

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

Procedure [Observe](#) repair stage 3!

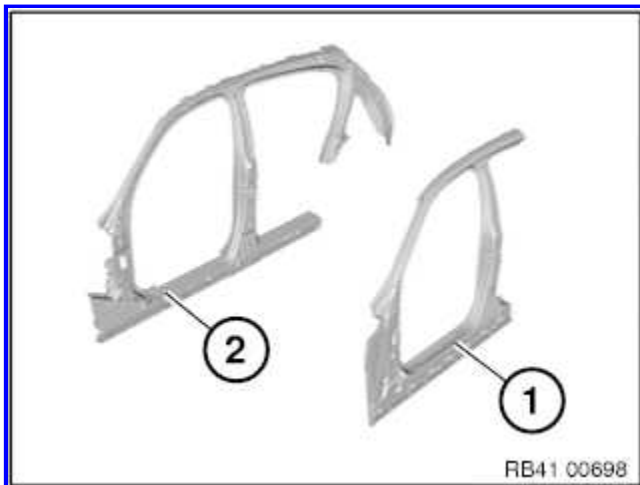
Read contents of [Body, General](#).

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.



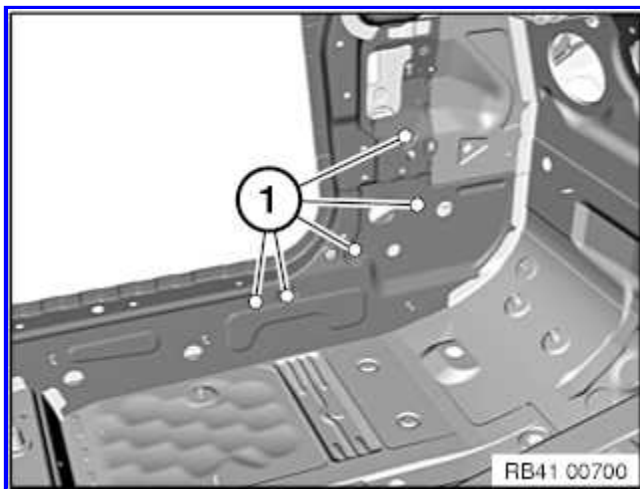
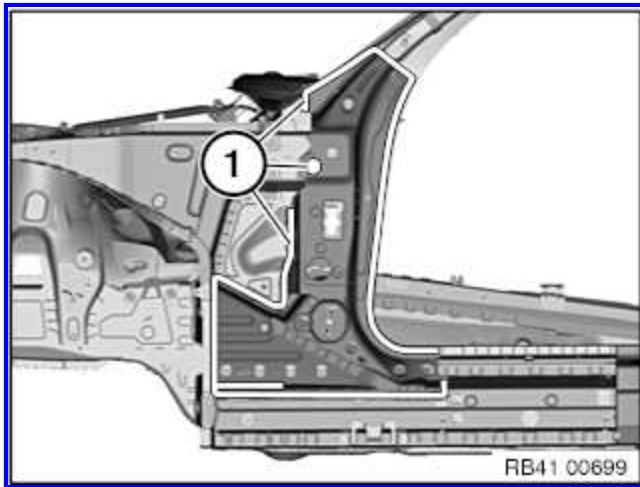
Following new body parts are required (refer to Electronic Parts Catalogue):

- (1) A-pillar, outer
- (2) Middle side frame
- (3) Shaped part, A-pillar, top (not shown)
- (4) Shaped part, A-pillar, top inside (not shown)

Following [consumables](#) are required:

Material	Quantity
Blind rivet N1	1
Blind rivet N2	1

Removing the A-pillar with reinforcement



View of passenger compartment A-pillar.

Loosen welded connections (1) and remove A-pillar reinforcement.



New part preparation

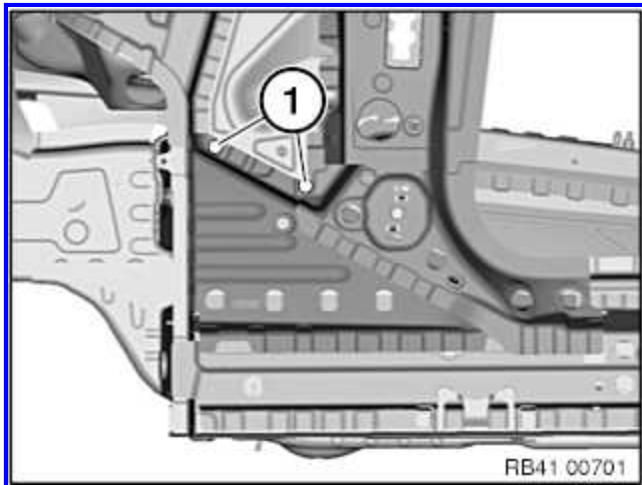
Mark severance cuts on new parts according to severance cuts on vehicle and sever.

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

Adjust A-pillar to fit with alignment bracket or universal mount and secure.

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.



In areas (1), set 2 bore holes $\varnothing$ 6.8 mm for blind rivets.
Remove new parts and deburr bore holes.

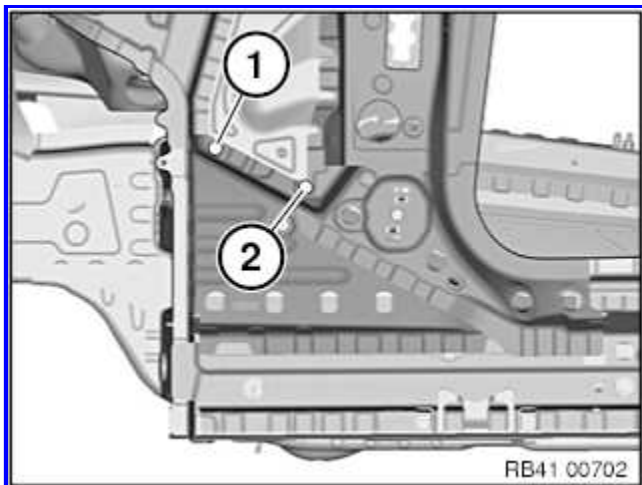


Installing the A-pillar with reinforcement

Apply sealant to [cavity sealing](#).

Install new A-pillar and reinforcement plates with alignment bracket or universal mount and fix.

When adjusting, the lack of outer skin means that a plate with the same thickness must be used as a shim in the area of the door hinges.



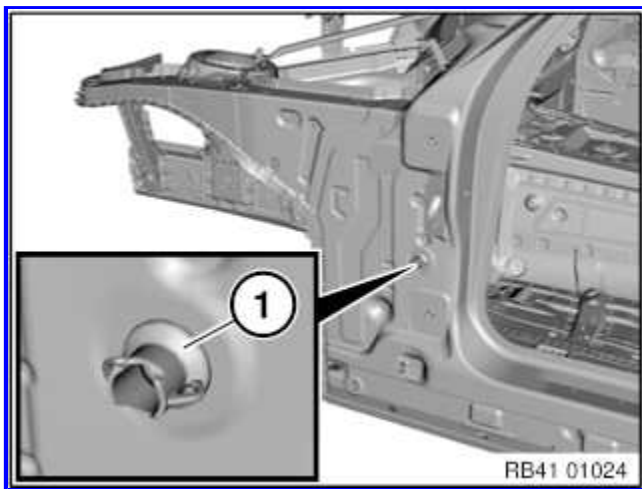
Rivet new part in areas (1) and (2).

Area (1): Blind rivet N1.

Area (2): Blind rivet N2.

Weld new part in further joint areas.

Install and weld outer A-pillar and reinforcement plates.



Note:

- Vehicles with slide/tilt sunroof: Make sure water drain hose (1) is correctly installed (watertightness).
- In vehicle with a normal roof, a grommet is installed instead of the water drain hose.

Please ensure correct installation of the grommet!