

41 21 003**Replacing A-pillar with reinforcement on left**

Procedure [Observe](#) repair stage 3!

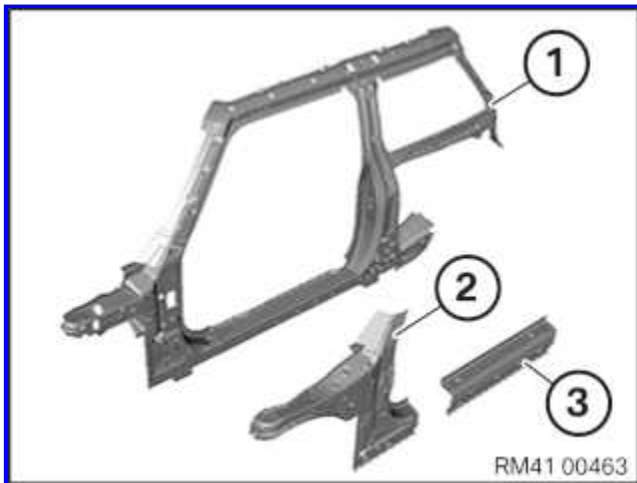
Read contents of [Body, General](#).

For stripping and rigging operations, refer to texts on KSD CD (job number: 41 21 003).

Spot-weld bonding is used on this vehicle. Observe specific [procedure](#).

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

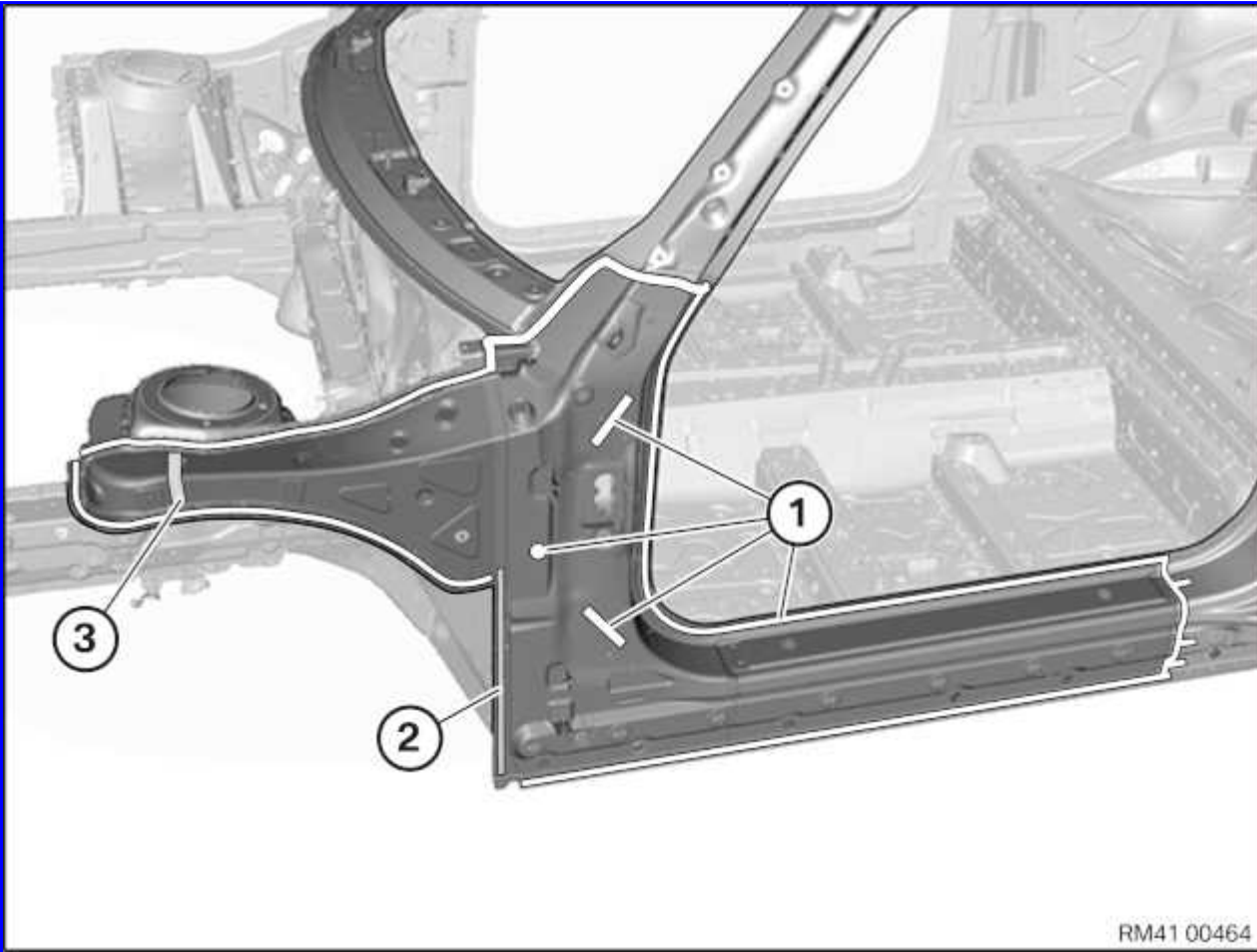
Place vehicle on straightening bench.



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

- (1) Middle side frame
- (2) Outer front side frame
- (3) Outer side sill

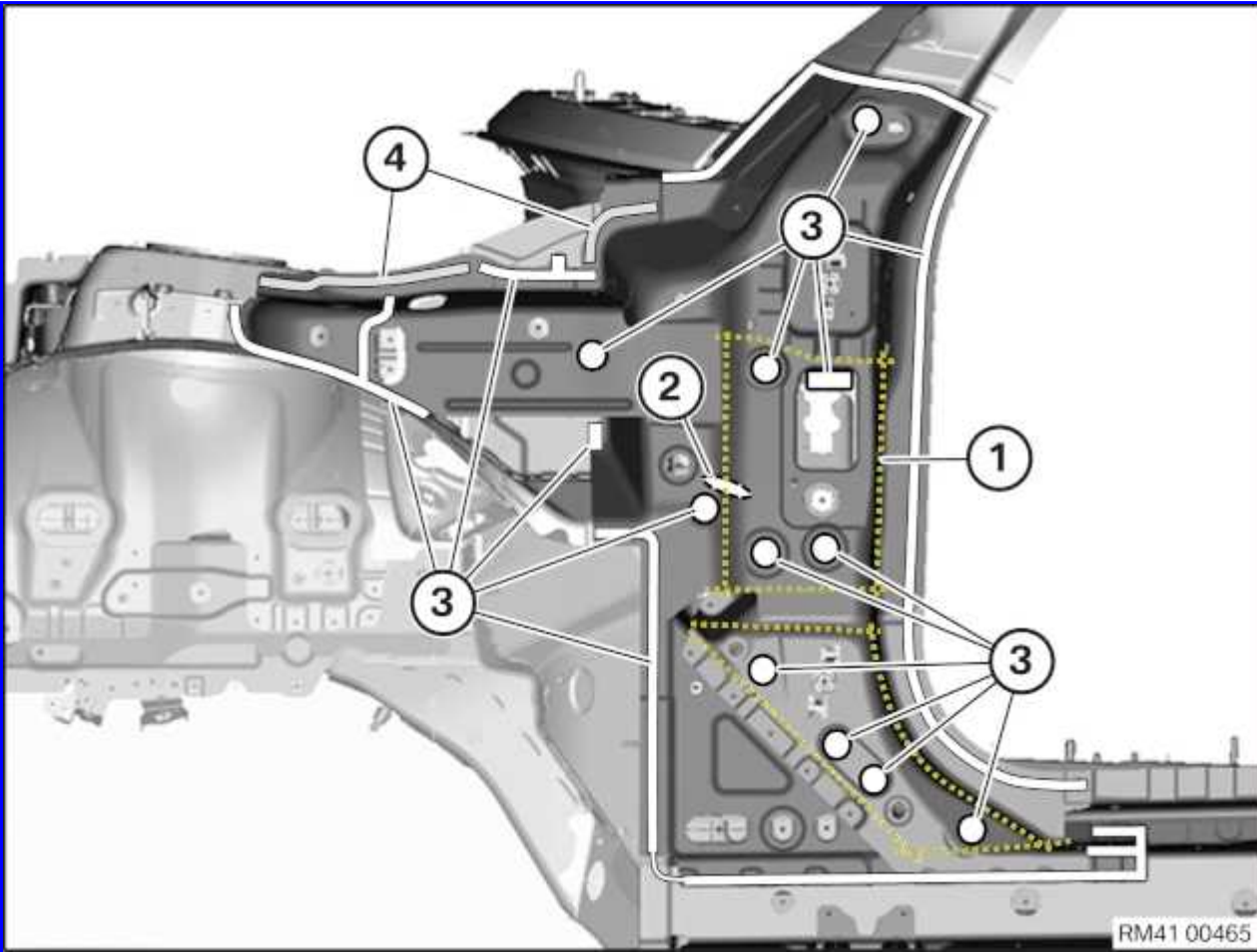
**Removal:**



Open welded connections in areas (1).

[Open](#) spot-welded adhesive joints in area (2).

Release and remove A-pillar outer section from cavity sealing (3).



Roughly mark areas (1) as pictured and cut.

Important!

Cut outer panel only.

Do not damage bulkhead in area (2)!

Open welded connections in areas (3).

Open spot-welded adhesive joints in area (4).

Remove A-pillar reinforcement.

If necessary, additionally replace side member attachment. HTSP.....

.....addition top ..instructions for outer A-pillar in area of windscreen.....

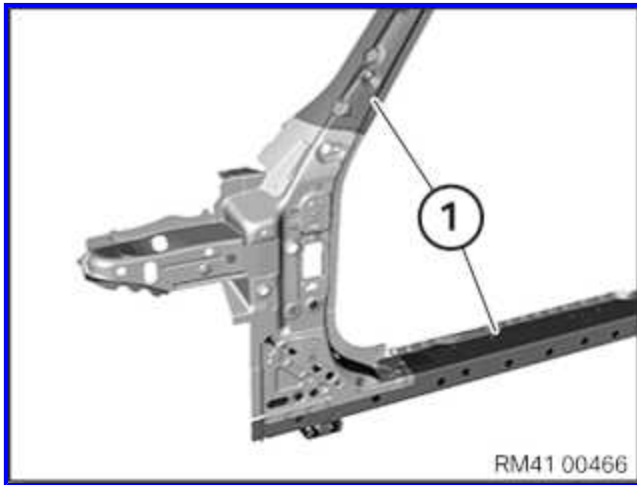
.....and bottom side member attachment, first left side sill 41 1 420

.....side member attachment: Clarification first concerning severance cut (material).....



Preparation of new part:

Open welded connections for components (1) which are not required. Remove components (1) which are not required.



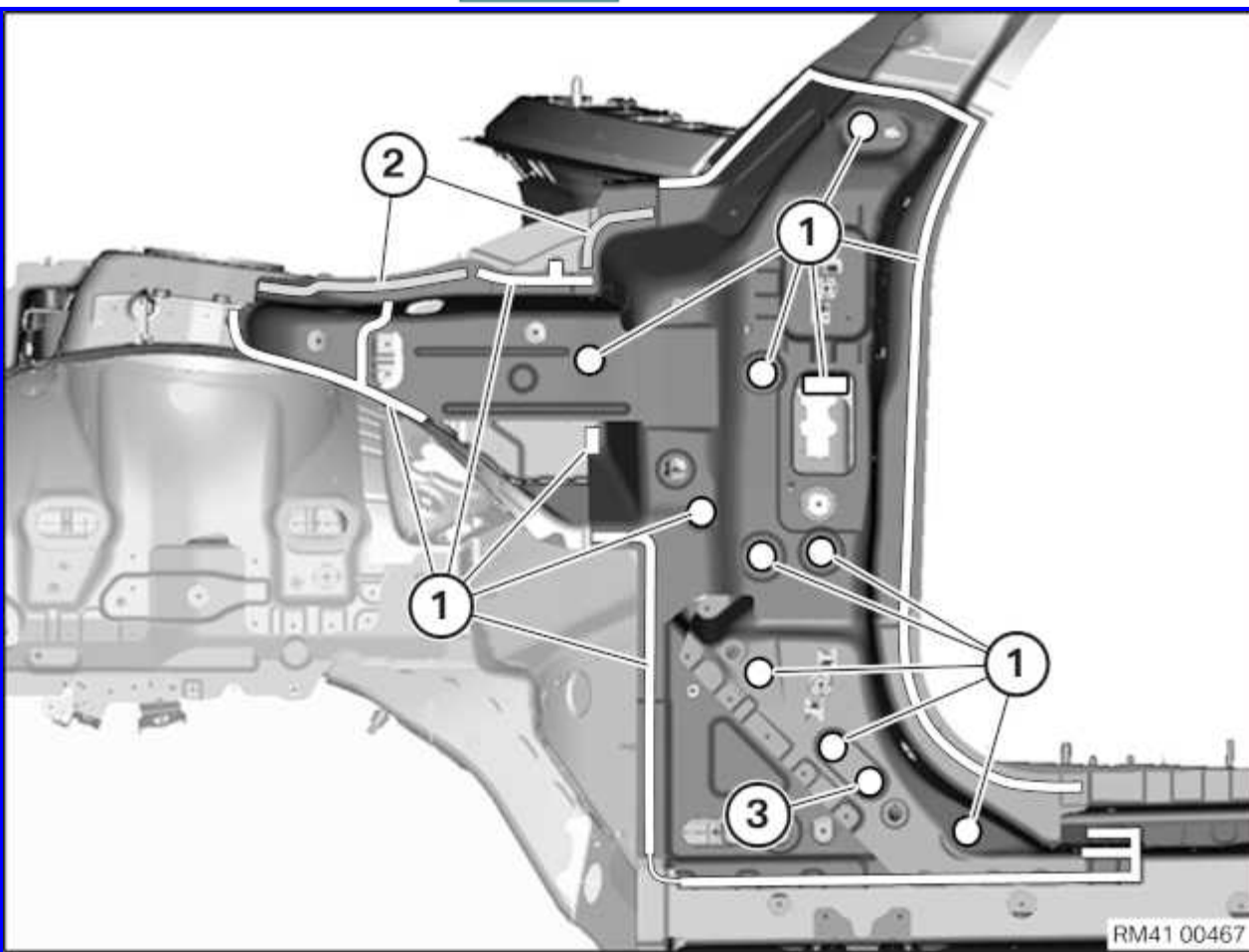
Adjust new parts to fit with alignment bracket or universal mounting.

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:



Install A-pillar with alignment bracket or universal fixture and weld in areas (1) and (2).

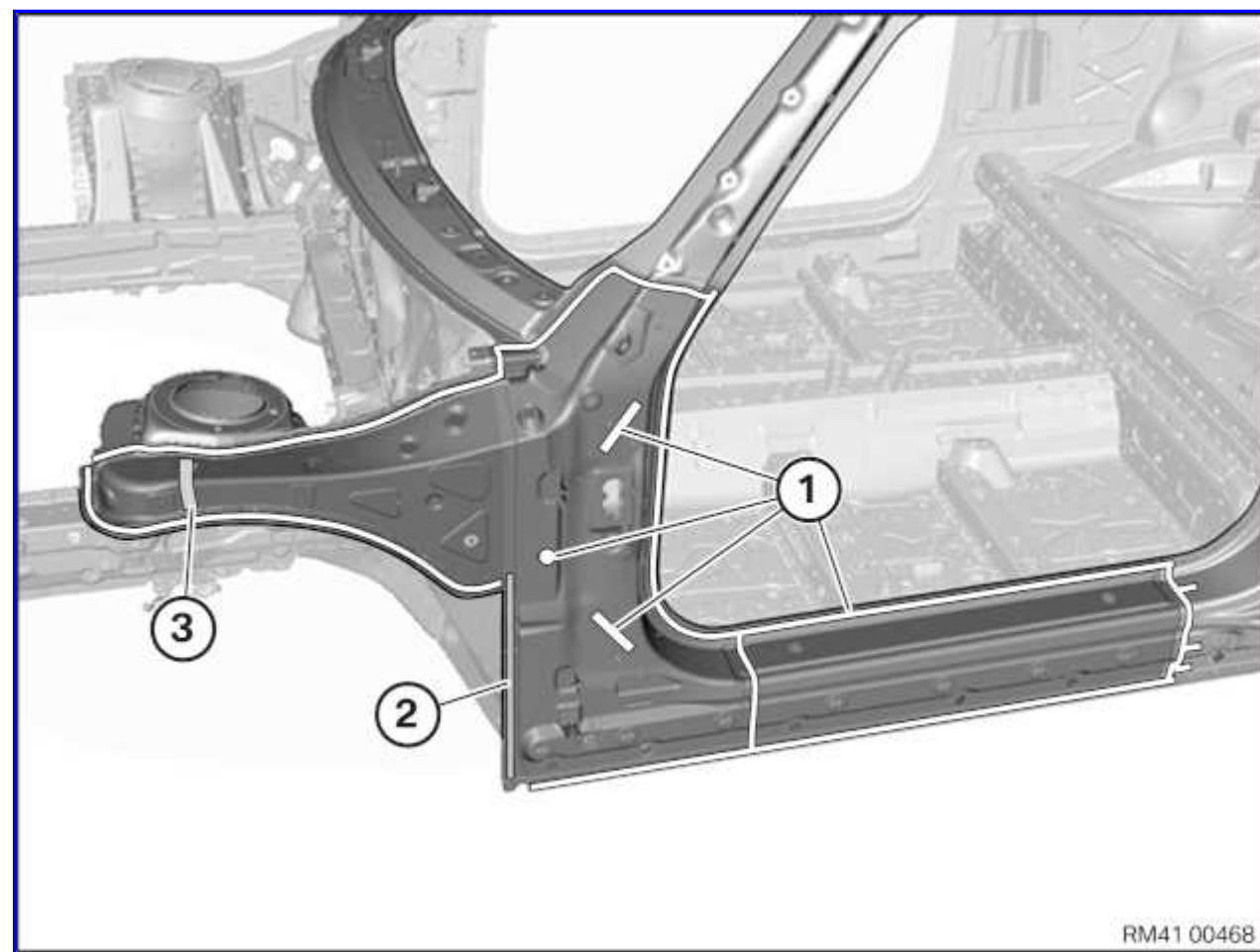
Note:

When installing, 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 [double number of welding spots](#) in areas (2).

Apply repair welding spot (3) to existing welding spot on vehicle. This is necessary because the adhesive

between the spot flanges acts as an insulator.



Apply sealing compound to [cavity sealing](#) (3).

Install new parts and weld in areas (1) and (2).

Note:

Note double number of welding spots in area (2).

Vehicles with slide/tilt sunroof: Make sure water drain hose is installed correctly! (watertightness).

In vehicles with a normal roof, a grommet is installed instead of the water drain hose.