

## Contents

<b>00 - Materials</b> .....	<b>1</b>
<b>1 Safety briefing/employee qualification</b> .....	<b>1</b>
1.1 Qualification .....	1
<b>2 Safety precautions</b> .....	<b>2</b>
2.1 Safety precautions .....	2
2.2 Safety precautions when working on the cooling system .....	4
2.3 Safety precautions when using testers and measuring instruments during a road test .....	4
<b>3 Repair instructions</b> .....	<b>5</b>
3.1 Important notes .....	5
3.2 General notes .....	5
3.3 Information on handling fine dust, aluminium dust and steel dust .....	6
3.4 Routing and attachment of pipes, hoses and wiring .....	6
3.5 Contact corrosion .....	7
3.6 Bonding surfaces for adhesive strips .....	7
3.7 Self-locking bolts .....	7
3.8 Identification plates .....	7
3.9 Impact wrenches .....	7
3.10 Bonded joints .....	8
3.11 Matching the surface contour .....	9
<b>4 Tools</b> .....	<b>11</b>
4.1 Using edge milling unit -VAS 882 005- .....	16
<b>50 - Body - front</b> .....	<b>48</b>
<b>1 Safety precautions</b> .....	<b>48</b>
<b>2 Intermediate piece - Partial renewal</b> .....	<b>49</b>
2.1 Procedure .....	49
<b>3 Upper wheel housing longitudinal member - Renewal</b> .....	<b>51</b>
3.1 Procedure .....	51
<b>4 Front longitudinal member - Partial renewal</b> .....	<b>53</b>
4.1 Procedure .....	53
<b>5 Front longitudinal member - Renewal</b> .....	<b>55</b>
5.1 Procedure .....	55
<b>51 - Body - centre</b> .....	<b>59</b>
<b>1 Safety precautions</b> .....	<b>59</b>
<b>2 Outer roof frame - Renewal</b> .....	<b>60</b>
2.1 Procedure .....	60
<b>3 Side frame - Renewal</b> .....	<b>63</b>
3.1 Procedure .....	63
<b>4 A-pillar - Renewal</b> .....	<b>66</b>
4.1 Procedure .....	66
<b>5 Reinforcement tube - Renewal</b> .....	<b>69</b>
5.1 Procedure .....	69
<b>6 Outer side member - Renewal</b> .....	<b>71</b>
6.1 Procedure .....	71
<b>7 Floor panel - Partial renewal</b> .....	<b>74</b>
7.1 Procedure .....	74
<b>53 - Body - rear</b> .....	<b>76</b>
<b>1 Safety precautions</b> .....	<b>76</b>



<b>2</b>	<b>Rear upper cross panel - Renewal</b> .....	<b>77</b>
2.1	Procedure .....	77
<b>3</b>	<b>Inner cross panel - Renewal</b> .....	<b>79</b>
3.1	Procedure .....	79
<b>4</b>	<b>Rear cross panel - Renewal</b> .....	<b>81</b>
4.1	Procedure .....	81
<b>5</b>	<b>Tail light mounting - Renewal</b> .....	<b>83</b>
5.1	Procedure .....	83
<b>6</b>	<b>Side panel - Renewal</b> .....	<b>85</b>
6.1	Procedure .....	85
<b>7</b>	<b>Rear wheel housing - Renewal</b> .....	<b>88</b>
7.1	Procedure .....	88