



WARNING

Position the "nut and bolt securing the sleeve" assembly so that the assembly cannot come into contact with the underbody.

Tighten the sleeve while supporting the exhaust pipe to ensure they are aligned.

3. FINAL OPERATION

Check:

-
- that all the exhaust pipe heat shields are in place and properly attached,
- that there is no contact with the underbody,
- that there are no leaks.

Refit the engine undertray.



[Repair-10x08x02x05-01x37-1-51-1.xml](#)



CONNECTIONS BY ARC WELDING UNDER SHIELDING GAS: DESCRIPTION

1. DISASSEMBLY

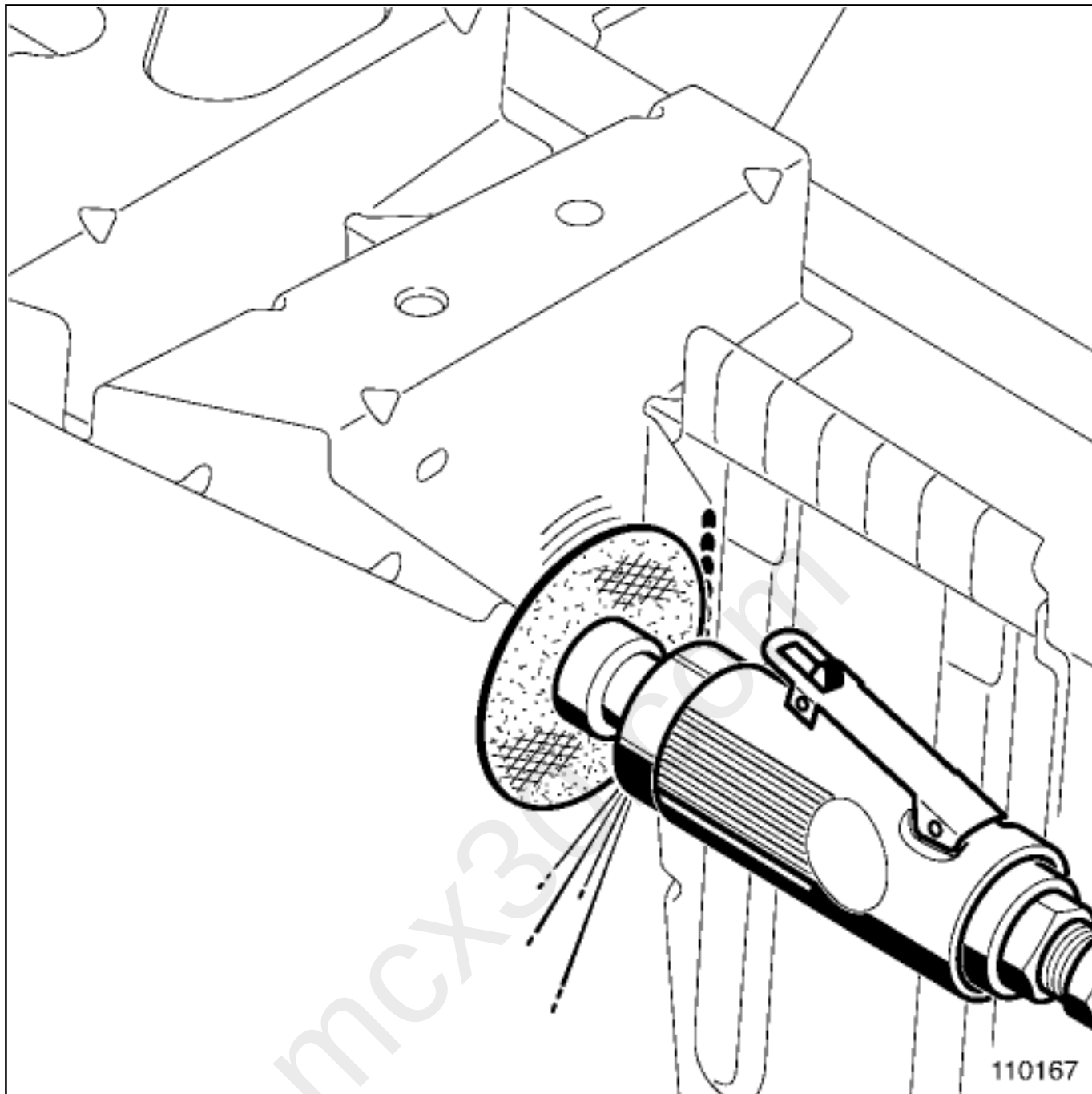
1- SCOURING

If necessary, scour the joint line to bring out the weld bead:

(see 05B, Equipment and Tools, Tools for stripping very thick soft mastic: Use)

(see 05B, Equipment and Tools, Tools for scraping rigid adhesives and paint: Use)

2- UNPICKING

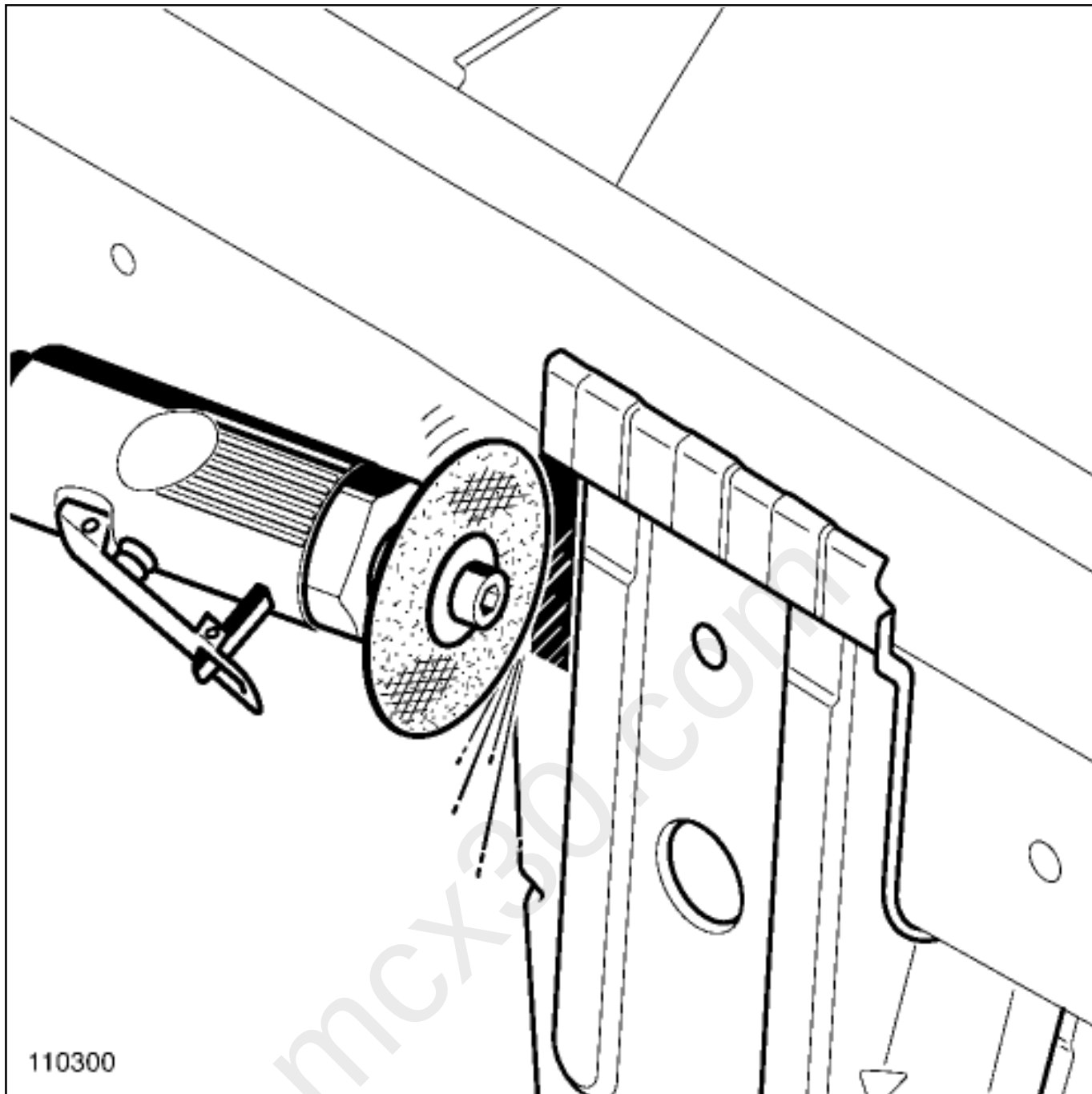


Unpick the weld bead.

[\(see 05B, Equipment and Tools, Tools for unpicking a structural component: Use\)](#)

Remove the damaged part.

3- GRINDING



Grind the welding residue.

[\(see 05B, Equipment and Tools, Tool for levelling off weld residue: Use\)](#)

Surface the mating face.

[\(see 05B, Equipment and Tools, Tool for surfacing mating faces: Use\)](#)



Note:

Do not strike or damage the panel.

2. PREPARATION BEFORE ASSEMBLY

1- POSITIONING AND ADJUSTMENT

Position the replacement part, adjust it and fix it using the locking pliers.

If necessary, reassemble the adjacent components and check the panel gaps.

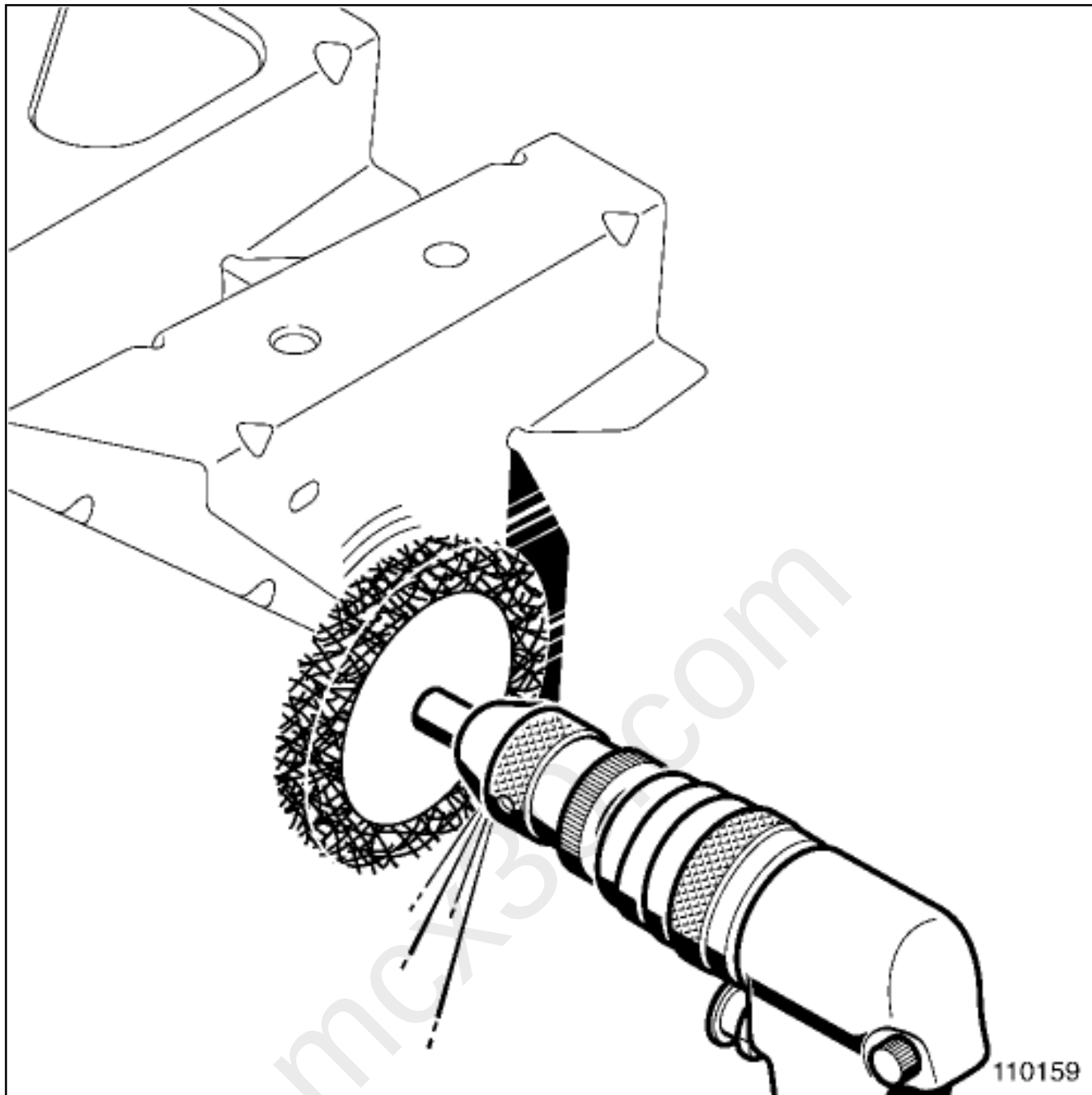
(see 05B, Equipment and Tools, Tools for adjusting and supporting a structural component: Use)

2- MARKING AND IDENTIFYING THE JOINTS

Mark the joint zones.

Remove the replacement part.

3- PREPARATION OF THE JOINTS ON THE REPLACEMENT PART



Scour the external mating face.

[\(see 05B, Equipment and Tools, Tools for scraping rigid adhesives and paint: Use\)](#)

4- APPLY THE PROTECTION BEFORE ASSEMBLY

Position the acoustic inserts in the hollow sections, if necessary.

[\(see 04F, Bodywork products and mountings, Soundproofing products before assembly: Use\)](#)

Apply the anti-corrosion protection to the internal joint mating faces.

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

3. ASSEMBLY

1- POSITIONING AND ADJUSTING THE REPLACEMENT PART

Position the replacement part, adjust it and fix it using the locking pliers.

If necessary, reassemble the adjacent components and check the panel gaps.

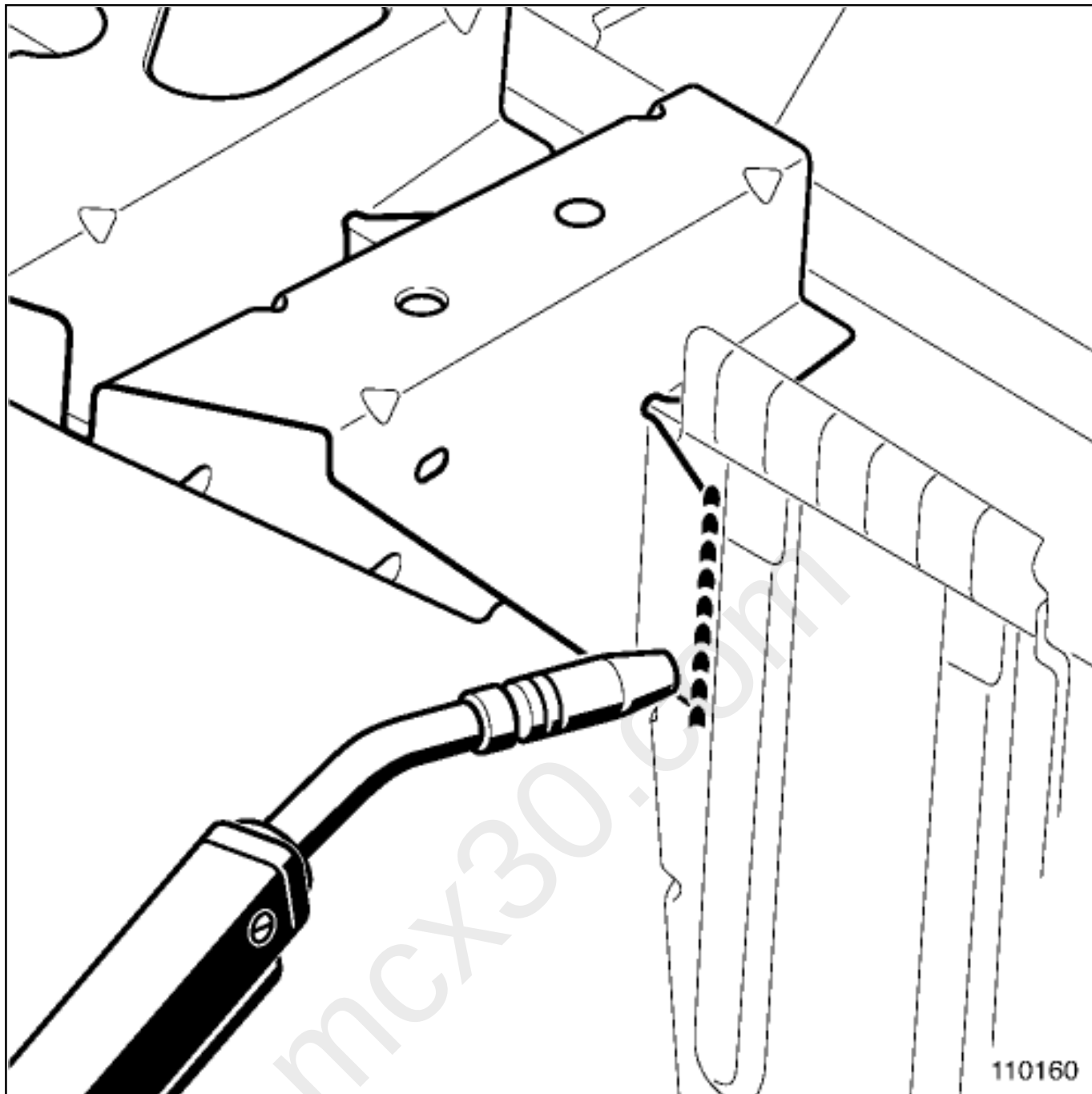
(see 05B, Equipment and Tools, Tools for adjusting and supporting a structural component: Use)

2- ADJUSTING THE WELDER

Before working on the vehicle, follow the procedure below:

(see 40C, Gas metal arc welded connections, Connections by arc welding under shielding gas: Precautions for the repair)

3- WELDING



Make the weld bead, the same length and in exactly the same position as the original.

4- FINISHING

No finishing is required on this type of weld; the appearance should be identical to the original.

