Attacks the galvanising and the support sheet.

Operator protection:

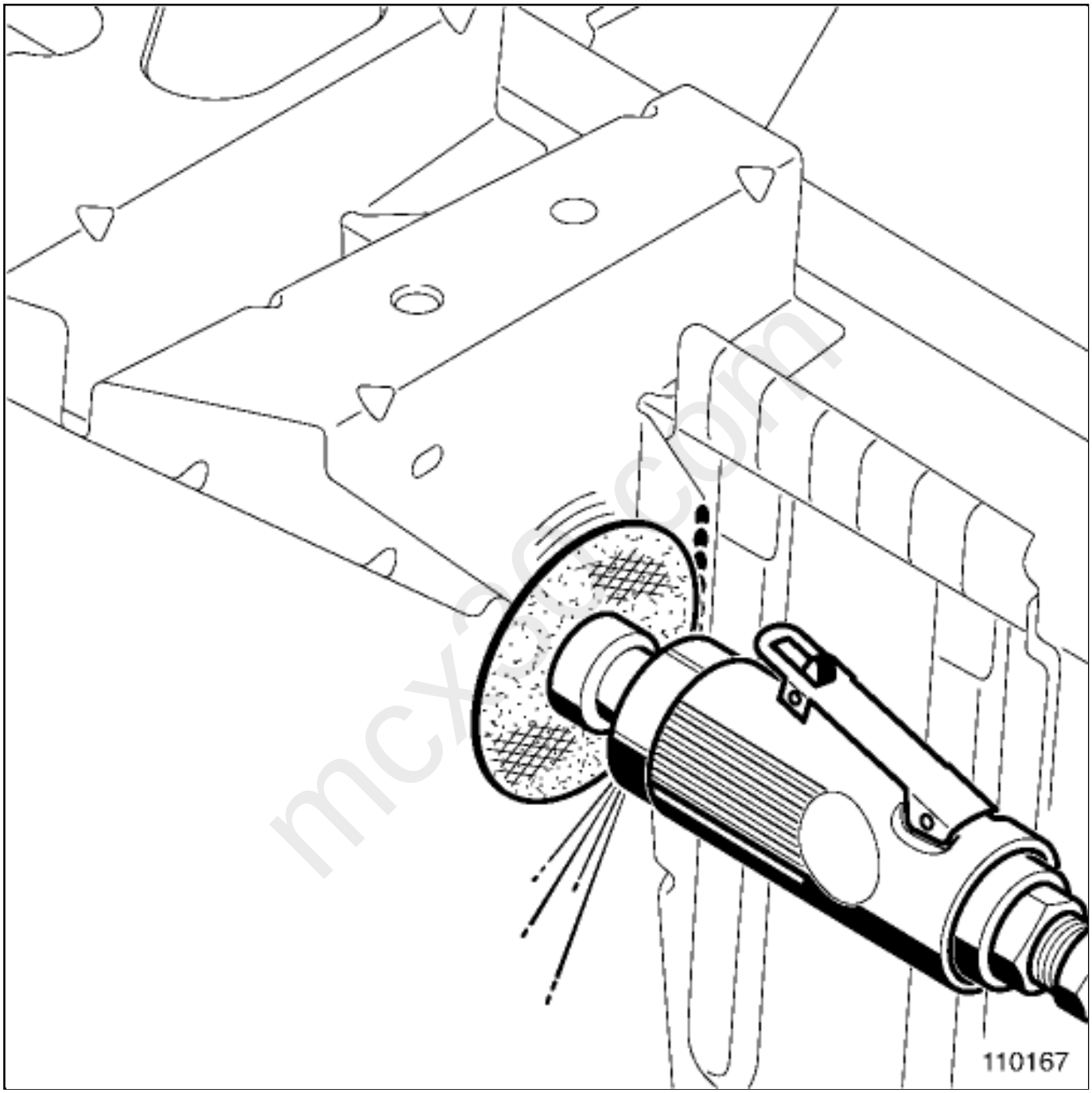
- obligatory eye and face protection,
- obligatory respiratory protection,
- obligatory ears protection,
- obligatory hand protection.

Protection of the environment:

- protection of interior fittings.

TOOLS FOR UNPICKING A STRUCTURAL COMPONENT: USE

1. FLAT UNWELDING AND UNWELDING A WELD BEAD



- Use of a unwelding grinder ∅ 76 mmthickness 3 mm, fitted to a straight grinder (20000 rpm)fitted with speed control.

- Advantages:
  - a very fast method that causes the least damage to the sheet located underneath the mating surface overlap,

allows unwelding of THLE and UHLE sheets.

Disadvantages:

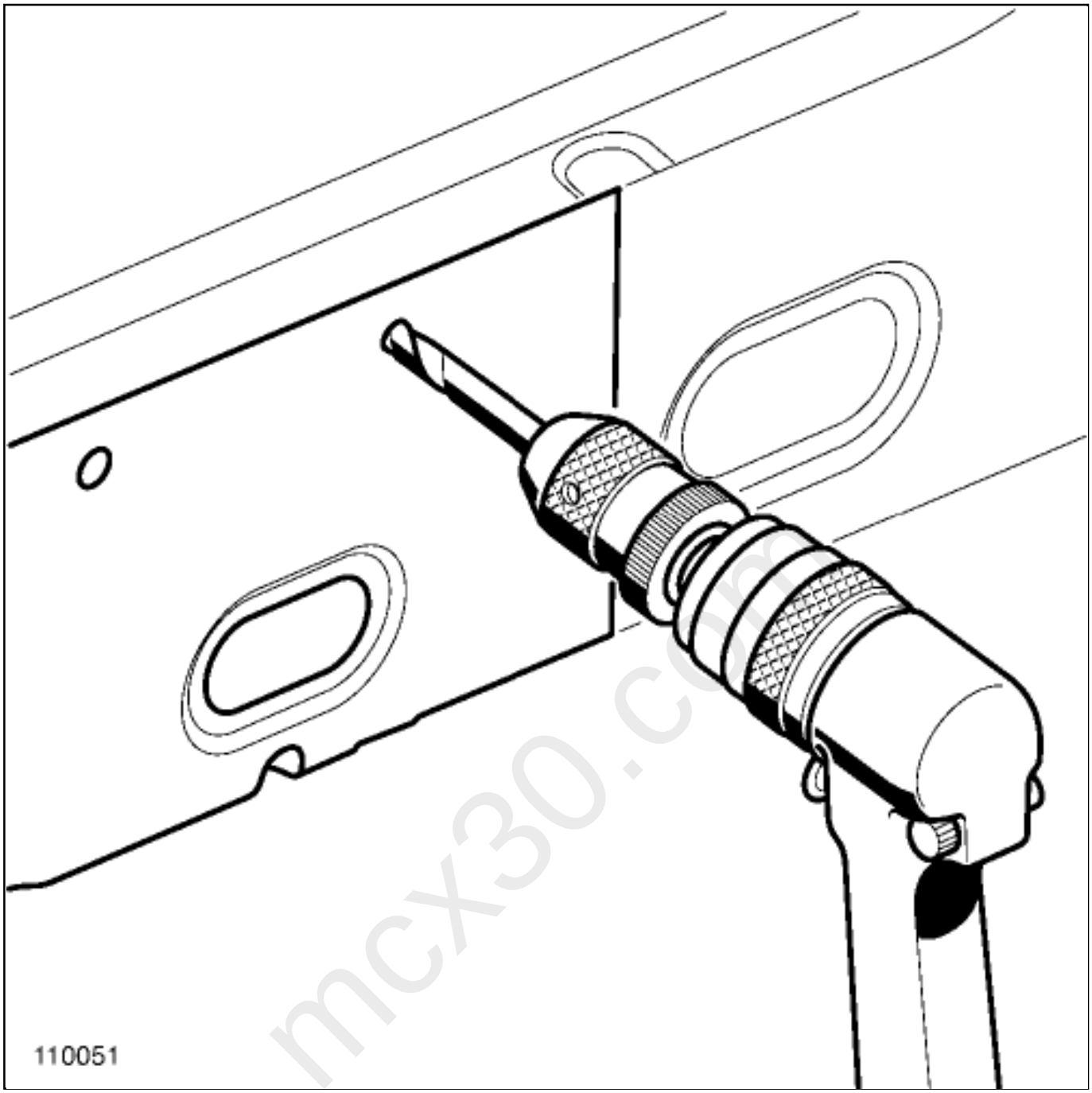
- causes a large quantity of sparks that can damage nearby components (windows, plastic components, cloth, etc.).

Operator protection:

- obligatory eye protection,
- obligatory hand protection,
- obligatory ears protection,
- obligatory respiratory protection.

Protection in the work area:

- protection of interior fittings,
- protection of internal and external window faces.



Use of a hardened steel bit ∅ 6 to 10 mm, fitted to a drill (2000 rpm), fitted with speed control.

Advantages:

- Rapid unwelding without projections,
- clean holes, ideal for plug welding the first sheet.

Disadvantages:

- it is necessary to drill vertically into the part,
- not for unwelding THLE and UHLE sheets.

Operator protection:

- obligatory eye protection,
- obligatory hand protection.

Protection in the work area:

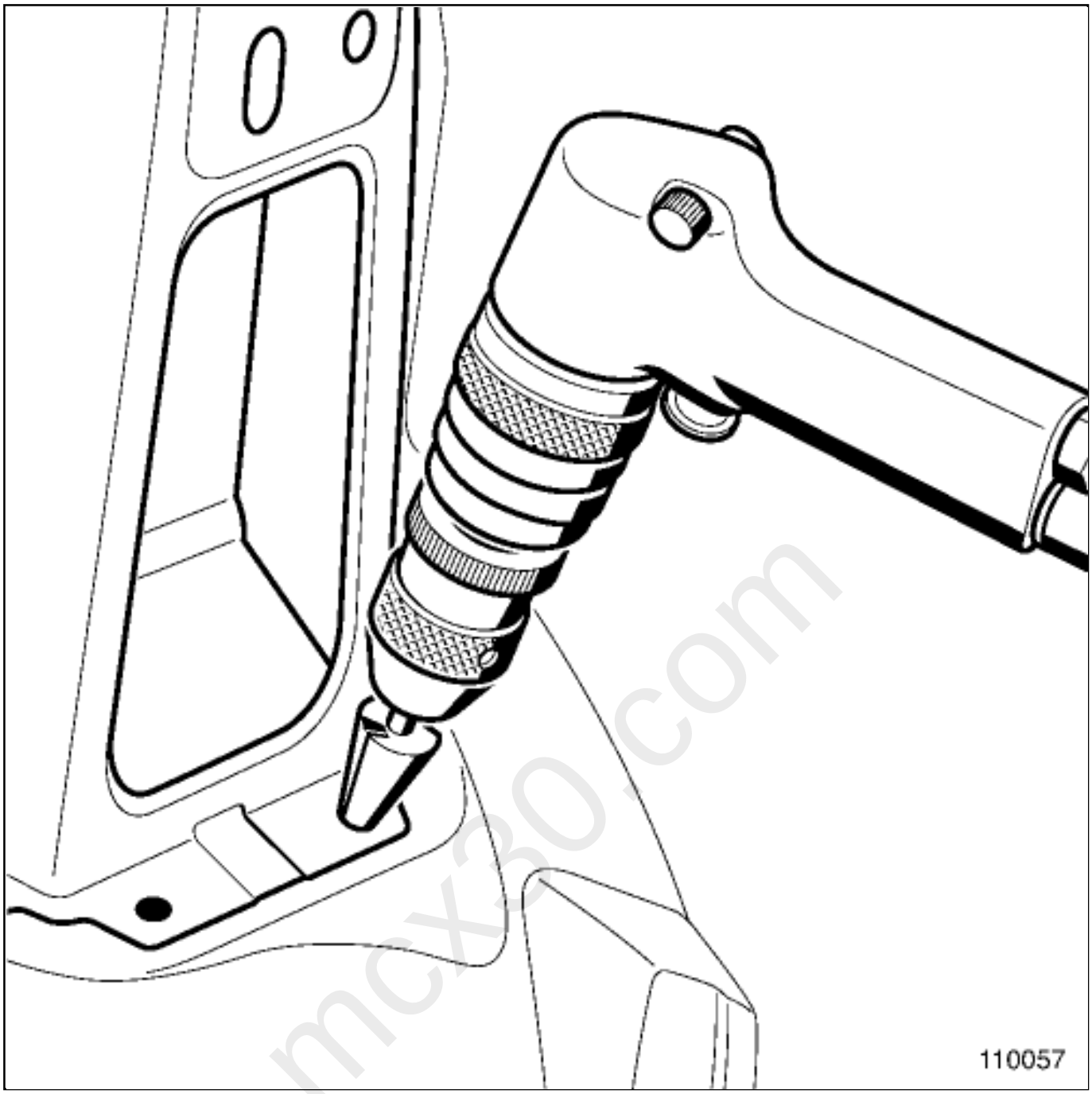
- protection of interior fittings.

Note:

The speed control is for optimising the cut and bit penetration, avoids premature wear, above all for drilling high tensile sheets.

In that case, use HSStype drill bits.

1- PARTICULAR CASE OF UNWELDING A SHEET LOCATED BEHIND, FOR TWO THICKNESSES



Use of a tapered drill bit, fitted to a drill (2000 rpm), fitted with speed control.

Advantages:

- clean hole and correctly matched to the spot weld diameter, allowing you to plug weld.

Disadvantages:

It is necessary to drill vertically into the part.

Operator protection:

- obligatory eye protection,
- obligatory hand protection.

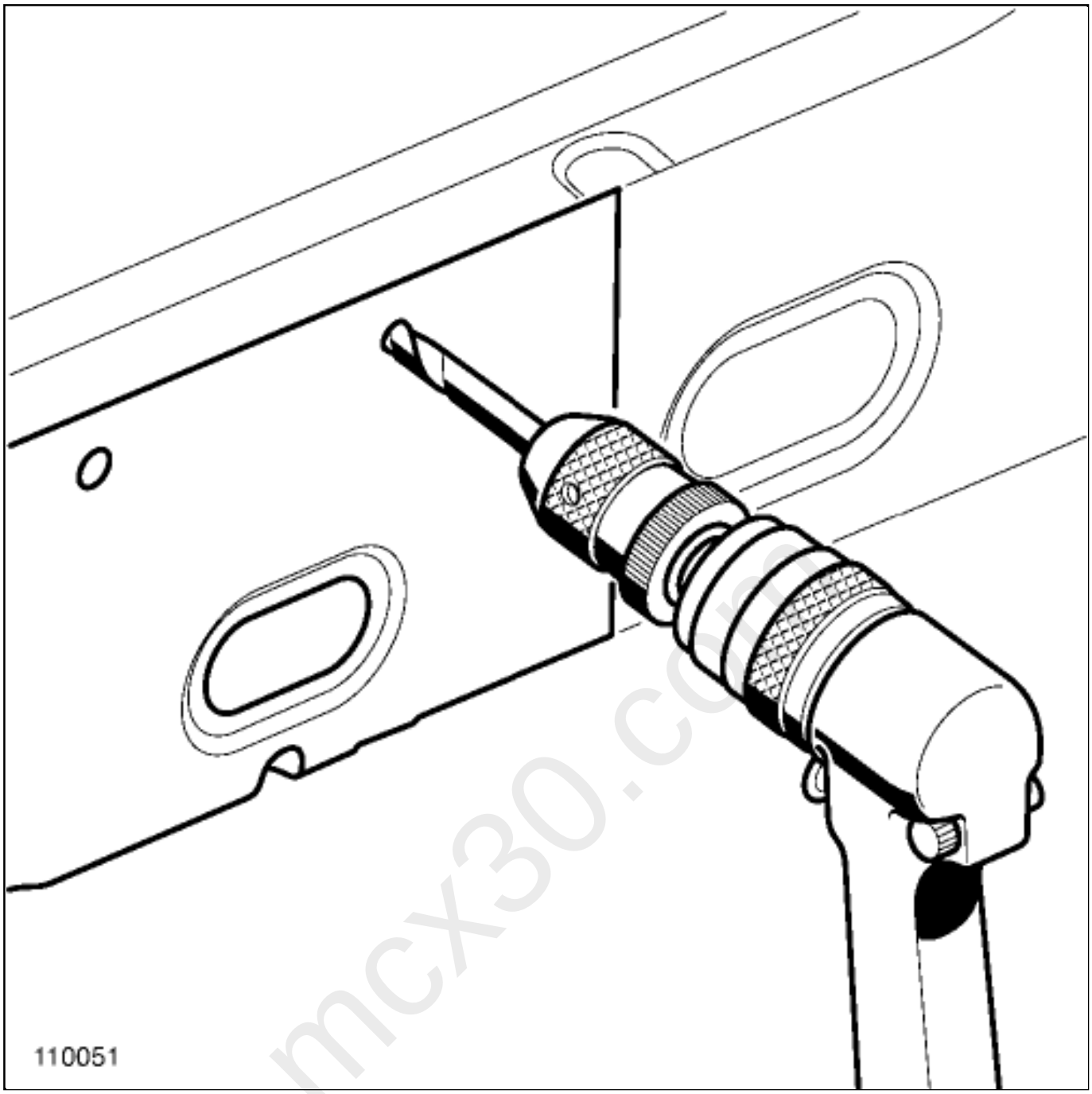
Protection in the work area:

- protection of interior fittings.

Note:

Before drilling, you are advised to centre punch the point in such a way as the hole required for unpicking is as small as possible.

2- PARTICULAR CASE OF UNWELDING A SHEET LOCATED BEHIND, FOR THREE THICKNESSES



Use of a hardened steel bit, fitted to a drill (2000 rpm), fitted with speed control.

Advantages:

- enables you to drill the first hole by making a clean hole for plugging,
- unwelds the second sheet without damaging the third sheet.

Disadvantages:

- requires certain precautions to avoid perforating the third sheet.
- it is necessary to drill vertically into the part.

Operator protection:

- obligatory eye protection,
- obligatory hand protection.

Protection in the work area:

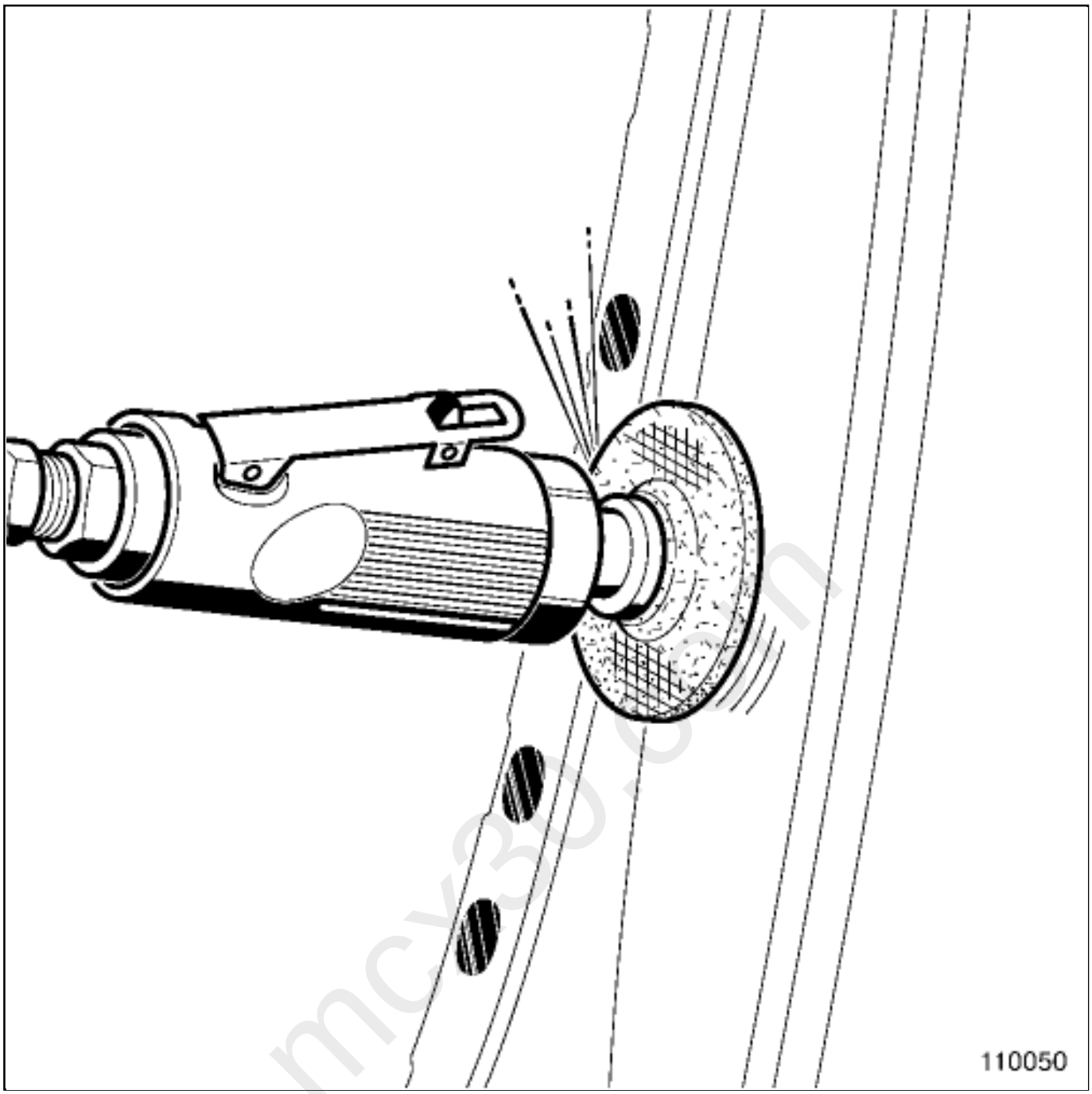
- protection of interior fittings.

Note:

The speed control is for optimising the cut and bit penetration, avoids premature wear, above all for drilling high tensile sheets.

In that case, use HSStype drill bits.

2. UNWELDING AT AN ANGLE



Use of a unwelding grinder ∅ 76 mmthickness 3 mm, fitted to a straight grinder (2000 rpm) fitted with speed control.

Advantages:

- a very fast method that causes the least damage to the sheet located underneath the mating surface overlap,
- allows unwelding of THLE and UHLE sheets.

Disadvantages:

- causes a large quantity of sparks that can damage nearby components (windows, plastic components, cloth, etc.).

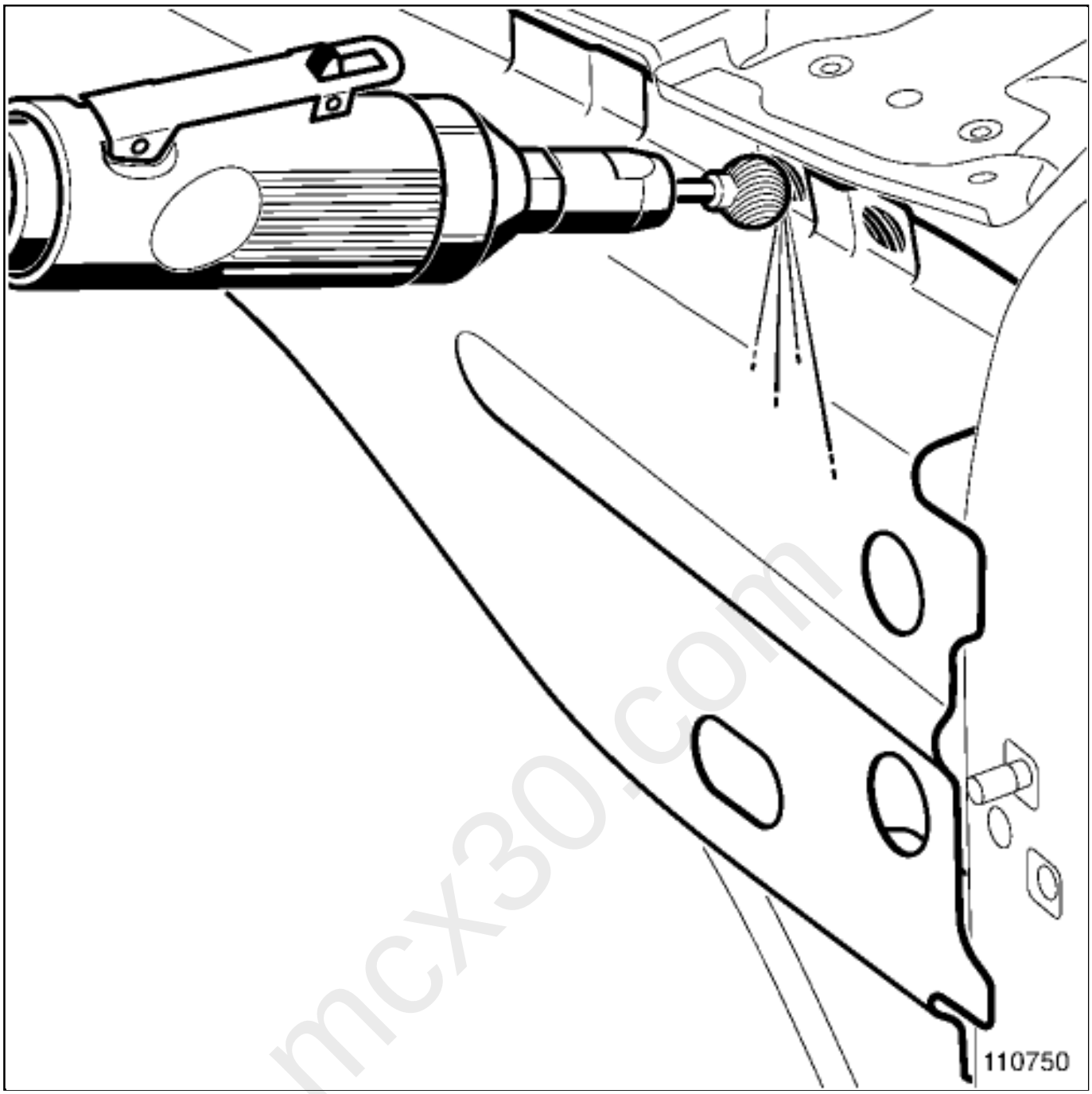
Operator protection:

- obligatory eye protection,
- obligatory hand protection,
- obligatory ears protection.

Protection in the work area:

- protection of interior fittings,
- protection of internal and external window faces.

3. UNWELDING IN A CORNER



Use of a spherical burr on a straight grinder (20,000 rpm), equipped with speed control.

Advantages:

- a very fast method that causes the least damage to the sheet located underneath the mating surface overlap,
- allows unwelding of THLE and UHLE sheets.