

FRONT SIDE MEMBER CLOSURE PANEL: REPLACEMENT



Note, one or more warnings are present in this procedure



WARNING

DANGER: HIGH VOLTAGE VEHICLE.



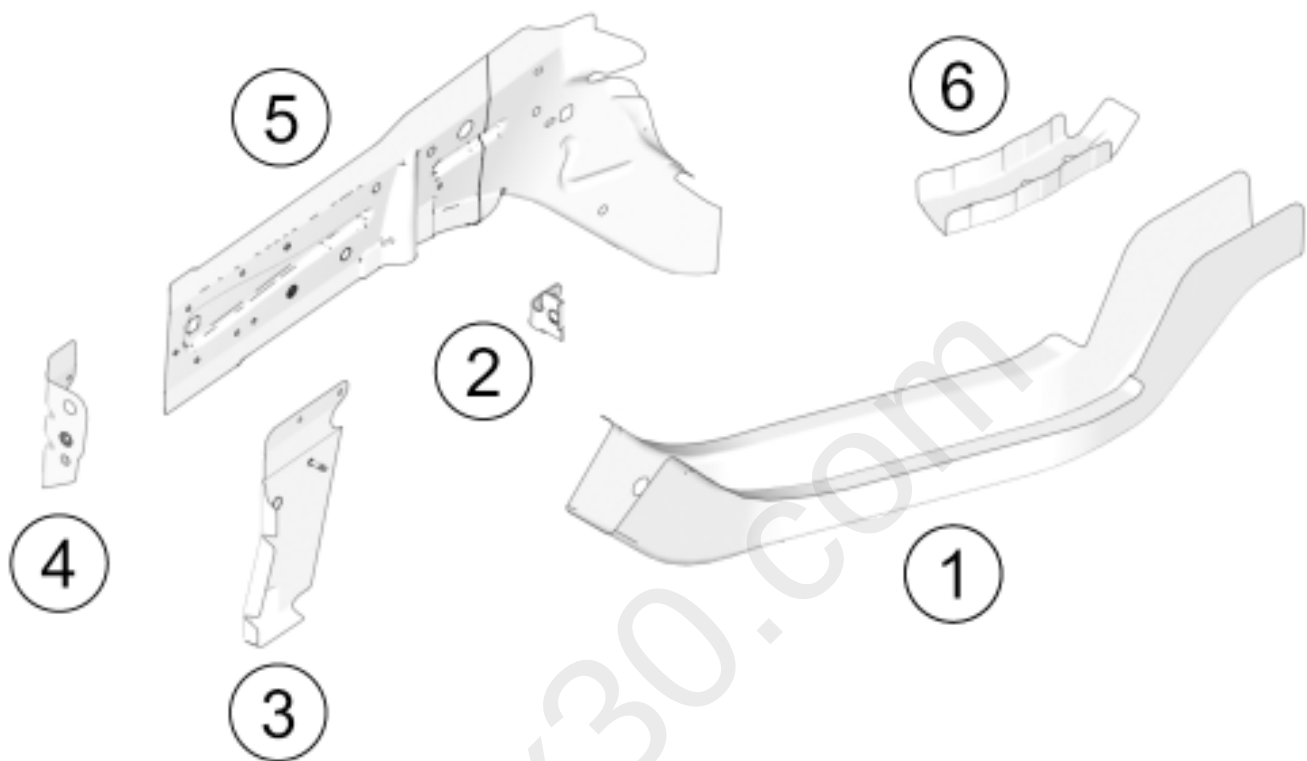
Risks of serious burns or electric shocks that may prove fatal.

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



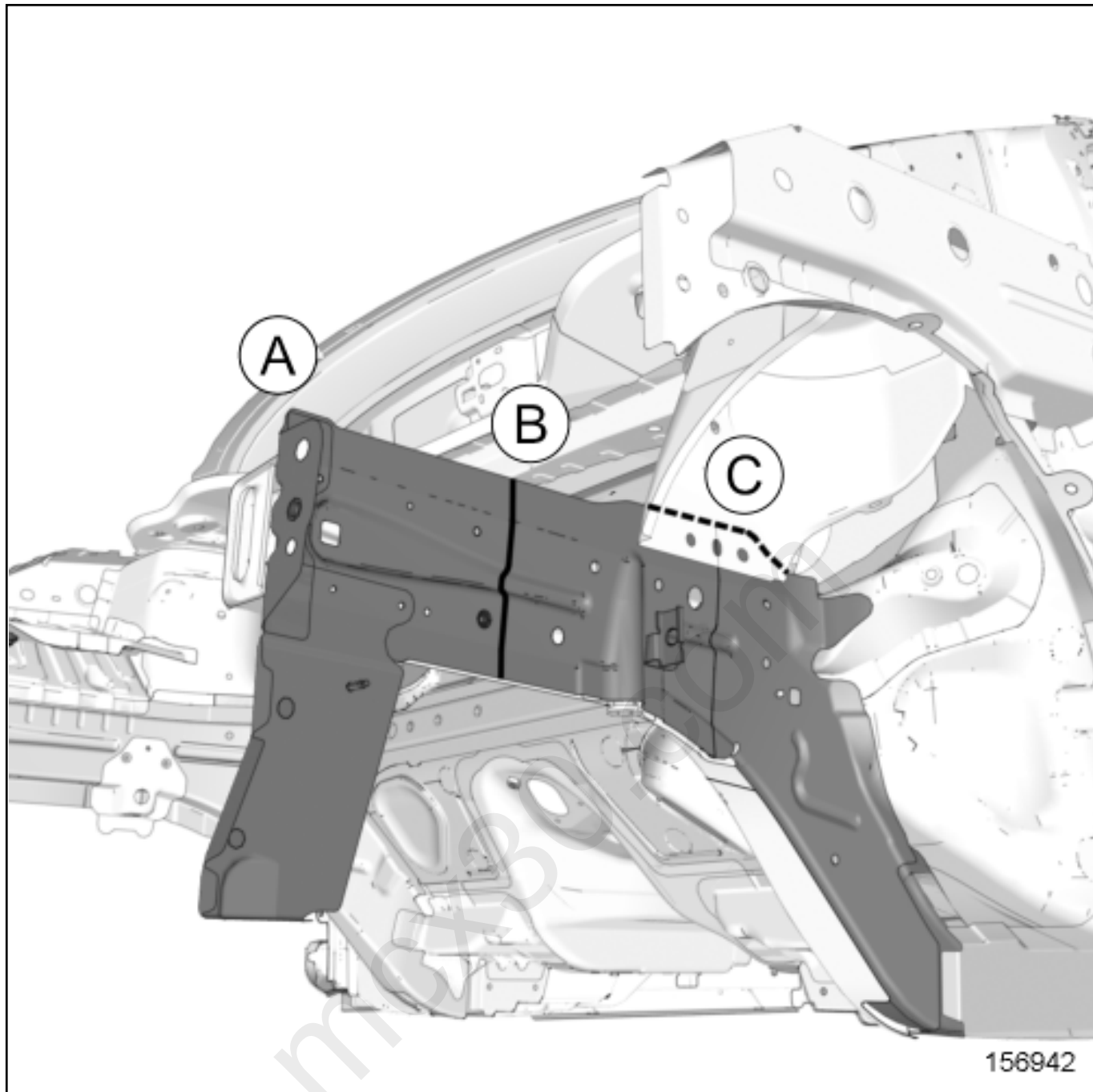
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No.	Description	Thickness (mm)
(1)	Front side member union	2.5
(2)	Brake hose stop bracket	1.5
(3)	Closure panel component impact absorber unit	1.2
(4)	Front cross member mounting support	2
(5)	Front side member closure panel	1.6/2.7
(6)	front side member union reinforcement	1.5

2. IN THE EVENT OF REPLACEMENT

■ The options for replacing this part are as follows:

- partial replacement A-B,
- partial replacement A-C.



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.

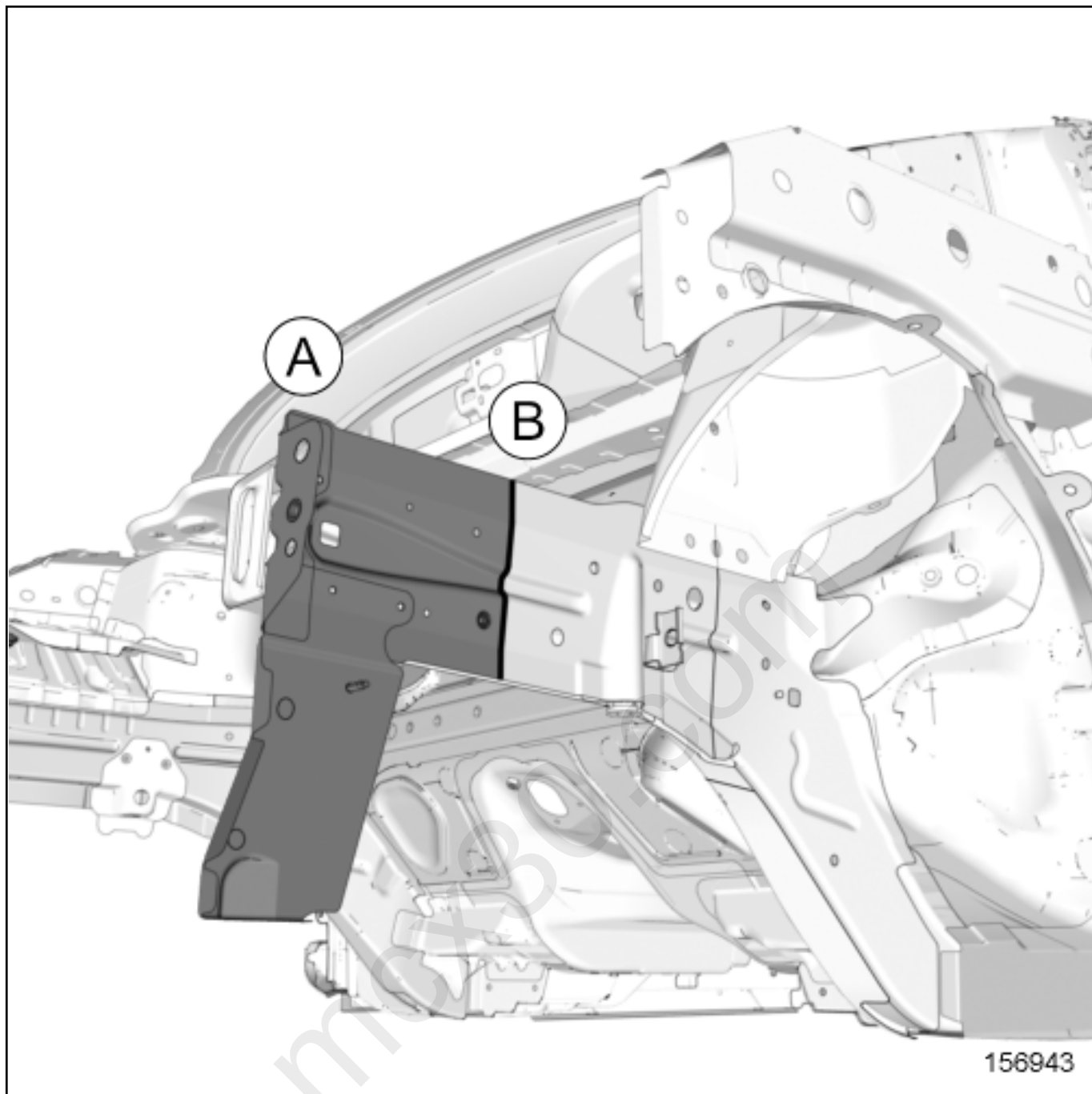
Position the earth of the welding machine as close as possible to the weld area (see MR 400).

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

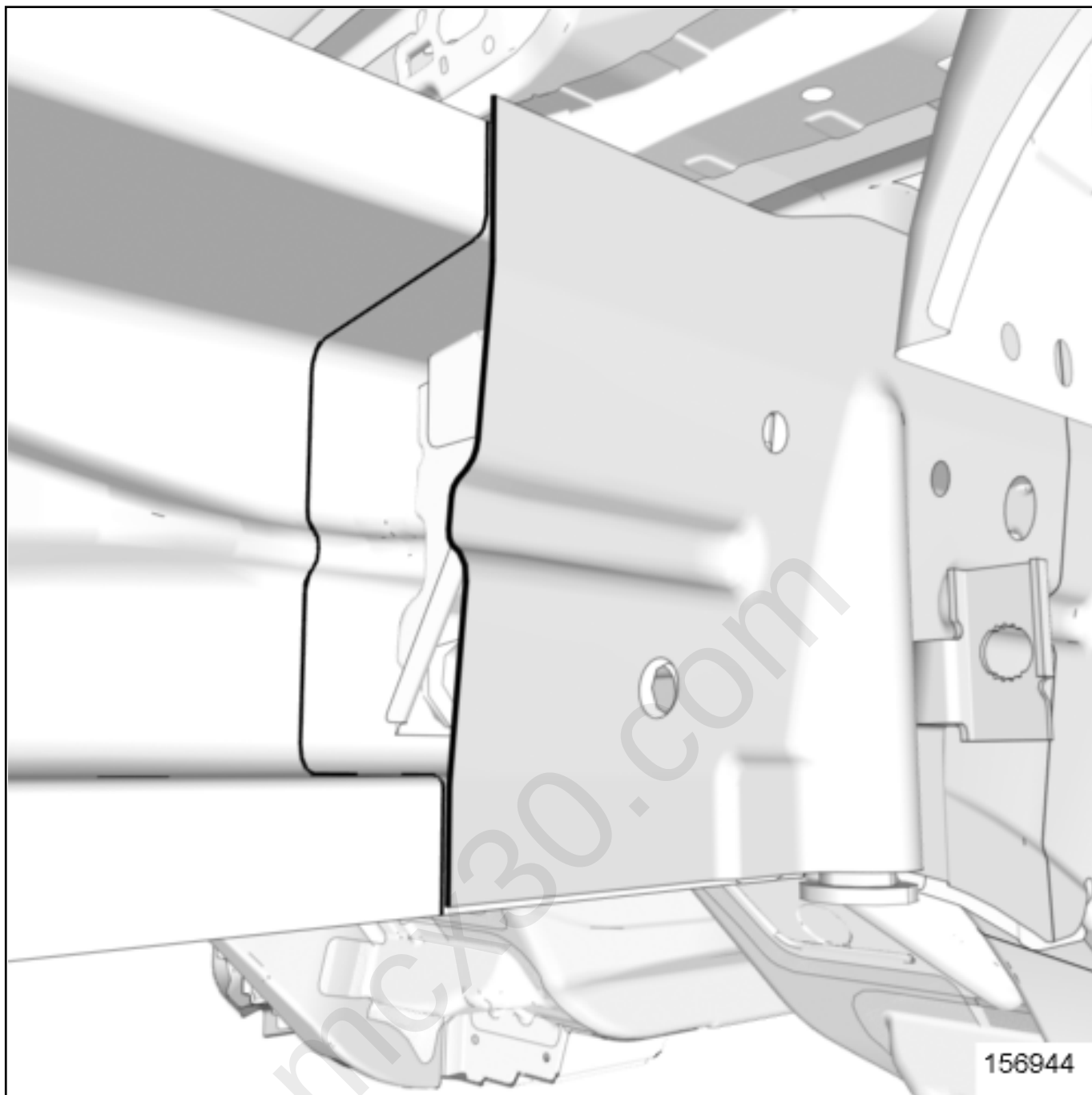
1- PARTIAL REPLACEMENT A-B

1)PART IN POSITION

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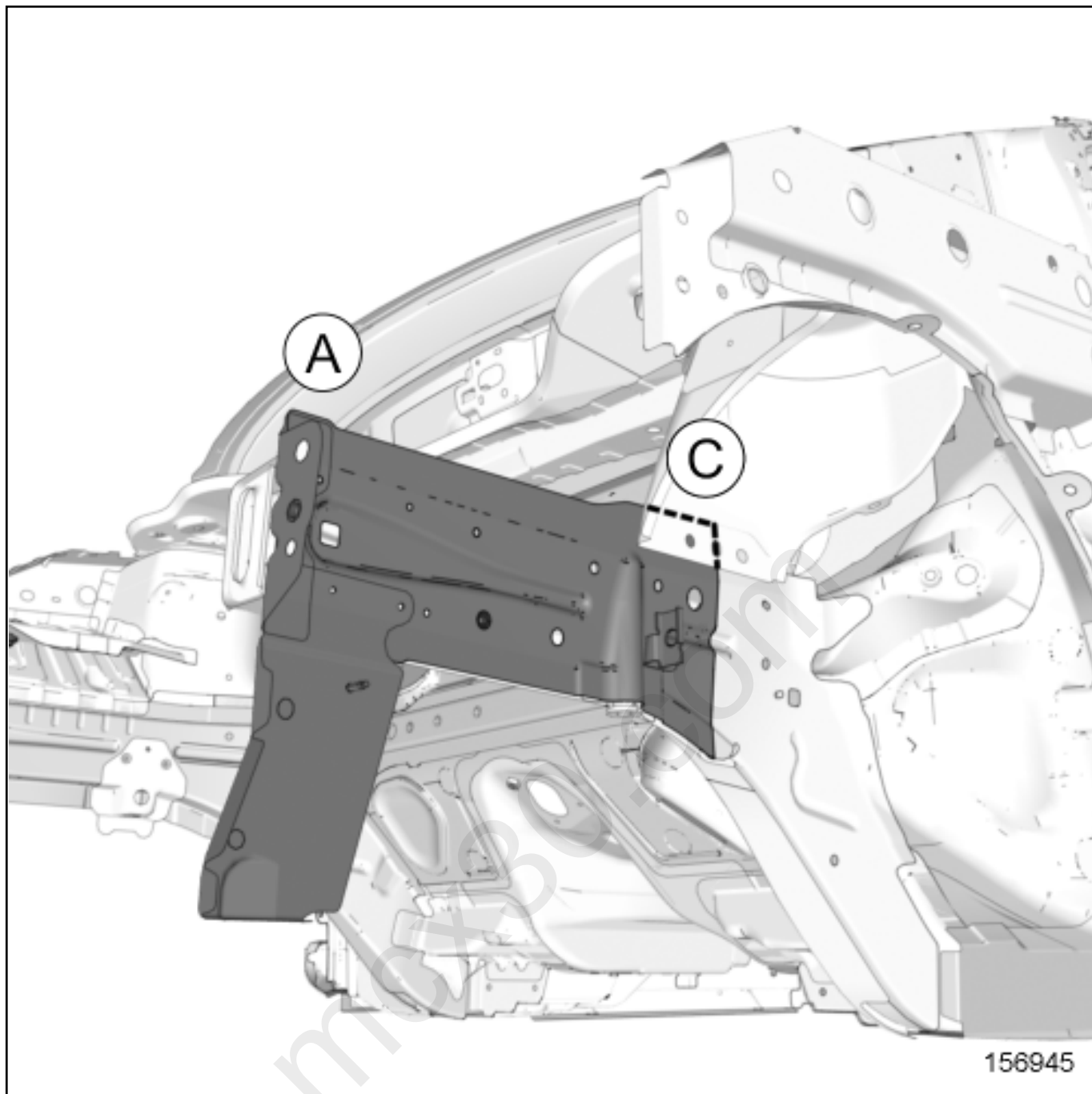


DETAILED VIEW B



2- PARTIAL REPLACEMENT A-C

1)PART IN POSITION



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