

FRONTHALF-UNIT:REPLACEMENT



Note, one or more warnings are present in this procedure



WARNING

DANGER: HIGH VOLTAGE VEHICLE.



Risks of serious burns or electric shocks that may prove fatal.

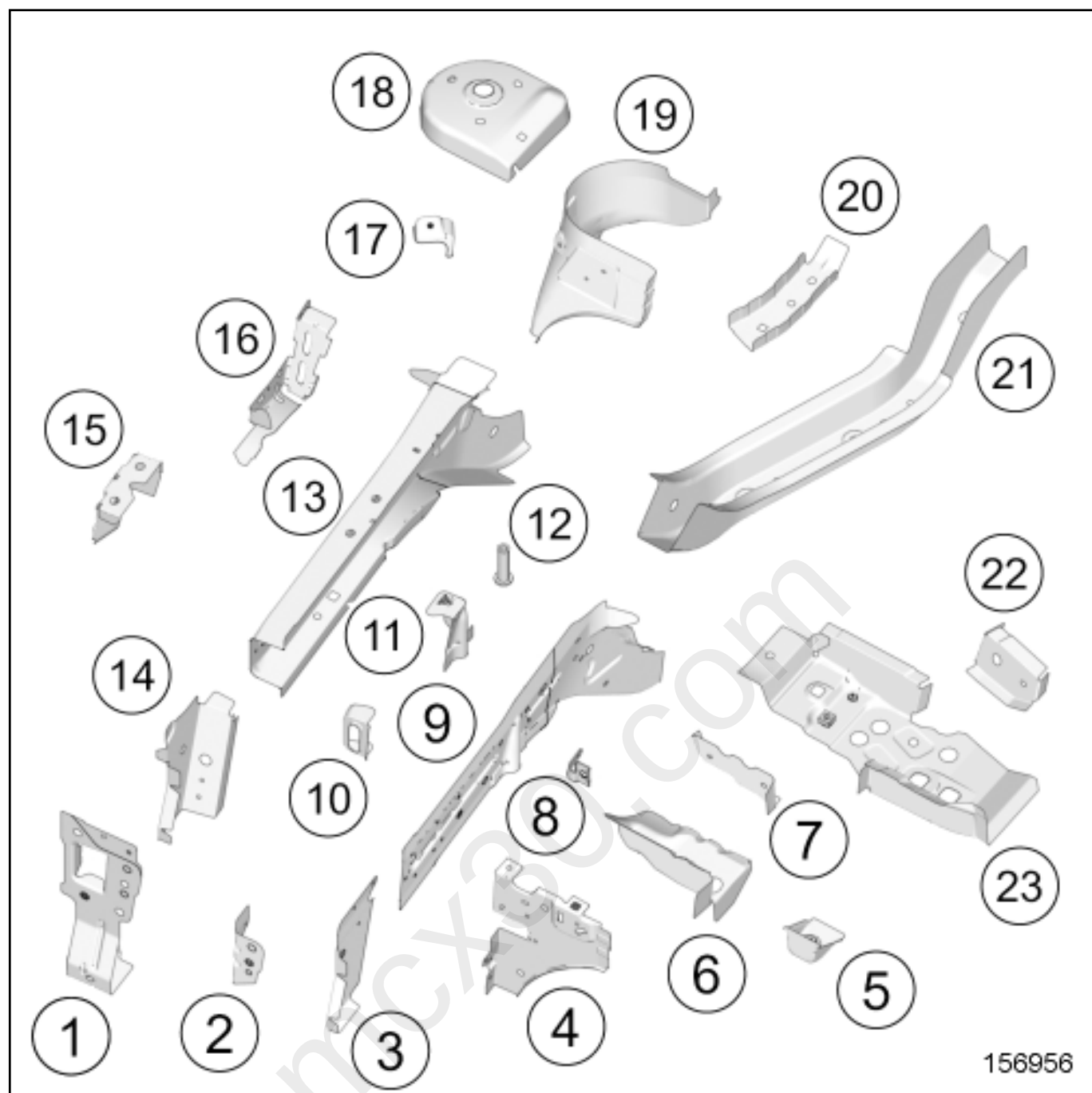
Before carrying out any work on the vehicle, it is essential that you follow the instructions regarding vehicle lockout. This work must be carried out by an employee who is qualified and authorised to work on a high-voltage onboard network [Vehicle:](#)

[Precautions for the repair](#) .

Lockout the vehicle [Vehicle: Lockout - Removal of lockout](#) .

1. COMPOSITION OF THE SPARE PART

LEFT-HAND SIDE

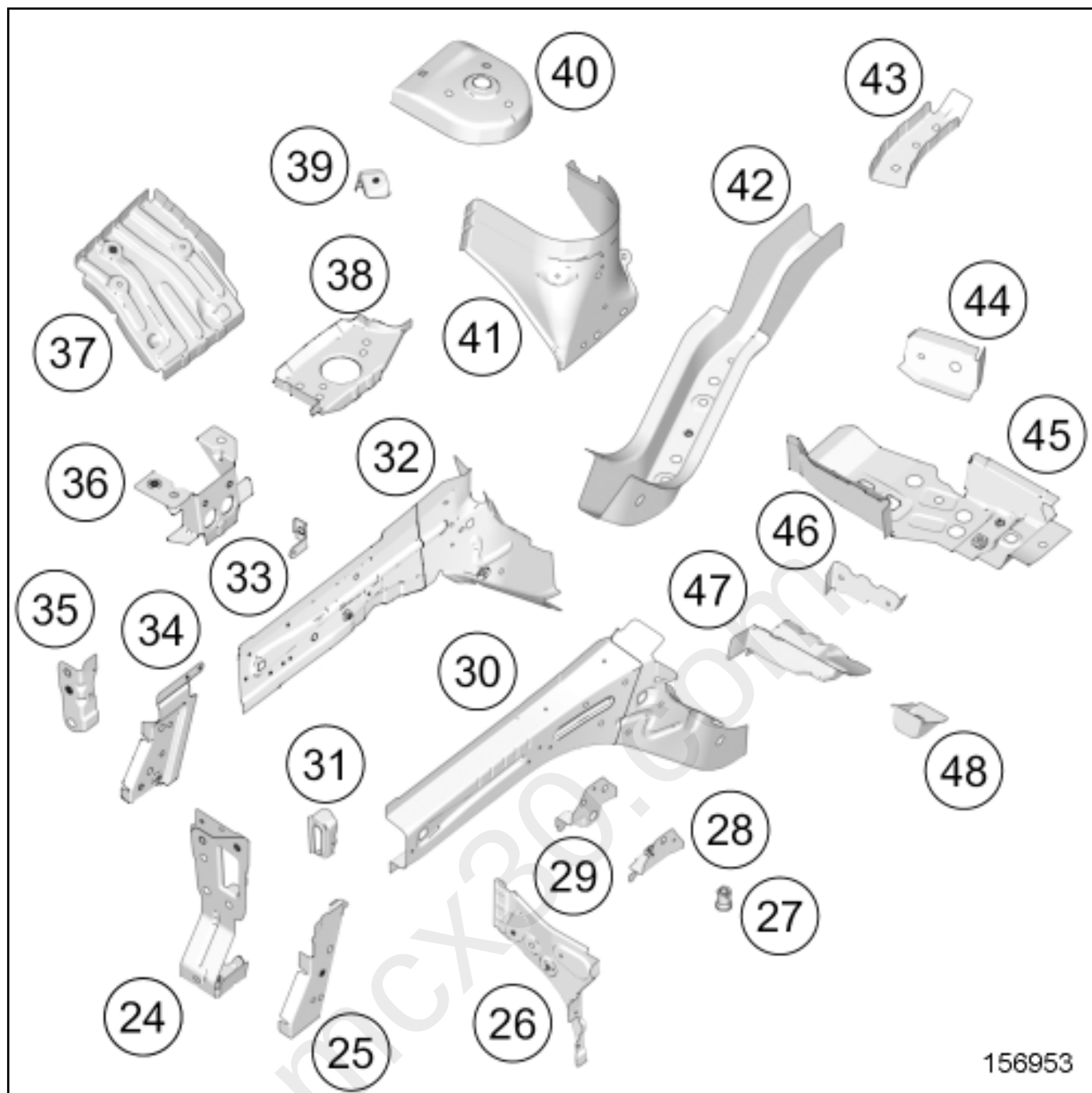


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No.	Description	Thickness (mm)
(1)	Connection component of impact absorber unit	2.5
(2)	Front cross member mounting support	2
(3)	Closure panel component impact absorber unit	1.2
(4)	Side member A-pillar lining connection element	1.5
(5)	Front subframe rear mounting reinforcement	2.6
(6)	Rear mounting unit of front subframe	2
(7)	Front side cross member	2
(8)	Brake hose stop bracket	1.5
(9)	Front side member closure panel	1.6/2.7
(10)	Front left-hand side member impact reinforcement	2
(11)	Front sub-frame front mounting unit	3
(12)	Subframe mounting spacer	4
(13)	Front left-hand side member	2/2.6
(14)	Front left-hand side member impact reinforcement	1.2
(15)	Engine - gearbox assembly suspension reinforcement on body	1.6

(16)	Front left-hand side member reinforcement	1.6
(17)	Windscreen wiper plate mounting bridge	1.5
(18)	Front left-hand shock absorber cup	2.2
(19)	Front shock absorber cup height adjuster	1.2
(20)	Front side member union reinforcement	1.5
(21)	Front side member union	2.5
(22)	Front end side cross member	1.5
(23)	Centre floor front side cross member	2

RIGHT-HAND SIDE



No.	Description	Thickness (mm)
(24)	Connection component of impact absorber unit	2.5
(25)	Front right-hand side member impact reinforcement	1.2
(26)	Front section engine mounting	1.5
(27)	Subframe mounting spacer	4
(28)	Subframe front mounting unit closure panel	2
(29)	Front sub-frame front mounting unit	2
(30)	Front right-hand side member	2/2.6
(31)	Front right-hand side member impact reinforcement	2
(32)	Front side member closure panel	1.6/2.7
(33)	Brake hose stop bracket	2
(34)	Closure panel component impact absorber unit	1.2
(35)	Front end cross member support	2
(36)	Engine mounting lower section	2
(37)	Right-hand engine - gearbox assembly suspension support on body	1.5
(38)	Engine mounting centre section	2.5

(39)	Windscreen wiper plate mounting bridge	1.5
(40)	Front right-hand shock absorber cup	2.2
(41)	Front shock absorber cup height adjuster	1.2
(42)	Front side member union	2.5
(43)	Front side member union reinforcement	1.5
(44)	Front end side cross member	1.5
(45)	Rear mounting unit of front subframe	2
(46)	Front side cross member	2
(47)	Rear mounting unit of front subframe	2
(48)	Front subframe rear mounting reinforcement	2.6

2. IN THE EVENT OF REPLACEMENT

- ☐ There is one way of replacing this part:
- partial replacement.



CAUTION

If the mating faces of the parts to be welded are not accessible, make EGW plug welds to replace the original resistance welds (see MR 400).

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 MR 400).

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

1- PARTIAL REPLACEMENT

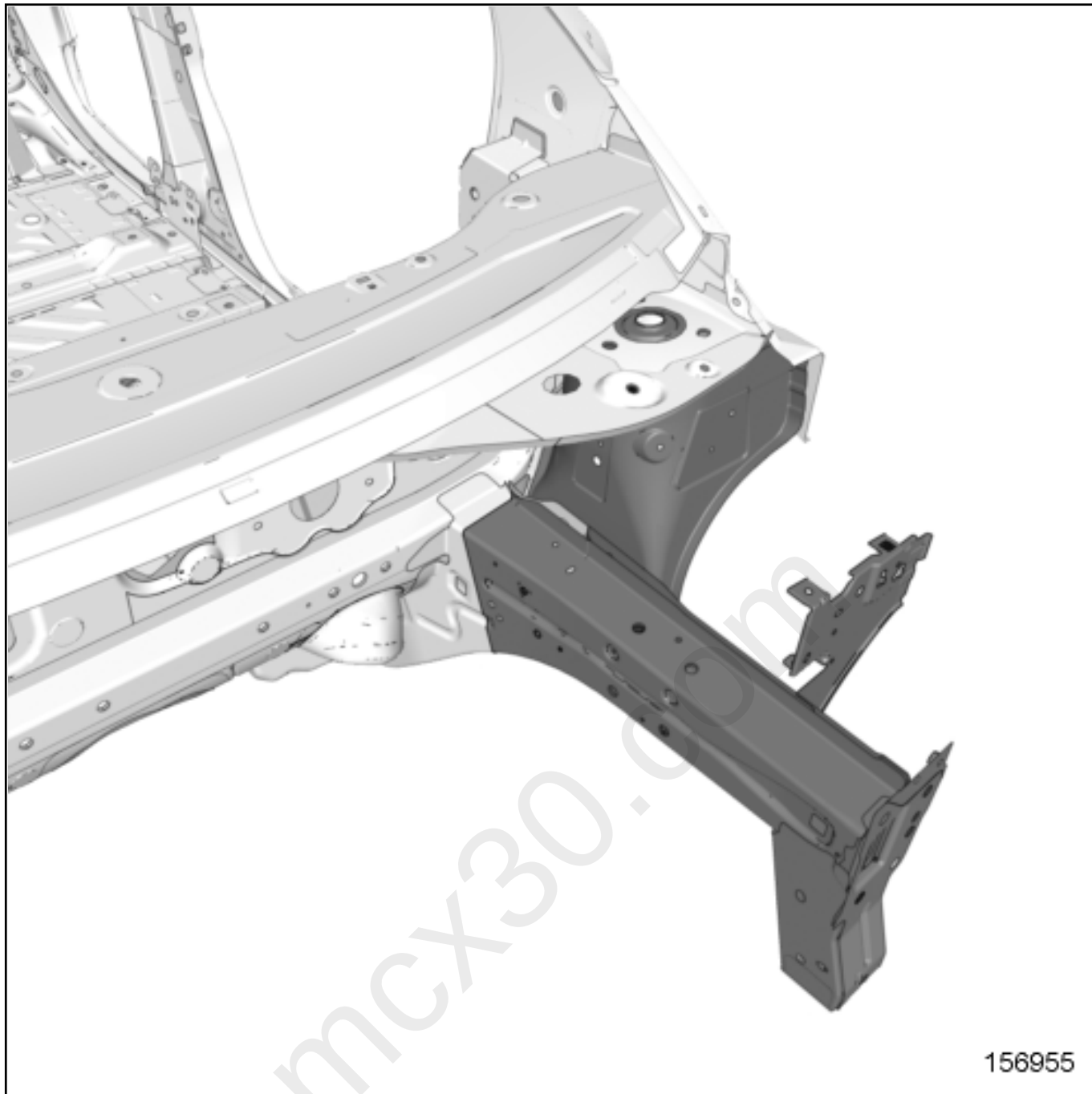


WARNING

Use a repair bench to ensure the positioning of the points and the geometry of the axle assemblies.

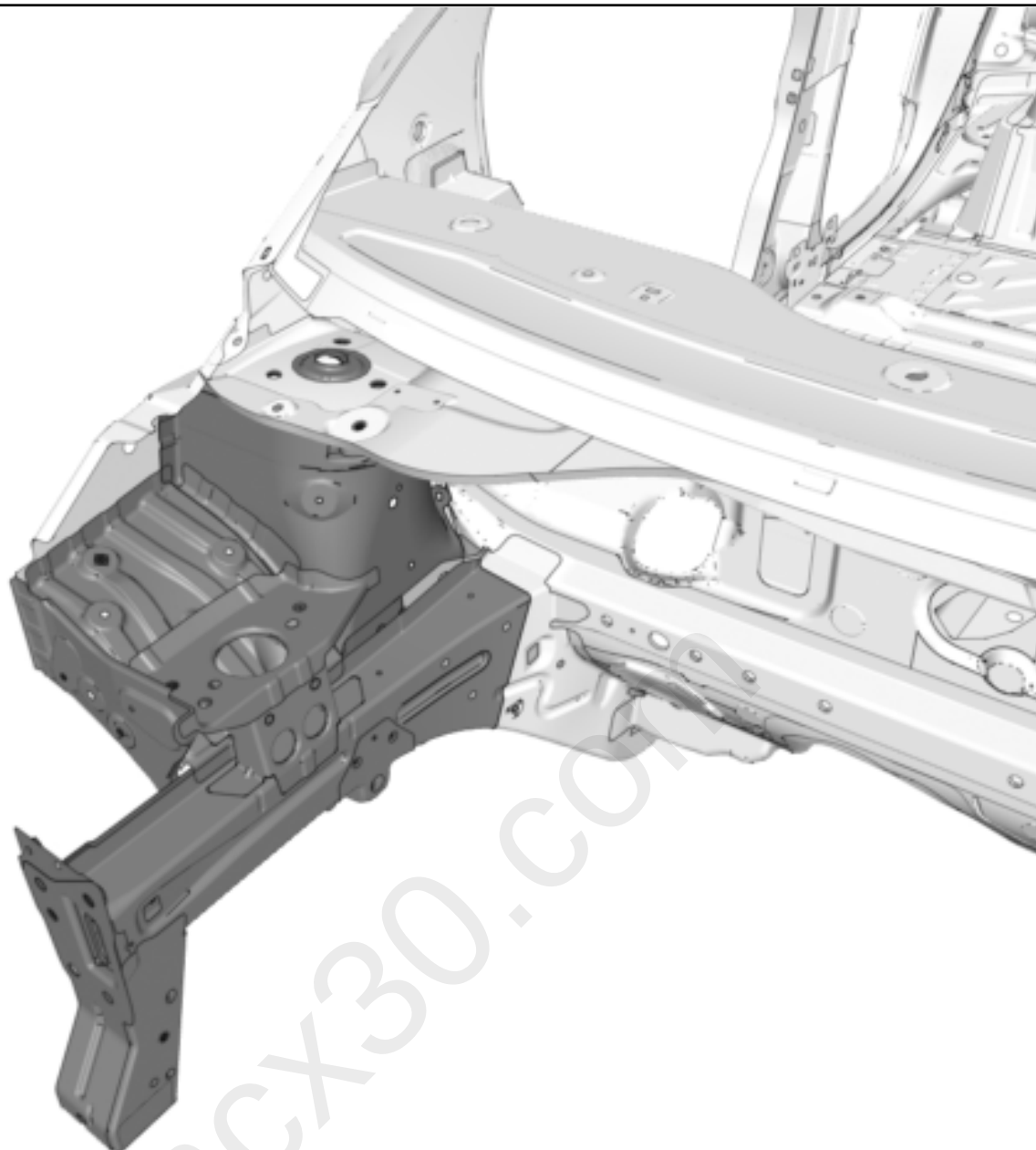
1)PART IN POSITION

LEFT-HAND SIDE



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RIGHT-HAND SIDE



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