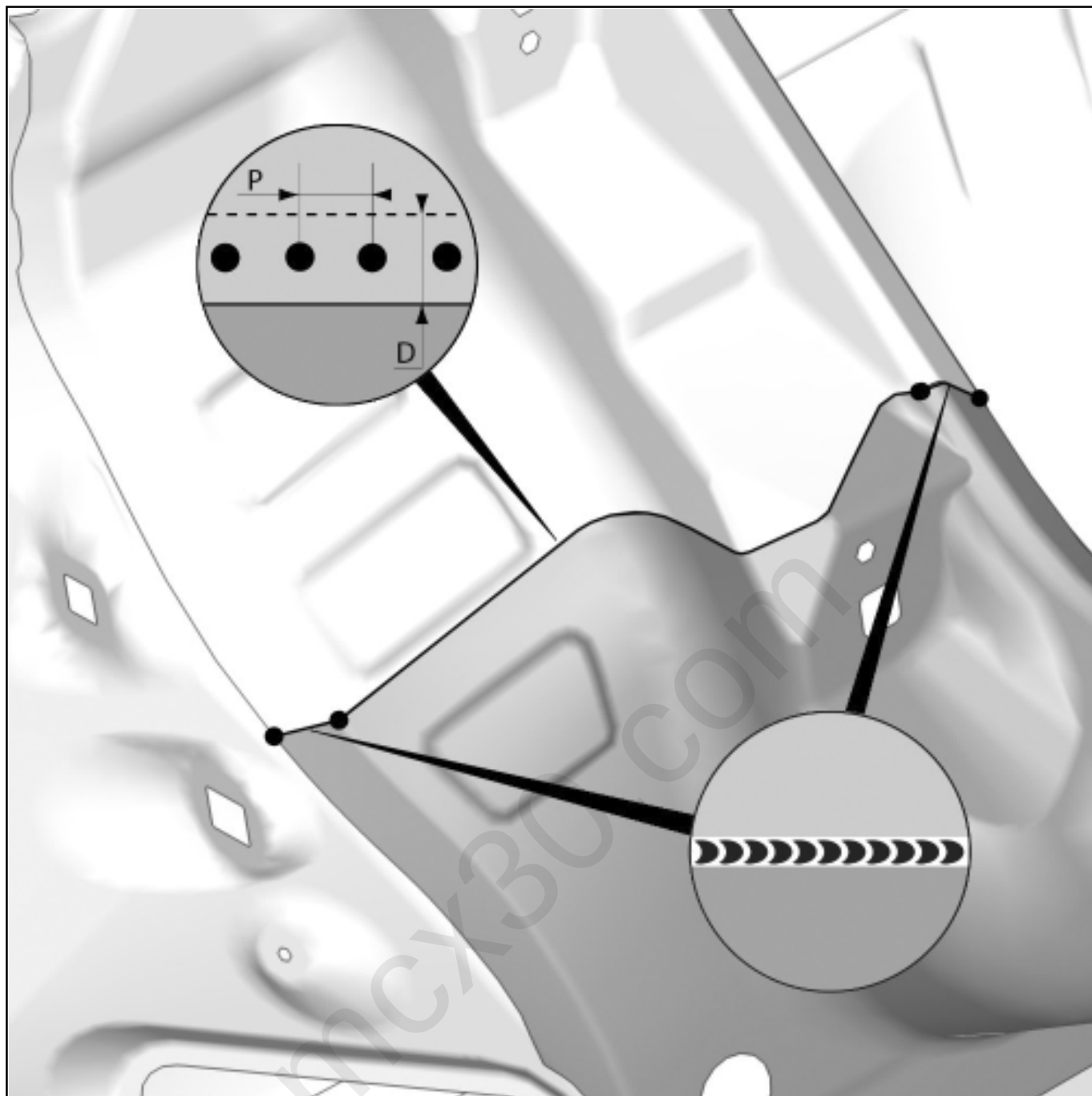




If two types of welds are used, points delimit the areas.



Repair-00x05x01-02x21-1-1-1.xml



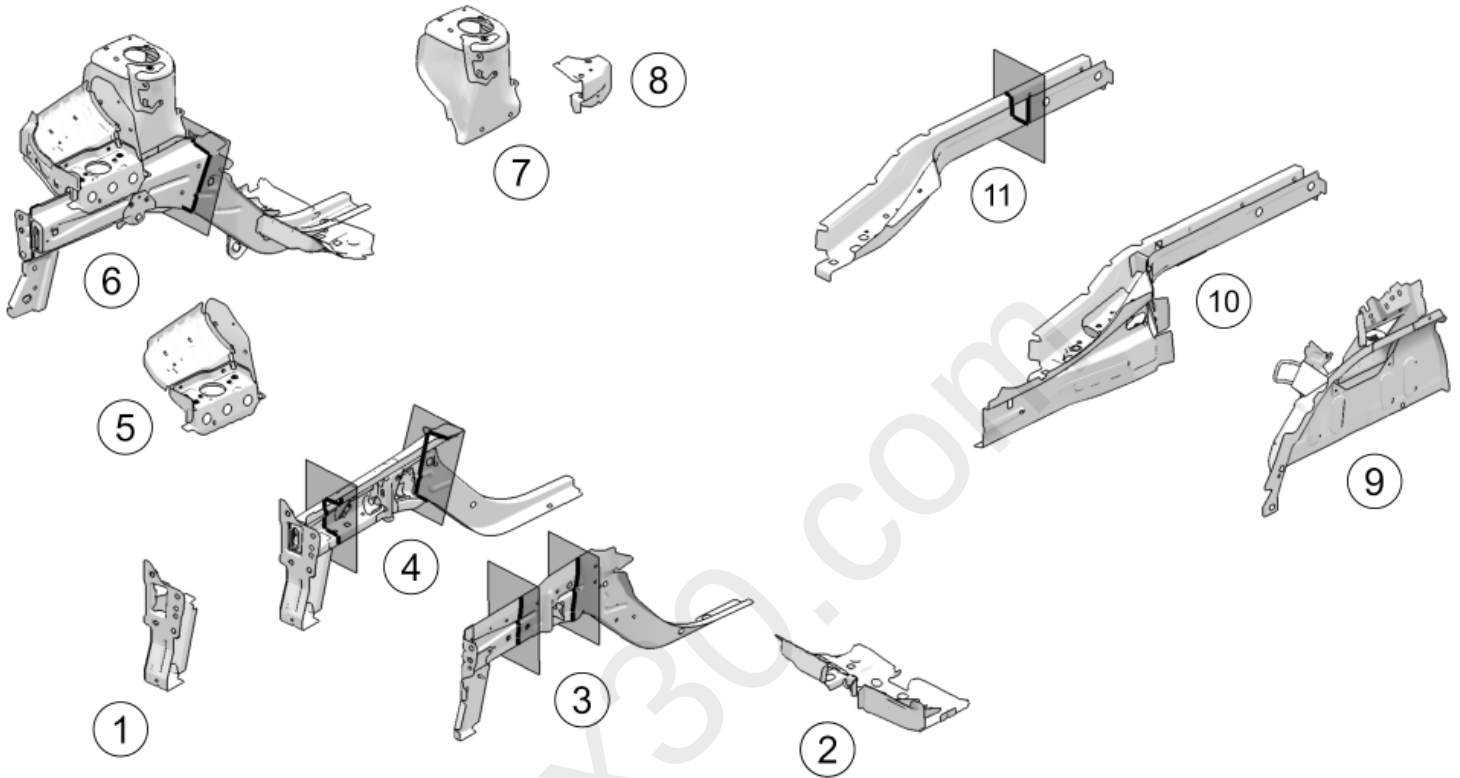
XSL version : 3.02 du 22/07/11



Note, one or more warnings are present in this procedure



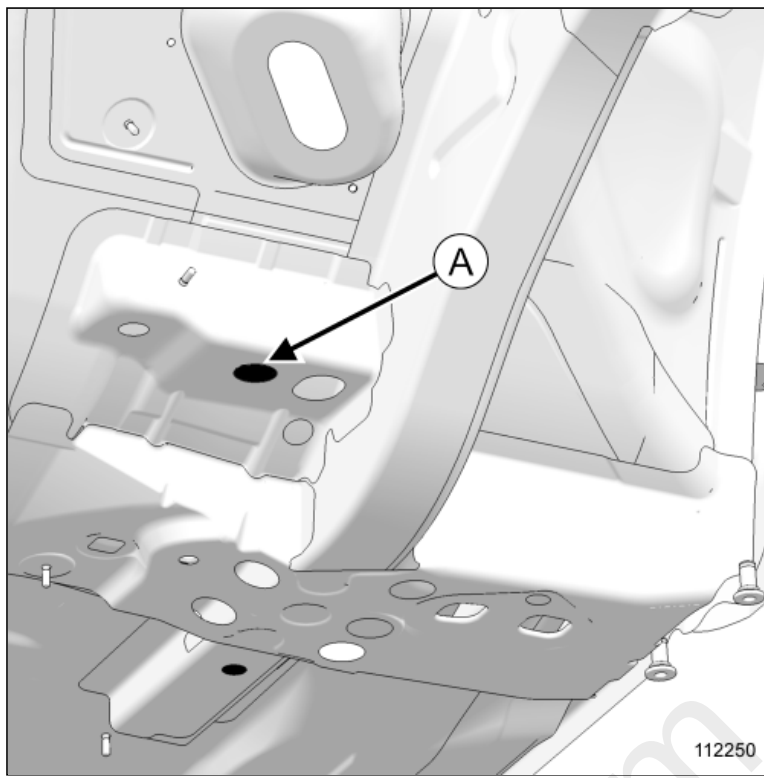
1. PARTS REQUIRING THE USE OF A BODY JIG BENCH



112487

- (1) Radiator cross member support
- (2) Centre floor front side cross member
- (3) Front side member closure panel
- (4) Front side member
- (5) Engine stand
- (6) Front half-unit
- (7) Front wheel arch
- (8) Engine tie-rod attachment
- (9) Inner rear wheel arch
- (10) Rear side member
- (11) Rear side member, rear section

2. FRONT SUBFRAME REAR MOUNTING



The jig rests under the subframe mounting unit and is centred in the threaded hole(A).

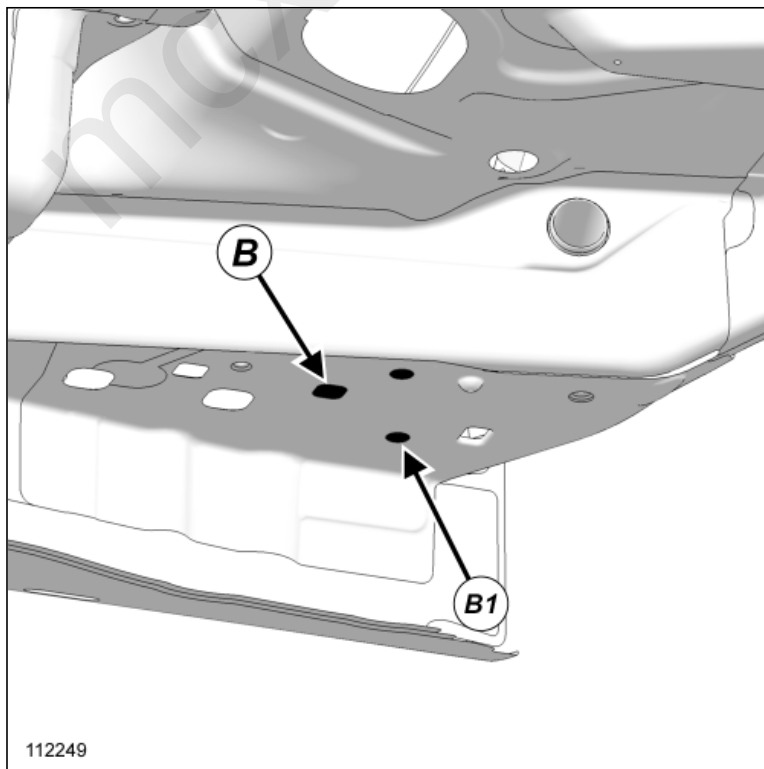
It is used for replacing a complete front half unit.



WARNING

This/these point(s) help to ensure the correct axle assembly geometry.

3. REAR AXLE ASSEMBLY FRONT MOUNTING



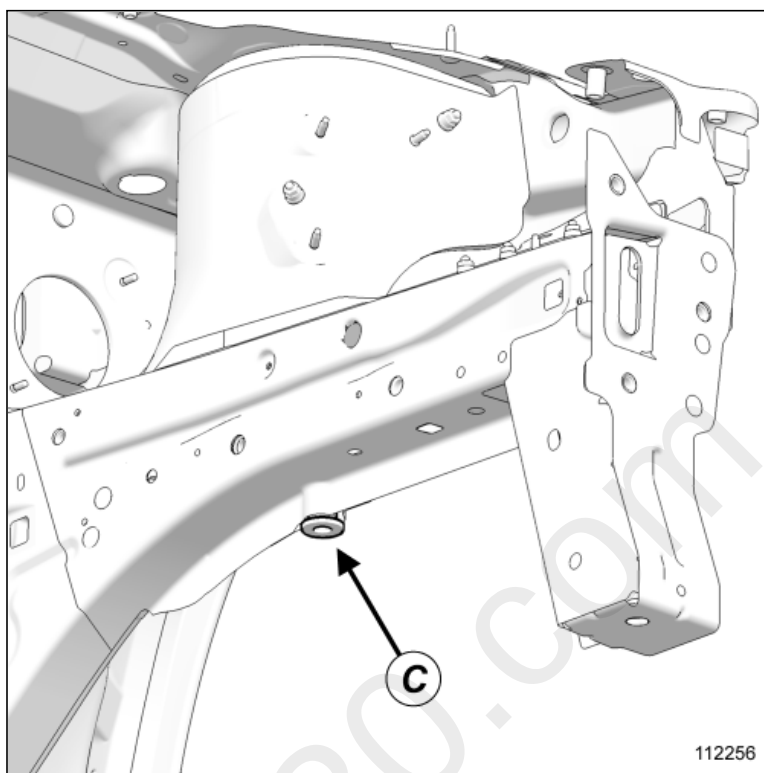
The jig supports the underneath of the rear axle assembly mounting unit and is centred on square hole(B) and fixed on tapped hole(B1) of the rear axle bearing mounting.



WARNING

This/these point(s) help to ensure the correct axle assembly geometry.

4. FRONT SUB-FRAME FRONT MOUNTING



The jig supports the underneath of the front sub-frame mounting and is centred on tapped hole(c) .

It is used when replacing:

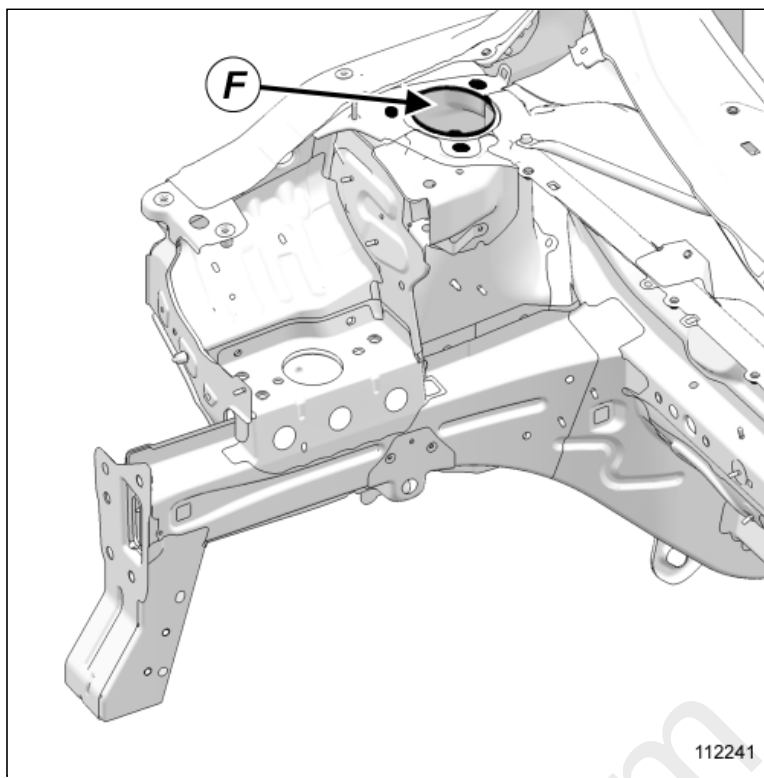
- a complete front side member,
- a front half unit.



WARNING

This/these point(s) help to ensure the correct axle assembly geometry.

5. FRONT SHOCK ABSORBER UPPER MOUNTING



The jig supports the underneath of the shock absorber cup and is centred in the hole(F) of the shock absorber cup.

It is used when replacing:

- a wheel arch,
- a front half unit.

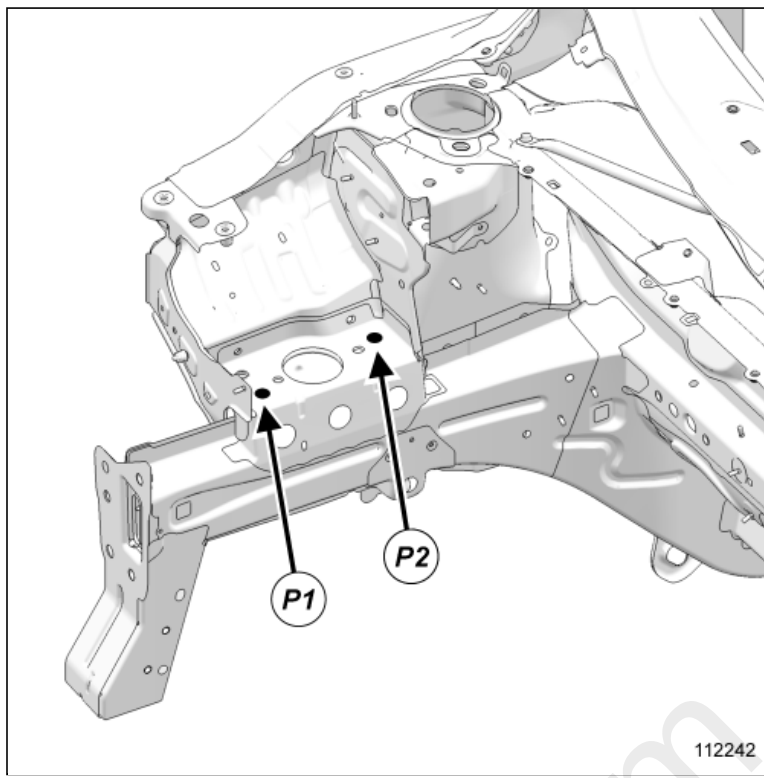
It is also used in straightening.



WARNING

This/these point(s) help to ensure the correct axle assembly geometry.

6. ENGINE MOUNTING



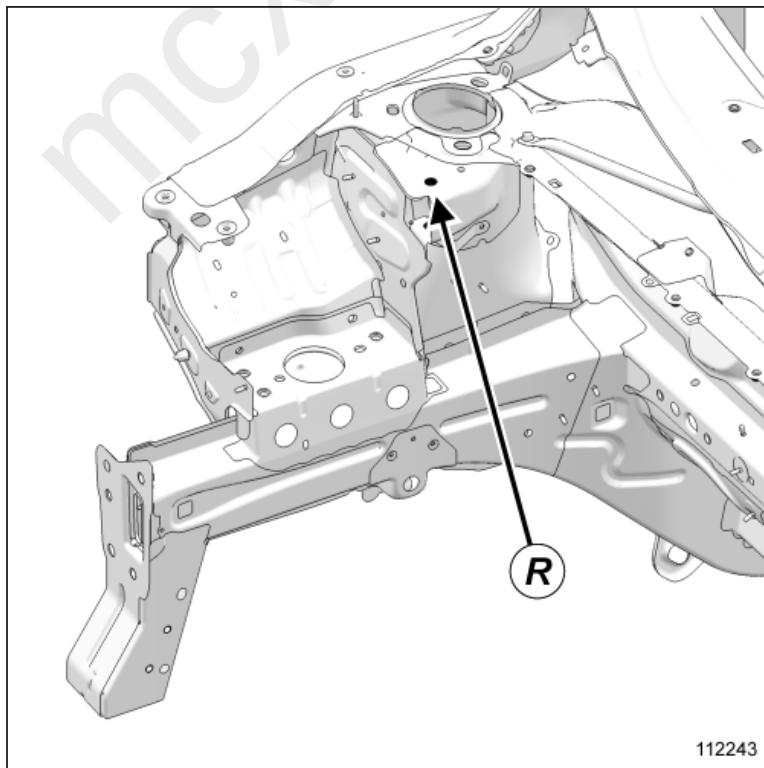
112242

The jig rests on the engine mounting and is centred in engine mounting securing holes(P1) and (P2) .

It is used with the mechanical components removed for the replacement of:

- a front half unit.
- the engine mounting.

7. ENGINE TIE-ROD ATTACHMENT



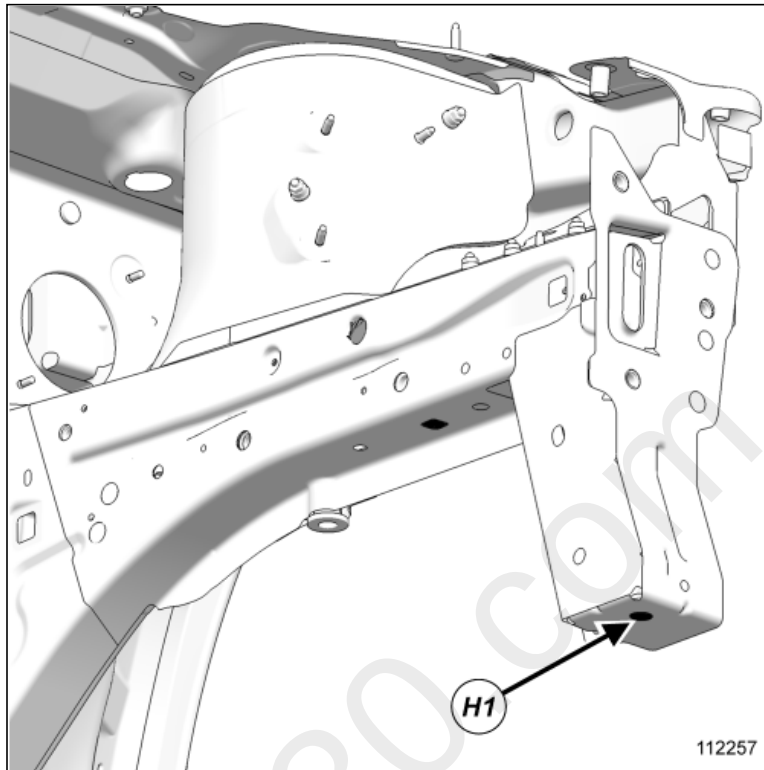
112243

The jig supports the engine tie-rod attachment mounting and is centred in hole(R) .

It is used with the mechanical components removed for the replacement of:

-
- the engine tie-rod attachment,
- a front half unit.

8. RADIATOR MOUNTING CROSS MEMBER MOUNTING

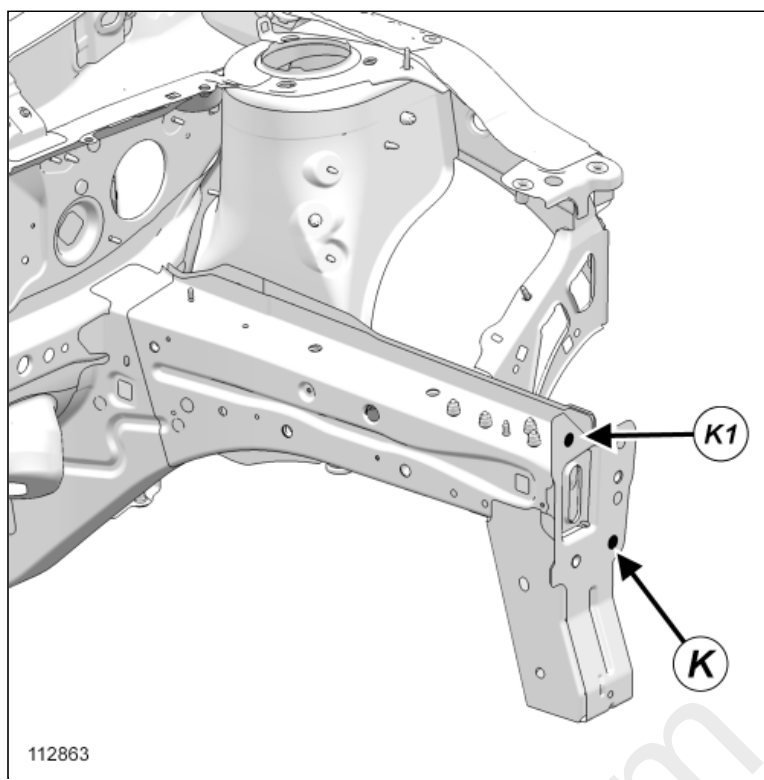


The jig supports the underneath of the radiator cross member and is centred in tapped hole(H1) .

It is used when replacing:

-
- the radiator cross member mounting,
- the front side member completely or partially,
- a half unit.

9. FRONT IMPACT CROSS MEMBER MOUNTING

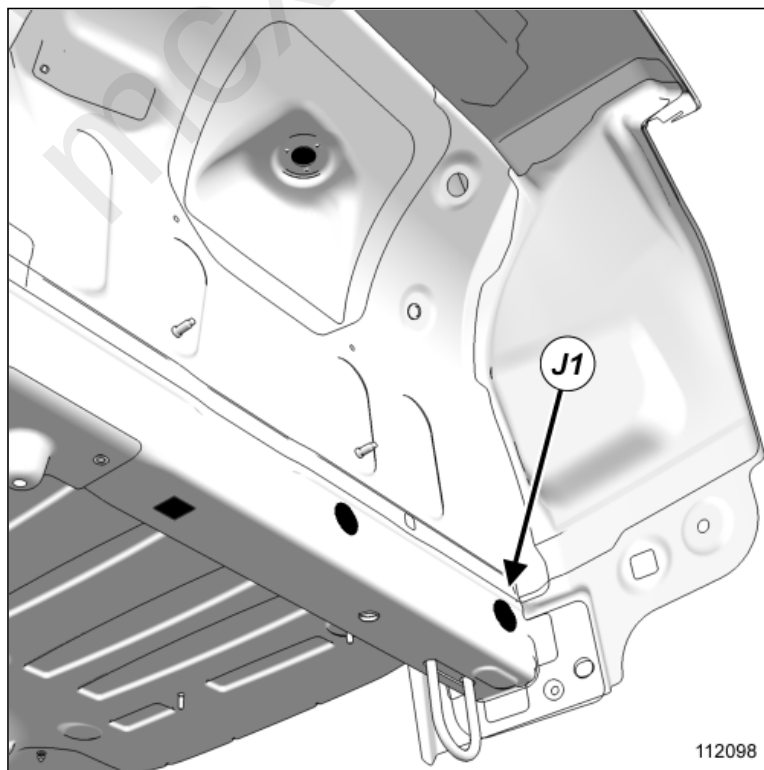


The jig rests vertically against the radiator cross member mounting unit and is centred in mounting holes(K) and (K1) .

It is used when replacing:

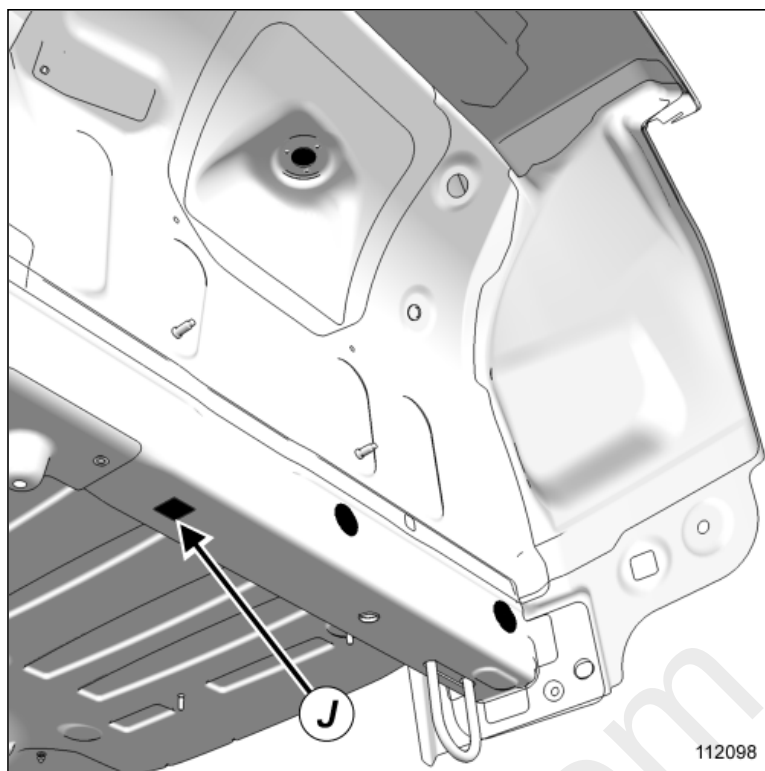
- the radiator cross member mounting,
- the front side member completely or partially..

10. END OF REAR SIDE MEMBER



The jig rests vertically against the side member and is centred in hole(J1) .

It is used for partially replacing a rear side member.

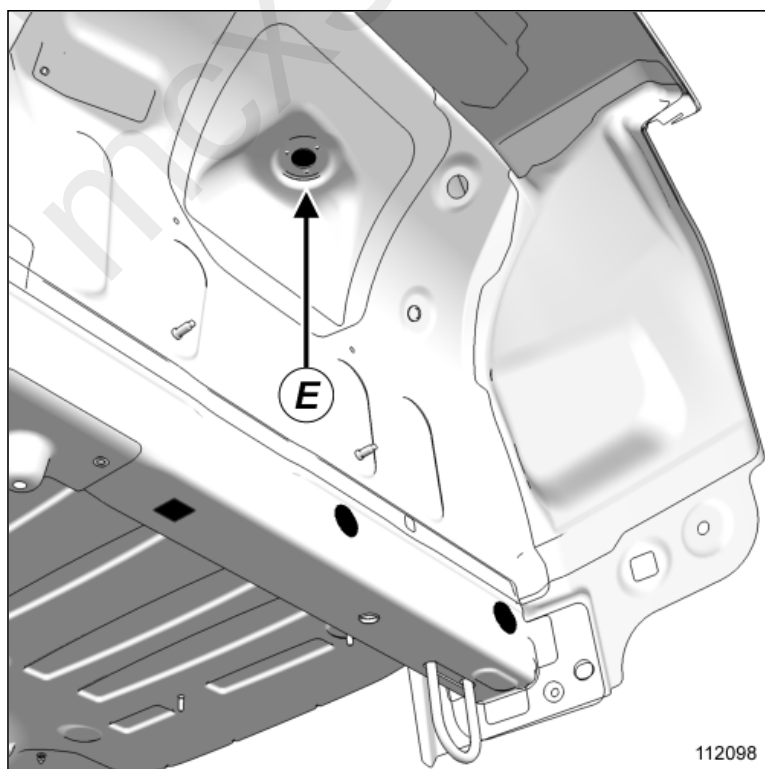


The jig rests under the rear side member and is centred in hole(J) .

It should be used with the mechanical components in place to realign a rear side member.

It is used with the mechanical components removed, under the same conditions, to replace the complete rear side member.

11. INNER REAR WHEEL ARCH



The jig supports the underneath of the rear shock absorber cup and is centred on hole(E) .

Use it when replacing the rear wheel arch.