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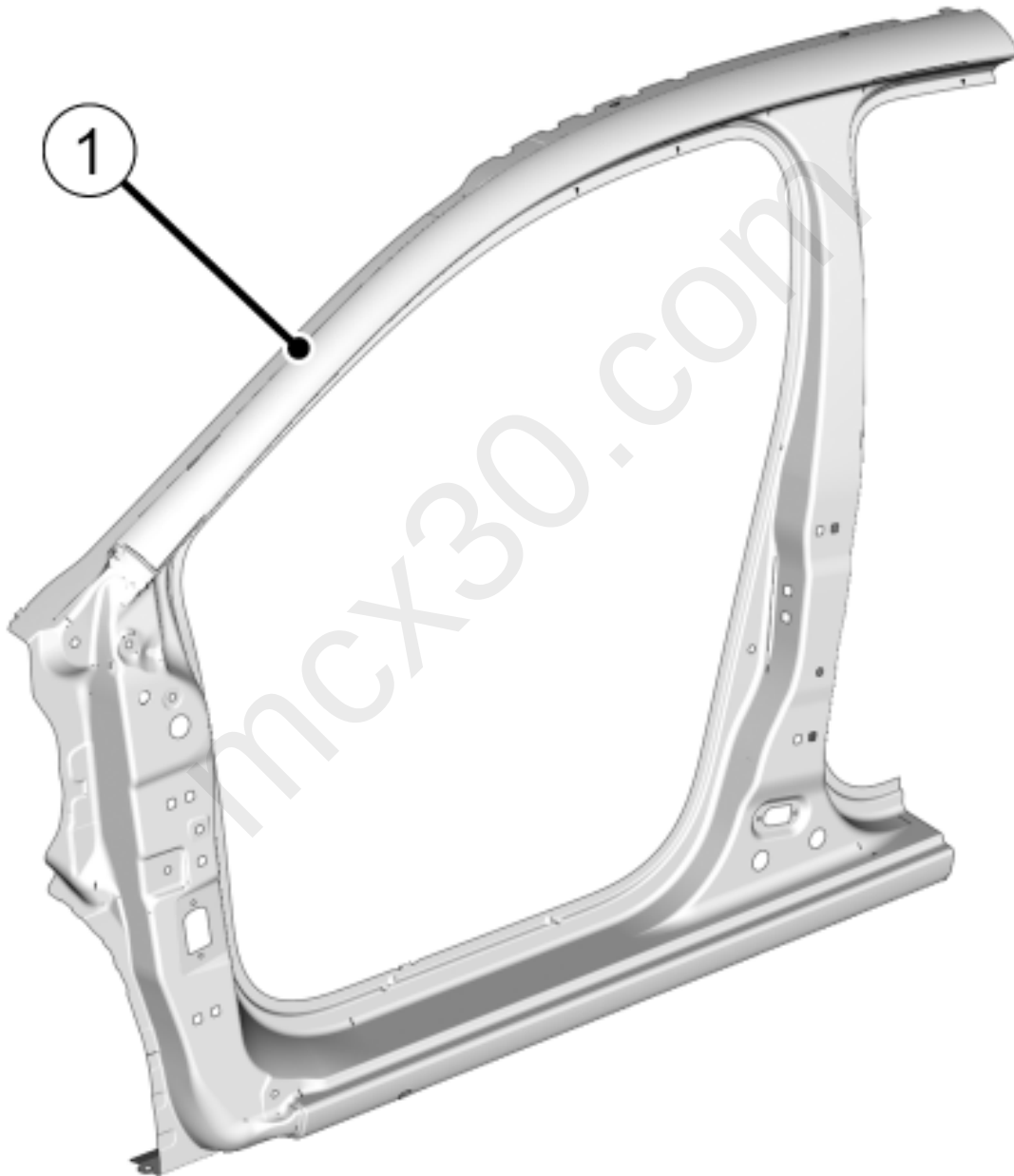
BODY SIDE, FRONT SECTION: REPLACEMENT



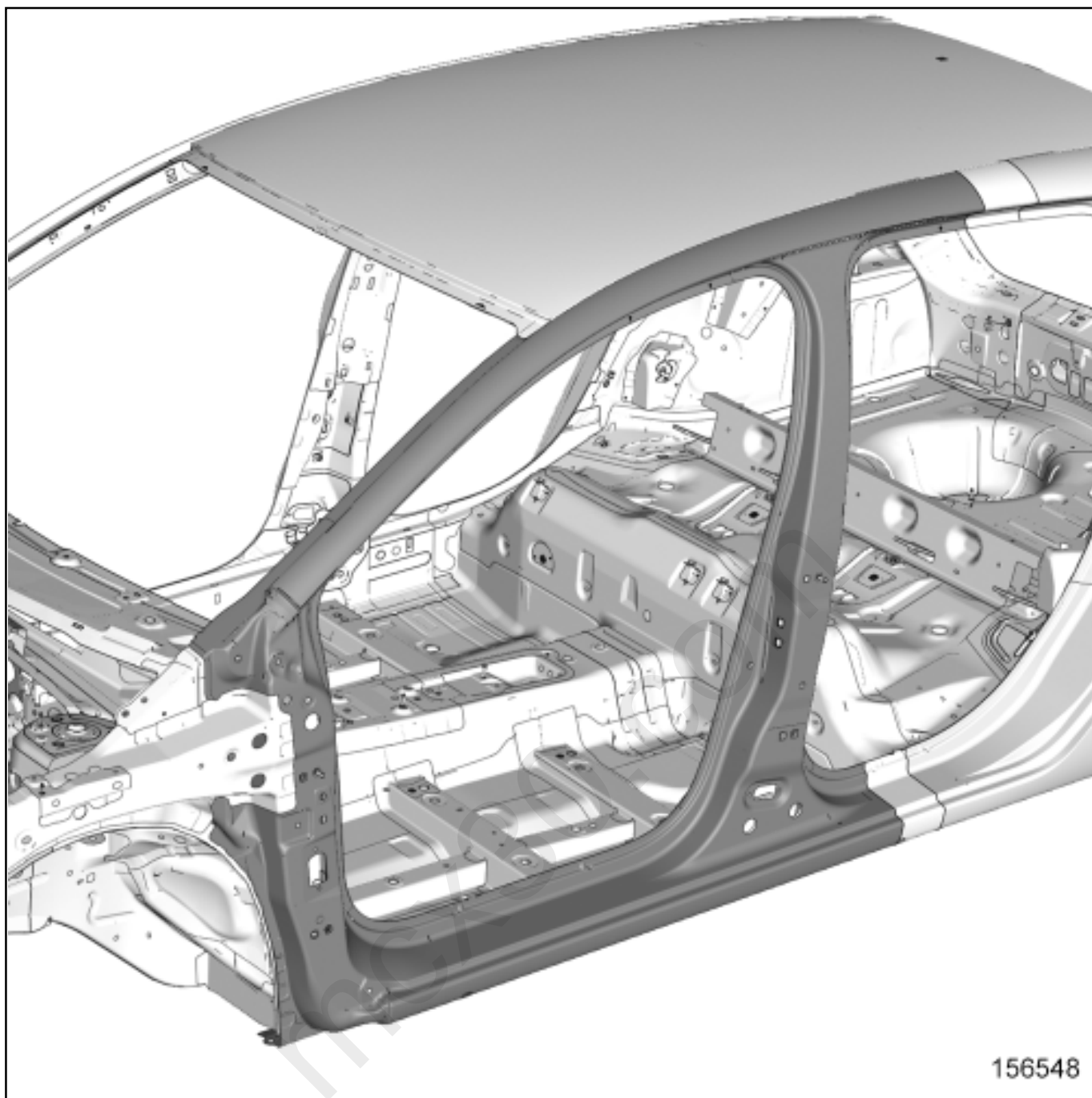
Note, one or more warnings are present in this procedure



1. COMPOSITION OF THE SPARE PART



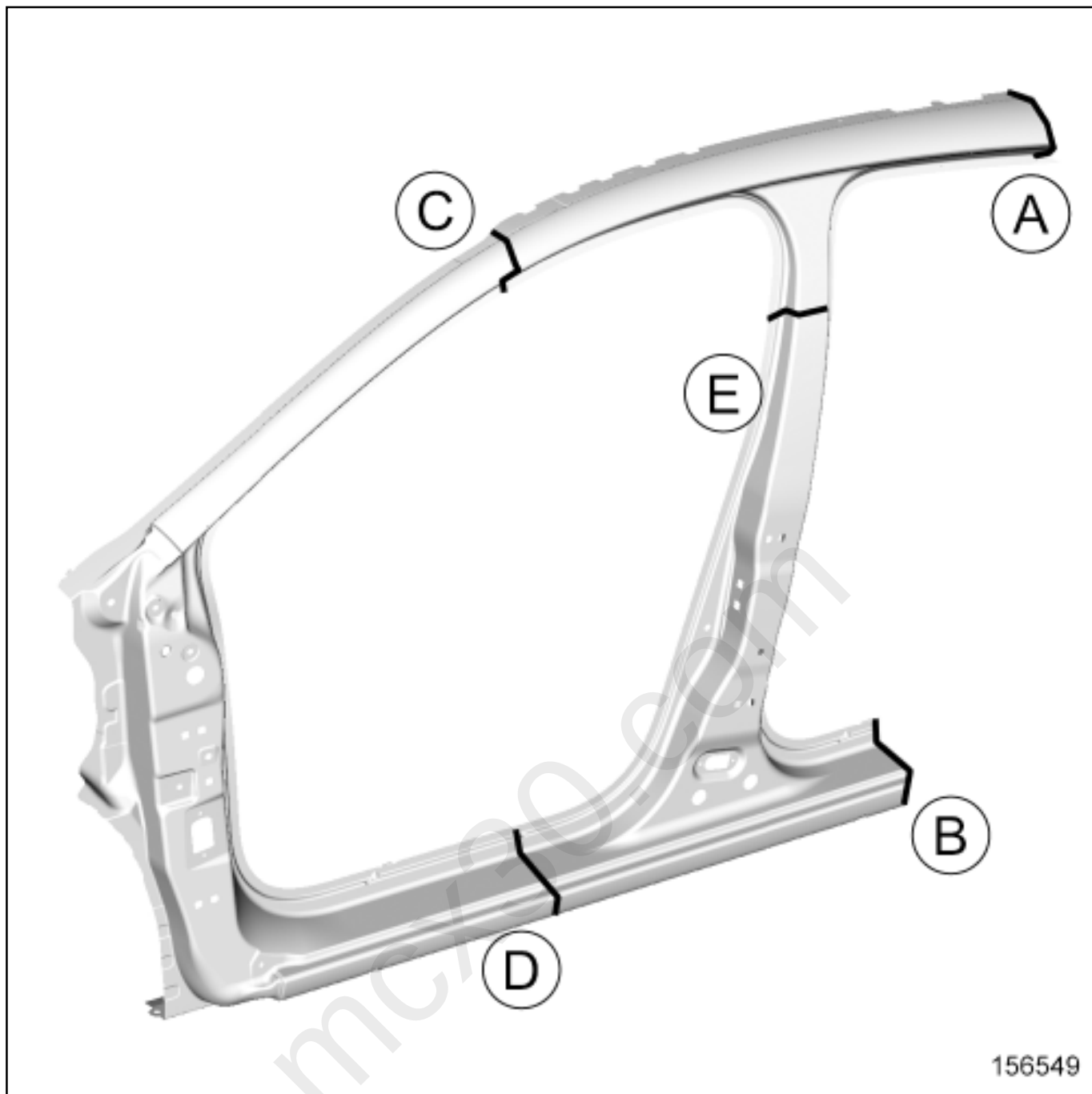
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No.	Description	Type	Thickness (mm)
(1)	Body side	Mild steel	0.7

2. IN THE EVENT OF REPLACEMENT

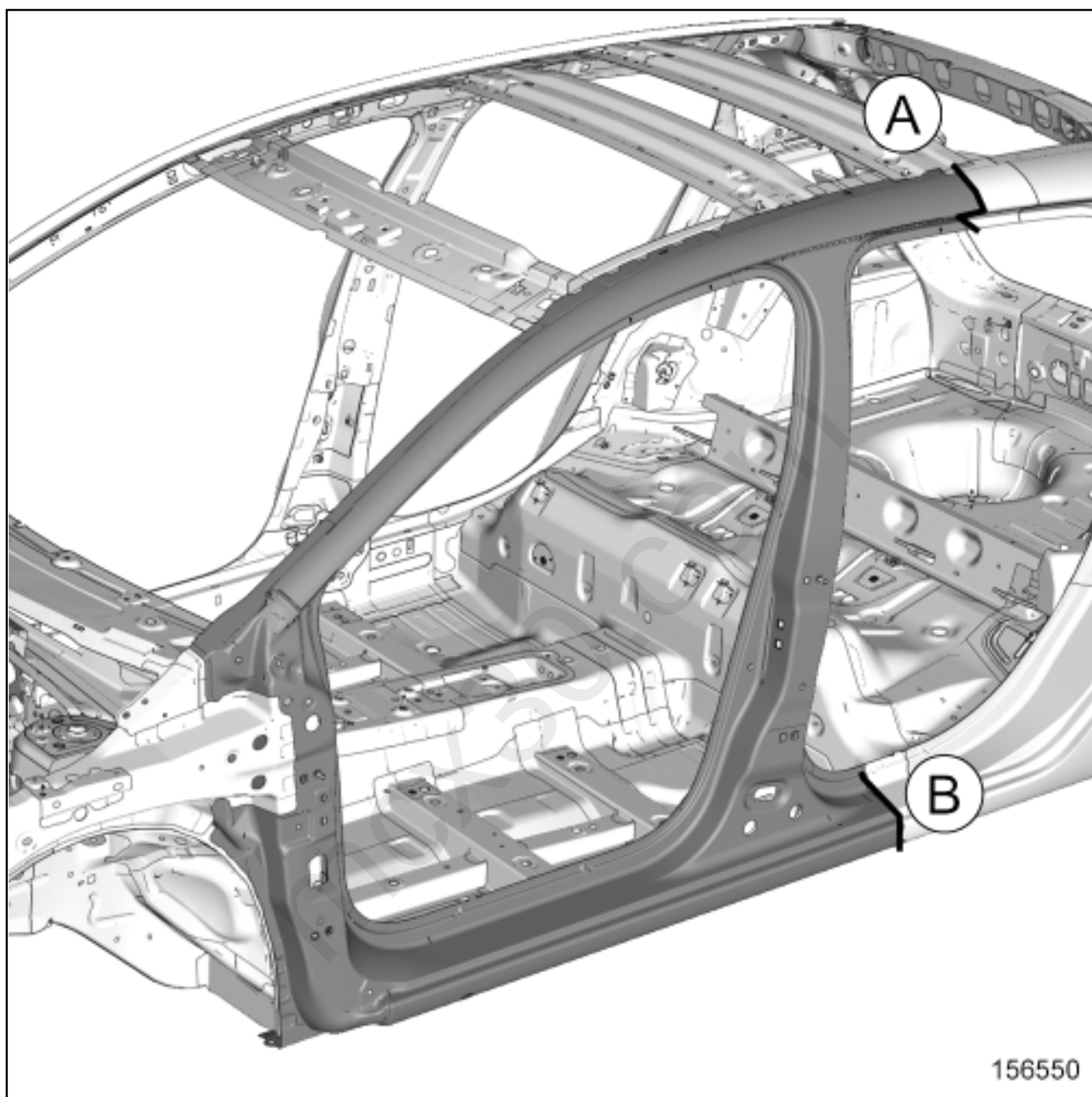


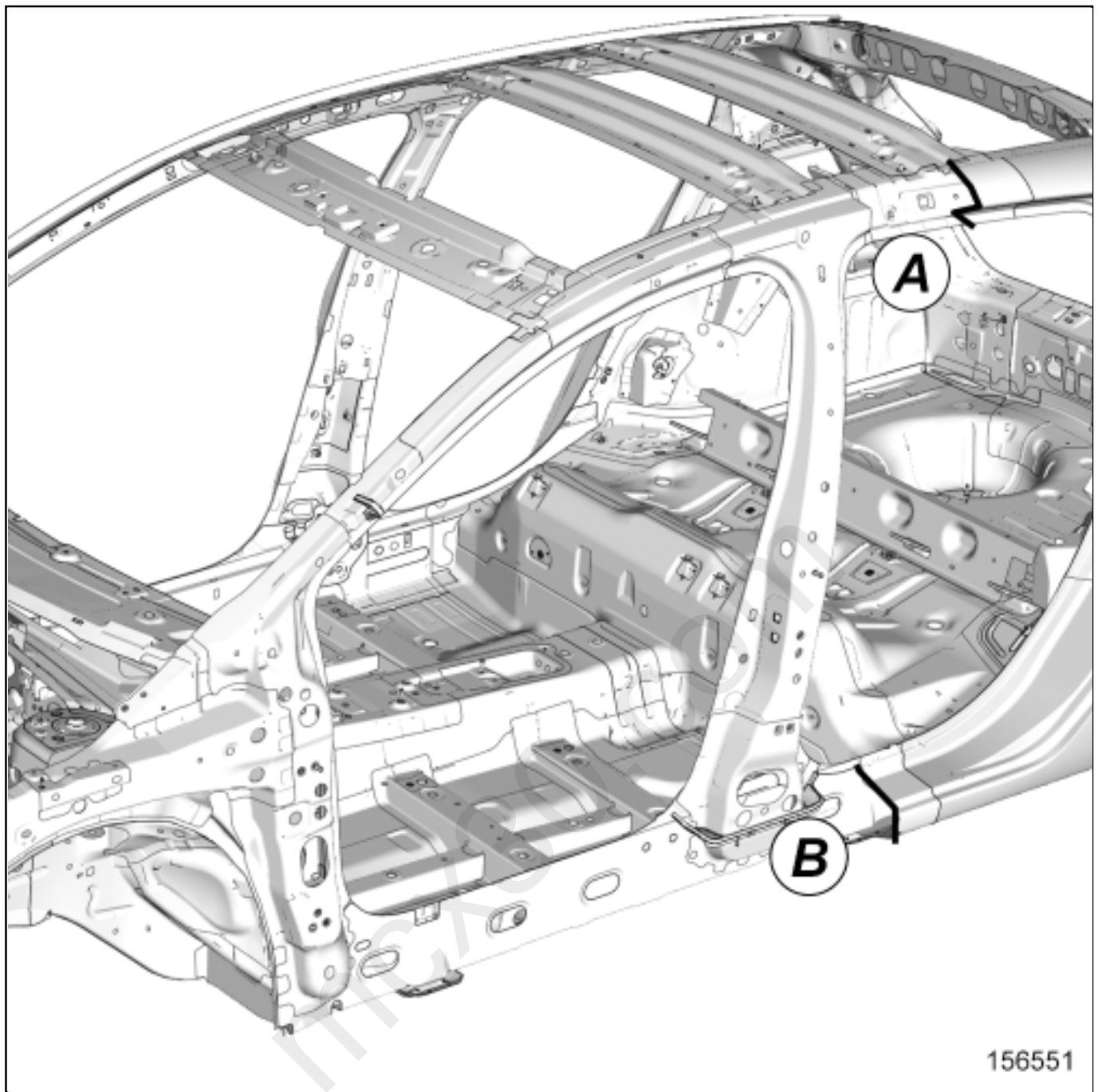
The options for replacing this part are as follows:

-
- complete replacement A-B,
- partial replacement A-C-E,
- partial replacement B-D-E,
- partial replacement C-D.

1- COMPLETE REPLACEMENT A-B

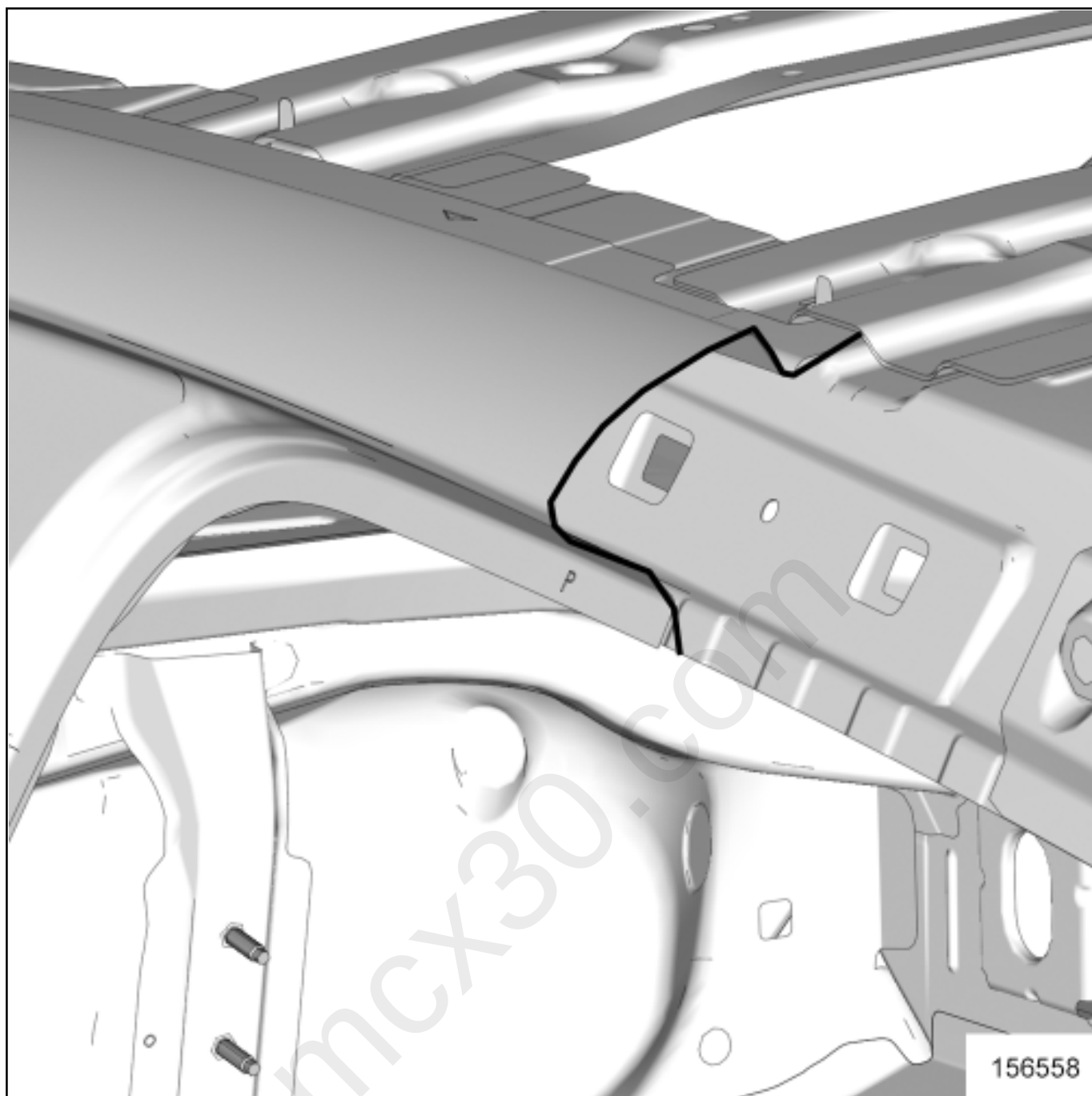
1)PART IN POSITION



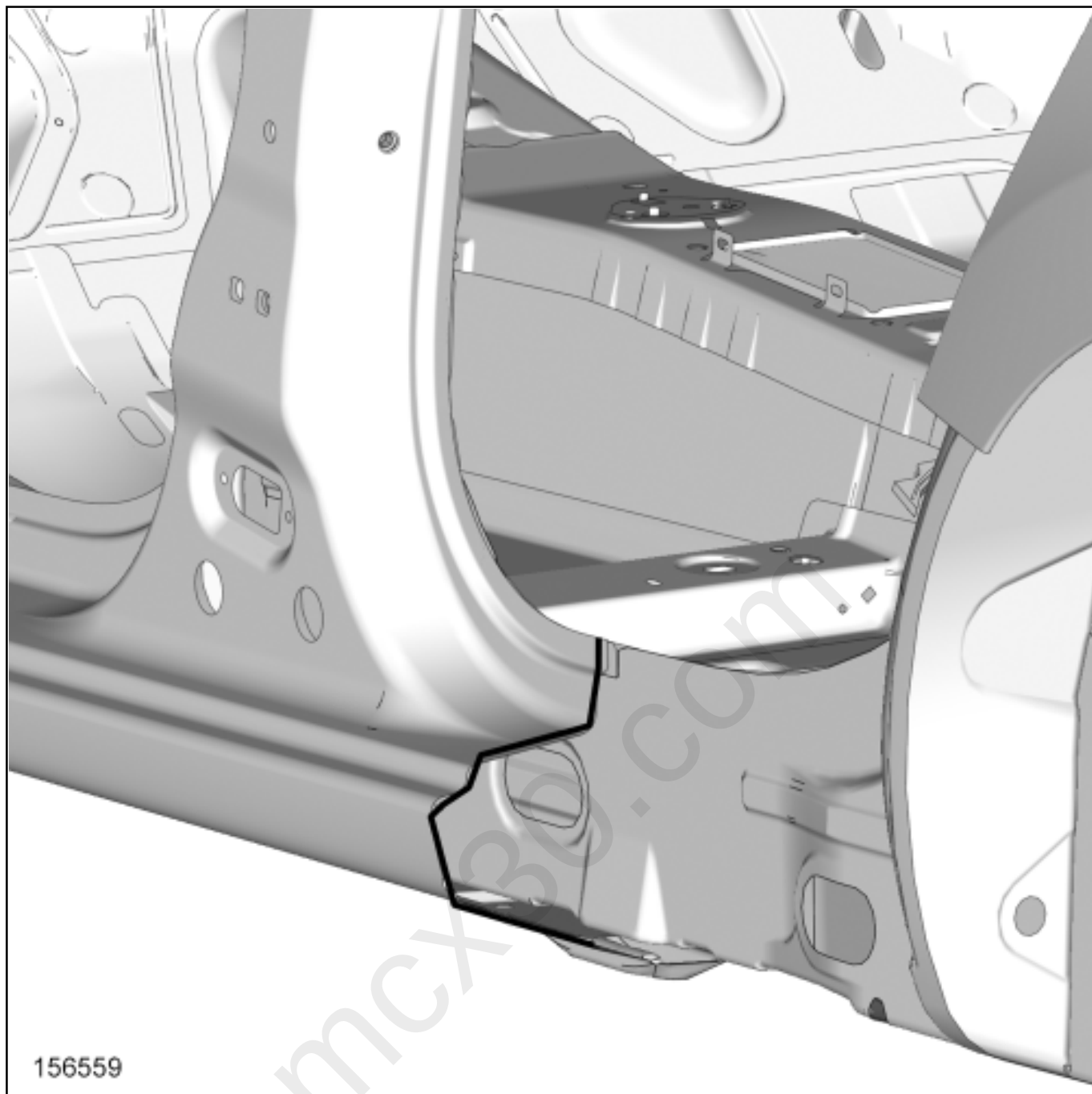


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DETAILED VIEW A



DETAILED VIEW B



2) POSITION OF ELECTRIC EARTHS

CAUTION

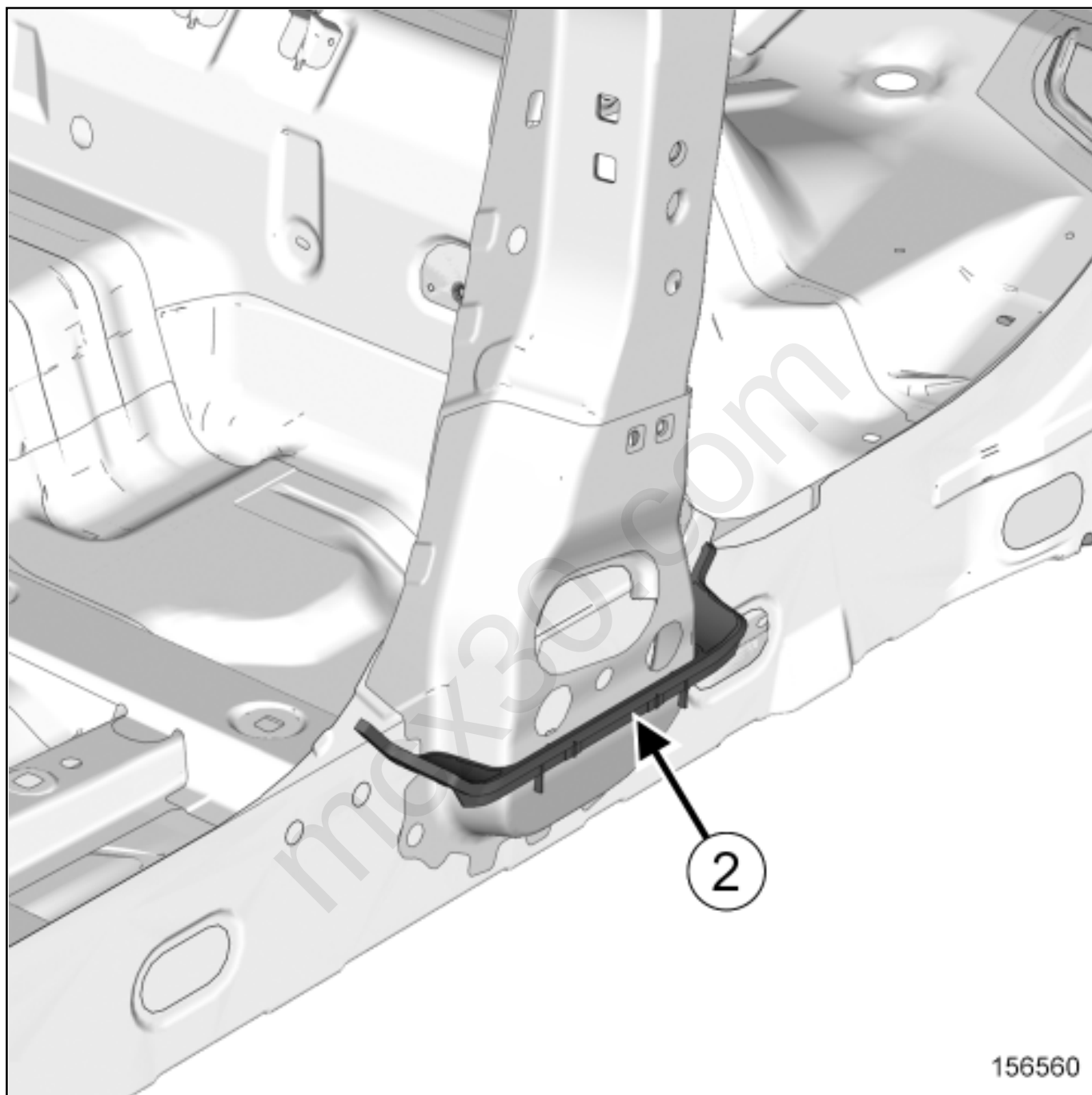


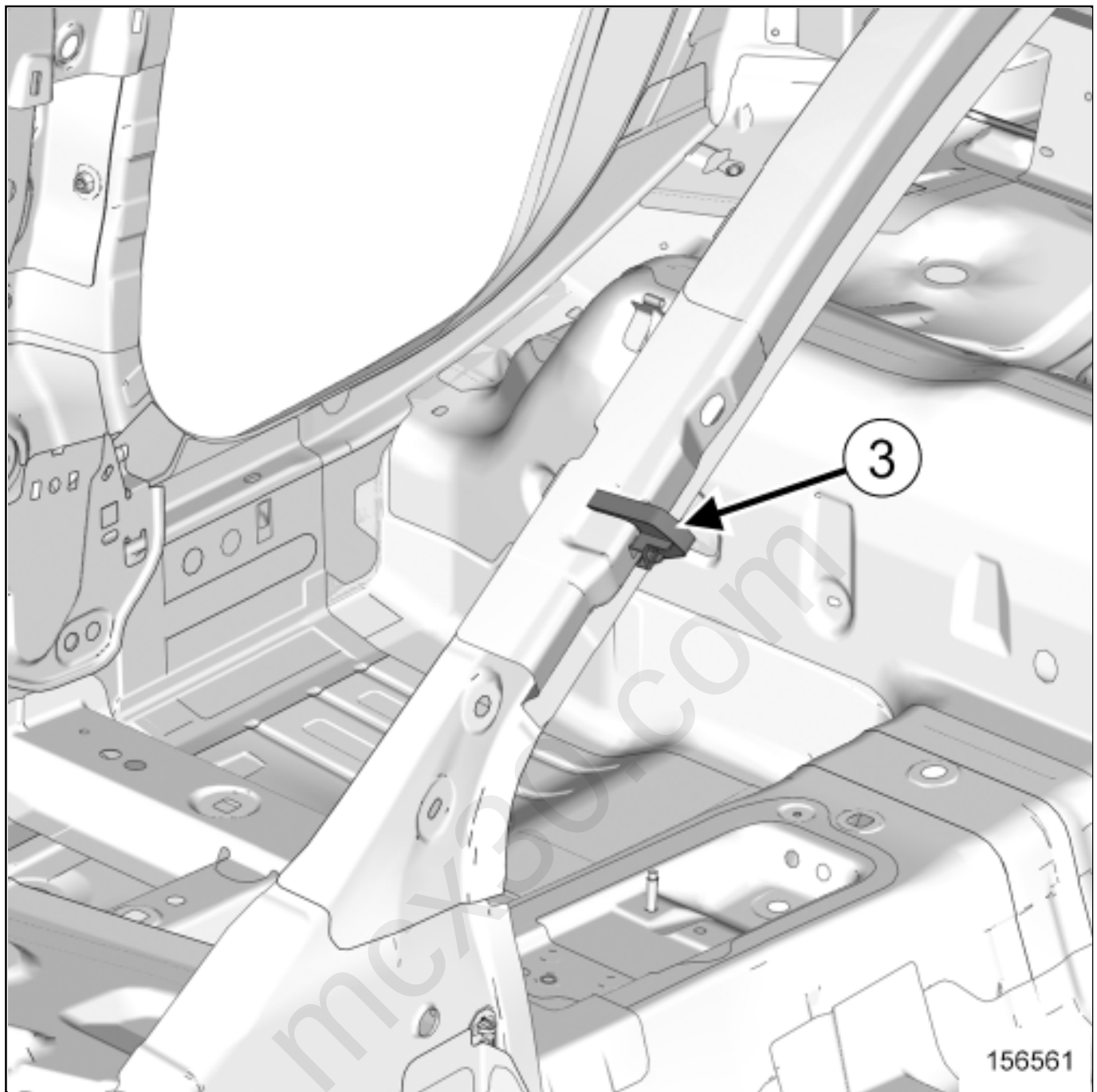
To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

Position the earth of the welding machine as close as possible to the weld area. [Earth screw connection: Description](#) (MR 400, 40H, Bolted connections).

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

3)PARTS ALWAYS TO BE REPLACED





Replace:

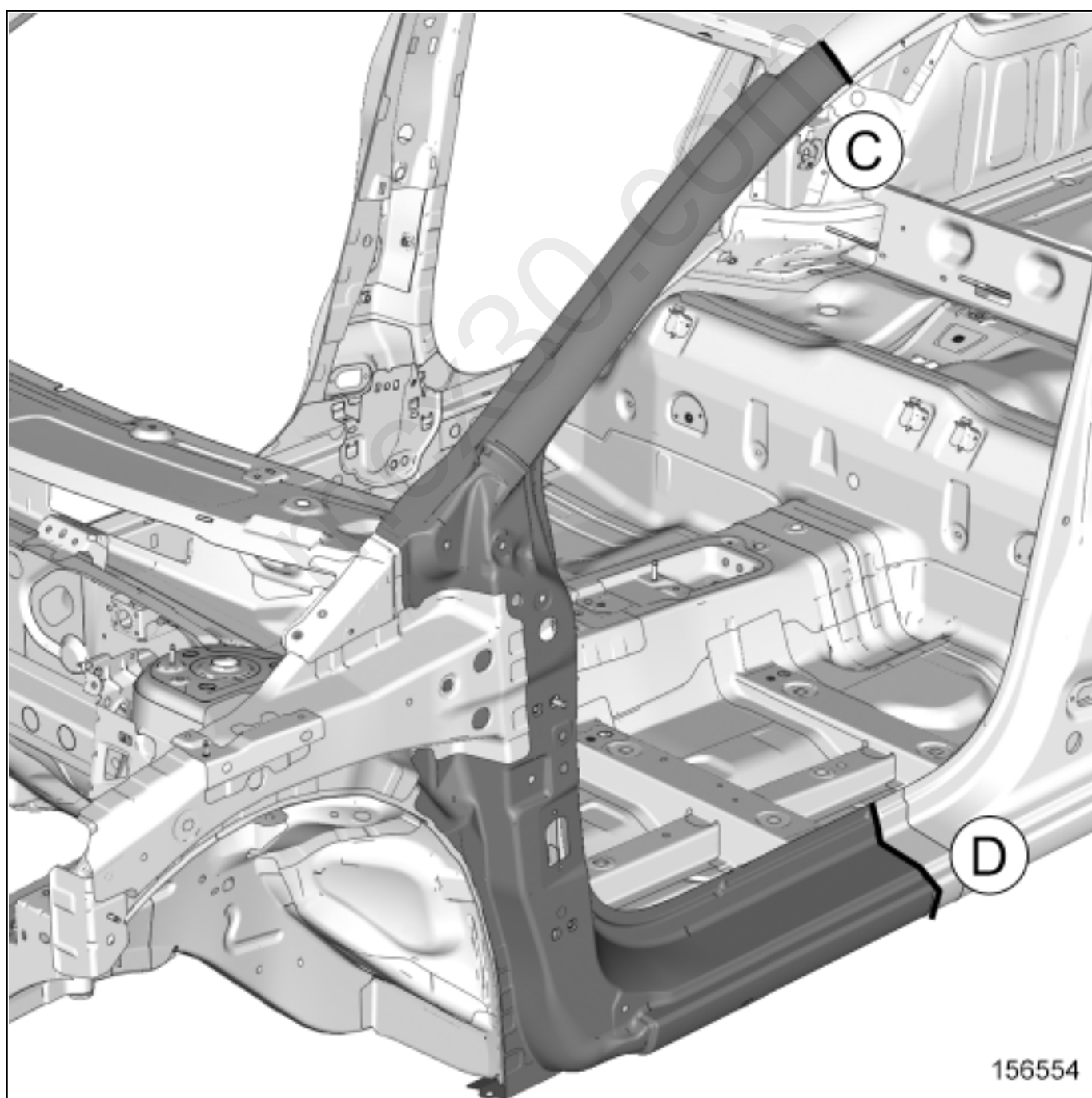
the inserts for the hollow parts of the B-pillar(2), and A-pillar(3).

4)IRREMOVABLE BODYWORK COMPONENTS - STRUCTURAL COMPONENTS TO BE REMOVED IN ORDER TO CARRY OUT THE REPLACEMENT OPERATION

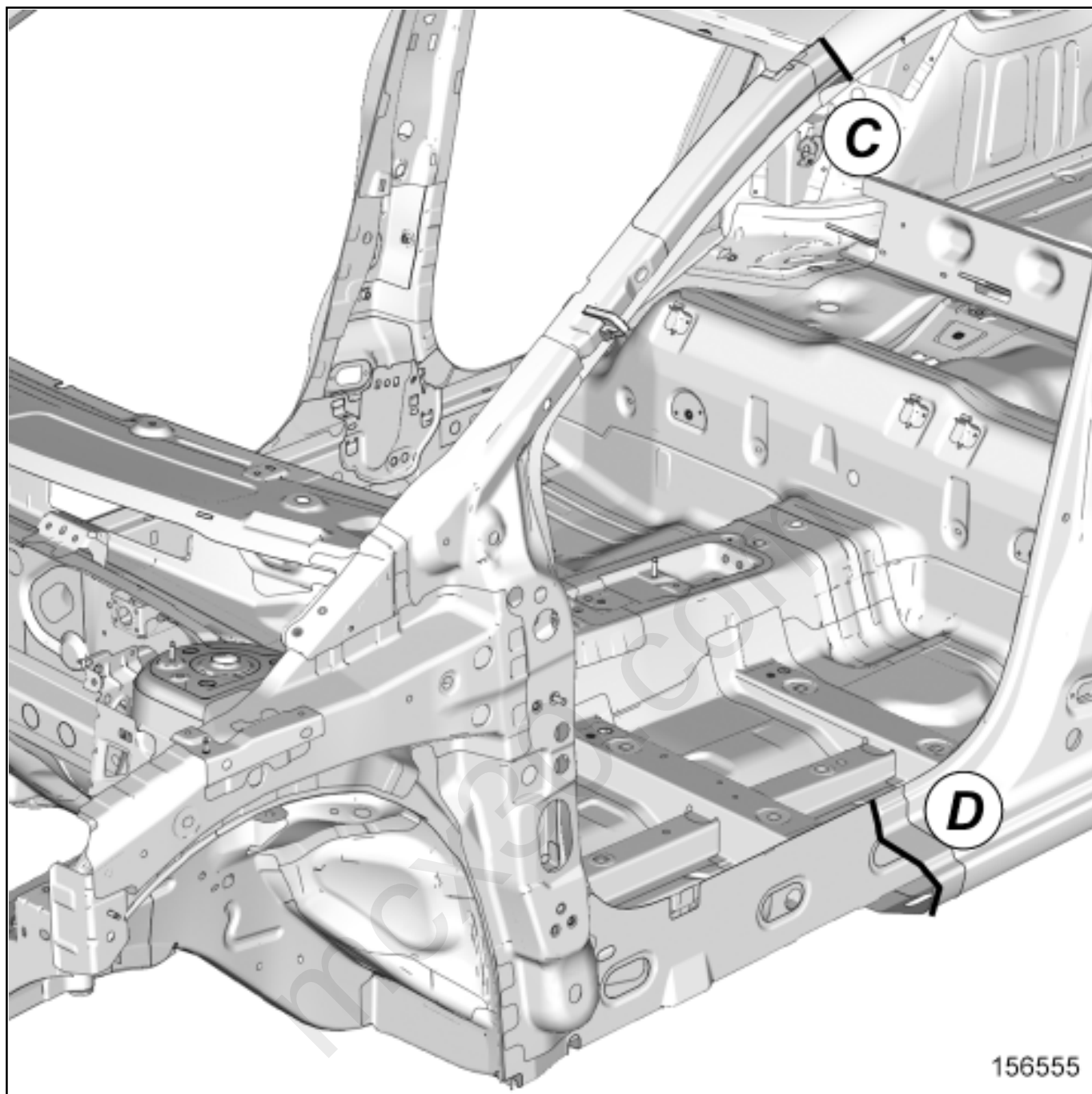
Remove the roof [Roof: Replacement](#).

**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)).

2- PARTIAL REPLACEMENT C-D**1)PART IN POSITION**

156554



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 [Earth screw connection: Description](#) (MR 400, 40H, Bolted connections).

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

3)PARTS ALWAYS TO BE REPLACED



Replace:



the inserts for the hollow parts of the A-pillar.

4)SPECIAL NOTES ON MATING

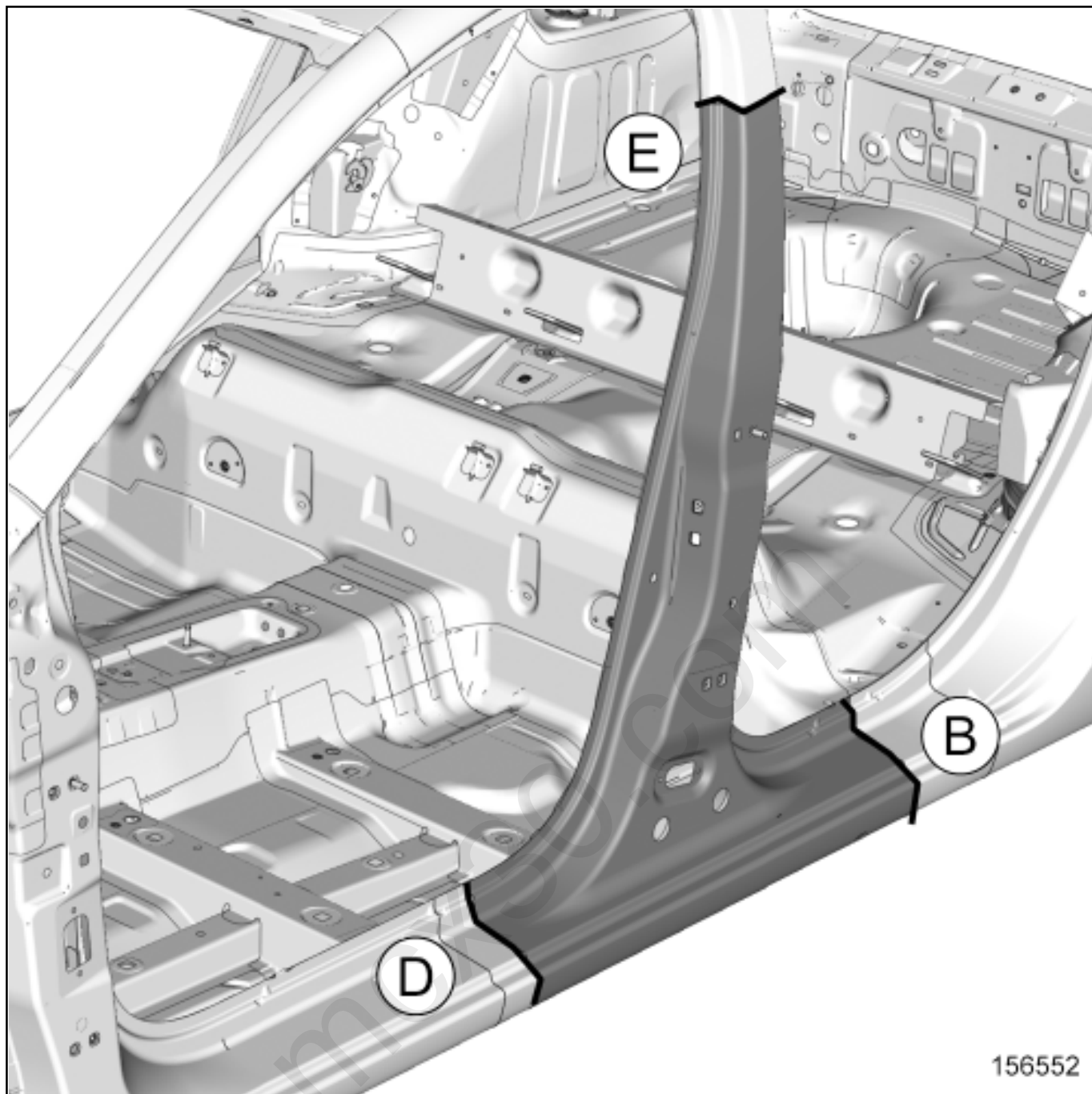
CAUTION



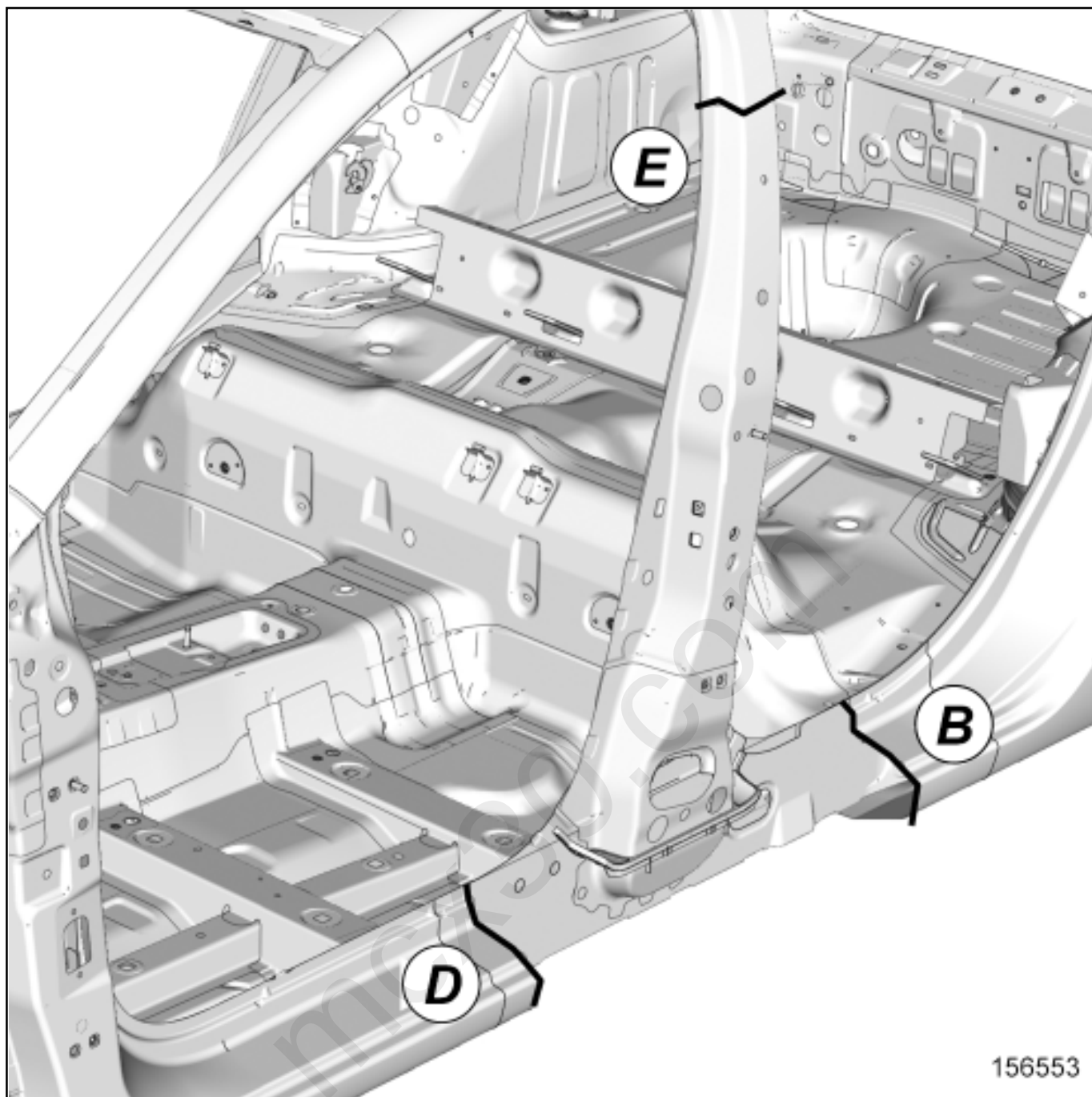
If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld [Connections by arc welding under shielding gas: Description](#) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

3- PARTIAL REPLACEMENT B-D-E

1)PART IN POSITION



156552



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 [Earth screw connection: Description](#) (MR 400, 40H, Bolted connections).

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

3)PARTS ALWAYS TO BE REPLACED



Replace:



the inserts for the hollow parts of the B-pillar(2) .

4)SPECIAL NOTES ON MATING

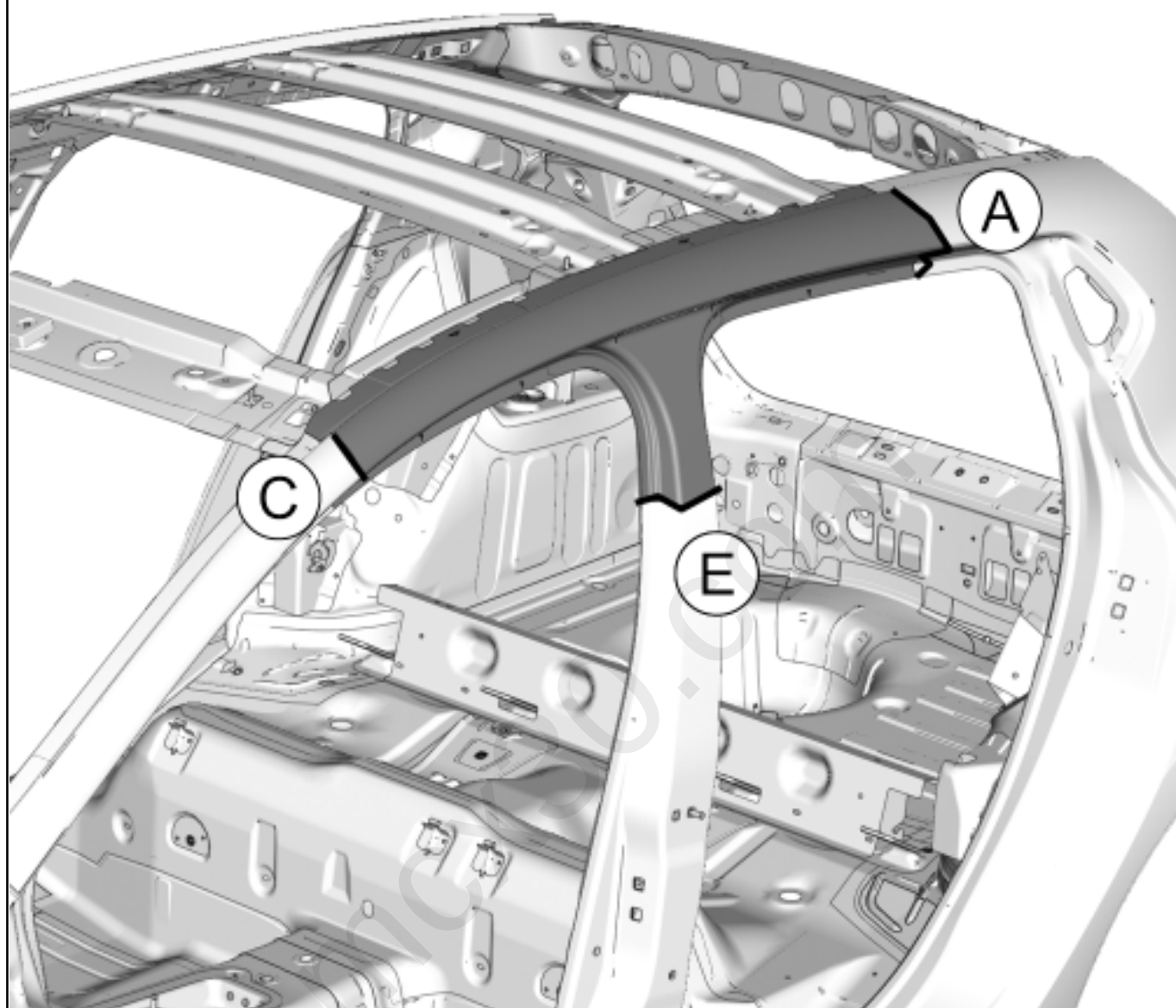
CAUTION

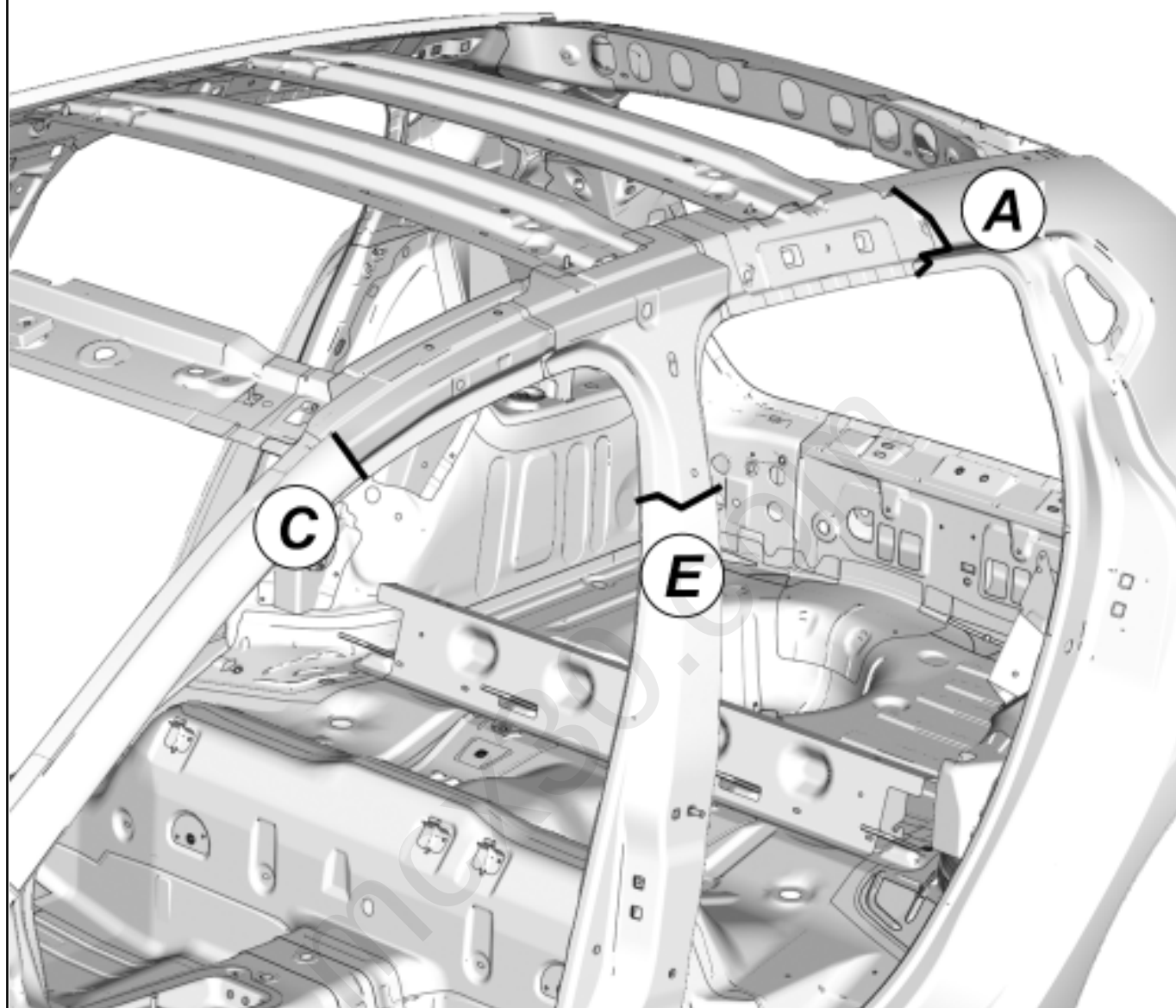


If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld [Connections by arc welding under shielding gas: Description](#) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

4- PARTIAL REPLACEMENT A-C-E

1)PART IN POSITION





2) POSITION OF ELECTRIC EARTHS