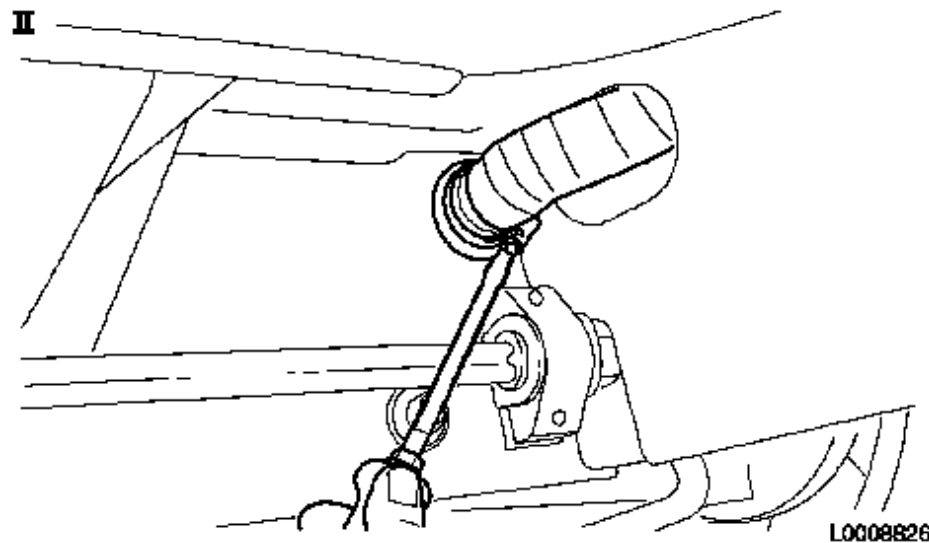
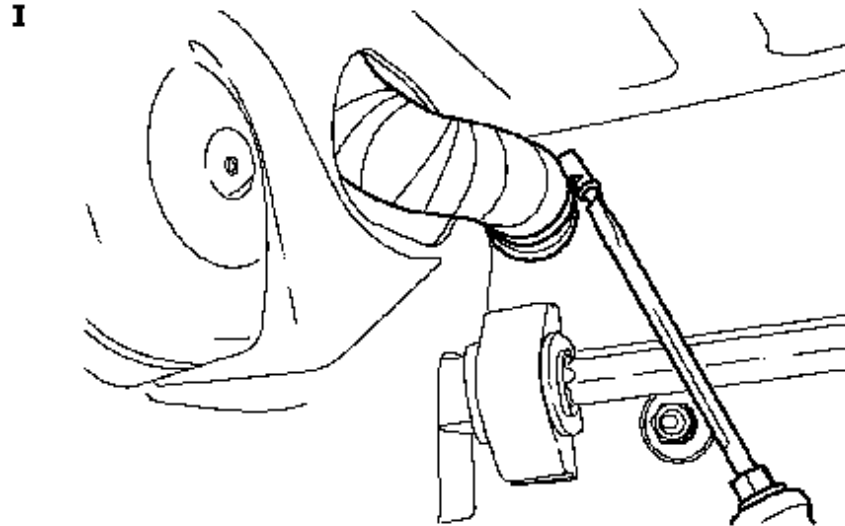


Crashbox, Replace

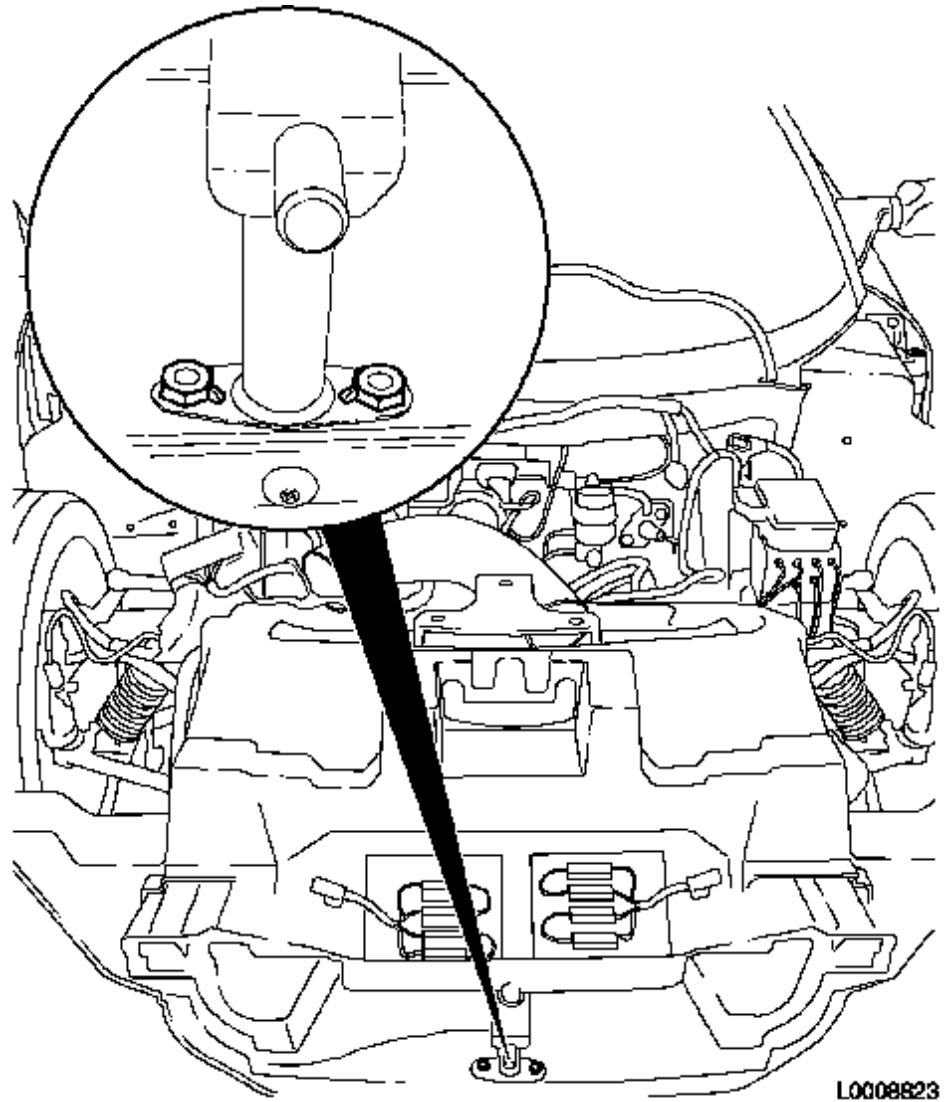


Remove

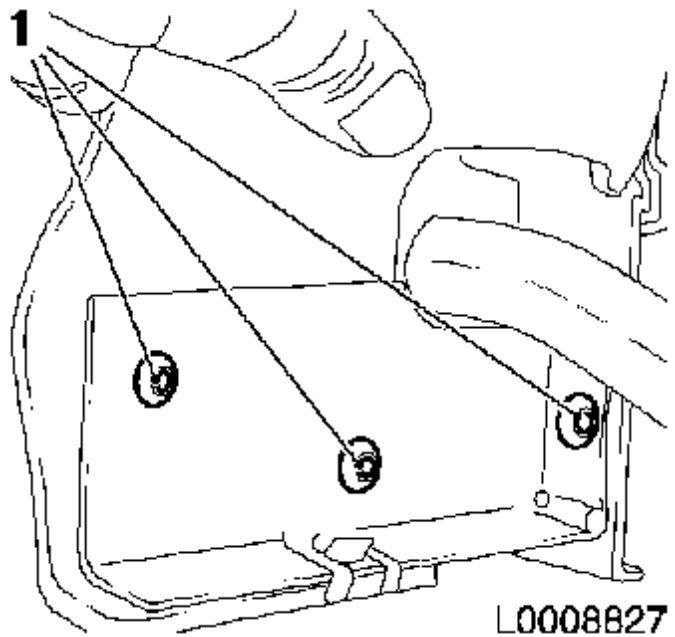
1. Remove radiator.
Note: Includes detaching front clamshell.
 - see operation "Radiator, Remove and Install" in group J
2. Detach left radiator hose (I) from coolant pipe
3. Detach right radiator hose (II) from coolant pipe



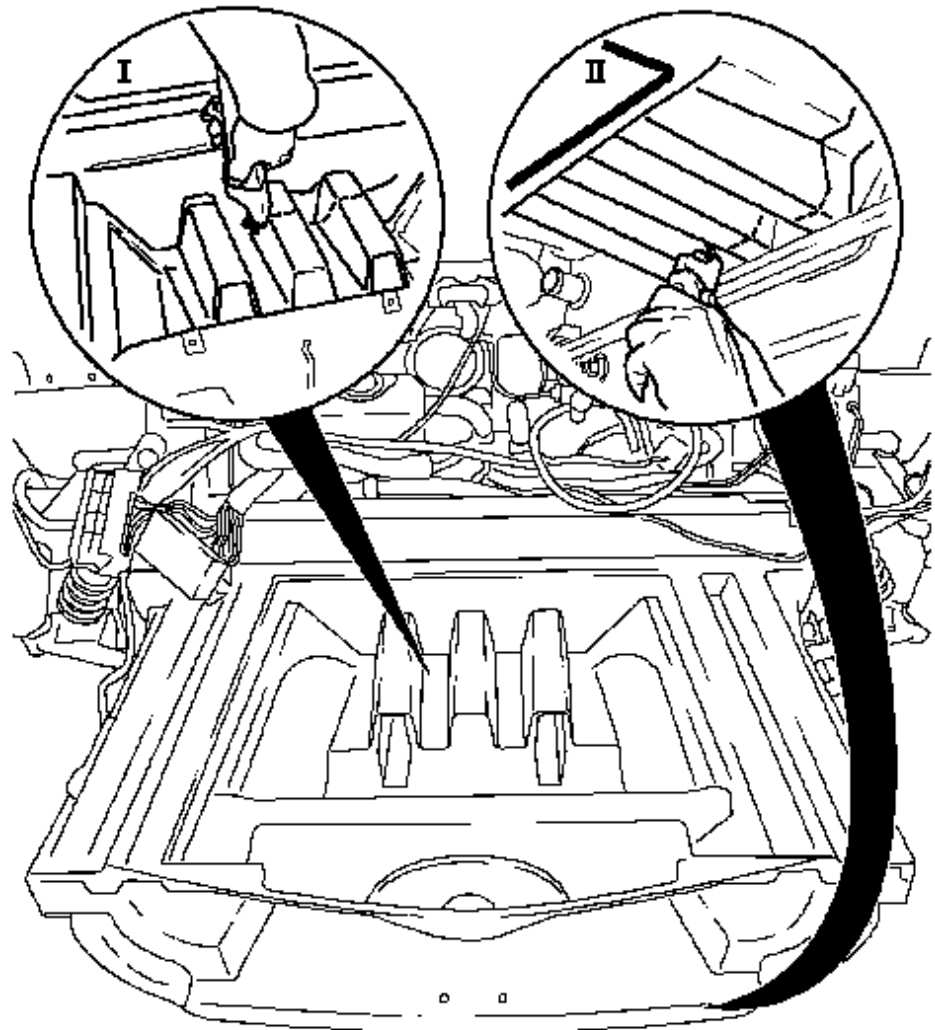
4. Remove towing device



- 5. Drill out rivets (1) from left and right gussets
 - Remove gussets



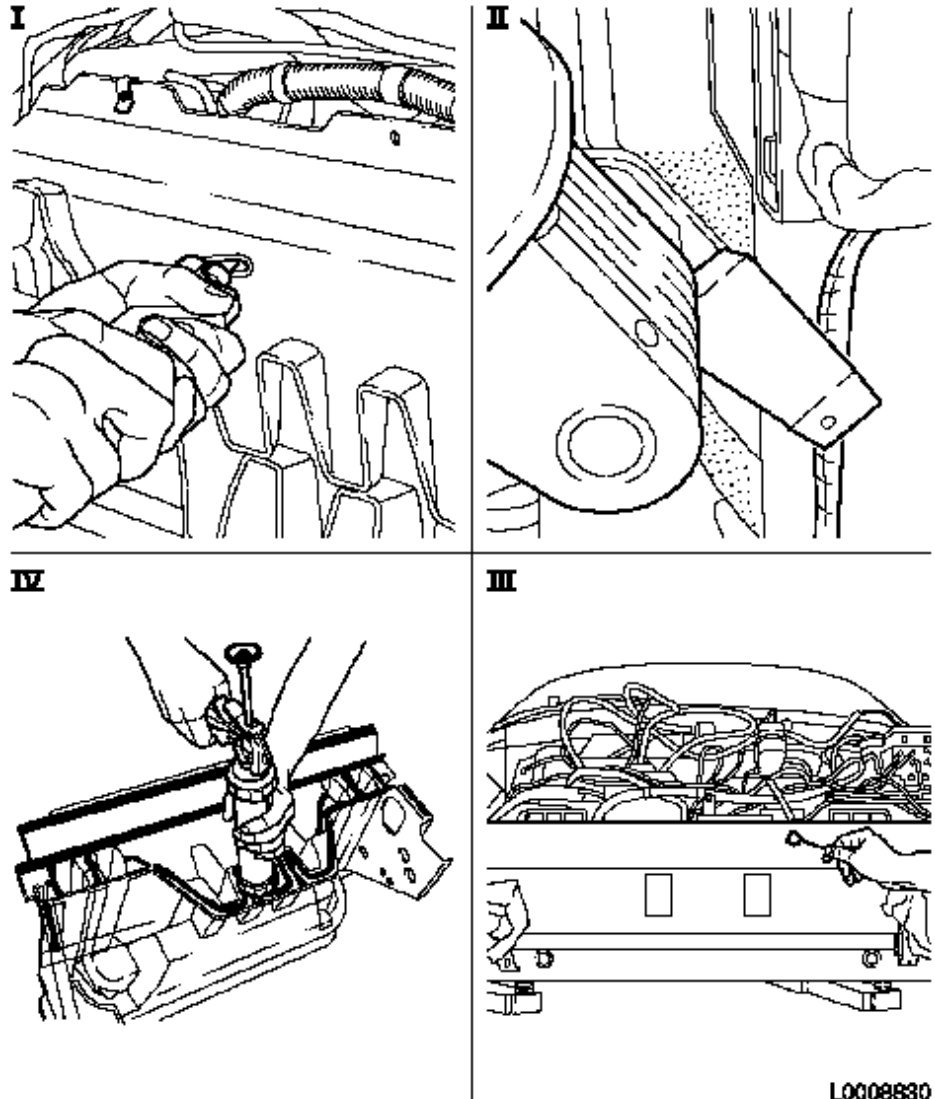
6. Detach threaded clamps from crashbox
 - 10x
7. Cut off flange from crashbox at top (I)
 - using a pneumatic saw
8. Make cut in side of crashbox on left
9. Make cut in side of crashbox on right
10. Roughly cut out crashbox
 - using a pneumatic saw
11. Cut off flange from crashbox at bottom (II)



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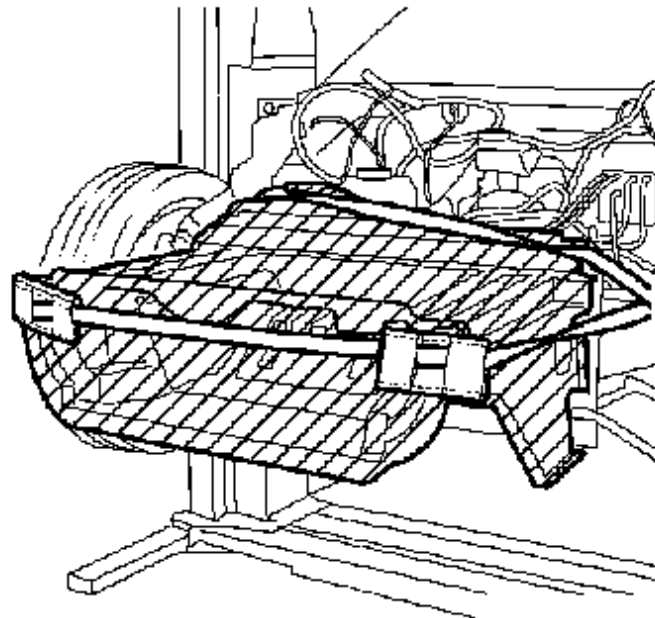
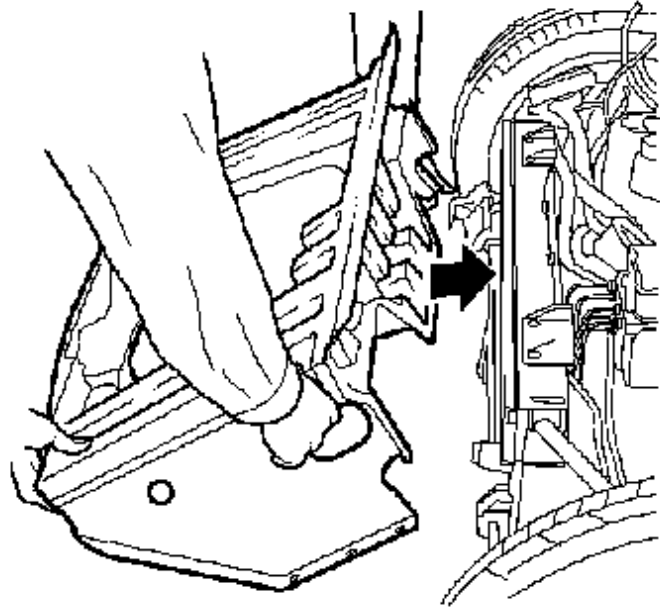
12. Cut off residues (I)
13. Trim down adhesive beads (II)
14. Clean crashbox
15. Clean adhesive points on vehicle (III)
16. Apply primer to crashbox
 - Shake primer for 1 minute
 - 15 minutes drying time
17. Using primer, make good the adhesive points on the vehicle
18. Apply adhesive to

crashbox (IV)

**Install**

19. Place crashbox in position
 - Align crashbox
 - fix in place with strap pliers and tensioning strap

Note: 2. Second technician required, follow instructions regarding adhesive drying time



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20. Remove strap pliers
21. Rivet on right gusset
 - Drill 2 holes
 - 3 rivets
22. Rivet on left gusset
 - Drill 2 holes
 - 3 rivets
23. Fit threaded clamps
 - 12x
24. Install towing device
 - Coat screws with locking compound
25. Apply primer to crashbox

- to coolant pipe
- 26.** Fit right radiator hose
- to coolant pipe
- 27.** Install radiator
- see operation "Radiator, Remove and Install" in group J