

Special Tool

Cross spindle

108 589 000 27 00

Removal

- 1 Remove trunk lid (75.1–100).
- 2 Remove cover of top well (75.1–200).
- 3 Remove top (75.1–230).
- 4 Remove cover on box column (68.1–460) and cover base for coupe top.
- 5 Remove pertinent lining in rear of vehicle (68.1–450).
- 6 Remove closing eye (72.1-260).
- 7 Remove trimstrip on entrance (68.1–512).
- 8 Remove fuel tank (47.1–020).
- 9 Remove pertinent tail lamp.
- 10 Remove rear bumper (88.1–220).
- 11 Remove sealing frame for trunk lid and top well cover in range of deformed fender.
- 12 Remove pertinent cover strip under driver's door.
- 13 Loosen rubber lining on entrance in connection range of fender.
- 14 Jack-up vehicle, remove rear wheel.
- 15 Separate damaged fender from body.

Note: The fender can be separated by means of an abrasive cutting-off machine or by means of a sharp chisel, taking care that the hinged bearing of the trunk lid under the connection of the top rear center piece and the fender is not damaged.

16 Cut welding spots on flanges with a grinder and pull off with pliers or cutoff with chisel.

17 Align joints and make bright (Fig. 1).

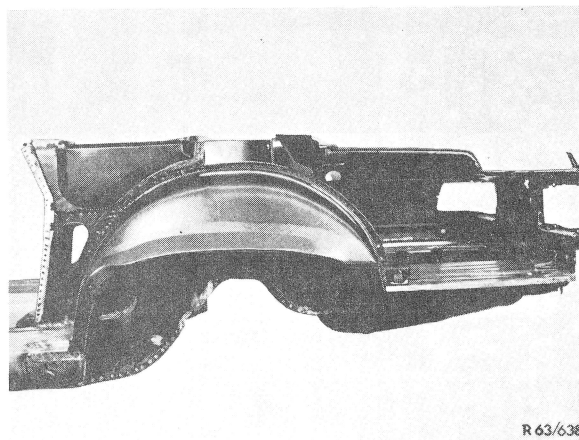


Fig. 1

Installation

- 18 Grind rear fender bright on joints.
- 19 Fit rear fender.
- 20 Coat brightly ground joints on body and fender with zinc dust paint, Part No. 000 986 34 42.
- 21 Attach rear fender to spot weld flanges with hand clamps or polygrip pliers and tack with sheet metal screws.
- 22 Mount trunk lid and top well cover.

63.1 Replacement of Rear Fender

23 Check correct seat of fender (1) by opening and closing doors, trunk lid and top well cover, and align by inserting cross spindle (2) (Fig. 2).

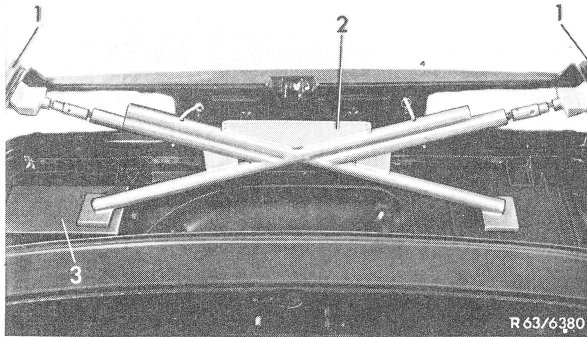


Fig. 2

- 1 Rear fender
- 2 Cross spindle 108 589 00 27 00
- 3 Supplementary plate

Note: The supplementary plate (3) is self-made according to Fig. 3.

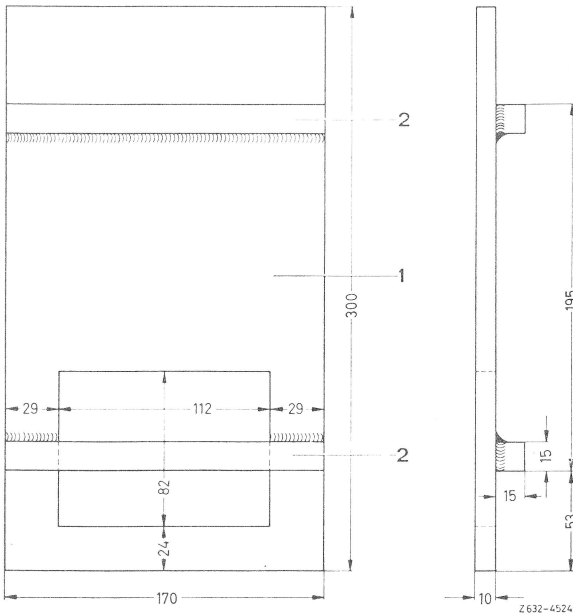


Fig. 3

- 1 Flat iron 300 x 170 x 10
- 2 Supporting strips 15 x 15 x 170

24 Spot weld rear fender (1) to box column (4) (Fig. 4 and 5).

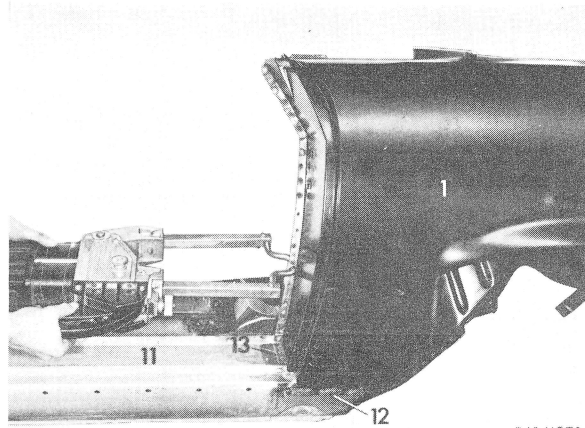


Fig. 4

- 1 Rear fender
- 11 Side member
- 12 String weld
- 13 Flange

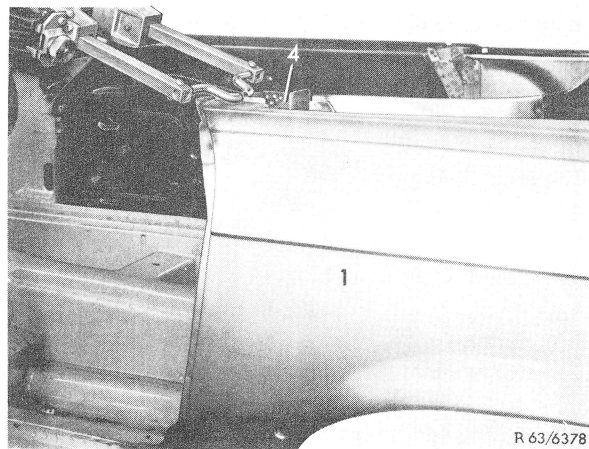


Fig. 5

- 1 Rear fender
- 4 Box column

25 Remove trunk lid and top well cover once again.

26 Spotweld rear fender (1) to side wall (5) of top well (6) (Fig. 6).

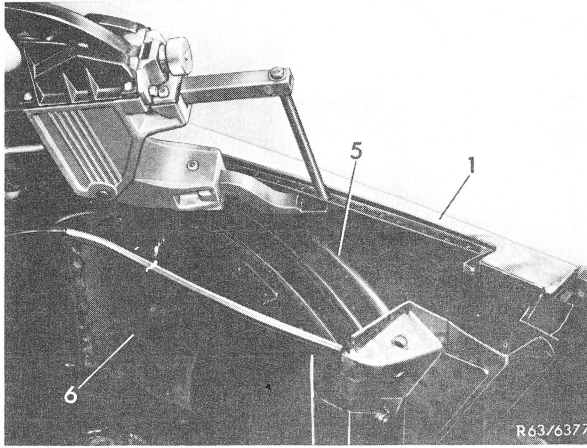


Fig. 6
 1 Rear fender
 5 Side wall
 6 Top well

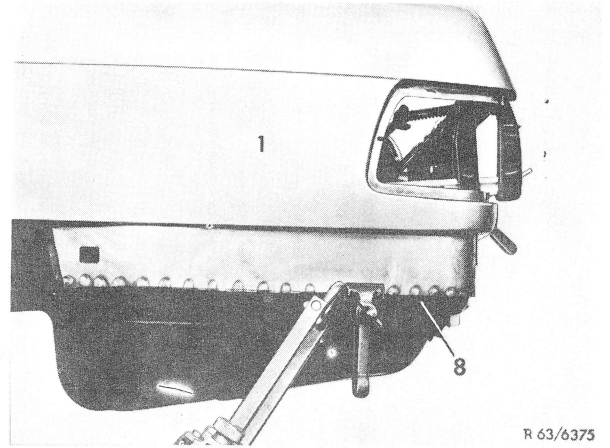


Fig. 8
 1 Rear fender
 8 Rear floor

27 Spot weld rear fender (1) to wheel housing (7) (Fig. 7).

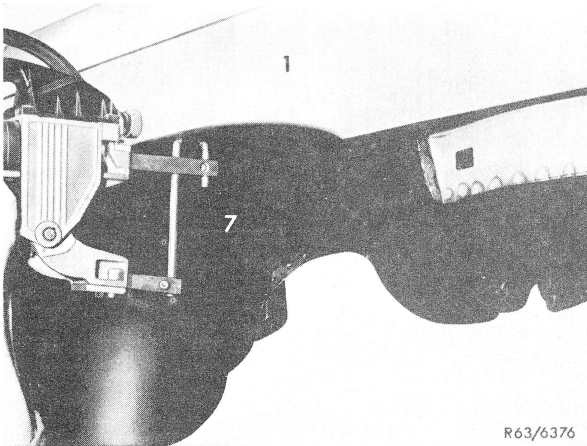


Fig. 7
 1 Rear fender
 7 Wheel housing

29 Weld rear fender (1) to rear center piece top (9) (Fig. 9).

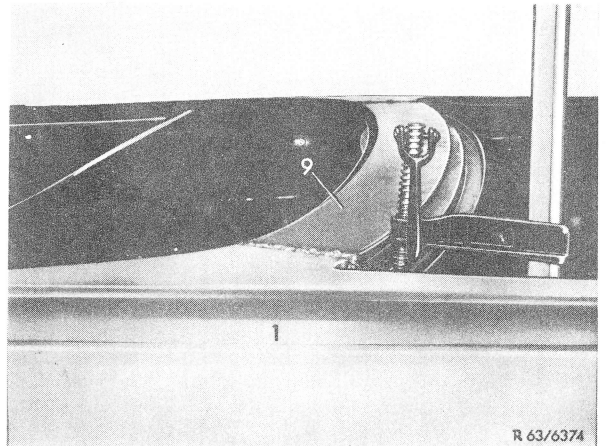


Fig. 9
 1 Rear fender
 9 Rear center piece top

28 Spot weld rear fender (1) to rear floor (8) (Fig. 8).

30 Spot weld rear fender (1) to rear center piece bottom (10) in range of tail lamp (Fig. 10 and 11).

63.1 Replacement of Rear Fender

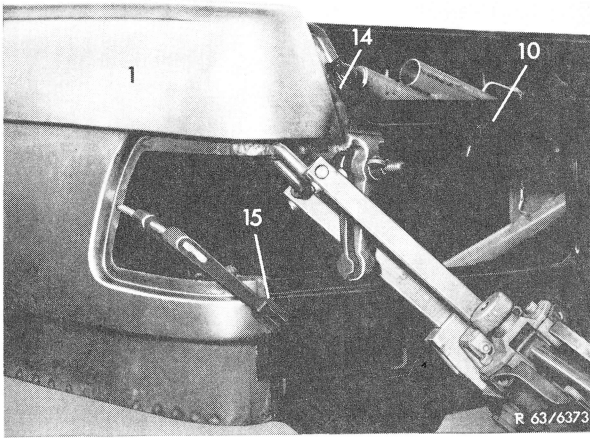


Fig. 10

1 Rear fender
10 Rear center piece bottom
14 Rabet
15 Joint

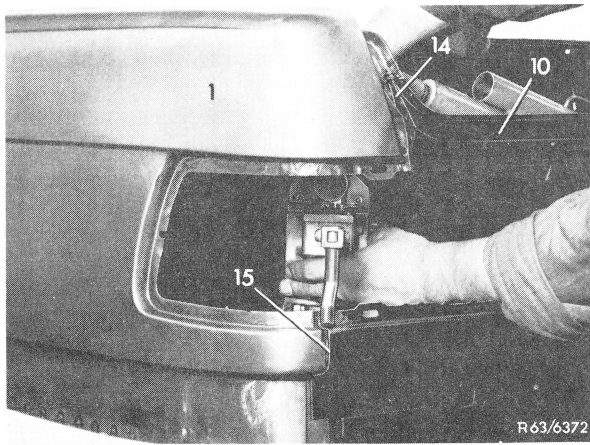


Fig. 11

1 Rear fender
10 Rear center piece bottom
14 Rabet
15 Joint

31 Fit tail lamp.

32 Connect rear fender (1) to side member (11) by string welding (12) (Fig. 4).

33 Connect flange (13) to side member (11) by plug welding (Fig. 4).

34 Braze rear fender at the following joints:

- a) Side member (11) on entrance (Fig. 4),
- b) rear center piece bottom (10) on rabet (14) for trunk lid rubber and to joint (15) below tail lamp (Fig. 10 and 11).

35 Caulk weld points on center piece top as well as brazed areas on rear center piece bottom with tin and trim.

36 Caulk weld seams in trunk (96.1–200).

37 Degrease rear fender, prime and paint.

38 Reinstall removed parts.