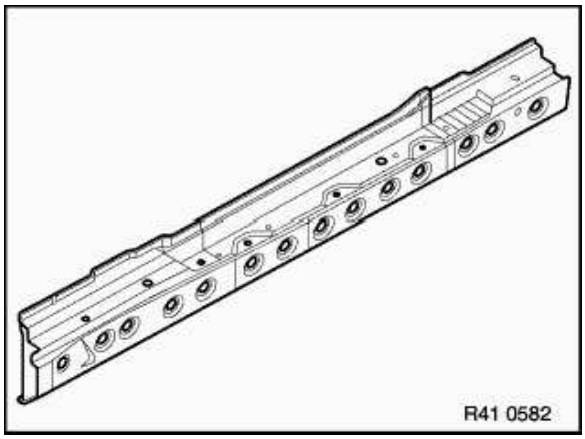
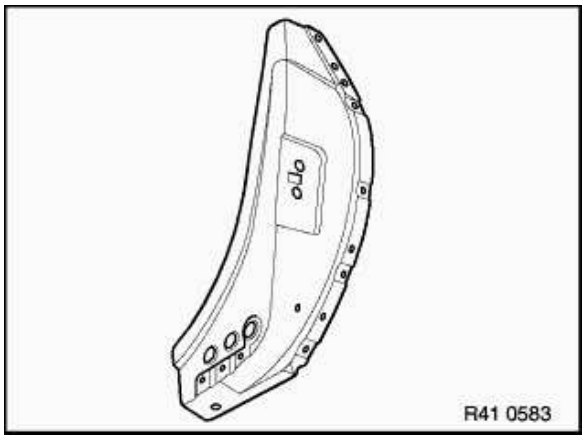
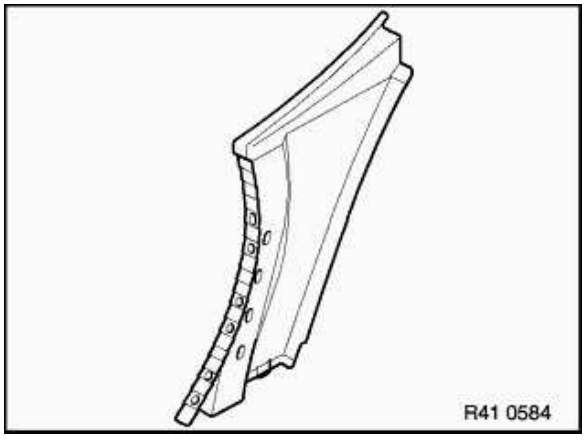


This replacement operation involves the following components:

Side member cover



Outer B-pillar



Front side section on B-pillar

Note:

In the following operation, the vehicle is shown on a straightening bench. This is not essential for performing this operation.

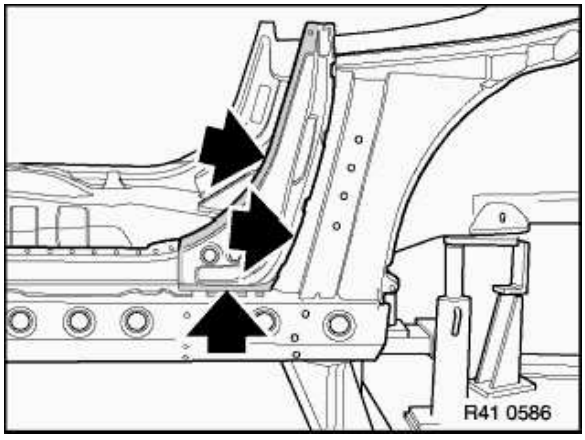
Instructions on body repair,

refer to 41 00

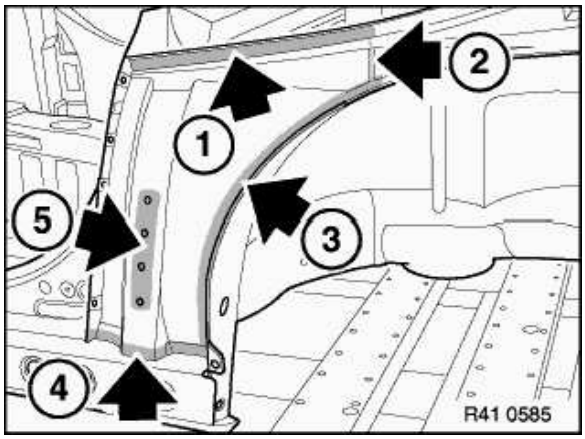
Remove or disconnect following parts:

- Complete left tension strut
- Complete rear oddments box
- B-pillar upper and lower trim panel
- Carpet (partial)
- Complete convertible top
- Rear side panel

Other vehicle parts located in the repair zone or subject to damage from heat, sparks or dust, must be removed or covered.



Drill out welding points on outer B-pillar.



Expose and open up welding points and welding seams on side section for front of B-pillar at the following connection points:

1 = Convertible top box

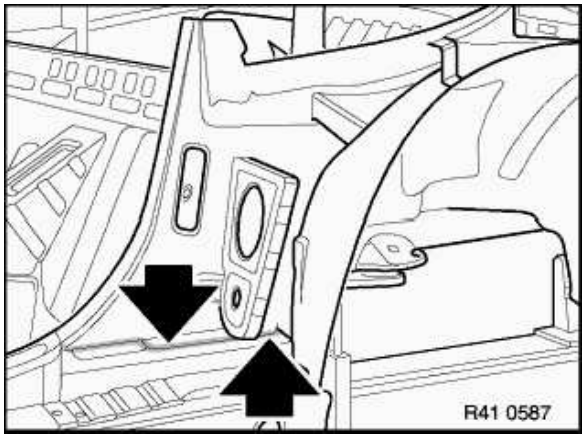
2 = Side section at rear of B-pillar (brazed seam)

3 = Wheel arch, outside rear

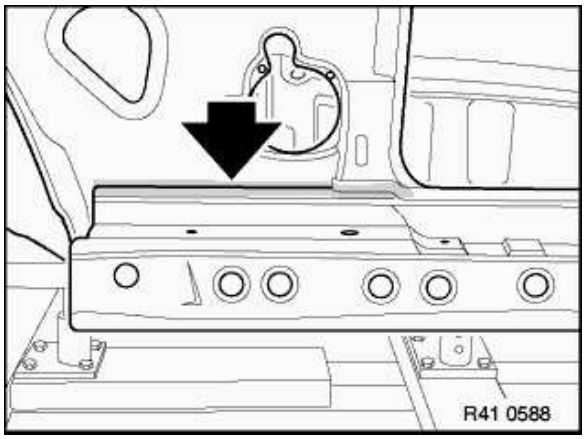
4 = Side member cover

5 = Reinforcement B-pillar

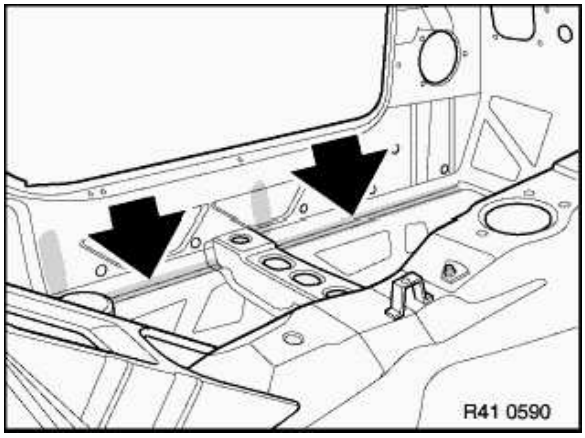
Remove B-pillar, front outer and side section.



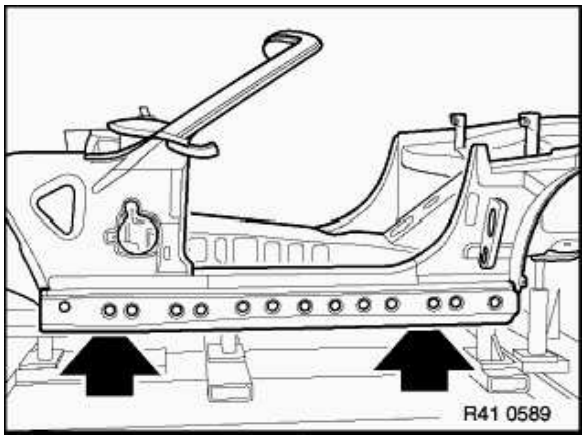
Open welding seams on cover for side member on inside of B-pillar.



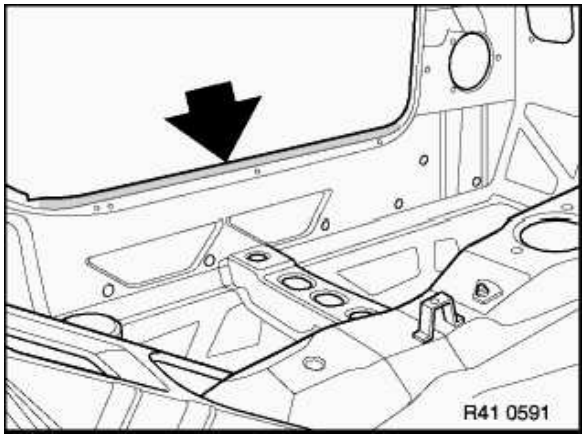
Open inner welding seams of cover for side member on inside of A-pillar.



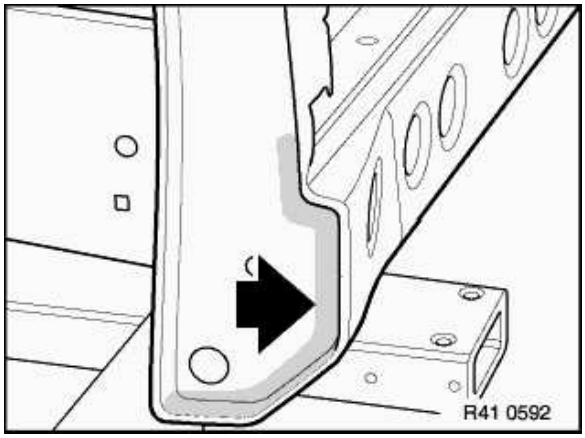
Expose welding points inside vehicle and drill out.



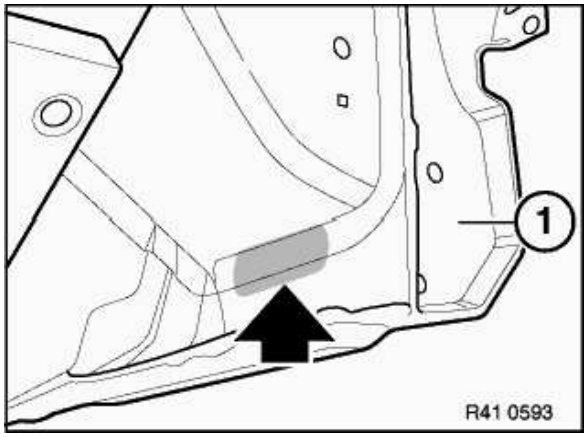
Drill out connection point on underbody and drill out welding points which are not accessible from the interior.



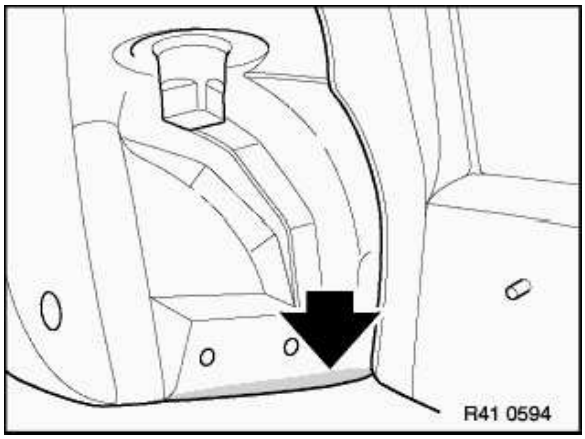
Drill out welding points on door opening.



Expose and drill out front closing plate connection.



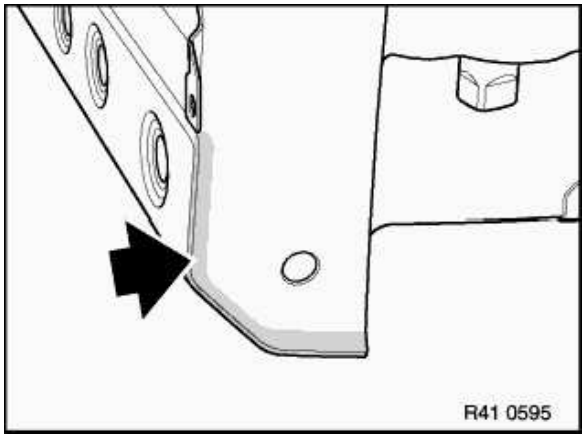
Expose and drill out connection in cover between side member/engine support on front endplate (1).



Expose and drill out welding points on cover for side member on rear wheel arch.

Note:

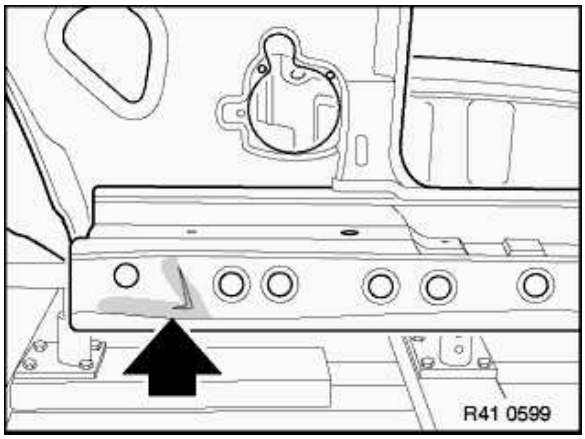
To illustrate more clearly, shown with rear axle removed.



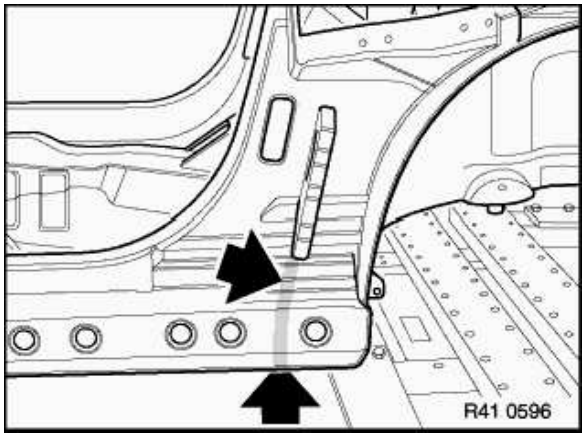
Expose and drill out connection for rear closing plate.

Note:

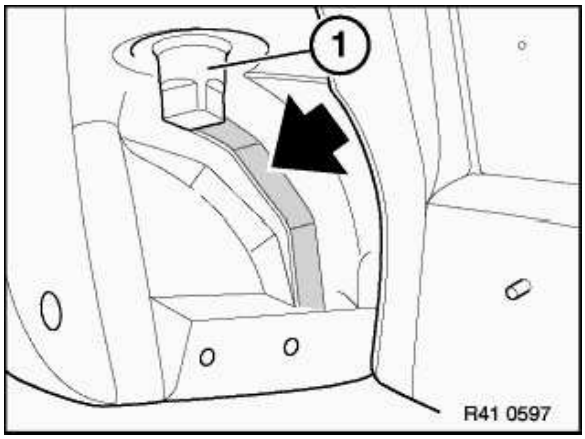
To illustrate more clearly, shown with rear axle removed.



Cut away connection for front reinforcement plate on side member cover at joint between A-pillar/engine support.



Roughly cut out connection at rear for reinforcement cover of side member on jacking point support.



Remove side member cover.

After cutting it out roughly, remove reinforcement cover for side member from back of jacking point support.

Drill right through welding points when opened to ensure that holes for plug of new part are perfectly positioned. It is very time-consuming to scribe out and drill new parts at a later time.

Clean connection point around support on rear axle (1).

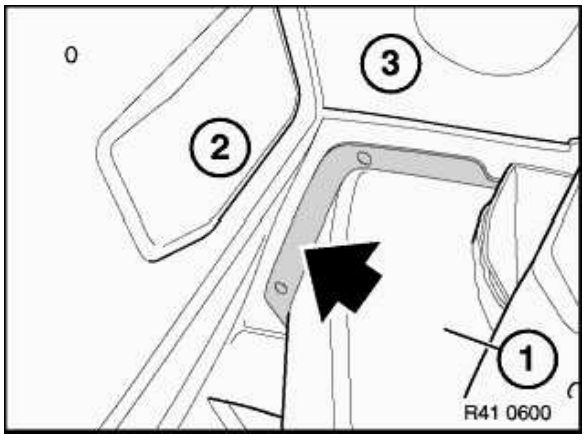
Remove scrap metal. Straighten and grind joint surfaces.

Note:

To illustrate more clearly, shown with rear axle removed.

Remove cut away reinforcement from front of connection between A-pillar/engine support.

Drill right through welding points when opened to ensure that holes for plug of new part are perfectly positioned. It is very time-consuming to scribe out and drill new parts at a later time.



Clean A-pillar/engine support connection.

Note:

View from above:

1 = A-pillar/engine support connection

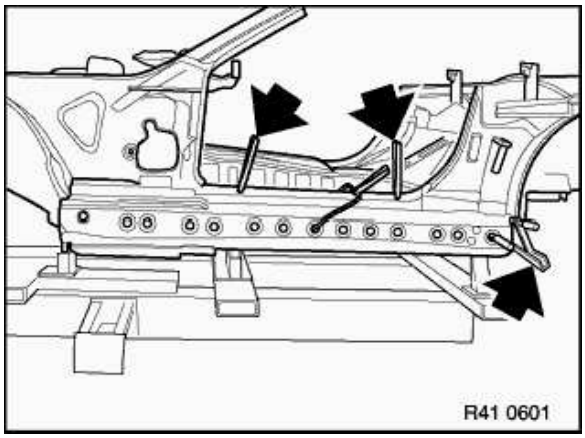
2 = End wall

3 = Inner A-pillar

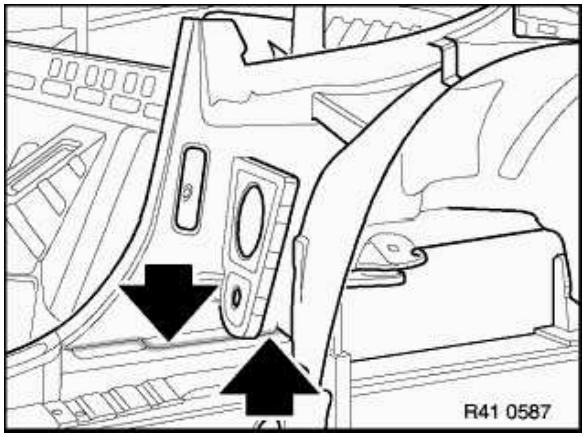
Remove scrap metal. Straighten and grind joint surfaces.

Clean spare part connection points and coat with zinc dust paint.

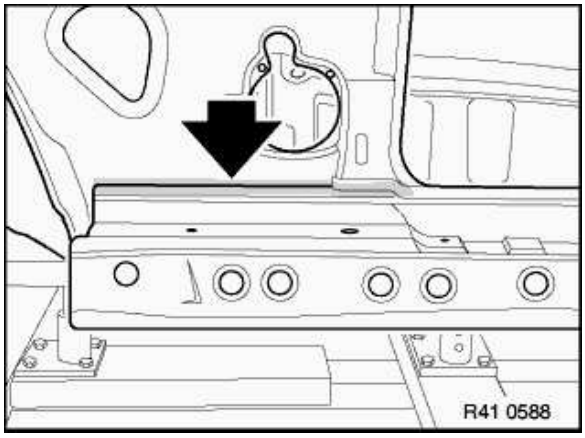
Clean vehicle connection points and coat with zinc dust paint.



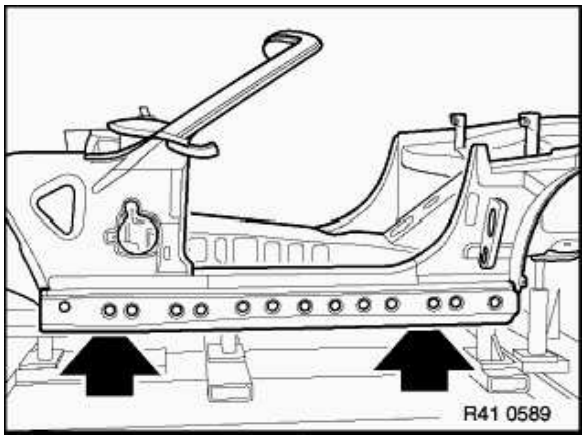
Align and secure spare part.



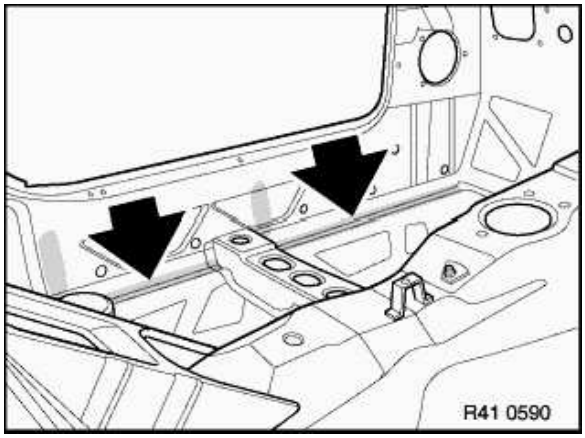
Weld cover for side member on inner B-pillar.



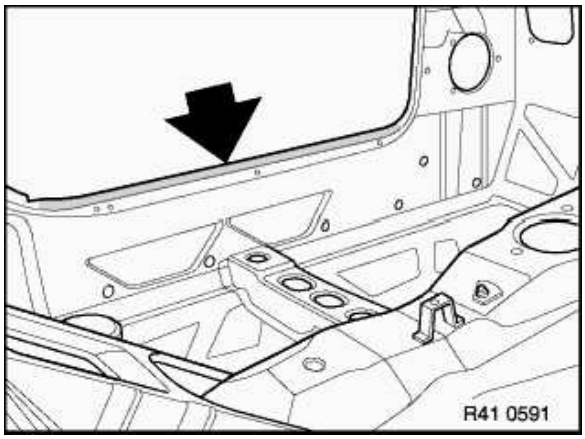
Weld cover for side member on inner A-pillar.



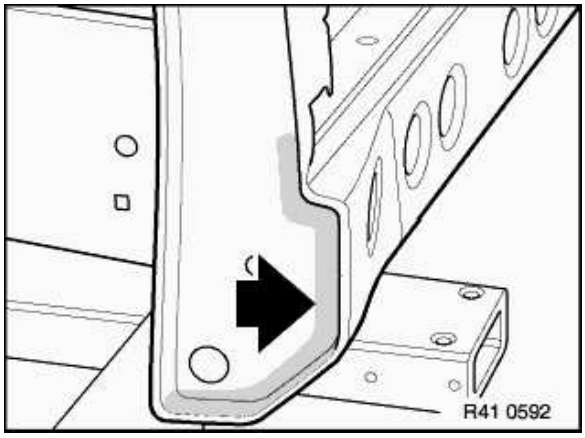
Weld cover for side member on underbody.



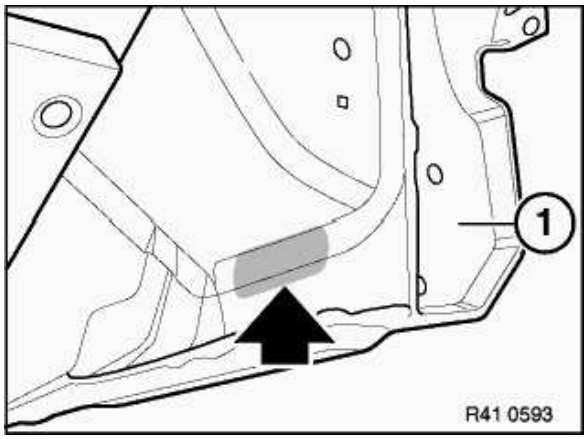
Weld cover for interior side member.



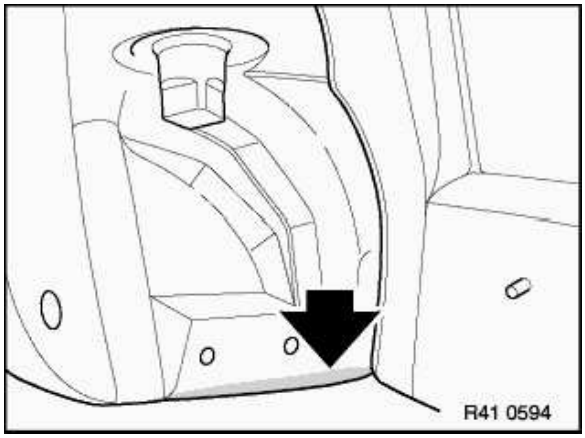
Weld cover for side member on door opening.



Weld front endplate connection.



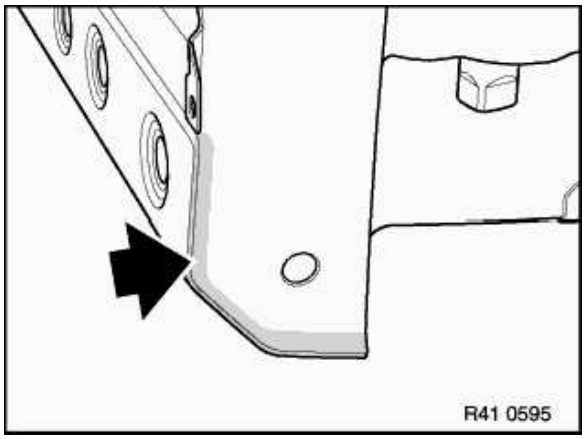
Weld connection in cover of side member/engine support on front endplate (1).



Weld cover for side member on rear wheel arch.

Note:

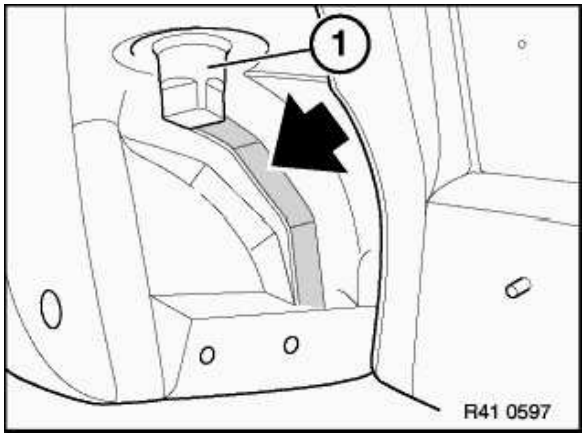
To illustrate more clearly, shown with rear axle removed.



Weld connection for rear closing plate.

Note:

To illustrate more clearly, shown with rear axle removed.



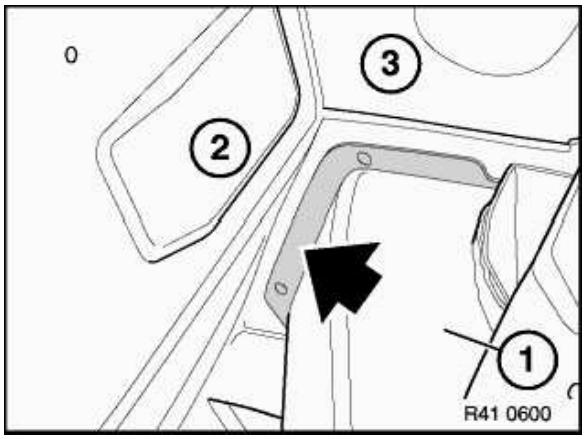
Grind down reinforcement cover for side member on rear jack support.

1 = Connection point support on rear axle

Note:

To illustrate more clearly, shown without rear axle.

Grind down other connection points.



Grind down A-pillar/engine support connection points.

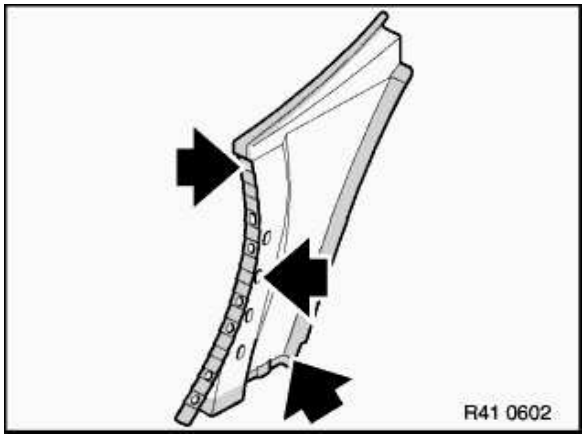
Note:

View from above:

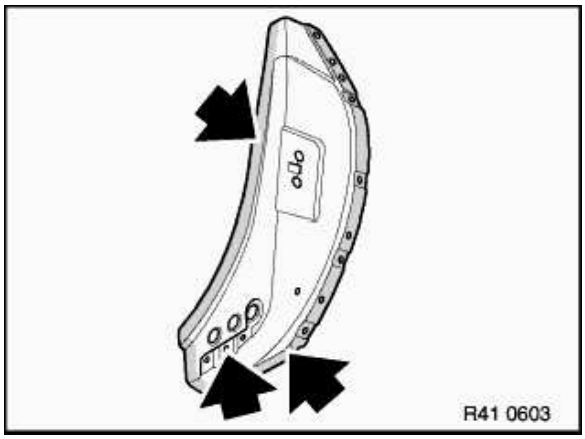
1 = A-pillar/engine support connection

2 = End wall

3 = Inner A-pillar



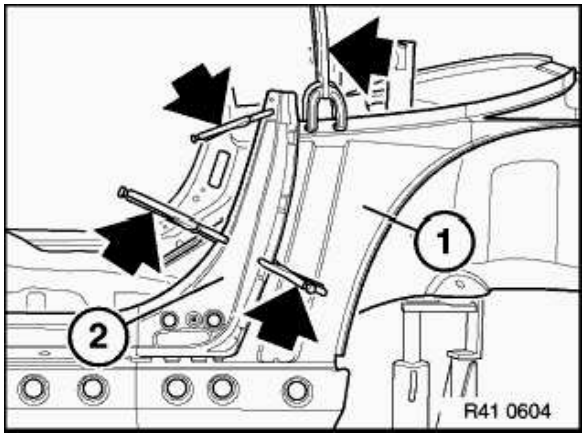
Clean connection points on front side section on B-pillar.



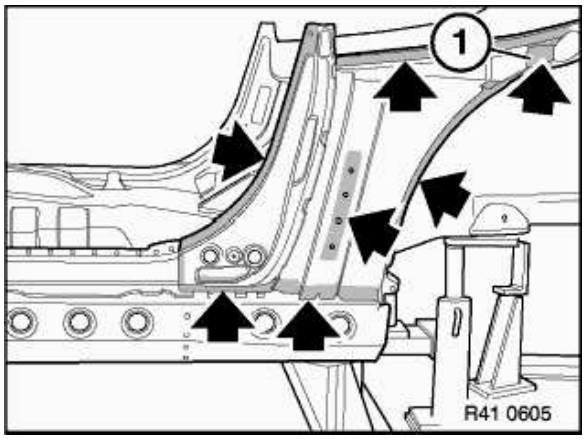
Clean connection points on outer B-pillar.

Coat connection points on front side section on B-pillar and outer B-pillar with zinc dust paint.

Coat connection points on vehicle with zinc dust paint.



Adjust front side section of B-pillar (1) to fit outer B-pillar (2) and secure.



Weld connection points.
Set in area of (1) brazed seam.
Grind down connection points.