



## TWINGO

Type

S/Section

X06

X

41

41

ADAPTING A BODYSHELL SUPPLIED BY THE PARTS DEPARTMENT FOR A PHASE 1  
TYPE VEHICLE

44

*Other sub-section concerned :*

Basic manual :

M.R. 306

For reasons of standardisation, the Parts Department will supply phase 2 Twingo bodys-hells for phase 1 Twingo vehicles.

As a result, the following adaptations will be required:

## BODYWORK OPERATIONS INCLUDING WELDING AND ANTICORROSION PROTECTION

- Front lashing hook Part No. : 77 50 815 216
- Rear right-hand bumper shield mounting Part No. : 77 51 669 823
- Rear left-hand bumper shield mounting Part No. : 77 51 669 822
- Coil bracket Part No. : 77 50 820 988 (for C3G engines only)
- Rear lashing hook Part No. : 77 50 814 915

## ADAPTATION WORK NOT INVOLVING WELDING

- Specific strut Part No. : 77 00 426 738 (for C3G engines only)
- Sealing plug for screen washer \* Part No. : 77 00 794 309
- Screen washer sealing plug base \* Part No. : 77 00 794 310
- Door striker plate (two) \* Part No. : 77 00 423 922
- Clip for dashboard cowl \* Part No. : 77 03 081 205

\* No specific method required

Below you will find the instructions for the operations which need to be carried out before painting.

**NOTE:** Once the lashing hooks have been welded and the rear bumper shield mounted, it is essential to protect the box sections.

Time allowed for these operations: 2.5 hours

Code : 4087

"The repair methods given by the manufacturer in this document are based on the technical specifications current when it was prepared.

The methods may be modified as a result of changes by the manufacturer in the production of the various component units and accessories from which his vehicles are constructed".

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# LOWER STRUCTURE

## Side member closing panel

41 A

### REMINDER OF TECHNICAL NOTE 463A

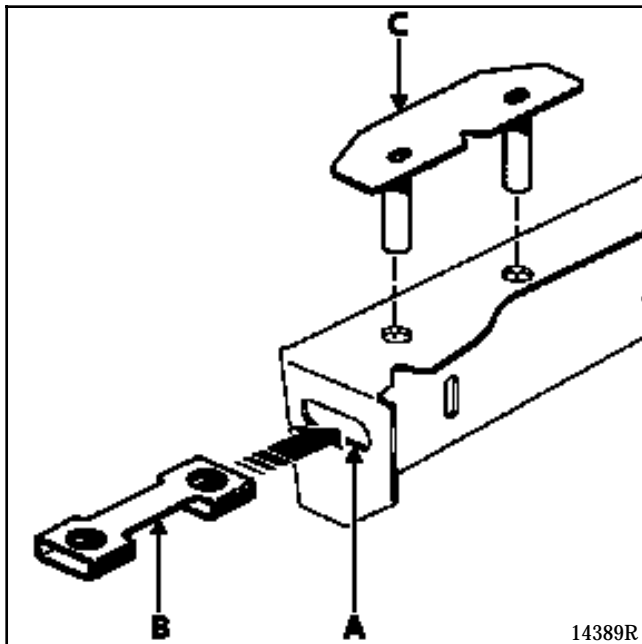
For reasons of standardisation, the Parts Department is only supplying bodyshells or side members for engine types D7F.

As a result, when replacing a bodyshell or side member for a C3G engine it will be necessary to order the following items in addition:

- a specific strut **Part No. : 77 00 426 738**
- a coil bracket **Part No. : 77 50 820 988**

You will find the instructions for these operations below.

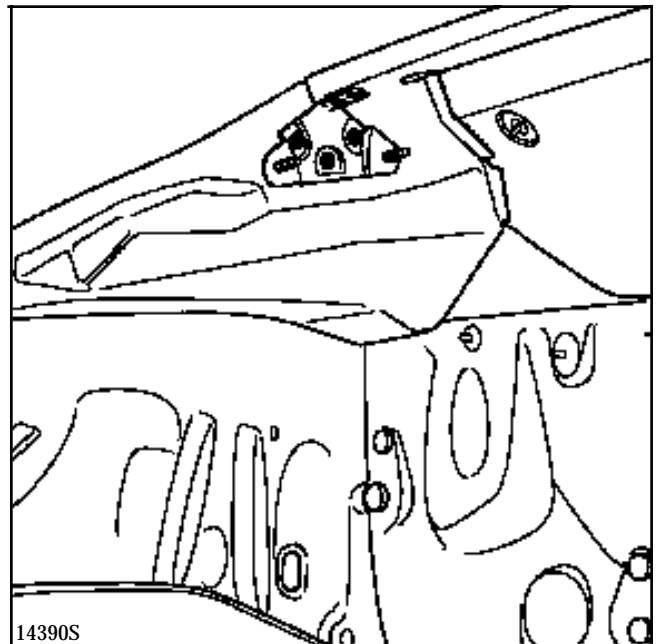
### ENGINE STRUT MOUNTING



Insert the lower plate (B) through the opening (A) in the side member closing panel.

Position the upper plate (C) in the holes (28 mm dia.) on the upper section of the closing panel.

### COIL BRACKET

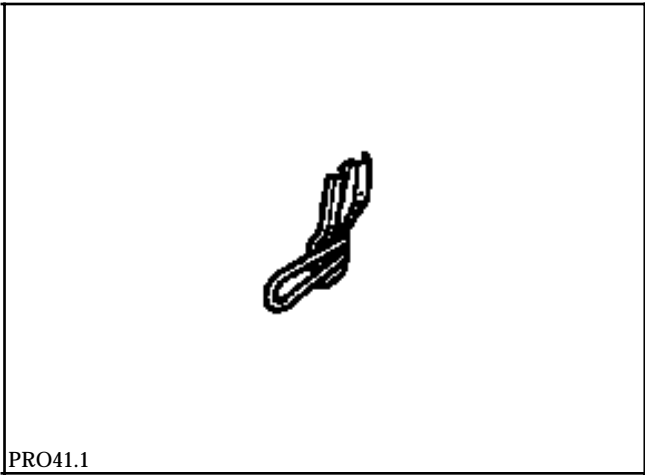


**INTRODUCTION**

The lashing ring is on the left of the Phase 1 Twingo. The existing ring on the on the bodyshell supplied by the Parts Department (which is on the right) must be unpicked and the Phase 1 ring welded on.

**COMPOSITION OF PART FROM PARTS DEPT.**

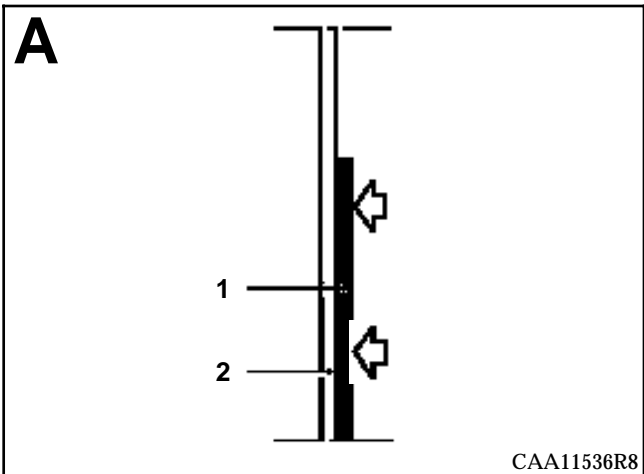
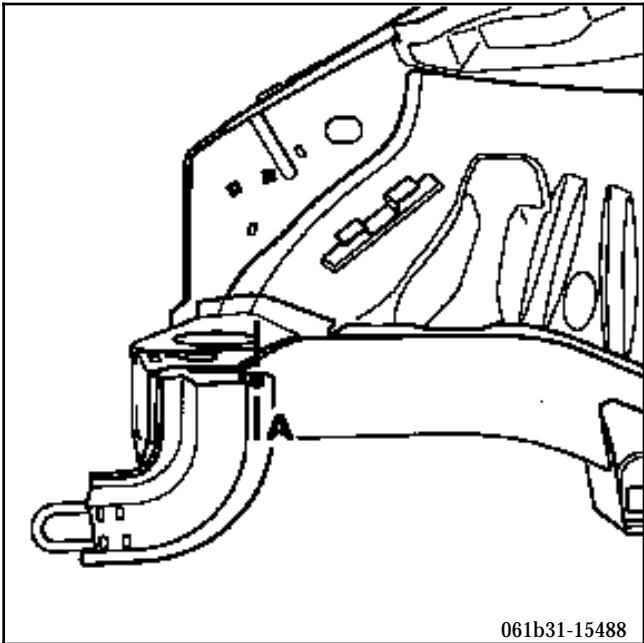
Part only.



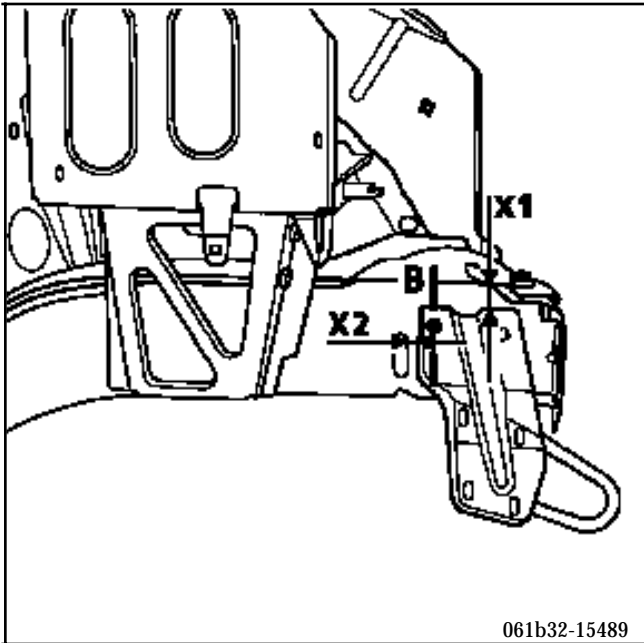
**RELEVANT PARTS (thickness in mm) :**

- |   |                      |     |
|---|----------------------|-----|
| 1 | Lashing ring support | 2   |
| 2 | Side member          | 1.2 |

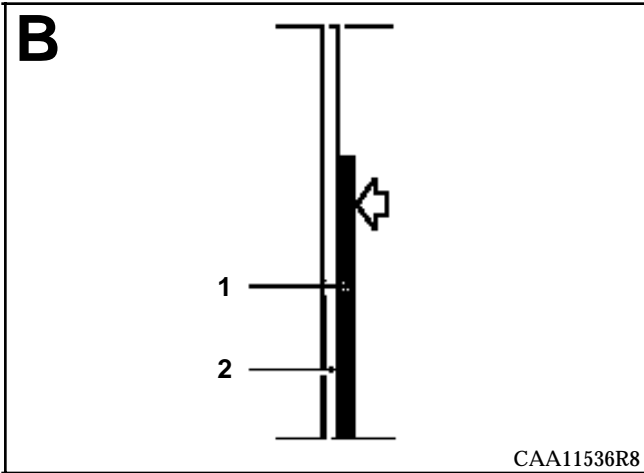
UNPICKING



FITTING



X1 = 17 mm  
X2 = 10 mm

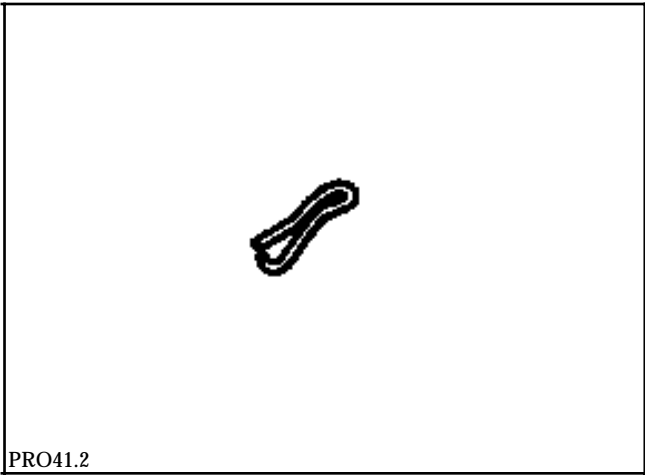


**INTRODUCTION**

As the lashing ring is different on the Phase 1 Twingo, the existing ring on the bodyshell supplied by the Parts Dept. (on the right) must be unpicked and the Phase 1 ring welded on.

**COMPOSITION OF PART FROM PARTS DEPT.**

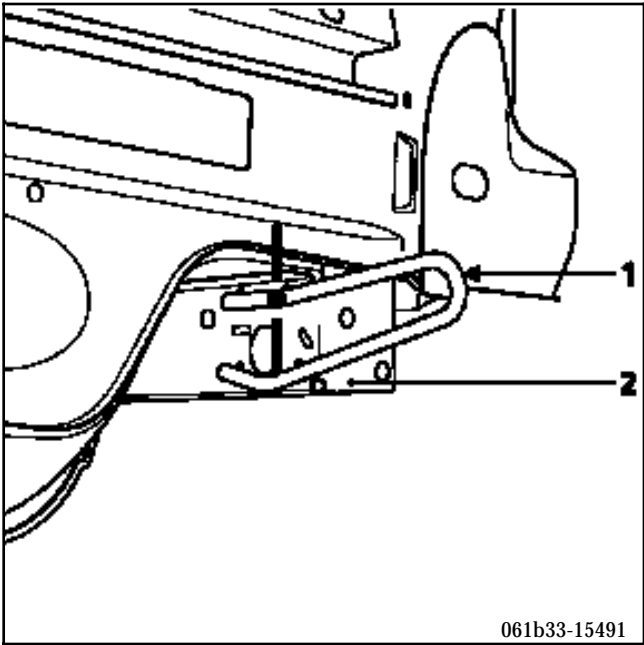
Part only.



**PARTS INVOLVED (thickness in mm) :**

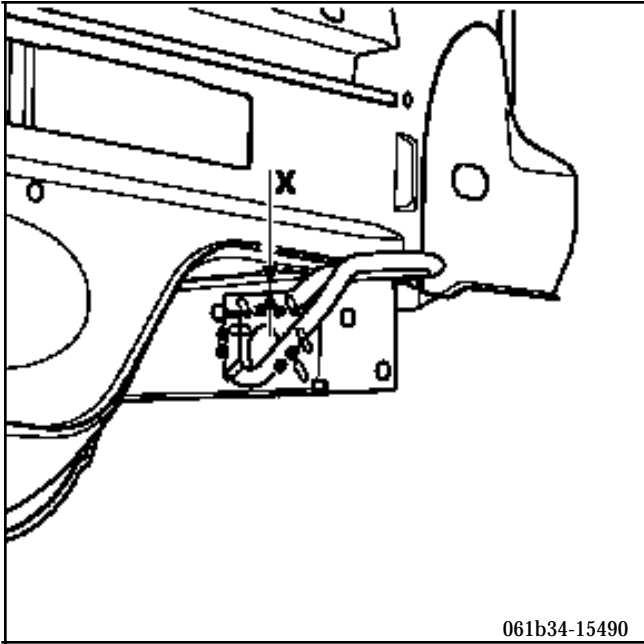
- |   |              |           |
|---|--------------|-----------|
| 1 | Lashing ring | 8 mm dia. |
| 2 | Side member  | 1.8       |

UNPICKING



FITTING

Fit the lashing ring in its place, positioning it on the six bosses.



X = 10 mm



INTRODUCTION

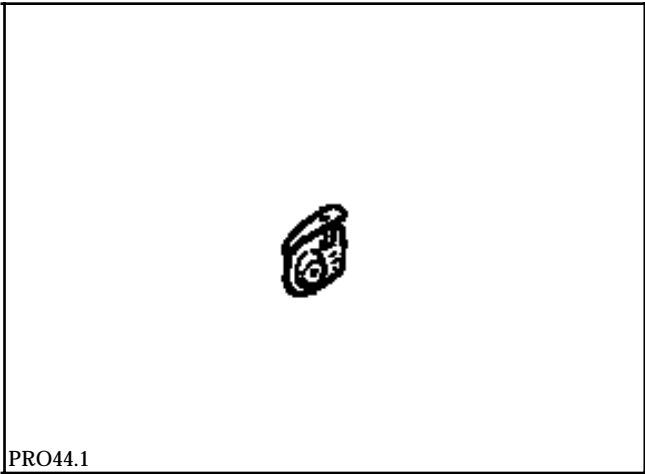
As the side bumper shield mountings are different on the Phase 1 Twingo, it will be necessary to unpick these from the bodyshell supplied by the Parts Department and weld the mountings for the Phase 1 vehicle in their place.

LIST OF PARTS THAT WILL NEED TO BE ORDERED :

- Left-hand side mounting      **Part No.: 77 51 669 822**
- Right-hand side mounting    **Part No.: 77 51 669 823**

COMPOSITION OF PART FROM PARTS DEPT.

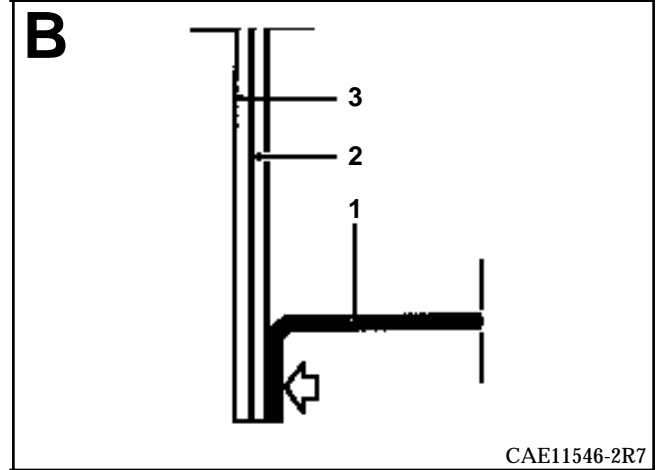
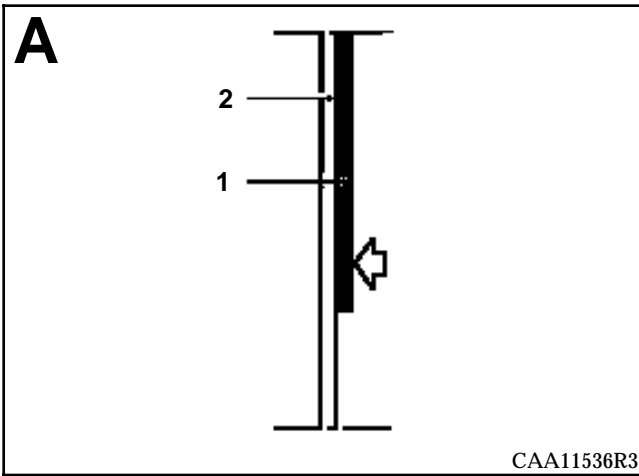
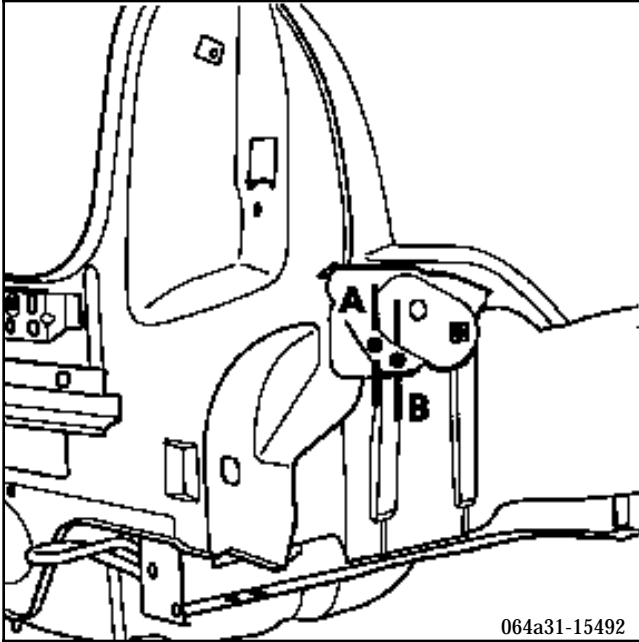
Part only.



PARTS CONCERNED (thickness in mm) :

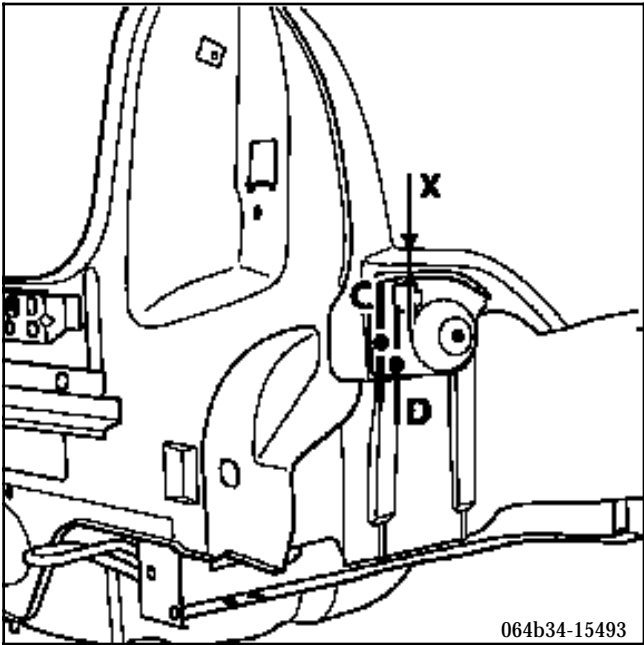
- |   |                             |     |
|---|-----------------------------|-----|
| 1 | Side bumper shield mounting | 1.5 |
| 2 | Wing panel                  | 0.7 |
| 3 | Rear quarter closing panel  | 0.8 |

UNPICKING





FITTING



X = 19 mm

