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2020.0 DEFENDER (LE), 501-27

FRONT END SHEET METAL REPAIRS

FRONT BUMPER MOUNTING – 110 (G2394397)

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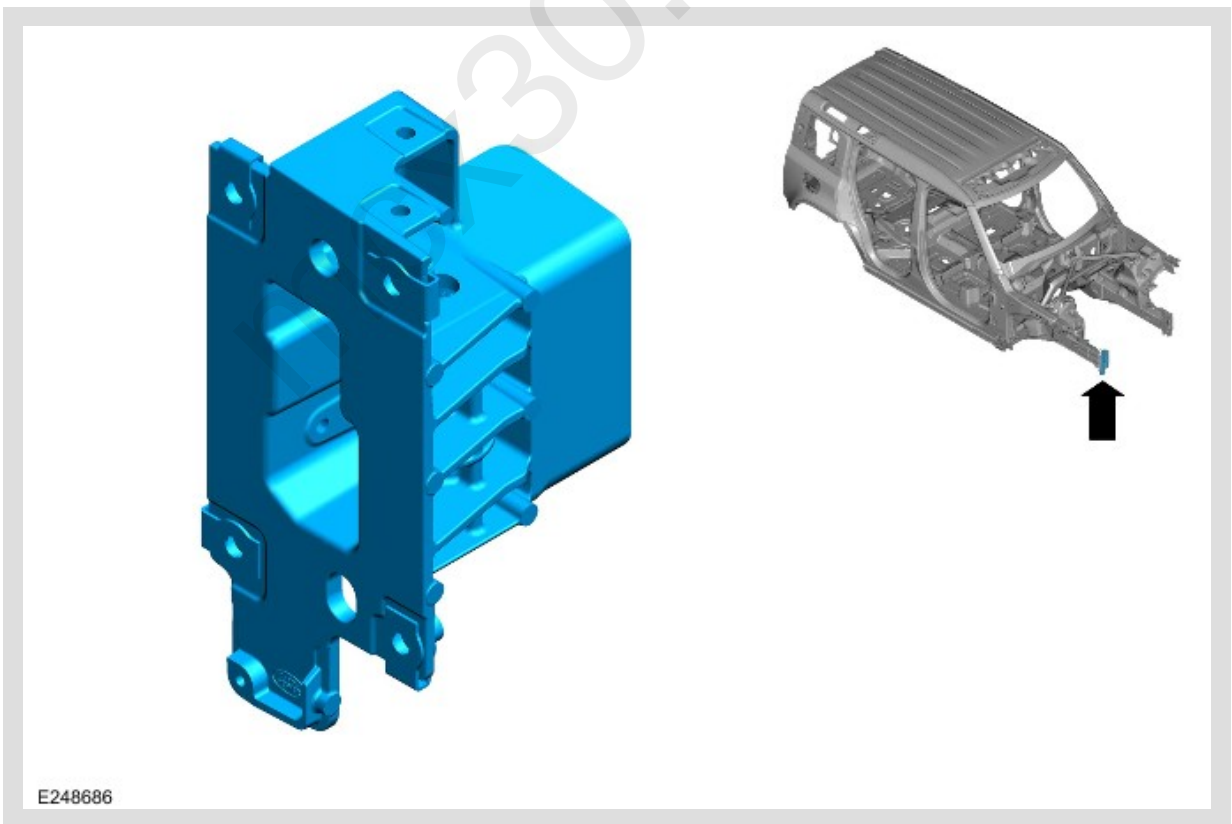
REMOVAL

 NOTE:

The front bumper mounting is installed in conjunction with:

- Front armature
- Hood latch panel
- Cooling module
- Auxiliary radiator
- Charge air radiator.

1.



The front bumper mounting is serviced as indicated.

2.

Before commencing this procedure make sure that you are aware of all Health and Safety requirements. Refer to: [Health and Safety Precautions](#) (100-00 General Information, Description and Operation).

3.



NOTES:

- Where Breakstem Fastener (BSF) removal is instructed remove fastener shaft with a 4 mm punch and remove the head with a 6.5 mm drill bit. Clean all the drilled holes to make sure they are free from debris.
- Where Self Piercing Rivet (SPR) removal is instructed use either the approved SPR tool or 5.3 mm drill bit.
- Any joints sealed as part of vehicle manufacture must be sealed as part of the repair.

When installing the front bumper mounting make sure that you are aware of the methods, tools and fixings used in this procedure.

Refer to: [Body Repairs](#) (501-25A Body Repairs - General Information, Description and Operation).

Refer to: [Adhesives, Fixings and Consumables](#) (501-25A Body Repairs - General Information, Description and Operation).

4.

For additional information on the fixings required to complete this procedure

Refer to: [Specifications - 110](#) (501-27 Front End Sheet Metal Repairs, Specifications).

5.

For additional removal information

Refer to: [Front Armature](#) (501-19 Bumpers, Removal and Installation).

6.

For additional removal information

Refer to: [Hood Latch Panel](#) (501-02 Front End Body Panels, Removal and Installation).

7.

For additional removal information

Refer to: [Cooling Module](#) (303-03A Engine Cooling - INGENIUM I4 2.0L Diesel, Removal and Installation).

Refer to: [Cooling Module](#) (303-03B Engine Cooling - INGENIUM I4 2.0L Petrol/INGENIUM I4 2.0L Petrol - PHEV, Removal and Installation).

Refer to: [Cooling Module](#) (303-03C Engine Cooling - INGENIUM I6 3.0L Petrol, Removal and Installation).

8.

For additional removal information

Refer to: [Auxiliary Radiator](#) (303-03B Engine Cooling - INGENIUM I4 2.0L Petrol/INGENIUM I4 2.0L Petrol - PHEV, Removal and Installation).

9.

For additional removal information

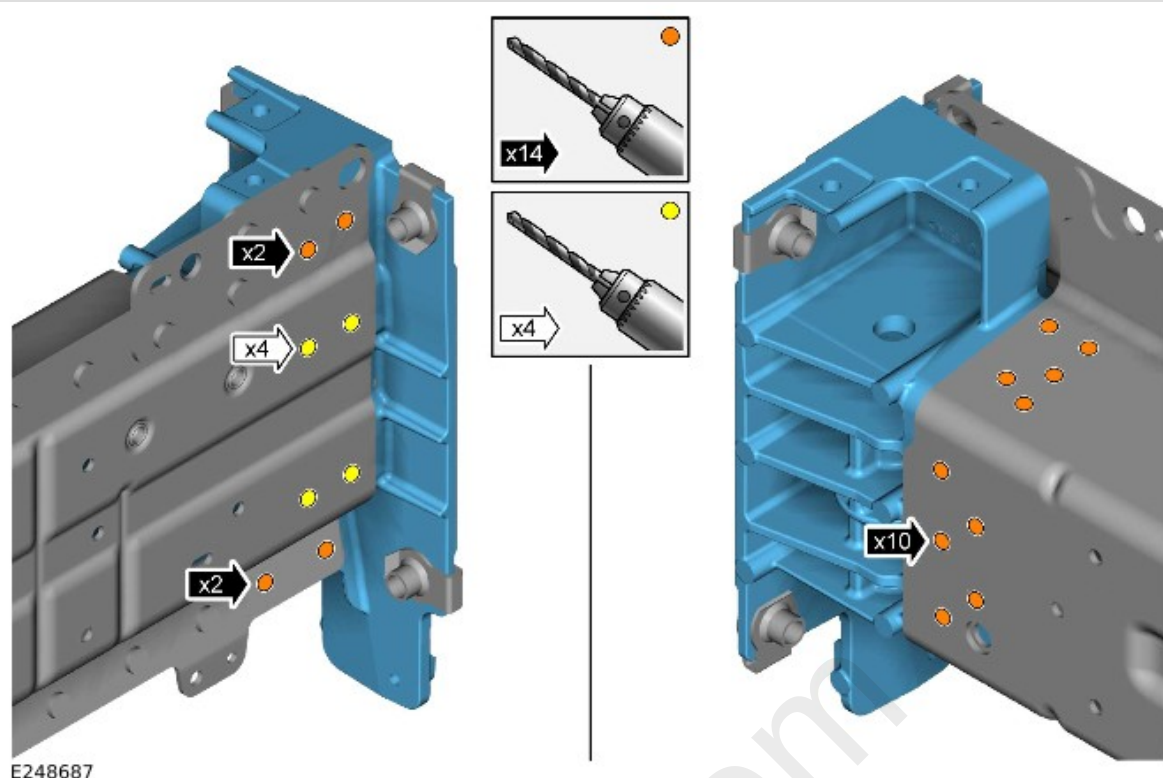
Refer to: [Charge Air Radiator](#) (303-03A Engine Cooling - INGENIUM I4 2.0L Diesel, Removal and Installation).

Refer to: [Charge Air Radiator](#) (303-03B Engine Cooling - INGENIUM I4 2.0L Petrol/INGENIUM I4 2.0L Petrol - PHEV, Removal and Installation).

10.

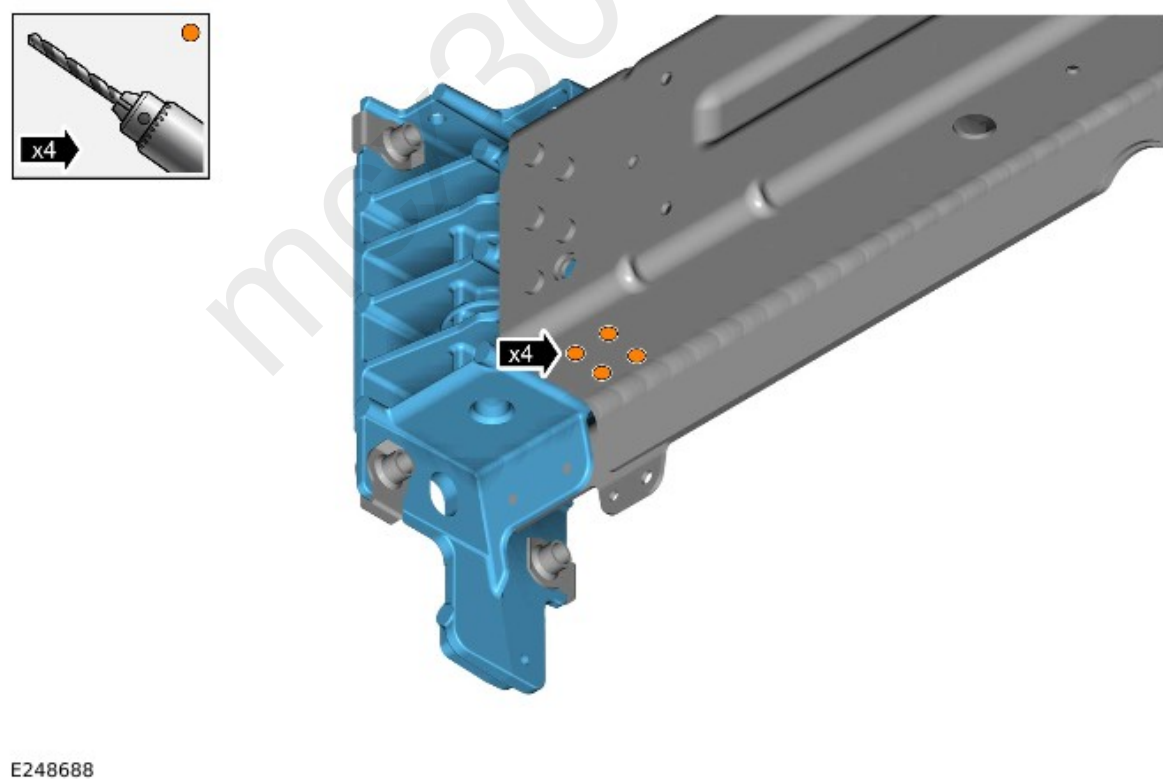
Release and position the wiring harness to one side.

11.



Remove the breakstem fasteners and Self Piercing Rivets (SPRs) as indicated.

12.



Remove the SPRs as indicated.

13.

Carefully separate the joints and remove the front bumper mounting.

⚠ CAUTION:

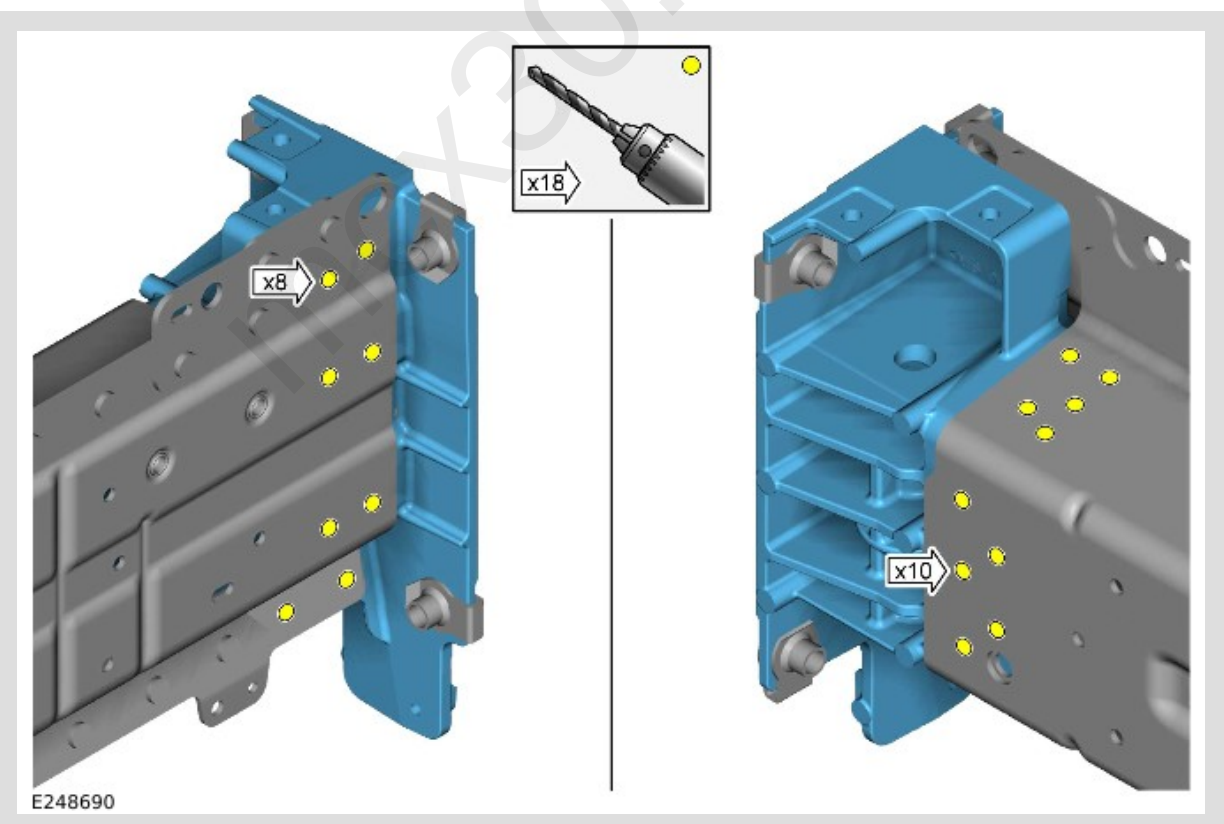
Where structural adhesive is to be applied between surfaces it is essential compression is applied to the joints during the curing period.

△ NOTE:

Breakstem Fastener (BSF) installation involves using the Jaguar Land Rover (JLR) approved BSF installation tool and requires a hole diameter of 6.5 mm.

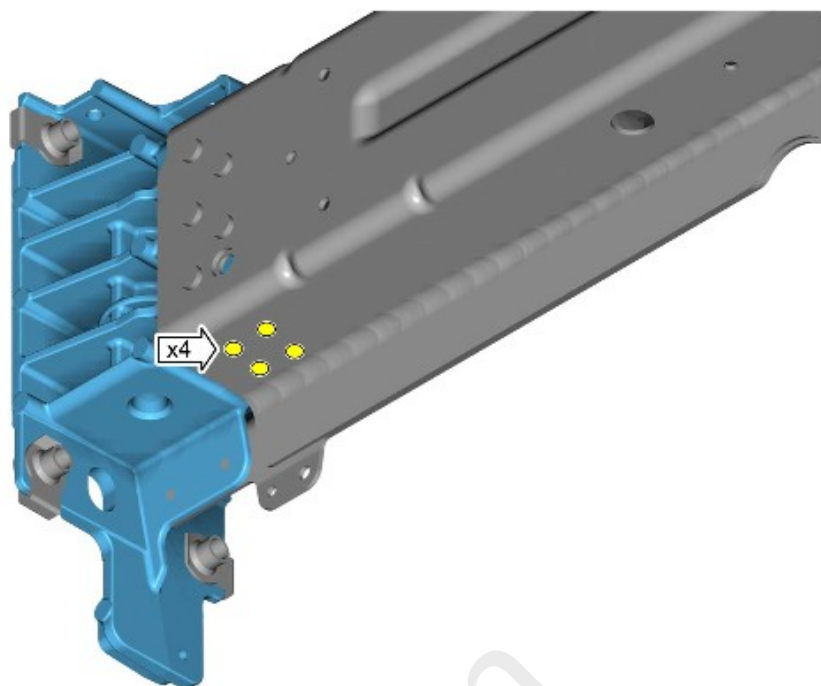
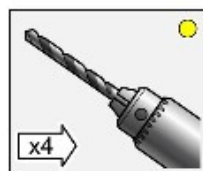
1. Remove the rivet remnants.
2. Dress the flanges where necessary.
3. Offer up the new front bumper mounting and clamp into position. Check alignment, if correct proceed to next step, if not rectify and check the alignment again before proceeding.

4.



Drill holes where the Breakstem Fasteners (BSFs) are to be installed as indicated.

5.



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Drill holes where the BSFs are to be installed as indicated.

6. Remove the new front bumper mounting.

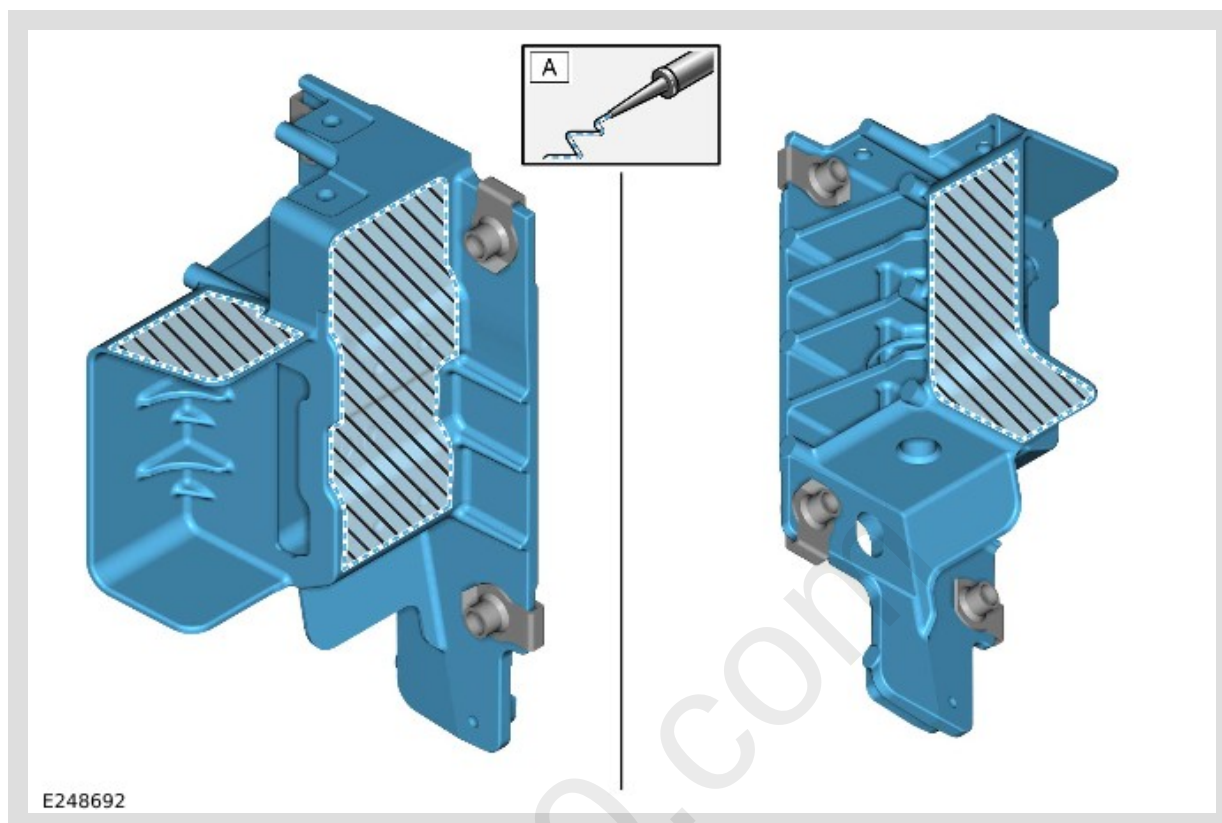
7. Deburr the drilled holes.

8. Clean and prepare the panel surfaces.

9.

NOTE:

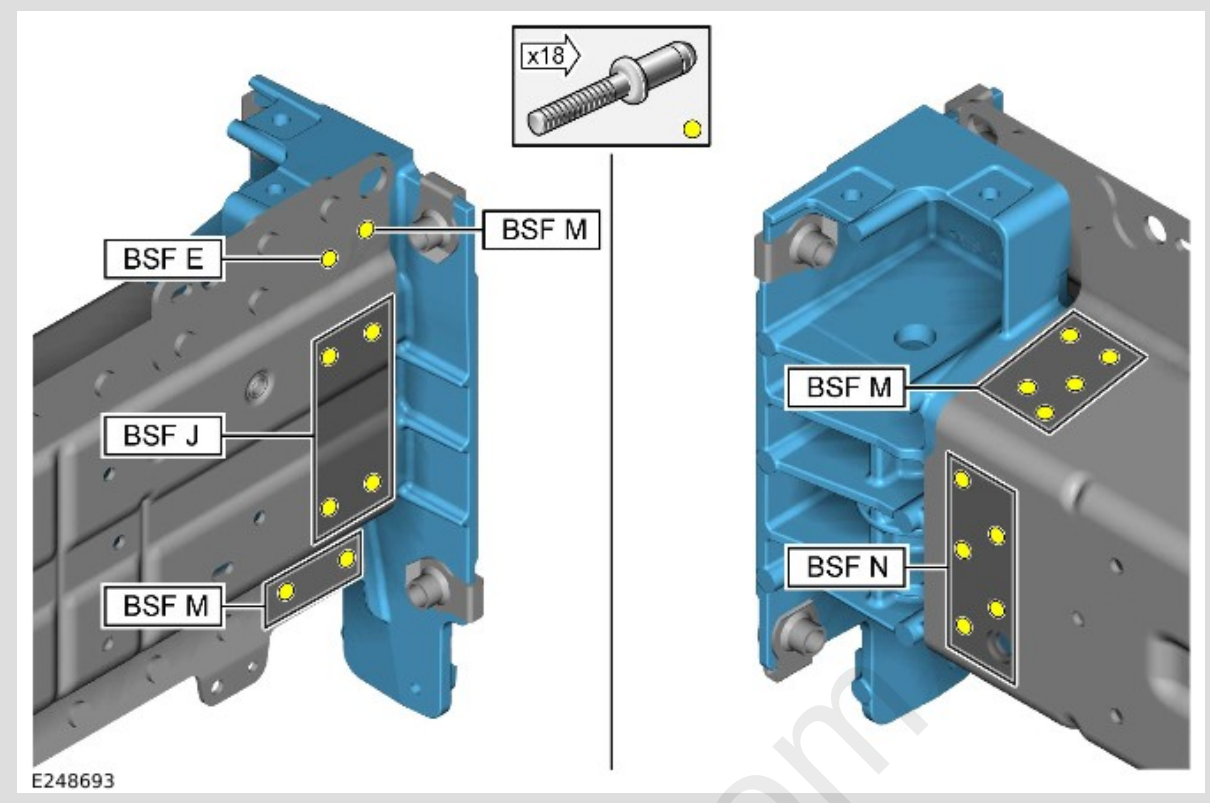
Make sure a continuous bead of adhesive surrounds the fixing holes.



Apply a 5 mm zig zag bead of the JLR recommended bonding material as indicated.

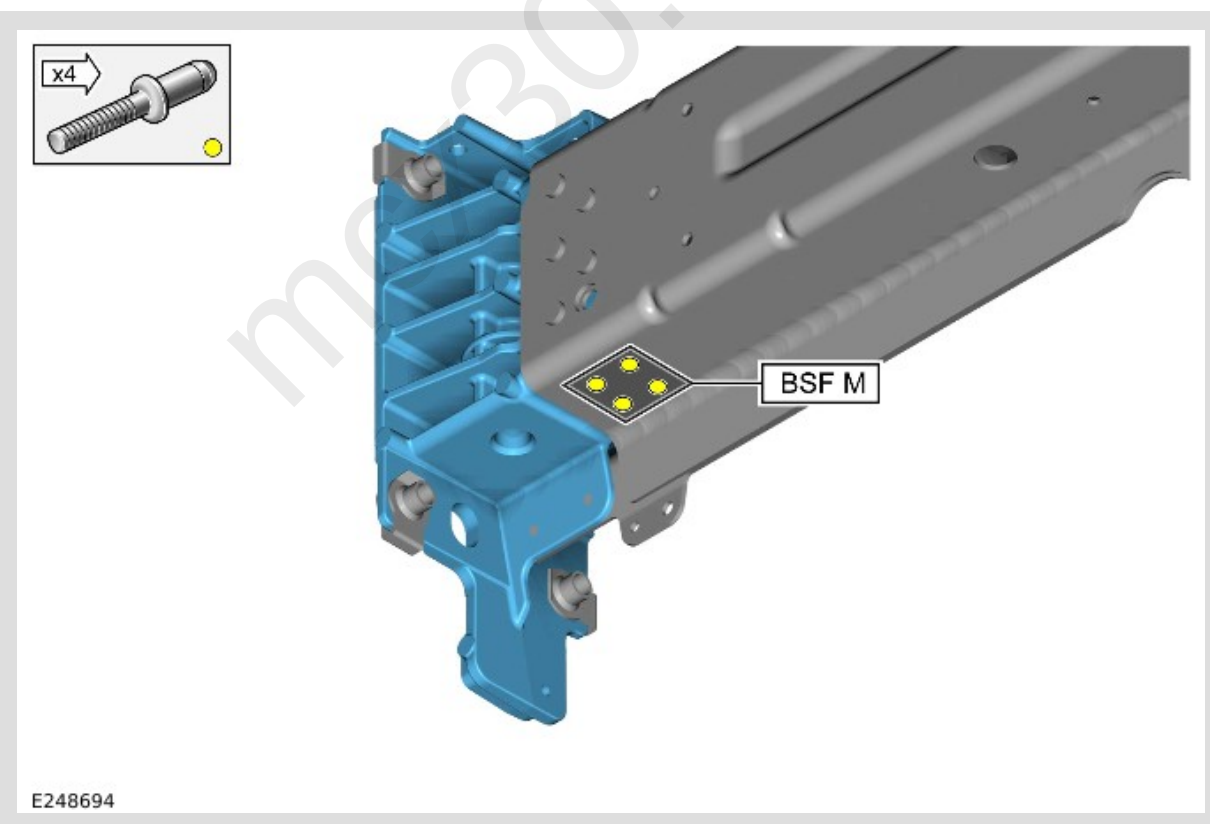
10. Offer up the new front bumper mounting and clamp into position. Check alignment, if correct proceed to next step, if not rectify and check the alignment again before proceeding.

11.



Install the BSFs as indicated.

12.



Install the BSFs as indicated.

13.

Remove any excess adhesive.

14. Make sure that any open or exposed panel joints are correctly sealed.

15. Make sure corrosion protection is applied to all areas affected by repair.

16. Make sure that all installed BSFs are sealed using a JLR recommended sealer.



NOTE:

The installation of associated panels and components is the reversal of removal procedure.

17. For additional installation information.

Refer to: [Charge Air Radiator](#) (303-03A Engine Cooling - INGENIUM I4 2.0L Diesel, Removal and Installation).

Refer to: [Charge Air Radiator](#) (303-03B Engine Cooling - INGENIUM I4 2.0L Petrol/INGENIUM I4 2.0L Petrol - PHEV, Removal and Installation).

18. For additional installation information.

Refer to: [Auxiliary Radiator](#) (303-03B Engine Cooling - INGENIUM I4 2.0L Petrol/INGENIUM I4 2.0L Petrol - PHEV, Removal and Installation).

19. For additional installation information.

Refer to: [Cooling Module](#) (303-03A Engine Cooling - INGENIUM I4 2.0L Diesel, Removal and Installation).

Refer to: [Cooling Module](#) (303-03B Engine Cooling - INGENIUM I4 2.0L Petrol/INGENIUM I4 2.0L Petrol - PHEV, Removal and Installation).

Refer to: [Cooling Module](#) (303-03C Engine Cooling - INGENIUM I6 3.0L Petrol, Removal and Installation).

20. For additional installation information.

Refer to: [Hood Latch Panel](#) (501-02 Front End Body Panels, Removal and Installation).

21. For additional installation information.

Refer to: [Front Armature](#) (501-19 Bumpers, Removal and Installation).