

Special Tool

Crosshead spindle

108 589 00 27 00

Note

The rear center piece can be replaced only in part, if the deformation does not involve the joints of the rear fender. If so, the rear center piece must be completely replaced.

If the lower rear center piece is replaced only in part, the fenders need not be painted.

Removal

- 1 Empty trunk compartment.
- 2 Remove fuel tank.
- 3 Remove rear lights.
- 4 Remove sealing frame for rear lid in range of lower rear center piece.
- 5 Remove rear bumper.
- 6 Separate rear center piece with hand saw as shown in Fig. 1.
- 7 Straighten joints and grind bright.

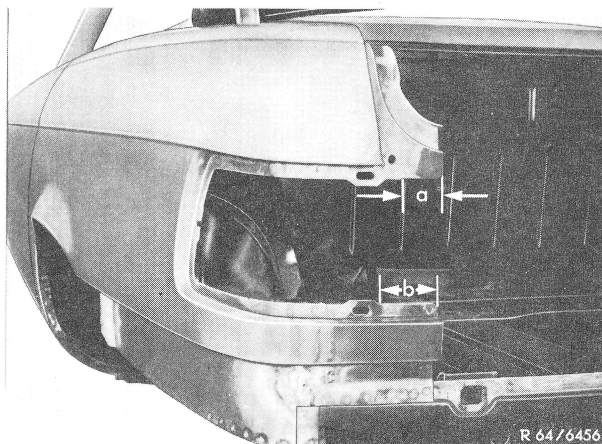


Figure 1

a = 55 mm

b = 55 mm

Installation

- 8 Cut lower rear center piece to size and fit.
- 9 Grind joints on lower rear center piece bright.
- 10 Coat spot weld flange on rear floor and on rear center piece with zinc dust paint, Part No. 000 986 34 42.
- 11 Insert lower rear center piece (2) and attach with hand vices or screw clamp (Fig. 2).

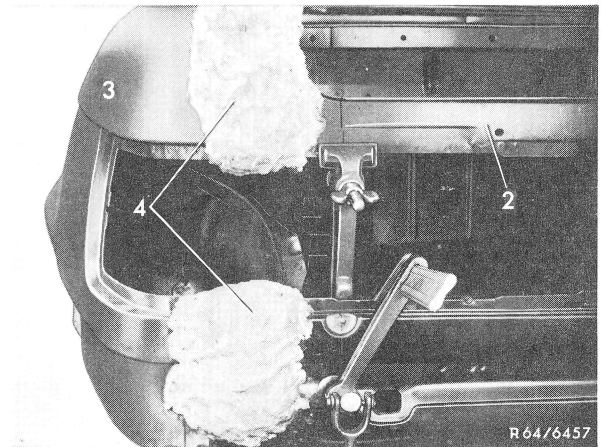


Figure 2

- | | |
|---------------------------|------------|
| 2 Lower rear center piece | 4 Asbestos |
| 3 Rear fender | |

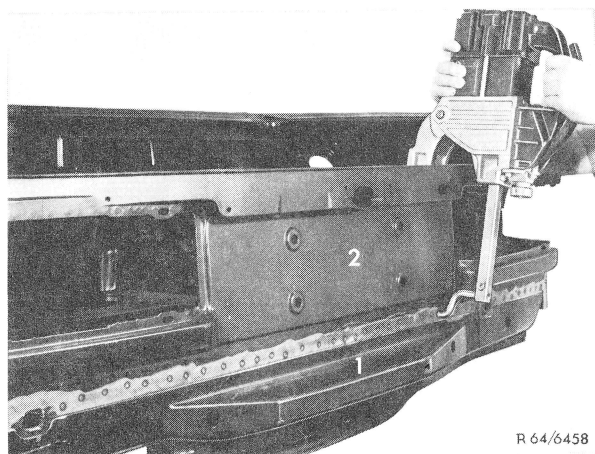
12 Check rear lid clearance and align with crosshead spindle Part No. 108 589 00 27 00 and tackweld.

13 Fit rear light assembly.

14 Weld-in rear center piece.

Note: To protect paintwork of fender (3), place asbestos on joint (4) (Fig. 2).

64.1 Partially Replacing Lower Rear Center Piece



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Figure 3

- 1 Rear end floor
- 2 Lower rear center piece

15 Spotweld lower rear center piece (2) to rear end floor (1) (Fig. 3).

16 Braze and clean welding seams.

17 Seal welding seams in trunk compartment.

18 Prime rear center piece and paint.

19 Reinstall removed parts.