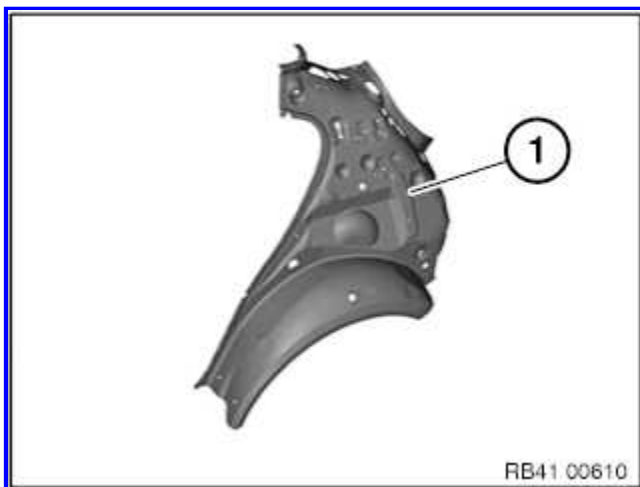


**41 14 505****Replacing rear left outer wheel arch section (rear side panel removed)**

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



Observe procedure for [\(repair stage 2\)](#)!



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

- (1) Outer wheel arch section, rear
- (2) Shaped part attachment, outer entrance (not shown)

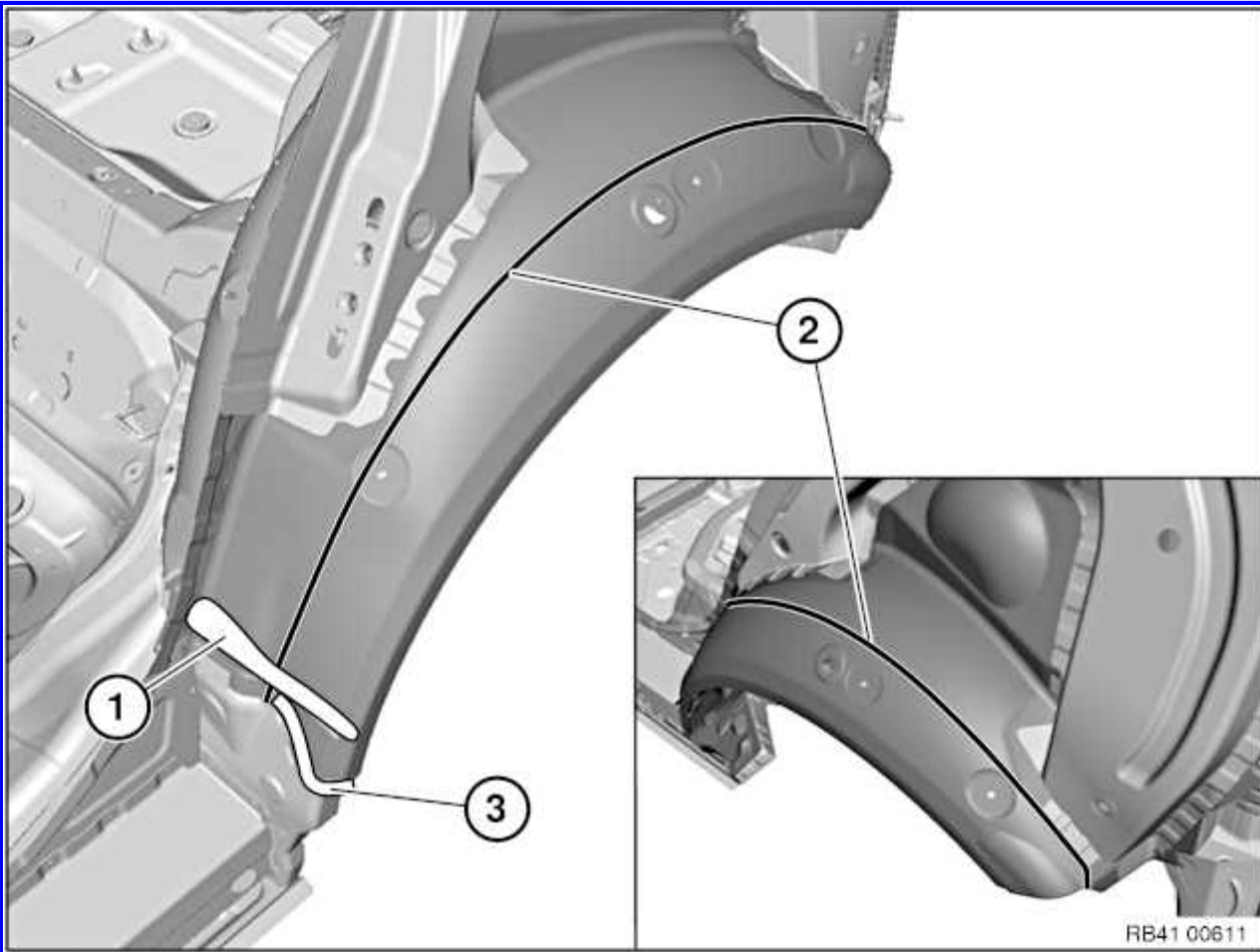
Following [consumables](#) are required:

| Material                   | Quantity |
|----------------------------|----------|
| Adhesive K5a               | 1        |
| Blind rivets N3            | 12       |
| Cleaning agent R1          | 1        |
| Cavity sealing wax remover | 1        |
|                            |          |

|            |  |
|------------|--|
| Sealant D1 |  |
|------------|--|



### Removal of outer wheel arch section



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Remove cavity sealing (1).

Mark severance cut (2) as pictured and cut.

Open welded connections in area (3).

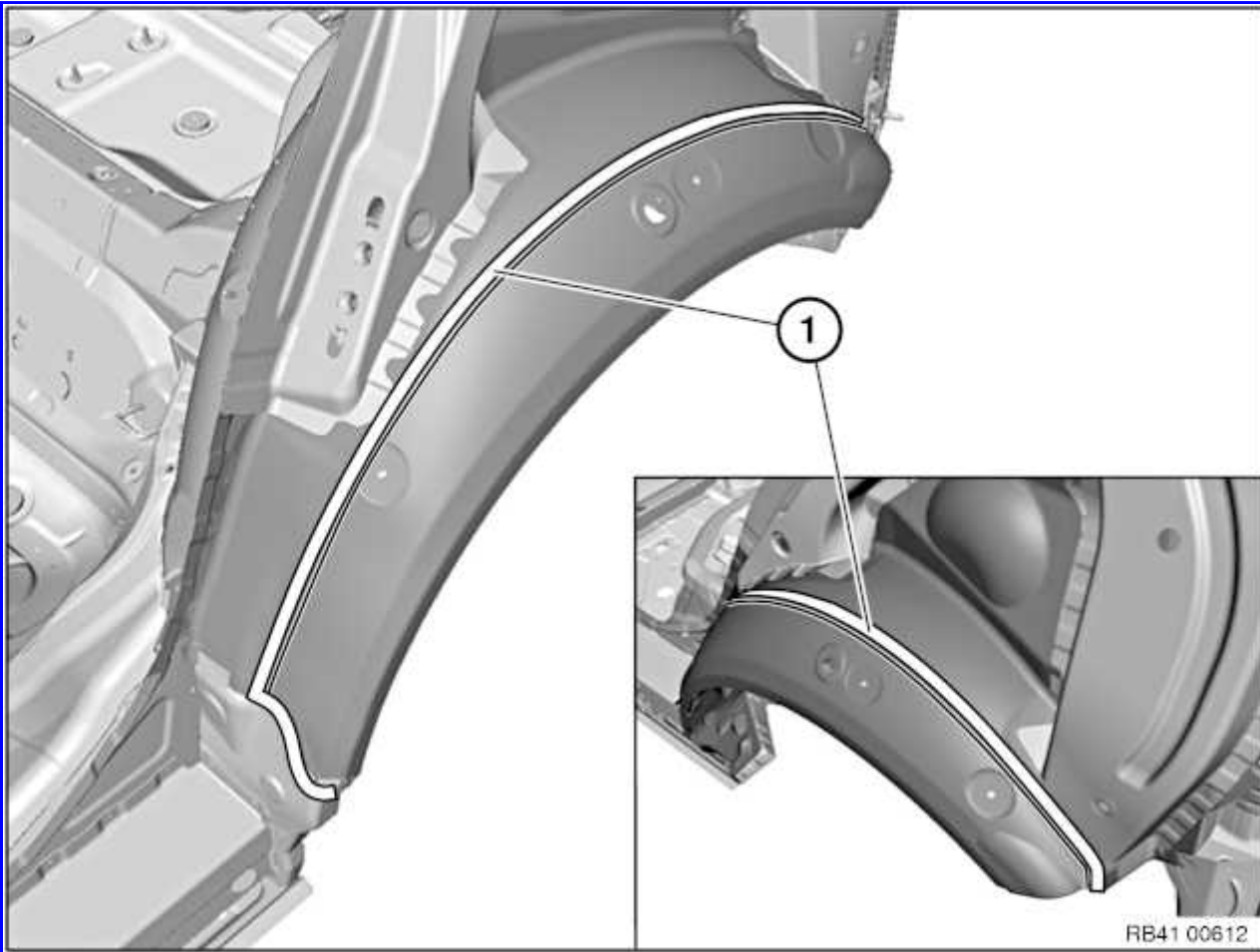
Remove part of the outer wheel arch section.

**Preparation of new part:**



Mark severance cut on new part according to severance cut on vehicle + 20 mm material extra and cut.

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Adjust new parts in combination with side wall to fit and secure.

In area of bonding surface (1), drill 12  $\varnothing$  4.2 mm holes for blind rivets.

### Installation of outer wheel arch section

**Important!**

Do not grind/sand new part in area of bonding surfaces.



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

Apply adhesive to bonding surfaces.

Apply sealant to new [cavity acoustic baffle](#).

Install and rivet outer wheel arch section.