

41 21 201**Replace B-pillar with reinforcement on left**

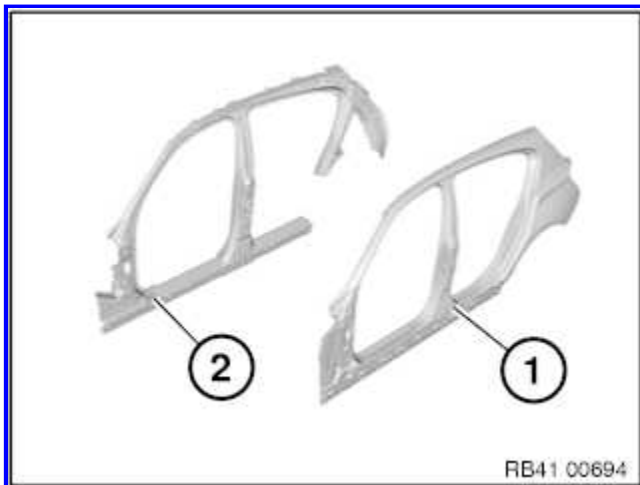
Procedure [Observe](#) repair stage 3!

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

For stripping and rigging operations, refer to texts on KSD CD (FR number 41 21 201).

Use only approved [spot-welding apparatus](#) for repairs!

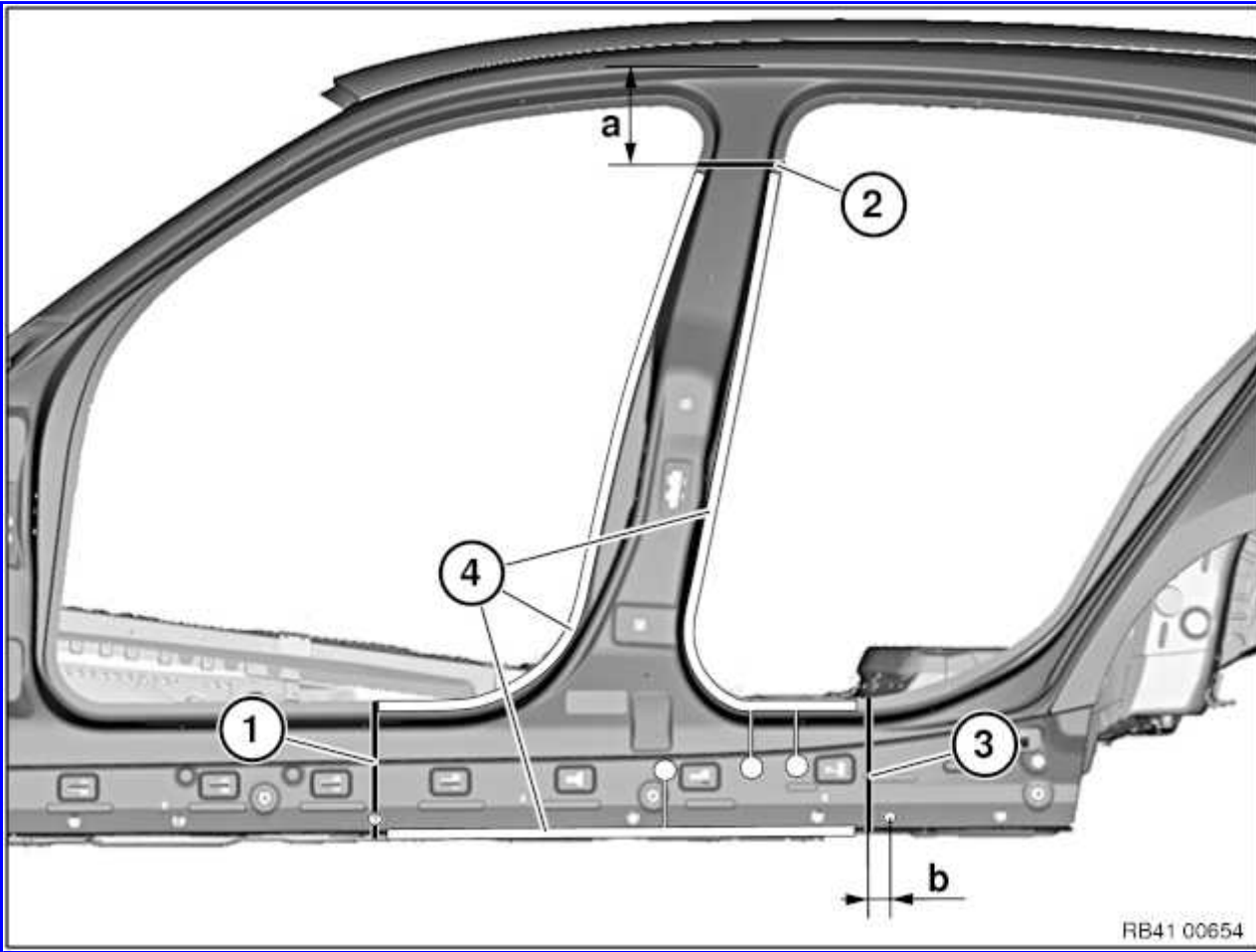
Place vehicle on straightening bench.



Following new body parts are required (see Electronic Parts Catalogue EPC):

- (1) Outer side frame
- (2) Middle side frame
- (3) Shaped part, B-pillar (not shown)

**Removal of B-pillar with reinforcement**



Mark severance cuts (1) to (3) and cut according to specifications.

Important!

Cut outer panel only for following severance cuts.

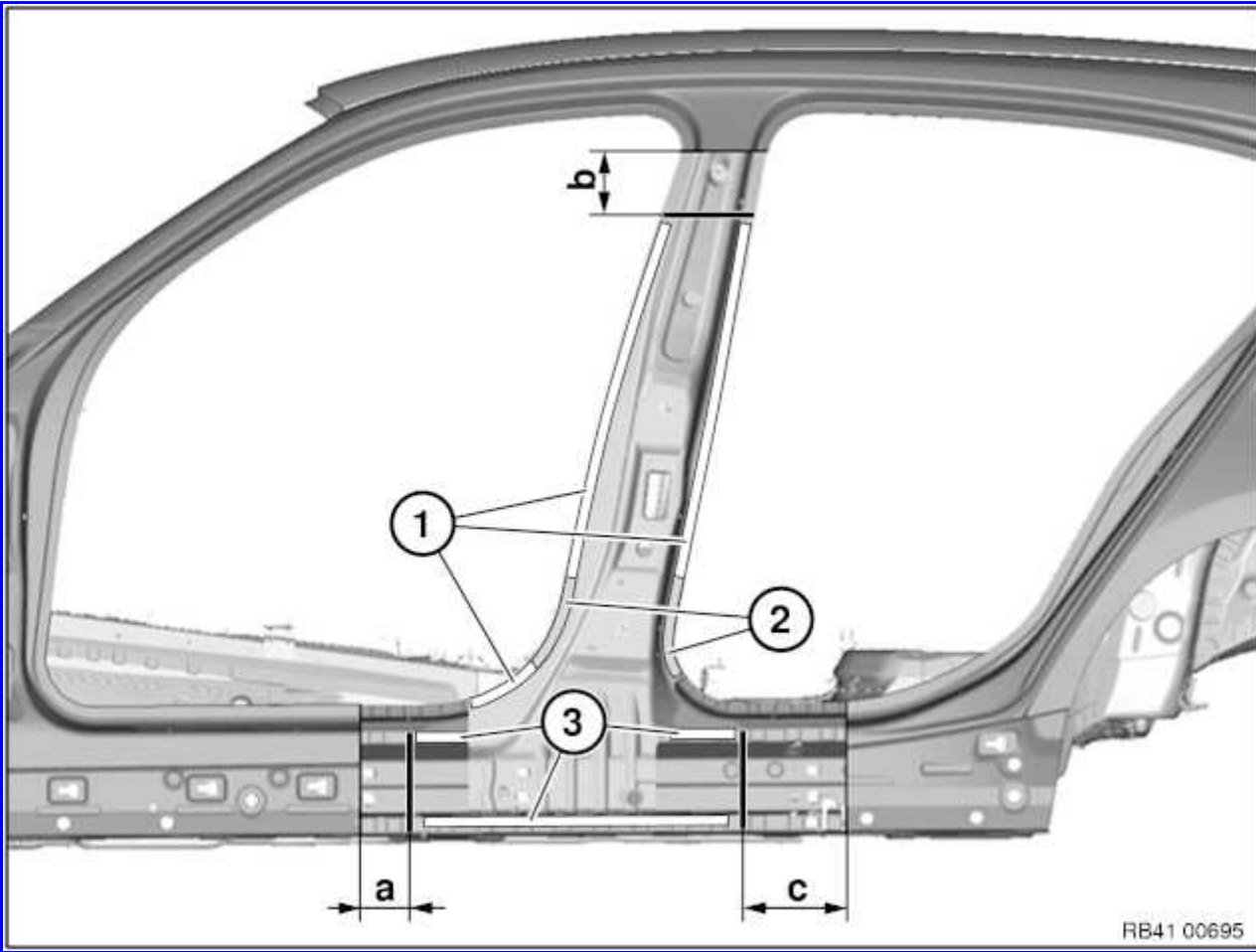
Severance cut (1): through 20 mm diameter hole.

Severance cut (2): Dimension a = approx. 120 mm from edge of roof frame.

Severance cut (3): Dimension b = approx. 30 mm in front of 20 mm diameter hole.

Open welded connections in areas (4).

Remove B-pillar (outer skin).



Mark severance cuts in accordance with specified dimensions and cut.

Important!

Cut outer panel only for following severance cuts.

Dimension a = approx. 70 mm behind previous separation cut.

Dimension b = approx. 90 mm below previous severance cut.

Dimension c = approx. 160 mm in front of previous separation cut.

Open welded connections in areas (1) to (3).

Note:

Open welded connections in areas (2) for both outer panels.

Important!

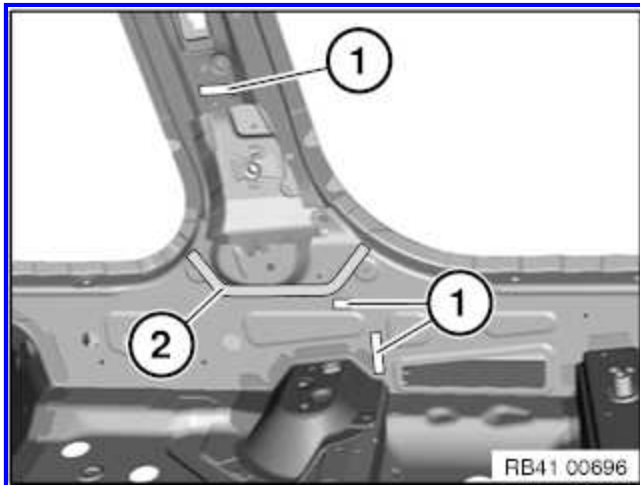
When opening welded connections in areas (3) do not damage panel behind.

The same welding points must be used again when welding the new parts.

View, B-pillar passenger compartment.

Open welded connections in areas (1).

Release B-pillar reinforcement and cavity sealing (2) and remove.



New part preparation

Mark severance cuts on new parts in accordance with severance cuts on vehicle and cut.

Prepare [reinforcement plates](#) at severance cuts.

Adjust new parts and reinforcements plates with alignment bracket or universal mount.

Note:

When adjusting, due to the absence of an outer skin, it is necessary to place a panel of equal thickness in the area of the door hinges.



Installation of B-pillar with reinforcement

Apply sealing compound to [cavity acoustic baffle](#).

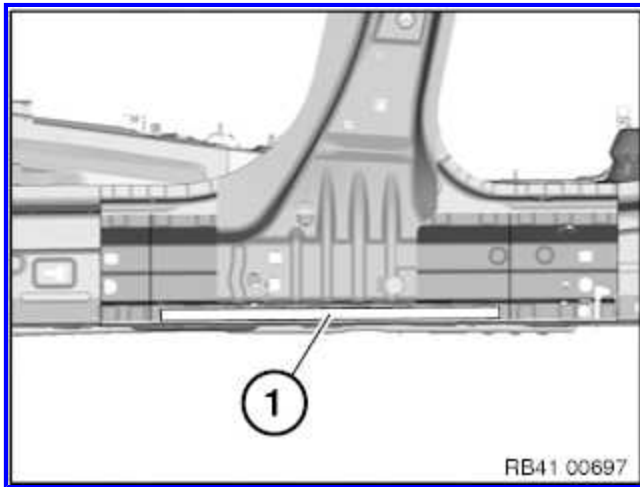
Install new parts and reinforcement plates with alignment bracket or universal mount and weld.

For installation, due to the absence of an outer skin, it is necessary to place a panel of equal thickness in the area of the door hinges.

Note:

In area (1) the floor panel and inner side member are joined by spot-welding bonding technology.

Apply repair welding spots in area (1) to existing welding spots on vehicle.



This is necessary because the adhesive between the spot flanges acts as an insulator.