

3- FINISHING

Wipe the excess product away using a cloth lightly soaked in surface cleaner.



Repair-40x01x30x05-02x21-1-1-1.xml



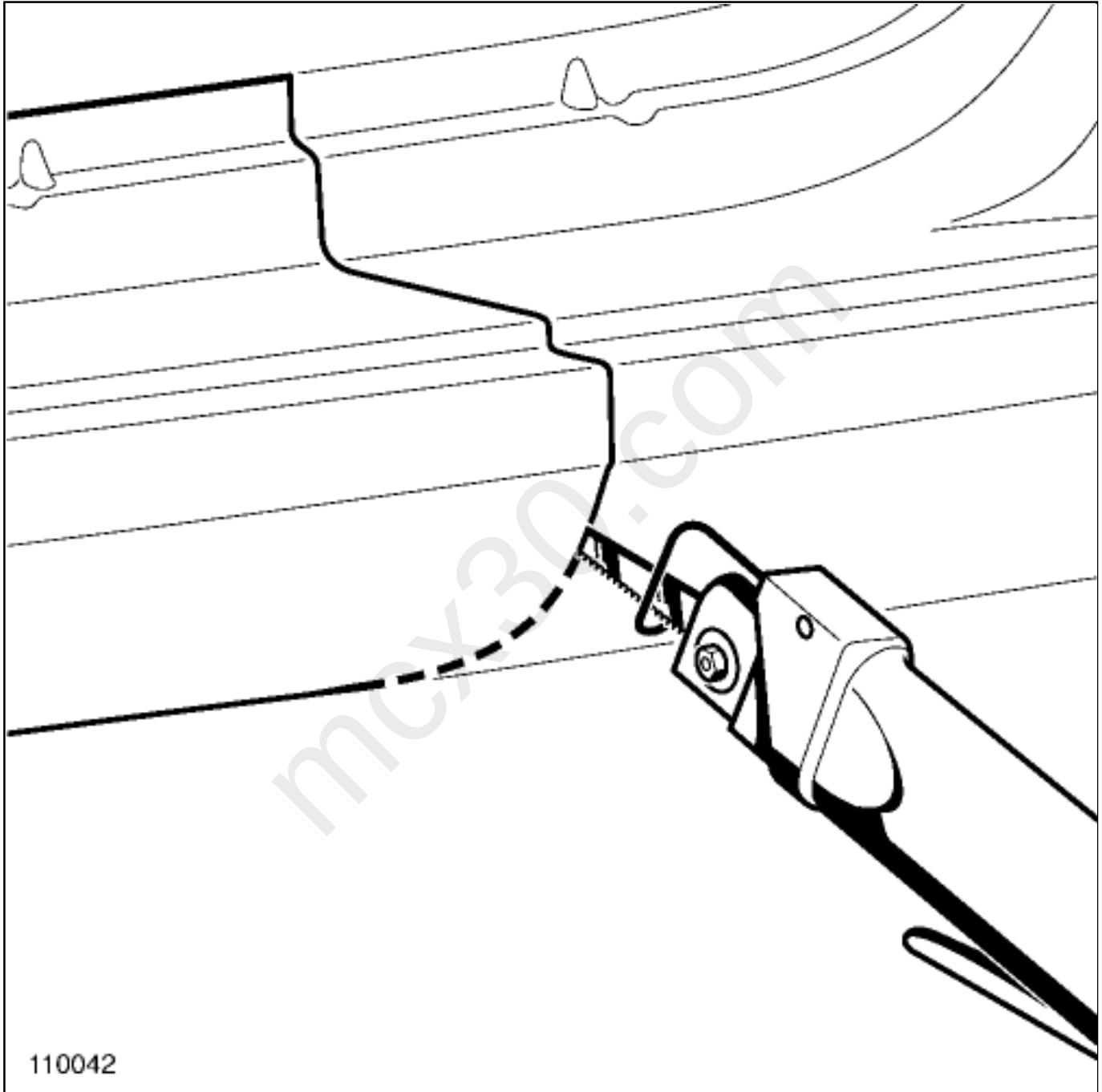
XSL version : 3.02 du 22/07/11

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CONNECTIONS FOR EDGE TO EDGE PARTIAL REPLACEMENTS

1. DISASSEMBLY

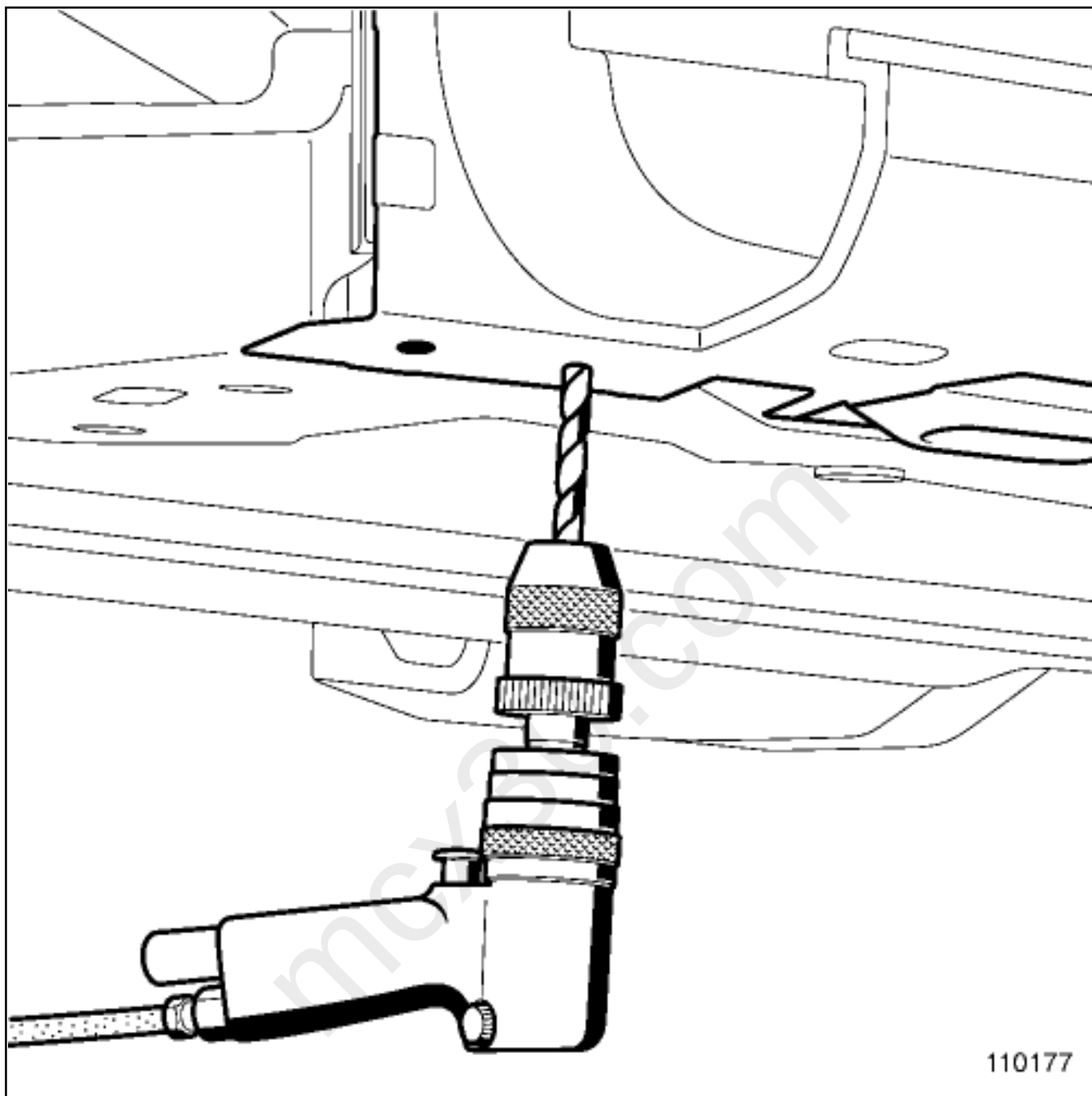
1- CUTTING



Cut the damaged part approximately 25 mm above the cut defined in the MR of the vehicle concerned.

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

2- UNPICKING



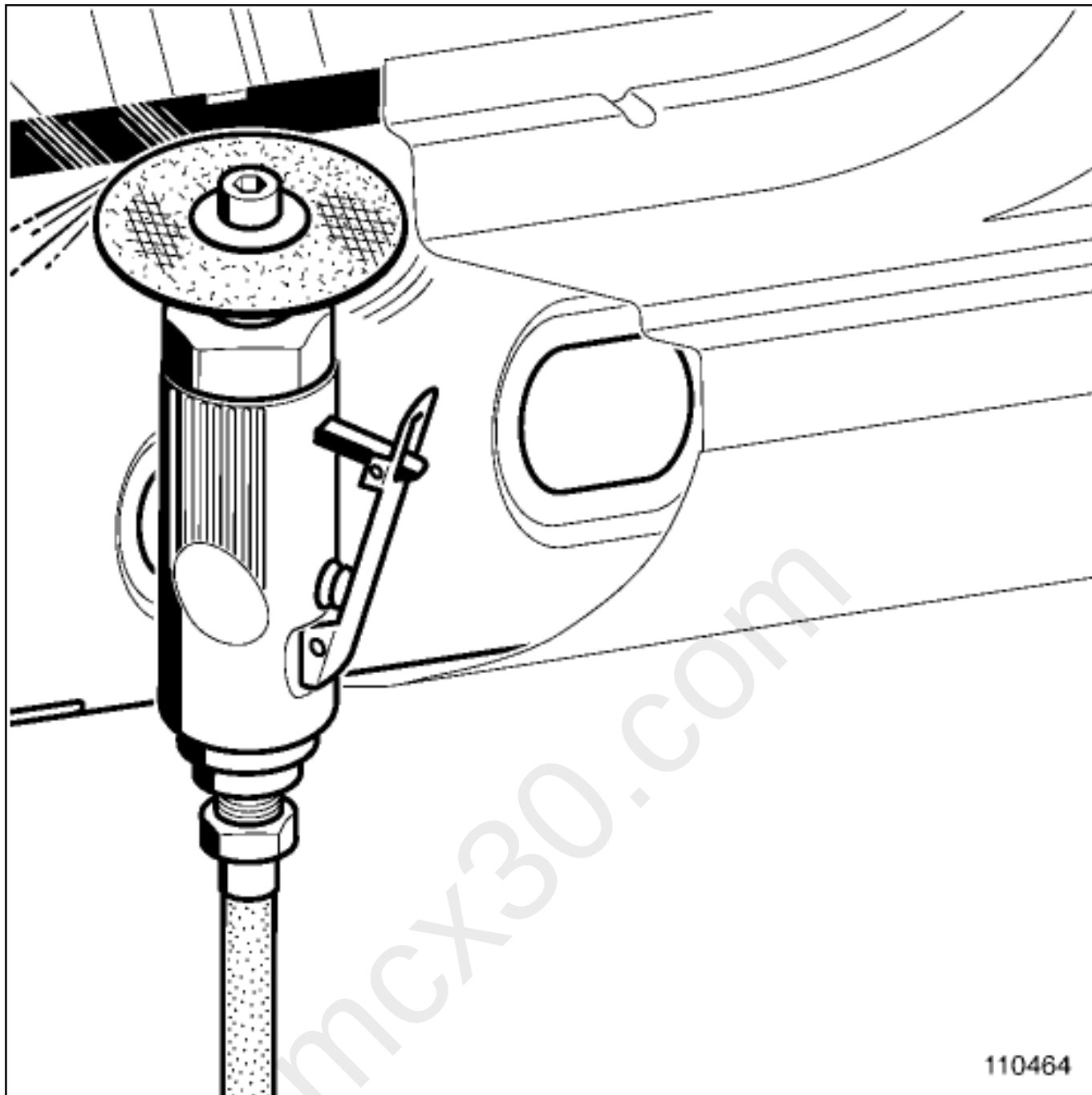
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Unpick the part's welded connections.

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

Remove the damaged part.

3- GRINDING



Level off all the welding residue as well as that left by the cutting.

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

Put the support faces flat so as not to penalise the joint.

Surface the internal mating faces.

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



Note:

Do not strike or damage the panel.

2. PREPARATION BEFORE ASSEMBLY

1- ADJUSTMENT FOR SUPERIMPOSITION CUTTING

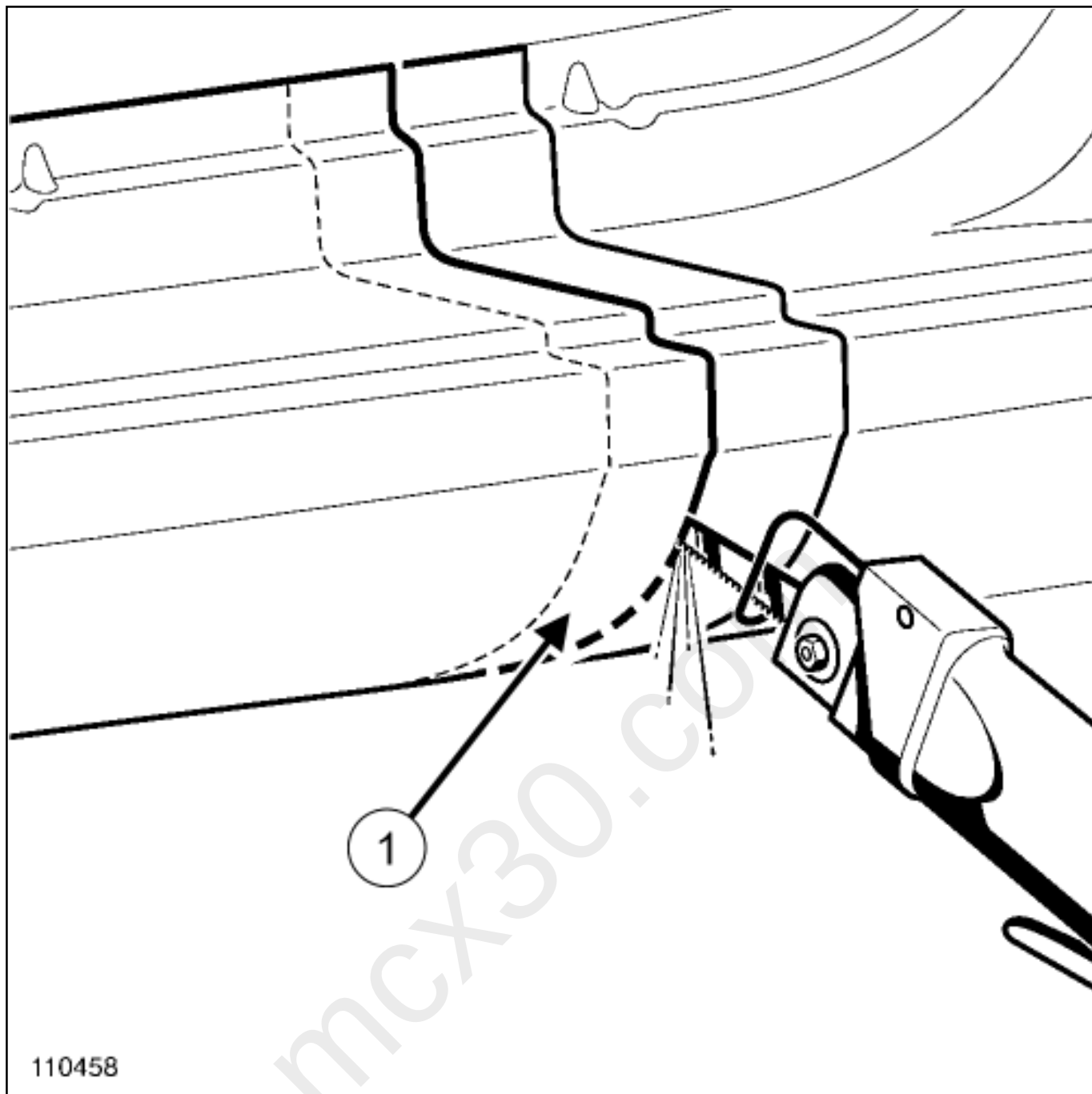
Position the replacement part, adjust it and fix it using the locking pliers.

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)

Mark the mating zones.

2- OVERLAPPING CUT



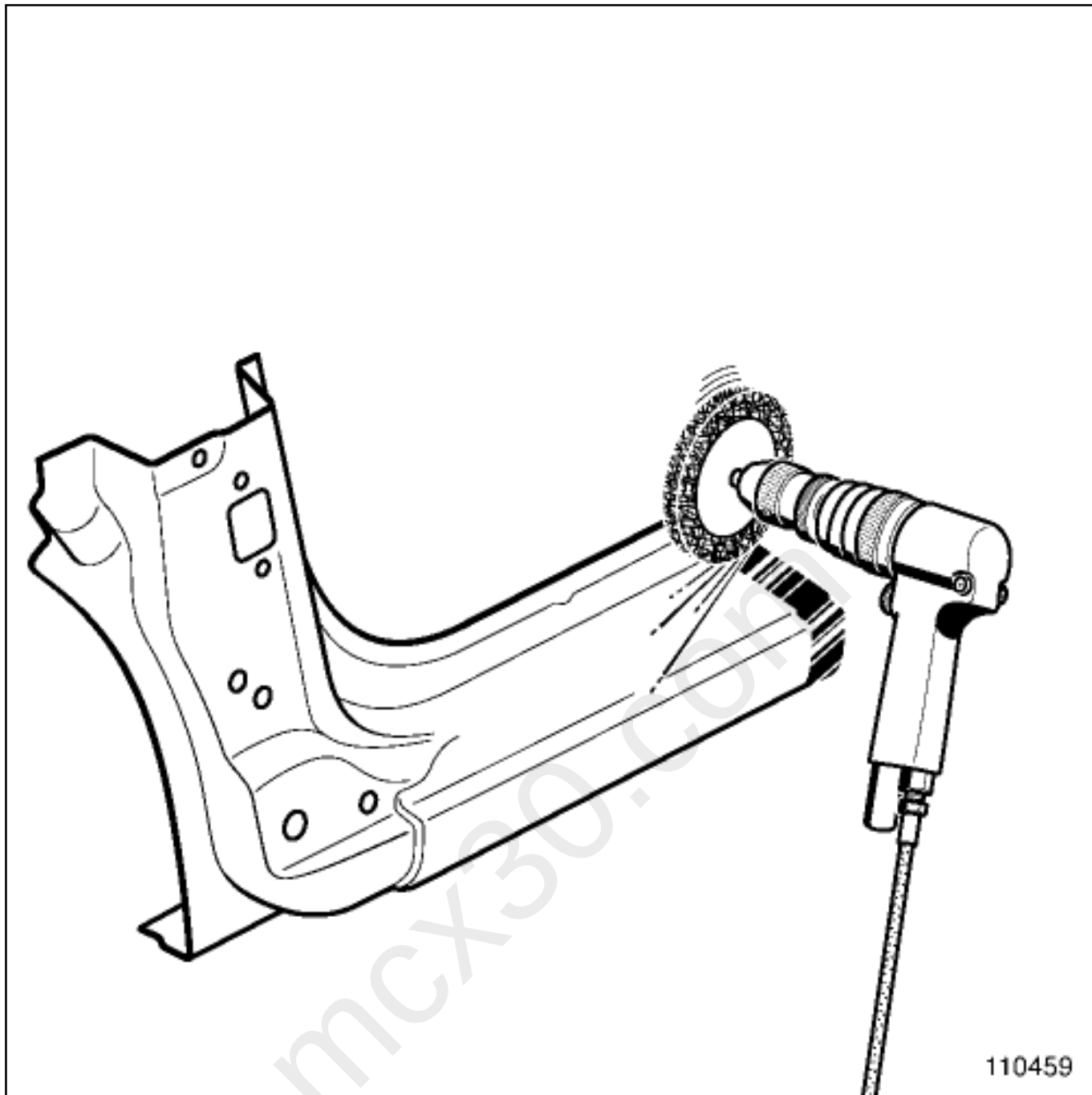
Cut the two parts simultaneously, approximately 25 mm from the cut made on the vehicle.

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

Remove the part and detach the panel cut off(1) on the vehicle.

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

3- PREPARATION OF THE JOINTS ON THE REPLACEMENT PART

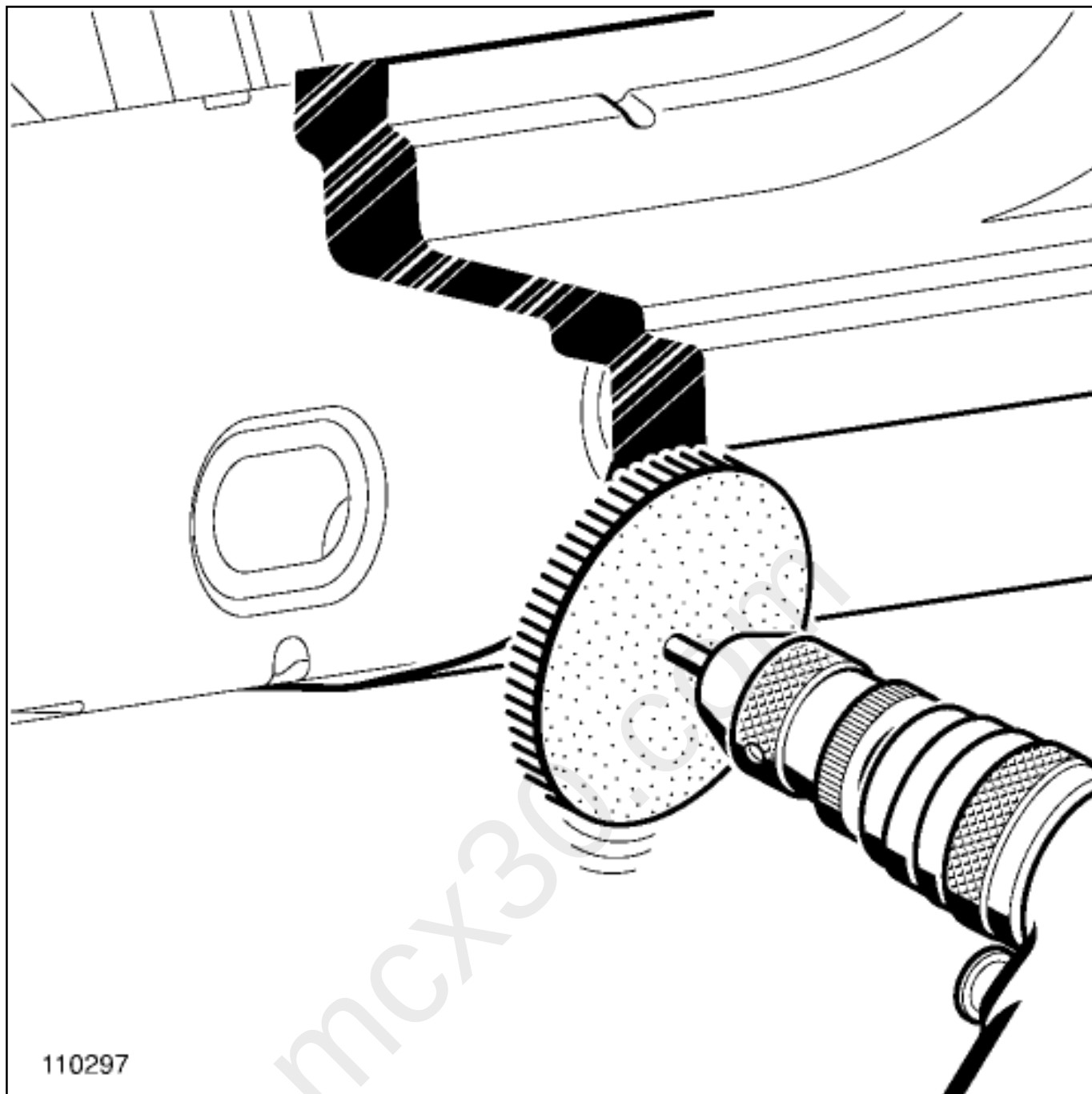


Scour the external face around the edge to edge cutting.

(see **Tools for stripping hard mastics and paint: Use**)

Prepare the rest of the replacement part, according to the chosen joint types and the available access to the mating faces.

4- PREPARATION OF THE JOINTS ON THE VEHICLE



Scour the external face around the edge to edge cutting.

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

(see Tools for stripping hard mastics and paint: Use)

Prepare the rest of the vehicle, according the chosen joint types and the available access to the mating faces.

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

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

(see 40J, Protective devices , Structural acoustic protection: Description)

Apply the joint anti-corrosion protection according to the type of weld.

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

(see 40J, Protective devices , Anti-corrosion protection of joints before welding: Description)

3. ASSEMBLY

1- ADJUSTING THE WELDERS.

Butt welding is by GMAW weld bead.

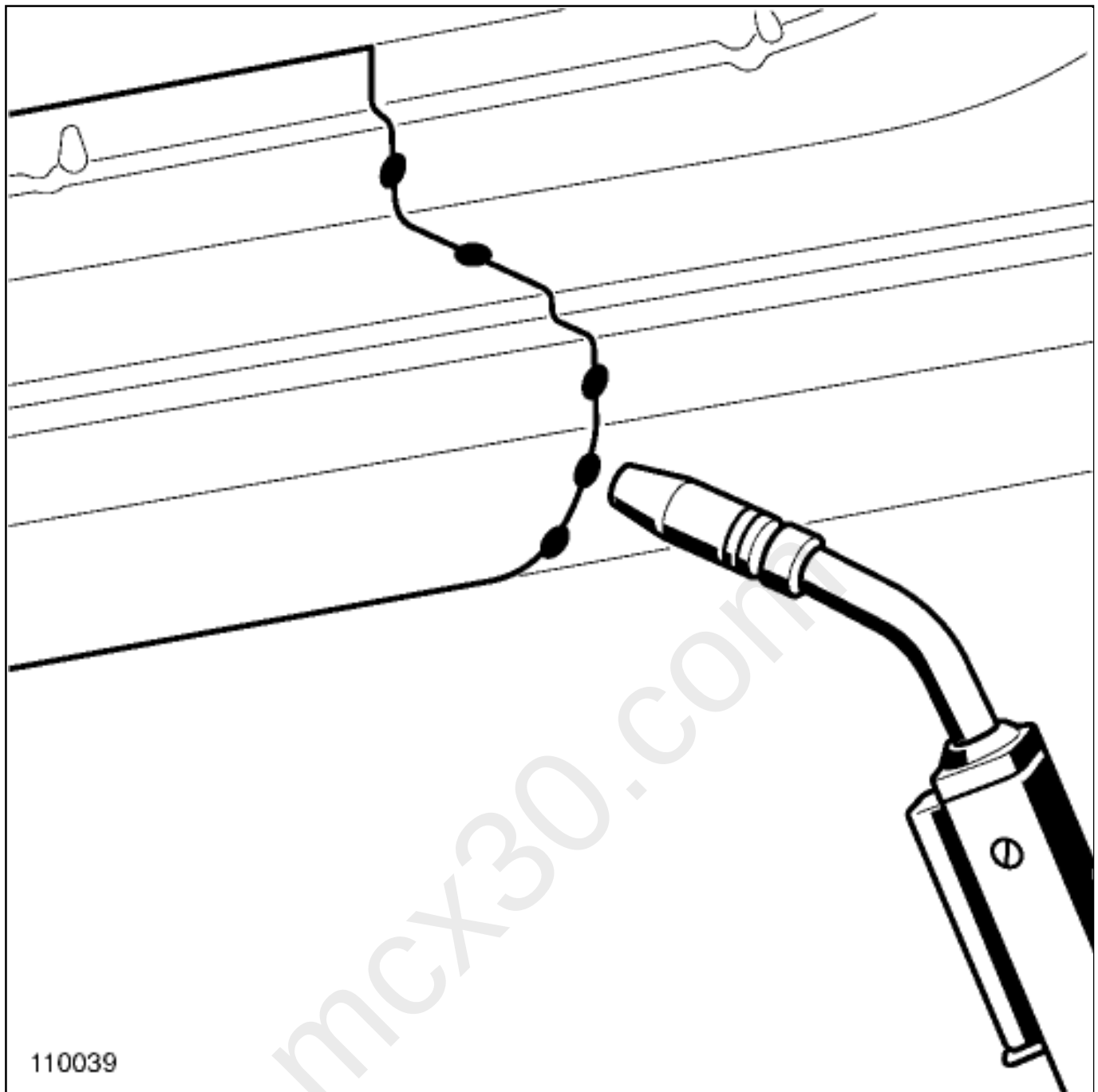
(see 40C, Gas metal arc welded connections, Connections by arc welding under shielding gas: Precautions for the repair)

2- FITTING AND ADJUSTING THE REPLACED PARTS

Reassemble, adjust and fix the part in place; 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)

The distance between the two panels at the continuous butt welding locations must be equal to the thickness of the thinnest panel.

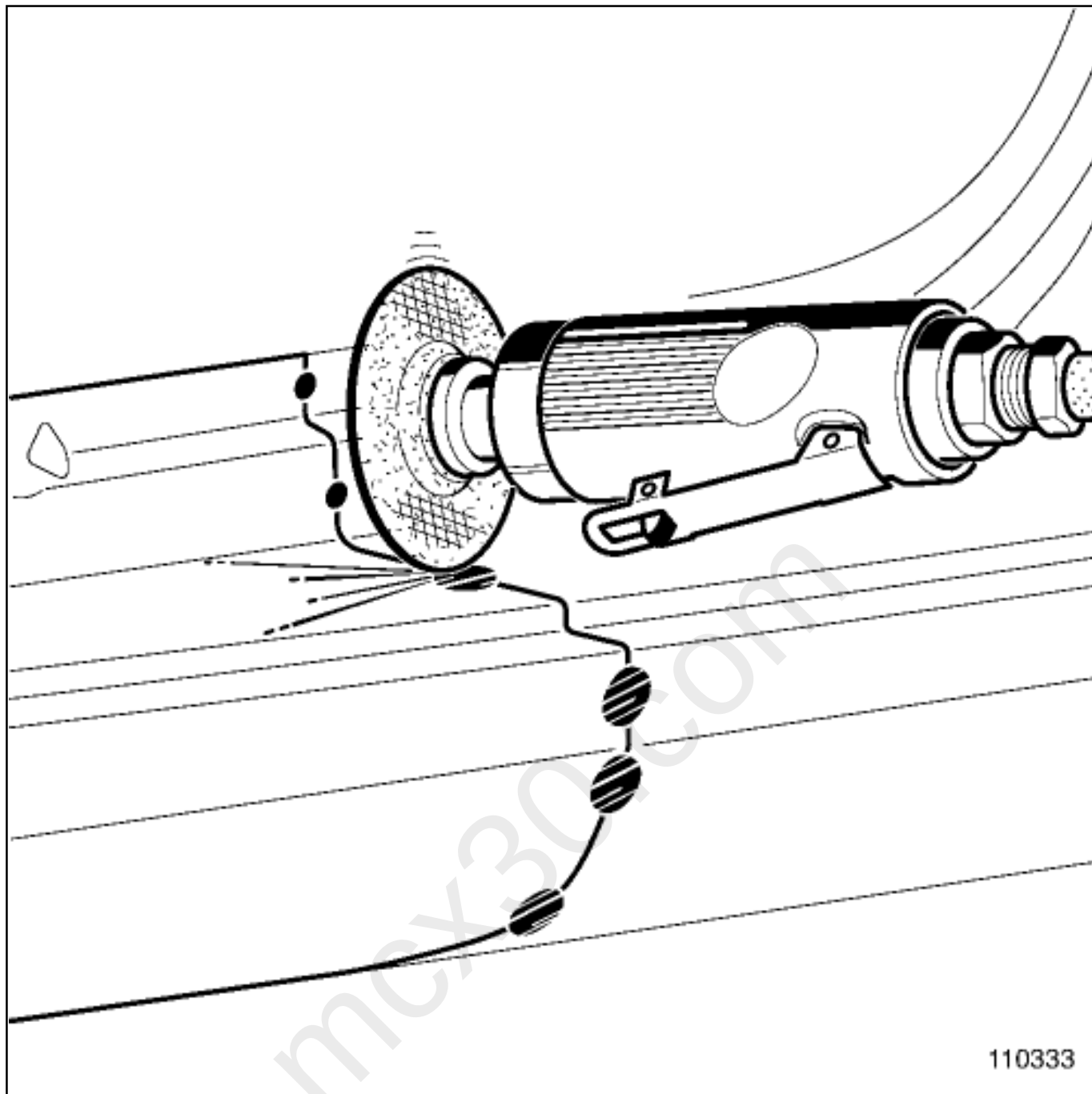


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Tack the panels with spots 20 mm apart, avoiding edges and square corners.

Tack the parts starting from the middle, then make a spot on each side of it alternately.

[\(see 40C, Gas metal arc welded connections, Connections by arc welding under shielding gas: Description\)](#)

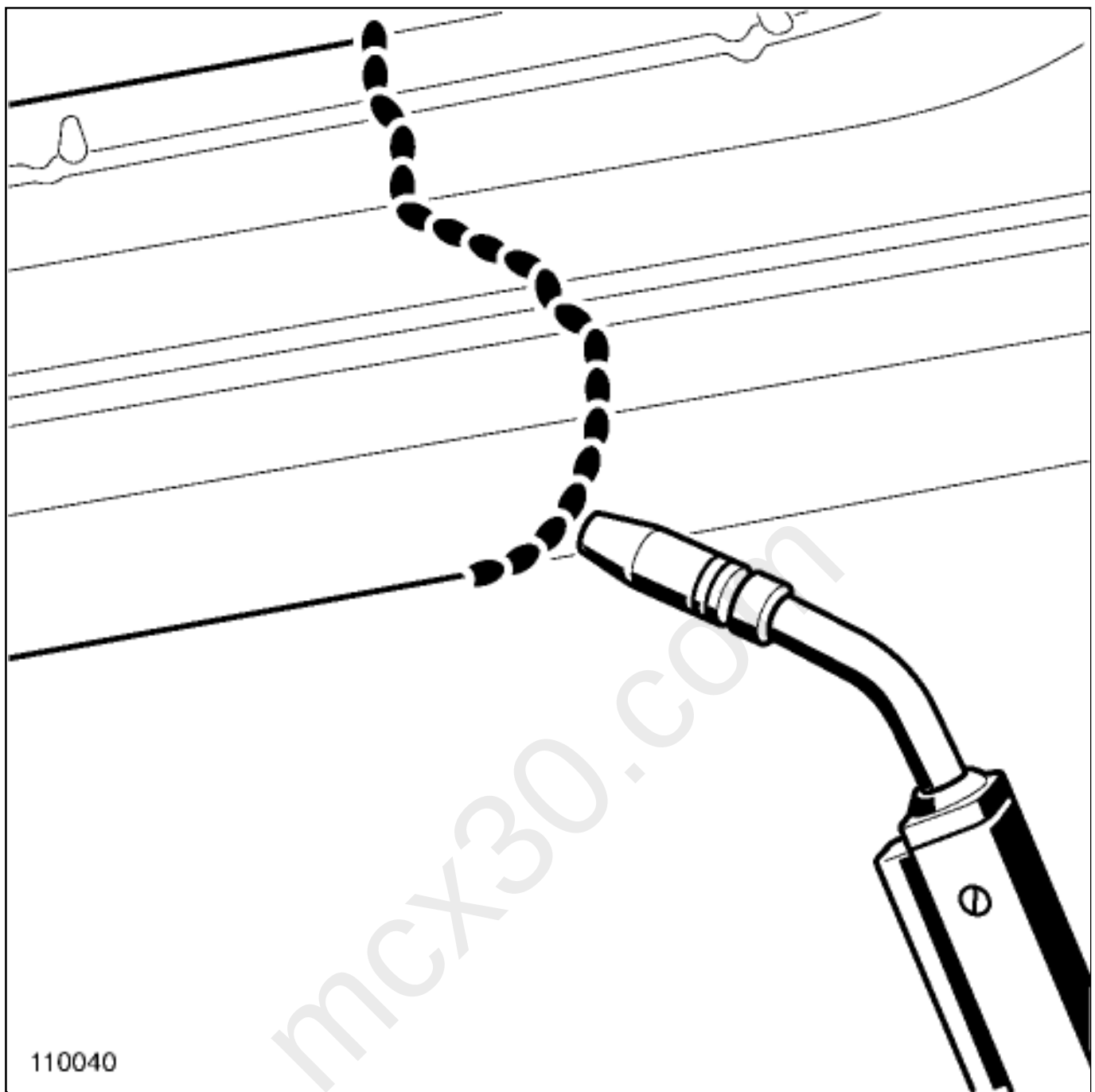


Grind the maintenance points, after checking for good exposure.

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

3- CARRYING OUT THE WELDING

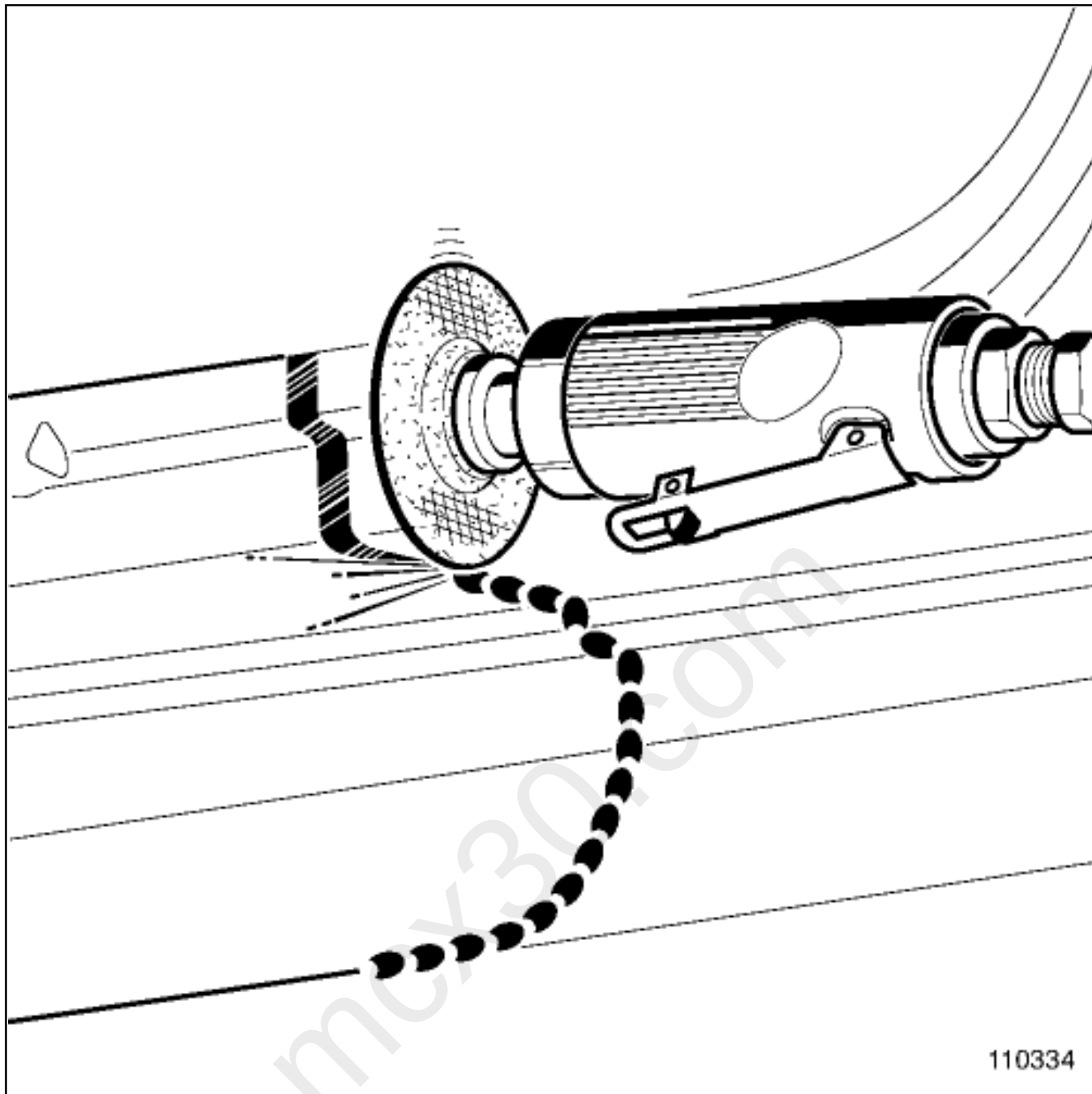
Carry out the different connections of the part.



Carry out the continuous weld, by small sections, if the weld is very long.

[\(see 40C, Gas metal arc welded connections, Connections by arc welding under shielding gas: Description\)](#)

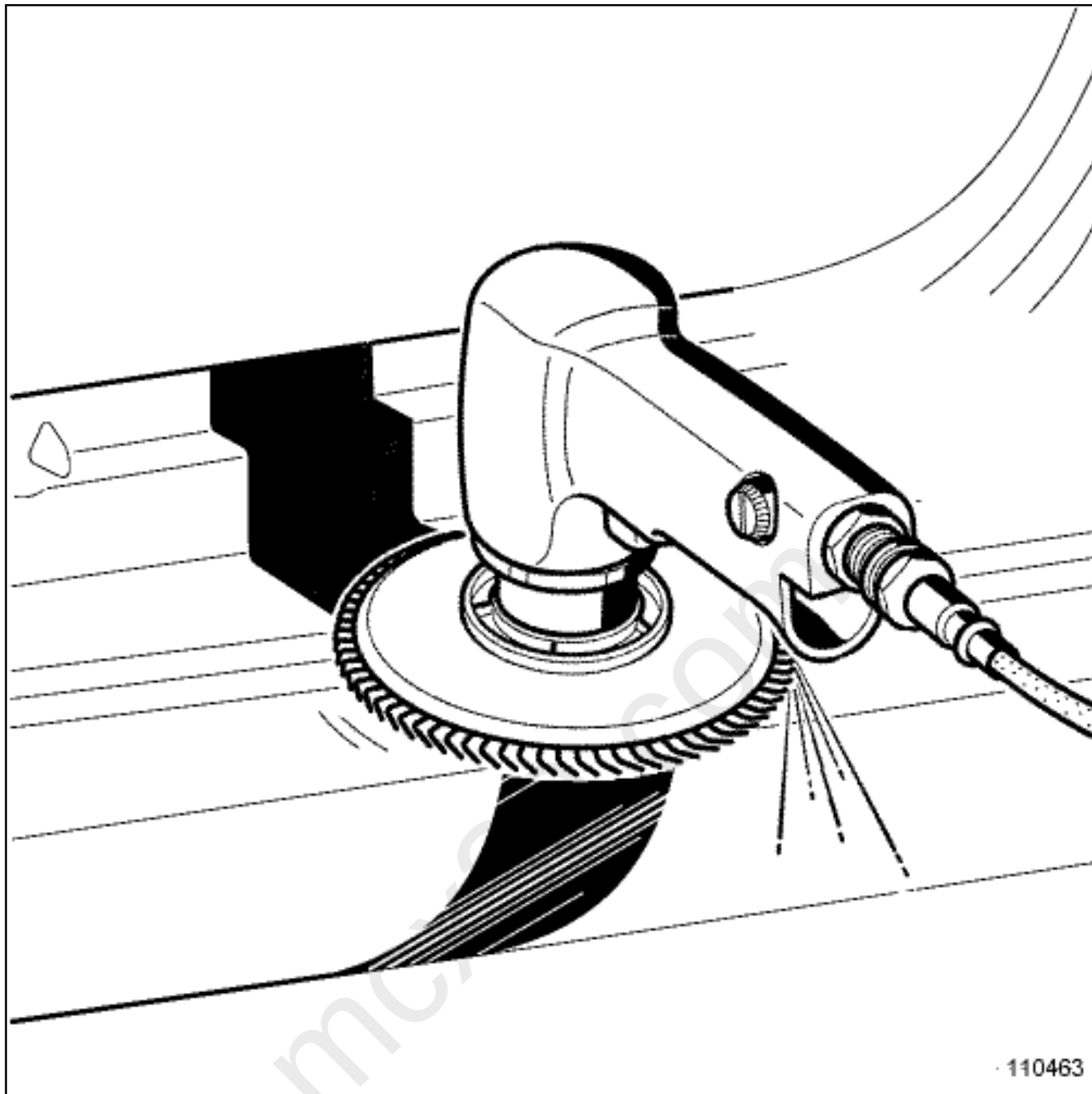
4- GRINDING THE WELDS



Grind the continuous weld.

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

5- FINISHING AND SHAPING



Surface the assembly area.

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



Note:

Do not strike or damage the panel.

If necessary, surface finish the visible parts.