

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, make EGW plug welds to replace the original resistance welds (see MR 400).



Repair-40x03x08x04-02x49-1-7-1.xml



XSL version : 3.02 du 22/07/11

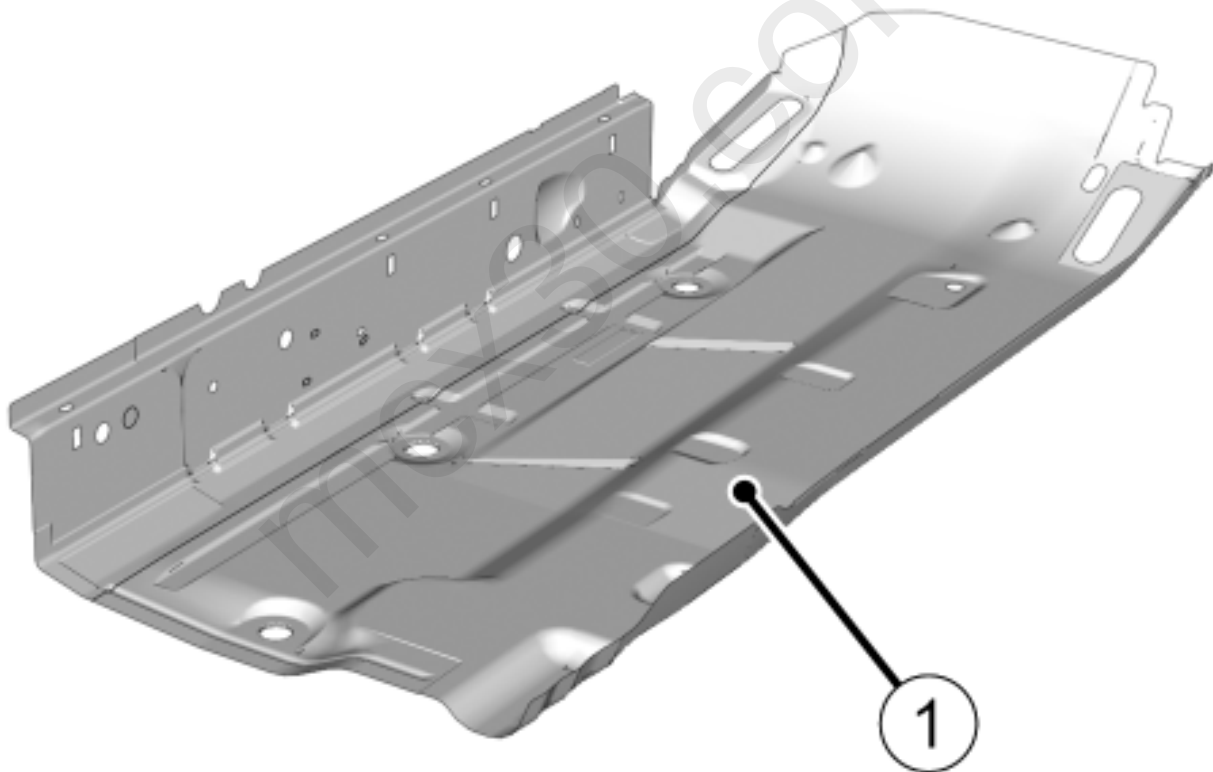
CENTRE FLOOR, SIDE SECTION: REPLACEMENT



Note, one or more warnings are present in this procedure

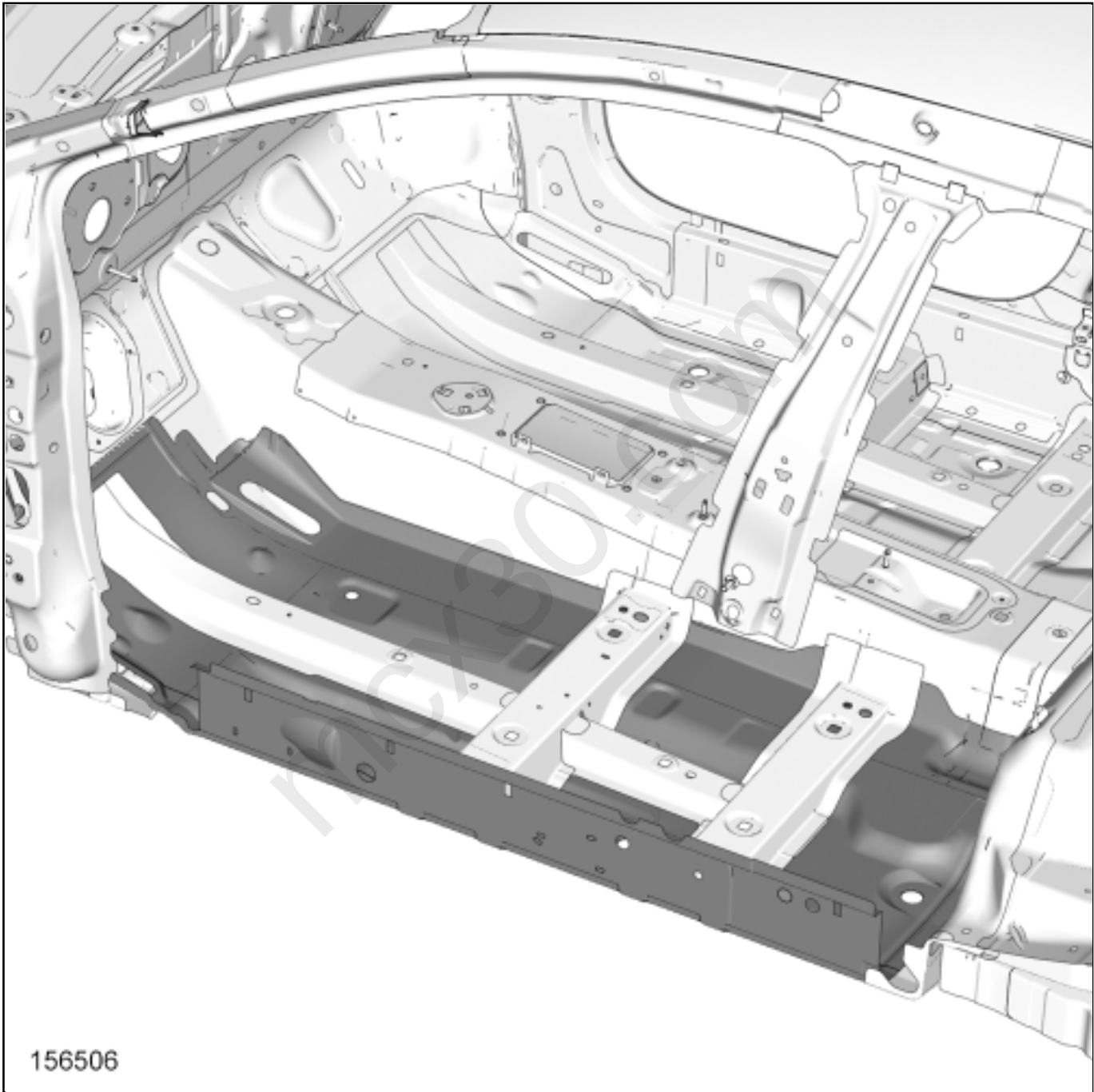


1. COMPOSITION OF THE SPARE PART



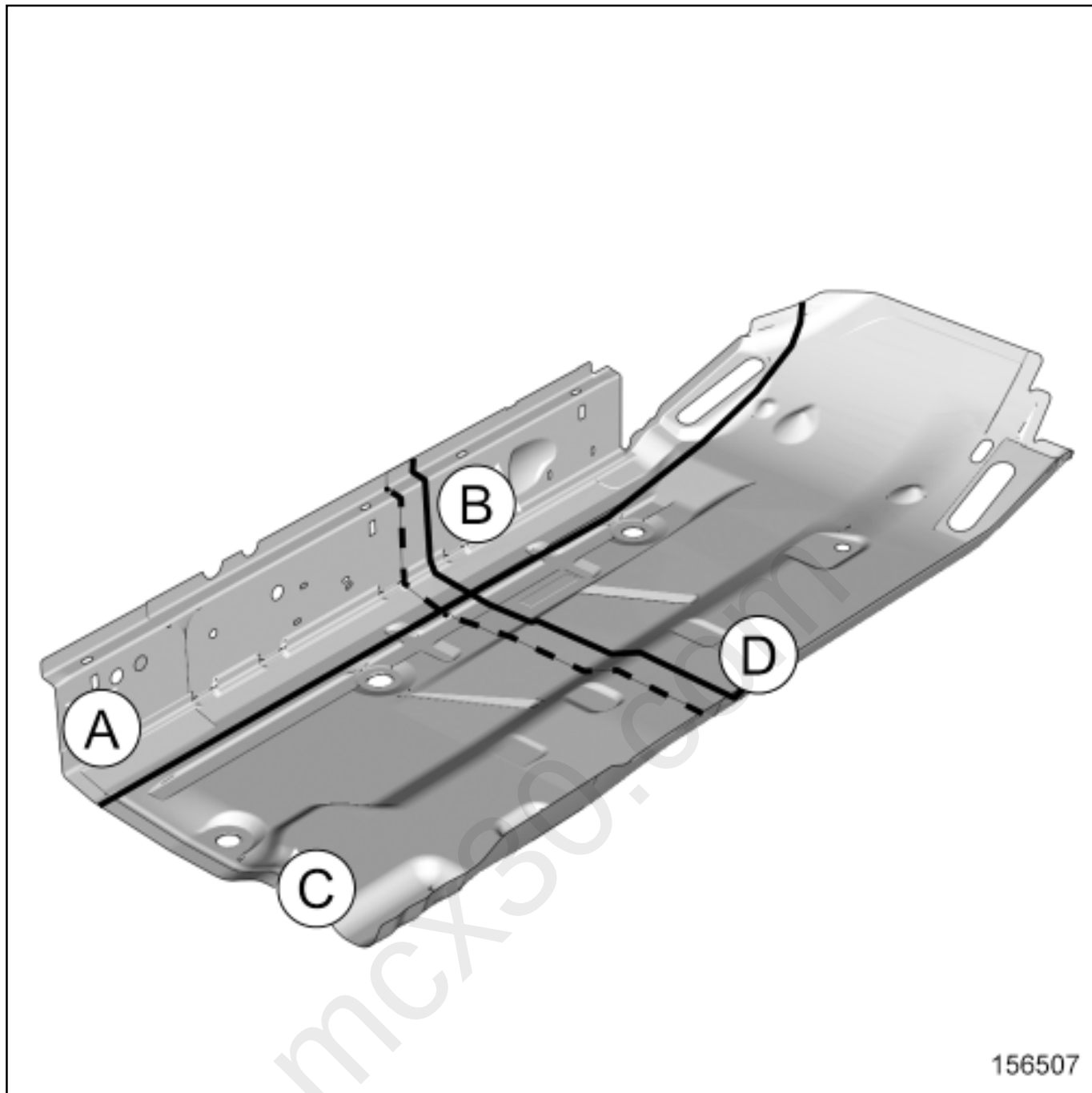
156505

No.	Description	Type	Thickness (mm)
(1)	Centre floor, side section	Mild steel	0.65/1.2



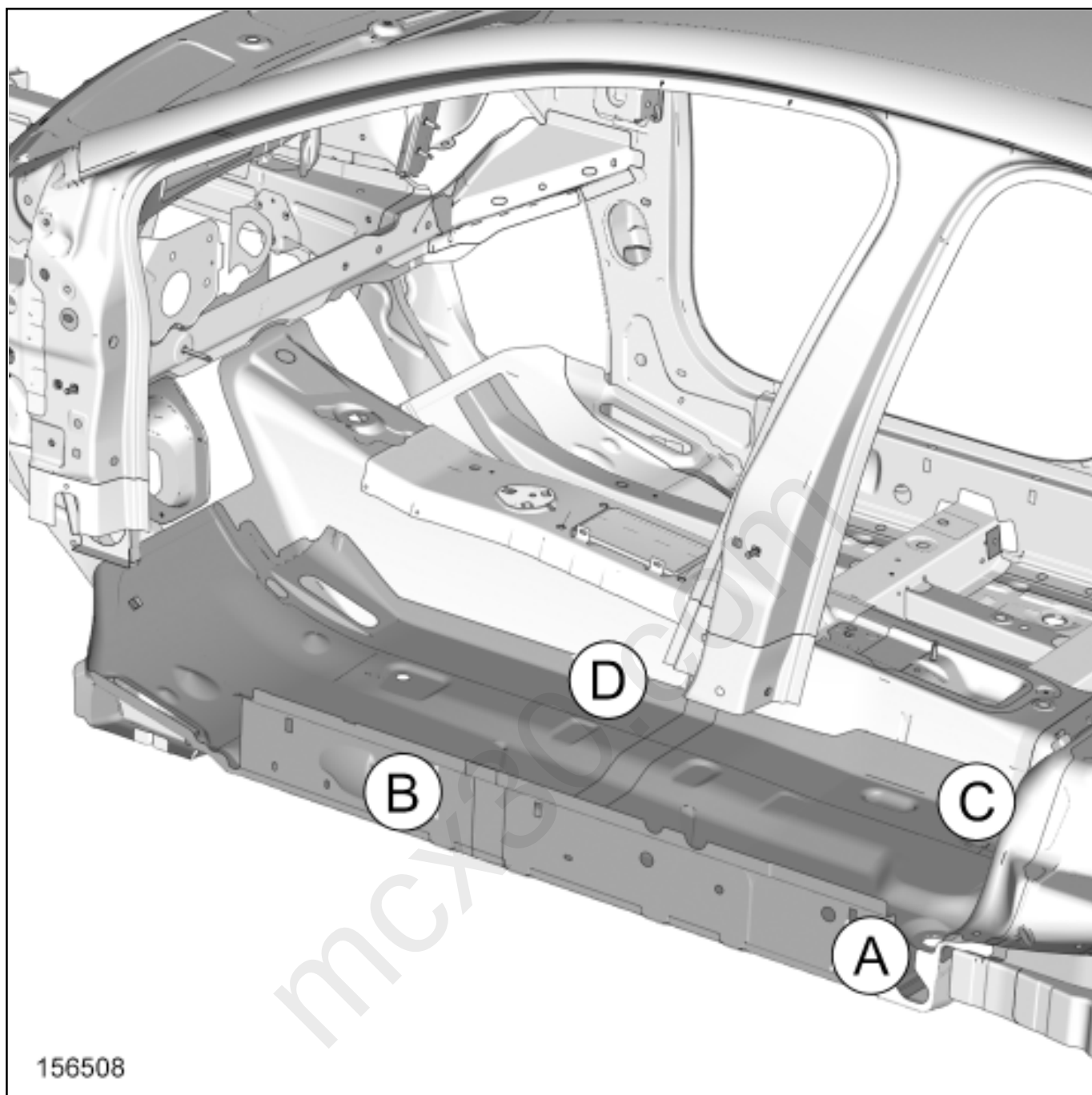
156506

2. IN THE EVENT OF REPLACEMENT

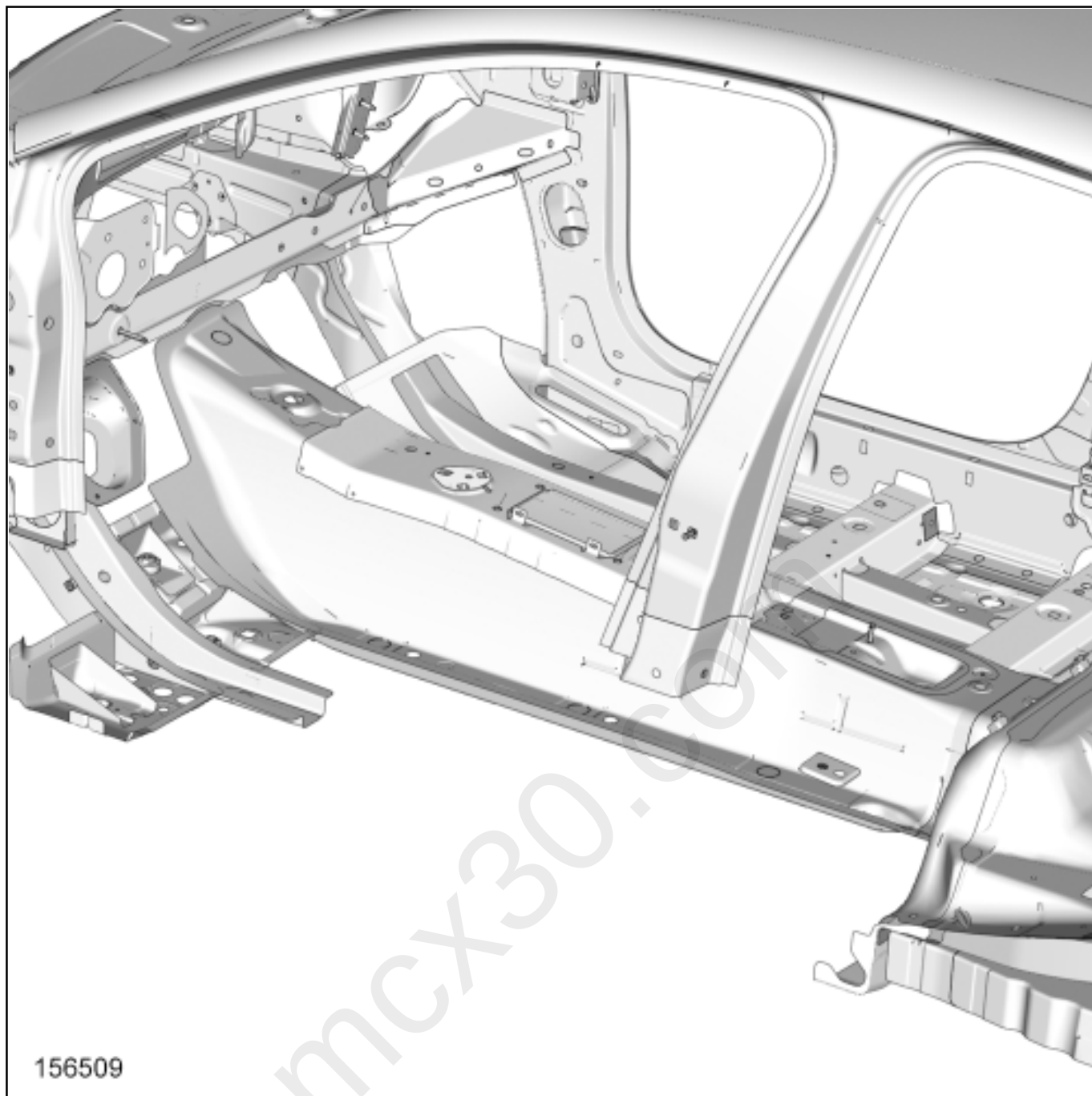


The options for replacing this part are as follows:

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



VIEW WITHOUT PART



156509

2) POSITION OF ELECTRIC EARTHS

CAUTION

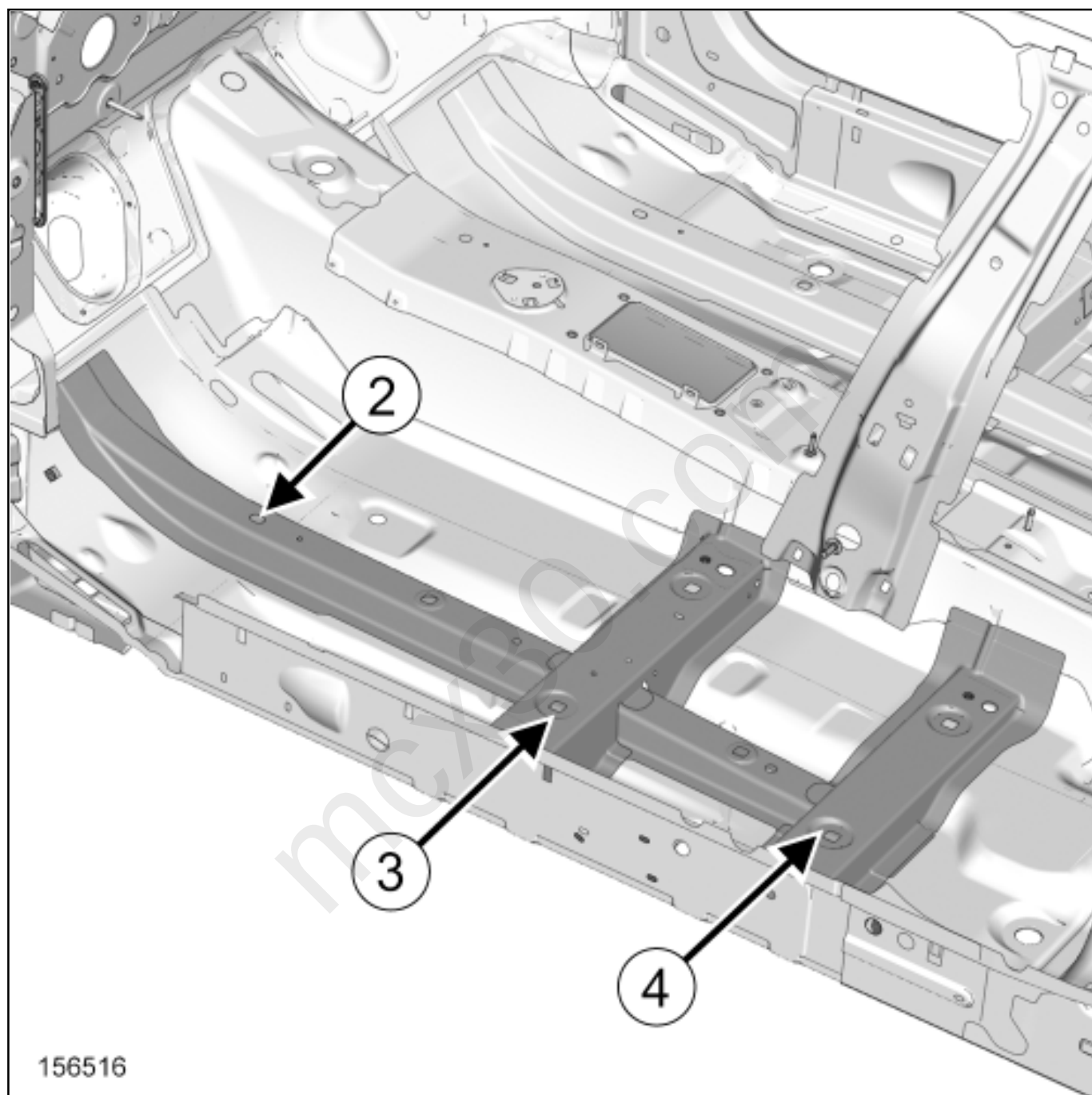


To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

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



Remove:



the sill panel [Sill panel: Replacement](#) ,



the sill panel closure panel [Sill panel closure panel: Replacement](#) ,

the sill panel reinforcement, rear section [Sill panel rear reinforcement: Replacement](#) .

the centre side member(2) ,

the front cross member under front seat(3) ,

the rear cross member under front seat(4) .

4)SPECIAL NOTES ON THE MATING FACES

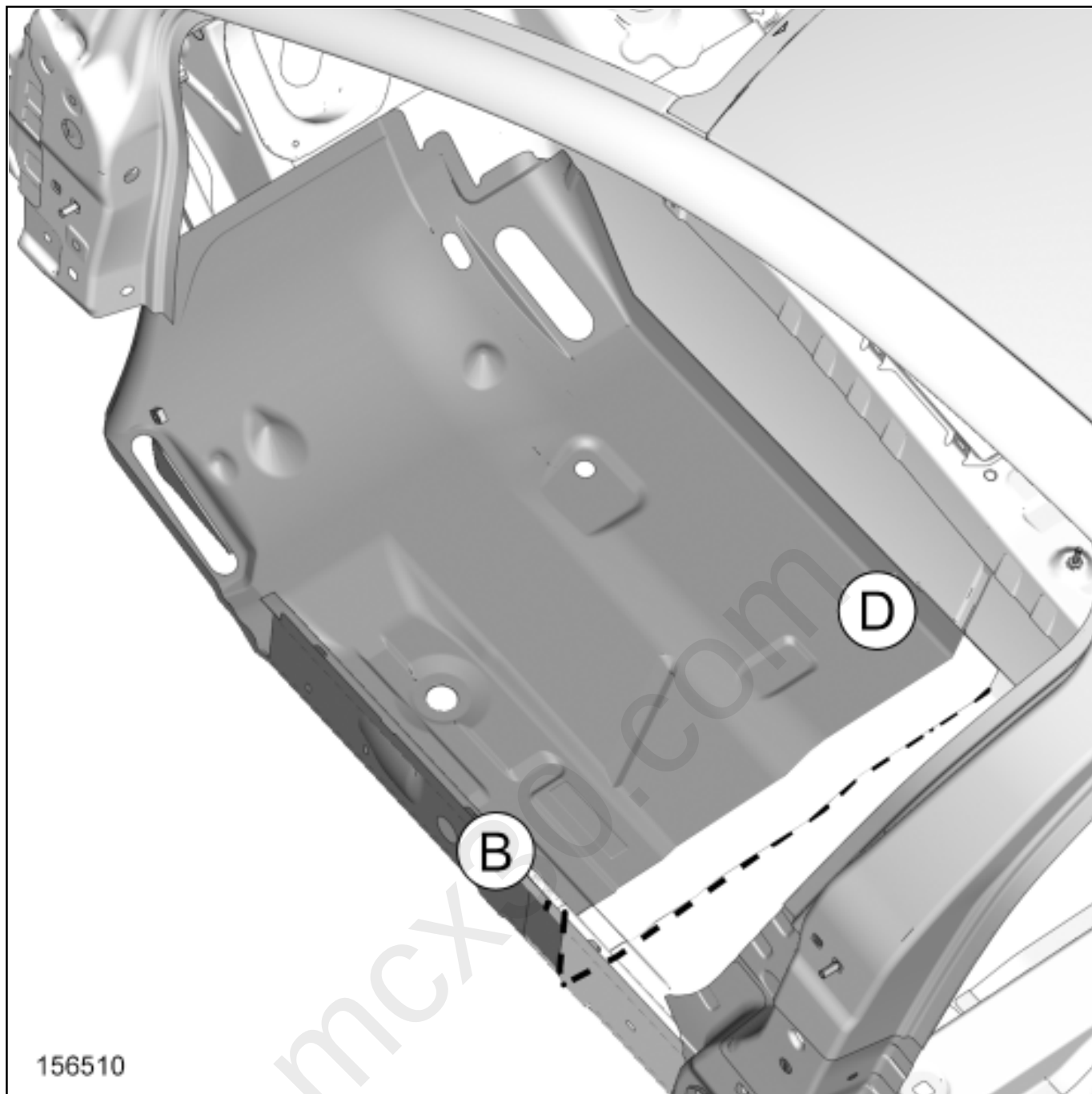


CAUTION

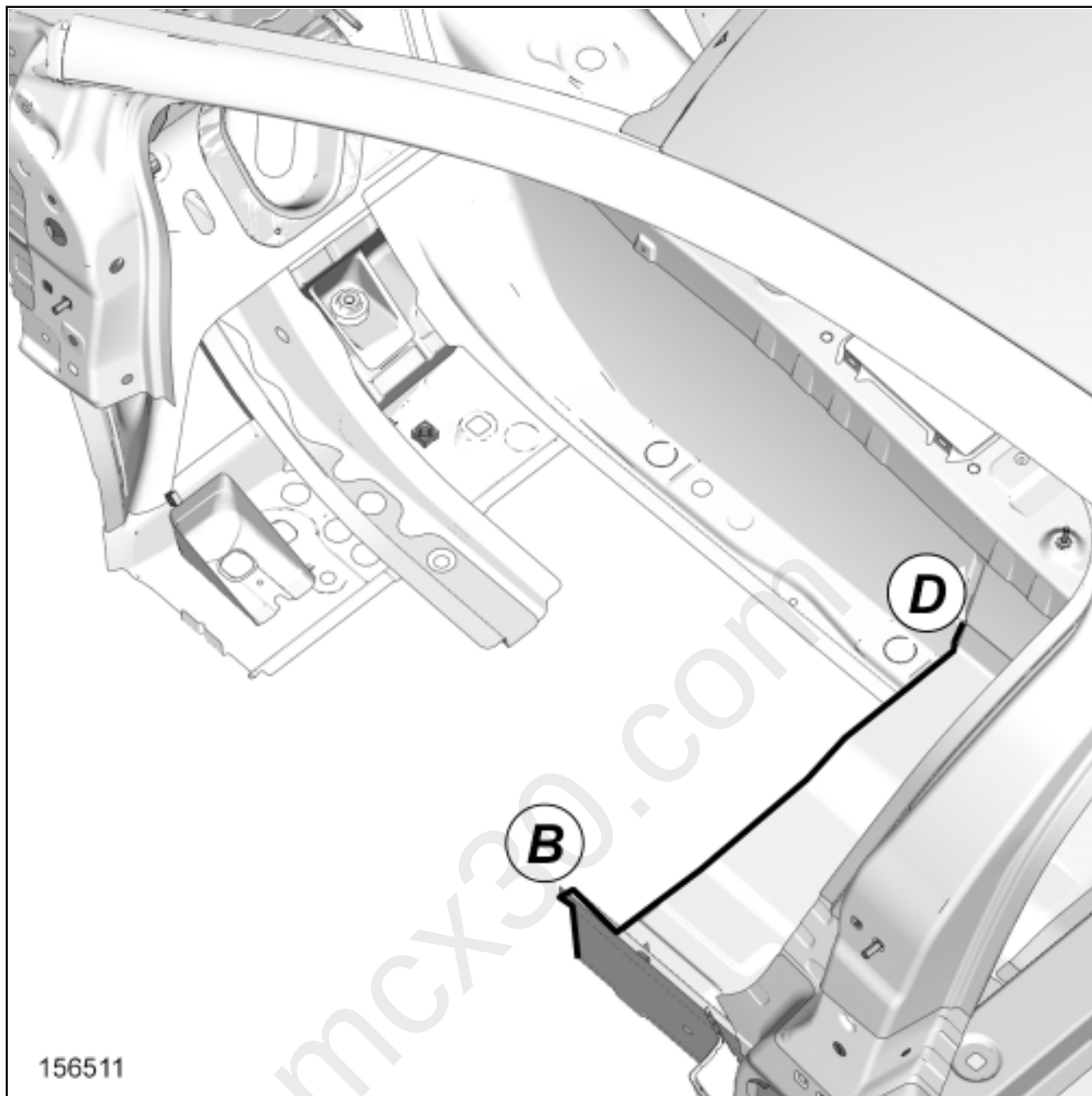
If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld [Connections by arc welding under shielding gas: Description](#) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

2- FRONT PARTIAL REPLACEMENT B-D

1)PART IN POSITION



VIEW WITHOUT PART



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2) POSITIONING OF ELECTRICAL EARTHS

CAUTION

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

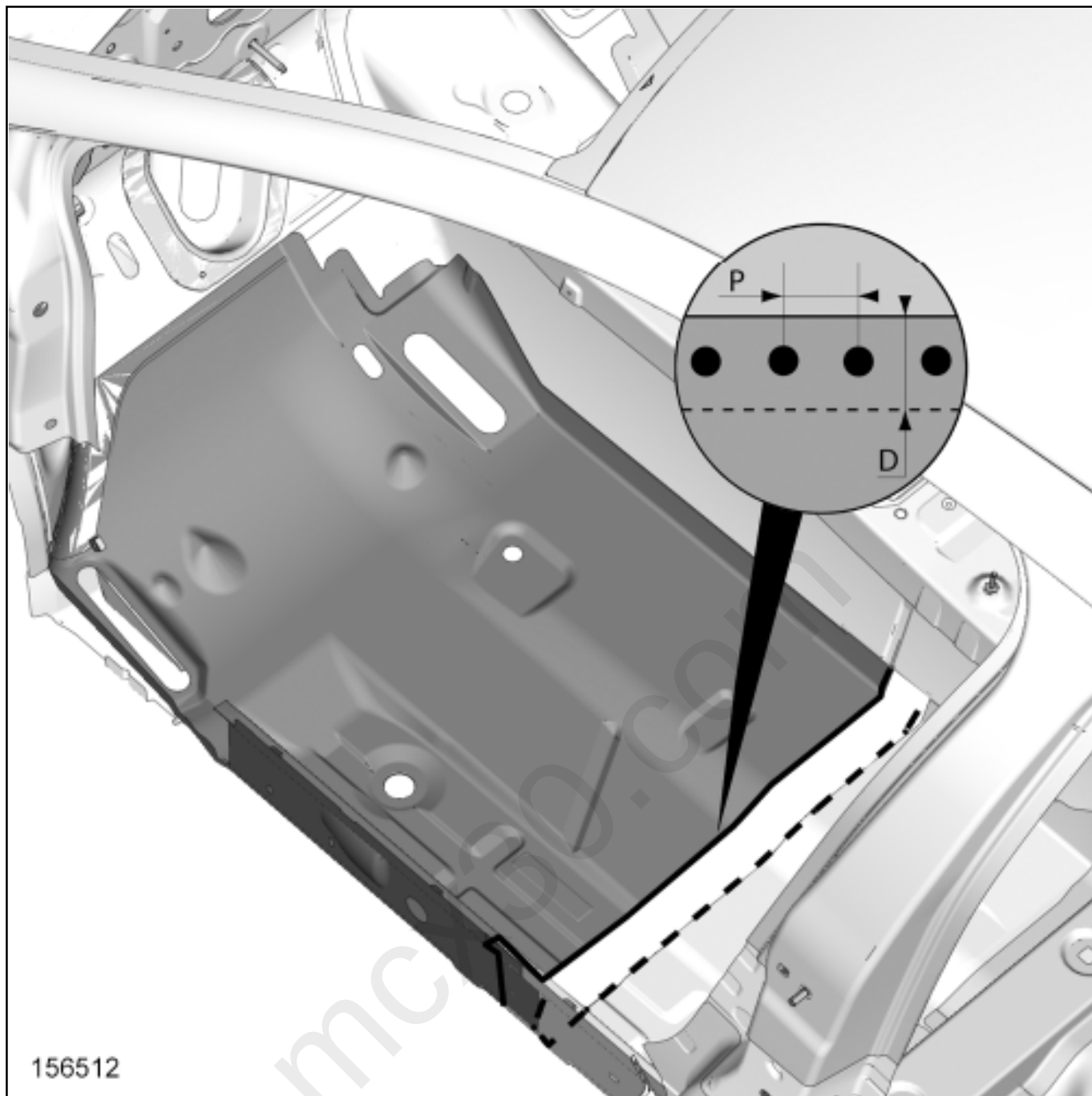
3)IRREMOVABLE BODYWORK COMPONENTS - STRUCTURE TO BE REMOVED IN ORDER TO CARRY OUT THE REPLACEMENT OPERATION



Remove:

-
- the sill panel [Sill panel: Replacement](#) ,
- the sill panel closure panel [Sill panel closure panel: Replacement](#) ,
- the sill panel reinforcement, rear section [Sill panel rear reinforcement: Replacement](#) (see **Sill panel reinforcement, front section: Replacement**) .
- the front cross member under front seat(3) ,
- the centre side member(2) .

4)SPECIAL NOTES ON THE MATING FACES



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

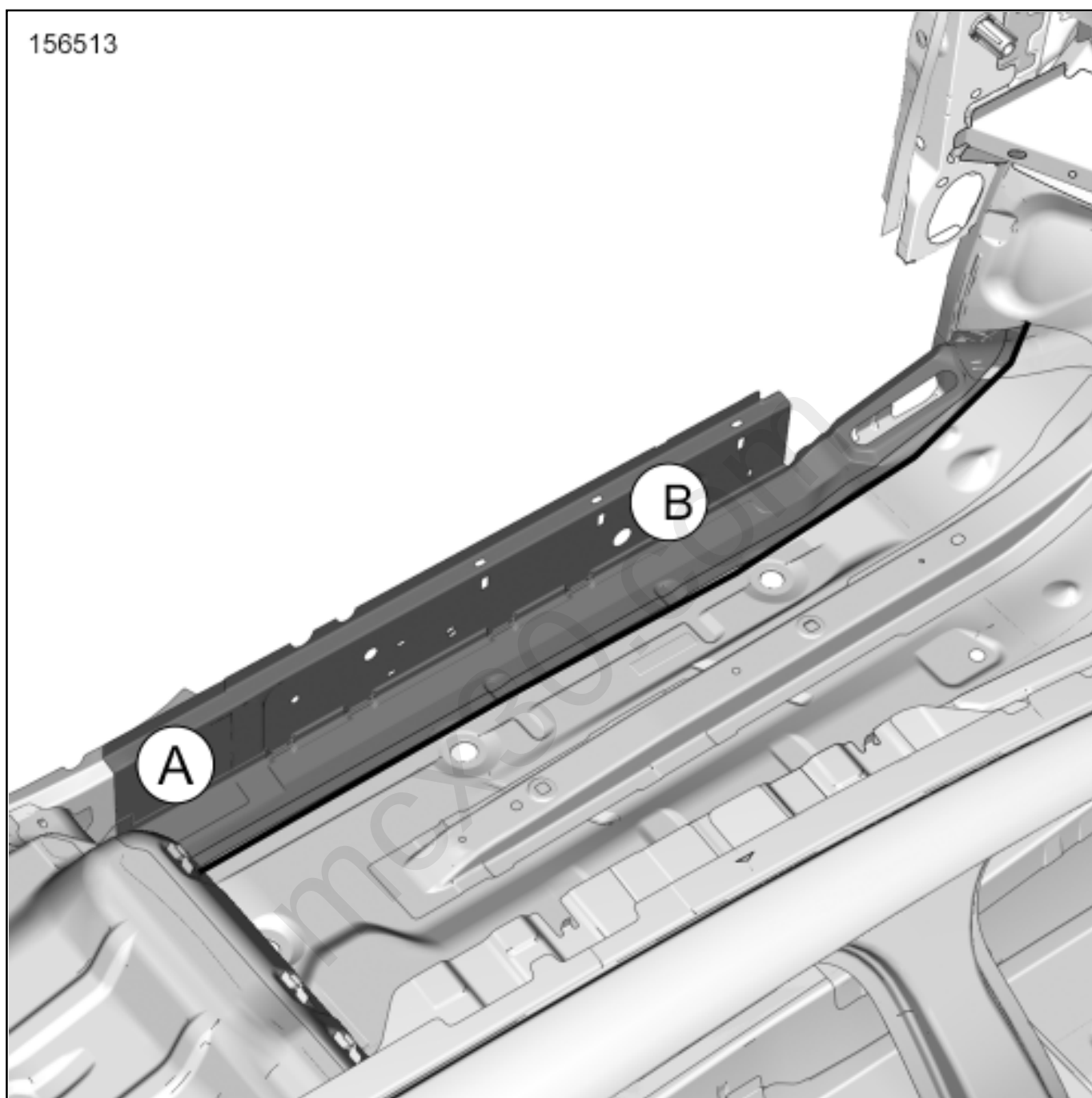


CAUTION

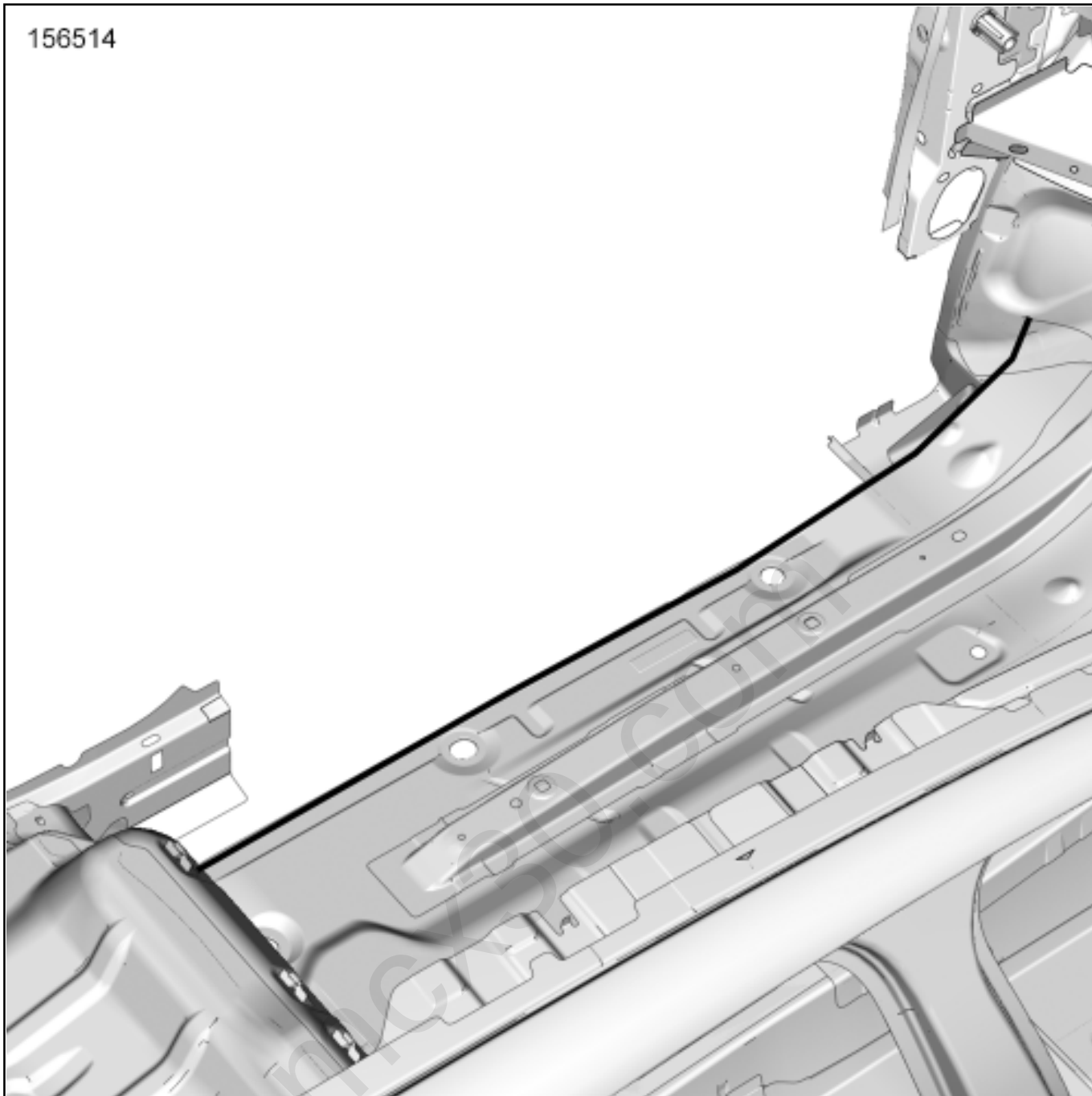
If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld [Connections by arc welding under shielding gas: Description](#) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

3- PARTIAL REPLACEMENT A-B

1)PART IN POSITION



VIEW WITHOUT PART



2) POSITIONING OF ELECTRICAL EARTHS

CAUTION



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the sill panel closure panel [Sill panel closure panel: Replacement](#) ,



the sill panel reinforcement, rear section [Sill panel rear reinforcement: Replacement](#) .

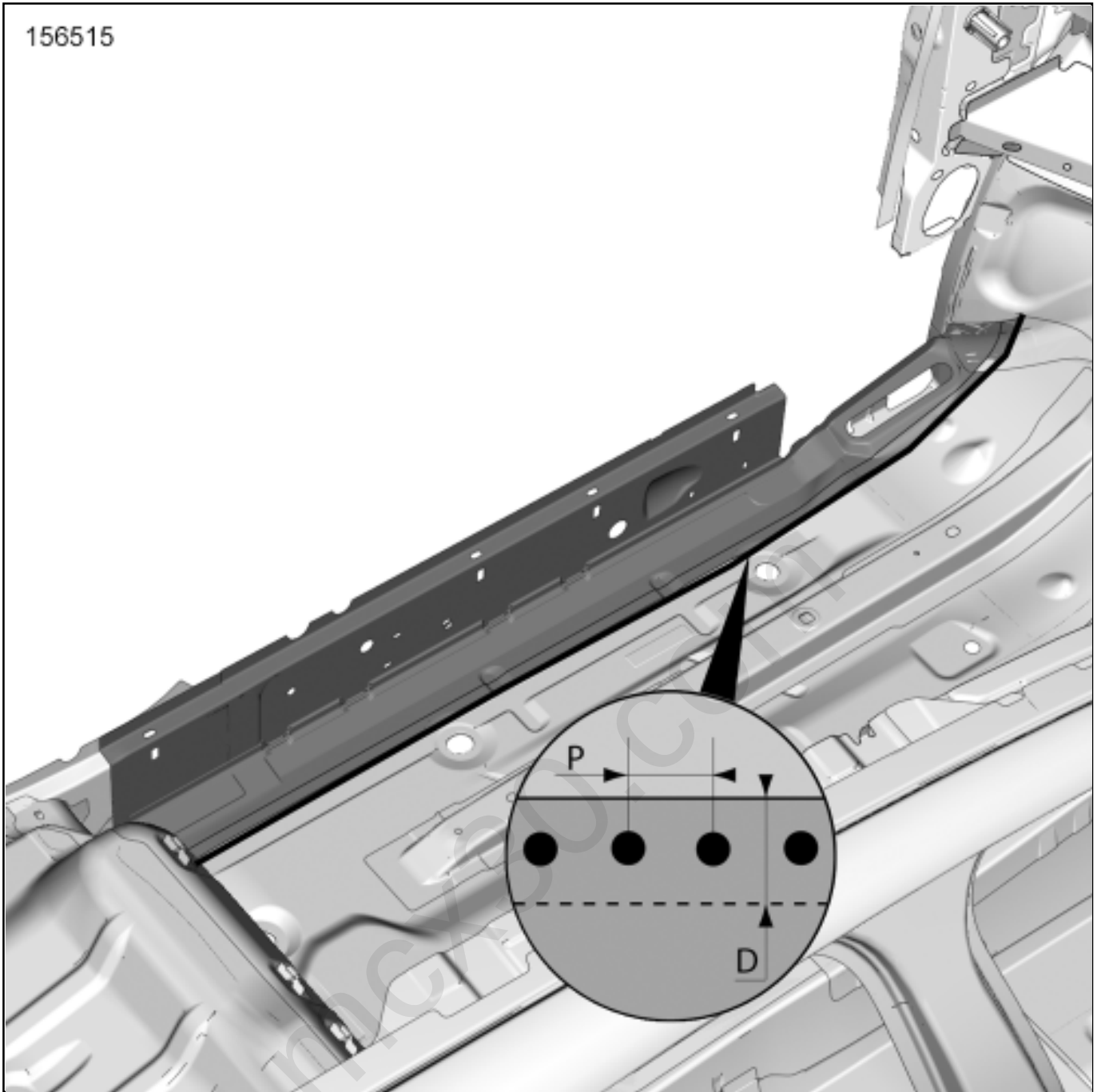


the front cross member under front seat(3) ,



the rear cross member under front seat(4) .

4)SPECIAL NOTES ON THE MATING FACES



Make a superimposed connection [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)).