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2020.0 DEFENDER (LE), 501-30

REAR END SHEET METAL REPAIRS

TAILGATE REINFORCEMENT RIGHT SIDE - 110 (G2394518)

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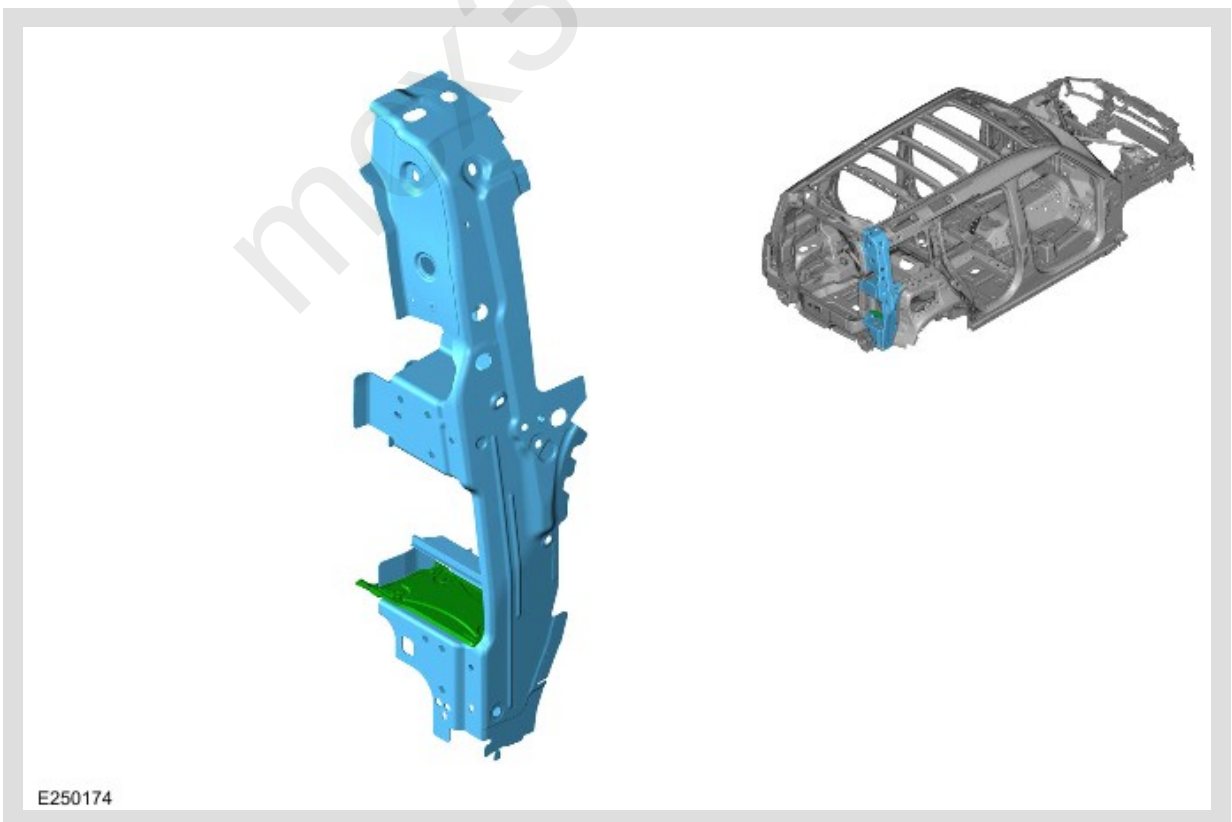
REMOVAL

 NOTE:

In this procedure, the tailgate reinforcement right side is installed in conjunction with:

- Rear header panel upper
- Side panel
- Quarter panel assembly
- Outer tail lamp outer panel right side
- Back panel outer
- Rear wheelhouse lower rear extension.

1.



The tailgate reinforcement right side is serviced as indicated.

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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).
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3. **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 tailgate reinforcement right side 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).

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4. For additional information on the fixings required to complete this procedure
Refer to: [Specifications - 110](#) (501-30 Rear End Sheet Metal Repairs, Specifications).

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5. For additional removal information
Refer to: [Rear Header Panel Upper - 110](#) (501-28 Roof Sheet Metal Repairs, Removal and Installation).

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6. For additional removal information
Refer to: [Side Panel - 110](#) (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).

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7. For additional removal information
Refer to: [Quarter Panel Assembly - 110](#) (501-30 Rear End Sheet Metal Repairs, Removal and Installation).

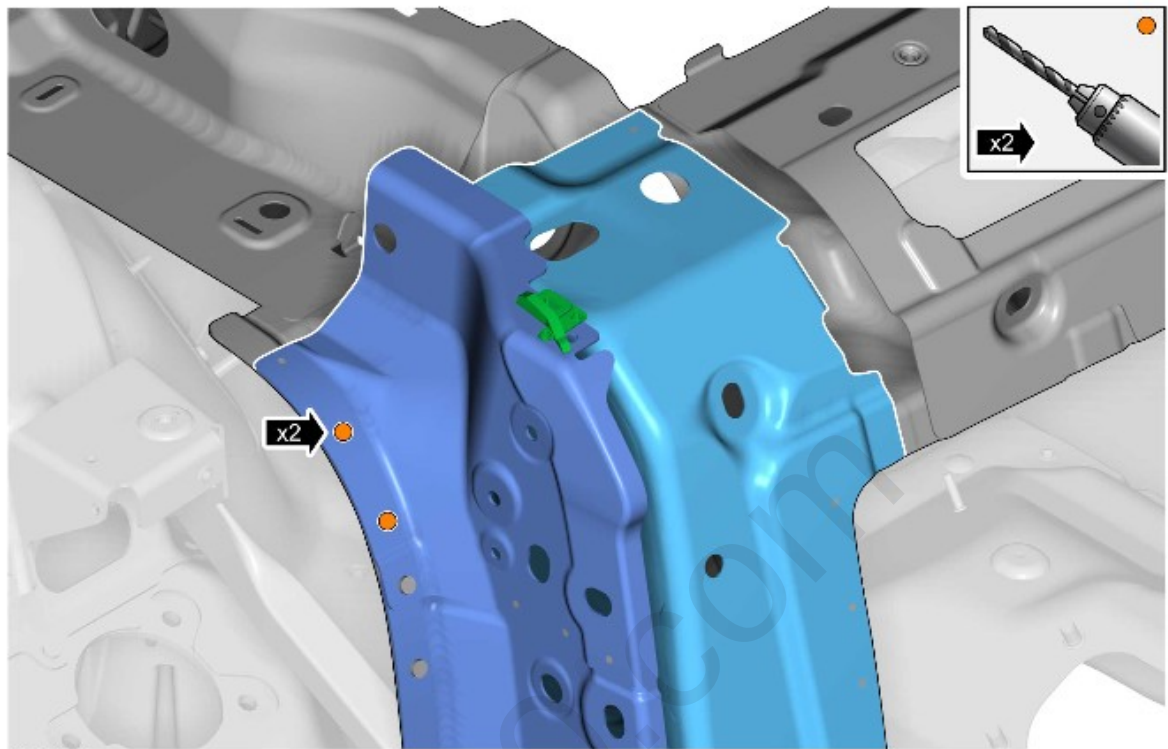
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8. For additional removal information
Refer to: [Outer Tail Lamp Outer Panel Right Side - 110](#) (501-30 Rear End Sheet Metal Repairs, Removal and Installation).

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9. For additional removal information
Refer to: [Back Panel Outer - 110](#) (501-30 Rear End Sheet Metal Repairs, Removal and Installation).

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10. For additional removal information
Refer to: [Rear Wheelhouse Lower Rear Extension - 110](#) (501-30 Rear End Sheet Metal Repairs, Removal and Installation).
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NOTE:

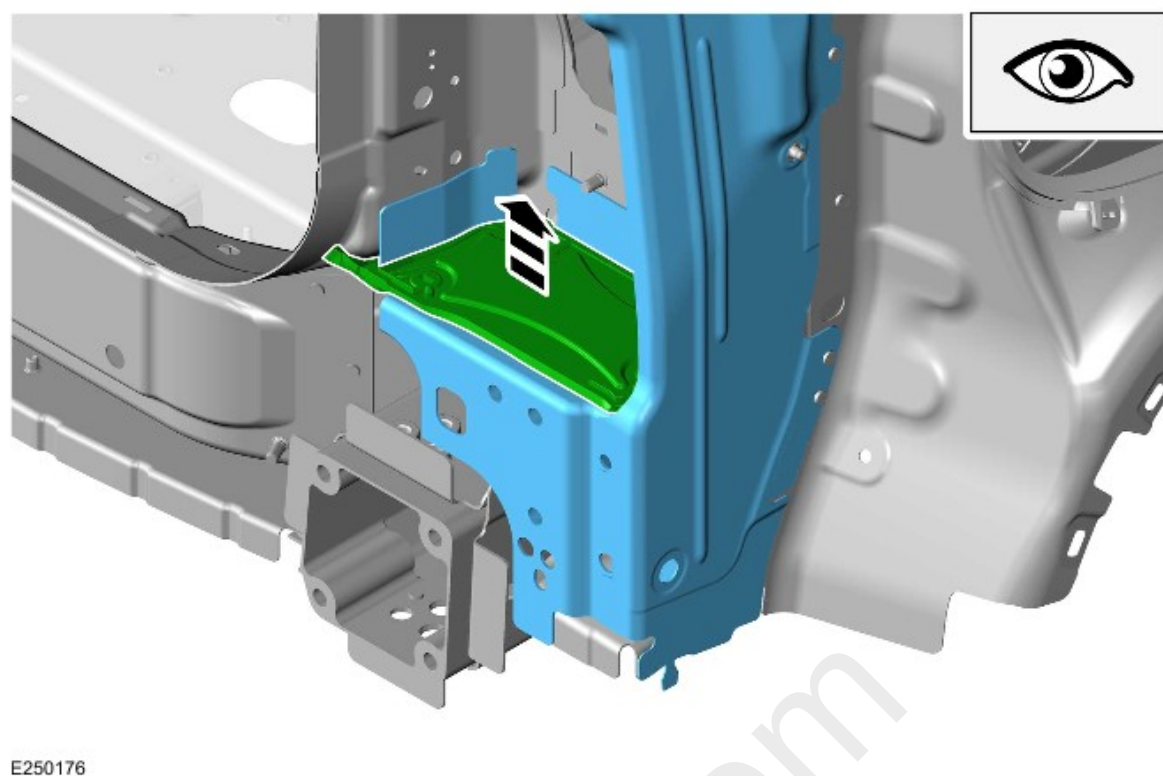
When installing the tailgate reinforcement right side in conjunction with the outer tail lamp outer panel right side.



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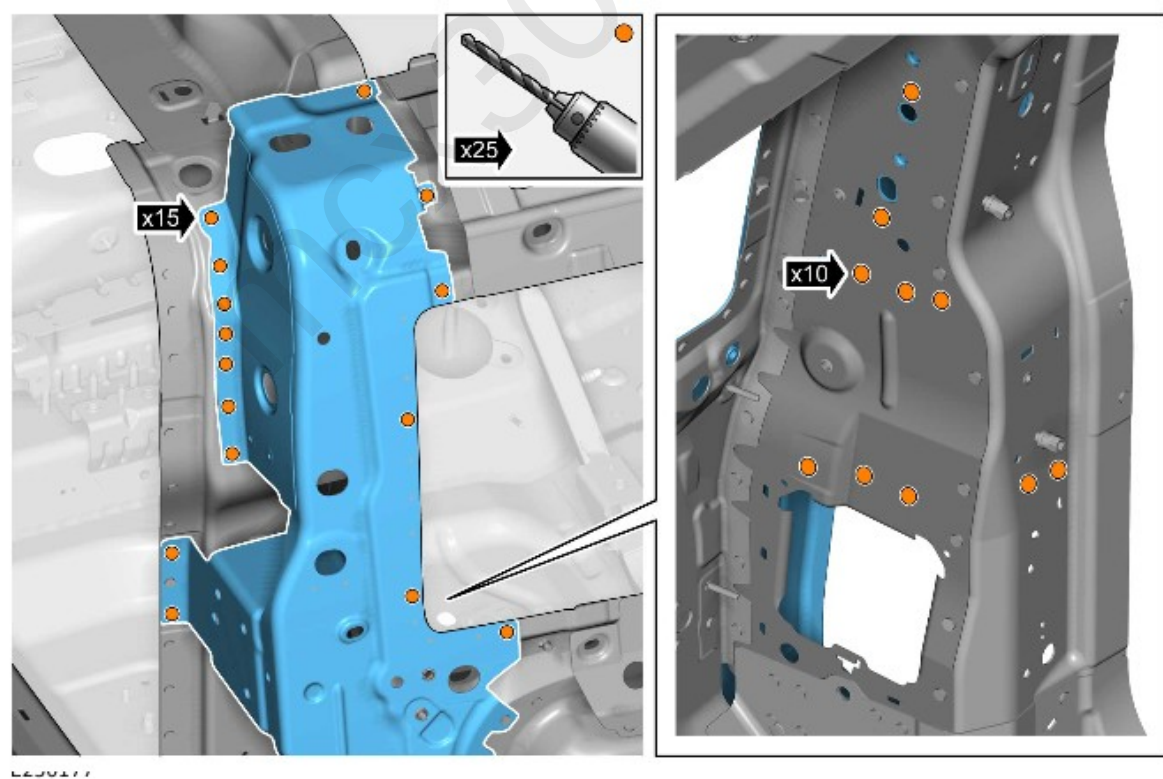
Remove the Self Piercing Rivets (SPRs) as indicated.

12.



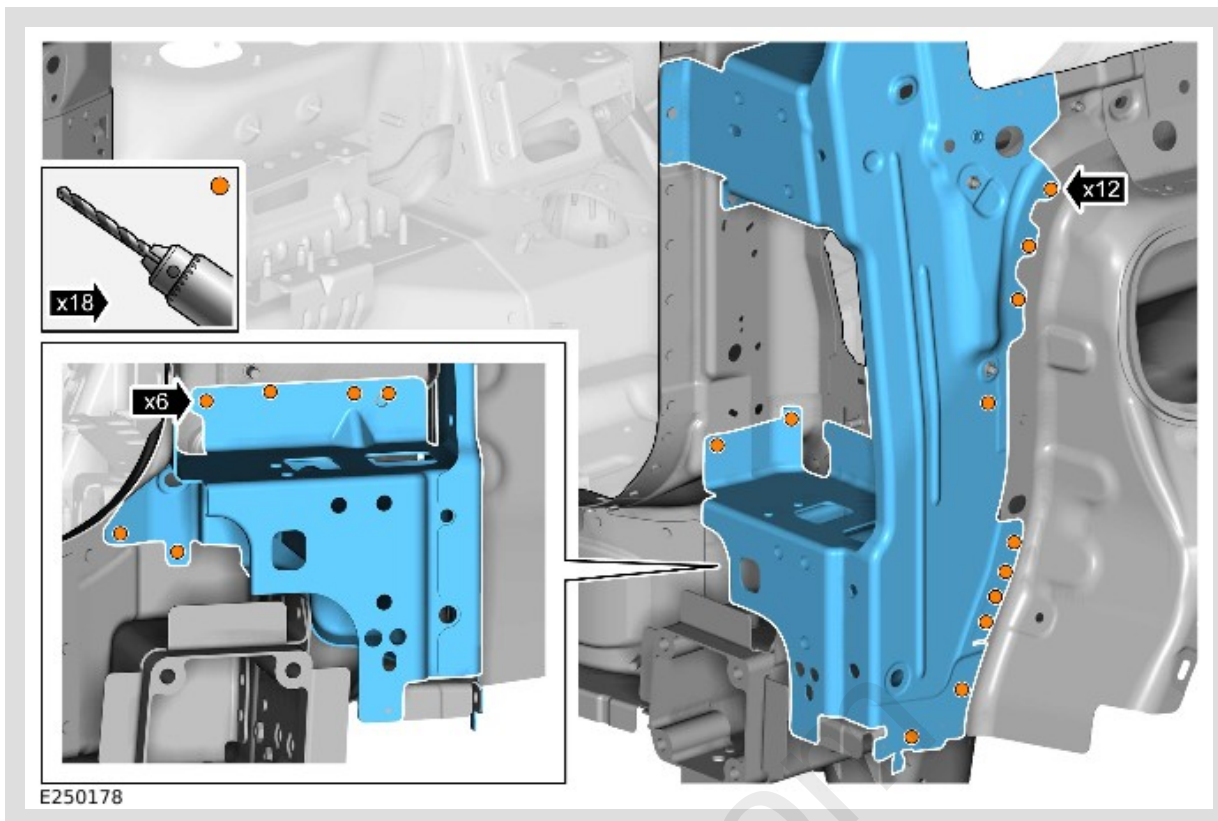
Remove the Noise, Vibration and Harshness (NVH) material as indicated.

13.



Remove the SPRs as indicated.

14.



Remove the SPRs as indicated.

15. Carefully separate the joints and remove the tailgate reinforcement right side.

INSTALLATION

⚠ CAUTION:

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

△ NOTES:

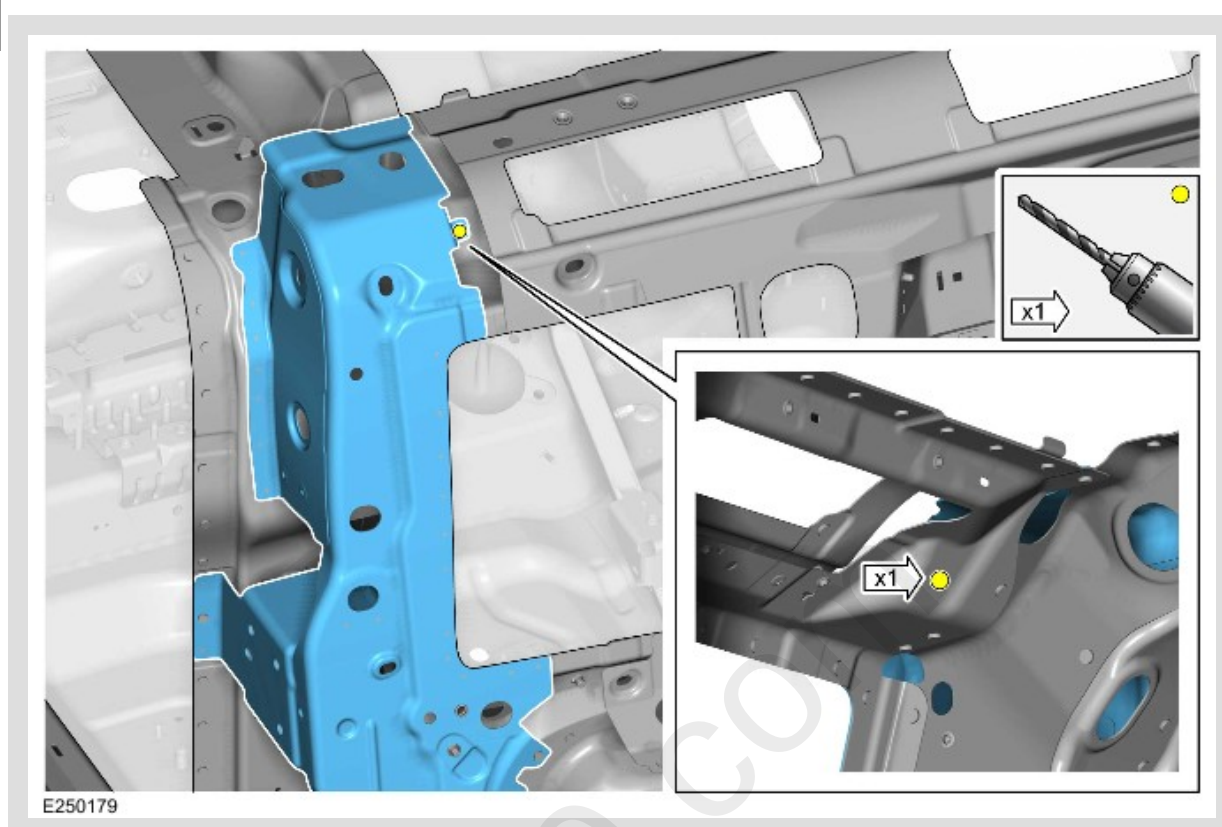
- Breakstem Fastener (BSF) installation involves using the JLR approved BSF installation tool and requires a hole diameter of 6.5 mm.
- Self Piercing Rivet (SPR) installation requires using the JLR approved SPR tool.

1. Remove the rivet remnants.

2. Dress the flanges where necessary.

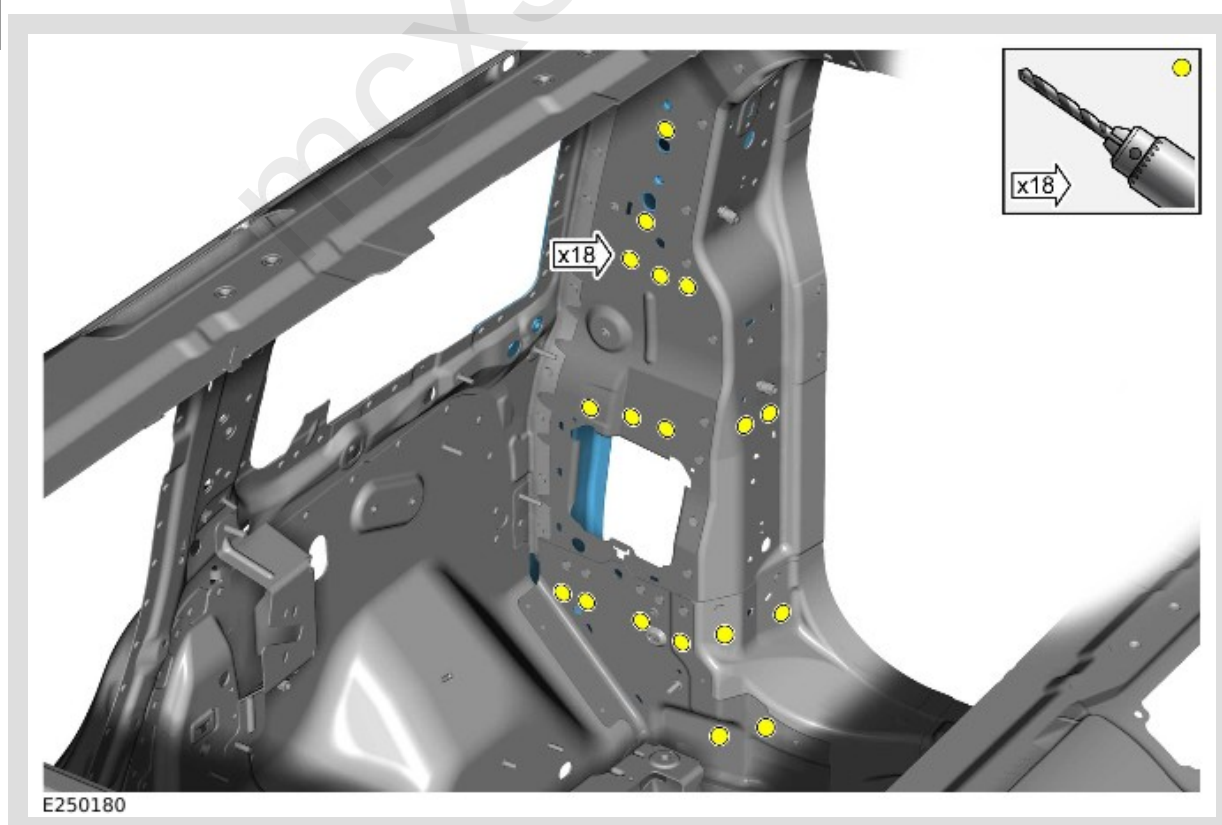
3. Offer up the new tailgate reinforcement right side. Clamp into position. Check alignment, if correct proceed to next step, if not rectify and check the alignment again before proceeding.

4.

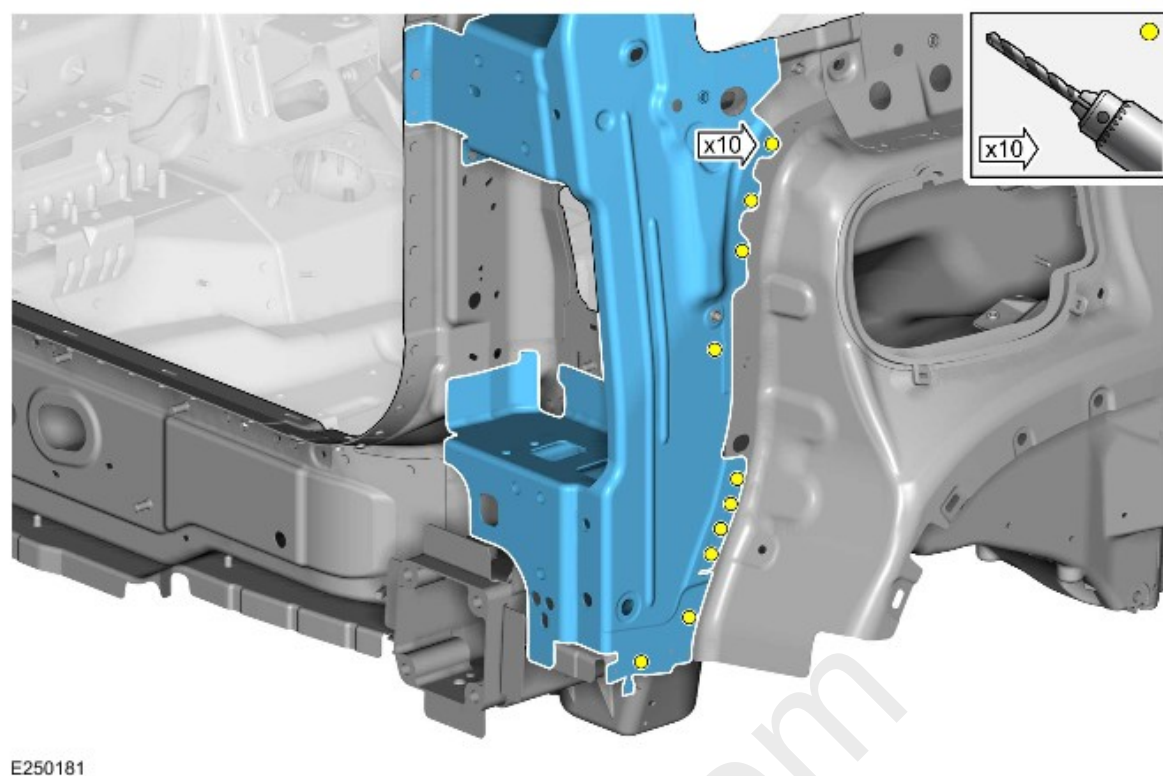


Drill a hole where the Breakstem Fastener (BSF) is to be installed as indicated.

5.



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

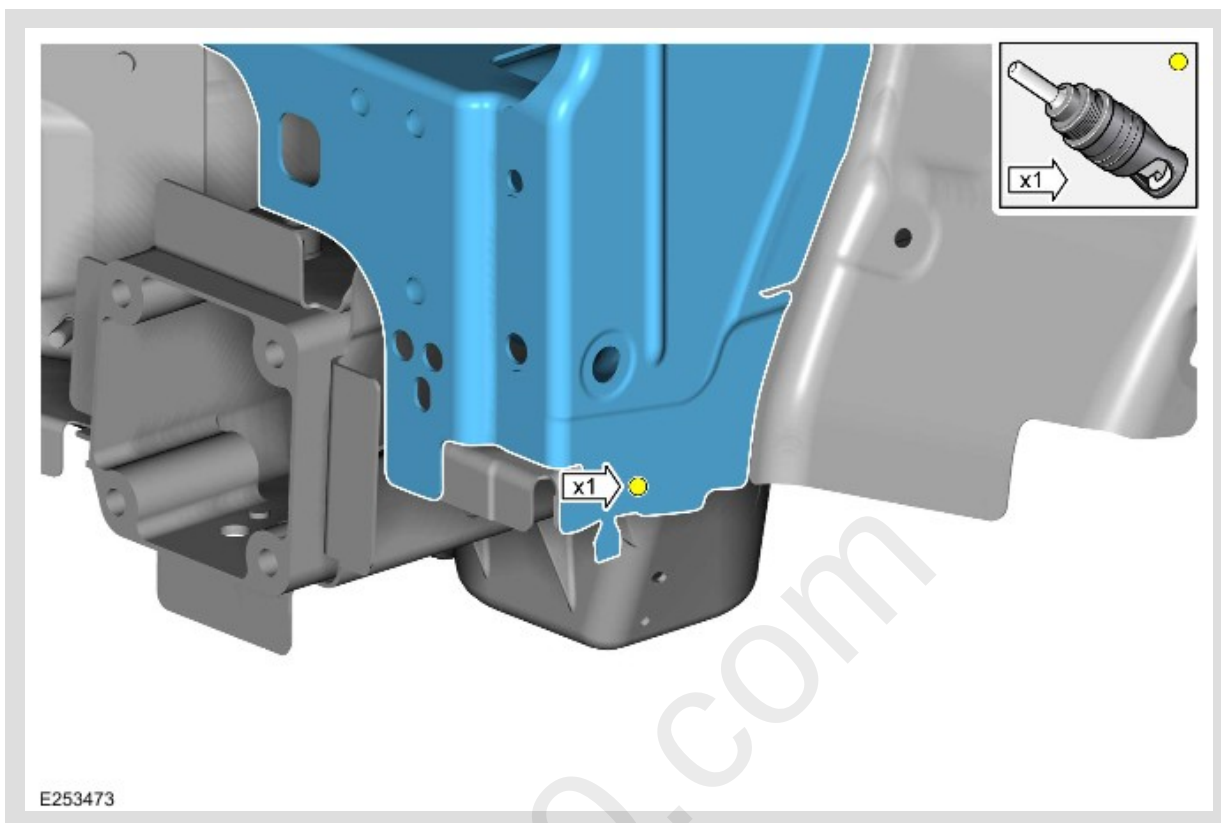


Drill holes where the BSFs are to be installed as indicated.

7.

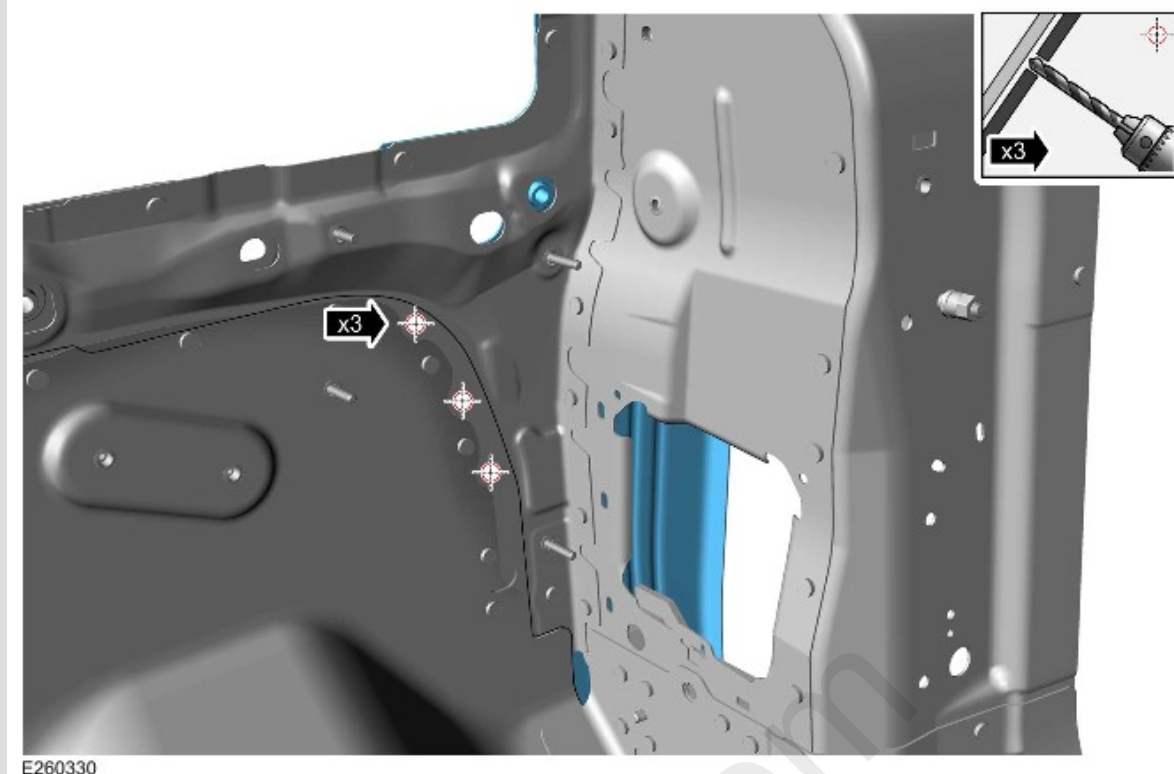
 NOTE:

Make sure that the JLR recommended countersink tool is used for this step.



Countersink the hole to a depth of 2 mm as indicated.

8.



Drill 12 mm clearance holes for BSF access as indicated.

9. Remove the new tailgate reinforcement right side.

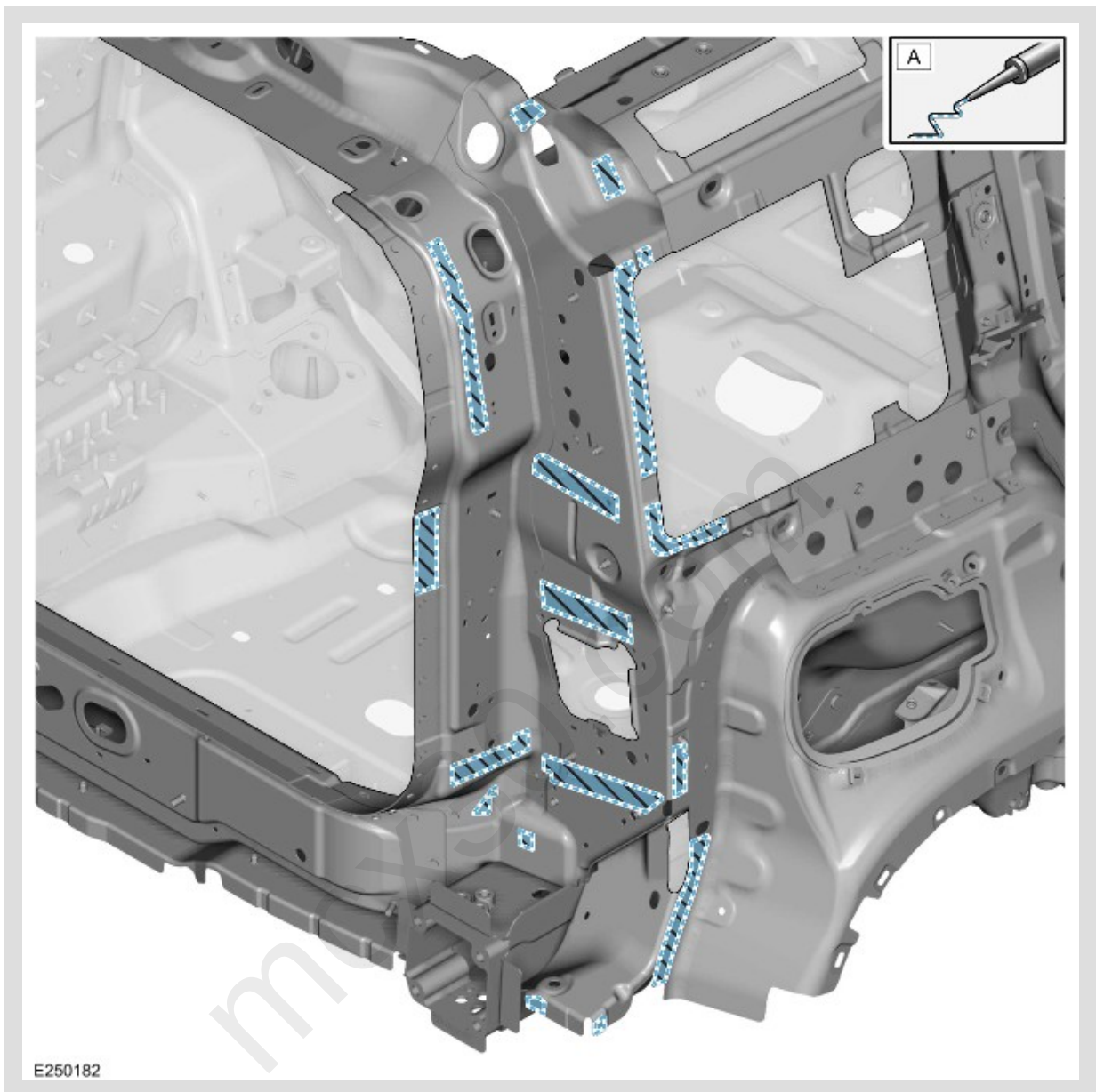
10. Deburr the drilled holes.

11. Clean and prepare the panel surfaces.

12.

 NOTE:

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

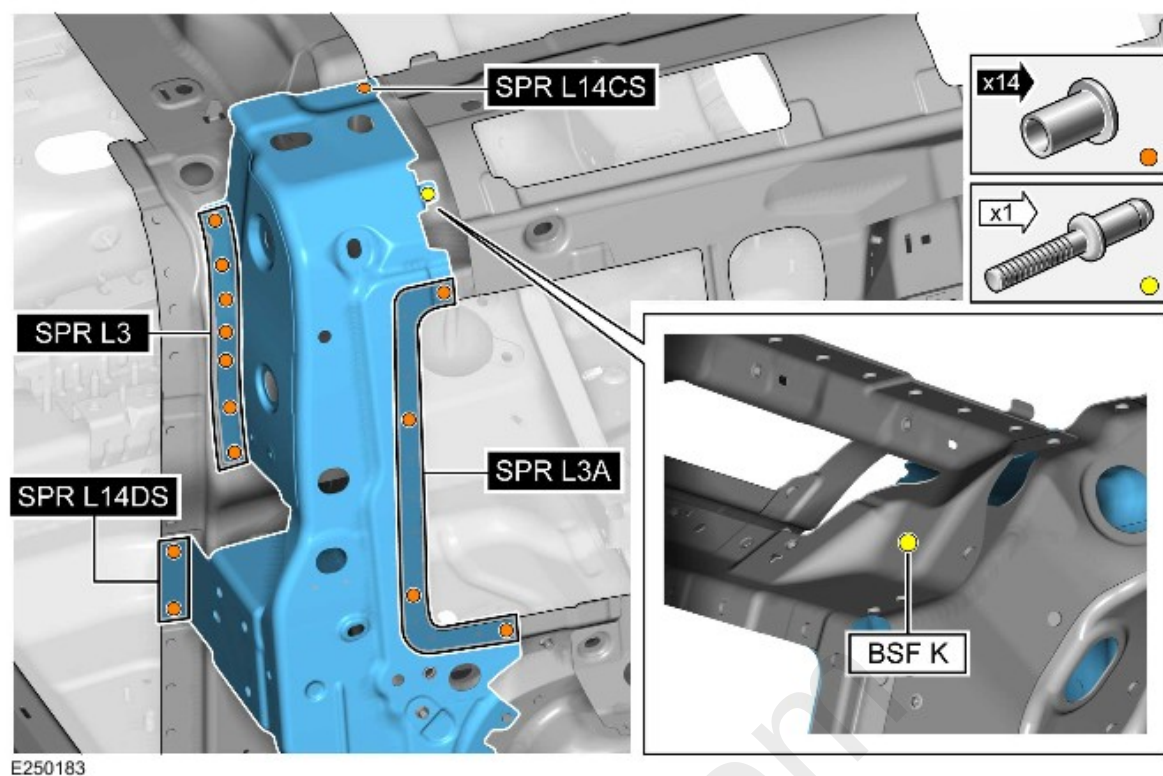


Apply a 5 mm zig zag bead of the JLR recommended bonding material as indicated.

13.

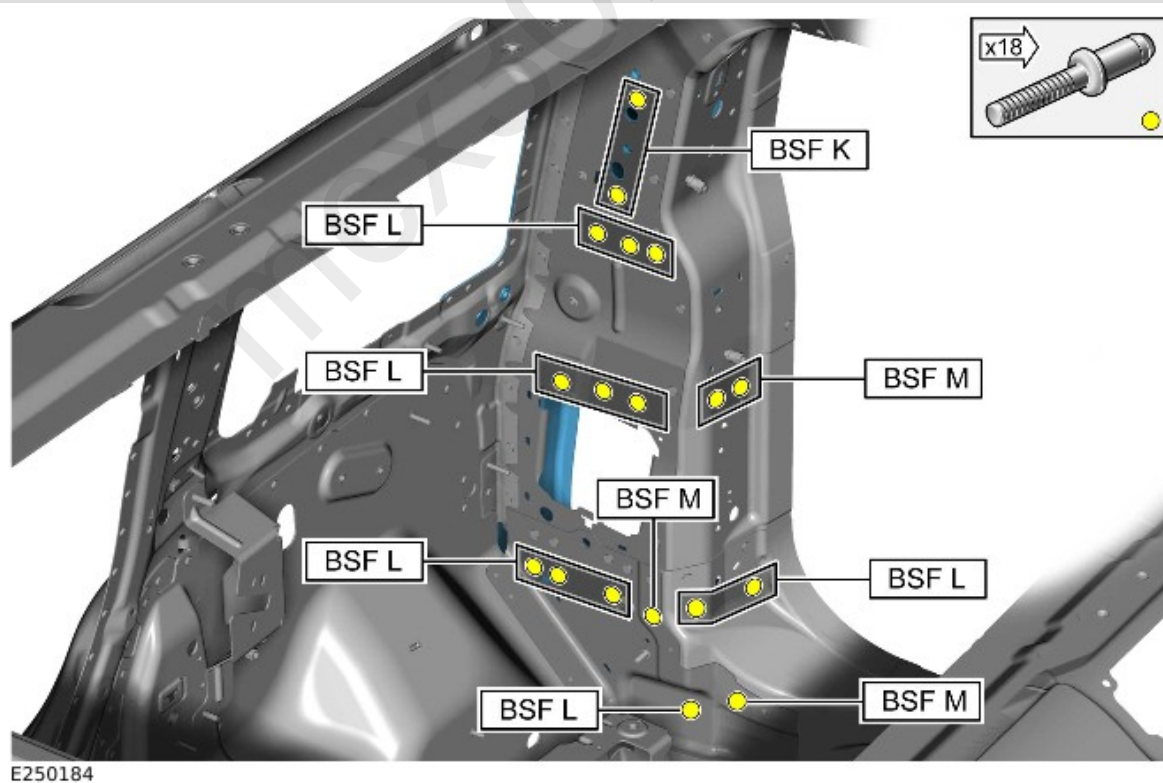
Offer up the new tailgate reinforcement right side. Clamp into position. Check alignment, if correct proceed to next step, if not rectify and check the alignment again before proceeding.

14.



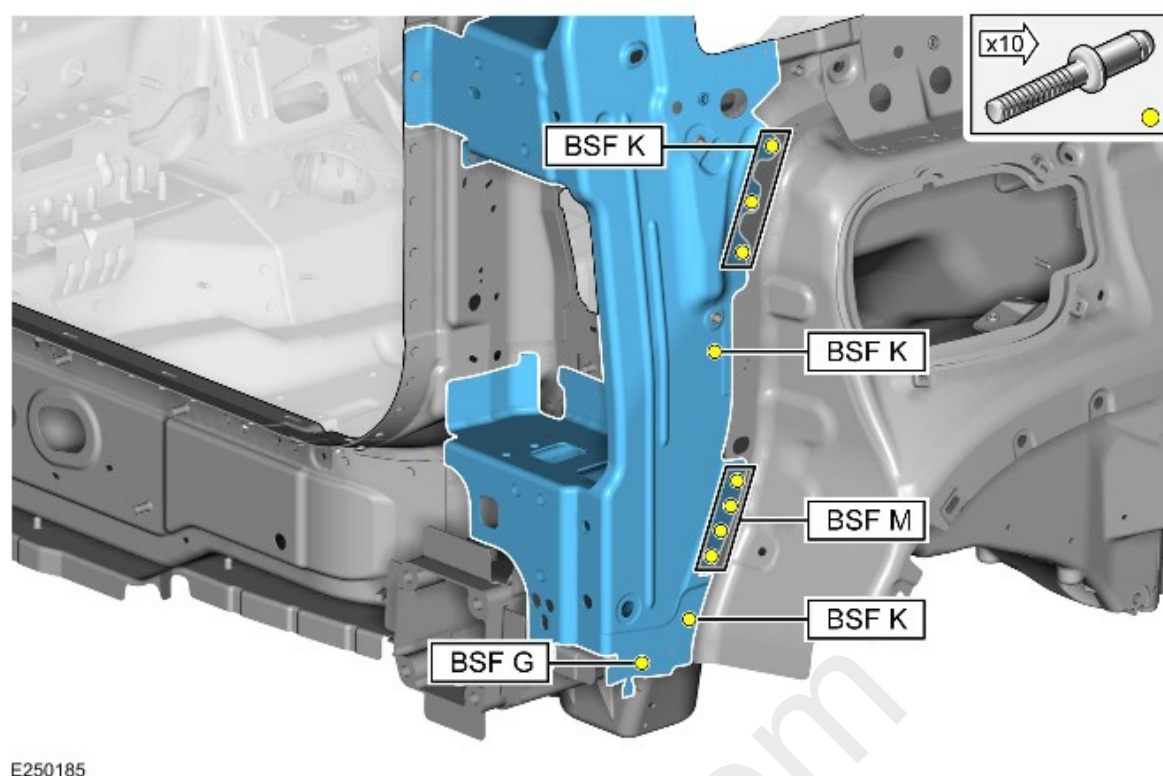
Install the BSF and Self Piercing Rivets (SPRs) as indicated.

15.



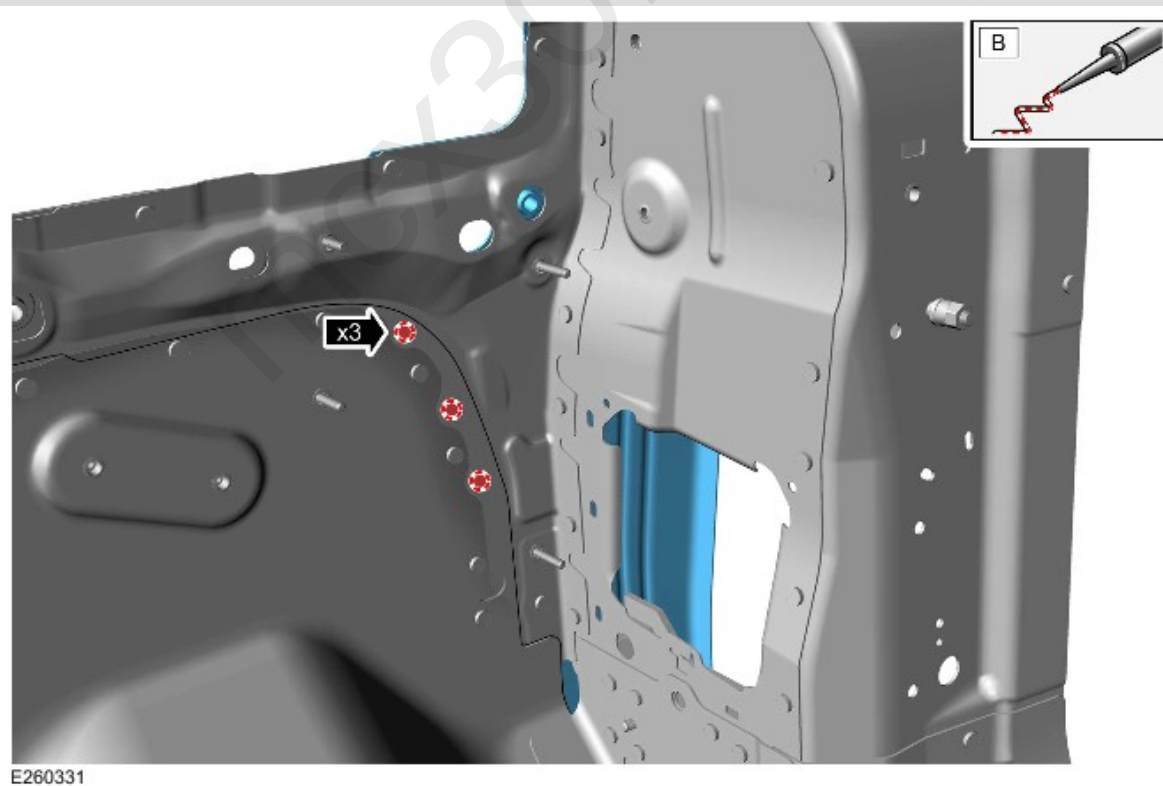
Install the BSFs as indicated.

16.



Install the BSFs as indicated.

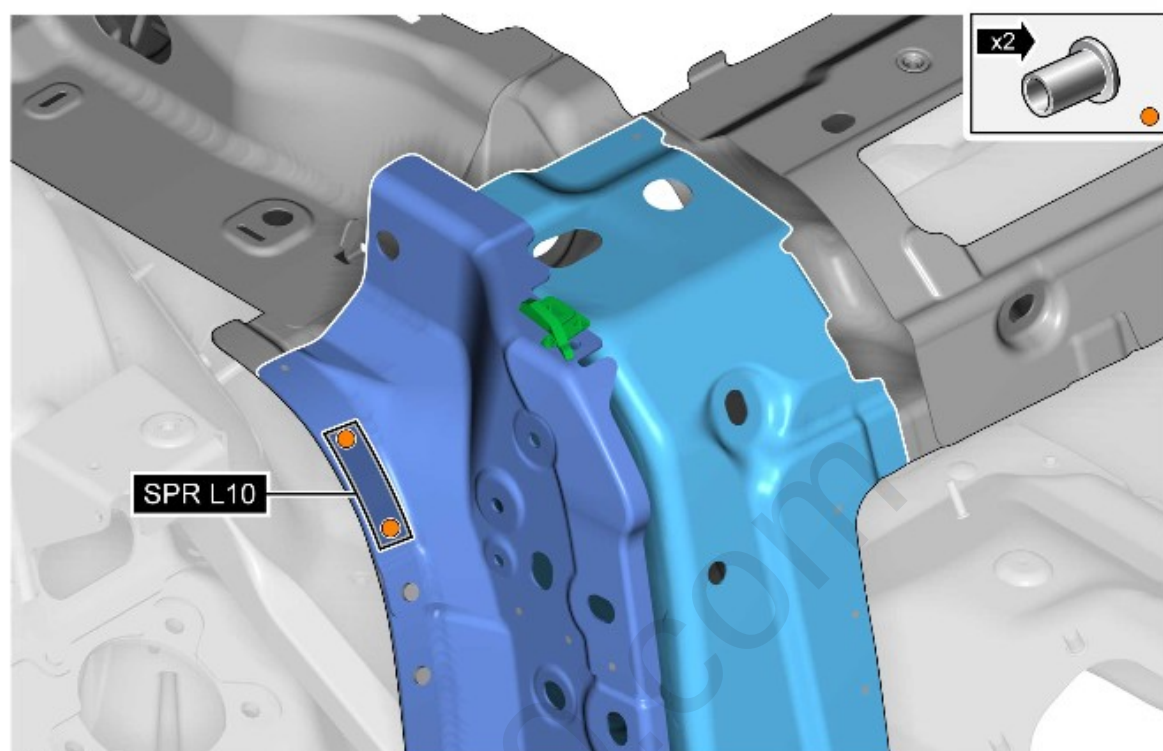
17.



Apply a JLR recommended sealant to the BSF clearance holes as indicated.

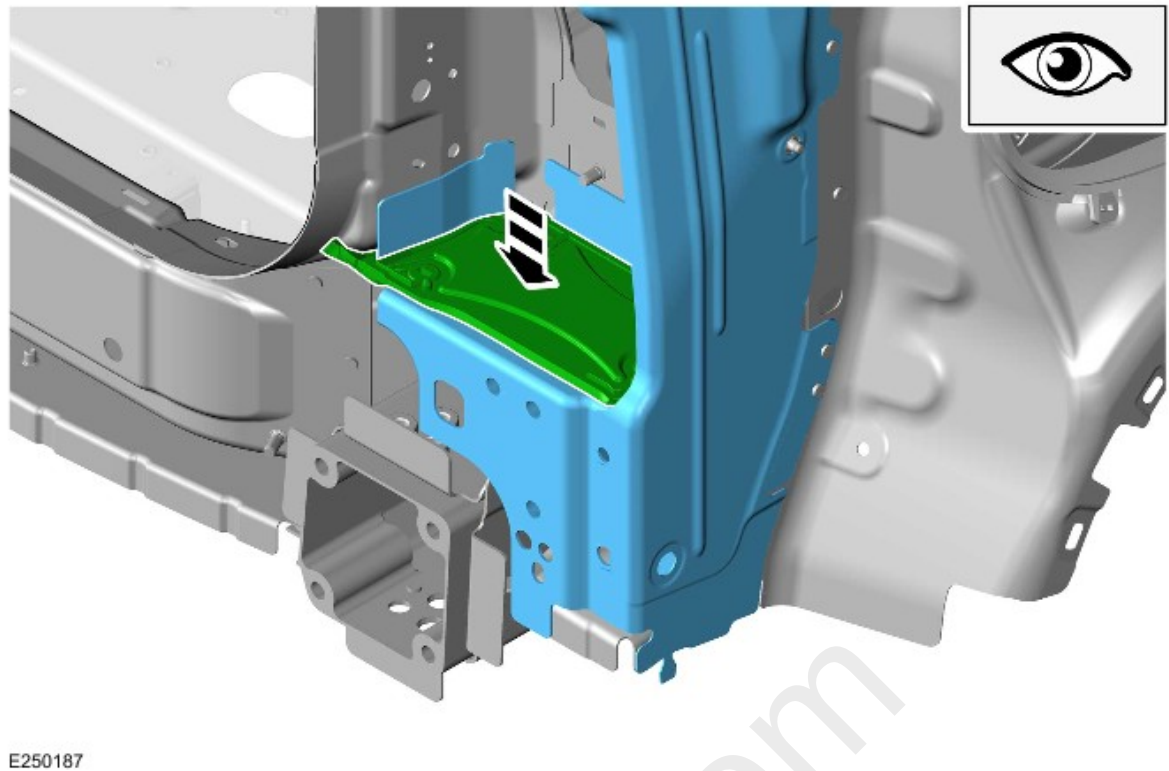
NOTE:

When installing the tailgate reinforcement right side in conjunction with the outer tail lamp outer panel right side.



Install the SPRs as indicated.

19.



Install the NVH material as indicated.

20. Remove any excess adhesive.

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

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

23. Make sure that all BSFs and SPRs are sealed using a JLR recommended sealer.

 NOTE:

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

24. For additional installation information

Refer to: [Rear Wheelhouse Lower Rear Extension - 110](#) (501-30 Rear End Sheet Metal Repairs, Removal and Installation).

25. For additional installation information

Refer to: [Back Panel Outer - 110](#) (501-30 Rear End Sheet Metal Repairs, Removal and Installation).

26. For additional installation information

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

27. For additional installation information

Refer to: [Quarter Panel Assembly - 110](#) (501-30 Rear End Sheet Metal Repairs, Removal and Installation).

28. For additional installation information

Refer to: [Side Panel - 110](#) (501-29 Side Panel Sheet Metal Repairs, Removal and Installation).

29. For additional installation information

Refer to: [Rear Header Panel Upper - 110](#) (501-28 Roof Sheet Metal Repairs, Removal and Installation).