

WINDSCREEN APERTURE LOWER CROSS MEMBER: REPLACEMENT



Note, one or more warnings are present in this procedure



WARNING

DANGER: HIGH VOLTAGE VEHICLE.



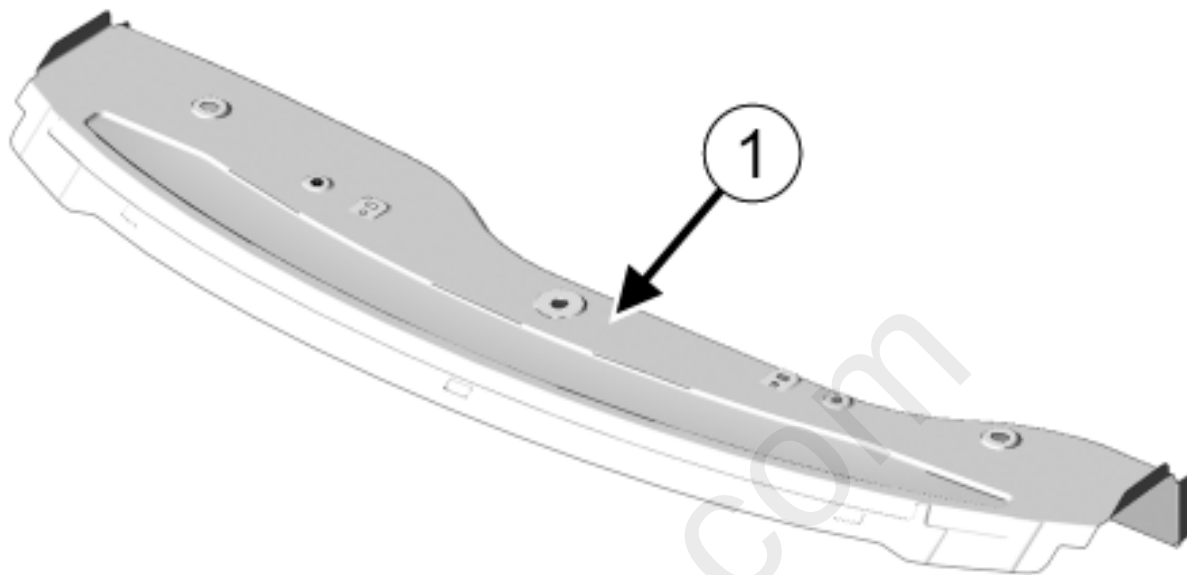
Risks of serious burns or electric shock that may prove fatal.

Before carrying out any work on the vehicle, it is essential that you adhere to the instructions regarding vehicle voltage cut-off. This work must be carried out by an employee who is qualified and authorized 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



155897

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No.	Description	Type	Thickness (mm)
(1)	Windscreen aperture cross member	Mild steel	0.65

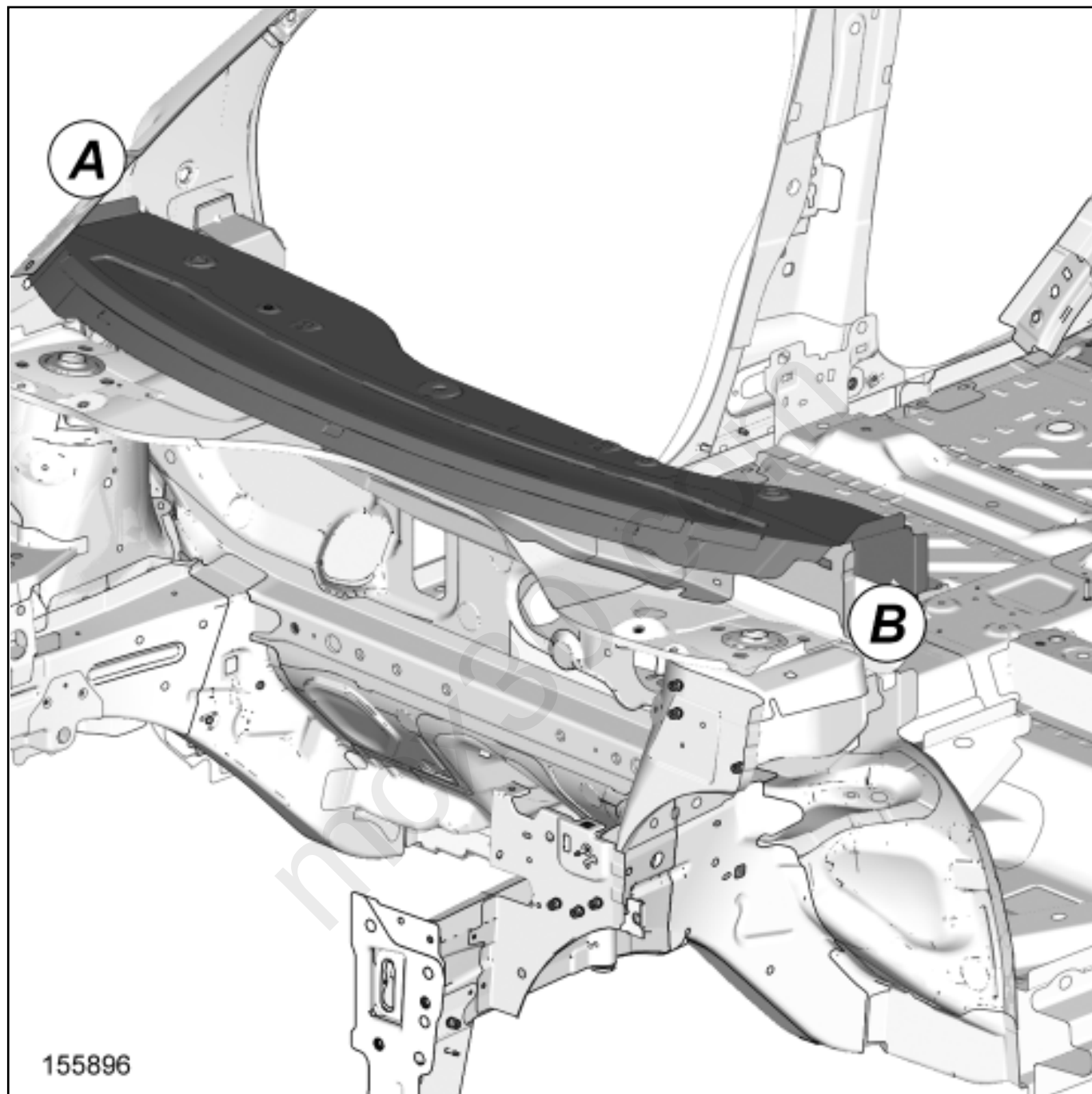
2. IN THE EVENT OF REPLACEMENT

■ There is only one way of replacing this part:

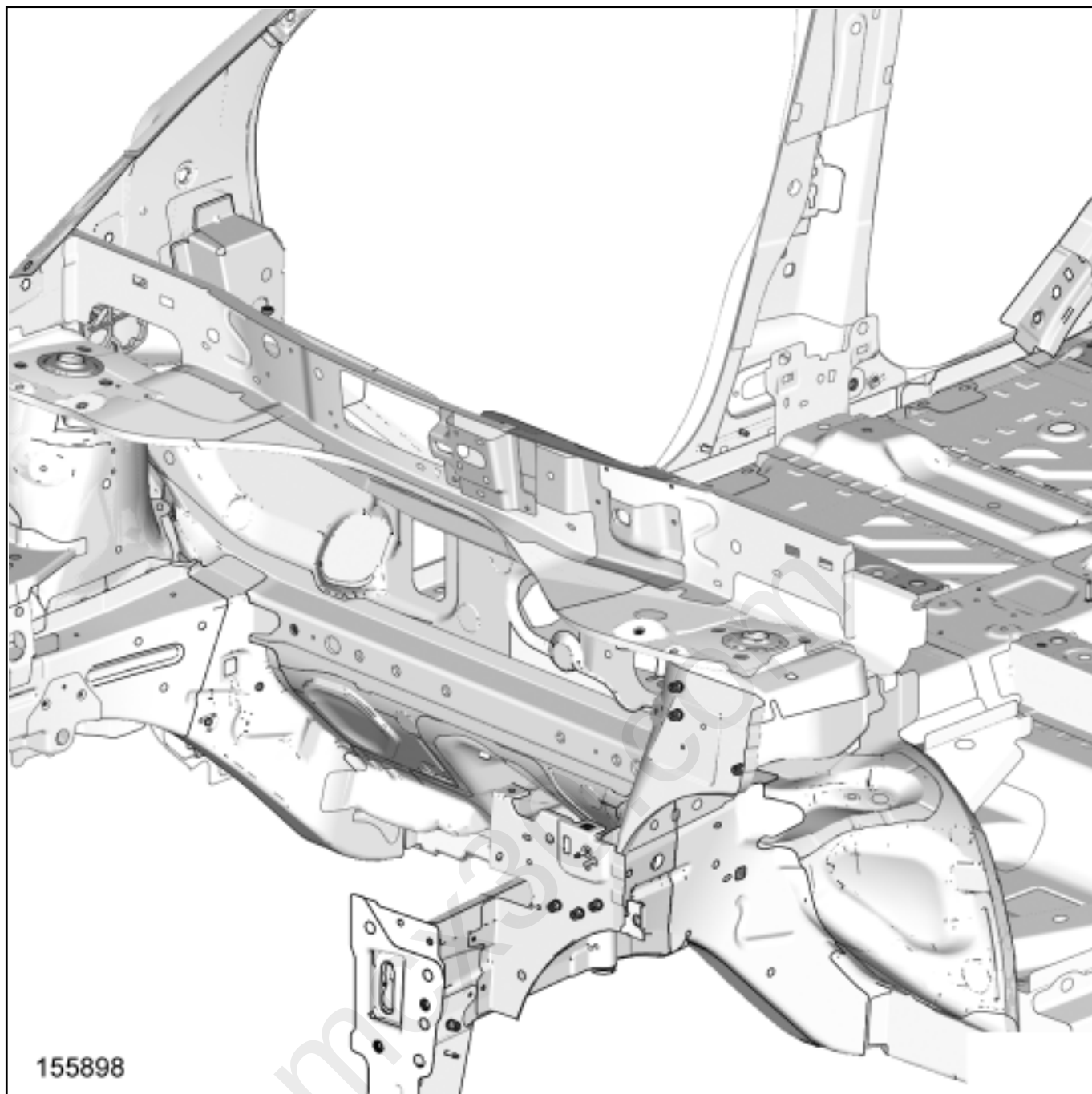
■ complete replacement A-B.

1- COMPLETE REPLACEMENT A-B

1)PART IN POSITION



DETAILED VIEW WITHOUT PART



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)).



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