

### 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)).



[Repair-40x06x06x02-02x49-1-10-1.xml](#)



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## SEALINGPRODUCT:DESCRIPTION



Note, one or more warnings are present in this procedure



### **WARNING**

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

Operator protection : use extra ventilation source.

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| Steps | Description                                         | Special notes                                                                                                                                                                                              |
|-------|-----------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 1     | Remove the mastic from the areas to be repaired     | <a href="#">Tools for stripping very thick soft mastic: Use</a><br><a href="#">Tools for scraping rigid adhesives and paint: Use</a>                                                                       |
| 2     | Wipe / blow                                         |                                                                                                                                                                                                            |
| 3     | Sand                                                | P180 - P240 dry                                                                                                                                                                                            |
| 4     | Wipe / blow                                         |                                                                                                                                                                                                            |
| 5     | Degrease                                            | Lint-free cloth soaked in surface cleaner <a href="#">Vehicle: Parts and consumables for the repair</a> (04B, Consumables - Products). Wipe with a dry lint-free cloth                                     |
| 6     | If the panel is bare, use cold electro zinc plating | <a href="#">(see 04E, Paint, Anti-corrosion protection by cold electro zinc plating: Description)</a>                                                                                                      |
| 7     | Application of a pre-treatment primer on bare areas | <a href="#">Vehicle: Parts and consumables for the repair</a> (04B, Consumables - Products)                                                                                                                |
| 8     | Solvent remover                                     |                                                                                                                                                                                                            |
| 9     | Degrease                                            | Lint-free cloth soaked in surface cleaner <a href="#">Vehicle: Parts and consumables for the repair</a> (04B, Consumables - Products). Wipe with a dry lint-free cloth                                     |
| 10    | Apply a bi-component primer                         | <a href="#">Vehicle: Parts and consumables for the repair</a> (04B, Consumables - Products)                                                                                                                |
| 11    | Apply a sealing mastic                              | <a href="#">Anti-corrosion protection products after assembly: Use</a> (04F, Products and bodywork mountings)) <a href="#">Vehicle: Parts and consumables for the repair</a> (04B, Consumables - Products) |