

FRONT END SHEET METAL REPAIRS

– 90 [G2722855]

SPECIFICATIONS

NOTES:

- Breakstem Fastener (BSF) installation involves using the Jaguar Land Rover (JLR) approved BSF installation tool and requires a hole diameter of 6.5 mm.
- Self Piercing Rivet (SPR) installation requires using the JLR approved SPR tool.
- Make sure the JLR approved SPRs, die type and load are used during installation.
- Flow Form Rivet (FFR) installation requires using the JLR approved FFR installation tool.

Required fixings - Front End Sheet Metal Repairs.

Front Bumper Mounting

FIXING TYPE	CODE	DIE TYPE	LOAD (KN)	PART NUMBER	AMOUNT REQUIRED	WERS NUMBER
Breakstem Fastener	BSF E	N/A	N/A	LR044287	x 1	W780388 SJ46
Breakstem Fastener	BSF J	N/A	N/A	LR094293	x 4	W780623 SJ90
Breakstem Fastener	BSF M	N/A	N/A	LR147841	x 12	W780579 SJ90
Breakstem Fastener	BSF N	N/A	N/A	LR147842	x 5	W781049 SJ90

Front Fender Mounting Bracket Upper

FIXING TYPE	CODE	DIE TYPE	LOAD (KN)	PART NUMBER	AMOUNT REQUIRED	WERS NUMBER
Breakstem Fastener	BSF E	N/A	N/A	LR044287	x 4	W780388 SJ46
Breakstem Fastener	BSF M	N/A	N/A	LR147841	x 4	W780579 SJ90

Front Fender Mounting Bracket Lower

FIXING TYPE	CODE	DIE TYPE	LOAD (KN)	PART NUMBER	AMOUNT REQUIRED	WERS NUMBER
Breakstem Fastener	BSF M	N/A	N/A	LR147841	x 5	W780579 SJ90

Fender Apron Panel

FIXING TYPE	CODE	DIE TYPE	LOAD (KN)	PART NUMBER	AMOUNT REQUIRED	WERS NUMBER
Breakstem Fastener	BSF E	N/A	N/A	LR044287	x 12	W780388 SJ46
Breakstem Fastener	BSF L	N/A	N/A	LR147840	x 3	W781047 SJ90
Breakstem Fastener	BSF M	N/A	N/A	LR147841	x 22	W780579 SJ90
Breakstem Fastener	BSF N	N/A	N/A	LR147842	x 12	W781049 SJ90

Fender Apron Panel Reinforcement

FIXING TYPE	CODE	DIE TYPE	LOAD (KN)	PART NUMBER	AMOUNT REQUIRED	WERS NUMBER
Breakstem Fastener	BSF G	N/A	N/A	LR044288	x 2	W780389 SJ46
Breakstem Fastener	BSF M	N/A	N/A	LR147841	x 11	W780579 SJ90
Rivnut	Rivnut G	N/A	N/A	C2C10348	x 1	W706538

Suspension Top Mount

FIXING TYPE	CODE	DIE TYPE	LOAD (KN)	PART NUMBER	AMOUNT REQUIRED	WERS NUMBER
Breakstem Fastener	BSF G	N/A	N/A	LR044288	x 1	W780389 SJ46
Breakstem Fastener	BSF M	N/A	N/A	LR147841	x 20	W780579 SJ90
Breakstem Fastener	BSF N	N/A	N/A	LR147842	x 11	W781049 SJ90

Front Side Member And Closing Panel Section

FIXING TYPE	CODE	DIE TYPE	LOAD (KN)	PART NUMBER	AMOUNT REQUIRED	WERS NUMBER
Breakstem Fastener	BSF E	N/A	N/A	LR044287	x 4	W780388 SJ46
Breakstem Fastener	BSF M	N/A	N/A	LR147841	x 10	W780579 SJ90
Breakstem Fastener	BSF N	N/A	N/A	LR147842	x 5	W781049 SJ90
Self Piercing Rivet	SPR L6	Pip	50 kN	LR043557	x 11	W709936 S900
Flow Form Rivet	FFR S5	N/A	55 kN	.	x 2	.

Front Side Member And Suspension Top Mount Assembly

FIXING TYPE	CODE	DIE TYPE	LOAD (KN)	PART NUMBER	AMOUNT REQUIRED	WERS NUMBER
Breakstem Fastener	BSF E	N/A	N/A	LR044287	x 11	W780388 SJ46

FIXING TYPE	CODE	DIE TYPE	LOAD (KN)	PART NUMBER	AMOUNT REQUIRED	WERS NUMBER
Breakstem Fastener	BSF M	N/A	N/A	LR147841	x 41	W780579 SJ90
Breakstem Fastener	BSF N	N/A	N/A	LR147842	x 10	W781049 SJ90

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