

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 (Fig. 1).

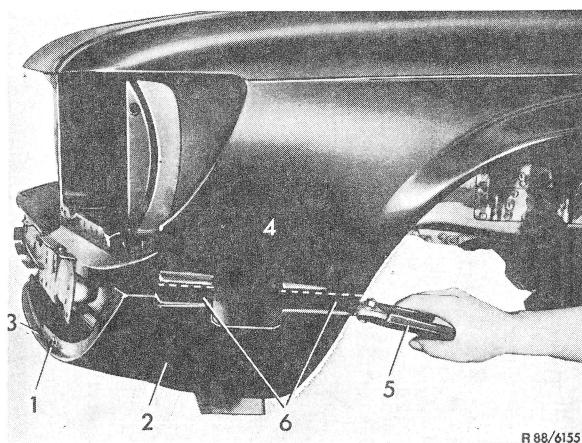


Fig. 1

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|--------------------|--------------------|
| 1 Screw connection | 4 Fender |
| 2 Fender bottom | 5 Shears |
| 3 Molding | 6 Spot weld flange |

- 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) (Fig. 2).

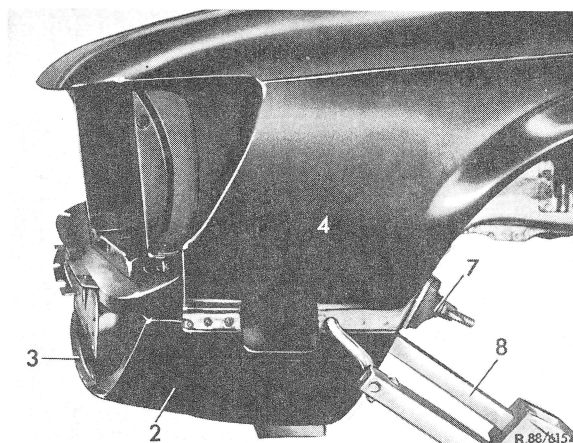


Fig. 2

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|-----------------|---------------|
| 2 Fender bottom | 7 Hand vise |
| 3 Molding | 8 Spot welder |
| 4 Fender | |

- 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) (Fig. 2).
- 15 Align spot welds and grind off spatter, if any.
- 16 Prime machined spots and paint.
- 17 Reinstall all removed parts.