

mcx30.com

REAR SIDE PANEL: REPLACEMENT

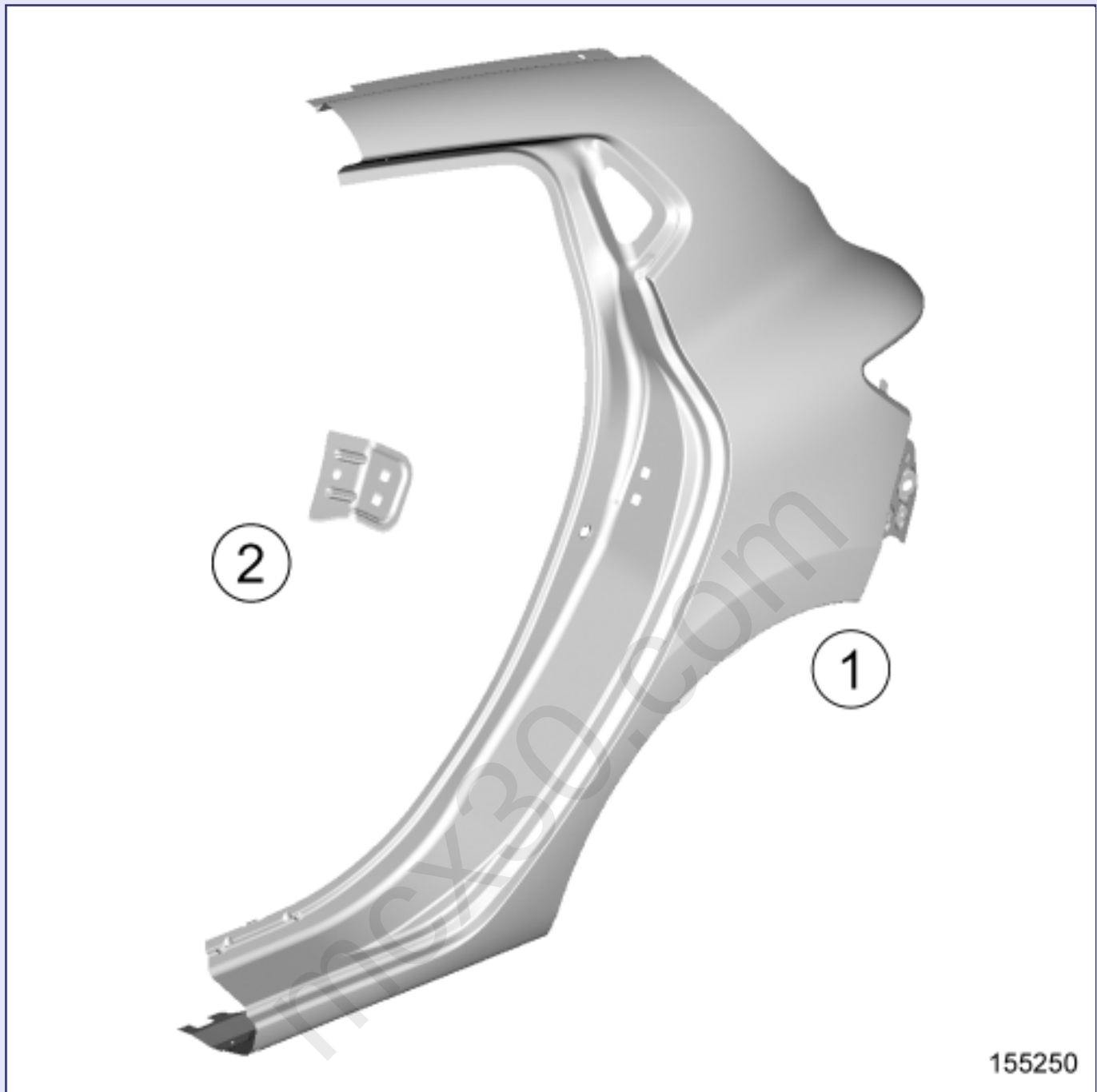


Note, one or more warnings are present in this procedure



1. COMPOSITION OF THE SPARE PART

mcx30.com



155250

No.	Description	Type	Thickness (mm)
(1)	Rear side panel	Mild steel	1.5
(2)	Door striker panel reinforcement	Mild steel	1.5



157828

No.	Description	Type	Thickness (mm)
(3)	Rear side panel	Mild steell	1.5

2. IN THE EVENT OF REPLACEMENT

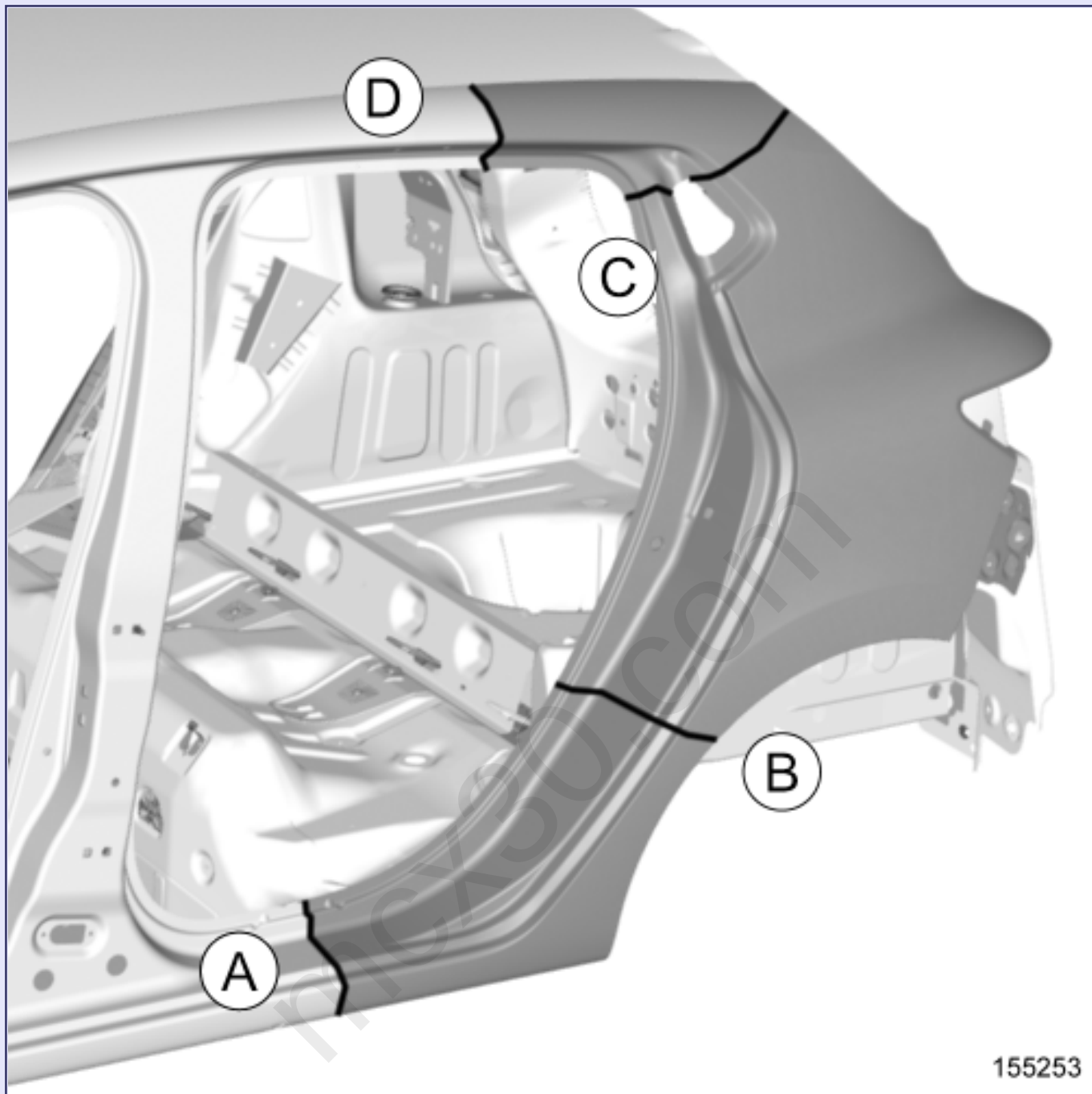


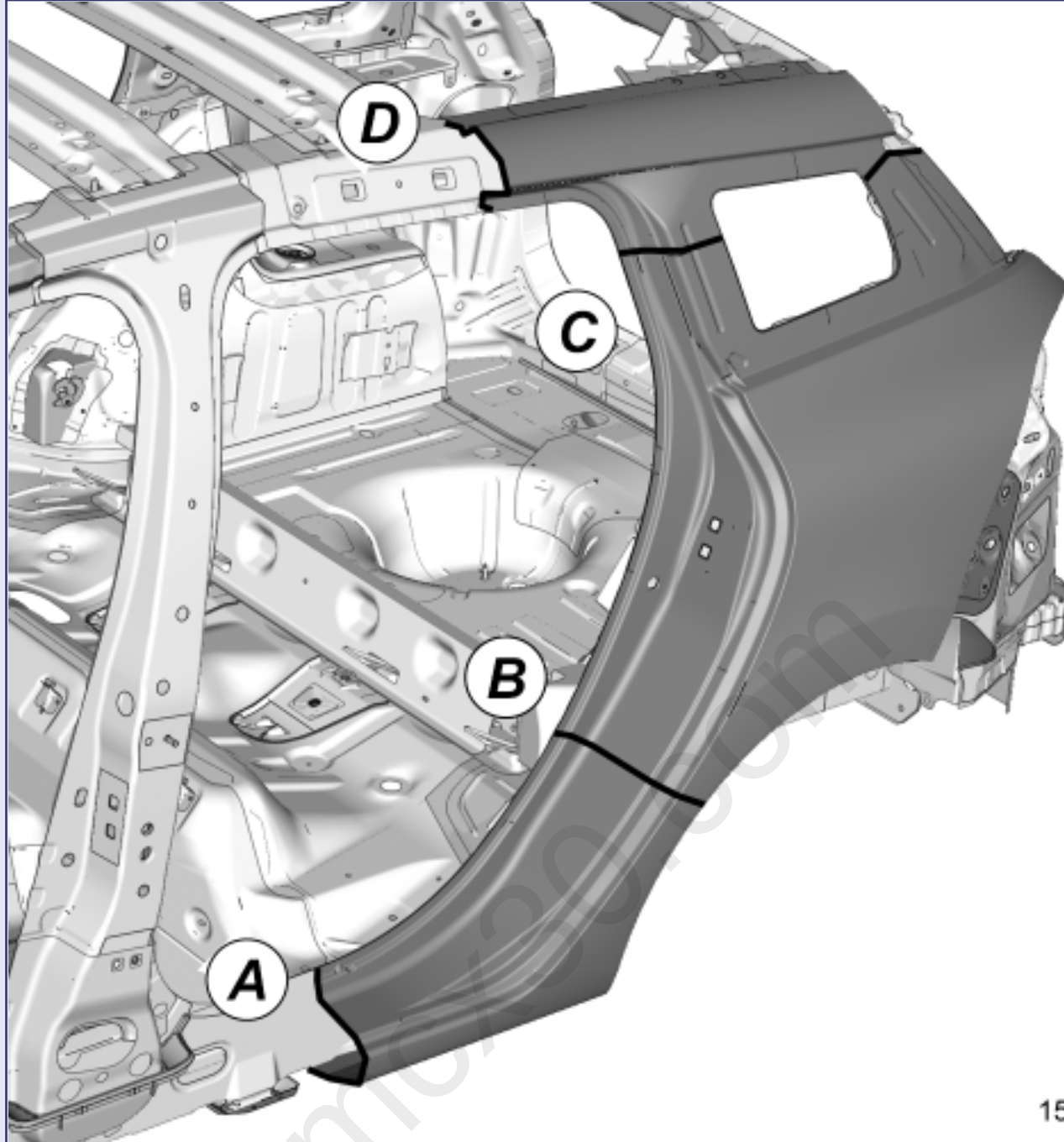
The options for replacing this part are as follows:



- complete replacement A-D,
- partial replacement A-C,
- partial replacement B-C.

mcx30.com





157829

1- 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. [Earth screw connection: Description](#) (MR 400, 40H, Bolted connections).

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

2- SPECIAL NOTES ON MATING



CAUTION

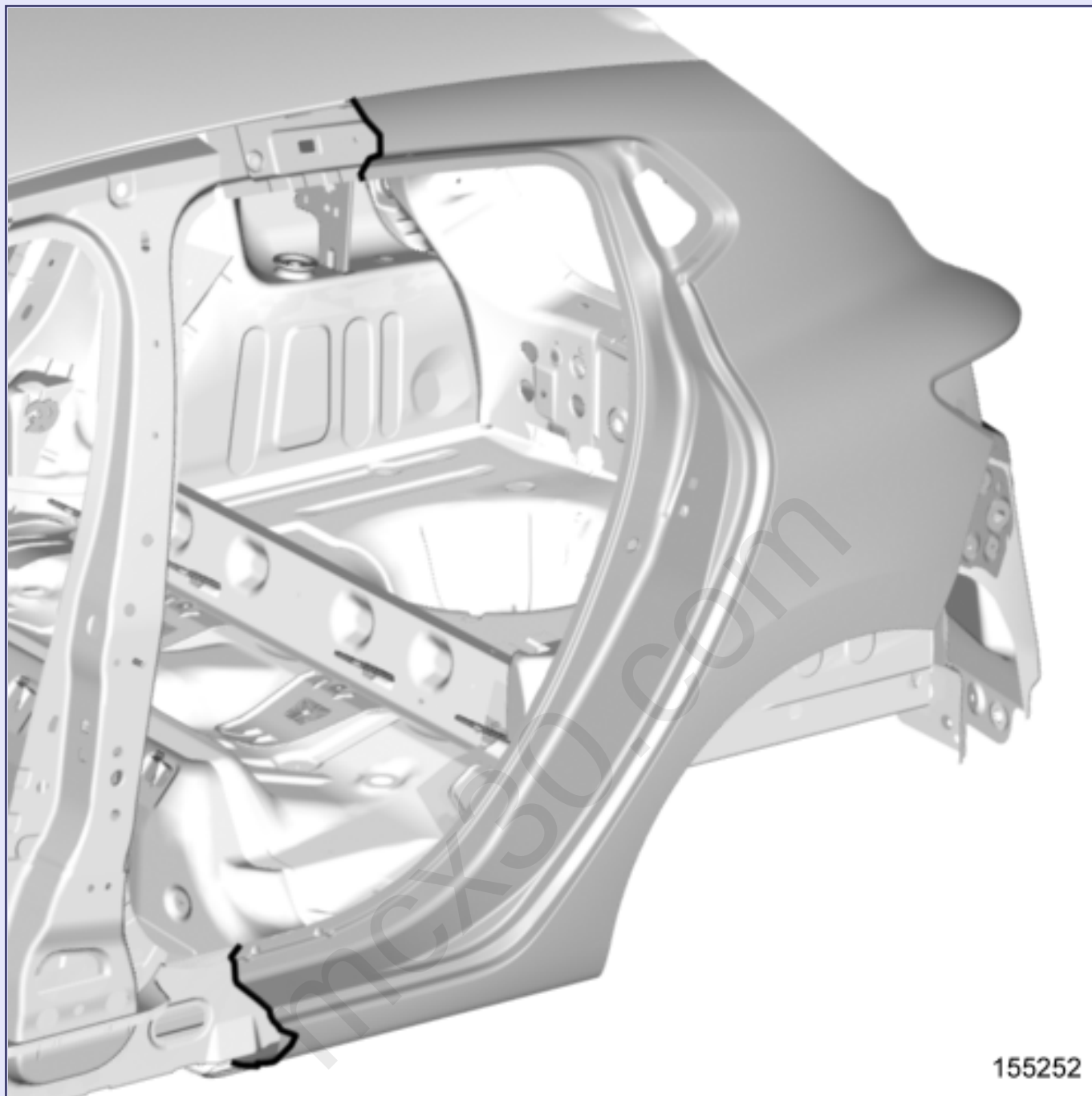
If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld [Connections by arc welding under shielding gas: Description](#) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

3- COMPLETE REPLACEMENT A-D

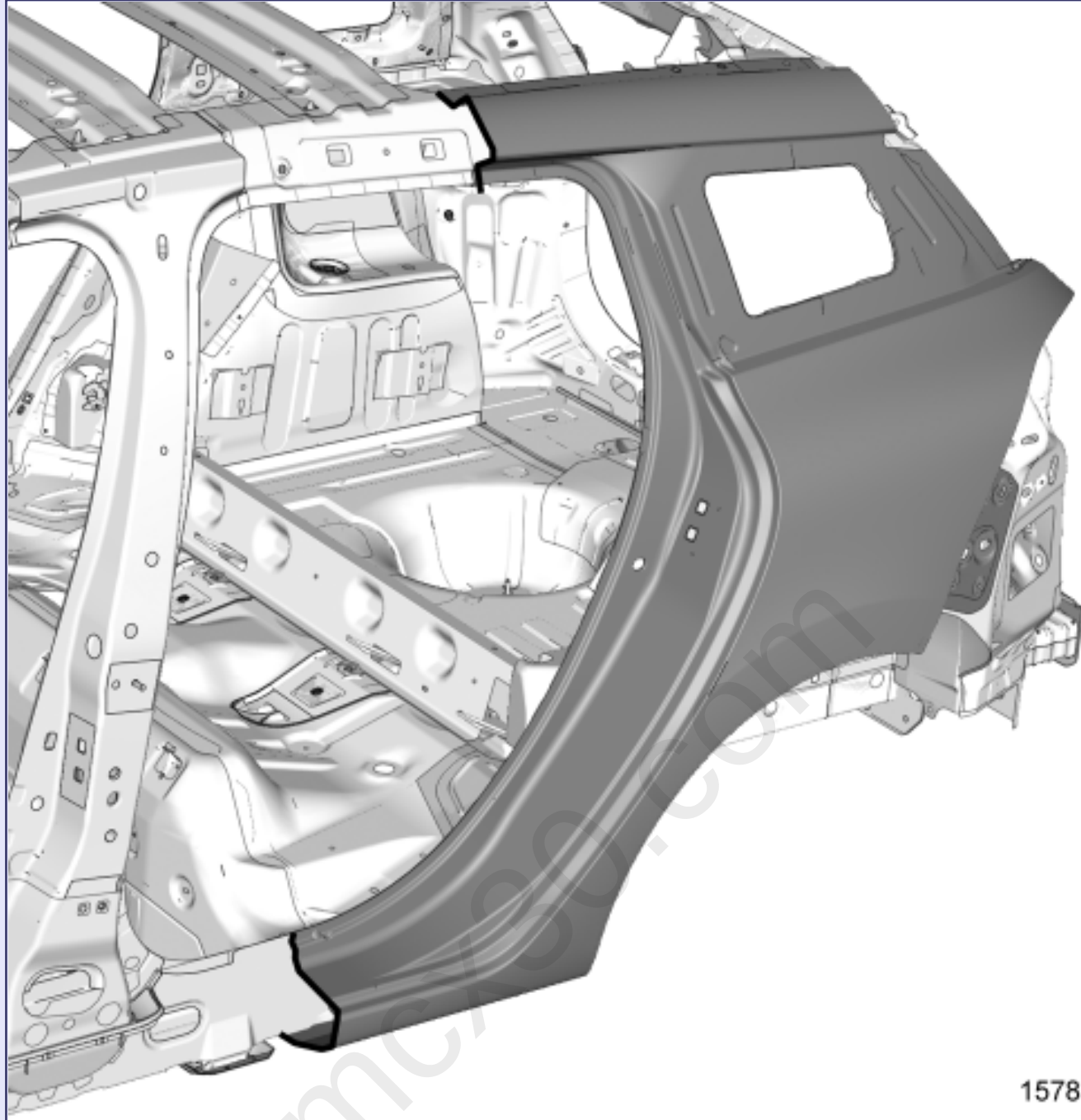
1)PART IN POSITION

mcx30.com

B98(B98) CUT



K98(K98) CUT

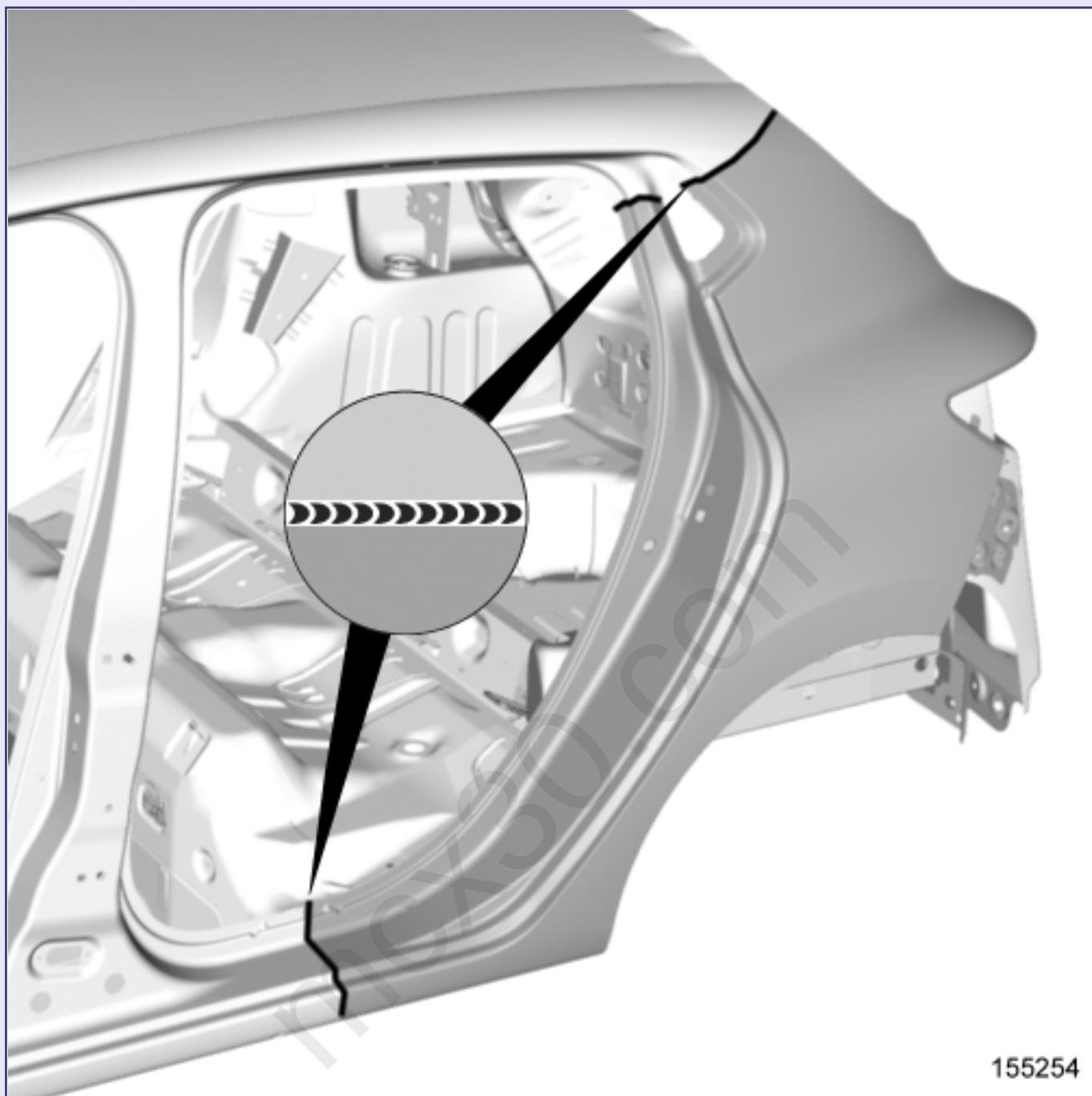


157838

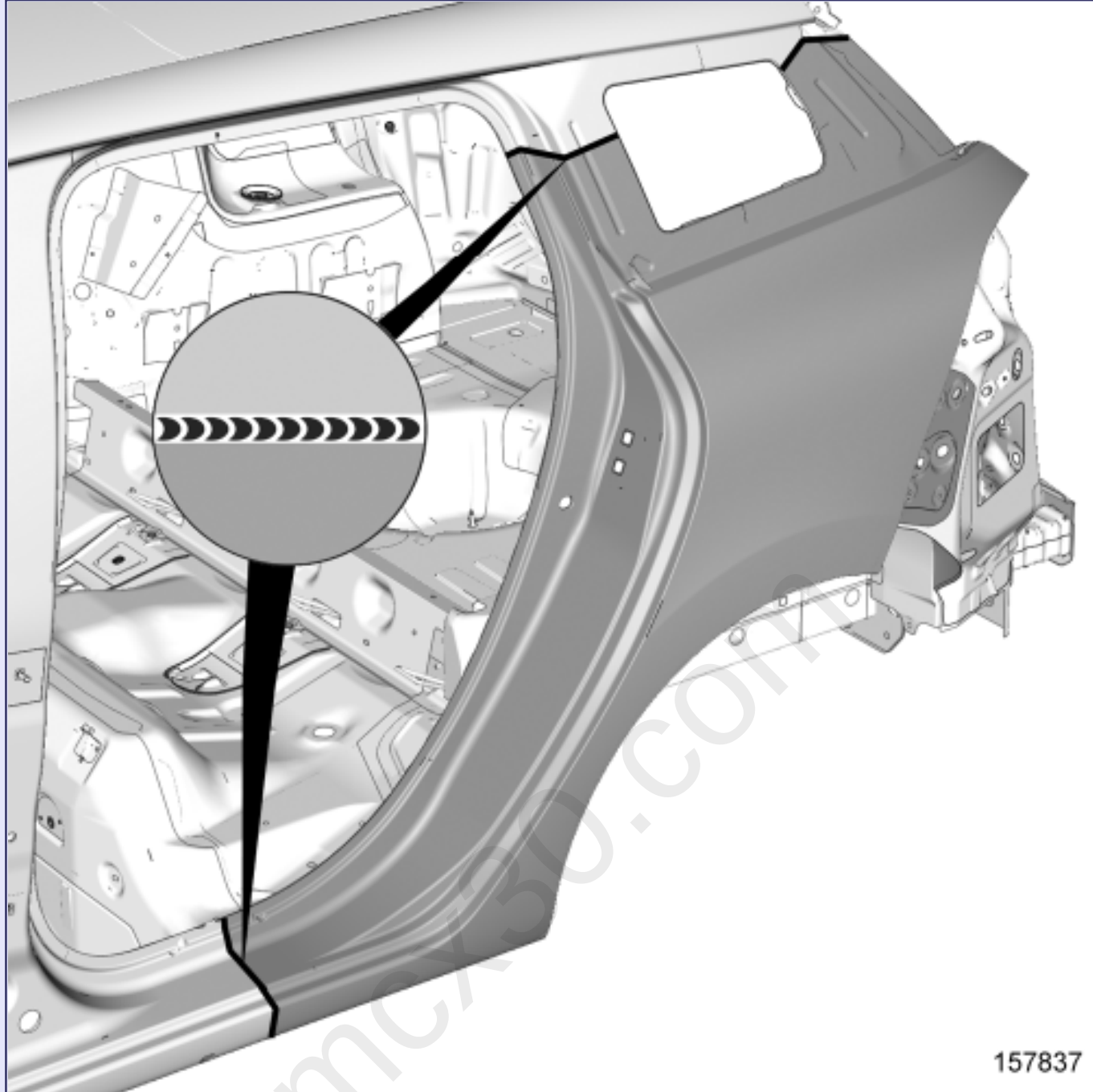
4- PARTIAL REPLACEMENT A-C

1)PART IN POSITION

B98(B98)



K98(K98)



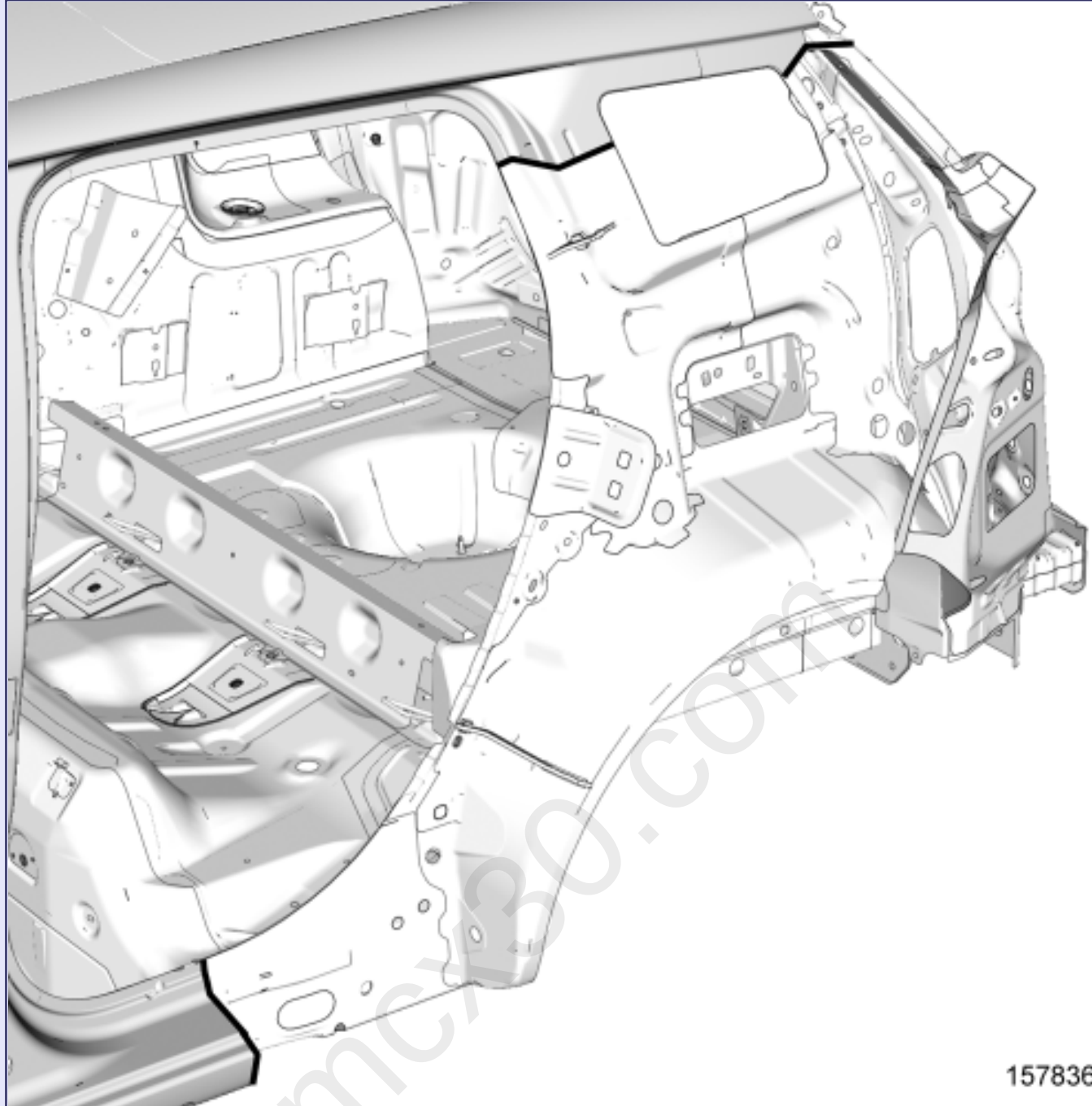
Use a butt weld [Connections for edge to edge partial replacements: Description](#) (MR 400, 40E, Partial replacement connections).

2) DETAILED VIEW OF CUT A-C

B98(B98)

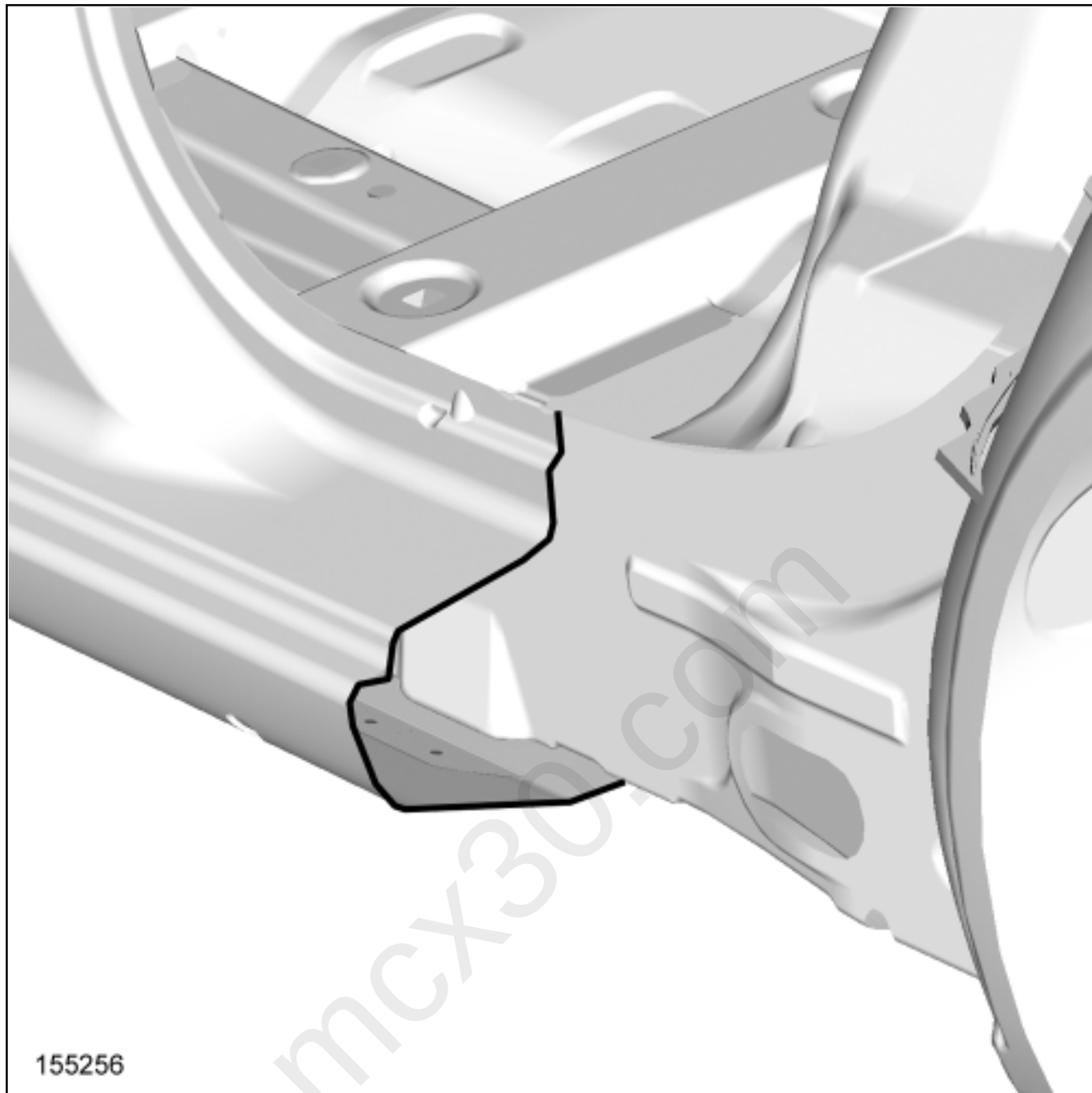


K98(K98)



157836

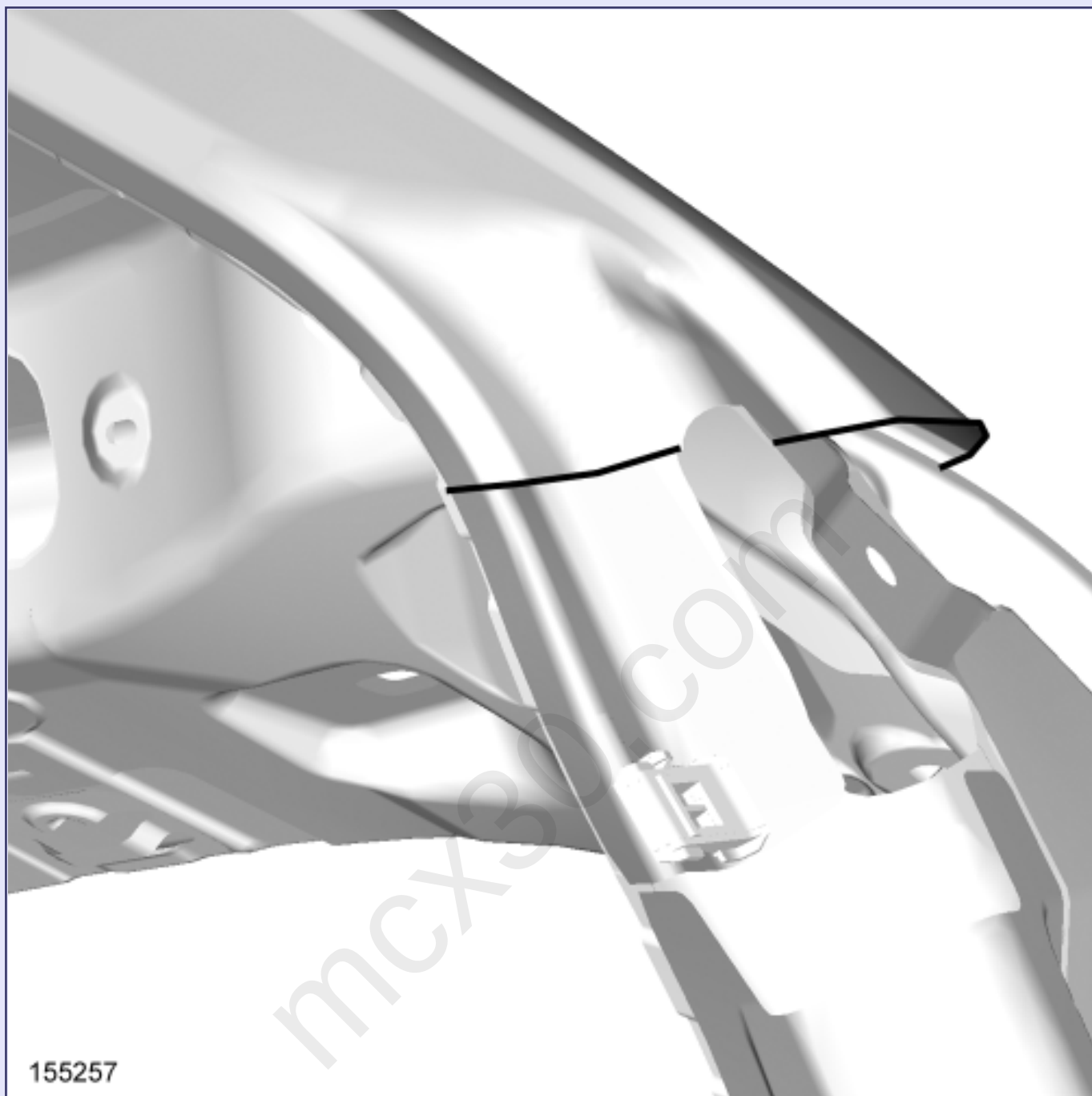
3)DETAILED VIEW A



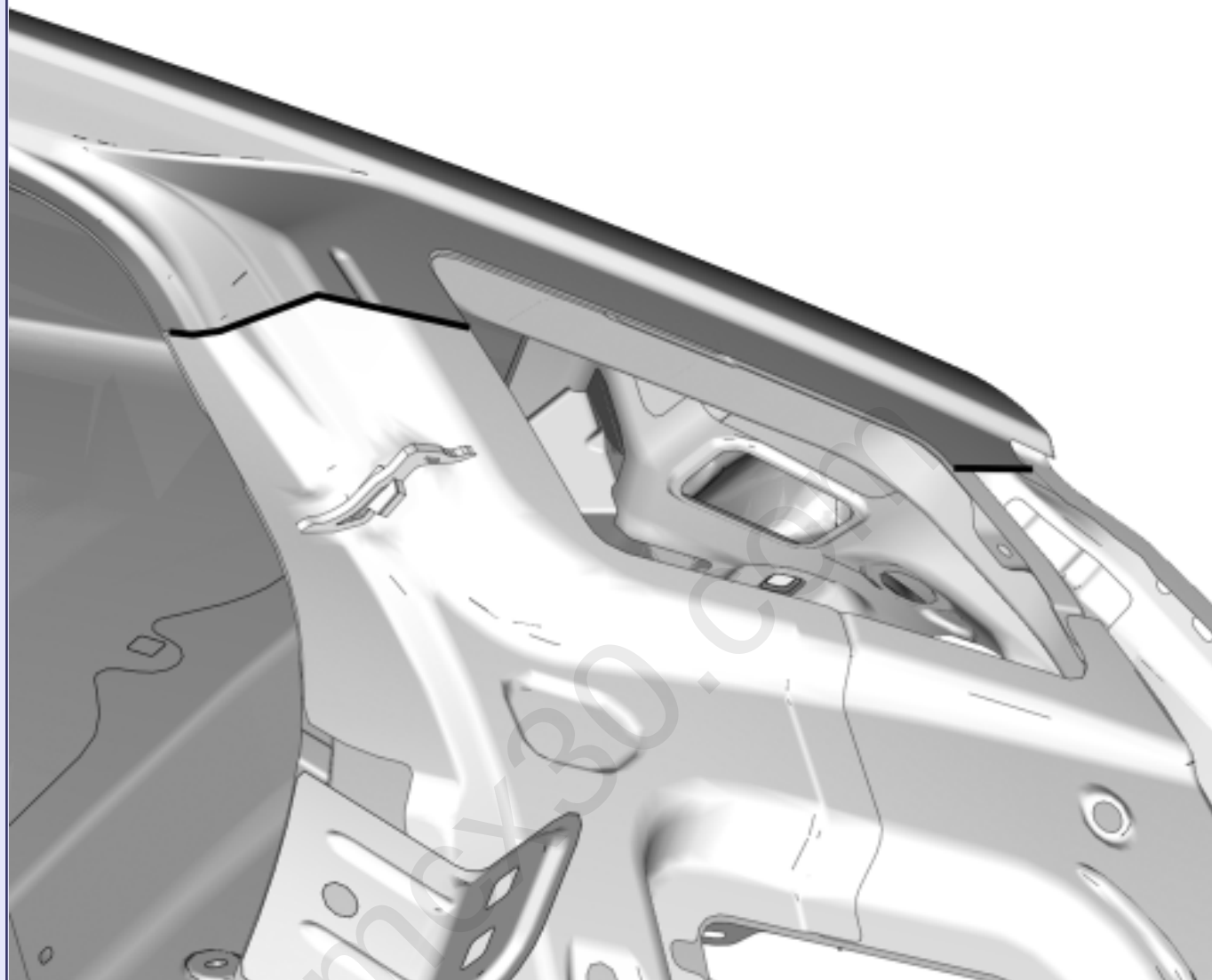
155256

4) DETAILED VIEW C

B98(B98)



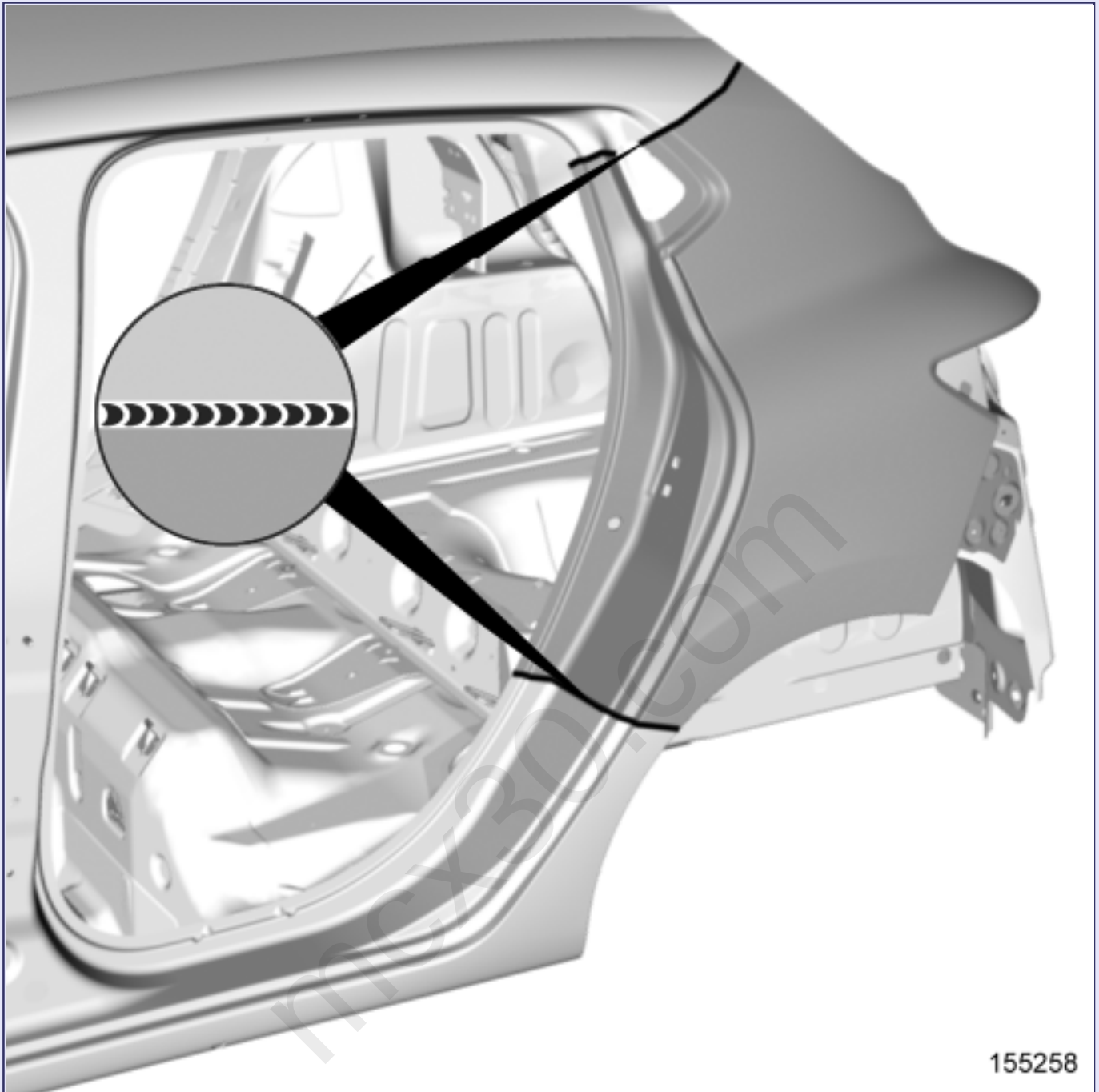
K98(K98)



5- PARTIAL REPLACEMENT B-C

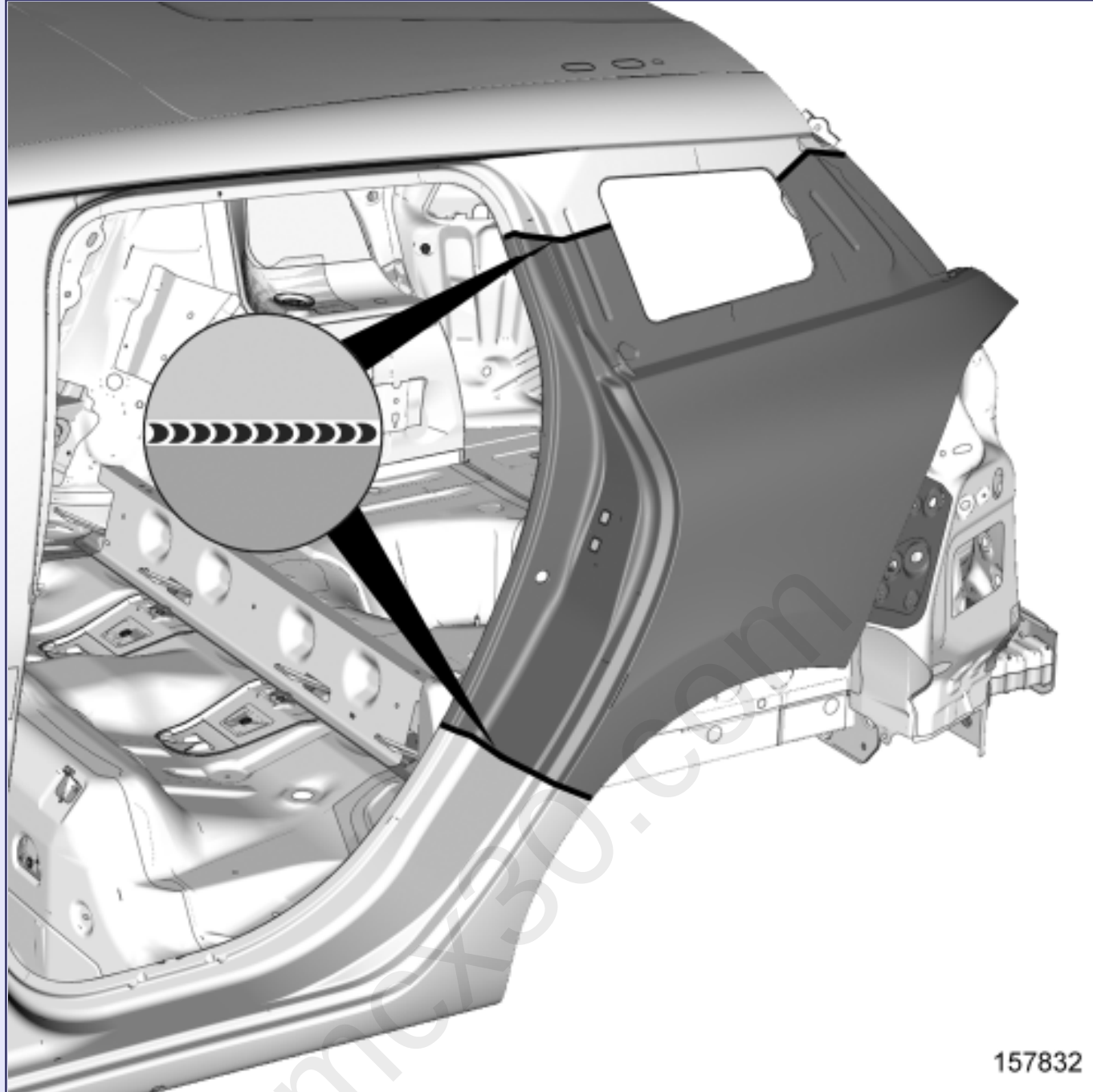
1)PART IN POSITION

B98(B98)



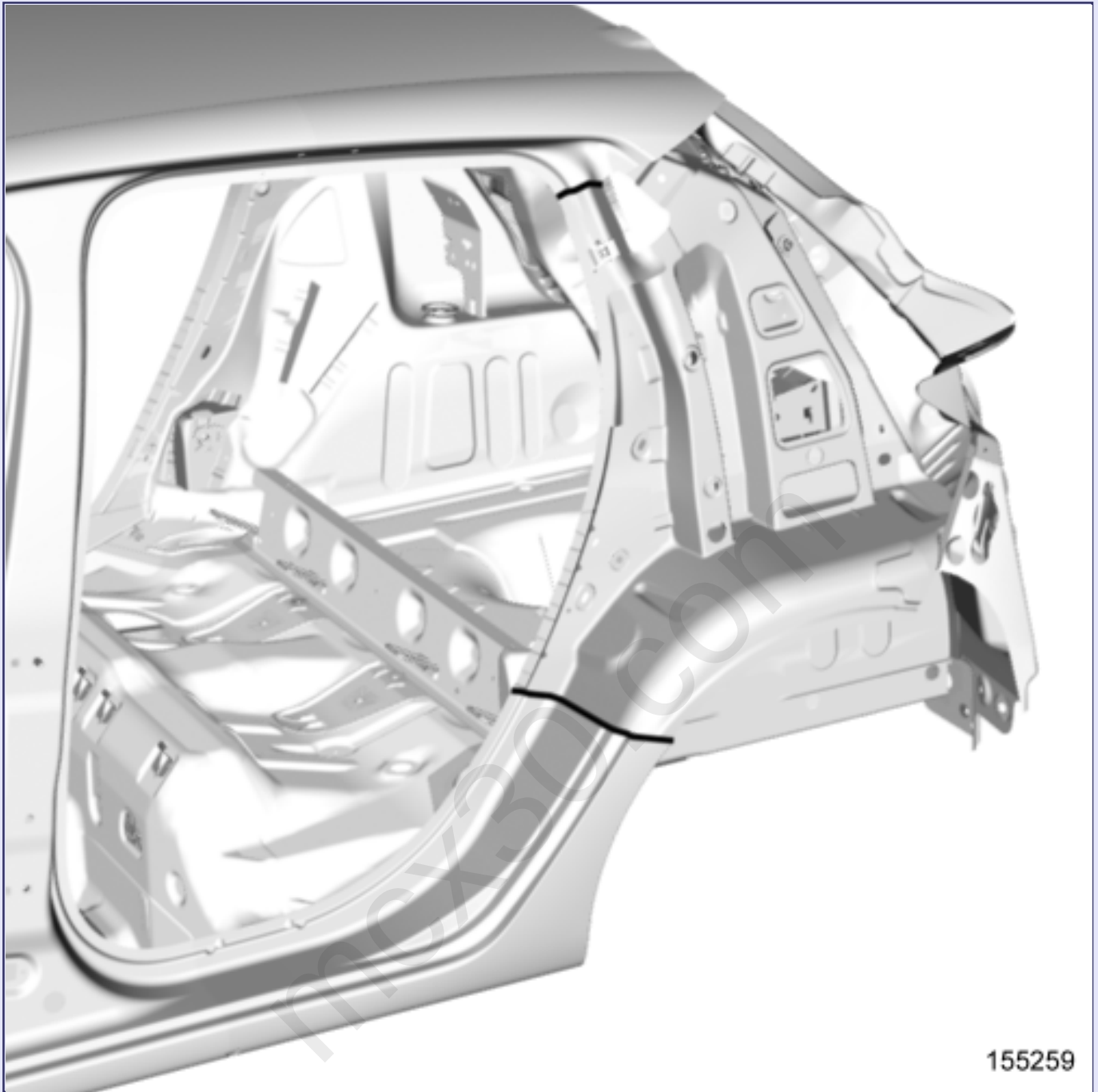
155258

K98(K98)

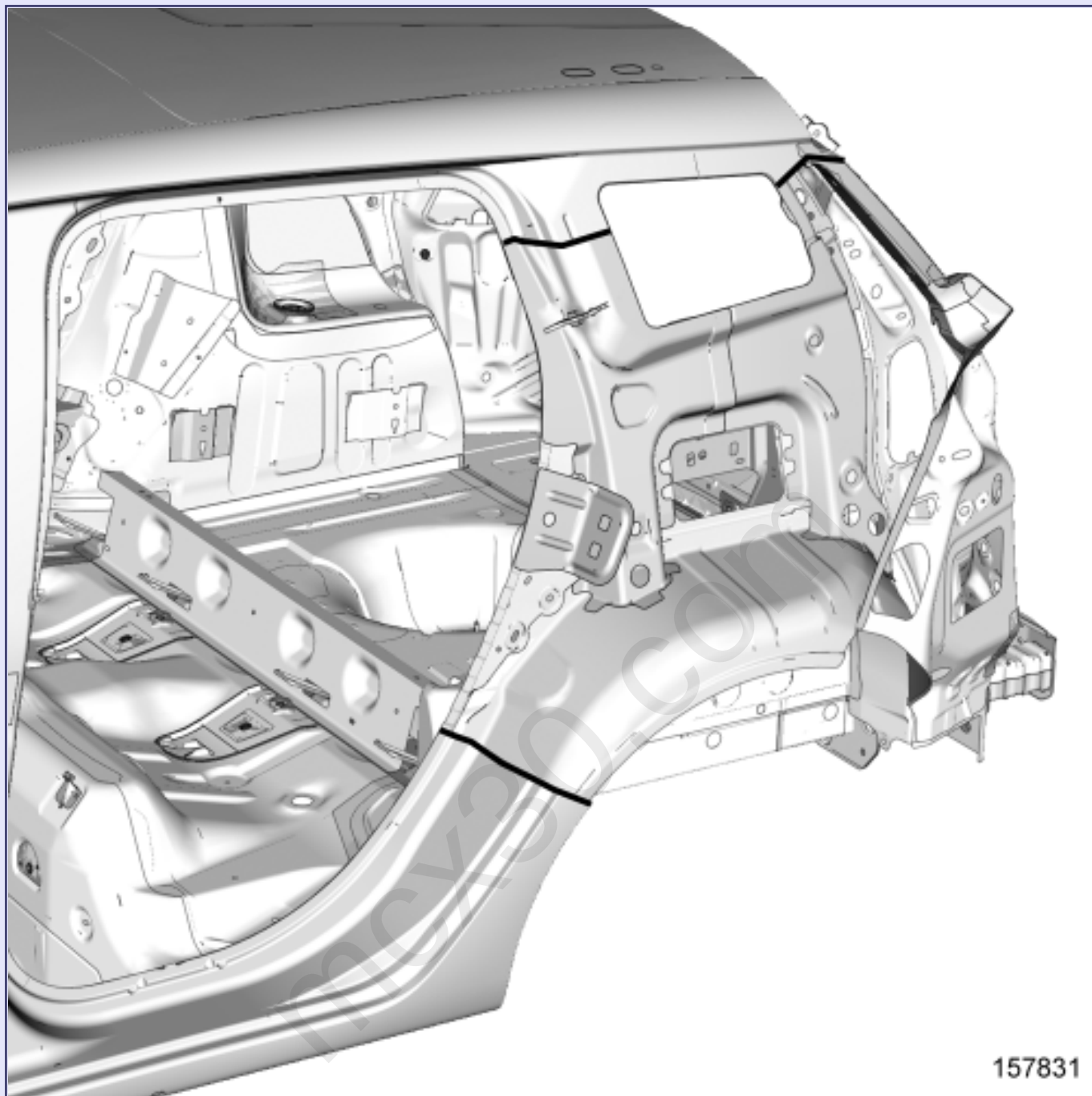


Use a butt weld [Connections for edge to edge partial replacements: Description](#) (MR 400, 40E, Partial replacement connections).

2) DETAILED VIEW OF CUT B-C

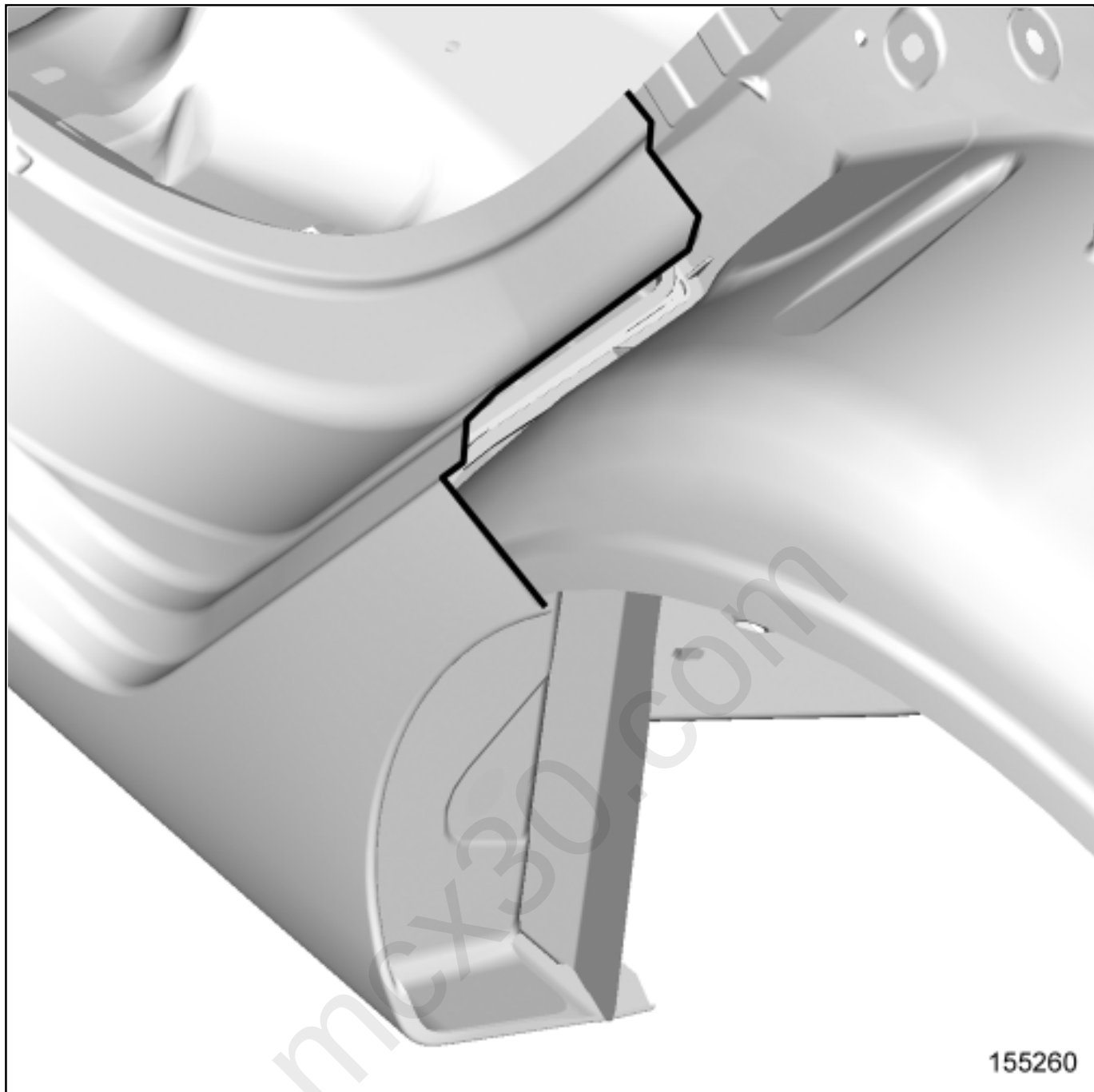


155259



157831

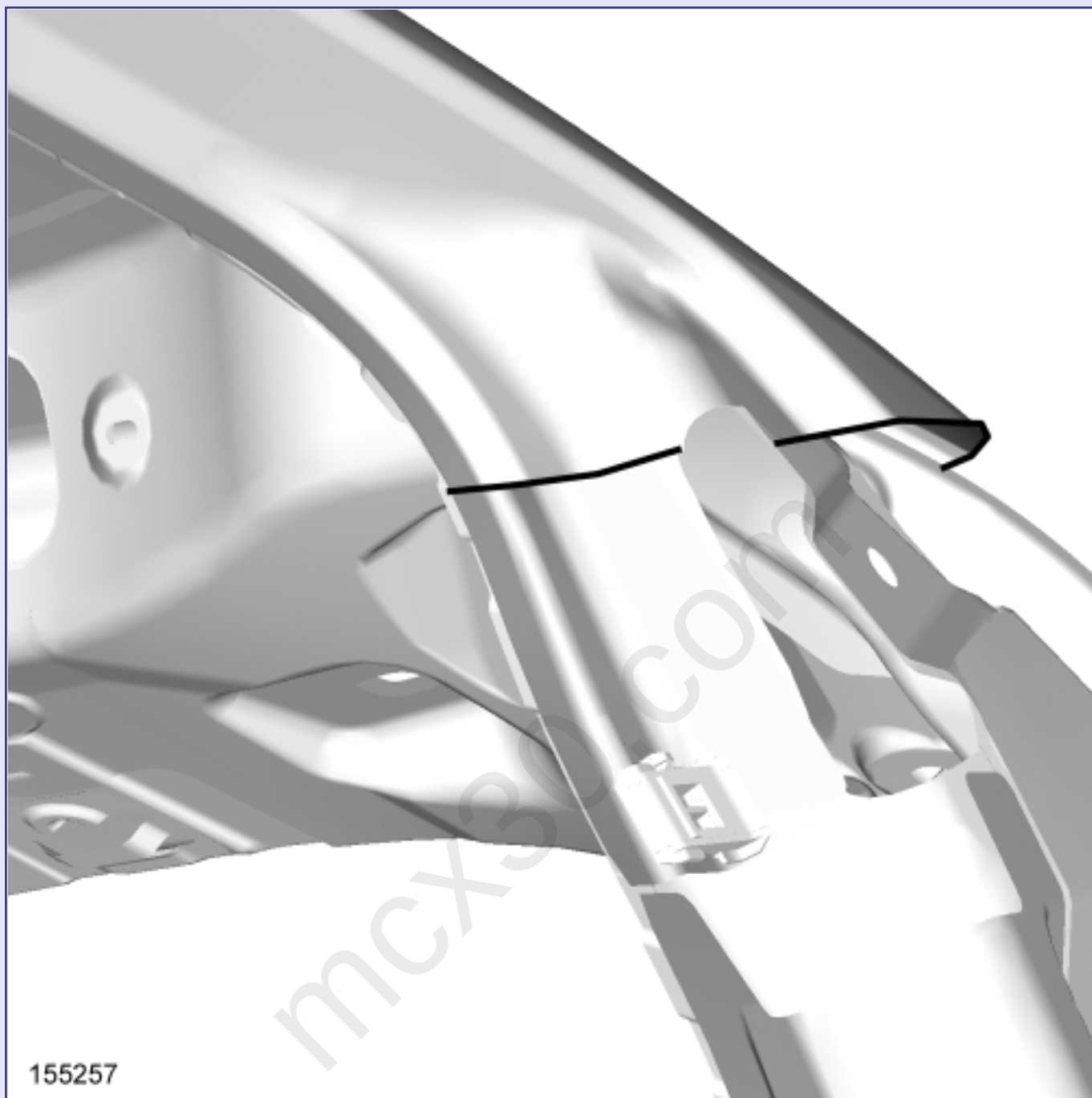
3)DETAILED VIEW B



155260

4)DETAILED VIEW C

B98(B98)



K98(K98)