

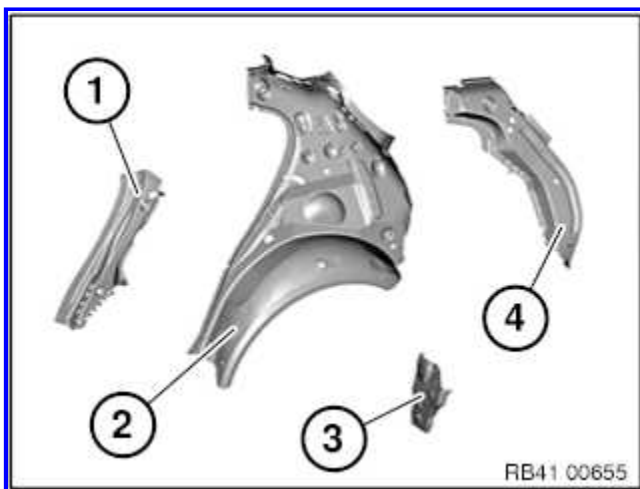
41 14 502**Replacing rear left outer wheel arch section with reinforcement (rear side panel removed)**

Follow procedure for [repair stage 3](#).

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

For stripping and rigging operations, refer to texts on KSD CD (job number 41 14 502).

Use only approved [spot-welding apparatus](#) for repairs.

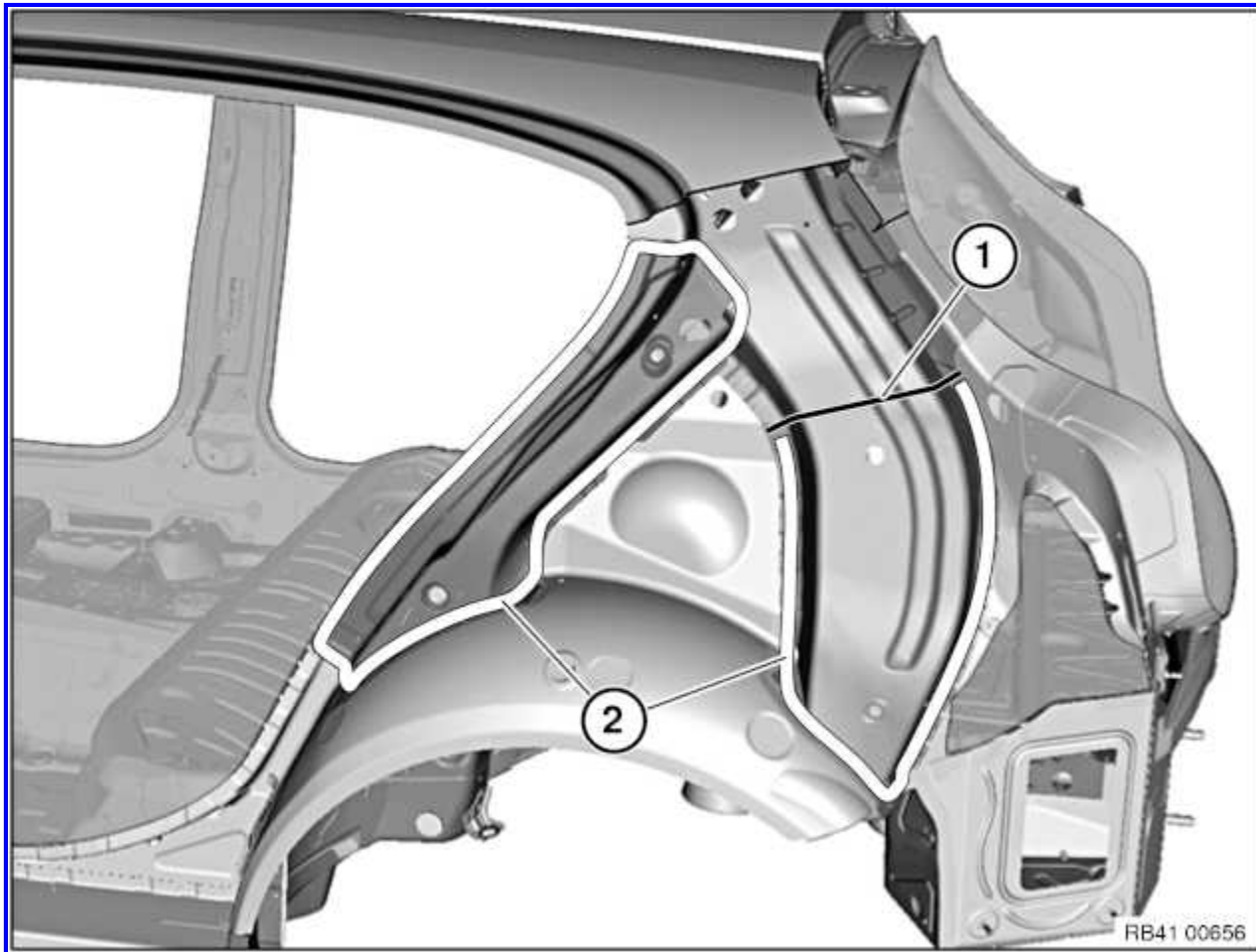


Following new body parts are required (refer to Electronic Parts Catalogue):

- (1) Support, C-pillar
- (2) Wheel arch, outer, rear
- (3) Closing plate, wheel arch
- (4) C-pillar reinforcement
- (5) Shaped part attachment, entrance (not shown)

**Removal of the outer wheel arch section with reinforcement**

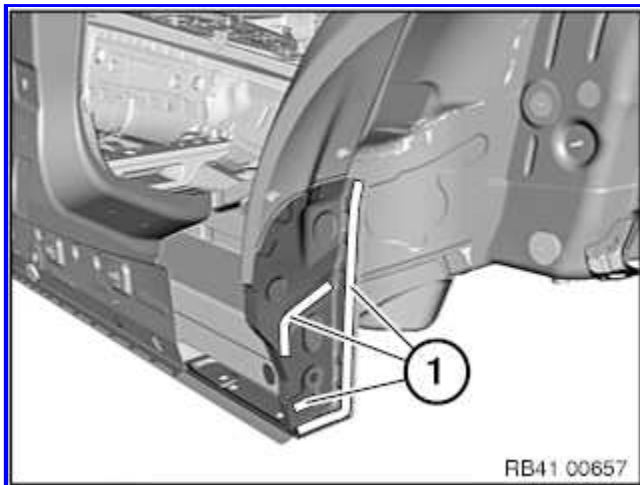
Mark severance cut (1) as pictured and cut.

**Important!**

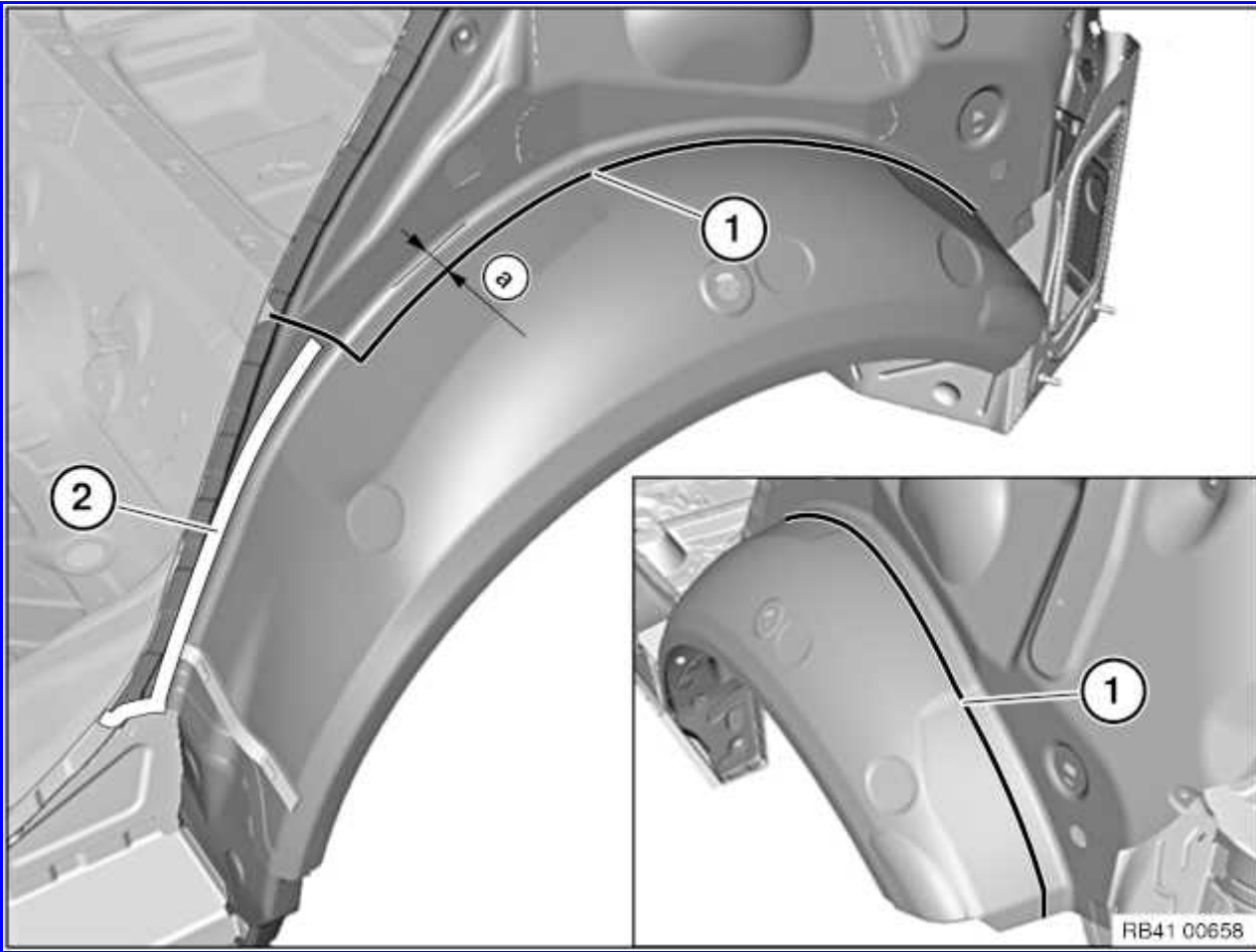
Cut outer
panel only.

Open welded
connections in
areas (2).

Remove C-pillar
support and
reinforcement.



Open welded connections in areas (1).



Mark severance cut (1) in accordance with dimension and cut.

Important!

Cut outer panel only.

Dimension a = 20 mm from radius of outer wheel arch section.

Open welded connections in area (2).

Remove part section of outer wheel arch section.

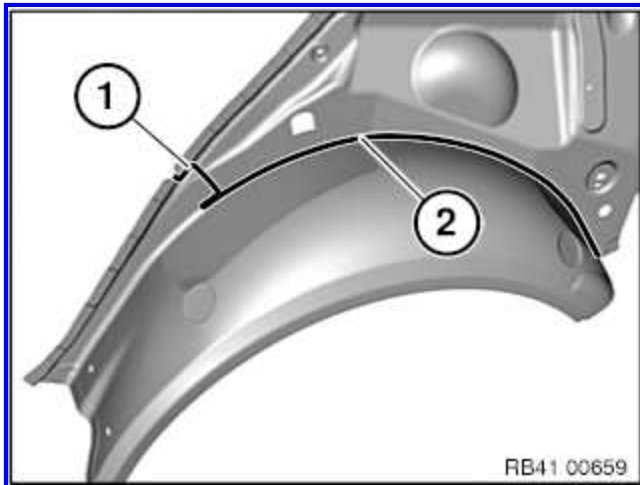


New part preparation

Carry out severance cut on C-pillar reinforcement in accordance with severance cut on vehicle.

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

Mark severance cut (1) in accordance with severance cut on vehicle + 20 mm extra material and cut.



Mark severance cut (2) in radius and cut.

Adjust new parts in conjunction with side panel to fit.

Note:

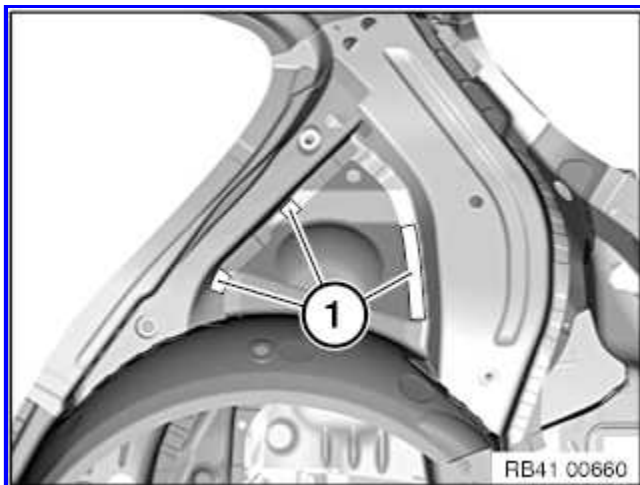
New parts are installed overlapping in areas of severance cuts.



Installation of the outer wheel arch section with reinforcement

Apply sealant to new [cavity sealing](#).

Install new parts and reinforcement plate and weld in place.



In areas (1) the outer wheel arch section and panel behind are joined by spot-welding bonding technology.

Apply repair welding spots in areas (1) to existing welding spots on vehicle.

This is necessary because the adhesive between the spot flanges acts as an insulator.

Apply repair welding spots in area (1) to existing welding spots on vehicle.

