

(see 04F, Bodywork products and mountings, Panelwork finishing products: Use)

1)FITTING PROTECTION AFTER ASSEMBLY

Fit the soundproofing.

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

Apply the anti-corrosion protection.

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



Repair-40x01x28x04-02x21-1-1-1.xml



XSL version : 3.02 du 22/07/11

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CONNECTIONSFORPARTIALREPLACEMENTBYOVERLAPPING

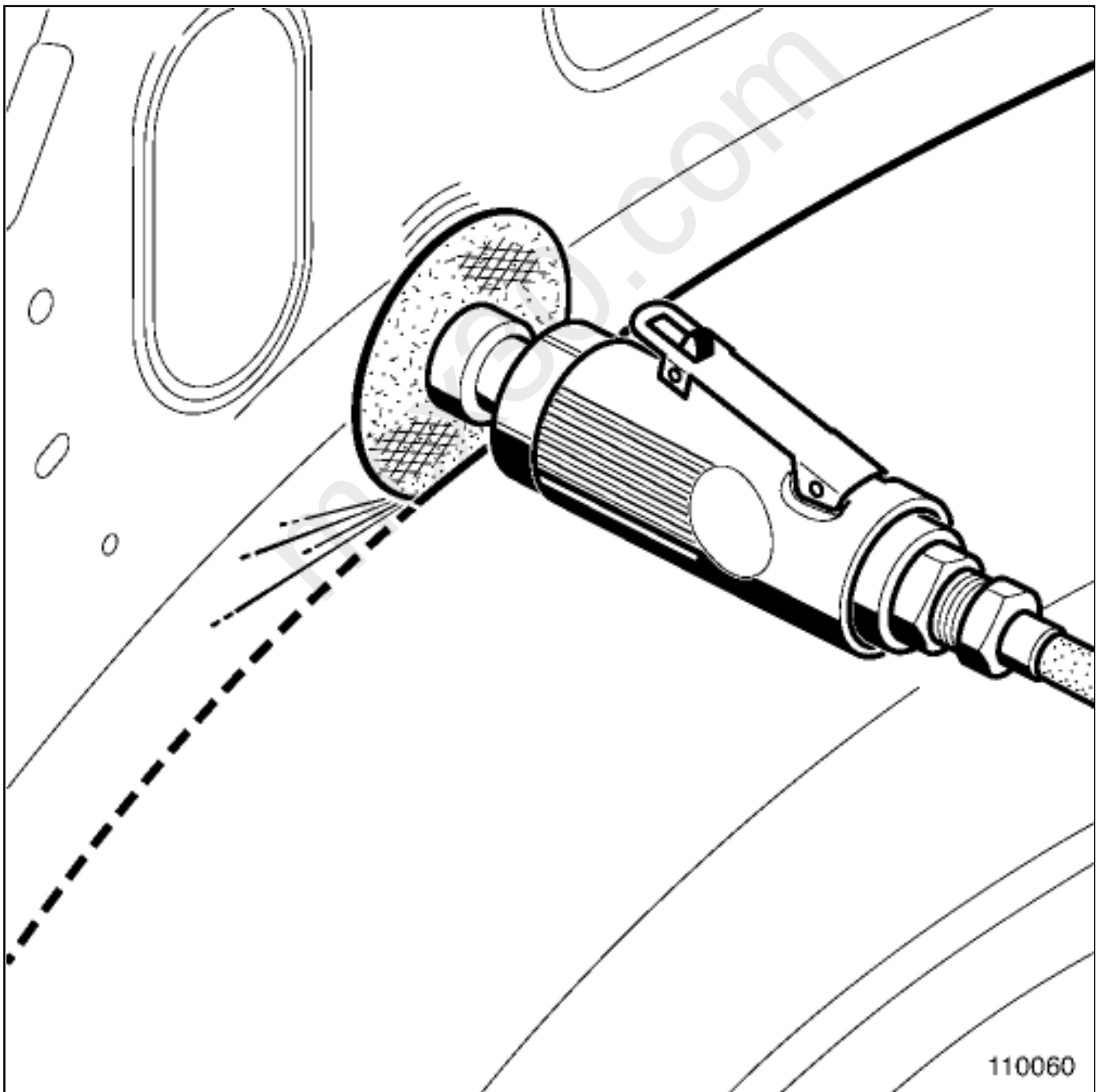
1. DISASSEMBLY

1- SCOURING

If necessary, scour the joint areas.

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

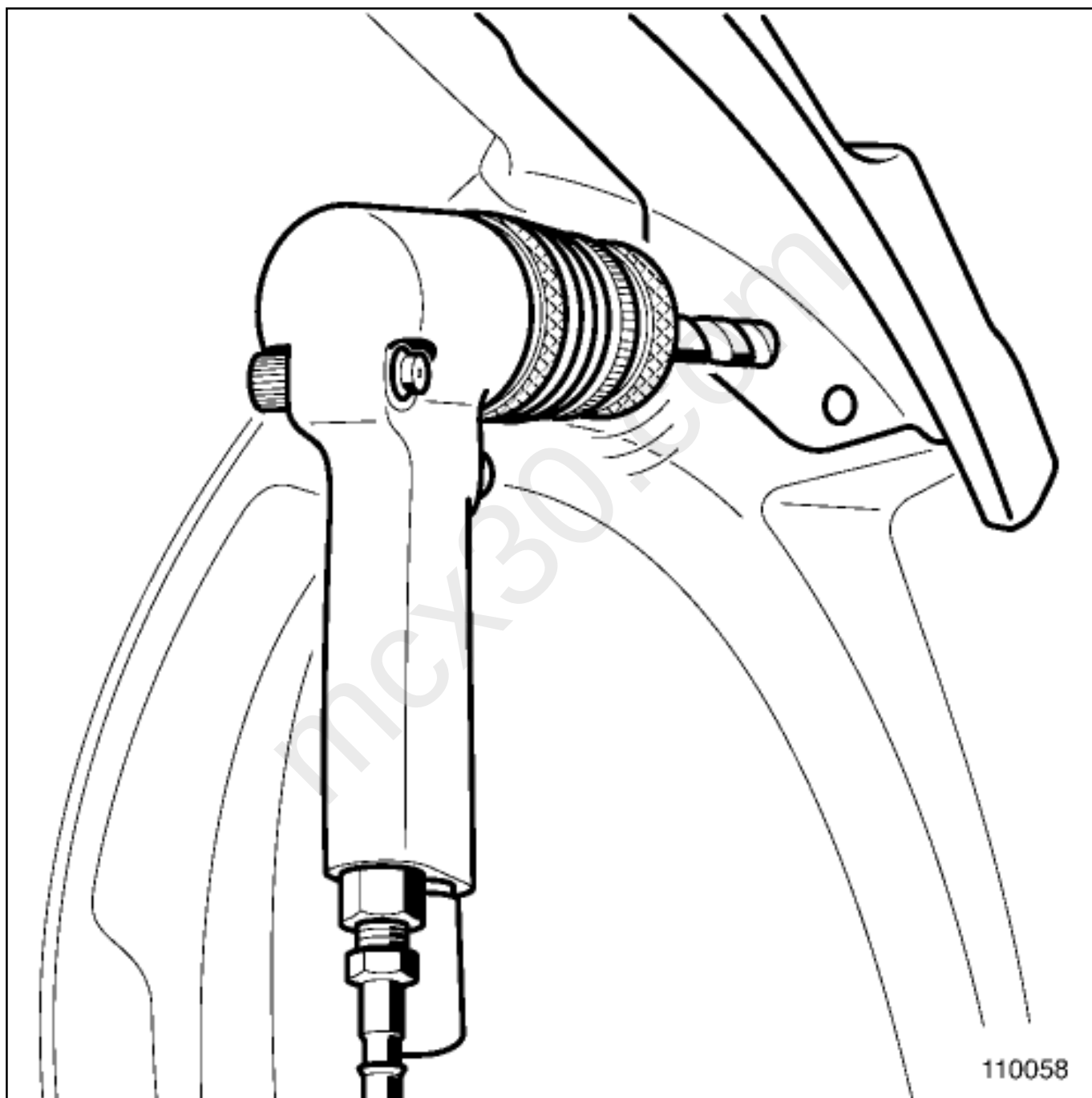
2- CUTTING



Cut the damaged part; refer to the MR for the vehicle concerned.

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

3- UNPICKING



Unpick the part's welded connections.

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

Remove the damaged part.



Note:

Do not strike or damage the panel.

4- GRINDING

Grind the unpicking and cutting residue.

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

Surface the internal mating face.

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

2. TWO FACE ACCESS

1- PREPARATION 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)

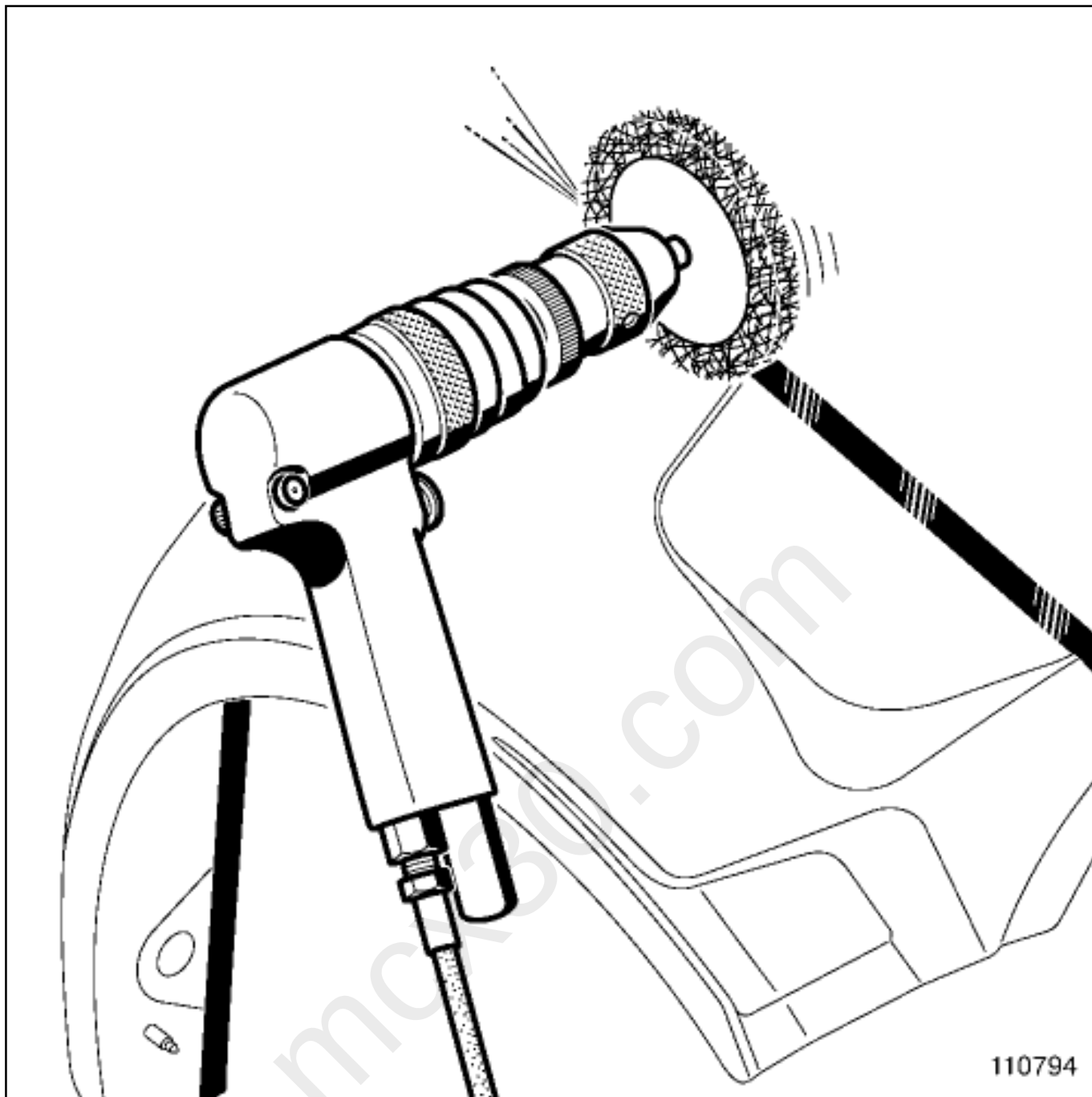
Mark the joint faces; refer to the MR for the vehicle concerned.

Disassemble the replacement part.

2- PREPARATION OF THE JOINTS ON THE REPLACEMENT PART

Cut the replacement part according to the marking.

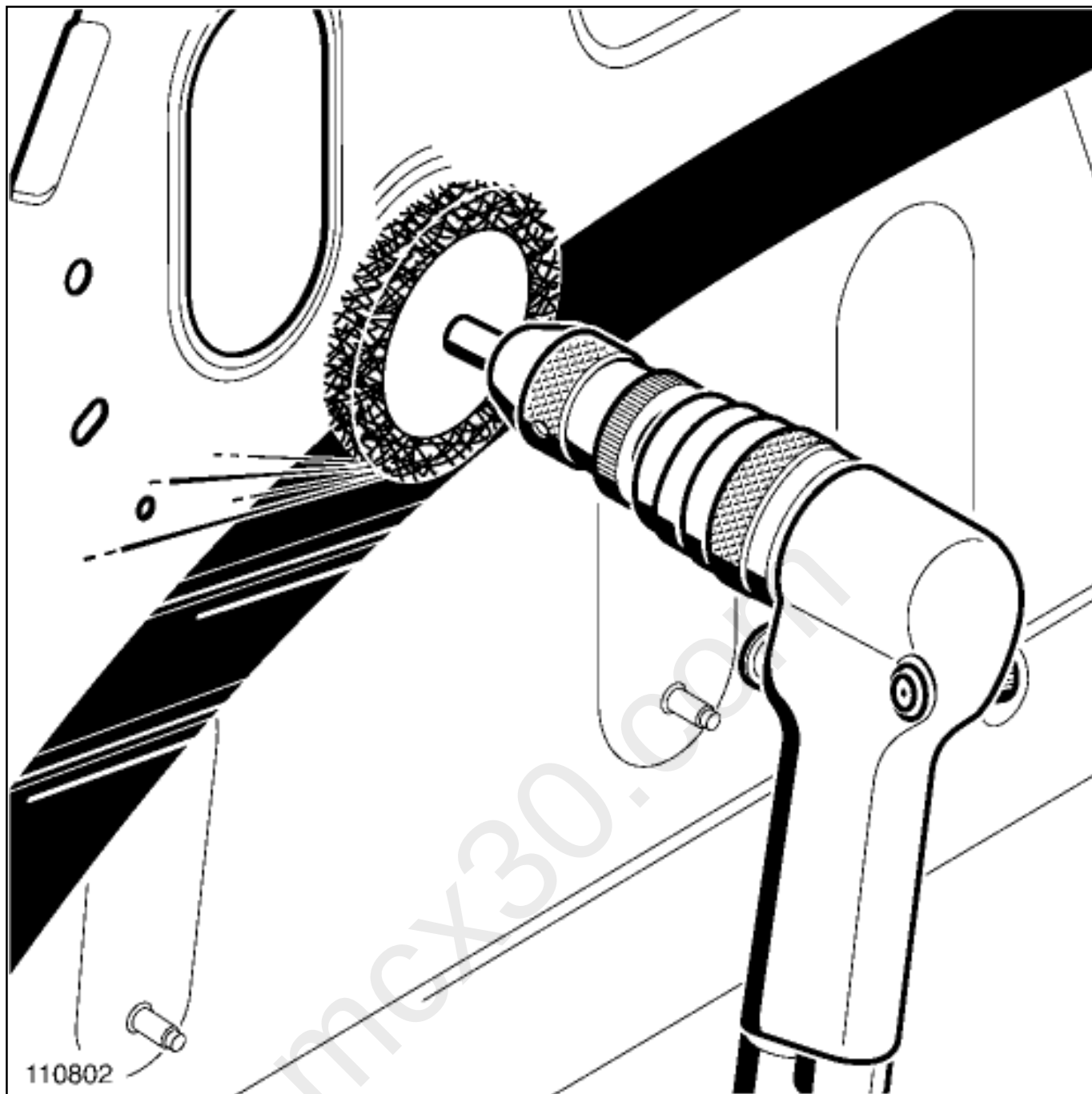
(see 05B, Equipment and Tools, Tools for cutting a structural component: Use)



Scour the internal and external joint faces around the cut.

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

3- PREPARATION OF THE JOINTS ON THE VEHICLE



Scour the internal and external joint faces.

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

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

4- APPLY THE PROTECTION BEFORE ASSEMBLY

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

Apply the anti-corrosion protection to the internal faces.

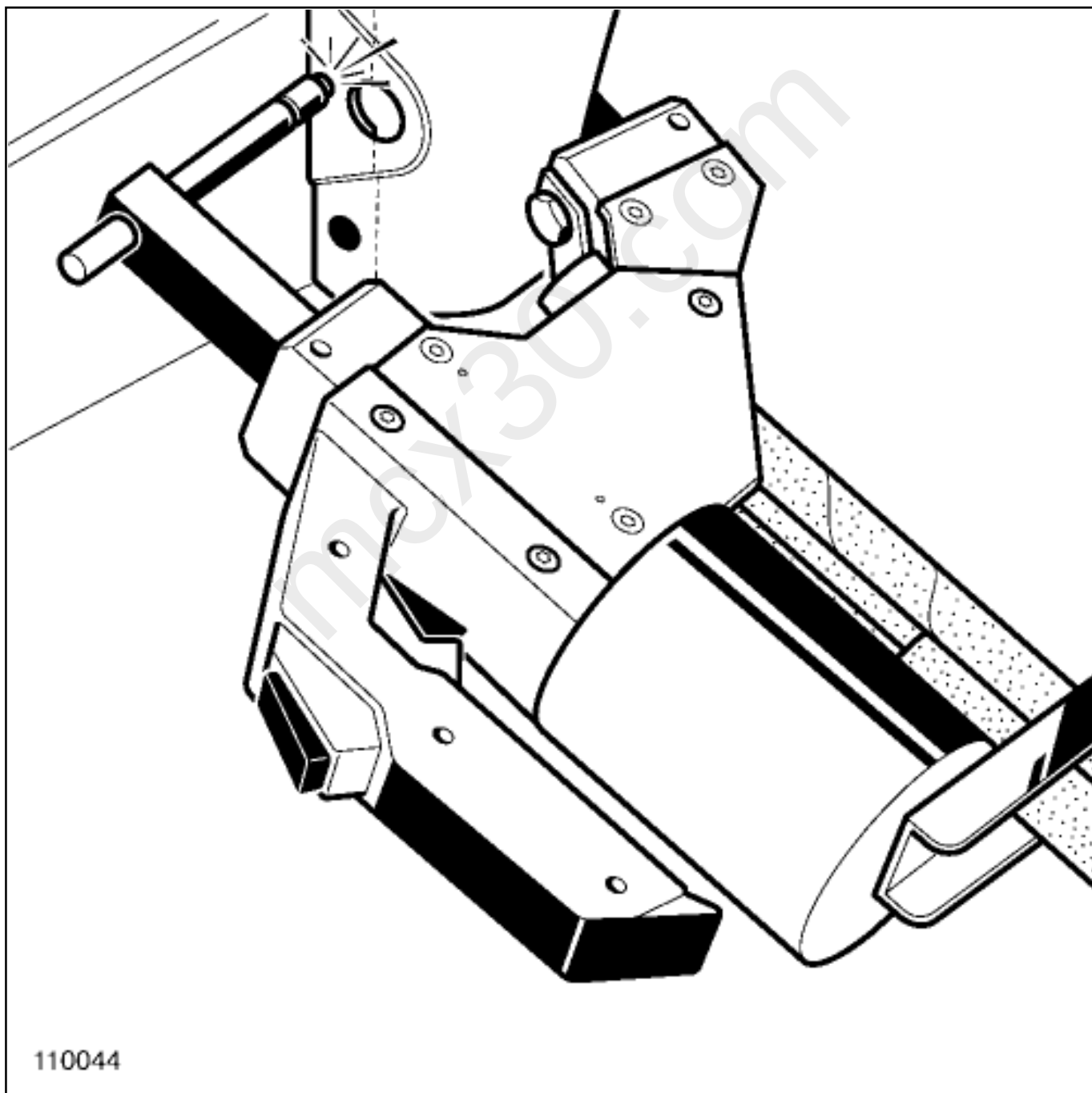
[\(see 04F, Bodywork products and mountings, Anti-corrosion protection product before assembly: Use\)](#)

5- CARRYING OUT THE WELDING

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

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

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



Weld the part checking for good part jointing.

3. SINGLE FACE ACCESS

1- PREPARATION 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)

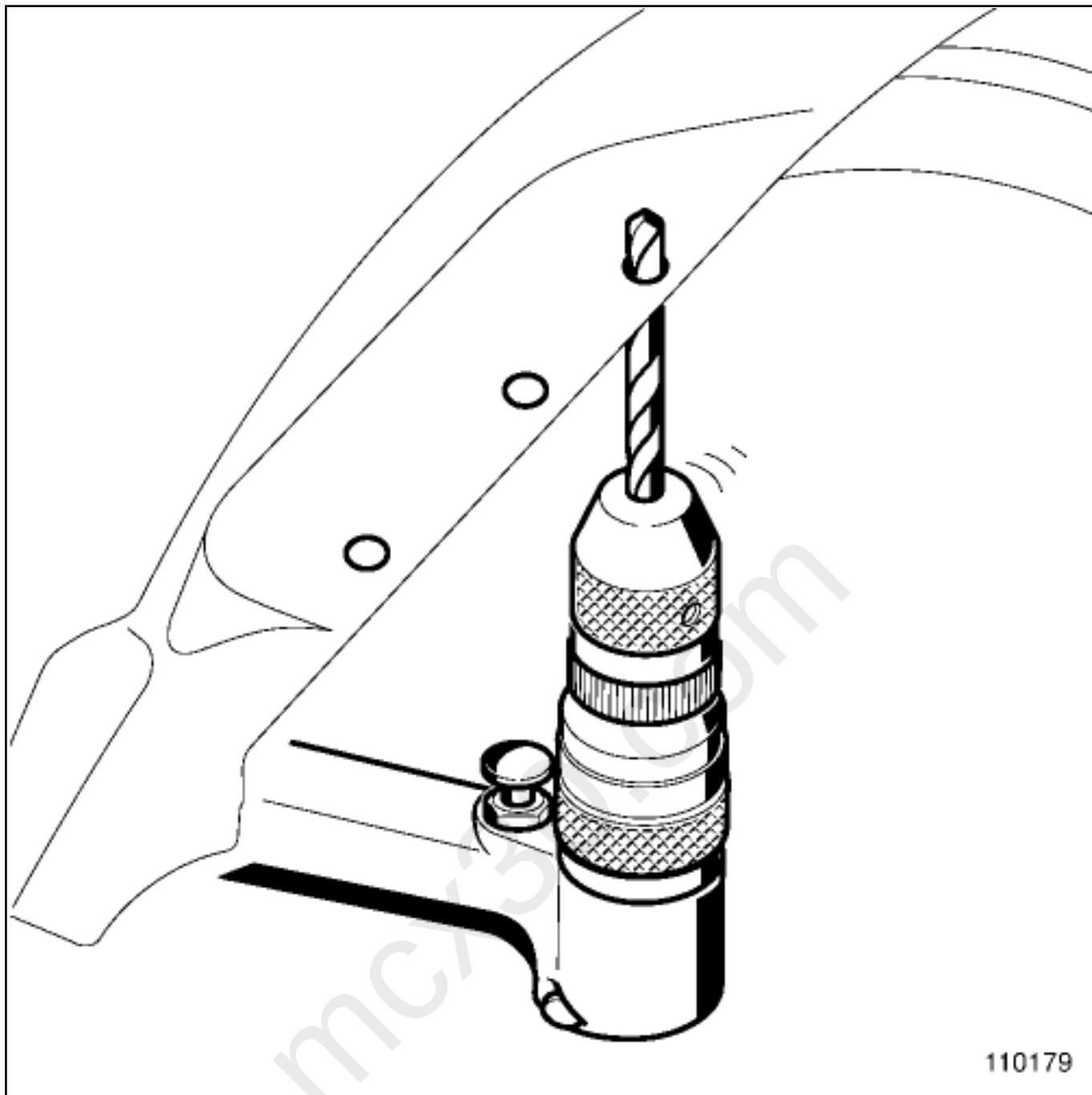
Mark the joint faces; refer to the MR for the vehicle concerned.

Remove the replacement part.

2- PREPARATION OF THE JOINTS ON THE REPLACEMENT PART

Cut the replacement part according to the marking.

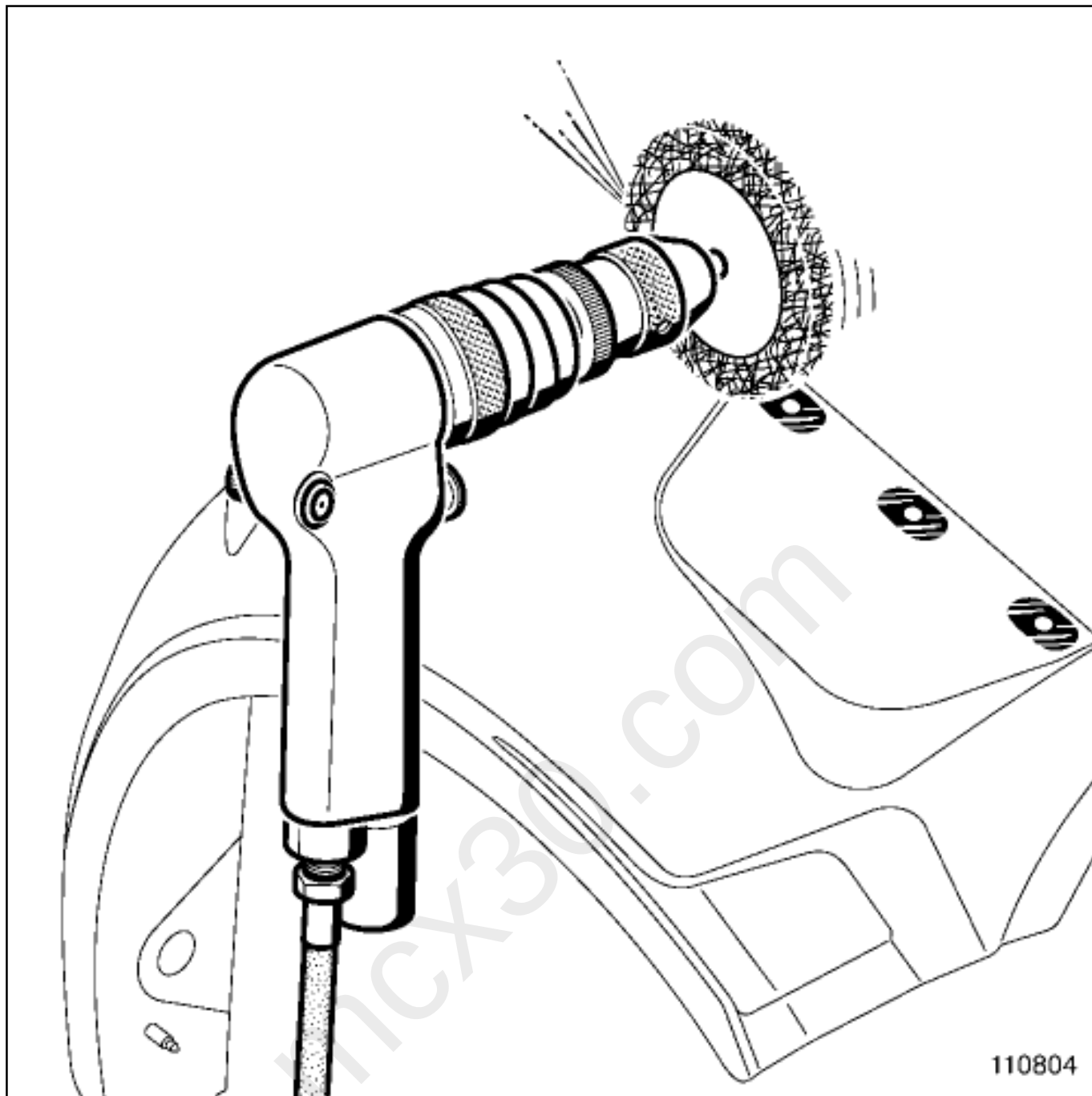
(see 05B, Equipment and Tools, Tools for cutting a structural component: Use)



Drill or pierce the holes for the plug welds via the internal face, following the 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

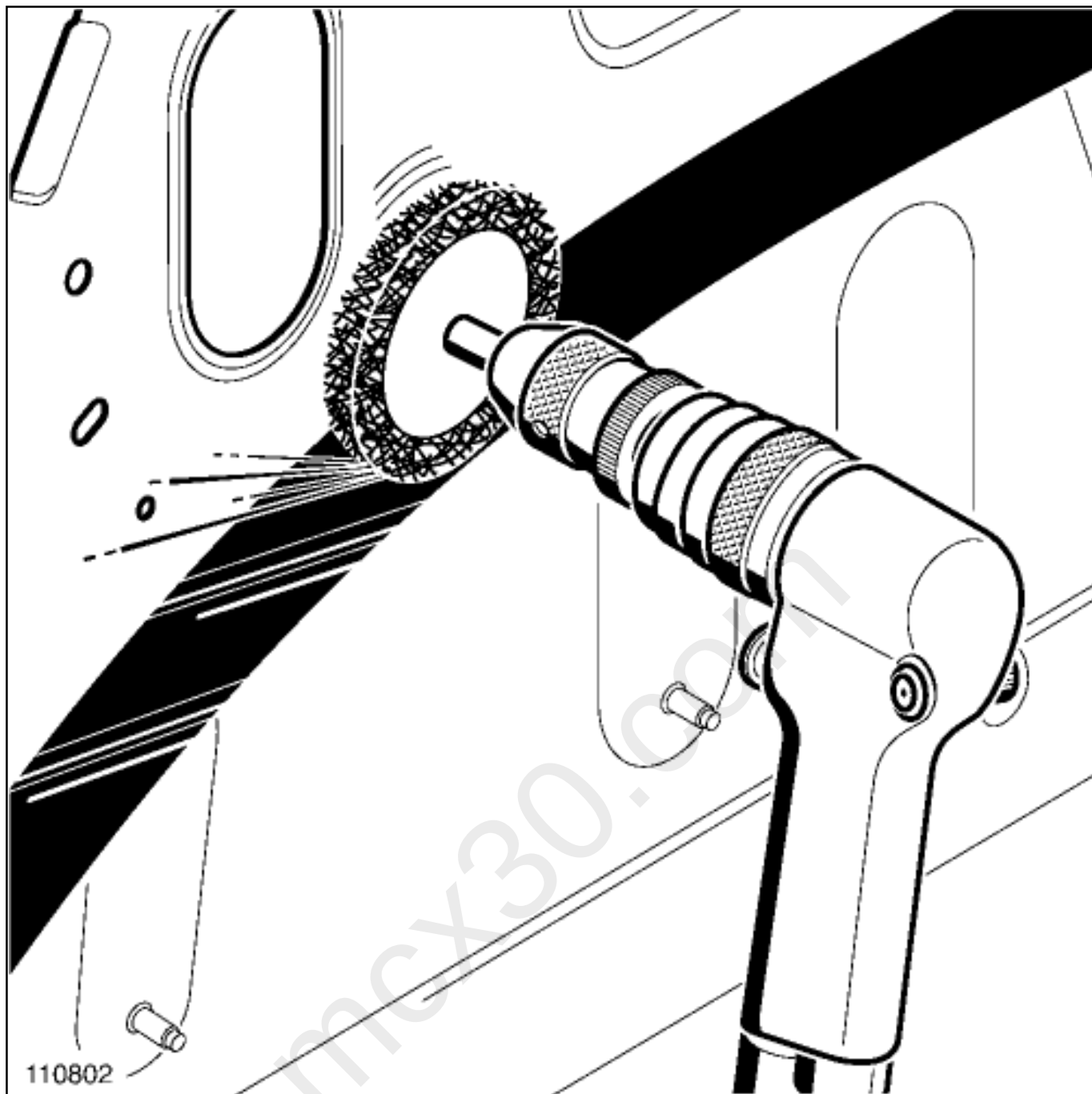
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Scour the edges of the holes on the external joint faces.

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

3- PREPARATION OF THE JOINTS ON THE VEHICLE



Scour the internal mating faces.

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

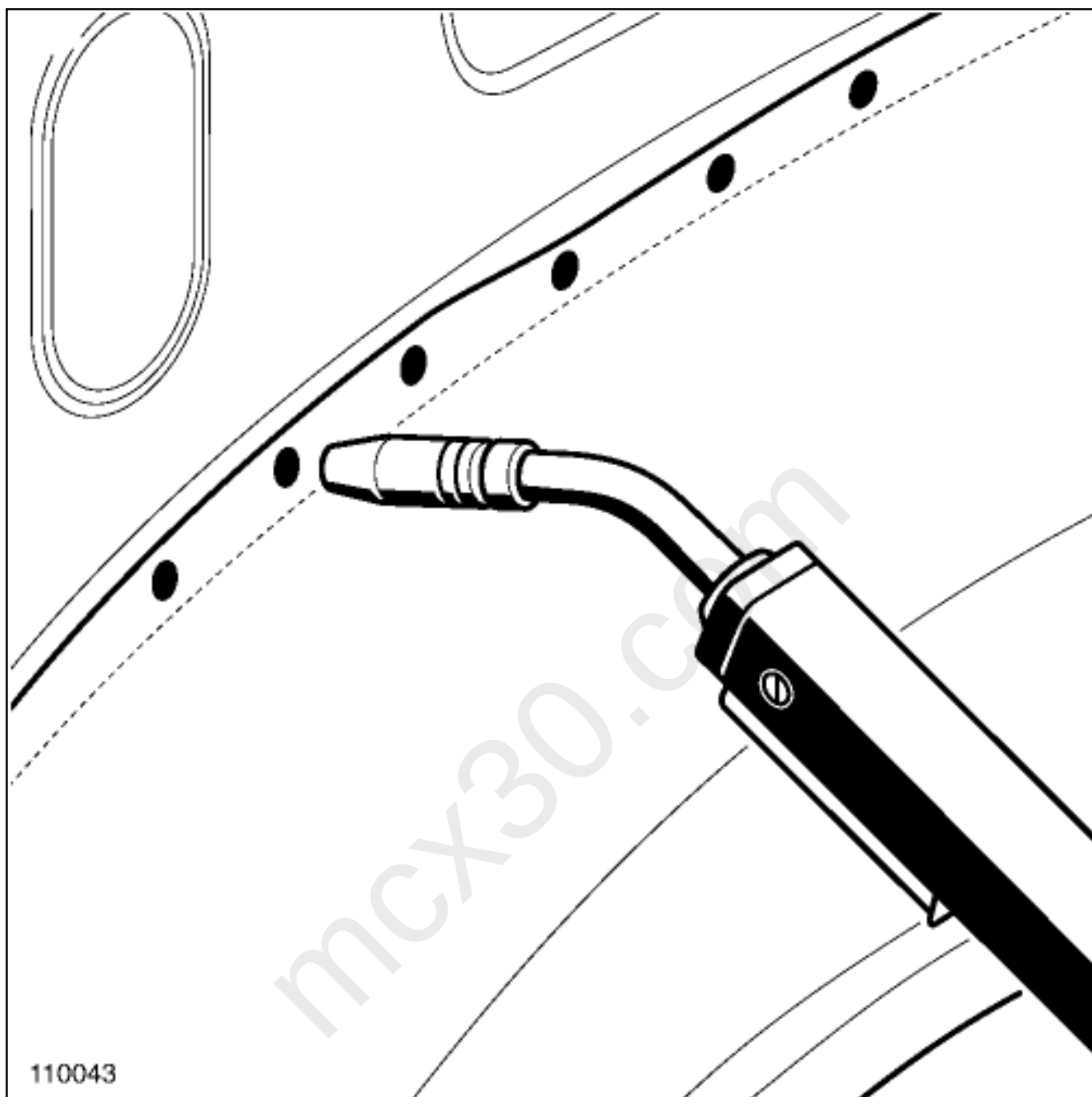
[\(see 05B, Equipment and Tools, Tools for scraping rigid adhesives and paint: Use\)](#)

4- CARRYING OUT THE WELDING

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

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

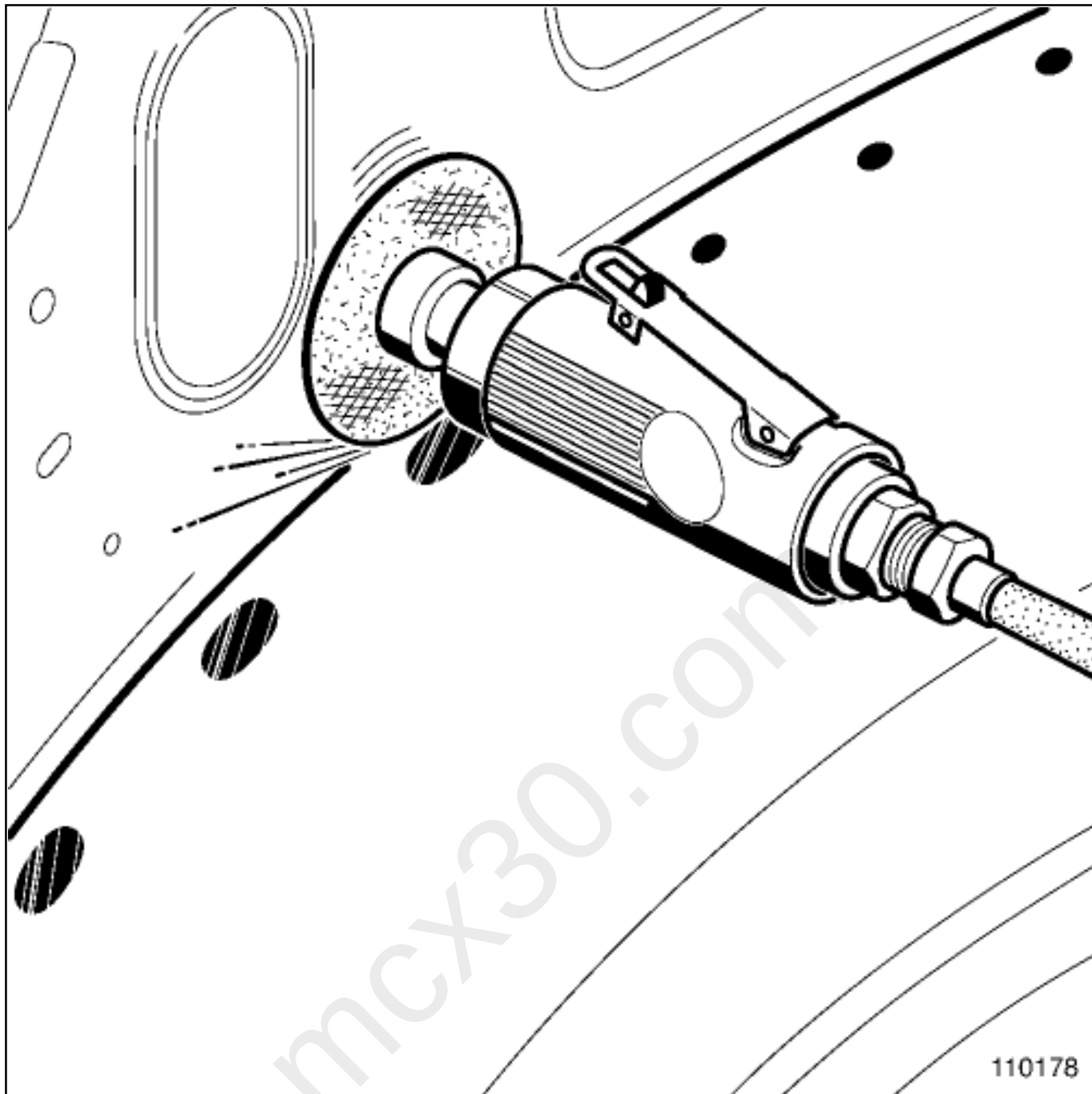
[\(see 05B, Equipment and Tools, Tools for adjusting and supporting a structural component: Use\)](#)



Do the plug welds.

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

5-FINISHING



Grind the plug welds.

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

Surface the joint areas.

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