

41 12 700**Replacing luggage compartment floor and side member on left (left side wall and tail panel removed)**

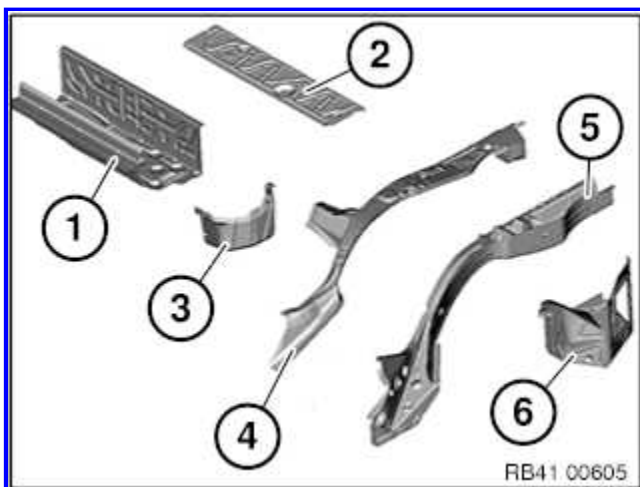
Read contents of [Body, General](#).

[Strip down vehicle](#)

Place vehicle on straightening bench.



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



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

- (1) Luggage compartment well
- (2) Luggage compartment floor, rear
- (3) Luggage compartment well, left
- (4) Frame side member, top left
- (5) Side member, bottom left
- (6) Luggage compartment floor, left section

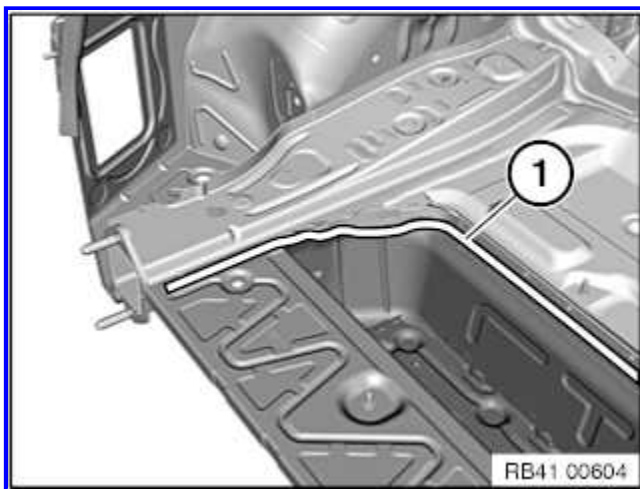
Following [consumables](#) are required:

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Material	Quantity
Adhesive K5a	2
Blind rivet N3	17
Blind rivet N6	6
EMC screws	7
Cleaning agent R1	1
Sealant D1	

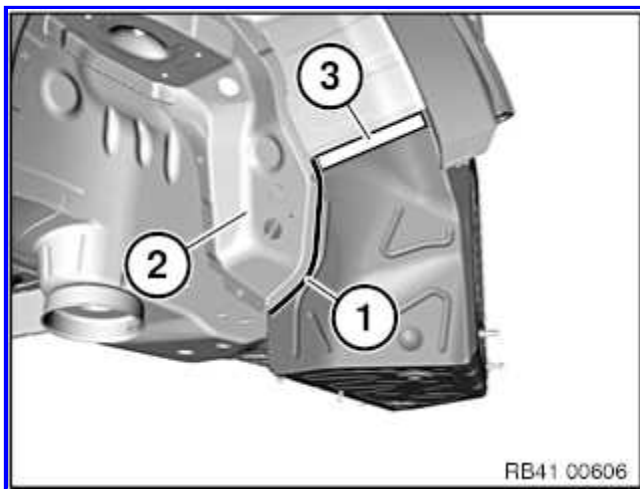
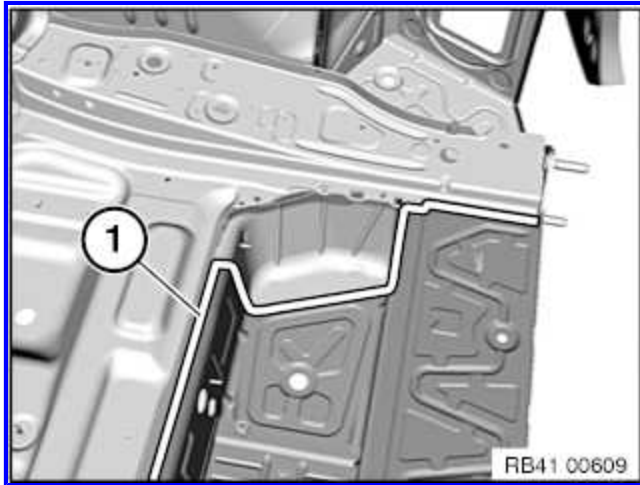


Removal of side member and luggage compartment floor:



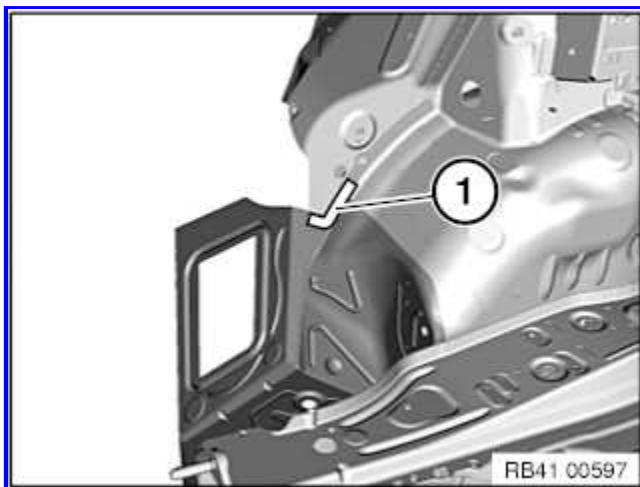
Open welded connections in area (1).

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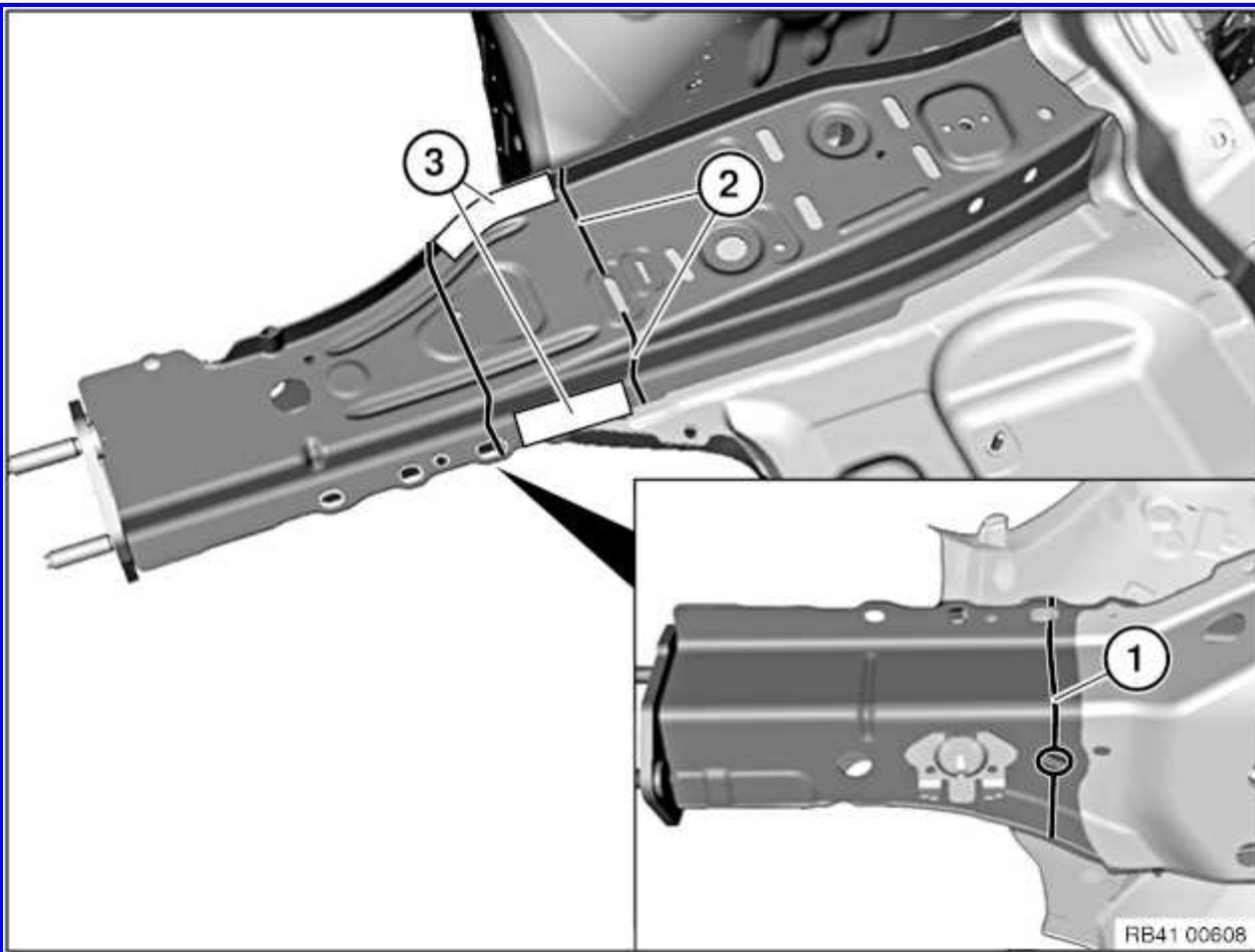
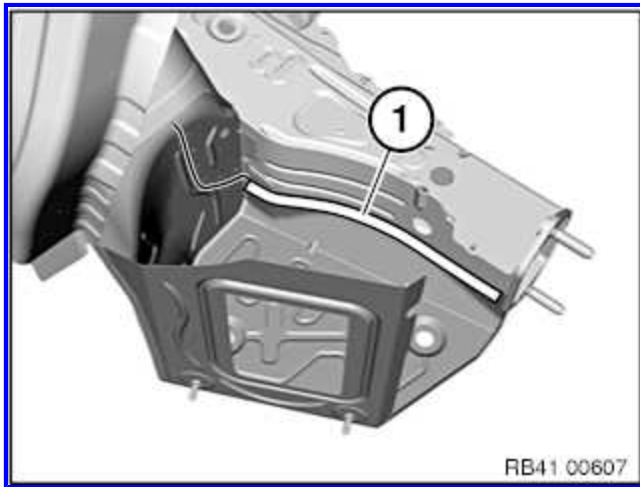
Mark severance cut (1) next to reinforcement (2) and disconnect.

Open welded connections in area (3).



Open welded connections in area (1).

Open welded connections in area (1).
Remove the luggage compartment floor.



Mark and cut severance cut (1) through Ø 20 mm hole.

Cut side member.

Mark severance cut (2) through elongated hole for MAG weld seam and cut.

Important!

Cut outer panel only.

Open welded connections in areas (3).

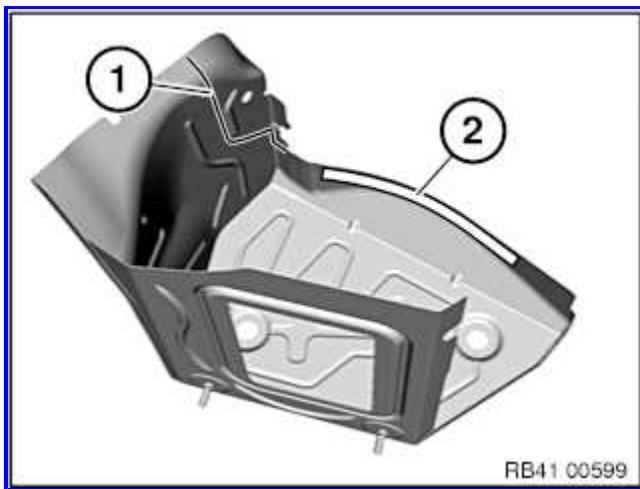
Remove side member.



Mark severance cuts on side members in accordance with severance cuts on vehicle and cut.

Loosen component not required (cross member) from luggage compartment well.

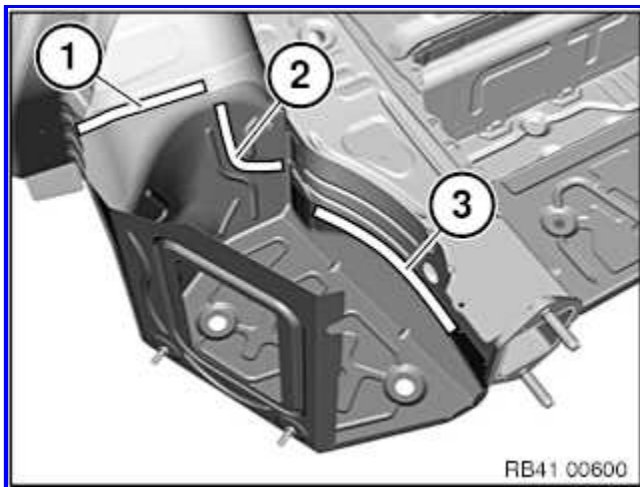
For all severance cuts on side members, prepare [reinforcement plates](#).



Mark severance cut at luggage compartment floor in accordance with severance cut on vehicle + 15 mm extra material and cut (1).

Create three 4.2 mm dia. bore holes in area (2).

Adjust new parts with alignment bracket or universal mount and in conjunction with side wall and tail panel and secure.



In areas (1) to (3), set $\varnothing$ 4.2 mm bore holes for blind rivets N3.

Area	Number
1	2
2	2
3	3

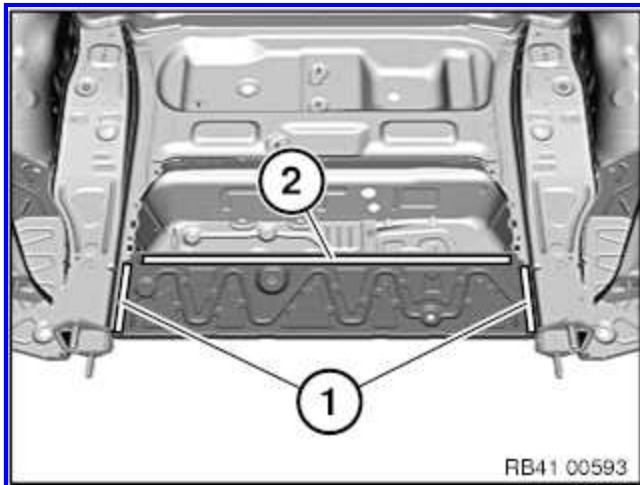
If necessary, mark bore holes in area (3) on body and create after removal of new part.

Note:

Side wall and tail panel have been hidden for clarity.

In areas (1) and (2), set $\varnothing$ 4.2 mm bore holes for blind rivets.





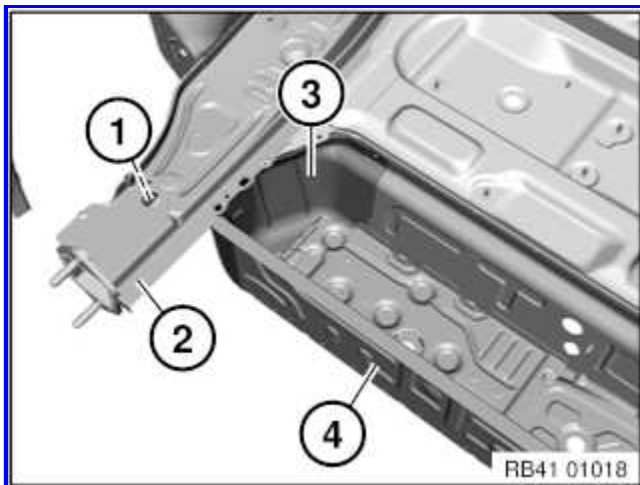
Area	Number	Rivet type
1	3 each	Blind rivet N6
2	7	Blind rivet N3

Remove new parts and deburr bore holes.



Important!

Do not grind new parts and body in area of bonding surfaces.



Installation of side member and luggage compartment well:

Install new parts and reinforcement plates with alignment bracket or universal mount and weld analogue to series standard:

- (1) Extension, bottom side member
- (2) Extension, top side member
- (3) Luggage compartment well, left
- (4) Luggage compartment well

Installation of rear luggage compartment floor and left luggage compartment floor:

Clean all bonding surfaces with cleaning agent R1.

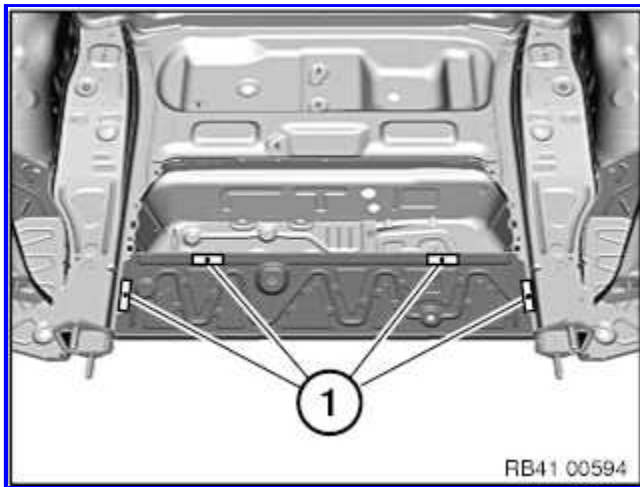
Apply adhesive to bonding surfaces.

Install new part and rivet with blind rivets .

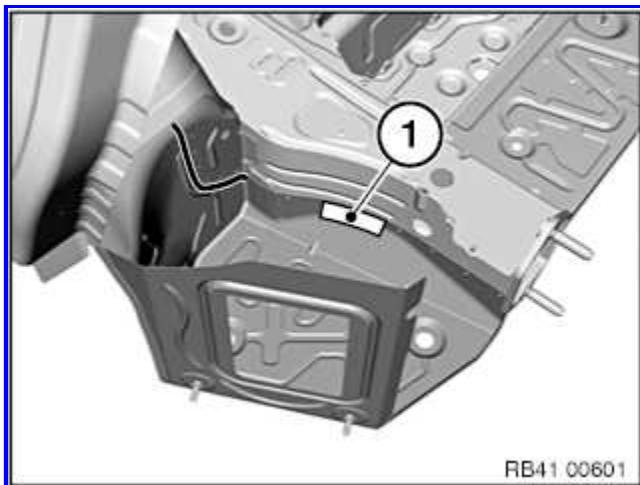
When installing the new part, make sure that all bonding



surfaces have sufficient adhesive.

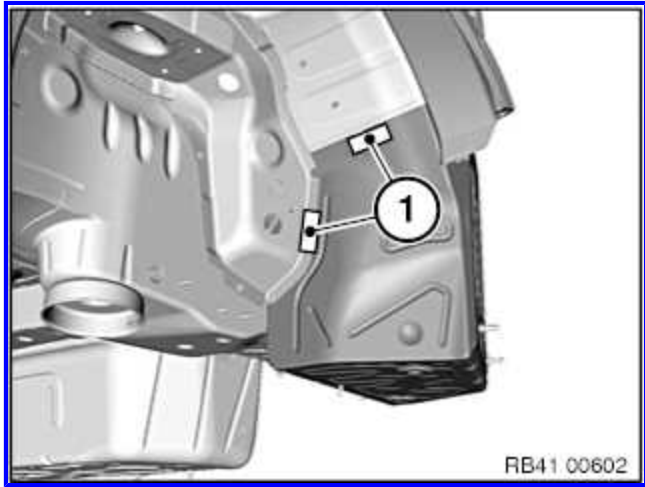


After hardening of the adhesive install [4 EMC screws](#) in the areas shown (1).



In area (1) install one EMC screw.

In area (1) install two EMC screws.



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