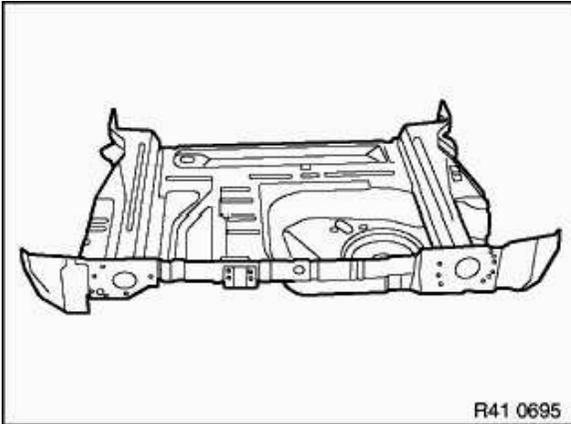


Instructions on body repair,  
refer to 41 00

Place vehicle on straightening bench.

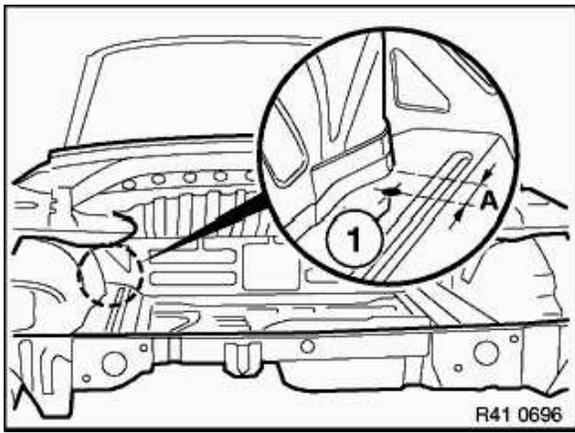
Rear trunk floor panel, complete



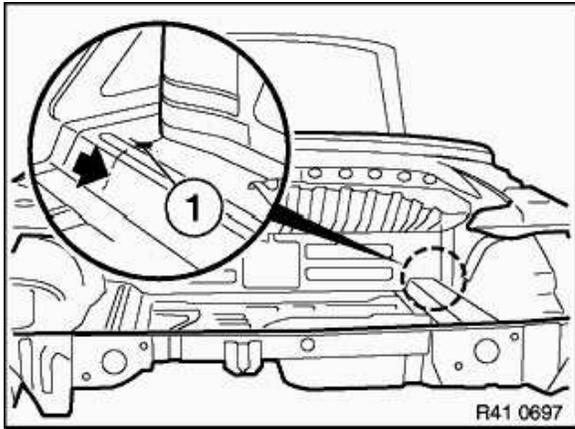
Remove or disconnect following parts:

- Fuel tank
- Rear axle carrier

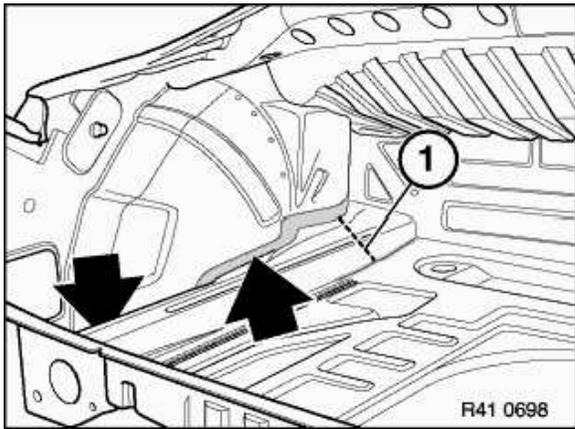
Other vehicle parts located in the repair zone or subject to be damaged from heat, sparks or dust, must be removed or covered.



Mark cutting line on left side member and cut through.  
Dimension (A) = 65 mm from hole  $\varnothing$ 12 mm (1) near spring strut dome.



Mark cutting line on right side member and cut through.  
Connection point: Center hole  $\varnothing$ 12 mm (1) near spring strut dome.



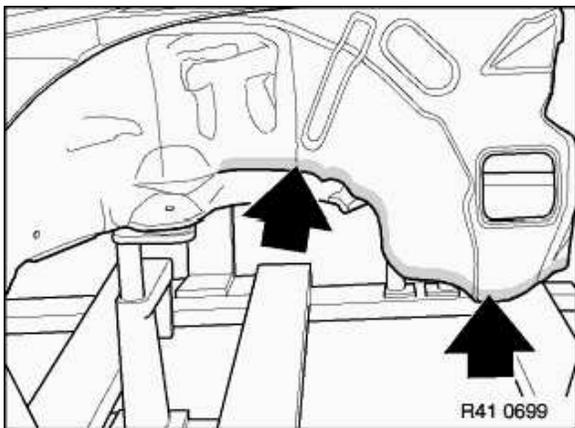
Expose connection points between side member / wheel arch and side section.

**Note:**

1 = Connection point on left side member

**Note:**

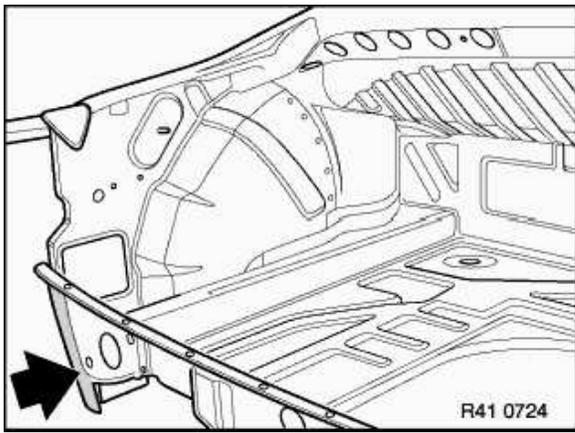
Diagram shows left connection points; also expose right connection points.



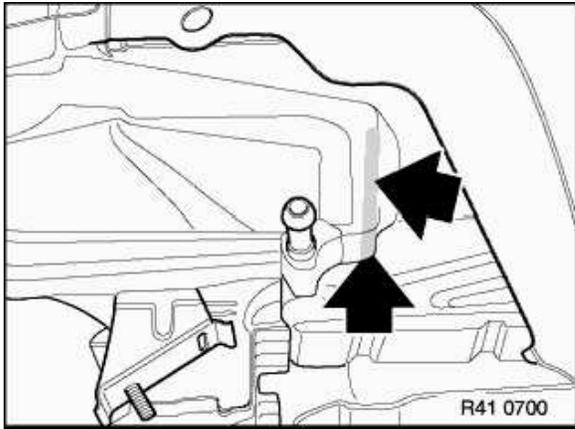
Expose connection points between side member / wheel arch and side section.

**Note:**

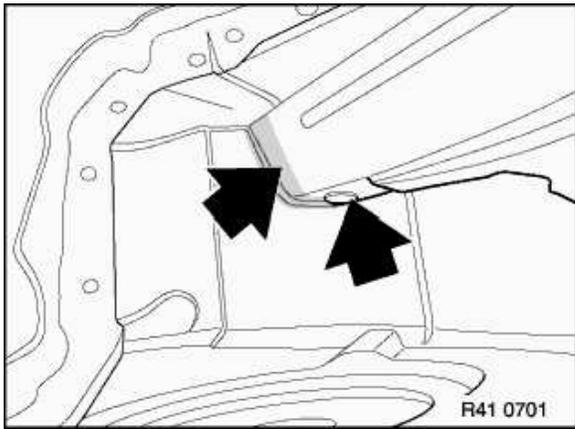
Diagram shows left connection points, also expose right connection points.



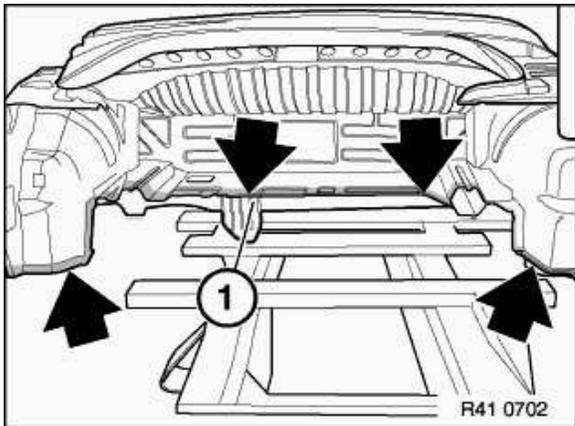
Expose connection point trunk floor / wheel arch.



Expose and cut through connection point between side member on underfloor.



Expose connection point between side member on right underbody.

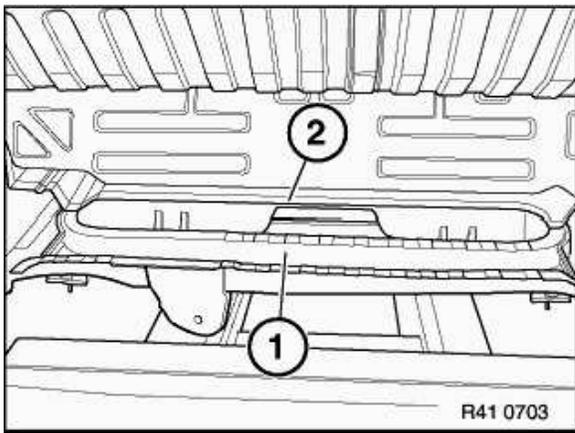


Cut through trunk floor roughly.  
Remove trunk floor.

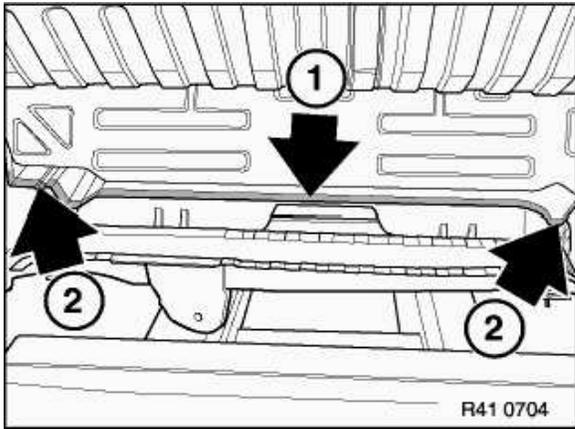
**Caution!**

Do not damage front crossmember on trunk floor (1)!

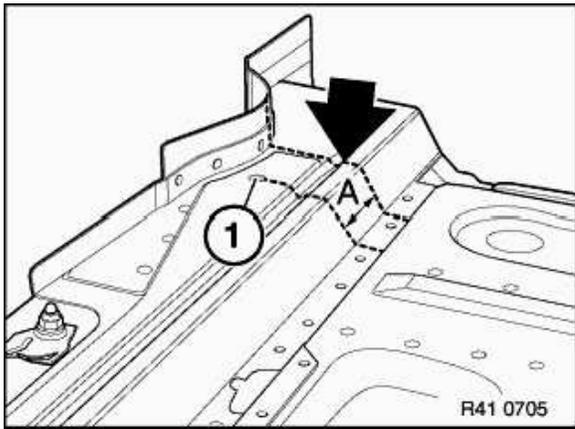
Remove scrap metal.  
Straighten and grind joint surfaces.



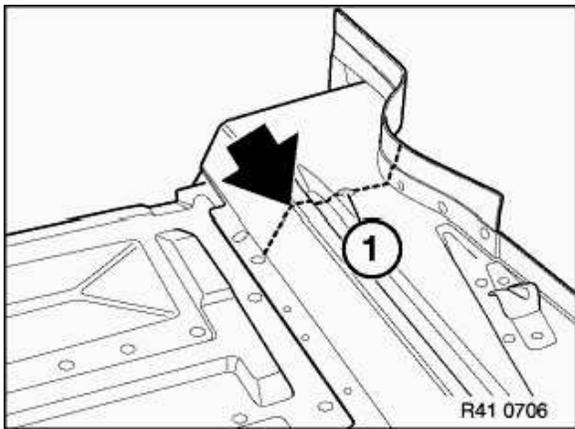
Remove residual plates from front crossmember on trunk floor (1) and on the connection point in the trunk floor (2).  
Straighten and grind joint surfaces.



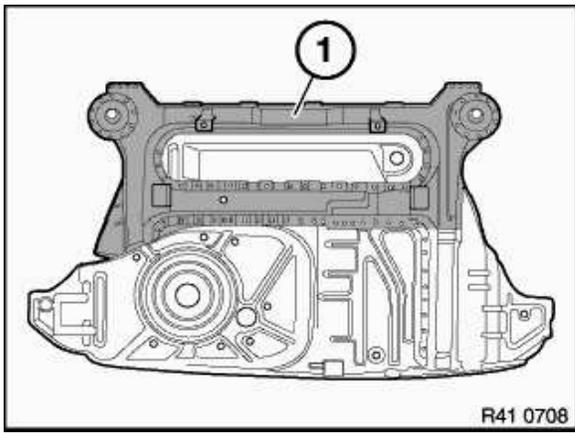
Drill holes for plug welding in connection point between trunk floor (1) and left and right side member(2).



Mark out and cut through spare trunk floor connection point on left side member.  
Dimension (A) = 65 mm from hole  $\varnothing 12$  mm (1) near connection point of spring strut dome.



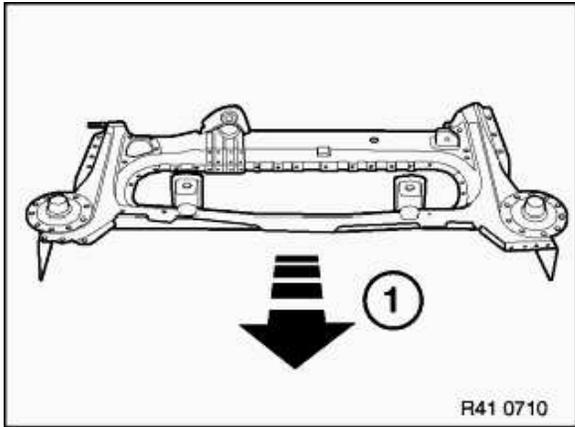
Mark out and cut through spare trunk floor connection point on right side member.  
Connection point: Center hole  $\varnothing 12$  mm (1) near connection point of spring strut dome.



Drill out support member of trunk floor (1).

Note:

View of spare trunk floor seen from underbody area.

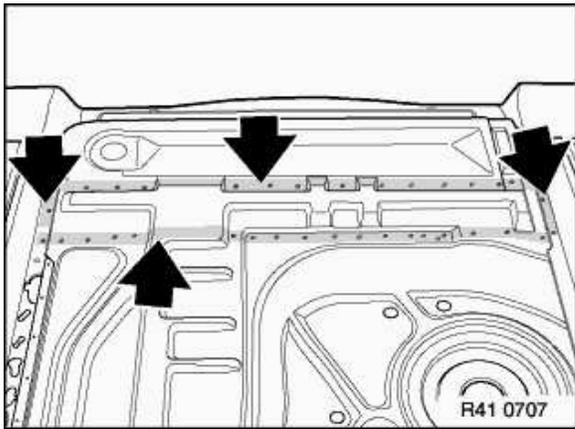


Trunk floor beam drilled out.

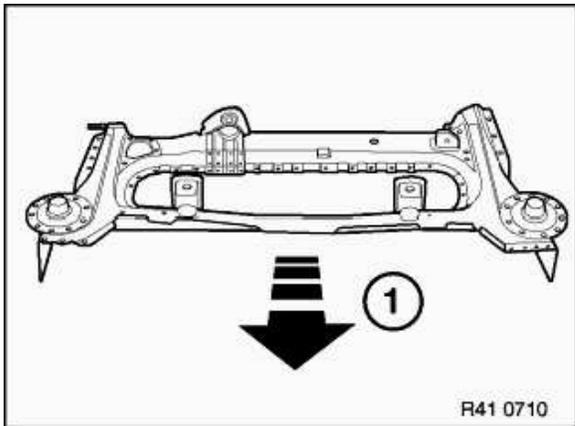
1 = direction of travel

Note:

View of trunk floor beam from underbody area.



Drill out welding points in trunk floor beam and remove beam from trunk floor.

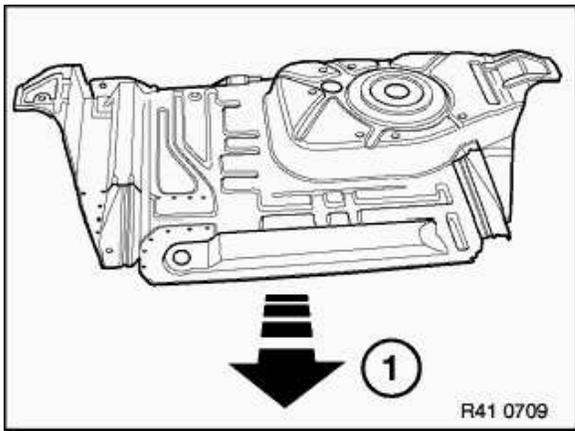


Trunk floor beam drilled out.

1 = direction of travel

Note:

View of trunk floor beam from underbody area.

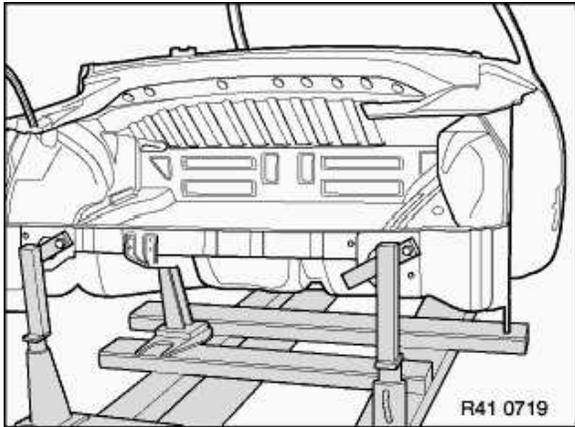


Spare trunk floor without trunk floor beam.

1 = direction of travel

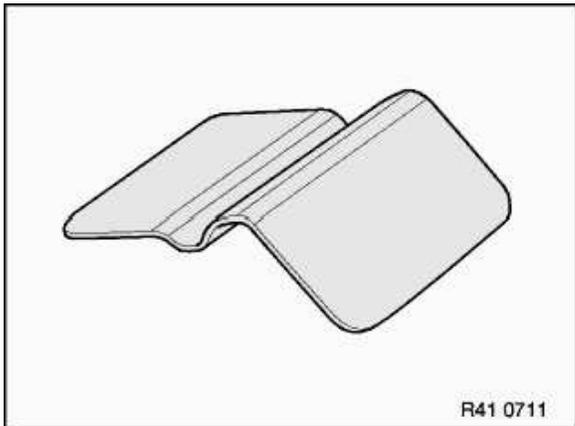
Note:

View of spare trunk floor without trunk floor beam from underbody area.



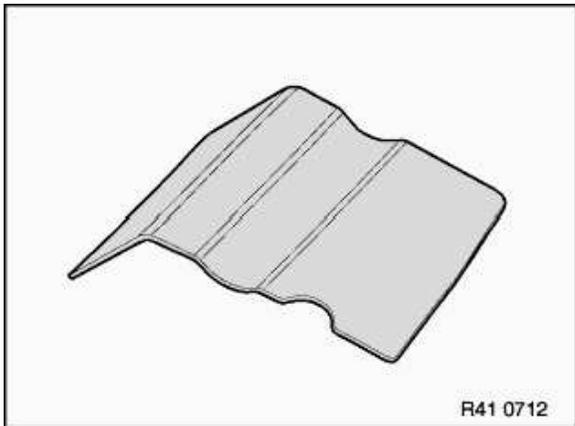
Adjust spare trunk floor with straightening angle set, reworking connection points if necessary.

Remove spare trunk floor.



Manufacture reinforcement plate for connection point in left side member from scrap sheet metal.

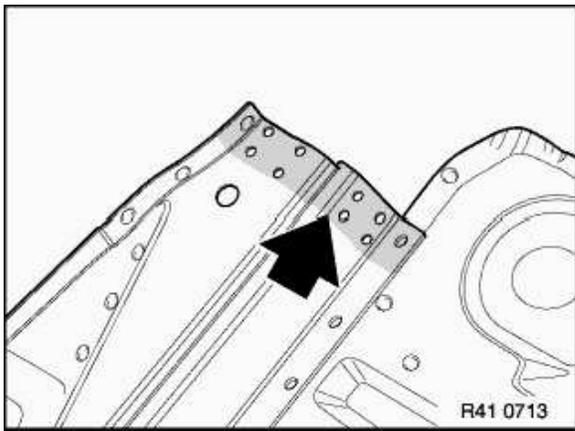
Width approx. 60 mm.



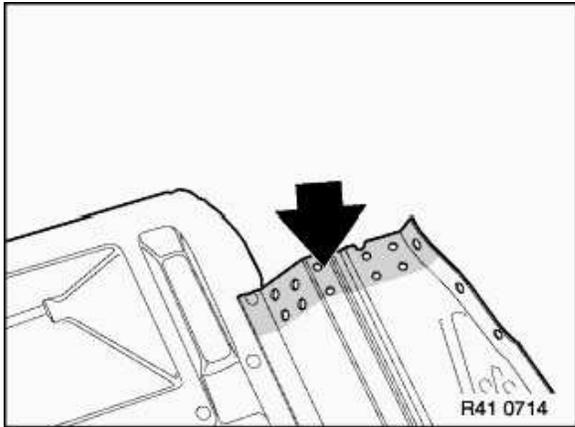
Manufacture reinforcement plate for connection point in right side member from scrap sheet metal.

Width approx. 60 mm.

Coat reinforcement plate for connection point between left and right side members with zinc dust paint.

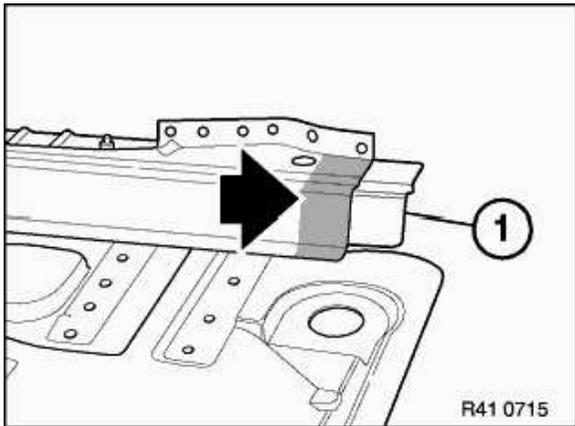


Drill out holes for plug welding reinforcement plate at connection point between left side member in spare trunk floor.



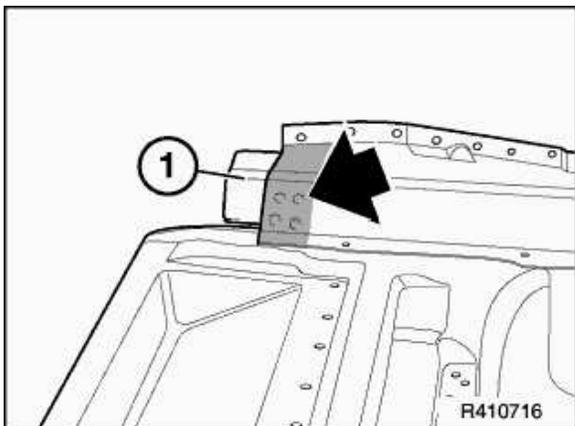
Drill out holes for plug welding reinforcement plate at connection point on right side member in spare trunk floor section.

Clean and coat joint surfaces with zinc dust paint.



Insert reinforcement plate for connection point in left side member (1) approx. 30 mm in spare part.

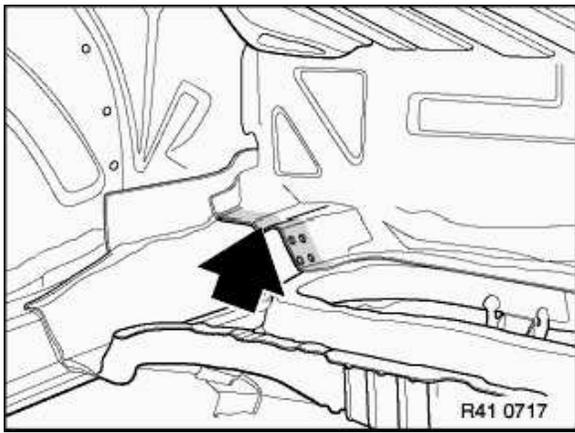
Weld reinforcement plate.



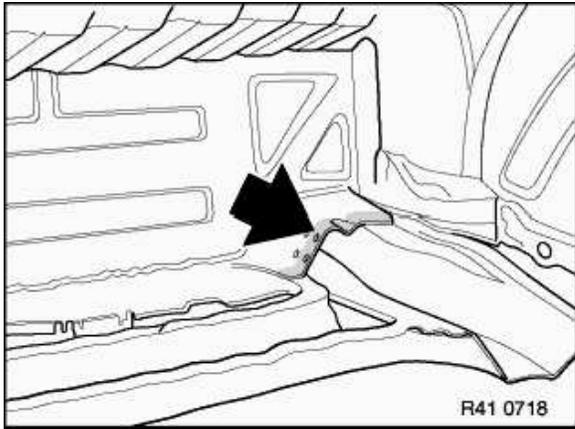
Install reinforcement plate for connection point in right side member (1) approx. 30 mm in spare part.

Weld reinforcement plate.

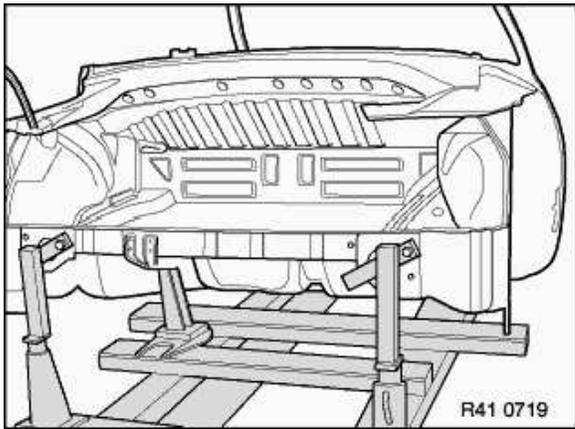
Grind welding spots until smooth.



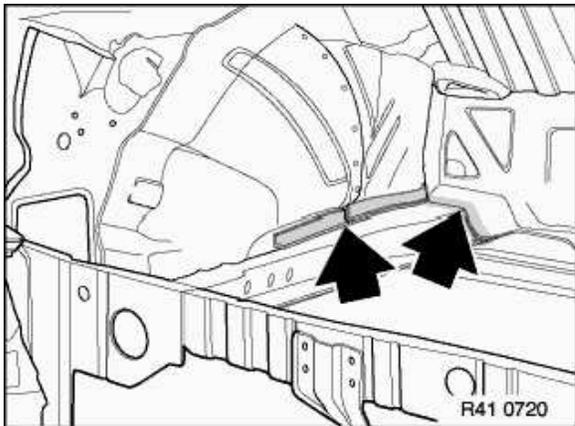
Drill holes for plug welding left reinforcement plate in connection point on left side member in vehicle.



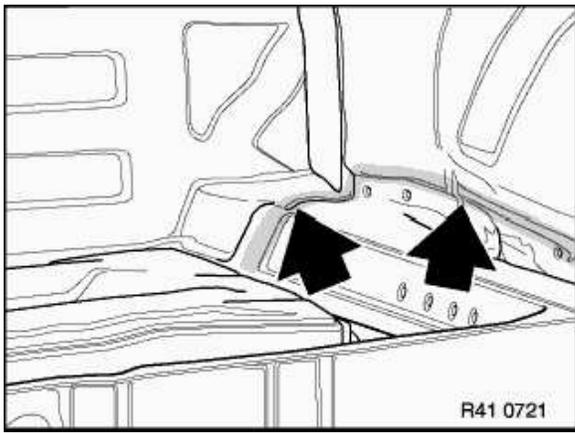
Drill holes for plug welding right reinforcement plate in connection point on right side member of vehicle.



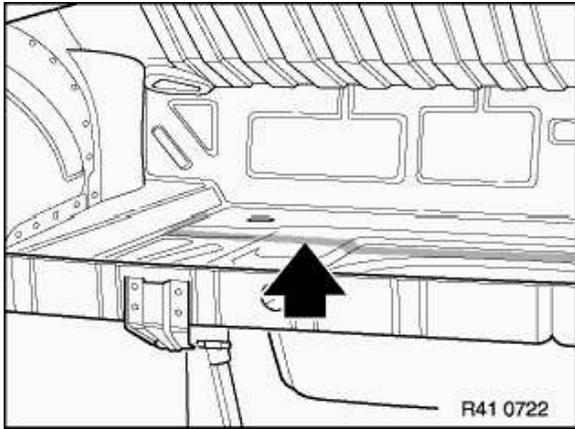
Install and adjust trunk floor with straightening angle set.



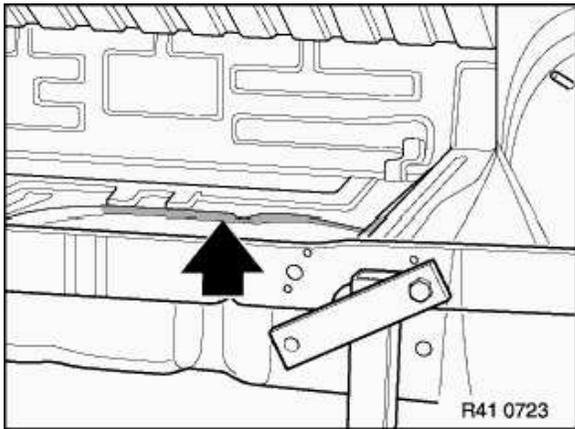
Weld up connection point in left side member and side member / wheel arch.



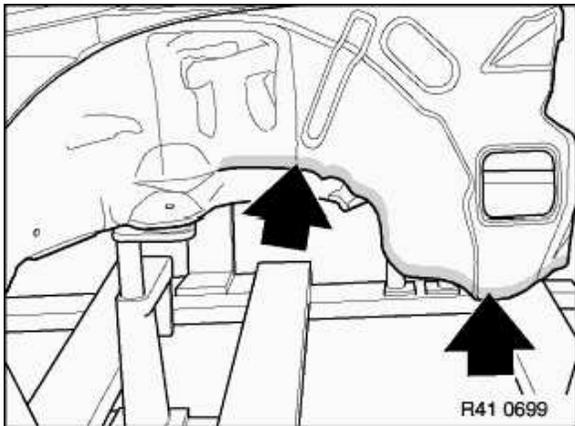
Weld up connection point on right side member and side member / wheel arch.



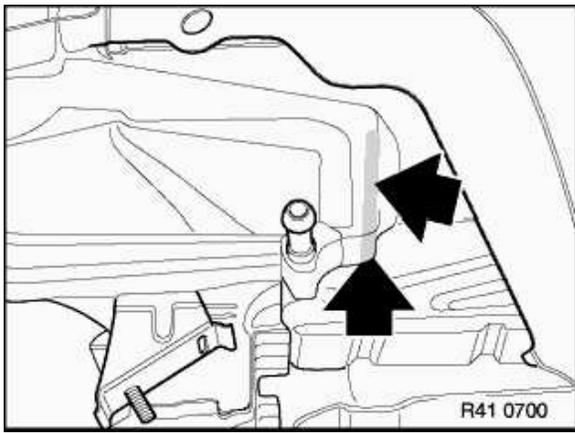
Weld up connection point on left underbody.



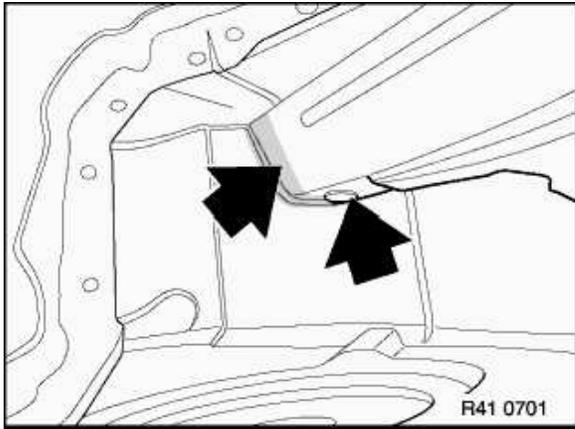
Weld up connection point on right sub-frame.



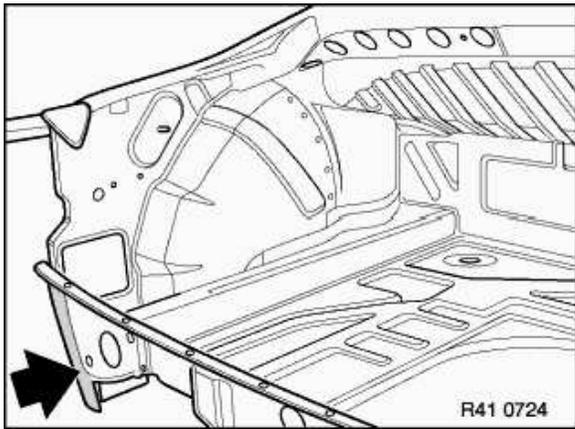
Expose connection points between side member / wheel arch and side section extension.



Weld up connection point in side member on left underbody.



Weld up connection point on side member on right underbody section.



Weld up connection point between trunk floor / wheel arch.  
Grind down all connection points and seal.