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Reinforcement plate (bonded)

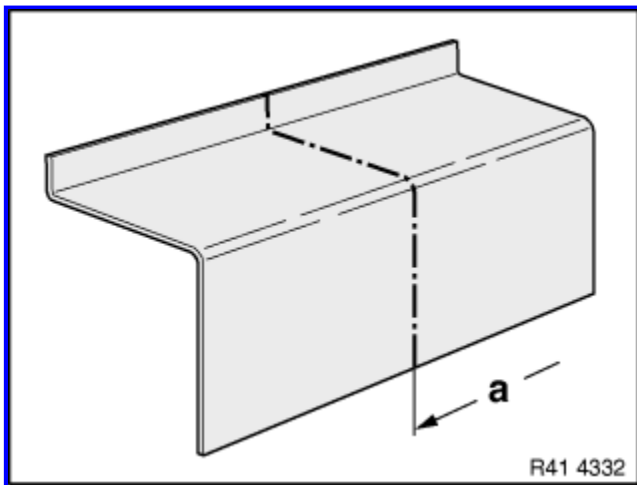
In the case of a partial replacement piece, a body component is cut at a point described in the repair instructions.

A reinforcement plate is bonded in to ensure sufficient strength.

Observe notes on [repair stage 2](#) .

Note:

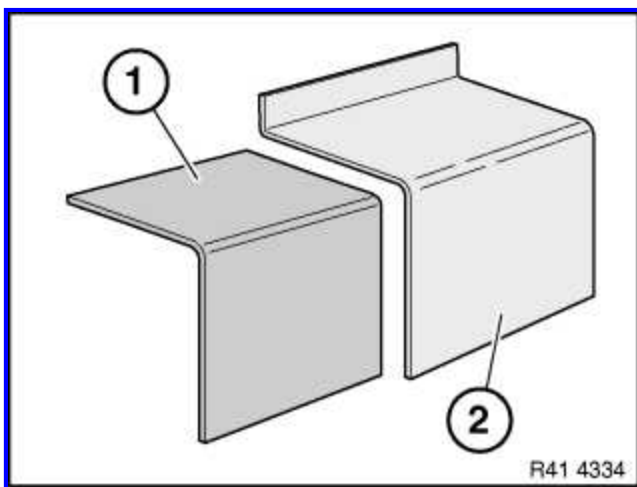
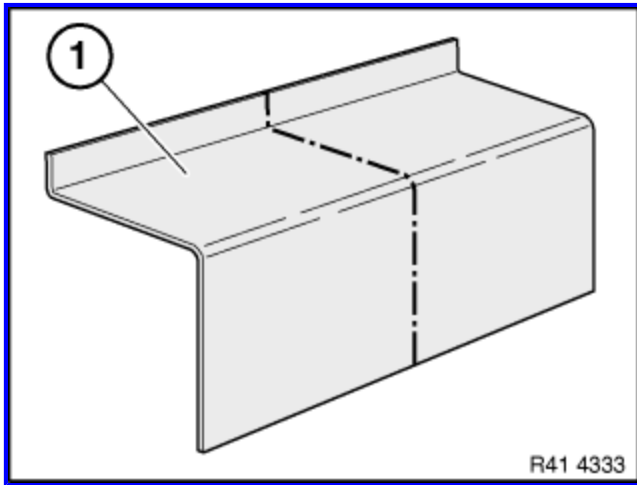
The following graphics serve as general illustrations of reinforcement plate repair work. They apply to sectional repairs to the structure.



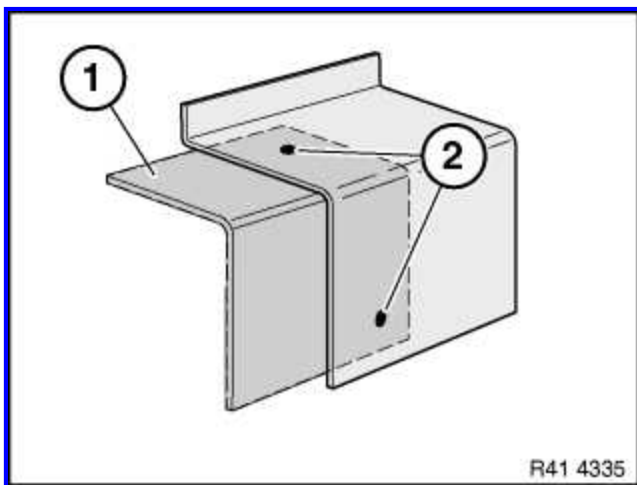
Mark component in accordance with measurement a and cut.

**Preparation of new part:**

Cut new part (1) in accordance with cut on vehicle and if necessary adjust to fit with straightening attachment or universal mount.



Make reinforcement plate (1) from trim of new part (2).
Length of reinforcement plate is 80 mm.



Slide reinforcement plate (1) half-way into component on body
and fasten with 2 self-tapping screws (2).

Adjust new part (1) to fit and set 4.3 mm dia. bore holes (2).

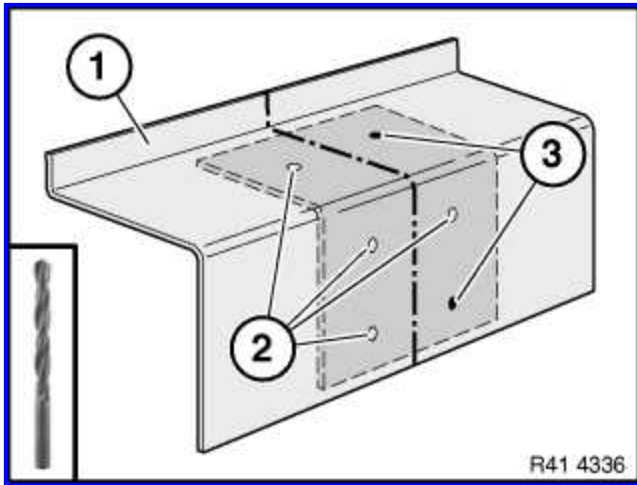
Remove new part again.

Release self-tapping screws (3).

Remove reinforcement plate.

Drill out bore holes (3) for screws to 4.3 mm dia.

Deburr all bore holes.



Important!

Do not grind new part and body in area of bonding surfaces.



Installing reinforcement plate

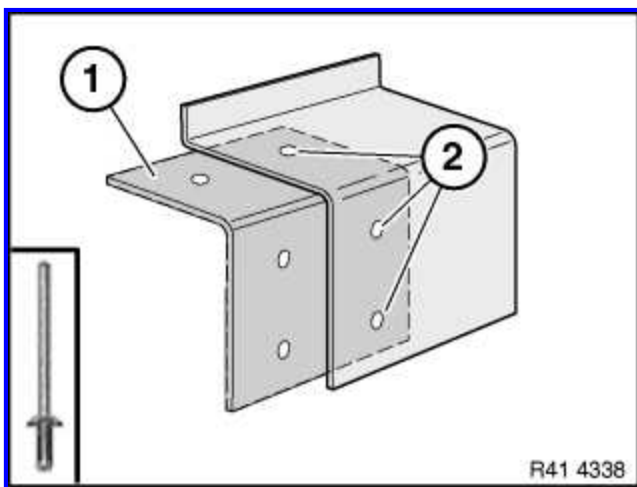
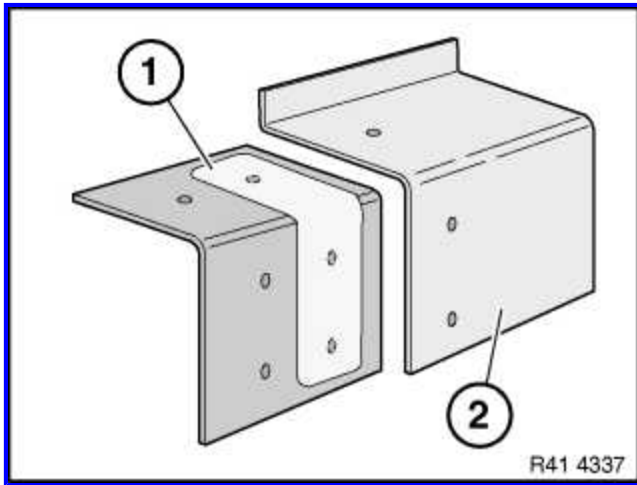
Clean all bonding surfaces with cleaning agent R1.

Apply adhesive (1) to reinforcement plate bonding surface.

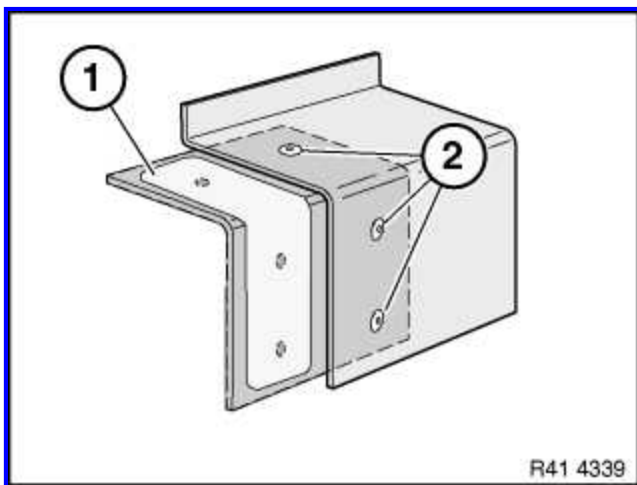
Carefully slide reinforcement plate half-way into body component (2).

Important!

When joining reinforcement plate, make sure there is sufficient adhesive on bonding surfaces.



Rivet reinforcement plate (1) up to half-way with blind rivets N3 (2).



Apply adhesive (1) to reinforcement plate bonding surface.

Install new part (1) with straightening attachment or universal mount and rivet with blind rivets N3 (2).

After adhesive has hardened, flatten adhesive area and seal blind rivets.

