

RENAULT

4 Panelwork

40A GENERAL INFORMATION

41A FRONT LOWER STRUCTURE

41B CENTRE LOWER STRUCTURE

41C SIDE LOWER STRUCTURE

41D REAR LOWER STRUCTURE

42A FRONT UPPER STRUCTURE

43A SIDE UPPER STRUCTURE

44A REAR UPPER STRUCTURE

45A TOP OF BODY

47A SIDE OPENING ELEMENTS

48A NON-SIDE OPENING ELEMENTS

X91

AUGUST 2009

EDITION ANGLAISE

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

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

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LAGUNA III - Section 4

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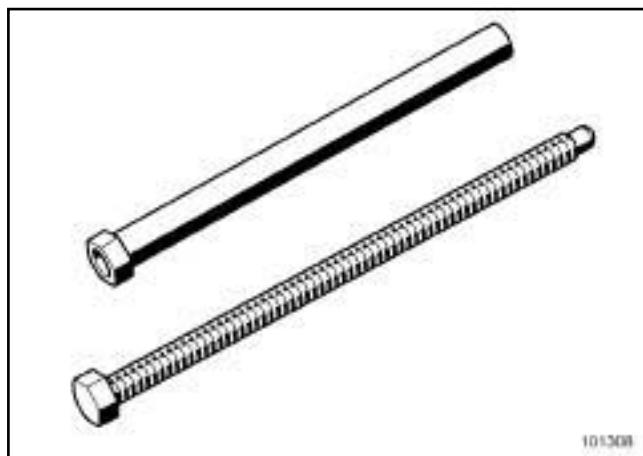
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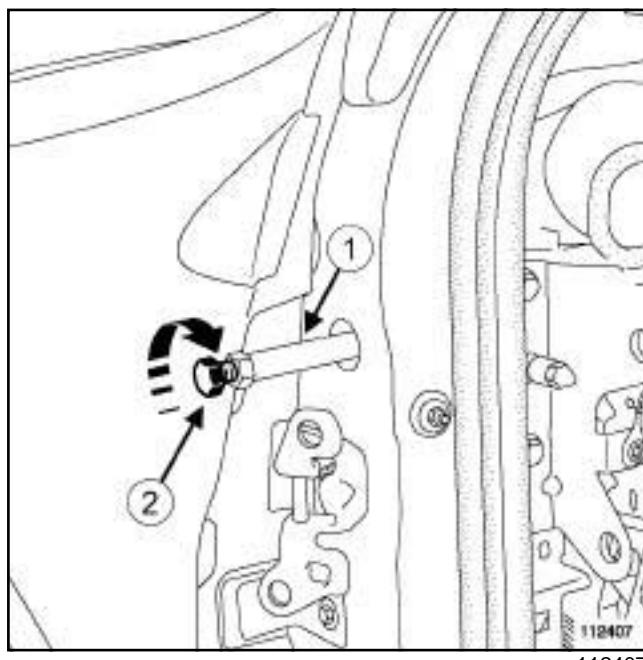
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USING TOOL Car. 1765 FOR REMOVING THE DASHBOARD CROSS MEMBER

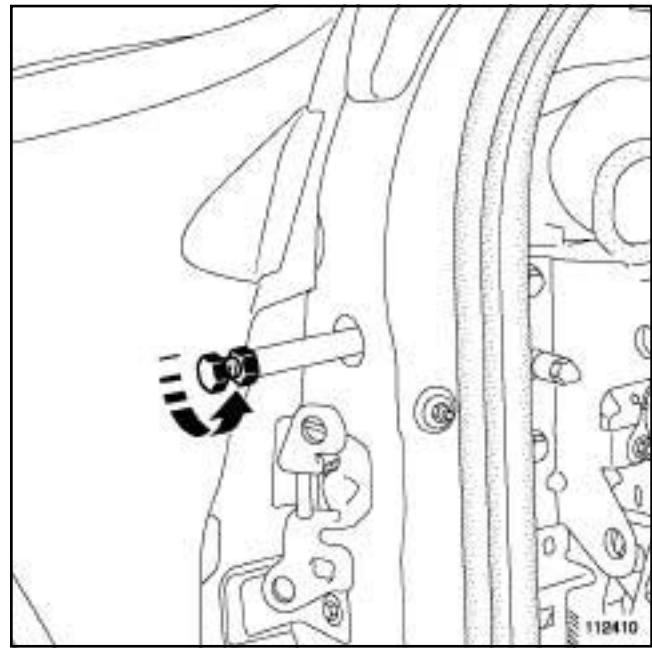


- Use this tool as indicated in the dashboard removal procedure.



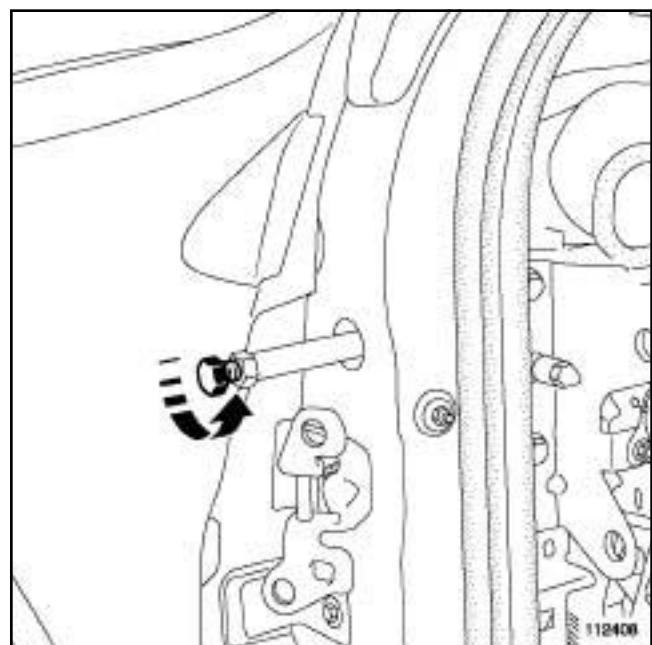
112407

- Fit the Car. 1765 as far as the stop (1).
- Screw the rod (2) onto the tool body (1) as far as the stop.
- Firmly lock tool body in the same way as a lock nut against the dashboard cross member nut while holding hexagon bolt.



112410

- Unscrew the whole tool as far as the stop and tighten it gently (during this operation, the beam nut, which has a left-hand thread, screws into the beam and disengages it from the A-pillar).



112408

- Hold the tool body (1) and unlock the rod (2).
- Unscrew dashboard cross member rod to remove the tool.

WARNING

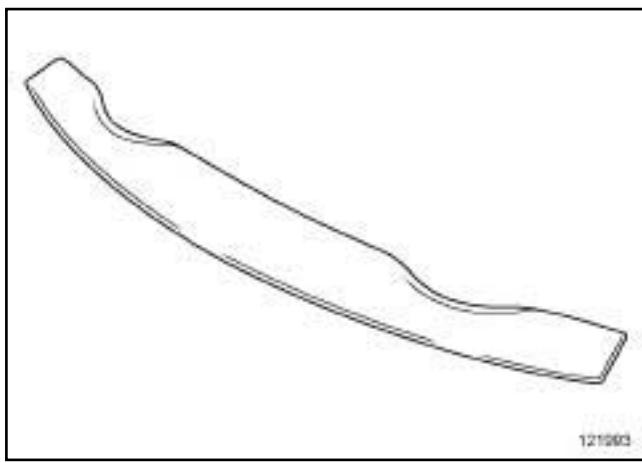
To maintain the adjustment of the dashboard cross member and make refitting easier, undo the lock nut or the index on one side.

GENERAL INFORMATION

Specialised bodywork tools: Use

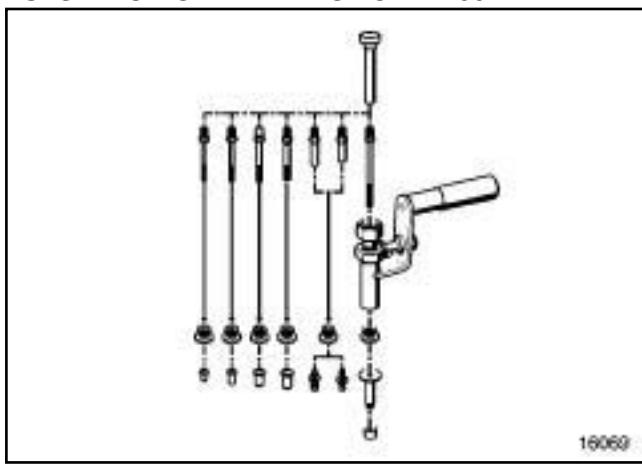
40A

USING THE Car. 1819 DASHBOARD PROTECTION TOOL



- Use this tool when replacing the windscreen:
 - remove the windscreen pillar trims,
 - position the protector to prevent damaging the dashboard.

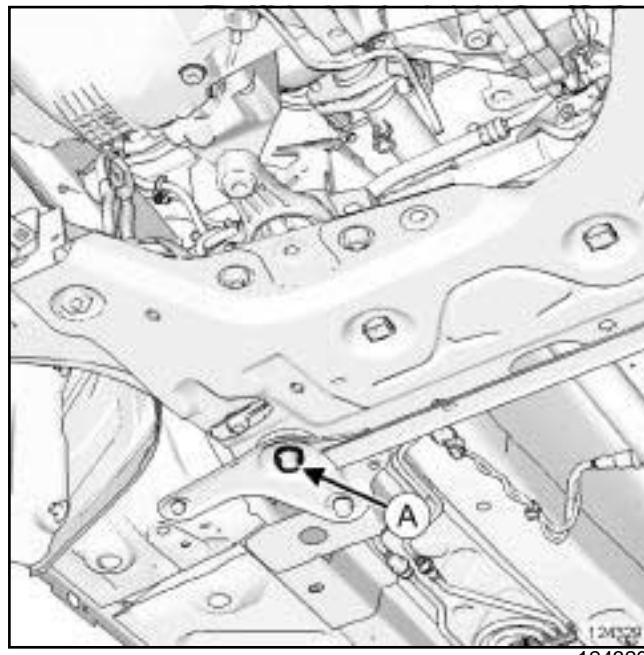
USING THE TOOL FOR FITTING CRIMPED TYPE NUTS INTO BODY PANELS - CAR. 1504



- To use the tool for fitting crimped type nuts into body panels **Car. 1504**, see **MR 400**.

I - MAIN REFERENCE POINTS BEFORE TRIM-SETTING

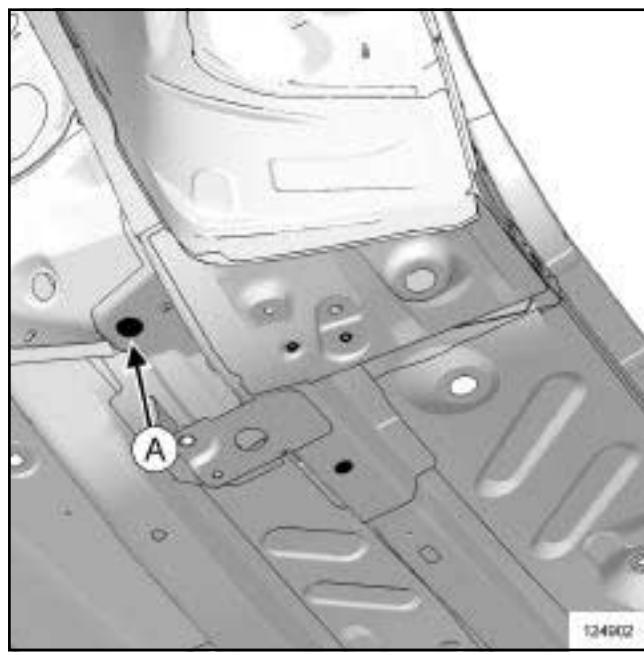
1 - Front mechanical components in place



The jig covers the rear bolt of the front subframe (A) .

Use this situation for a rear impact or a light frontal impact without removal of the mechanical components.

2 - Front mechanical components removed



The jig rests under the subframe mounting unit and is centred in the threaded hole (A) .

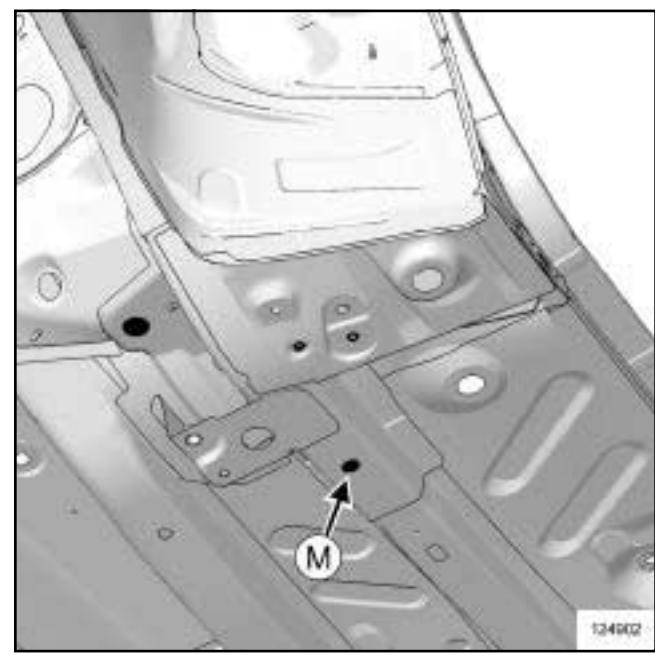
Two possible cases can arise:

- if the rear of the vehicle is being rebuilt, these two points alone may be used to align and support the front of the vehicle.
- for a light frontal impact not requiring removal of the front axle sub-frame.

Note:

If it is suspected that one of these points may be deformed, use two additional points located in an area not affected by the impact in order to confirm trim-setting.

II - SECONDARY FRONT TRIM-SETTING REFERENCE POINT

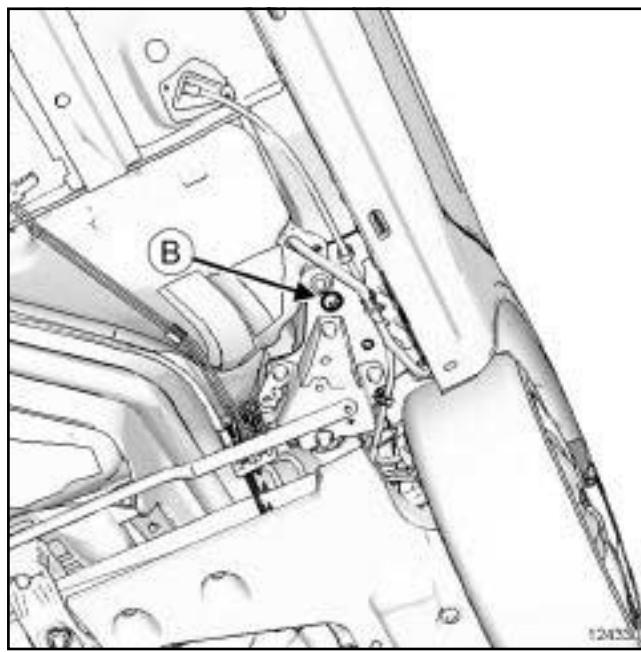


The jig rests under the front side member, centre section and is centred on the hole (M) .

Use this situation for a major front impact requiring replacement of the front subframe rear mounting unit.

III - MAIN REAR TRIM-SETTING REFERENCE POINTS

1 - Rear mechanical components in place

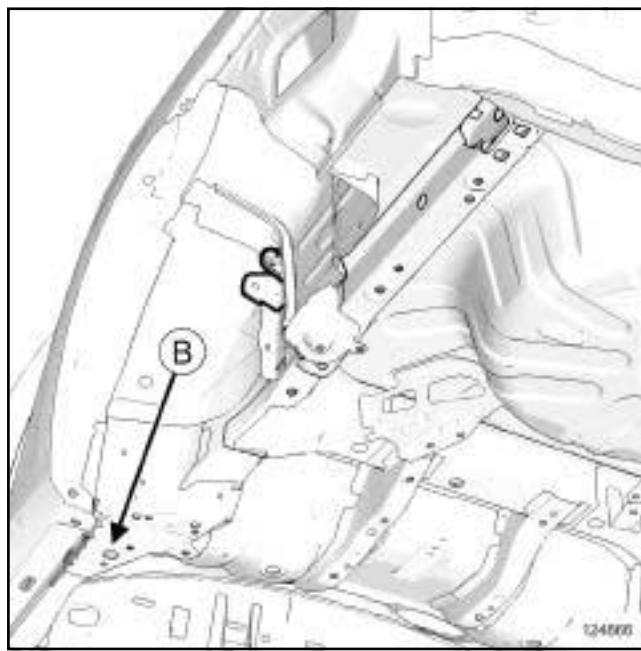


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The jig rests under the rear axle fork and is centred on the rear axle assembly pilot hole (B) .

Use this situation for a frontal impact or a light rear impact.

2 - Rear mechanical components removed



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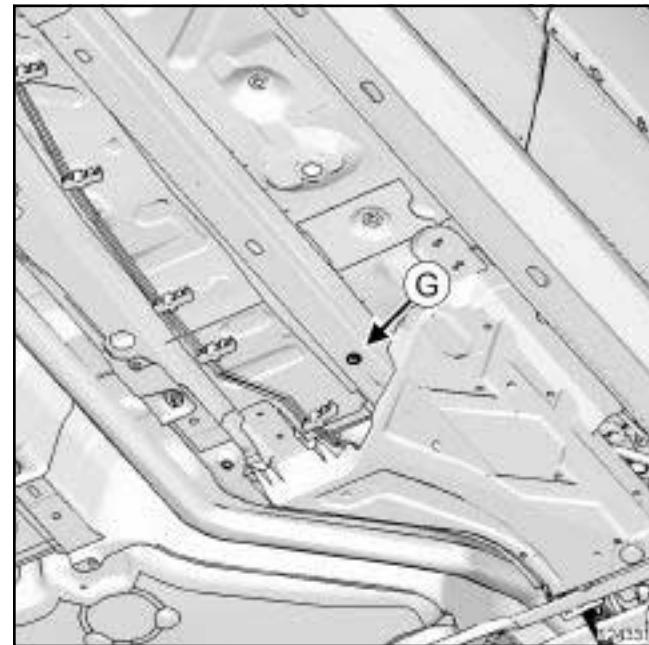
The jig supports the underneath of the rear axle assembly mounting unit and is centred on the pilot hole (B) .

Use this situation for a rear impact with removal of the mechanical components.

Note:

If it is suspected that one of these points may be deformed, use two additional points located in an area not affected by the impact in order to confirm trim-setting.

IV - SECONDARY REAR TRIM-SETTING REFERENCE POINT



124331

The jig rests under the front side member rear section and is positioned in the hole (G) .

Use for a major rear impact when replacing the rear side member assembly.

It is used to confirm the vehicle level in case of doubt about the deformation of a main rear reference point.

GENERAL INFORMATION

Subframe: Specifications

40A

B91 or K91

	Description	Dimen-sion X (mm)	Dimen-sion Y (mm)	Dimen-sion Z (mm)	Diameter (mm)	Angle (°)
(Ag)	Front left-hand subframe rear mounting without mechanical components	384.5	337	61.17	Ø 26.8 / M14	
(Ad)	Front right-hand subframe rear mounting without mechanical components	384.5	337	61.17	Ø 26.8 x 30.4 / M14	
(A)	Front sub-frame rear mounting with mechanical components	384.5	337	-15.3	H 21 bolt	
(B1)	Rear axle guide	2168.5	647.31	61.4	Ø 30	
(B2)	Rear axle assembly front mounting	2431.5	555	60	Ø 14.5 / M10	
(C)	Front subframe front mounting (hole)	92.5	426	243	Ø 18.5	4°
(C1)	Front subframe front mounting (lug)	65.5	417	247	Ø 8	4°
(C2)	Front subframe front mounting (lug)	117	410.5	247	Ø 8	4°
(E1)	Rear shock absorber front upper mounting	2584	566.7	450.54	12	
(E2)	Rear shock absorber rear upper mounting	2655.2	566.7	455.5	Ø 14.5	
(F)	Front shock absorber upper mounting	52.89	589.47	676.41	Ø 42.6	
(F1)	Front shock absorber upper stop	-1.22	533.69	676.37	10.2 x 20.2	
(F2)	Front shock absorber upper stop	51.69	667.97	680.61	10.2 x 20.2	
(F3)	Front shock absorber upper stop	102.72	533.67	666.25	10.2 x 20.2	
(G)	Front side member rear leader pin	1650	443.5	-22	Ø 20	
(H)	Front side member front leader pin	-620	498	260	20 x 20	
(J)	Rear side member rear leader pin	3298	478	224	20 x 20	
(K)	Front panel attachment leader pin	-640	564	260	Ø 14.5 / M10	
(K1)	Front panel mounting on side member	-603	431	432	M10	
(K3)	Frontal impact cross member left-hand exterior mounting	--592.16	-620.7	370.2	M10	4°
(K4)	Frontal impact cross member left-hand interior mounting	-700	-518	238	M10	4°
(K3)	Frontal impact cross member right-hand exterior mounting	-592.16	620.7	370.2	M10	4°

GENERAL INFORMATION

Subframe: Specifications

40A

	Description	Dimen-sion X (mm)	Dimen-sion Y (mm)	Dimen-sion Z (mm)	Diameter (mm)	Angle (°)
(K4)	Frontal impact cross member right-hand interior mounting	-700	-518	238	M10	4°
(L)	Rear end cross member (end panel) Hatch	3405.86	390	235	Ø 20	
(L)	Rear end cross member (end panel) Estate	3563	436	179	Ø 15	
(M)	Leader pin under centre floor	640	443.5	-23.5	16.2 x 20.2	
(P1)	Engine mounting	-283	519	502	M10	
(P2)	Engine mounting	-115	497	502	M10	
(Q1)	Gearbox mounting	-296.8	-467.7	314.66	M12	4°
(Q2)	Gearbox mounting	-114.83	-453	320	M12	4°
(R)	Additional engine mounting (tie-rod)	35	453	583	Ø 14.5 / M12	

D91

	Description	Dimen-sion X (mm)	Dimen-sion Y (mm)	Dimen-sion Z (mm)	Diameter (mm)	Angle (°)
(Ag)	Front left-hand subframe rear mounting without mechanical components	384.5	337	61.17	Ø 26.8 / M14	
(Ad)	Front right-hand subframe rear mounting without mechanical components	384.5	337	61.17	Ø 26.8 x 30.4 / M14	
(A)	Front sub-frame rear mounting with mechanical components	384.5	337	-15.3	H 21 bolt	
(B1)	Rear axle guide	2108.5	647.31	61.4	Ø 30	
(B2)	Rear axle assembly front mounting	2371.5	555	60	Ø 14.5 / M10	
(C)	Front subframe front mounting (hole)	92.5	426	243	Ø 18.5	4°
(C1)	Front subframe front mounting (lug)	65.5	417	247	Ø 8	4°
(C2)	Front subframe front mounting (lug)	117	410.5	247	Ø 8	4°
(E1)	Rear shock absorber front upper mounting	2524	566.7	450.54	12	
(E2)	Rear shock absorber rear upper mounting	2595.2	566.7	455.5	Ø 14.5	
(F)	Front shock absorber upper mounting	52.89	589.47	676.41	Ø 42.6	

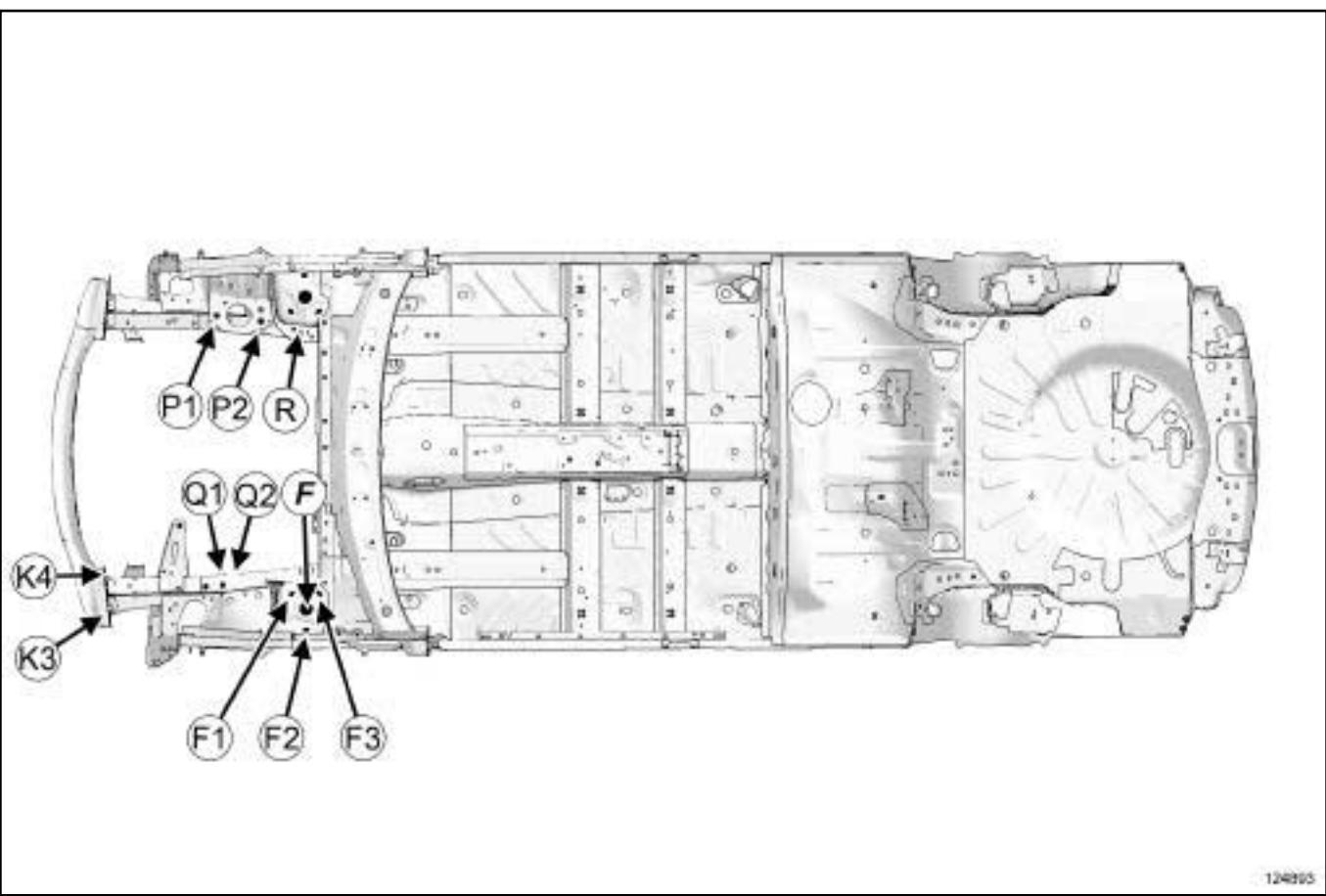
GENERAL INFORMATION
Subframe: Specifications

40A

	Description	Dimension X (mm)	Dimension Y (mm)	Dimension Z (mm)	Diameter (mm)	Angle (°)
(F1)	Front shock absorber upper stop	-1.22	533.69	676.37	10.2 x 20.2	
(F2)	Front shock absorber upper stop	51.69	667.97	680.61	10.2 x 20.2	
(F3)	Front shock absorber upper stop	102.72	533.67	666.25	10.2 x 20.2	
(G)	Front side member rear leader pin	1650	443.5	-22	Ø 20	
(H)	Front side member front leader pin	-620	498	260	20 x 20	
(J)	Rear side member rear leader pin	3238	478	224	20 x 20	
(K)	Front panel attachment leader pin	-640	564	260	Ø 14.5 / M10	
(K1)	Front panel mounting on side member	-603	431	432	M10	
(K3)	Frontal impact cross member left-hand exterior mounting	--592.16	-620.7	370.2	M10	4°
(K4)	Frontal impact cross member left-hand interior mounting	-700	-518	238	M10	4°
(K3)	Frontal impact cross member right-hand exterior mounting	-592.16	620.7	370.2	M10	4°
(K4)	Frontal impact cross member right-hand interior mounting	-700	-518	238	M10	4°
(L)	Rear end cross member (end panel) Hatch	2946	390	235	Ø 20	
(L)	Rear end cross member (end panel) Estate	3523	436	179	Ø 15	
(M)	Leader pin under centre floor	640	443.5	-23.5	16.2 x 20.2	
(P1)	Engine mounting	-283	519	502	M10	
(P2)	Engine mounting	-115	497	502	M10	
(Q1)	Gearbox mounting	-296.8	-467.7	314.66	M12	4°
(Q2)	Gearbox mounting	-114.83	-453	320	M12	4°
(R)	Additional engine mounting (tie-rod)	35	453	583	Ø 14.5 / M12	

GENERAL INFORMATION
Subframe: Specifications

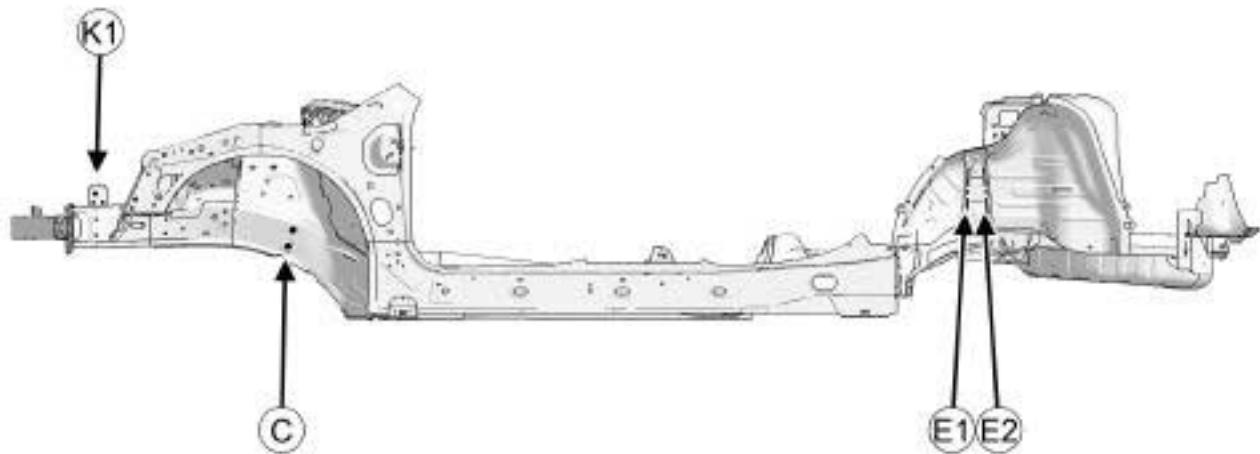
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GENERAL INFORMATION
Subframe: Specifications

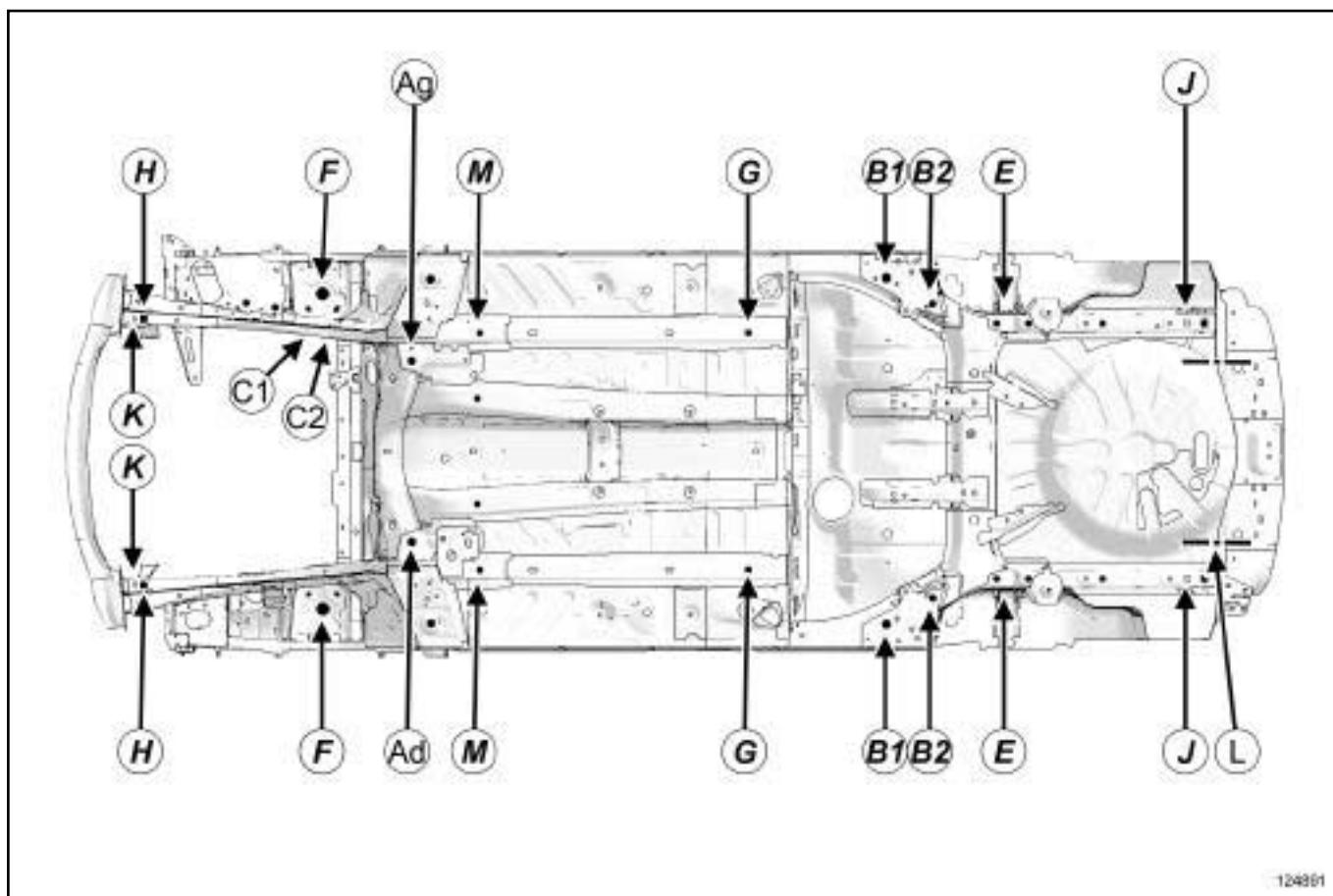
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GENERAL INFORMATION
Subframe: Specifications

40A



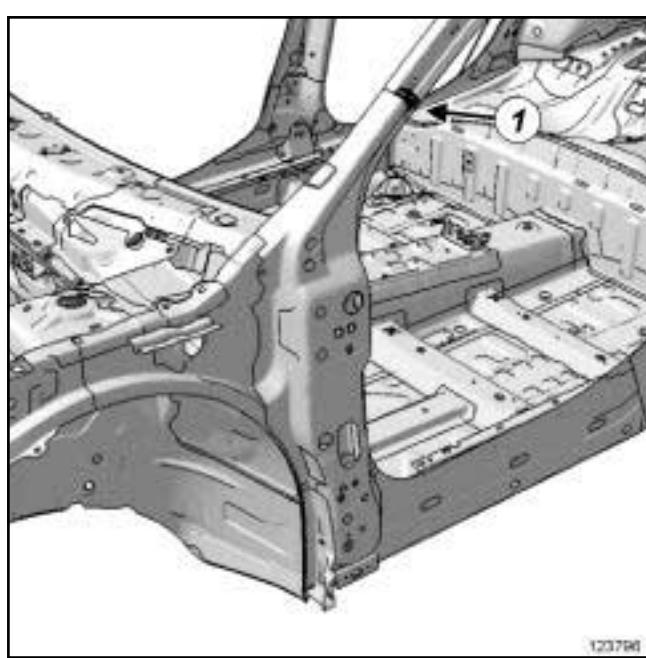
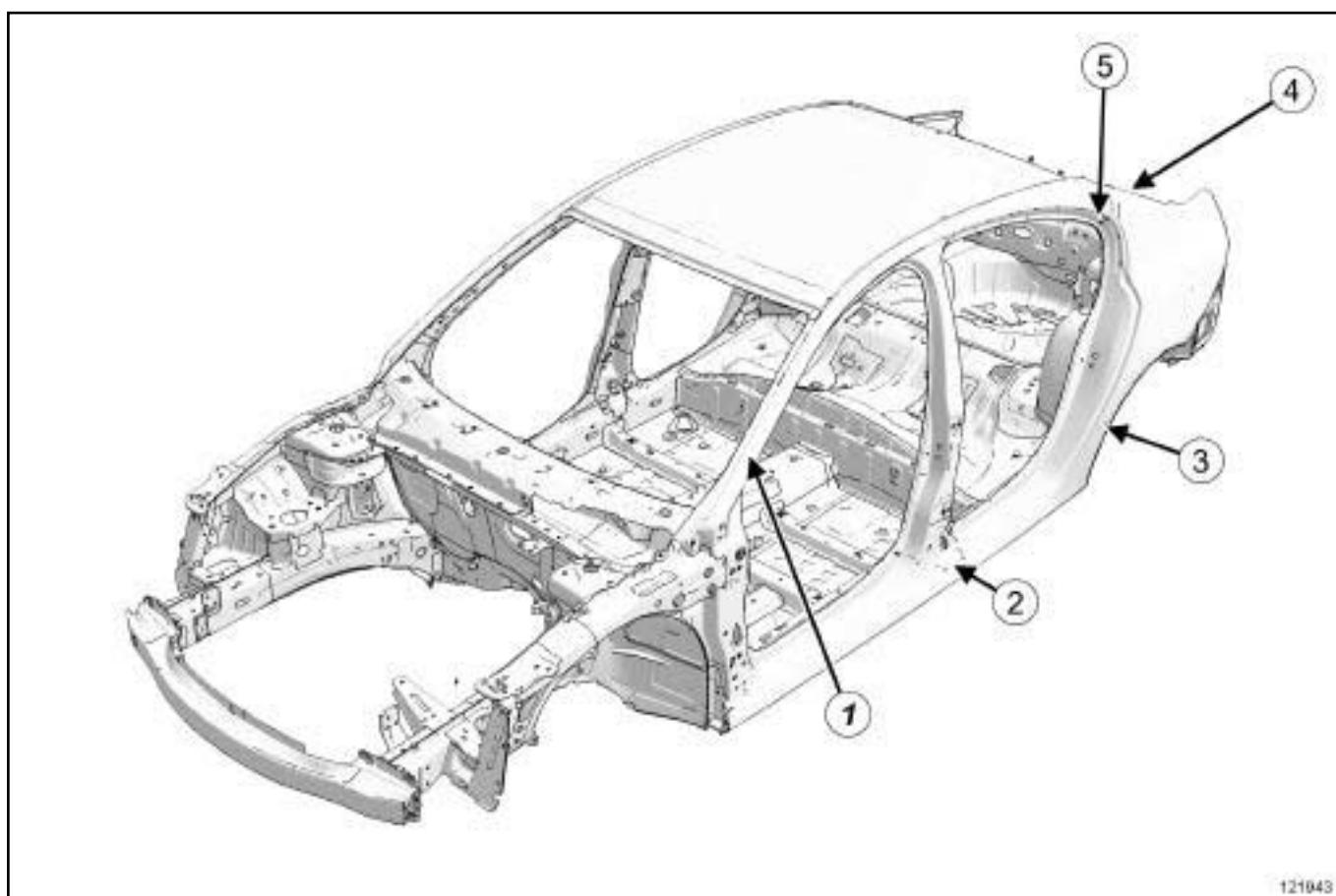
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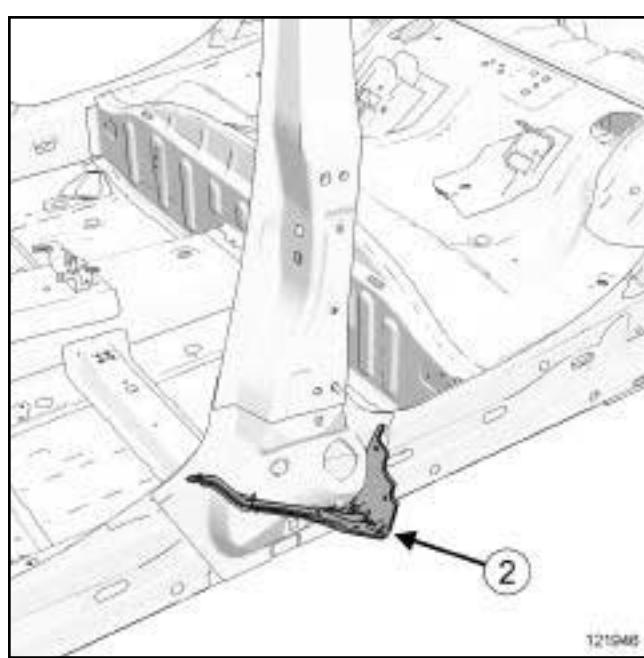
GENERAL INFORMATION

Hollow section inserts: List and location of components

40A



A-pillar insert **(1)** .

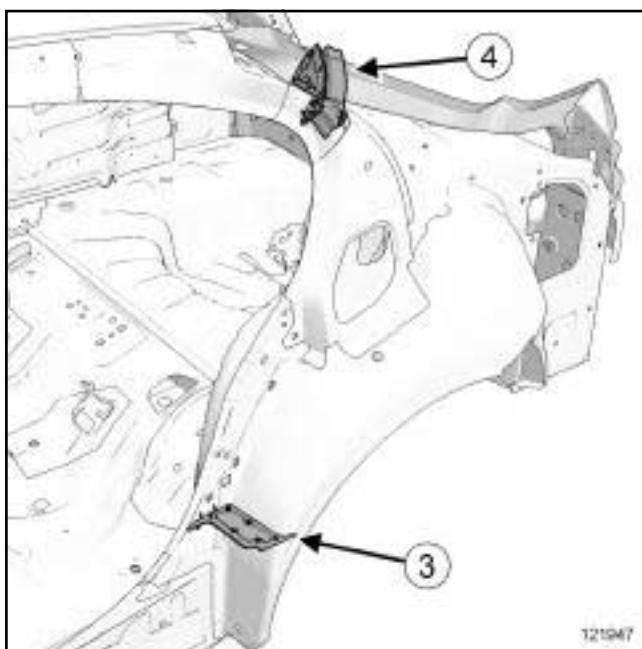


B-pillar insert **(2)** .

GENERAL INFORMATION

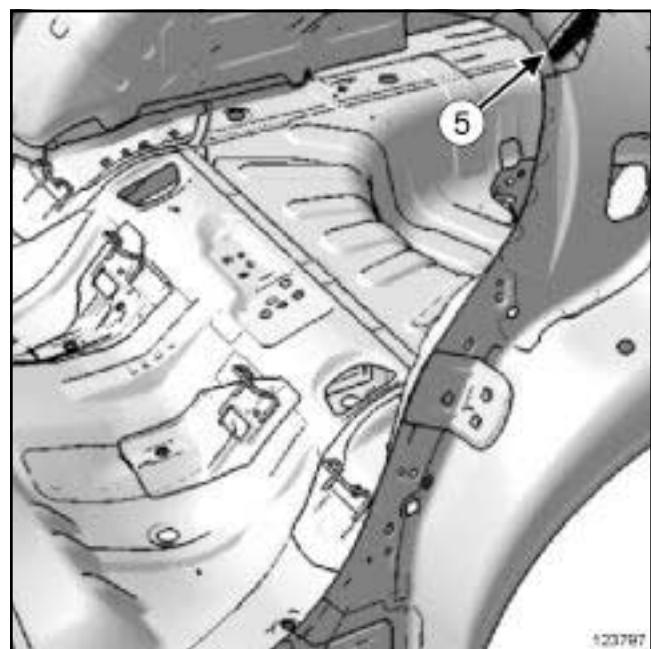
Hollow section inserts: List and location of components

40A



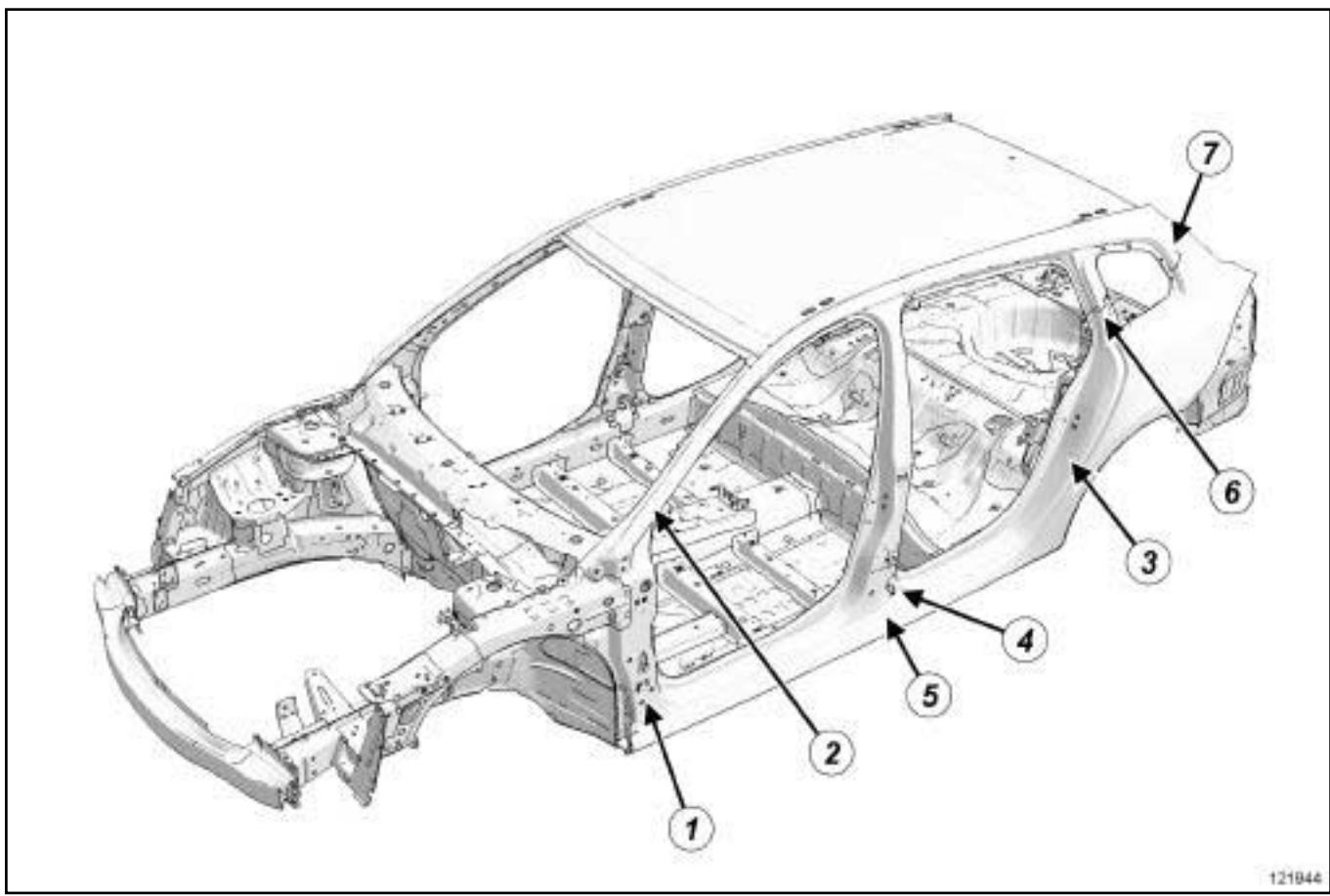
Rear wheel arch insert (3) .

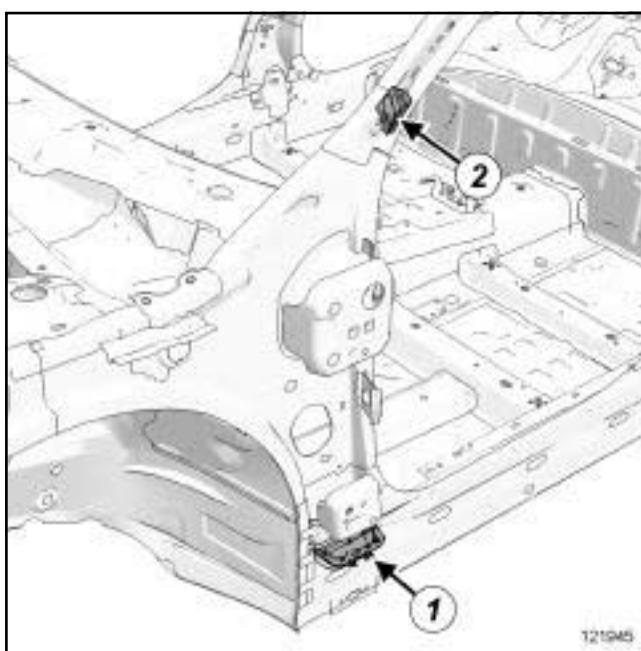
Quarter panel insert (4) .



Side roof rail lining insert (5) .

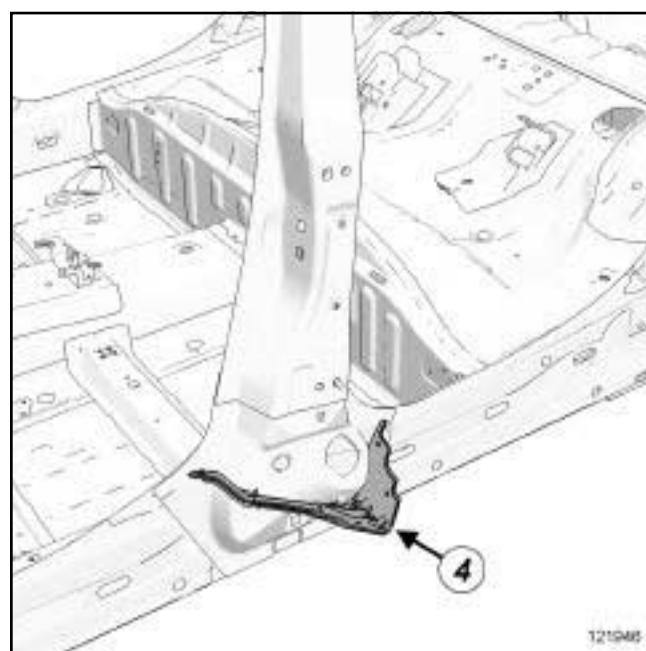
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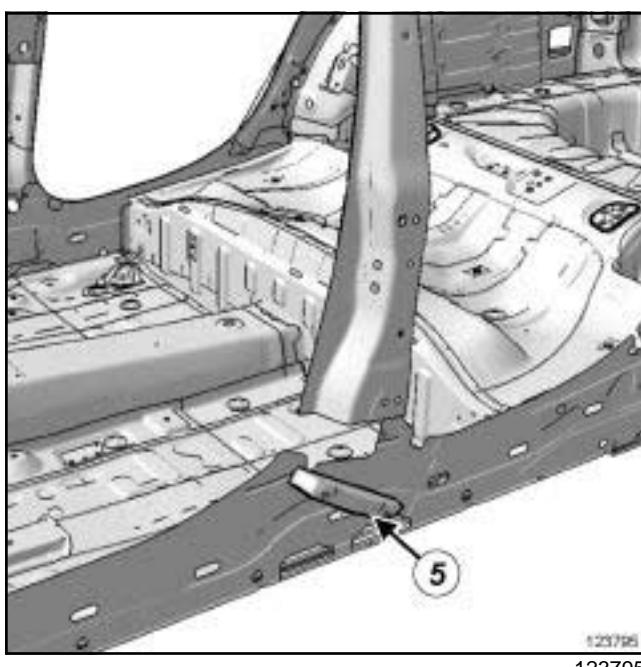


A-pillar insert (1) .

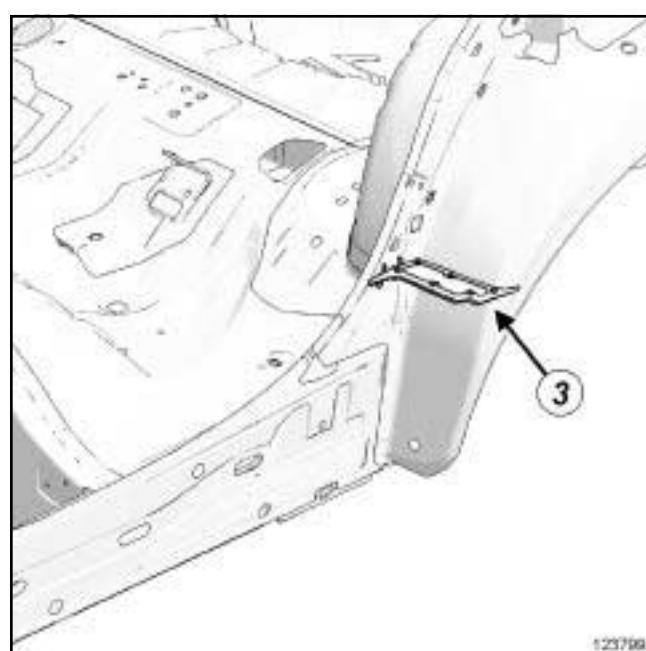
A-pillar insert (2) .



B-pillar insert (4) .



B-pillar insert (5) .

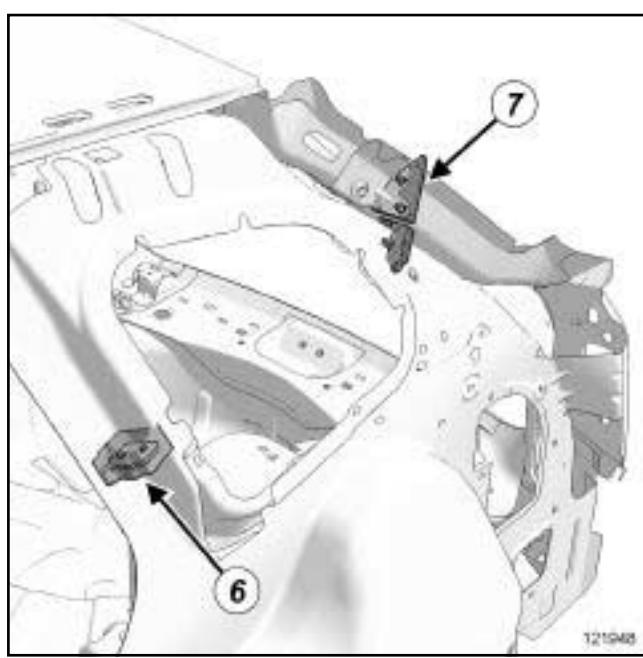


Rear wheel arch insert (3) .

GENERAL INFORMATION

Hollow section inserts: List and location of components

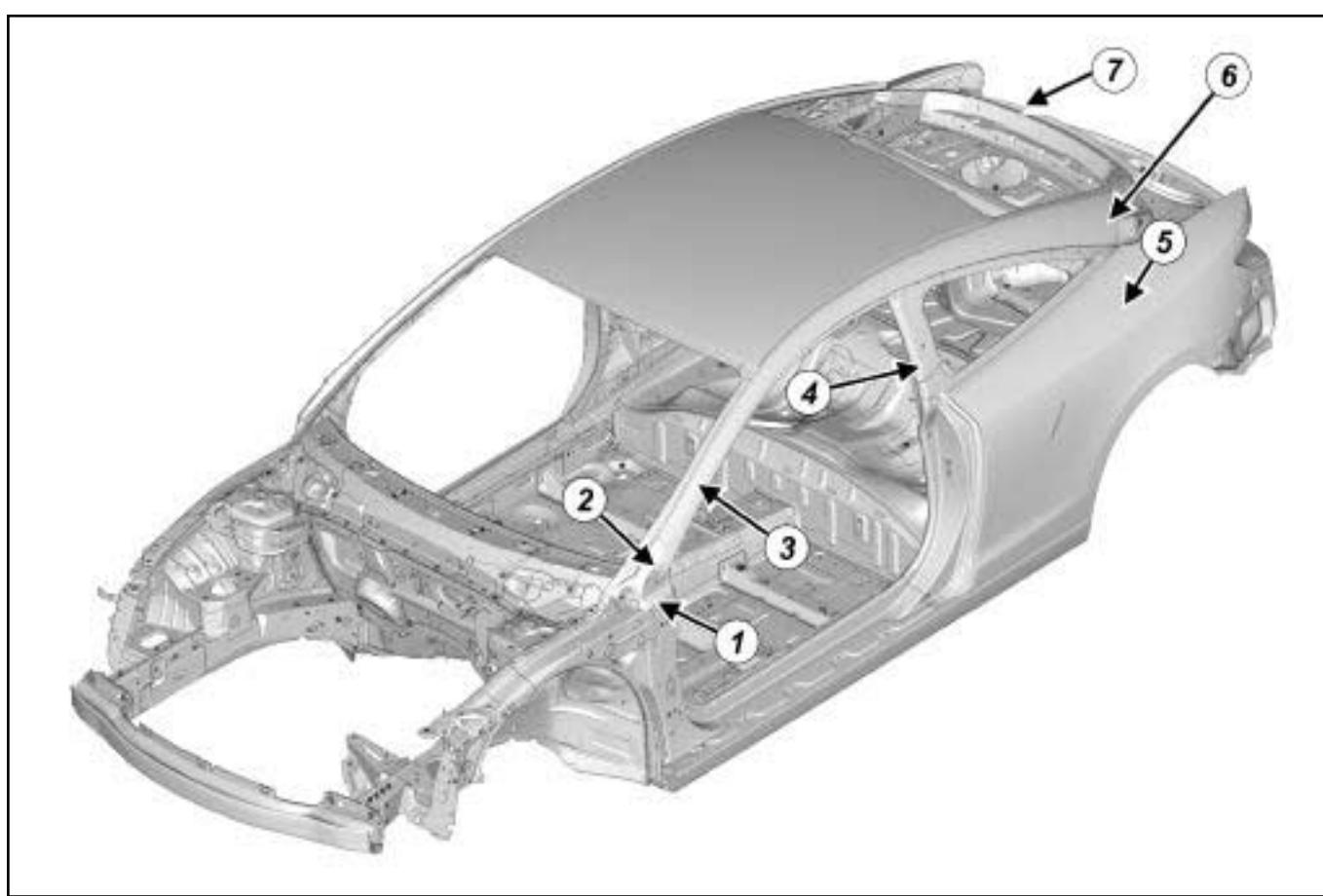
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Quarter panel rear insert (7) .

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Quarter panel front insert (6) .

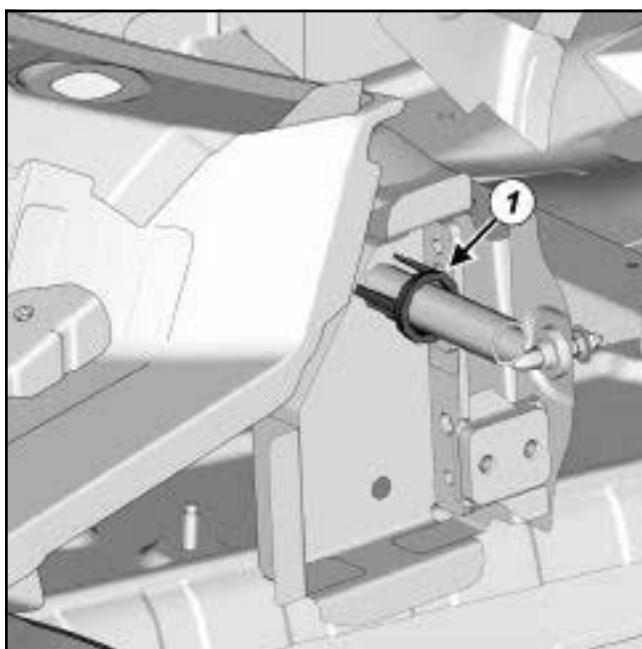


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GENERAL INFORMATION

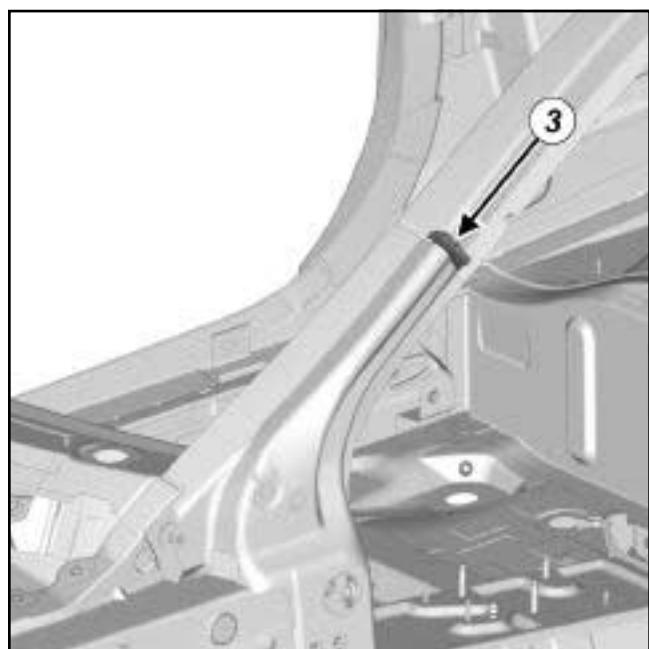
Hollow section inserts: List and location of components

40A



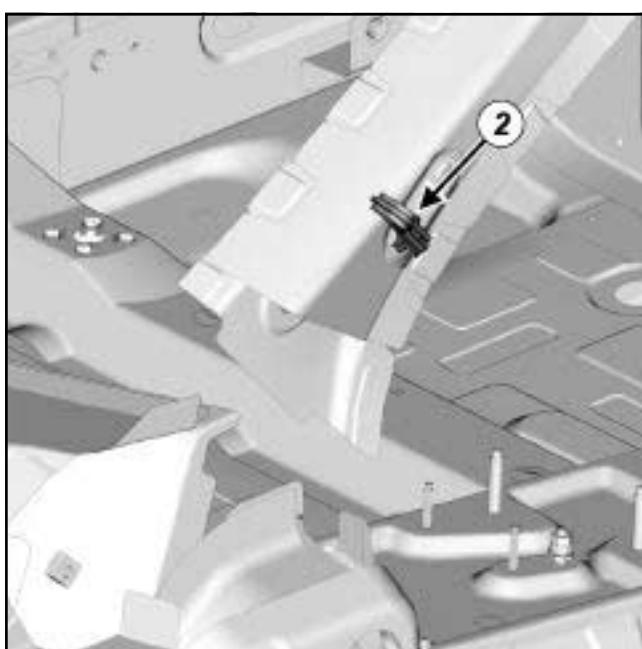
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A-pillar expanding insert (1) .



134265

Windscreen pillar reinforcement expanding insert, upper section (3) .



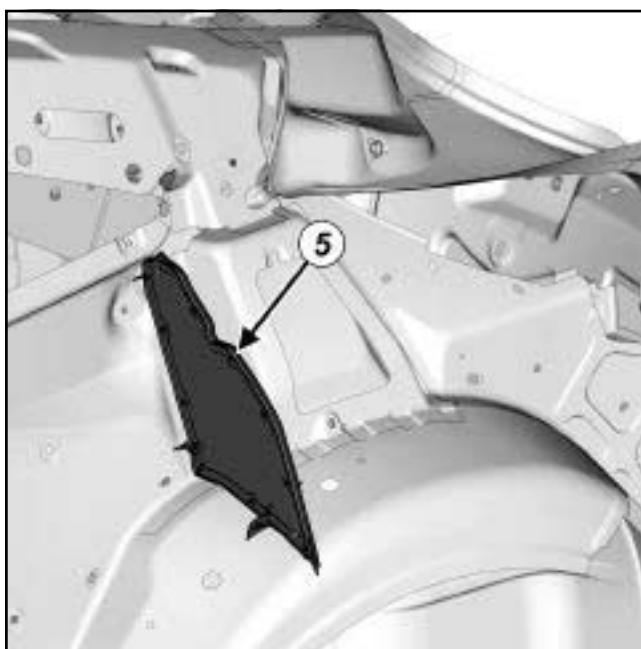
134264

Windscreen pillar lining expanding insert (2) .



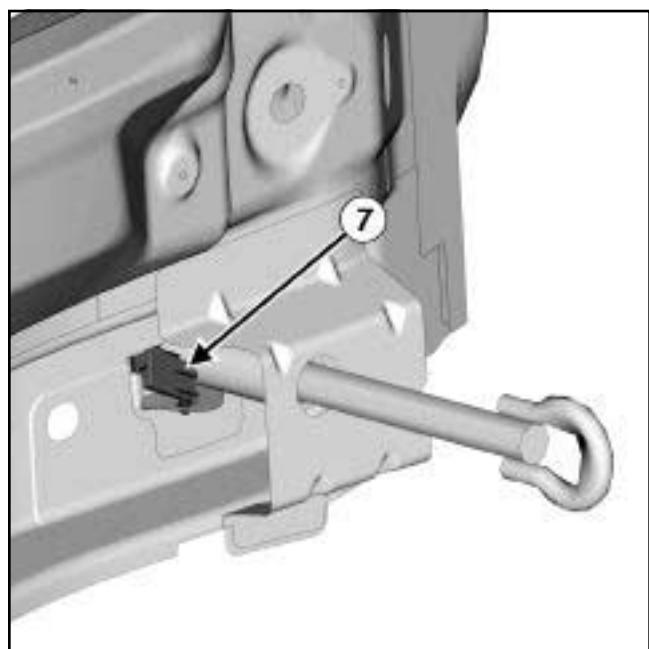
134266

B-pillar reinforcement expanding insert (4) .



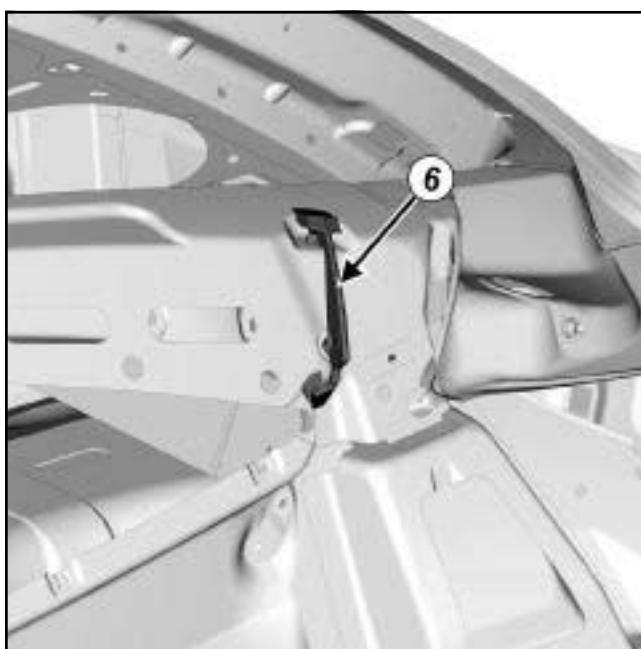
134267

Rear quarter panel lining area expanding insert (5) .



134269

Rear tow eye mounting expanding insert (7) .



134268

Side roof rail rear reinforcement expanding insert (6) .

For all welding operations (e.g.: Resistance welding, Electric welding with shielding gas or spot welding):

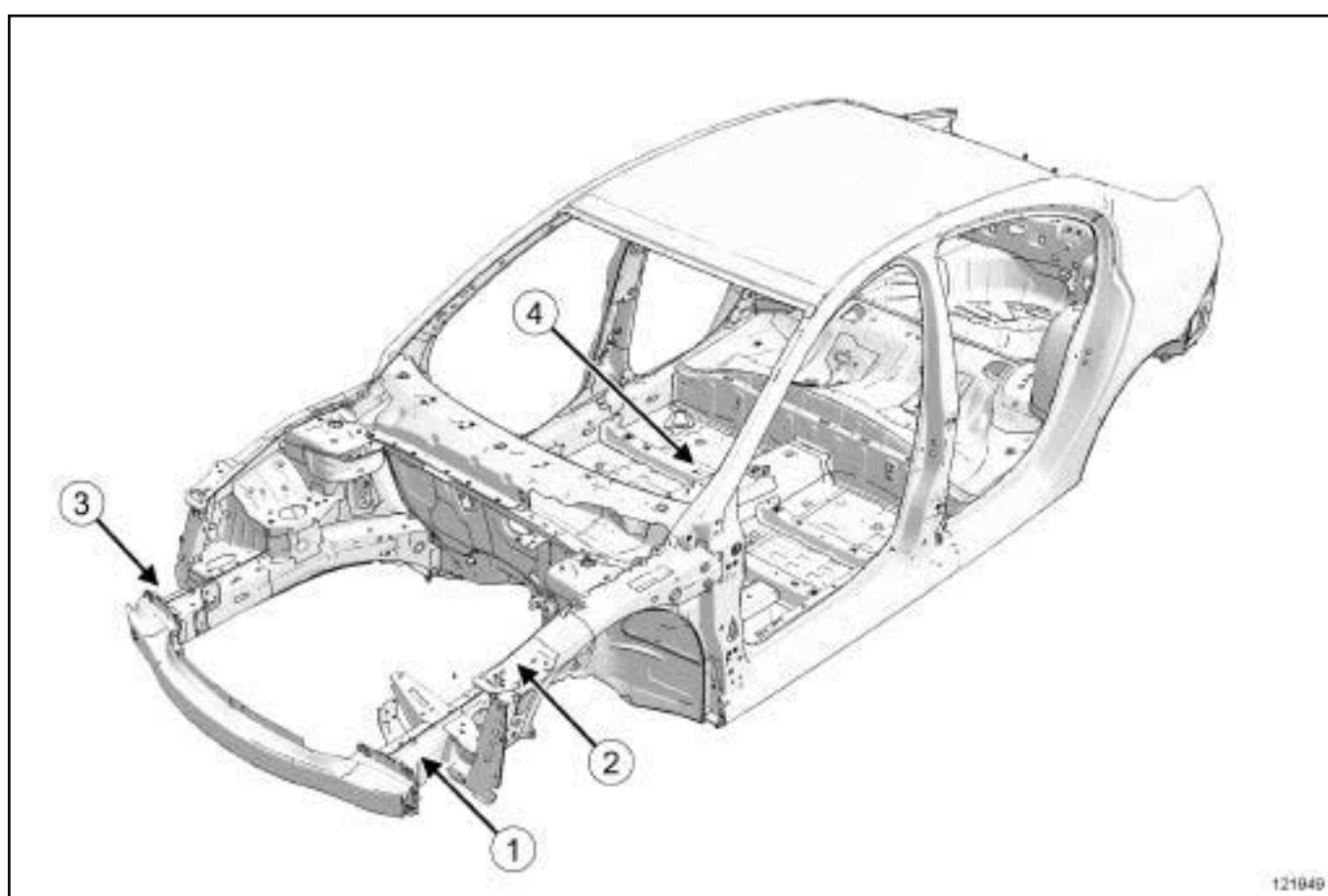
- lock the airbag computer (see **Airbag and pretensioners: Precautions for the repair** (88C, Airbags and pretensioners)),
- disconnect the battery and the vehicle's electrical circuit earths located near the area to be welded (see **Battery: Removal - Refitting** (80A, Battery)),
- position the earth of the welding machine as close as possible to the weld area.

WARNING

To avoid damaging the vehicle's electrical and electronic components, disconnect the earths of any wiring near the weld area.

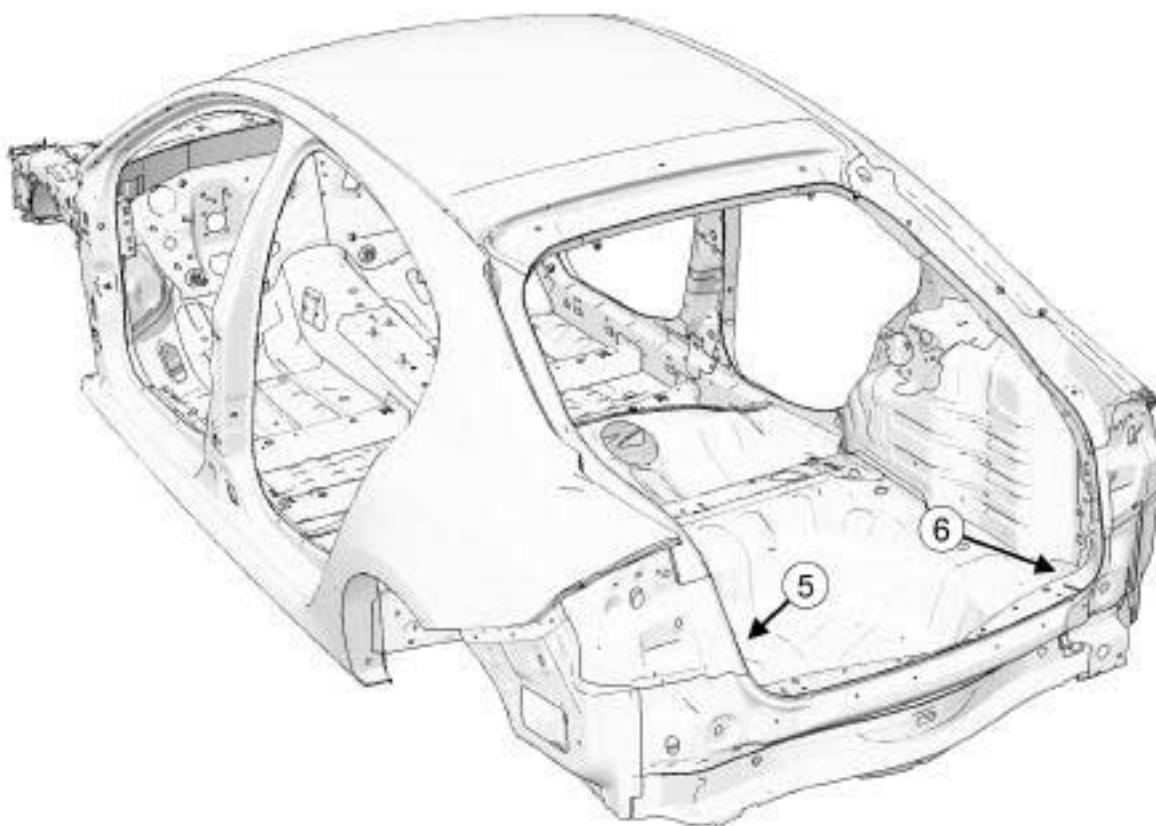
Position the welding machine earth as close as possible to the weld zone (see **MR 400**).

For the earth stud fitting procedure, see **MR 400**.



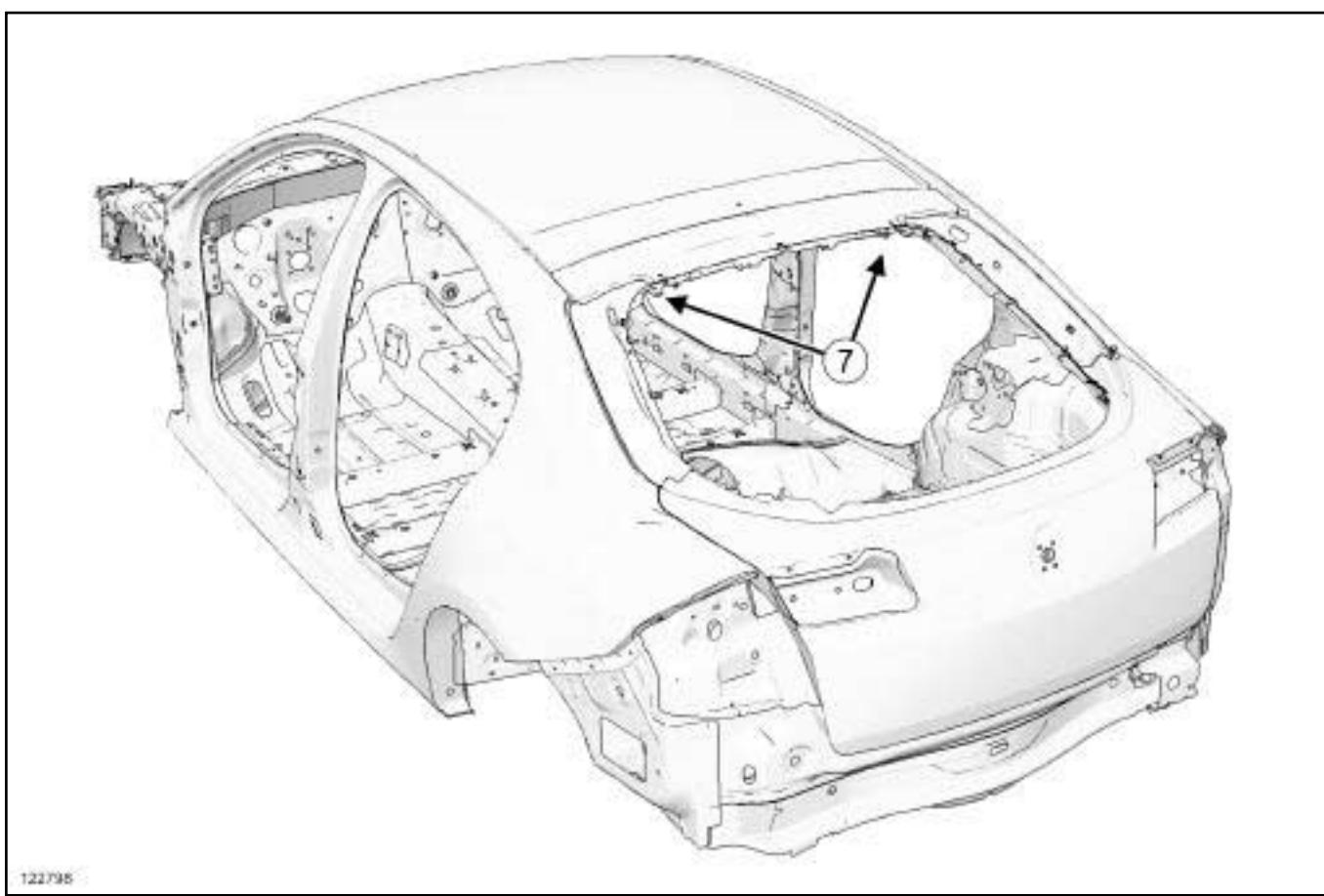
121949

121949



122799

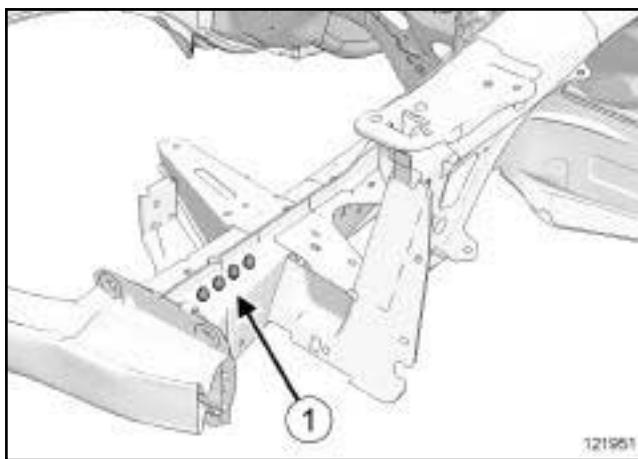
122799



122798

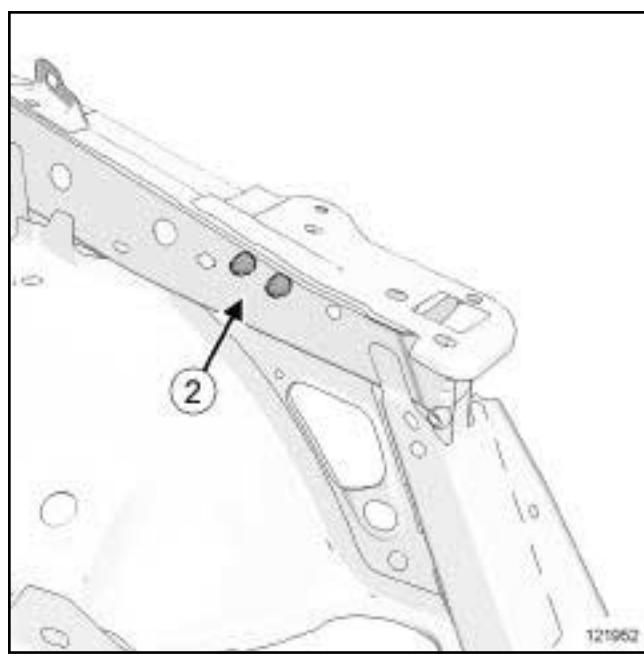
122798

I - DETAILED VIEW OF THE POSITION OF EARTHS ON THE VEHICLE



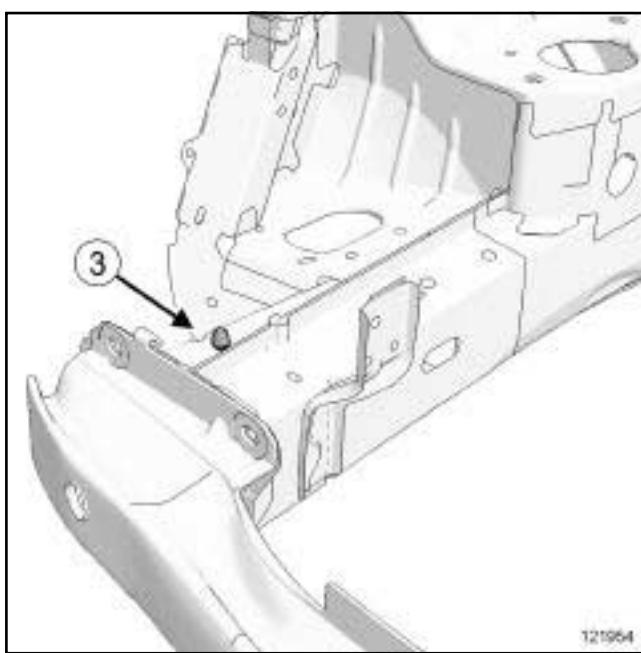
121951

Earth studs on the front left-hand side member (1).

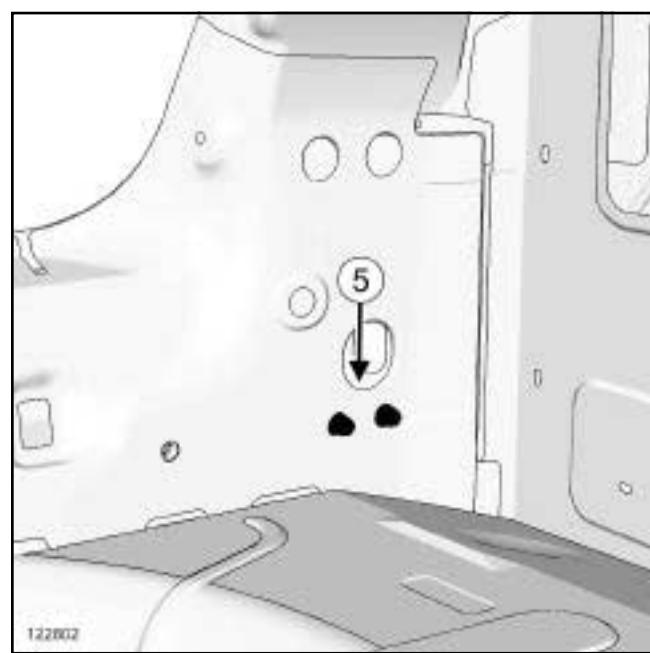


121952

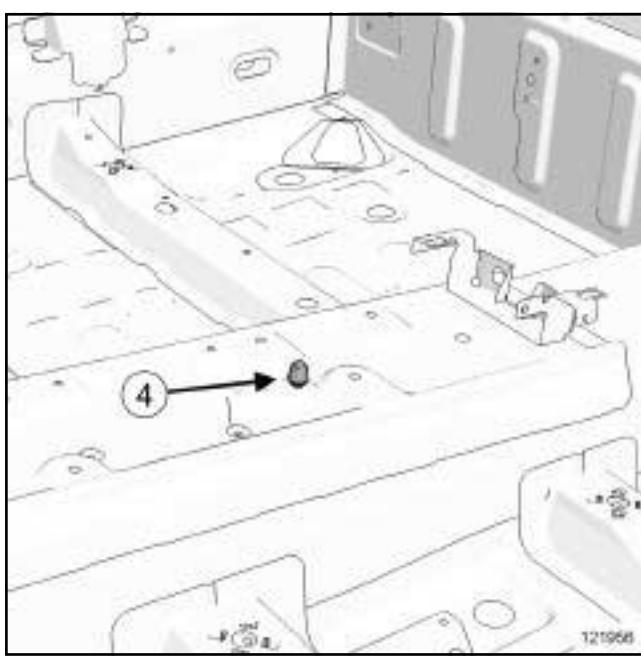
Earth studs on the left-hand scuttle side panel (2).



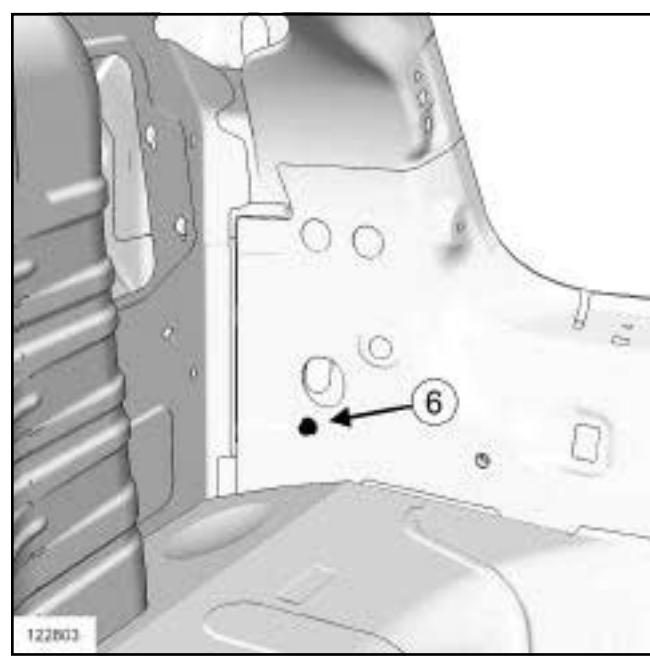
Earth studs on the front right-hand side member (3).



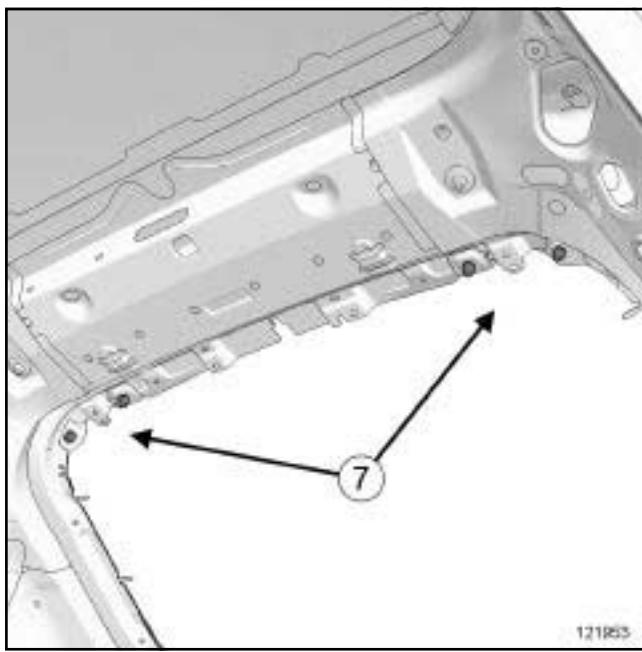
Earth studs on the rear end panel (left-hand side) (5).



Earth stud on the centre floor tunnel (4).

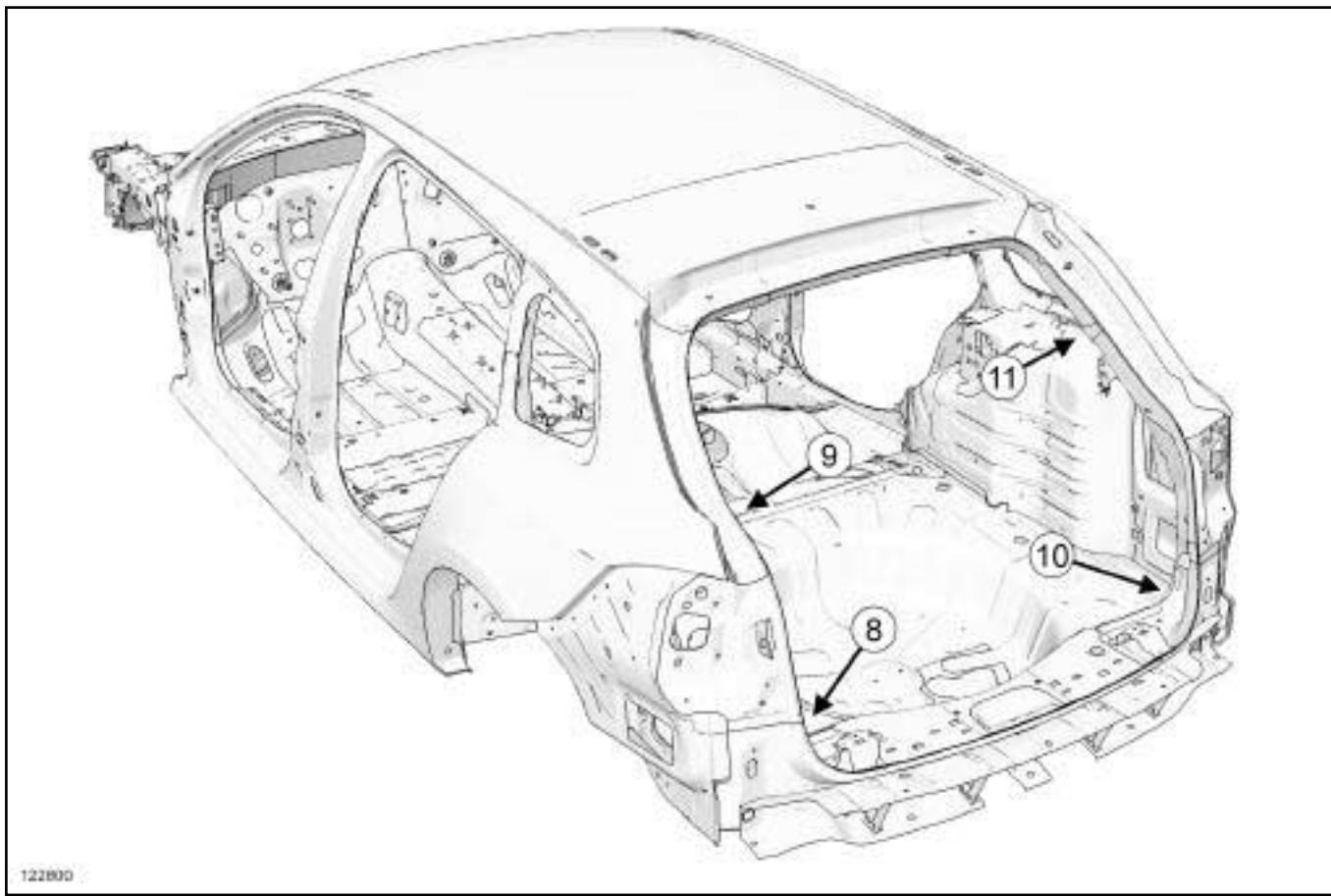


Earth stud on the rear end panel (right-hand side) (6).

II - SPECIAL FEATURE OF THE ESTATE

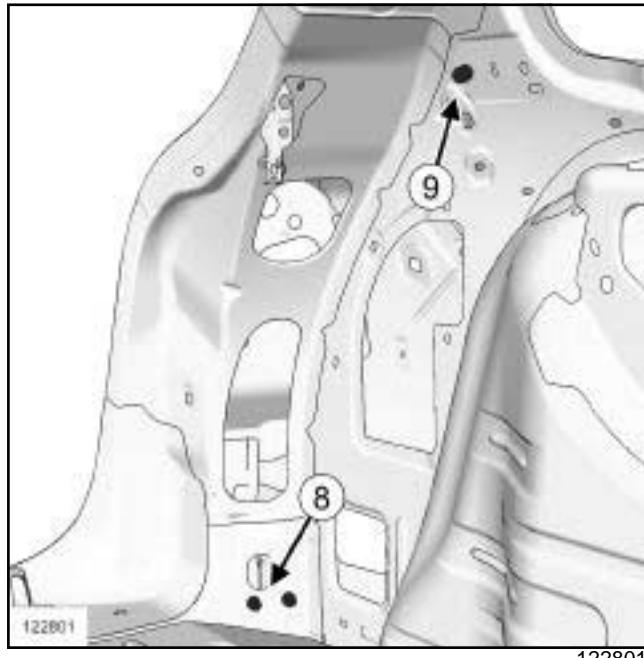
K91

Earth studs on the tailgate (7) .



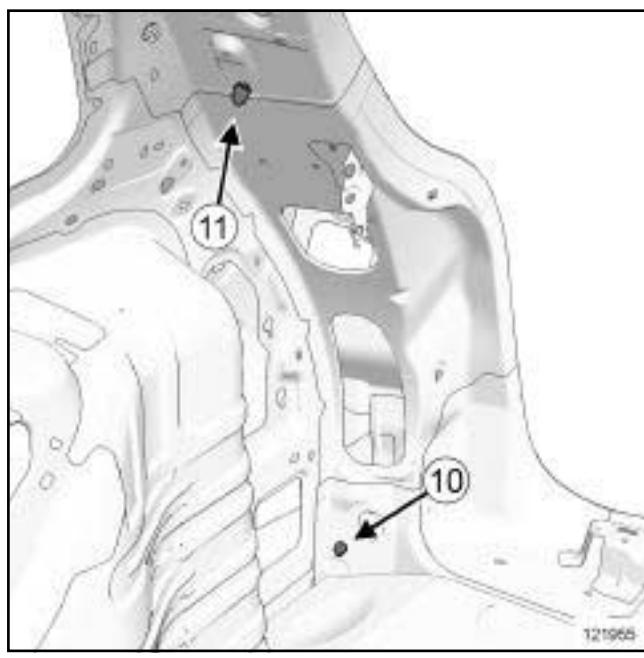
III - DETAILED VIEW OF THE POSITION OF EARTHS ON THE VEHICLE

K91



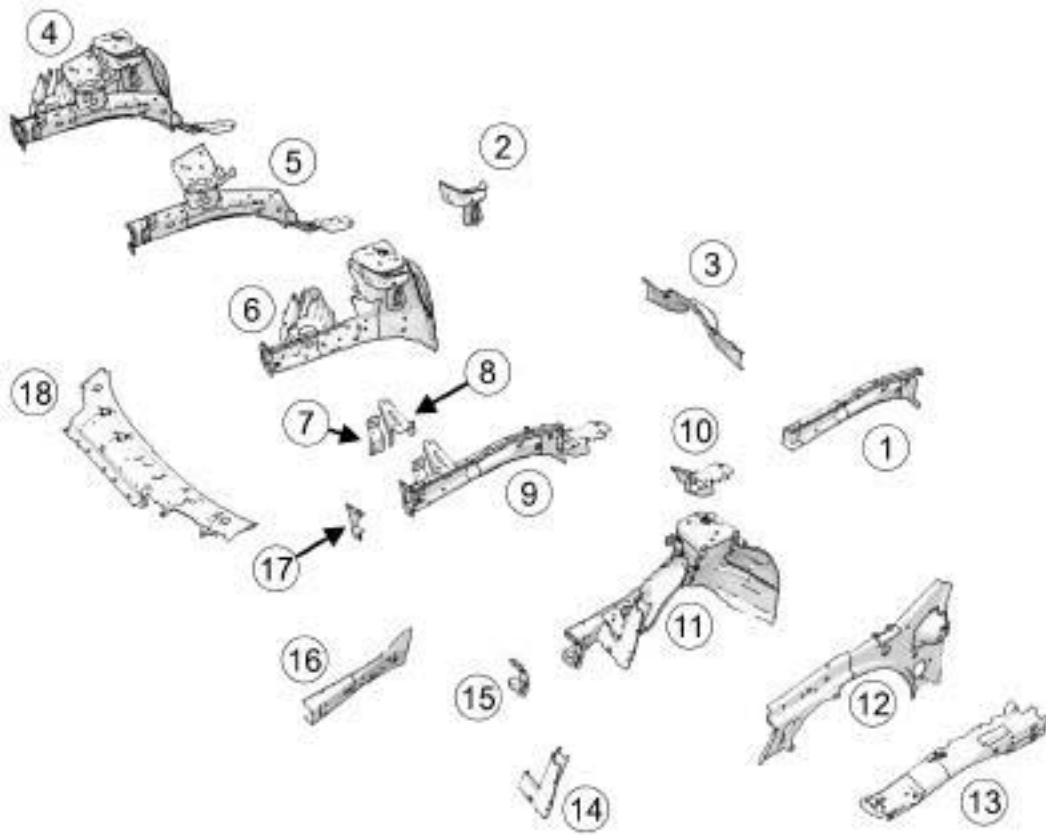
Earth studs on the rear end panel (left-hand side) (8).

Earth stud on the left-hand rear quarter lining (9).



Earth stud on the rear end panel (right-hand side) (10).

Earth stud on the right-hand lining of the rear wing panel rain channel (11).



124895

124895

No.	Description	Classification	Type	Thickness (mm)
(1)	Front side member	(see 41 A, Front lower structure, Front side member, front section: Description, page 41A-15)	HLE/THLE	1.77 / 1.8
(2)	Upper tie-rod mounting	(see 42 A, Front upper structure, Front wheel arch: Description, page 42A-25)	Mild steel	2.5
(3)	Central floor front cross member	(see 41B, Centre lower structure, Centre floor front cross member: Description, page 41B-4)		
(4)	Front half unit	(see 41A, Front lower structure, Front half unit: Description, page 41A-30)		
(5)	Front right-hand section of front side member	(see 41A, Front lower structure, Front side member, front section: Description, page 41A-15)		
(6)	Front right-hand wheel arch	(see 42A, Front upper structure, Front wheel arch: Description, page 42A-25)		

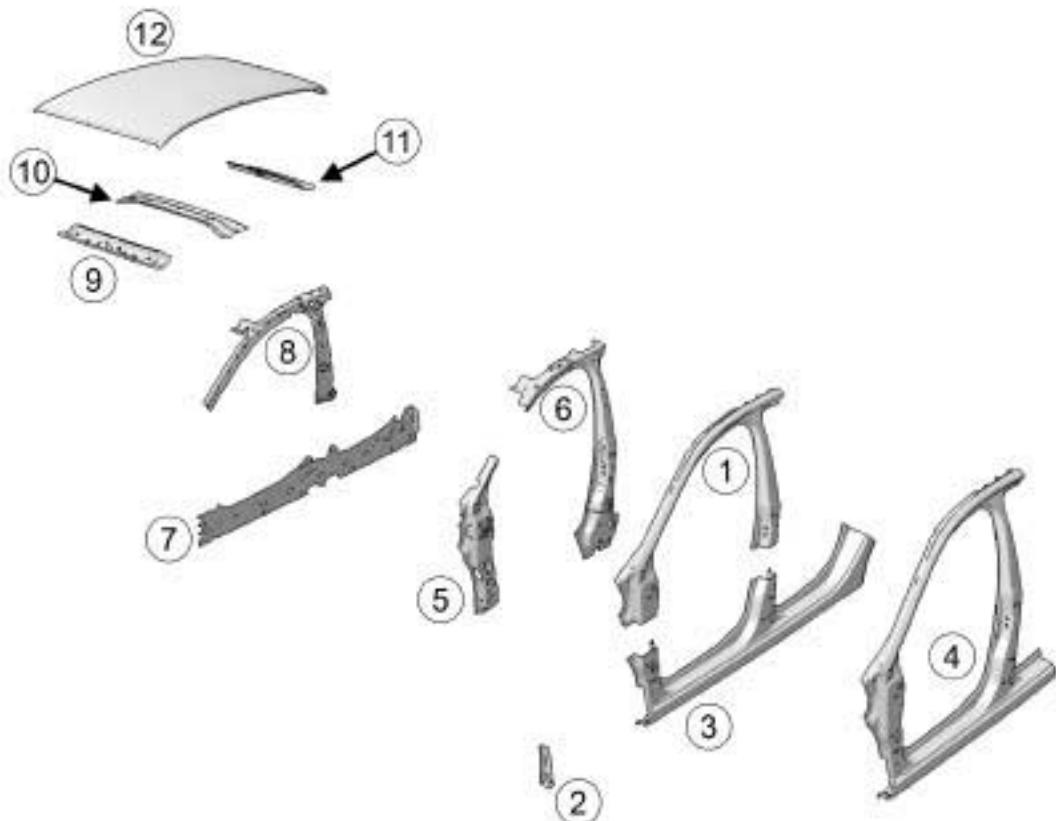
GENERAL INFORMATION

Vehicle structure, front section: Description

40A

No.	Description	Classification	Type	Thickness (mm)
(7)	Facade mounting support.	(see 41A, Front lower structure, Front panel mounting bracket: Description, page 41A-12)		
(8)	Battery tray support	(see 41A, Front lower structure, Battery tray bracket: Description, page 41A-27)		
(9)	Front left-hand section of front side member	(see 41A, Front lower structure, Front side member, front section: Description, page 41A-15)		
(10)	Front sub-frame rear mounting unit	(see 41A, Front lower structure, Front subframe rear mounting unit: Description, page 41A-28)		
(11)	Front left-hand wheel arch	(see 42A, Front upper structure, Front wheel arch: Description, page 42A-25)		
(12)	Scuttle side panel	(see 42A, Front upper structure, Scuttle side panel: Description, page 42A-20)		
(13)	Scuttle side panel upper reinforcement	(see 42A, Front upper structure, Upper reinforcement of scuttle side panel: Description, page 42A-23)		
(14)	Front end side cross member	(see 41A, Front lower structure, Front end side cross member: Description, page 41A-5)		
(15)	Left-hand front end cross member mounting stiffener	(see 41A, Front lower structure, Front end cross member mounting reinforcement: Description, page 41A-6)		
(16)	Front section of front side member closure panel	(see 41A, Front lower structure, Front side member closure panel, front section: Description, page 41A-20)		
(17)	Right-hand front end cross member mounting stiffener	(see 41A, Front lower structure, Front end cross member mounting reinforcement: Description, page 41A-6)		
(18)	Windscreen aperture lower cross member	(see 42A, Front upper structure, Windscreen aperture lower cross member: Description, page 42A-29)		

B91



125428

125428

No.	Description	Classification	Type	Thickness (mm)
(1)	Roof panel	(see 43A, Side upper structure, Body side, front section: Description, page 43A-17)	Mild steel	0.75
(2)	sill panel blanking cover	(see 41C, Side lower structure, Sill panel: Description, page 41C-4)	Mild steel	0.65
(3)	Sill panel	(see 41C, Side lower structure, Sill panel: Description, page 41C-4)		
(4)	Body side front section	(see 43A, Side upper structure, Body side, front section: Description, page 43A-17)		
(5)	A-pillar reinforcement	(see 43A, Side upper structure, A-pillar reinforcement: Description, page 43A-1)		
(6)	B-pillar reinforcement	(see 43A, Side upper structure, B-pillar reinforcement: Description, page 43A-7)		

GENERAL INFORMATION

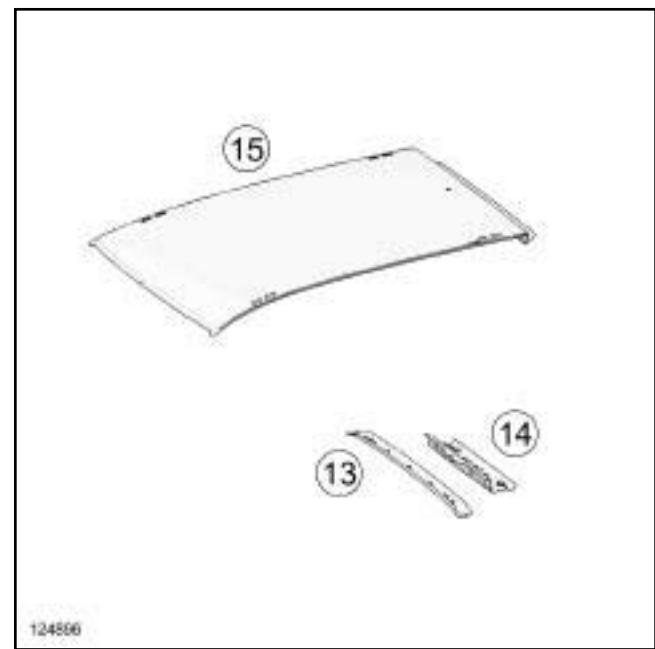
Vehicle structure, side section: Description

40A

No.	Description	Classification	Type	Thickness (mm)
(7)	Sill panel reinforcement	(see 41C, Side lower structure, Sill panel reinforcement: Description, page 41C-17)		
(8)	Windscreen pillar lining	(see 43A, Side upper structure, Windscreen pillar lining: Description, page 43A-3)		
(9)	Roof front cross member	(see 45A, Top of body, Roof front cross member: Description, page 45A-8)		
(10)	Roof centre cross member	(see 45A, Top of body, Roof centre cross member: Description, page 45A-10)		
(11)	Roof rear cross member	(see 45A, Top of body, Roof rear cross member: Description, page 45A-14)		
(12)	Roof	(see 45A, Top of body, Roof: Description, page 45A-2)		



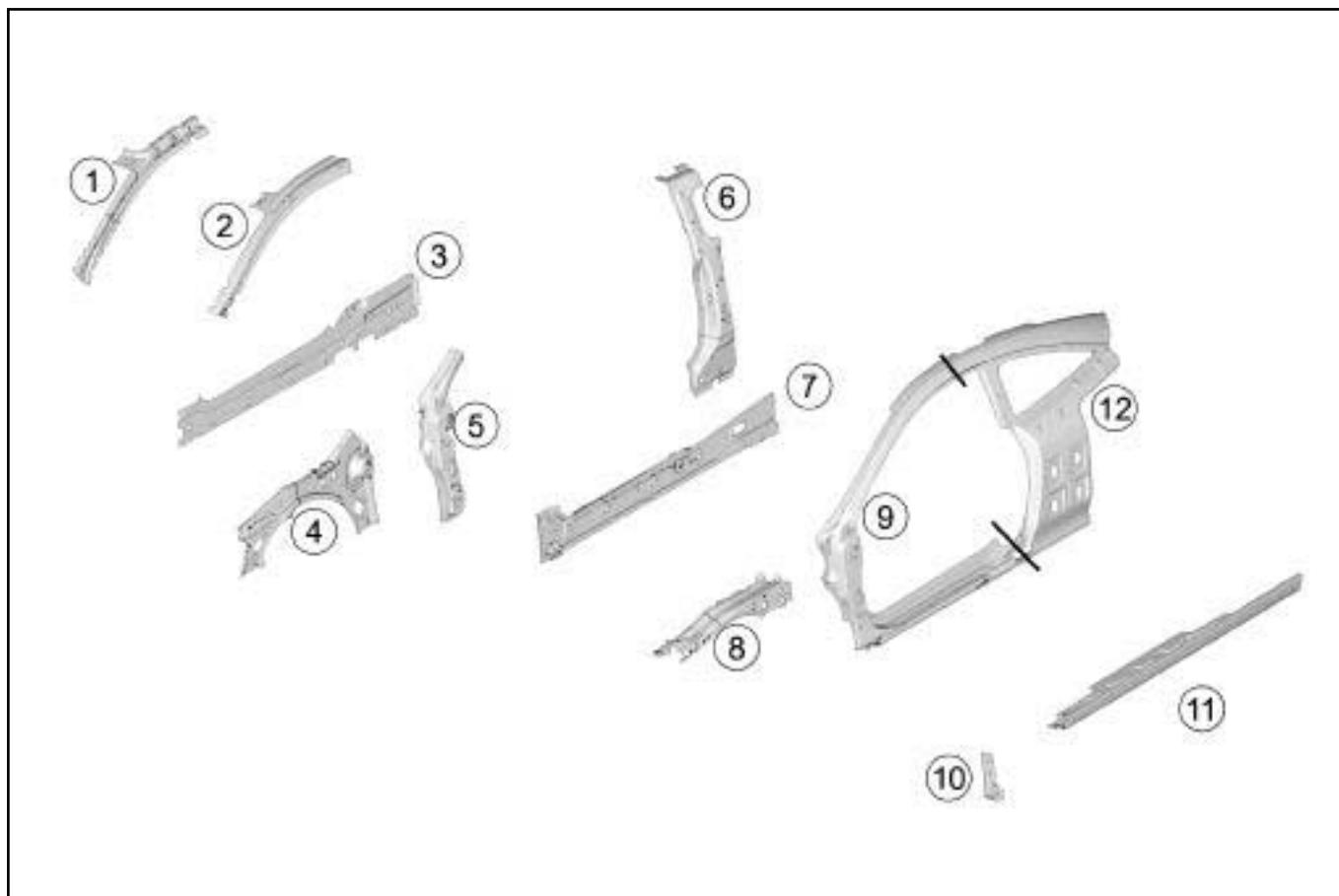
K91



124896

No.	Description	Classification	Type	Thickness
(13)	Roof panel arch	(see 45A, Top of body, Roof panel arch: Description, page 45A-12)		
(14)	Roof rear cross member	(see 45A, Top of body, Roof rear cross member: Description, page 45A-14)		
(15)	Roof	(see 45A, Top of body, Roof: Description, page 45A-2)		

D91



134780

No.	Description	Classification	Type	Thickness (mm)
(1)	Windscreen pillar lining	(see 43A, Side upper structure, Windscreen pillar lining: Description, page 43A-3)		
(2)	Windscreen pillar reinforcement	(see Windscreen pillar lining reinforcement: Description)		
(3)	Sill panel lining	(see 41C, Side lower structure, Sill panel closure panel: Description, page 41C-12)		
(4)	A-pillar lining	(see 43A, Side upper structure, A-pillar reinforcement: Description, page 43A-1)		
(5)	A-pillar reinforcement	(see 43A, Side upper structure, A-pillar reinforcement: Description, page 43A-1)		
(6)	B-pillar reinforcement	(see 43A, Side upper structure, B-pillar reinforcement: Description, page 43A-7)		
(7)	Sill panel reinforcement	(see 41C, Side lower structure, Sill panel reinforcement: Description, page 41C-17)		

GENERAL INFORMATION**Vehicle structure, side section: Description****40A**

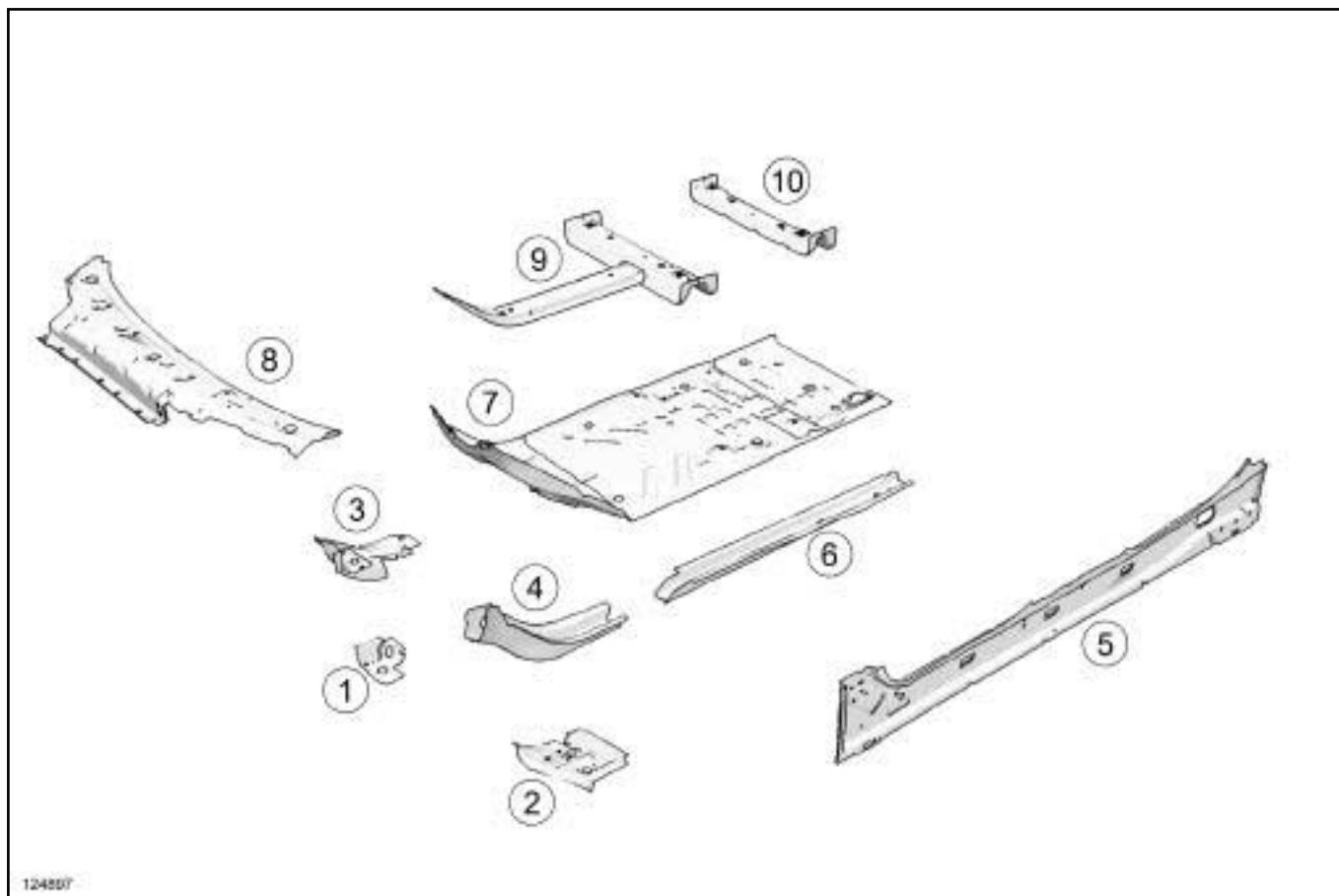
No.	Description	Classification	Type	Thickness (mm)
(8)	A-pillar lining reinforcement	(see 43A, Side upper structure, Body side, front section: Description, page 43A-17)		
(9)	Body side front section	(see 43A, Side upper structure, Body side, front section: Description, page 43A-17)		
(10)	Closure panel component, front section	(see 43A, Side upper structure, Body side, front section: Description, page 43A-17)		
(11)	Sill panel	(see 41C, Side lower structure, Sill panel: Description, page 41C-4)		
(12)	Body side rear lining	(see Body side rear lining: Description)		

GENERAL INFORMATION

Vehicle structure, centre section: Description

40A

B91 or K91



124897

124897

No.	Description	Classification	Type	Thickness (mm)
(1)	Reinforced front subframe	(see: MR 400)	HLE	1.97
(2)	Centre floor front side cross member	(see 41B, Centre lower structure, Centre floor front side cross member: Description , page 41B-6)		
(3)	Front subframe rear mounting unit	(see 41A, Front lower structure, Front subframe rear mounting unit: Description , page 41A-28)		
(4)	Front side member, centre section	(see 41A, Front lower structure, Front side member, centre section: Description , page 41A-23)		
(5)	Sill panel closure panel	(see 41C, Side lower structure, Sill panel closure panel: Description , page 41C-12)		
(6)	Front side member rear part	(see 41A, Front lower structure, Front side member, rear section: Description , page 41A-24)		
(7)	Central floor, side section	(see 41B, Centre lower structure, Centre floor, side section: Description , page 41B-1)		
(8)	Windscreens aperture lower cross member	(see 42A, Front upper structure, Windscreens aperture lower cross member: Description , page 42A-29)		

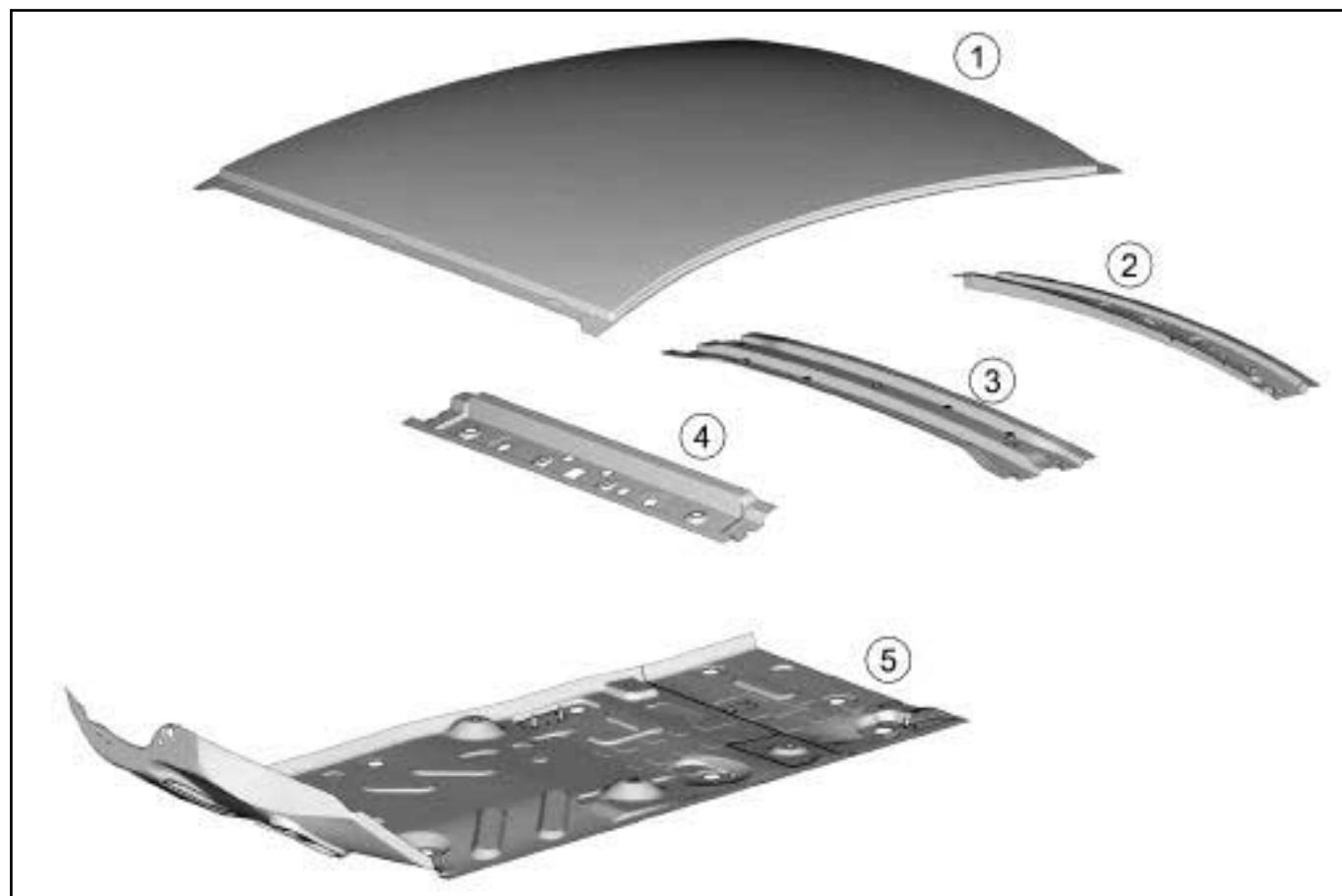
GENERAL INFORMATION

Vehicle structure, centre section: Description

40A

No.	Description	Classification	Type	Thickness (mm)
(9)	Front cross member under front seat	(see 41B, Centre lower structure, Front cross member under front seat: Description, page 41B-8)		
(10)	Rear cross member under front seat	(see 41B, Centre lower structure, Rear cross member under front seat: Description, page 41B-11)		

D91



134270

No.	Description	Classification	Type	Thickness (mm)
(1)	Roof	(see 45A, Top of body, Roof: Description, page 45A-2)		
(2)	Roof rear cross member	(see 45A, Top of body, Roof rear cross member: Description, page 45A-14)		
(3)	Roof centre cross member	(see 45A, Top of body, Roof centre cross member: Description, page 45A-10)		

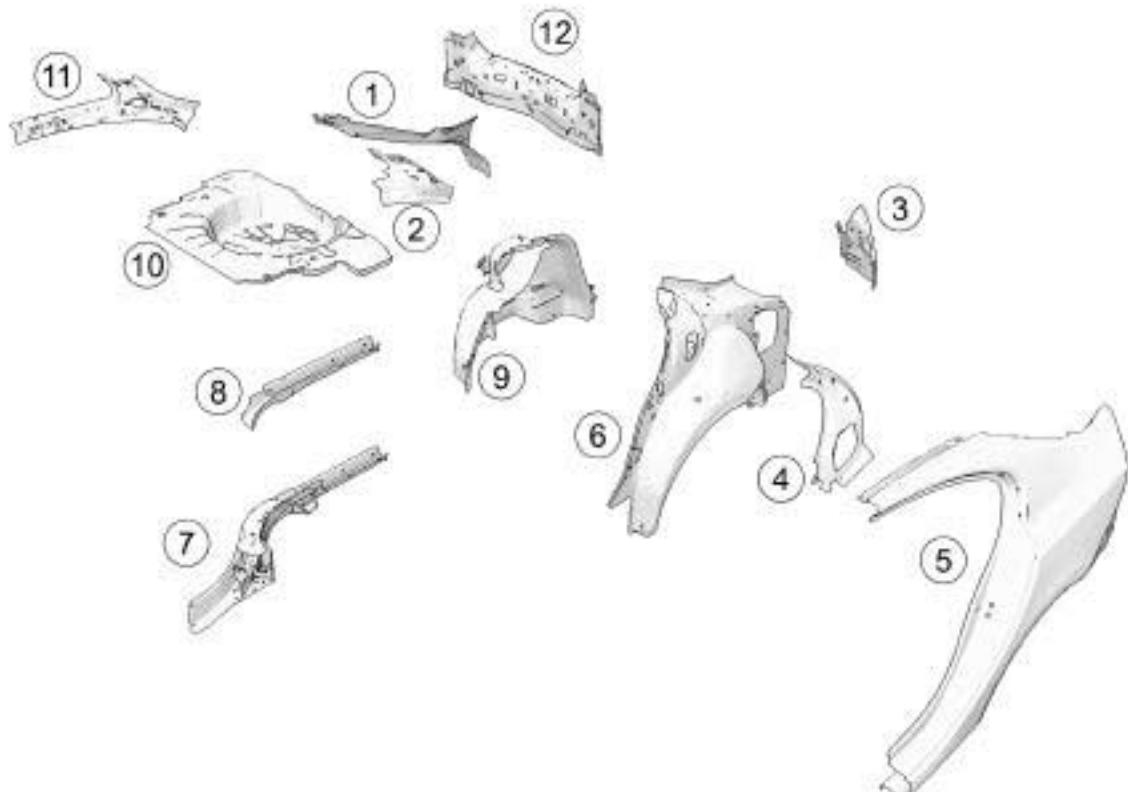
GENERAL INFORMATION

Vehicle structure, centre section: Description

40A

No.	Description	Classification	Type	Thickness (mm)
(4)	Roof front cross member	(see 45A, Top of body, Roof front cross member: Description, page 45A-8)		
(5)	Side floor	(see 41B, Centre lower structure, Centre floor, side section: Description, page 41B-1)		

B91



124899

124899

No.	Description	Classification	Type	Thickness (mm)
(1)	Rear wing panel rain channel	(see 44A, Rear upper structure, Rear wing panel rain channel: Description, page 44A-15)	Mild steel	1
(2)	Quarter panel upper section stiffener	(see 44A, Rear upper structure, Quarter panel reinforcement: Description, page 44A-41)	Mild steel	0.9
(3)	Rear light mounting	(see 44A, Rear upper structure, Rear wing panel rain channel: Description, page 44A-15)	Mild steel	0.7
(4)	Quarter panel lower section stiffener	(see 44A, Rear upper structure, Quarter panel reinforcement: Description, page 44A-41)	Mild steel	0.9

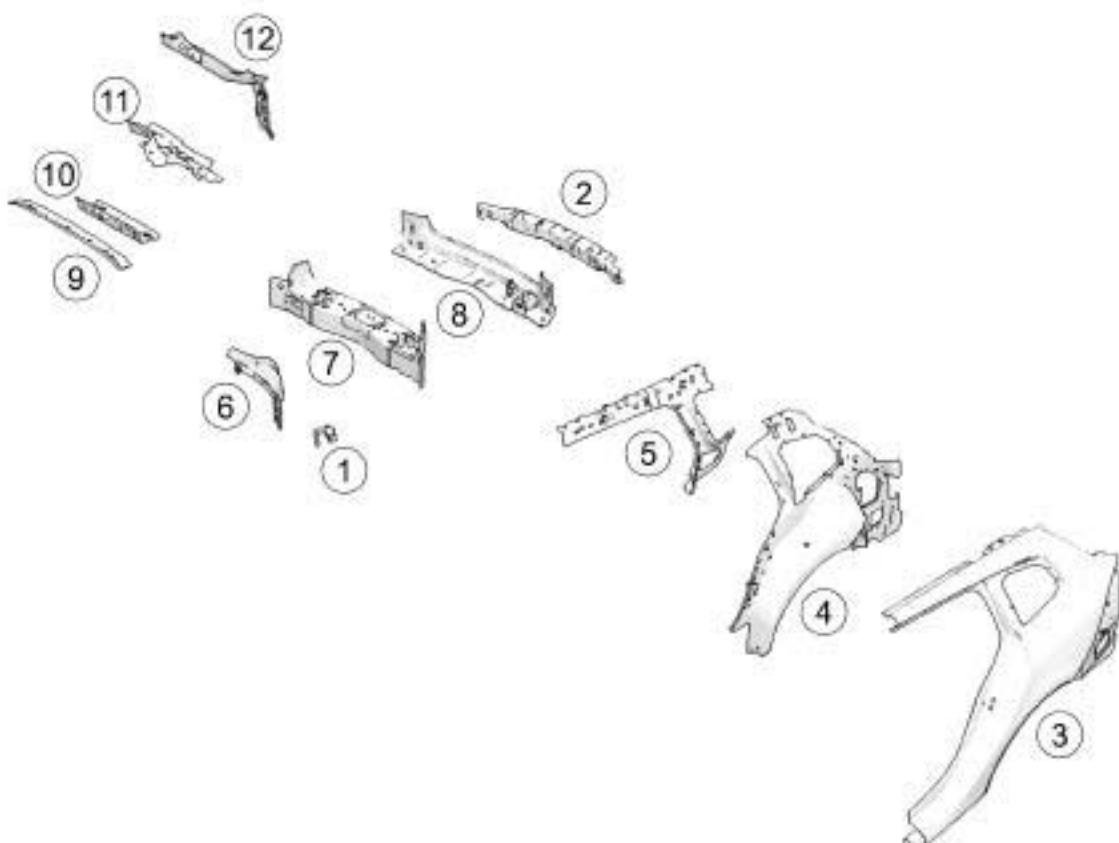
GENERAL INFORMATION

Vehicle structure, rear section: Description

40A

No.	Description	Classification	Type	Thickness (mm)
(5)	Rear wing panel	(see 44A, Rear upper structure, Rear wing panel: Description, page 44A-4)		
(6)	Outer rear wheel arch	(see 44A, Rear upper structure, Outer rear wheel arch: Description, page 44A-25)		
(7)	Rear side member assembly	(see 41D, Rear lower structure, Rear side member assembly: Description, page 41D-6)		
(8)	Rear side member	(see 41D, Rear lower structure, Rear side member: Description, page 41D-9)		
(9)	Inner rear wheel arch	(see 44A, Rear upper structure, Inner rear wheel arch: Description, page 44A-28)		
(10)	Rear floor rear section	(see 41D, Rear lower structure, Rear floor, rear section: Description, page 41D-3)		
(11)	Roof drip moulding lining	(see 43A, Side upper structure, Side roof rail lining: Description, page 43A-30)		
(12)	Rear end panel assembly	(see 44A, Rear upper structure, Rear end panel assembly: Description, page 44A-46)		

K91



124880

124898

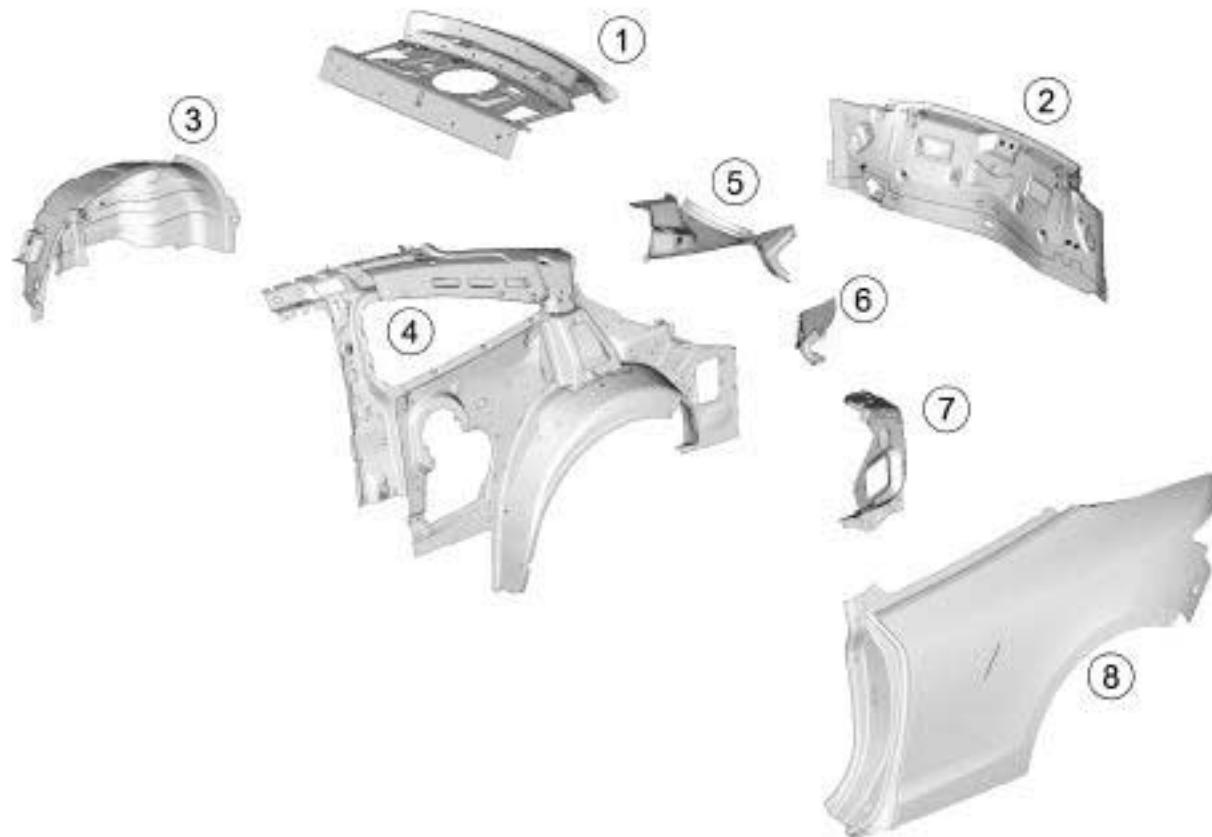
GENERAL INFORMATION

Vehicle structure, rear section: Description

40A

No.	Description	Classification	Type	Thickness (mm)
(1)	Roof bar mounting reinforcement	(see MR 400)	Mild steel	1.3
(2)	Absorber mounting cross member	(see MR 400)	HLE	1
(3)	Rear wing panel	(see 44A, Rear upper structure, Rear wing panel: Description, page 44A-4)		
(4)	Outer rear wheel arch	(see 44A, Rear upper structure, Outer rear wheel arch: Description, page 44A-25)		
(5)	Side roof rail lining	(see 43A, Side upper structure, Side roof rail lining: Description, page 43A-30)		
(6)	Rear end pillar closure panel	(see 44A, Rear upper structure, Rear end pillar closure panel: Description, page 44A-21)		
(7)	Rear floor rear cross member	(see 41D, Rear lower structure, Rear floor rear cross member: Description, page 41D-12)		
(8)	Rear end panel assembly	(see 44A, Rear upper structure, Rear end panel assembly: Description, page 44A-46)		
(9)	Roof panel arch	(see 45A, Top of body, Roof panel arch: Description, page 45A-12)		
(10)	Roof rear cross member	(see 45A, Top of body, Roof rear cross member: Description, page 45A-14)		
(11)	Quarter panel reinforcement	(see 44A, Rear upper structure, Quarter panel reinforcement: Description, page 44A-41)		
(12)	Rear wing panel rain channel	(see 44A, Rear upper structure, Rear wing panel rain channel: Description, page 44A-15)		

D91

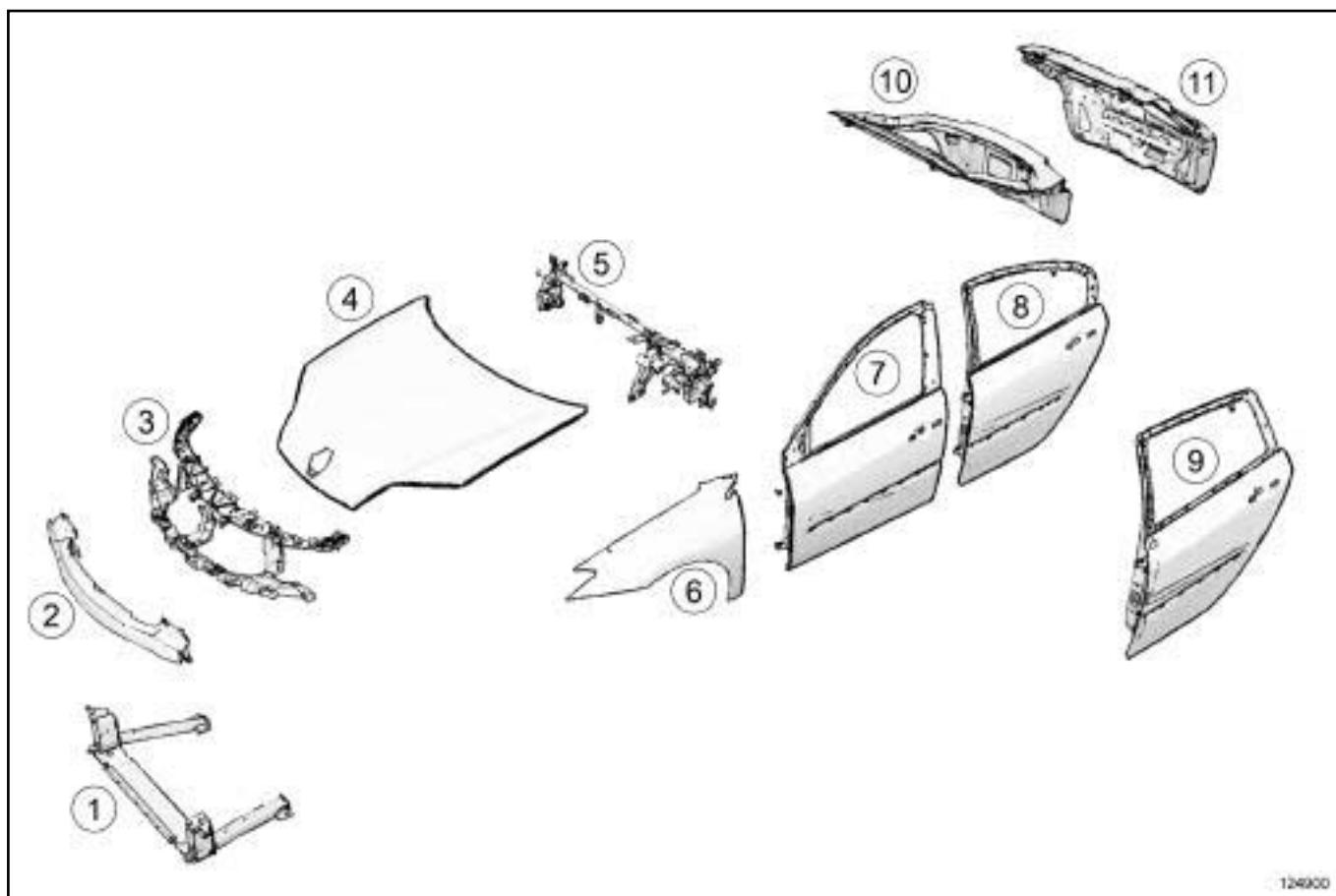


134271

No.	Description	Classification	Type	Thickness (mm)
(1)	Rear parcel shelf	(see 44A, Rear upper structure, Rear parcel shelf: Description, page 44A-43)		
(2)	Rear end panel	(see 44A, Rear upper structure, Rear end panel: Description, page 44A-50)		
(3)	Inner rear wheel arch	(see 44A, Rear upper structure, Inner rear wheel arch: Description, page 44A-28)		
(4)	Quarter panel lining	(see 44A, Rear upper structure, Quarter panel lining: Description, page 44A-33)		
(5)	Upper side rain channel	(see 44A, Rear upper structure, Rear wing panel rain channel: Description, page 44A-15)		
(6)	Rear light upper section upper component on body	(see 44A, Rear upper structure, Rear lights mounting: Description, page 44A-18)		

GENERAL INFORMATION**Vehicle structure, rear section: Description****40A**

No.	Description	Classification	Type	Thickness (mm)
(7)	Body side extension	(see 44A, Rear upper structure, Rear wheel arch extension: Description, page 44A-31)		
(8)	Rear wing panel	(see 44A, Rear upper structure, Rear wing panel: Description, page 44A-4)		



124900

124900

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No.	Description	Classification	Type
(1)	Radiator mounting cross member	(see 41A, Front lower structure, Radiator mounting cross member: Removal - Refitting, page 41A-8)	Aluminium
(2)	Front impact cross member (B,K)	(see 41A, Front lower structure, Front impact cross member: Removal - Refitting, page 41A-3)	Aluminium
(3)	Front end panel	(see 42A, Front upper structure, Front end panel: Removal - Refitting, page 42A-16)	Polypropylene
(4)	Bonnet (B,K)	(see 48A, Non-side opening elements, Bonnet: Removal - Refitting, page 48A-1)	Aluminium
(5)	Dashboard cross member	(see 42A, Front upper structure, Dashboard cross member: Removal - Refitting, page 42A-31)	Steel
(6)	Front wing (B,K)	(see 42A, Front upper structure, Front wing: Removal - Refitting, page 42A-3)	Steel

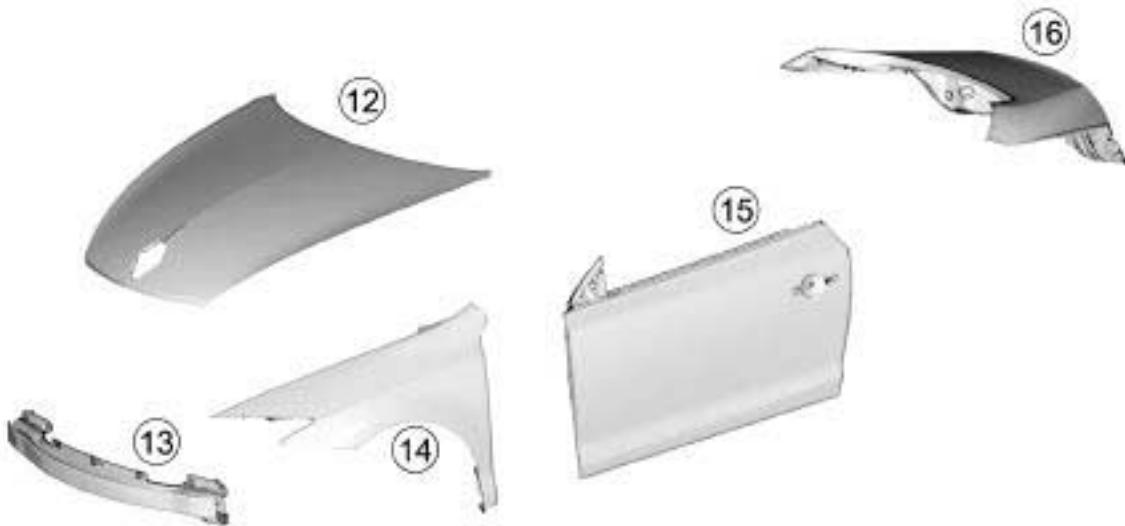
GENERAL INFORMATION

Vehicle structure, removable section: Description

40A

No.	Description	Classification	Type
(7)	Front side door (B,K)	(see 47A, Side opening elements, Front side door: Removal - Refitting, page 47A-1)	Steel
(8)	Rear side door (B)	(see 47A, Side opening elements, Rear side door: Removal - Refitting, page 47A-10)	Steel
(9)	Rear side door (K)	(see 47A, Side opening elements, Rear side door: Removal - Refitting, page 47A-10)	Steel
(10)	Tailgate (hatch)	(see 48A, Non-side opening elements, Tailgate: Removal - Refitting, page 48A-10)	Steel
(11)	Tailgate (estate)	(see 48A, Non-side opening elements, Tailgate: Removal - Refitting, page 48A-10)	SMC

D91



134272

GENERAL INFORMATION

Vehicle structure, removable section: Description

40A

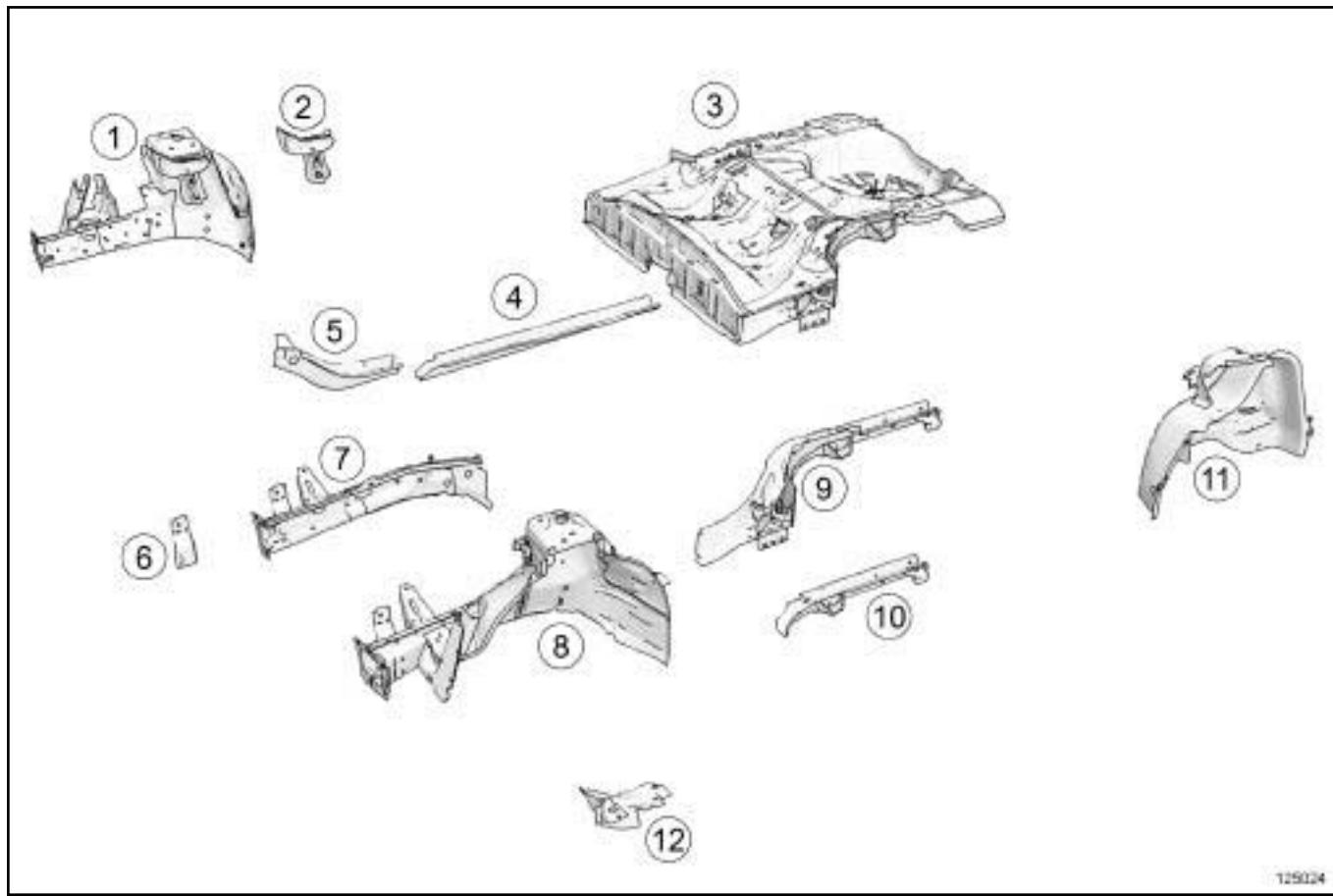
No.	Description	Classification	Type
(12)	Bonnet	(see 48A, Non-side opening elements, Bonnet: Removal - Refitting, page 48A-1)	Aluminium
(13)	Frontal impact cross member	(see 41A, Front lower structure, Front impact cross member: Removal - Refitting, page 41A-3)	Aluminium
(14)	Front wing	(see 42A, Front upper structure, Front wing: Removal - Refitting, page 42A-3)	Steel
(15)	Side door	(see 47A, Side opening elements, Front side door: Removal - Refitting, page 47A-1)	Steel
(16)	Boot lid	(see 48A, Non-side opening elements, Luggage compartment lid: Removal - Refitting, page 48A-5)	SMC

GENERAL INFORMATION

Structural components to be positioned on the repair bench: Description

40A

I - LIST OF PARTS REQUIRING REPAIR ON REPAIR BENCH



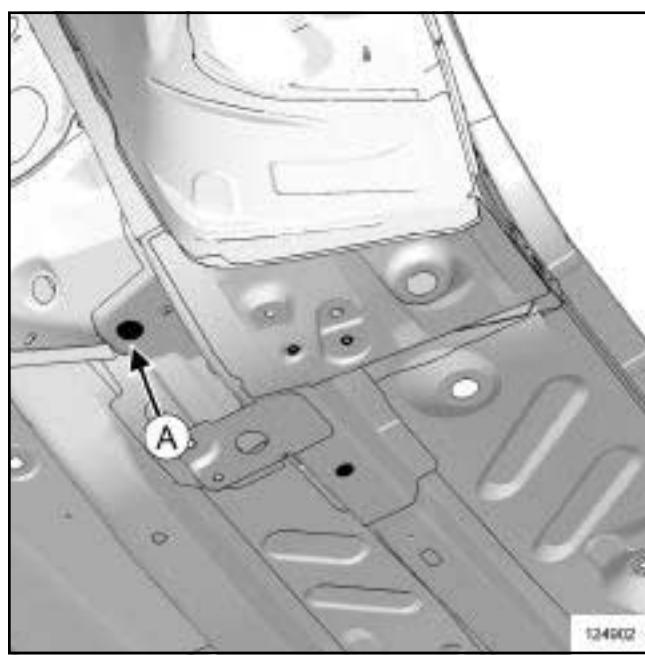
125024

125024

- (1) Front right-hand wheel arch
- (2) Top tie-bar mounting
- (3) Rear subframe assembly
- (4) Front side member rear part
- (5) Front side member, centre section
- (6) Front panel mounting bracket
- (7) Front side member front section
- (8) Front half-unit
- (9) Rear side member assembly
- (10) Rear side member
- (11) Inner rear wheel arch
- (12) Front sub-frame rear mounting unit

II - TEST POINTS

1 - Subframe rear mounting



124902

124902

GENERAL INFORMATION

Structural components to be positioned on the repair bench: Description

40A

The jig rests under the subframe mounting unit and is centred in the threaded hole (**A**) .

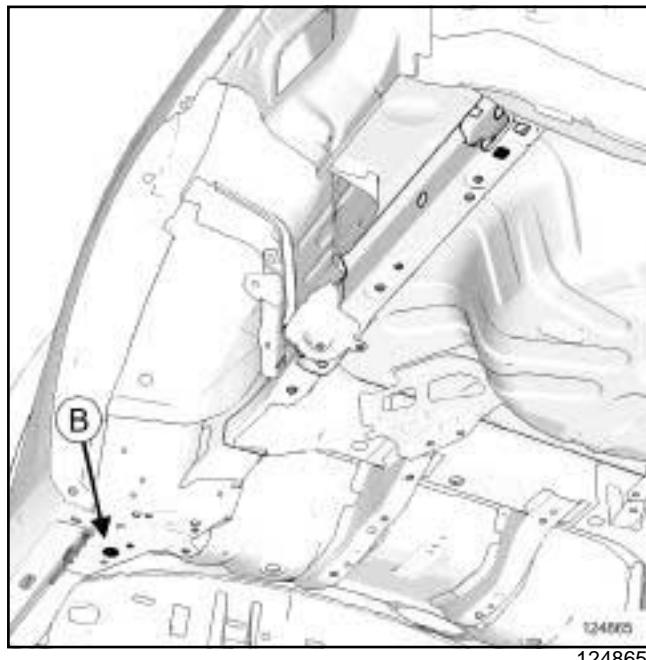
It is used for replacing a complete front half unit.

IMPORTANT

This/these point/s help(s) to ensure axle geometry.

This point aligns the subframe of the front axle in relation to the body. It has a direct influence on all of the front axle angles.

2 - Rear axle assembly front mounting



The jig supports the underneath of the rear axle mounting unit and is centred in the pilot hole (**B**) of the rear axle mounting.

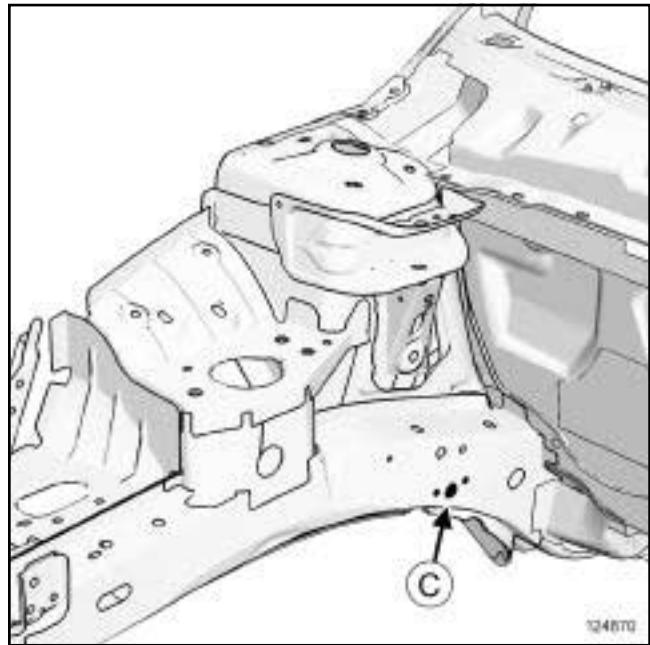
It is used for replacing a rear side member assembly.

IMPORTANT

This/these point/s help(s) to ensure axle geometry.

This point has a direct influence on the path angle of the vehicle.

3 - Front sub-frame front mounting



124870

The jig rests under the front subframe attachment positioning pins and it is fitted in the mounting hole of the attachment (**C**) .

It is used when replacing:

- a complete front side member,
- a front half unit.

IMPORTANT

This/these point/s help(s) to ensure axle geometry.

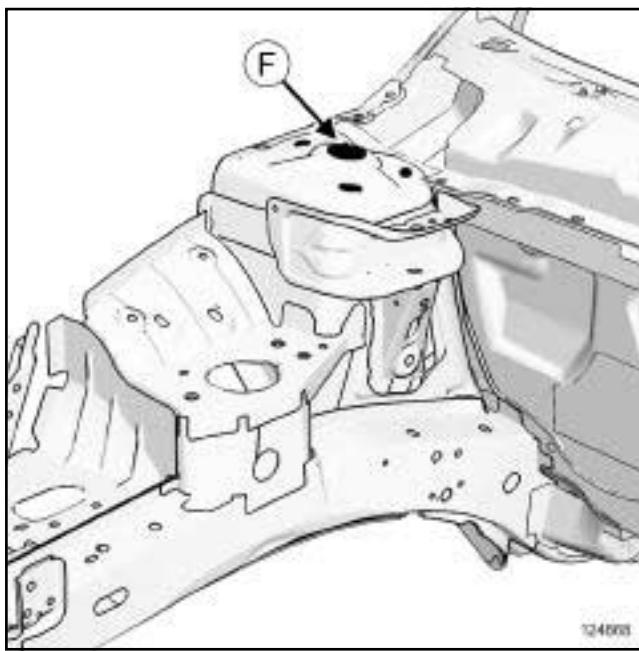
This point directly influences the clearance in the space of the front axle lower wishbone and therefore the variations in castor angle and wheel alignment.

GENERAL INFORMATION

Structural components to be positioned on the repair bench: Description

40A

4 - Front shock absorber upper mounting



The jig supports the underneath of the shock absorber cup and is centred on the hole (**F**) of the shock absorber cup.

It is used when replacing:

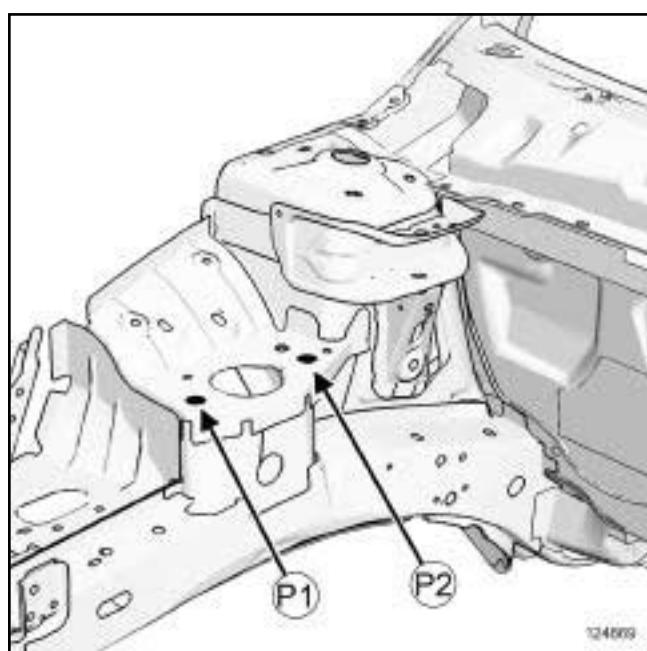
- a wheel arch,
- a front half unit.

IMPORTANT

This/these point/s help(s) to ensure axle geometry.

This point has a direct influence on the pivot, camber and castor angles.

5 - Engine mounting

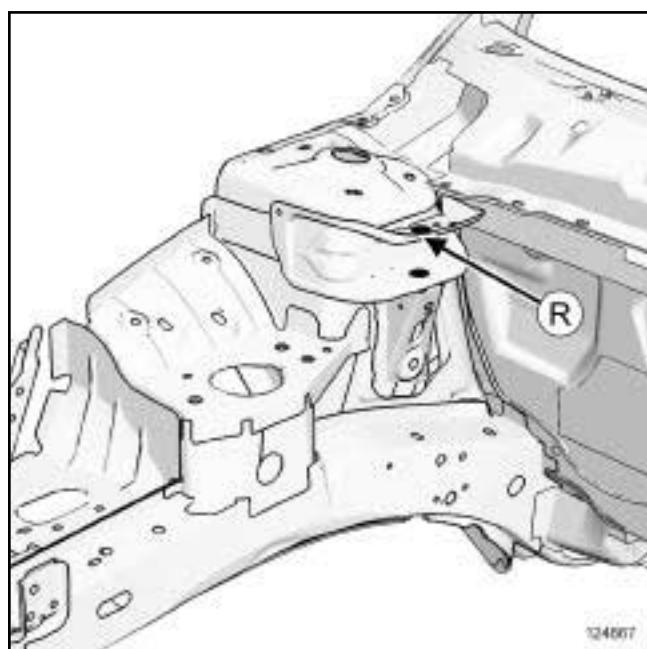


The jig rests on the engine mounting and is centred in engine mounting securing holes (**P1**) and (**P2**).

It is used with the mechanical components removed for the replacement of:

- a front half unit.
- the engine mounting.

6 - Engine tie-rod attachment



The jig supports the engine tie-rod attachment mounting and is centred on hole (**R**).

GENERAL INFORMATION

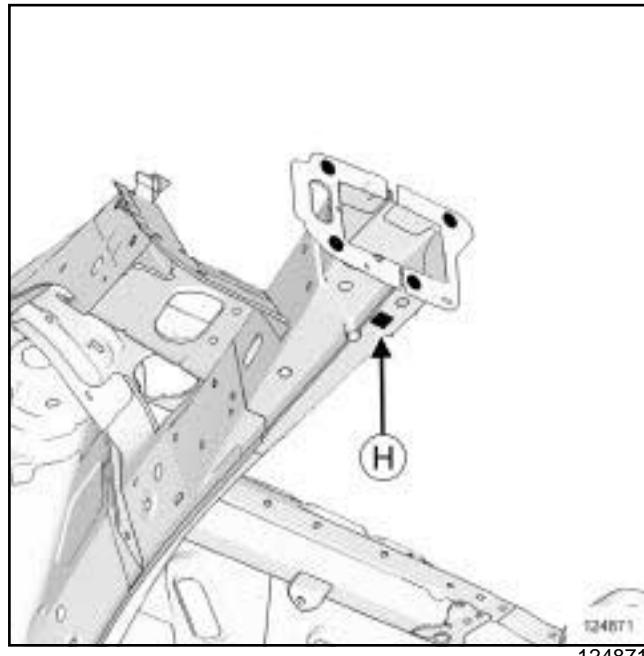
Structural components to be positioned on the repair bench: Description

40A

It is used with the mechanical components removed for the replacement of:

- the engine tie-rod attachment,
- a front half unit.

7 - Radiator mounting cross member mounting

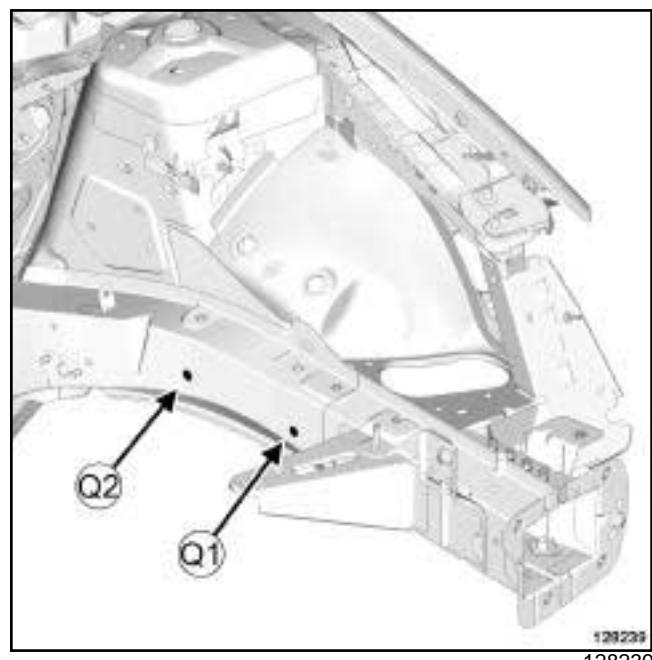


The jig rests under the front side member and is centred in the threaded hole (**H**) .

It is used when replacing:

- the front side member completely or partially,
- a front half unit.

8 - gearbox mounting

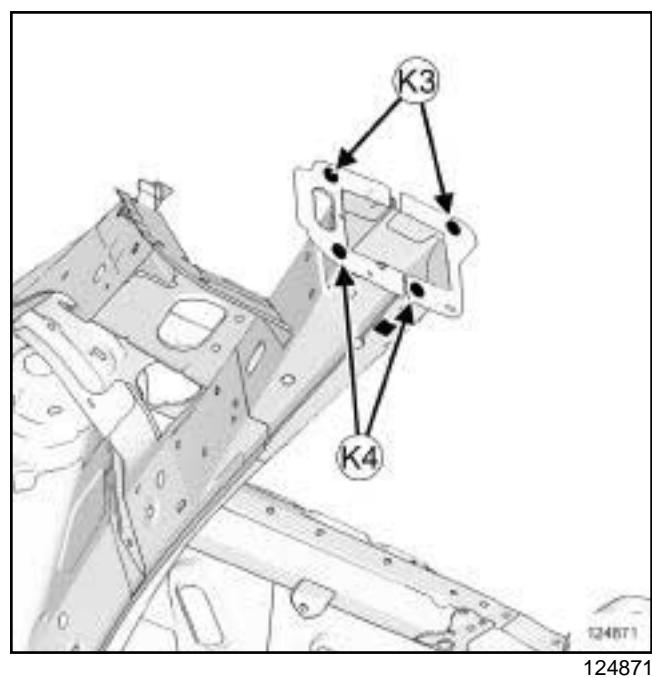


The jig rests against the front side member and is centred in the threaded holes (**Q1**) and (**Q2**) ,

It is used when replacing:

- the front side member completely or partially,
- a front half unit.

9 - Front impact cross member mounting



The jig rests vertically against the front impact cross member mounting reinforcement and is centred on the mounting holes (**K3**) and (**K4**) .

GENERAL INFORMATION

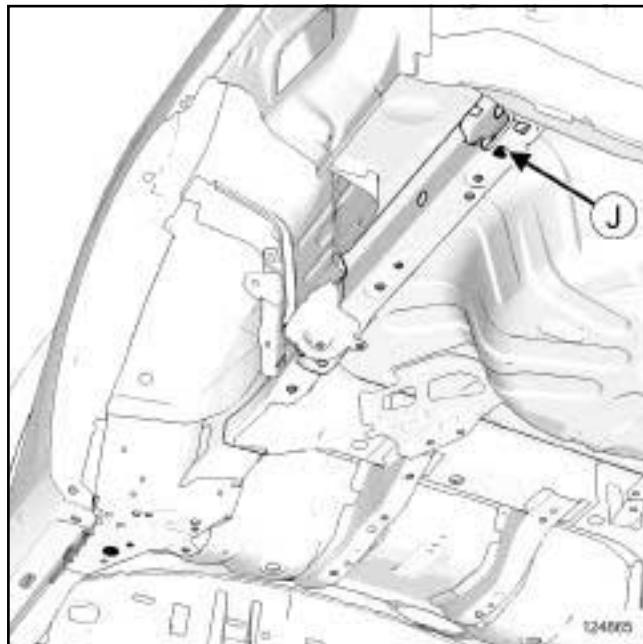
Structural components to be positioned on the repair bench: Description

40A

It is used when replacing:

- the front impact cross member mounting,
- the front side member completely or partially

10 - End of rear side member



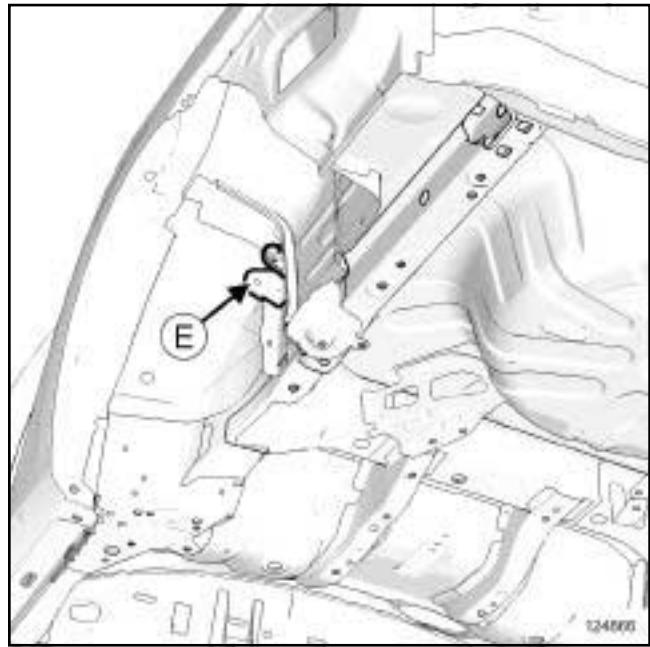
124865

The jig rests under the rear side member and is centred in the square hole (J) .

It should be used with the mechanical components in place to realign a rear side member.

It is used with the mechanical components removed, under the same conditions, to replace the complete rear side member.

11 - inner rear wheel arch



124866

The jig is centred in the rear shock absorber mounting yoke and is centred in the mounting hole (E) .

Use it when replacing the rear wheel arch.

Note:

For standardisation purposes, the Parts Department only supplies one body type.

On vehicles equipped with **F4R**, **M9R**, **V4Y** and **V9X** engines, it is necessary to carry out adaptation operations.

ADAPTATION

D91, and F4R or M9R

Adapt the front side member: (see **Front side member: Conversion**) .



V4Y or V9X

Adapt the centre floor side section: (see **41B, Centre lower structure, Centre floor, side section: Description**, page **41B-1**) .



Note:

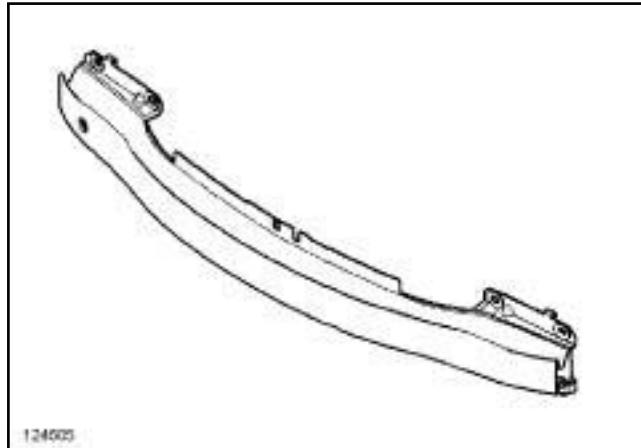
The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400**.

DESIGN OF THE STRUCTURAL COMPONENT



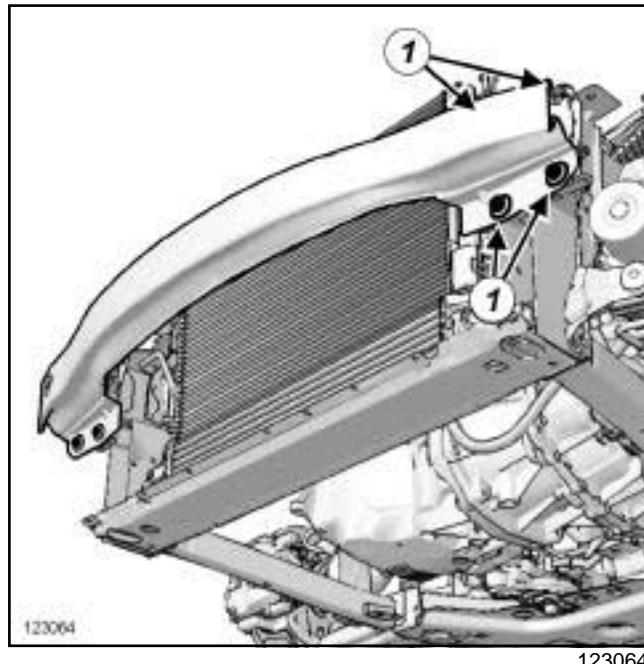
124605

The special features of this type of part is that it is bolted onto the front side member ends, it does not have any impact absorber units, and it is made of aluminium.

REMOVAL**I - REMOVAL PREPARATION OPERATION**

Remove:

- the front wheel arch liners (see **Front wheel arch liner: Removal - Refitting**) (MR 416, 55A, Exterior protection),
- the front bumper (see **Front bumper: Removal - Refitting**) (MR 416, 55A, Exterior protection),
- the headlights (see **Headlight: Removal - Refitting**) (MR 415, 80B, Headlights),
- the front of the vehicle (see **42A, Front upper structure, Front end panel: Removal - Refitting**, page **42A-16**).

II - OPERATION FOR REMOVAL OF PART CONCERNED

Remove:

- the bolts (1) ,
- the front impact cross member,

REFITTING**I - REFITTING OPERATION FOR PART CONCERNED**

Refit:

- the front impact cross member,
- the bolts (1) .

II - FINAL OPERATION.

Refit:

- the front panel (see **42A, Front upper structure, Front end panel: Removal - Refitting**, page **42A-16**),
- the headlights (see **Headlight: Removal - Refitting**) (MR 415, 80B, Headlights),
- the front bumper (see **Front bumper: Removal - Refitting**) (MR 416, 55A, Exterior protection),
- the front wheel arch liners (see **Front wheel arch liner: Removal - Refitting**) (MR 416, 55A, Exterior protection).

Note:

the information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400**.

DESIGN OF THE STRUCTURAL COMPONENT



124581

124581

This is a basic part; its only function is that of a front end side cross member.

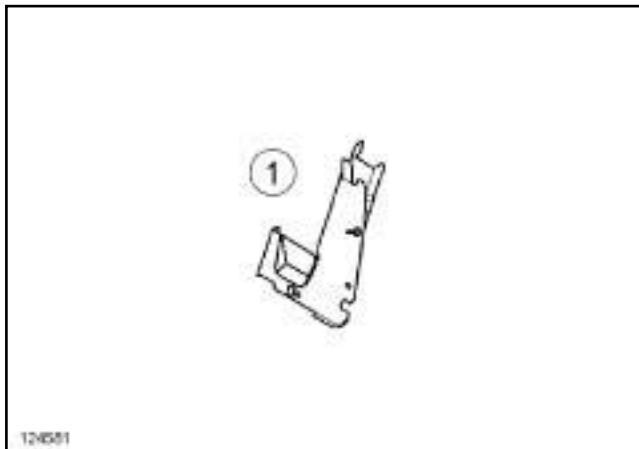
WARNING

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**).

There is only one way of replacing this part:

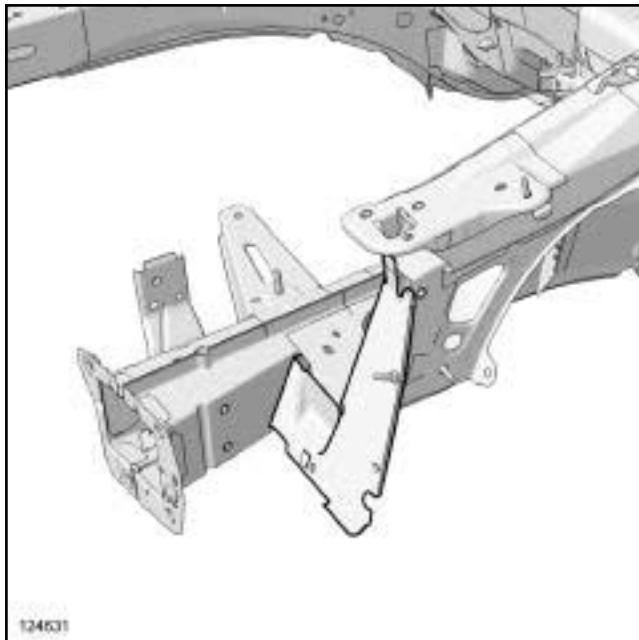
- complete replacement.

I - COMPOSITION OF THE SPARE PART



No.	Description	Type	Thickness (mm)
(1)	Front end side cross member	HEL	1.2

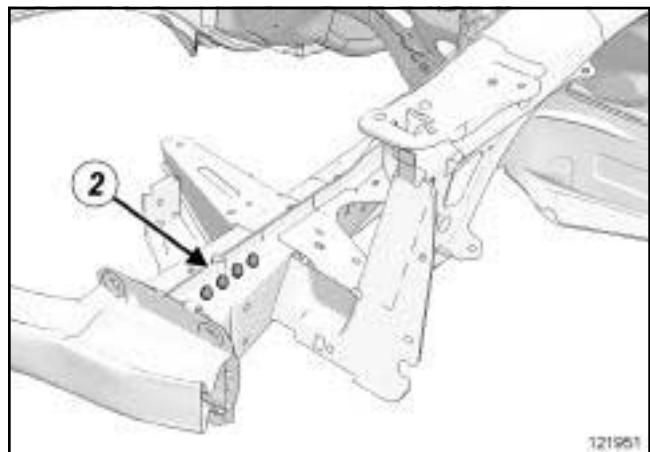
II - PART IN POSITION



Note:

For a detailed description of welded connections, see **MR 400**.

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



WARNING

To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

The earth of the welding machine must be placed as close as possible to the weld area (see **MR 400**).

FRONT LOWER STRUCTURE

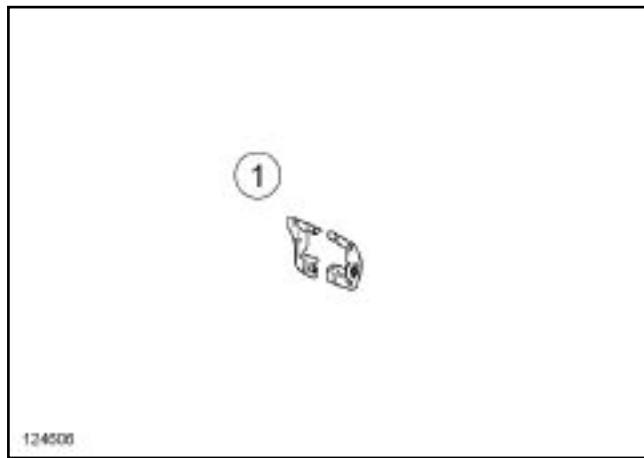
Front end cross member mounting reinforcement: Description

41A

There is only one way of replacing this part:

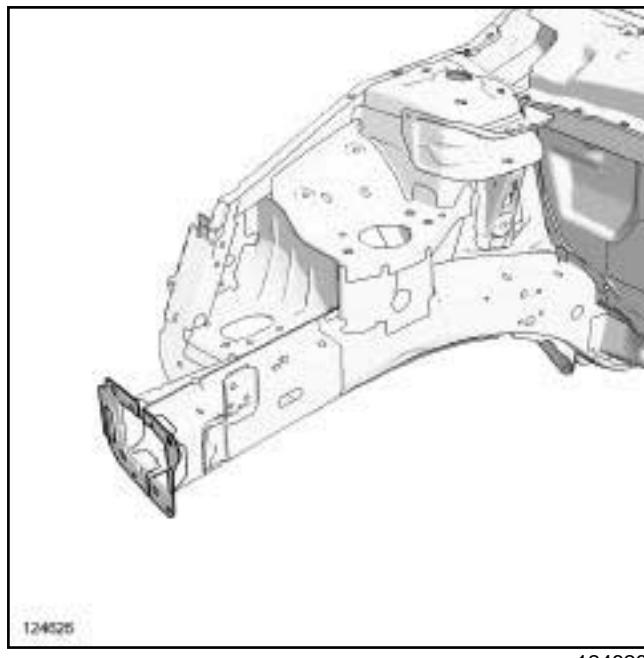
- complete replacement.

I - COMPOSITION OF THE SPARE PART



No.	Description	Type	Thickness (mm)
(1)	Front end cross member mounting stiffener	HEL	1.5

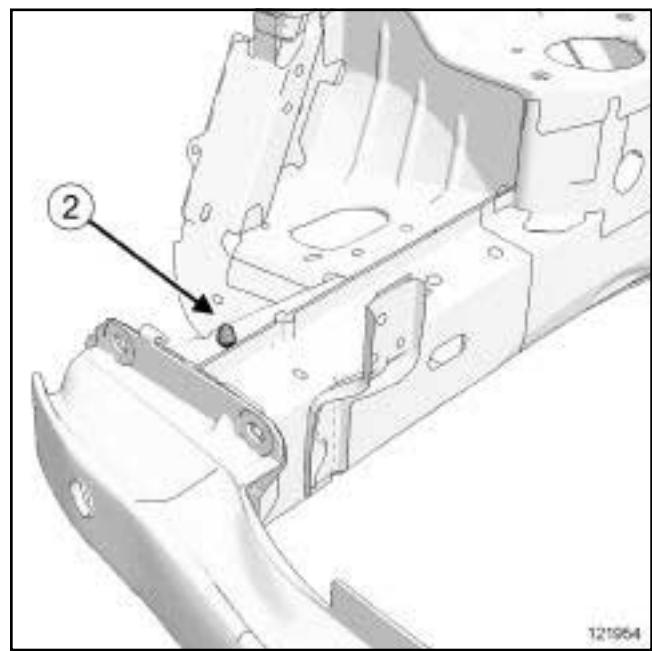
II - PART IN POSITION



Note:

For a detailed description of welded connections, see **MR 400**.

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



WARNING

To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

The earth of the welding machine must be placed as close as possible to the weld area (see **MR 400**).

Note:

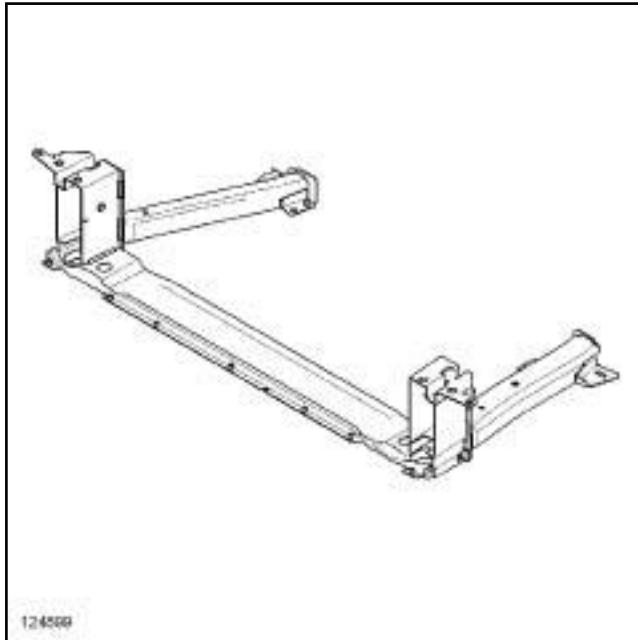
The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading this general information, check that there are no special notes associated with this vehicle. These special notes will be specified if applicable in other parts of this subsection dealing with the part.

Note:

For a detailed description of a particular connection, see **MR 400**.

DESIGN OF THE STRUCTURAL COMPONENT



124599

This aluminium part, which bolts onto the front axle subframe and onto the ends of the front side members, combines two functions:

- subframe extension and impact absorber,
- radiator support.

Tightening torques 

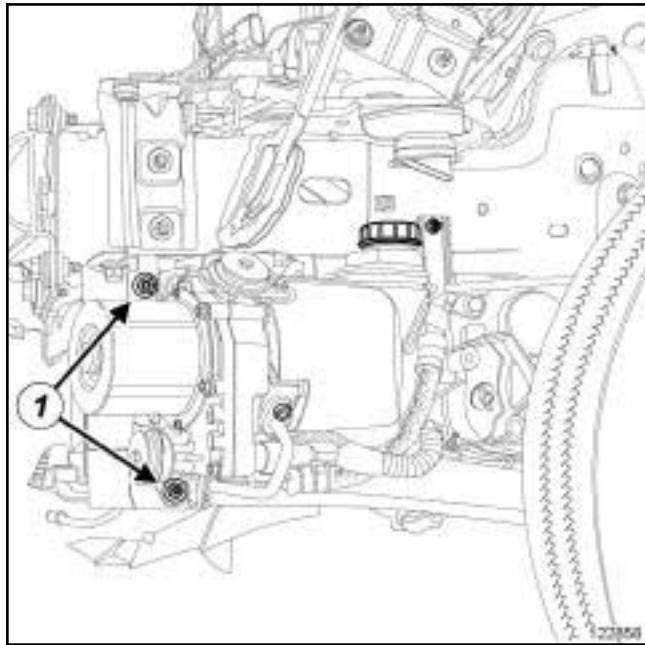
electric vacuum pump mounting bolts	21 N.m
--	--------

REMOVAL**I - REMOVAL PREPARATION OPERATION**

- Disconnect the battery (see **Battery: Removal - Refitting**) (MR 415, 80A, Battery).
- Remove:
 - the engine undertray bolts,
 - the engine undertray,
 - the front wheel arch liners (see **Front wheel arch liner: Removal - Refitting**) (MR 416, 55A, Exterior protection),
 - the front bumper (see **Front bumper: Removal - Refitting**) (MR 416, 55A, Exterior protection).

K9K or M9R

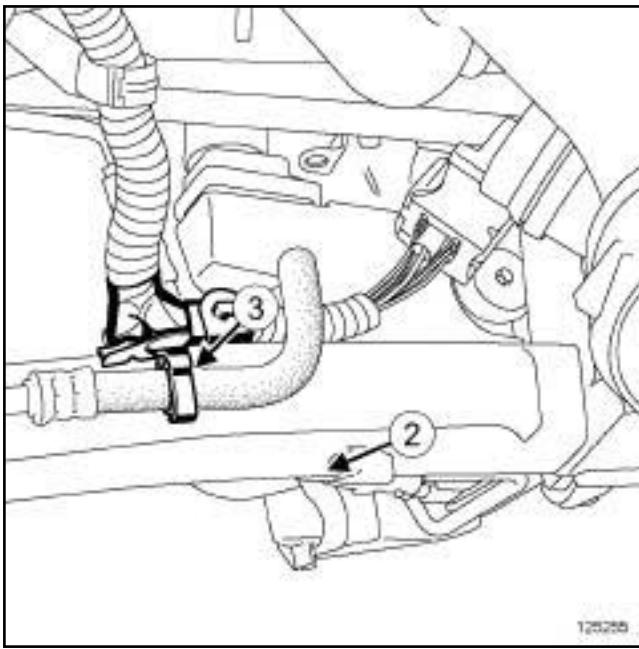
- Remove the pre-postheating unit (see **Pre-postheating unit: Removal - Refitting**) (MR 415, 13C, Preheating).

K9K or M4R or M9R, and 742

122858

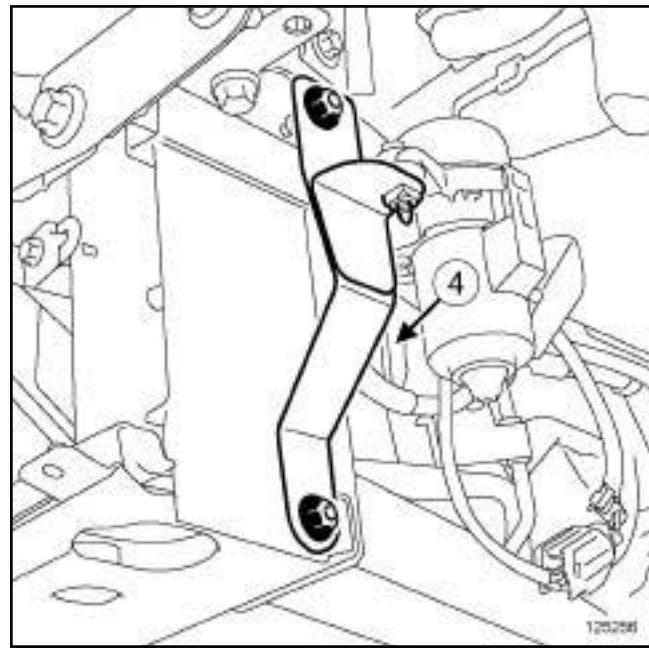
- Remove the two bolts (1) from the pump assembly mounting.

K9K or M4R or M9R, and 742



- Remove:
 - the bolt (2) from the pump assembly return pipe mounting,
 - the mounting from the pump assembly return pipe.
- Unclip the return pipe (3) from the radiator mounting cross member pump assembly.

F4R



- Remove the two bolts (4) from the electric vacuum pump mounting.

II - OPERATION FOR REMOVAL OF PART CONCERNED

- Attach the cooling system to the engine and transmission assembly.

REFITTING

I - REFITTING PREPARATION OPERATION

- Refit the radiator elastic studs.

II - REFITTING OPERATION FOR PART CONCERNED

- Refit:

- the radiator mounting cross member,
- the radiator mounting cross member bolts,
- the radiator mounting cross member tie-rod bolts.

- Tighten:

- the radiator mounting cross member bolts,
- the radiator mounting cross member tie-rod bolts.

- Remove the cooling system from the engine and transmission assembly.

- Refit the cooling system in the elastic studs.

III - FINAL OPERATION.

F4R

- Refit the bolts on the electric vacuum pump mounting.

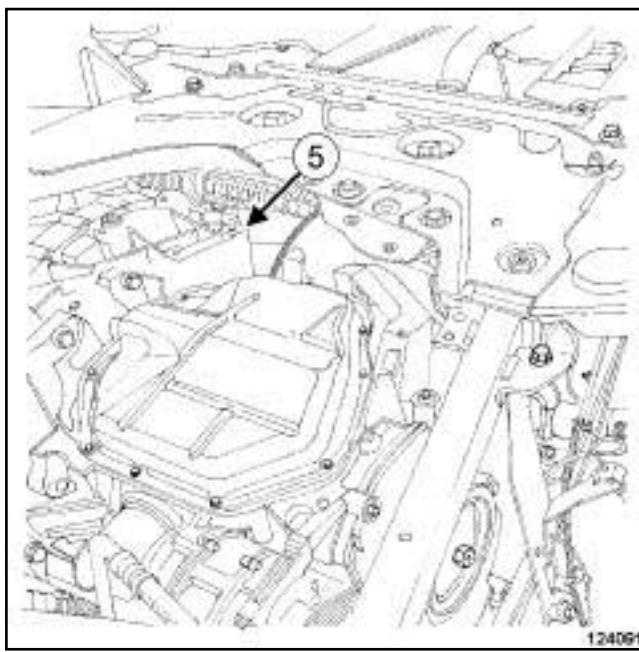
- Torque tighten the **electric vacuum pump mounting bolts (21 N.m)**.

K9K or M4R or M9R, and 742

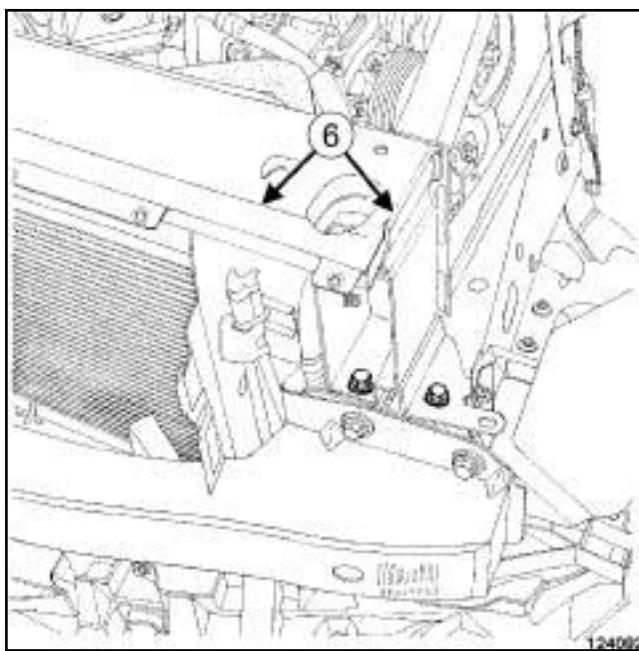
- Refit:

- the pump assembly return pipe mounting,
- the pump assembly return pipe mounting bolt.

- Clip the pump assembly return pipe onto the radiator mounting cross member.

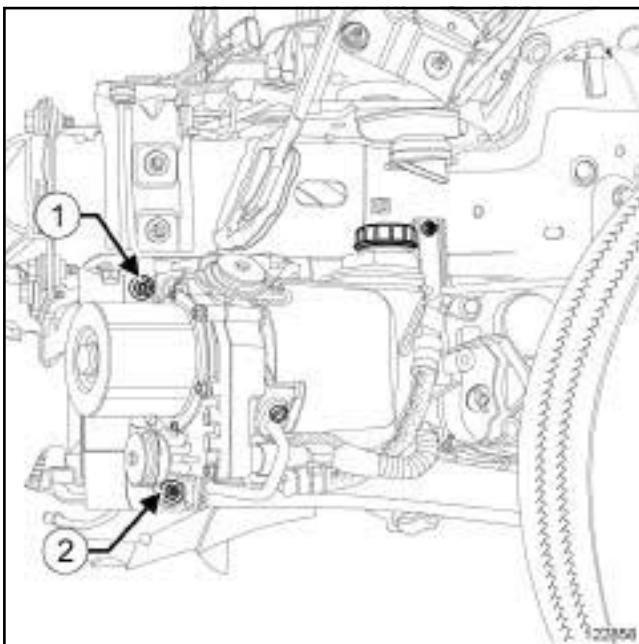


- Remove the radiator mounting cross member tie-rod bolts (5) .



- Remove:
- the radiator mounting cross member bolts (6) ,
 - the radiator mounting cross member,
 - the radiator elastic studs when replacing the radiator mounting cross member.

K9K or M4R or M9R, and 742



122858

- Remove the two bolts from the pump assembly mounting.
 - Tighten in order the pump assembly mounting bolts.
-

K9K or M9R

- Refit the pre-postheating unit (see **Pre-postheating unit: Removal - Refitting**) (MR 415, 13C, Preheating).
-

- Refit:

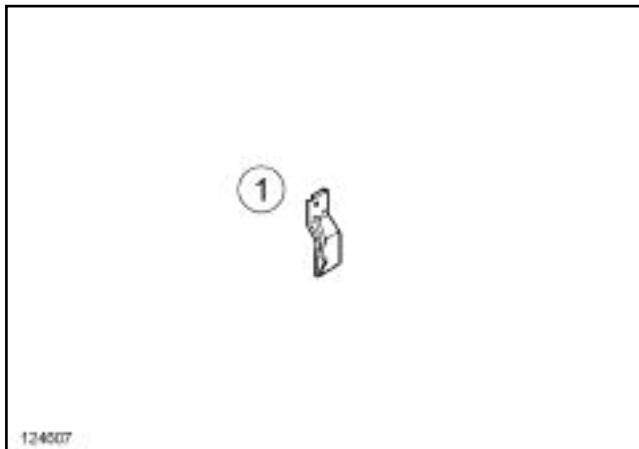
- the front bumper (see **Front bumper: Removal - Refitting**) (MR 416, 55A, Exterior protection),
- the front wheel arch liners (see **Front wheel arch liner: Removal - Refitting**) (MR 416, 55A, Exterior protection),
- the engine undertray,
- the engine undertray bolts.

- Tighten the engine undertray bolts.
 - Connect the battery (see **Battery: Removal - Refitting**) (MR 415, 80A, Battery).
-

There is only one way of replacing this part:

- complete replacement.

I - COMPOSITION OF THE SPARE PART

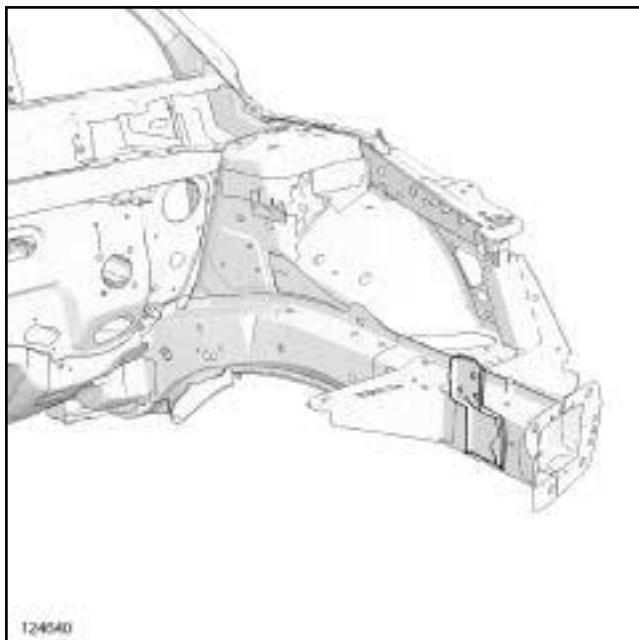


124607

124607

No.	Description	Type	Thickness (mm)
(1)	Facade mounting support .	HEL	1.5

II - PART FITTED



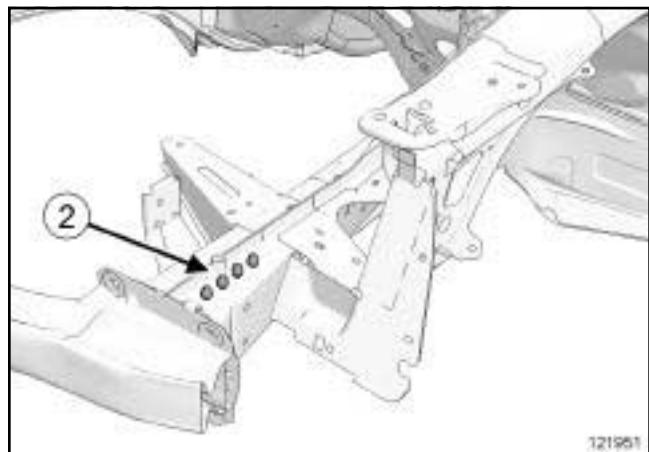
124640

124640

Note:

For a detailed description of welded connections,
see **MR 400**.

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



121951

121951

WARNING

To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

The earth of the welding machine must be placed as close as possible to the weld area (see **MR 400**).

IMPORTANT

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

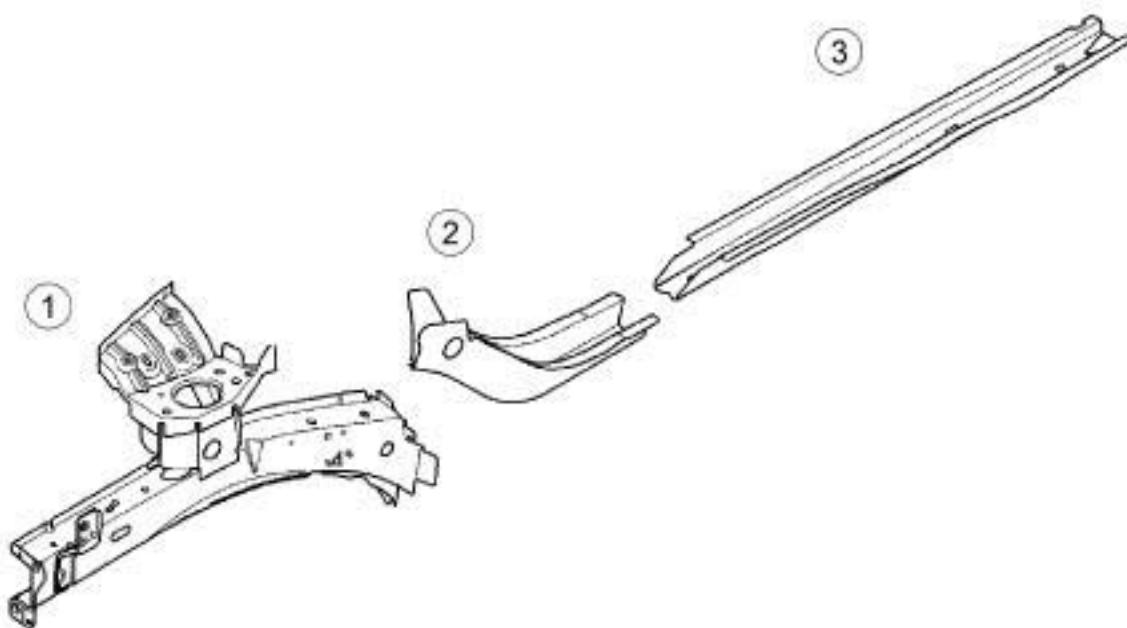
Note:

For a detailed description of a particular connection, see **MR 400**.

Note:

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

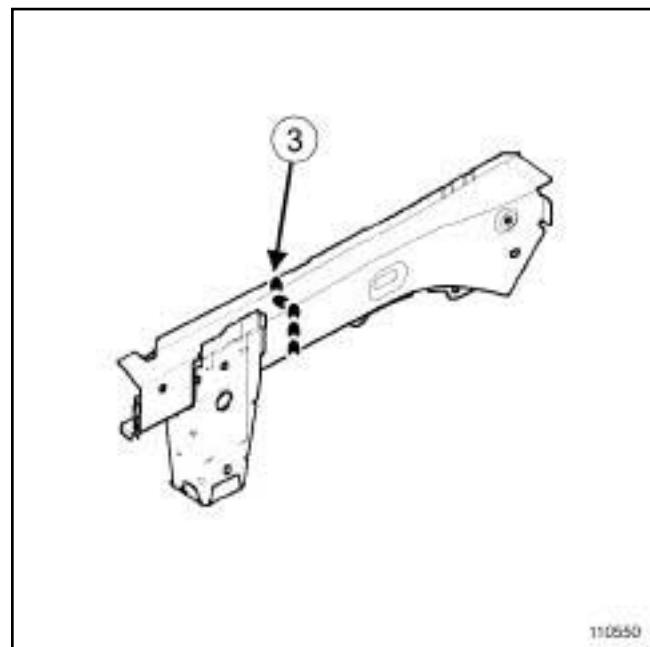
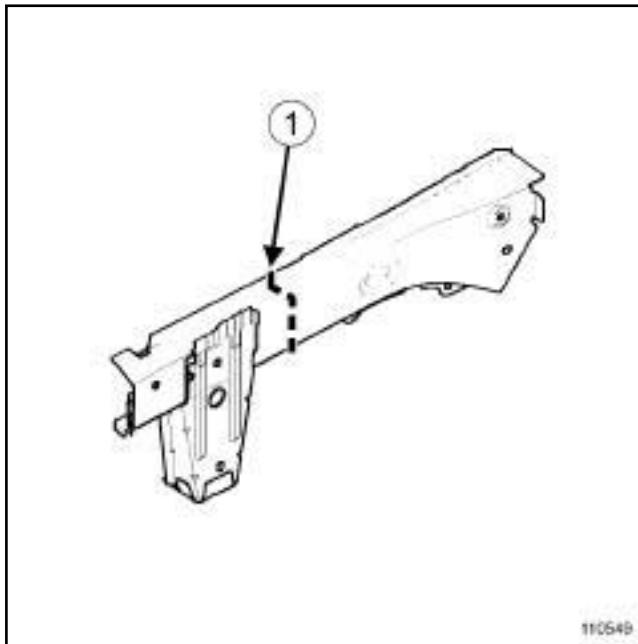
I - DESIGN OF THE STRUCTURAL COMPONENT

124608

124608

The special features of this part are that it combines the functions of front side member front section (1), front side member centre section (2), front side member rear section (3) and that it is made of two panels with different thicknesses and materials.

II - AREA TO BE CUT FOR PARTIAL REPLACEMENT



Line (3) on the drawing shows a butt weld by continuous EGW welding.

Cut 1:

This line marks the place in which it is possible to make a partial replacement.

This operation allows you to access the inside of the hollow section of the structural element to straighten it.

Note:

For the partial replacement of parts constituting a single structural component, it is essential to stagger the welds of each of the components.

In this case, the side member weld line must be staggered from that of its closure panel.

III - ASSEMBLY METHOD FOR A PARTIAL REPLACEMENT

Only the connections which are specific to the partial replacement by cutting are indicated.

WARNING

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**).

If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400**).



124611

124611

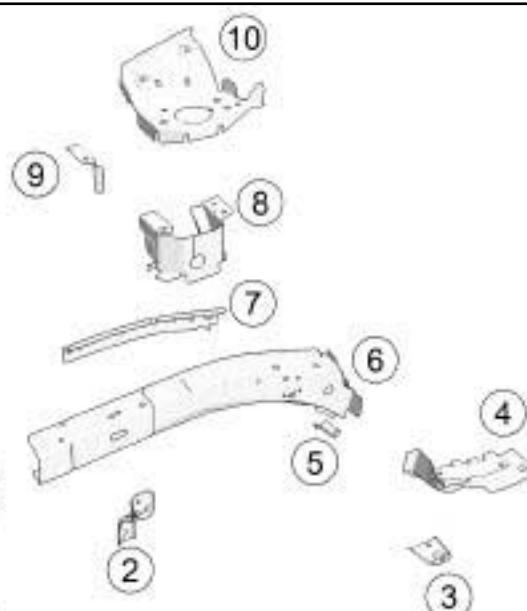
The options for replacing this part are as follows:

- partial replacement of front end section,
- partial replacement of the front section,
- complete replacement.

IMPORTANT

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

No.	Description	Type	Thickness (mm)
(1)	Inner mounting plate of the unit	HLE	1.5
(2)	Lower section cross member mounting	HLE	1.5
(3)	Rear mounting reinforcement of the sub frame	HLE	1.97
(4)	Front sub-frame rear mounting unit	HLE	1.47
(5)	Subframe mounting spacer		2.5
(6)	Front side member front section	HLE/ THLE	1.77 / 1.8
(7)	Front side member reinforcement	VHEL	2
(8)	Engine mounting lower section	HLE	1.5
(9)	Engine mounting reinforcement	HLE	2.5
(10)	Engine mounting upper section	HLE	2

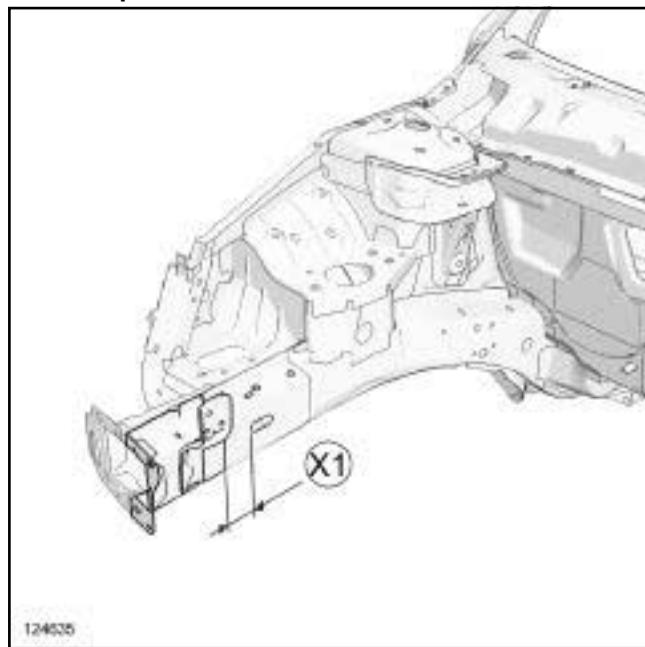
I - COMPOSITION OF THE SPARE PART

124636

124636

II - PART FITTED

Partial replacement of the front end section



124635

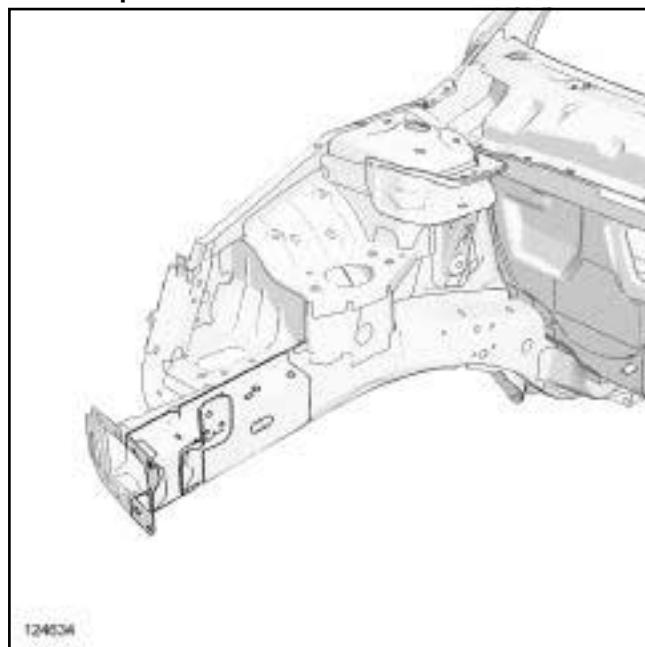
124635

(X1) = 50 mm.

WARNING

To maintain the mechanical properties of the vehicle, the position of the cut must be observed. It is determined by the mechanical component mounting points.

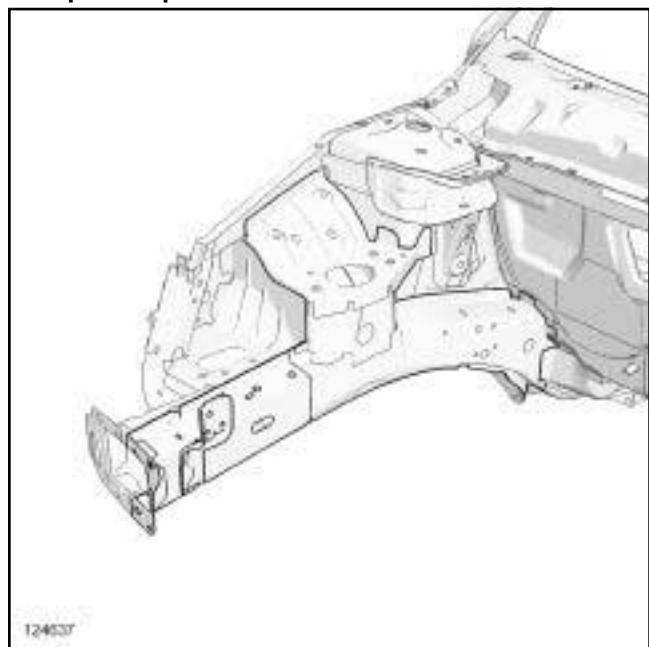
Partial replacement of the front section



124634

124634

Complete replacement



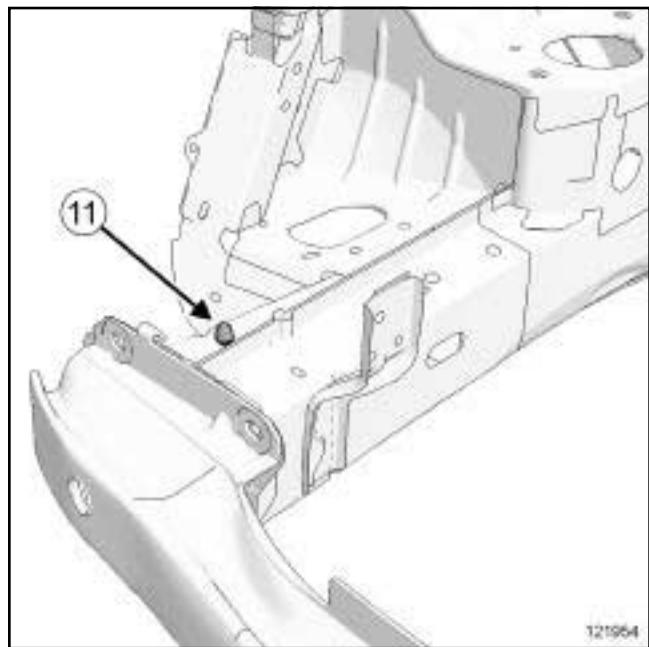
124637

124637

Note:

For a description of the welded connections, see **MR 400**.

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



121954

121954

WARNING

To avoid damaging the vehicle's electrical and electronic components, disconnect the earths of any wiring near the weld area.

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

FRONT LOWER STRUCTURE

Front side member closure panel, front section: General description

41A

IMPORTANT

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

Note:

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400**.

I - DESIGN OF THE STRUCTURAL COMPONENT



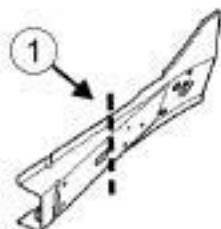
122749
122749

This is a basic part; its only function is that of front side member closure panel, front section.

II - AREA TO BE CUT FOR PARTIAL REPLACEMENT

Note:

For the partial replacement of parts constituting a single structural component, it is essential to stagger the welds of each of the components.



122750
122750

Cut 1:

This line shows the centre of the area in which it is possible to carry out a partial replacement.

This operation allows you to access the inside of the hollow section of the structural component to straighten it.

III - ASSEMBLY INSTRUCTIONS FOR A PARTIAL REPLACEMENT

In this case, the side member weld line must be staggered from that of its closure panel.

Note:

For the partial replacement of parts constituting a single structural component, it is essential to stagger the welds of each of the components.

Only the connections which are specific to the partial replacement by cutting are indicated.

FRONT LOWER STRUCTURE

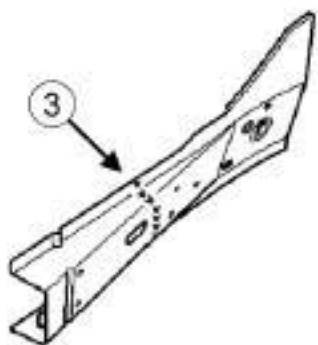
Front side member closure panel, front section: General description

41A

WARNING

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**).

If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400**).



122751

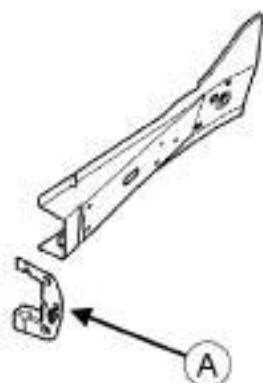
122751

Line (3) on the drawing shows a butt weld by continuous EGW welding.

FRONT LOWER STRUCTURE

Front side member closure panel, front section: Description

41A



122755
122755

To replace this part, also order the unit mounting outer plate (A) .

The options for replacing this part are as follows:

- front section replacement,
- complete replacement.

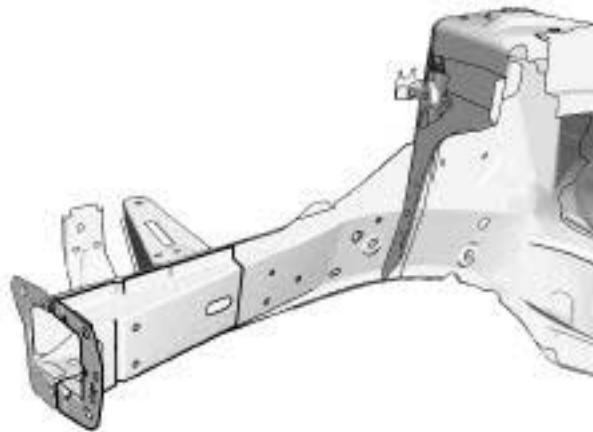
IMPORTANT

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

No.	Description	Type	Thickness (mm)
(1)	Front section of front side member closure panel	HEL	1.67/2.2

II - PART IN POSITION

1 - Front section replacement



122463
122463

I - COMPOSITION OF THE SPARE PART



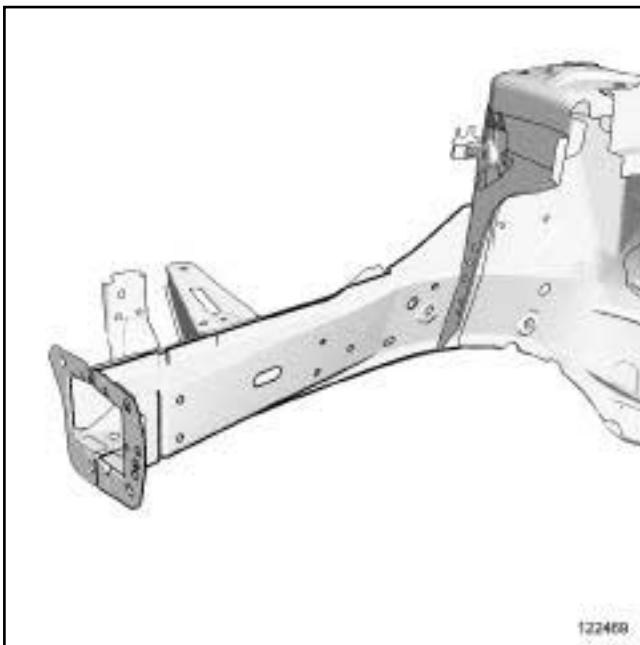
122748
122749

FRONT LOWER STRUCTURE

Front side member closure panel, front section: Description

41A

2 - Complete replacement



122468
122469

WARNING

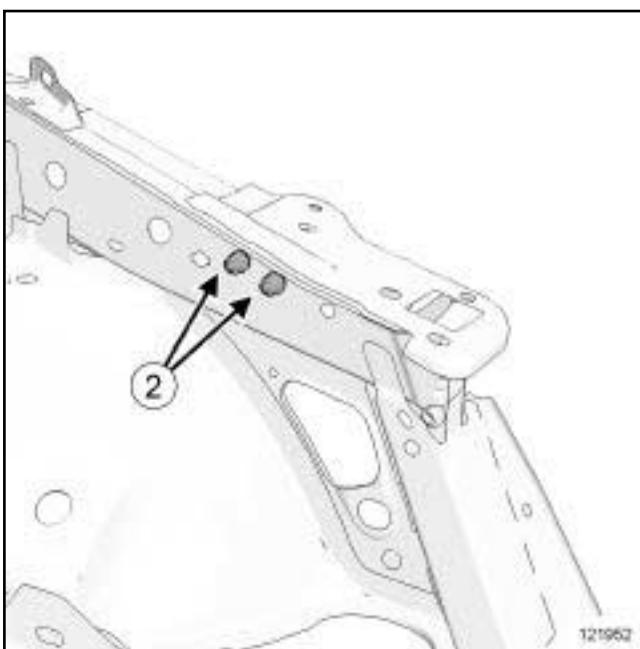
To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

The earth of the welding machine must be placed as close as possible to the weld area (MR 400).

Note:

For a detailed description of welded connections, see **MR 400**.

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



121952

IMPORTANT

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

Note:

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400**.

DESIGN OF THE STRUCTURAL COMPONENT



124612

124612

This is a basic part; its only function is that of front side member, centre section.

WARNING

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**).

There is only one way of replacing this part:

- complete replacement.

IMPORTANT

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

I - COMPOSITION OF THE SPARE PART

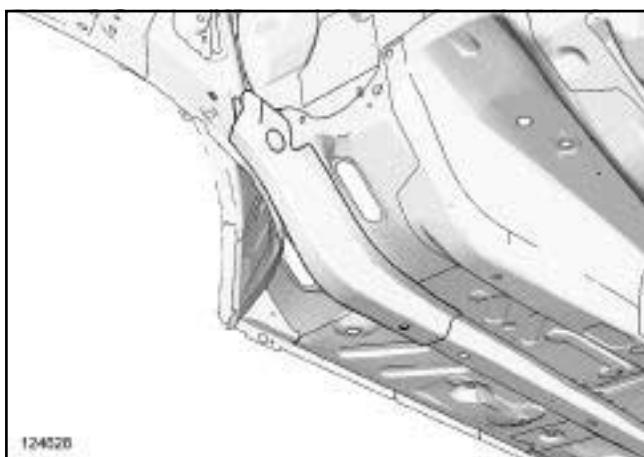


124612

124612

No.	Description	Type	Thickness (mm)
(1)	Front side member centre section	Very high yield strength	4

II - PART FITTED



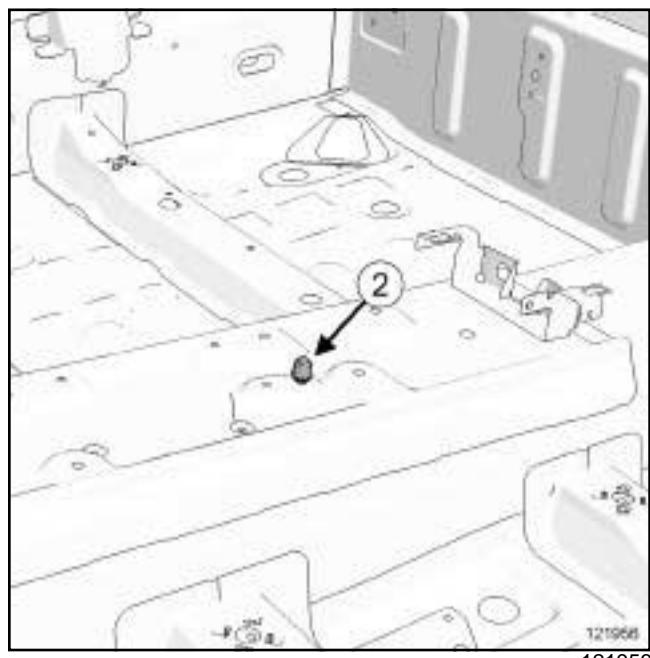
124620

124628

Note:

For a detailed description of welded connections, see **MR 400**.

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



121956

WARNING

To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

The earth of the welding machine must be placed as close as possible to the weld area (see **MR 400**).

FRONT LOWER STRUCTURE

Front side member, rear section: Description

41A

There is only one way of replacing this part:

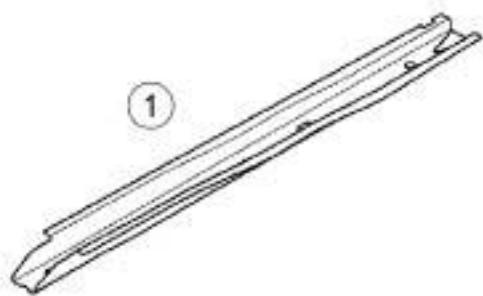
- complete replacement.

IMPORTANT

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

I - COMPOSITION OF THE SPARE PART

B91 or K91



124613

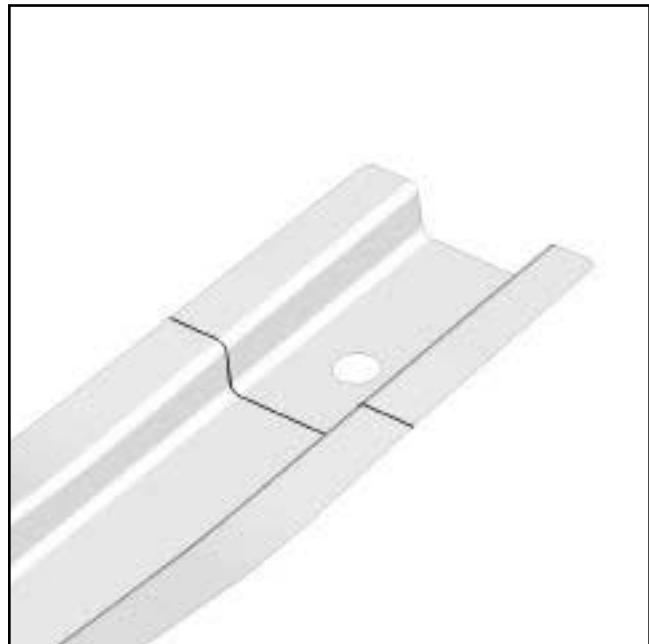
124613

No.	Description	Type	Thickness (mm)
(1)	Front side member rear part	UHLE	1.7

No.	Description	Type	Thickness (mm)
(1)	Front side member rear part	UHLE	1.7

Adaptation of the replacement part

Part cutting at A

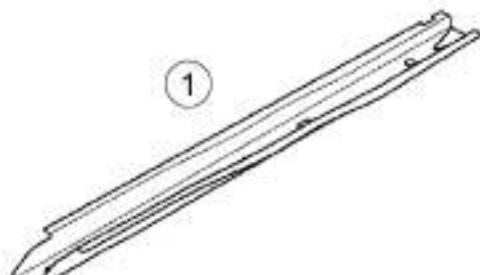


134782

Note:

The Parts Department only supplies part B91 and K91 which must be cut again to the correct length.

D91



124613

124613

II - PART IN POSITION

B91 or K91



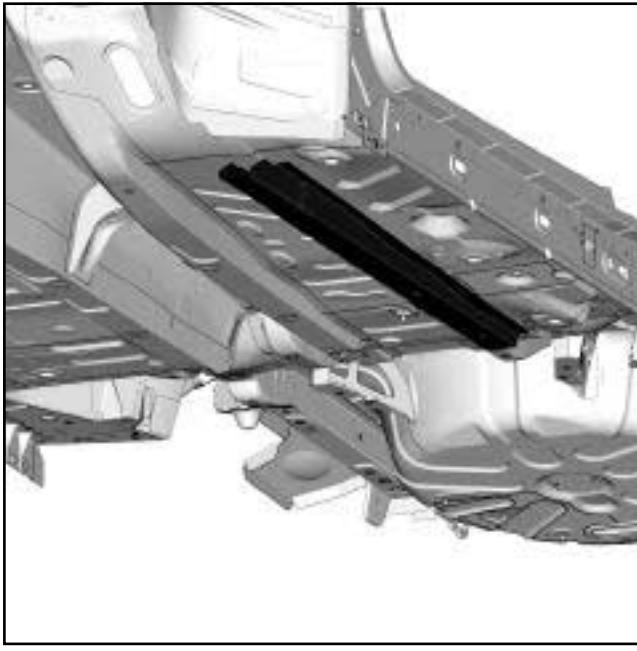
Note:

For a detailed description of welded connections, see **MR 400**.

Note:

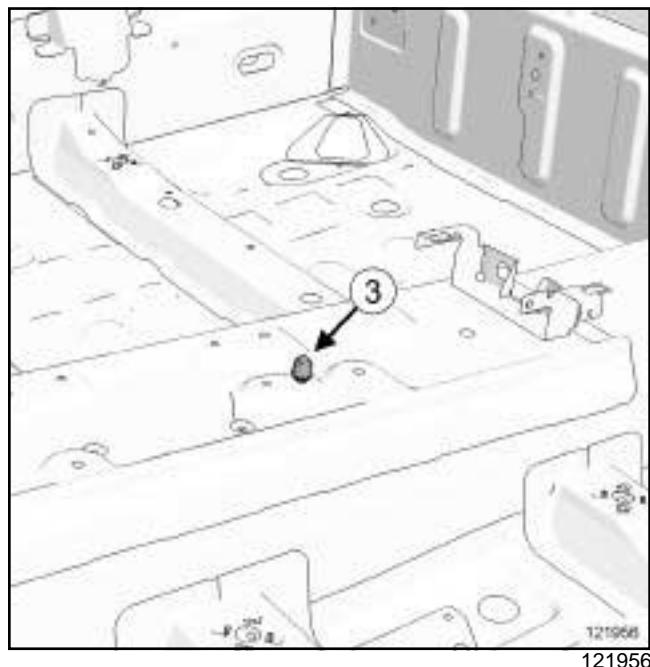
For a detailed description of welded connections, see **MR 400**.

D91



III - POSITIONING OF LOCAL ELECTRICAL EARTHS

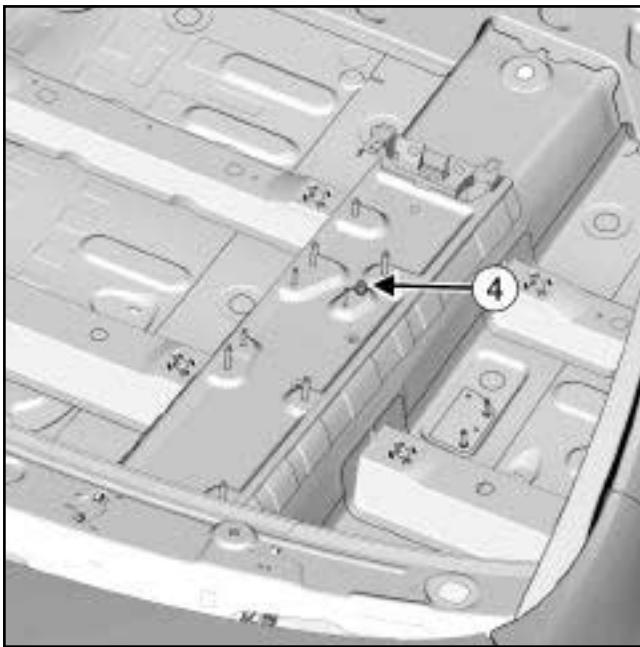
B91 or K91

**WARNING**

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 closely as possible to the weld area (see **MR 400**).

D91



134783

WARNING

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 closely as possible to the weld area (see **MR 400**).

FRONT LOWER STRUCTURE

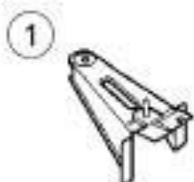
Battery tray bracket: Description

41A

There is only one way of replacing this part:

- complete replacement.

I - COMPOSITION OF THE SPARE PART

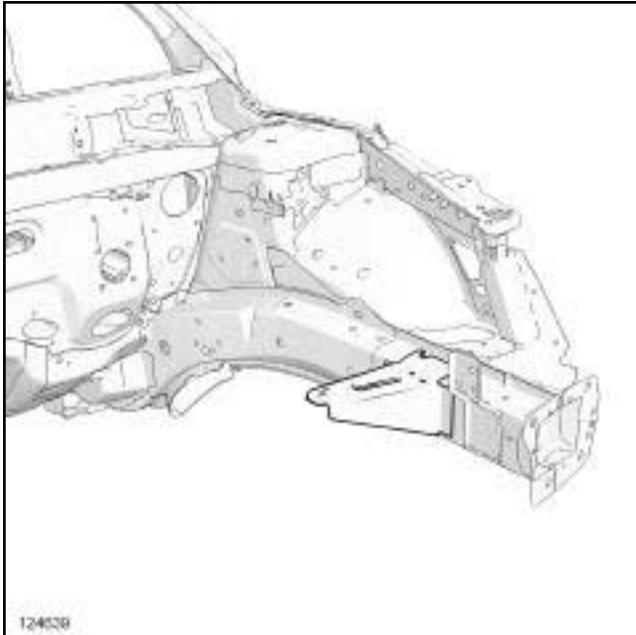


124614

124614

No.	Description	Type	Thickness (mm)
(1)	Battery tray support	Mild steel	2

II - PART IN POSITION



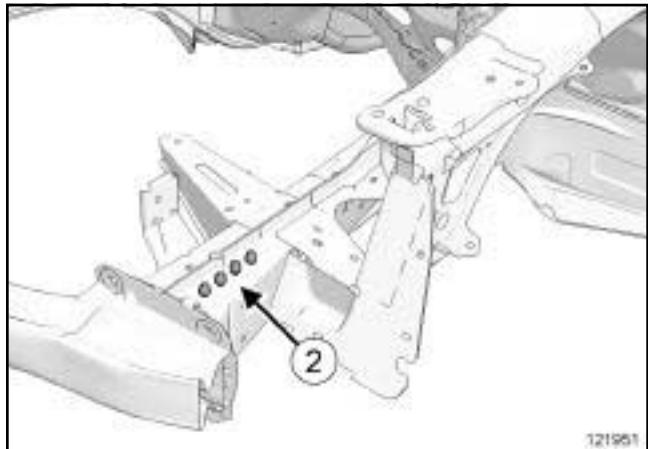
124639

124639

Note:

For a detailed description of welded connections,
see **MR 400**.

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



121951

121951

WARNING

To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

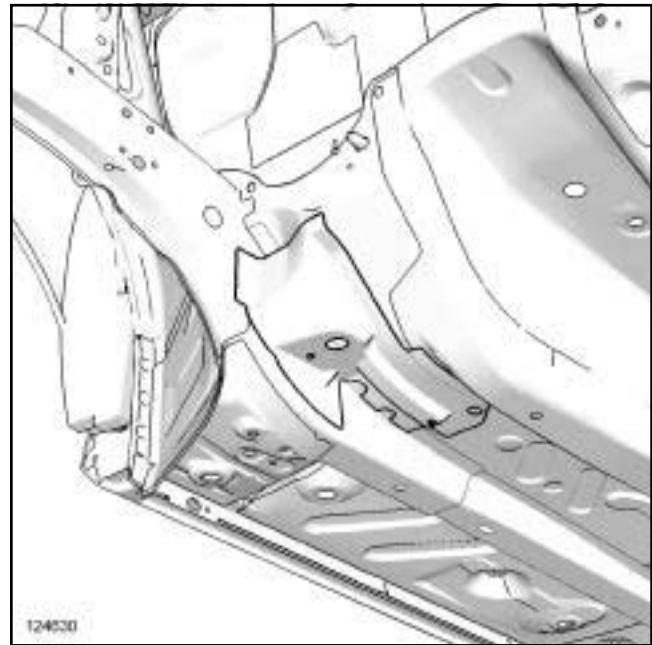
The earth of the welding machine must be placed as close as possible to the weld area (see **MR 400**).



124615

124615

No.	Description	Type	Thickness (mm)
(1)	Front sub-frame rear mounting unit	HEL	1.47
(2)	Rear subframe mounting reinforcement	HEL	1.97

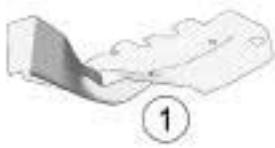
II - PART IN POSITION

124630



124877

124877

**Note:**

For a detailed description of welded connections, see **MR 400**.

IMPORTANT

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

Note:

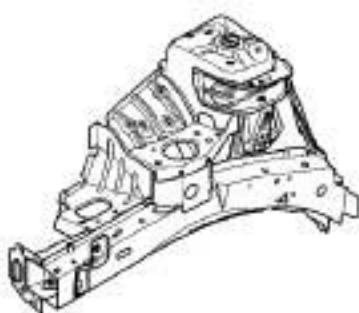
The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400**.

DESIGN OF THE STRUCTURAL COMPONENT



124618

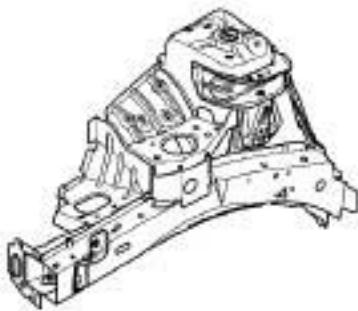
124618

The special feature of this type of part is that it combines the functions of front section of front side member, front wheel arch and front end side cross member, and is made up of several panels of different types and thicknesses.

FRONT LOWER STRUCTURE

Front half unit: Description

41A



124618

124618

There is only one way of replacing this part:

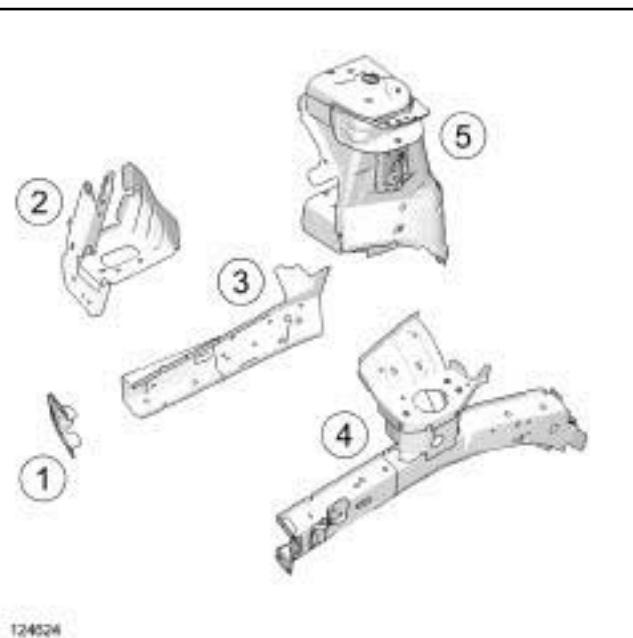
- complete replacement.

IMPORTANT

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

I - COMPOSITION OF THE SPARE PART

Left side

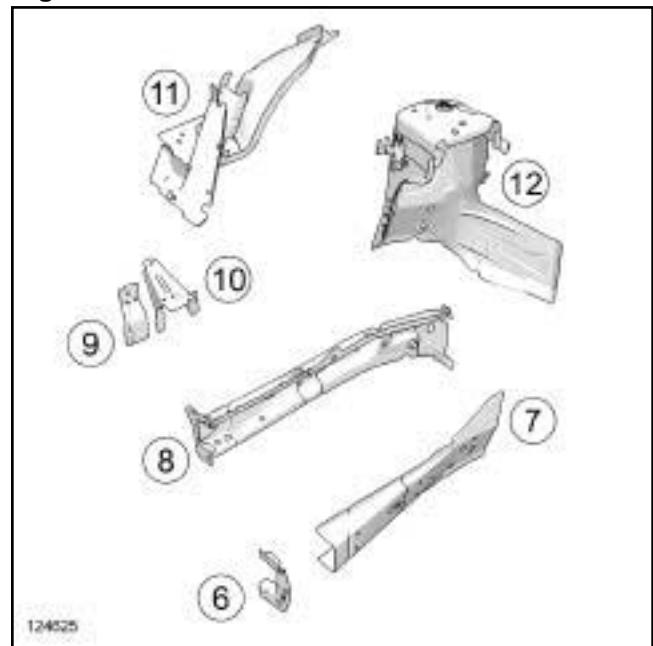


124624

124624

No.	Description	Type	Thickness (mm)
(1)	Front end cross member mounting stiffener	HLE	2.5
(2)	Front wheel arch, front section	Mild steel / High elastic limit	2 / 1.2
(3)	Front section of front side member closure panel	HLE	1.67 / 2.22
(4)	Front side member front section	Very High Elastic Limit / High Elastic Limit	1.5 / 2.5
(5)	Centre section of front wheel arch	Mild steel / High elastic limit	0.77 / 2

Right-hand side



124625

124625

FRONT LOWER STRUCTURE

Front half unit: Description

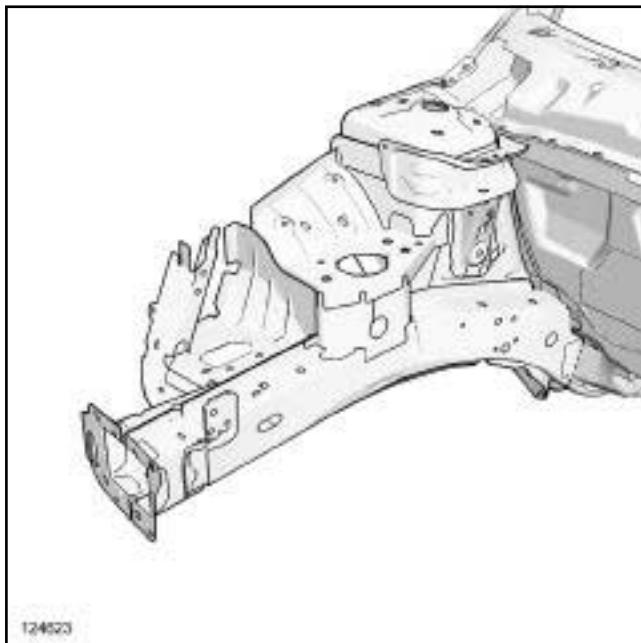
41A

No.	Description	Type	Thickness (mm)
(6)	Front end cross member mounting stiffener	HLE	2.5
(7)	Front section of front side member closure panel	HLE	1.67 / 2.2
(8)	Front side member front section	VHEL	1.77
(9)	Lower section of upper cross member mounting	HLE	1.5
(10)	Battery tray support	Mild steel	2
(11)	Front wheel arch, front section	Mild steel / High elastic limit	1.2/2
(12)	Centre section of front wheel arch	Mild steel / High elastic limit	0.77 / 2

Note:

For a detailed description of the welded connections, see **MR 400**.

II - PART IN POSITION



Note:

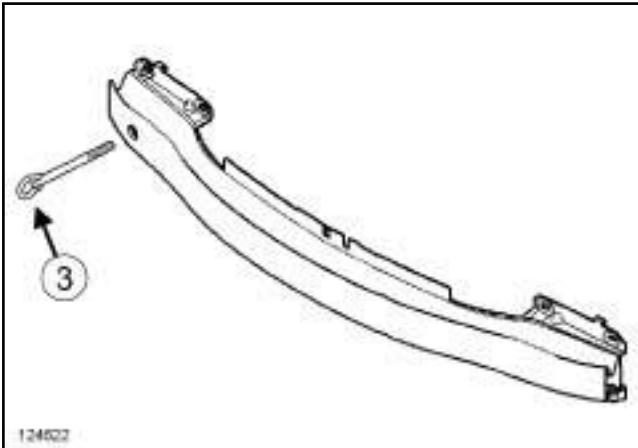
The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading this general information, check that there are no special notes associated with this vehicle. These special notes will be specified if applicable in other parts of this subsection dealing with the part.

Note:

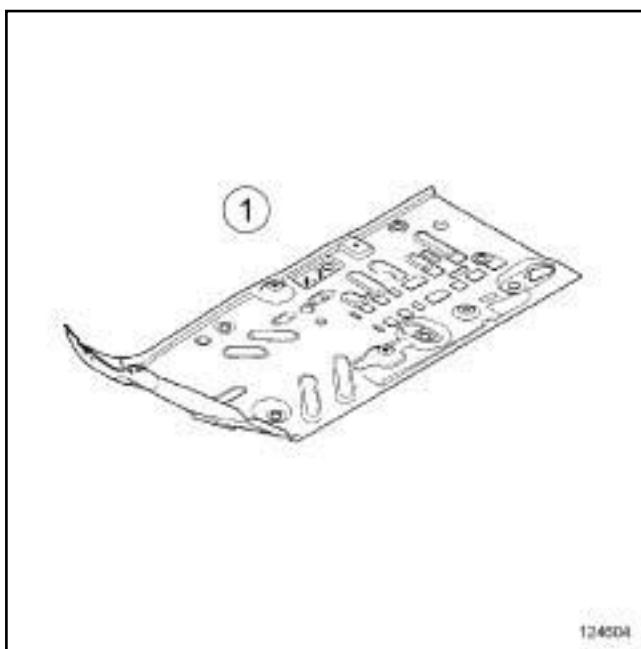
For a detailed description of a particular connection, see **MR 400**.

DESIGN OF THE STRUCTURAL COMPONENT



If the thread is damaged, the tow eye mounting cannot be replaced. Replace the front impact cross member. The threaded ring (3) is provided in the vehicle tool kit.

II - PART IN POSITION



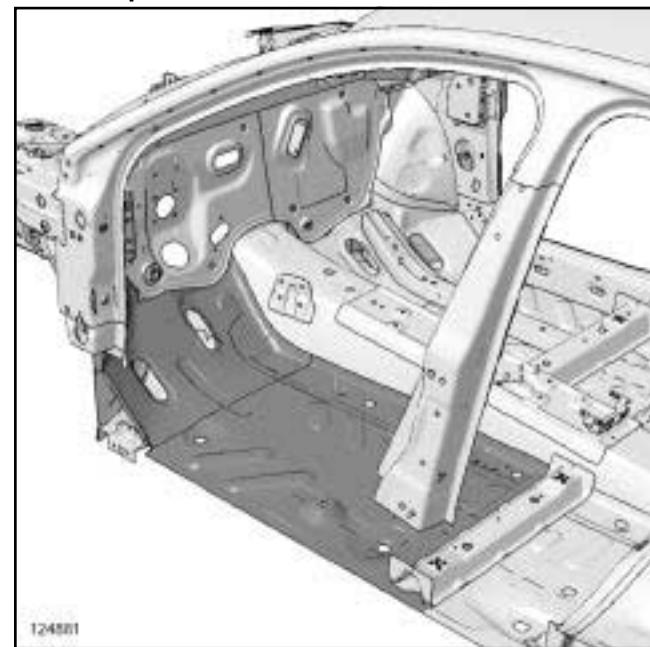
The options for replacing this part are as follows:

- partial replacement of the front section,
- partial replacement of the rear section.
- complete replacement

I - COMPOSITION OF THE SPARE PART

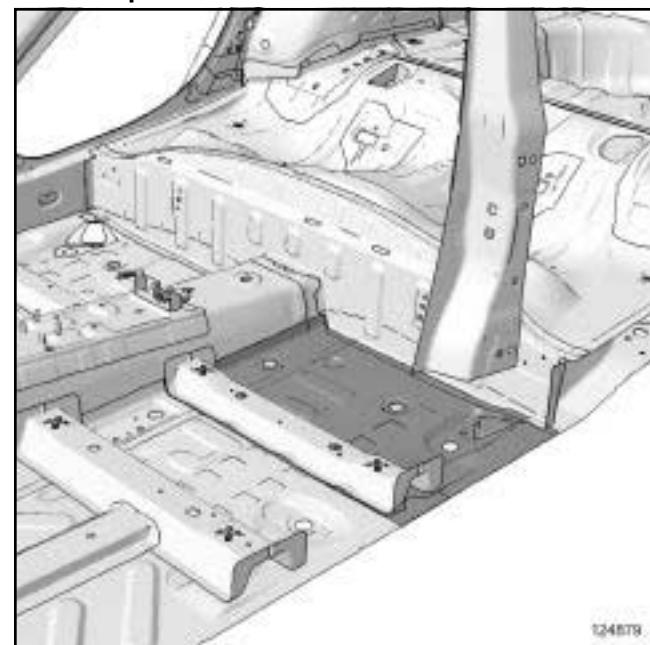
No.	Description	Type	Thick-ness (mm)
(1)	Centre floor, side section	Mild steel	0.97 / 0.67

Partial replacement of the front section



124881

Partial replacement of the rear section



124879

Note:

For a complete replacement, combine the two operations without making the partial cut

Note:

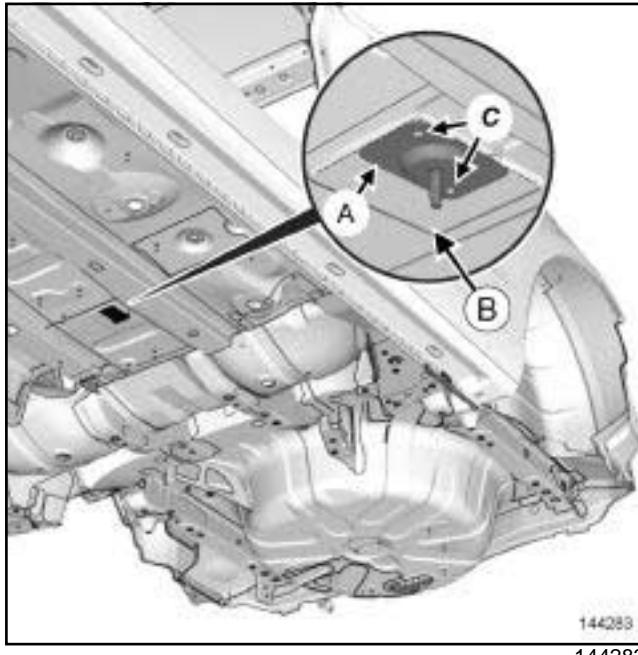
For a detailed description of welded connections, see **MR 400**.

V4Y or V9X

Note:

During partial or complete replacement of the rear section of the left-hand side floor, it is necessary to make two holes with a diameter of **5.2 mm** in order to fit the neck support using two steel rivets with a diameter of **4.8 mm**.

- neck support (part number: **767A00001R**).
- steel rivets (part number: **7703072305**).

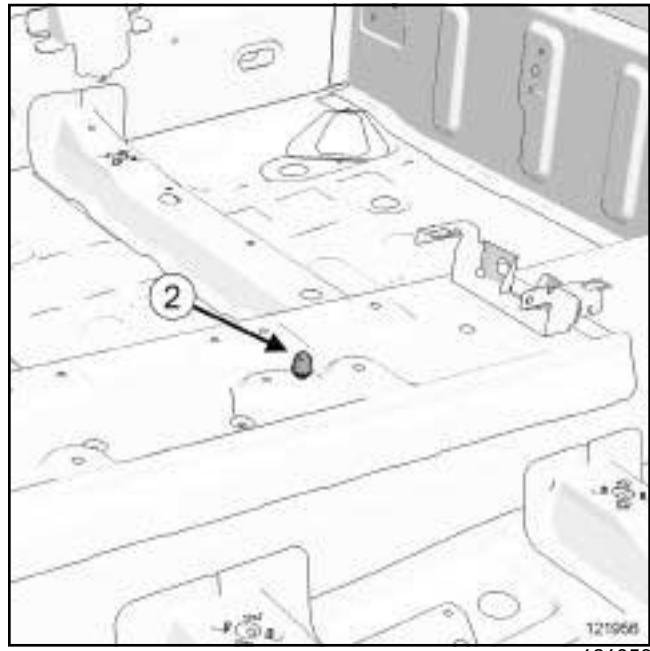


Put the neck support (**A**) in the position indicated in relation to the square boss (**B**).

Drill the 2 holes (**C**) using a **5 mm** drill bit.

Secure the neck support using the steel rivets.

III - POSITIONING OF LOCAL ELECTRICAL EARTHS

**WARNING**

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 closely as possible to the weld area (see **MR 400**).

IMPORTANT

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

Note:

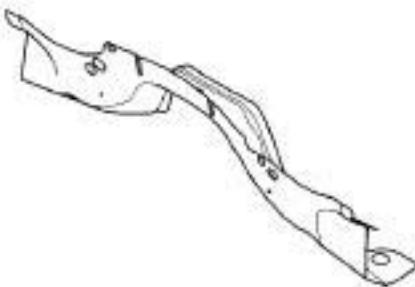
The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400**.

DESIGN OF THE STRUCTURAL COMPONENT



124586

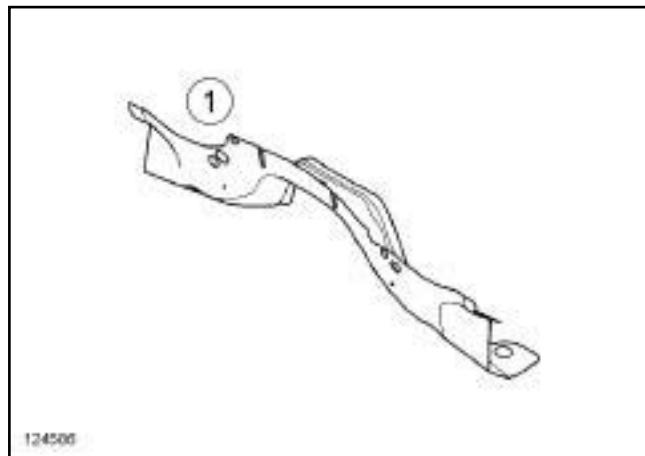
124586

This is a basic part; it functions only as a centre floor front cross member.

There is only one way of replacing this part:

- complete replacement.

I - COMPOSITION OF THE SPARE PART

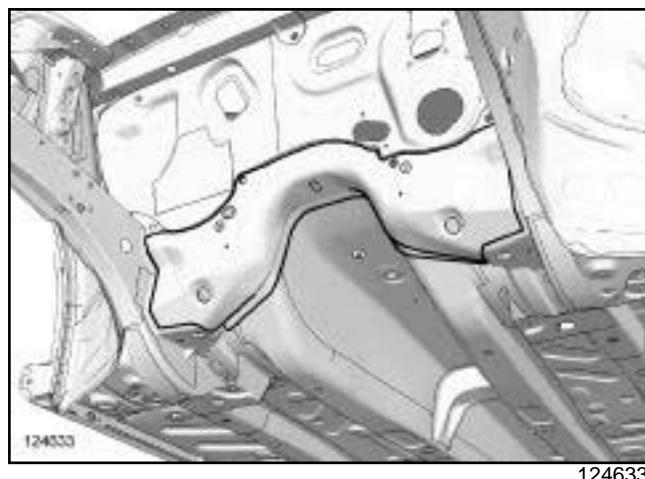


124500

124586

No.	Description	Type	Thickness (mm)
(1)	Central floor front cross member	Mild steel	1.17

II - PART FITTED



124633

124633

Note:

For a detailed description of welded connections,
see **MR 400**.

IMPORTANT

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

Note:

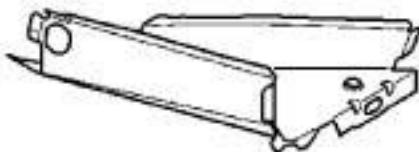
The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading this general information, check that there are no special notes associated with this vehicle. These special notes will be specified if applicable in other parts of this subsection dealing with the part.

Note:

For a detailed description of a particular connection, see **MR 400**.

I - DESIGN OF THE STRUCTURAL COMPONENT



120936

120936

This is a basic part; it only fulfills the function of a centre floor front side cross member.

There is no partial replacement for this part, the repair bench is not required.

There is only one way of replacing this part:

- complete replacement.

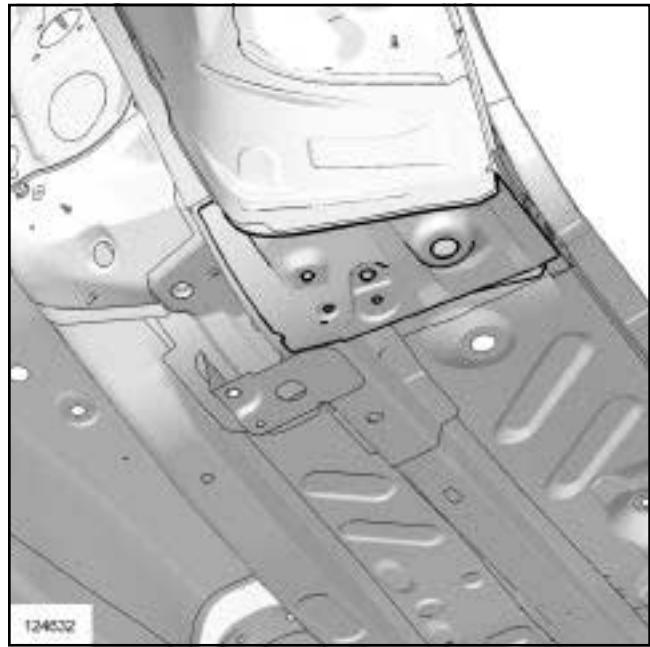
I - COMPOSITION OF THE SPARE PART



124580

124580

II - PART IN POSITION



124632

No.	Description	Type	Thickness (mm)
(1)	Centre floor front side cross member	HLE	1.77

Note:

For a detailed description of the welded connections, see **MR 400**.

IMPORTANT

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

Note:

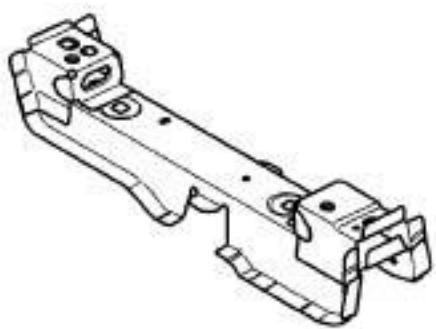
The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading this general information, check that there are no special notes associated with this vehicle. These special notes will be specified if applicable in other parts of this subsection dealing with the part.

Note:

For a detailed description of a particular connection, see **MR 400**.

DESIGN OF THE STRUCTURAL COMPONENT



110507

110507

This is a basic part; its function is to secure the front section of the front seat and to stiffen the bodywork in the event of a side impact.



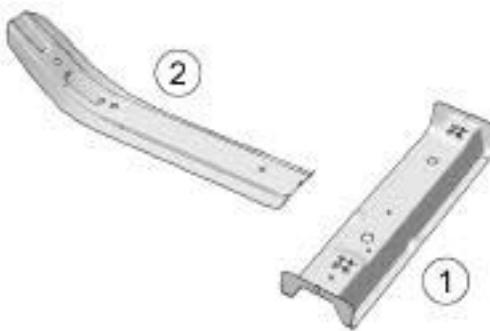
124603

124603

The options for replacing this part are as follows:

- front partial replacement,
- complete replacement.

I - COMPOSITION OF THE SPARE PART



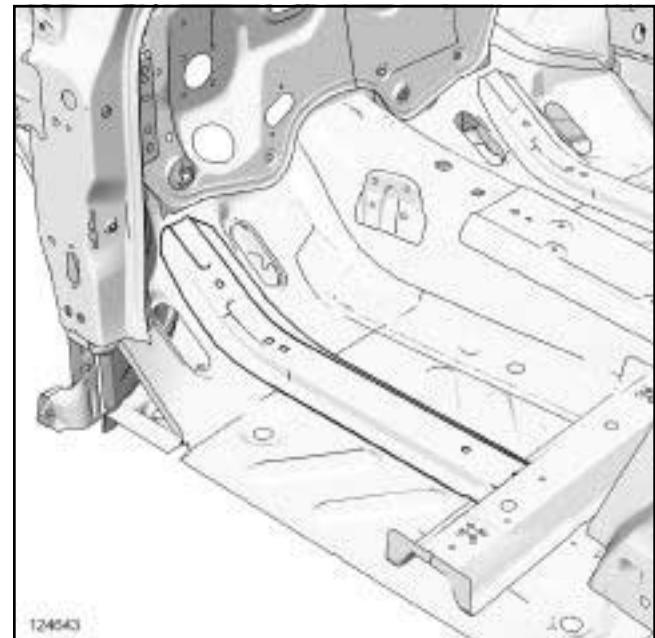
127880

124880

No.	Description	Type	Thickness (mm)
(1)	Front cross member under front seat	Very high yield strength	1.8
(2)	Floor side member reinforcement	Very high yield strength	2

II - PART IN POSITION

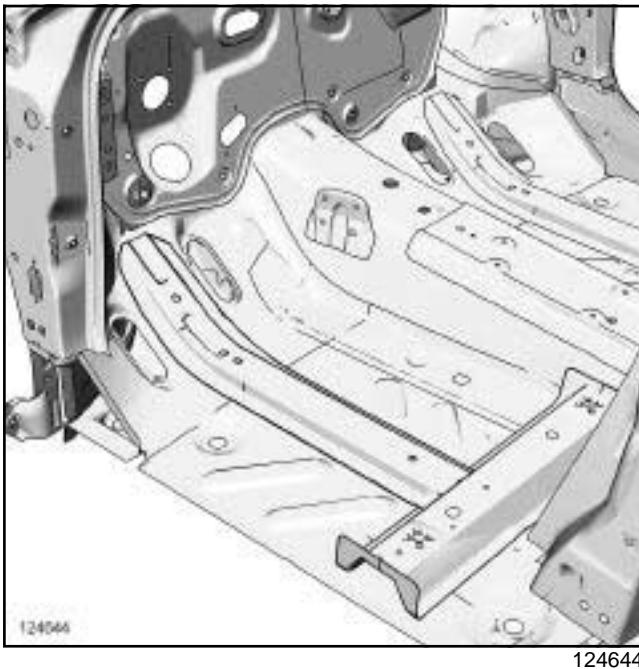
Partial front replacement



124643

124643

Complete replacement



124644

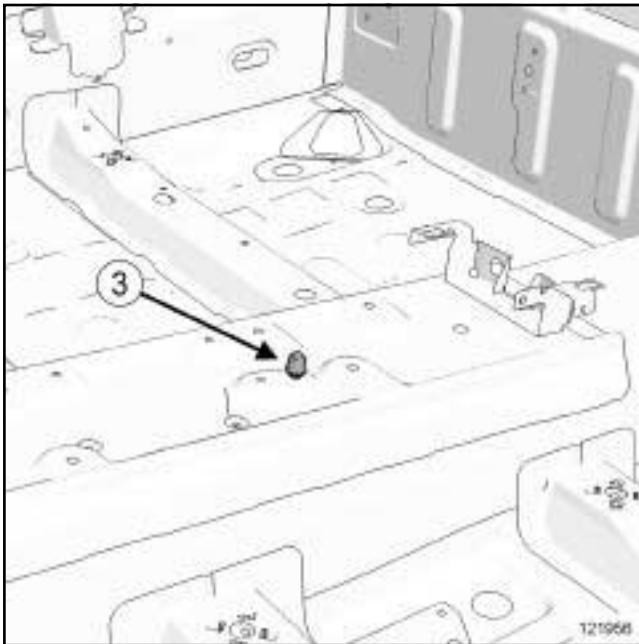
WARNING

To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

The earth of the welding machine must be placed as close as possible to the weld area (see **MR 400**).

Note:

For a detailed description of welded connections, see **MR 400**.

III - POSITIONING OF LOCAL ELECTRICAL EARTHS

121956

Note:

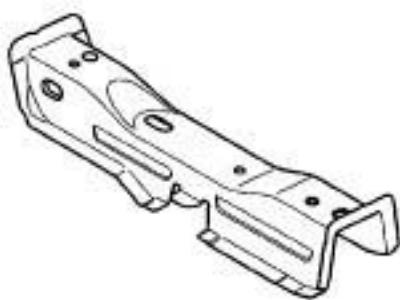
The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading this general information, check that there are no special notes associated with this vehicle. These special notes will be specified if applicable in other parts of this subsection dealing with the part.

Note:

For a detailed description of a particular connection, see **MR 400**.

DESIGN OF THE STRUCTURAL COMPONENT



110499

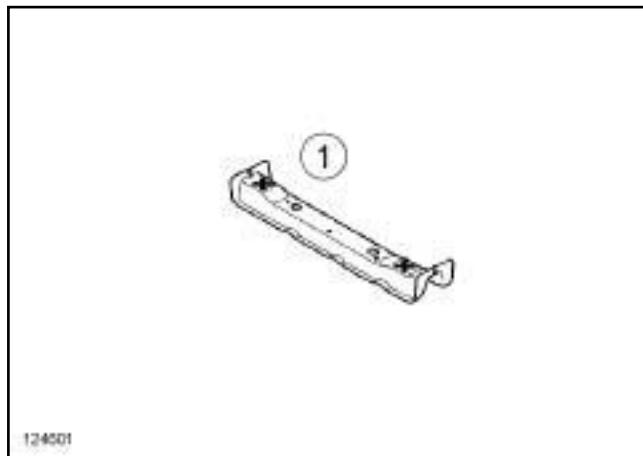
110499

This is a basic part. It serves as a mounting for the rear part of the front seat and to rigidify the body in the event of a side impact.

There is only one way of replacing this part:

- complete replacement.

I - COMPOSITION OF THE SPARE PART



124601

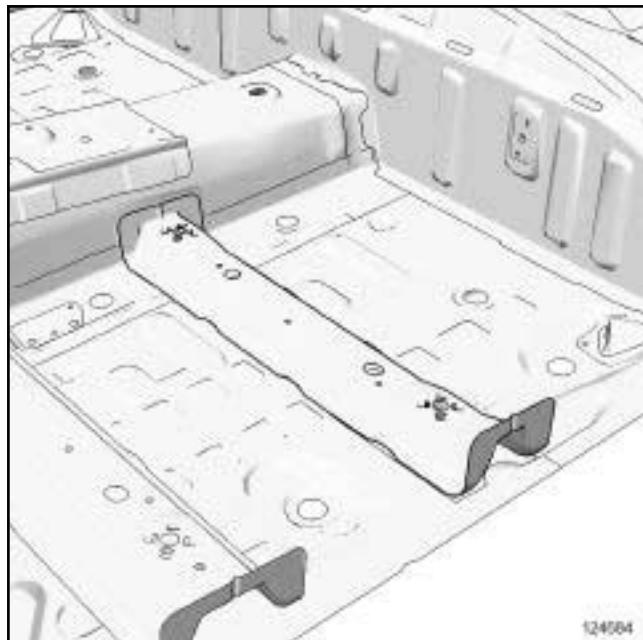
124601

Note:

For a detailed description of welded connections, see **MR 400**.

No.	Description	Type	Thickness (mm)
(1)	Rear cross member under front seat	Very high yield strength	1.8

II - PART IN POSITION



124684

124684

Note:

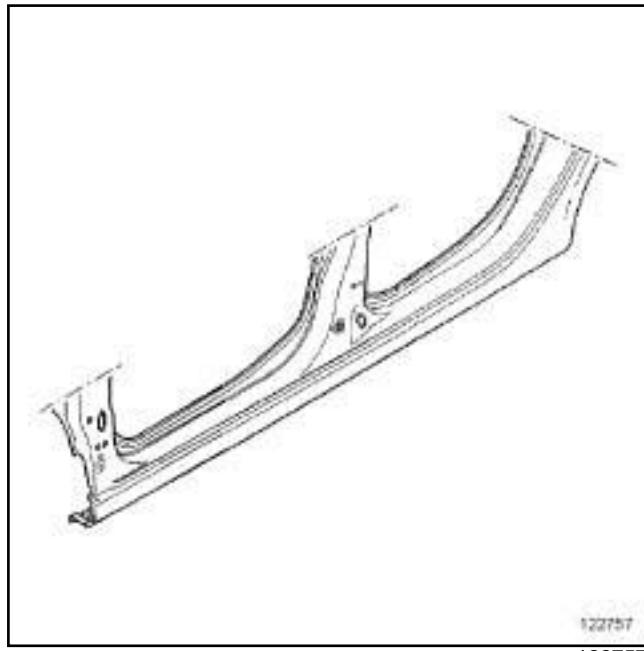
The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading this general information, check that there are no special notes associated with this vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

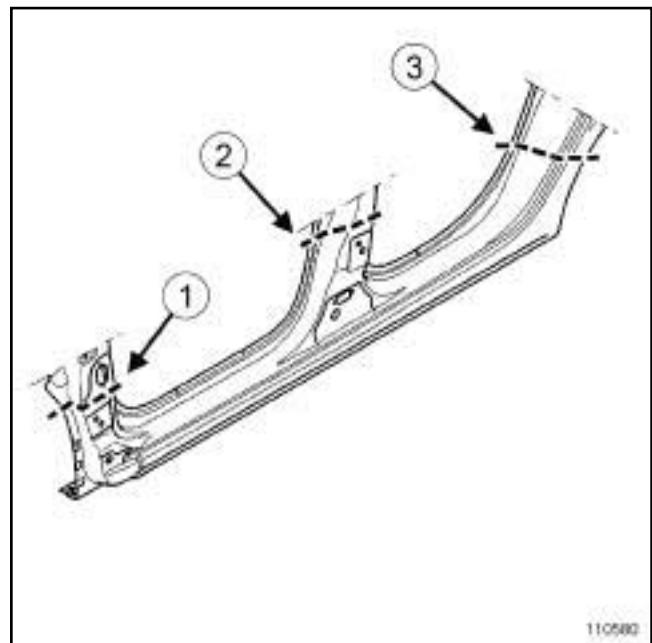
For a detailed description of a particular connection, (see **MR 400**).

I - DESIGN OF THE STRUCTURAL COMPONENT



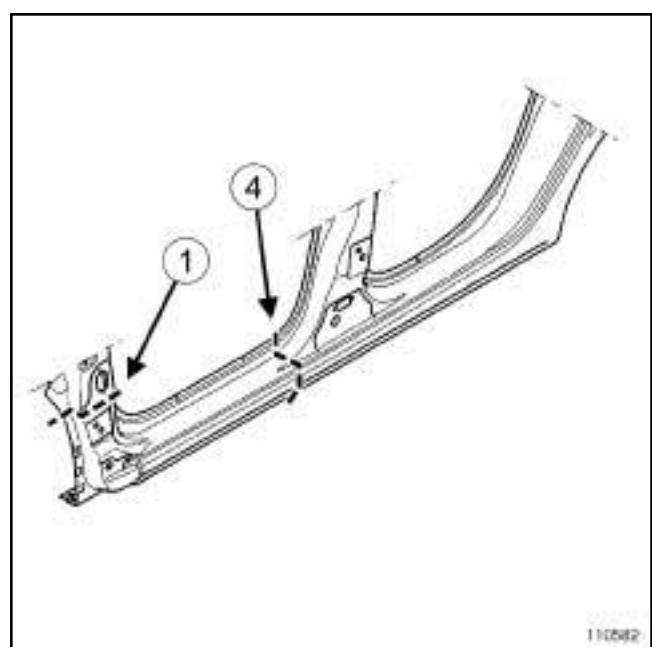
This part is removed by cutting into the complete body side. This part fulfills the basic function of the sill panel. It can be replaced partially by following the cuts described as follows.

II - AREA TO BE CUT FOR COMPLETE REPLACEMENT



The lines (1), (2) and (3) mark the cutting areas for the complete replacement of the sill panel.

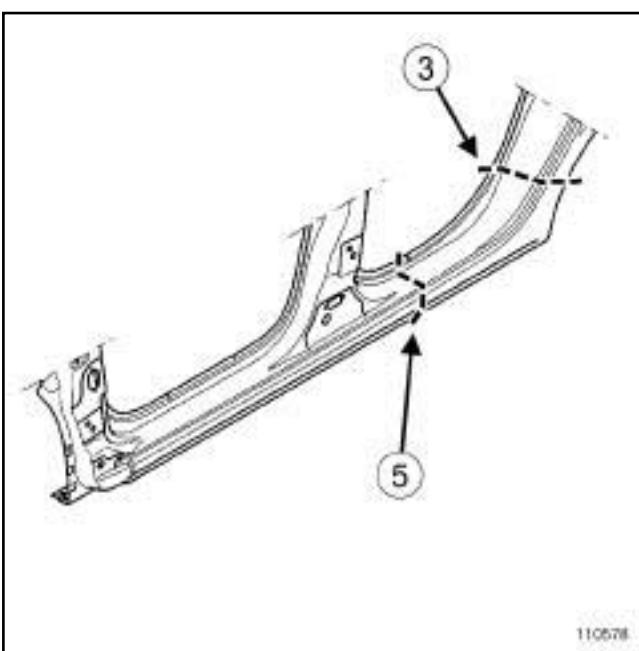
III - AREA TO BE CUT FOR PARTIAL REPLACEMENT



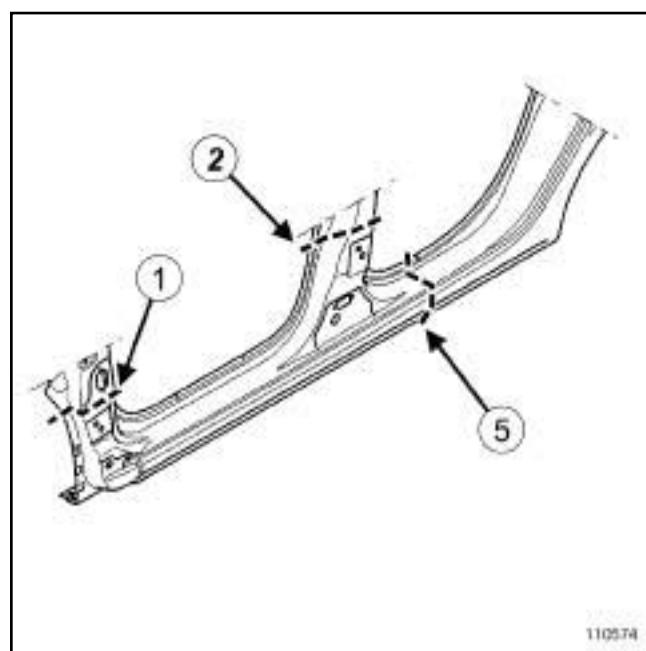
The lines (1) and (4) mark the areas for the partial replacement of the front of the sill panel.

SIDE LOWER STRUCTURE
Sill panel: General description

41C

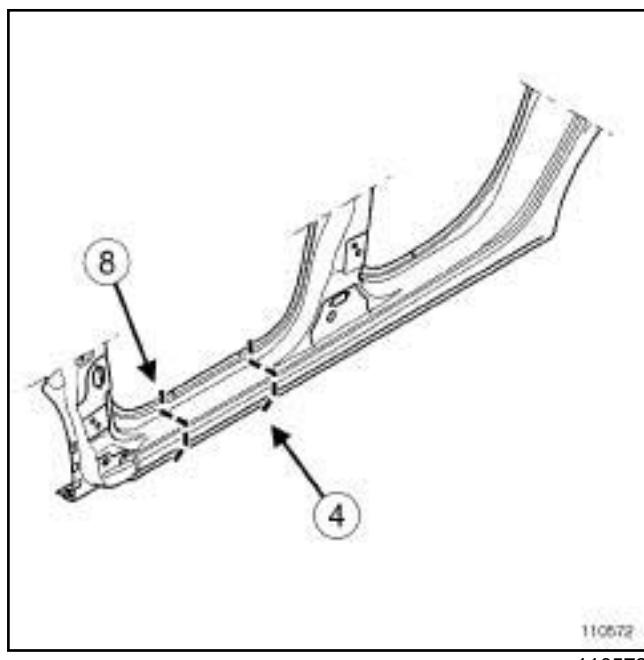


110578
110578



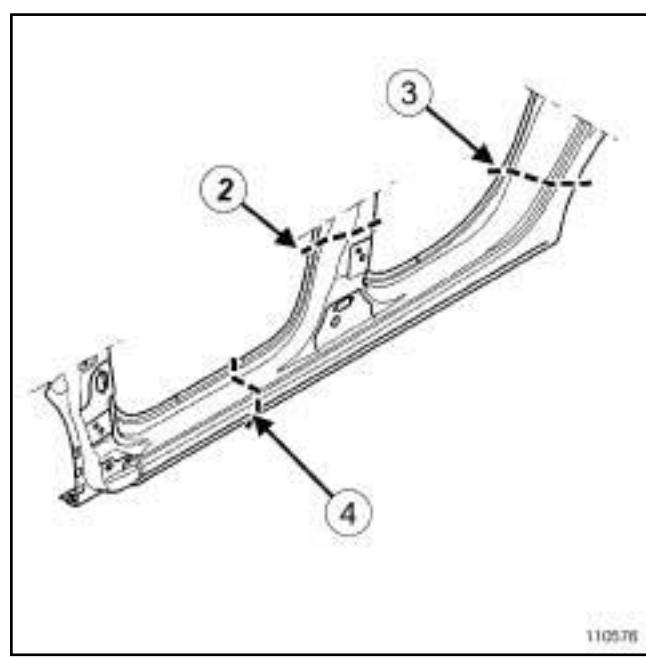
110574
110574

The lines (3) and (5) mark the cutting areas for the partial replacement of the rear of the sill panel.



110572
110572

The lines (4) and (8) mark the cutting areas for the partial replacement of the sill panel section under the door.



110576
110576

Previous cuts can be used to carry out more extensive partial replacements:

- front partial replacement, cut (1) , (2) and (5)
- Rear partial replacement, cut (2) , (3) and (4) .

These operations allow you to access the inside of the hollow section of the structural element to straighten it.

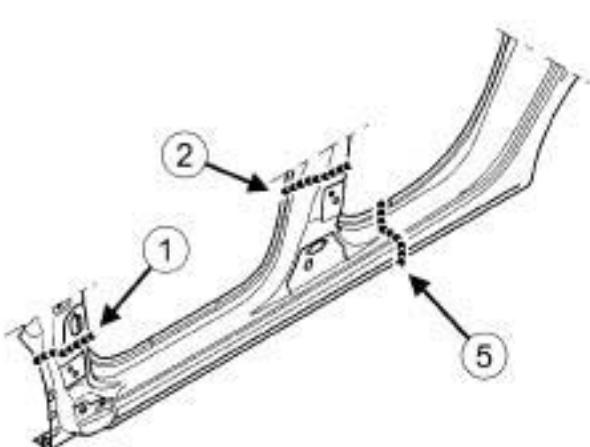
IV - ASSEMBLY INSTRUCTIONS FOR A PARTIAL REPLACEMENT

Only the connections which are specific to the partial replacement by cutting are indicated.

WARNING

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**).

If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400**).



110575

Lines (1) , (2) and (5) on the drawing show a butt weld by continuous EGW welding.

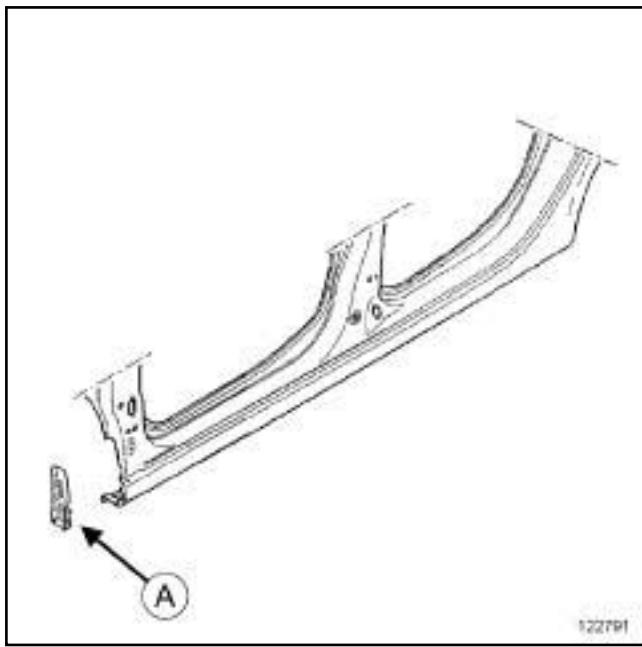
The welds described in this procedure are all identical.

SIDE LOWER STRUCTURE

Sill panel: Description

41C

B91 or K91



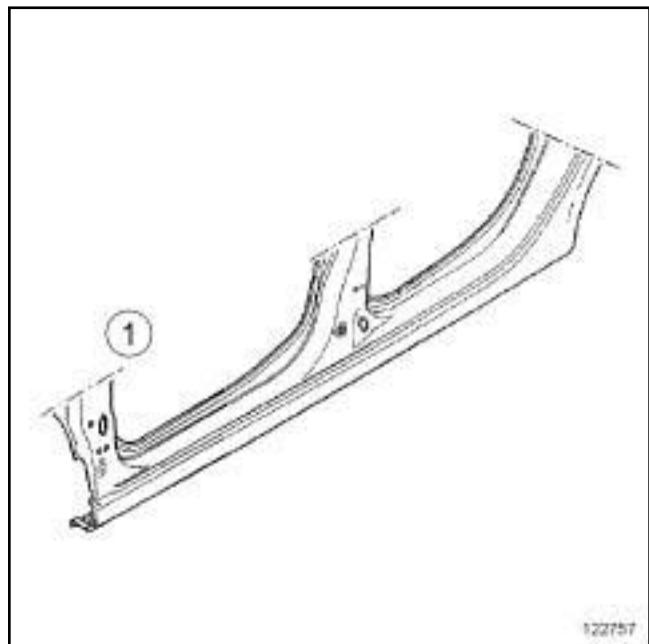
122791

To replace this part, also order the sill panel front closure (A) , the A-pillar insert, the B-pillar insert and the rear wheel arch insert (see 40A, General information, Hollow section inserts: List and location of components, page 40A-11) .

The options for replacing this part are as follows:

- front end replacement,
- partial replacement under door:
- front section replacement,
- rear end section replacement,
- rear section replacement,
- complete replacement.

I - COMPOSITION OF THE SPARE PART



122757

No.	Description	Type	Thickness (mm)
(1)	Sill panel	Mild steel	0.75

II - PART IN POSITION

1 - Front end replacement

WARNING

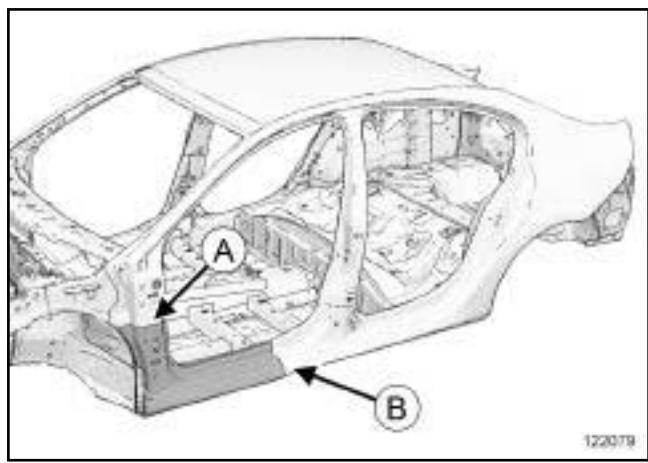
Respect the position of this cut which has been determined in accordance with the position of the inner stiffeners or acoustic inserts, in order to prevent damaging the parts (inner stiffener and/or acoustic insert).

SIDE LOWER STRUCTURE

Sill panel: Description

41C

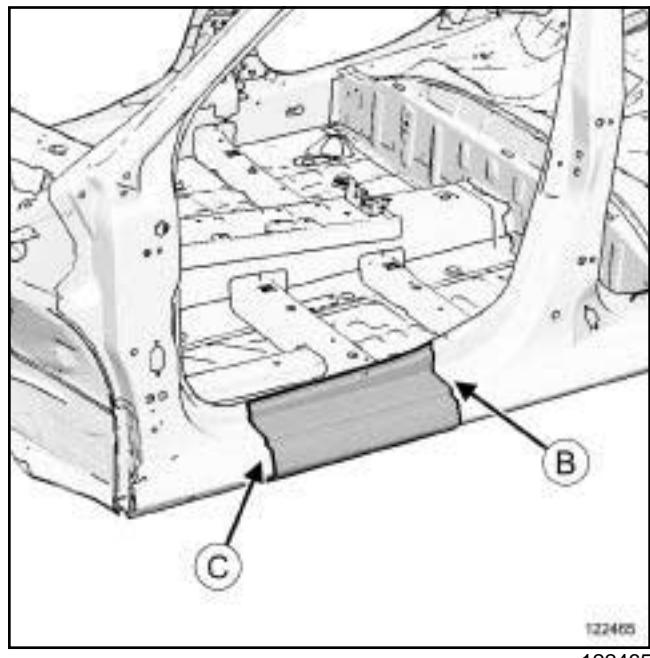
B91 or K91



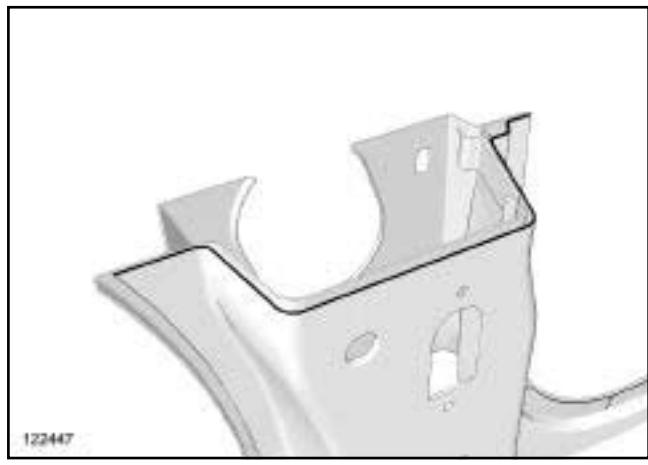
2 - Partial replacement under door

WARNING

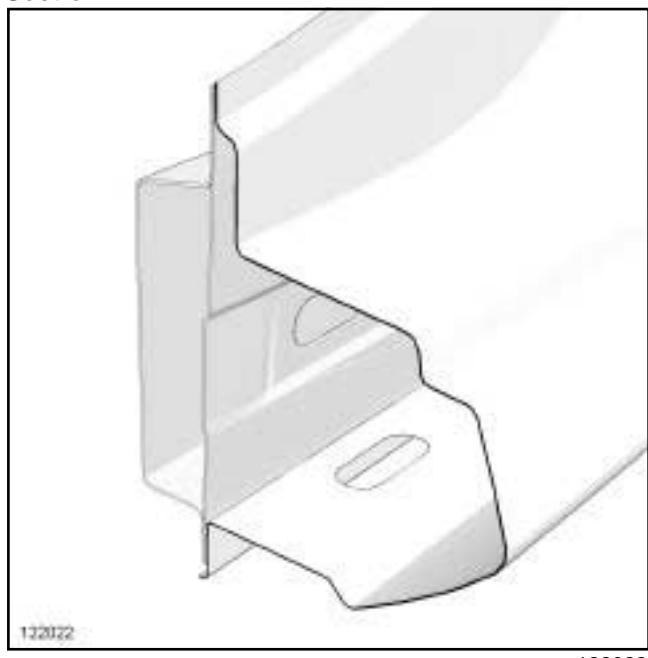
Respect the position of this cut which has been determined in accordance with the position of the inner stiffeners or acoustic inserts, in order to prevent damaging the parts (inner stiffener and/or acoustic insert).



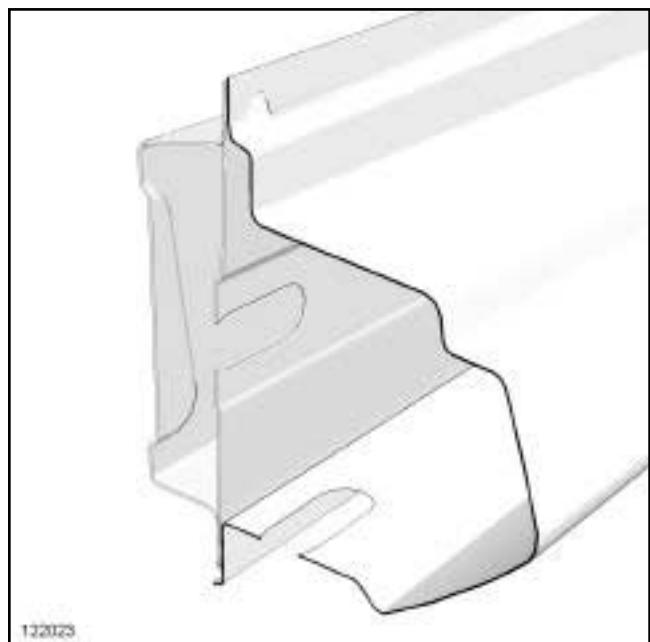
Section A



Section B



Section C



SIDE LOWER STRUCTURE

Sill panel: Description

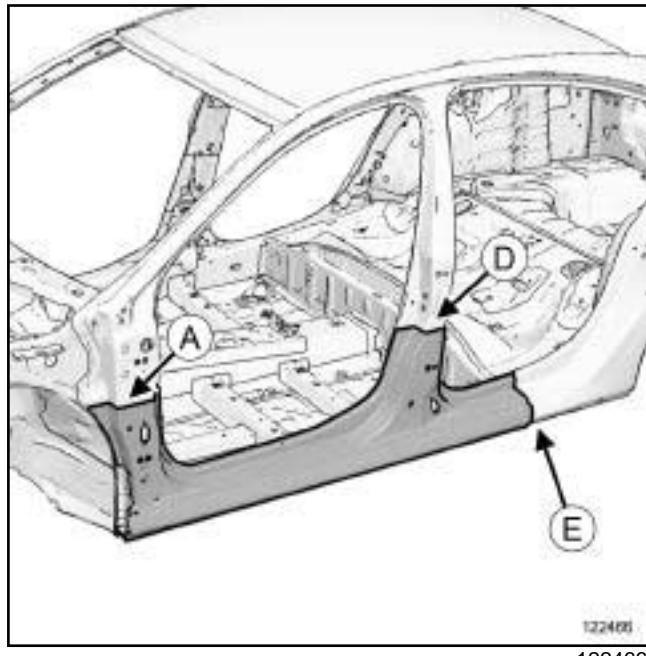
41C

B91 or K91

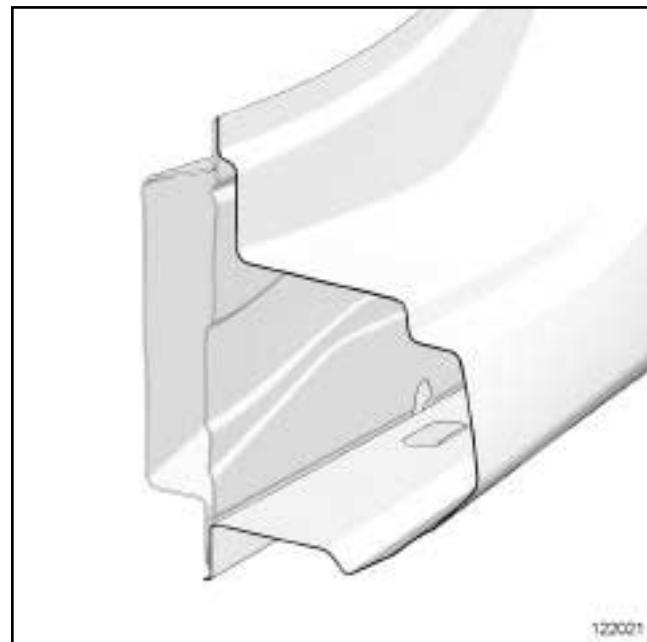
3 - Front section replacement

WARNING

Respect the position of this cut which has been determined in accordance with the position of the inner stiffeners or acoustic inserts, in order to prevent damaging the parts (inner stiffener and/or acoustic insert).



Section E



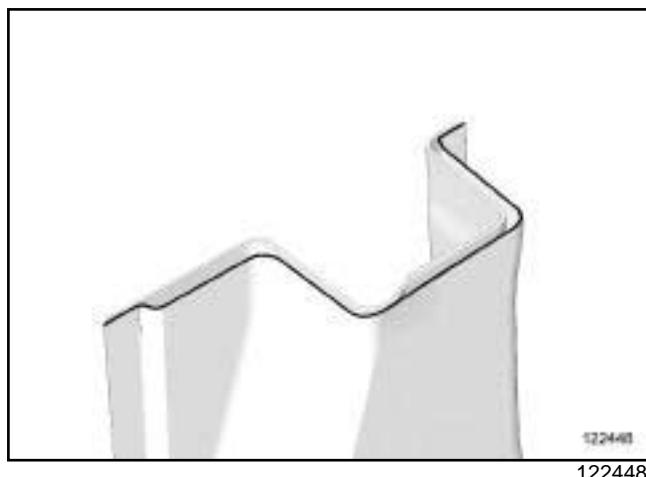
123021
122021

4 - Rear end section replacement

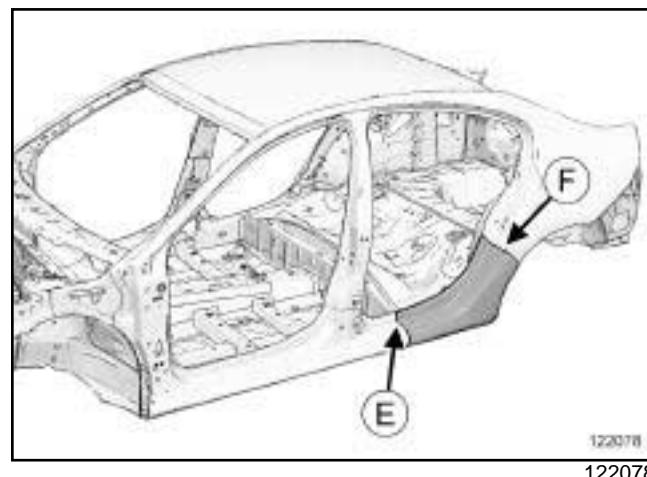
WARNING

Respect the position of this cut which has been determined in accordance with the position of the inner stiffeners or acoustic inserts, in order to prevent damaging the parts (inner stiffener and/or acoustic insert).

Section D



122448
122448



122078
122078

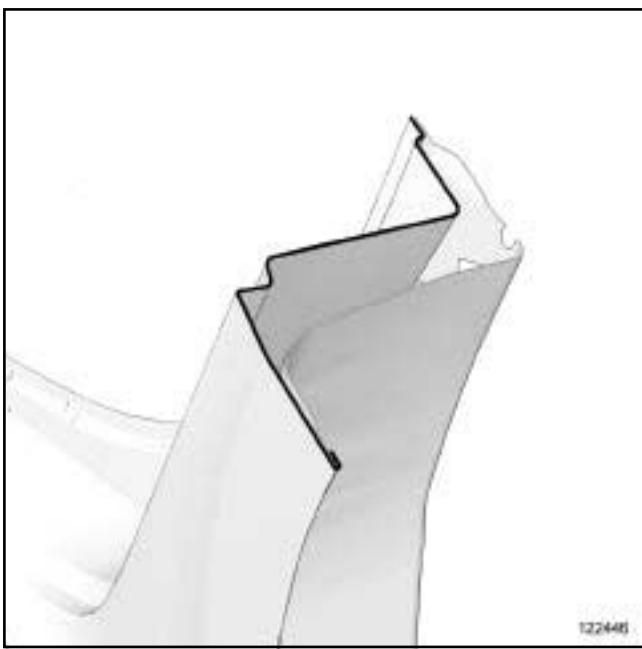
SIDE LOWER STRUCTURE

Sill panel: Description

41C

B91 or K91

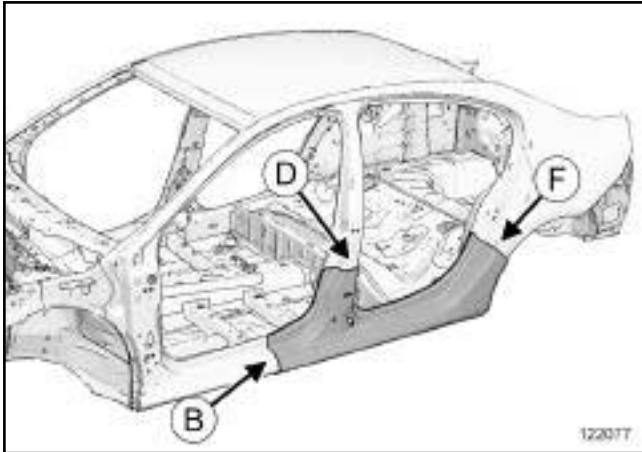
Section F



5 - Rear section replacement

WARNING

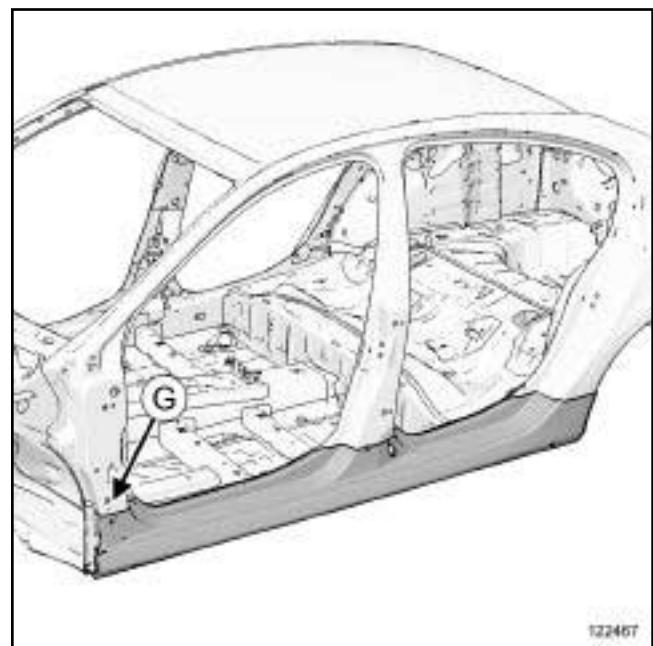
Respect the position of this cut which has been determined in accordance with the position of the inner stiffeners or acoustic inserts, in order to prevent damaging the parts (inner stiffener and/or acoustic insert).



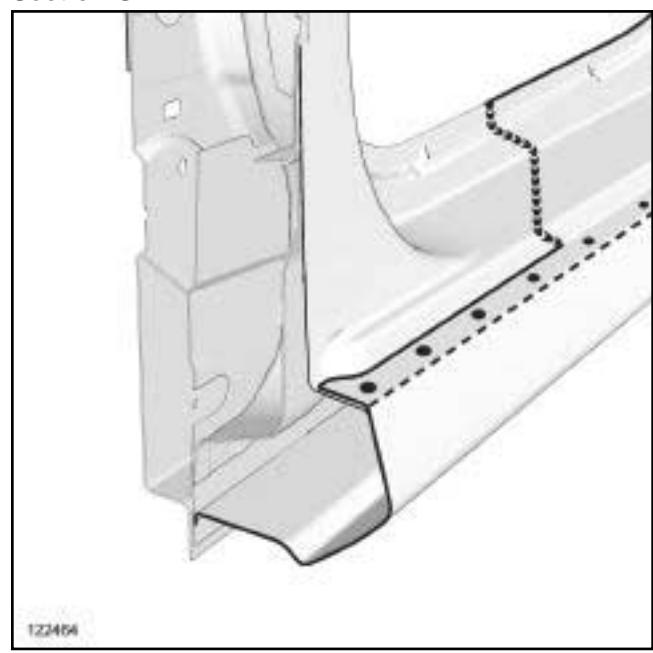
6 - Complete replacement

WARNING

Respect the position of this cut which has been determined in accordance with the position of the inner stiffeners or acoustic inserts, in order to prevent damaging the parts (inner stiffener and/or acoustic insert).



Section G



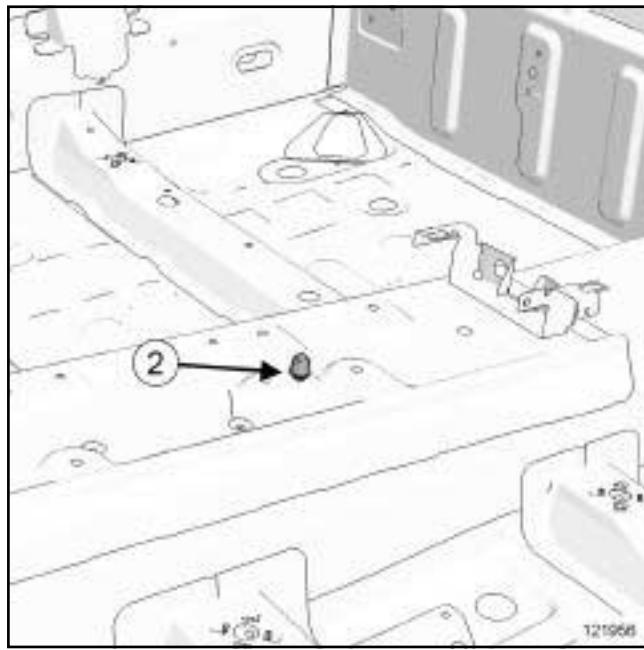
SIDE LOWER STRUCTURE

Sill panel: Description

41C

B91 or K91

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



121956

IMPORTANT

To avoid damaging the vehicle's electric and electronic components, the battery and the earths of any wiring harness near the weld area must be disconnected.

The earth of the welding machine must be placed as close as possible to the weld area.

SIDE LOWER STRUCTURE

Sill panel: Description

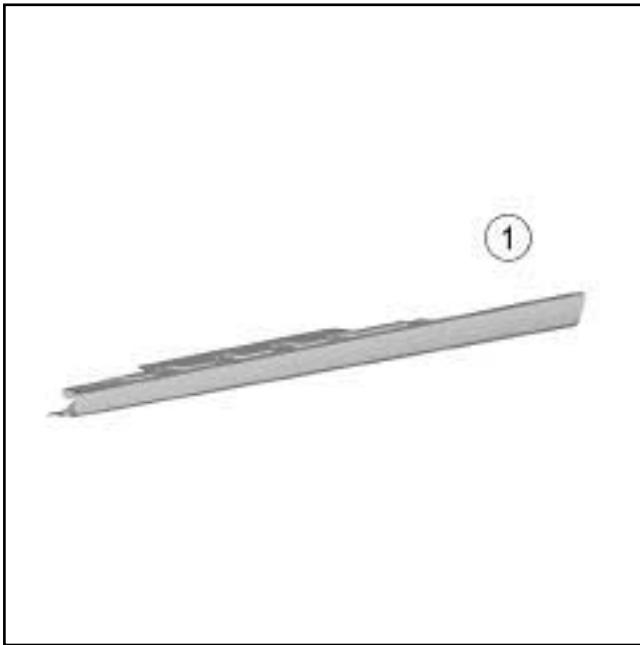
41C

D91

The options for replacing this part are as follows:

- partial replacement of the front section,
- complete replacement.

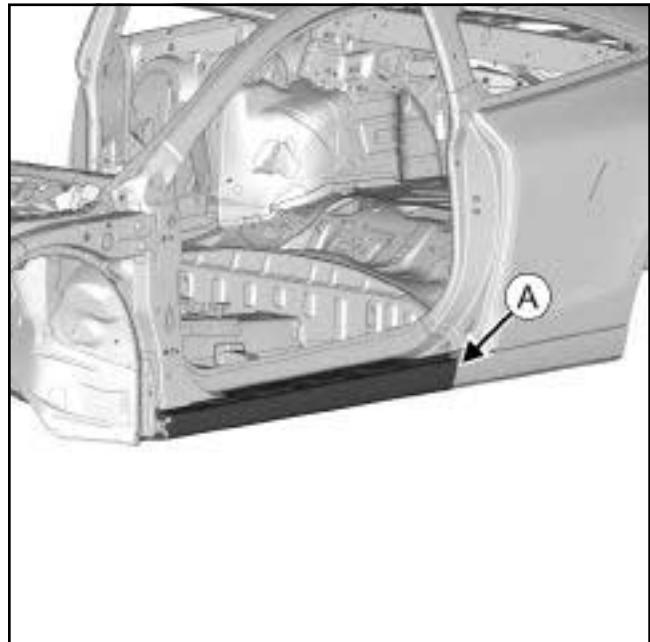
I - COMPOSITION OF THE SPARE PART



134317

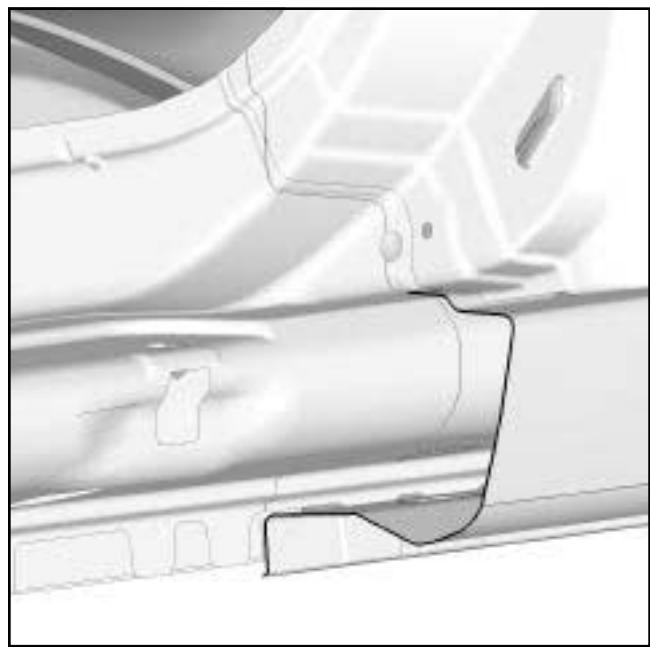
II - PART FITTED

1 - Partial replacement of the front section



134318

Section A



134320

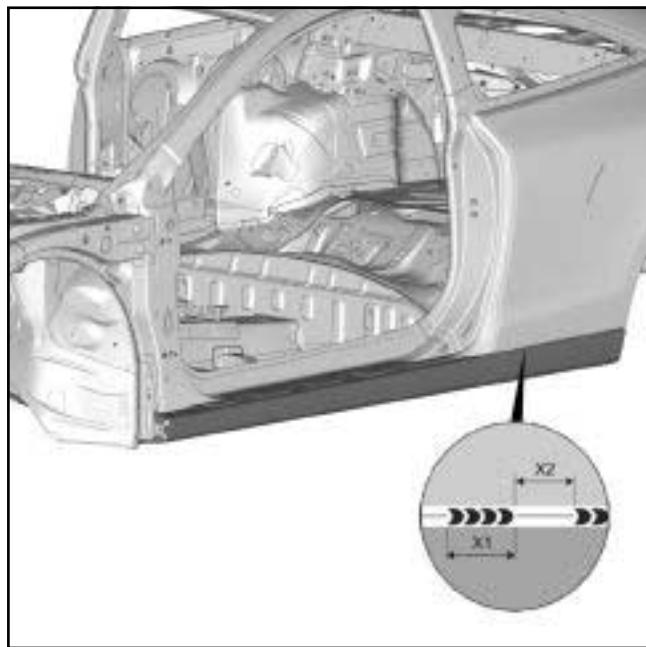
No.	Description	Type	Thickness (mm)
(1)	Sill panel	Mild steel	0.75

SIDE LOWER STRUCTURE
Sill panel: Description

41C

D91

2 - Complete replacement



134319

Note: For the connection of this joint (see **Electrical resistance spot welding connection with direct access: Description**) (MR 400, 40B, Electrical resistance welded connections).

Note:

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading this general information, check that there are no special notes associated with this vehicle. These special notes will be specified if applicable in other parts of this subsection dealing with the part.

If there are other issues regarding access to mating faces, the various options are described in the basic instructions for structural bodywork repair (see **MR 400**).

Note:

For a detailed description of a particular connection, (see **MR 400**).

I - DESIGN OF THE STRUCTURAL COMPONENT

B91 or K91

124602

124602

This is a basic part; its only function is that of a sill panel closure panel.

II - ASSEMBLY METHOD FOR A PARTIAL REPLACEMENT

Only the connections which are specific to the partial replacement by cutting are indicated.

WARNING

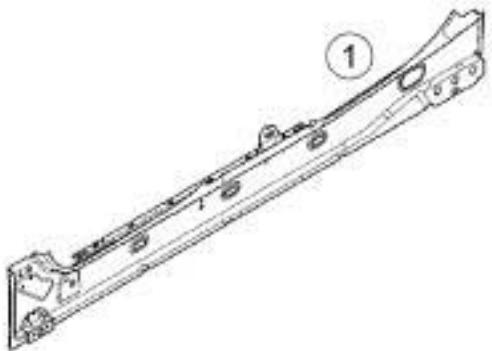
If the mating faces of the parts to be welded are not accessible, make EGW plug welds to replace the original resistance welds (see **MR 400**).

B91 or K91

There is only one way of replacing this part:

- complete replacement.

I - COMPOSITION OF THE SPARE PART

124602
124602

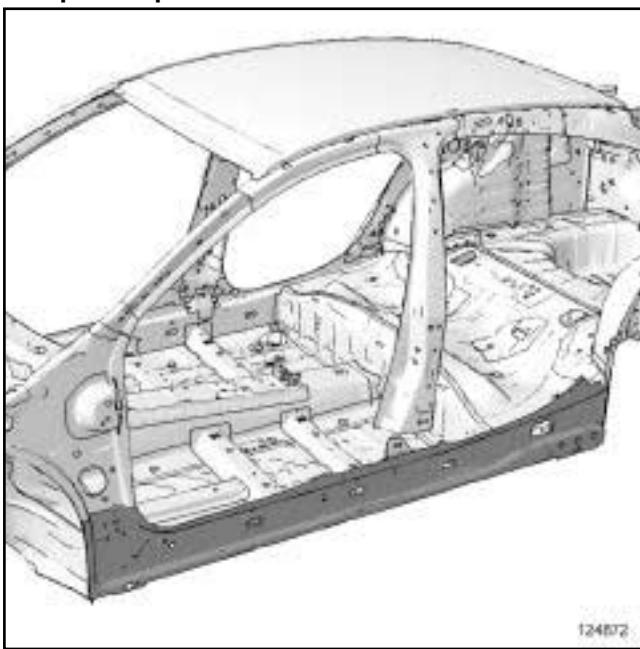
Note:

For a detailed description of welded connections,
see **MR 400**.

No.	Description	Type	Thick-ness (mm)
(1)	Sill panel closure panel	Very high yield strength	1.2

II - PART IN POSITION

Complete replacement

124872
124872

D91

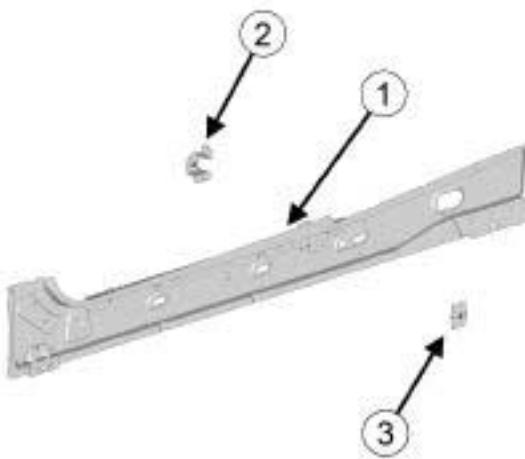


134326

The options for replacing this part are as follows:

- partial
- complete

I - COMPOSITION OF THE SPARE PART



134327

No.	Description	Type	Thickness (mm)
(1)	Sill panel closure panel	THLE	1.2
(2)	Seat belt rail fixed bridge piece	THLE	2
(3)	Seat belt rail fixed reinforcement	HLE	2

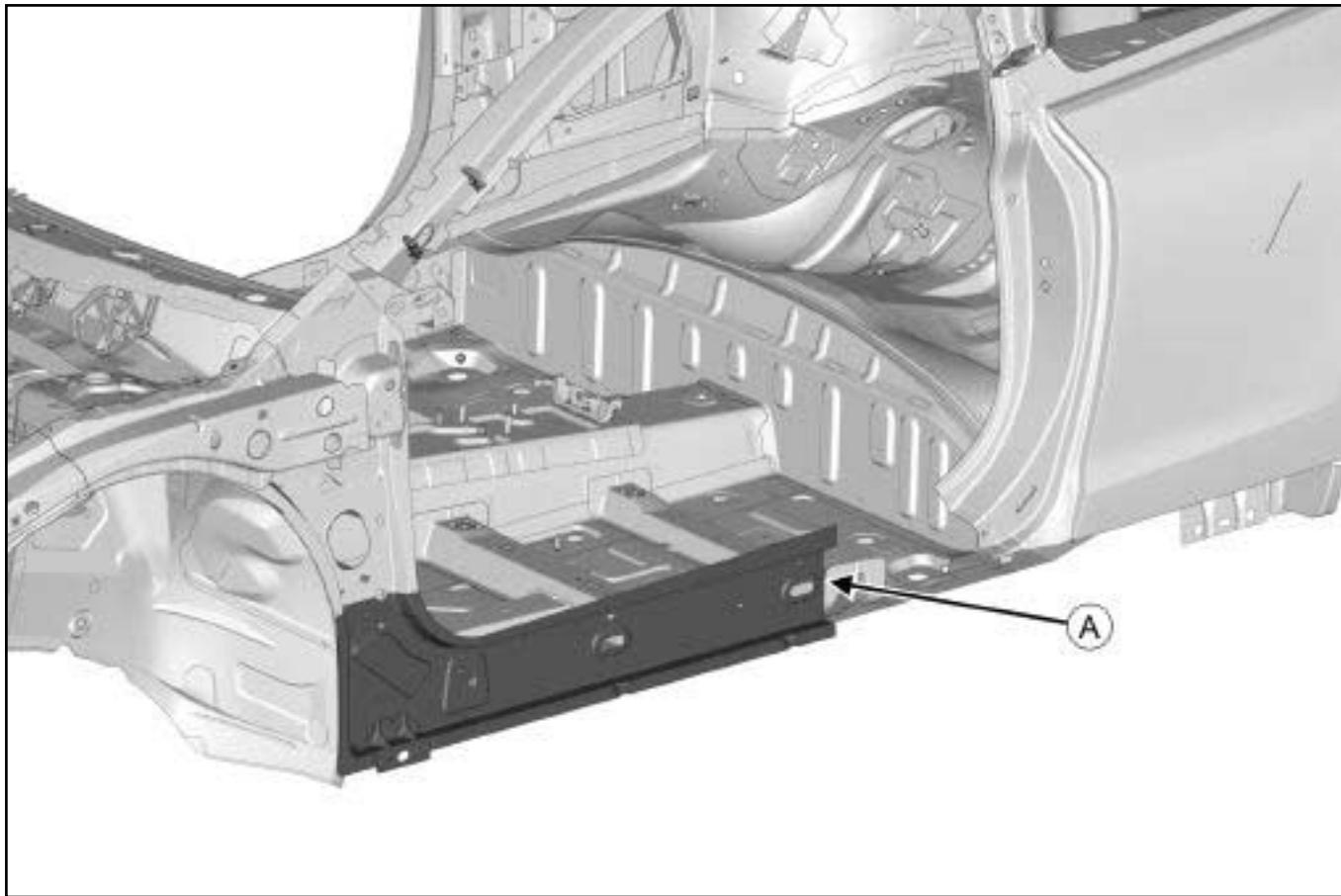
II - PART FITTED

1 - Partial replacement

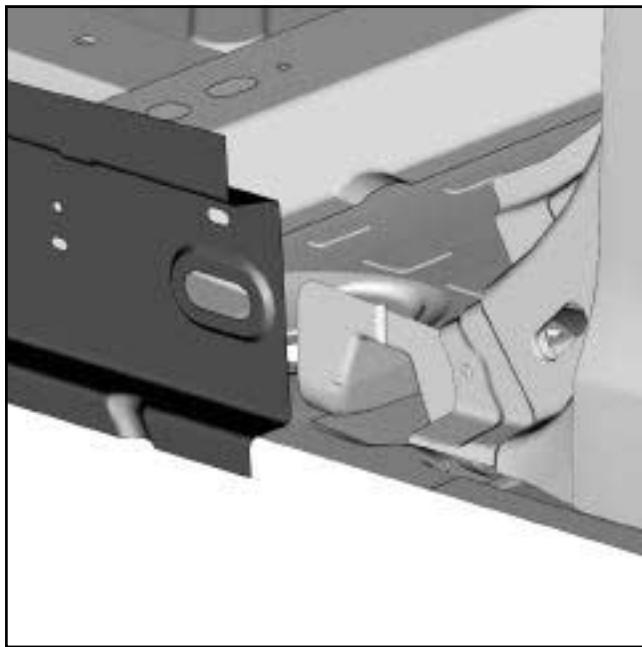
WARNING

Respect the position of this cut which has been determined in accordance with the position of the inner stiffeners or acoustic inserts, in order to prevent damaging the parts (inner stiffener and/or acoustic insert).

D91



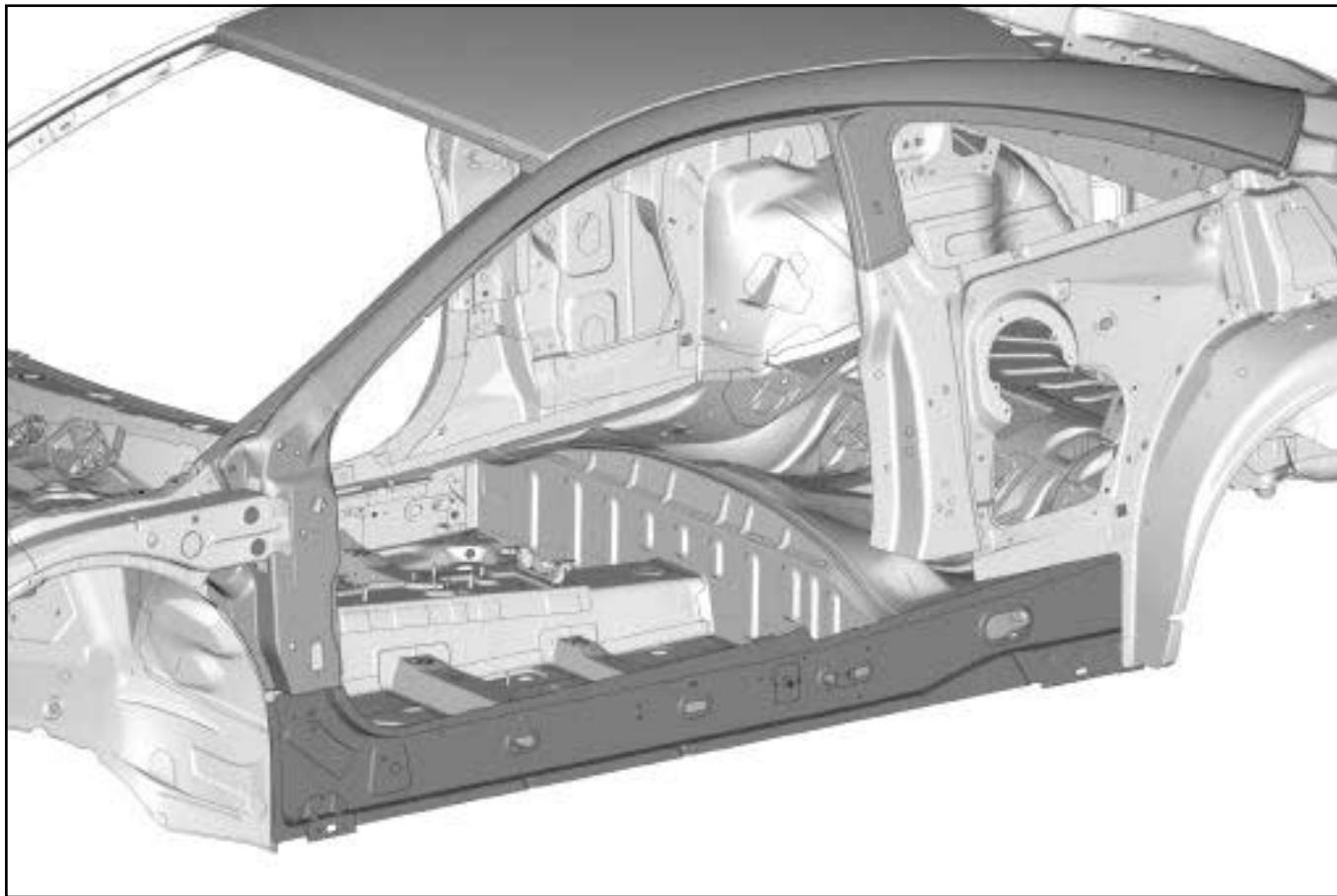
134329

Section A

134781

D91

2 - Complete replacement |



134328

Note:

For a detailed description of welded connections,
see **MR 400**.

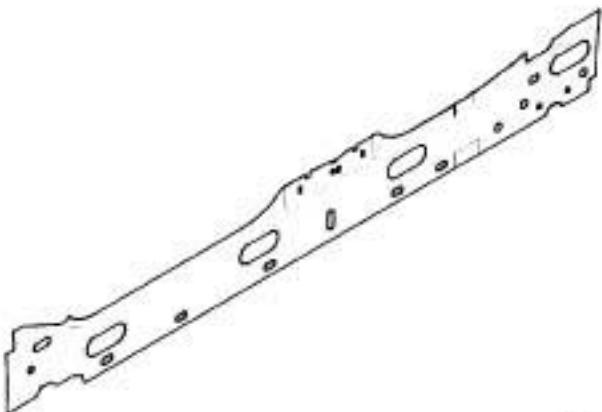
Note:

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

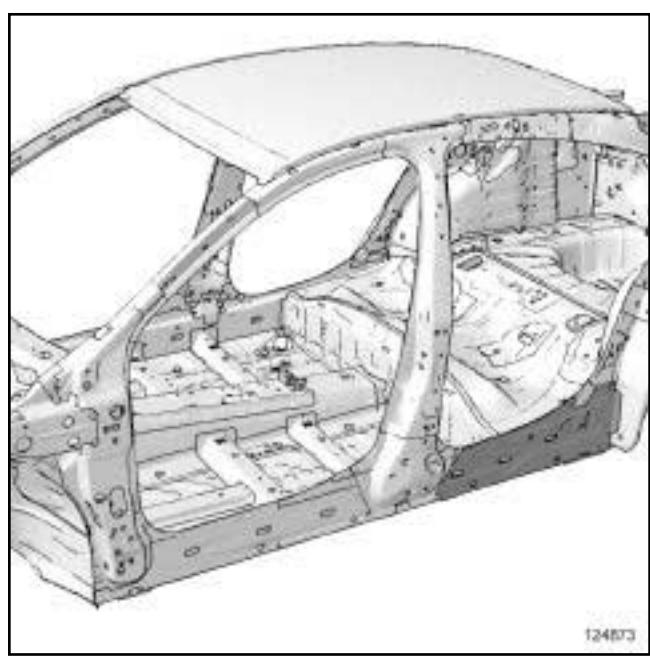
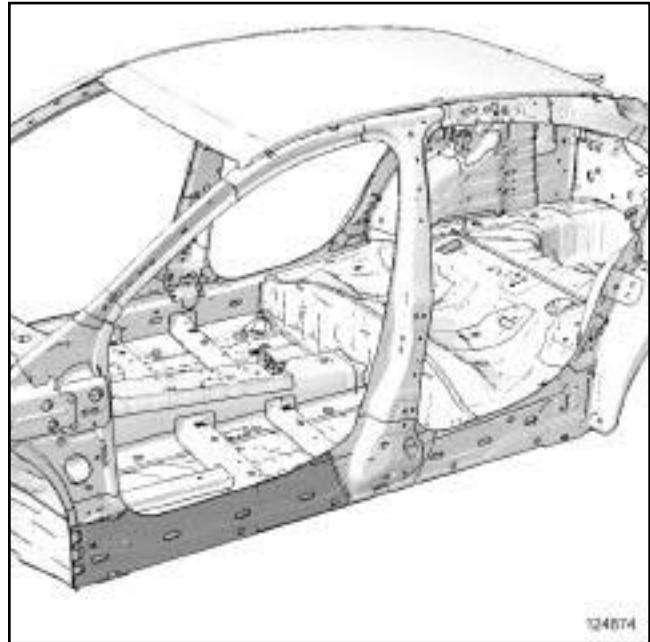
Before reading this general information, check that there are no special notes associated with this vehicle. These special notes will be specified if applicable in other parts of this subsection dealing with the part.

Note:

For a detailed description of a particular connection, see **MR 400**.

I - DESIGN OF THE STRUCTURAL COMPONENT

This is a basic part, its only function is as a sill panel reinforcement and it is not linked to any other part.

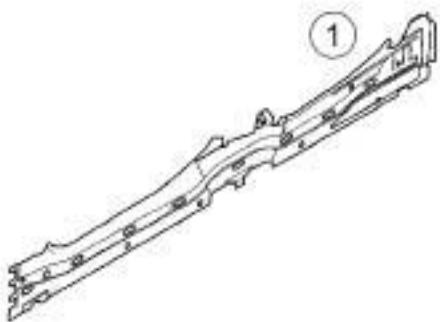
II - AREA TO BE CUT FOR PARTIAL REPLACEMENT

B91 or K91

The options for replacing this part are as follows:

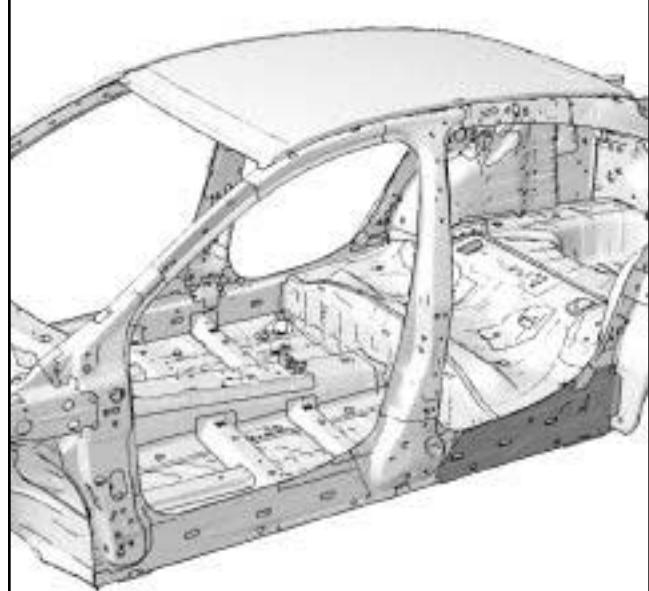
- partial replacement of the front section,
- partial replacement of the rear section,
- complete replacement.

I - COMPOSITION OF THE SPARE PART



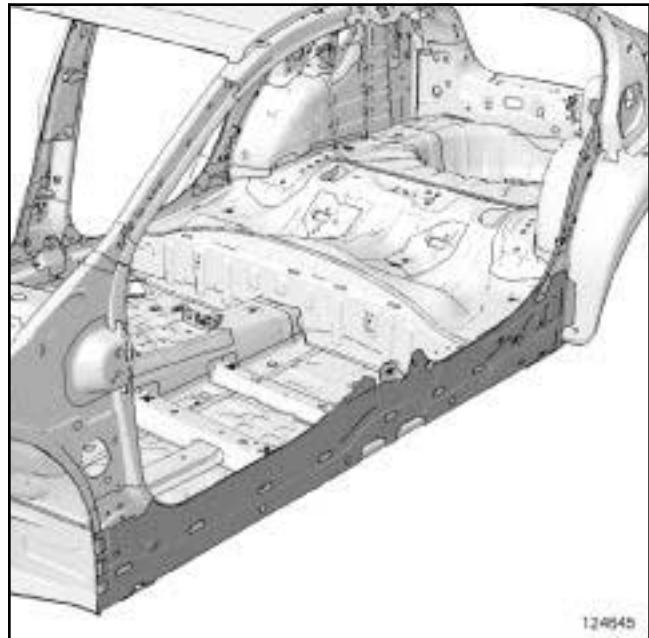
124593
124593

Partial replacement of the rear section



124873
124873

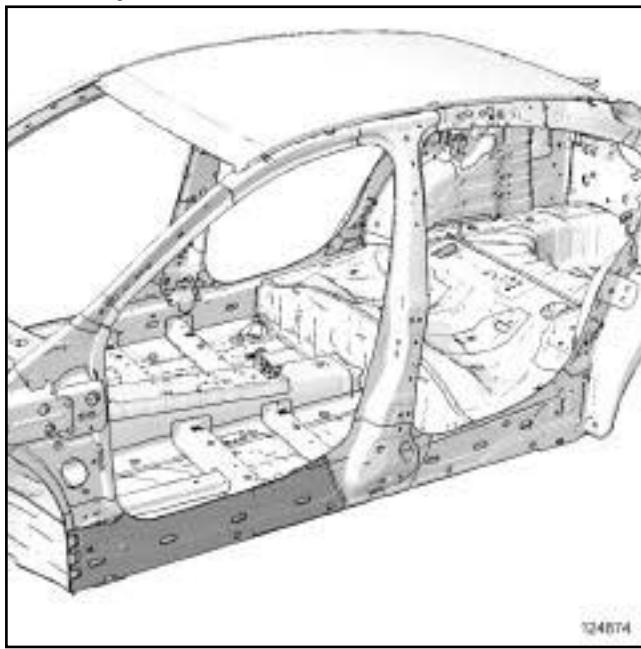
Complete replacement



124645
124645

II - PART IN POSITION

Partial replacement of the front section



124874
124874

WARNING

To preserve the mechanical specifications when partially replacing parts with a single structural component, alter the weld lines for each of these components.

SIDE LOWER STRUCTURE
Sill panel reinforcement: Description

41C

B91 or K91

Note:

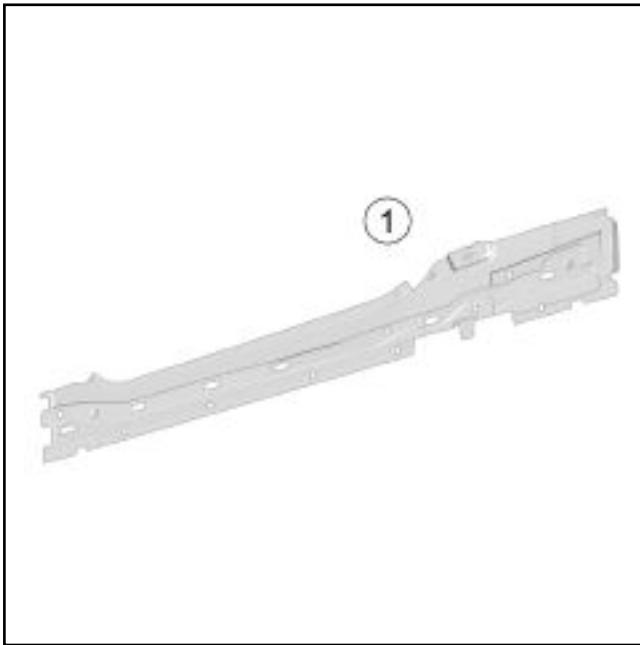
For a detailed description of welded connections,
see **MR 400**.

D91

The options for replacing this part are as follows:

- partial front replacement,
- complete replacement.

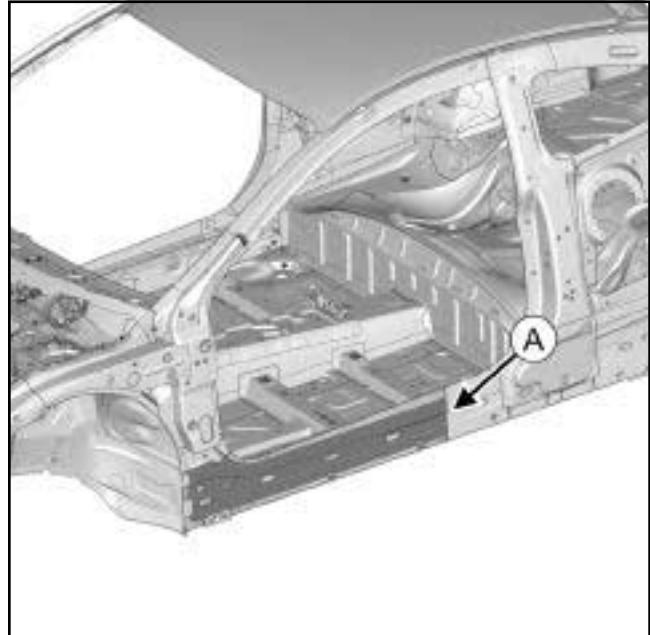
I - COMPOSITION OF THE SPARE PART



134325

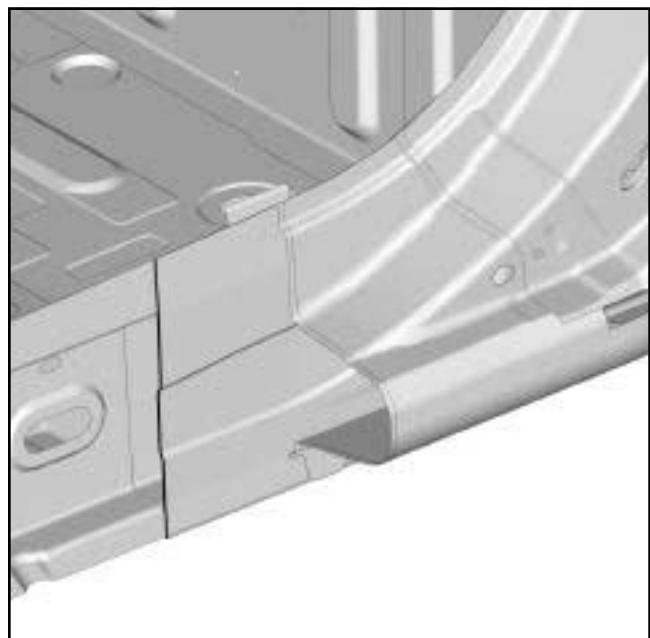
II - PART FITTED

Partial front replacement



134322

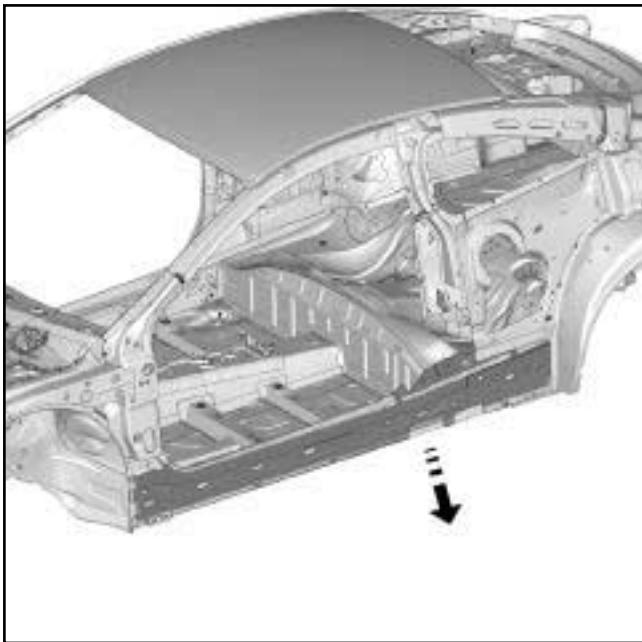
Detailed view A



134323

No.	Description	Type	Thickness (mm)
(1)	Sill panel reinforcement	HLE	1

D91

Complete replacement

134321

WARNING

To preserve the mechanical specifications when partially replacing parts with a single structural component, alter the weld lines for each of these components.

Note:

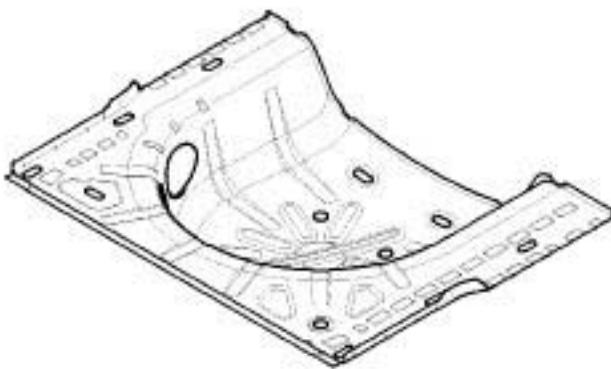
The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400**.

I - DESIGN OF THE STRUCTURAL COMPONENT

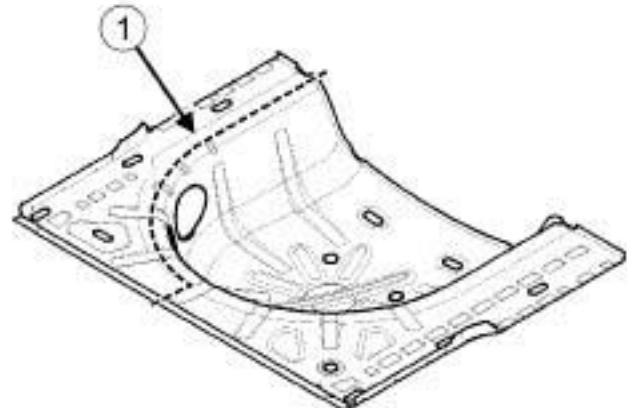


123065

123065

The distinctive feature of this part is that it combines the functions of the rear section of the rear floor and integrates the emergency spare wheel.

II - AREA TO BE CUT FOR PARTIAL REPLACEMENT



123066

123066

Cut 1:

This line marks the area in which it is possible to make a partial replacement.

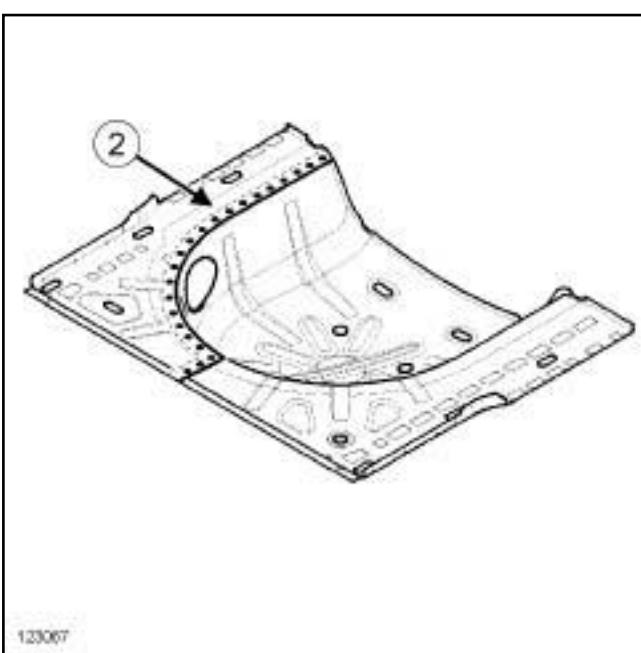
III - ASSEMBLY INSTRUCTIONS FOR A PARTIAL REPLACEMENT

Only the connections which are specific to the partial replacement by cutting are indicated.

WARNING

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**).

If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400**).



123067

123067

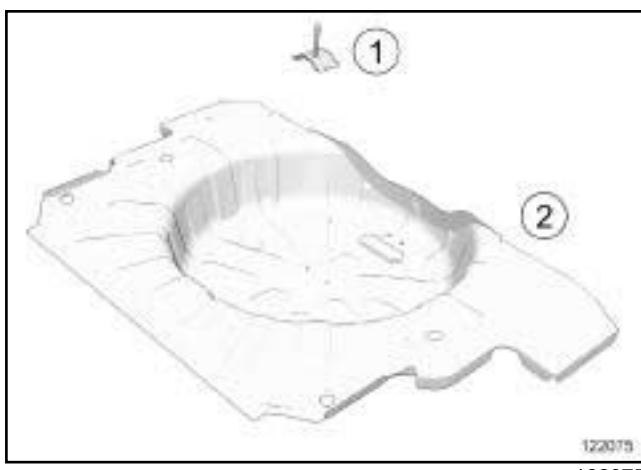
Line (2) on the diagram shows a joint made by joggling connected with plug welds at regular intervals.



The options for replacing this part are as follows:

- partial replacement,
- complete replacement.

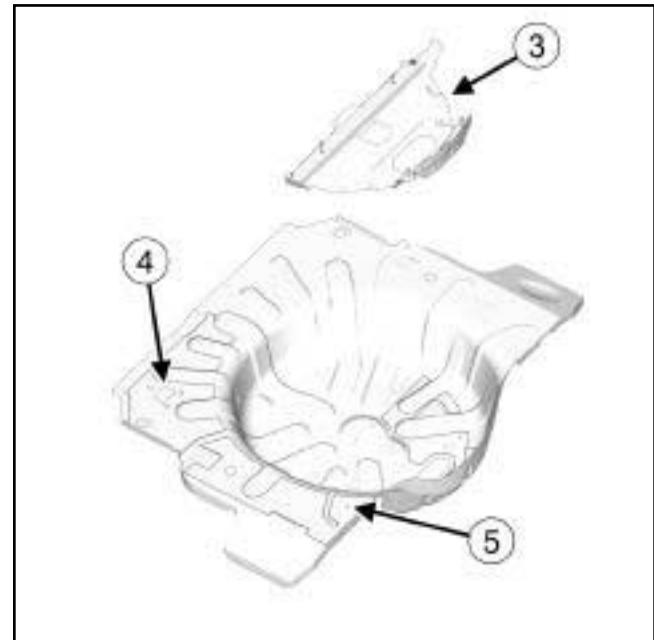
I - COMPOSITION OF THE SPARE PART



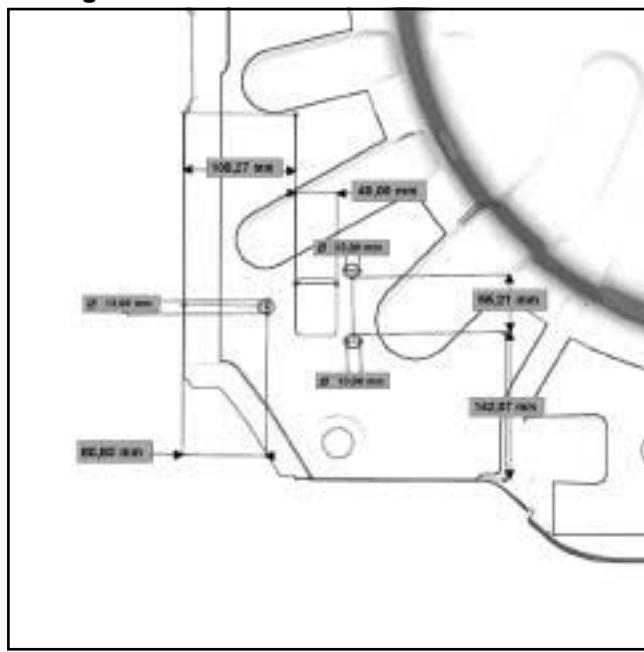
No.	Description	Type	Thickness (mm)
(1)	Emergency spare wheel bridge mounting piece	Mild steel	1.17
(2)	Rear floor, rear section	Mild steel	0.7

V4Y or V9X

Adaptation

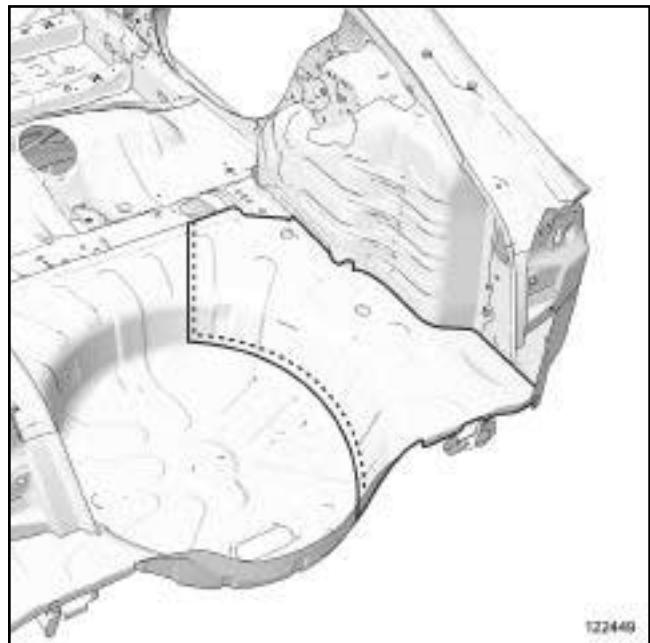


- (1) unsolder the bridge piece,
- (3) battery mounting to be ordered additionally,
- (4) battery wiring routing drilling,
- (5) battery degassing pipe routing drilling.

Cutting dimensions

134786

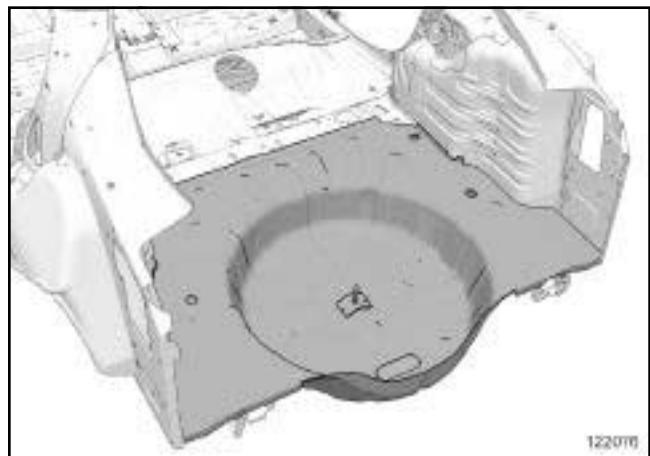
B91 or K91

1 - Partial replacement

122449

II - PART IN POSITION

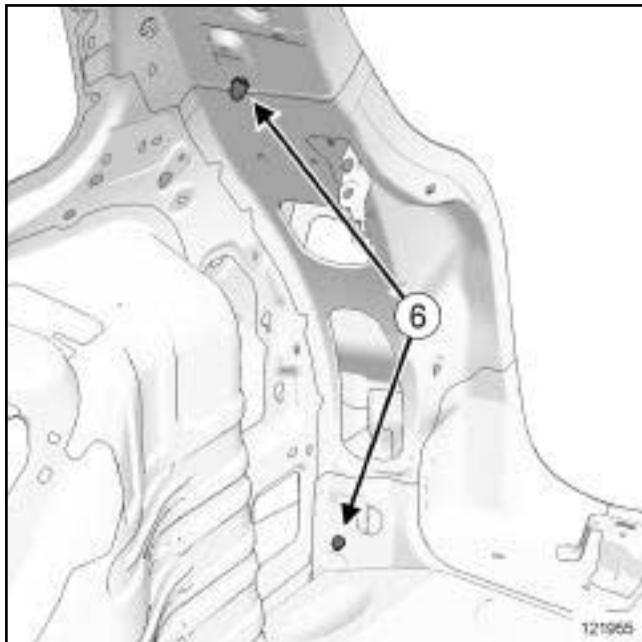
134314

2 - Complete replacement

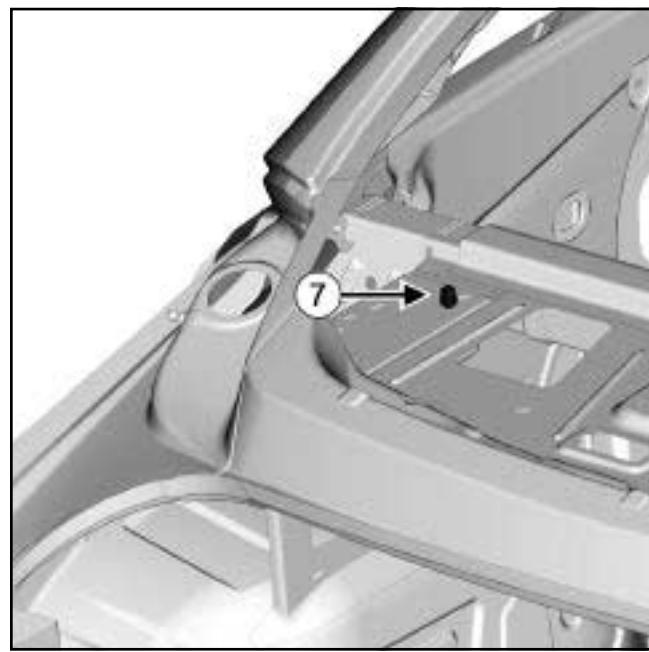
122076

Note:

For a detailed description of welded connections,
see **MR 400**.

III - POSITIONING OF LOCAL ELECTRICAL EARTHS**B91 or K91**

121955



134819

WARNING

To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

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

WARNING

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 closely as possible to the weld area (see **MR 400**).

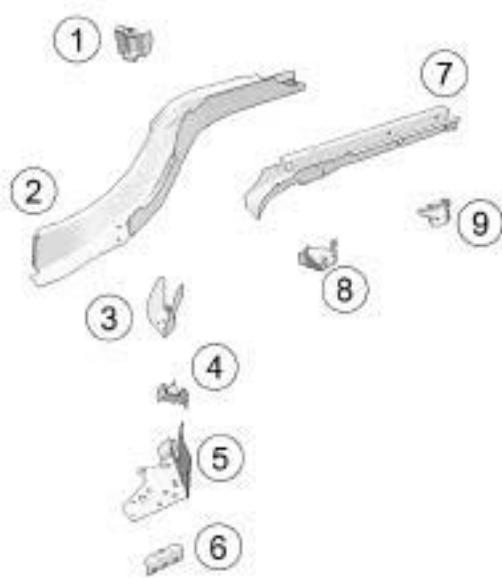
124616
124615

There is only one way of replacing this part:

- complete replacement.

IMPORTANT

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

I - COMPOSITION OF THE SPARE PART

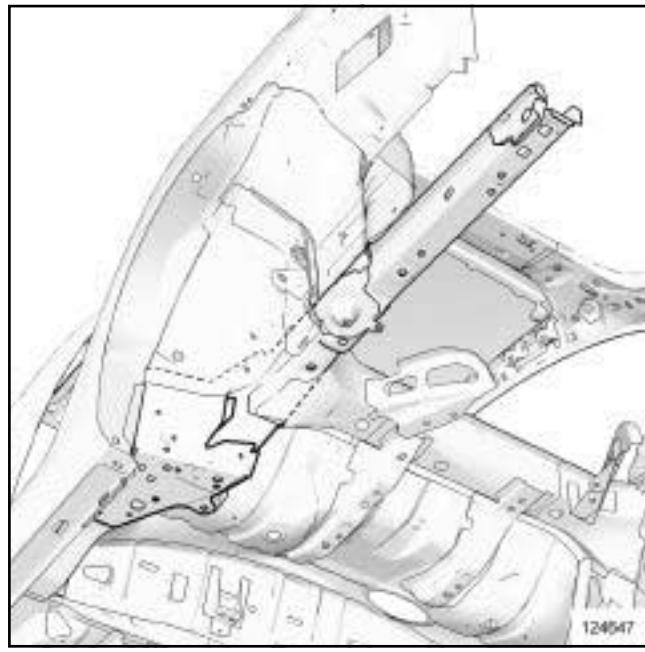
124651

124651

No.	Description	Type	Thickness (mm)
(1)	Rear axle assembly mounting bridge piece	Very high yield strength	4
(2)	Rear side member, front section	HEL	1.77
(3)	Axle assembly mounting unit	HEL	2.5
(4)	Axle mounting exterior reinforcement	HEL	1.97
(5)	Inner wheel arch stiffener	HEL	1.17
(6)	Jacking point reinforcement	Very high yield strength	1.97
(7)	Rear section of rear side member	HEL	1.7
(8)	Suspension spring support	HEL	1.97
(9)	Towing ring mounting	Mild steel	1.47

II - PART IN POSITION

Complete replacement



Note:

For a detailed description of welded connections,
see **MR 400**.

IMPORTANT

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

Note:

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading this general information, check that there are no special notes associated with this vehicle. These special notes will be specified if applicable in other parts of this subsection dealing with the part.

Note:

For a detailed description of a particular connection, see **MR 400**.

I - DESIGN OF THE STRUCTURAL COMPONENT

124617

124617

This is a basic part; it simply fulfills the function of a rear side member.

II - AREA TO BE CUT FOR PARTIAL REPLACEMENT

124617

124617

Cut 1:

This line marks the area in which it is possible to make a partial replacement.

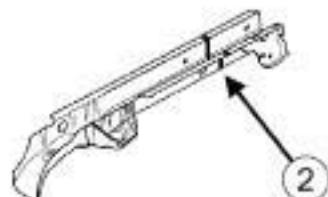
III - ASSEMBLY INSTRUCTIONS FOR A PARTIAL REPLACEMENT

Only the connections which are specific to the partial replacement by cutting are indicated.

WARNING

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**).

If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400**).



124617

124617

The line (2) on the drawing shows a butt weld made by continuous **GMAW** welding.

REAR LOWER STRUCTURE

Rear side member: Description

41D



124617

124617

the options for replacing this part are as follows:

- rear end section replacement,
- complete replacement.

IMPORTANT

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

I - COMPOSITION OF THE SPARE PART



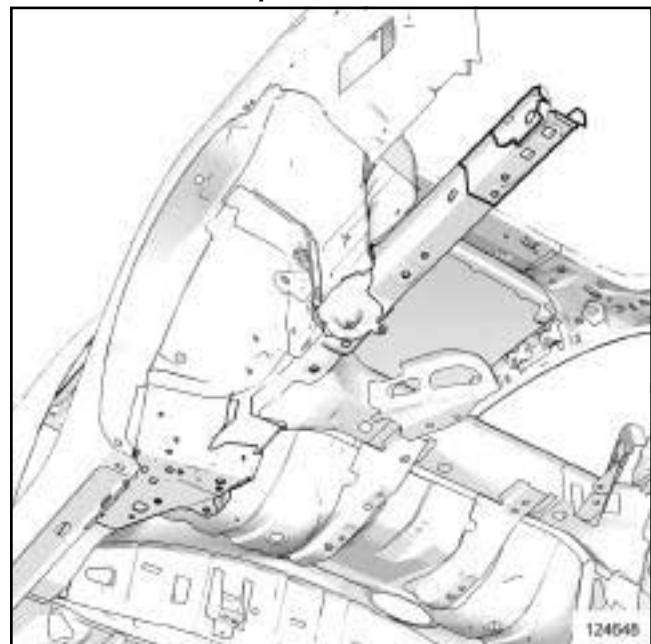
124650

124650

No.	Description	Type	Thickness (mm)
(1)	Rear section of rear side member	HEL	1.7
(2)	Suspension spring support	HEL	1.97
(3)	Towing ring mounting	Mild steel	1.47

II - PART IN POSITION

Rear end section replacement



124648

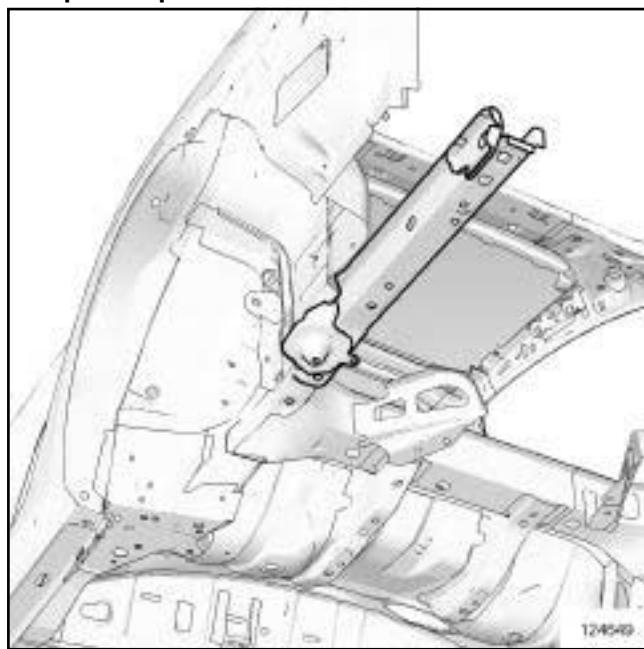
WARNING

To conserve the vehicle's mechanical specifications, respect the position of the cut: it is determined according to the mounting points of the mechanical components.

REAR LOWER STRUCTURE
Rear side member: Description

41D

Complete replacement



124649

Note:

For a detailed description of welded connections,
see **MR 400**.

Rear floor rear cross member: General description

K91

Note:

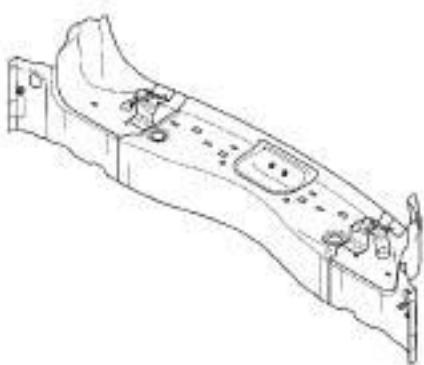
The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading this general information, check that there are no special notes associated with this vehicle. These special notes will be specified if applicable in other parts of this subsection dealing with the part.

DESIGN OF THE STRUCTURAL COMPONENT

Note:

For a detailed description of a particular connection, see **MR 400**.



122752

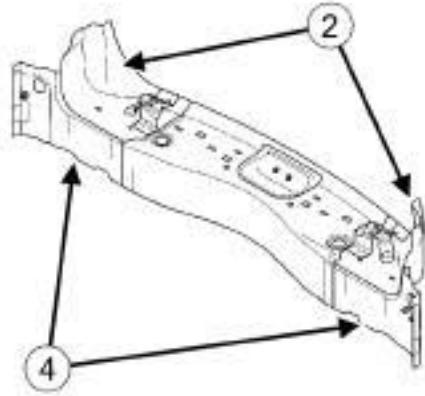
122752

This serves as a rear floor rear cross member, it consists of an assembly of several parts that can be unclipped from the new part depending on the requirements of the impact concerned.

WARNING

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**).

K91



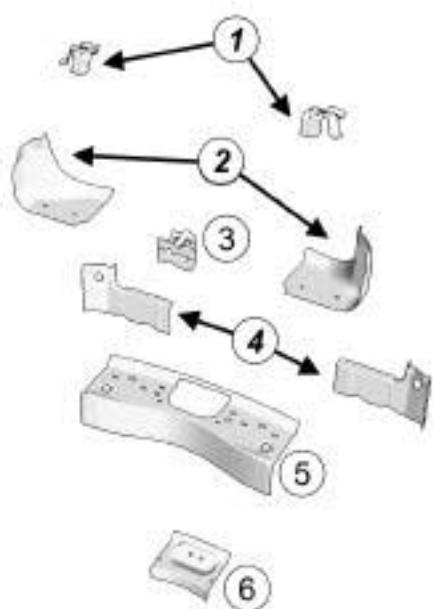
122752

122752

There are several ways of replacing this part:

- complete replacement.
- partial replacement without the side parts (2) and (4) of the right-hand or left-hand side, that can be unclipped from the new part beforehand.

I - COMPOSITION OF THE SPARE PART

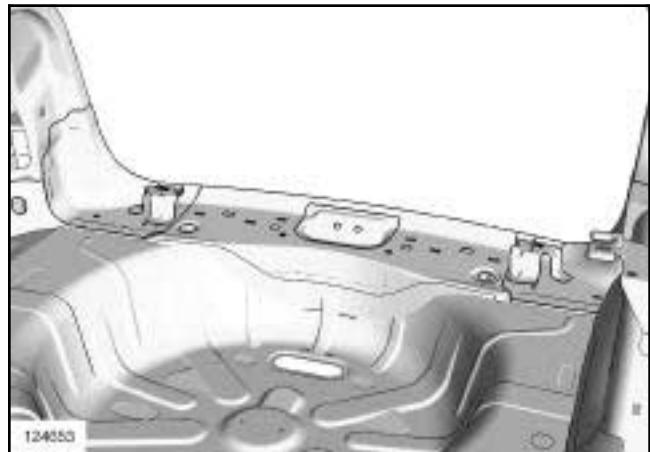


124652

124652

No.	Description	Type	Thickness (mm)
(1)	Lashing ring reinforcement	HLE	1.5
(2)	Floor cross member closure panel component	Mild steel	0.8
(3)	Towing ring mounting	HLE	2
(4)	Rear pillar lower reinforcement	Mild steel	1.2
(5)	Rear end cross member	Mild steel	0.8
(6)	Rear end panel striker panel reinforcement	Mild steel	1.2

II - PART FITTED



124653

Note:

For a detailed description of the welded connections, see **MR 400**.

IMPORTANT

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

This type of part is used when there has been a large rear collision (3rd degree) for putting back together the rear geometry of the vehicle's subframe.

It is carried out on a restructuring bench with geometric inspection (body jig bench).

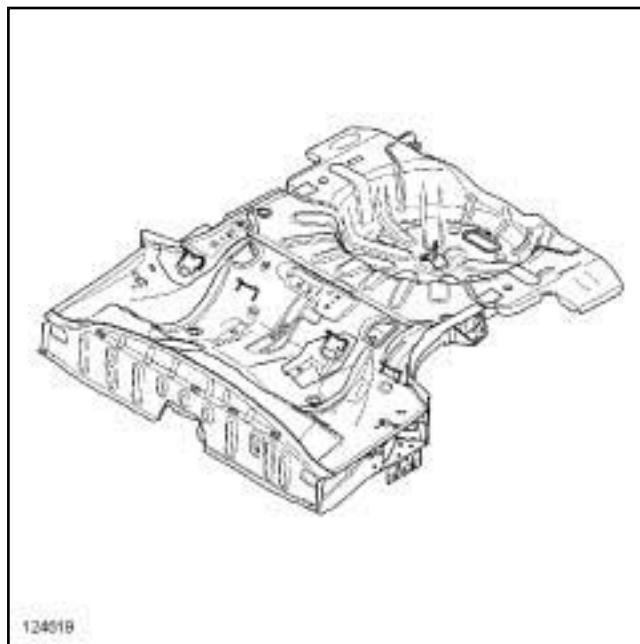
Note:

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading this general information, check that there are no special notes associated with this vehicle. These special notes will be specified if applicable in other parts of this subsection dealing with the part.

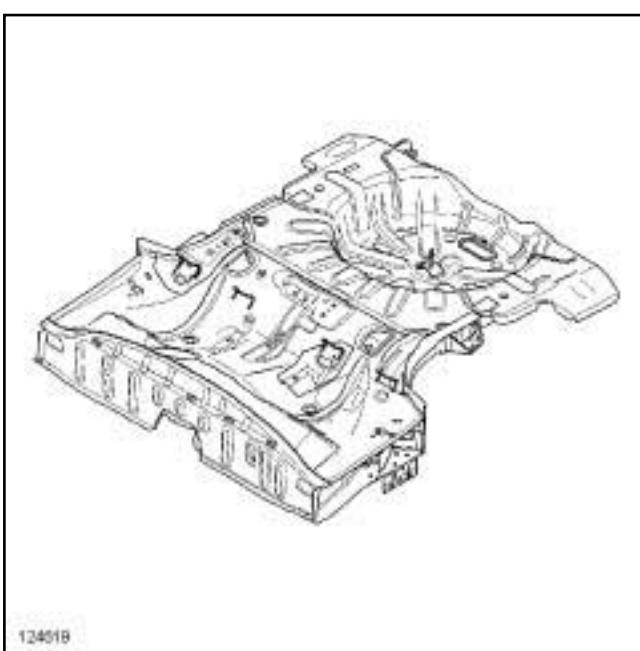
Note:

For a detailed description of a particular connection, see **MR 400**.

DESIGN OF THE STRUCTURAL COMPONENT

The special feature of this type of part is that it combines several functional parts made up of several panels of different types and thicknesses:

- rear section and front section of rear floor
- front cross member of rear floor
- centre cross member of rear floor
- rear side member assembly.

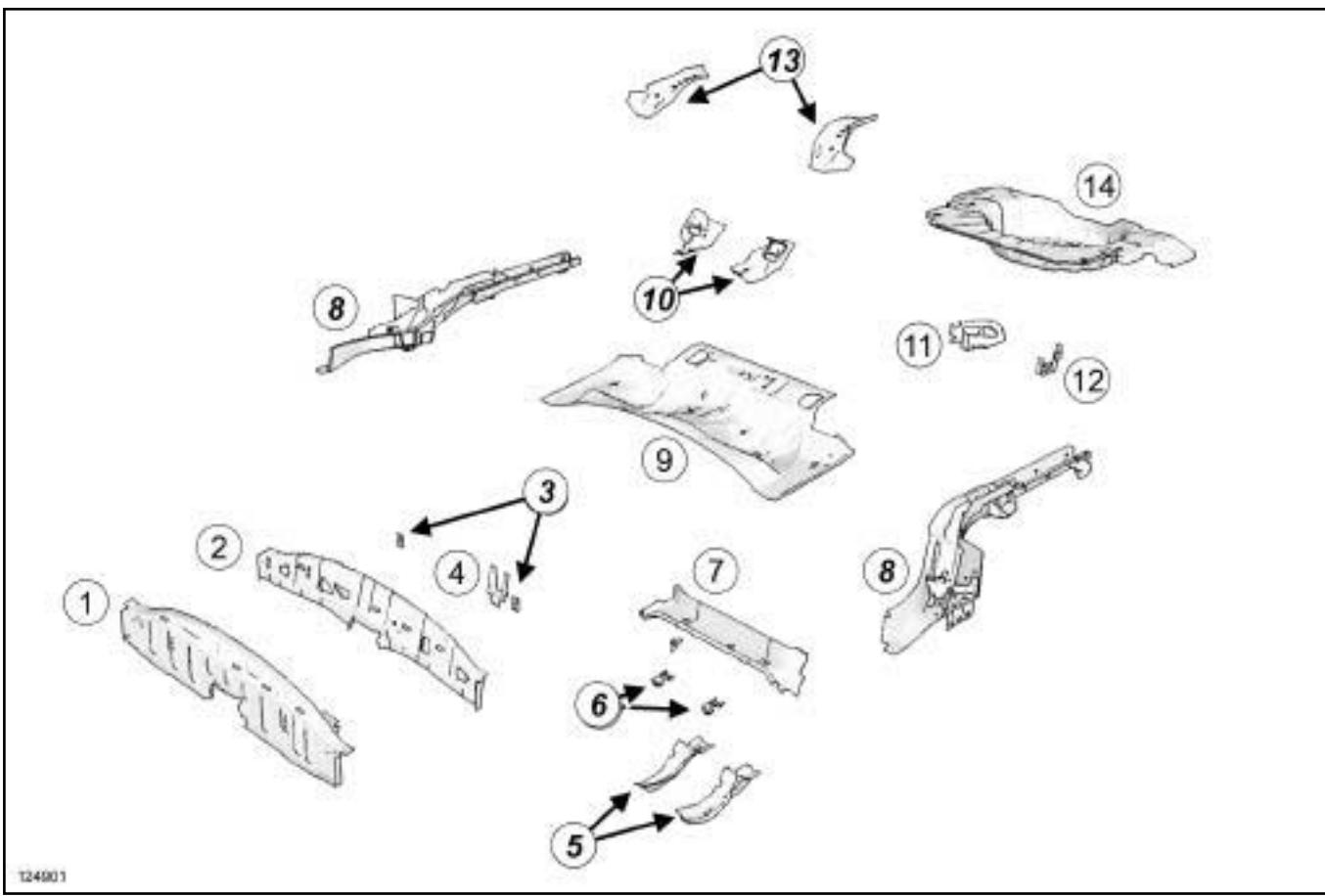


124619

There is only one way of replacing this part:

- complete replacement.

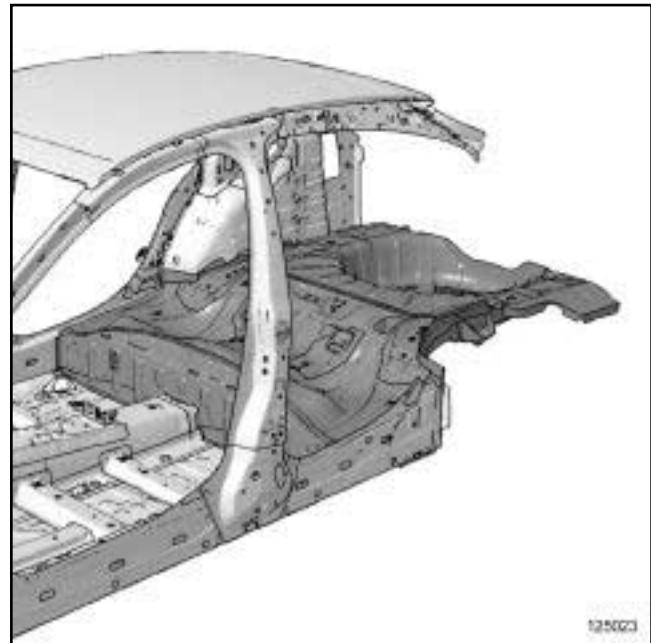
I - COMPOSITION OF THE SPARE PART



124901

II - PART IN POSITION

No.	Description	Type	Thickness (mm)
(1)	Rear floor cross member	HEL	0.97
(2)	Partitioning cross member	HEL	0.97
(3)	Child/baby seat anchoring exterior plate	Mild steel	2
(4)	Partitioning cross member tank mounting	HEL	1.47
(5)	Rear seat anchoring centre stiffener	HEL	1.17
(6)	Seat belt anchoring spacer	HEL	1.47
(7)	Rear centre cross member	HEL	1.17
(8)	Rear side member assembly		
(9)	Front section of rear floor	Mild steel	0.67
(10)	Child/baby seat central reinforcement	HEL	1.47
(11)	Floor sound-proofing bracket	Mild steel	1.5
(12)	Rear axle mounting exterior reinforcement	HEL	1.97
(13)	Seatback mounting joint stiffener	Mild steel	1.47
(14)	Rear floor rear section	Mild steel	0.7



125023

Note:

For a detailed description of welded connections, see **MR 400**.

IMPORTANT

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

FRONT UPPER STRUCTURE

Front wing: General description

42A

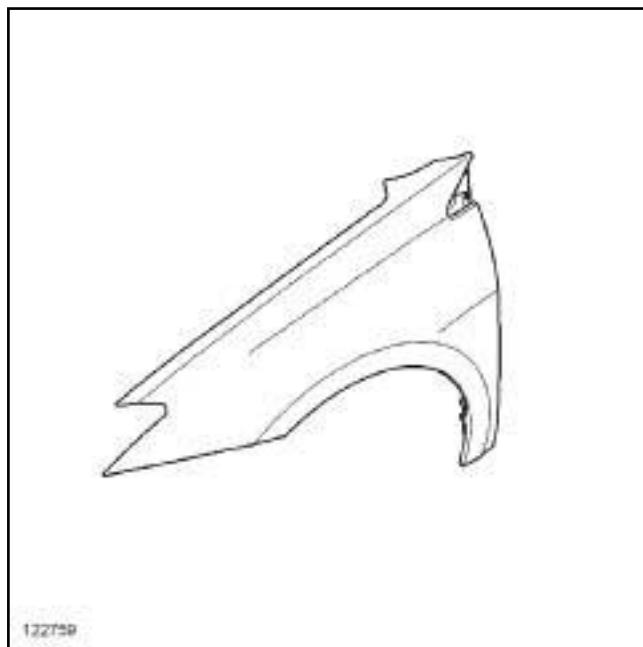
B91 or D91 or K91

Note:

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

I - DESIGN OF THE STRUCTURAL COMPONENT



122759

This is a basic part; it is made of steel and is bolted onto its upper mounting support.

II - REMOVAL - REFITTING

Note:

In all cases of removal of a component without its replacement with a new one, mark the position of the mountings before removing the mountings to avoid adjustments during refitting.

To remove or replace the front wing, remove:

- the front wheel arch liner,
- the front bumper,
- the headlight,
- the windscreen lower trim piece.

III - ADJUSTMENT

Note:

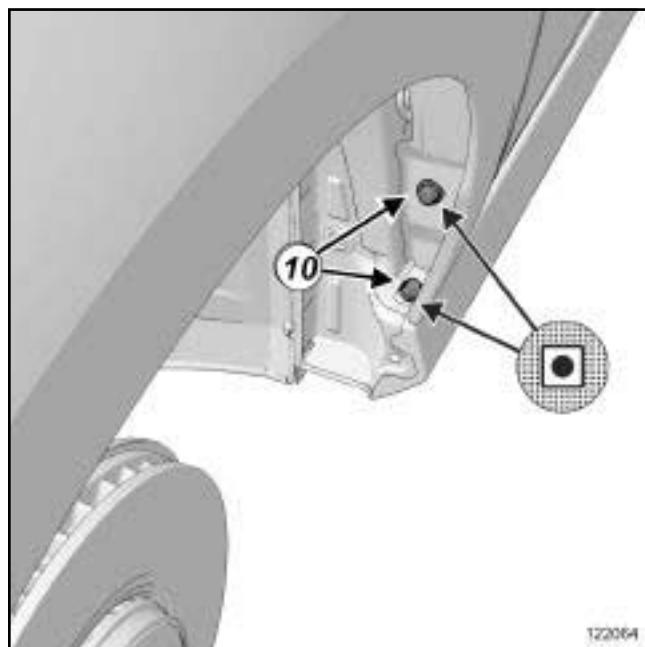
The front wing is the penultimate removable component to be fitted to the vehicle body in the factory.

For final adjustment, correctly position all the other components including the bumper and the headlights for them to be correctly positioned.

Two main areas of adjustment may be identified:

- the adjustment of the rear area,
- the adjustment of the front area

1 - Adjustment of the rear area:



122064

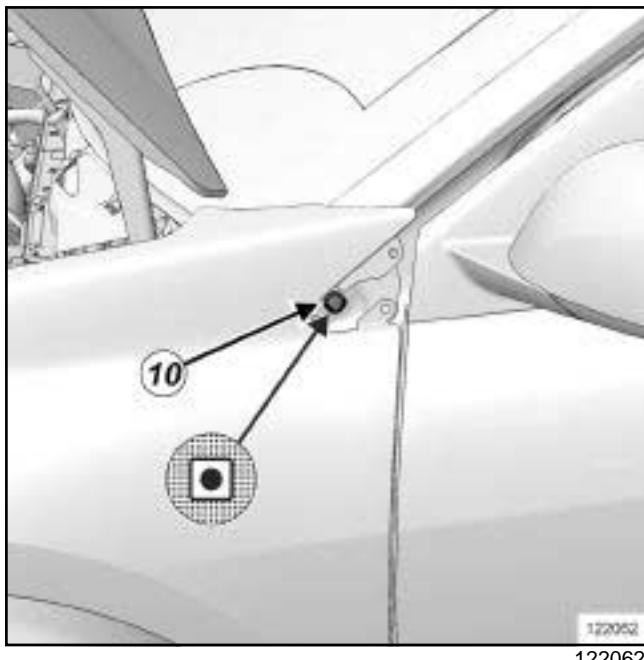
122064

FRONT UPPER STRUCTURE

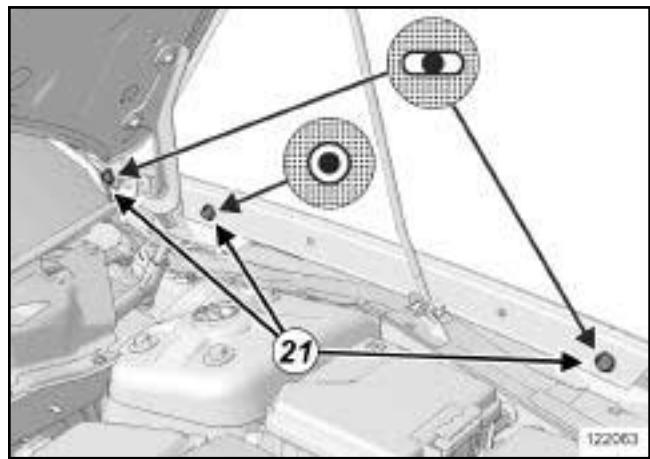
Front wing: General description

42A

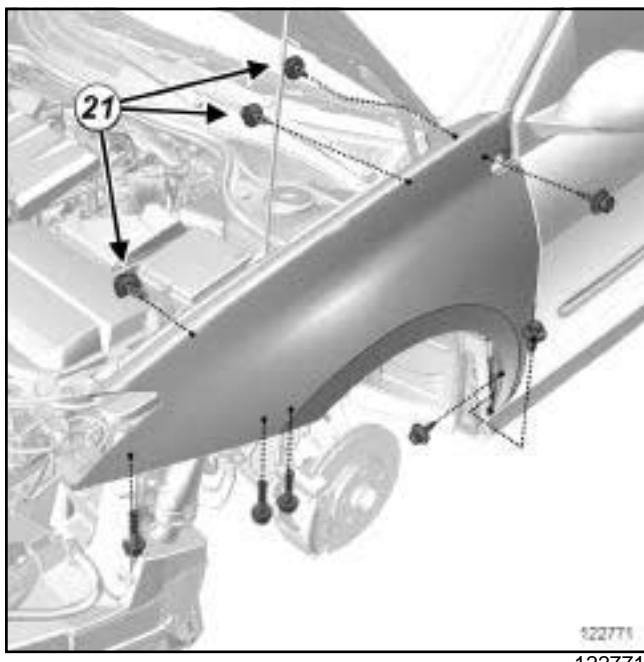
B91 or D91 or K91



Adjust the panel gaps and alignment with the front door using mountings (10) .



Adjust the alignment of the wing using mountings (21) .



FRONT UPPER STRUCTURE

Front wing: Removal - Refitting

42A

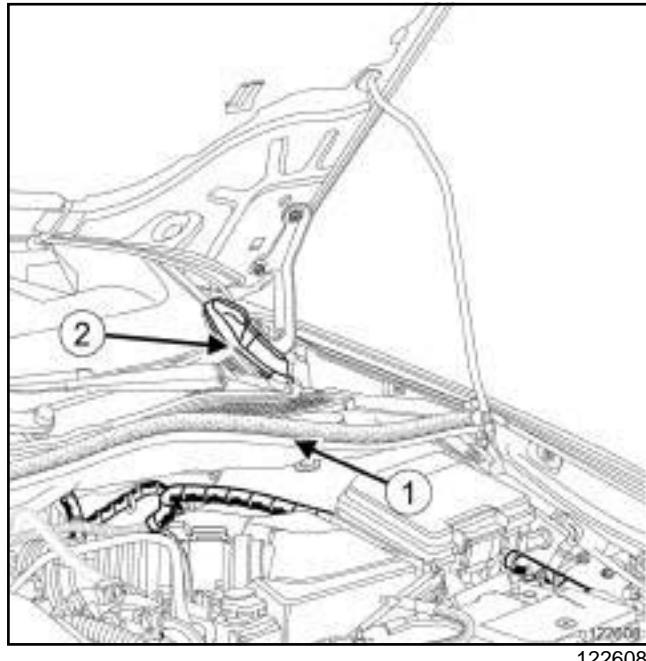
B91 or K91

REMOVAL

I - REMOVAL PREPARATION OPERATION

Remove:

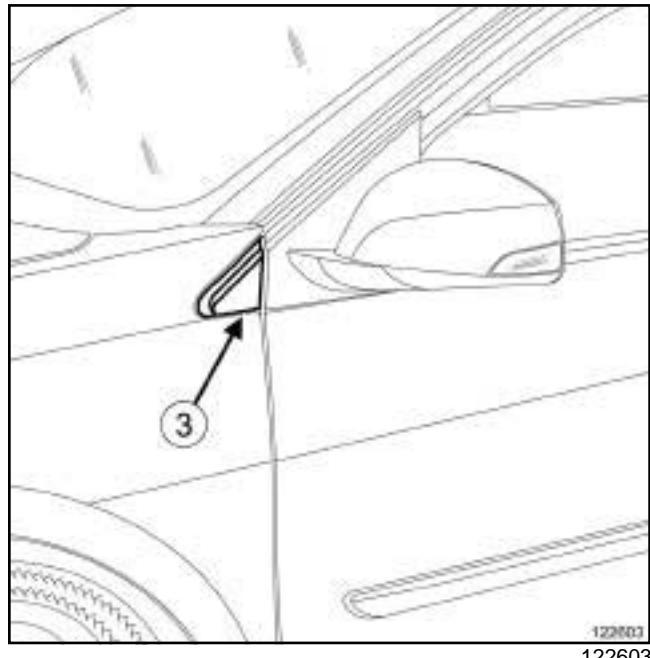
- the front wheel arch liner (see **Front wheel arch liner: Removal - Refitting**) (MR 416, 55A, Exterior protection),
- the front bumper (see **Front bumper: Removal - Refitting**) (MR 416, 55A, Exterior protection),
- the headlight (see **Headlight: Removal - Refitting**) (MR 415, 80B, Headlights).



122608

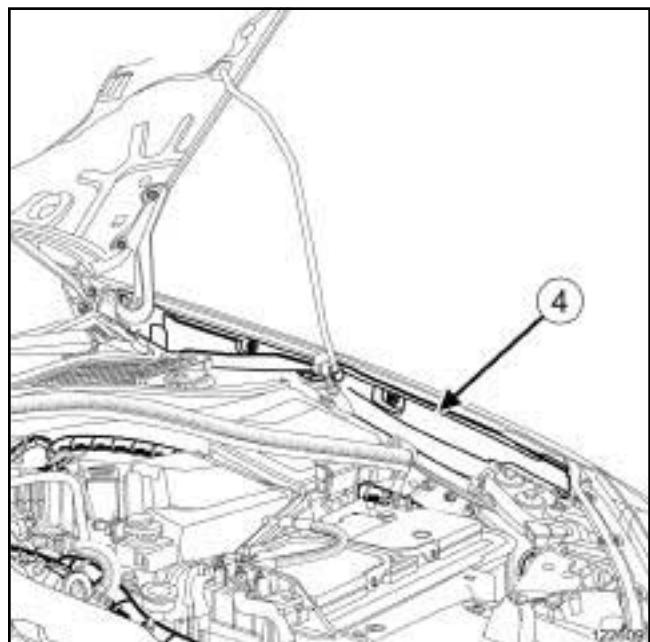
Partially remove the seal (1) .

Remove the windscreen lower trim piece (2) .



122603

Remove the trim (3) .

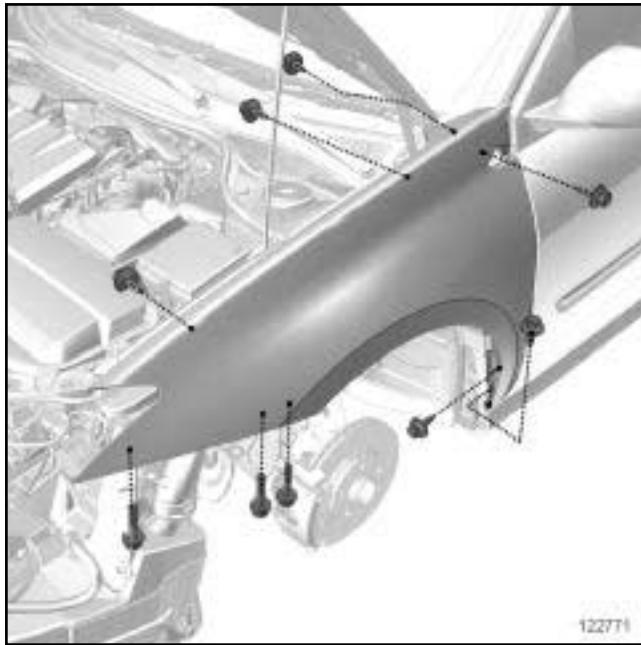


122609

Remove the wing upper trim (4) .

B91 or K91

II - OPERATION FOR REMOVAL OF PART CONCERNED



122771

- Remove:
 - the bolts,
 - the front wing.

REFITTING

I - REFITTING OPERATION FOR PART CONCERNED

- Refit:
 - the front wing,
 - the bolts.

II - FINAL OPERATION

- Refit:
 - the wing upper trim (4),
 - the trim (3),
 - the windscreens lower trim piece (2),
 - the seal (1),
 - the headlight (see **Headlight: Removal - Refitting**) (MR 415, 80B, Headlights),
 - the front bumper (see **Front bumper: Removal - Refitting**) (MR 416, 55A, Exterior protection),
 - the front wheel arch liner (see **Front wheel arch liner: Removal - Refitting**) (MR 416, 55A, Exterior protection).

FRONT UPPER STRUCTURE

Front wing: Removal - Refitting

42A

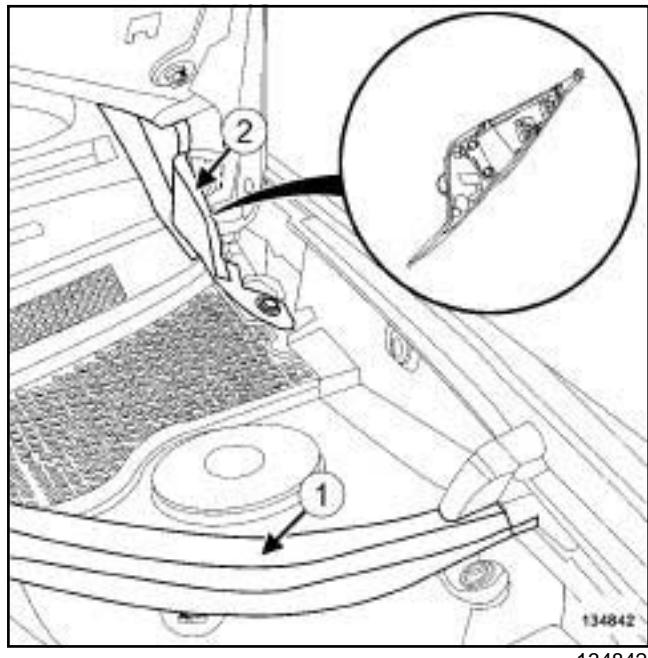
D91

REMOVAL

I - REMOVAL PREPARATION OPERATION

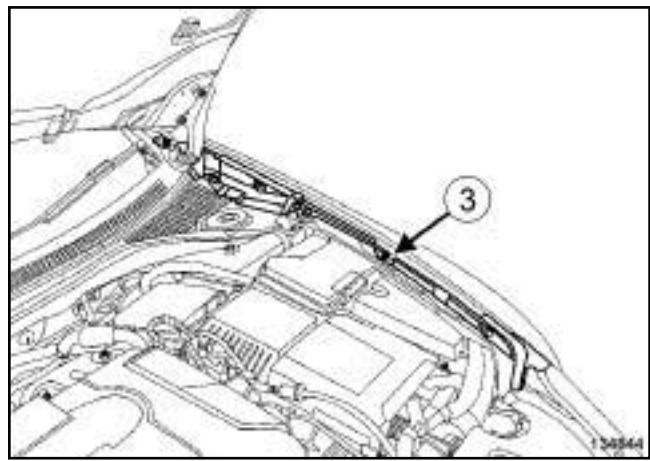
Remove:

- the front wheel arch liners (see **Front wheel arch liner: Removal - Refitting**) (55A, Exterior protection),
- the front bumper (see **Front bumper: Removal - Refitting**) (55A, Exterior protection),
- the headlight on the side concerned (see **Headlight: Removal - Refitting**) (80B, Headlights).
- the front side door seal on the side concerned (see **Front side door seal: Removal - Refitting**) (65A, Opening element sealing).

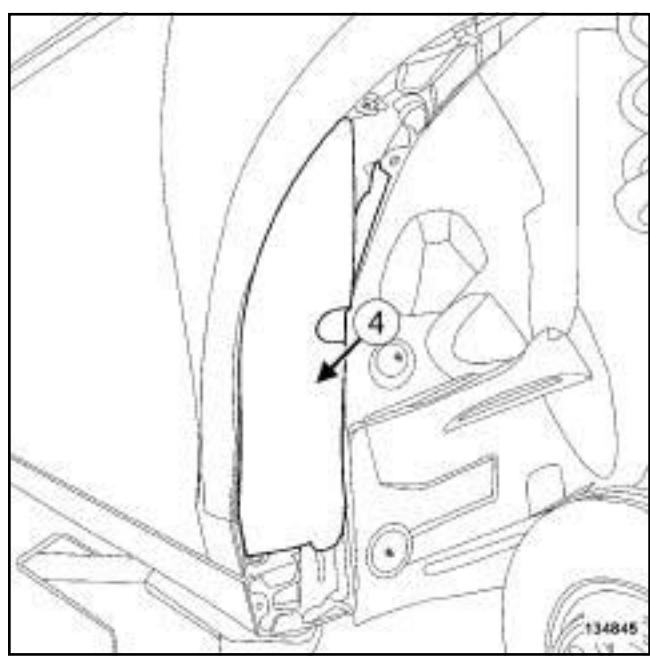


Partially remove the seal (1) .

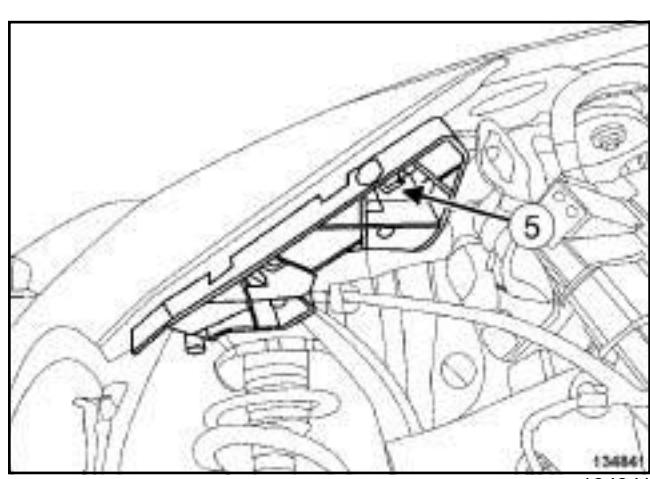
Remove the windscreens lower trim piece (2) .



Remove the wing upper trim (3) .



Remove the soundproofing pad (4) .



Remove the front bumper support (5) .

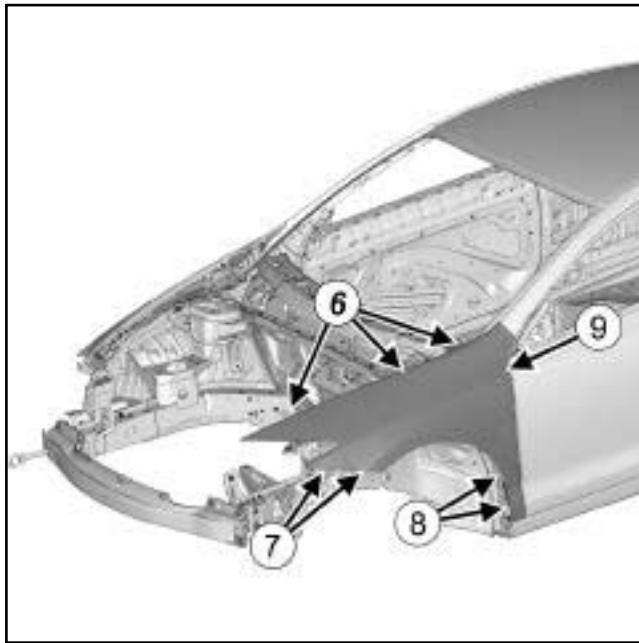
FRONT UPPER STRUCTURE

Front wing: Removal - Refitting

42A

D91

II - OPERATION FOR REMOVAL OF PART CONCERNED



134919

Remove:

- the bolts (6) , (7) , (8) and (9) ,
- the front wing.

REFITTING

I - REFITTING OPERATION FOR PART CONCERNED

Refit:

- the front wing,
- bolts (6) , (7) , (8) and (9) .

II - FINAL OPERATION

Refit:

- the front bumper support (5) ,
- the soundproofing (4) ,
- the wing upper trim (3) ,
- the windscreens lower trim piece (2) ,
- the seal (1) ,
- the front side door seal (see **Front side door seal: Removal - Refitting**) (65A, Opening element sealing),
- the headlight (see **Headlight: Removal - Refitting**) (80B, Headlights),

- the front bumper (see **Front bumper: Removal - Refitting**) (55A, Exterior protection) ,

- the front wheel arch liners (see **Front wheel arch liner: Removal - Refitting**) (55A, Exterior protection).

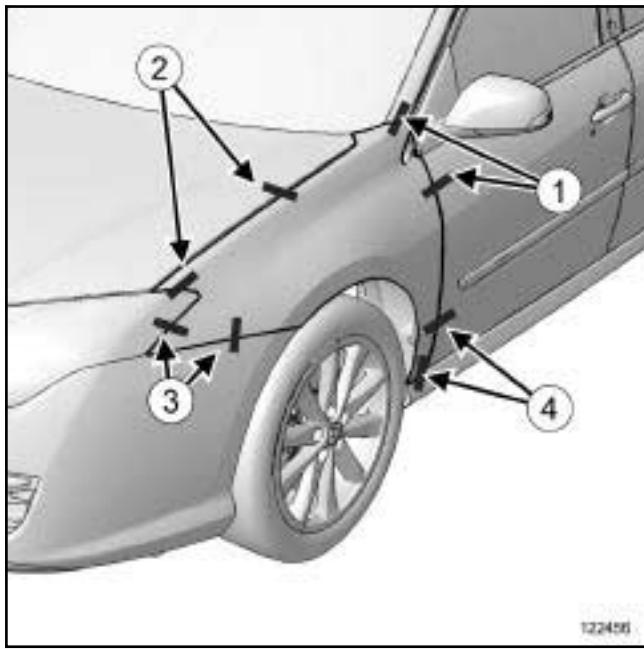
B91 or K91

ADJUSTMENT VALUES

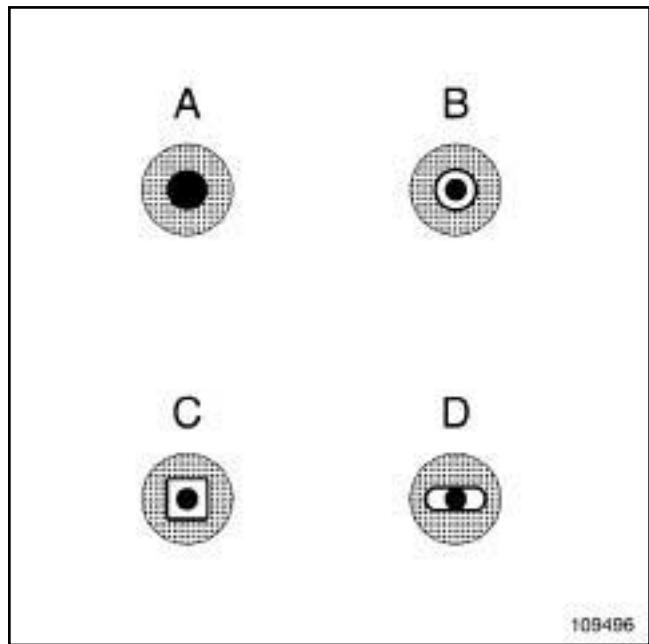
- For all information regarding wing adjustment values, (see **Vehicle panel gaps: Adjustment value**) (01C, Vehicle bodywork specifications).

ADJUSTMENT

- There are three possible front wing adjustments:
- Adjustment with the front door
 - Adjustment with the bonnet
 - Adjustment with the headlight and bumper



- For information on panel gap values (see **Vehicle panel gaps: Adjustment value**) (01C, Vehicle bodywork specifications).
- Observe the adjustment sequence (1), (2), (3) and (4)



- Symbols A, B, C and D show the adjustment options.

The black dot in the centre represents the body of the bolt.

The grey section represents the component to be adjusted.

The white section represents the adjustment area.

I - PREPARATION FOR THE ADJUSTMENT.

- Remove:
- the front wheel arch liner (see **Front wheel arch liner: Removal - Refitting**) (55A, Exterior protection),
 - the front bumper (see **Front bumper: Removal - Refitting**) (55A, Exterior protection).

II - ADJUSTMENT WITH THE BONNET AND THE FRONT HEADLIGHT**Note:**

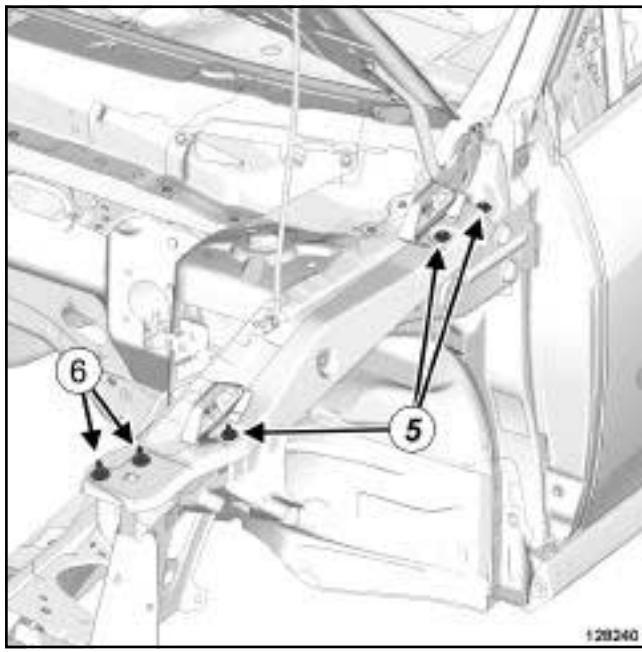
The adjustment with the bonnet and the front headlight is done with the nuts on the front wing upper attachment mounting with the front wing removed.

- Remove:

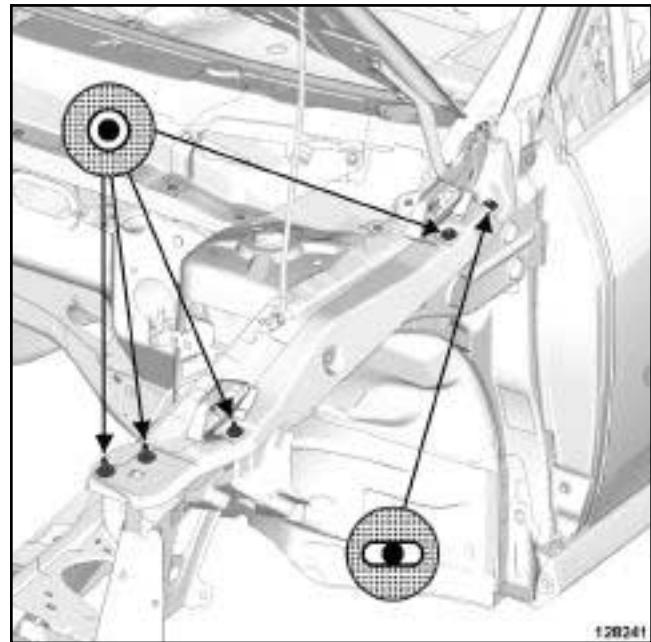
- the headlight (see **Headlight: Removal - Refitting**) (80B, Headlights),

B91 or K91

- the front wing (see **42A, Front upper structure, Front wing: Removal - Refitting**, page **42A-3**) .



128240



128241

Loosen the mountings (5) and (6) .

Refit:

- the front wing,
- the headlight.

Adjust the front wing.

Tighten the bolts (6) .

Remove:

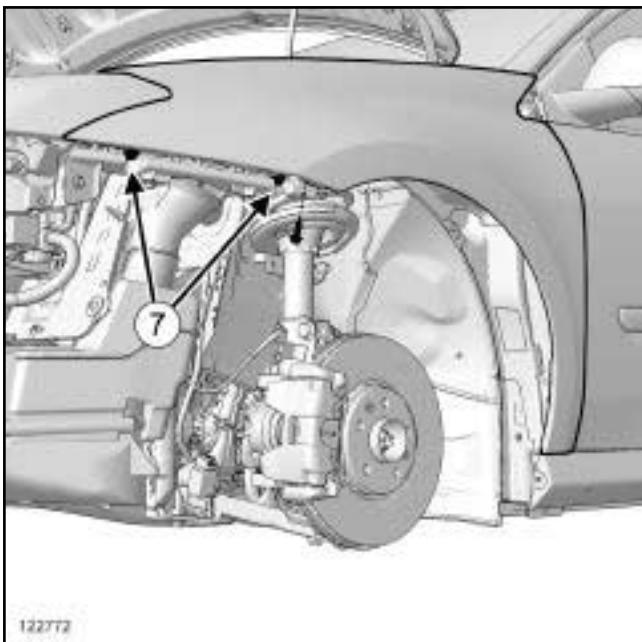
- the front wing,
- the headlight.

Tighten the nuts (5) .

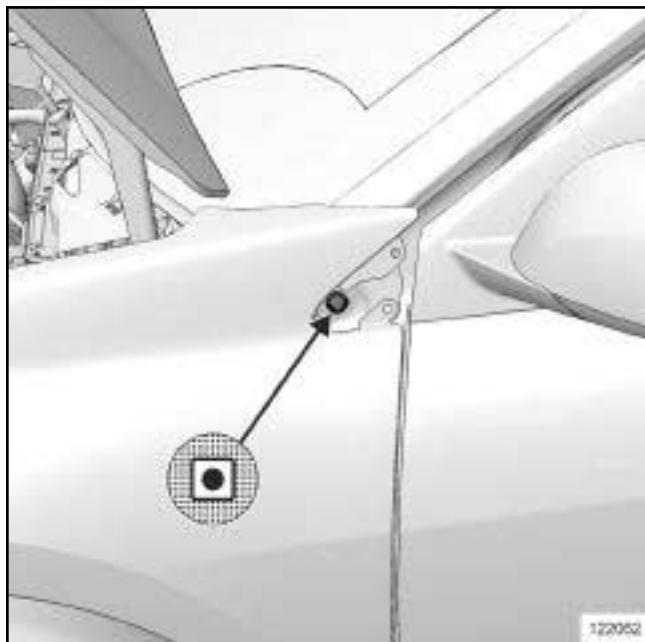
Refit:

- the front wing (see **42A, Front upper structure, Front wing: Removal - Refitting**, page **42A-3**),
- the front headlight (see **Headlight: Removal - Re-fitting**) (80B, Front headlights).

B91 or K91



122772

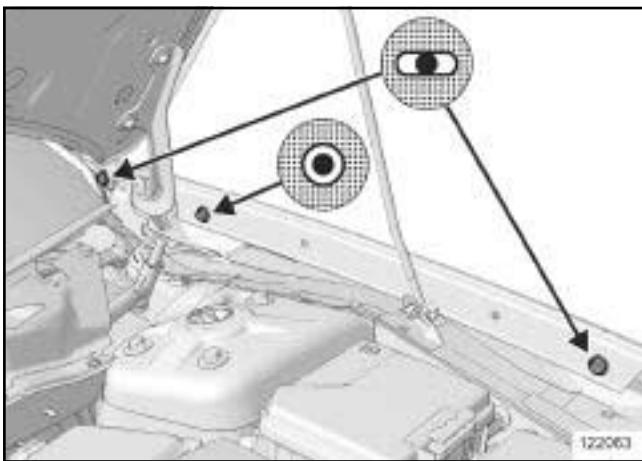


122062

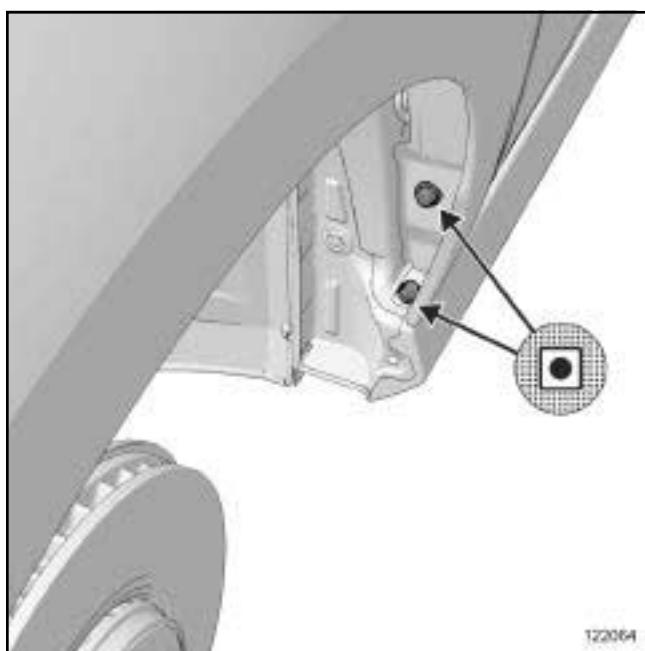
- Adjust the panel gaps between the front bumper and the front headlight.

III - ADJUSTMENT WITH FRONT BUMPER AND FRONT DOOR

- Remove:
 - the windscreen lower trim piece,
 - the wing upper trim.



122063



122064

- Adjust the panel gaps with the front door.

- Adjust the panel gaps with the front door and the sill panel.

- Refit:

- the wing upper trim,
- the windscreen lower trim piece.

IV - FINAL OPERATION

- Refit:

- the front bumper (see **Front bumper: Removal - Refitting**) (55A, Exterior protection),

B91 or K91

- the front wheel arch liner (see **Front wheel arch liner: Removal - Refitting**) (55A, Exterior protection).

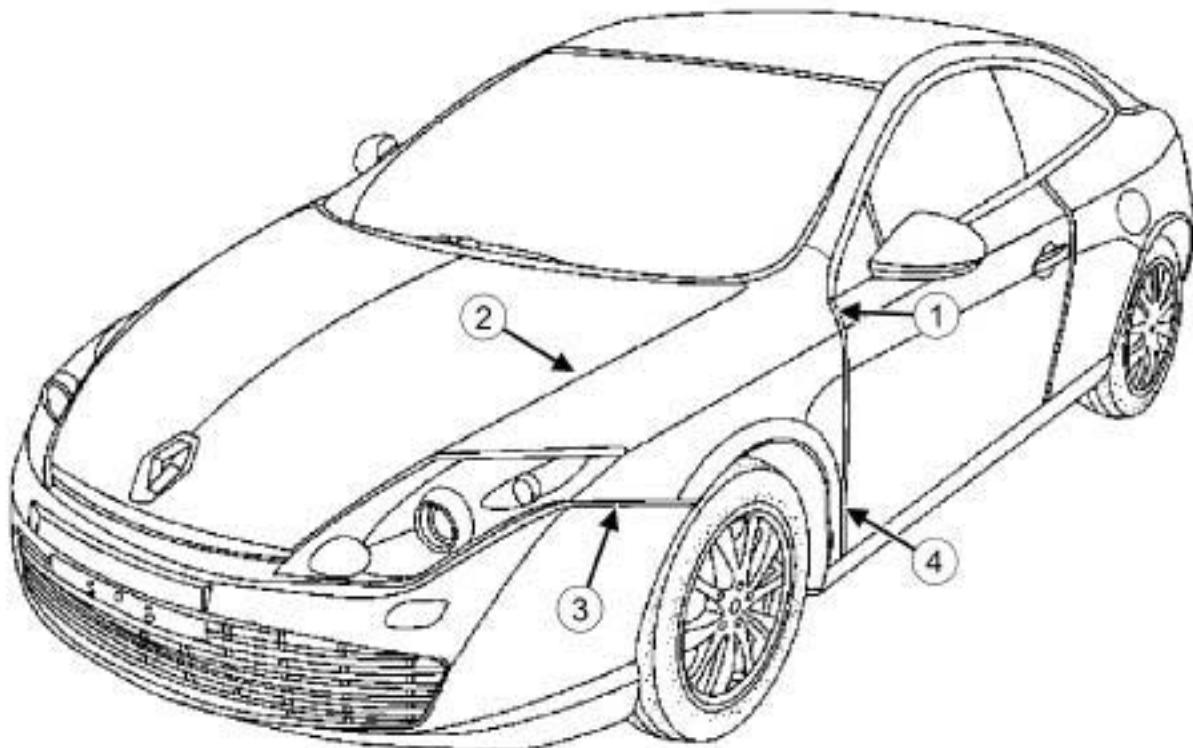
D91

ADJUSTMENT VALUES

- For all information regarding wing adjustment values, (see **Vehicle panel gaps: Adjustment value**) (01C, Vehicle bodywork specifications).

ADJUSTMENT

- There are three options for adjusting the front wing:
 - adjustment with the front door
 - adjustment with the bonnet
 - adjustment with the headlight and bumper



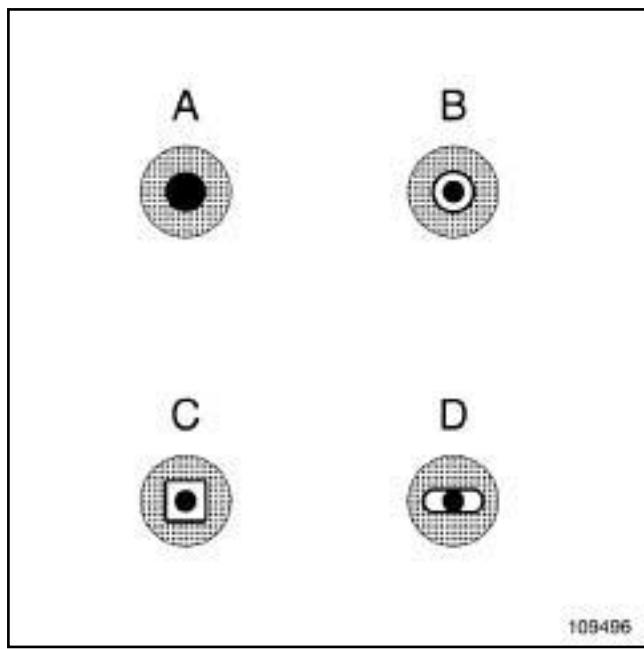
135220

135220

- For information on panel gap values (see **Vehicle panel gaps: Adjustment value**) (01C, Vehicle bodywork specifications).
- Observe the adjustment sequence (1) , (2) , (3) (4) .

D91

- the front wing (see 42A, Front upper structure, Front wing: Removal - Refitting, page 42A-3) .



- Symbols A, B, C and D show the adjustment options.

The black dot in the centre represents the body of the bolt.

The grey section represents the component to be adjusted.

The white section represents the adjustment area.

I - PREPARATION FOR THE ADJUSTMENT.

- Remove:

- the front wheel arch liners (see **Front wheel arch liner: Removal - Refitting**) (55A, Exterior protection),

- the front bumper (see **Front bumper: Removal - Refitting**) (55A, Exterior protection).

II - ADJUSTMENT WITH THE BONNET AND THE FRONT HEADLIGHT

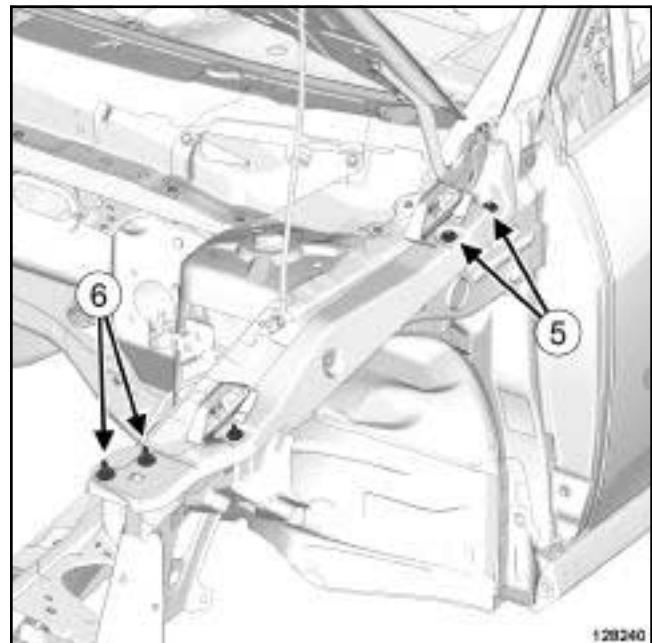
-

Note:

The adjustment with the bonnet and the front headlight is done with the nuts on the front wing upper attachment mounting with the front wing removed.

- Remove:

- the headlight on the side concerned (see **Headlight: Removal - Refitting**) (80B, Headlights),

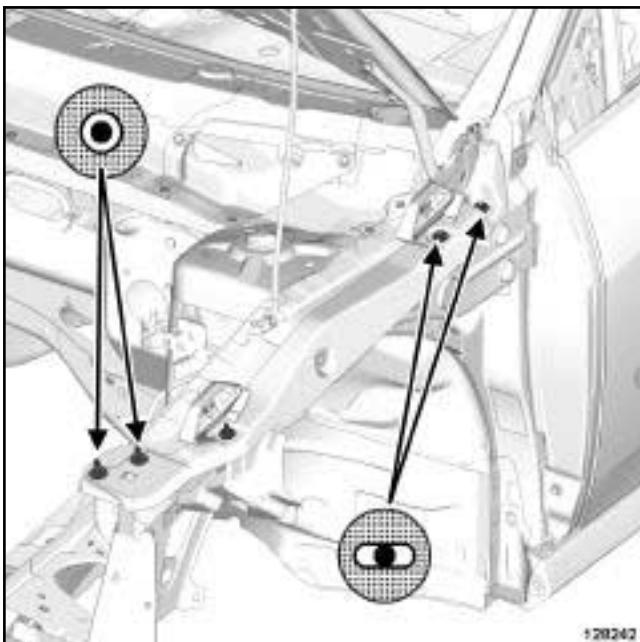


- Loosen the mountings (5) and (6) .

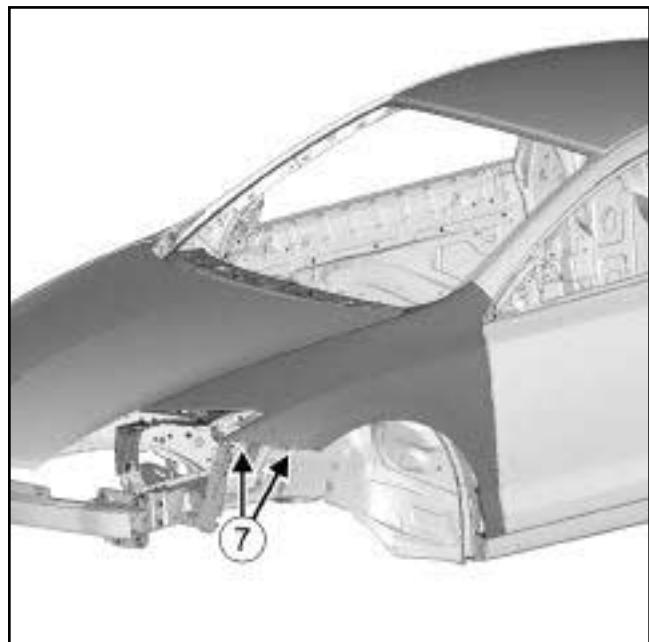
- Refit:

- the front wing,
- the headlight.

D91



128242



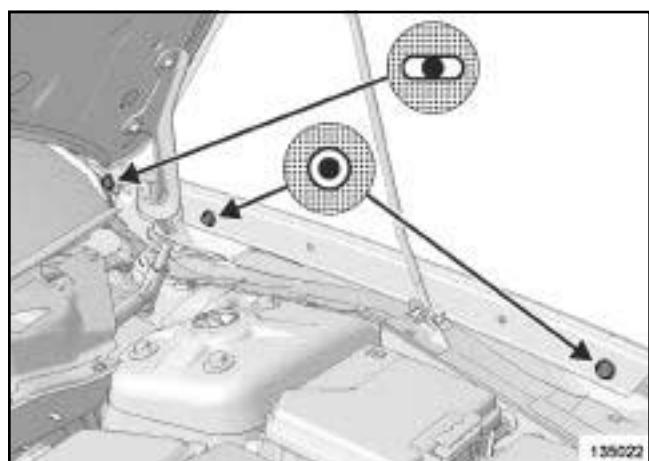
134918

- Adjust the front wing.
- Tighten the bolts (6).
- Remove:
 - the front wing,
 - the headlight.
- Tighten the nuts (5).
- Refit:
 - the front wing (see **42A, Front upper structure, Front wing: Removal - Refitting**, page 42A-3),
 - the front headlight (see **Headlight: Removal - Re-fitting** (80B, Front headlights)).

- Adjust the panel gaps between the front bumper and the headlight (7).

III - ADJUSTMENT WITH FRONT BUMPER AND FRONT DOOR

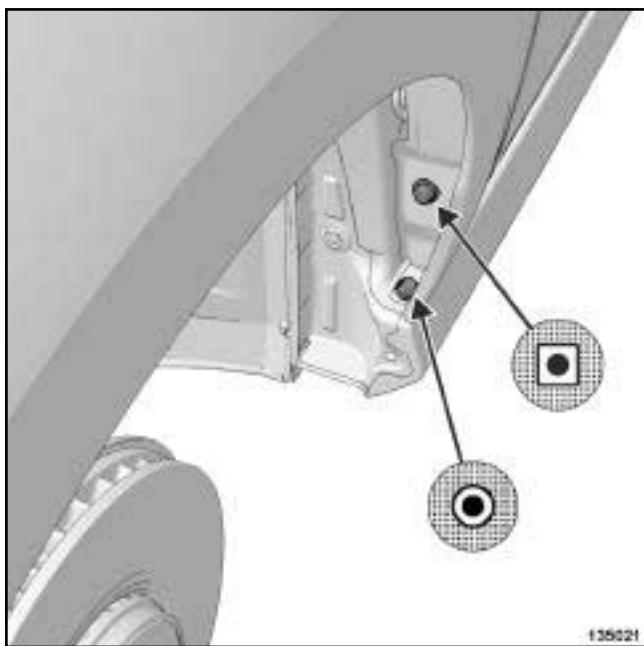
- Remove:
 - the windscreen lower trim piece,
 - the wing upper trim.



135022

- Adjust the panel gaps with the front door.

D91



135021

- Adjust the panel gaps with the front door and the sill panel.
- Refit:
 - the wing upper trim,
 - the windscreens lower trim piece.

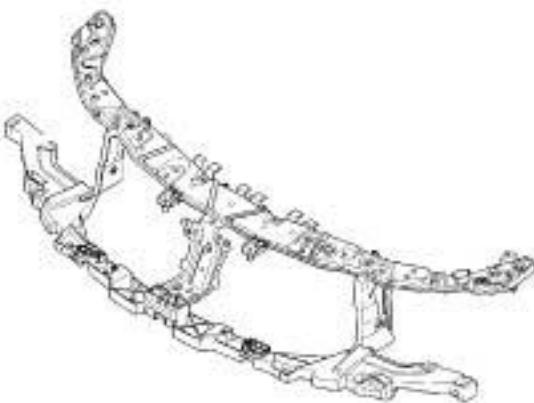
IV - FINAL OPERATION

- Refit:
 - the front bumper (see **Front bumper: Removal - Refitting**) (55A, Exterior protection),
 - the front wheel arch liners (see **Front wheel arch liner: Removal - Refitting**) (55A, Exterior protection).

Note:

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

DESIGN OF THE STRUCTURAL COMPONENT

122748

122748

A special feature of this part is that it is made out of composite materials, which cannot be repaired and are bolted onto the vehicle.

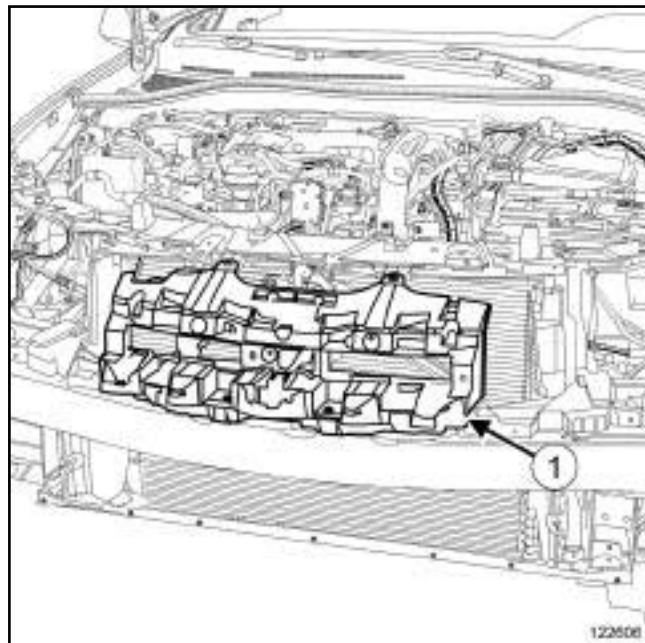
REMOVAL**I - REMOVAL PREPARATION OPERATION**

Remove:

- the front wheel arch liners (see **Front wheel arch liner: Removal - Refitting**) (MR 416, 55A, Exterior protection),
- the front bumper (see **Front bumper: Removal - Refitting**) (MR 416, 55A, Exterior protection),
- the headlights (see **Headlight: Removal - Refitting**) (MR 415, 80B, Headlights).

II - OPERATION FOR REMOVAL OF PART CONCERNED

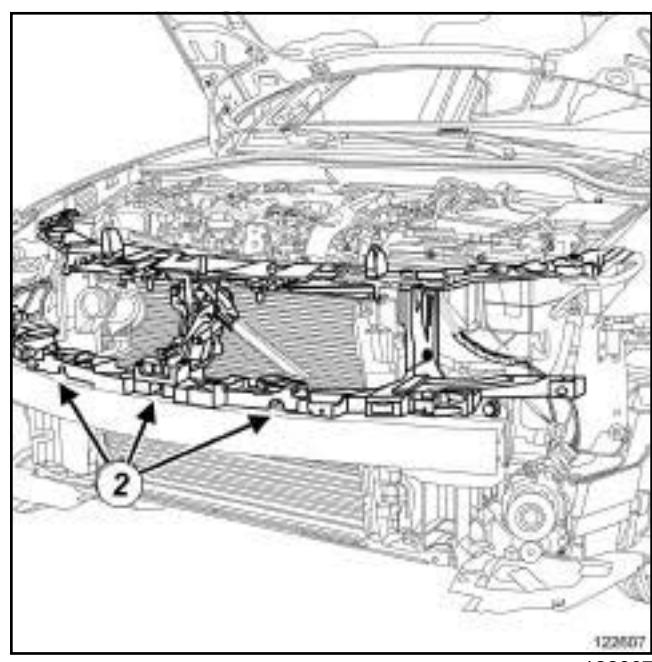
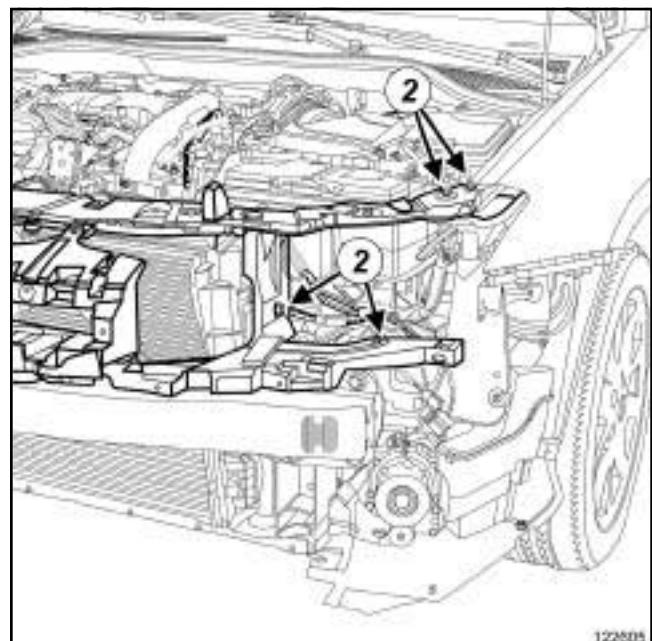
Unclip the windscreen washer bottle.



Remove:

- the front end panel central component (1) ,
- the bonnet lock (see **Bonnet lock: Removal - Refitting**) (MR 416, 52A, Non-side opening element mechanisms).

Disconnect the various connectors.



Remove:

- the bolts (2) ,
- the front end panel.

REFITTING**I - REFITTING OPERATION FOR PART CONCERNED**

Refit:

- the front end panel,
- the bolts.

- Connect the connectors.
- Refit:
 - the bonnet lock (see **Bonnet lock: Removal - Refitting**) (MR 416, 52A, Non-side opening element mechanisms),
 - the front end panel central component.
- Clip on the windscreen washer bottle.

II - FINAL OPERATION

- Refit:
 - the headlights (see **Headlight: Removal - Refitting**) (MR 415, 80B, Headlights),
 - the front bumper (see **Front bumper: Removal - Refitting**) (MR 416, 55A, Exterior protection),
 - the front wheel arch liners (see **Front wheel arch liner: Removal - Refitting**) (MR 416, 55A, Exterior protection).

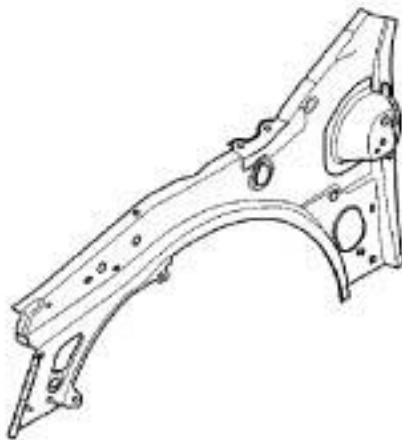
Note:

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

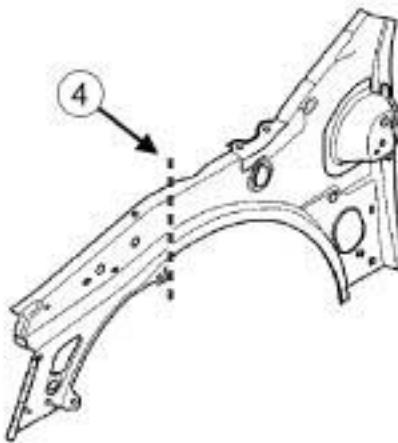
For a detailed description of a particular connection, see **MR 400**.

I - DESIGN OF THE STRUCTURAL COMPONENT

124582

124582

This part serves as a scuttle side panel and pillar lining, and consists of two sections of different thicknesses which are laser butt welded together prior to forming.

II - AREA TO BE CUT FOR PARTIAL REPLACEMENT124748
124748

The cutting line (4) must be along the original butt weld line.

III - ASSEMBLY METHOD FOR A PARTIAL REPLACEMENT

Only the connections which are specific to the partial replacement by cutting are indicated.

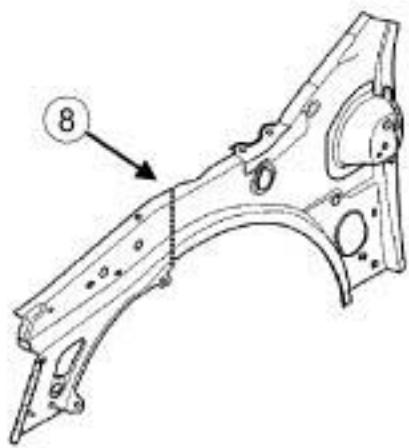
WARNING

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**).

If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400**).

FRONT UPPER STRUCTURE
Scuttle side panel: General description

42A



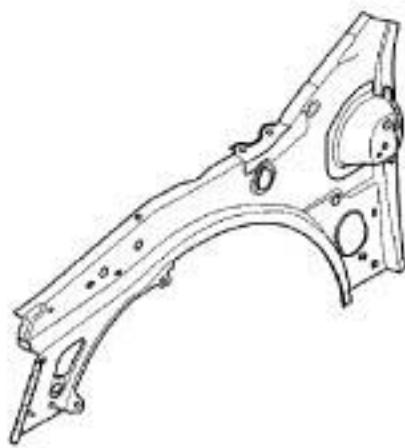
124749
124749

Line (8) on the diagram shows the partial replacement and an EGW butt weld. The weld must be made along the original butt weld line.

FRONT UPPER STRUCTURE

Scuttle side panel: Description

42A

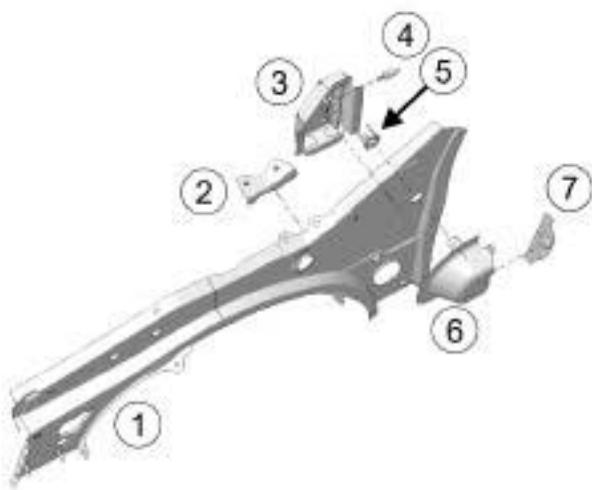


124582
124582

The options for replacing this part are as follows:

- front section replacement,
- rear section replacement,
- complete replacement.

I - COMPOSITION OF THE SPARE PART



124883
124883

No.	Description	Type	Thickness (mm)
(1)	Scuttle side panel	Mild steel	0.8 / 1
(2)	Windscreen wiper mounting side bridge piece	Mild steel	1.5
(3)	Dashboard cross member mounting	Very high yield strength	2
(4)	Threaded leader pin shaft		
(5)	Upper A-pillar spacer		
(6)	Upper pillar lower hinge reinforcement	Very high yield strength	2
(7)	Upper pillar angle bracket	Very high yield strength	2

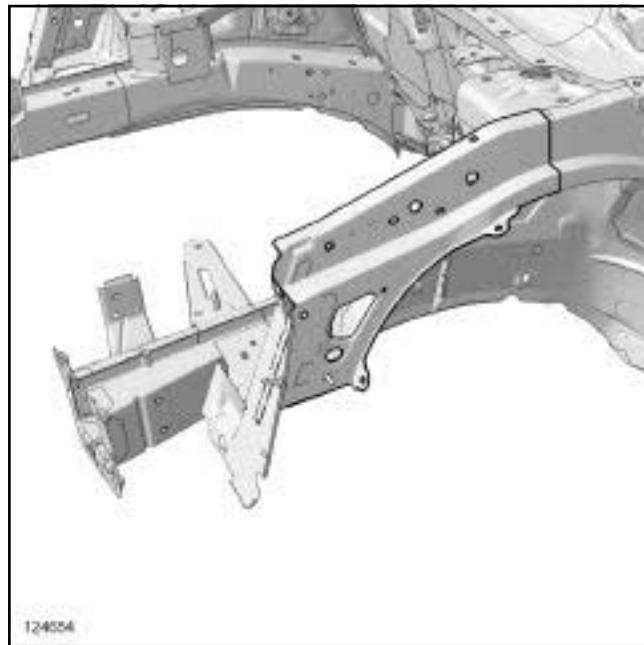
FRONT UPPER STRUCTURE

Scuttle side panel: Description

42A

II - PART IN POSITION

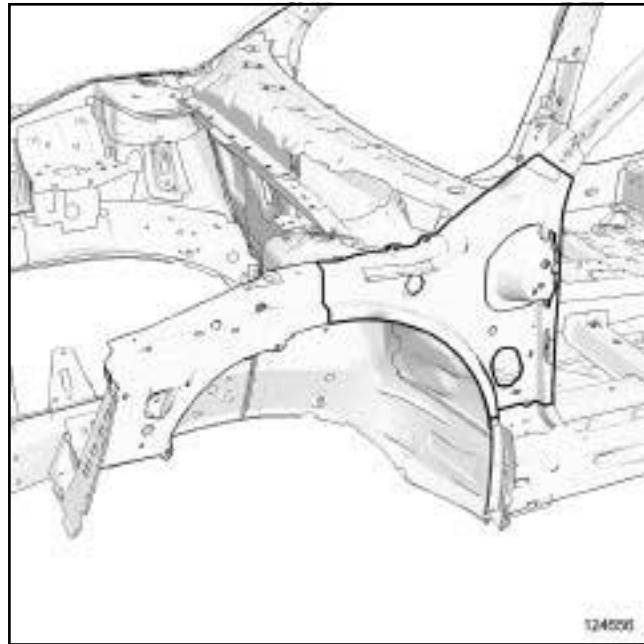
Front section replacement



124654

124654

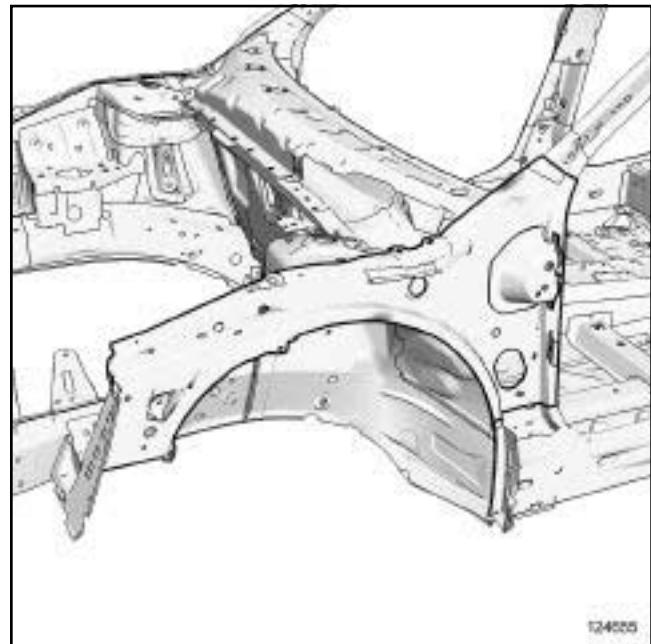
Rear section replacement



124655

124656

Complete replacement



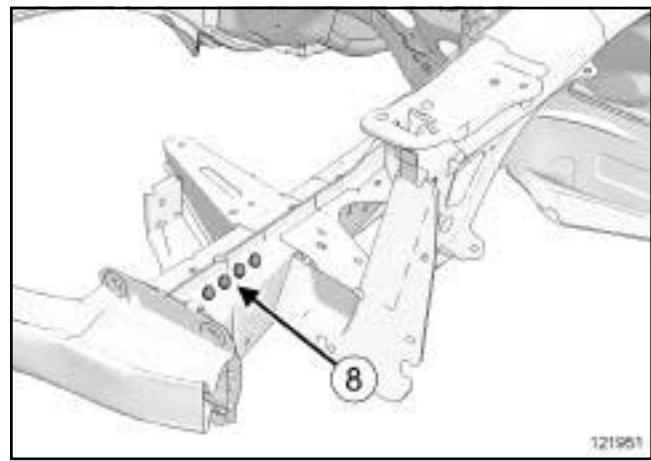
124655

124655

Note:

For a detailed description of welded connections, see **MR 400**.

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



121951

121951

WARNING

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**).

Note:

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400**.

DESIGN OF THE STRUCTURAL COMPONENT



124583

124583

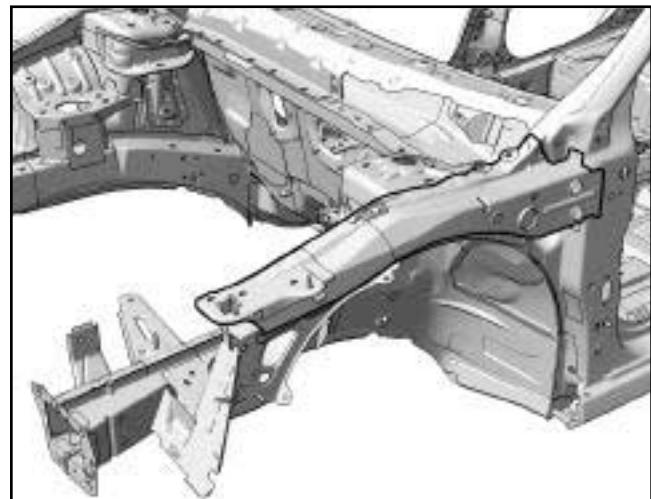
This type of part secures the front panel, the front wing upper mounting support, and the bonnet hinge mounting. It consists of two different sections which are initially laser butt welded together prior to forming.

II - PART IN POSITION



124653

124583



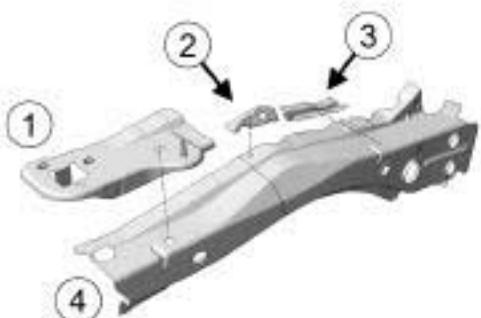
124658

124658

There is only one way of replacing this part:

- complete replacement.

I - COMPOSITION OF THE SPARE PART

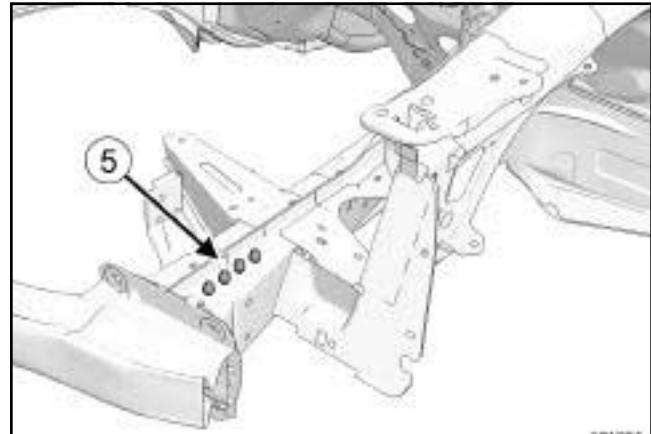


124657

Note:

For a detailed description of welded connections, see **MR 400**.

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



121951

121951

WARNING

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 closely as possible to the weld area (see **MR 400**).

No.	Description	Type	Thickness
(1)	Front end panel mounting reinforcement	Mild steel	1.3
(2)	Stay support bridge piece	HEL	1.2
(3)	A-pillar lining impact reinforcement	HEL	2
(4)	Cowl side panel upper reinforcement	HEL	0.7 / 1.2

IMPORTANT

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

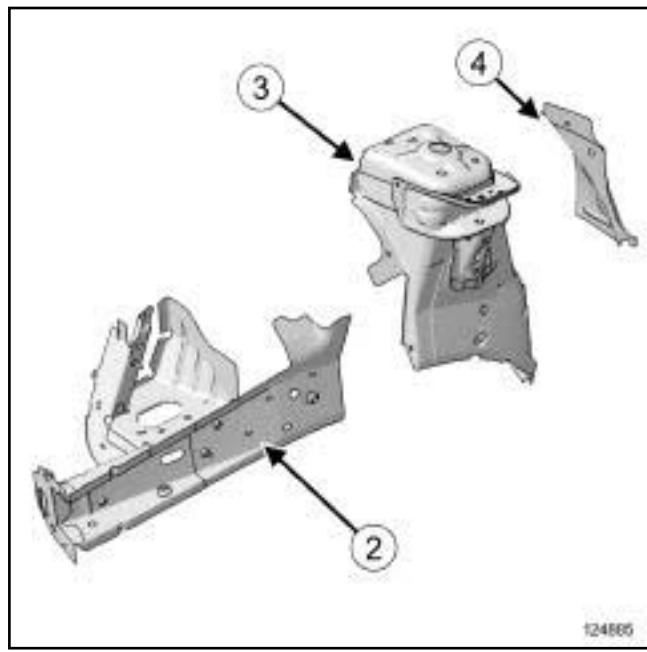
Note:

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400**.

DESIGN OF THE STRUCTURAL COMPONENT

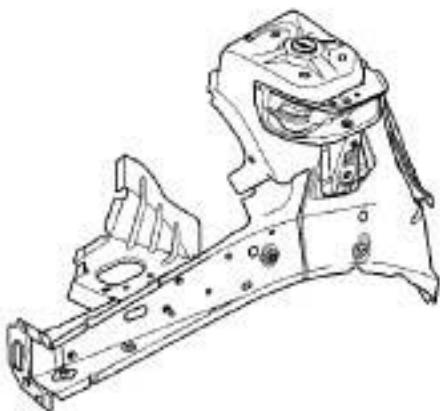
This part has the special feature of being composed of three parts:

- Front part (2) , which also serves as the side member closure panel.
- Centre part (3) , also called the shock absorber turret.
- Rear part (4) , which also serves as the side part of the bulkhead.

FRONT UPPER STRUCTURE

Front wheel arch: Description

42A



124585
124585

There is only one way of replacing this part:

- complete replacement.

IMPORTANT

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

I - COMPOSITION OF THE SPARE PART

Right-hand side



124660

No.	Description	Type	Thickness (mm)
(1)	Frontal impact cross member mounting	HEL	2.5
(2)	Side member closure panel component	HEL	1.67 /2.2
(3)	Front end side cross member	HEL	1.2
(4)	Wheel arch closure panel component	Mild steel	2
(5)	Front wheel arch, front section	Mild steel	2
(6)	Front wheel arch, centre section	Very high yield strength	1.8
(7)	Upper linkage support, lower section	Mild steel	2
(8)	Front wheel arch, rear section	Mild steel	0.77
(9)	Vibration limiter support, upper section	Mild steel	2.5
(10)	Shock absorber cup	HEL	2.2

FRONT UPPER STRUCTURE

Front wheel arch: Description

42A

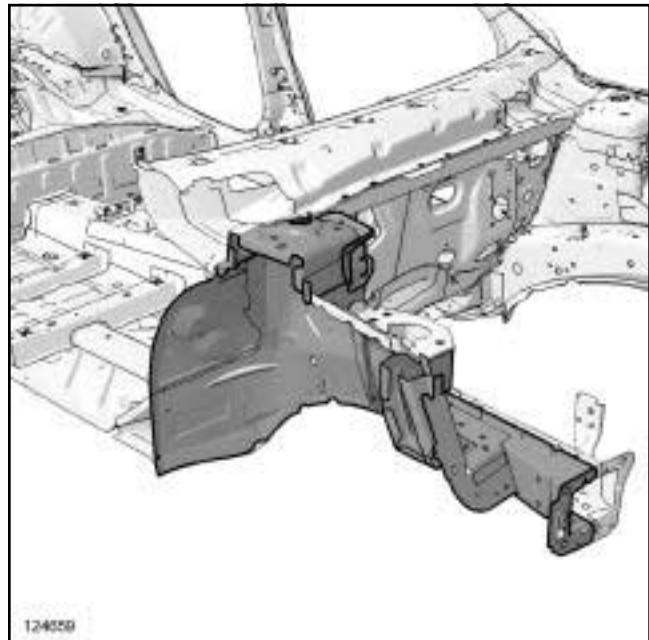
Left side



124661

No.	Description	Type	Thickness (mm)
(18)	Shock absorber cup	HEL	2.2
(19)	Front wheel arch, rear section	Mild steel	0.77

II - PART IN POSITION



124659

Note:

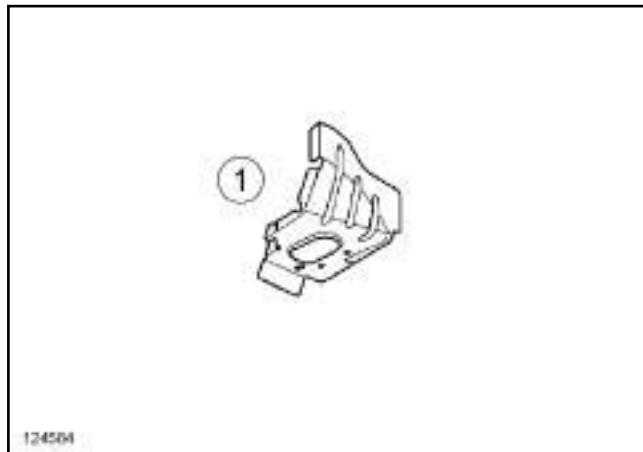
For a detailed description of welded connections, see **MR 400**.

No.	Description	Type	Thickness (mm)
(11)	Frontal impact cross member mounting	HEL	2.5
(12)	Front end side cross member	HEL	1.2
(13)	Side member closure panel component	HEL	1.67 /2.2
(14)	Front wheel arch closure panel component	HEL	1.2
(15)	Front wheel arch, front section	Very high yield strength	1.8
(16)	Gearbox linkage support mounting bridge piece	Mild steel	1.5
(17)	Gearbox control mounting reinforcement	Mild steel	1.5

There is only one way of replacing this part:

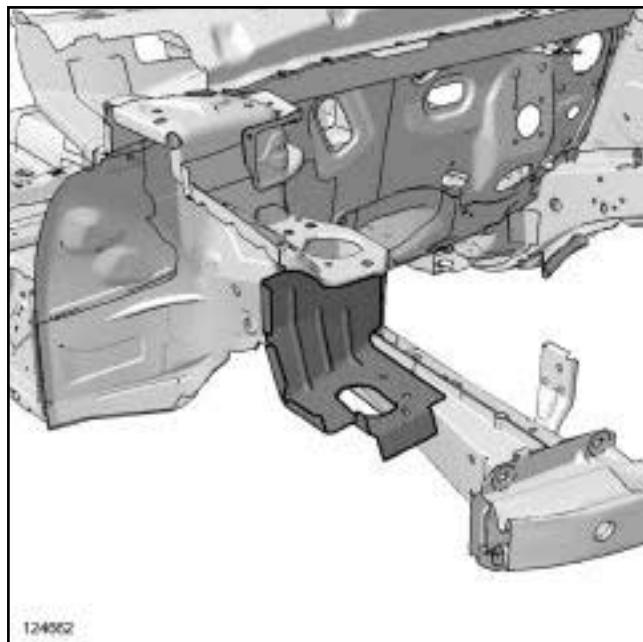
- complete replacement.

I - COMPOSITION OF THE SPARE PART



No.	Description	Type	Thickness (mm)
(1)	Front wheel arch, front section	Mild steel	2

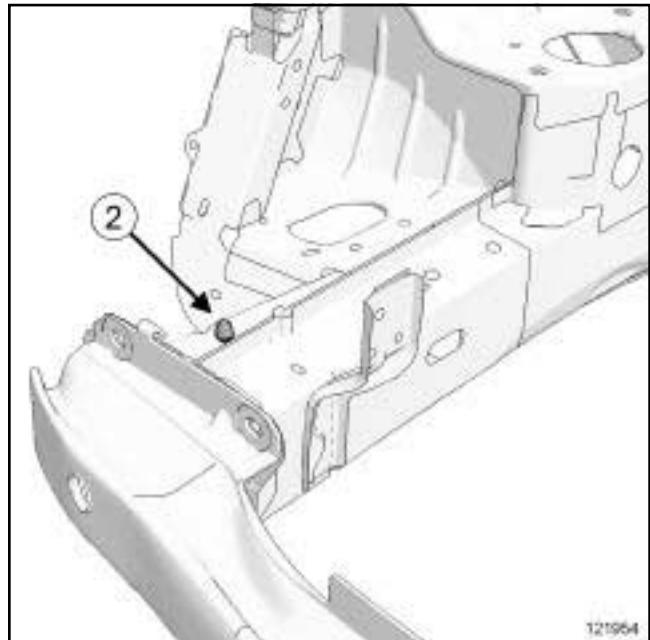
II - PART IN POSITION



Note:

For a detailed description of welded connections, see **MR 400**.

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



WARNING

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**).

Note:

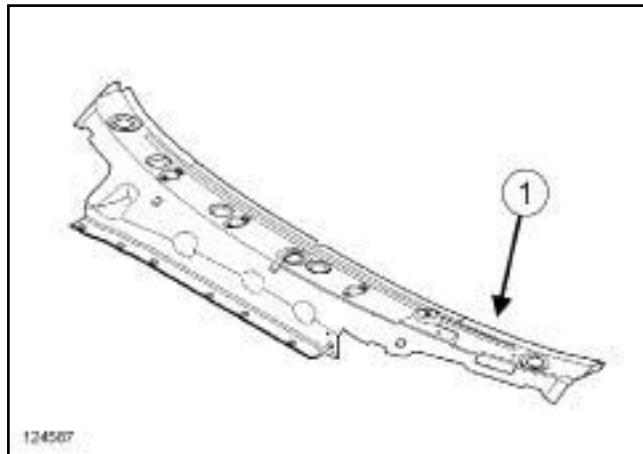
The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400**.

DESIGN OF THE STRUCTURAL COMPONENT



This is a basic part; it serves only as the windscreen aperture lower cross member.

Its replacement allows access to the interior of the aperture cross member for straightening.

It can be replaced partially from the left-hand side (1).

FRONT UPPER STRUCTURE

Windscreen aperture lower cross member: Description

42A



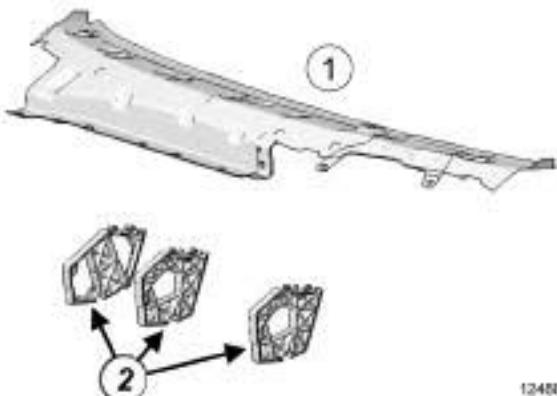
134330

For complete replacement of this part, order an extra 6 studs, part number: **77 03 047 685**.

Note:

This part can be partially replaced in order to avoid repositioning the studs.

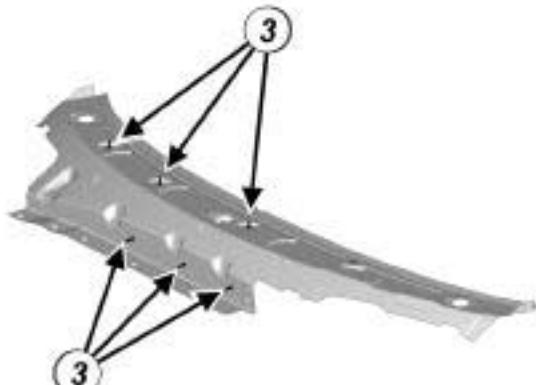
I - COMPOSITION OF THE SPARE PART



124886

No.	Description	Type	Thickness (mm)
(1)	Windscreen aperture lower cross member, upper section	Mild steel	0.8
(2)	Windscreen aperture lower cross member soundproofing reinforcement		

II - PREPARATION OF THE REPLACEMENT PART



134330

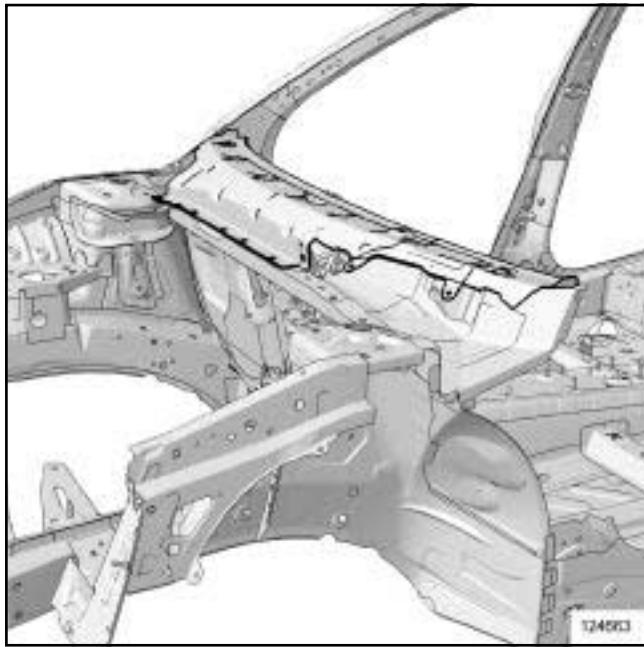
For fitting stud rivets, (see **Riveted connection: Description**)

FRONT UPPER STRUCTURE

Windscreen aperture lower cross member: Description

42A

III - PART IN POSITION



124663

Note:

For a detailed description of welded connections,
see **MR 400**.

Special tooling required

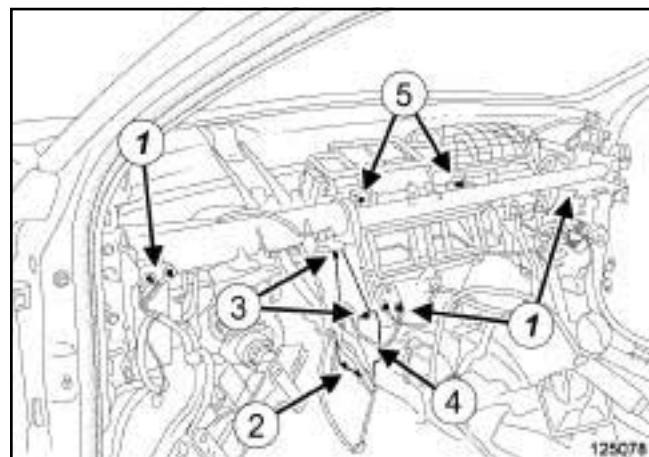
Car. 1765	Bolt for repositioning the play compensation bushes of the dashboard cross member
------------------	---

Tightening torques

dashboard cross member side bolts	21 Nm
dashboard cross member tie rod bolt	21 Nm
dashboard cross member bolts	21 Nm

REMOVAL**I - REMOVAL PREPARATION OPERATION**

- Disconnect the battery (see **Battery: Removal - Refitting**) (MR 415, 80A, Battery).
- Remove:
 - the front side doors (see **47A, Side opening elements, Front side door: Removal - Refitting**, page **47A-1**) ,
 - the dashboard (see **Dashboard: Removal - Refitting**) (MR 416, 57A, Interior equipment),
 - the UCH (see **UCH: Removal - Refitting**) (MR 415, 87B, Connection unit),
 - the steering column (see **Steering column: Removal - Refitting**) (MR 415, 36A, Steering assembly).
- Unclip the passenger compartment fuse box.



125078

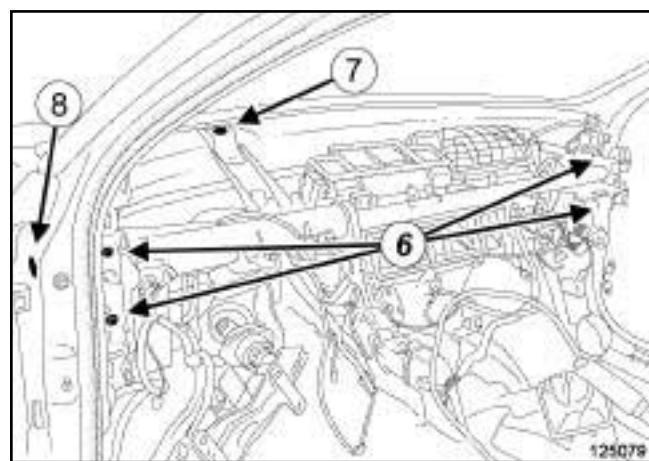
- Disconnect the earths (1) .

 Remove:

- the dashboard cross member flange bolts (2) ,
- the dashboard cross member flange nuts (3) ,
- the dashboard cross member flange (4) ,
- the bolts (5) to the distribution unit,

 Unclip:

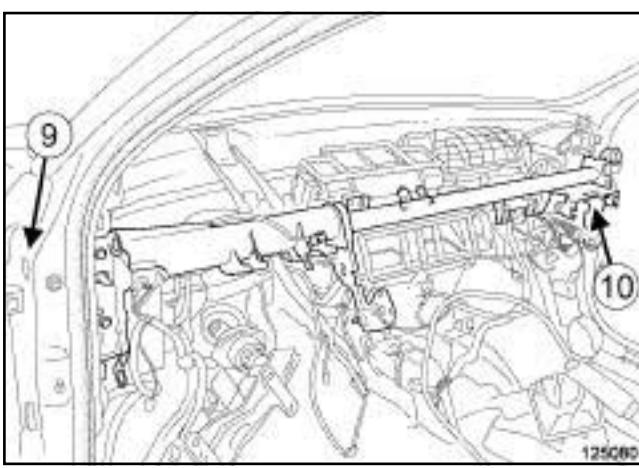
- the various cable harnesses,
- the bonnet opening cable.

II - REMOVAL OPERATION FOR PART CONCERNED

125079

 Remove:

- the dashboard cross member bolts (6) ,
- the dashboard cross member tie rod bolt (7) ,
- the blanking covers (8) .



- Remove the dashboard cross member side bolt (9).
- Undo the dashboard cross member centring nut using the (Car. 1765) (see 40A, General information, Specialised bodywork tools: Use, page 40A-1) (MR 416, 40A, General information).
- Remove:
 - the dashboard cross member side bolt (10),
 - the dashboard cross member.

REFITTING

I - REFITTING OPERATION FOR PART CONCERNED

- Refit:
 - the dashboard cross member,
 - the dashboard cross member side bolt (10).
- Tighten the dashboard cross member centring nut using the (Car. 1765) (see 40A, General information, Specialised bodywork tools: Use, page 40A-1) (MR 416, 40A, General information).
- Refit the dashboard cross member side bolt (9).
- Torque tighten the **dashboard cross member side bolts (21 Nm)**.
- Refit:
 - the blanking covers (8),
 - the dashboard cross member tie rod bolt (7),
 - the dashboard cross member bolts (6).
- Torque tighten:
 - the **dashboard cross member tie rod bolt (21 Nm)**,
 - the **dashboard cross member bolts (21 Nm)**.

II - FINAL OPERATION.

- Clip on the passenger compartment fuse box.
- Refit:
 - the bolts (5) from the distribution unit,
 - the dashboard cross member flange (4),
 - the dashboard cross member flange nuts (3),
 - the dashboard cross member flange bolts (2).
- Clip on:
 - the various cable harnesses,
 - the bonnet opening cable.
- Connect the earths (1).
- Refit:
 - the steering column (see **Steering column: Removal - Refitting**) (MR 415, 36A, Steering assembly),
 - the UCH (see **UCH: Removal - Refitting**) (MR 415, 87B, Connection unit),
 - the dashboard (see **Dashboard: Removal - Refitting**) (MR 416, 57A, Interior equipment),
 - the front side doors (see **47A, Side opening elements, Front side door: Removal - Refitting**, page 47A-1).
- Connect the battery (see **Battery: Removal - Refitting**) (MR 415, 80A, Battery).

Note:

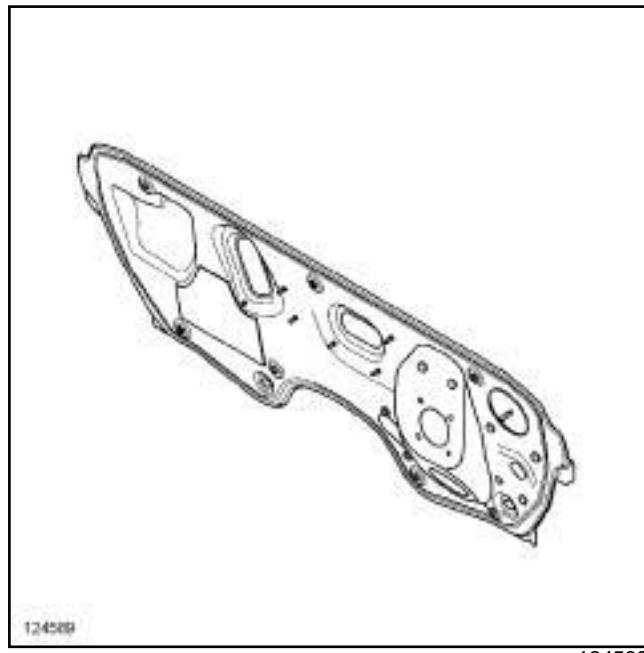
The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading this general information, check that there are no special notes associated with this vehicle. These special notes will be specified if applicable in other parts of this subsection dealing with the part.

Note:

For a detailed description of a particular connection, see **MR 400**.

I - DESIGN OF THE STRUCTURAL COMPONENT



124589

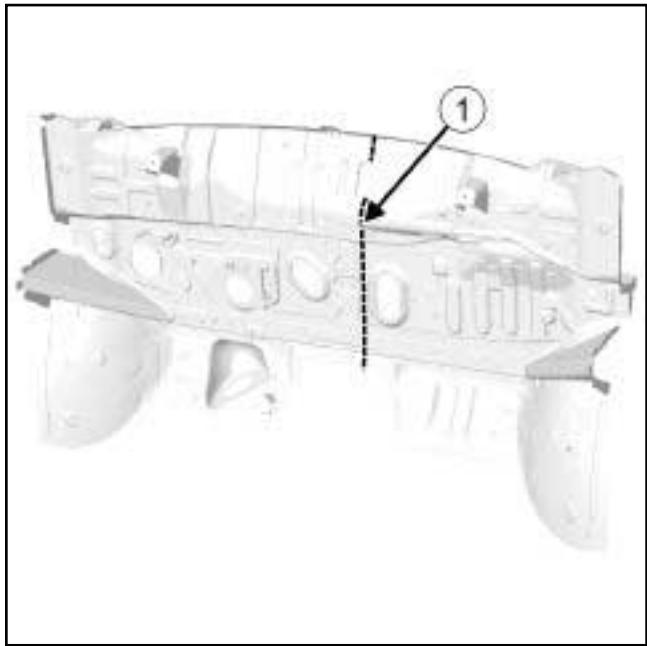
This part contributes to the function of the bulkhead and the pedal mounting plate.

The other parts that make up the bulkhead are:

- The bulkhead lower cross member
- The rear section of the wheel arches.

This is a removable part fixed by nuts and bonded by a "windscreen adhesive" type cement bead. For products and tools required for removal and refitting of this part, (see **Windscreen: Removal - Refitting**)

**II - AREA TO BE CUT FOR PARTIAL
REPLACEMENT**



131064

Cutting line (1) shows the area in which it is possible to carry out a partial replacement.

**III - ASSEMBLY INSTRUCTIONS FOR A PARTIAL
REPLACEMENT**

FRONT UPPER STRUCTURE

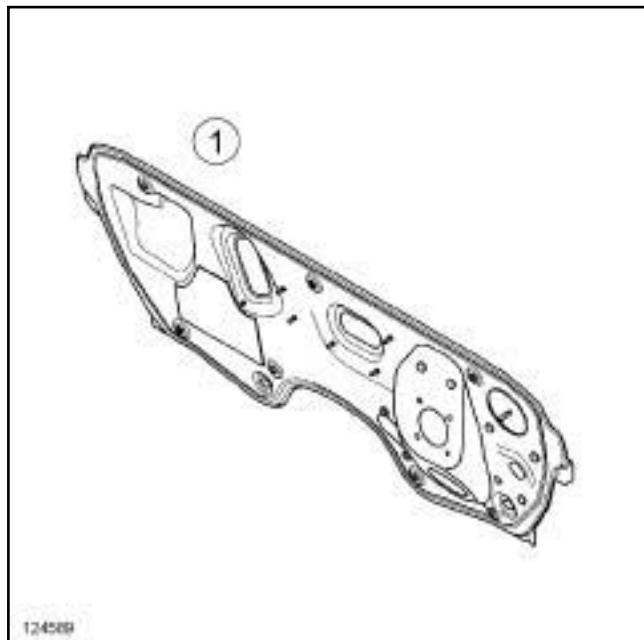
Bulkhead plate: Description

42A

There is only one way of replacing this part:

- complete replacement.

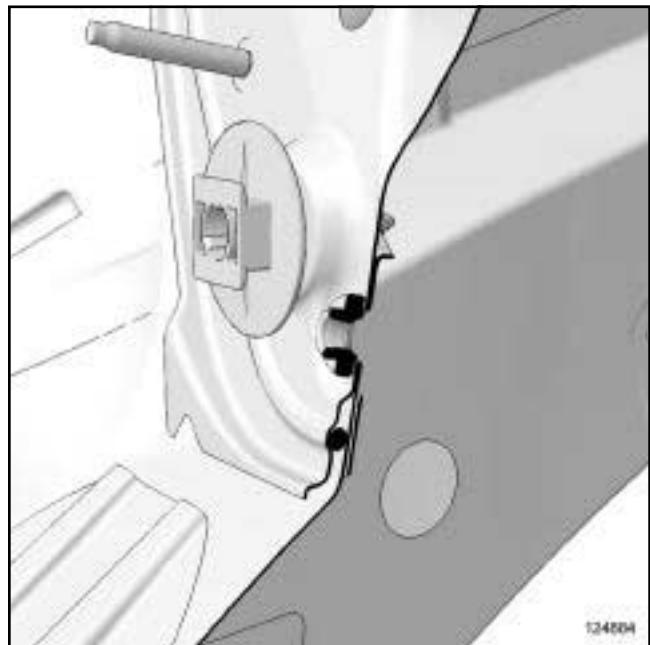
I - COMPOSITION OF THE SPARE PART



Note:

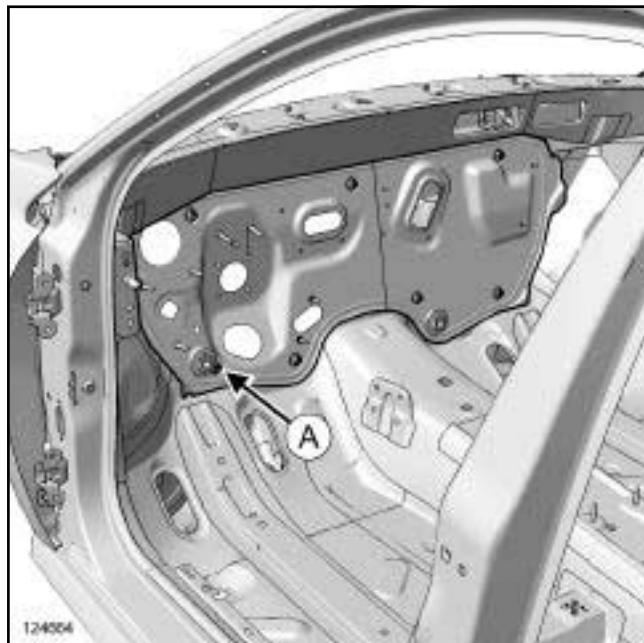
To refit, the bonding procedure is identical to that for replacing a bonded windscreens (see **Technical Note 560 A**).

Section A



No.	Description	Type	Thick-ness (mm)
(1)	Bulkhead plate	HEL	1.5 / 0.8

II - PART IN POSITION



SIDE UPPER STRUCTURE

A-pillar reinforcement: Description

43A



124580

124590

K91

To replace this part, also order the front end insert (see **40A, General information, Hollow section inserts: List and location of components**, page **40A-11**).

I - COMPOSITION OF THE SPARE PART

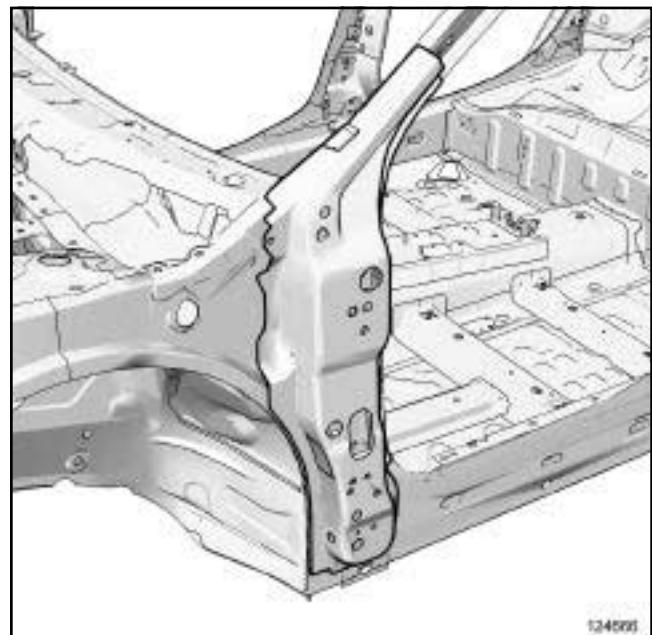


124665

124665

No.	Description	Type	Thickness (mm)
(1)	Door hinge mounting retainer	Mild steel	0.8
(2)	Upper hinge mounting plate	HEL	8
(3)	Upper hinge reinforcement	HEL	2
(4)	Door check strap stiffener	Mild steel	1.97
(5)	Lower hinge reinforcement	HEL	1.5
(6)	Pillar reinforcement	HEL	1

II - PART IN POSITION



124666

Note:

For a detailed description of welded connections, see **MR 400**.

Note:

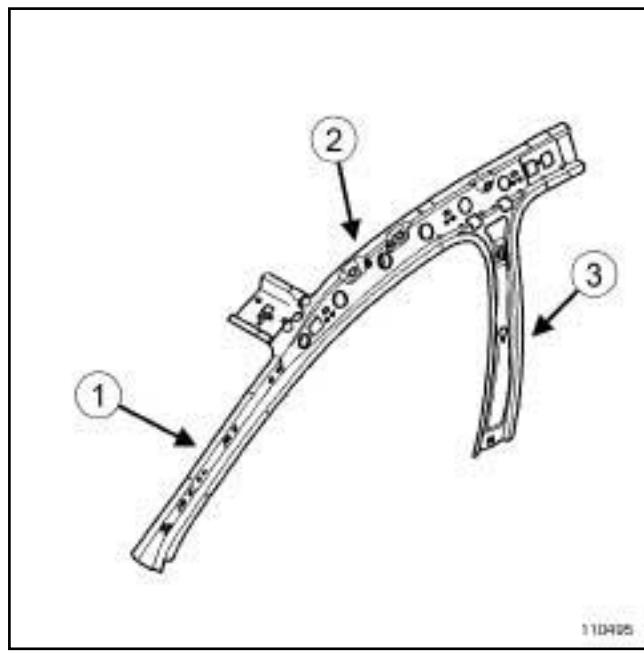
The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400**.

DESIGN OF THE STRUCTURAL COMPONENT



The distinctive feature of this part is that it combines three functions:

- windscreen A-pillar lining (1) ,
- front roof drip moulding lining (2) ,
- B-pillar upper lining (3) .

If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400**).

B91 or K91



124620

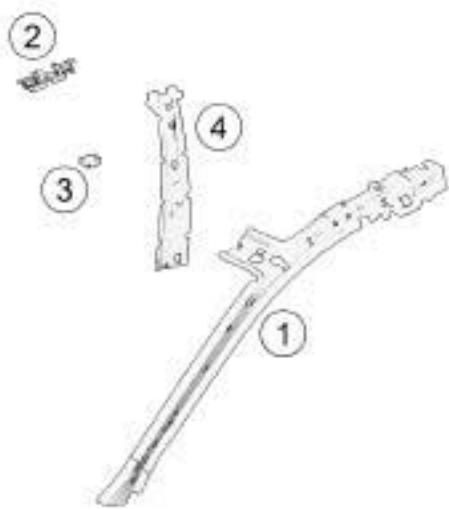
124620

To replace this part, also order the A-pillar insert (see **40A, General information, Hollow section inserts: List and location of components**, page 40A-11).

The options for replacing this part are as follows:

- front partial replacement,
- Rear partial replacement
- complete replacement.

I - COMPOSITION OF THE SPARE PART



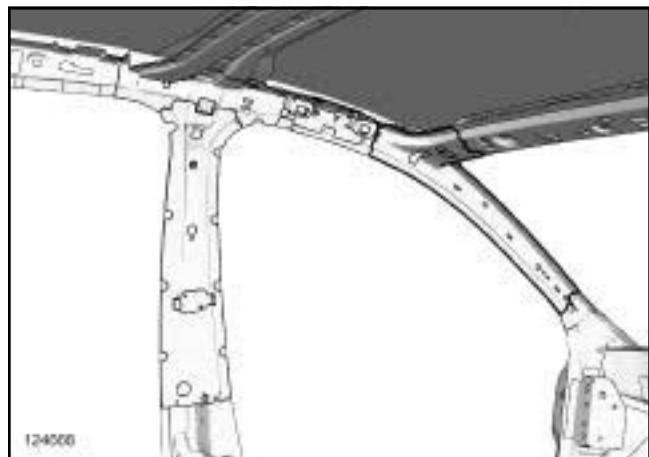
124678

124878

No.	Description	Type	Thickness (mm)
(1)	A-pillar lining	HEL	1.5
(2)	Grab handle mounting	HEL	1.3
(3)	Seat belt web linkage mounting bridge piece	HEL	1.5
(4)	B-pillar lining	HEL	1.5

II - PART IN POSITION

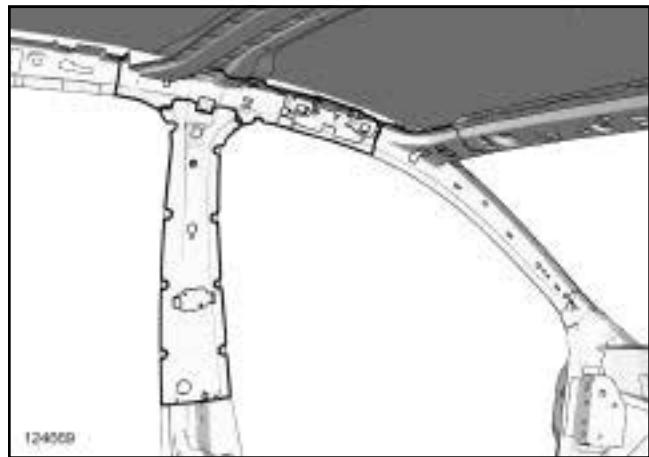
1 - Partial front replacement



124668

124668

2 - Partial rear replacement



124669

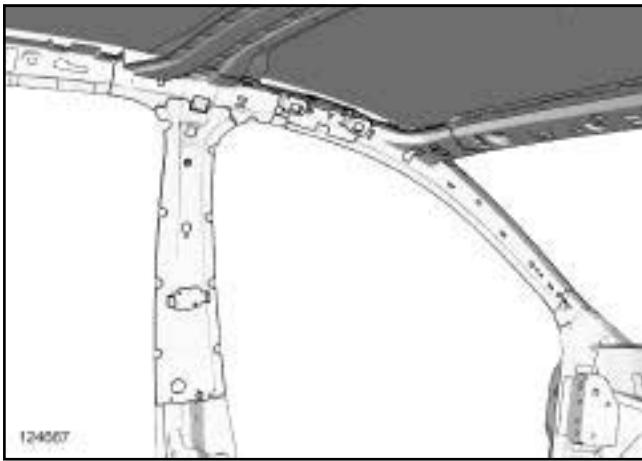
124669

SIDE UPPER STRUCTURE
Windscreen pillar lining: Description

43A

B91 or K91

3 - Complete replacement



Note:

For a detailed description of welded connections,
see **MR 400**.

D91



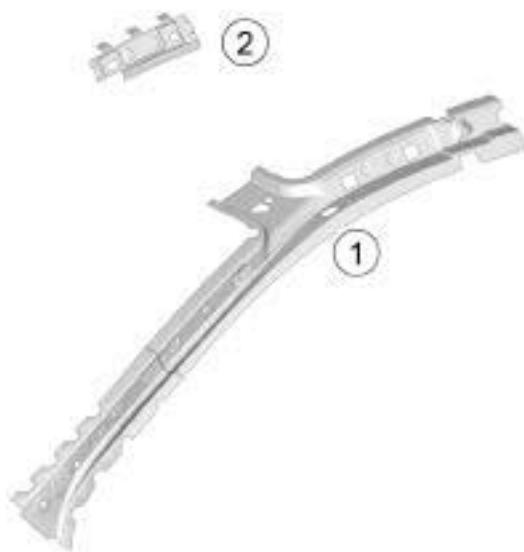
134746

To replace this part, also order the windscreen pillar insert (see 40A, General information, Hollow section inserts: List and location of components, page 40A-11)

the options for replacing this part are as follows:

- partial front replacement, without removal of the roof,
- complete replacement, with removal of the roof.

I - COMPOSITION OF THE SPARE PART

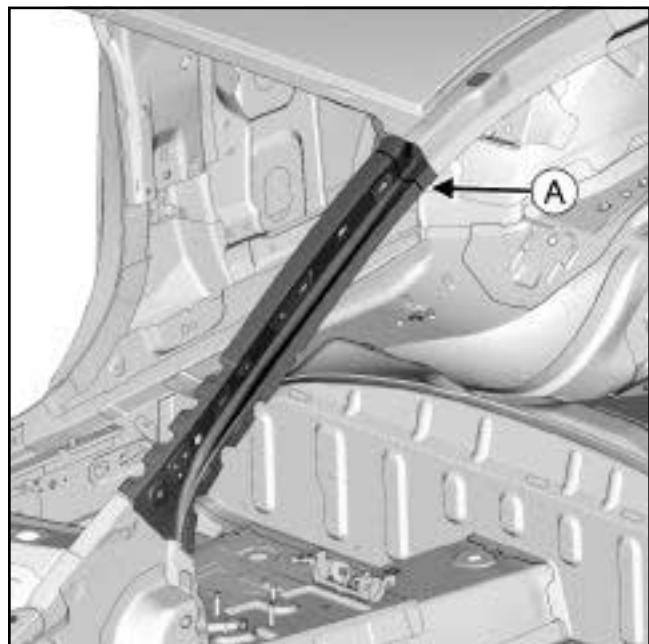


134747

No.	Description	Type	Thickness (mm)
(1)	Windscreen pillar lining	HLE	1.5
(2)	Front grab handle fixed bridge piece	HLE	1.3

II - PART FITTED

1 - Partial front replacement



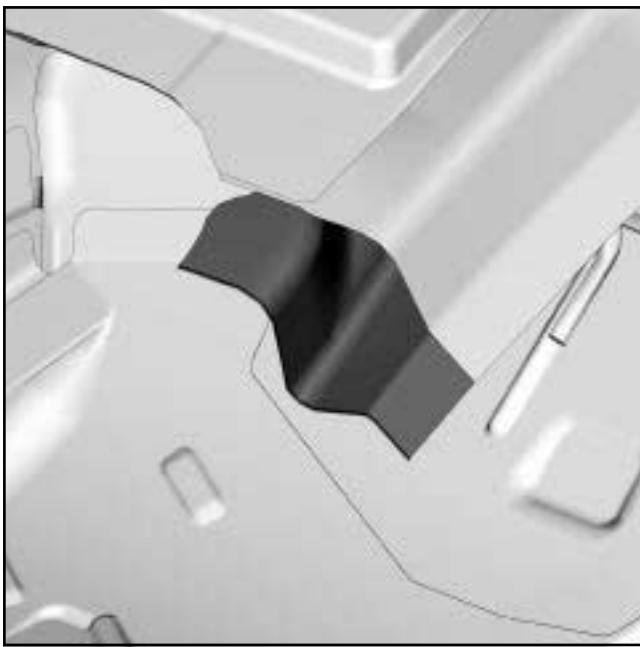
134792

SIDE UPPER STRUCTURE
Windscreen pillar lining: Description

43A

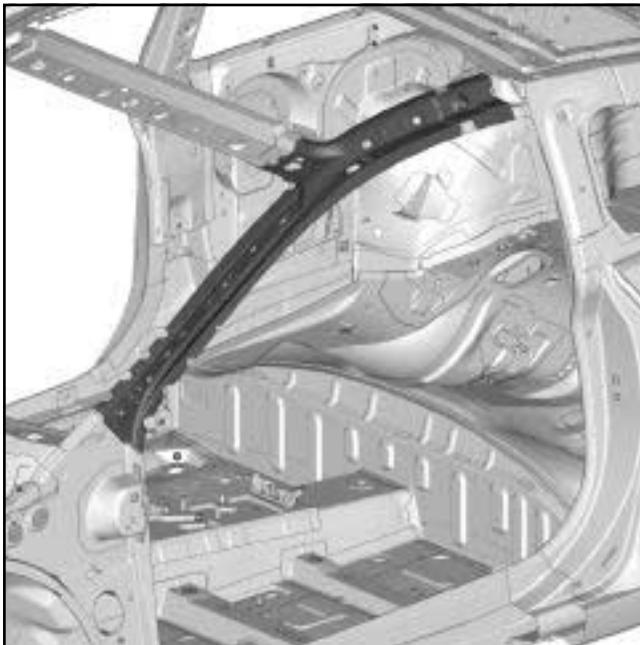
D91

Section A



134793

2 - Complete replacement



134748

WARNING

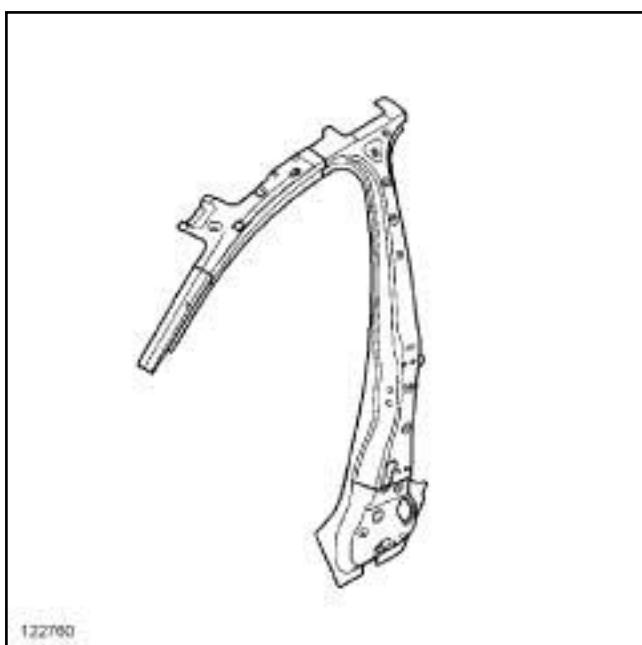
To preserve the mechanical specifications when partially replacing parts with a single structural component, alter the weld lines for each of these components.

SIDE UPPER STRUCTURE

B-pillar reinforcement: Description

43A

B91 or K91



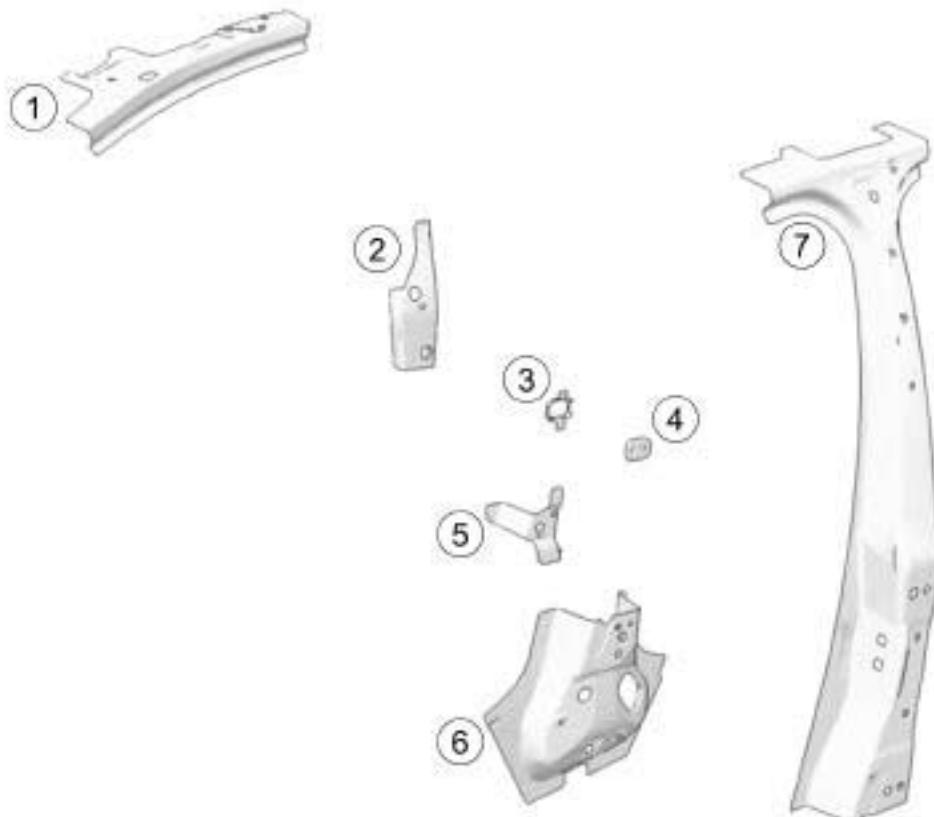
122760

122760

The options for replacing this part are as follows:

- Complete replacement
- lower section replacement.

I - COMPOSITION OF THE SPARE PART



122012

122012

SIDE UPPER STRUCTURE

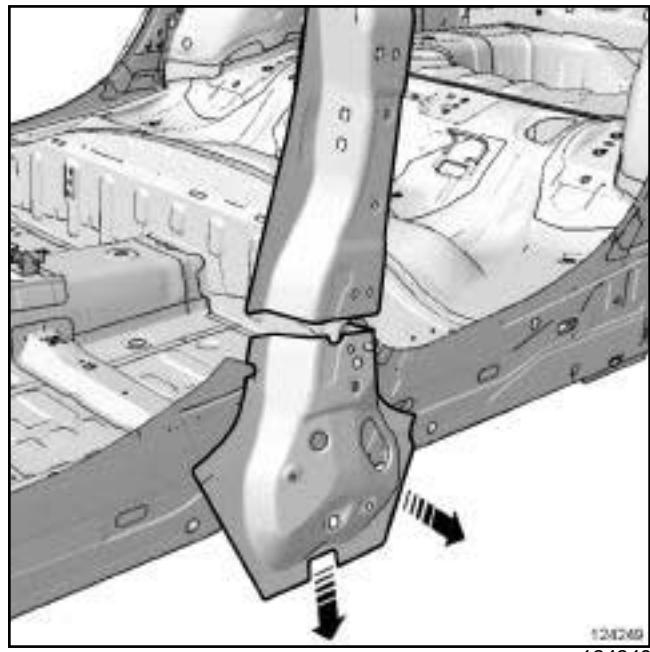
B-pillar reinforcement: Description

43A

B91 or K91

No.	Description	Type	Thick-ness (mm)
(1)	Roof drip moulding reinforcement	HLE	1
(2)	B-pillar impact reinforcement	UHLE	1.8
(3)	Door upper hinge mounting retainer	Mild steel	0.8
(4)	Door upper hinge mounting plate	HLE	8
(5)	Airbag sensor mounting bridge piece	Mild steel	2
(6)	B-pillar reinforcement lower section	HLE	1.8
(7)	B-pillar reinforcement	UHLE	1.5

2 - Replacement of the lower section

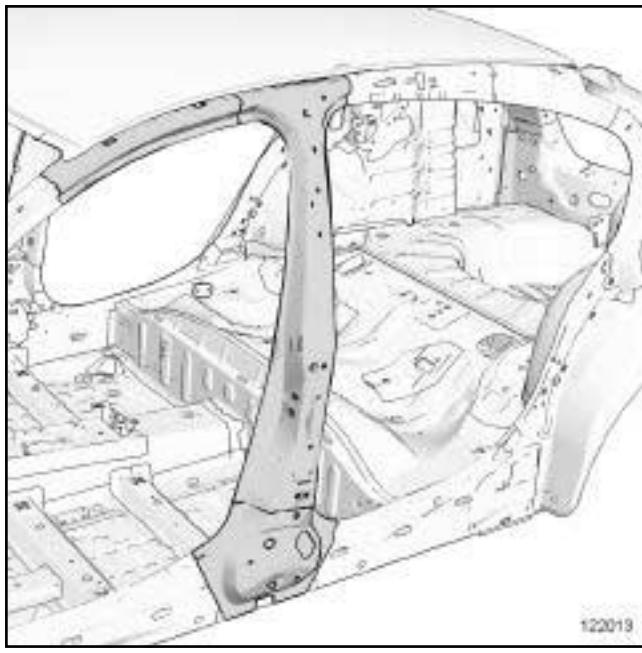


WARNING

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**).

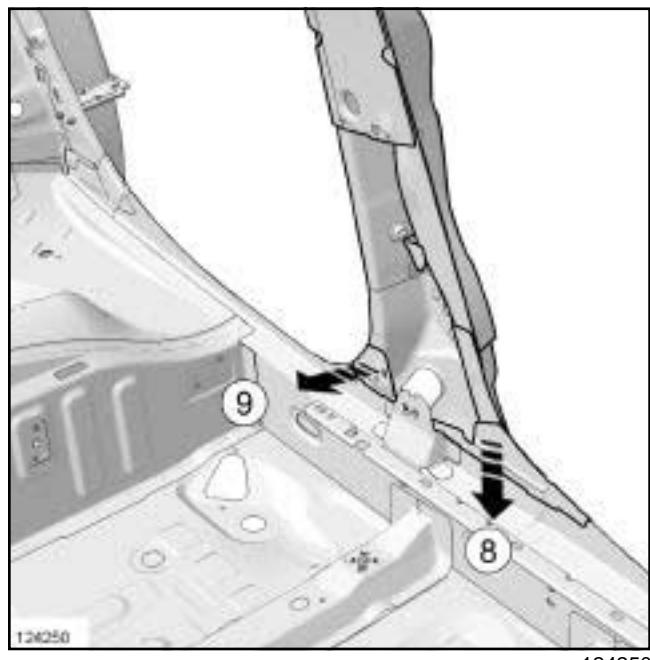
II - PART IN POSITION

1 - Complete replacement



Note:

For a detailed description of welded connections in three thicknesses, see **MR 400**.



SIDE UPPER STRUCTURE

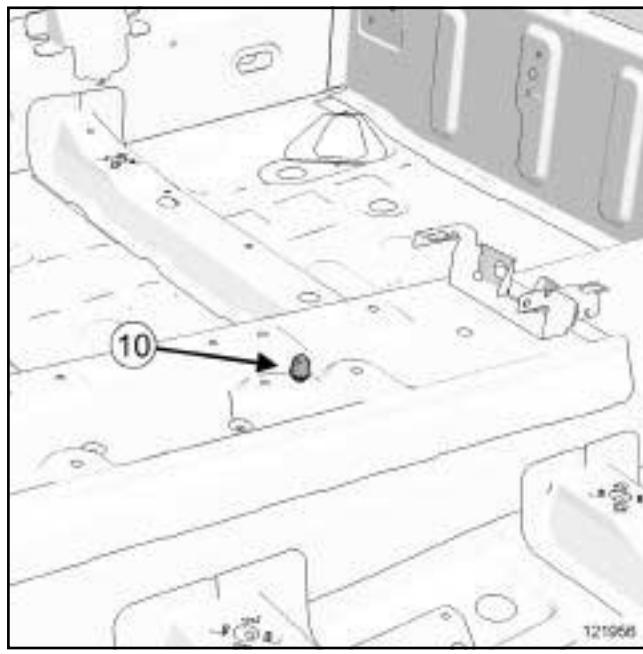
B-pillar reinforcement: Description

43A

B91 or K91

Replacement of the B-pillar reinforcement can be carried out without replacing the B-pillar upper reinforcement as long as tabs (8) and (9) are folded in order to remove the lower part more quickly.

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



IMPORTANT

To avoid damaging the vehicle's electric and electronic components, the battery and the earths of any wiring harness near the weld area must be disconnected.

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

SIDE UPPER STRUCTURE

B-pillar reinforcement: Description

43A

D91



134750

No.	Description	Type	Thickness (mm)
(1)	B-pillar reinforcement	UHLE	1.8
(2)	Impact reinforcement	UHLE	2
(3)	B-pillar reinforcement lower section	HLE	1.5
(4)	Pad	HLE	2.5
(5)	Bridge piece	Mild steel	2

To replace this part, also order the B-pillar insert (see **40A, General information, Hollow section inserts: List and location of components**, page **40A-11**).

The options for replacing this part are as follows:

- Complete replacement
- lower section replacement.

COMPOSITION OF THE SPARE PART



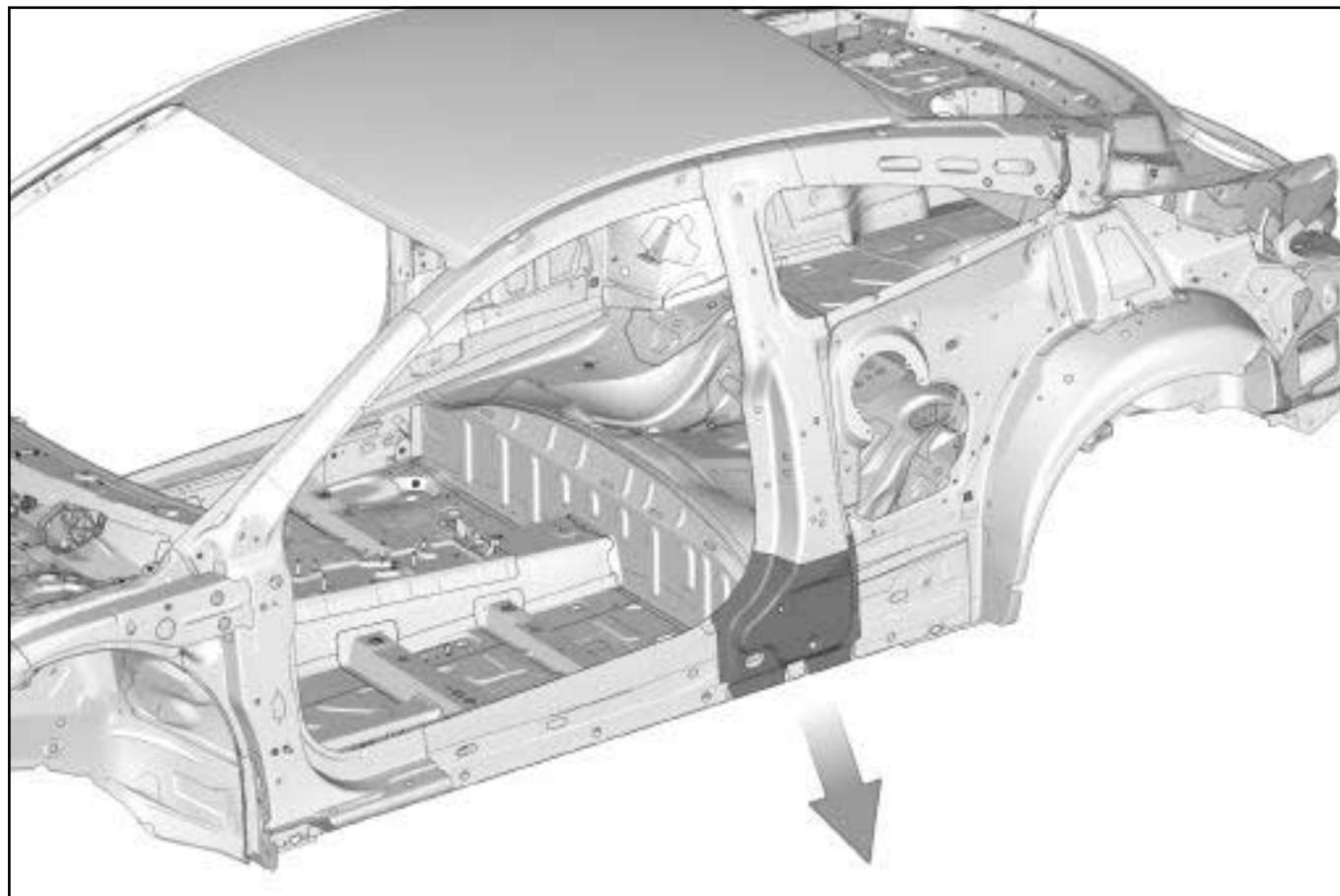
134751

SIDE UPPER STRUCTURE
B-pillar reinforcement: Description

43A

D91

1 - Lower section replacement



134795

WARNING

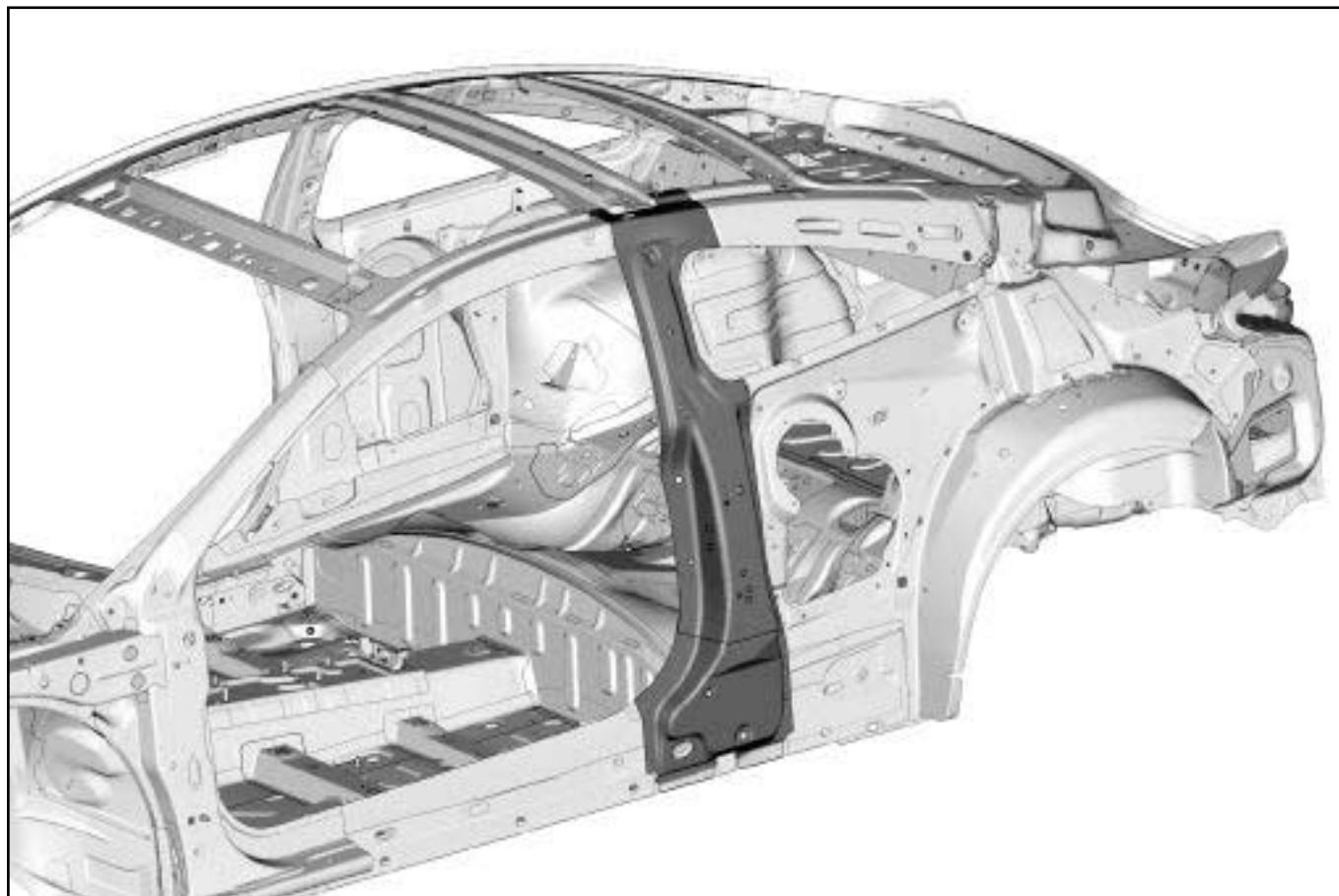
If the mating faces of the parts to be welded are not accessible, perform GMAW plug welds instead of the original resistance welding **see MR 400**.

SIDE UPPER STRUCTURE
B-pillar reinforcement: Description

43A

D91

2 - Complete replacement |



134794

WARNING

If the mating faces of the parts to be welded are not accessible, perform GMAW plug welds instead of the original resistance welding **see MR 400**.

Note:

For detailed descriptions of a welded connection in three thicknesses, see **MR 400**.

B91 or K91

Note:

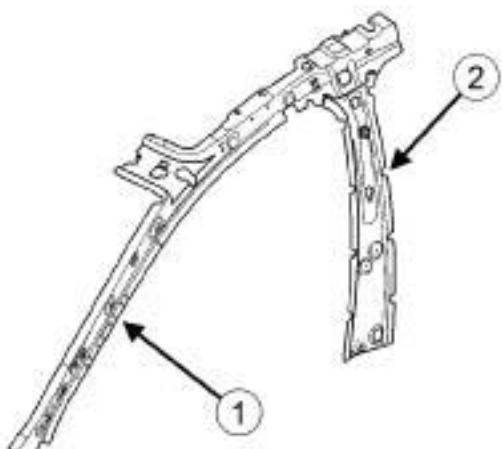
The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400**.

DESIGN OF THE STRUCTURAL COMPONENT



122761

122761

The special feature of this part is that it concurrently serves two functions:

- A-pillar lining (1) .
- B-pillar upper lining (2) ,

These two components can be partially replaced.

WARNING

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**).

SIDE UPPER STRUCTURE

Body side: General description

43A

B91 or K91 – D91

Note:

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

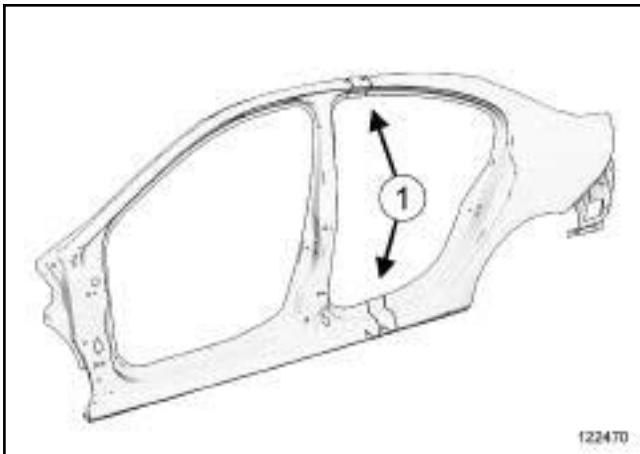
The body side is achieved by welding the rear wing and the body side front section.

Note:

For a detailed description of a particular connection (see **MR 400**).

DESIGN OF THE STRUCTURAL COMPONENT

B91 or K91



The two parts must be welded at the joint (1) and butt welded by continuous EGW welding.

If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400**).

WARNING

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**).

SIDE UPPER STRUCTURE
Body side: General description

43A

B91 or K91 – D91

D91



135011

The special feature of the body side is that it is comprised of three distinct parts assembled by electric resistance welding:

- sill panel (1) ,
- rear wing panel (2) ,
- body side, front section (3) .

B91 or D91 or K91

Note:

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

(1) , (2) , (3) , (4) , (5) and (6) show the areas in which it is possible to carry out a partial replacement.

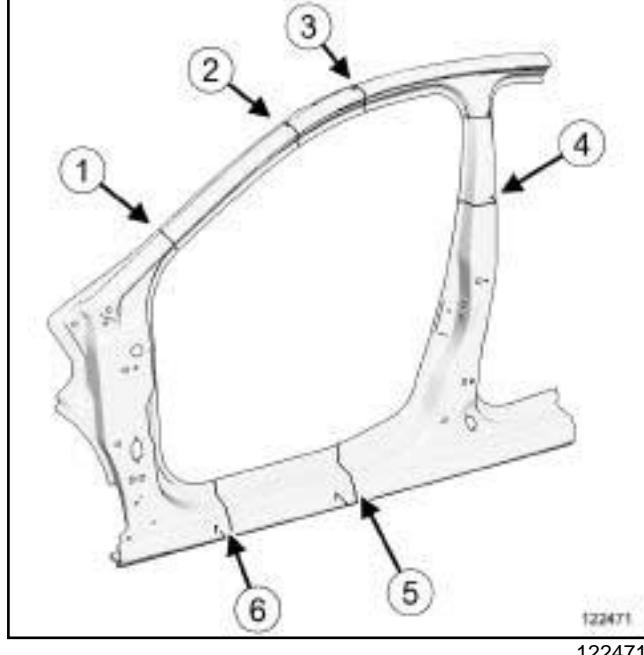
D91



134337

DESIGN OF THE STRUCTURAL COMPONENT

B91 or K91



122471

This part has the special feature of being welded under the roof.

This part combines the functions of A-pillar and B-pillar. It can be replaced in several ways following an impact. For detailed information about the body side front section (see **43A, Side upper structure, Body side, front section: Description**, page 43A-17).

WARNING

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**).

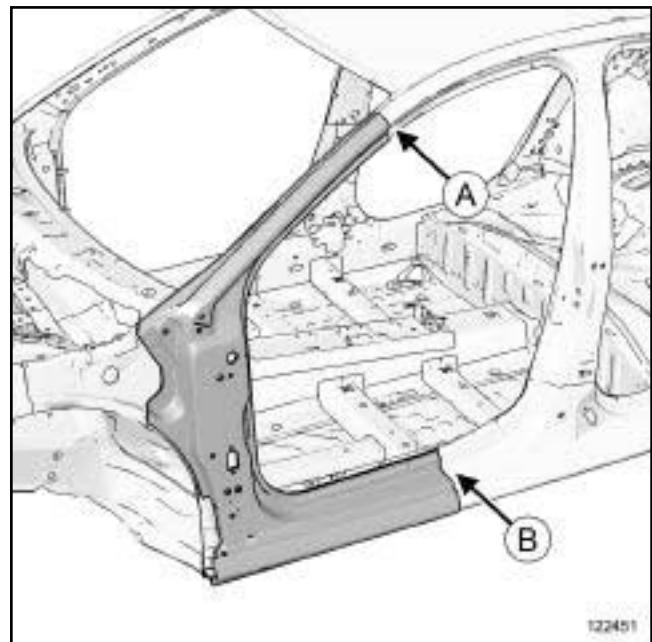
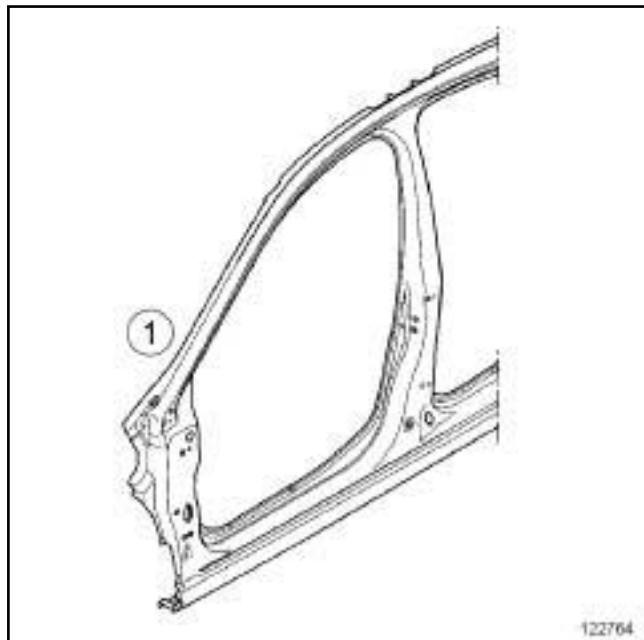
B91 or K91

To replace this part, also order the A-pillar insert, A-pillar insert, and B-pillar insert (see **40A, General information, Hollow section inserts: List and location of components**, page **40A-11**).

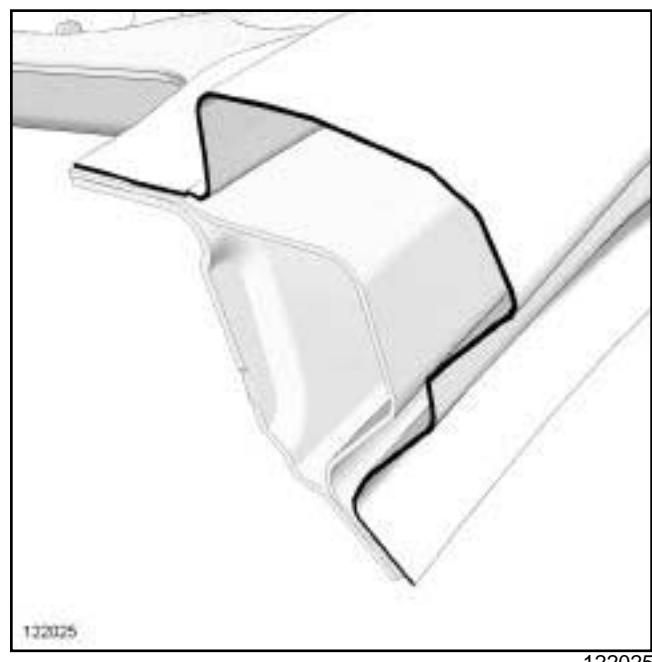
The options for replacing this part are as follows:

- front section replacement,
- rear section replacement,
- lower section replacement,
- upper section replacement,
- complete replacement.

I - COMPOSITION OF THE SPARE PART



Section A



No.	Description	Type	Thickness (mm)
(1)	Body side front section	Mild steel	0.75

II - PART IN POSITION

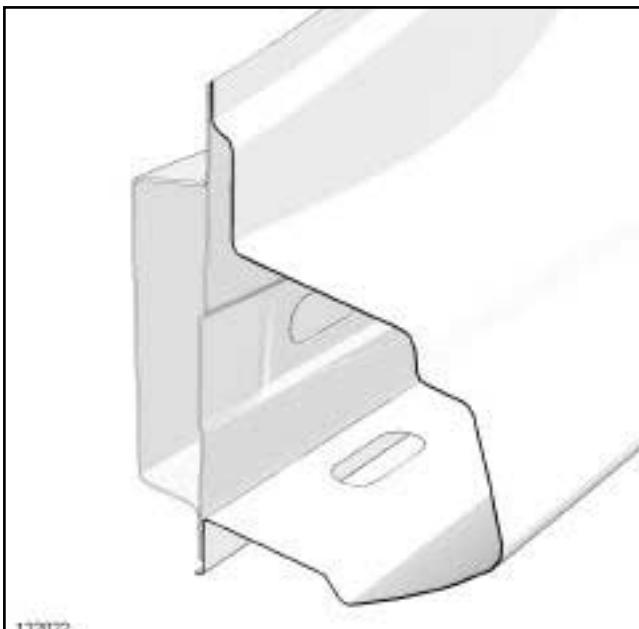
1 - Front section replacement

WARNING

Respect the position of this cut which has been determined in accordance with the position of the inner stiffeners or acoustic inserts, in order to prevent damaging the parts (inner stiffener and/or acoustic insert).

B91 or K91

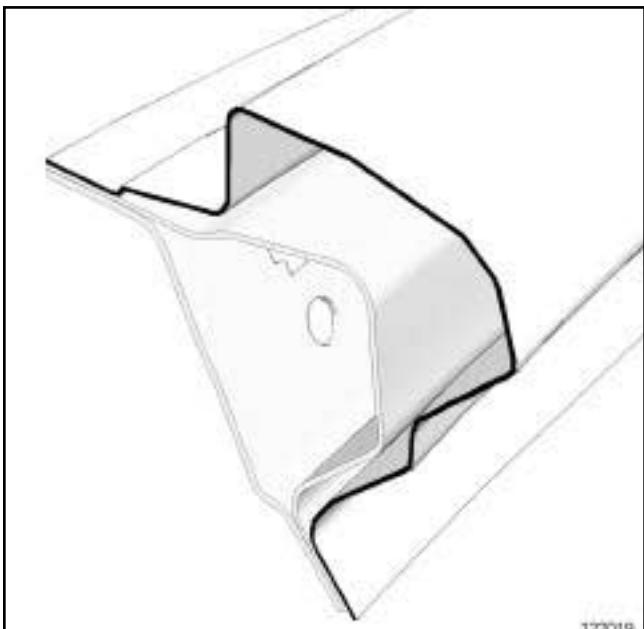
Section B



122022

122022

Section C



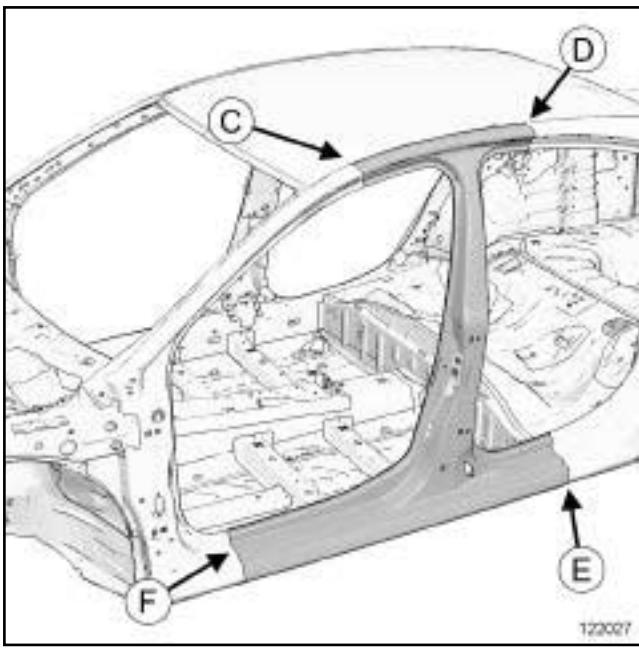
122018

122019

2 - Rear section replacement

WARNING

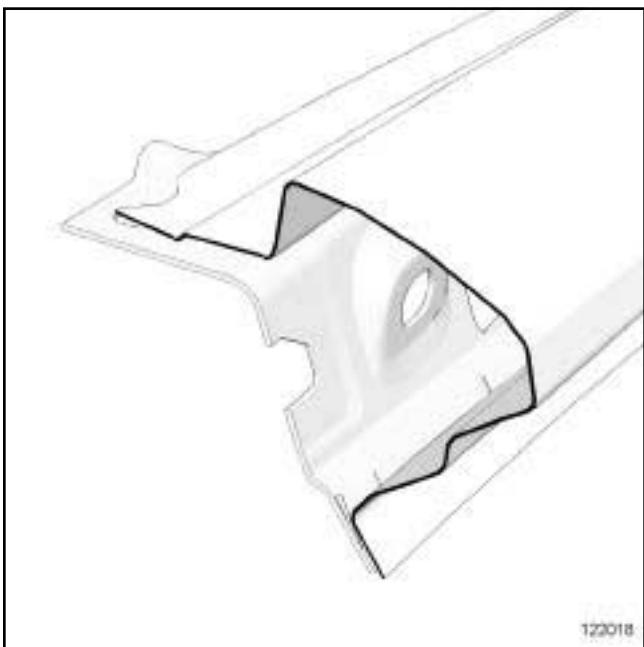
Respect the position of this cut which has been determined in accordance with the position of the inner stiffeners or acoustic inserts, in order to prevent damaging the parts (inner stiffener and/or acoustic insert).



122027

122027

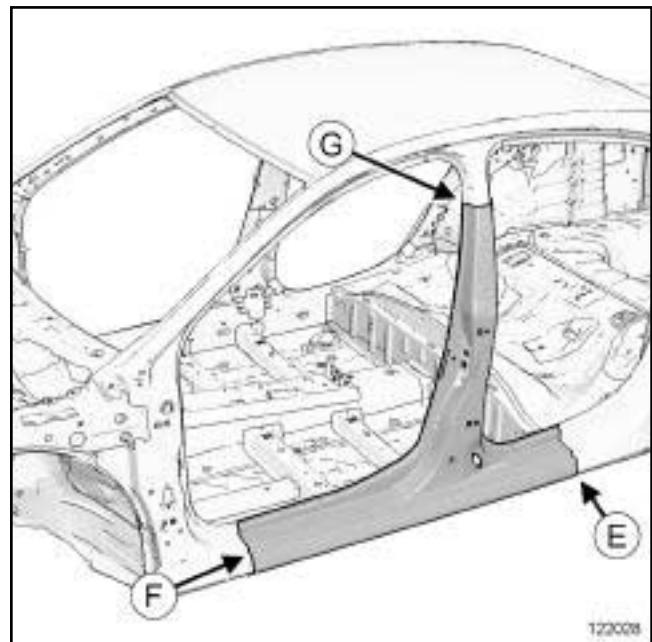
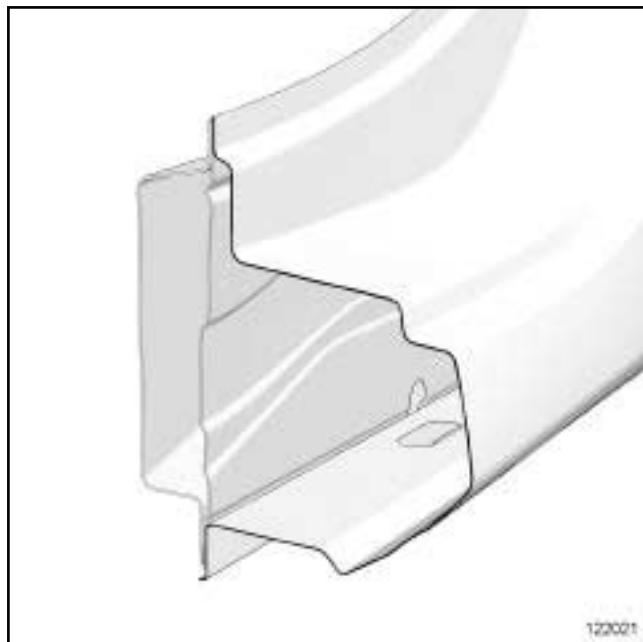
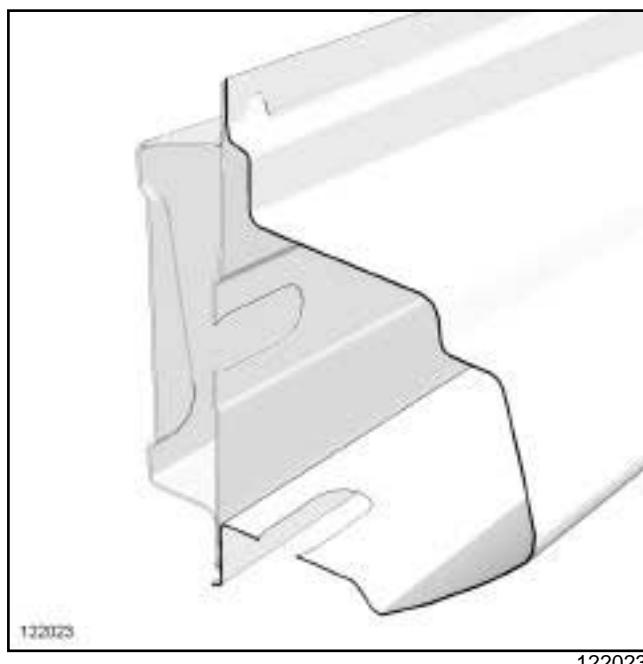
Section D



122018

122018

B91 or K91

Section E**Section F**

122023

Section G

122020

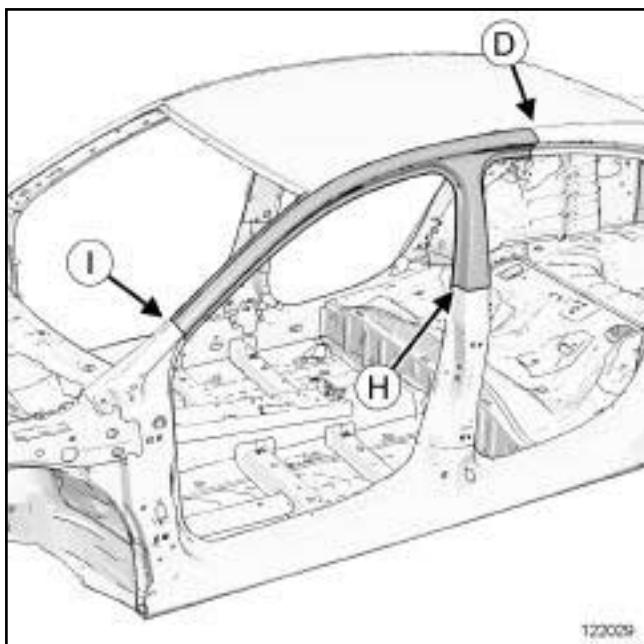
3 - Replacement of the lower section**WARNING**

Respect the position of this cut which has been determined in accordance with the position of the inner stiffeners or acoustic inserts, in order to prevent damaging the parts (inner stiffener and/or acoustic insert).

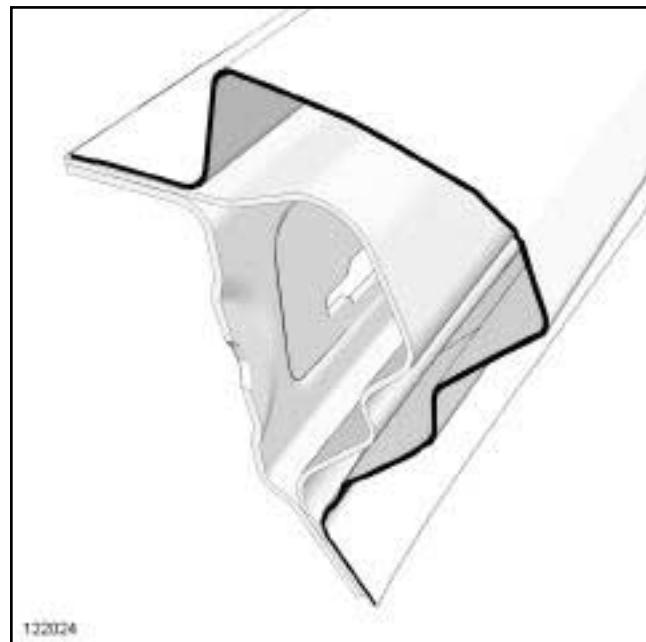
4 - Replacement of the upper section**WARNING**

Respect the position of this cut which has been determined in accordance with the position of the inner stiffeners or acoustic inserts, in order to prevent damaging the parts (inner stiffener and/or acoustic insert).

B91 or K91



122029

Section I

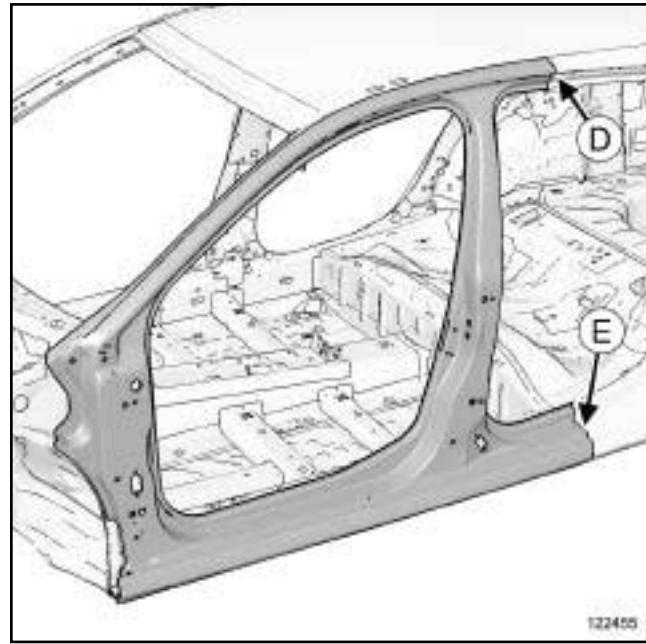
122024

Section H

122017

5 - Complete replacement**WARNING**

Respect the position of this cut which has been determined in accordance with the position of the inner stiffeners or acoustic inserts, in order to prevent damaging the parts (inner stiffener and/or acoustic insert).



122455

122255

B91 or K91

WARNING

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**).

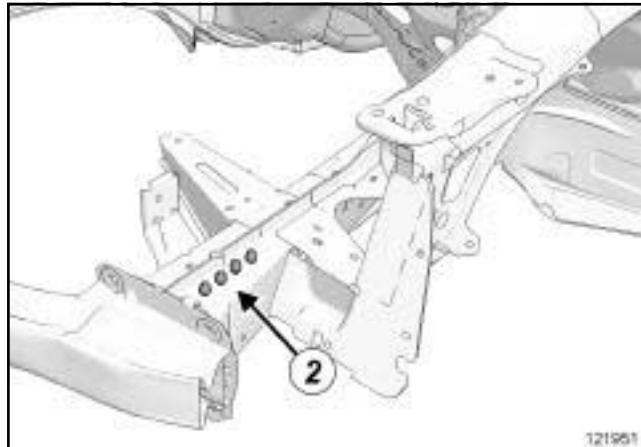
Note:

For more detailed information on welded connections with three thicknesses, see **MR 400**.

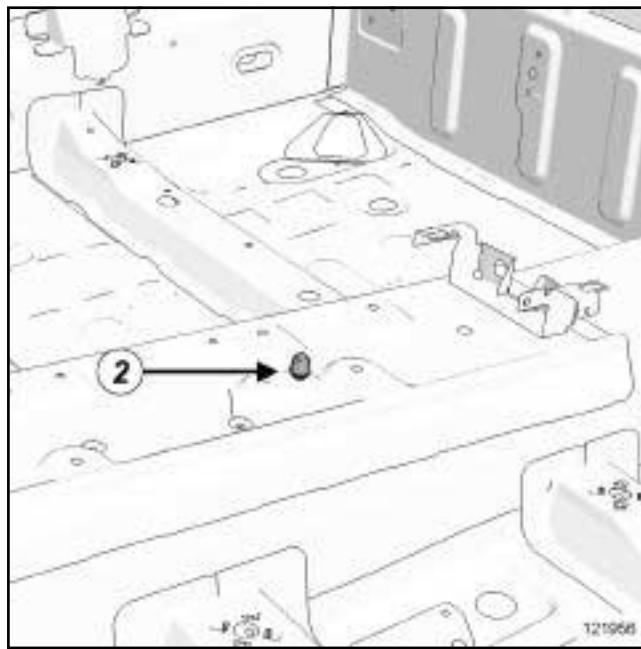
IMPORTANT

To avoid damaging the vehicle's electric and electronic components, the battery and the earths of any wiring harness near the weld area must be disconnected.

The earth of the welding machine must be placed as close as possible to the weld area.

III - POSITIONING OF LOCAL ELECTRICAL EARTHS

121951



121956

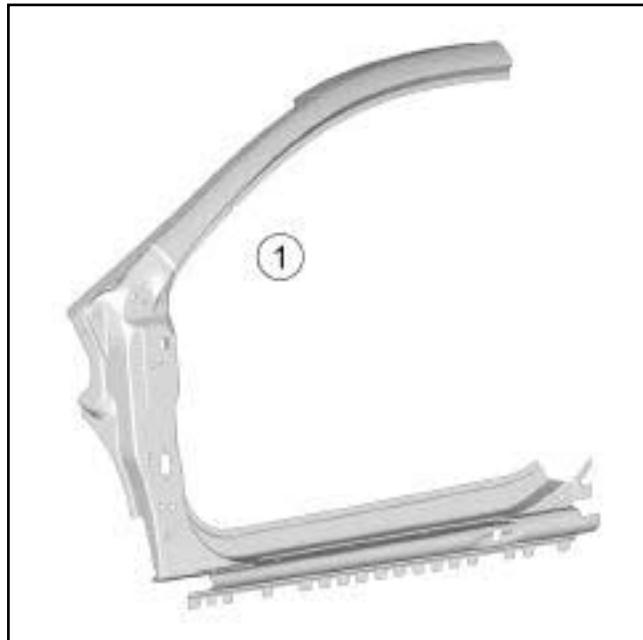
D91

When replacing this part, order the windscreen pillar lining insert and the windscreen pillar upper section insert in addition (see **40A, General information, Hollow section inserts: List and location of components**, page **40A-11**)

The options for replacing this part are as follows:

- A-pillar lower section replacement with the scuttle side panel reinforcement,
- sill lining replacement,
- A-pillar replacement,
- A-pillar lower section replacement without the scuttle side panel reinforcement,

I - COMPOSITION OF THE SPARE PART



134337

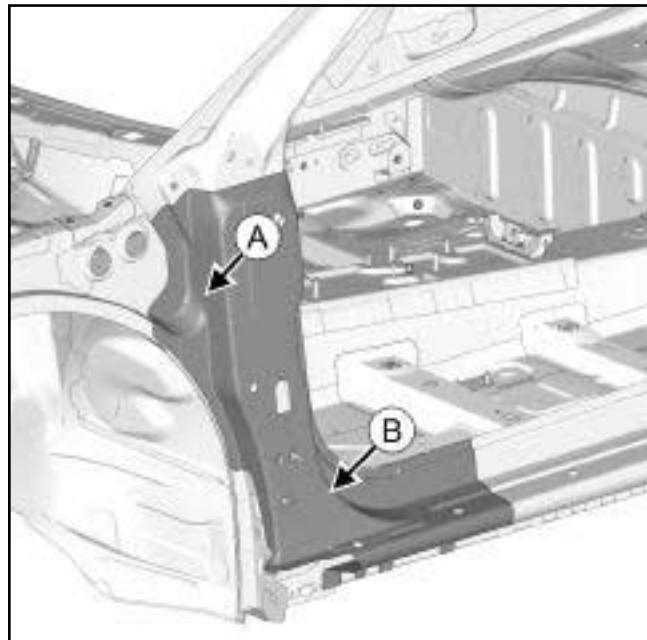
No.	Description	Type	Thickness (mm)
(1)	Body side front section	Mild steel	0.75

II - PART FITTED

1 - A-pillar lower section replacement with the scuttle side panel reinforcement

WARNING

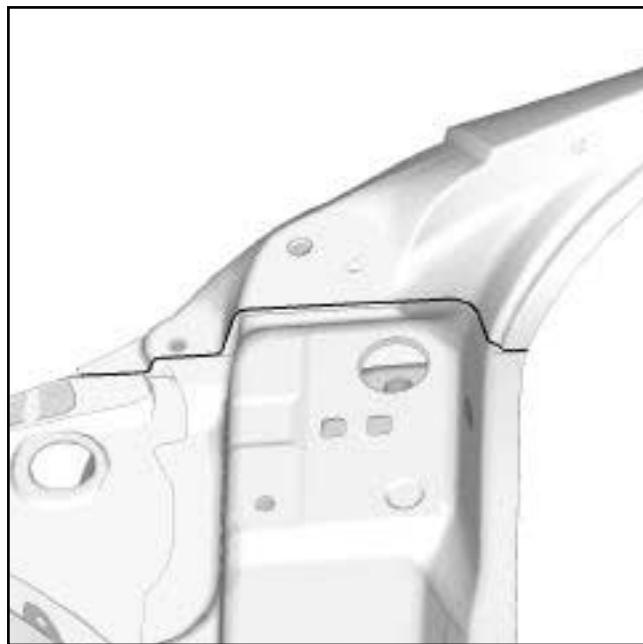
Respect the position of this cut which has been determined in accordance with the position of the inner stiffeners or acoustic inserts, in order to prevent damaging the parts (inner stiffener and/or acoustic insert).



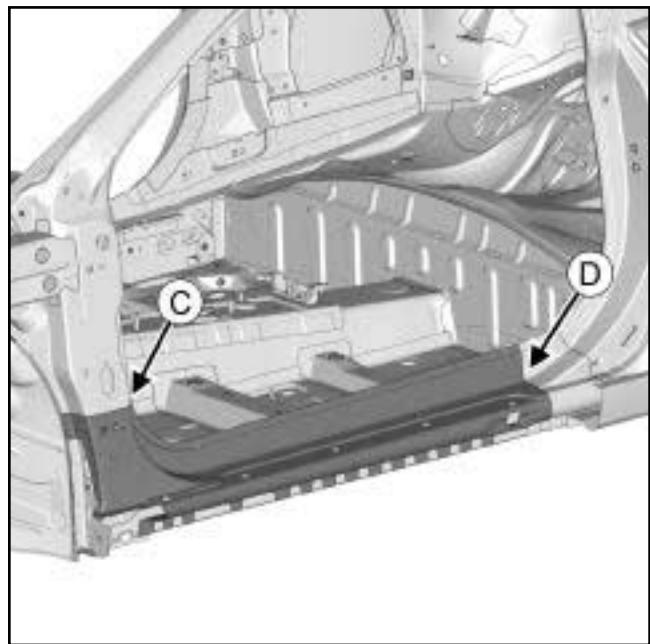
134339

D91

Section A

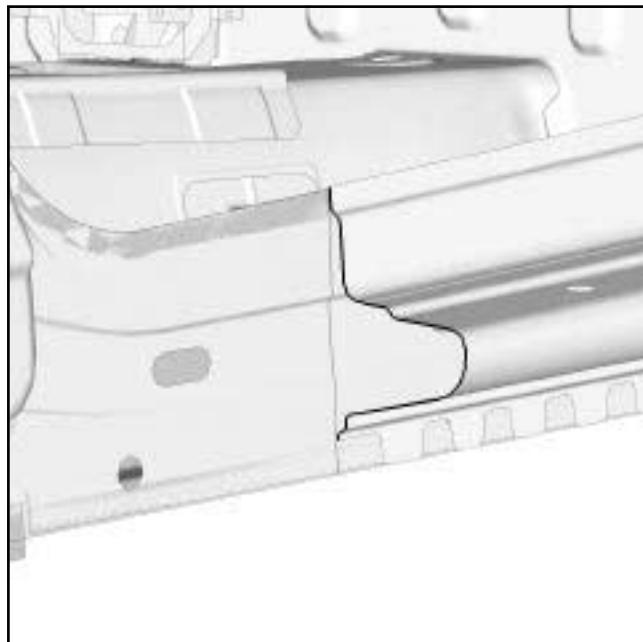


134764



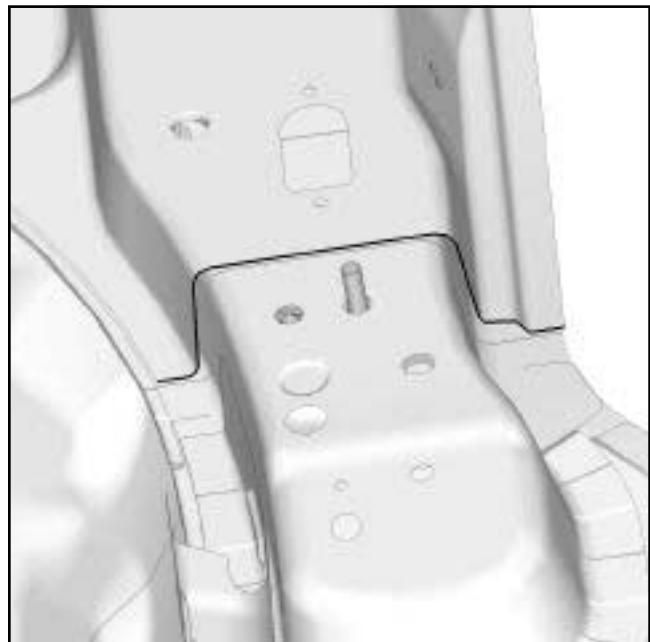
134338

Section B



134765

Section C



134762

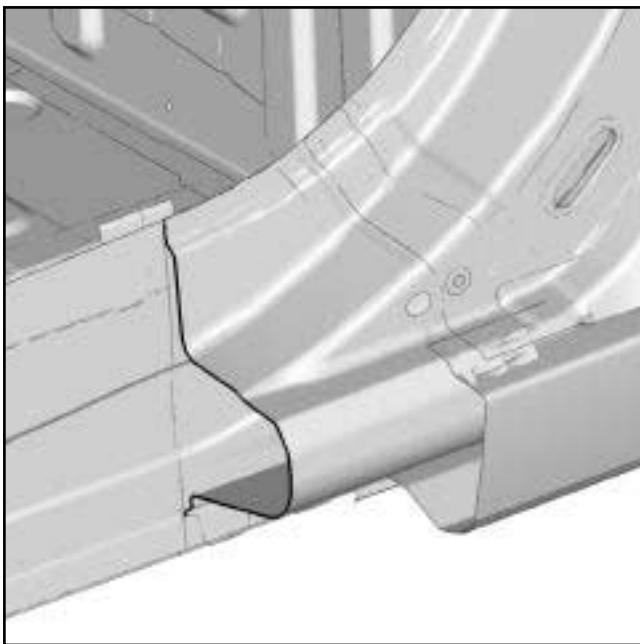
2 - Sill lining replacement

WARNING

Respect the position of this cut which has been determined in accordance with the position of the inner stiffeners or acoustic inserts, in order to prevent damaging the parts (inner stiffener and/or acoustic insert).

D91

Section D



134763

Section E

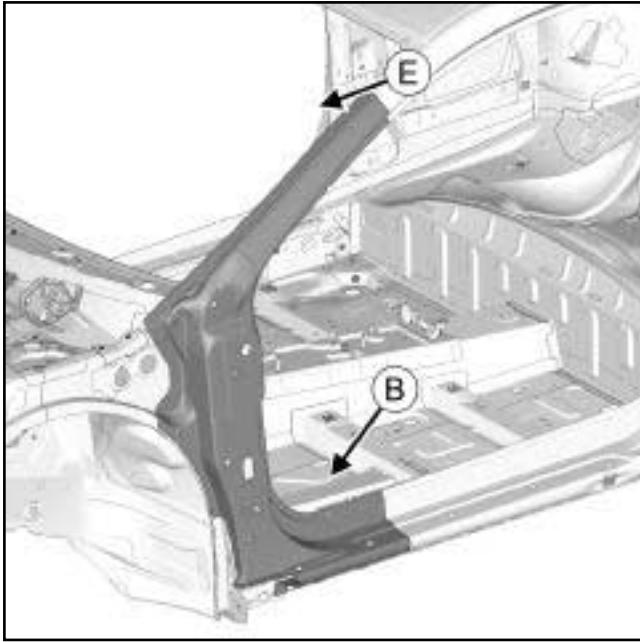


134761

3 - A-pillar replacement

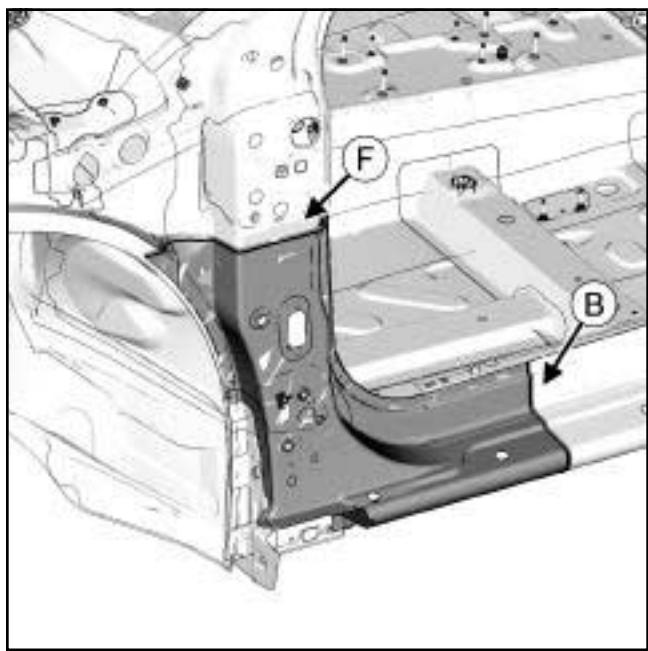
WARNING

Respect the position of this cut which has been determined in accordance with the position of the inner stiffeners or acoustic inserts, in order to prevent damaging the parts (inner stiffener and/or acoustic insert).



134340

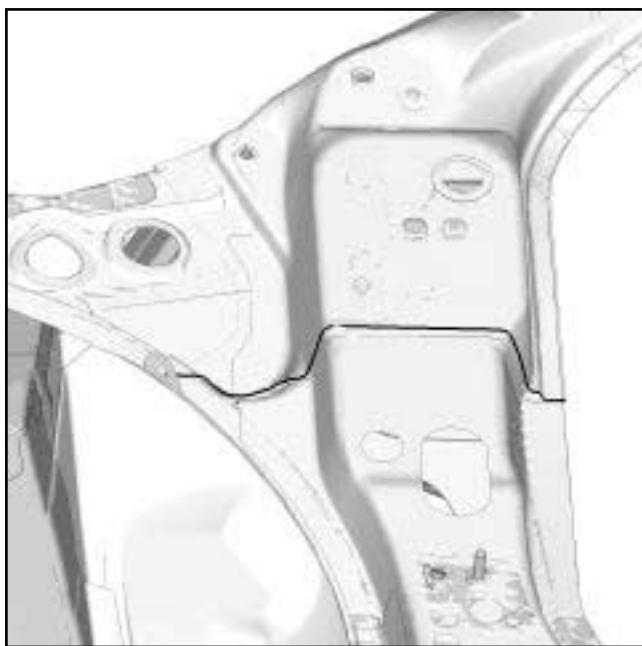
4 - A-pillar lower section replacement without the scuttle side panel reinforcement



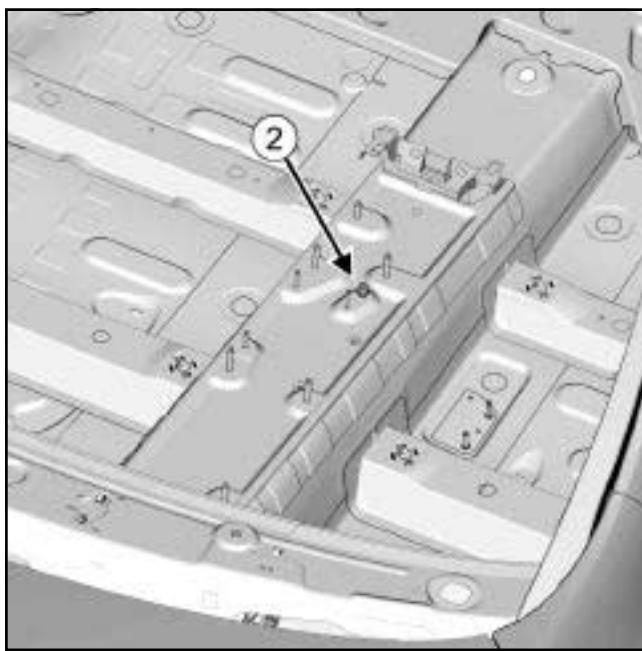
134791

D91

Section F



134790

III - POSITIONING OF THE NEARBY ELECTRICAL EARTHS

134783

WARNING

To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

Position the welding machine earth as close as possible to the weld zone **see MR 400**.

SIDE UPPER STRUCTURE

Upper body: General description

43A

B91 or K91

Note:

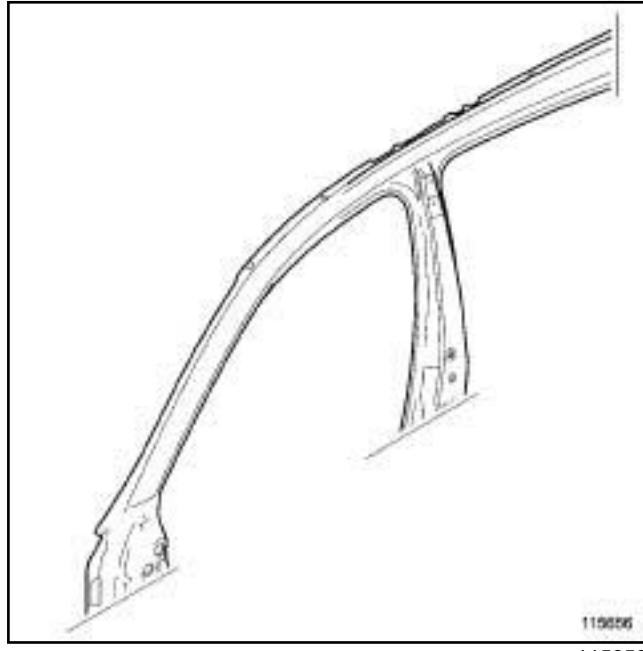
The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400**.

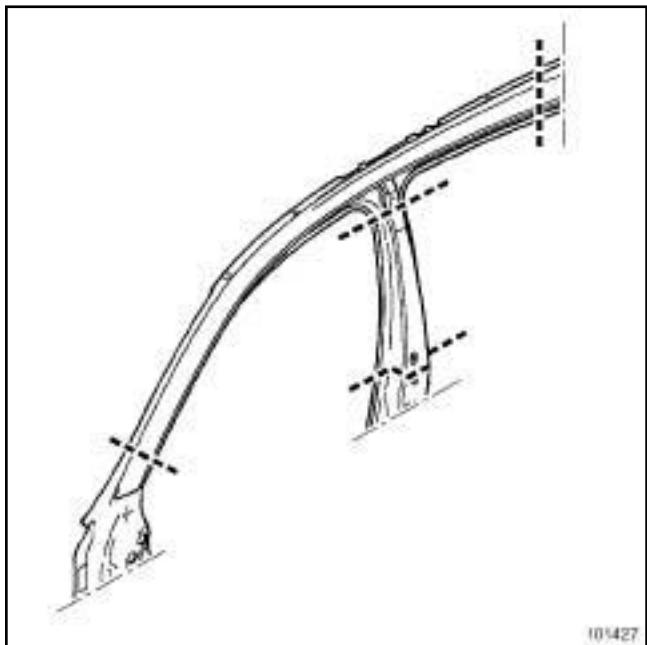
I - DESIGN OF THE STRUCTURAL COMPONENT



115656

This is a basic part; its only function is that of an upper body.

II - AREA TO BE CUT FOR PARTIAL REPLACEMENT



101427

101427

III - ASSEMBLY METHOD FOR A PARTIAL REPLACEMENT

Only the connections which are specific to the partial replacement by cutting are indicated.

WARNING

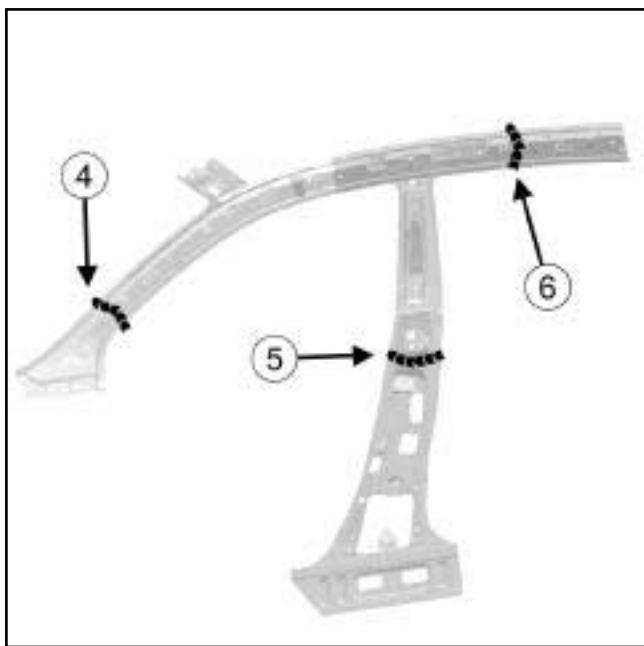
If the mating faces of the parts to be welded are not accessible, make EGW plug welds to replace the original resistance welds (see **MR 400**).

If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400**).

SIDE UPPER STRUCTURE
Upper body: General description

43A

B91 or K91



132023

Lines (4) , (5) and (6) on the drawing show a butt weld by continuous EGW welding.

Weld (6) along the butt weld line.

B91 or K91

Note:

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

DESIGN OF THE STRUCTURAL COMPONENT

Note:

For a detailed description of a particular connection, see **MR 400**.

K91

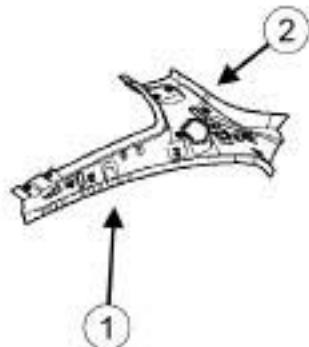


110493

This is a basic part, its only function is that of the B-pilar lining.

If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400**).

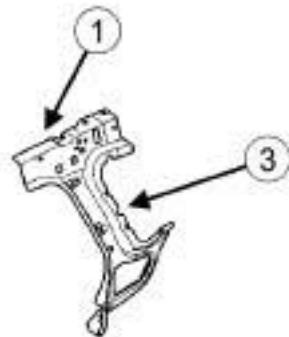
B91



122765

Cette pièce est de type composé, elle remplit la fonction de doublure de brancard (1) et de renfort de coin supérieur arrière (2) .

K91



122766

122766

SIDE UPPER STRUCTURE

Side roof rail lining: General description

43A

B91 or K91

Cette pièce est de type composé, elle remplit la fonction de doublure de brancard (1) et de renfort de fixation de ceinture de sécurité (3).

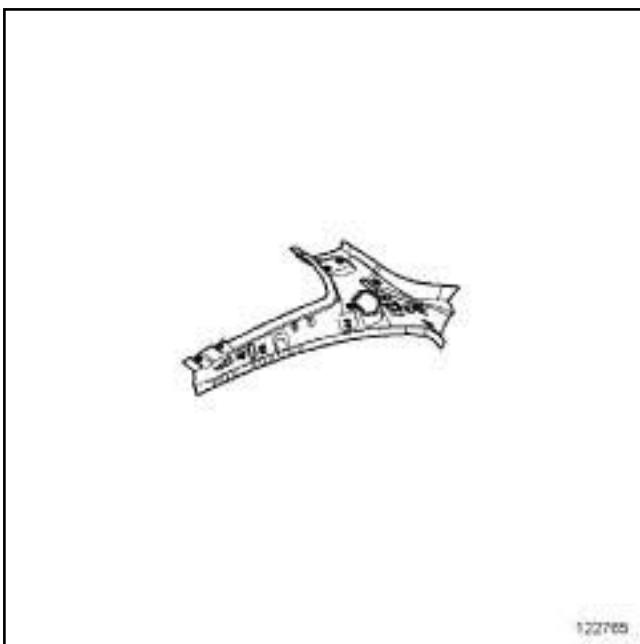


SIDE UPPER STRUCTURE

Side roof rail lining: Description

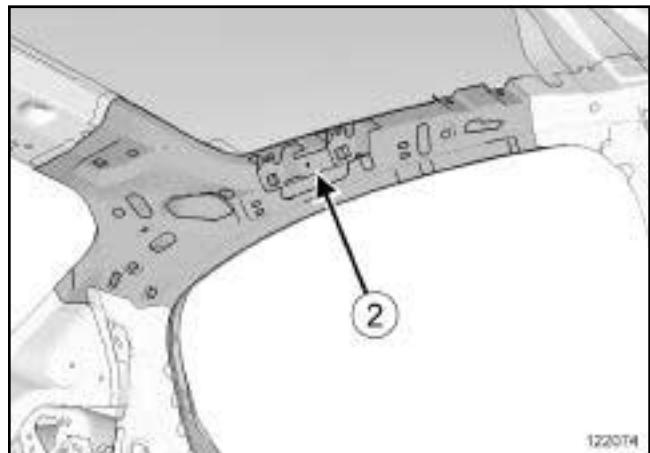
43A

B91



II - PART IN POSITION

Complete replacement



122765

122074

To replace this part, also order the quarter panel insert (see **40A, General information, Hollow section inserts: List and location of components**, page **40A-11**).

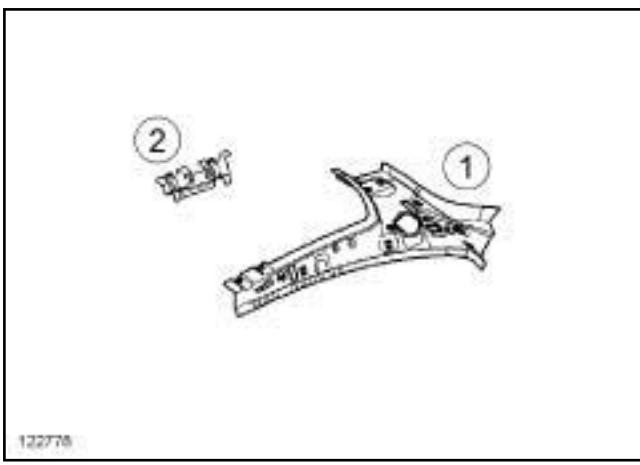
WARNING

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**).

There is only one way of replacing this part:

- complete replacement.

I - COMPOSITION OF THE SPARE PART

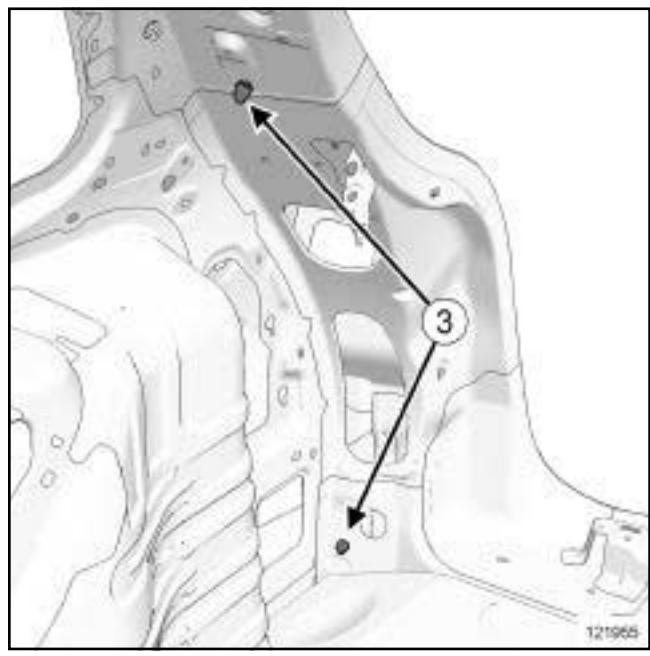


122778

Note:

For more detailed information on welded connections with three thicknesses, see **MR 400**.

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



121955

No.	Description	Type	Thick-ness (mm)
(1)	Quarter panel lin-ing	Mild steel	1.5
(2)	Grab handle fixed bridge piece	HLE	1.3

SIDE UPPER STRUCTURE
Side roof rail lining: Description

43A

B91

IMPORTANT

To avoid damaging the vehicle's electric and electronic components, the battery and the earths of any wiring harness near the weld area must be disconnected.

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

SIDE UPPER STRUCTURE

Side roof rail lining: Description

43A

K91



122766

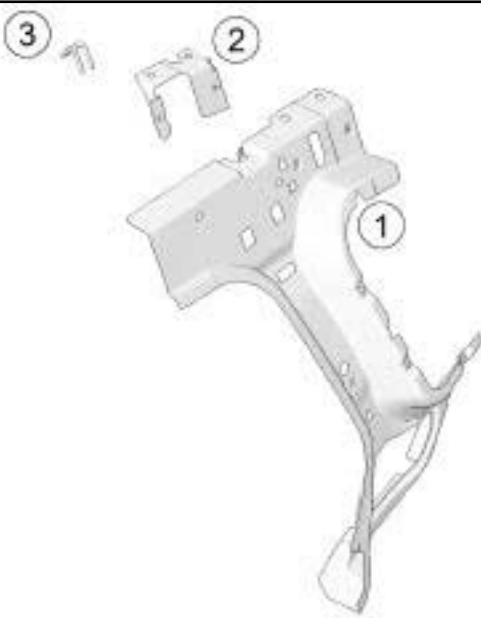
122766

When replacing this part, the quarter panel front insert and the quarter panel rear insert (see **40A, General information, Hollow section inserts: List and location of components**, page **40A-11**) must also be ordered.

The options for replacing this part are as follows:

- partial replacement of the lower section
- partial replacement of the upper section
- complete replacement.

I - COMPOSITION OF THE SPARE PART

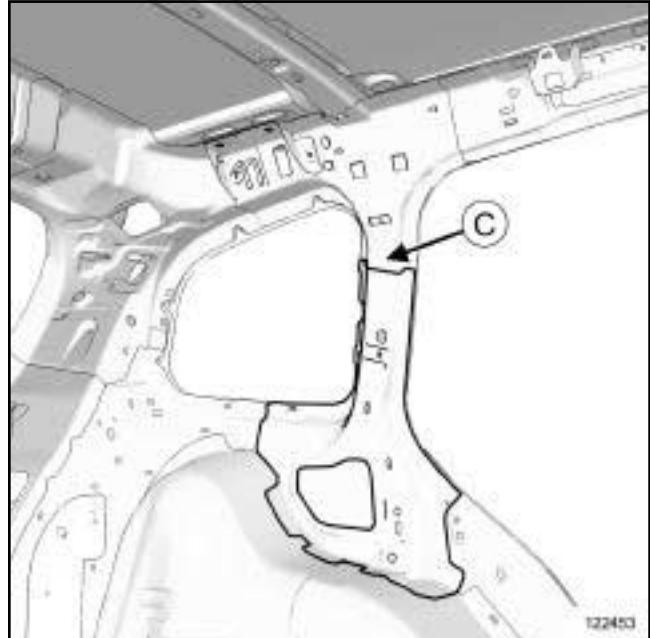


122071

No.	Description	Type	Thickness (mm)
(1)	Roof drip moulding lining	HEL	1.5
(2)	Retaining mounting bridge piece	HEL	1.3
(3)	Luggage retention front mounting strap		

II - PART IN POSITION

1 - Replacement of the lower section



122453

SIDE UPPER STRUCTURE
Side roof rail lining: Description

43A

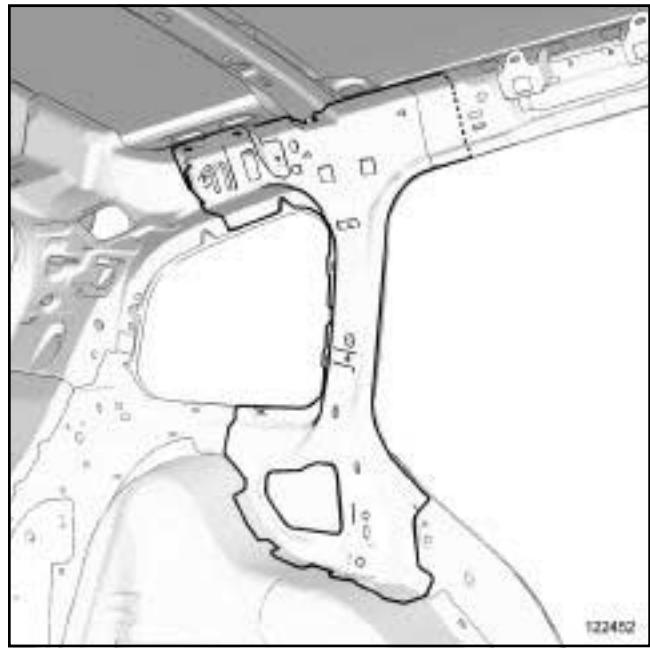
K91

Section C



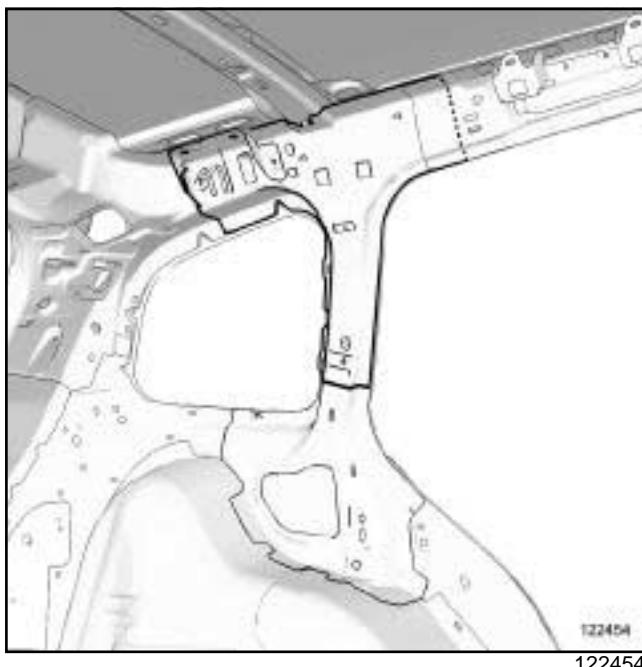
122072

3 - Complete replacement



122452

2 - Replacement of the upper section



122454

WARNING

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**).

Note:

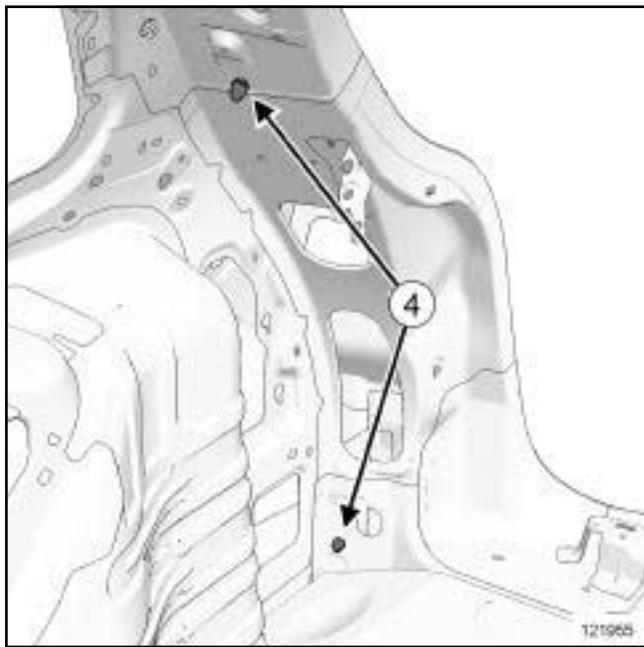
For more detailed information on welded connections with three thicknesses, see **MR 400**.

SIDE UPPER STRUCTURE
Side roof rail lining: Description

43A

K91

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



IMPORTANT

To avoid damaging the vehicle's electric and electronic components, the battery and the earths of any wiring harness near the weld area must be disconnected.

The earth of the welding machine must be placed as close as possible to the weld area.

B91 or D91 or K91

Note:

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400**.

I - DESIGN OF THE STRUCTURAL COMPONENT

B91

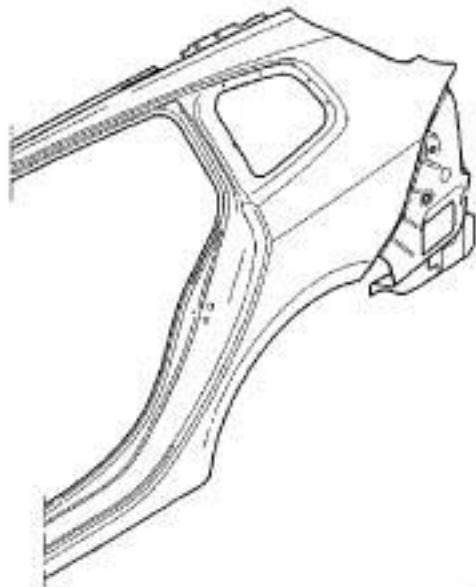


122763

This part has two special features:

- it is welded under the roof,
- it is crimped on the lower section.

K91



122762

This part has two special features:

- it is welded under the roof,
- it is crimped on the lower section.

D91



134741

REAR UPPER STRUCTURE

Rear wing panel: General description

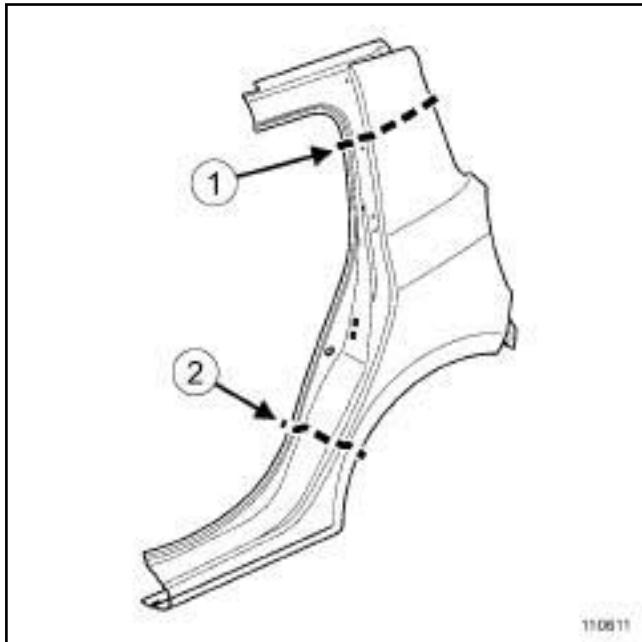
44A

B91 or D91 or K91

This part is a distinct component of the body side. It can be disassembled without a partial cut.

II - AREA TO BE CUT FOR PARTIAL REPLACEMENT

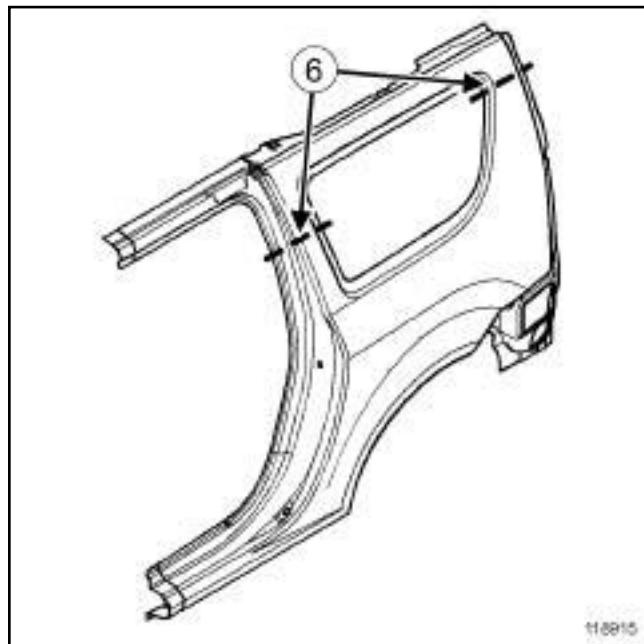
B91



110611

Lines (1) and (2) in the drawing show the areas in which it is possible to carry out a partial replacement.

K91



118915

Lines (6) in the drawing show the areas in which it is possible to carry out a partial replacement.

III - ASSEMBLY METHOD FOR A PARTIAL REPLACEMENT

Only the connections which are specific to the partial replacement by cutting are indicated.

WARNING

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**).

If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400**).

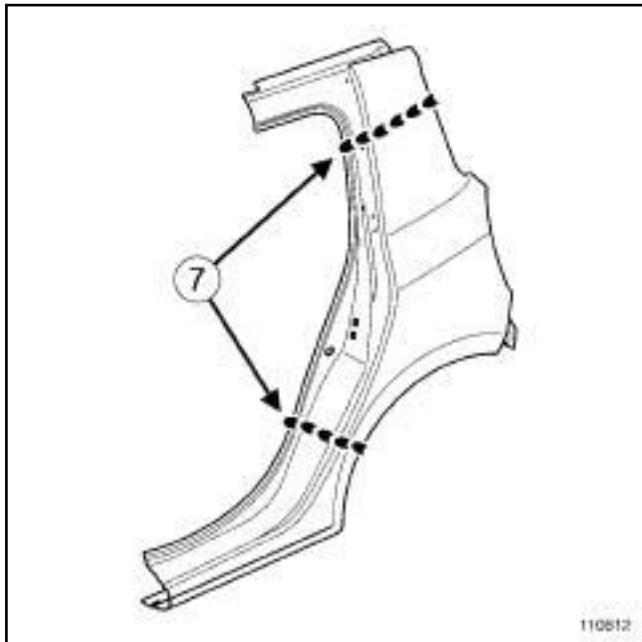
REAR UPPER STRUCTURE

Rear wing panel: General description

44A

B91 or D91 or K91

B91

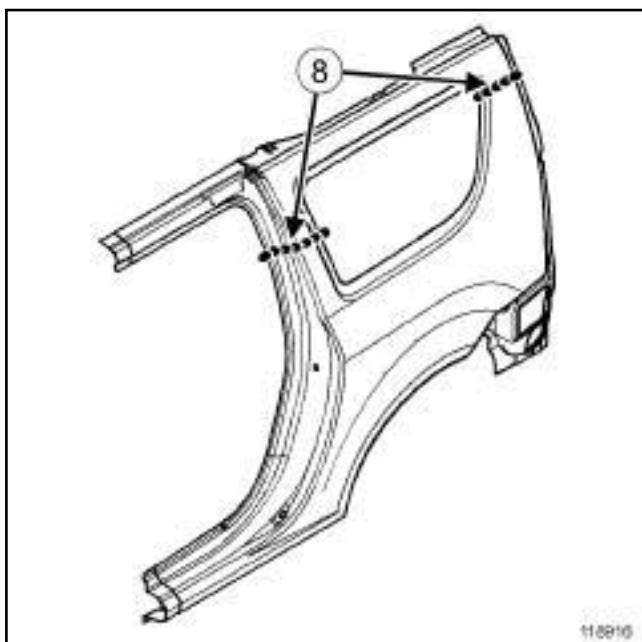


110612

Lines (7) in the diagram show butt welding by continuous EGW welding.

Lines (8) in the diagram show butt welding by continuous EGW welding.

K91



118916

REAR UPPER STRUCTURE

Rear wing panel: Description

44A

B91



122763

To replace this part, also order the rear wheel arch insert and the quarter panel insert (see **40A, General information, Hollow section inserts: List and location of components**, page **40A-11**) .

The options for replacing this part are as follows:

- lower section replacement,
- central section replacement,
- complete replacement.

I - COMPOSITION OF THE SPARE PART

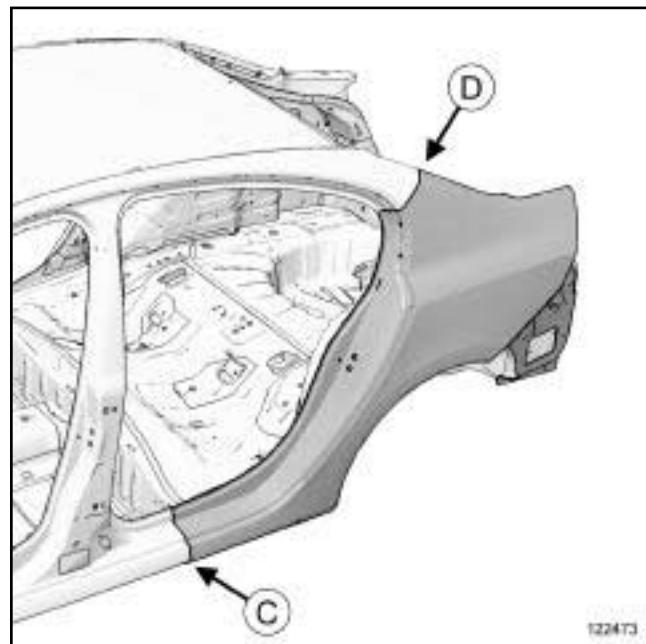


128234

No.	Description	Type	Thickness (mm)
(1)	Rear wing panel	Mild steel	0.75
(2)	Striker plate stiffener	Mild steel	1.2

II - PART IN POSITION

1 - Replacement of the lower section



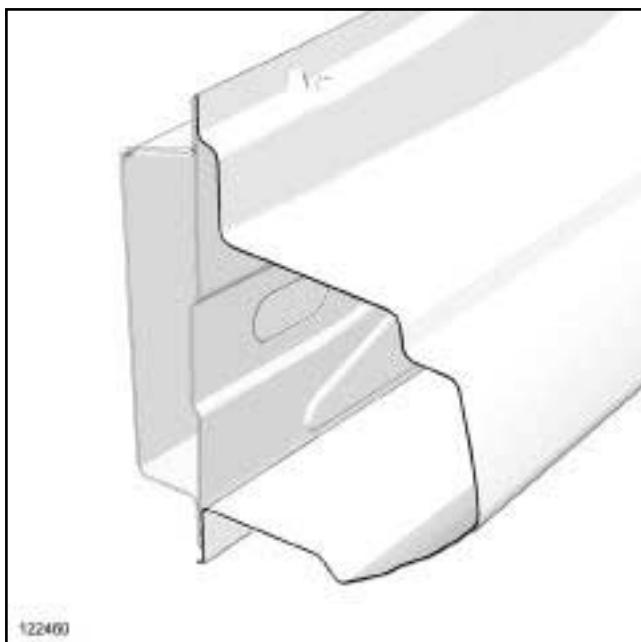
122473

REAR UPPER STRUCTURE
Rear wing panel: Description

44A

B91

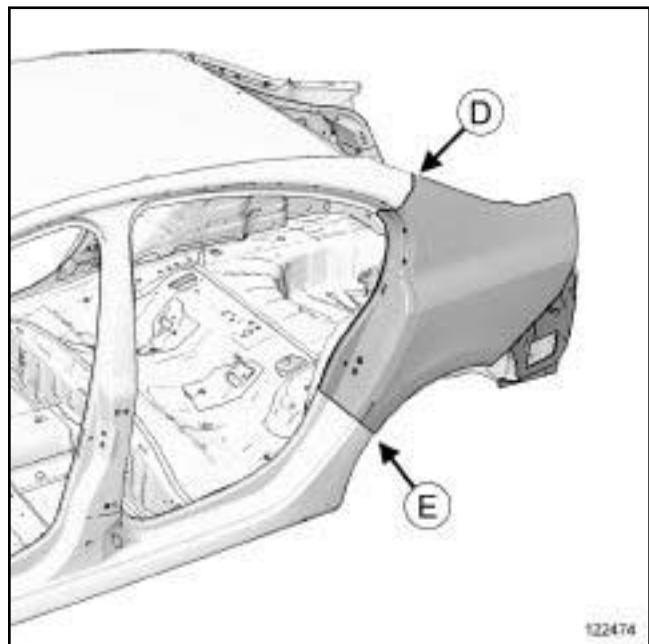
Section C



122460

122460

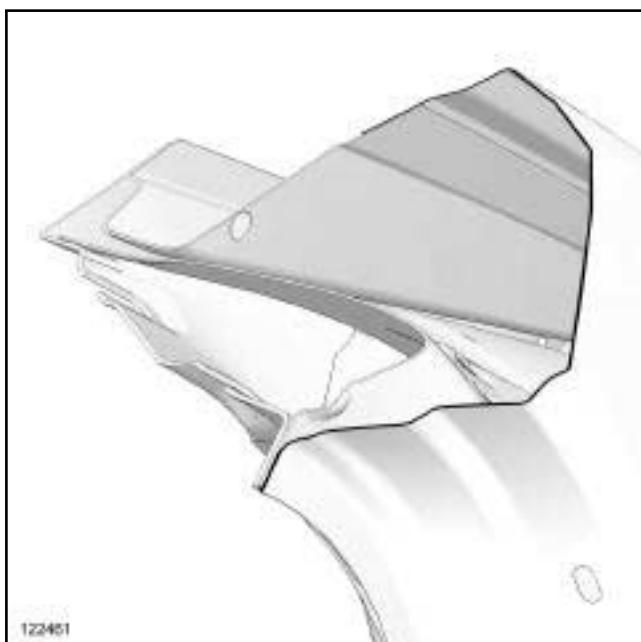
2 - Central section replacement



122474

122474

Section D



122461

122461

Section E



122446

122446

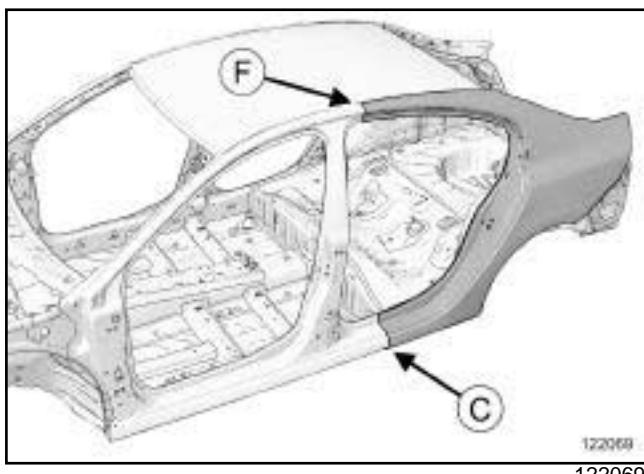
REAR UPPER STRUCTURE

Rear wing panel: Description

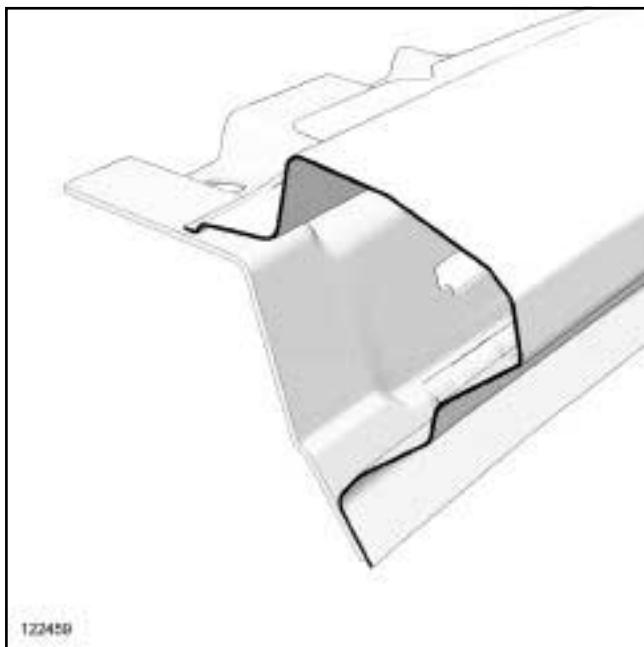
44A

B91

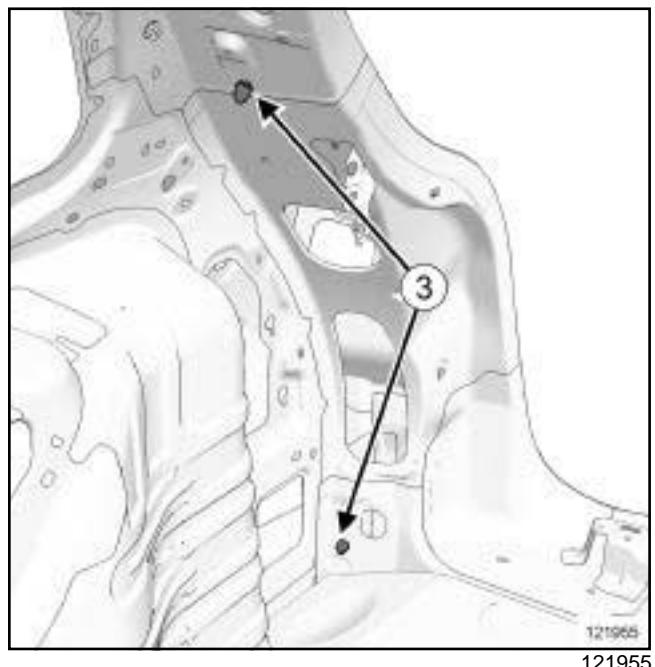
3 - Complete replacement



Section F



III - POSITIONING OF LOCAL ELECTRICAL EARTHS



IMPORTANT

To avoid damaging the vehicle's electric and electronic components, the battery and the earths of any wiring harness near the weld area must be disconnected.

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

WARNING

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**).

Note:

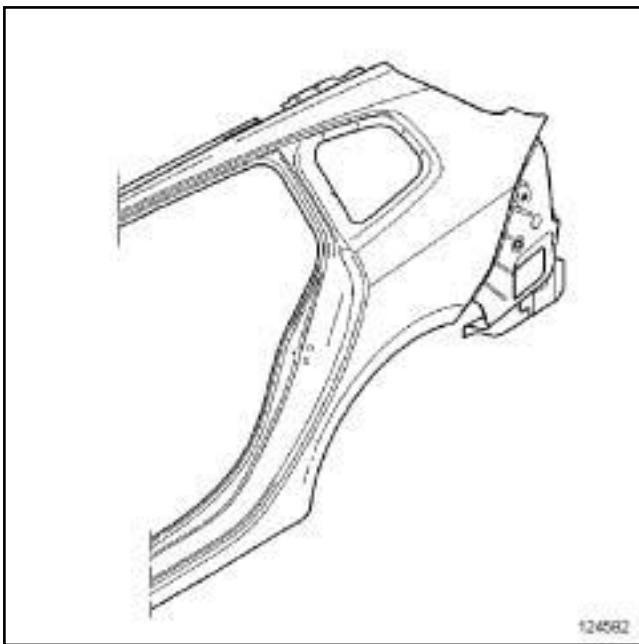
For more detailed information on welded connections with three thicknesses, see **MR 400**.

REAR UPPER STRUCTURE

Rear wing panel: Description

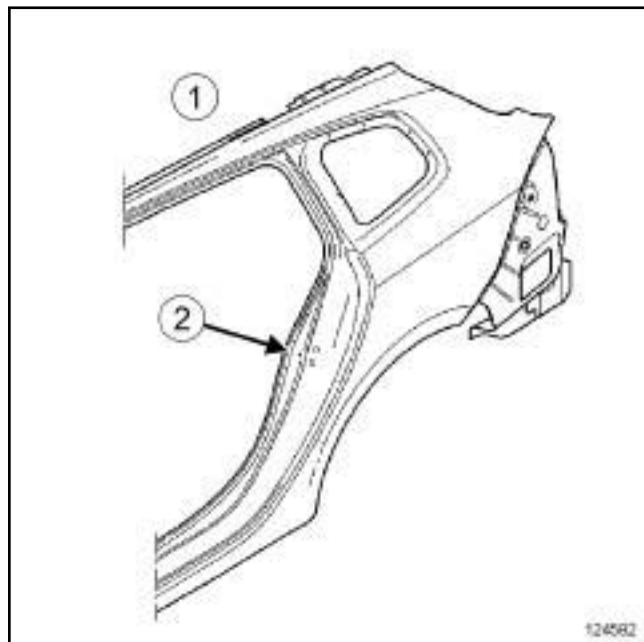
44A

K91



124592

I - COMPOSITION OF THE SPARE PART



124592

When replacing this part, always order additional corresponding inserts (see **40A, General information, Hollow section inserts: List and location of components**, page **40A-11**).

The options for replacing this part are as follows:

- lower section replacement,
- upper section replacement,
- rear end section replacement,
- central section replacement,
- complete replacement.

No.	Description	Type	Thickness (mm)
(1)	Rear wing panel	Mild steel	0.75
(2)	Striker plate stiffener	Mild steel	1.2

REAR UPPER STRUCTURE

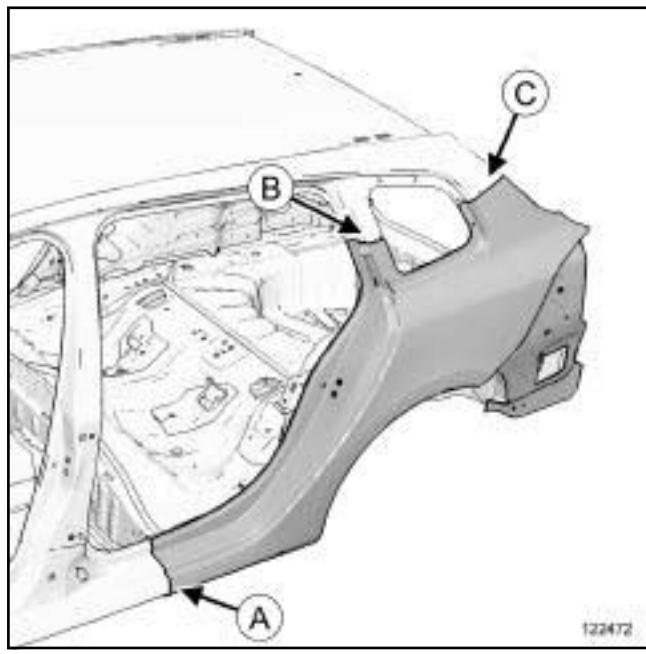
Rear wing panel: Description

44A

K91

II - PART FITTED

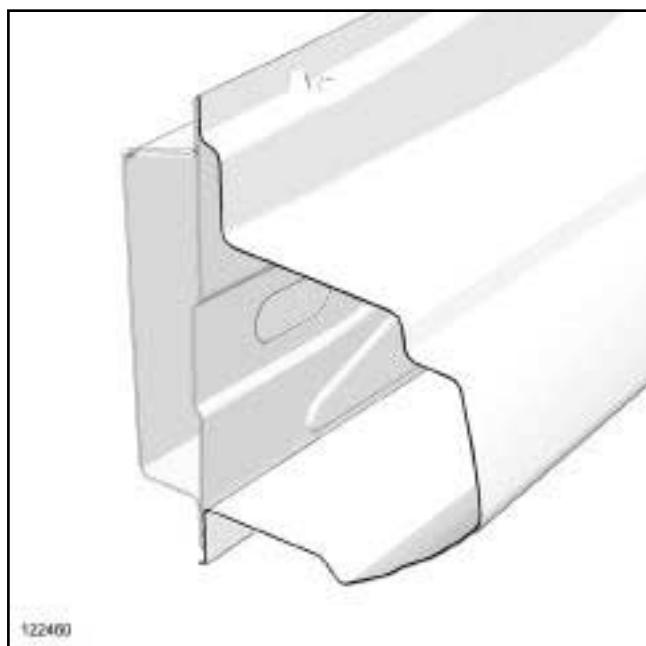
1 - Lower section replacement



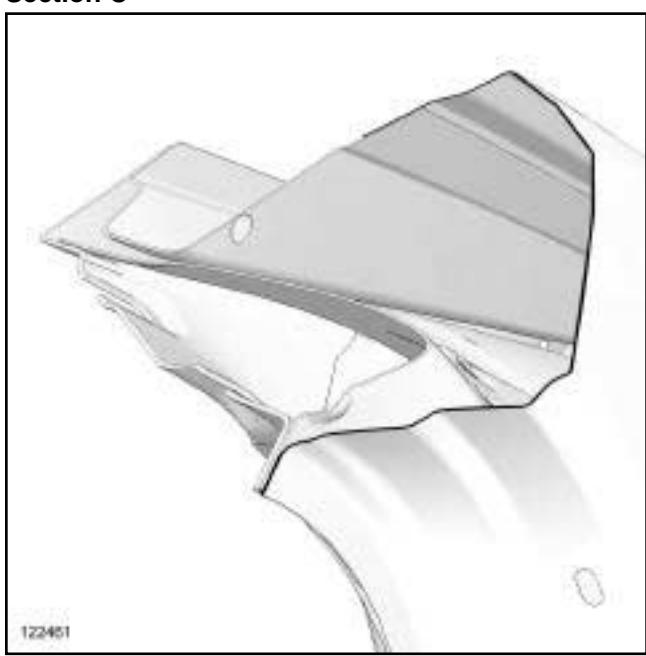
Section B



Section A



Section C



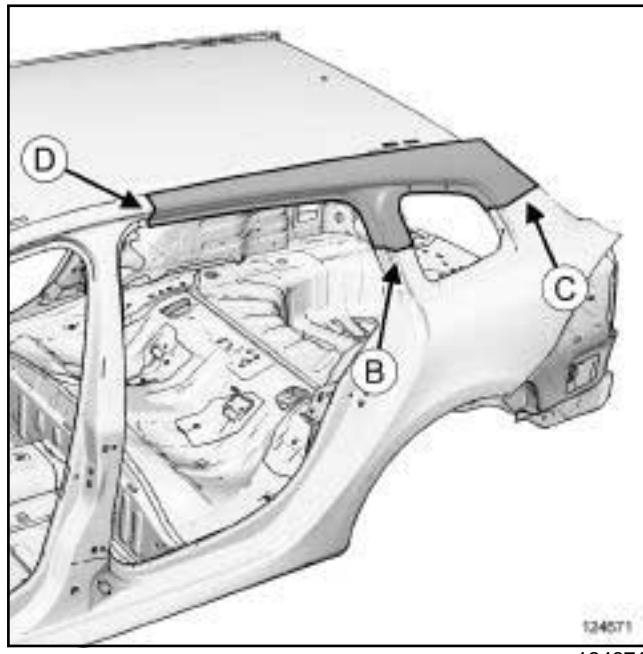
REAR UPPER STRUCTURE

Rear wing panel: Description

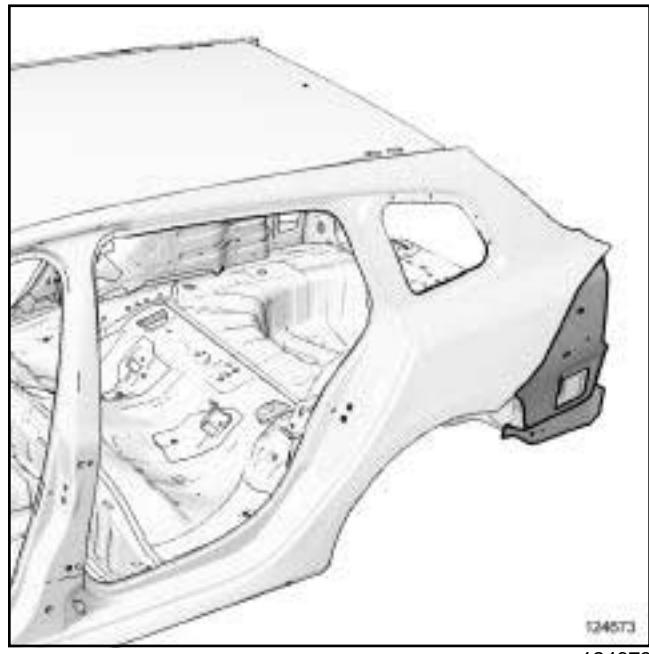
44A

K91

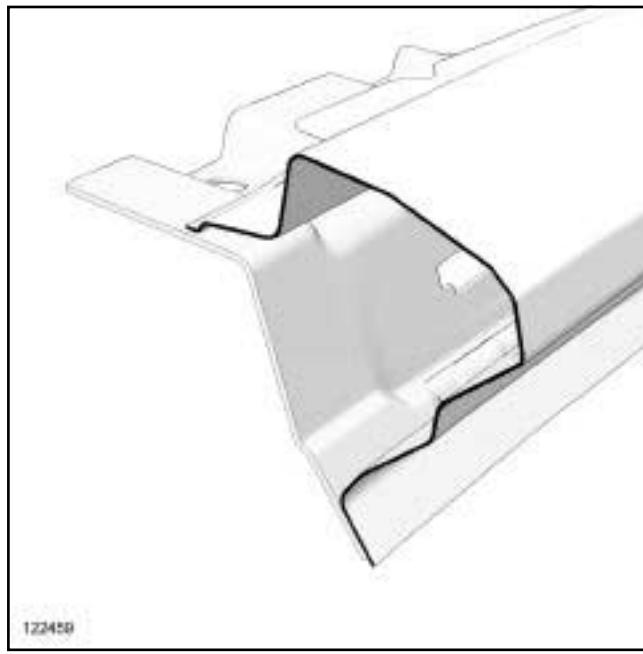
2 - Replacement of the upper section



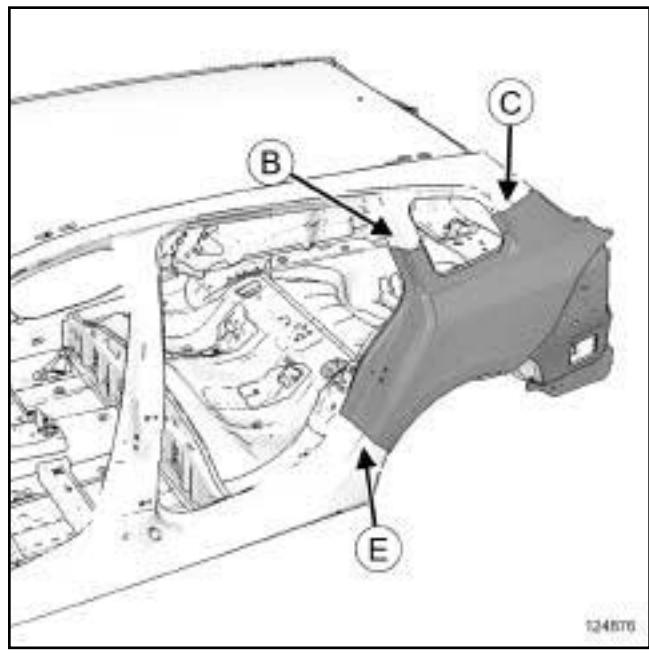
3 - Rear end section replacement



Section D



4 - Central section replacement



REAR UPPER STRUCTURE

Rear wing panel: Description

44A

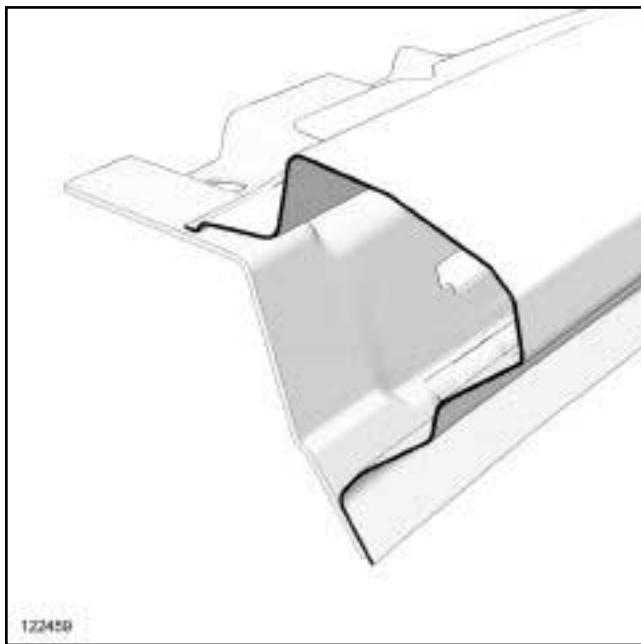
K91

Section E



122446

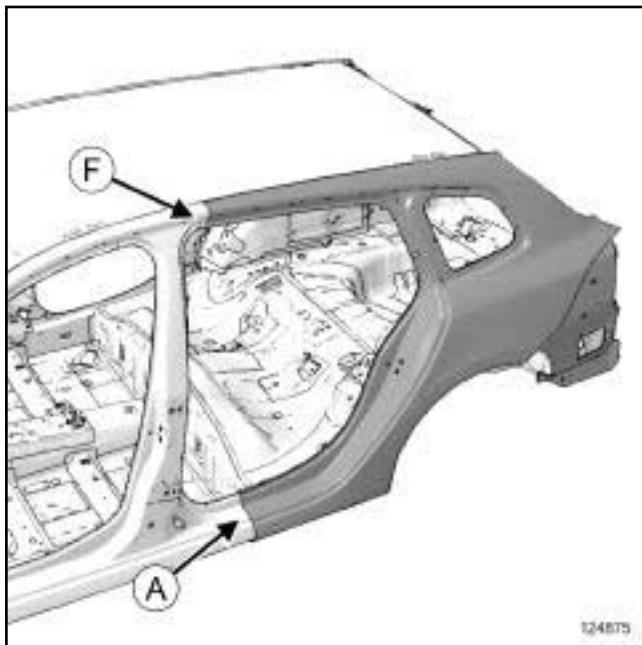
Section F



122459

122459

5 - Complete replacement

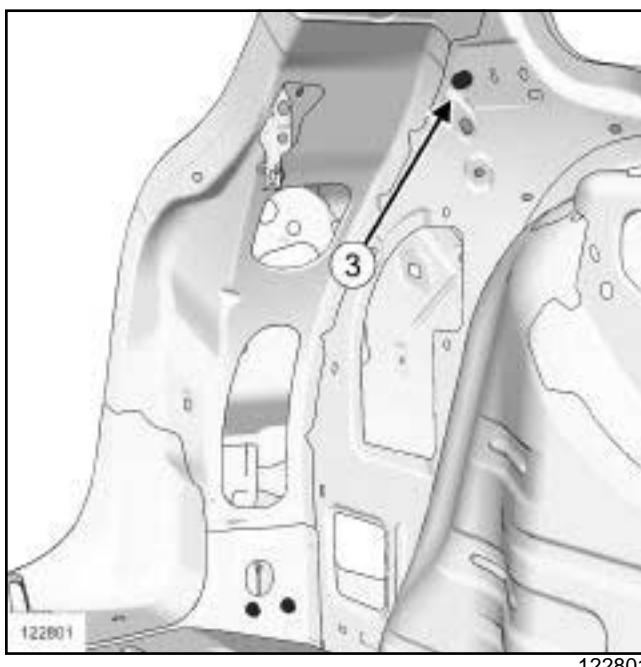


124875

Note:

For a detailed description of welded connections, see **MR 400**.

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



122801

122801

REAR UPPER STRUCTURE

Rear wing panel: Description

44A

K91

WARNING

To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

The earth of the welding machine must be placed as close as possible to the weld area (see **MR 400**).

REAR UPPER STRUCTURE

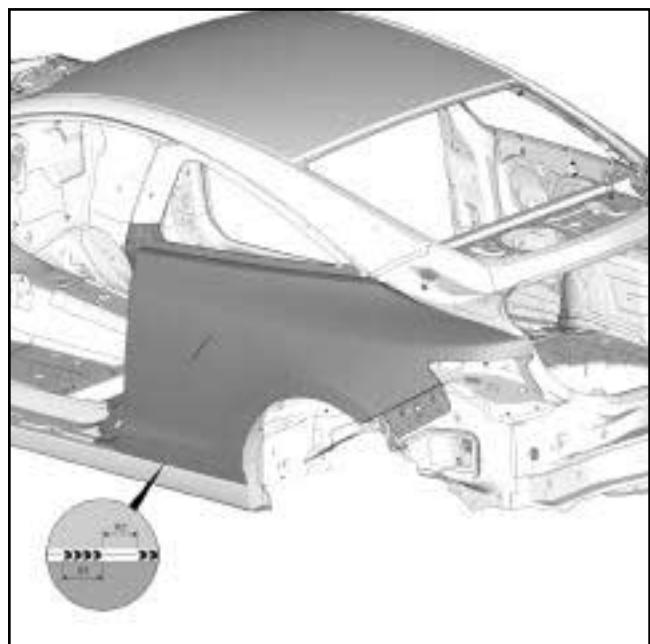
Rear wing panel: Description

44A

D91



134741



134742

There is only one way of replacing this part:

- complete replacement.

I - COMPOSITION OF THE SPARE PART

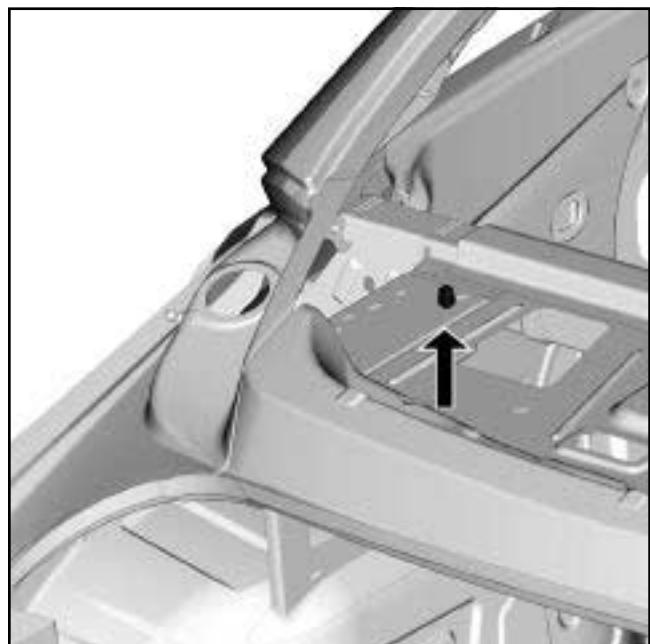


134741

Note:

For the connection of this joint (see **Electrical resistance spot welding connection with indirect access: Description**) (MR 400, 40B, Electrical resistance welded connections).

II - POSITIONING OF LOCAL ELECTRICAL EARTHS



134819

No.	Description	Type	Thickness (mm)
(1)	Rear wing panel	Mild steel	0.75

REAR UPPER STRUCTURE

Rear wing panel: Description

44A

D91

WARNING

To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

Position the welding machine earth as close as possible to the weld zone **see MR 400**.

B91 or D91 or K91

Note:

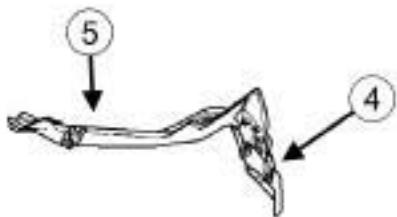
The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400**.

DESIGN OF THE STRUCTURAL COMPONENT



124594

124594

The special feature of this part is that it is made up of two components:

- the rear light mounting (4) ,
- the rear wing panel rain channel (5) .

If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400**).

REAR UPPER STRUCTURE

Rear wing panel rain channel: Description

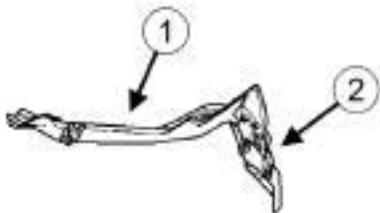
44A

B91 or K91

The options for replacing this part are as follows:

- lower section replacement,
- complete replacement.

I - COMPOSITION OF THE SPARE PART

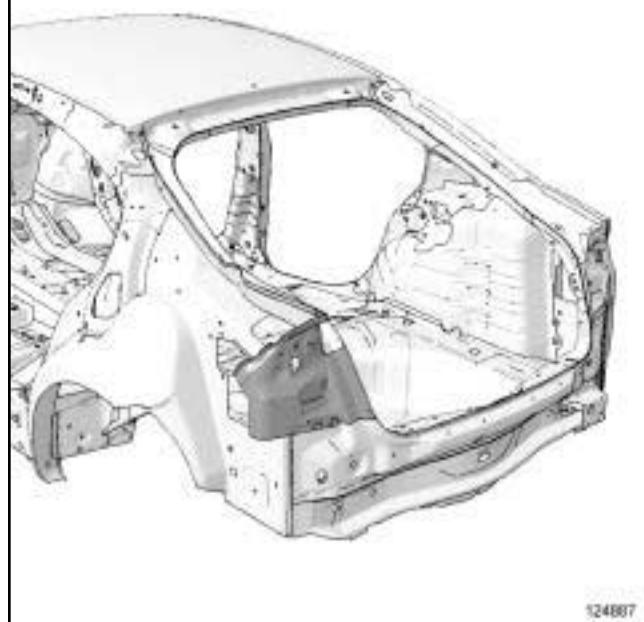


124594

124594

II - PART IN POSITION

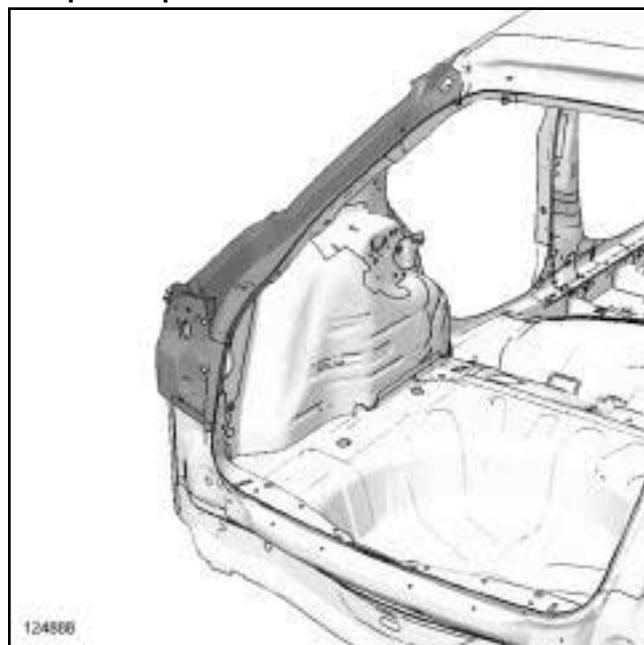
Lower section replacement



124887

124887

Complete replacement



124888

124888

Note:

For a detailed description of welded connections, see **MR 400**.

REAR UPPER STRUCTURE

Rear wing panel rain channel: Description

44A

D91



134756

The options for replacing this part are as follows:

- lower section replacement,
- complete replacement.

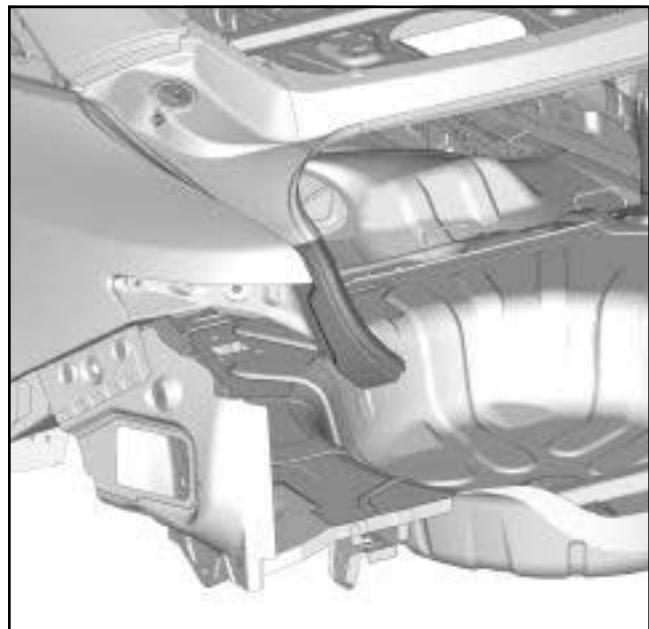
I - COMPOSITION OF THE SPARE PART



134757

No.	Description	Type	Thickness (mm)
(1)	Lower side rear rain channel	Mild steel	1
(2)	Upper side rear rain channel	Mild steel	1.2

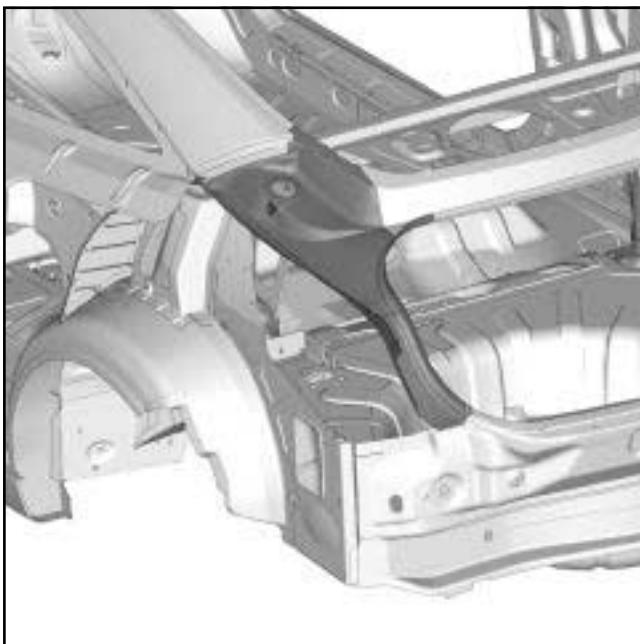
1 - Lower section replacement



134758

D91

2 - Complete replacement



134760

WARNING

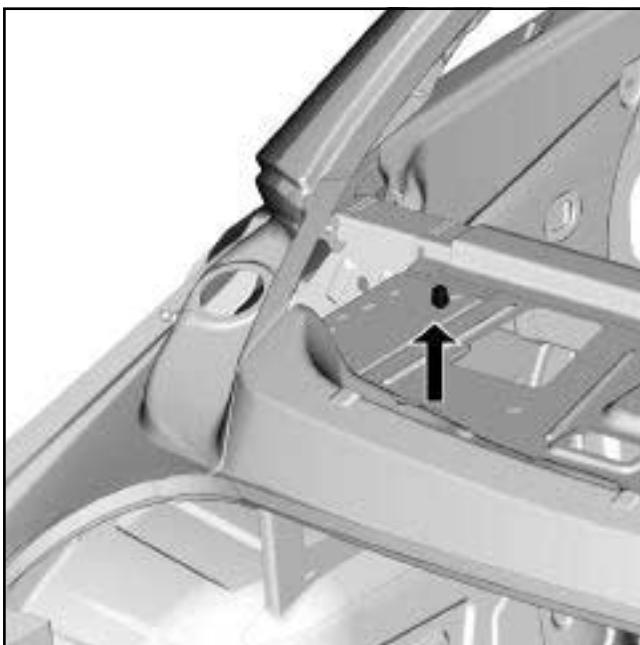
To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

Position the welding machine earth as close as possible to the weld zone **see MR 400**.

Note:

For a detailed description of welded connections, see **MR 400**.

II - POSITIONING OF LOCAL ELECTRICAL EARTHS



134819

REAR UPPER STRUCTURE

Rear lights mounting: Description

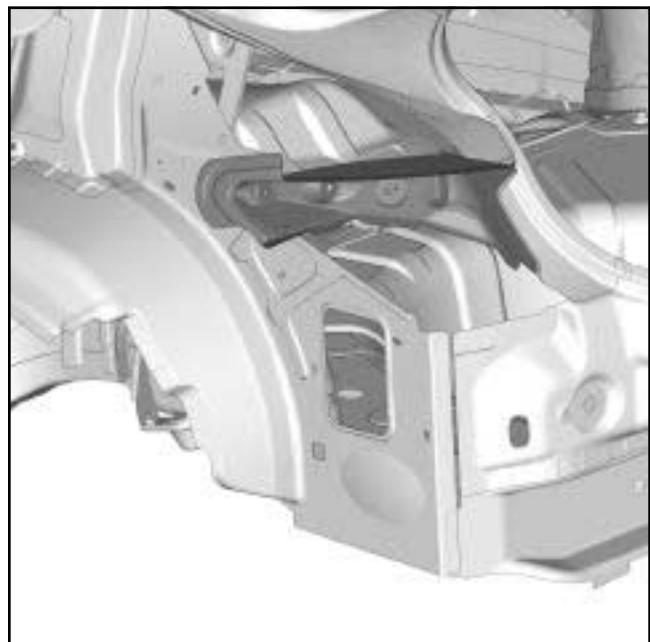
44A

D91



134738

II - PART FITTED

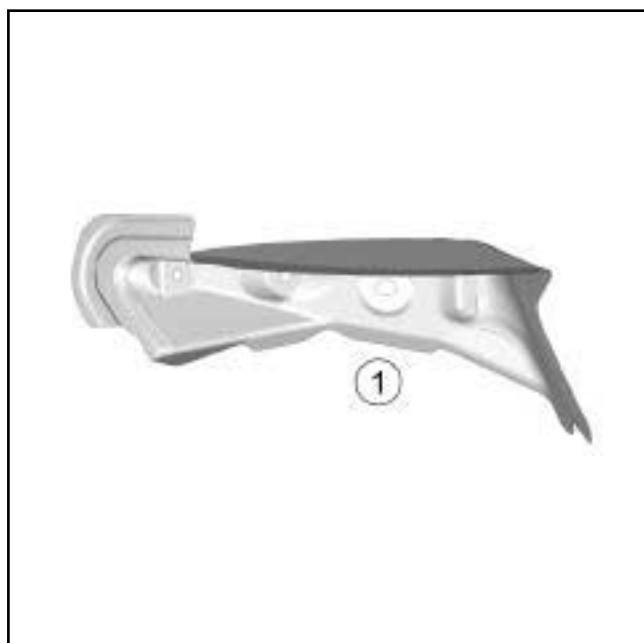


134740

There is only one way of replacing this part:

- complete replacement.

I - COMPOSITION OF THE SPARE PART

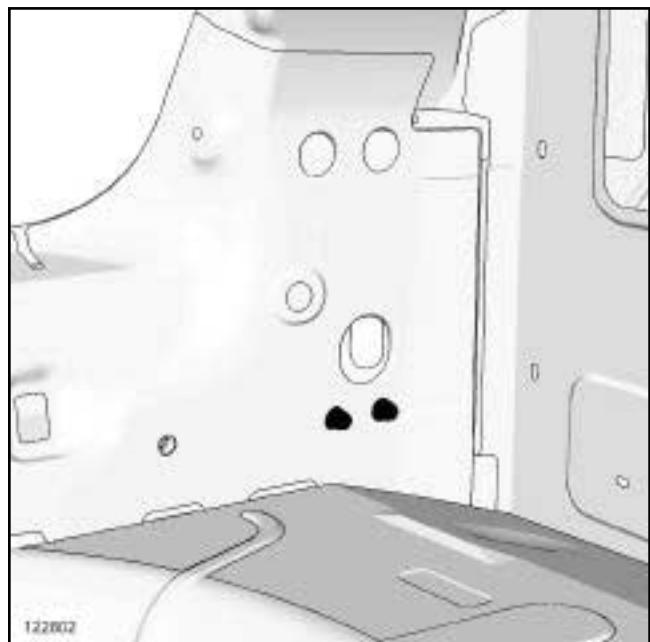


134738

Note:

For a detailed description of welded connections,
see **MR 400**.

III - POSITIONING OF THE NEARBY ELECTRICAL EARTHS



122802

No.	Description	Type	Thickness (mm)
(1)	Lights support lining	Mild steel	0.65

REAR UPPER STRUCTURE
Rear lights mounting: Description

44A

D91

WARNING

To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

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

REAR UPPER STRUCTURE

Light mounting lining: Description

44A

B91

There is only one way of replacing this part:

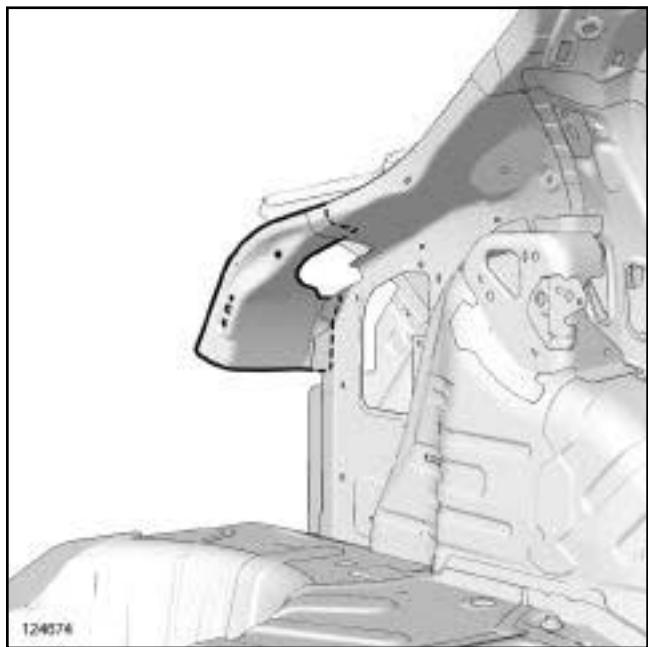
- complete replacement.

I - COMPOSITION OF THE SPARE PART



124890

II - PART IN POSITION



124674

Note:

For a detailed description of welded connections,
see **MR 400**.

No.	Description	Type	Thickness (mm)
(1)	Lights support lining	Mild steel	0.7

REAR UPPER STRUCTURE

Rear end pillar closure panel: Description

44A

K91



124889

No.	Description	Type	Thickness (mm)
(1)	Rear end pillar closure panel	Mild steel	1
(2)	Opening control mounting bridge piece	Mild steel	1.5

II - PART IN POSITION



124675

124675



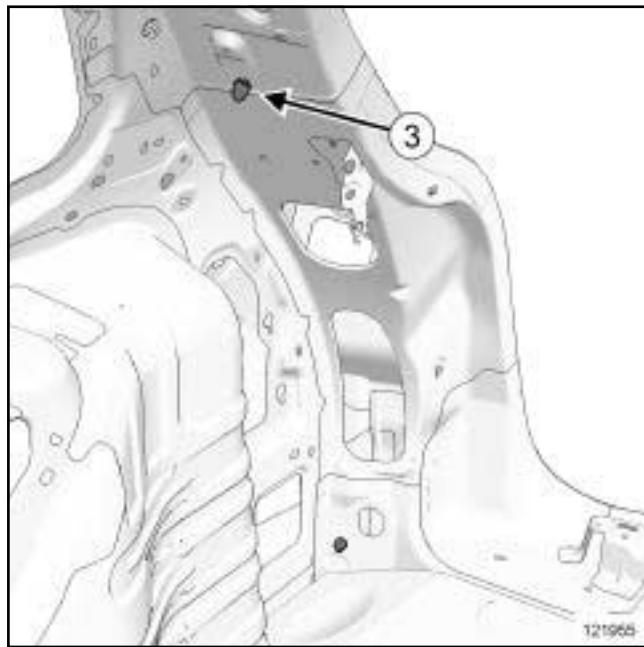
124576

124676

Note:

For a detailed description of welded connections, see **MR 400**.

K91

III - POSITIONING OF LOCAL ELECTRICAL EARTHS

121955

WARNING

To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

The earth of the welding machine must be placed as close as possible to the weld area (see **MR 400**).

B91 or D91 or K91

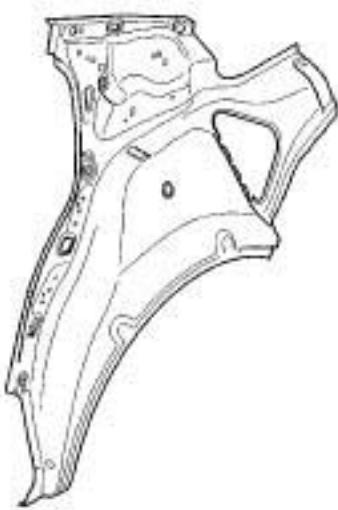
Note:

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

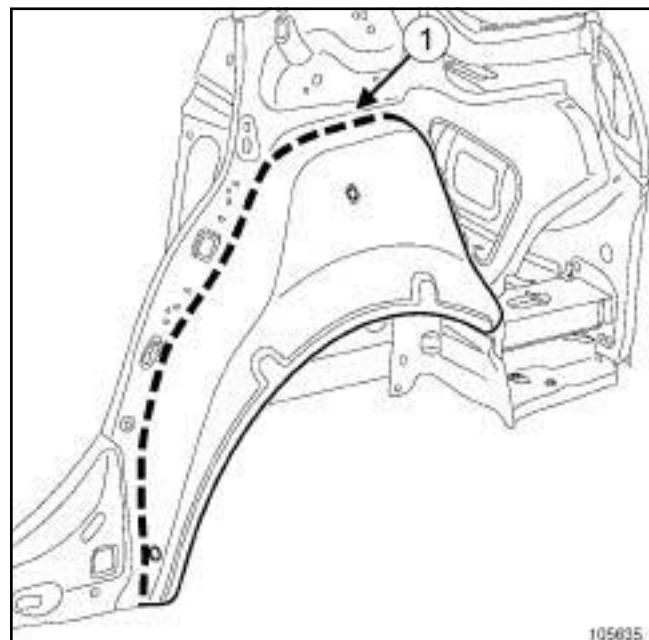
Note:

For a detailed description of a particular connection, see **MR 400**.

I - DESIGN OF THE STRUCTURAL COMPONENT

105282

The special feature of this part is its extension from the quarter panel lining to create the external rear wheel arch.

II - AREA TO BE CUT FOR PARTIAL REPLACEMENT105635
105635

The line (1) in the drawing shows the area in which it is possible to carry out a partial replacement.

III - ASSEMBLY METHOD FOR A PARTIAL REPLACEMENT

Only the connections which are specific to the partial replacement by cutting are indicated.

WARNING

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**).

If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400**).

REAR UPPER STRUCTURE

Outer rear wheel arch: General description

44A

B91 or D91 or K91



110626

110626

Line (2) on the diagram shows partial replacement and a weld by joggling with plug welds at regular intervals.

REAR UPPER STRUCTURE

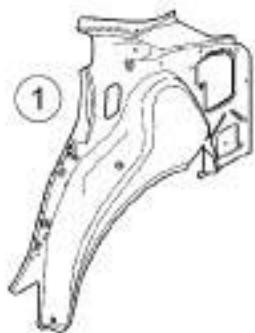
Outer rear wheel arch: Description

44A

There is only one way of replacing this part:

- partial replacement.

I - COMPOSITION OF THE SPARE PART



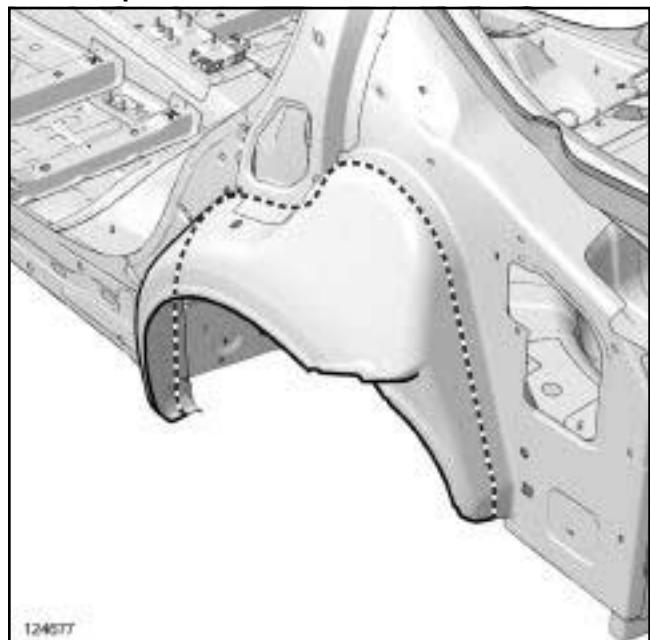
124585

124595

No.	Description	Type	Thick-ness (mm)
(1)	Outer rear wheel arch	Mild steel	0.7

II - PART FITTED

Partial replacement

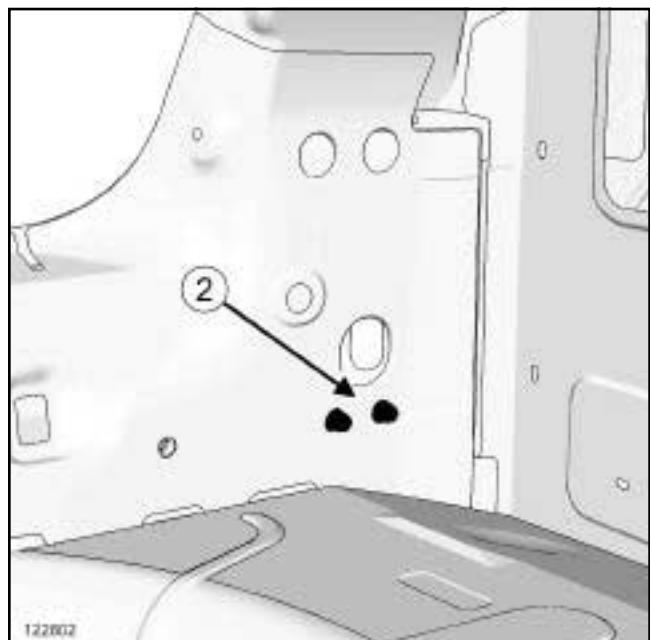


124677

Note:

For a detailed description of welded connections, see **MR 400**.

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



122802

WARNING

To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

The earth of the welding machine must be placed as close as possible to the weld area (see **MR 400**).

B91 or D91 or K91

IMPORTANT

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

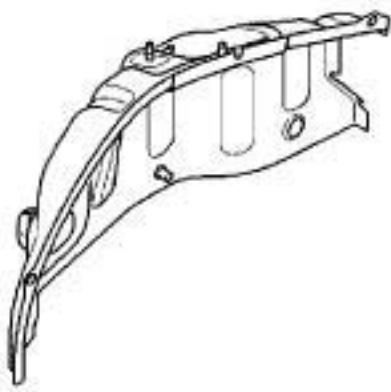
Note:

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400**.

DESIGN OF THE STRUCTURAL COMPONENT

121041

121041

The special feature of this part is that it combines the functions of the rear inner wheel arch and the rear shock absorber mounting.

If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400**).

REAR UPPER STRUCTURE

Inner rear wheel arch: Description

44A



124596
124596

There is only one way of replacing this part:

- complete replacement.

I - COMPOSITION OF THE SPARE PART



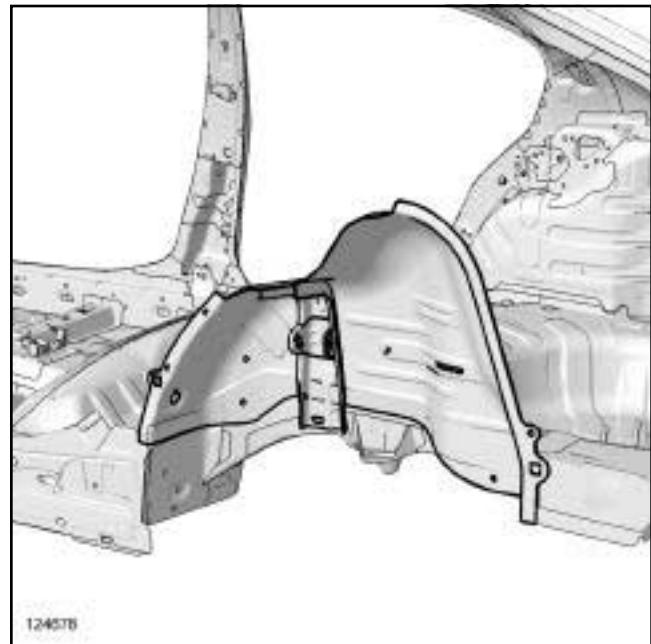
128235

No.	Description	Type	Thickness (mm)
(1)	Inner rear wheel arch	Mild steel	0.8
(2)	Shock absorber mounting reinforcement	HLE	1.5
(3)	Shock absorber mounting yoke	HLE	2
(4)	Inertia reel mounting reinforcement	HLE	2
(5)	Backrest mounting reinforcement	HLE	2

IMPORTANT

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

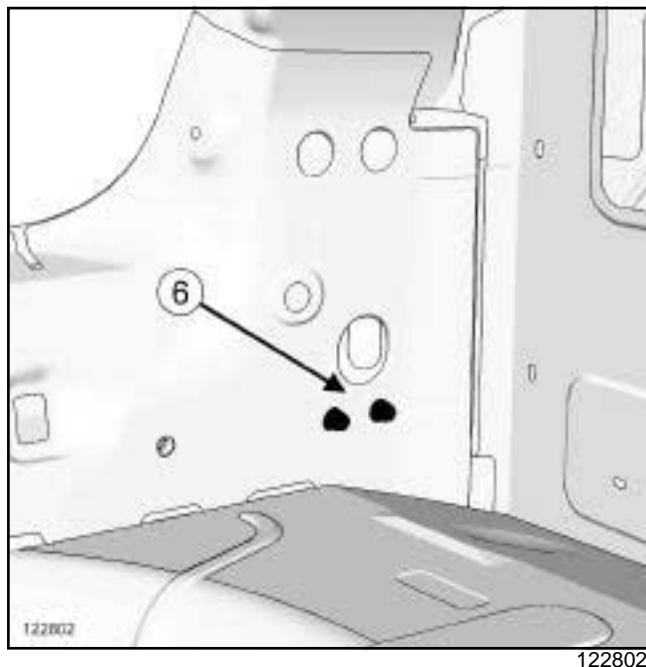
II - PART IN POSITION



Note:

For a detailed description of the welded connections, see **MR 400**.

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



WARNING

To avoid damaging the vehicle's electrical and electronic components, disconnect the earths of any wiring near the weld area.

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

REAR UPPER STRUCTURE

Inner rear wheel arch: Description

44A

D91



134734

There is only one way of replacing this part:

- complete replacement.

I - COMPOSITION OF THE SPARE PART



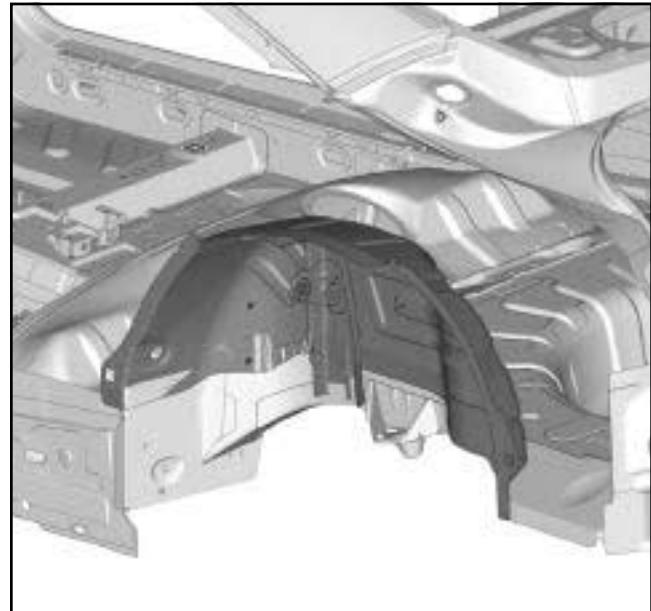
134736

No.	Description	Type	Thickness (mm)
(1)	Inner rear wheel arch	Mild steel	0.8
(2)	Frame lower mounting bridge piece	HLE	1.5
(3)	Shock absorber mounting reinforcement	HLE	1.5
(4)	Shock absorber mounting yoke	HLE	2

IMPORTANT

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

II - PART FITTED



134737

Note:

For a detailed description of welded connections, see **MR 400**.

D91

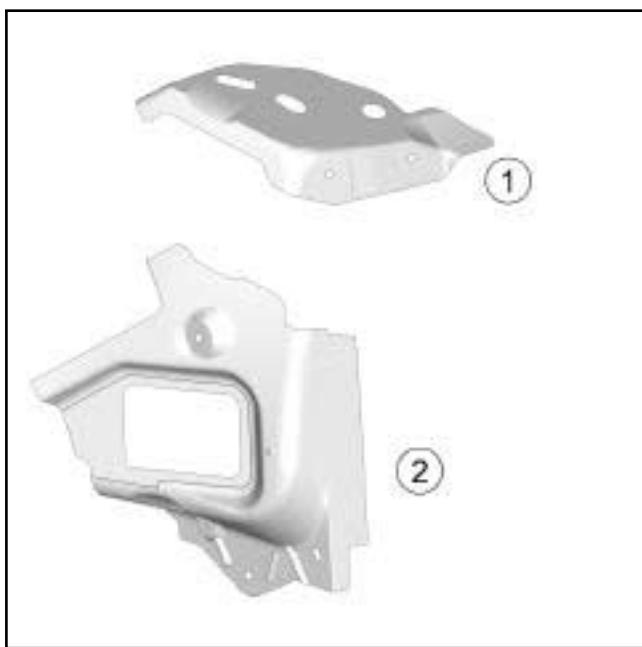


134730

The options for replacing this part are as follows:

- lower section replacement,
- complete replacement.

I - COMPOSITION OF THE SPARE PART

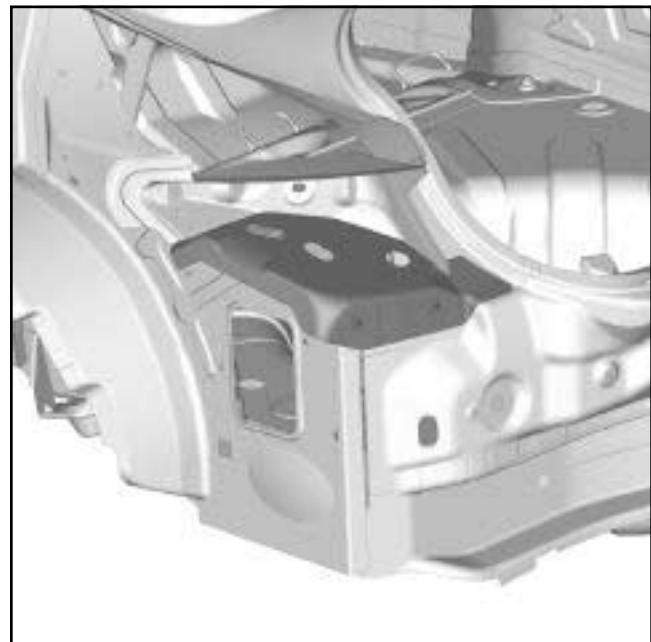


134731

No.	Description	Type	Thickness (mm)
(1)	Body side extension	Mild steel	0.75
(2)	Rear light mounting element, lower section	Mild steel	0.65

II - PART FITTED

1 - Lower section replacement



134796

WARNING

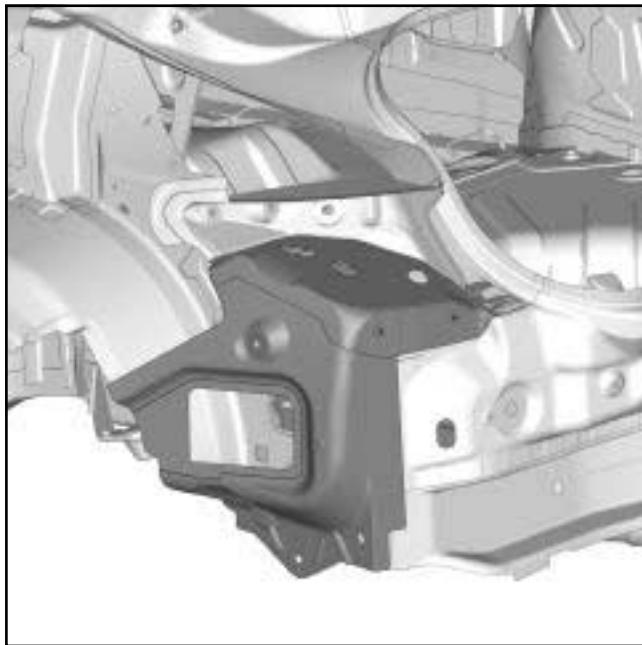
If the mating faces of the parts to be welded are not accessible, make EGW plug welds to replace the original resistance welds (see **MR 400**).

REAR UPPER STRUCTURE
Rear wheel arch extension: Description

44A

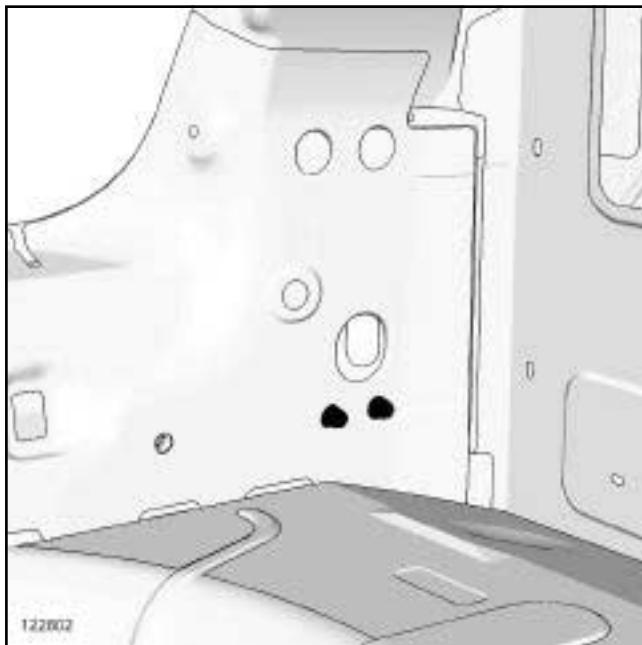
D91

2 - Complete replacement



134732

**III - POSITIONING OF LOCAL ELECTRICAL
EARTHS**



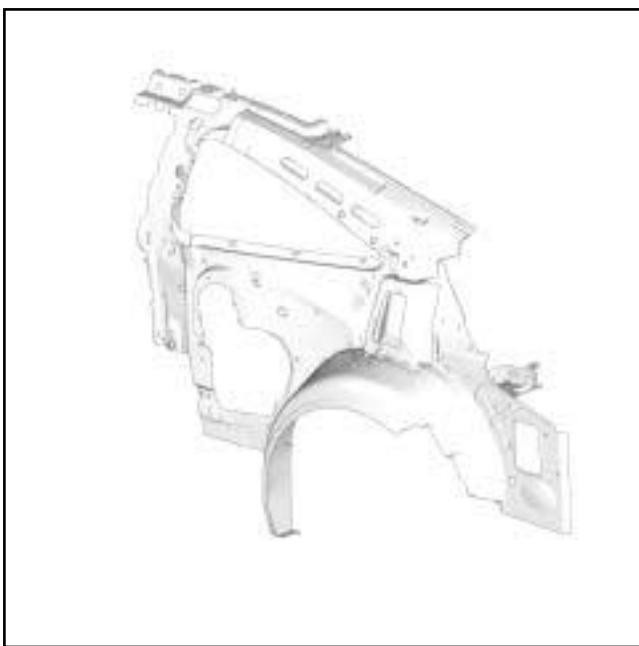
122802

REAR UPPER STRUCTURE

Quarter panel lining: Description

44A

D91



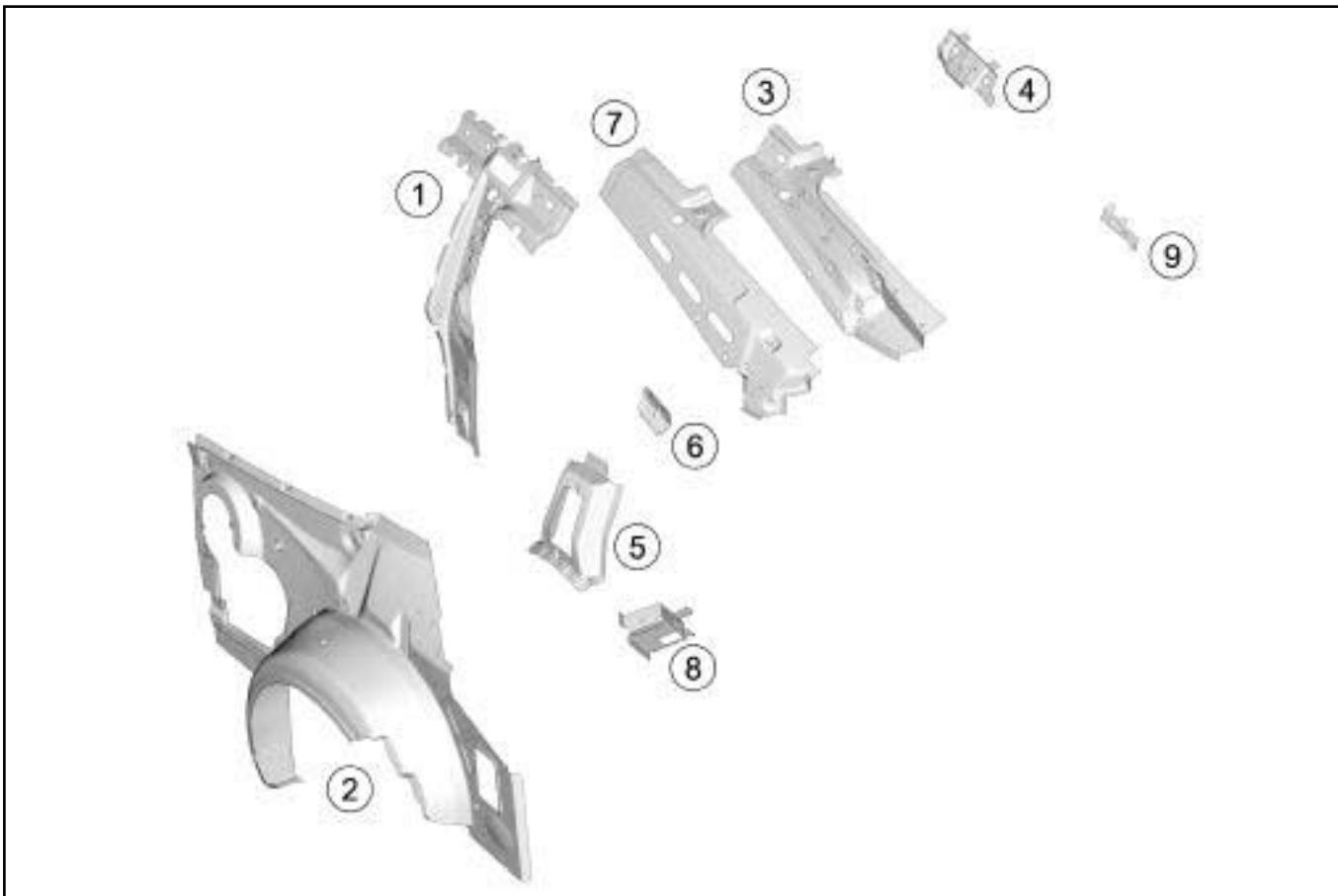
134722

- replacement of rear section, wheel arch extension,
- replacement of lower section without roof,
- complete replacement.

I - COMPOSITION OF THE SPARE PART

The options for replacing this part are as follows:

- replacement of outer wheel arch,
- replacement of front section, B-pillar lining,



134803

REAR UPPER STRUCTURE
Quarter panel lining: Description

44A

D91

No.	Description	Type	Thick-ness (mm)
(1)	Front shoulder harness reinforcement	Mild steel	1.8
(2)	Quarter panel lining	Mild steel	0.8
(3)	Rear roof drip moulding lining	Mild steel	0.7
(4)	Rear grab handle mounting bridge piece	Mild steel	1.3
(5)	Quarter panel outer rear stiffener	Mild steel	0.8
(6)	Luggage compartment lid hinge mounting reinforcement	Mild steel	1.5
(7)	Roof drip moulding rear reinforcement	Mild steel	1
(8)	Seat opening control support bridge piece	Mild steel	1.5
(9)	Mounting bridge piece of quarter panel upper section trim	Mild steel	1.2

II - PART FITTED

1 - Replacement of outer wheel arch

WARNING

Respect the position of this cut which has been determined in accordance with the position of the inner stiffeners or acoustic inserts, in order to prevent damaging the parts (inner stiffener and/or acoustic insert).

D91

Outer wheel arch



134804

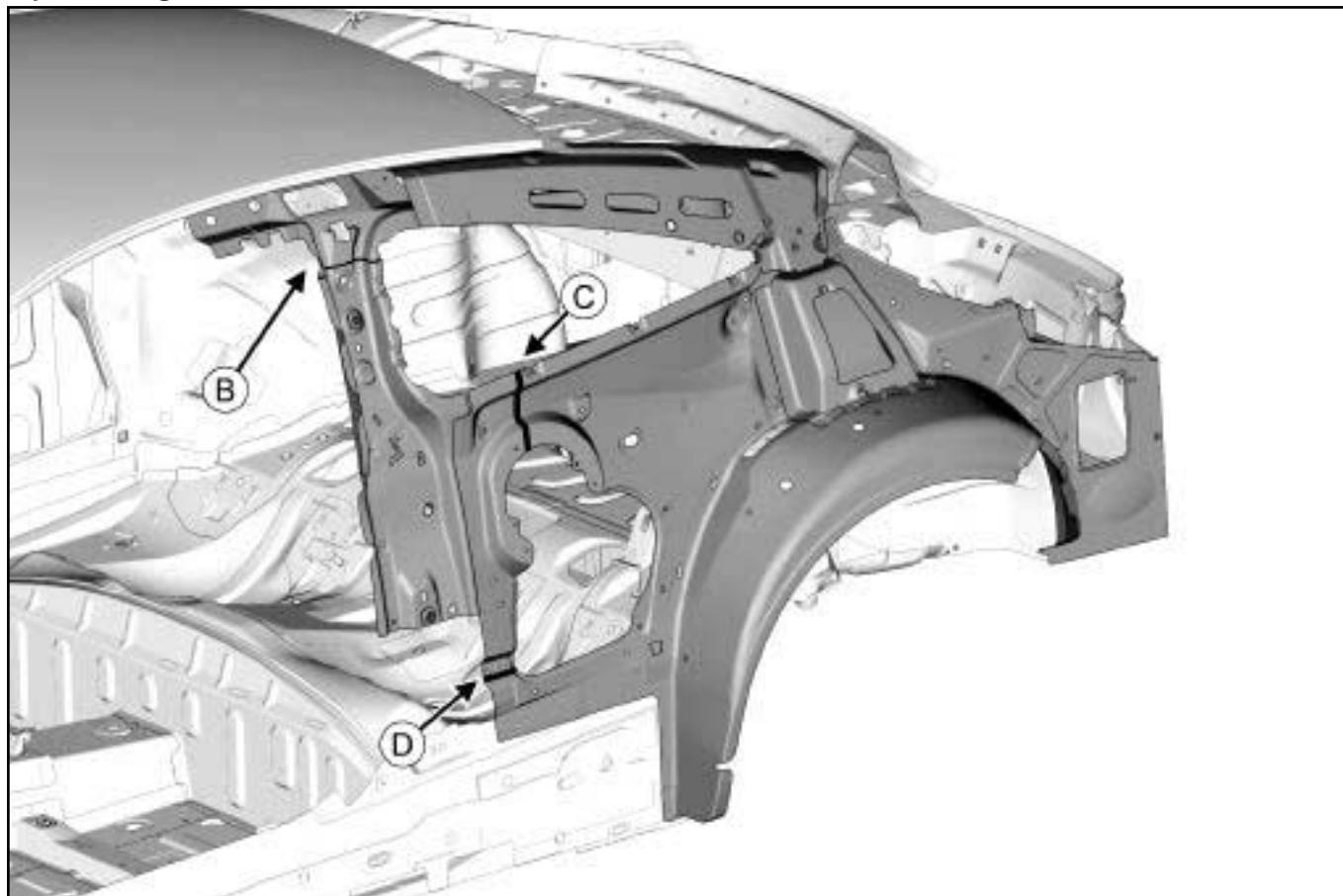
2 - Replacement of front section, B-pillar lining

WARNING

Respect the position of this cut which has been determined in accordance with the position of the inner stiffeners or acoustic inserts, in order to prevent damaging the parts (inner stiffener and/or acoustic insert).

D91

B-pillar lining



134802

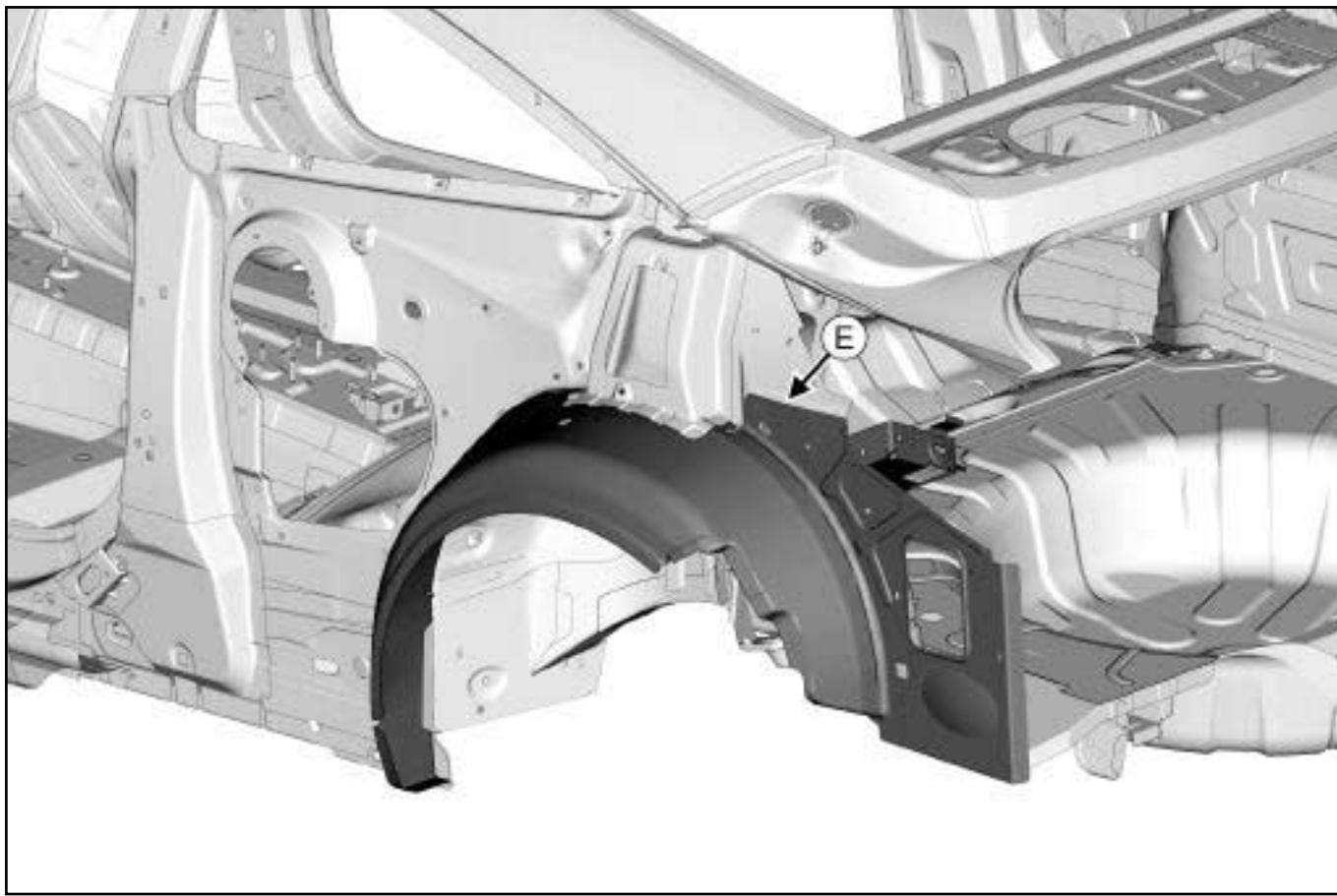
3 - Replacement of rear section, wheel arch extension

WARNING

Respect the position of this cut which has been determined in accordance with the position of the inner stiffeners or acoustic inserts, in order to prevent damaging the parts (inner stiffener and/or acoustic insert).

D91

Wheel arch extension



134799

4 - Complete replacement without roof

WARNING

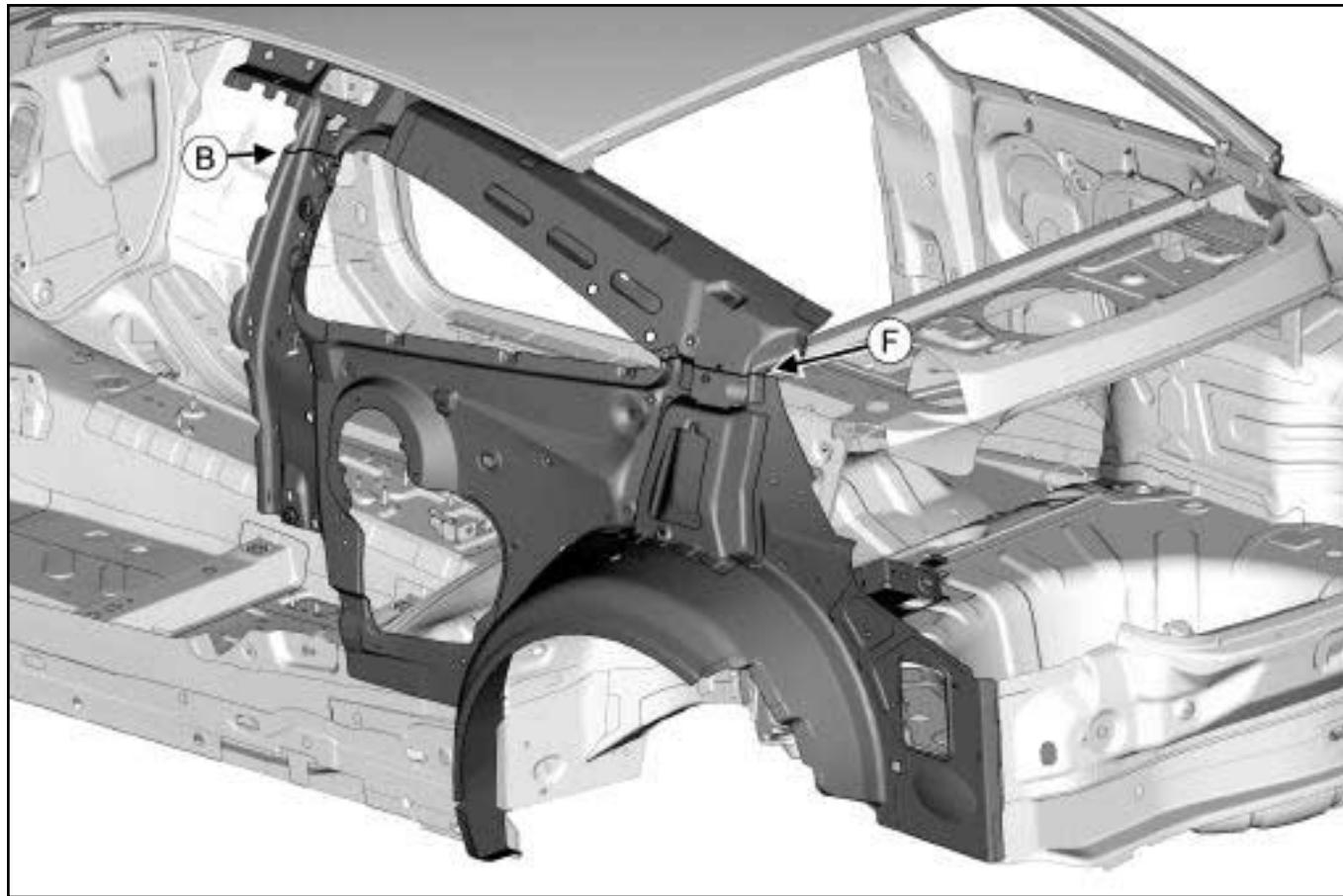
Respect the position of this cut which has been determined in accordance with the position of the inner stiffeners or acoustic inserts, in order to prevent damaging the parts (inner stiffener and/or acoustic insert).

REAR UPPER STRUCTURE
Quarter panel lining: Description

44A

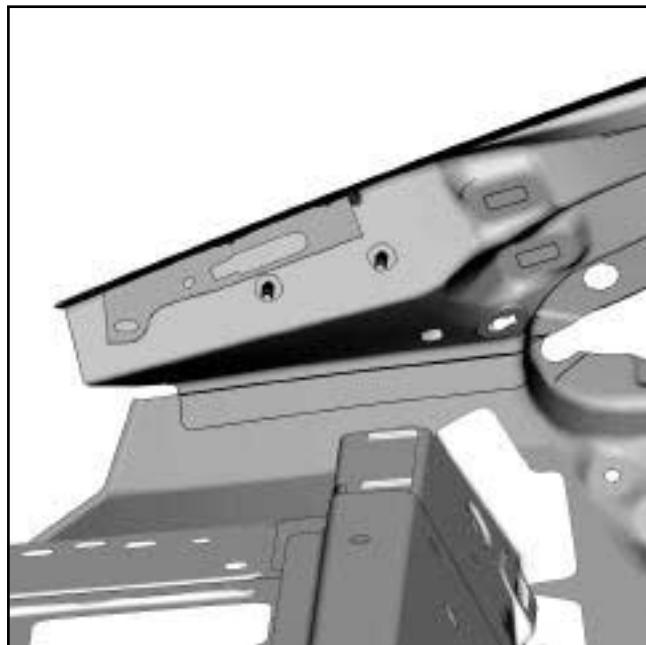
D91

Complete without roof



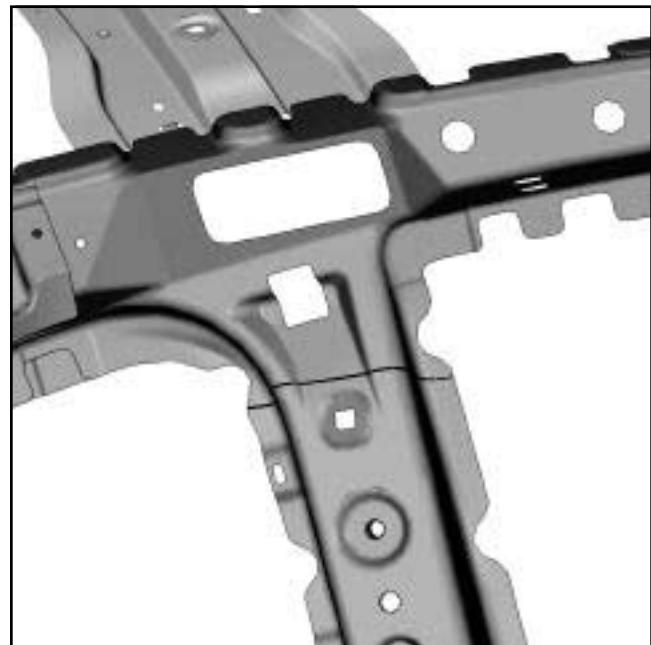
134801

Section F



134806

Section B



134807

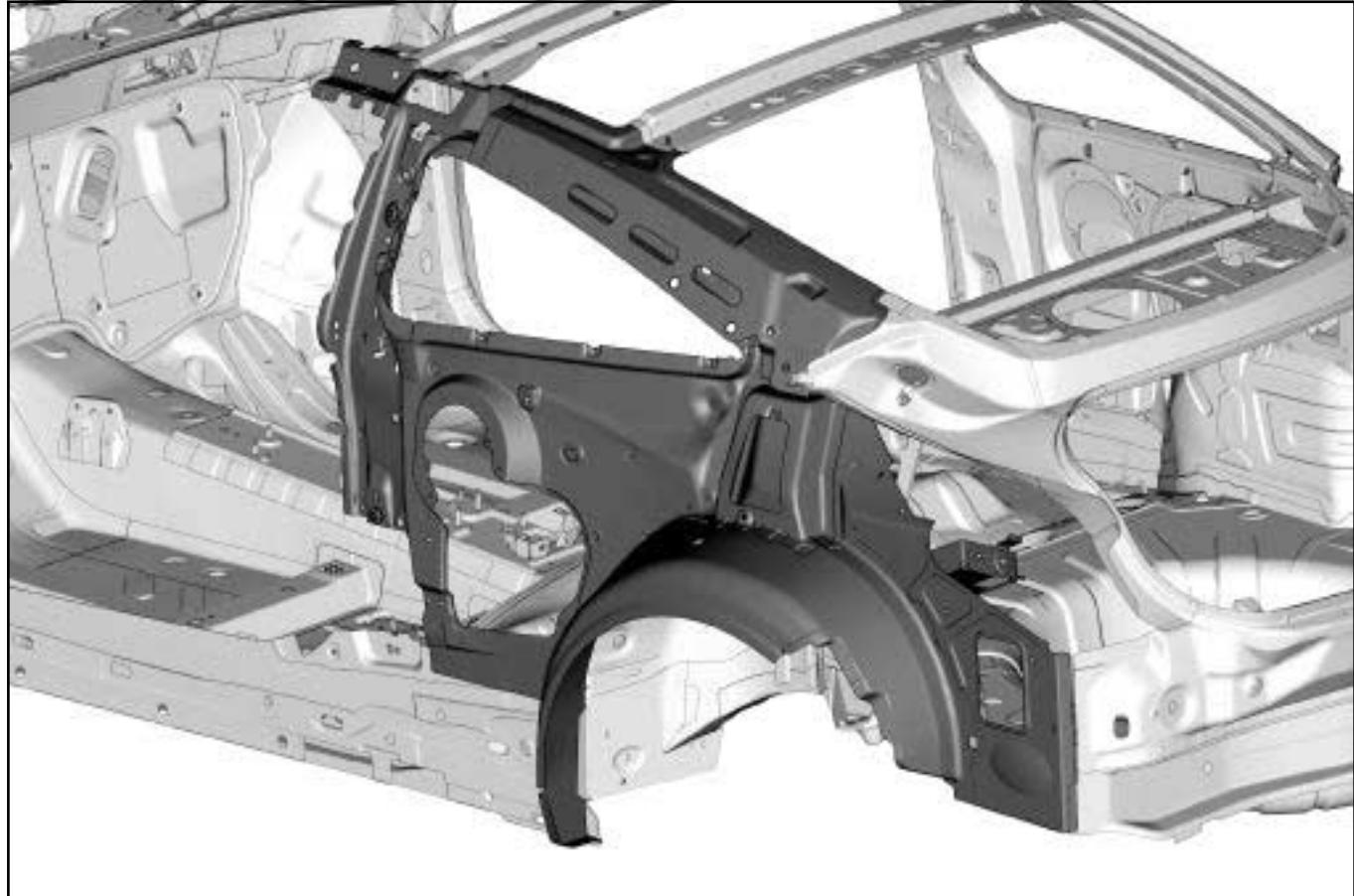
REAR UPPER STRUCTURE
Quarter panel lining: Description

44A

D91

5 - Complete replacement |

Complete with roof



134798

Note:

To preserve the mechanical specifications when making a partial replacement, respect the positioning of the cuts.

B91 or K91

Note:

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

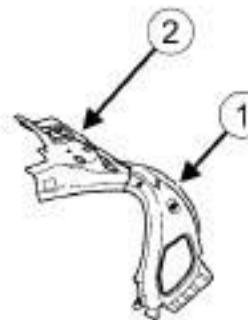
Before reading this general information, check that there are no special notes associated with this vehicle. These special notes will be specified if applicable in other parts of this subsection dealing with the part.

Note:

For a detailed description of a particular connection, see **MR 400**.

DESIGN OF THE STRUCTURAL COMPONENT

B91



124597

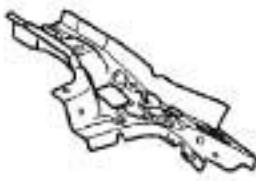
124597

This part serves as both quarter panel reinforcement (1) and corner reinforcement (2).

It can be replaced partially to avoid removing the roof, for this it is necessary to unclip the corner reinforcement (2).

The complete replacement of this part is in addition to the replacement of the roof.

K91



124591

124591

This is a basic part; it serves as the quarter panel reinforcement.

B91



124587

124597

There is only one way of replacing this part:

- partial replacement of lower section.

I - COMPOSITION OF THE SPARE PART



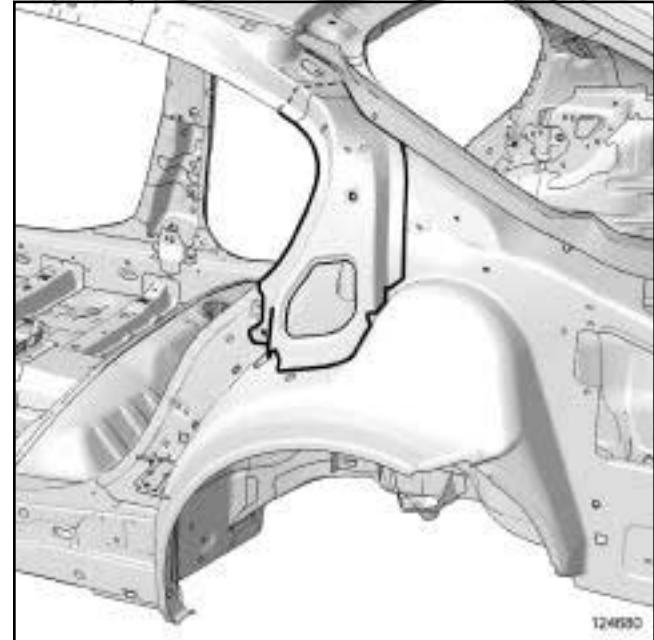
124679

124679

No.	Description	Type	Thickness (mm)
(1)	Quarter panel lower section stiffener	Mild steel	0.9
(2)	Quarter panel upper section stiffener	Mild steel	0.9

II - PART IN POSITION

Partial replacement of lower section



124680

124680

Note:

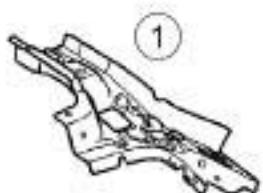
For a detailed description of welded connections, see **MR 400**.

K91

There is only one way of replacing this part:

- complete replacement.

I - COMPOSITION OF THE SPARE PART



124581

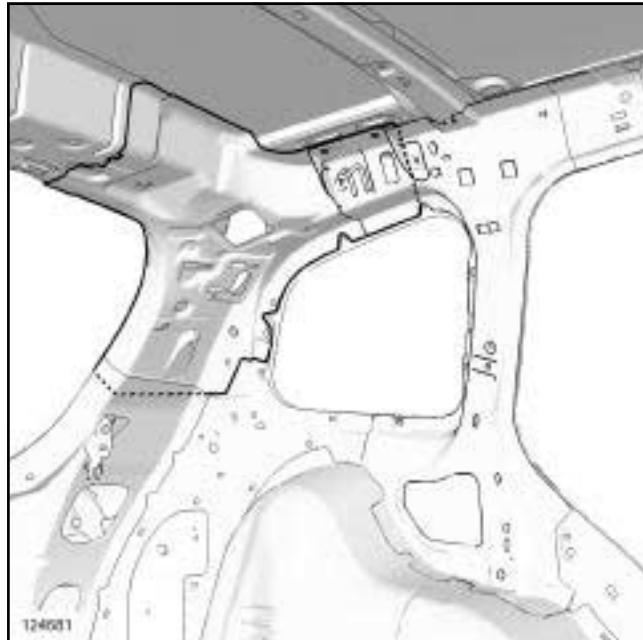
124591

Note:

For a detailed description of welded connections,
see **MR 400**.

No.	Description	Type	Thick-ness (mm)
(1)	Quarter panel reinforcement	Mild steel	1.5

II - PART IN POSITION



124681

REAR UPPER STRUCTURE

Rear parcel shelf: Description

44A

D91

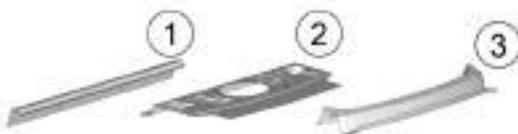


134719

There is only one way of replacing this part:

- complete replacement

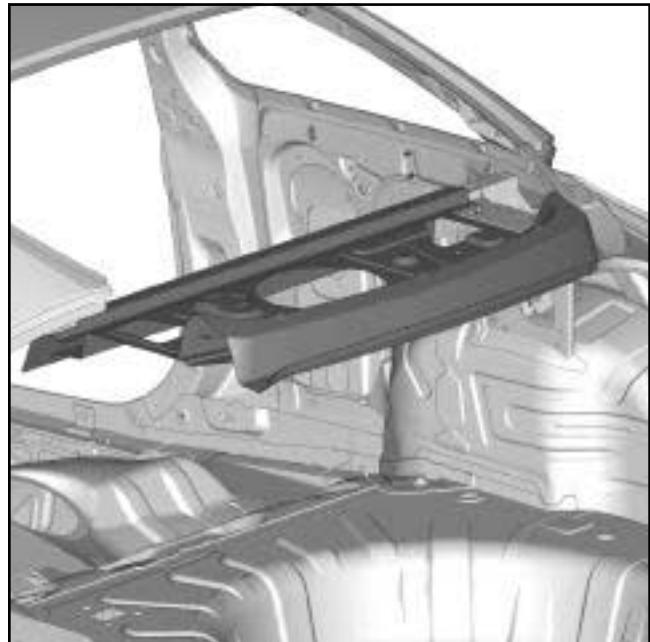
I - COMPOSITION OF THE SPARE PART



134720

No.	Description	Type	Thickness (mm)
(1)	Centre cross member	Mild steel	0.65
(2)	Rear parcel shelf centre cross member	Mild steel	0.75
(3)	Rear screen lower cross member	Mild steel	0.65

II - PART FITTED



134721

WARNING

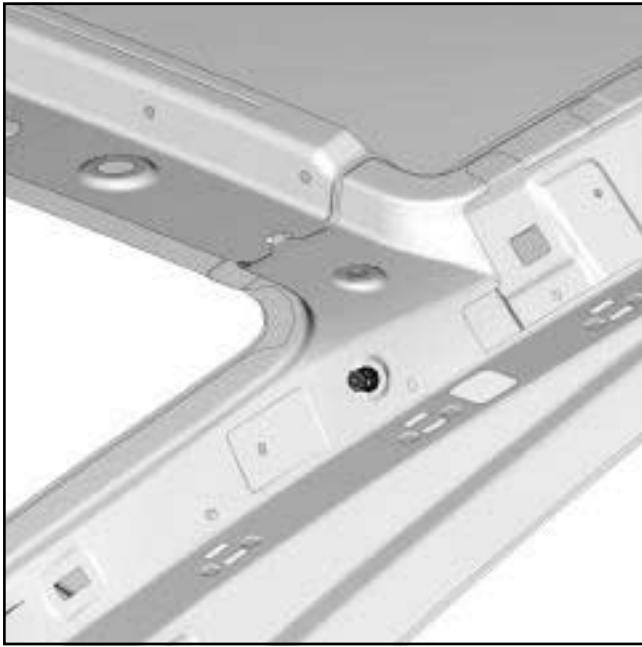
If the mating faces of the parts to be welded are not accessible, make EGW plug welds to replace the original resistance welds (see **MR 400**).

REAR UPPER STRUCTURE
Rear parcel shelf: Description

44A

D91

**III - POSITIONING OF LOCAL ELECTRICAL
EARTHS**



134812

B91 or D91

Note:

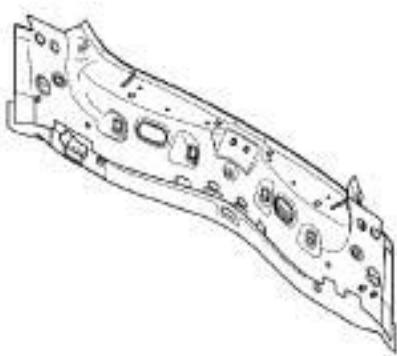
The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading this general information, check that there are no special notes associated with this vehicle. These special notes will be specified if applicable in other parts of this subsection dealing with the part.

Note:

For a detailed description of a particular connection, see **MR 400**.

DESIGN OF THE STRUCTURAL COMPONENT



122754

122754

This part is an assembled component; it functions both as the rear end panel and rear end cross member.

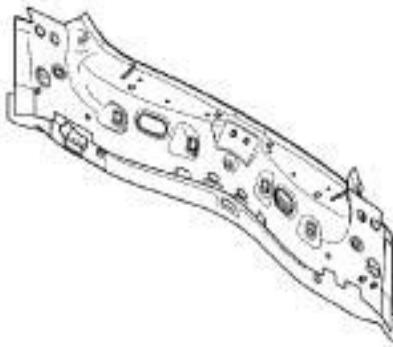
It can only be replaced as a complete unit.

B91

There is only one way of replacing this part:

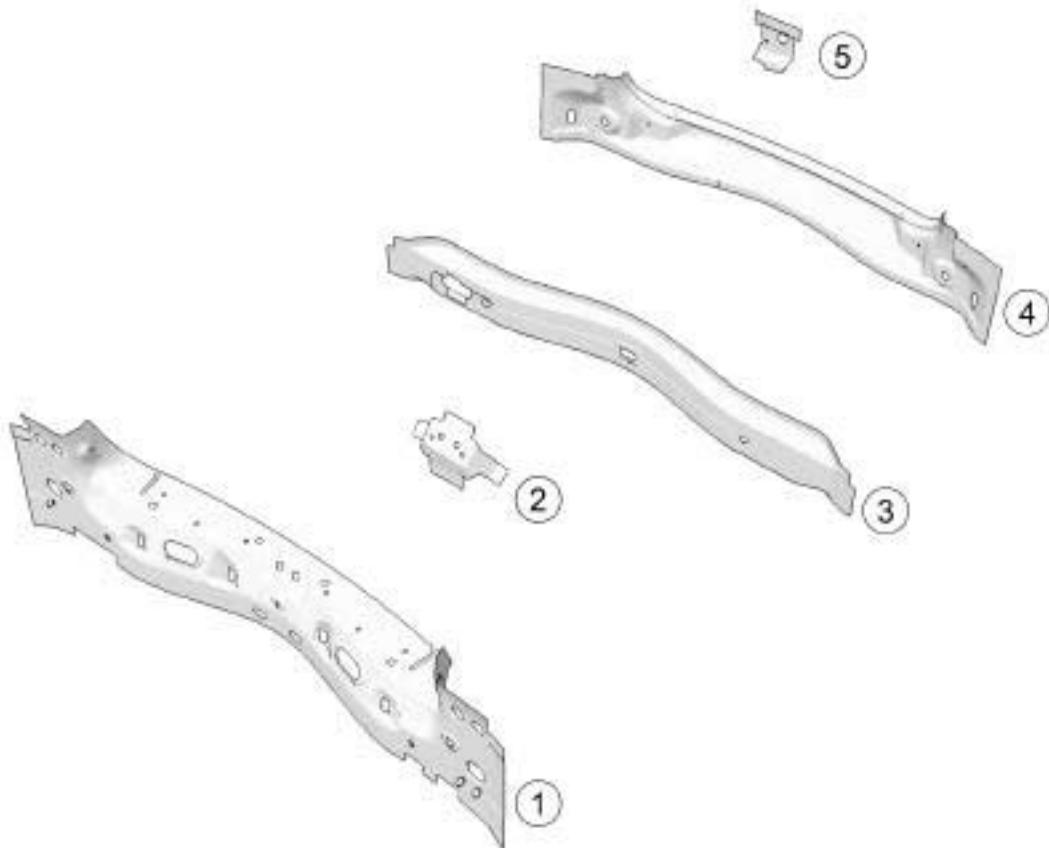
- complete replacement.

I - COMPOSITION OF THE SPARE PART



122754

122754



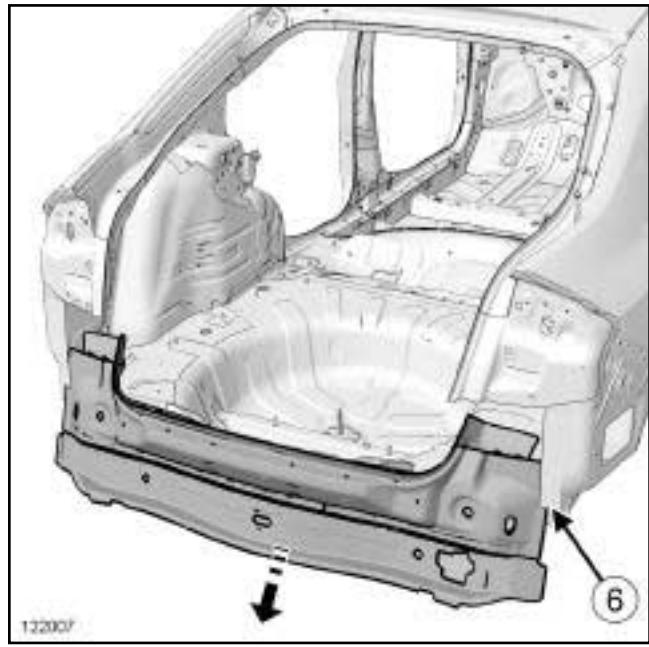
122003

122003

B91

Special notes during removal

No.	Description	Type	Thick-ness (mm)
(1)	Rear end panel lining	HEL	1
(2)	Boot lid striker panel mounting	Mild steel	1.2
(3)	Rear end panel cross member	HEL	1
(4)	Rear end panel	Mild steel	0.7
(5)	Rear end cross member exterior flange	Mild steel	2



122007

II - PART IN POSITION

Complete replacement



122005

When removing the rear end panel assembly, gently lift the corners (6) of the right and left-hand rear wing panels to ease removal.

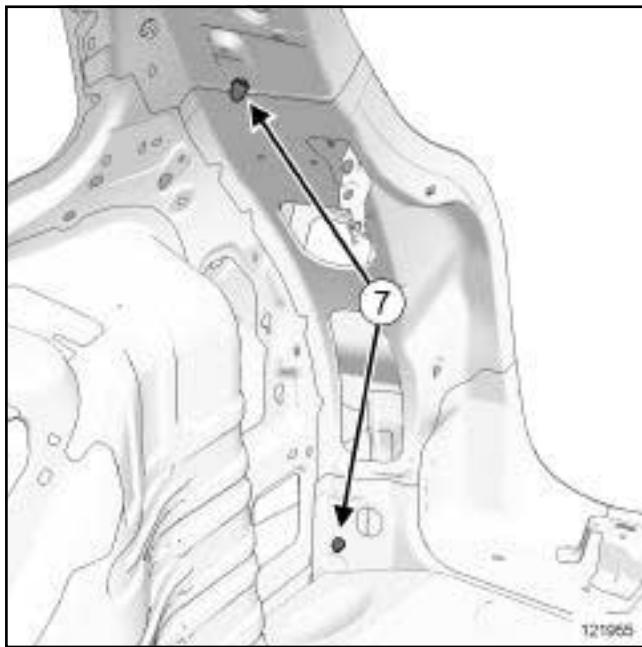
WARNING

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**).

Note:

For a detailed description of a particular connection, see **MR 400**.

B91

III - POSITIONING OF LOCAL ELECTRICAL EARTHS

121955

121955

IMPORTANT

To avoid damaging the vehicle's electric and electronic components, the battery and the earths of any wiring harness near the weld area must be disconnected.

The earth of the welding machine must be placed as close as possible to the weld area.

K91

Note:

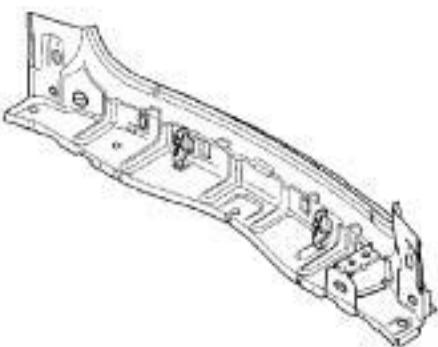
The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400**.

DESIGN OF THE STRUCTURAL COMPONENT



122753

122753

This part is of an elementary type, and serves only as the rear end panel.

If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400**).

REAR UPPER STRUCTURE

Rear end panel: Description

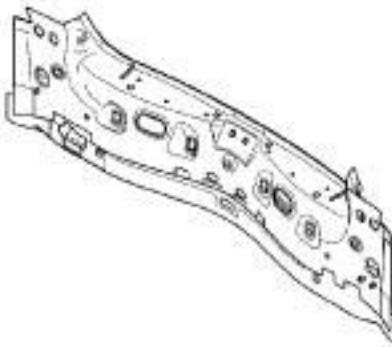
44A

B91 or D91

There is only one way of replacing this part:

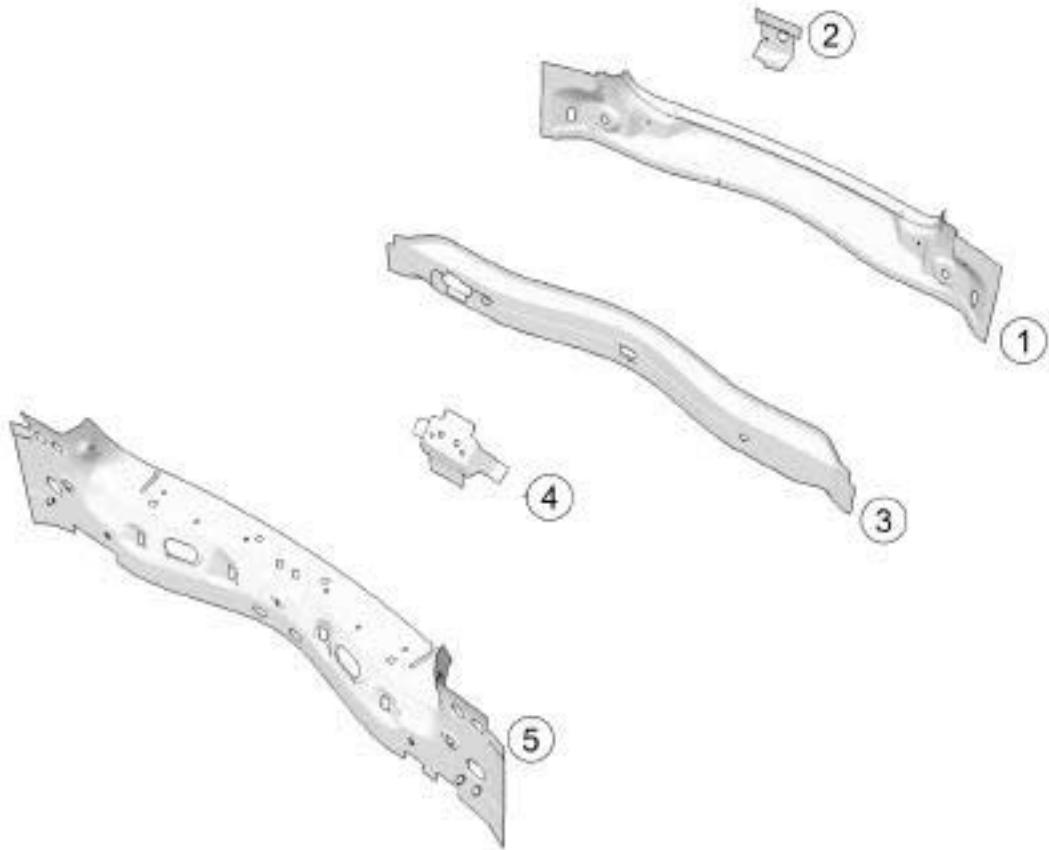
- complete replacement.

I - COMPOSITION OF THE SPARE PART



122754

122754



122003

122003

REAR UPPER STRUCTURE

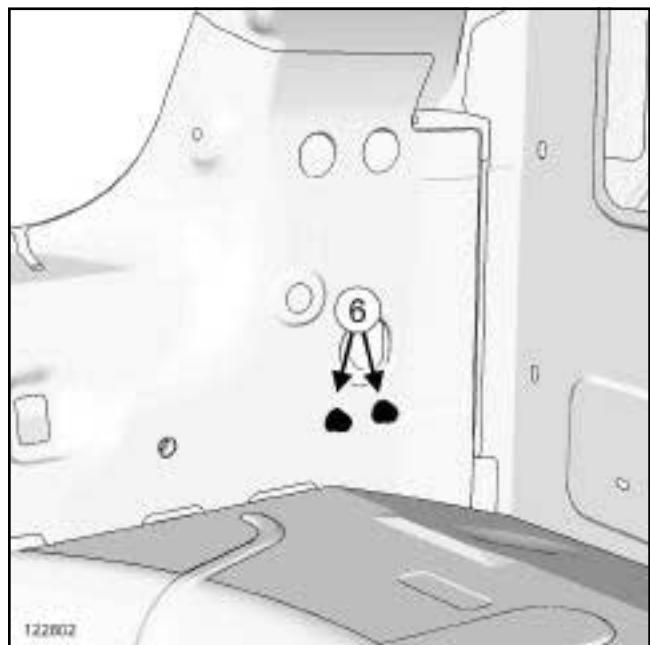
Rear end panel: Description

44A

B91 or D91

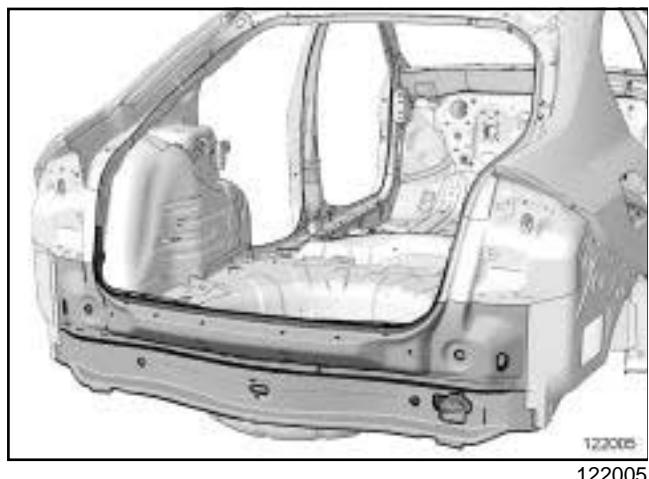
No.	Description	Type	Thick-ness (mm)
(1)	Rear end panel	HLE	1
(2)	Rear end panel lower cross member closure panel	Mild steel	0.7
(3)	Rear end panel lower cross member	HLE	1
(4)	Striker plate support	Mild steel	1.2
(5)	Rear end panel lining	HLE	1

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



122802

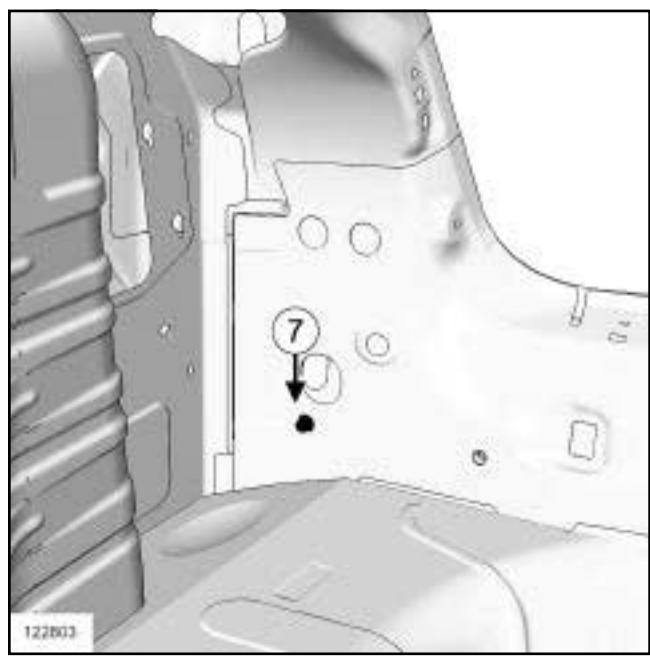
II - PART IN POSITION



122005

WARNING

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**).



122803

IMPORTANT

To avoid damaging the vehicle's electric and electronic components, the battery and the earths of any wiring harness near the weld area must be disconnected.

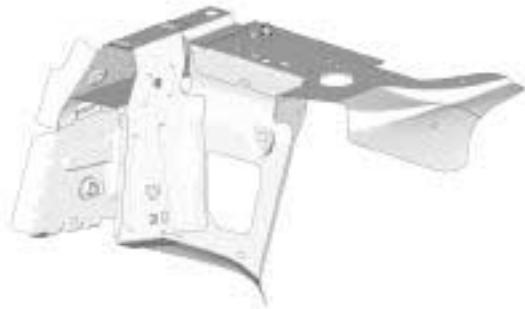
Position the welding machine earth as close as possible to the weld zone (see **MR 400**).

REAR UPPER STRUCTURE

Rear parcel shelf mounting: General description

44A

D91

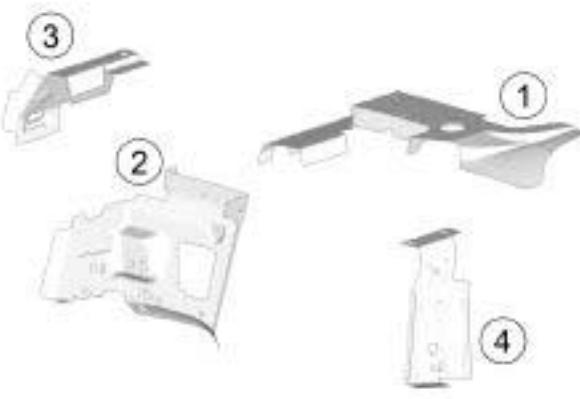


134744

There is only one way of replacing this part:

- complete replacement.

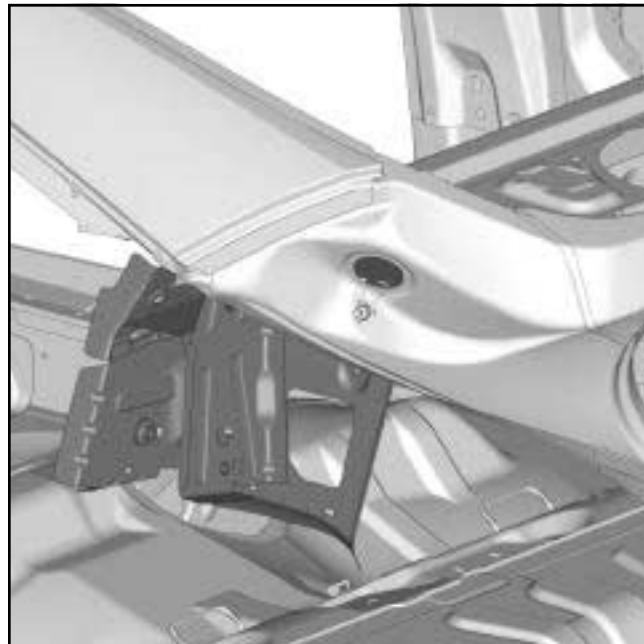
I - COMPOSITION OF THE SPARE PART



134743

No.	Description	Type	Thickness (mm)
(1)	Rear side parcel shelf	Mild steel	1.2
(2)	Rear inertia reel mounting reinforcement	Mild steel	1.5
(3)	Rear seat belt shoulder harness reinforcement	Mild steel	1.2
(4)	Rear seat belt inertia reel lower pretensioner anchor support	Mild steel	1.5

II - PART FITTED



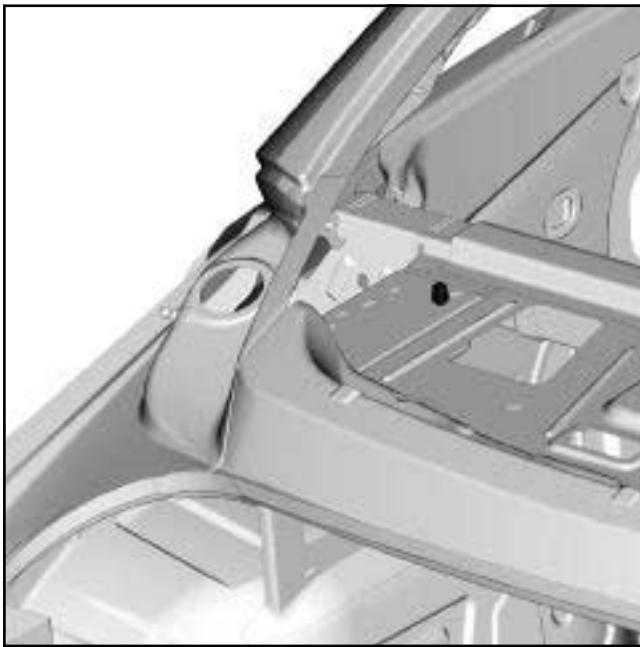
134745

WARNING

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).

D91

III - POSITION OF LOCAL ELECTRICAL EARTHS



134819

WARNING

To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

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

Note:

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400**.

DESIGN OF THE STRUCTURAL COMPONENT



122790

122790

This is a basic part; its only function is that of a roof.

A special feature of the roof is that it is laser welded to the sides of the body by transparent welding.

For vehicles fitted with a sunroof, the roof only has a front section and a rear section.

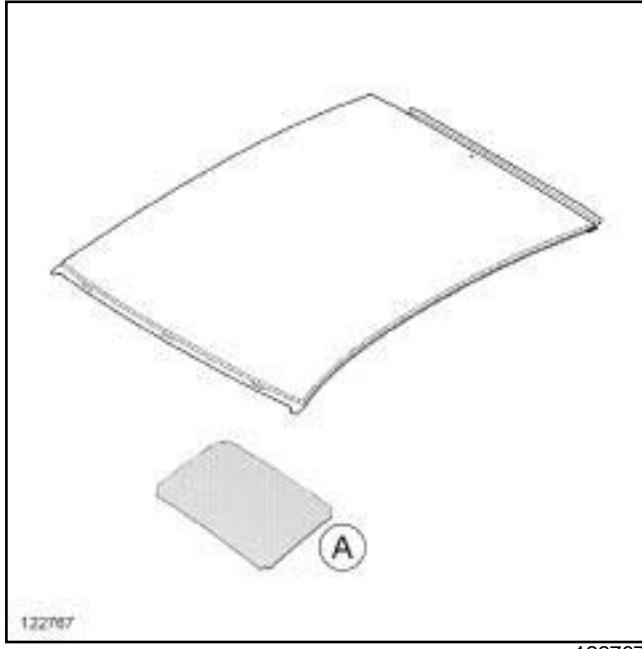
If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400**).

TOP OF BODY

Roof: Description

45A

Special tooling required	
Car. 1816	Roof positioning shims
Equipment required	
safety strap(s)	

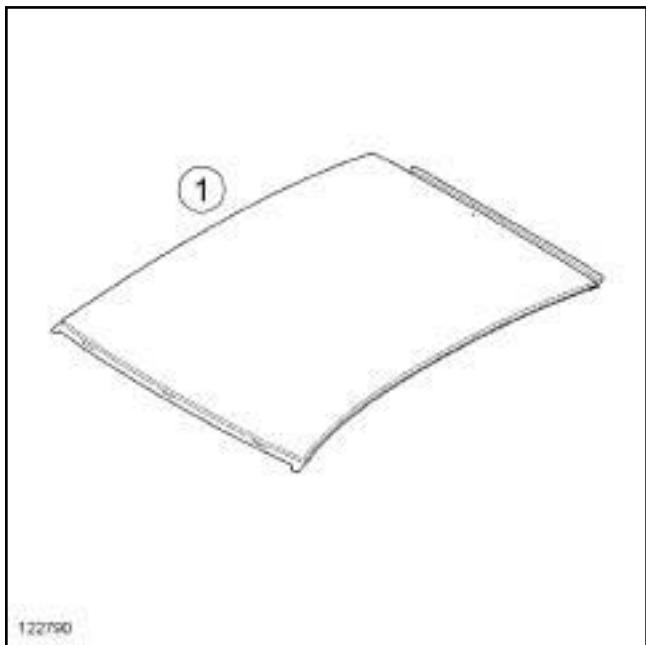


To replace this part, order the roof soundproofing as well (A).

There is only one way of replacing this part:

- complete replacement.

I - COMPOSITION OF THE SPARE PART



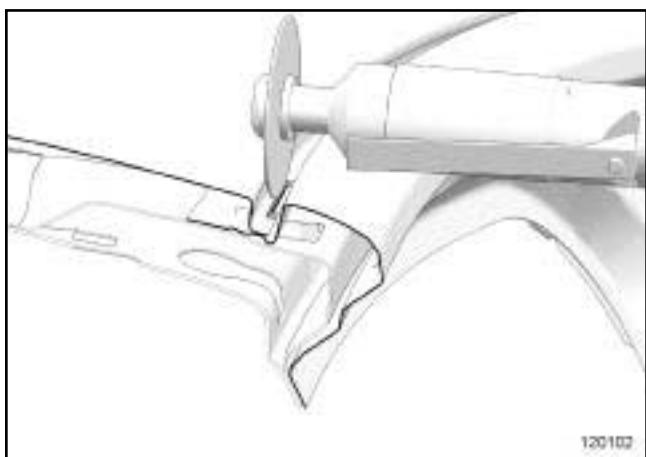
122790

No.	Description	Type	Thickness
(1)	Roof	Mild steel	0.7

II - PART IN POSITION

1 - Dismantling

a - Cutting



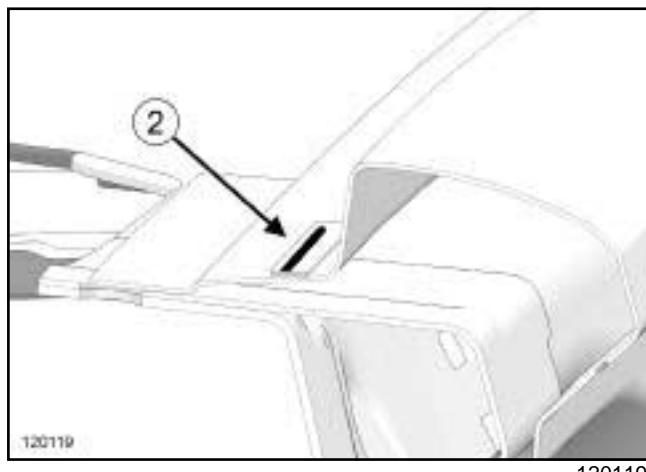
120102

120102

Cut the part around each laser bead (see **MR 400**).

Remove the damaged part.

b - Grinding



Level off the tabs (2) remaining on the vehicle using an orbital sander fitted with a flap disc (see **MR 400**).

2 - Preparation before assembly

a - Preparation and adjustment

Position the spare part, adjust it and fit it using a vice (see **MR 400**).

If necessary, refit the surrounding components and check the panel gaps.

b - Marking and identifying the joints

Mark its optimum position using masking tape between the replacement part and the vehicle.

Remove the replacement part.

c - Preparing the mating faces on the spare part

Gently sand the internal mating faces of the spare part bonding zones with P320 dry sand paper or with a red abrasive pad without removing the protection.

Prepare the remaining mating faces according to the connection method.

d - Preparing the mating faces on the vehicle

Gently sand the internal mating faces at the bonding zones on the vehicle with P320 dry sand paper or with a red abrasive pad without removing the galvanised protection.

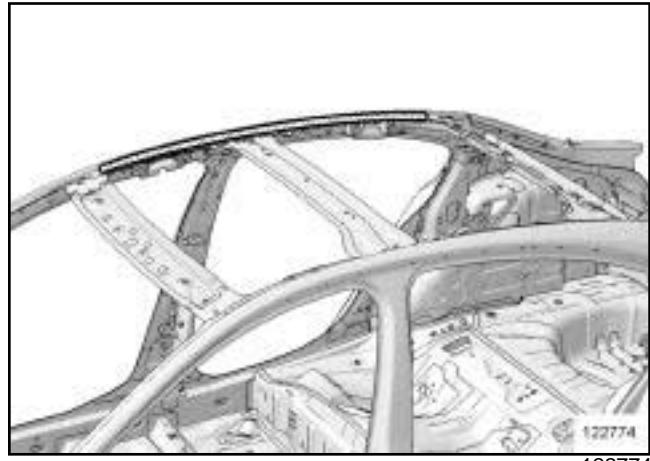
Prepare the remaining mating faces according to the connection method.

e - Apply the protection before assembly

Apply anti-corrosion protection to the welded mating faces on the spare part and the vehicle before assembly (see **MR 400**).

3 - Assembly

a - Application of the bonding products



Degrease the bonding zones on the replacement part and the vehicle using heptane.

On the vehicle, apply a **4 mm** diameter bead of **HIGH PERFORMANCE STRUCTURAL ADHESIVE** (see **Vehicle: Parts and consumables for the repair**) along the entire length of the side bonding zones and a bead of **BLACK MJPRO** to the roof cross members (see **Vehicle: Parts and consumables for the repair**).

b - Fitting and adjusting the replaced parts



Position the replacement part on the vehicle.

Position the four positioning shims (**Car. 1816**) into the grooves at the front and rear of the roof.

TOP OF BODY

Roof: Description

45A

Observe the dimension (X1) = **12.4 mm** between the roof and the body side.

Hold the spare part with a vice at the four corners of the roof and with safety straps positioned on the shims, passing the straps through the door windows **safety strap(s)** to position it in accordance with the markings made previously (see **MR 400**).

c - Making the other joints

Make the rest of the replacement part joints.

4 - Finishing after assembly

Apply a **BLACK MJ PRO** finishing seal (see **Vehicle: Parts and consumables for the repair**) (MR 415, 04B, Consumables - Products) to the side bonding zones.

There is only one way of replacing this part:

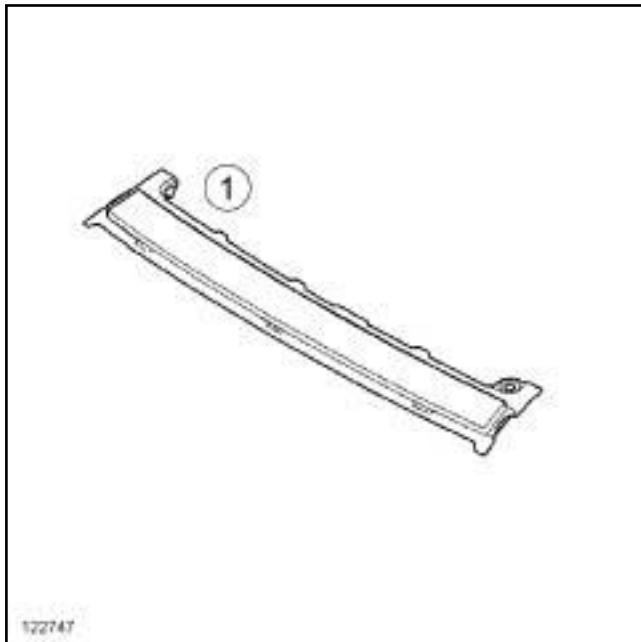
- complete replacement.

This operation only affects versions fitted with a sun-roof.

Note:

For a detailed description of the welded connections, see **MR 400**.

I - COMPOSITION OF THE SPARE PART



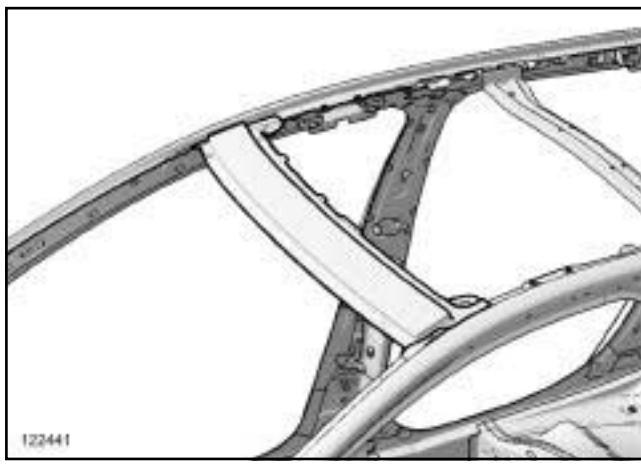
122747

122747

No.	Description	Type	Thickness (mm)
(1)	Front section of roof	Mild steel	0.7

II - PART IN POSITION

Complete replacement



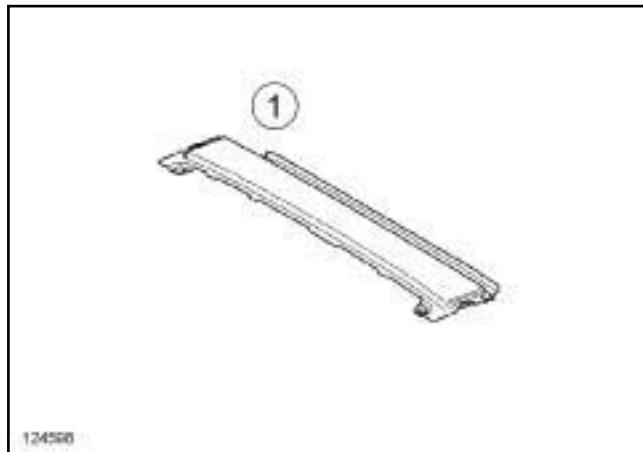
122441

122441

There is only one way of replacing this part:

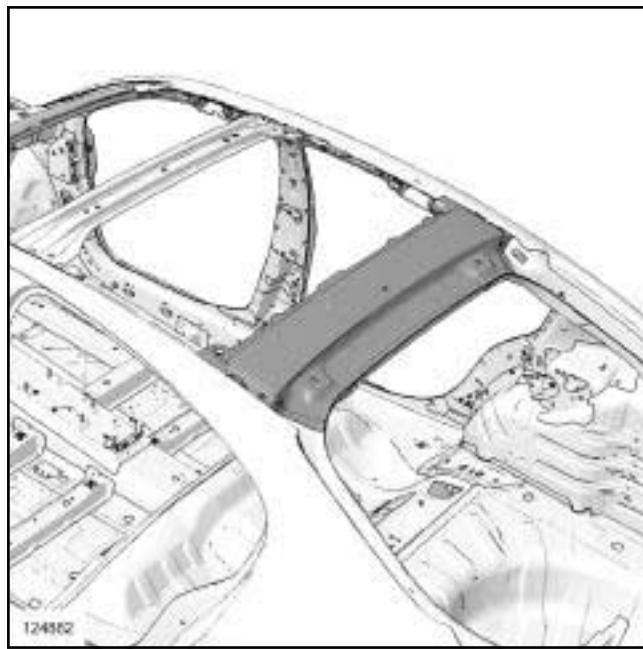
- complete replacement.

I - COMPOSITION OF THE SPARE PART



No.	Description	Type	Thickness (mm)
(1)	Roof rear section	Mild steel	0.85

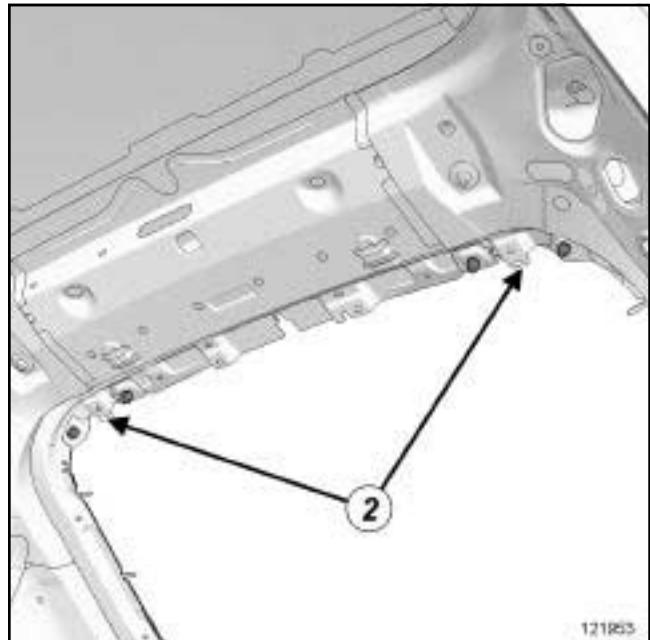
II - PART IN POSITION



Note:

For a detailed description of welded connections,
see **MR 400**.

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



WARNING

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 closely as possible to the weld area (see **MR 400**).

Note:

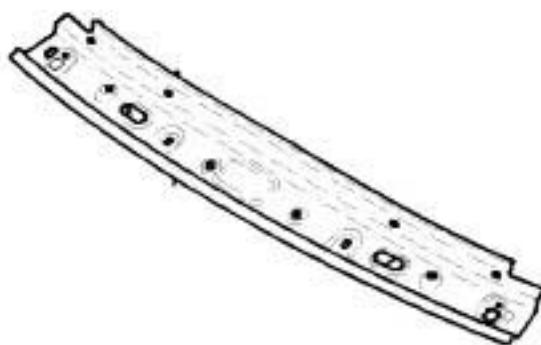
The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

DESIGN OF THE STRUCTURAL COMPONENT

Note:

For a detailed description of a particular connection, see **MR 400**.



110529
110529

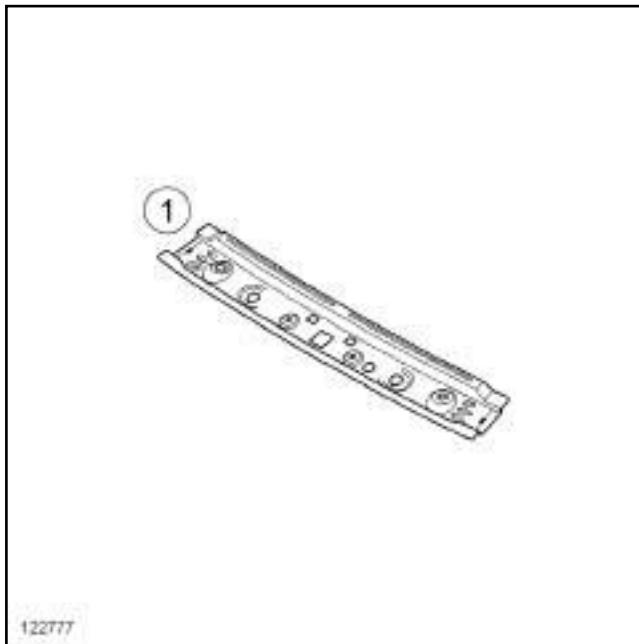
This is a basic part; its only function is that of a roof front cross member and roof stiffener by means of a cemented connection.

For other issues regarding access to mating faces, the various replacement possibilities are described in the basic instructions for structural bodywork repair (see **MR 400**).

There is only one way of replacing this part:

- complete replacement.

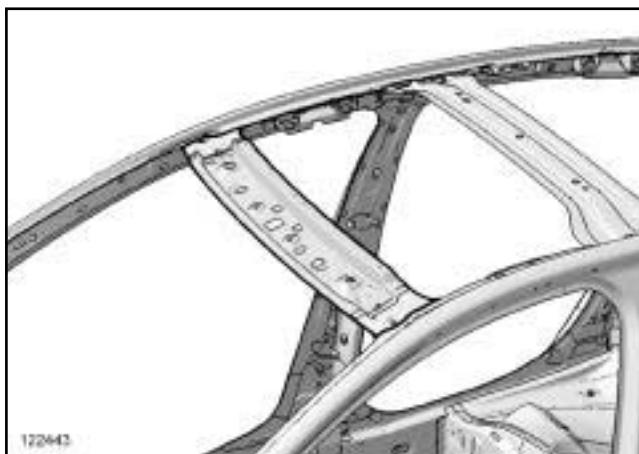
I - COMPOSITION OF THE SPARE PART



122777

No.	Description	Type	Thickness (mm)
(1)	Roof front cross member	Mild steel	0.95

II - PART IN POSITION



122443

Note:

For a detailed description of the welded connections, see **MR 400**.

Note:

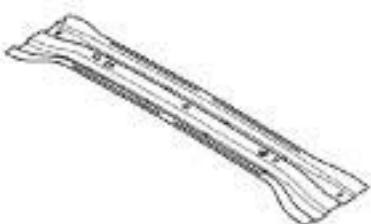
The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400**.

DESIGN OF THE STRUCTURAL COMPONENT



122769

122769

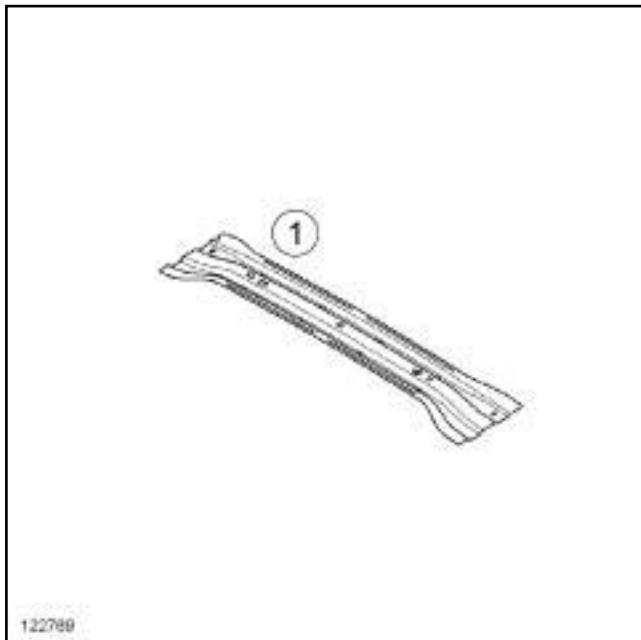
This is a basic part, it only fulfils the function of a roof middle cross member.

If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400**).

There is only one way of replacing this part:

- complete replacement.

I - COMPOSITION OF THE SPARE PART

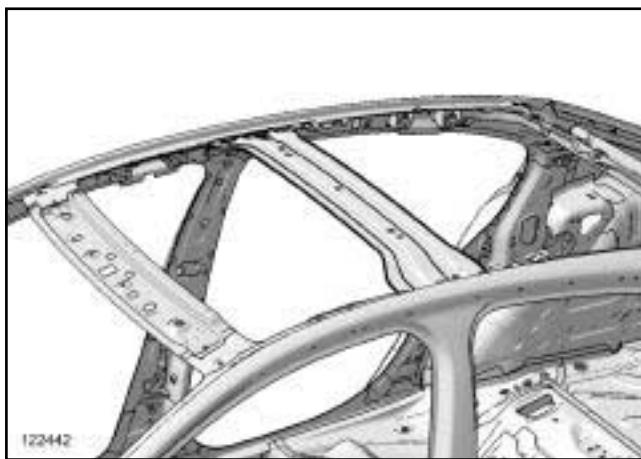


122769

122769

No.	Description	Type	Thickness (mm)
(1)	Roof centre cross member	UHLE	1.3

II - PART IN POSITION



122442

122442

Note:

For a detailed description of the welded connections, see **MR 400**.

K91

Note:

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400**.

DESIGN OF THE STRUCTURAL COMPONENT



122745

122745

This is a basic part, its only function is that of a roof panel arch and replaces the roof middle cross member on models fitted with a sunroof.

TOP OF BODY
Roof panel arch: Description

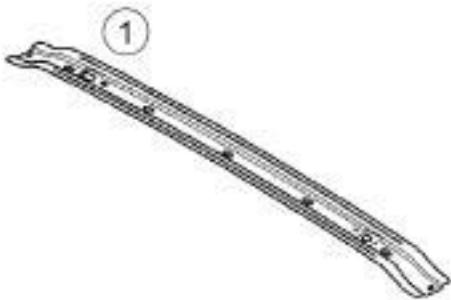
45A

K91

There is only one way of replacing this part:

- complete replacement.

I - COMPOSITION OF THE SPARE PART



122745

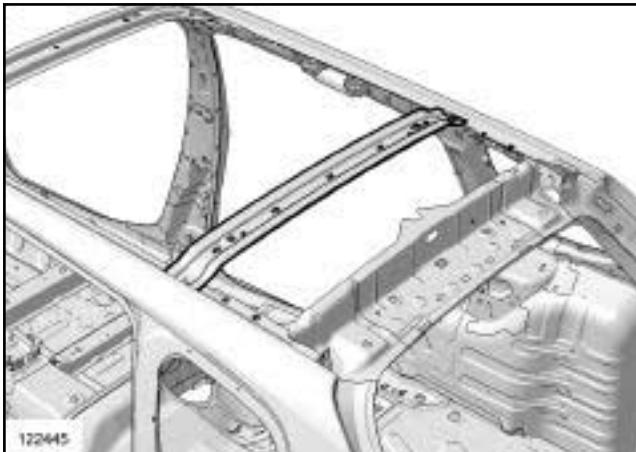
122745

Note:

For a detailed description of the welded connections, see **MR 400**.

No.	Description	Type	Thickness (mm)
(1)	Roof centre cross member	HEL	1

II - PART FITTED



122445

122445

Note:

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400**.

DESIGN OF THE STRUCTURAL COMPONENT



112721

112721

This is a basic part; its only function is that of roof rear cross member as well as roof stiffener by means of a cemented connection.

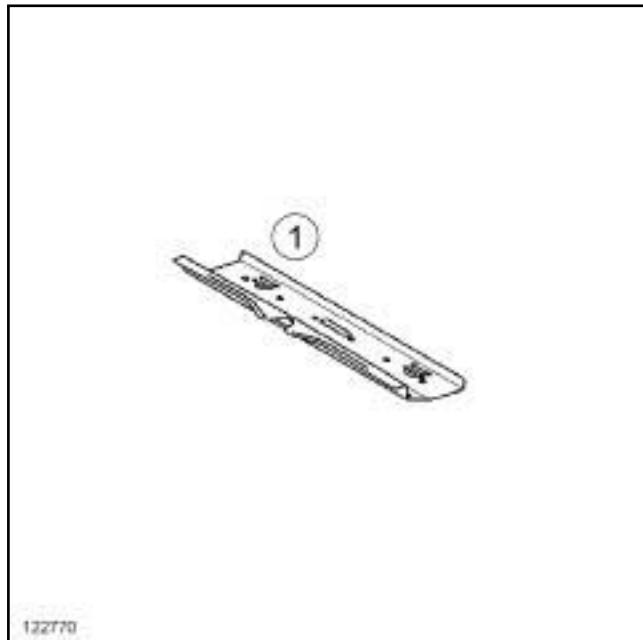
For other issues regarding access to mating faces, the various replacement possibilities are described in the basic instructions for structural bodywork repair (see **MR 400**).

B91 or K91

There is only one way of replacing this part:

- complete replacement.

I - COMPOSITION OF THE SPARE PART



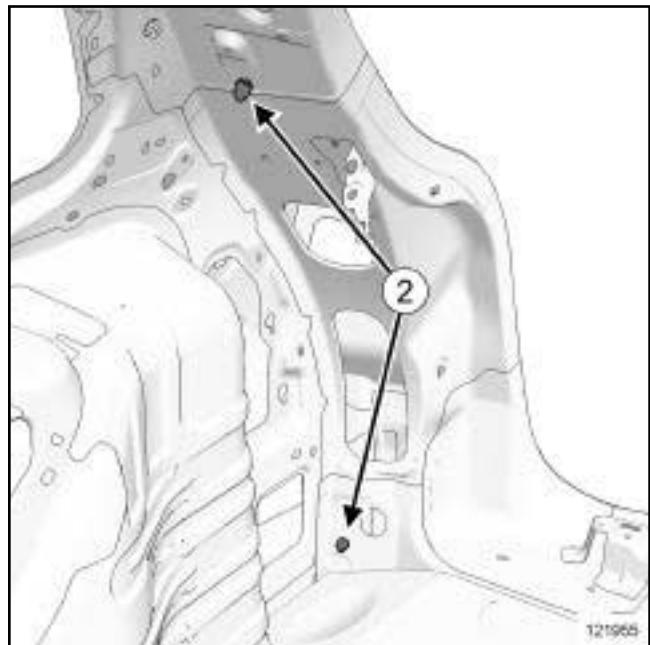
122770

122770

Note:

For a detailed description of the welded connections, see **MR 400**.

III - POSITIONING OF LOCAL ELECTRICAL EARTHS

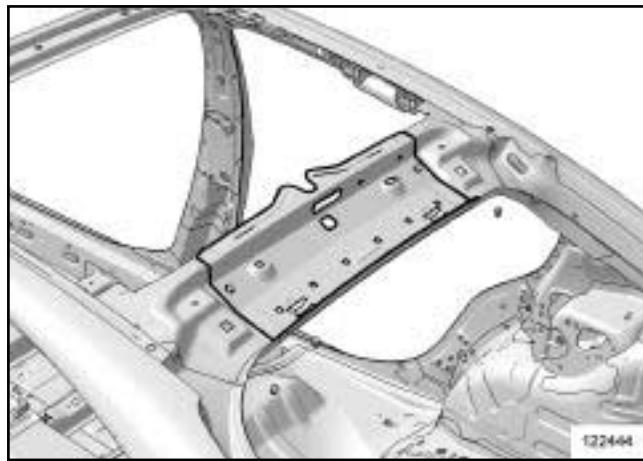


121955

121955

No.	Description	Type	Thickness (mm)
(1)	Roof rear cross member	Mild steel	0.7

II - PART IN POSITION



122444

122444

WARNING

To avoid damaging the vehicle's electrical and electronic components, disconnect the earths of any wiring near the weld area.

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

D91

There is only one way of replacing this part:

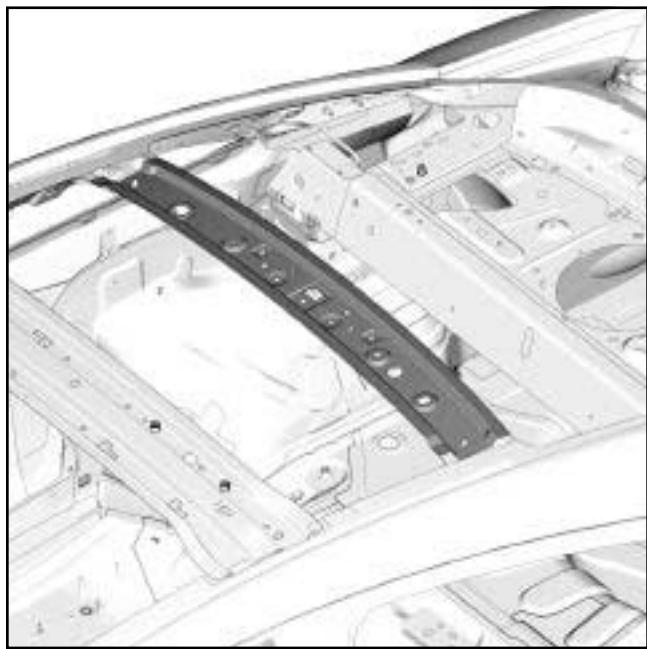
- complete replacement.

I - COMPOSITION OF THE SPARE PART



134712

II - PART FITTED



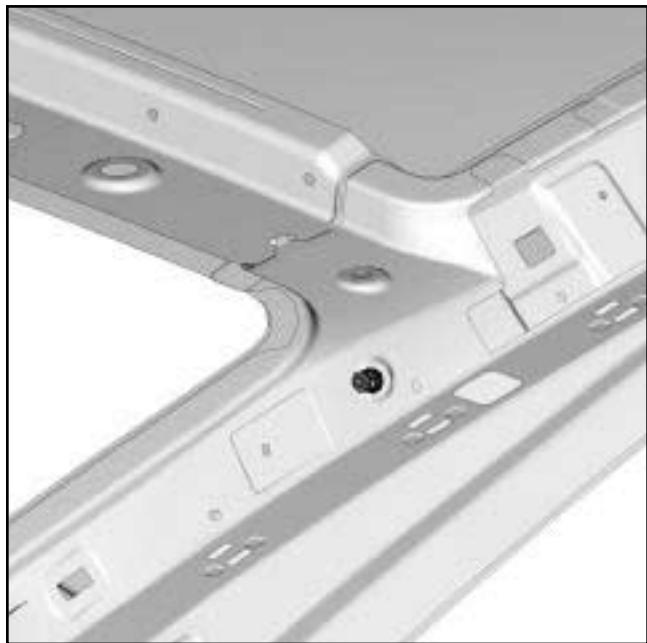
134711

Note:

For a detailed description of welded connections, see **MR 400**.

No.	Description	Type	Thickness (mm)
(1)	Roof rear cross member	Mild steel	1

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



134812

D91

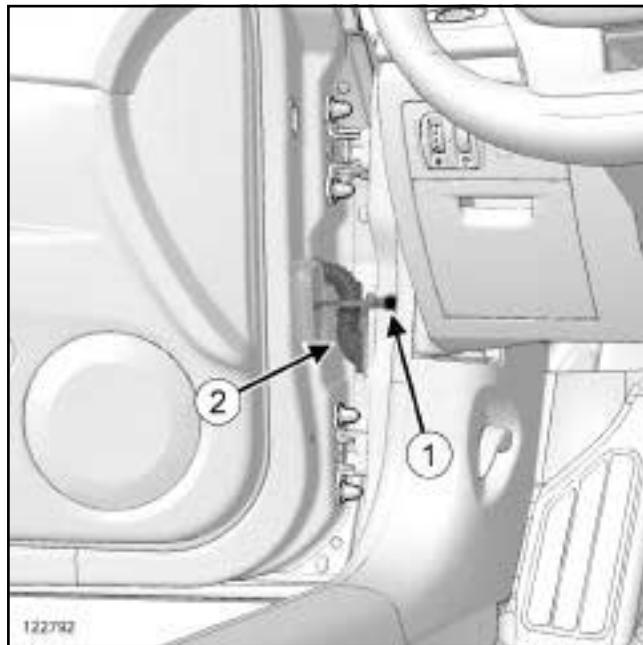
WARNING

To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

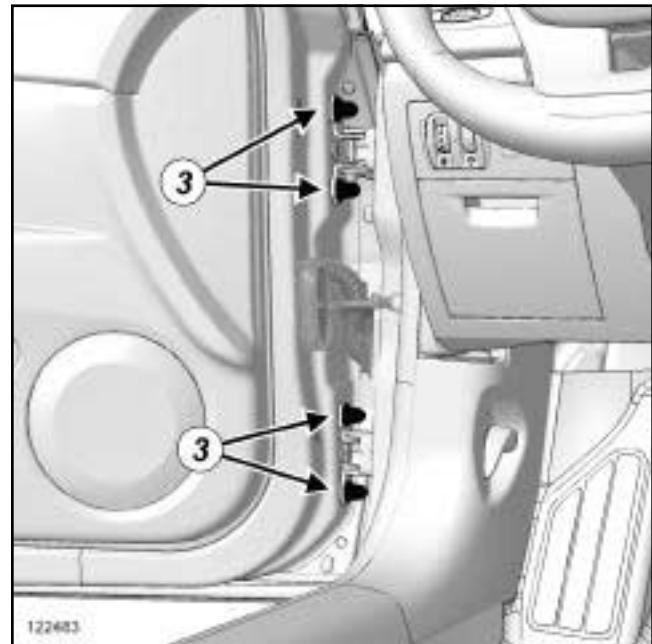
Position the welding machine earth as close as possible to the weld zone see **MR 400**.

I - REMOVAL WITHOUT HINGES**1 - REMOVAL PREPARATION OPERATION**

- Disconnect the battery (see **Battery: Removal - Refitting**) (MR 415, 80A, Battery).



- Remove the front side door check strap bolt (1).
- Disconnect the supply connector from the front side door wiring harness (2).

2 - OPERATION FOR REMOVAL OF PART CONCERNED

- Remove:

- the front side door nuts (3),
- the front side door.

II - REFITTING WITHOUT HINGES**1 - OPERATION FOR REFITTING PART CONCERNED**

-

Note:

When replacing a front side door, order hinge mounting plates in addition.

- Refit:

- the front side door,
- the front side door nuts (3).

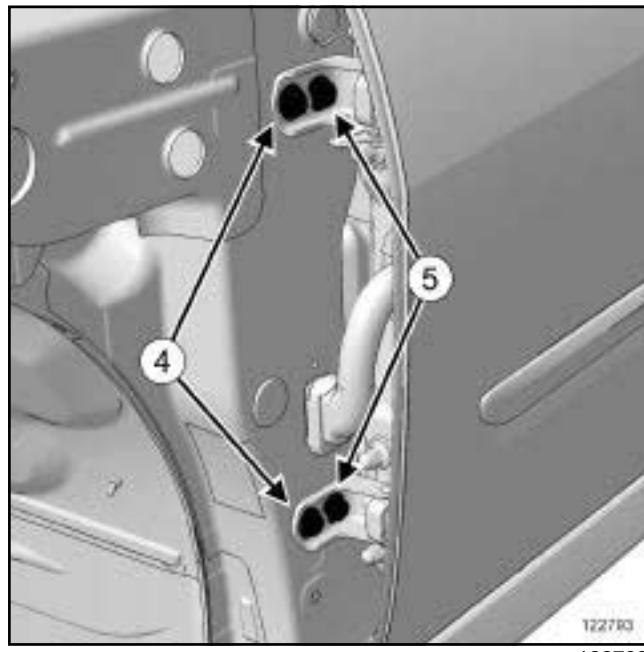
- Adjust the front side door clearances and flush fittings (see **47A, Side opening elements, Front side door: Adjustment**, page 47A-7).

2 - FINAL OPERATION

- Connect the supply connector to the front side door wiring harness (2).
- Refit the front side door check strap bolt (1).
- Connect the battery (see **Battery: Removal - Refitting**) (MR 415, 80A, Battery).

III - REMOVAL WITH HINGES**1 - REMOVAL PREPARATION OPERATION**

- Disconnect the battery (see **Battery: Removal - Refitting**) (MR 415, 80A, Battery).
- Remove the front wing (see **42A, Front upper structure, Front wing: Removal - Refitting**, page **42A-3**).
- Remove the front side door check strap bolt (1).
- Disconnect the supply connector from the front side door wiring harness (2).

2 - OPERATION FOR REMOVAL OF PART CONCERNED

- Remove:
 - the front side door hinge bolts (4),
 - the front side door hinge nuts (5),
 - the front side door.

IV - REFITTING WITH HINGES**1 - OPERATION FOR REFITTING PART CONCERNED**

- Refit:
 - the front side door,
 - the front side door hinge nuts (5),
 - the front side door hinge bolts (4).

- Adjust the front side door clearances and flush fittings (see **47A, Side opening elements, Front side door: Adjustment**, page **47A-7**).

2 - FINAL OPERATION

- Connect the supply connector to the front side door wiring harness.
- Refit the front side door check strap bolt (1).
- Refit the front wing (see **42A, Front upper structure, Front wing: Removal - Refitting**, page **42A-3**).
- Connect the battery (see **Battery: Removal - Refitting**) (MR 415, 80A, Battery).

Equipment required
Diagnostic tool

Note:

The order of the operations described below is specific to the front side door replacement.

The following procedure applies to the front side door on the vehicle.

STRIPPING**I - STRIPPING PREPARATION OPERATION**

Lock the airbag computer. Apply the before repair procedure using the **Diagnostic tool** :

- connect the **Diagnostic tool**,
- select « Airbag computer » ,
- go to repair mode,
- apply the « Before repair procedure » .

Disconnect:

- the battery (see **Battery: Removal - Refitting**) (MR 415, 80A, Battery),
- the supply connector from the front side door wiring harness.

II - STRIPPING OPERATION FOR PART CONCERNED

Remove:

- the front side door trim (see **Front side door trim: Removal - Refitting**) (MR 416, 72A, Side opening elements trim),
- the front side door sealing film (see **Door sealing film: Removal - Refitting**) (MR 416, 65A, Door sealing),
- the door mirror (see **Door mirror: Removal - Refitting**) (MR 416, 56A, Exterior equipment),
- the front side door exterior weatherstrip (see **Front side door exterior weatherstrip: Removal - Refitting**) (MR 416, 66A, Window sealing),
- the front side door moulding (see **Front side door protective strip: Removal - Refitting**) (MR 416, 55A, Exterior protection),

- the front side door frame interior trim (see **Front side door frame interior trim: Removal - Refitting**) (MR 416, 72A, Side opening elements trim),
- the front side door pillar exterior trim (see **Front side door pillar exterior trim: Removal - Refitting**) (MR 416, 56A, Exterior equipment),
- the anti-fouling seal,
- the front side door glass run channel (see **Front side door window run channel: Removal - Refitting**) (MR 416, 66A, Window sealing),
- the window winder motor (see **Electric window motor: Removal - Refitting**) (MR 415, 87D, Electric windows - Sunroof),
- the front side door sliding window (see **Front side door sliding window: Removal - Refitting**) (MR 416, 54A, Windows),
- the front speakers (see **Front speakers: Removal - Refitting**) (MR 415, 86A, Radio),
- the front side door electric window winder mechanism (see **Front side door electric window mechanism: Removal - Refitting**) (MR 416, 51A, Side opening element mechanisms),
- the front side door lock barrel (see **Front side door lock barrel: Removal - Refitting**) (MR 416, 51A, Side opening element mechanisms),
- the front side exterior door handle (see **Exterior door handle: Removal - Refitting**) (MR 416, 51A, Side opening element mechanisms),
- the front side door lock (see **Front side door lock: Removal - Refitting**) (MR 416, 51A, Side opening element mechanisms),
- the front side door check strap (see **Front side door check strap: Removal - Refitting**) (MR 416, 51A, Side opening element mechanisms),
- the side impact sensor (see **Side impact sensor: Removal - Refitting**) (MR 415, 88C, Airbags and pretensioners),
- the driver's or passenger's front side door wiring (see **Driver's front side door wiring: Removal - Refitting**) or (see **Passenger's front side door wiring: Removal - Refitting**) (MR 415, 88A, Wiring).

REBUILDING**I - REBUILDING PREPARATION OPERATION**

Always replace:

- the sealing film,
- the side impact sensor,

- the tyre pressure label,
- the foam pads.

Order a door fitting kit in addition.

II - REBUILDING OPERATION FOR PART CONCERNED

Refit:

- the driver's or passenger's front side door wiring (see **Driver's front side door wiring: Removal - Refitting**) or (see **Passenger's front side door wiring: Removal - Refitting**) (MR 415, 88A, Wiring),
- the side impact sensor (see **Side impact sensor: Removal - Refitting**) (MR 415, 88C, Airbags and pretensioners),
- the front side door check strap (see **Front side door check strap: Removal - Refitting**) (MR 416, 51A, Side opening element mechanisms),
- the front side door lock (see **Front side door lock: Removal - Refitting**) (MR 416, 51A, Side opening element mechanisms),
- the front side exterior door handle (see **Exterior door handle: Removal - Refitting**) (MR 416, 51A, Side opening element mechanisms),
- the front side door lock barrel (see **Front side door lock barrel: Removal - Refitting**) (MR 416, 51A, Side opening element mechanisms),
- the front side door electric window winder mechanism (see **Front side door electric window mechanism: Removal - Refitting**) (MR 416, 51A, Side opening element mechanisms),
- the front speakers (see **Front speakers: Removal - Refitting**) (MR 415, 86A, Radio),
- the front side door sliding window (see **Front side door sliding window: Removal - Refitting**) (MR 416, 54A, Windows),
- the window winder motor (see **Electric window motor: Removal - Refitting**) (MR 415, 87D, Electric windows - Sunroof),
- the front side door glass run channel (see **Front side door window run channel: Removal - Refitting**) (MR 416, 66A, Window sealing),
- the anti-fouling seal,
- the front side door pillar exterior trim (see **Front side door pillar exterior trim: Removal - Refitting**) (MR 416, 56A, Exterior equipment),
- the front side door frame interior trim (see **Front side door frame interior trim: Removal - Refitting**) (MR 416, 72A, Side opening elements trim),

- the front side door moulding (see **Front side door protective strip: Removal - Refitting**) (MR 416, 55A, Exterior protection),
- the front side door exterior weatherstrip (see **Front side door exterior weatherstrip: Removal - Refitting**) (MR 416, 66A, Window sealing),
- the door mirror (see **Door mirror: Removal - Refitting**) (MR 416, 56A, Exterior equipment),
- the front side door sealing film (see **Door sealing film: Removal - Refitting**) (MR 416, 65A, Door sealing),
- the front side door trim (see **Front side door trim: Removal - Refitting**) (MR 416, 72A, Side opening elements trim).

III - FINAL OPERATION.

Connect:

- the supply connector to the front side door wiring harness,
- the battery (see **Battery: Removal - Refitting**) (MR 415, 80A, Battery).

Unlock the airbag computer. Apply the after repair procedure using the **Diagnostic tool** :

- connect the **Diagnostic tool**,
- select « Airbag computer » ,
- go to repair mode,
- apply the « After repair procedure » .

D91

Equipment required

Diagnostic tool

Note:

The order of the operations described below is specific to the front side door replacement.

The following procedure applies to the front side door on the vehicle.

STRIPPING**I - STRIPPING PREPARATION OPERATION**

Lock the airbag computer. Apply the before repair procedure using the **Diagnostic tool** :

- connect the **Diagnostic tool**,
- select « Airbag computer » ,
- go to repair mode,
- apply the « Before repair procedure » .

Disconnect:

- the battery (see **Battery: Removal - Refitting**) (80A, Battery),
- the supply connector for the front side door wiring.

II - STRIPPING OPERATION FOR PART CONCERNED

Remove:

- the front side door trim (see **Front side door trim: Removal - Refitting**) (72A, Side opening element trim),
- the front side door sealing film (see **Door sealing film: Removal - Refitting**) (65A, Door sealing),
- the door mirror (see **Door mirror: Removal - Refitting**) (56A, Exterior equipment),
- the front side door exterior weatherstrip (see **Front side door exterior weatherstrip: Removal - Refitting**) (66A, Window sealing),
- the anti-fouling seal,
- the window motor (see **Electric window motor: Removal - Refitting**) (87D, Electric windows - Sunroof),

- the front side door sliding window (see **Front side door sliding window: Removal - Refitting**) (54A, Windows),

- the front speaker (see **Front speakers: Removal - Refitting**) (86A, Radio),

- the front side door electric window mechanism (see **Front side door electric window mechanism: Removal - Refitting**) (51A, Side opening element mechanisms),

- the front side door lock barrel (see **Front side door lock barrel: Removal - Refitting**) (51A, Side opening element mechanisms),

- the front side exterior door handle (see **Exterior door handle: Removal - Refitting**) (51A, Side opening element mechanisms),

- the front side door lock (see **Front side door lock: Removal - Refitting**) (51A, Side opening element mechanisms),

- the front side door check strap (see **Front side door check strap: Removal - Refitting**) (51A, Side opening element mechanisms),

- the side impact sensor (see **Side impact sensor: Removal - Refitting**) (88C, Airbags and pretensioners),

- the driver's or passenger's front side door wiring (see **Driver's front side door wiring: Removal - Refitting**) or (see **Passenger's front side door wiring: Removal - Refitting**) (88A, Wiring).

REBUILDING**I - REBUILDING PREPARATION OPERATION**

Always replace:

- the sealing film,
- the side impact sensor,
- the tyre pressure label,
- the foam pads.

Order a door fitting fastener kit in addition.

II - REBUILDING OPERATION FOR PART CONCERNED

Refit:

- the driver's or passenger's front side door wiring (see **Driver's front side door wiring: Removal - Refitting**) or (see **Passenger's front side door wiring: Removal - Refitting**) (88A, Wiring),

D91

- the side impact sensor (see **Side impact sensor: Removal - Refitting**) (88C, Airbags and pretensioners),
- the front side door check strap (see **Front side door check strap: Removal - Refitting**) (51A, Side opening element mechanisms),
- the front side door lock (see **Front side door lock: Removal - Refitting**) (51A, Side opening element mechanisms),
- the front side exterior door handle (see **Exterior door handle: Removal - Refitting**) (51A, Side opening element mechanisms),
- the front side door lock barrel (see **Front side door lock barrel: Removal - Refitting**) (51A, Side opening element mechanisms),
- the front side door electric window mechanism (see **Front side door electric window mechanism: Removal - Refitting**) (51A, Side opening element mechanisms),
- the front speaker (see **Front speakers: Removal - Refitting**) (86A, Radio),
- the front side door sliding window (see **Front side door sliding window: Removal - Refitting**) (54A, Windows),
- the window motor (see **Electric window motor: Removal - Refitting**) (87D, Electric windows - Sunroof),
- the anti-fouling seal,
- the front side door exterior weatherstrip (see **Front side door exterior weatherstrip: Removal - Refitting**) (66A, Window sealing).

Adjust the front side door sliding window (see **Side windows: Adjustment**) (54A, Windows).

Refit:

- the door mirror (see **Door mirror: Removal - Refitting**) (56A, Exterior equipment),
- the front side door sealing film (see **Door sealing film: Removal - Refitting**) (65A, Door sealing),
- the front side door trim (see **Front side door trim: Removal - Refitting**) (72A, Side opening element trim).

III - FINAL OPERATION

Connect:

- the supply connector for the front side door wiring,
- the battery (see **Battery: Removal - Refitting**) (80A, Battery).

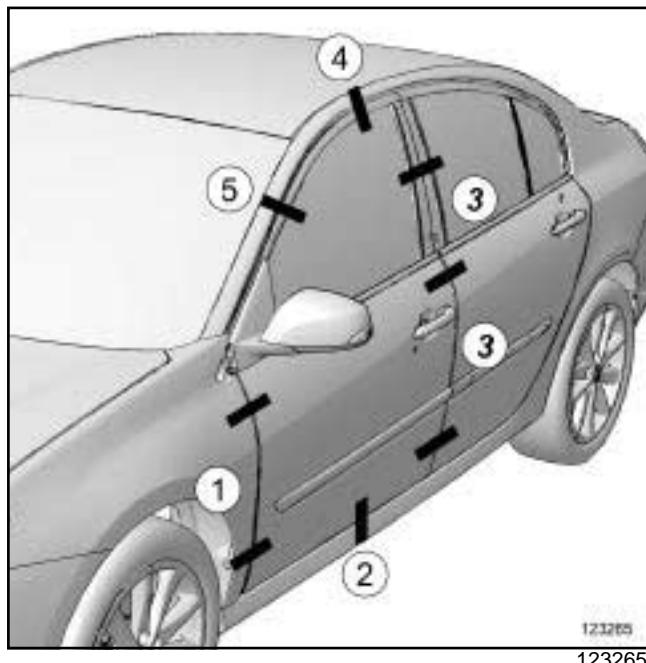
- Unlock the airbag computer. Apply the after repair procedure using the **Diagnostic tool** :
- connect the **Diagnostic tool**,
 - select « Airbag computer » ,
 - go to repair mode,
 - apply the « After repair procedure » .

ADJUSTMENT VALUES

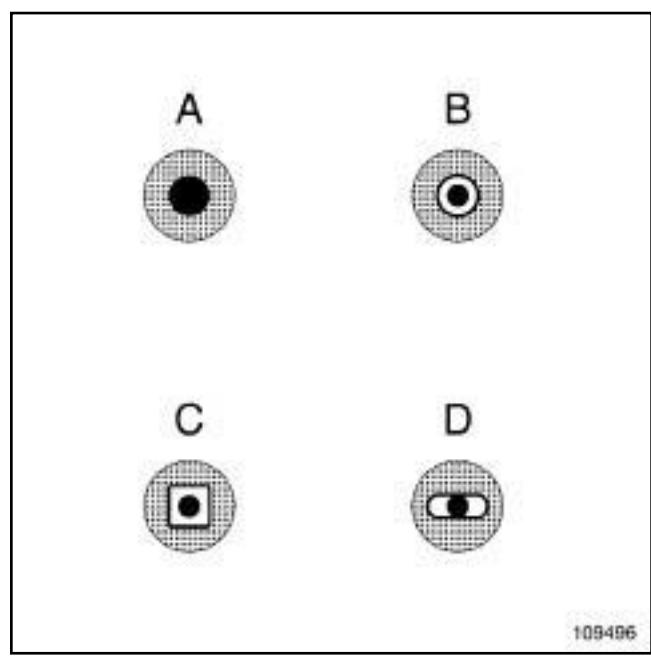
- For information on the front side door adjustment values, (see **Vehicle panel gaps: Adjustment value**) (MR 416, 01C, Vehicle bodywork specifications).

ADJUSTMENT

- There are two options for adjusting the door:
 - by means of the mountings on the door box section (opening clearance adjustment),
 - by means of the mountings on the A-pillar (shut line adjustment): the front wing needs to be removed for this operation.



- Observe the adjustment sequence.



-

Symbols A, B, C and D show the adjustment options.

The black dot in the centre represents the body of the bolt.

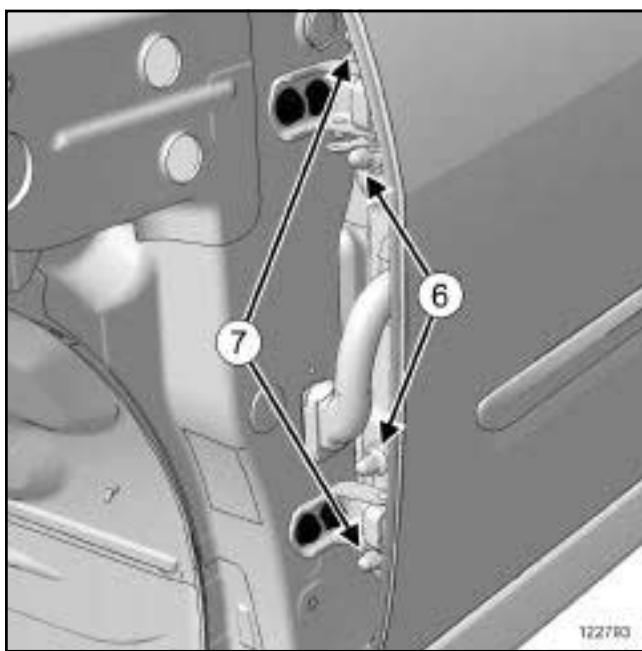
The grey section represents the component to be adjusted.

The white section represents the adjustment area.

I - ADJUSTMENT OF OPENING CLEARANCES WITH THE FRONT WING AND THE REAR DOOR

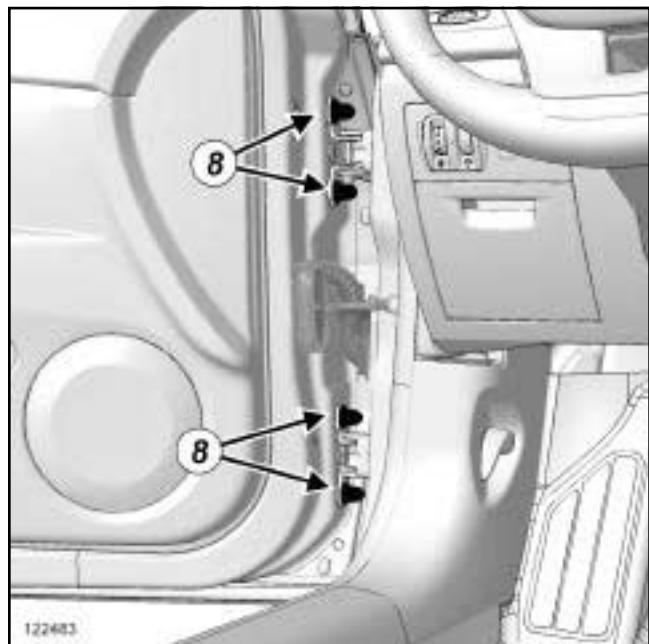
1 - PREPARATION FOR ADJUSTING THE FLUSH FITTING OF A FRONT SIDE DOOR (1st ASSEMBLY)

- Remove the front wing (see **42A, Front upper structure, Front wing: Removal - Refitting**, page **42A-3**).
- Disconnect the battery (see **Battery: Removal - Refitting**) (MR 415, 80A, Battery).



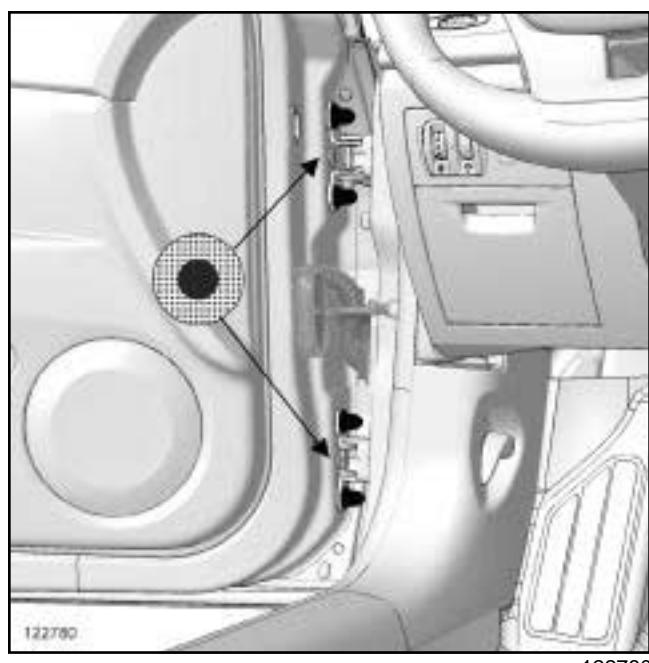
- Remove the front side door box section nuts (6) .
- Place at (6) standard nuts available from **Magasin de Pièce Rechange**, taking care not to exceed the threading.
- Undo the nuts (7) .
- Remove the front side door mounting plates by tapping the standard nuts with a hammer with an Ø 8 mm minimum and 150 mm long minimum cylindrical hammer (6) .
- Remove the standard nuts (6) .
- Refit the original front side door box section nuts (6) without tightening them.

2 - PREPARATION FOR ADJUSTING THE FLUSH FITTING OF A FRONT SIDE DOOR (PARTS DEPARTMENT PART)



- Undo the front side door box section nuts (8) .

3 - ADJUSTING THE FLUSH FITTING OF A FRONT SIDE DOOR



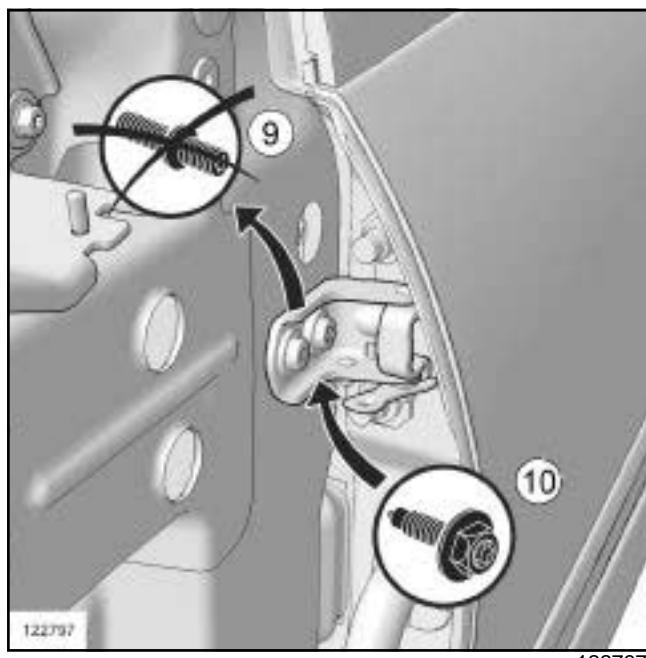
- Adjust the front side door flush fittings.
- Tighten the front side door box section nuts (8) .

4 - FINAL STEP FOR ADJUSTING THE FLUSH FITTING OF A FRONT SIDE DOOR (1st ASSEMBLY)

- Connect the battery (see **Battery: Removal - Refitting** (MR 415, 80A, Battery)).
- Inject wax for hollow sections into the door box section through the wiring harness sleeve opening. Window closed.

II - ADJUSTING THE REAR SIDE DOOR CLEARANCES

- Remove the front wing (see **42A, Front upper structure, Front wing: Removal - Refitting**, page **42A-3**).

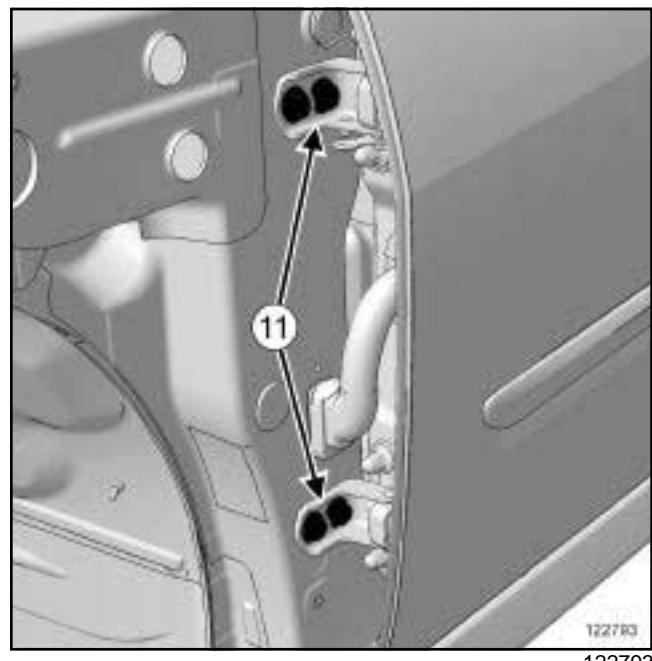


- Replace the original indexing studs (9) with bolts (10), available from **the Parts Department** to enable the flush fitting to be adjusted.

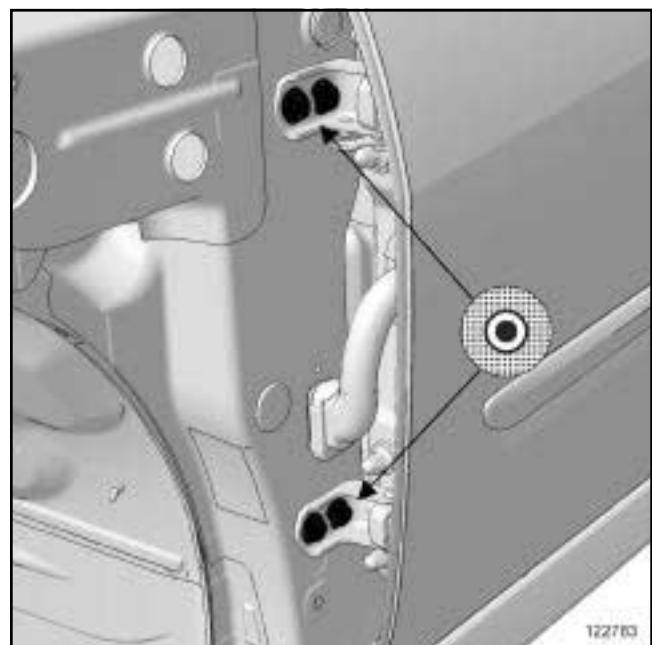
Note:

To increase the adjustment available, enlarge the holes on the original hinges.

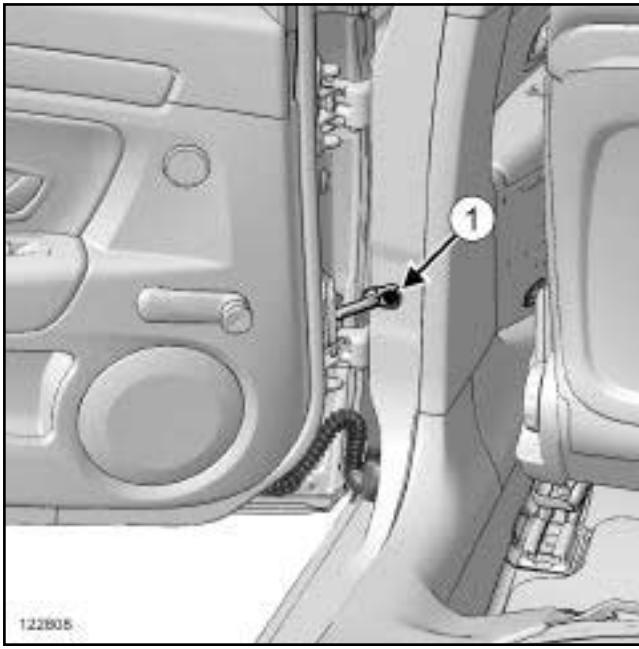
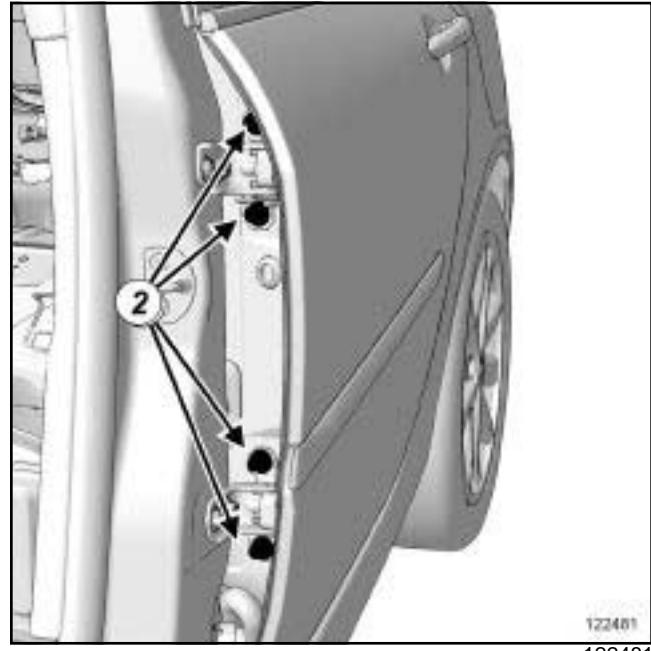
After-Sales hinges are supplied with square slots.



- Undo the front side door hinge bolts (11).



- Adjust the rear side door clearances.
- Tighten the front side door hinge bolts (11).
- Refit the front wing (see **42A, Front upper structure, Front wing: Removal - Refitting**, page **42A-3**).

REMOVAL**I - REMOVAL WITHOUT HINGES****1 - REMOVAL PREPARATION OPERATION****2 - OPERATION FOR REMOVAL OF PART CONCERNED**

122481

122481

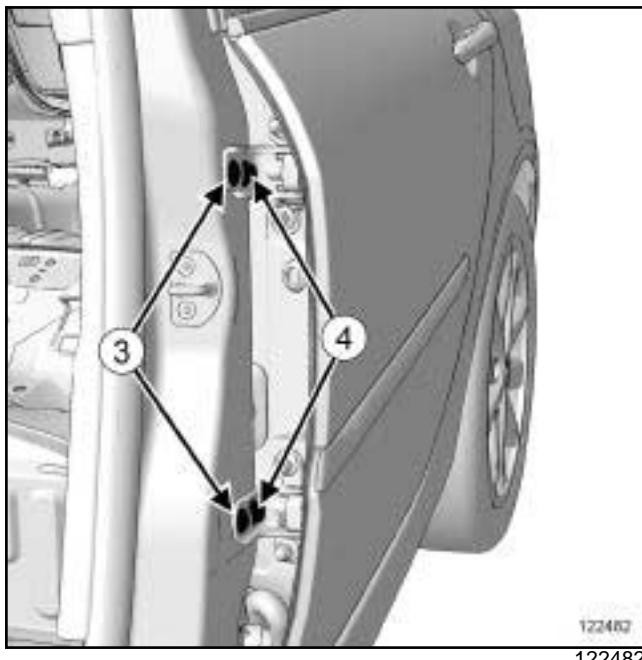
□ Remove:

- the rear side door nuts (2) ,
- the rear side door.

II - REMOVAL WITH HINGES**1 - REMOVAL PREPARATION OPERATION**

- Remove the rear side door check strap bolt (1) .
- Disconnect the supply connector from the rear side door wiring harness.

2 - OPERATION FOR REMOVAL OF PART CONCERNED



Remove:

- the rear side door hinge bolts (3) ,
- the rear side door hinge nuts (4) ,
- the rear side door.

REFITTING

I - REFITTING WITHOUT HINGES

1 - OPERATION FOR REFITTING PART CONCERNED

Refit:

- the rear side door,
- the rear side door nuts,
- the rear side door check strap bolt (1) .

Adjust the rear side door clearances and flush fittings (see **47A, Side opening elements, Rear side door: Adjustment**, page 47A-14) .

2 - FINAL OPERATION

Connect the supply connector to the rear side door wiring harness.

II - REFITTING WITH HINGES

1 - OPERATION FOR REFITTING PART CONCERNED

Refit:

- the rear side door,
- the rear side door hinge bolts (2) ,
- the rear side door hinge nuts (3) ,
- the rear side door check strap bolt (1) .

Adjust the rear side door clearances and flush fittings (see **47A, Side opening elements, Rear side door: Adjustment**, page 47A-14) .

2 - FINAL OPERATION

Connect the supply connector to the rear side door wiring harness.

Note:

The order of the operations described below applies specifically to replacing the rear side door.

The following procedure applies to the rear side door on the vehicle.

STRIPPING**STRIPPING OPERATION FOR PART CONCERNED**

- Disconnect the supply connector from the rear side door wiring harness.
- Remove:
 - the rear side door trim (see **Rear side door trim: Removal - Refitting**) (MR 416, 72A, Side opening elements trim),
 - the rear side door sealing film (see **Door sealing film: Removal - Refitting**) (MR 416, 65A, Door sealing),
 - the rear side door frame interior trim (see **Rear side door frame interior trim: Removal - Refitting**) (MR 416, 72A, Side opening elements trim),
 - the anti-fouling seal,
 - the rear side door glass run channel (see **Rear side door window run channel: Removal - Refitting**) (MR 416, 66A, Window sealing),
 - the rear side door pillar exterior trim (see **Rear side door pillar exterior trim: Removal - Refitting**) (MR 416, 56A, Exterior equipment),
 - the window winder motor (see **Electric window motor: Removal - Refitting**) (MR 415, 87D, Electric windows - Sunroof) (depending on equipment level),
 - the rear side door sliding window (see **Rear side door sliding window: Removal - Refitting**) (MR 416, 54A, Windows),
 - the rear side door fixed window (see **Rear side door fixed window: Removal - Refitting**) (MR 416, 54A, Windows),
 - the rear side door window winder mechanism (see **Rear side door manual window winder mechanism: Removal - Refitting**) or (see **Rear side door electric window mechanism: Removal - Refitting**) (MR 416, 51A, Side opening element mechanisms),

- the exterior door handle (see **Exterior door handle: Removal - Refitting**) (MR 416, 51A, Side opening element mechanisms),

- the rear side door lock (see **Rear side door lock: Removal - Refitting**) (MR 416, 51A, Side opening element mechanisms),

- the rear side door check strap (see **Rear side door check strap: Removal - Refitting**) (MR 416, 51A, Side opening element mechanisms),

- the rear side door moulding (see **Rear side door protective strip: Removal - Refitting**) (MR 416, 55A, Exterior protection),

- the rear speakers (see **Rear speakers: Removal - Refitting**) (MR 415, 86A, Radio),

- the rear side door wiring.

REBUILDING**I - REBUILDING PREPARATION OPERATION**

- Always replace:
 - the sealing film,
 - the foam pads.
- Order a door fitting kit in addition.

II - REBUILDING OPERATION FOR PART CONCERNED

- Refit:
 - the rear side door wiring,
 - the rear speakers (see **Rear speakers: Removal - Refitting**) (MR 415, 86A, Radio),
 - the rear side door moulding (see **Rear side door protective strip: Removal - Refitting**) (MR 416, 55A, Exterior protection),
 - the rear side door check strap (see **Rear side door check strap: Removal - Refitting**) (MR 416, 51A, Side opening element mechanisms),
 - the rear side door lock (see **Rear side door lock: Removal - Refitting**) (MR 416, 51A, Side opening element mechanisms),
 - the exterior door handle (see **Exterior door handle: Removal - Refitting**) (MR 416, 51A, Side opening element mechanisms),
 - the rear side door window winder mechanism (see **Rear side door manual window winder mechanism: Removal - Refitting**) or (see **Rear side door electric window mechanism: Removal - Refitting**) (MR 416, 51A, Side opening element mechanisms),

- the rear side door fixed window (see **Rear side door fixed window: Removal - Refitting**) (MR 416, 54A, Windows),
- the rear side door sliding window (see **Rear side door sliding window: Removal - Refitting**) (MR 416, 54A, Windows),
- the window winder motor (see **Electric window motor: Removal - Refitting**) (MR 415, 87D, Electric windows - Sunroof) (depending on equipment level),
- the rear side door pillar exterior trim (see **Rear side door pillar exterior trim: Removal - Refitting**) (MR 416, 56A, Exterior equipment),
- the rear side door glass run channel (see **Rear side door window run channel: Removal - Refitting**) (MR 416, 66A, Window sealing),
- the anti-fouling seal,
- the rear side door frame interior trim (see **Rear side door frame interior trim: Removal - Refitting**) (MR 416, 72A, Side opening elements trim),
- the rear side door sealing film (see **Door sealing film: Removal - Refitting**) (MR 416, 65A, Door sealing),
- the rear side door trim (see **Rear side door trim: Removal - Refitting**) (MR 416, 72A, Side opening element trim).

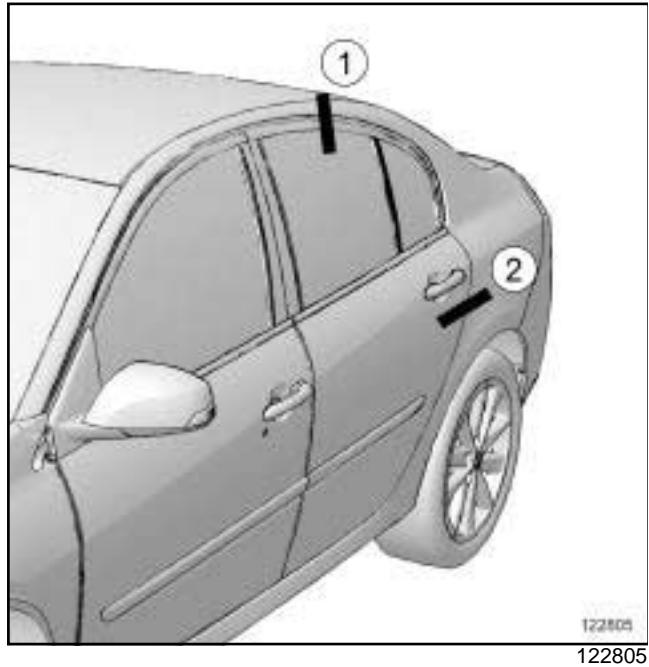
Connect the supply connector to the front side door wiring harness.

ADJUSTMENT VALUES

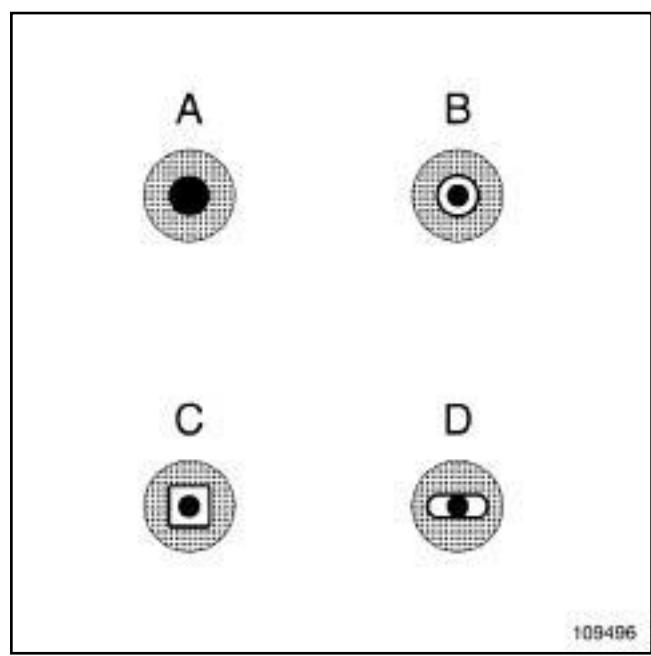
- For information on the rear side door adjustment values, (see **Vehicle panel gaps: Adjustment value**) (MR 416, 01C, Vehicle bodywork specifications).

ADJUSTMENT

- There are two options for adjusting the door:
- by means of the mountings on the door box section (opening clearance adjustment),
 - by means of the mountings on the B-pillar (panel gap adjustment).



- Observe the adjustment sequence.



-

Symbols A, B, C and D show the adjustment options.

The black dot in the centre represents the body of the bolt.

The grey section represents the component to be adjusted.

The white section represents the adjustment area.

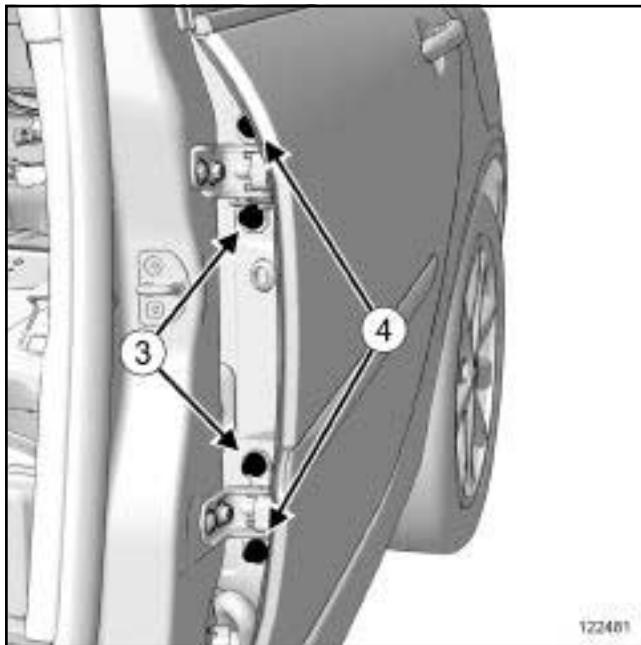
SIDE OPENING ELEMENTS

Rear side door: Adjustment

47A

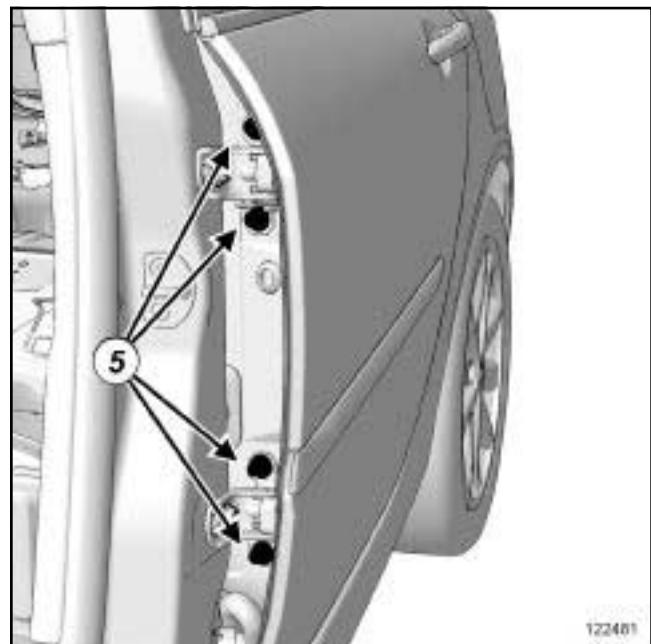
I - ADJUSTMENT OF OPENING CLEARANCE WITH THE FRONT DOOR AND THE REAR WING

1 - PREPARATION FOR ADJUSTING THE FLUSH FITTING OF A REAR SIDE DOOR (1st ASSEMBLY)



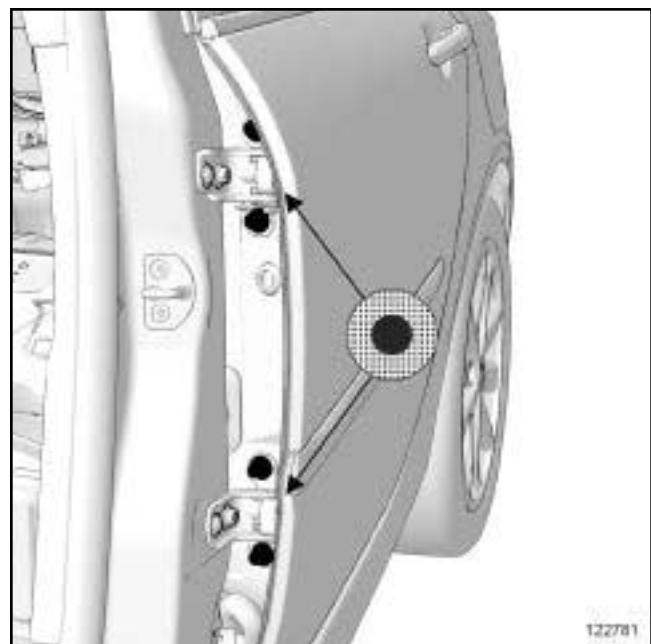
- Remove the door box section nuts (3) .
- Place at (3) standard nuts available from **Magasin de Pièce Rechange**, taking care not to exceed the threading.
- Undo the nuts (4) .
- Remove the rear side door mounting plates by tapping the nuts with a hammer using an **Ø 8 mm** minimum and **150 mm** long minimum cylindrical hammer (3) .
- Remove the standard nuts (3) .
- Refit the original rear side door box section nuts (3) without tightening them.

2 - PREPARATION FOR ADJUSTING THE FLUSH FITTING OF A REAR SIDE DOOR (PARTS DEPARTMENT PART)



- Undo the rear side door box section nuts (5) .

3 - ADJUSTING THE FLUSH FITTING OF THE REAR SIDE DOOR

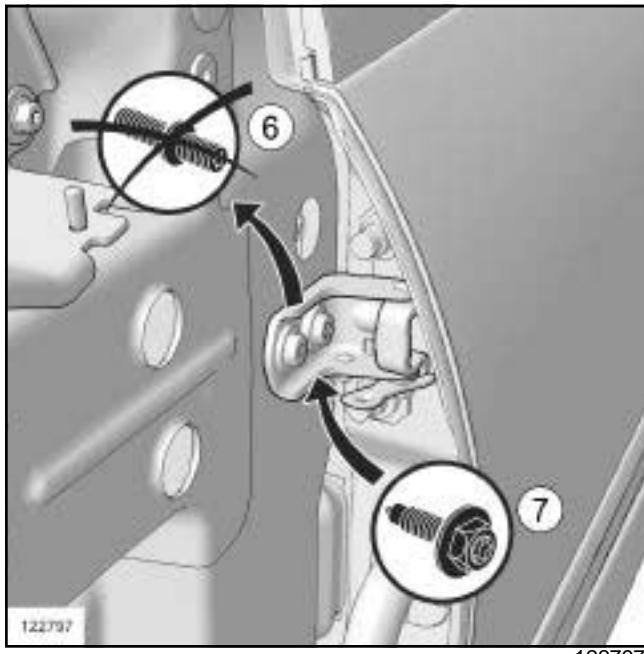


- Adjust the rear side door flush fittings.
- Tighten the door box section nuts (5) .

4 - FINAL STEP FOR ADJUSTING THE FLUSH FITTING OF A REAR SIDE DOOR

- Inject wax for hollow sections into the door box section through the wiring harness sleeve opening. Window closed.

II - ADJUSTMENT OF SHUT LINES WITH THE FRONT DOOR AND THE REAR WING

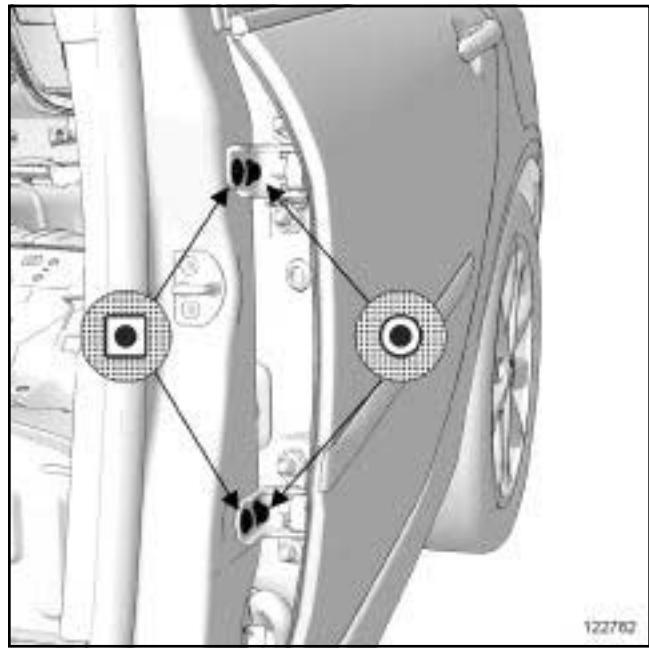


- Replace the original indexing studs (6) with bolts (7), available from the **Parts Department** to enable the flush fitting to be adjusted.

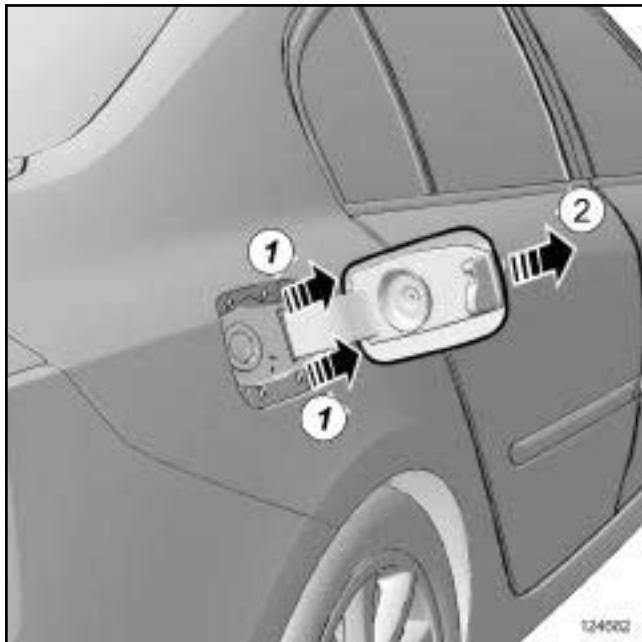
Note:

To increase the adjustment available, enlarge the holes on the original hinges.

After-Sales hinges are supplied with square slots.



- Undo the B-pillar bolts.
- Adjust the rear side door clearance.
- Tighten the B-pillar bolts.

REMOVAL**OPERATION FOR REMOVAL OF PART CONCERNED**

- Press the two sides of the fuel filler flap cover at (1) .
- Unclip the fuel filler flap cover in the direction shown (2) .

REFITTING**REFITTING OPERATION FOR PART CONCERNED**

- Clip on the fuel filler flap cover at (3) .

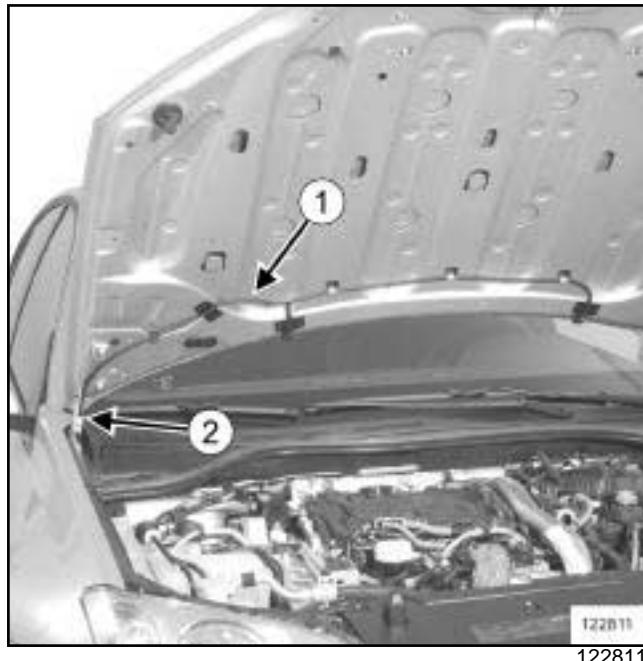
NON-SIDE OPENING ELEMENTS

Bonnet: Removal - Refitting

48A

I - REMOVAL BY MEANS OF THE BONNET BOLTS

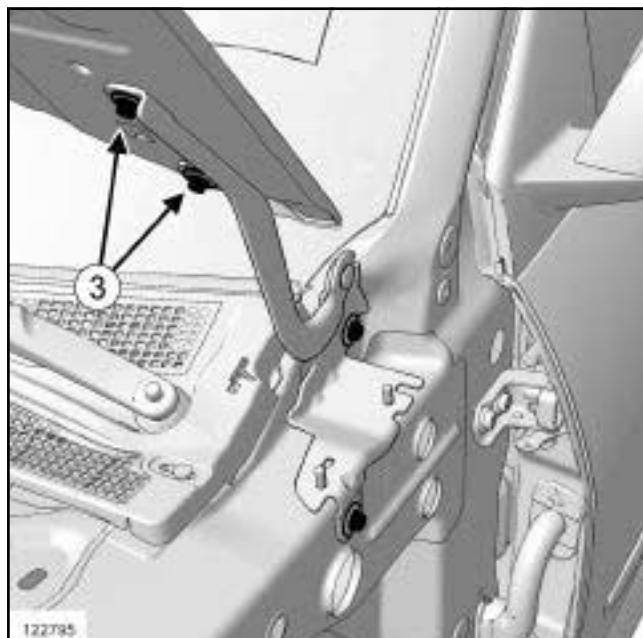
1 - REMOVAL PREPARATION OPERATION



122811

- Disconnect pipe (1)
- Unclip the pipe at (2) .

2 - OPERATION FOR REMOVAL OF PART CONCERNED



122795

- Remove:

- the bolts (3) ,
- the bonnet.

II - REFITTING BY MEANS OF THE BONNET BOLTS

1 - OPERATION FOR REFITTING PART CONCERNED

- Refit:
 - the cover,
 - the bolts (3) .
- Adjust the opening clearances and flush fitting (see **48A, Non-side opening elements, Bonnet: Adjustment**, page 48A-3) .

2 - FINAL OPERATION

- Clip on the pipe at (2) .
- Connect the pipe (1) .

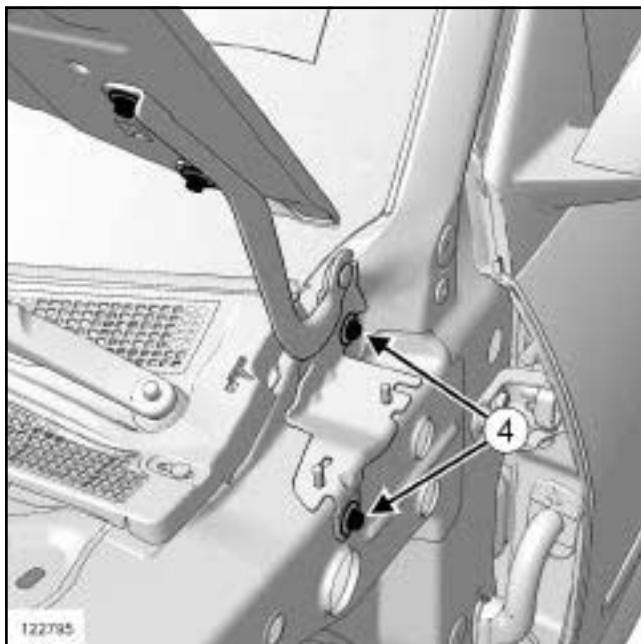
III - REMOVAL BY MEANS OF THE BONNET HINGE BOLTS

1 - REMOVAL PREPARATION OPERATION

- Remove:
 - the front wheel arch liner (see **Front wheel arch liner: Removal - Refitting**) (55A, Exterior protection),
 - the front bumper (see **Front bumper: Removal - Refitting**) (55A, Exterior protection),
 - the halogen headlights (see **Halogen headlight: Removal - Refitting**) (80B, Headlights),
 - the front wings (see **42A, Front upper structure, Front wing: Removal - Refitting**, page 42A-3) ,
 - the front wing upper mounting supports.

- Disconnect pipe (1)
- Unclip the pipe at (2) .

2 - OPERATION FOR REMOVAL OF PART CONCERNED



122795

122795

Remove:

- the bolts (4) ,
- the bonnet.

IV - REFITTING BY MEANS OF THE BONNET HINGE BOLTS

1 - OPERATION FOR REFITTING PART CONCERNED

Refit:

- the cover,
- the bolts (4) .

Adjust the opening clearances and flush fitting (see **48A, Non-side opening elements, Bonnet: Adjustment**, page **48A-3**).

2 - FINAL OPERATION

Clip on the pipe at (2).

Connect the pipe (1) .

Refit:

- the front wing upper mounting supports,
- the front wing (see **42A, Front upper structure, Front wing: Removal - Refitting**, page **42A-3**) ,
- the halogen headlights (see **Halogen headlight: Removal - Refitting**) (80B, Headlights),

- the front bumper (see **Front bumper: Removal - Refitting**) (55A, Exterior protection),

- the front wheel arch liner (see **Front wheel arch liner: Removal - Refitting**) (55A, Exterior protection).

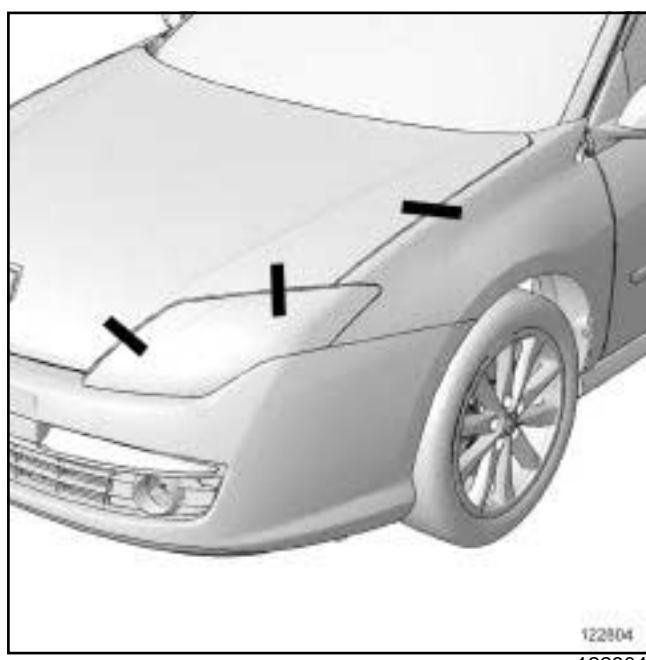
ADJUSTMENT VALUES

- For information on the adjustment values for the bonnet, (see **Vehicle panel gaps: Adjustment value**) (MR 416, 01C, Vehicle bodywork specifications).

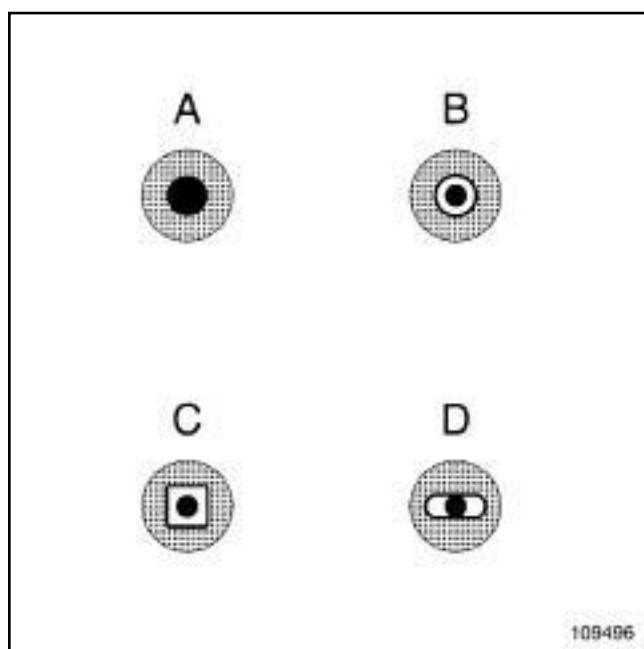
ADJUSTMENT

- There are two options for adjusting the bonnet:
- by means of the bonnet mounting bolts,
- by means of the bonnet hinge mounting bolts: this operation requires the removal of the front wing and the front wing upper mounting bracket.

The bonnet striker must be adjusted in addition to the bonnet adjustment.



- Observe the adjustment sequence.



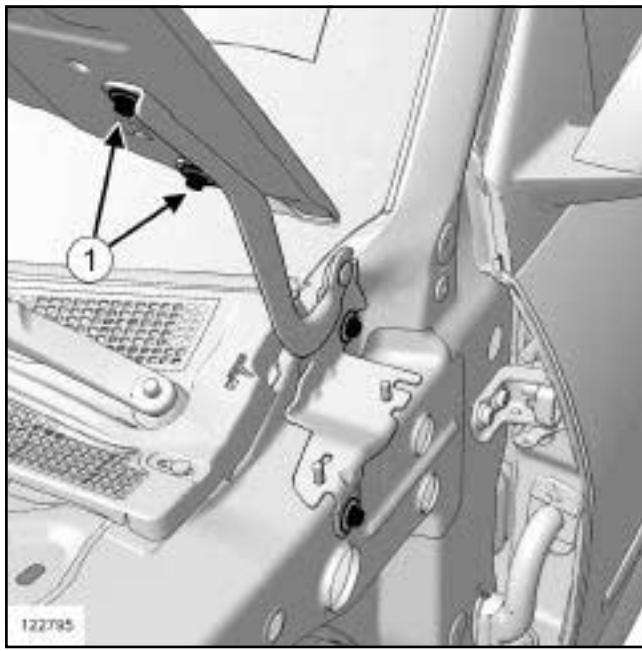
- Symbols A, B, C and D show the adjustment options.

The black dot in the centre represents the body of the bolt.

The grey section represents the component to be adjusted.

The white section represents the adjustment area.

I - ADJUSTMENT BY MEANS OF THE BONNET MOUNTING BOLTS



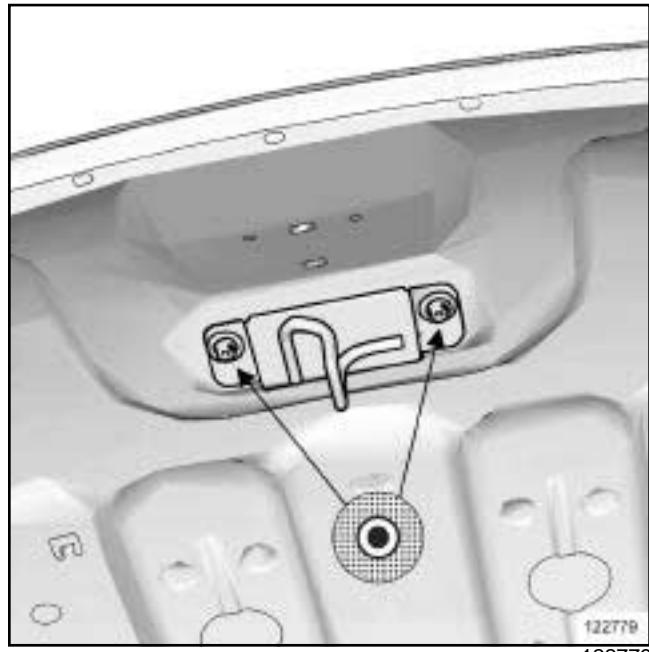
122795

- Undo the bolts (1) .
- Adjust the bonnet shut lines.

II - ADJUSTMENT BY MEANS OF THE BONNET HINGE MOUNTING BOLTS

- Remove:
 - the front wing (see **42A, Front upper structure, Front wing: Removal - Refitting**, page **42A-3**) ,
 - the front wing upper mounting support,
- Undo the bonnet hinge bolts.
- Refit:
 - the front wing upper mounting bracket,
 - the front wing.
- Adjust the bonnet shut lines.
- Remove:
 - the front wing,
 - the front wing mounting bracket.
- Refit:
 - the front wing upper mounting bracket,
 - the front wing (see **42A, Front upper structure, Front wing: Removal - Refitting**, page **42A-3**) .

III - BONNET STRIKER ADJUSTMENT



122779



Note:

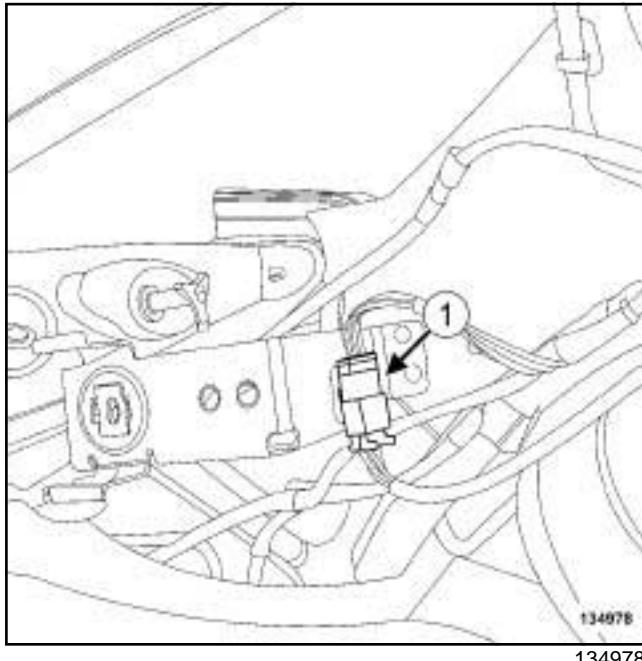
When adjusting the bonnet striker, it is imperative to remove the striker plate and fill in the paintwork to protect the bonnet from corrosion.

- Remove:
 - the bonnet striker plate bolts,
 - the bonnet striker.
- Fill in the paintwork.
- Refit the striker plate and the bolts.
- Adjust the bonnet striker with the bonnet lock.

D91

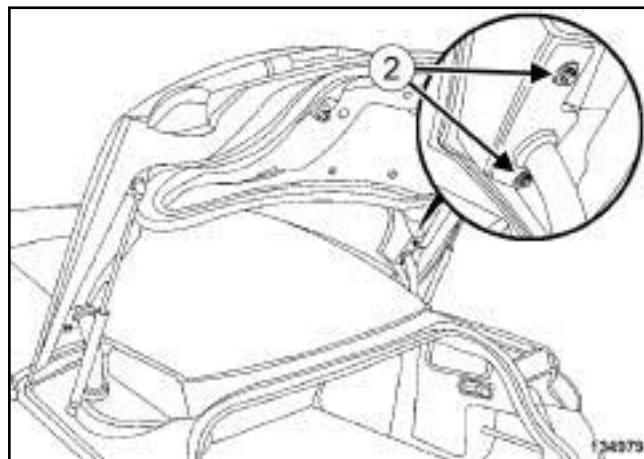
REMOVAL**I - REMOVAL PREPARATION OPERATION**

- Remove the rear wheel arch trim (see **Rear wheel arch trim: Removal - Refitting**) (71A, Body internal trim).



134978

- Disconnect the connector (1) .
 Remove the boot lid struts (see **Tailgate strut: Removal - Refitting**) (52A, Non-side opening element mechanisms).

II - REMOVAL OF PART CONCERNED

134979

- Remove
 - the bolts (2) ,
 - the boot lid.

Note:

This operation requires two people.

REFITTING

- Refit the boot lid.

Note:

This operation requires two people.

- Adjust the panel gaps and flush fittings (see **48A, Non-side opening elements, Luggage compartment lid: Adjustment**, page **48A-7**) .

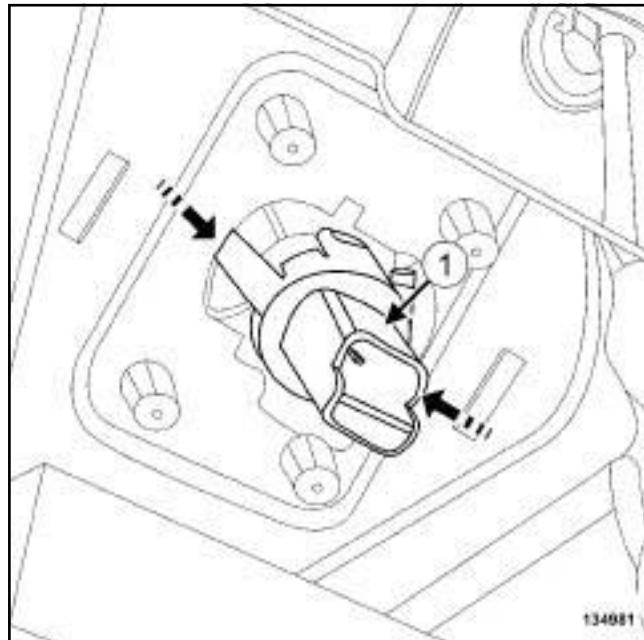
FINAL OPERATION

- Refit the boot lid struts (see **Tailgate strut: Removal - Refitting**) (52A, Non-side opening element mechanisms).
 Connect the connector (1).
 Refit the rear wheel arch trim (see **Rear wheel arch trim: Removal - Refitting**) (71A, Body internal trim).

D91

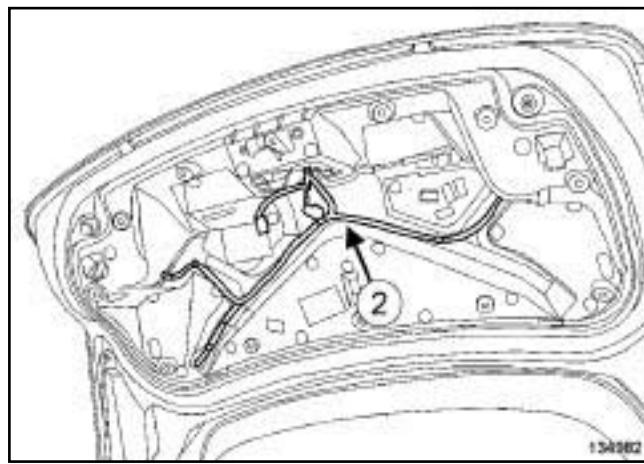
STRIPPING Remove:

- the boot lid trim (see **Luggage compartment lid trim: Removal - Refitting**) (73A, Non-side opening elements trim),
- the badges (see **Rear badges: Removal - Refitting**) (56A, Exterior equipment),
- the boot lid lock (see **Luggage compartment lid lock: Removal - Refitting**) (52A, Non-side opening element mechanisms).



134981

- Remove the boot lid exterior handle (1) .
- Remove the tailgate lights (see **Rear opening element light: Removal - Refitting**) (81A, Rear lighting).



134982

- Remove the wiring (2) .

REBUILDING Refit:

- the wiring of the boot lid (2) ,
- the tailgate lights (see **Rear opening element light: Removal - Refitting**) (81A, Rear lighting),
- the boot lid exterior handle (1) ,
- the boot lid lock (see **Luggage compartment lid lock: Removal - Refitting**) (52A, Non-side opening element mechanisms),
- the badges (see **Rear badges: Removal - Refitting**) (56A, Exterior equipment),
- the boot lid trim (see **Luggage compartment lid trim: Removal - Refitting**) (73A, Non-side opening elements trim).

D91

ADJUSTMENT VALUES

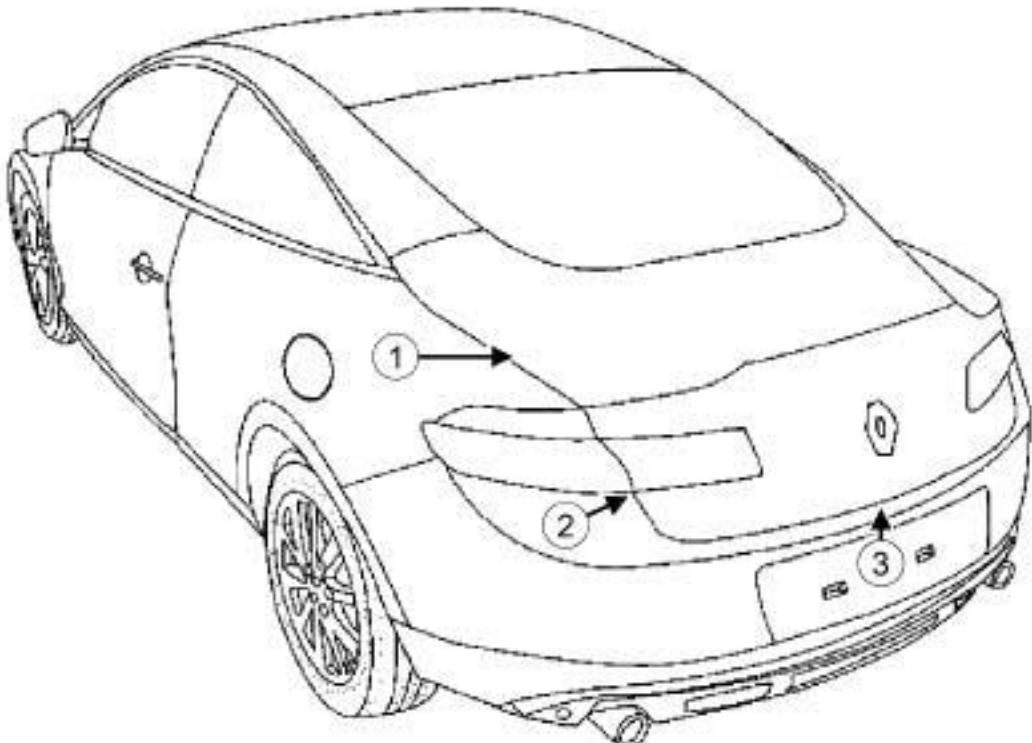
- For information on the boot lid adjustment values, (see **Vehicle panel gaps: Adjustment**) (01C, Vehicle bodywork specifications).

ADJUSTMENT

- The boot lid can be adjusted in two ways:
- by adjusting the boot lid bolts,
 - by adjusting the boot lid hinge bolts. This operation requires the quarter panel trim to be removed (see **Quarter panel trim: Removal - Refitting**) (71A, Body internal trim).

Note:

Adjustment of the boot lid striker supplements the adjustment of the boot lid.

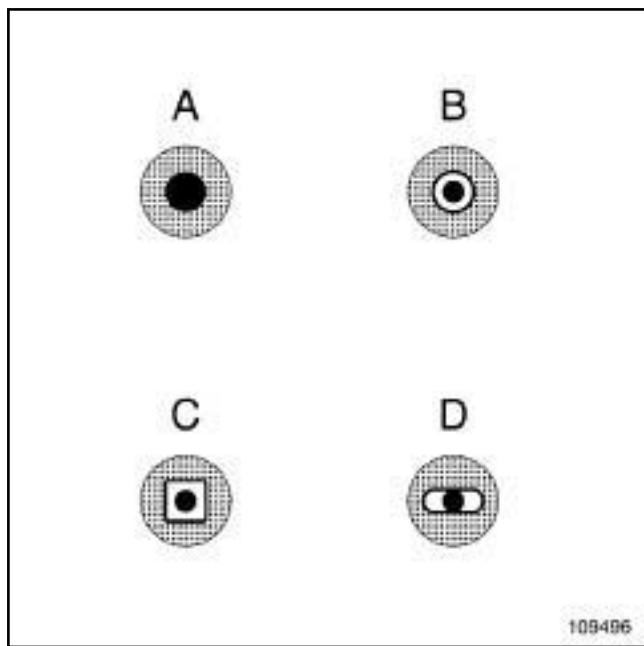


135219

135219

- Observe the following tightening order (1), (2), (3). |

D91

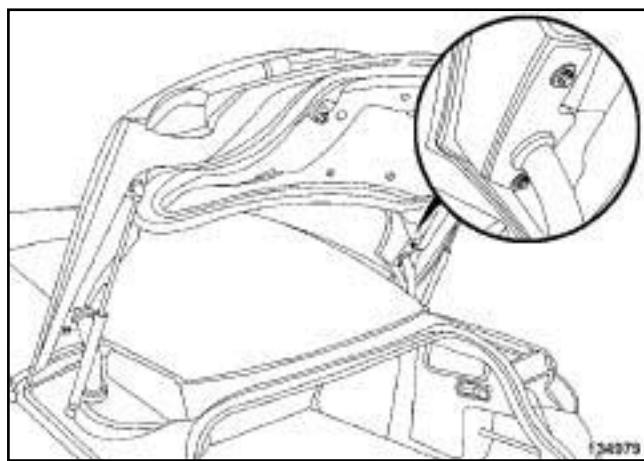


- Symbols A, B, C and D show the adjustment options.

The black dot in the centre represents the body of the bolt.
The grey section represents the component to be adjusted.

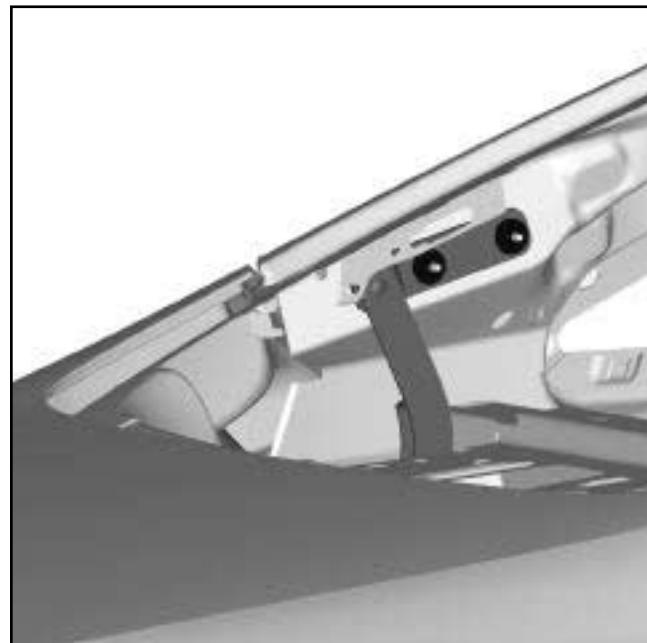
The white section represents the adjustment area.

I - ADJUSTMENT BY MEANS OF THE BOOT LID BOLTS



- Loosen the boot lid bolts.
- Adjust the panel gaps and flush fitting of the boot lid.
- Tighten the boot lid bolts.

II - ADJUSTMENT BY MEANS OF THE BOOT LID HINGE BOLTS



- Remove the rear quarter panel trim (see **Quarter panel trim: Removal - Refitting**) (71A, Body internal trim).
- Loosen the boot lid hinge bolts.
- Adjust the panel gaps and flush fittings of the boot lid.
- Tighten the boot lid hinge bolts.
- Refit the rear quarter panel trim (see **Quarter panel trim: Removal - Refitting**) (71A, Body internal trim).

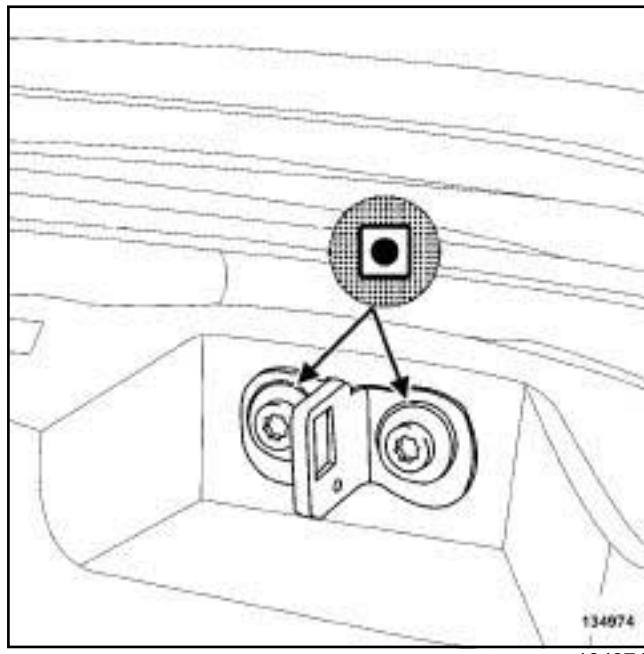
NON-SIDE OPENING ELEMENTS

Luggage compartment lid: Adjustment

48A

D91

III - ADJUSTMENT BY MEANS OF THE BOOT LID LOCK



- Loosen the boot lid striker panel bolt (see **Luggage compartment lid lock: Removal - Refitting**) (52A, Non-side opening element mechanisms).
- Adjust the panel gaps and flush fittings of the boot lid (see **Vehicle panel gaps: Adjustment value**) (01C, Vehicle bodywork specifications).
- Tighten the boot lid striker panel bolt (see **Luggage compartment lid lock: Removal - Refitting**) (52A, Non-side opening element mechanisms).

The two possible removal - refitting methods are described below:

- Removal - refitting without the hinges: this method is mainly used if the opening element is being replaced.
- Removal with the hinges: this method is mainly used when replacing the body and recovering the opening element.

I - REMOVAL - REFITTING WITHOUT THE HINGES

1 - PREPARATION FOR REMOVAL

- Remove the tailgate trim (see **Tailgate trim: Removal - Refitting**) (73A, Non-side opening elements trim).
- Disconnect the electrical connectors to:
 - the rear screen wiper motor,
 - the tailgate lock,
 - for the boot lid opening control,
 - the heated rear screen,
 - the high level brake light.

B91

- Disconnect:
 - the earths,
 - the aerial connectors,
 - the tailgate lights.
-

K91

- Disconnect the number plate light connectors.
-

- Remove:
 - the tailgate wiring,
 - the tailgate washer jet tube,
 - the tailgate gas struts (see **Tailgate strut: Removal - Refitting**) (52A, Non-side opening element mechanisms).

2 - REMOVAL



122484

- Remove:
 - the tailgate bolts (1) ,
 - the tailgate.

3 - REFITTING

- Refit:
 - the tailgate,
 - the tailgate bolts (1) .

4 - FINAL OPERATION

- Refit:
 - the tailgate gas struts (see **Tailgate strut: Removal - Refitting**) (52A, Non-side opening element mechanisms),
 - the tailgate washer jet tube,
 - the tailgate wiring.

B91

- Connect:
 - the earths,
 - the aerial connectors,
 - the tailgate lights.
-

NON-SIDE OPENING ELEMENTS

Tailgate: Removal - Refitting

48A

K91

- Connect the number plate light connectors.

- Connect the electrical connectors to:

- the rear screen wiper motor,
- the tailgate lock,
- for the boot lid opening control,
- the heated rear screen.

- Refit the tailgate trim (see **Tailgate trim: Removal - Refitting**) (73A, Non-side opening elements trim).

II - REMOVAL - REFITTING WITH THE HINGES

1 - PREPARATION FOR REMOVAL

- Remove the tailgate trim (see **Tailgate trim: Removal - Refitting**) (73A, Non-side opening elements trim).

- Disconnect the electrical connectors to:

- the rear screen wiper motor,
- the tailgate lock,
- for the boot lid opening control,
- the heated rear screen,
- the high level brake light.

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- Disconnect:

- the earths,
- the aerial connectors,
- the tailgate lights.

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- Disconnect the number plate light connectors.

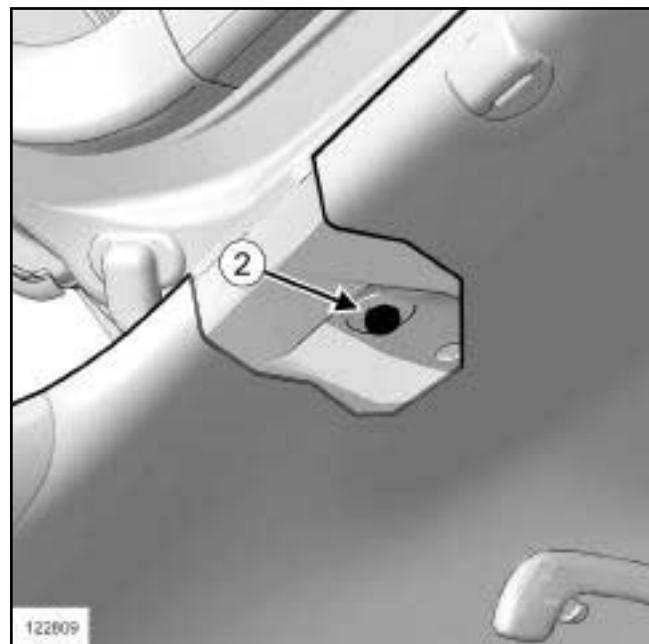
- Remove:

- the tailgate wiring,
- the tailgate washer jet tube,

- the tailgate gas struts (see **Tailgate strut: Removal - Refitting**) (52A, Non-side opening element mechanisms),

- the rear section of the headlining (see **Headlining: Removal - Refitting**) (71A, Body internal trim).

2 - REMOVAL



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- Remove:

- the tailgate hinge nuts (2) ,
- the tailgate.

3 - REFITTING

- Refit:

- the tailgate,
- the tailgate hinge nuts (2) .

- If necessary adjust the tailgate edge clearances (see **48A, Non-side opening elements, Tailgate: Adjustment**, page 48A-15) .

4 - FINAL OPERATION

- Refit:

- the tailgate gas struts (see **Tailgate strut: Removal - Refitting**) (52A, Non-side opening element mechanisms),
- the tailgate washer jet tube,
- the tailgate wiring.

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Connect:

- the earths,
- the aerial connectors,
- the tailgate lights.



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Connect the number plate light connectors.



Connect the electrical connectors to:

- the rear screen wiper motor,
- the tailgate lock,
- for the boot lid opening control,
- the heated rear screen.

Refit the tailgate trim (see **Tailgate trim: Removal - Refitting**) (73A, Non-side opening elements trim).

Note:

Described below is a special sequence of operations for tailgate replacement.

The procedure described below applies to the tailgate on the vehicle.

STRIPPING

Remove:

- the tailgate trim (see **Tailgate trim: Removal - Refitting**) (73A, Non-side opening elements trim),
- the rear screen wiper motor (see **Rear screen wiper motor: Removal - Refitting**) (85A, Washing - Wiping),
- the tailgate lock (see **Tailgate lock: Removal - Refitting**) (52A, Non-side opening element mechanisms),
- the tailgate exterior opening control (see **Tailgate exterior opening control: Removal - Refitting**) (52A, Non-side opening element mechanisms),
- the high level brake light (see **3rd brake light: Removal - Refitting**) (81A, Rear lighting),
- the rear screen (see **Rear screen: Removal - Refitting**) (54A, Windows).

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Remove the tailgate lights (see **Rear opening element light: Removal - Refitting**) (81A, Rear lighting).

- the number plate lights.

Remove the tailgate wiring.

REBUILDING

I - PREPARATION FOR REBUILDING

- Always replace the rear badge.
- Order a tailgate fitting kit in addition.

II - REBUILDING

Refit the tailgate wiring.

B91

Refit the tailgate lights (see **Rear opening element light: Removal - Refitting**) (81A, Rear lighting).

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Refit:

- the opening rear screen seal,
- the opening rear screen (see **Opening rear screen: Removal - Refitting**) (54A, Windows),
- the opening rear screen struts,
- the tailgate spoiler (see **Tailgate spoiler: Removal - Refitting**) (56A, Exterior equipment),
- the registration plate lights,
- the tailgate strip (see **Tailgate strip**) (55A, Exterior protection).

Refit:

- the rear screen (see **Rear screen: Removal - Refitting**) (54A, Windows),
- the high level brake light (see **3rd brake light: Removal - Refitting**) (81A, Rear lighting),
- the rear screen wiper motor (see **Rear screen wiper motor: Removal - Refitting**) (85A, Washing - Wiping),
- the tailgate lock (see **Tailgate lock: Removal - Refitting**) (52A, Non-side opening element mechanisms),

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Remove:

- the opening rear screen (see **Opening rear screen: Removal - Refitting**) (54A, Windows),
- the opening rear screen struts,
- the opening rear screen seal,
- the tailgate spoiler (see **Tailgate spoiler: Removal - Refitting**) (56A, Exterior equipment),
- the tailgate strip (see **Tailgate strip**) (55A, Exterior protection),

NON-SIDE OPENING ELEMENTS

Tailgate: Stripping - Rebuilding

48A

- the tailgate exterior opening control (see **Tailgate exterior opening control: Removal - Refitting**) (52A, Non-side opening element mechanisms),
- the tailgate trim (see **Tailgate trim: Removal - Refitting**) (73A, Non-side opening elements trim).

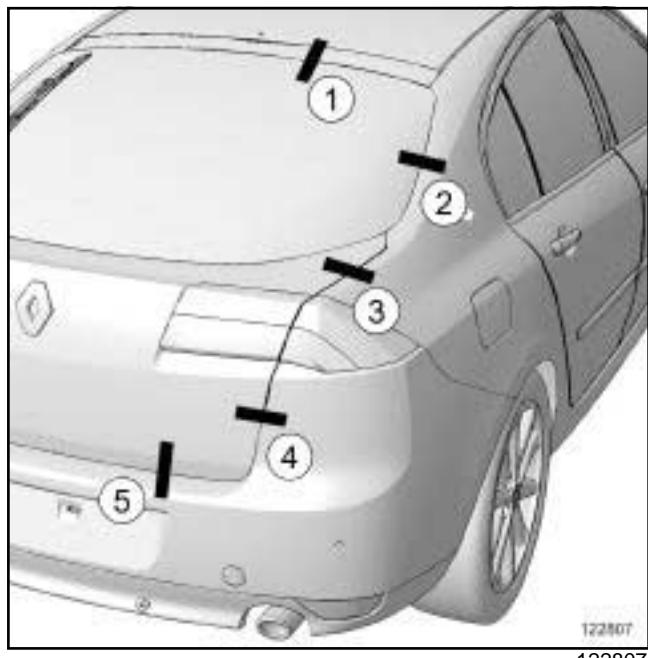
ADJUSTMENT VALUES

- For information on the tailgate adjustment values, (see **Vehicle panel gaps: Adjustment value**) (MR 416, 01C, Vehicle bodywork specifications).

ADJUSTMENT

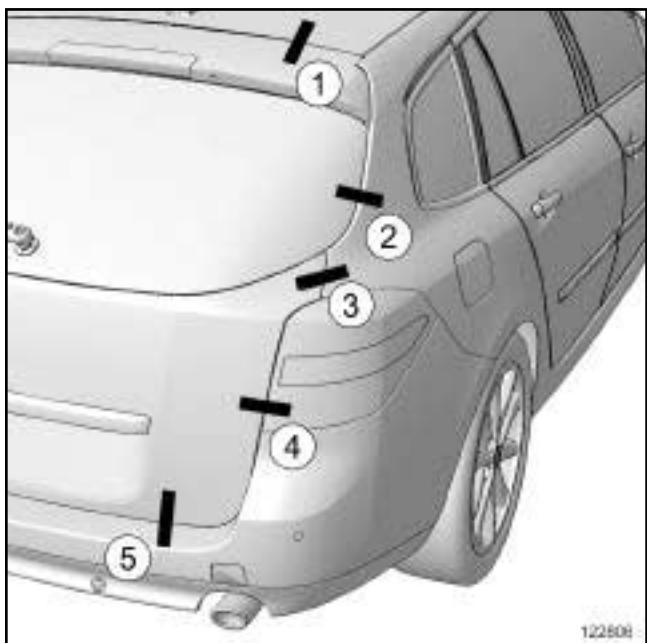
- There are two options for adjusting the tailgate:
- using the tailgate bolts,
- using the tailgate hinge nuts: operation in addition to the removal of the headlining.

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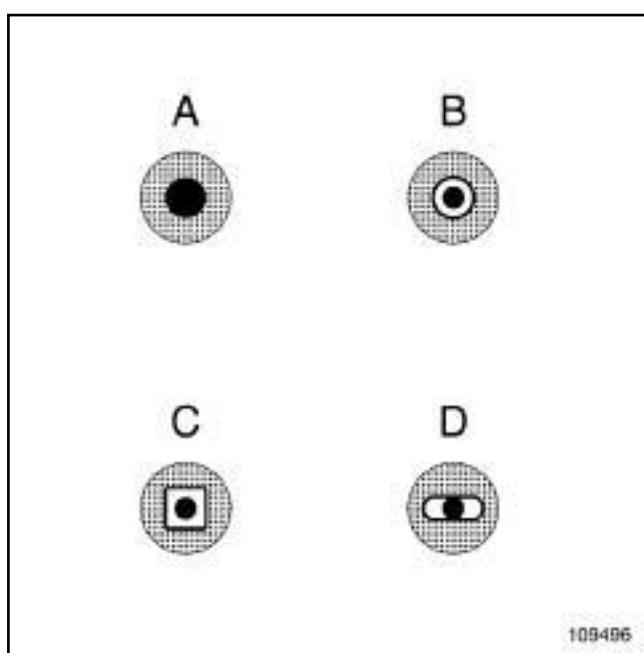


- Observe the adjustment sequence.

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- Observe the adjustment sequence.



□

Note:

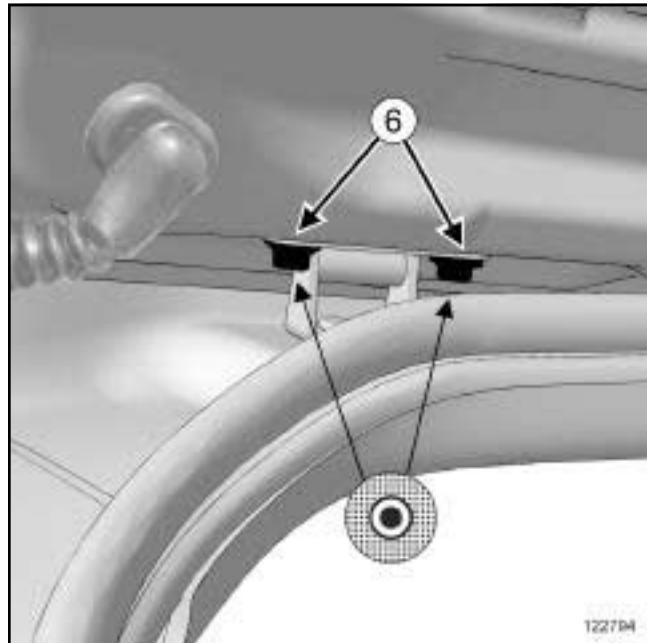
Symbols A, B, C and D show the adjustment options.

The black dot in the centre represents the body of the bolt.

The grey section represents the component to be adjusted.

The white section represents the adjustment area.

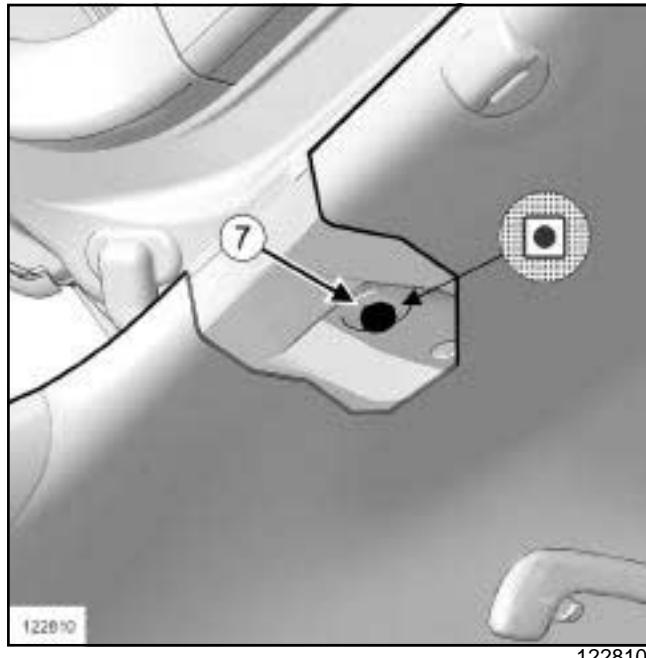
I - ADJUSTMENT USING THE TAILGATE BOLTS



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- Undo the tailgate bolts (6) on each side of the vehicle.
- Adjust the clearances at the top of zones (1) and (2) on the tailgate.

II - ADJUSTMENT USING THE HINGE NUTS



- Partially remove the rear section of the headlining (see **Headlining: Removal - Refitting**) (MR 416, 71A, Body internal trim).
- Undo the hinge nut (7) on both sides of the vehicle.
- Adjust the tailgate edge clearances.
- Refit the headlining (see **Headlining: Removal - Refitting**) (MR 416, 71A, Body internal trim).