

Wipe the bonding area using a lint-free cloth [Vehicle: Parts and consumables for the repair](#) (04B, Consumables - Products).

Level the residual beading (leave a thickness of 1 to 2 mm of beading).

Place indexing guides and positioning shims onto the sunroof mechanism.

Carry out a test assembly of the sunroof mechanism on the vehicle.

Note:



If there is an area without residual beading on the sunroof mechanism (e.g.: difficulty in adhering):

- apply the glass cleaner/activator using a pre-soaked wipe along the bonding line,
- wipe with a dry cloth.

Apply the primer (green and red marking) with a single, uniform stroke onto the entire bonding area.

Let it dry for a minimum of 10 minutes.

Apply the cement bead.

Bond the sunroof mechanism immediately.



[Repair-50x04x01x04-02x21-1-1-1.xml](#)



XSL version : 3.02 du 22/07/11

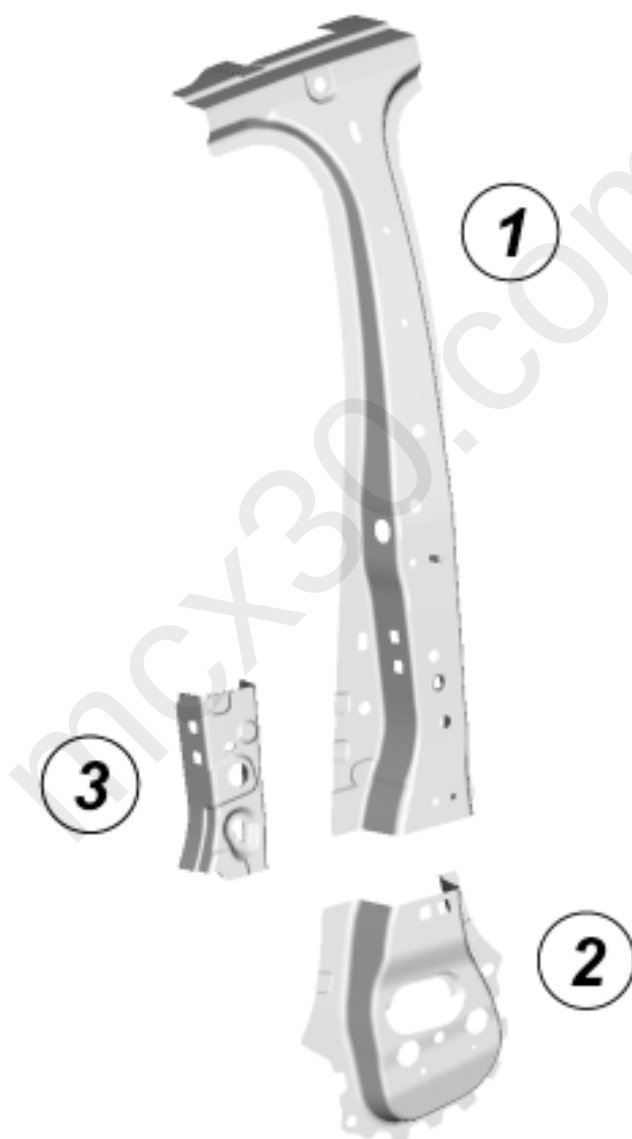
B-PILLAR REINFORCEMENT REPLACEMENT



Note, one or more warnings are present in this procedure



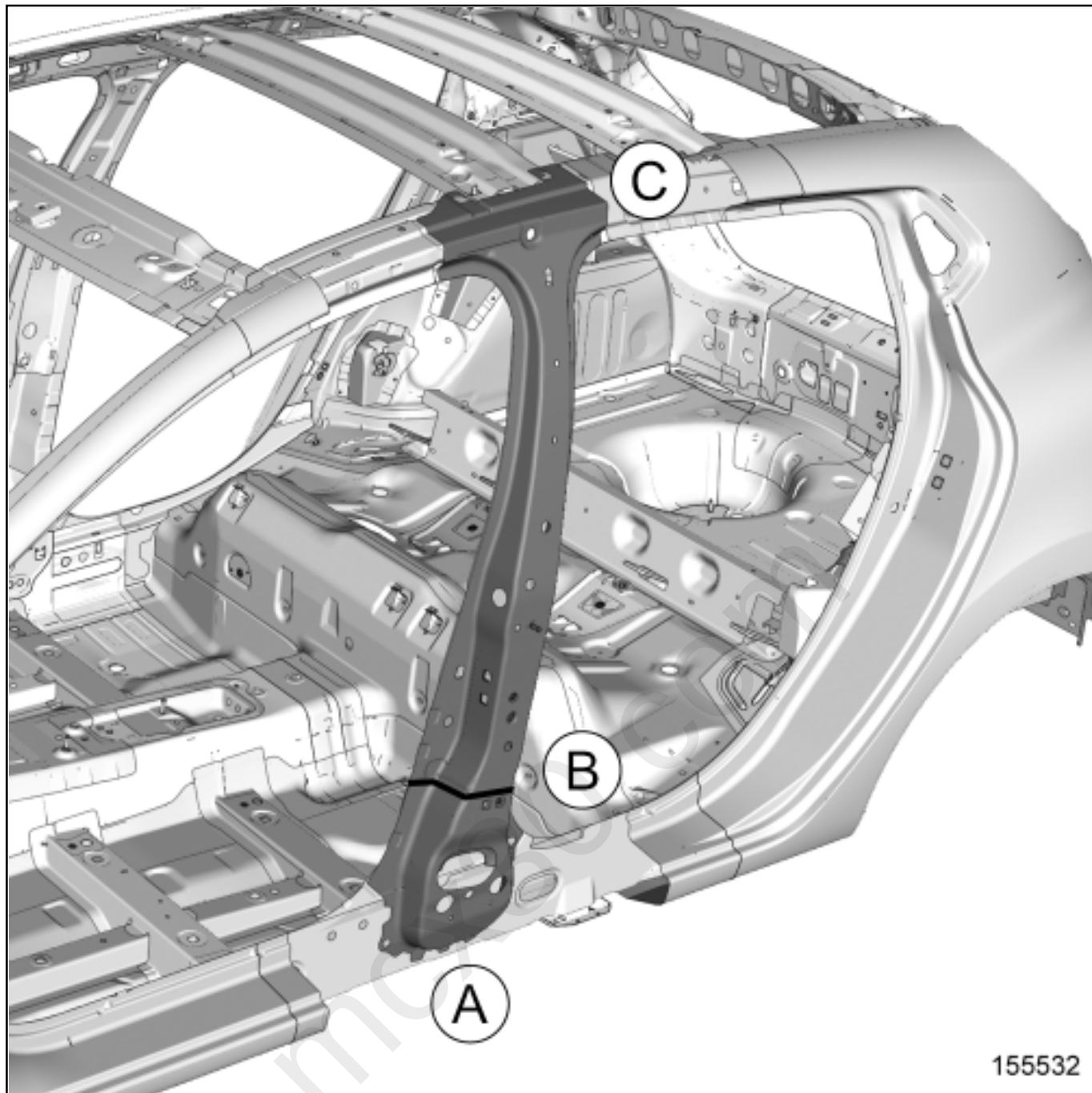
1. COMPOSITION OF THE SPARE PART



155177

No.	Description	Type	Thickness (mm)
(1)	B-pillar upper reinforcement	UHLE	1.7
(2)	B-pillar lower reinforcement	HLE	1.9
(3)	Mounting bridge piece	Mild steel	1.8

2. IN THE EVENT OF REPLACEMENT



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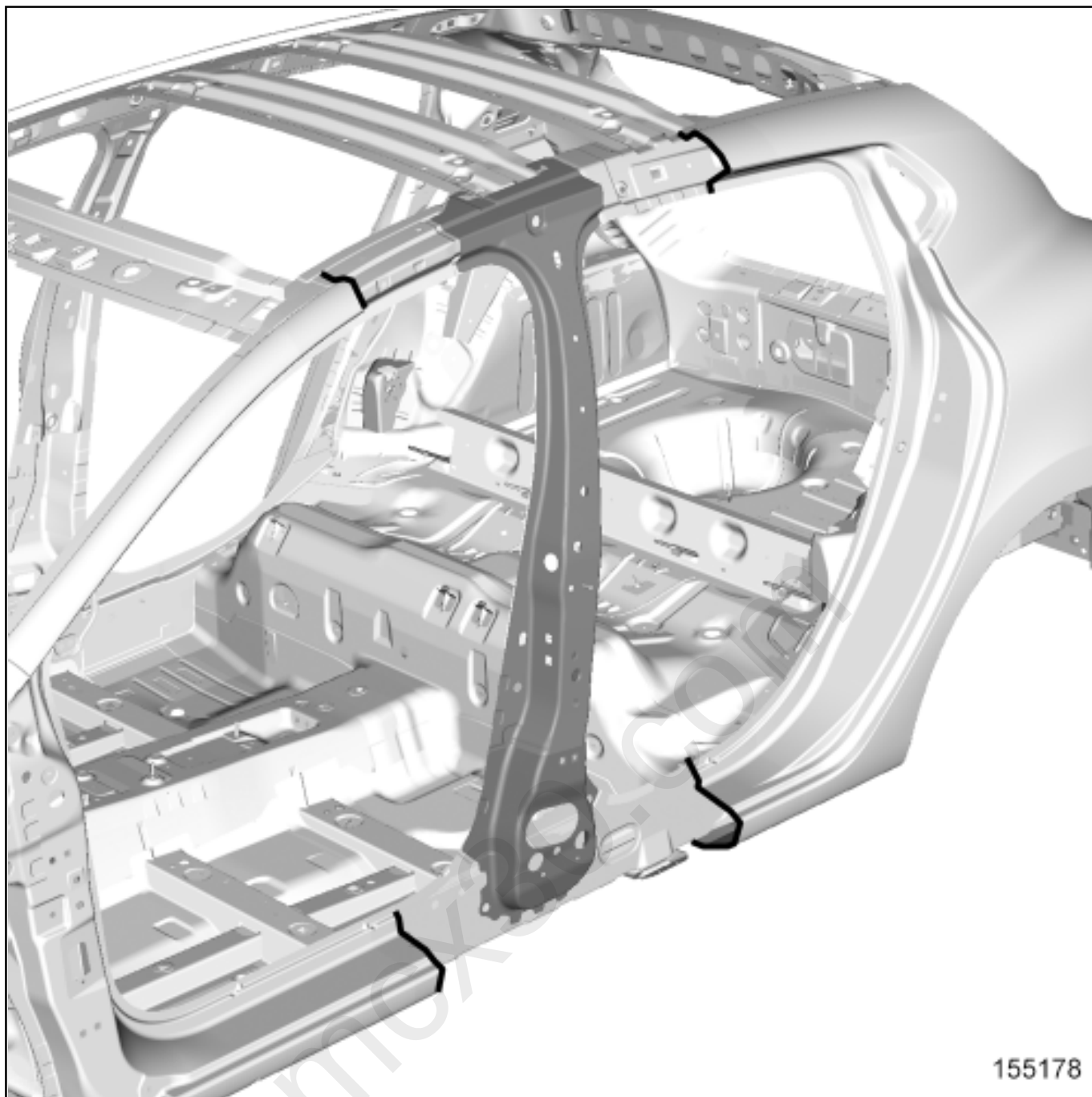
There are several ways of replacing this part:

- complete replacement A-C,

- partial replacement A-B (lower reinforcement).

1- COMPLETE REPLACEMENT A-C

1)PART IN POSITION



155178

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).

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

3)SPECIAL NOTES ON MATING

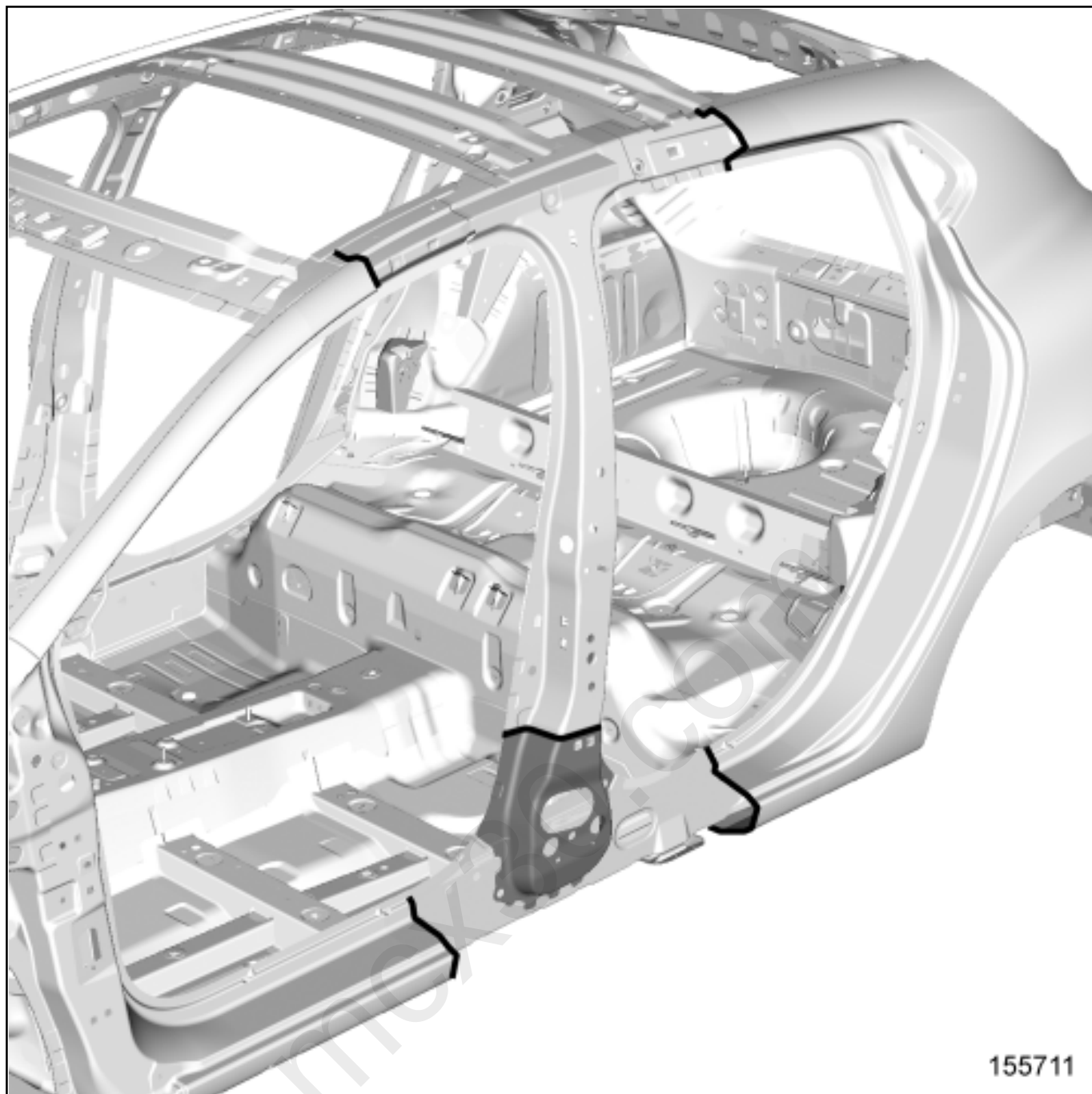


CAUTION

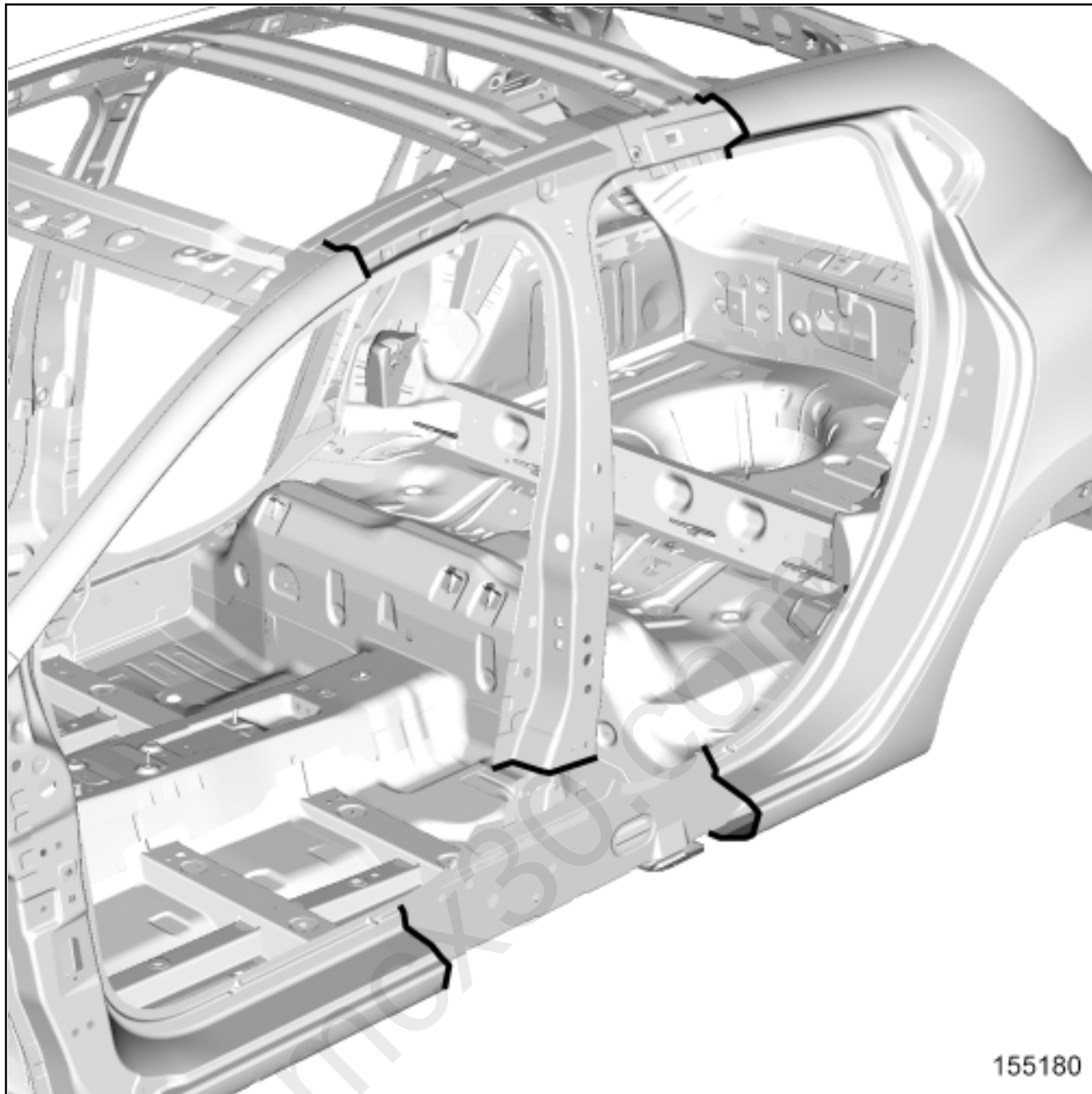
If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld [Connections by arc welding under shielding gas: Description](#) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

2- PARTIAL REPLACEMENT A-B (LOWER REINFORCEMENT)

1)PART IN POSITION



VIEW WITHOUT PART



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).