

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-40x09x26x01-02x49-1-8-1.xml



XSL version : 3.02 du 22/07/11

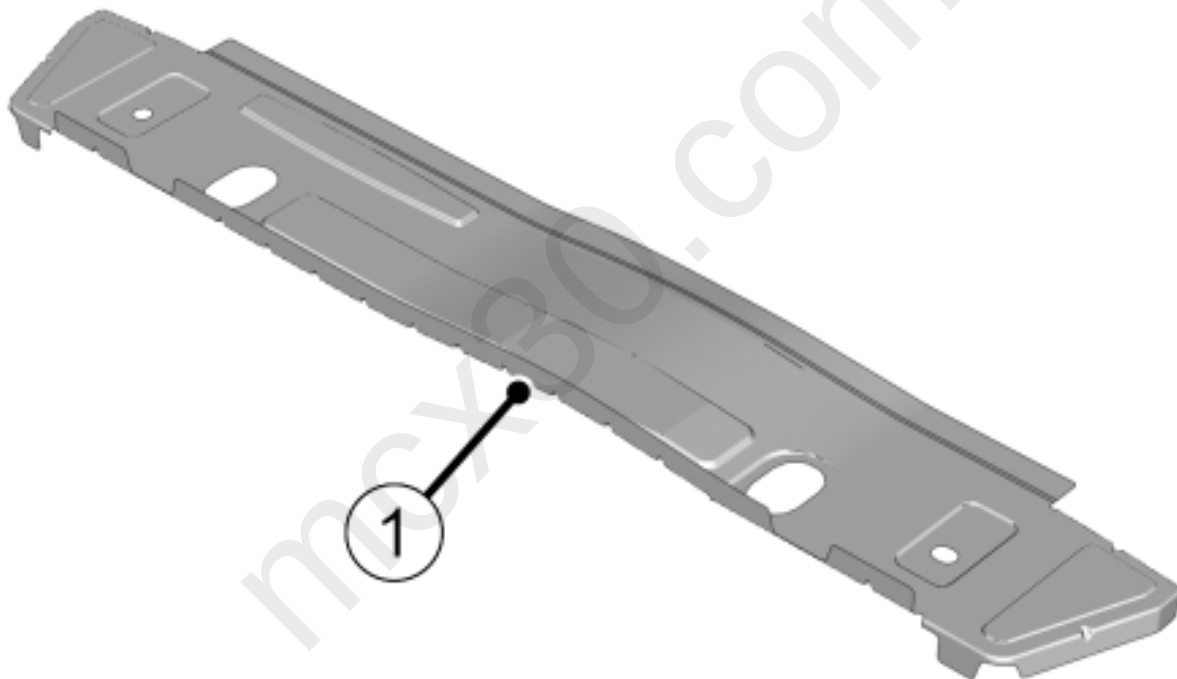
REARFLOOREXTENSION :REPLACEMENT



Note, one or more warnings are present in this procedure



1. COMPOSITION OF THE SPARE PART



157437

No.	Description	Type	Thickness (mm)
(1)	Rear floor extension	HLE	0.65

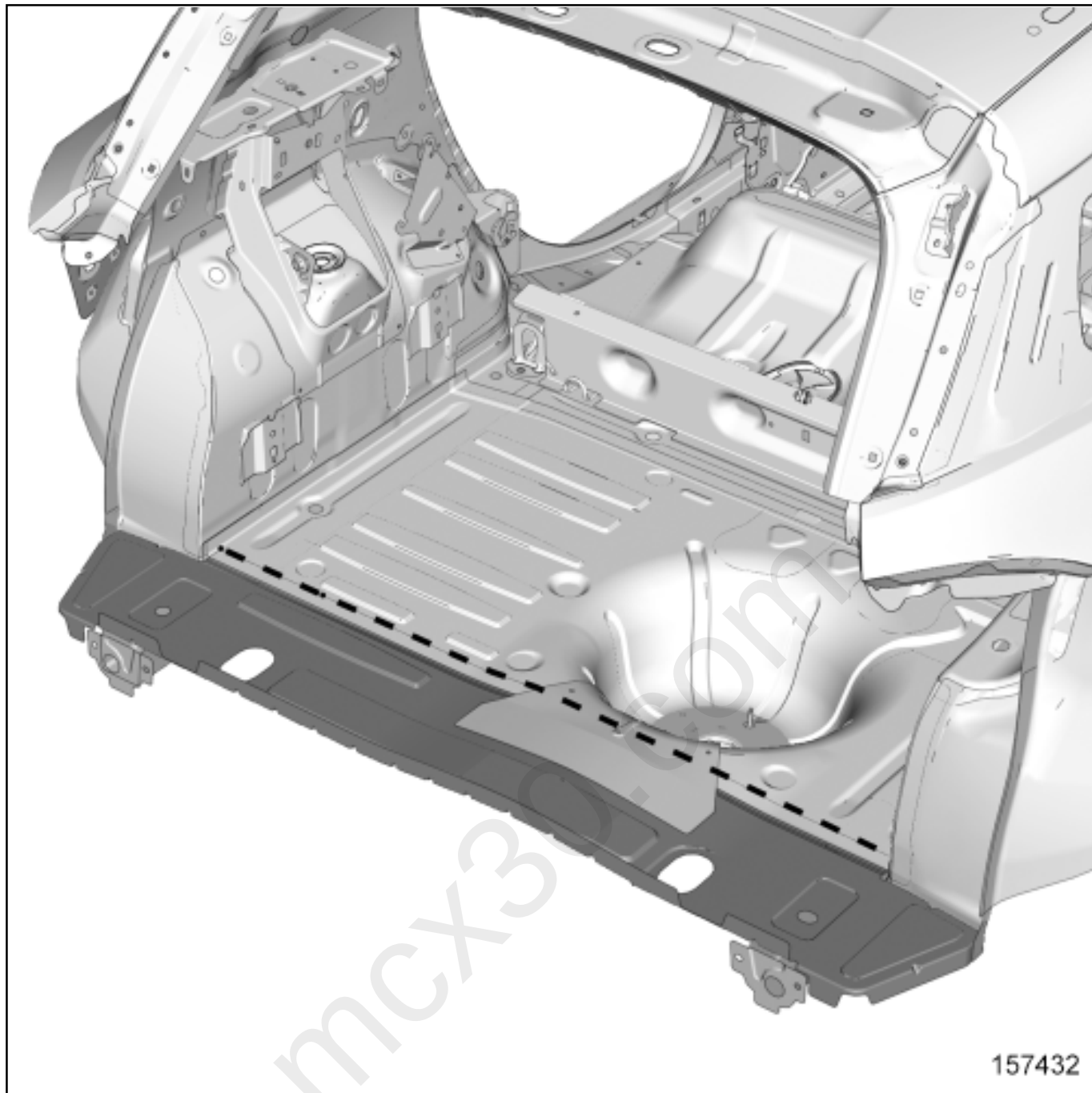
2. IN THE EVENT OF REPLACEMENT

There is only one way of replacing this part:

complete replacement.

1- COMPLETE REPLACEMENT

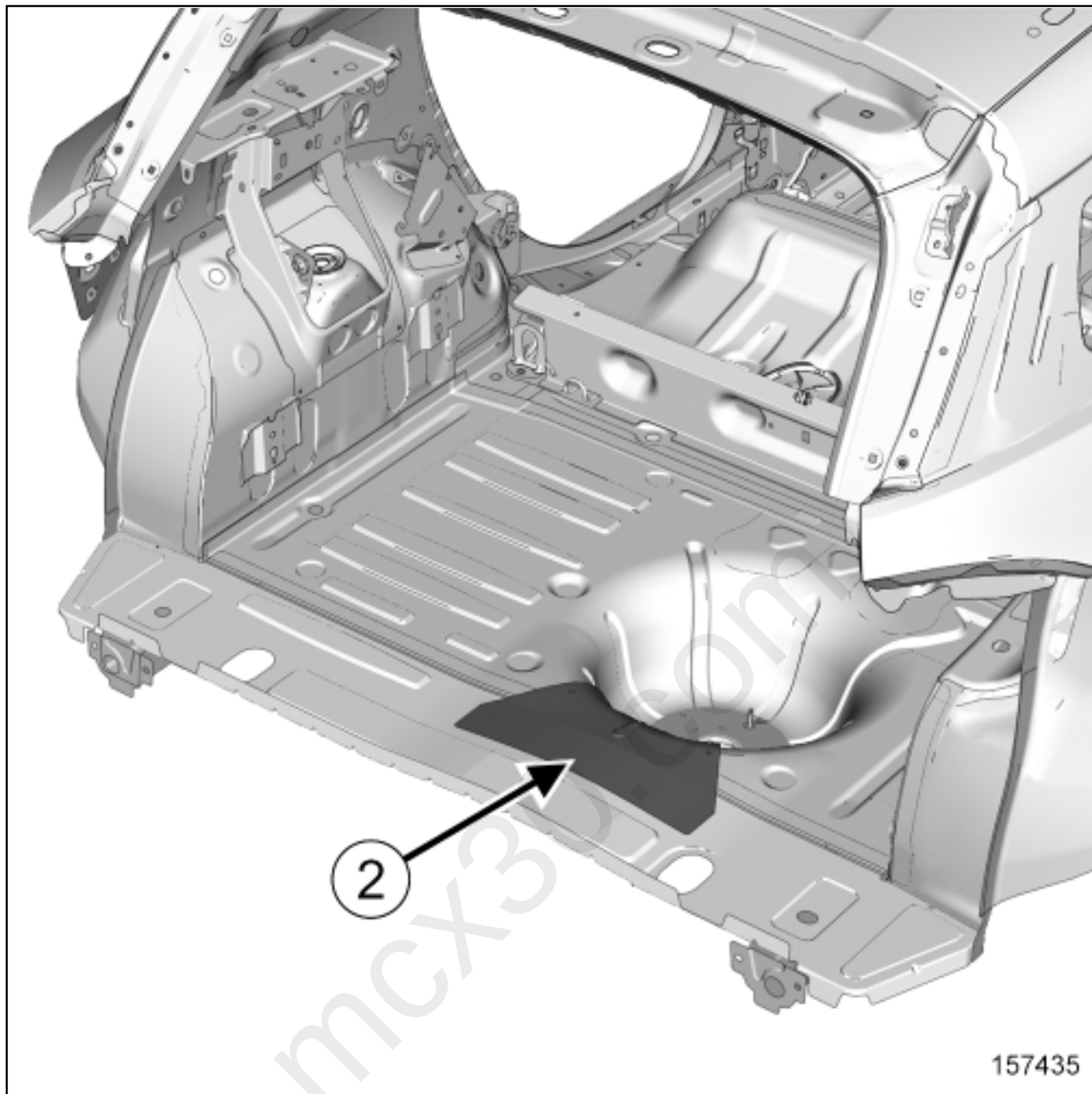
1)PART IN POSITION



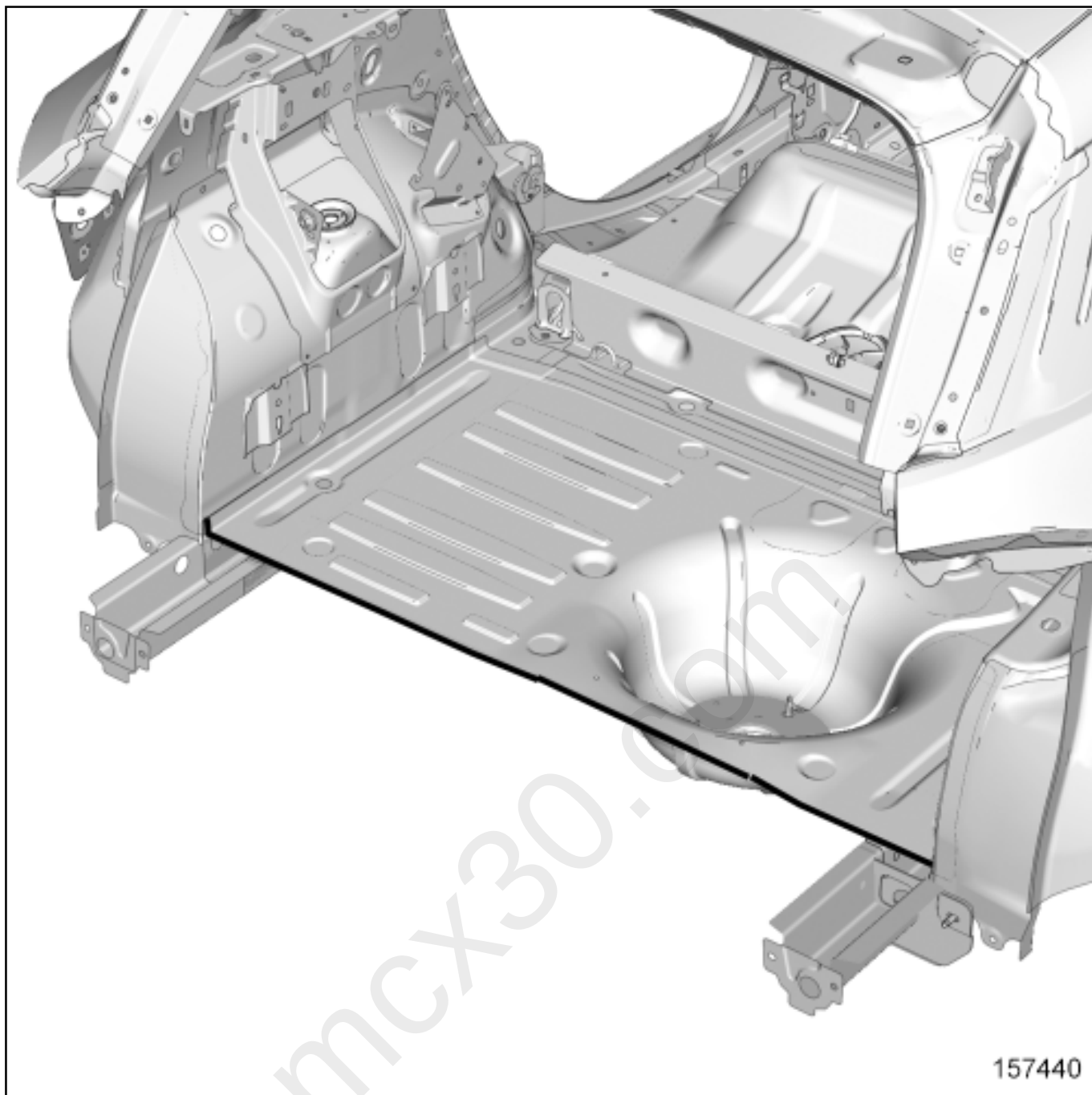
Note:



When performing the replacement of the rear floor extension, also order the emergency spare wheel compartment rear reinforcement⁽²⁾.



DETAILED VIEW OF CUT



2) POSITION OF ELECTRIC EARTHS

CAUTION

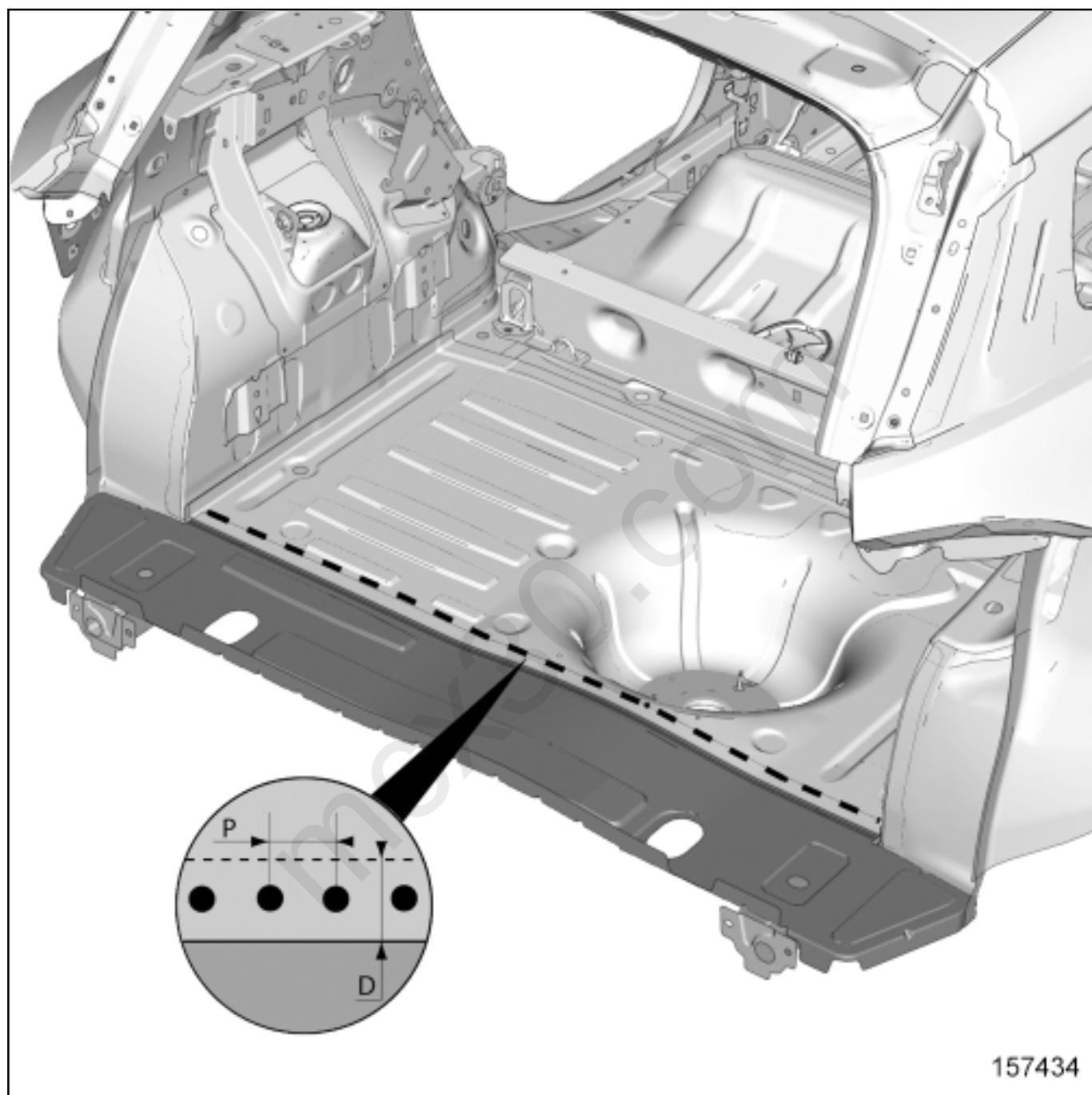


To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

Position the earth of the welding machine as close as possible to the weld area (see Bolted connection for earth: Fitting) .

Locate the earths located near to the weld area [Earths on body: List and location of components](#) .

3)SPECIAL NOTES ON MATING



P (Pitch) = 25 mm

D = covering dimension