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2020.0 DEFENDER (LE), 501-30

REAR END SHEET METAL REPAIRS

TAILGATE OPENING PANEL LEFT SIDE - 90 (G2452673)

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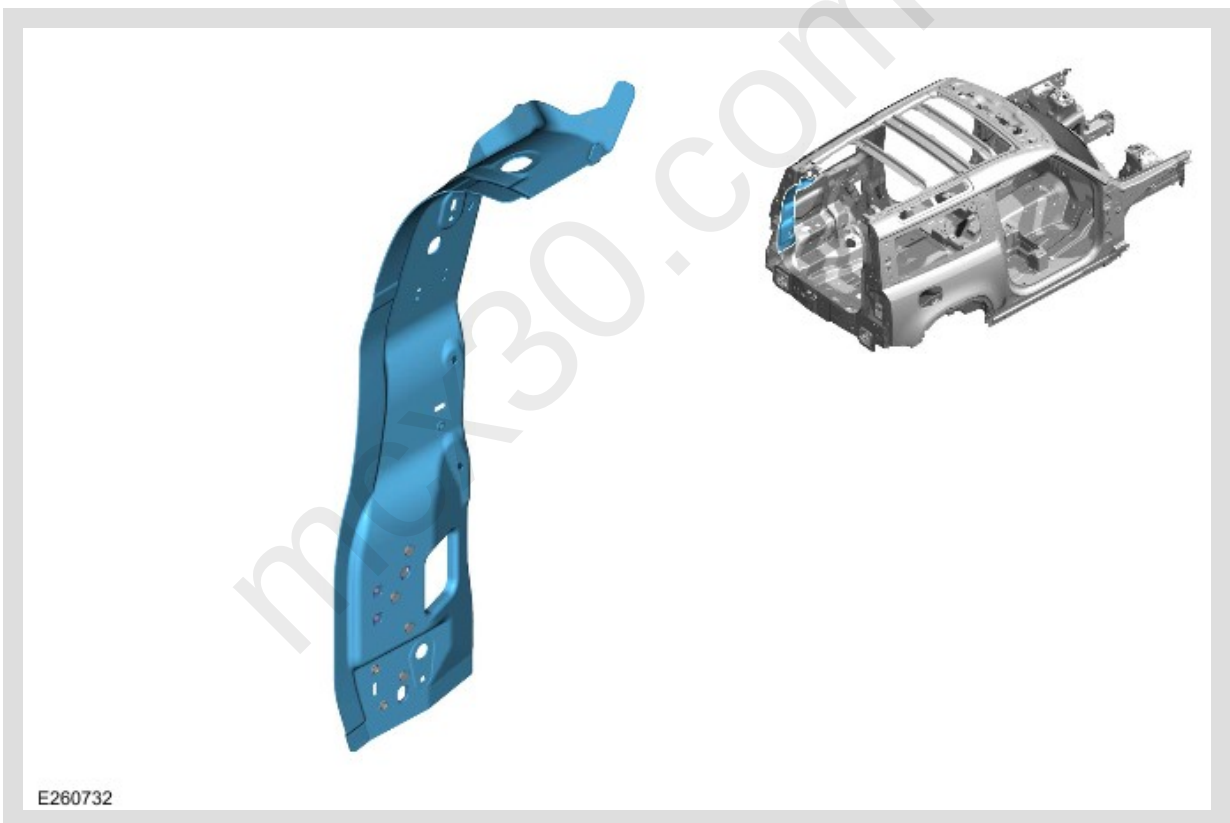
REMOVAL

 NOTE:

In this procedure, the tailgate opening panel left side is installed in conjunction with:

- Rear header panel lower
- Tailgate reinforcement left side.

1.



The tailgate opening panel left side 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 tailgate opening panel left 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).

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: [Rear Header Panel Lower - 90](#) (501-28 Roof Sheet Metal Repairs, Removal and Installation).

6.

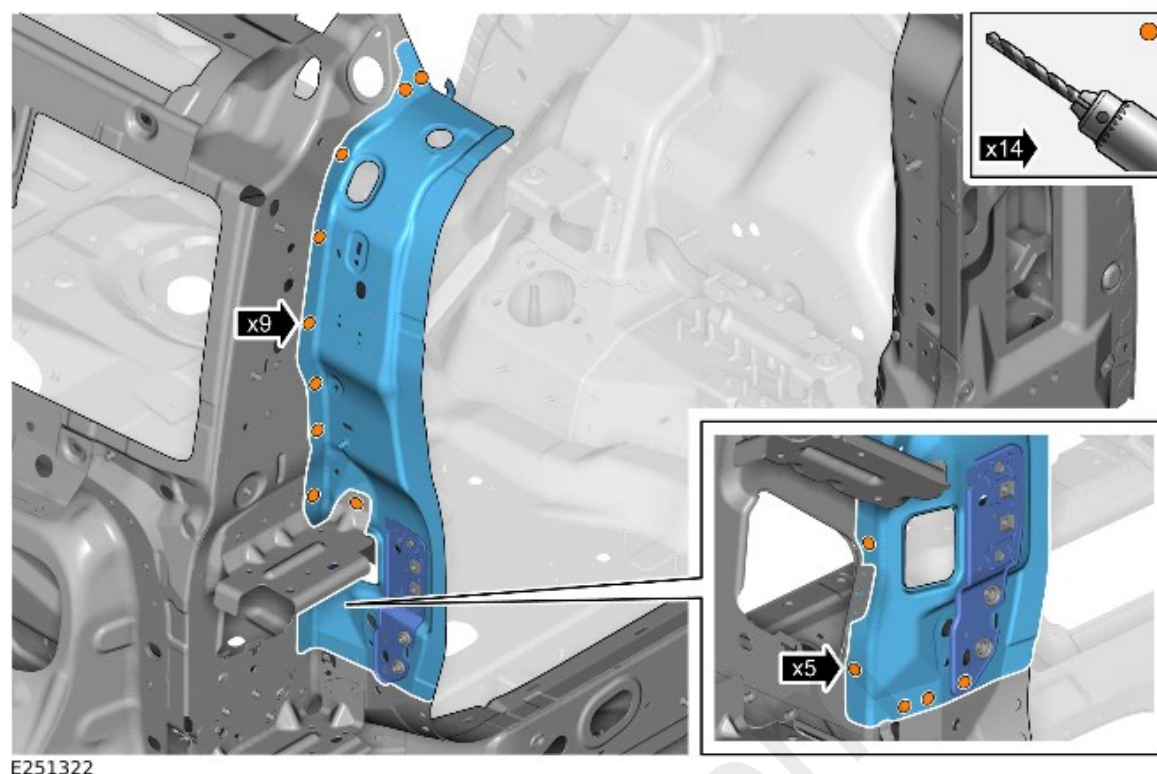
For additional removal information

Refer to: [Tailgate Reinforcement Left Side - 90](#) (501-30 Rear End Sheet Metal Repairs, Removal and Installation).

7.

Release and position the wiring harness to one side.

8.



Remove the self piercing rivets as indicated.

9. Carefully separate the joints and remove the tailgate opening panel left side.

INSTALLATION

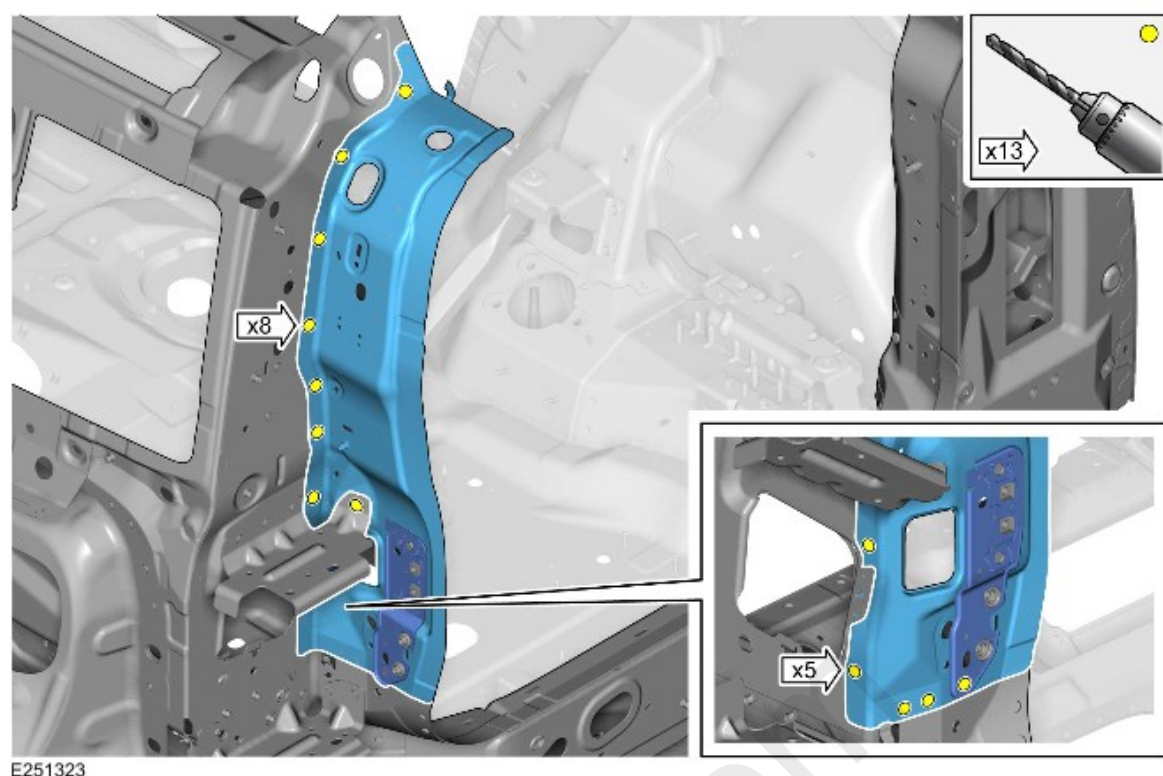
⚠ CAUTION:

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

△ 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 tailgate opening panel left side and clamp into position. Check alignment, if correct proceed to next step, if not rectify and check the alignment again before proceeding.

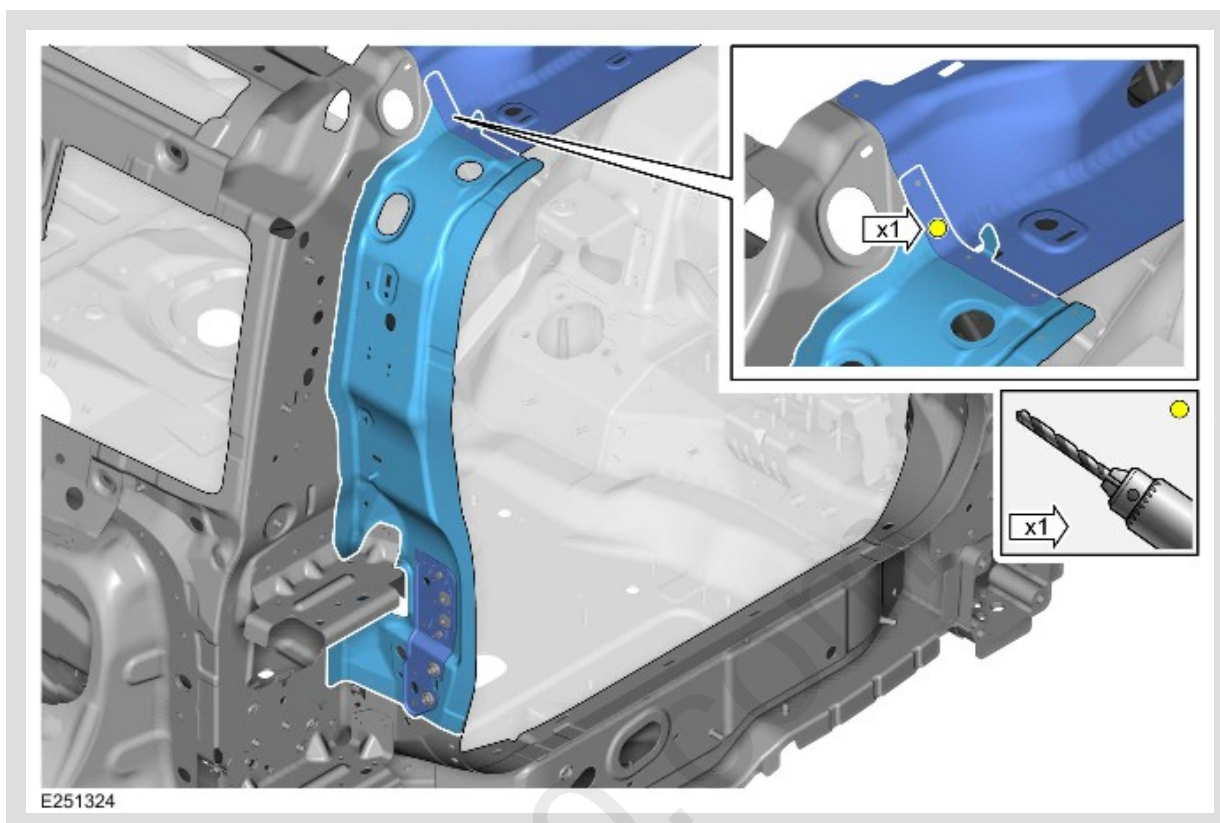


Drill holes where the Breakstem Fasteners (BSFs) are to be installed as indicated.

5.

NOTE:

When installing the tailgate opening panel left side in conjunction with the rear header panel lower.



Drill a hole where the BSF is to be installed as indicated.

6. Remove the new tailgate opening panel left side.

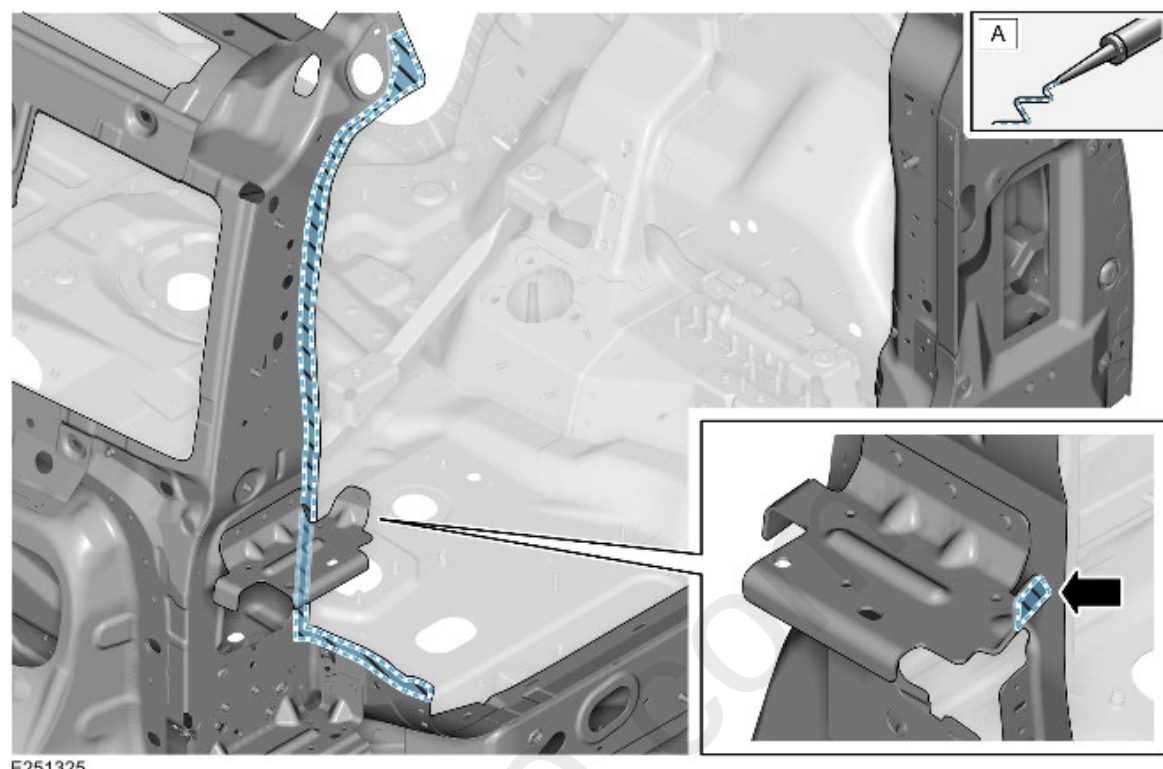
7. Deburr the drilled holes.

8. Clean and prepare the panel surfaces.

9.

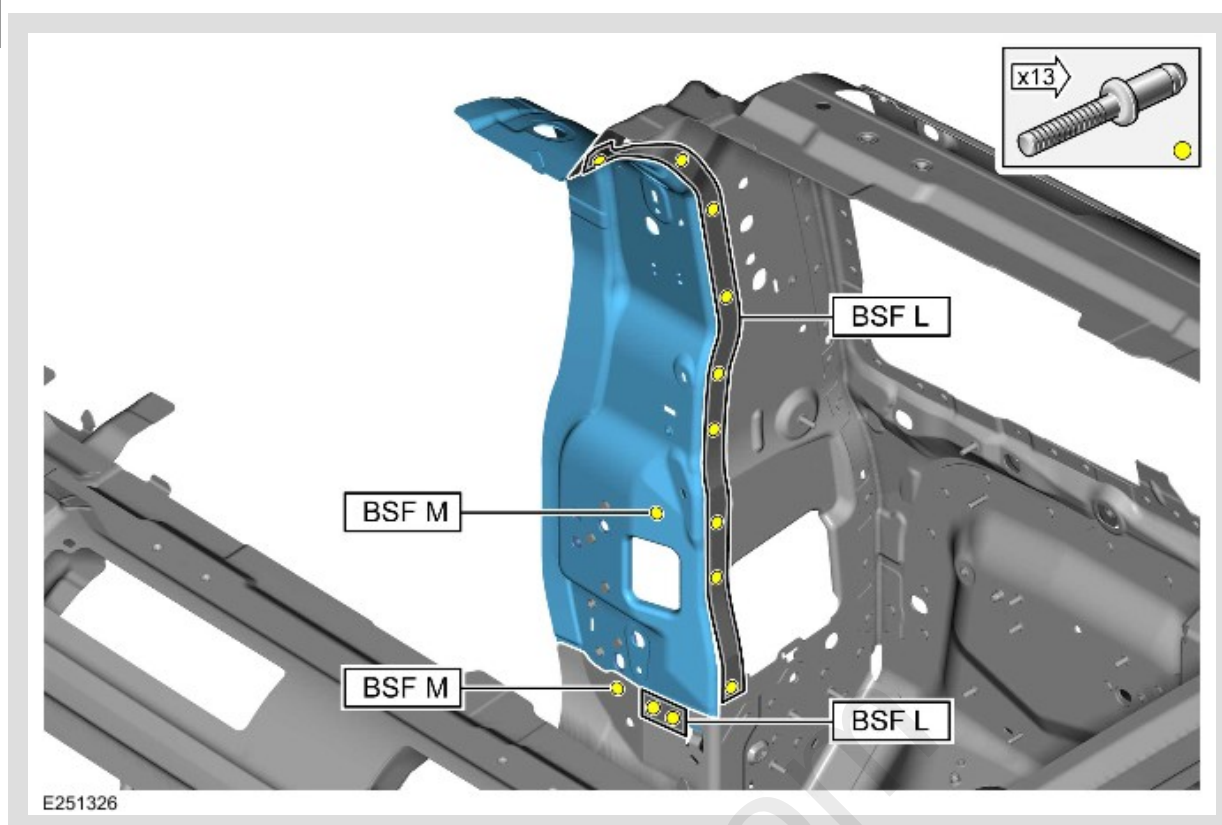
NOTE:

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.

10. Offer up the new tailgate opening panel left side and clamp into position. Check alignment, if correct proceed to next step, if not rectify and check the alignment again before proceeding.

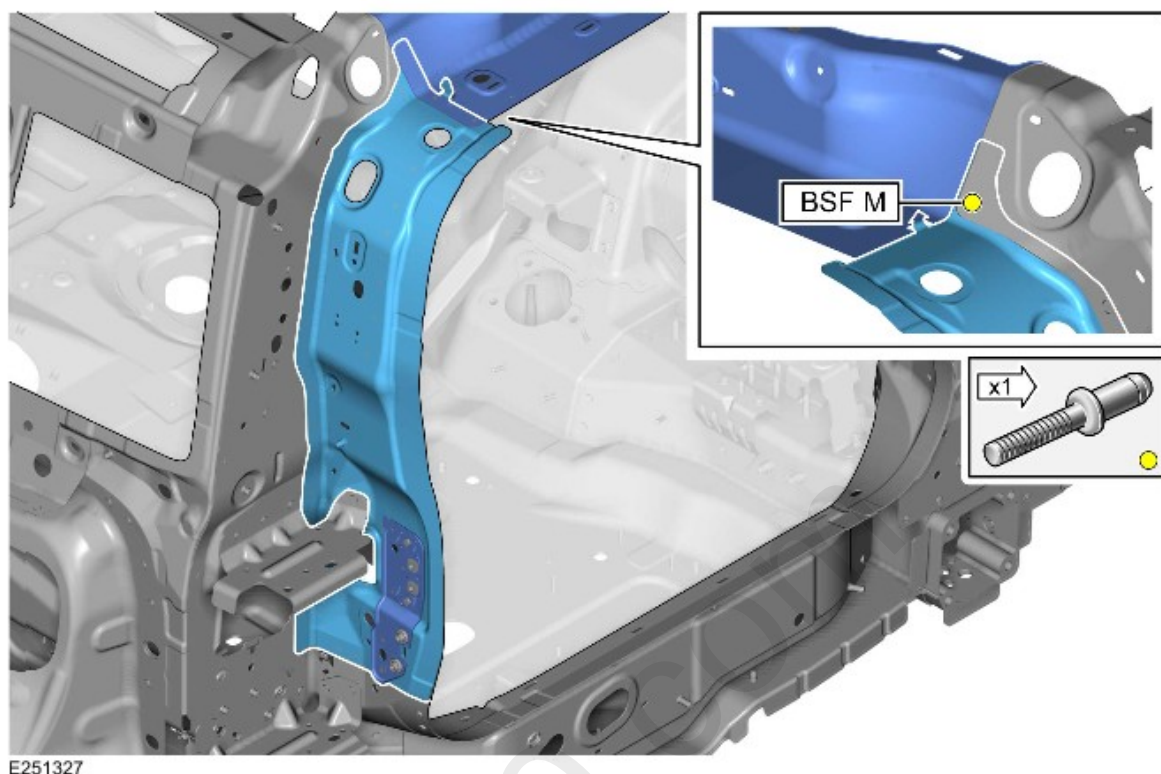


Install the BSFs as indicated.

12.

 NOTE:

When installing the tailgate opening panel left side in conjunction with the rear header panel lower.



Install the BSF as indicated.

13. Remove any excess adhesive.

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

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

16. 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.

17. For additional installation information

Refer to: [Tailgate Reinforcement Left Side - 90](#) (501-30 Rear End Sheet Metal Repairs, Removal and Installation).

18. For additional installation information

Refer to: [Rear Header Panel Lower - 90](#) (501-28 Roof Sheet Metal Repairs, Removal and Installation).

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