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2020.0 DEFENDER (LE), 501-30

REAR END SHEET METAL REPAIRS

OUTER TAIL LAMP INNER PANEL - 110 (G2394493)

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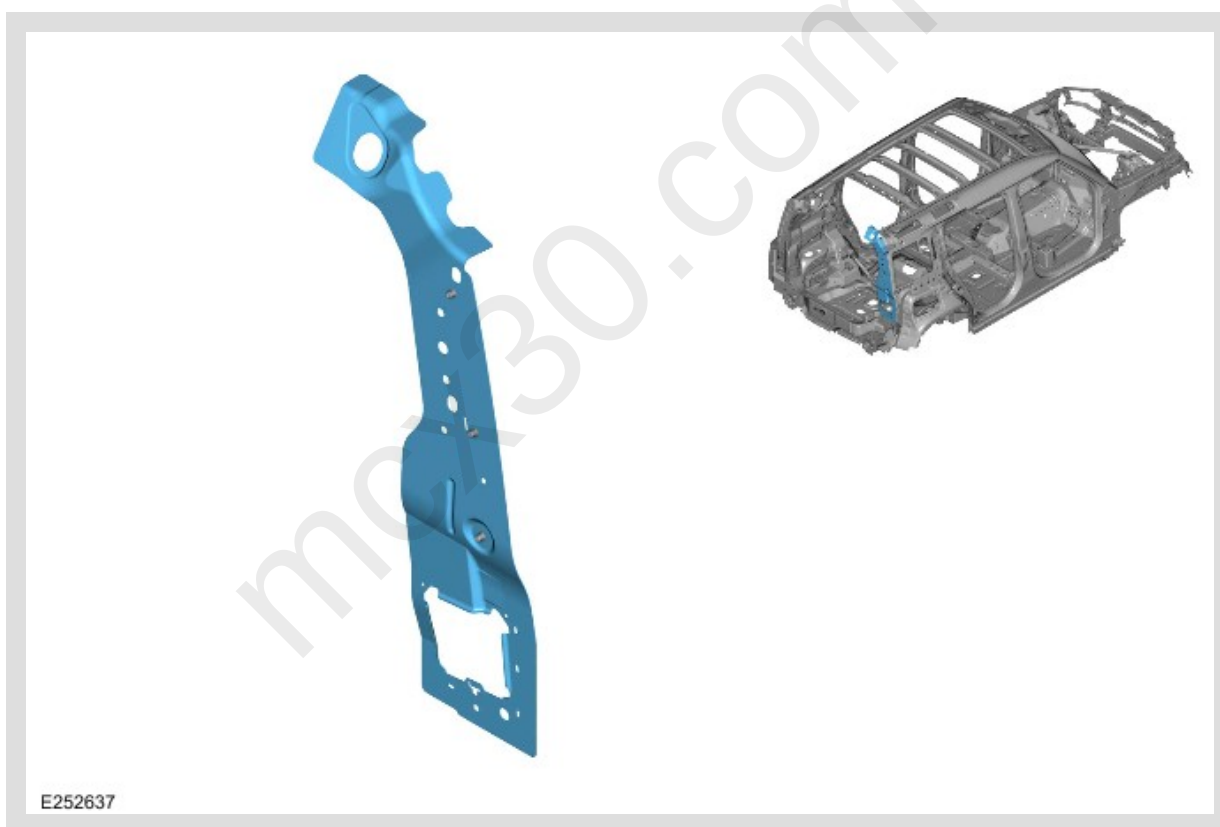
REMOVAL

 NOTE:

In this procedure, the outer tail lamp inner panel is installed in conjunction with:

- Tailgate reinforcement
- Tailgate opening panel

1.



The outer tail lamp inner panel 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).

**NOTES:**

- Where Breakstem Fastener (BSF) removal is instructed remove the 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 Jaguar Land Rover (JLR) approved SPR tool or a 5.3 mm drill bit. Clean all the drilled holes to make sure they are free from debris.
- Any joints sealed as part of vehicle manufacture must be sealed as part of the repair.

When installing the outer tail lamp inner panel 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).

For additional information on the fixings required to complete this procedure

Refer to: [Specifications - 110](#) (501-30 Rear End Sheet Metal Repairs, Specifications).

For additional removal information

Refer to: [Tailgate Reinforcement Right Side - 110](#) (501-30 Rear End Sheet Metal Repairs, Removal and Installation).

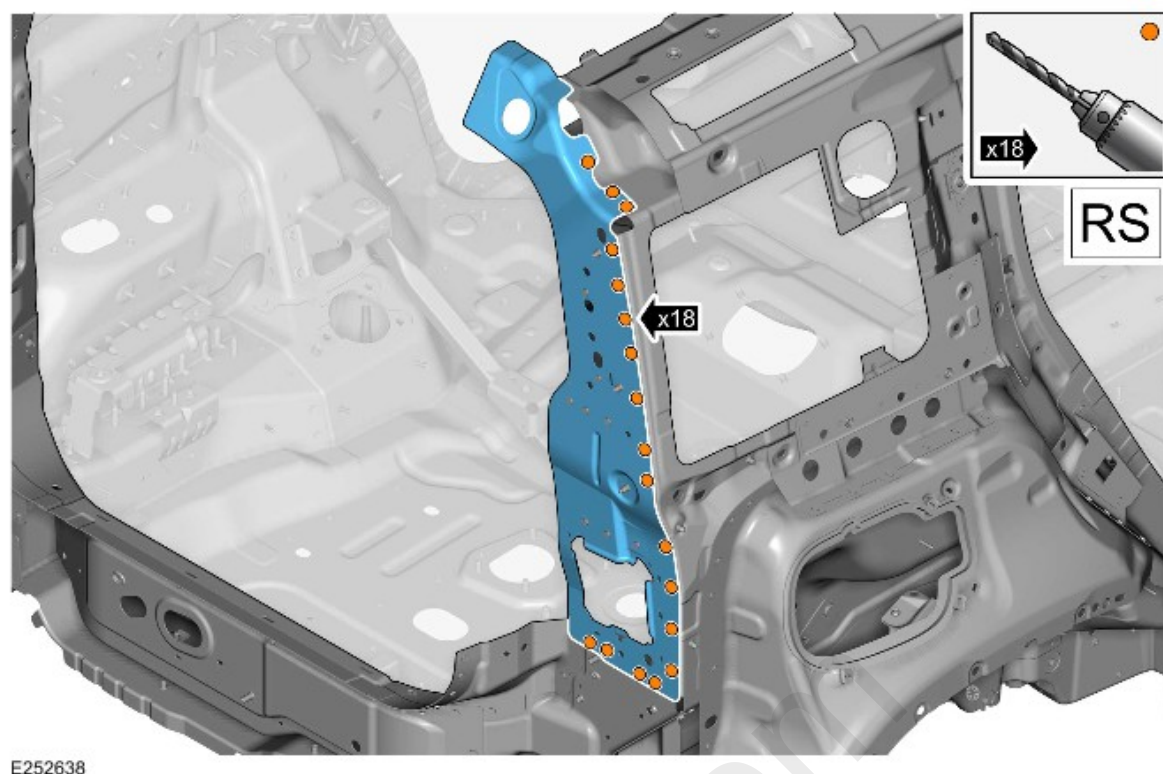
Refer to: [Tailgate Reinforcement Left Side - 110](#) (501-30 Rear End Sheet Metal Repairs, Removal and Installation).

For additional removal information

Refer to: [Tailgate Opening Panel Right Side - 110](#) (501-30 Rear End Sheet Metal Repairs, Removal and Installation).

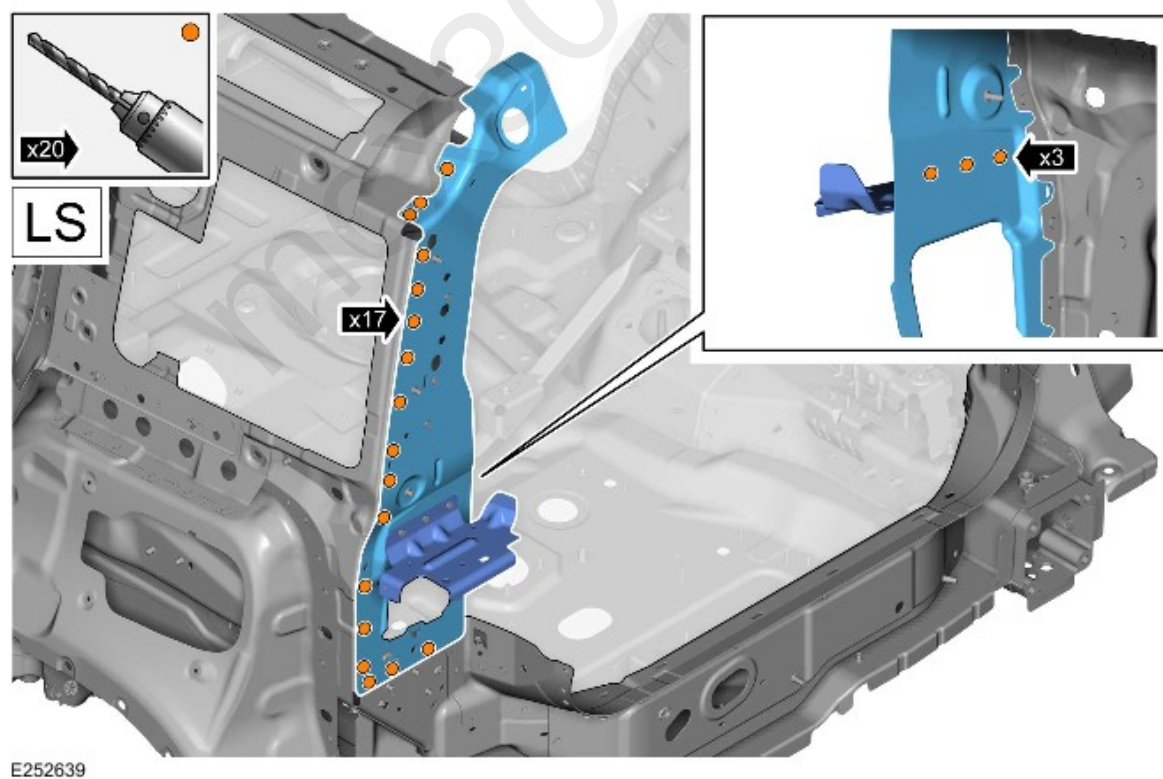
Refer to: [Tailgate Opening Panel Left Side - 110](#) (501-30 Rear End Sheet Metal Repairs, Removal and Installation).

7.



Remove the Self Piercing Rivets (SPRs) as indicated.

8.



Remove the SPRs as indicated.

9.

 NOTE:

Left Side (L/S) only. Remove the bracket. Do not discard the bracket as it is used in the installation steps.

Carefully separate the joints and remove the outer tail lamp inner panel.

INSTALLATION

 CAUTION:

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

 NOTE:

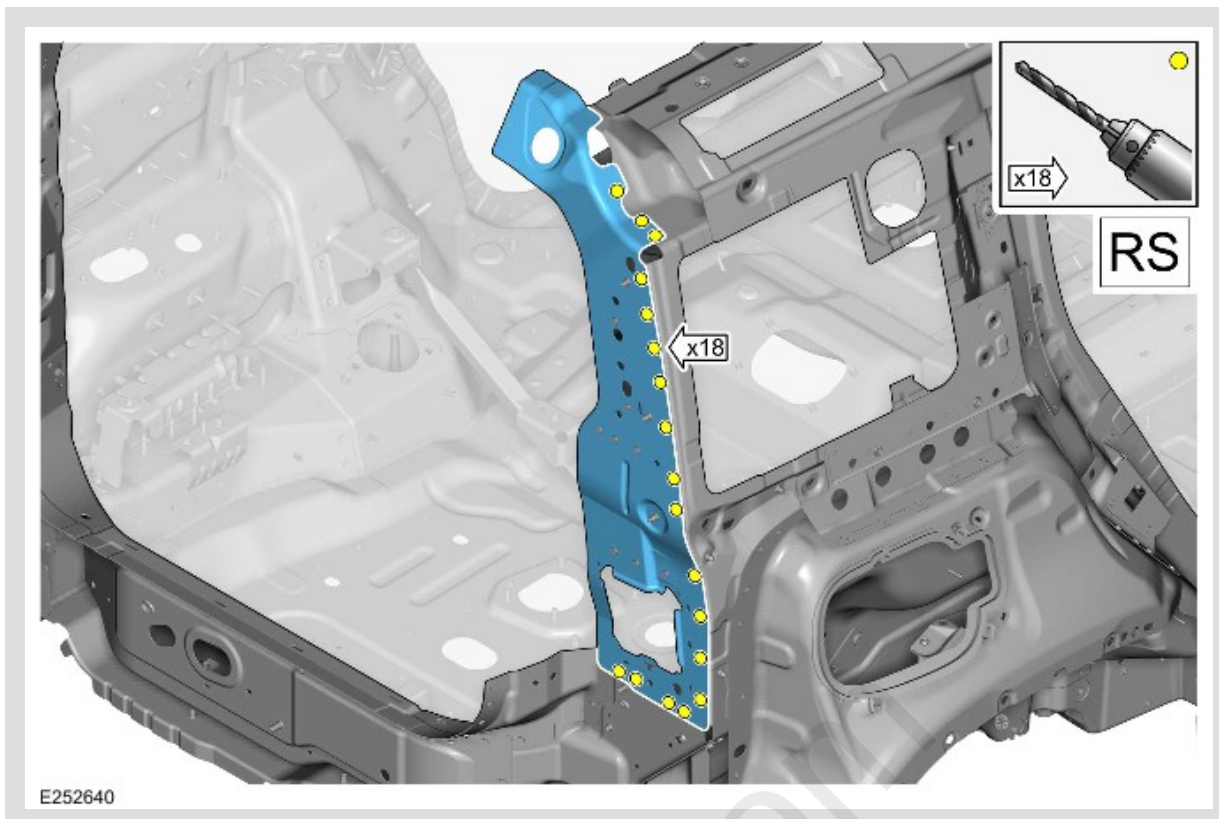
Breakstem Fastener (BSF) installation involves using the Jaguar Land Rover (JLR) approved BSF installation tool and requires a hole diameter of 6.5 mm.

1. Remove the rivet remnants.

2. Dress the flanges where necessary.

3. Offer up the new outer tail lamp inner panel 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.

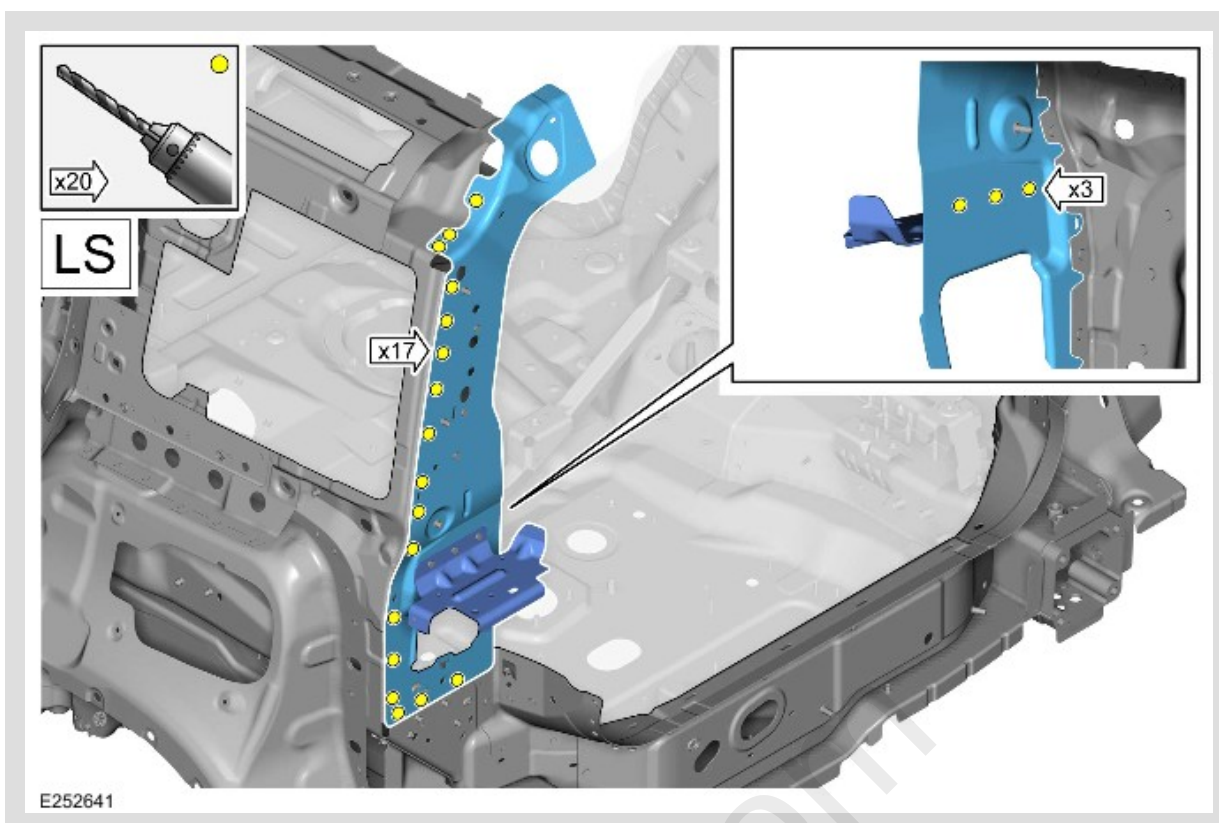
5.

NOTE:

Left Side (L/S) only.

Offer up the new outer tail lamp inner panel and bracket. Clamp into position. Check alignment, if correct proceed to next step, if not rectify and check the alignment again before proceeding.

6.



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

7. Remove the new outer tail lamp inner panel.

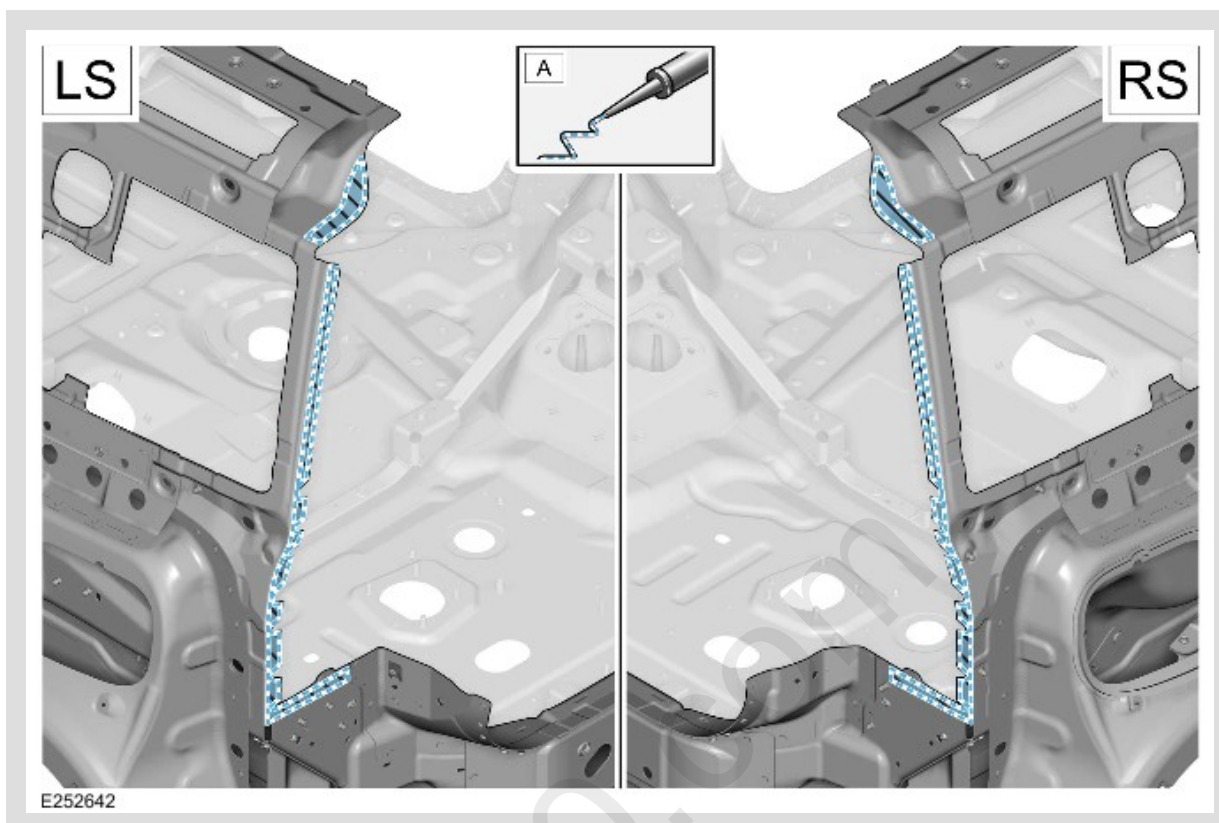
8. Deburr the drilled holes.

9. Clean and prepare the panel surfaces.

10.

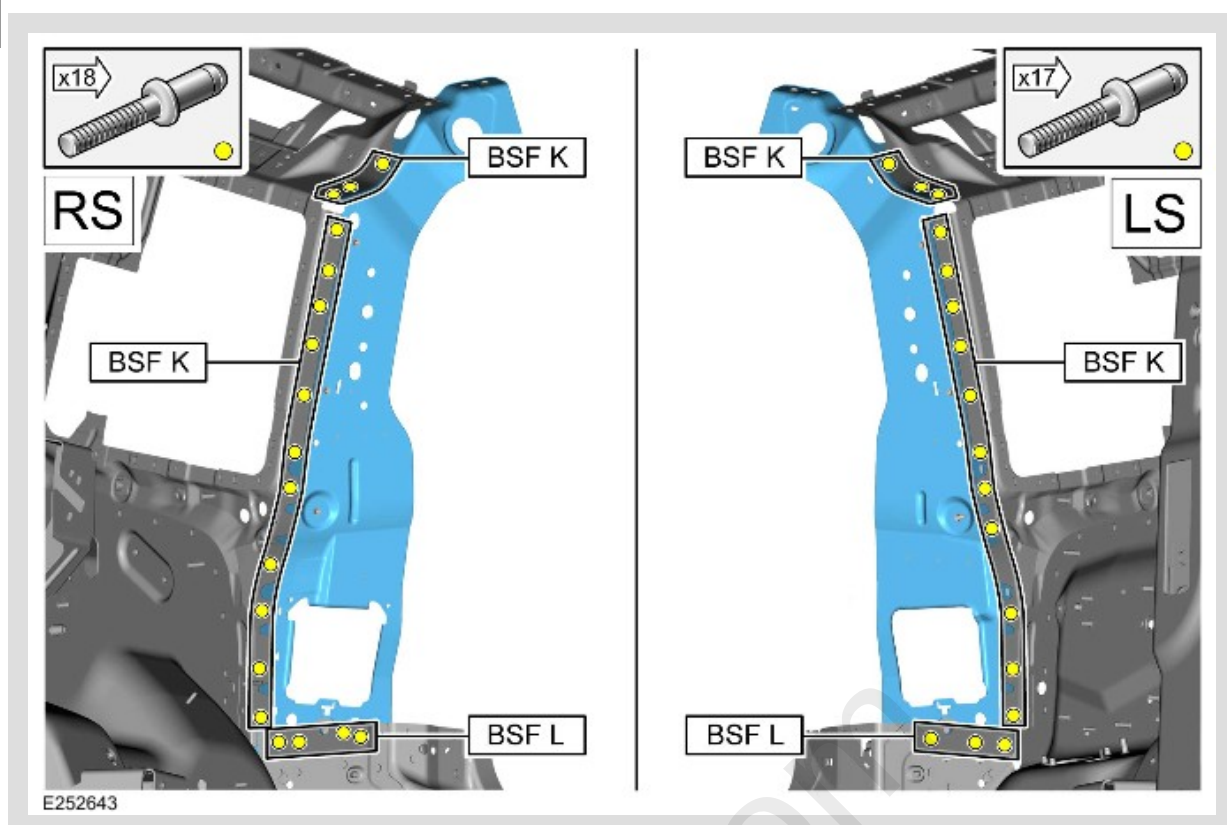
 NOTE:

Make sure a continuous bead of adhesive surrounds fixing holes.



Apply a 5 mm zig zag bead of the Jaguar Land Rover (JLR) recommended bonding material as indicated.

11. Offer up the new outer tail lamp inner panel and clamp into position. Check alignment, if correct proceed to next step, if not rectify and check the alignment again before proceeding.

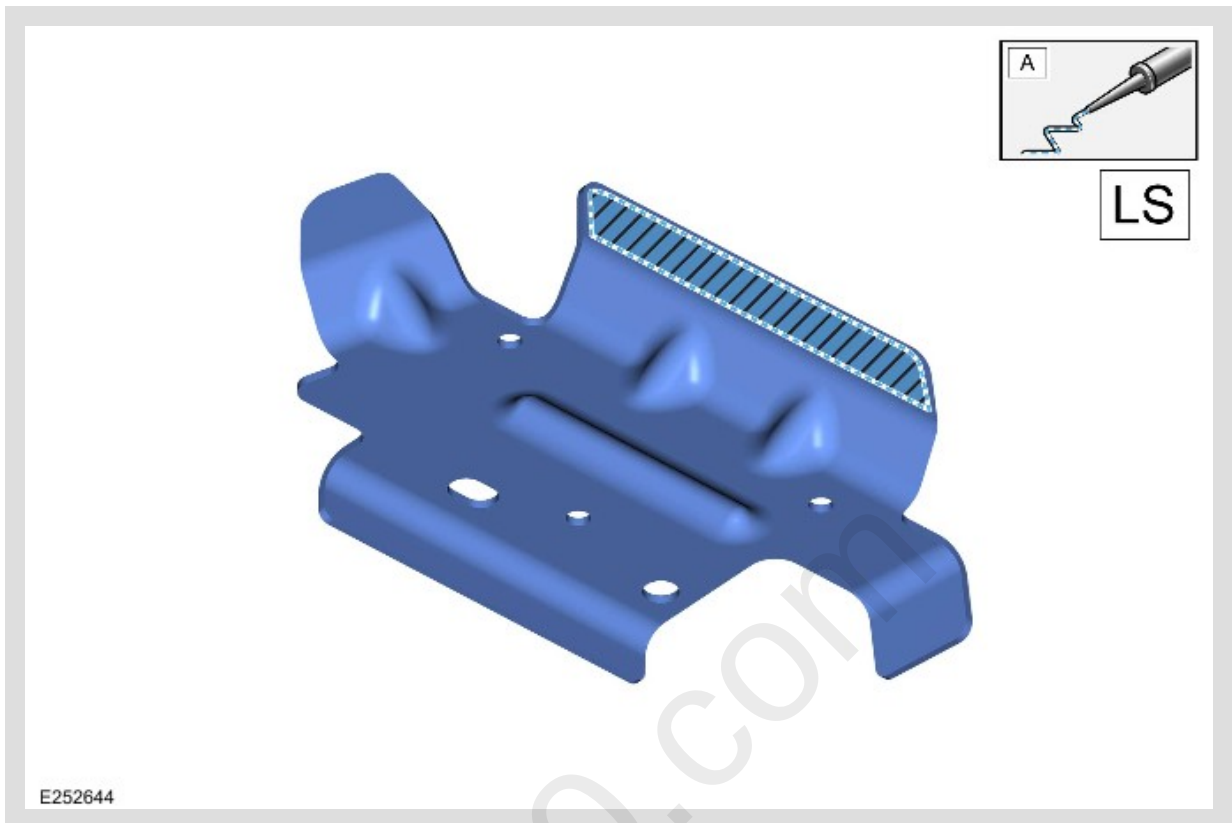


Install the BSFs as indicated.

13.

NOTE:

Make sure a continuous bead of adhesive surrounds fixing holes.



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

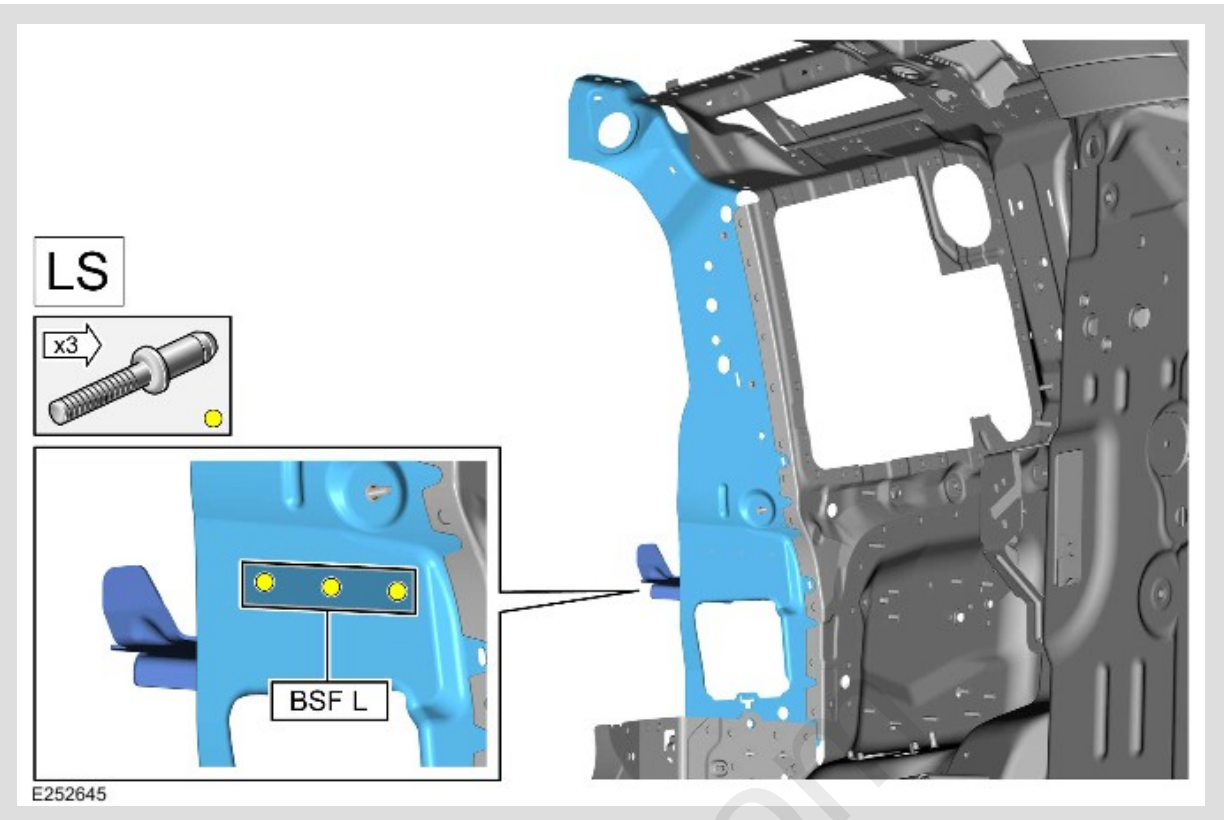
14.

NOTE:

Left Side (L/S) only.

Offer up the outer tail lamp reinforcement bracket. Check alignment, if correct proceed to next step, if not rectify and check the alignment again before proceeding.

15.



Install the BSFs as indicated.

16. Remove any excess adhesive.

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

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

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

NOTE:

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

20. For additional installation information.

Refer to: [Tailgate Opening Panel Right Side - 110](#) (501-30 Rear End Sheet Metal Repairs, Removal and Installation).

Refer to: [Tailgate Opening Panel Left Side - 110](#) (501-30 Rear End Sheet Metal Repairs, Removal and Installation).

21. For additional installation information.

Refer to: [Tailgate Reinforcement Right Side - 110](#) (501-30 Rear End Sheet Metal Repairs, Removal and Installation).

Refer to: [Tailgate Reinforcement Left Side - 110](#) (501-30 Rear End Sheet Metal Repairs, Removal and Installation).

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