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2020.0 DEFENDER (LE), 501-30

REAR END SHEET METAL REPAIRS

OUTER TAIL LAMP OUTER PANEL RIGHT SIDE - 90

[G2452706]

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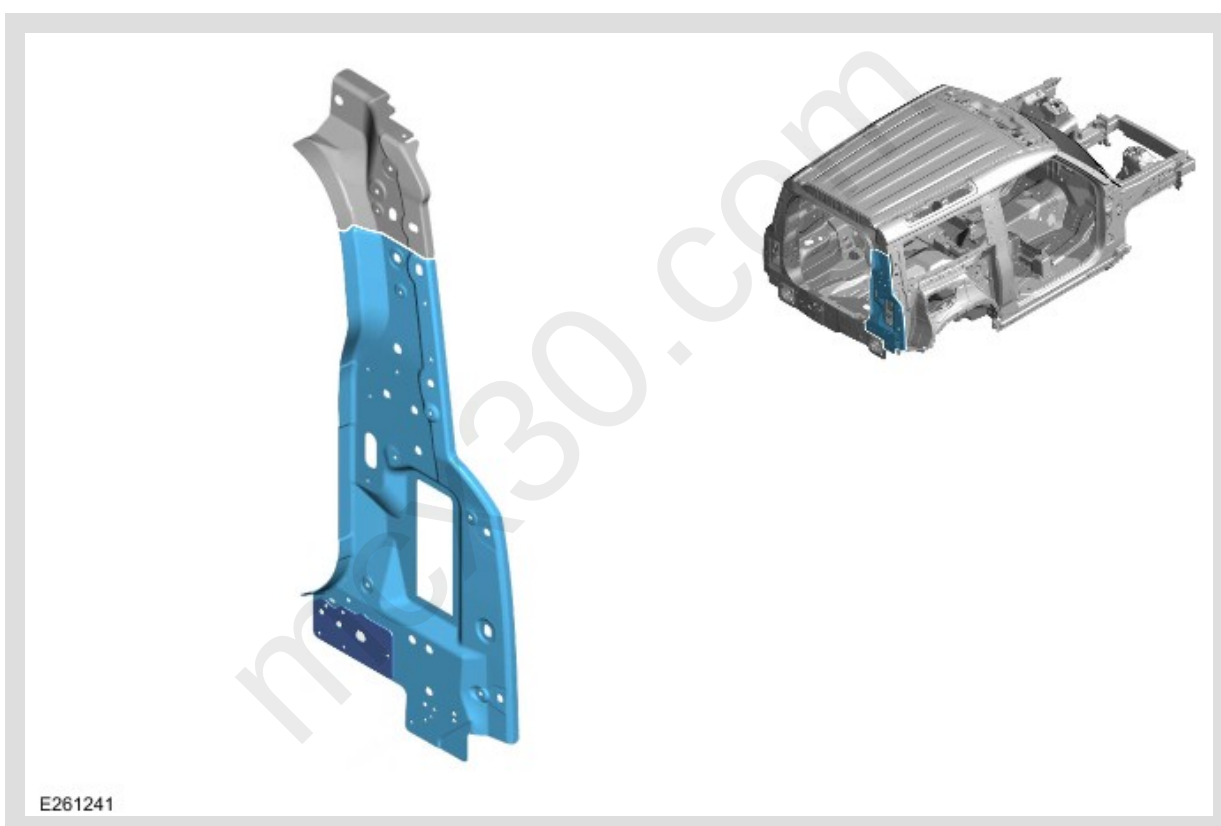
REMOVAL

 NOTE:

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

- Quarter panel.

1.



The outer tail lamp outer 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.
- Where Flow Form Rivet (FFR) removal is instructed, remove the head and then remove the shaft with a punch. Clean the 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 outer 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).

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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).

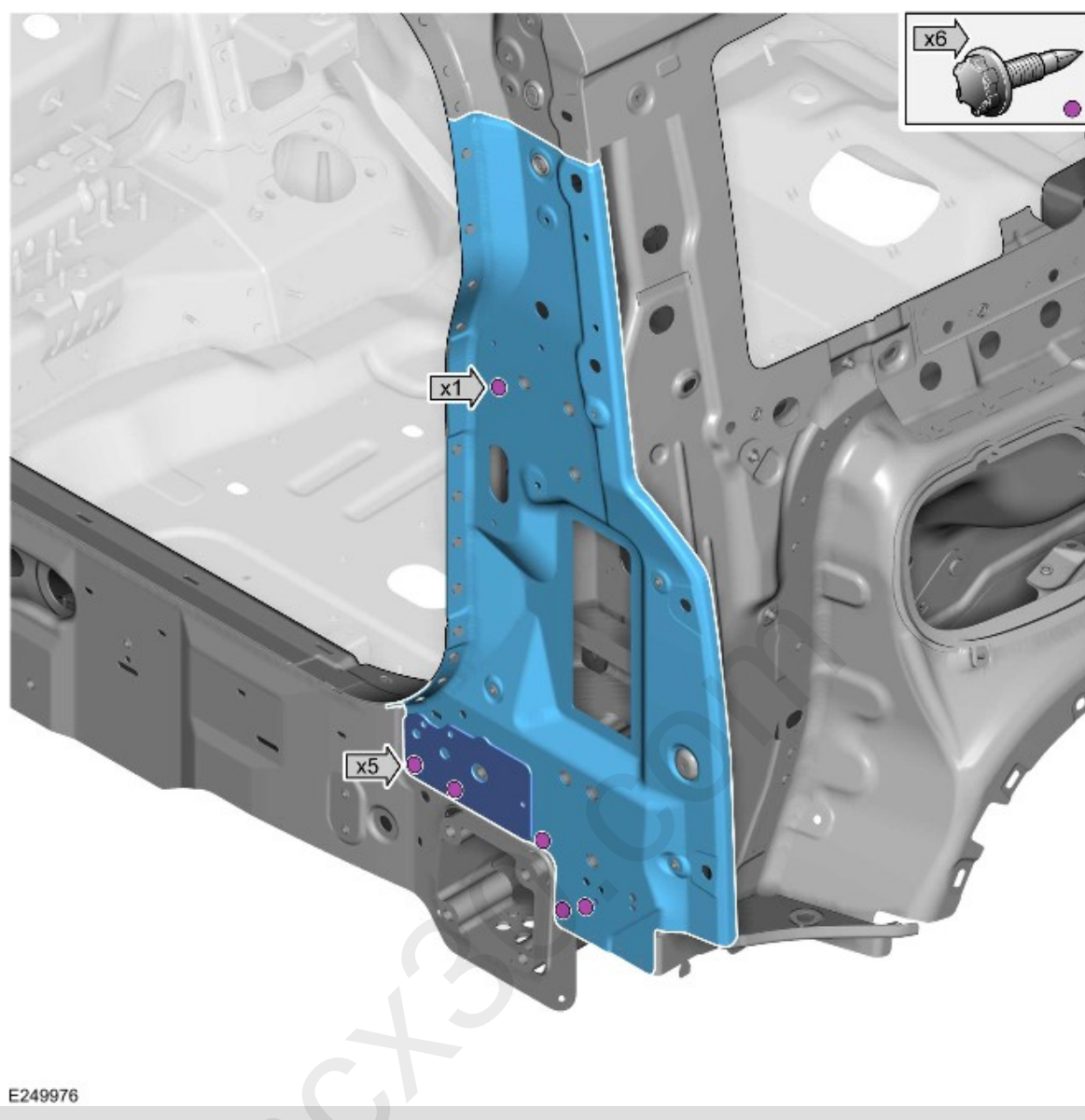
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5. For additional removal information

Refer to: [Quarter Panel - 90](#) (501-30 Rear End Sheet Metal Repairs, Removal and Installation).

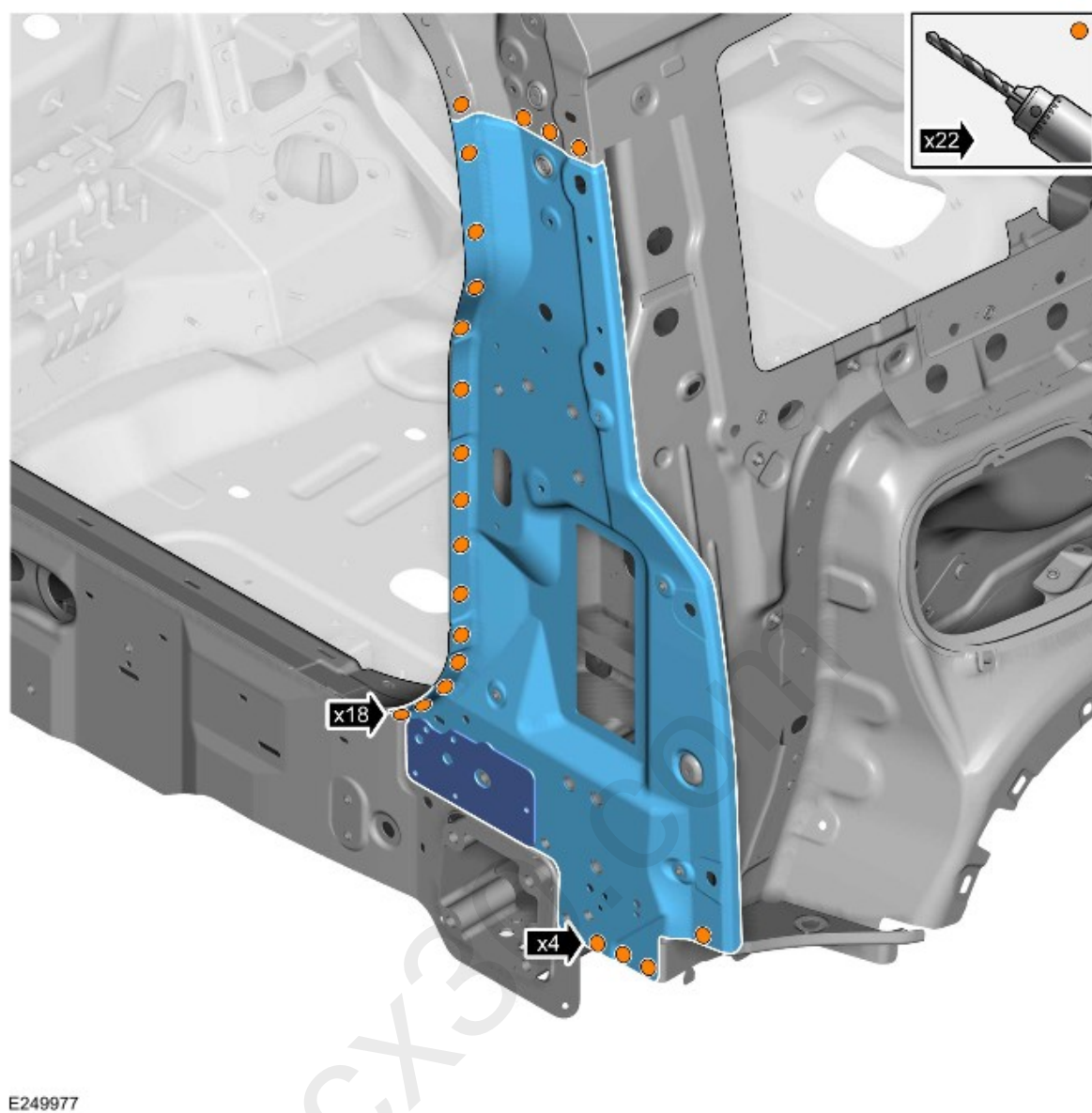
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6. Release and position the Noise, Vibration and Harshness (NVH) material to one side.

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7. Release and position the wiring harness to one side.

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8. Remove the tailgate upper and lower hinges.
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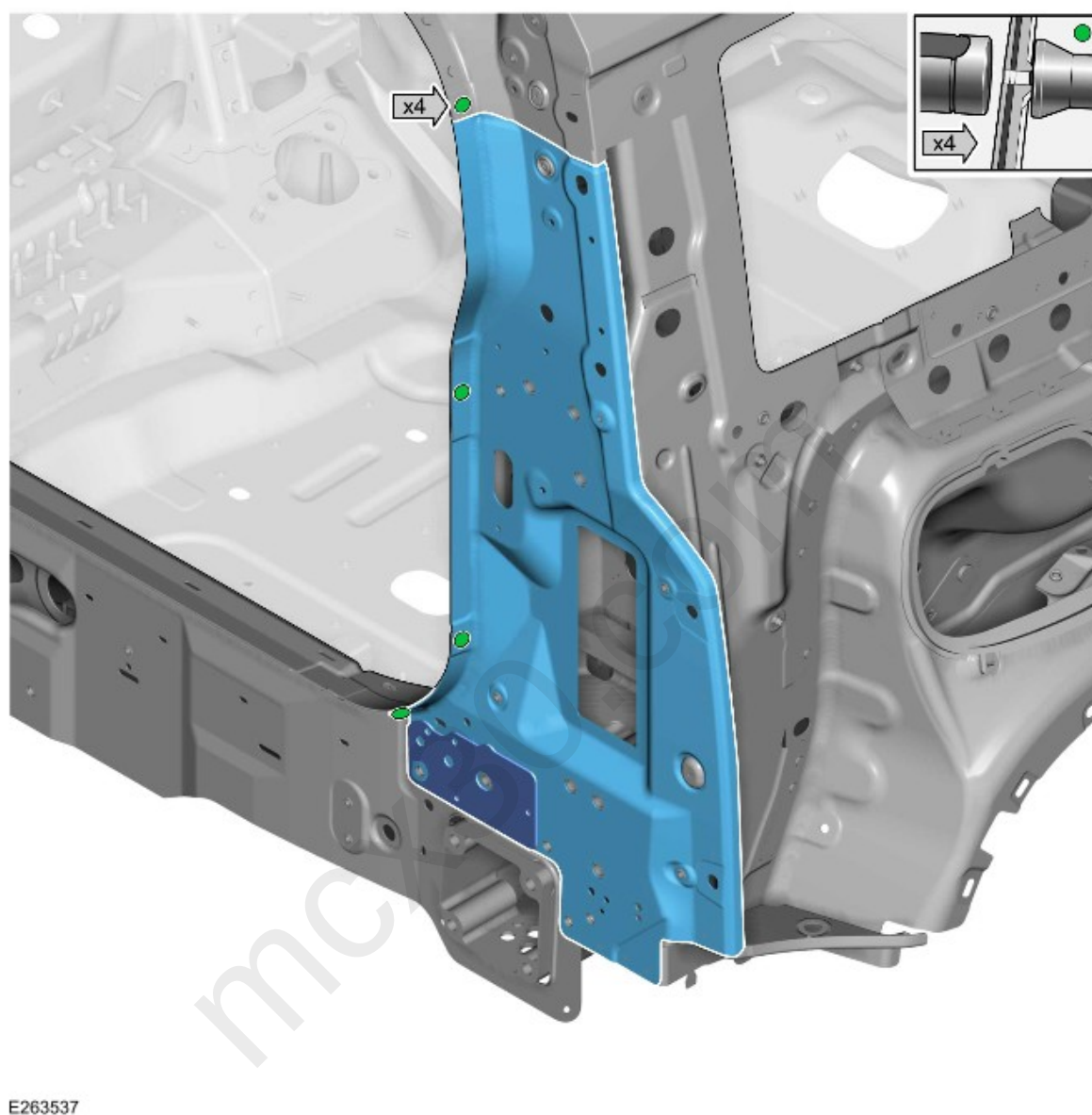
Remove the friction drilling screws as indicated.



Remove the self piercing rivets as indicated.

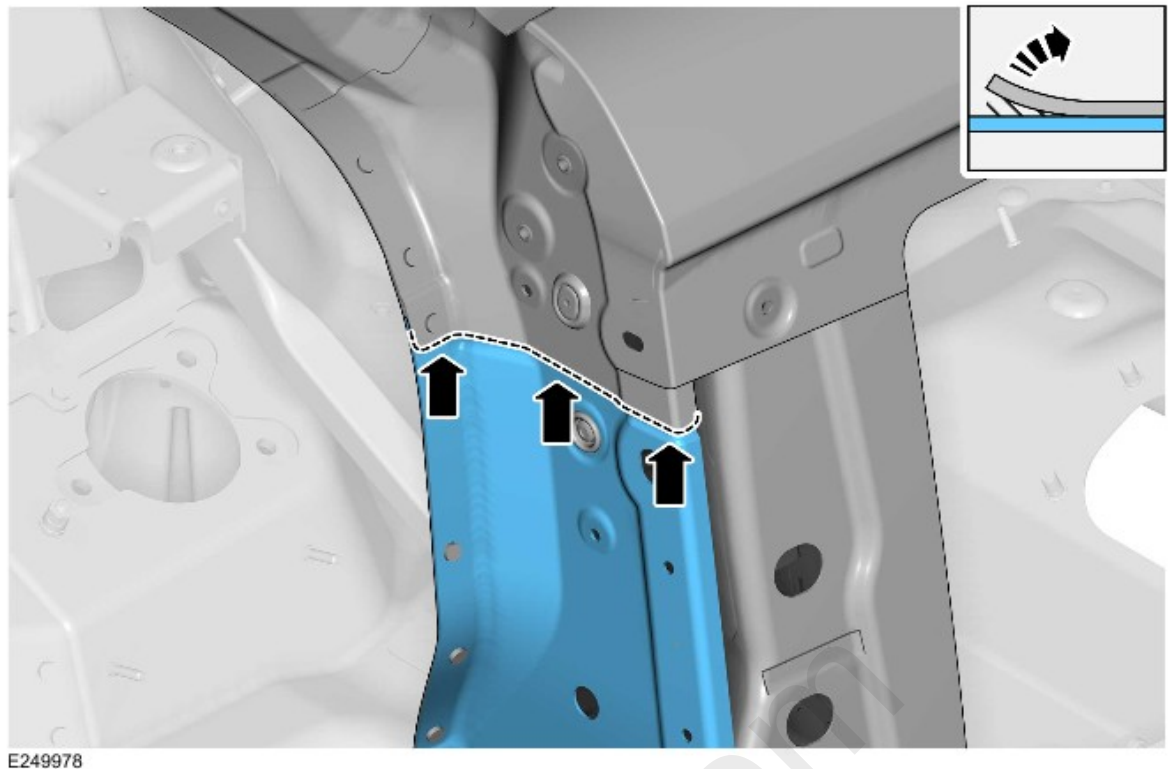
 NOTE:

Where Flow Form Rivet (FFR) installation is indicated. Make sure that the panel is planished before removal.



Planish the panel as indicated.

12.



Build an expansion space as indicated.

13. Carefully separate the joints and remove the outer tail lamp outer 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.

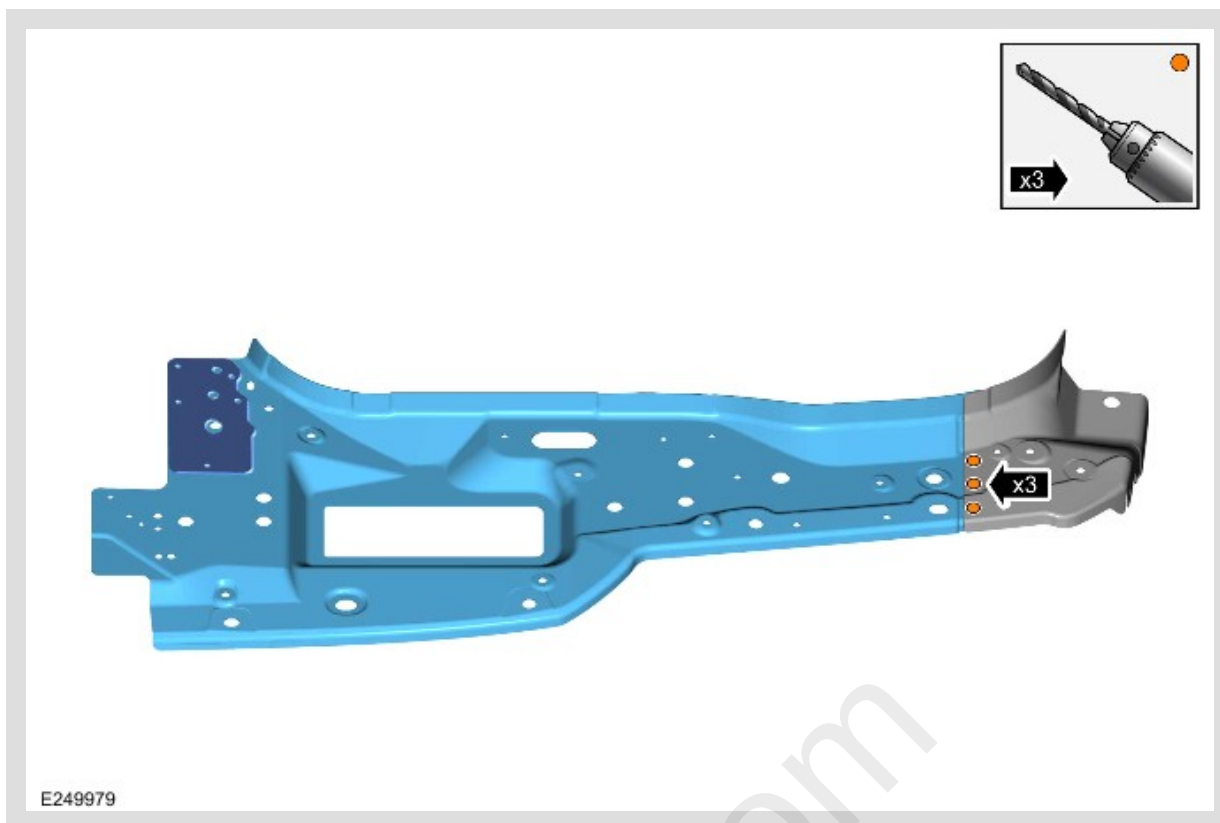
△ NOTES:

- 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.
- Flow Form Rivet (FFR) installation requires using the JLR approved FFR tool.
- Refer to Adhesive, Fixings and Consumables for further information on Flow Form Rivets (FFRs).

1. Remove the rivet remnants.

2. Dress the flanges where necessary.

3.



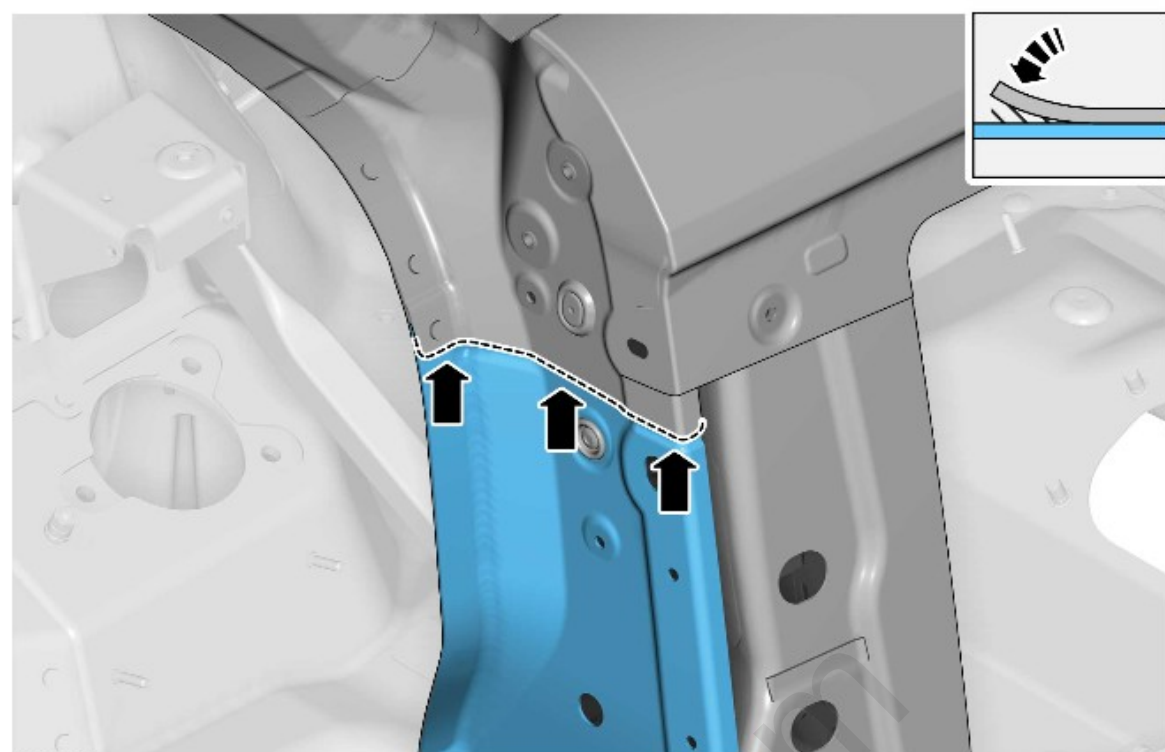
Remove the Self Piercing Rivets (SPRs) from the new outer tail lamp outer panel as indicated.

4.

Carefully separate the joints and remove the tail lamp outer panel upper section.

5.

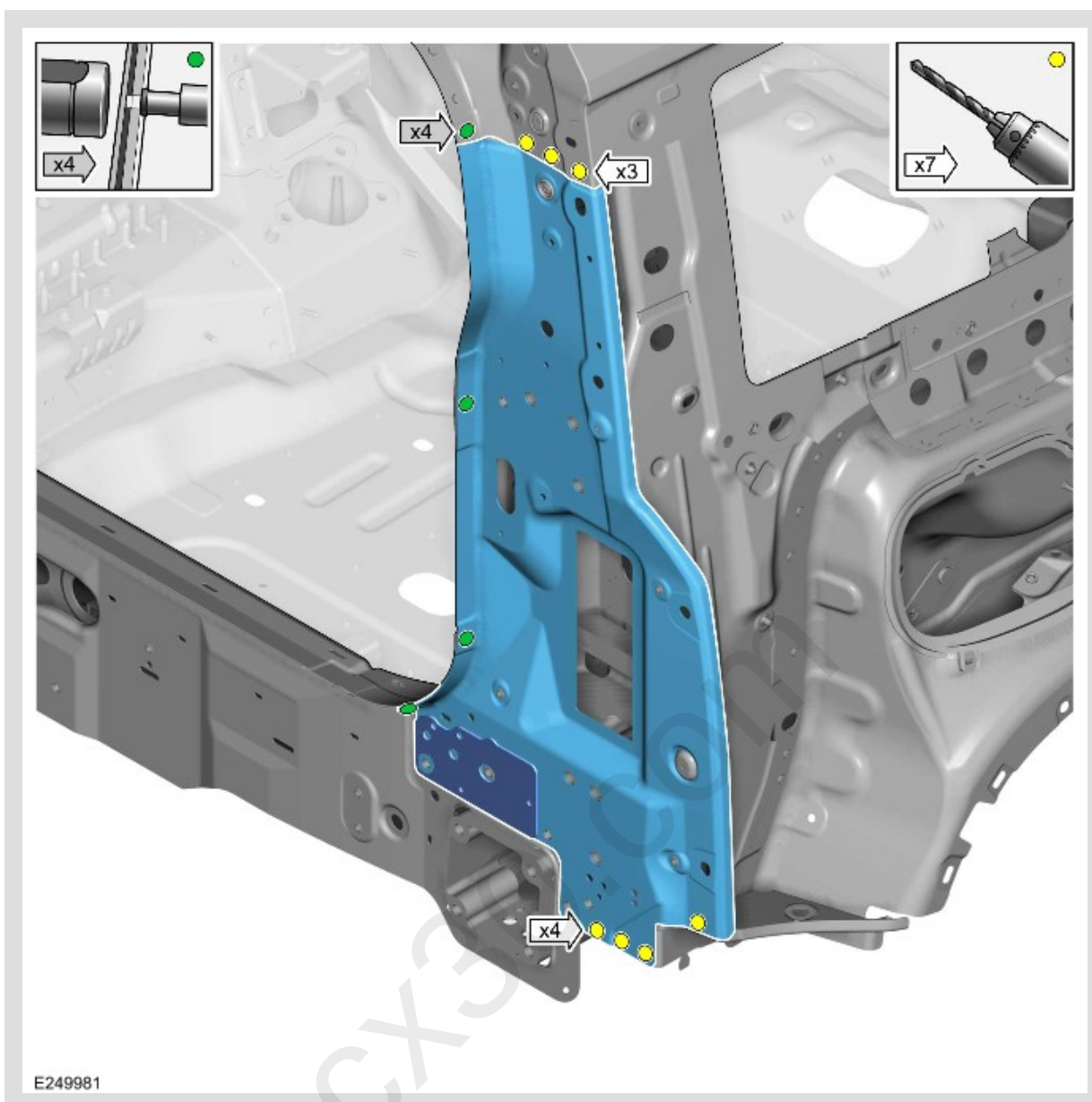
Offer up the new outer tail lamp outer panel. Clamp into position. Check alignment, if correct proceed to next step, if not rectify and check the alignment again before proceeding.



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Close the expansion space as indicated.

7.



Drill holes where the Breakstem Fasteners (BSFs) are to be installed. Punch calibrated holes where the Flow Form Rivets (FFRs) are to be installed as indicated.

8. Remove the new outer tail lamp outer panel.

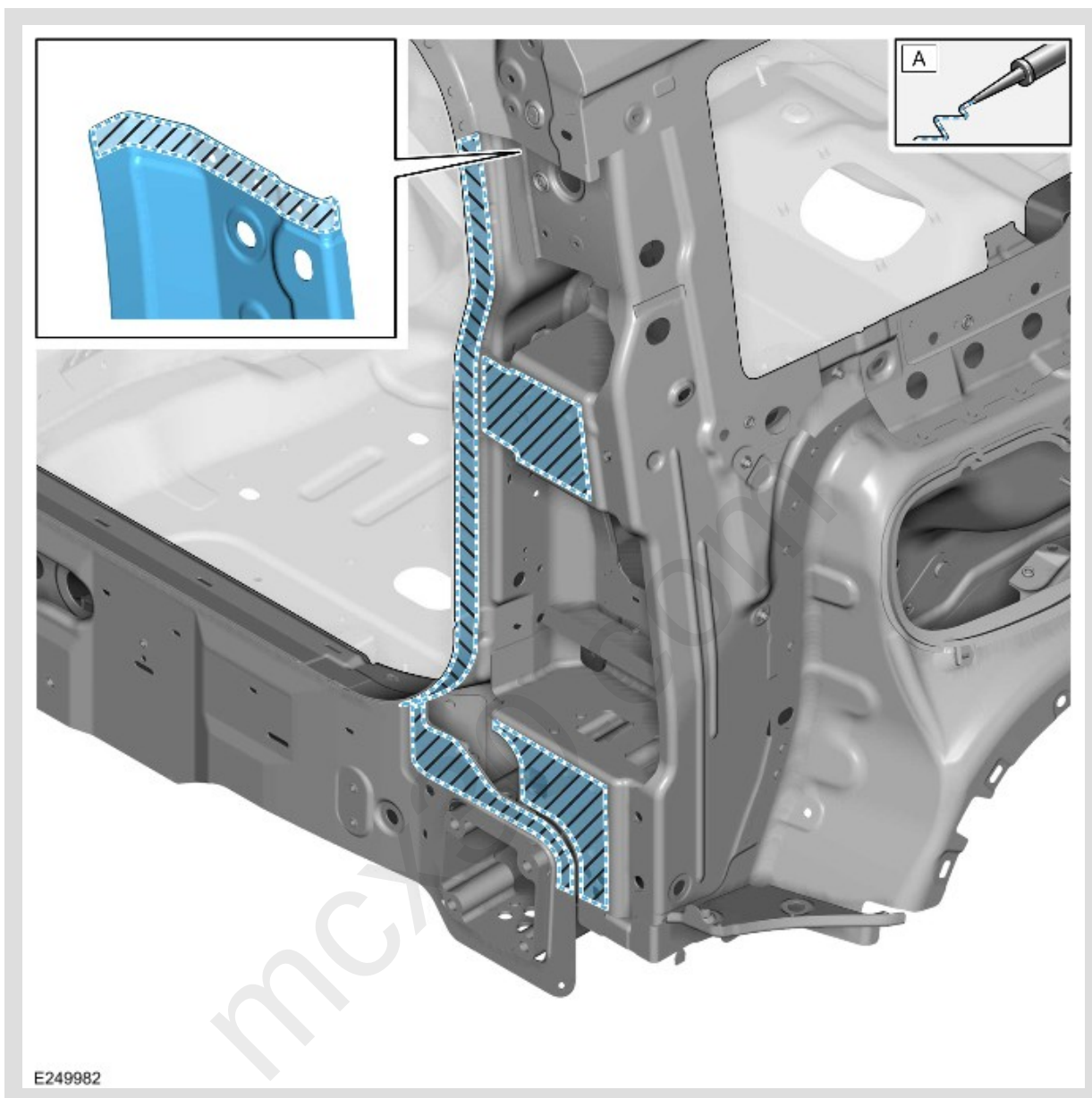
9. Deburr the drilled holes.

10. Clean and prepare the panel surfaces.

11.

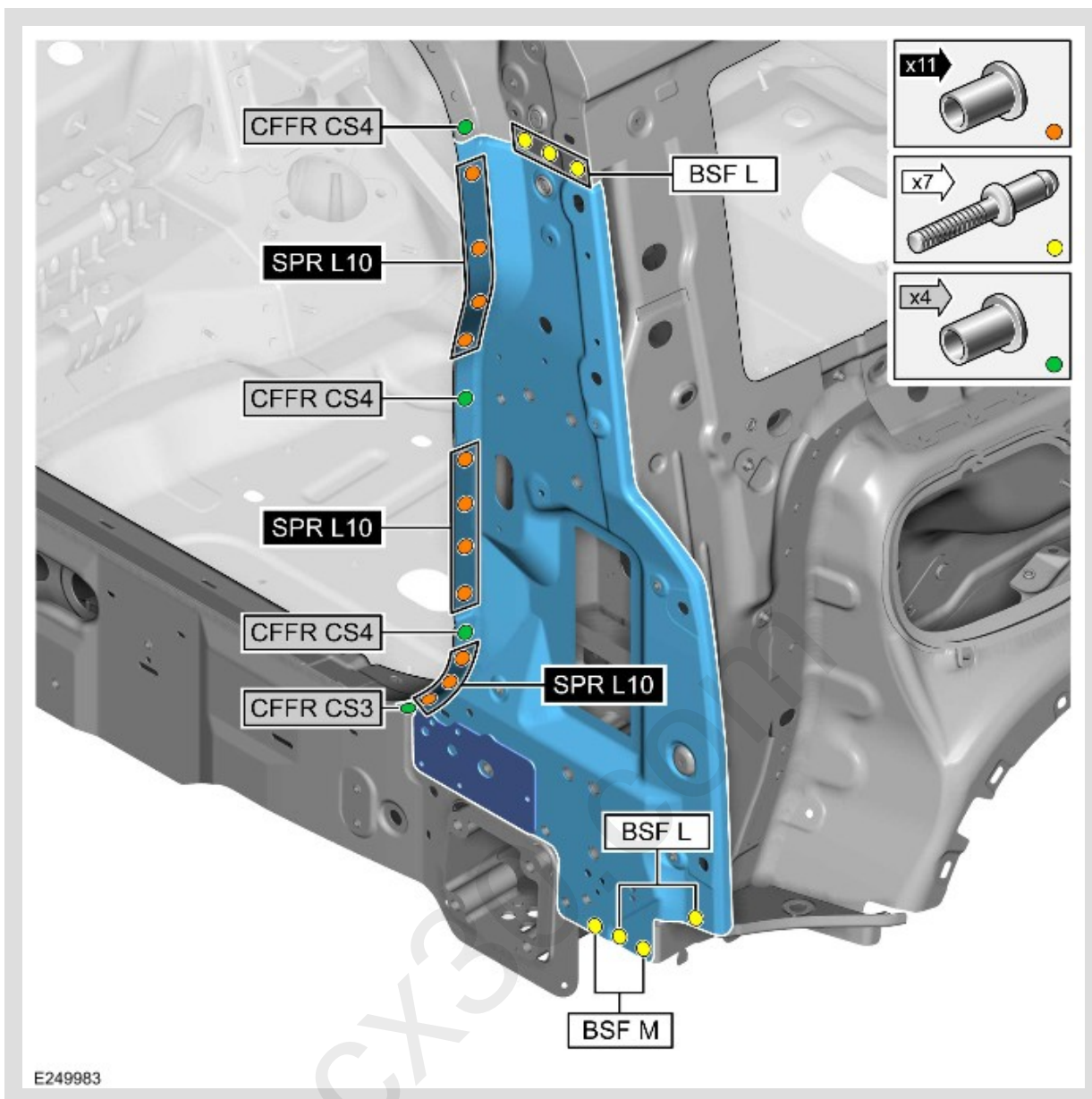
 NOTE:

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



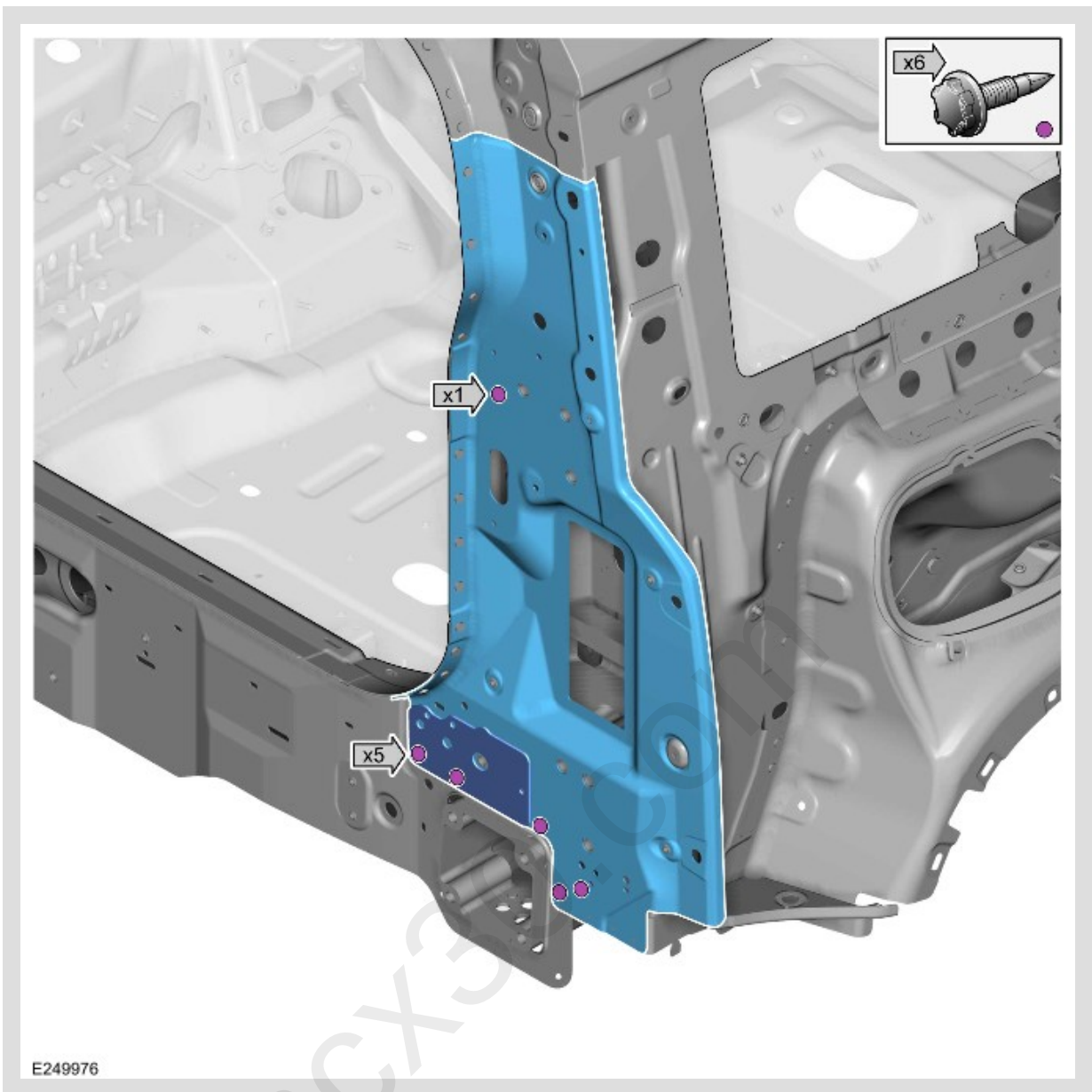
Apply a 5 mm zig zag bead of the JLR recommended bonding material as indicated.

12. Offer up the new outer tail lamp outer 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 FFRs, BSFs and SPRs as indicated.

14.



Install the new M6 Friction Drilling Screws (FDS) and tighten.

Torque: 10Nm

15. Remove any excess adhesive.

16. Install the tailgate upper and lower hinges.

Torque: 60Nm

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 installed fixings 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: [Quarter Panel - 90](#) (501-30 Rear End Sheet Metal Repairs, Removal and Installation).

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