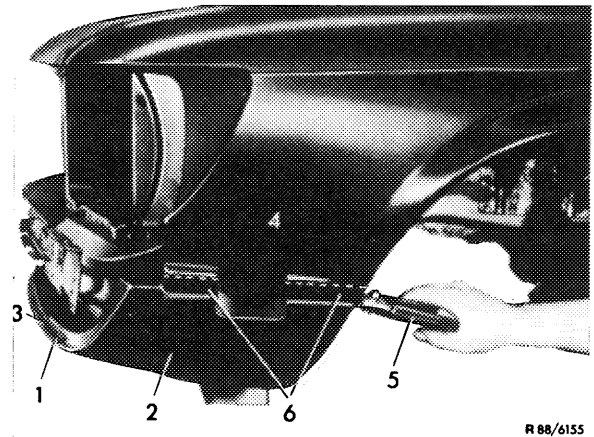


Removal

- 1 Jack-up vehicle.
- 2 Remove pertinent front wheel.
- 3 Remove bumper with holding bracket.
- 4 Remove air grille under bumper front.
- 5 Unscrew molding under lighting unit.
- 6 Loosen screw connection (1) of fender bottom (2) and molding (3) between front fender (4) front center.
- 7 Cut fender bottom (2) from fender (4) with shears (5).
- 8 Cut remaining section of spot weld flange (6) from inside of fender with grinding wheel and pull off.
- 9 Align spot weld flange and make bright.



Installation

- 10 Grind spot weld flange on fender bottom (2) bright.
- 11 Coat spot weld flanges with zinc dust paint, Part No. 000 986 34 42.
- 12 Fit fender bottom (2) to fender (4) and clamp with hand vise (7).
- 13 Screw fender bottom (2) with molding (3) between front fender front center.
- 14 Weld fender (4) and fender bottom (2) by means of spot welder (8).
- 15 Align spot welds and grind off spatter, if any.
- 16 Prime machined spots and paint.
- 17 Reinstall all removed parts.

