

Locate the earths located near to the weld area [Earths on body: List and location of components](#) .

3)SPECIAL NOTES ON MATING



CAUTION

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld [Connections by arc welding under shielding gas: Description](#) (MR 400, 40C, Gas metal arc welded connections (GMAW)).



Repair-40x08x02x04-02x49-1-2-1.xml



XSL version : 3.02 du 22/07/11

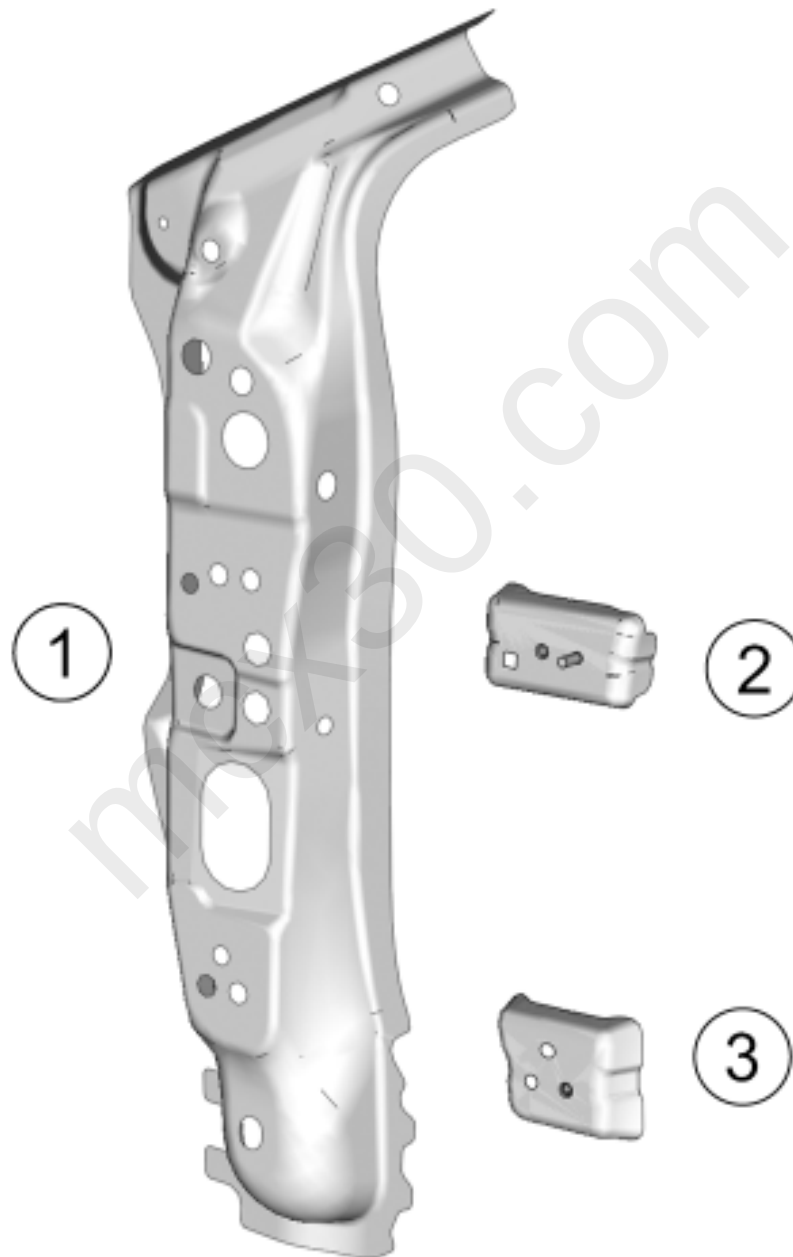
A-PILLAR REINFORCEMENT REPLACEMENT



Note, one or more warnings are present in this procedure



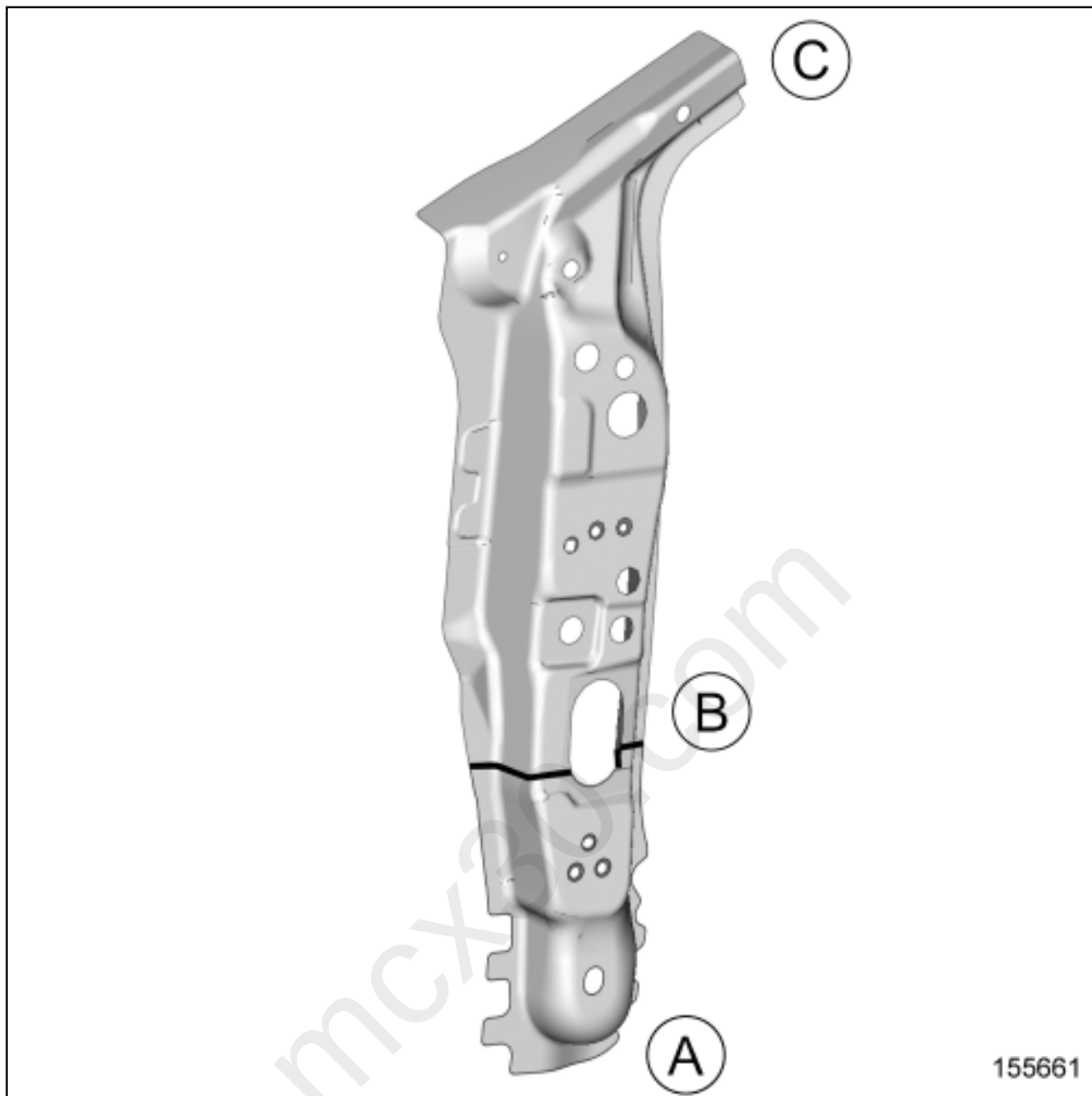
1. COMPOSITION OF THE SPARE PART



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No.	Description	Type	Thickness (mm)
(1)	A-pillar reinforcement	HLE	1.2
(2)	A-pillar upper hinge reinforcement	HLE	2
(3)	A-pillar lower hinge reinforcement	THLE	2

2. IN THE EVENT OF REPLACEMENT



There are several ways of replacing this part:



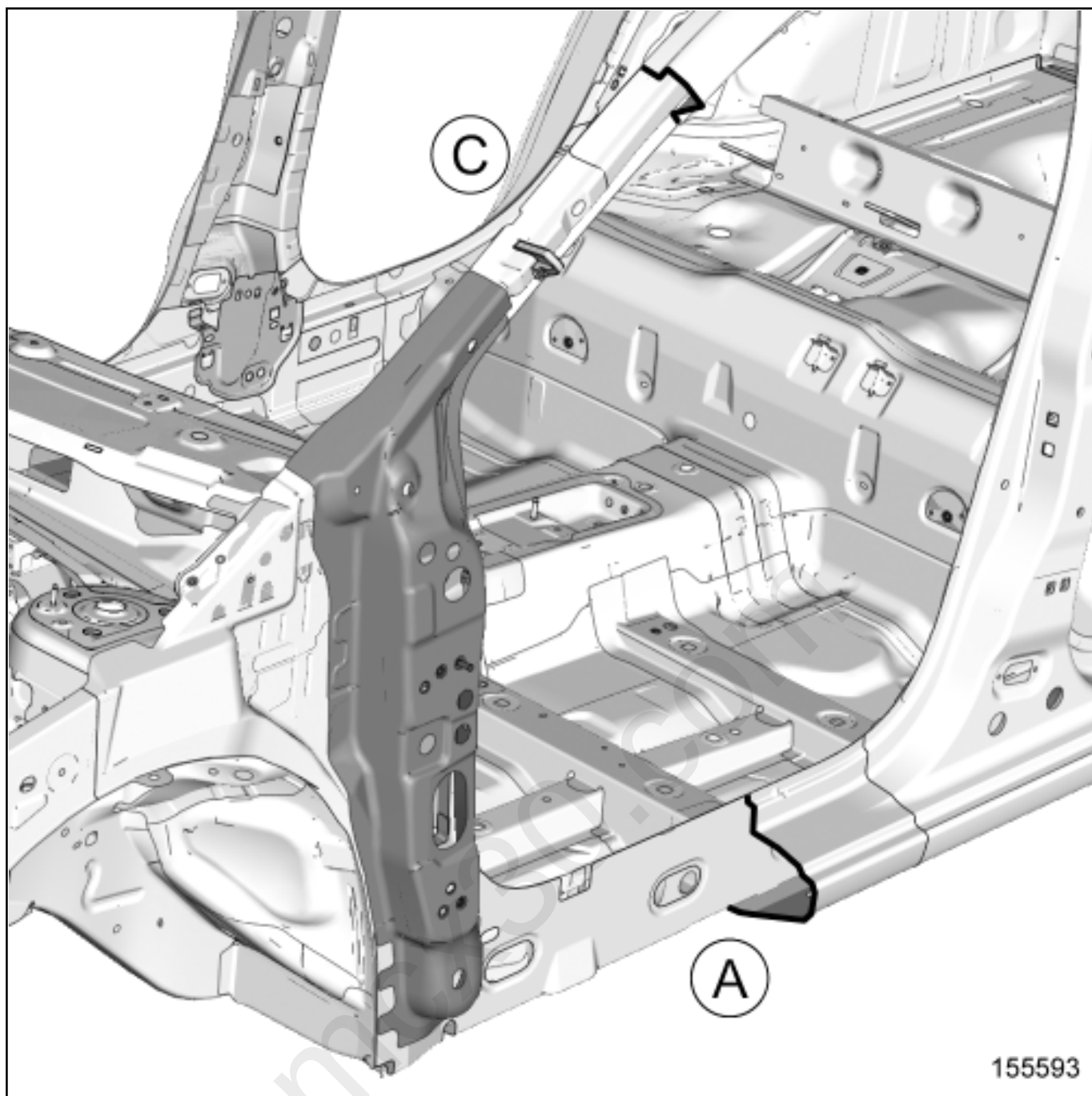
complete replacement A-C



partial replacement B.

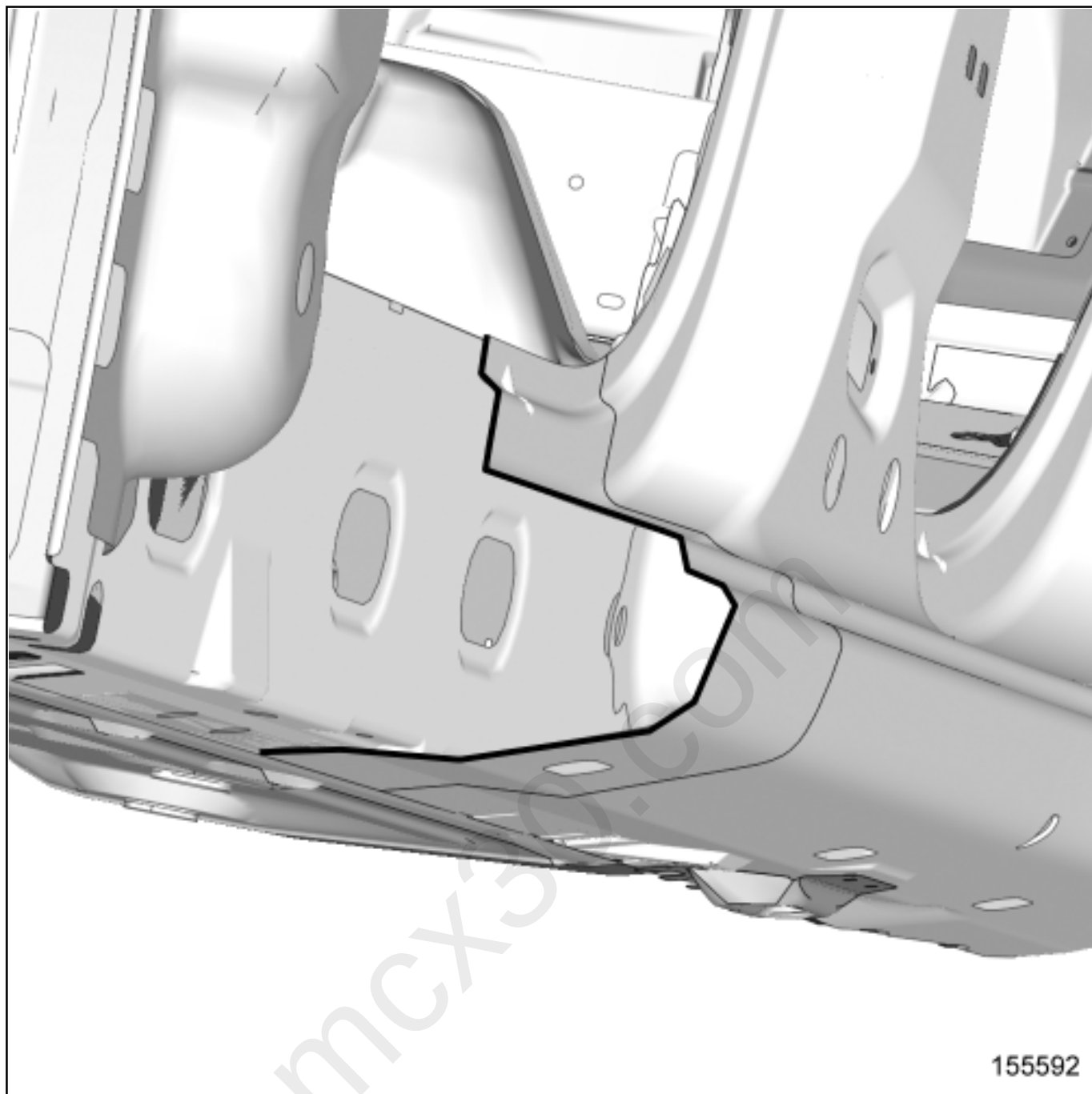
1- COMPLETE REPLACEMENT A-C

1)PART IN POSITION



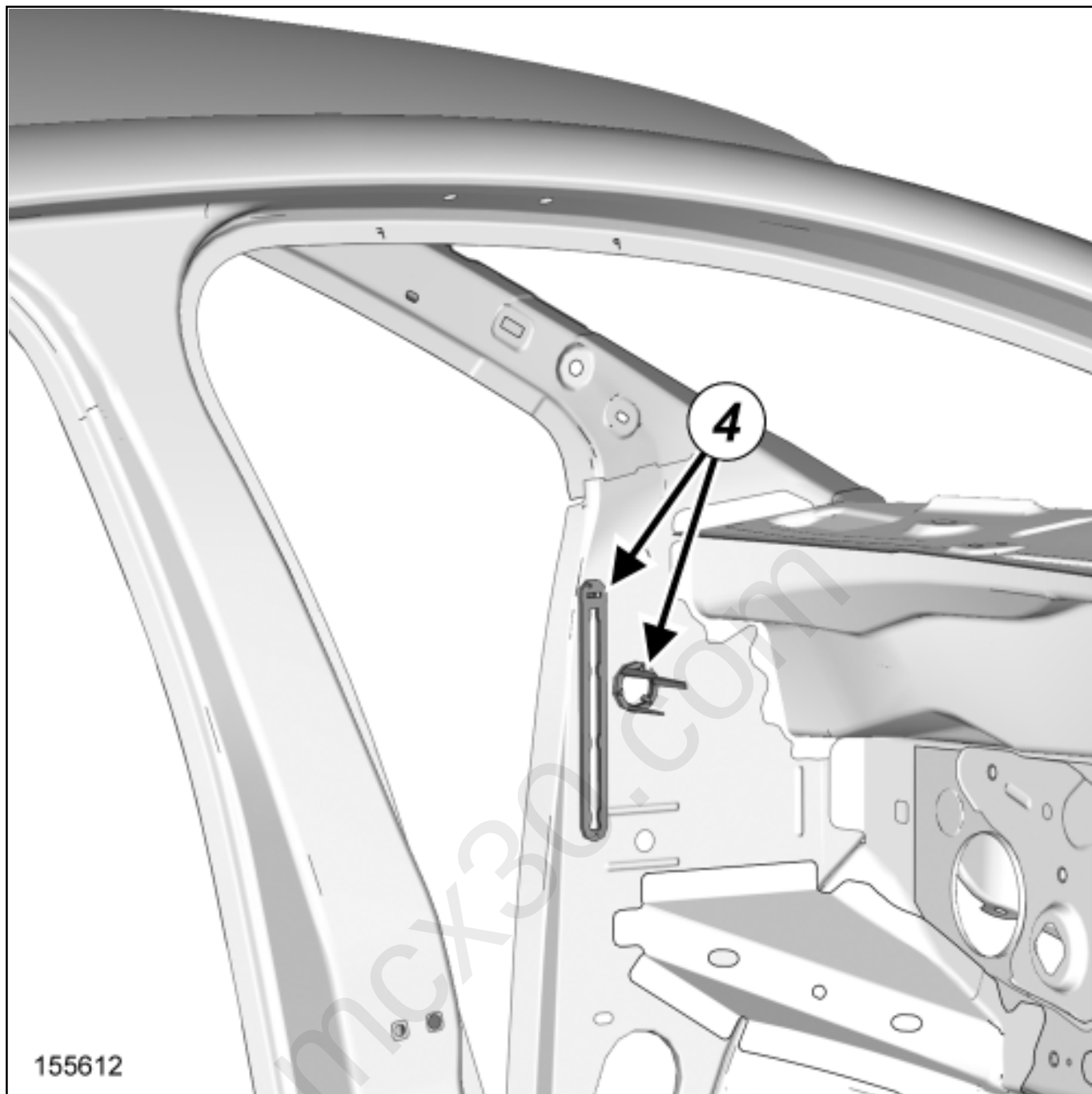
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DETAILED VIEW A



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2)PARTS ALWAYS TO BE REPLACED



Replace the A-pillar expanding inserts(4)

3)POSITION OF ELECTRIC EARTHS

CAUTION



To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

Position the earth of the welding machine as close as possible to the weld area (see **Bolted connection for earth: Fitting**) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area [Earths on body: List and location of components](#) .

4) SPECIAL NOTES ON MATING

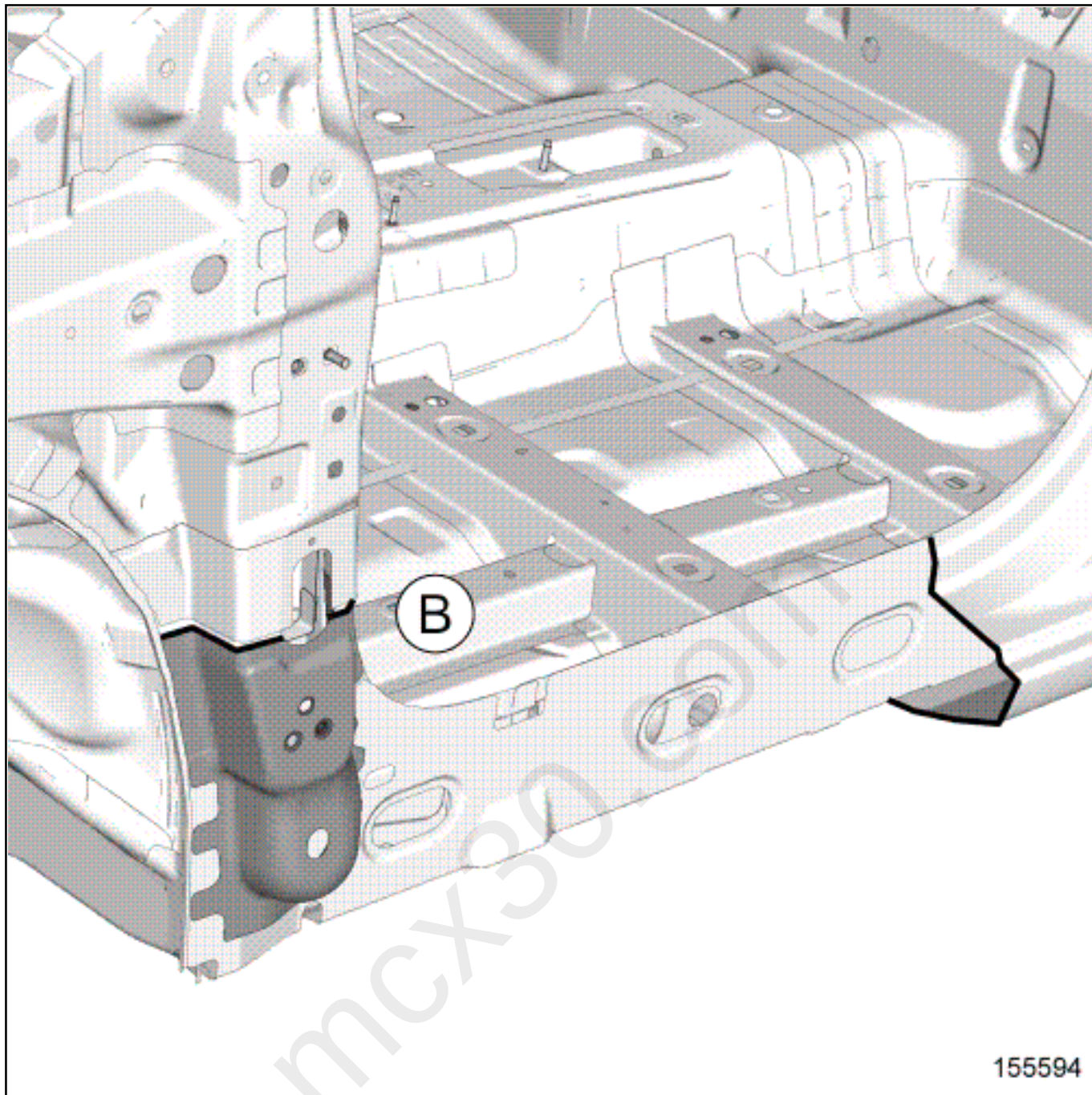
CAUTION



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2- PARTIAL REPLACEMENT B

1) PART IN POSITION



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2) POSITION OF ELECTRIC EARTHS

CAUTION



To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

Position the earth of the welding machine as close as possible to the weld area(see **Bolted connection for earth: Fitting**) (MR 400, 40H, Bolted connections).