



Body Repairs

Audi A8 2003 >

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Repair Group overview for Body Repairs

Repair Group

00 - Technical data

50 - Body - front

51 - Body - centre

53 - Body - rear



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Technical information should always be available to the foremen and mechanics, because their careful and constant adherence to the instructions is essential to ensure vehicle road-worthiness and safety. In addition, the normal basic safety precautions for working on motor vehicles must, as a matter of course, be observed.

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00 – Technical data

1 Vehicle identification data

1.1 Vehicle identification number

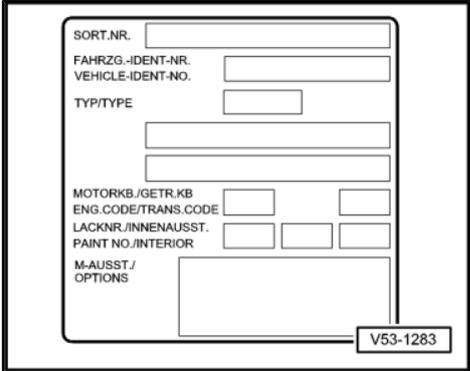
The vehicle identification number appears in the windscreen on the driver's side, on the vehicle data sticker and is stamped on the suspension turret (right-side).

1.2 Type plate

The type plate is located on the passenger-side door pillar. Vehicles for certain export countries have no type plate.

1.3 Vehicle data sticker

The vehicle data sticker is located in the spare wheel well under the luggage compartment floor (left-side in direction of travel).



SORT.NR.	<input type="text"/>
FAHRZG.-IDENT-NR. VEHICLE-IDENT-NO.	<input type="text"/>
TYP/TYPE	<input type="text"/>
	<input type="text"/>
	<input type="text"/>
MOTORKB./GETR.KB	<input type="text"/>
ENG.CODE/TRANS.CODE	<input type="text"/>
LACKNR./INNENAUSST.	<input type="text"/>
PAINT NO./INTERIOR	<input type="text"/>
M-AUSST./ OPTIONS	<input type="text"/>

V53-1283



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2 Moulded foam inserts

Various body cavities of the Audi A8 2003 are fitted with moulded foam inserts.

The foam inserts reduce the noise transmitted to the interior when driving.

These pre-moulded parts are fitted during body manufacture and subsequently increase their volume in the paint shop drying oven at approx. 180 °C after priming.



Caution

The replacement foam inserts expand only after reaching about 180°C. For this reason, an additional filler foam is used when performing repairs.

Filler foam required for repairs: D 506 KD1 A3.

As the required temperatures cannot be achieved under normal workshop conditions, proceed as follows:

Remove residue of foam material on vehicle.

Restore paint coating; apply two coats (wet on wet) of glass/paint primer D 009 200 02 if necessary, flash-off time approx. 10 minutes.

Requirement

Before continuing with this procedure, ensure that the replacement panel is ready for installation, i.e. cut to shape, matched up to the vehicle, corrosion protection applied.

Renewing moulded foam insert

Fix moulded foam insert to vehicle.

Apply filler foam -D 506 KD1 A3- to replacement part.

Secure new part in position. Gently press in new part in vicinity of moulded foam insert until it makes contact, and then weld into place.

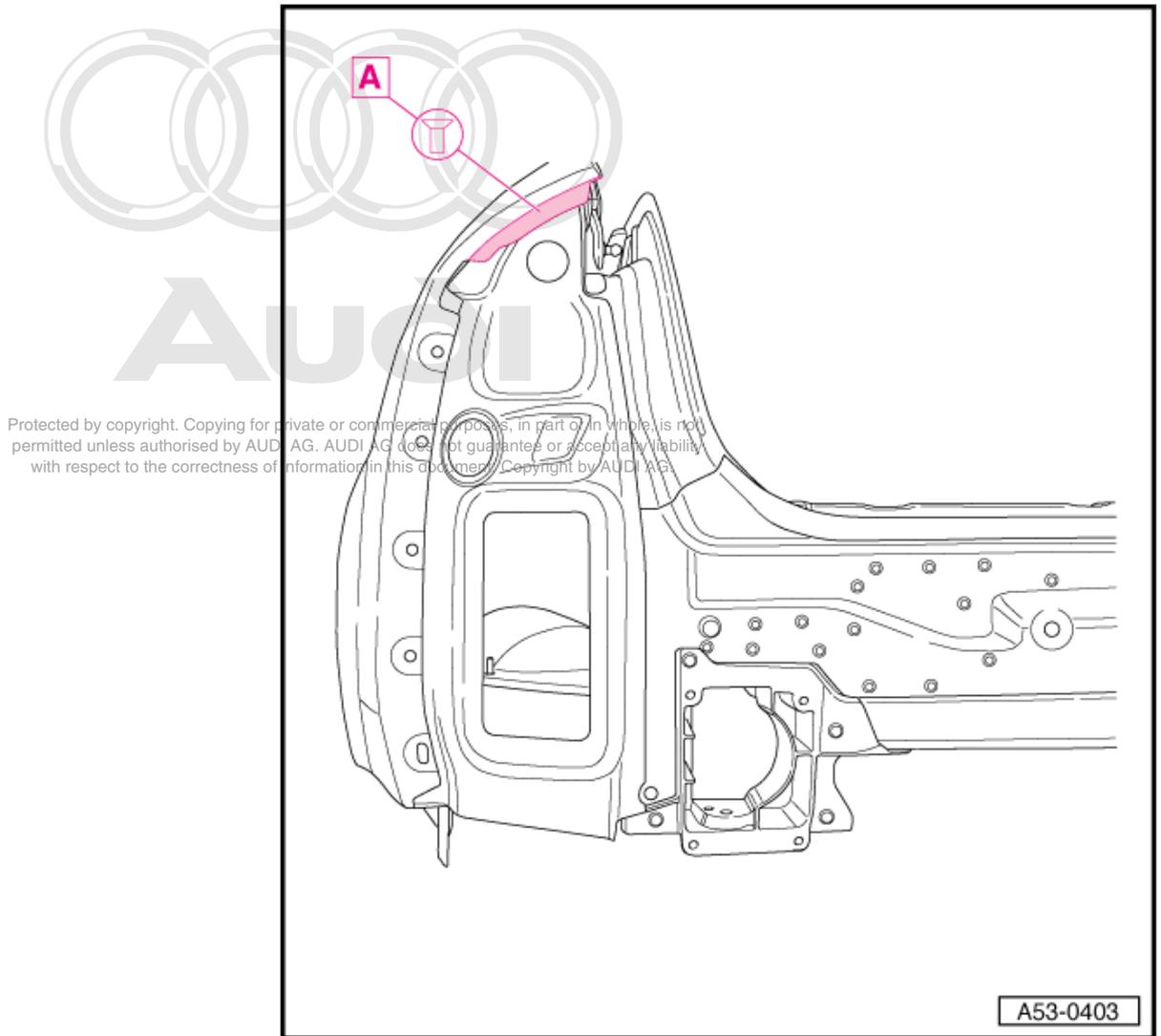
The foam hardens within 25 minutes.

Do not weld (SG) within 15 mm of the foam insert (on either side).

After painting the vehicle the repaired area must be cavity-sealed.

3 Repair methods for bonded joints

3.1 Body - rear



- Light mounting to outer side panel. 5x solid rivets.

4 Body dimensions

4.1 Floor group, front

a - 836 ± 2 mm

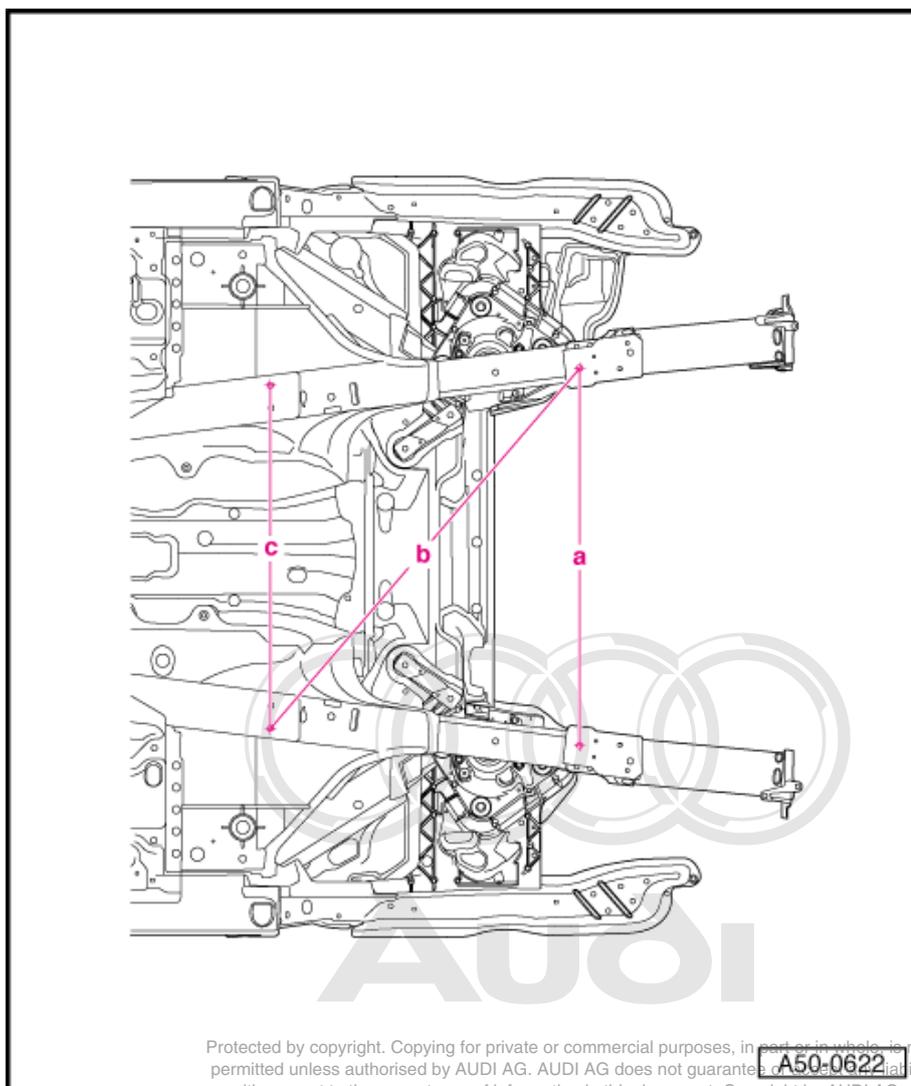
Distance between front attachment points of front suspension

b - 1067 ± 2 mm

Diagonal distance between attachment points of front suspension

c - 762 ± 2 mm

Distance between rear attachment points of front suspension



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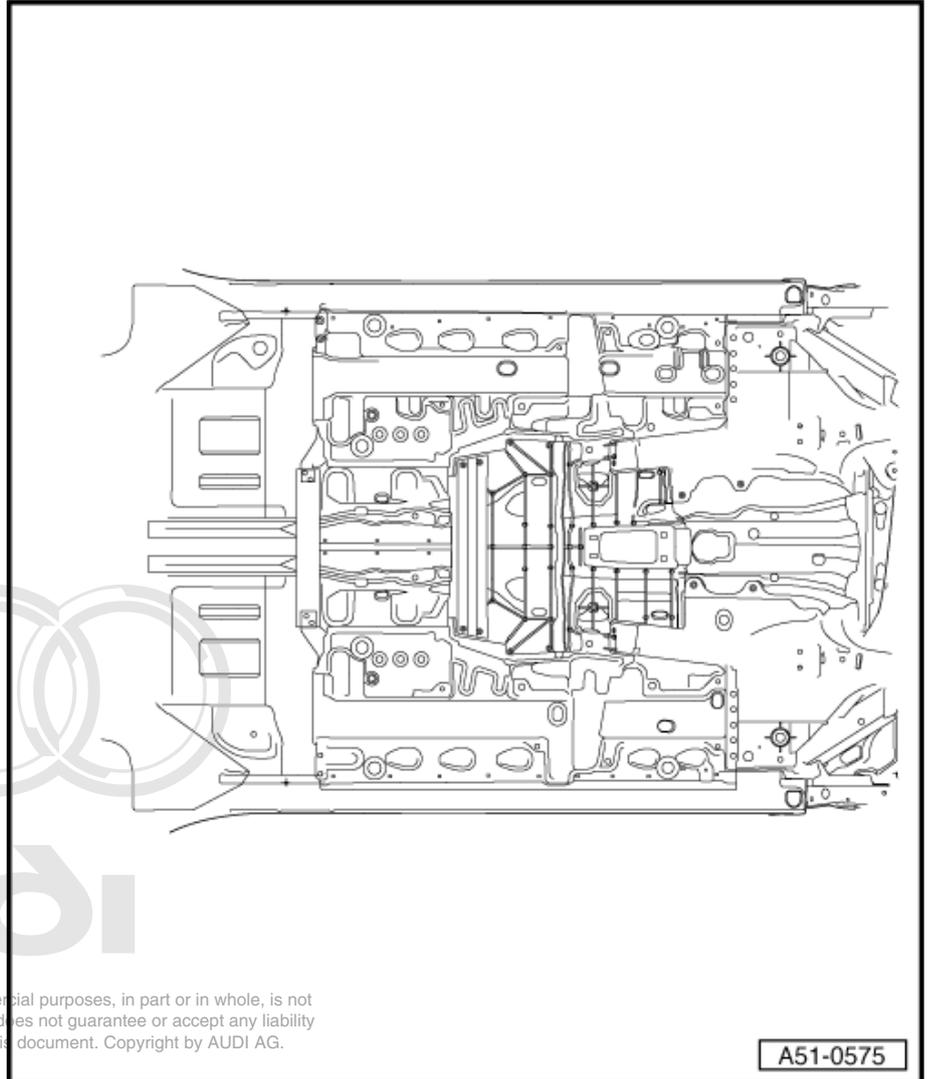
4.2 Floor group, centre

a - 1818 ± 2 mm

Distance between rear attachment points of front suspension and rear axle mounting

b - 2245 ± 2 mm

Diagonal distance between rear attachment points of front axle and rear axle mounting



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4.3 Floor group, rear

a - 1444 ± 2 mm

Distance between front attachment points of rear suspension

b - 1078 ± 2 mm

Distance between rear attachment points of rear suspension

c - 1599 ± 2 mm

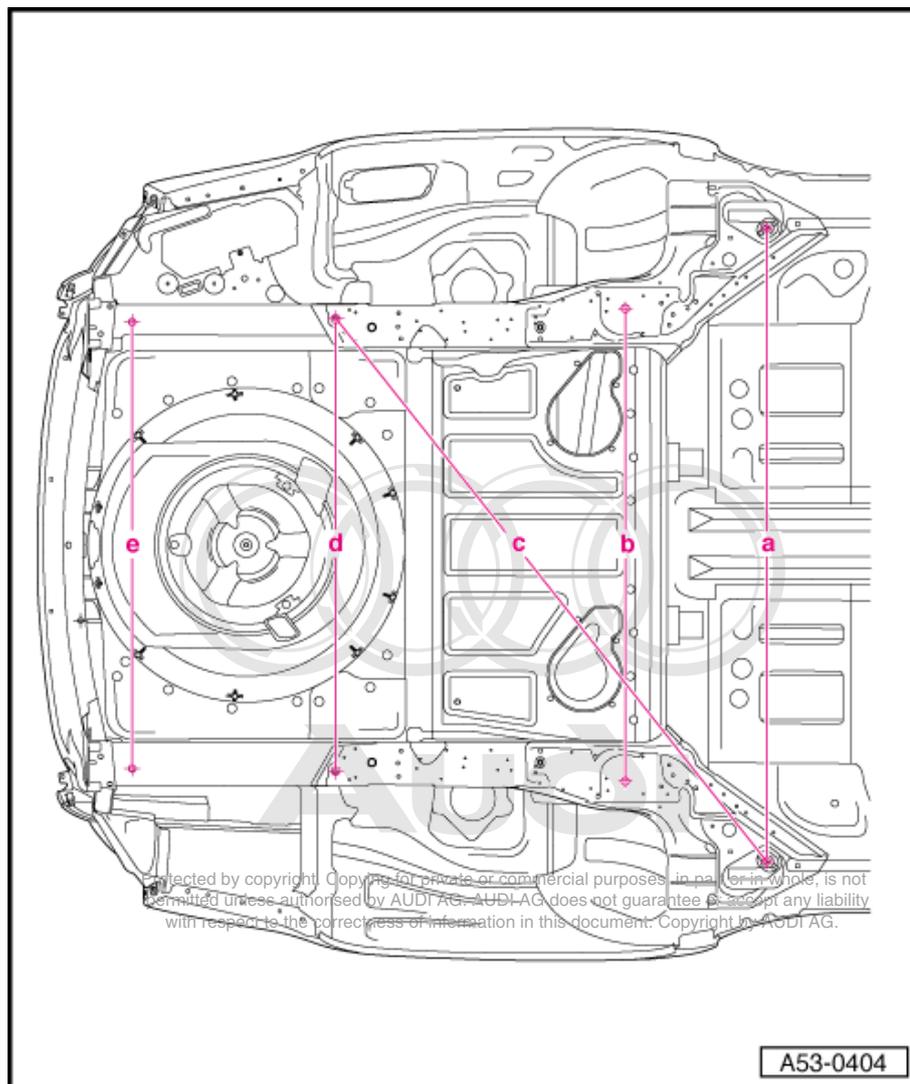
Diagonal distance between attachment points of rear suspension

d - 1032 ± 2 mm

Distance between attachment points of rear suspension

e - 1014 ± 2 mm

Distance between rear attachment points of rear suspension

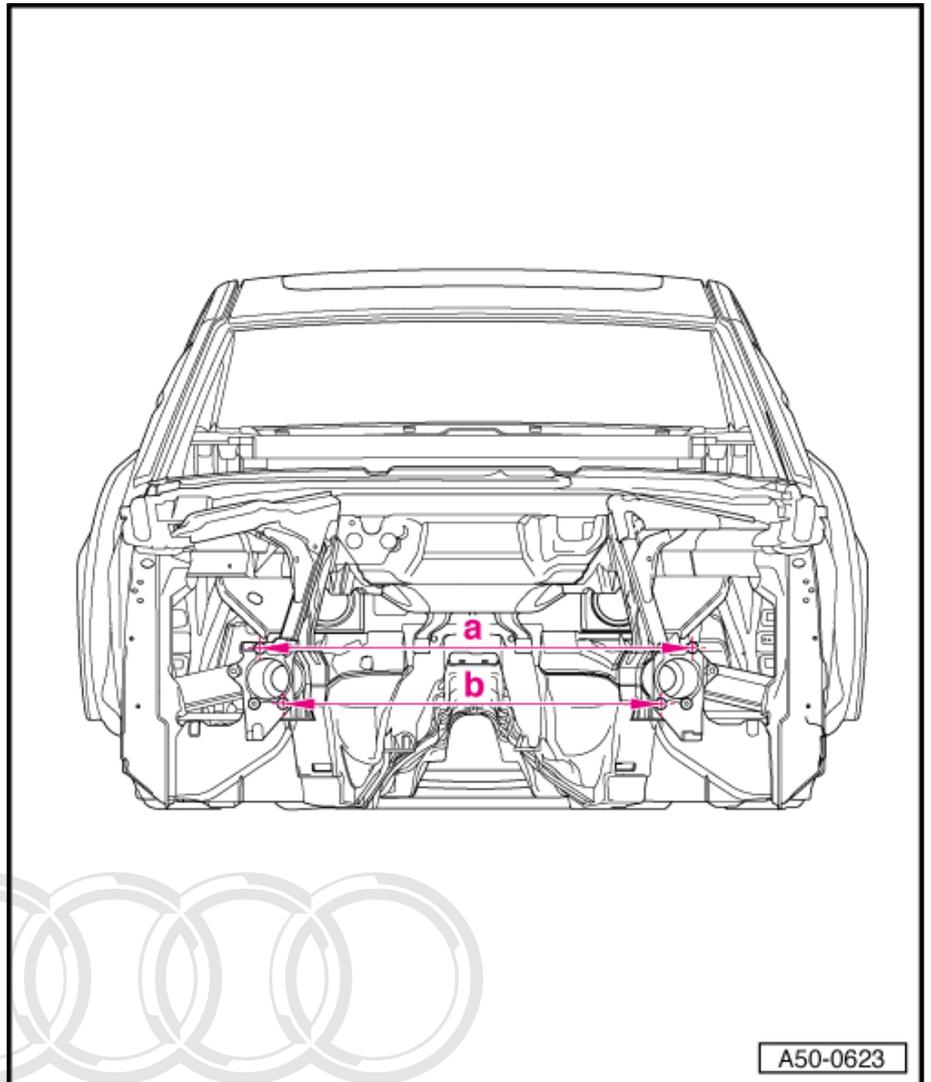


4.4 Body - front

a - 1026 ± 2 mm

Distance between front longitudinal members

b - 894 ± 2 mm



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c - 1428 ± 2 mm

Distance between wing panel mountings

e - 848 ± 2 mm

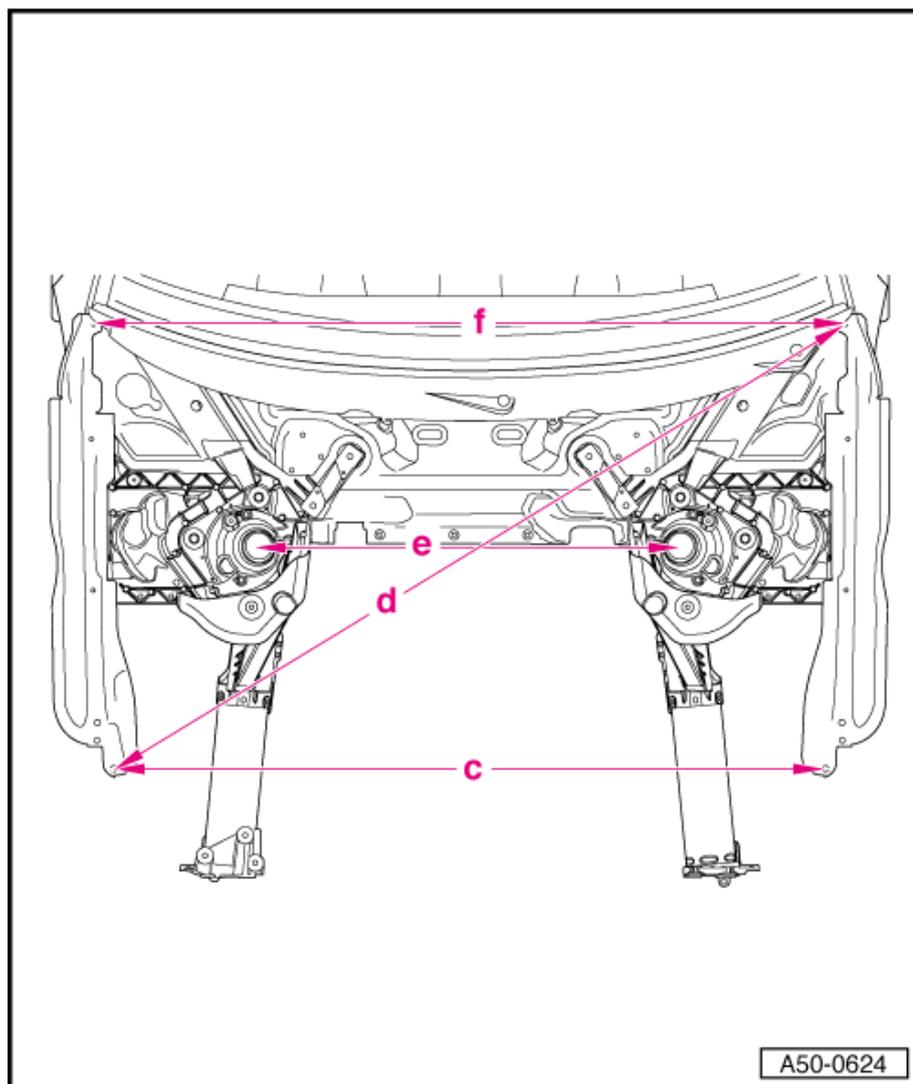
Distance between attachment points of suspension strut mountings

f - 1510 ± 2 mm

Distance between front hinge mountings

d - 1726 ± 2 mm

Diagonal distance between hinge mountings and wing panel mountings



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4.5 Body - centre

4.5.1 Front door opening

a - 929 ± 2 mm

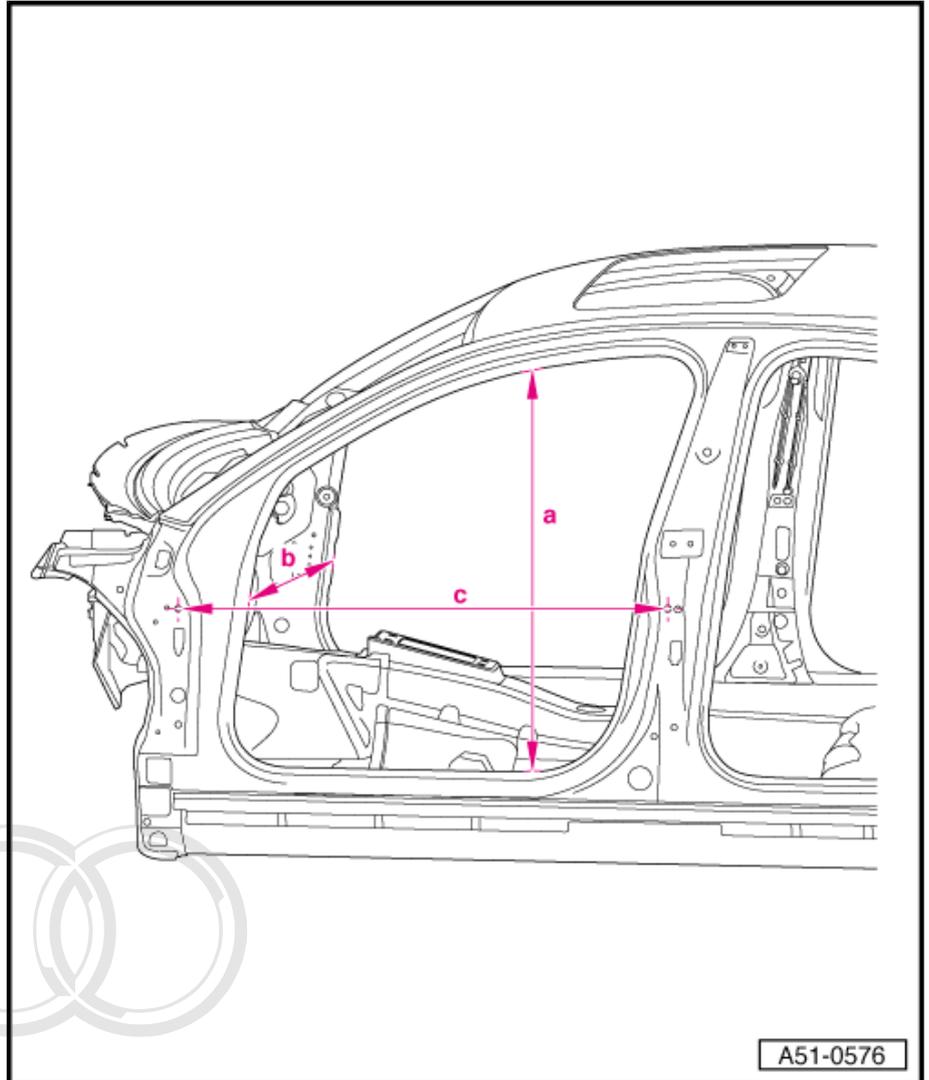
Height of door opening

b - 1552 ± 2 mm

Distance between A-pillars

c - 1124 ± 2 mm

Distance between A-pillar and B-pillar



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4.5.2 Rear door opening

a - 964 ± 2 mm

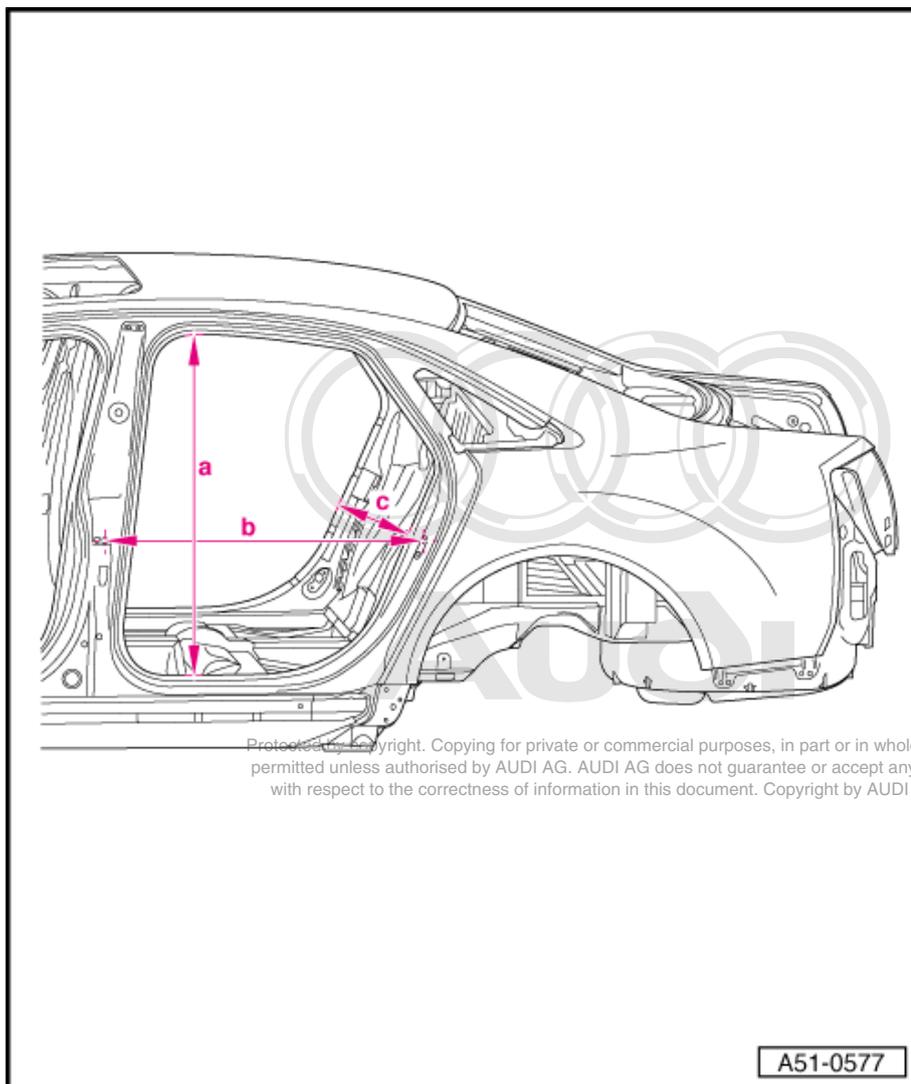
Height of door opening

b - 917 ± 2 mm

Distance between B-pillar and
C-pillar

c - 1506 ± 2 mm

Distance between C-pillars



4.6 Body - rear

a - 1096 ± 2 mm

b - 914 ± 2 mm

Distance between rear longitudinal members

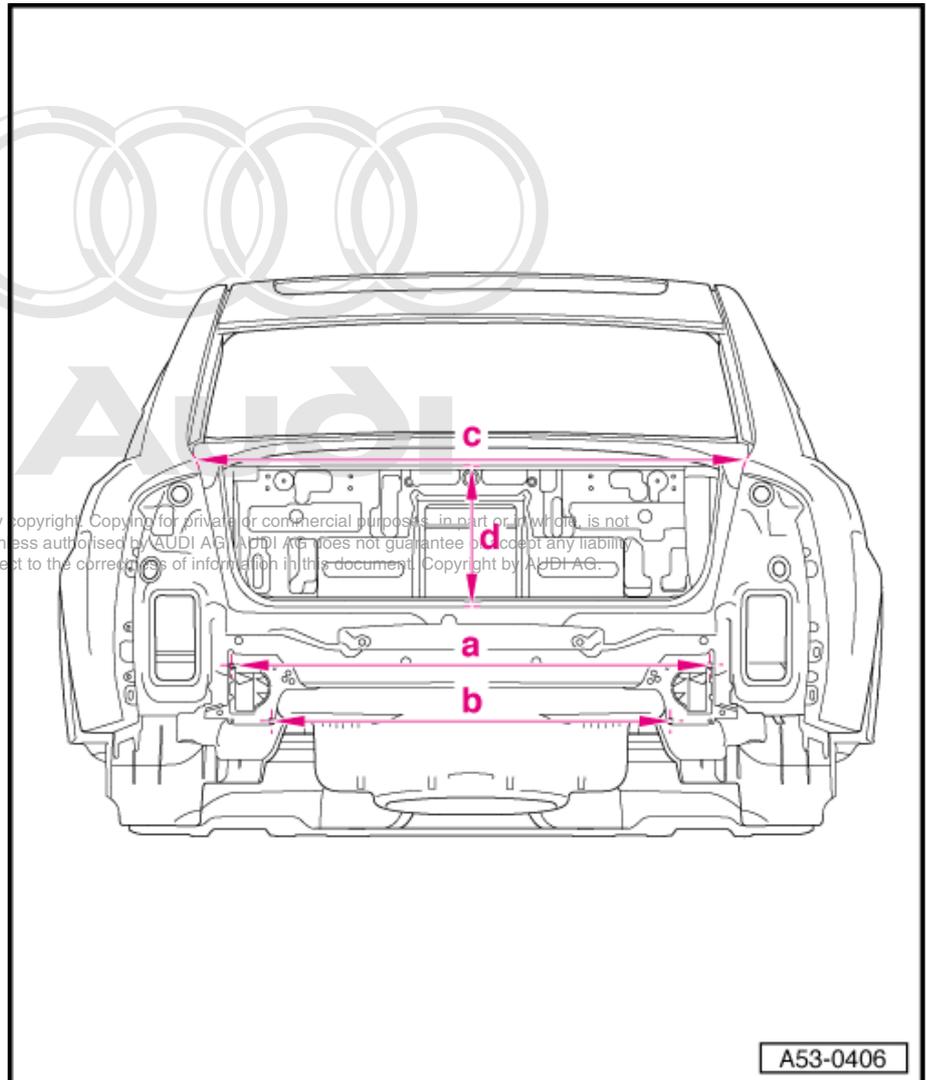
c - 1259 ± 2 mm

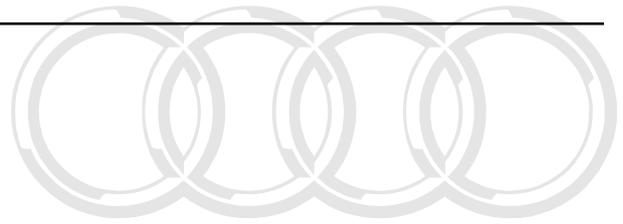
Distance between side panels (top)

d - 603 ± 2 mm

Distance between rear cross panel flange and window cross member flange

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5 Body panel gaps/shut lines

5.1 Body - front

N - 0.0 mm

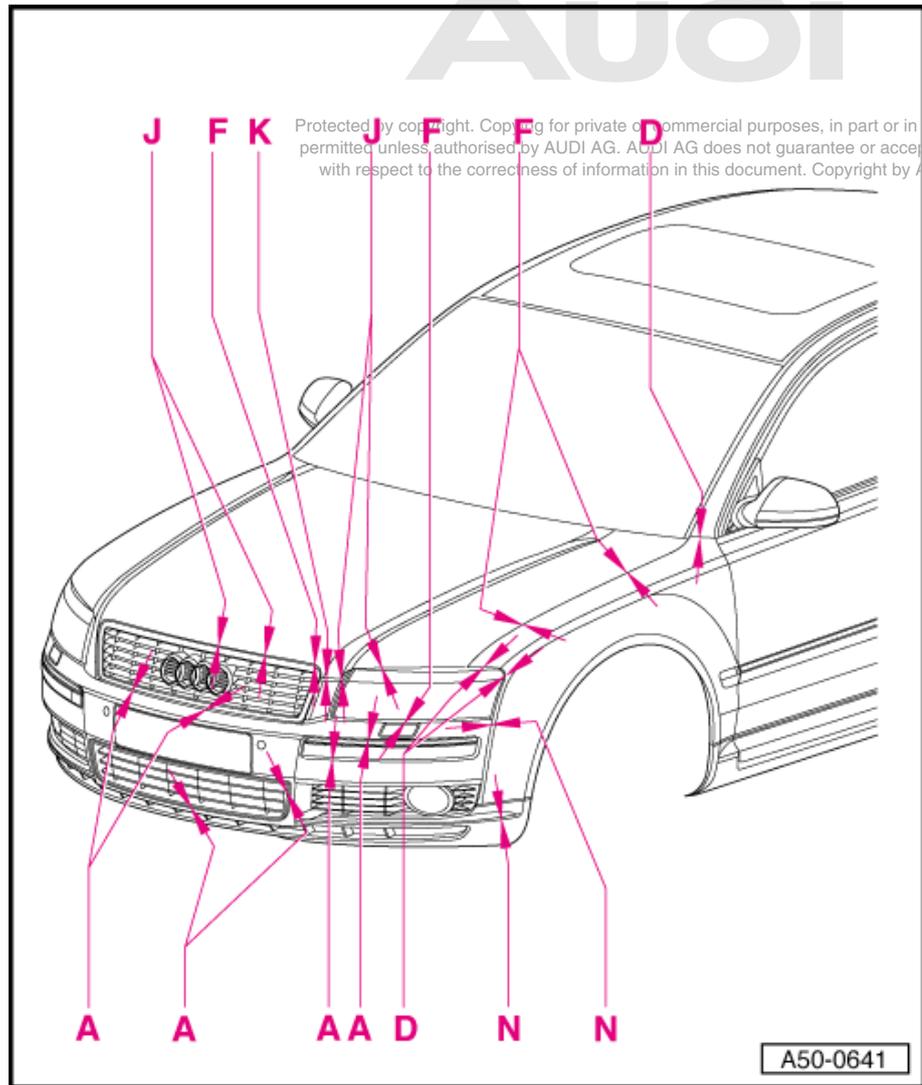
A - 1.0 mm

D - 2.0 mm

F - 3.0 mm

J - 4.5 mm

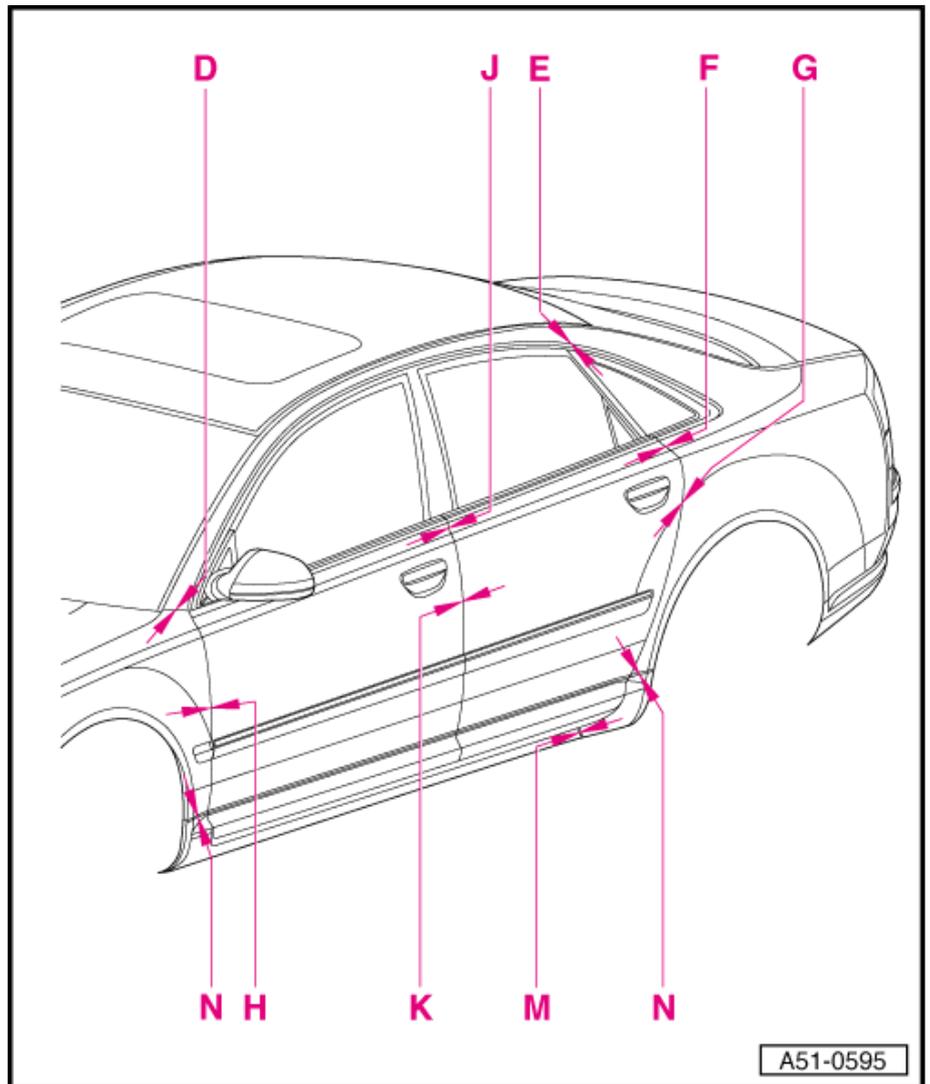
K - 5.0 mm



Use special tool 3371 for adjusting or checking.

5.2 Body - centre

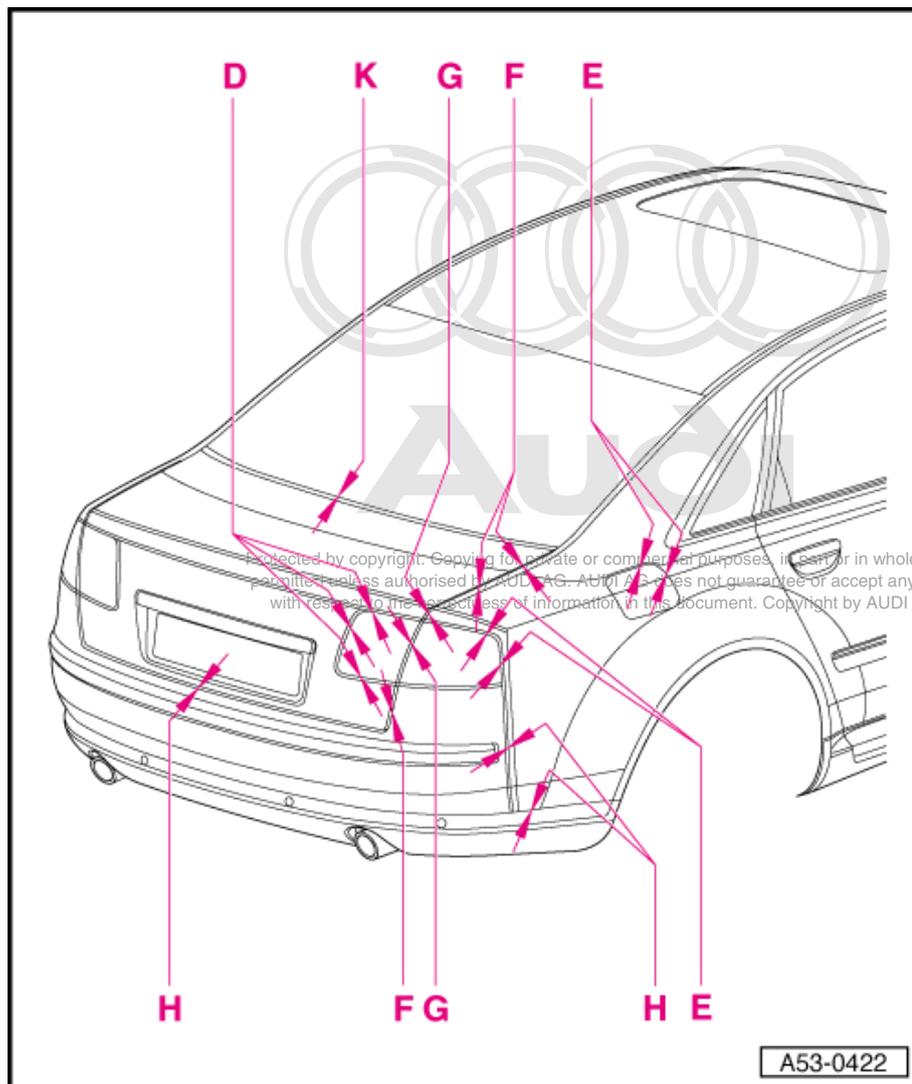
- N - 0.0 mm
- D - 2.0 mm
- E - 2.5 mm
- F - 3.0 mm
- G - 3.5 mm
- H - 4.0 mm
- J - 4.5 mm
- K - 5.0 mm
- M - 6.0 mm



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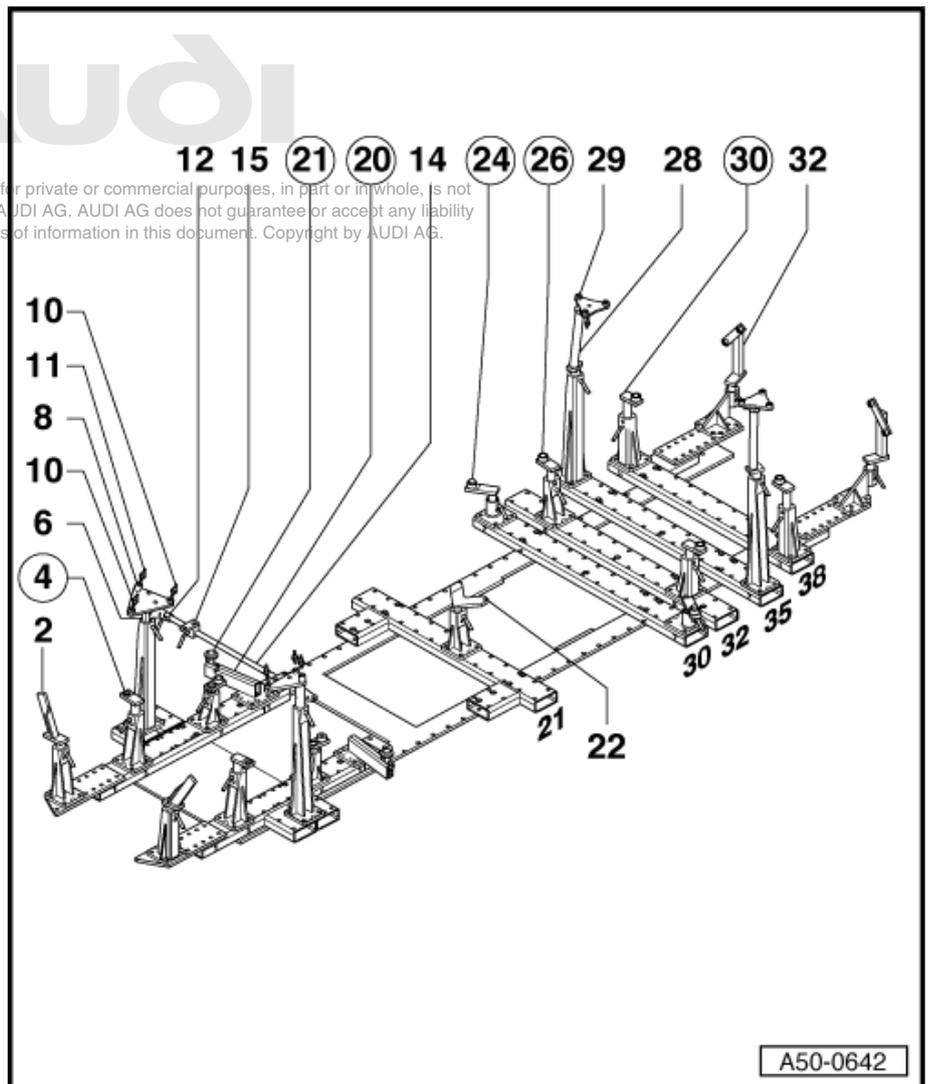
5.3 Body - rear

- D - 2.0 mm
- E - 2.5 mm
- F - 3.0 mm
- G - 3.5 mm
- H - 4.0 mm
- K - 5.0 mm



6 Straightening jig

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Alignment bracket set -VAS 6181- (also suitable for quattro versions)

i Note

- ◆ The item numbers in the illustrations are identical with the end numbers on the alignment bracket mountings.
- ◆ The item numbers of the alignment bracket mountings marked with a circle are for checking the body with mechanical units installed.
- ◆ The required basic set size is given for the alignment bracket mountings.
- ◆ The following illustrations show the right side of the vehicle.



2 - MZ 260 and TV 400

4 - MZ 260

6 - MZ 602

12 - Mounting for bar

6 - MZ 602 and alignment bracket mounting -8-

10 - Bolts for suspension strut mounting

11 - Bolt for suspension strut mounting

14 - Bar in place of steering box

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15 - Mounting for steering

16 - MZ 140

20 - Bracket without MZ, and front production mounting -21-

22 - MZ 200 (quattro only)

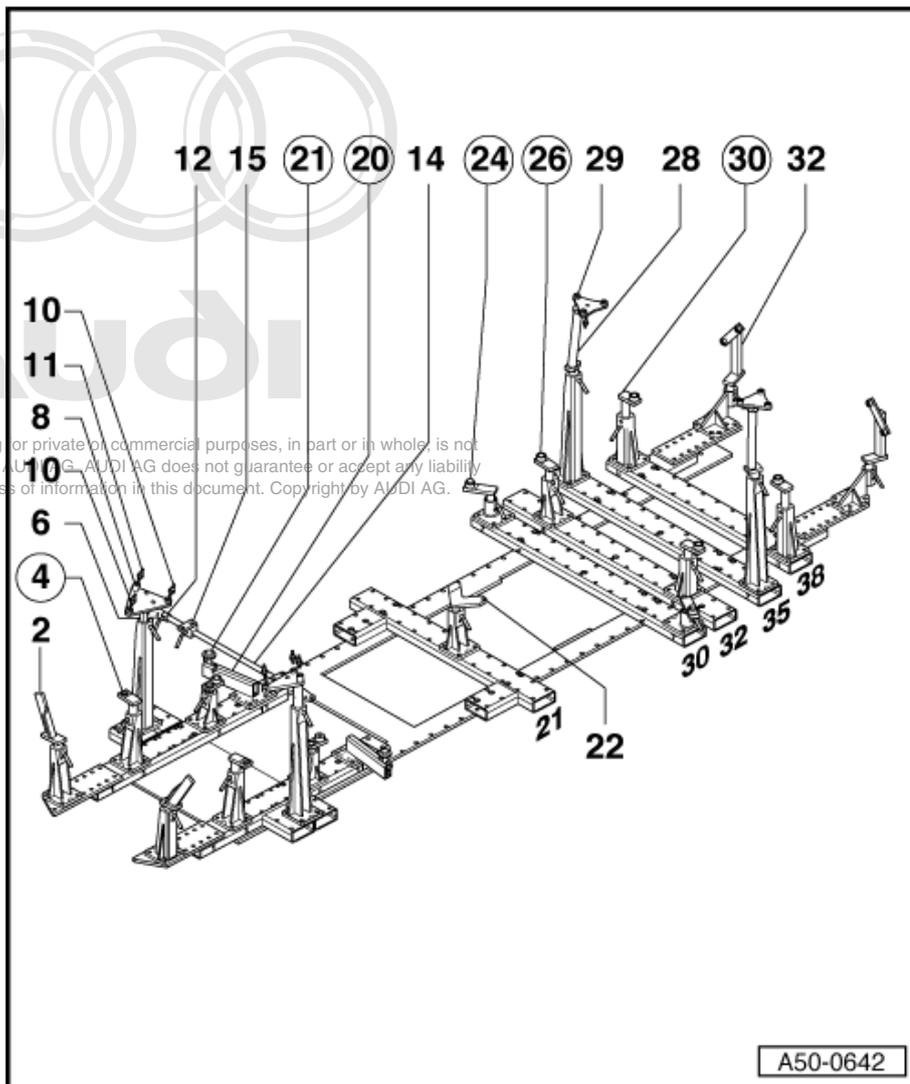
24 - MZ 080

26 - MZ 200

28 - MZ 602 and alignment bracket mounting 29

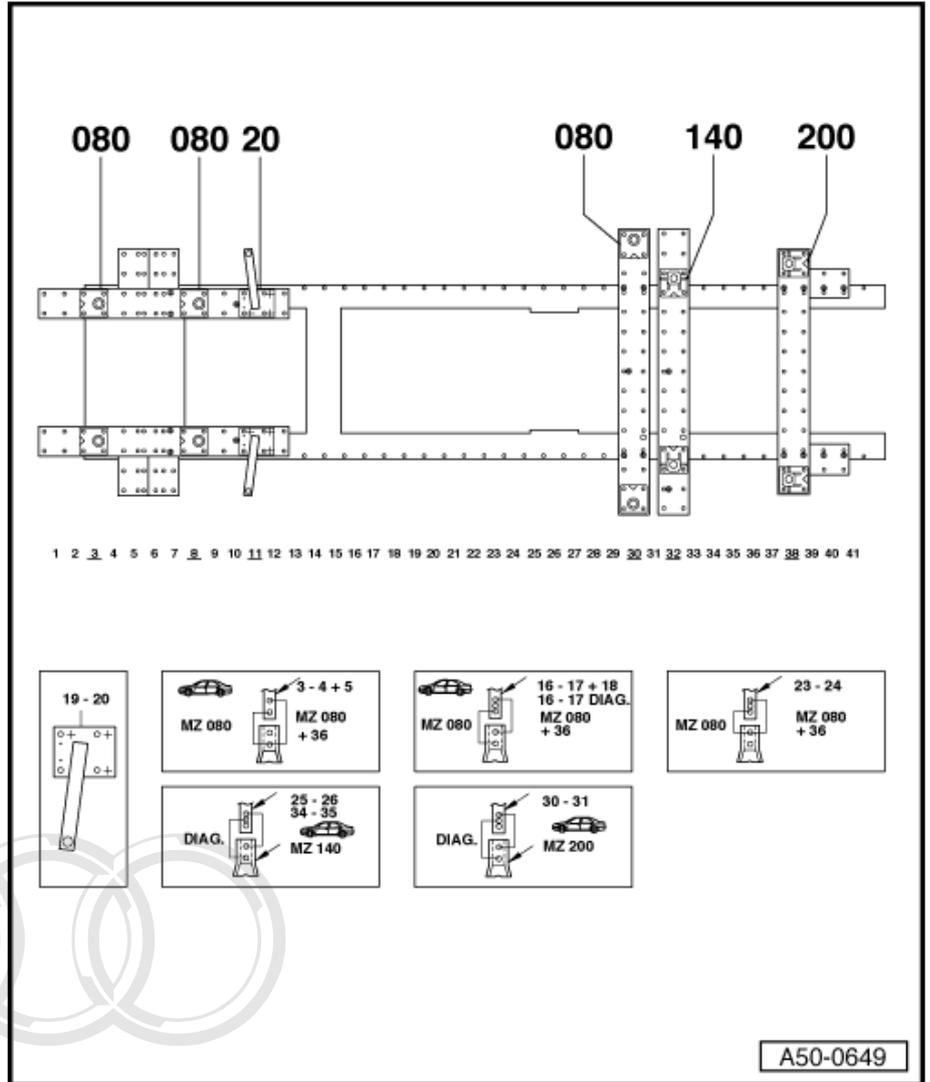
30 - MZ 260

32 - MZ 142 and TV 400



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- 2 - MZ 200 and TV 400
- 4 - MZ 260
- 6 - MZ 602
- 16 - MZ 140
- 22 - MZ 200
- 24 - MZ 080
- 26 - MZ 200
- 28 - MZ 602
- 30 - MZ 260
- 32 - MZ 142 and TV 400



Overview and locations of MZ elements

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4 - MZ 080

5 - Spacer

16 - MZ 080

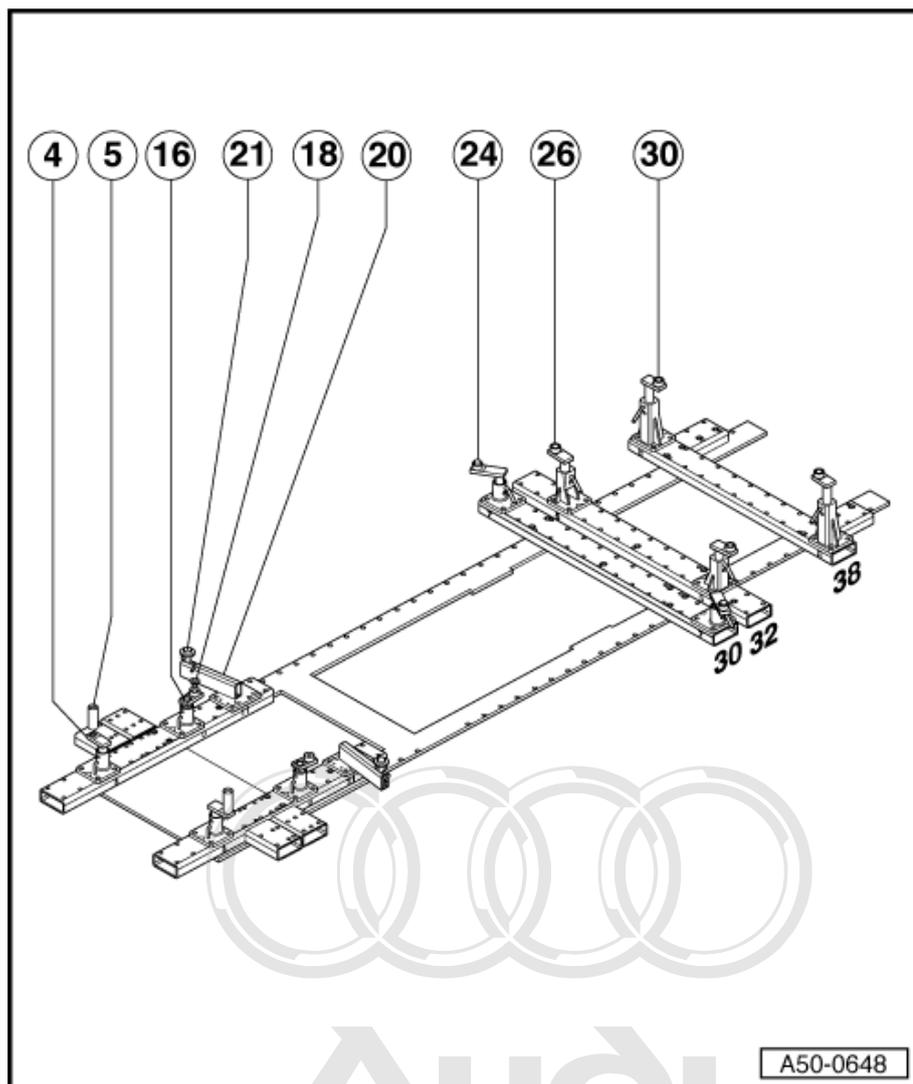
18 - Left and right centring
piece identical

20 - Bracket without MZ, and
front production mounting -21-

24 - MZ 080

26 - MZ 140

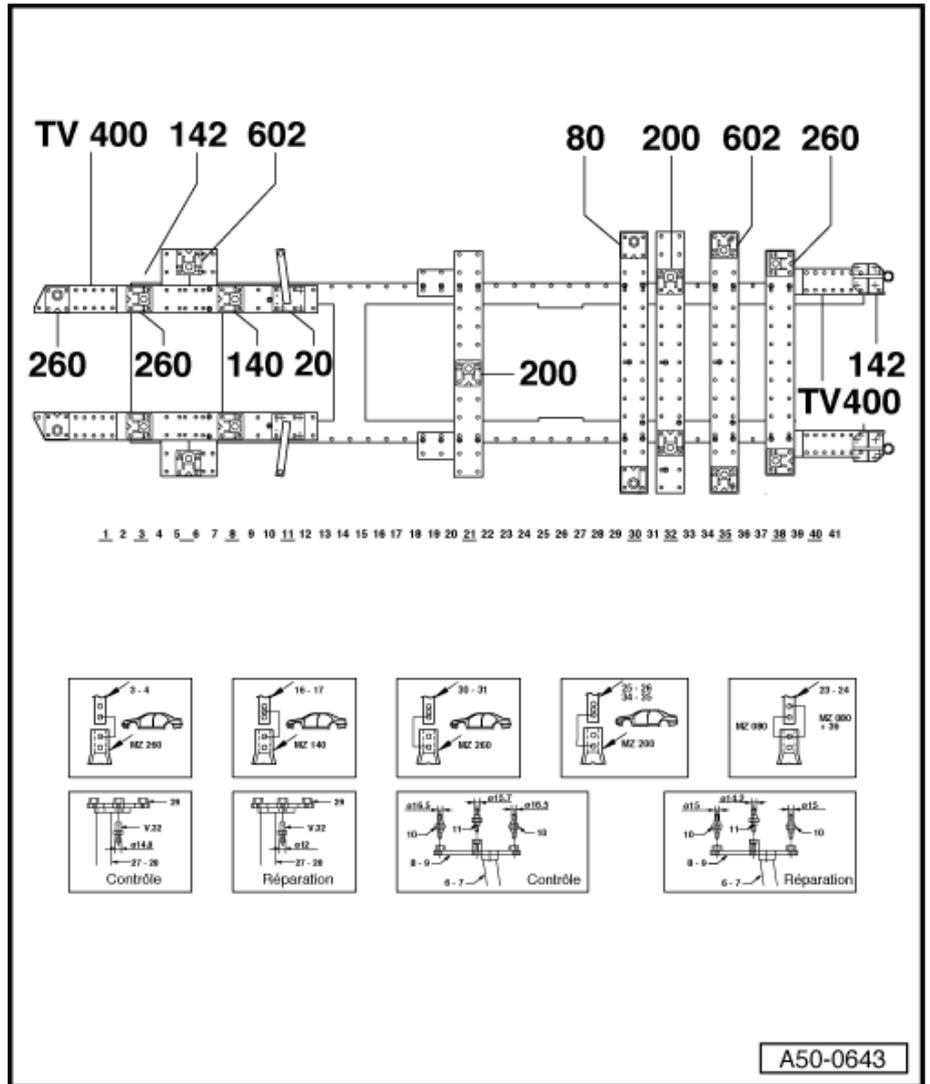
30 - MZ 200



**Overview of alignment brackets for vehicles with mechanical units
installed**

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- 4 - MZ 080
- 16 - MZ 080
- 20 - Bracket without MZ, and front production mounting -21-
- 24 - MZ 080
- 26 - MZ 140
- 30 - MZ 200



Overview of MZ elements for vehicles with mechanical units installed



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2 - MZ 260 and TV 400

4 - MZ 260

6 - MZ 602

12 - Mounting for bar

6 - MZ 602 and alignment
bracket mounting -8-

10 - Bolts for suspension strut
mounting

11 - Bolt for suspension strut
mounting

14 - Bar in place of steering
box

15 - Mounting for steering

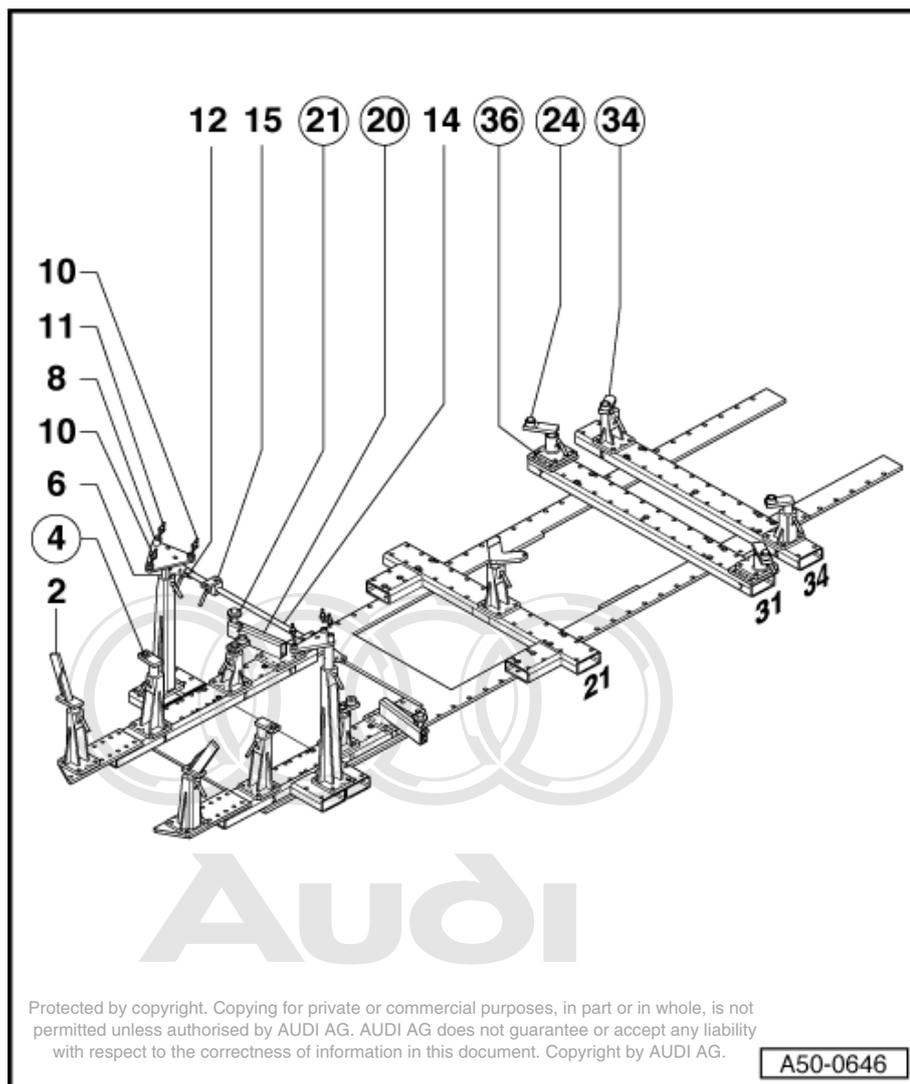
20 - Bracket without MZ, and
front production mounting -21-

22 - MZ 200 (quattro only)

24 - MZ 080

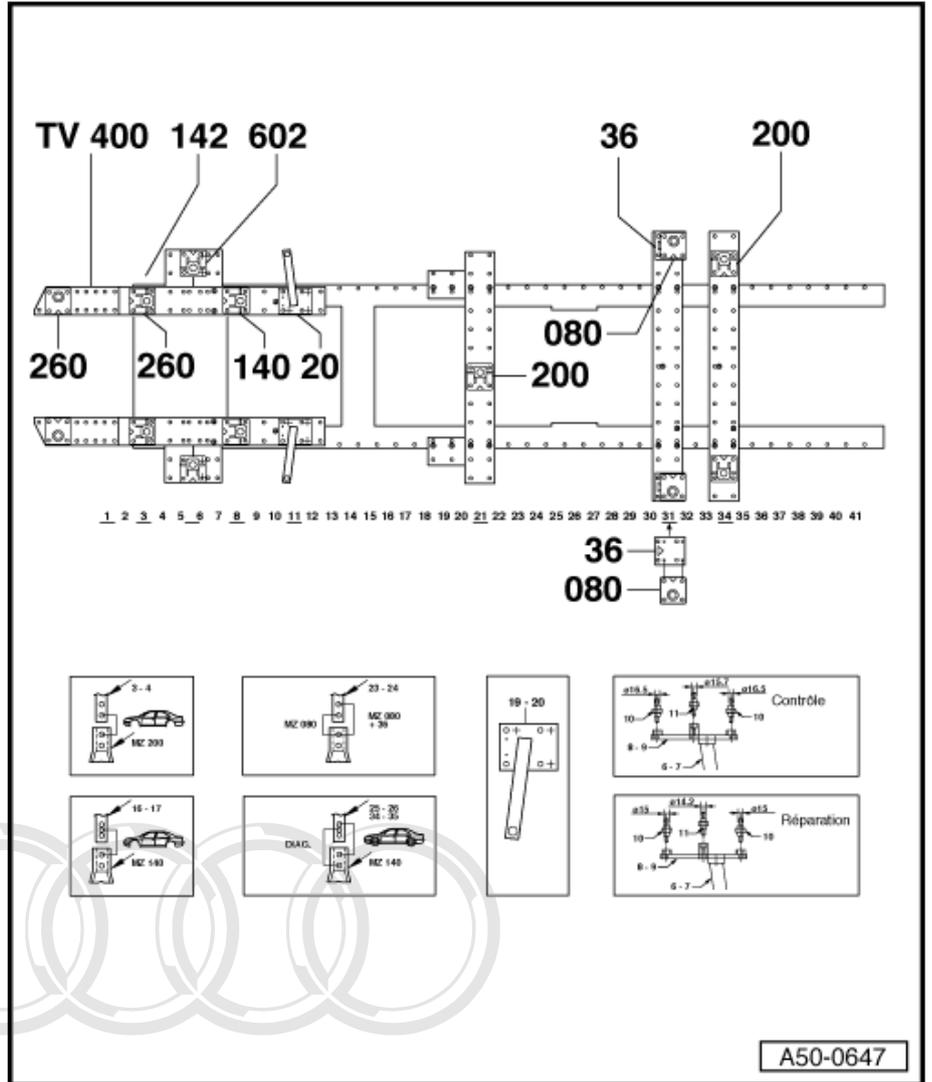
34 - MZ 140

36 - Base plate



Overview of alignment brackets for long A8 vehicles (130 mm longer) when repairing front-end damage

- 2 - MZ 200 and TV 400
- 4 - MZ 260
- 6 - MZ 602
- 16 - MZ 140
- 22 - MZ 200
- 24 - MZ 080
- 34 - MZ 140



Overview of MZ elements for long A8 vehicles (130 mm longer) when repairing front-end damage

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4 - MZ 080

5 - Spacer

16 - MZ 080

18 - Left and right centring
piece identical20 - Bracket without MZ, and
front production mounting -21-

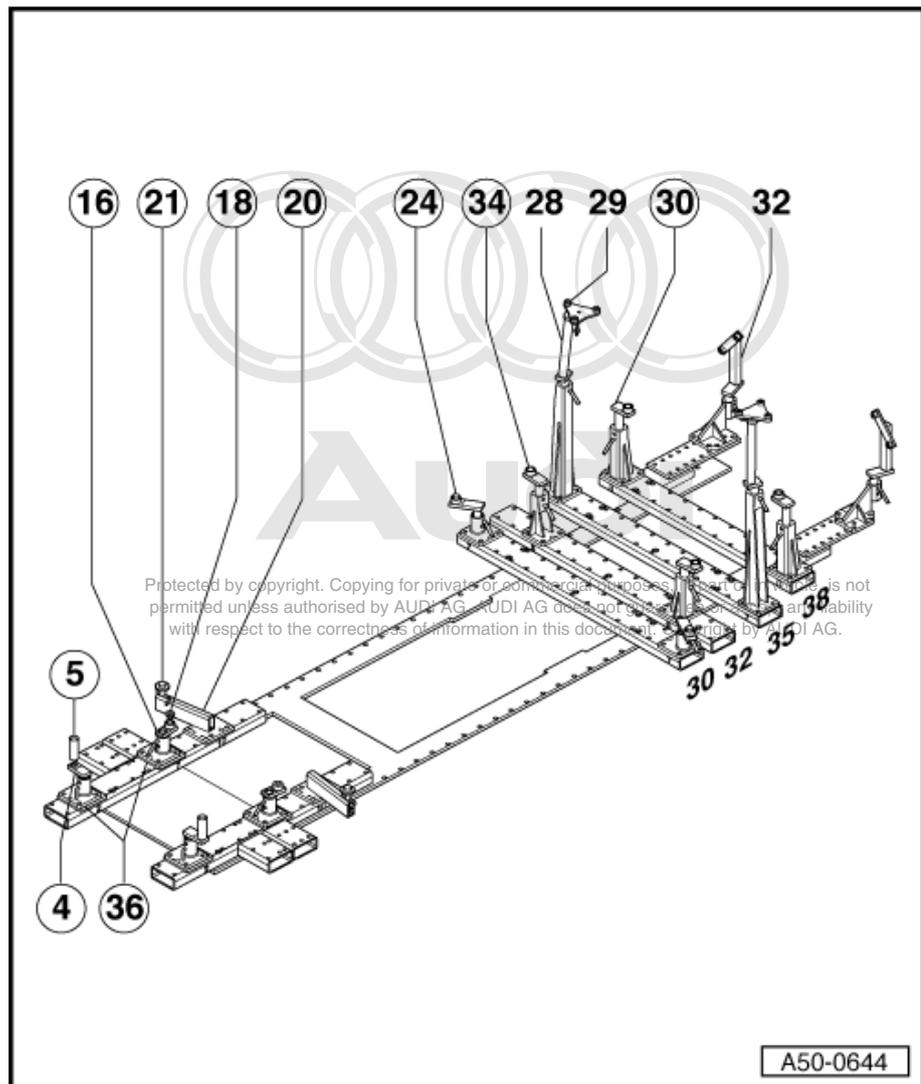
24 - MZ 080

28 - MZ 602 and alignment
bracket mounting 29

30 - MZ 260

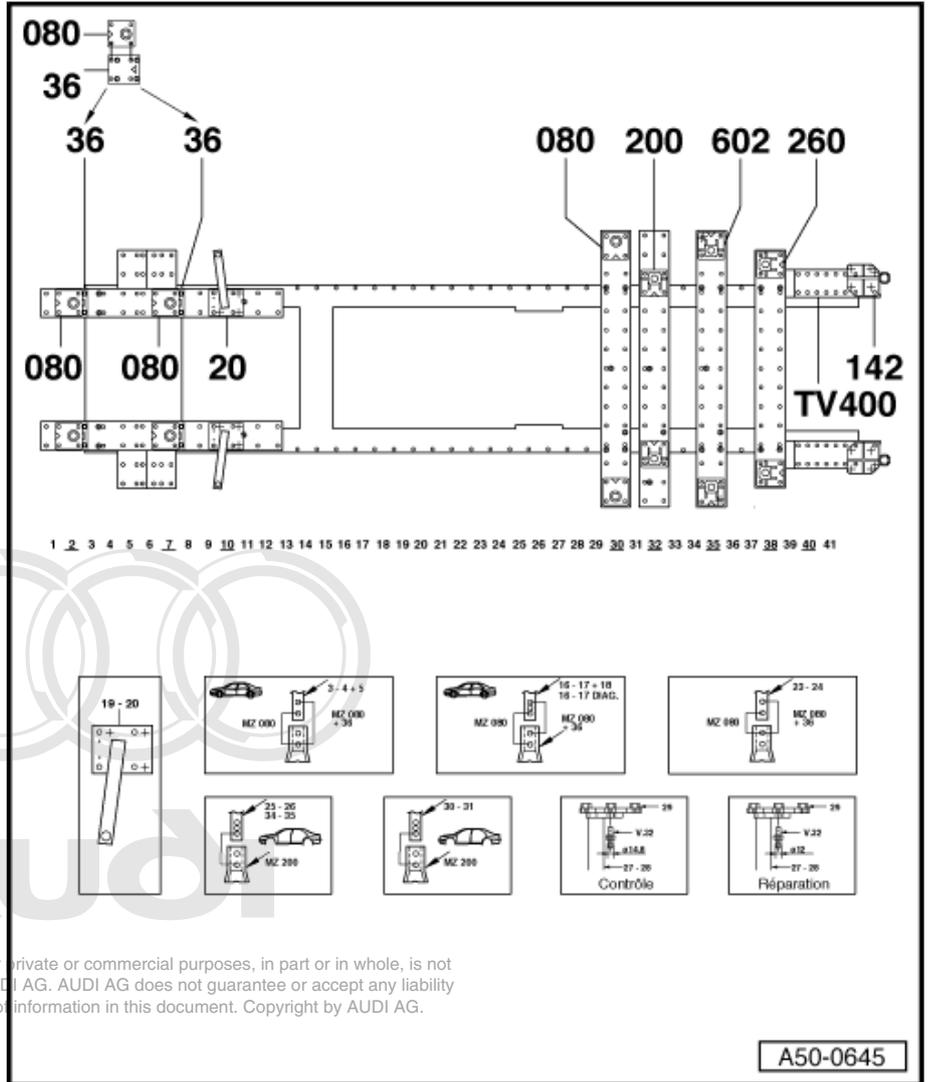
32 - MZ 142 and TV 400

34 - MZ 200



Overview of alignment brackets for long A8 vehicles (130 mm longer) when repairing rear-end damage

- 4 - MZ 080 and base plate 36
- 16 - MZ 080 and base plate 36
- 20 - Bracket without MZ, and front production mounting -21-
- 24 - MZ 080
- 28 - MZ 602 and alignment bracket mounting 29
- 30 - MZ 260
- 32 - MZ 142 and TV 400
- 34 - MZ 200



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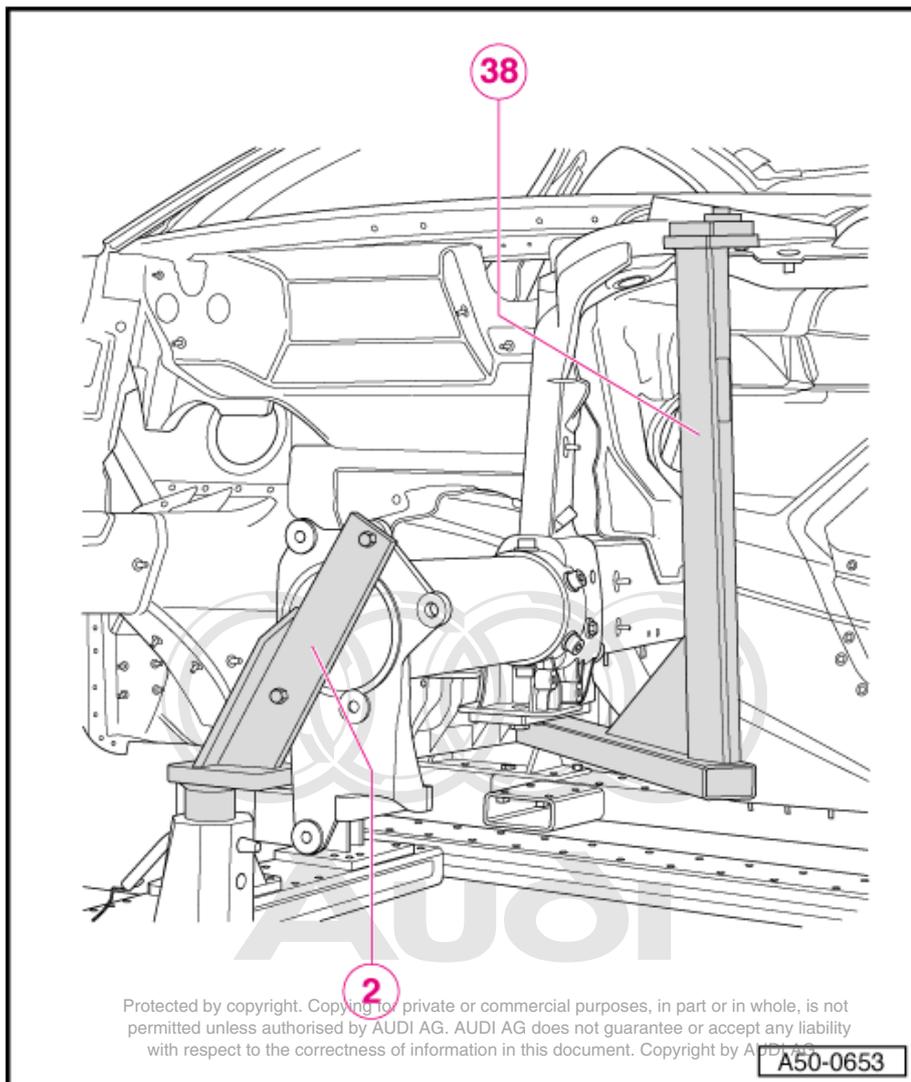
Overview of MZ elements for long A8 vehicles (130 mm longer) when repairing rear-end damage

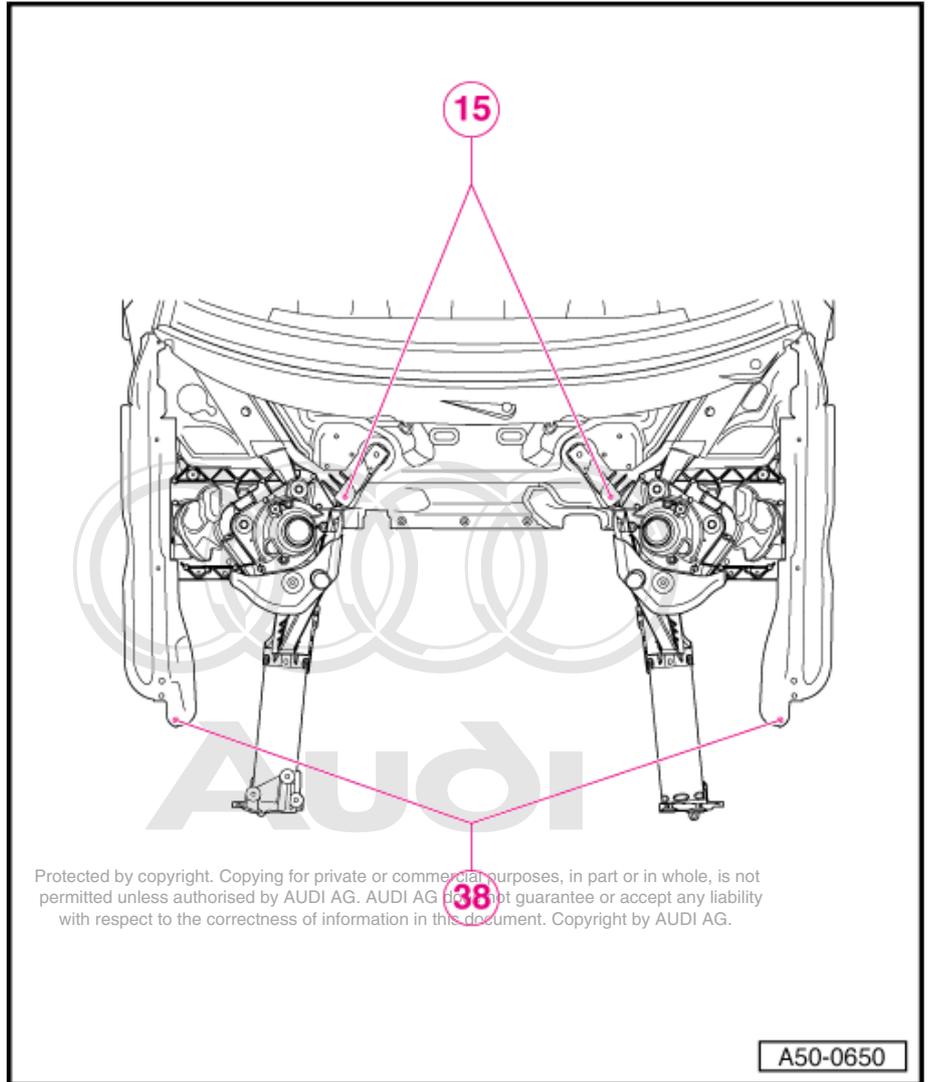
2 - Front longitudinal member

When checking, bolt on MZ last, as the longitudinal position of the impact damper mounting can vary by several mm due to production tolerances - if necessary do not bolt down.

3 - Spacer

38 - Front longitudinal member / top of wheel housing



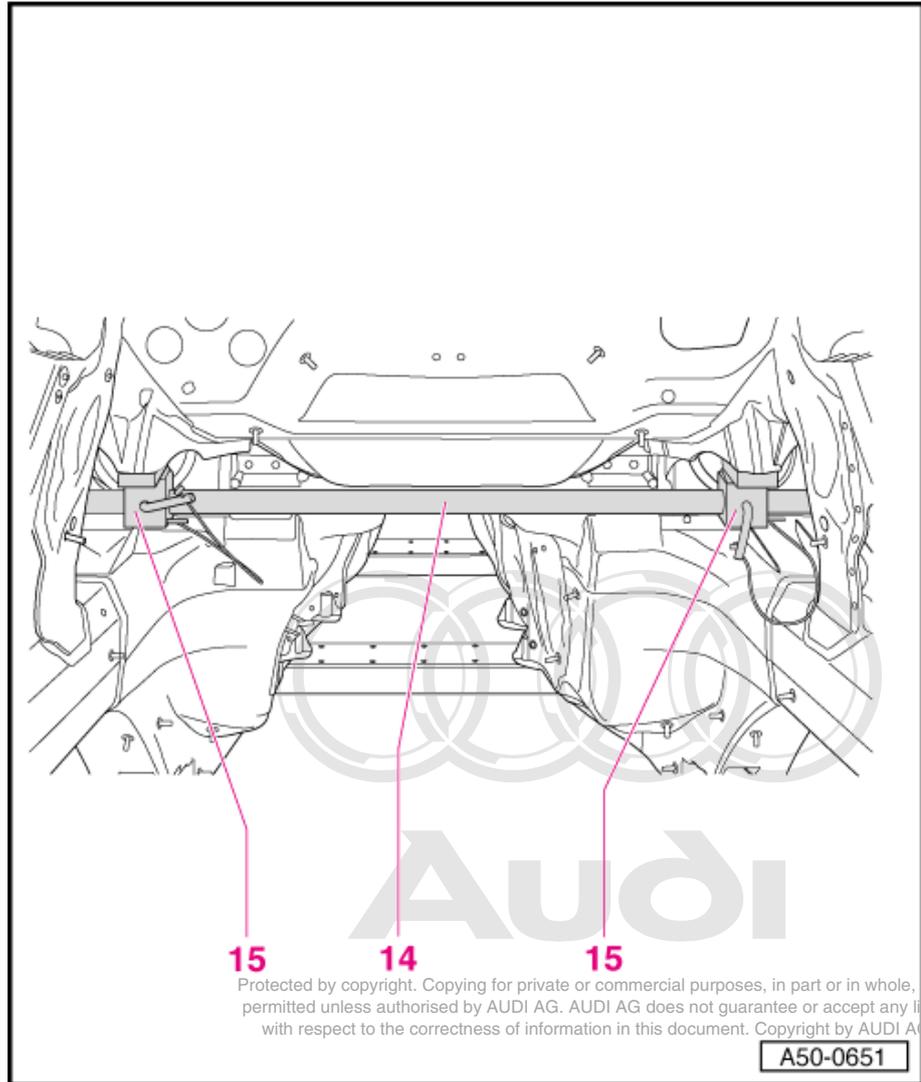


Overview of front alignment brackets

14 - Bar in place of steering box

Lubricate bar with oil and take care to avoid damage.

15 - Mounting for steering



4 - Mounting for front longitudinal member

6 - Mounting for suspension strut and alignment bracket mounting -8-

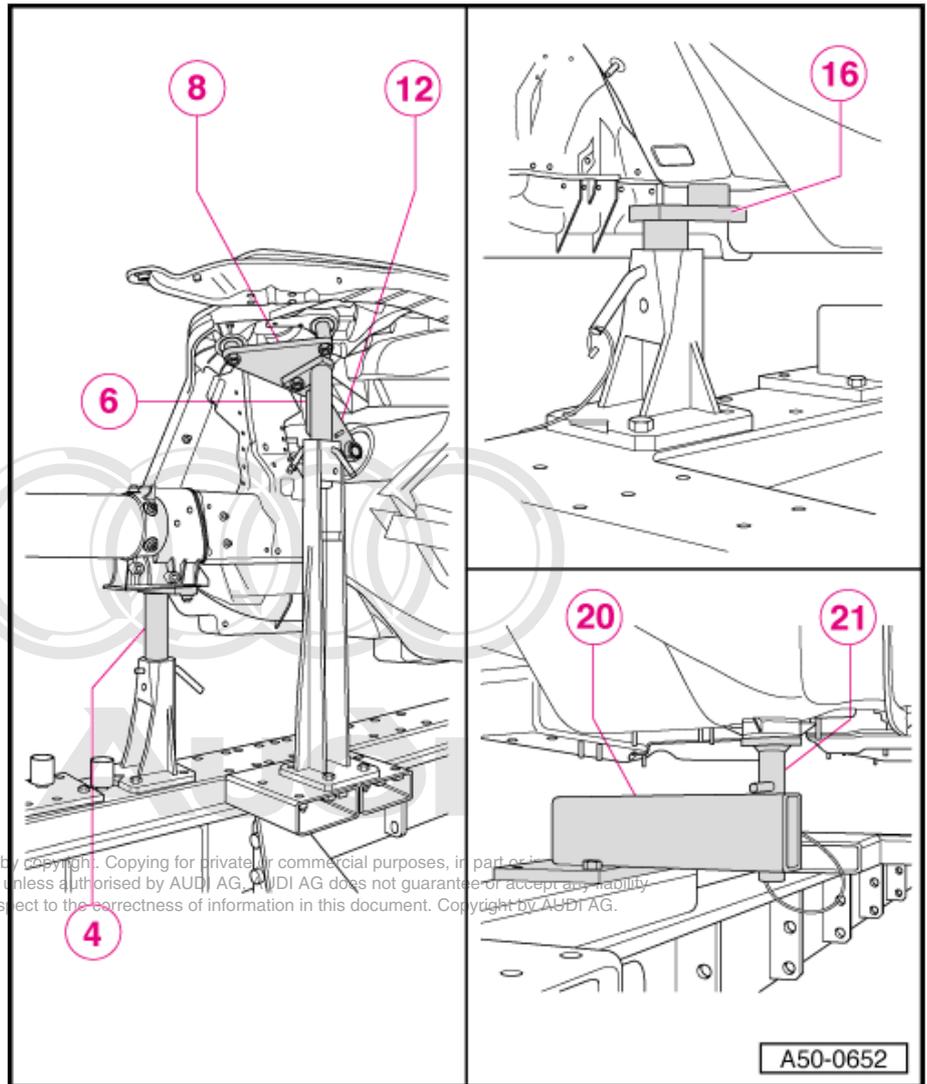
12 - Mounting for bar

16 - Mounting for front longitudinal member

20 - Bracket

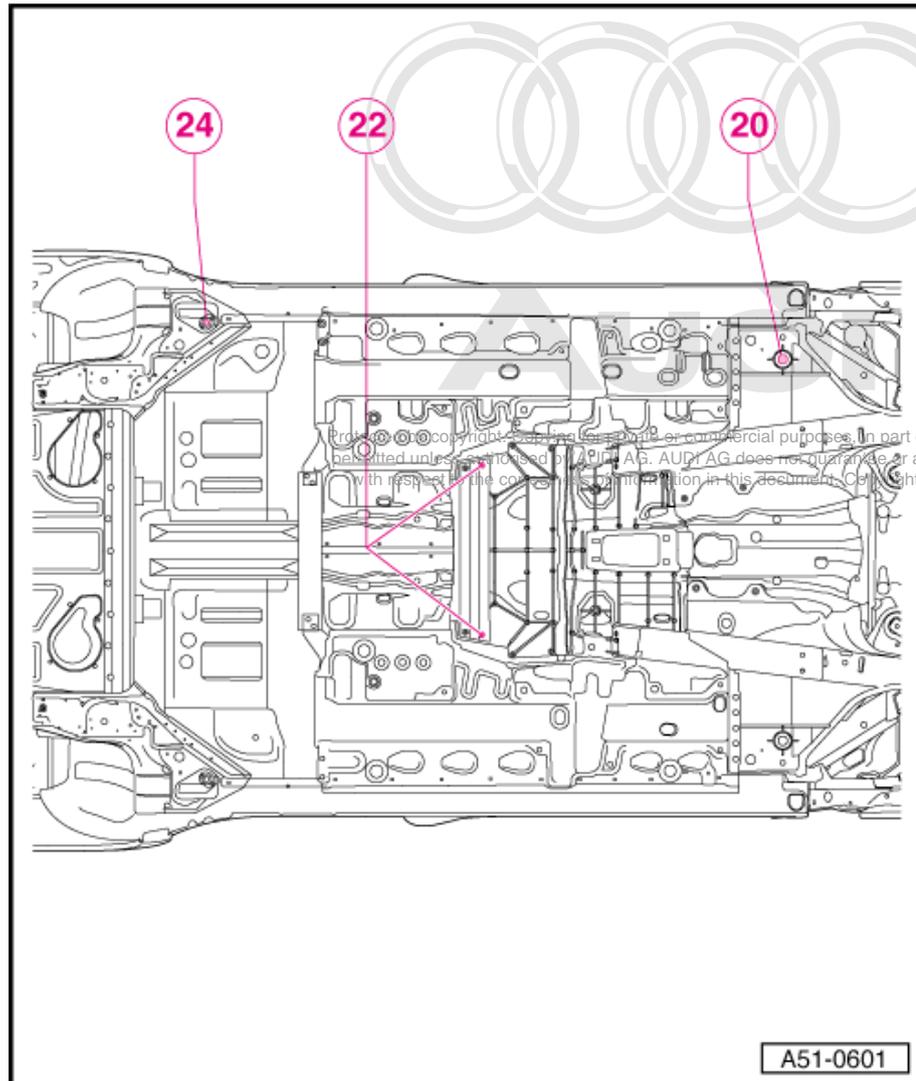
21 - Front production mounting

May have been forced upwards by handling vehicle in factory: when checking dimensions, pack with spacer up to 4 mm if necessary



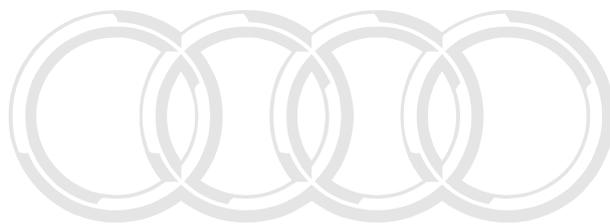
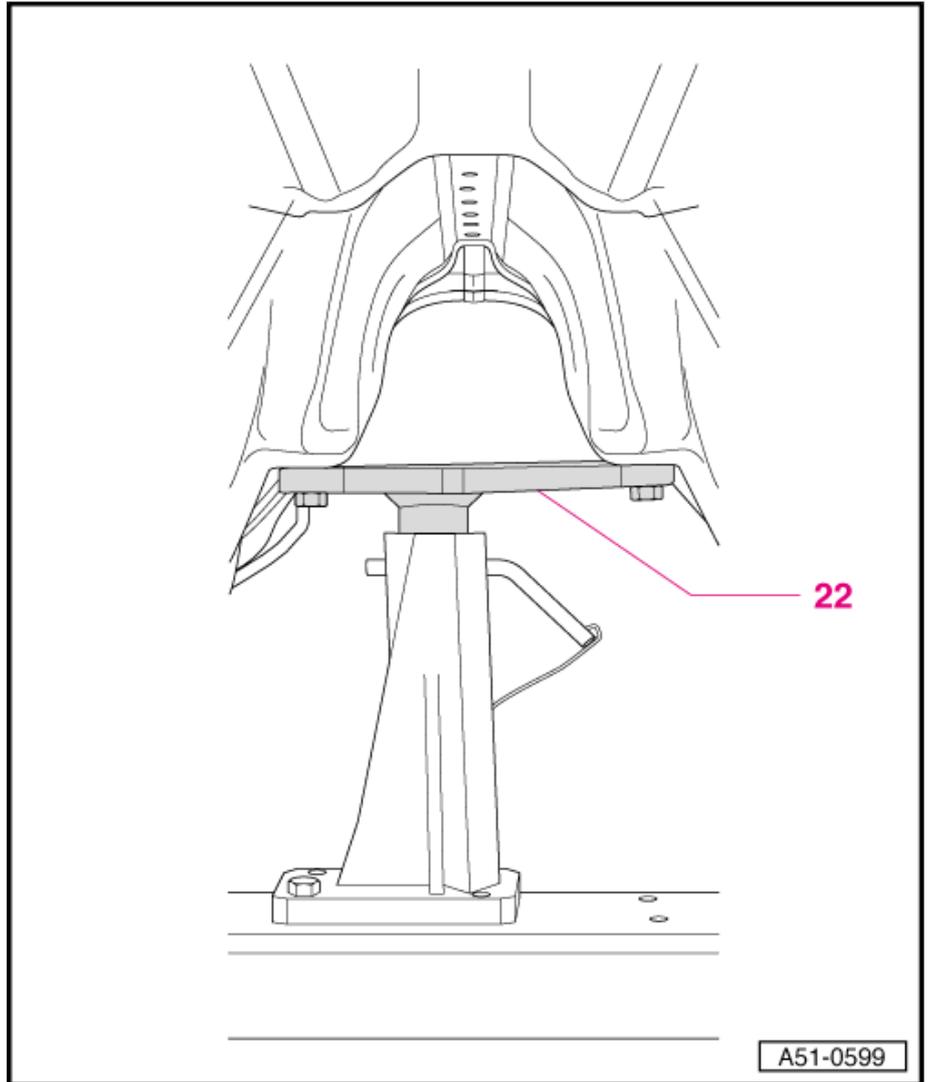
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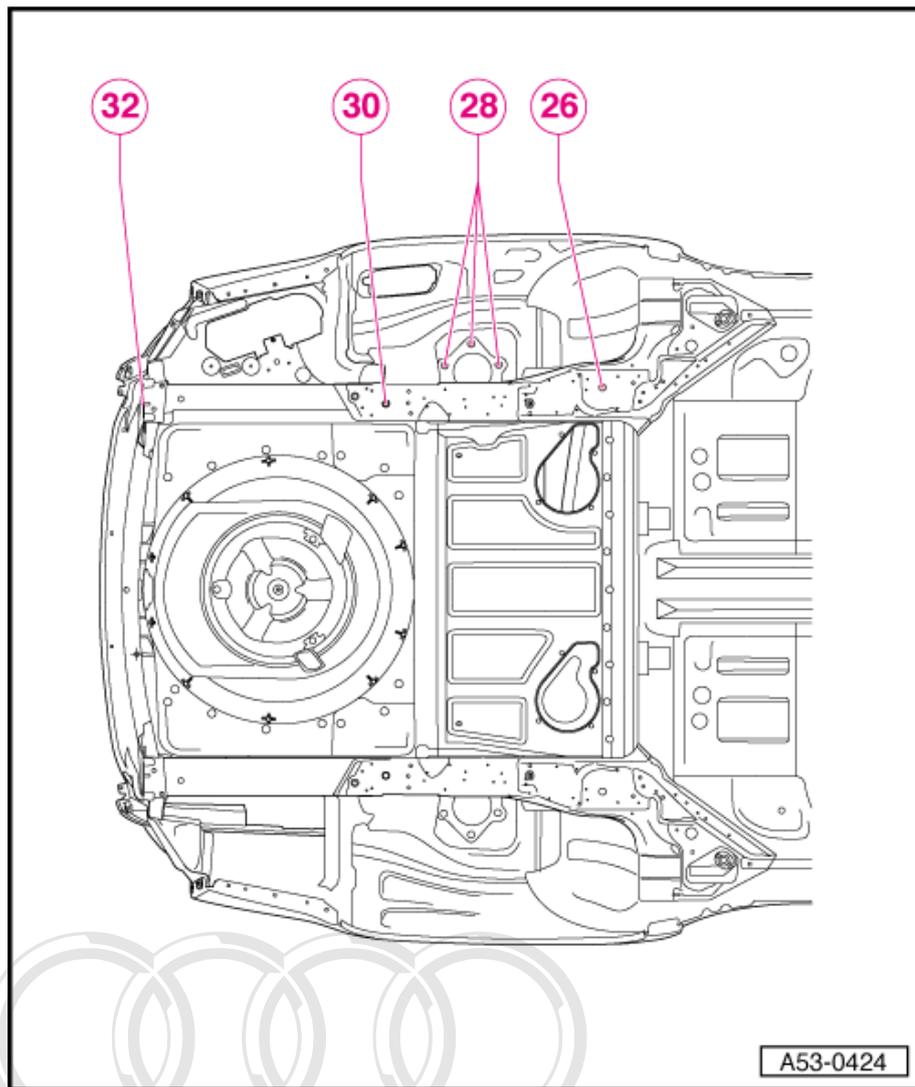
Overview of front alignment brackets

**22 - Mounting for propshaft
(quattro only)**



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Overview of centre alignment brackets



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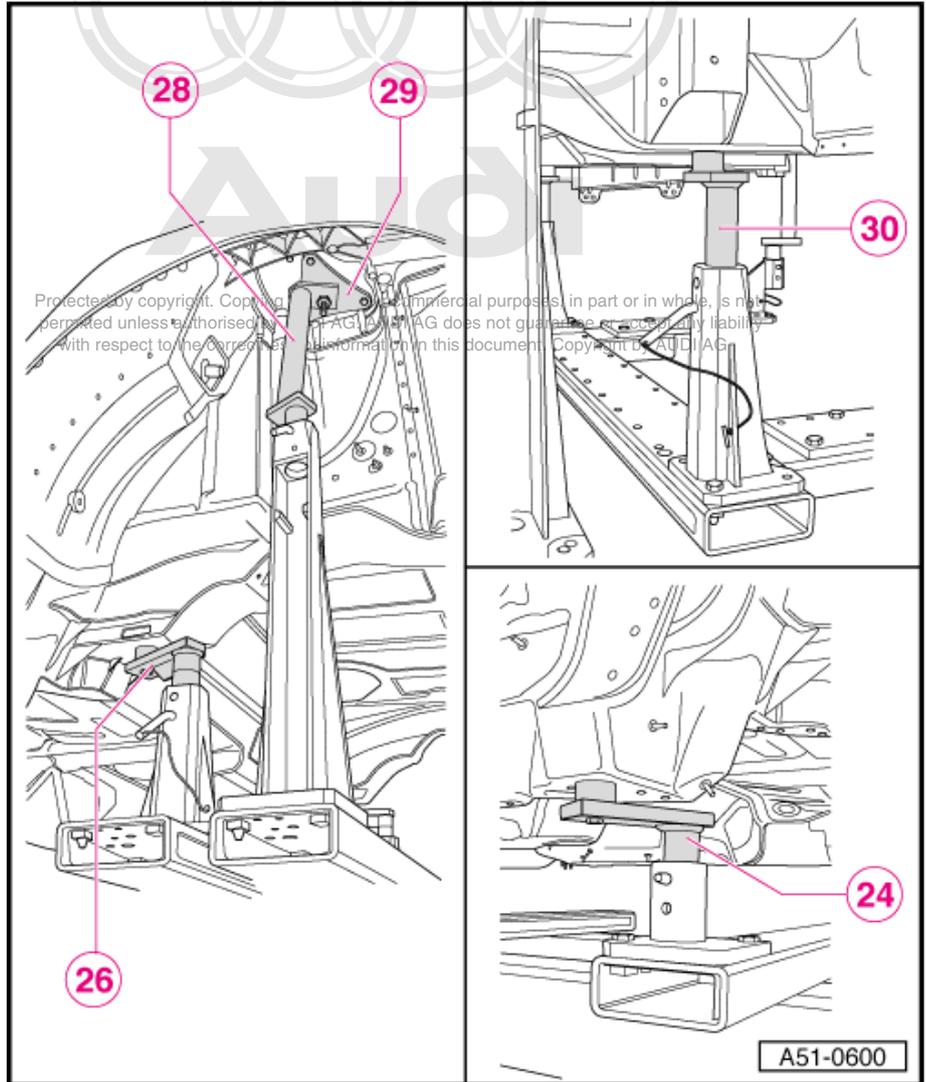
26 - Mounting for rear axle

Do not insert pin until after fitting body on jig.

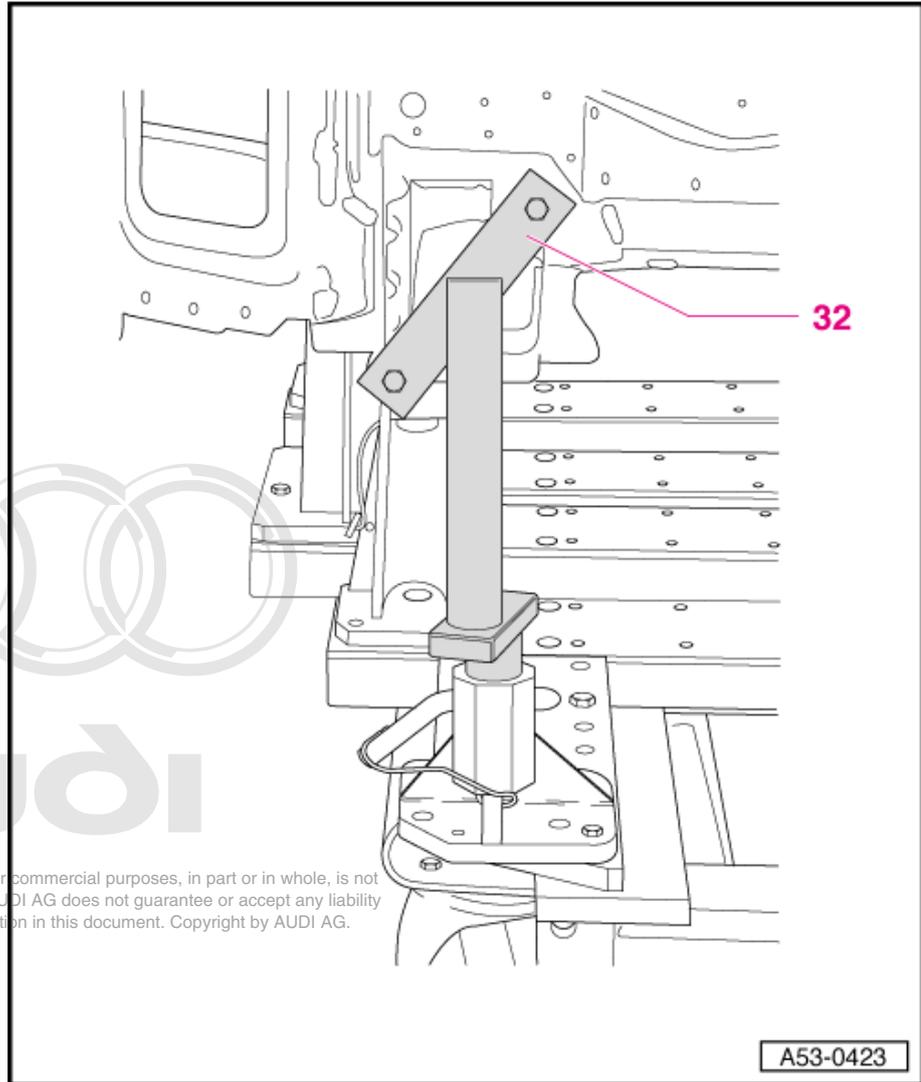
28 - Suspension strut mounting

Do not insert pin until after fitting body on jig.

30 - Mounting for rear axle



32 - Mounting for rear longitudinal member



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Overview of rear alignment brackets

6.1 Portal gauge

Portal gauge -VAS 5007/15-

A - Extension

B - Telescopic column

C - Cross bar 1200 mm

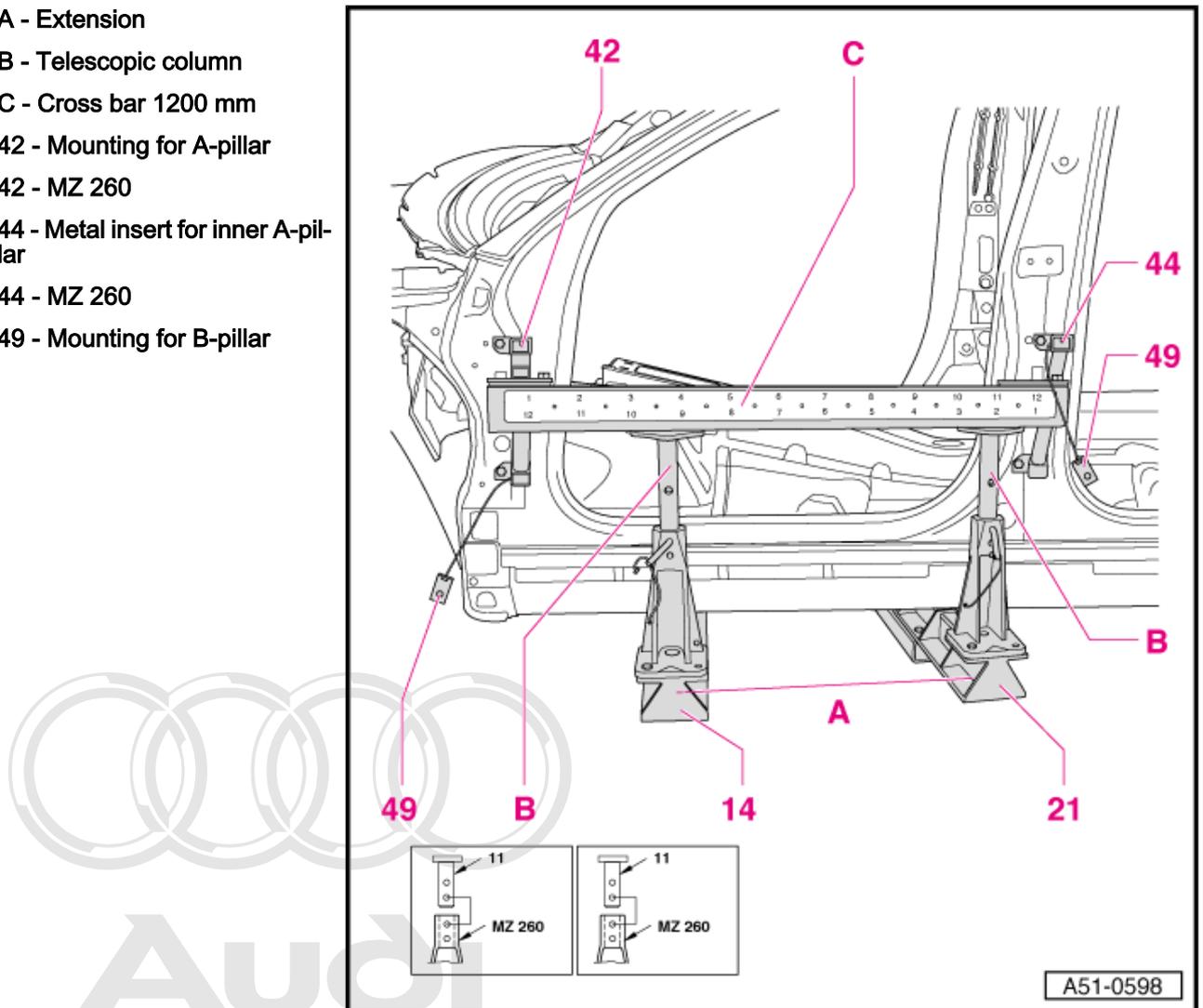
42 - Mounting for A-pillar

42 - MZ 260

44 - Metal insert for inner A-pillar

44 - MZ 260

49 - Mounting for B-pillar

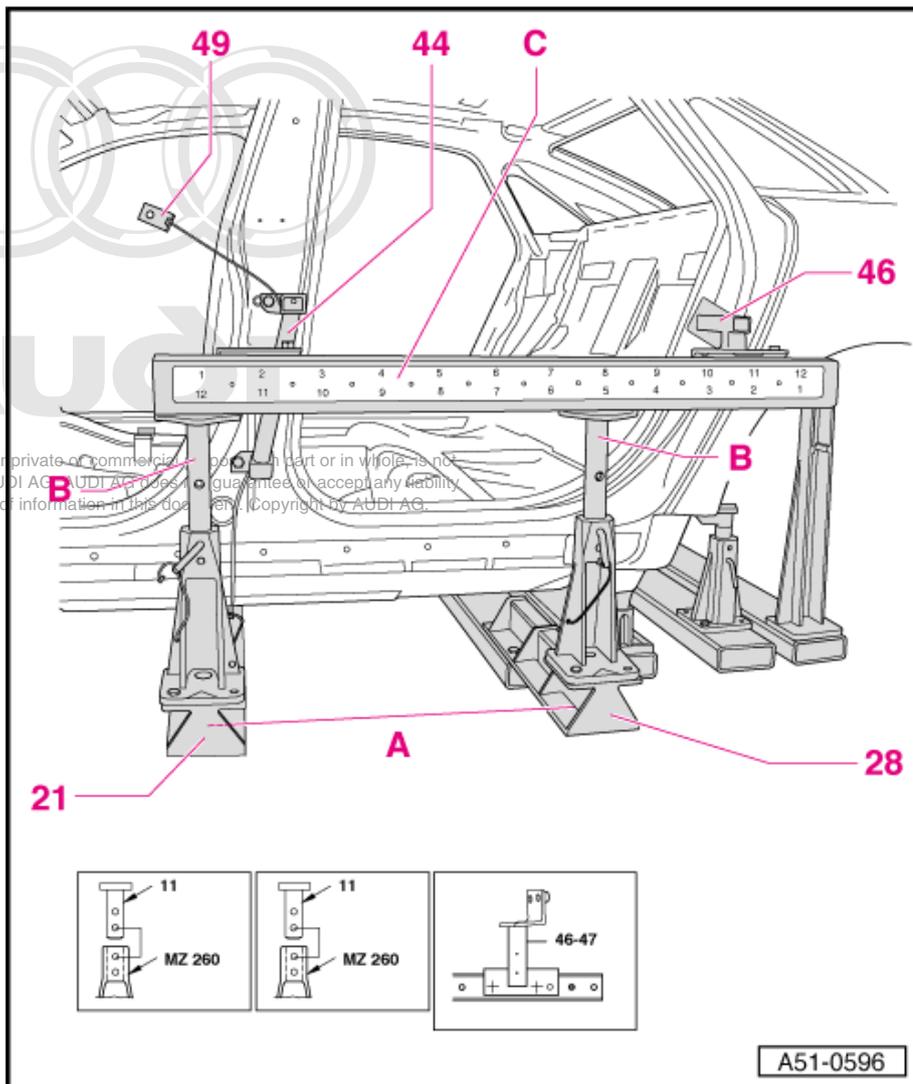


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- A - Extension
- B - Telescopic column
- C - Cross bar 1200 mm
- 44 - Metal insert for inner A-pillar
- 44 - MZ 260
- 49 - Mounting for B-pillar
- 46 - Mounting for A-pillar
- 46 - MZ 260

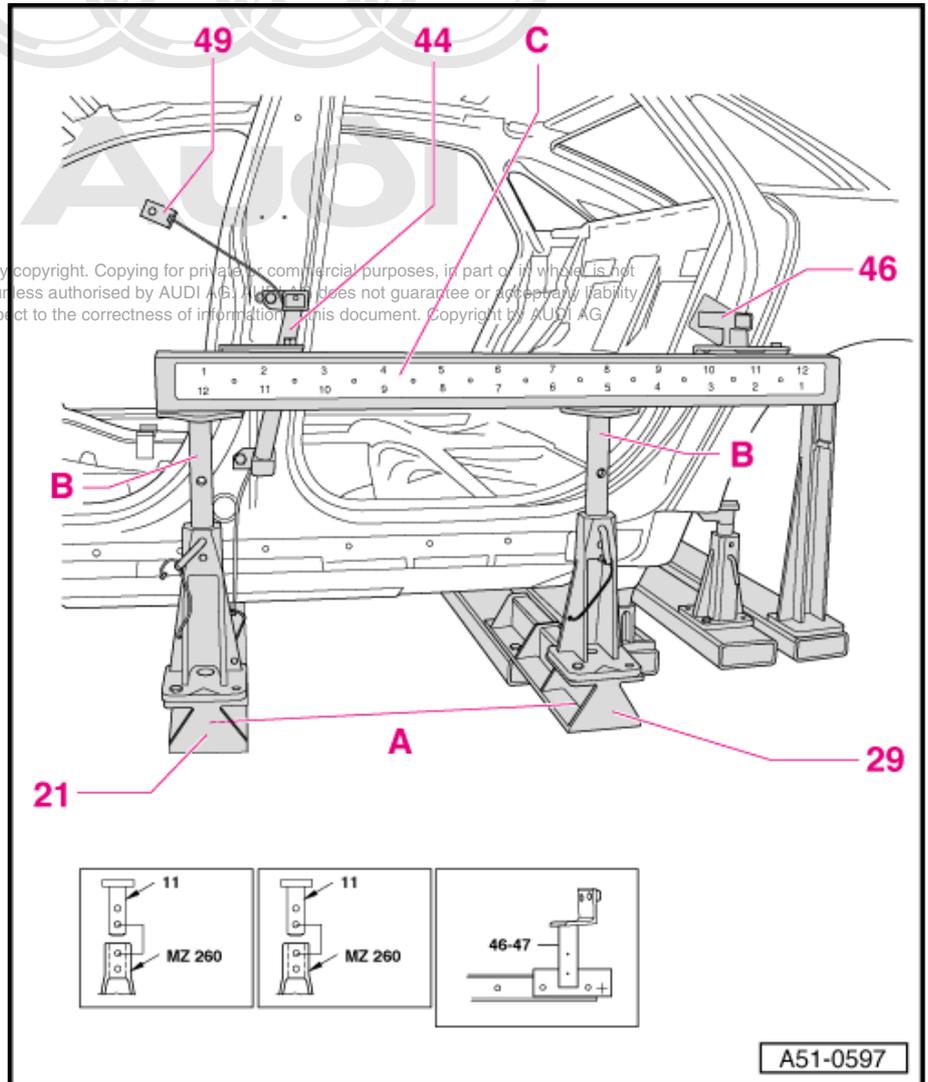
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A51-0596

6.1.1 Portal gauge for long Audi A8

- A - Extension
- B - Telescopic column
- C - Cross bar 1200 mm
- 44 - Metal insert for inner A-pillar
- 44 - MZ 260
- 49 - Mounting for B-pillar
- 46 - Mounting for A-pillar
- 46 - MZ 260



50 – Body - front

RO: 50 72 55 00

1 Wing mounting flange - Renewal



WARNING

Always observe safety precautions.

Safety notes ⇒ General Information; Body Repairs, General Body Repairs ; Safety notes .

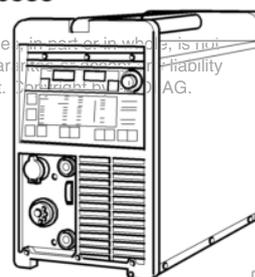
1.1 Tools

Special tools and workshop equipment required

- ◆ Compact angle grinder -VAS 5167-
- ◆ Shielded arc welding equipment 250A

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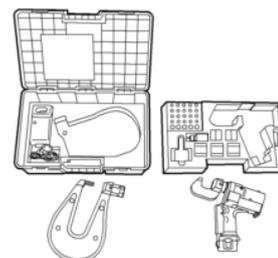
VAS 6388



W00-10622

- ◆ Rechargeable riveter -VAS 5279A-

VAS 5279 A



W00-10641

1.2 Procedure

Cutting locations

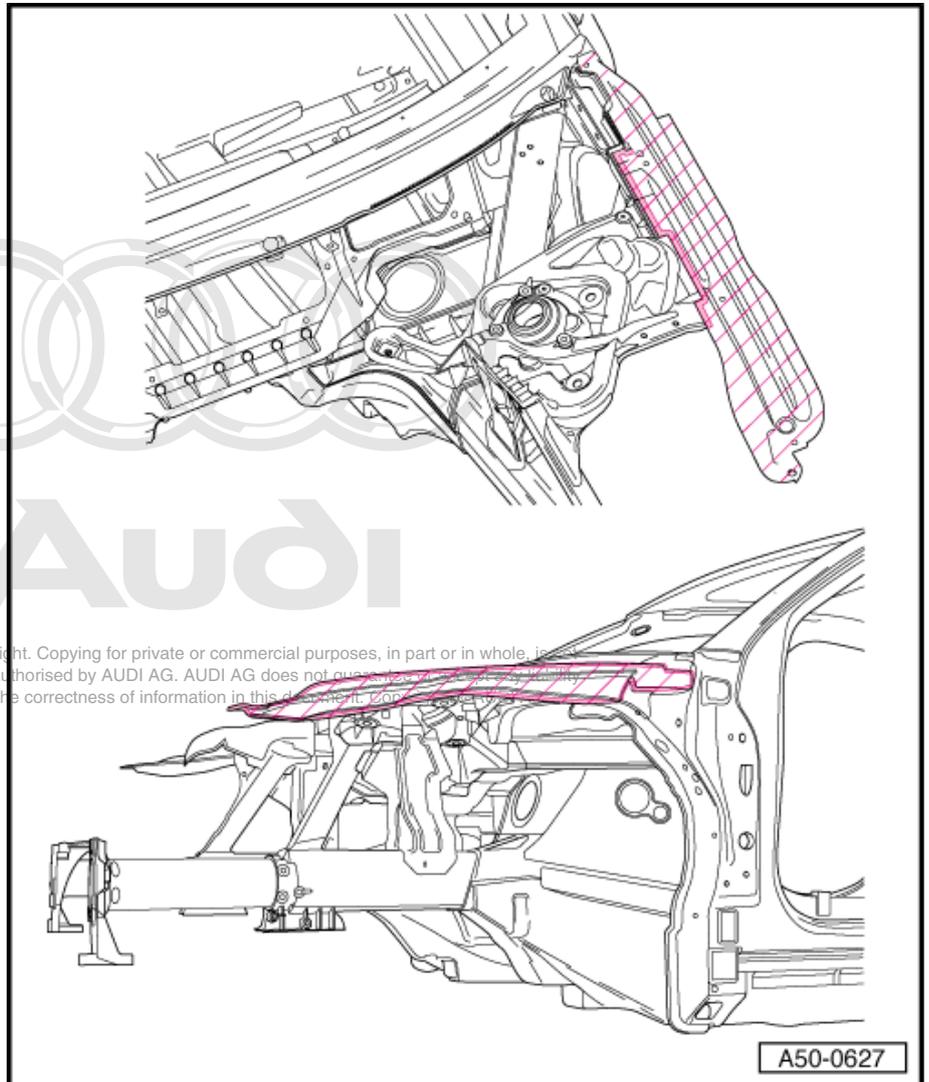


WARNING

Take care not to damage node castings and extruded sections when cutting.

- Separate weld seams using compact angle grinder -VAS 5167- .
- Separate original joint with rechargeable riveter -VAS 5279A- .

- Remove small punch rivets. Use rechargeable riveter -VAS 5279A- with attachments S1 and D2 from -VAS 5279/2 - or rechargeable riveter -VAS 5279B- with attachments S1 and D2 .
- Detach part.



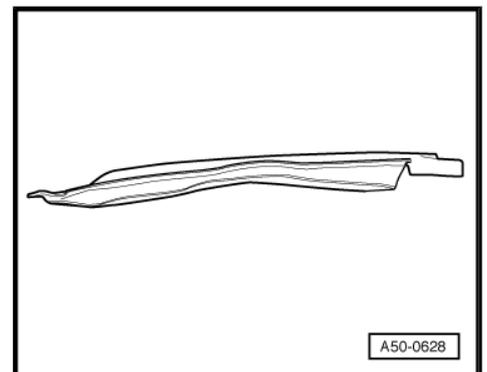
Replacement part

- ◆ Wing mounting strip

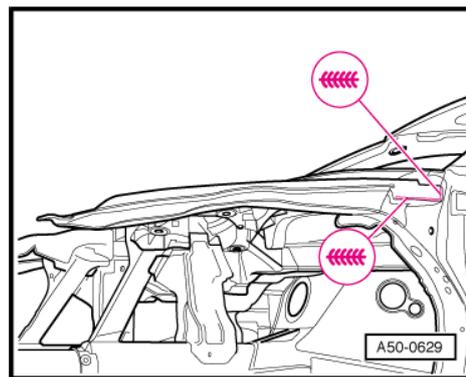
Preparing new parts

- Match up new parts.
- Prepare flanges on body and new parts for welding.
- Fix new part in position with alignment bracket.

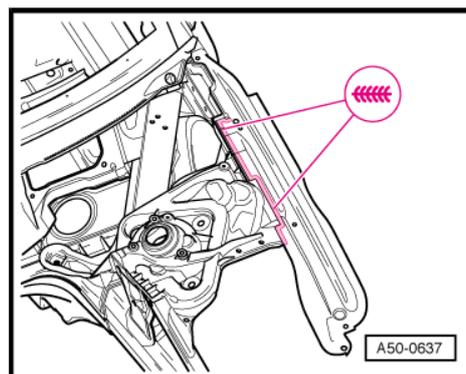
Welding in



- Weld wing mounting flange to A-pillar using shielded arc welding equipment 250A : SG continuous seam.



- Weld wing mounting flange to node casting on suspension strut mounting using shielded arc welding equipment 250A : SG continuous seam.



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RO: 50 72 55 02

2 Wing mounting flange - Partial renewal



WARNING

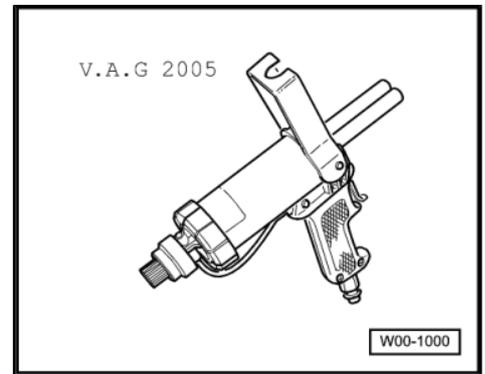
Always observe safety precautions.

Safety notes ⇒ General Information; Body Repairs, General Body Repairs ; Safety notes .

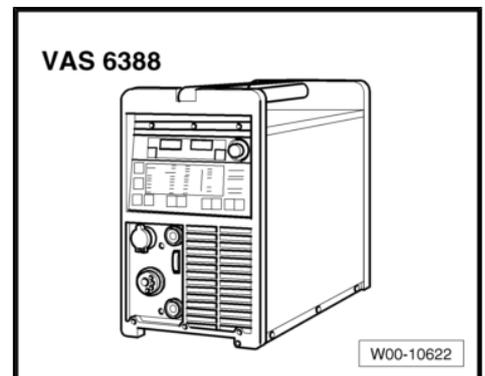
2.1 Tools

Special tools and workshop equipment required

- ◆ Compact angle grinder -VAS 5167-
- ◆ Pneumatic glue gun -V.A.G 2005 B-



- ◆ Shielded arc welding equipment 250A



2.2 Procedure

Cutting locations

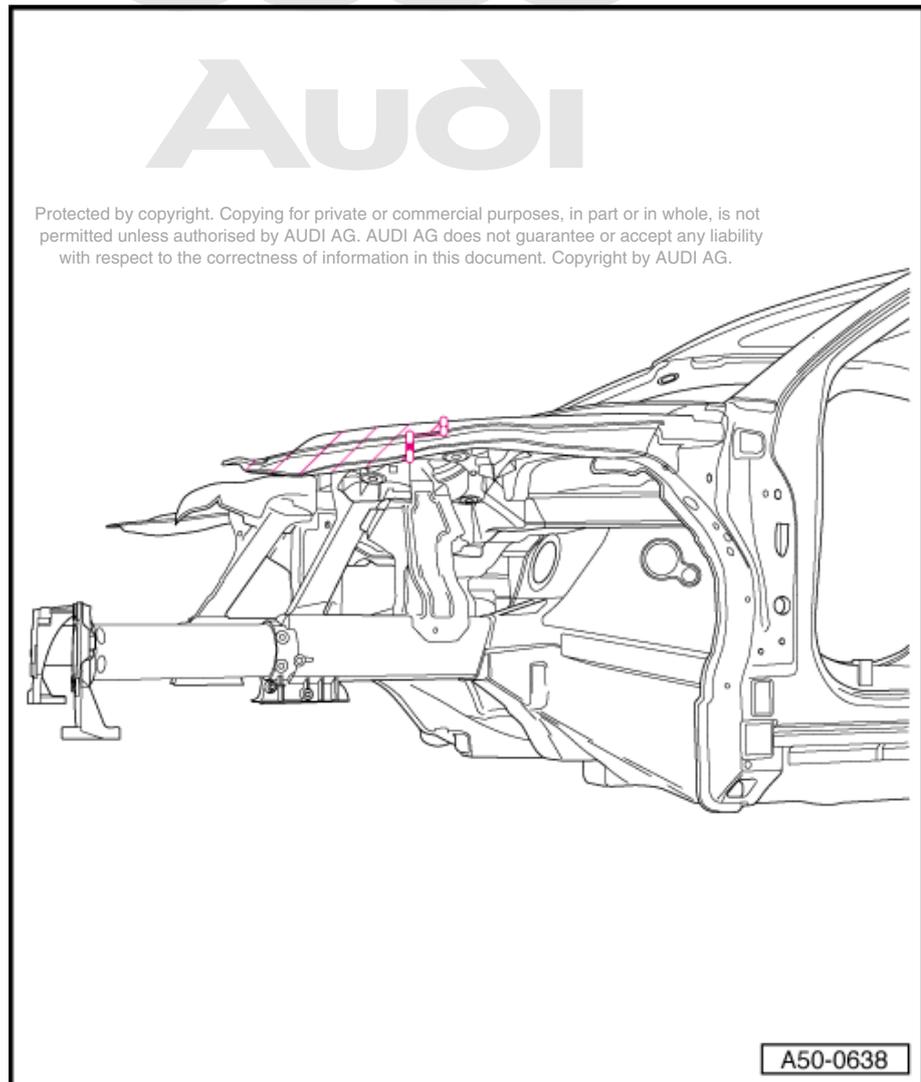


WARNING

Take care not to damage node castings and extruded sections when cutting.

- Remove small punch rivets. Use rechargeable riveter -VAS 5279A- with attachments S1 and D2 from -VAS 5279/2 - or rechargeable riveter -VAS 5279B- with attachments S1 and D2 .
- Make separating cut as shown using pneumatic sabre saw - V.A.G 1523A- .

- Detach part.



Replacement part

- ◆ Punch rivets (self-piercing rivets)
- ◆ 2-component epoxy adhesive -DA 001 730 A2-
- ◆ Silicone remover -LSE 020 100 A3-
- ◆ Silicate stone -DA 009 800 -
- ◆ Aluminium primer -DA 009 801 -
- ◆ Applicator -D 009 500 25 -
- ◆ Wing mounting flange (sub-part)

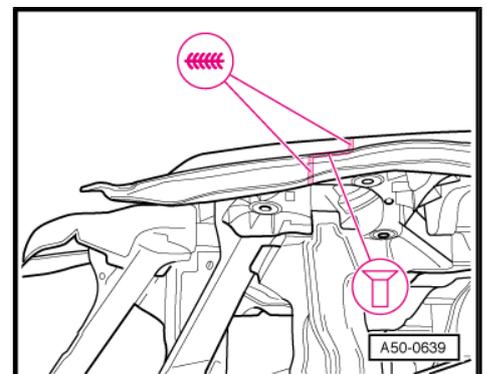
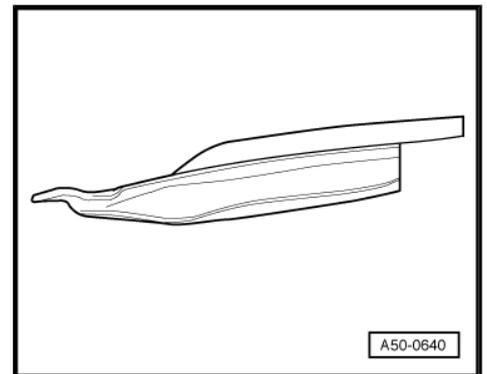
Preparing joints for adhesive application

- Clean bonding area with silicone remover - LSE 020 100 A3- .
- Prepare bonding area with silicate stone -DA 009 800 - and clean.
- Apply aluminium primer -DA 009 801 - to bonding surfaces using applicator -D 009 500 25 - .
- Apply 2-component body adhesive -DA 001 730 A2- to entire riveting area using pneumatic glue gun -V.A.G 2005 B- .

Inserting new part

- Fix new part in position with alignment bracket.
- Prepare flanges on body and new parts for welding.
- Weld in new part using shielded arc welding equipment 250A : SG continuous seam.
- Rivet in new part using rechargeable riveter -VAS 5279A- .
- Use rechargeable riveter -VAS 5279A- with attachments S2 and S3 from -VAS 5279/2 - or rechargeable riveter -VAS 5279B- with attachments S2 and S3 .

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RO: 50 74 55 00

3 Front wheel housing - Renewal

**WARNING**

Always observe safety precautions.

Safety notes ⇒ General Information; Body Repairs, General Body Repairs ; Safety notes .

3.1 Procedure

Special tools and workshop equipment required

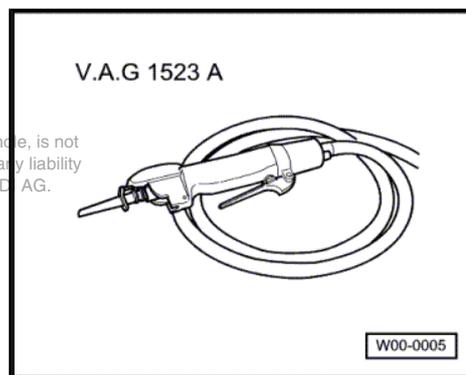
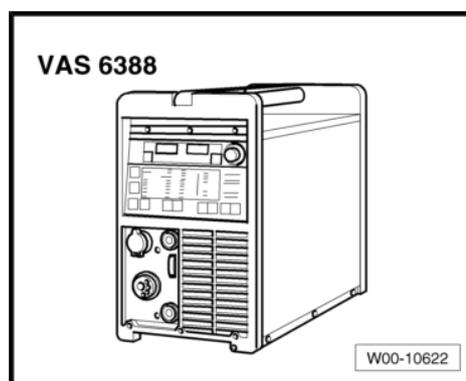
- ◆ Compact angle grinder -VAS 5167-
- ◆ Shielded arc welding equipment 250A



- ◆ Pneumatic sabre saw -V.A.G 1523A-

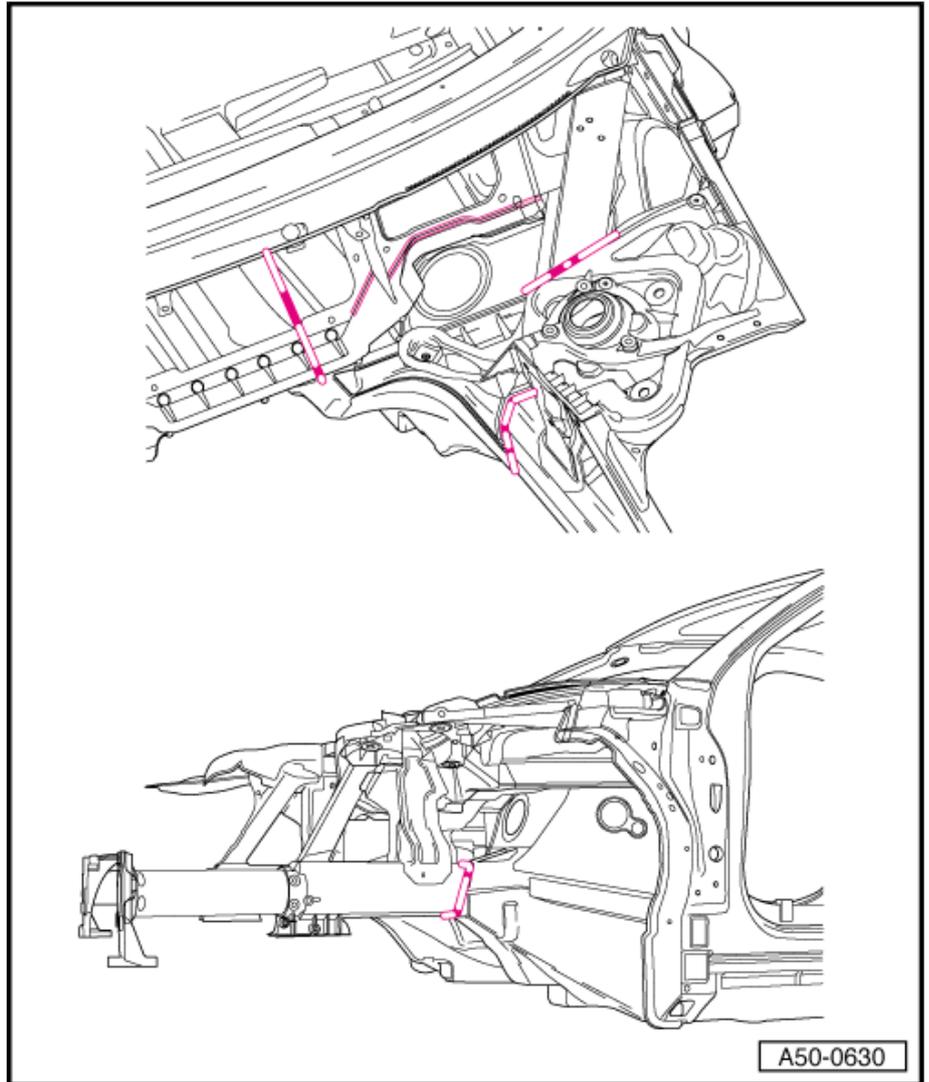


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**WARNING**

Take care not to damage node castings and extruded sections when cutting.

- Make separating cut in plenum chamber as shown using pneumatic sabre saw -V.A.G 1523A- .
- Make separating cut in support for suspension strut mounting as shown using pneumatic sabre saw -V.A.G 1523A- .
- Make separating cut in longitudinal member in front of node casting as shown using pneumatic sabre saw -V.A.G 1523A- .
- Detach wheel housing.
- Remove remaining material from node casting using compact angle grinder -VAS 5167- .

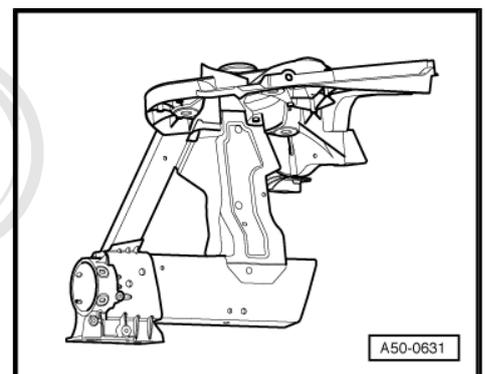


Replacement part

- ◆ Wheel housing - front section

Welding in

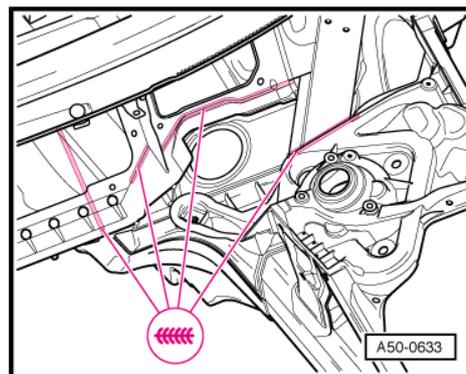
- Prepare flanges on body and new parts for welding.
- Fix new part in position with alignment bracket.
- Weld suspension strut mounting/subframe mount from underneath to plenum chamber using shielded arc welding equipment 250A : SG stepped seam.
- Weld suspension strut mounting to support using shielded arc welding equipment 250A : SG continuous seam.



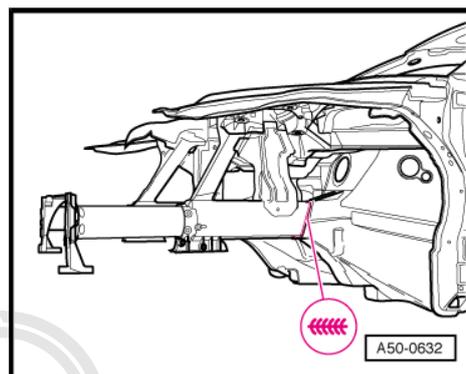
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- Place backing plate of same material behind joint with plenum chamber and weld in using shielded arc welding equipment 250A : SG continuous seam.



- Weld in front longitudinal member at node casting using shielded arc welding equipment 250A : SG continuous seam.



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RO: 50 79 55 03

4 Front longitudinal member - Renewal



WARNING

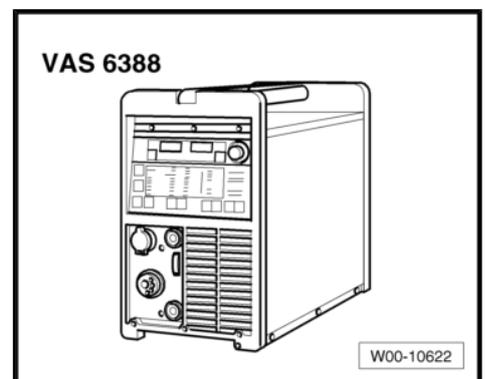
Always observe safety precautions.

Safety notes ⇒ General Information; Body Repairs, General Body Repairs ; Safety notes .

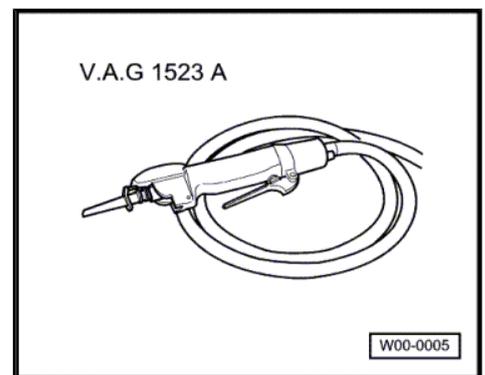
4.1 Tools

Special tools and workshop equipment required

- ◆ Compact angle grinder -VAS 5167-
- ◆ Shielded arc welding equipment 250A



- ◆ Pneumatic sabre saw -V.A.G 1523A-



4.2 Procedure



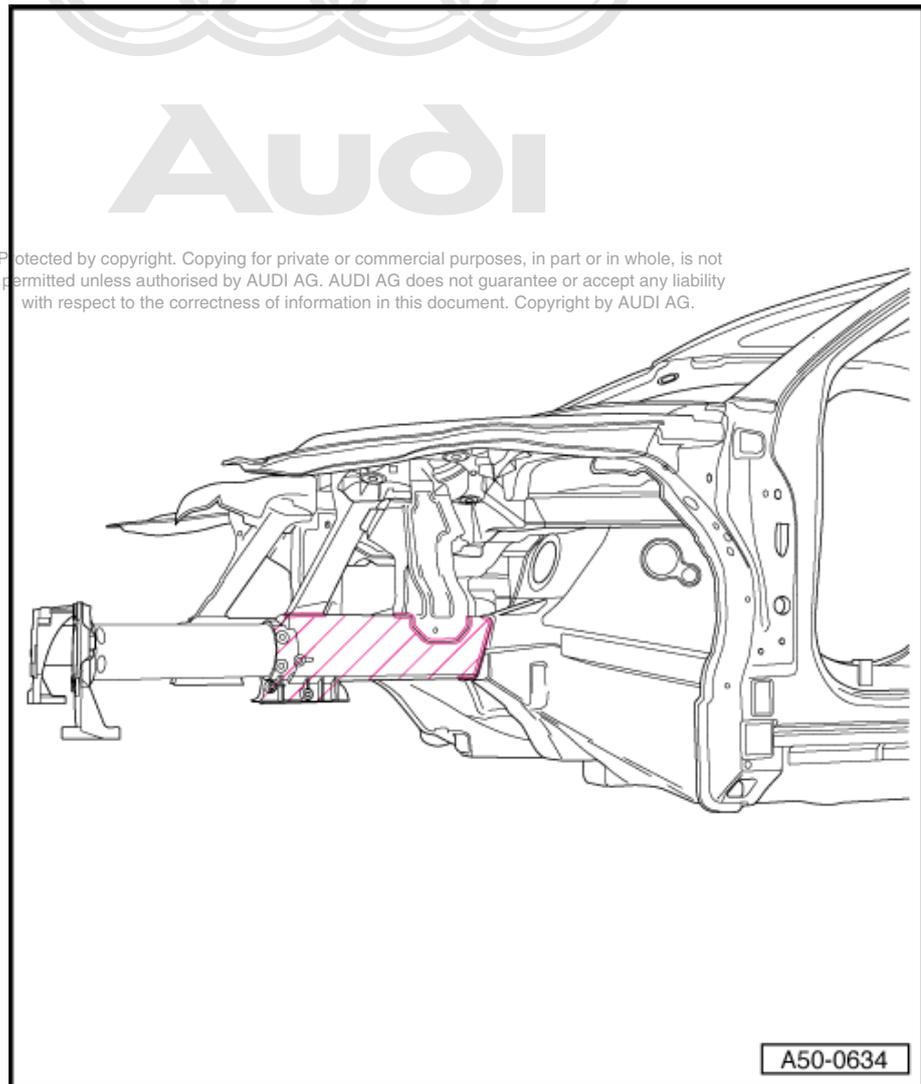
WARNING

Take care not to damage node castings and extruded sections when cutting.

Cutting locations

- Make separating cut at longitudinal member in front of node casting using pneumatic sabre saw -V.A.G 1523A- .
- Make separating cut at support plate and support using pneumatic sabre saw -V.A.G 1523A- .
- Detach longitudinal member.

- Remove remaining material from node casting using compact angle grinder -VAS 5167- .



Replacement part

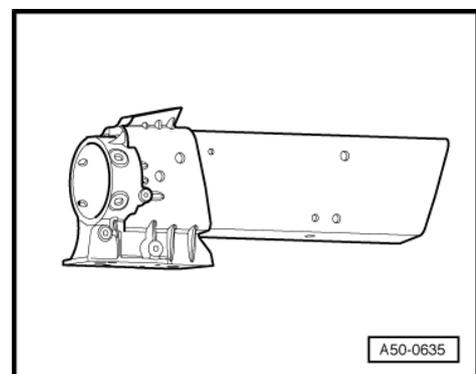
- ◆ Longitudinal member with moulded foam insert

Preparing new part

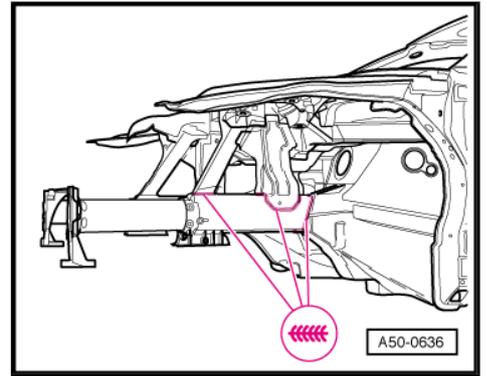
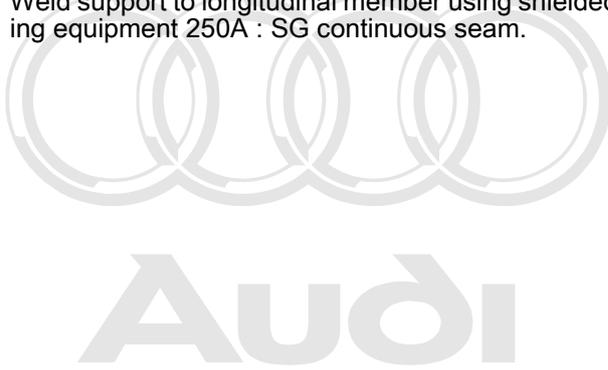
- Match up new part to body.
- Prepare flanges on body and new parts for welding.
- Fix longitudinal member in position on alignment bracket.

Welding in

- Weld in longitudinal member at node casting using shielded arc welding equipment 250A : SG continuous seam.
- Weld support plate for suspension strut mounting to longitudinal member using shielded arc welding equipment 250A : SG continuous seam.



- Weld support to longitudinal member using shielded arc welding equipment 250A : SG continuous seam.



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RO: 50 80 55 00

5 Longitudinal member (front section) - Renewal



WARNING

Always observe safety precautions.

Safety notes ⇒ General Information; Body Repairs, General Body Repairs ; Safety notes .

5.1 Procedure



WARNING

Take care not to damage aluminium node castings.

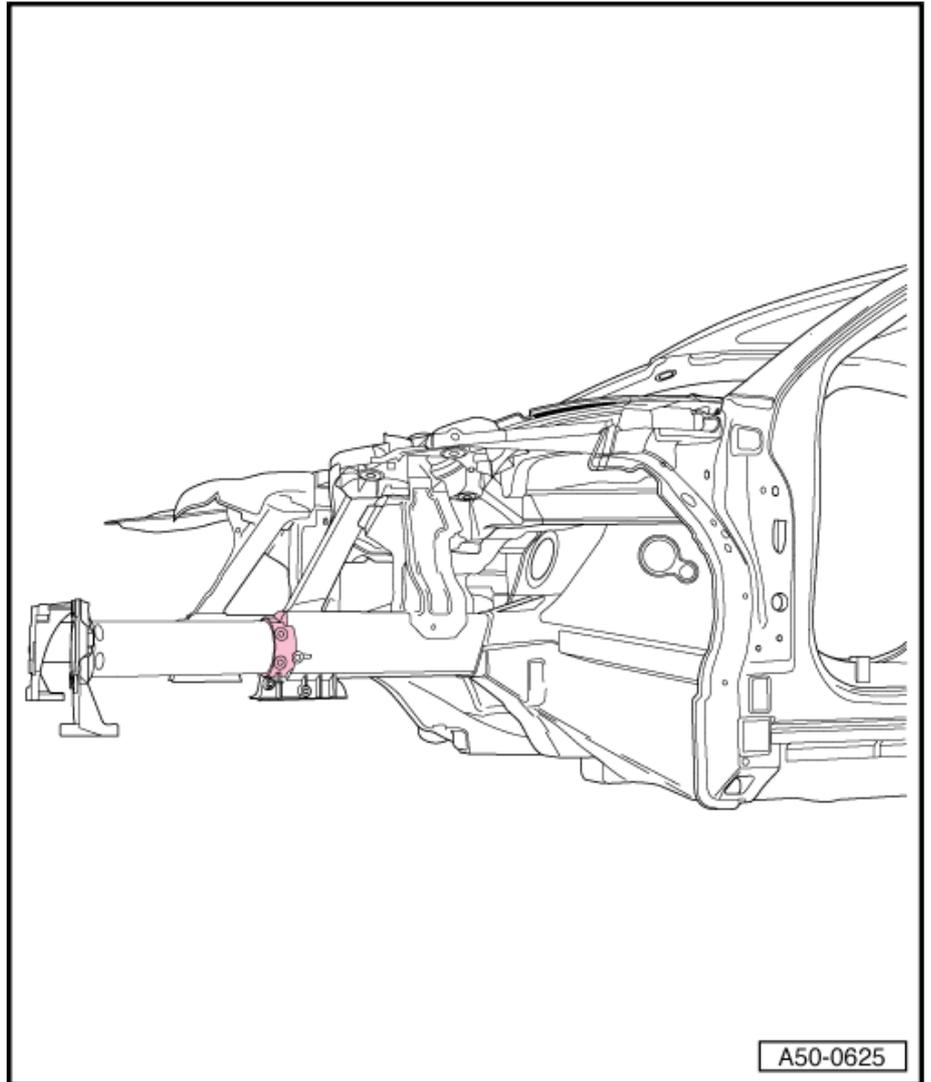
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Cutting locations



Note

Detach bolted joint securing longitudinal member.



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Replacement parts

- ◆ Front longitudinal member
- ◆ Connecting collar with bolts

Preparing new parts

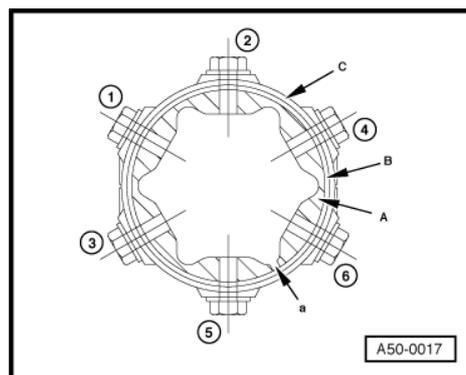
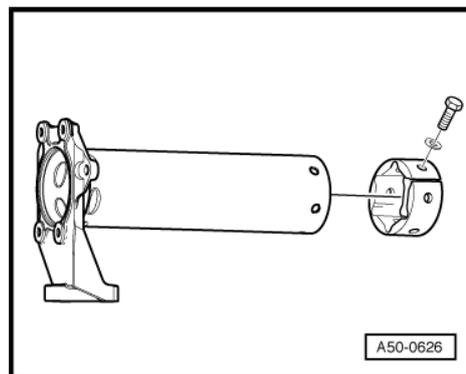
Note

Align longitudinal member with bolted-on parts.

Note

Threads must be free of paint and grease.

- Match length if necessary. Distance from node casting at least 1 mm.
- Insert threaded collar in longitudinal member.
- Insert longitudinal member with threaded collar in node casting.
- Hand-tighten bolts.
- Tighten bolts 1 - 6. (Tightening torque 24 Nm).



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51 – Body - centre

RO: 51 03 55 00

1 Roof - Renewal



WARNING

Always observe safety precautions.

Safety notes ⇒ General Information; Body Repairs, General Body Repairs ; Safety notes .

1.1 Tools

Special tools and workshop equipment required

- ◆ Compact angle grinder -VAS 5167-
- ◆ Double cartridge gun -VAS 6453-
- ◆ Shielded arc welding equipment 250A

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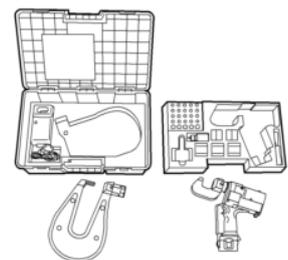
VAS 6388



W00-10622

- ◆ Rechargeable riveter -VAS 5279A-

VAS 5279 A



W00-10641

1.2 Procedure

Cutting locations

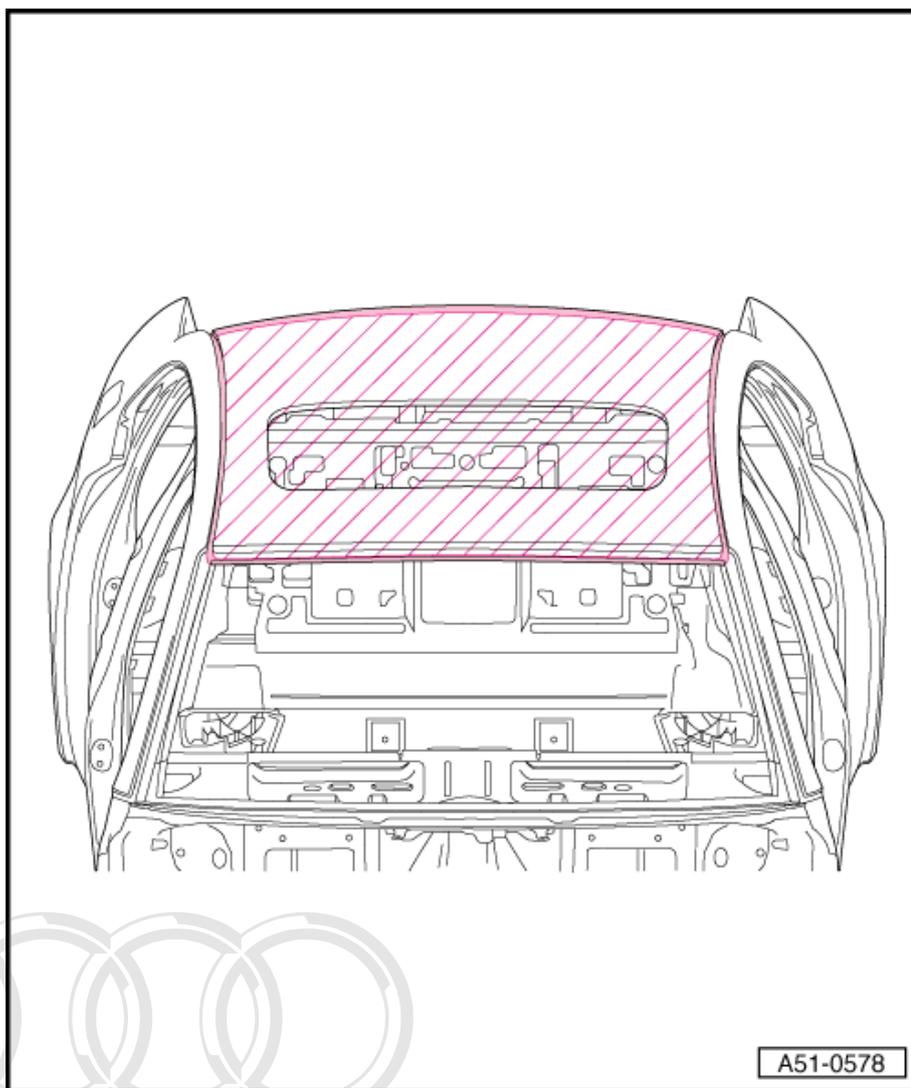


Note

Refer to section on laser welding in General information on aluminium.

- Separate original joint using compact angle grinder -VAS 5167- .

- Remove small punch rivets. Use rechargeable riveter -VAS 5279A- with attachments S1 and D2 from -VAS 5279/2 - or rechargeable riveter -VAS 5279B- with attachments S1 and D2 .
- Remove remaining material using compact angle grinder - VAS 5167- .



Replacement parts

- ◆ Roof
- ◆ Solid rivets
- ◆ 2-component epoxy adhesive -DA 180 A00 A2-
- ◆ Silicone remover -LSE 020 100 A3-
- ◆ Applicator -D 009 500 25 -
- ◆ Aluminium primer -DA 009 801 -
- ◆ Silicate stone -DA 009 800 -

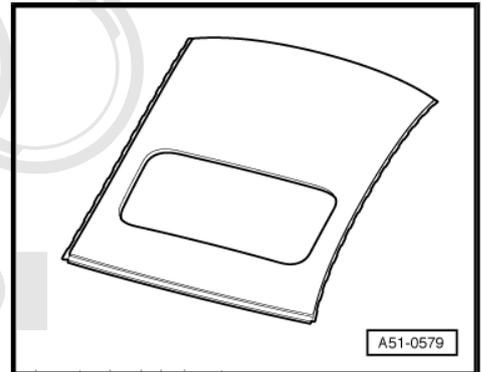
Preparing joints for adhesive application

- Clean bonding area with silicone remover - LSE 020 100 A3- .

- Prepare bonding area with silicate stone -DA 009 800 - and clean.
- Apply aluminium primer -DA 009 801 - to bonding surfaces using applicator -D 009 500 25 - .
- Apply 2-component epoxy adhesive -DA 180 A00 A2- (two cartridge sets) to entire riveting area using double cartridge gun -VAS 6453- .

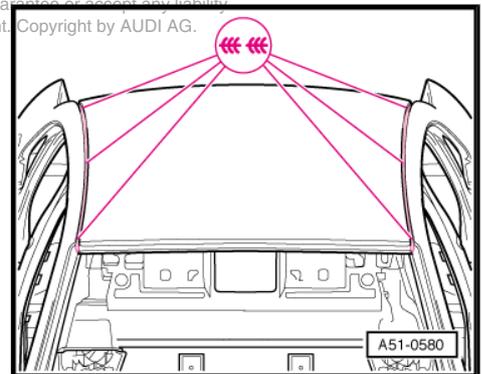
Welding in

Match up roof and fix in place.



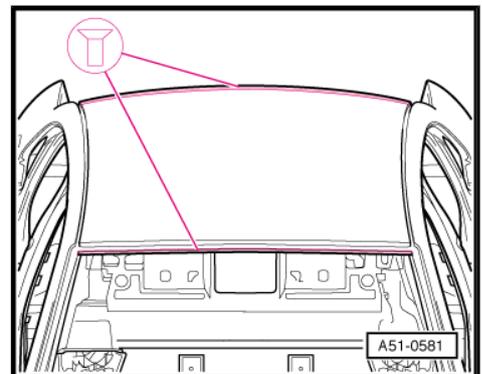
- Weld in roof using shielded arc welding equipment 250A : SG continuous seam (staggered - with gaps).

Riveting in



 **Note**

- ◆ Use clamps.
- ◆ Rivet in roof using rechargeable riveter -VAS 5279 B- .



RO: 51 35 55 00

2 Roof side member - Renewal



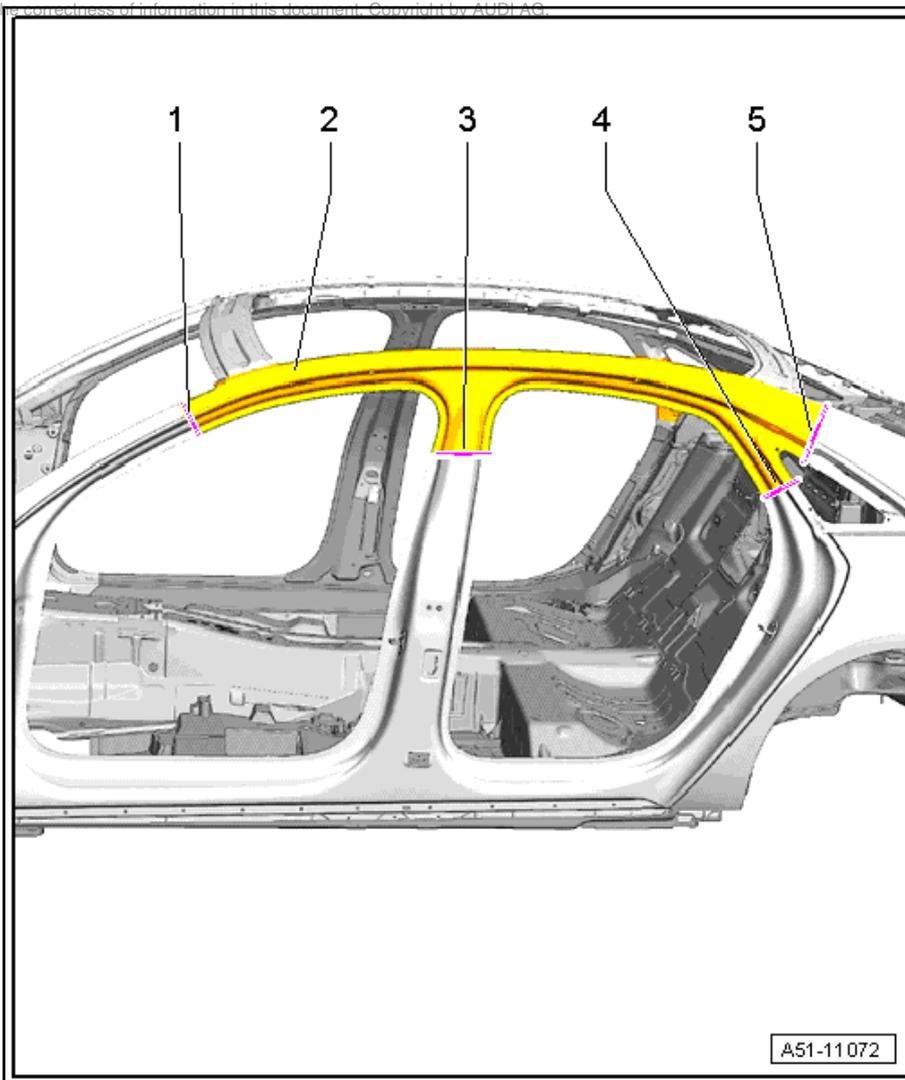
WARNING

Always observe safety precautions.

Safety notes ⇒ General Information; Body Repairs, General Body Repairs ; Safety notes .

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- 1 - Separating cut in A-pillar
- 2 - Roof side member
- 3 - Separating cut in B-pillar
- 4 - Separating cut in C-pillar
- 5 - D-pillar separating cut

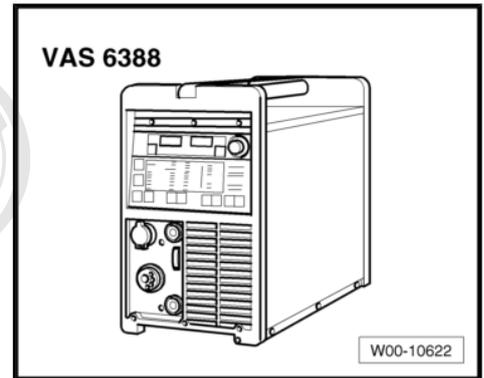


2.1 Tools

Special tools and workshop equipment required

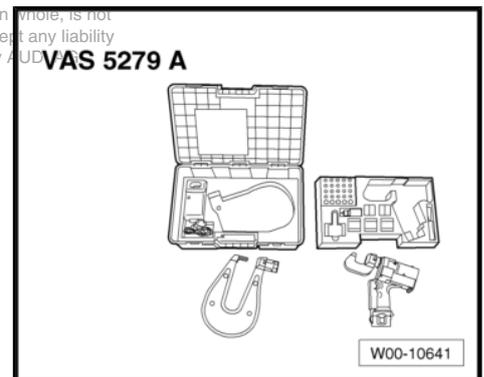
- ◆ Compact angle grinder -VAS 5167-
- ◆ Drill -VAS 5830-

- ◆ Shielded arc welding equipment 250A

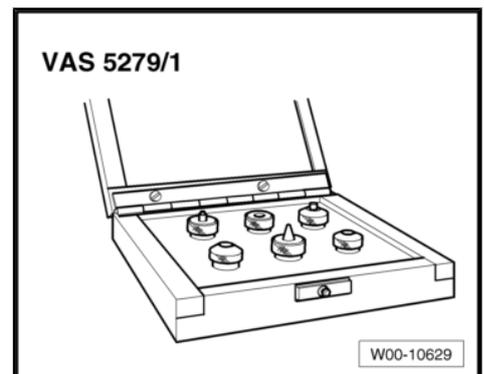


- ◆ Rechargeable riveter -VAS 5279A-

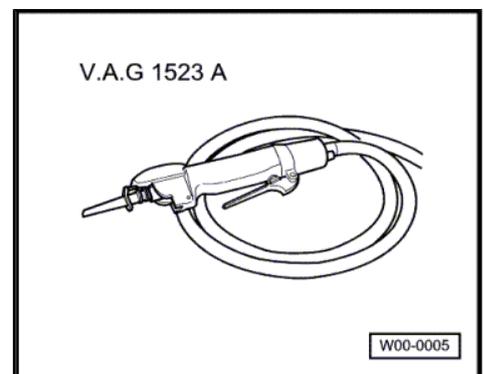
- ◆ Alternatively, you can use the new rechargeable riveter -VAS 5279 B-. This is a complete set.



- ◆ Accessory set for rechargeable riveter -VAS 5279/1-



- ◆ Pneumatic sabre saw -V.A.G 1523A-

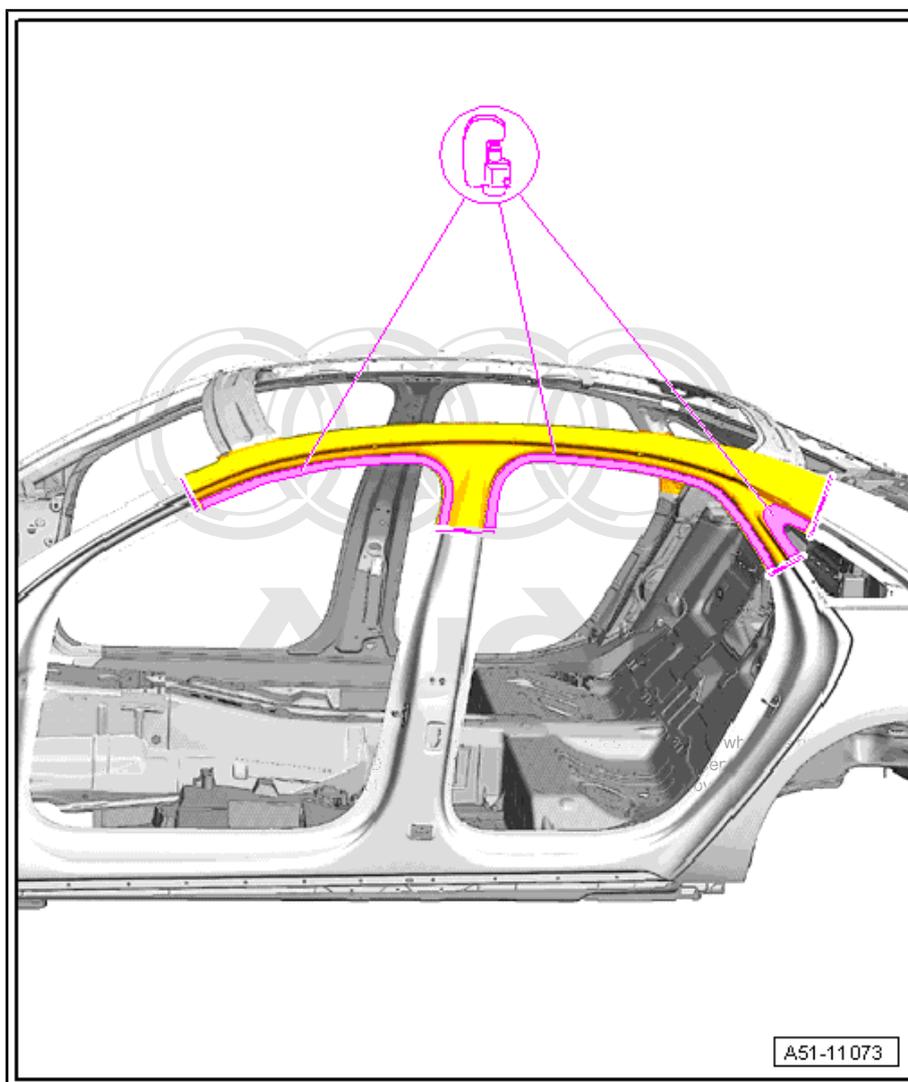


2.2 Procedure

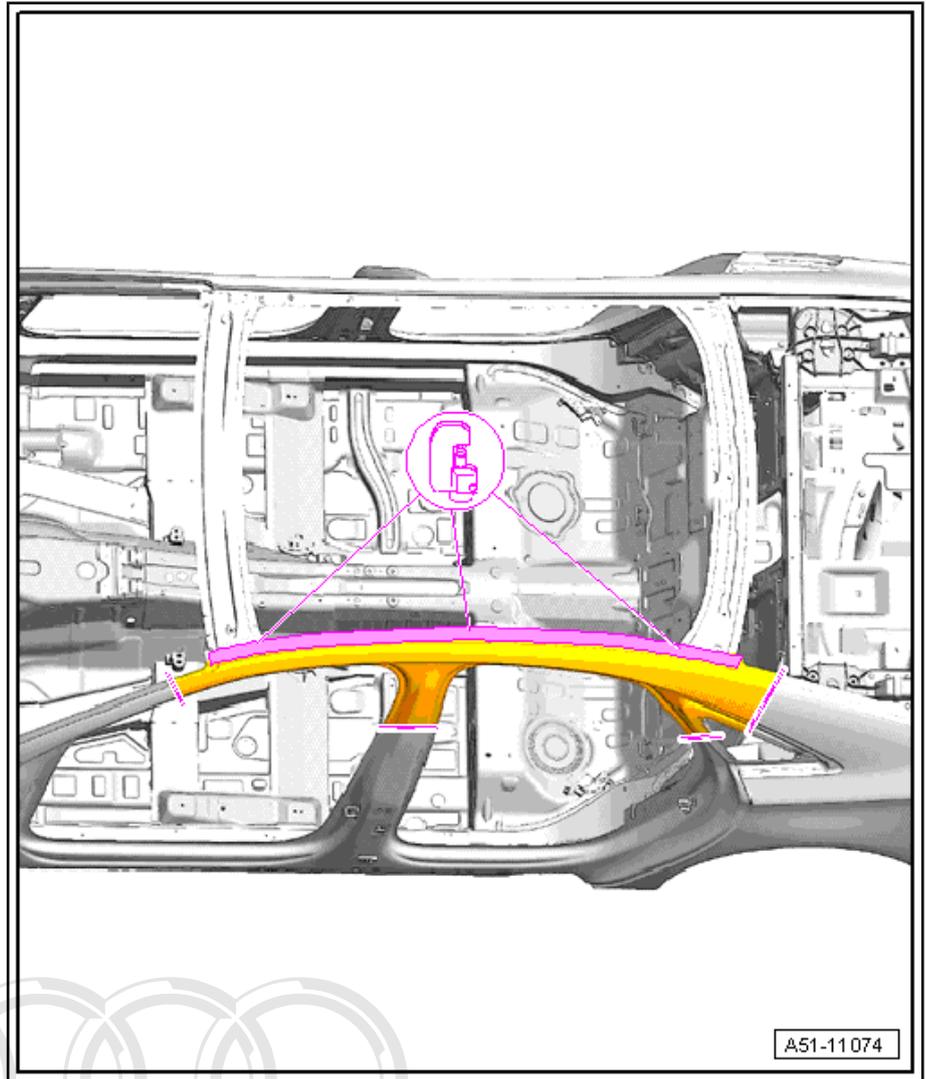
Roof already removed

Cutting locations

- Separate original joint with rechargeable riveter -VAS 5279A- .
- Remove large punch rivets. Use rechargeable riveter -VAS 5279A- with attachments S4 and D5 from -VAS 5279/2 - or rechargeable riveter -VAS 5279B- with attachments S4 and D5 .
- Remove small punch rivets. Use rechargeable riveter -VAS 5279A- with attachments S1 and D2 from -VAS 5279/2 - or rechargeable riveter -VAS 5279B- with attachments S1 and D2 .
- Make separating cuts using pneumatic sabre saw -V.A.G 1523A- .



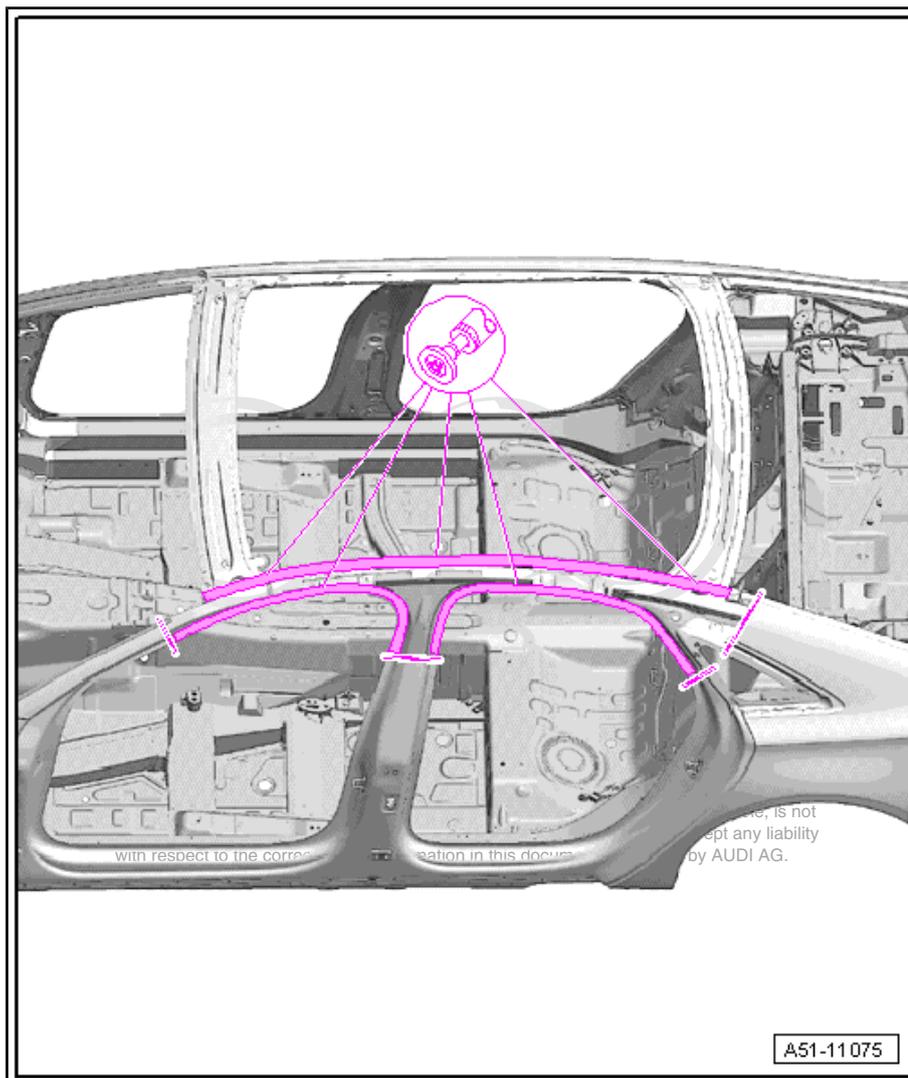
- Separate original joint with rechargeable riveter -VAS 5279A- .
- Remove large punch rivets. Use rechargeable riveter -VAS 5279A- with attachments S4 and D5 from -VAS 5279/2 - or rechargeable riveter -VAS 5279B- with attachments S4 and D5 .
- Remove small punch rivets. Use rechargeable riveter -VAS 5279A- with attachments S1 and D2 from -VAS 5279/2 - or rechargeable riveter -VAS 5279B- with attachments S1 and D2 .



- Remove remaining material using compact angle grinder - VAS 5167- .

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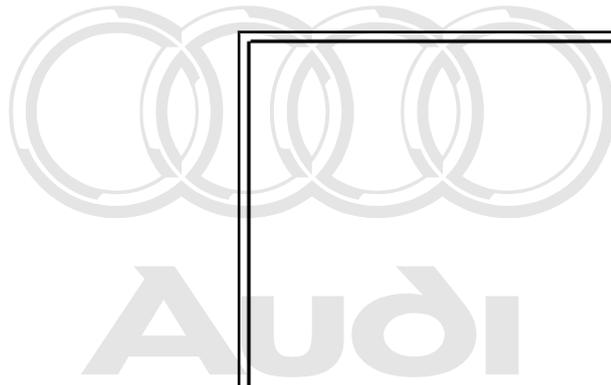


Replacement parts

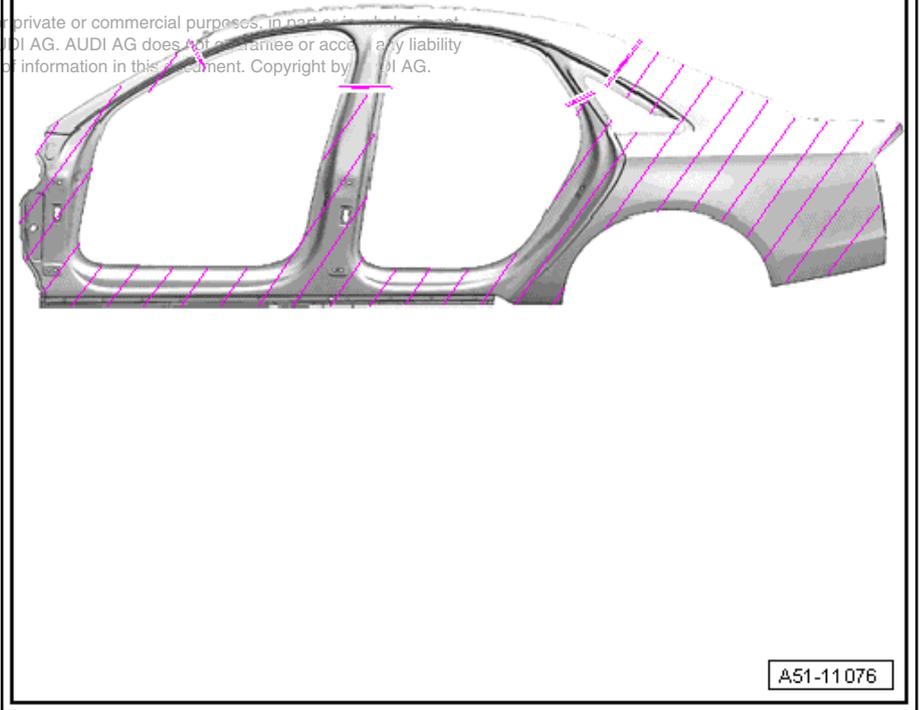
- ◆ Side panel -4E0 809 601/4E0 809 602-
- ◆ Punch rivets (self-piercing rivets)
- ◆ 2-component epoxy adhesive -DA 001 730 A2-
- ◆ Aluminium primer -DA 009 801-
- ◆ Cleaning solution -D 009 401 04-
- ◆ Silicate stone -DA 009 800 -

Preparing new part

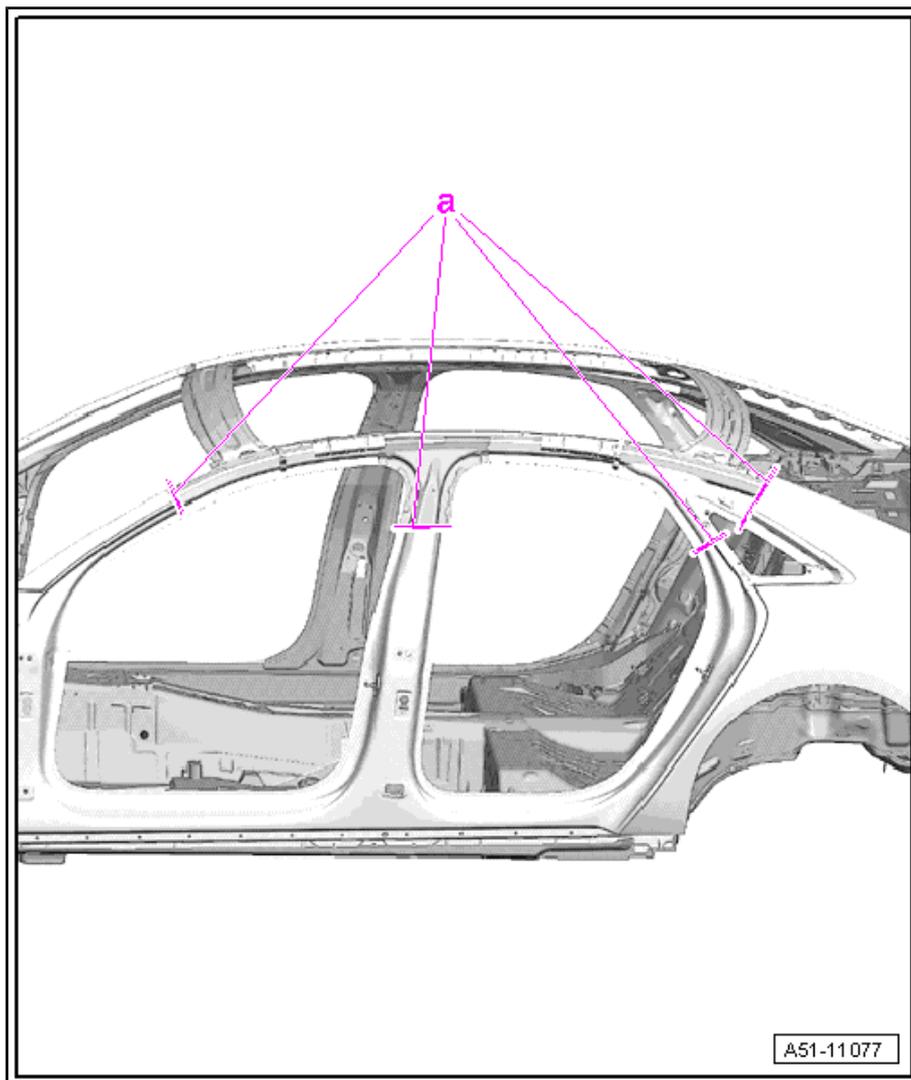
- Transfer separating cuts to new part and cut to size using pneumatic sabre saw -V.A.G 1523A- .



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- Place backing plate of same material behind separating cuts -a-.



Preparing joints for adhesive application

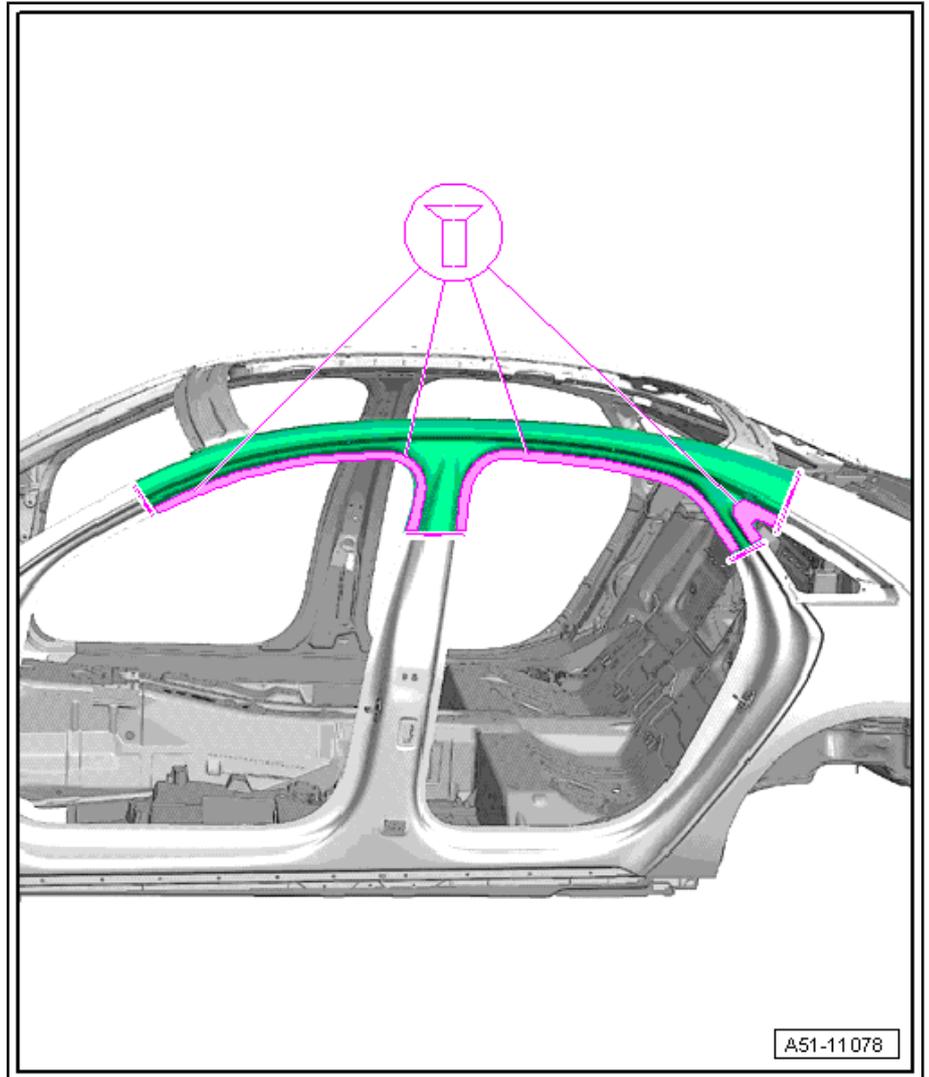
- Take off roof side member and prepare flanges on body and roof side member for bonding.
- Clean bonding area with silicone remover - LSE 020 100 A3- .
- Prepare bonding area with silicate stone -DA 009 800 - and clean.
- Apply aluminium primer -DA 009 801 - to bonding surfaces using applicator -D 009 500 25 - .
- Operate double cartridge gun -VAS 6453- with 2-component epoxy adhesive -DA 180 A00 A2- and apply an approx. 100 mm long adhesive bead to a piece of cardboard before starting application on the B-pillar.

Riveting in

- Rivet in roof side member using rechargeable riveter -VAS 5279A- .

Use rechargeable riveter -VAS 5279A- with attachments S2 and S3 from -VAS 5279/2 - or rechargeable riveter -VAS 5279B- with attachments S2 and S3 .

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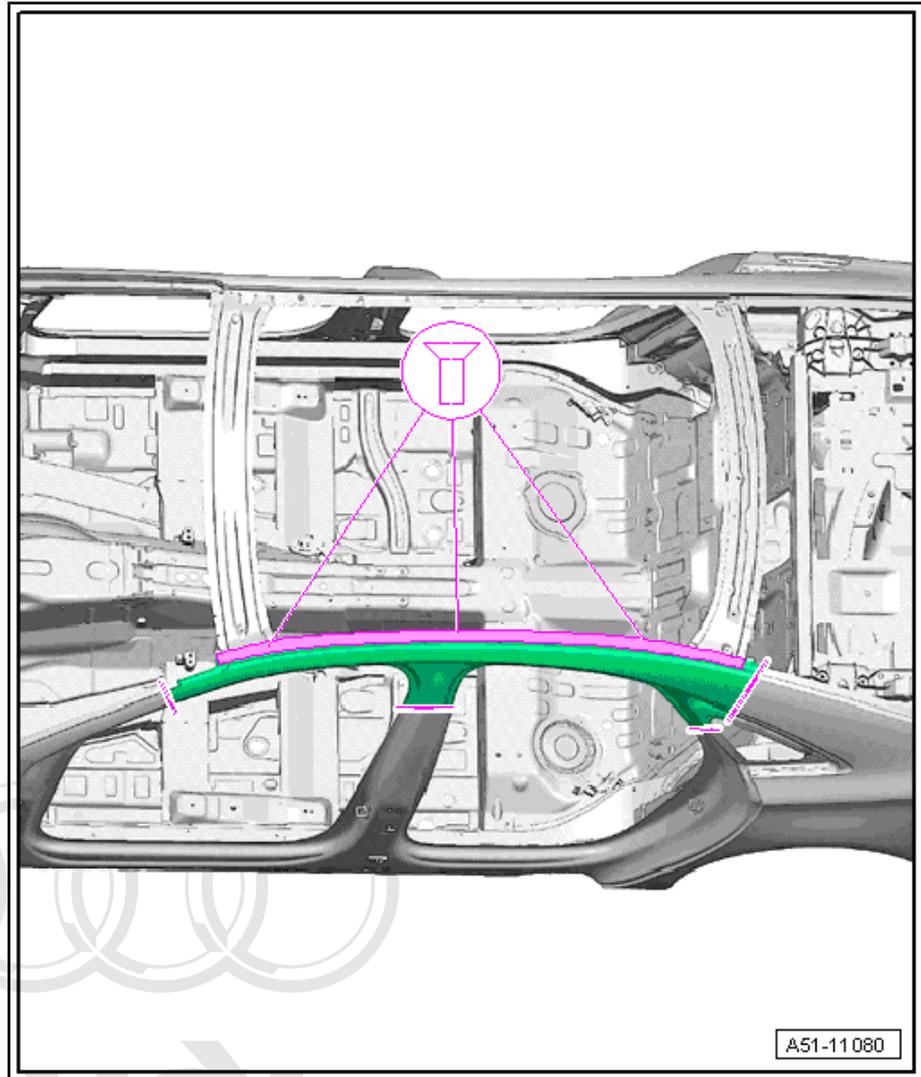


- Rivet in roof side member using rechargeable riveter -VAS 5279A- .

Use rechargeable riveter -VAS 5279A- with attachments S2 and S3 from -VAS 5279/2 - or rechargeable riveter -VAS 5279B- with attachments S2 and S3 .

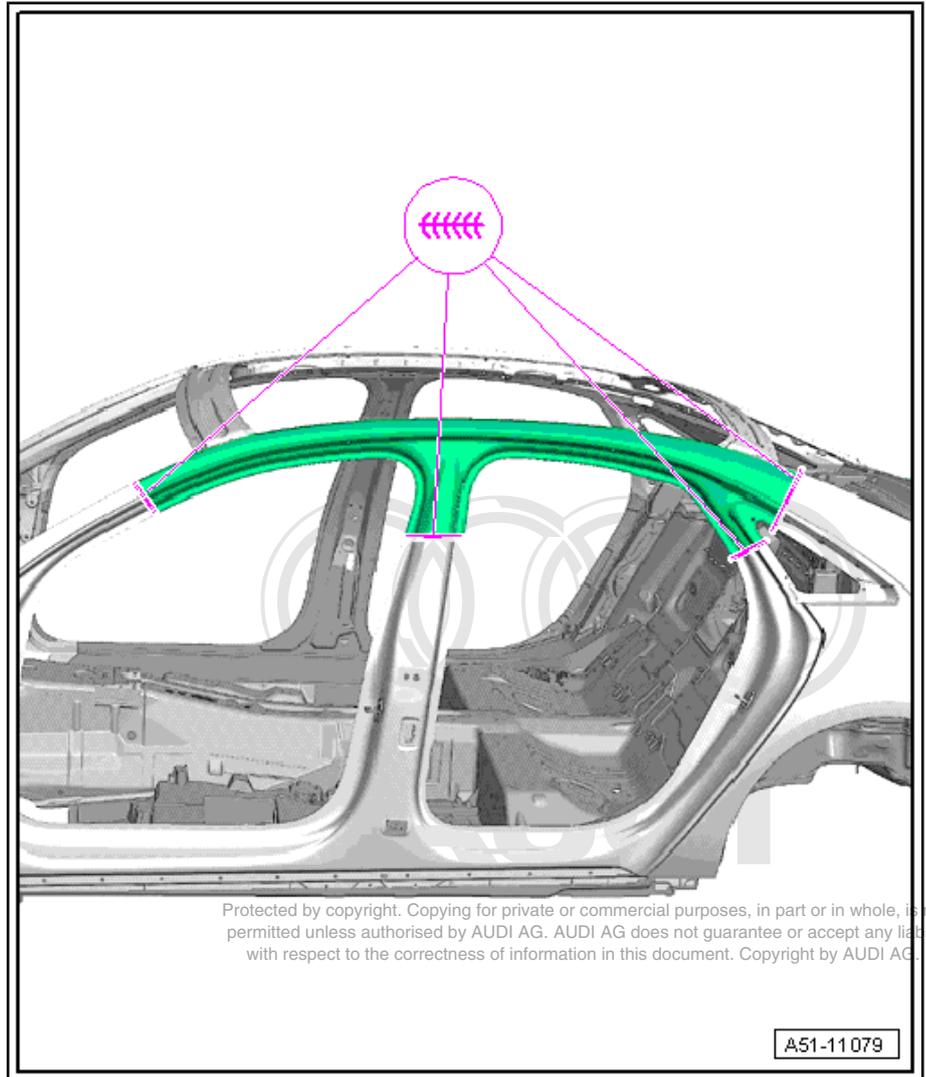


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Welding in

- Weld in at separating cuts using shielded arc welding equipment : SG continuous seam.



RO: 51 35 55 00

3 Roof side member - Renewal (long version)



WARNING

Always observe safety precautions.

Safety notes ⇒ General Information; Body Repairs, General Body Repairs ; Safety notes .

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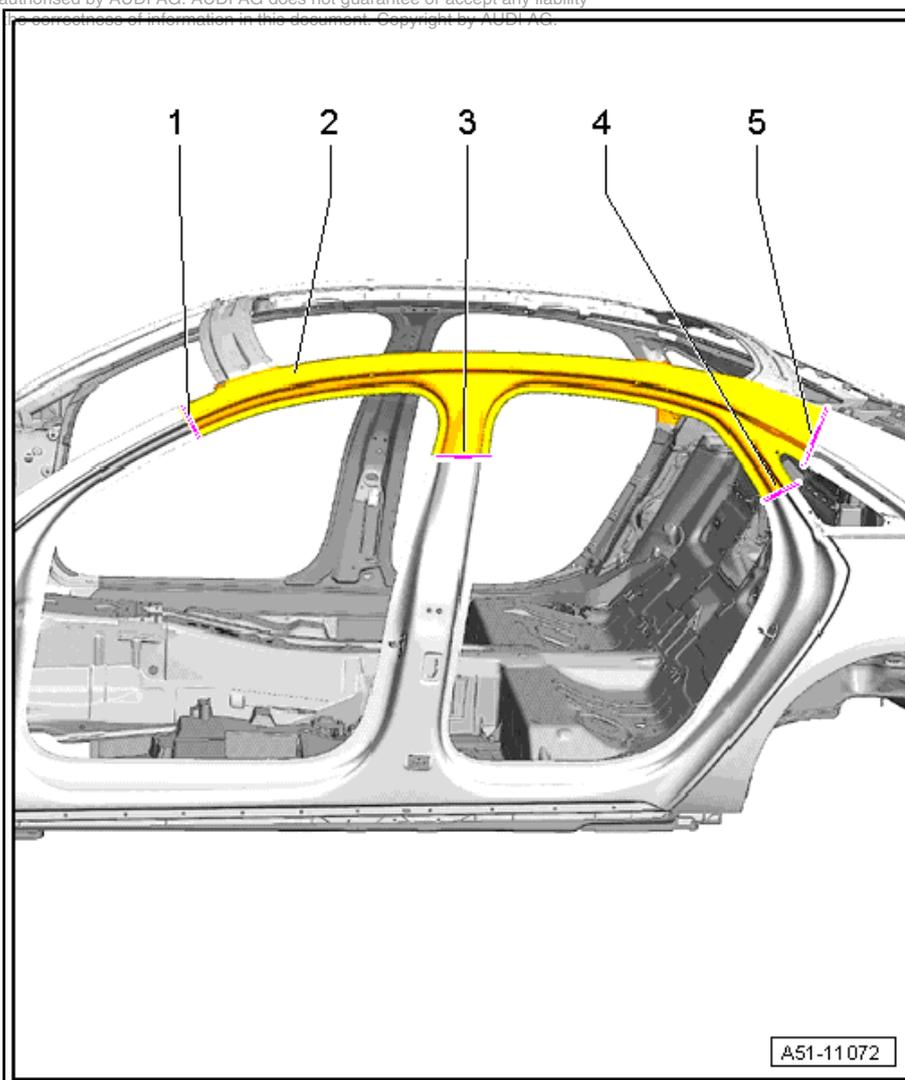
1 - Separating cut in A-pillar

2 - Roof side member

3 - Separating cut in B-pillar

4 - Separating cut in C-pillar

5 - D-pillar separating cut

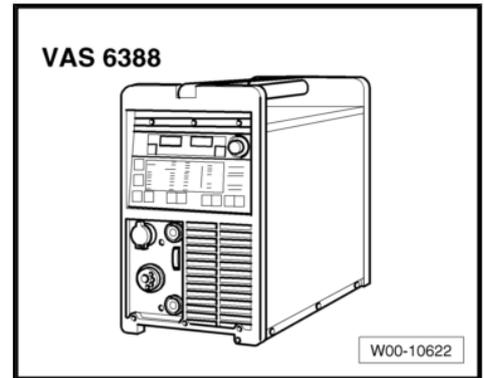


3.1 Tools

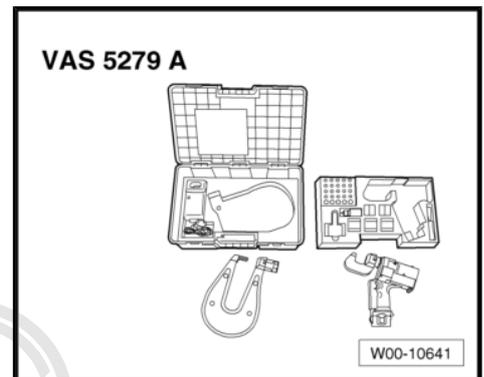
Special tools and workshop equipment required

- ◆ Compact angle grinder -VAS 5167-
- ◆ Drill -VAS 5830-

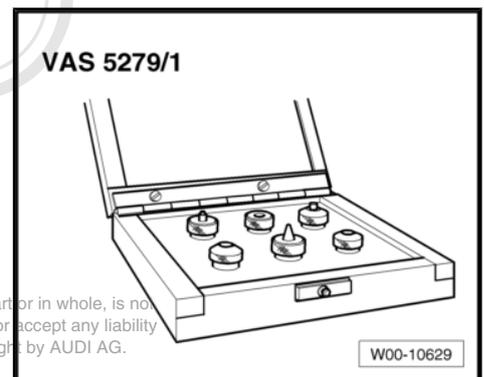
- ◆ Shielded arc welding equipment 250A



- ◆ Rechargeable riveter -VAS 5279A-
- ◆ Alternatively, you can use the new rechargeable riveter -VAS 5279 B-. This is a complete set.

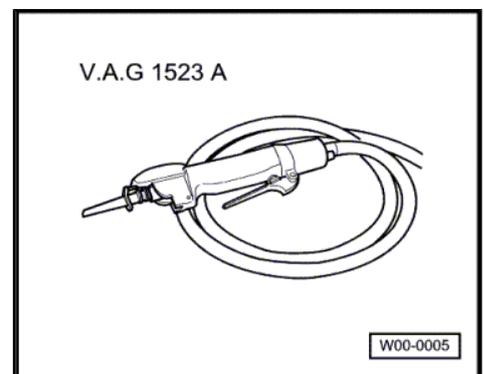


- ◆ Accessory set for rechargeable riveter -VAS 5279/1-



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- ◆ Pneumatic sabre saw -V.A.G 1523A-

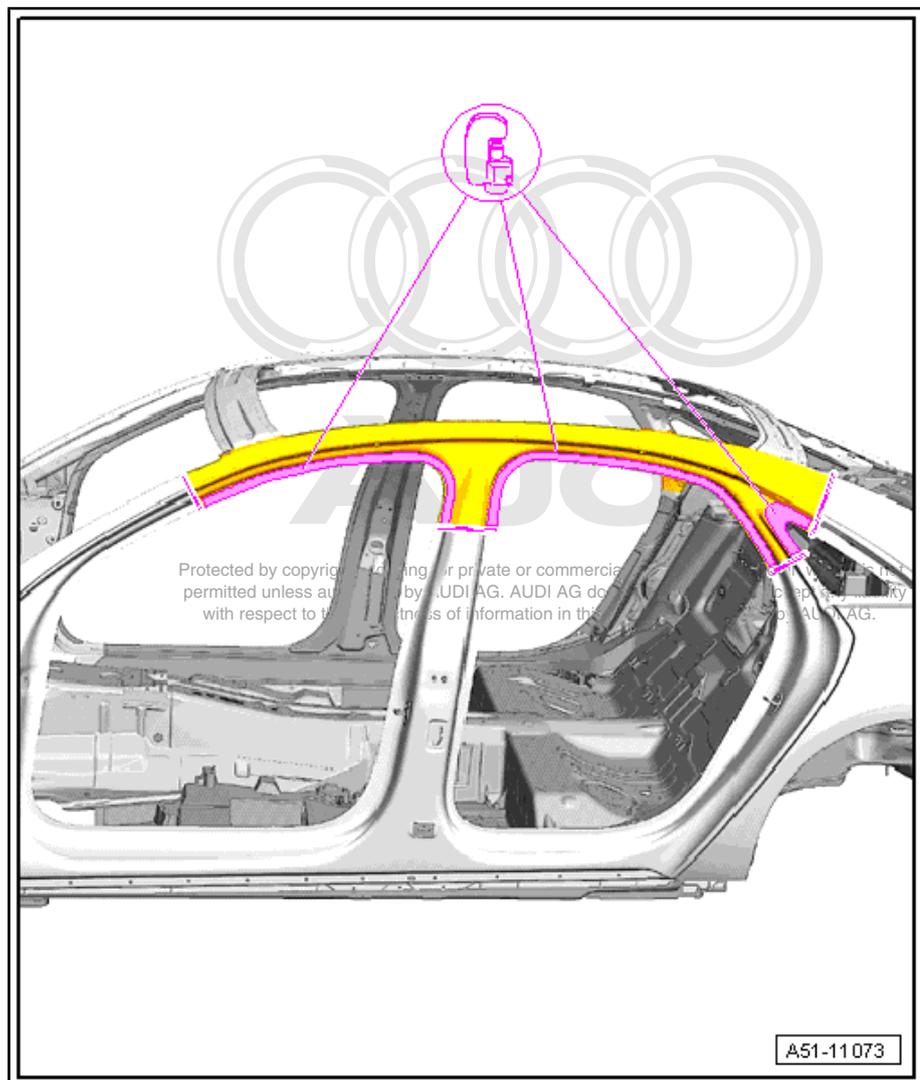


3.2 Procedure

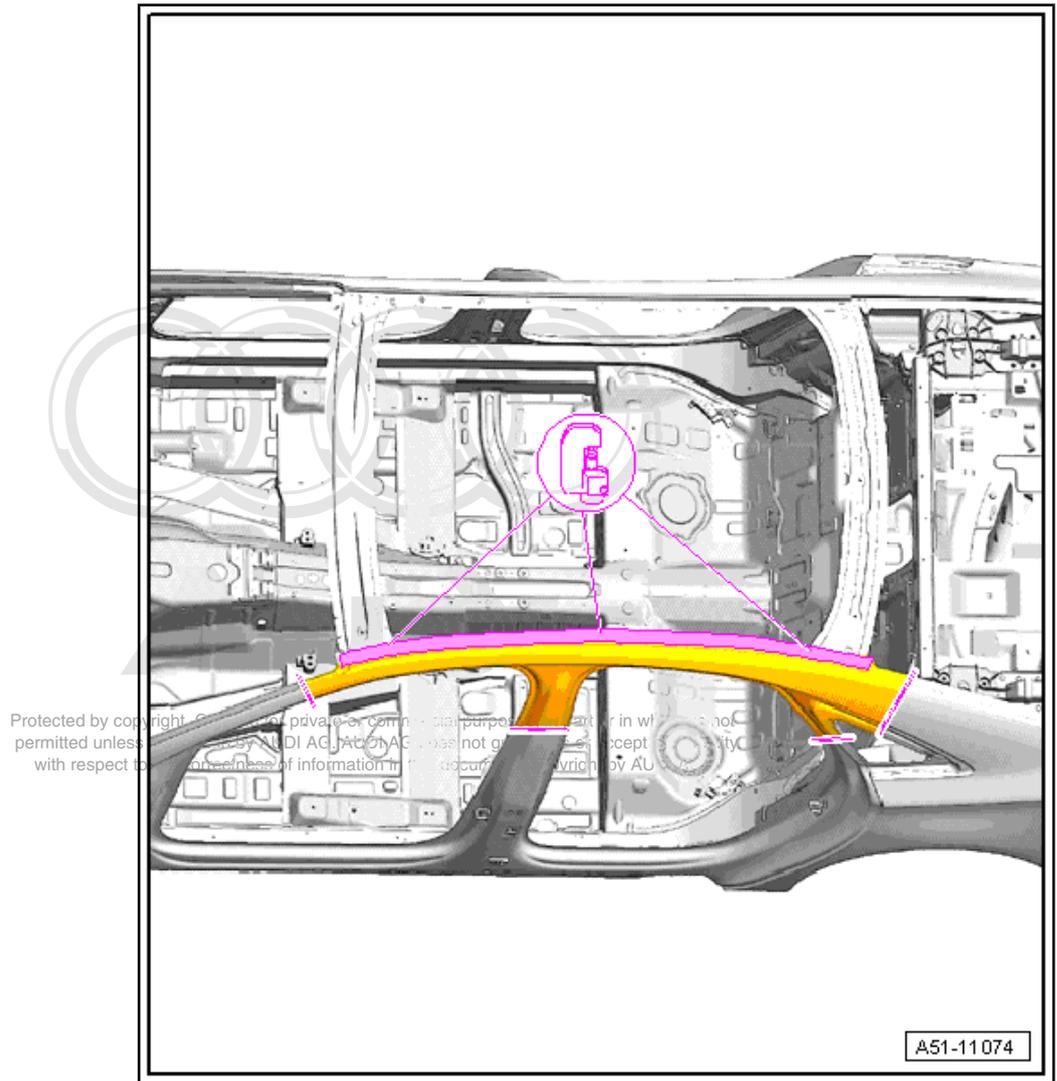
Roof already removed

Cutting locations

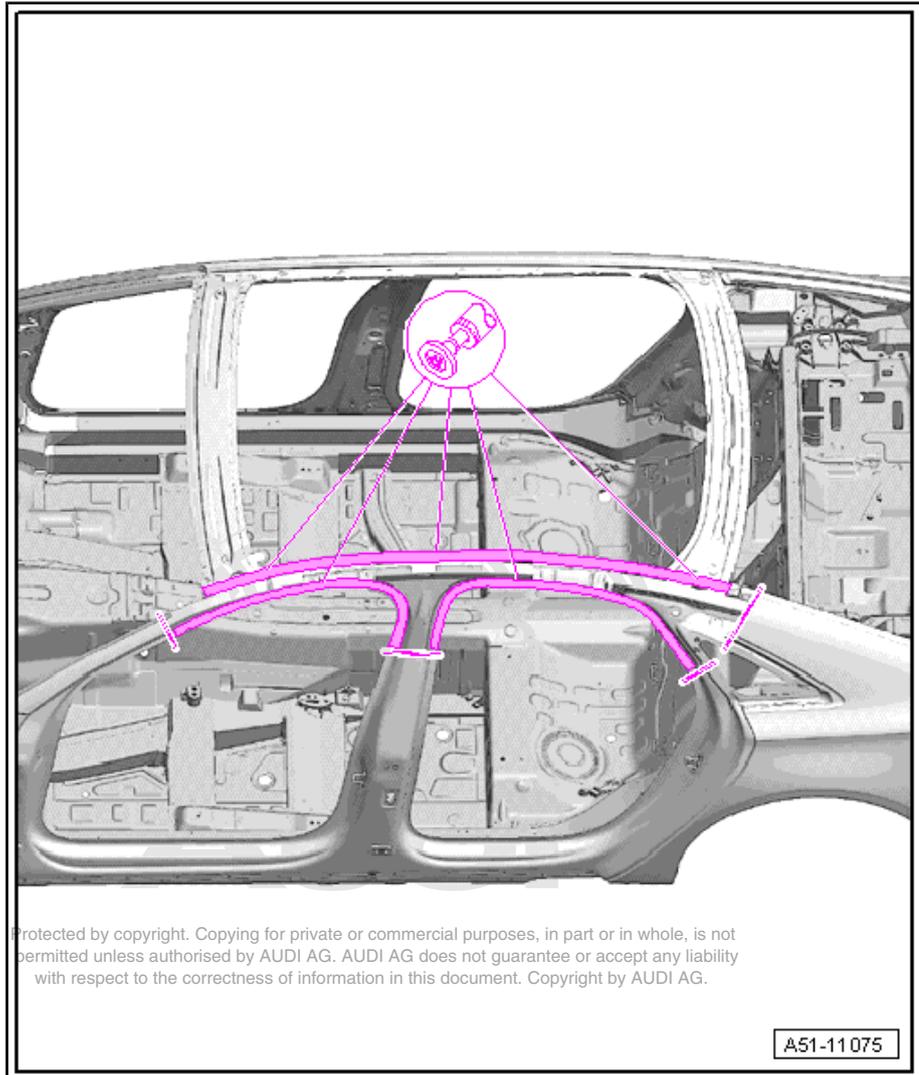
- Separate original joint with rechargeable riveter -VAS 5279A- .
- Remove large punch rivets. Use rechargeable riveter -VAS 5279A- with attachments S4 and D5 from -VAS 5279/2 - or rechargeable riveter -VAS 5279B- with attachments S4 and D5 .
- Remove small punch rivets. Use rechargeable riveter -VAS 5279A- with attachments S1 and D2 from -VAS 5279/2 - or rechargeable riveter -VAS 5279B- with attachments S1 and D2 .
- Make separating cuts using pneumatic sabre saw -V.A.G 1523A- .



- Separate original joint with rechargeable riveter -VAS 5279A- .
- Remove large punch rivets. Use rechargeable riveter -VAS 5279A- with attachments S4 and D5 from -VAS 5279/2 - or rechargeable riveter -VAS 5279B- with attachments S4 and D5 .
- Remove small punch rivets. Use rechargeable riveter -VAS 5279A- with attachments S1 and D2 from -VAS 5279/2 - or rechargeable riveter -VAS 5279B- with attachments S1 and D2 .



- Remove remaining material using compact angle grinder - VAS 5167- .

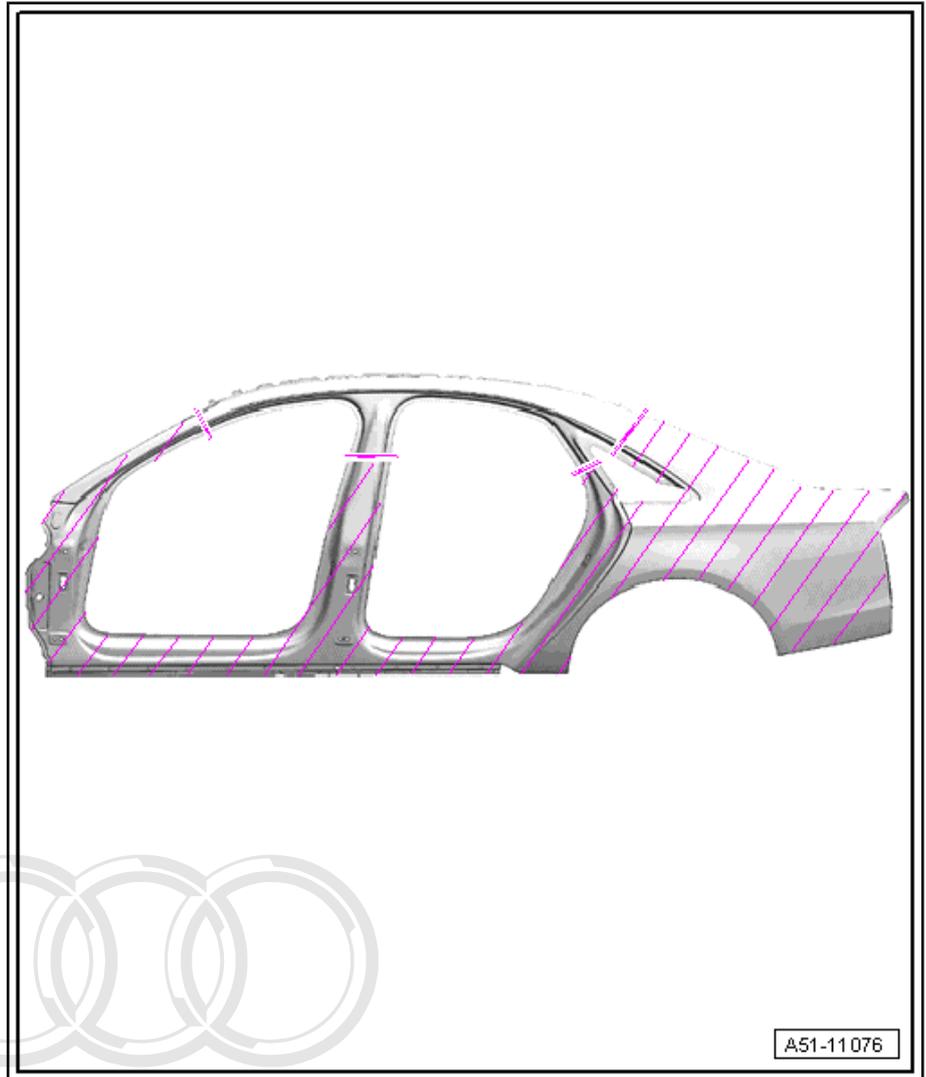


Replacement parts

- ◆ Side panel -4E4 809 601 / 4E4 809 602-
- ◆ Punch rivets (self-piercing rivets)
- ◆ 2-component epoxy adhesive -DA 001 730 A2-
- ◆ Aluminium primer -DA 009 801-
- ◆ Cleaning solution -D 009 401 04-
- ◆ Silicate stone -DA 009 800 -

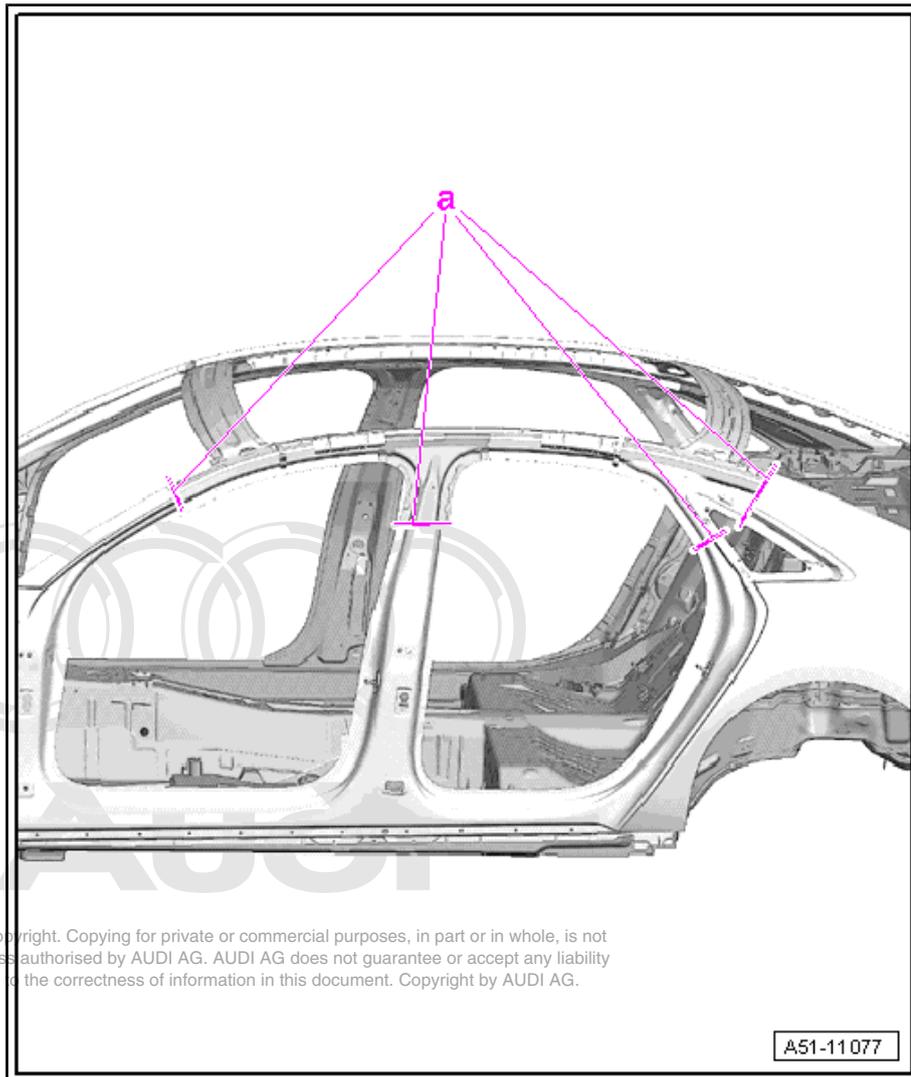
Preparing new part

- Transfer separating cuts to new part and cut to size using pneumatic sabre saw -V.A.G 1523A- .



- Place backing plate of same material behind separating cuts -a-.

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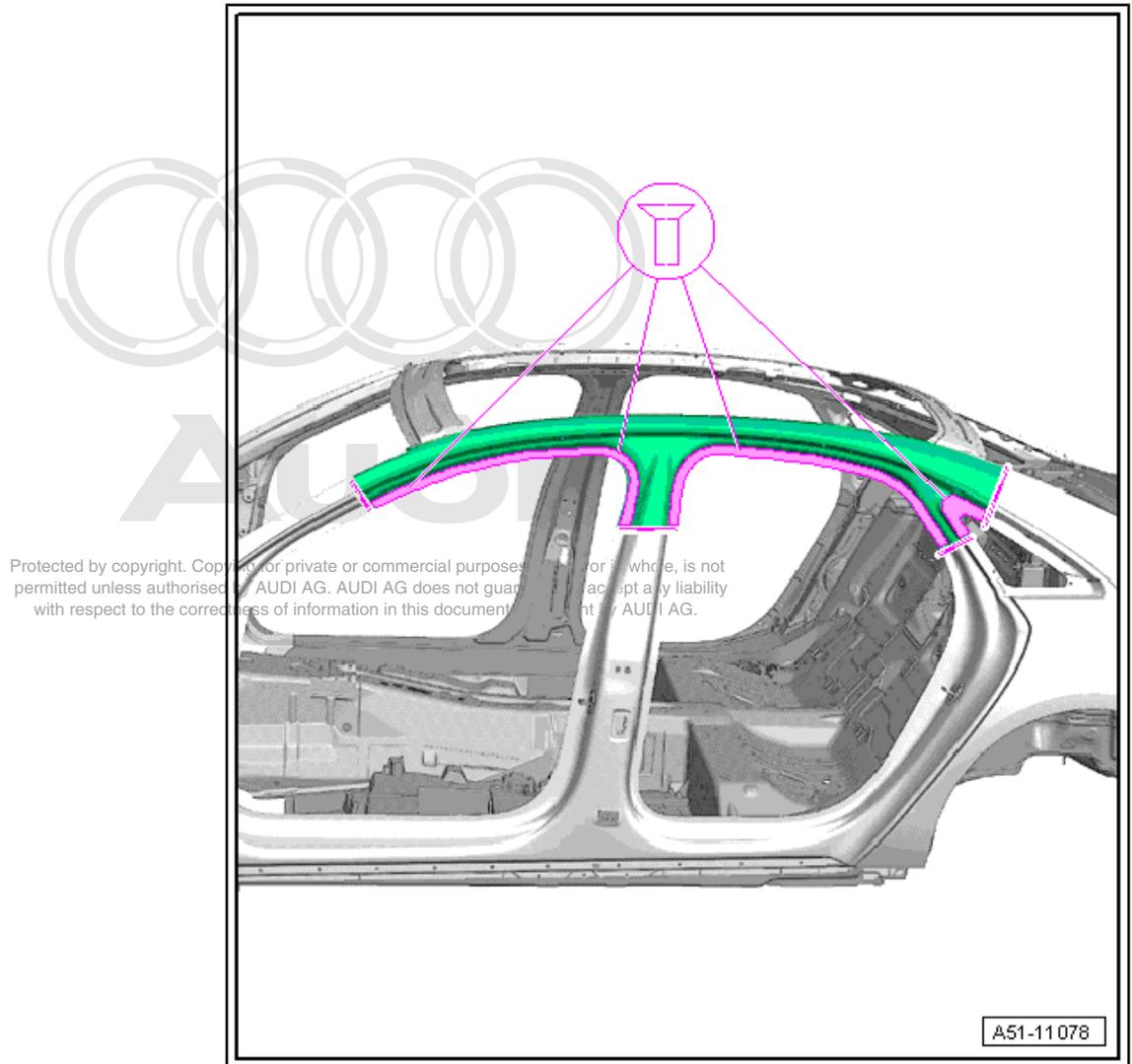
Preparing joints for adhesive application

- Take off roof side member and prepare flanges on body and roof side member for bonding.
- Clean bonding area with silicone remover - LSE 020 100 A3- .
- Prepare bonding area with silicate stone -DA 009 800 - and clean.
- Apply aluminium primer -DA 009 801 - to bonding surfaces using applicator -D 009 500 25 - .
- Operate double cartridge gun -VAS 6453- with 2-component epoxy adhesive -DA 180 A00 A2- and apply an approx. 100 mm long adhesive bead to a piece of cardboard before starting application on the B-pillar.

Riveting in

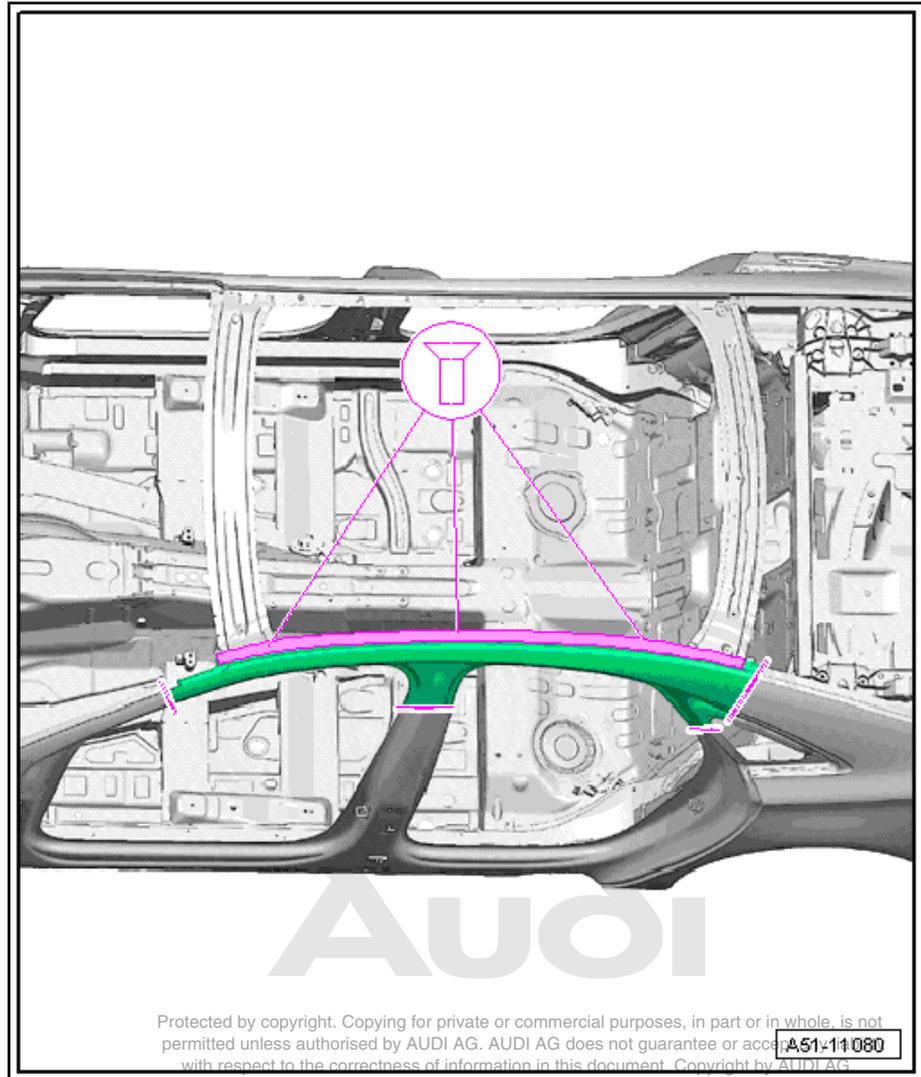
- Rivet in roof side member using rechargeable riveter -VAS 5279A- .

Use rechargeable riveter -VAS 5279A- with attachments S2 and S3 from -VAS 5279/2 - or rechargeable riveter -VAS 5279B- with attachments S2 and S3 .



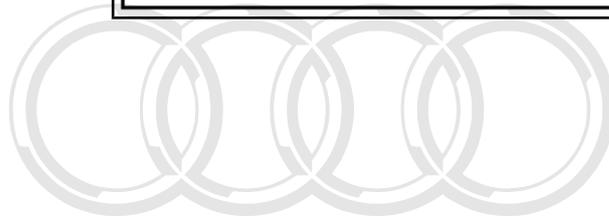
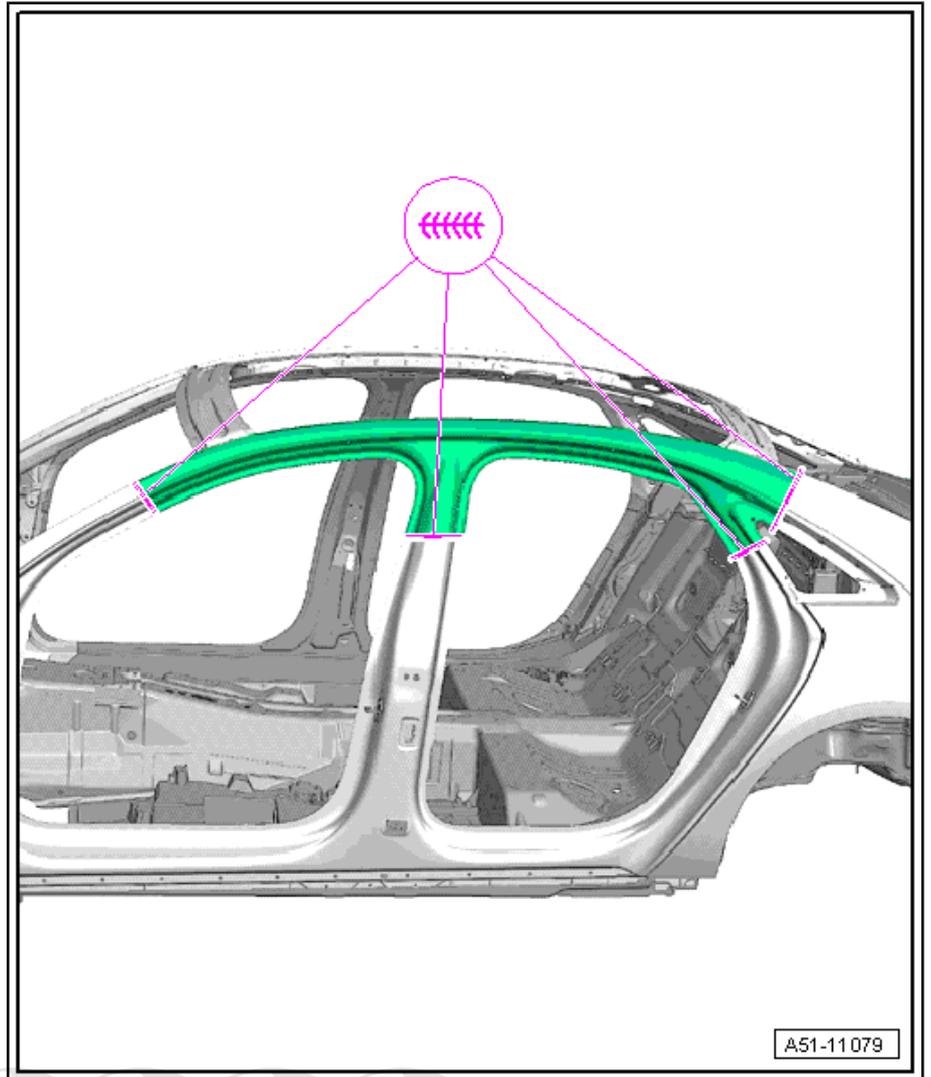
- Rivet in roof side member using rechargeable riveter -VAS 5279A- .

Use rechargeable riveter -VAS 5279A- with attachments S2 and S3 from -VAS 5279/2 - or rechargeable riveter -VAS 5279B- with attachments S2 and S3 .



Welding in

- Weld in at separating cuts using shielded arc welding equipment : SG continuous seam.



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RO: 51 37 55 00

4 A-pillar - Renewal



WARNING

Always observe safety precautions.

Safety notes ⇒ General Information; Body Repairs, General Body Repairs ; Safety notes .

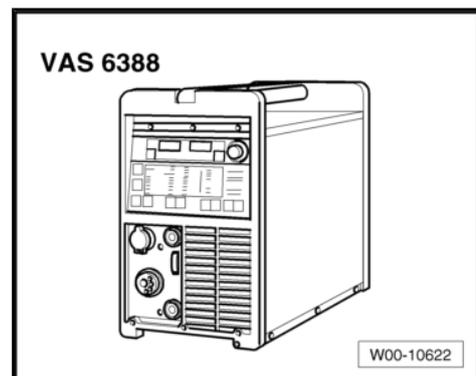
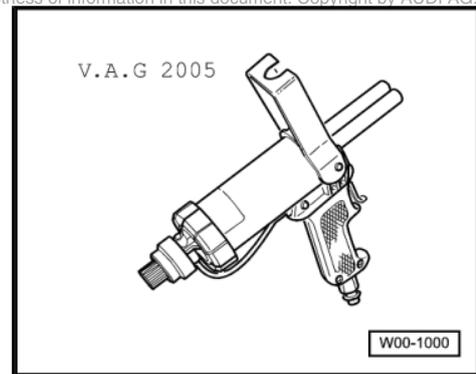
4.1 Tools

Special tools and workshop equipment required

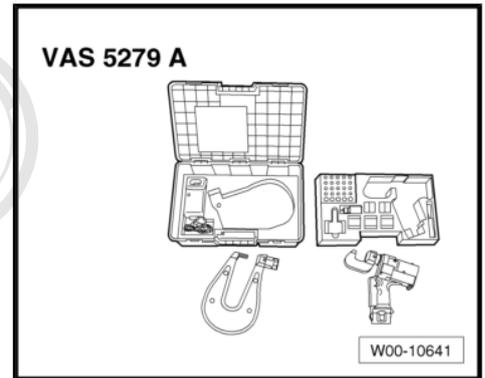
- ◆ Compact angle grinder -VAS 5167-
- ◆ Pop rivet pliers -VAS 5072-
- ◆ Compact angle grinder -VAS 5167-
- ◆ Drill -VAS 5830-
- ◆ Pneumatic glue gun -V.A.G 2005 B-

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- ◆ Shielded arc welding equipment 250A

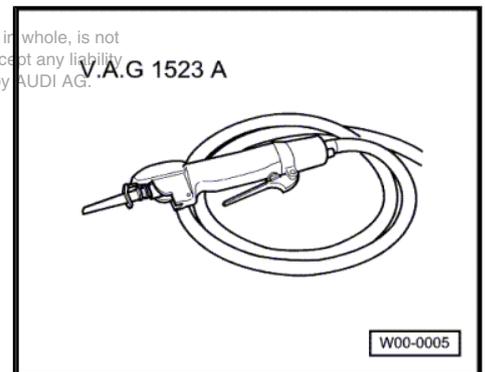


◆ Rechargeable riveter -VAS 5279A-



◆ Pneumatic sabre saw -V.A.G 1523A-

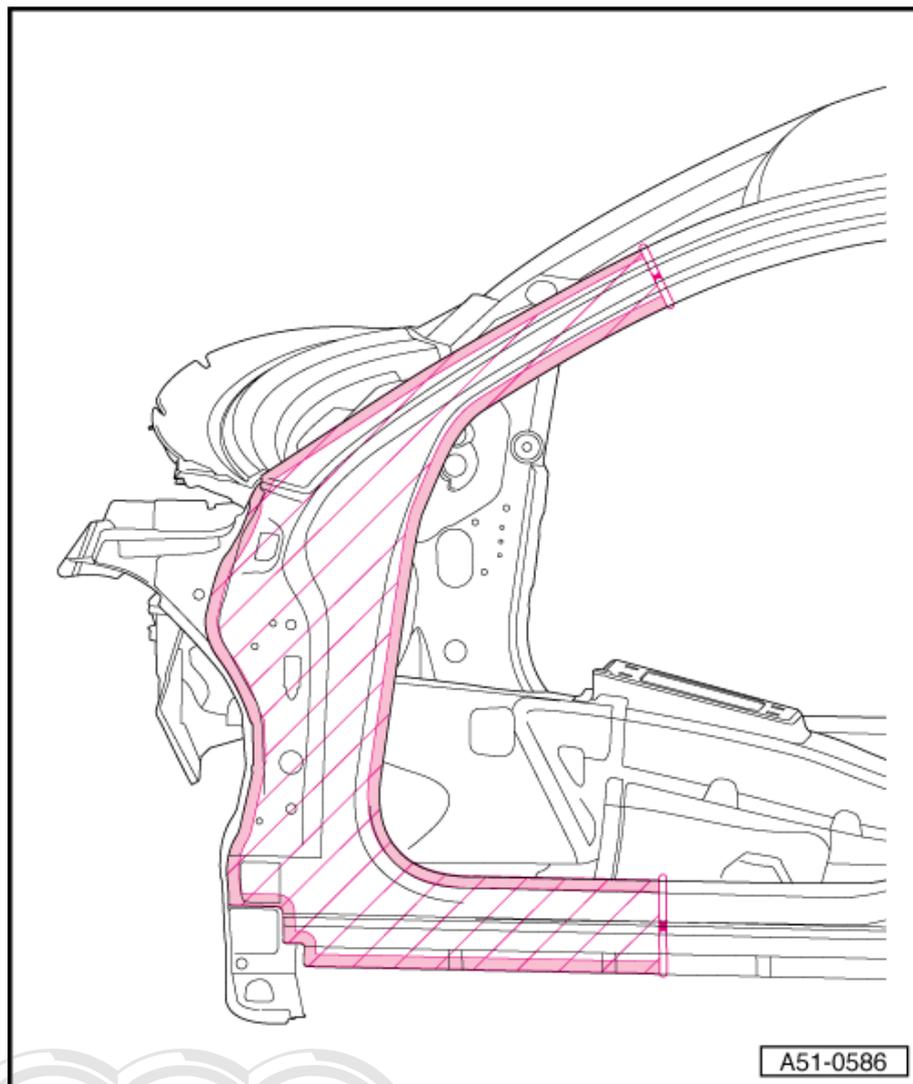
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4.2 Procedure

Cutting locations

- Make separating cut as shown using pneumatic sabre saw - V.A.G 1523A- . Do not damage internal reinforcements.
- Make separating cuts at side member as shown using pneumatic sabre saw -V.A.G 1523A- ; take care not to damage inner side member.
- Unfasten riveted joints at A-pillar.
- Remove large punch rivets. Use rechargeable riveter -VAS 5279A- with attachments S2 and S3 from -VAS 5279/2 - or rechargeable riveter -VAS 5279B- with attachments S4 and D5 .
- Remove small punch rivets. Use rechargeable riveter -VAS 5279A- with attachments S1 and D2 from -VAS 5279/2 - or rechargeable riveter -VAS 5279B- with attachments S1 and D2 .
- Remove remaining material using compact angle grinder - VAS 5167- .



Replacement parts

- ◆ Pop rivets
- ◆ A-pillar (sub-part) -4E4 809 849/4E4 809 850-
- ◆ 2-component epoxy adhesive -DA 001 730 A2-
- ◆ Aluminium primer -DA 009 801 -
- ◆ Solid rivets
- ◆ Silicate stone -DA 009 800 -

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Preparing new part

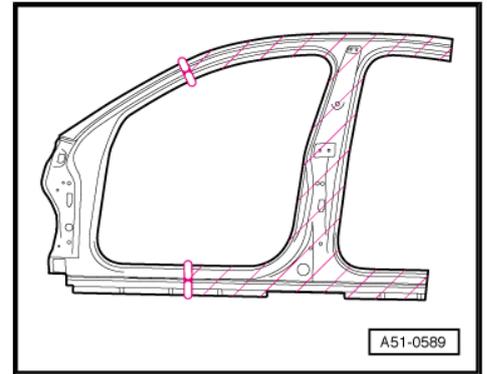
- Transfer separating cuts to new part and cut to shape using pneumatic sabre saw -V.A.G 1523A- .
- Fix outer A-pillar on portal gauge.

 **Note**

Bolt on hinges and striker plate for better positioning.

 **Note**

Refer to General information on bonding.



Preparing joints for adhesive application

- Clean bonding area with silicone remover - LSE 020 100 A3- .
- Prepare bonding area with silicate stone -DA 009 800 - and clean.
- Apply aluminium primer -DA 009 801 - to bonding surfaces using applicator -D 009 500 25 - .
- Apply 2-component body adhesive -DA 001 730 A2- to entire riveting area using pneumatic glue gun -V.A.G 2005 B- .

Preparing new part

- Weld in weld pool backing to body side of joint.

Riveting in

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- **Fit outer A-pillar and fix in position.**

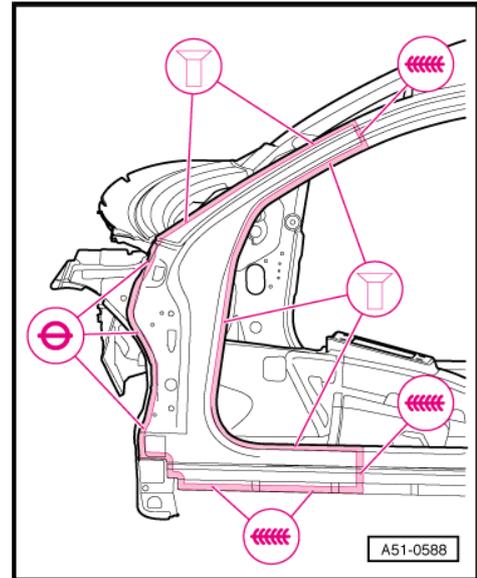
Rivet in outer A-pillar using rechargeable riveter -VAS 5279A- .

 **Note**

Rivet in new part with 4.8 x 9 mm aluminium pop rivets.

- Set pop rivets in overlap area using pop rivet pliers -VAS 5072- .
- Weld in outer side member using shielded arc welding equipment 250A : SG continuous seam.

- Weld in at separating cuts using shielded arc welding equipment 250A : SG continuous seam.



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RO: 51 41 55 00

5 Outer B-pillar - Renewal



WARNING

Always observe safety precautions.

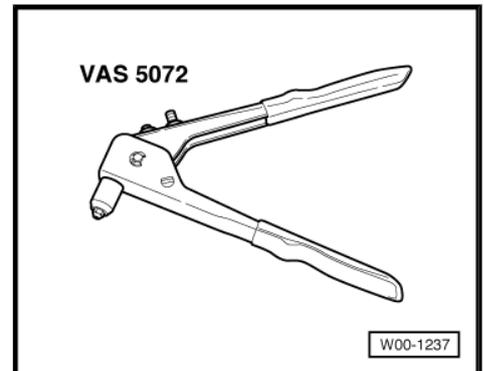
Safety notes ⇒ General Information; Body Repairs, General Body Repairs ; Safety notes .

5.1 Tools

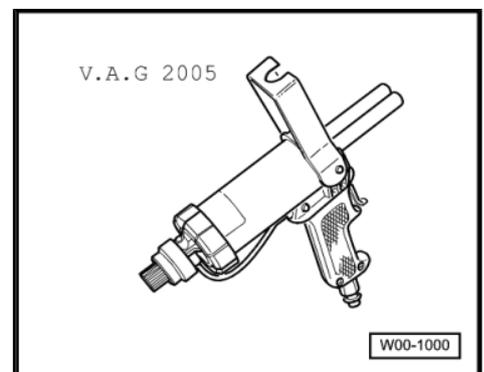
Special tools and workshop equipment required

- ◆ Drill -VAS 5830-
- ◆ Compact angle grinder -VAS 5167-
- ◆ Pop rivet pliers -VAS 5072-

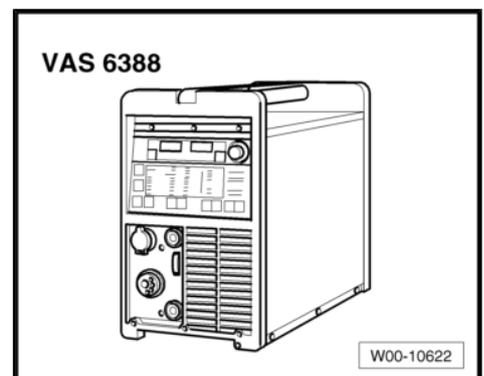
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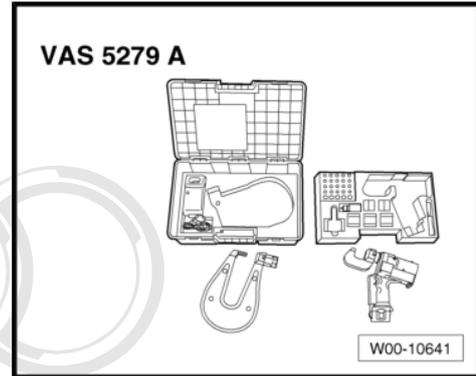
- ◆ Pneumatic glue gun -V.A.G 2005 B-



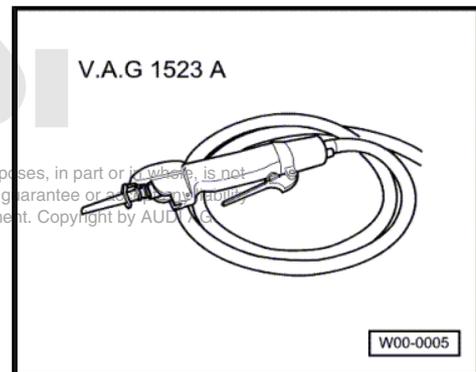
- ◆ Shielded arc welding equipment 250A



◆ Rechargeable riveter -VAS 5279A-



◆ Pneumatic sabre saw -V.A.G 1523A-



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5.2 Procedure

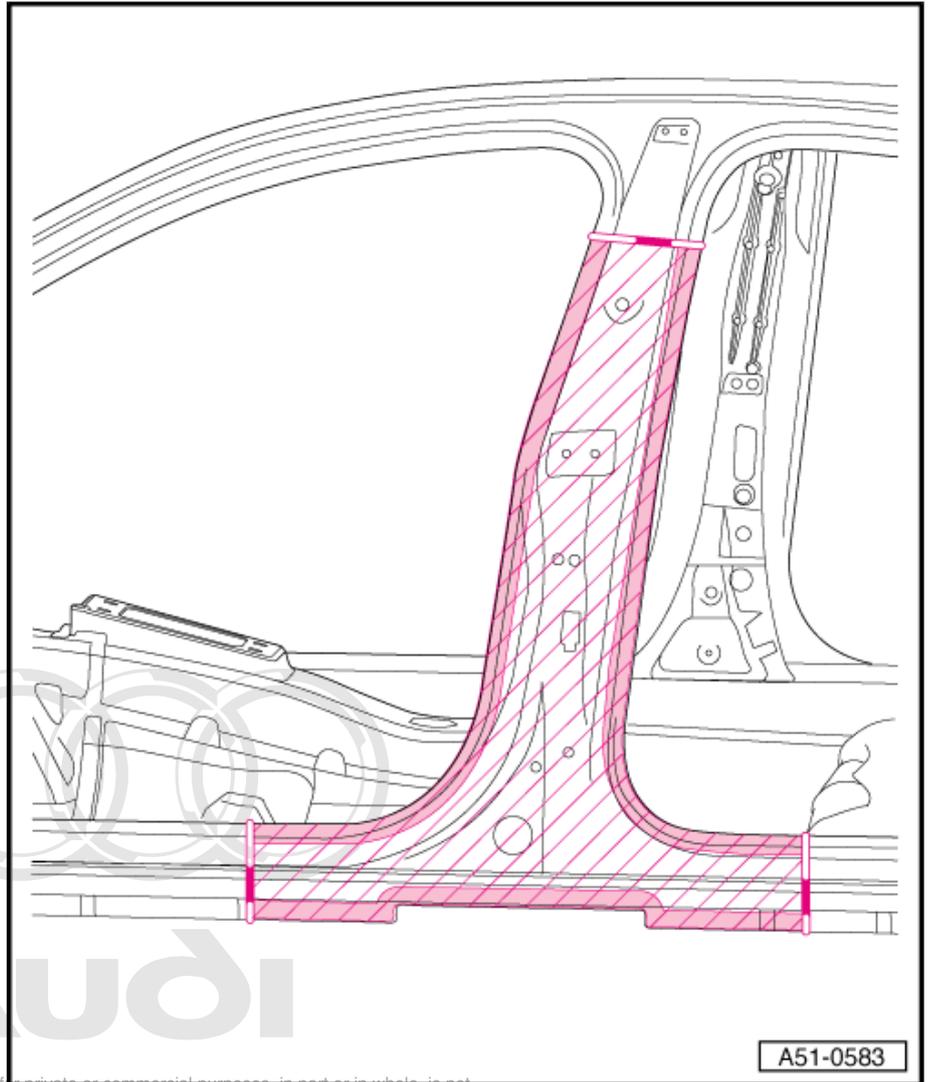
Cutting locations

- Make separating cut as shown using pneumatic sabre saw - V.A.G 1523A- . Take care not to damage internal reinforcement.
- Take care not to damage inner side member when making separating cuts in side member.
- Separate riveted joints on B-pillar using rechargeable riveter - VAS 5279A- .
- Separate original joint with rechargeable riveter -VAS 5279A- .

Remove large punch rivets. Use rechargeable riveter -VAS 5279A- with attachments S4 and D5 from -VAS 5279/2 - or rechargeable riveter -VAS 5279B- with attachments S1 and D2 .

Remove small punch rivets. Use rechargeable riveter -VAS 5279A- with attachments S1 and D2 from -VAS 5279/2 - or rechargeable riveter -VAS 5279B- with attachments S1 and D2 .

- Remove remaining material using compact angle grinder - VAS 5167- .



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Replacement parts

- ◆ A-pillar (sub-part) -4E4 809 849/4E4 809 850-
- ◆ 2-component epoxy adhesive -DA 001 730 A2-
- ◆ Silicone remover - LSE 020 100 A3-
- ◆ Silicate stone -DA 009 800 -
- ◆ Aluminium primer -DA 009 801 -
- ◆ Solid rivets
- ◆ Pop rivets

Preparing new parts

- Transfer separating cut to new part and cut to size using pneumatic sabre saw -V.A.G 1523A- .

Preparing new part

- Fit outer B-pillar and fix in position.



Note

Bolt on hinges and striker plate for better positioning.

Preparing joints for adhesive application

- Clean bonding area with silicone remover - LSE 020 100 A3- .
- Prepare bonding area with silicate stone -DA 009 800 - and clean.
- Apply aluminium primer -DA 009 801 - to bonding surfaces using applicator -D 009 500 25 - .
- Apply 2-component body adhesive -DA 001 730 A2- to entire riveting area using pneumatic glue gun -V.A.G 2005 B- .
- Countersink holes in all parts.
- Prepare flanges on body and new parts for welding.

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Riveting in



Note

Refer to General information on bonding.

- Fit outer B-pillar and fix in position.

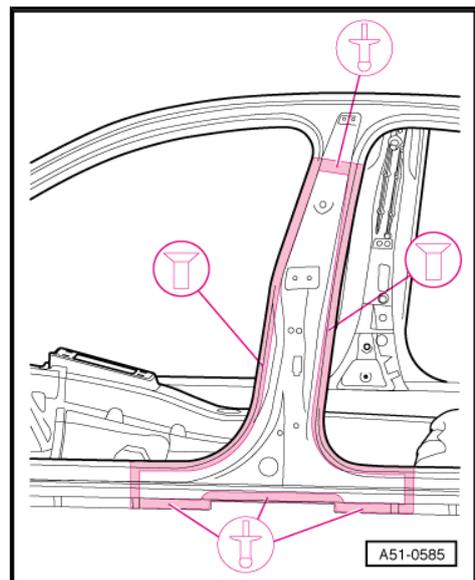
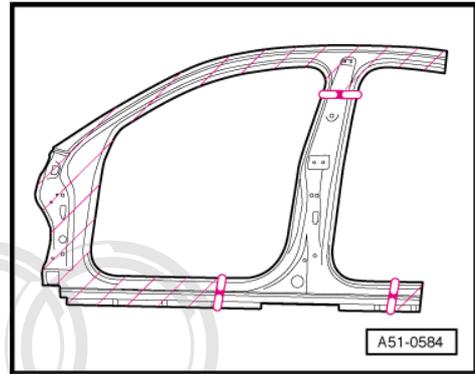


Note

Use clamps.

Rivet in outer B-pillar using rechargeable riveter -VAS 5279A- .

- Set pop rivets in overlap area using pop rivet pliers -VAS 5072- .



RO: 51 45 55 00

6 Outer side member - Renewal



WARNING

Always observe safety precautions.

1 - Outer side member

2 - Separating cut in B-pillar

3 - Separating cut in A-pillar

4 - Separating cut in side member (front)

Partial renewal

Partial renewal is possible with this separating cut.

5 - Separating cut in side member

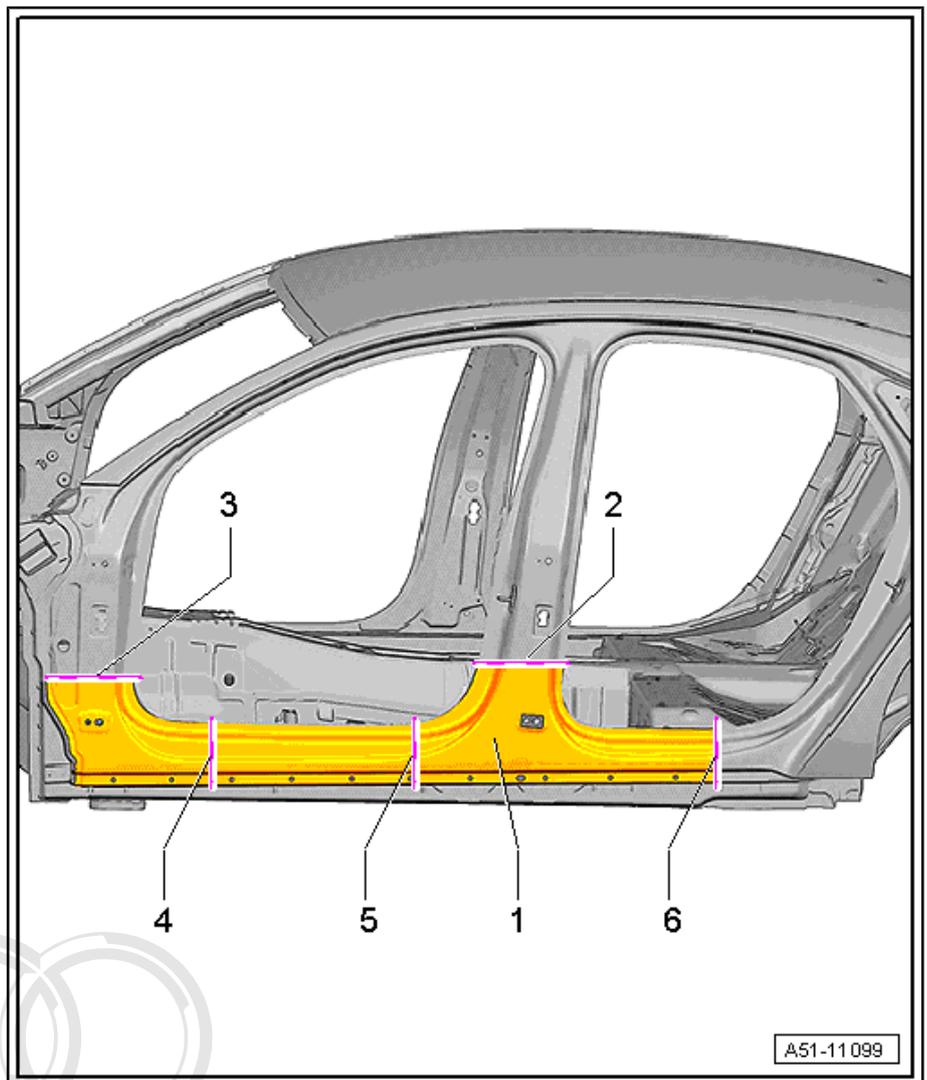
Partial renewal

Partial renewal is possible with this separating cut.

6 - Separating cut in side member

Partial renewal

Partial renewal is possible with this separating cut.



A51-11099

6.1 Tools

Special tools and workshop equipment required

◆ Compact angle grinder -VAS 5167-

◆ Drill -VAS 5830-

◆ Chisel -VAS 5300/34-

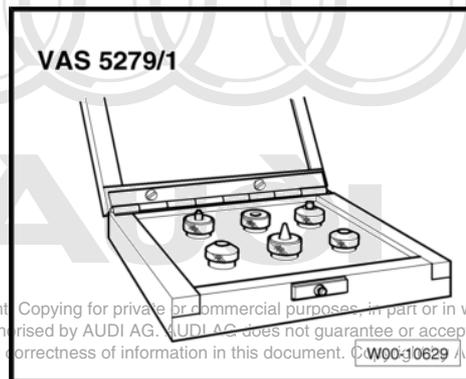
◆ Socket for flow-drill screws -VAS 6426-

◆ Compact angle grinder -VAS 5167-

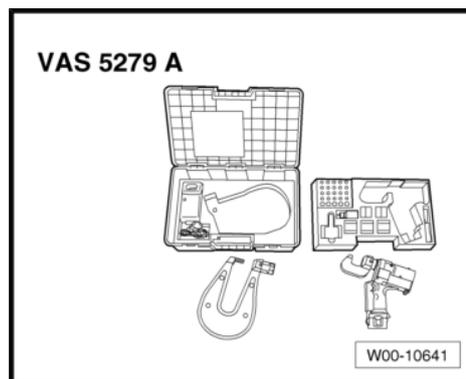
◆ Double cartridge gun -VAS 6453-

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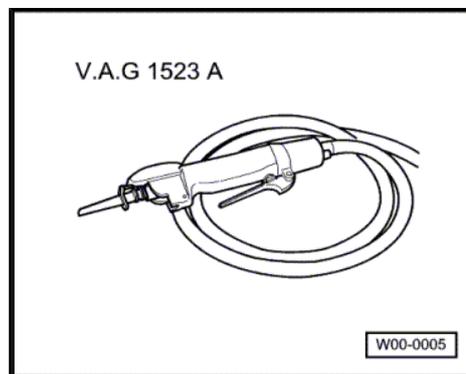
- ◆ Accessory set for rechargeable riveter -VAS 5279/1-



- ◆ Rechargeable riveter -VAS 5279A-
- ◆ Alternatively, you can use the new rechargeable riveter -VAS 5279 B-. This is a complete set.



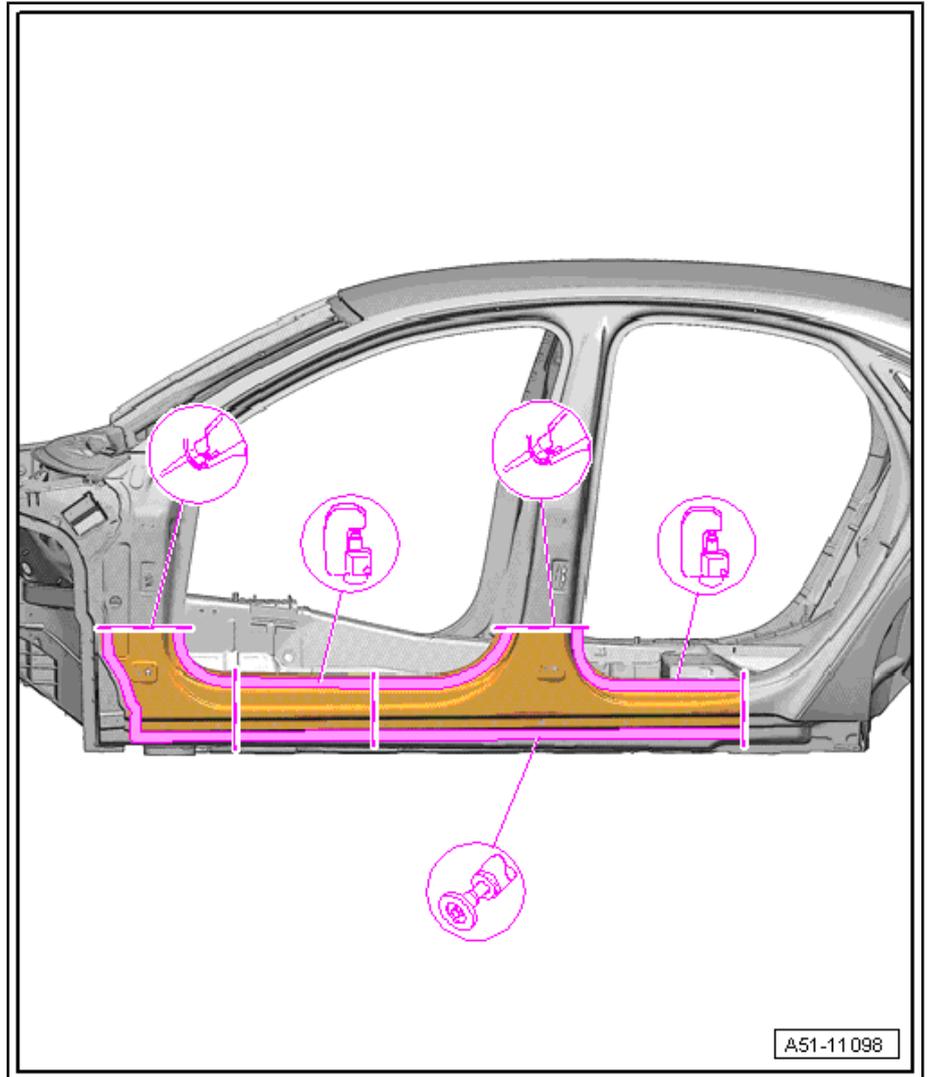
- ◆ Shielded arc welding equipment
- ◆ Pneumatic sabre saw -V.A.G 1523A-



6.2 Procedure

Cutting locations

- Mark off separating cuts according to degree of damage and make cuts using pneumatic sabre saw -V.A.G 1523A- .
- Separate original joint with rechargeable riveter -VAS 5279A- .
- Separate bonded joints using chisel -VAS 5300/34- .
- Make separating cut 3 in front of node casting.

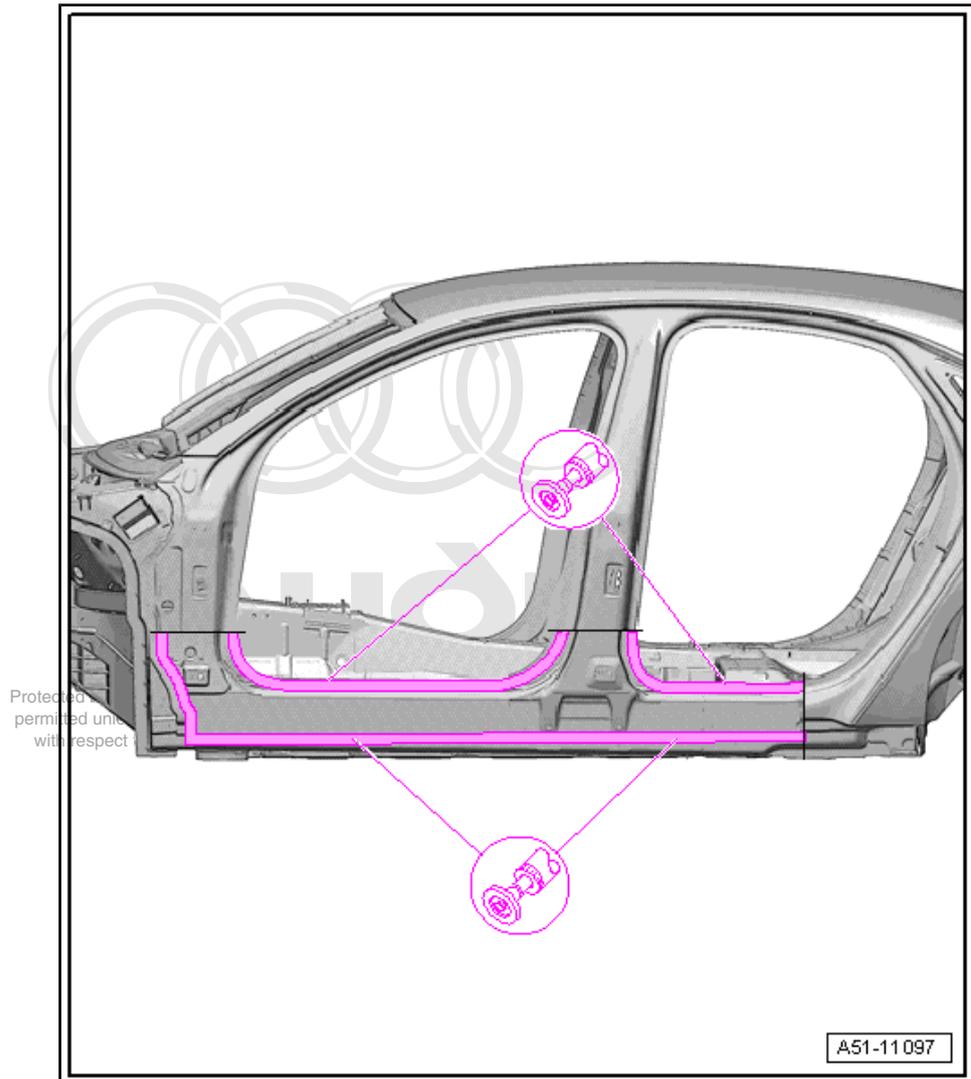


- Remove remaining material using compact angle grinder - VAS 5167- .



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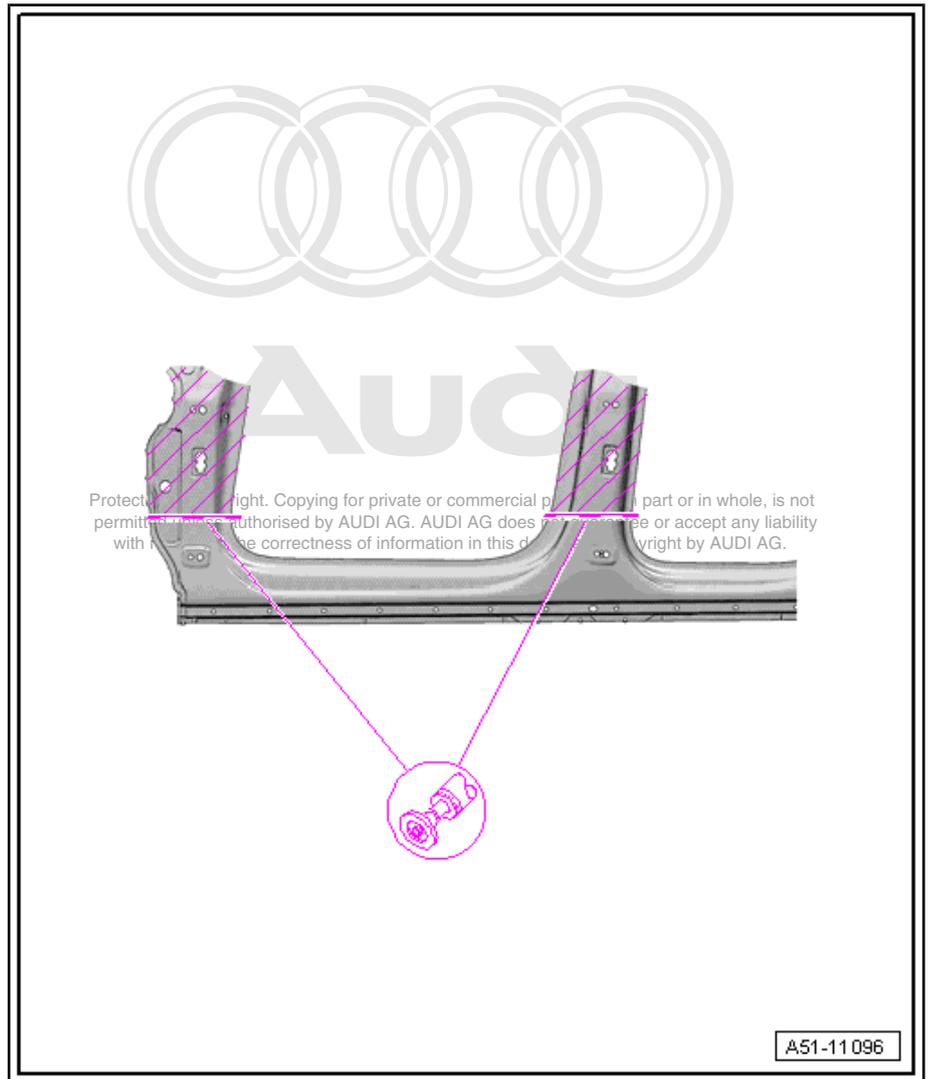


Replacement part

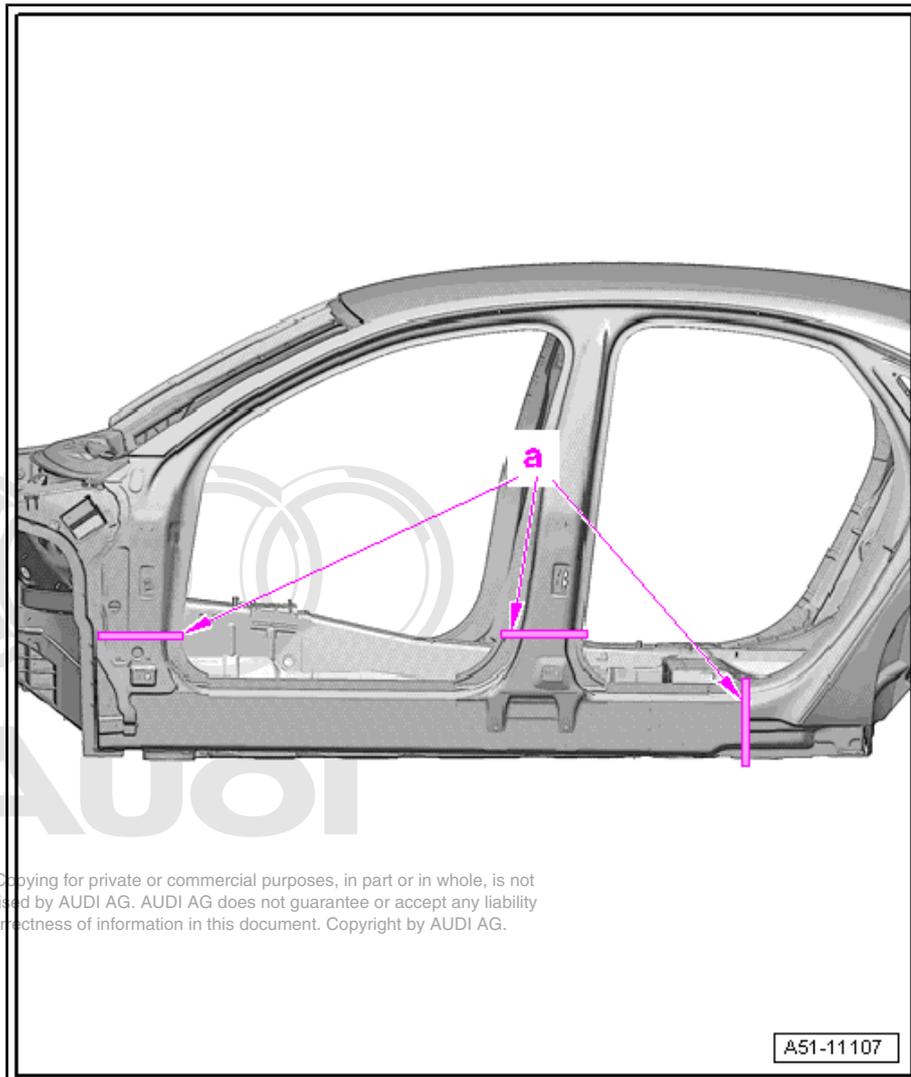
- ◆ Outer side member (sub-part) -4E4 809 838/4E4 809 837-

Preparing new part

- Transfer separating cuts to new part and cut to size using pneumatic sabre saw -V.A.G 1523A- .



- Place backing plate of same material behind separating cuts
-a-

**Note**

Refer to General information on bonding.

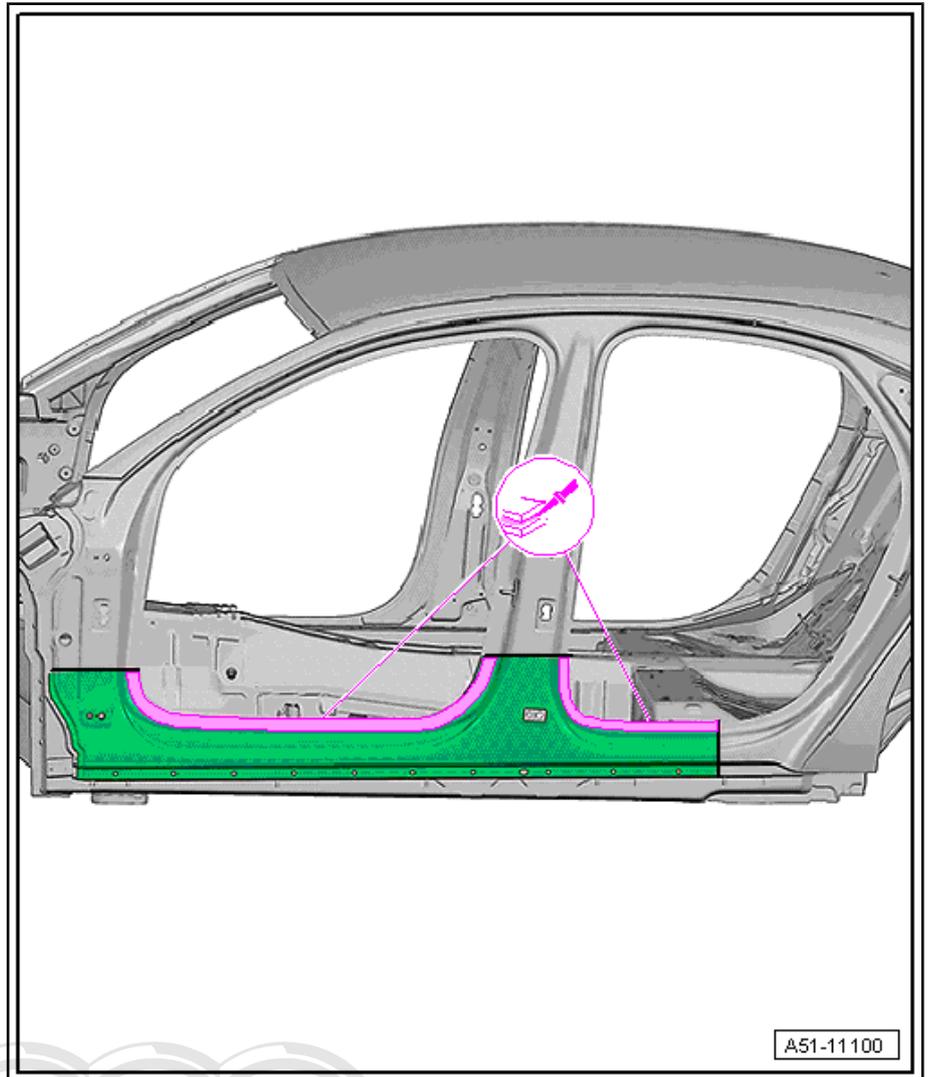
Preparing joints for adhesive application

- Prepare flanges on body and new parts for welding.
- Clean flanges on body and new parts with silicone remover - LSE 020 100 A3- .
- Prepare bonding area with silicate stone -DA 009 800 - and clean.
- Apply aluminium primer -DA 009 801 - to bonding surfaces using applicator -D 009 500 25 - .

Riveting in

- Match up and fix new part in position.
- Check fit relative to bolt-on parts.
- Rivet in outer side member using rechargeable riveter -VAS 5279A- .

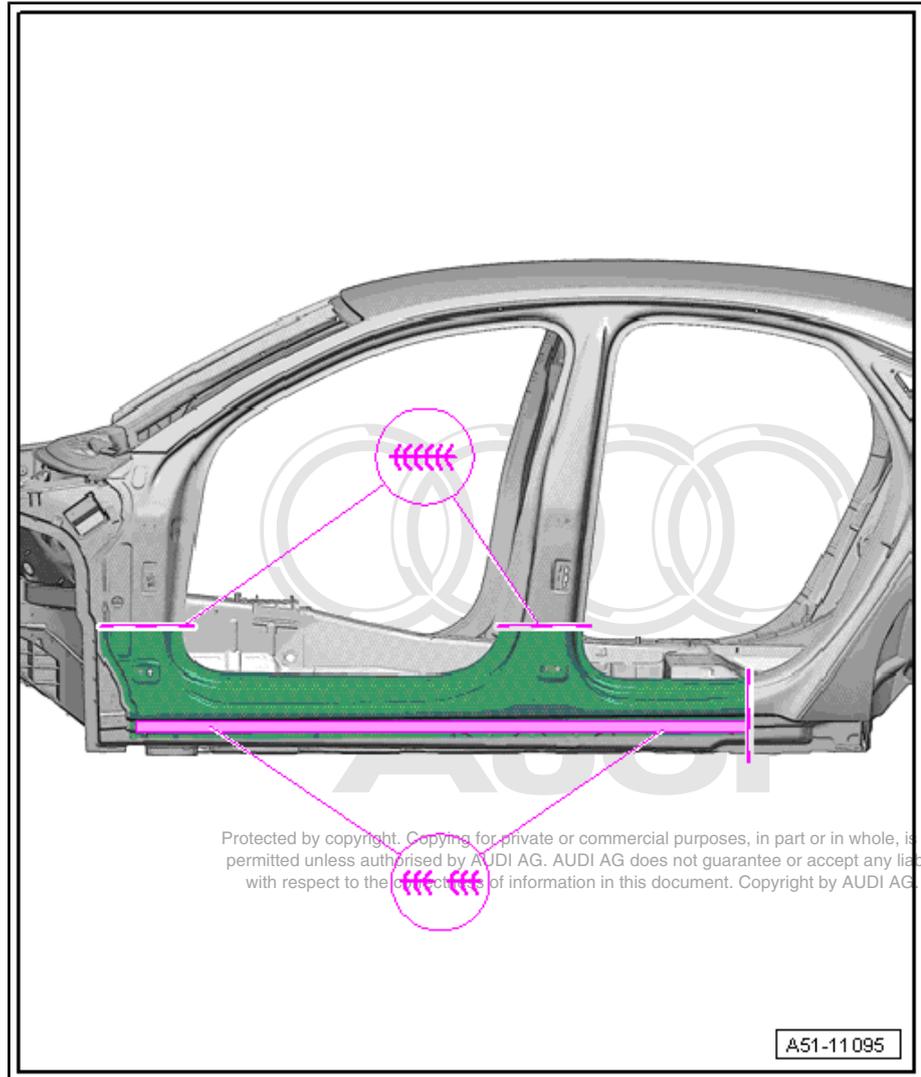
- Apply 2-component body adhesive -DA 180 A00 A2- to bonding area using double cartridge gun -VAS 6453- .



Welding in

- Weld in at outer separating cuts using shielded arc welding equipment : SG continuous seam.
- Weld in lower side member using shielded arc welding equipment : SG continuous seam (staggered - with gaps).

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RO: 51 42 55 50

7 Inner B-pillar - Renewal



WARNING

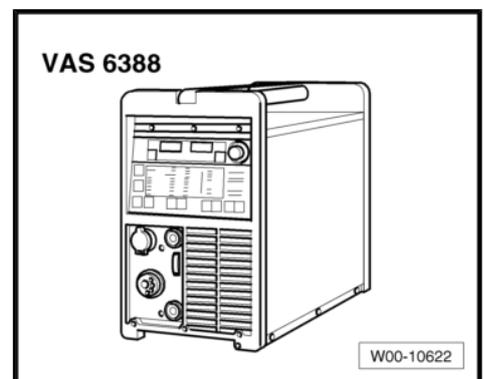
Always observe safety precautions.

Safety notes ⇒ General Information; Body Repairs, General Body Repairs ; Safety notes .

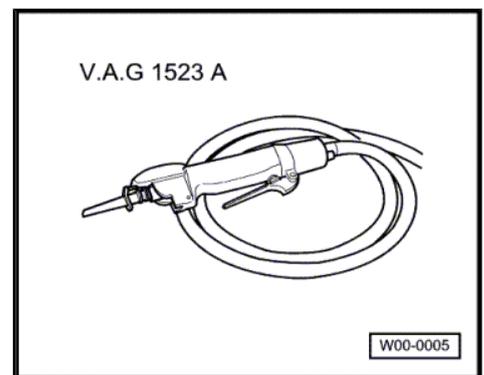
7.1 Tools

Special tools and workshop equipment required

- ◆ Compact angle grinder -VAS 5167-
- ◆ Shielded arc welding equipment 250A



- ◆ Pneumatic sabre saw -V.A.G 1523A-

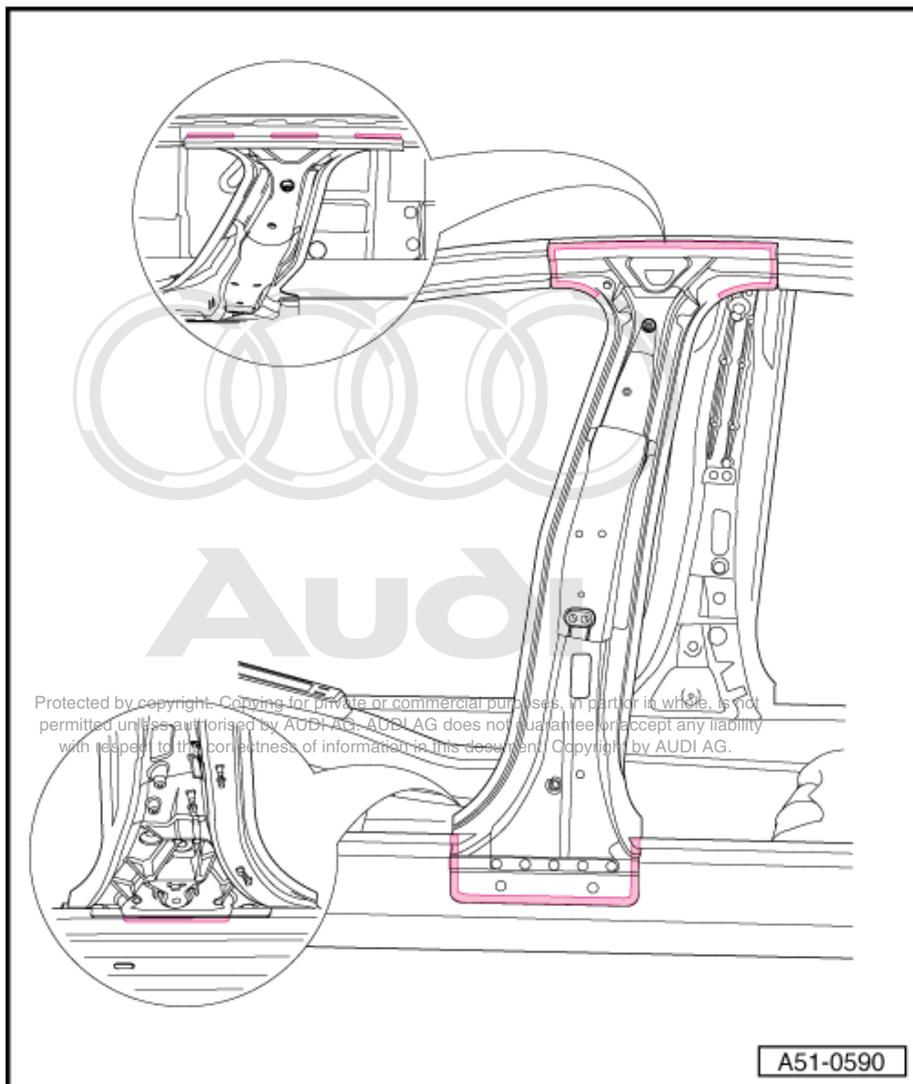


7.2 Procedure

- Outer B-pillar and outer side member already removed
- Roof side member (part section) already removed

Cutting locations

- Separate weld seam between inner B-pillar and inner side member using compact angle grinder -VAS 5167- .
- Separate weld seam between B-pillar and roof side member using compact angle grinder -VAS 5167- .



Replacement part

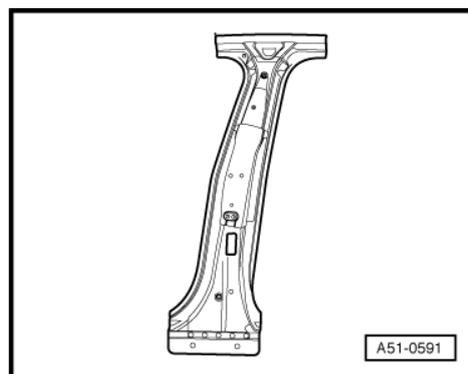
- ◆ Inner B-pillar

Preparing new parts

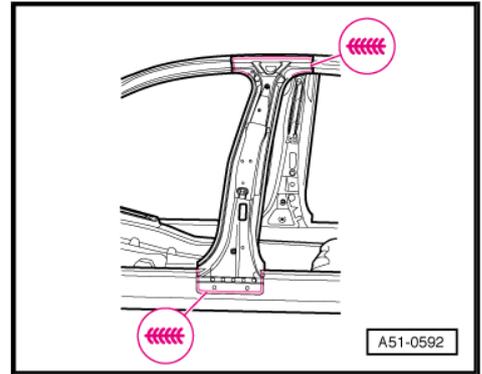
- Prepare flanges on body and new parts for welding.
- Match up new parts.
- Fix inner B-pillar in position on alignment bracket.

Welding in

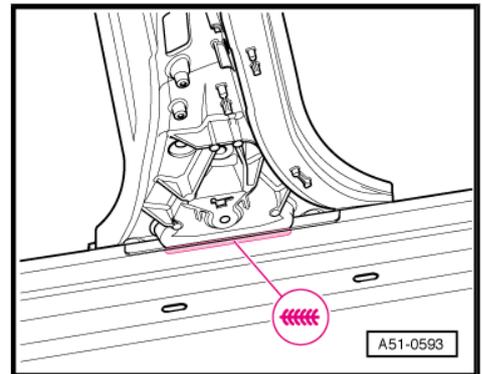
- Weld inner B-pillar to inner side member using shielded arc welding equipment 250A : SG continuous seam.



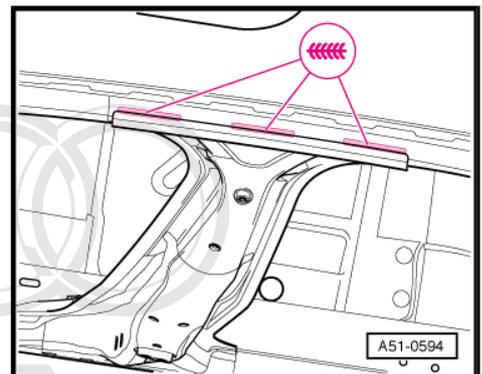
- Weld inner B-pillar to roof side member using shielded arc welding equipment 250A : SG continuous seam.



- Weld inner B-pillar to inner side member using shielded arc welding equipment 250A : SG continuous seam.



- Weld inner B-pillar to roof side member using shielded arc welding equipment 250A : SG continuous seam.



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53 – Body - rear

RO: 53 05 55 00

1 Rear cross panel - Renewal



WARNING

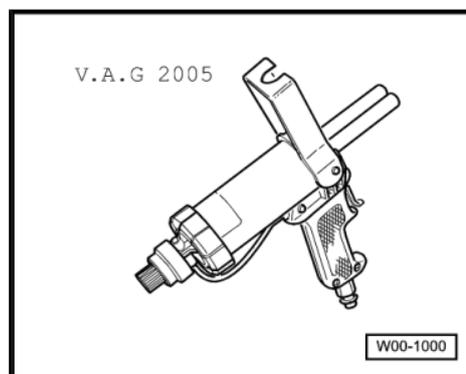
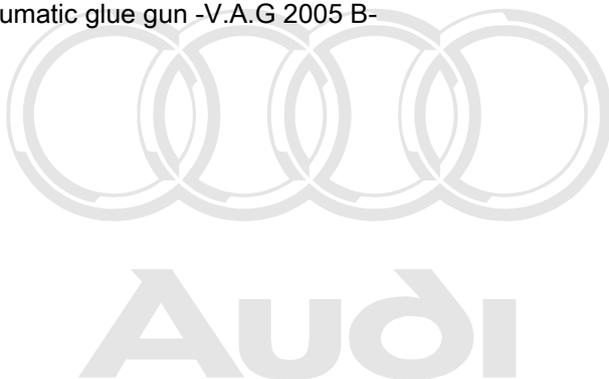
Always observe safety precautions.

Safety notes ⇒ General Information; Body Repairs, General Body Repairs ; Safety notes .

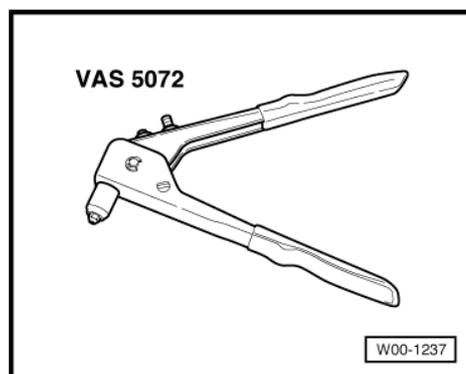
1.1 Tools

Special tools and workshop equipment required

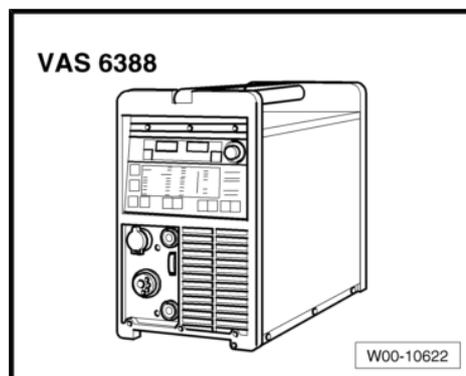
- ◆ Pneumatic glue gun -V.A.G 2005 B-



- ◆ Pop rivet pliers -VAS 5072-
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- ◆ Shielded arc welding equipment 250A

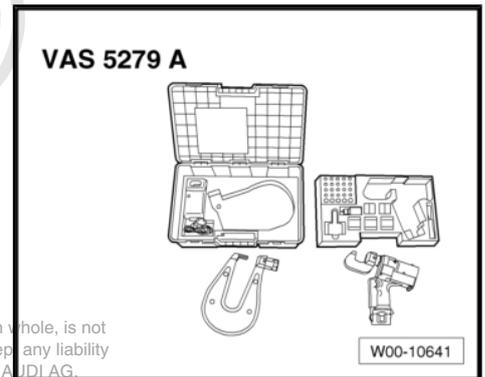


- ◆ Rechargeable riveter -VAS 5279A-

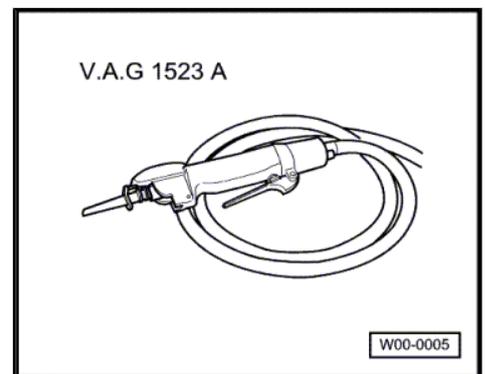
- ◆ When using the rechargeable riveter -VAS 5279A-, the attachment set -VAS 5279/2 - is also required.
- ◆ Alternatively, you can use the new rechargeable riveter -VAS 5279B- . This is a complete set.

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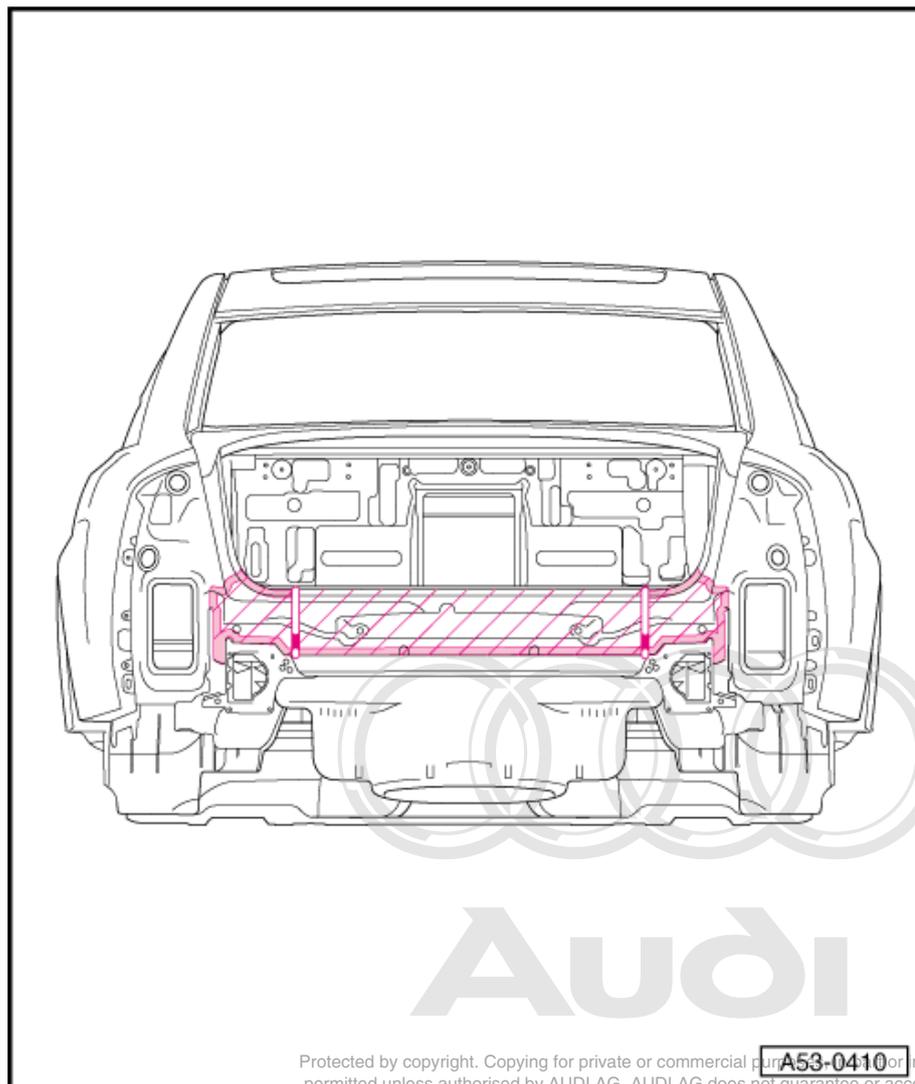
- ◆ Pneumatic sabre saw -V.A.G 1523A-



1.2 Procedure

Cutting locations

- Roughly cut out rear cross panel using pneumatic sabre saw -V.A.G 1523A- .
- Separate original joint with rechargeable riveter -VAS 5279A- .
- Remove remaining material using compact angle grinder -VAS 5167- .



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A53-0410

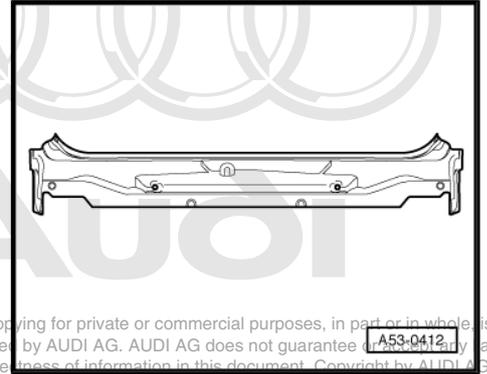
Replacement parts

- ◆ Rear cross panel
- ◆ Pop rivets
- ◆ Silicone remover -LSE 020 100 A3-
- ◆ 2-component epoxy adhesive -DA 001 730 A2-
- Match up new parts.



Check dimensional accuracy with respect to rear lid.

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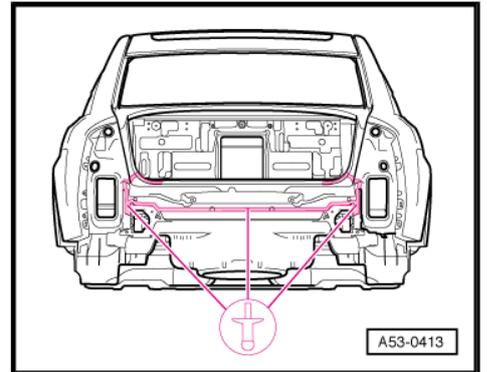


Preparing joints for adhesive application

- Clean bonding area with silicone remover - LSE 020 100 A3- .
- Prepare bonding area with silicate stone -DA 009 800 - and clean.
- Apply aluminium primer -DA 009 801 - to bonding surfaces using applicator -D 009 500 25 - .
- Apply 2-component epoxy adhesive -DA 001 730 A2- to entire riveting area using pneumatic glue gun -V.A.G 2005 B- .
- Insert rear cross panel.

Riveting in

- Rivet in rear cross panel using pop rivet pliers -VAS 5072- .



RO: 53 16 55 00

2 Rear cross member - Renewal



WARNING

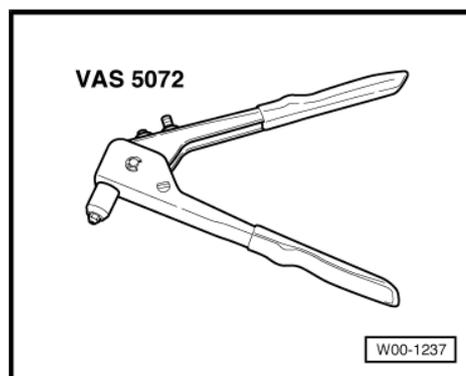
Always observe safety precautions.

Safety notes ⇒ General Information; Body Repairs, General Body Repairs ; Safety notes .

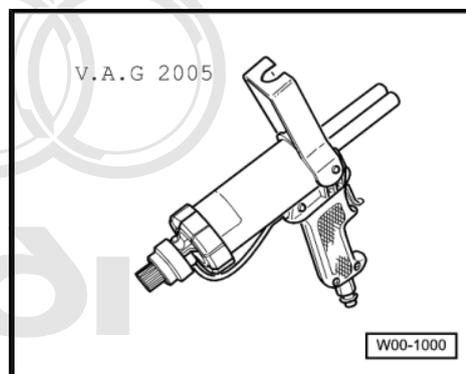
2.1 Tools

Special tools and workshop equipment required

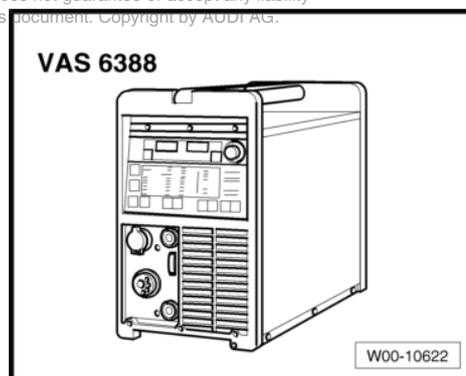
- ◆ Compact angle grinder -VAS 5167-
- ◆ Drill -VAS 5830-
- ◆ Pop rivet pliers -VAS 5072-



- ◆ Pneumatic glue gun -V.A.G 2005 B-

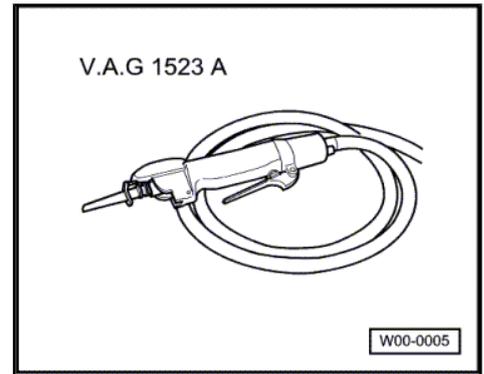


- ◆ Shielded arc welding equipment 250A



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- ◆ Pneumatic sabre saw -V.A.G 1523A-

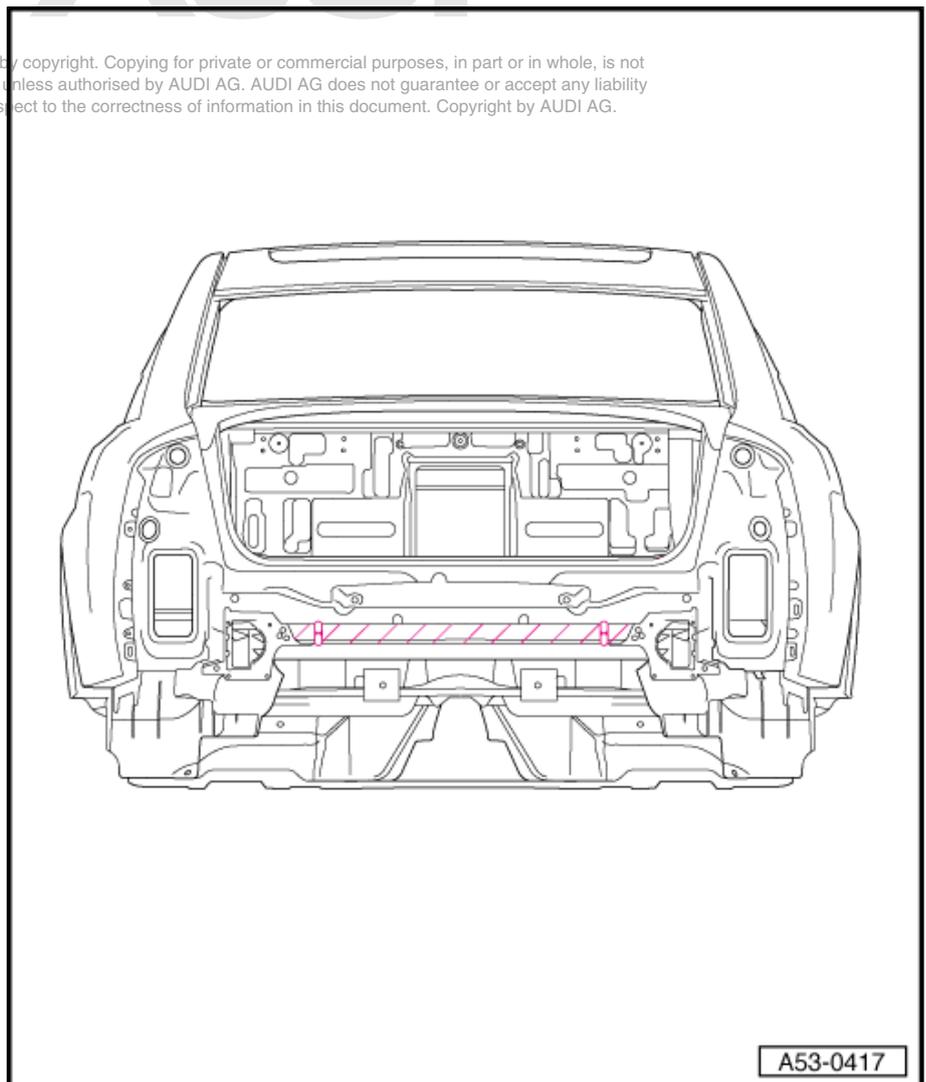


2.2 Procedure

Cutting locations

- Roughly cut out rear cross member using pneumatic sabre saw -V.A.G 1523A- .
- Detach part.
- Remove remaining material using compact angle grinder - VAS 5167- .

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Replacement parts

- ◆ Rear cross member
- ◆ Pop rivets
- ◆ 2-component epoxy adhesive -DA 001 730 A2-



Note

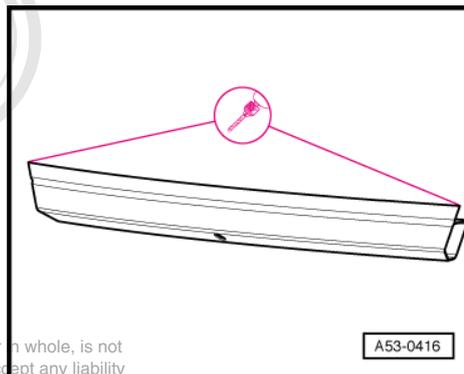
Refer to General information on bonding.

Preparing new part

- New part for bonding only: Drill 4 x left + right
- Match up new part to body.

Preparing joints for adhesive application

- Clean bonding area with silicone remover - LSE 020 100 A3- .
- Prepare bonding area with silicate stone -DA 009 800 - and clean.
- Apply aluminium primer -DA 009 801 - to bonding surfaces using applicator -D 009 500 25 - .
- Apply 2-component epoxy adhesive -DA 001 730 A2- to entire riveting area using pneumatic glue gun -V.A.G 2005 B- .

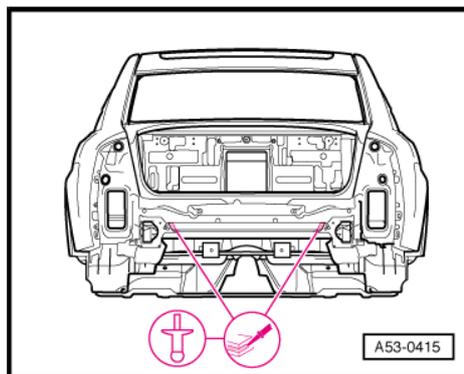


Riveting in

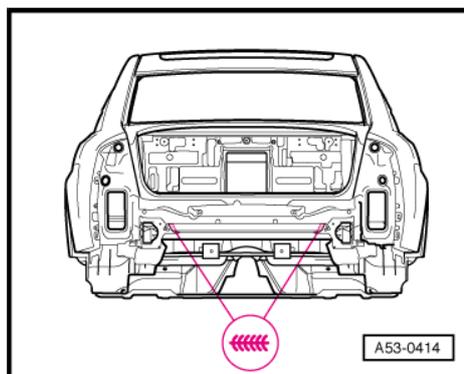
- Rivet in new part using pop rivet pliers -VAS 5072- .

Welding in

- Prepare flanges on body and new parts for welding.



- Weld in rear cross member using shielded arc welding equipment 250A : SG continuous seam.



RO: 53 48 55 62

3 Rear longitudinal member - Partial renewal



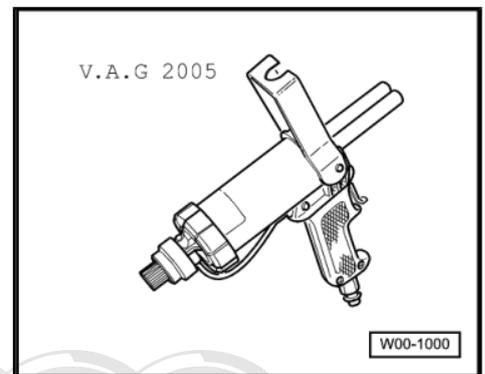
WARNING
Always observe safety precautions.

Safety notes ⇒ General Information; Body Repairs, General Body Repairs ; Safety notes .

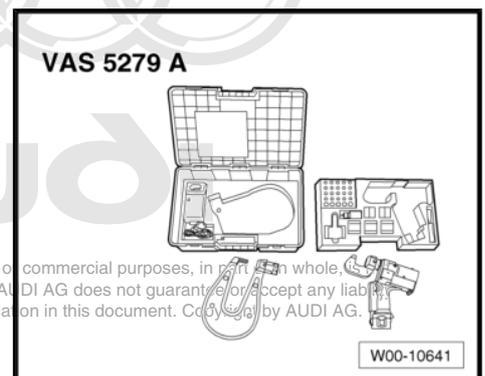
3.1 Tools

Special tools and workshop equipment required

- ◆ Socket for flow-drill screws -VAS 6426 -
- ◆ Drill -VAS 5830-
- ◆ Pneumatic glue gun -V.A.G 2005 B-

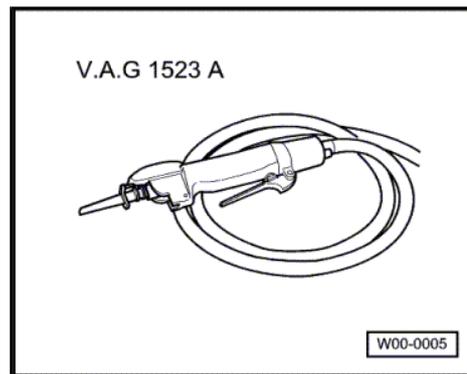


- ◆ Shielded arc welding equipment
- ◆ Rechargeable riveter -VAS 5279A-
- ◆ Alternatively, you can use the new rechargeable riveter -VAS 5279 B- . This is a complete set.



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- ◆ Pneumatic sabre saw -V.A.G 1523A-



3.2 Procedure

Cutting locations

- Spare wheel well already cut out



WARNING

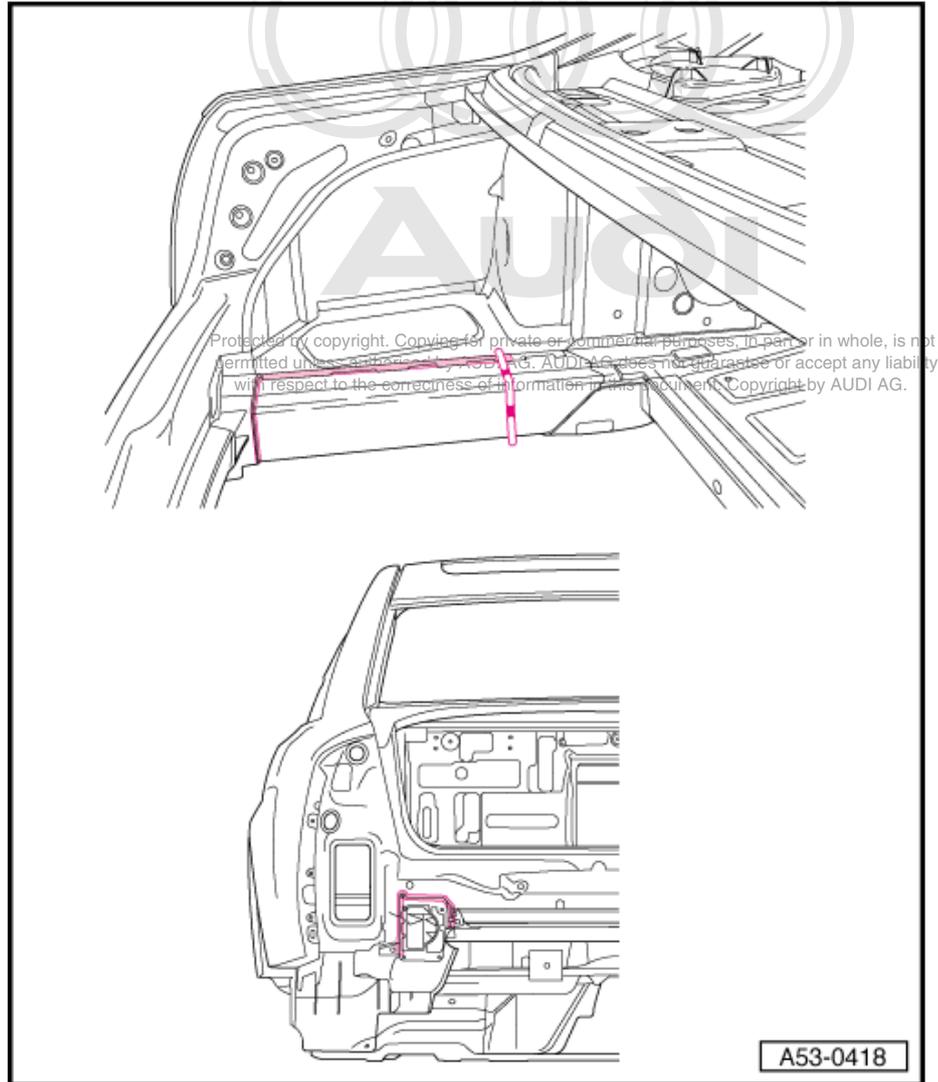
Take care not to damage aluminium node castings.

- Separating cut behind node casting.
- Rear cross panel, welded seam.
- Detach part.



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Replacement part

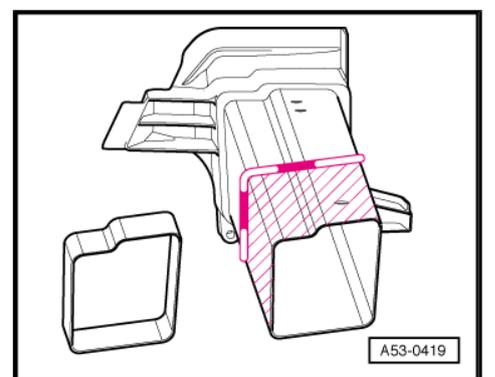
- ◆ Longitudinal member part section
- ◆ Impact damper mounting
- ◆ Sleeves

Preparing new part

- Transfer separating cut to new part and cut off hatched area.

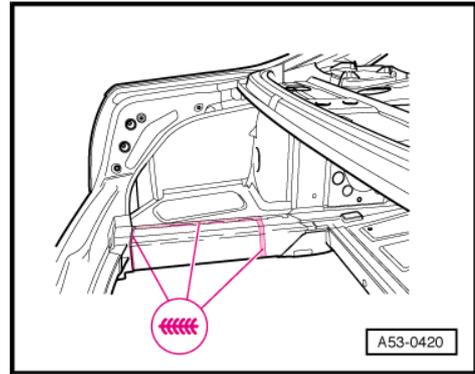
Welding in

- Match up new parts.
- Prepare flanges on body and new parts for welding.
- Insert sleeves in body.
- Fix new parts in position on alignment bracket.





- Weld in new part using shielded arc welding equipment 250A : SG continuous seam.



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RO: 53 55 55 00

4 Side panel - Renewal

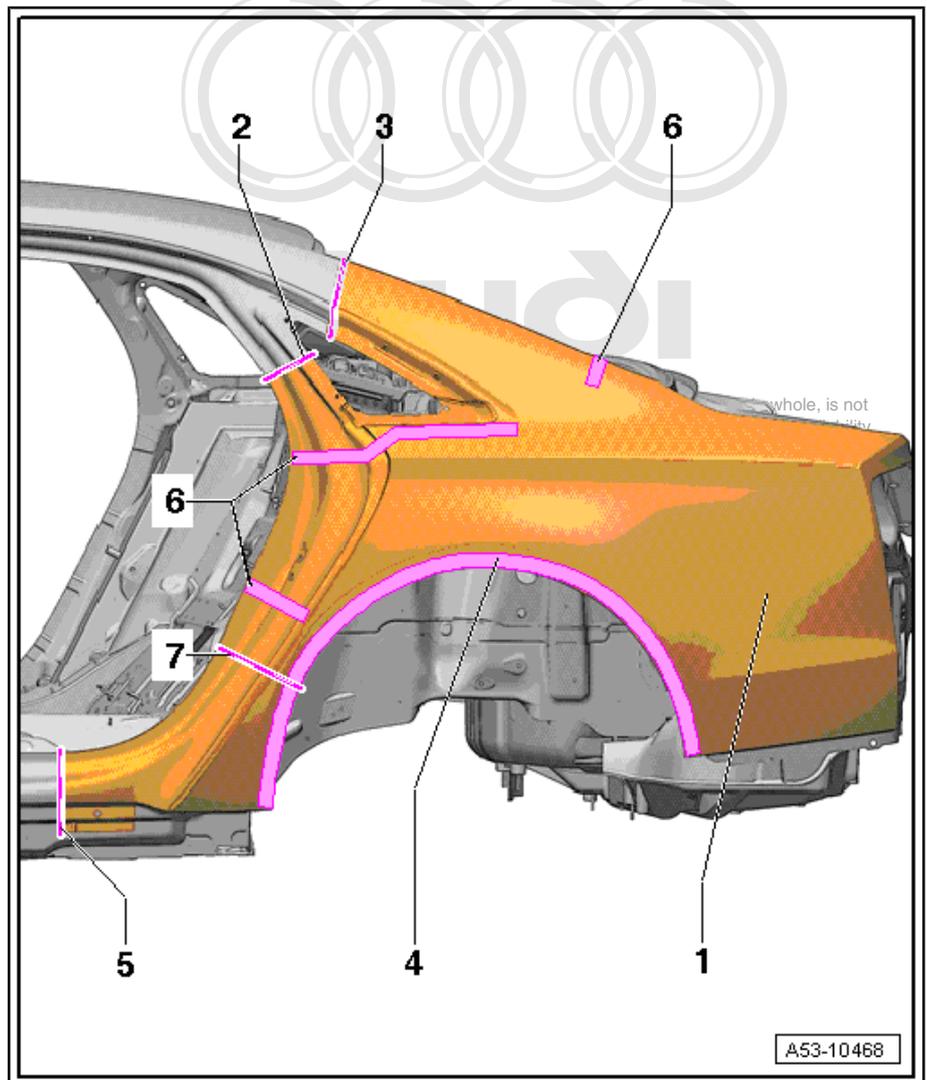


WARNING

Always observe safety precautions.

- 1 - Side panel
- 2 - Separating cut in C-pillar
- 3 - D-pillar separating cut
- 4 - Bonded area
- 5 - Separating cut in side member
- 6 - Moulded foam inserts
- 7 - Separating cut

Partial renewal
Partial renewal is possible with this separating cut.

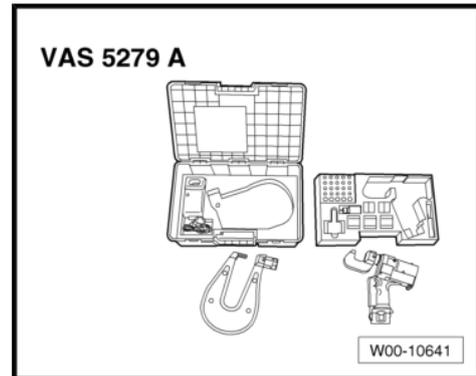


4.1 Tools

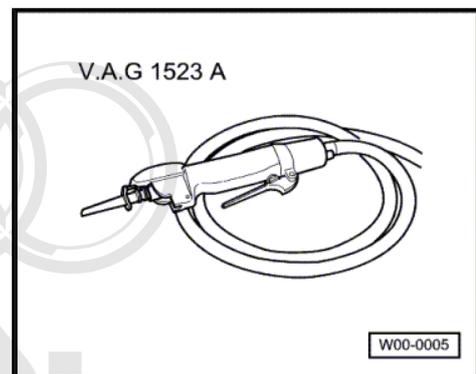
Special tools and workshop equipment required

- ◆ Double cartridge gun -VAS 6453-
- ◆ Shielded arc welding equipment
- ◆ Rechargeable riveter -VAS 5279A-

- ◆ Alternatively, you can use the new rechargeable riveter -VAS 5279 B-. This is a complete set.

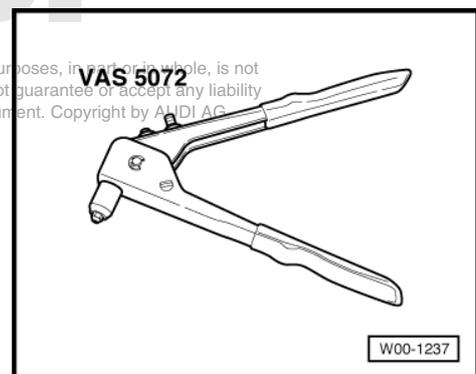


- ◆ Pneumatic sabre saw -V.A.G 1523A-



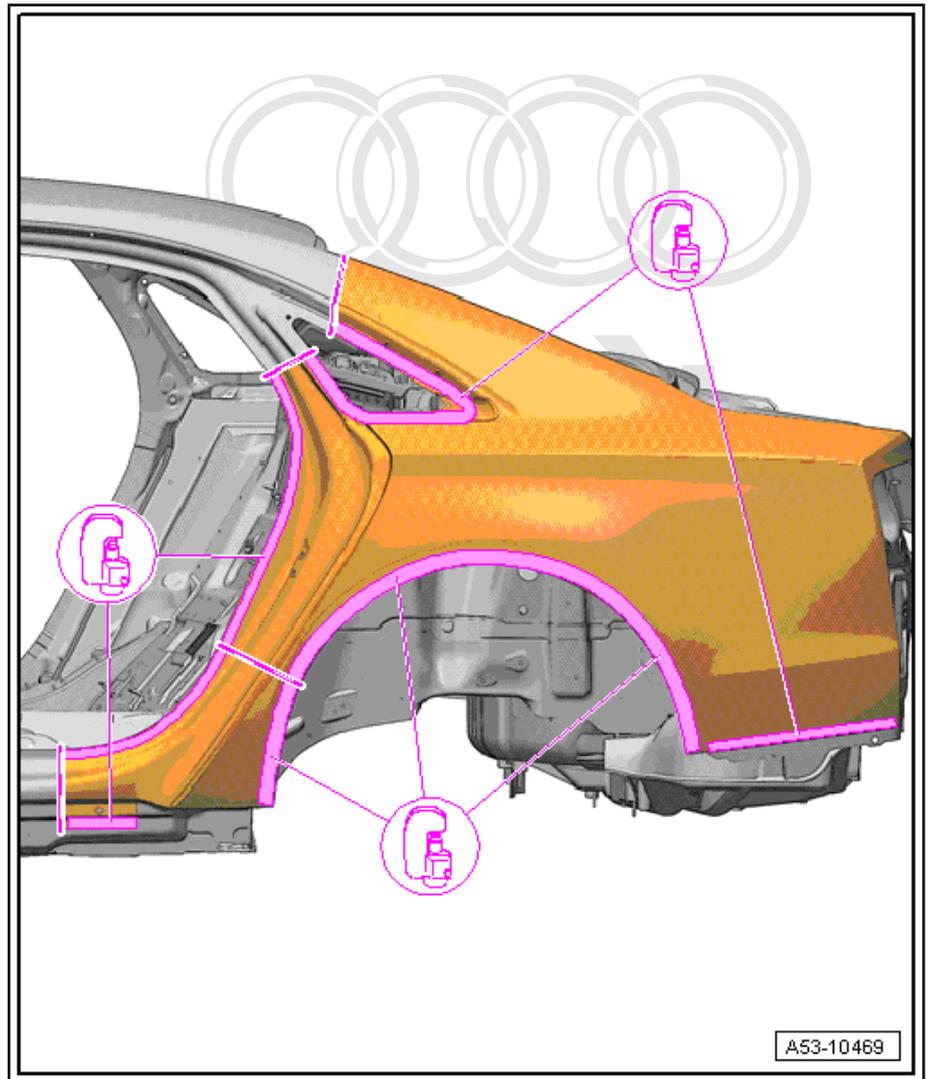
- ◆ Pop rivet pliers -VAS 5072-

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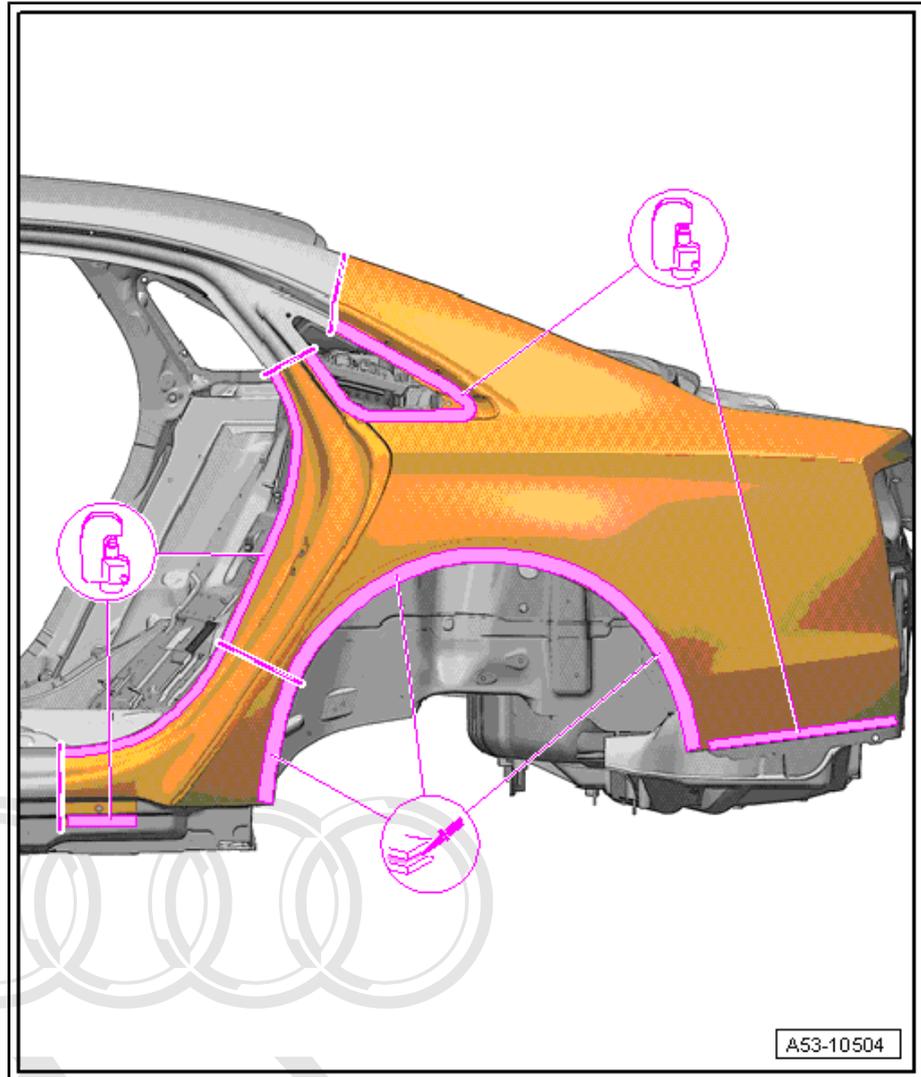


4.2 Procedure

Cutting locations

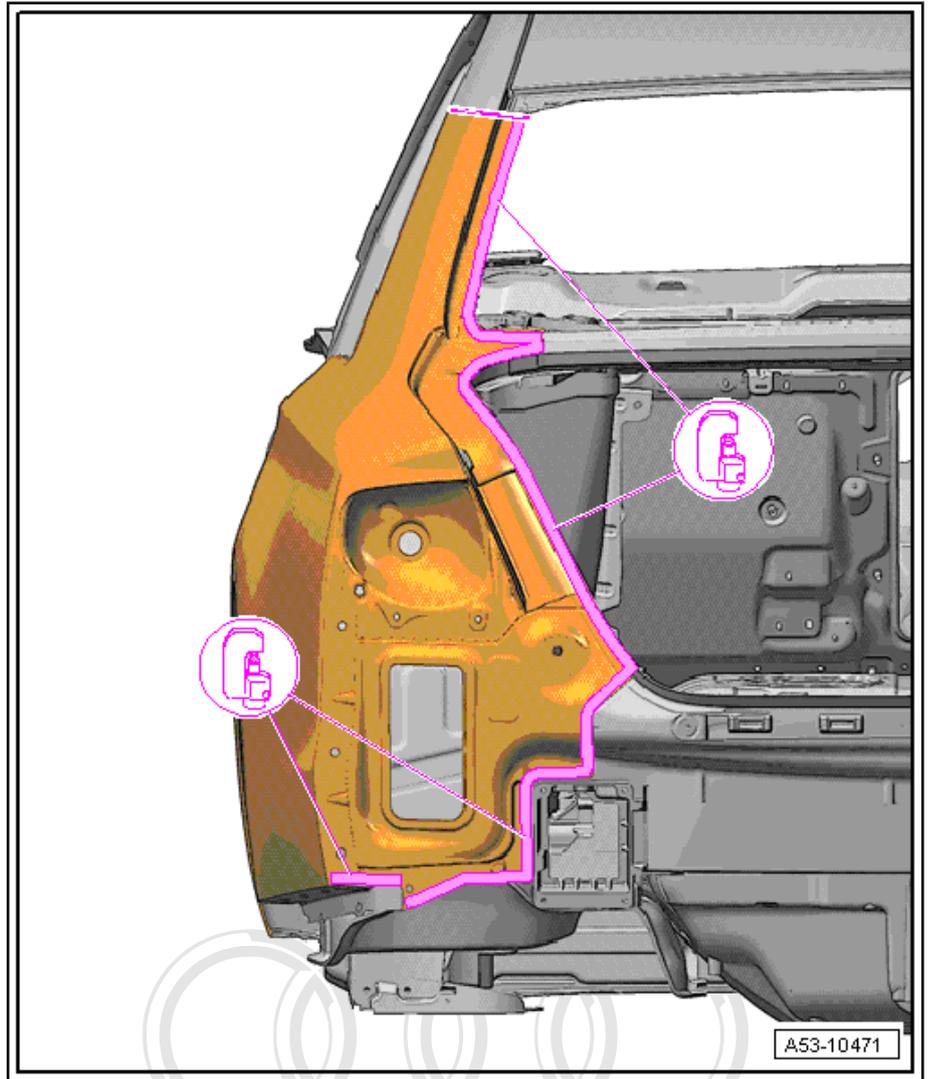


- Make separating cuts at C and D-pillar according to extent of damage.
- Make separating cuts in side member according to extent of damage. Take care not to damage internal reinforcement.
- Grind through outer edge at wheel arch using compact angle grinder - VAS 5167- .
- Separate original joint with rechargeable riveter -VAS 5279A- .



- Separate original joint with rechargeable riveter -VAS 5279A- .

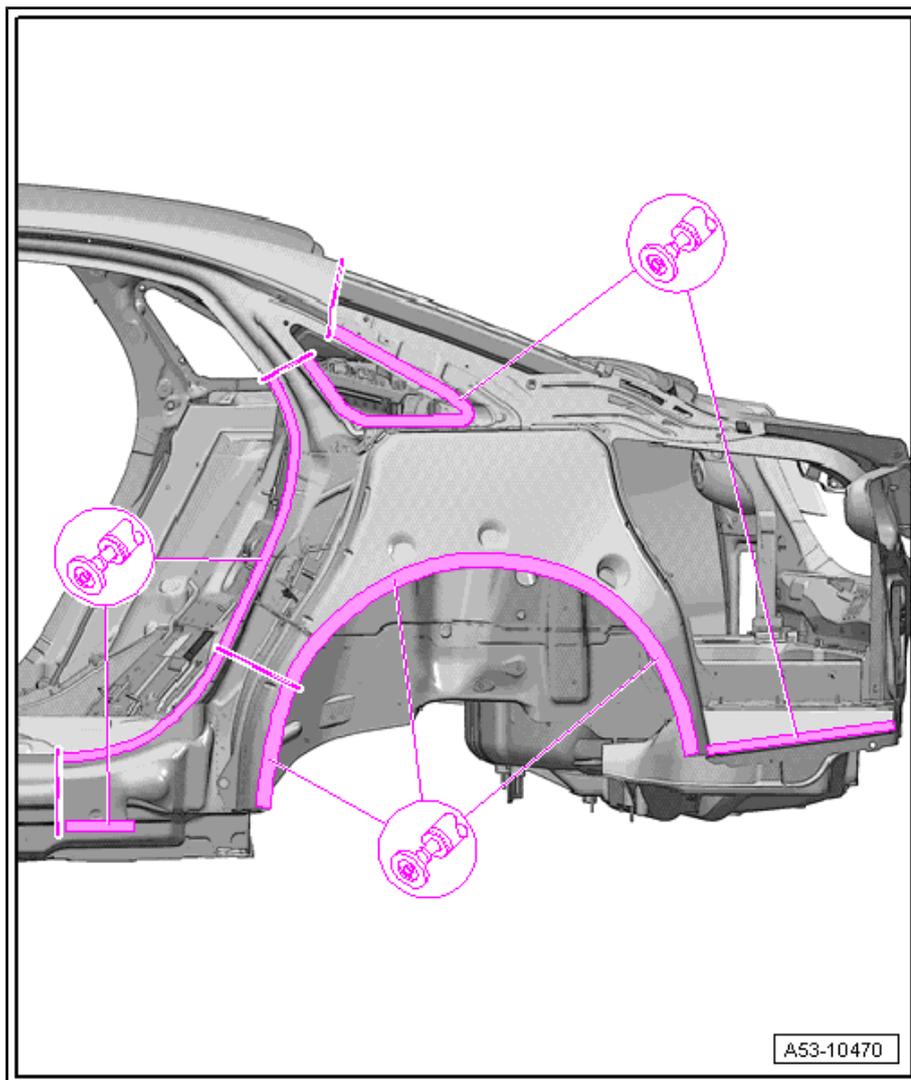
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- Remove remaining material using compact angle grinder - VAS 5167- .

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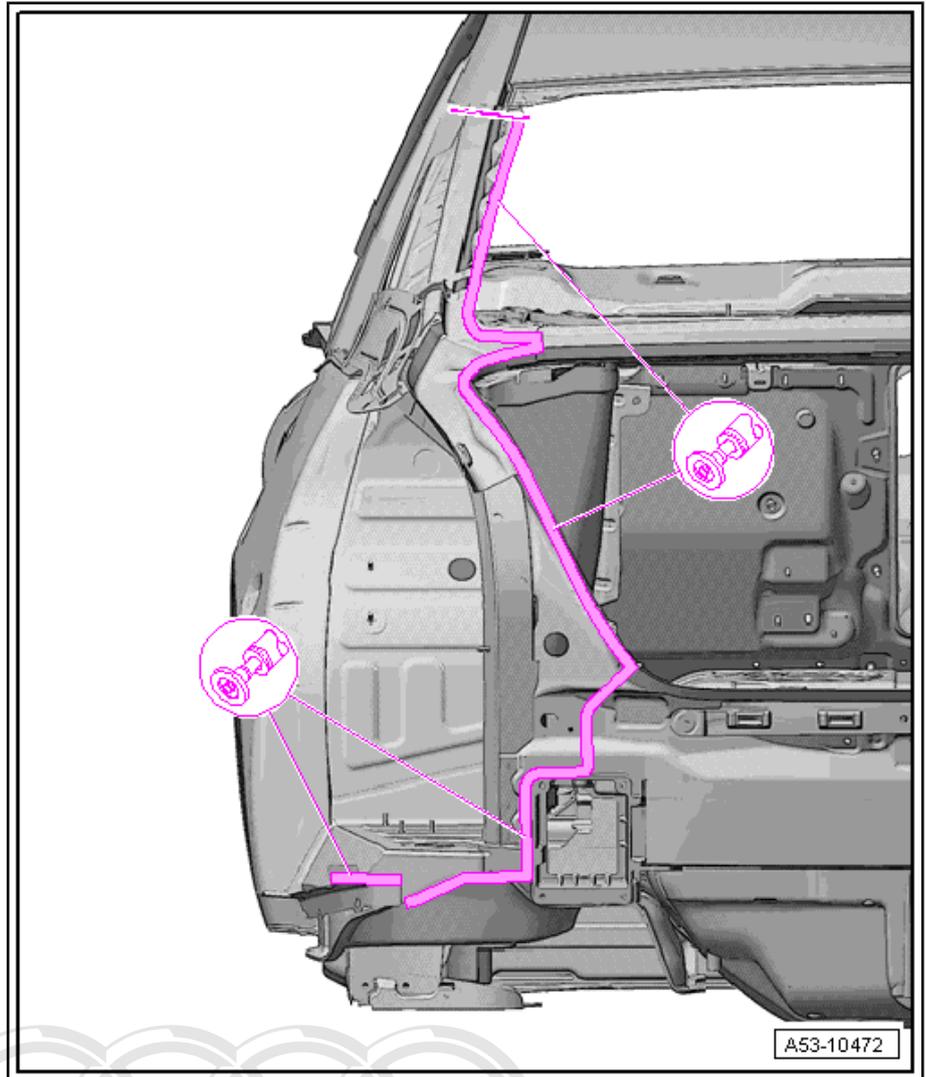
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- Remove remaining material using compact angle grinder - VAS 5167- .



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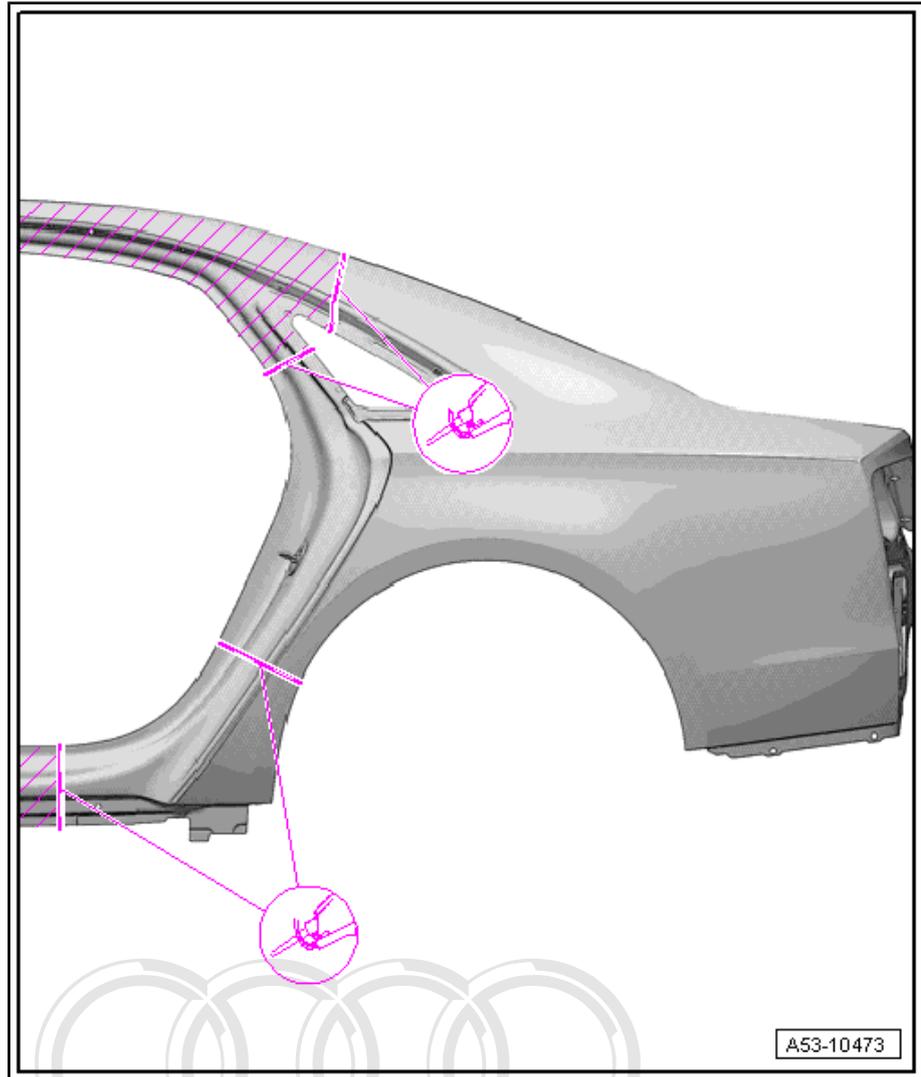
Replacement parts

- ◆ Side frame (sub-part)
- ◆ Body adhesive -DA 001 730 A2-

Preparing new part

- Transfer separating cuts to new part and cut off hatched area using pneumatic sabre saw - V.A.G 1523A- .

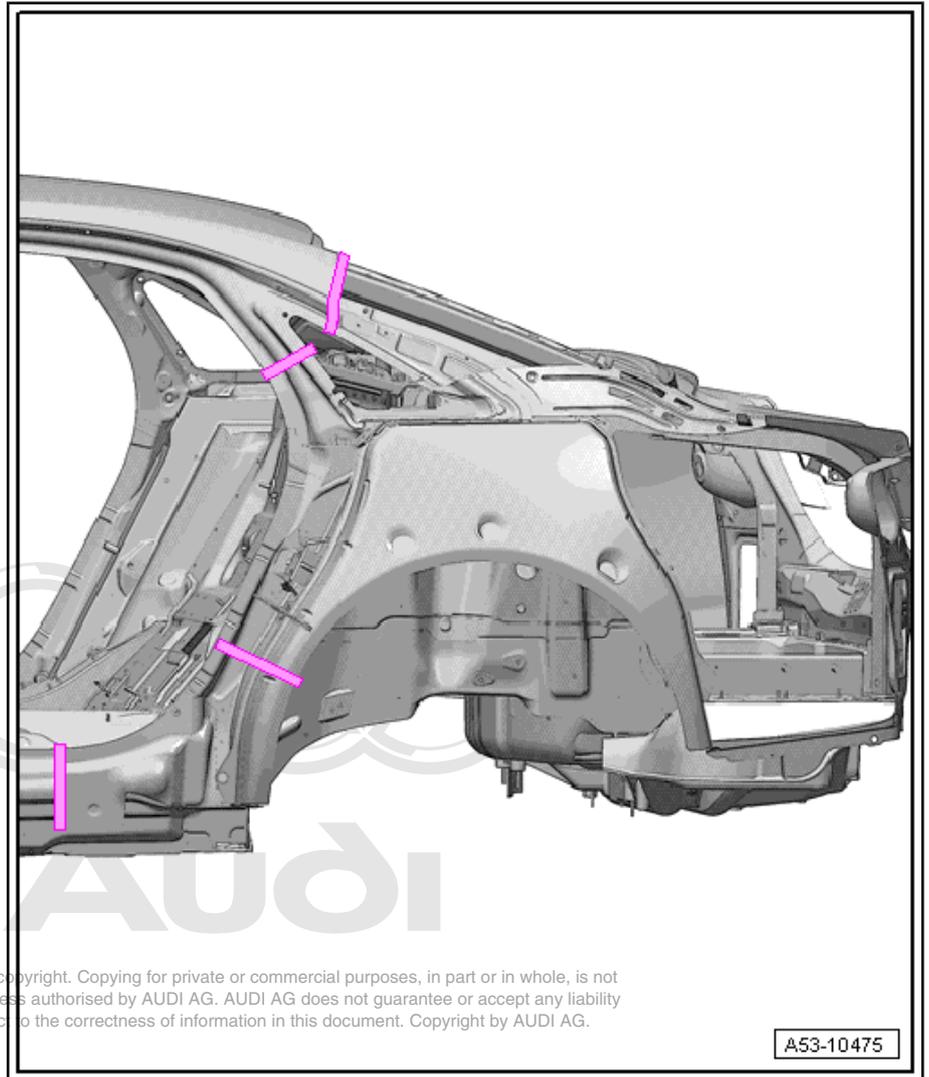
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Weld in weld pool backing plates at separating cuts using surplus material.

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- Fix new part on portal gauge.

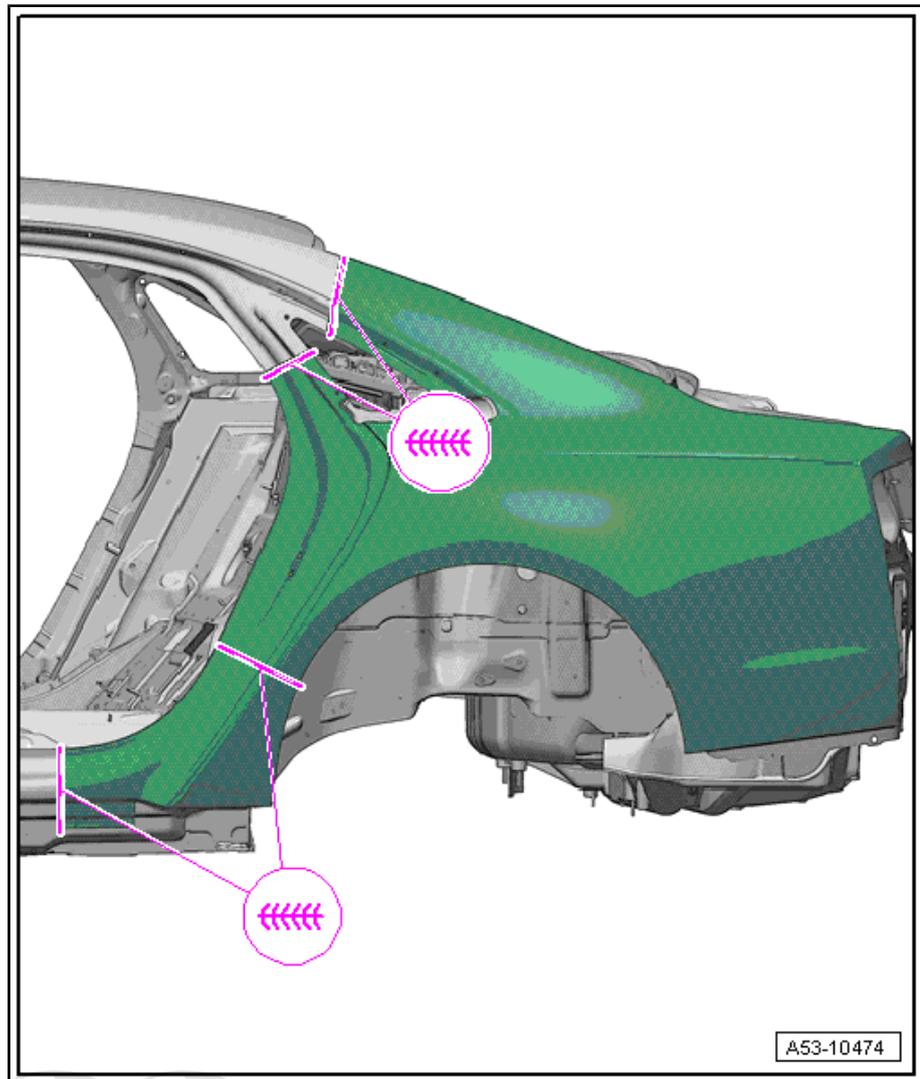
Preparing joints for adhesive application

- Prepare flanges on body and new parts for bonding and welding.
- Prepare bonding area with silicate stone -DA 009 800 - and clean.
- Apply aluminium primer -DA 009 801 - to bonding surfaces using applicator -D 009 500 25 - .
- Clean new part with silicone remover -LSE 020 100 A3- .
- Apply 2-component body adhesive -DA 180 A00 A2- to wheel housing and entire riveting area using double cartridge gun -VAS 6453- .
- Apply adhesive to beaded flange. Two beads of adhesive: 3.5 mm diameter.
- Place new part on portal gauge.

Welding in new part

- Weld in side panel using shielded arc welding equipment : SG continuous seam.

- Bead over wheel arch flange. Wipe off emerging adhesive and seal joint.

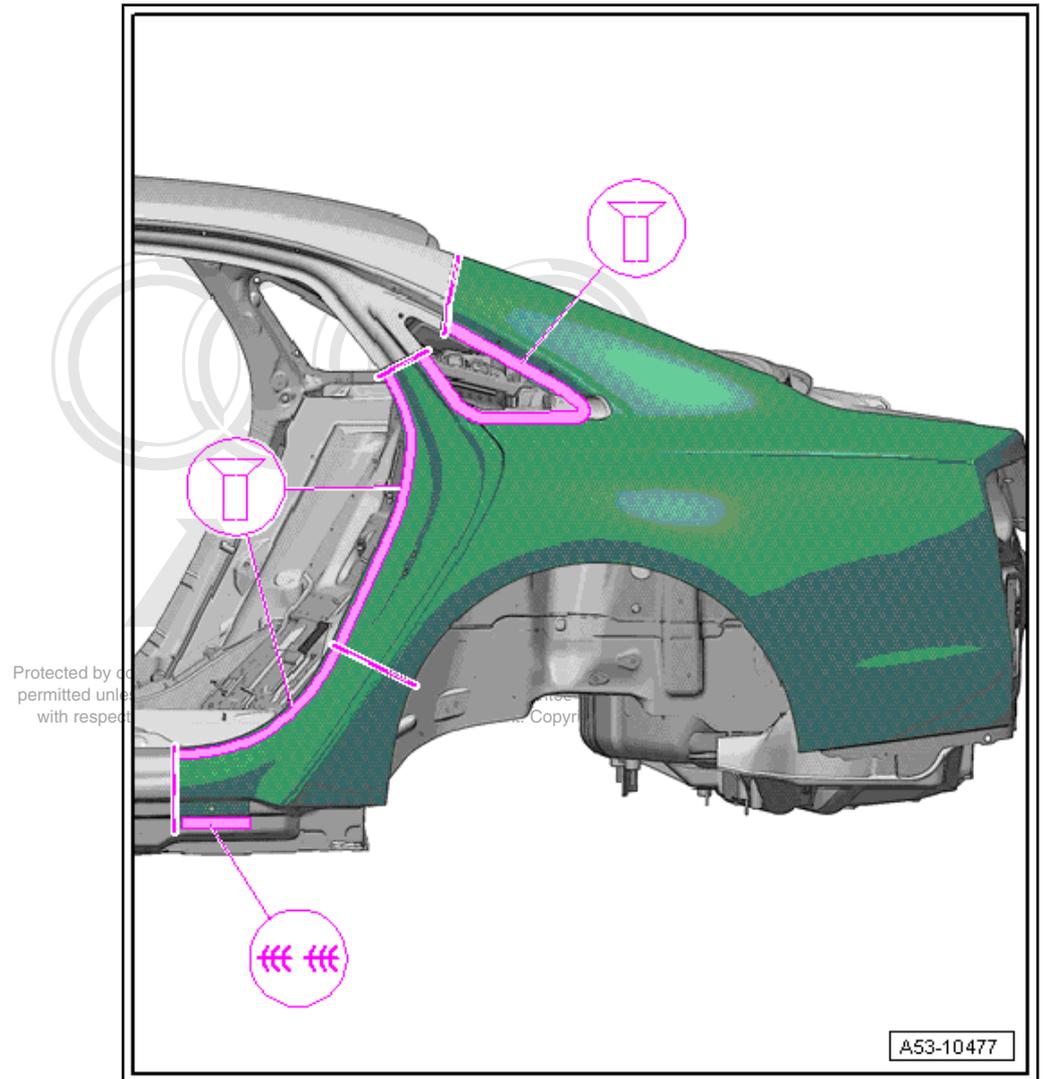


Riveting in

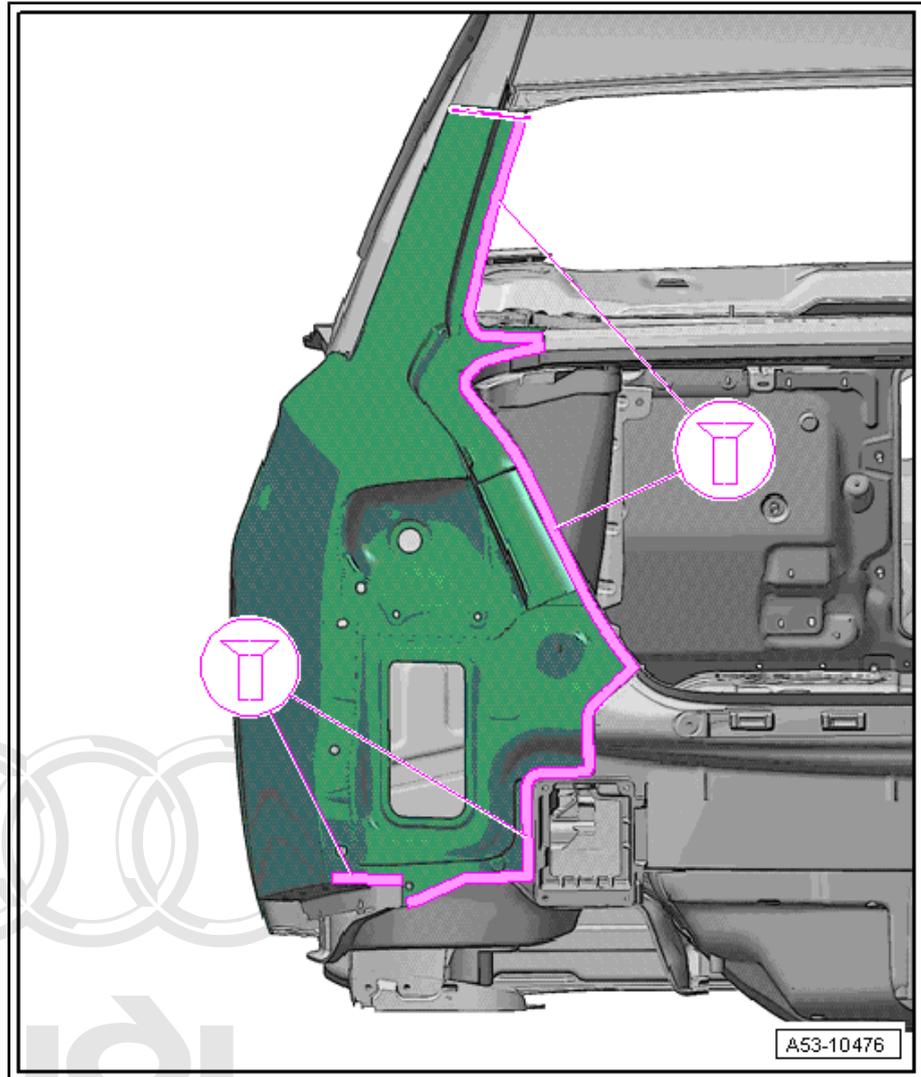
- Rivet in side panel using rechargeable riveter -VAS 5279A- .
- Weld in side panel using shielded arc welding equipment : SG continuous seam (staggered - with gaps).



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- Rivet in side panel to closure plate using rechargeable riveter -VAS 5279A- .
- Rivet in side panel to tail light mounting using rechargeable riveter -VAS 5279A- .
- Rivet in side panel to rain channel using rechargeable riveter -VAS 5279A- .



RO: 53.69.55.52
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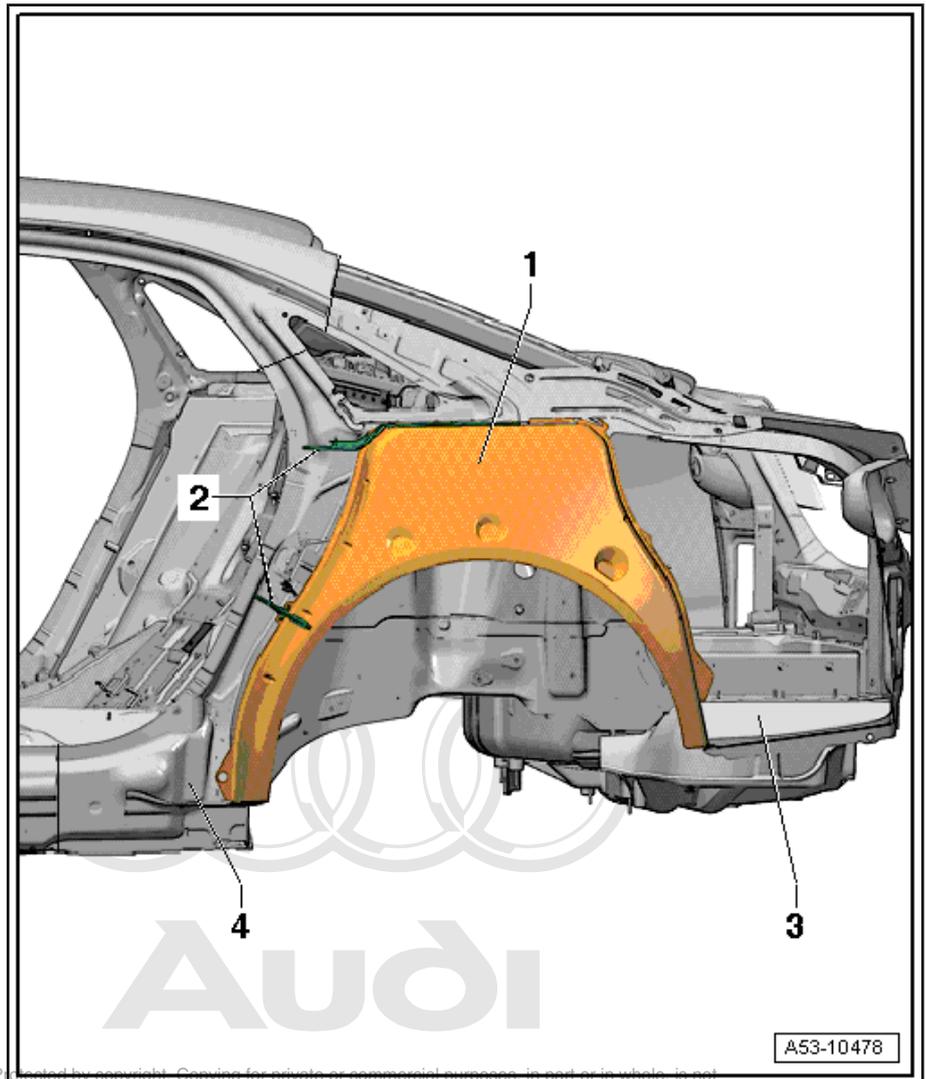
4.3 Rear wheel housing - Renewal



WARNING

Always observe safety precautions.

- 1 - Outer wheel housing
- 2 - Moulded foam inserts
- 3 - Corner panel
- 4 - Lower C-pillar reinforcement

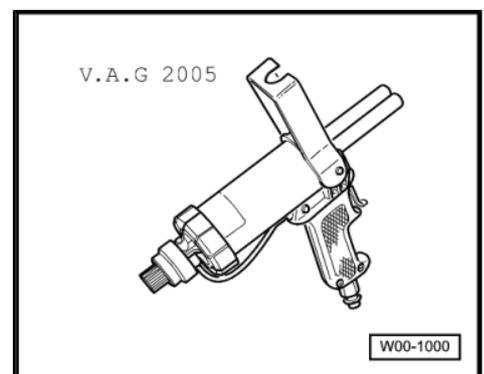


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4.4 Tools

Special tools and workshop equipment required

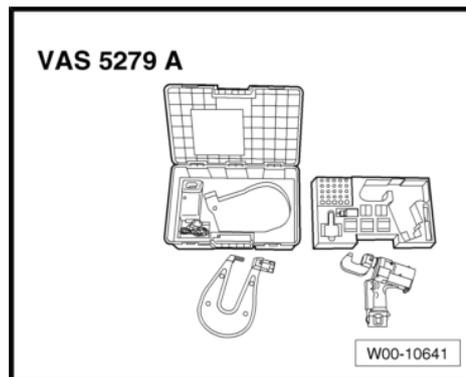
- ◆ Pneumatic glue gun -V.A.G 2005 B-



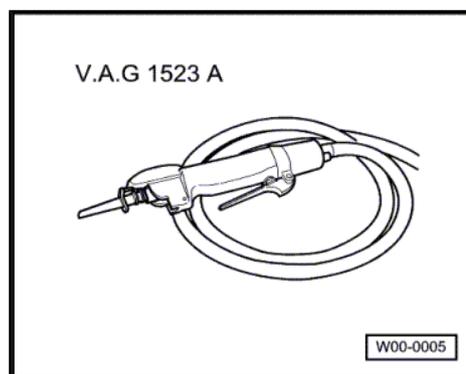
- ◆ Shielded arc welding equipment
- ◆ Rechargeable riveter -VAS 5279A-



- ◆ Alternatively, you can use the new rechargeable riveter -VAS 5279 B- . This is a complete set.



- ◆ Pneumatic sabre saw - V.A.G 1523A-



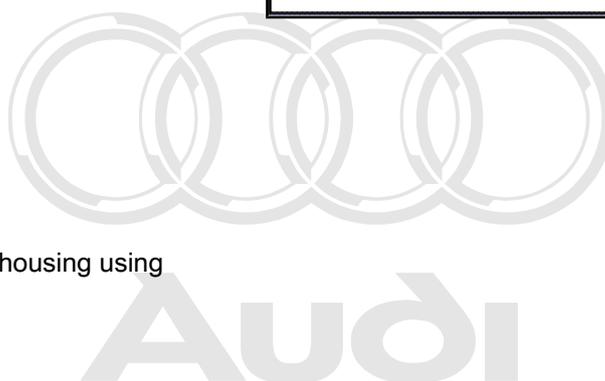
- ◆ Compact angle grinder -VAS 5167-

4.5 Procedure

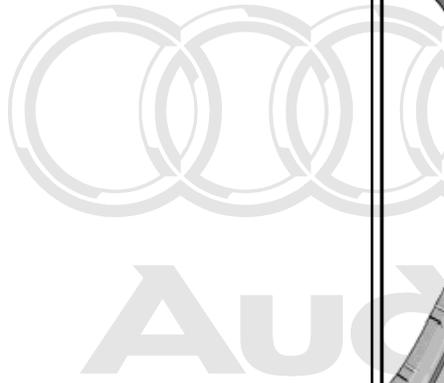
- Side panel already removed

Removing

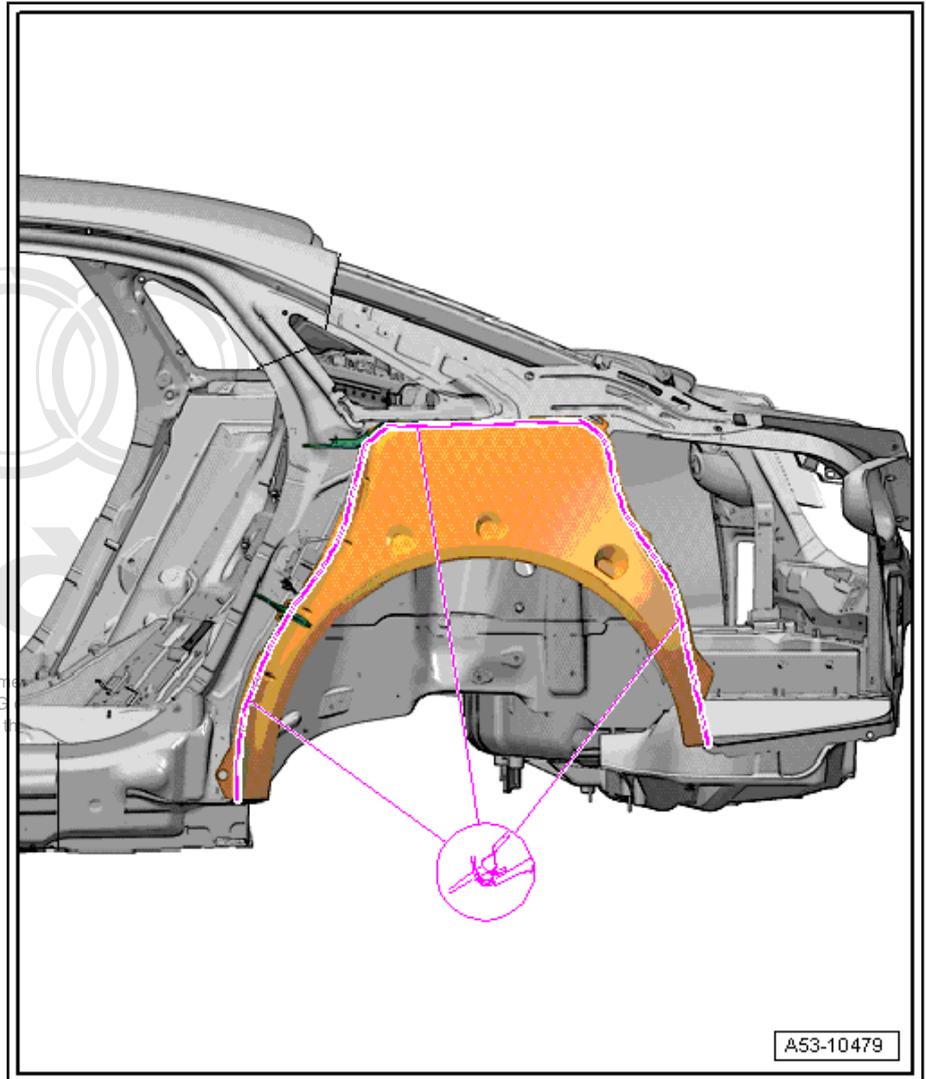
- Make separating cut parallel to inner wheel housing using pneumatic sabre saw - V.A.G 1523A- .



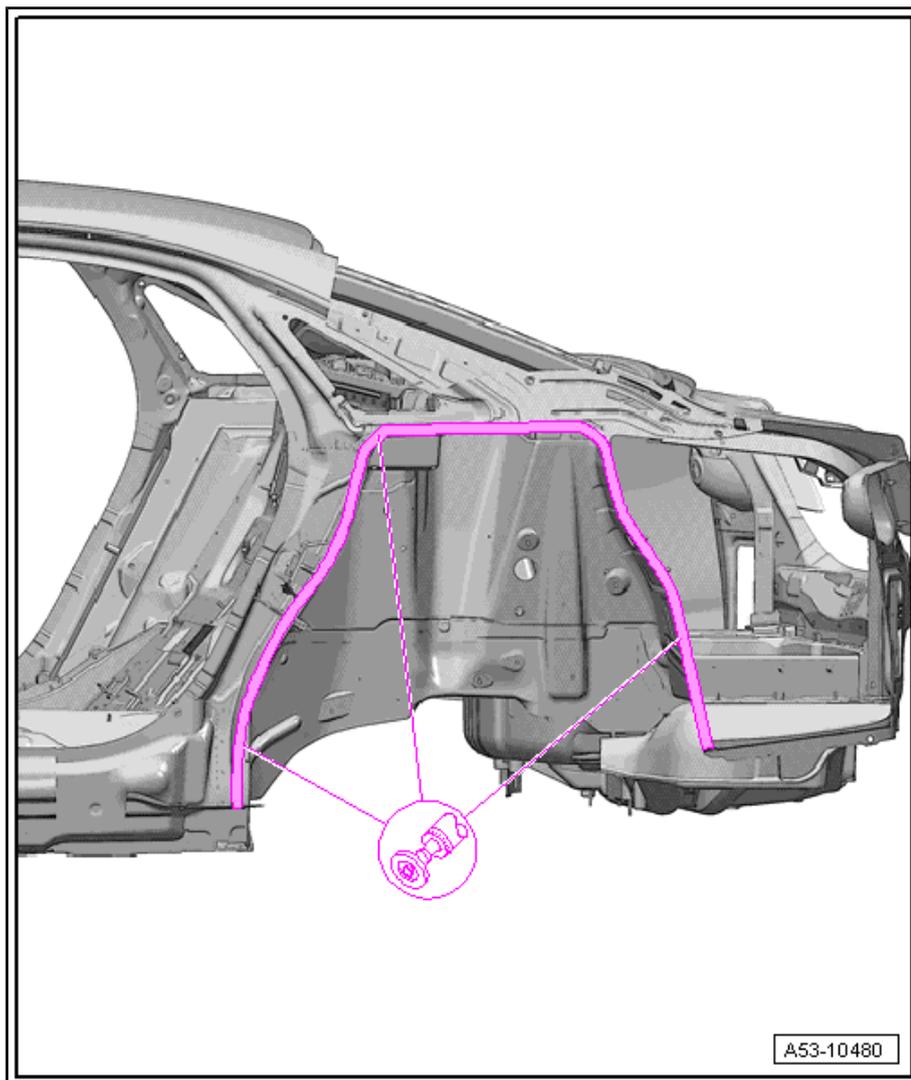
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- Remove remaining material using compact angle grinder - VAS 5167- .
- Press out remaining material using rechargeable riveter -VAS 5279A- .



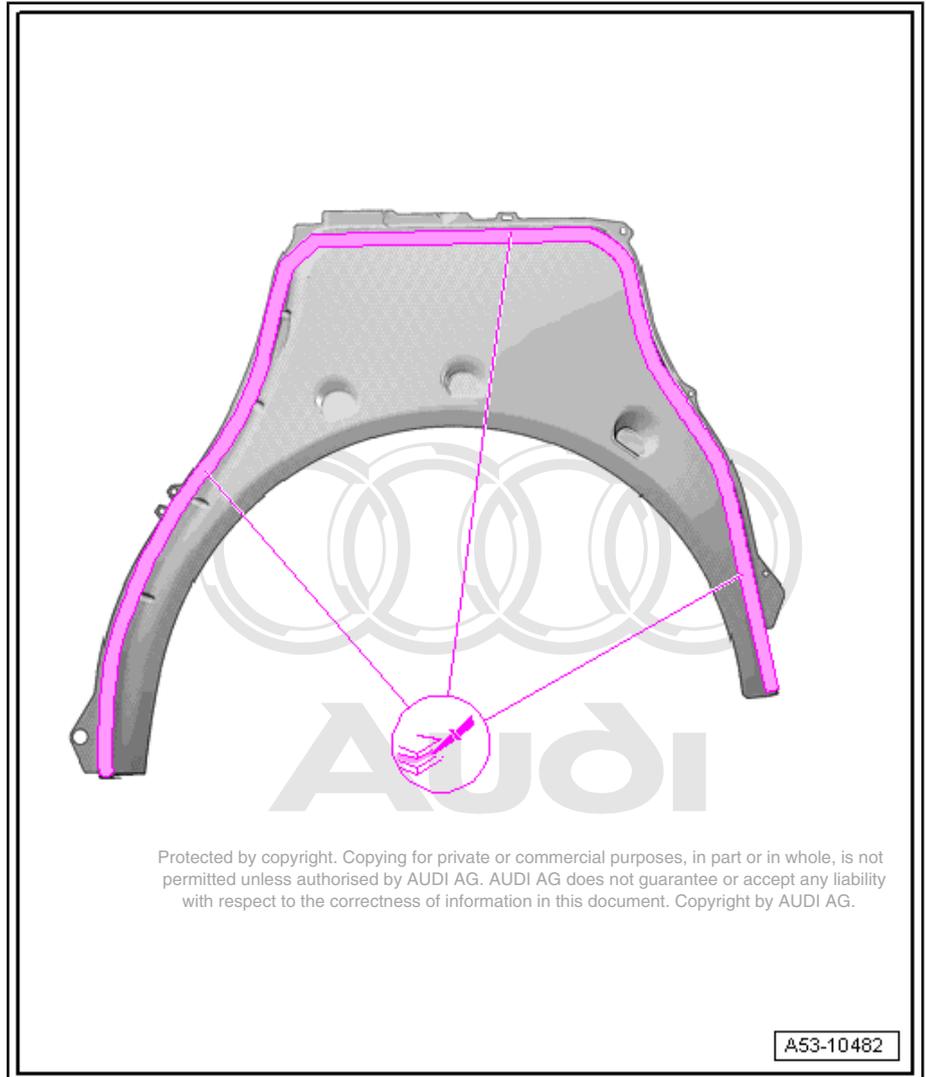
Replacement part

- ◆ Rear outer wheel housing

Preparing joints for adhesive application

- Prepare flanges on body and new parts for bonding and welding.
- Prepare bonding area with silicate stone -DA 009 800 - and clean.
- Apply aluminium primer -DA 009 801 - to bonding surfaces using applicator -D 009 500 25 - .
- Clean new part with silicone remover -LSE 020 100 A3- .
- Apply 2-component body adhesive -DA 0001 730 A2- to wheel housing and entire riveting area using pneumatic glue gun - V.A.G 2005 B- .

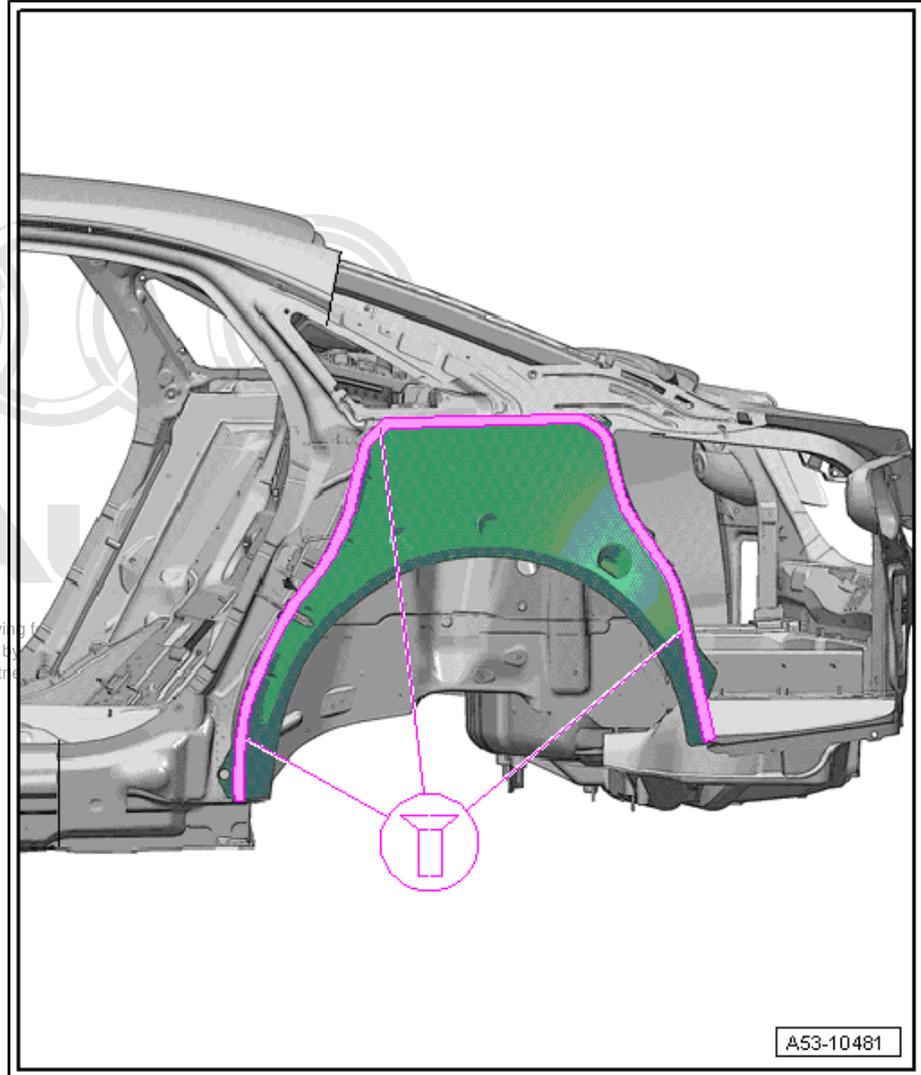
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Installing

- Match up outer wheel housing and fix in position.
- Check fit relative to side panel.
- Rivet in new part using rechargeable riveter -VAS 5279A- .
- Alternatively, joint can also be welded using shielded arc welding equipment : SG continuous seam (staggered - with gaps).

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5 Spare wheel well - Renewal

i Note

The spare wheel well is made of plastic.



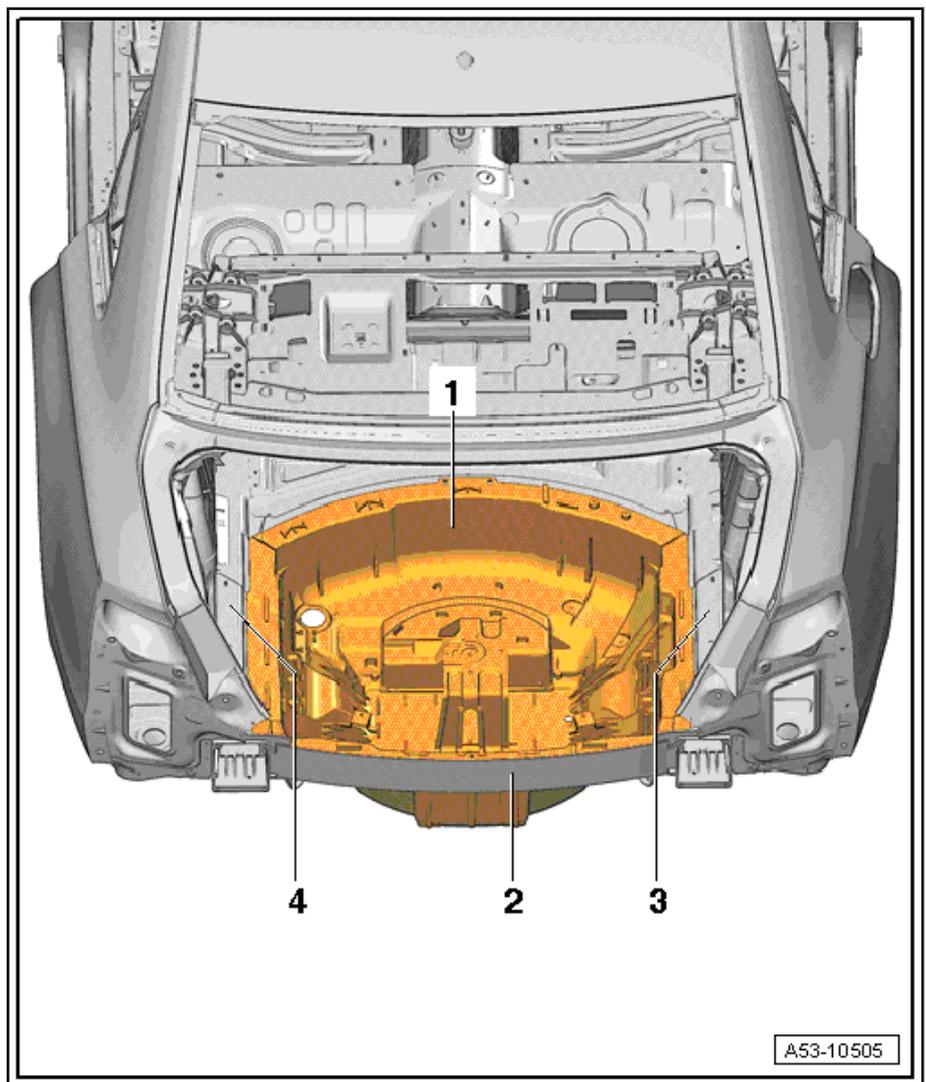
WARNING

Always observe safety precautions.

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The cross panels are removed in the illustration to show the spare wheel well more clearly. These parts do not necessarily have to be removed for the repair.

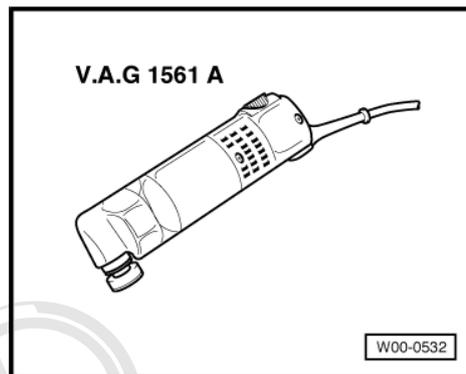
- 1 - Spare wheel well
- 2 - Cross member
- 3 - Longitudinal member (right-side)
- 4 - Longitudinal member (left-side)



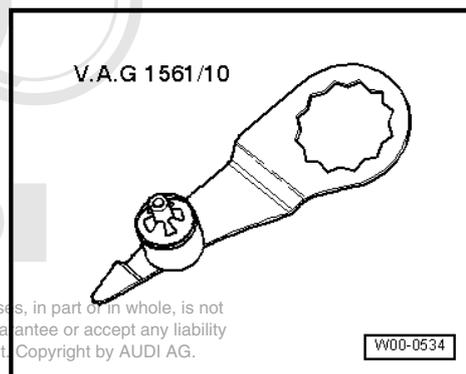
5.1 Tools

Special tools and workshop equipment required

- ◆ Electric cutter -V.A.G 1561 A-

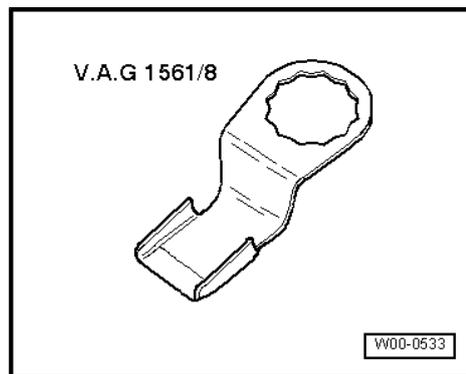


- ◆ Blade, offset -V.A.G 1561/10-



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- ◆ Scraper (15 + 25 mm) -V.A.G 1561/7+8-

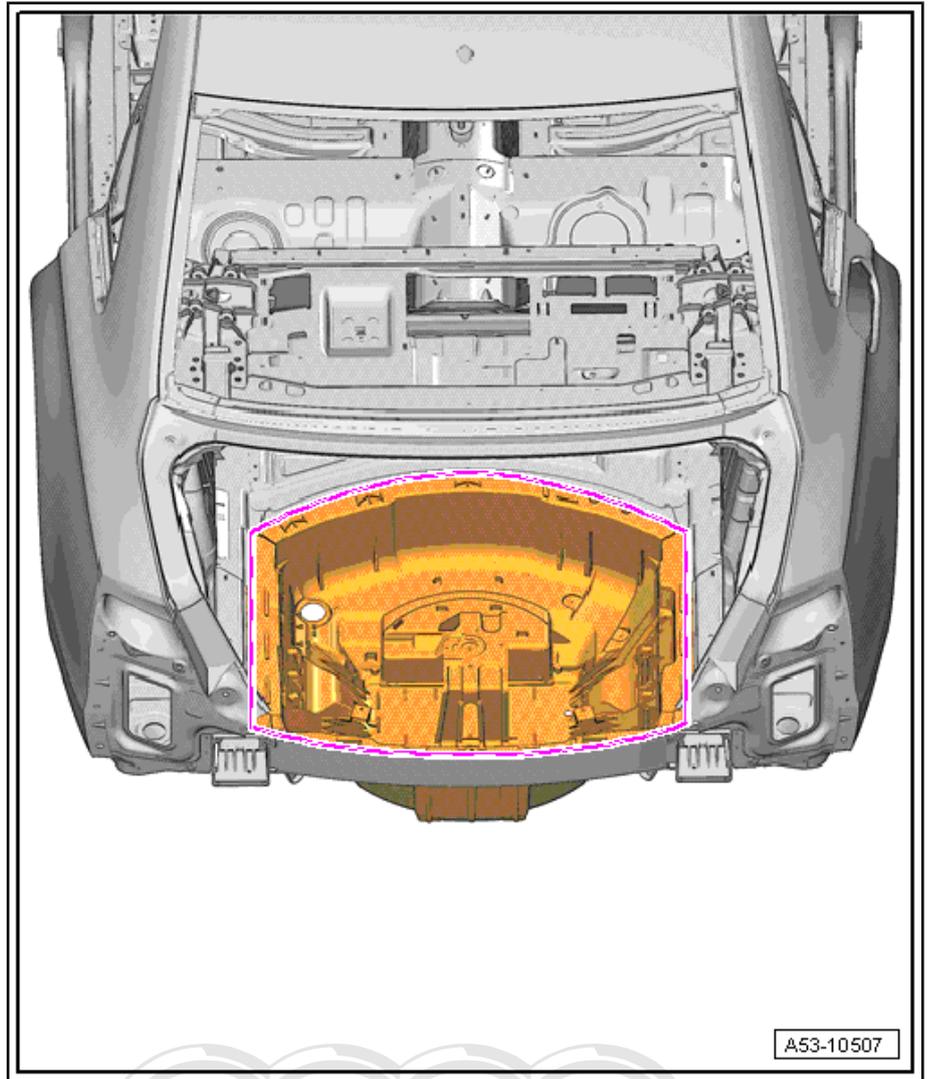


- ◆ Double cartridge gun -VAS 5237-

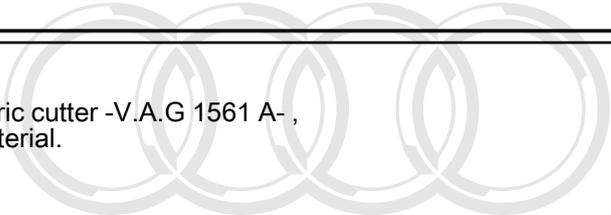
5.2 Procedure

Removing

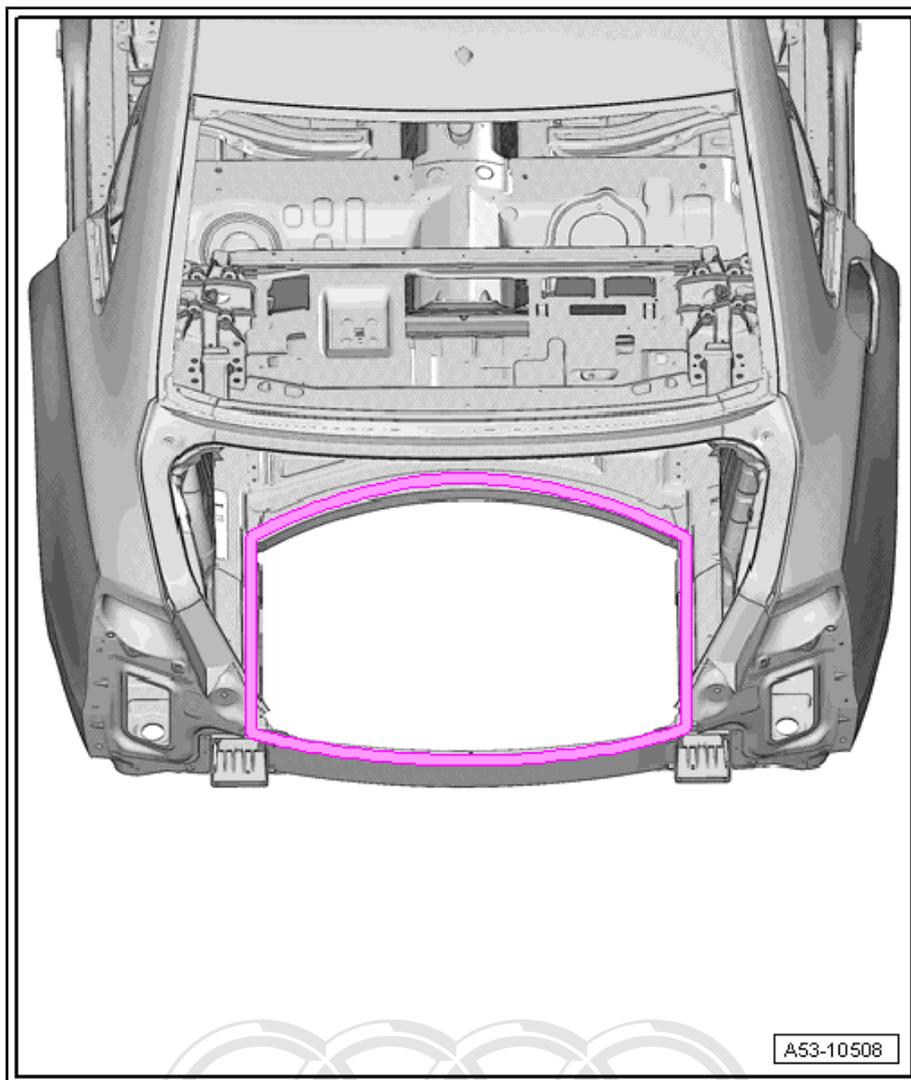
- Cut through adhesive bead all round using electric cutter - V.A.G 1561 A- .



- Cut back adhesive bead using electric cutter -V.A.G 1561 A-, but do not remove all remaining material.


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Replacement parts

- ◆ Spare wheel well
- ◆ 2-component window adhesive set -DA 004 600 A2-
- ◆ Cleaning solution -D 009 401 04- . Observe safety precautions when handling.

Preparing new part

- Clean bonding surface on spare wheel well with cleaning solution -D 009 401 04- .

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Installing



Caution

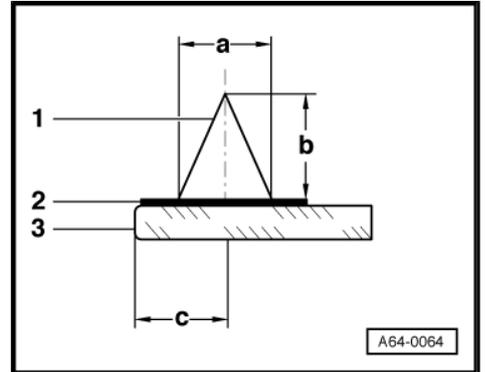
- ◆ *Bonding surface must be free of dirt and grease.*
- ◆ *Do not cut back bonding surface until immediately before installation.*
- ◆ *Do not apply primer to bonding surface or treat with cleaning solution.*

 **Note**

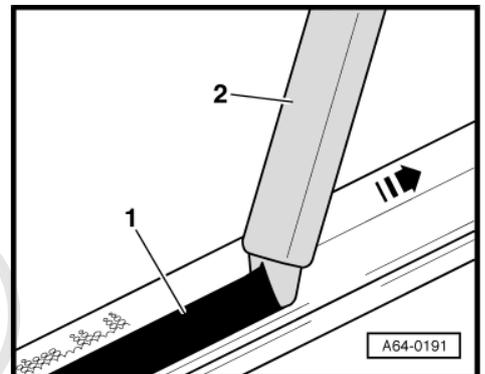
The cross-section of the adhesive bead is determined by the size of the applicator nozzle opening and the rate of application.

Dimensions for adhesive application:

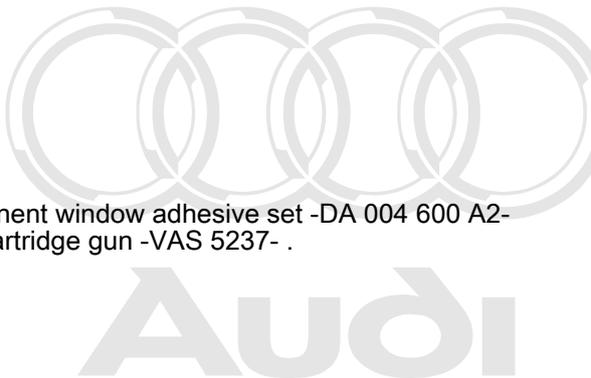
- 1 - Adhesive bead
- 2 - Old adhesive bead
- 3 - Spare wheel well
 - Dimension -a- = 8 mm
 - Dimension -b- = 12 mm
 - Dimension -c-: note variations in spacing from contact surface.



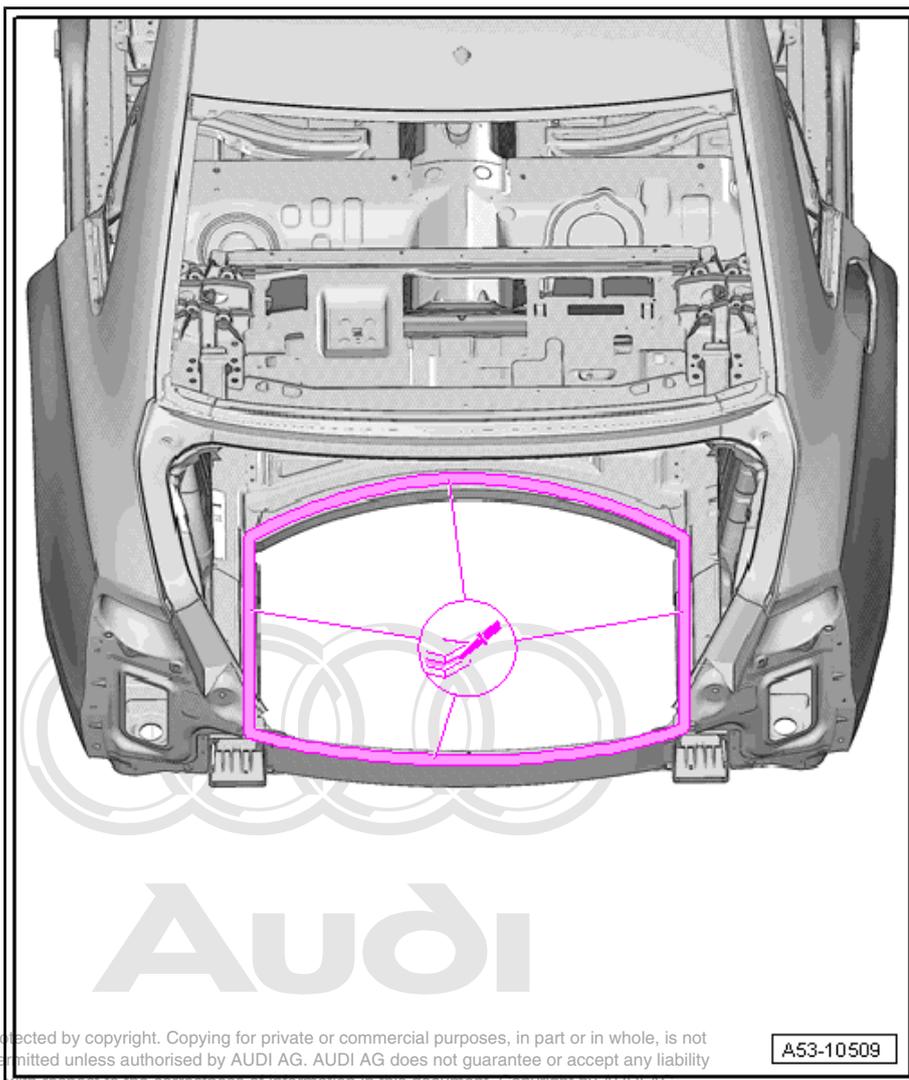
- Apply nozzle -2- so it is in full contact with bonding surface.
- Adhesive bead -1- is applied in direction indicated by -arrow-.
- Apply adhesive/sealant -1- all round bonding surface -2-.



- Apply 2-component window adhesive set -DA 004 600 A2- using double cartridge gun -VAS 5237- .



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Bonding area:

- If the bonding area has been damaged, the paint finish must be repaired and corrosion protection applied as required.



Note

- ◆ *After bonding has been completed, the vehicle must remain stationary on a level surface for 3 hours at room temperature (min. 15 °C) so that the adhesive components can harden (curing time).*
- ◆ *Do not move the vehicle until the „curing time“ has elapsed.*