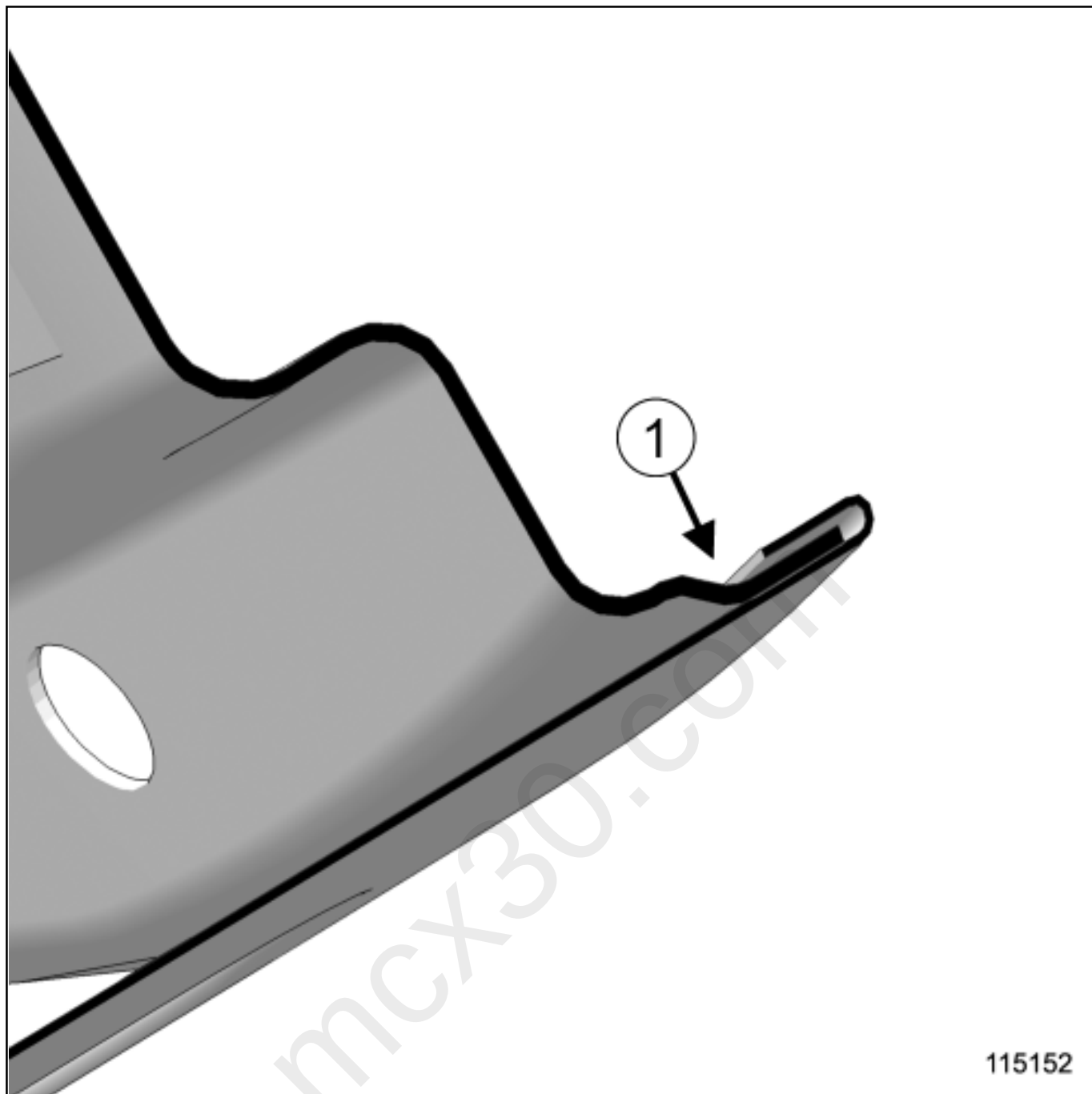




Apply an extruded seal at(1) ([see 40J, Protective devices , Anti-corrosion protection of joints after welding: Description](#)) .



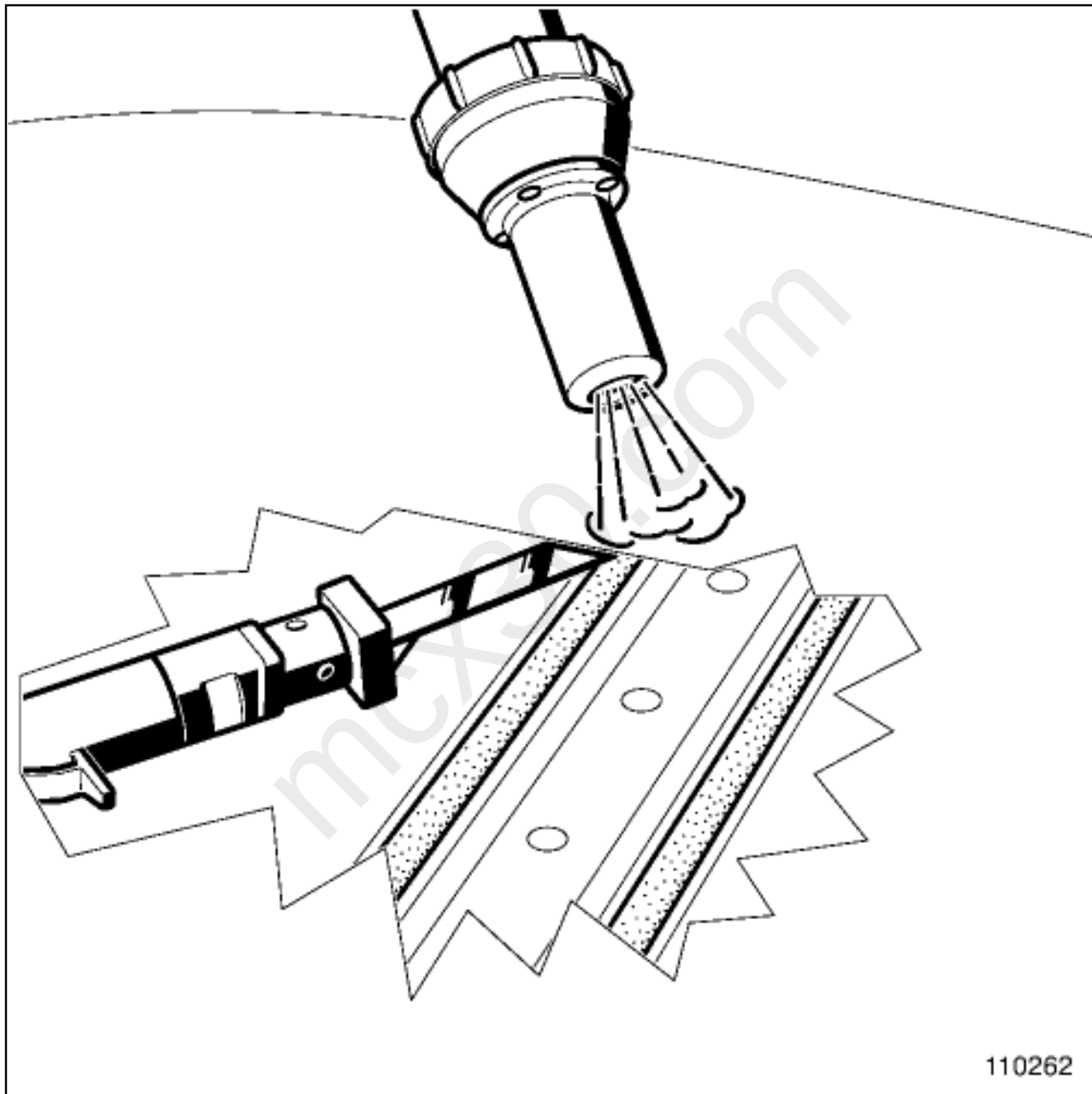
Repair-40x01x30x08-02x21-1-1-1.xml



CONNECTIONS BY SOFT BONDING: DESCRIPTION

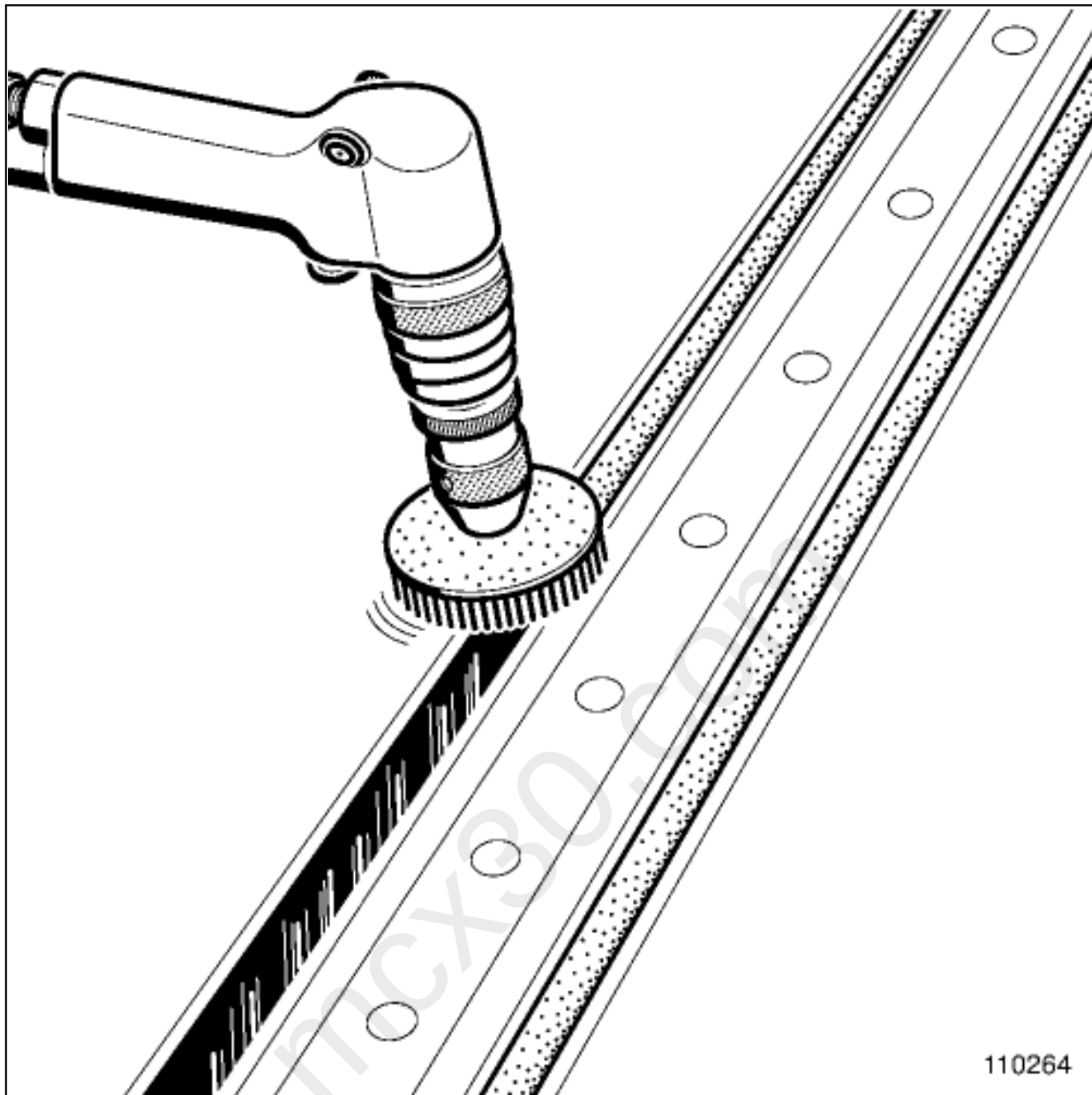
1. DISASSEMBLY

1- CUTTING, SCOURING



Detach the damaged part, by simultaneously heating with a heat stripper to destroy the cement.

2- SCOURING



Using the most suitable tool([see 05B, Equipment and Tools, Tools for stripping very thick soft mastic: Use](#)) , scour the excess cement left on the vehicle.

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.

Measure the distance between the panels at the location of the joint.

Remove the replacement part.

3- PREPARATION OF THE JOINTS ON THE REPLACEMENT PART

Sand using P320 dry sand paper or a red abrasive pad, without removing the cathaphoretic protection.

Clean the joint face with surface cleaner.

4- PREPARATION OF THE JOINTS ON THE VEHICLE

Clean the joint face with surface cleaner.

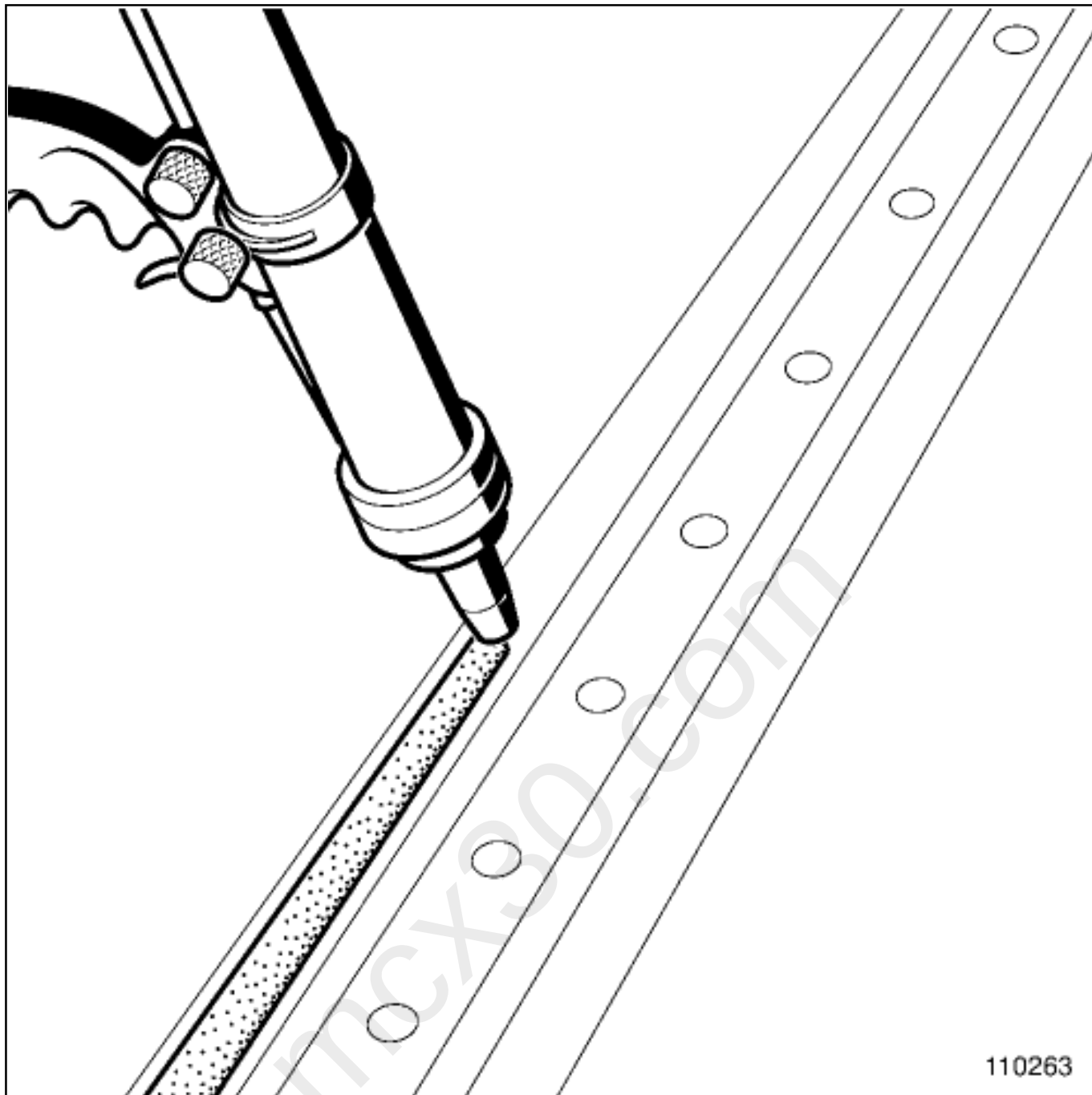
5- APPLY THE PROTECTION BEFORE ASSEMBLY

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 PRODUCTS



On the vehicle mating face apply an even cement bead with a diameter of 4 to 10 mm depending on the distance between the panels measured during the adjustment.

The width of the bead after squeezing depends on the application diameter of the extruded product and on the distance between the panels ([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

Position the part on the vehicle.