

41 11 091**Replacing engine support in front of bulkhead, left**

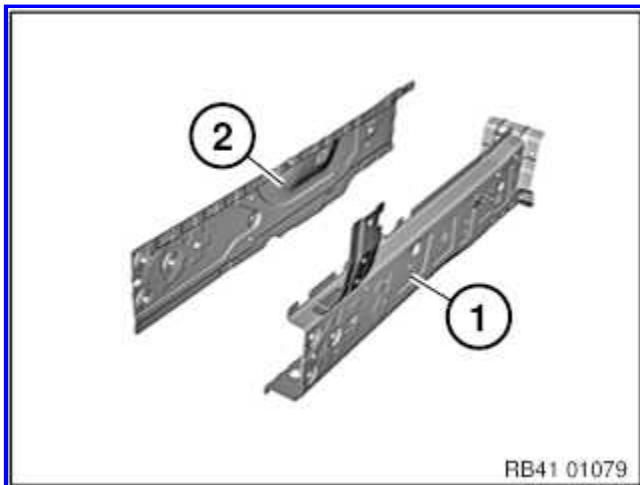
Observe procedure of [repair stage 3](#).

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

For stripping and rigging operations, refer to texts on KSD CD (job number 41 11 091).

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

Place vehicle on straightening bench.



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

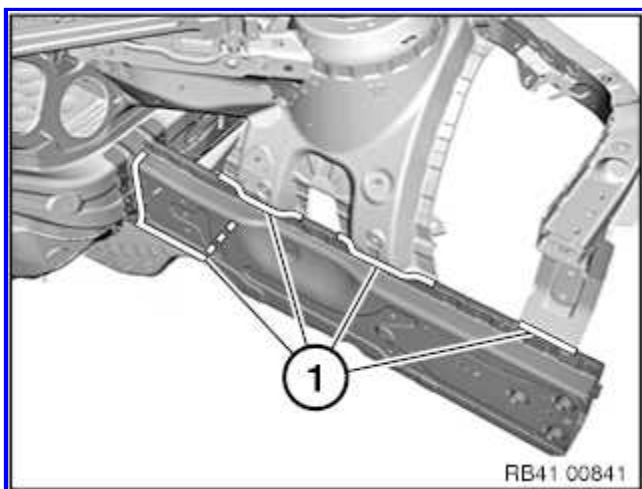
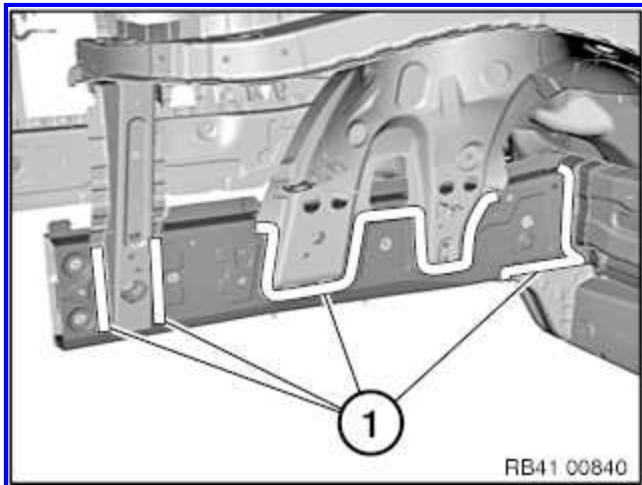
- (1) Engine support, outer left
- (2) Engine support, inner left

Following [consumables](#) are required:

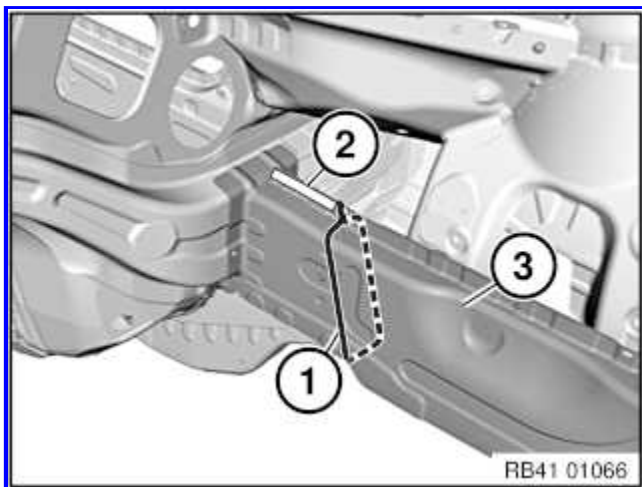
Material	Quantity
Blind rivets N1	4

**Removing the engine support**

Open welded connections in areas (1).



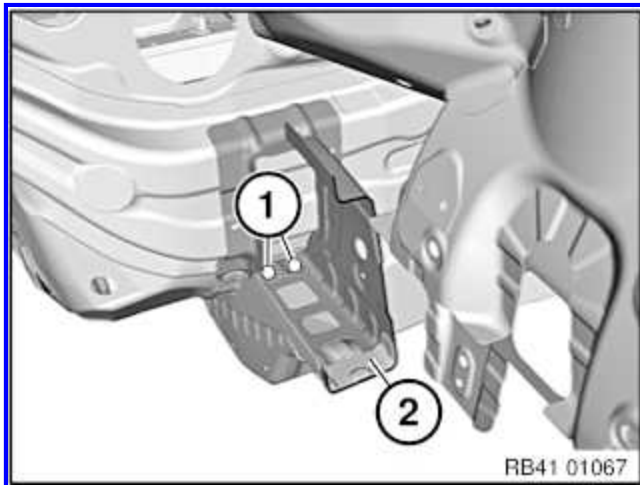
Open welded connections in areas (1).



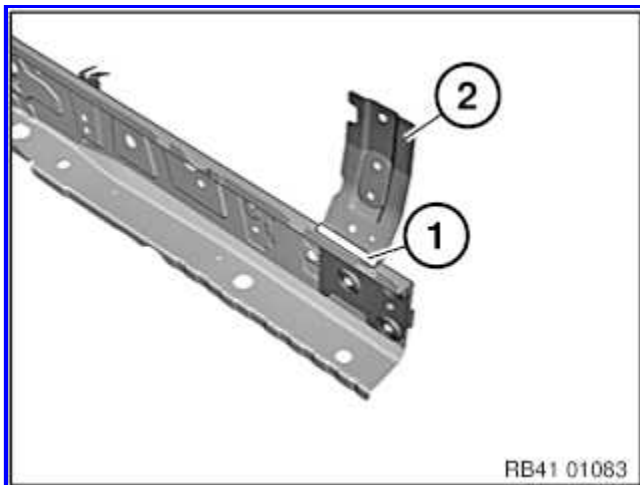
Roughly mark severance cut (1) as pictured and cut.

Open welded connections in area (2) and remove engine support (3).

Open welded connections in areas (1) by grinding and remove residual section of engine support (2).

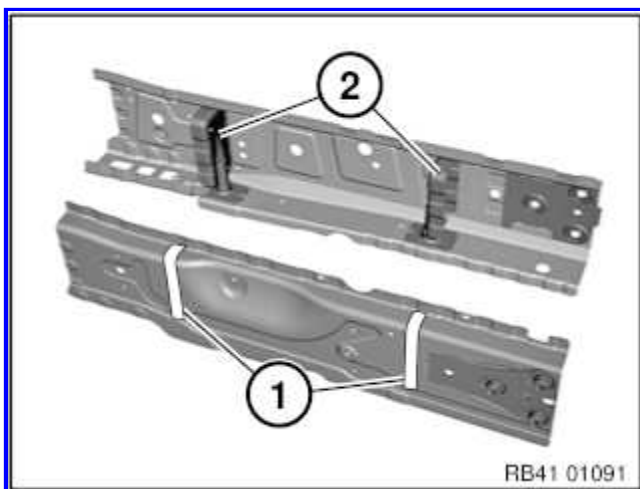
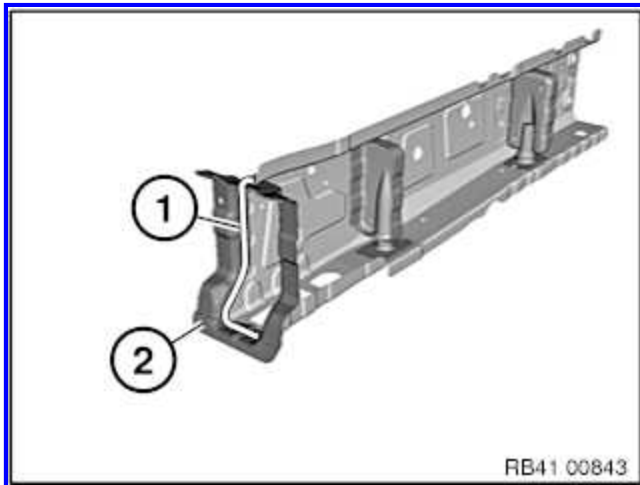


New part preparation

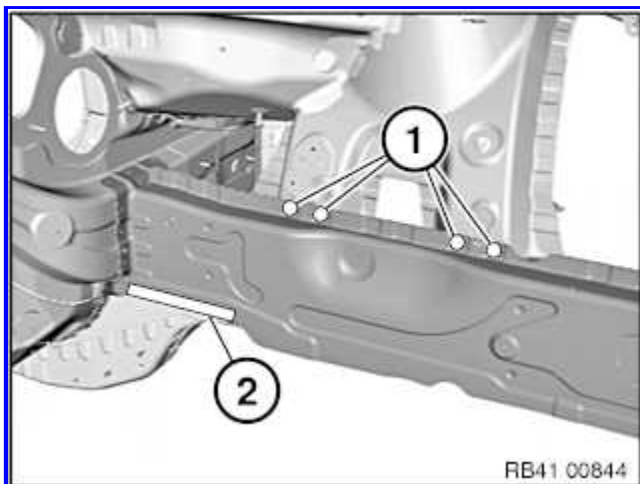


Open welded connections (1) and remove component (2) which is not required.

Release welded connections (1) and remove adapter plate (2).



Set bore holes for welding the reinforcements (2) in areas (1).
Refer to series part for number and position and transfer to new part.



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

In areas (1), create 4 dia. 6.8 mm bore holes for blind rivets N1.

Note:

Three-sheet joint in area (2)!

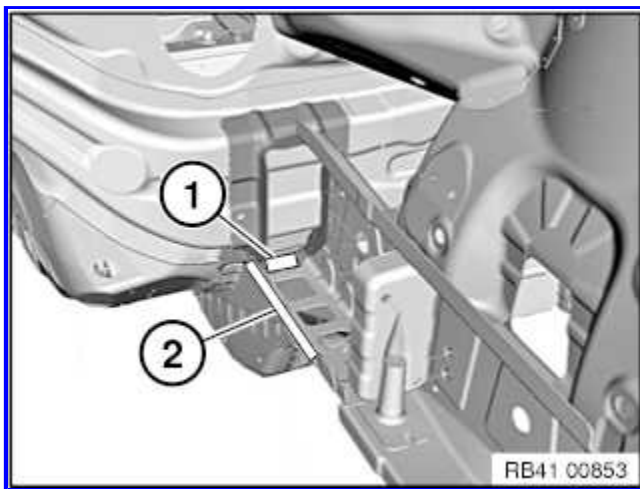
All three panels must be welded in area (2)!

Prepare new parts and vehicle accordingly.

Remove new parts and deburr bore holes.

Installing engine support

Install new parts using an alignment bracket or universal mount.



Rivet and weld new parts.

Note:

Weld the outer section of the engine support to the body in the areas (1) and (2)!