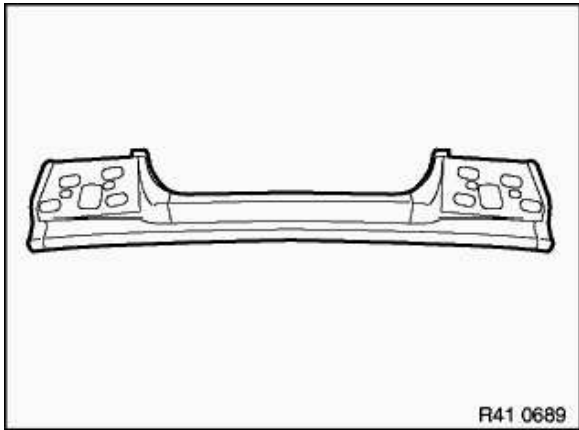


Instructions on body repair,  
refer to 41 00

### Tail panel

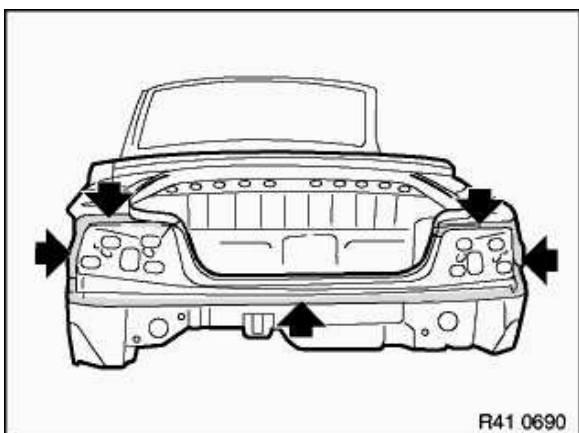


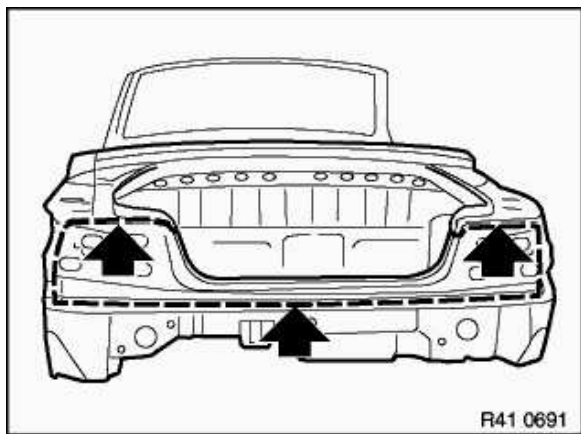
Remove or disconnect following parts:

- Complete rear bumper
- Trunk trim panels
- Spare wheel
- Tool tray
- Left, right tail lights
- Cable harness (partially)
- Lock base
- Luggage compartment lid
- Rear left and right side panel

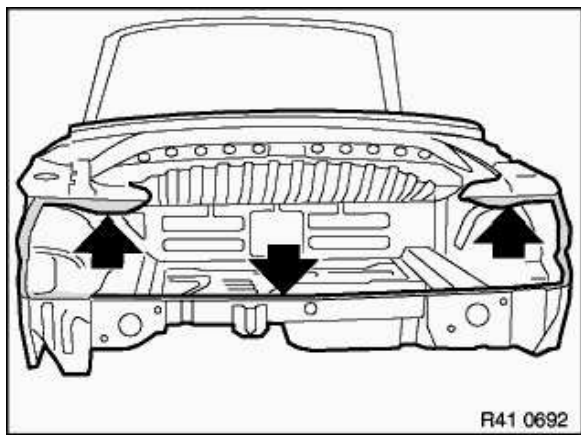
Other vehicle parts located in the repair zone or subject to be damaged from heat, sparks or dust, must be removed or covered.

Uncover mating surfaces.

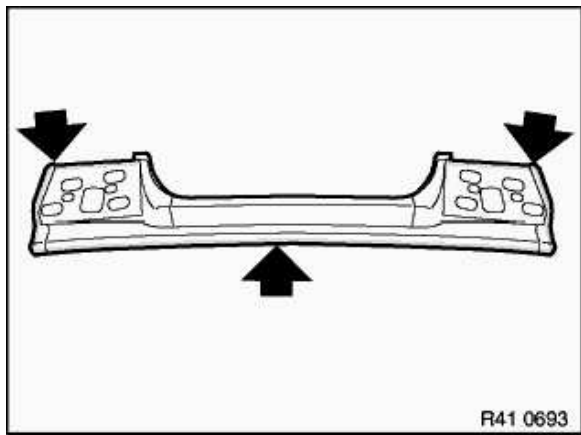




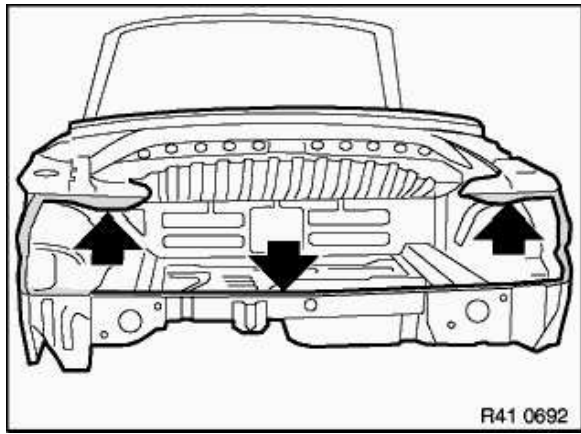
Cut out tail panel roughly.



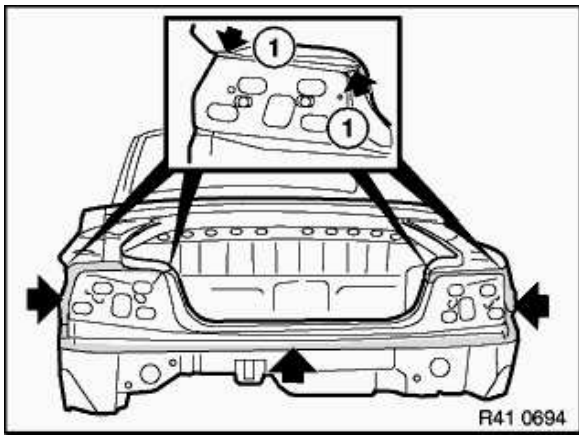
Remove scrap metal. Grind down and straighten mating surfaces.



Clean connection point on spare tail panel and coat with zinc dust paint.



Coat connection points on the body with zinc dust paint.



Adjust tail panel to fit, secure and weld up.  
Braze tail panel in these areas (1).  
Grind down connection points and seal.