

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

3- CARRYING OUT THE WELDING

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

4- FINISHING

Reproduce the original appearance of the connection by brazing.



CONNECTIONS BY RIGID BONDING: DESCRIPTION

Special tooling required

Levelling tool for bodywork seal

Car. 1786

Equipment required

safety strap(s)

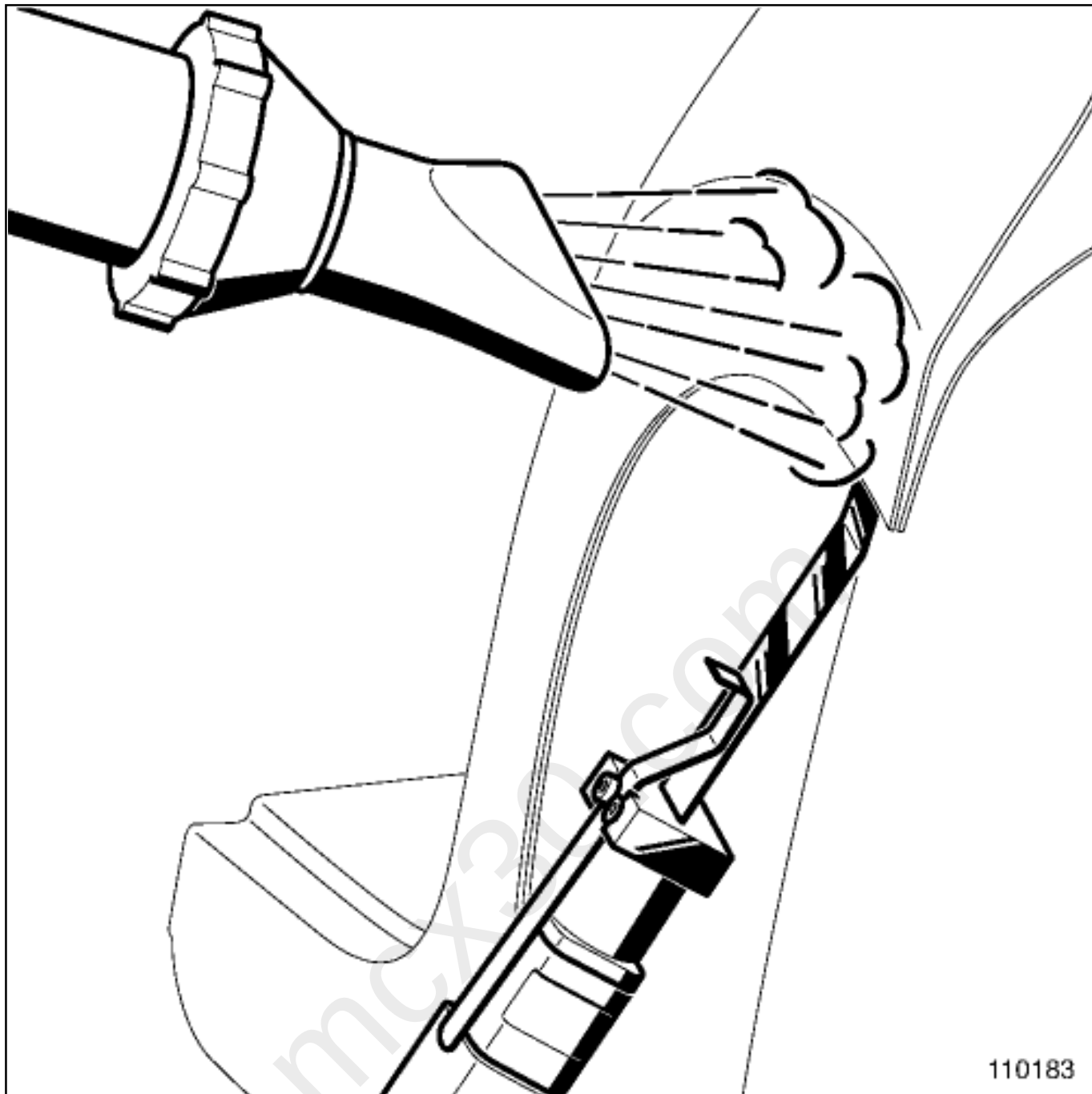
1. DISASSEMBLY

☐ A rigid bonded joint can be associated with a variety of joints:

- crimped,
- resistance welded,
- riveted,
- bolted.

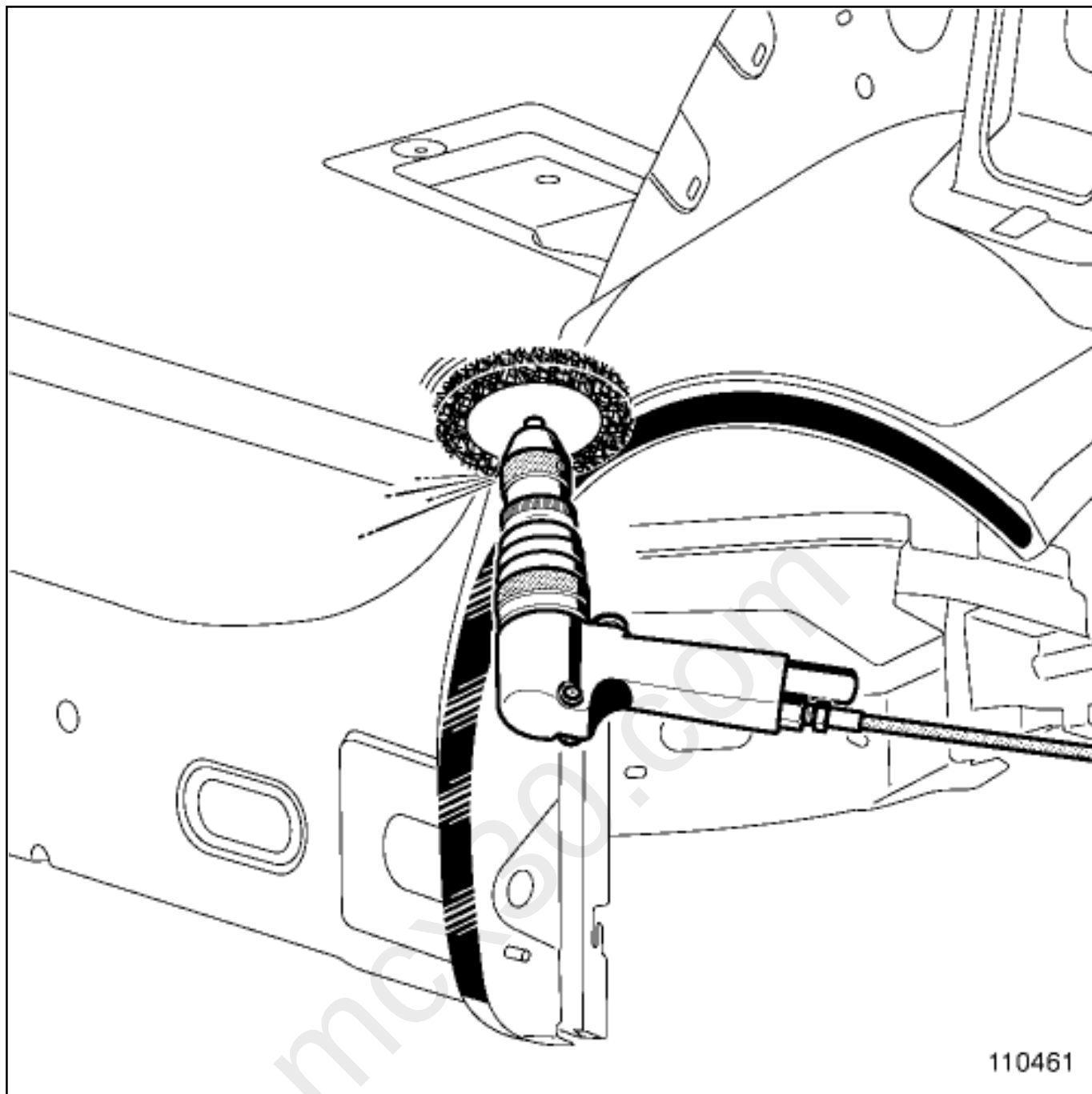
Disassemble these joints to allow access to the cement bead (see documentation corresponding to the relevant associated joint).

1- UNSTICKING



Remove the damaged part, by simultaneously heating with a heat stripper to destroy the bonding.

2- SCOURING



Scour the cement residue left on the vehicle(see [Tools for stripping hard mastics and paint: Use](#)) .

2. PREPARATION BEFORE ASSEMBLY

1- ADJUSTMENT BEFORE ASSEMBLY

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

Sand using P320dry sand paper or a red abrasive pad, without removing the protection.

Clean the internal joint face with surface cleaner.

4- PREPARATION OF THE JOINTS ON THE VEHICLE

Clean the internal joint face with surface cleaner.

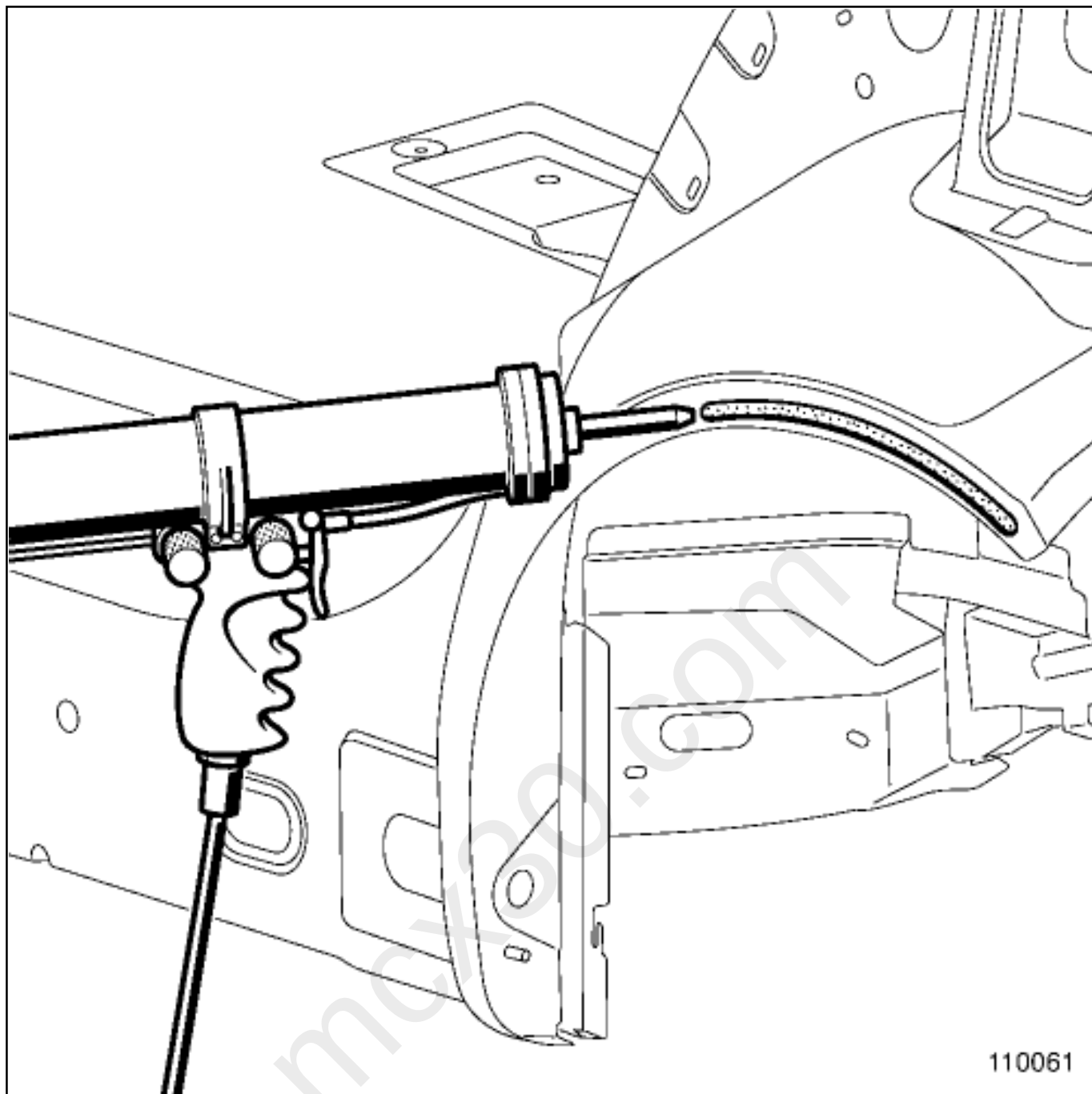
5- APPLY THE PROTECTION BEFORE ASSEMBLY

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

(see 04F, Bodywork products and mountings, Soundproofing products before assembly: Use)

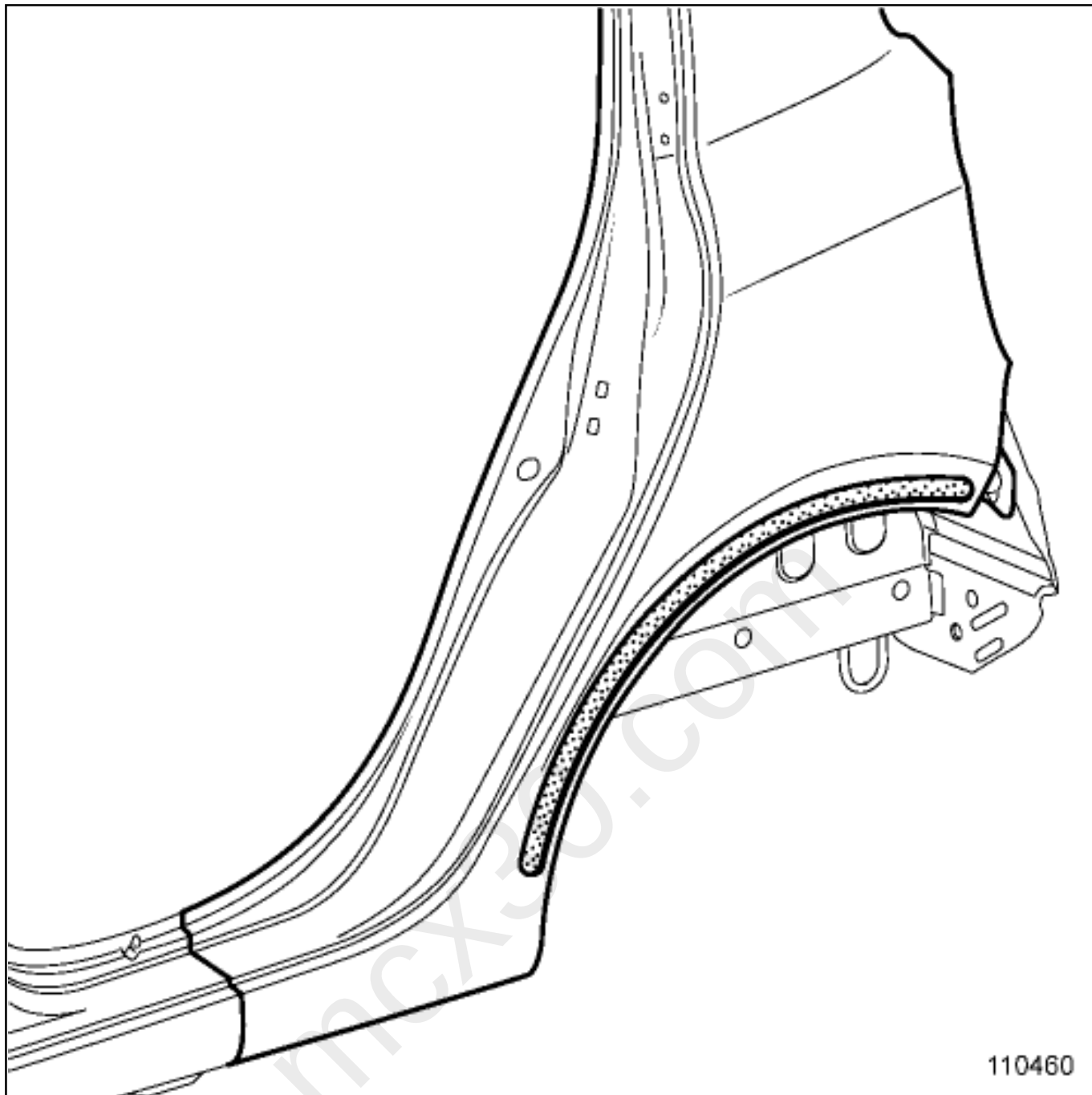
3. ASSEMBLY

1- APPLICATION OF THE BONDING PRODUCT



Apply the relevant bonding product for the type of joint concerned ([see 40F, Bonded connections, Connections by bonding: Precautions for the repair](#)) ([see 04F, Bodywork products and mountings, Products and equipment for bonded assembly: Use](#))

2- FITTING AND ADJUSTING THE REPLACED PARTS



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Position the part on the vehicle.

Tighten the joint using C-clamps to flatten the seal and ensure bonding.

Insert the plastic protector shims between the C-clamps and the part so that it is not marked.

3- FINISHING

Remove the excess cement with thinner before drying.

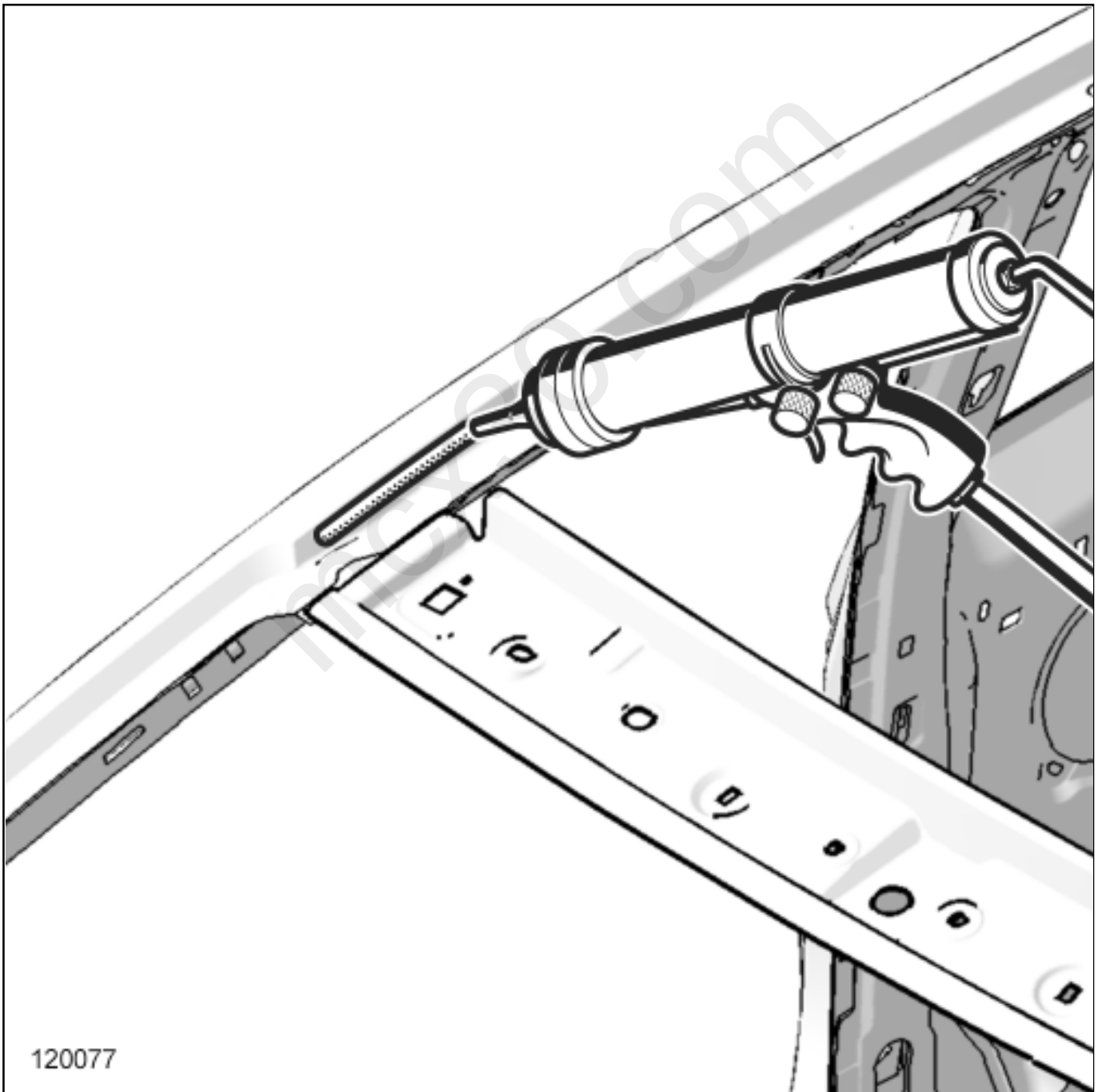
Make the original associated joint (see procedure corresponding to the relevant associated joint).

Note:



If the bonded joint is associated with a resistance welded joint, the joint face is not accessible using the spot welder and the spot welds are replaced by plug welds, the cement bead must be broken at the plug welds so as not to alter the spot quality.

4. SPECIAL NOTES ON ROOF ASSEMBLY: DESCRIPTION

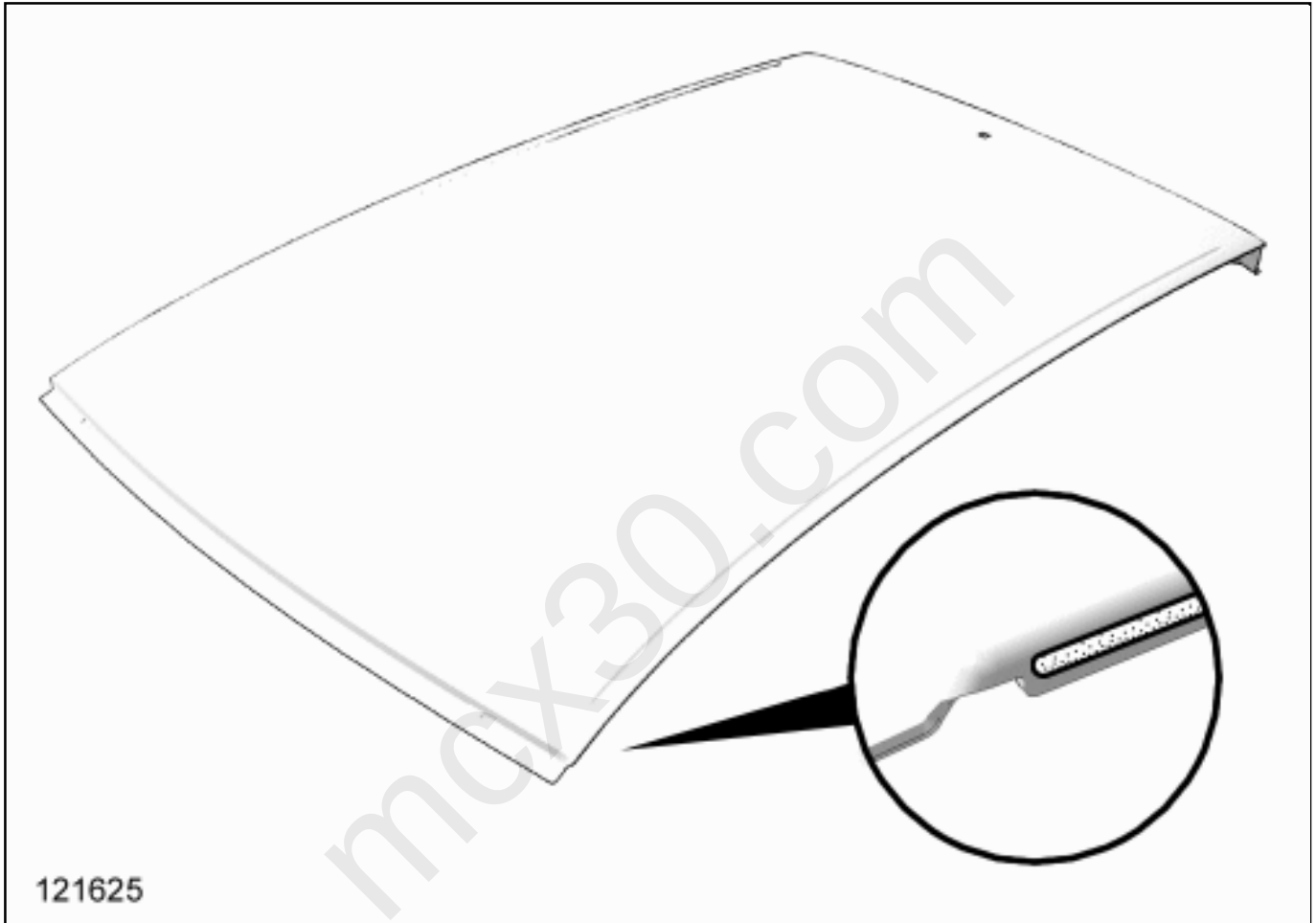


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Apply a cement bead to the roof cross members.

Apply a bead of high performance structural adhesive over the whole internal joint face on the body side
([see 40F, Bonded connections, Connections by rigid bonding: Description](#)) (MR400, 40F, Bonded connections).

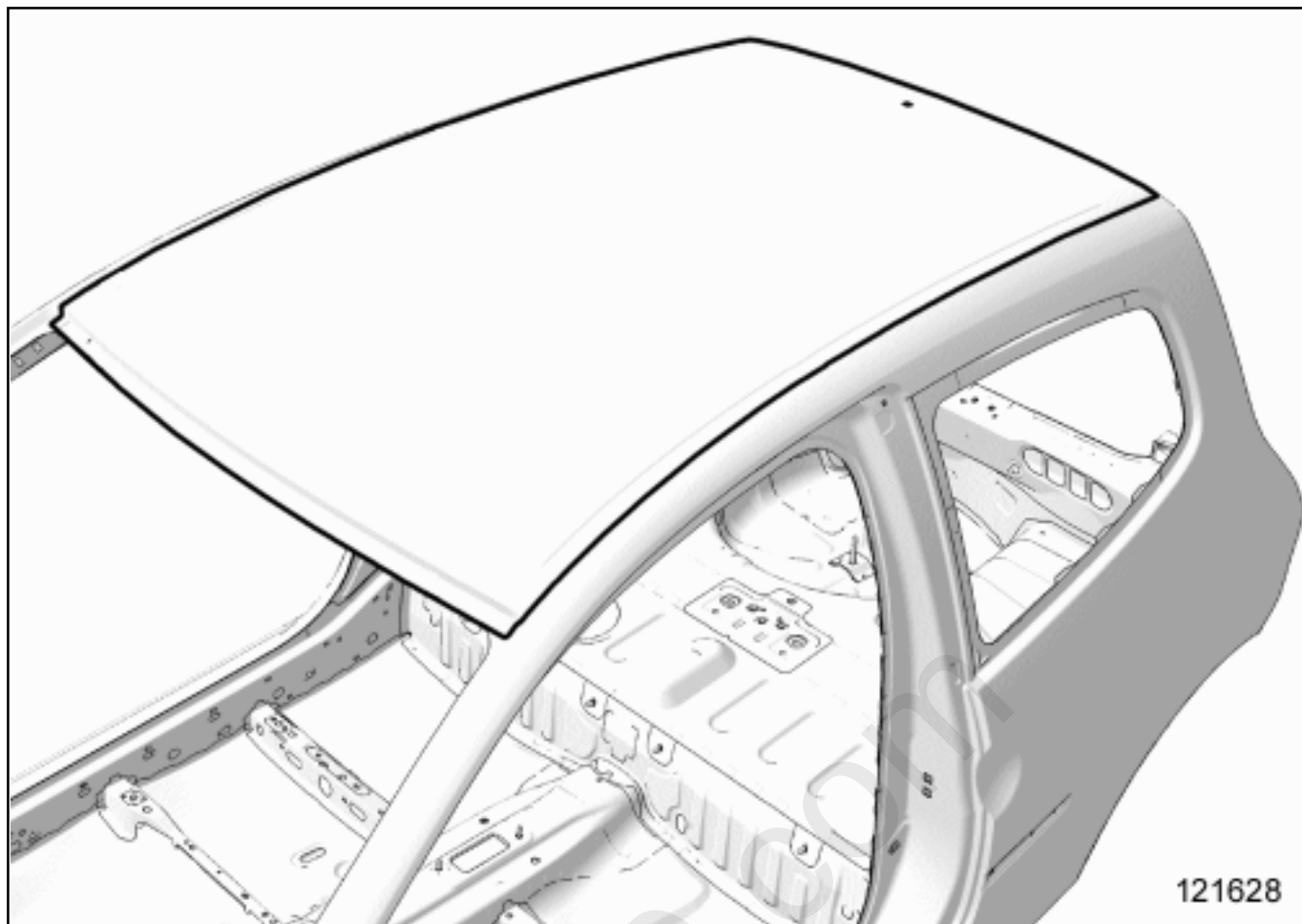
Smooth the high performance structural adhesive using a small brush.



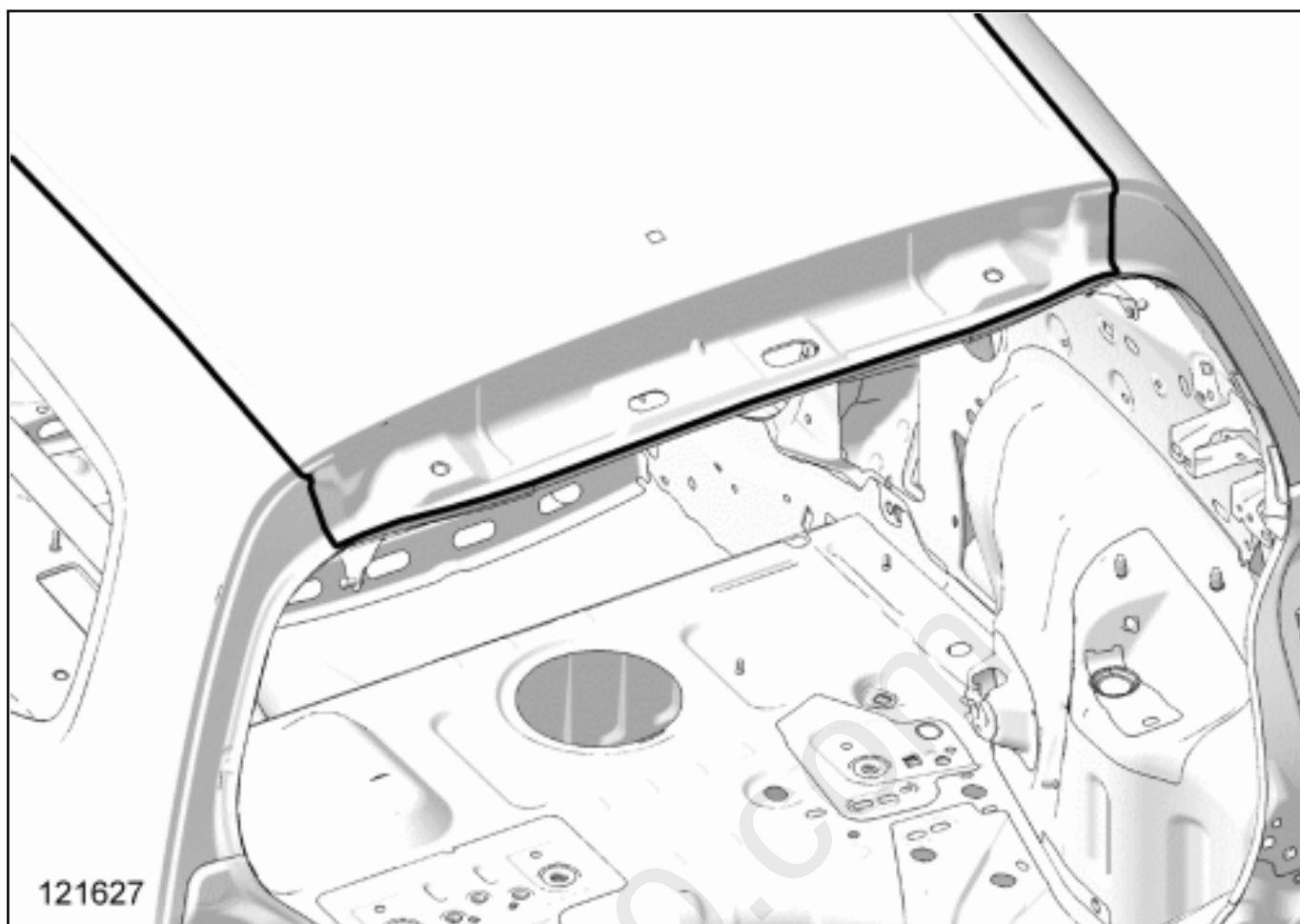
Apply a bead of high performance structural adhesive to the spare part.

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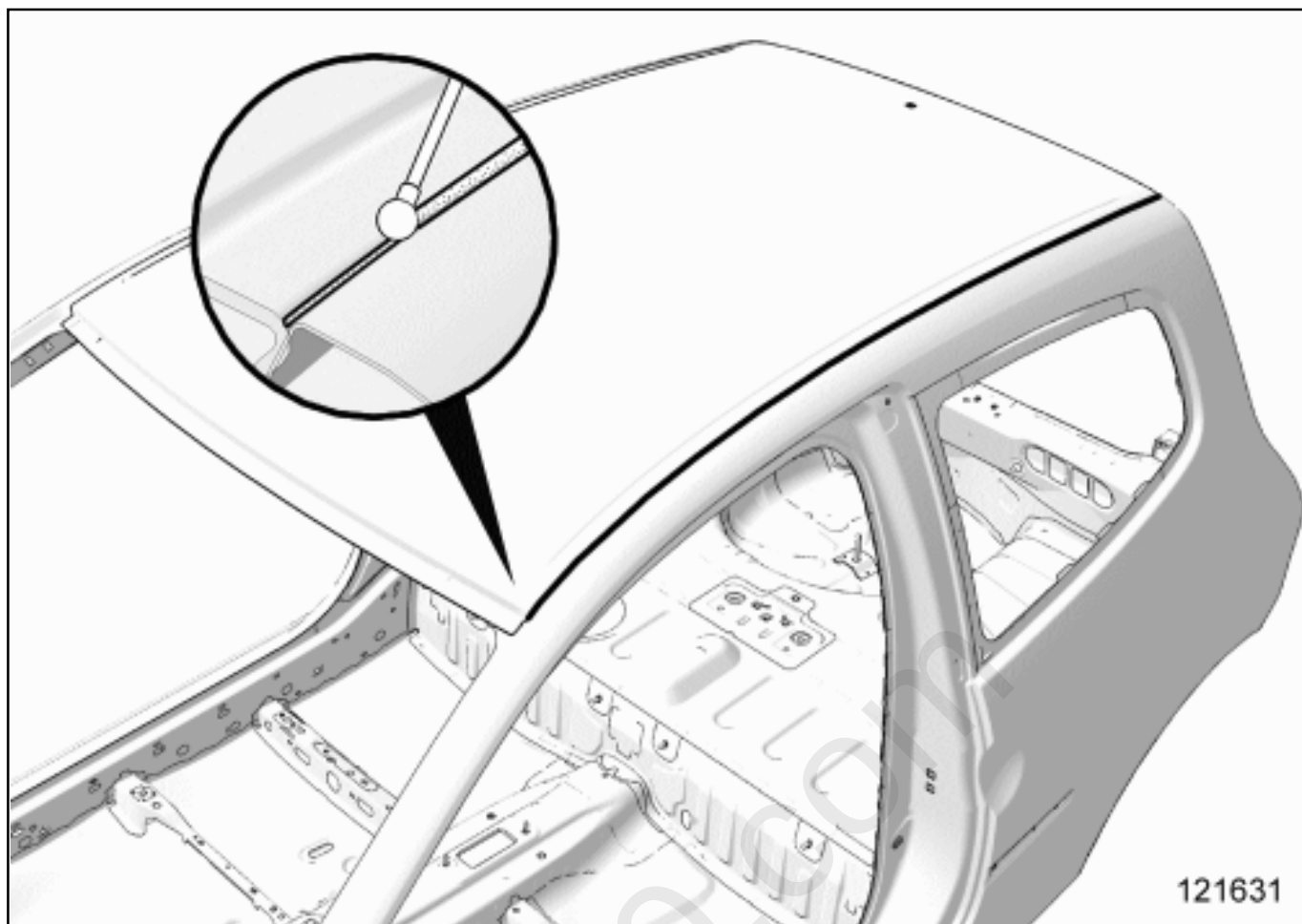
1) FITTING AND ADJUSTING THE REPLACED PARTS



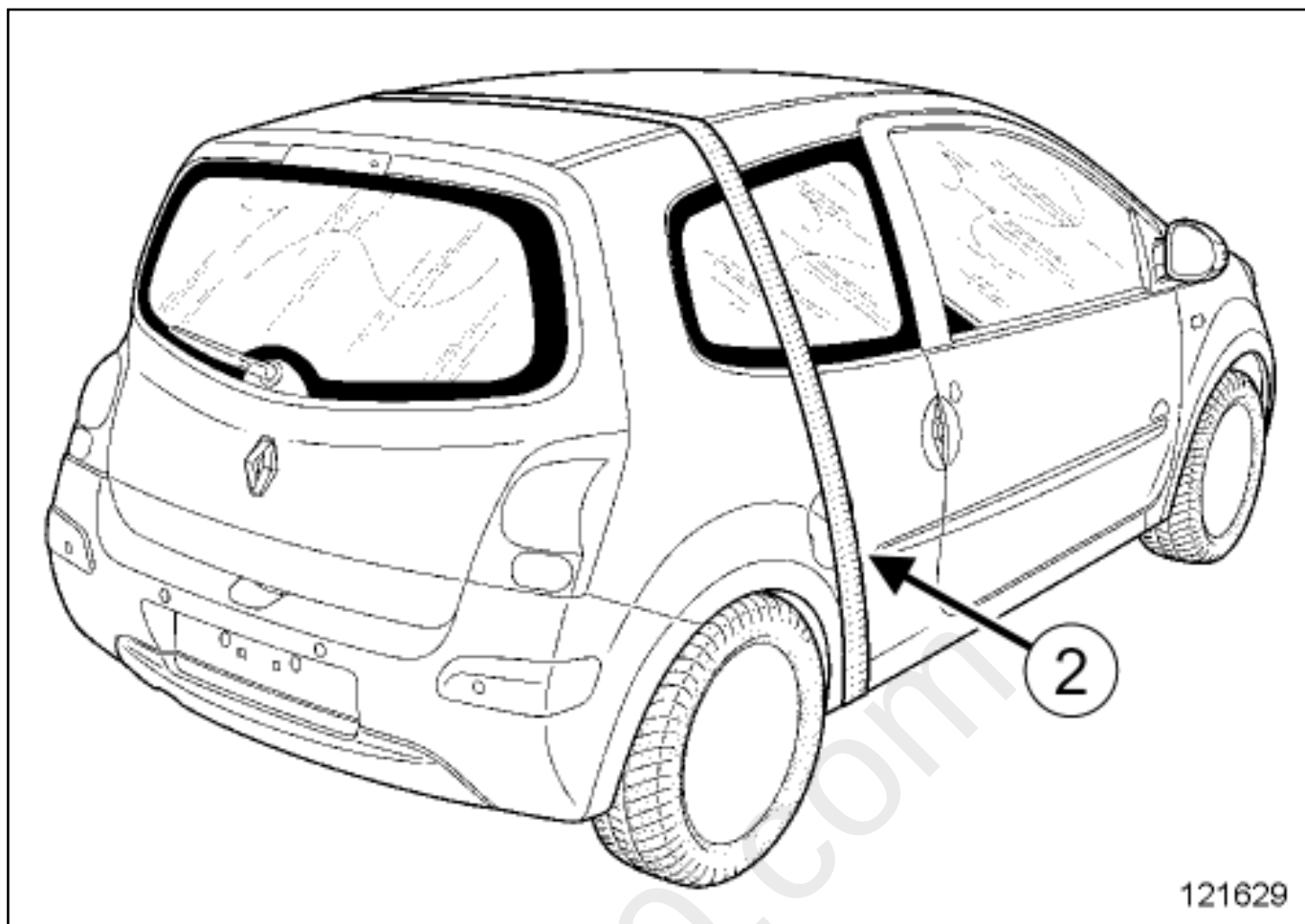
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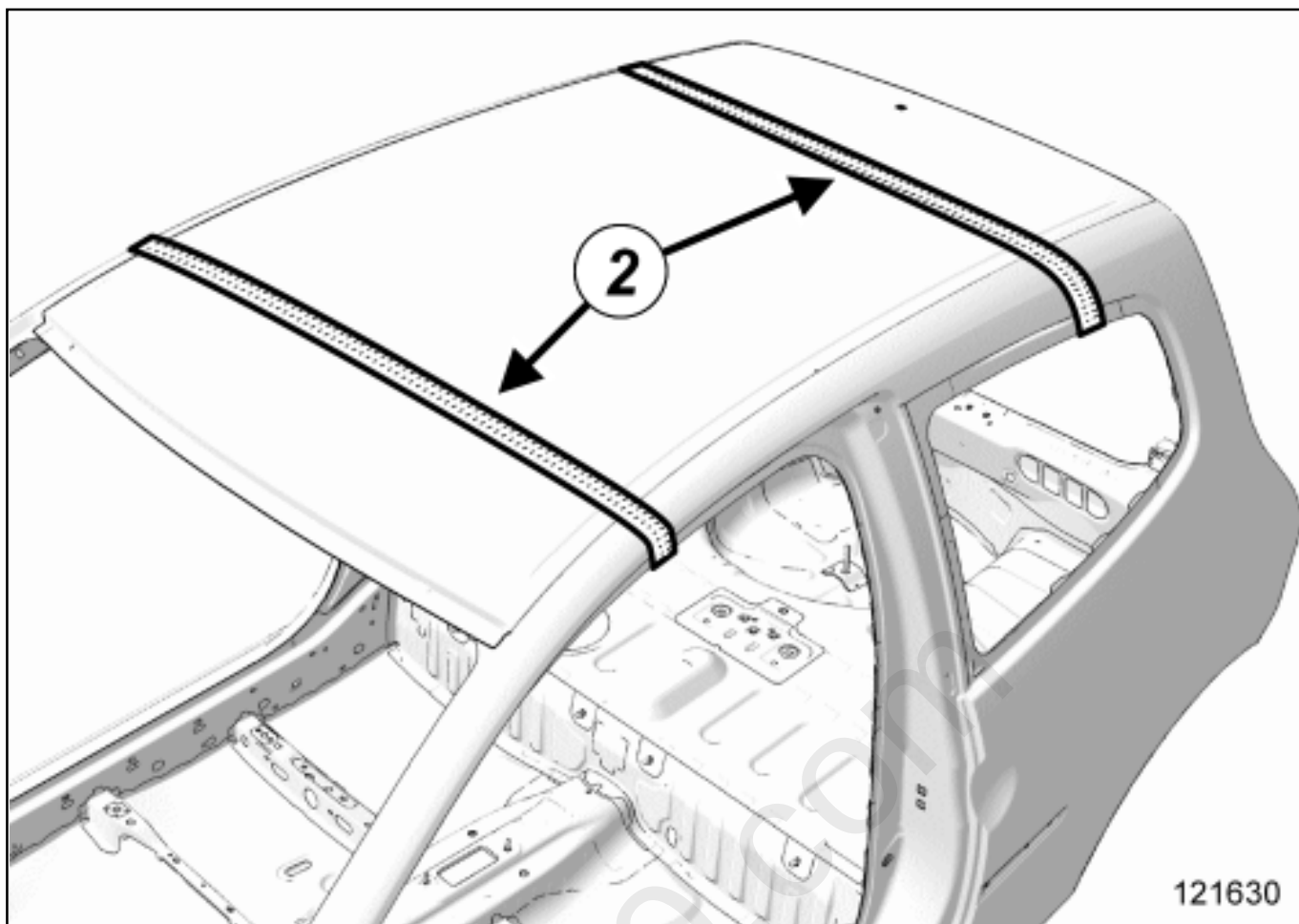
Position the replacement part on the vehicle.



Scrape off the surplus adhesive before it dries using the Levelling tool for bodywork seal (Car. 1786) .



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Hold the replacement part with the locking pliers (at the front and rear cross members) and the safety strap (s) to position it securely according to the markings made earlier ([see 05B, Equipment and Tools, Tools for adjusting and supporting a structural component: Use](#)) (MR400, 05B, Bodywork equipment and tooling).

Note:



To fit the safety straps without removing the quarter panel windows, use 3 safety straps.

Let the adhesive dry for 10 hours at an ambient temperature or for 2 hours at 60°C.

2) MAKING THE OTHER JOINTS

Make the rest of the replacement part joints.