

41 14 020**Replacing front left wheel arch**

When replacing front right wheel arch: observe specific procedure regarding the vehicle identification number. (order new body part with vehicle identification number if necessary)



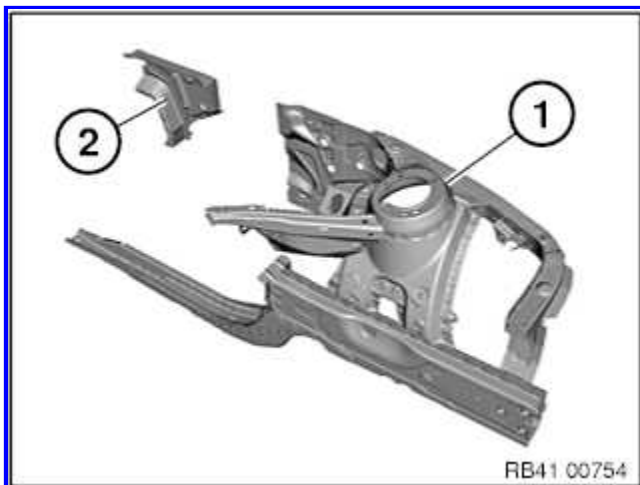
Observe procedure of [repair stage 3](#).

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

[Strip down](#) vehicle.

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)

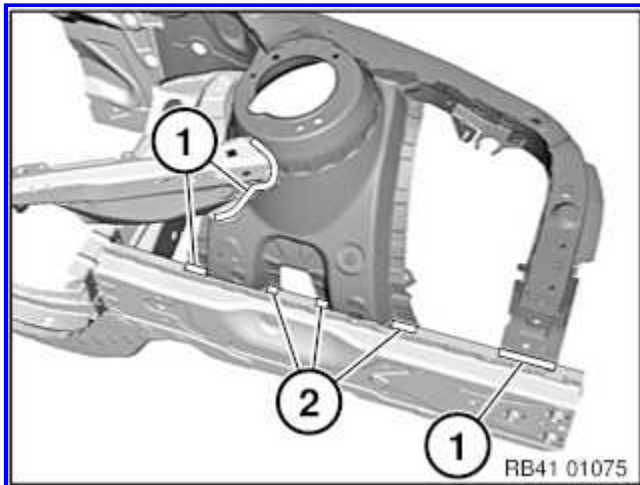
Following [consumables](#) are required:

Material	Quantity
Adhesive K1	1
Blind rivet N1	8

Blind rivet N7	29
Blind rivet N3	5
Punch rivets N5	12
Sealant D1	
Cleaning agent R1	1



New part preparation



Open welded connections in areas (1).

Centre punch the welded connections in area (2) in the middle and drill out with a drill diameter of 6.8 mm.

Note:

The new part is joined in areas (2) by adhesive riveting.

The bore holes in areas (2) are required for fitting the blind rivets.

The new part is joined the areas (1) by plug-welding.

Open welded connections in areas (1).

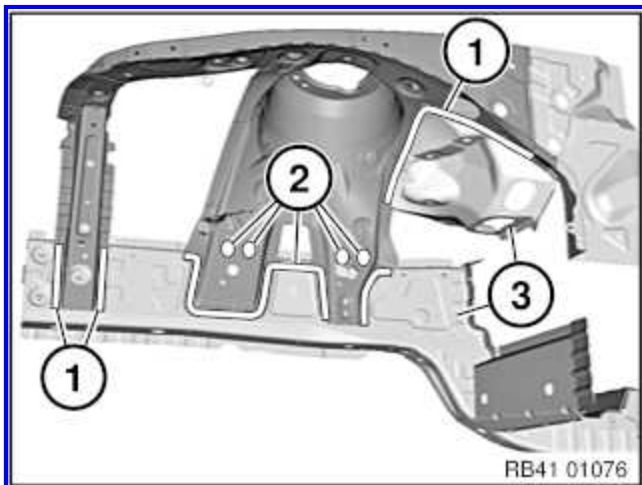
Centre punch the welded connections in area (2) in the middle and drill out with a drill diameter of 6.8 mm.

Remove components (3) which are not required.

Note:

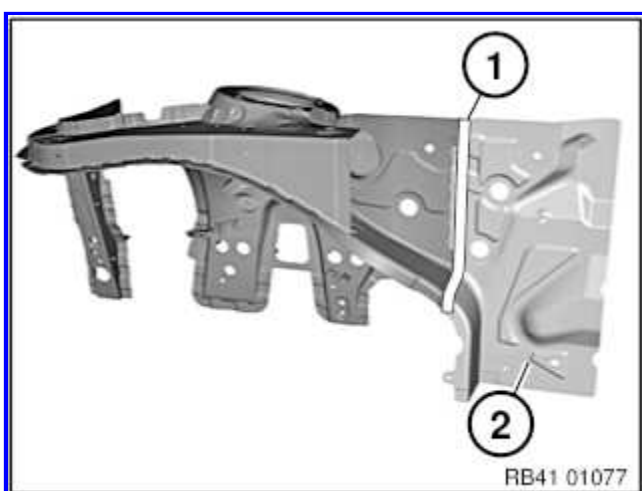
New part is attached in area (2) using adhesive riveting technology.

The bore holes in areas (2) are required for fitting the blind



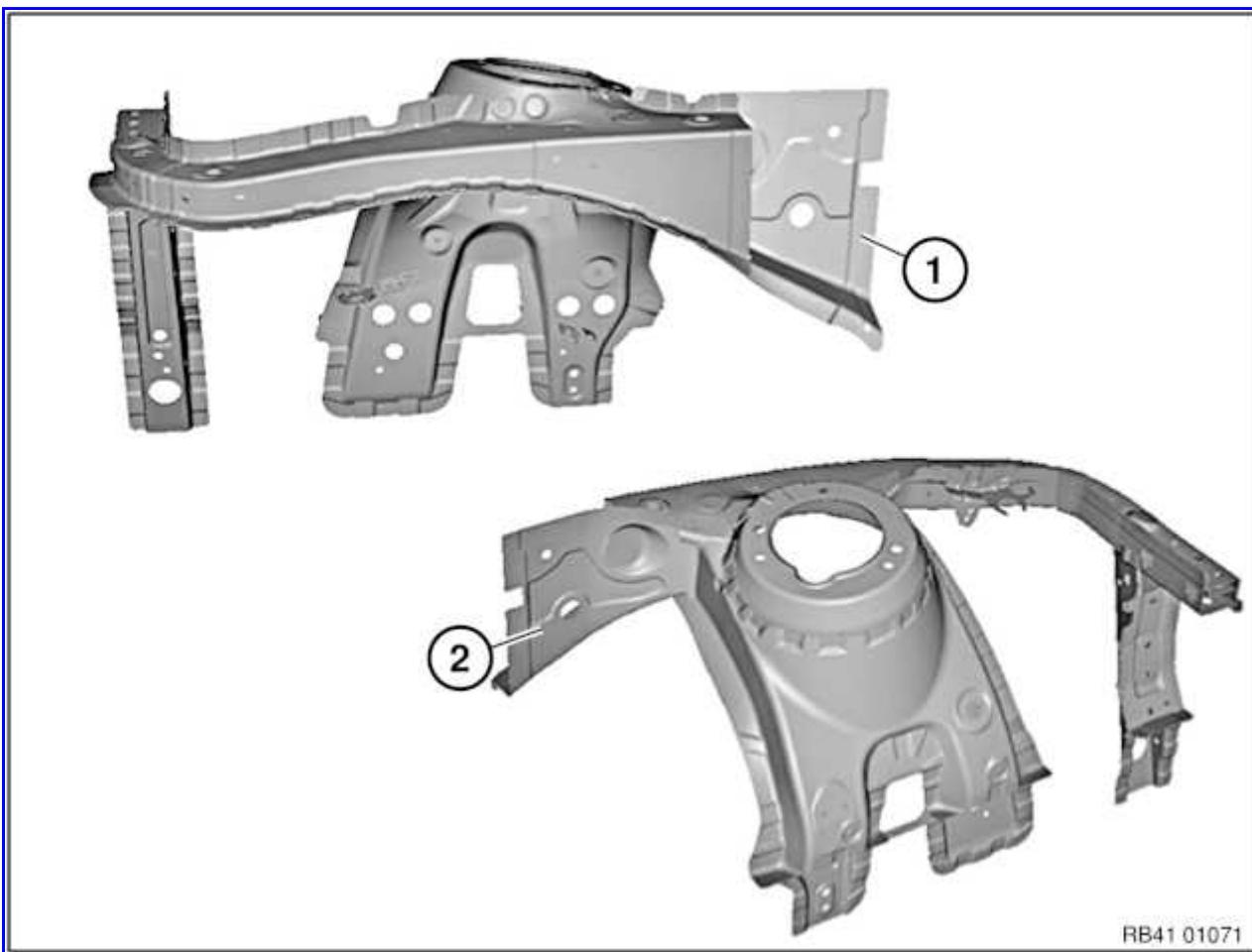
rivets.

The new part is joined the areas (1) by plug-welding.



Open welded connections in area (1).

Remove component (2) which is not required.



Views of the wheel arch (new part) to be fitted:

- (1) View from outside
- (2) View, engine compartment



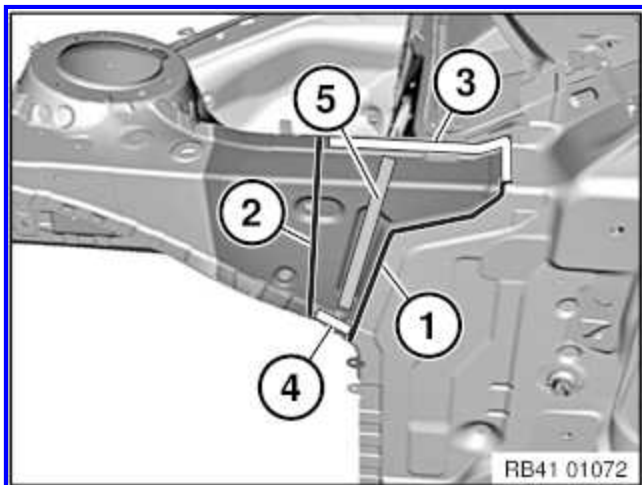
Removing the wheel arch

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

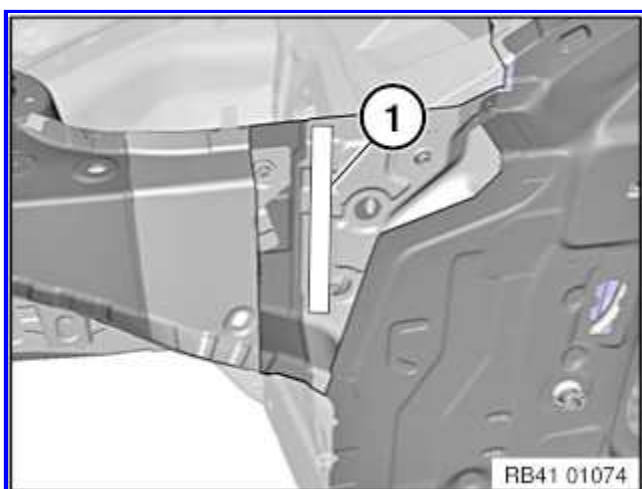
Mark severance cut (2) as pictured and cut.

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

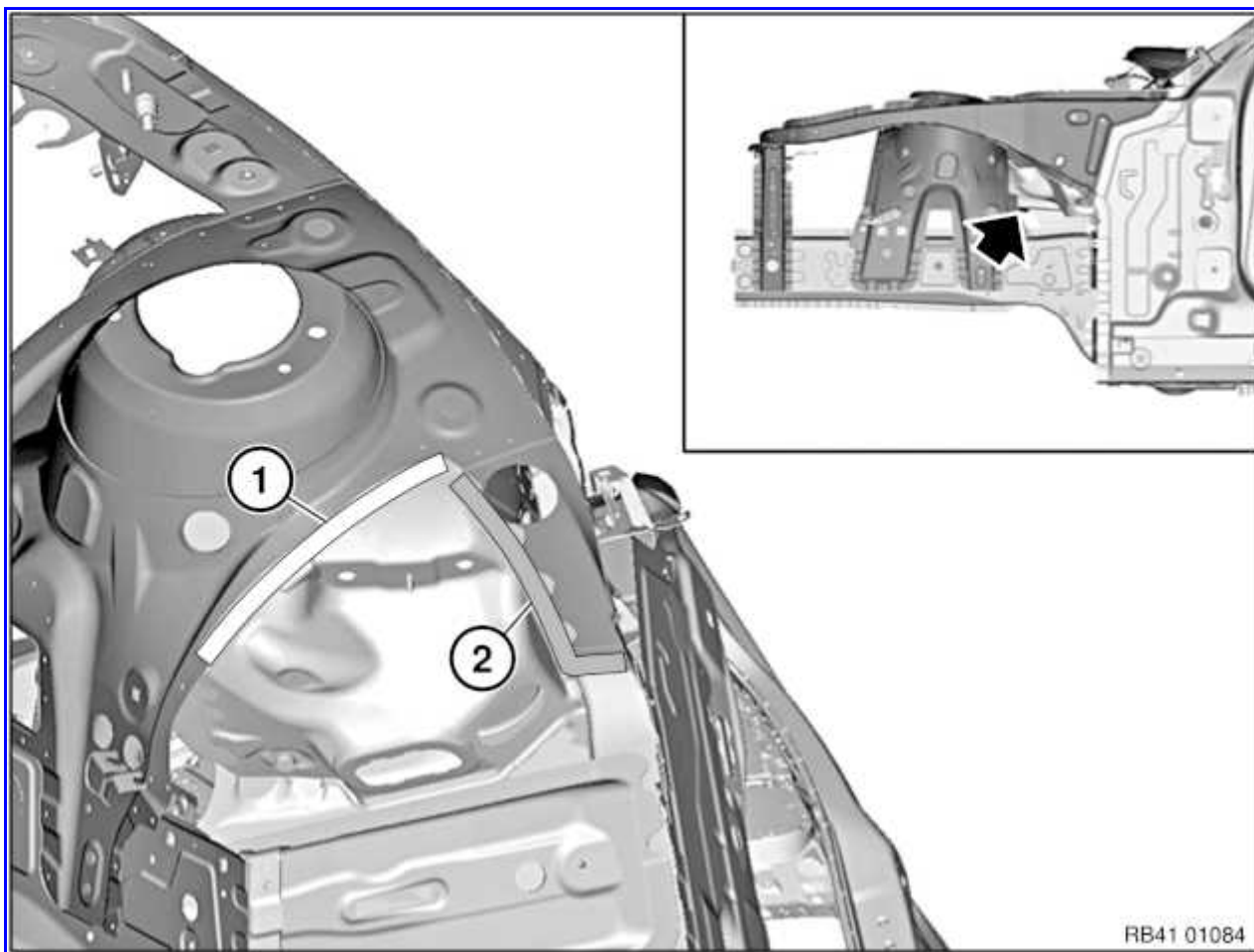
Open welded connections in area (4).



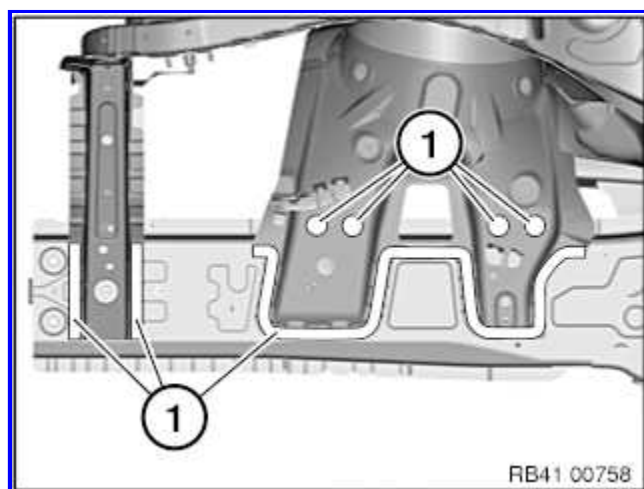
Release metal section from cavity sealing (5) and remove.
Remove cavity sealing (5).



Open welded connections in area (1).



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



Open welded connections in areas (1).

Note:

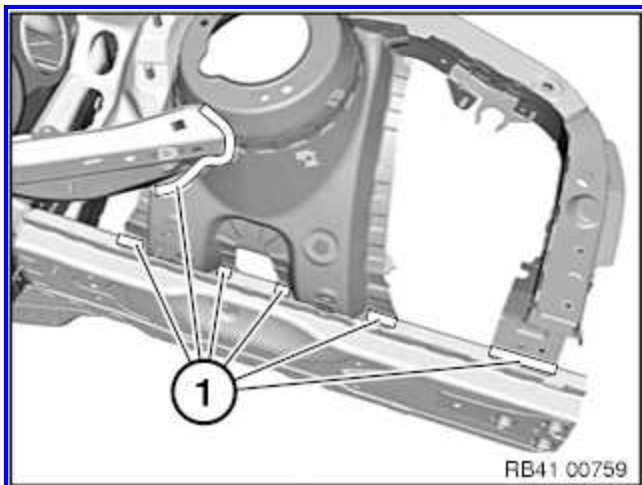
Do not drill into or through the engine support when releasing the welded connections!

Open welded connections in areas (1).

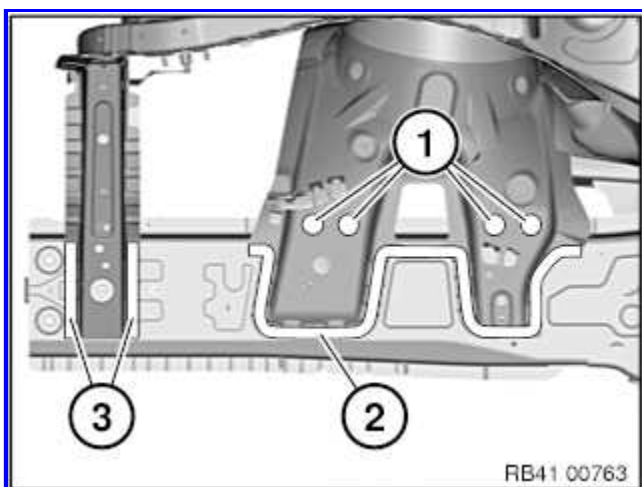
Remove the wheel arch.

Note:

Do not drill into or through the engine support when releasing the welded connections!



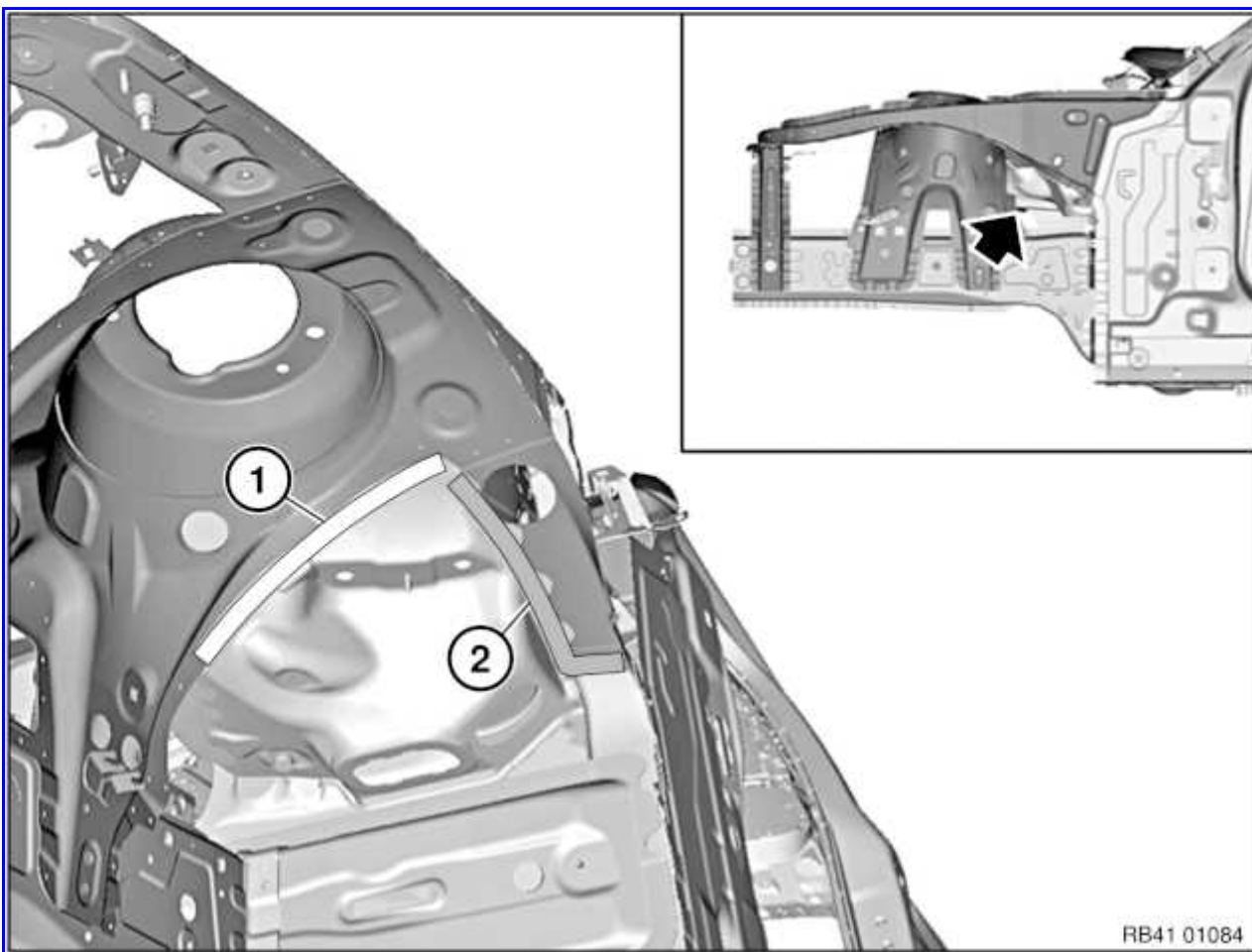
Fit in new part



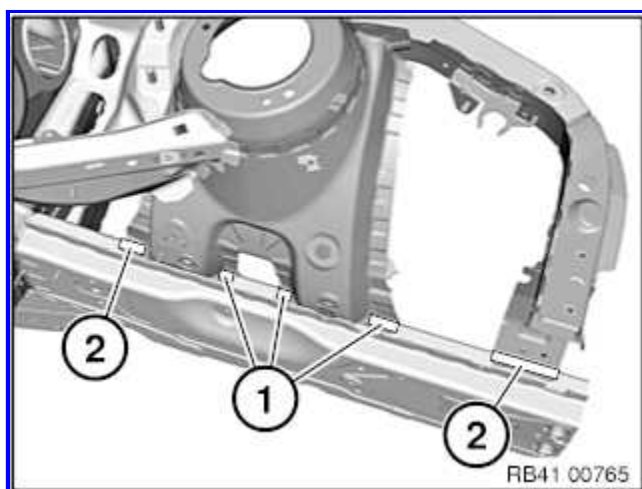
Adjust wheel arch new part to fit with alignment bracket or universal mount and secure.

Areas (1) and (2): Transfer existing 6.8 mm diameter bore holes for blind rivets to engine support.

In areas (3), prepare new part and vehicle for plug-welding.



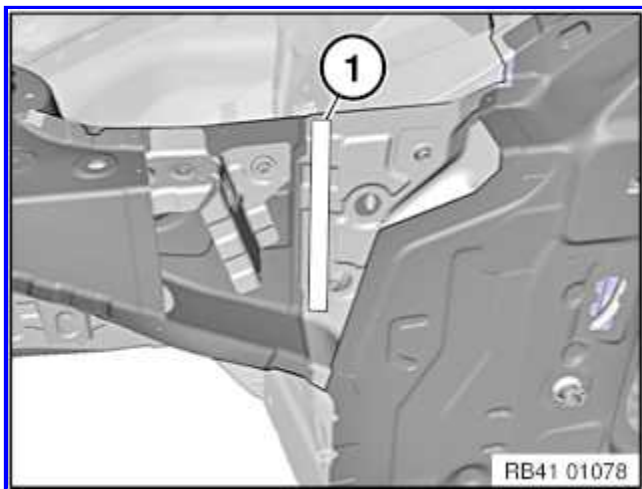
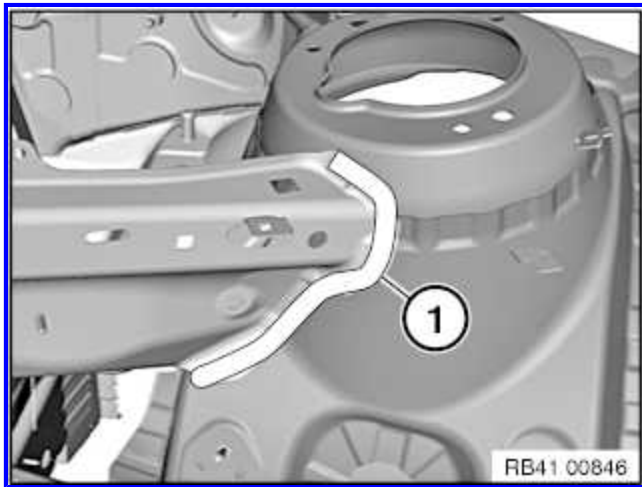
In areas (1) and (2), prepare new part and vehicle for plug-welding.



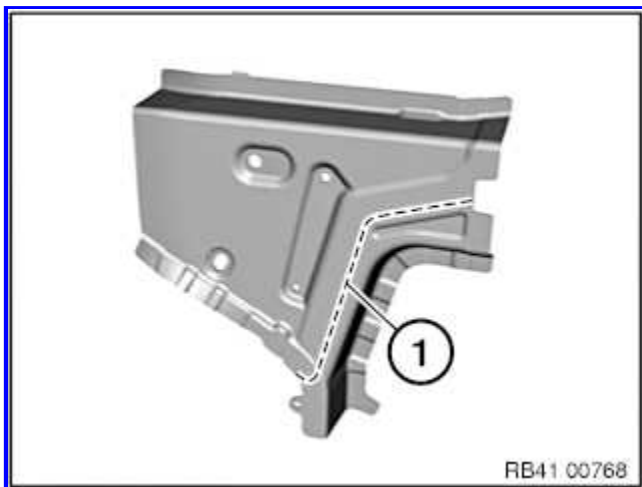
Areas (1): Transfer existing 6.8 mm diameter bore holes for blind rivets to engine support.

In areas (2), prepare new part and vehicle for plug-welding.

In area (1), prepare new part and vehicle for plug welding.



In area (1), prepare new part and vehicle for plug welding.

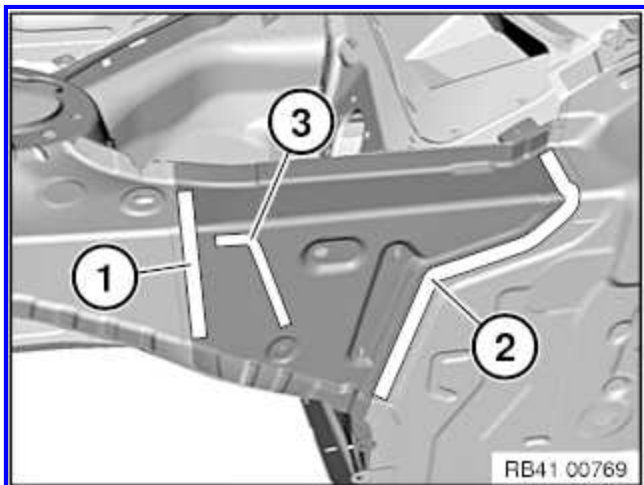


Mark and disconnect severance cut on the new part according to the severance cut on the vehicle + 20 mm added material (1).

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

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

Area	Number



1	3
2	5

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

Remove new parts and deburr bore holes.



Important!

Structure bonding!

Observe preparation of bonding surfaces.



Installing new part, front wheel arch

Clean bonding surfaces with cleaning agent R1.

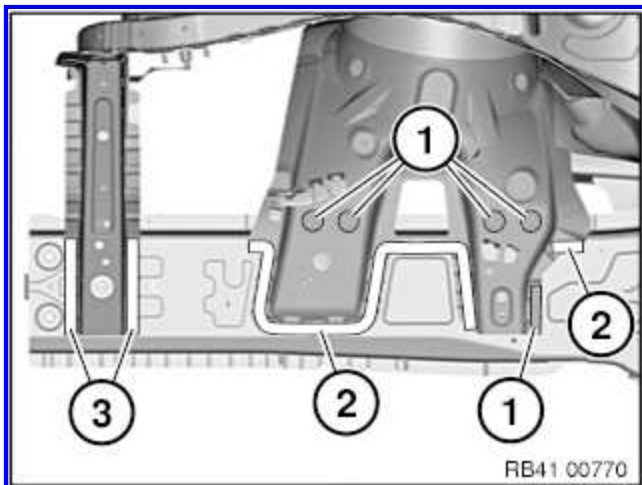
Apply adhesive to bonding surfaces.

Install wheel arch with alignment bracket or universal mount.

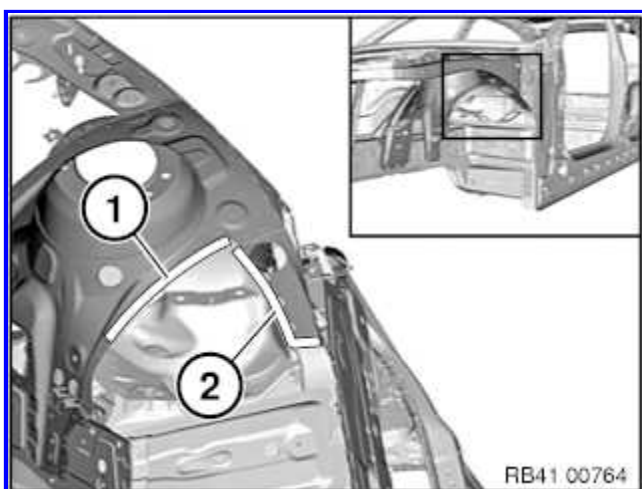
In areas (1), rivet new part with blind rivets N1.

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

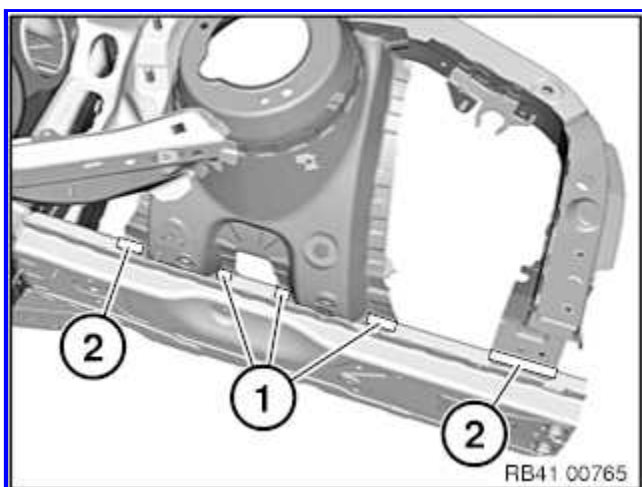
In areas (3) weld new part.



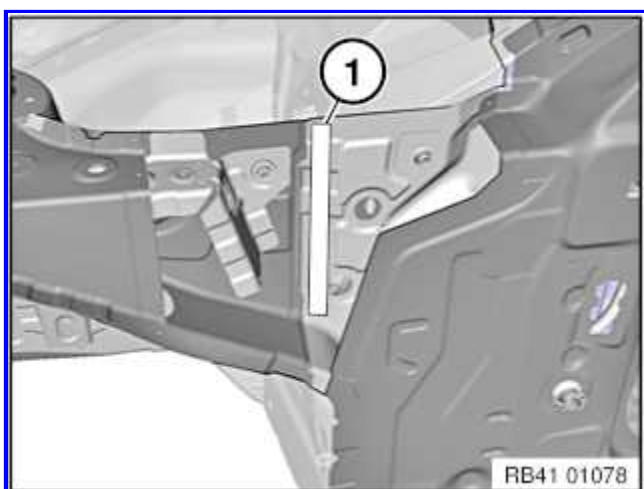
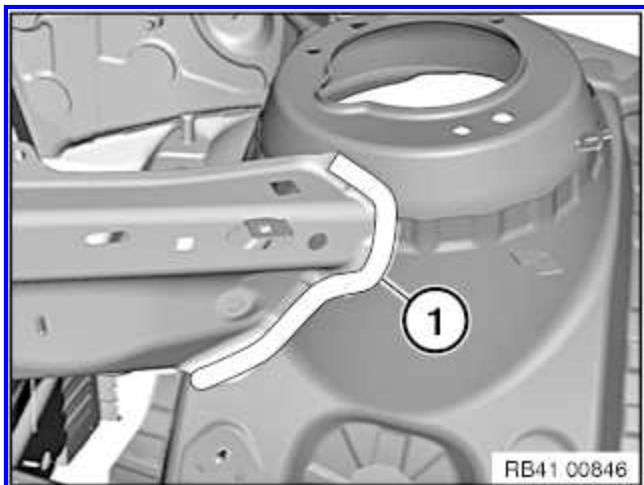
In areas (1) and (2), weld new part.



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



Weld new part in area (1).



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 cavity sealing.

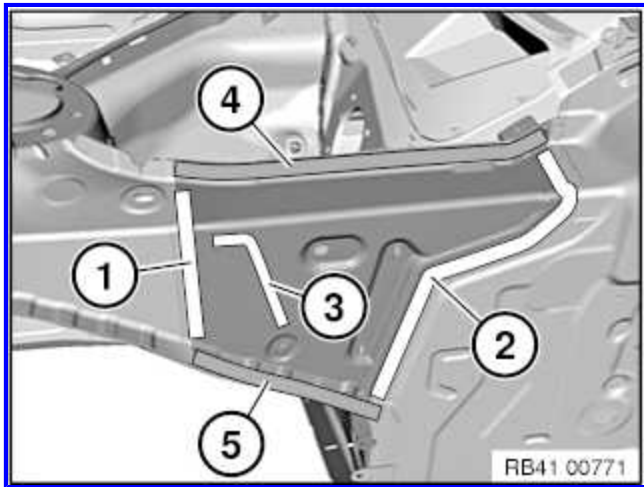
Install extension, wheel arch carrier support.

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