



## Contents

<b>00 - Technical data</b>	<b>1</b>
<b>1 Basic instructions</b>	<b>1</b>
1.1 Original joint	1
1.2 Used joining techniques	1
<b>2 Vehicle identification data</b>	<b>2</b>
2.1 Vehicle identification number	2
2.2 Type plate	3
2.3 Vehicle data sticker	4
<b>3 Safety information</b>	<b>6</b>
<b>4 Moulded foam inserts</b>	<b>7</b>
<b>5 Galvanized body parts, high- and higher-strength and hot-formed body panels</b>	<b>9</b>
<b>6 Laser welding</b>	<b>12</b>
<b>7 Gaps/shut lines</b>	<b>13</b>
7.1 Body - front	13
7.2 Body, centre	17
7.3 Body, rear	20
<b>8 Body dimensions</b>	<b>23</b>
8.1 Body - front	23
8.2 Body, centre	24
8.3 Body, rear	29
8.4 Floor panel, front	30
8.5 Floor panel, centre	31
8.6 Floor panel, rear	32
<b>9 Straightening bracket set</b>	<b>34</b>
9.1 Setup overview of complete body	34
<b>10 Portal gauge</b>	<b>36</b>
10.1 Setup overview of complete body	36
<b>50 - Body - front</b>	<b>38</b>
<b>1 Renewing right bracket</b>	<b>38</b>
1.1 Tools	38
1.2 Removing	38
1.3 Installing	40
<b>2 Repairing threads for securing subframe</b>	<b>43</b>
2.1 Contents of thread repair kit	44
2.2 Repairing threads	45
<b>3 Renewing mounting bracket for subframe</b>	<b>49</b>
3.1 Tools	50
3.2 Removing	50
3.3 Installing	51
<b>4 Renewing front bumper carrier</b>	<b>55</b>
4.1 Tools	56
4.2 Removing	56
4.3 Installing	57
<b>5 Renewing upper wheel housing longitudinal member</b>	<b>60</b>
5.1 Tools	61
5.2 Removing	61
5.3 Installing	62
<b>6 Renewing upper inner wheel housing longitudinal member</b>	<b>67</b>
6.1 Tools	68



6.2	Removing	68
6.3	Installing	70
<b>7</b>	<b>Renewing front wheel housing</b>	<b>74</b>
7.1	Tools	75
7.2	Removing	75
7.3	Installing	78
<b>8</b>	<b>Renewing front longitudinal member</b>	<b>82</b>
8.1	Tools	83
8.2	Removing	83
8.3	Installing	84
<b>9</b>	<b>Renewing front longitudinal member (left part section)</b>	<b>88</b>
9.1	Tools	89
9.2	Removing	89
9.3	Installing	91
<b>10</b>	<b>Renewing front longitudinal member (right part section)</b>	<b>97</b>
10.1	Tools	98
10.2	Removing	98
10.3	Installing	100
<b>51 - Body - centre</b>		<b>105</b>
<b>1</b>	<b>Renewing roof - vehicles with no panorama tilting sunroof</b>	<b>105</b>
1.1	Tools	106
1.2	Removing	107
1.3	Installing	109
<b>2</b>	<b>Renewing roof - vehicles with panorama tilting sunroof</b>	<b>120</b>
2.1	Tools	121
2.2	Removing	121
2.3	Installing	123
<b>3</b>	<b>Renewing A-pillar</b>	<b>134</b>
3.1	Tools	135
3.2	Removing	136
3.3	Installing	137
<b>4</b>	<b>Renewing A-pillar reinforcement (part section)</b>	<b>142</b>
4.1	Tools	143
4.2	Removing	143
4.3	Installing	146
<b>5</b>	<b>Renewing upper A-pillar reinforcement (part section)</b>	<b>150</b>
5.1	Tools	151
5.2	Removing	152
5.3	Installing	154
<b>6</b>	<b>Renewing B-pillar</b>	<b>163</b>
6.1	Tools	165
6.2	Type plate	165
6.3	Removing	166
6.4	Installing	168
<b>7</b>	<b>Renewing B-pillar reinforcement</b>	<b>173</b>
7.1	Tools	174
7.2	Type plate	174
7.3	Removing	175
7.4	Installing	177
<b>8</b>	<b>Renewing B-pillar reinforcement (part section)</b>	<b>181</b>
8.1	Tools	182
8.2	Removing	183
8.3	Installing	186



<b>9</b>	<b>Renewing outer side member</b>	<b>193</b>
9.1	Tools	194
9.2	Type plate	194
9.3	Removing	195
9.4	Installing	197
<b>10</b>	<b>Renewing gusset plate</b>	<b>202</b>
10.1	Tools	202
10.2	Removing	202
10.3	Installing	204
<b>53 - Body - rear</b>		<b>207</b>
<b>1</b>	<b>Renewing rear cross panel</b>	<b>207</b>
1.1	Tools	208
1.2	Removing	208
1.3	Installing	210
<b>2</b>	<b>Renewing rear cross member</b>	<b>214</b>
2.1	Tools	215
2.2	Removing	215
2.3	Installing	216
<b>3</b>	<b>Renewing luggage compartment floor</b>	<b>221</b>
3.1	Tools	222
3.2	Removing	222
3.3	Installing	224
<b>4</b>	<b>Renewing rear longitudinal member (part section)</b>	<b>229</b>
4.1	Tools	230
4.2	Removing	230
4.3	Installing	232
<b>5</b>	<b>Renewing rear longitudinal member (second parting cut - part section)</b>	<b>236</b>
5.1	Tools	237
5.2	Removing	237
5.3	Installing	241
<b>6</b>	<b>Renewing side panel (part section)</b>	<b>252</b>
6.1	Removing	254
6.2	Installing	257
<b>7</b>	<b>Renewing outer wheel housing liner</b>	<b>263</b>
7.1	Tools	264
7.2	Removing	264
7.3	Installing	265