

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)).



[Repair-40x09x26x02-02x49-1-5-1.xml](#)



XSL version : 3.02 du 22/07/11

REARENDPANEL:REPLACEMENT

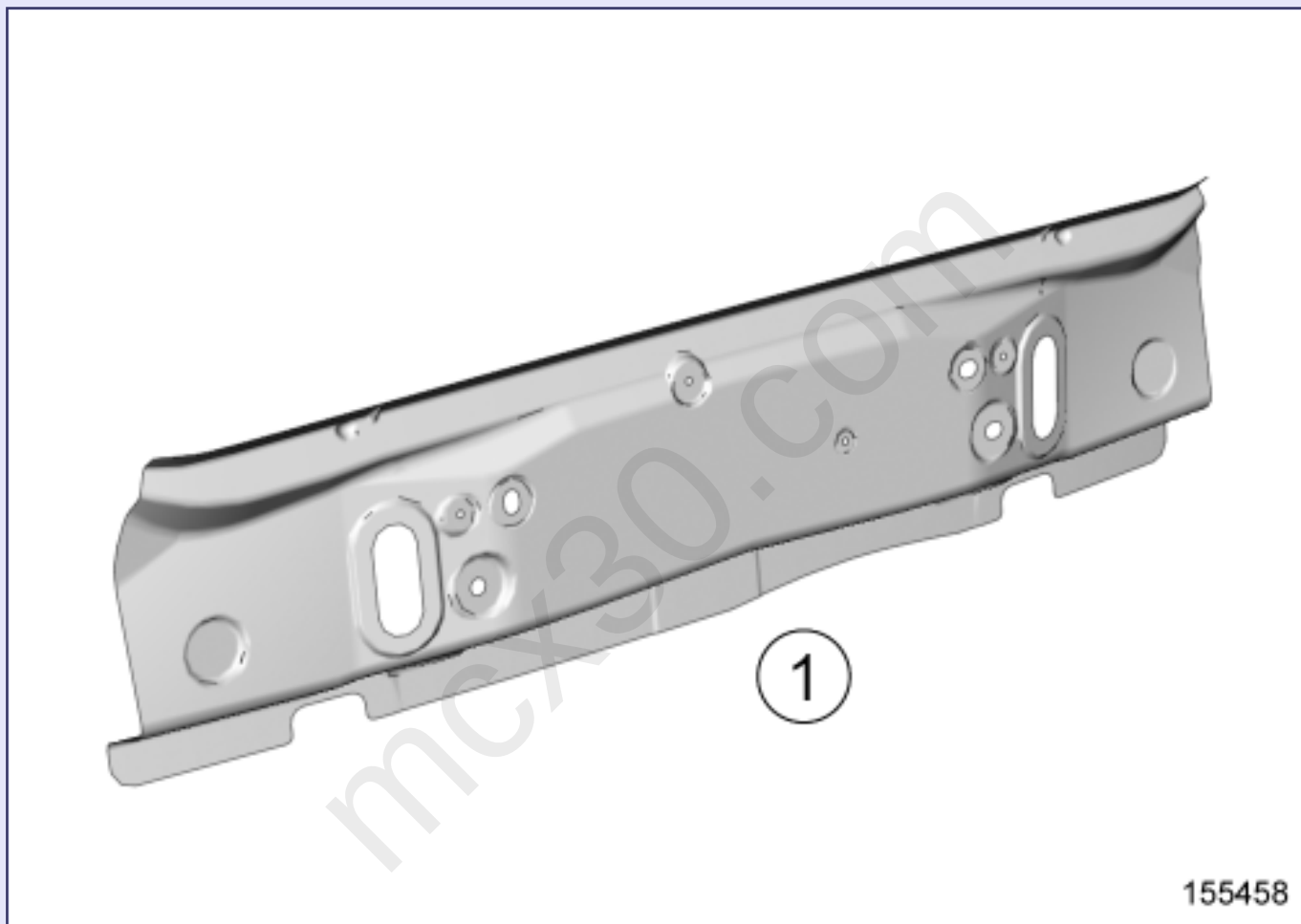


Note, one or more warnings are present in this procedure



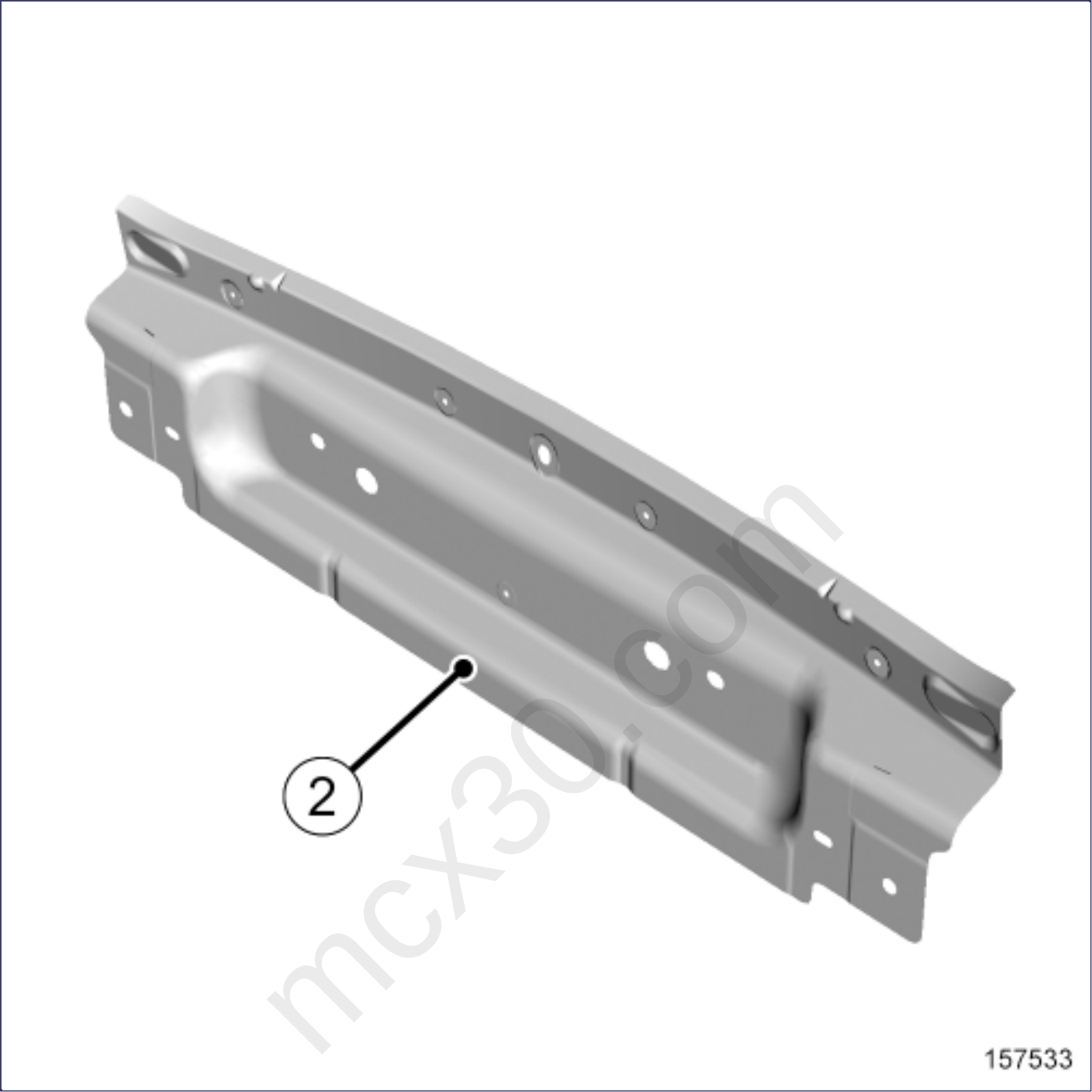
1. COMPOSITION OF THE SPARE PART

B98(B98)



155458

No.	Description	Type	Thickness (mm)
(1)	Rear end panel	Mild steel	0.85



No.	Description	Type	Thickness (mm)
(2)	Rear end panel	Mild steel	0.85



There is only one way of replacing this part:

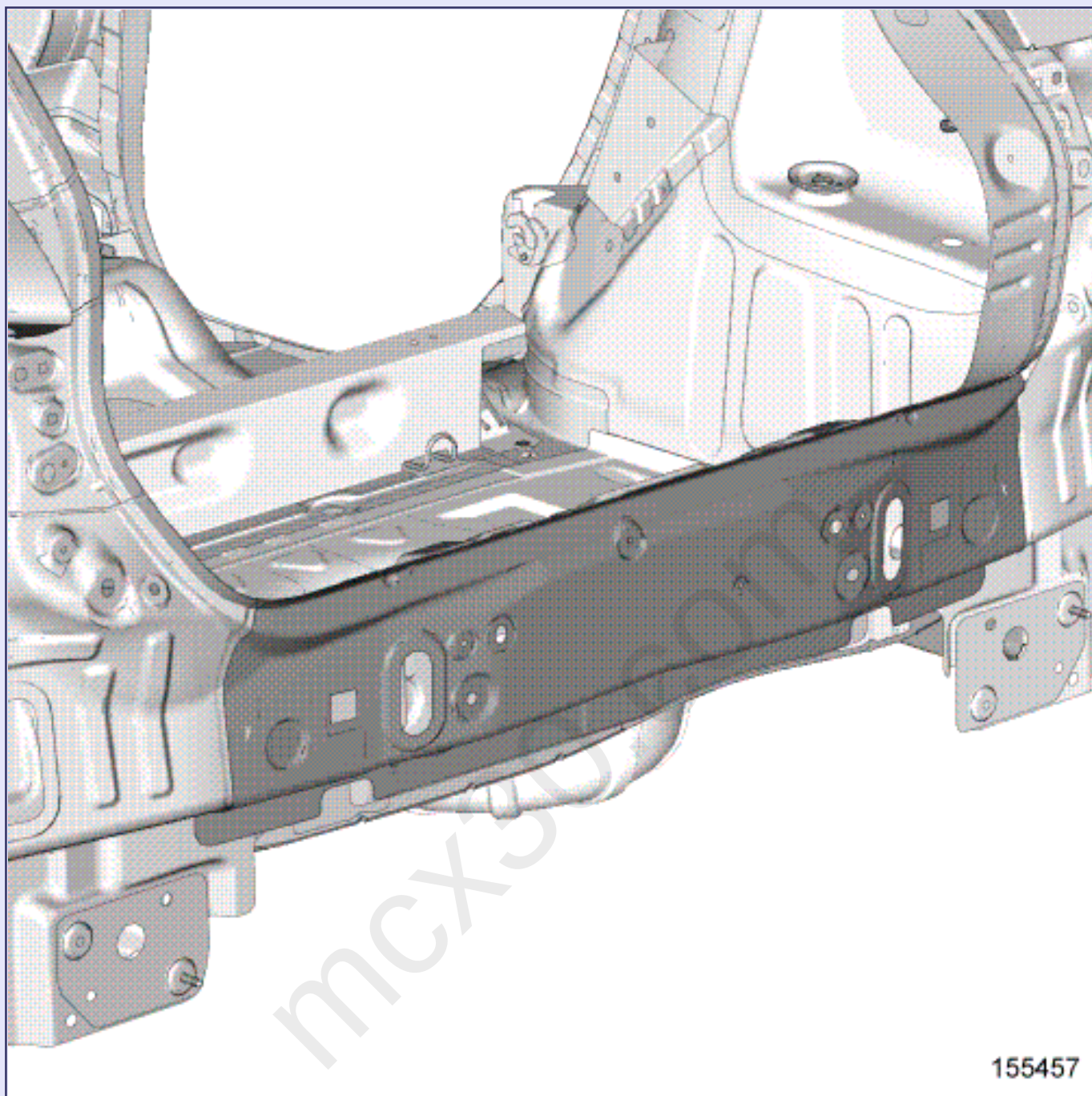


complete replacement.

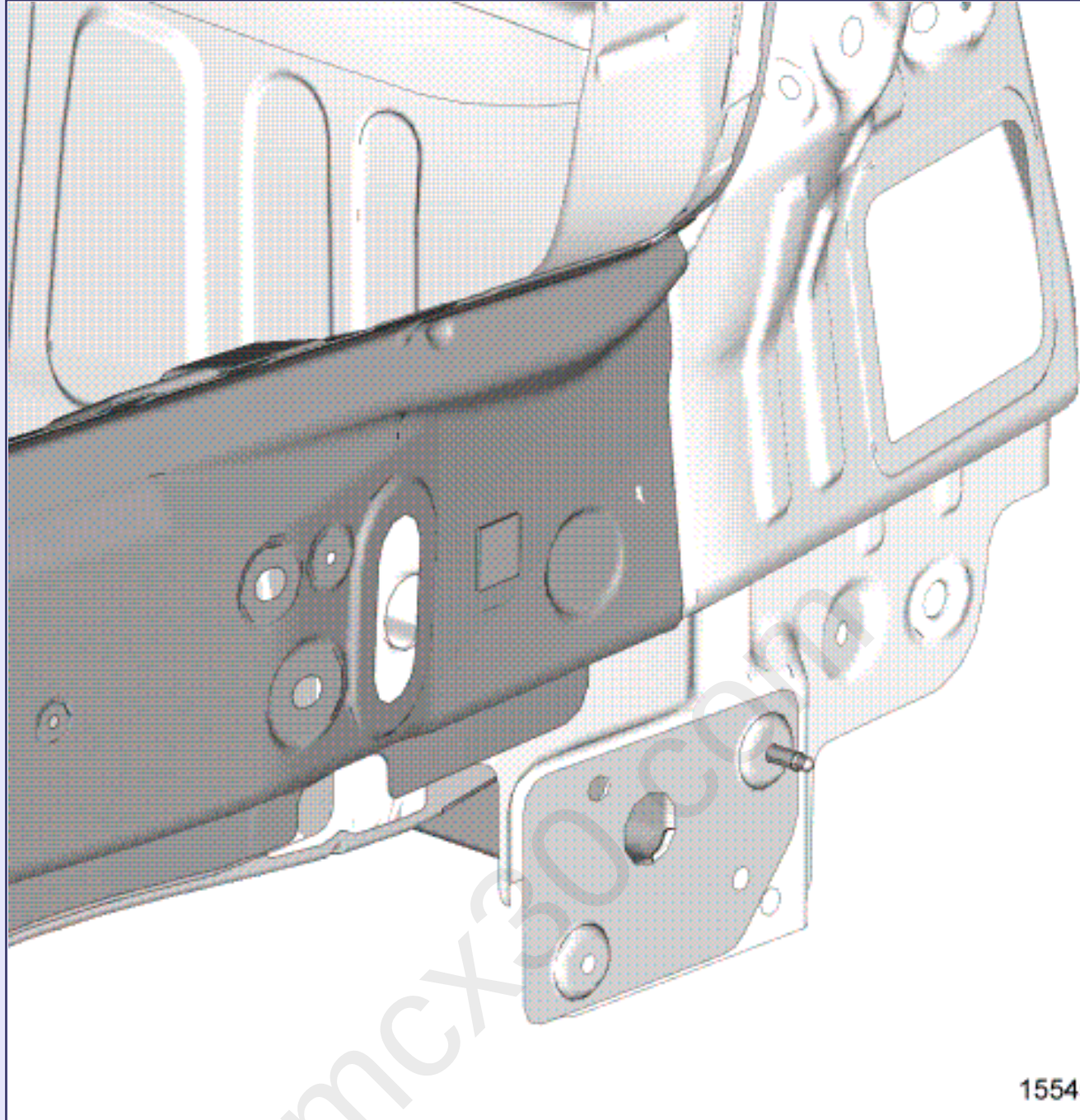
1- COMPLETE REPLACEMENT

1)PART IN POSITION

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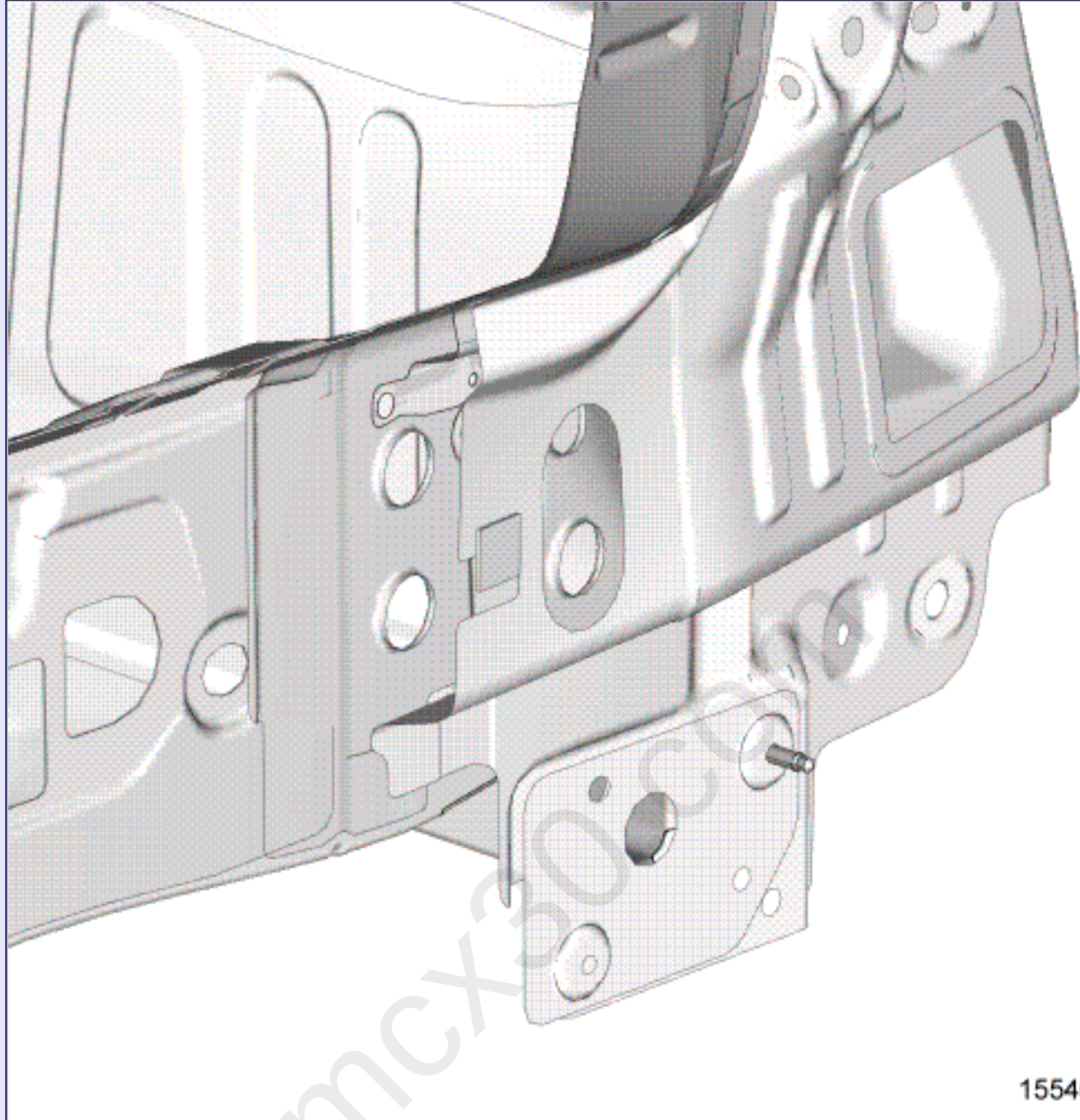


DETAILED VIEW

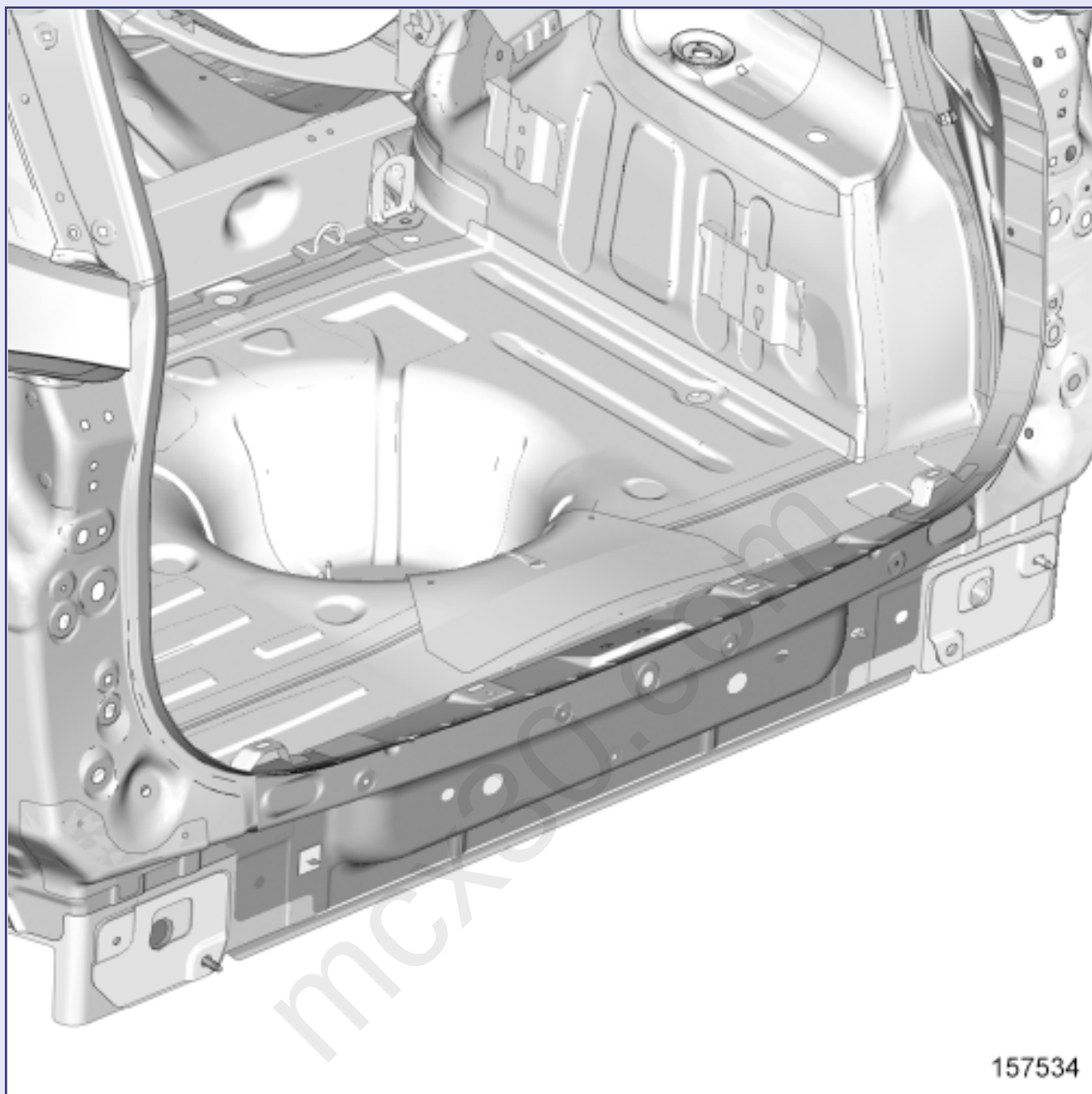


155459

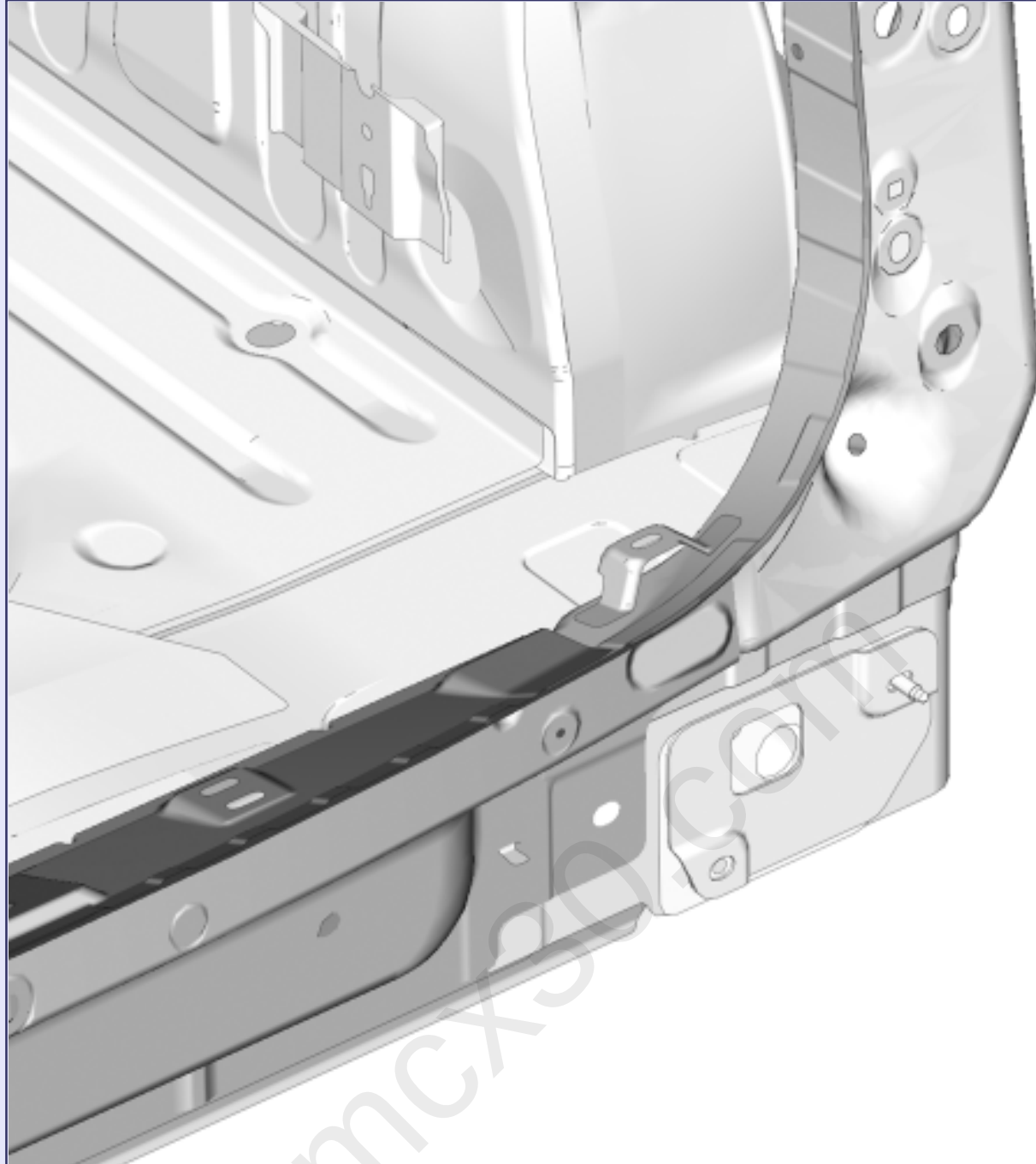
DETAILED VIEW WITHOUT PART



155460

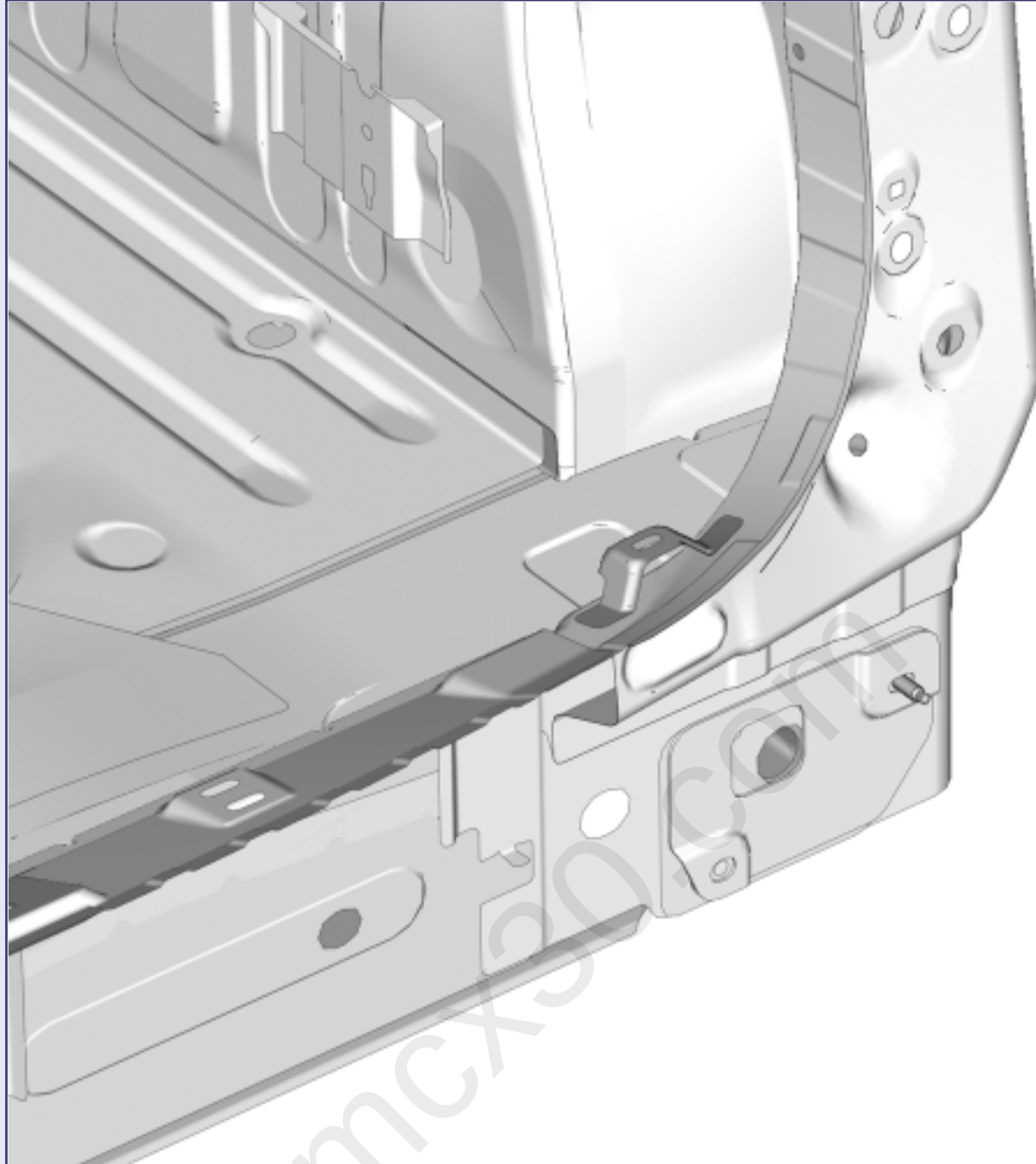


DETAILED VIEW



157535

DETAILED VIEW WITHOUT PART



157536

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).