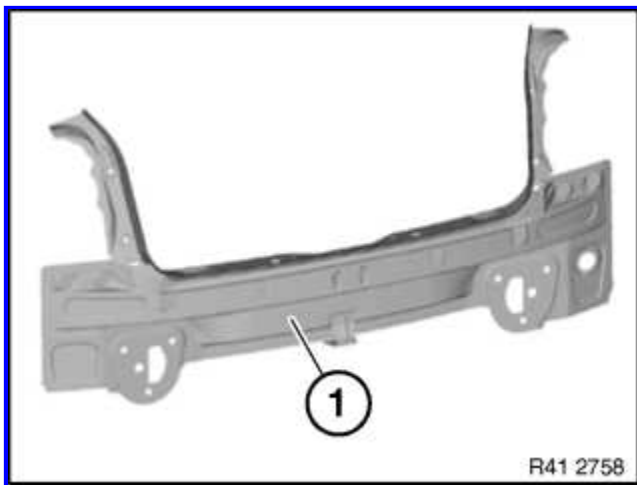


41 34 041**Replacing tail panel**

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



Procedure [Observe](#) repair stage 2!



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

- (1) Rear trim panel

Following [consumables](#) are required:

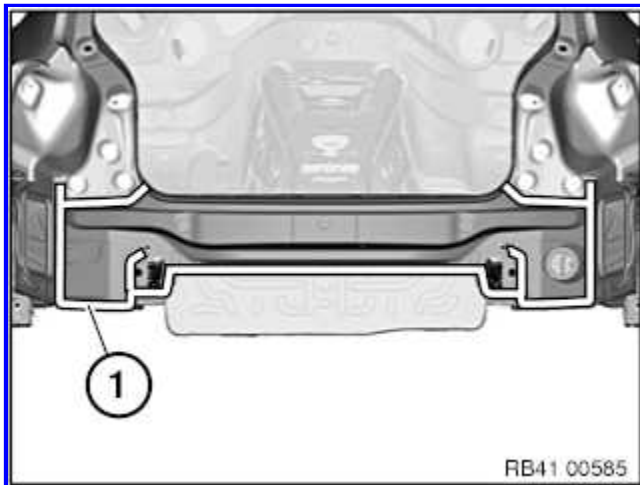
Material	Quantity
Adhesive K5b	1
Blind rivet N3	26
Punch rivet N4	12
Punch rivet N5	6
EMC screw	11

Cleaning agent R1	1
Sealant D1	
Cavity wax remover	

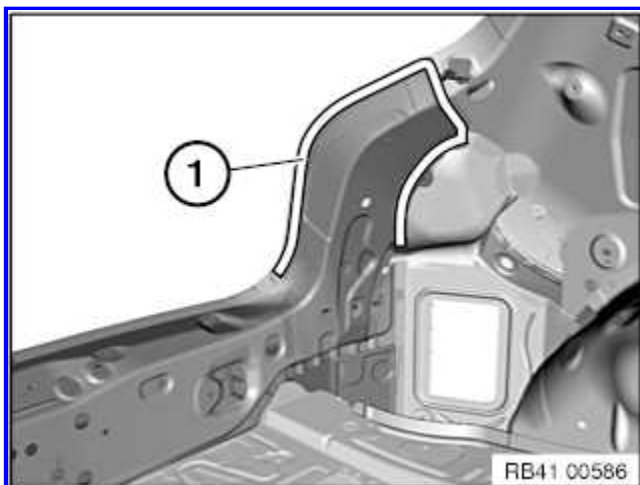


Removing rear trim panel

Operation is partially described on the left side. Right side identical.



Open welded connections in area (1).

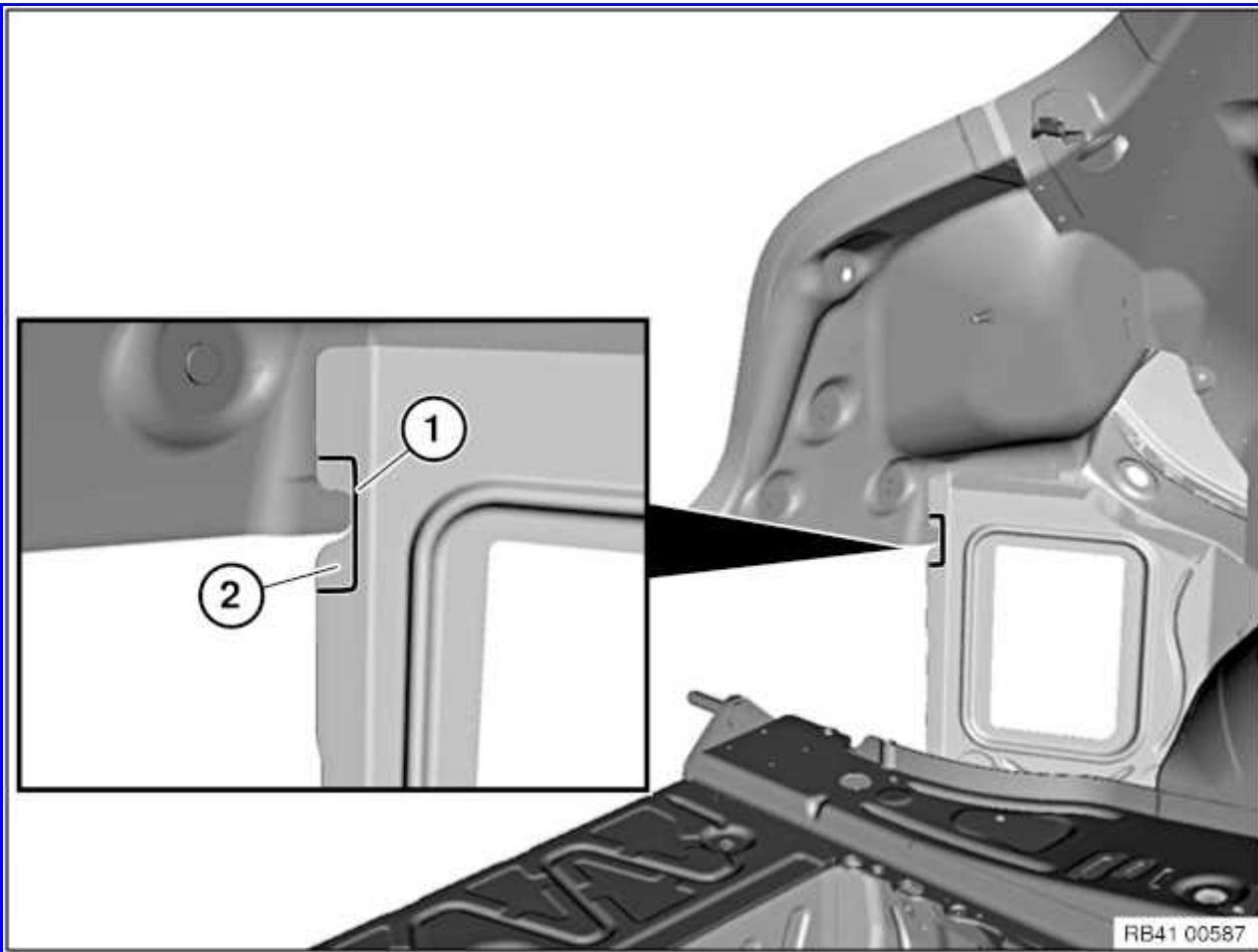


Open welded connections in area (1).



New part preparation

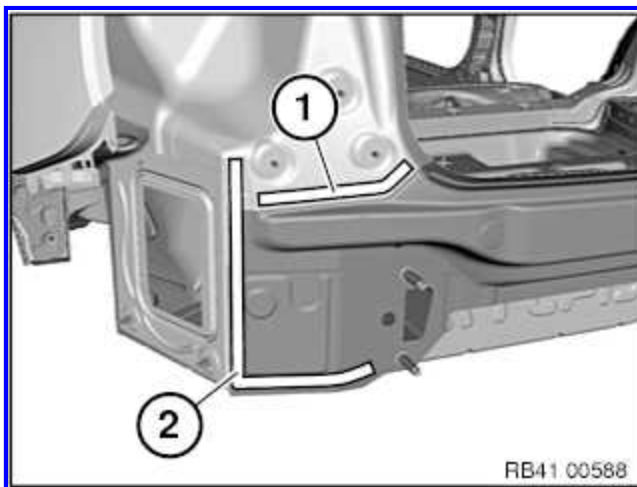
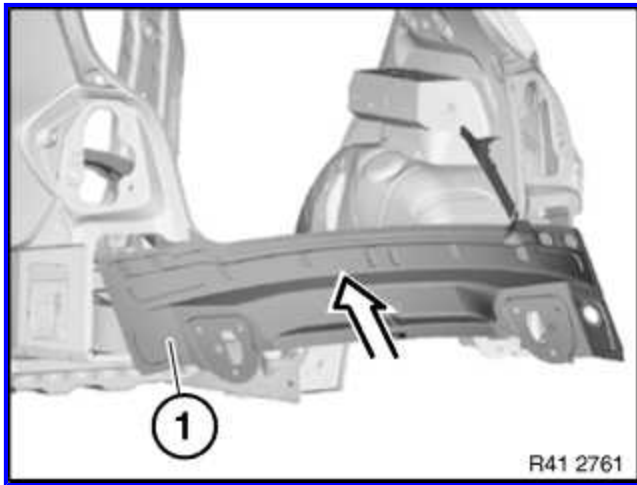
Operation is partially described on the left side. Right side identical.



Cut separating cut (1) in accordance with schematic diagram and remove section (2).

Length of section approx. 60 mm.

Slide in rear trim panel (1) from bottom upwards. Adjust rear trim panel in combination with rear lid and rear lights to fit and secure.

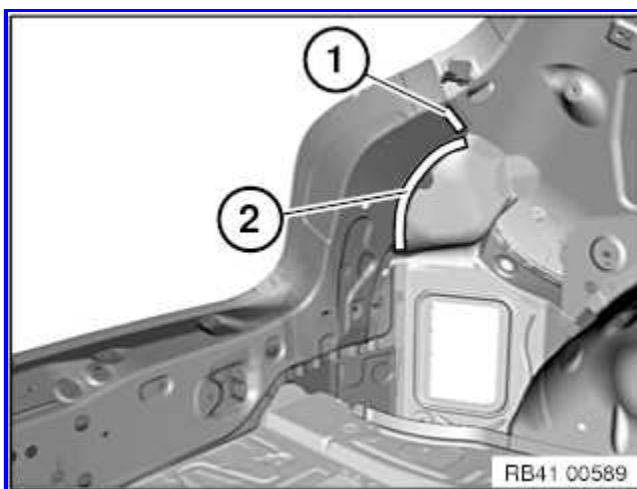


Important!

Retaining screws must not be used in area in area of tailgate seal.

In areas (1) and (2) set 4.2 mm diameter bore holes for blind rivets:

Area	Number
1	3
2	6



In areas (1) and (2) set 4.2 mm diameter bore holes for blind rivets:

Area	Number
1	1
2	3

Installation note:

Set blind rivet from outside inwards in area (2).

Remove new part and deburr bore holes.

Important!

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

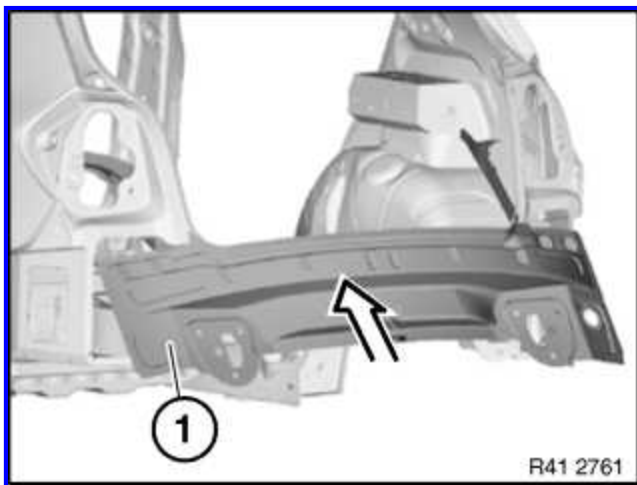


Installing rear trim panel:

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

Apply adhesive to bonding surfaces.

When inserting new parts, make sure there is sufficient adhesive on bonding surfaces.

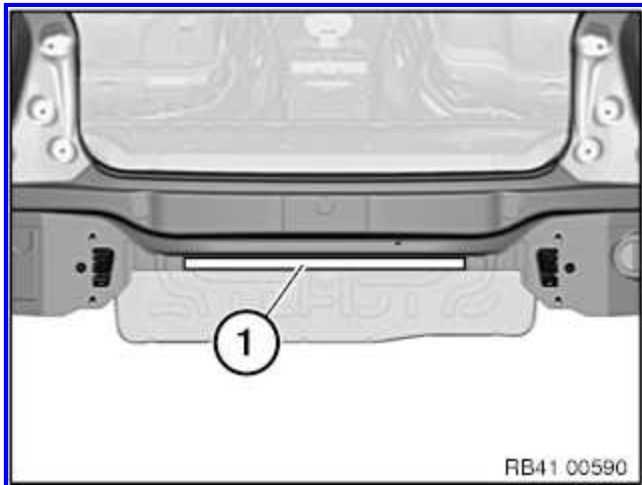


Mount rear trim panel (1) and secure with blind rivets.

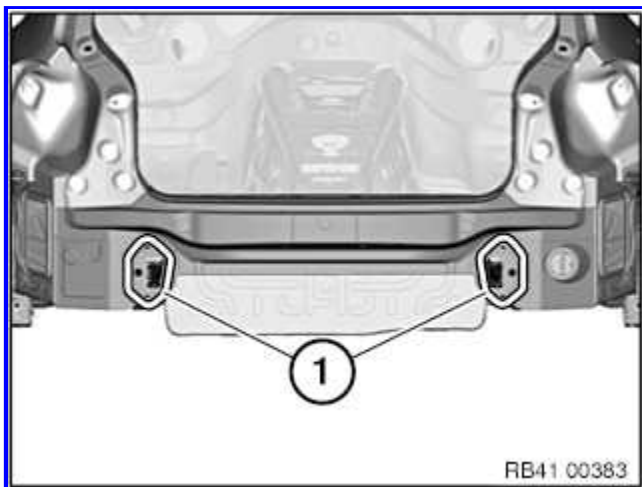
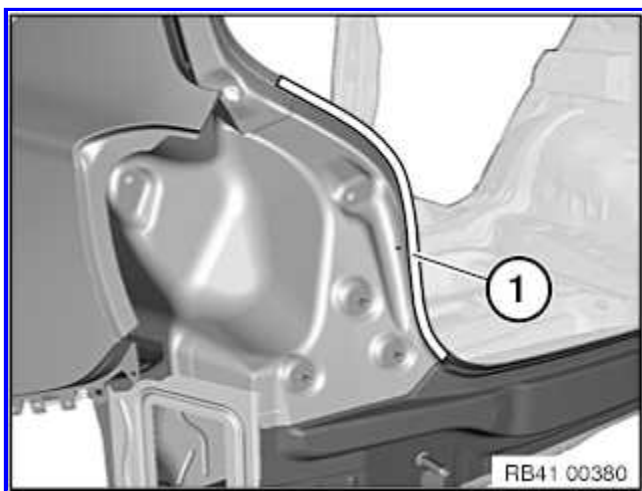
Important!

Three-plate connection!

In area (1) use 8 punch rivets N5 offset on both sides.



In area (1) set 6 punch rivets N4.



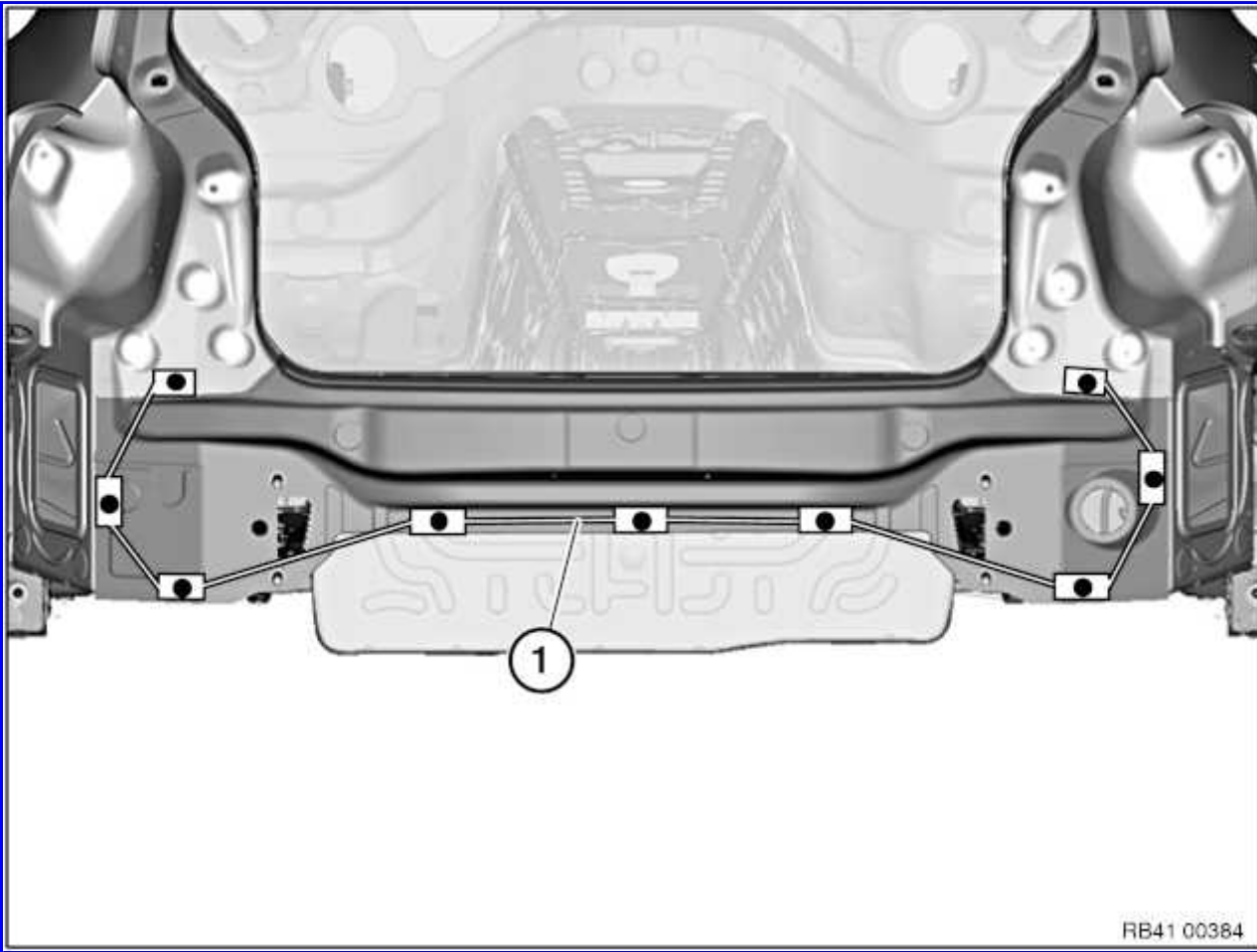
Press rear trim panel in areas (1) and remove emerging adhesive.

Then install carrier for bumper panel to secure rear trim panel.

Important!

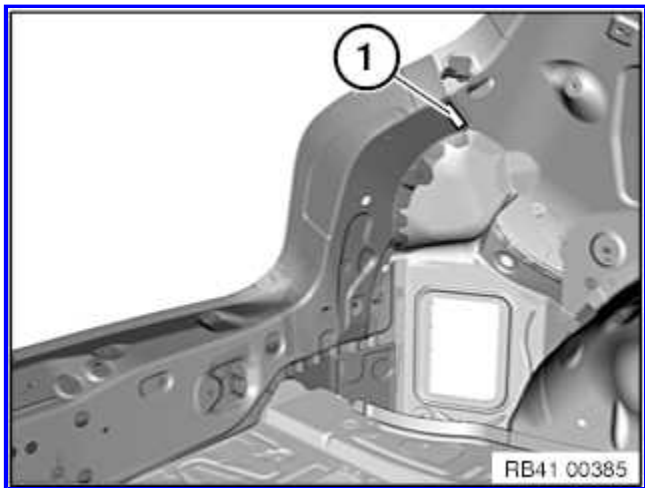
Prevent emerging adhesive from coming into contact with support.

Do not use any cleaning agents containing solvents.



After hardening of the adhesive in area (1), install [9 EMC screws](#).

Graphic similar.



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