



Repair-40x01x30-02x60-1-1-1.xml



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CONNECTIONSBYBRAZING:CONNECTIONSBYBRAZING

To replace an original braze connection, apply a GMAW weld bead.

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 braze bead.

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

3- GRINDING

Grind the brazing residues.

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

Surface finish the mating face.

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



Note:

Remove all brazing residue, in order not to contaminate the GMAW bead joint.



Note:

Do not strike or damage the support panel.

2. PREPARATION BEFORE ASSEMBLY

1- POSITIONING AND ADJUSTMENT

Position the replacement part, adjust it and fix it.

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 areas.

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

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 THE REPLACEMENT PART

Position the replacement part, adjust it and fix it.

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: