

41 11 095**Replacing engine support in front of wheel arch, left**

Follow procedure for [repair stage 3](#).

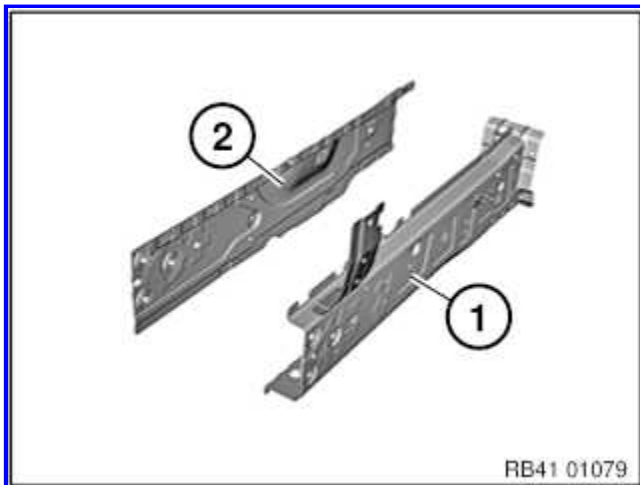
Read contents of [Body, General](#).

[Strip down vehicle](#).

For stripping and rigging operations, refer to texts on KSD CD (job number 41 11 095).

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
- (2) Engine support, inner

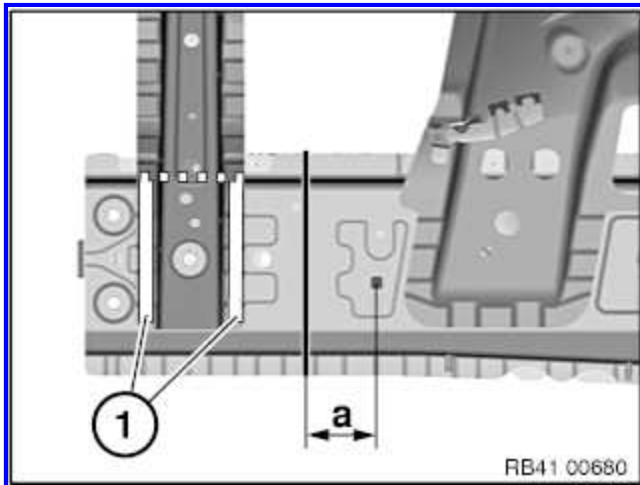
**Removal**

Mark severance cut in accordance with Dimension a and cut.

Important!

Offset severance cuts!

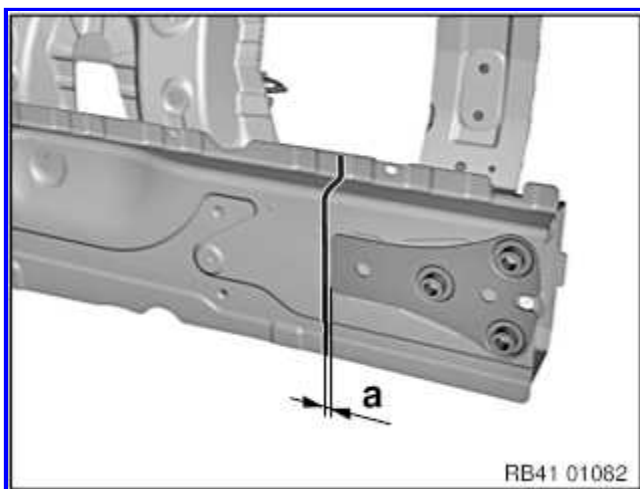
Cut outer metal panel only.



Dimension a = approx. 63 mm before centre point of 9 x 9 mm dia. hole.

Severance cut path is carried out through 7 mm diameter hole.

Open welded connections in areas (1).



View of inside:

Mark severance cut in accordance with Dimension a and cut.

Important!

Cut outer metal panel only.

Dimension a = approx. 5 mm from component edge of reinforcement plate.

Remove section of engine support.

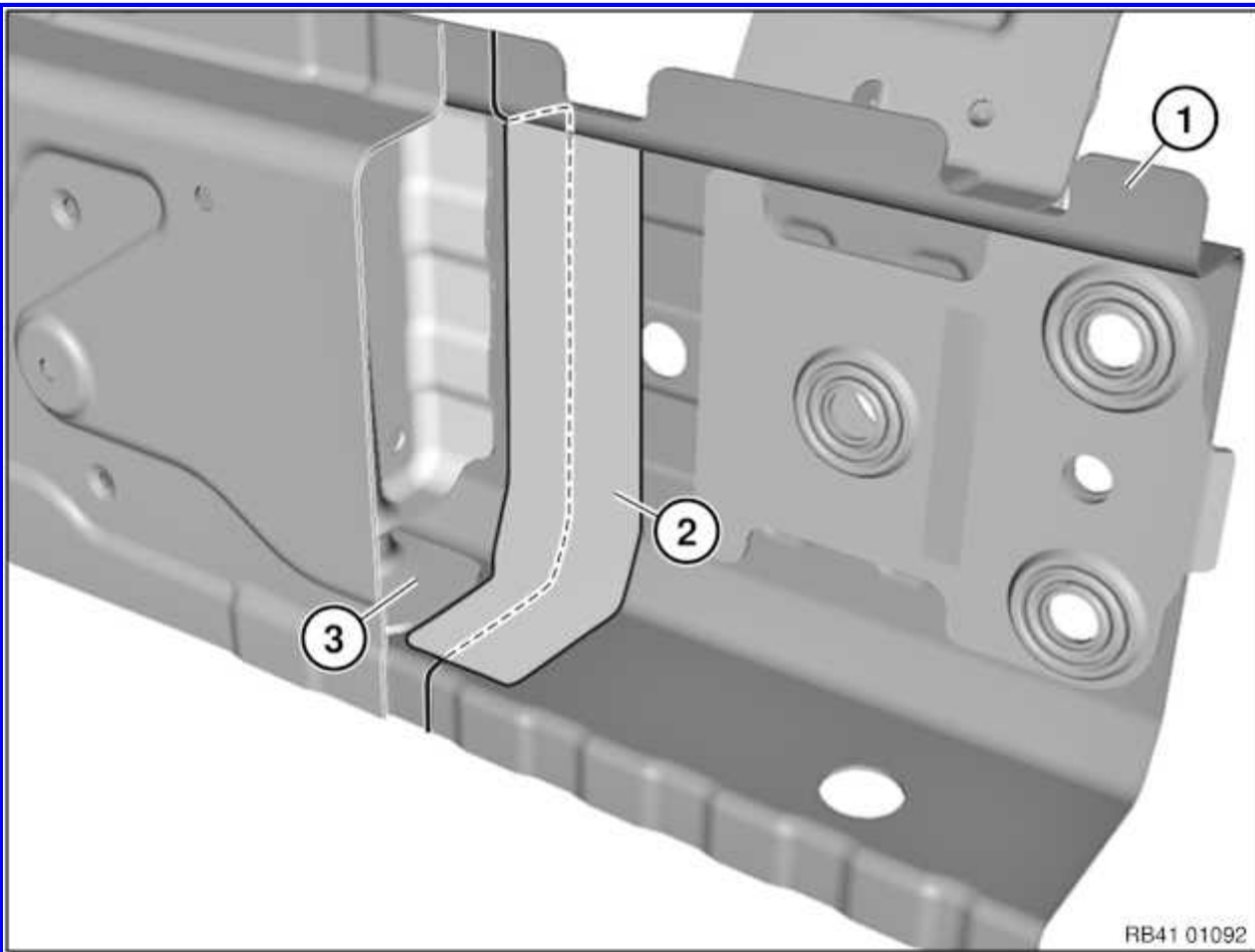
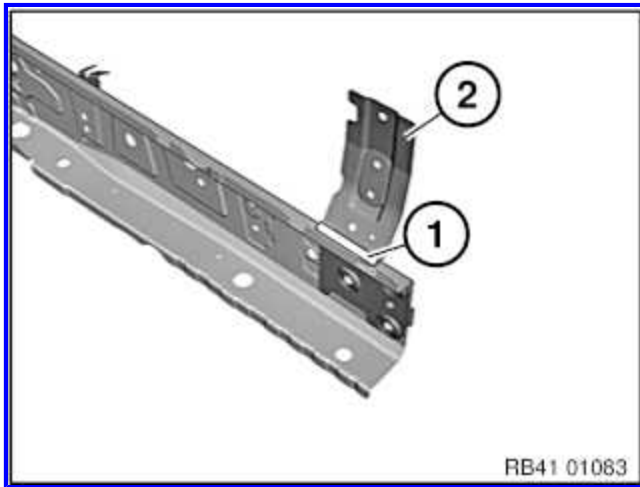


New part preparation

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

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

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



Adjust engine support outer section (1) to alignment bracket or universal fixture and fix in position.

Adjust [reinforcement plate](#) (2) for engine support outer section (1) according to schematic diagram.

Remove engine support outer section.

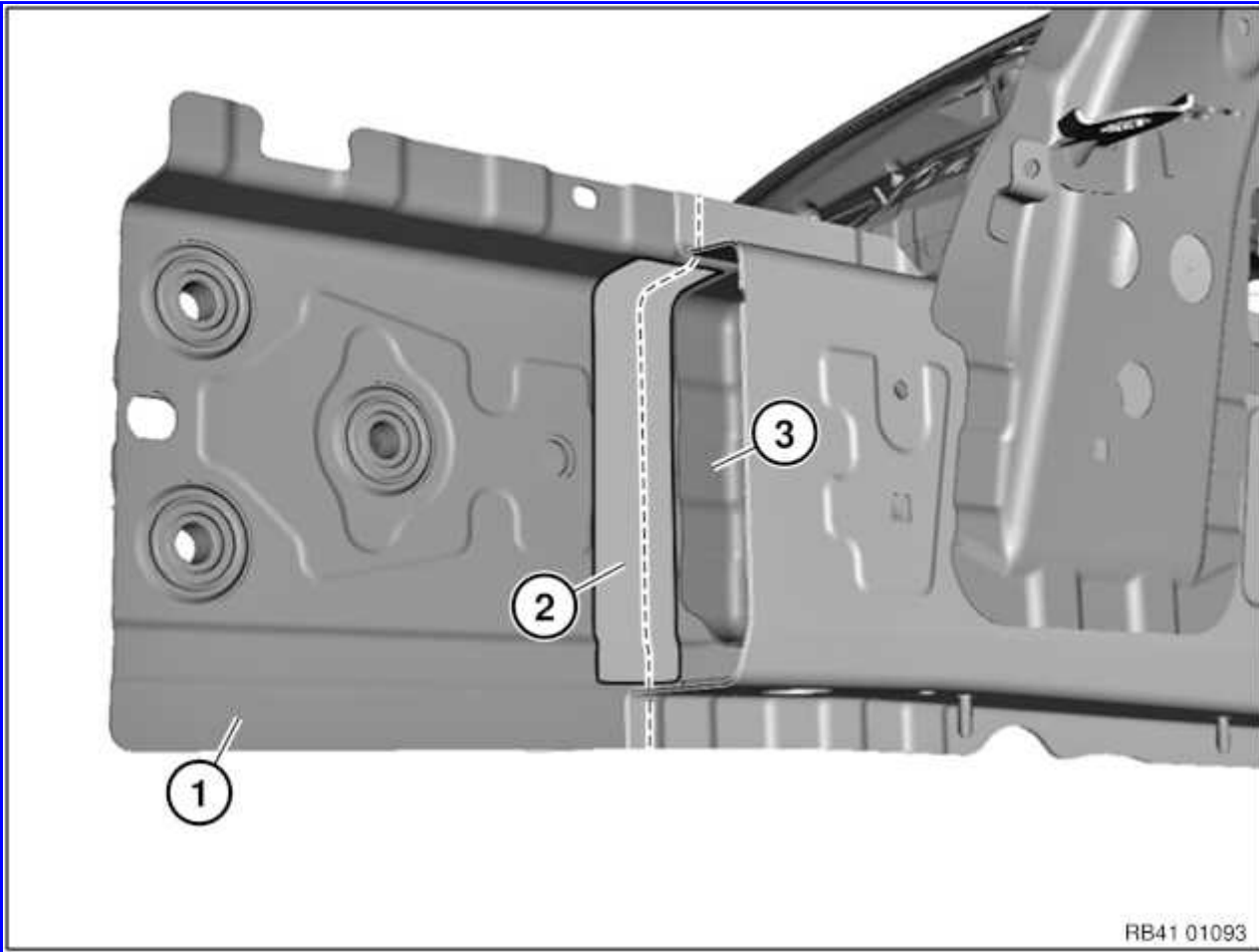
Important!

Reinforcement plate must be adjusted in area of axle support (3).

Different procedure: Reinforcement plate is welded from inside during installation.

Bore hole for welding the reinforcement plate from outside are therefore not required.

Alignment bracket not shown for purposes of clarity.



Adjust engine support inner section (1) to alignment bracket or universal fixture and fix in position.

Adjust [reinforcement plate](#) (2) for engine support inner section (1) according to schematic diagram.

Important!

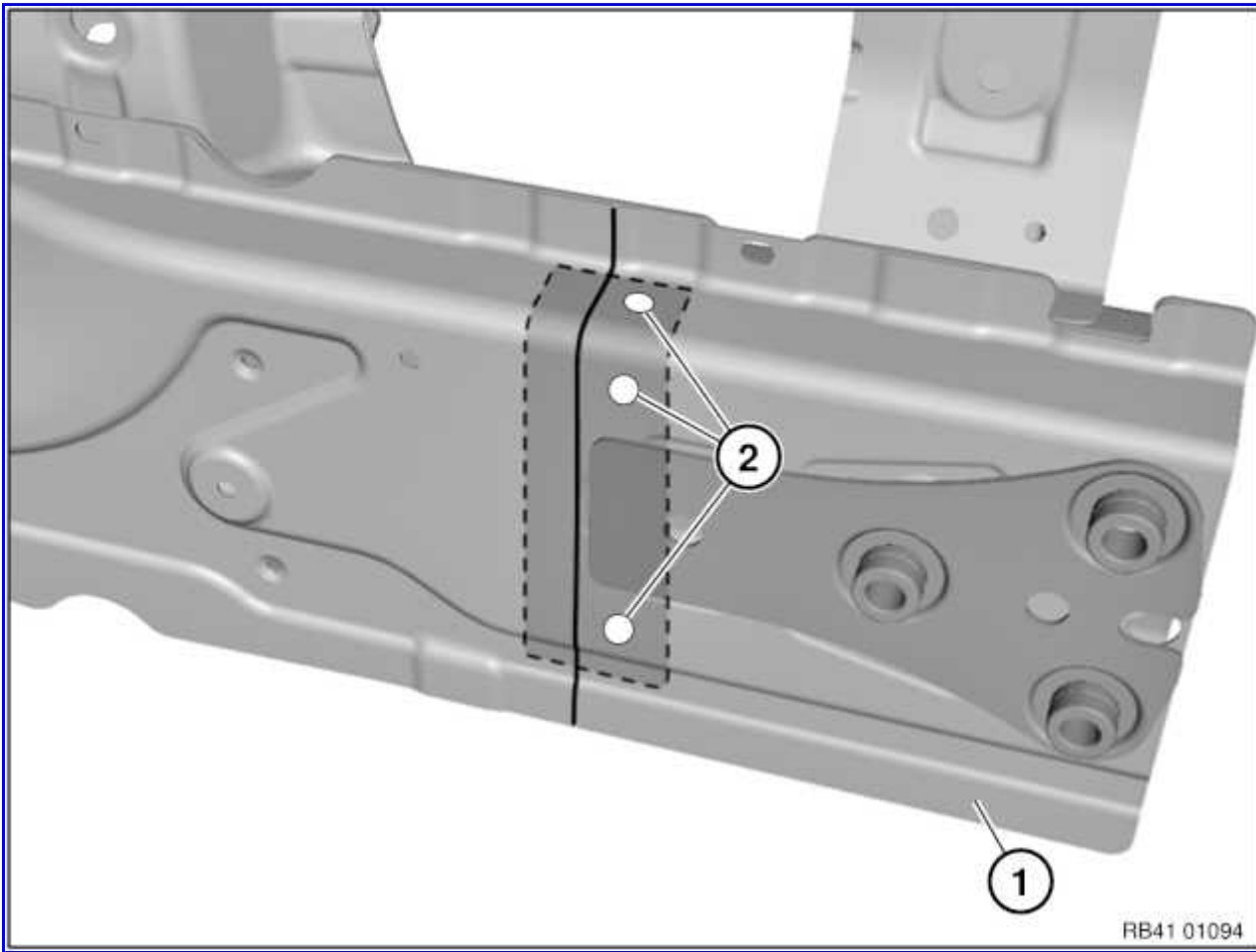
Reinforcement plate (2) must be adjusted in area of axle support (3).

Reinforcement plate is welded from inside to outside during installation.

Bore hole for welding the reinforcement plate from outside are therefore only required in the front area.

See graphic below.

Alignment bracket and carrier support not shown for purposes of clarity.



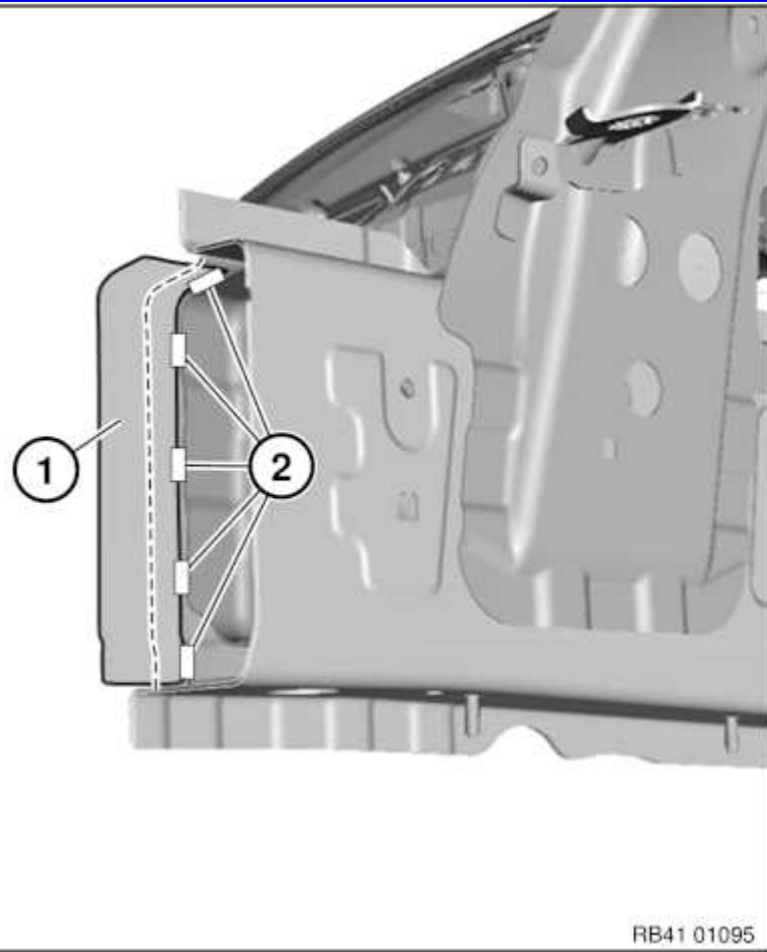
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In areas (2), set bore holes for plug welding.

Remove engine support inner section (1).

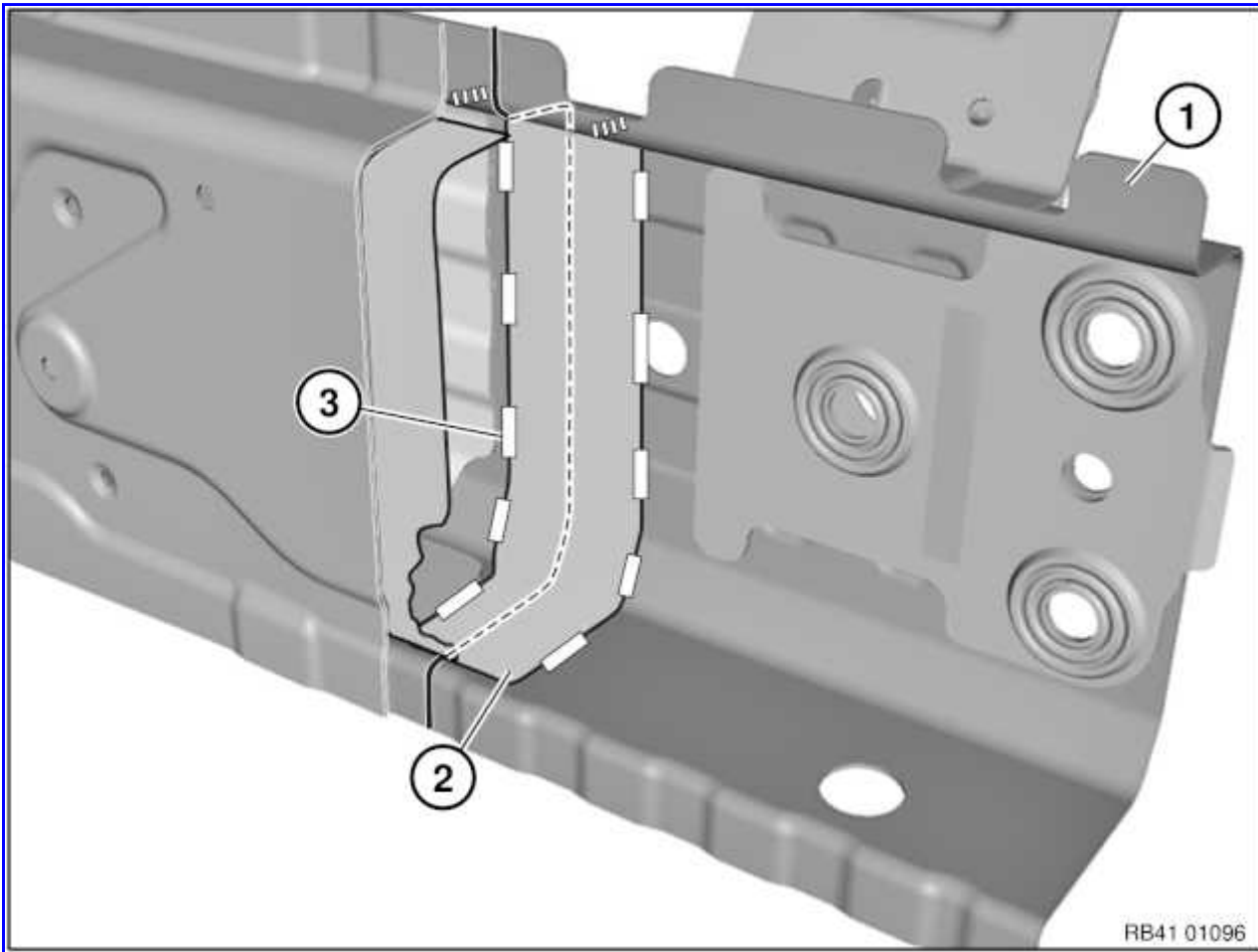


Installation



Install the reinforcement plate (1) for the engine support inner section and weld to the axle support. For this purpose, in areas (2) set MAG weld seams with a length of 10 - 15 mm.

Note:
Alignment bracket and engine support inner section not shown for purposes of clarity.

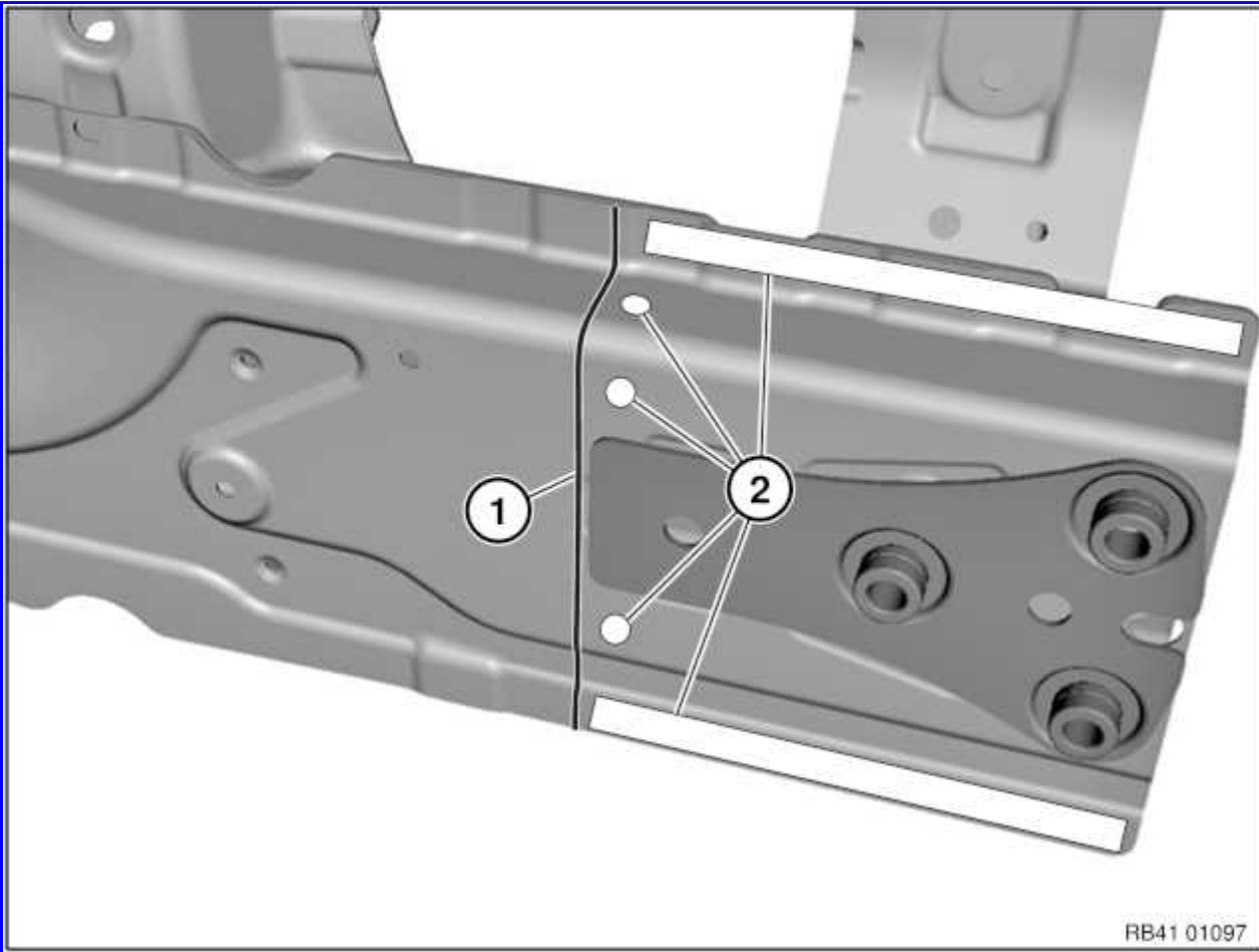


Install engine support outer section (1) and reinforcement plate (2) with alignment bracket or universal fixture and weld.

For this purpose, in areas (3) set MAG weld seams with a length of 10 - 15 mm.

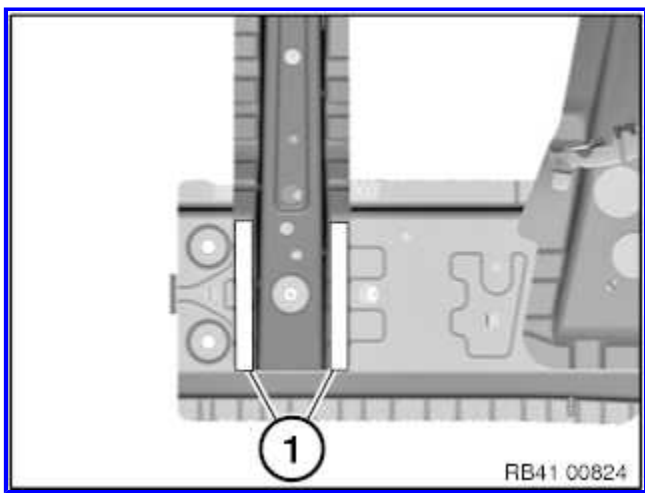
Note:

Alignment bracket not shown for purposes of clarity.



Install engine support inner section with alignment bracket or universal fixture and weld in areas (1) and (2).

Note:
Alignment bracket not shown for purposes of clarity.



In areas (1) weld new part.

Weld new part in area (1).

