

SIT-SIT-SI2016-411116418 SIT-SIT-SI2016-411116418 - Door repair (edge corrosion on door outer skin) - V.1&comma; VIN:

|                     |               |                 |                                    |                    |
|---------------------|---------------|-----------------|------------------------------------|--------------------|
| ISTA system version | 4.05.31.20245 | Data version    | R4.05.31                           | Programming - data |
| VIN                 | Vehicle       | 5'/F11/Sports   | Wagon/530d/N57/AUTO/ECE/RL/2010/07 |                    |
| Int.lev.works       | -             | Int.lev. (cur.) | -                                  | Int.lev.(tar.) -   |
| Mileage             | 0 km          |                 |                                    |                    |

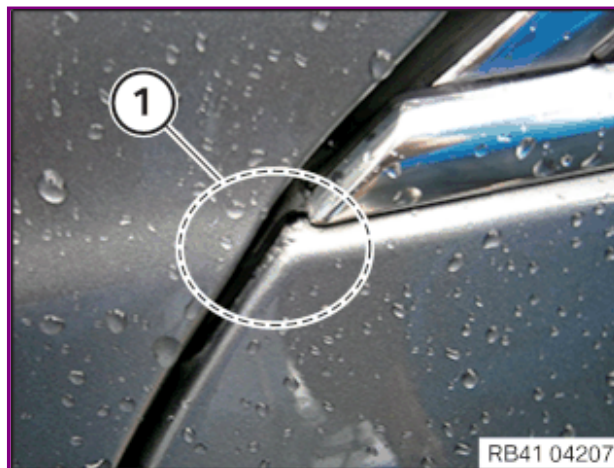
41 11 16 (418)

Door repair (edge corrosion on door outer skin)

F10, F11, F18

Situation:

Edge corrosion (1) may develop on doors around the window cavity seal (see figure).



Vehicles concerned:

F10, F11, F18 production period: Series introduction up to 03/2016

Measure:

In case of customer complaints, the already existing damage must be eliminated by partial painting and replacing the seal.

Attention!

Replacement of the doors is not permissible in

these cases!

Procedure:

Remove the [exterior mirror at the front door](#).

Remove the [weather strip](#).

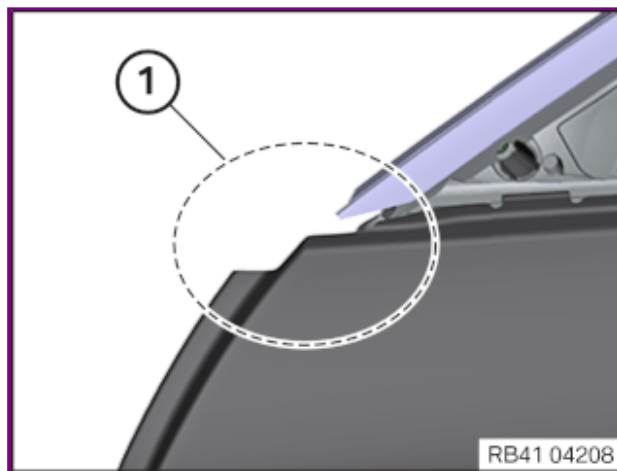
Remove the [outside door handle](#).

Remove the [door](#).

Remove the [seal for the door gap/roof frame](#).

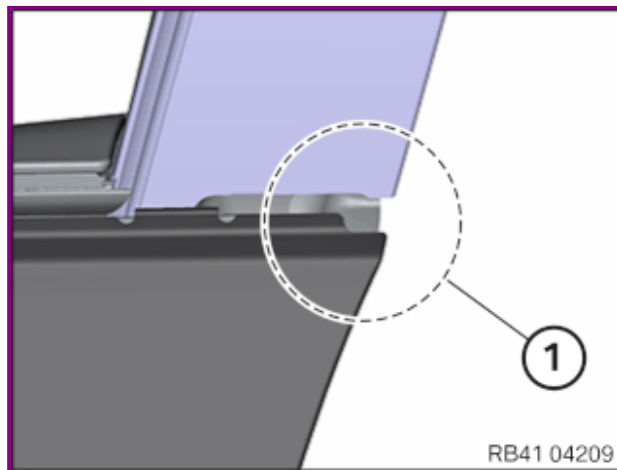
*Note:*

Adhere to [notes on body repair](#).



Front door:

Grind  
corroded  
areas (2)  
down to the  
metal.

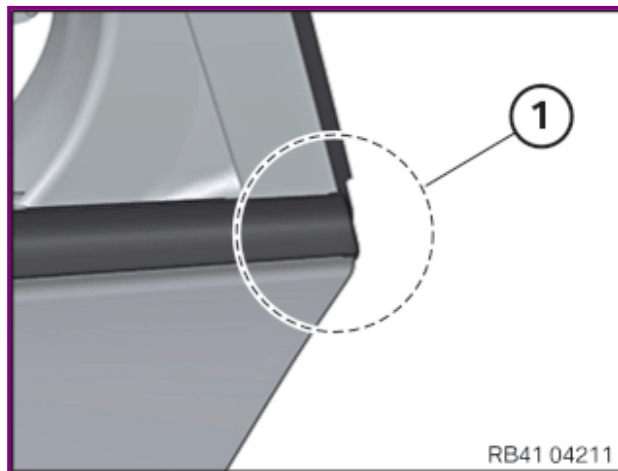
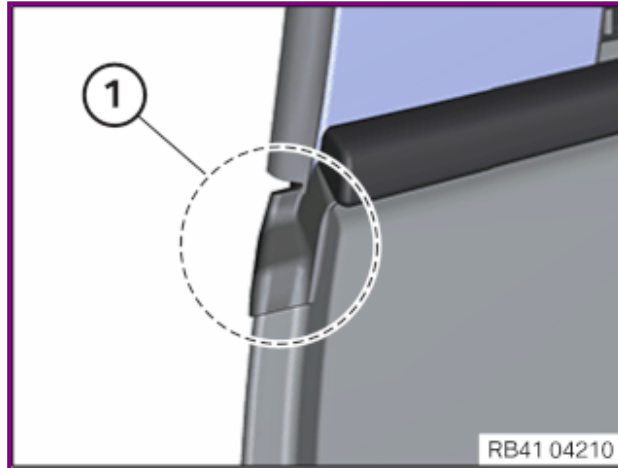


Front door:

Grind corroded areas (2) down to the metal.

Rear door:

Grind  
corroded  
areas (2)  
down to the  
metal.



**Rear door:**

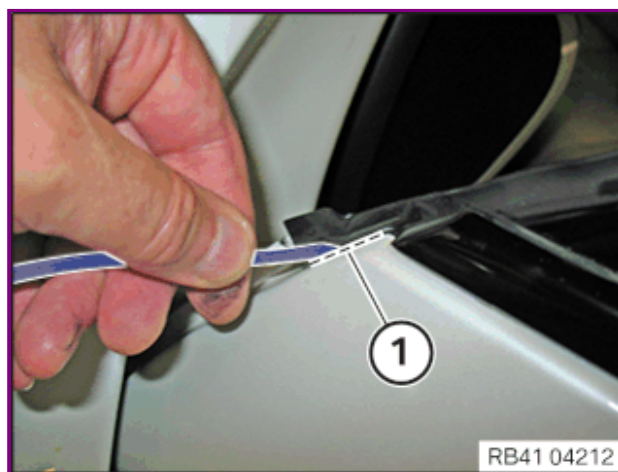
Grind  
corroded  
areas (2)  
down to the  
metal.

Paint the door outer skin.

Replace the [seal for the door gap/roof frame](#).

Preserve corroded areas of the door from the inside.

Reassemble the vehicle.

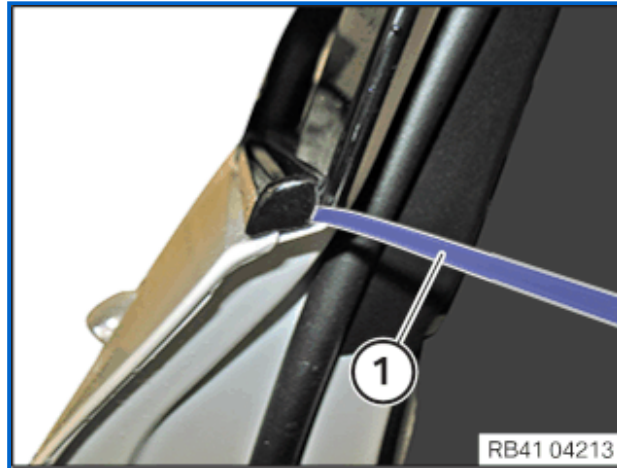


**Front door:**

Lift the seal  
and coat  
with cavity  
preservation  
in this area  
(1).

Mount  
gasket .

Clean the  
door outer  
skin.

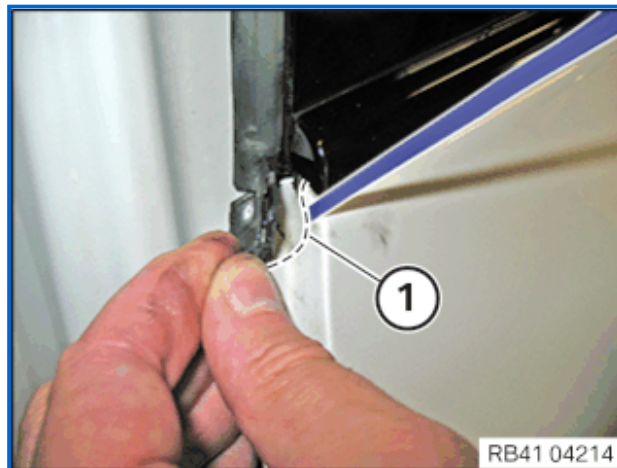


**Front door:**

Push the spraying pipe (1) under the window cavity seal.

Coat the area with cavity preservation.

Clean the door outer skin.



**Rear door:**

Lift the seal and coat with cavity preservation in this area (1).

Mount gasket .

Clean the door outer skin.



**Rear door:**

Lift the seal and coat with cavity preservation in this area (1).

Mount gasket .

Clean the door outer skin.

**Parts:**

| <b>Designation</b>  | <b>Part number</b> | <b>Quantity</b> |
|---------------------|--------------------|-----------------|
| Cavity preservation | 83420428190        | 1               |