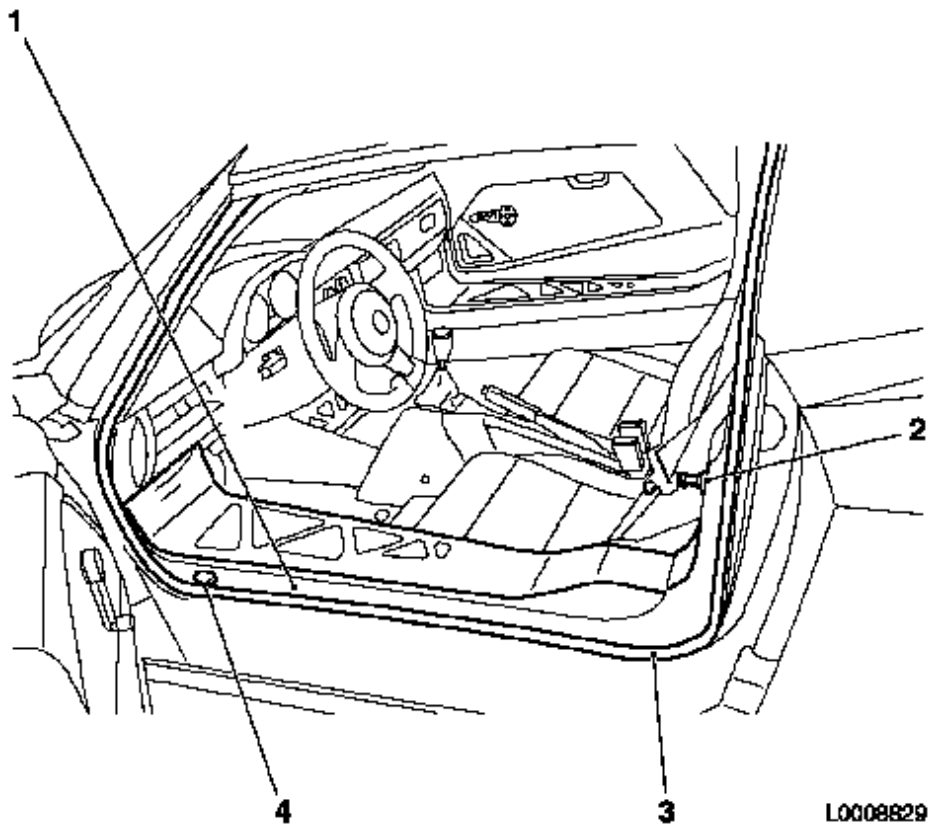


Side Sill, Replace

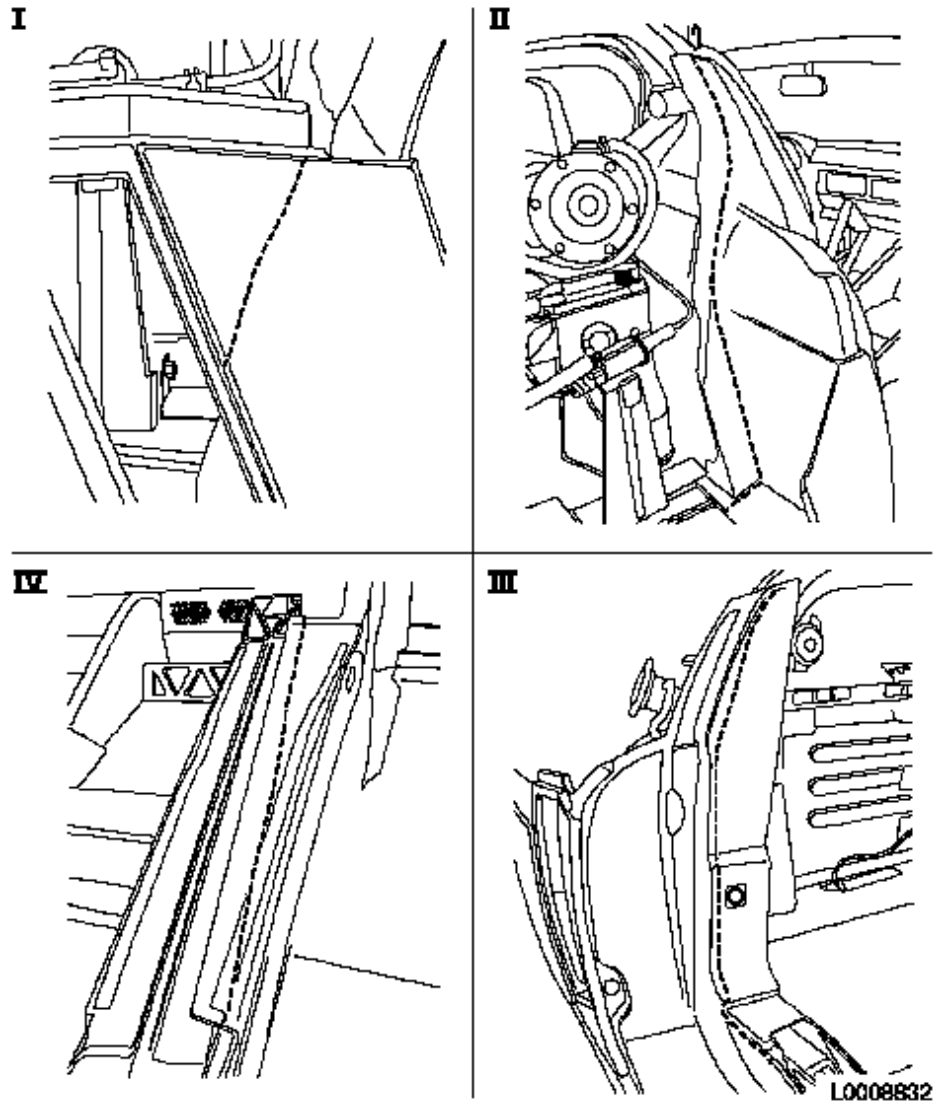


Remove

1. Detach front clamshell
 - see operation "Front Clamshell, Remove and Install".
2. Detach rear clamshell
 - see operation "Rear Clamshell, Remove and Install".
3. Remove door
 - see operation "Door, Remove and Install".
4. Detach ancillary components
 - Sill inner trim (1)
 - Door lock (2)
 - Door seal (3)
 - Door contact switch (4)



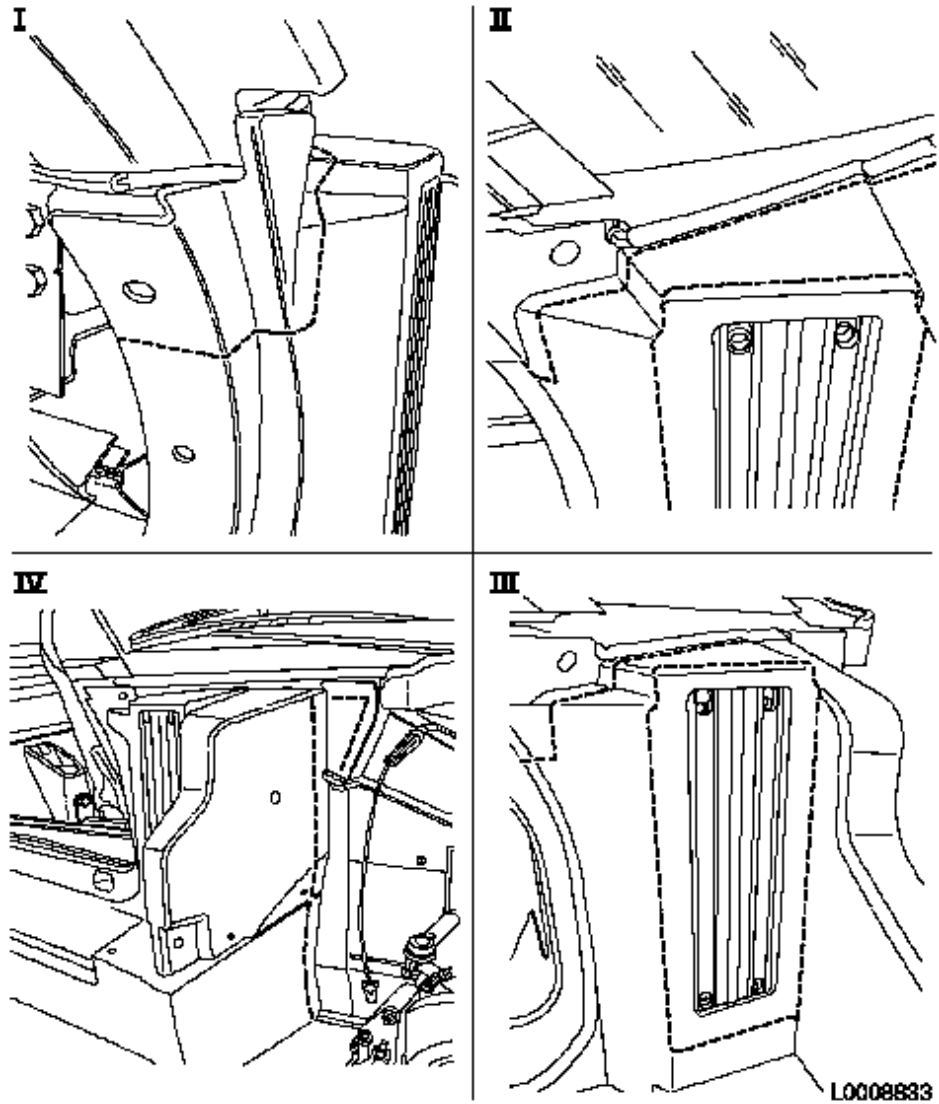
5. Mark out cutting lines
 - Note:** Mark out all cutting lines to avoid damage when cutting out.
 - Mark out cutting lines I, II, III and IV



6. Mark out cutting lines

Note: Mark out all cutting lines to avoid damage when cutting out.

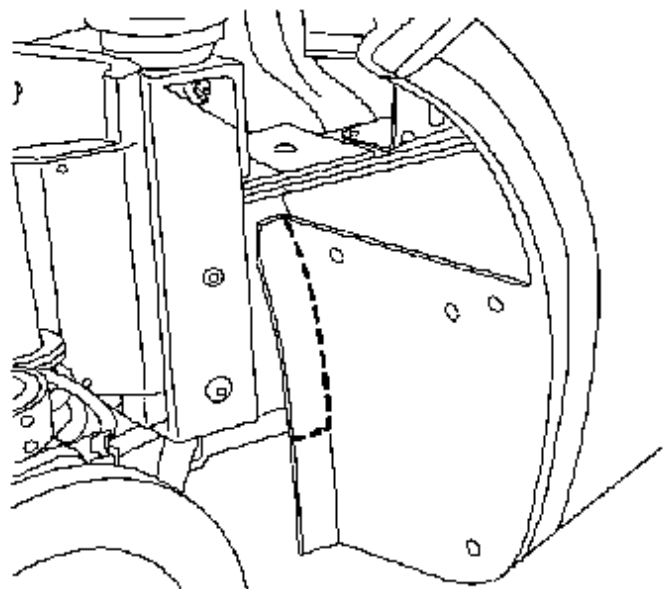
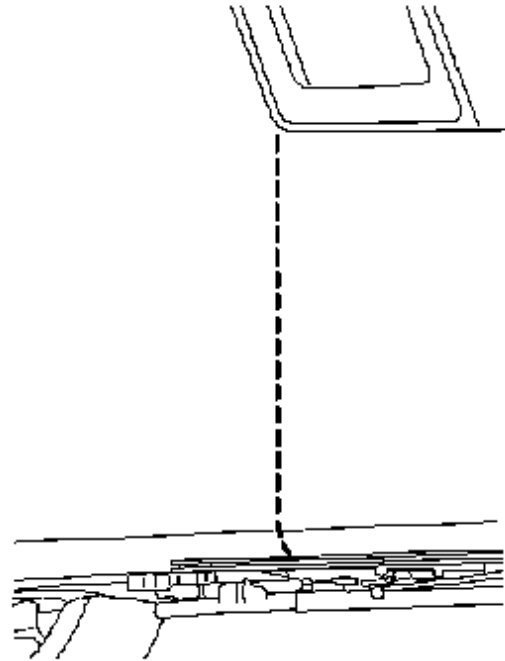
- Mark out cutting lines I, II, III and IV



7. Mark out cutting lines

Note: Mark out all cutting lines to avoid damage when cutting out.

- Mark out cutting lines I and II



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8. Cut step plate at bottom along entire length
9. Cut free in rear section
 - Detach along marked cutting line
10. Cut free at rear of B-pillar
 - Detach along marked cutting line from top to bottom
11. Cut free at front of B-pillar
 - Detach along marked cutting line from top to bottom
12. Cut free at hinge area
 - Detach along marked cutting line
13. Cut free at top of A-pillar
 - Detach along marked cutting line
14. Cut free at front of A-pillar

- Detach along marked cutting line from top to bottom
15. Detach step plate at top
 - Detach along marked cutting line
 16. Remove sill

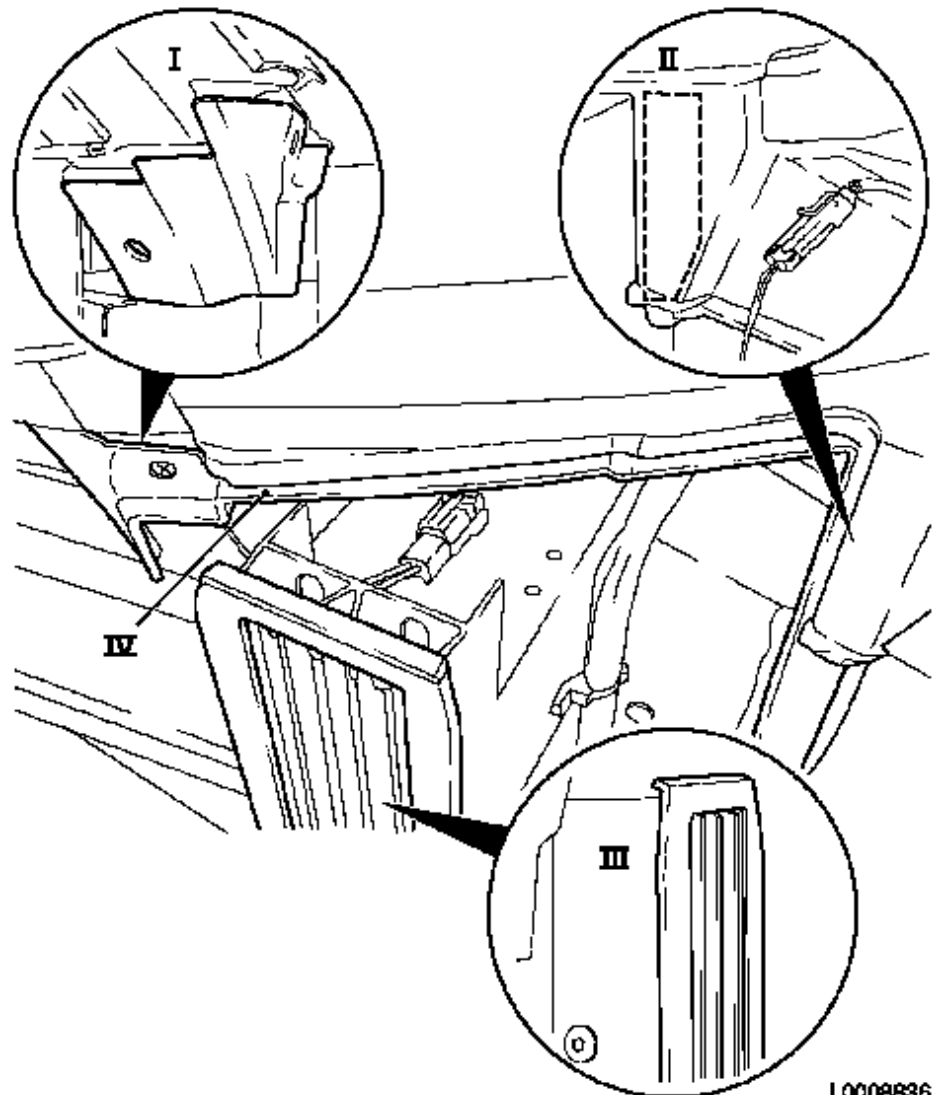
17. Cutting out window frame corner (II)
 - Note:** Window frame corner (II) is re-used.

18. Change cutting blade
 - **MKM-846-9**

19. Detach remaining flange at front of A-pillar

20. Remove remaining flange from windscreen frame (IV)

21. Remove remaining flange in hinge area (III)



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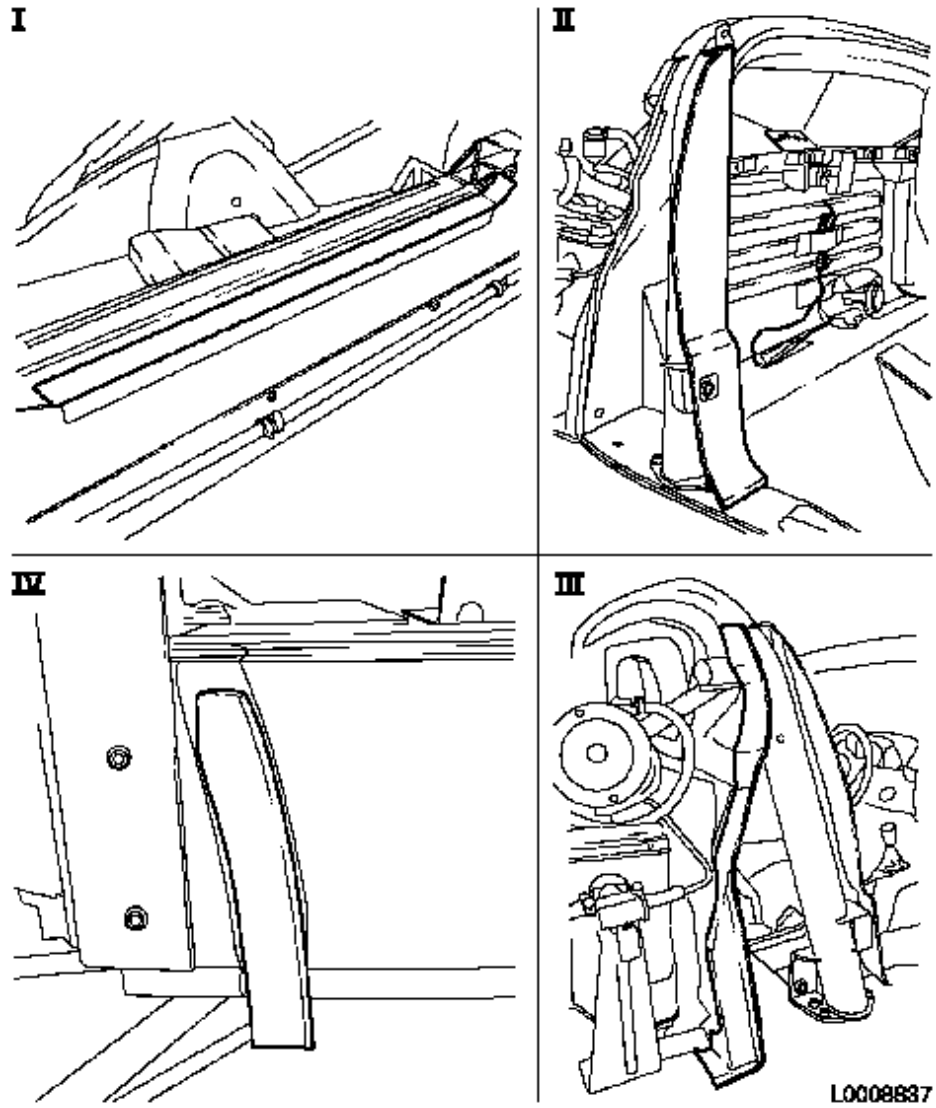
22. Remove remaining flange on step plate (I)

23. Remove remaining flange at front of B-pillar (II)

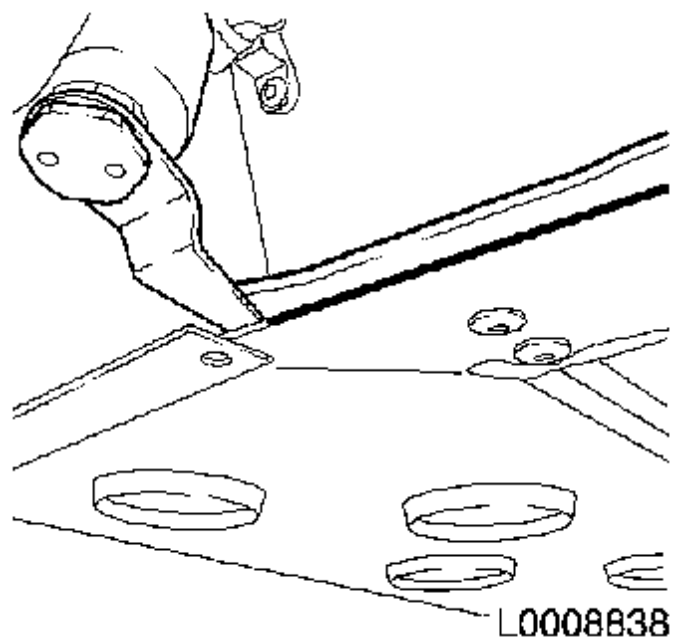
Important: Do not damage bulkhead

24. Remove remaining flange at rear of B-pillar (III)

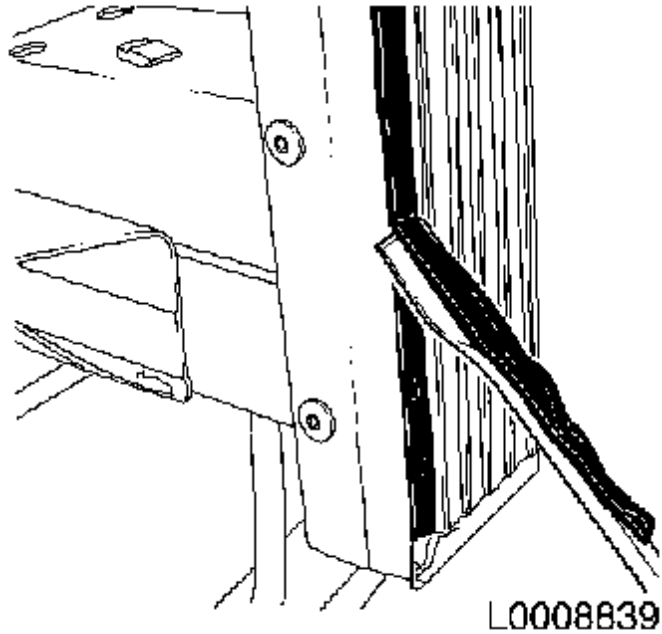
25. Remove remaining flange at rear wheel well (IV)



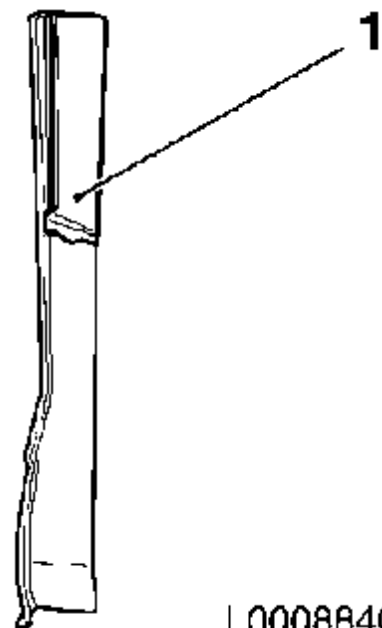
26. Remove remaining flange from step plate at bottom
- Cut at the top and bottom along the remaining flange



27. Remove the adhesive residues in the grooves
 - Note:** Lower areas of step plate and B-pillar must be completely free of adhesive residues
28. Remove adhesive residues from step plate at top
29. Remove adhesive residues from front of A-pillar
30. Remove adhesive residues from rear wheel well
31. Remove adhesive residues from windscreen frame
 - Scraper and carpet knife
32. Remove adhesive residues from hinge support
- Important:** Do not damage bulkhead
33. Remove adhesive residues from rear bulkhead
34. Remove adhesive residues from roll bar

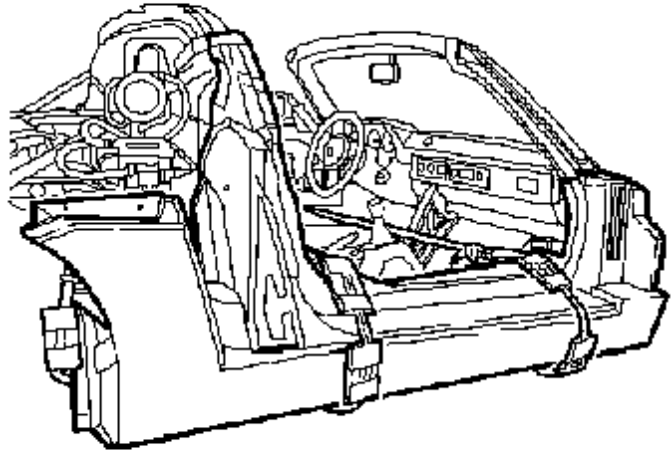


35. Check that new part fits
 - Offer up and correct if necessary
36. Clean all adhesive areas on vehicle
 - Activator from adhesive pack
37. Prime all adhesive areas on vehicle
 - Primer from adhesive pack
38. Clean all adhesive areas on new part
39. Prime all adhesive areas on new part
40. Detach corner (1) from old part
 - Clamp in vice



Install

41. Remove adhesive residues from window frame corner
42. Clean window frame corner
43. Prime window frame corner
44. Apply adhesive
 - Together **462 cm**, of which on new part **56 cm** when installed
45. Place new part in position
 - 2nd technician required
46. Fix new part in place
 - Fix in place with tensioning straps



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47. Apply adhesive to window frame corner
 - **30 cm**
48. Insert window frame corner and fix in place
49. Attach the ancillary components
 - Door contact switch
 - Sill inner trim
 - Door lock
 - Door seal
50. Install door
 - 4 screws to A-pillar
51. Attach front clamshell
 - see operation "Front Clamshell, Detach and Attach".
52. Attach rear clamshell
 - see operation "Rear Clamshell, Detach and Attach".
53. Cleaning work