

41 11 205**Completely replacing left carrier support**

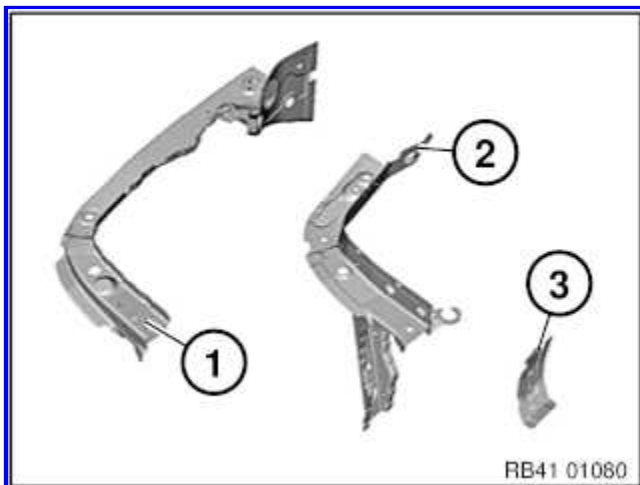
When replacing the right carrier support, follow the special procedure concerning the vehicle identification number. (order new body part with vehicle identification number if necessary)



Read contents of [Body, General](#).

Follow procedure for [repair stage 2](#).

[Strip down](#) vehicle.



The following new body parts are required (refer to Electronic Parts Catalogue).

- (1) Carrier support, outer wheel arch section
- (2) Wheel arch inner section support member
- (3) Carrier support end plate

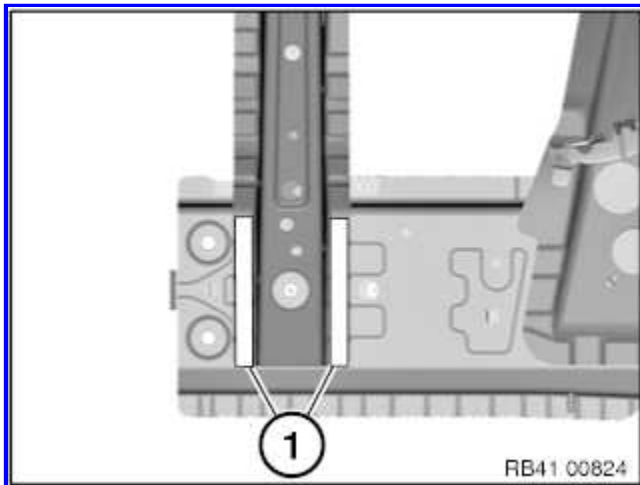
Following [consumables](#) are required:

Material	Quantity
Adhesive K1	1
Blind rivet N1	4
Blind rivet N7	5

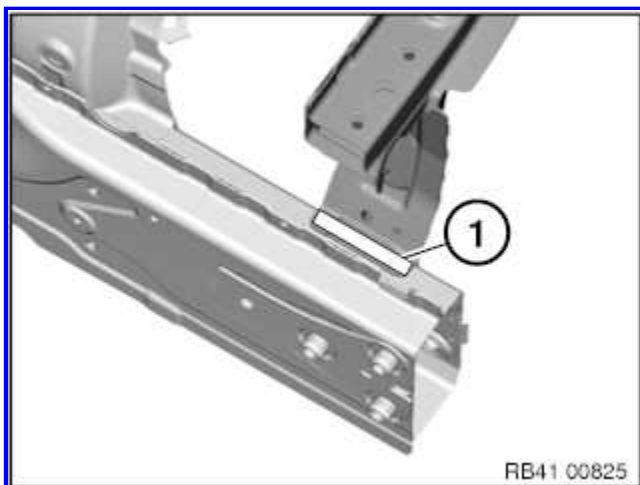
Punch rivets N5	56
Sealant D1	1
Cleaning agent R1	1



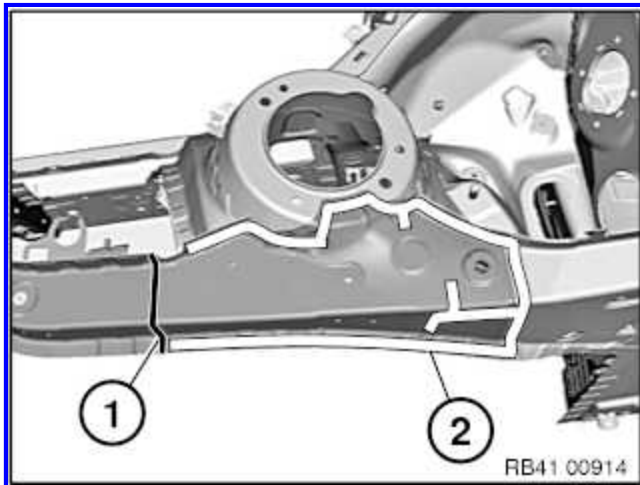
Removing carrier support



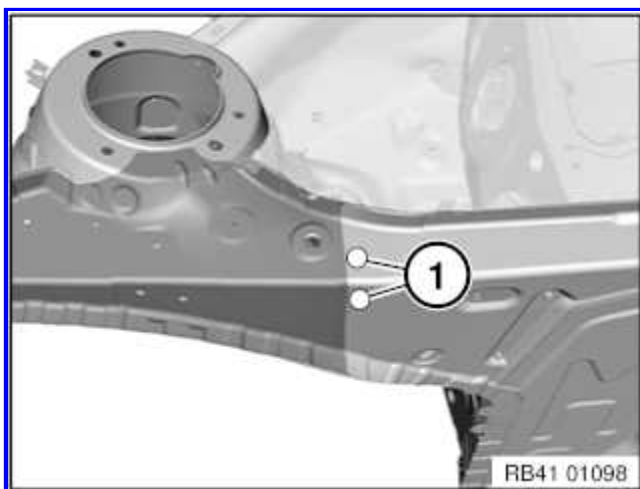
Open welded connections in areas (1).



Open weld joint in area (1).



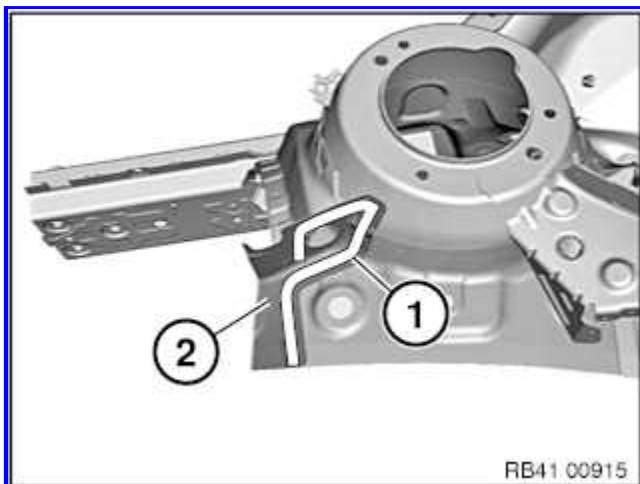
Mark severance cut (1) as pictured and cut off carrier support.
Open weld connections in area (2) and remove outer part of carrier support.



Important!

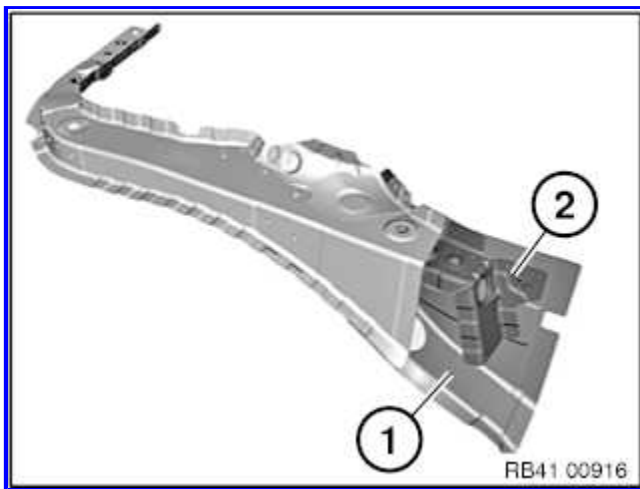
Covered welding spots.

In areas (1), undo welded connections for both external panels.

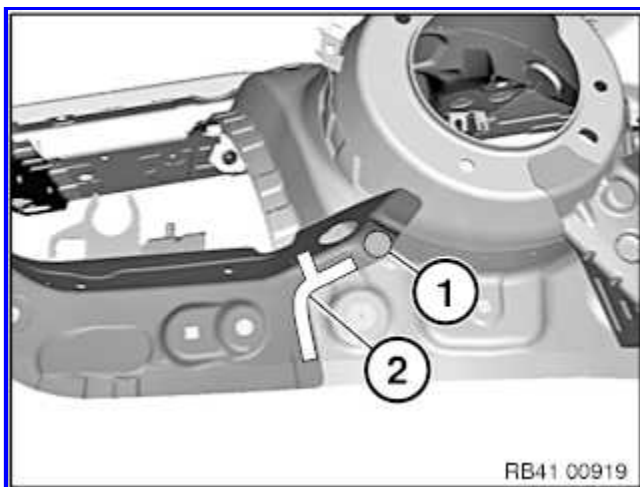


Release welded connections in area (1) and remove sheet section (2).

New part preparation



Release welded connections and take off components (1) and (2) that are not required.



Adjust new parts with add-on parts to fit and secure.

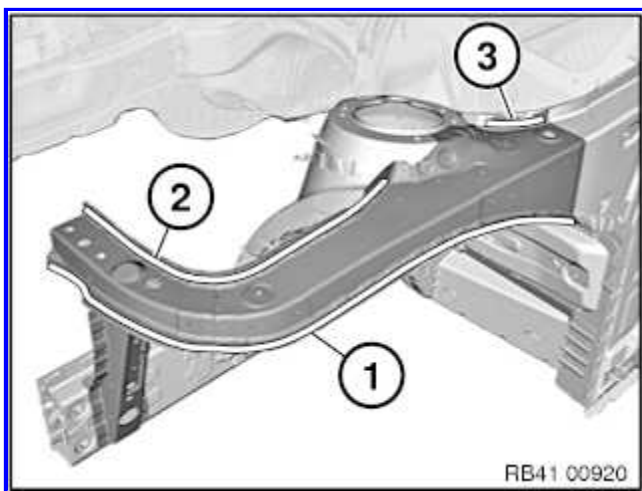
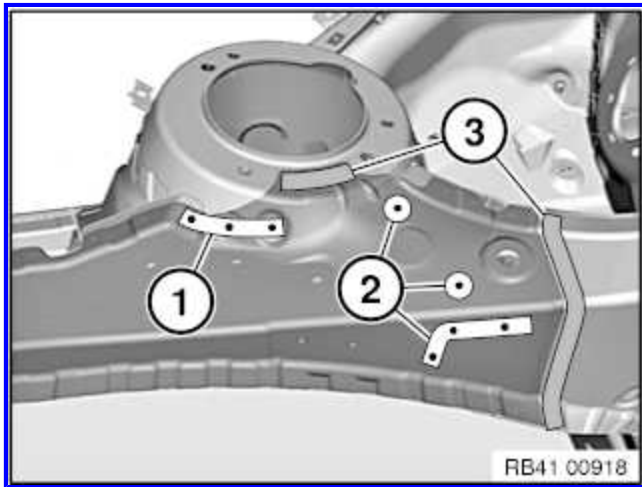
Areas (1) and (2): join using bond-and-rivet method.

In area (1), drill a 6.8 mm dia. bore hole for blind rivet N1.

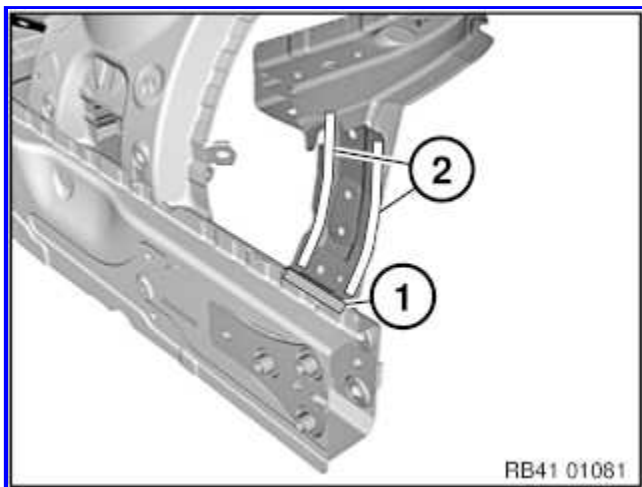
Areas (1) and (2): join using bond-and-rivet method.

In areas (1) and (2), set 8 6.8 mm diameter bore holes for blind rivets.

Prepare areas (3) for joints by welding.



Areas (1) to (3): join using bond-and-rivet method. (punch rivets)



In area (1), prepare new part/engine support for plug-welding.
Area (2): join using bond-and-rivet method.
Remove new parts.

Important!

Structure bonding!

Observe preparation of bonding surfaces.

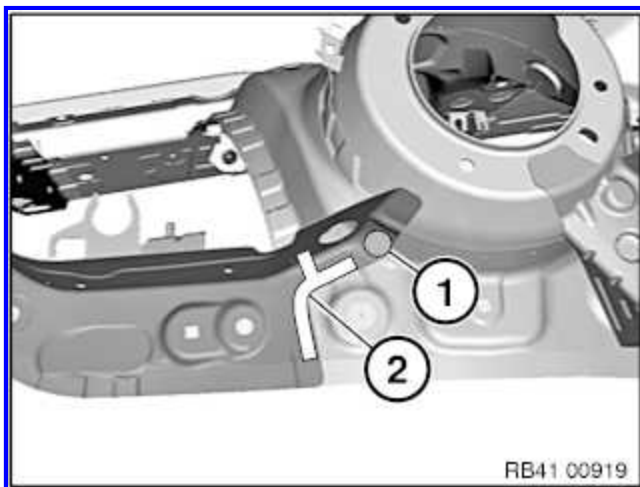


Installing carrier support

Clean all bonding surfaces with cleaning agent R1.

Apply adhesive to bonding surfaces.

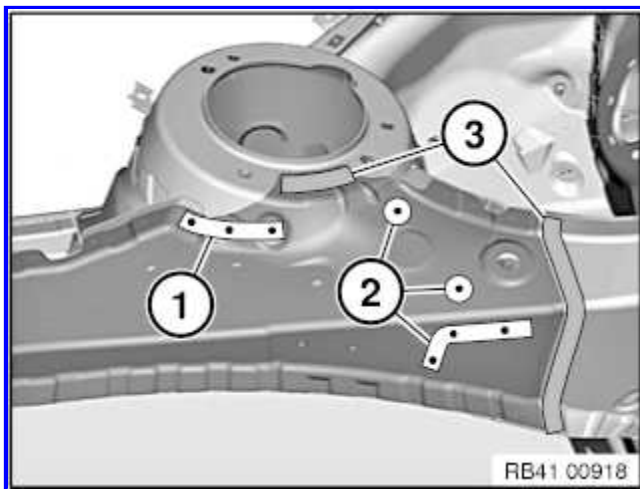
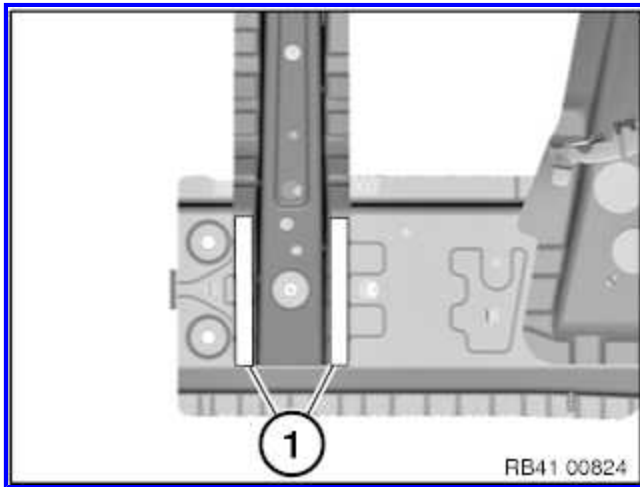
Install and secure inside part of carrier support (new part) with add-on parts.



In area (1), rivet new part with blind rivet N1.

In area (2) rivet new part with 4 punch rivets N5.

In areas (1) weld new part.



Install and secure outside part of carrier support (new part).
In areas (1) and (2), rivet new part with blind rivets .

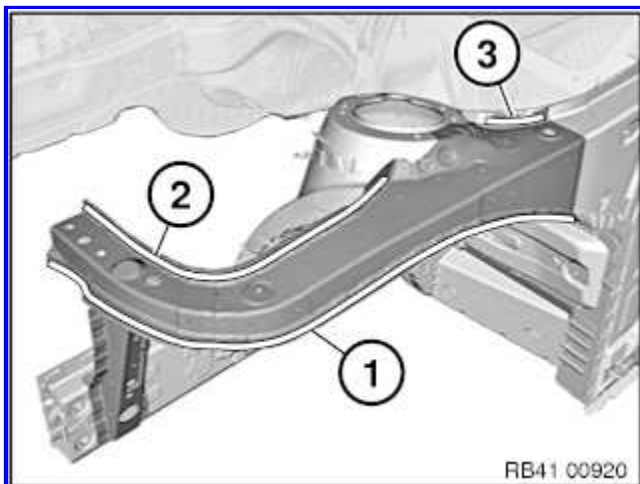
Area	Remarks
1	N1
2	N7

In areas (3) weld new part.

Important!

Risk of damage!

Avoid excessive application of heat to adjacent adhesive areas.

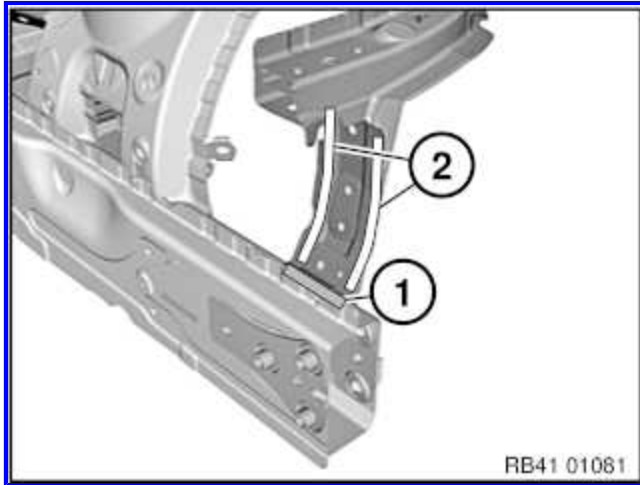


In areas (1) to (3), rivet new part with punch rivets N5.

Area	Number
1	22
2	15
3	3

Note:

Do not seal new parts in adhesive rivet areas (1) and (2).
(visible area)



Install and secure carrier support end plate.

In areas (2), rivet new part with 12 punch rivets N5.

Weld new part in area (1).

Important!

Risk of damage to adhesive area!

Avoid applying excessive heat to the neighbouring adhesive areas!

Note:

Do not seal new parts in the area of the adhesive riveting.
(visible area)



Remove excess adhesive.

Do not use any cleaning agents containing solvents.