

oxygen sensors - 1/2 square drive and 24 mm hexagonal ext.([Mot. 1495](#)) connected to a universal joint
(see **Engine and transmission assembly sensors: List and location of components**) .

REFITTING

1. REFITTING PREPARATION OPERATION



Clean the threading of the upstream and downstream oxygen sensor using a wire brush.



Use surface cleaner [Vehicle: Parts and consumables for the repair](#) to clean and degrease:



the thread hole of the upstream and downstream oxygen sensor on the catalytic pre-converter,



the threading of the upstream and downstream oxygen sensor if it is to be reused.

2. REMOVAL OPERATION



Refit the upstream and downstream oxygen sensor using the tool 22 mm socket for removal - refitting of oxygen sensors - 1/2 square drive and 24 mm hexagonal ext.([Mot. 1495](#)) (see **Engine and transmission assembly sensors: List and location of components**) .



Torque tighten the upstream and downstream oxygen sensor using the tool 22 mm socket for removal - refitting of oxygen sensors - 1/2 square drive and 24 mm hexagonal ext.([Mot. 1495](#)) (see **Engine and transmission assembly sensors: List and location of components**) .



Proceed in the reverse order to removal.



PAINT BLEND: PREPARATION AND PAINT RANGE



Note, one or more warnings are present in this procedure



Note:



The blending in method should be used on adjacent components when replacing a surface component.



WARNING

Always wear protective gear (gloves, goggles and breathing masks).

Use extra ventilation source.

1. BLENDING IN METHODS

water dilutable or solvent basecoats and clearcoats.

- Procedure 1 : Water dilutable basecoat union,
- Procedure 2 : Solvent basecoat union,
- Procedure 3 : LS - MS - HS clearcoat union.

1- WATER DILUTABLE BASECOAT UNION

1)PROCEDURE 1

Standard method:

Steps	Description	Special notes
1	Degrease	Lint-free cloth soaked in surface cleaner H ₂ O Vehicle: Parts and consumables for the repair (04B, Consumables - Products). Wipe with a dry lint-free cloth
2	Wipe / blow	
3	Sand	P400 - P5000 on the repaired zones / Grey dampened abrasive finishing pad or P1000 at the edge
4	Wipe / blow	
5	Degrease	Lint-free cloth soaked in surface cleaner H ₂ O Vehicle: Parts and consumables for the repair (04B, Consumables - Products). Wipe with a dry lint-free cloth
6	Prepare the water dilutable basecoat	According to the PRODUCT TECHNICAL SHEET
7	Apply the water dilutable basecoat	a haze and one or two coats (covering) plus a fine fitting coat while overlapping towards the exterior of the repair zone Wide graduation with spray gun
8	Remove solvent / dry	Complete Masking (with or without forced ventilation)

Droplet method:

Steps	Description	Special notes
1	Degrease	Lint-free cloth soaked in surface cleaner H ₂ O Vehicle: Parts and consumables for the repair (04B, Consumables - Products). Wipe with a dry lint-free cloth
2	Wipe / blow	
3	Sand	P400 - P500on the repaired zones / Grey dampened abrasive finishing pad or P1000at the edge
4	Wipe / blow	
5	Degrease	Lint-free cloth soaked in surface cleaner H ₂ O Vehicle: Parts and consumables for the repair (04B, Consumables - Products). Wipe with a dry lint-free cloth
6	Prepare the water dilutable basecoat	According to the PRODUCT TECHNICAL SHEET
7	Apply the water dilutable basecoat	a haze and one or two coats (covering) plus a fine fitting coat while overlapping towards the exterior of the repair zone Wide graduation with spray gun
8	Dry / remove solvent	Complete Masking (with or without forced ventilation)
9	Prepare the union	Use the same mixture, reduce the air pressure so as to obtain fine spray droplets
10	Apply	a thin coat while redoing the whole graduation zone from the exterior towards the interior (the droplet appearance disappears during drying)
11	Remove solvent / dry	Complete Masking (with or without forced ventilation)

Basic stabilising additive:

Steps	Description	Special notes
1	Degrease	Lint-free cloth soaked in surface cleaner H ₂ O Vehicle: Parts and consumables for the repair (04B, Consumables - Products). Wipe with a dry lint-free cloth
2	Wipe / blow	
3	Sand	P400 - P5000 on the repaired zones / Grey dampened abrasive finishing pad or P1000 at the edge
4	Wipe / blow	
5	Degrease	Lint-free cloth soaked in surface cleaner H ₂ O Vehicle: Parts and consumables for the repair (04B, Consumables - Products). Wipe with a dry lint-free cloth
6	Prepare the water dilutable stabilising basecoat	According to the PRODUCT TECHNICAL SHEET
7	Prepare the water dilutable basecoat	According to the PRODUCT TECHNICAL SHEET
8	Apply the water dilutable stabilising basecoat	a thin coat of stabilising basecoat on the whole component
9	Apply the coloured water dilutable basecoat	On the repaired zone in one or two coats (covering), plus a fitting coat by overlapping towards the exterior of the repaired zone
10	Remove solvent / dry	Complete Masking (with or without forced ventilation)

2- SOLVENT BASECOAT UNION

1)PROCEDURE 2

Standard method:

Steps	Description	Special notes
1	Degrease	Lint-free cloth soaked in surface cleaner H ₂ O Vehicle: Parts and consumables for the repair (04B, Consumables - Products). Wipe with a dry lint-free cloth
2	Wipe / blow	
3	Sand	P400 - P500on the repaired zones / Grey dampened abrasive finishing pad or P1000at the edge
4	Wipe / blow	
5	Degrease	Lint-free cloth soaked in surface cleaner H ₂ O Vehicle: Parts and consumables for the repair (04B, Consumables - Products). Wipe with a dry lint-free cloth
6	Prepare the solvent basecoat	Dilute the basecoat according to the PRODUCT TECHNICAL SHEET
7	Apply the solvent basecoat	Apply two or three coats of this mixture to obtain the cover while slightly overlapping towards the exterior of the repaired zone
8	Remove solvent / dry	Masking between each coat, leave for 15 minutes before applying the clearcoat

3- LS - MS - HS CLEARCOAT UNION