

SIDE PANEL SHEET METAL REPAIRS

– 90 [G2722857]

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 - Side Panel Sheet Metal Repairs.

A-Pillar Outer Panel

FIXING TYPE	CODE	DIE TYPE	LOAD (KN)	PART NUMBER	AMOUNT REQUIRED	WERS NUMBER
Breakstem Fastener	BSF G	N/A	N/A	LR044288	x 3	W780389 SJ46
Breakstem Fastener	BSF L	N/A	N/A	LR147840	x 2	W781047 SJ90
Breakstem Fastener	BSF M	N/A	N/A	LR147841	x 4	W780579 SJ90
Self Piercing Rivet	SPR L16FS	Shallow	45 kN	LR099825	x 1	W780565 SJ91
Self Piercing Rivet	SPR L16G	Pipped	45 kN	LR099825	x 24	W780565 SJ91
Self Piercing Rivet	SPR L21AS	Shallow	45 kN	LR099826	x 9	W780566 SJ91
Flow Form Rivet	FFR S3	N/A	55 kN	LR146795	x 3	W585443 SJ50

A-Pillar Section

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 L	N/A	N/A	LR147840	x 5	W781047 SJ90
Breakstem Fastener	BSF M	N/A	N/A	LR147841	x 4	W780579 SJ90
Self Piercing Rivet	SPR L16FS	Shallow	45 kN	LR099825	x 10	W780565 SJ91

FIXING TYPE	CODE	DIE TYPE	LOAD (KN)	PART NUMBER	AMOUNT REQUIRED	WERS NUMBER
Self Piercing Rivet	L21AS	Shallow	45 kN	LR099826	x 2	W780566 SJ91
Flow Form Rivet	FFR S3	N/A	55 kN	LR146795	x 2	W585443 SJ50

Rocker Panel Section

FIXING TYPE	CODE	DIE TYPE	LOAD (KN)	PART NUMBER	AMOUNT REQUIRED	WERS NUMBER
Breakstem Fastener	BSF L	N/A	N/A	LR147840	x 5	W781047 SJ90
Self Piercing Rivet	SPR L16FS	Shallow	45 kN	LR099825	x 9	W780565 SJ91

Side Panel. Vehicles With Roof Opening Panel.

FIXING TYPE	CODE	DIE TYPE	LOAD (KN)	PART NUMBER	AMOUNT REQUIRED	WERS NUMBER
Breakstem Fastener	BSF G	N/A	N/A	LR044288	x 3	W780389 SJ46
Breakstem Fastener	BSF K	N/A	N/A	LR147839	x 14	W781165 SJ90
Breakstem Fastener	BSF L	N/A	N/A	LR147840	x 15	W781047 SJ90
Breakstem Fastener	BSF M	N/A	N/A	LR147841	x 7	W780579 SJ90
Self Piercing Rivet	SPR L5K	Pip	50 kN	LR043553	x 6	W708716 S900
Self Piercing Rivet	SPR L13DS	Shallow	45 kN	LR043559	x 1	W710246 S900
Self Piercing Rivet	SPR L16AS	Shallow	50 kN	LR099825	x 11	W780565 SJ91
Self Piercing Rivet	SPR L16FS	Shallow	45 kN	LR099825	x 11	W780565 SJ91
Self Piercing Rivet	SPR L16G	Pipped	45 kN	LR099825	x 40	W780565 SJ91
Self Piercing Rivet	SPR L19B	Flat Bottom	45 kN	LR099830	x 9	W780648 SJ91
Self Piercing Rivet	SPR L21KS	Shallow	45 kN	LR099826	x 2	W780566 SJ91
Flow Form Rivet	FFR S1	N/A	55 kN	LR146792	x 29	W585441 SJ50
Flow Form Rivet	FFR S2	N/A	55 kN	LR146794	x 26	W585442 SJ50
Flow Form Rivet	FFR S3	N/A	55 kN	LR146795	x 17	W585443 SJ50

Side Panel. Vehicles Without Roof Opening Panel.

FIXING TYPE	CODE	DIE TYPE	LOAD (KN)	PART NUMBER	AMOUNT REQUIRED	WERS NUMBER
Breakstem Fastener	BSF G	N/A	N/A	LR044288	x 3	W780389 SJ46
Breakstem Fastener	BSF K	N/A	N/A	LR147839	x 14	W781165 SJ90

FIXING TYPE	CODE	DIE TYPE	LOAD (KN)	PART NUMBER	AMOUNT REQUIRED	WERS NUMBER
Breakstem Fastener	BSF L	N/A	N/A	LR147840	x 10	W781047 SJ90
Breakstem Fastener	BSF M	N/A	N/A	LR147841	x 7	W780579 SJ90
Self Piercing Rivet	SPR L5K	Pip	50 kN	LR043553	x 2	W708716 S900
Self Piercing Rivet	SPR L16AS	Shallow	50 kN	LR099825	x 11	W780565 SJ91
Self Piercing Rivet	SPR L16FS	Shallow	45 kN	LR099825	x 11	W780565 SJ91
Self Piercing Rivet	SPR L16G	Pipped	45 kN	LR099825	x 40	W780565 SJ91
Self Piercing Rivet	SPR L19B	Flat Bottom	45 kN	LR099830	x 9	W780648 SJ91
Self Piercing Rivet	SPR L21KS	Shallow	45 kN	LR099826	x 2	W780566 SJ91
Flow Form Rivet	FFR S1	N/A	55 kN	LR146792	x 29	W585441 SJ50
Flow Form Rivet	FFR S2	N/A	55 kN	LR146794	x 26	W585442 SJ50
Flow Form Rivet	FFR S3	N/A	55 kN	LR146795	x 17	W585443 SJ50

Side Panel Reinforcement Front Assembly. Vehicles With Roof Opening Panel.

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 18	W780579 SJ90
Breakstem Fastener	BSF N	N/A	N/A	LR147842	x 6	W781049 SJ90
Self Piercing Rivet	SPR L3	Flat Bottom	30 kN	LR043551	x 10	W708711 S900
Self Piercing Rivet	SPR L19DS	Shallow	45 kN	LR099830	x 7	W780648 SJ91
Flow Form Rivet	FFR S2	N/A	55 kN	LR146794	x 5	W585442 SJ50
Flow Form Rivet	FFR S4	N/A	55 kN	LR146796	x 1	W585444 SJ50

Side Panel Reinforcement Front Assembly. Vehicles Without Roof Opening Panel.

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 18	W780579 SJ90
Breakstem Fastener	BSF N	N/A	N/A	LR147842	x 6	W781049 SJ90
Self Piercing Rivet	SPR L3	Flat Bottom	30 kN	LR043551	x 7	W708711 S900
Self Piercing Rivet	SPR L19DS	Shallow	45 kN	LR099830	x 5	W780648 SJ91
Flow Form Rivet	FFR S2	N/A	55 kN	LR146794	x 2	W585442 SJ50

FIXING TYPE	CODE	DIE TYPE	LOAD (KN)	PART NUMBER	AMOUNT REQUIRED	WERS NUMBER
Flow Form Rivet	FFR S4	N/A	55 kN	LR146796	x 1	W585444 SJ50

A-Pillar Reinforcement

FIXING TYPE	CODE	DIE TYPE	LOAD (KN)	PART NUMBER	AMOUNT REQUIRED	WERS NUMBER
Breakstem Fastener	BSF G	N/A	N/A	LR044288	x 3	W780389 SJ46
Breakstem Fastener	BSF L	N/A	N/A	LR147840	x 2	W781047 SJ90
Breakstem Fastener	BSF M	N/A	N/A	LR147841	x 10	W780579 SJ90
Breakstem Fastener	BSF N	N/A	N/A	LR147842	x 2	W781049 SJ90
Flow Form Rivet	CFFR CS2	N/A	55 kN	LR146799	X 1	W585447 SJ50

Rocker Panel Inner

FIXING TYPE	CODE	DIE TYPE	LOAD (KN)	PART NUMBER	AMOUNT REQUIRED	WERS NUMBER
Breakstem Fastener	BSF L	N/A	N/A	LR147840	x 20	W781047 SJ90
Breakstem Fastener	BSF M	N/A	N/A	LR147841	x 14	W780579 SJ90
Self Piercing Rivet	SPR L22DS	Shallow	45 kN	LR099829	x 2	W780638 SJ91

Rocker 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 3	W780389 SJ46
Breakstem Fastener	BSF M	N/A	N/A	LR147841	x 18	W780579 SJ90
Breakstem Fastener	BSF N	N/A	N/A	LR147842	x 4	W781049 SJ90

B-Pillar Inner Panel Lower

FIXING TYPE	CODE	DIE TYPE	LOAD (KN)	PART NUMBER	AMOUNT REQUIRED	WERS NUMBER
Breakstem Fastener	BSF L	N/A	N/A	LR147840	x 6	W781047 SJ90
Breakstem Fastener	BSF M	N/A	N/A	LR147841	x 2	W780579 SJ90
Breakstem Fastener	BSF N	N/A	N/A	LR147842	x 6	W781049 SJ90
Flow Form Rivet	CFFR CS1	N/A	55 kN	LR146798	x 2	W585446 SJ50
Friction Drilling Screw	M6 FDS	N/A	N/A	T4K7064	x 1	W781565 SJ50

B-Pillar Reinforcement

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 L	N/A	N/A	LR147840	x 1	W781047 SJ90
Breakstem Fastener	BSF M	N/A	N/A	LR147841	x 5	W780579 SJ90
Friction Drilling Screw	M6 FDS	N/A	55 kN	T4K7064	x 5	W781565 SJ50

cmIjaGFyZG1vcnRvbjsyMDIwLTA5LTE4VDE5OjlyOjU4LjknN1o7OTAuMTk5LjEyMS4xMTc7