

[\(see 04F, Bodywork products and mountings, Panelwork finishing products: Use\)](#) [\(see 05B, Equipment and Tools, Tools for sanding a structural component: Use\)](#)

6- FITTING PROTECTION AFTER ASSEMBLY

Apply the anti-corrosion protection.

[\(see 04F, Bodywork products and mountings, Anti-corrosion protection products after assembly: Use\)](#)

[\(see 40J, Protective devices , Anti-corrosion protection of joints after welding: Description\)](#)

Fit the soundproofing.

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

[\(see 40J, Protective devices , Structural acoustic protection: Description\)](#)



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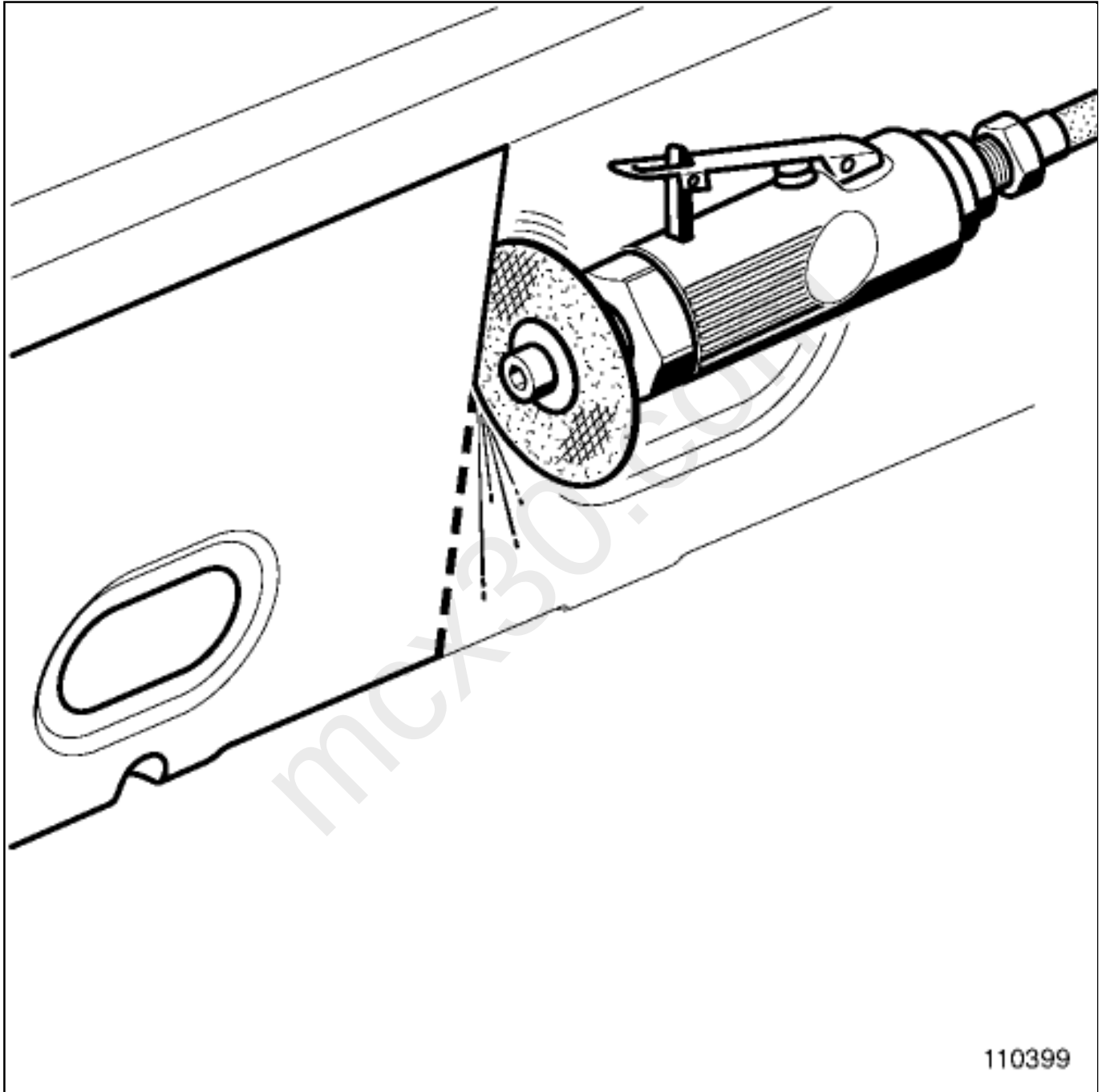


XSL version : 3.02 du 22/07/11

CONNECTIONS FOR PARTIAL REPLACEMENT BY JOGGLING

1. DISASSEMBLY

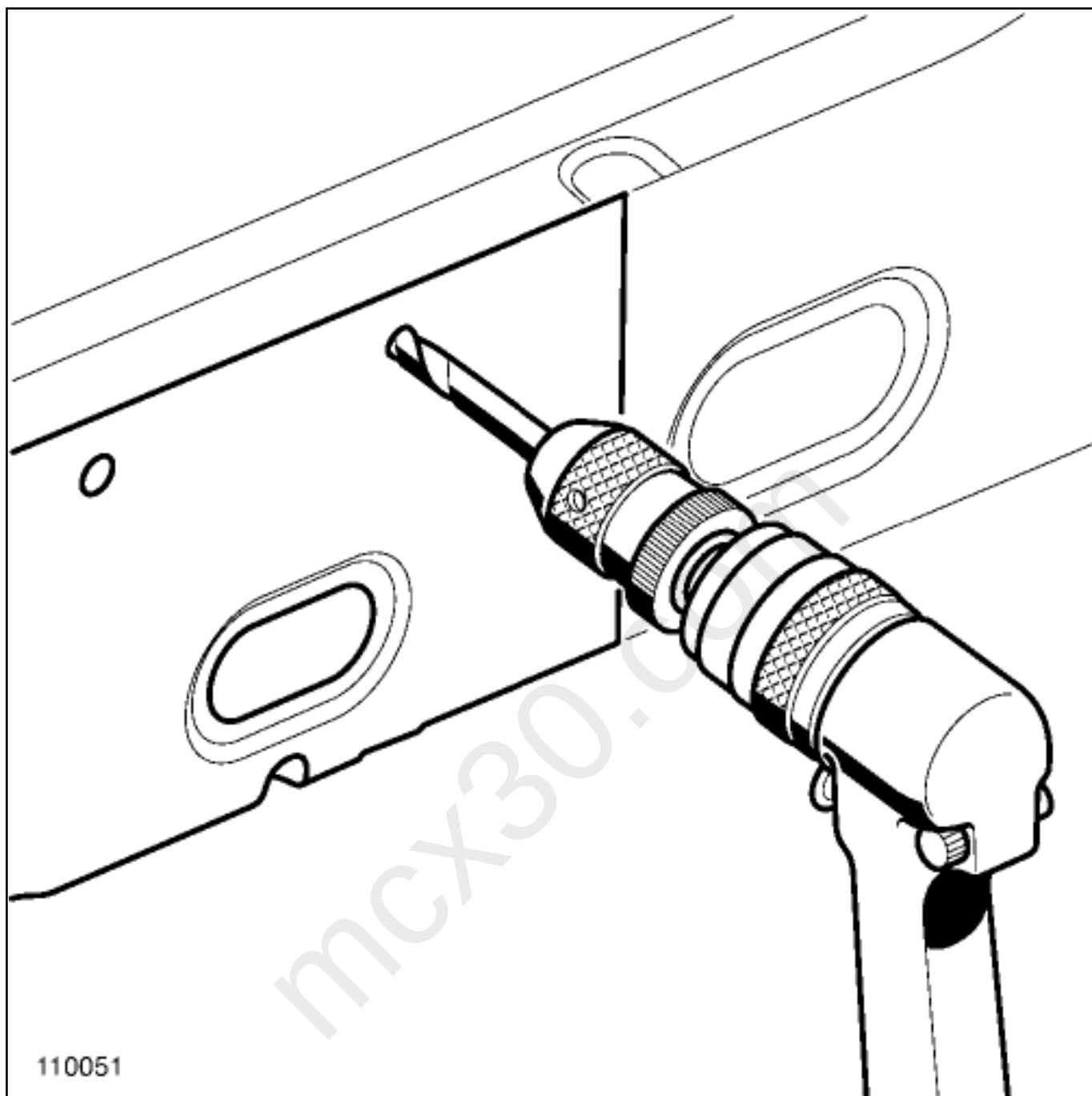
1- CUTTING



Cut the damaged part, adhering to the area defined in the MR of the vehicle concerned.

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

2- UNPICKING

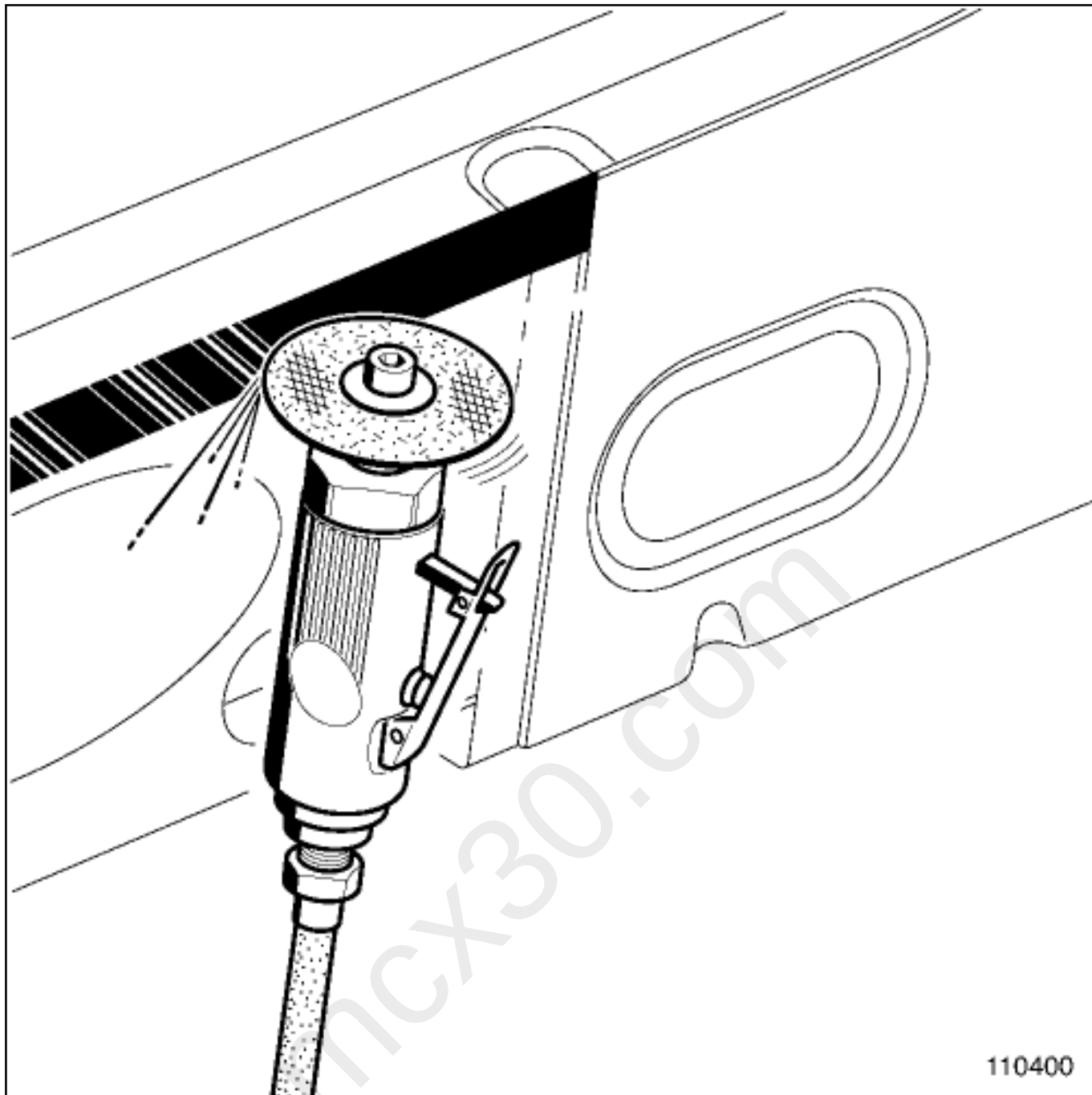


Unpick the retaining points of the damaged part.

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

Remove the damaged part.

3- GRINDING



Level off the welding residue, as well as that from the cut.

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

Surface finish the mating faces.

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



Note:

Do not strike or damage the panel.

2. ASSEMBLY METHOD



The step drilling joint can be made in two ways, depending on the available access to the mating faces:



Two face access, resistance spot welding (RSW).



Single face access, gas metal arc plug welding (GMAW).

In both cases, refer to the indications given in the vehicle MR to find out the weld points.

For visible areas, apply a bead of chain weld (GMAW).

3. TWO FACE ACCESS

1- PREPARATION BEFORE ASSEMBLY

1)ADJUSTMENT BEFORE ASSEMBLY

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

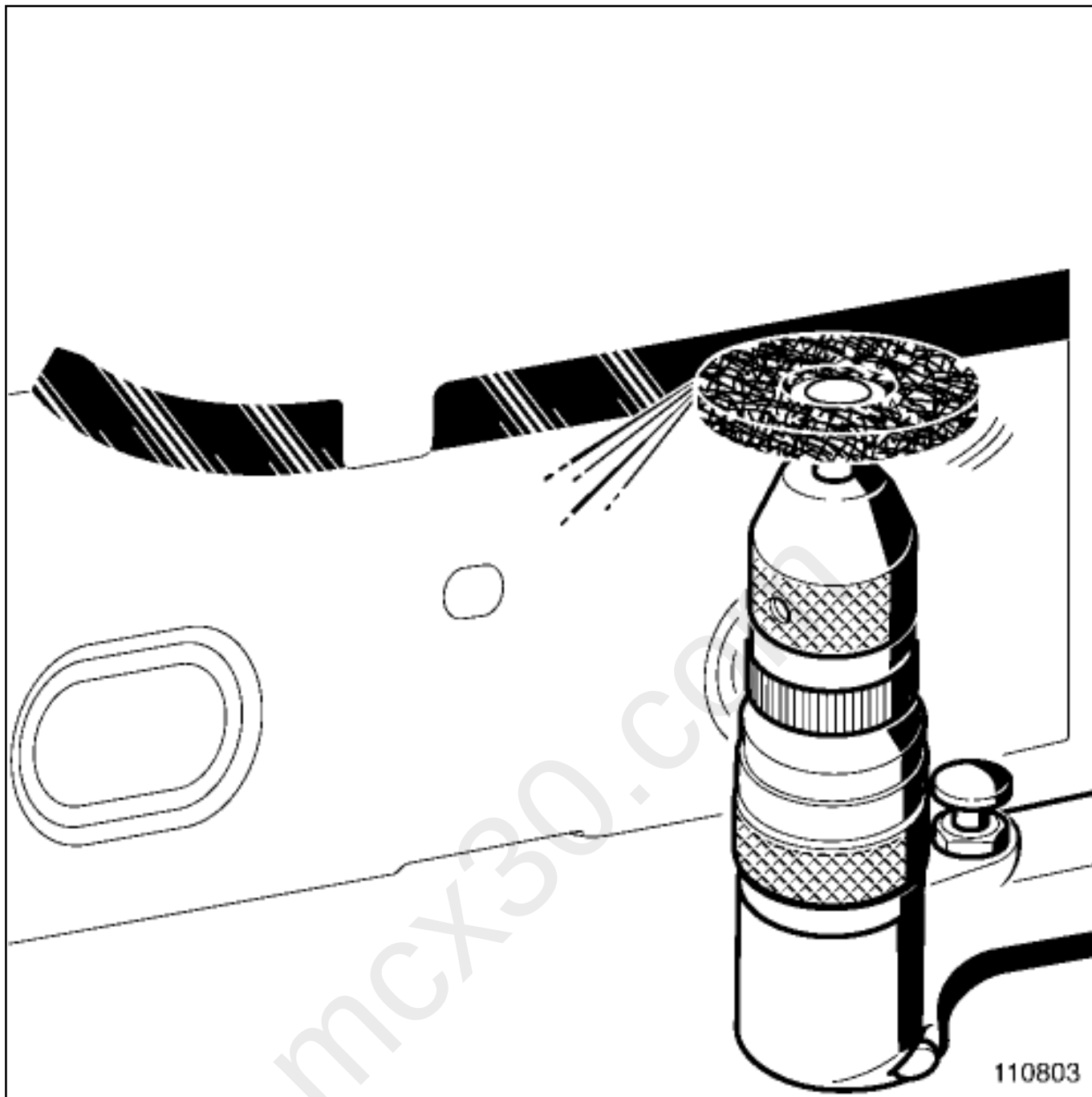
Mark the joint and cut zones.

Remove the replacement part.

3)PREPARATION OF THE JOINTS ON THE REPLACEMENT PART

Cut the replacement part according to the marks.

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

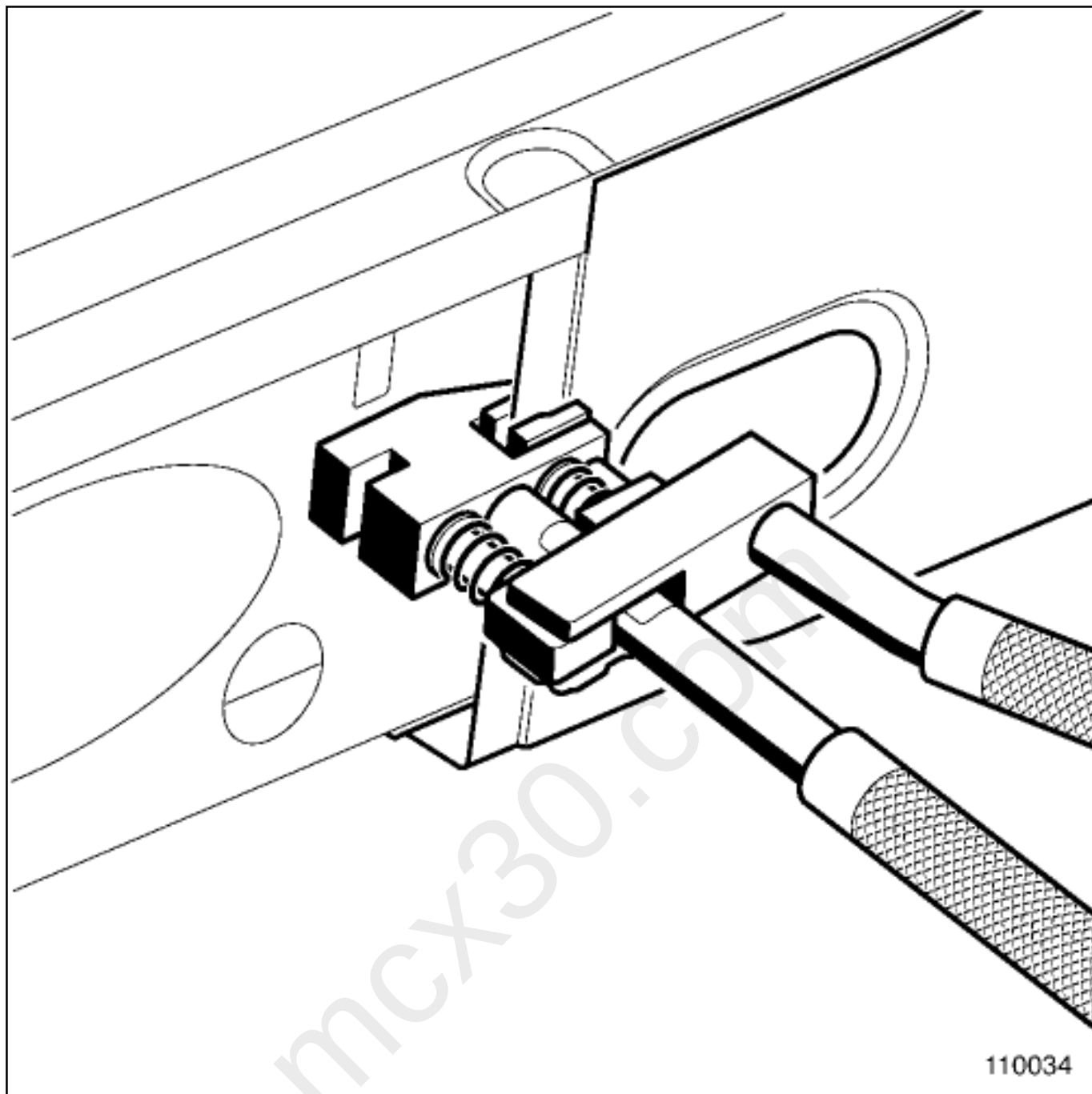


Scour the internal and external mating faces at the drilling location.

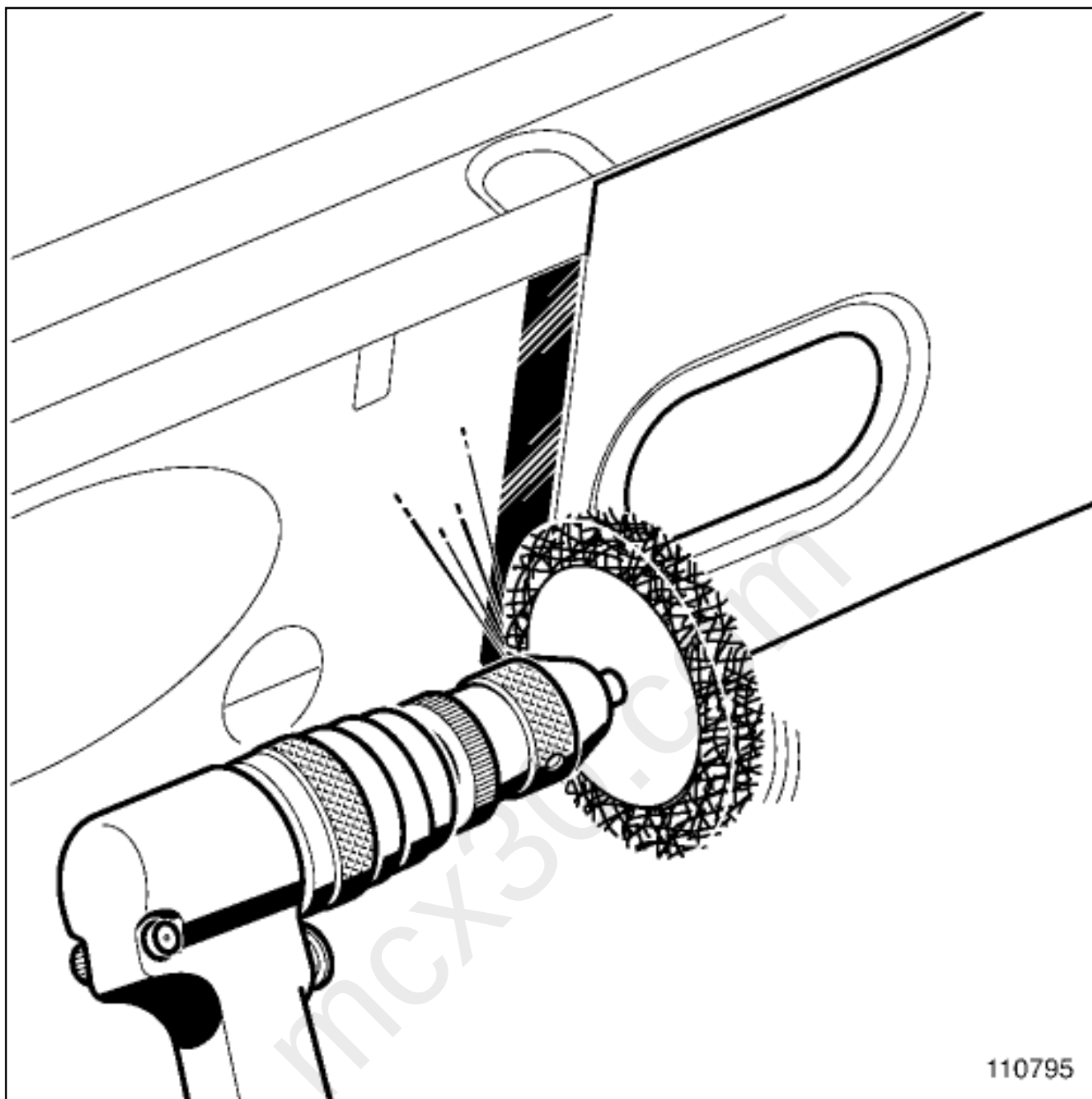
[\(see 05B, Equipment and Tools, Tools for scraping rigid adhesives and paint: Use\)](#)

Prepare the rest of the replacement part according to the chosen joint types, in accordance with the available joint face access.

4)PREPARATION OF THE JOINTS ON THE VEHICLE



Carry out the drilling, at the cutting location.



Scour the internal and external mating faces at the drilling location.

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

Prepare the rest of the vehicle, according to the chosen joint types.

5)APPLYING 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 faces.

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

2- ASSEMBLY

1) FITTING AND ADJUSTING THE REPLACED PARTS

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

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

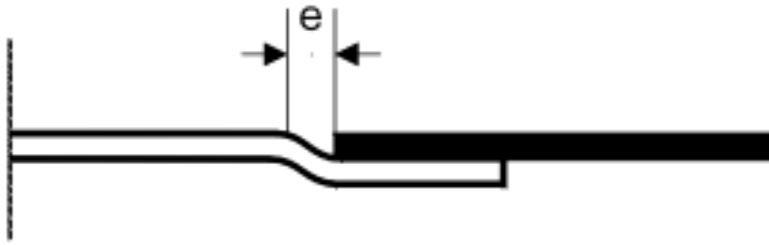
(see 05B, Equipment and Tools, Tools for adjusting and supporting a structural component: Use)

Note:



Leave a clearance(e) between the cut and the step drilling angle.

The clearance should be equal to the panel thickness.



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2)ADJUSTING THE WELDERS

Before making the joints on the vehicle, carry out the tests required for adjusting the welders.

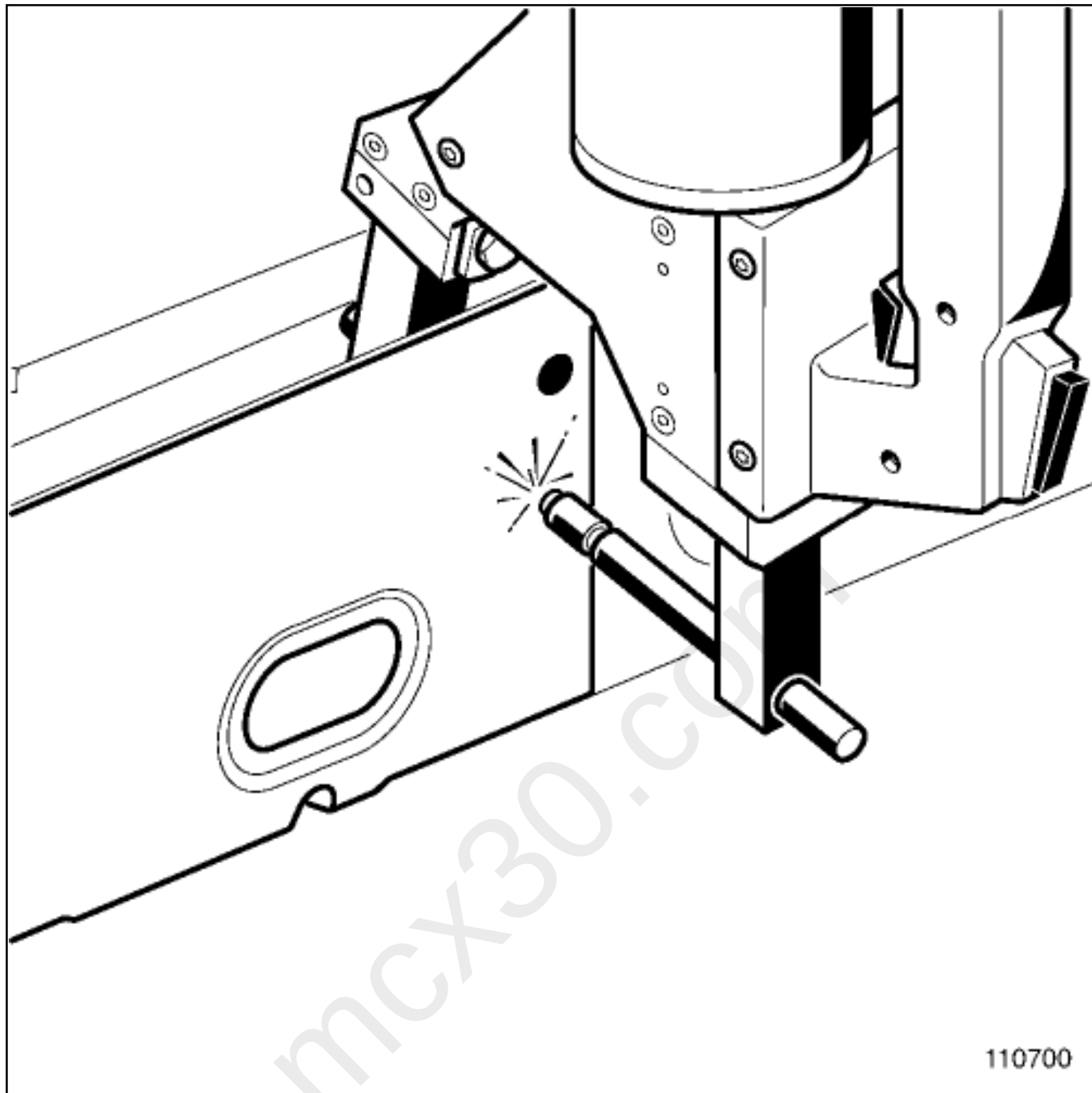
Resistance welding joint.

(see 40B, Electrical resistance welded connections, Electrical resistance spot welding connection: Precautions for the repair)

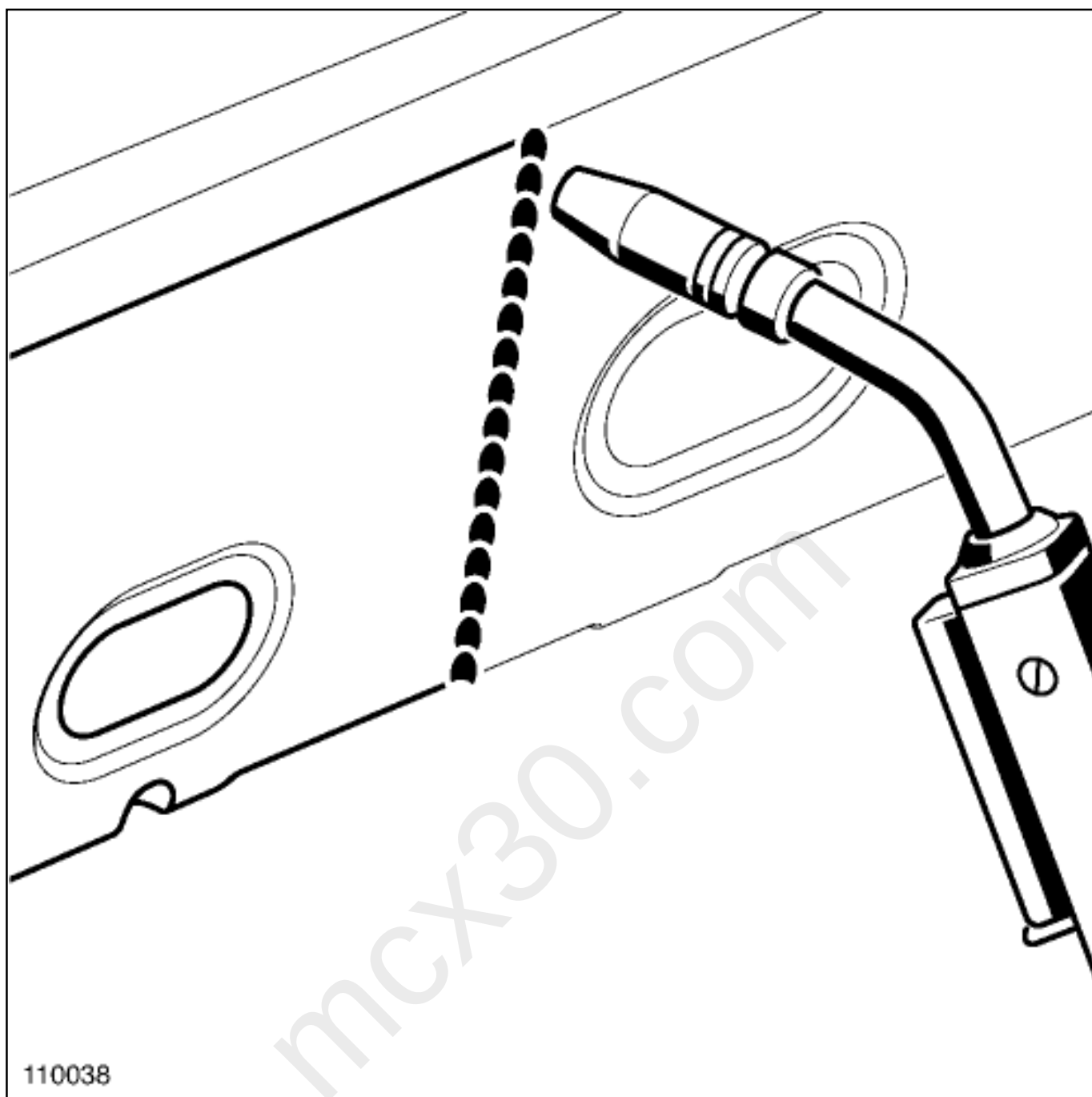
GMAW joint, if necessary with a bead of chain weld in the visible area.

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

3)CARRYING OUT THE WELDING



Weld the replacement part.



Apply a bead of chain weld along the whole cut.

4. SINGLE FACE ACCESS

1- PREPARATION BEFORE ASSEMBLY

1)ADJUSTMENT BEFORE ASSEMBLY

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 and cut zones.

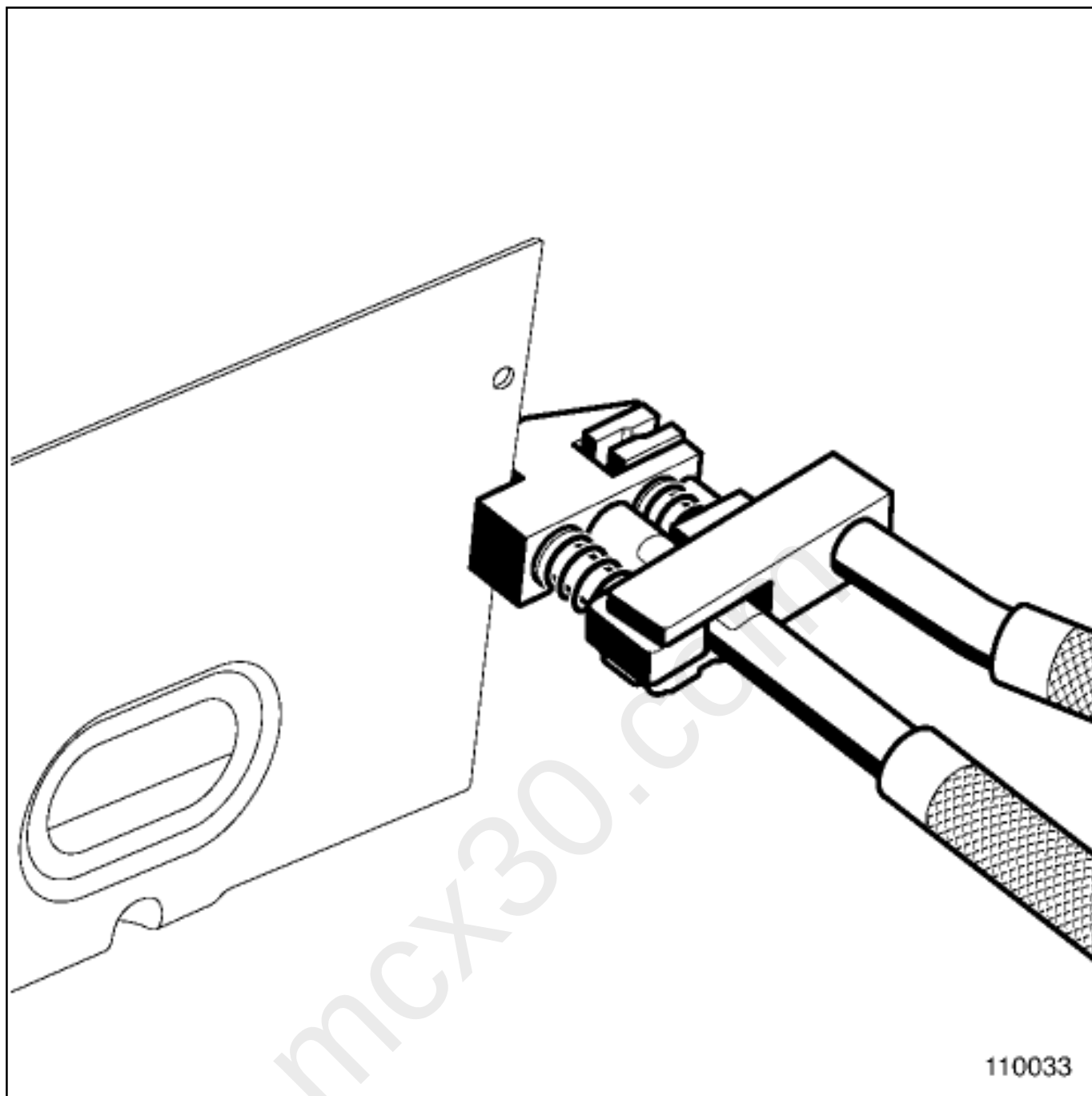
Remove the replacement part.

3) PREPARATION OF THE JOINTS ON THE REPLACEMENT PART

Cut the replacement part according to the marks.

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

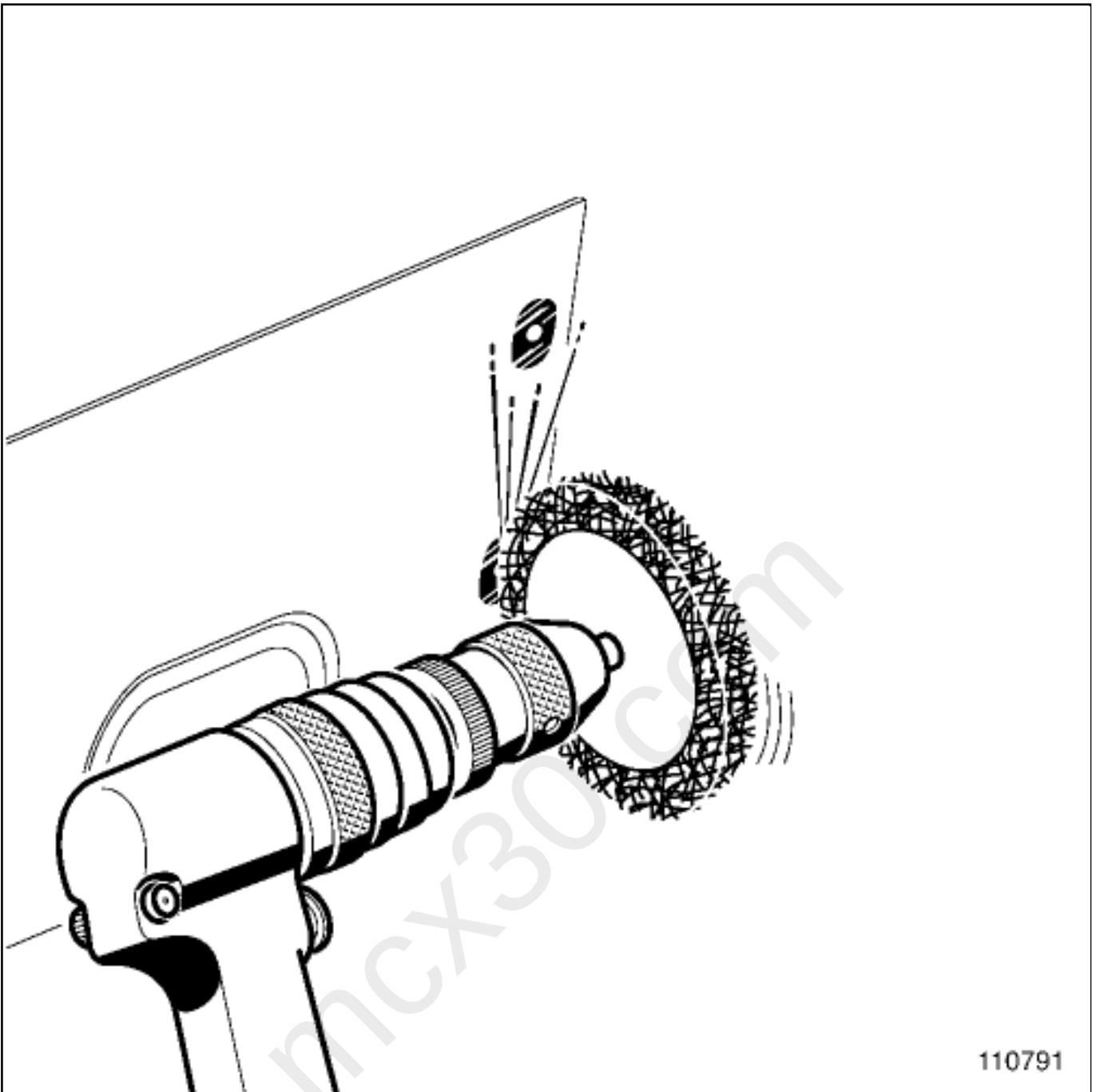
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Drill or pierce via the internal face at the drilling position, see table below.

Panel thickness (mm)	Drill bit diameter (mm)
0.6 to 1	6
1 to 1.5	7
1.5 to 2	8
2 and more	10

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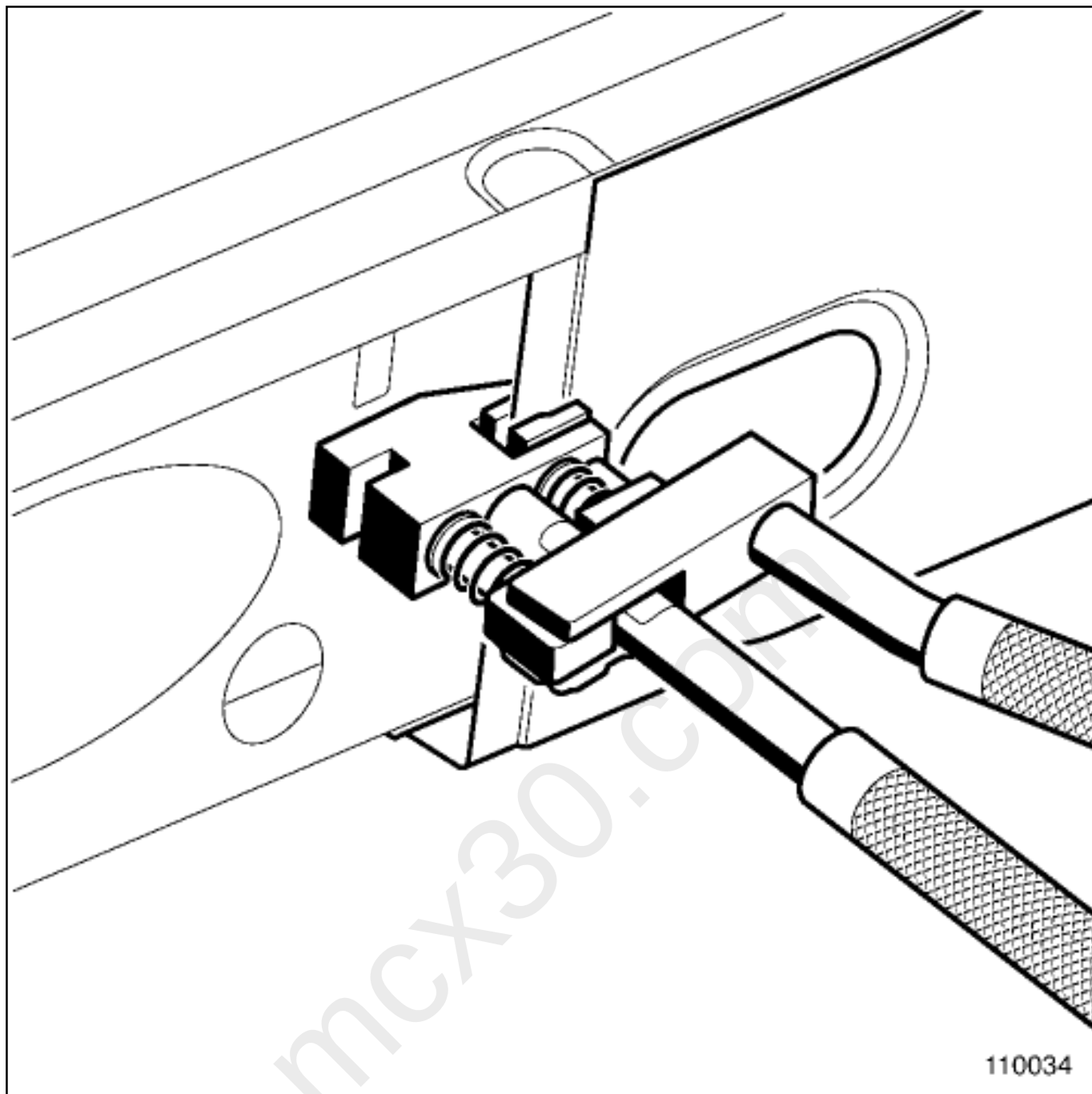


Scour the edges of the drilling holes and the external joint face along the length of the cut.

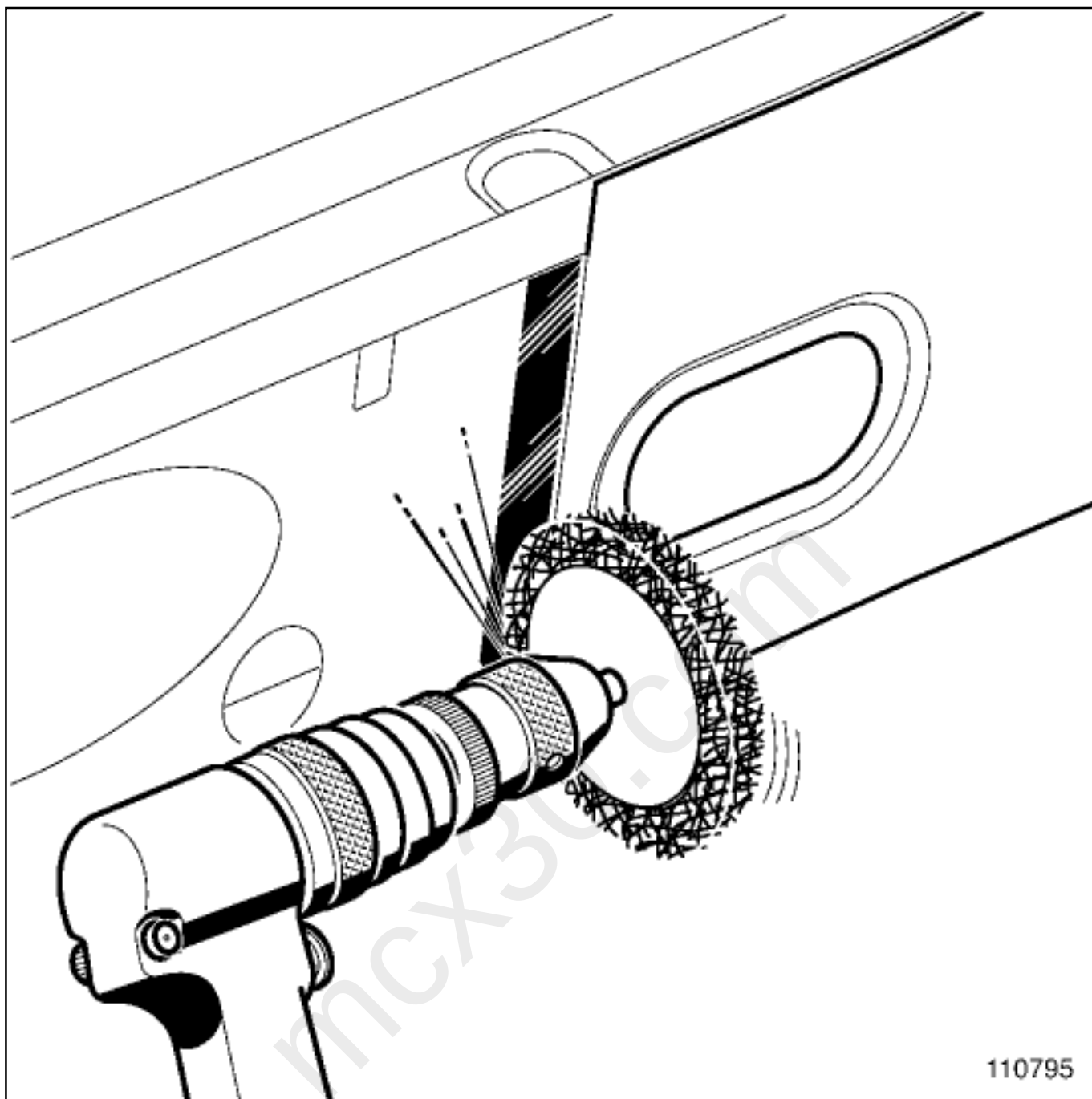
[\(see 05B, Equipment and Tools, Tools for scraping rigid adhesives and paint: Use\)](#)

Prepare the rest of the replacement part according to the chosen joint types, in accordance with the available joint face access.

4)PREPARATION OF THE JOINTS ON THE VEHICLE



Carry out the drilling, at the cutting location.



Scour the internal mating face at the step drilling location.

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

Prepare the rest of the vehicle, according to the chosen joint types.

5)APPLYING 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 faces.

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

2- ASSEMBLY

1) FITTING AND ADJUSTING THE REPLACED PARTS

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

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

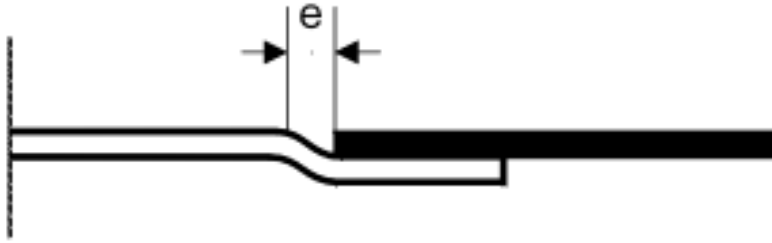
(see 05B, Equipment and Tools, Tools for adjusting and supporting a structural component: Use)

Note:



Leave a clearance(e) between the cut and the step drilling angle.

The clearance should be equal to the panel thickness.



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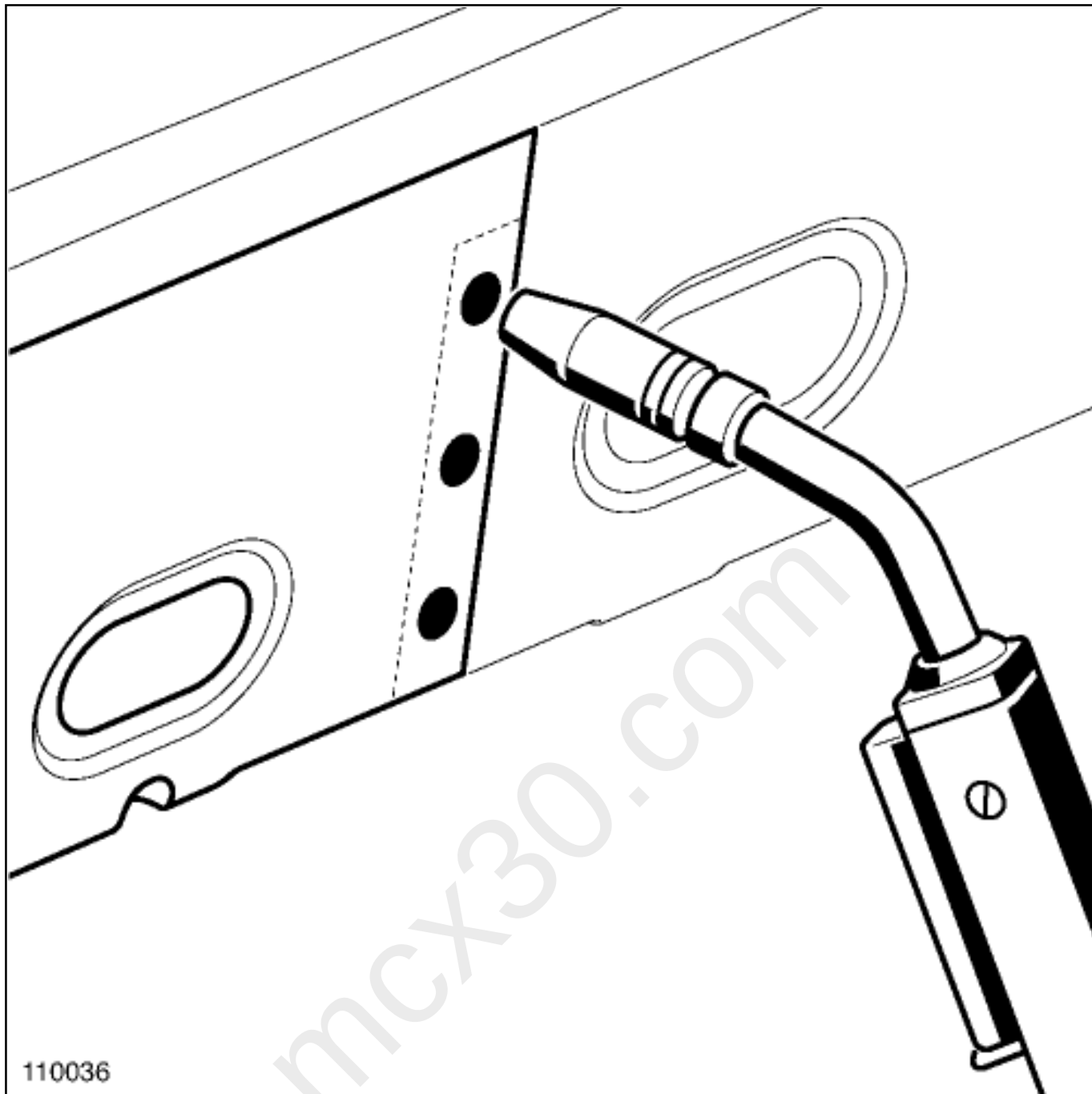
2)ADJUSTING THE WELDERS

Before making the joints on the vehicle, carry out the tests required for adjusting the welders.

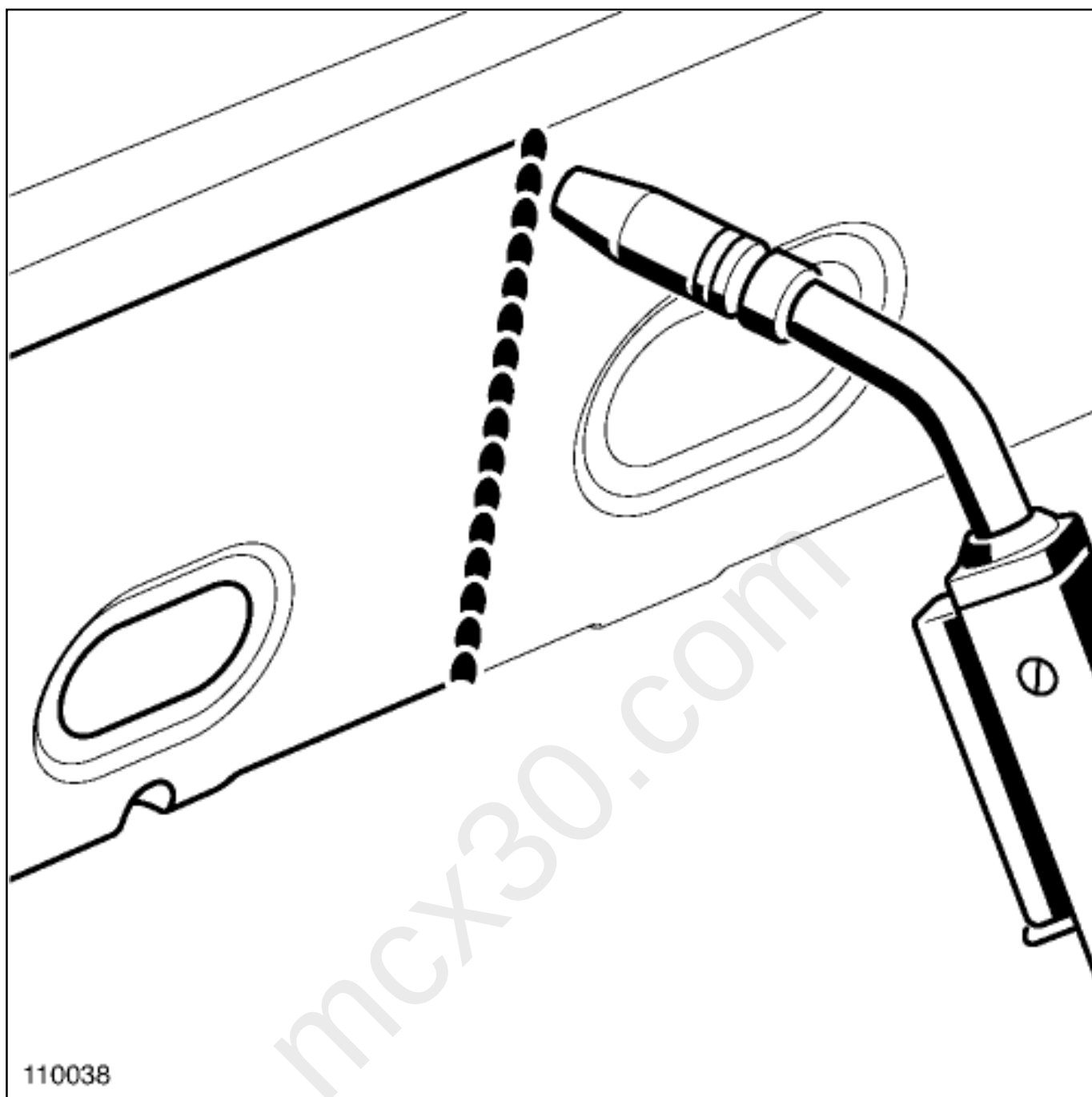
GMAW joint.

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

3)CARRYING OUT THE WELDING

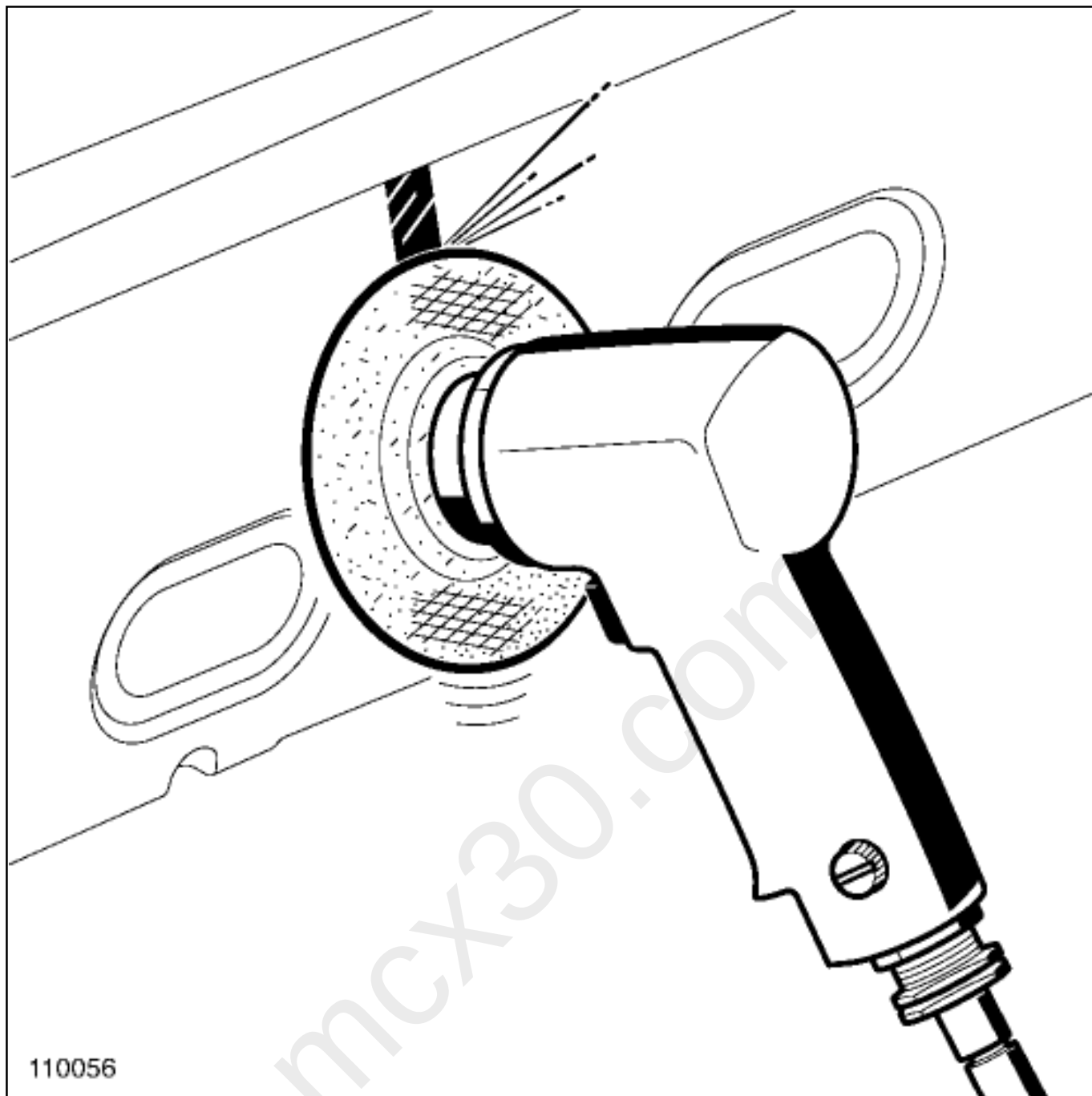


Do the plug welds.



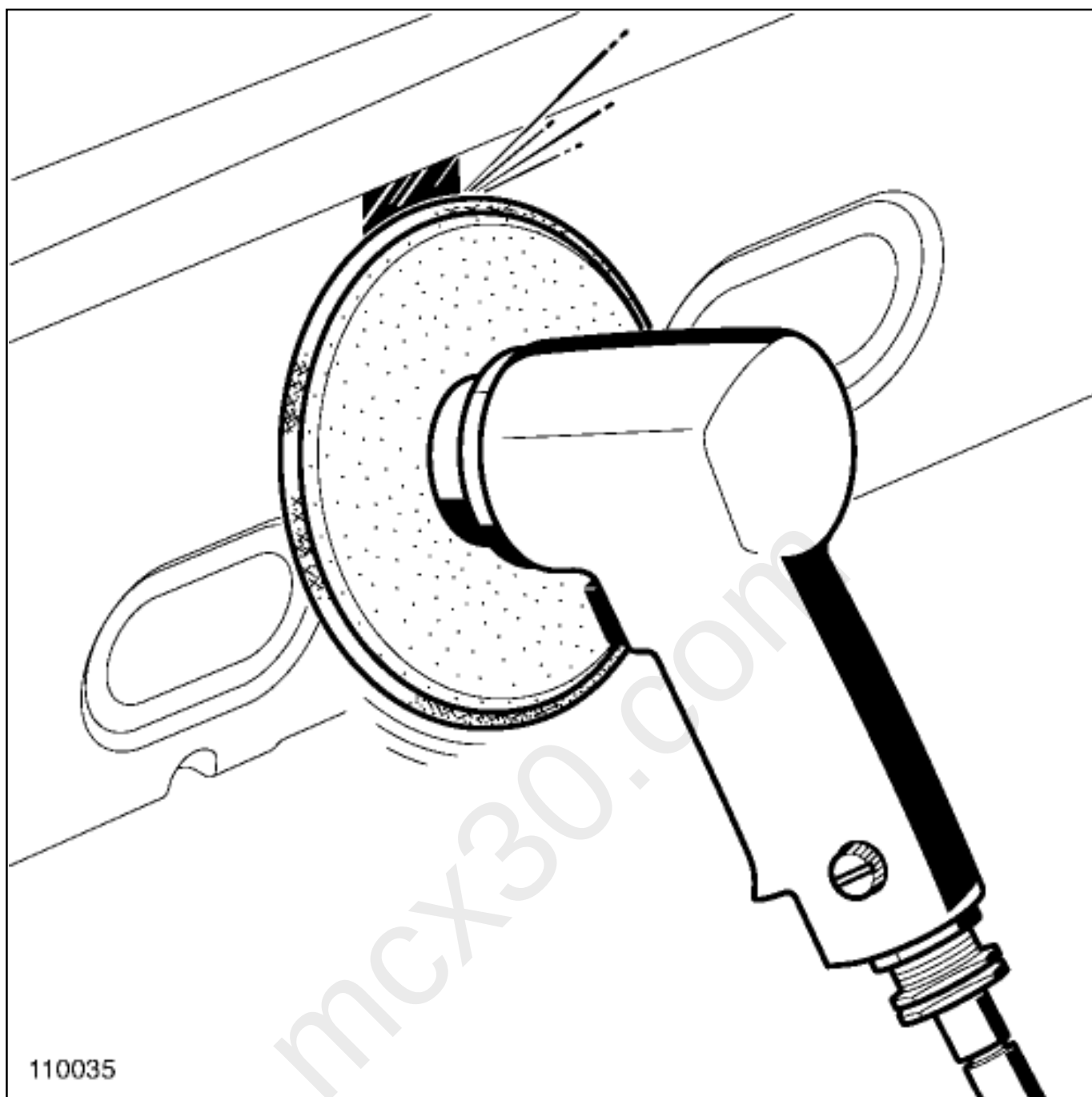
Apply a bead of chain weld along the whole cut.

3- FINISHING



Grind the continuous weld and the plug welds.

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



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, carry out surface finishing.