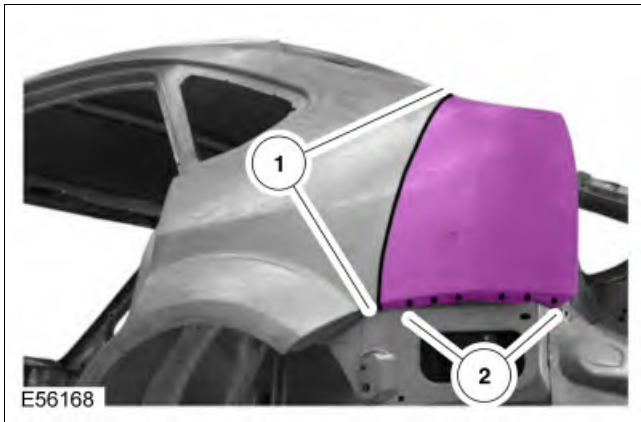


Complete Panel Replacement/Partial Replacement

Partial Replacement



Item	Description
1	Sectioning area
2	Manufacture weld joint

Decision Criteria

The following points are crucial to the decision of complete or partial replacement of the part(s).

- Is the repair economically feasible.
- Retention/integrity of the original joint.

In addition, sectioning or partial panel replacement must meet standardized guidelines or approved procedures in the model specific workshop manual for a sectional replacement solution in the damaged area.

For additional information, refer to: Body Panel Sectioning (501-26 Body Repairs - Vehicle Specific Information and Tolerance Checks, General Procedures).

Depending on the damaged area, the following points need to be considered when determining whether to perform a partial repair or complete replacement:

- Sectioning cuts should be as short as possible.
- Feature lines and panel margins must meet original manufacture design.
For additional information, refer to: Body and Frame (501-26 Body Repairs - Vehicle Specific Information and Tolerance Checks, Description and Operation).
- Inner reinforcement panels must not limit the straightening work.
- Inner reinforcement profiles in the pillar areas must allow for separation.
- Partial replacements on structural frame sections must be allowed for the specific vehicle being repaired. If no procedure exists, it must be assumed no sectioning is allowed.
- The large surface welding seams at the connections must be restored.

Advantages of Partial Replacement

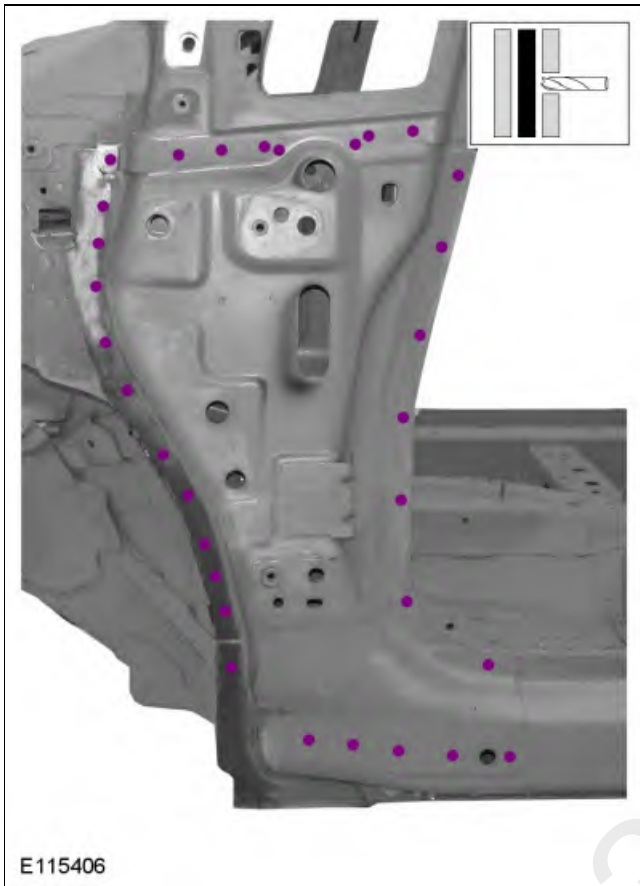
A partial replacement repair offers many advantages for a professional repair of accident damage:

- Repairs can be made both in the outer panel area (e.g. side frame) and in the inner areas (e.g. structural member, trunk floor).

- The repair can be limited to the actual damaged area.
- Reduction of repair costs, as aggregates and other components can usually remain in the vehicle.

Complete Replacement

In a complete replacement, the original connections are largely reused.



A complete replacement is advantageous if the damaged body part can be detached from its original connections and the replacement part can be fitted without creating additional joints.

A complete replacement is necessary if there is no sectional replacement solution.
