

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-40x04x02x05-02x49-1-4-1.xml



XSL version : 3.02 du 22/07/11

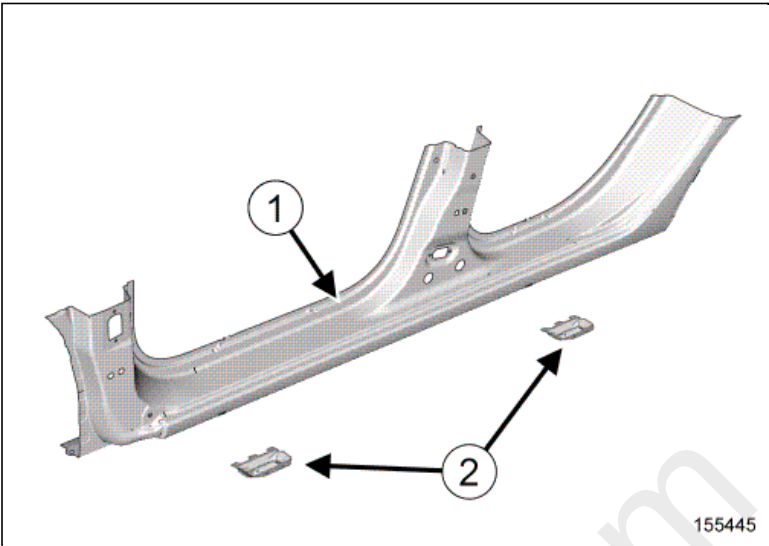
SILLPANEL:REPLACEMENT



Note, one or more warnings are present in this procedure



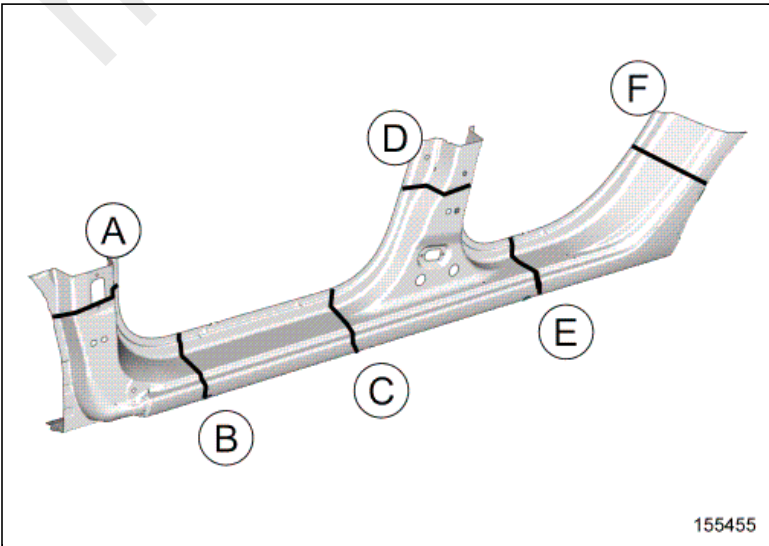
1. COMPOSITION OF THE SPARE PART



No.	Description	Type	Thickness (mm)
(1)	Sill panel	Mild steel	0.65
(2)	Jack bearing support	THLE	2

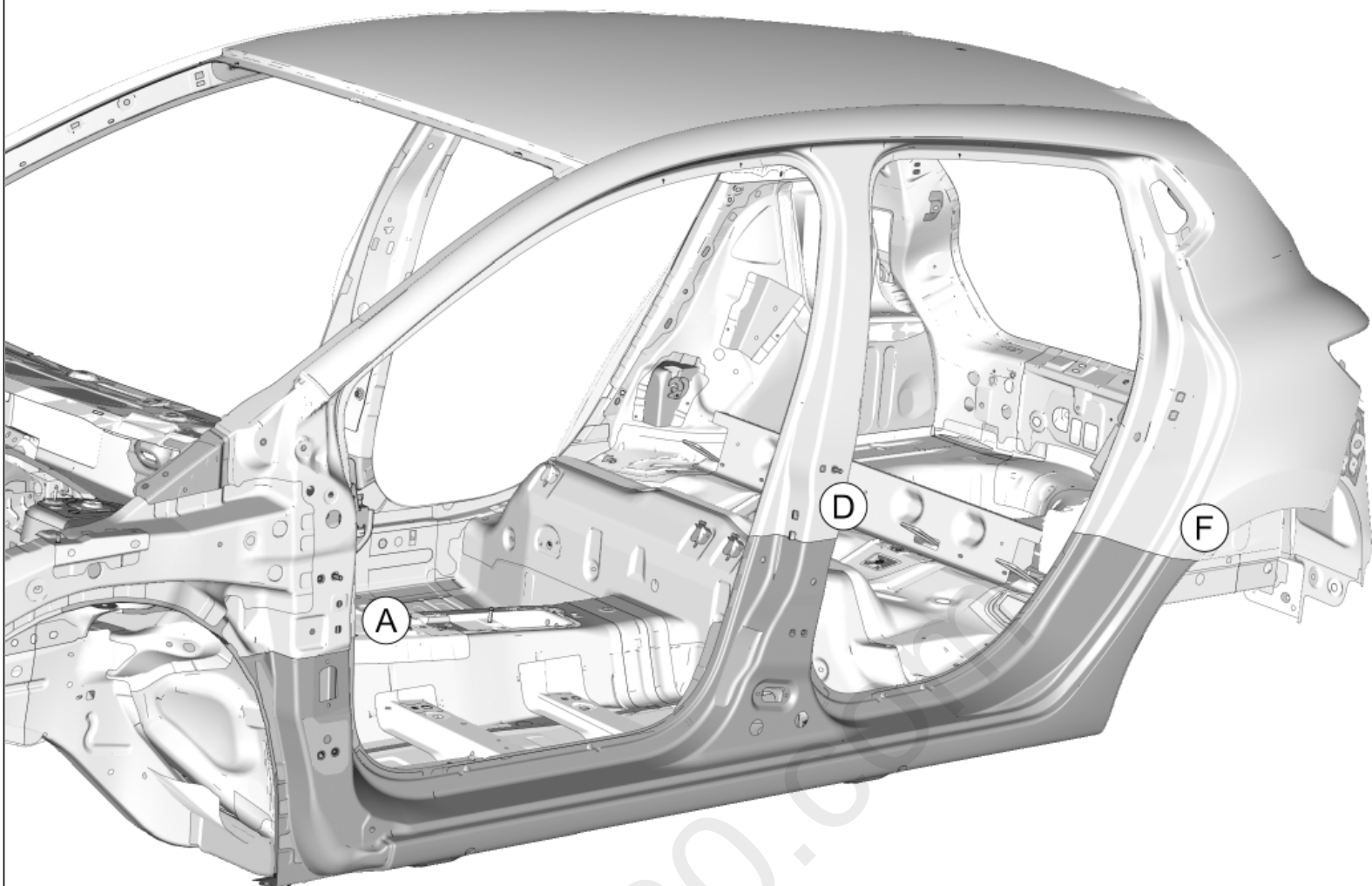
2. IN THE EVENT OF REPLACEMENT

- The options for replacing this part are as follows:
- complete replacement A-D-F,
 - front end partial replacement A-C,
 - partial replacement under door B-C,
 - rear end section partial replacement E-F.



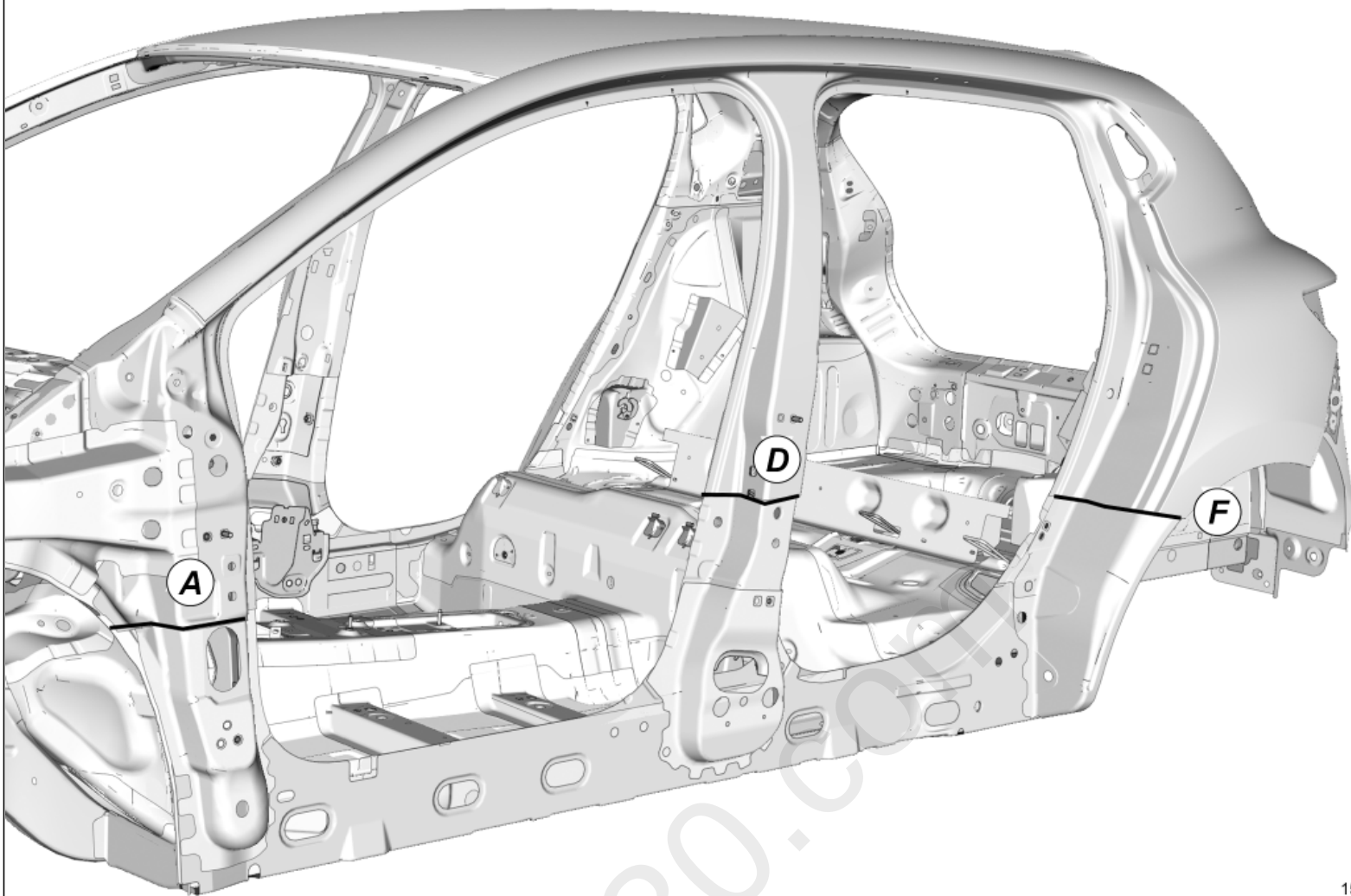
1- COMPLETE REPLACEMENT A-D-F

1)PART IN POSITION



155446

CUT



155449

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).

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3) SPECIAL NOTES ON MATING

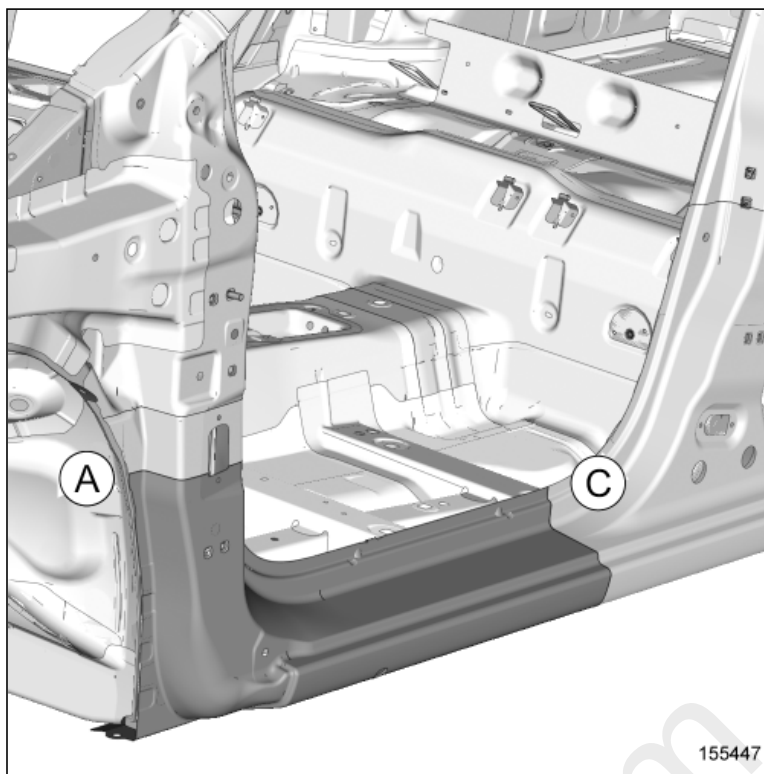


CAUTION

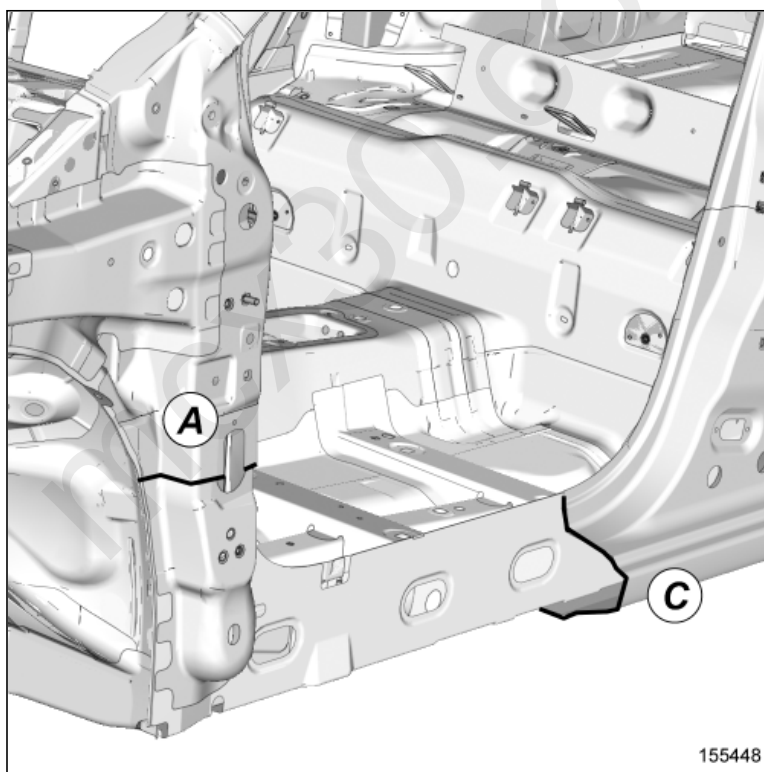
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2- FRONT END PARTIAL REPLACEMENT A-C

1) PART IN POSITION



CUT



2) POSITION OF ELECTRIC EARTHS



CAUTION

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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).

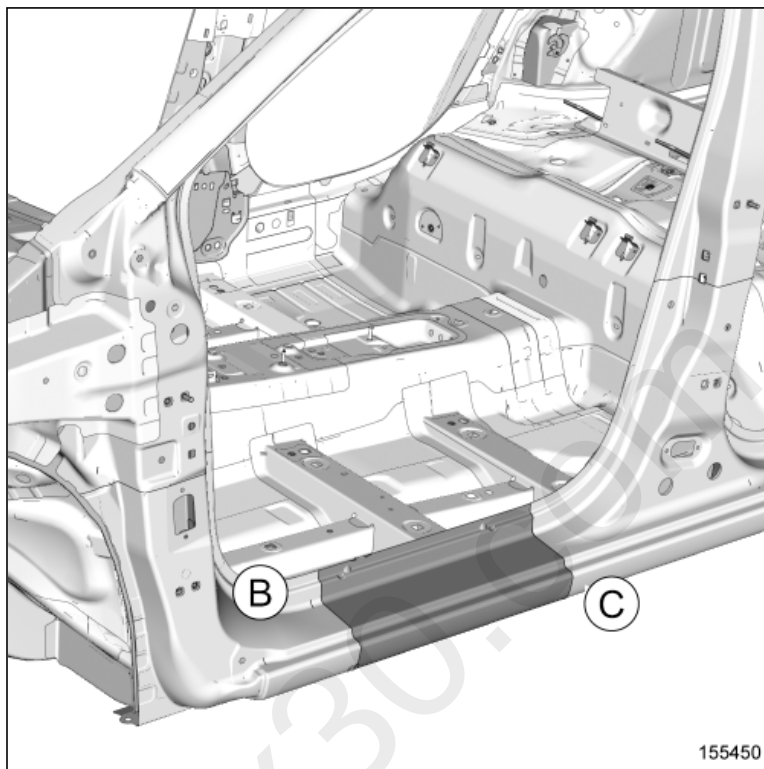
Locate the earths located near to the weld area[Earths on body: List and location of components](#) .

**CAUTION**

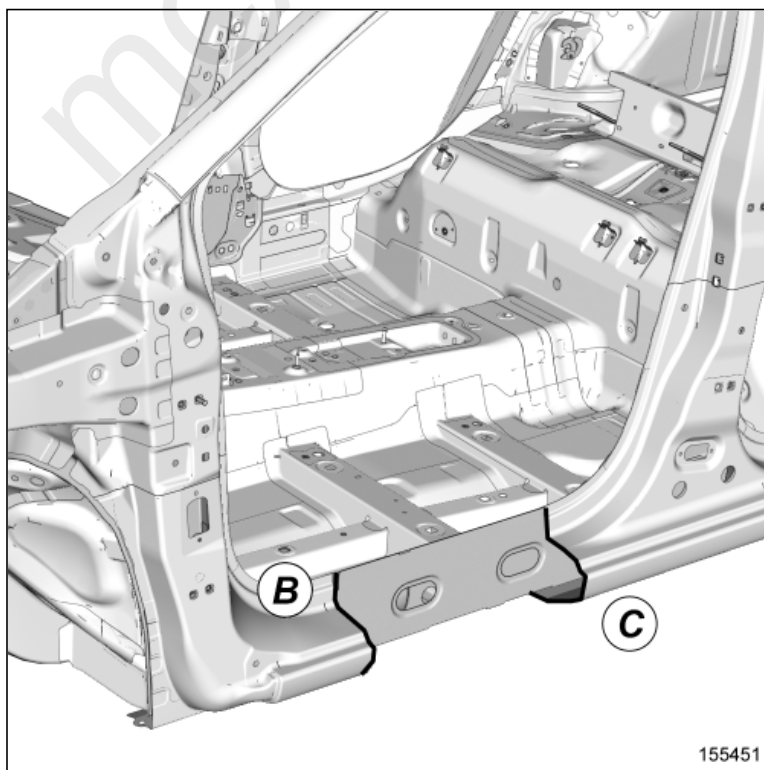
If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld. [Connections by arc welding under shielding gas: Description](#) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

3- PARTIAL REPLACEMENT UNDER DOOR B-C

1)PART IN POSITION



CUT



**CAUTION**

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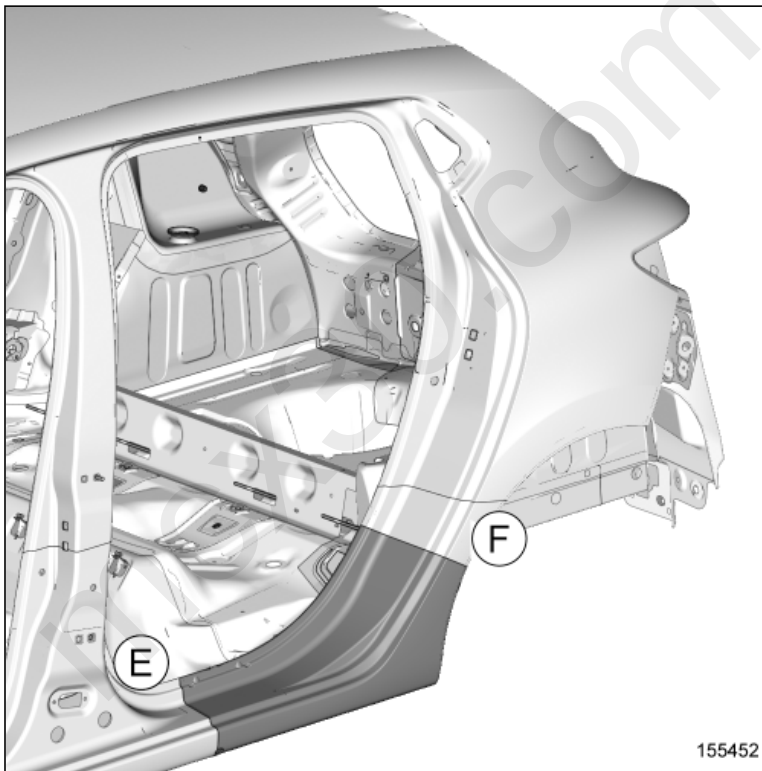
Position the earth of the welding machine as close as possible to the weld area (see **Bolted connection for earth: Fitting**) (MR 400, 40H, Bolted connections).

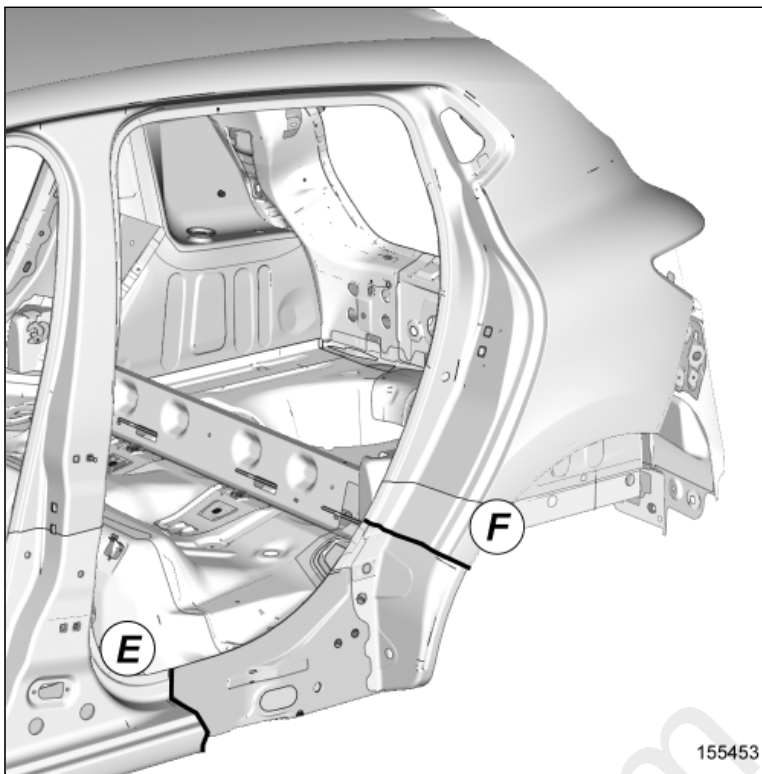
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**CAUTION**

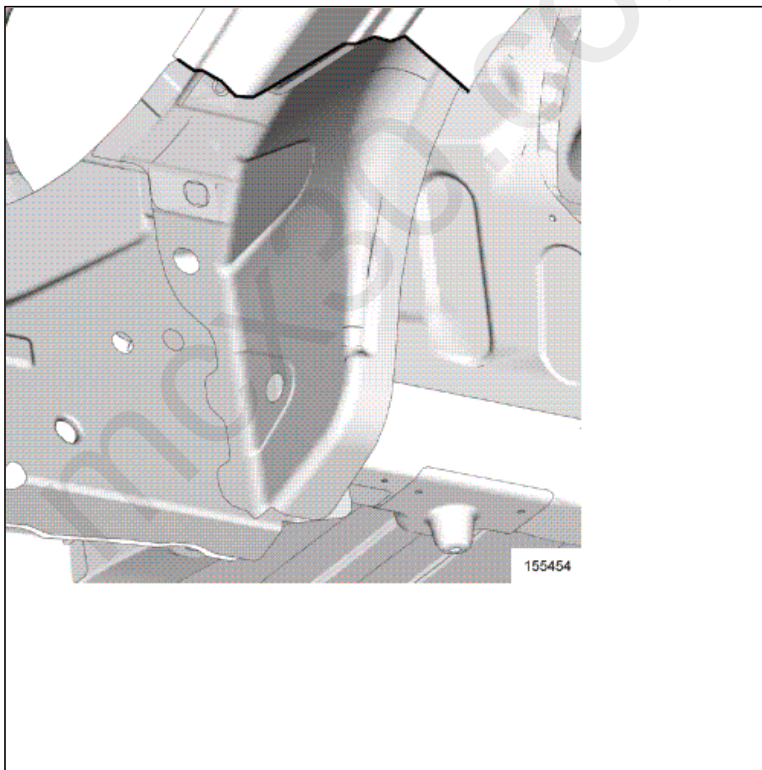
If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld [Connections by arc welding under shielding gas: Description](#) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

4- REAR END SECTION PARTIAL REPLACEMENT E-F





DETAILED VIEW F



2) POSITION OF ELECTRIC EARTHS



CAUTION

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