



Contents

00 - Technical data	1
1 Vehicle identification data	1
1.1 Vehicle identification number	1
1.2 Type plate	2
1.3 Vehicle data sticker	3
2 Safety information	5
3 Basic instructions	6
3.1 Original joint	6
3.2 Used joining techniques	6
4 Moulded foam inserts	7
5 Galvanized body parts, high- and higher-strength and hot-formed body panels	9
6 Laser welding	13
7 Gaps/shut lines	14
7.1 Body - front	14
7.2 Body, centre	18
7.3 Body, rear	21
8 Body dimensions	24
8.1 Body - front	24
8.2 Body, centre	25
8.3 Body, rear	30
8.4 Floor panel, front	31
8.5 Floor panel, centre	32
8.6 Floor panel, rear	33
9 Straightening bracket set	35
9.1 Setup overview of complete body	35
10 Portal gauge	37
10.1 Setup overview of complete body	37
50 - Body - front	39
1 Overview of parts	39
2 Renewing right bracket	40
2.1 Tools	40
2.2 Removing	40
2.3 Installing	42
3 Repairing threads for securing subframe	45
3.1 Contents of thread repair kit	46
3.2 Repairing threads	47
4 Renewing mounting bracket for subframe	51
4.1 Tools	52
4.2 Removing	52
4.3 Installing	53
5 Renewing front bumper carrier	56
5.1 Tools	57
5.2 Removing	57
5.3 Installing	58
6 Renewing upper wheel housing longitudinal member	61
6.1 Tools	62
6.2 Removing	62
6.3 Installing	63
7 Renewing upper inner wheel housing longitudinal member	67



7.1	Tools	68
7.2	Removing	68
7.3	Installing	70
8	Renewing front wheel housing	74
8.1	Tools	75
8.2	Removing	75
8.3	Installing	77
9	Renewing front longitudinal member	81
9.1	Tools	82
9.2	Removing	82
9.3	Installing	83
10	Renewing front longitudinal member (left part section)	87
10.1	Tools	88
10.2	Removing	88
10.3	Installing	90
11	Renewing front longitudinal member (right part section)	96
11.1	Tools	97
11.2	Removing	97
11.3	Installing	99
12	Renewing studs	103
51 - Body - centre		104
1	Overview of parts	104
2	Renewing roof - vehicles with no panorama tilting sunroof	105
2.1	Tools	106
2.2	Removing	106
2.3	Installing	109
3	Renewing roof - vehicles with panorama tilting sunroof	119
3.1	Tools	120
3.2	Removing	120
3.3	Installing	123
4	Renewing front cross member for roof	133
4.1	Tools	134
4.2	Removing	134
4.3	Installing	135
5	Renewing rear roof cross member	139
5.1	Tools	140
5.2	Removing	140
5.3	Installing	141
6	Renewing roof side member	145
6.1	Tools	146
6.2	Removing	147
6.3	Installing	148
7	Renewing A-pillar	153
7.1	Tools	154
7.2	Removing	155
7.3	Installing	156
8	Renewing A-pillar reinforcement (part section)	161
8.1	Tools	162
8.2	Removing	162
8.3	Installing	165
9	Renewing upper A-pillar reinforcement (part section)	168
9.1	Tools	169



9.2	Removing	169
9.3	Installing	172
10	Renewing B-pillar	181
10.1	Tools	183
10.2	Type plate	183
10.3	Removing	184
10.4	Installing	186
11	Renewing B-pillar reinforcement	190
11.1	Tools	191
11.2	Type plate	191
11.3	Removing	192
11.4	Installing	194
12	Renewing B-pillar reinforcement (part section)	198
12.1	Tools	199
12.2	Type plate	199
12.3	Removing	200
12.4	Installing	204
13	Renewing inner B-pillar - part section	211
13.1	Tools	212
13.2	Removing	212
13.3	Installing	213
14	Renewing outer side panel - part section	217
14.1	Tools	218
14.2	Type plate	218
14.3	Removing	219
14.4	Installing	220
15	Renewing side member reinforcement	225
15.1	Tools	226
15.2	Removing	226
15.3	Installing	227
16	Renewing end plate for wing	231
16.1	Tools	232
16.2	Removing	232
16.3	Installing	234
53 - Body - rear		238
1	Overview of parts	238
2	Renewing rear cross panel	239
2.1	Tools	240
2.2	Removing	240
2.3	Installing	241
3	Renewing rear cross member	245
3.1	Tools	246
3.2	Removing	246
3.3	Installing	247
4	Renewing luggage compartment floor	251
4.1	Tools	252
4.2	Removing	252
4.3	Installing	254
5	Renewing luggage compartment floor, vehicles with hybrid drive	258
5.1	Tools	259
5.2	Moulded foam inserts	259
5.3	Removing	259
5.4	Installing	261



6	Renewing rear longitudinal member (part section)	265
6.1	Tools	266
6.2	Removing	266
6.3	Installing	267
7	Renewing rear longitudinal member (second parting cut - part section)	271
7.1	Tools	272
7.2	Removing	272
7.3	Installing	275
8	Renewing side panel (part section)	286
8.1	Tools	288
8.2	Removing	288
8.3	Installing	290
9	Renewing tail light mounting	296
9.1	Tools	297
9.2	Removing	297
9.3	Installing	298
10	Renewing outer wheel housing liner	302
10.1	Tools	303
10.2	Removing	303
10.3	Installing	304
11	Renewing C-pillar reinforcement	308
11.1	Tools	309
11.2	Removing	309
11.3	Installing	310