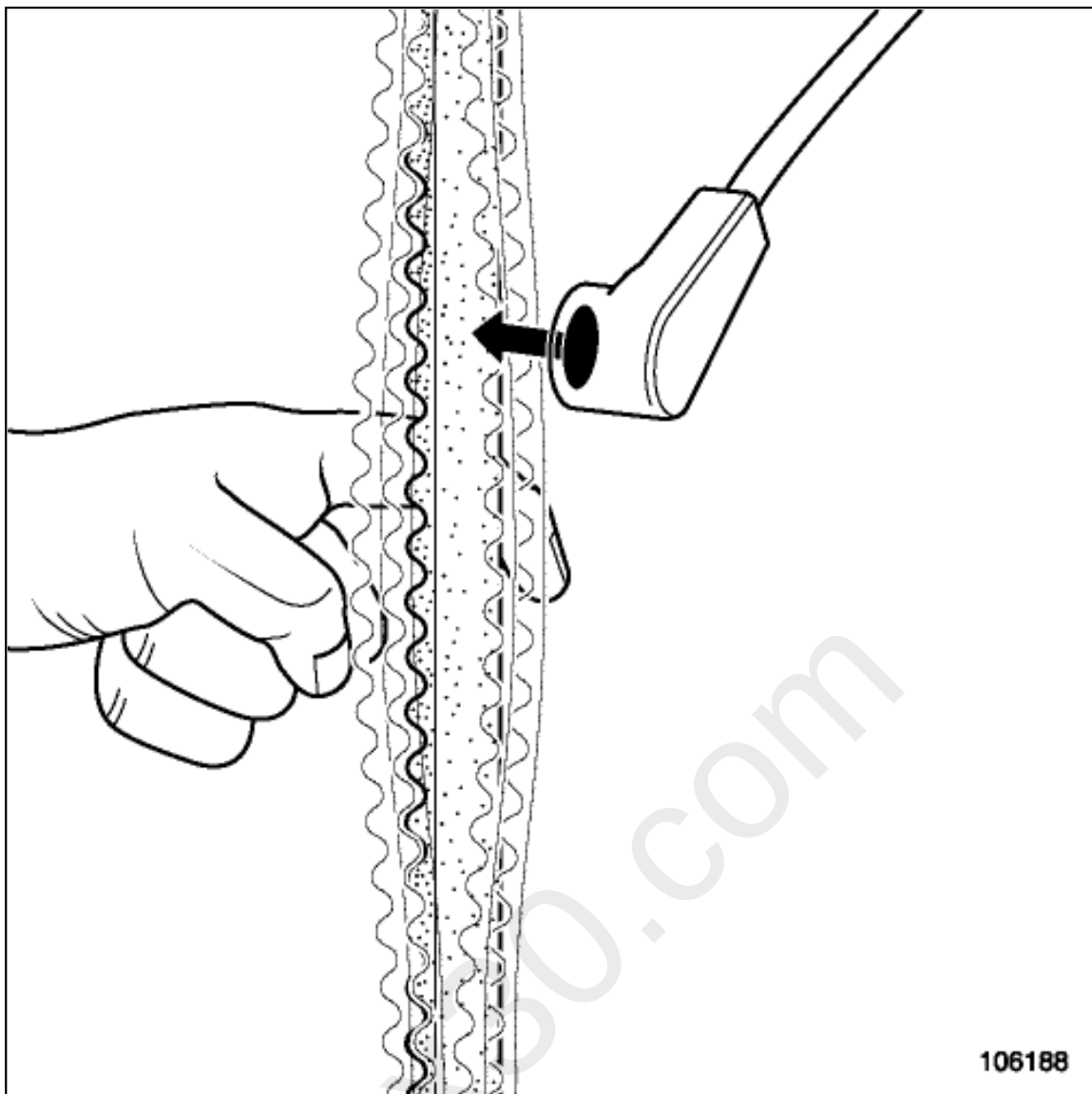




Make the measurement after setting the belt vibrating with a finger.



Repair-00x02x01x05-01x79-1-5-1.xml



BODY SIDEREAR LINING: REPLACEMENT

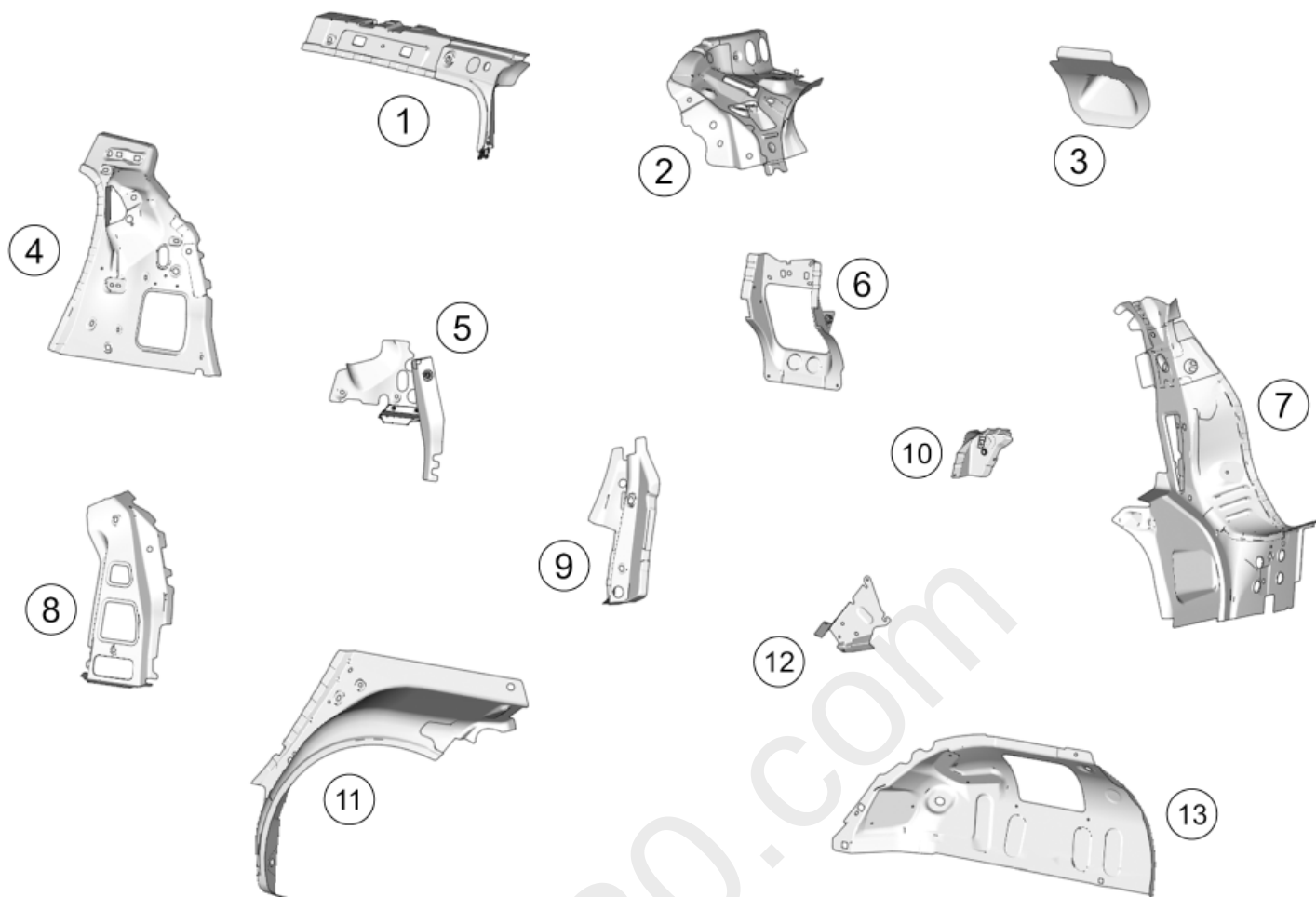


Note, one or more warnings are present in this procedure



1. COMPOSITION OF THE SPARE PART

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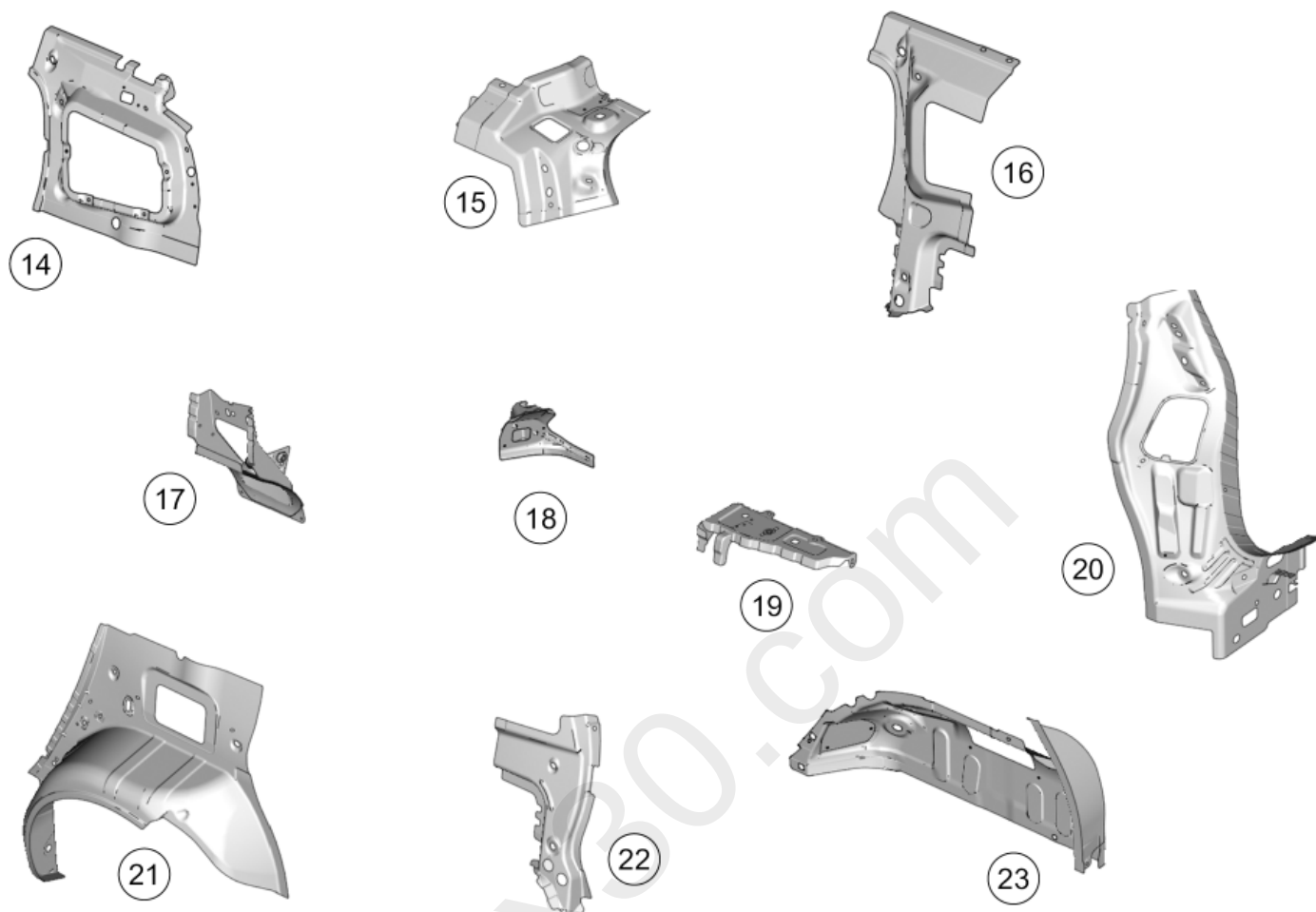


157922

No.	Description	Type	Thickness (mm)
(1)	Rear side roof rail reinforcement	Mild steel	1
(2)	Quarter panel upper section rear reinforcement	Mild steel	1.5
(3)	Shock absorber cup mounting	Mild steel	2
(4)	Left-hand quarter panel lining	Mild steel	0.8
(5)	Left-hand rear quarter panel lining reinforcement	Mild steel	2
(6)	Shock absorber connecting bracket	HLE	2
(7)	Quarter panel lower reinforcement	Mild steel	0.85
(8)	Left-hand quarter panel reinforcement	Mild steel	1.2
(9)	Front left-hand quarter panel lining reinforcement	Mild steel	1.2
(10)	Left-hand seatback mounting	Mild steel	1.5
(11)	Rear left-hand outer wheel arch	Mild steel	0.6

(12)	Left-hand seatback mounting reinforcement	Mild steel	2
(13)	Rear left -hand inner wheel arch	Mild steel	0.75

K98(K98)



157923

No.	Description	Type	Thickness (mm)
(14)	Left-hand quarter panel lining	Mild steel	0.6
(15)	Quarter panel upper section rear reinforcement	Mild steel	1.2
(16)	Left-hand quarter panel lining reinforcement	Mild steel	1.2
(17)	Shock absorber connecting bracket	HLE	1.2
(18)	Rear left-hand outer wheel arch reinforcement	Mild steel	1
(19)	Rear side parcel shelf	Mild steel	1.5
(20)	Quarter panel lower reinforcement	Mild steel	1
(21)	Rear left-hand outer wheel arch	Mild steel	0.6
(22)	Left-hand quarter panel reinforcement	Mild steel	1.2
(23)	Rear left-hand inner wheel arch	Mild steel	0.75

2. IN THE EVENT OF REPLACEMENT



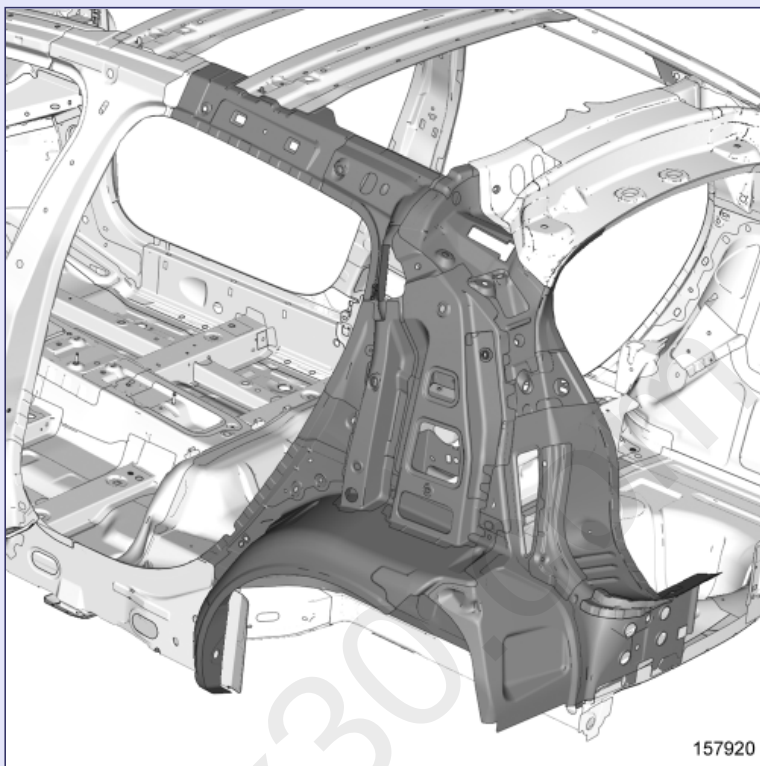
There is only one way of replacing this part:

complete replacement.

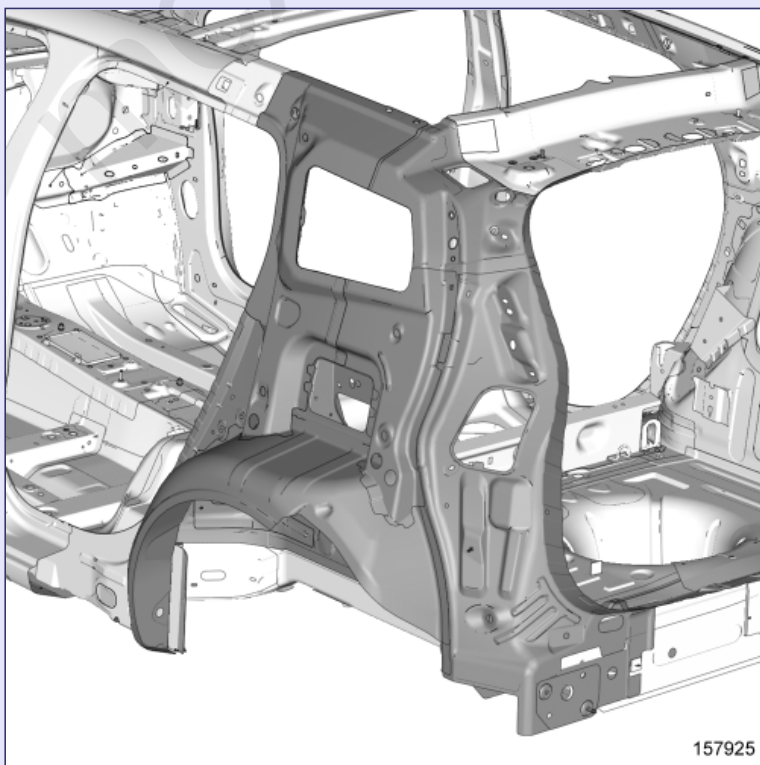
1- COMPLETE REPLACEMENT

1)PART IN POSITION

B98(B98)



K98(K98)

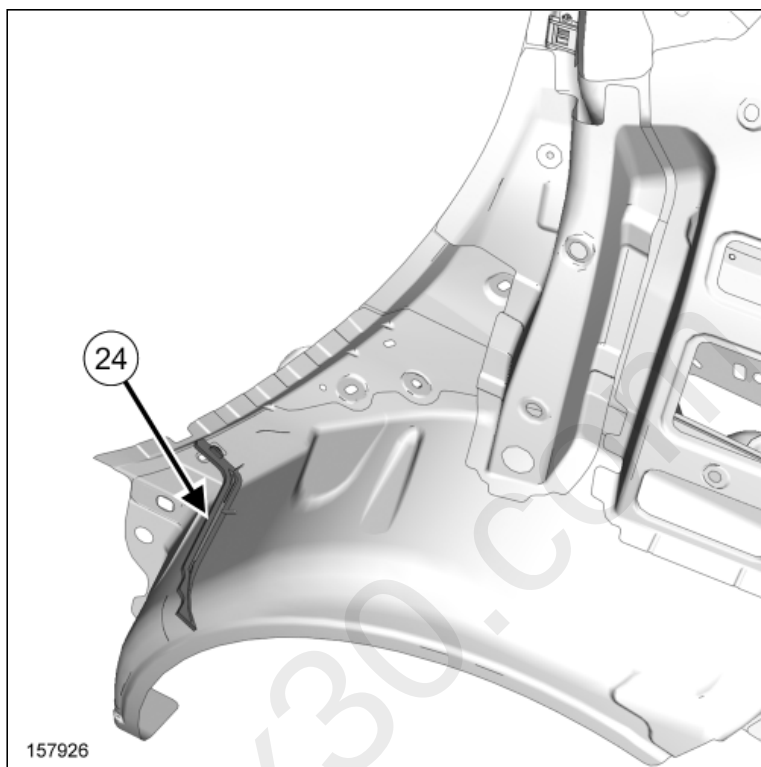


**CAUTION**

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](#).



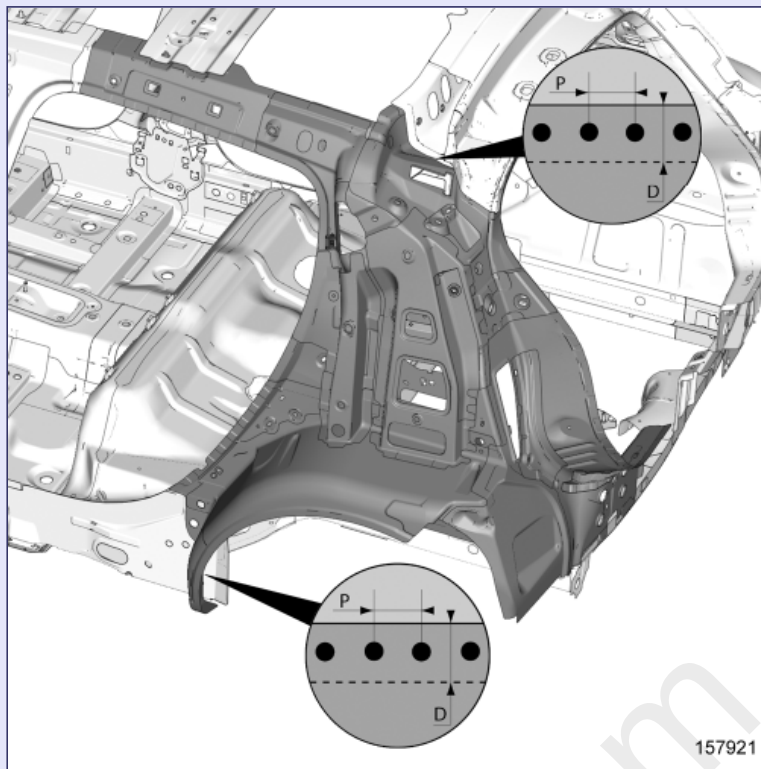
Replace the hollow section inserts (24).



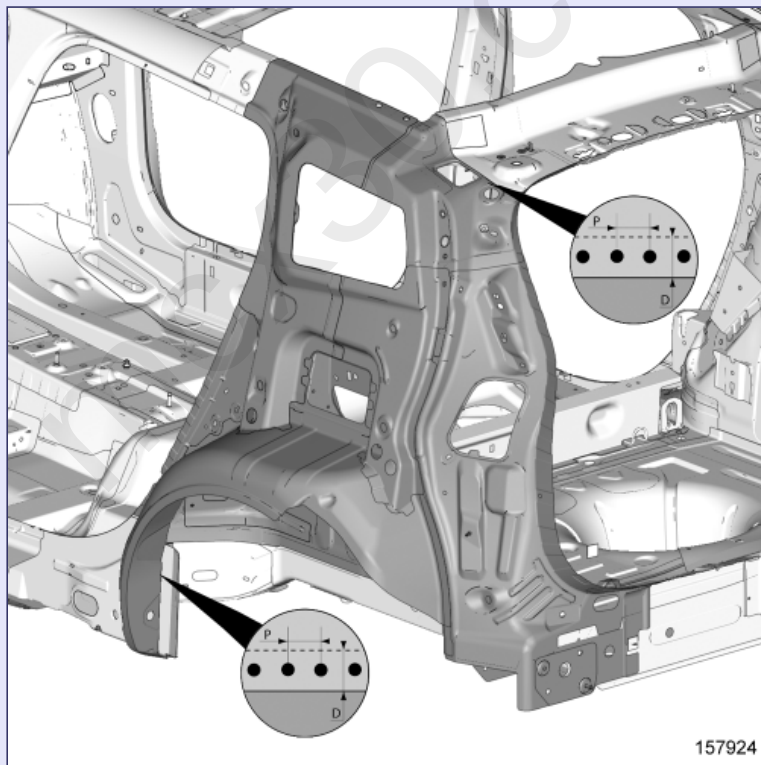
Remove:

the roof [Roof: Replacement](#).

B98(B98)



K98(K98)



Make a superimposed connection at [Partial replacement connections by overlapping: Description](#) (MR 400, 40E, Partial replacement connections).



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)).