



Repair-50x04-01x95-1-1-1.xml



XSL version : 3.02 du 22/07/11

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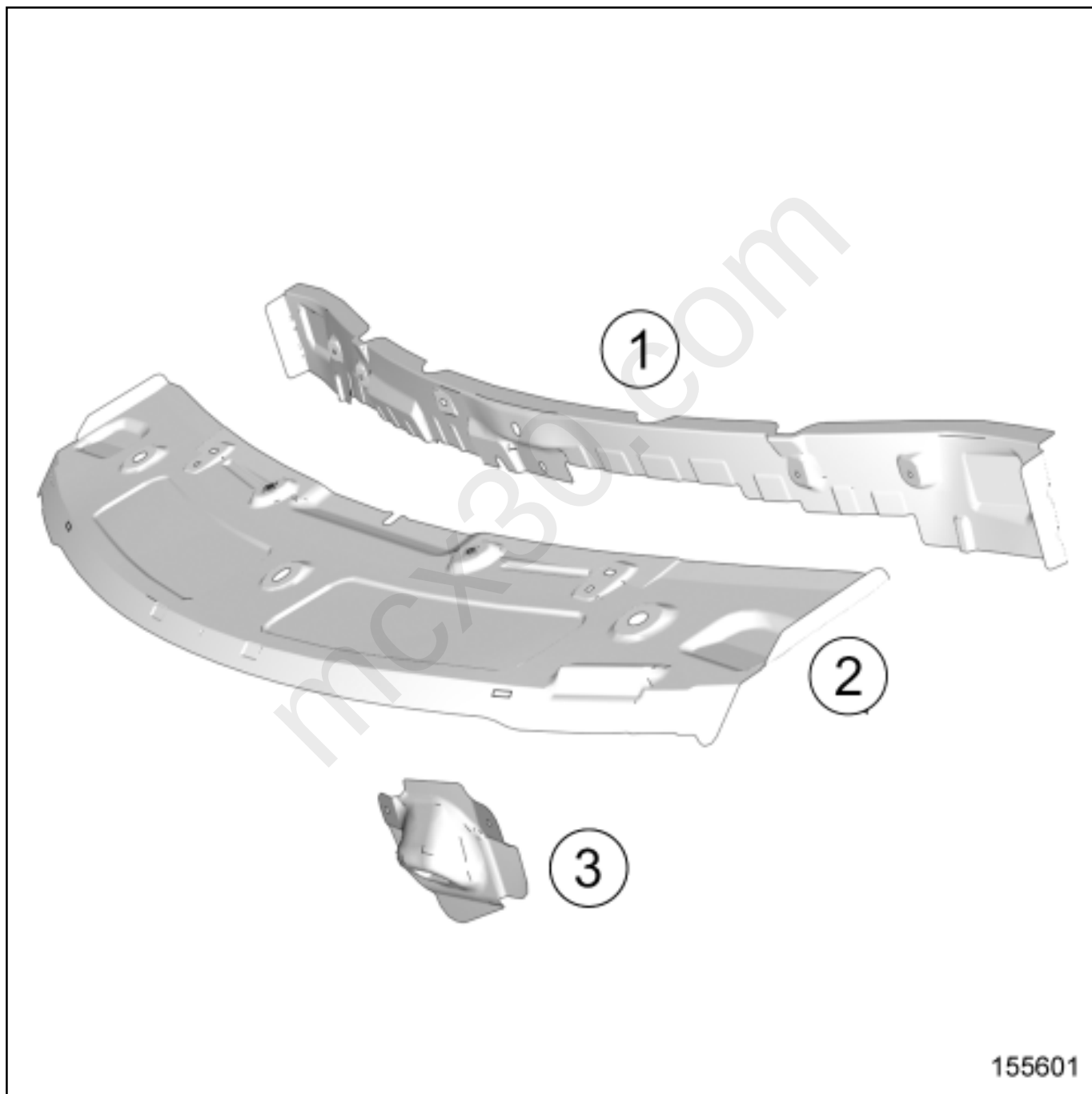
WINDSCREEN APERTURE LOWER CROSS MEMBER: REPLACEMENT



Note, one or more warnings are present in this procedure



1. COMPOSITION OF THE SPARE PART



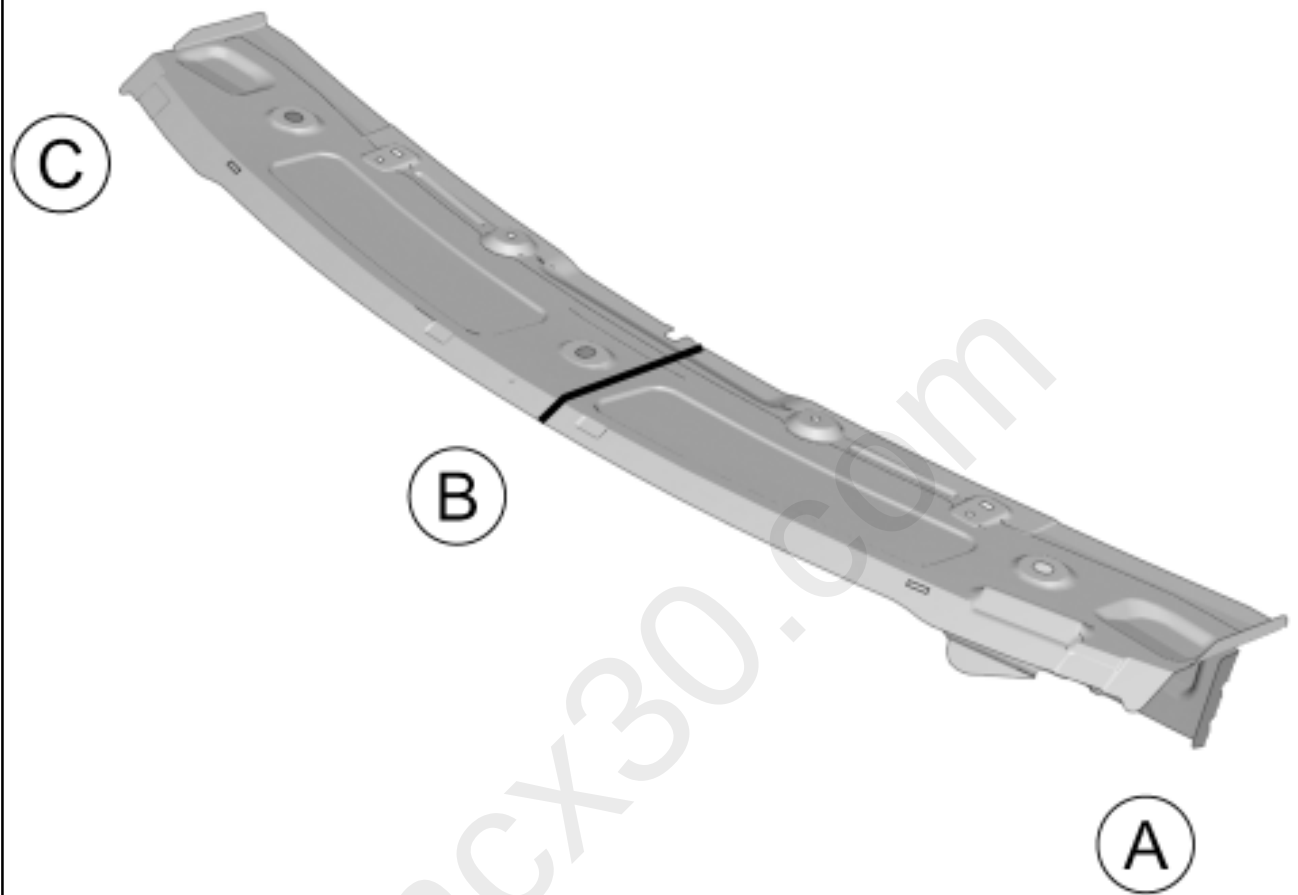
No.	Description	Type	Thickness (mm)
(1)	Windscreen aperture lower cross member	Mild steel	0.7
(2)	windscreen aperture lower cross member closure panel	Mild steel	0.7
(3)	Wiper motor bridge piece	Mild steel	1.5

2. IN THE EVENT OF REPLACEMENT

■ The options for replacing this part are as follows:

- complete replacement A-C,

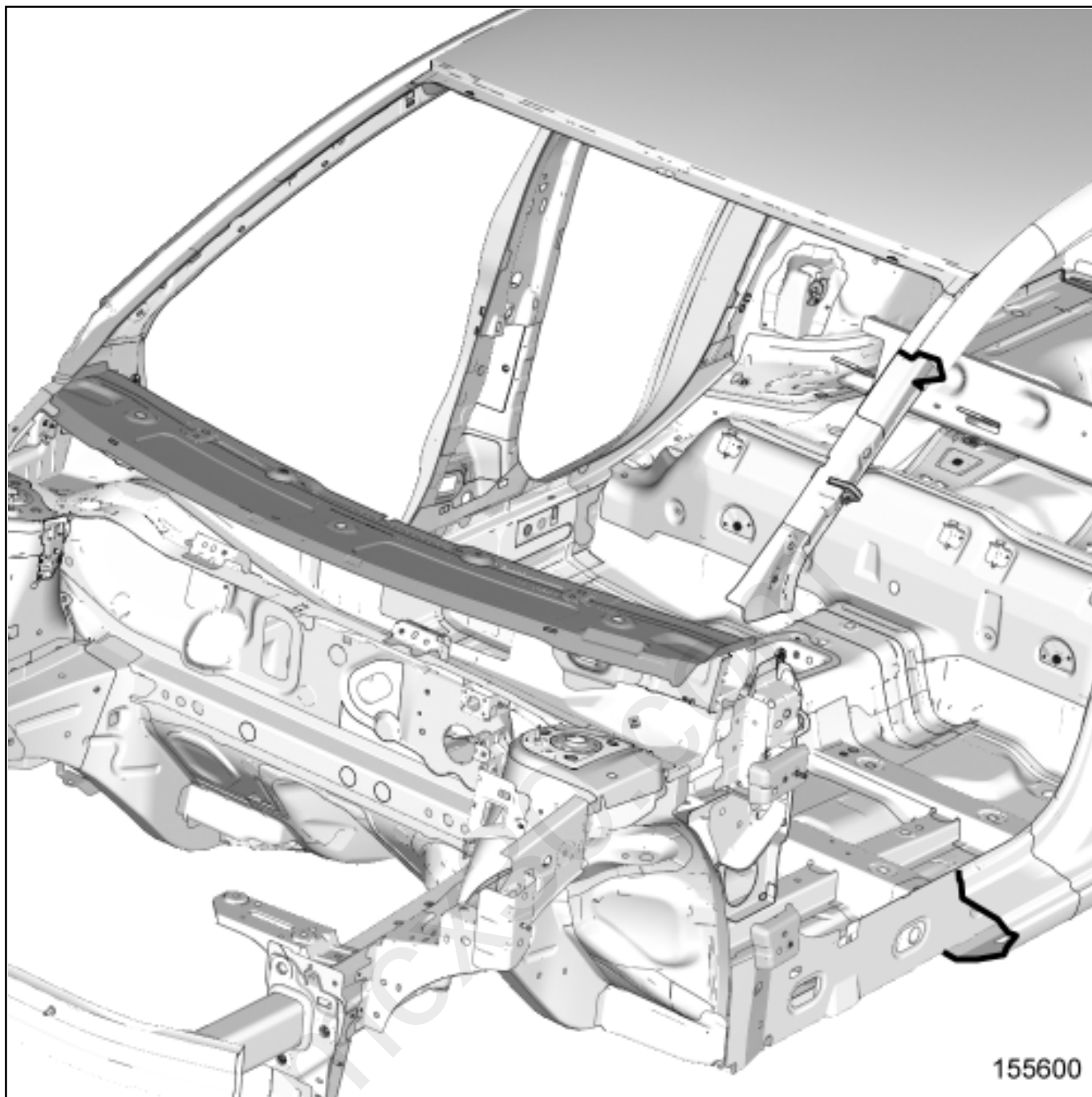
partial replacement A-B.



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1- COMPLETE REPLACEMENT A-C

1)PART IN POSITION



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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).

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

3)SPECIAL NOTES ON MATING



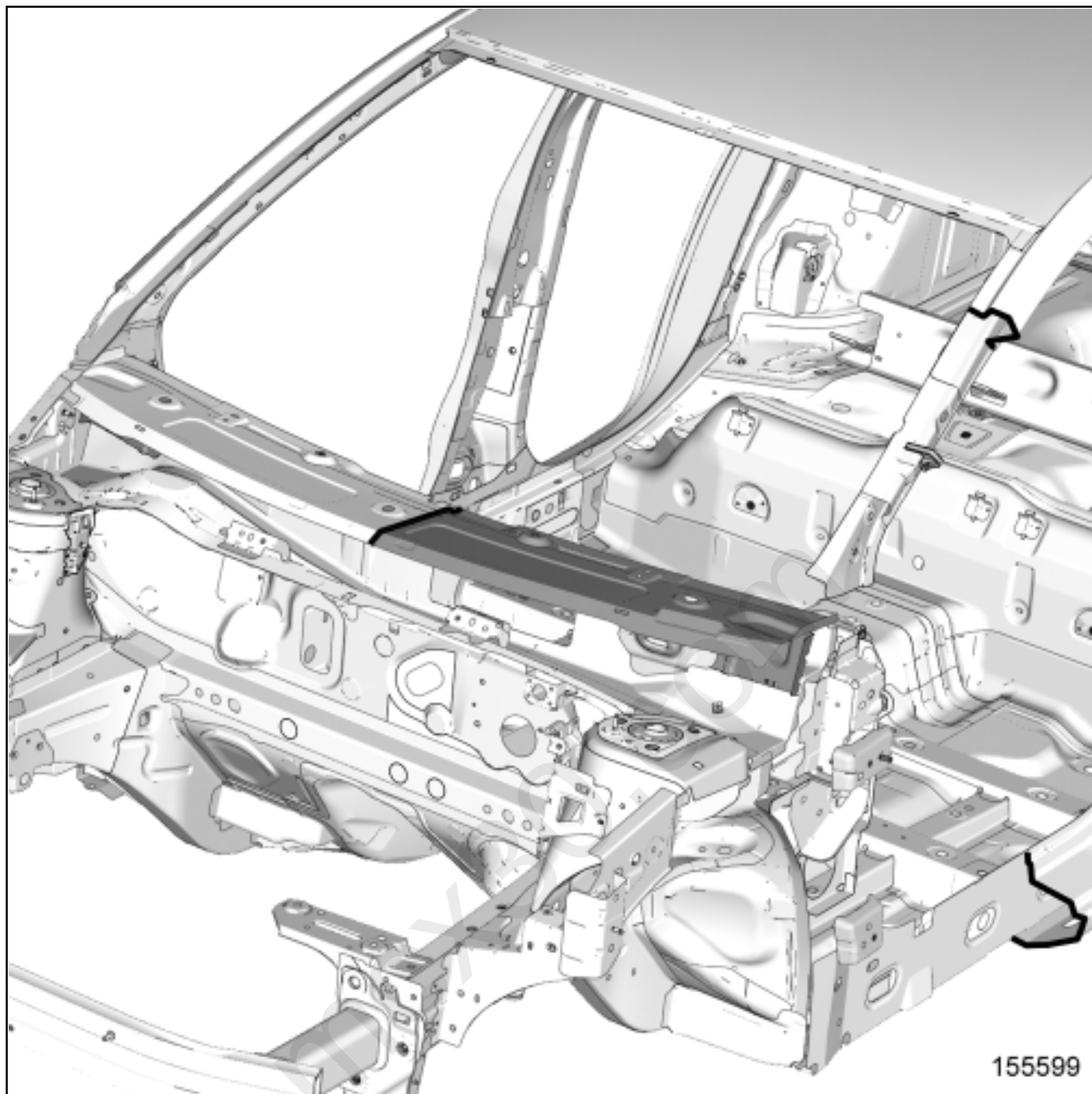
CAUTION

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)).

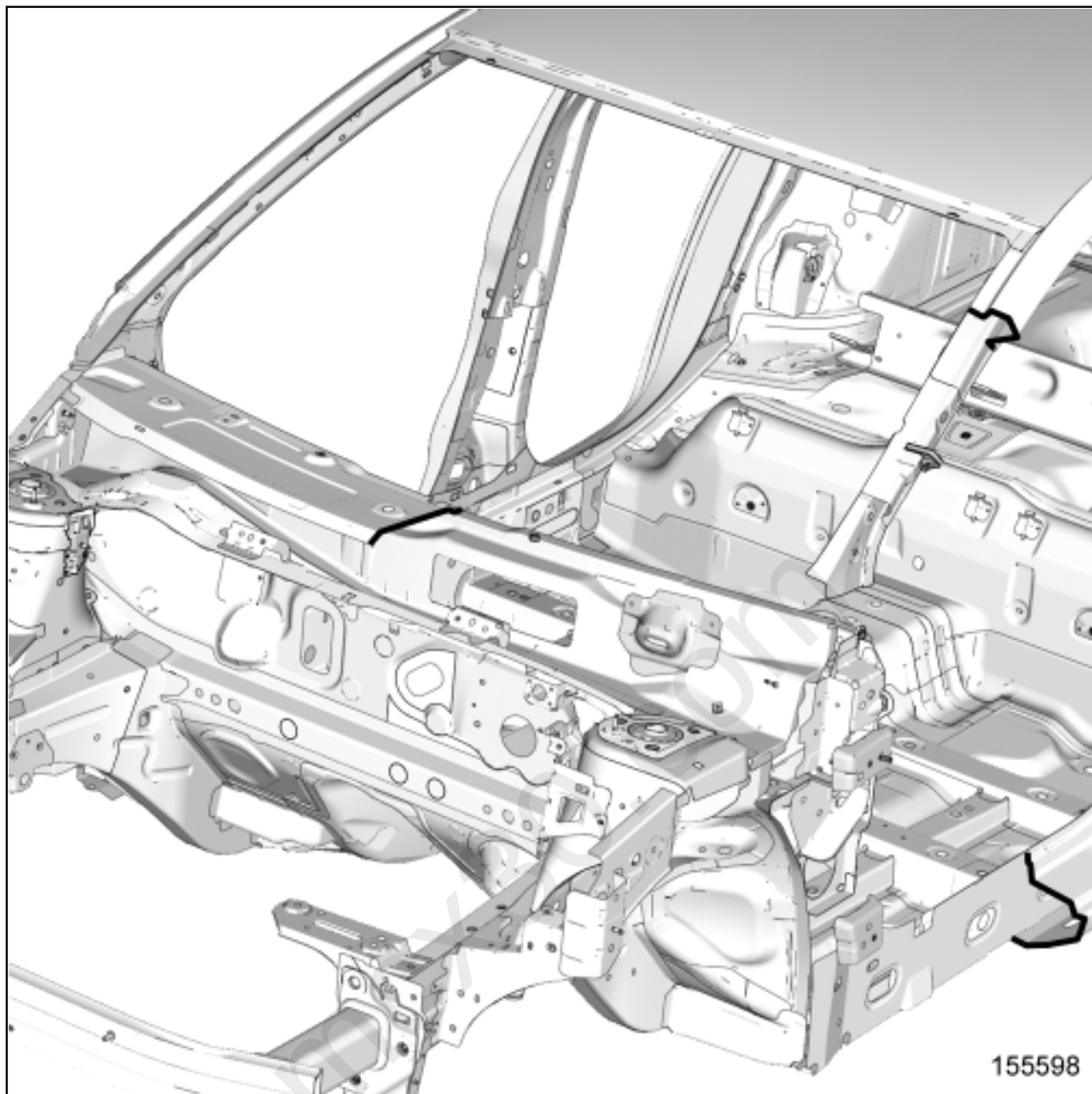
2- PARTIAL REPLACEMENT A-B

1)PART IN POSITION

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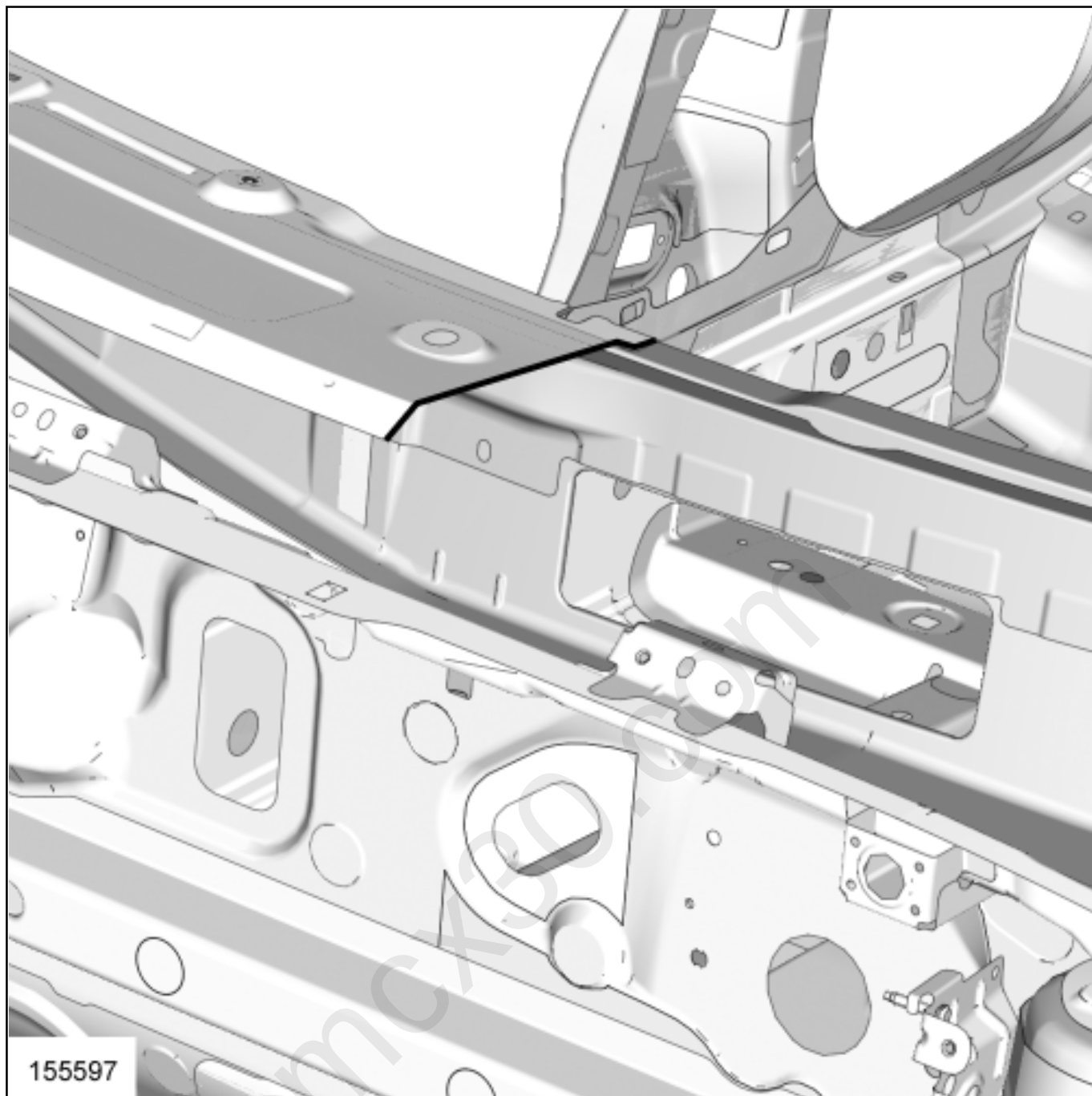


VIEW WITHOUT PART



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DETAILED VIEW OF CUT B



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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).