



Contents

00 - Technical data	1
1 Basic instructions	1
1.1 Original joint	1
1.2 Used joining techniques	1
2 Vehicle identification data	2
2.1 Vehicle identification number	2
2.2 Identification plate	4
2.3 Vehicle data sticker	5
3 Safety information	6
4 Moulded foam inserts	7
5 Galvanized body parts, high- and higher-strength and hot-formed body panels	9
6 Laser welding	12
7 Gaps/shut lines	13
7.1 Front body	13
7.2 Body, centre	15
7.3 Body - rear	18
8 Body dimensions	20
8.1 Front body	20
8.2 Body, centre	22
8.3 Body - rear	27
8.4 Floor panel - front	28
8.5 Floor panel - centre	29
8.6 Floor panel - rear	30
9 Alignment bracket set	31
9.1 Setup overview of complete body	31
10 Portal gauge	33
10.1 Setup overview of complete body	33
50 - Body - front	35
1 Overview of parts	35
2 Renewing right bracket	36
2.1 Tools	37
2.2 Removing	37
2.3 Installing	38
3 Repairing threads for securing subframe	41
3.1 Contents of thread repair kit	42
3.2 Repairing threads	42
4 Renewing mounting bracket for subframe	46
4.1 Tools	47
4.2 Removing	47
4.3 Installing	48
5 Renewing cross panel for front longitudinal member	52
5.1 Tools	53
5.2 Removing	53
5.3 Installing	54
6 Renewing upper wheel housing longitudinal member	57
6.1 Tools	58
6.2 Removing	58
6.3 Installing	59
7 Renewing upper inner wheel housing longitudinal member	63



7.1	Tools	64
7.2	Removing	64
7.3	Installing	65
8	Renewing front wheel housing	68
8.1	Tools	69
8.2	Removing	69
8.3	Installing	71
9	Renewing front longitudinal member	76
9.1	Tools	77
9.2	Removing	77
9.3	Installing	78
10	Renewing front longitudinal member (left part section)	82
10.1	Tools	83
10.2	Removing	83
10.3	Installing when using complete longitudinal member assembly	85
10.4	Installing when using individual components of longitudinal member	89
11	Renewing front longitudinal member (right part section)	92
11.1	Tools	93
11.2	Removing	93
11.3	Installing when using complete longitudinal member assembly	95
11.4	Installing when using individual components of longitudinal member	99
12	Renewing studs	102
51 - Body - centre		103
1	Overview of parts	103
2	Renewing roof - vehicles with no panorama tilting sunroof	104
2.1	Tools	105
2.2	Removing	105
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 A-pillar	132
4.1	Tools	133
4.2	Moulded foam inserts	134
4.3	Removing	134
4.4	Installing	135
5	Renewing upper A-pillar reinforcement (part section)	140
5.1	Tools	141
5.2	Moulded foam inserts	141
5.3	Removing	141
5.4	Installing	144
6	Renewing lower A-pillar reinforcement (part section)	154
6.1	Tools	155
6.2	Moulded foam inserts	155
6.3	Removing	155
6.4	Installing	156
7	Renewing B-pillar	160
7.1	Tools	161
7.2	Identification plate	161
7.3	Moulded foam inserts	162
7.4	Removing	162
7.5	Installing	163



8	Renewing B-pillar reinforcement	168
8.1	Tools	169
8.2	Identification plate	169
8.3	Moulded foam inserts	170
8.4	Removing	170
8.5	Installing	171
9	Renewing B-pillar reinforcement (part section)	177
9.1	Tools	178
9.2	Identification plate	178
9.3	Moulded foam inserts	179
9.4	Removing	179
9.5	Installing	182
10	Renewing outer side member	191
10.1	Tools	192
10.2	Identification plate	193
10.3	Moulded foam inserts	194
10.4	Removing	194
10.5	Installing	195
11	Renewing side member cover plate	200
11.1	Tools	201
11.2	Removing	201
11.3	Installing	202
53 - Body - rear		206
1	Overview of parts	206
2	Renewing rear cross panel	207
2.1	Tools	208
2.2	Removing	208
2.3	Installing	212
3	Renewing cross panel member	218
3.1	Tools	219
3.2	Removing	219
3.3	Installing	220
4	Renewing lower corner part	225
4.1	Tools	226
4.2	Removing	226
4.3	Installing	227
5	Renewing luggage compartment floor	231
5.1	Tools	232
5.2	Moulded foam inserts	232
5.3	Removing	232
5.4	Installing	234
6	Renewing rear longitudinal member (part section)	237
6.1	Tools	238
6.2	Moulded foam inserts	238
6.3	Removing	238
6.4	Installing	240
7	Renewing rear longitudinal member (part section – second parting cut)	244
7.1	Tools	245
7.2	Moulded foam inserts	245
7.3	Removing	245
7.4	Installing	251
8	Permitted parting cuts on side panel	266
9	Renewing side panel (part section)	267



9.1	Tools	268
9.2	Moulded foam inserts	269
9.3	Removing	269
9.4	Installing	271