

FRONT SIDE MEMBER: 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.

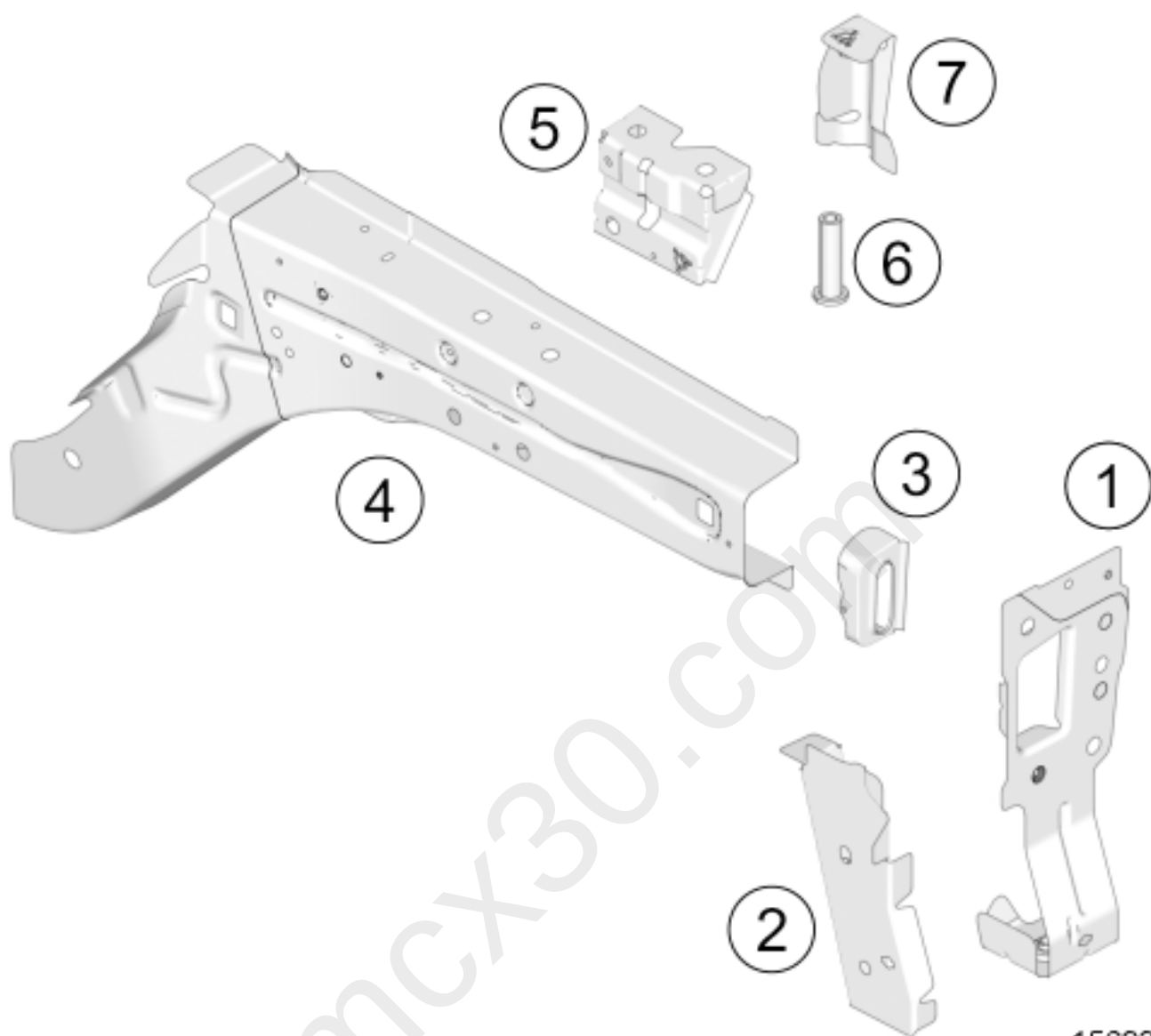
Before carrying out any work on the vehicle, it is essential that you follow the instructions regarding vehicle lockout. This work must be carried out by an employee who is qualified and authorised to work on a high-voltage onboard network [Vehicle:](#)

[Precautions for the repair](#) .

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

1. COMPOSITION OF THE SPARE PART

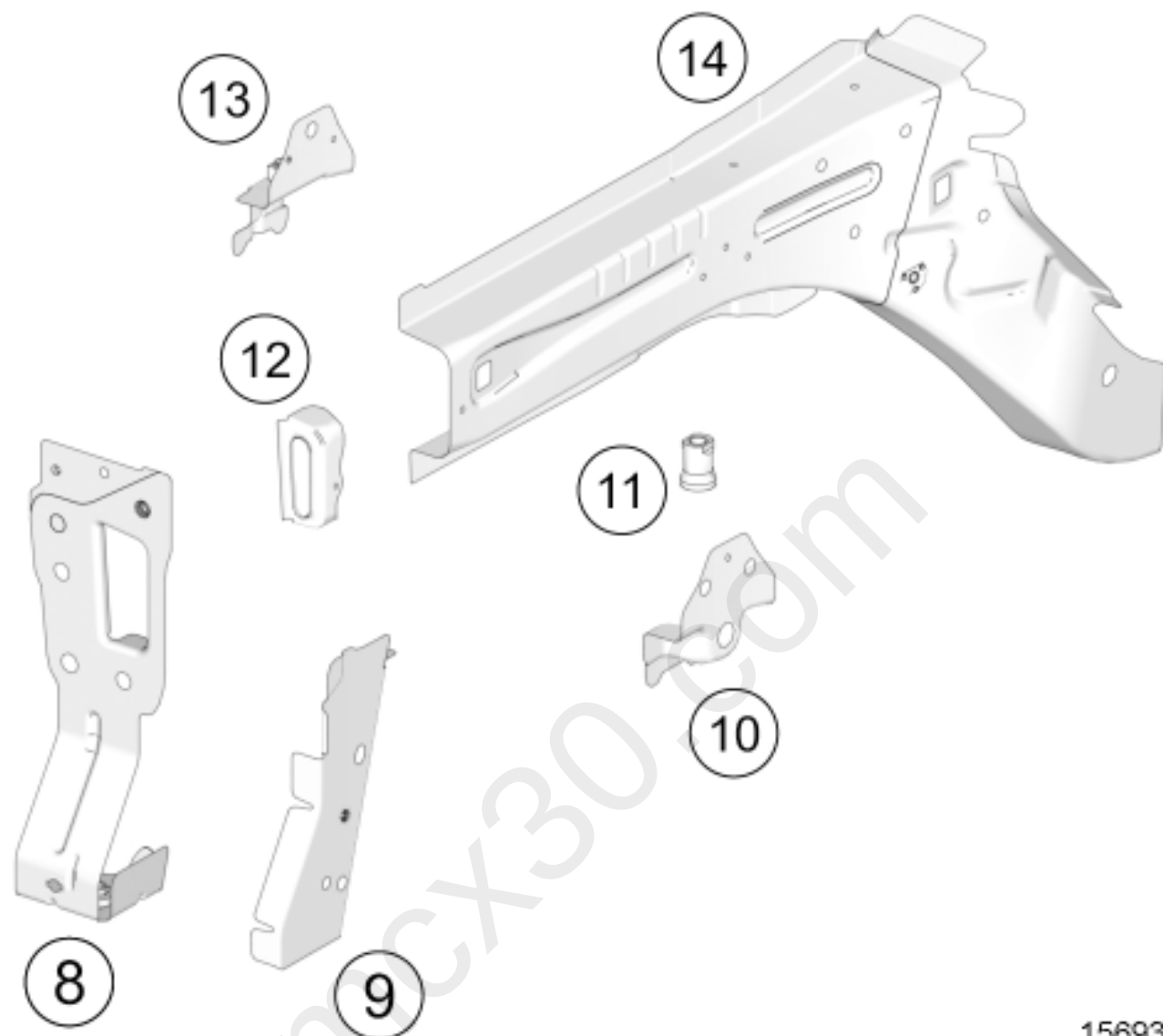
LEFT-HAND SIDE



156934

No.	Description	Thickness (mm)
(1)	Connection component of impact absorber unit	2.5
(2)	Impact absorber mounting unit	1.2
(3)	Front left-hand side member impact reinforcement	2
(4)	Front left-hand side member	2/2.6
(5)	Engine - gearbox assembly suspension reinforcement on body	1.6
(6)	Subframe mounting spacer	4
(7)	Front sub-frame front mounting unit	3

RIGHT-HAND SIDE



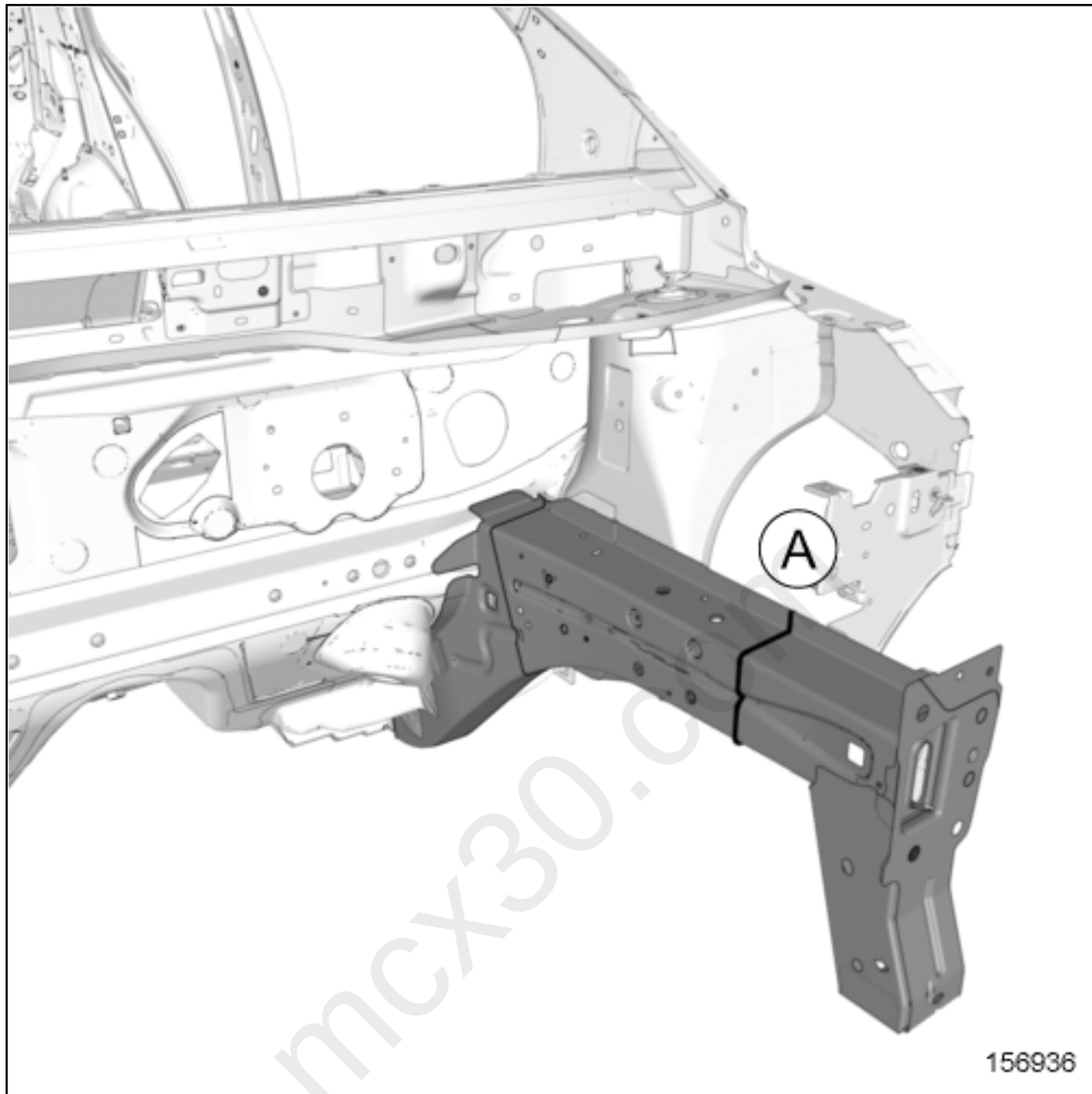
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No.	Description	Thickness (mm)
(8)	Connection component of impact absorber unit	1.6/2.5
(9)	Impact absorber mounting unit	1.5
(10)	Closure panel of subframe front mounting unit	2
(11)	Subframe mounting spacer	4
(12)	Front left-hand side member impact reinforcement	2
(13)	Subframe mounting front unit	2
(14)	Front right-hand side member	1.95

2. IN THE EVENT OF REPLACEMENT

■ The options for replacing this part are as follows:

- complete replacement,
- partial replacement along cut A.



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](#) .

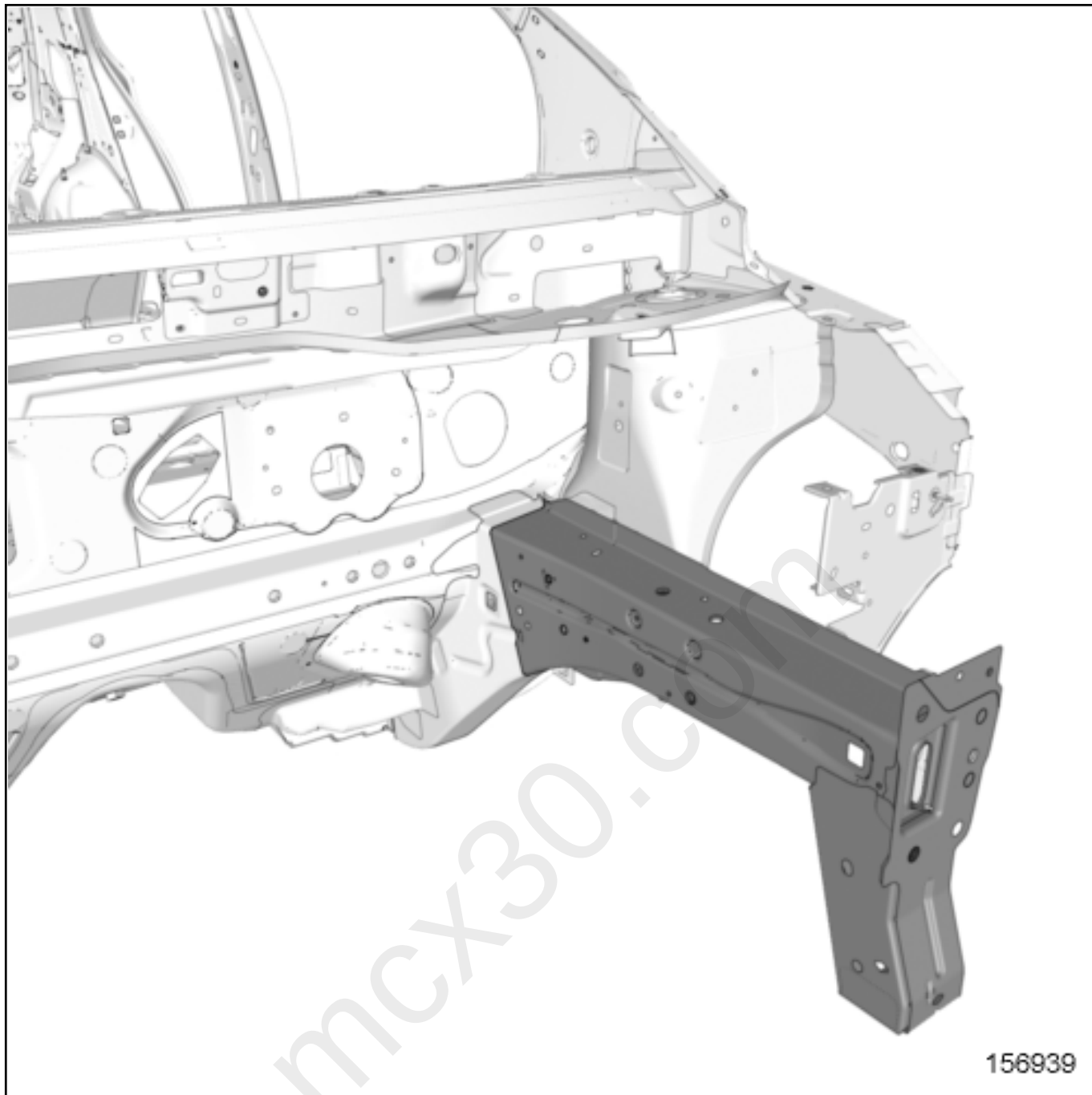
1- COMPLETE REPLACEMENT



WARNING

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

1)PART IN POSITION



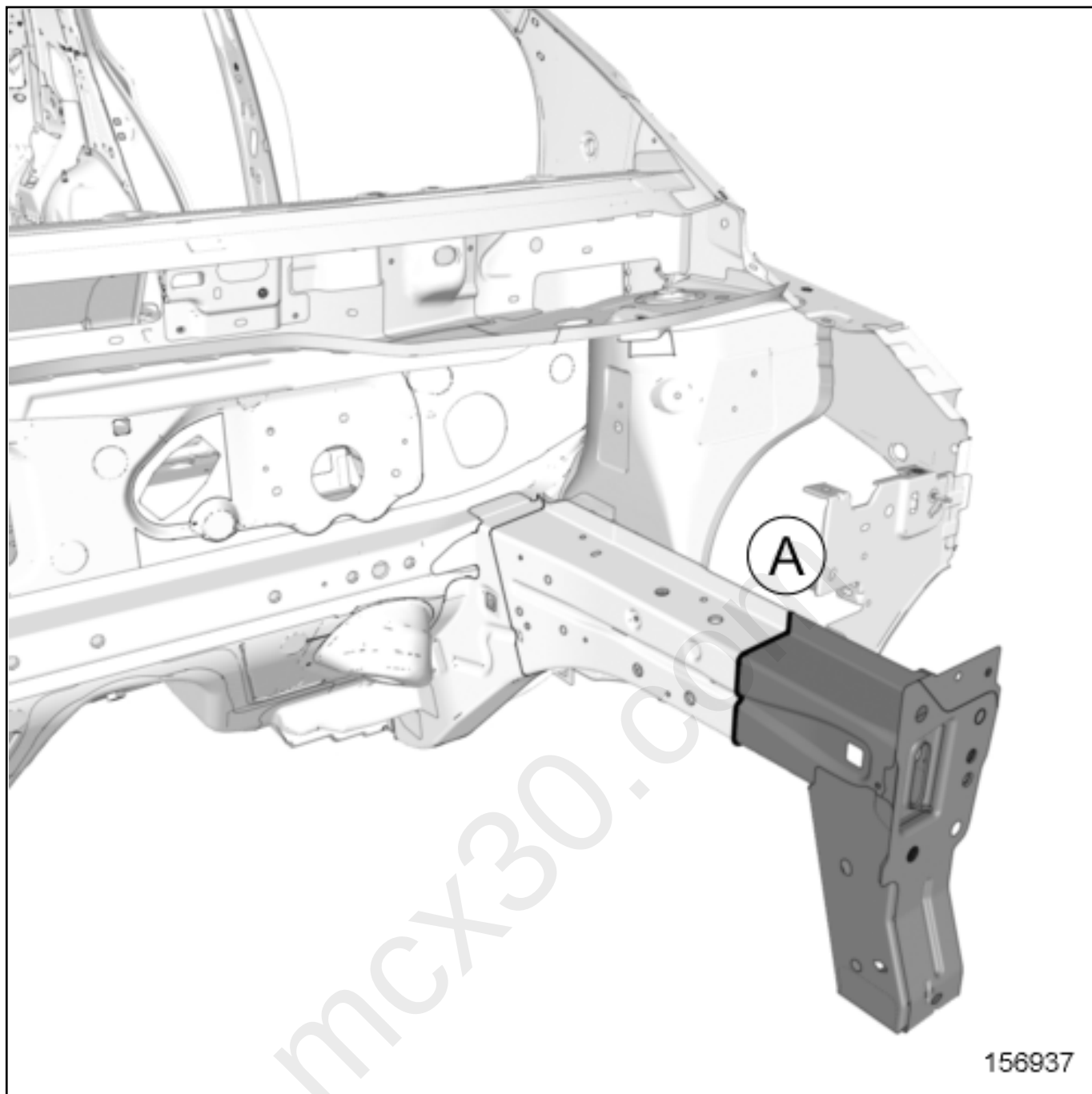
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2- PARTIAL REPLACEMENT ALONG CUT A

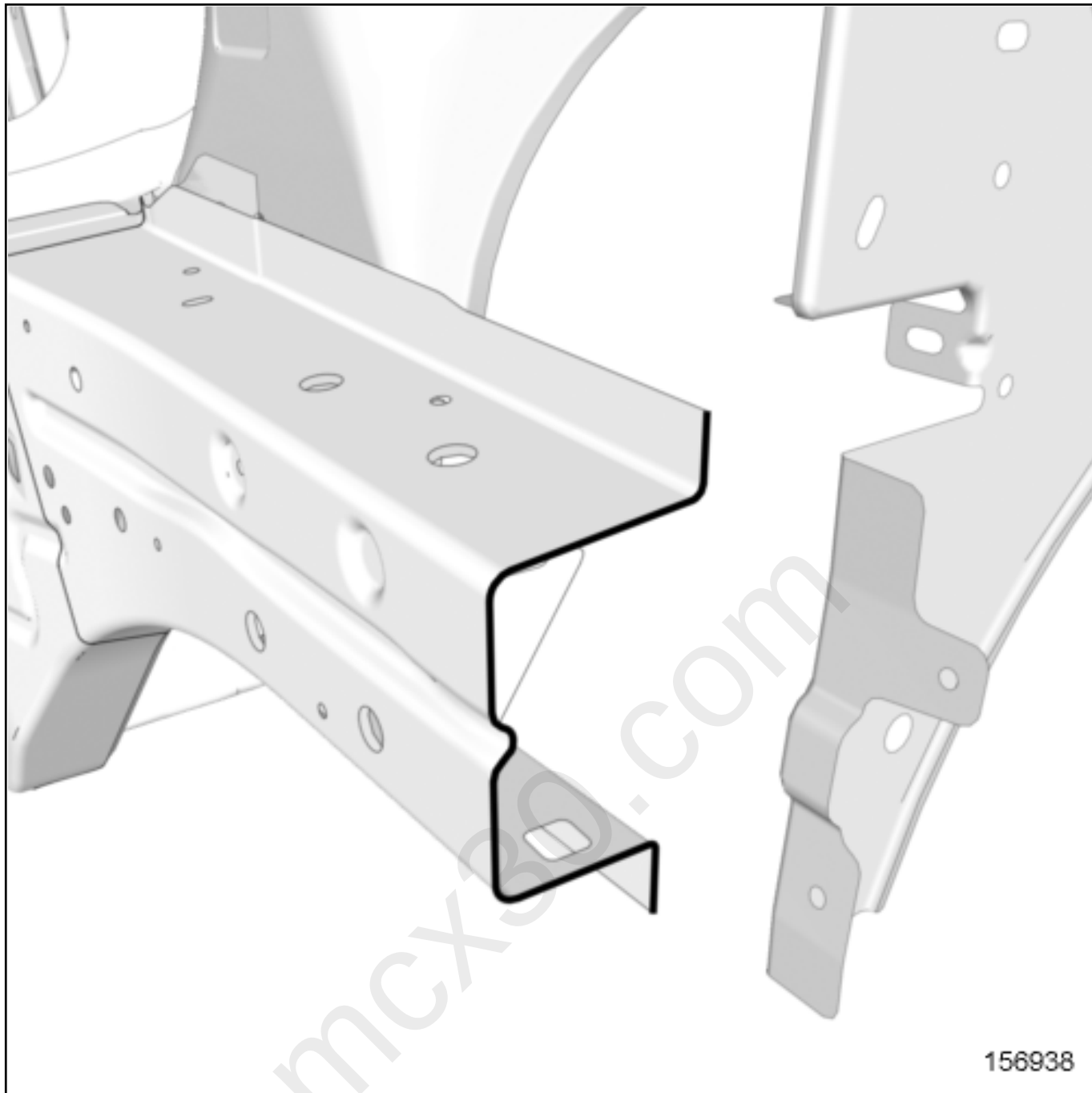


WARNING

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



DETAILED VIEW A



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