

Special Tools

Adjusting angle set ENS 121 for Celette adjusting bench

Adjusting angle set ENS 166 for Celette adjusting bench

Cross spindle

108 589 00 27 00

Note

During the repairs described below the following components are replaced:

Rear floor complete
Both wheel housings
Both rear fenders
Top well
Lower rear center piece
(Fig. 1).

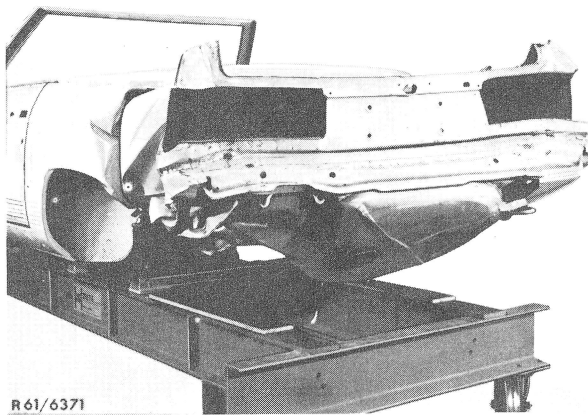


Fig. 1

Removal

- 1 Remove chassis units front and rear.
- 2 Expose interior of vehicle in range of rear end.
- 3 Place vehicle on adjusting bench.
- 4 Remove rear end (Fig. 2).
- 5 Align connections on body and make bright.

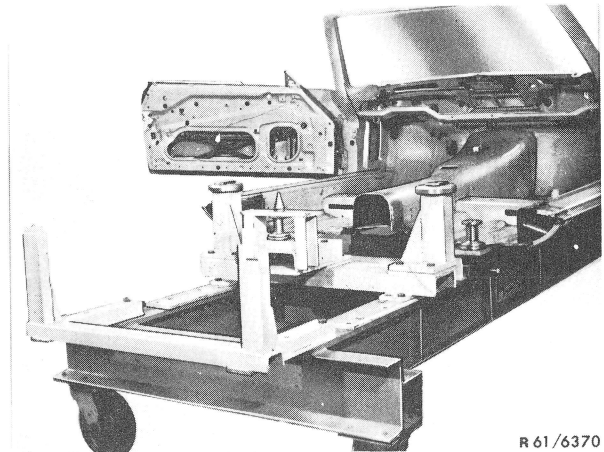


Fig. 2

Installation

- 6 Grind connections of rear floor bright.
- 7 Fit rear floor.

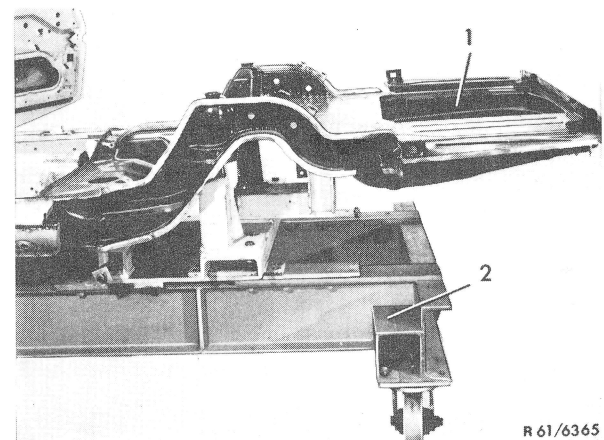


Fig. 3

1 Rear floor

2 Adjusting bench

61.1 Replacement of Complete Rear Floor

8 Coat spot weld flanges with zinc dust paint Part No. 000 986 34 42.

9 Place rear floor (1) on adjusting bench (2) and tack weld (Fig. 3).

Note: Raise body at the rear to mount rear end. After mounting rear end (1) attach rear end and body to adjusting bench (2).

10 Spot weld rear floor (1) to side member (3) and bead weld (4), (Fig. 4).

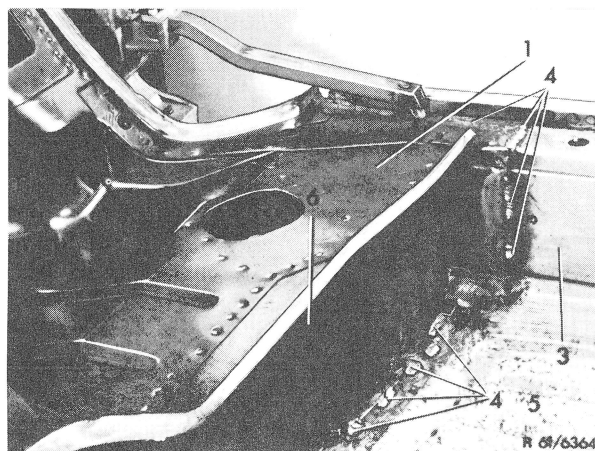


Fig. 4

- | | |
|---------------|----------------------------|
| 1 Rear floor | 5 Floor plate |
| 3 Side member | 6 Cross member outer shell |
| 4 Bead weld | |

11 Connect cross member outer shell (6) to floor plate (5) by means of bead welds (4) (Fig. 4).

12 Weld cross member outer shell (6) from under-side of vehicle to tunnel.

13 Coat inside of cross member outer shell and cross member inner shell with zinc dust paint Part No. 000 986 34 42.

14 Spot weld cross member inner shell (7) to cross member outer shell (Fig. 5).

15 Bead weld (4) floor plate (5) and cross member inner shell (7).

16 Connect tunnel (8) to cross member inner shell (7) by means of continuous weld (9) (Fig. 5).

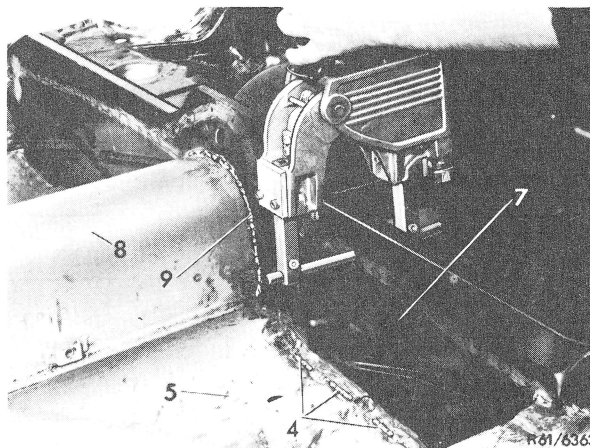


Fig. 5

- | | |
|----------------------------|----------------|
| 4 Bead weld | 8 Tunnel |
| 5 Floor plate | 9 Welding seam |
| 7 Cross member inner shell | |

17 Weld-on supporting bearing (61.1-435).

18 Insert wheel housings and top well and attach with sheet metal screws.

19 Tack rear fender and rear center piece with sheet metal screws and check respective air gap by inserting doors, trunk lid and top well cover.

20 Remove screwed-on parts.

21 Connect wheel housing (10) with side member (11) by bead welds (4) (Fig. 6).

22 Spot weld wheel housing (10) to side member (11) and plug weld through holes (12) drilled into wheel housing (Fig. 7).

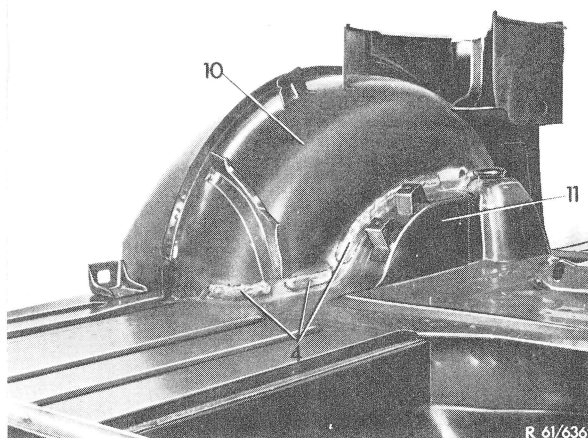


Fig. 6

- | | | |
|--------------|------------------|----------------|
| 4 Bead welds | 10 Wheel housing | 11 Side member |
|--------------|------------------|----------------|

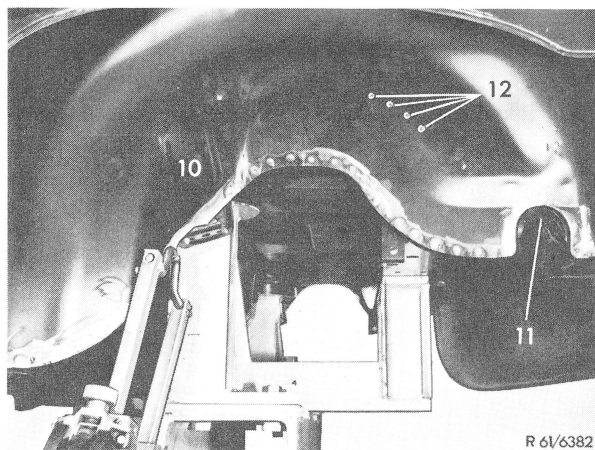


Fig. 7

10 Wheel housing
11 Side member

12 Holes

23 Weld wheel housing (10) to side member (3) and cross member inner shell (7) (Fig. 8).

24 Install assembly of top well and rear wall.

25 Spot weld rear wall (13) to shock absorber bracket (14) (Fig. 9).

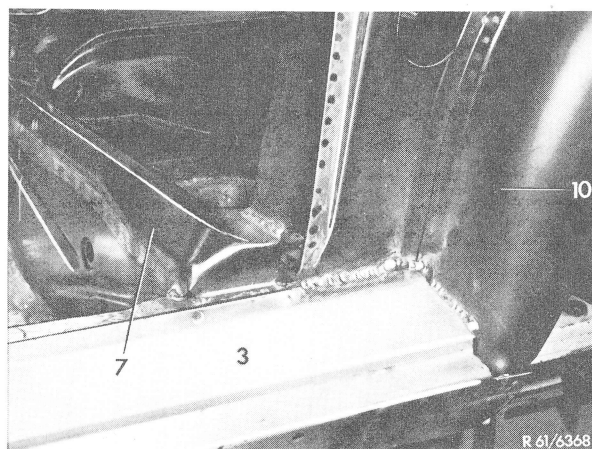


Fig. 8

3 Side member
7 Cross member inner shell
10 Wheel housing

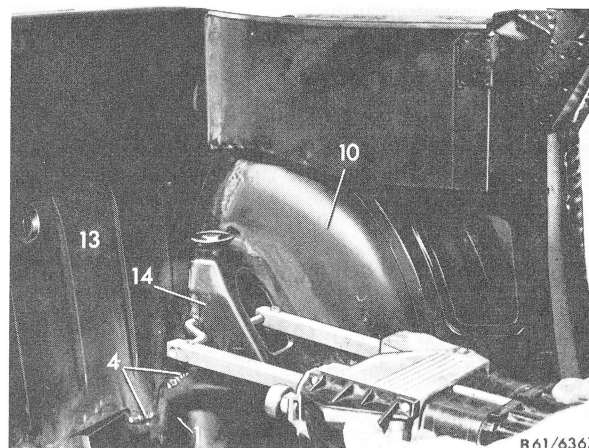


Fig. 9

13 Rear wall
14 Shock absorber bracket

26 Connect rear wall (13) to rear floor (1) by bead welding (4) (Fig. 9).

27 Bead weld rear wall (13) in range of wheel housing (10).

28 Spot weld rear wall (13) to top well side member (15) (Fig. 10).

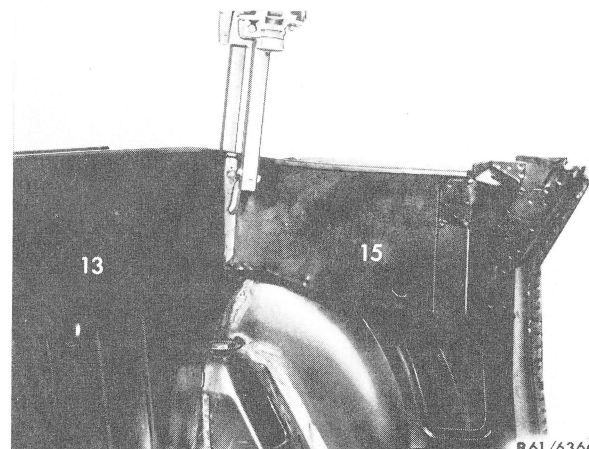


Fig. 10

13 Rear wall
15 Top well side member

29 Weld-in stiffening struts for top well.

30 Weld hinge plate with welding nut for safety belt to box post.

31 Tack rear fender and rear center piece at bottom and adjust trunk lid clearance by means of cross spindle Part No. 108 589 00 27 00.

61.1 Replacement of Complete Rear Floor

32 Weld-in rear fender (63.1—300).

33 Weld-in rear center piece at bottom.

Note: The cross spindle must remain in place until the welding is completed, so that the trunk lid clearance cannot change.

34 Weld-in hinged bearing for trunk lid (64.1—370).

35 Caulk weld and clean welding beads on outer skin.

36 Seal rear end and apply permanent underfloor protection (96.1—200).

37 Paint rear end and apply wax preservation agent.

38 Insert closing washers or rubber plugs in rear floor (60.1—100).

39 Reinstall removed parts.