FRONT SIDE AIR DISTRIBUTION DUCT: REMOVAL - REFITTING

Locations and specifications (tightening torques, parts to always be replaced, etc.)(see 61A, Heating, Air distribution circuit assembly: Exploded view) .

REMOVAL

1. REMOVAL PREPARATION OPERATION

- Disconnect the batteryBattery: Removal - Refitting .
- Remove the dashboardDashboard assembly: Exploded view .

2. REMOVAL OPERATION

- Unclip the front side air distribution ducts(see 61A, Heating, Air distribution circuit assembly: Exploded view) .
- Remove the front side air distribution ducts(see 61A, Heating, Air distribution circuit assembly: Exploded view) .

REFITTING

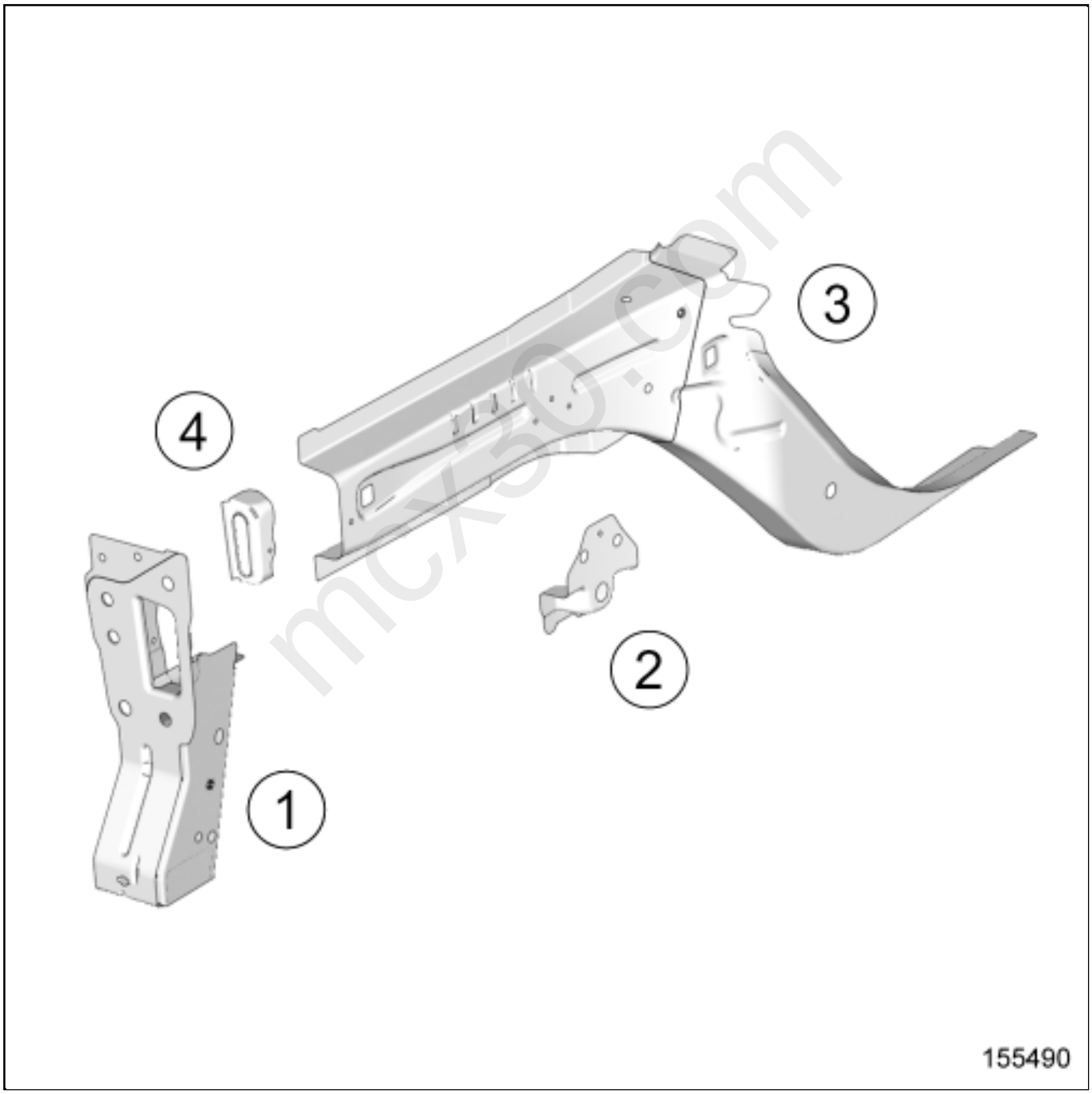
- Proceed in the reverse order to removal.

FRONTSIDEMEMBER:REPLACEMENT

Note, one or more warnings are present in this procedure

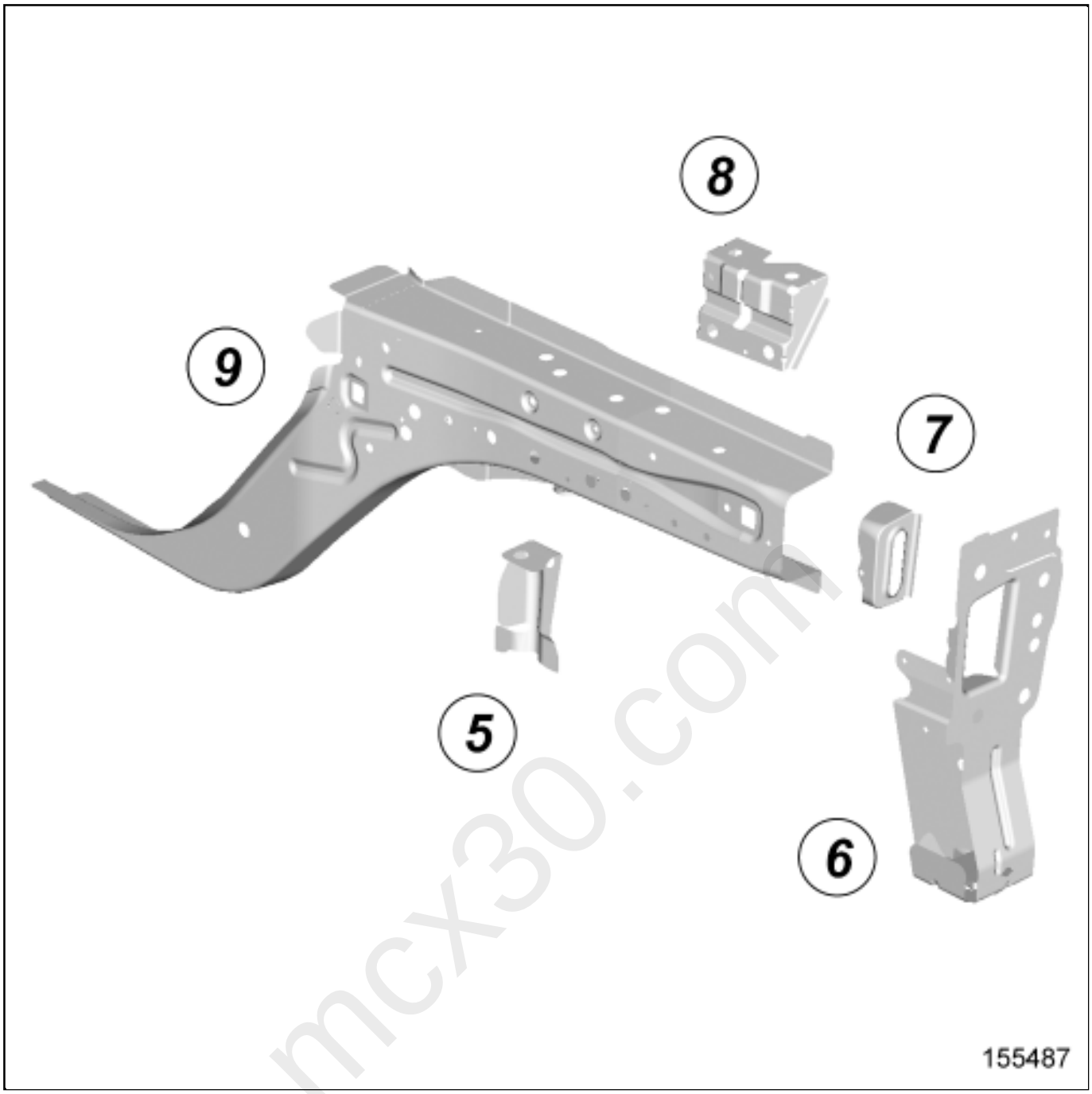
1. COMPOSITION OF THE SPARE PART

1- RIGHT-HAND SIDE



No.	Description	Type	Thickness (mm)
(1)	Right-hand radiator cross member support	HLE	2.5
(2)	Front subframe front right-hand mounting	HLE	2
(3)	Front right-hand side member	THLE	1.6/2.6
(4)	Right-hand reinforcement unit for front right-hand side member end	THLE	2

2- LEFT-HAND SIDE

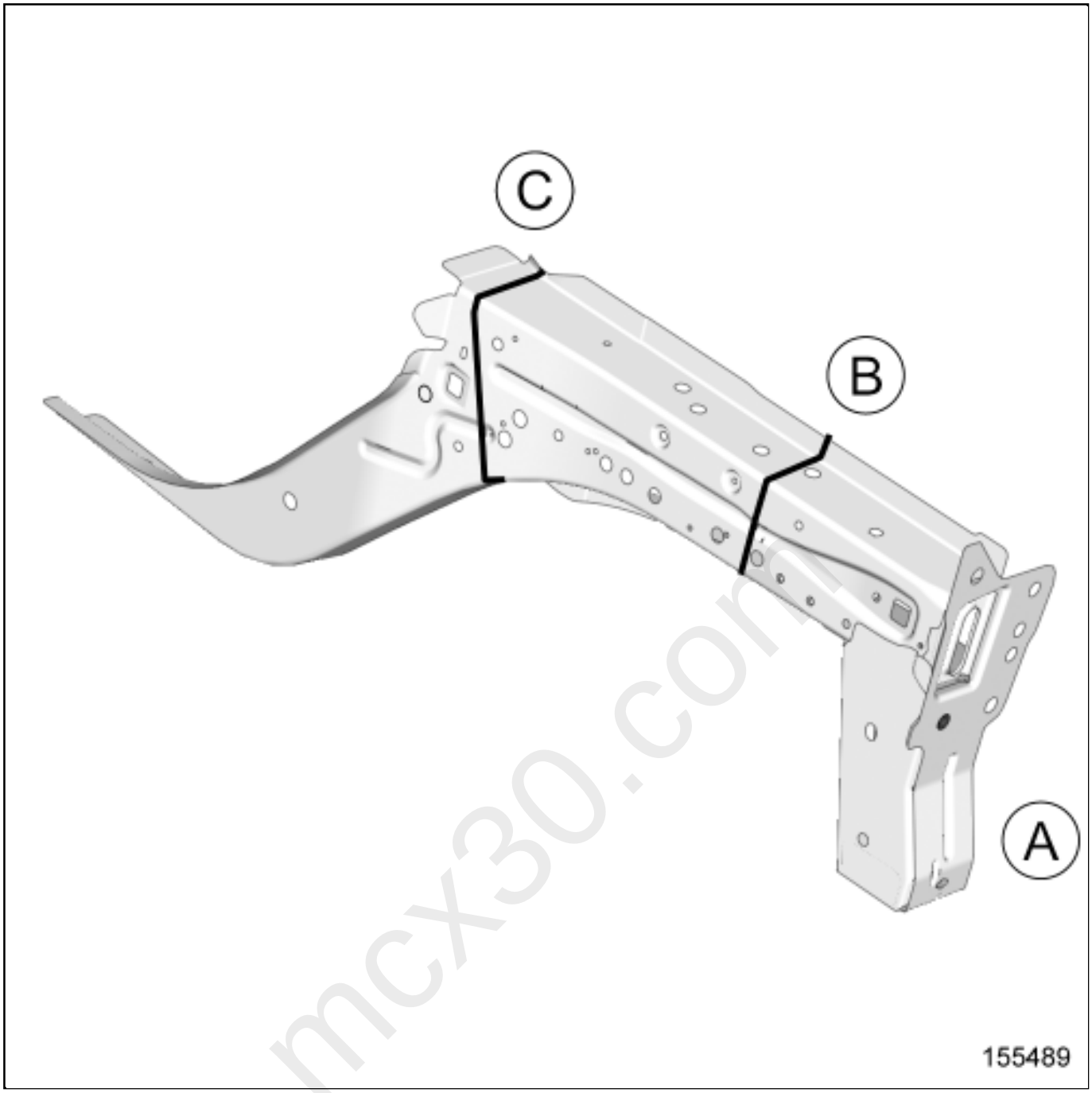


No.	Description	Type	Thickness (mm)
(5)	Front subframe front left-hand mounting	HLE	3
(6)	Left-hand radiator cross member support	THLE	1.2
(7)	Reinforcement unit of front left-hand side member end	THLE	1.8
(8)	Front gearbox reinforcement	Mild steel	1.6
(9)	Front left-hand side member	THLE	1.6/2.6

2. IN THE EVENT OF REPLACEMENT

The options for replacing this part are as follows:

- front partial replacement A-B,
- rear partial replacement A-C.

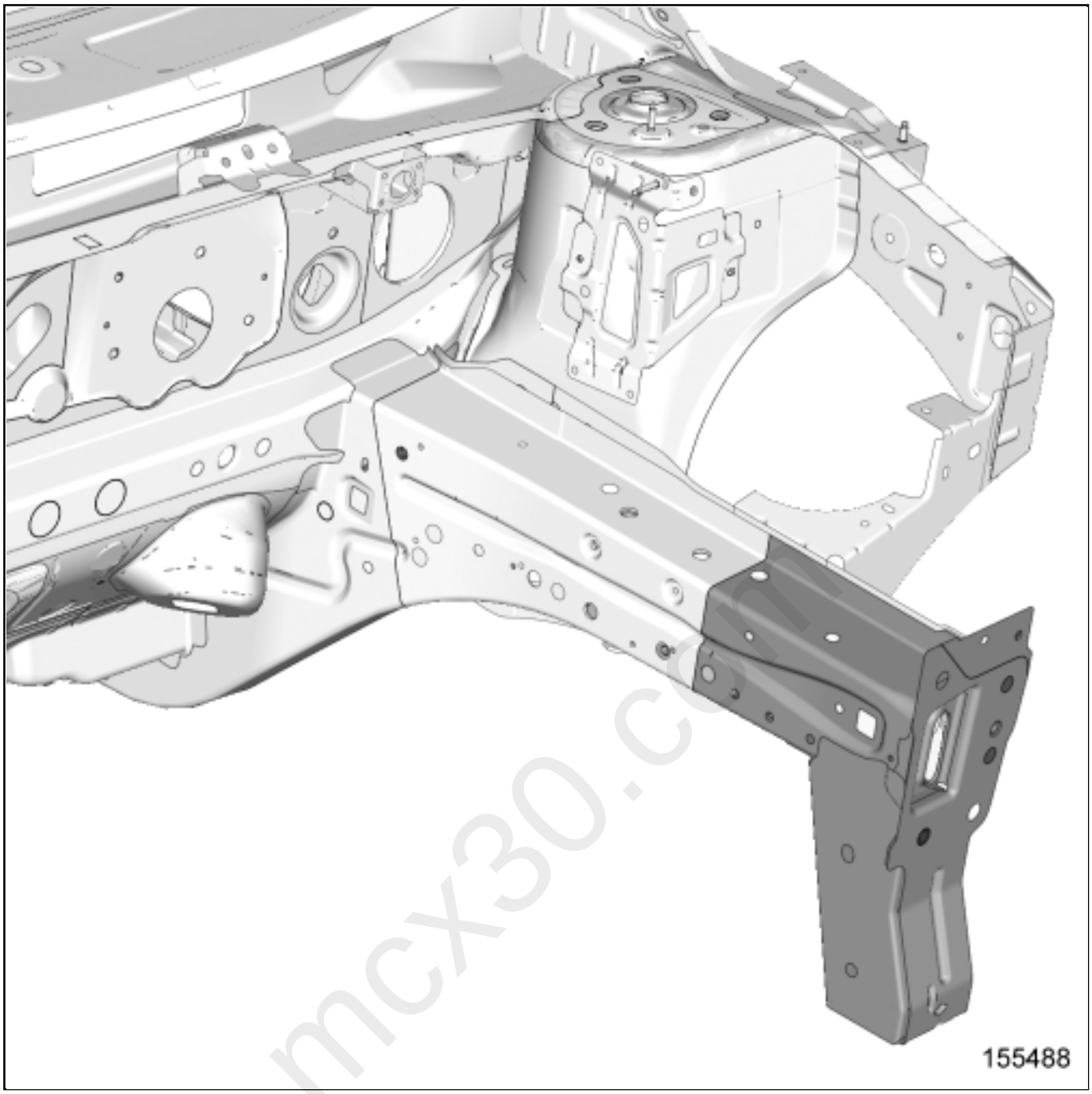


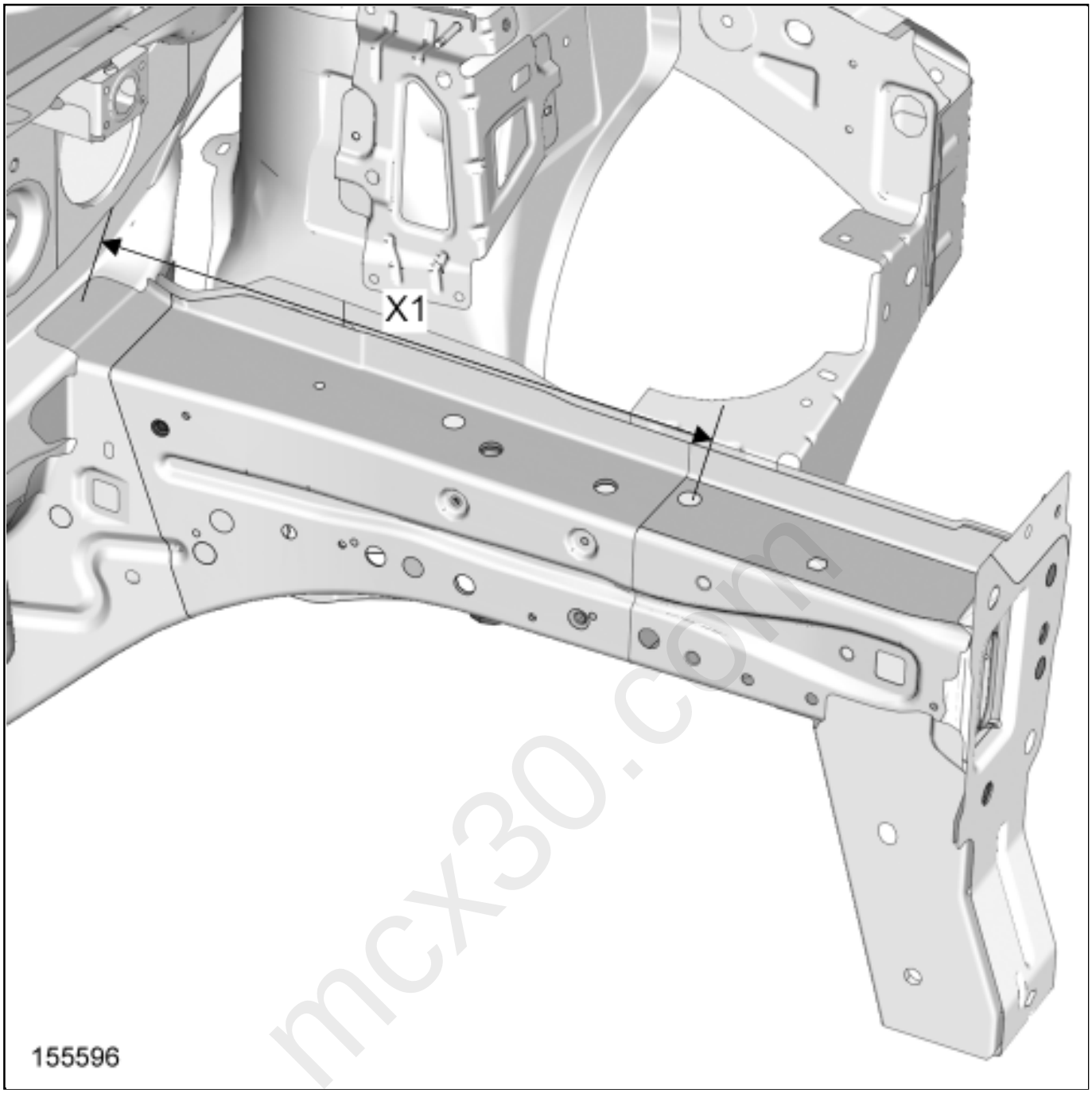
WARNING

Use a repair bench to ensure the positioning of the points and the geometry of the axle assemblies.

1- FRONT LEFT-HAND PARTIAL REPLACEMENT A-B

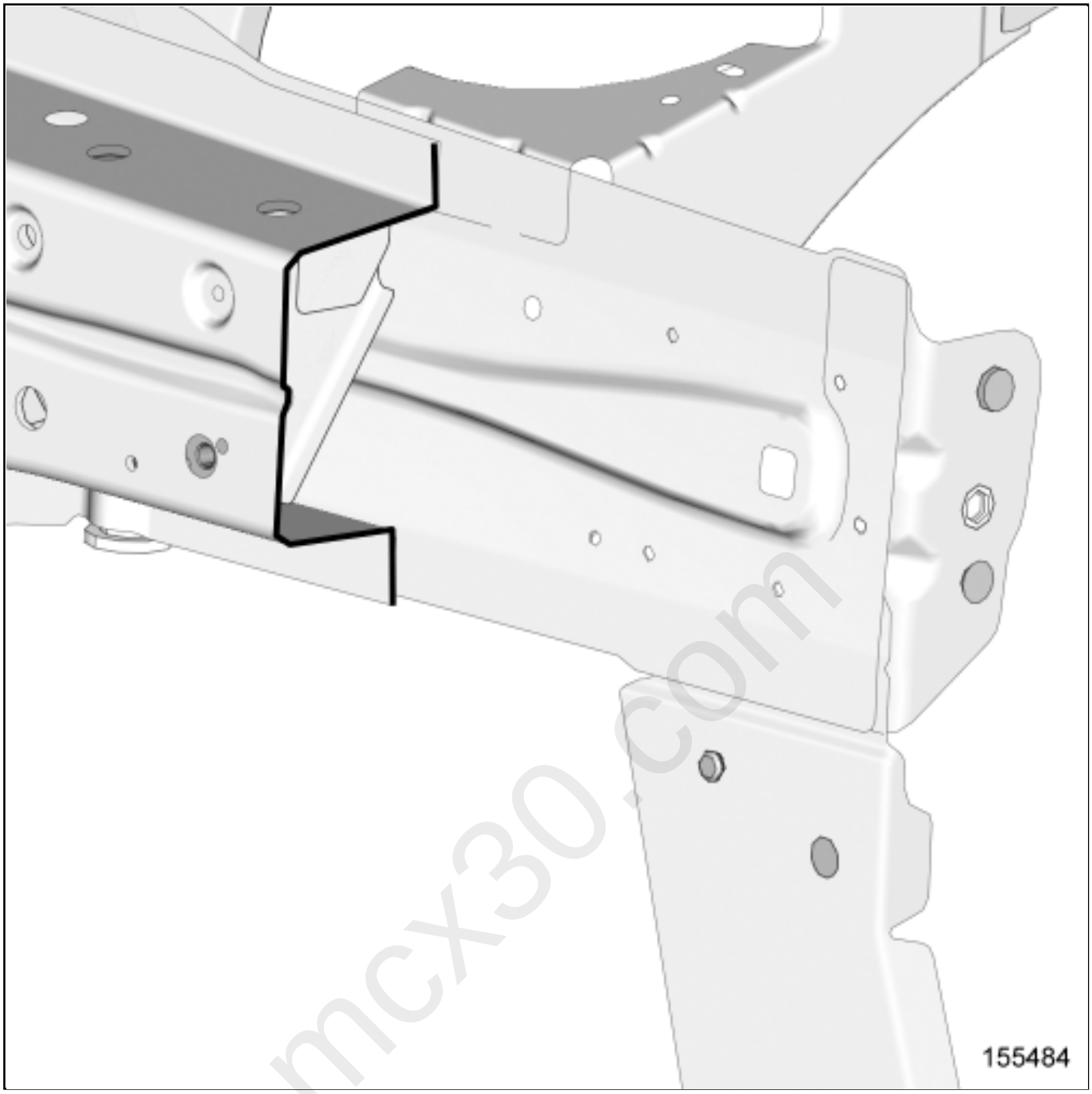
1)PART IN POSITION





(X1) = 449.63 mm

DETAILED VIEW OF CUT B



2)POSITION OF ELECTRIC EARTHS

CAUTION

To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

Position the earth of the welding machine as close as possible to the weld area(see **Bolted connection for earth: Fitting**) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area Earths on body: List and location of components .

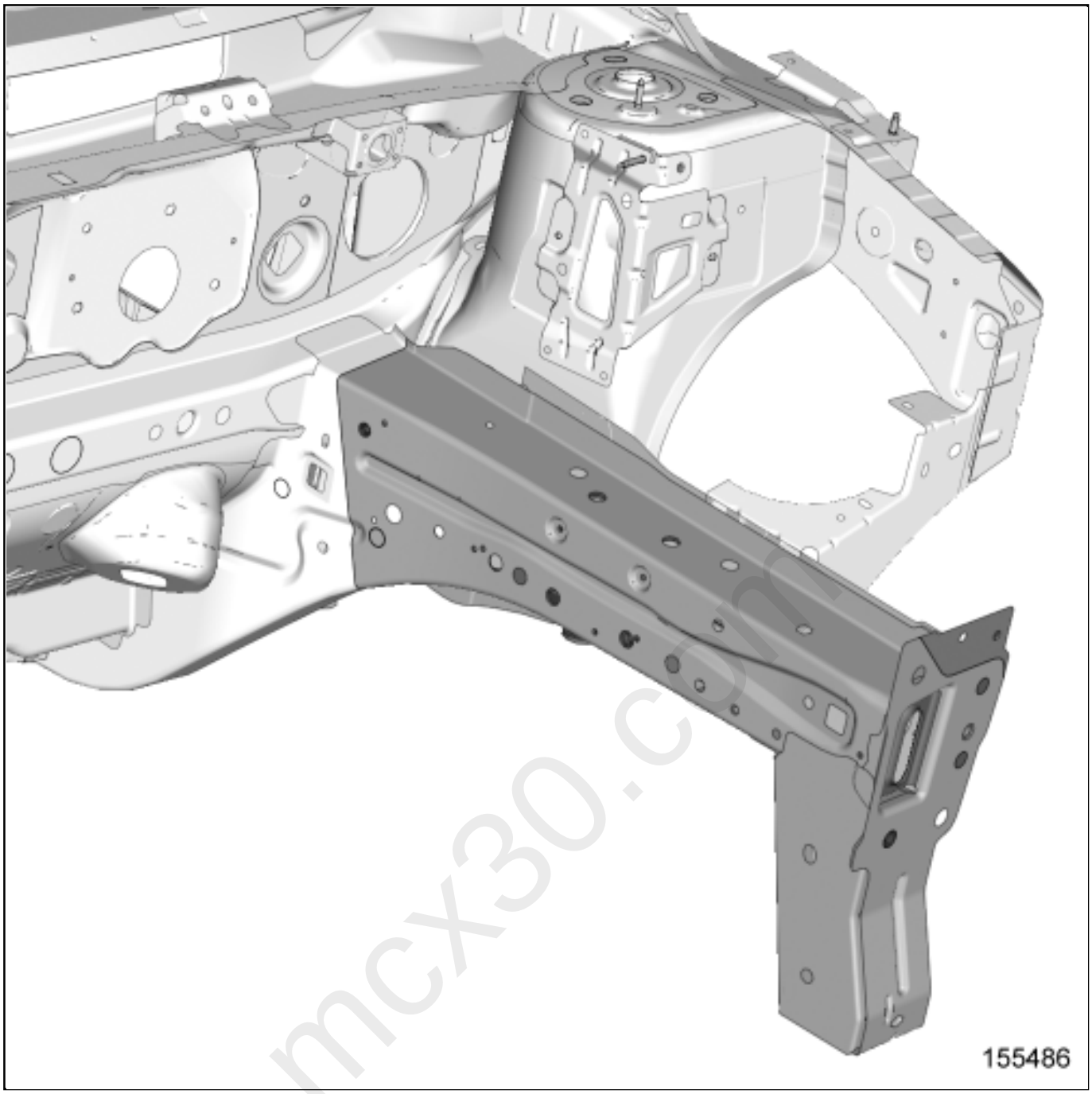
3)SPECIAL NOTES ON MATING

CAUTION

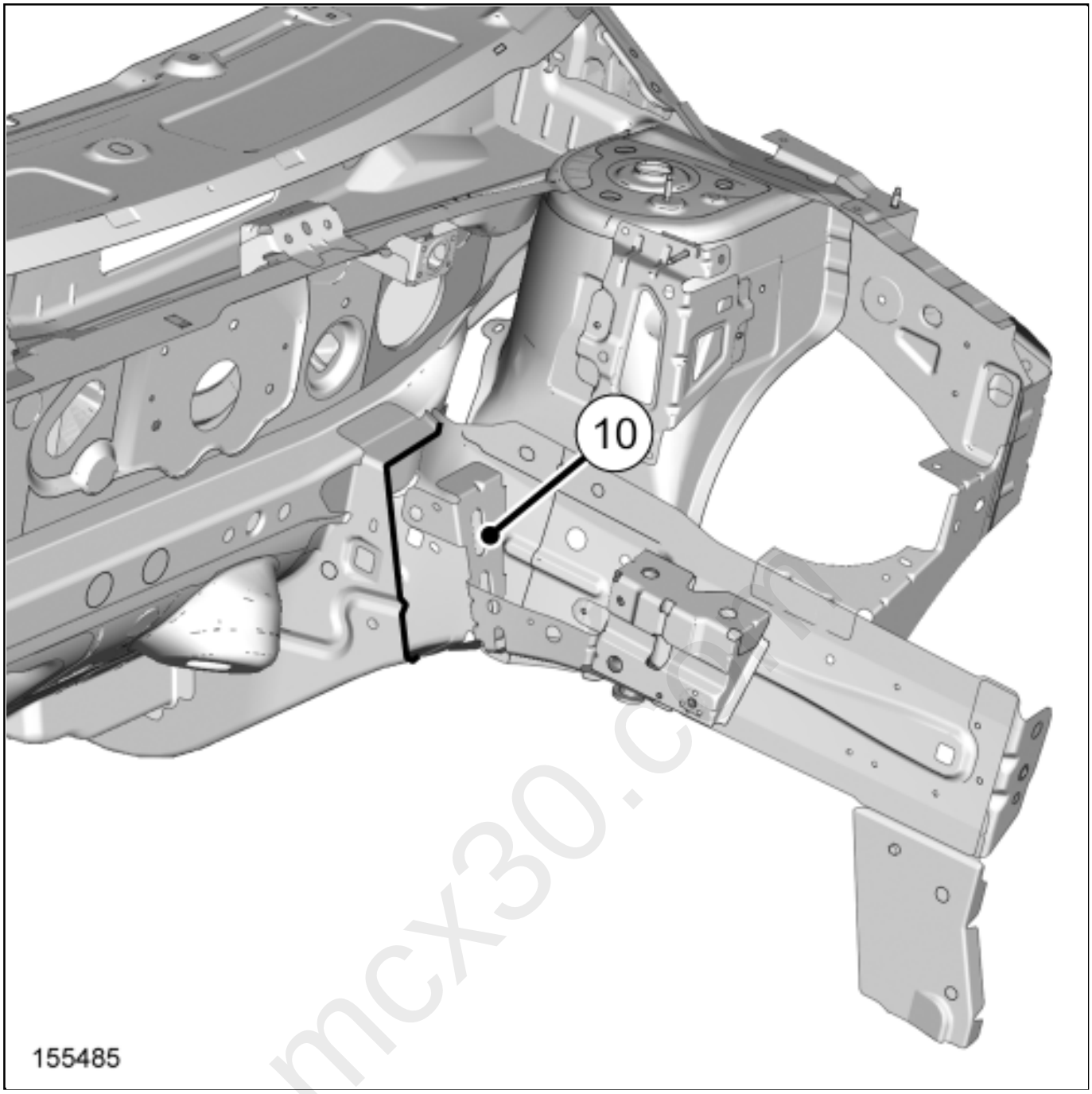
If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld Connections by arc welding under shielding gas: Description (MR 400, 40C, Gas metal arc welded connections (GMAW)).

2- REAR LEFT-HAND PARTIAL REPLACEMENT A-C

1)PART IN POSITION



SPECIAL FEATURES OF CUT C



Note:

When cutting, be careful not to damage the rear inner reinforcement(10) .

2)POSITION OF ELECTRIC EARTHS

CAUTION

To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

Position the earth of the welding machine as close as possible to the weld area(see **Bolted connection for earth: Fitting**) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area**Earths on body: List and location of components** .

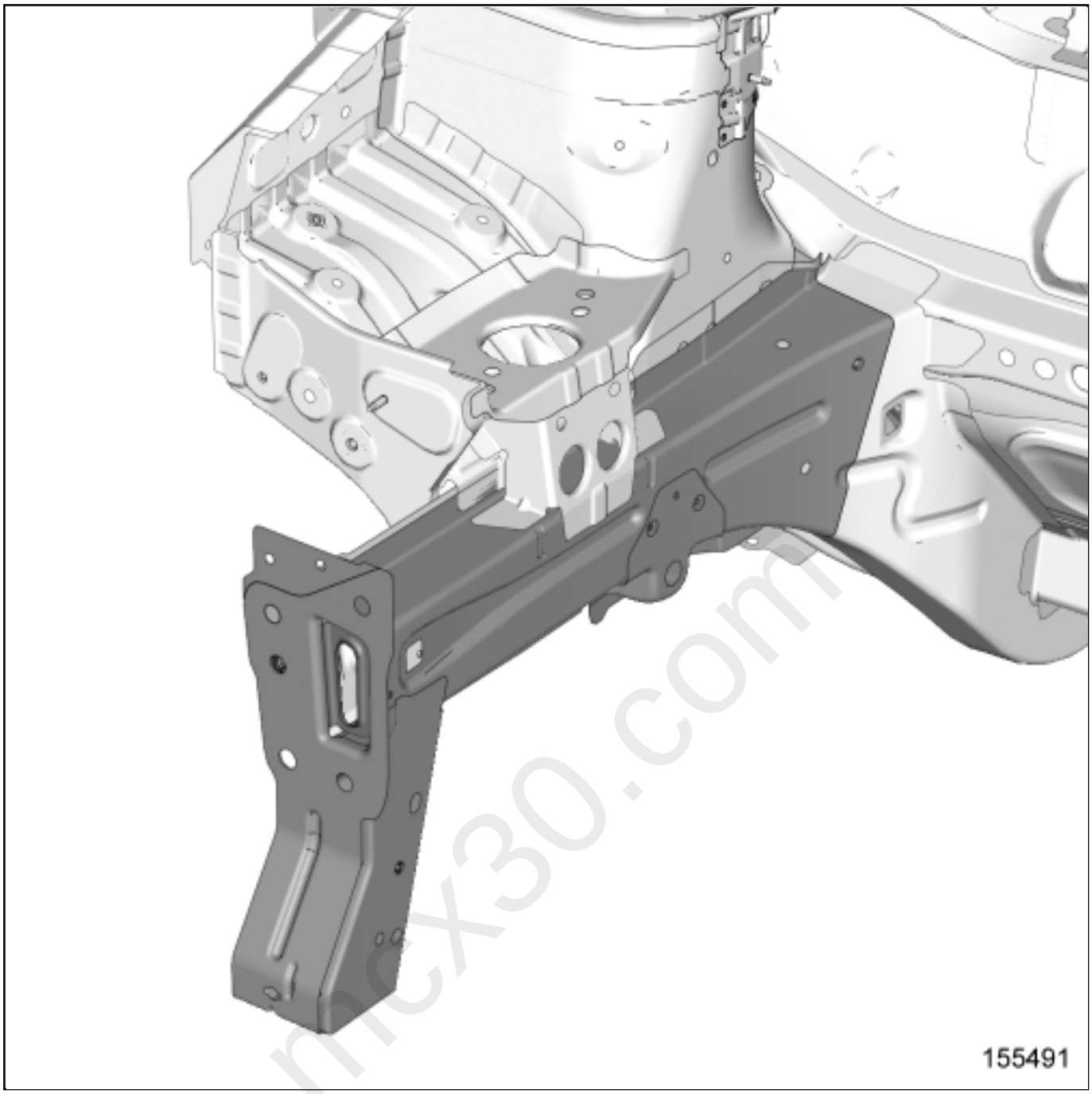
3)SPECIAL NOTES ON MATING

CAUTION

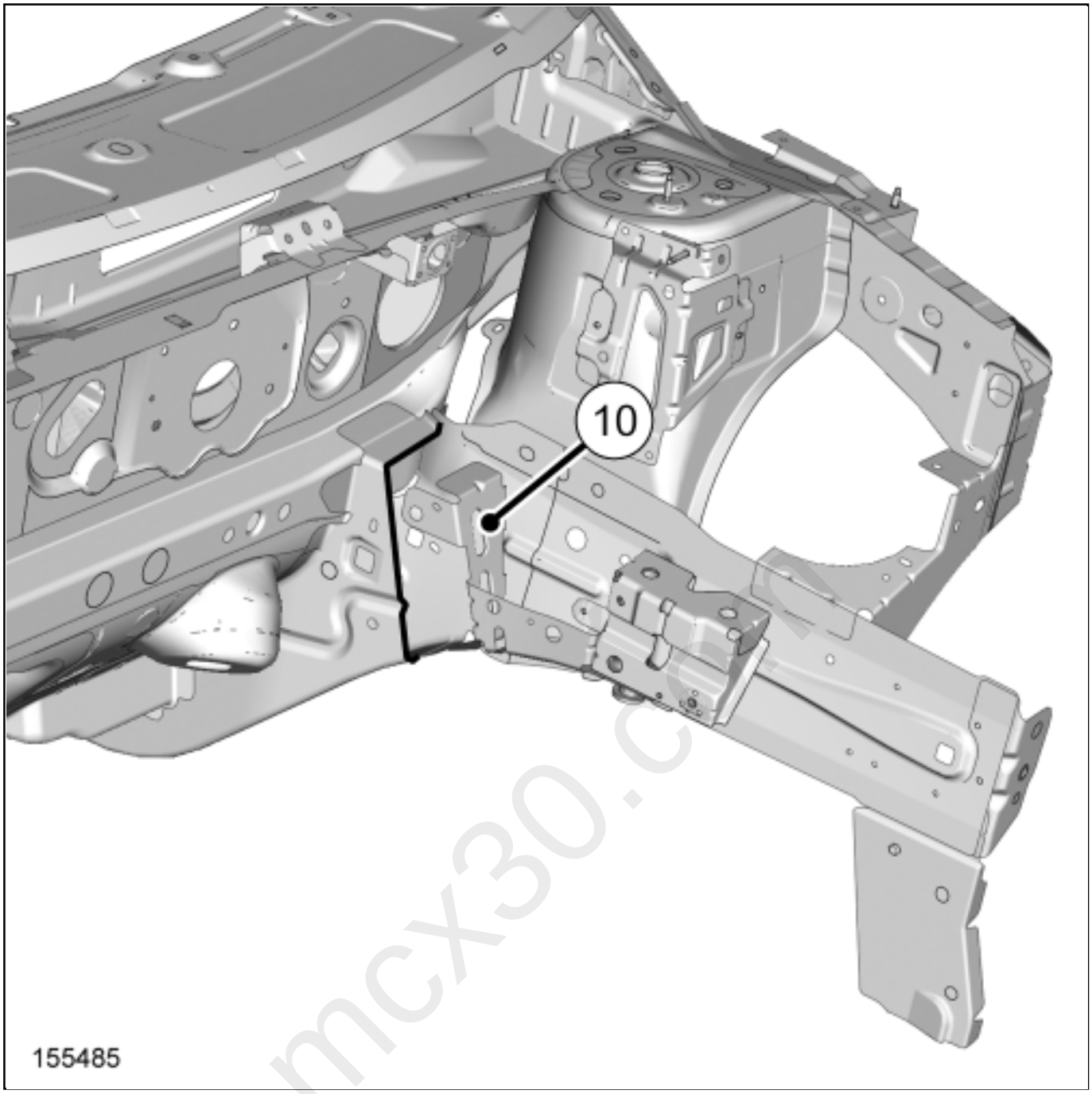
If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld**Connections by arc welding under shielding gas: Description** (MR 400, 40C, Gas metal arc welded connections (GMAW)).

3- REAR RIGHT-HAND PARTIAL REPLACEMENT A-C

1)PART IN POSITION



SPECIAL FEATURES OF CUT C



Note:

When cutting, be careful not to damage the rear inner reinforcement(10) .

2)POSITION OF ELECTRIC EARTHS