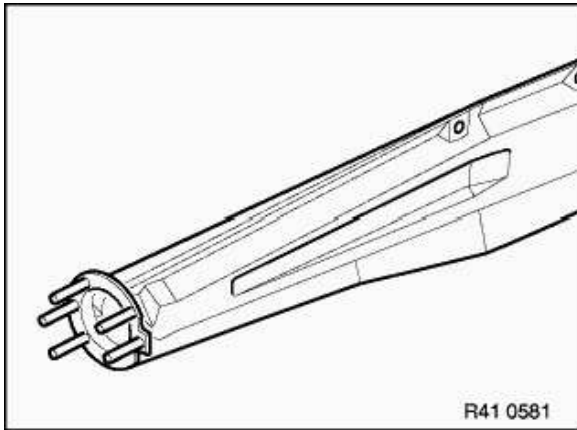


Instructions on body repair,  
refer to 41 00

Z3

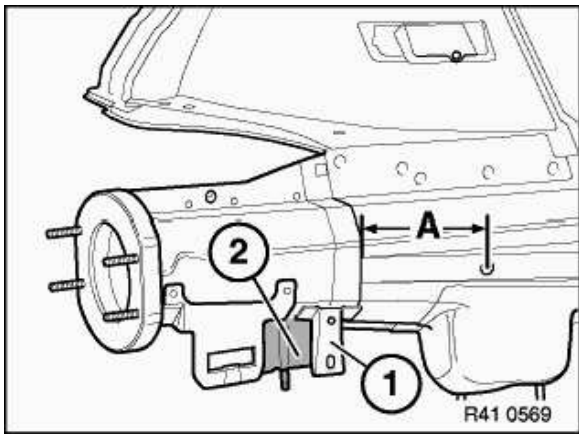
Engine support spare part



Place vehicle on straightening bench.  
Remove or disconnect following parts:

- Complete front bumper
- Complete radiator assembly
- Both headlights complete
- Left and right hood locks
- Front wheel arch trim

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



Remove brackets (1) and (2).

Define and mark out distance from center of 10 mm bore via bracket stabilizer and up to connection point.

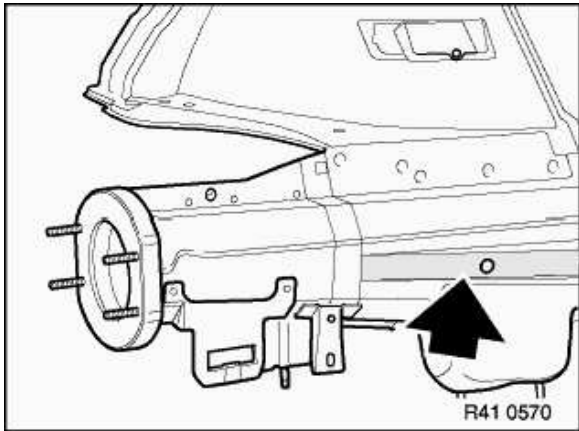
Distance (A) = 130 mm.

Clean connection point.

**Caution!**

Do not cut through both sides of impact absorber support.

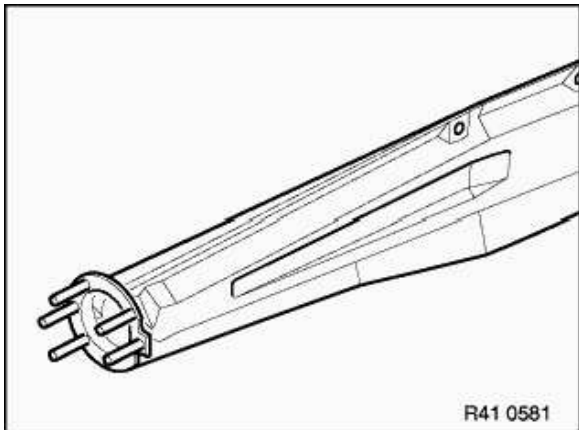
Cut through engine support.



Expose and open up welding points on both sides of reinforcement/impact absorber support.

Remove front section of engine support.

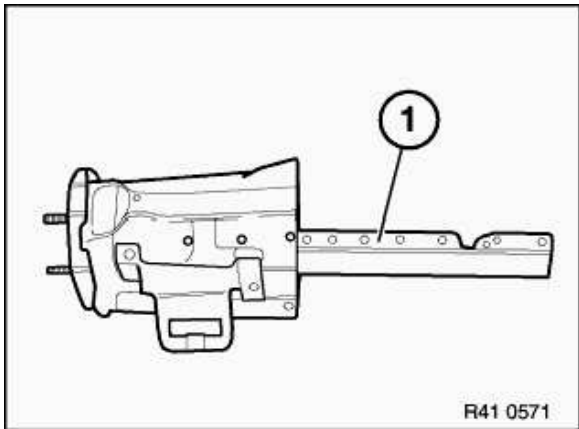
Re-align and grind down connection point.



Cut spare part to size.

Define and mark out distance from center of 10 mm bore via bracket stabilizer and up to connection point.

Distance (A) = 130 mm.



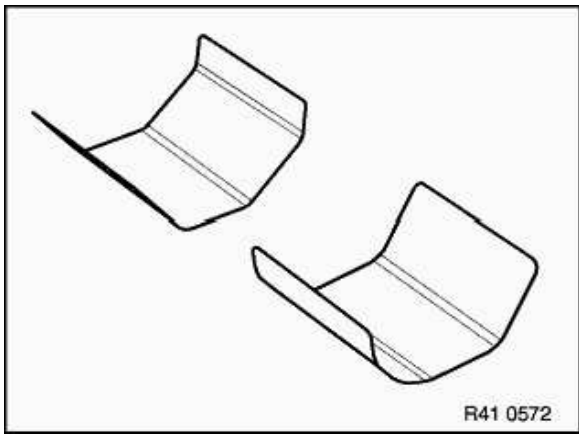
View: Spare part with reinforcement cut to size

**Caution!**

Do not cut reinforcement/impact absorber support (1).

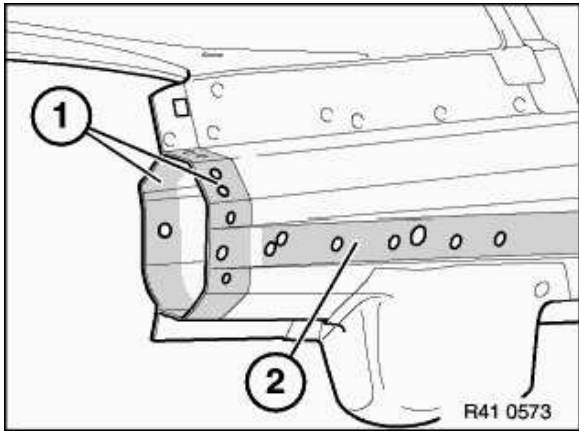
Separate the replacement part.

Open up welding points on reinforcement/impact absorber support and remove front section of engine support with reinforcement/impact absorber support.



Make reinforcement plate from surplus sheet metal and adjust to fit.

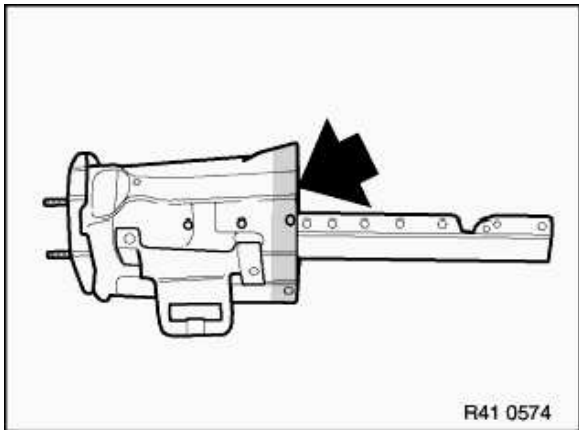
Width = 60 mm



Drill holes in engine support for plug welding with reinforcement plates.

1 = Holes for plug welding reinforcement plates.

2 = Holes for plug welding reinforcement plate/impact absorber support.

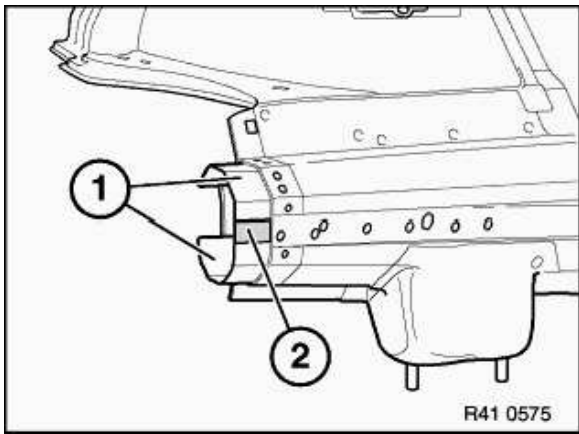


Clean connection surfaces of spare part.

Drill holes in spare part for plug welding reinforcement plates.

Clean reinforcement plates and connection surfaces on engine support and spare part.

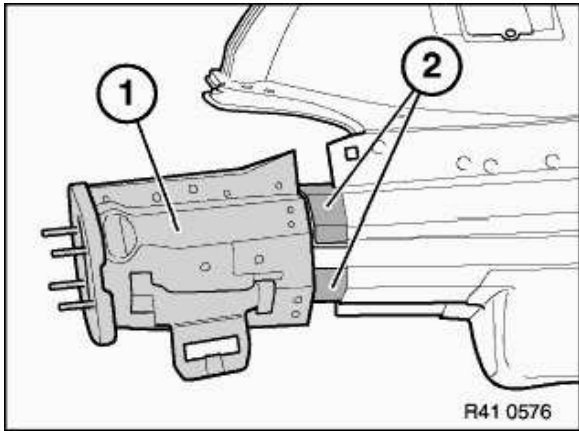
Coat contact surfaces with zinc dust paint.



**Caution!**

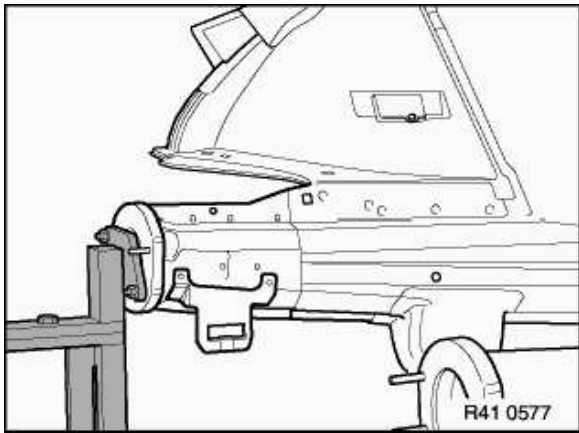
Note space required for reinforcement/impact absorber support (2).

Install approx. 30 mm of reinforcement plate (1) and weld into place.

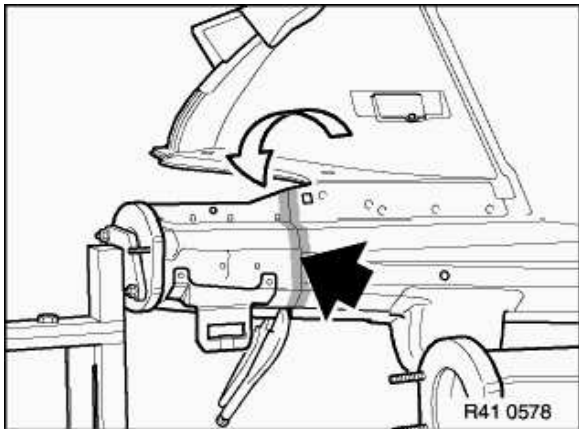


Install spare part (1) with reinforcement/impact absorber support.

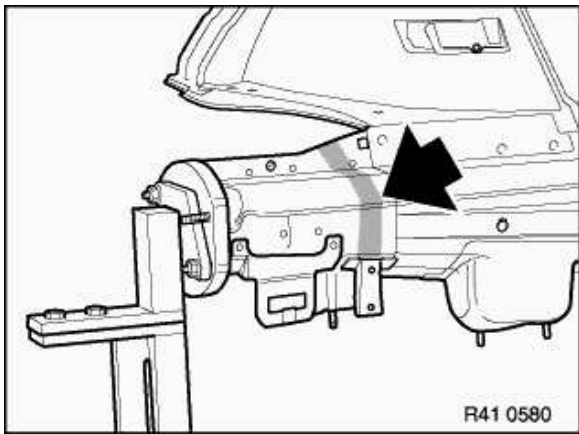
2 = Reinforcement plate



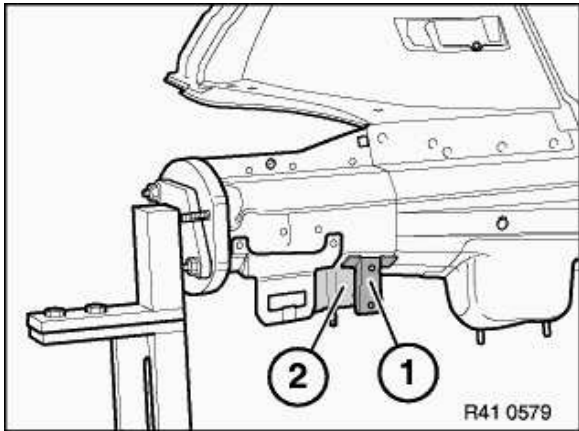
Adjust spare part with straightening angle set to fit and secure. Plug-weld reinforcement plate.



Weld spare part all round.



Grind down welded surfaces and, if necessary, open up any blocked bores.



Clean contact surfaces on brackets (1) and (2).  
Adjust brackets (1) and (2) to fit, secure and grind down.  
Grind down welded surfaces.

Tin out and grind down contact surfaces.