

41 12 653**Replacing luggage compartment floor,
left section (rear side panel and tail
panel removed)**

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

Procedure [Observe](#) repair stage 2!

[Strip down vehicle](#)



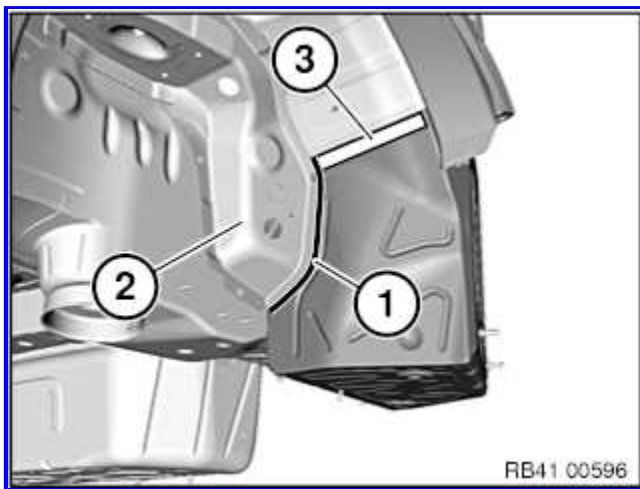
Following new body parts are required (refer to Electronic Parts Catalogue):

- (1) Luggage compartment floor, left section

Following [consumables](#) are required:

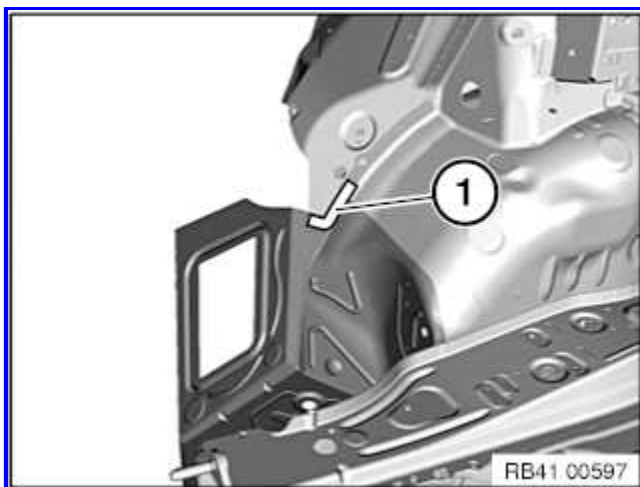
Material	Quantity
Adhesive K5a	1
Blind rivet N3	7
EMC screws	3
Cleaning agent R1	1
Sealant D1	

Removal of luggage compartment floor



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

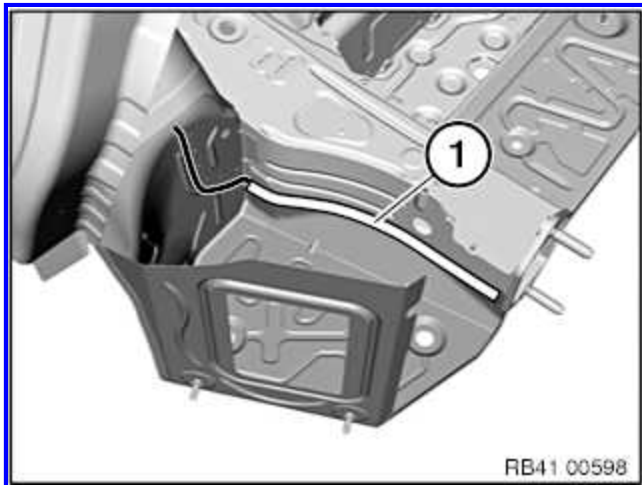
Open welded connections in area (3).



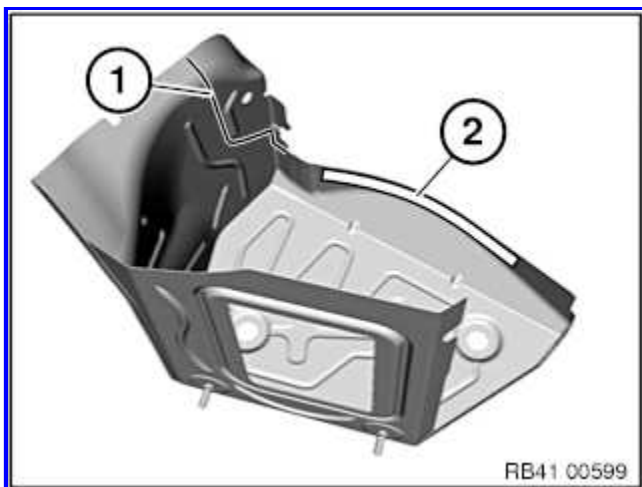
Open welded connections in area (1).

Open welded connections in area (1).

Remove the luggage compartment floor.



New part preparation



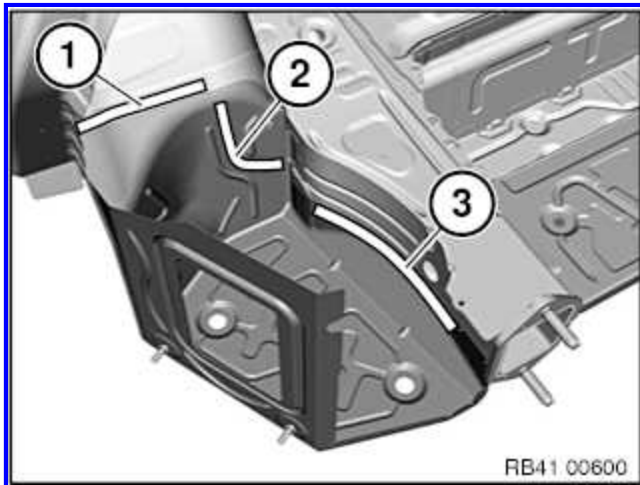
Mark severance cut at luggage compartment floor in accordance with severance cut on vehicle + 15 mm extra material and cut (1).

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

Adjust luggage compartment floor in combination with side panel and tail panel to fit and secure.

In areas (1) to (3), create 4.2 mm dia. bore holes.

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.

Remove new parts and deburr bore holes.

Note:

Side wall and tail panel have been hidden for clarity.



Important!

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



Installation of luggage compartment floor

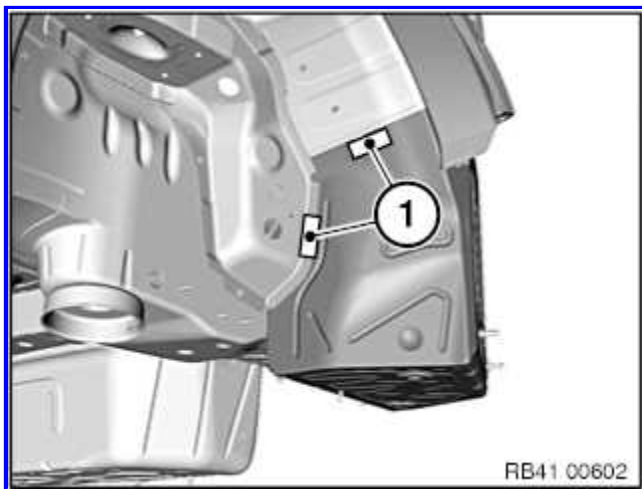
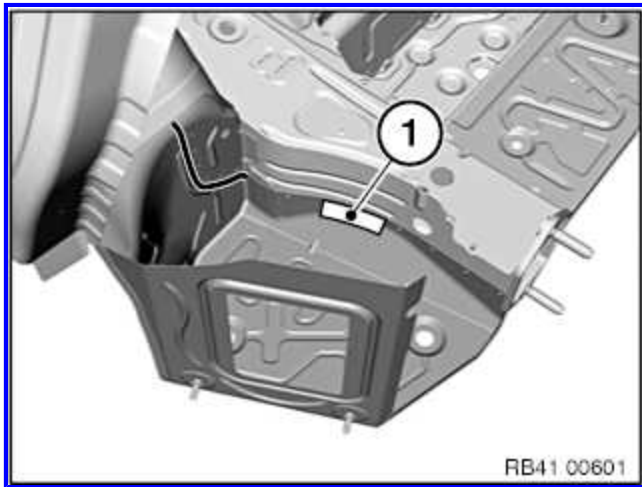
Clean all bonding surfaces on new part and on vehicle with cleaning agent R1.

Apply adhesive on all bonding and riveting surfaces.

Install new part and rivet with blind rivets .

When installing the new part, make sure that all bonding surfaces have sufficient adhesive.

Fit an [EMC screw](#) after adhesive has hardened in area (1).



In areas (2), use two EMC screws.