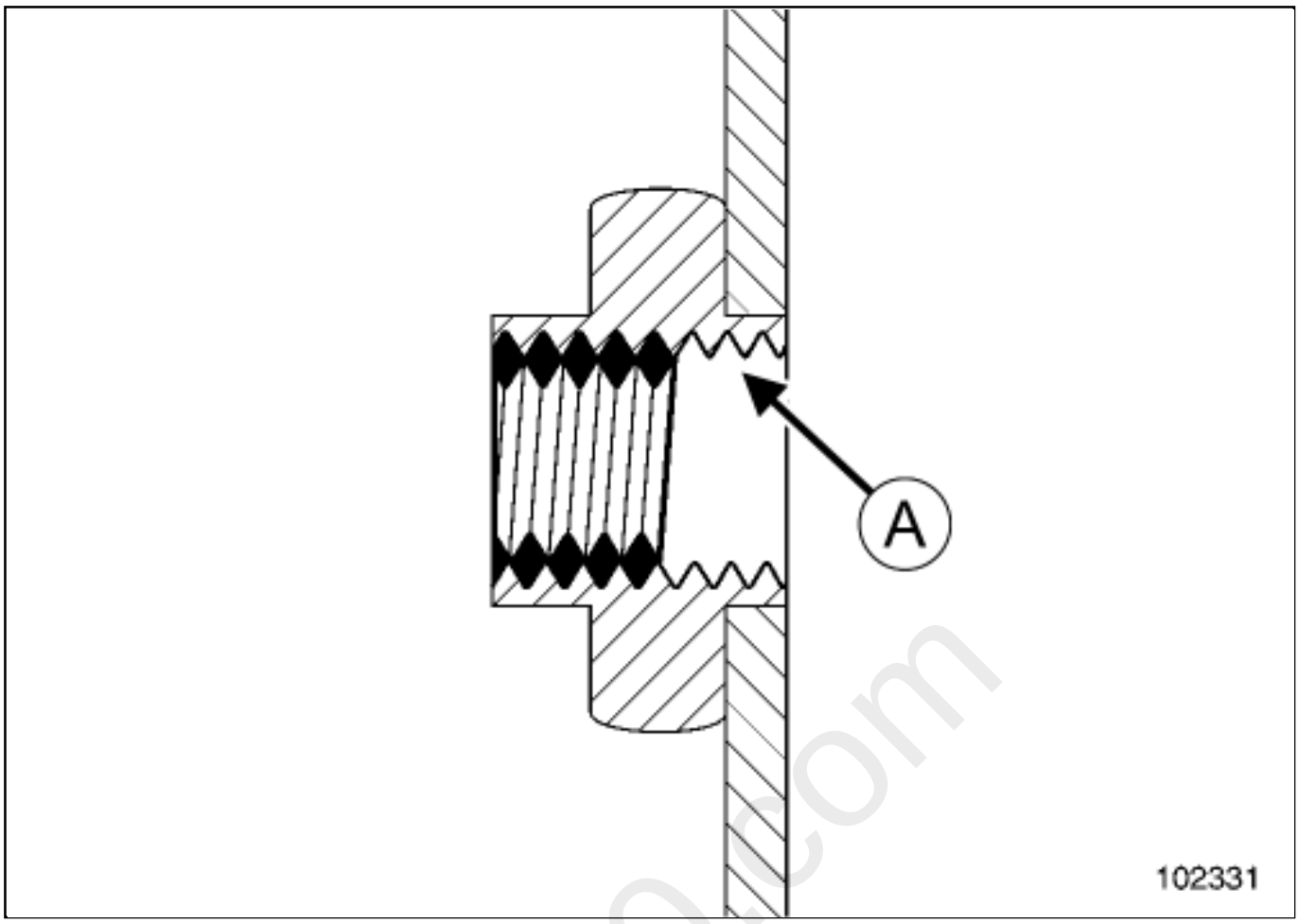


After fitting the helical thread insert, apply anti-corrosion protection to the section(A) of the insert which has been re-tapped. To do this, inject some protective wax for hollow sections in the captive nut before refitting the bolt.

(see 04F, Bodywork products and mountings, Anti-corrosion protection products after assembly: Use)

BOLTED CONNECTION WITH WELDED STUD

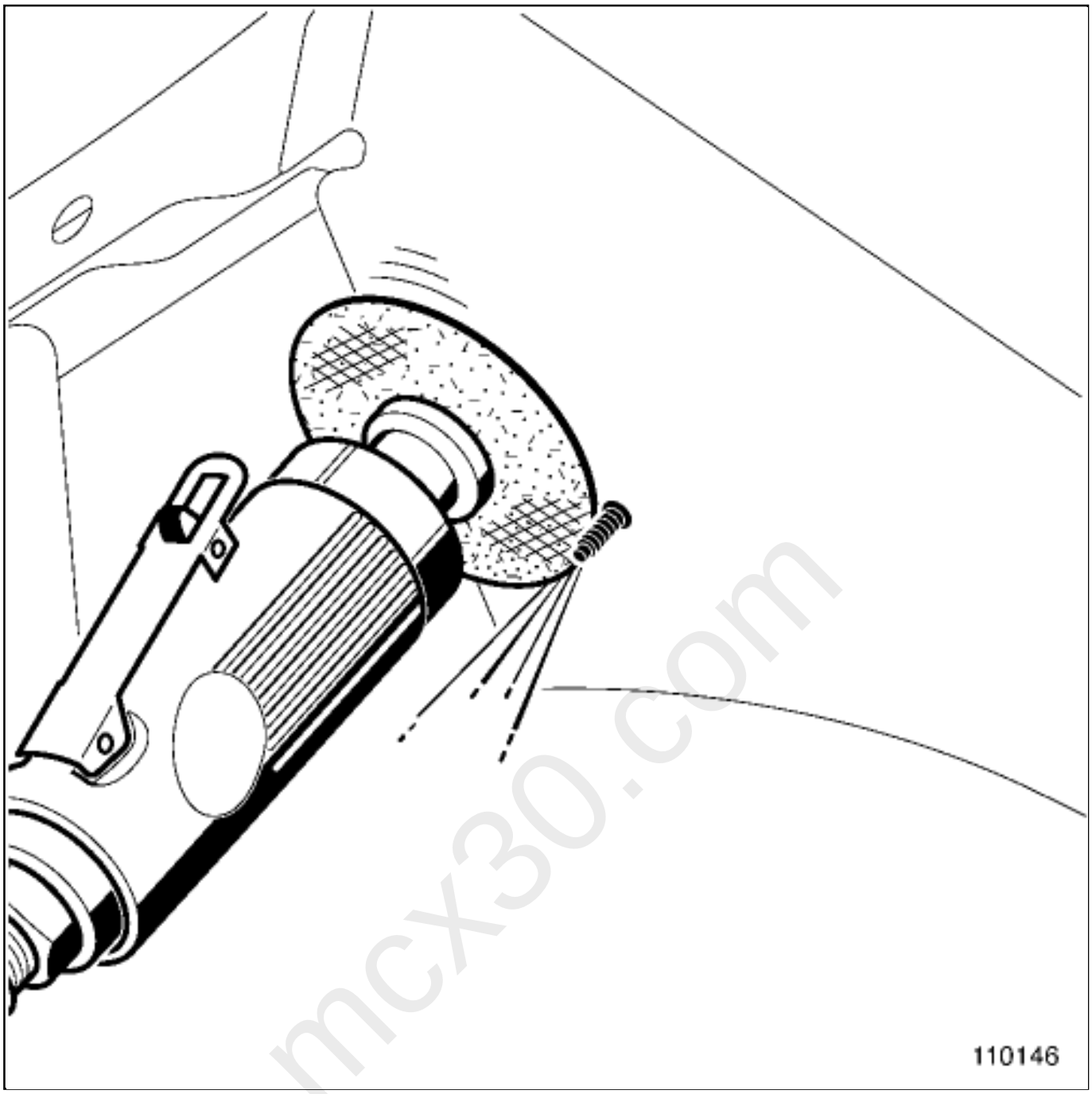
Repairing a welded stud is done according three possibilities:

- by identical to the origin welding of a welded stud, if the operator is equipped with a resistance welding device with a specific nozzle by using studs supplied with the material,
- by fitting of a crimped stud**(see 40H, Bolted connections, Screw connection with crimped mounting: Description)** .

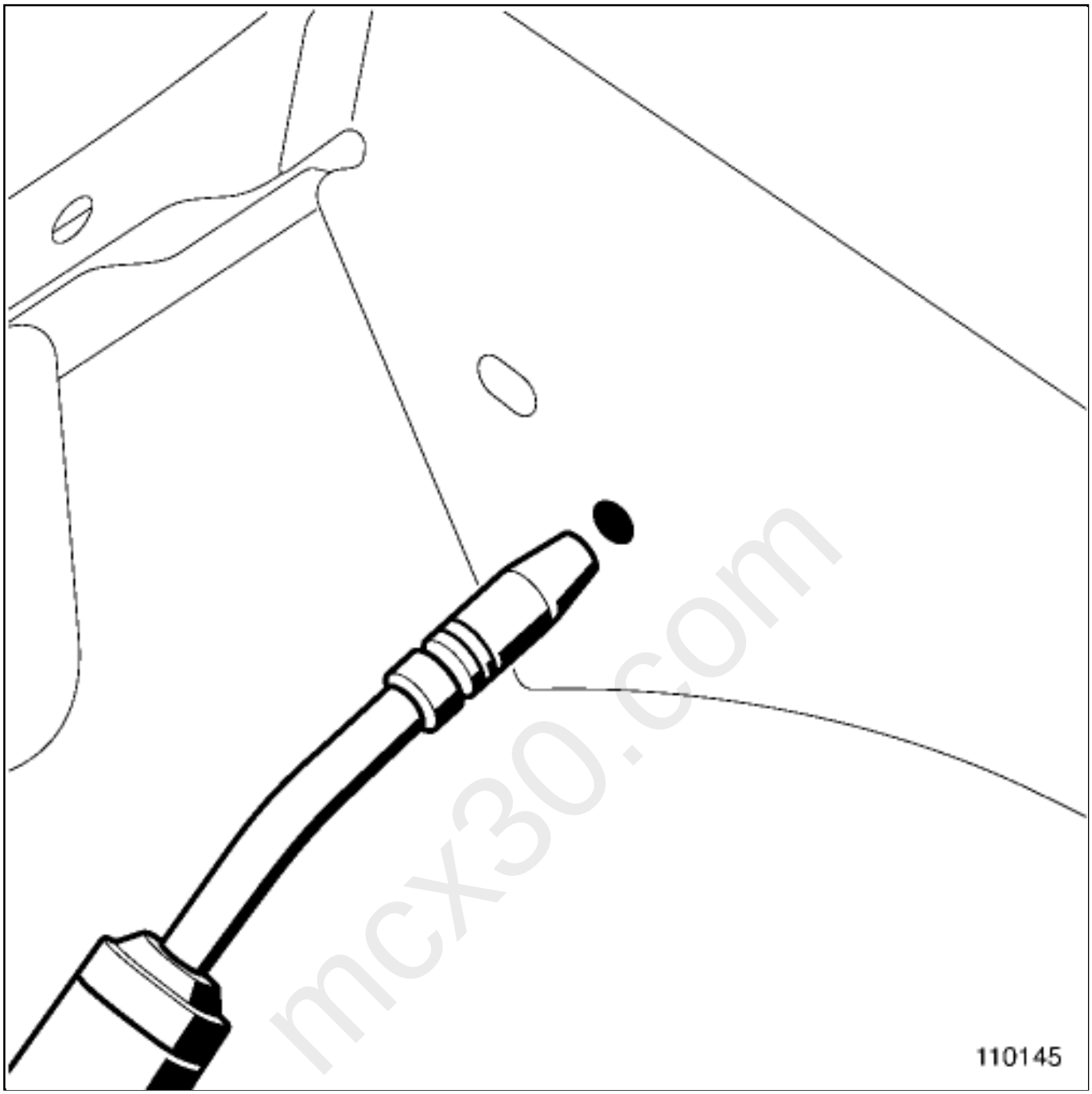
Note:

If it is about a D5 stud at "lying thread", it is possible to fit a riveted stud.

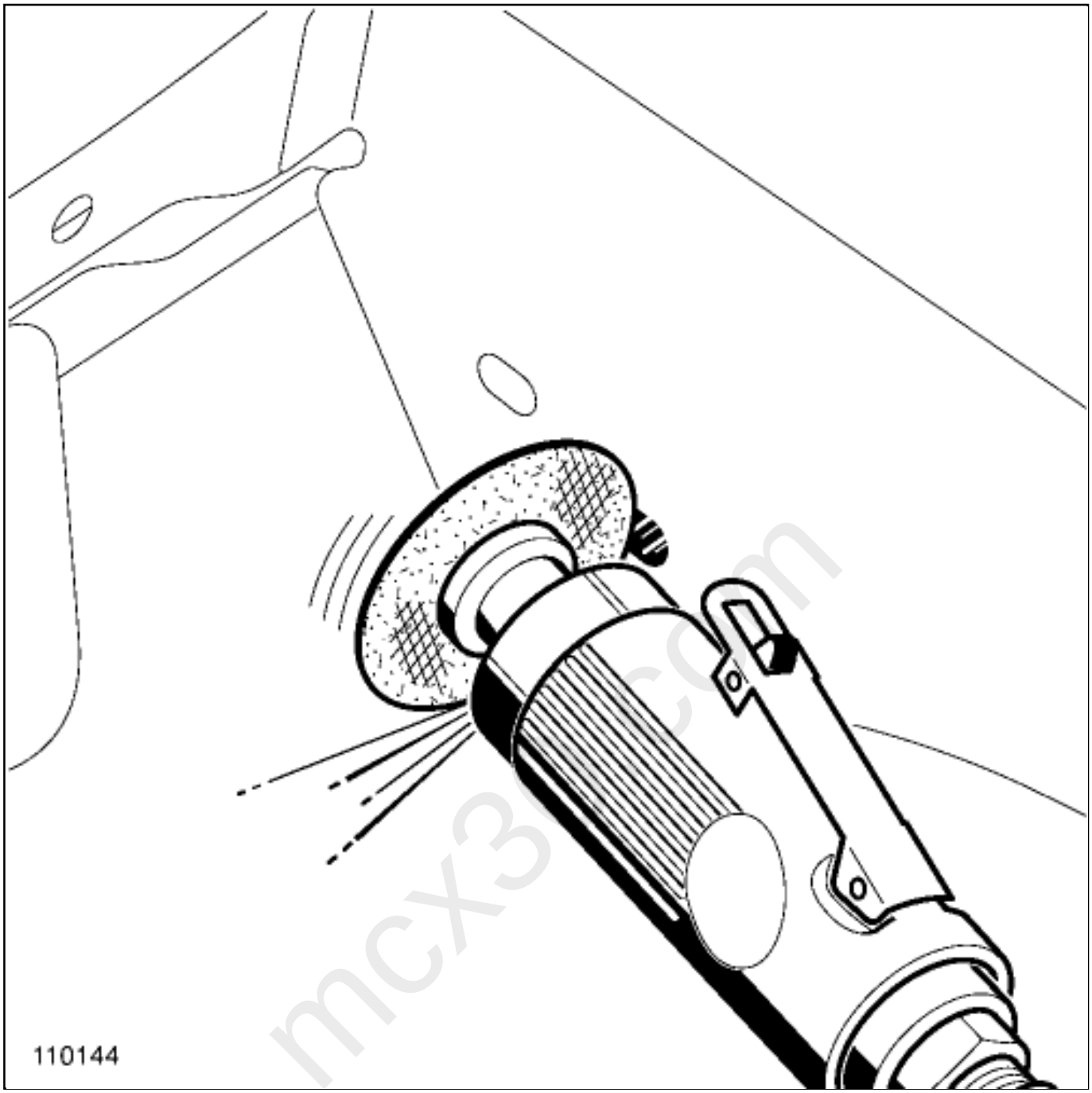
1. DISASSEMBLY



Cut the stud close to the panel mounting(see 05B, Equipment and Tools, Tools for cutting a structural component: Use) .



If the panel tears when the stud ruptures, use an electric welding process with shielding gas(see **Products and equipment for welded assembly: Use**) .



Level off the residual stud or weld(see 05B, Equipment and Tools, Tool for levelling off weld residue: Use) .

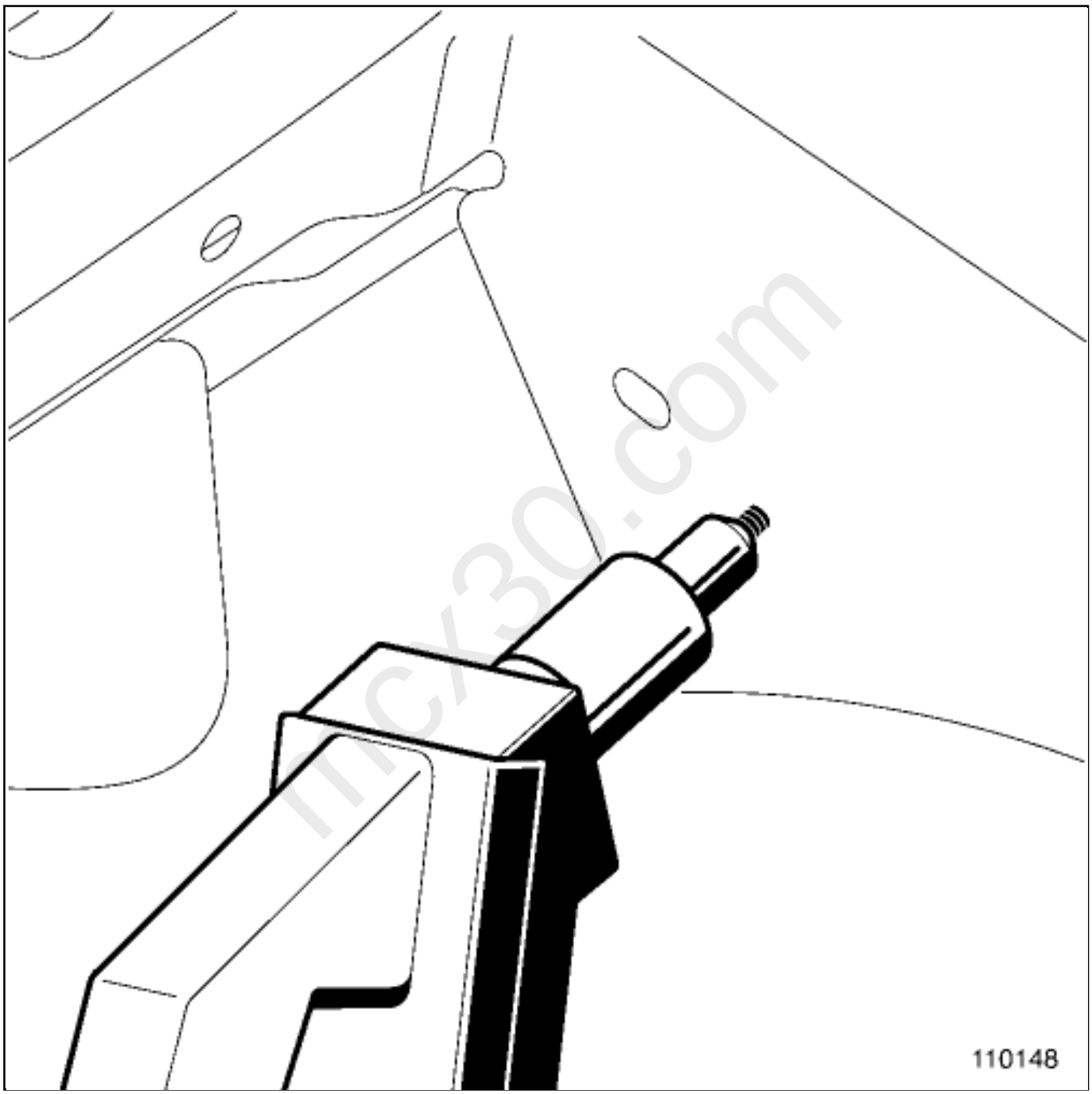
Note:

Do not strike or damage the panel.

2. FITTING A WELDED STUD IDENTICAL TO THE ORIGIN

The following procedure is used:

- before painting the part,
- on a component which is at risk from water infiltration (e.g.: floor).



Weld the stud using a resistance welder equipped with an adapted nozzle, use the studs to be welded given by the supplier of the welding equipment.

3. FITTING A CRIMPED STUD

(see 40H, Bolted connections, Screw connection with crimped mounting: Description) .

4. FITTING A RIVETED STUD

The following procedure is used:

- after painting the part,
- if there is a hollow section.