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Model

320 i

320 i A

Impact Absorbers

Front Bumper Impact Absorber

H (stroke) mm (in.) 60 (2.362)

Length A / B / C / D / E mm (in.) 392 (15.433)/241 (9.488)/44 (1.732)/40.15 (1.581)/15 (0.590)

Distance from body mounting bore to body mounting bore mm (in.) 178 ± 0.5 (7.008 ± 0.020)

Color code white



Rear Bumper Impact Absorber

H (stroke) mm (in.) 72 (2.835)

Length A / B / C / D / E mm (in.) 340 (13.386)/243 (9.567)/44 (1.732)/40.15 (1.581)/15 (0.590)

Distance from centerline of frame mounting bore to centerline of body mounting bore mm (in.) 217.5 ± 0.5 (8.563 ± 0.020)

Color Code yellow

a) Front Bumper with Impact Absorber

Impact absorber to holder (M 14) 16 ... 20 / 1.6 ... 2.0 (12 ... 14)

Absorber holder to center bumper (M 8) 20 / 2.0 (14)

Absorber to body (M 10) 49 / 4.9 (35)

Absorber to body (M 8) 6 / 0.6 (4.3)

Guard to bumper (M 6) 6 / 0.6 (4.3)

Bumper side to center section (M 6) 6 / 0.6 (4.3)

Bumper side to body (M 6) 3 / 0.3 (2.2)

Trim to body (B 4.2) 3 / 0.3 (2.2)

Torque Specifications in Nm / kpm (ft. lbs.)

b) Rear Bumper with Impact Absorber

Impact absorber to holder (M 14) 16 ... 20 / 1.6 ... 2.0 (12 ... 14)

Absorber holder to center bumper (M 8) 20 / 2.0 (14)

Absorber to body (M 8) 15 / 1.5 (11)

Absorber to body (M 14) 30 / 3.0 (22)

Left or right trim to body (M 6) 6 / 0.6 (4.3)

Right trim to left trim (M 6) 6 / 0.6 (4.3)

Bumper side to center section (M 6) 6 / 0.6 (4.3)

Bumper side to body (M 6) 3 / 0.3 (2.2)

Table of Adhesives, Sealing Compounds and Similar Products

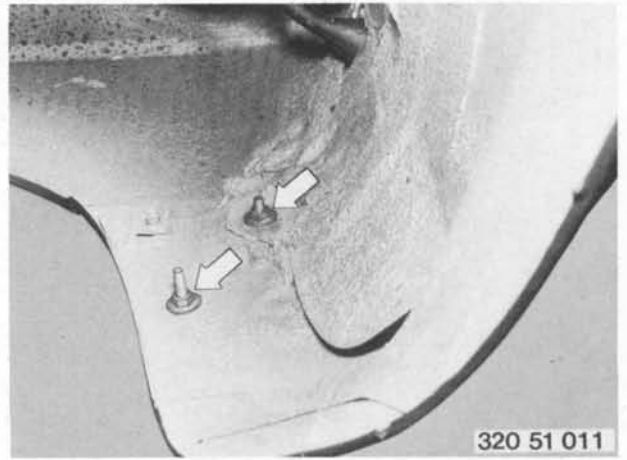
<u>Point of Application</u>	<u>Adhesive</u>
Headliner	Herberts 3150, Tivigum 7361
Velours carpet	Tivigum 7361
Felt strip behind rear seat	Tivigum 7361, Teroson 2444 T
Door seals	Teroson 2444 anthracite
Acella plastic sheet on doors	Teroson 2012
PVC sheet (heat resistant up to 100° C / 212° F)	Terokal transparent
Trunk lining	Tivigum 7361
Windshield	Bostik 2423 P *)
<u>Point of Application</u>	<u>Sealant</u>
Windshield	Terokal 3212 (from Teroson)
Rear Window	Terokal 2322 (from Teroson)
Seams	Terolan 3531
<u>Noise Insulation and Protection Against Flying Stones</u>	<u>Body Compound</u>
Body underside	Terophon 80 light body compound

*) Special solvent for Bostik 2423 P = 746 Haku (from Kluthe)

51 11 000 REMOVING AND INSTALLING FRONT BUMPER

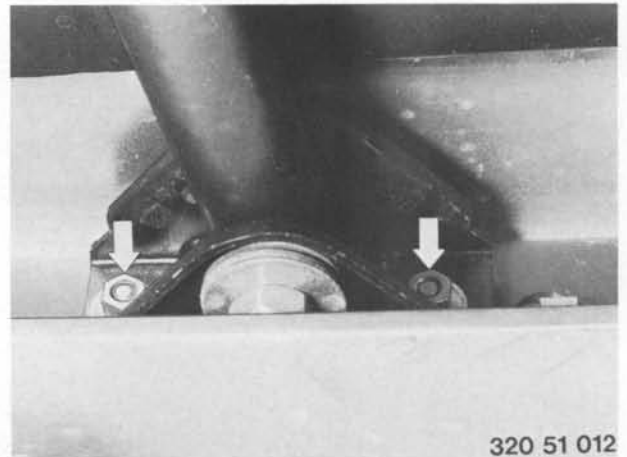
Unscrew nuts in left and right wheelhouses.

Installation Note! Tighten to specified torque¹⁾.



Unscrew left and right nuts at impact absorber and remove bumper.

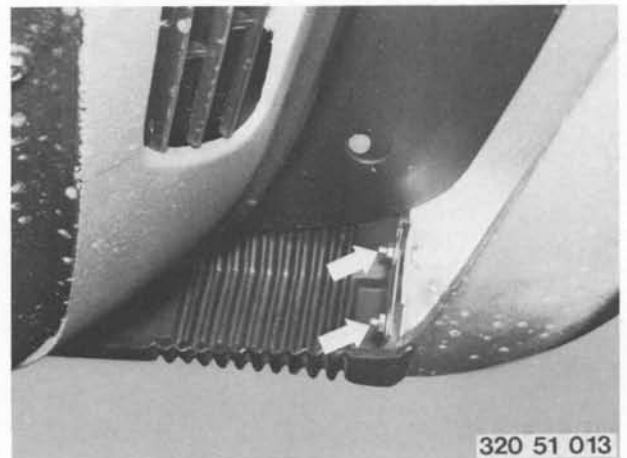
Installation Note! Tighten to specified torque¹⁾.



51 11 010 REMOVING AND INSTALLING FRONT BUMPER
CENTER SECTION

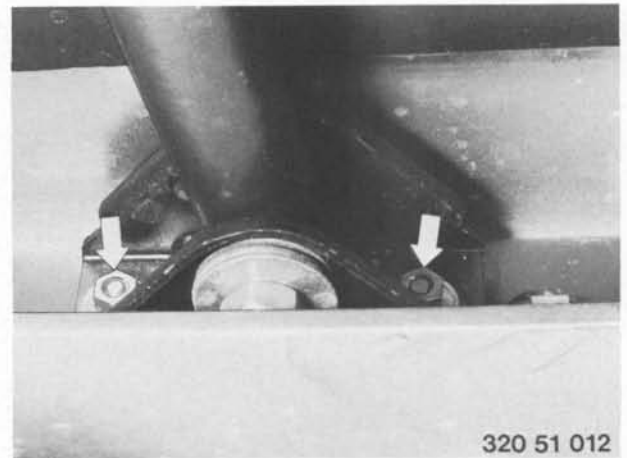
Detach left and right bumper side sections at center section.

Installation Note! Tighten to specified torque¹⁾.



Unscrew left and right nuts at impact absorber and remove bumper center section.

Installation Note! Tighten to specified torque¹⁾.



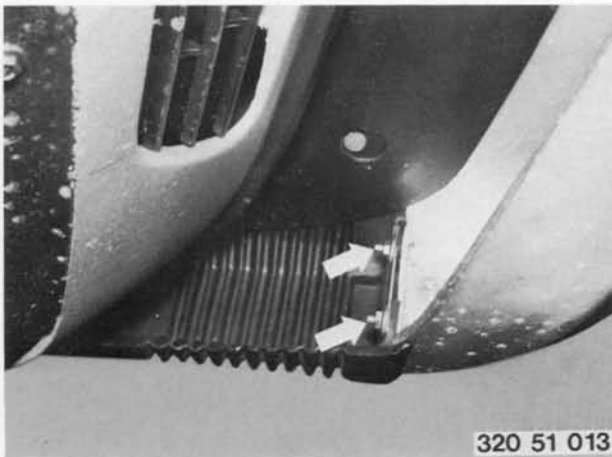
1) See Specifications.



51 11 070 REMOVING AND INSTALLING FRONT BUMPER SIDE SECTION

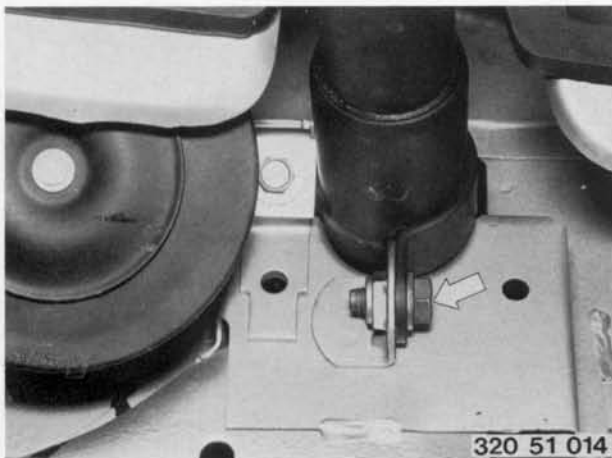
Unscrew nuts in wheelhouse.

Installation Note! Tighten to specified torque¹⁾.



Detach bumper side section at bumper center section.

Installation Note! Tighten to specified torque¹⁾.



51 11 163 REPLACING BOTH FRONT BUMPER STRUTS

Remove and install front bumper - 51 11 000.

Detach bottom grille parts.

Remove bolt.

Installation Note! Tighten to specified torque¹⁾.



Detach strut at body.

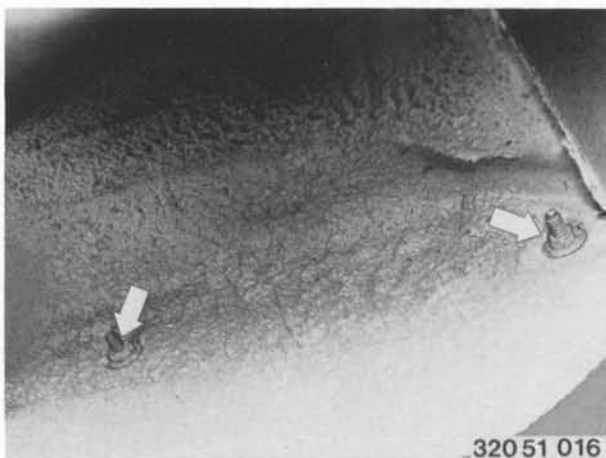
Installation Note! Tighten to specified torque¹⁾.

1) See Specifications

51 12 000 REMOVING AND INSTALLING REAR BUMPER

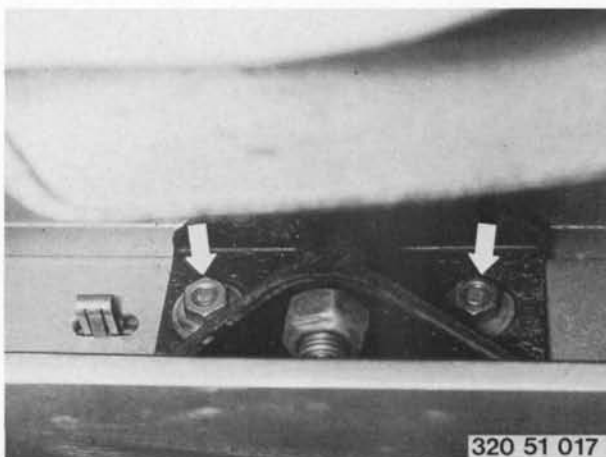
Detach left and right bumper side sections in wheel-houses.

Installation Note! Tighten to specified torque¹⁾.



Unscrew left and right nuts on impact absorber and remove bumper.

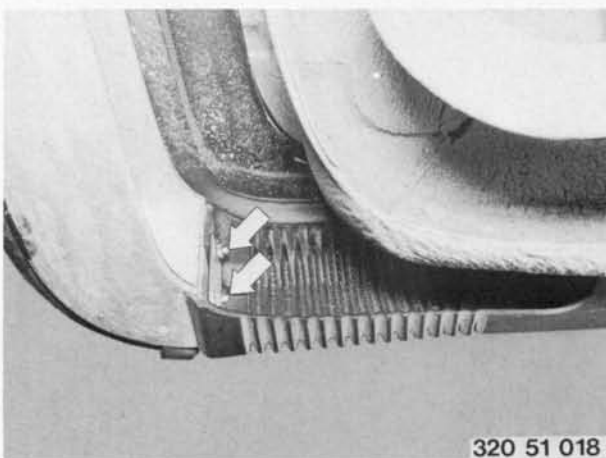
Installation Note! Tighten to specified torque¹⁾.



51 12 010 REMOVING AND INSTALLING REAR BUMPER CENTER SECTION

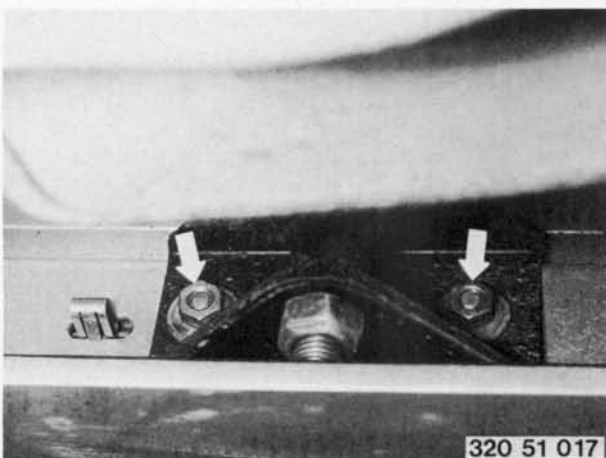
Detach left and right bumper side sections at bumper center section.

Installation Note! Tighten to specified torque¹⁾.

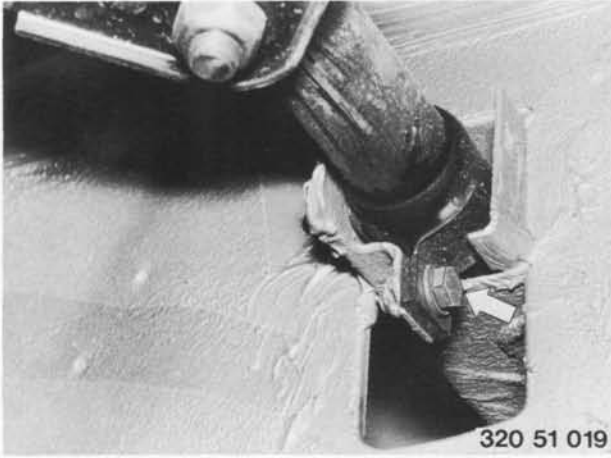


Unscrew left and right nuts on impact absorber and remove bumper center section.

Installation Note! Tighten to specified torque¹⁾.



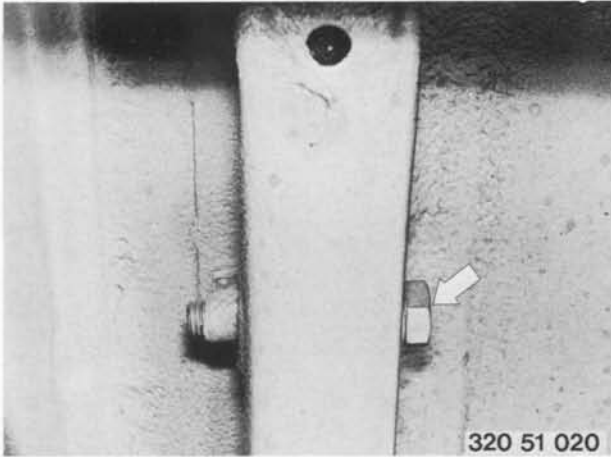
1) See Specifications



51 12 170 REPLACING REAR BUMPER STRUT

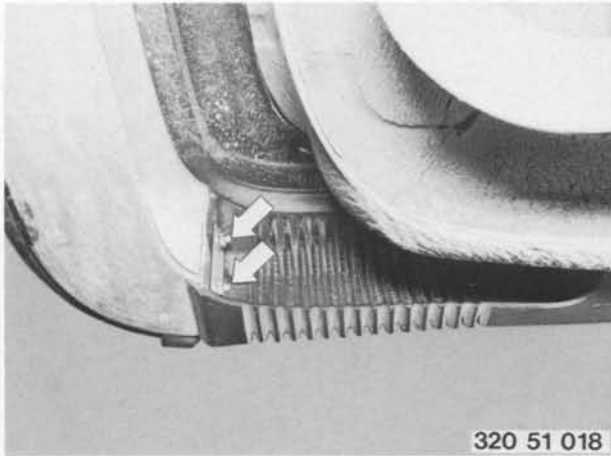
Remove and install rear bumper - 51 12 000.
Remove bolt.

Installation Note! Tighten to specified torque¹⁾.



Detach strut at body.

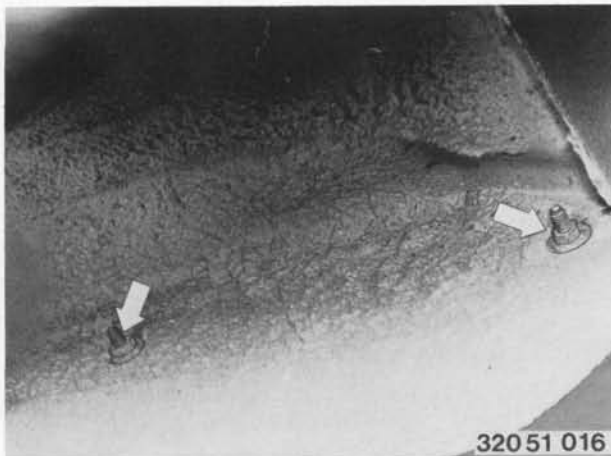
Installation Note! Tighten to specified torque¹⁾.



51 12 200 REMOVING AND INSTALLING REAR BUMPER SIDE SECTION

Detach bumper side section at bumper center section.

Installation Note! Tighten to specified torque¹⁾.



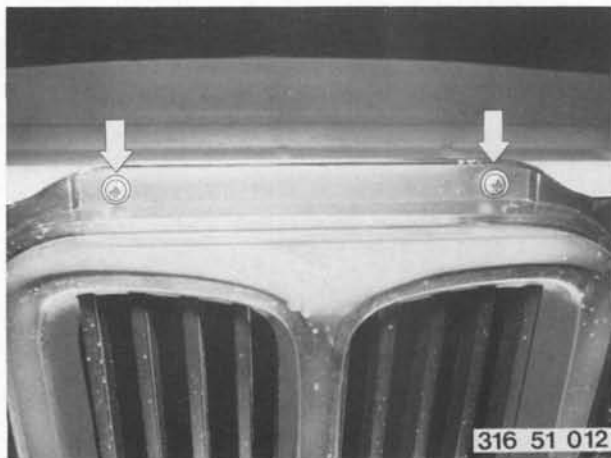
Unscrew nuts in wheelhouse and remove bumper side section.

Installation Note! Tighten to specified torque¹⁾.

1) See Specifications

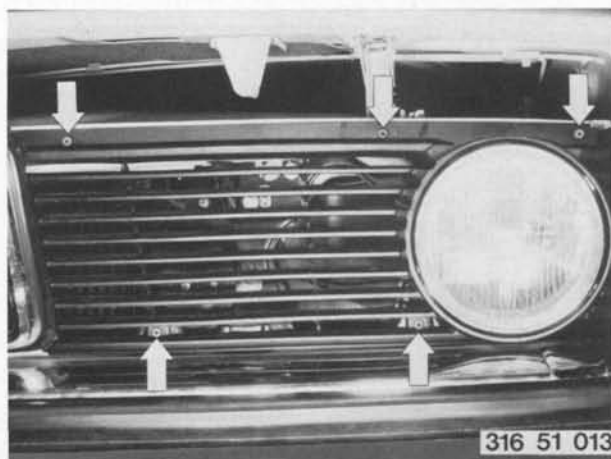
51 13 000 REMOVING AND INSTALLING CENTER FRONT GRILLE

Release engine hood lock, loosen screws and remove center front grille.



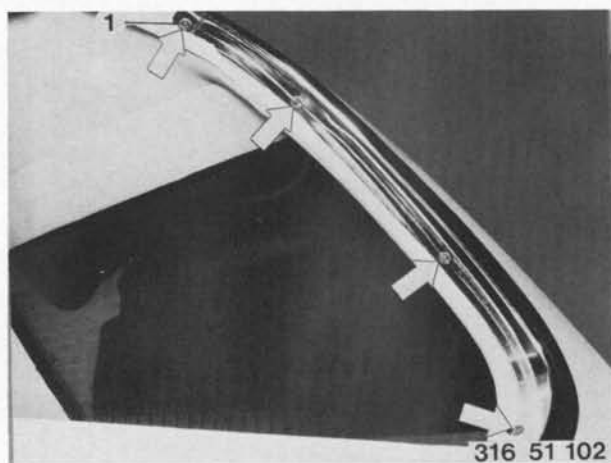
51 13 040 REMOVING AND INSTALLING SIDE FRONT GRILLE

Remove and install front turn signal - 63 13 180. Loosen screws and remove side front grille.

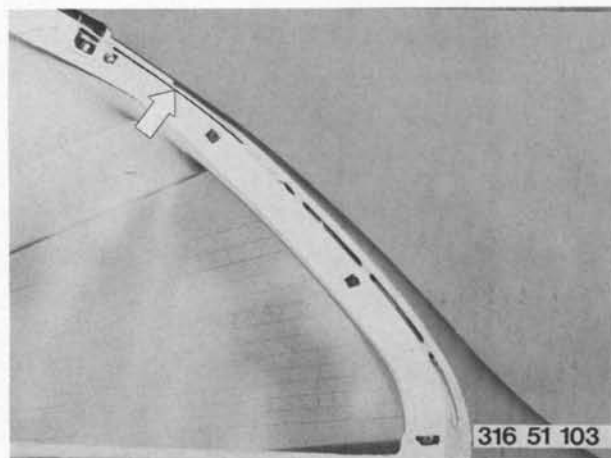


51 13 333 REMOVING AND INSTALLING REAR AIR OUTLET TRIM

Remove and install rear side window - 51 36 050. Loosen screw (1) and slide sleeve forward. Loosen remaining screws and take off trim.

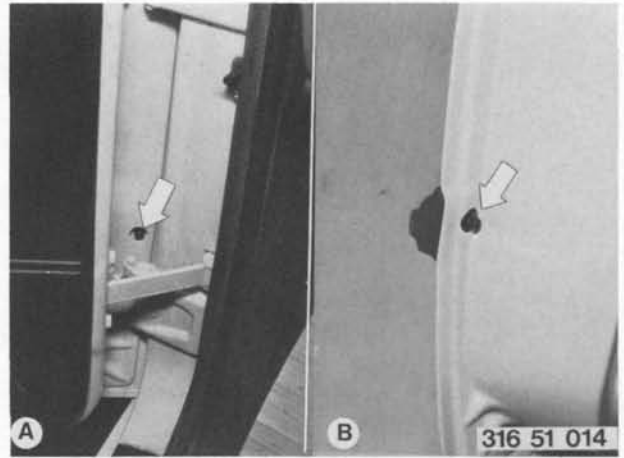


Installation Note! Place Terastat cord along outer edge.



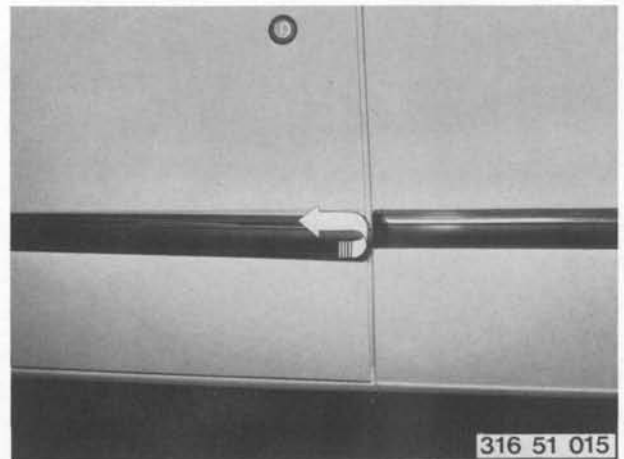
51 15 330 REMOVING AND INSTALLING FRONT DOOR RUBBING STRIP

Unscrew cap nuts.
A = front
B = rear

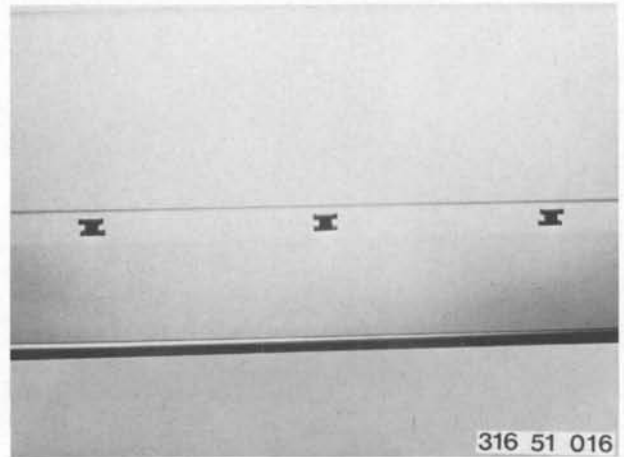


Lift rubbing strip out of clips.

Installation Note! Bevelled outer edges must be parallel to outer edges of adjacent rubbing strip.



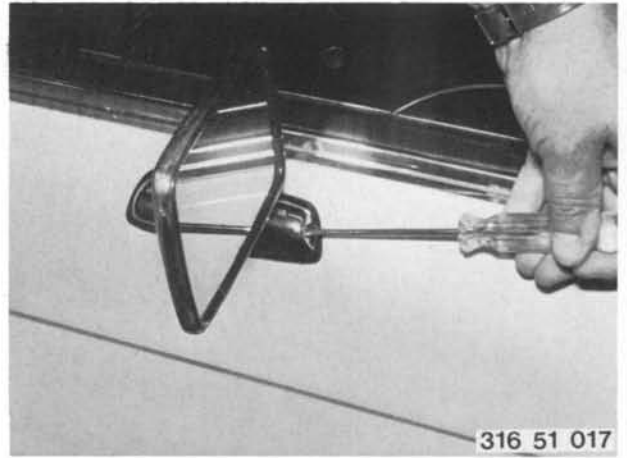
Installation Note! Check clips, replace if necessary.



51 16 000 REMOVING AND INSTALLING FRONT DOOR REAR VIEW MIRROR

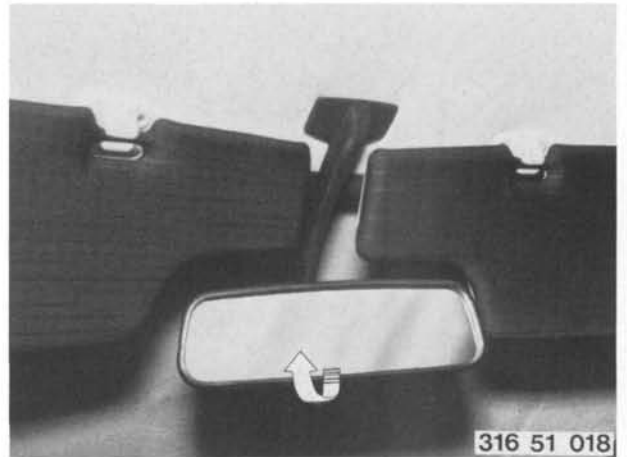
Bend away rubber cover.
Loosen screw and remove mirror.

Installation Note! Make sure that rubber liner fits properly.



51 16 060 REMOVING AND INSTALLING INTERIOR REAR VIEW MIRROR

Pull off mirror toward rear.

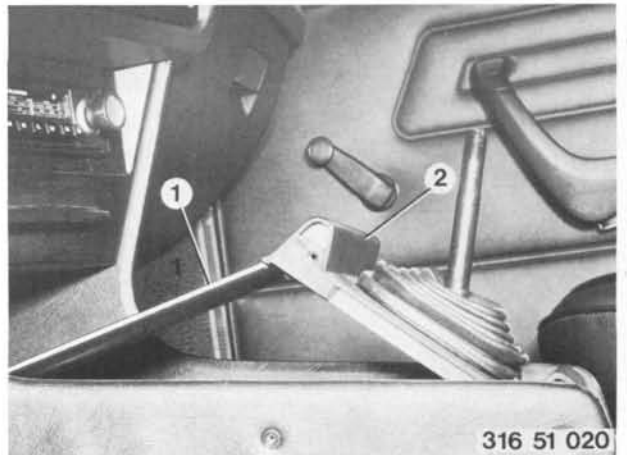


51 16 200 REMOVING AND INSTALLING SHELF

Unscrew screws (1 and 2) on left and right-hand sides.



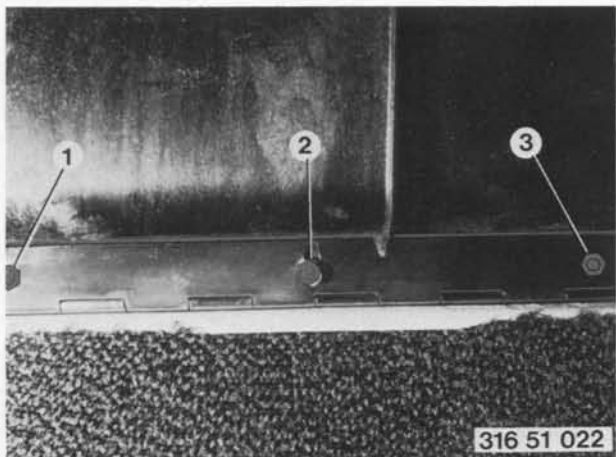
Unscrew selector lever knob.
Remove shelf floor (1) and selector lever cover (2).





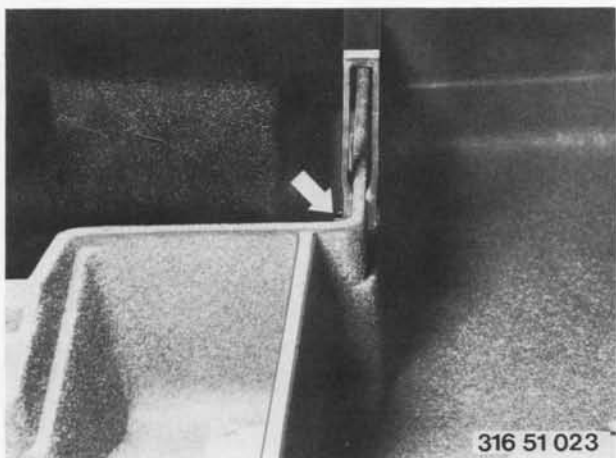
Unscrew nut and remove bracket.
Disconnect ashtray light plug.
Remove shelf downward.

Note! If car has radio, also disconnect antenna cable, ground strap, live wire and loudspeaker wire.



51 16 360 REMOVING AND INSTALLING GLOVE COMPARTMENT

Unscrew screws (1 ... 3).



Press left and right plastic rivets together and pull out.
Remove glove compartment.

51 21 000 REMOVING AND INSTALLING FRONT DOOR CATCH

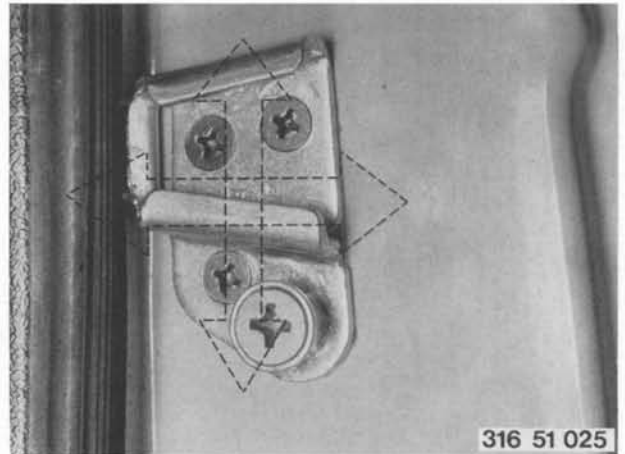
Remove and install rear left side trim - 51 43 000.
Mark position of door catch with a pencil.
Loosen all door catch screws.

Caution! Hold threaded plate.



Installation Note! Tighten door catch screws slightly and align catch with door lock. Align door catch that when door is closed the outer door panel surface is about 1 mm (0.040") further out than rear side panel surface.

Use shim, if necessary.

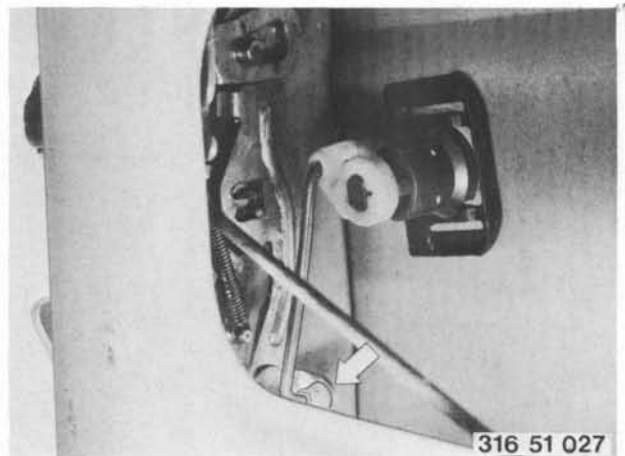


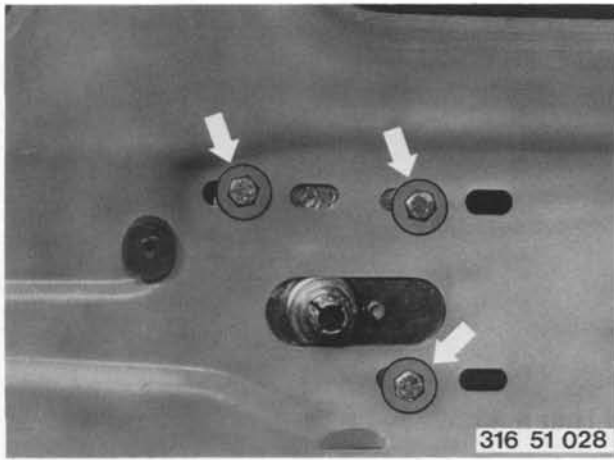
51 21 090 REMOVING AND INSTALLING DOOR LOCK

Remove and install door trim - 51 41 000.
Take off Acella plastic sheet to an extent as required.
Loosen rear window guide rail mounting screw.
Pull window guide out of window guide rail partially and remove window guide rail by pulling down.

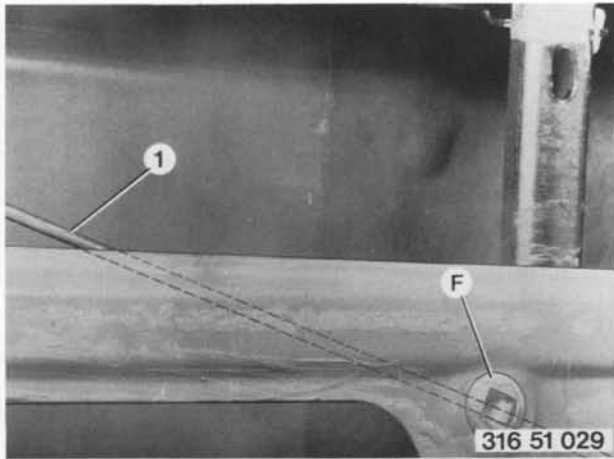


Lift out operating linkage between door lock and lock cylinder.

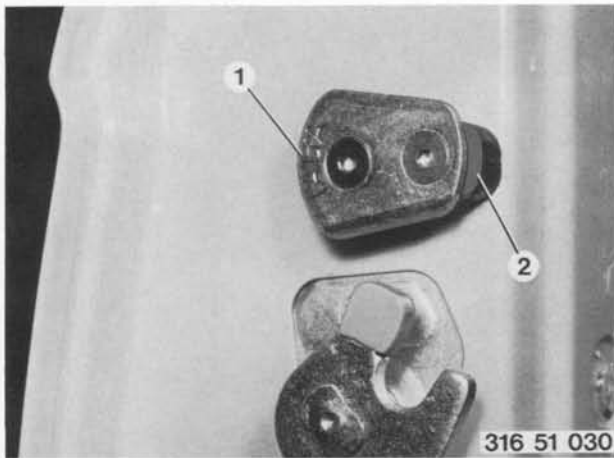




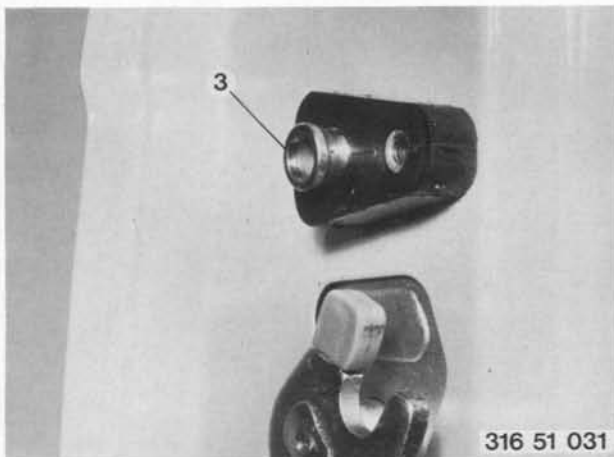
Loosen door lock remote control mounting screws.



Detach connecting rod (1) at guide clip (F).

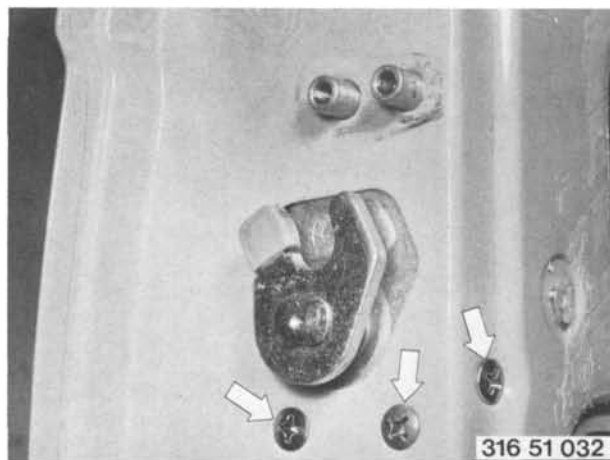


Loosen screws. Remove clamp plate (1) and guide pad (2).



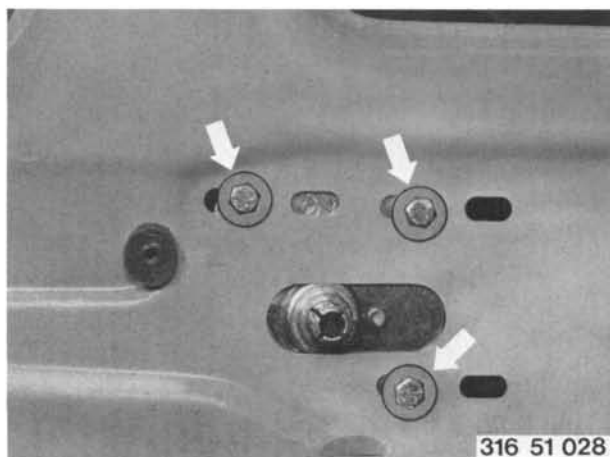
Installation Note! Place bushing (3) in guide pad.

Shut rotary striker.
Loosen screws.
Detach lock remote control and remove door lock.



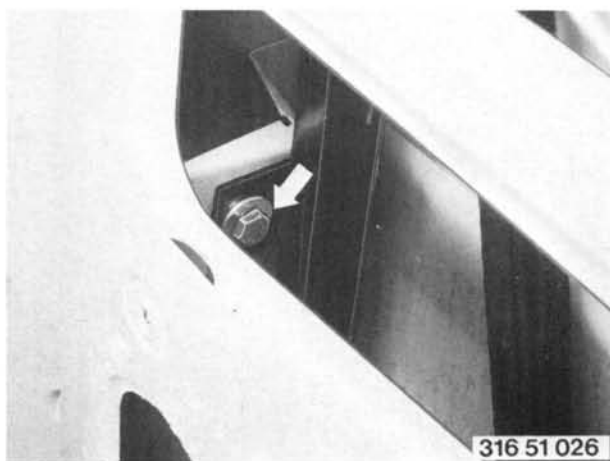
51 21 120 REMOVING AND INSTALLING LOCK REMOTE CONTROL

Remove and install door trim - 51 41 000.
Remove Acella plastic sheet to an extent as required.
Loosen screws.
Detach connecting rod.

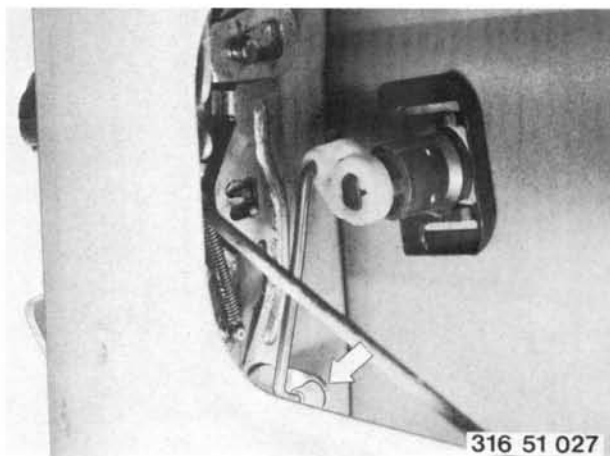


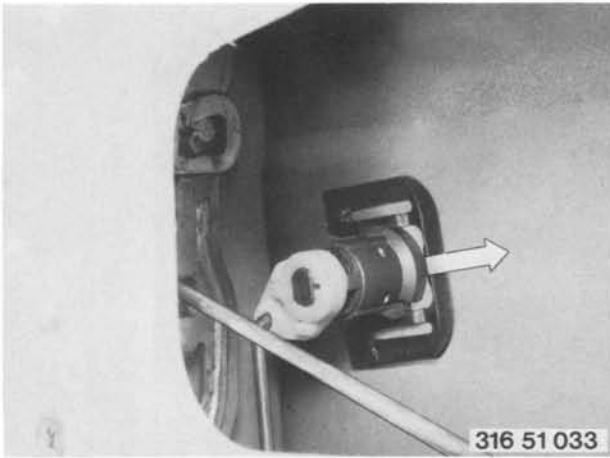
51 21 140 REMOVING AND INSTALLING LOCK CYLINDER

Remove and install door trim - 51 41 000.
Remove Acella plastic sheet to an extent as required.
Loosen rear window guide rail mounting screw.
Pull window guide out of window guide rail partially
and remove window guide rail by pulling down.



Detach operating linkage between door lock and lock cylinder.





Take retainer off of lock cylinder.
Remove lock cylinder outward.

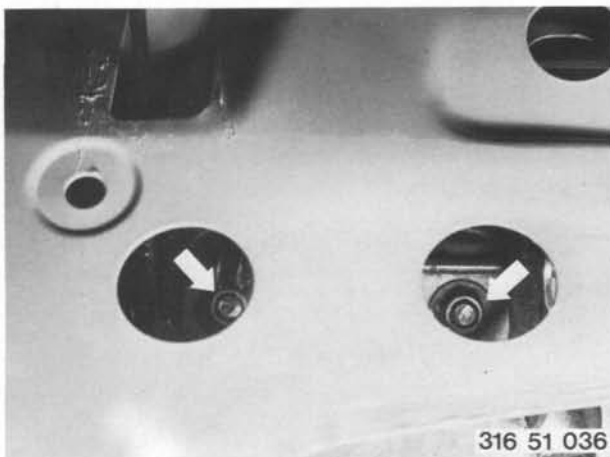


Note key number on removed lock cylinder.



51 21 170 REMOVING AND INSTALLING OUTSIDE HANDLE

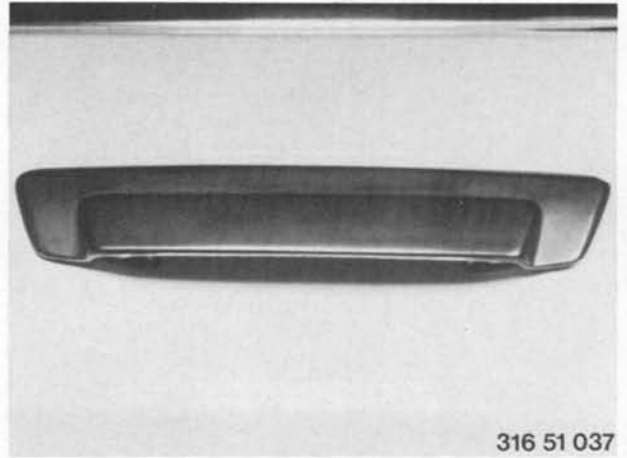
Take outside handle off of lock mechanism.



51 21 200 REMOVING AND INSTALLING OUTSIDE HANDLE
AND LOCK MECHANISM

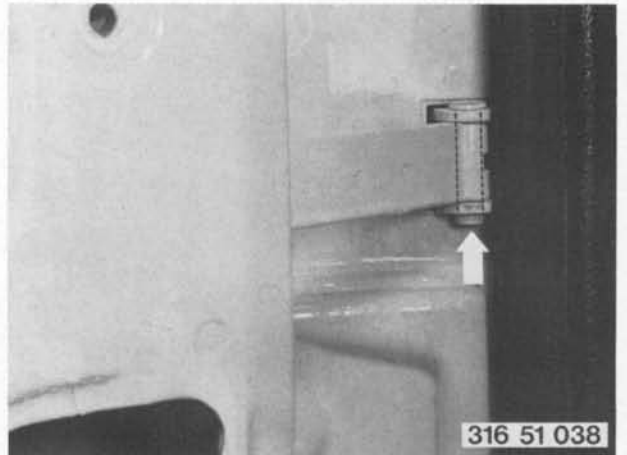
Remove and install outside handle - 51 21 170.
Remove and install door trim - 51 41 000.
Pull off Acella plastic sheet to an extent as
required.
Remove lock mechanism.

Installation Note! Align lock mechanism with outside door handle.

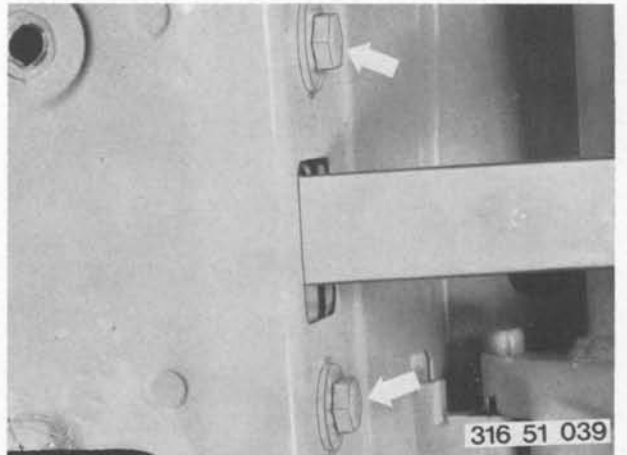


51 21 280 REMOVING AND INSTALLING DOOR RETAINER

Remove and install door trim - 51 41 000.
Pull off Acella plastic sheet to an extent as required.
Drill into door retainer pin from below and remove.
Installation Note! Rivet door retainer pin.



Loosen screws and remove door retainer inward.
Installation Note! Install door retainer in catch 2.



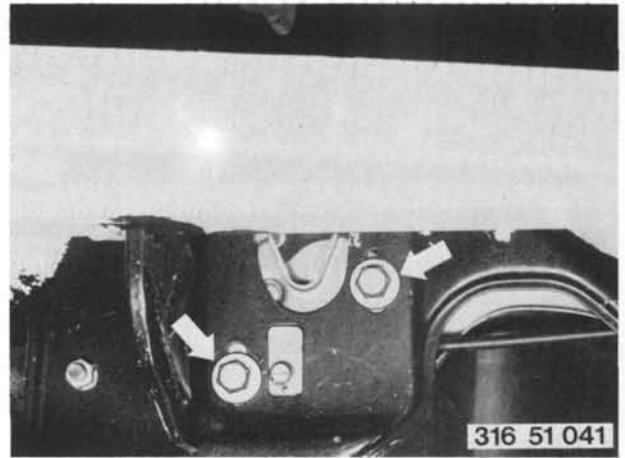
51 21 300 REMOVING AND INSTALLING WINDOW RECESS COVER STRIP

Loosen window recess cover strip by applying light knocks with a hard wooden wedge and remove.
Caution! Cover window frame trim with tape to prevent scratching.

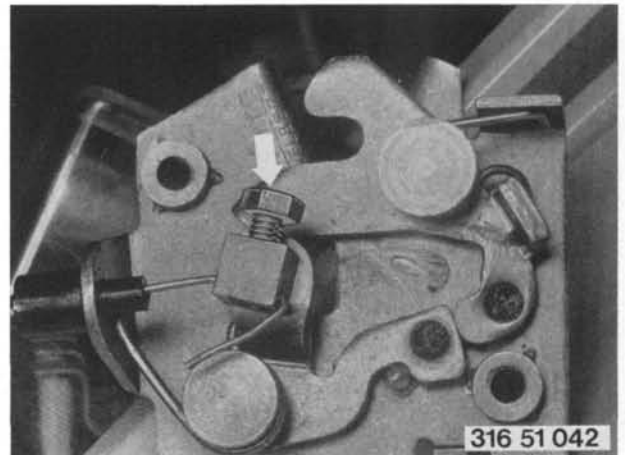


51 23 110 REMOVING AND INSTALLING ENGINE HOOD LOCK

Remove and install front grille - 51 13 010.
Detach cable at lock.
Mark location.
Remove screws.

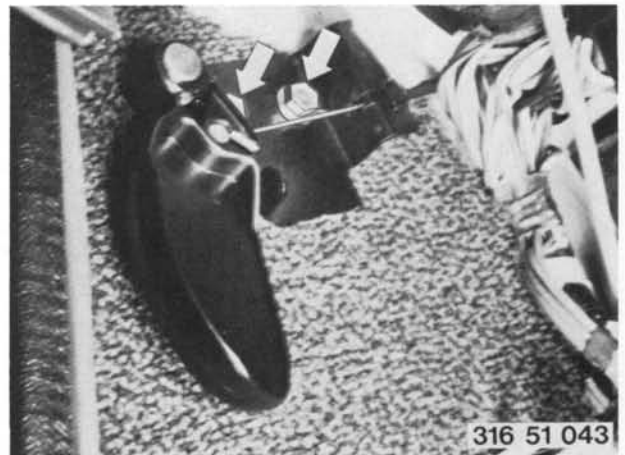


Installation Note! Move engine hood lock operating lever all the way forward and secure cable in this position. Bend protruding end.

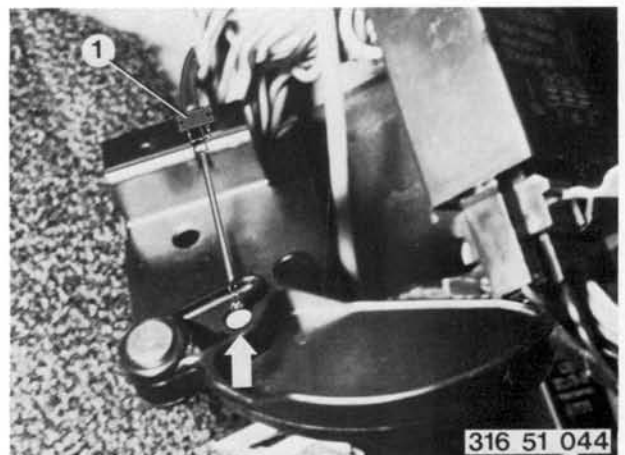


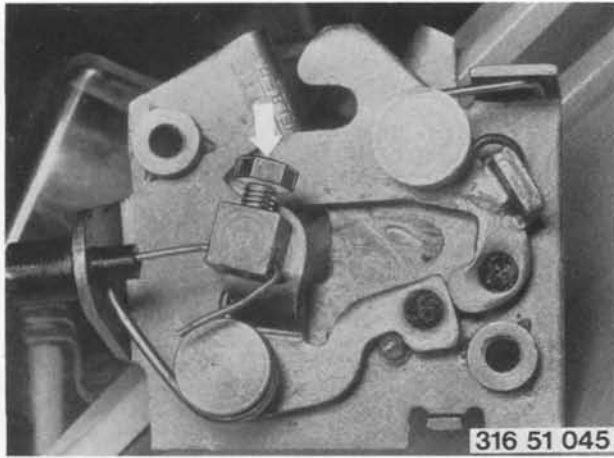
51 23 200 REMOVING AND INSTALLING ENGINE HOOD CATCH
RELEASE LEVER WITH BASE

Detach and attach bottom center instrument panel trim
- 51 45 190.
Loosen screws.



Remove clip (1).
Detach cable at lever.



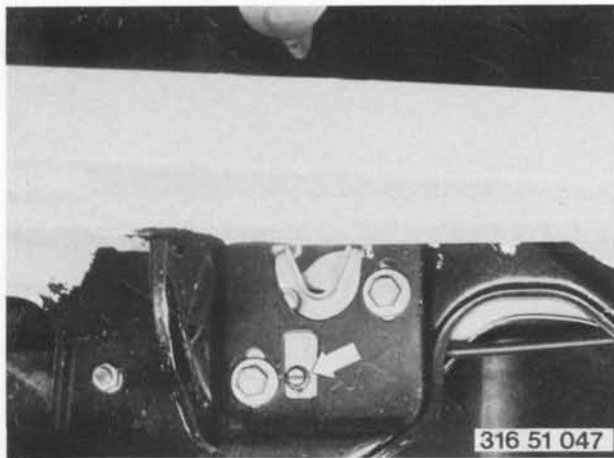


51 23 210 REMOVING AND INSTALLING ENGINE HOOD CATCH
CABLE

Detach and attach bottom center instrument panel trim
- 51 45 190.
Detach cable at lock.



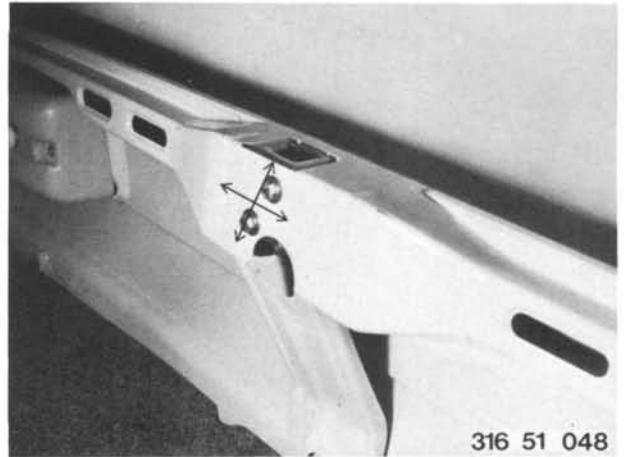
Pull cable out of base, clamp and strap.
Detach cable at lever and pull out through rubber
grommet.



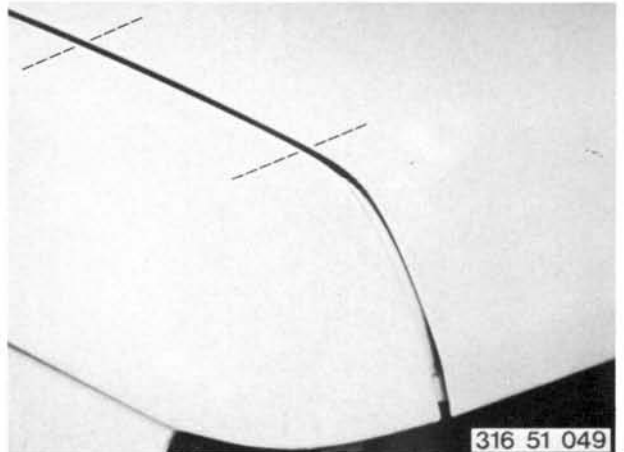
Caution! Should cable tear when closing engine hood,
it can be opened again by loosening the lock screw.

51 24 004 ADJUSTING TRUNK LID CATCH

Loosen screws and adjust lock lower section in slots.



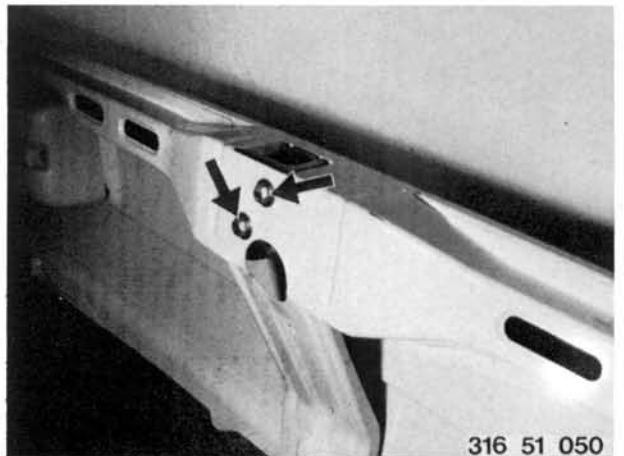
Adjust trunk lid catch that outer edges of trunk lid are in same plane as inner edges of rear side panels.



51 24 050 REMOVING AND INSTALLING TRUNK LID CATCH

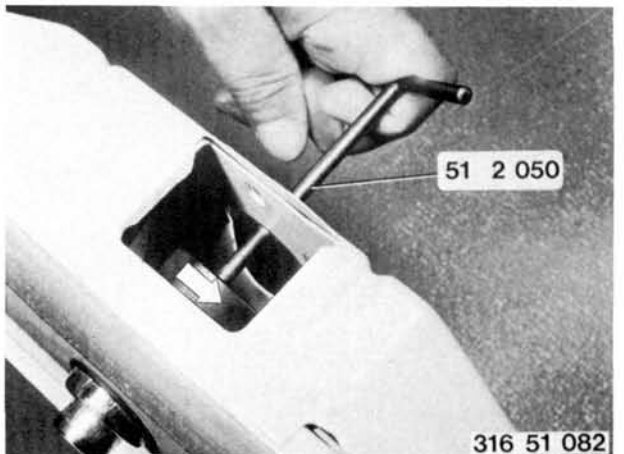
Loosen screws.

Installation Note! Adjust trunk lid catch - 51 24 004.

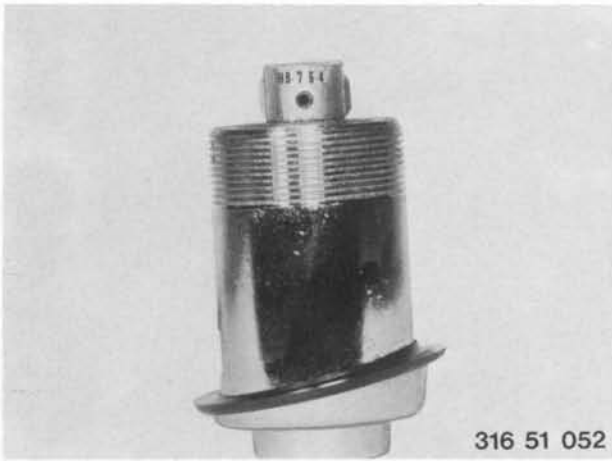


51 24 100 REMOVING AND INSTALLING TRUNK LID LOCK

Remove and install trunk lid catch - 51 24 050.
Unscrew threaded ring with Special Tool 51 2 050 and remove end sleeve.
Remove trunk lid lock.



Key number can be seen on removed trunk lid lock,
which must be identical with door lock.



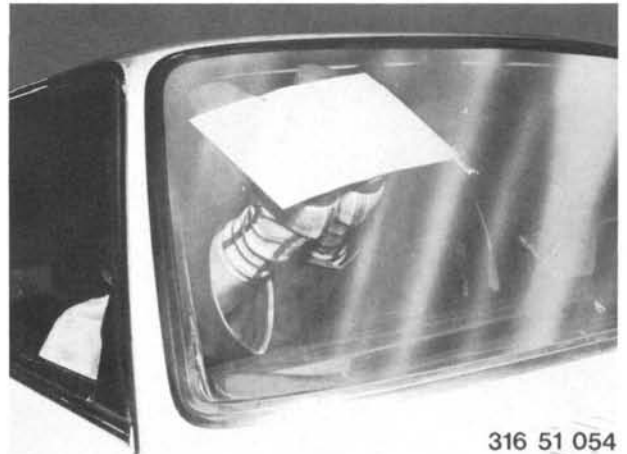
51 31 000 REMOVING AND INSTALLING WINDSHIELD

Carefully separate rubber frame from body with lip puller.



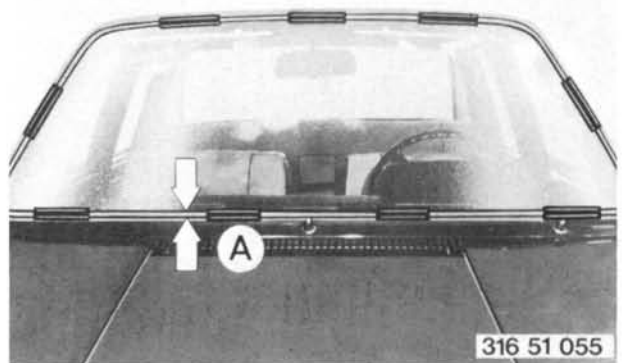
Press out windshield with your feet, starting at an upper corner.
Remove old sealant.

Installation Note! Check rubber frame and filler strip, replace if necessary.
Seal windshield. 1)

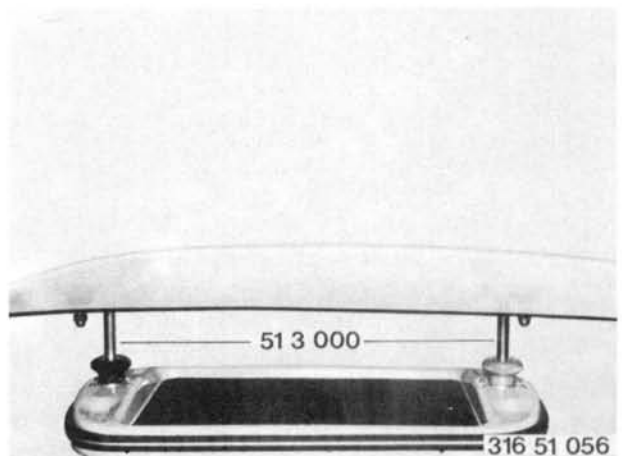


51 31 001 REPLACING WINDSHIELD

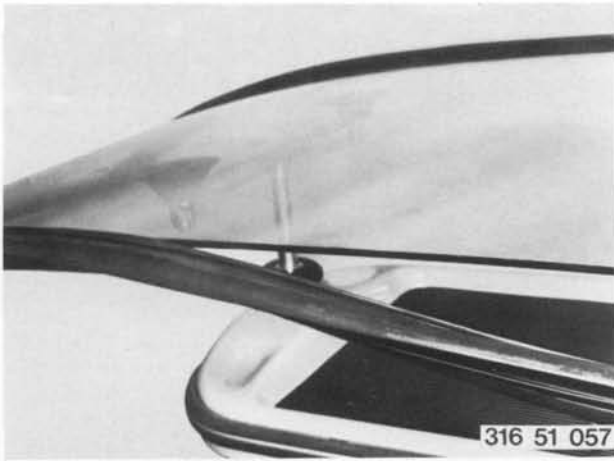
Check whether rubber frame and filler strip can be reused.
Install new glass pane in windshield opening lined with several pieces of rubber frame.
Distance (A) between glass pane and body opening is about 9 ... 10 mm (0.354 ... 0.394") all around.



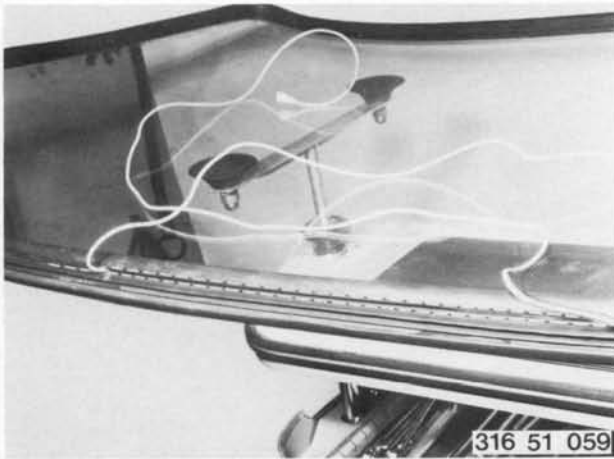
Place Special Tool 51 3 000 in "Assistant" and install windshield.



1) See Specifications
6.76



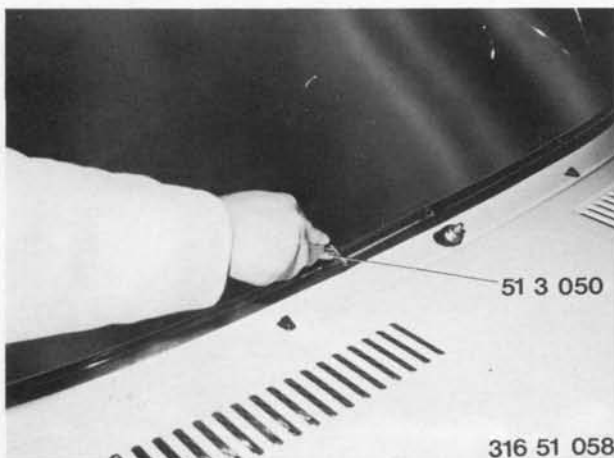
Coat windshield with adhesive¹⁾ all around and pull on rubber frame.



Pull an about 3 mm (0.118") diameter cord or wire behind lip of rubber frame.
At one side cord or wire must cross by a length of about 30 cm (12").



Place pre-assembled windshield in windshield opening and hold it to keep it from slipping to either side. Pull rubber frame over body land with inserted cord or wire.
During installation procedures move windshield to correct position by applying even knocks with a pad or your flat hand.



Installation Note! Heat filler strip to about 40° C (104° F).
Insert filler strip into rubber frame with Special Tool 51 3 050, starting at bottom center.
Seal window. 1)

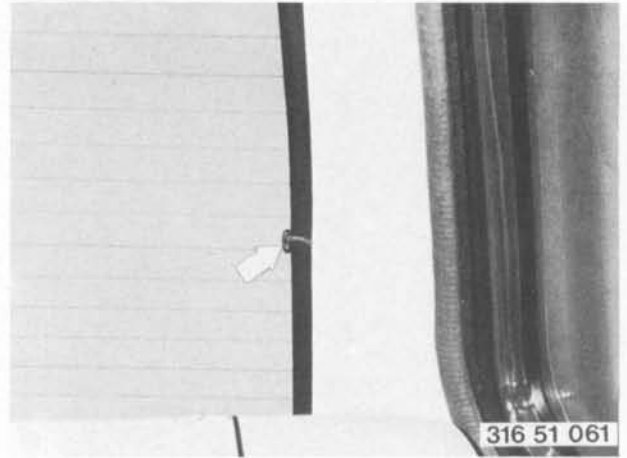
1) See Specifications

51 31 200 REMOVING AND INSTALLING REAR WINDOW

Disconnect rear window defogger connections.

Installation Note! Check function.

All other jobs are identical with those of 51 31 000.



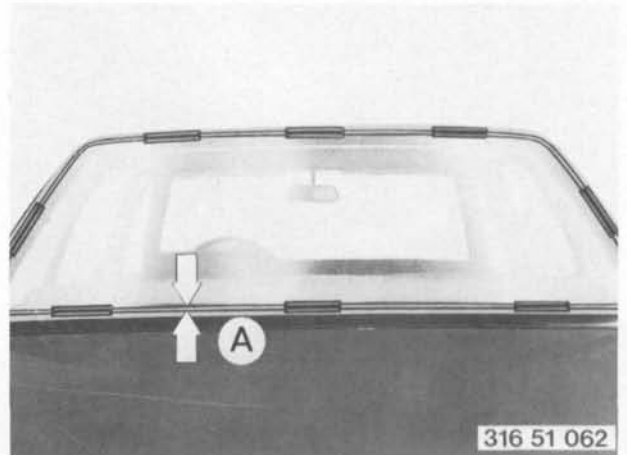
51 31 221 REPLACING REAR WINDOW

Check whether rubber frame can be reused.

Replace if necessary.

Install new glass pane in rear window opening lined with several pieces of rubber frame.

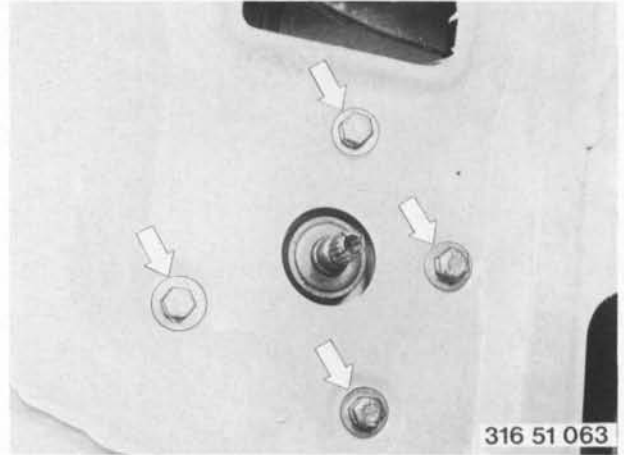
Distance (A) between glass pane and body opening is about 9 ... 10 mm (0.354 ... 0.394") all around.



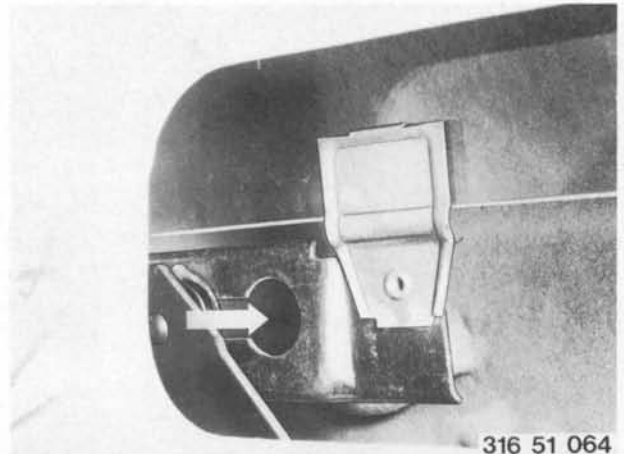
All other jobs are identical with those of 51 31 001.

51 32 020 REMOVING AND INSTALLING WINDOW CONTROL

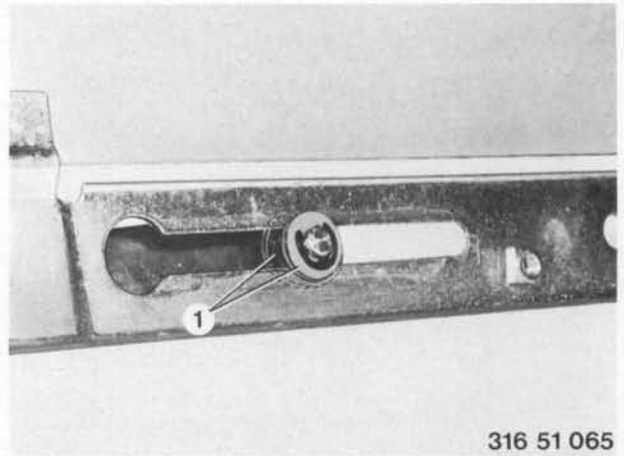
Remove and install door trim - 51 41 000.
Detach Acella plastic sheet.
Close window and take window control off of door.



Hold window tight at top.
Detach lifting arm through large hole in lifting plate.

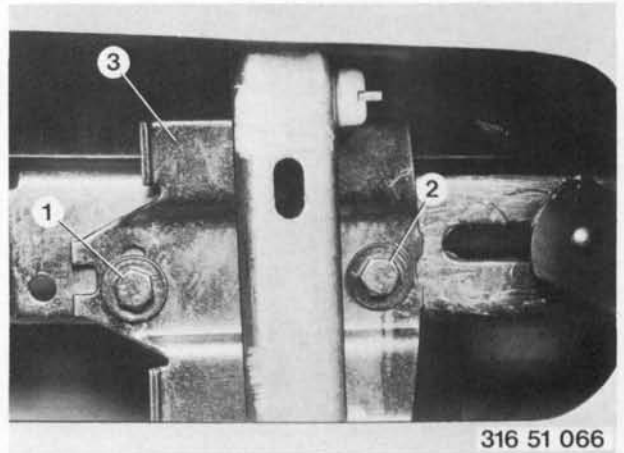


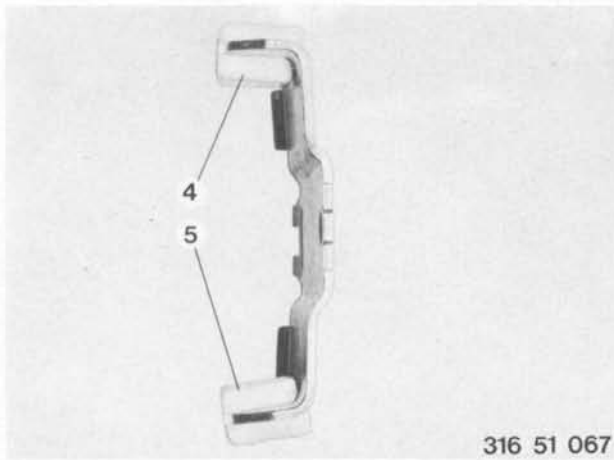
Installation Note! Lifting rail must run between both plastic discs (1).
Coat toothed segment of window control with a brand name multipurpose grease.



51 32 040 REMOVING AND INSTALLING WINDOW LIFT RAIL HOLDER

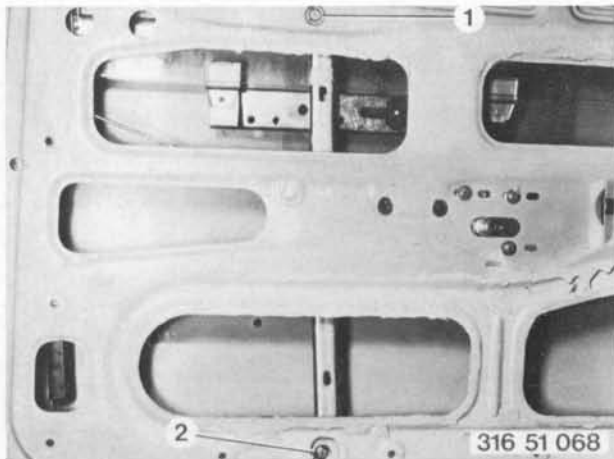
Adjust door window - 51 32 154.
Detach Acella plastic sheet.
Remove mounting screws (1 and 2) from holder (3).





When replacing, pull off slides (4 and 5).

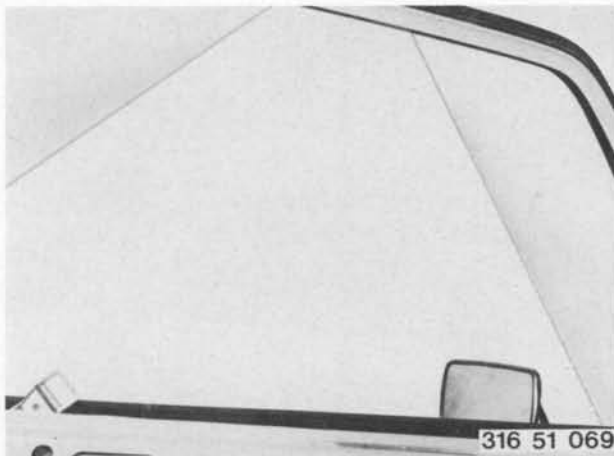
Installation Note! Note position of slides. Longer side must rest on outside of holder. Coat slides with a brand-name multipurpose grease.



51 32 080 REMOVING AND INSTALLING WINDOW SLIDE RAIL

Remove and install window lift rail holder - 51 32 040.
Loosen screws (1 and 2) and remove slide rail.

Installation Note! If necessary, place shims underneath screw (1) between window slide rail and inner door panel.



51 32 120 REMOVING AND INSTALLING FRONT WINDOW GUIDE RAIL

Remove and install window lift rail holder - 51 32 040.
Detach door window glass pane at lift arm and position at an angle.



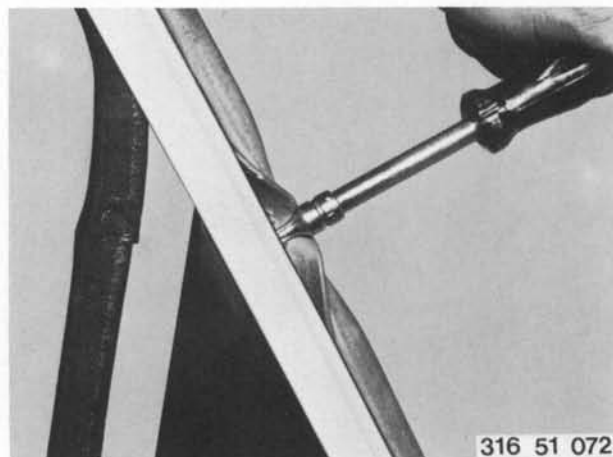
Pull window guide out of guide rail.
Loosen lower screw.

Loosen upper screw.

Installation Note! Install shims, if necessary.



Pull off door seal as required.
Loosen screw.
Remove window guide rail downward.



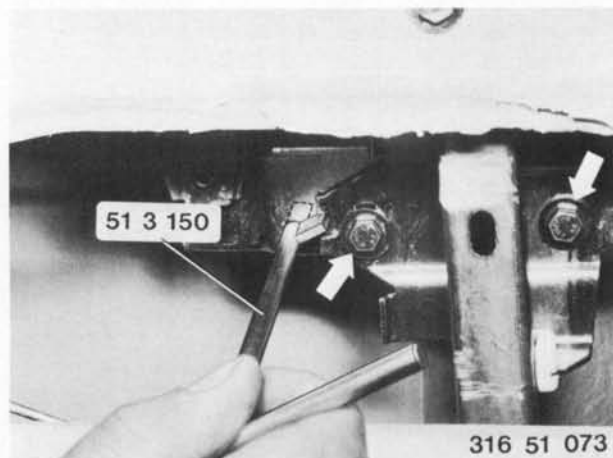
51 32 125 REMOVE AND INSTALL REAR WINDOW GUIDE RAIL

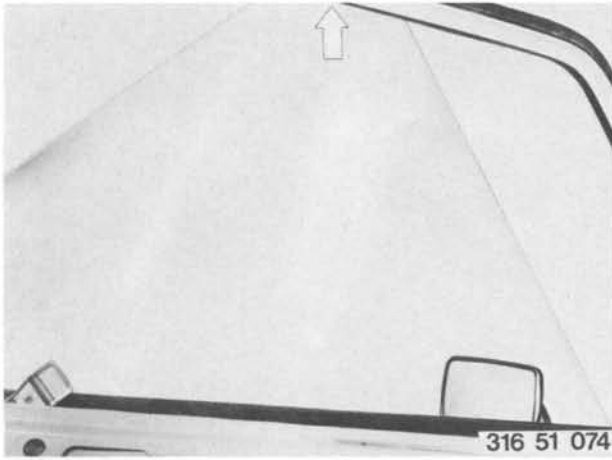
Remove and install door trim - 51 41 000.
Detach Acella plastic sheet.
Loosen rear window guide rail mounting screw.
Pull window guide out of window guide rail partially
and remove window guide rail downward.



51 32 154 ADJUSTING DOOR WINDOW

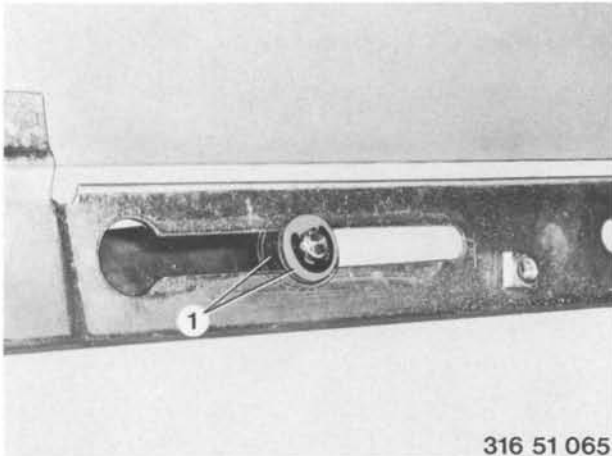
Remove and install door trim - 51 41 000.
Detach Acella plastic sheet.
Loosen screws and take up any side door window play
with Special Tool 51 3 150.
Lubricate guides.
Tighten mounting screws.



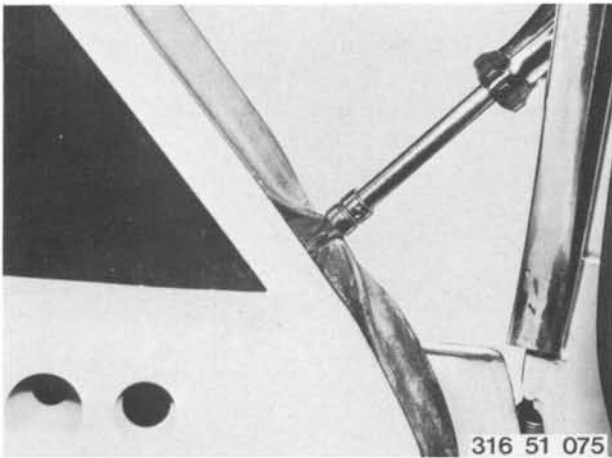


51 32 170 REMOVING AND INSTALLING DOOR WINDOW

Remove and install window lift rail holder - 51 32 040.
Detach door window glass pane at lift arm and remove upward.

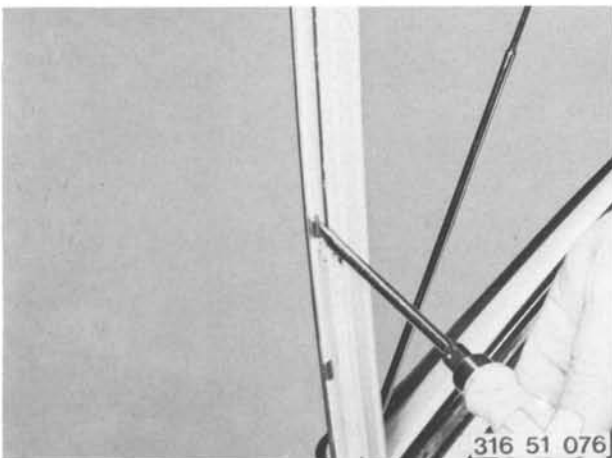


Installation Note! Lift rail must run between both plastic discs (1).



51 32 390 REMOVING AND INSTALLING WINDOW FRAME TRIM

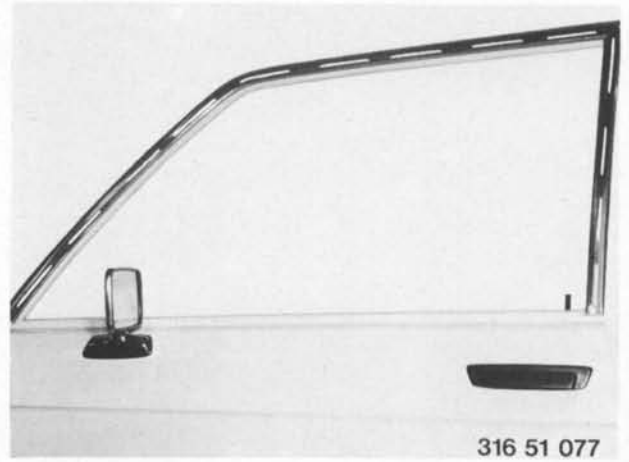
Remove and install door window - 51 32 170.
Remove and install window guide rail - 51 32 120.
Remove and install outer window recess cover strip - 51 21 300.
Pull window guide out of guide rail and window frame.
Loosen screw and remove corner trim.



Starting at front, lift out clips with a screwdriver and remove trim.

Installation Note! Replace clips.
First install clips in window frame and then press on trim.

Installation Note! To avoid any rattling noise from window frame trim, insert pieces of Terostat cord at several points.



51 36 050 REMOVING AND INSTALLING REAR SIDE WINDOW

Remove and install rear side trim - 51 43 000.
Press out side window with your feet at either upper corner.

Caution! Always hold glass tight on outside, to keep it from falling down.

Installation Note! Remove old sealant.
Seal corners with Terostat cord.



316 51 078

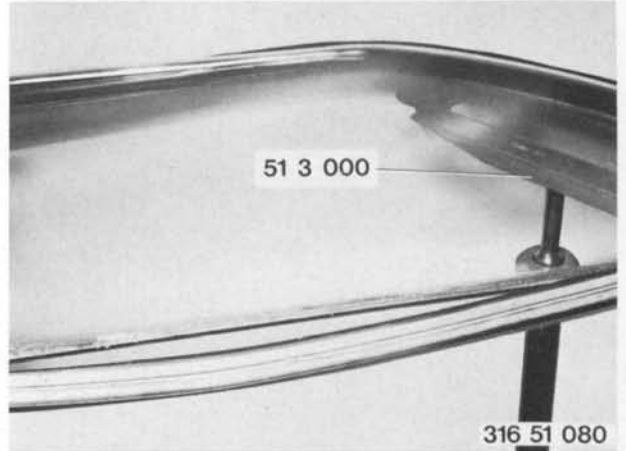
Installation Note! Place Terostat cord in window opening.
Place cord or wire in last lip of rubber frame.
Install glass pane and pull rubber frame over window land. Move window to correct position by applying light knocks with a pad or your flat hand.



316 51 079

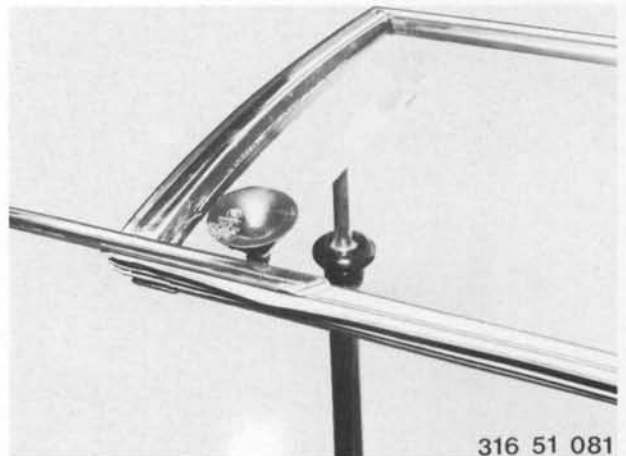
51 36 071 REPLACING REAR SIDE WINDOW

Check whether rubber frame and strip can be reused.
Insert Special Tool 51 3 000 into "Assistant" and place glass pane on it.
Pull on rubber frame.



316 51 080

Insert strips into rubber frame.
Sequence: 1. vertical strip
 2. upper strip
 3. horizontal strip
Make sure that rubber sealing lips grab strips correctly.



316 51 081



Place Terostat cord in window opening all around. Pull an about 3 mm (0.118") diameter cord or wire into lip of rubber frame.

Ends of cord or wire must cross at one side by a length of about 30 cm (12").

Place pre-assembled window glass pane in window opening and hold tight to prevent slipping to one side.

Pull rubber frame over body land with inserted cord or wire.

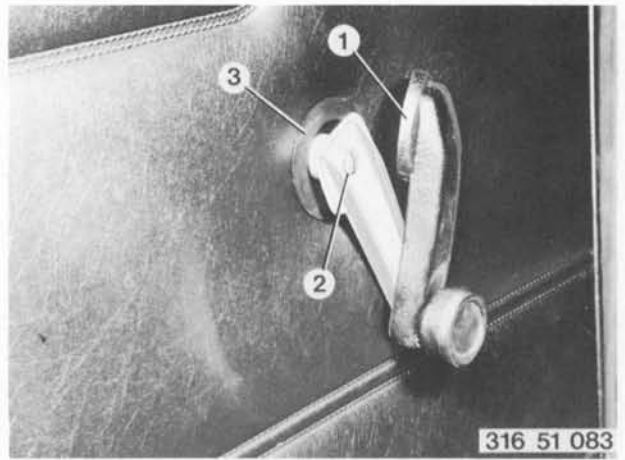
During this procedure move window to correct position by applying uniform knocks with a pad or your flat hand. 1)

Seal window .

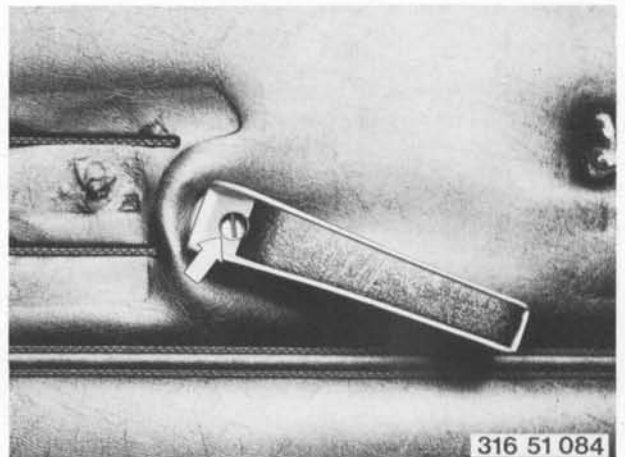
1) See Specifications

51 41 000 REMOVING AND INSTALLING DOOR TRIM

Remove and install armrest - 51 41 060.
Lift off cover (1).
Loosen mounting screw (2) and remove window control with escutcheon (3).



Loosen mounting screw and remove inside door handle.
Installation Note! Note position of door handle.

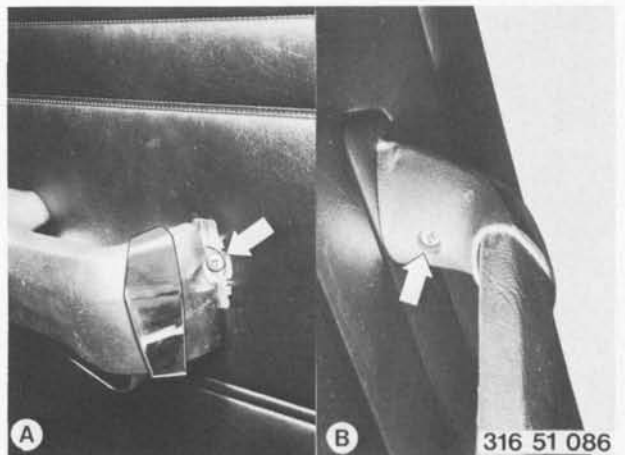


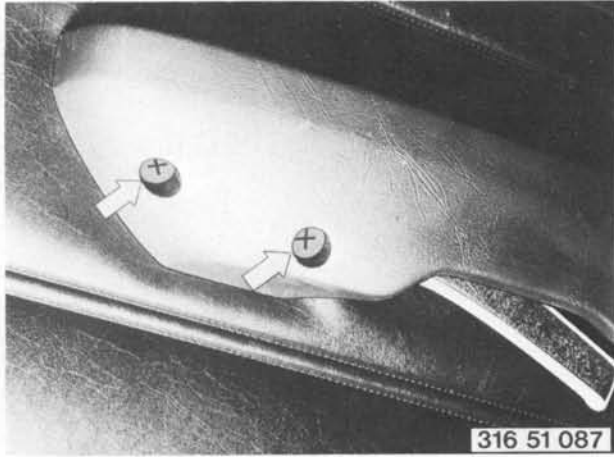
Lift off clips and remove door trim upward.
Caution! Large coil of spring (4) faces trim.
Installation Note! Check clips and sockets, replace if necessary.



51 41 060 REMOVING AND INSTALLING ARMREST

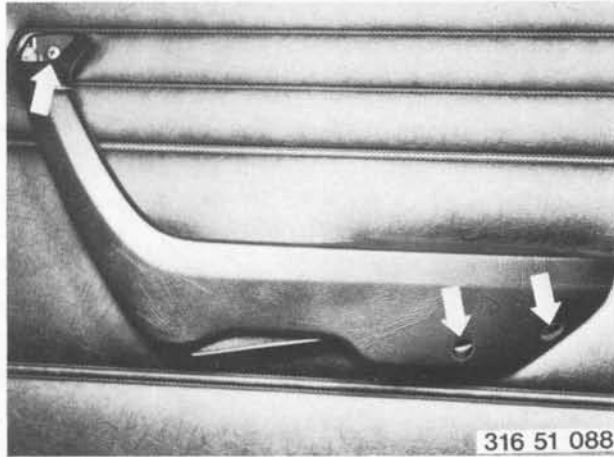
- A) Left Side
Slide back cover and loosen screw.
- B) Right Side
Unscrew cover.





316 51 087

Left Side
Remove armrest.



316 51 088

Right Side
Remove armrest.

51 43 000 REMOVING AND INSTALLING REAR SIDE TRIM

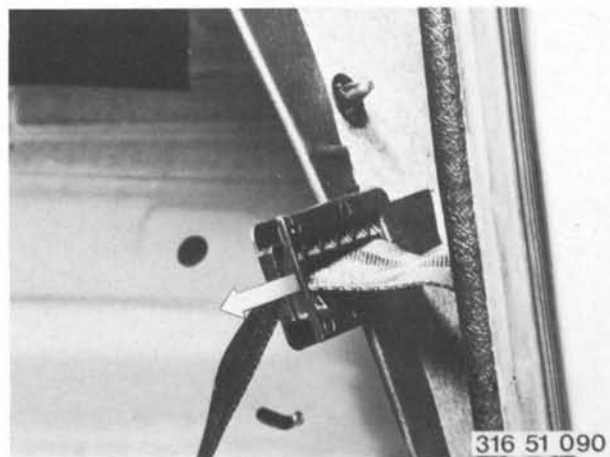
Remove and install rear seat cushion and backrest -
52 20 000.

Lift off clips and pull off side trim upward.

Installation Note! Check locks, sockets and clips,
replace if necessary.

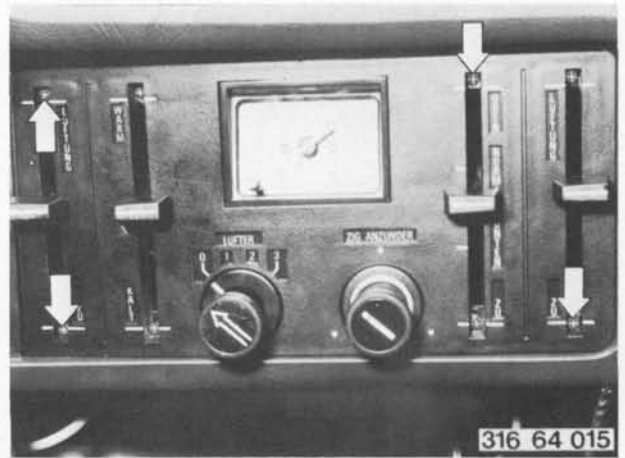


Pull out seat belt guide and remove side trim.

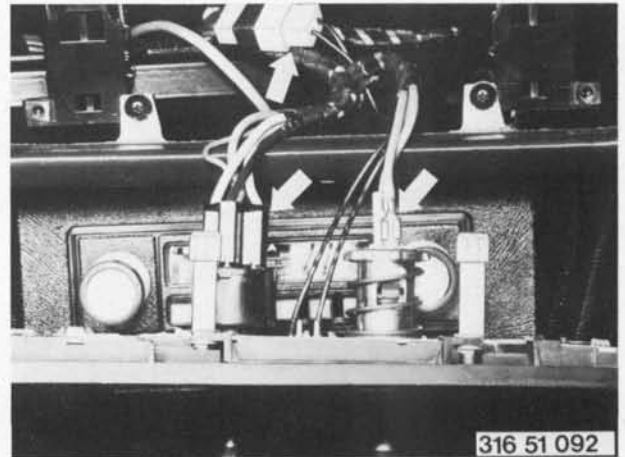


51 45 050 REMOVING AND INSTALLING UPPER INSTRUMENT
PANEL TRIM

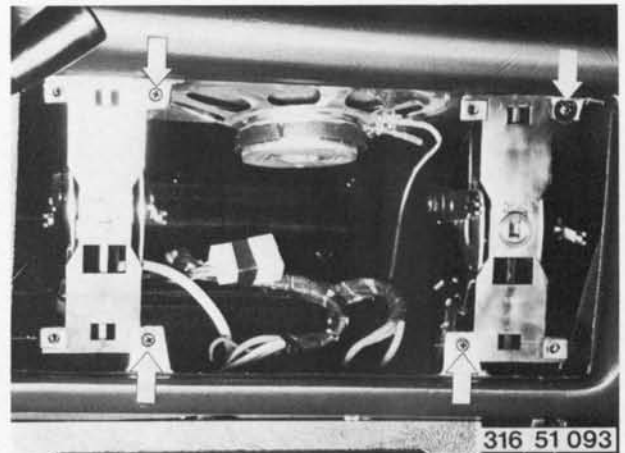
Remove and install entire instrument carrier -
62 21 000.
Detach and attach bottom center instrument panel trim
(at shelf) - 51 45 200.
Pull off control knobs.
Loosen screws and remove switch plate.



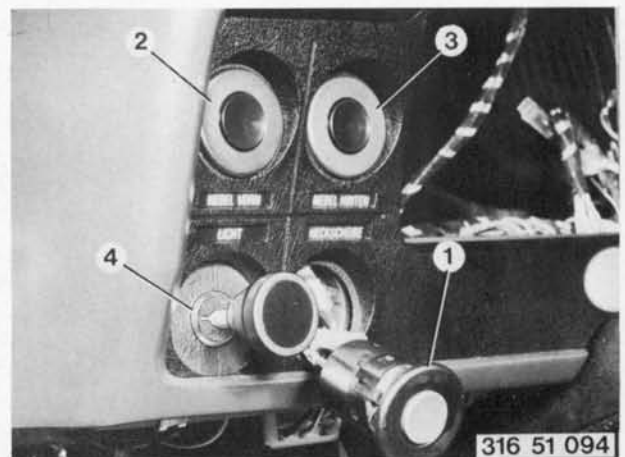
Disconnect central plug and wires at switch plate.

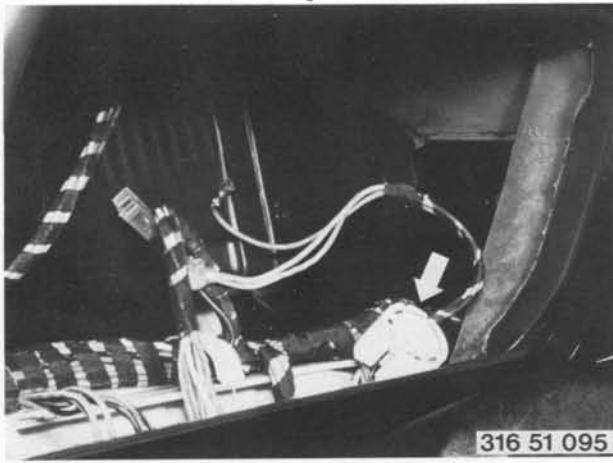


Detach operating switches.
If applicable, disconnect wires at loudspeaker.

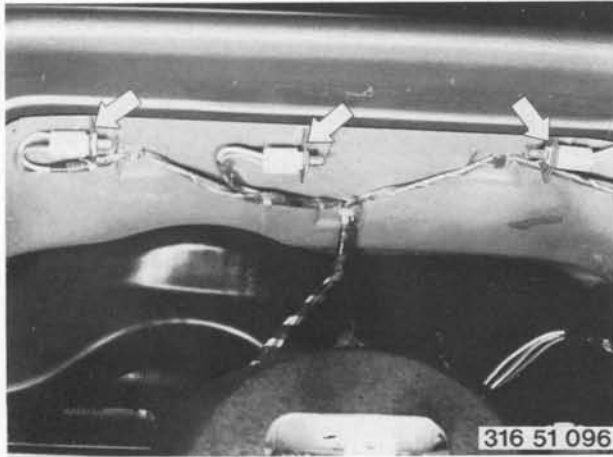


Press out switch (1) - possibly switches (2 and 3) -
and disconnect wires.
Unscrew knob on switch (4). This requires counter-
holding shaft with a mandrel to prevent damage on
the potentiometer.
Remove switch (4).



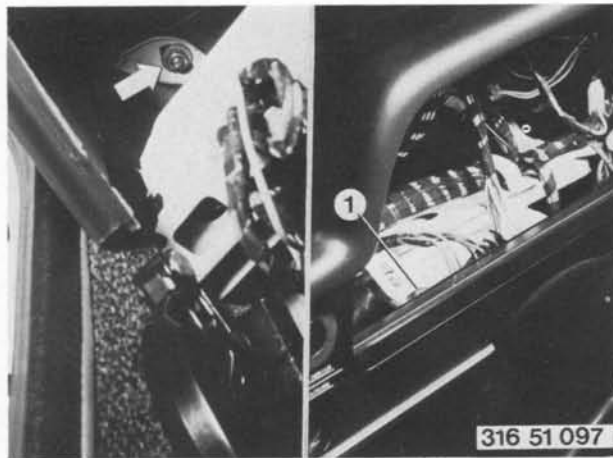


Pull central plug off of hazard light switch.

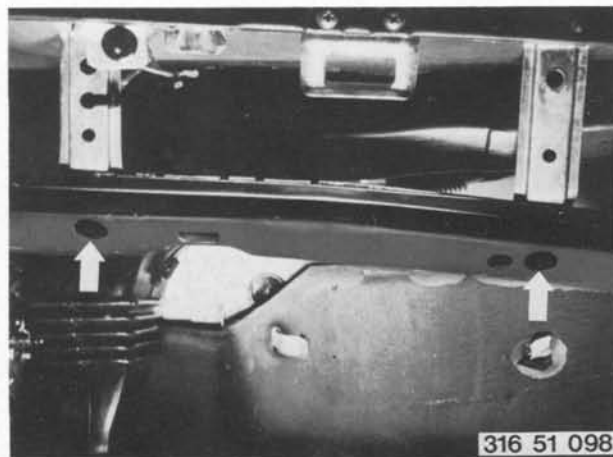


Pull out instrument light holders.

Installation Note! Hold wires in clips.

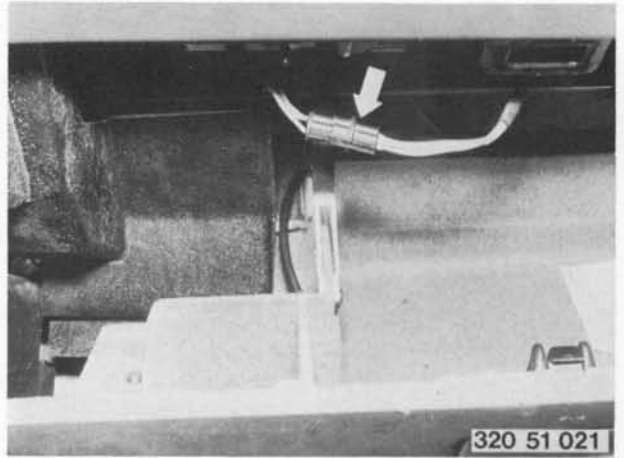


Unscrew nut on left-hand side and remove screw (1) on right-hand side.



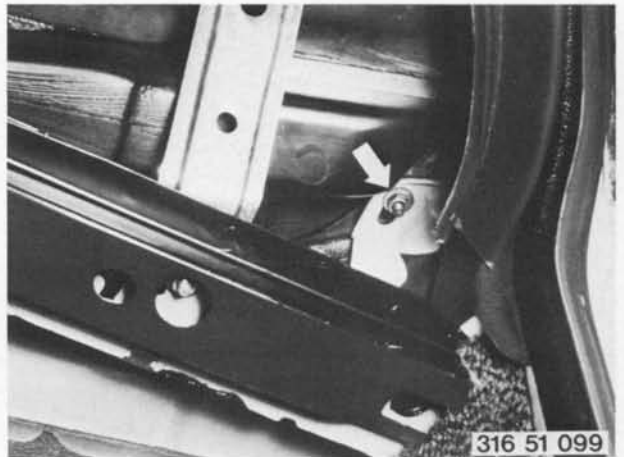
Detach joint on glove compartment.
Pull wires off of lamp and undo wire strap.
Remove nuts on brackets.

Disconnect plug for service interval indicator.



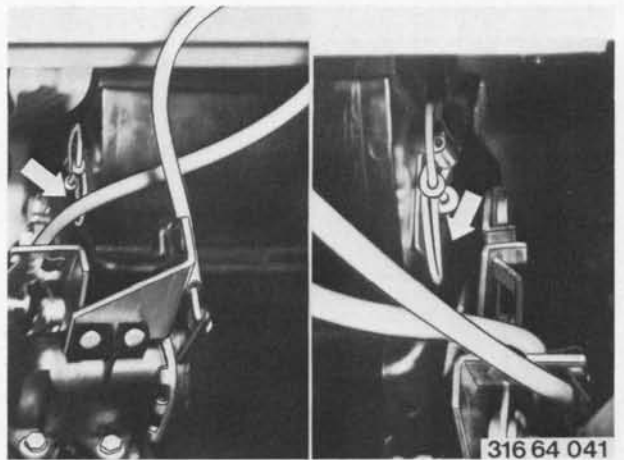
Unscrew nut on right-hand side.

Installation Note! Press trim forward all the way, before tightening all nuts.



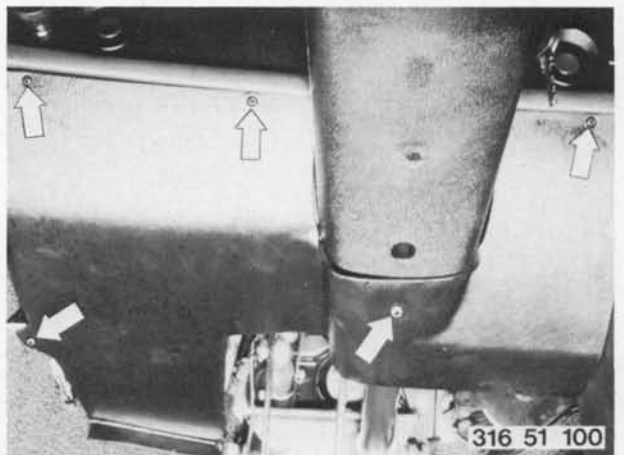
Open left and right snap-type fasteners. Starting at one side, lift trim and remove to the rear.

Installation Note! Make sure that heater connectors are located in defroster nozzles.



51 45 190 DETACHING AND ATTACHING BOTTOM CENTER INSTRUMENT PANEL TRIM

Loosen screws and remove trim.



51 45 200 DETACHING AND ATTACHING BOTTOM CENTER
RIGHT INSTRUMENT PANEL TRIM

Detach joint on left and right-hand sides of glove compartment.
Loosen screws and remove trim.

