

BODY DIMENSION TABLE

Pos.	DESCRIPTION, Measured Section	ASTRA Dimensions in mm	KADETT Dimensions in mm
1	Diagonal of engine compartment opening	1 573	
2	Depth of engine Compartment (centre bonnet locking bolt)	805	
3	Width between both spring strut domes (outer edge of hole)	1 138	
4	Diagonal of windscreen frame	1 364	
5	Height of windscreen frame	740	
6	Diagonal of front door frame	1 344	1 344
7	Height of front door frame	984	984
8	Opening of front door frame (A to B pillar)	890	890
9	Diagonal of rear door frame (long)	1 154	1 154
10	Diagonal of rear door frame (short)	905	905
11	Height of rear door frame (centre of sill)	1 001	1 001
12	Opening of rear door frame	818	818
13	Diagonal of frame — rear quarter window	615	679
14	Height of frame — rear quarter window (centre)	—	—
17	Distance between both A pillars (upper)		970
18	Distance between both B pillars (upper)		960
19	Distance between both C pillars (upper)	950	950
20	Distance between both D pillars (upper)	—	—
21	Distance between both A pillars (door stop bracket)	1 366	
22	Distance between both B pillars (door stop bracket)	1 376	
23	Distance between both C pillars (at height of door lock bolt)	1 332	1 332
24	Distance between both A pillars (lower)	1 410	
25	Distance between both B pillars (lower)	1 378	
26	Distance between both C pillars (lower)	1 405	1 405
27	Distance between frame of rear side window (rear corner)	1 345	1 345
28	Diagonal of upper B pillar to lower B pillar	1 580	
29	Tailgate diagonal opening	—	1 240
30	Tailgate opening height	—	895
31	Width of rear quarter panel ends (at height of rear lamps)	—	962
32	Distance between both shock absorber mountings (centre of hole)	1 038	1 038
33	Width between inner quarter panels (end of wheel housing)		1 316
34	Depth of luggage compartment floor	945	790
35	Depth of luggage compartment floor (crossmember to butt joint overlap)	777	—
36	Diagonal of luggage compartment lid opening	1 082	—
37	Depth of luggage compartment lid opening	505	—
38	Diagonal of rear screen frame opening	1 215	—

All dimensions in mm without tolerances. Tolerance ± 2 mm. All dimensions reference points which are not shown in detail are based on the body ridges or sealing flanges.

NOTE:

- A pillar = Hinge pillar of front door — All Models
- C pillar = Lock pillar of rear door — Kadett
- B pillar = Lock pillar of front door — All Models
- D pillar = Side roof extension and frame of tailgate

TRIM PANELS, TRIM PANEL PARTS, SPOILER

Front Panelling — Remove and Install

REMOVE, DISCONNECT

1. Front panelling.
2. From side member — Two nuts.
3. From side bucket — Four bolts
4. From wheel housing inner panelling — Four bolts.
5. With heavy version "Front Member (Radiator Crossmember)" — Four body-bound rivets.

INSTALL, CONNECT

1. Front panelling.

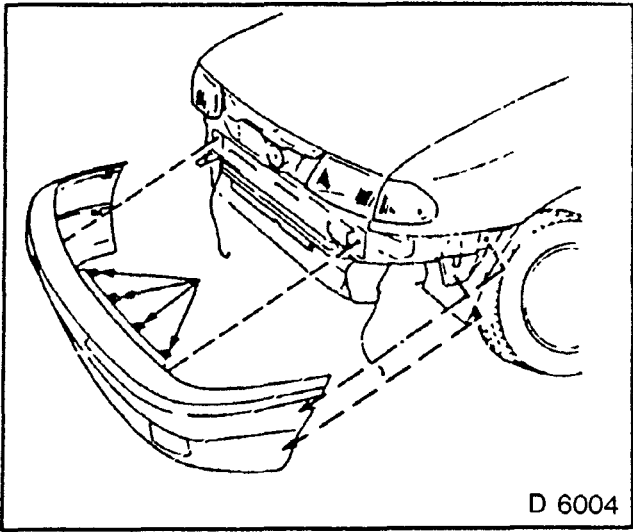


Fig. 13

Front Panelling — Replace

Only work that deviates from the operation "Front Panelling, Remove and Install" is described.

REMOVE, DISCONNECT

- 1 Front panelling.

ASSEMBLY

- 1 = Brackets to support, two bolts each
- 2 = Support to front panelling, eleven bolts.
- 3 = Assemble front panelling extensions and reinforcement, four body-bound rivets.
- 4 = Bolts on extension to front panelling, fourteen bolts.

INSTALL, CONNECT

- 1. Front panelling.

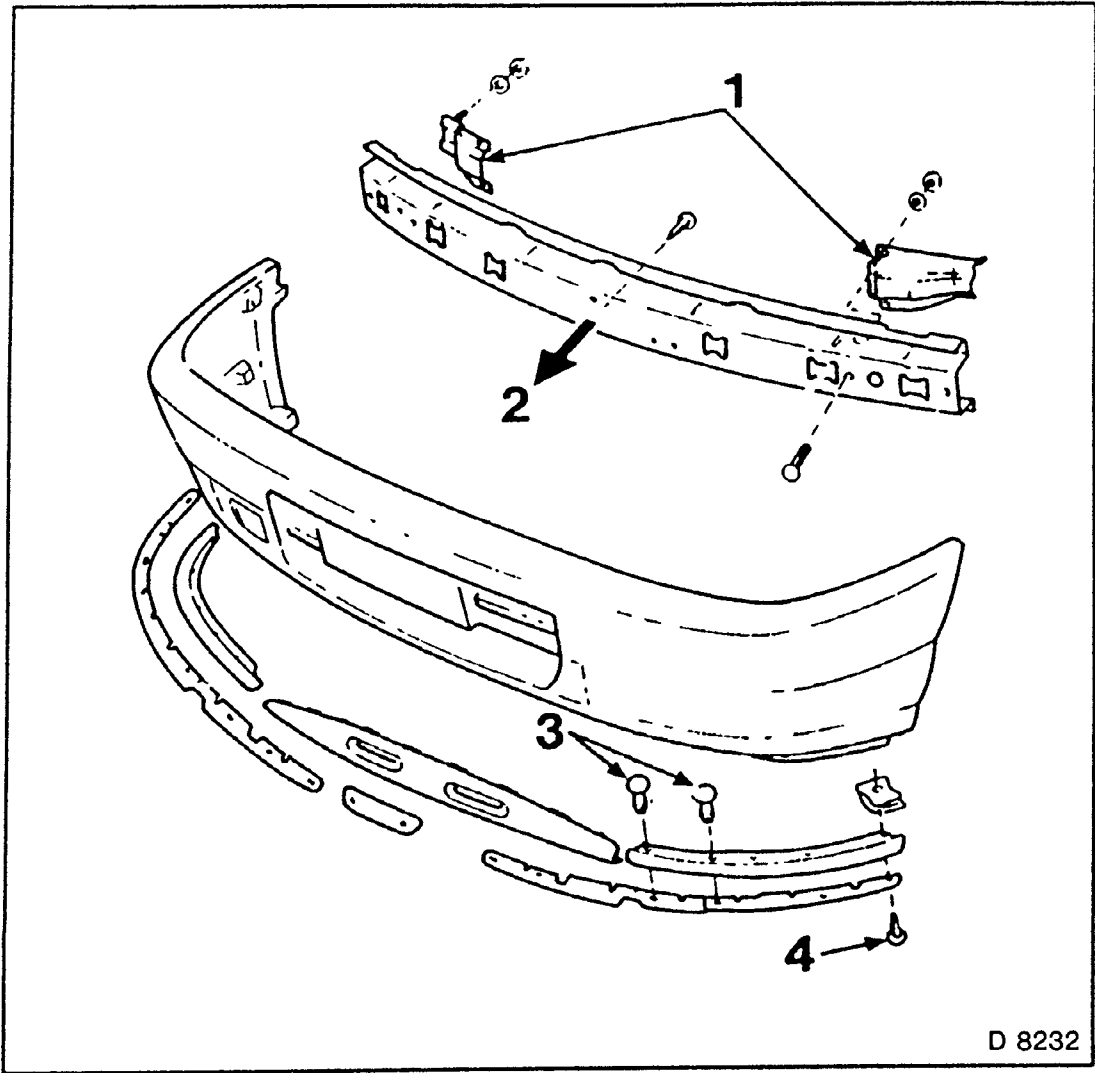


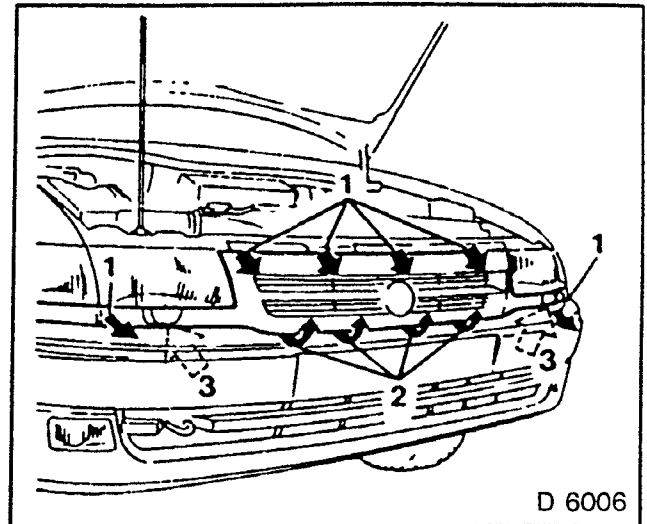
Fig. 14

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Radiator Grille, — Remove and Install

REMOVE, DISCONNECT

- 1 = Pull radiator grille forwards out of retaining lugs.
- 2 = Pull lower bracket upwards out of front panelling.
- 3 = Disconnect headlamp cleaner hose (if present).

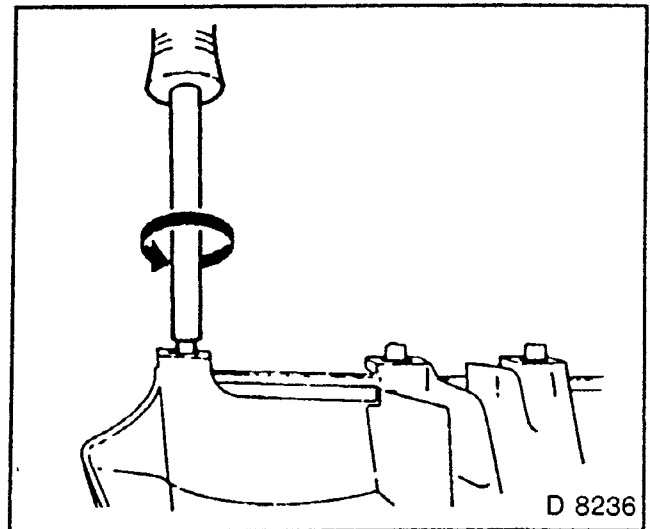


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Fig. 15

INSTALL, CONNECT

1. After painting, place grille in radiator grille.
2. Bond plastic pins by screwing with KM — 205.
3. Apply seal lips.
4. Radiator grille.



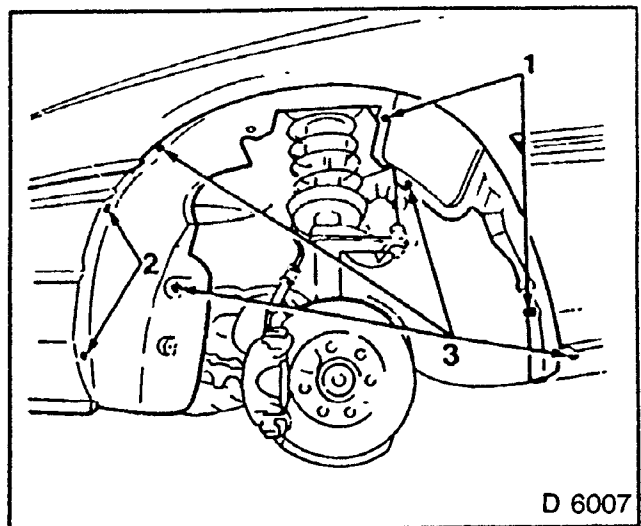
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Fig. 16

Wheel Well Inner Panelling — Remove and Install

REMOVE, DISCONNECT

- 1 Wheel well inner panelling.
 2. Two plastic nuts (1).
 3. Two bolts (2).
 4. Four body-bound rivets (3).
- Fig. 17 indicates wheel removed.



D 6007

Fig. 17

INSTALL, CONNECT

1. Wheel well inner panelling — use new plastic nuts.

Cowl Panel, — Remove and Install

REMOVE, DISCONNECT

- 1 = Windscreen wiper arms.
- 2 = Rubber seal.
- 3 = Water deflector.
- 4 = Cowl panel.
- 5 = Two cover caps, two bolts.
- 6 = Two plastic nuts.
- 7 = Two velcro strips.

INSTALL, CONNECT

- 1. Cowl panel.
- 2. Place paper strips between velcro strips as installation aid. Remove after installation.
- 3. Water deflector.
- 4. Rubber seal.
- 5. Windscreen wiper arms.

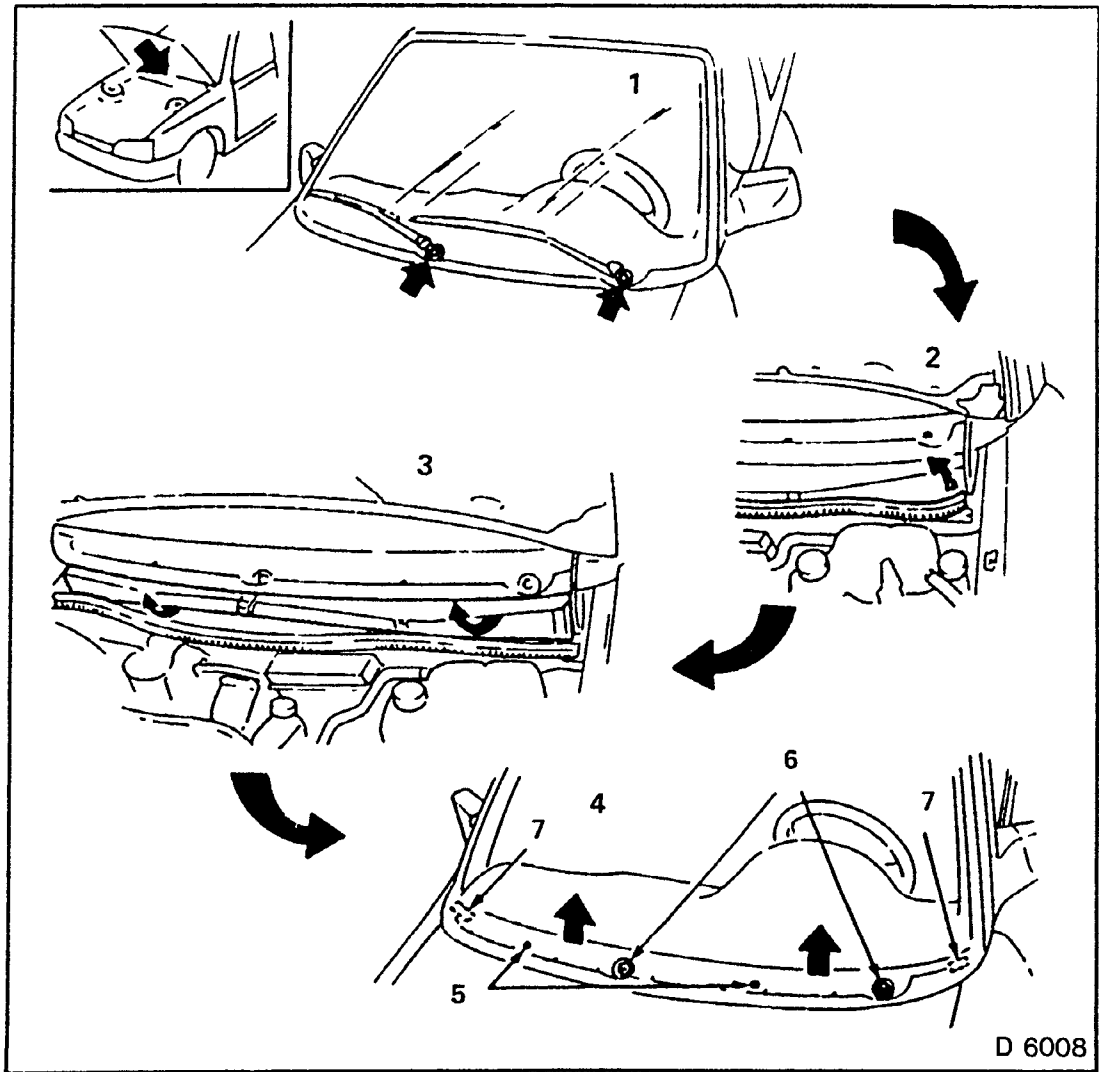


Fig. 18

Outer B Pillar Panel — Remove and Install

REMOVE, DISCONNECT

- 1. Panel — Four clips.

INSTALL, CONNECT

- 1. Panel.

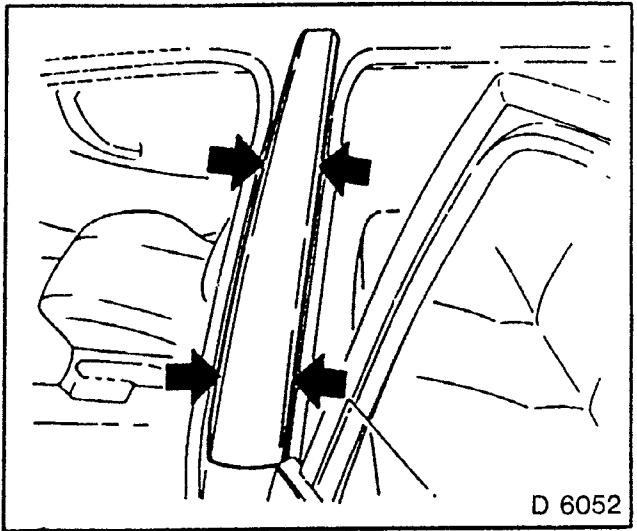


Fig. 20

Rear Panelling — Remove and Install (Kadett)

REMOVE, DISCONNECT

- 1. Licence plate lamp.
- 2. Rear end panel inner panelling.
- 3. Rear panelling.
- 4. On rear end panel — Two nuts.
- 5. On each wheel well — Two bolts.

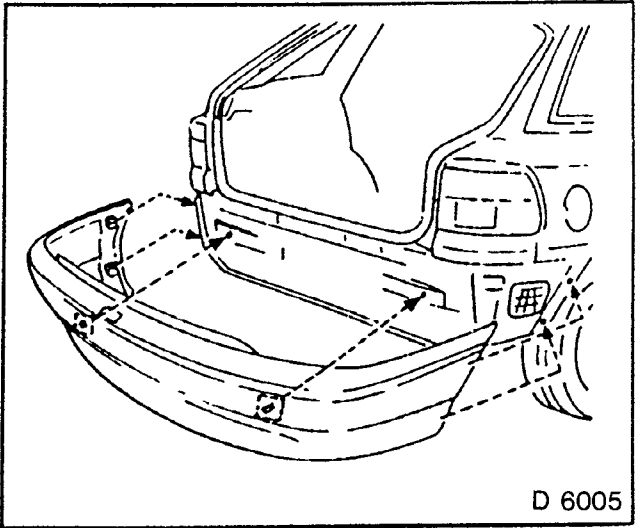


Fig. 21

INSTALL, CONNECT

(GSi styled bumper only)

- 1. After painting cement two damping strips 150 mm long to inside of rear panelling.
- 2. Rear panelling.
- 3. Inner panelling.
- 4. Licence plate lamp.

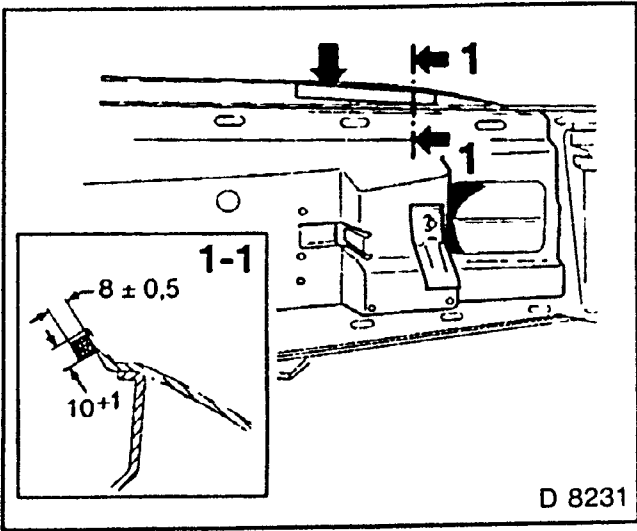


Fig. 22

Rear Panelling — Remove and Install (Astra)

REMOVE, DISCONNECT

- 1. Licence plate lamp.
- 2. Rear end panel inner panelling.
- 3. Rear panelling.
- 4. On rear end panel — Two nuts.
- 5. From wheel well — Two bolts on each.

INSTALL, CONNECT

- 1. Rear panelling.
- 2. Licence plate lamp.
- 3. Inner panelling.

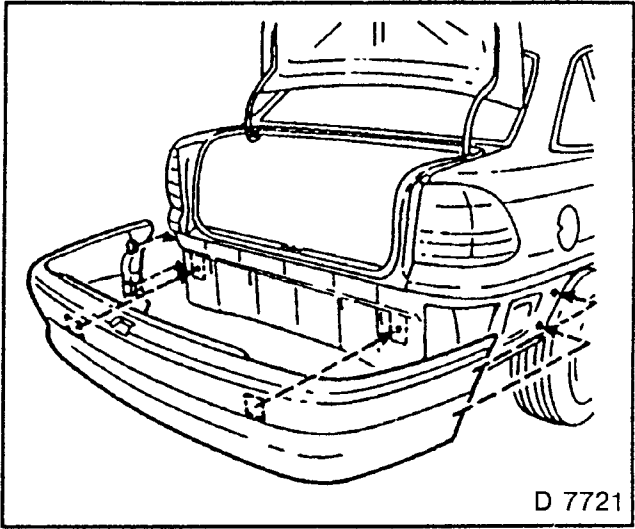


Fig. 23

Rear Spoiler — Remove and Install (Kadett)

REMOVE, DISCONNECT

- 1. Rear spoiler — Four bolts (1).
- 2. Rear spoiler member — Seven plastic nuts (2).
- 3. Remove spray nozzle (3).

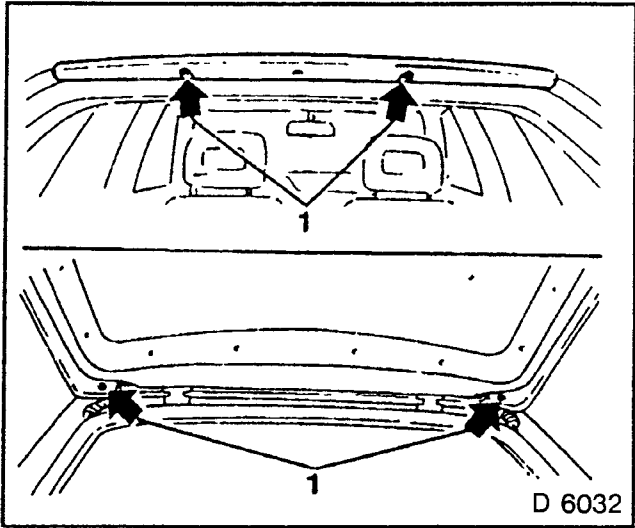


Fig. 24

INSTALL, CONNECT

- 1. Rear spoiler member — use new plastic nuts.
- 2. Spray nozzle.
- 3. Rear spoiler.

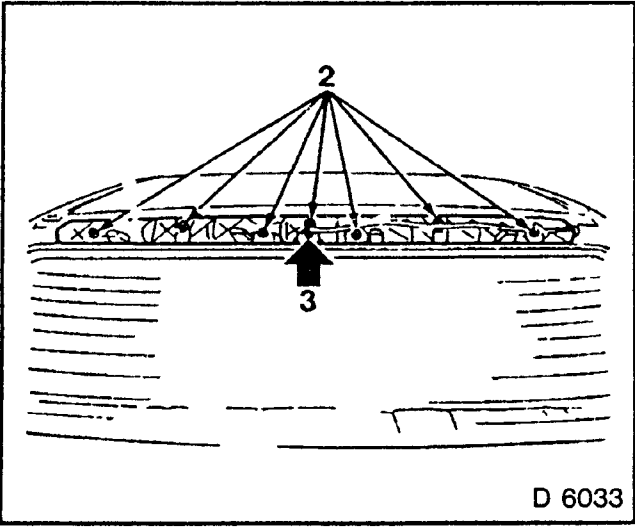


Fig. 25

Rear Spoiler — Remove and Install (Kadett) (200iS & 200ts)

REMOVE, DISCONNECT

- 1. Tailgate upper inner panelling.
- 2. Rear spoiler.
 - 1.1 = Lever out two covers
 - 1.2 = Two bolts
 - 2 = Eight bolts
 - 3 = Remove double-sided adhesive tape
 - 4 = Remove rear spoiler washer nozzle bracket
 - Seven plastic nuts
 - Four bolts
 - 5 = Remove seals and retaining clip.

INSTALL, CONNECT

- 1. Rear spoiler bracket.
- 2. Use new plastic nuts and new adhesive tape.
- 3. Rear spoiler.

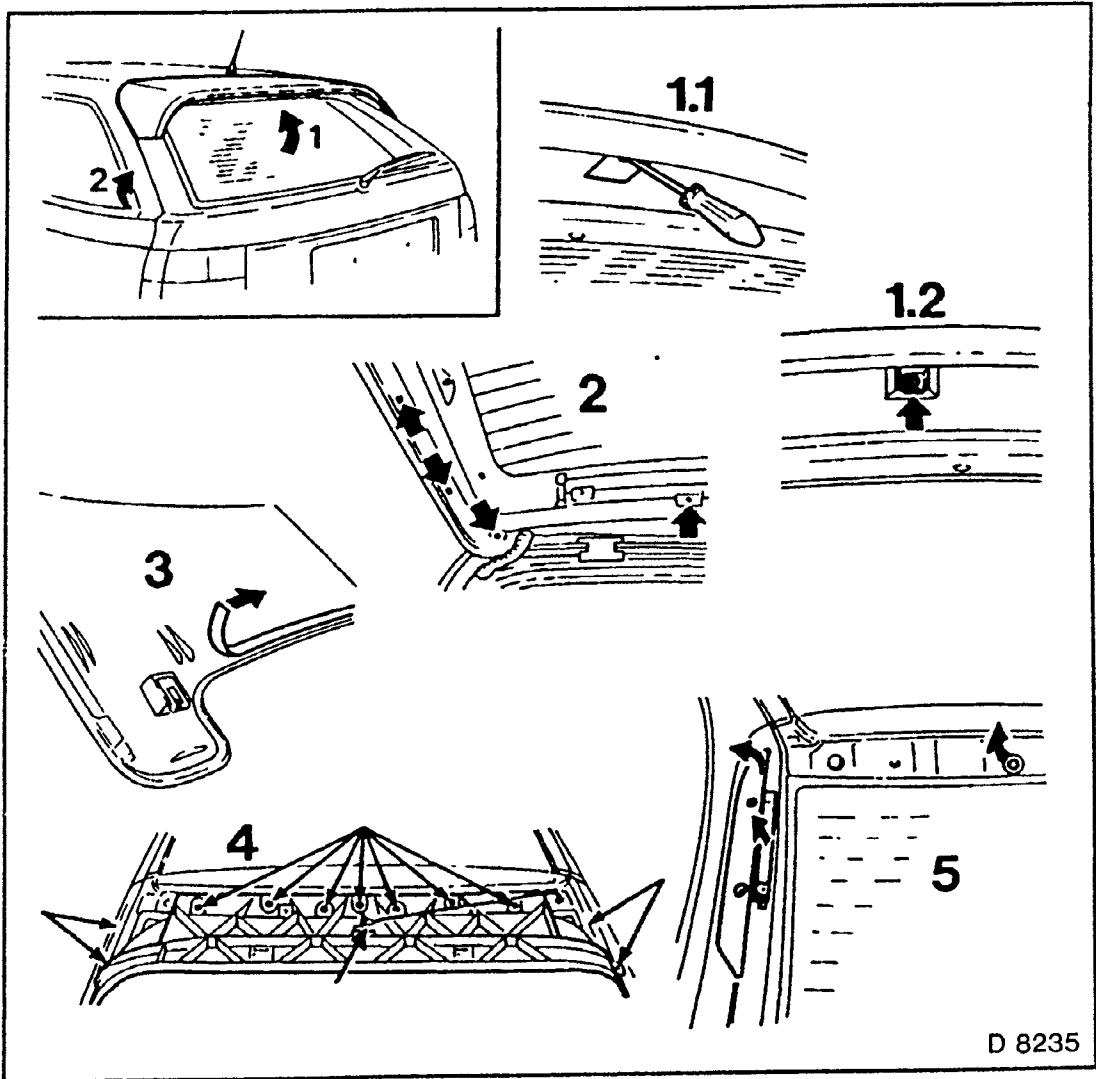


Fig. 26

Rear Spoiler — Install (Astra)

(Additional operation to replacement of luggage compartment lid)

Only installation of standard rear spoiler is described.

INSTALL, CONNECT

- 1. Transfer drill dimensions.
- 2. Drill holes.
- 3. Deburr hole edges and protect against corrosion.

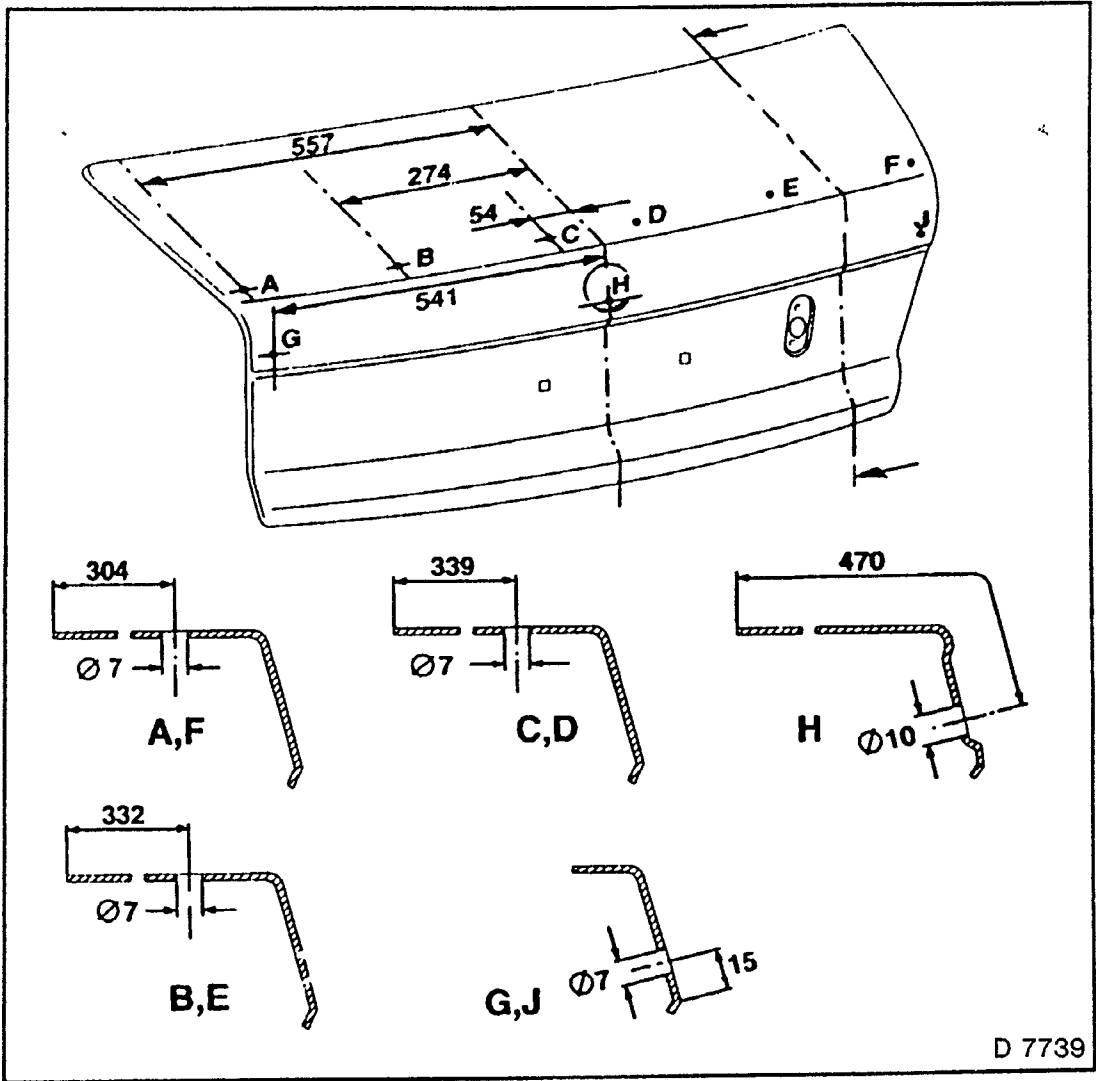


Fig. 27

INSTALL, CONNECT

- 1. Seal holes for company emblem on luggage compartment lid.
- 2. Clean cement surfaces on rear spoiler and luggage compartment lid.
- 3. Attach double-sided adhesive tape to rear spoiler (approximately 4 mm from outer edge).
- 4. Remove protective foil.
- 5 Place rear spoiler on luggage compartment lid.
- 6. Fasten rear spoiler.
- 7 Fastening parts:
 - 1 = Double-sided adhesive tape
 - 2.1 = Special hex bolt
 - 2.2 = Cap, self-adhesive
 - 2.3 = Seal
 - 3.1 = Hex nut with washer
 - 3.2 = Seal
- 8. Attach company emblem.

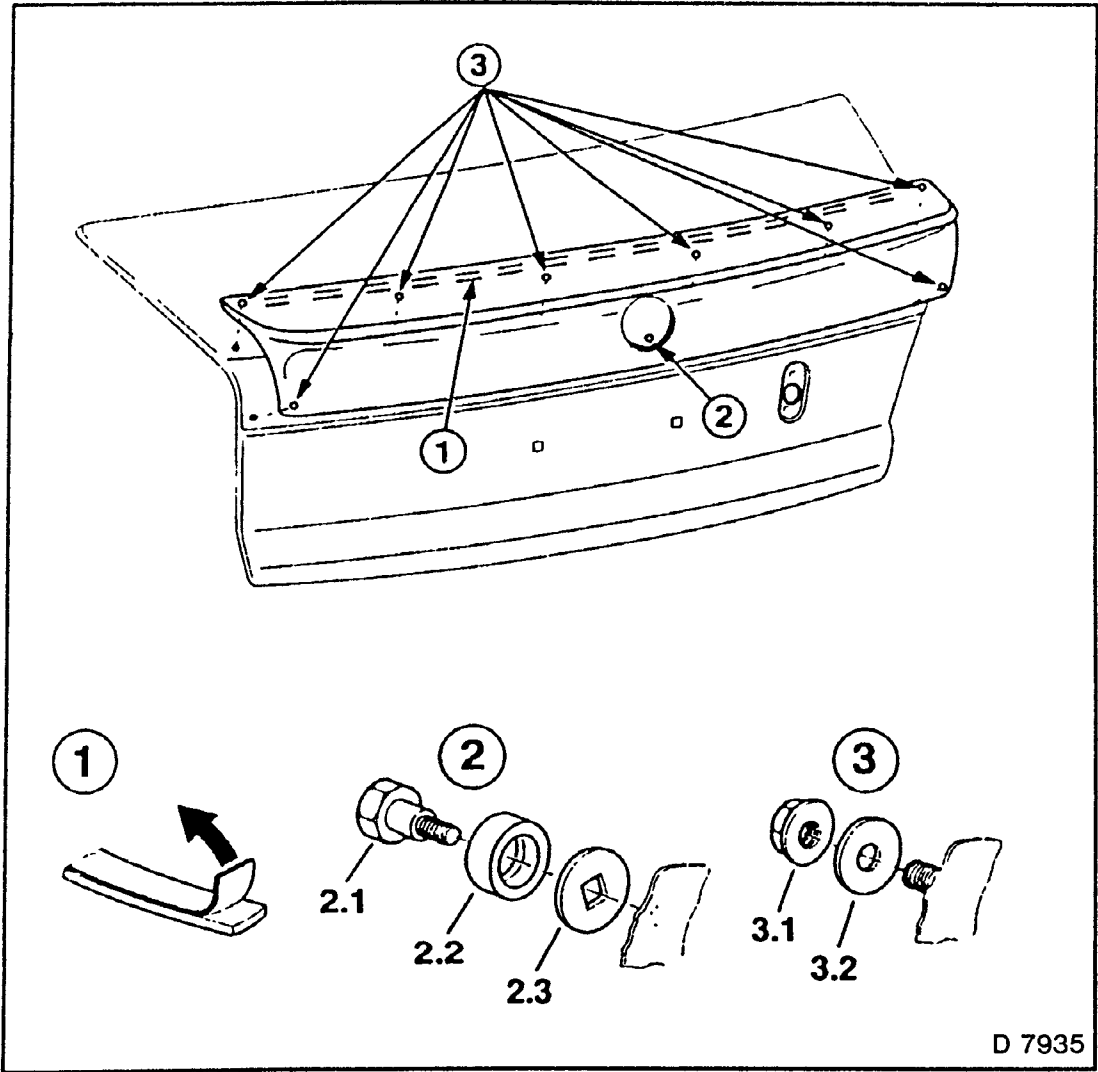


Fig. 28

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Tailgate Trim Strip — Remove and Install (Kadett) (200iS & 200ts)

REMOVE, DISCONNECT

1. Licence plate.
2. Pull trim strip towards rear out of retaining clamps.

INSTALL, CONNECT

1. Trim strip.
2. Licence plate.

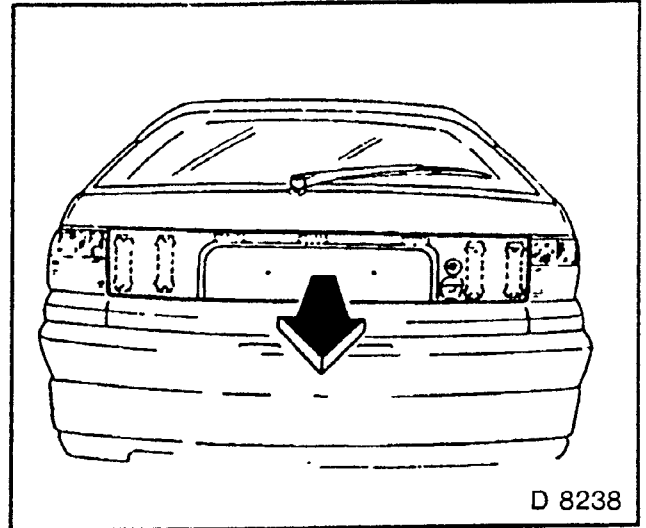


Fig. 29