

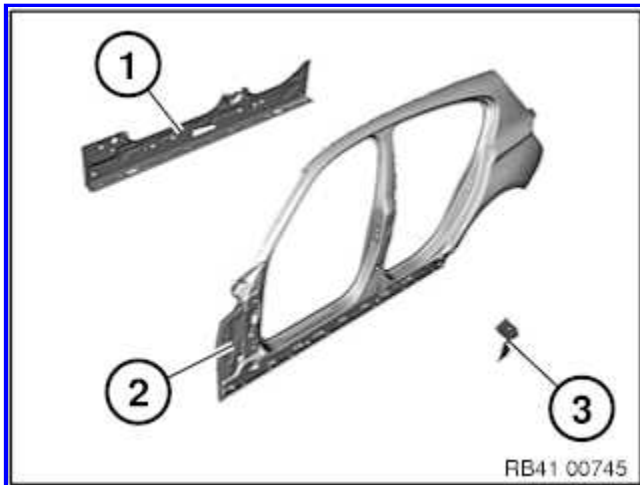
41 11 420**Replace sills, left.**

Procedure [Observe](#) repair stage 3!

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

For stripping and rigging operations, refer to texts on KSD CD (job number 41 11 420).

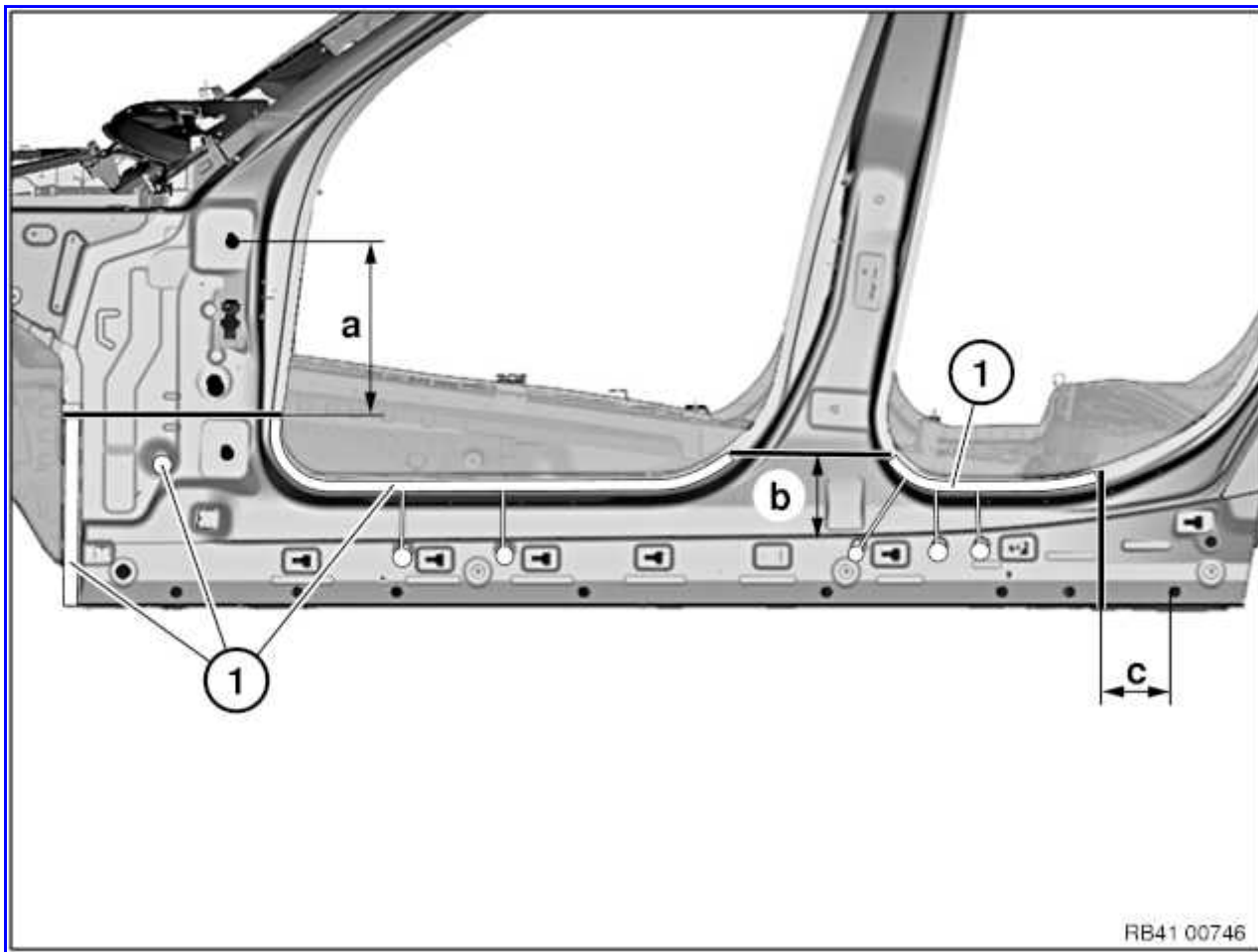
Use only approved [spot-welding apparatus](#) for repairs.



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

- (1) Inner side member
- (2) Side frame, outer
- (3) Sill reinforcement plate (rear side panel)

**Removal**



Mark severance cuts in accordance with specified dimensions and cut.

Important!

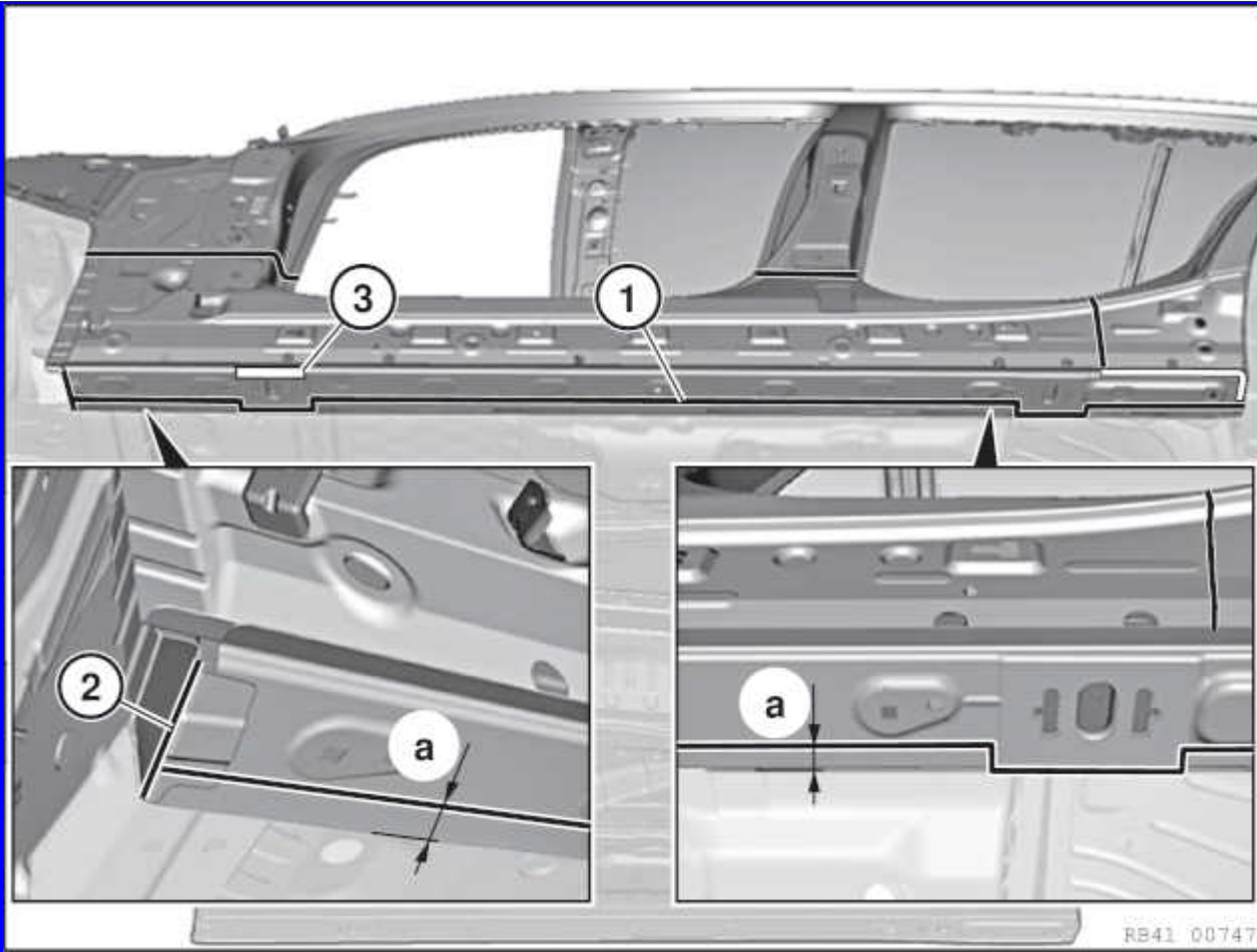
Cut outer panel only.

Dimension a = approx. 275 mm from centre point of 20 mm dia. hole.

Dimension b = approx. 140 mm from component edge of sill.

Dimension c = approx. 115 mm before centre point of hole dia. 20 mm.

Open welded connections in areas (1).

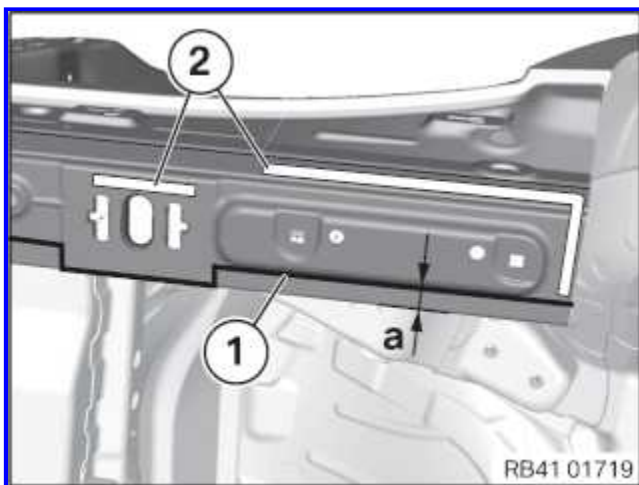


Mark severance cut (1) in accordance with dimension a and cut.

Measurement a = approx. 20 mm from component edge.

Carry out severance cut (2) at component edge.

Open welded connections in area (3).



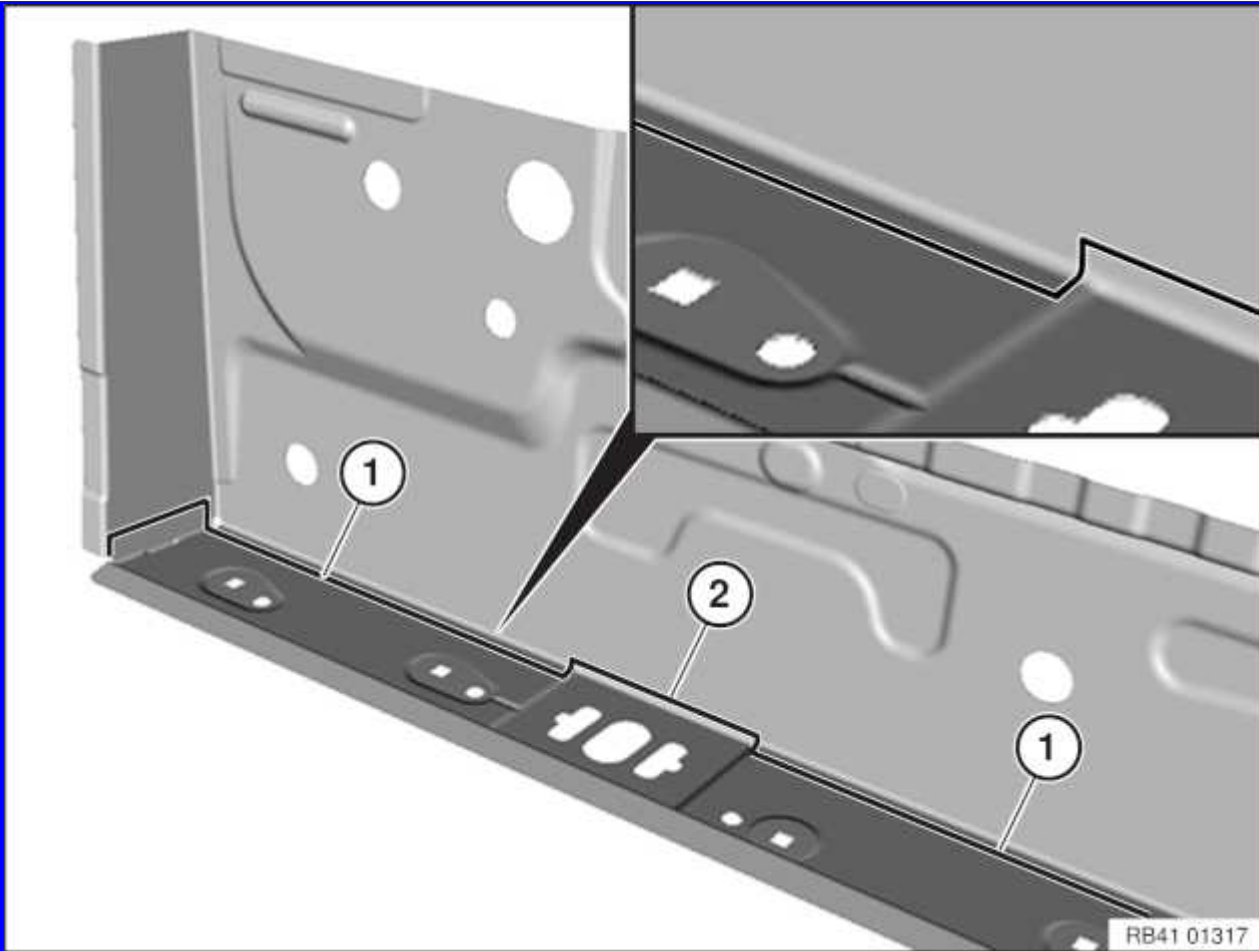
Mark severance cut (1) in accordance with dimension and cut.

Dimension a = approx. 15 mm from component edge.

Open welded connections in areas (2).

Release and remove side sill from cavity sealings.

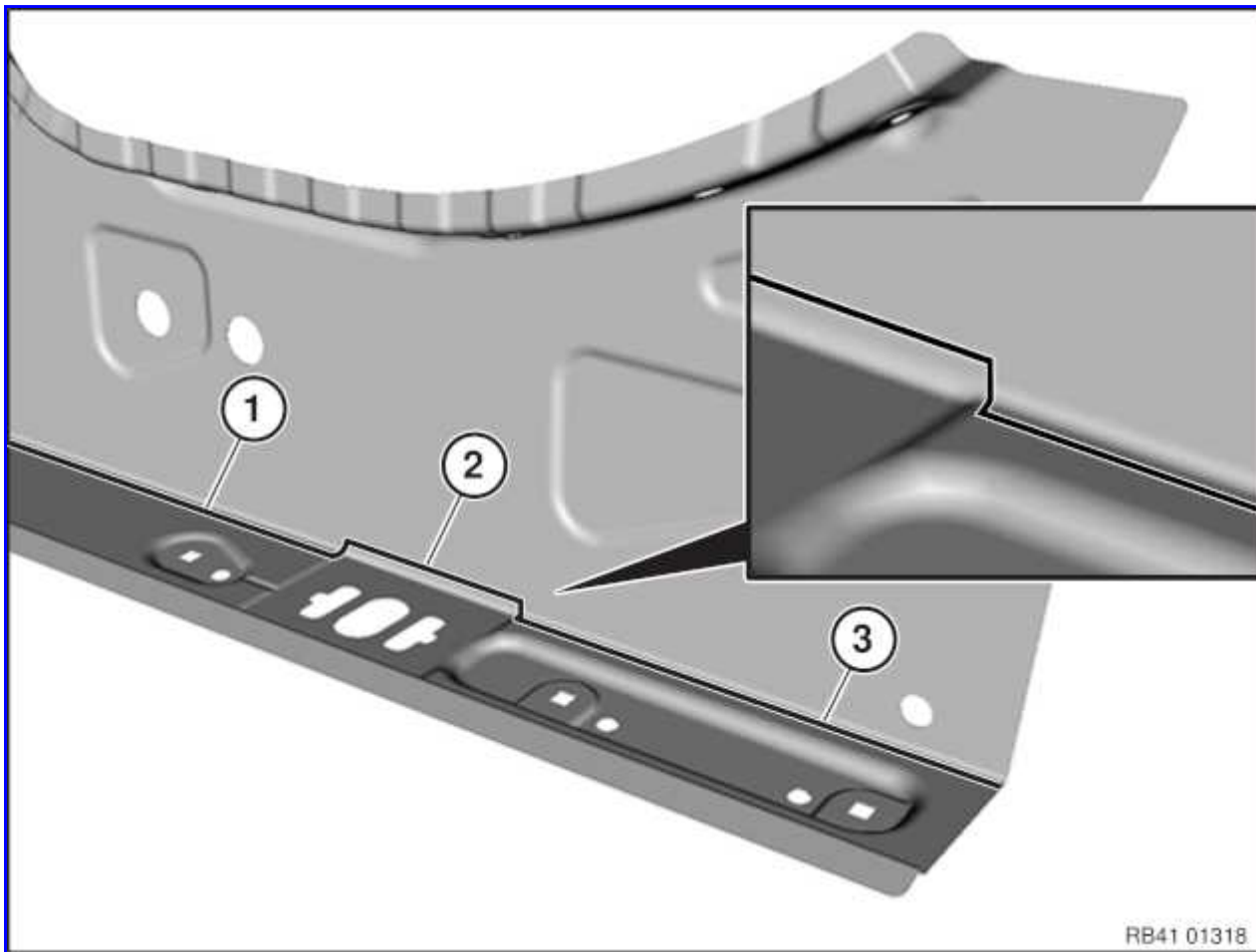
New part preparation



Inner front side member:

Mark severance cut (1) in accordance with severance cut on vehicle +15 mm extra material and cut.

In area (2) of jacking point, extra material = 5 - 10 mm.

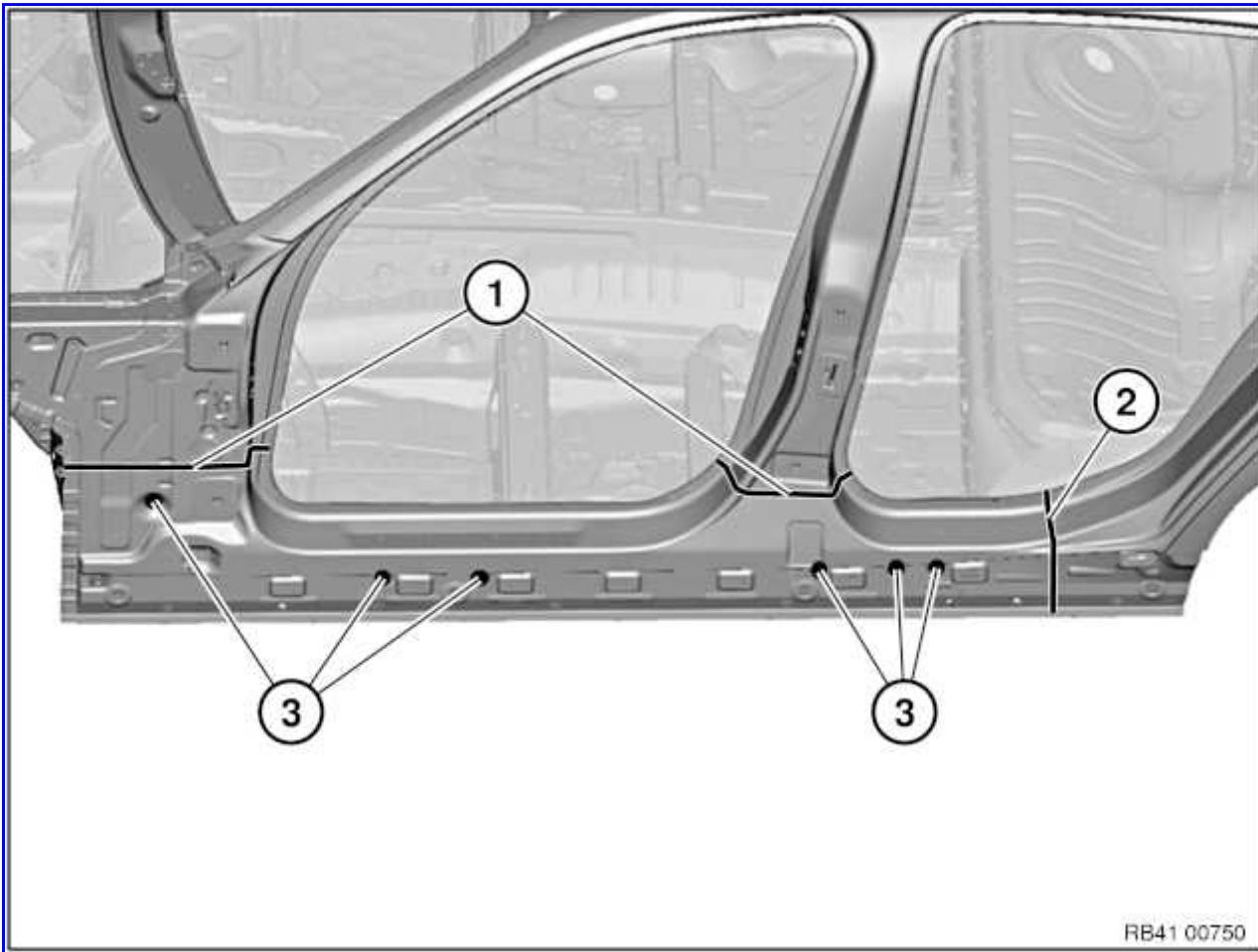


Inner rear side member:

Mark severance cut (1) in accordance with severance cut on vehicle +15 mm extra material and cut.

In area (2) of jacking point, extra material = 5 - 10 mm.

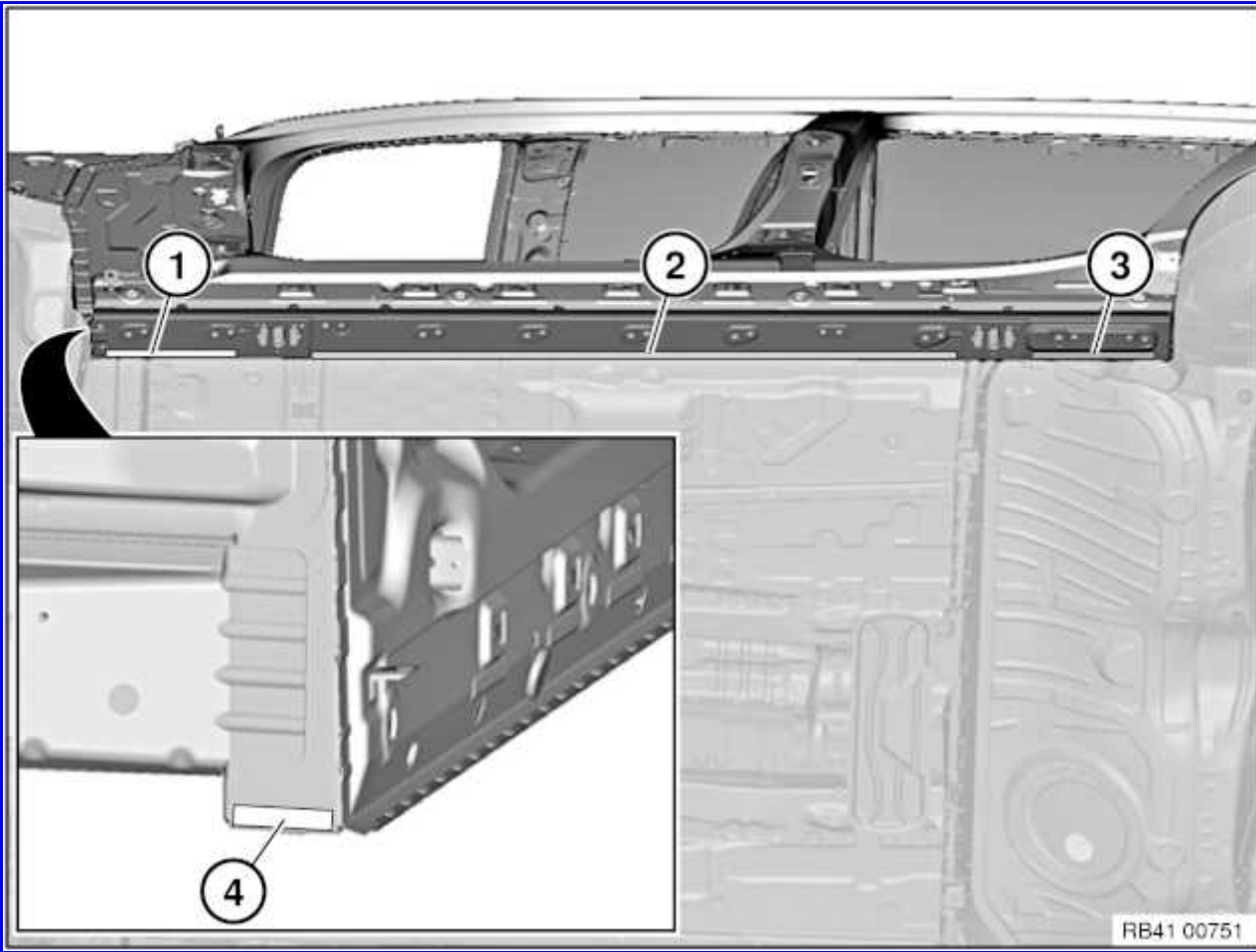
In area (3) extra material = approx. 10 mm.



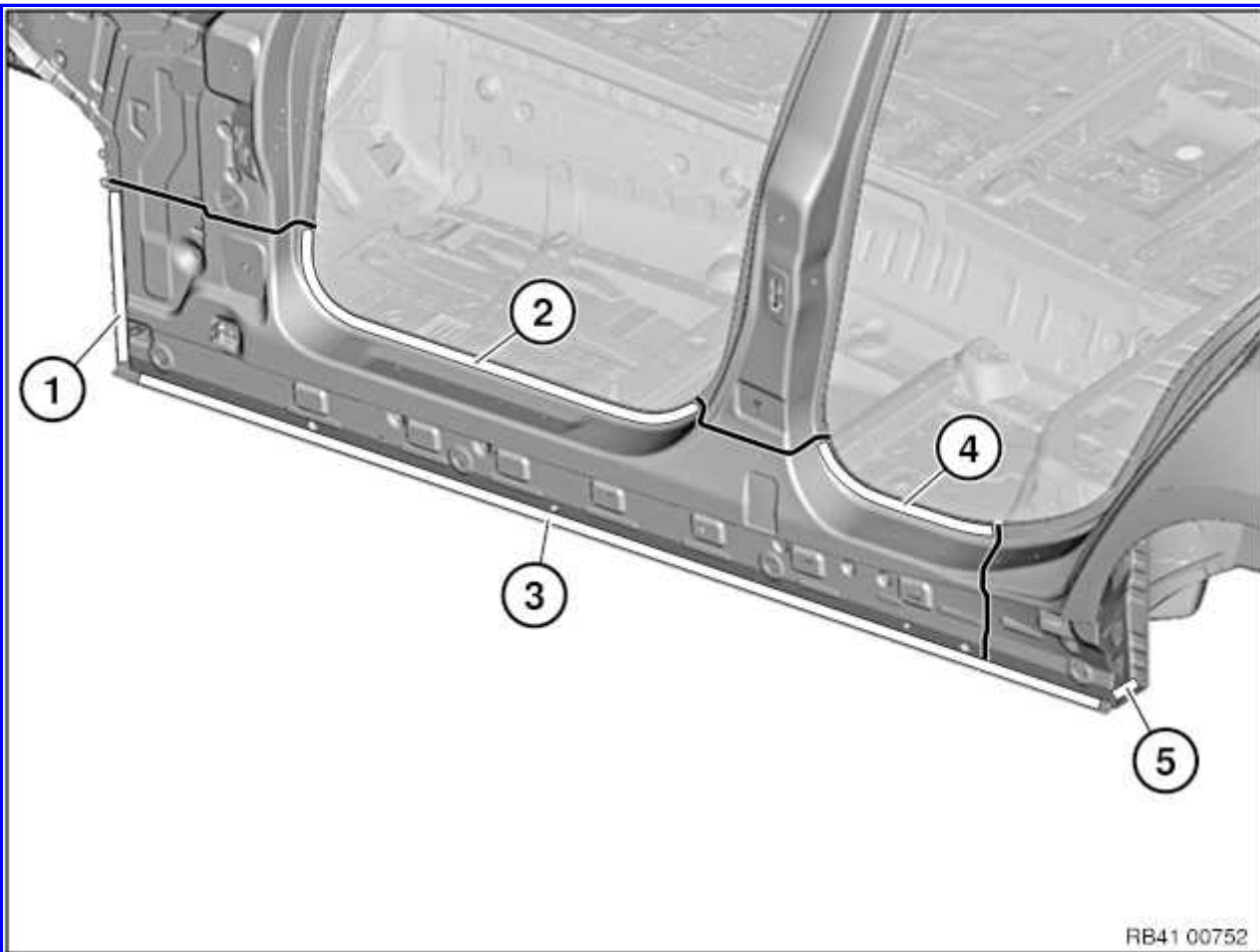
Adjust new parts to fit and secure.

For severance cuts (1) and (2), prepare [reinforcement plates](#).

Prepare new part for plug welding in areas (3).



Prepare new part for plug welding in areas (1) - (4).



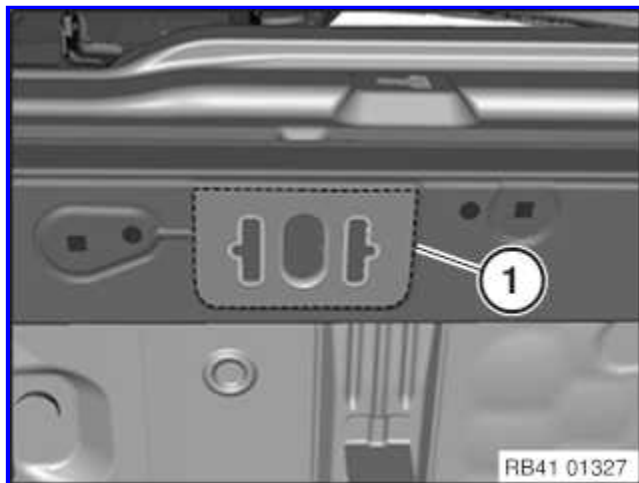
Prepare new part for spot welding in areas (1) - (5).

Remove new parts again and deburr bore holes.



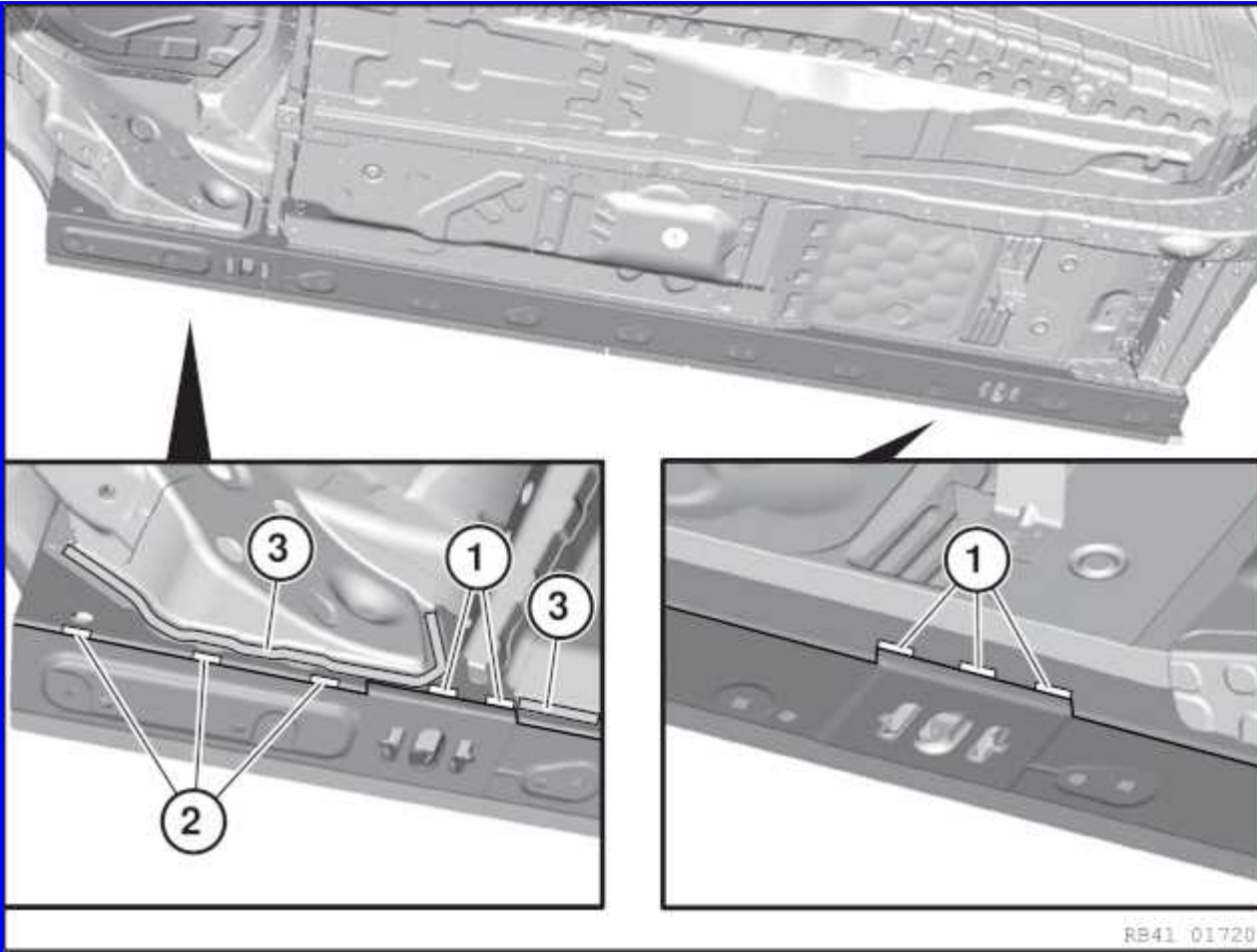
Installation

Install and weld new parts and reinforcement plates.



Note:

The new part must be welded gap-free in area of jacking point (1).



RB41 01720

Perform MAG weld (metal active gas) for new part in areas (1) of jacking points.

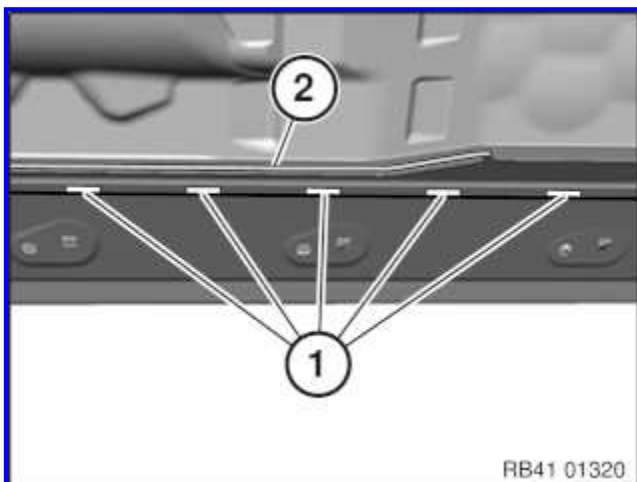
For this purpose, set weld seams with a length of 20 mm at a distance of 20 mm in each case.

Additionally weld new part with 20 mm long metal active gas weld seams (2) at distance of 60 mm.

Important!

Risk of damage to adhesive area!

Avoid applying excessive heat to the neighbouring adhesive areas (3)!



RB41 01320

Additionally weld new part with 20 mm long metal active gas weld seams (1) at distance of 60 mm on both sides.

Important!

Risk of damage to adhesive area!

Avoid applying too much heat to adjacent adhesive area (2) of floor panel!