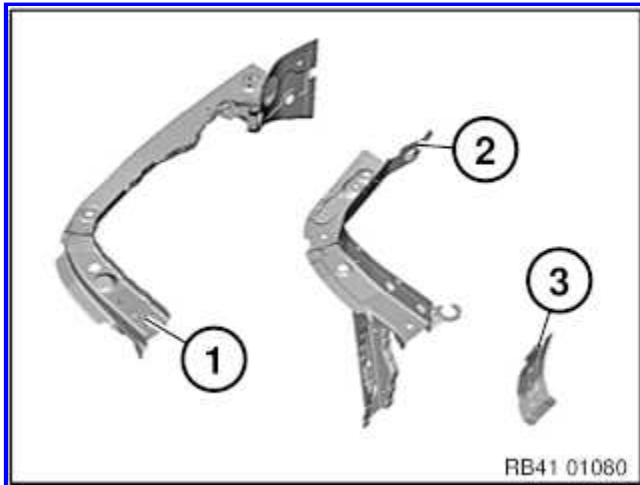


41 11 201**Replacing the carrier support before the wheel arch on the left**

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

Follow procedure for [repair stage 2](#).

[Strip down](#) vehicle.



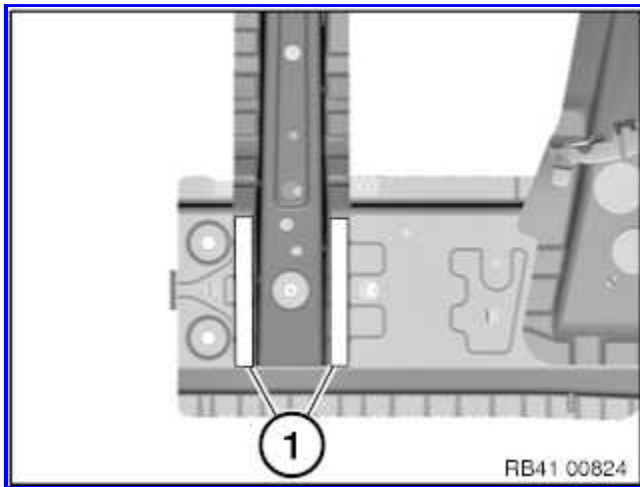
Following new body parts are required (see Electronic Parts Catalogue):

- (1) Carrier support, outer wheel arch section
- (2) Wheel arch inner section support member
- (3) Carrier support end plate

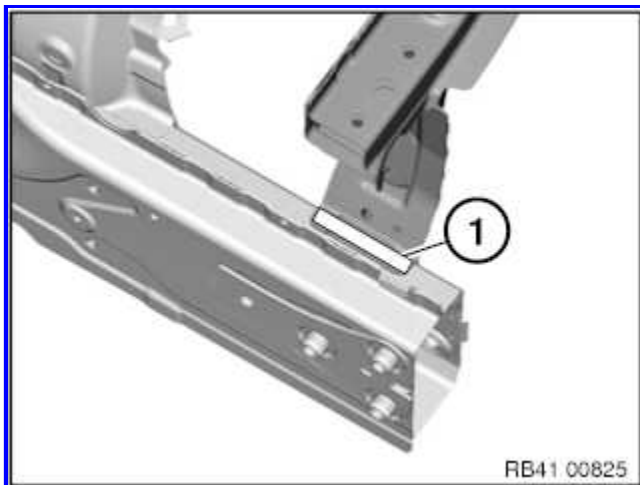
Following [consumables](#) are required:

Material	Quantity
Adhesive K1	1
Punch rivets N5	33
Sealant D1	
Cleaning agent R1	1

Removing carrier support



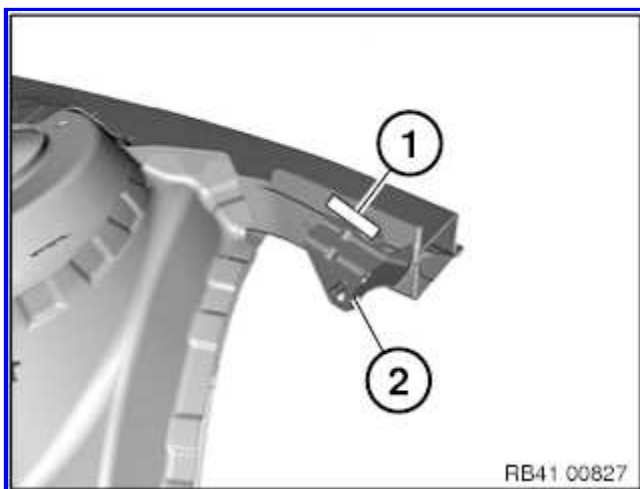
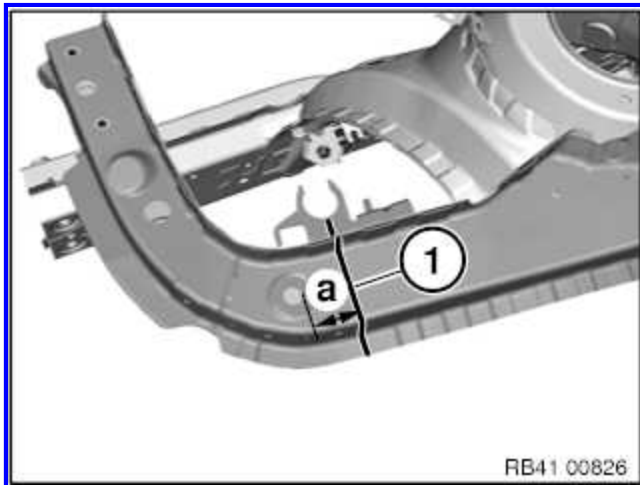
Open welded connections in areas (1).



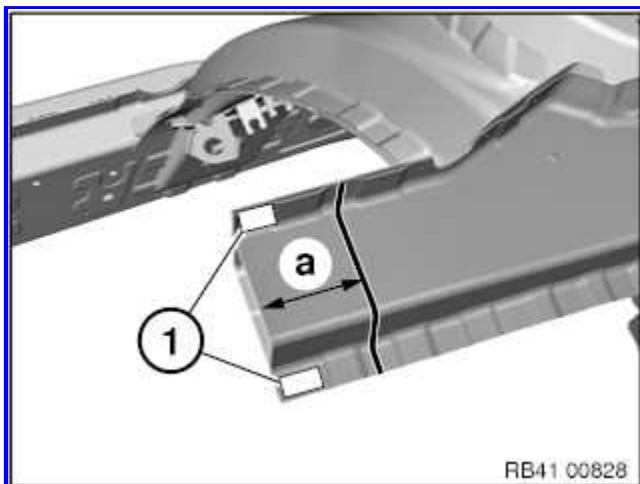
Open welded connections in area (1).

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

Dimension a = approx. 35 mm from 15 mm diameter hole.



Detach welded connections (1) and remove holder (2).



Mark severance cut in accordance with dimension and cut.

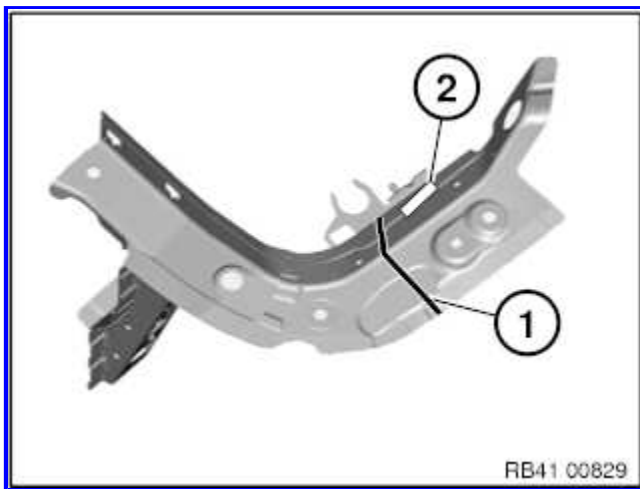
Important!

Cut outer metal panel only.

Dimension a = approx. 55 mm from previous separation cut.

Open weld joints in areas (1) and remove metal panel section.

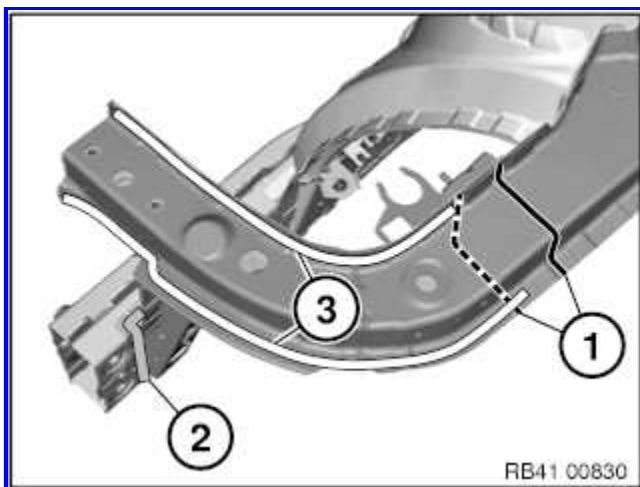
New part preparation



Mark severance cut (1) on inside part of carrier support in accordance with severance cut on vehicle and cut.

Release welded connections (2) for holder.

Mark severance cut on outside part of carrier support in accordance with severance cut on vehicle and disconnect.



Adjust new parts with add-on parts to fit and secure.

Prepare [reinforcement plates](#) (welded) at severance cuts (1).

Prepare new parts in engine support area (2) for plug-welding.

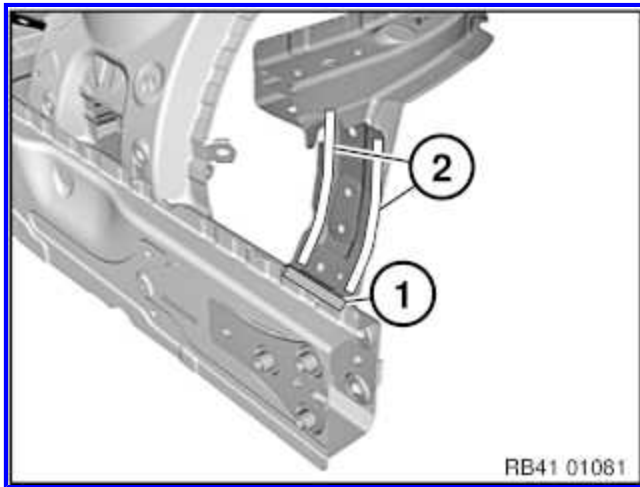
Note:

In areas (3), the new components are joined using the adhesive riveting method.

In area (1), prepare new part and engine support for plug-welding.

Note:

In areas (2), the new parts are joined using the adhesive riveting method.



Important!

Structure bonding!

Observe preparation of bonding surfaces.



Installing carrier support

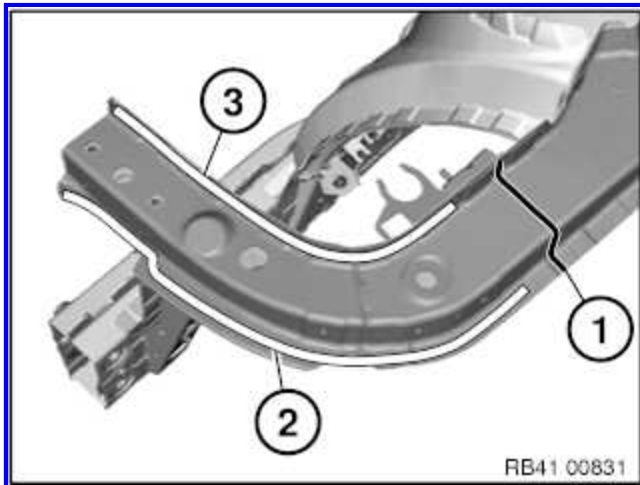
Install new part (carrier support for inner wheel arch section) and reinforcement plate and weld in place.

Install reinforcement plate in area of severance cut (1) and weld in place.

Clean all bonding surfaces with cleaning agent R1.

Apply adhesive to bonding surfaces, fit new component (outside part of carrier support) and fasten.

In areas (2) and (3), rivet new part with punch rivets N5.



Area	Number
2	11
3	10

Weld new part and reinforcement plate in the area of severance cut (1).

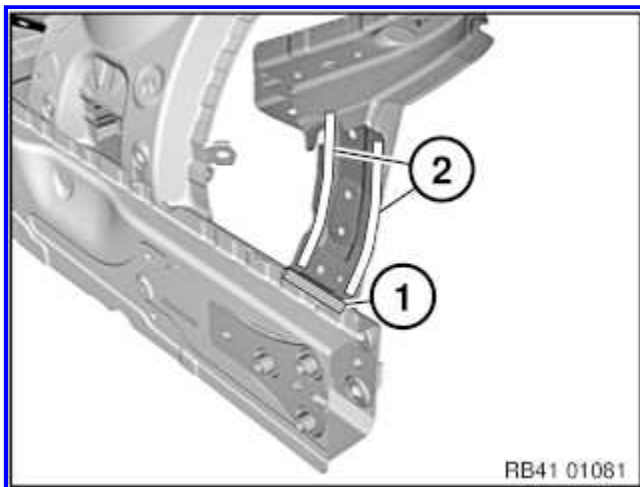
Important!

Risk of damage to adhesive area!

Avoid applying excessive heat to the neighbouring adhesive areas!

Note:

Do not seal new parts in the adhesive rivet areas (2) and (3). (visible area)



Apply adhesive to bonding surfaces, fit new part carrier support end plate and secure.

In areas (2), rivet new part with 12 punch rivets N5.

Weld new part in area (1).

Important!

Risk of damage to adhesive area!

Avoid applying excessive heat to the neighbouring adhesive areas!

Note:

Do not seal new parts in the area of the adhesive riveting. (visible area)

Remove excess adhesive.

Do not use any cleaning agents containing solvents.

