

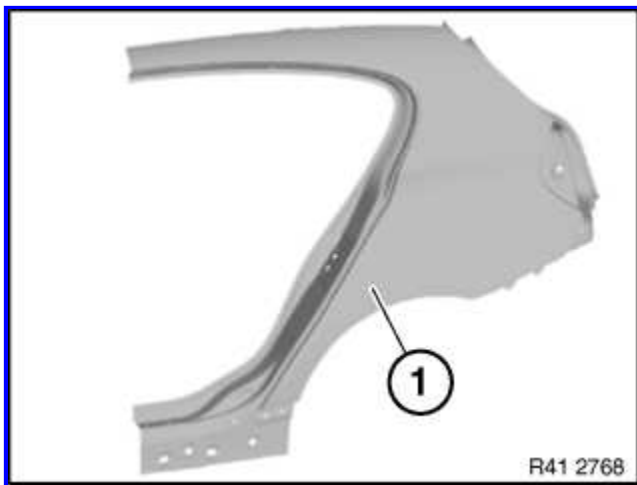
**41 35 101****Replacing rear left side panel**

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

[Strip down vehicle](#)



Procedure [Observe](#) repair stage 2!



The following new body parts are required (refer to Electronic Parts Catalogue).

- (1) Rear side wall
- (2) Reinforcement plates side sill (not shown)
- (3) Reinforcement plates C-pillar (not shown)
- (4) Lock nuts (not pictured)

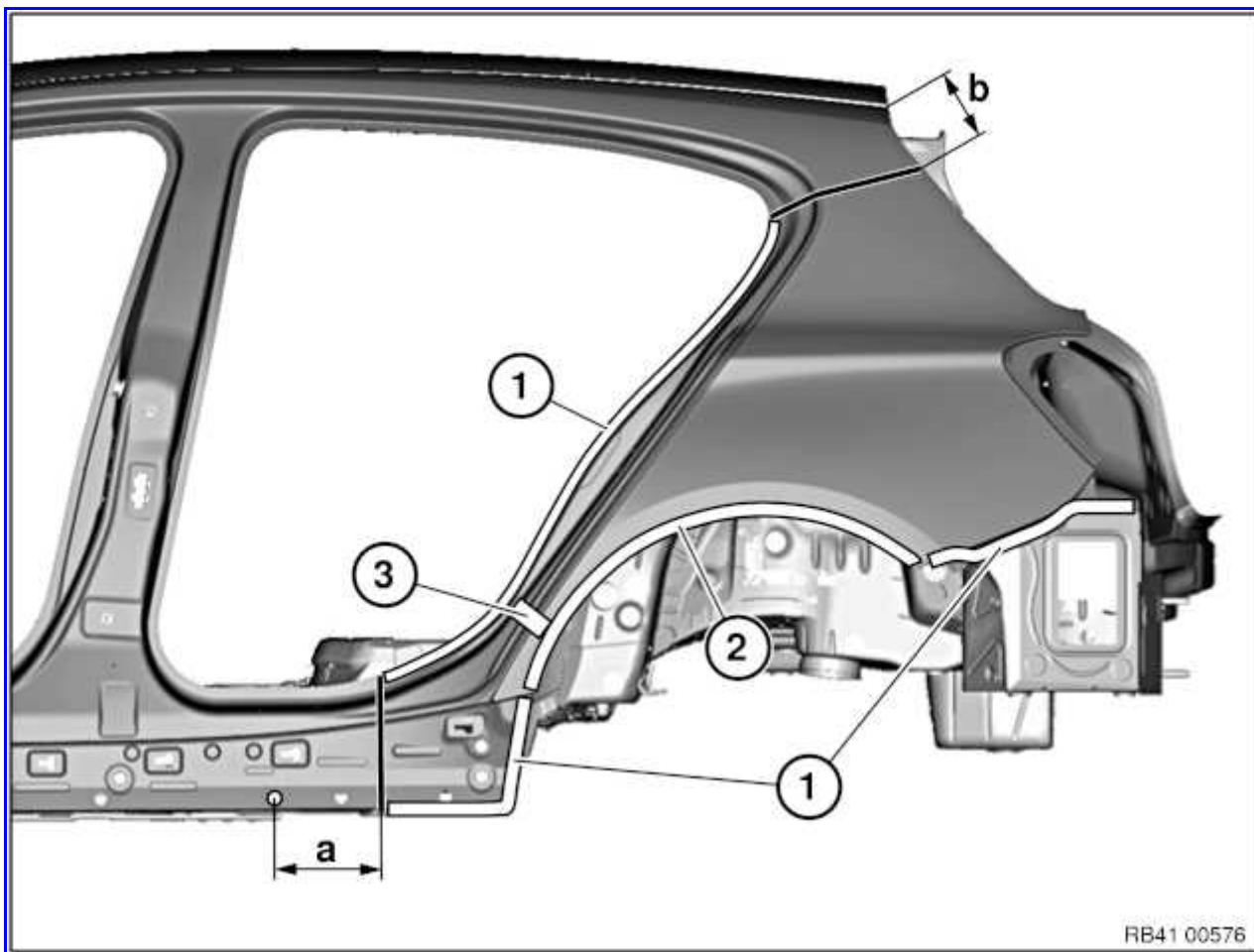
Following [consumables](#) are required:

| Material     | Quantity |
|--------------|----------|
| Adhesive K5b | 1        |
| Adhesive K5a | 1        |
|              |          |

|                            |    |
|----------------------------|----|
| Blind rivets N3            | 7  |
| Punch rivets N4            | 32 |
| Punch rivets N5            | 2  |
| EMC screws                 | 3  |
| Cleaning agent R1          | 1  |
| Cavity sealing wax remover | 1  |
| Sealant D1                 |    |



**Removing side wall:**



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Mark severance cuts in accordance with specified dimensions and cut.

Important!

Cut outer panel only.

Compare position of severance cuts with [reinforcement plates](#).

Dimension a = approx. 160 mm from centre point of 20 mm dia. hole.

Dimension b = approx. 170 mm from corner of roof outer skin.

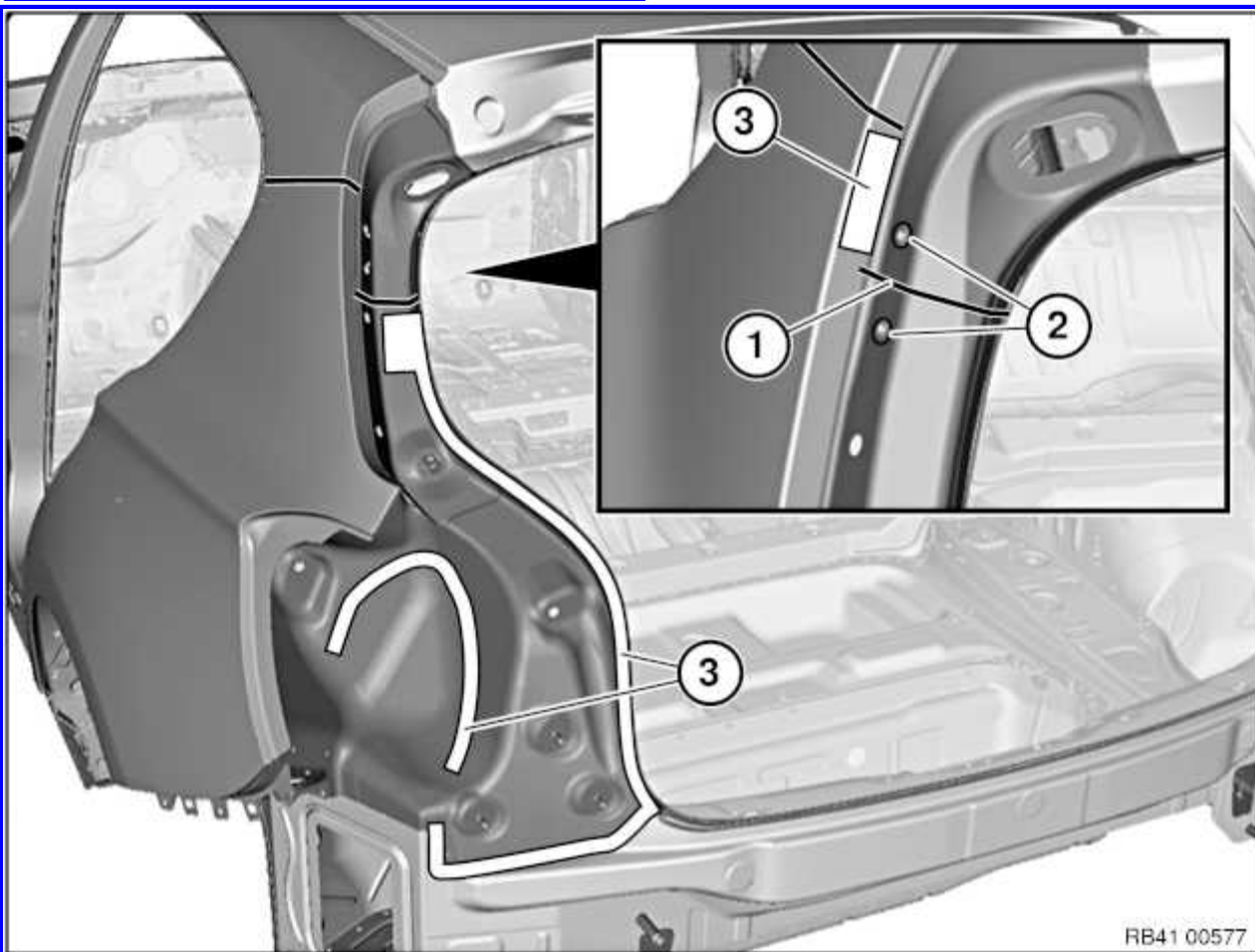
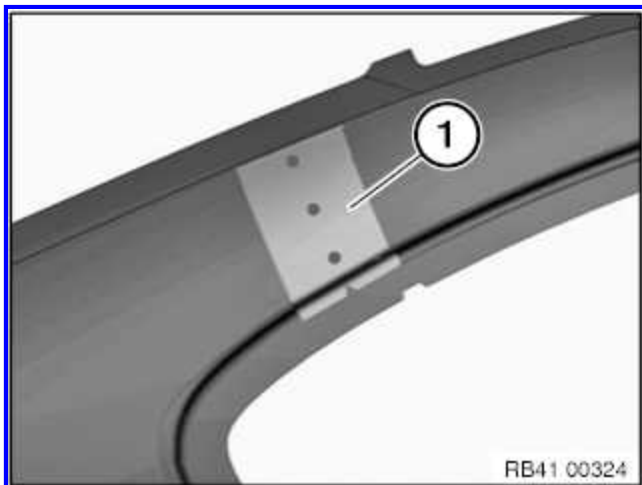
Open welded connections in areas (1).

Open [seam adhesive bond](#) in area (2).

Release side wall from cavity sealing (3).

*Note:*

In addition to the dimensions, the position of the separating cut can be determined with a [template](#) (1).



Mark severance cut (1) on water channel in accordance with schematic diagram and cut.

The severance cut runs down the middle between the attachment points (2) of the gas pressure spring.

Important!

Cut outer panel only.

The severance cut must be partially executed using a belt sander.

Detach welding spots from side wall in area of tailgate seal.

Open welded connections in areas (3).

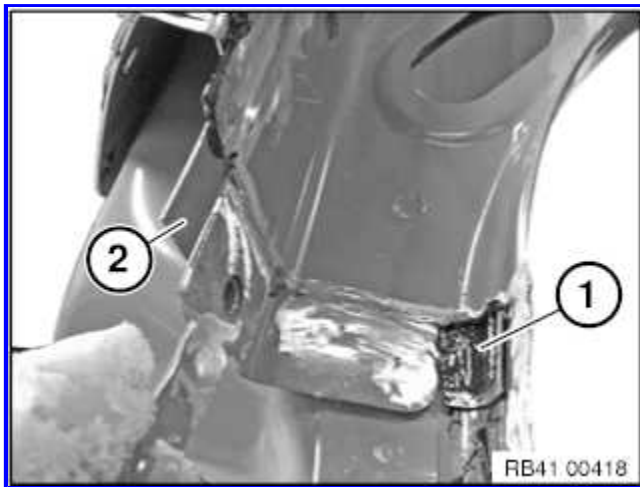
Detach side wall.



### Preparation of new part:

Mark severance cuts on the new part according to vehicle and cut.

Prepare [reinforcement plates](#) at severance cuts.



C-pillar water channel severance cut area:

Make an additional 2 shims (1) and (2) in the severance cut area.

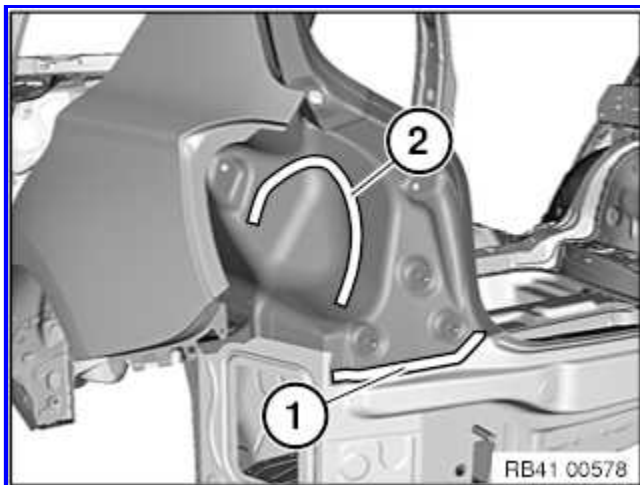
*Note:*

Before installing the side wall:

Clean bonding surfaces with cleaning agent R1.

Coat shim (1) with adhesive and slide in.

Coat shim (2) with adhesive and secure with a punch rivet N4.



Adjust new part to fit and secure.

### Important!

Adjust new part to fit without strain particularly in area of C-pillar. Straightening after the adhesive has hardened is not possible.

In areas (1) and (2) set 4.2 mm dia. holes for blind rivets N3:

| Area | Number |
|------|--------|
| 1    | 3      |
| 2    | 4      |

Remove new part again and deburr bore holes.

### Important!

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



### Installing side wall:

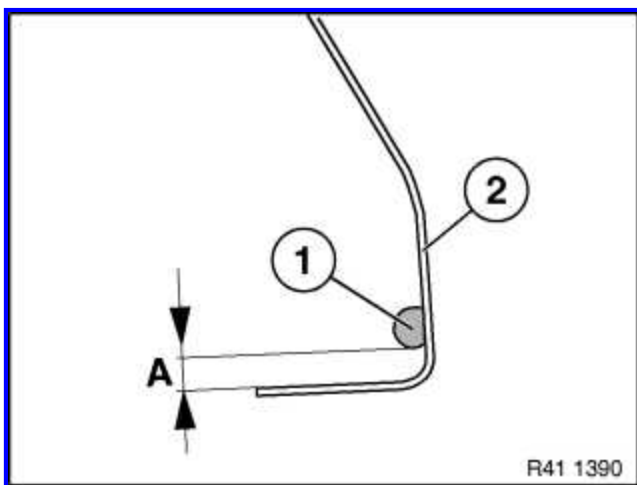
Clean all bonding surfaces on vehicle, on the new part and on the reinforcement plate with cleaning agent R1.

Apply adhesive to reinforcement plates. Install reinforcement plates.

Apply sealant to [cavity sealing](#).

Apply adhesive to bonding surfaces on vehicle.

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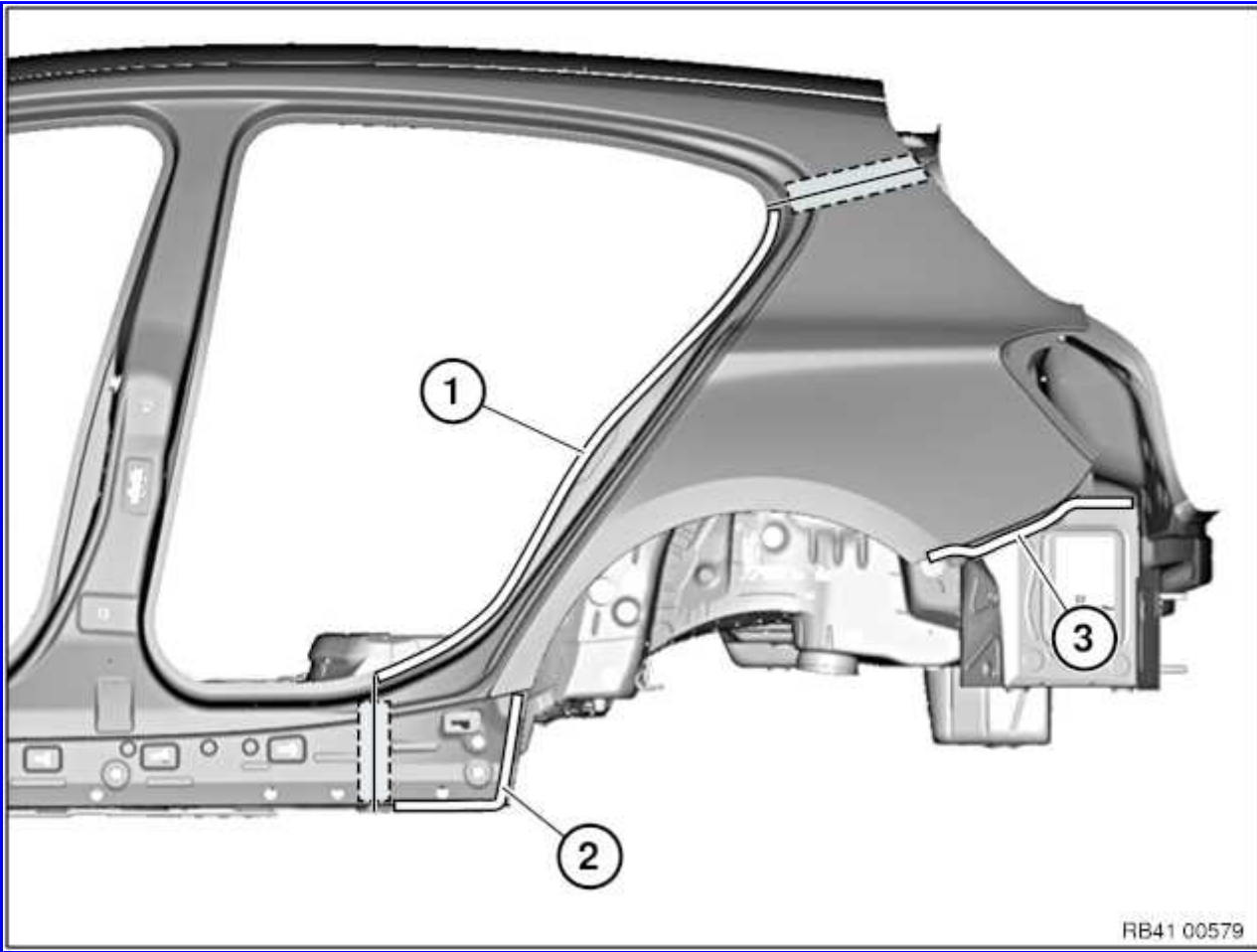


Apply adhesive to new part in area of wheel arch.

Apply adhesive (1) to inside of side panel (2) at distance a.

Dimension a = approx. 5 mm.

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Install side panel with a second person helping.

Note:

When installing side panel, make sure there is sufficient adhesive on bonding surfaces.

After adjusting side wall to fit, tighten nuts of reinforcement plates.

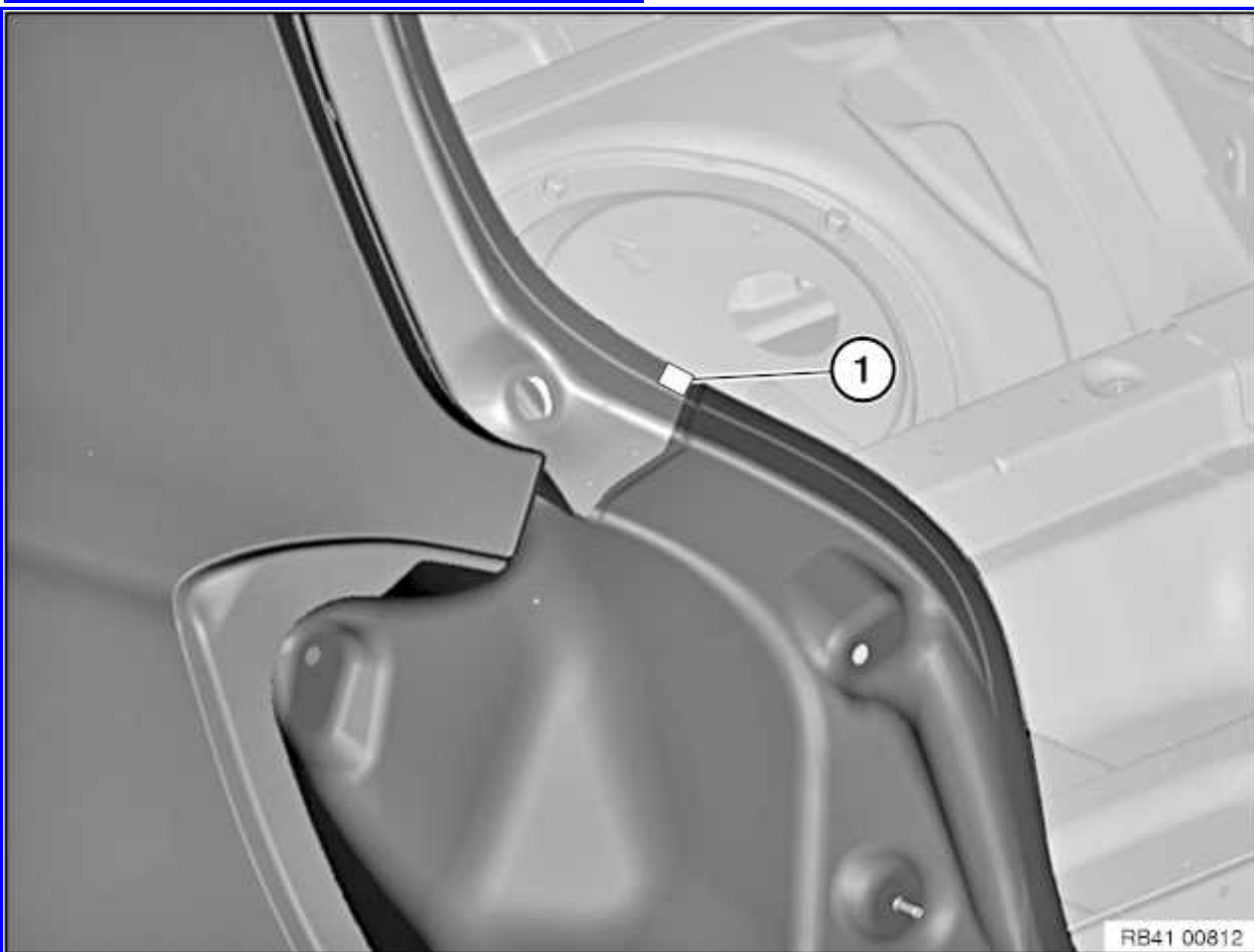
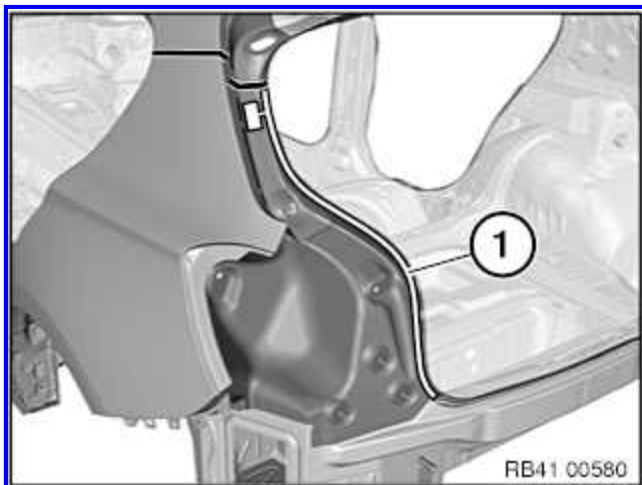
Secure side wall in area of reinforcement plates with gripping pliers.

Rivet side panel with blind rivets.

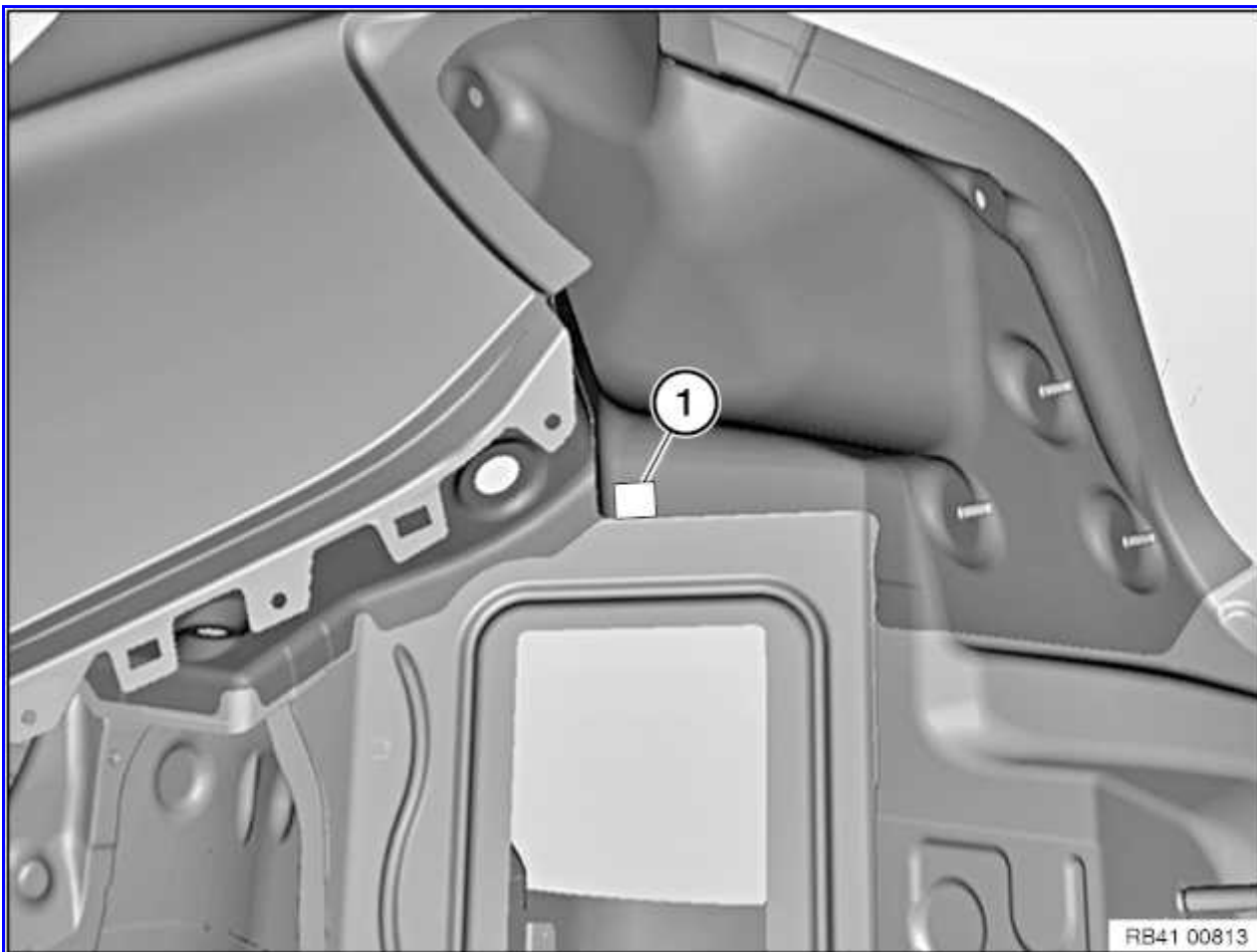
Use N4 punch rivets in areas (1) to (3).

| Area | Number |
|------|--------|
| 1    | 10     |
| 2    | 6      |
| 3    | 5      |

Use 10 punch rivets N4 in area (1).

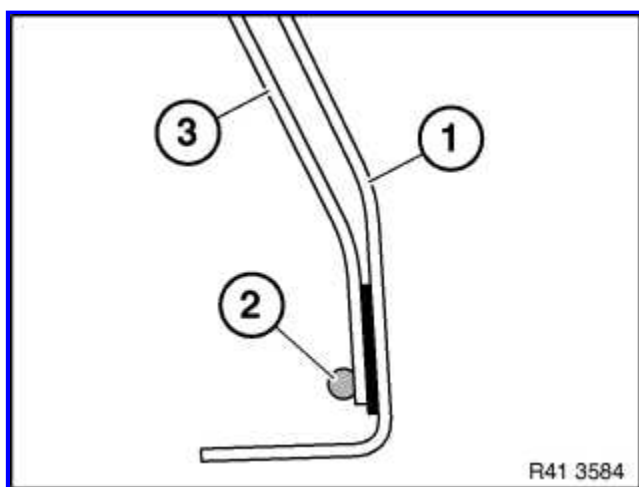
**Note:**

Due to a missing welding spot on the new part, a punch rivet N5 needs to be introduced in area (1) of the water channel.



Note:

Due to a missing welding spot on the new part, a punch rivet N5 needs to be introduced in area (1).



Also apply adhesive (2) to outer wheel arch section (3).

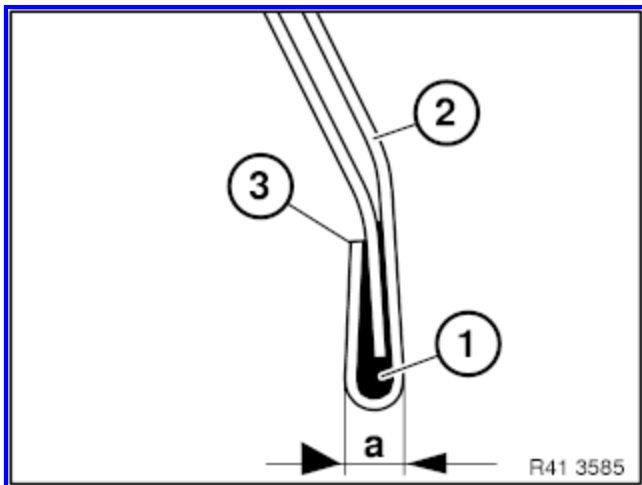
(1) Rear side wall.

Flange edge of wheel arch (3) of side wall flush to outer wheel arch section.

Do not create sharp edges when flanging as otherwise the flange edge may begin to tear.

Dimension (A) = 5 mm.

(1) Adhesive

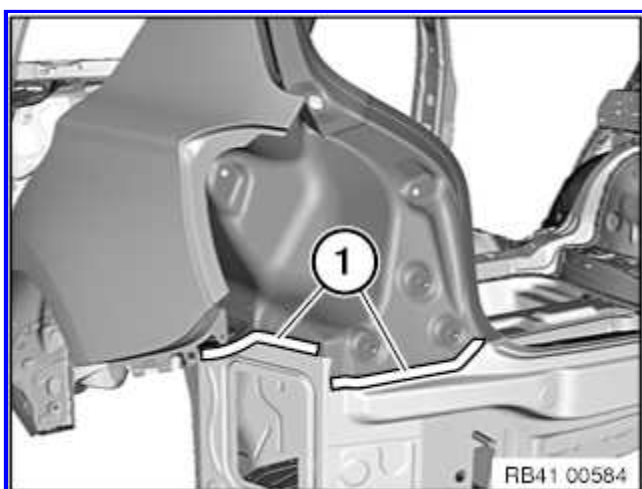


(2) Rear side wall

Also seal in area (3) according to standard.

**Important!**

Flange edge must be completely filled with adhesive!



After adhesive has hardened, install one [EMC screw](#) in each case in areas (1).

Additionally, install EMC screw in sill area.