

REAR SIDE MEMBER ASSEMBLY: REPLACEMENT



Note, one or more warnings are present in this procedure



WARNING

DANGER: HIGH VOLTAGE VEHICLE.



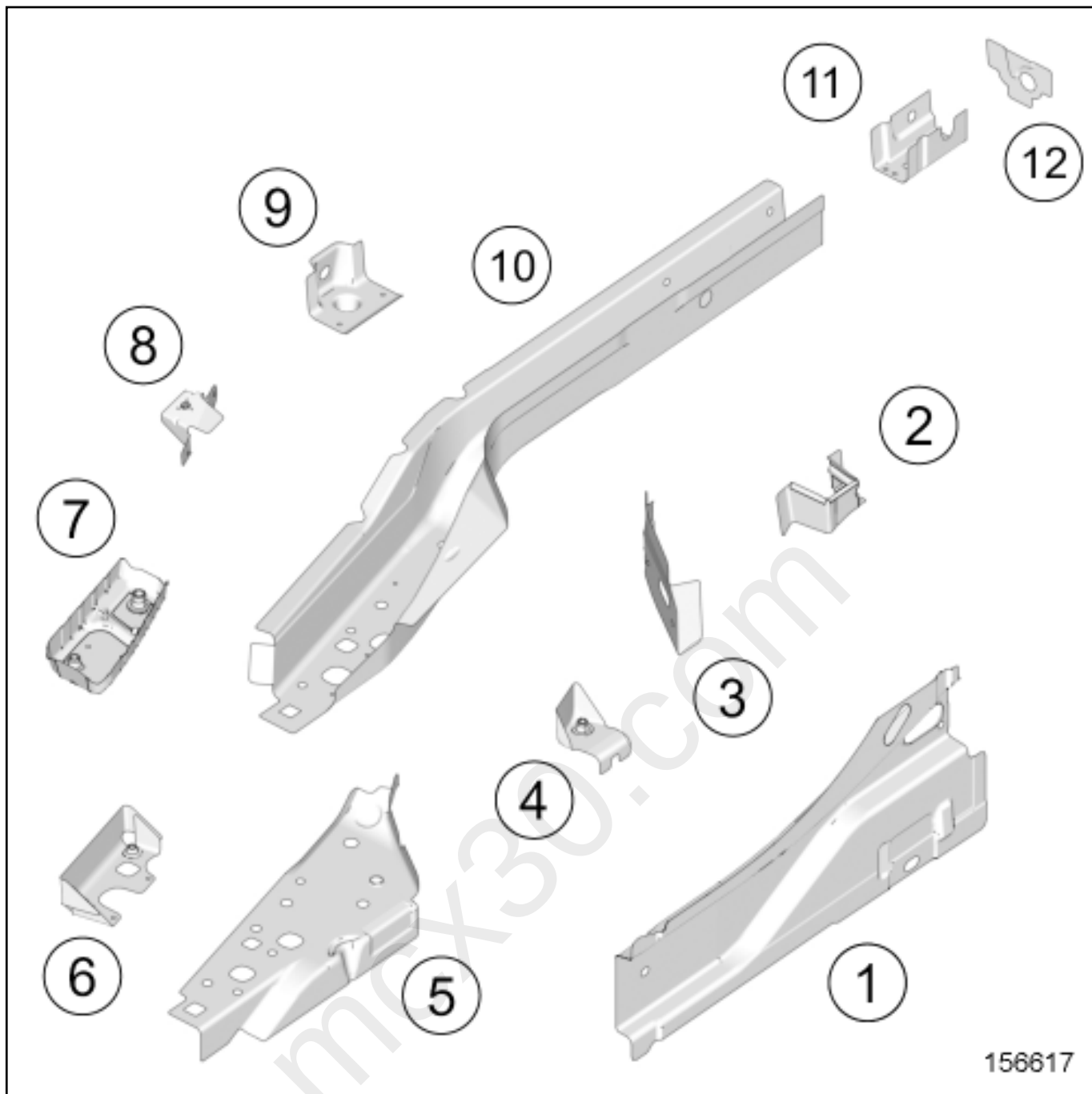
Risks of serious burns or electric shocks that may prove fatal.

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)	Sill panel rear reinforcement	1.5
(2)	Rear central side member reinforcement	1.5
(3)	Upper connecting element of sill rear reinforcement and rear side member	1.2
(4)	Rear axle mounting exterior reinforcement	2.8
(5)	Lower connecting element of sill rear reinforcement and rear side member	1.5
(6)	Battery tray rear mounting reinforcement	2.8
(7)	Rear axle mounting interior reinforcement	2.8
(8)	Seat belt anchorage point reinforcement	1.2
(9)	Rear suspension spring support	2
(10)	Rear side member	1.5
(11)	Rear cross member - rear side member connection component	2.2
(12)	Closure panel component on connection between rear side member and impact cross member mounting	2.2

2. IN THE EVENT OF REPLACEMENT

 There is only one way of replacing this part:

- complete 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](#) .

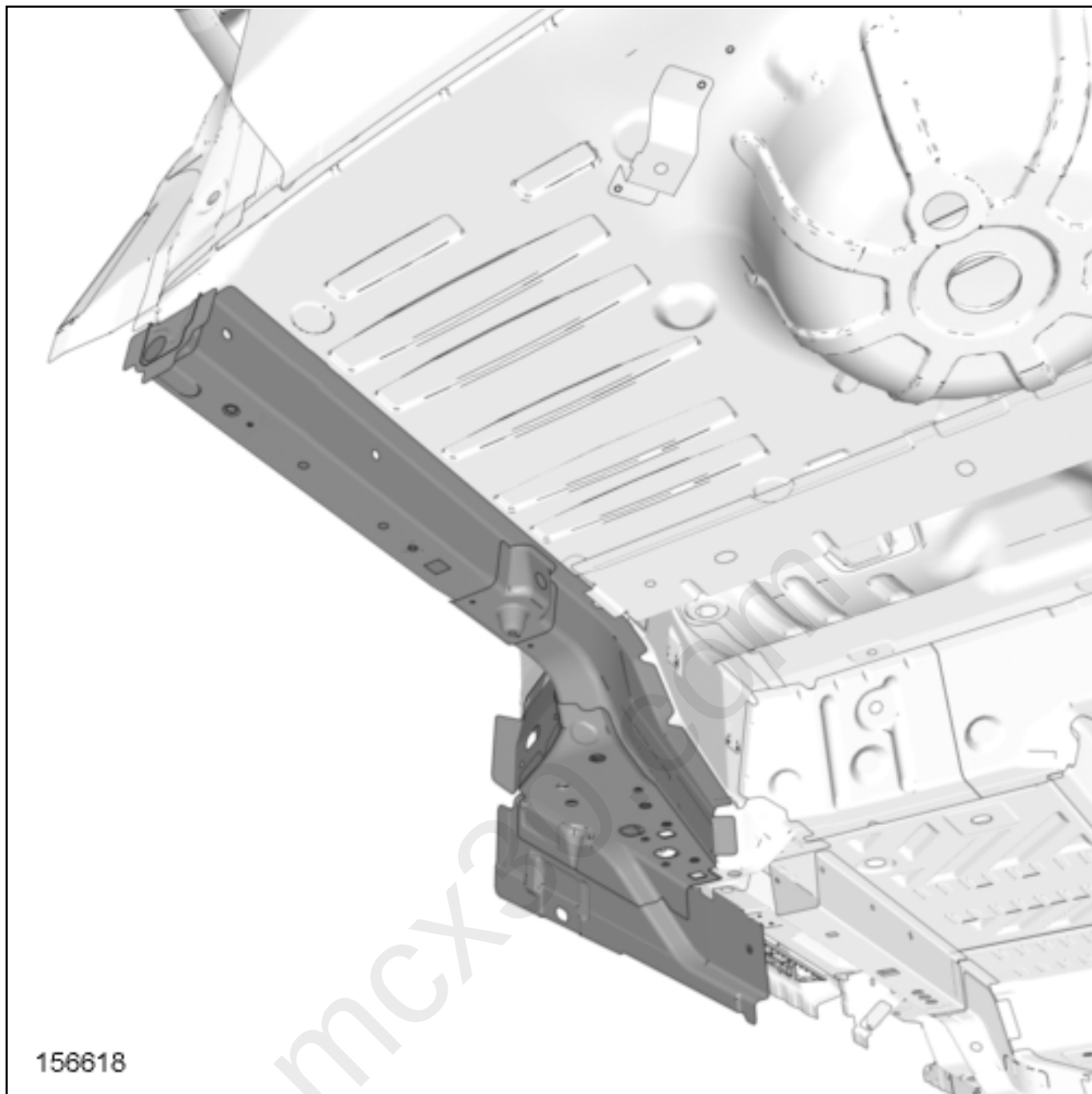
1- COMPLETE REPLACEMENT



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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