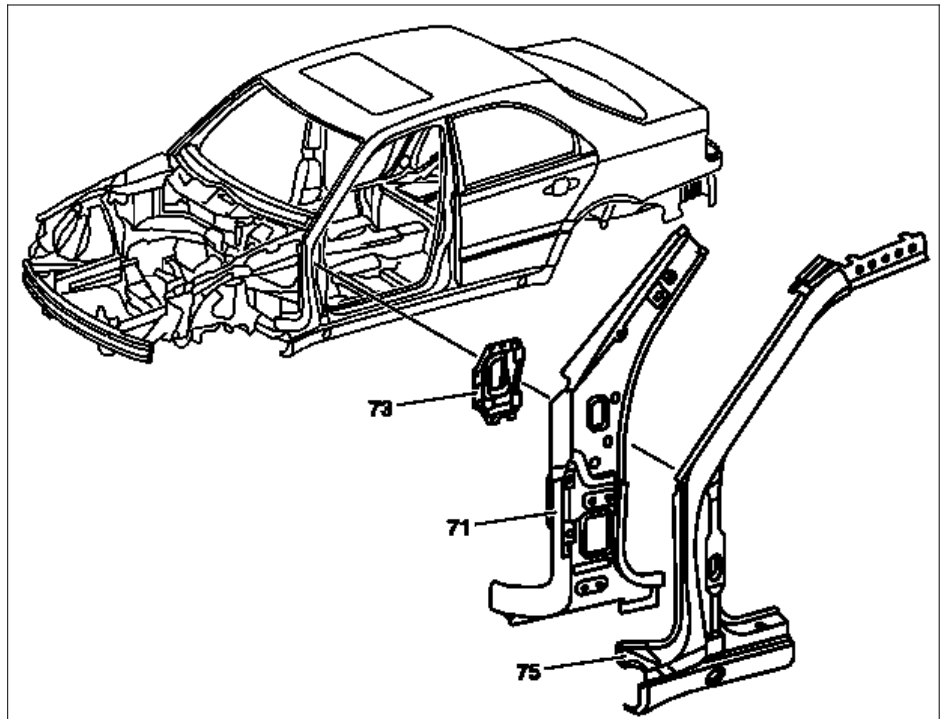


**Document title** Completely replacing A-pillar





**Document number** ar6320p1100e

## MODEL 202.0 /1

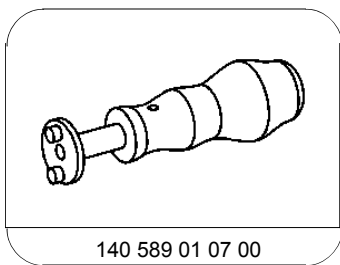
- 71 Inner section of A-pillar  
 73 Console for instrument panel carrier  
 75 A-pillar paneling



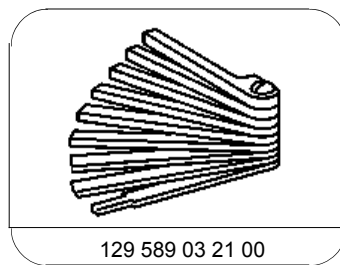
P63.20-0281-06

	Remove		
	General information on repairs to body	All models	AH60.00-N-0001-01A
1	Remove engine hood		AR88.40-P-3000E
2	Remove bumper		AR88.20-P-2000E
3	Remove front fender		AR88.10-P-1000E
4	Remove front door		AR72.10-P-0500E
5	Remove both front seats, remove floor mats		AR91.10-P-1000E
6	Remove instrument panel (cockpit) together with heater or air conditioner		AR68.10-P-1000E
7	Remove jacket tube		AR46.10-P-0400A
8	Remove pedal assembly for parking brake		
9	Remove attached parts in engine compartment and on firewall		
10	Remove or loosen electric lines and vacuum lines in area to be repaired		
11	Remove windshield		AR67.10-P-1000E
12	Cover vehicle passenger compartment		
13	Remove dampings on inside on firewall, floor and A-pillar		
14	Set up modular members on straightening bench		AR60.10-P-1050E
15	Set up straightening bench with straightening set	 Pay attention to the arrangement drawings enclosed with the straightening angle set. <b>Celette straightening set</b> <b>Car-Benchstraightening set</b>  Model 202.026/029/033/086/089/093 Additionally use supplementary straightening bracket set for engine 112, 113! Refer to ↓ Model 202, 208 with engine 112, 113 Celette supplementary straightening set Model 202, 208 with engine 112, 113 Car-Bench supplementary straightening set	AR60.10-P-1070E  *WE58.40-Z-1009-01E *WE58.40-Z-1001-01A  *WE58.40-Z-1012-01A *WE58.40-Z-1013-01A
16	Place vehicle on straightening bench lift and fasten		
17	Separate A-pillar (71, 75)		AR63.20-P-1100-01E

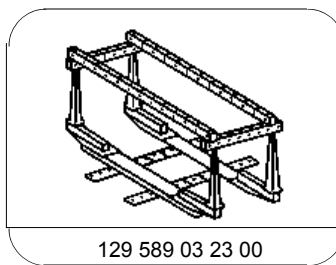
	<b>Install</b>		
<b>⚠ Danger!</b>	<b>Risk of death</b> caused by high voltage used for arc welding. <b>Risk of explosion</b> caused by welding in the area of highly inflammable materials. <b>Injury hazard</b> from welding spatter and UV-light while welding. <b>Risk of poisoning</b> caused by inhaling welding vapors.	Use insulating mats. Wear protective clothing, safety glasses and protective mask. Remove highly inflammable materials from the danger zone. Use air extractor.	AS00.00-Z-0007-01A
	Measures for preventing damage to vehicles or components when performing arc welding work	All models	AH00.00-N-0005-01A
18	Prepare connection points on body		AR63.20-P-1100-02E
19	Prepare internal component (71), console (73) and paneling (75)		AR63.20-P-1100-03E
20	Weld in inner section (71) and console (73)		AR63.20-P-1100-04E
21	Install side portal straightening set		AR60.20-P-1700E
22	Weld in paneling (75)		AR63.20-P-1100-05E
23	Loosen vehicle and remove from straightening bench		
24	Seal welding flanges	Seam sealing following repairs	AR97.10-P-4000E
25	Supplement permanent underfloor protection	Apply permanent underbody protection agent	AR97.20-P-0500A
26	Paint repaired areas to match vehicle color		
27	Prepaint detachable body components to match the color of the car		
28	Install or replace damping on inside		
29	Install front door		AR72.10-P-0500E
30	Install engine hood		AR88.40-P-3000E
31	Install front fender		AR88.10-P-1000E
32	Finish painting vehicle		
33	Supplement cavity preservation and underbody preservation		
	Notes on cavity preservation	Model 129, 140, 170, 201, 202, 208, 210	AH97.20-P-0001-01B
	Underbody preservation	Model 100, 107, 108, 109, 111, 113, 114, 115, 116, 123, 124, 126, 129, 140, 163, 168, 170, 201, 202, 208, 210, 220	AH97.20-P-2000-01A
		Cavity preservation following repairs	AR97.20-P-1500E
34	Install detachable body components removed		



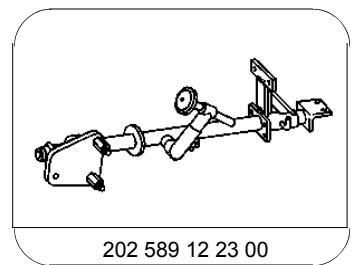
Puller



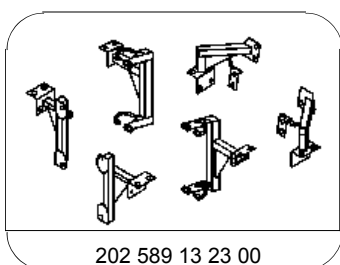
Feeler gauge



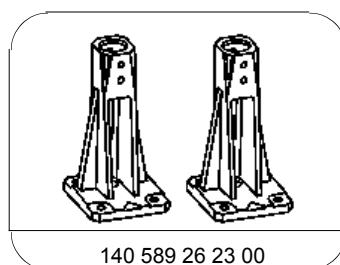
Portal frame



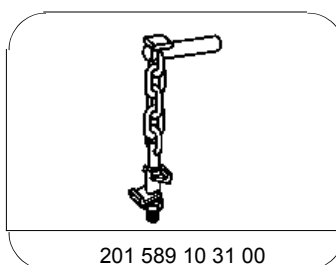
Check and welding gage



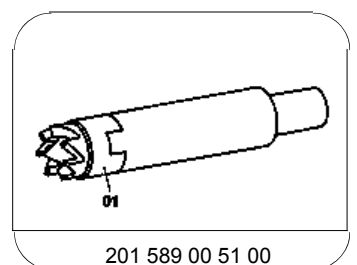
Set of check and welding gauges



Multi-Z elements MZ 260



Tensioning device set



Spot weld milling cutter

### Commercially available tools

Number	Designation
WH58.30-Z-1002-01A	Ball cutter, dia. 12 mm
WH58.30-Z-1006-01A	Vario Drill WS 91 spot weld removing tool
WH58.30-Z-1003-02A	Clamping pliers
WH58.30-Z-1031-02A	C-clamp
WH58.30-Z-1001-03A	Round wire brush, braided, dia. 70 mm
WH58.30-Z-1021-04A	Cutting disk, dia. 65 mm, 80 m/s (max. 23,500 rpm)
WH58.30-Z-1024-04A	Abrasive disk, dia. 115 mm, 80 m/s (max. 13,250 rpm)
WH58.30-Z-1007-06A	Reversible ratchet
WH58.30-Z-1010-06A	Socket SW19 for hexagon head screws
WH58.30-Z-1011-06A	Socket wrench bit A/SW22 for hexagon bolts
WH58.30-Z-1026-06A	Screwdriver bit, 8 mm for hexagon socket head screws
WH58.30-Z-1001-11A	Double end box wrench, offset, 17 x 19 mm
WH58.30-Z-1002-11A	Double end box wrench, offset, 22 x 24 mm

### Workshop equipment

WE58.40-Z-1001-01A	Car bench straightening bracket set 82415, (model 202)
WE58.40-Z-1012-01A	Celette straightening bracket set 7202.309 (model 202, 208 with engine 112, 113), as supplement to 7202.300 (model 202)
WE58.40-Z-1013-01A	Car Bench straightening bracket set 82 426 (models 202, 208 with engines 112, 113), as supplement to 82 415, (model 202)
WE58.40-Z-1001-01E	Celette straightening bench
WE58.40-Z-1002-01E	Celette straightening unit
WE58.40-Z-1003-01E	Car-Bench straightening bench
WE58.40-Z-1004-01E	Car-Bench straightening lifting platform
WE58.40-Z-1005-01E	Car-Bench straightening equipment
WE58.40-Z-1007-01E	Celette module crossmember set 955.940
WE58.40-Z-1008-01E	Celette additional member 955.908
WE58.40-Z-1009-01E	Celette straightening bracket set 7202.300
WE58.40-Z-1010-01E	Car-Bench universal cross member set A 296
WE58.40-Z-1001-02A	Inert gas welder
WE58.40-Z-1001-03A	Drill (electric/pneumatic)
WE58.40-Z-1002-03A	Straight grinder (electric/pneumatic)
WE58.40-Z-1003-03A	Angle grinder (electric/pneumatic)
WE58.40-Z-1004-03A	Body saw (electric/pneumatic)
WE58.40-Z-1008-03A	Pneumatic ratchet
WE58.40-Z-1001-05A	Two-post lifting platform