

WORK DESCRIPTION FOR FIELD MEASURE

Code: 24P7590001

Version: 2.0

Check laser solder seam on trunk lid for cracks; rework if necessary

Model 236

Check/Test Procedure

1. Remove left rear inner lamp unit (E3/17, Figure 1) and right rear inner lamp unit (E4/17, Figure 1).
i For basic information, see **AR82.10-P-4927WEC**.
2. Remove the trim element (1, Figure 1) from the trunk lid (2, Figure 1).
i **Installation:** The trim element (1, Figure 1) is destroyed when you remove it and a new one has to be installed in its place.
3. Check the laser solder seam (area A, Figure 1) on the trunk lid (2, Figure 1) for cracks.
i Use a flashlight here to inspect for cracks.

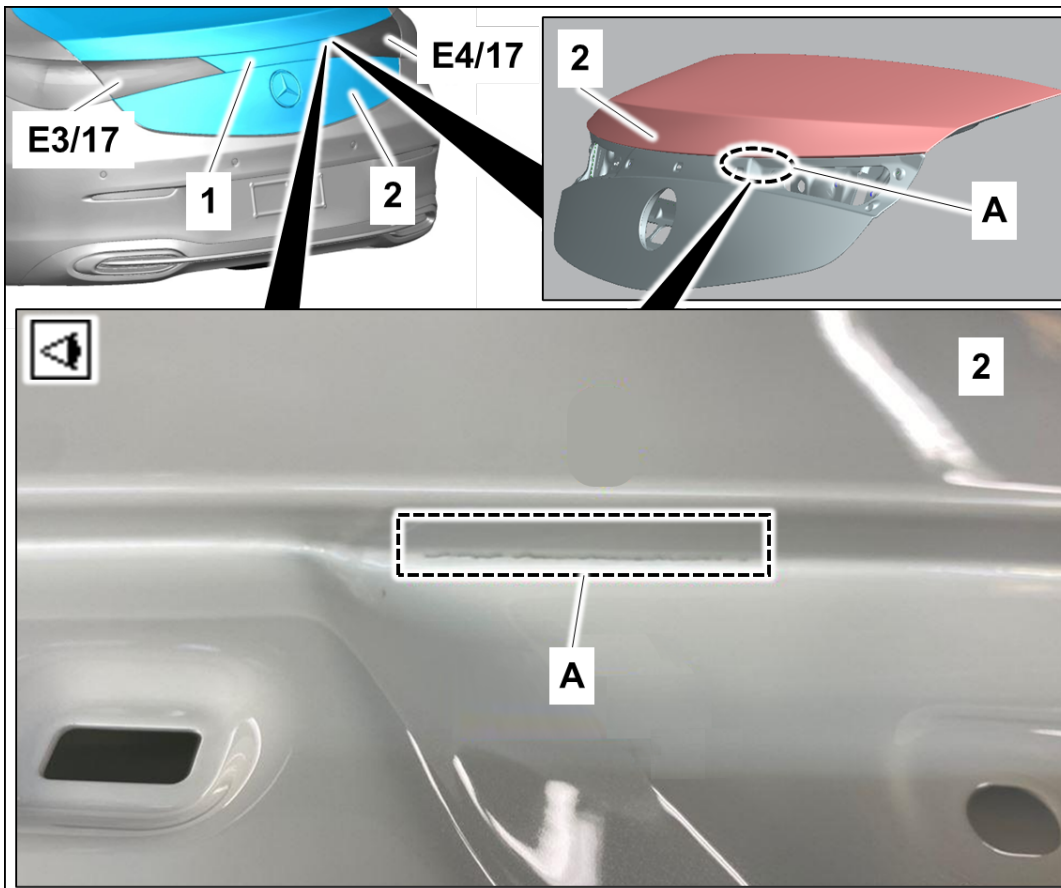


Figure 1

- a. If the laser solder seam is cracked (A, Figure 1): Perform the necessary **Work Procedure**.
- b. If the laser solder seam is **not** cracked (A, Figure 1): **End the measure**.

Work Procedure

1. Clean the affected area of the laser solder seam (area A, Figure 1) on the trunk lid (2, Figure 1) over a wide area.
i For example with silicone remover.
2. Apply activator to the affected area of the laser solder seam (area A, Figure 1) on the trunk lid (2, Figure 1).
i Observe manufacturer's specifications for product!
3. Seal the affected area of the laser solder seam (area A, Figure 1) on the trunk lid (2, Figure 1) with transparent seam seal.
i Seal approx. 2 cm over the entire crack length of the laser solder seam (area A, Figure 1).
i Observe manufacturer's specifications for product!
4. Install in the reverse order.

Parts

Quantity	Designation	Part no.
As required (1) **	Activator	A 000 989 31 00
As required (1) **	Seam seal (transparent)	A 000 989 32 00 09
1 *	Trim element	A 236 757 41 00

* **The required replacement parts for the equipment variant must be determined according to the vehicle identification number (VIN) via the XENTRY Parts Information system.**

** One packaging unit suffices for at least 10 vehicles.

i Small parts such as screws, lock nuts, sealing rings, cable ties, fluids, sealant, etc. are not listed in the parts list. The required small parts are taken into account in the budgeting.

Operation text and flat rate

Operation no.	Operation text	Flat rate	Accounting no./ damage code
12-2156	Operations: Check laser solder seam on trunk lid for cracks Includes: Remove/install rear left and rear right inner lamp units and remove/install trim element on trunk lid.	0.7 h	75 900 01
12-2157	Operations: Rework laser solder seam on trunk lid (after check)	0.2 h	75 900 01

* Operation item may be invoiced only once for each workshop order.