

50 - BODY, FRONT

PROCEDURE

- Separate the original joint.

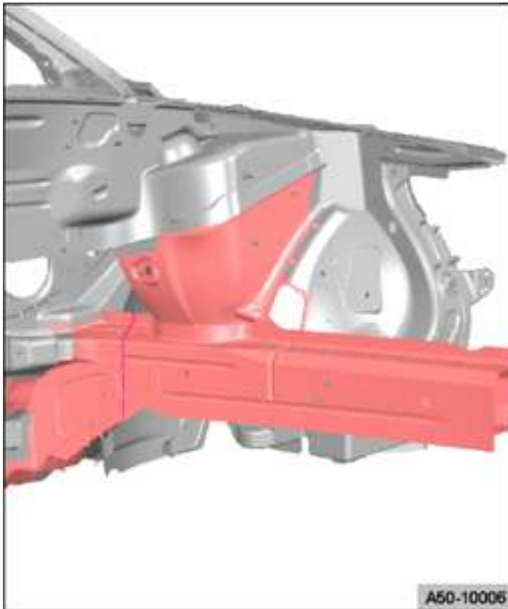


Fig. 43: Separate The Inner Longitudinal Member
Courtesy of VOLKSWAGEN UNITED STATES, INC.

- Separate the inner longitudinal member.

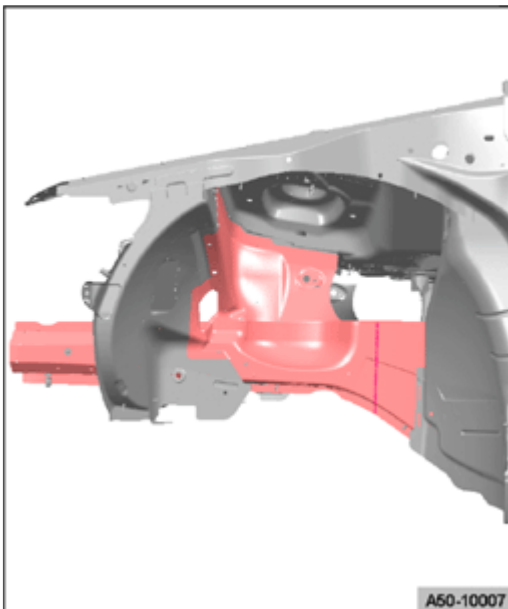


Fig. 44: Separate Outer Longitudinal Member

Courtesy of VOLKSWAGEN UNITED STATES, INC.

- Separate outer longitudinal member.

Replacement parts

- Longitudinal member

Preparing new parts

- Transfer separating cut to new part.

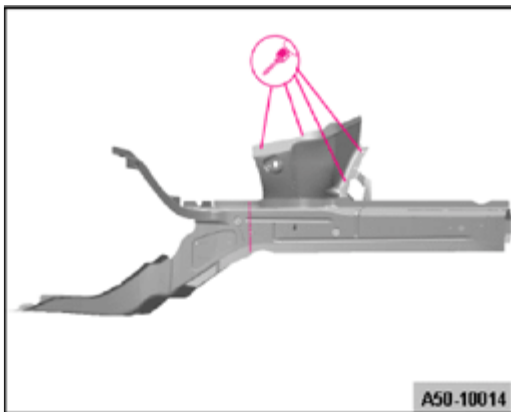


Fig. 45: Drilling Holes For Gas-Shielded Arc Plug Weld Seam, 7 MM
Courtesy of VOLKSWAGEN UNITED STATES, INC.

- Drill holes for gas-shielded arc plug weld seam, 7 mm.

Welding

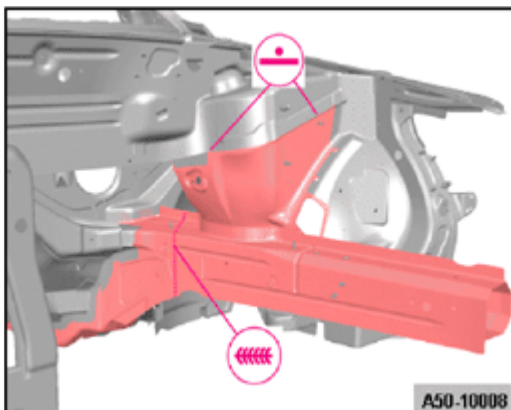


Fig. 46: Welding Longitudinal Member And Separating Cut
Courtesy of VOLKSWAGEN UNITED STATES, INC.

- Install new part using straightening bracket.
- Weld in longitudinal member: Gas-shielded arc plug weld seam.

- Butt weld the separating cut; Gas-shielded arc continuous weld seam.

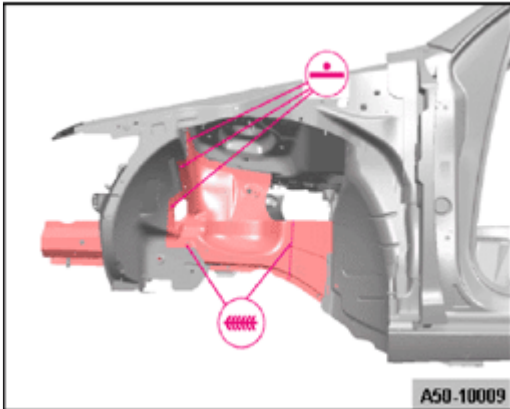


Fig. 47: Welding Remainder Of Joint And Separating Cut
Courtesy of VOLKSWAGEN UNITED STATES, INC.

- Spot weld remainder of joint, Straight-line spot weld seam.
- Spot weld remainder of joint, Straight-line spot weld seam.
- Butt weld the separating cut; Gas-shielded arc continuous weld seam.
- Weld remaining joint in, Gas-shielded arc continuous weld seam.

FRONT LONGITUDINAL MEMBER, PARTIAL SECTION

Procedure

Separating areas

- Cut out longitudinal member.

NOTE:

- **Separating cut must be a straight line.**

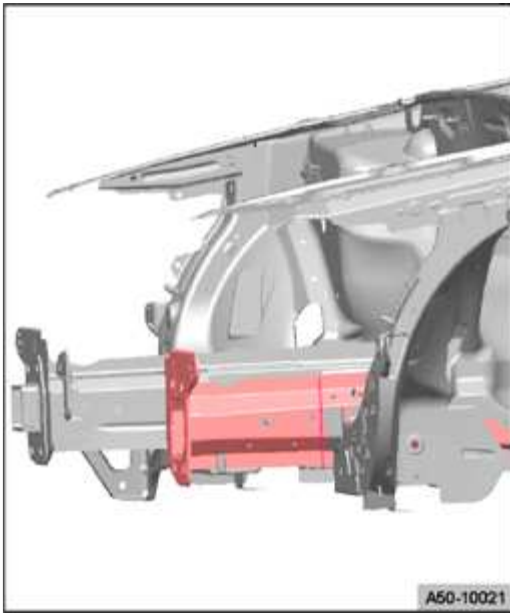


Fig. 48: Identifying Separating Cut For Front Longitudinal Member
Courtesy of VOLKSWAGEN UNITED STATES, INC.

Replacement part

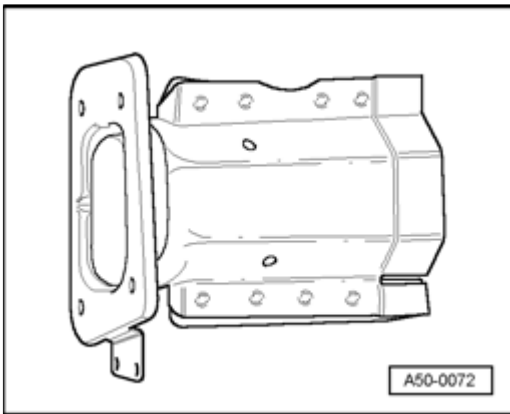


Fig. 49: Front Longitudinal Member, Partial Replacement - Replacement Part
Courtesy of VOLKSWAGEN UNITED STATES, INC.

- Longitudinal member (sub-part)

Welding

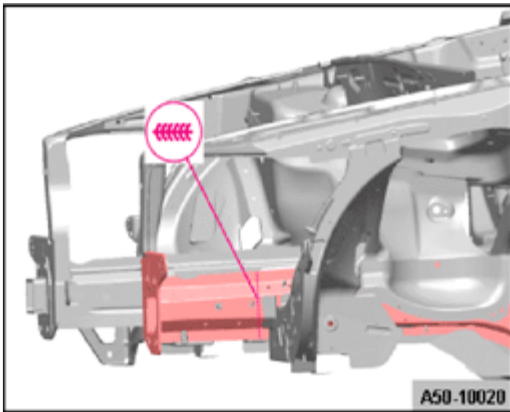


Fig. 50: Matching Length To Body Side

Courtesy of VOLKSWAGEN UNITED STATES, INC.

- If necessary, match the length to the body side.

NOTE:

- Align the longitudinal member with lock carrier, crossmember and headlight to bumper.
- Weld in front longitudinal member, Gas-shielded arc continuous weld seam, 8 x 15 mm.
- Seal off the seam area.

UPPER OUTER LONGITUDINAL MEMBER, REPLACING

Upper outer longitudinal member, replacing

- Separate the original joint.

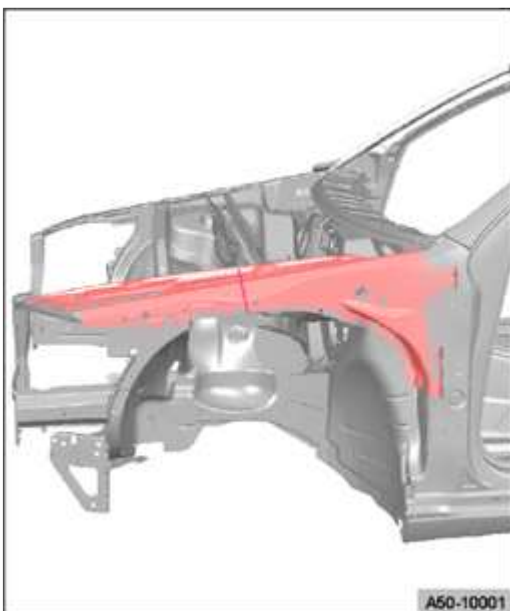


Fig. 51: Making Separating Cut Based On Extent Of Damage
 Courtesy of VOLKSWAGEN UNITED STATES, INC.

- Make separating cut based on extent of damage

Replacement part

- Upper outer longitudinal member

New part preparation

- Transfer separating cut to new part.

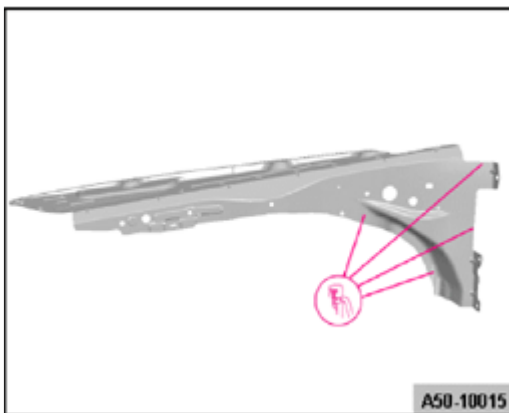


Fig. 52: Punching Holes For Gas-Shielded Arc Plug Weld Seam
 Courtesy of VOLKSWAGEN UNITED STATES, INC.

- Punch holes for gas-shielded arc plug weld seam, 7 mm.

Welding

- Weld the separating cut, Gas-shielded arc continuous weld seam.
- Weld in new part, Straight-line spot weld seam.

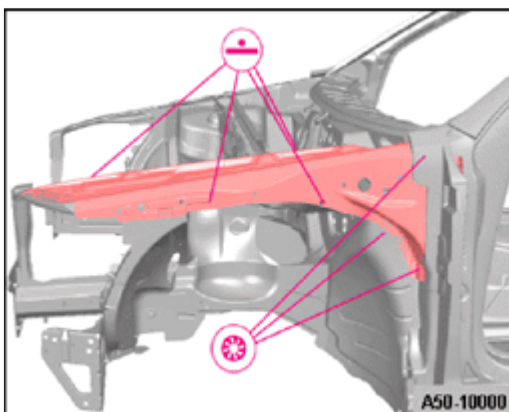


Fig. 53: Gas-Shielded Arc Plug Weld Seam

Courtesy of VOLKSWAGEN UNITED STATES, INC.

- Weld in new part; Gas-shielded arc plug weld seam.

UPPER INNER LONGITUDINAL MEMBER, REPLACING

Procedure

- Upper outer longitudinal member already removed.
- Separate the original joint.

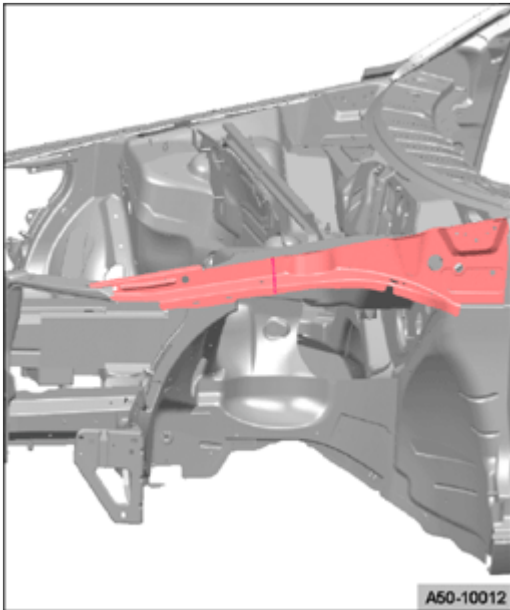


Fig. 54: Making Separating Cut Based On Extent Of Damage
Courtesy of VOLKSWAGEN UNITED STATES, INC.

- Make separating cut based on extent of damage.

Replacement part

- Upper inner longitudinal member

Preparing new parts

- Pierce new part for gas-shielded arc plug weld seam

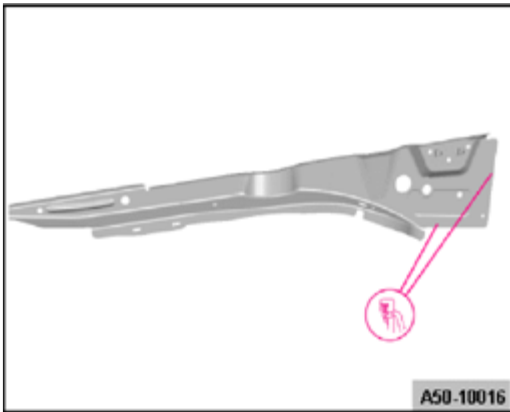


Fig. 55: Transferring Separating Cut To New Part
Courtesy of VOLKSWAGEN UNITED STATES, INC.

- Transfer separating cut to new part.

Welding

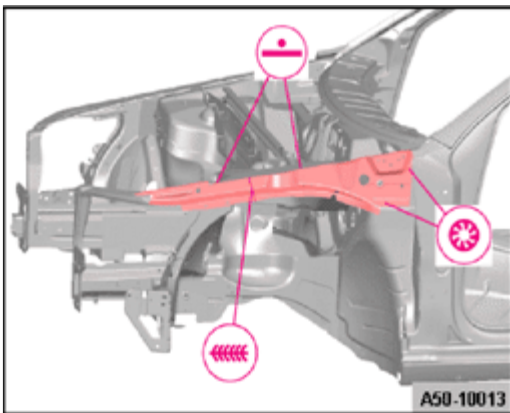


Fig. 56: Identifying Welding Points
Courtesy of VOLKSWAGEN UNITED STATES, INC.

- Weld in longitudinal member; Gas-shielded arc plug weld seam.
- Butt weld the separating cut; Gas-shielded arc continuous weld seam.
- Spot weld remainder of joint, Straight-line spot weld seam.

IMPACT ABSORBER PLATE, REPLACING

Procedure

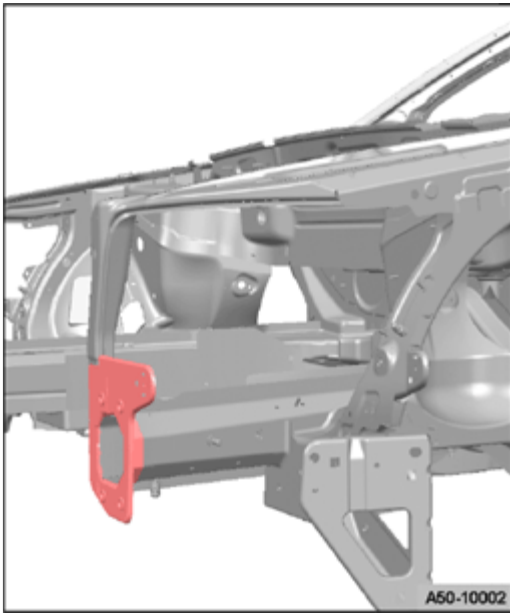


Fig. 57: Separating Original Joint
Courtesy of VOLKSWAGEN UNITED STATES, INC.

- Separate the original joint.

Replacement part

- Impact absorber plate

Welding

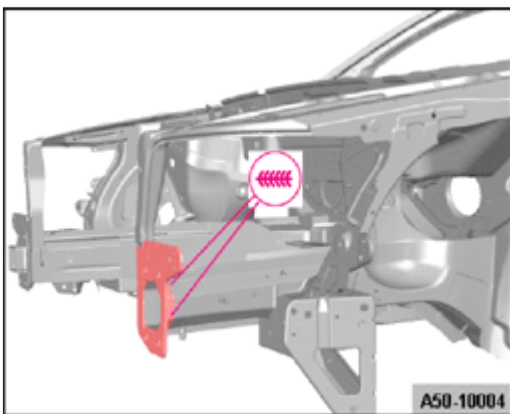


Fig. 58: Welding In Impact Absorber Plate, Straight-Line Spot Weld Seam
Courtesy of VOLKSWAGEN UNITED STATES, INC.

- Weld in impact absorber plate, straight-line spot weld seam.

HEADLIGHT MOUNT, REPLACING

Procedure

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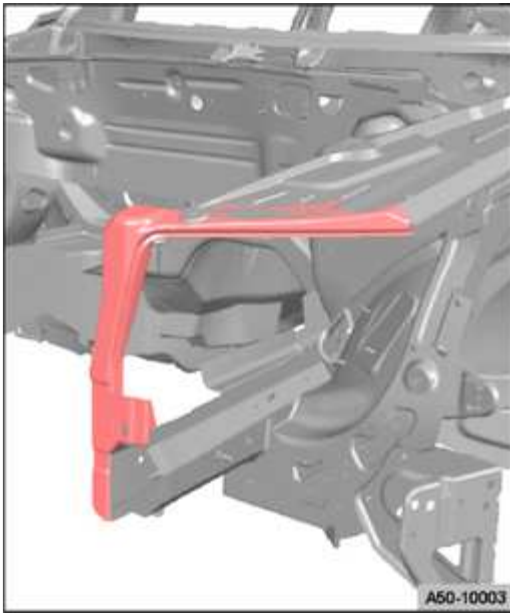


Fig. 59: Identifying Headlight Mount
Courtesy of VOLKSWAGEN UNITED STATES, INC.

- Separate the original joint.

Replacement part

- Headlight mount

Welding

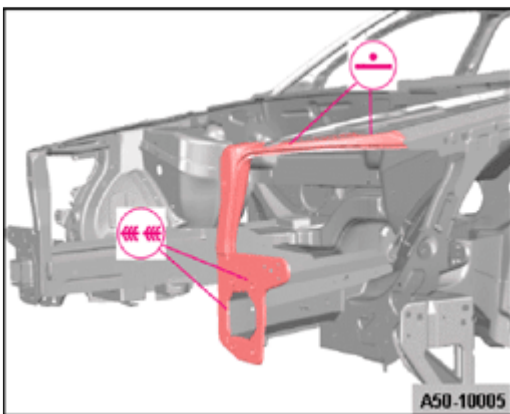


Fig. 60: Welding In New Part, Straight-Line Spot Weld Seam
Courtesy of VOLKSWAGEN UNITED STATES, INC.

- Weld in new part, Straight-line spot weld seam.

PLENUM CHAMBER, REPLACING

Plenum chamber, replacing

NOTE:

- Plenum chamber can only be replaced completely due to strength reasons.
- Upper longitudinal member already removed.

Procedure

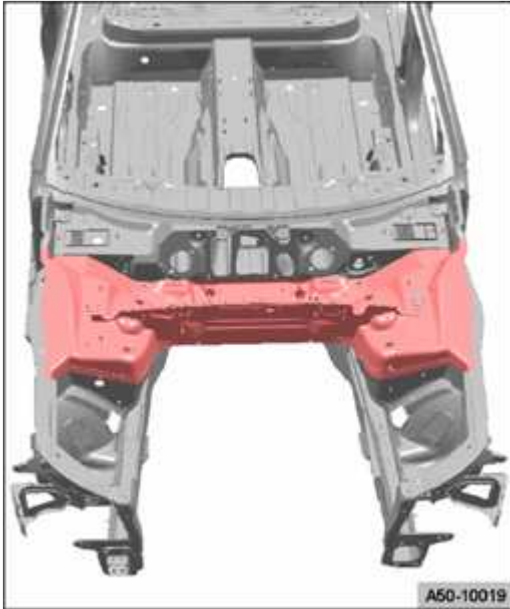


Fig. 61: Identifying Plenum Chamber
Courtesy of VOLKSWAGEN UNITED STATES, INC.

- Separate the original joint.

Replacement part

- Plenum chamber

New part preparation

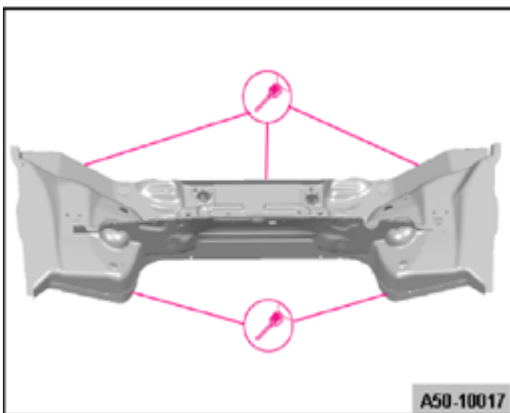


Fig. 62: Punching Holes For Gas-Shielded Arc Plug Weld Seam
Courtesy of VOLKSWAGEN UNITED STATES, INC.

- Punch holes for gas-shielded arc plug weld seam, 7 mm.

Welding

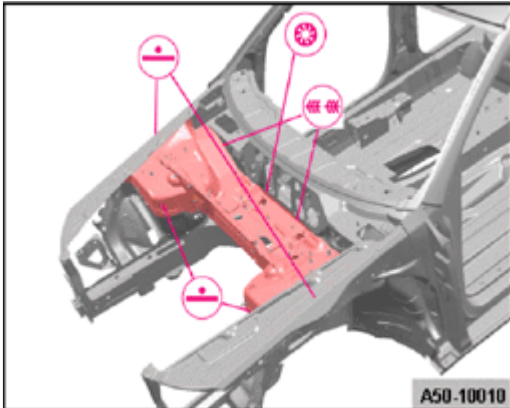


Fig. 63: Welding In New Part
Courtesy of VOLKSWAGEN UNITED STATES, INC.

- Weld in new part, Gas-shielded arc continuous weld seam (staggered).
- Weld in new part, Straight-line spot weld seam.
- Weld in new part; Gas-shielded arc plug weld seam.