

## Liftgate deformed below the star

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Topic number	LI72.20-N-062702
Version	2
Function group	72.20 Tailgate, rear door
Date	06-20-2019
Validity	Model 447.### ## up to 198809 with code W65 (Liftgate)
Reason for change	Validity restricted.
Reason for block	

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### Complaint:

When the liftgate is closed manually, a dent (deformation) occurs below the star.

Attachments	
File	Description
01.jpg	Dent in liftgate below star.
02.jpg	Dent in liftgate below star.

### Cause:

Internal reinforcement of liftgate not sufficient.

### Remedy:

1. Reform dent in liftgate (see Figure 1 and Figure 2).  
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2. Clean reinforcement (3) with assembly cleaner and degrease.  
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3. Prime reinforcement (3) with primer filler.  
Note: Observe AS98.00-Z-0002-01A.  
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4. Remove both license plate lamps (see AR82.10-S-5161E).  
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5. Remove handle of liftgate (1) (see AR72.20-S-7320E).  
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6. Remove insulation mat (2).  
Note: To do this, heat the insulation mat (2) and pull it off (heat gun, 000 588 00 84 00).  
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7. Clean inside of liftgate (1) in working area using assembly cleaner.  
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8. Apply primer from repair kit (A 221 670 81 01) to reinforcement (3).

# XENTRY TIPS

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Note: Observe the flash-off time. Otherwise the necessary adhesion cannot be guaranteed.

9. Apply primer from repair kit (A 221 670 81 01) to working area on liftgate (1).

Note: Observe the flash-off time. Otherwise the necessary adhesion cannot be guaranteed.

10. Apply adhesive bead (4) to center of reinforcement (3).

Note: Observe AS00.00-Z-0016-01A.

The reinforcement (3) is shaped to fit the base of the beading (5) on the liftgate (1). The depth of the adhesive (repair kit A 221 670 81 01) must be at least 5 mm. Otherwise the necessary adhesion cannot be guaranteed.

11. Glue reinforcement (3) with adhesive bead (4) fitting in base of beading (5).

Note: Pay attention to the position and installation location of the reinforcement (3) in the base of the beading (5) in the liftgate (1). Otherwise the desired support cannot be guaranteed.

Note: Remove surplus adhesive material. Observe curing time. Otherwise the necessary adhesion cannot be guaranteed.

12. Install handle of liftgate (1) (see AR72.20-S-7320E).

13. Install both license plate lamps (see AR82.10-S-5161E).

Attachments	
File	Description
03.jpg	Installation of reinforcement (3) on liftgate.

Symptoms
Body / Body/Cab / Body / Surface warp

Parts						
Part number	ES1	ES2	Designation	Quantity	Note	EPC
A 221 670 81 01			Windshield glass installation repair kit, 1-component adhesive	1		X
A 447 742 11 00			Reinforcement	1		X
			Assembly cleaner	1	Assembly cleaner Adolf Würth GmbH & Co. KG Reinhold-Würth-Str. 12-17 74653 Künzelsau-Gaisbach Germany Tel. +49 7940 15-0 Fax +49 7940 15-1000 www.wuerth.de	

# XENTRY TIPS

Operation numbers/damage codes				
Op. no.	Operation text	Time	Damage code	Note
85-6000	PERFORM DENT REPAIR (1-3 DENTS PER PART), LOCATION:.....		74201 IA	Liftgate - Deformed The listed damage code is not to be considered as an acceptance of costs. The general guidelines in the Warranty Manual apply.
02-8860	OPERATIONS: INSTALL LIFTGATE REINFORCEMENT		74201 IA	Liftgate - Deformed The listed damage code is not to be considered as an acceptance of costs. The general guidelines in the Warranty Manual apply.

WIS-References			
Document number	Title	Note	Allocation
AR72.20-S-7320E	Remove/install outside door handle on liftgate		Remedy
AR82.10-S-5161E	Remove/install license plate lamp		Remedy
AS00.00-Z-0016-01A	Risk of poisoning from inhaling vapors or from swallowing adhesive. Risk of injury from skin and eye contact with adhesive		Remedy
AS98.00-Z-0002-01A	Risk of explosion from ignition of paint vapors. Risk of poisoning from inhaling paint vapors		Remedy
WS54.00-P-0049B	000 588 00 84 00 Heat gun		Remedy

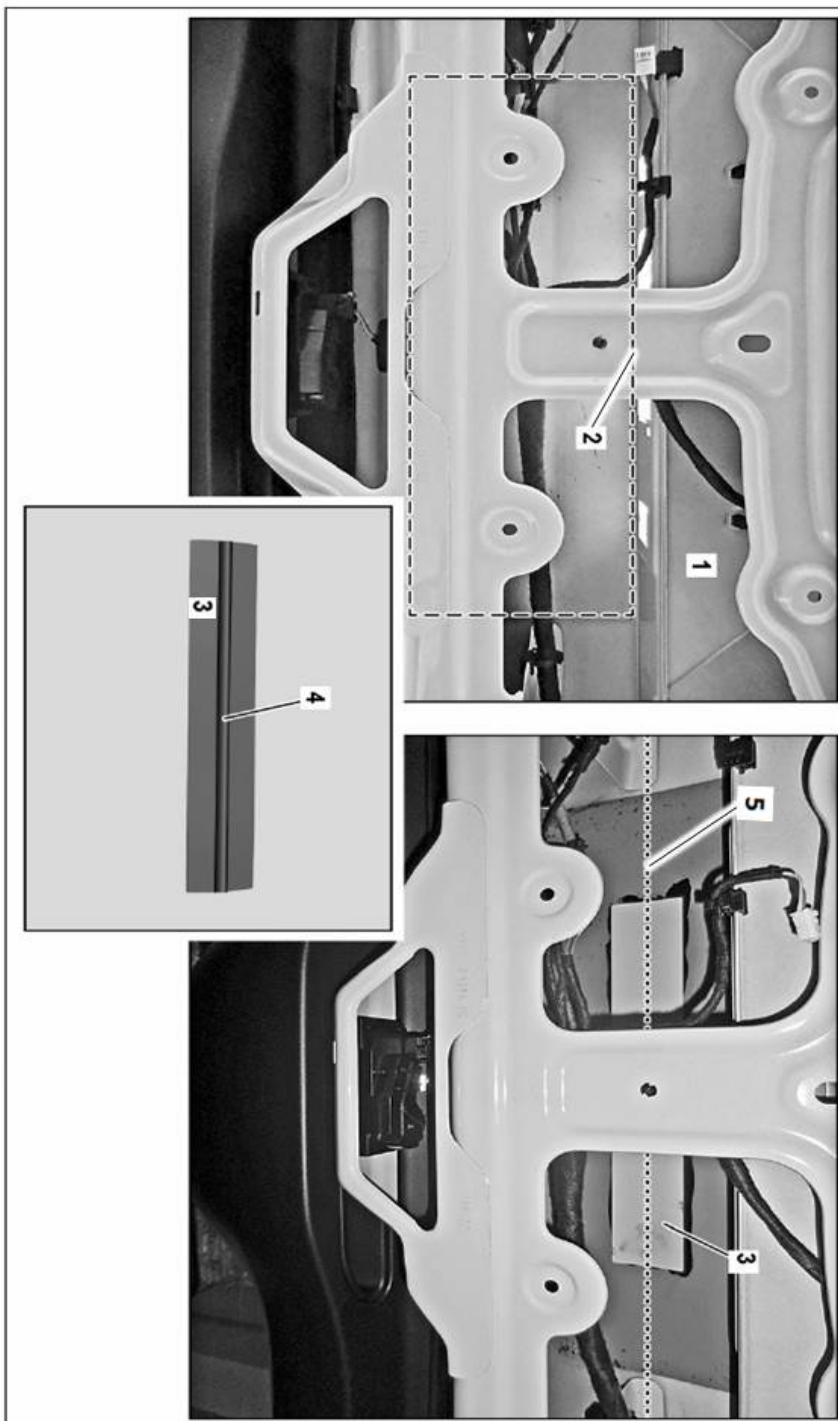
Validity		
Vehicle	Engine	Transmission
Vito/Metris 447	*	*

Attachments

# XENTRY TIPS

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03.jpg:



# XENTRY TIPS

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01.jpg:



# XENTRY TIPS

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02.jpg:

