

41 11 071**Replacing engine support with front left wheel arch in front of bulkhead**

Note the special vehicle identification number procedure when replacing the front right wheel arch (order the new body part with the vehicle identification number, if necessary)!



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

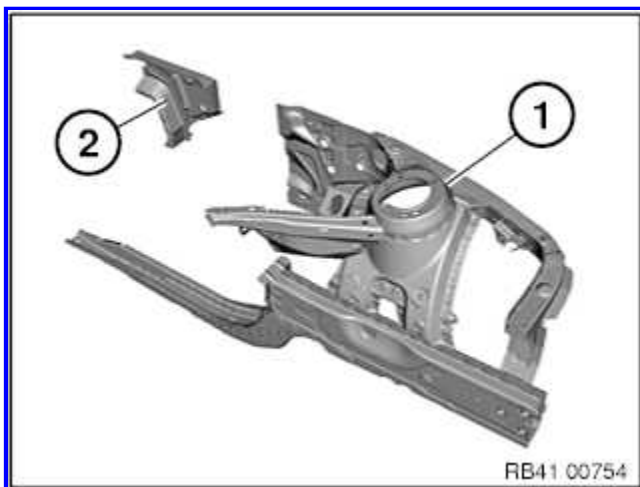
Read contents of [Body, General](#).

For stripping and rigging operations, refer to texts on KSD CD (job number 41 11 071).

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) Wheel arch, front
- (2) Extension, wheel arch carrier support
- (3) Shaped part, wheel arch carrier support (not shown)

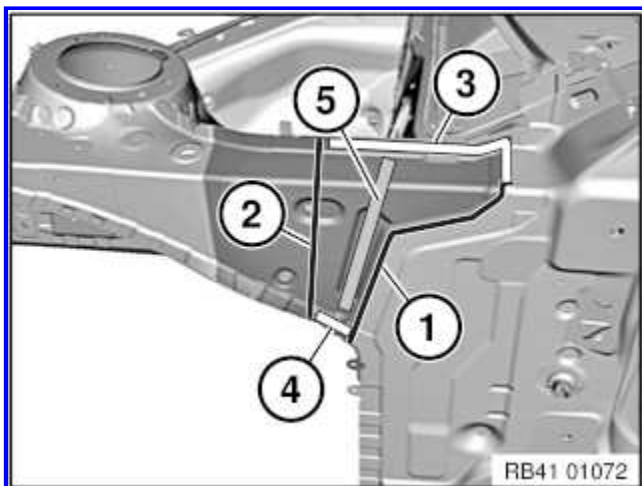
Following [consumables](#) are required:

Material	Quantity
Adhesive K1	1
Blind rivets N7	9

Blind rivets N3	5
Punch rivets N5	12
Sealant D1	
Cleaning agent R1	1



Removal of engine support with wheel arch



Mark severance cut (1) at component edge and cut.

Mark severance cut (2) as pictured and cut.

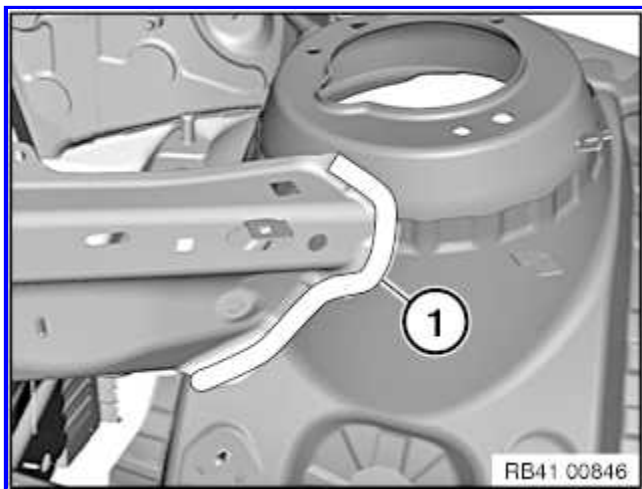
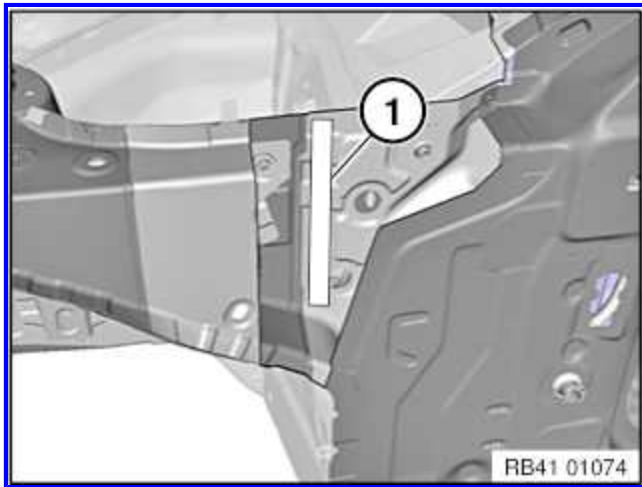
[Loosen](#) spot-welded adhesive joints in area (3).

Open welded connections in area (4).

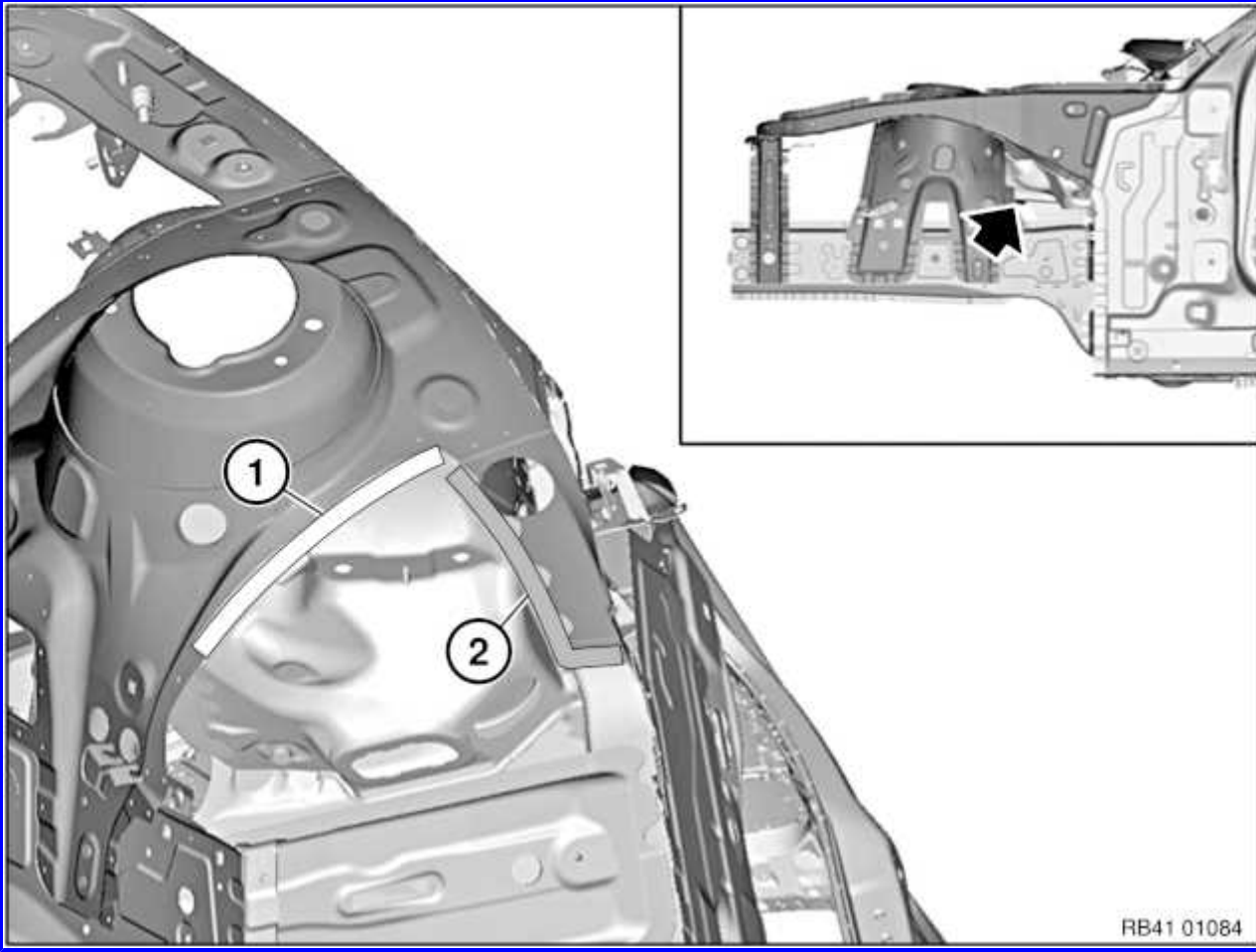
Release metal section from cavity sealing (5) and remove.

Remove cavity sealing (5).

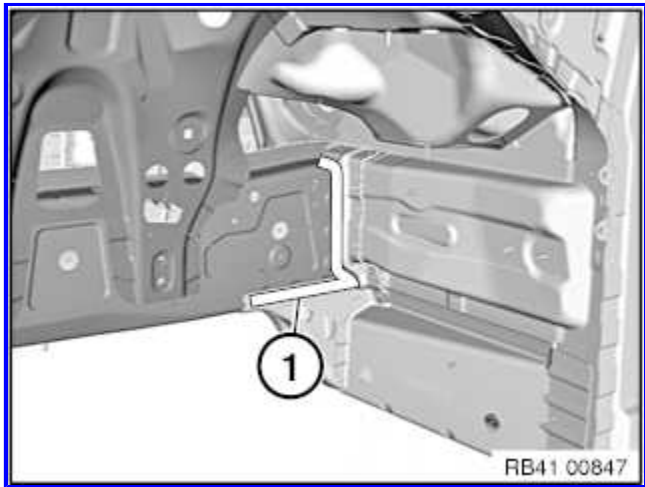
Open welded connections in area (1).



Open welded connections in area (1).

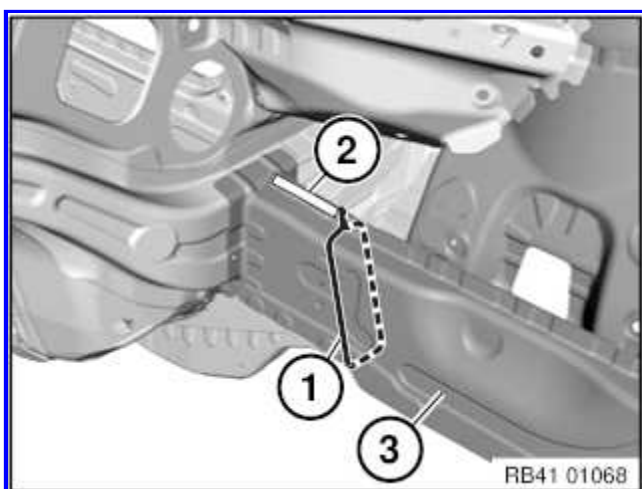
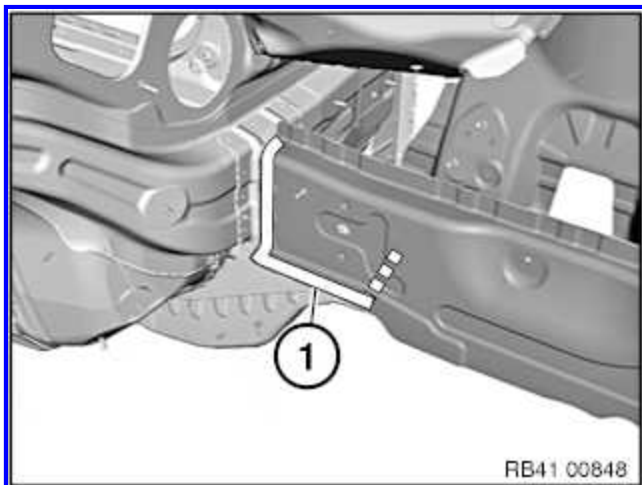


Open welded connections in areas (1) and (2).



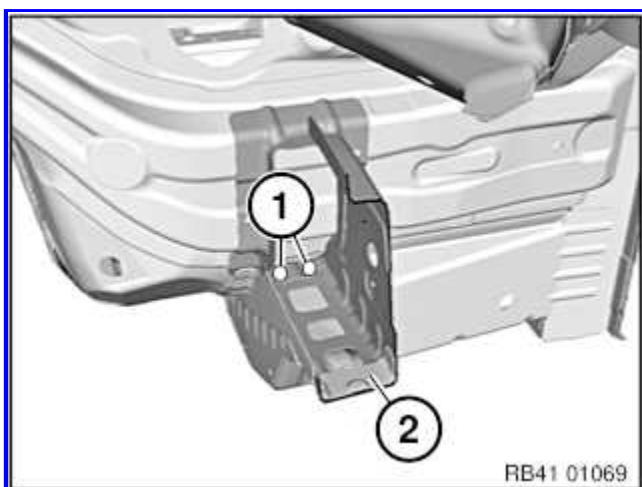
Open welded connections in area (1).

Open welded connections in area (1).



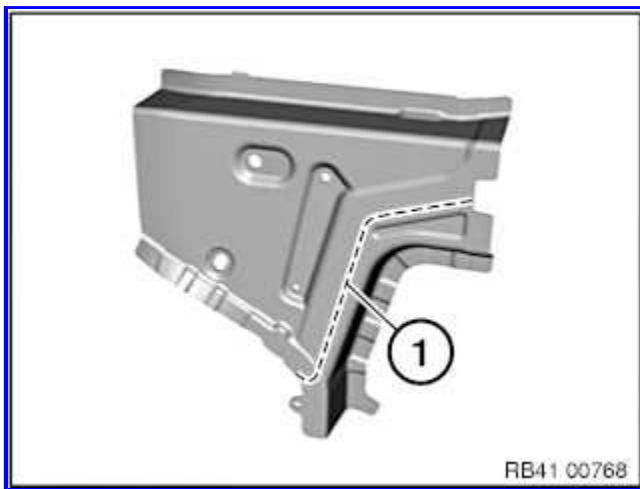
Mark severance cut (1) roughly as pictured and cut engine support.

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

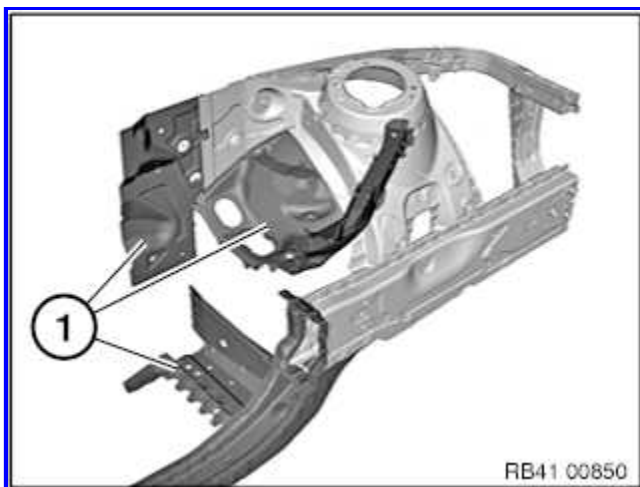


Open welded connections in areas (1) by grinding and remove residual section of engine support (2).

New part preparation



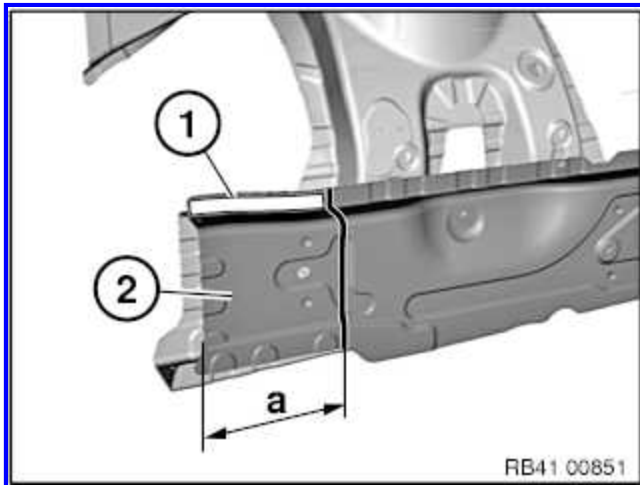
Mark and disconnect severance cut on the new part according to the severance cut on the vehicle + 20 mm added material (1).



Release welded connections and remove non-required components (1) from new part.

Mark severance cut in accordance with dimension and cut.
Measurement a = approx. 145 mm from component edge.
Cut outer metal panel only.
Open welded connections in area (1).
Remove metal section (2).

Note:

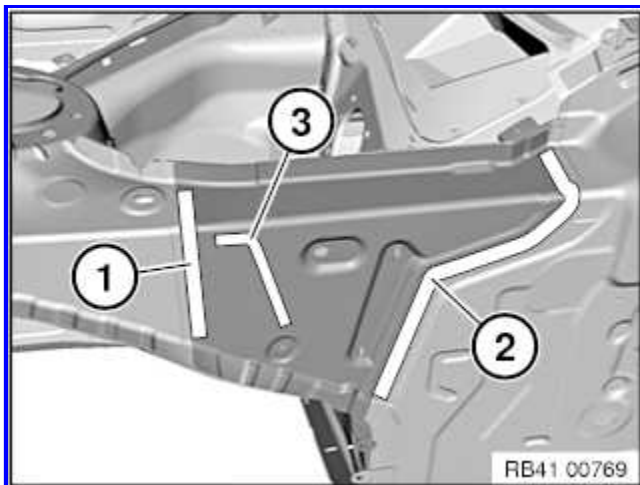


The metal section (2) is needed to close the engine support.

Prepare [reinforcement plate](#) at severance cut.



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



Adjust extension, wheel arch carrier support new part to fit and secure.

In areas (1) and (2), set dia. 6.8 mm bore holes for blind rivets.

Area	Number
1	3
2	5

In area (3), set 4 dia. 4.2 mm bore holes for blind rivets N3 .

Remove new parts and deburr bore holes.

Important!

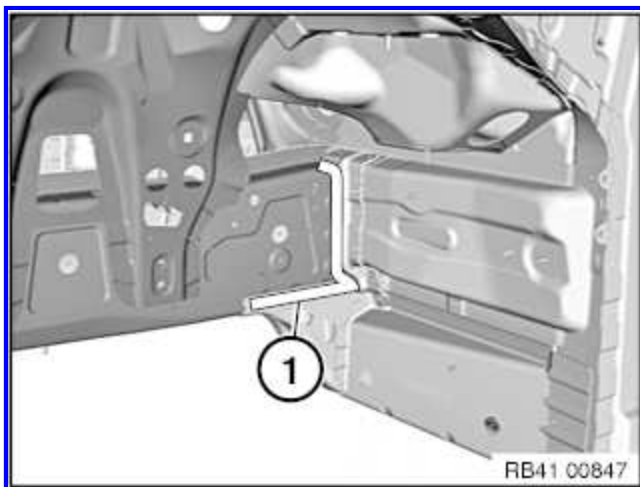
Structure bonding!

[Observe](#) preparation of bonding surfaces.



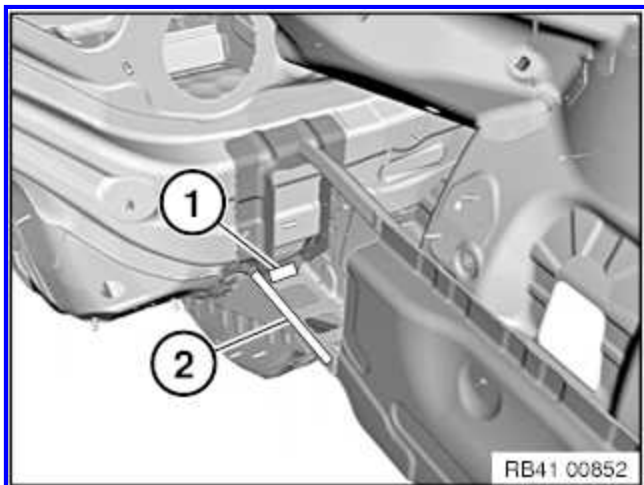
Installation of engine support with wheel arch

Install new front wheel arch and reinforcement plate with alignment bracket or universal mount.



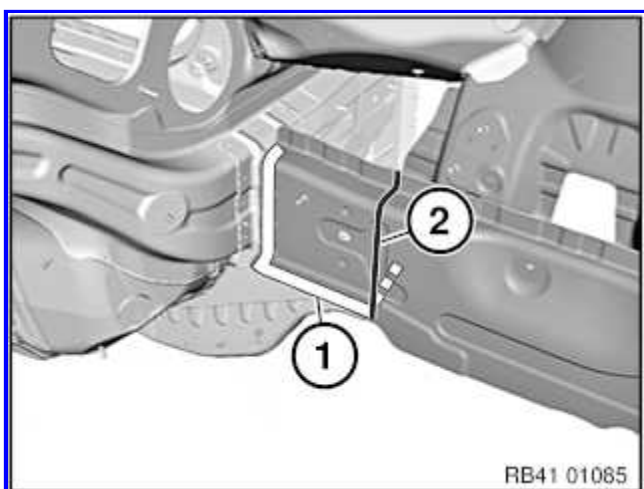
Weld new part in area (1).

Weld new part in the areas (1) and (2).

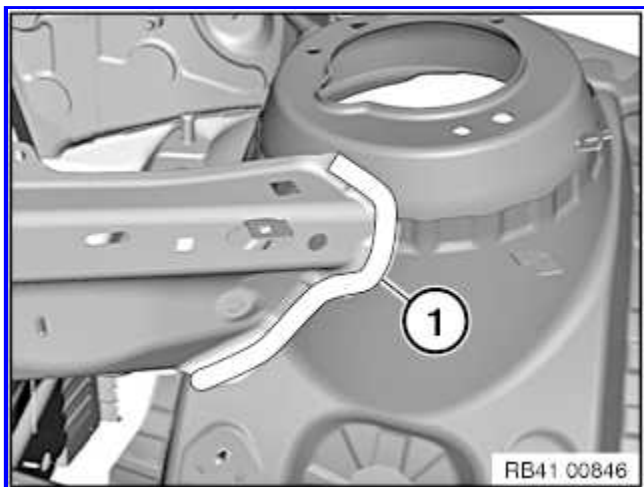


Weld new part in area (1).

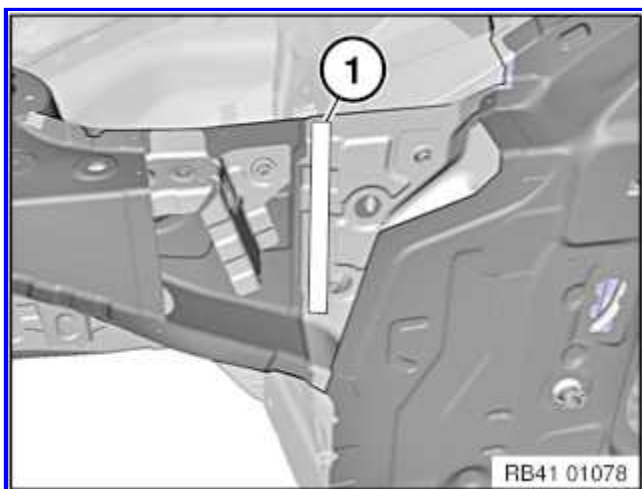
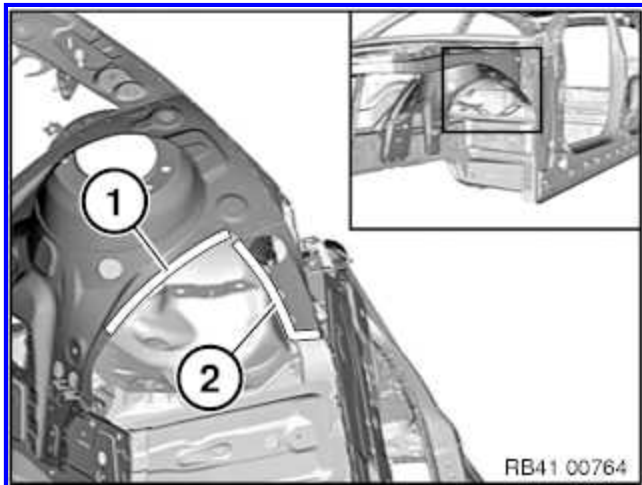
Weld severance cut (2) and reinforcement plate.



Weld new part in area (1).



Weld new part in the areas (1) and (2).



Weld new part in area (1).



Installation of extension, wheel arch carrier support

Clean bonding surfaces with cleaning agent R1.

Apply adhesive to bonding surfaces.

Apply sealant to [cavity sealing](#).

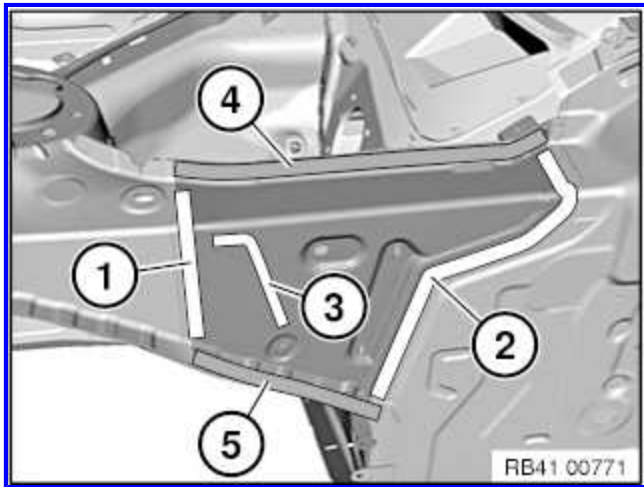
Install extension, wheel arch carrier support.

In areas (1) and (2), rivet new part with blind rivets N7.

In area (3) rivet new part with blind rivets N3.

In areas (4) and (5), rivet new part with punch rivets N5.

Area	Number



4	6
5	5