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2020.0 DEFENDER (LE), 501-30

REAR END SHEET METAL REPAIRS

REAR FLOOR PANEL - 90 (G2452670)

mcx30.com

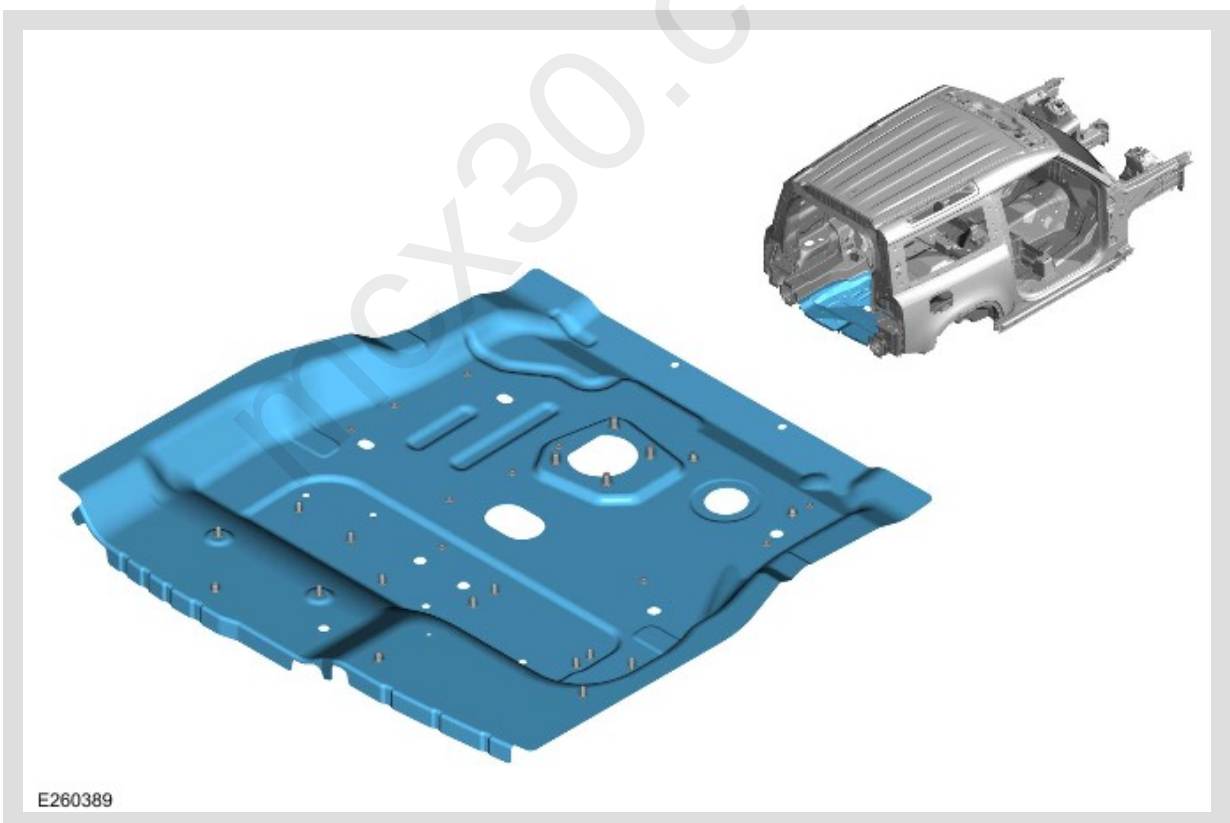
REMOVAL

 NOTE:

In this procedure the rear floor panel is installed in conjunction with:

- Second row seat
- Fuel filler neck
- Back panel inner
- Back panel inner extensions.

1.



The rear floor 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).

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 rear floor 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).

4.

For additional information on the fixings required to complete this procedure

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

5.

For additional removal information

Refer to: [Second Row Seat - 90](#) (501-10 Seating, Removal and Installation).

6.

For additional removal information

Refer to: [Fuel Filler Neck - INGENIUM I4 2.0L Petrol](#) (310-01A Fuel Tank and Lines - INGENIUM I4 2.0L Petrol/INGENIUM I4 2.0L Petrol - PHEV, Removal and Installation).

Refer to: [Fuel Tank Filler Pipe - INGENIUM I4 2.0L Petrol - PHEV](#) (310-01 Fuel Tank and Lines - INGENIUM I4 2.0L Petrol/INGENIUM I4 2.0L Petrol - PHEV, Removal and Installation).

7.

For additional removal information

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

8.

For additional removal information

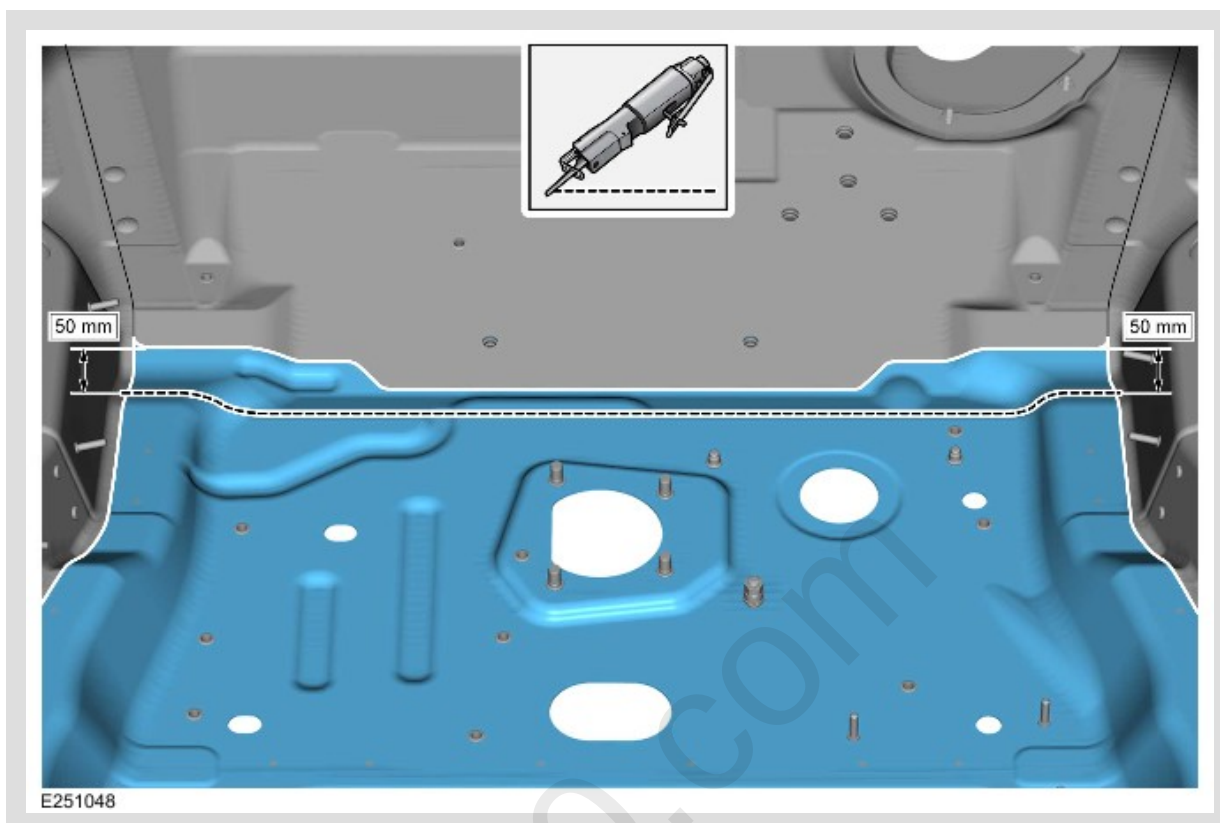
Refer to: [Back Panel Inner Extensions - 90](#) (501-30 Rear End Sheet Metal Repairs, Removal and Installation).

9.

Release and position the wiring harness to one side.

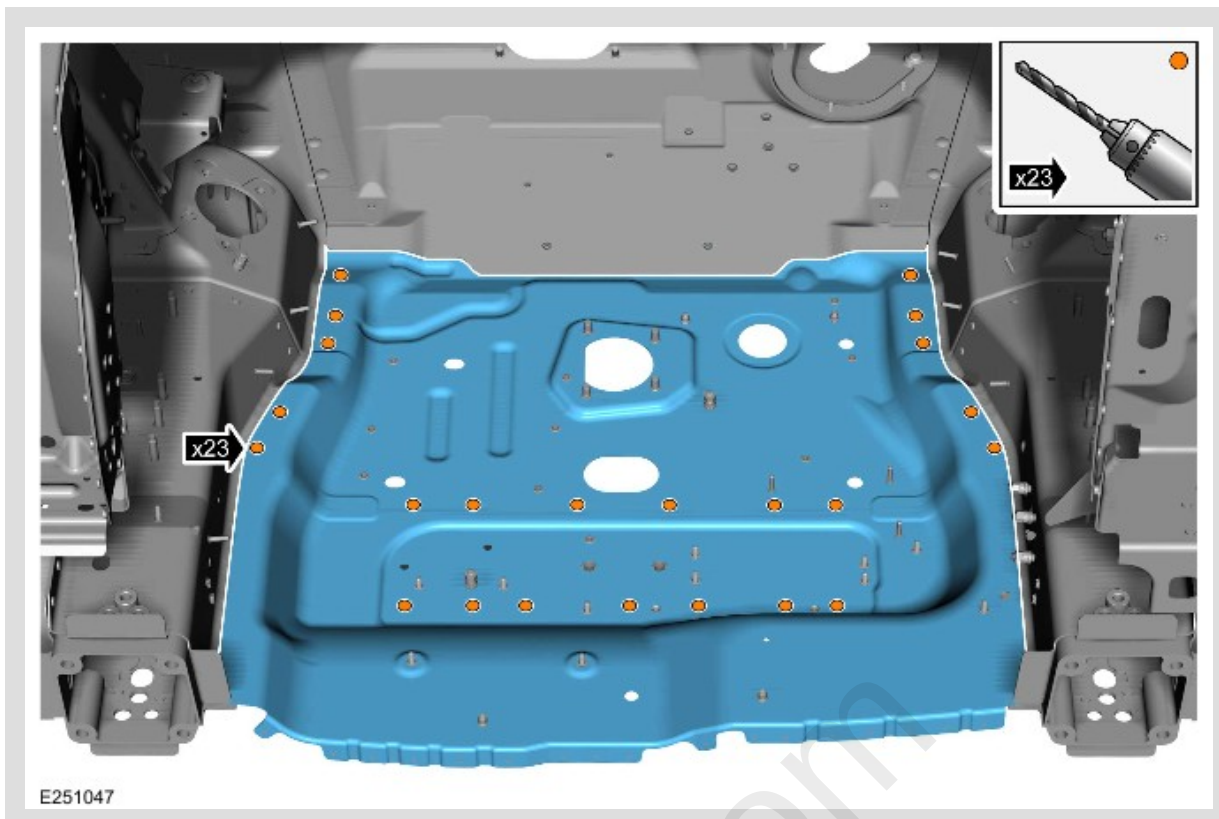
⚠ CAUTION:

Care should be taken not to cut through into the inner reinforcements.



Mark and cut the rear floor panel as indicated.

11.



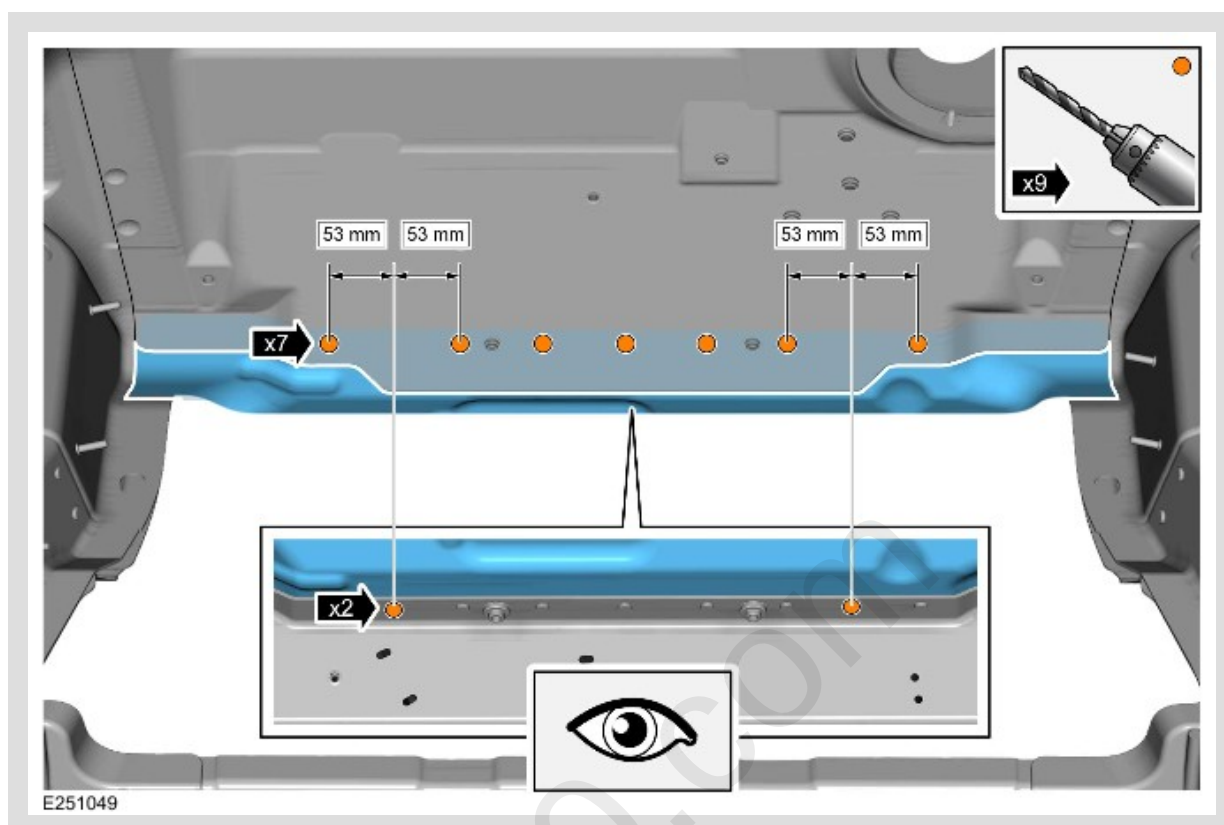
Remove the Self Piercing Rivets (SPRs) as indicated.

12.

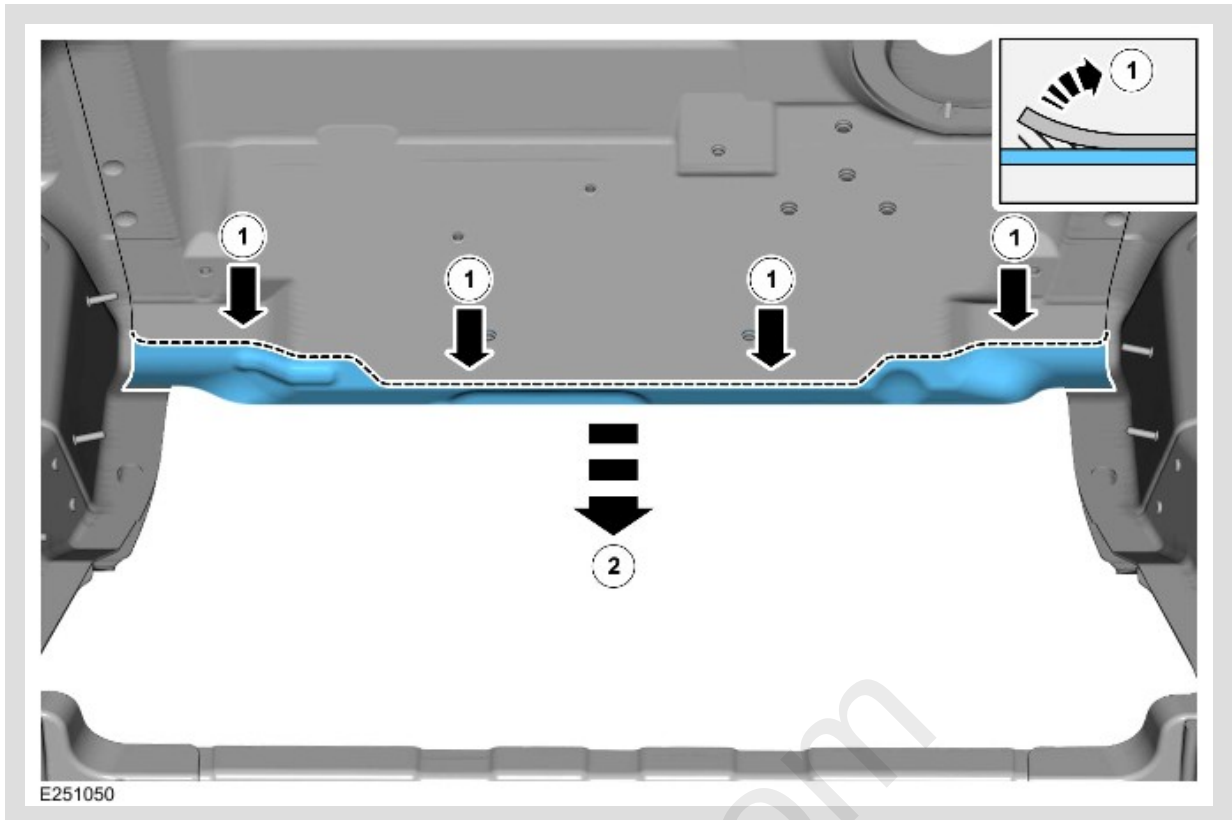
Carefully separate the joints and remove the rear floor panel.

 NOTE:

Note the location of the Self Piercing Rivets (SPRs) before removal.



Remove the SPRs as indicated.



Build an expansion space and carefully separate the joints. Remove the rear floor panel remnant as indicated.

INSTALLATION

⚠ CAUTION:

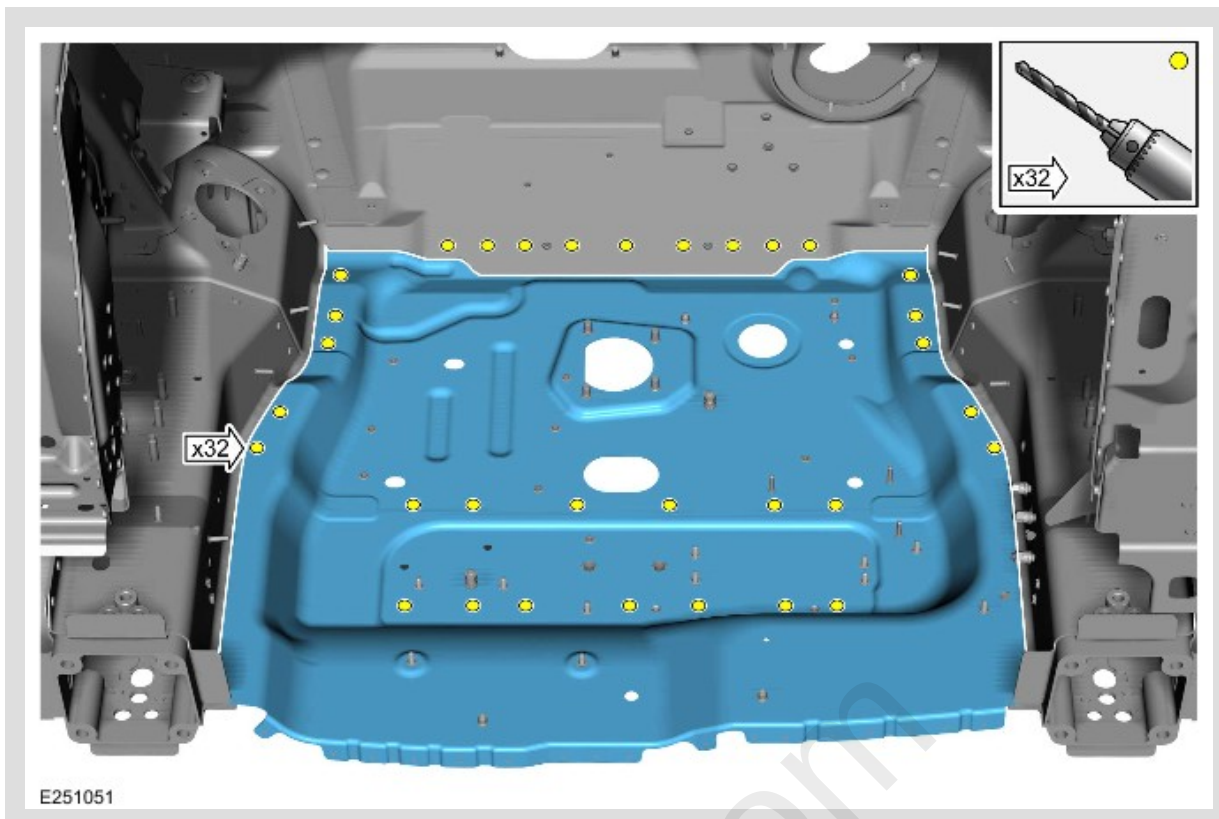
Where structural adhesive is to be applied between surfaces it is essential compression is applied to the joints during the curing period.

△ NOTE:

Breakstem Fastener (BSF) installation involves using the 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 rear floor 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. Remove the new rear floor panel.

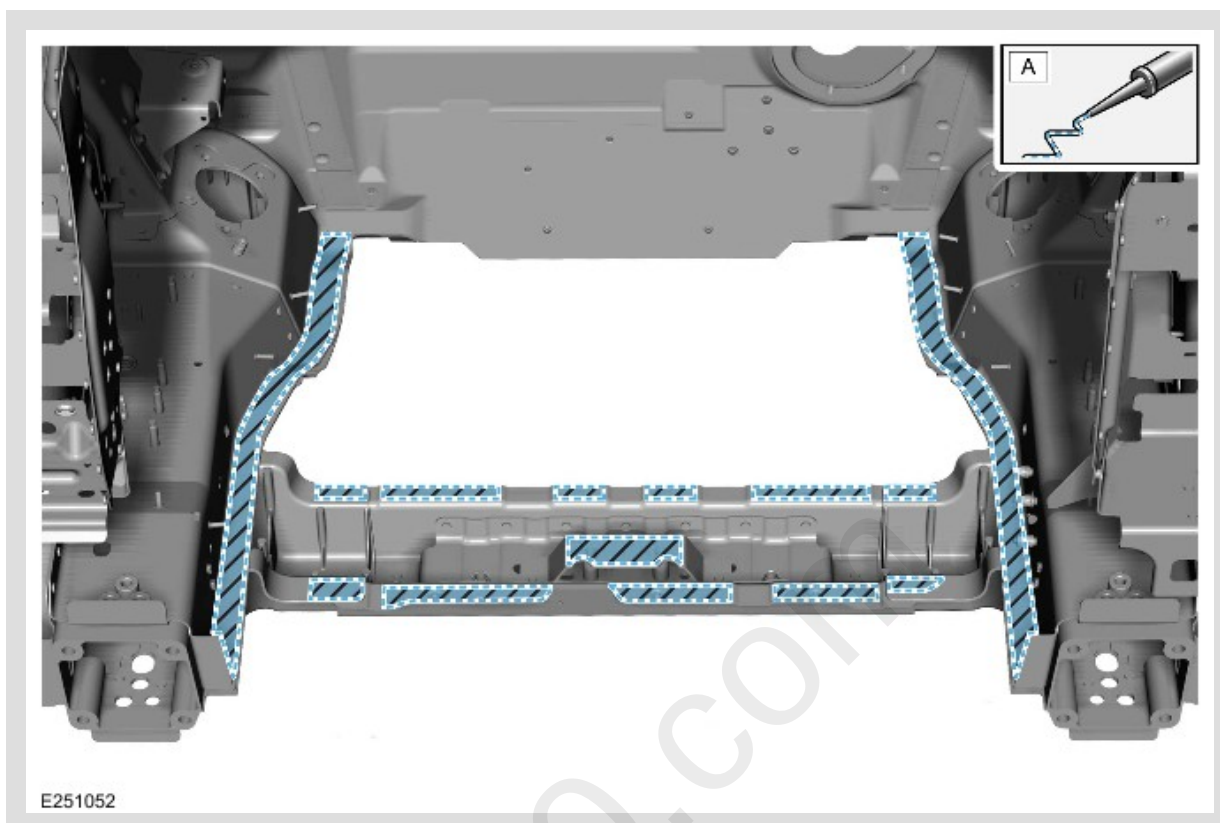
6. Deburr the drilled holes.

7. Clean and prepare the panel surfaces.

8.

 NOTE:

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

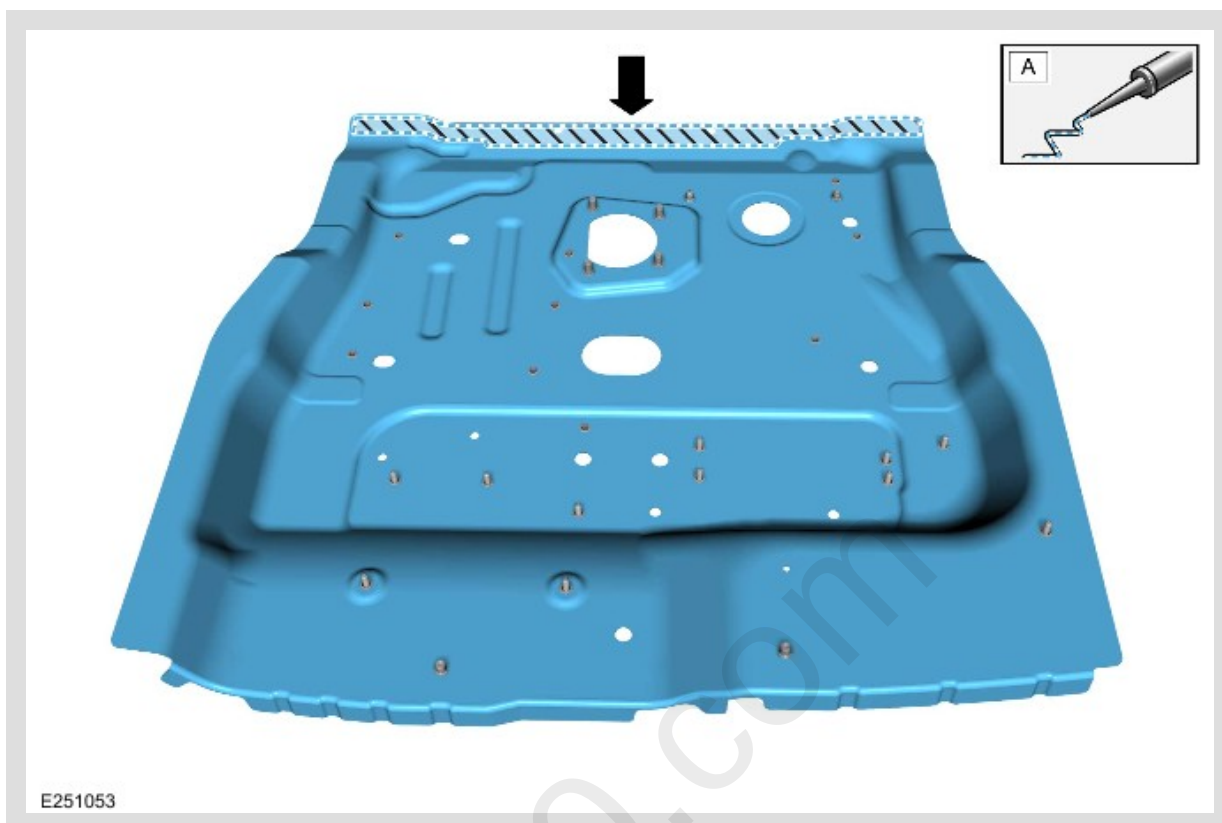


Apply a 5 mm zig zag bead of the JLR recommended bonding material as indicated.

9.

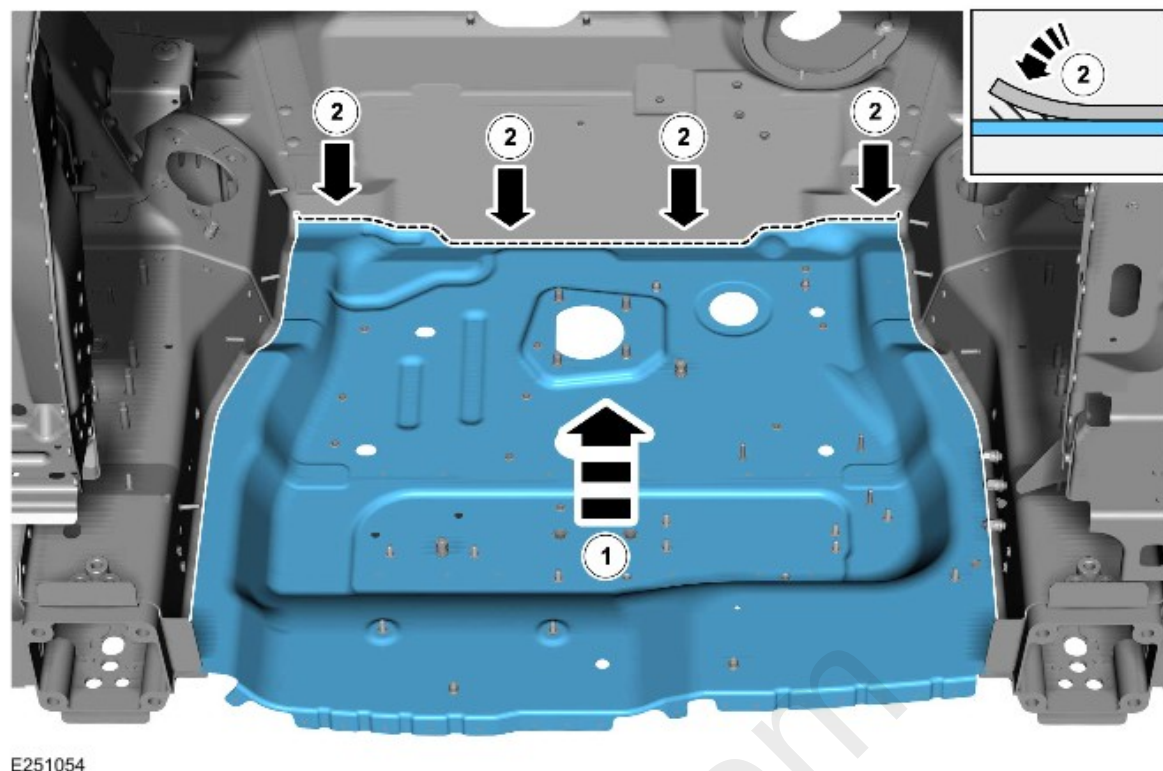
 NOTE:

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



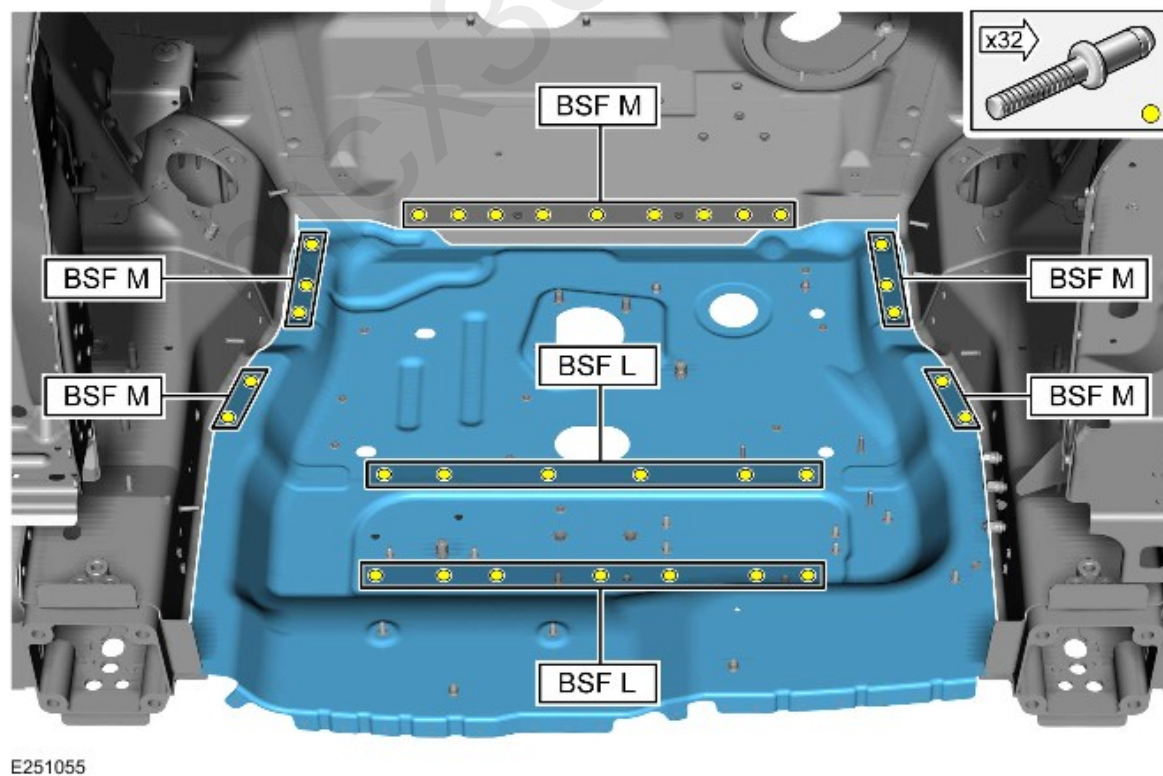
Apply a 5 mm zig zag bead of the JLR recommended bonding material as indicated.

10.



Offer up the new rear floor panel as indicated, close the expansion space 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. Remove any excess adhesive.

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

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

15. 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 the removal procedure.

16. For additional installation information

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

17. For additional installation information

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

18. For additional installation information

Refer to: [Fuel Filler Neck - INGENIUM I4 2.0L Petrol](#) (310-01A Fuel Tank and Lines - INGENIUM I4 2.0L Petrol/INGENIUM I4 2.0L Petrol - PHEV, Removal and Installation).

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19. For additional installation information

Refer to: [Second Row Seat - 90](#) (501-10 Seating, Removal and Installation).