

41 14 Reinforcement plate
Tightening Torques

	Type	Thread	Tightening specifications	Torque
1AZ Cap nut to reinforcement plate	All	M5		6 Nm

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4100 Overview of Technical Data

Gap dimension between door window glass and rear side window

1 front door; 2 side sill trim panel

a

8.0 (6.7 - 9.3) mm

b

0 (-0.7 - 1.7) mm

Gap dimension bonnet to bumper panel

1 bonnet; 2 bumper panel

a

3.5 (2.3 - 4.7) mm

b

1.0 (-0.5 - 2.5) mm

Gap dimension bonnet to front side panel

1 bonnet; 2 front side panel

a

3.3 (2.3 - 4.3) mm

b

0.5 (-1.1 - 2.1) mm



Gap dimension bonnet to headlight

1 bonnet; 2 headlight

a

5,3 (3,5 - 7,1) mm

Gap dimension from front door to rear side panel

1 Front door; 2 Rear side panel

a

3,8 (2,8 - 4,8) mm

b

0 (-0,3 - 1,3) mm



Gap dimension front door to side sill trim panel

1 front door; 2 side sill trim panel

a

3,8 (2,6 - 5.0) mm

b

1.6 (0,3 - 2,9) mm

Gap dimension front door to side sill trim panel

1 front door; 2 side sill trim panel

a

3,8 (2,6 - 5.0) mm

b

0 (-1.3 - 1.3) mm



Gap dimension front side panel to A-pillar

1 front side panel; 2 A-pillar

a

2.8 (1.6 - 4.0) mm

b

0,7 (-0,5 - 1,9) mm

Gap dimension front side panel to front door

1 Front side panel; 2 front door

a

3,8 (2.8 - 4,8) mm

0,5 (-0,3 - 1,3) mm

Gap dimension glass slide/tilt sunroof panel to roof outer skin

1 glass slide/tilt sunroof panel; 2 roof outer skin

a

0,7 (-0,05 - 1,45) mm



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Gap dimension rear side panel to tailgate

1 rear side panel; 2 tailgate

a

3.5 (2,4 - 4.6) mm

b

0,3 (-1,1 - 1,7) mm



Gap dimension rear side panel to tailgate

1 rear side panel; 2 tailgate

a

3.5 (2.3 - 4.7) mm

b

-0.6 (-2.0 - 0.8) mm

Gap dimension rear window to roof outer skin

1 rear window; 2 roof outer skin

a

3.2 (1.9 - 4.5) mm

b

1.5 (0.2 - 2.8) mm

Gap dimension roof outer skin to glass slide/tilt sunroof panel

1 roof outer skin; 2 glass slide/tilt sunroof panel

a

0.7 (-0.05 - 1.45) mm



Gap dimension tailgate to rear bumper panel

1 tailgate; 2 rear bumper panel

a

5,1 (3,6 - 6,6) mm

Gap dimension windscreen to roof outer skin

1 windscreen; 2 roof outer skin

a

4,3 (3,1 - 5,5) mm

b

3,6 (2,3 - 4,9) mm



Putty S1**Processing time**

20 °C

90 min

Processing time

30 °C

60 min

Age-hardening duration

60 °C

60 min

Storage

15 °C ... 25 °C

Durability (note the expiration date on the cartridge)

12 Monate

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41 14 Reinforcement plate
Tightening Torques

	Type	Thread	Tightening specifications	Torque
1AZ Cap nut to reinforcement plate	All	M5		6 Nm

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4135 Overview of tightening torques

Front side panel holder to body		
M6 screw	Tightening torque	8Nm
Front side panel to holder for front side panel		
Screw M6	Tightening torque	8Nm
Guide to side panel		
Screw	Tightening torque	3,0Nm

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4151 Overview of tightening torques

Door hinge to door		
Countersunk screw with Torx M8	Tightening torque	19Nm
Front door to door hinge		
Screw	Tightening torque	19Nm
Screw connection, hinge parts		
Screw	Tightening torque	27Nm

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4161 Overview of tightening torques

Bonnet to hinge			
Nut M8		Tightening torque	19Nm
Engine compartment lid hinge to body			
Screw		Tightening torque	28Nm

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4162 Overview of tightening torques

Hinge to hinge support		
Nut	Tightening torque	19Nm
Tailgate hinge to body		
Nut M8	Tightening torque	19Nm
Tailgate hinge to tailgate		
Hexagon screw M8 x 18	Tightening torque	19Nm

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41 operating fluid overview

Adhesive

Body adhesive K1	195 ml	83190413015
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Adhesive

Body adhesive K2	2x290 ml	83192355849
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Expendable materials

Thin-wall threaded insert M6		41002288195
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Expendable materials

Thin-wall threaded insert M8		41002361595
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Expendable materials

Helicoil thread insert	M12x30 mm	31 10 6 868 499
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Adhesive

Body adhesive K3	2x300 ml	83190417144
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Expendable materials

Betawipe 4800	10 ml	83192357707
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Expendable materials

Bonding base VP 206	30 ml	83199407777
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Expendable materials

Blind rivet N11 for CFRP connections	∅4,8 mm, Clamping area 2.2-4.7 mm	83197391057
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Expendable materials

Blind rivet N12 for CFRP connections	∅4,8 mm, Clamping area 4.5-7.5 mm	83197391046
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Expendable materials

Plastic nut	∅18 mm	51161943122
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Expendable materials

Plastic nut	∅22 mm	07147169847
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Expendable materials

Twist drill, high-strength	∅6,8 mm, Length: 79 mm	83192359262
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Length: 79 mm

Expendable materials

Twist drill, high-strength	∅4,2 mm, Length: 66 mm	83192359263
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Expendable materials

Scotchbrite Multiflex A, very fine (no longer available)	Ersatzweise Schleifpapier Körnung 220 verwenden.	
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Expendable materials

Adhesive tape		51717901759
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Expendable materials

Reinforcement plate, universal		41217275563
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Expendable materials

Sealant D1 (seam sealing)	310 ml	83422409985
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Expendable materials

Sealant D2	290 ml	83425A547B9
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Expendable materials

Cavity foamHS1	400 ml	83429410694
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Expendable materials

Structural foam HS2 (no longer available)	ml	
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Expendable materials

Cavity foam HS3 (2K polyurethane foam)	50 ml	83422288930
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Expendable materials

Aluminium adhesive tape (adhesive tape)	50 mm	11007769948
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Expendable materials

Repair rivet for T-bolt	∅2,4 mm, Clamping area 0.8-2.5 mm	07148497787
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Expendable materials

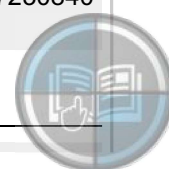
Repair rivet for T-bolt	∅2,4 mm, Clamping area 2.5-6.0 mm	07148497788
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Expendable materials

PrimerP2	50 ml, Gas cartridge	83190302555
Expendable materials		
PrimerP1	50 ml, Bottle	83190302556
Expendable materials		
Cavity sealing wax remover	500 ml, Spray bottle	83120390086
Expendable materials		
Screw EMC screw, SF Plus, M5x15		83190301639
Expendable materials		
Drill bit	∅6,8 mm, Length: 150 mm	83192460425
Expendable materials		
Drill bit	∅4,2 mm, Length: 120 mm	83192460424
Expendable materials		
Blind rivet N1 Ø 6.5 mm ; clamping area 2.8-4.8 mm		83190301414
Expendable materials		
Blind rivet N2 Ø 6.5 mm ; clamping area 4.8-6.8 mm		83190301419
Expendable materials		
Punch rivet N5 Ø 5 mm ; 5 mm long		83192158079
Expendable materials		
Blind rivet N7 Ø 6.5 mm ; clamping area 1.5 - 3.5 mm		83192240352
Expendable materials		
Blind rivet N10 Dia. 6.5 mm; clamping area 10.8-12.8 mm		83199144282
Expendable materials		
Blind rivet N9 Dia. 6.5 mm; clamping area 8.8-10.8 mm		83197239634
Adhesive		



Body adhesive K5	50 ml	83192158654
Expendable materials		
Blind rivet N3 Dia. 4 mm; clamping area 1-3 mm		83190301421
Expendable materials		
Blind rivet N6 Dia. 4 mm; clamping area 3-5 mm		83192158655
Adhesive		
Body adhesive K5	195 ml	83195A59935
Adhesive		
Body adhesive K4	50 ml, Cartridge	83192456697
Expendable materials		
Punch rivet N4 Ø 3 mm ; 4 mm long		83192457307
Expendable materials		
Cavity sealant spray	400 ml	83422457337
Expendable materials		
Cavity preservation	1000 ml	83422457338
Expendable materials		
Helicoil thread insert	M10x25 mm	33 30 6 782 756
Expendable materials		
Filler S1	175 ml	83192464575
Expendable materials		
Helicoil thread insert	M8x20 mm	31 10 6 868 376
Expendable materials		
Blind rivet (steel) Ø 4.8 mm ; Clamping area 2-6 mm ; Head diameter 13 mm		07147230840
Expendable materials		
Blind rivet Ø 4.8 mm ; Head Ø 13 mm ; Clamping area 2-6 mm		07147230840
Expendable materials		



Blind rivet nut with flat head	M10	07147199279
Expendable materials		
Helicoil thread insert	M10x30 mm	07129909659
Adhesive		
Aktivator -205	250 ml, Bottle	83190030155
Expendable materials		
Blind rivet Ø 6.0 mm ; Head Ø 15 mm ; Clamping area 2-6 mm		07147265827
Expendable materials		
Blind rivet nut for M6 bolt Ø 9.0 mm; clamping area 2.8-4.8 mm		6989330
Expendable materials		
Blind rivet N8 Ø 6.5 mm; clamping area 6.8-8.8 mm		83192355998



5100 Overview of Technical Data

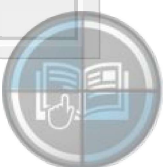
Dimension of adhesive bead	
Use standard nozzle C.	A
	8 (7 - 9) mm
	B
	12 (11 - 13) mm

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5111 Overview of tightening torques

Adapter, front axle support to front axle support		
M8x70	Tightening torque	19Nm
Bumper mounting, side front		
Screw	Tightening torque	3Nm
Bumper panel, front top		
Oval-head screwM6	Tightening torque	4,6Nm
Front bumper panel to front side panel		
Torx screw 5x35	Tightening torque	3Nm
Front bumper panel to underbody protection		
Hexagon screw for thermoplastic	Tightening torque	2,6Nm
Front bumper support to engine support		
Hexagon screw with flange Renew screw	Tightening torque	100Nm
	Angle of rotation	180°
License plate baseplate		
Oval-head screw	Tightening torque	2,5Nm
Support for bumper panel, bottom front on deformation element		
Combination oval-head machine screw	Tightening torque	10Nm
Vertical connection to deformation element		
Flat-head screw M6x20	Tightening torque	11,8Nm
Vertical connection to deformation element		
Hexagon screw	Setpoint torque	21Nm
Vertical connection to deformation element		
Hexagon screw	Tightening torque	21Nm



5112 Overview of tightening torques

Guide, side, to body		
Combination hexagon nut	Tightening torque	4,6Nm
Lower bumper panel to body		
Oval-head screw	Tightening torque	2.5Nm
Mounting for rear bumper panel on support for rear bumper panel		
Hexagon screw for thermoplastic	Tightening torque	2,6Nm
Rear bumper panel guide on body at the side		
Multi-purpose nut with paint scrape groove	Tightening torque	5Nm
Rear bumper trim panel to guide		
Hexagon screw	Tightening torque	2.5Nm
Rear centre guide to body		
Nut		4,6Nm
Rear silencer to support		
M8 hexagon nut	Tightening torque	19Nm
Support to impact plate		
M12 hexagon nut	Tightening torque	108Nm



5114 Overview of Technical Data

Heating using hot air blower	
	Surface temperature
	40 °C ... 50 °C

Model inscription on the left side of the tailgate	
	Dimension B from horizontal lower edge of tailgate
	47 mm

Model inscription on the left side of the tailgate	
	Dimension A from corner of tailgate
	69 mm

Model inscription on the right side of the tailgate	
	Dimension B from horizontal lower edge of tailgate
	45 mm

Model inscription on the right side of the tailgate	
	Dimension A from corner of tailgate
	75 mm



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5116 Overview of tightening torques

Centre console on tunnel		
M6x18 Hexagon screw	Tightening torque	4,6Nm
Centre console to instrument panel		
Oval-head screw	Tightening torque	1,8Nm
Cup holder to centre console		
Oval-head screw	Tightening torque	1,8Nm
Exterior mirror to door		
Screw	Tightening torque	8Nm
Fold-down compartment to instrument panel		
Oval-head screw	Tightening torque	1,8Nm
Housing to exterior mirror		
	Tightening torque	0,85Nm
Retaining ring to exterior mirror		
Screw	Tightening torque	0,85Nm
Storage compartment in centre console		
Oval-head screw	Tightening torque	1,8Nm
Sun visor to body		
Screw	Tightening torque	3.3Nm



5121 Overview of tightening torques

Attachment bell to outside door handle support		
Screw	Tightening torque	3Nm
Clamping bolt for door handle		
Screw	Tightening torque	2Nm
Door lock to door		
Screw	Tightening torque	8,8Nm
Door retainer to door		
Hexagon nut	Tightening torque	8Nm
Door stop to pillar		
Screw	Tightening torque	28Nm
Outer door handle to door		
Clamping bolt	Tightening torque	3Nm
Outside door handle support to door		
Screw	Tightening torque	2,6Nm



5122 Overview of tightening torques

Lock striker			
Screw		Tightening torque	21Nm

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5123 Overview of tightening torques

Actuator to engine compartment lid hinge		
M6x12 Renew screw.		8Nm
Engine compartment lid catch		
Screw Replace screws	Tightening torque	8Nm
Striker to bonnet		
Screw	Tightening torque	8Nm

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5124 Overview of tightening torques

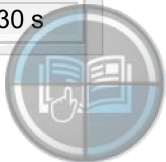
Striker to rear lid		
Hexagon screw M8x20	Tightening torque	19Nm
Tailgate lock to body		
Hexagon screw M8x20	Tightening torque	19Nm

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5131 Overview of Technical Data

Air drying time after cleaning	
	Cleaning agent R1
	1 min
Air drying time after cleaning	
	Window glass or painted panel without residual adhesive bead
	5 min
	Body with residual adhesive bead
	15 min
Air drying time after cleaning	
	Cleaning agent R2
	2 min
Air drying time after cleaning	
	Cleaning agent R2
	5 min
Air drying time after cleaning	
	Window glass or painted panel without residual adhesive bead
	5 min
	Body with adhesive bead
	15 min
Air drying time after the order	
	Glass activator
	10 min
Air drying time after the order	
	Glass activator
	2 min
Air drying time after the order	
	Loctite SF 770
	30 s



Air drying time after the order**Aktivator -205**

2 min

C nozzle

For windscreens, rear windows, and body-specific fixed side window glass.

Diameter A

7.5 (6,5 - 8,5) min

Height B

13 (12 - 14) mm

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5132 Overview of tightening torques

Door window glass to power window regulator		
Screw	Tightening torque	0.25Nm
Toothed nut of side window		
Toothed nut	Tightening torque	11Nm

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5133 Overview of tightening torques

Module carrier to the front door		
Oval-head screwM6	Tightening torque	9Nm

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5135 Overview of tightening torques

Power window regulator to inner door panel	
M6	9,5Nm

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5141 Overview of tightening torques

Door trim panel			
Oval-head screw		Tightening torque	3Nm
Handle on door trim panel			
Oval-head screw		Tightening torque	2.0Nm
Inner door opener on door trim panel			
Oval-head screw		Tightening torque	2.0Nm
Repair screw to door trim panel			
Oval-head screw M4x10		Tightening torque	2,0Nm



5143 Overview of tightening torques

A-pillar footwell side trim panel			
Screw		Tightening torque	2,5Nm
A-pillar trim panel to body			
Sheet metal screw 4,8x38		Tightening torque	2,6Nm
Armrest to side trim panel			
Screw		Tightening torque	1,8Nm
C-pillar trim panel to body			
Screw		Tightening torque	2,6Nm



5144 Overview of tightening torques

Headlining to frame		
Oval-head screw	Tightening torque	1,5Nm

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5145 Overview of tightening torques

Dashboard to support		
Screw	Tightening torque	2,4Nm
Support for instrument panel		
M8 hexagon nut	Tightening torque	21Nm
Hexagon screw	Tightening torque	21Nm

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5146 Overview of tightening torques

Mounting dome for parcel shelf		
Mounting dome	Tightening torque	3,6Nm

Screen trim mounting		
Sheet metal screw 4.8 x 16	Tightening torque	2Nm

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5147 Overview of tightening torques

Oddments tray on body		
Plastic nut		3Nm
Storage compartment/fixture on body		
Nut	Tightening torque	2.5Nm
Underbody protection front		
Hexagon screw for thermoplastic	Tightening torque	2,6Nm
Hexagon screw M6x20	Tightening torque	8Nm

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5161 Overview of tightening torques

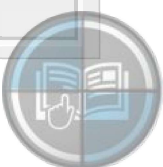
Cross-brace to bulkhead		
Hexagon screw M10x25 Renew screws.	Tightening torque	56Nm
	Angle of rotation	90°
Cross-brace to spring strut dome		
Hexagon screw M10x55 Renew screws.	Tightening torque	56Nm
	Angle of rotation	90°

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5164 Overview of tightening torques

Adapter to the front panel		
Oval-head screw with spring washer	Tightening torque	4Nm
Air flap control to front end		
Oval-head screw with spring washer	Tightening torque	4Nm
Bottom air flap control on top bumper panel support		
Oval-head screw	Tightening torque	4,6Nm
Bracing strut on cross connection and bumper support		
Hexagon screw M8	Tightening torque	28Nm
Cross connection, top		
M8x20	Tightening torque	28Nm
Cross connection, top		
M6x20	Tightening torque	11,8Nm
Front cross connection on the tailgate lock support		
Combination oval-head machine screw	Tightening torque	28Nm
Front end strut		
Screw	Tightening torque	56Nm
Holder to support		
M6x20	Tightening torque	8Nm
Rear top cross connection to wheel arch carrier support		
M10x20 screw Renew screw.	Jointing torque	56Nm
	Angle of rotation	90°
Strut on front end		
Hexagon screw	Tightening torque	28Nm



Top rear cross connection to bonnet catch support

Flat-head screw M6x20

Tightening torque

11,8Nm

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5171 Overview of tightening torques

Bulkhead lower part to body		
Screw	Tightening torque	2,6Nm
Plastic nut	Tightening torque	2,6Nm
Bulkhead upper part to bottom bulkhead		
	Tightening torque	3Nm
Connecting support to tunnel		
M8x25 screw	Tightening torque	20Nm
Screw	Tightening torque	3Nm
Cover, front bottom on side		
Hexagon screw for thermoplastic	Tightening torque	3Nm
Cover, steering unit		
Screw	Tightening torque	3Nm
Rear wheel arch cover to bumper trim panel		
Hexagon screw	Tightening torque	2,6Nm
Tension strut on bulkhead		
M10x25 screw	Tightening torque	56Nm
Tension strut to spring strut dome		
Screw Renew screws.	Jointing torque	56Nm
	Angle of rotation	90°
Wheel arch cover		
Screw		3Nm
Plastic nut		2,6Nm
Wheel arch cover (screws)		
Thermoplastic hexagon screw	Tightening torque	3Nm



Wheel arch trim panel, front

Thermoplastic hexagon screw

Tightening torque

2,6Nm

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5174 Overview of tightening torques

Brake air duct to front wheel arch cover of front section		
Hexagon screw for thermoplastic	Tightening torque	2,6Nm

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5175 Overview of tightening torques

Diffuser / underbody panelling		
Nuts and screws	Tightening torque	3Nm
Retaining plates for vehicle underbody cover		
Sheet metal nut/plastic nut Renew nuts.	Tightening torque	3Nm
Underbody panelling		
Screw	Tightening torque	2,6Nm
Plastic nut	Tightening torque	2,6Nm
Underbody panelling on body		
Plastic nut	Tightening torque	2,6Nm
Underbody panelling on body		
Hexagon screw	Tightening torque	2,6Nm
Underbody panelling, side		
Hexagon screw	Tightening torque	2.6Nm
Plastic nut	Tightening torque	2.6Nm
Underbody protection		
Hexagon screw	Tightening torque	3Nm
Underbody protection of the steering gear		
Hexagon screw for thermoplastic	Tightening torque	2.6Nm
Hexagon bolt M6x20	Tightening torque	8Nm



51 operating fluid overview

Expendable materials

Yellow plastic adhesive tape		83199410979
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Expendable materials

Adhesive tape, double-sided		54112290978
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Expendable materials

Cutting cord		81432344272
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Expendable materials

Cleaning agent R1	100 ml, Bottle	83192211217
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Expendable materials

Cleaning agent R2	500 ml	83190417324
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Adhesive

Window glass adhesive Rest of World	300 ml, Cartridge	83192289286
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Adhesive

Window glass adhesive USA	300 ml, Cartridge	83192289181
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Adhesive

Window glass adhesive CHN	300 ml, Cartridge	83192180002
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Expendable materials

Cutting wire for glass repair		83192150267
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Expendable materials

Self-adhesive felt strip set		52202697913
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Adhesive

Window glass adhesive (security vehicle) SIKA Flex 265	300 ml, Cartridge	
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Expendable materials

Isopropanol 70820 cleaning agent		
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Expendable materials

SIKA Primer 206 G+P		
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Expendable materials

SIKA Aktivator 100	
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Adhesive

Sika Flex 265 adhesive SIKA Flex 265	300 ml, Cartridge	
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Expendable materials

Washer Ø 6.4 x Ø 25 x 1.5		07146977329
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Expendable materials

Repair screw Delta PT4	Ø4 mm, l = 12 mm,	07149200941
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Expendable materials

Repair screw Delta PT4	Ø4 mm, l = 20 mm,	07149185673
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Expendable materials

Repair screw TS5	Ø5 mm, l = 16 mm,	51417067920
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Expendable materials

Repair screw TS6	Ø6 mm, l = 10 mm,	07147118369
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Expendable materials

Repair screw Torx	Ø3,3 mm, l = 5 mm,	07147305240
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Expendable materials

Repair screw PT5	Ø5 mm, l = 15,5 mm,	07147220383
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Expendable materials

Lock washer	Außendurchmesser: 11,5 mm, Wellendurchmesser: 4 mm,	64118247773
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Expendable materials

Lock washer	Außendurchmesser: 16 mm, Wellendurchmesser: 6 mm,	52207115704
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Expendable materials

Lock washer	Außendurchmesser: 20,5 mm, Wellendurchmesser: 6 mm,	07147295776
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Expendable materials

Lock washer	Außendurchmesser: 12,6 mm, Wellendurchmesser: 8 mm,	07149459832
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Expendable materials

Lock washer	Außendurchmesser: 25,3 mm, Wellendurchmesser: 10 mm,	07149889983
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Expendable materials

Clip	Schlitz 5,5 x 1,5 mm,	07147243883
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Expendable materials

Clip	Schlitz 7,8 x 0,6 mm,	51417464302
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Expendable materials

Clip	Schlitz 14 x 1,2 mm,	07149241763
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Expendable materials

Clip	Schlitz 13,5 x 0,7 mm,	07147464307
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Adhesive

Plastic repair adhesive SF	50 ml	51910446011
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