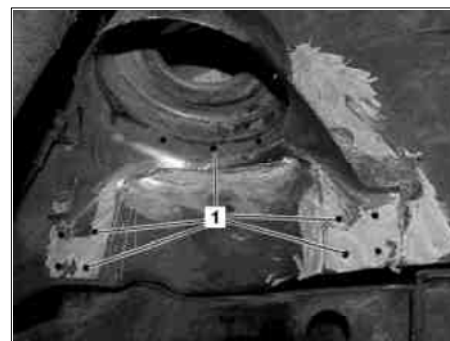


MODEL 210 (except 210.08 /28)

1 Spot welds for spring mount



P62.10-2048-01

2 Drill holes

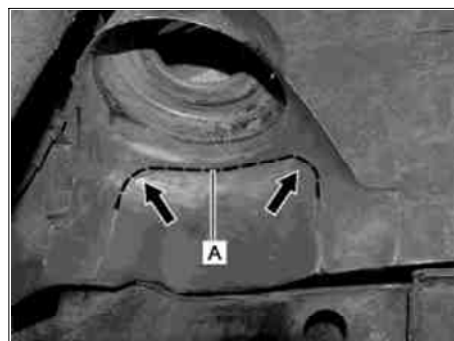


P62.10-2046-01

Shown on new riveted spring mount



P62.10-2047-01



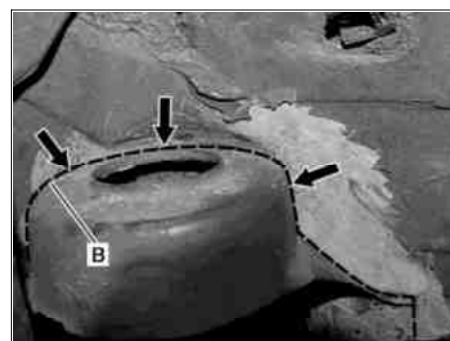
Shown on bottom spring plate

A Seam

P62.10-2044-01

















Shown on top spring plate

B Seam

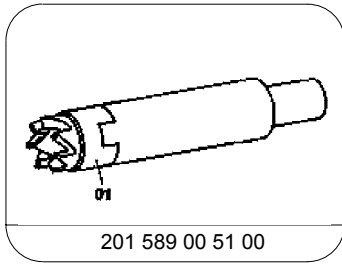


P62.10-2045-01

	<p>Remove</p>		
<p>⚠ Danger!</p>	<p>Risk of injury caused by scraping or cutting body parts on sharp vehicle parts</p>	<p>Always wear protective gloves when working on or near sharp and undeurred vehicle parts. Deburr replacement panels.</p>	<p>AS00.00-Z-0017-01A</p>
<p>⚠ Danger!</p>	<p>Risk of explosion caused by oxyhydrogen gas. Risk of poisoning and caustic burns caused by swallowing battery acid. Risk of injury caused by burns to skin and eyes from battery acid or when handling damaged lead-acid batteries</p>	<p>No fire, sparks, open flames or smoking. Wear acid-resistant gloves, clothing and safety glasses. Pour battery acid only into suitable and appropriately marked containers.</p>	<p>AS54.10-Z-0001-01A</p>

 Danger!	Risk of explosion and poisoning caused by solvent vapors and gasses. Injury hazard for eyes and skin when processing corrosion protection agent.	Never spray anticorrosion agents on flames or glowing hot 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
	General information on body repair	All models	AH60.00-N-0001-01A
	Notes on cavity preservation	Model 124, 126, 129, 140, 170, 171, 201, 202, 203, 208, 209, 210, 211, 215, 220, 230, 240, 463, 639, 671, 690.6, 901, 902, 903, 904, 905, Model WD1, WD2, WD3, WD6, WD7, XD1, XD2, XD3, XD4, XD5, XD6, XD7, YD1, YD2, YD3, YD4, YD5, YD6, YD7	AH97.20-P-0001-01B
	General information on MB materials	Model 124, 126, 129, 140, 163, 168, 170, 171, 201, 202, 203, 208, 209, 210, 211, 215, 220, 230, 240, 414, 463, 639	AH98.00-P-9409-03A
1	Disconnect battery ground cable		AR54.10-P-0003A
2	Remove wheels from front axle Remove/install wheels, rotate if necessary		AP40.10-P-4050Z
3	Remove front springs	Model 210 except model 210.07 without special protection version, code 979, without light armoring, code Z04, without B6 armoring, code Z06 Model 210.07 with special protection version 979, with light armoring, code Z04, with B6 armoring, code Z06	AR32.20-P-0200B AR32.20-P-0200FB
4	Remove brake wear indicators		
5	Remove line holder from ABS sensors		
6	Cut spot welds on spring mounts (1)	 Spot weld cutter  Spherical milling cutter, dia. 12 mm	*201589005100 *WH58.30-Z-1001-01A
7	Remove spring mounts	 Drill spot welds out of spring mount (1) Drill (electric/pneumatic)	*WE58.40-Z-1001-03A
	Install		
8	Clean installation surfaces on vehicle	 Round wire brush, braided, dia. 70 mm Drill (electric/pneumatic)	*WH58.30-Z-1001-03A *WE58.40-Z-1001-03A
9	Align installation surface on vehicle		
10	Drill pilot rivet holes in new parts	Drill (electric/pneumatic)	*WE58.40-Z-1001-03A
11	Countersink rivet holes in new parts	 Only countersink the three upper rivet holes Drill (electric/pneumatic)	*WE58.40-Z-1001-03A
12	Fit spring mounts	 Clamping pliers	*WH58.30-Z-1005-02A
13	Drill holes (2) for rivet connections	Drill (electric/pneumatic)	*WE58.40-Z-1001-03A
14	Deburr holes (2)		
15	Prime repair areas and adjacent surfaces		
16	Prime contacts surfaces on new parts		
17	Dry repair areas and adjacent surfaces	 Air-dry overnight Accelerated drying of 15 to 30 minutes with lamp or blower	
18	Rivet spring mounts	 Use only high-strength rivets, use countersink rivets in area of spring plate.  Taurus 4 blind rivet tool  100 mm extension for Taurus 4 pop rivet gun	*WH58.30-Z-1013-29A *WH58.30-Z-1014-29A
19	Generously wax connection areas	 Do not seal seam (A) in lower spring plate area and seam (B) in upper spring plate area, leave open	
20	Apply permanent underbody protection agent		AR97.20-P-0500-03A
21	Apply additional cavity preservation	HRS cavity preservation gun	*WE58.40-Z-1020-08A
22	Install line holder for ABS sensors		
23	Install brake wear indicators.		
24	Install front springs	Model 210 except model 210.07 without special protection version, code 979, without light armoring, code Z04, without B6 armoring, code Z06 Model 210.07 with special protection version 979, with light armoring, code Z04, with B6 armoring, code Z06	AR32.20-P-0200B AR32.20-P-0200FB

25	Install wheels for front axle Remove/install wheels, rotate if necessary	AP	AP40.10-P-4050Z
26	Connect ground cable to battery		AR54.10-P-0003A



201 589 00 51 00

Spot weld milling cutter

Commercially available tools (see Workshop Equipment Manual)

Number	Designation	Make (e. g.)	Order number
WH58.30-Z-1001-01A	Spherical milling cutter, dia. 12 mm	Wieländer-Schill D-78026 Villingen-Schwenningen	637002
WH58.30-Z-1005-02A	Clamping pliers	Wieländer & Schill D-78026 Villingen-Schwenningen	
WH58.30-Z-1001-03A	Round wire brush, braided, dia.70 mm	Wieländer & Schill D-78026 Villingen-Schwenningen	541202
WH58.30-Z-1013-29A	Taurus 4 blind rivet tool	Wieländer & Schill D-78026 Villingen-Schwenningen	571110
WH58.30-Z-1014-29A	100 mm extension for Taurus 4 blind rivet tool	Wieländer & Schill D-78026 Villingen-Schwenningen	578113

Workshop equipment/MB testers (see Workshop Equipment Manual)

WE58.40-Z-1001-03A	Drill (electric/pneumatic)
WE58.40-Z-1003-03A	Angular grinder (electric/pneumatic)
WE58.40-Z-1020-08A	HRS cavity preservation gun, with door probe, nylon probe and hook probe, Sata / Wieländer & Schill