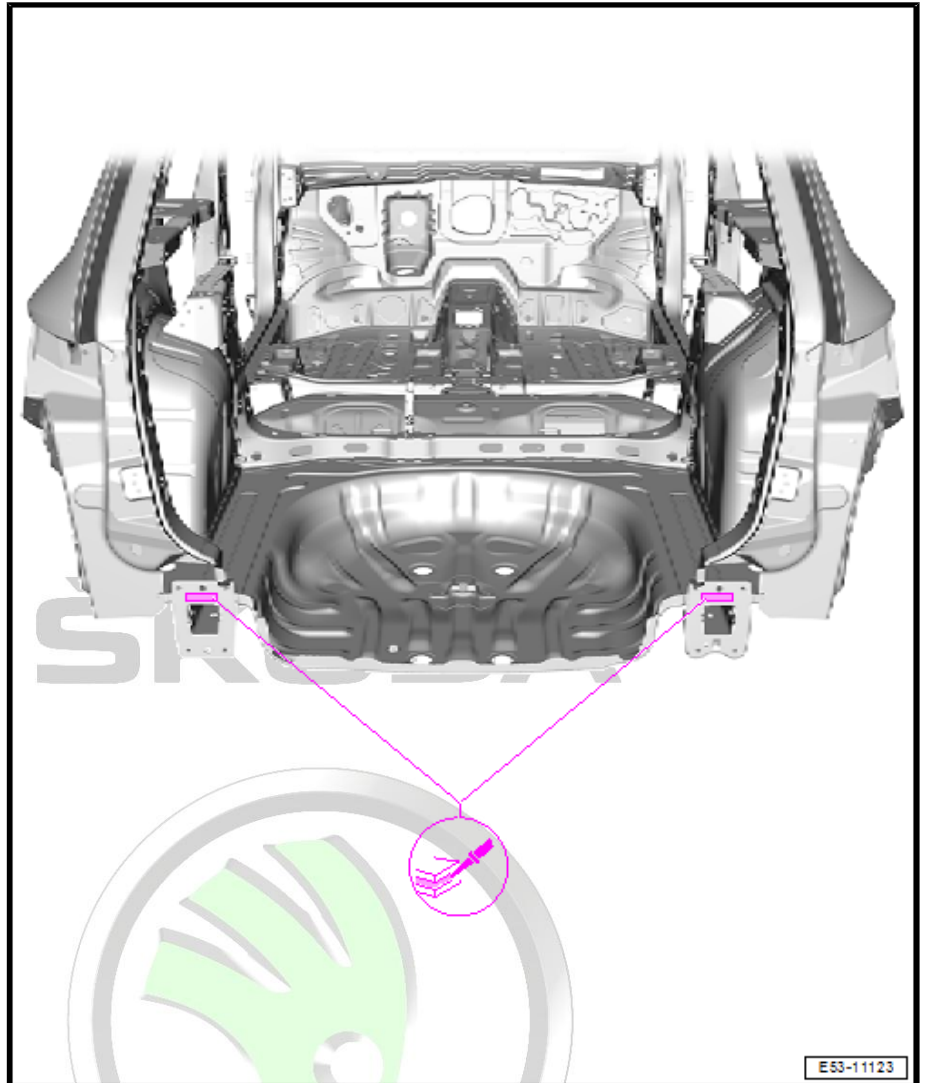


- Create holes for the GS plug weld seam, $\varnothing 8$ mm.
- Prepare surfaces -1- For RP spot weld seam.



Note

The new part must be welded within 90 minutes as otherwise the adhesion of the glue may be poor.



- Apply 2K epoxy adhesive - DA 001 730 A2- in the original areas.

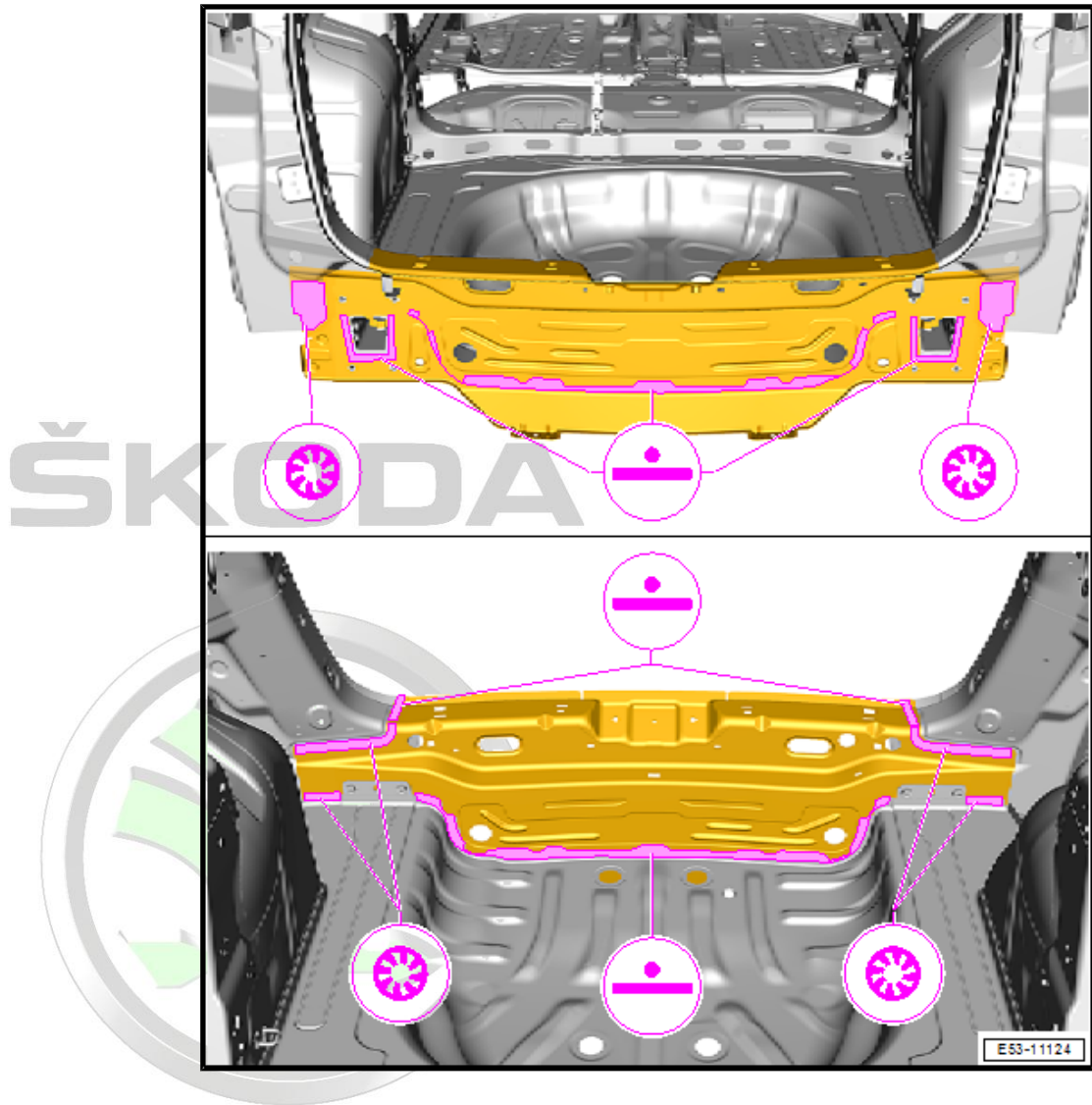
6.3 Part welding



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Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs



- Adjust the new part and fix. For this purpose, the vehicle is standing on its wheels or on the straightening bracket set. is, is not permitted or accept any liability with respect to the correctness of information in this document. Copyright by ŠKODA AUTO A. S.
- Check the fit with component parts.
- Check closing of the tailgate.
- Weld end cover plate, GS plug weld seam and RP spot weld seam.



7 Replace luggage compartment, four-wheel drive

⇒ [“7.1 Removing”, page 139](#)

⇒ [“7.2 Preparing the new part”, page 140](#)

⇒ [“7.3 Moulded foam parts”, page 142](#)

⇒ [“7.4 Part welding”, page 142](#)

7.1 Removing



Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs



Note

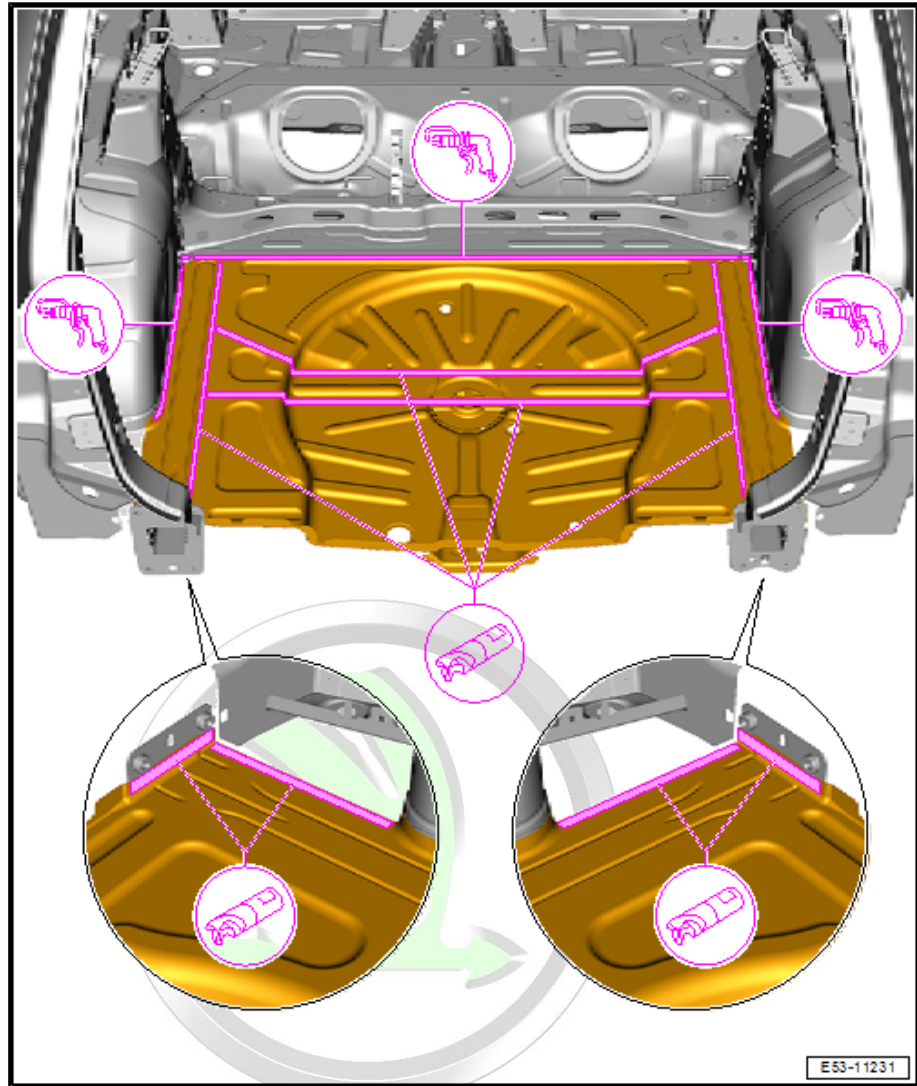
The work procedure for vehicles with front drive is identical.

Reinforcements of the sealing channel already removed.

End cover plate already removed.

Extension wheelhouse at the rear already removed (on both sides).

A new part can be cut to size, depending on damage.



- Loosen the original welding
- Remove the luggage compartment floor from the vehicle.
- Remove any residues.

i Note

The residual foam must be removed before carrying out grinding.

7.2 Preparing the new part



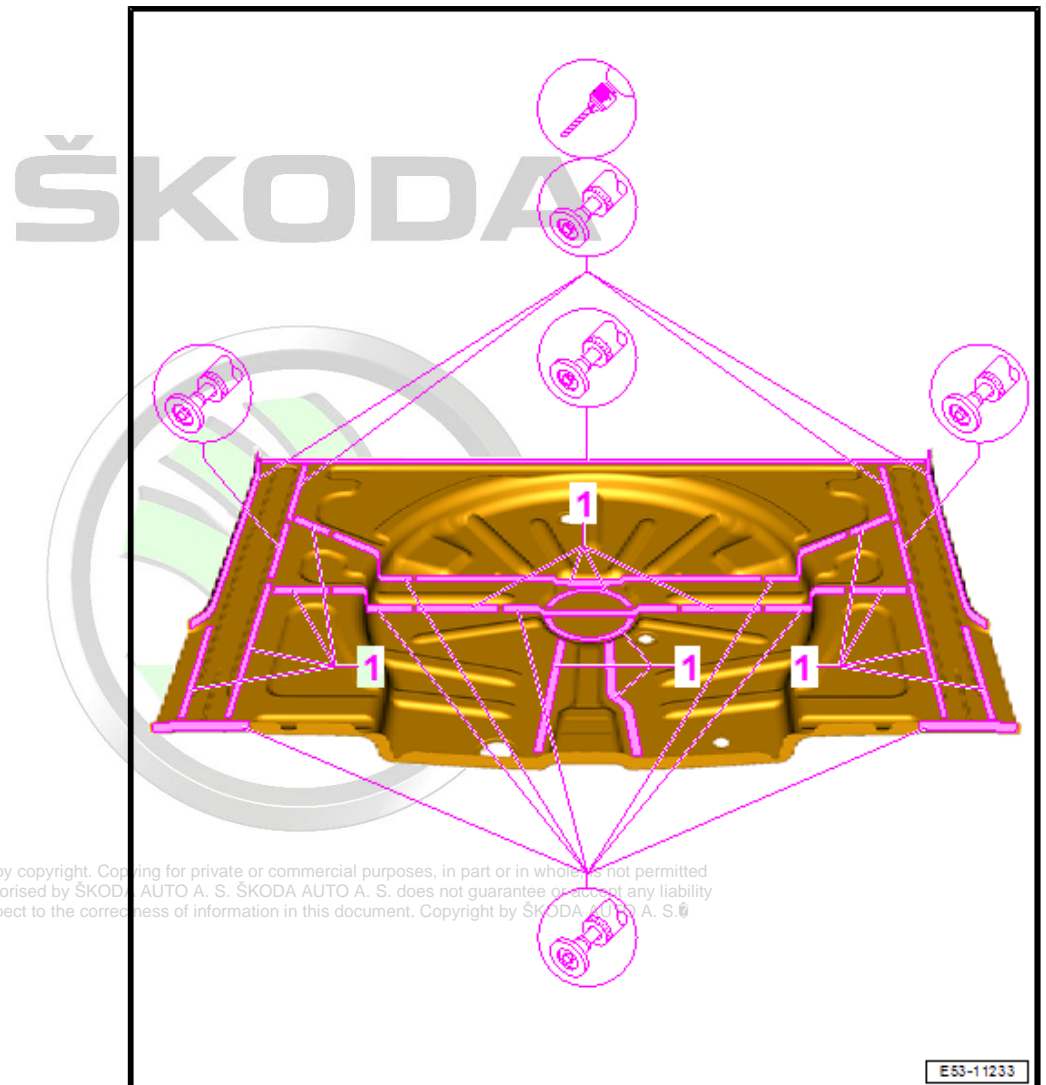
Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs

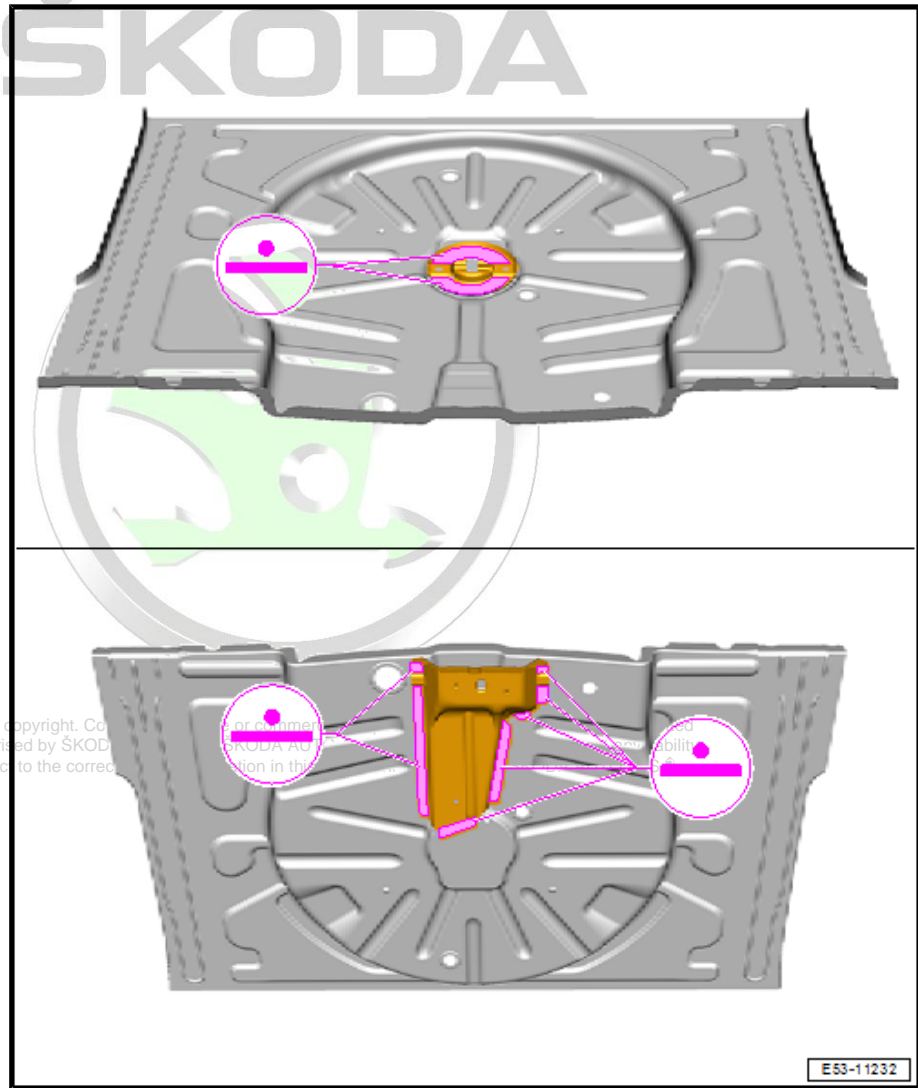
New part

- ◆ Luggage compartment floor
- ◆ Moulded foam parts
- ◆ Spare wheel mount

- ◆ Mounting bracket
- ◆ 2K epoxy adhesive - DA 001 730 A2-



- Create holes for the GS plug weld seam, \varnothing 8 mm.
- Prepare surfaces -1- For RP spot weld seam.
- Only slightly grind out the adhesive surfaces on which welding is not necessary.



- Weld in the parts, RP spot weld seam.

7.3 Moulded foam parts



Caution

Follow the general notes! → General Information; Body Repairs, General Body Repairs

Observe the repair instructions.

Moulded foam parts: ⇒ General Information; Body Repairs, General Body Repairs ; Basic Instructions, moulded foam parts

- Replace moulded foam part ⇒ [“4 Foam moulds”, page 4](#) .

7.4 Part welding



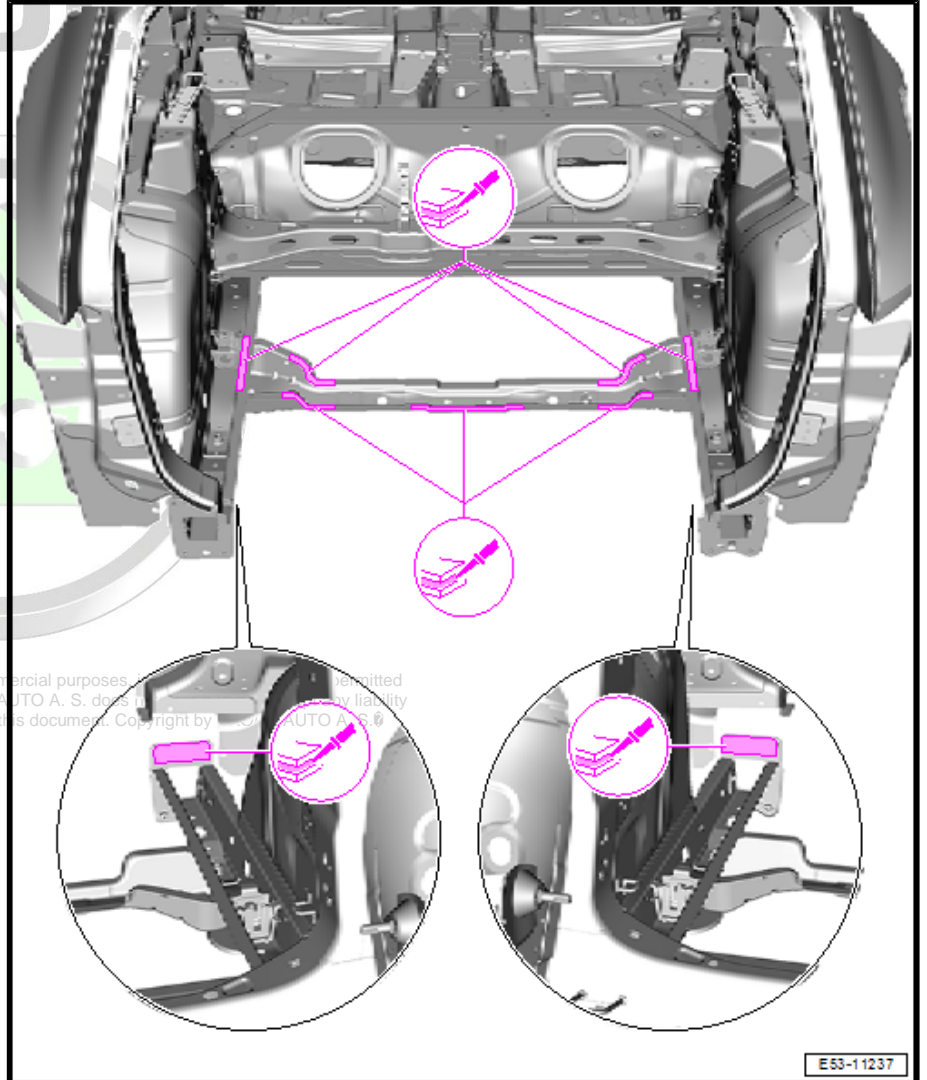
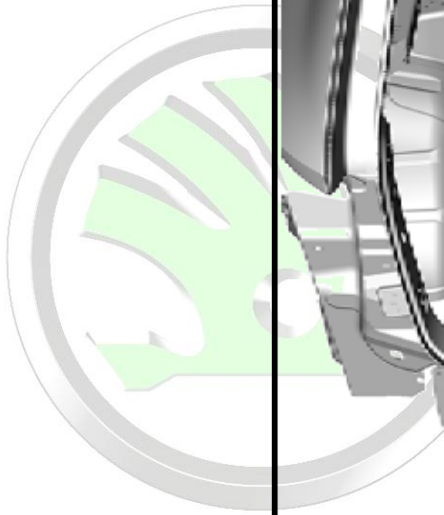
Caution

Follow the general notes! → General Information; Body Repairs, General Body Repairs

i Note

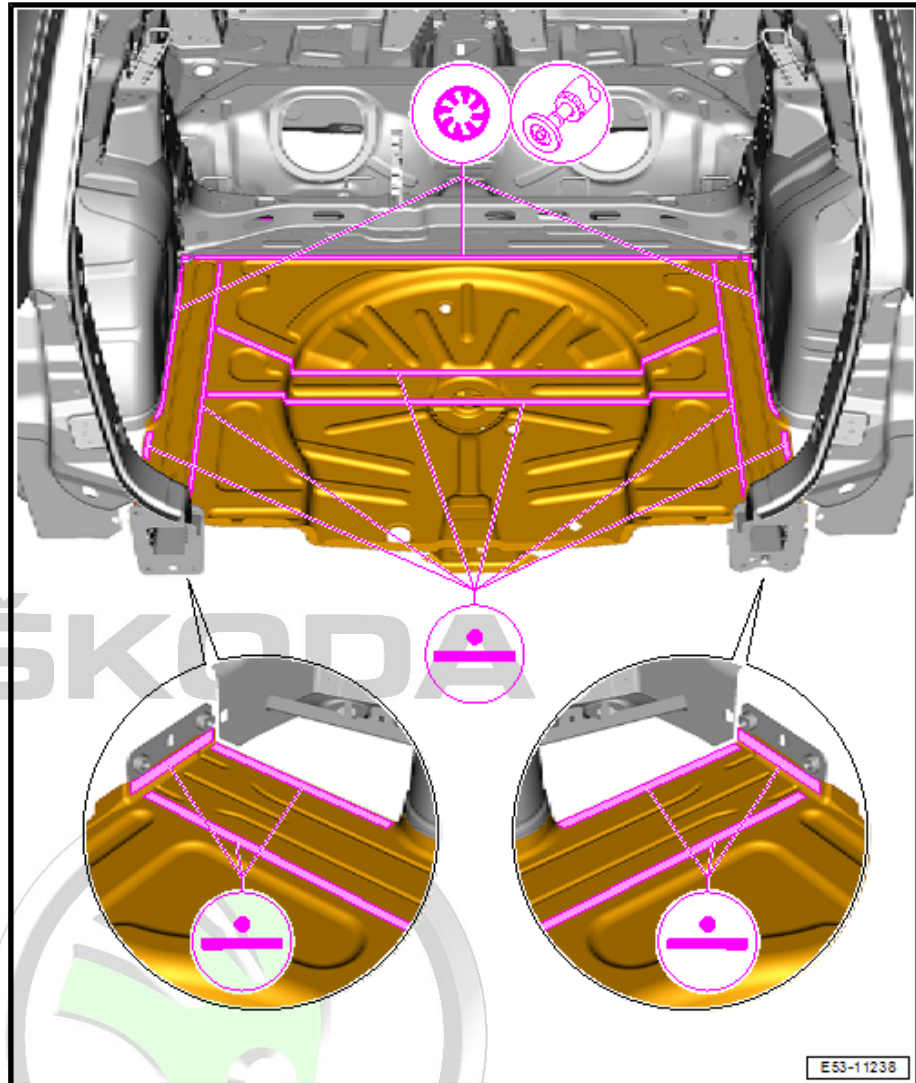
The new part must be welded within 90 minutes as otherwise the adhesion of the glue may be poor.

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- Apply 2K epoxy adhesive - DA 001 730 A2- in the original areas.



- Adjust the new part and fix. For this purpose, the vehicle is standing on its wheels or on the straightening bracket set .
- Check the fit with component parts.
- Weld in the new part, GS plug weld seam and RP spot seam.

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8 Replacing the end cover plate

⇒ "8.1 Removing", page 145

⇒ "8.2 Part welding", page 146

8.1 Removing

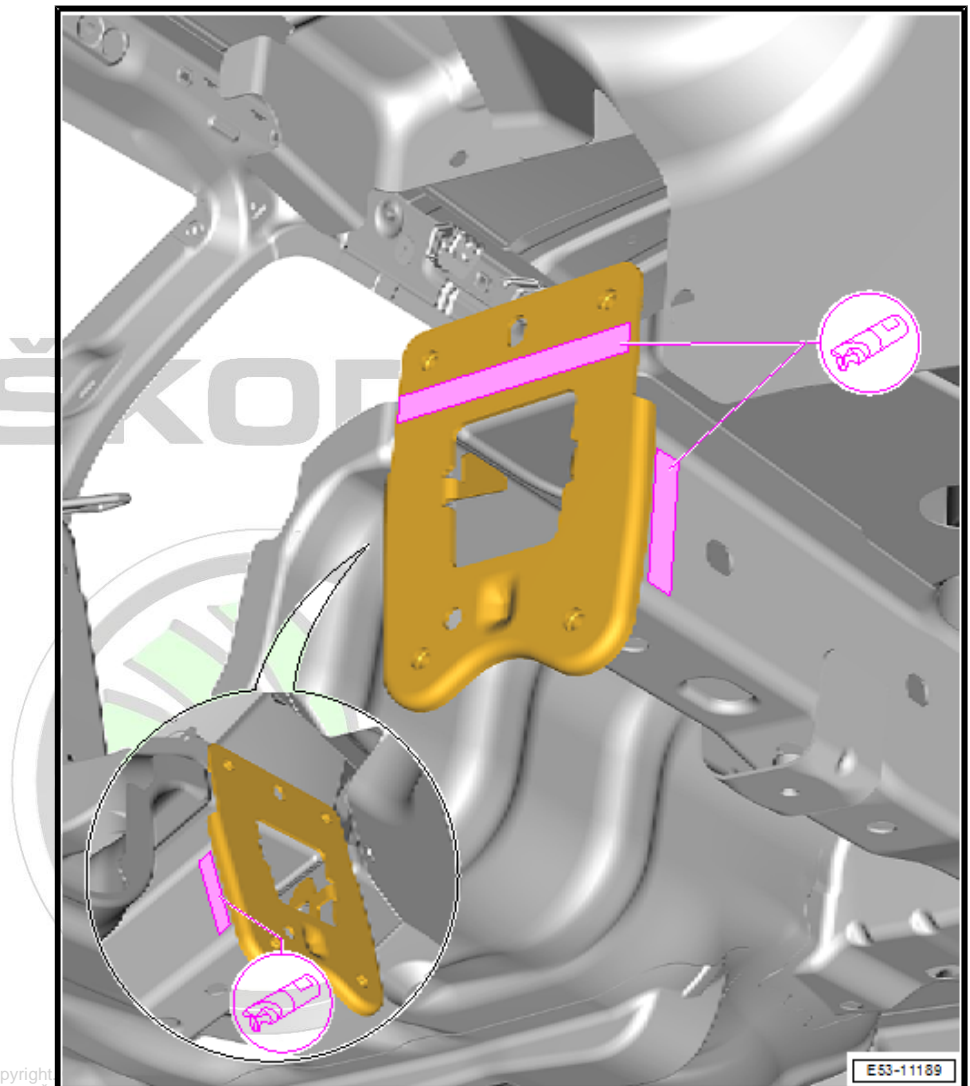


Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs

Special tools and workshop equipment required

- ◆ Welding point loosening tool e.g. -V.A.G 1731- and replacement breaker for high-strength panels e.g. -V.A.G 1731/3-



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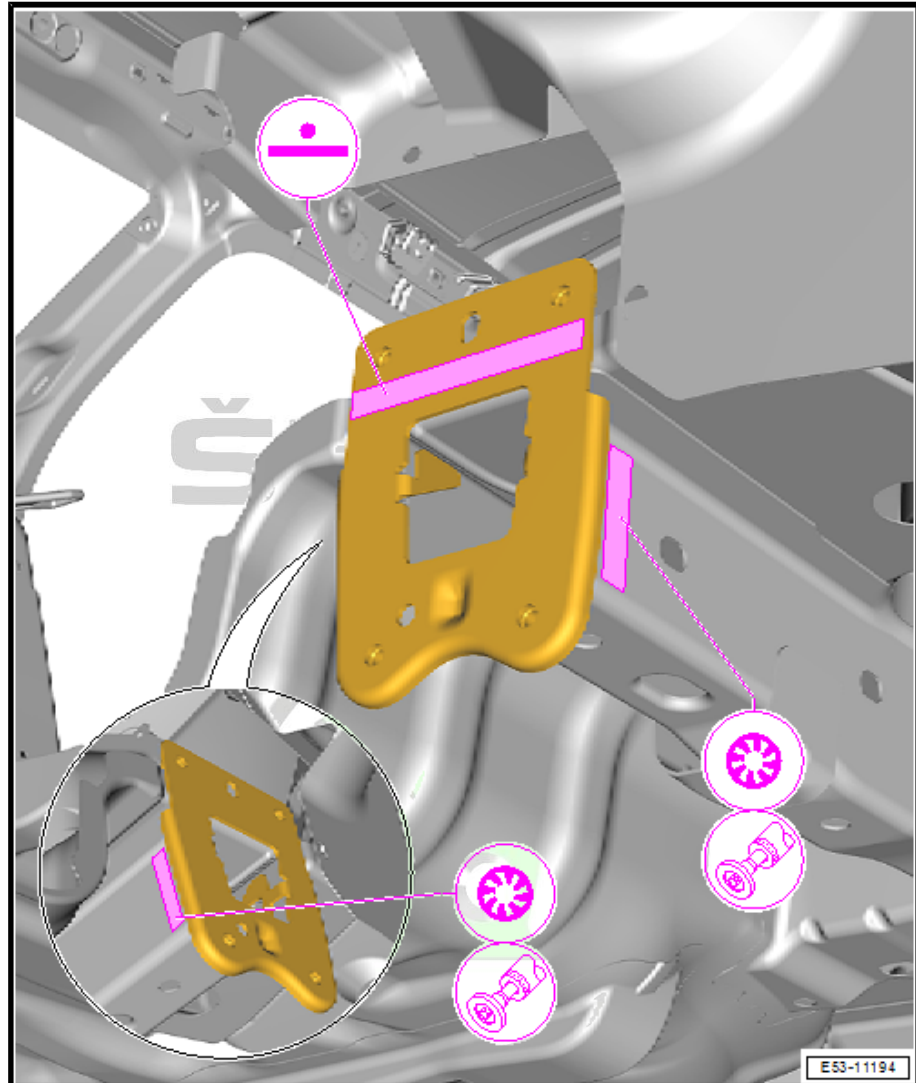
- Loosen the original welding.
- Remove the luggage compartment floor from the vehicle.
- Remove any residues.



8.2 Part welding

New part

- ◆ End cover plate



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- Adjust the new part and fix. For this purpose, the vehicle is standing on its wheels or on the straightening bracket set.
- Check the fit with component parts.
- Weld in the new part, inert gas shielded plug weld and inert gas shielded full seam.

9 Replacing rear frame side rail -part-

⇒ "9.1 Removing", page 147

⇒ "9.2 Preparing the new part", page 149

⇒ "9.3 Part welding", page 150

9.1 Removing



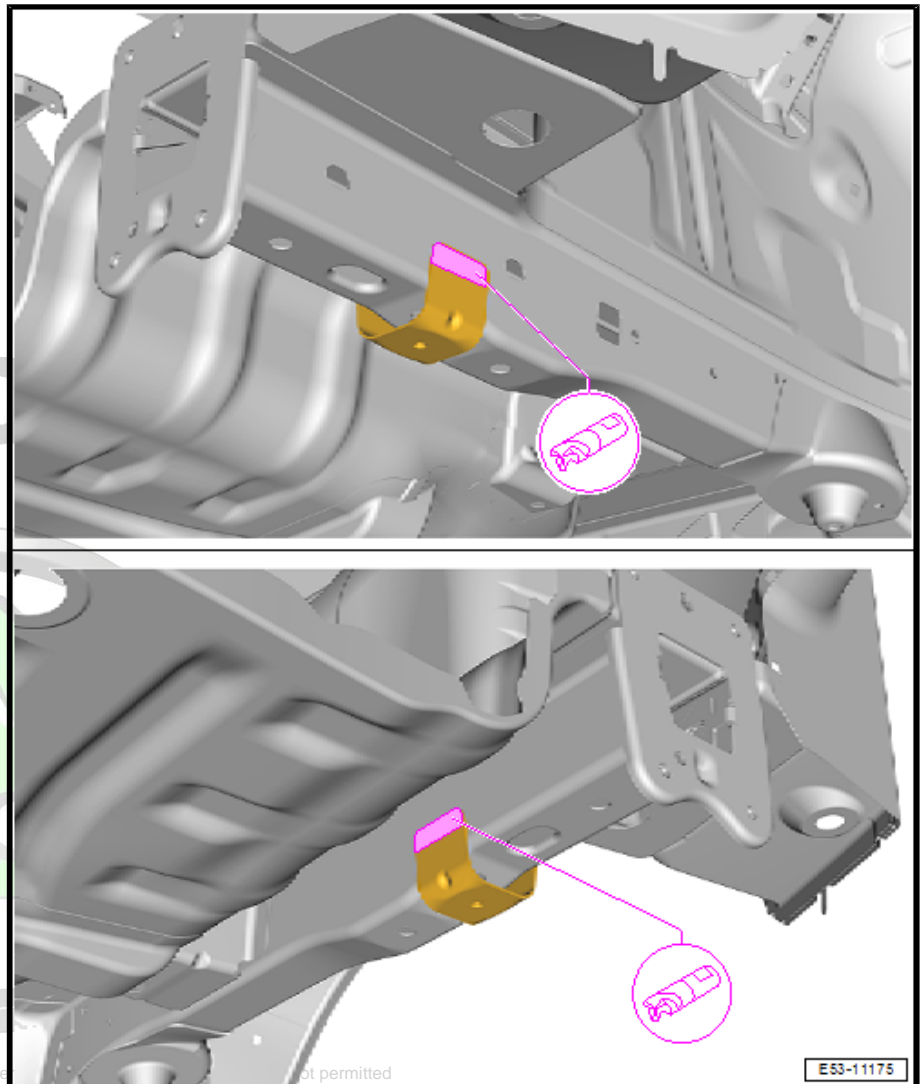
Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs

Special tools and workshop equipment required

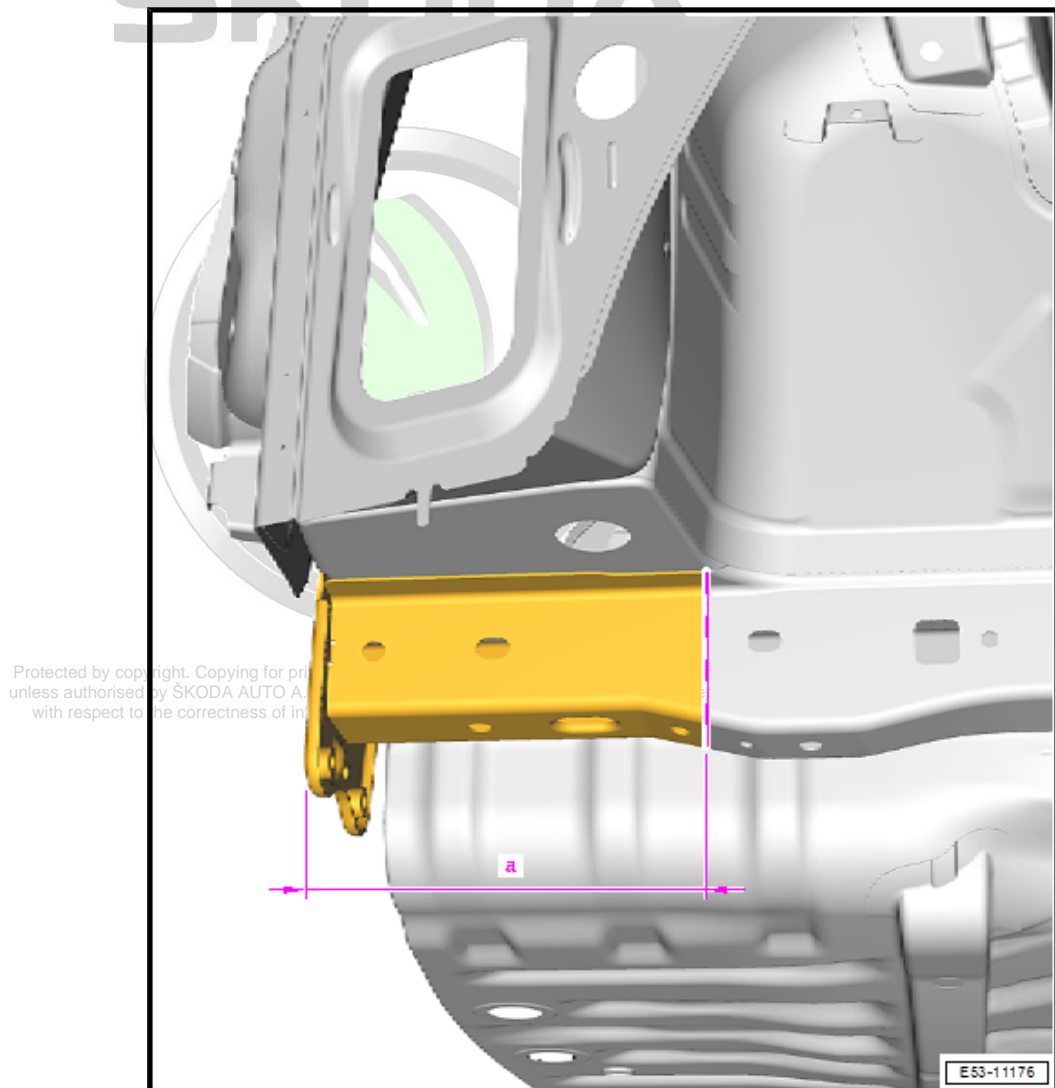
- ◆ Welding point loosening tool e.g. -V.A.G 1731- and replacement breaker for high-strength panels e.g. -V.A.G 1731/3-

End cover plate already removed.



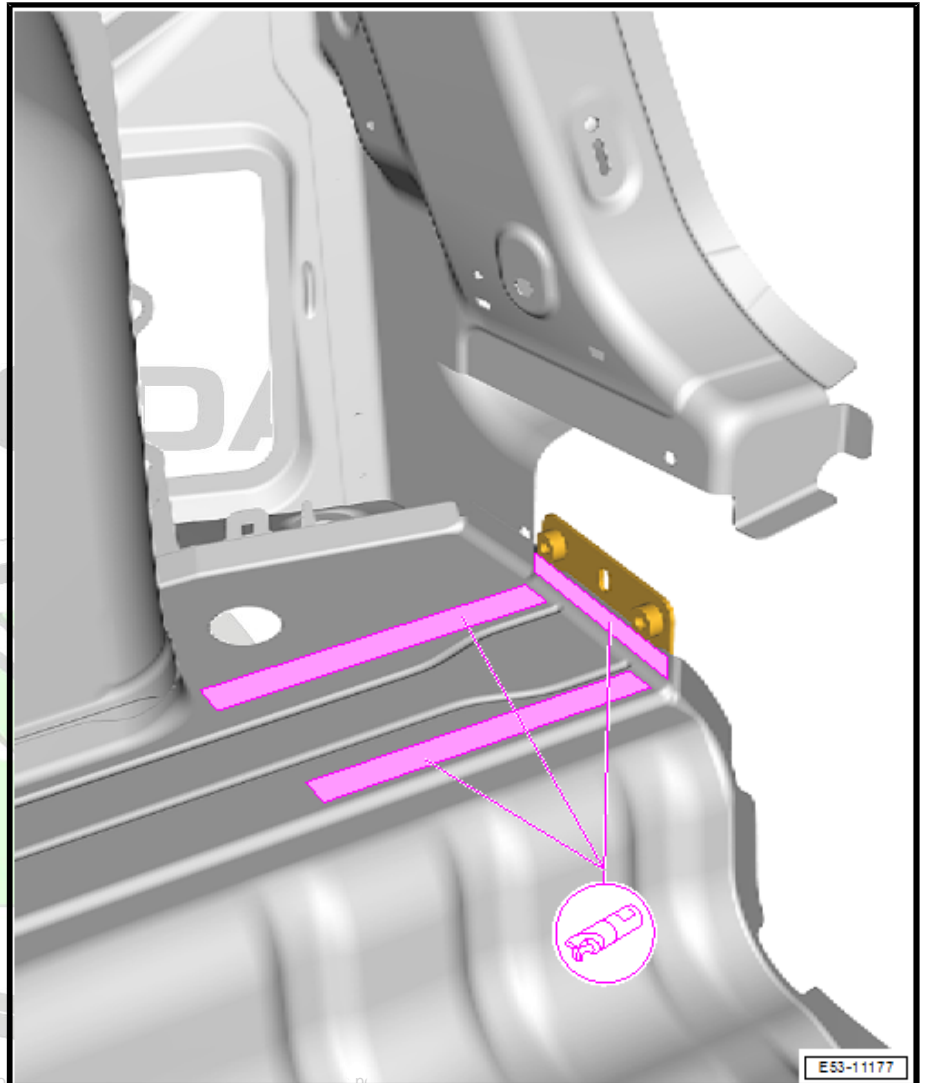
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- Remove the original welding and remove the mounting bracket.



- Carefully mark the separating cut on the rear longitudinal beam.
- a- = 120 mm
- b- = 70 mm
- Make a separating cut on the rear longitudinal beam.

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- Detach original welding with luggage compartment floor.
- Remove the longitudinal beam from the body.
- Remove any residues.

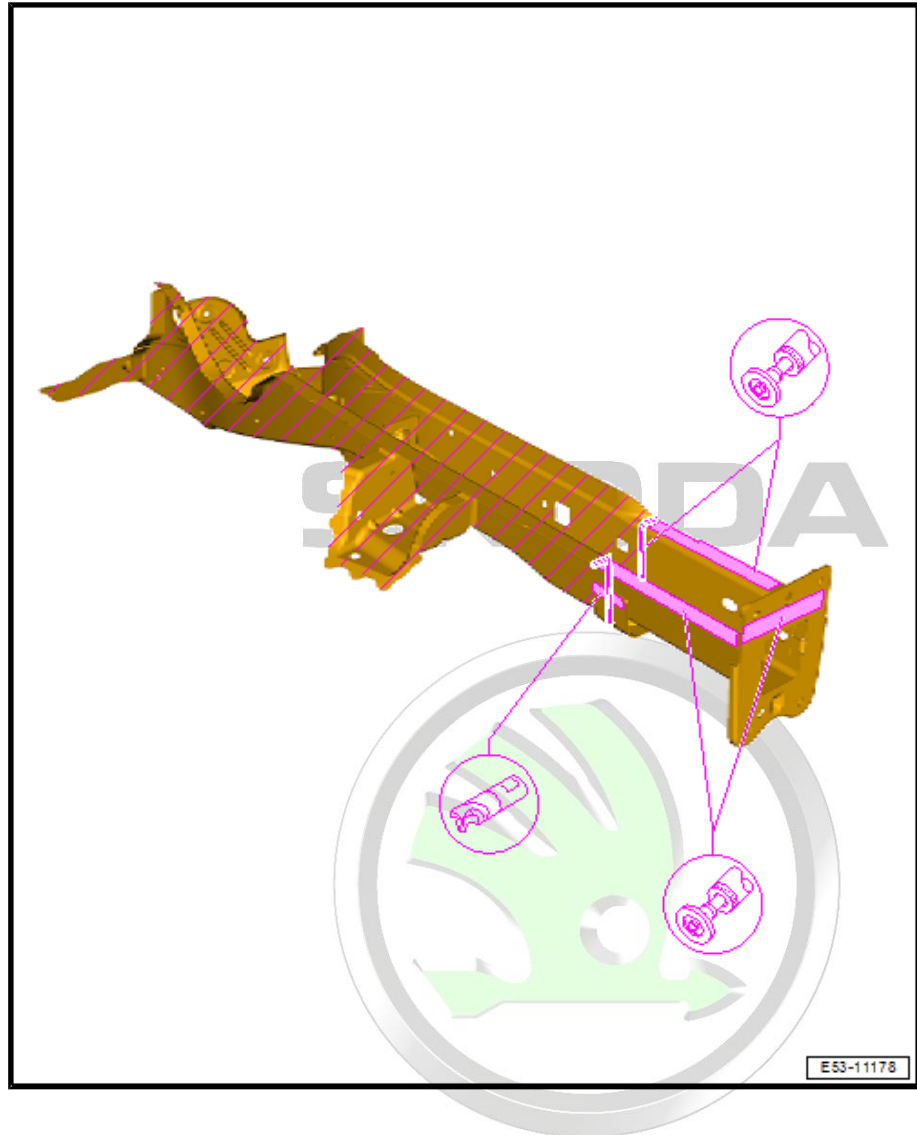
9.2 Preparing the new part



Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs

- ◆ The rear frame side rail



- Detach original welding of the mounting bracket.
- Remove the mounting bracket from the new part.
- Grind off the welding surfaces.

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Note

Detach mounting bracket from the new part so that it can be used again for installation.

- Transpose the separation cut from the body and cut the new part.
- Grind off the welding surfaces on the new part.

9.3 Part welding

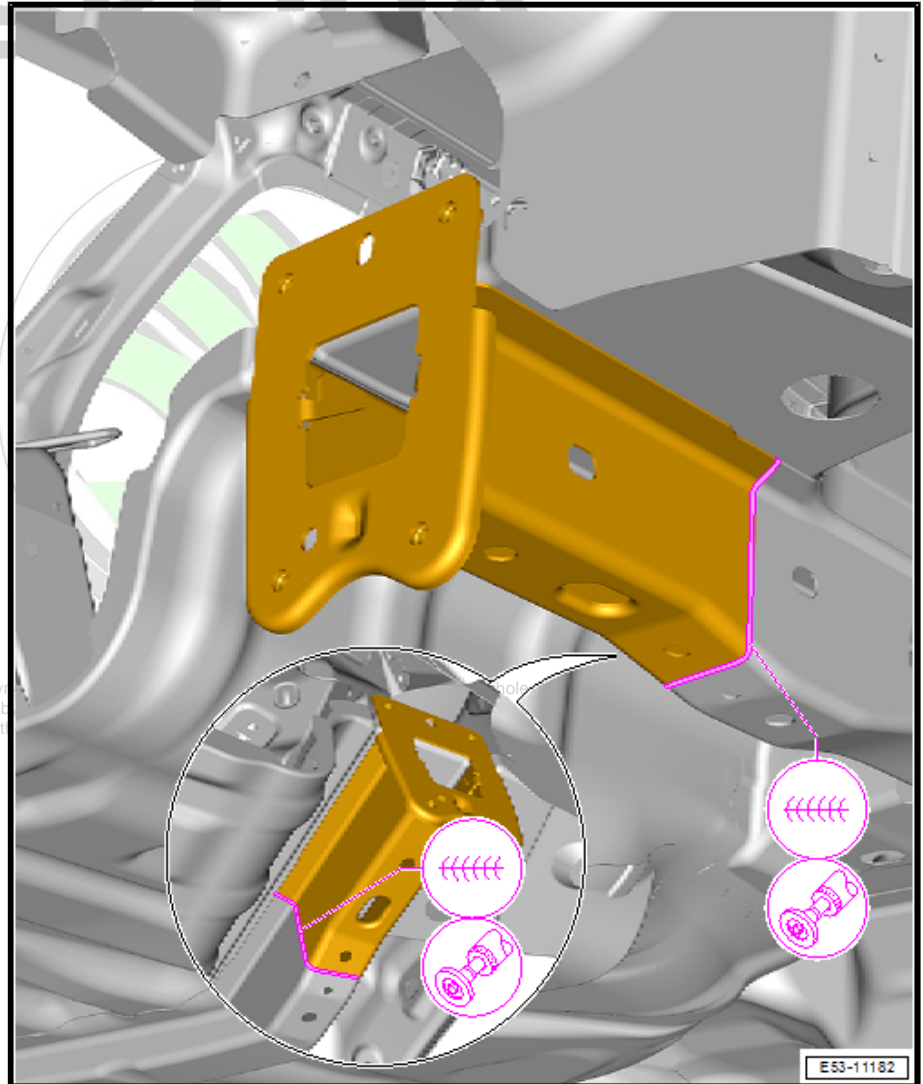


Caution

Follow the general notes! ⇒ General Information; Body Repairs, General Body Repairs

Welding when using the complete frame side rail unit

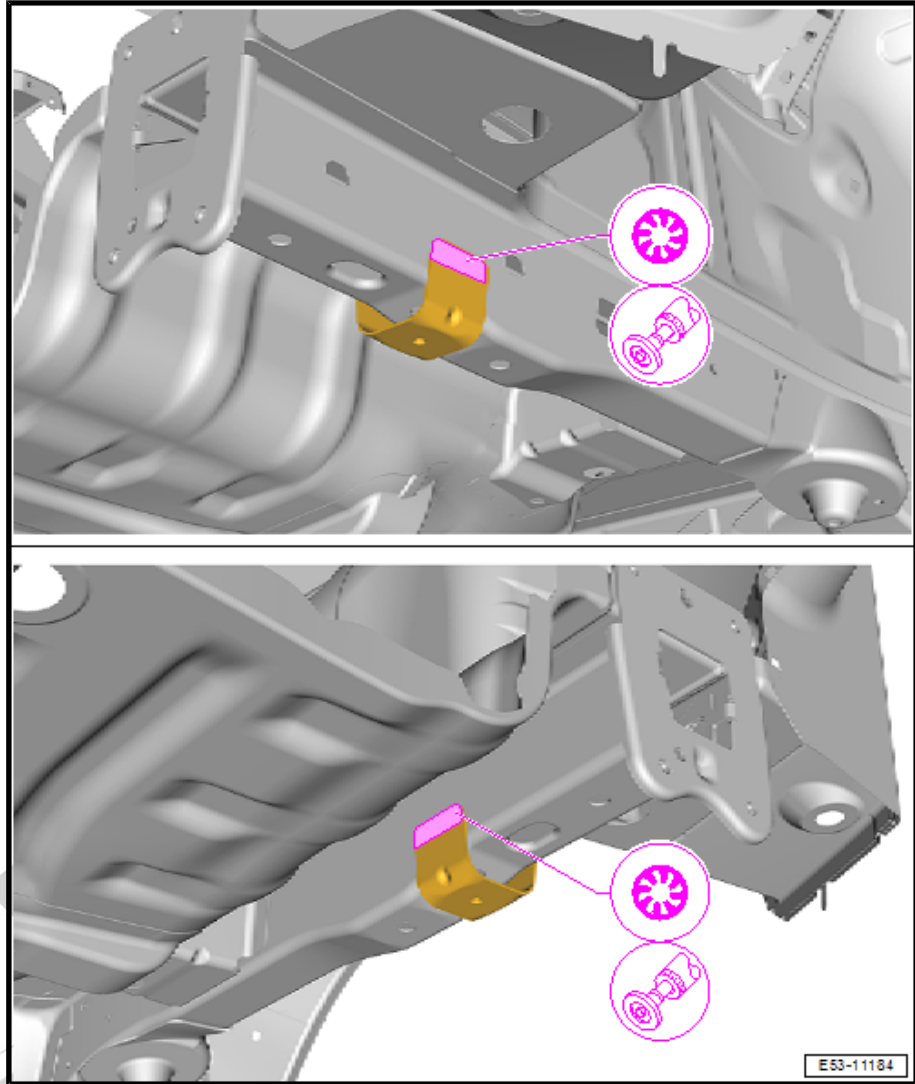
- Fit and attach new parts -1-. For this purpose, the vehicle is standing on the straightening bracket set .



- Butt weld the separation cut, GS full seam (inert gas shielded).

Note

GS full seam (inert gas shielded) must not be reworked (ground or smoothed)!



- Fit and attach the mounting bracket.
- Bracket weld, GS plug weld seam (inert gas shielded).

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