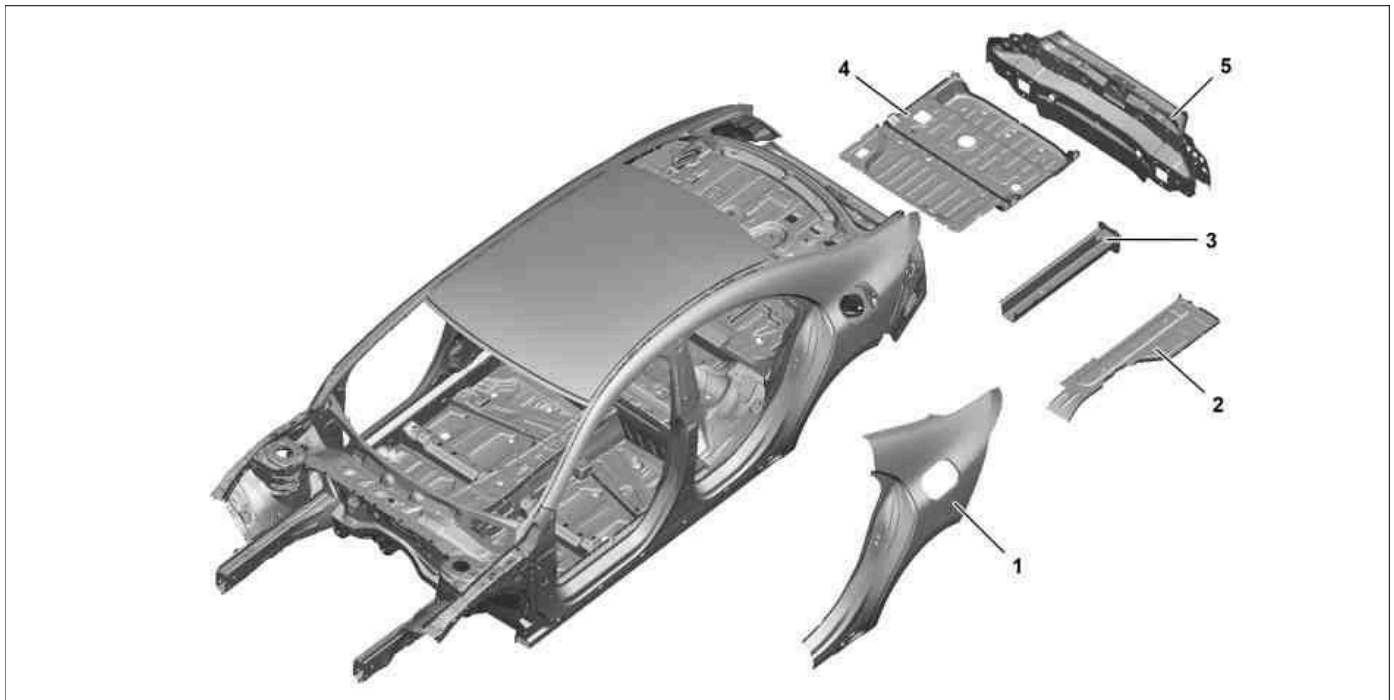


Model 118.3












P64.20-A308-09

1 Rear fender  
2 Left rear floor

3 Rear longitudinal member  
4 Spare wheel well

5 Rear center section

	<b>Risk of explosion</b> caused by fuel igniting, risk of poisoning caused by inhaling and swallowing fuel as well as risk of injury to eyes and skin caused by contact with fuel.	No fires, sparks, open flames or smoking. Pour fuels into suitable and appropriately marked containers only. Wear protective clothing when handling fuel.	AS47.00-Z-0001-01A
	<b>Risk of death</b> caused by vehicle slipping or toppling off of the lifting platform.	Align vehicle between vehicle lift columns and position the four support plates at the vehicle lift support points specified by the vehicle manufacturer.	AS00.00-Z-0010-01A
⚠ Warning	<b>Risk of injury</b> . Skin or eye injuries may result when handling hot or glowing objects.	Wear protective gloves, protective clothing and safety glasses, if necessary.	AS00.00-Z-0002-01A
⚠ Caution	<b>Risk of injury</b> caused by scraping or cutting body parts on sharp vehicle parts	Always wear protective gloves when working on or near sharp and non-deburred vehicle parts. Deburr repair panels.	AS00.00-Z-0017-01A
	General information on body repair		AH60.00-N-0001-01A
	Pretreatment of bonding surfaces		AH60.00-P-0008-01SX
	Notes on acoustic foam and structural foam in the vehicle		AH60.00-P-0039-01MFA
	General information on MB materials		AH98.00-P-9409-03A
☒	<b>Remove</b>		
1	Remove detachable parts in area of repair point.		
2	Cover all detachable parts remaining in vehicle with spark protection blankets.	<b>i</b> <b>Commercially available devices/tools</b> Spark-proof blankets	
3	Set up straightening bench with straightening bench crossmembers and straightening set. 000 588 01 23 00 Body straightening system		WS60.00-P-0023K
4	Place vehicle on straightening bench and fasten.		
5	Reshape damage area.		
6	Remove rear-end center section (5). 000 588 00 84 00 Heat gun		AR64.20-P-1000-02MFC WS54.00-P-0049B

		<b>i</b> <b>Commercially available devices/tools</b> Round wire brush Spot weld milling machine Wet/dry vacuum cleaner 1K-zinc dust paint  Spot weld milling cutter	*BR00.45-Z-1056-07A *201589005100
7  WS	Remove rear fender (1). 000 588 00 84 00 Heat gun	<b>i</b> <b>Commercially available devices/tools</b> Round wire brush Body saw Spot weld milling machine Wet/dry vacuum cleaner 1K-zinc dust paint	AR63.50-P-1400-02MFD WS54.00-P-0049B *BR00.45-Z-1056-07A
8  WS	Remove spare wheel well (4). 000 588 00 84 00 Heat gun	<b>i</b> <b>Commercially available devices/tools</b> Round wire brush Spot weld milling machine Wet/dry vacuum cleaner 1K-zinc dust paint  Spot weld milling cutter	AR64.20-P-1245-01MFC WS54.00-P-0049B *BR00.45-Z-1056-07A *201589005100
9  WS	Remove rear longitudinal member (3) with left rear-end floor (2). 000 588 00 84 00 Heat gun	<b>i</b> <b>Commercially available devices/tools</b> Round wire brush Body saw Spot weld milling machine Wet/dry vacuum cleaner 1K-zinc dust paint	AR64.20-P-1200-22MFD WS54.00-P-0049B *BR00.45-Z-1056-07A
	<b>Install</b>		
	<b>Risk of explosion</b> caused by paint vapors igniting. <b>Risk of poisoning</b> caused by inhaling paint vapors.	No smoking! No open fire! Use respiratory protection, protective clothing, gloves, safety glasses and protective skin cream. Ensure that the area is well ventilated.	AS98.00-Z-0002-01A
	<b>Risk of explosion and poisoning</b> caused by solvent vapors and gasses. <b>Risk of injury</b> to skin and eyes when working with anticorrosion agents	Never spray corrosion protection on flames or hot, glowing objects and keep them well away from all potential sources of ignition. Use them only in well-ventilated rooms; wear respiratory protection.	AS97.00-Z-0001-01A
	The high voltage used for electric welding presents a lethal hazard. <b>Risk of explosion</b> from welding in areas close to highly inflammable materials. <b>Risk of injury</b> from weld splatter and UV-light when welding. <b>Risk of poisoning</b> from inhaling welding gases	Use insulating mats. Wear protective clothing, safety glasses and a protective mask. Remove highly inflammable materials from the hazard area. Use air extraction system.	AS00.00-Z-0007-01A
 Warning	<b>Risk of poisoning</b> caused by inhaling vapors or swallowing adhesive. <b>Risk of injury</b> caused by adhesive coming into contact with skin and eyes	Wear respiratory protection, protective gloves and safety glasses. Pour adhesive into suitable and appropriately marked containers only.	AS00.00-Z-0016-01A
	Measures for preventing damage to components when performing electric welding and soldering work		AH60.00-P-0001-02A
	General information on riveting		AH60.00-P-0003-01N
10  WS	Prepare rear longitudinal member (3) and left rear-end floor (2). 000 588 01 84 00 Welder	<b>i</b> <b>Commercially available devices/tools</b> Round wire brush Body saw Wet/dry vacuum cleaner Parts kit for 2-component adhesive for body 1K-zinc dust paint	AR64.20-P-1200-23MFD WS60.00-P-0021K *BR00.45-Z-1162-02A *BR00.45-Z-1056-07A
11  WS	Install rear longitudinal member (3) and left rear-end floor (2). 000 588 01 23 00 Body straightening system	<b>i</b> <b>Commercially available devices/tools</b> Round wire brush Wet/dry vacuum cleaner Blind rivet gun (minimum pull-off force 19 kN) Parts kit for 2-component adhesive for body Blind rivet 6.5 × 12.5 (clamping range 2 mm to 5 mm, draw-off strength min. 19 kN)	AR64.20-P-1200-24MFD WS60.00-P-0023K *BR00.45-Z-1162-02A *BR00.45-Z-1012-13A