

**Special Tools**

Straightening angle set ENS 121 for Celette adjusting bench

Straightening angle set ENS 166 for Celette adjusting bench

Profile blocks	107 589 01 61 00
Number punch guide	107 589 01 63 00
Star punch	107 589 02 63 00

**Removal**

- 1 Remove all parts attached to front end, such as front fender, engine hood, bumper, radiator, battery, cable assembly, lines etc.
- 2 Remove front axle, engine and steering members.
- 3 Remove fuel tank.
- 4 Remove instrument panel.
- 5 Remove windshield.
- 6 Expose vehicle interior in range of front wall.
- 7 Mount vehicle with rear axle installed on Celette straightening bench and screw down.
- 8 Separate front end with front wall and outer

center piece under windshield from body (Fig. 1).

**Note:** Separation can be made by means of a chisel or a cutting-off grinder.

- 9 Cut any remaining spot welded flanges with grinder and pull off.

- 10 Straighten all interfaces and grind bright.

**Installation**

- 11 Grind all interfaces on new front wall bright.
- 12 Coat spot-welded flanges on body and front wall with zinc dust paint, Part No. 000 986 34 42.
- 13 Fit front wall (1) and tack with sheet metal screws (Fig. 2).
- 14 Mount jacket tube and check correct seat of front wall.
- 15 Fit outside center piece under windshield (2) and attach with hand vice (3) or polygrip pliers (4) (Fig. 2)
- 16 Fit windshield with assistance of profile blocks (5).
- 17 Tack outside center piece under windshield with sheet metal screws.

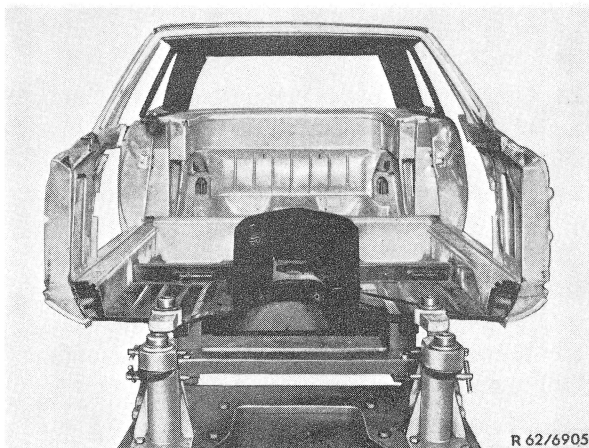


Figure 1

# 62.1 Replacement of Reinforced Front Wall

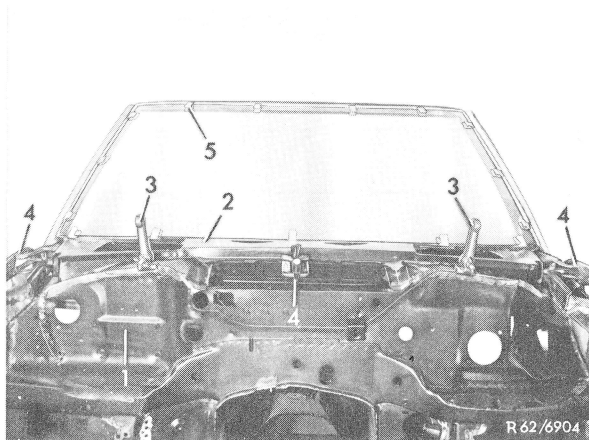


Figure 2

- |   |                   |
|---|-------------------|
| 1 Front wall                            | 3 Hand vice       |
| 2 Outside center piece under windshield | 4 Polygrip pliers |
|   | 5 Profile blocks  |

**18** Tack-weld front wall reinforcement (6) to connection sheet (7) and weld on (Fig. 3).

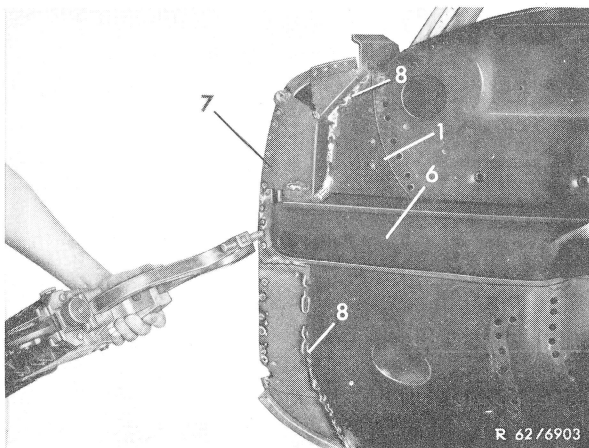


Figure 3

- |                            |               |
|----------------------------|---------------|
| 3 Front wall reinforcement | 8 String weld |
| 7 Connection sheet         |               |

**19** Weld front wall (1) to connection sheet (7) by stringwelding (8).

**20** Spotweld front wall (1) to tunnel (9).

**Note:** In range of front wall reinforcement (6), tunnel (9) must be connected by stringwelding (8) (Fig. 4).

**21** Connect front wall (1) to front wall pillar inner sheet (10) by spotwelding starting from inside vehicle (Fig. 5).

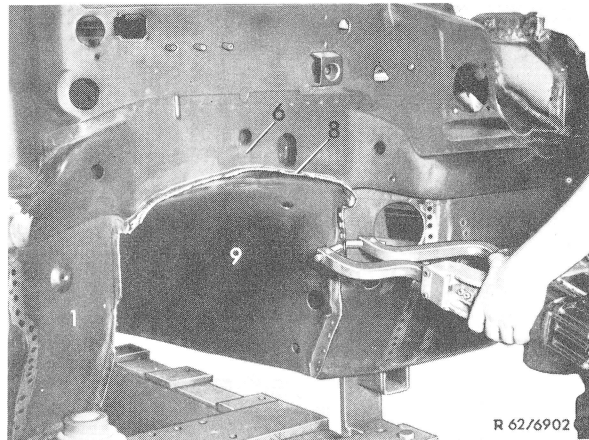


Figure 4

- |                            |               |
|----------------------------|---------------|
| 1 Front wall               | 8 String weld |
| 6 Front wall reinforcement | 9 Tunnel      |

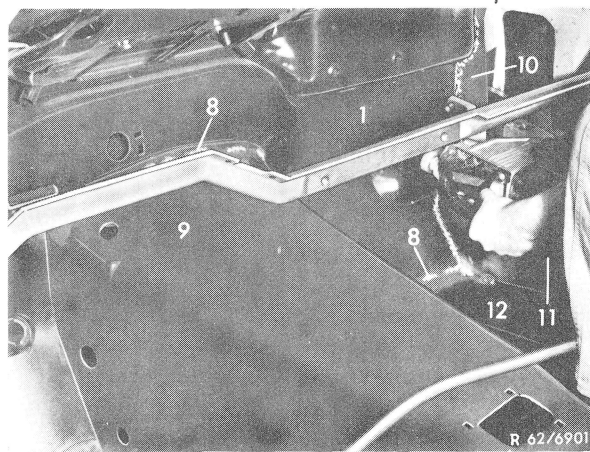


Figure 5

- |                                  |                |
|----------------------------------|----------------|
| 1 Front wall                     | 11 Side member |
| 9 Tunnel                         | 12 Floor plate |
| 10 Front wall pillar inner panel |                |

**22** Weld side member (11) to front wall (1).

**23** Connect floor plate (12) to front wall (1) and tunnel (9) to front wall by stringwelding.

**24** Remove outer center piece under windshield.

**25** Spotweld center piece under windshield inside (13) to front wall pillar (14) (Fig. 6).

**26** Spotweld center piece under windshield inside (13) to connection sheet (7) (Fig. 7).

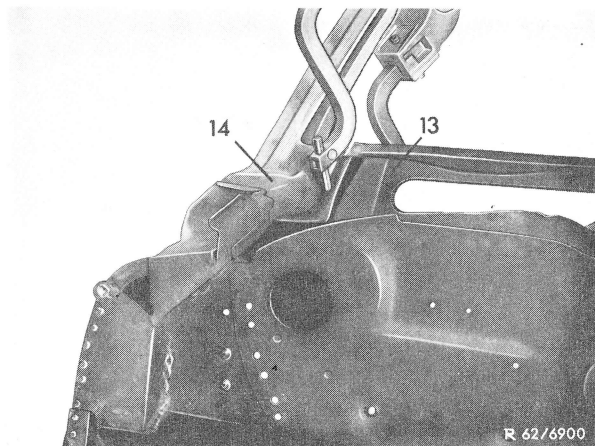


Figure 6

- 13 Center piece under windshield inside
- 14 Front wall pillar

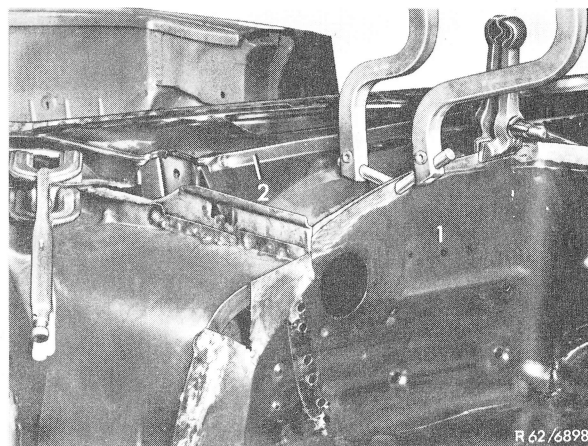


Figure 8

- 1 Front wall
- 2 Center piece outside under windshield

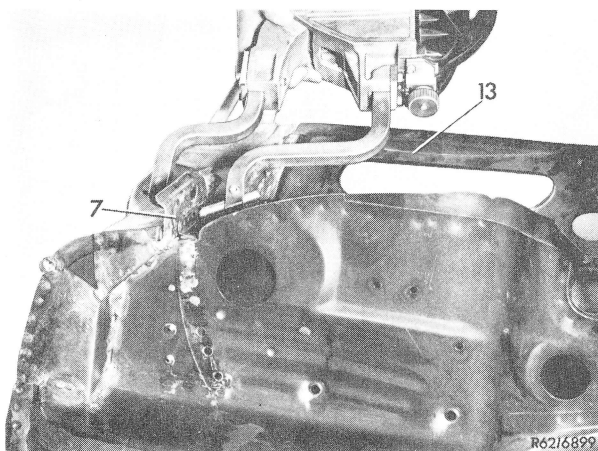


Figure 7

- 7 Connection sheet
- 13 Center piece under windshield inside

**30** Spotweld center piece outside under windshield and connection sheet (7) and weld (Fig. 9).

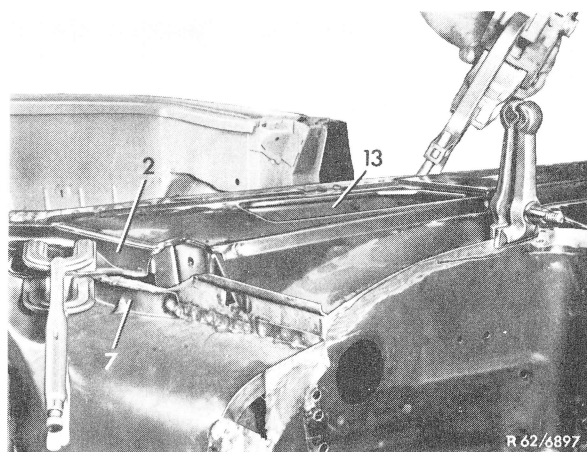


Figure 9

- 2 Center piece outside under windshield
- 7 Connection sheet
- 13 Center piece under windshield inside

**27** Seal welding seams of center piece under windshield inside with Terokal Union cement 412, Part No. 000 989 10 71.

**28** Insert center piece outside under windshield.

**29** Spotweld front wall (1) and center piece outside under windshield (2) (Fig. 8).

**31** Spotweld center piece under windshield inside (13) and center piece outside under windshield (2) together in range of windshield aperture.

**32** Coat all welding seams with zinc dust paint, Part No. 000 986 34 42.

**33** Attach front end by welding (62.1–100).