



## **4 Sheet Metalwork**

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***BB0A - BB0C - BB0D - BB0E - CB0A - CB0C - CB0D - CB0E***

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**77 11 197 393**

**DECEMBER 1997**

**Edition Anglaise**

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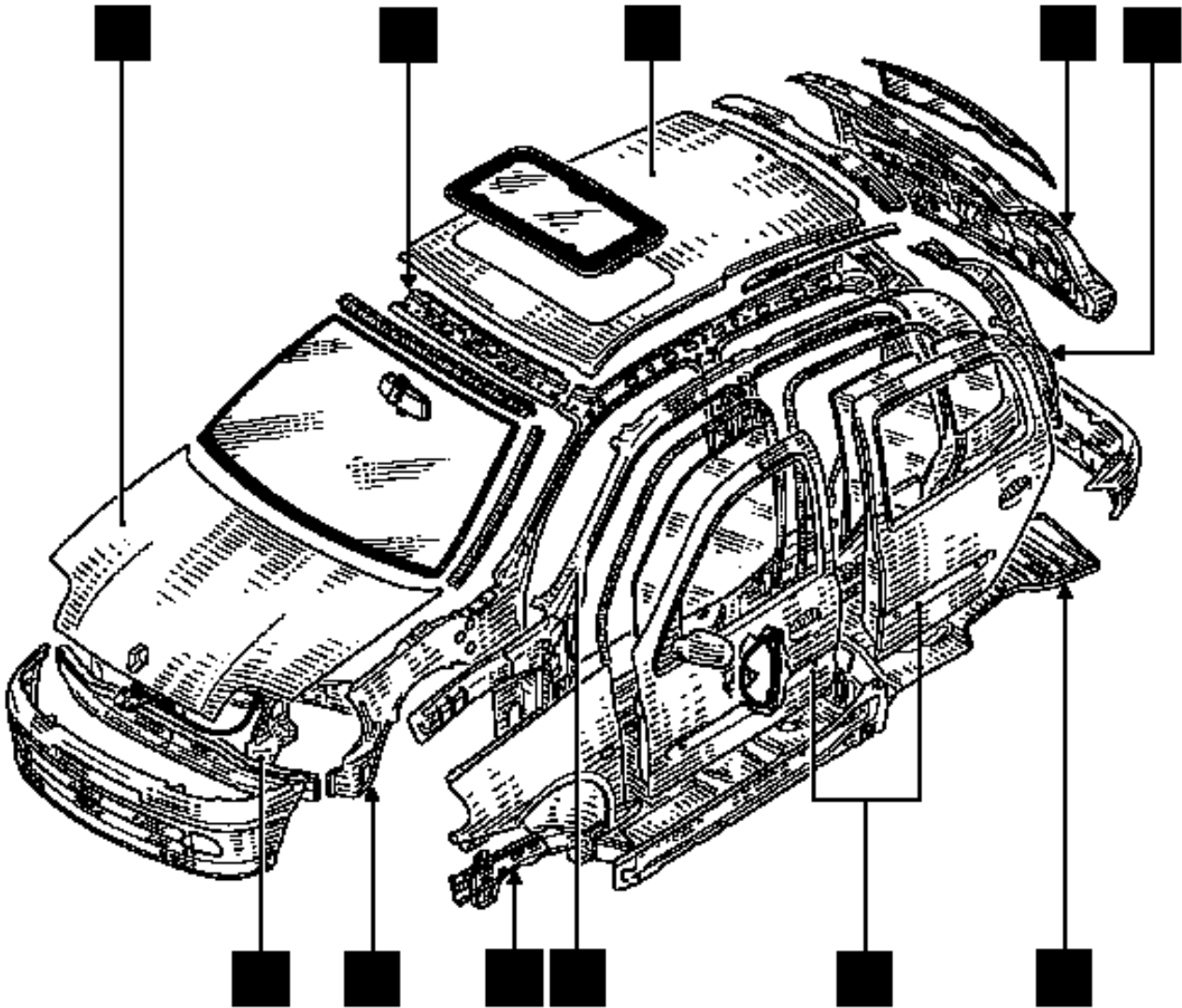
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**Renault 1997**

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EXPLODED VIEW



# Sheet Metalwork

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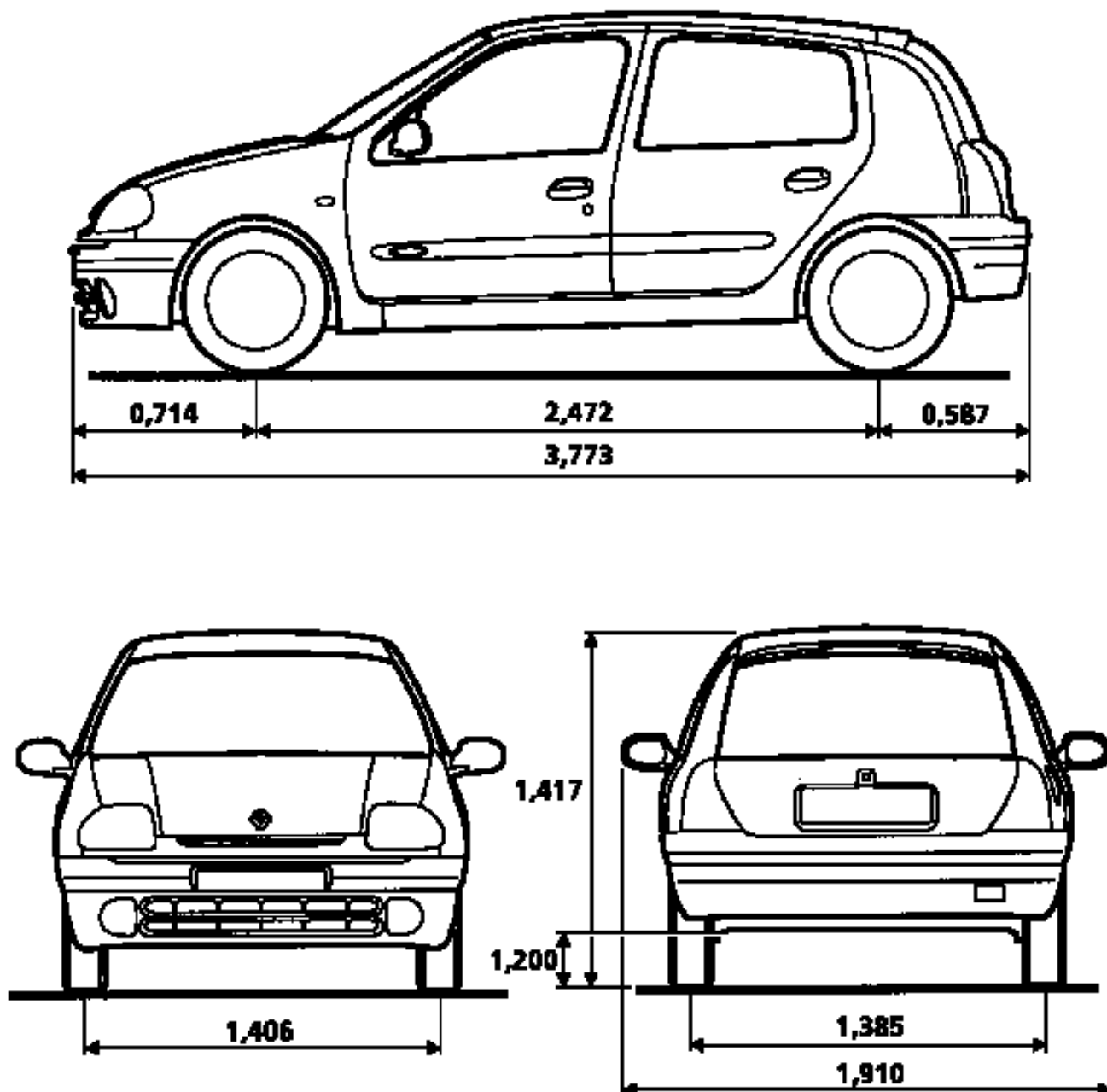
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Dimensions in metres



13491R3

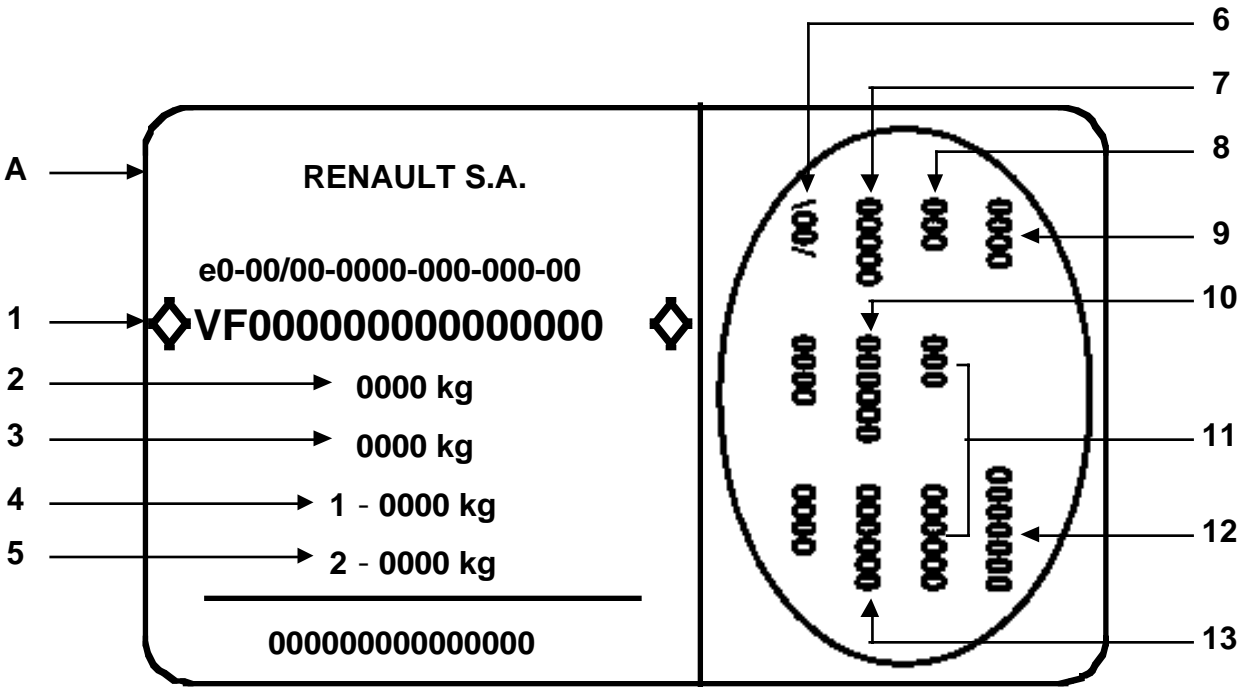
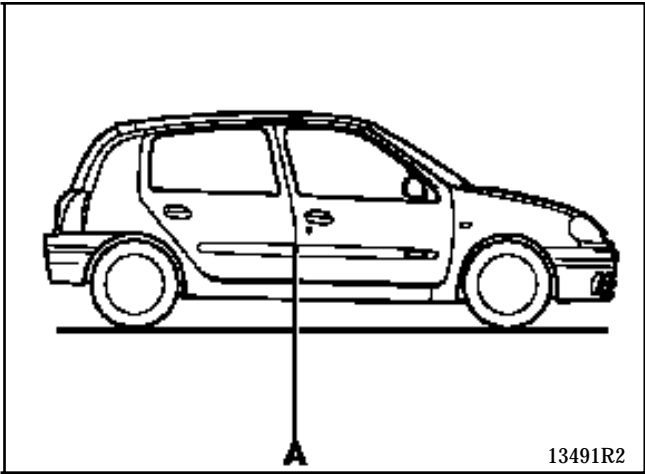
Vehicle type	Engine		Clutch type	Gearbox type Manual
	Type	Capacity (cm <sup>3</sup> )		
B/C B0A	D7F	1149	180 CP 3300	JB1
B/C B0C	E7J	1390	180 CP 3300	
B/C B0D	K7M	1598	200 CPOV 3500	
B/C B0E	F8Q	1870	200 CPOV 3250	

VEHICLE IDENTIFICATION

Example : BB0A

- B : Bodywork type (5-door)
- B : Project code
- 0A : Engine suffix

LOCATION OF THE VEHICLE IDENTIFICATION  
PLATE



- 1 The vehicle type mine and the chassis number
- 2 MTMA (maximum permitted all up weight for the vehicle)
- 3 MTR (Maximum permitted total train weight - vehicle fully laden and towing)
- 4 Maximum permitted weight on front axle
- 5 Maximum permitted weight on rear axle

- 6 Technical specifications of the vehicle
- 7 Paint reference
- 8 Equipment level
- 9 Vehicle type
- 10 Trim code
- 11 Additional equipment definition
- 12 Fabrication number
- 13 Interior matching trim code



Safety symbol (special precautions to be taken when carrying out operations).

SPECIAL TOOLING REQUIRED	
Cha. 280 -02	Adaptable cross piece for trolley jack
Cha. 408 -01 or Cha. 408 -02	Adaptable socket for trolley jack



If a trolley jack is used, appropriate axle stands must also be used.

The vehicle **MUST NOT** be lifted by supporting its weight under the front suspension arms or under the rear axle assembly.

Depending on the type of trolley jack, use sockets **Cha. 408-01** or **Cha. 408-02** to position the cross piece **Cha. 280-02**.

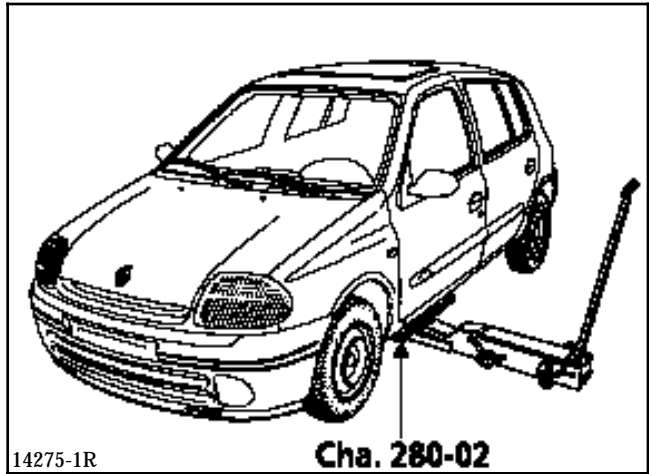
To lift at the front or rear, take the weight under the vehicle jacking points.

#### LIFTING FROM THE SIDE WITH A TROLLEY JACK

Use cross piece **Cha. 280-02**.

Take the weight under the valance at the front door.

Position the flange correctly in the cross member groove.

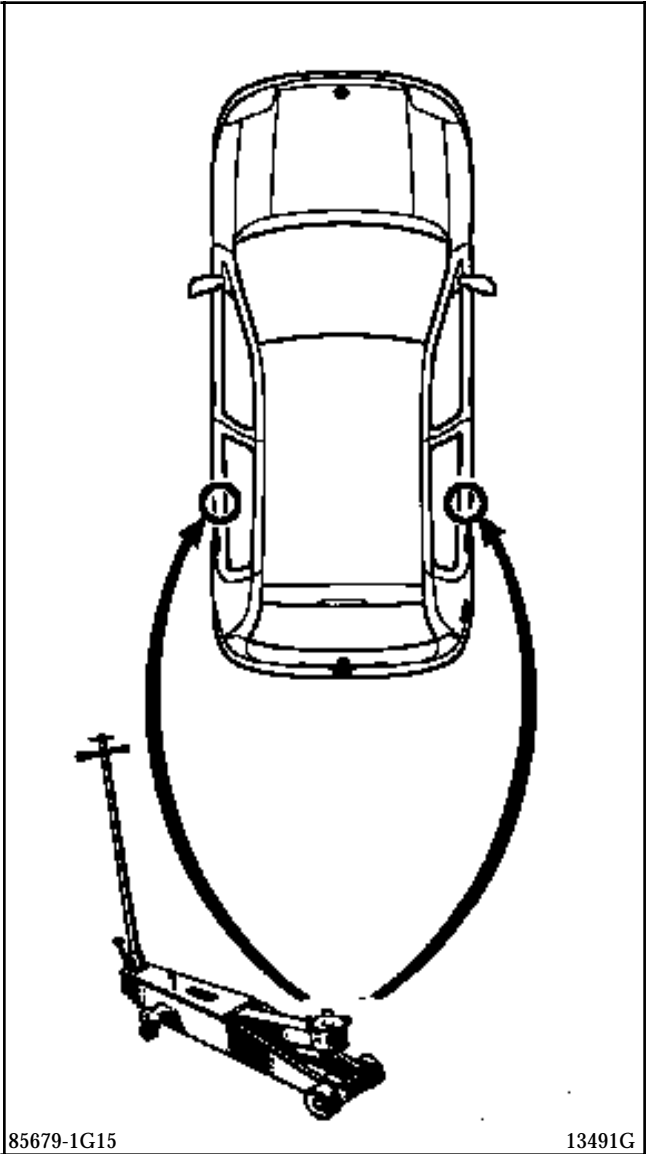


#### AXLE STANDS

To place the vehicle on axle stands, they **MUST** be placed :

- either under the reinforcements provided for lifting the vehicle with the jack which forms part of the vehicle equipment,
- or under the points behind the reinforcements.

Rear positioning of the axle stands can be carried out by lifting the vehicle from the side.





### SAFETY SYMBOL



There are several examples to consider :

#### 1 - WHEN REMOVING COMPONENTS

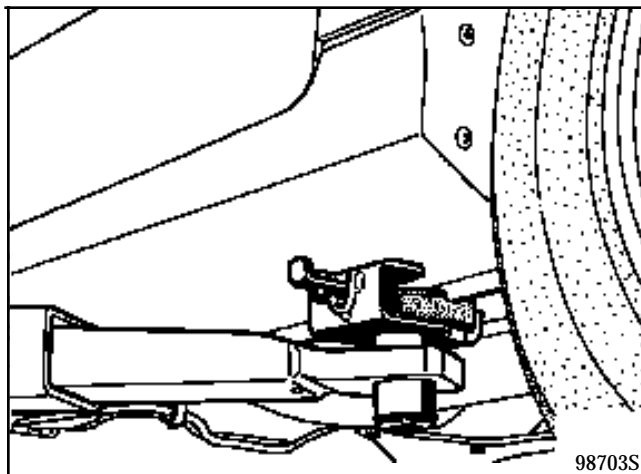
Generally speaking, **never use a 2-post lift** if a four post lift would be more suitable.

If this is not possible, position the lifting pads below the body flange at the jacking points for the jack supplied with the vehicle.

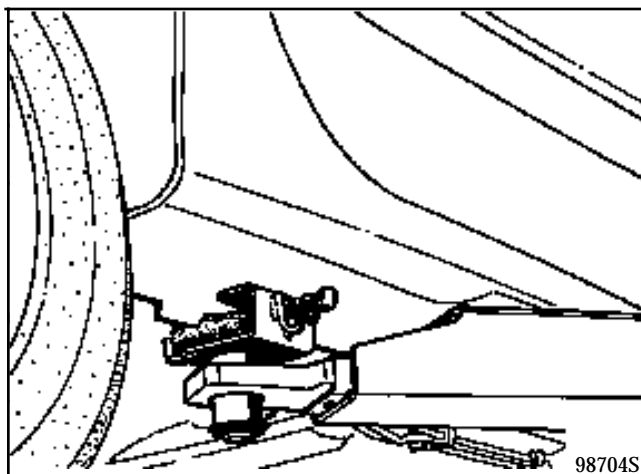
#### 2 - SPECIAL CASE OF THE REMOVAL - REFITTING OF THE ENGINE AND TRANSMISSION

In this specific case, the body of the vehicle **MUST** be fixed to the arms of the two post lift with special pads.

FRONT



REAR



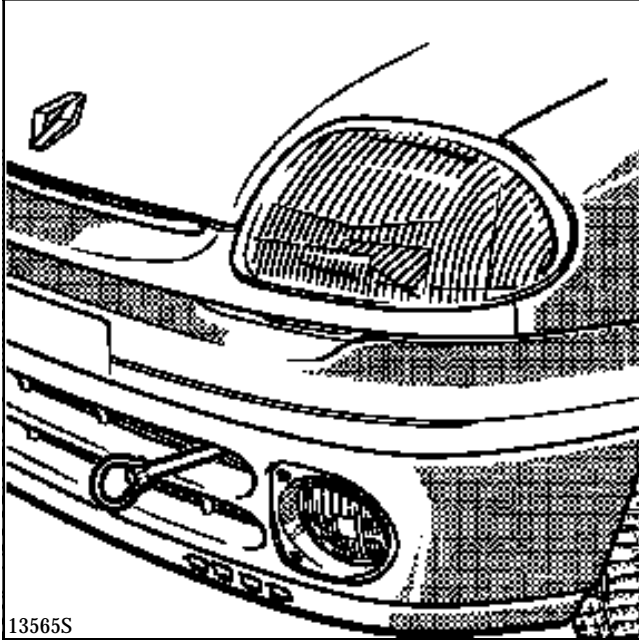
These **MUST** be placed to the right of the jacking points. They must be clipped into the sill panel flange openings.

**OBSERVE THE LEGAL TOWING REQUIREMENTS OF THE COUNTRY YOU ARE IN**

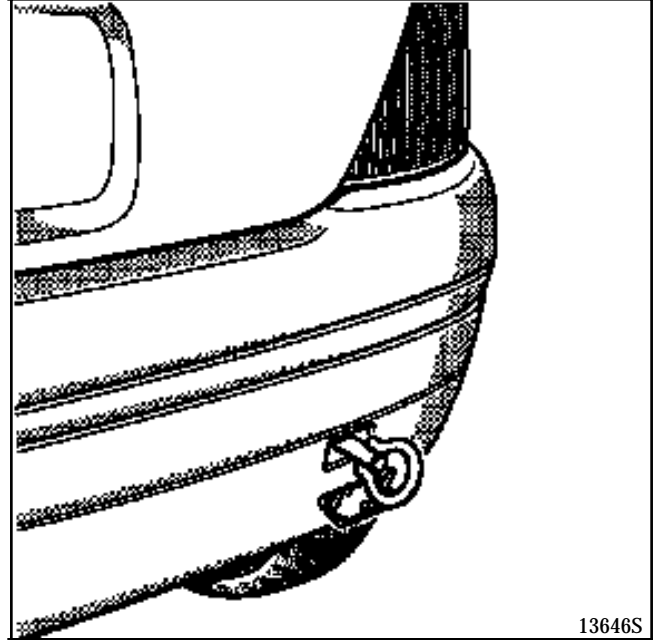
**NEVER USE THE DRIVESHAFTS AS ATTACHMENT POINTS**

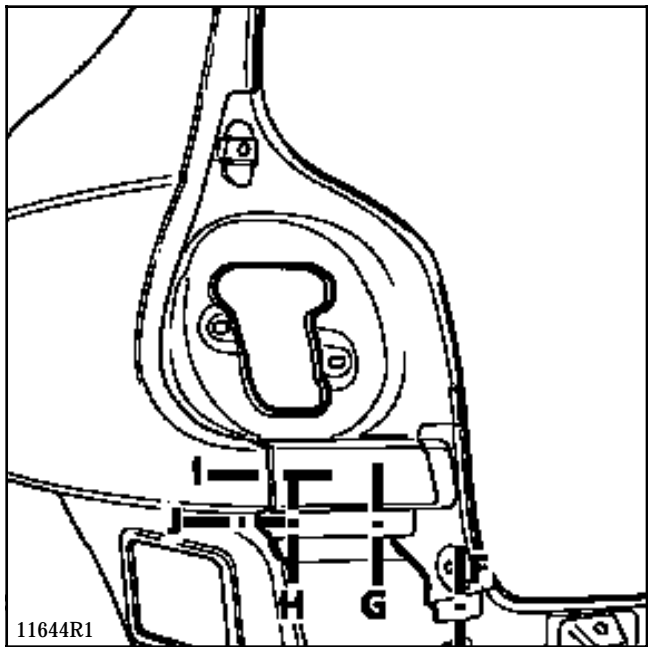
The towing points should only be used for towing the vehicle on the road. They should never be used for removing the vehicle from a ditch or for any other similar breakdown operation, or to lift the vehicle, either directly or indirectly.

**FRONT**

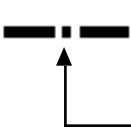


**REAR**





The above diagram shows the part on the vehicle for which a section of the panel butt welding joint is shown by the diagrams which follow.

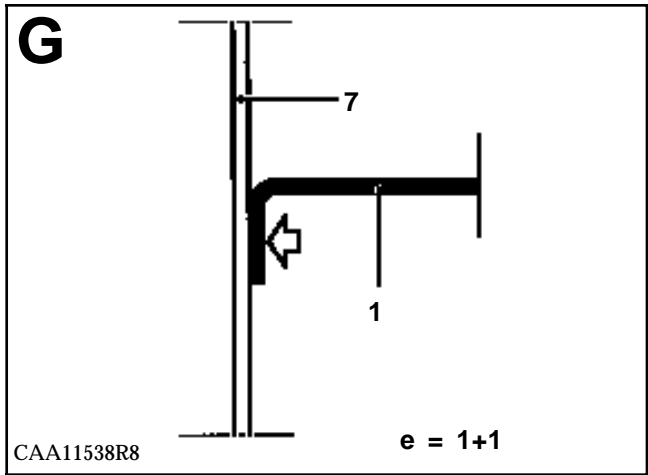


This dashed line shows the centre of the sections.


The point shows the exact position of the weld joint.

F - G -  
H - I - J

This letter designates the diagram corresponding to the section (it is given in one of the upper corners of each diagram).



The following indications are found in the section diagrams :

 The black part is the one which will be removed in the operation

1 and 7 are the part numbers corresponding to the list on the introduction page

$e = 1 + 1$  are the thicknesses (in mm) of the panels for electrical spot welding

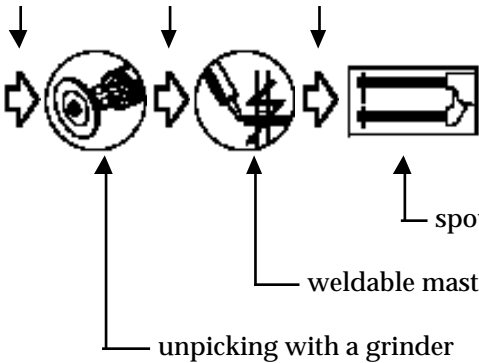


This arrow on the diagram designates the access points for the unpicking of spot welds (see specific cases)

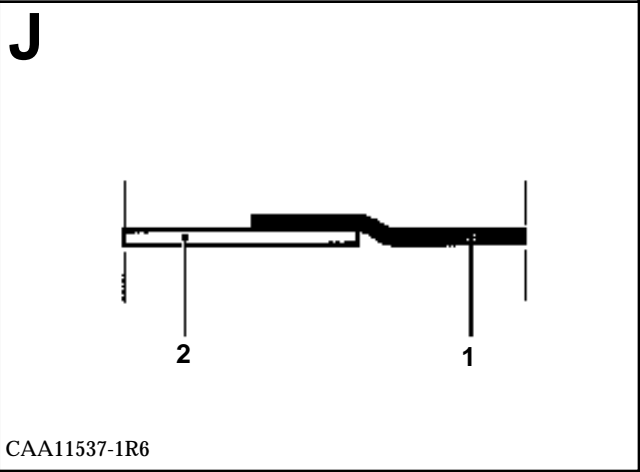
It also indicates the logical sequence of operations in the symbols which follow each diagram.

Example :

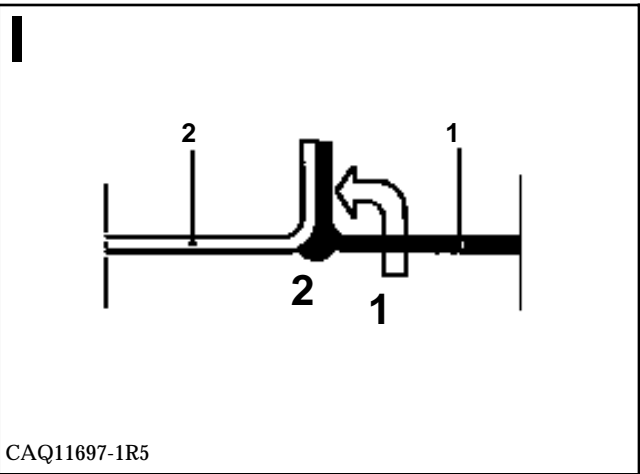
place of operation and logical sequence



SPECIFIC CASES



In this example, there is no direct access for removing part 1. The spot welds should be unpicked through part 2, which should be kept.



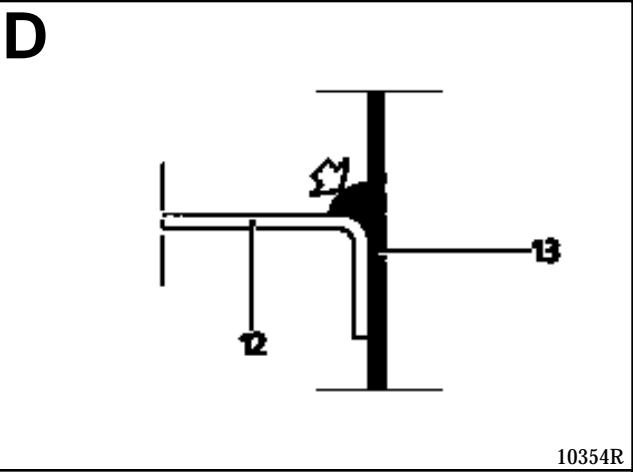
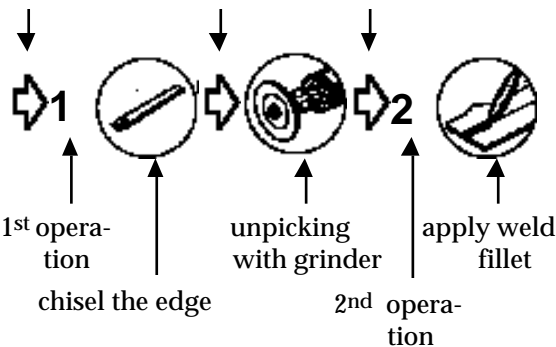
This arrow indicates that the part which it crosses must be cut before the joint can be accessed.

The references which follow indicate different operations:

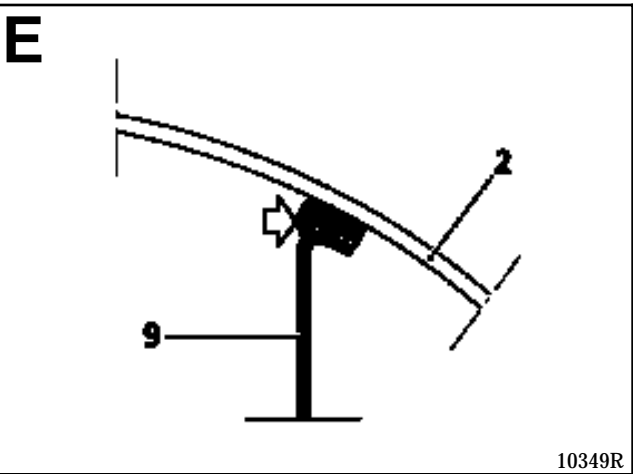
- 1 unpicking
- 2 welding

Under diagram I

site of operation and logical sequence



In this particular case, the arrow indicates that the joint is made by arc welding (MIG).


















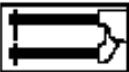


In this example, the joint is made by bonding.

# GENERAL

## Key to symbols

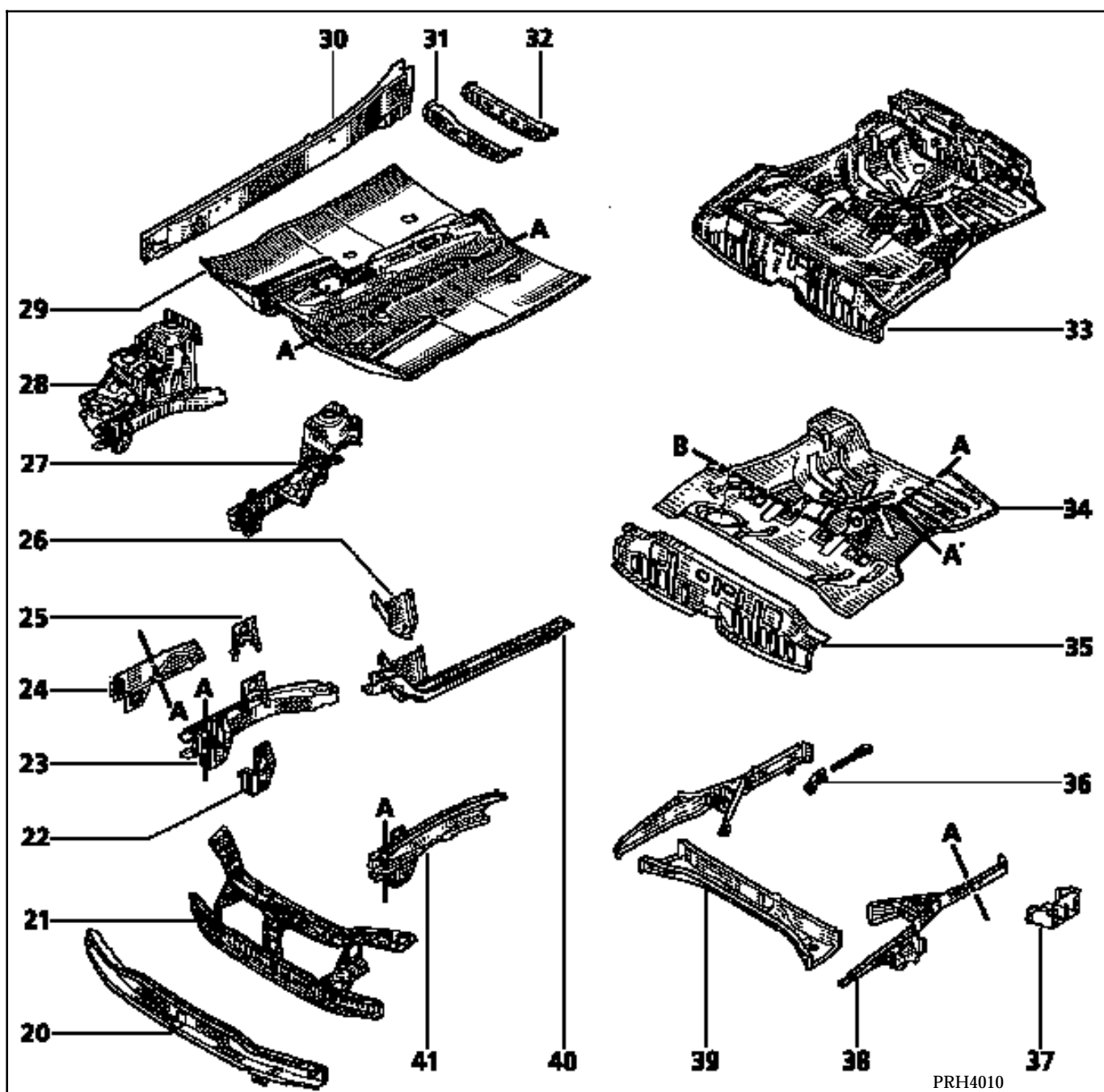
40

	Chiselling		Plug welding. Under MIG gas protection.
	Grind back beads or spot welds Straight grinding wheel with 75 mm diameter bakelite impregnated disc, thickness 1.8 mm to 3.2 mm.		Crimping of exterior door panels.
	Grind back spot welds 20 000 rpm. straight grinder with 10 or 16 mm spherical burr.		Safety symbol. This means that the welding operation in question concerns one or more of the vehicle's safety components.
	Drill spot welds Hardened steel bit. Speed of rotation 800 to 1 000 rpm.		Body solder - lead fill. Hot air torch. Nozzle output temperature 600° min. BAT+ 33% tin solder + tallow <b>Note :</b> to a large extent, body solder filling compensates for the heat distortion caused by welding.
	Unpicking		Application of weldable mastic. This mastic conducts electricity. Applied between two panels to be spot welded, it ensures the seal between the panels and avoids corrosion of the spot welds.
	Clean the surfaces to be welded 100 mm diameter fibre disc.		Application of aluminium paint. This is to be applied to the joint faces of each of the parts to be plug welded. The paint conducts electricity and is resistant to high temperatures; it provides anti-corrosion protection around the plug welds.
	Cutting with a saw Pneumatic power hacksaw.		Apply a fillet of extruded mastic <ul style="list-style-type: none"> <li>• from a manual or pneumatic gun</li> <li>• one or two pot mastic for crimped or butt joints.</li> </ul>
	<ul style="list-style-type: none"> <li>- Cutting out part by grinding off flange or grinding back remaining traces of spot weld.</li> <li>- Finish surface after welding.</li> <li>- Angle grinder equipped with a rubber pad and a 120 to 180 mm fibre disc grain size P36</li> </ul>		Spray on sealer <ul style="list-style-type: none"> <li>• spray gun</li> <li>• two pot anti-gravel and anti-corrosion mastic.</li> </ul>
	Unsolding.		
	MIG stitch weld <b>Note :</b> for a high quality weld we recommend the use of a gas consisting of argon + 15% CO <sub>2</sub> . This is considered to be an active gas (MAG). For UK = MIG.		
	Spot welding		

# GENERAL

## Description of parts (exploded view)

40



- 20 Front end lower cross member
- \*21 Complete front panel
- 22 Front mounting of front sub-frame
- \*23 Right hand side front side member
- \*23A Front side member (cut A)
- \*24 Front side member closure panel
- \*24A Front side member closure panel (cut A)
- 25 Engine mounting reinforcement
- \*26 Front side cross member
- \*27 Left hand side front half unit
- \*28 Right hand side front half unit
- 29 Centre floor
- 29A Centre floor, part section
- \*30 Sill panel closure panel

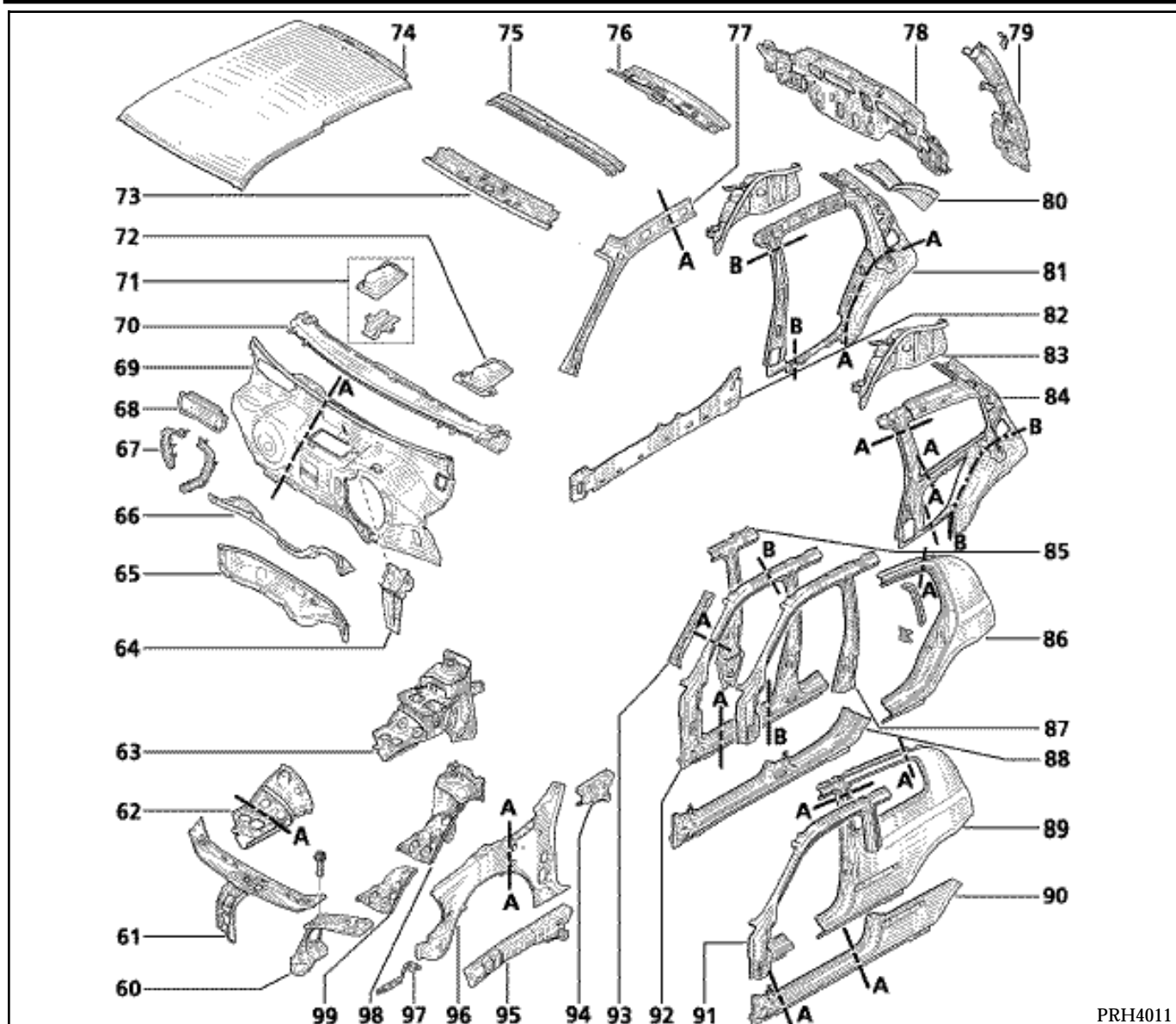
- 31 Front cross member of front seat
- 32 Rear cross member of front seat
- \*33 Rear floor unit
- 34 Rear floor
- 34AA' Rear floor (cut AA')
- 34BA Rear floor (cut BA)
- 35 Front cross member of rear floor (cross member)
- \*36 Lashing ring mounting
- \*37 Exhaust mounting support
- \*38 Rear side member
- \*38A Rear side member (cut A)
- \*39 Rear centre cross member
- \*40 Rear section of front side member
- \*41 Left hand side front side member

\* Part which must be subject to electro zinc plating of the repaired areas.

# GENERAL

## Description of parts (exploded view)

40



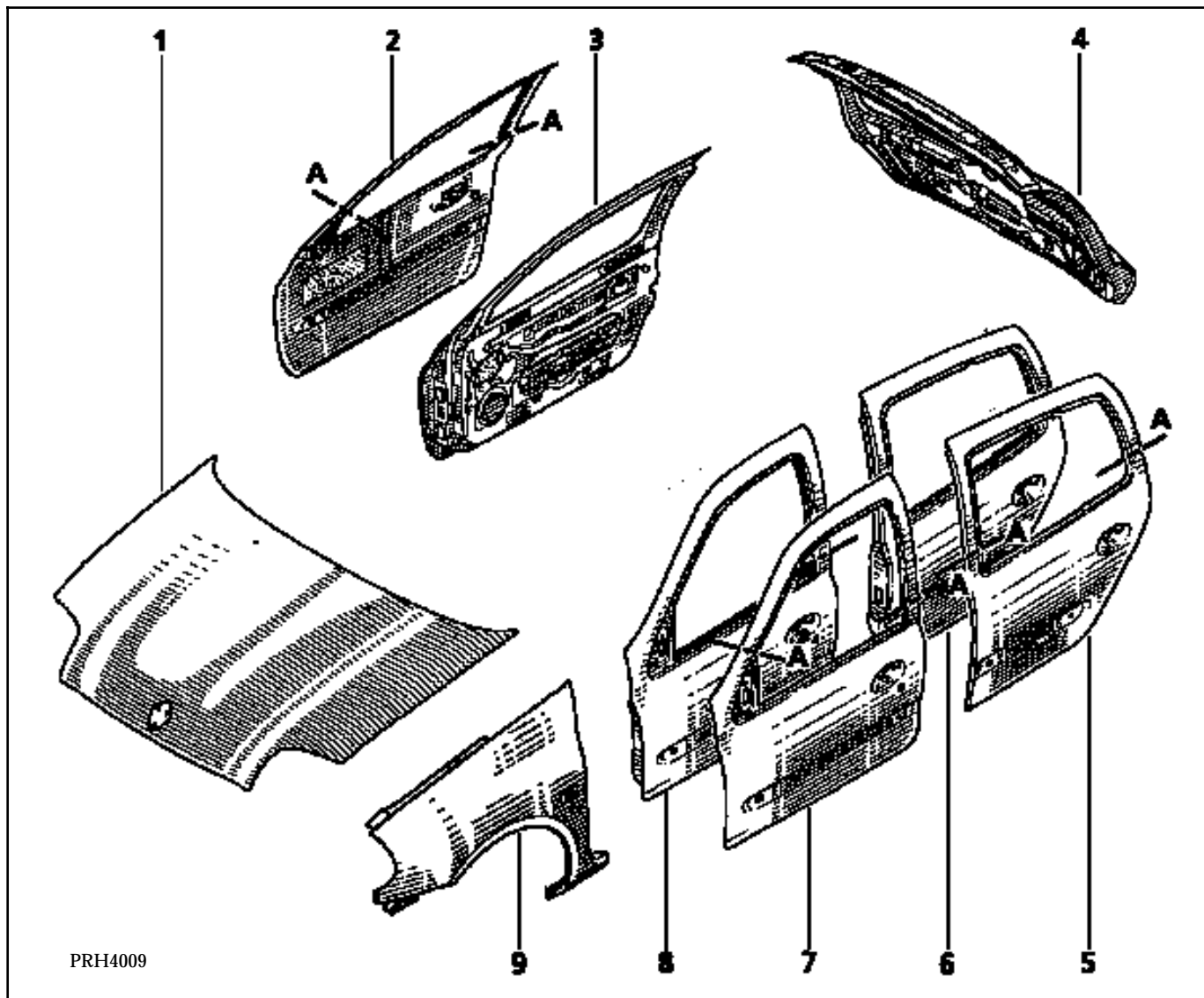
PRH4011

- |       |  |       |  |
|-------|--|-------|--|
| *60   | Headlight carrier panel                      | 81BB  | Centre pillar lining (version B)             |
| *61   | Upper front cross member                     | *82   | Sill panel reinforcement                     |
| *62A  | Right hand wheel arch, front section         | *83   | Inner wheel arch                             |
| *63   | Right hand wheel arch, complete              | *84   | Rear quarter panel lining (version C)        |
| *64   | Screen wiper mounting                        | *84AA | Centre pillar lining (version C)             |
| *65   | Plenum chamber closure panel                 | *84BB | Outer wheel arch (version C)                 |
| *66   | Plenum chamber, centre section               | 85    | Centre pillar reinforcement                  |
| *67   | Double pedal mounting                        | *86   | Wing panel (version VB)                      |
| 68    | Bulkhead blanking cover without AC           | *87   | Top of body (version B)                      |
| 69A   | Bulkhead (cut A)                             | *88   | Sill panel (version B)                       |
| *70   | Windscreen aperture lower cross member       | *89   | Wing panel (version C)                       |
| 71    | Right hand drive steering column mounting    | *89AA | Wing panel (version C)                       |
| 72    | Left hand drive steering column mounting     | *90AA | Sill panel under door                        |
| 73    | Roof front cross member                      | *91   | Top of body (version C)                      |
| 74    | Roof   | *92   | Body side, front section                     |
| 75    | Roof centre cross member                     | *92AA | Front pillar (versions B and C)              |
| 76    | Roof rear cross member                       | *92BB | Centre pillar (version B)                    |
| 77    | Windscreen aperture pillar lining(version B) | *93   | Double thickness joint support               |
| 77A   | Windscreen aperture pillar lining(version C) | *94   | Cowl side panel reinforcement, rear section  |
| *78   | Rear end panel                               | *95   | Cowl side panel reinforcement, front section |
| *79   | Lights mounting panel                        | *96   | Cowl side panel                              |
| *80   | Wing panel upper rain channel                | *96AA | Front pillar lining                          |
| *81   | Rear quarter panel lining (version B)        | *97   | Bumper mounting                              |
| *81AA | Outer wheel arch (version B)                 | *98   | Left hand wheel arch, complete               |
|       |  | *99   | Left hand wheel arch, front section          |

\*Part which must be subject to electro zinc plating of the repaired areas.

**GENERAL**  
**Description of parts (exploded view)**

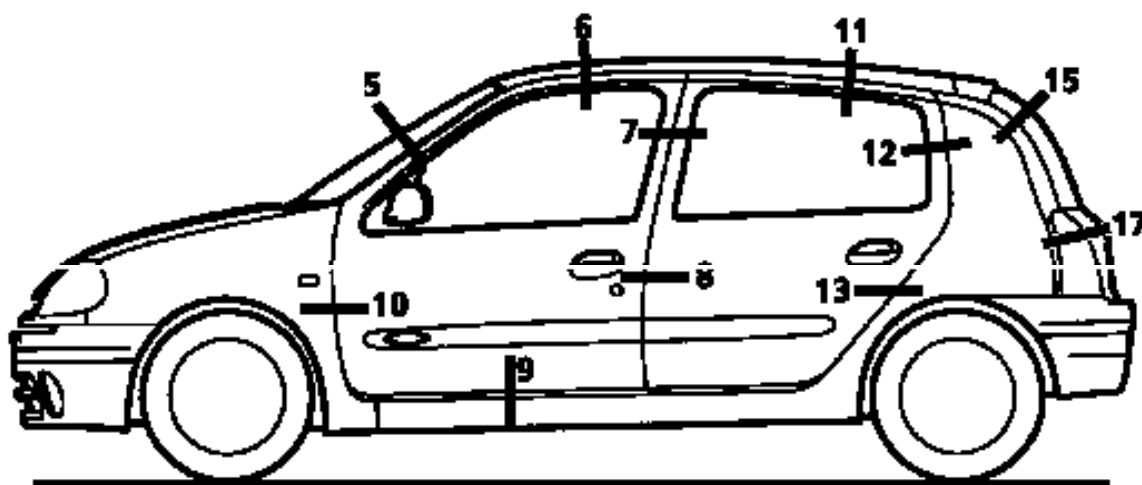
**40**



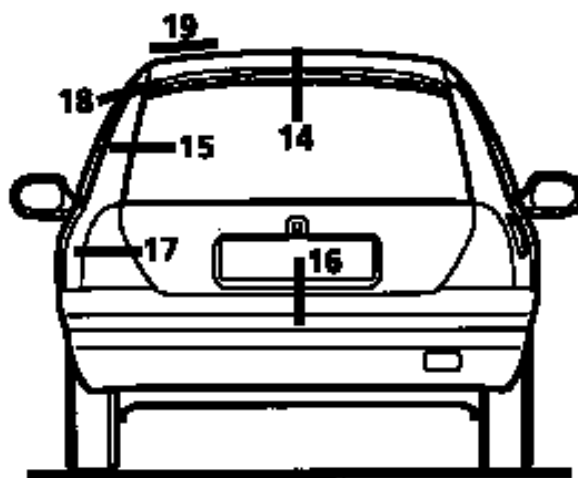
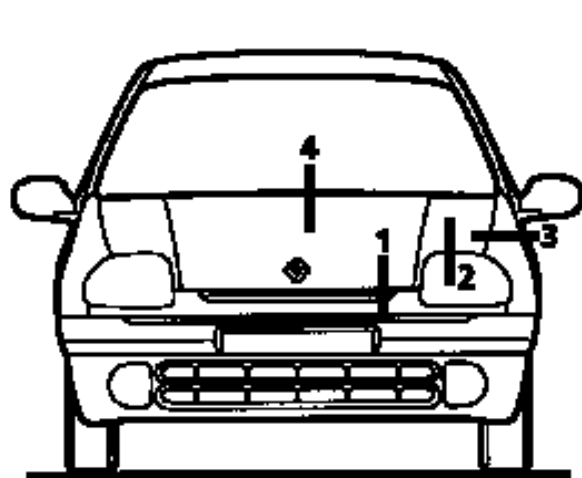
- \* 1 Bonnet
- \* 2 Front door panel (2 doors) along cut A
- \* 3 Front door (2 doors)
- \* 4 Rear tailgate
- \* 5 Rear door panel along cut A
- \* 6 Rear door
- \* 7 Front door panel (4 doors) along cut A
- \* 8 Front door (4 doors)
- \* 9 Front wing

\* Part which must be subject to electro zinc plating of the repaired areas.





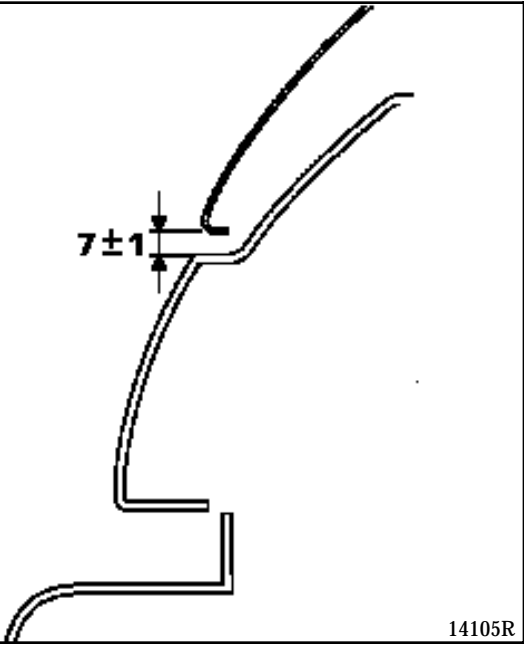
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13491R1

1

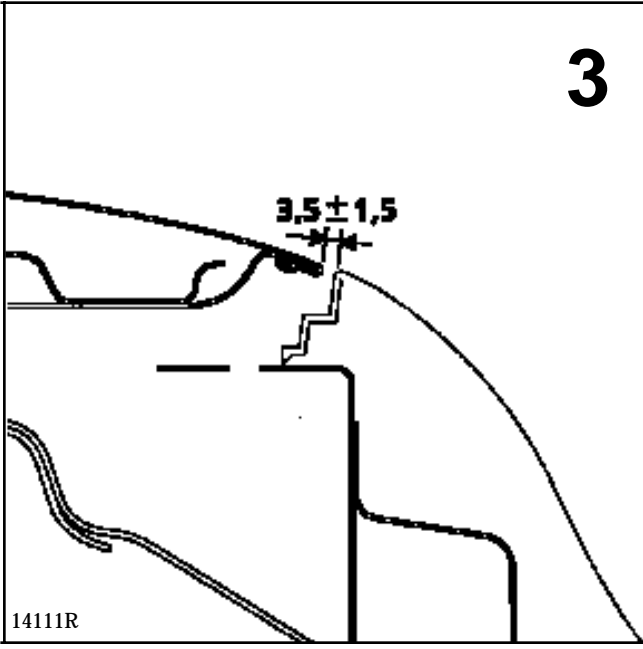
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14105R

3

$3,5 \pm 1,5$



14111R

2

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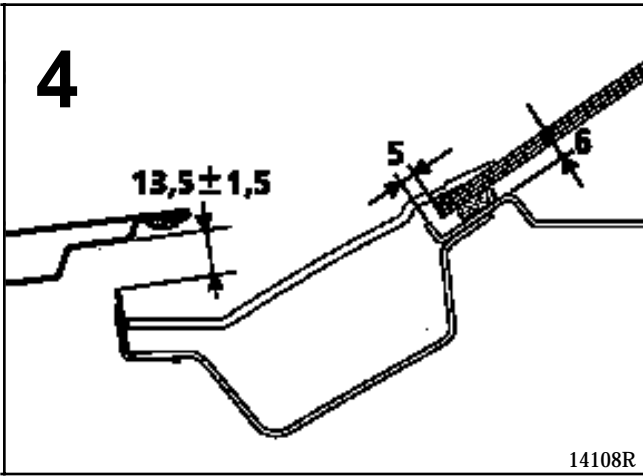


$3 \pm 1$

14106R

4

$13,5 \pm 1,5$



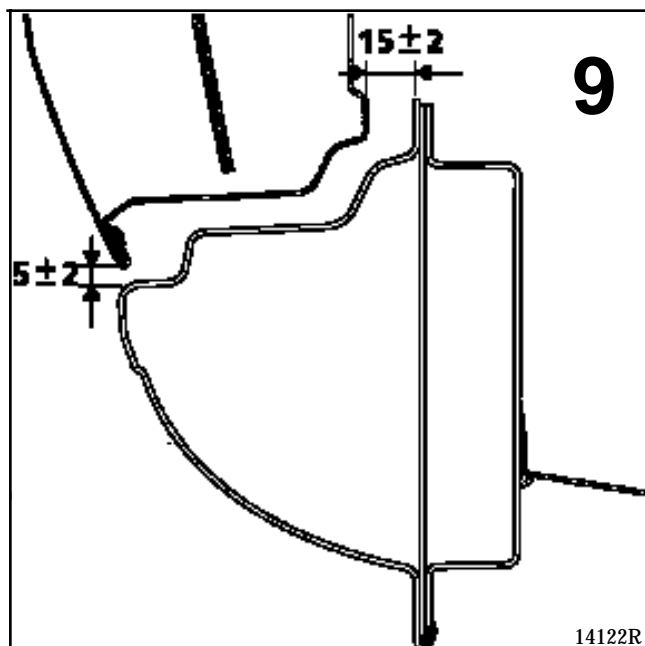
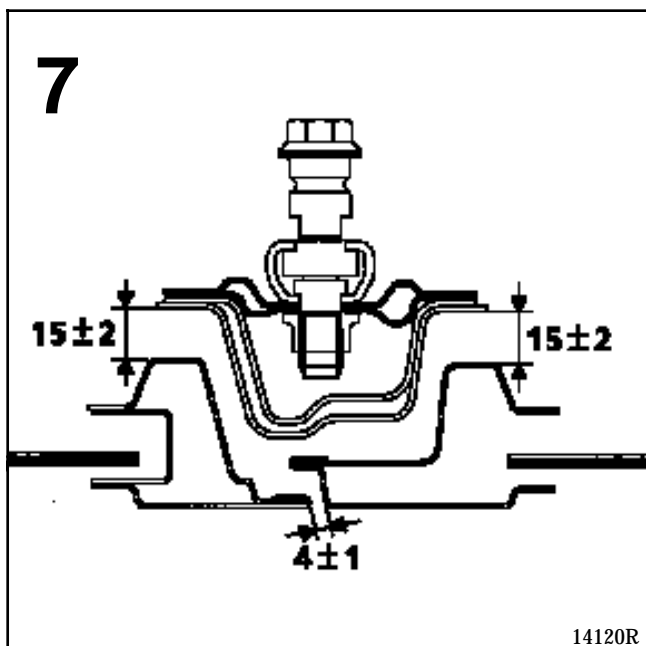
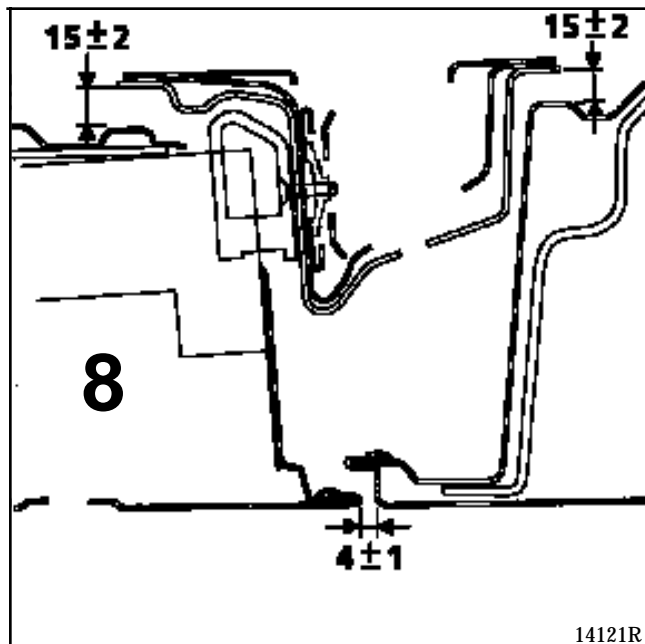
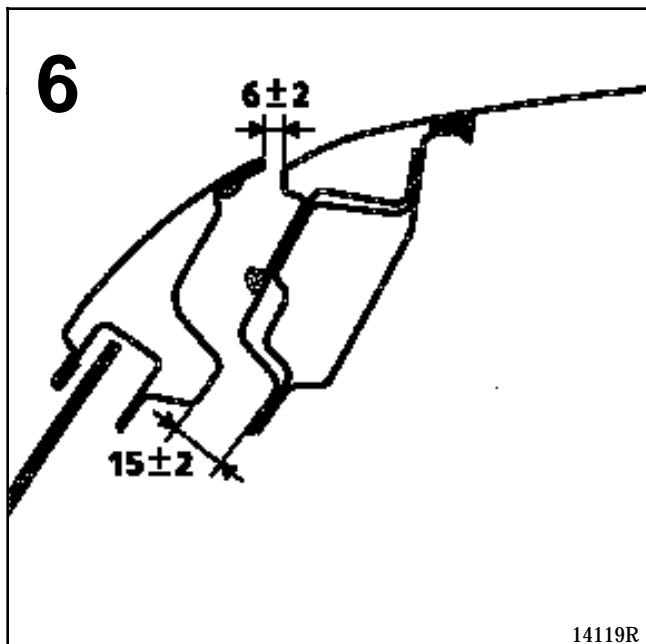
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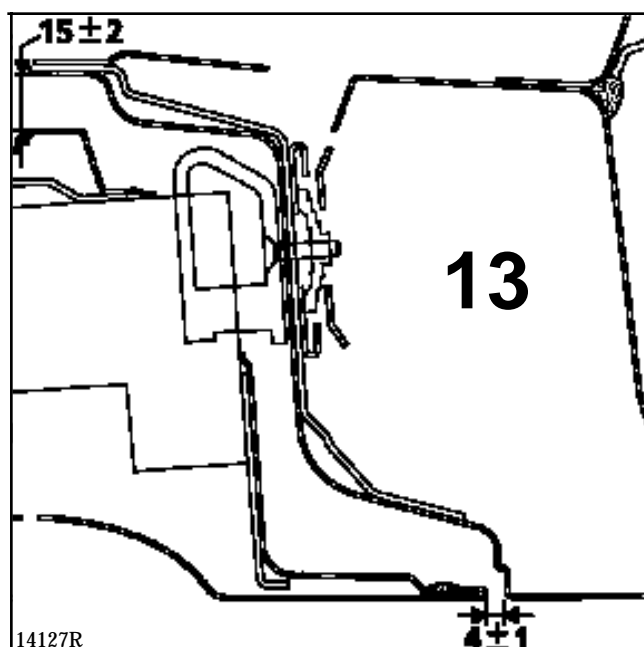
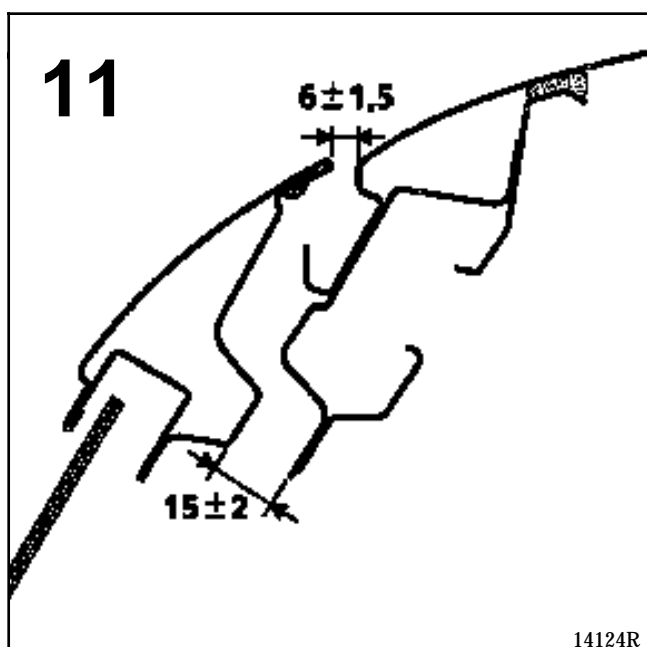
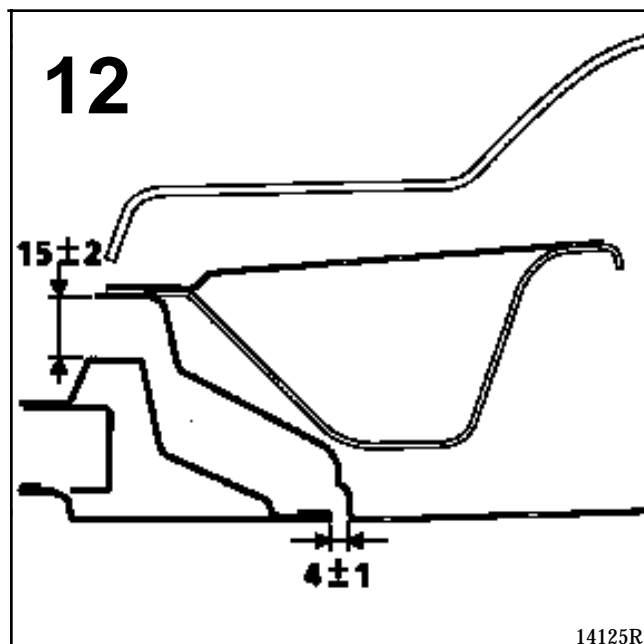
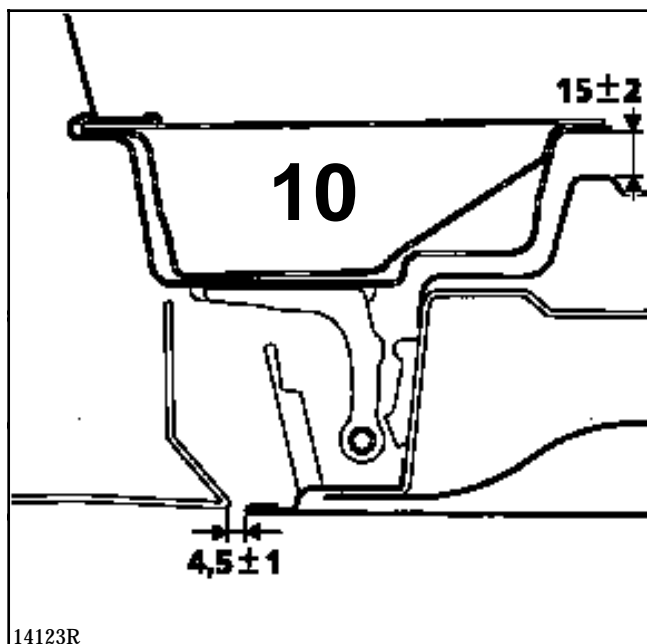
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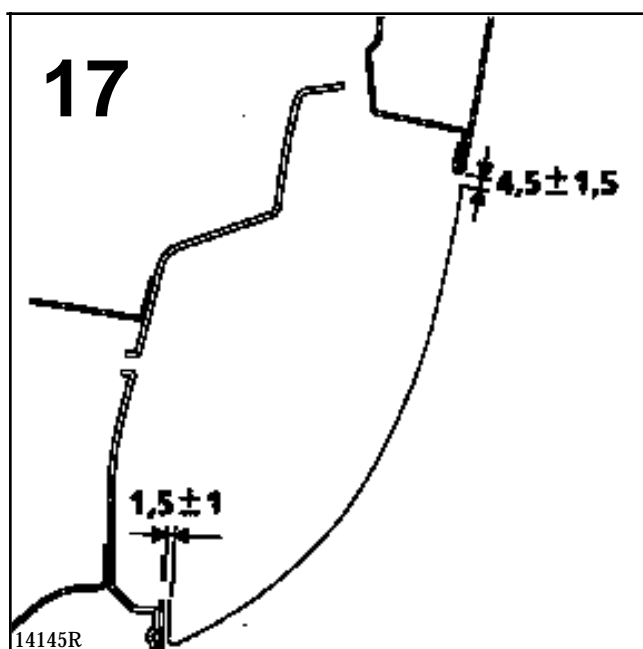
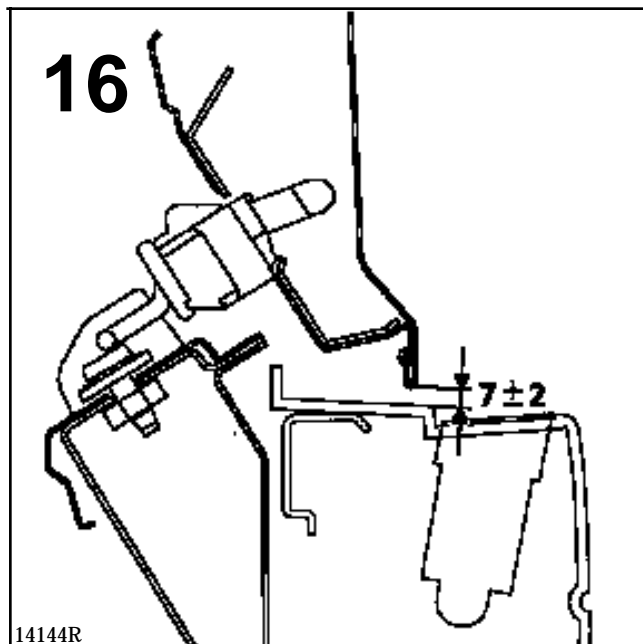
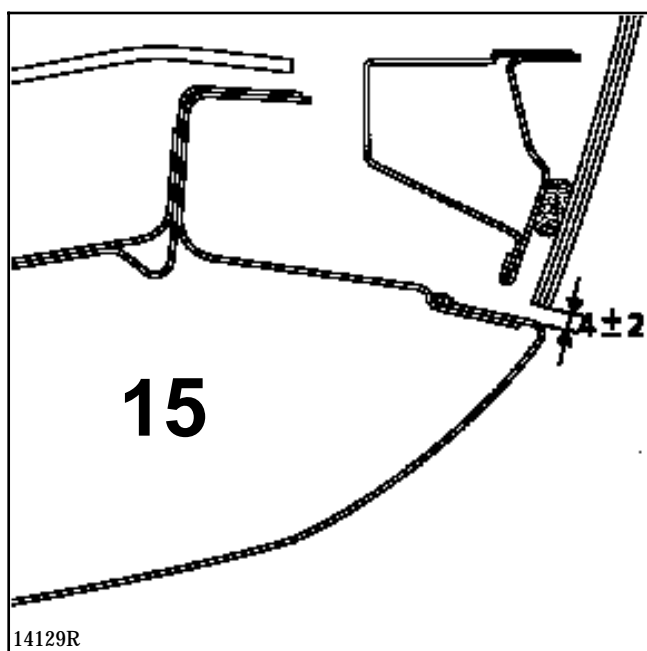
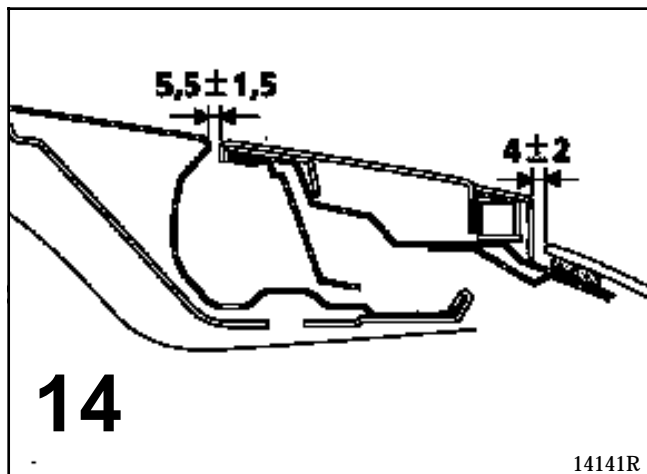
$9$   
 $6$   
 $6$   
 $6$   
 $15 \pm 2$

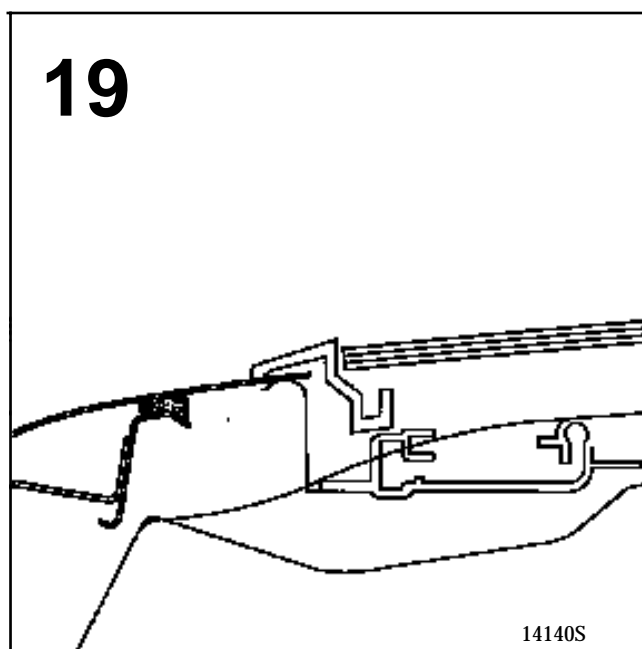
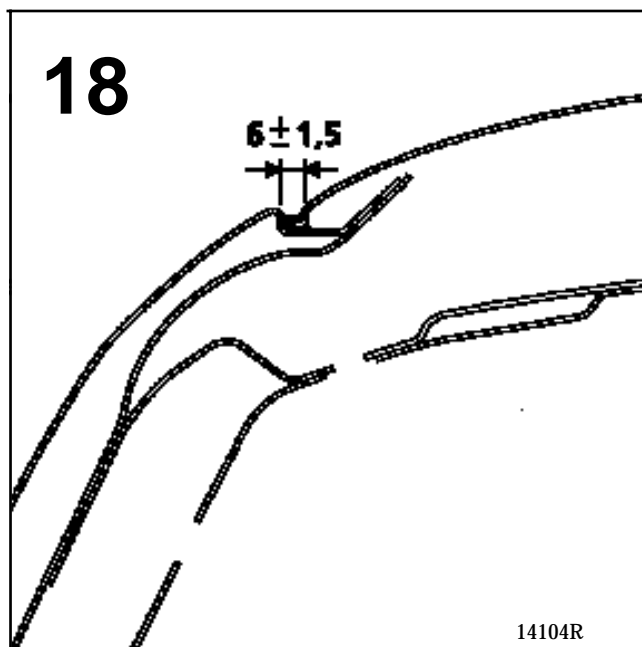


14118R

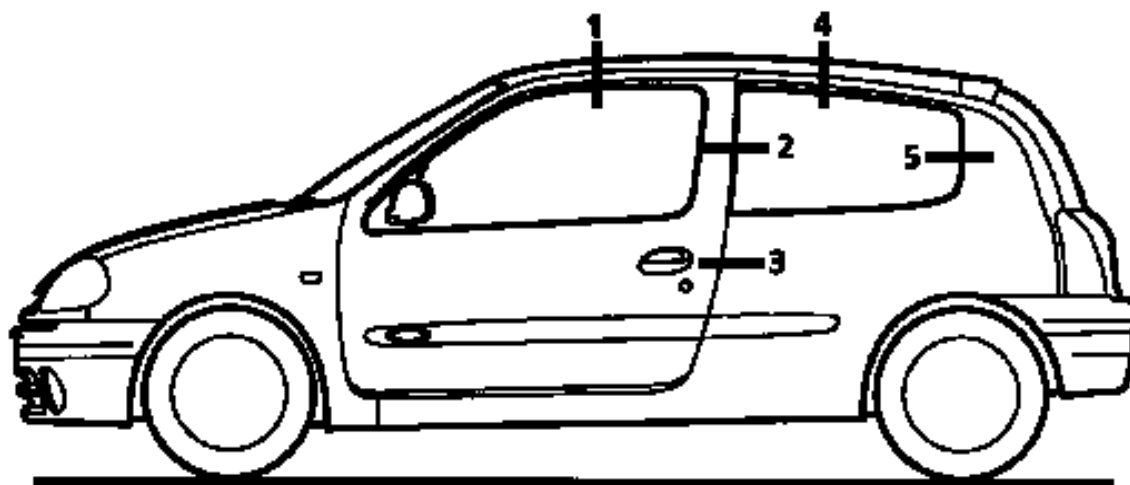




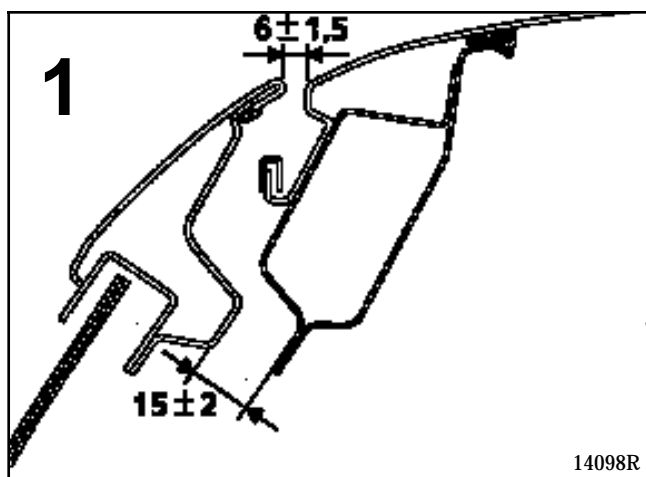




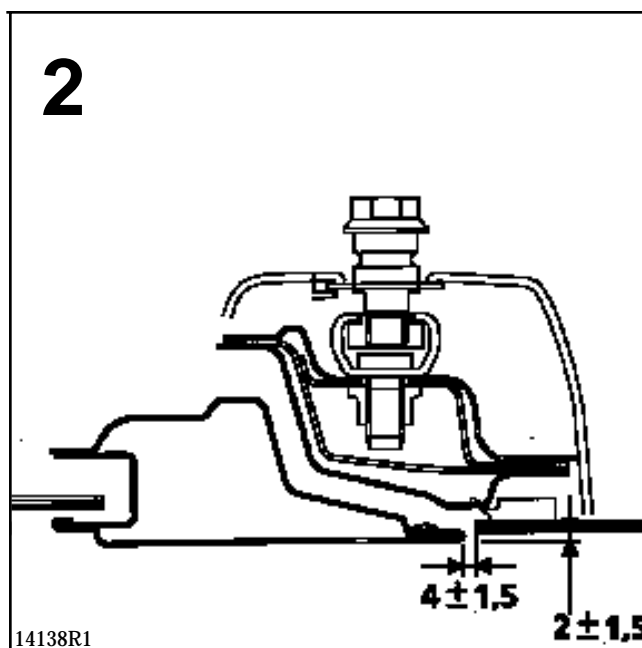
Section view of sun roof



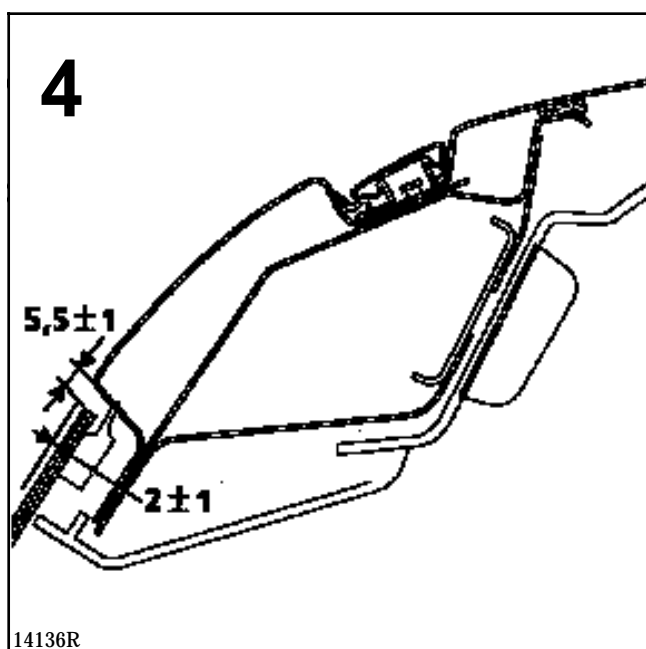
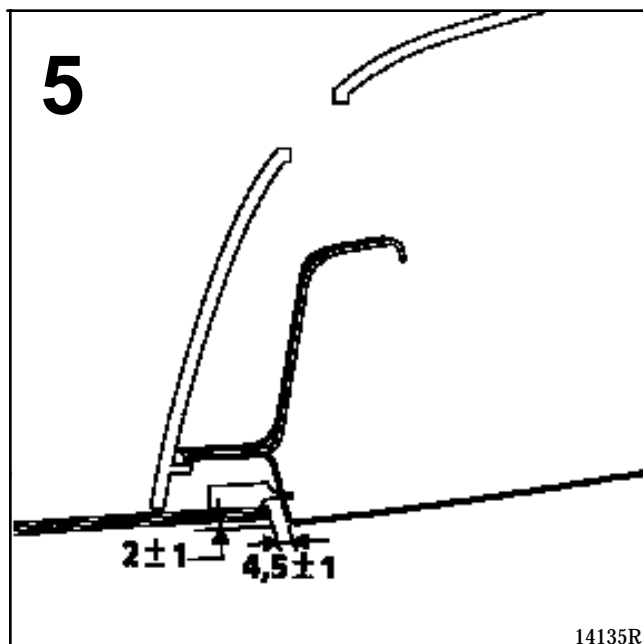
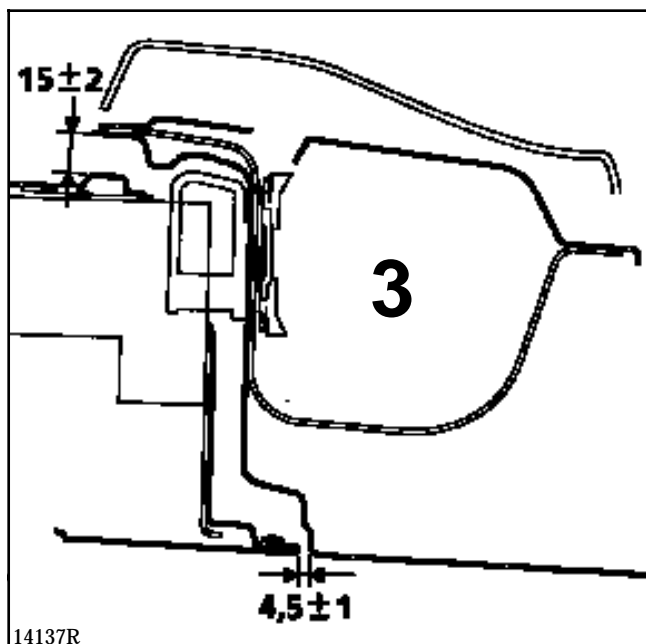
13491-1R1



14098R



14138R1





Before carrying out repairs to the bodywork of a car, even if the damage seems slight, it is necessary to carry out a series of tests :

- **VISUAL INSPECTION**

This inspection involves the examination of the sub-frame of the vehicle where mechanical components are mounted and in the crumple zones or vulnerable areas in order to detect folds where materials have been deformed.

- **INSPECTION USING TRAMMEL GAUGE**

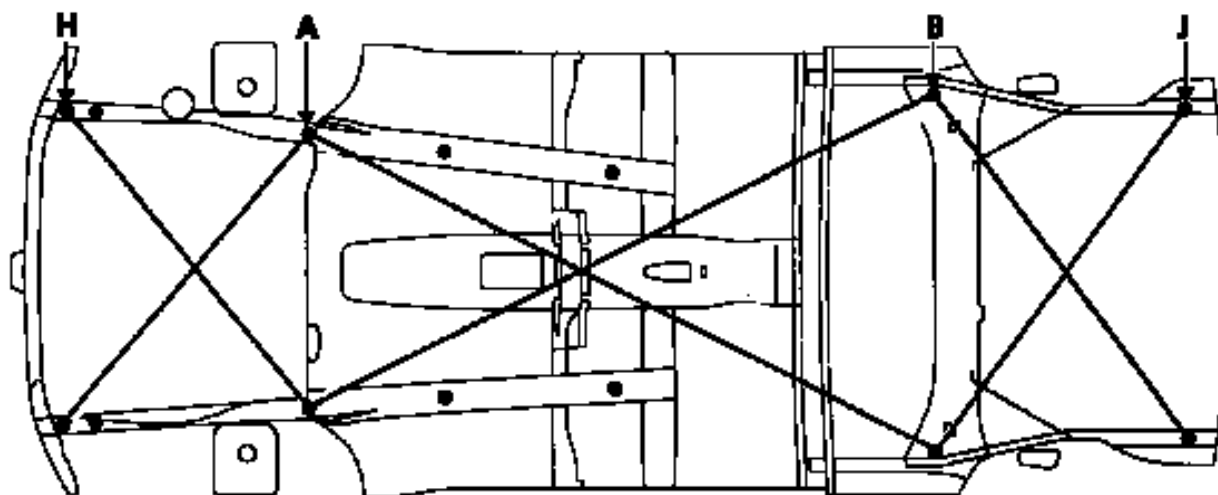
The visual inspection may be completed using a trammel gauge which will allow measurement of certain deformations by symmetrical comparisons (for more detail on each point to check, refer to the repair bench paragraph below).

- **INSPECTION OF AXLE ASSEMBLY GEOMETRY**

It is the only check which determines whether the impact suffered by the vehicle has or has not affected its road holding.

**Important :** In borderline cases, it is essential not to neglect checking the axle assembly components which may also have been subject to deformation.

On principle, no welded component in the body shell may be replaced without ensuring that the sub-frame was not affected by the impact.

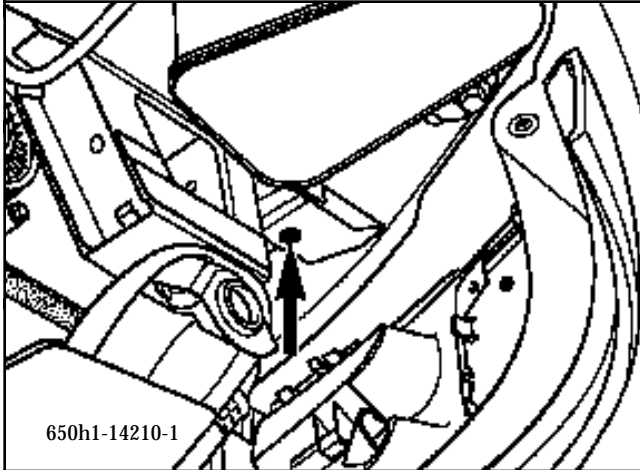


14147R

**GAUGE POINTS**

**Point H :**

Front end of front side member.

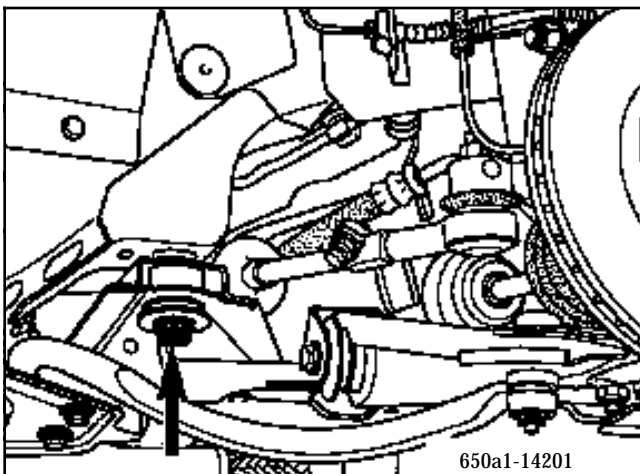


**Point A :**

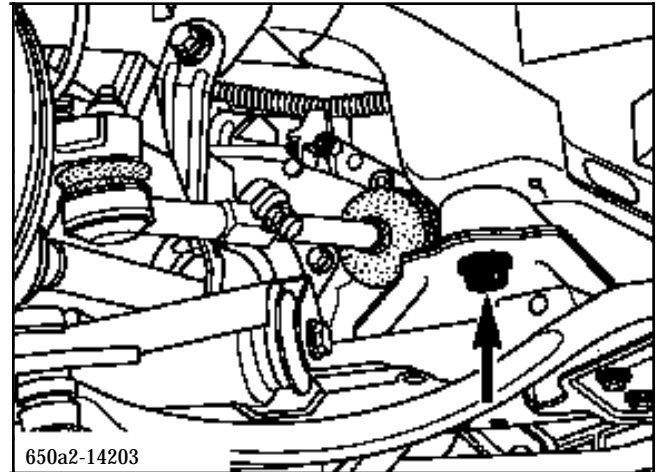
Rear mounting of front sub-frame.

The starting point for a rear impact.

**Right hand side**



**Left hand side**

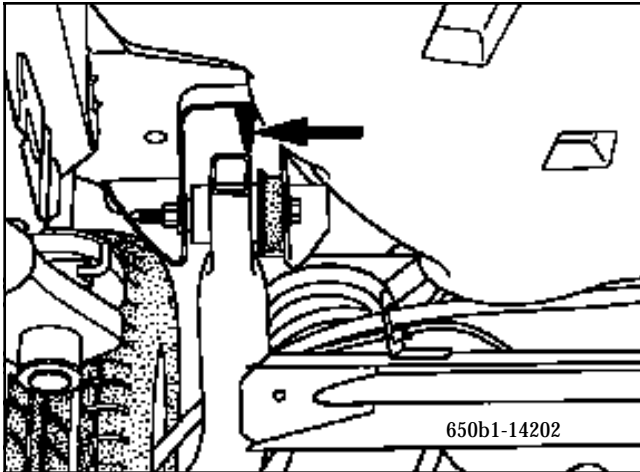


### Point B :

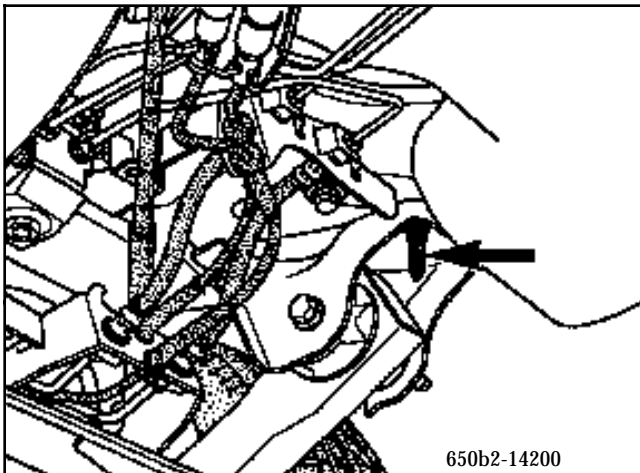
Front point of rear axle assembly.

The starting point for a frontal impact.

Right hand side



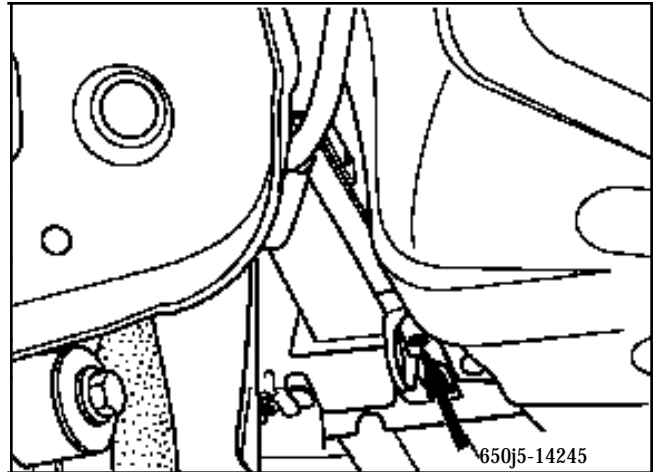
Left hand side



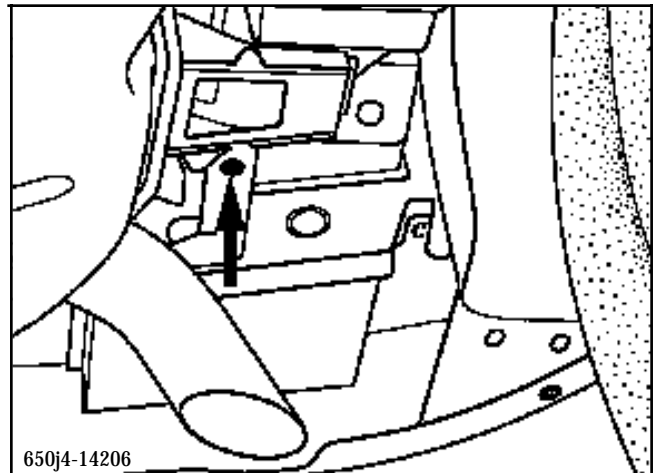
### Point J :

Rear end of rear side member.

Right hand side



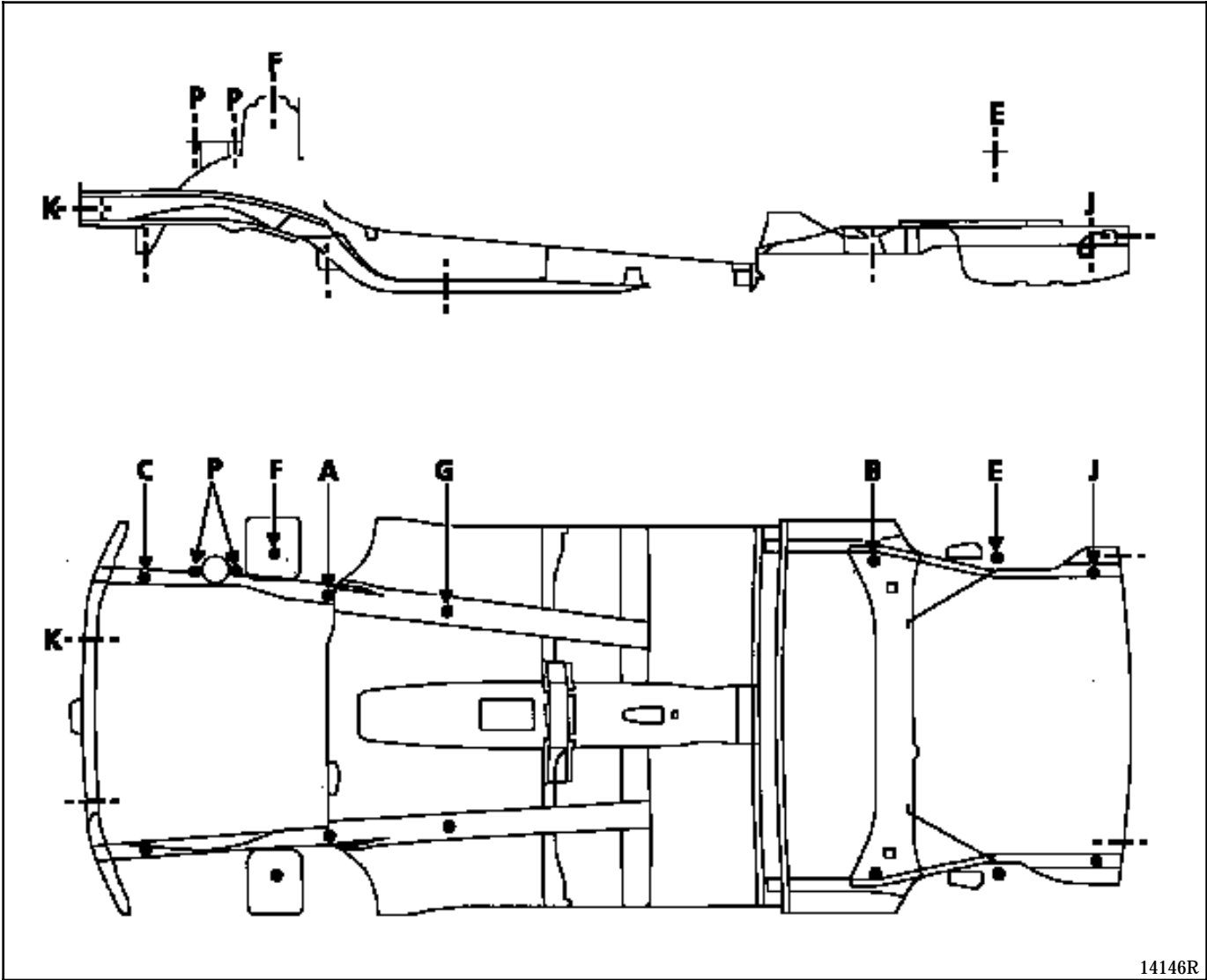
Left hand side



**GENERAL**  
**Sub-frame dimensions**

**40**

	DESCRIPTION	X	Y	Z	DIAMETER	ANGLE %
A	Front sub-frame rear mounting	205	402.5	71	18.5	0
B	Rear axle assembly front mounting	2 012	530	129	16.2	0
C	Left hand front mounting of front sub-frame	- 418	447	130	10×10 (squared)	0
	Right hand front mounting of front sub-frame	- 418	465	130	10×10 (squared)	0
E	Rear shock absorber upper mounting	2 448.5	534.5	477.5	18.2	0
F	Front shock absorber upper mounting	18.5	545.50	657	48	X : 3°02 Y : 1°
G	Rear section of front left side member	600	375	- 3.7	20×20 (squared)	0
	Rear section of front right side member	600	351.6	- 5	20×20 (squared)	0
J	Rear point of rear right side member	2 791	496.5	182	10.7	0
	Rear point of rear left side member	2 790	481	162.5	10.2	0
K	Front cross member	- 575	315	280	14.25	X : 4°30 Z : 5°
	Rear end cross member, left hand side (rear end panel)	2 879	- 420	200	12×16	X : 10°
P	Front engine mounting	- 247	483.5	514	M10	0
	Rear engine mounting	- 113	483.5	514	M10	0



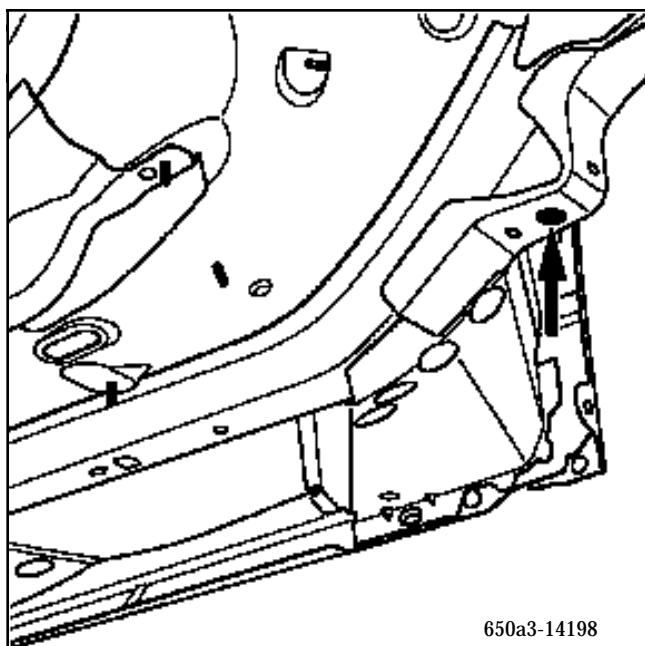
14146R

## I - PRINCIPLE REFERENCE POINTS FOR SETTING VEHICLE TRIM LEVEL

### A - FRONT SUB-FRAME REAR MOUNTING

It is the principle front reference point.

#### 1 - Front mechanical units removed



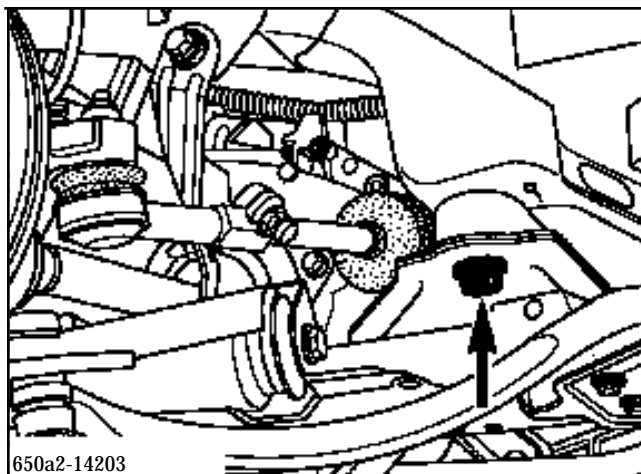
The bracket rests against the rear section of the side member and is centred in the sub-frame mounting hole.

#### NOTE :

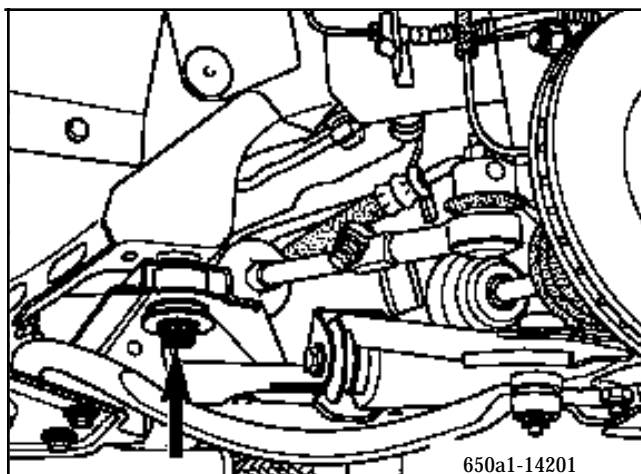
- on the left hand side, the hole is round,
- on the right hand side it is a slot.

#### 2 - Front mechanical units in place

##### Left hand side



##### Right hand side



The bracket covers the sub-frame mounting bolt and rests against the mounting bolt washer.

**NOTE :** The two sides are not symmetrical, on the right hand side the mounting is set on the rubber mounting.

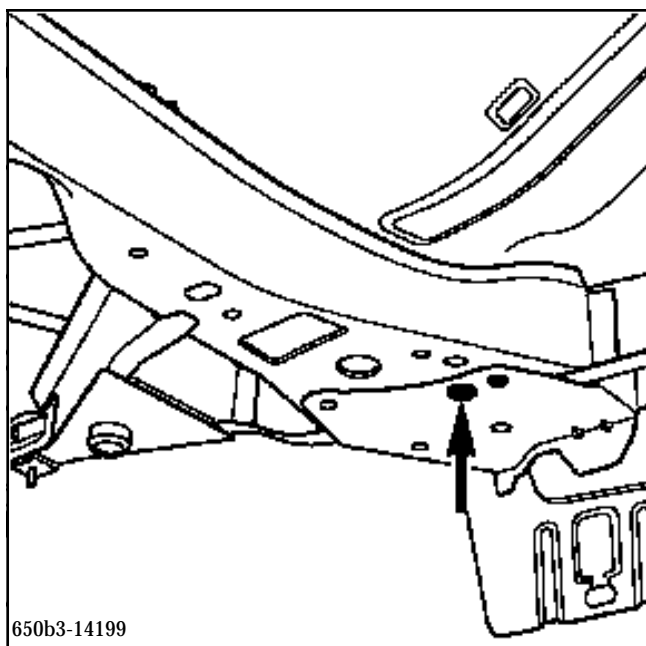
If the rear of the vehicle is being rebuilt, these two points alone may be used to align and support the front of the vehicle.

## I - PRINCIPLE REFERENCE POINTS FOR SETTING VEHICLE TRIM LEVEL (cont)

### B - FRONT POINT OF REAR AXLE ASSEMBLY

It is the main rear reference point.

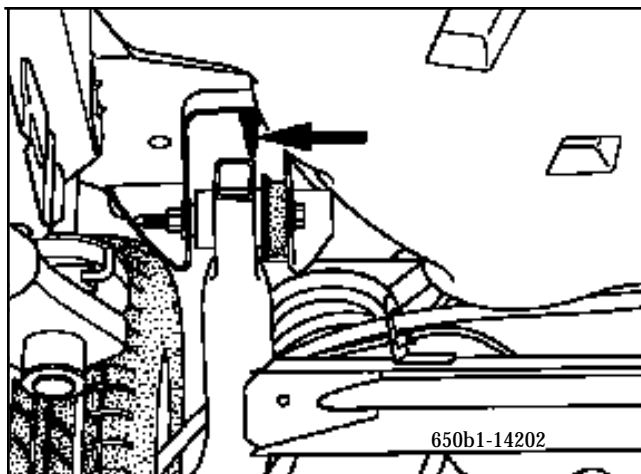
#### 1 - Rear mechanical units removed



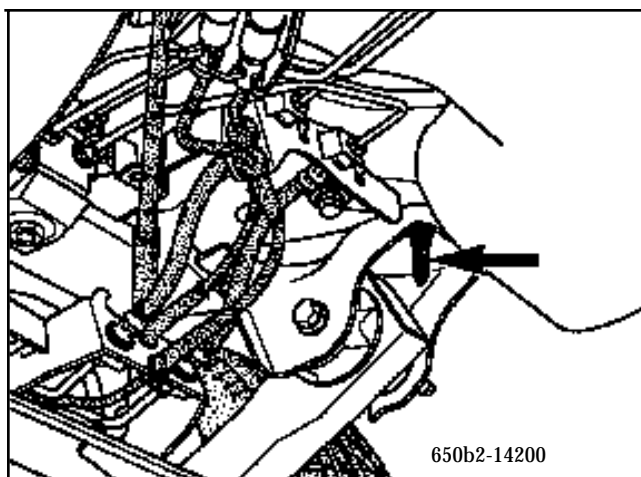
The bracket rests under the side cross member of the rear axle assembly front mounting and is centred in the control unit hole .

#### 2 - Rear mechanical units in place

##### Right hand side



##### Left hand side



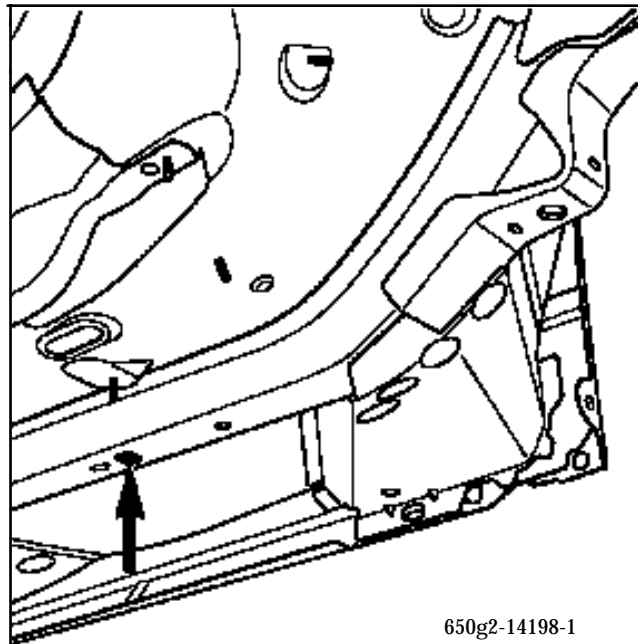
The bracket rests under the rear axle assembly bearing and covers the front mounting nut of the rear axle assembly.

If the front section is being rebuilt, these two points alone can be used to align and support the rear of the vehicle.

## II - ADDITIONAL REFERENCE POINTS FOR SETTING VEHICLE TRIM LEVEL

These are the provisional reference points which replace the main ones, when they have been affected by the impact.

### G - FRONT SIDE MEMBER, REAR SECTION



This point is also used as a positioning reference when replacing a rear section of the front side member.

On the impact side, this point allows the vehicle to be additionally supported with a main reference point on the opposite side.

**NOTE :** these points should only be used in the circumstances quoted, there is no need to use them when the main reference points (points A and B) are correct.

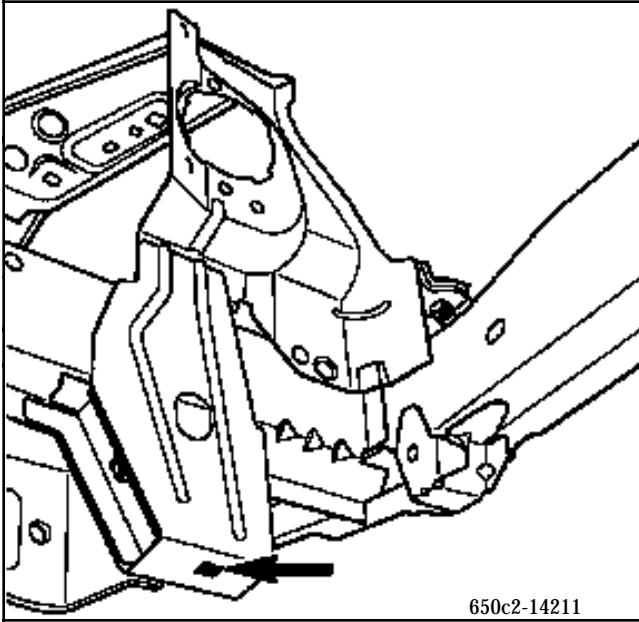
This additional reference function may also be filled by the front side member ends check points for a rear impact and vice versa.



## III - REFERENCE POINTS FOR POSITIONING REPLACED PARTS

### C - FRONT SUB-FRAME FRONT MOUNTING

#### 1 - Front mechanical units removed

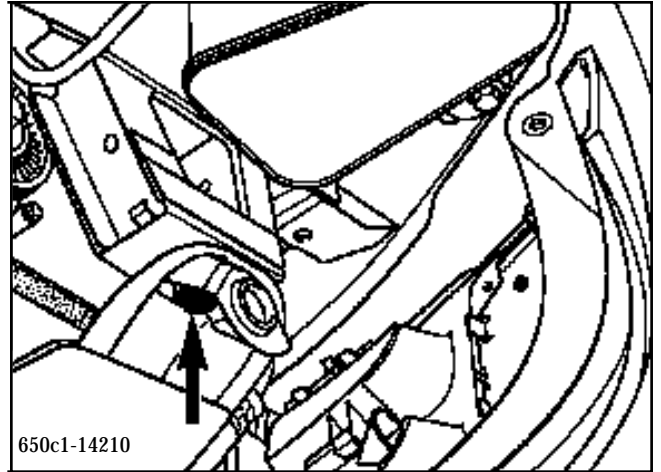


The bracket rests under the sub-frame front mounting and is centred in the hole with the mounting bolt.

It is used when replacing :

- a front end cross member,
- a side member, part section,
- a half unit.

#### 2 - Front mechanical units in place



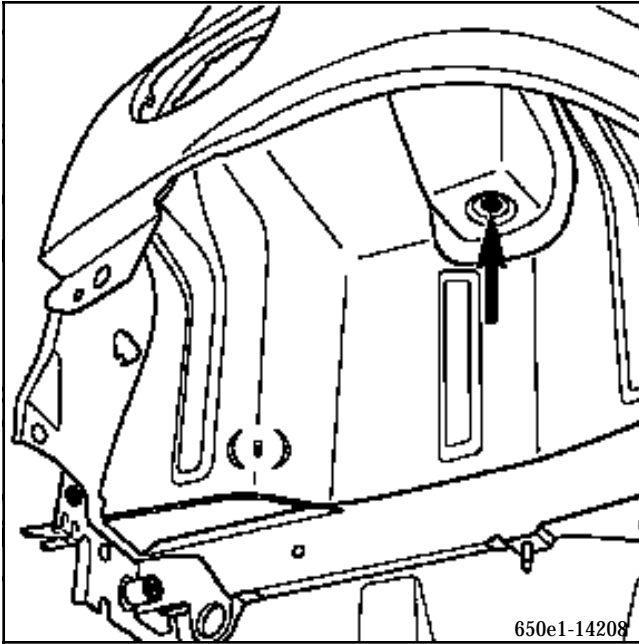
The bracket covers the sub-frame mounting bolt and washer.

It is used:

- following a frontal collision for a slight impact,
- for fault finding for the gauge inspection of the front section .

## III - REFERENCE POINTS FOR POSITIONING REPLACED PARTS (cont)

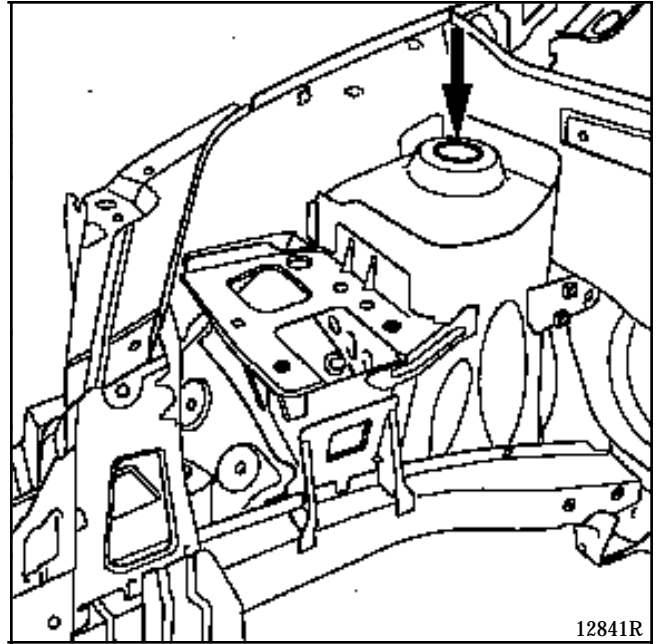
### E - REAR SHOCK ABSORBER UPPER MOUNTING



The bracket is fitted at the shock absorber cup and positions this mounting when replacing a wheel arch.

It is also used when straightening.

### F - FRONT SHOCK ABSORBER UPPER MOUNTING



The bracket rests under the shock absorber cup and is centred in the shock absorber mounting hole.

It is used when replacing :

- wheel arches,
- a front half unit.

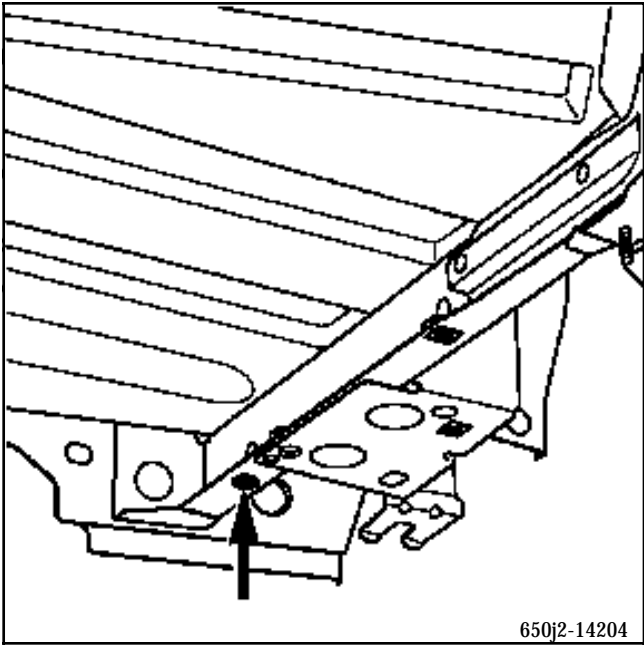
It is also used when straightening.

**III - REFERENCE POINTS FOR POSITIONING REPLACED PARTS (cont)**

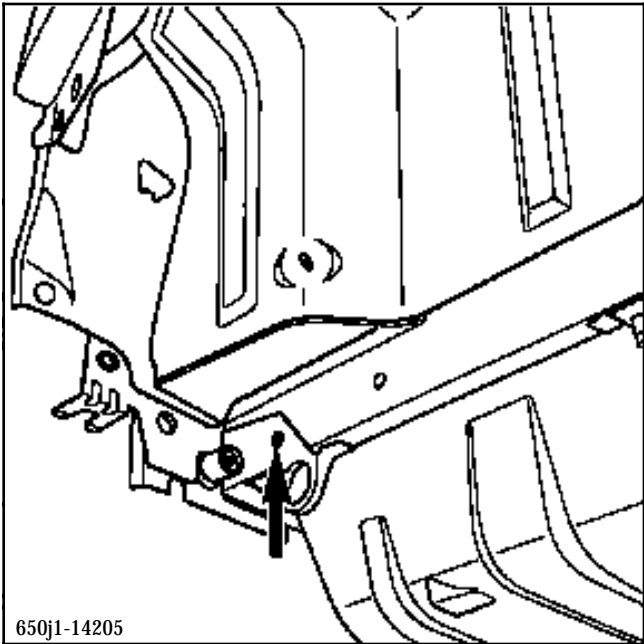
**J - REAR END OF REAR SIDE MEMBER**

**1- Without mechanical units**

**Left hand side**

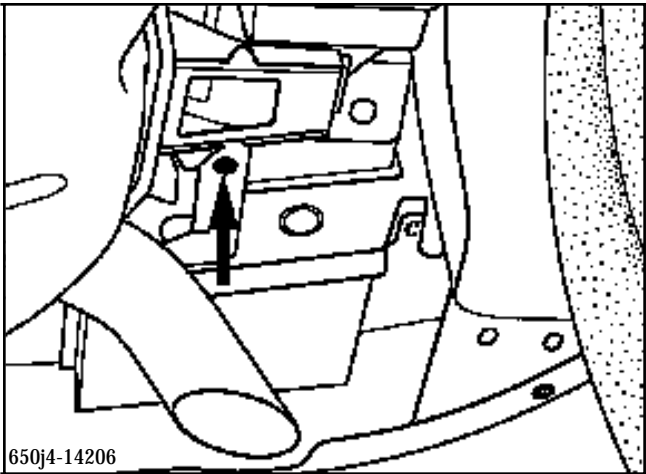


**Right hand side**

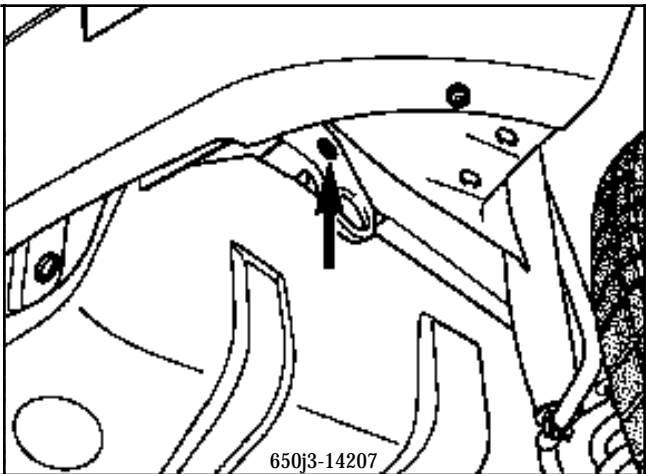


**2- With mechanical units**

**Left hand side**



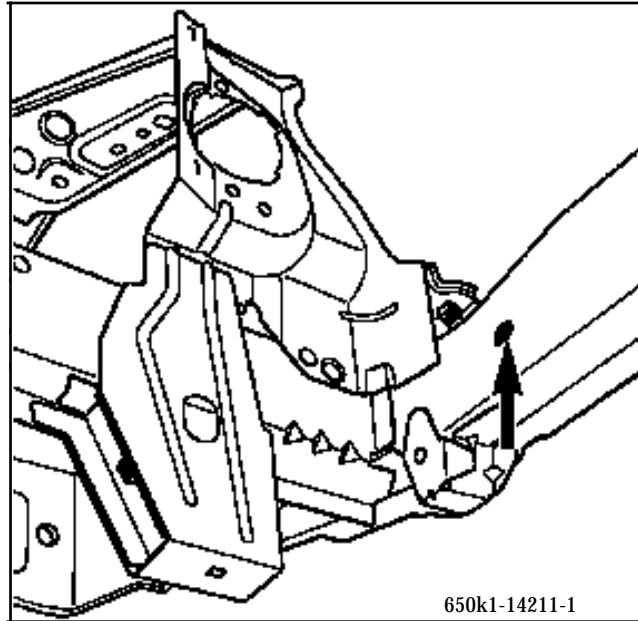
**Right hand side**



It may be used for a slight rear impact without removing the rear axle assembly.

## III - REFERENCE POINTS FOR POSITIONING REPLACED PARTS (cont)

### K - FRONT END CROSS MEMBER



The bracket helps with the fitting of the front cross member and rests vertically against the front end cross member, then it is centred by a centring bolt at (K).

#### 1 - Front mechanical units removed

It is used for replacing the front end cross member, with or without mechanical units.

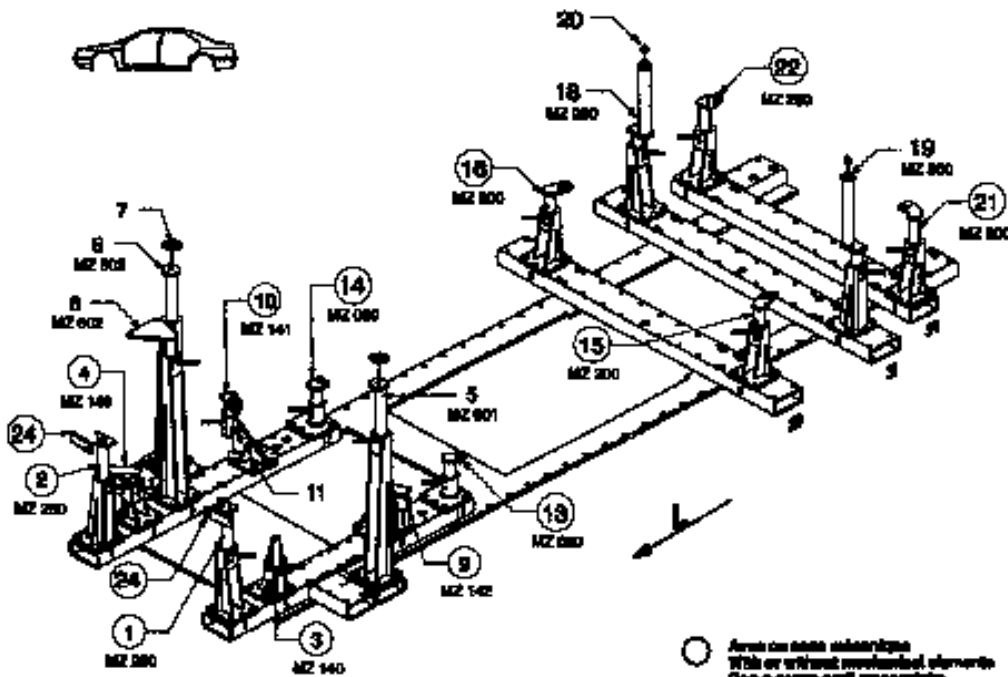
**NOTE :** The operation for replacing the front end cross member can be carried out without the removal of the engine and transmission assembly, but requires the removal of the radiator.

#### 2 - Front mechanical units in place

The bracket helps with fault finding on the front cross member.

This requires the removal of the plastic protective shield located between the bumper and the engine sub-frame.

## CELETTE REPAIR BENCH

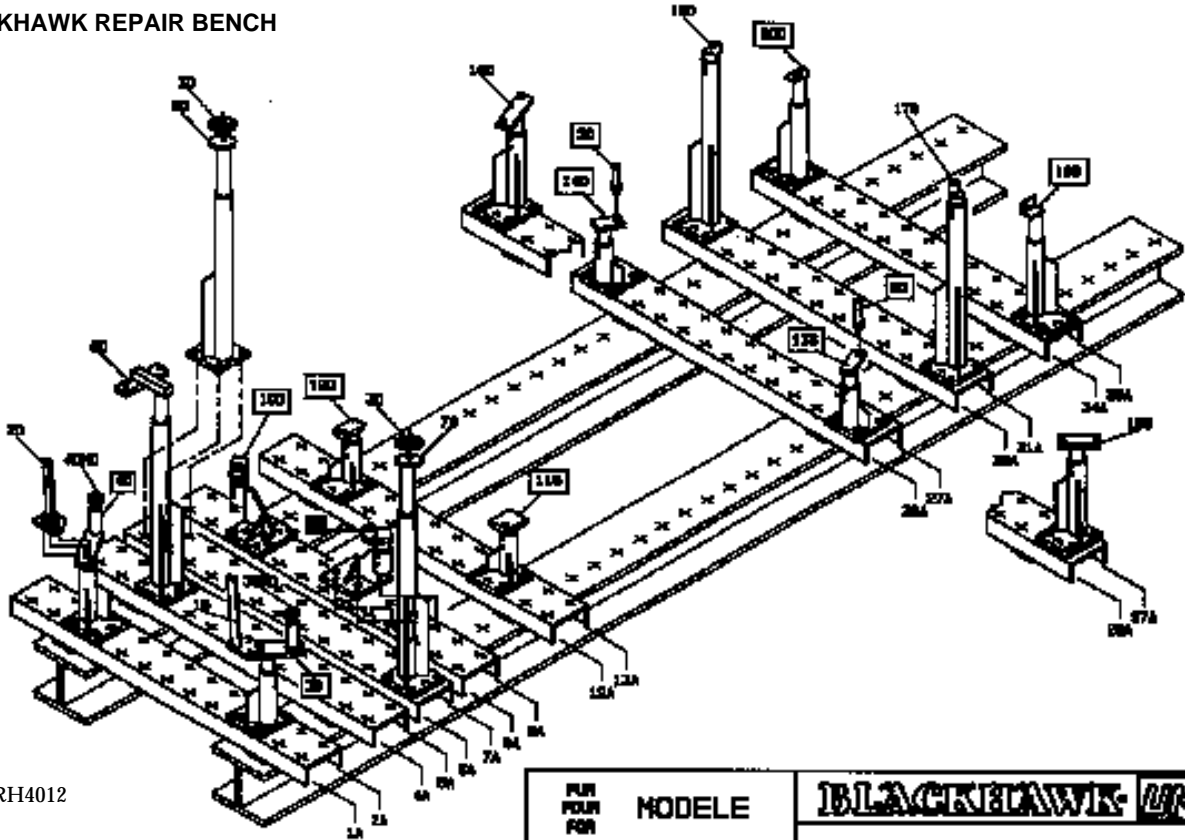


Arrows on this side indicate  
With or without mechanical elements  
Don't miss parts accessories  
See also other Approvals  
Don't miss mechanical elements

**RENAULT**

REF.	REFERENCE	POS.	MB.	MZ
24	774.7816	C 		

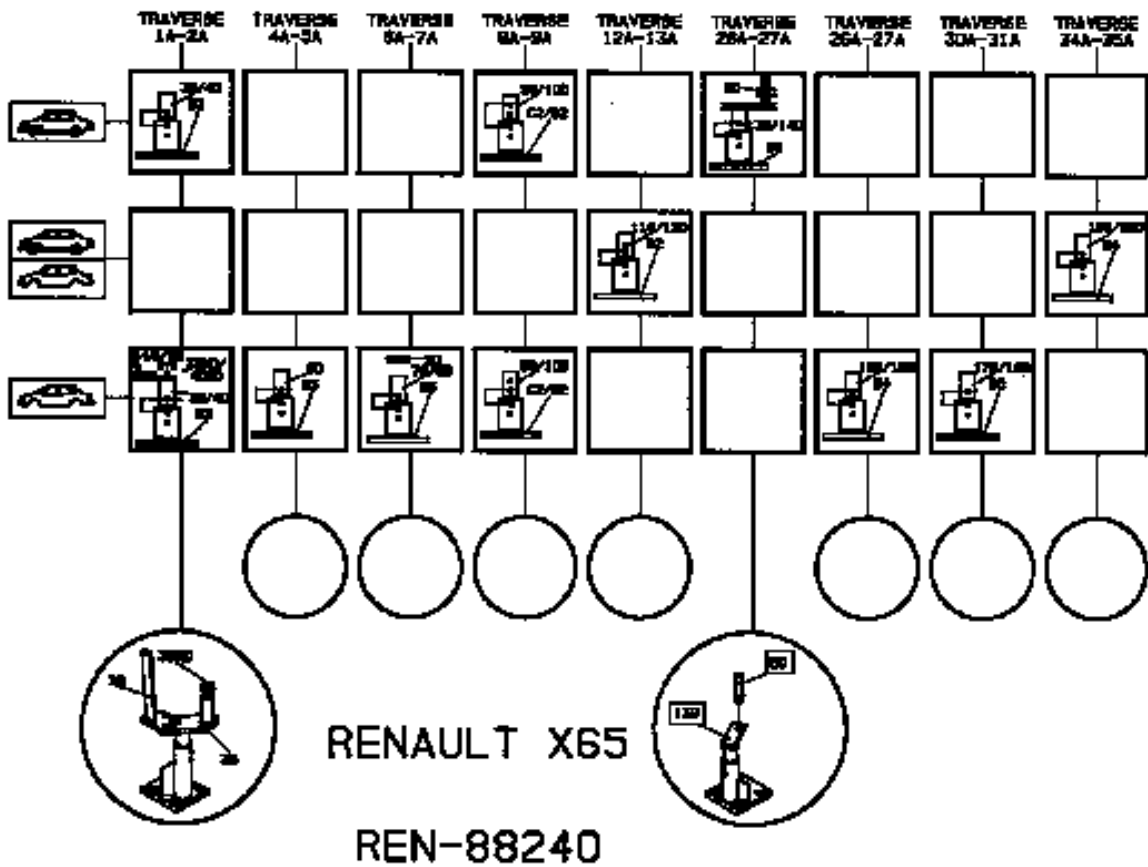
## BLACKHAWK REPAIR BENCH



PRH4012

☐ With mechanical units

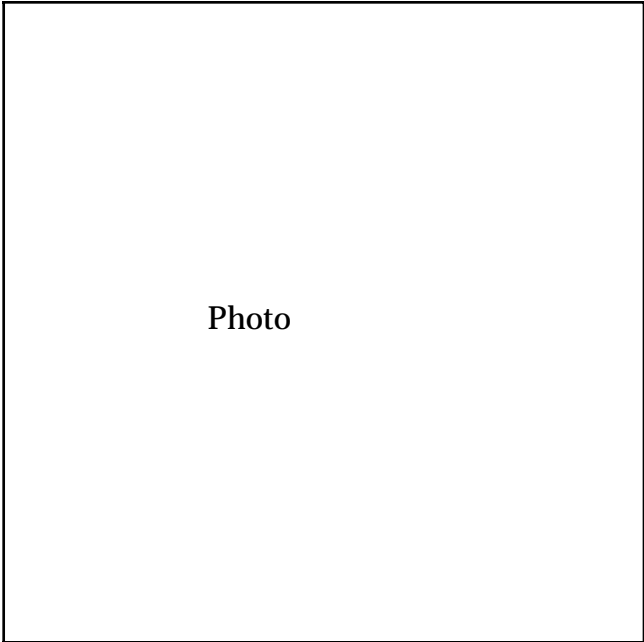
FOUR FOUR FOR	MODELE	BLACKBLAWK- <u>LINE 50</u>
	RENAULT XGS	REF. NO : REN-88240



PRH4013

IV - SPECIAL TOOLING

BLACKHAWK



Photo

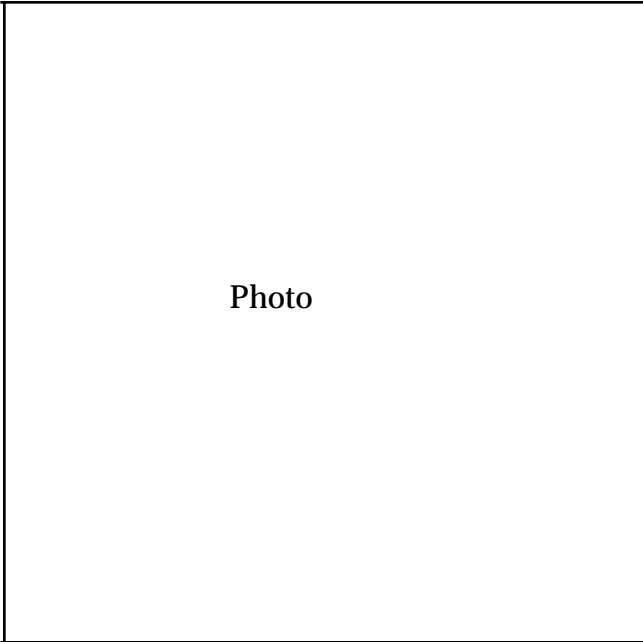
Special heads for **MS System**

Order from : Consult your After Sales Head Office

Supplier's Part Number :

- REN 88240** Complete kit
- REN 88221** Addition to the Kangoo kit (REN 88220)
- REN 88241** Addition to complete kit REN 88240 for repairing a Kangoo

CELETTE



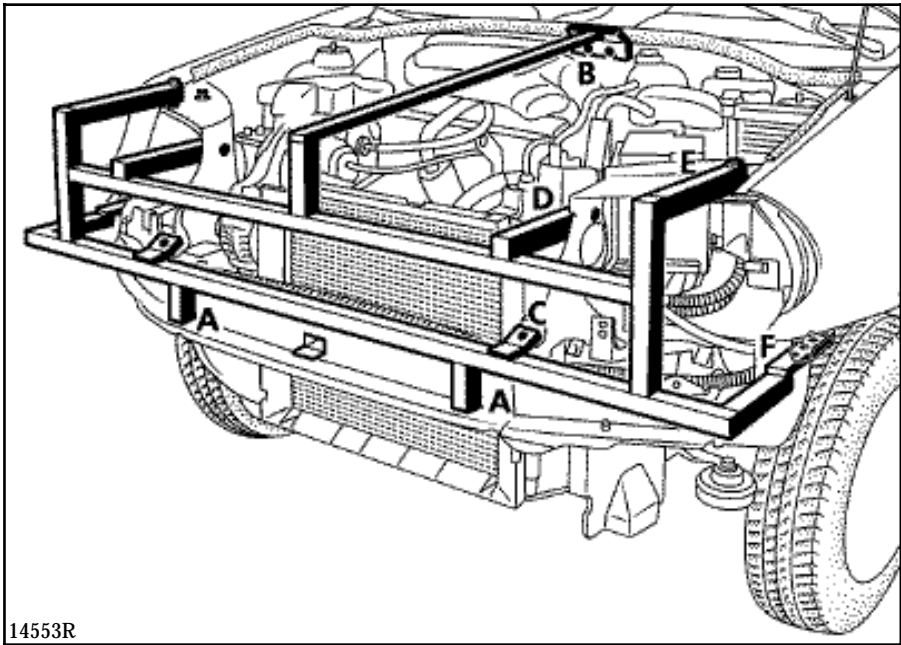
Photo

Special heads for **MS System**

Order from : Consult your After Sales Head Office

Supplier's Part Number :

- 774.300** Complete kit
- 760.309** Addition to Kangoo kit (760.300)
- 774.309** Addition to complete kit 774.300 for repairing a Kangoo




Points (A) and (B) are the references for the positioning of the jig on the vehicle.

Before fitting, when fault finding is carried out, the user must ensure that these points are correct.

Points (C), (D) (E) and (F) and their symmetry help with the mounting and positioning of the replaced components.

When points (A) or (B) can no longer be used as a reference (detected during a fault finding inspection), the points on the opposite side of the impact fulfil the function of positioning reference.

Special Tooling Part Number

Drawing	Manual Part Number	Parts Department <u>Number</u>	Description
	Car. 1481	00 00 148 100	Front end jig.



**INTRODUCTION**

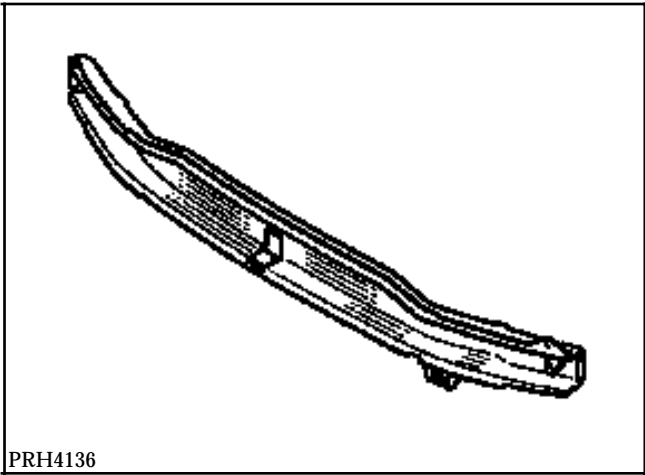
The replacement of this part is a basic operation for a frontal impact .

The repair bench does not have to be used, on condition that the side members have not been affected by the impact.

**COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT**

Part assembled with :

- front end lower cross member closure panel,
- towing ring mounting.

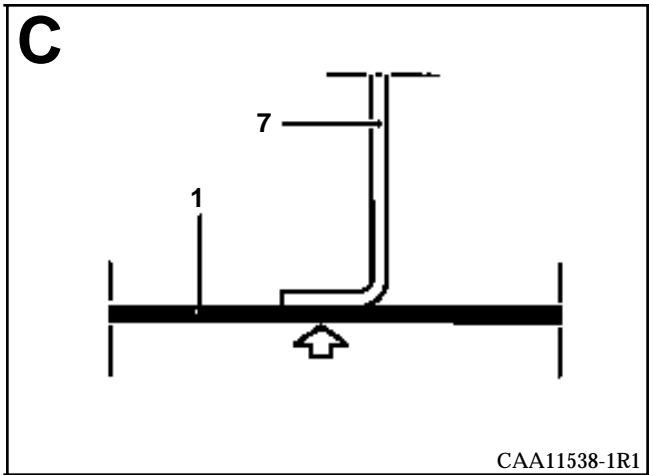
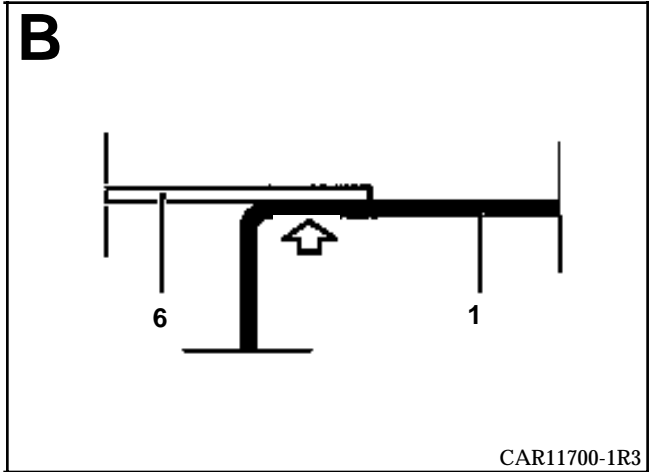
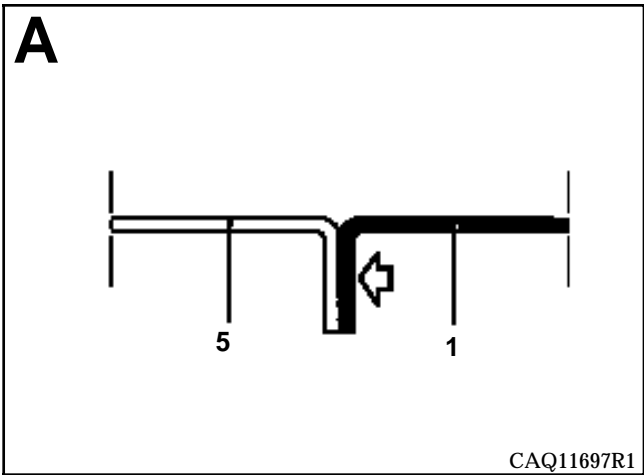
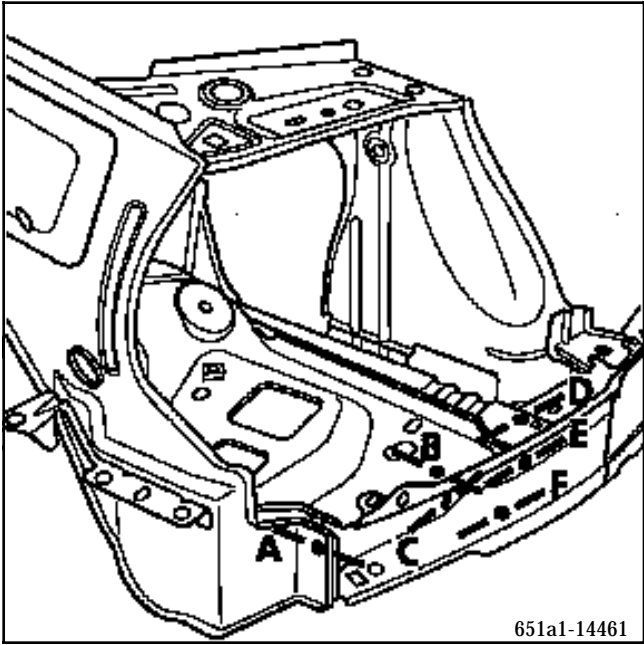


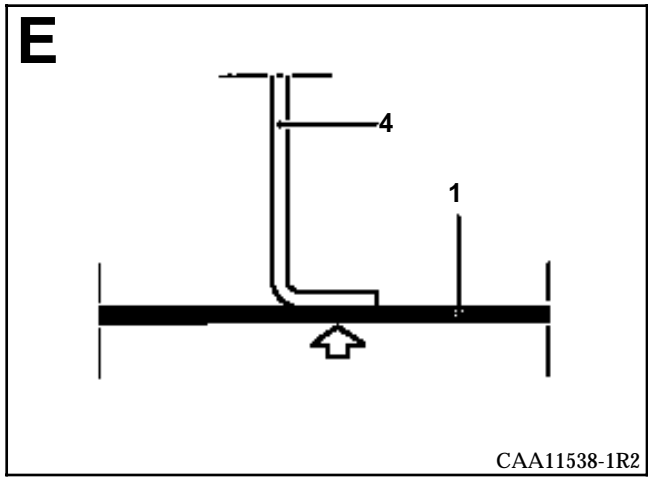
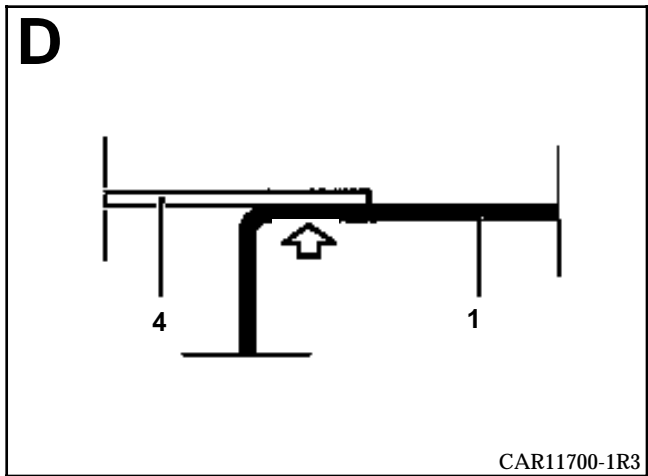
**PARTS CONCERNED (thickness in mm) :**

1	Front end lower cross member	1.8
2	Towing ring mounting	2.5
3	Headlight carrier panel	1.2
4	Front side member	1.5
5	Cowl side panel pillar lining	1.2
6	Wheel arch	0.8
7	Front side member closure panel	1.2

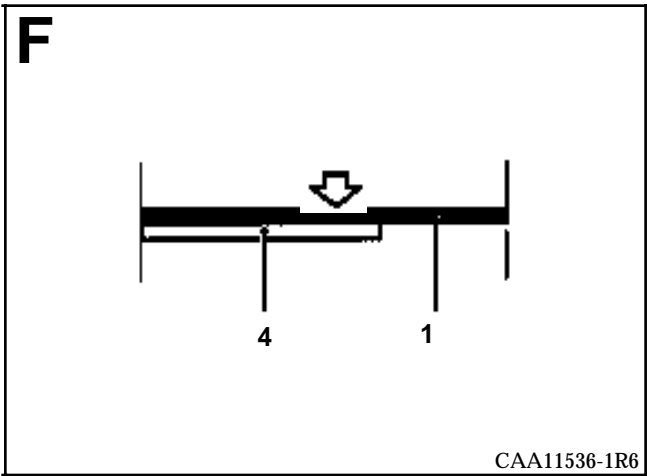
LOWER STRUCTURE  
Front end lower cross member

41A

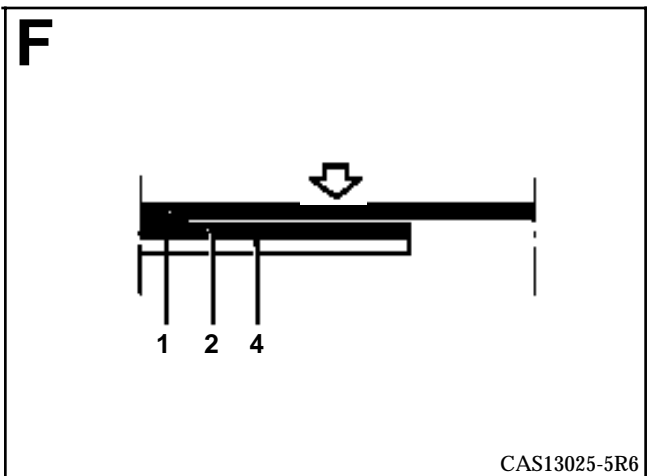


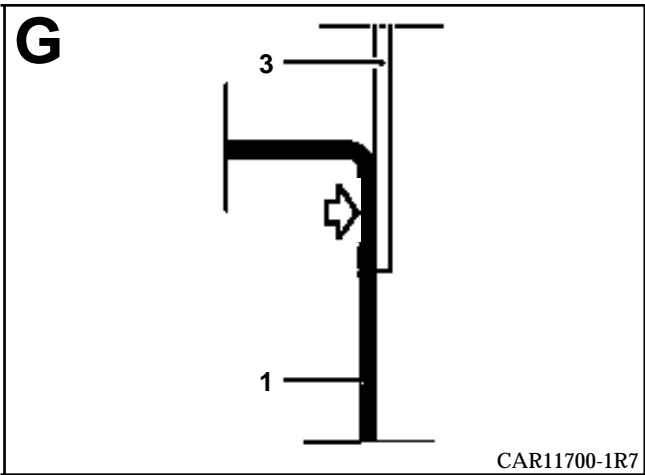
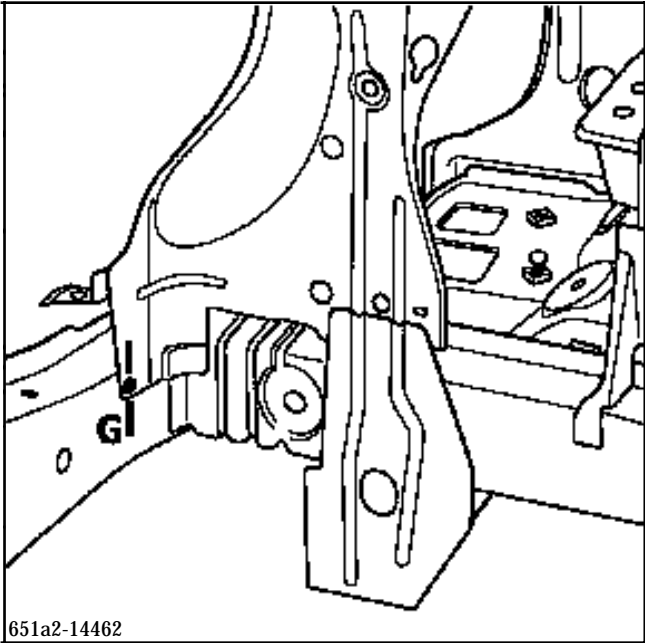


RIGHT HAND SIDE



LEFT HAND SIDE





### INTRODUCTION

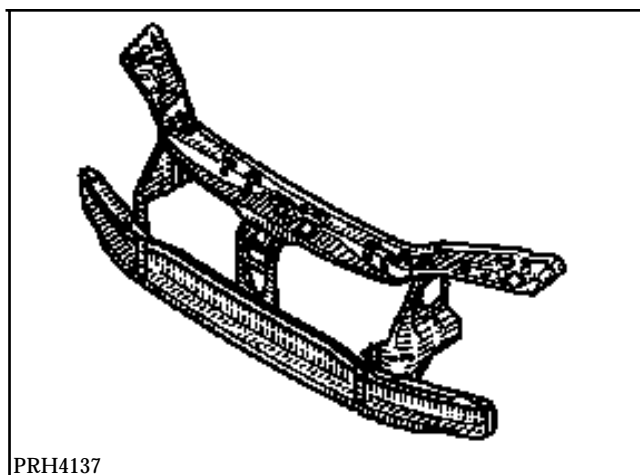
The replacement of this part is a basic operation for a frontal impact .

The repair bench does not have to be used, on condition that the side members have not been affected by the impact.

### COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

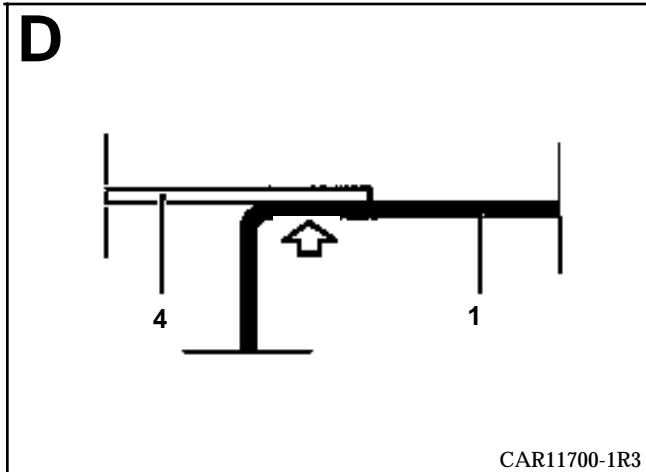
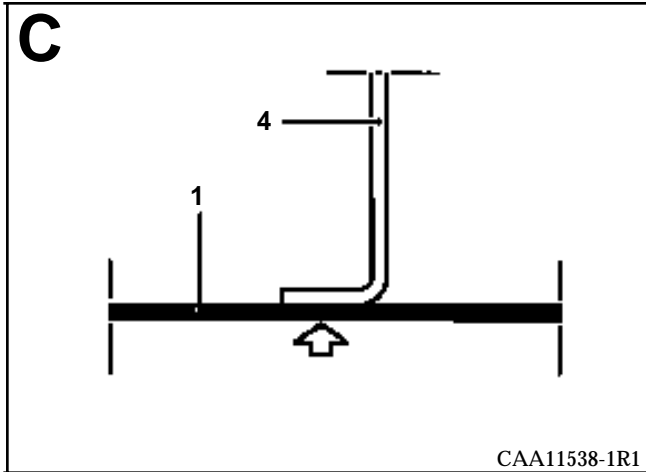
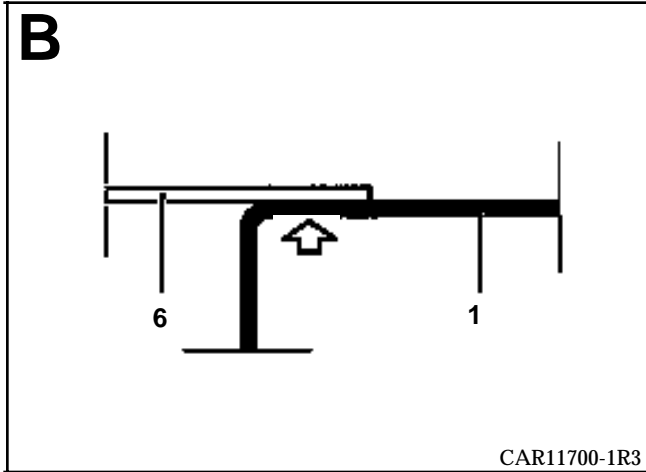
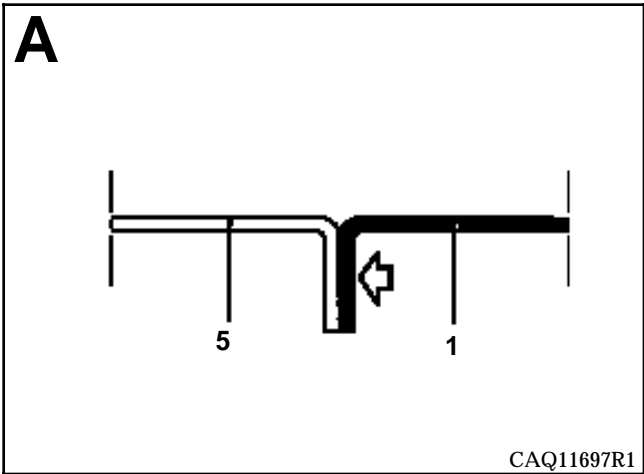
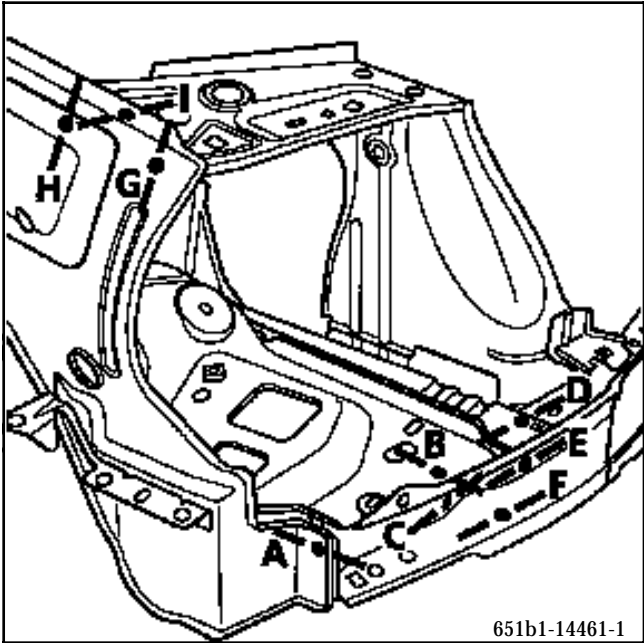
Part assembled with :

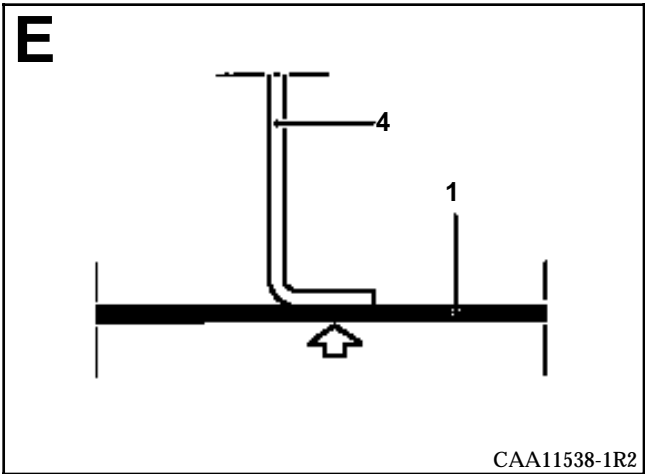
- front end cross member ,
- towing ring mounting ,
- threaded ring ,
- nuts to be welded ,
- front cross member closure panel ,
- front panel upper side cross member,
- front panel upper centre cross member,
- lock mounting reinforcement ,
- headlight carrier panel ,
- bumper mounting bridge.



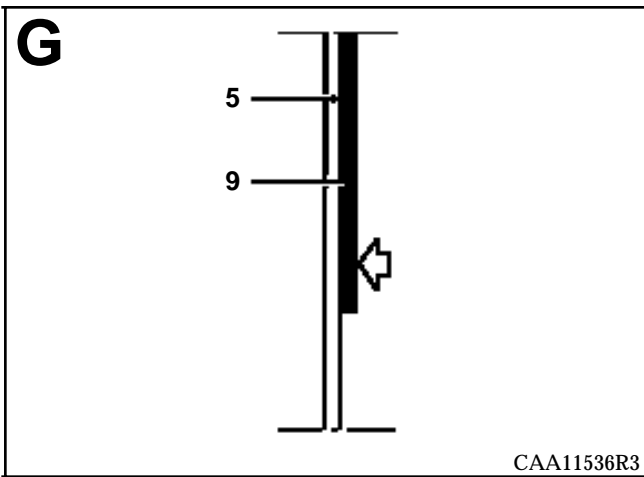
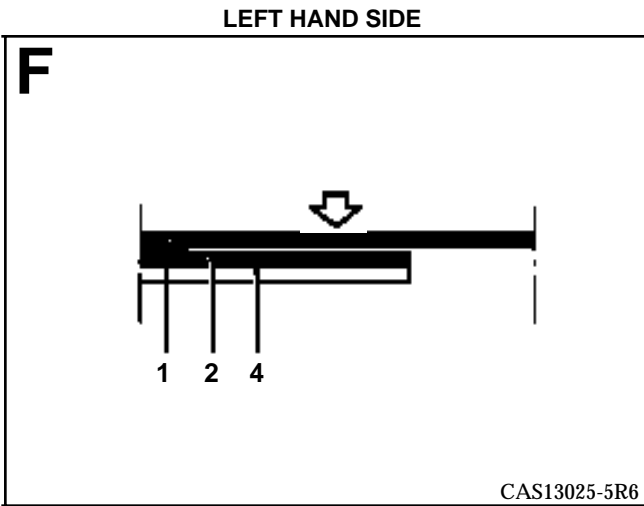
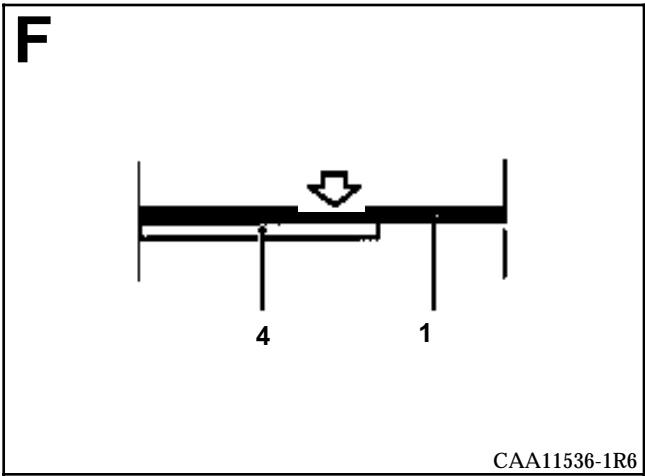
### PARTS CONCERNED (thickness in mm) :

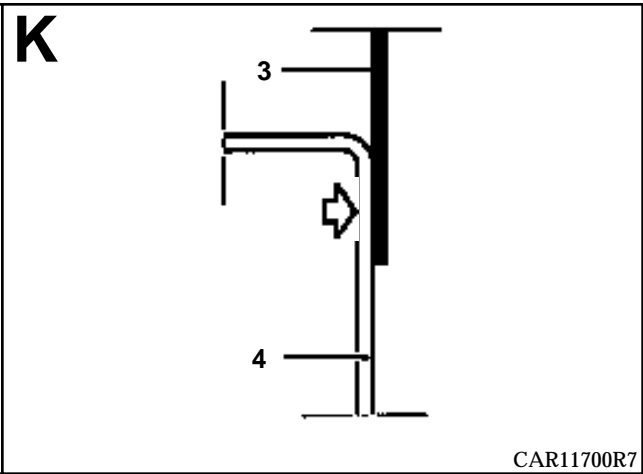
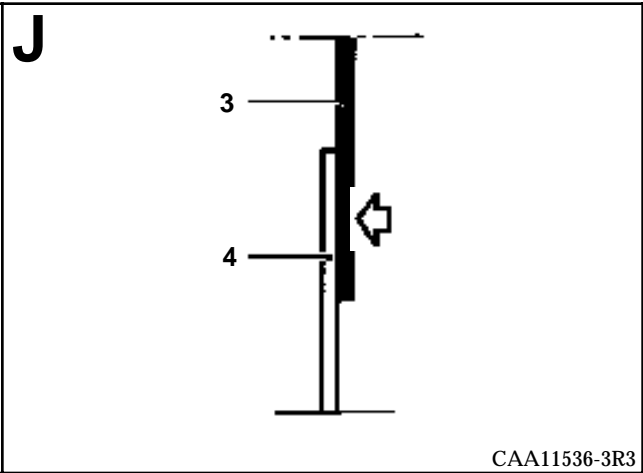
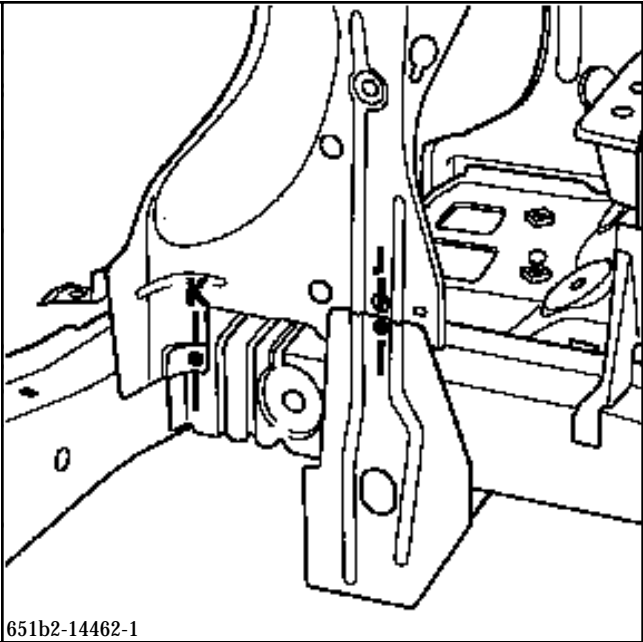
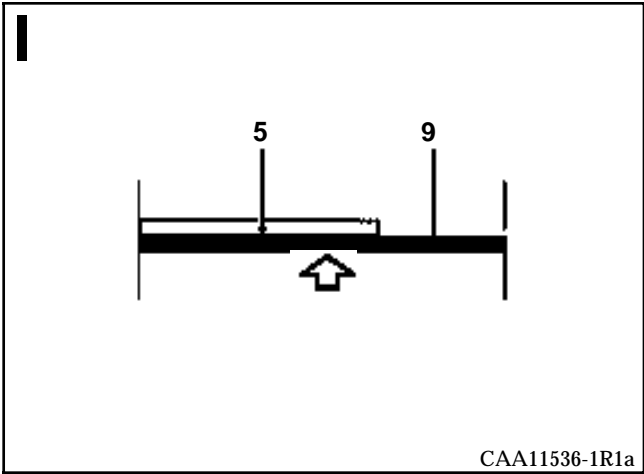
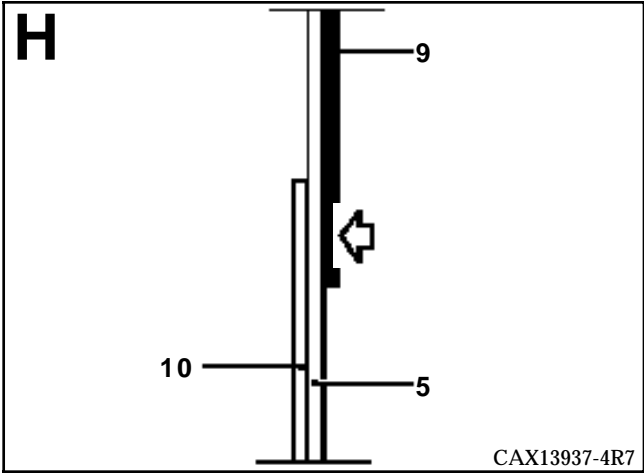
1	Front end lower cross member	1.8
2	Towing ring mounting	2.5
3	Headlight carrier panel	1.2
4	Front side member	1.5
5	Cowl side panel pillar lining	1.2
6	Wheel arch	0.8
7	Front side member closure panel	1.2
8	Front sub-frame front mounting, lower section	1.2
9	Front panel upper side cross member	1.2
10	Cowl side panel upper front reinforcement	1





RIGHT HAND SIDE







INTRODUCTION

The replacement of this part can be done in two ways :

- A Front side member, complete front section .
- B Front side member, partial front section (cut to be made in front of the front mounting of the sub-frame), see the following diagram.

In the two cases these are complementary operations to the replacement of the front end lower cross member and the headlight carrier panel. As a result, the joints with these parts will not be considered here, they will be dealt with in the respective sections.

The repair bench must be used when this is being completely replaced.

**NOTE:** the repair bench must also be used when there is partial replacement of the two side members .

The replacement of this part also requires the replacement of the side member closure panel which will have to be ordered separately.

COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

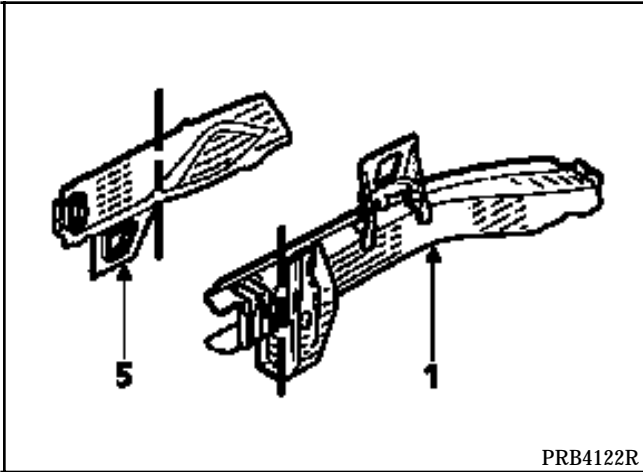
1 - Side member

Part assembled with :

- engine mounting height adjuster (only on the right hand side),
- sub-frame front mounting.

5 - Front side member closure panel

Part on its own.

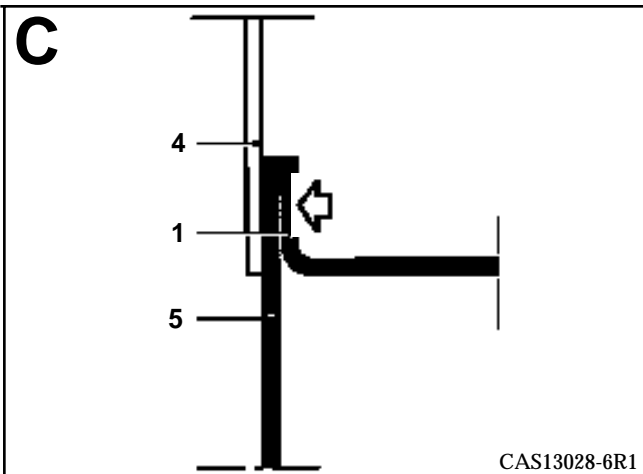
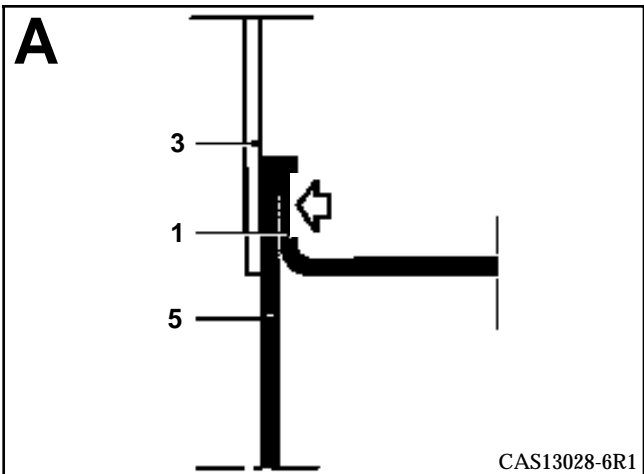
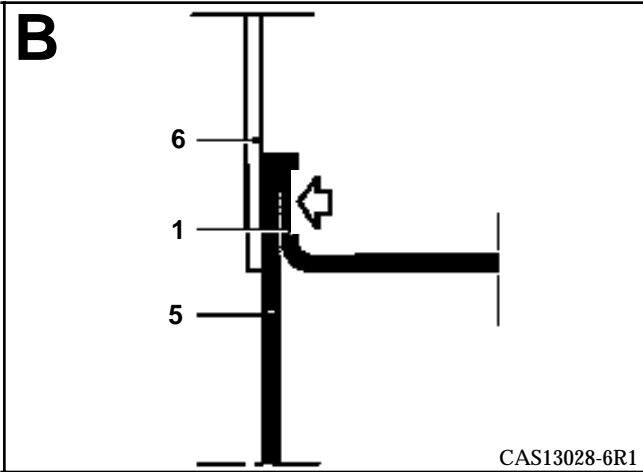
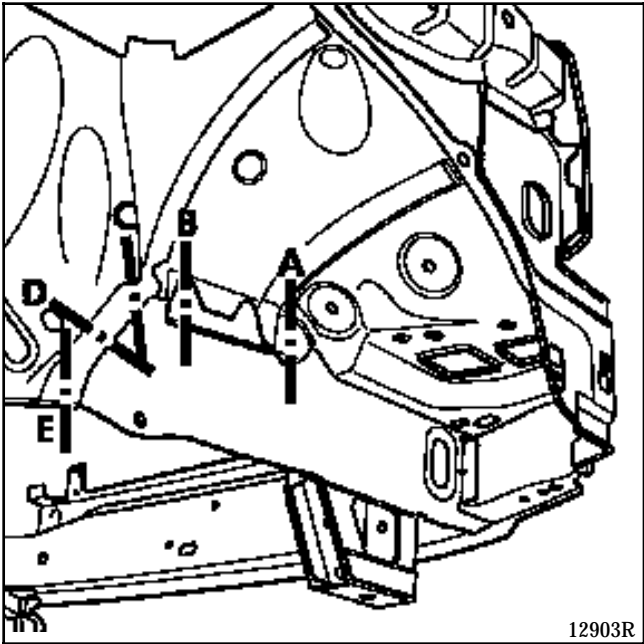


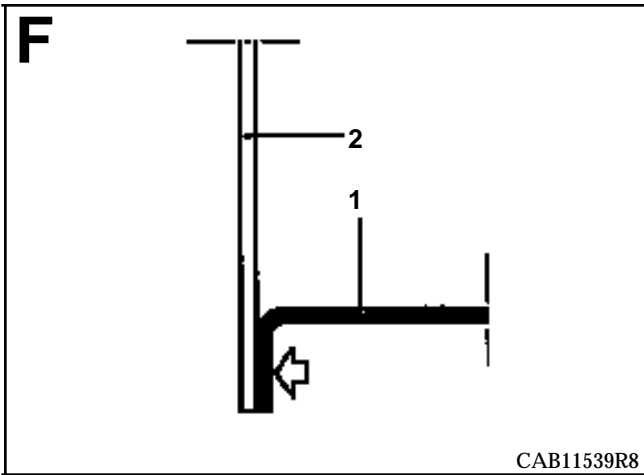
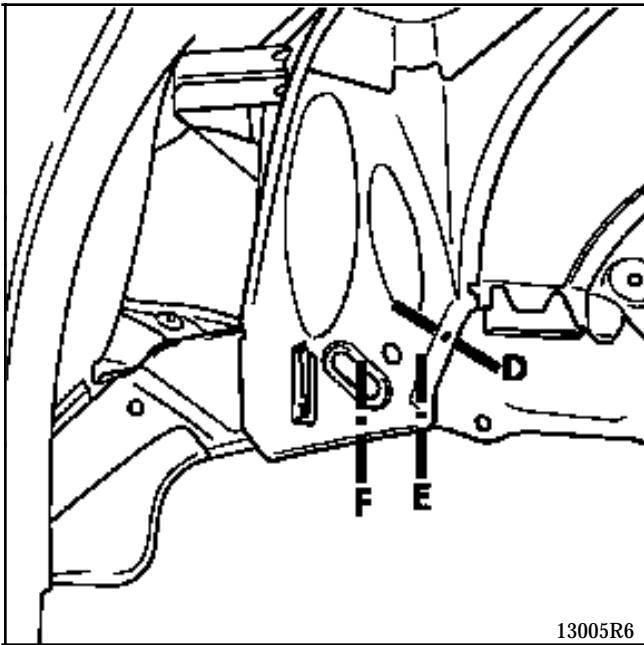
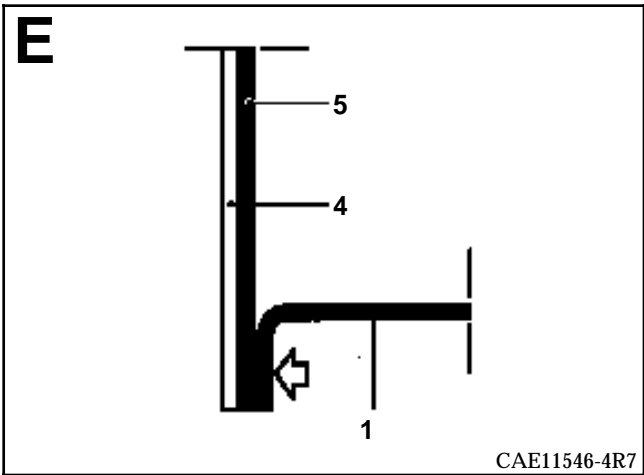
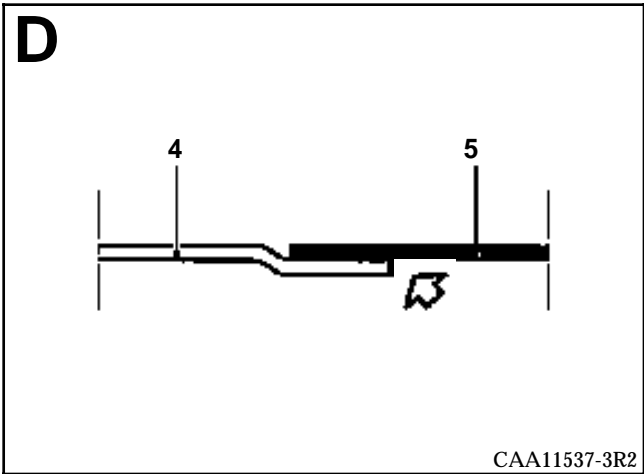
PARTS CONCERNED (thickness in mm) :

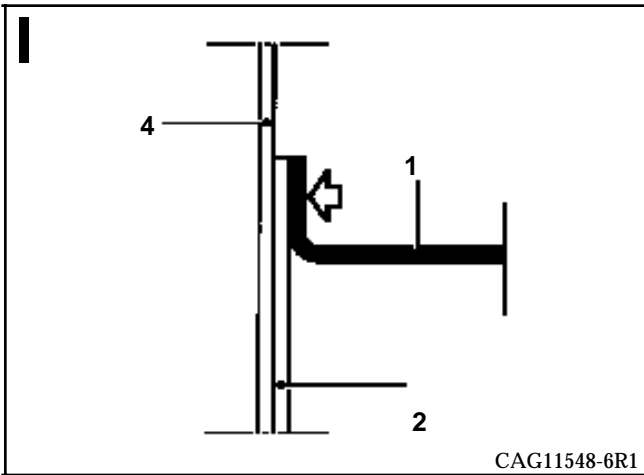
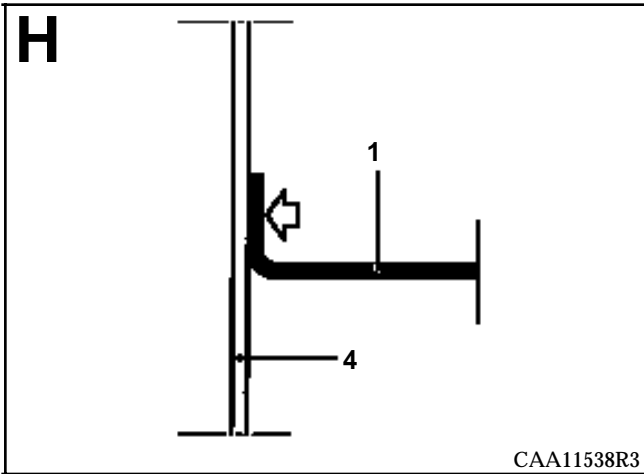
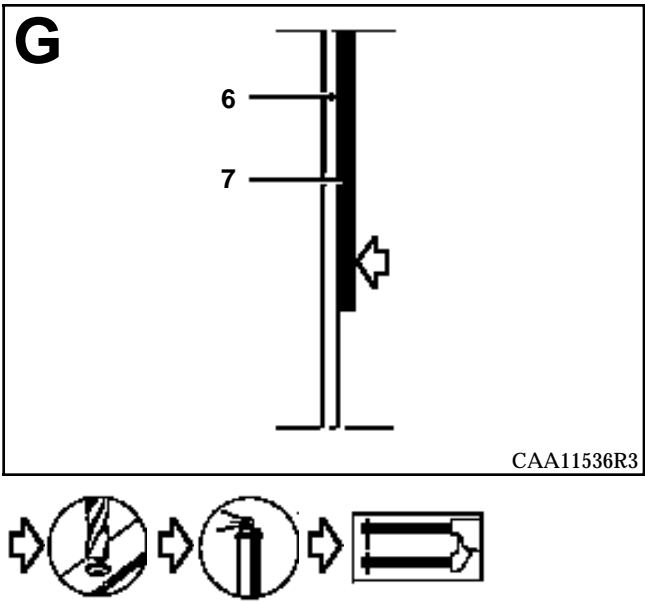
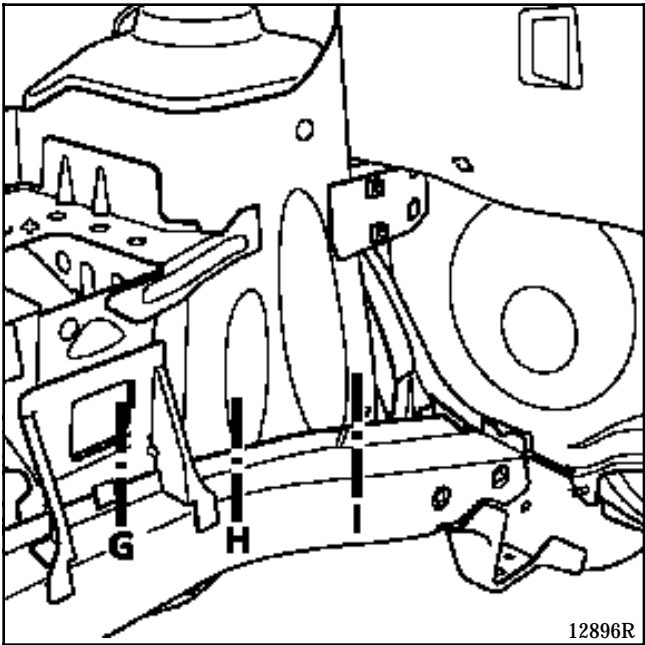
1	Front side member, front section	1.5
2	Front side member, rear section	2.5
3	Front wheel arch	0.8
4	Shock absorber cup height adjuster	0.8
5	Side member closure panel	1.2
6	Engine mounting height adjuster *	1.8
7	Engine mounting reinforcement *	1.5

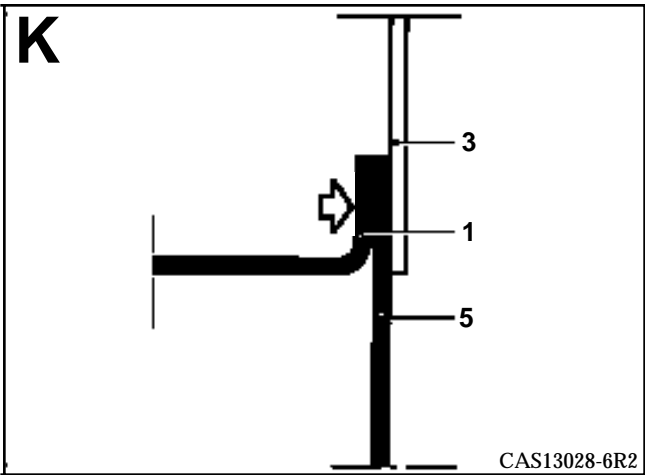
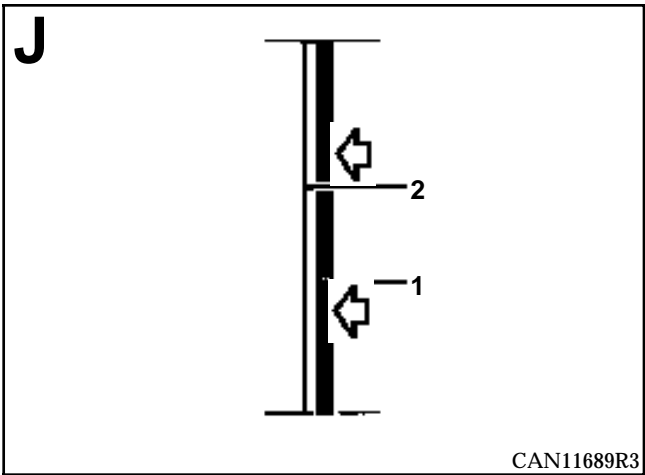
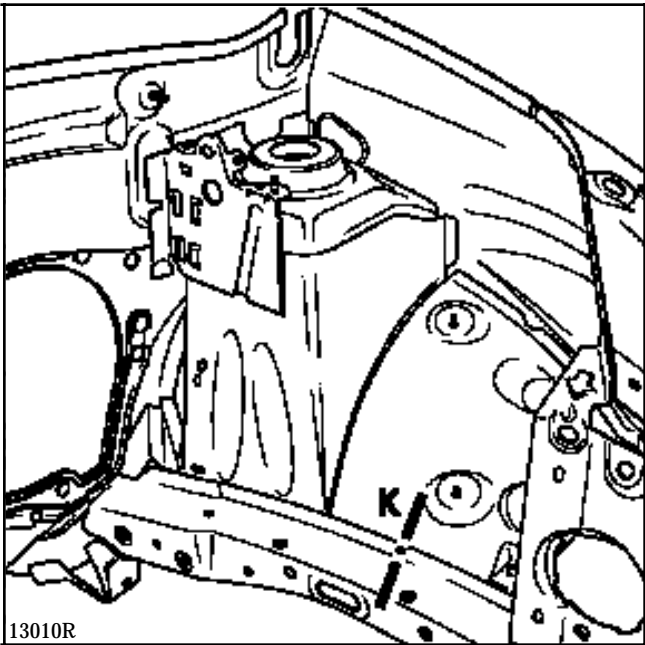
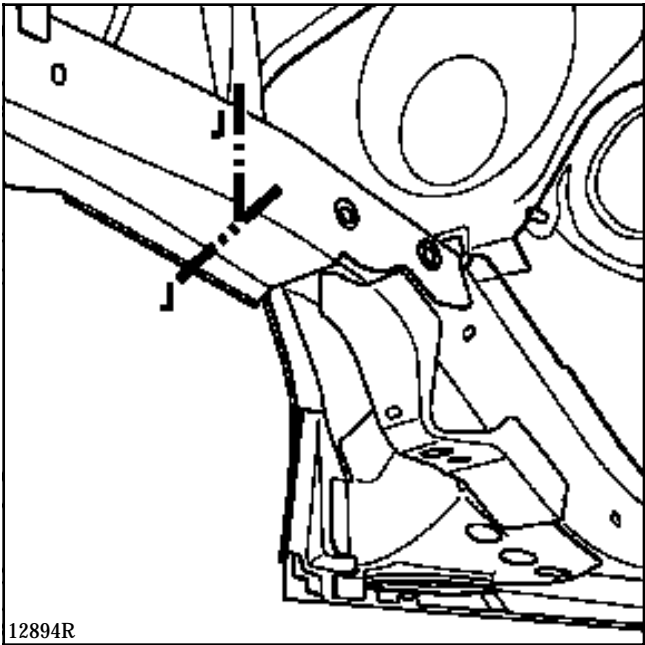
\* Only the right hand side.

COMPLETE REPLACEMENT

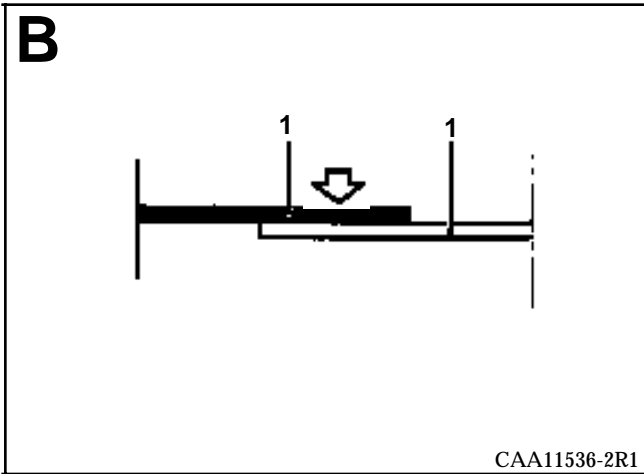
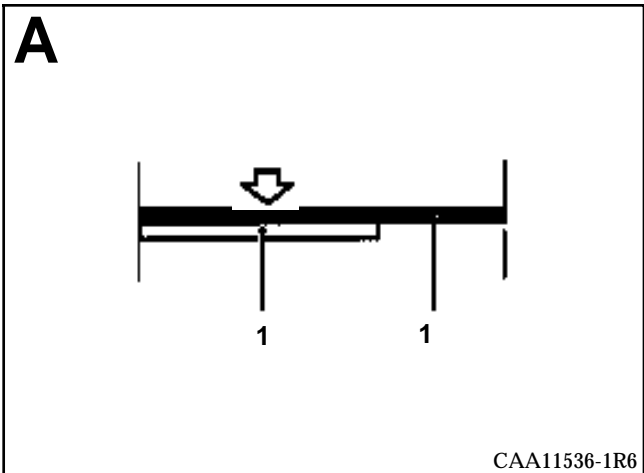
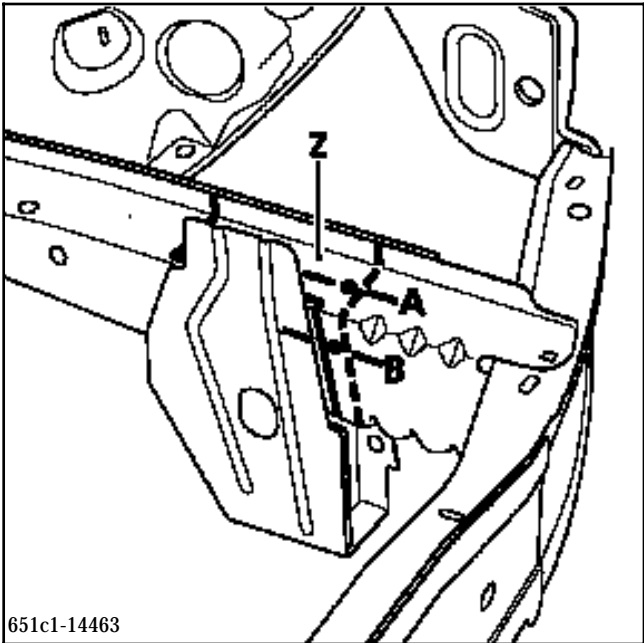




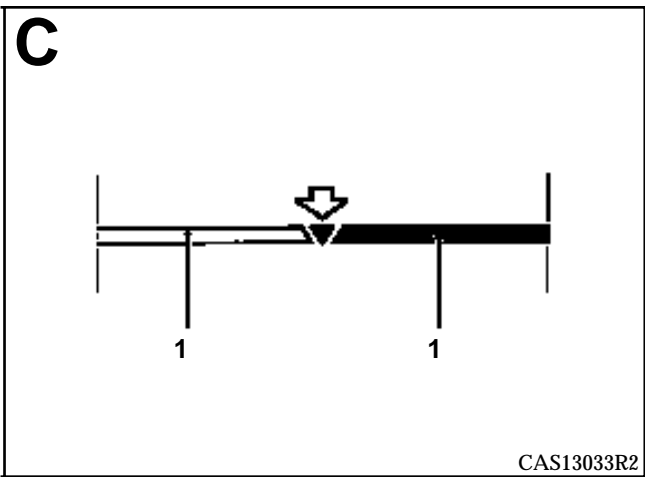
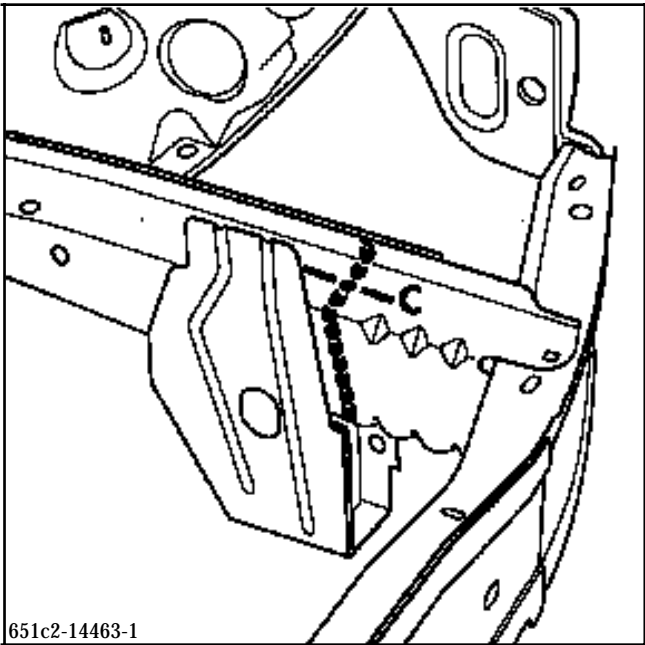




PARTIAL REPLACEMENT



**NOTE:** to avoid using the repair bench for the partial replacement of a side member, on the new side member, keep section (Z) which will ensure that the part replaced will line up correctly in relation to the part remaining on the vehicle. This will be removed when the overlapping part is cut.



INTRODUCTION

The replacement of this part may be done in two ways :

- A - **Complete front side member closure panel** (refer to the complete side member operation).
- B - **Front side member closure panel, partial front section** (cut to be made in front of the sub-frame front mounting), see cut in the diagram and the method following.

This operation is carried out by straightening or replacing the front side member. It is complementary to the front end lower cross member and to the wheel arch.

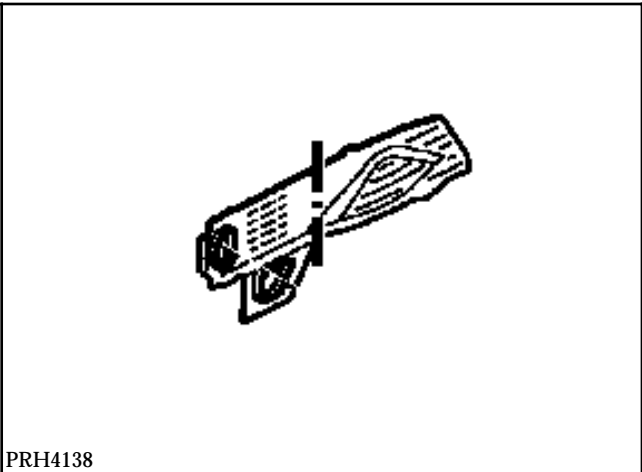
In the operation described below, there are only descriptions of the connections specific to the part concerned.

As a result, joints with other parts will not be considered here, they will be dealt with in the respective section(see contents).

COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

Front side member closure panel

Part on its own.



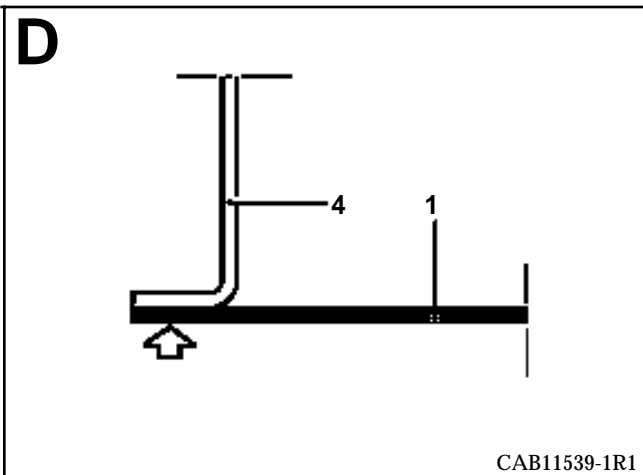
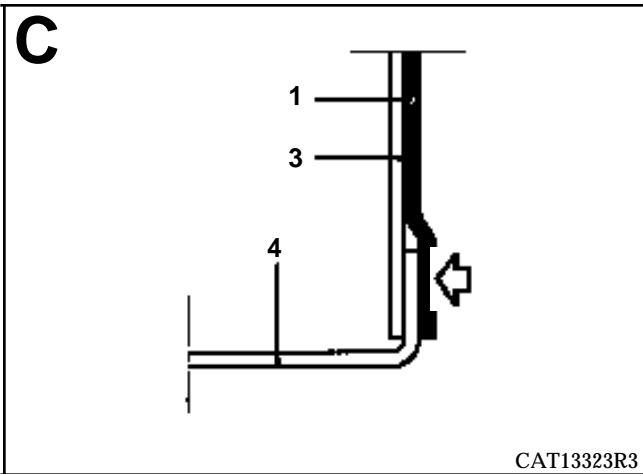
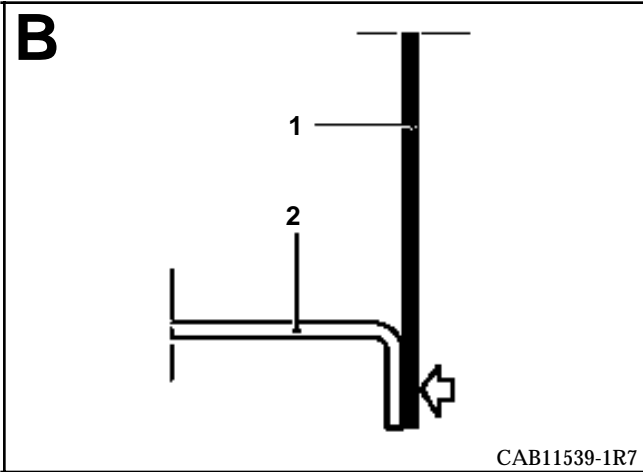
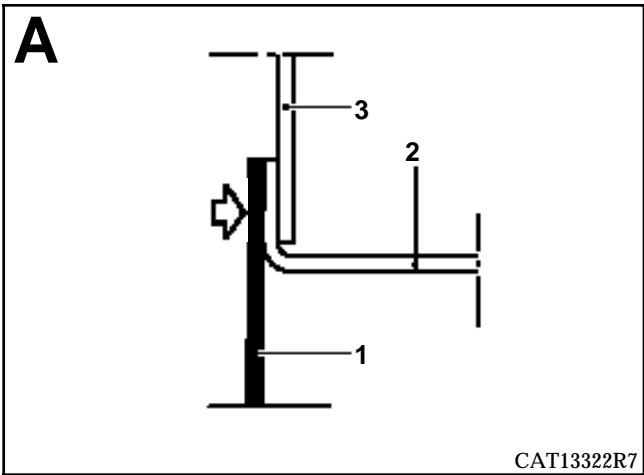
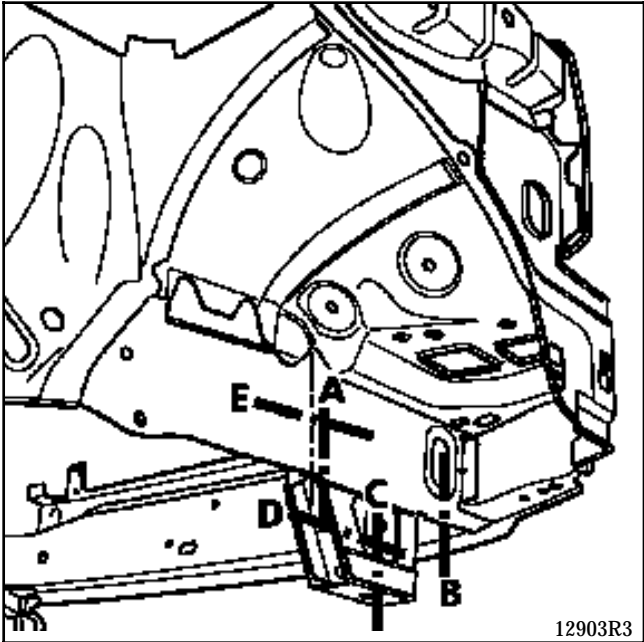
PARTS CONCERNED (thickness in mm) :

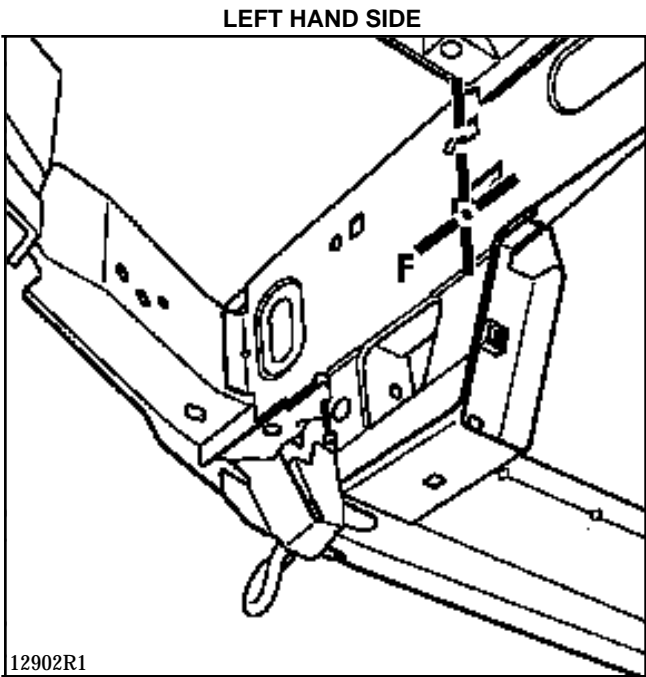
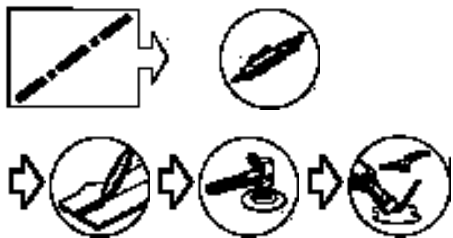
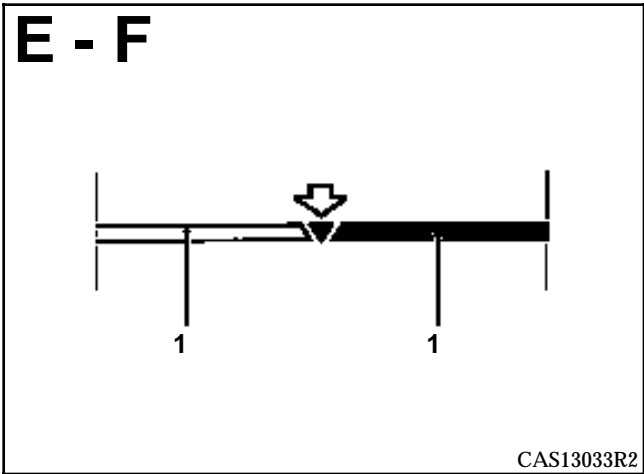
- |   |  |     |
|---|--|-----|
| 1 | Front side member closure panel              | 1.2 |
| 2 | Front side member, front section             | 1.5 |
| 3 | Front sub-frame front mounting reinforcement | 1.2 |
| 4 | Front sub-frame front mounting               | 1.2 |



PARTIAL REPLACEMENT

RIGHT HAND SIDE





**INTRODUCTION**

The replacement of this part is a basic operation for a collision affecting the sub-frame.

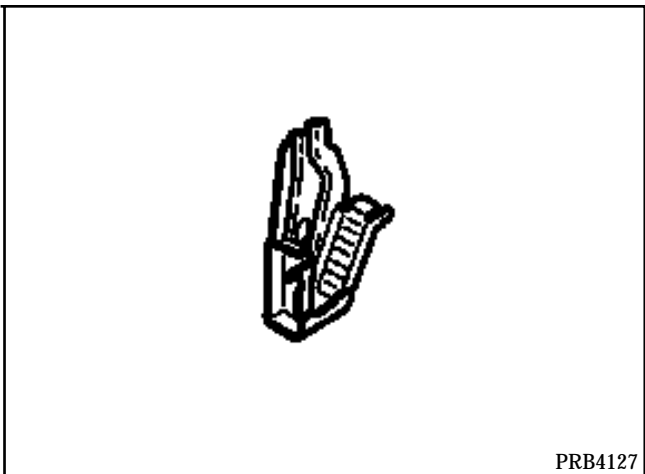
In the operation described below there are only descriptions of the connections specific to the part concerned.

Information concerning the other parts will be dealt with in the respective sections.

The repair bench must be used.

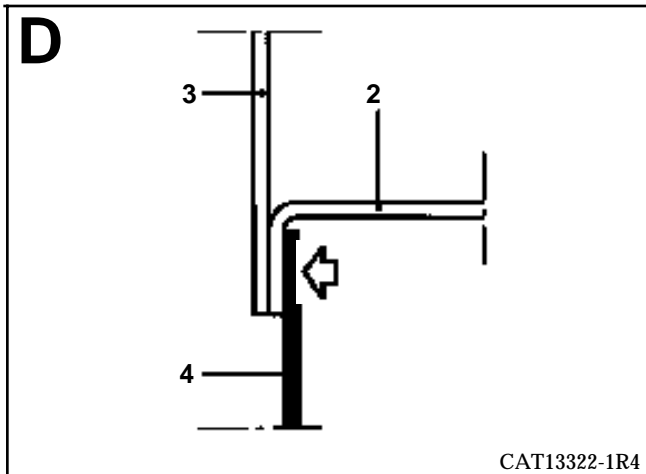
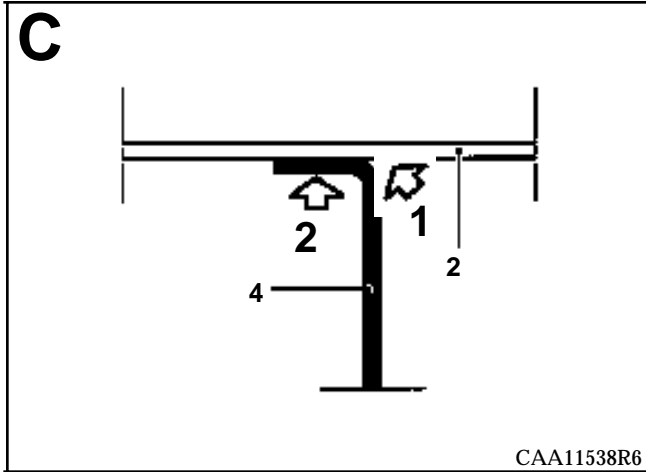
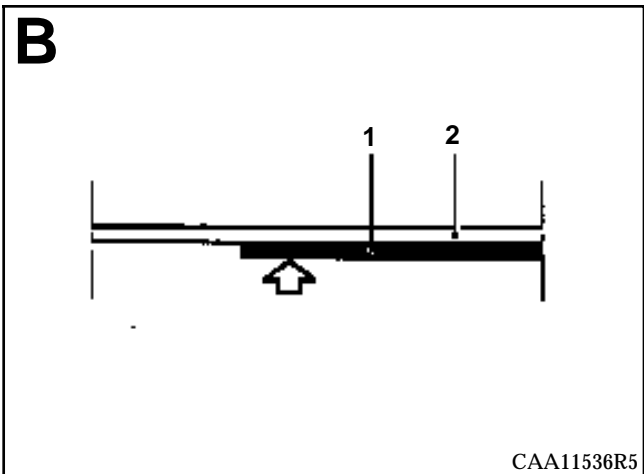
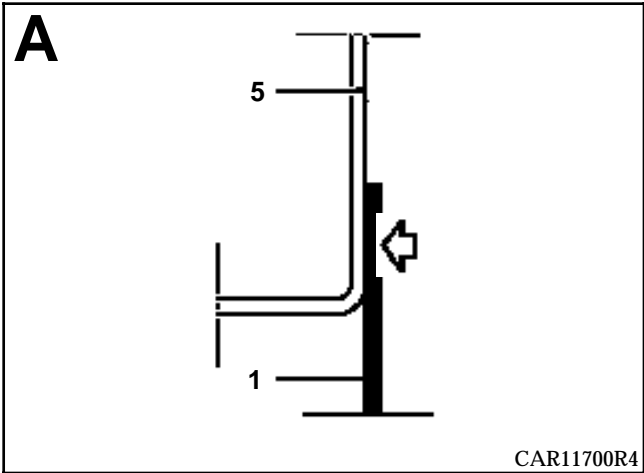
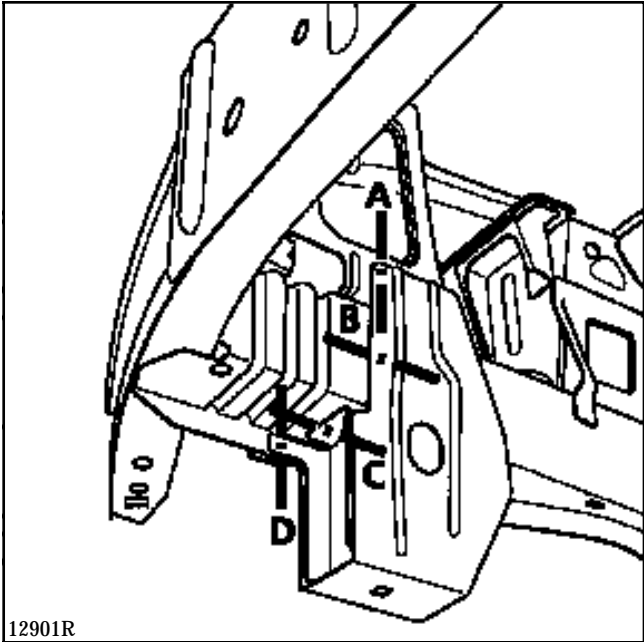
**COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT**

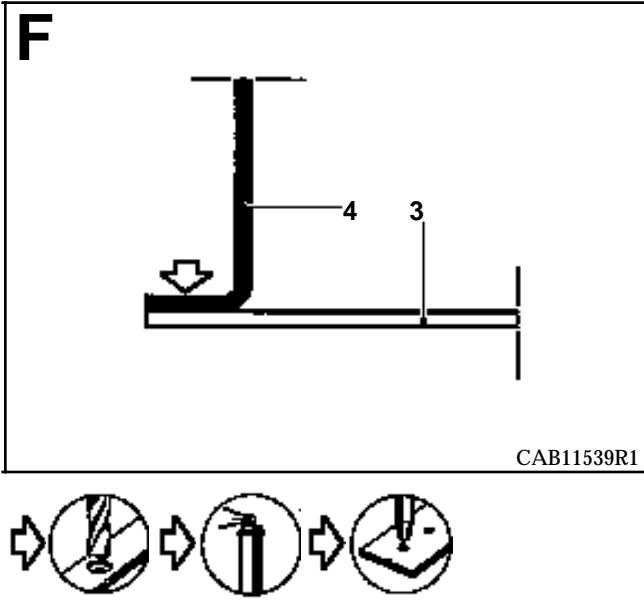
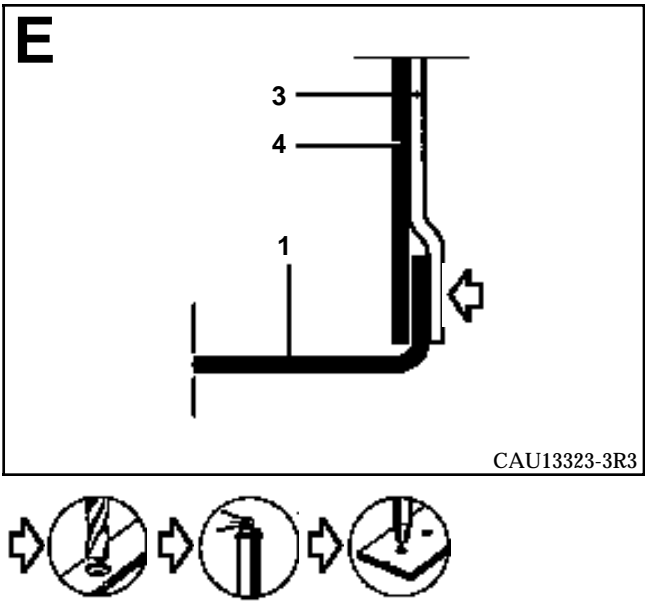
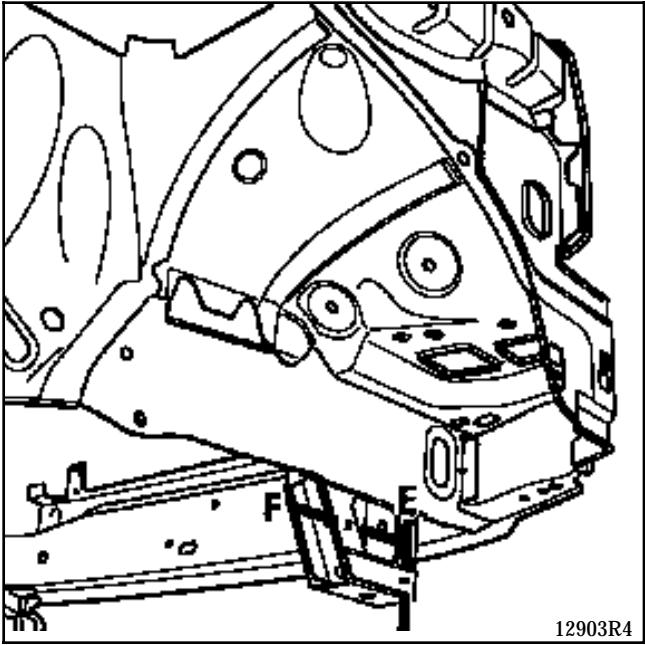
Part assembled with sub-frame front mounting reinforcement.



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

<b>1</b>	Front sub-frame front mounting	1.5
<b>2</b>	Front side member, front section	1.2
<b>3</b>	Side member closure panel	1.2
<b>4</b>	Front sub-frame front mounting reinforcement	1
<b>5</b>	Headlight carrier panel	1.2





INTRODUCTION

The operation for the replacement of this part is complementary to :

- the front end lower cross member,
- the headlight panel.

This operation requires the replacement of the **cowl side panel (pillar lining)** and of the **cowl side panel upper reinforcements**, which have to be ordered separately.

In the operation described below there are only descriptions of the specific joints to the part concerned, information concerning the parts to be ordered separately is not considered here. This will be dealt with in the respective sections.

The repair bench must be used.

COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

Part assembled with :

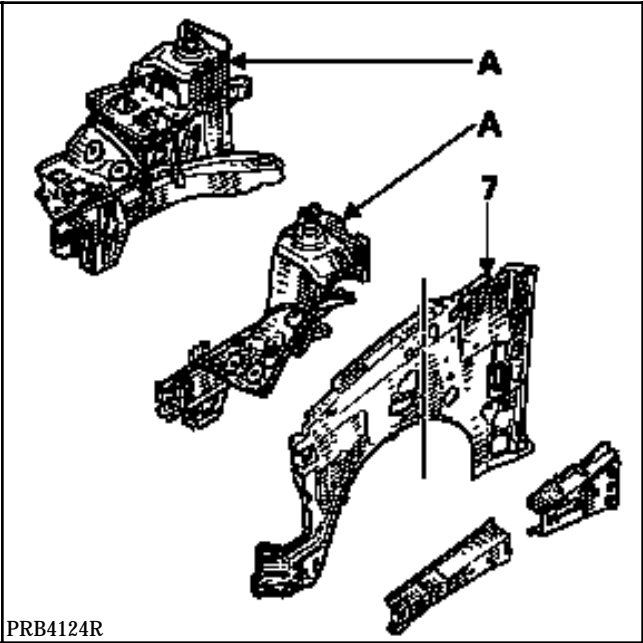
A Front side member, rear section

- engine mounting height adjuster (right hand side)
- engine mounting reinforcement (right hand side),
- engine mounting plate (right hand side),
- sub-frame front mounting ,
- front side member closure panel,
- wheel arch,
- shock absorber cup,
- shock absorber cup height adjuster,
- ABS mounting (right hand side),
- injection unit mounting and impact sensor (left hand side),
- side plenum chamber

**Cowl side panel (pillar lining)**

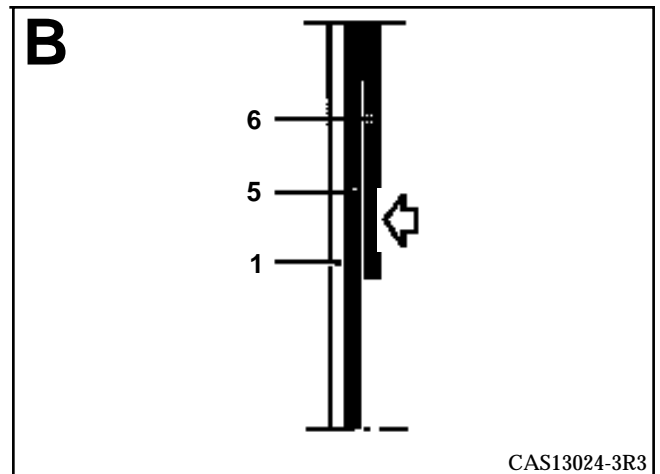
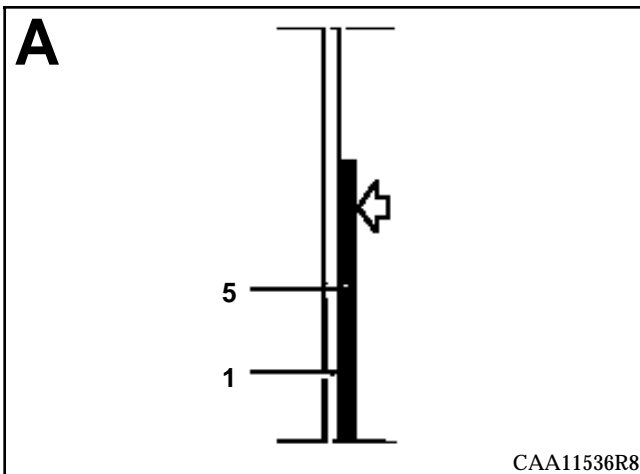
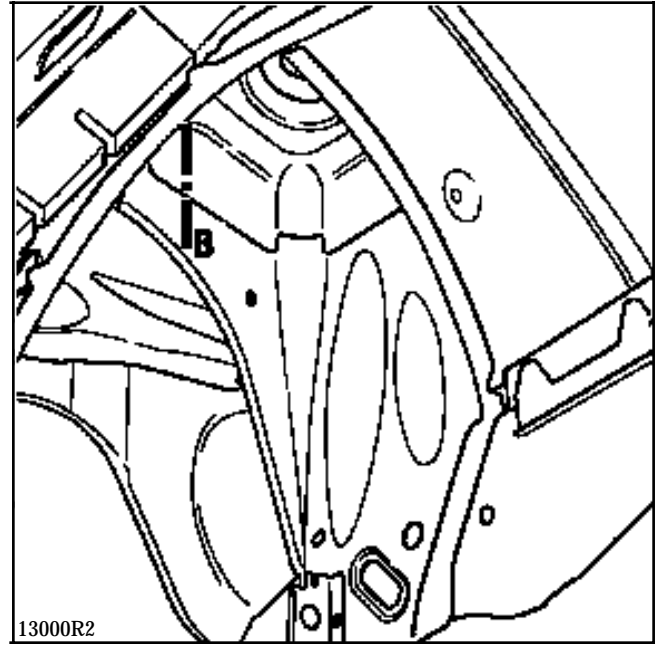
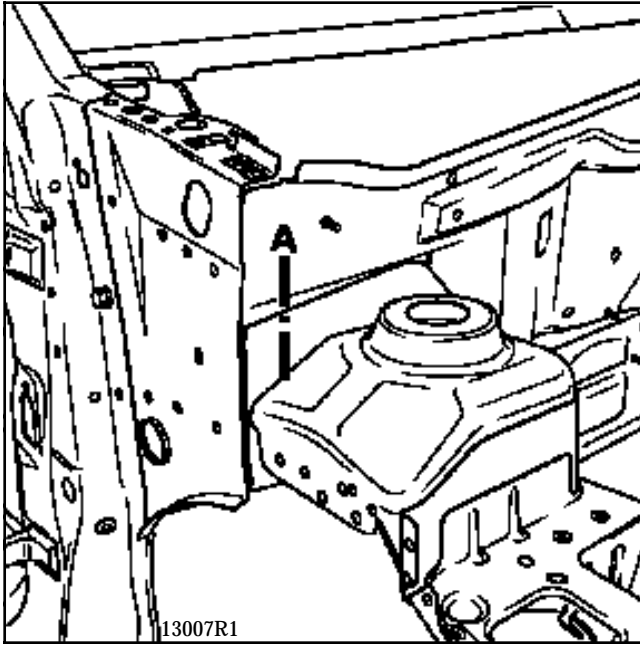
**Cowl side panel upper reinforcement**

**NOTE :** to avoid removing the bulkhead lining, the side section of the new half unit plenum chamber must be removed, if this part of the vehicle is not damaged.

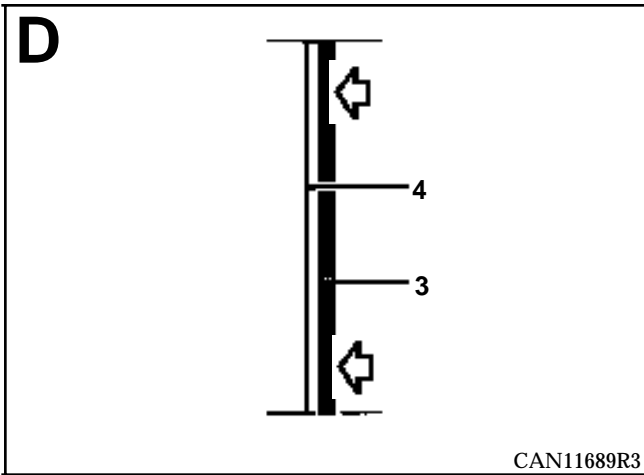
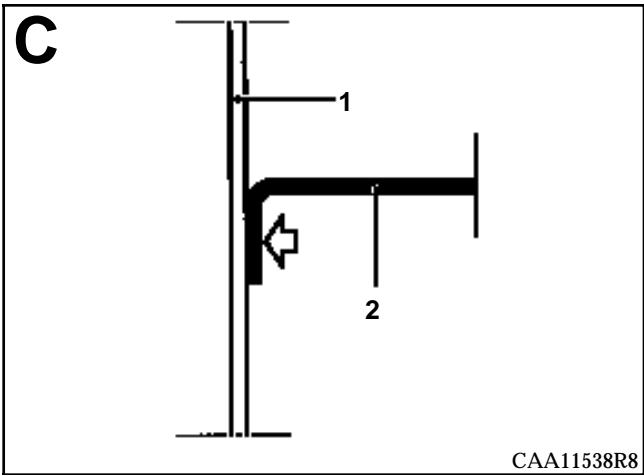
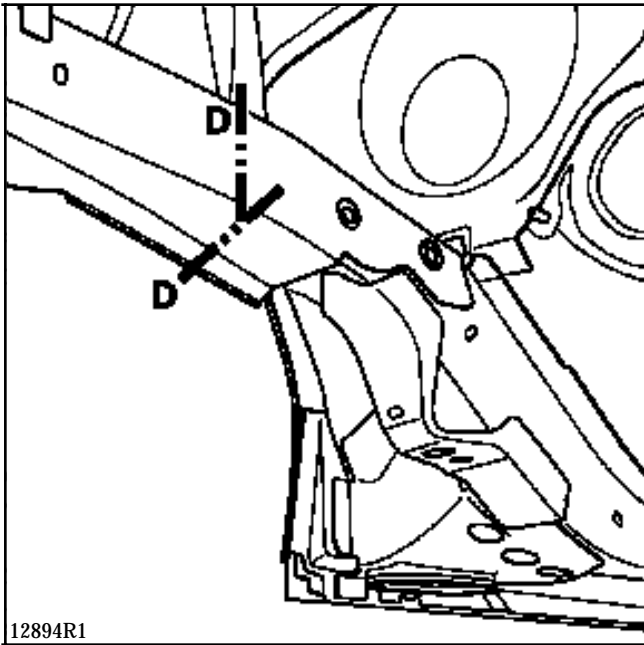
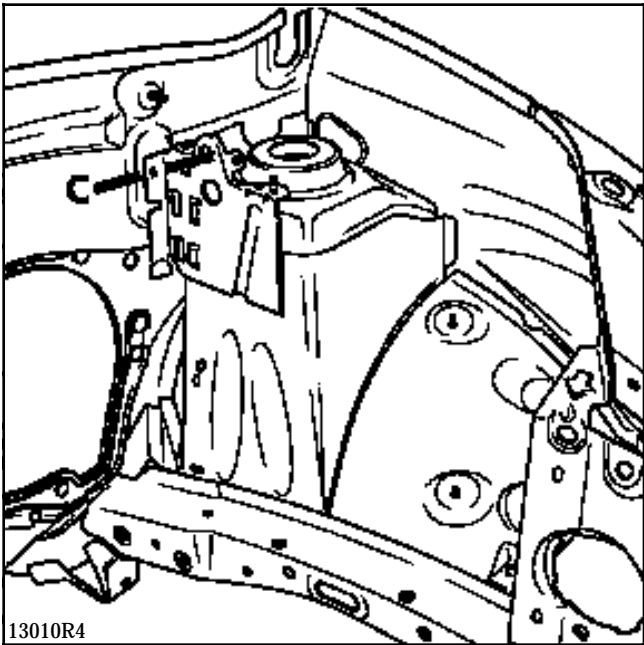


PARTS CONCERNED (thickness in mm) :

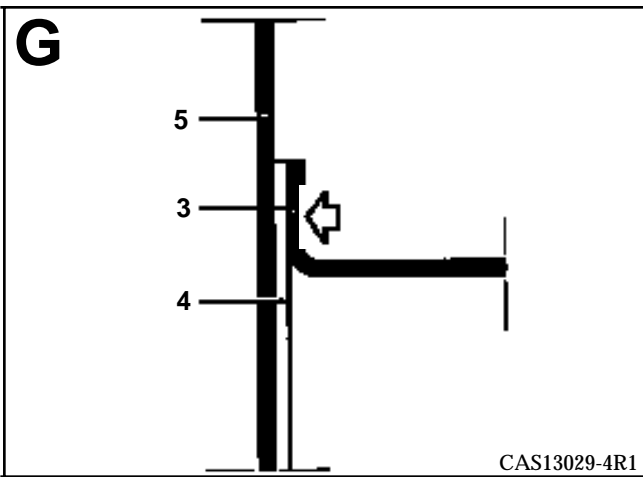
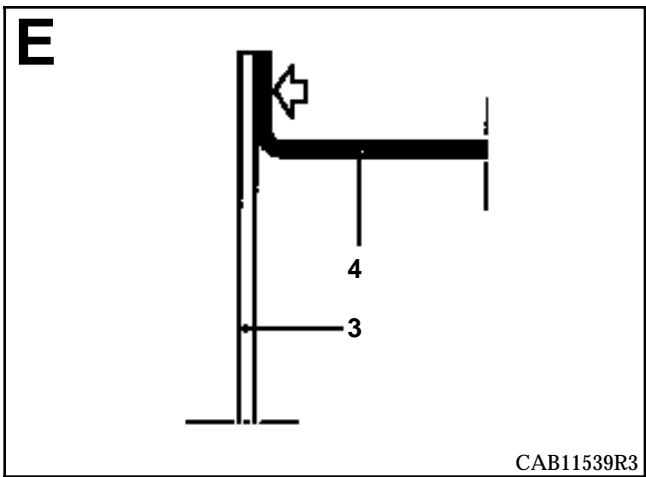
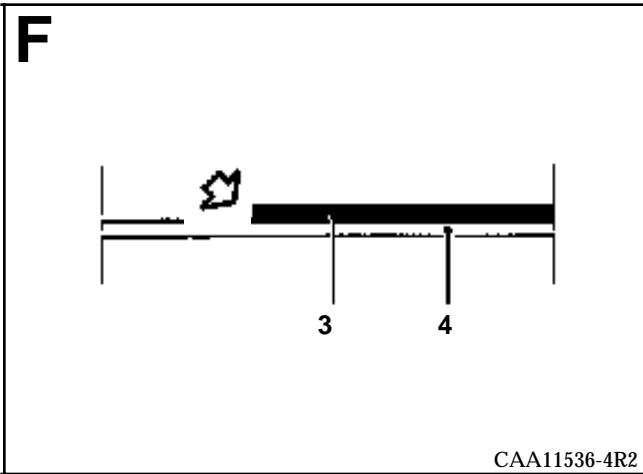
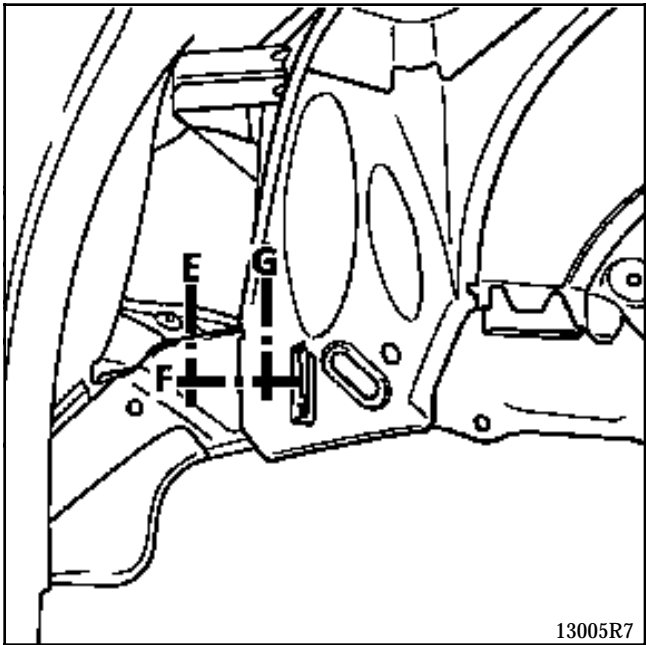
1	Central plenum chamber	1
2	Injection unit mounting and impact sensor (left hand side)	2
3	Front side member, front section	1.5
4	Front side member, rear section	1.8
5	Shock absorber cup height adjuster	1
6	Shock absorber cup	2
7	Cowl side panel (pillar lining)	1.5
8	Cowl side panel upper reinforcements	1
9	Central plenum chamber	1
10	Side plenum chamber	1
11	Bulkhead	0.7



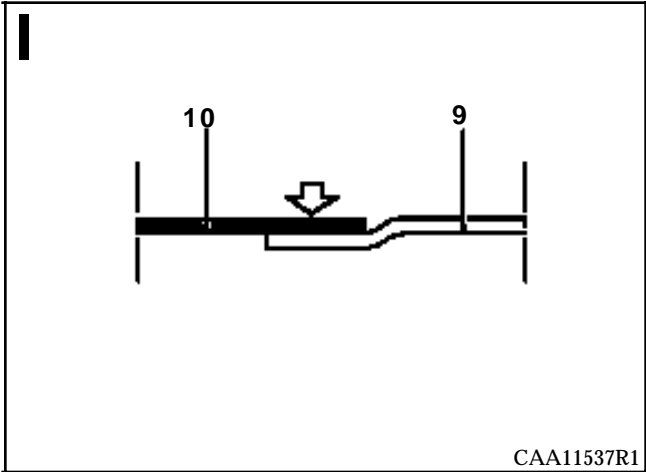
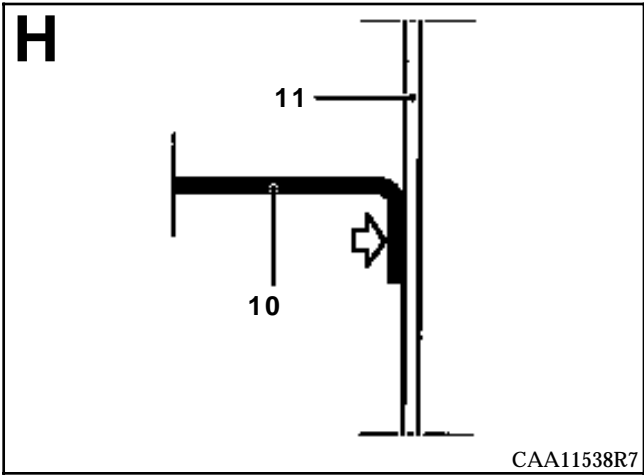
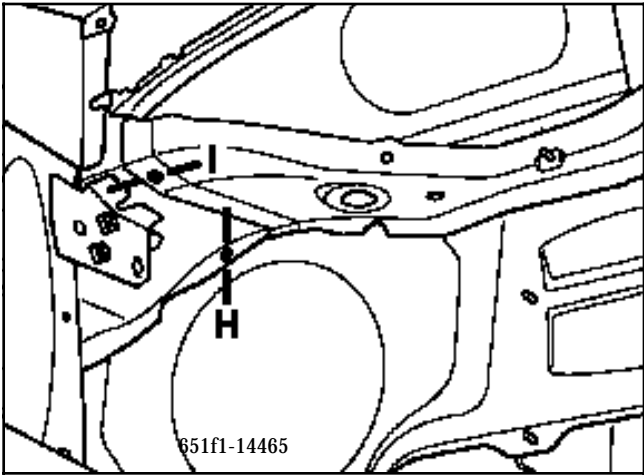
Right hand side special feature.







REPLACEMENT WITH SIDE CHAMBER



### INTRODUCTION

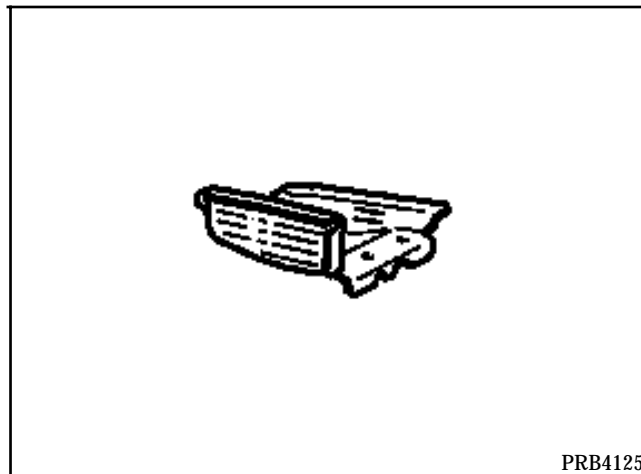
The replacement of this part is a complementary operation to the replacement of a front pillar or a sill panel with a lining for a side impact.

In the operation described below there are only descriptions of the joints specific to the part concerned.

Information concerning the other parts will be dealt with in the respective sections.

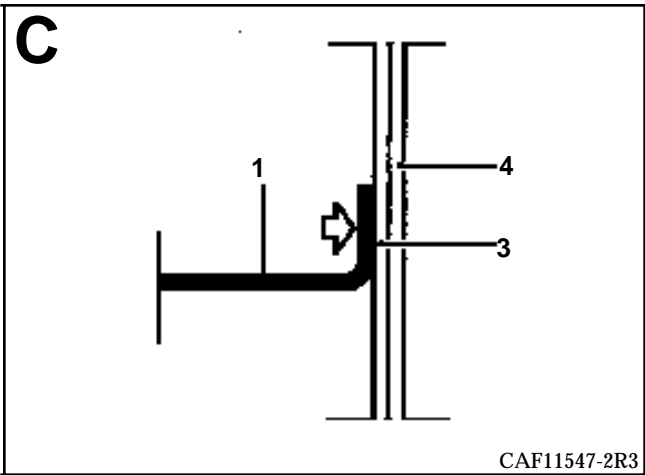
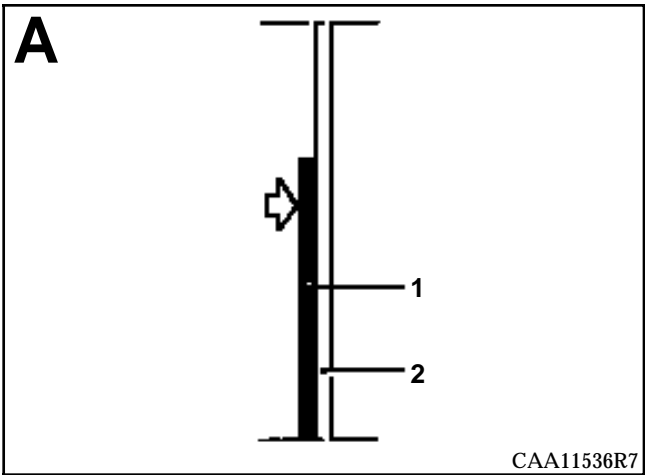
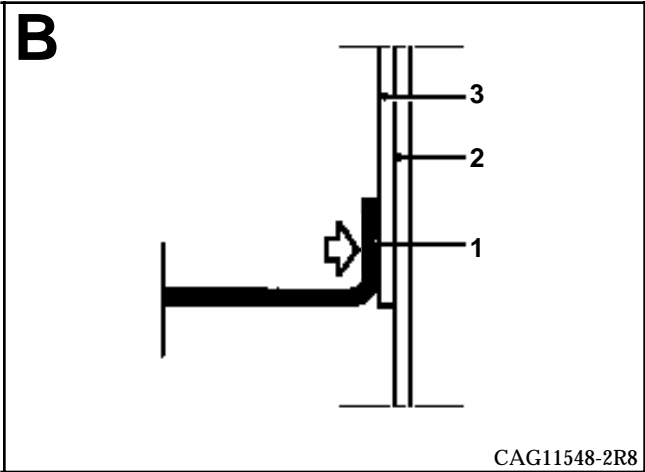
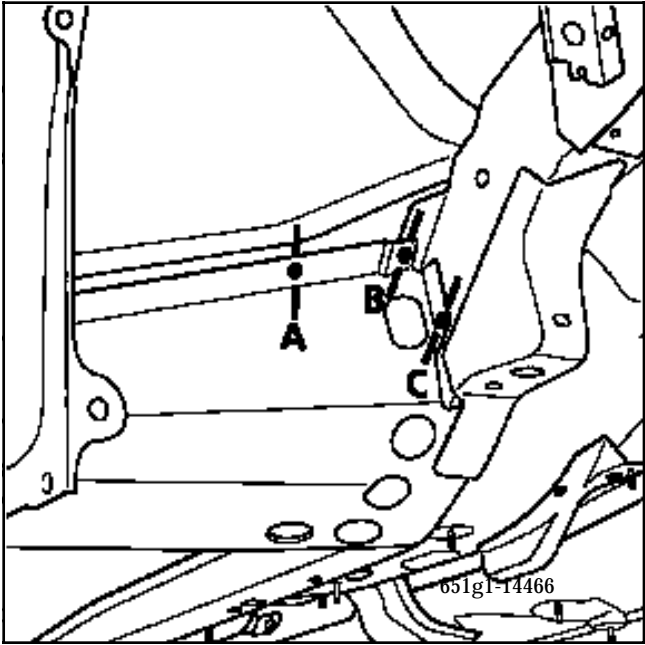
### COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

Part on its own.



### PARTS CONCERNED (thickness in mm) :

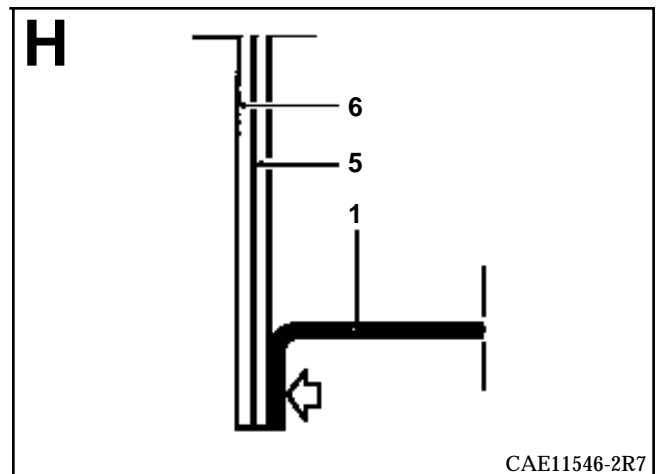
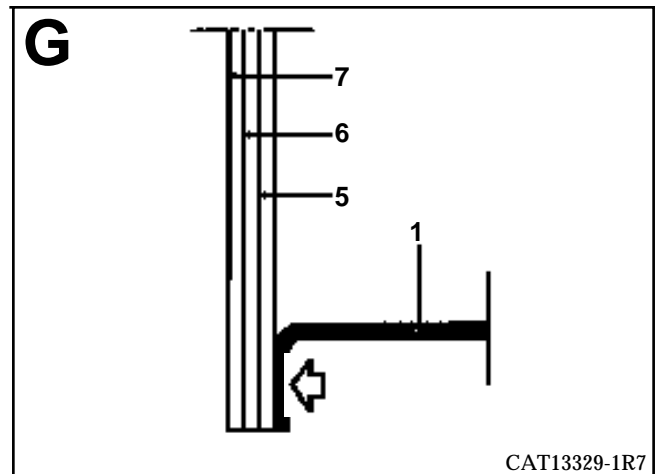
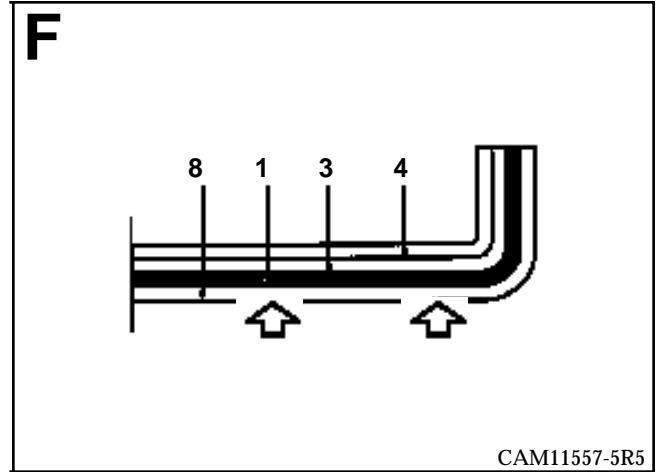
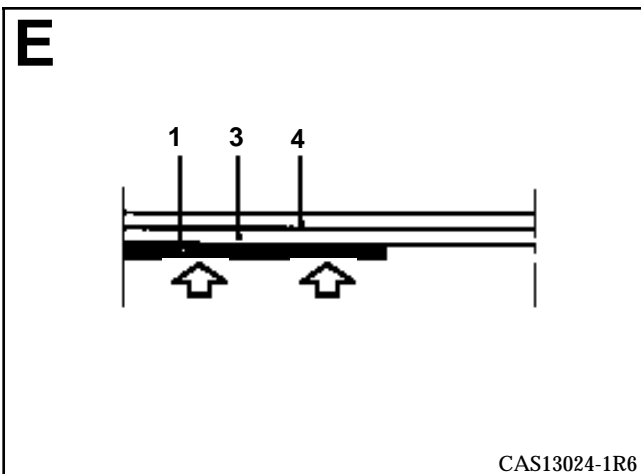
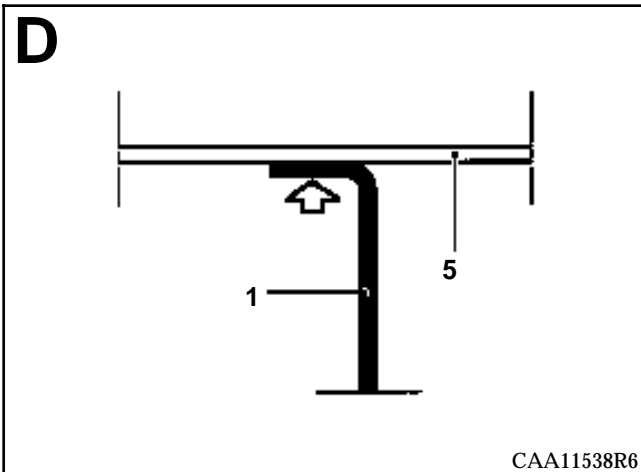
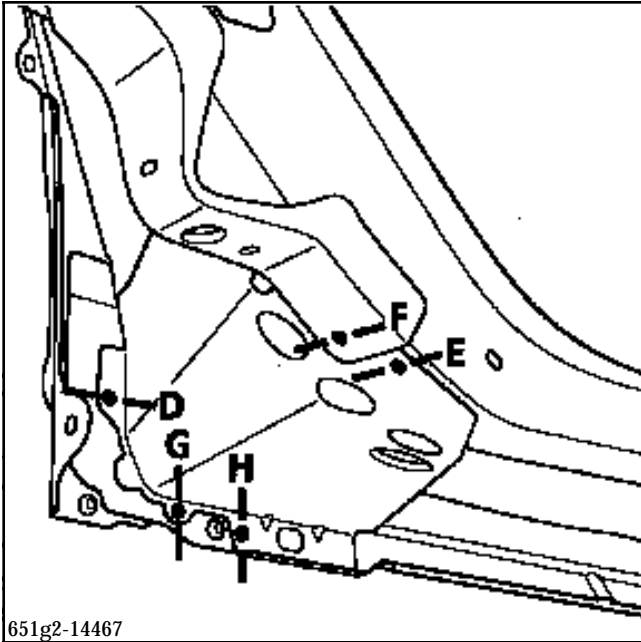
1	Front side cross member	1
2	Floor	1
3	Front side member, rear section	1.8
4	Front side member reinforcement, rear section	2.5
5	Sill panel closure panel	1.2
6	Sill panel reinforcement	0.7
7	Sill panel	1
8	Front sub-frame rear mounting	2.5



# LOWER STRUCTURE

## Front side cross member

41 G

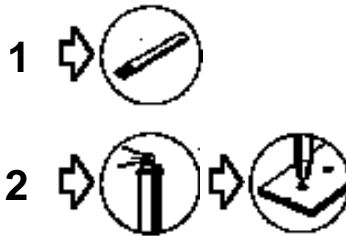
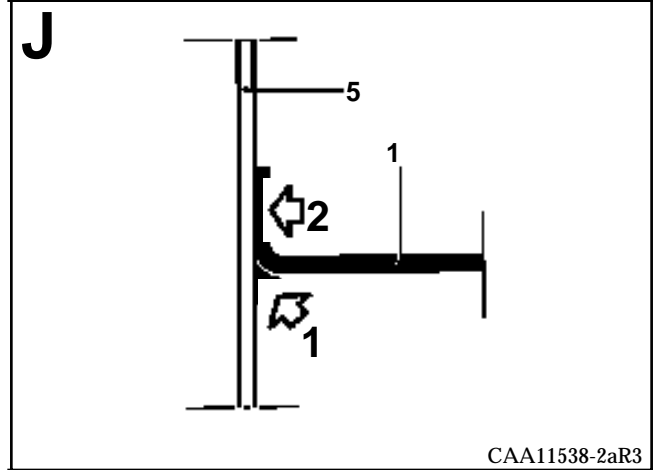
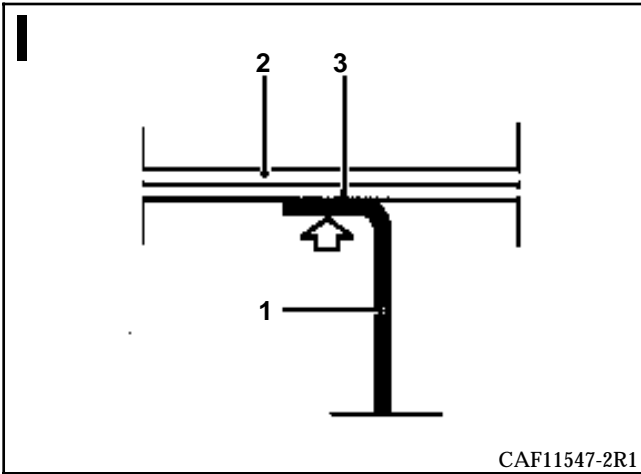
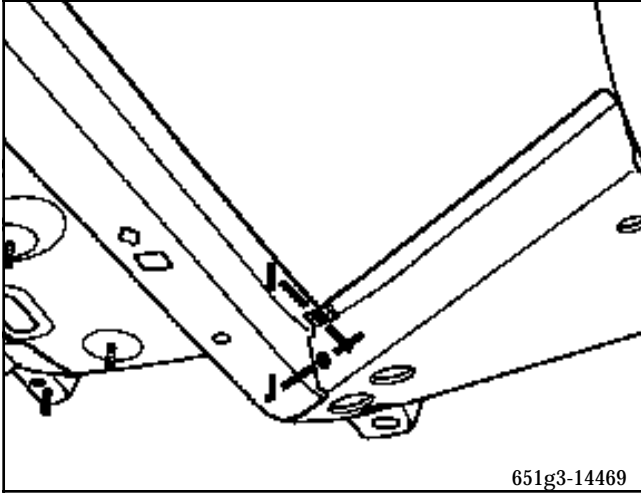


# LOWER STRUCTURE

## Front side cross member

41

G



### INTRODUCTION

The replacement of this part is a complementary operation to the replacement of the half unit.

In the operation described below, there are only descriptions of the joints specific to the part concerned.

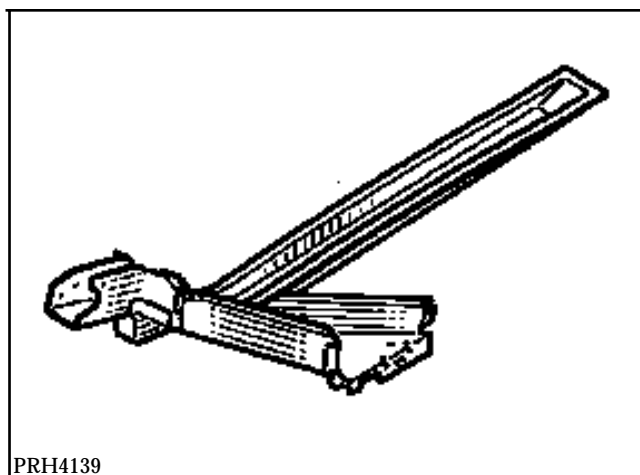
Information concerning the other parts will be dealt with in the respective sections (see contents).

The repair bench must be used.

### COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

Part assembled with :

- sub-frame front mounting ,
- front side cross member ,
- side member reinforcement.

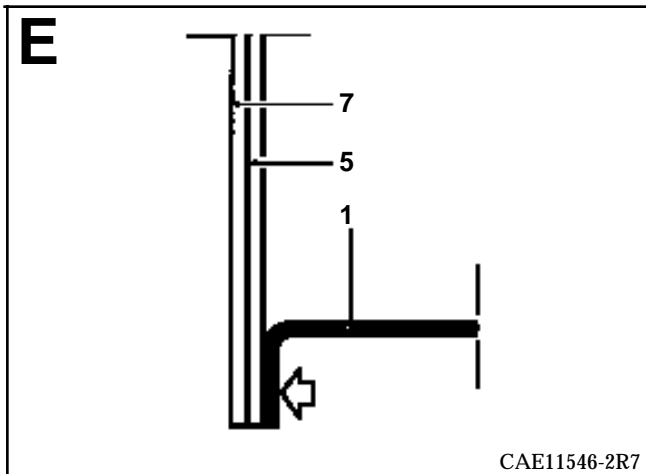
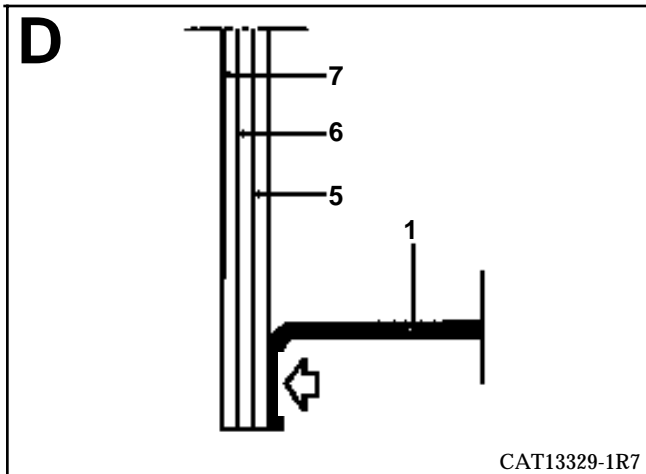
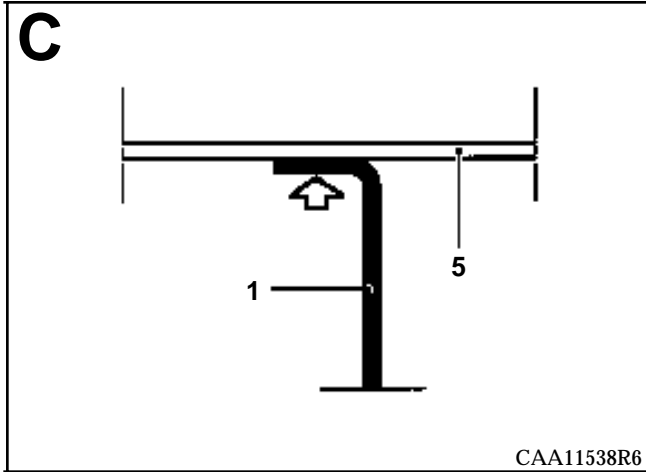
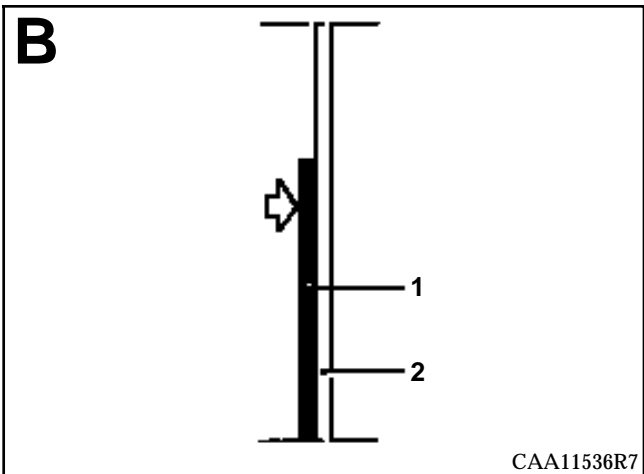
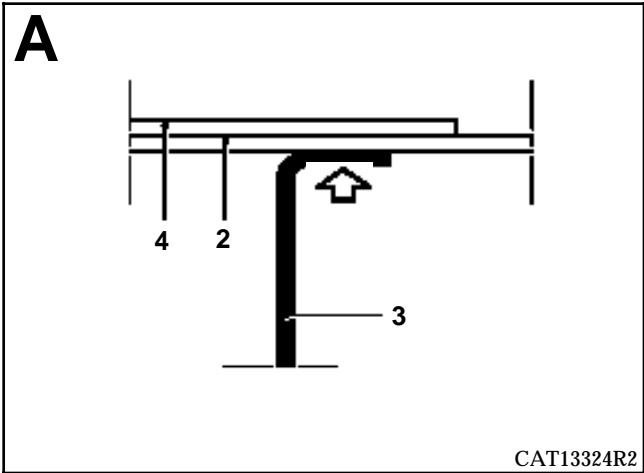
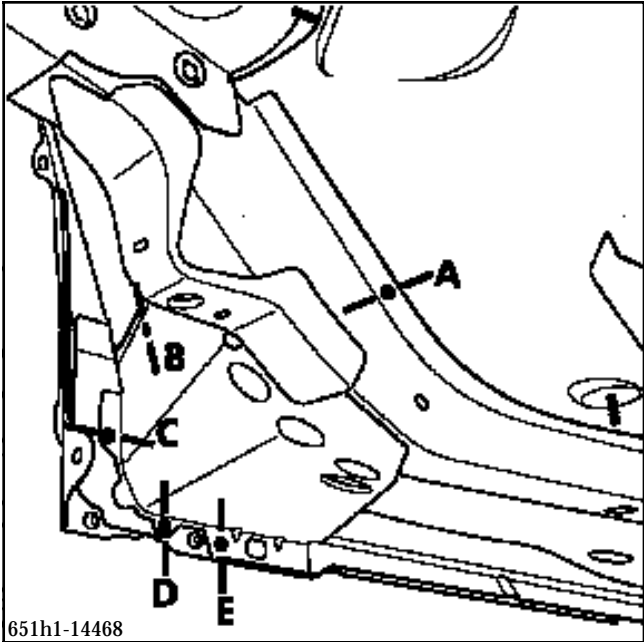


### PARTS CONCERNED (thickness in mm) :

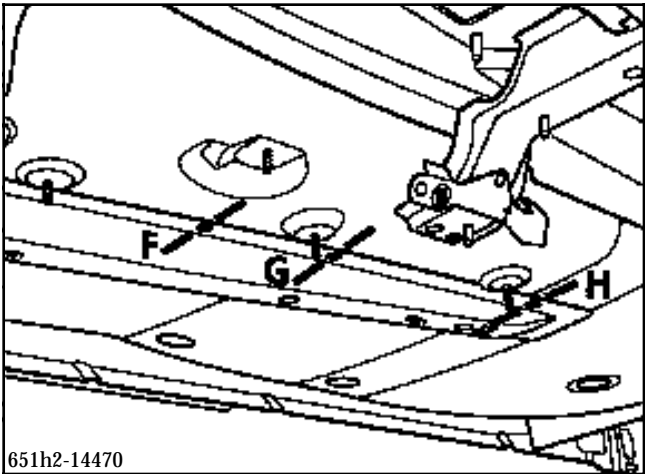
1	Front side cross member	1
2	Centre floor	1.47
3	Front side member, rear section	2
4	Front side member reinforcement	2.5
5	Sill panel closure panel	1
6	Sill panel reinforcement	1
7	Sill panel	1.2
8	Front sub-frame rear mounting	2.5
9	Front cross member under front seat	1
10	Rear cross member under front seat	1

LOWER STRUCTURE  
Front side member, rear section

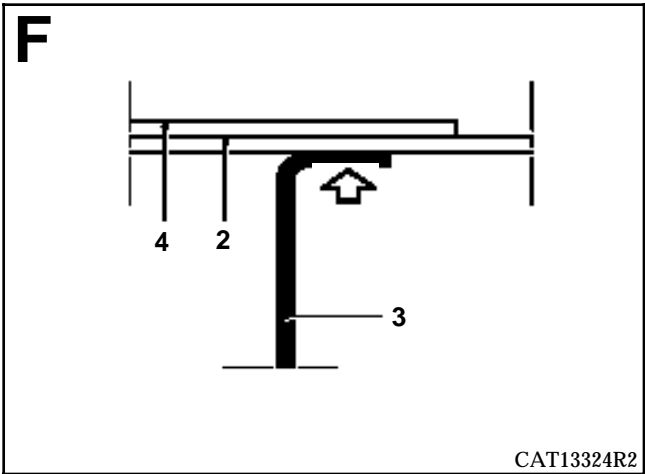
41 H



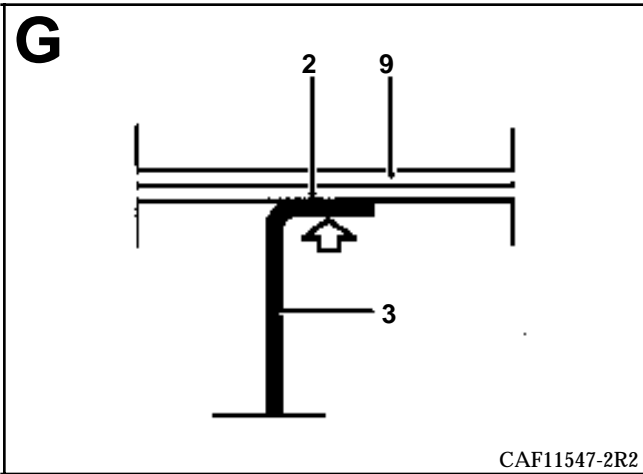




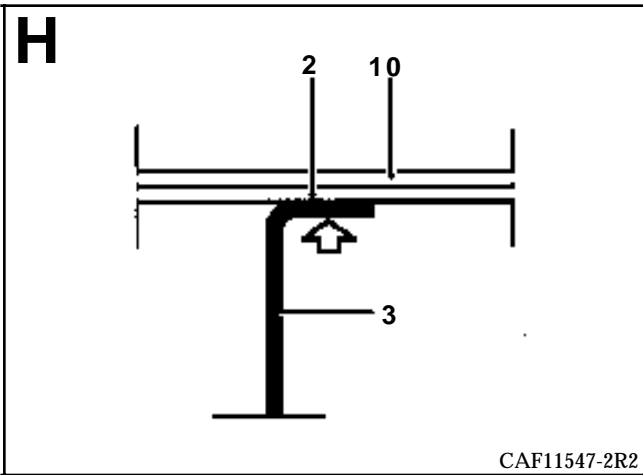
651h2-14470



CAT13324R2



CAF11547-2R2



CAF11547-2R2



INTRODUCTION

The replacement of this part is a complementary operation to the replacement of:

- 1 - For a frontal impact
  - front side member, rear section,
  - bulkhead.
- 2 - For a side impact
  - front pillar with lining,
  - sill panel closure panel

The replacement of this part is carried out in the same way for the front section as for the rear section (see cut in the method below).

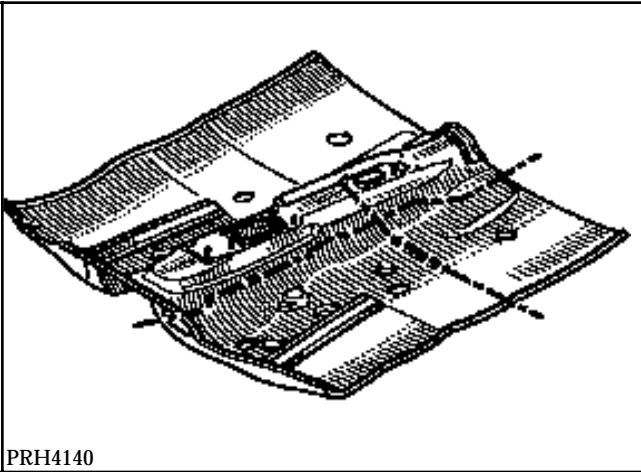
The repair bench must be used.

In the operation described below, there are only descriptions of the joints specific to the part concerned.

Information concerning the other parts will be dealt with in the respective sections (see contents).

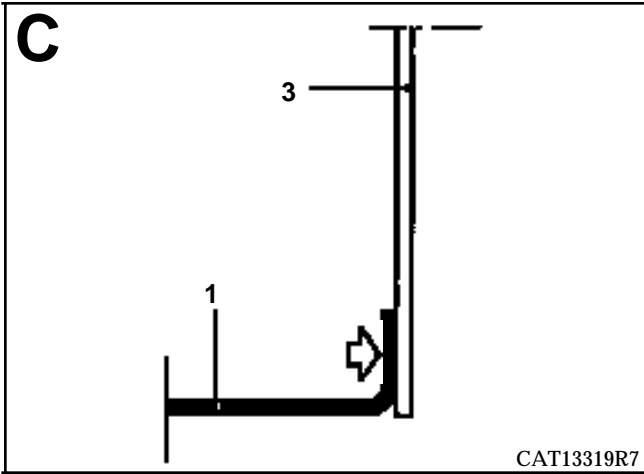
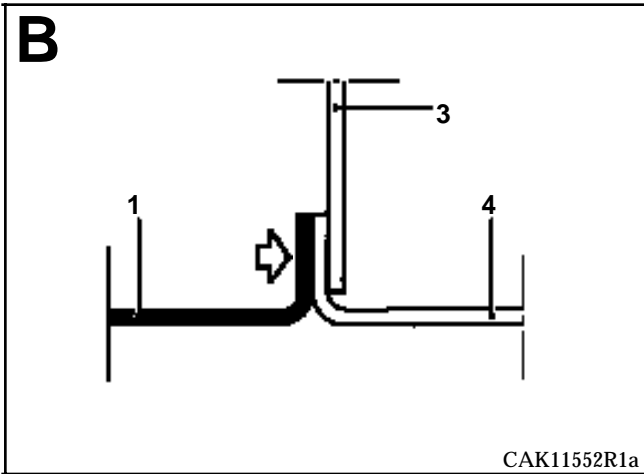
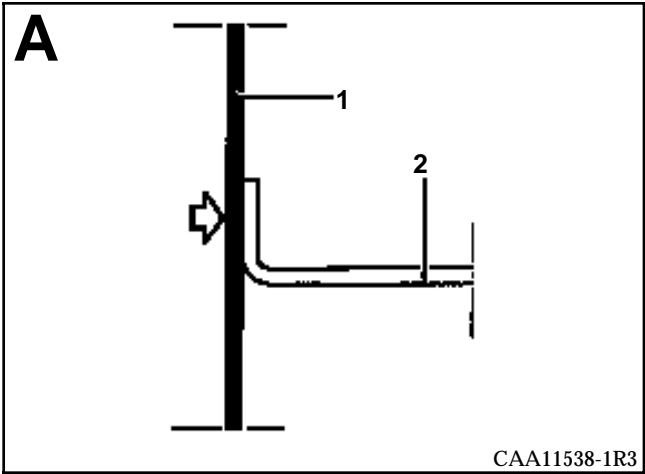
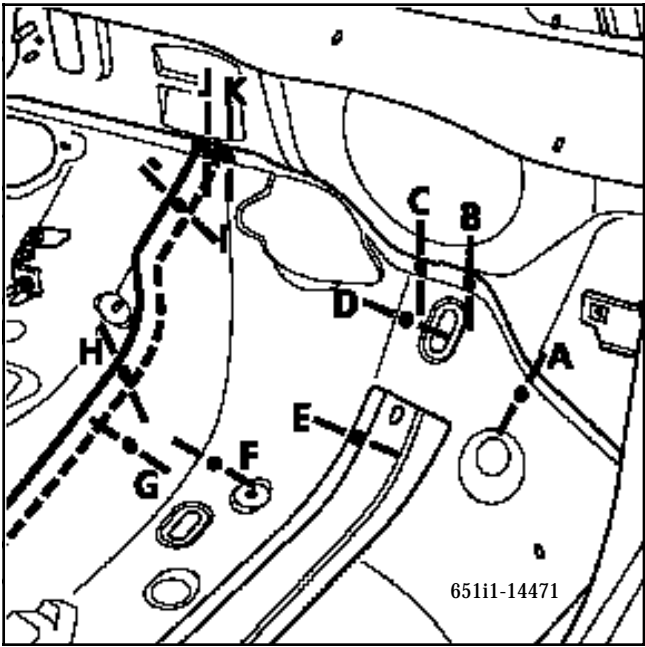
COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

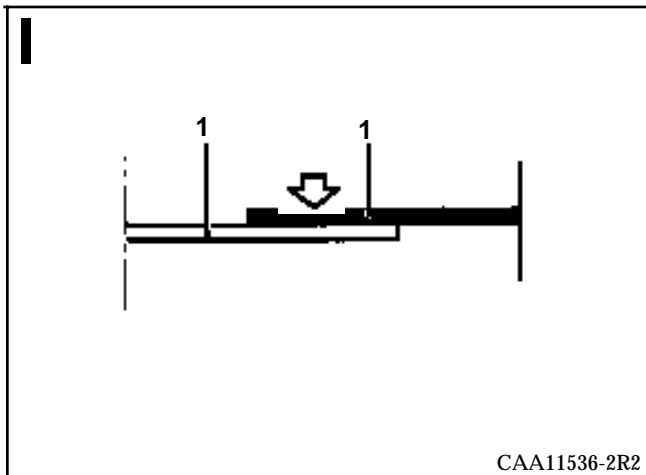
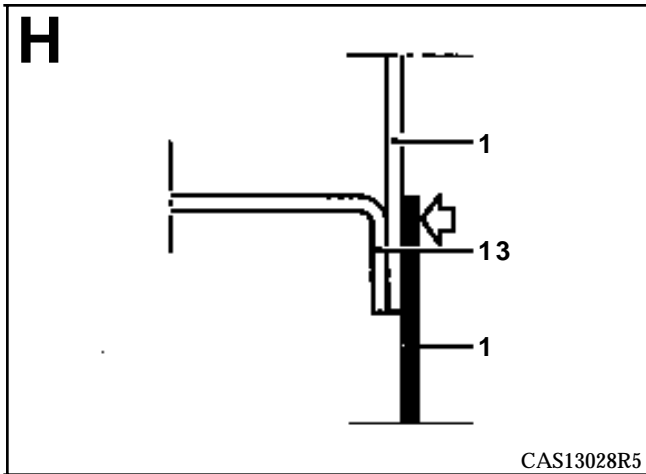
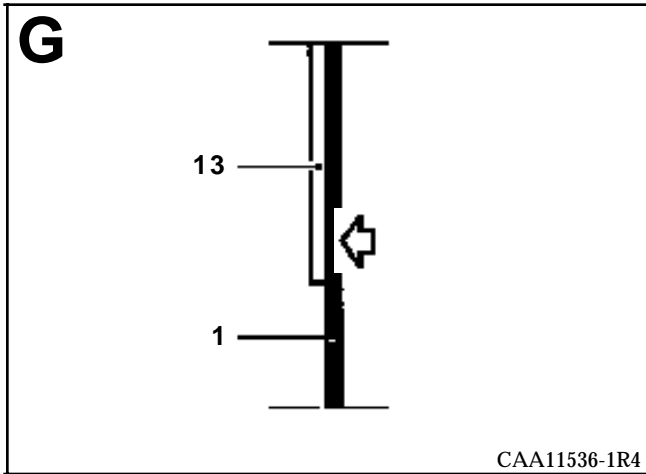
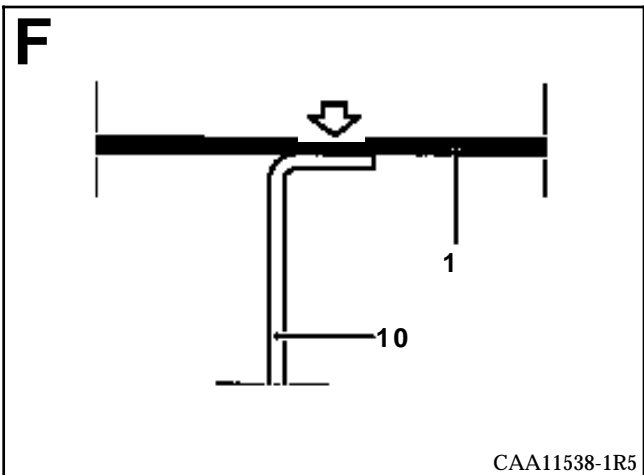
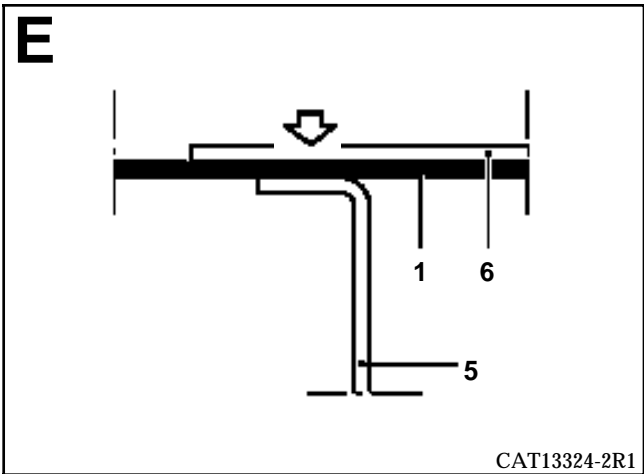
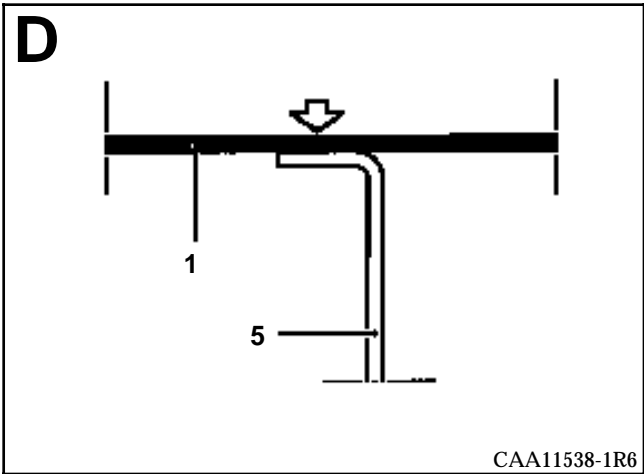
- Part assembled with :
- front cross member under front seat,
  - rear cross member under front seat,
  - bolts to be welded,
  - studs to be welded,
  - tunnel front reinforcement,
  - cable sleeve stop mounting,
  - front cross member of rear floor cross member.

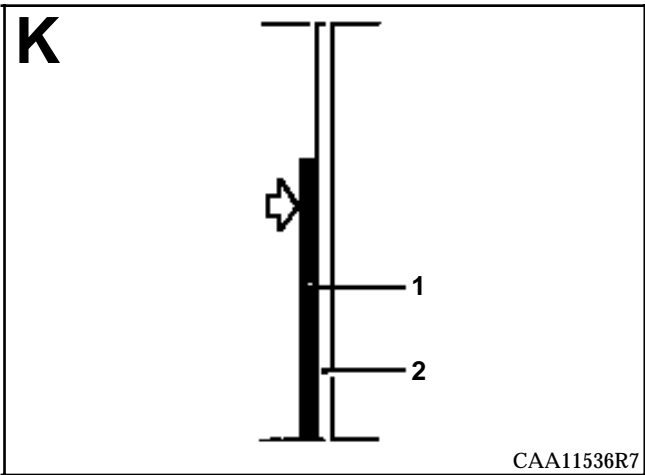
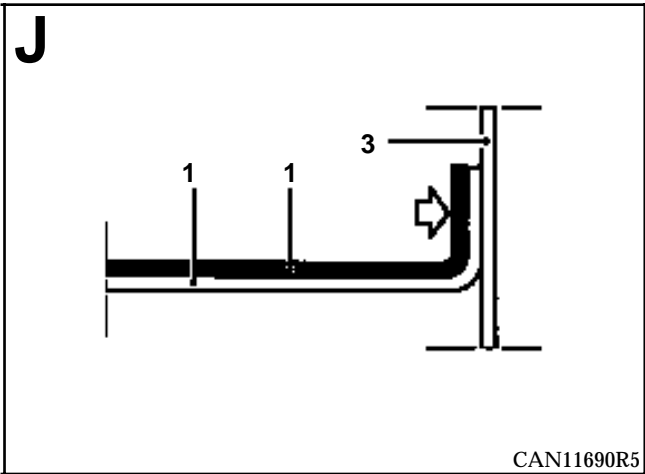


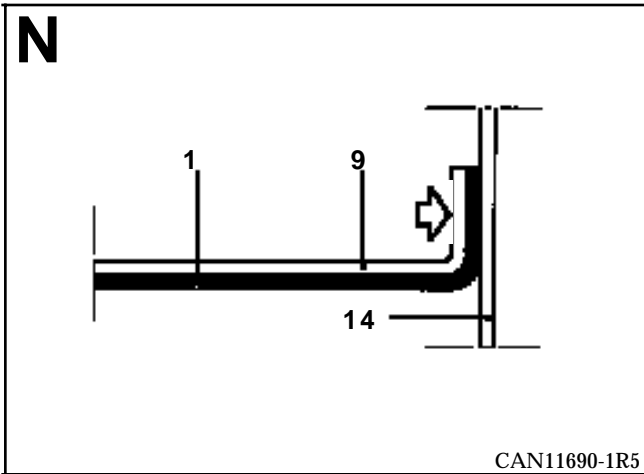
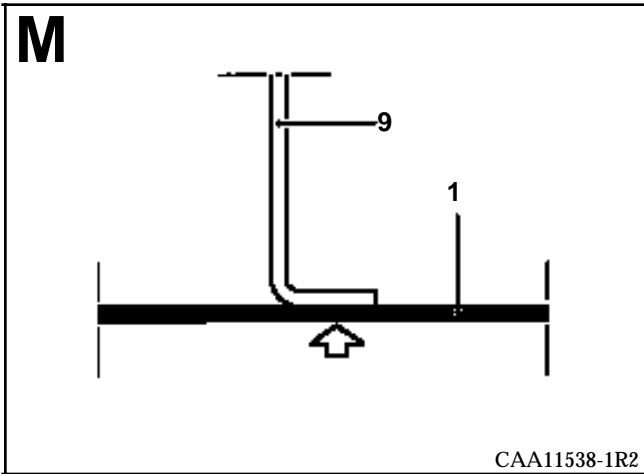
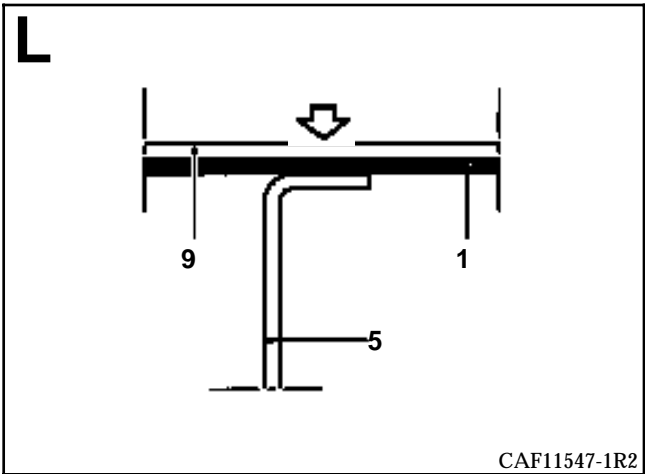
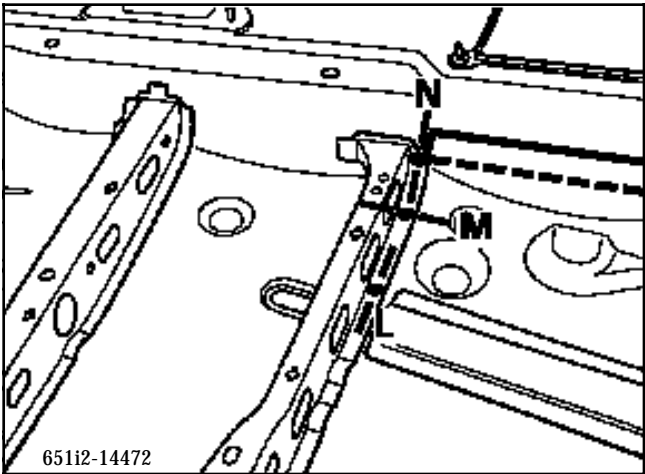
PARTS CONCERNED (thickness in mm) :

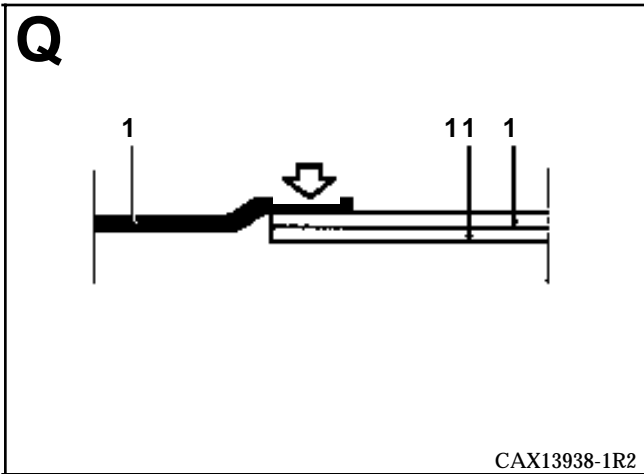
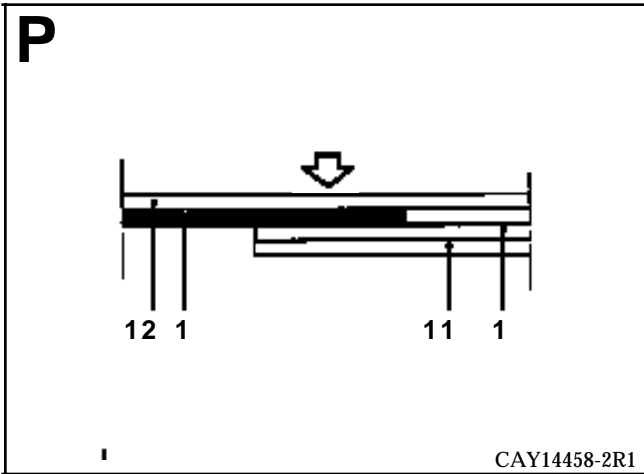
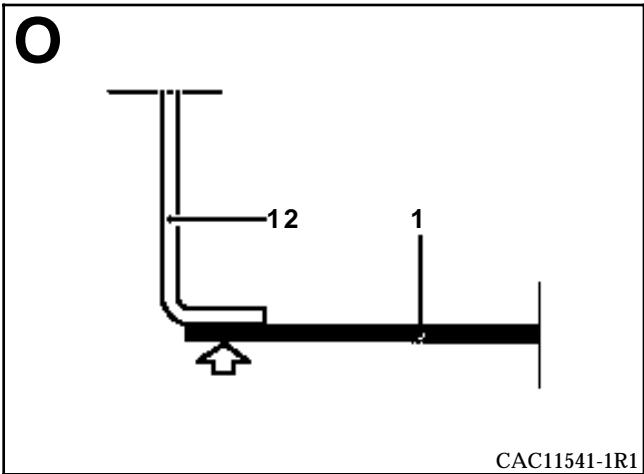
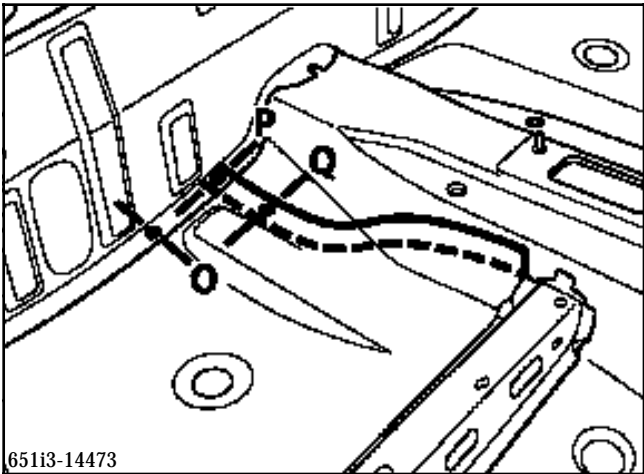
1	Centre floor	1.47
2	Front side cross member	1
3	Bulkhead	0.7
4	Front side member	1.5
5	Front side member, rear section	2
6	Front side member reinforcement	2.5
7	Tunnel reinforcement	1
8	Rear cross member under front seat	1
9	Front cross member under front seat	1
10	Tunnel front reinforcement	1
11	Cable sleeve stop mounting	1.2
12	Front cross member of rear floor cross member	1.5
13	Tunnel reinforcement	1.5
14	Sill panel closure panel	1











### INTRODUCTION

The replacement of this part is a complementary operation to the replacement of the sill panel closure panel following a side impact.

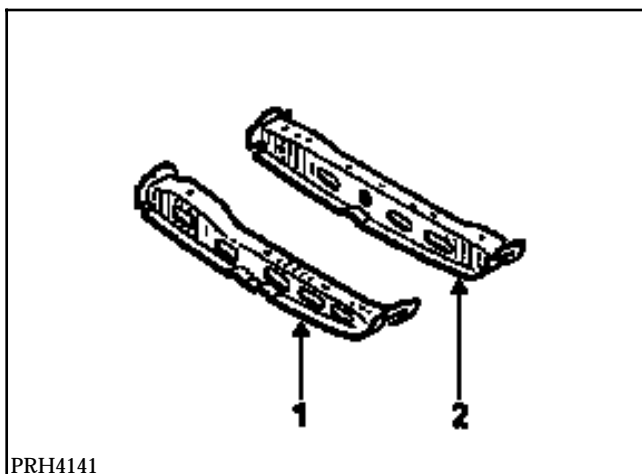
In the operation described below, there are only descriptions of the joints specific to the part concerned.

Information concerning the other parts will be dealt with in the respective sections (see contents).

### COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

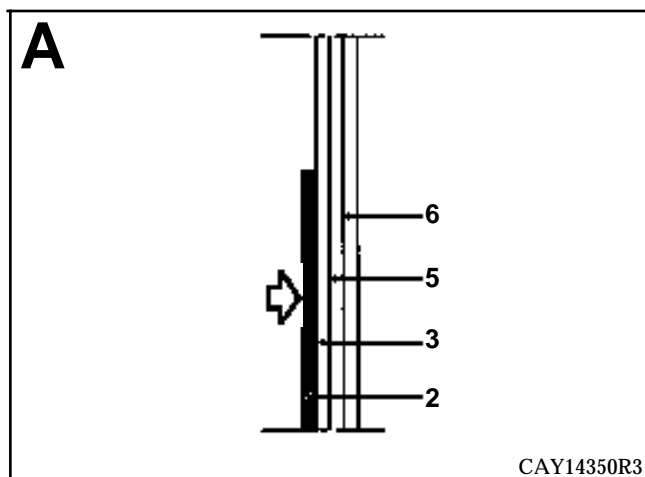
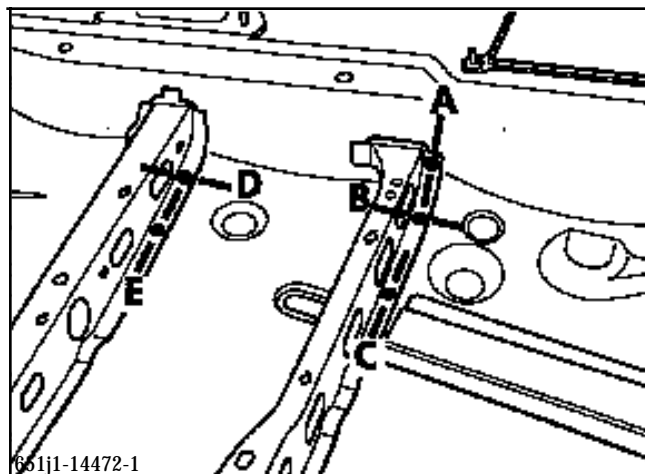
**1 - Front cross member under front seat**  
Part assembled with front seat spacer.

**2 - Rear cross member under front seat**  
Part assembled with front seat spacer.

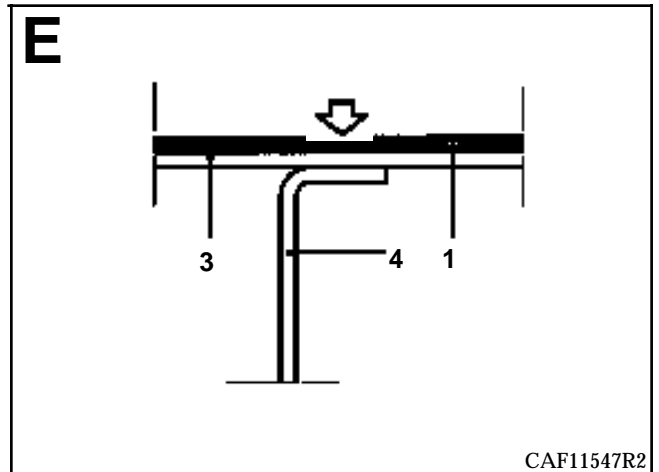
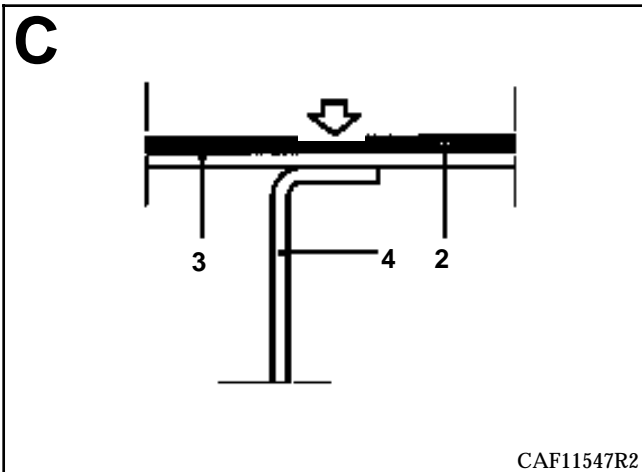
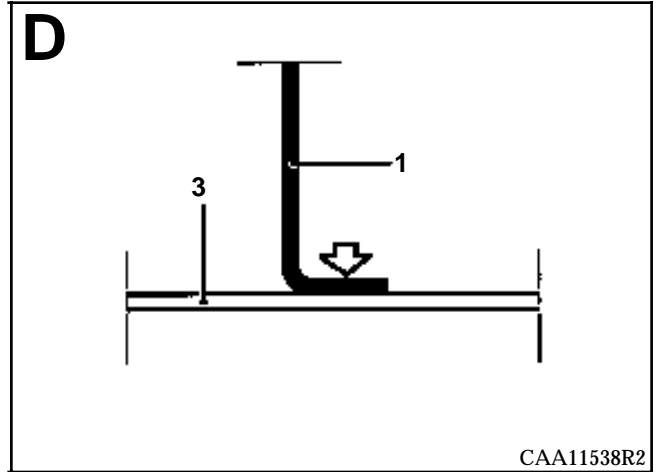
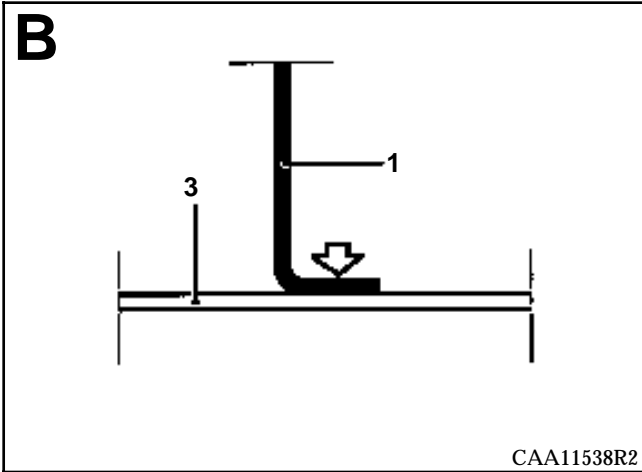


### PARTS CONCERNED (thickness in mm) :

1	Rear cross member under front seat	1
2	Front cross member under front seat	1
3	Centre floor	1.47
4	Front side member, rear section	2
5	Tunnel reinforcement	1.5
6	Tunnel front reinforcement	1.5







INTRODUCTION

The replacement of this part is a complementary operation to the replacement of a body side lining or a wheel arch for a side impact.

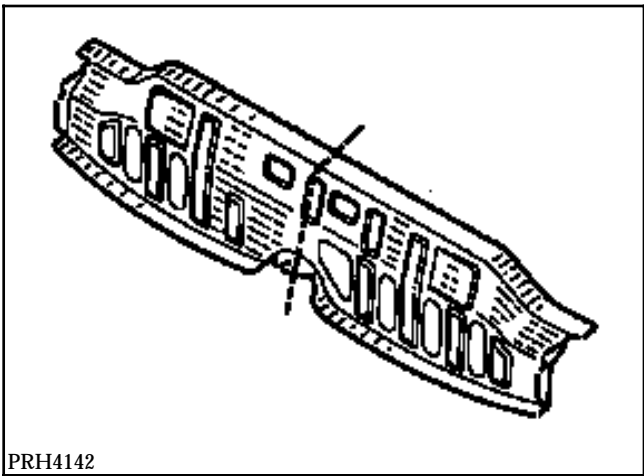
This operation is carried out partially (see cut and method below).

In the operation described below, there are only descriptions of the joints specific to the part concerned.

Information concerning the other parts will be dealt with in the respective sections (see contents).

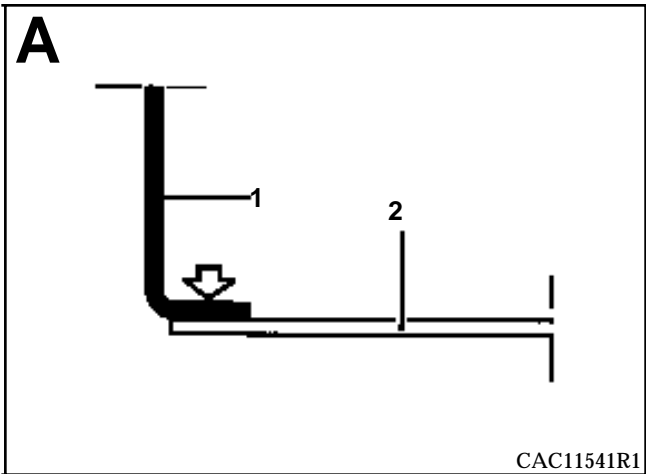
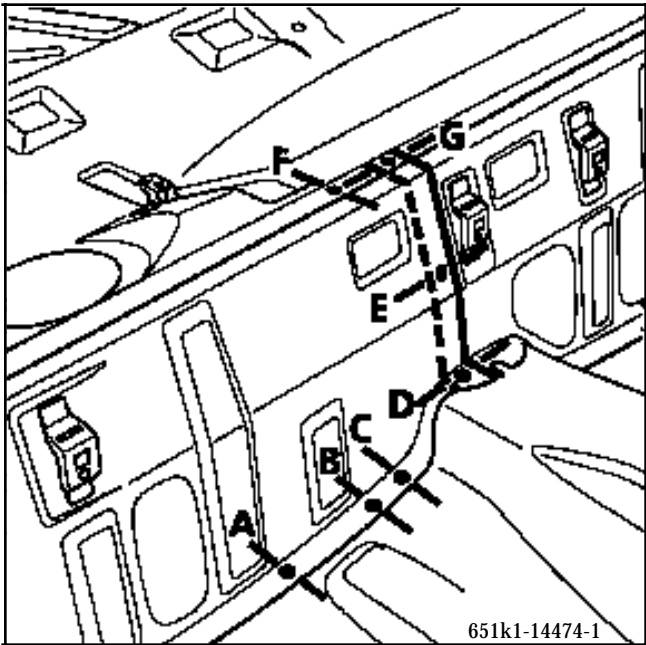
COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

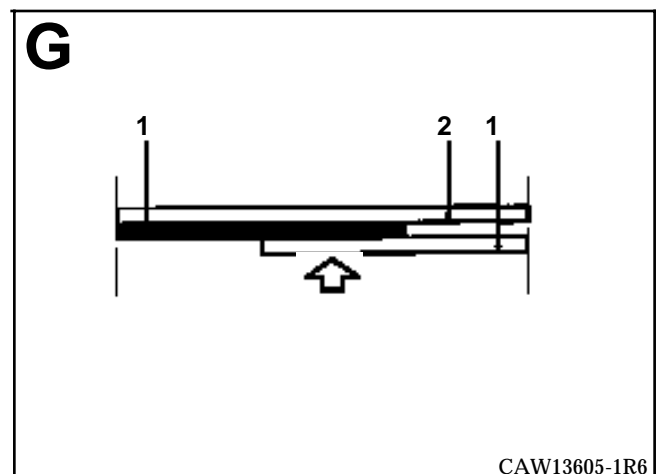
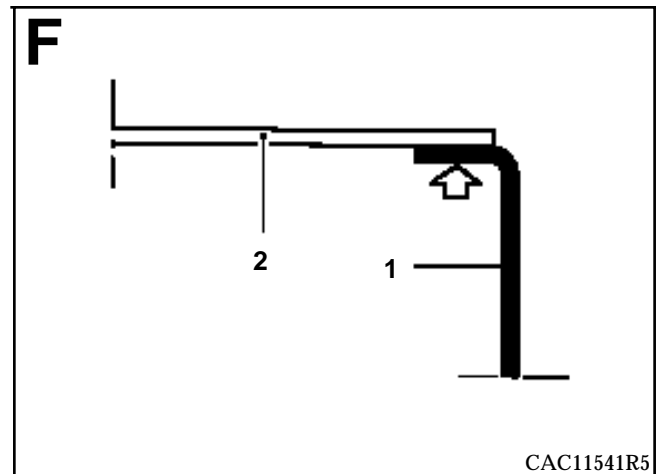
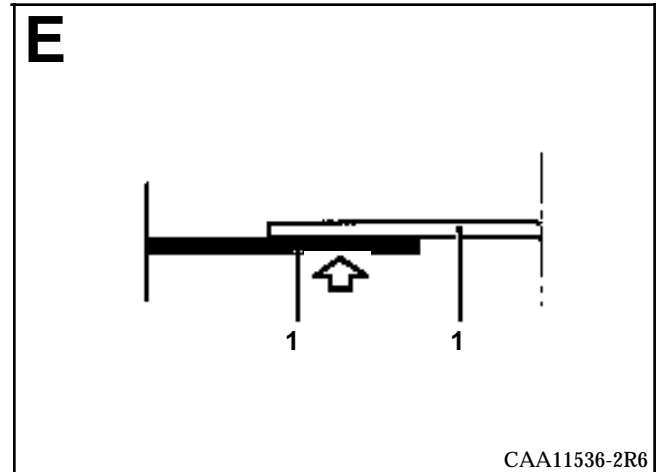
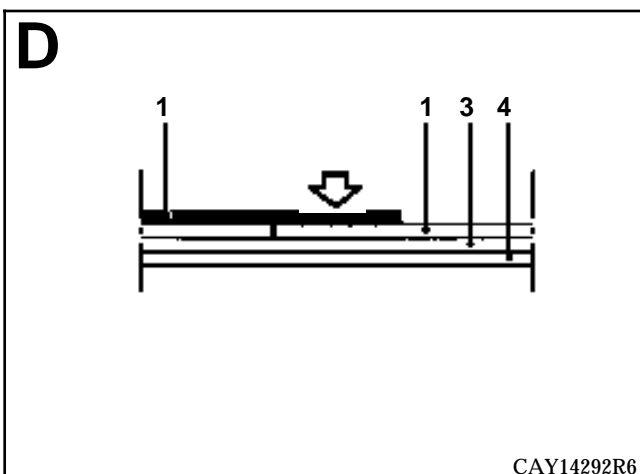
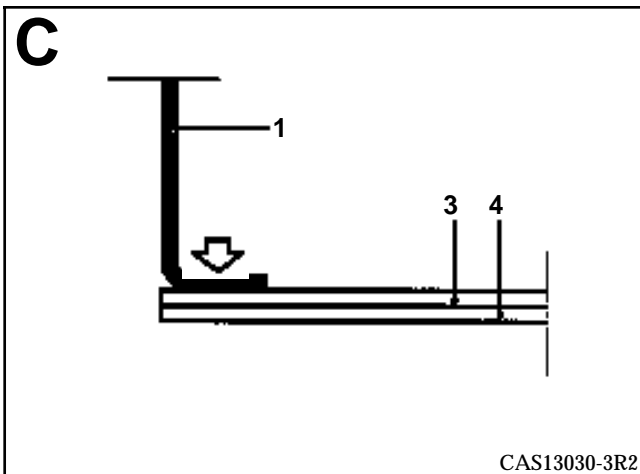
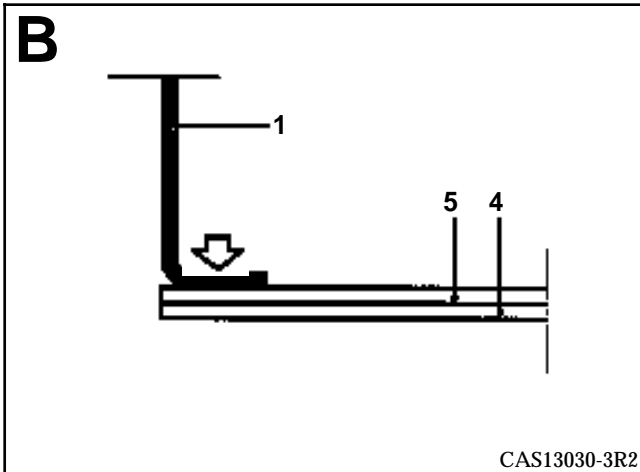
Part assembled with fuel tank mounting.



PARTS CONCERNED (thickness in mm) :

1	Rear floor raised section	1.5
2	Rear floor	0.7
3	Tunnel reinforcement	1
4	Cable sleeve stop mounting	1.2
5	Centre floor	1.47





INTRODUCTION

The replacement of this part is a complementary operation to the replacement of the sill panel closure panel, rear section.

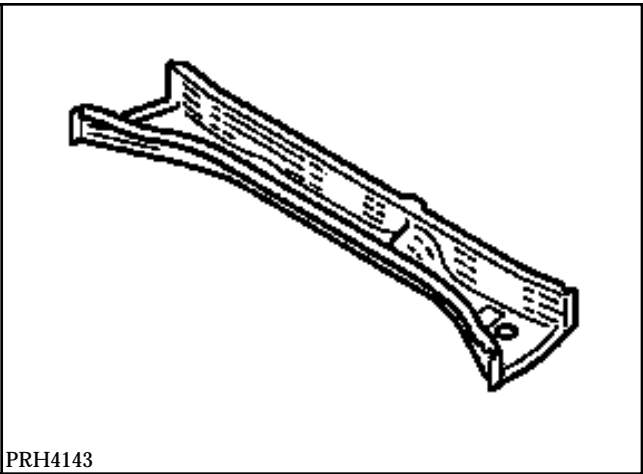
In the operation described below, there are only descriptions of the joints specific to the part concerned.

Information concerning additional parts will be dealt with in the respective section (see contents).

COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

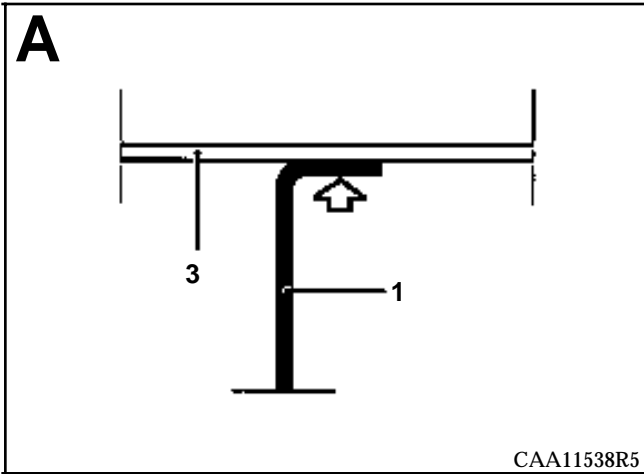
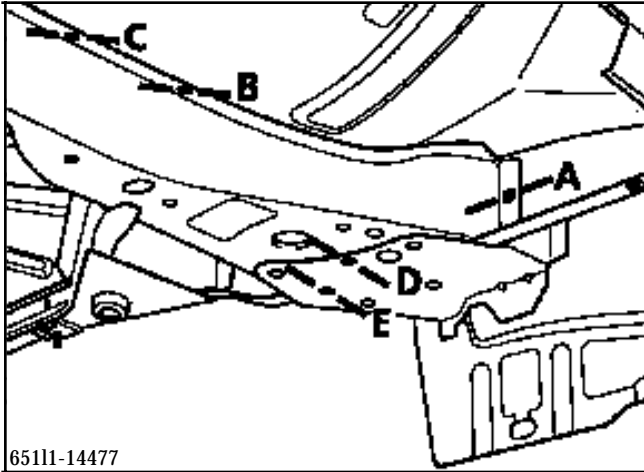
Part assembled with :

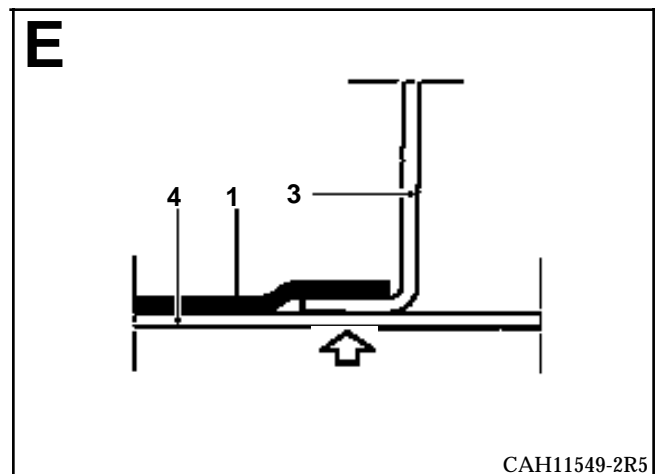
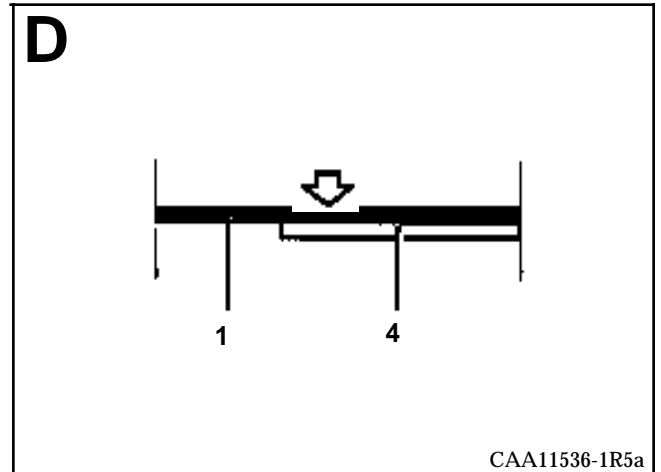
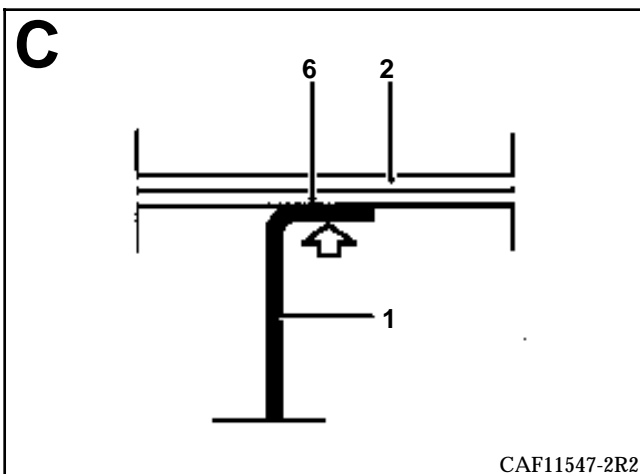
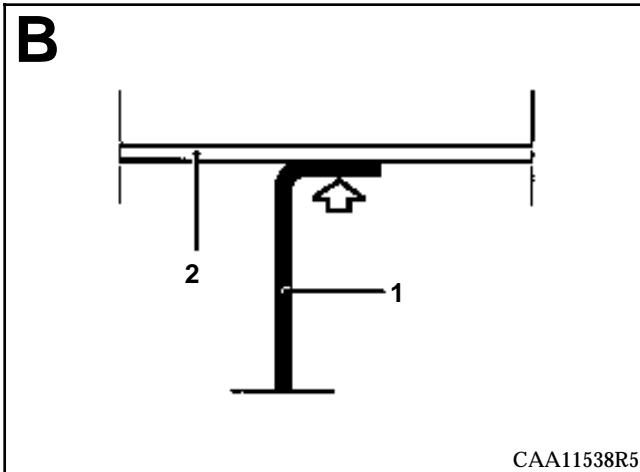
- nut to be welded,
- seat belt mounting,
- seat back mounting reinforcement.

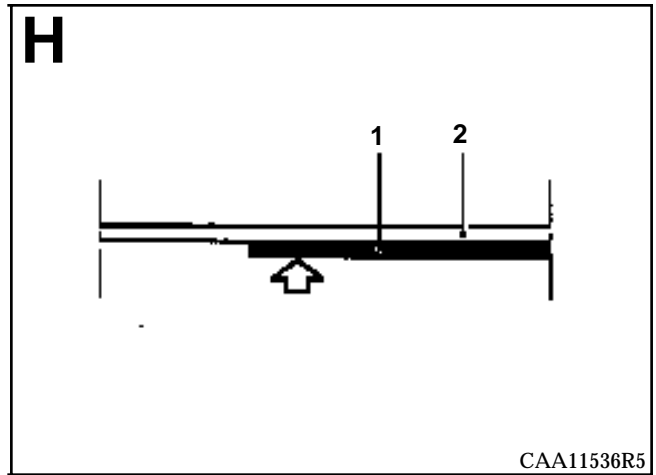
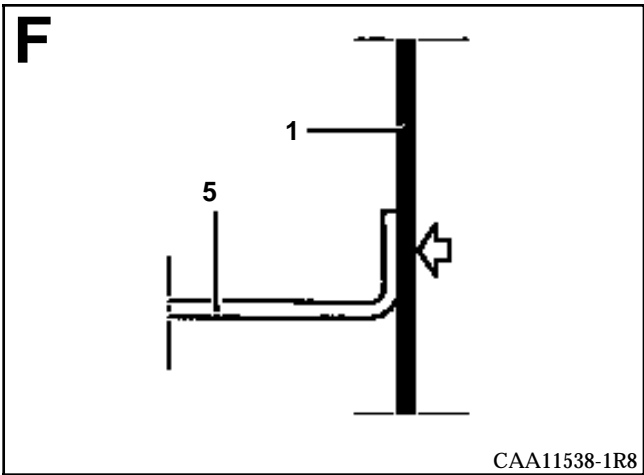
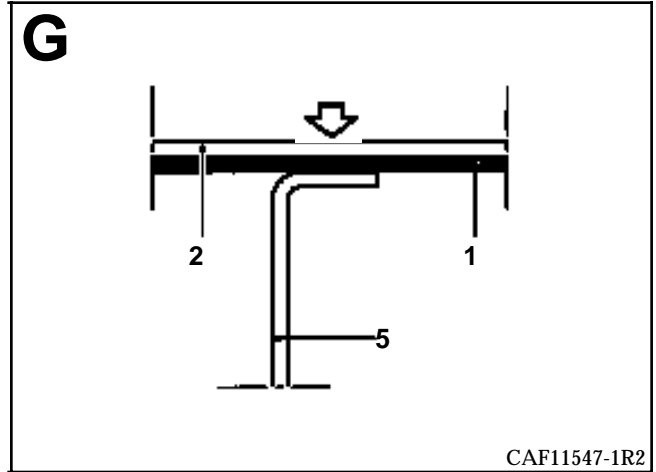
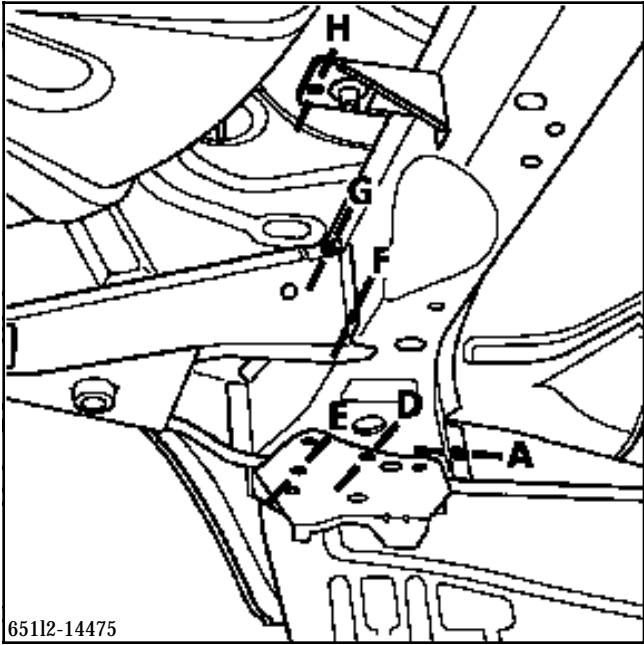


PARTS CONCERNED (thickness in mm):

1	Rear floor centre cross member	1.2
2	Rear floor	0.7
3	Rear side member	1.2
4	Rear axle assembly mounting unit	1
5	Side member / cross member joining component	1.5
6	Seat belt mounting support	1.2
7	Seat back mounting reinforcement	1.2







INTRODUCTION

The replacement of this part can be carried out in two ways:

- A - Complete rear side member**  
(for a rear impact)  
In this case it is a complementary operation to the sill panel closure panel.
- B - Complete rear side member, part section**  
(for a rear side impact) (cut to be made in front of the side member reinforcement), see cut, diagram and method below.  
In this case it is a complementary operation to the rear end panel.

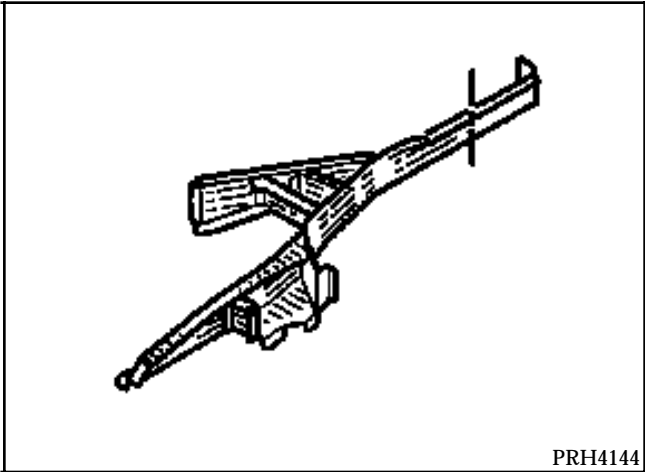
In the operation described below, there are only descriptions of the joints specific to the part concerned.

Information concerning additional parts will be dealt with in the respective section (see contents).

The repair bench must be used when replacing the complete side member.

COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

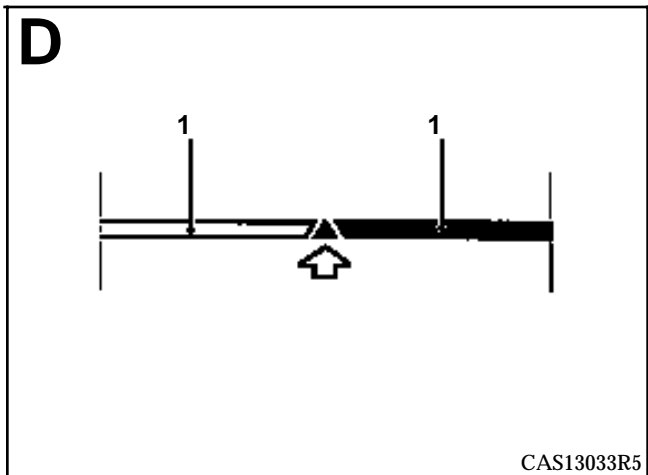
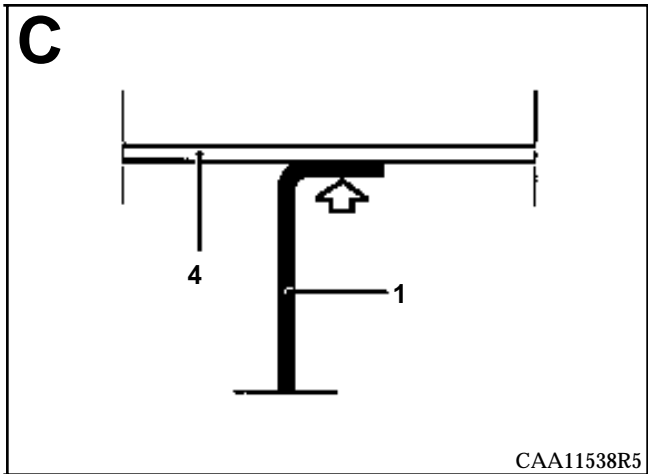
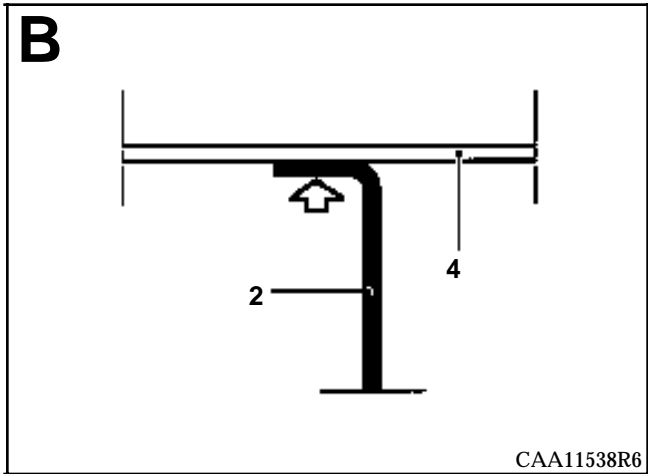
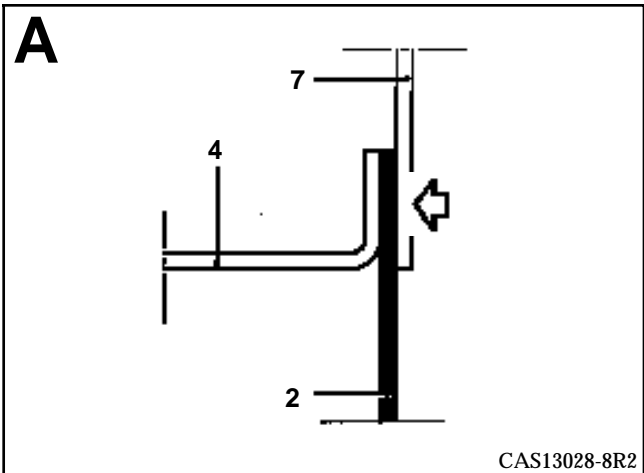
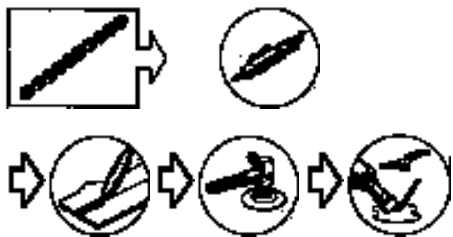
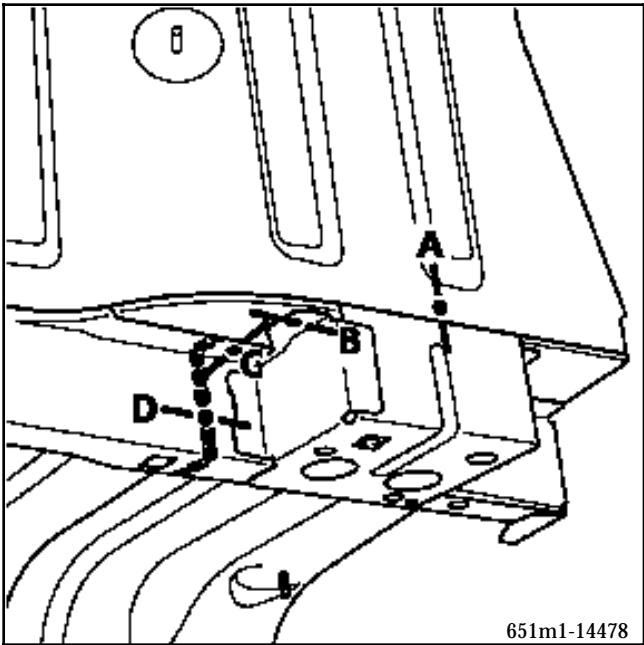
- Part assembled with :
- welded nuts,
  - exhaust mounting (left hand side),
  - rear axle assembly mounting unit,
  - rear axle assembly mounting spacer,
  - rear side member reinforcement,
  - towing ring mounting,
  - rear suspension spring cup,
  - rear suspension spring cup reinforcement,
  - side member / cross member joining component .



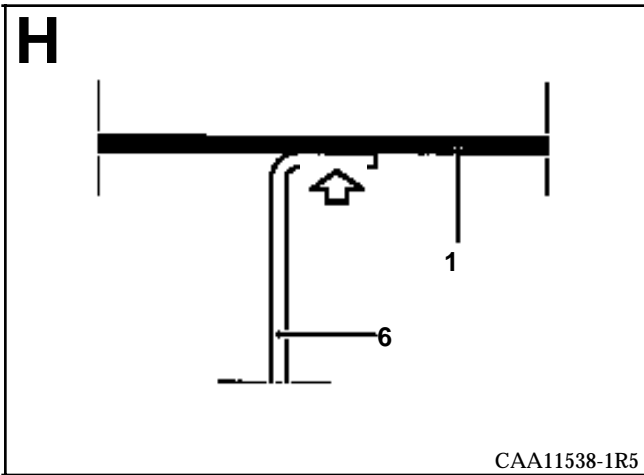
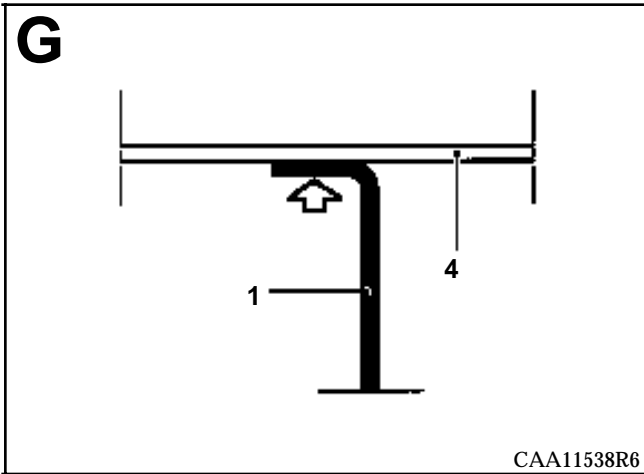
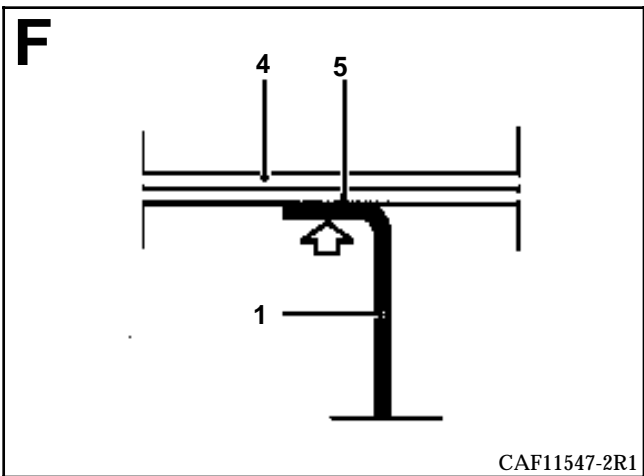
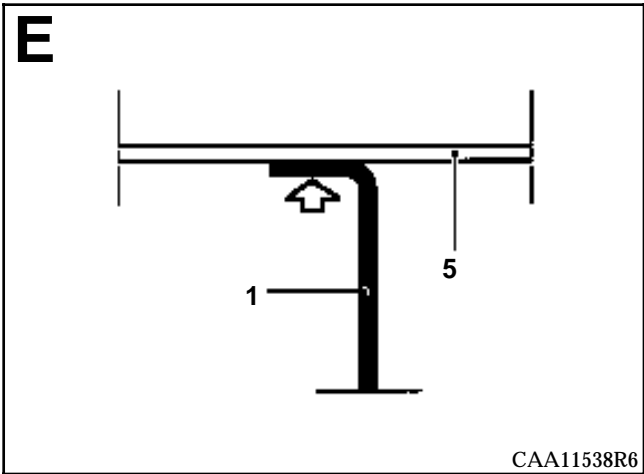
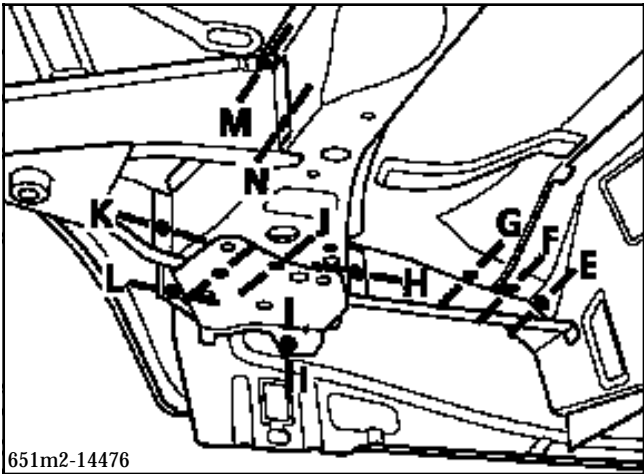
PRH4144

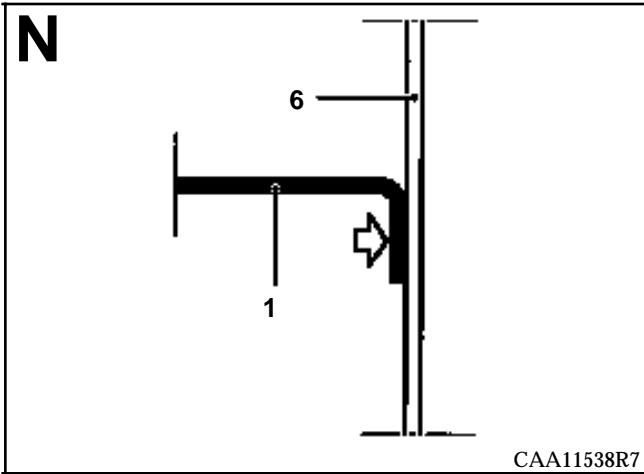
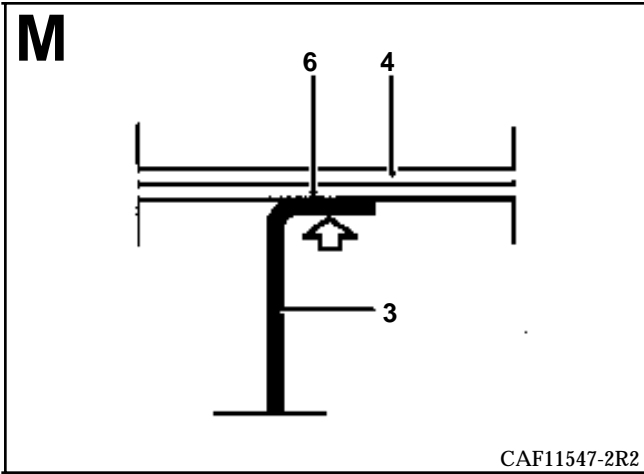
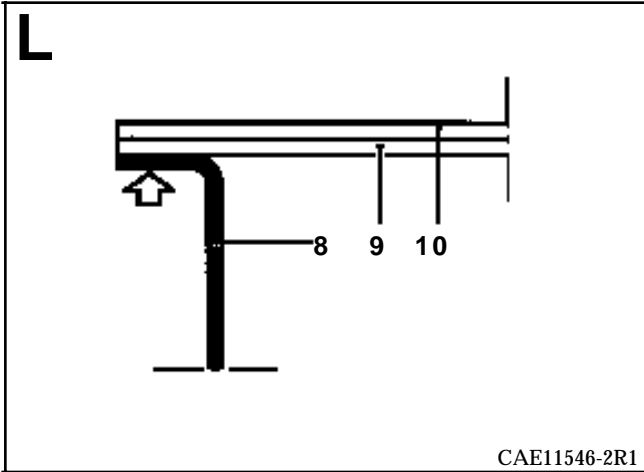
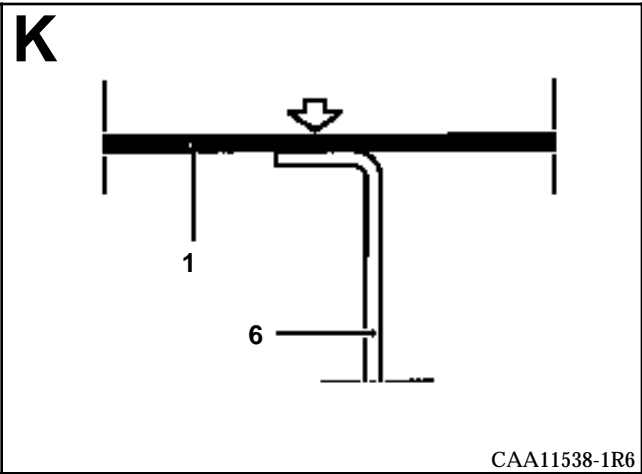
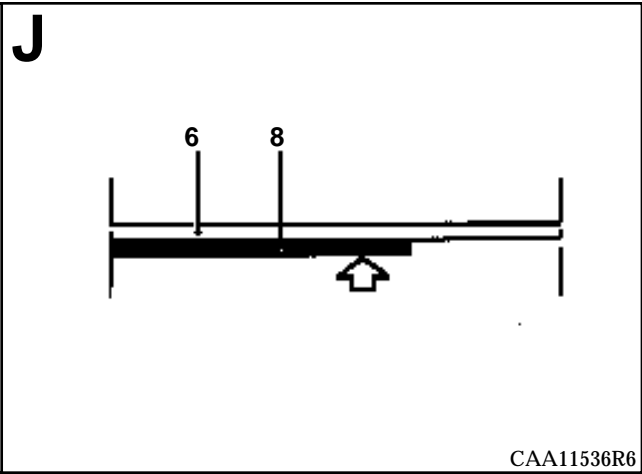
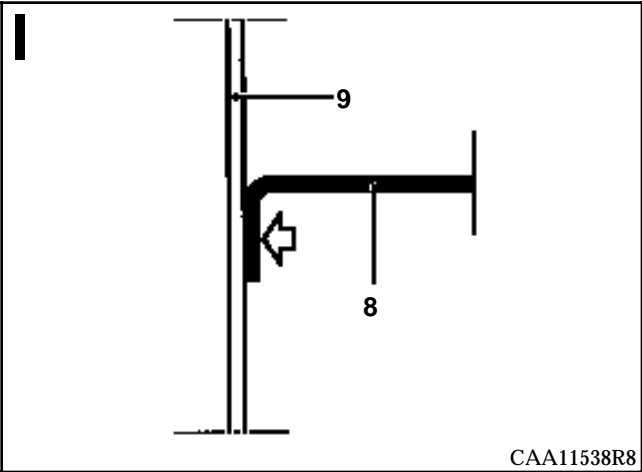
PARTS CONCERNED (thickness in mm):

1	Rear side member	1.8
2	Exhaust mounting unit	1.2
3	Side member / cross member joining component	1.5
4	Rear floor	0.7
5	Front cross member of rear floor cross member	1.5
6	Rear floor centre cross member	1.2
7	Wheel arch	0.8
8	Rear axle assembly mounting unit	1
9	Sill panel closure panel	1
10	Sill panel reinforcement	1









INTRODUCTION

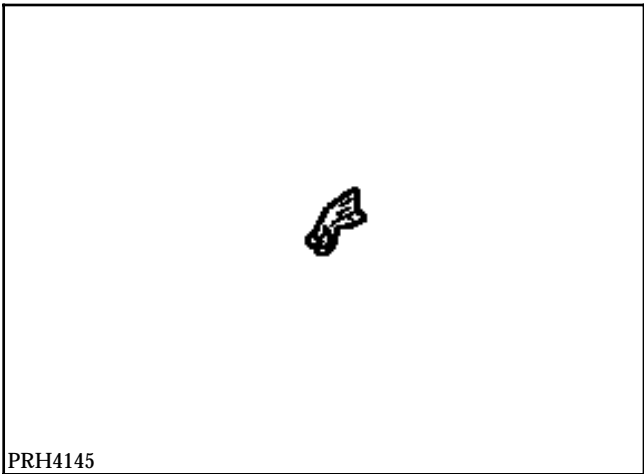
The replacement of this part is a complementary operation to the partial floor for a rear impact.

In the operation described below, there are only descriptions of the joints specific to the part concerned.

Information concerning additional parts will be dealt with in the respective section (see contents).

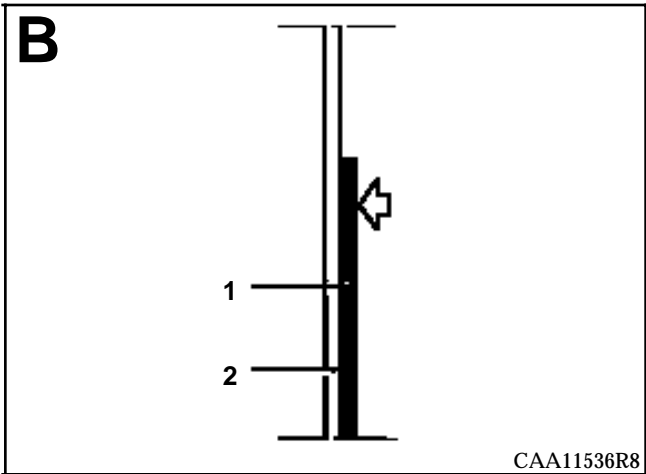
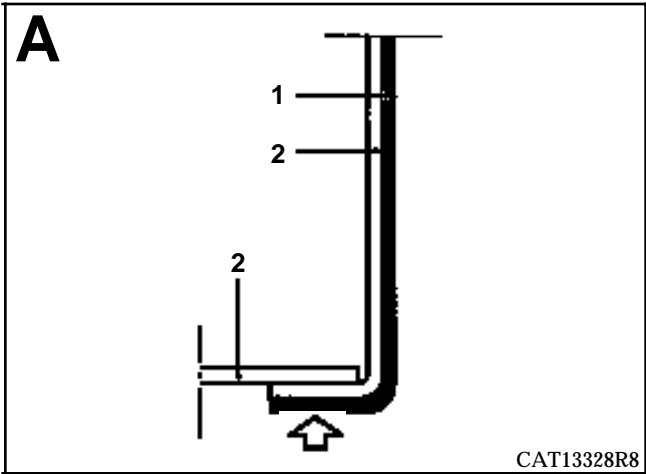
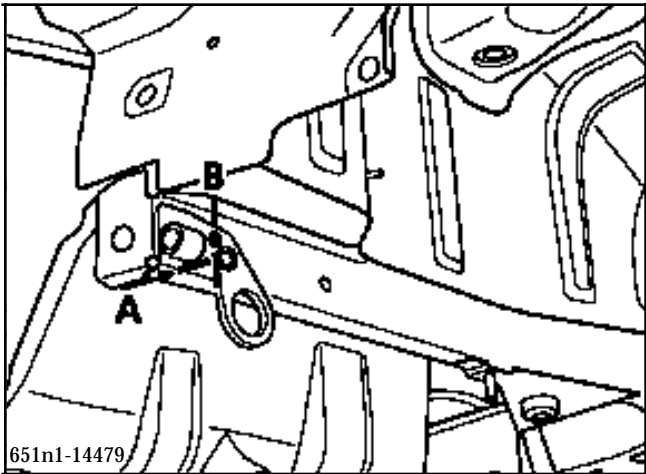
COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

Part assembled with a threaded support.



PARTS CONCERNED (thickness in mm):

- |   |                  |     |
|---|------------------|-----|
| 1 | Towing ring      | 1.5 |
| 2 | Rear side member | 1.8 |



INTRODUCTION

The replacement of this part is a complementary operation to the replacement of the :

**A - Cut for a side impact :**  
of the rear sill panel closure panel.

**B - Cut for a rear impact :**  
of the rear end panel.

This operation is carried out partially , with three possibilities (see cut in the diagram below) :

- rear left hand section,
- rear right hand section,
- front section.

In the operation described below, there are only descriptions of the joints specific to the part concerned.

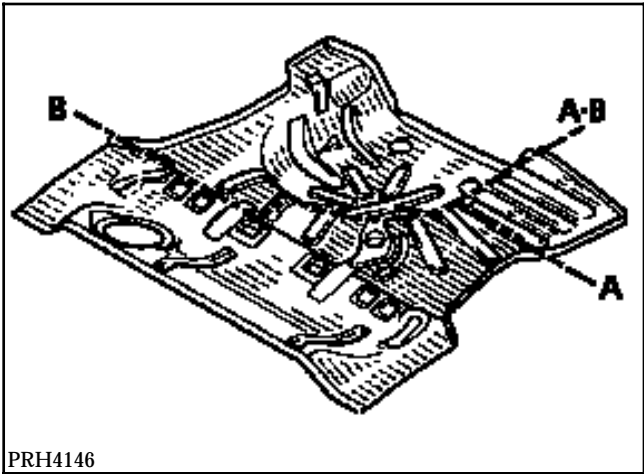
Information concerning additional parts will be dealt with in the respective section (see contents).

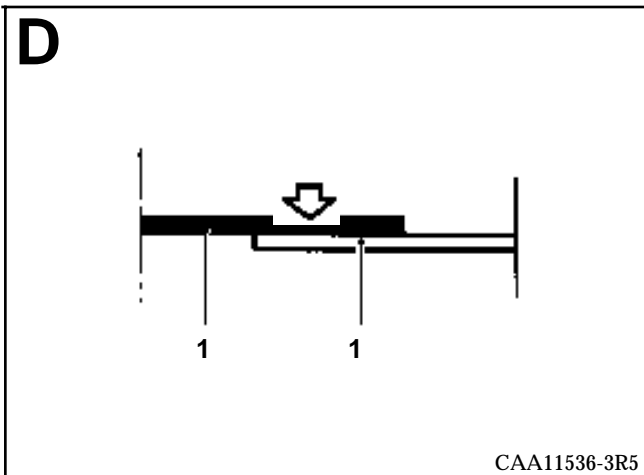
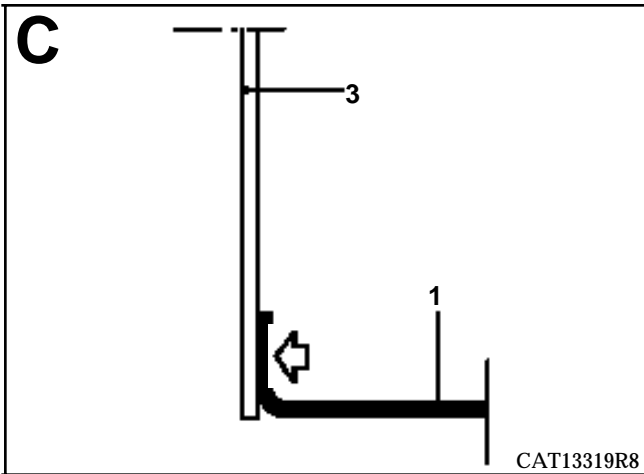
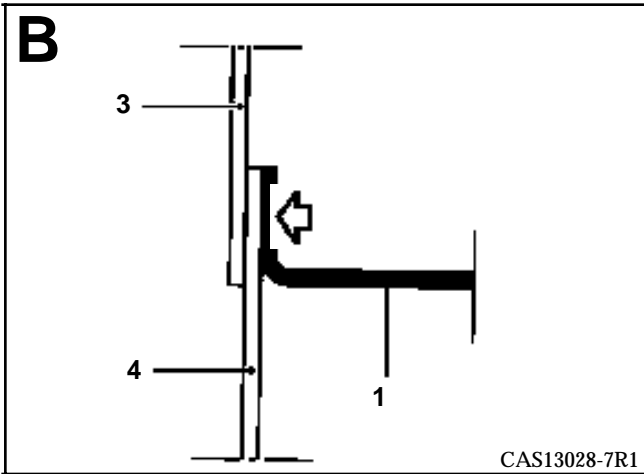
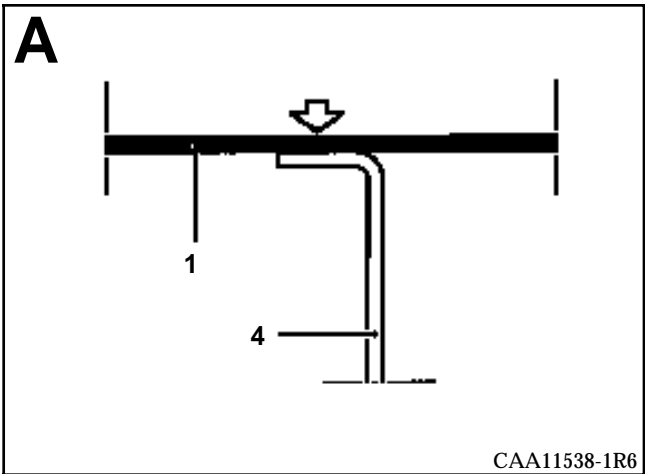
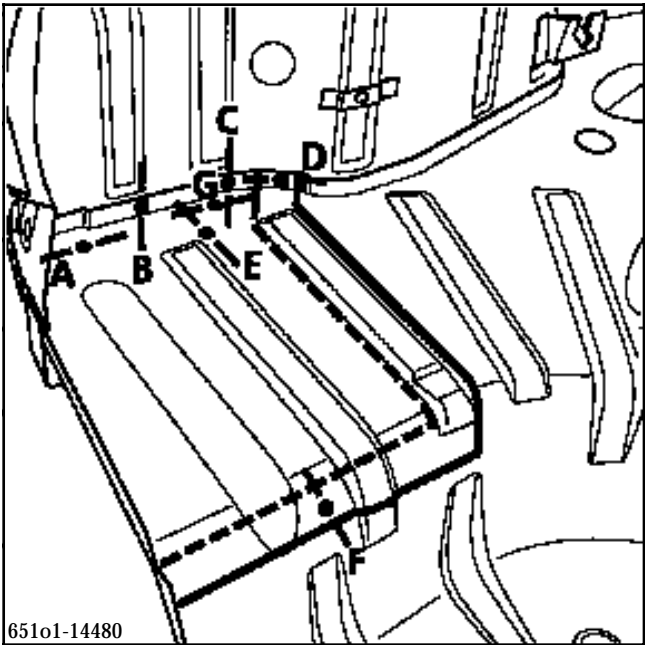
COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

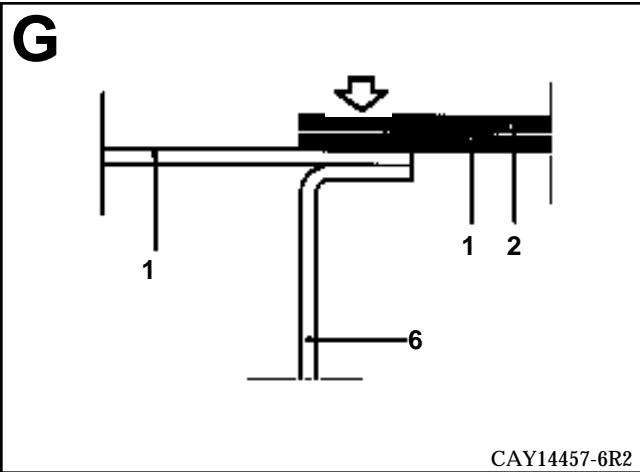
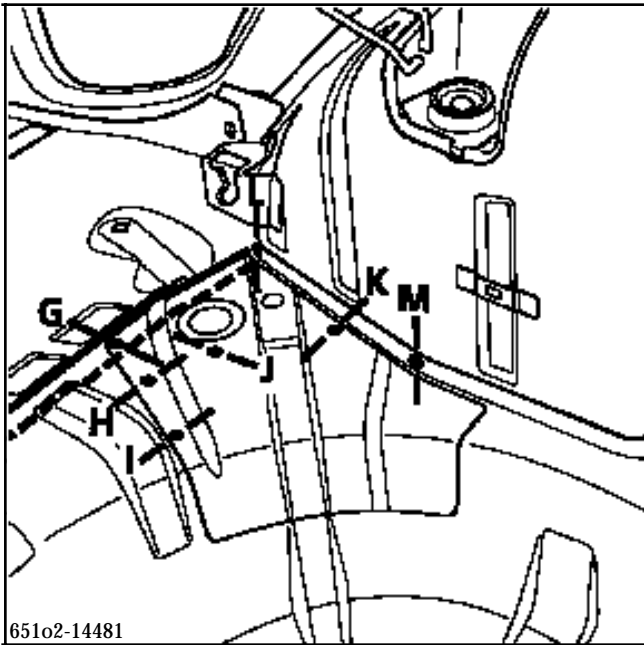
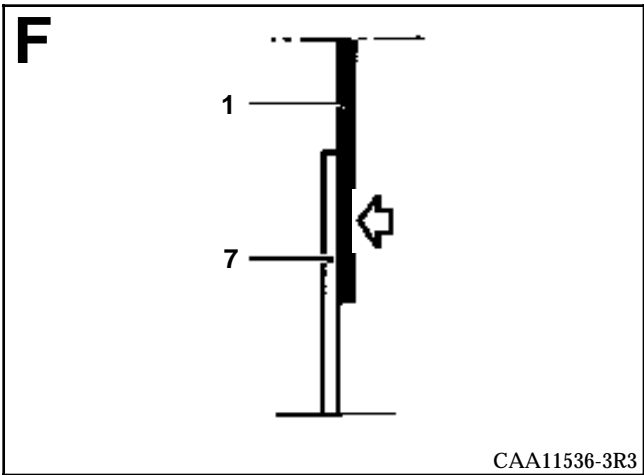
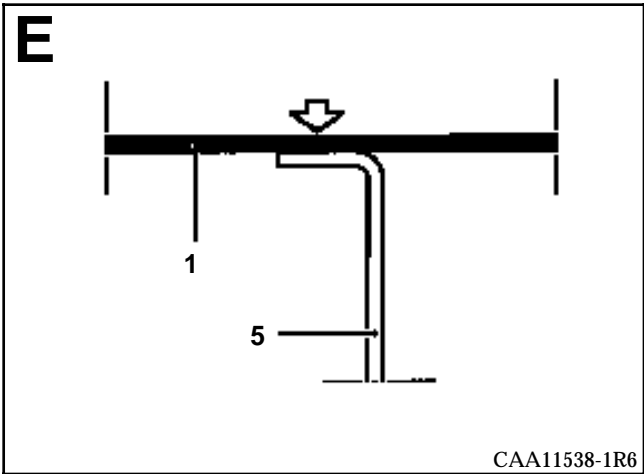
- Part assembled with :
- emergency spare wheel mounting,
  - rear floor reinforcement,
  - bolts to be welded,
  - stud to be welded,
  - rear cushion retaining bracket.

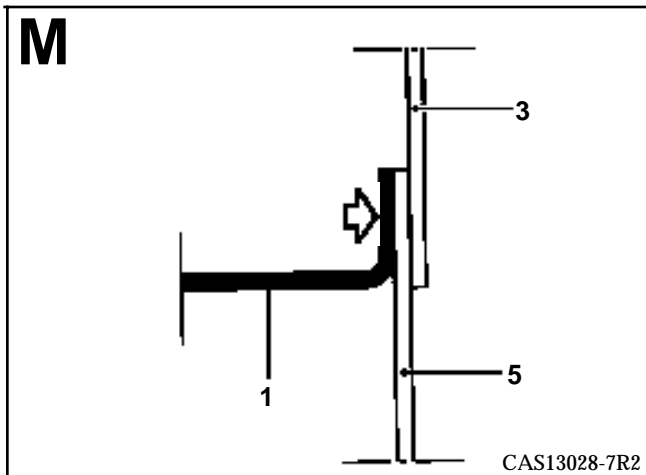
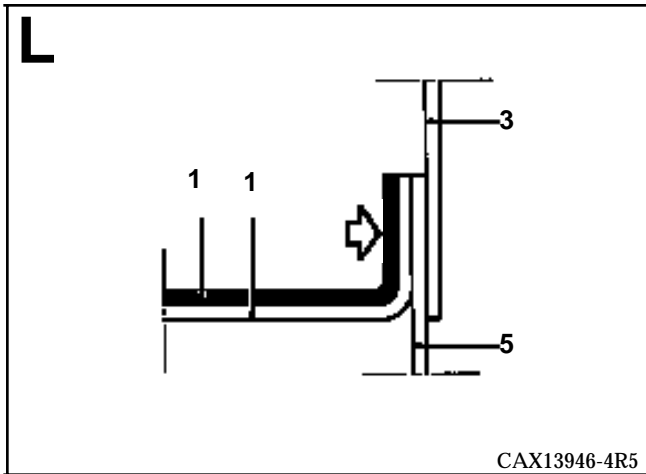
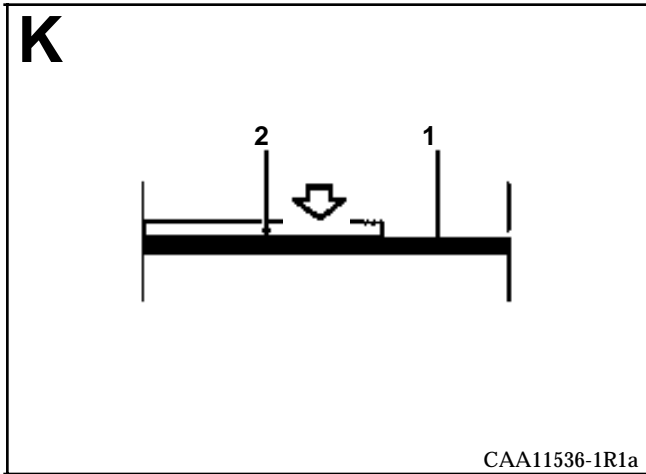
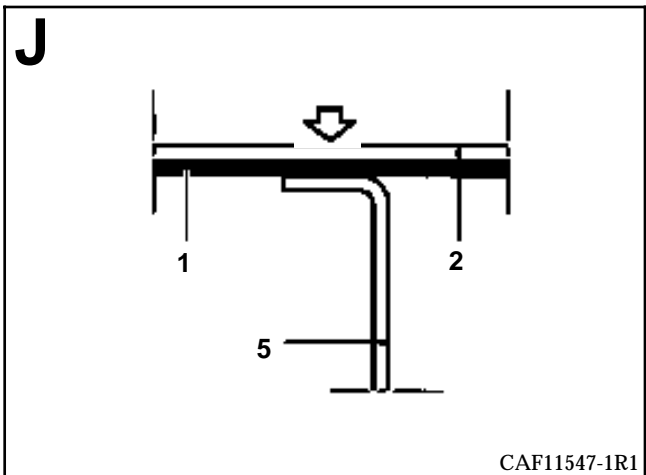
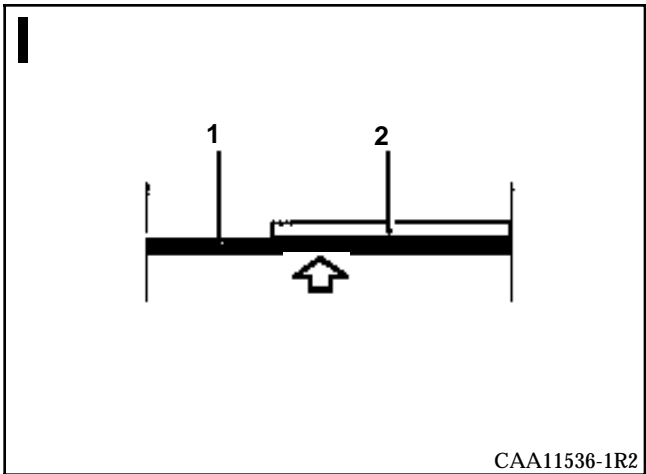
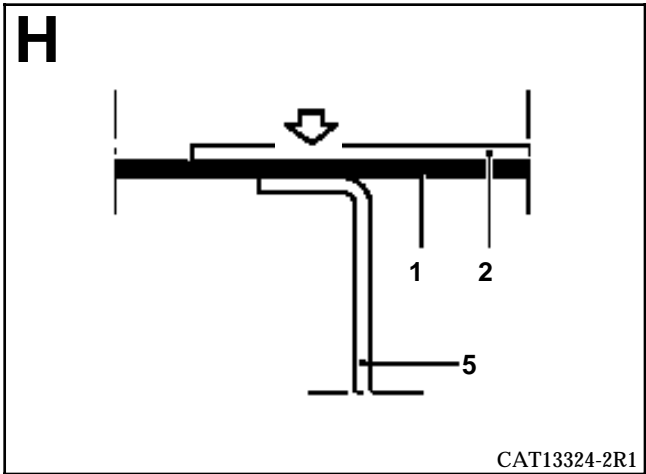
PARTS CONCERNED (thickness in mm):

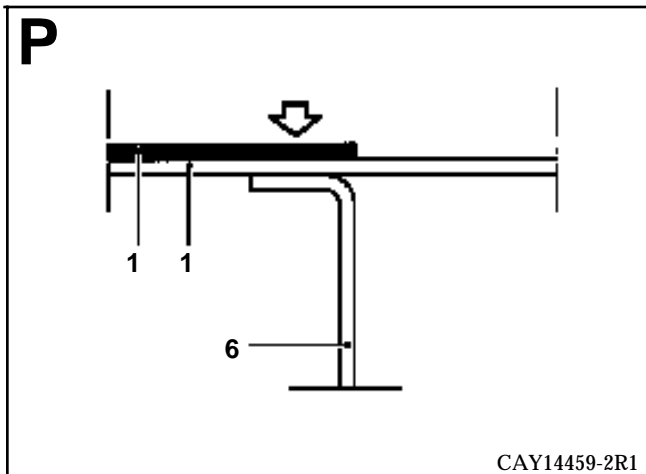
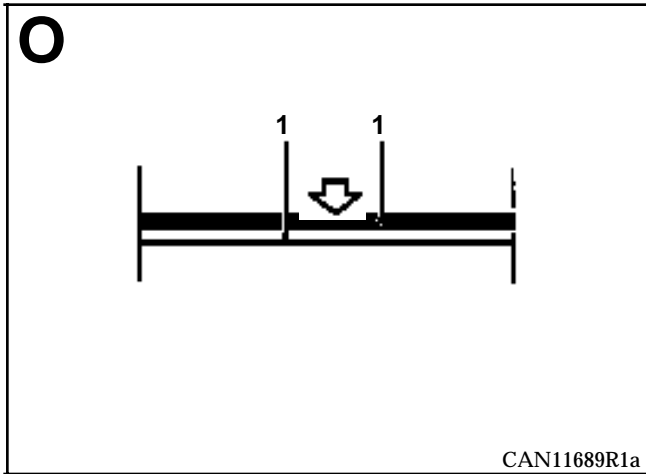
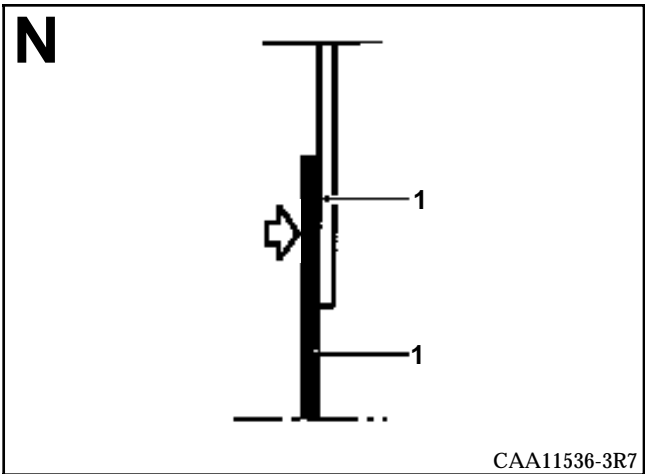
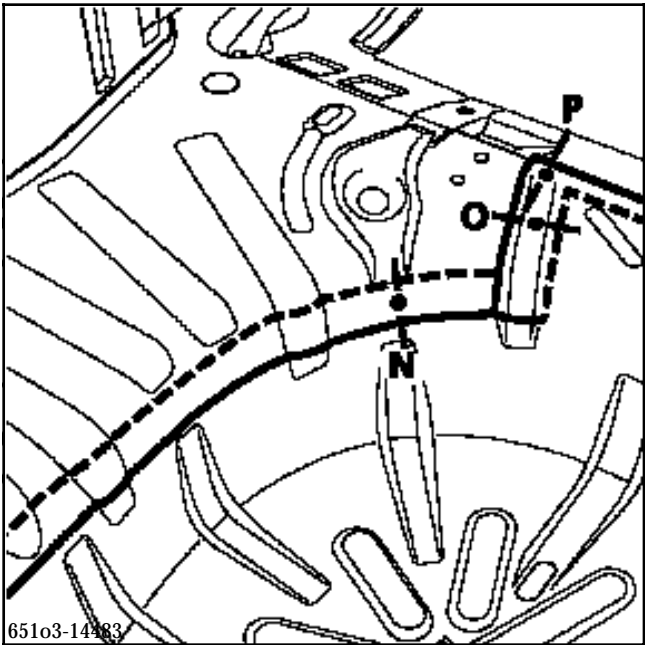
1	Rear floor	0.7
2	Rear floor reinforcement	1.8
3	Rear inner wheel arch	0.8
4	Exhaust mounting	1.2
5	Rear side member	1.2
6	Rear floor centre cross member	1.2
7	Side member / cross member joining component	1.5
8	Front cross member of rear floor cross member	1.5
9	Sill panel closure panel	1
10	Rear axle assembly mounting unit	1



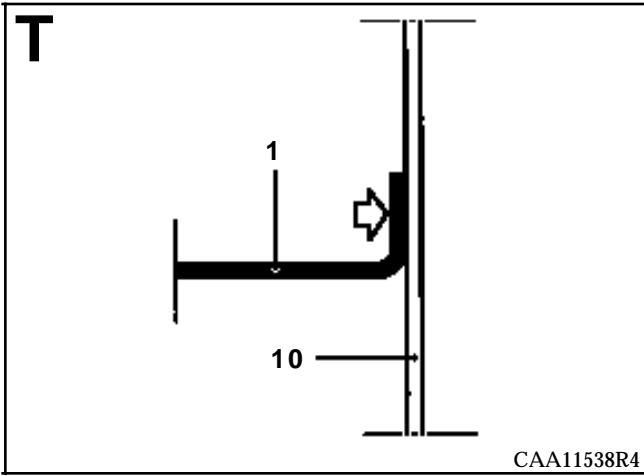
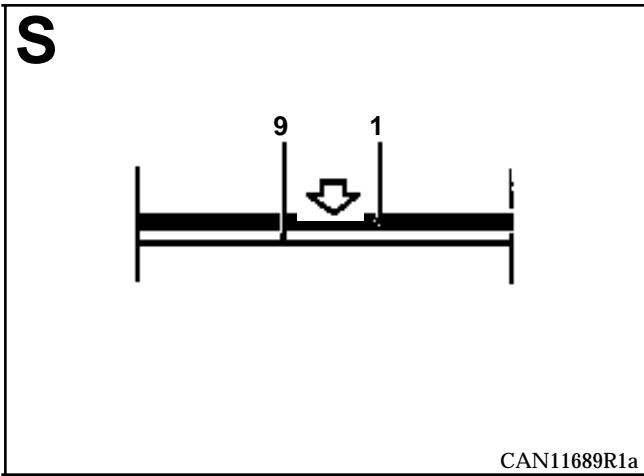
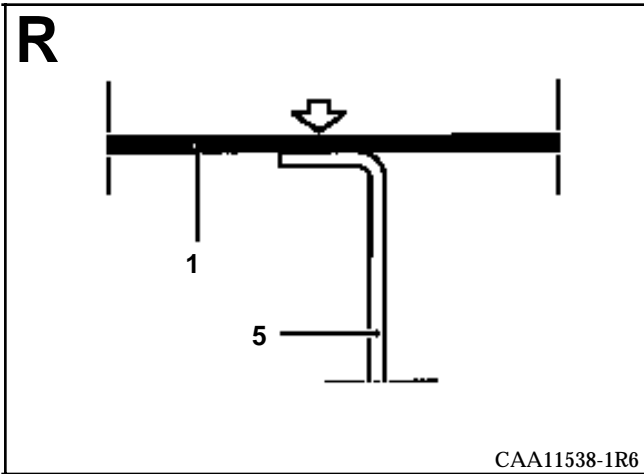
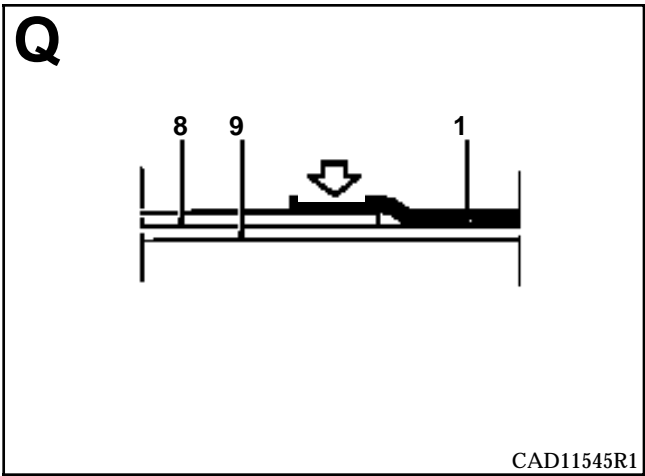
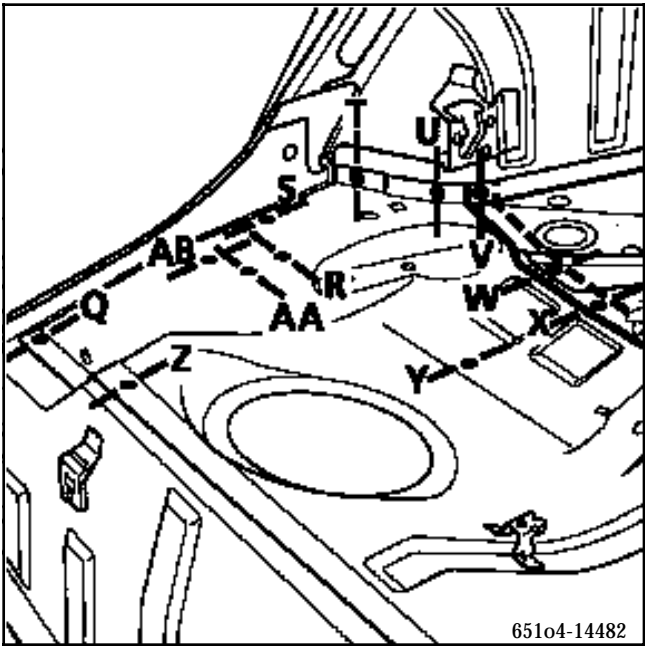


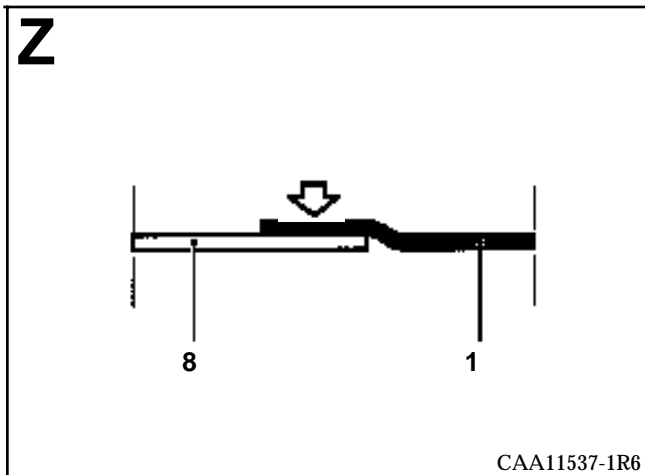
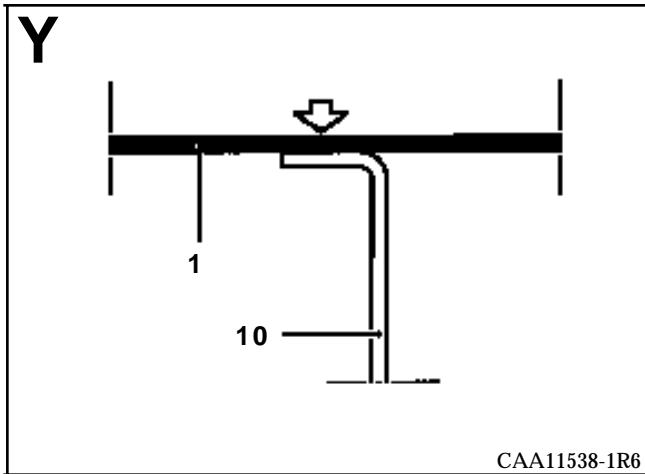
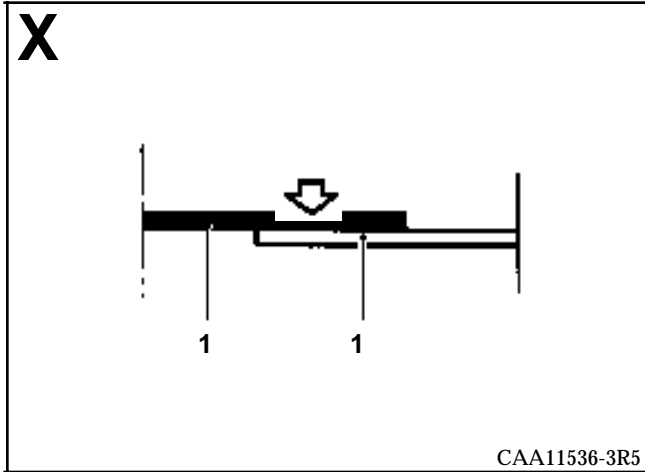
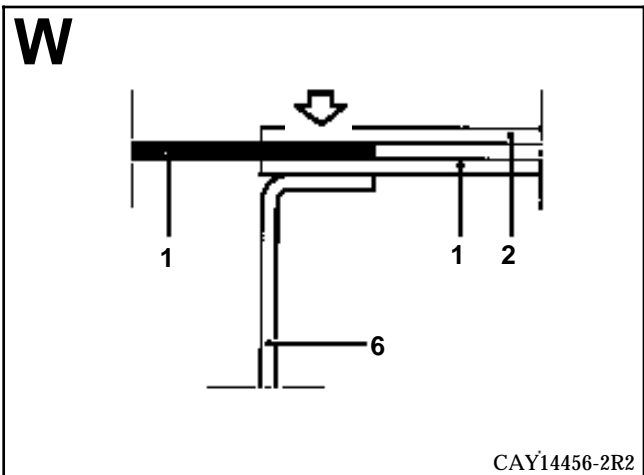
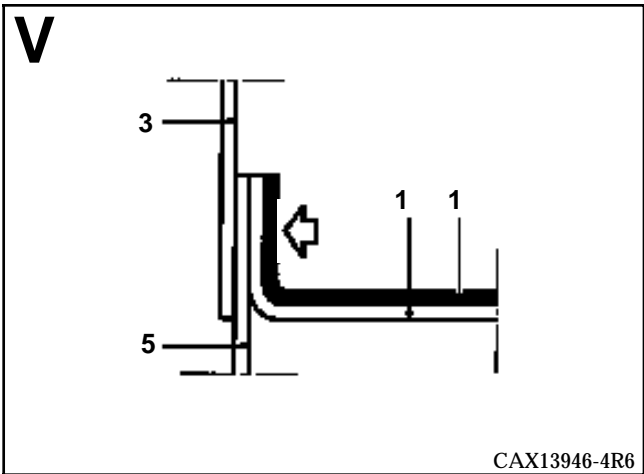
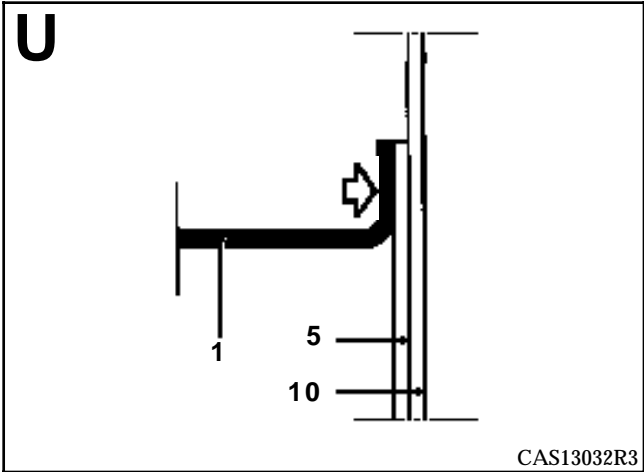


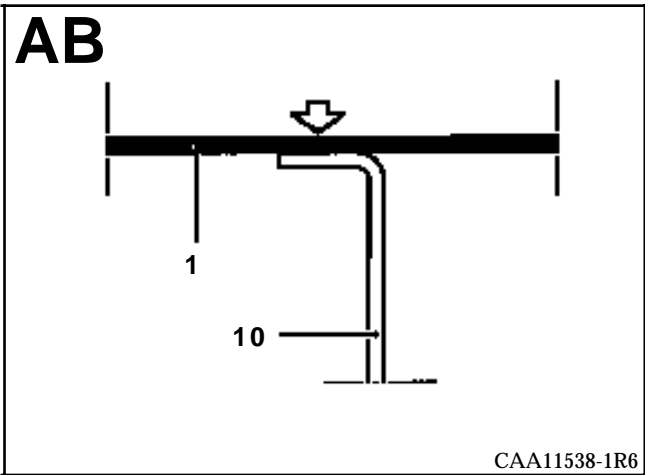
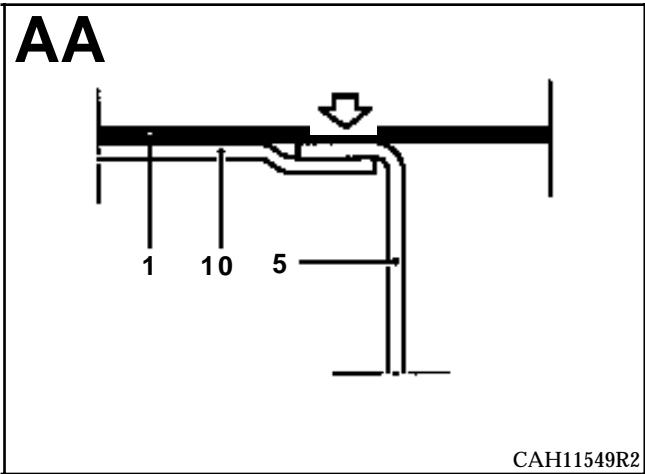












**INTRODUCTION**

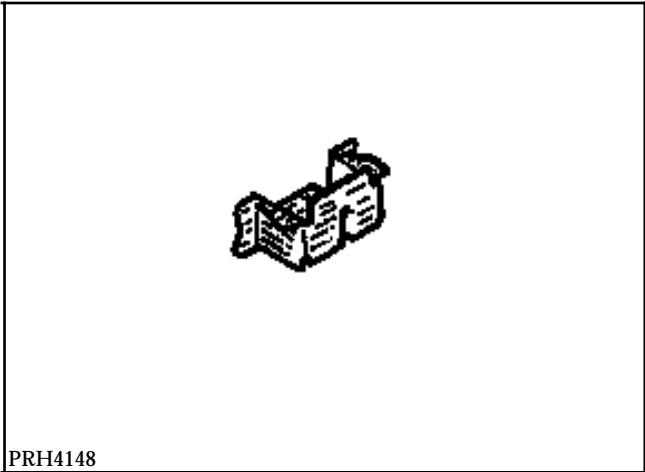
The replacement of this part is a complementary operation to the replacement of the rear end panel.

In the operation described below, there are only descriptions of the joints specific to the part concerned.

Information concerning additional parts will be dealt with in the respective section (see contents).

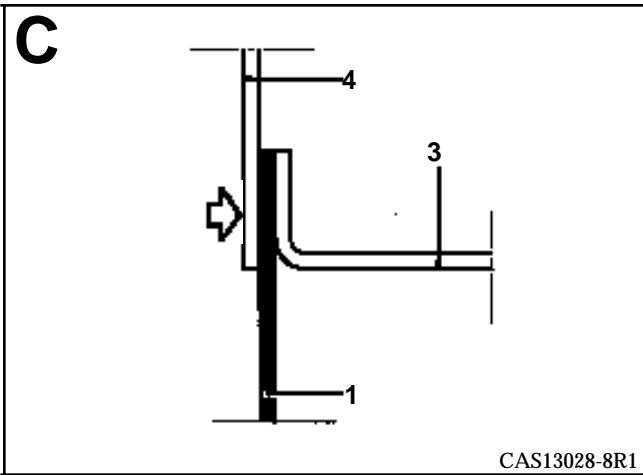
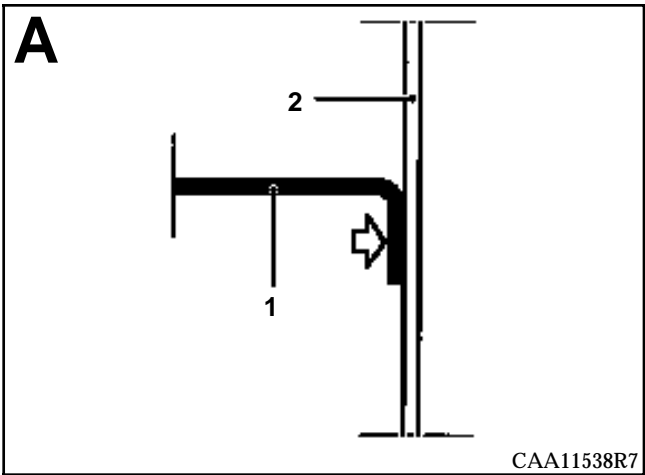
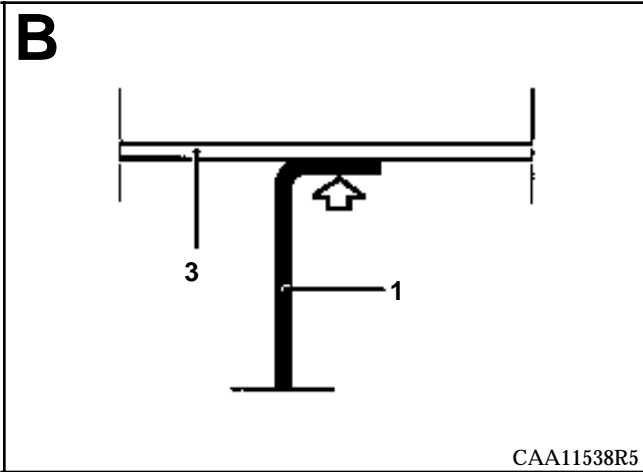
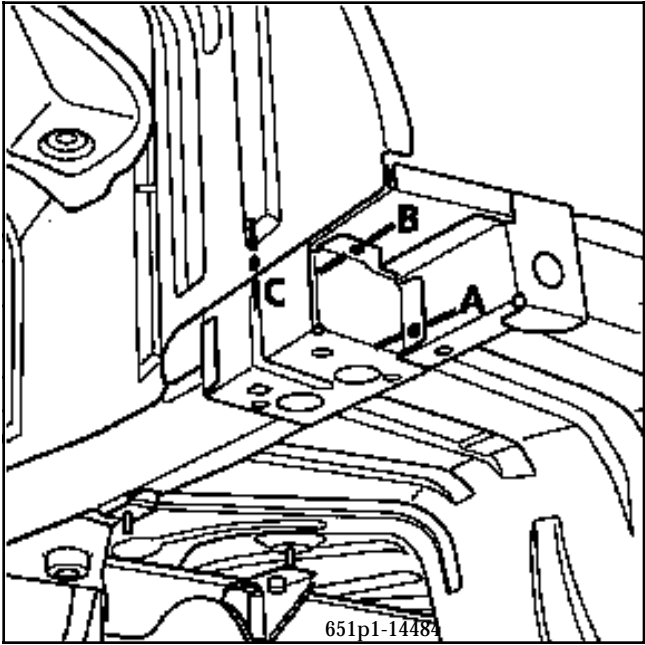
**COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT**

Part assembled with welded nuts.



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

<b>1</b>	Exhaust mounting	1.2
<b>2</b>	Rear side member	1.8
<b>3</b>	Rear floor	0.7
<b>4</b>	Wheel arch	0.8



INTRODUCTION

The replacement of this part is a complementary operation to the replacement of the rear end panel for a rear impact.

In the operation described below, there are only descriptions of the joints specific to the part concerned.

Information concerning additional parts will be dealt with in the respective section (see contents).

The repair bench must be used.

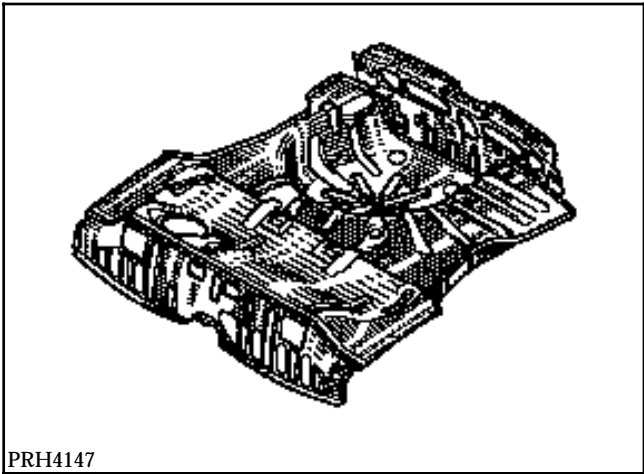
COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

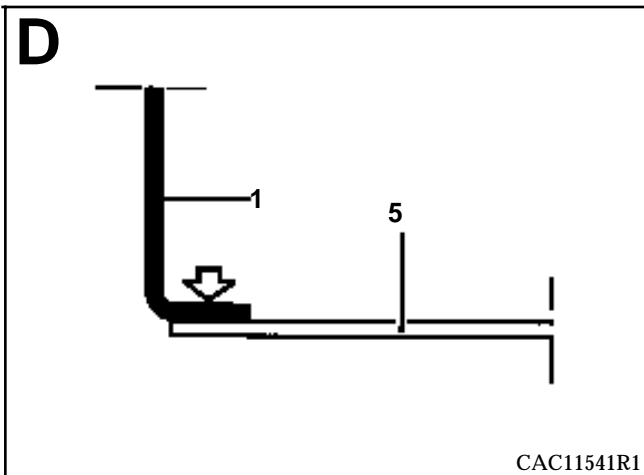
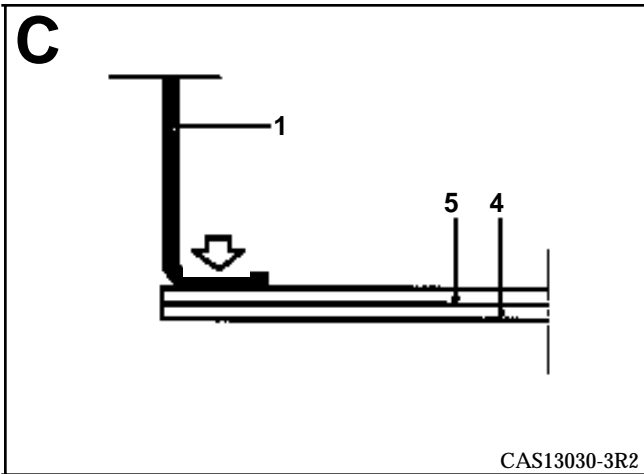
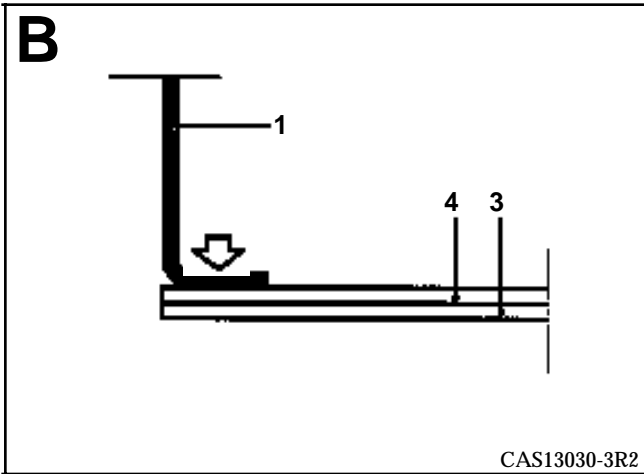
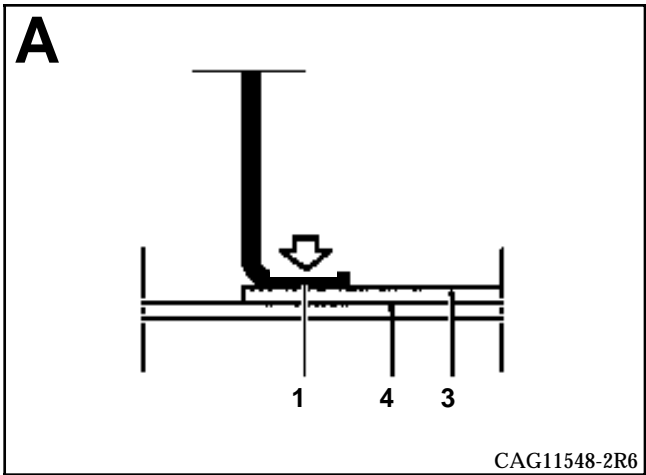
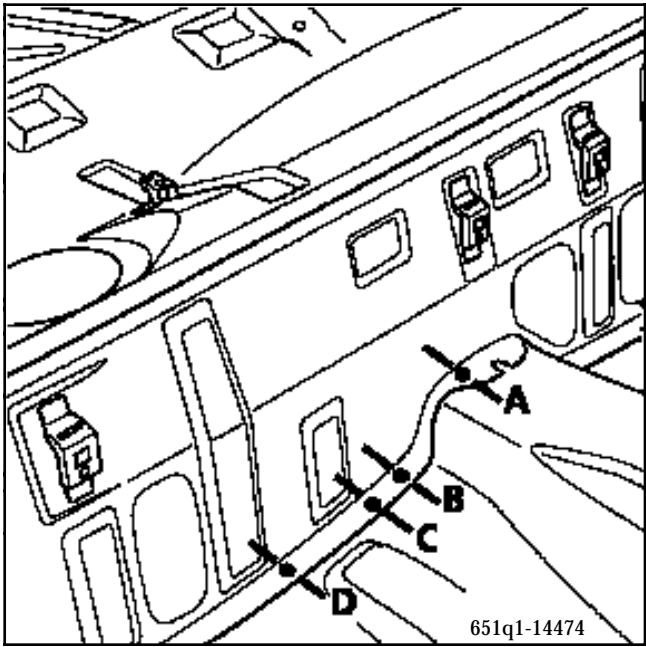
Part assembled with :

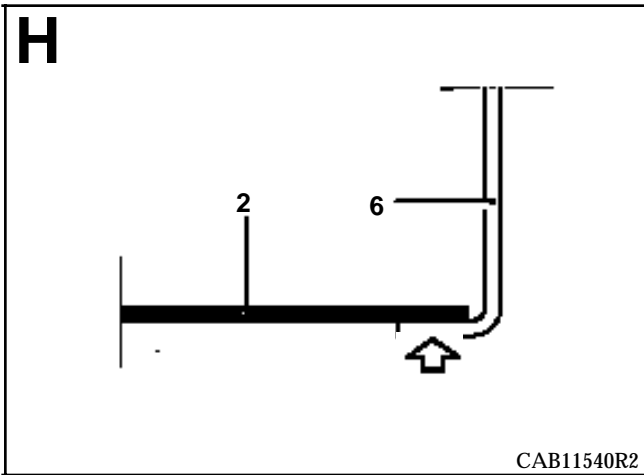
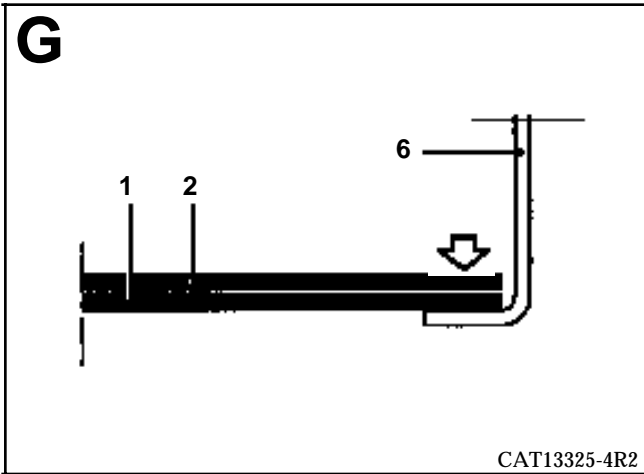
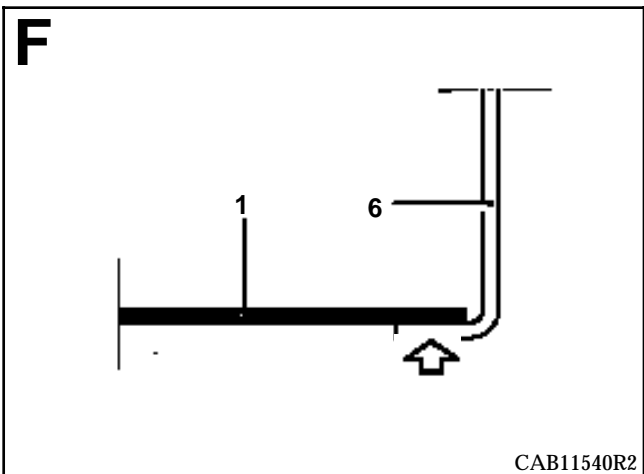
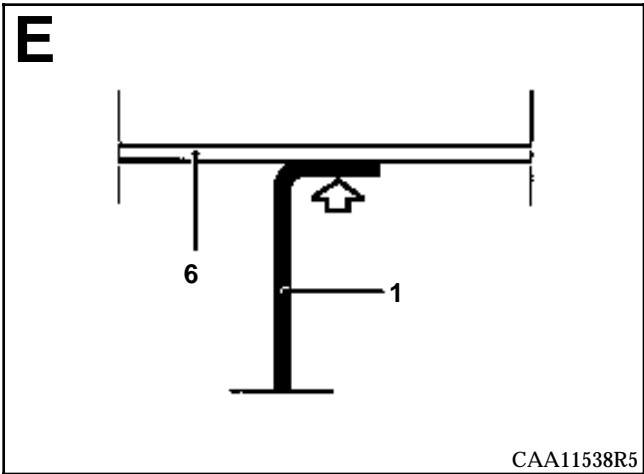
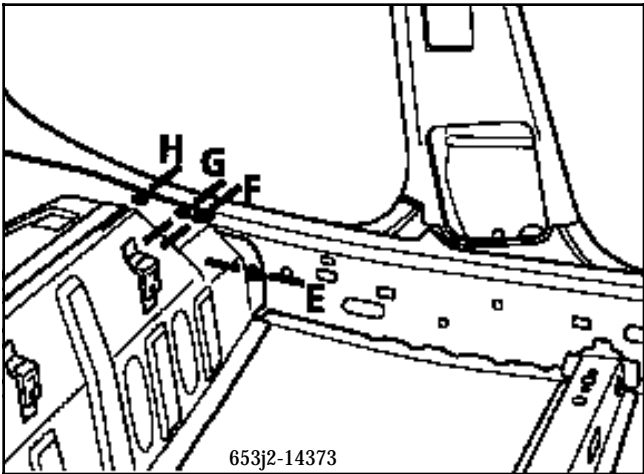
- fuel tank mounting,
- welded nuts,
- exhaust mounting (left hand side ),
- rear axle assembly mounting unit,
- rear axle assembly mounting spacer,
- rear side member reinforcement,
- towing ring mounting,
- rear suspension spring cup,
- rear suspension spring cup reinforcement,
- side member / cross member joining component ,
- rear side members,
- rear floor ,
- rear floor raised section ,
- towing ring .

PARTS CONCERNED (thickness in mm):

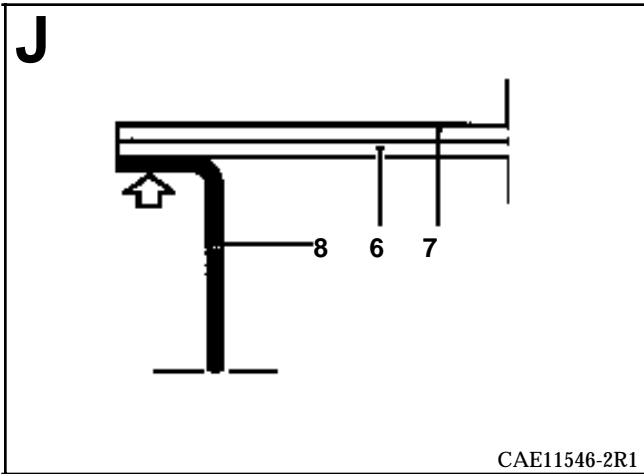
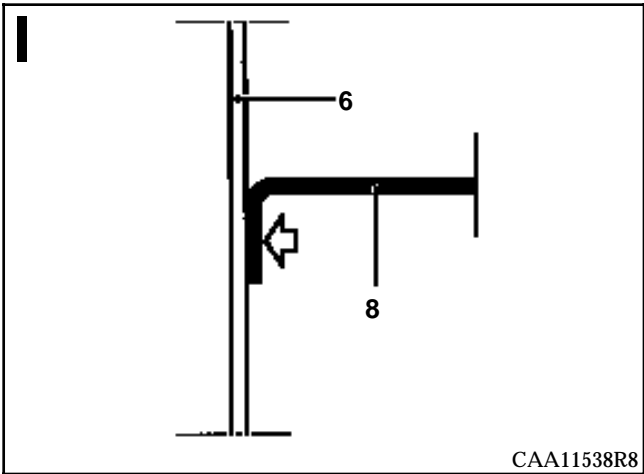
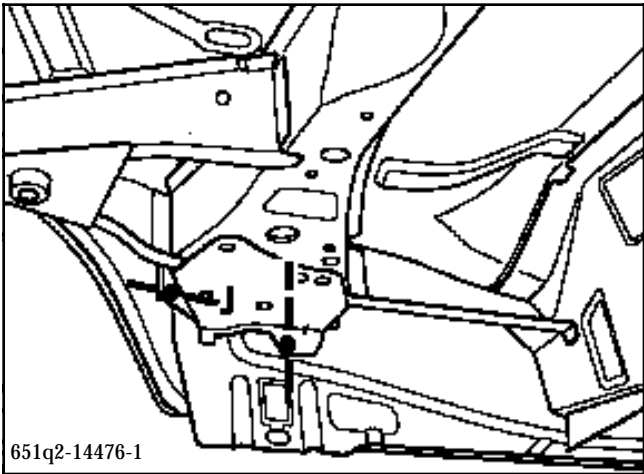
1	Rear floor raised section	1.5
2	Rear floor	0.7
3	Tunnel reinforcement	1
4	Cable sleeve stop mounting	1.2
5	Centre floor	1.47
6	Sill panel closure panel	1
7	Sill panel reinforcement	1
8	Rear axle assembly mounting unit	1
9	Rear side member	1.8
10	Wheel arch	0.8

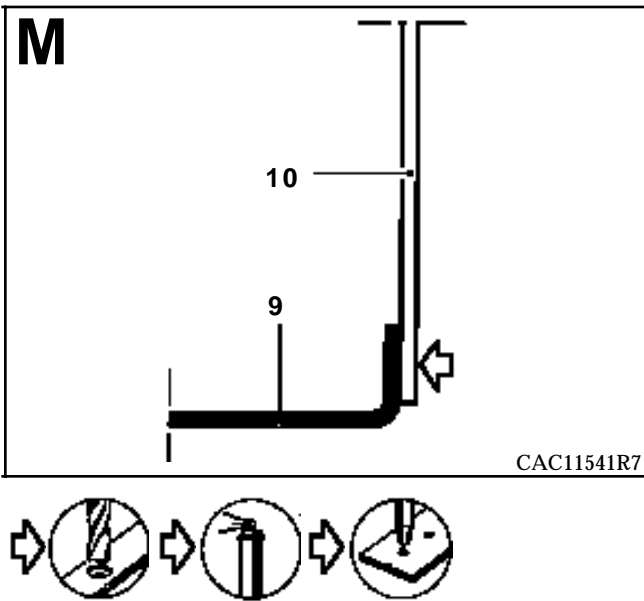
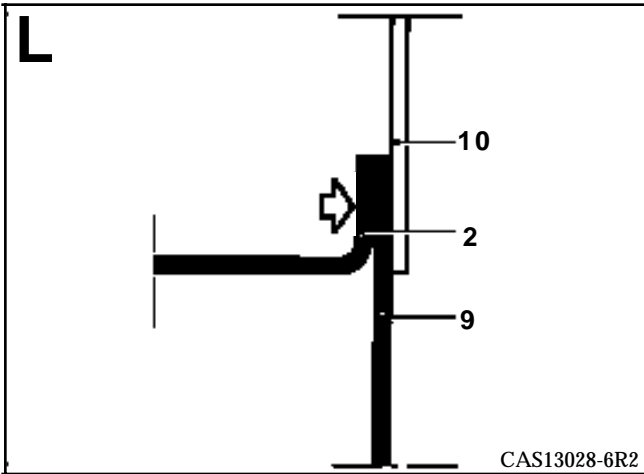
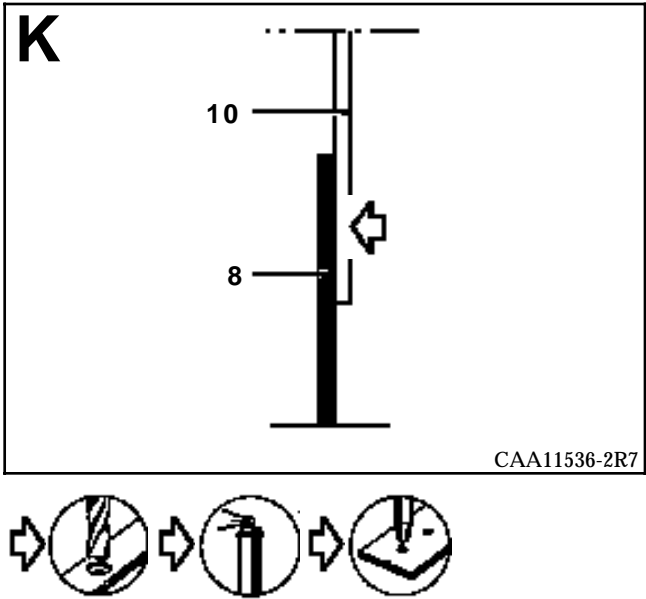
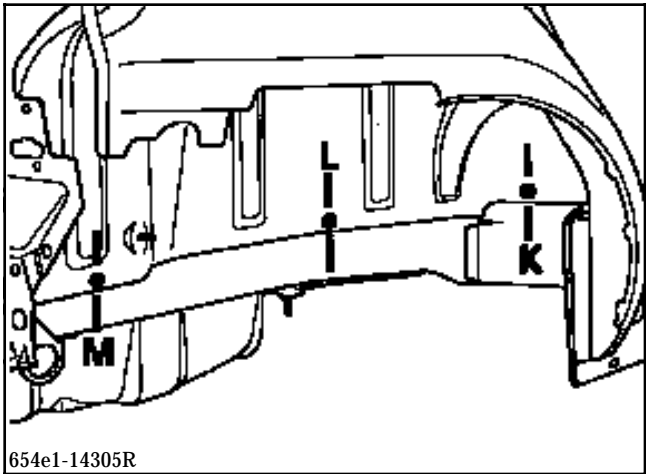






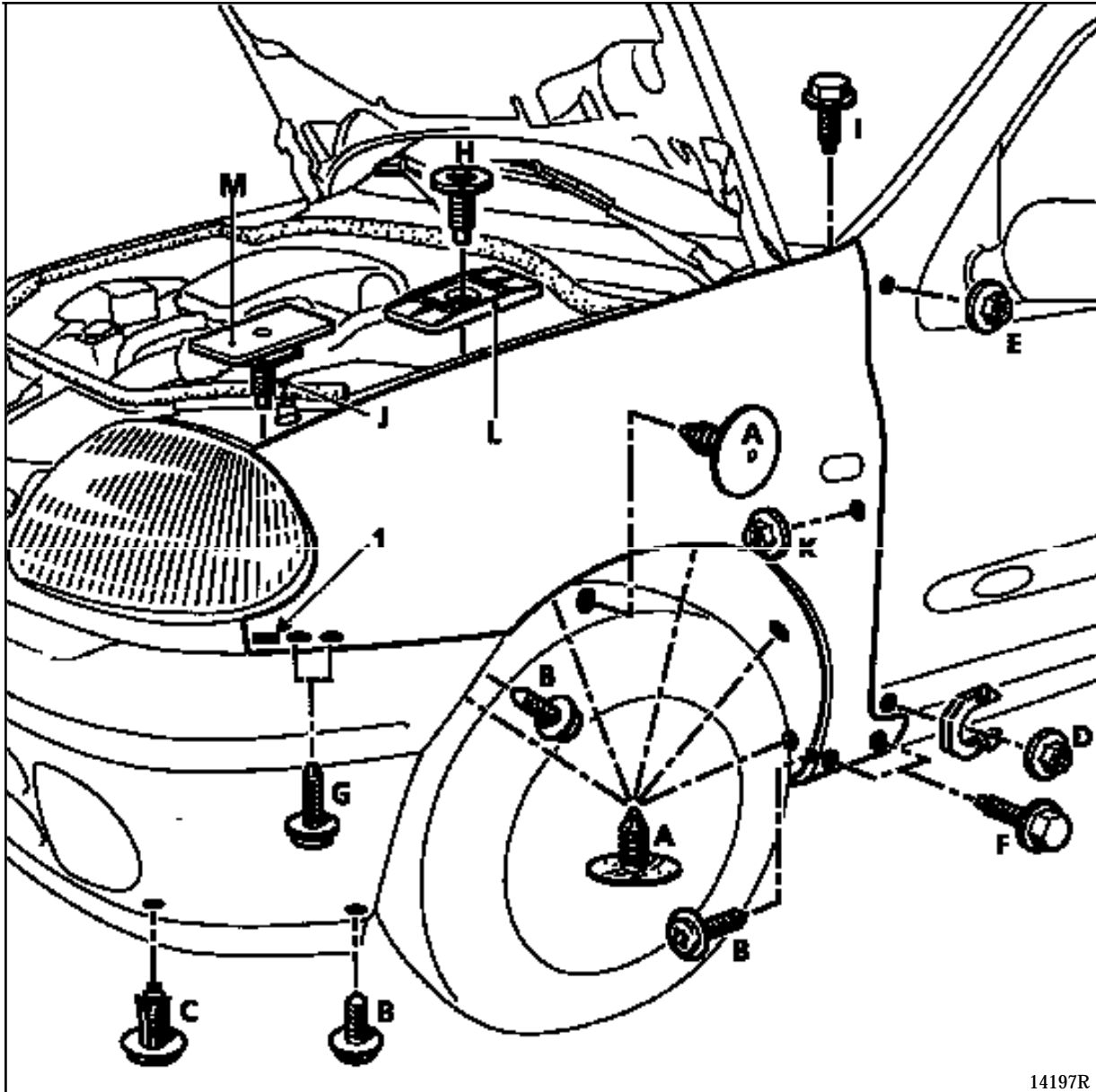






### INTRODUCTION

The replacement of this part is a basic operation for a frontal and side impact.



14197R

### REMOVAL

Remove:

- the radiator grille and unclip it from the wing (1) (see section 55-C),
- the scuttle panel grille (see section 55-D),
- the front bumper (see section 55-A),
- the clips (A), the bolts (B), and the clips (C),
- the front and rear mudguards.

### REMOVING THE WING

Open the door and remove the mounting nuts (D) and (E).  
Remove the bolts (F), (G), (H), (I) and the nuts (J), (K).

ADJUSTING PROCEDURE


First fit the sliding clips (L) and (M) onto the wing .

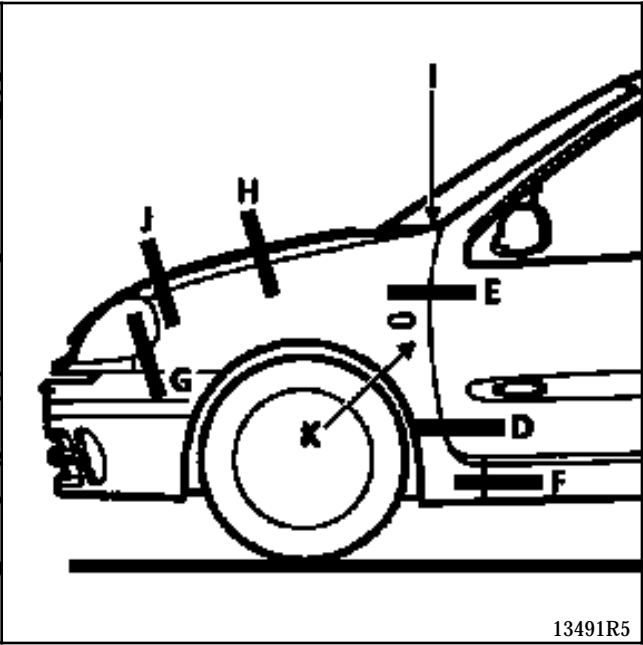
Fit all the mountings without tightening them, before adjusting the opening clearances.

Observe the tightening order as follows :

- Bolt (I), nut (K), bolt (F), nut (J) with bonnet and doors closed.
- Nut (E), nut (D) with door open.
- bolt (L) with bonnet open.

Adjust the flush fitting of the headlight unit on the wing with bolts (G), then tighten these two bolts.

TIGHTENING TORQUE (in daN.m)	
All wing mounting bolts	0.5



REPAIRING THE PLASTIC WING

Reminder

Certain types of repairs to the wing may be carried out - scratches, score marks etc., ...

For more information, consult Technical Note n° 392A on the repair of bumpers.

In this note you will find information concerning methods and products.

### INTRODUCTION

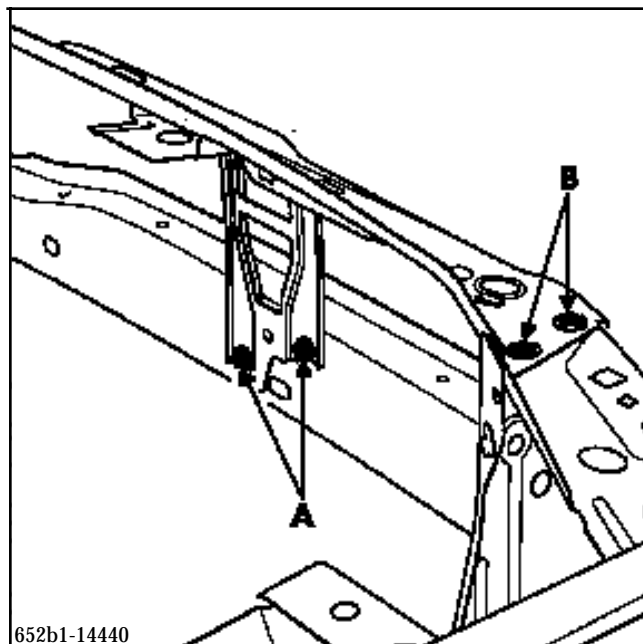
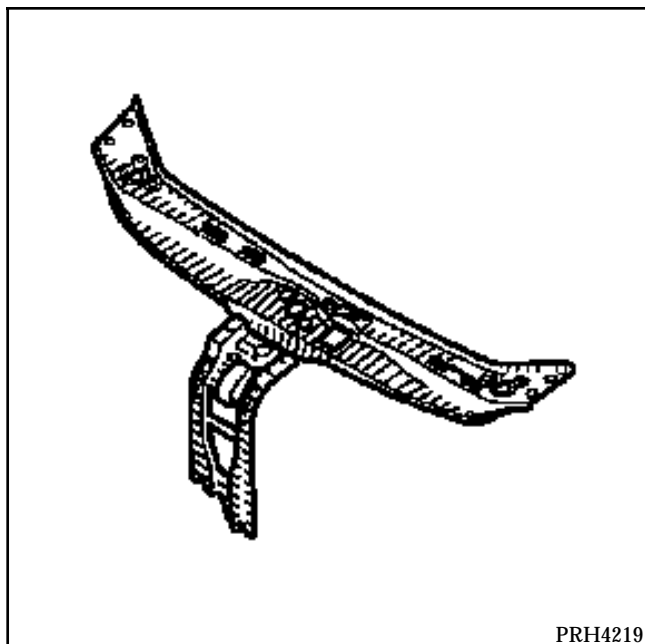
The replacement of this part is a basic operation for a frontal impact.

This is a removable bodywork component, secured by 6 x 8 mm bolts :

- four Torx 40 bolts on the headlight carrier panel at (A),
- two hexagonal bolts on the front end lower cross member (B).

### COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

Part assembled with lock mounting.



### INTRODUCTION

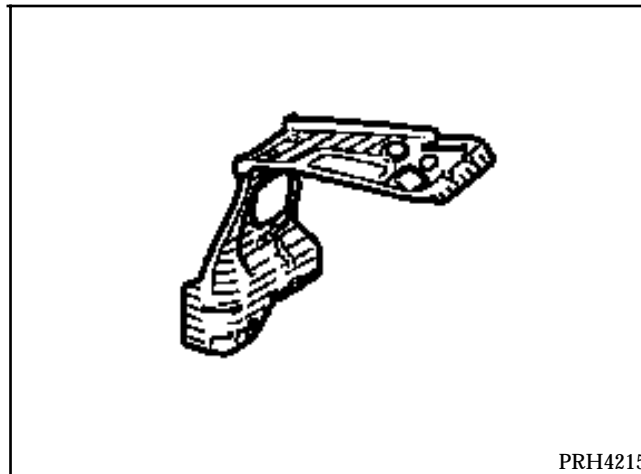
The replacement of this part is a basic operation for a frontal impact.

The fitting jig must be used.

### COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

Part assembled with:

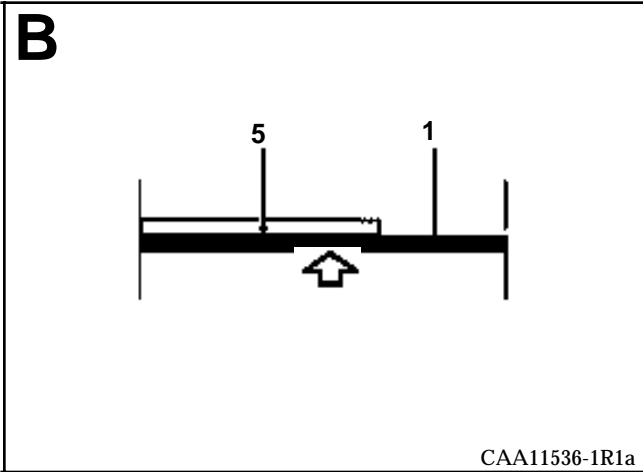
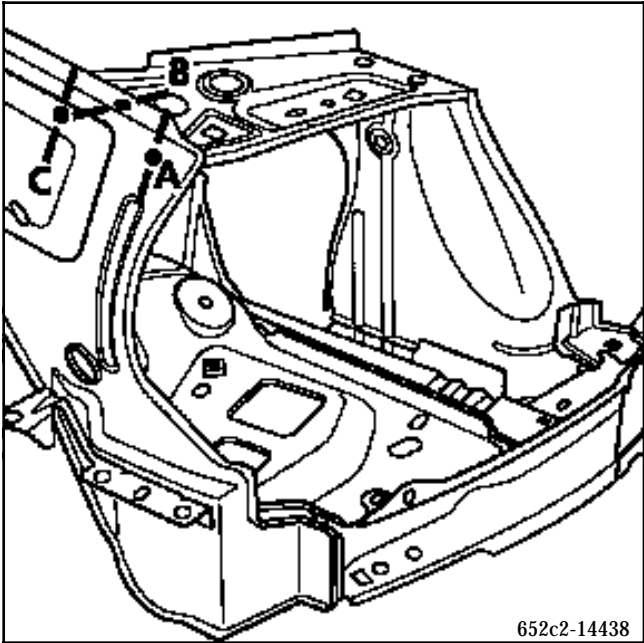
- front panel upper side cross member,
- headlight carrier panel ,
- bumper mounting support,
- welded nuts.



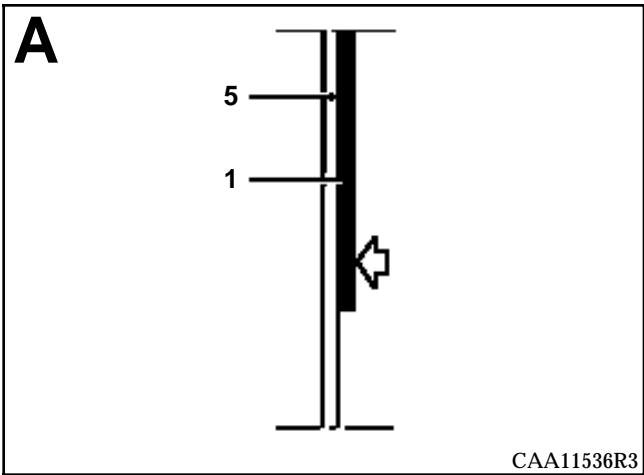
PRH4215

### PARTS CONCERNED (thickness in mm) :

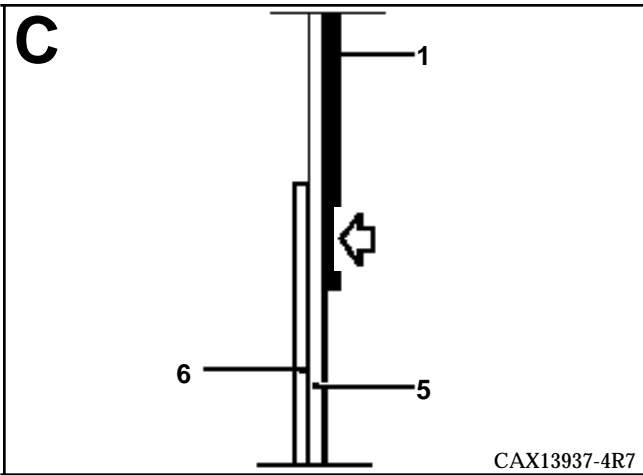
1	Front panel upper side cross member	1.2
2	Headlight carrier panel	1.2
3	Front end cross member	1.8
4	Front side member	1.5
5	Cowl side panel upper front reinforcement	1
6	Front sub-frame front mounting, lower section	1.2



CAA11536-1R1a

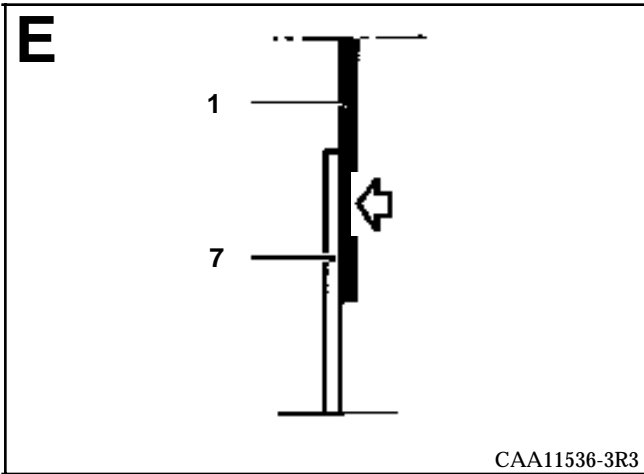
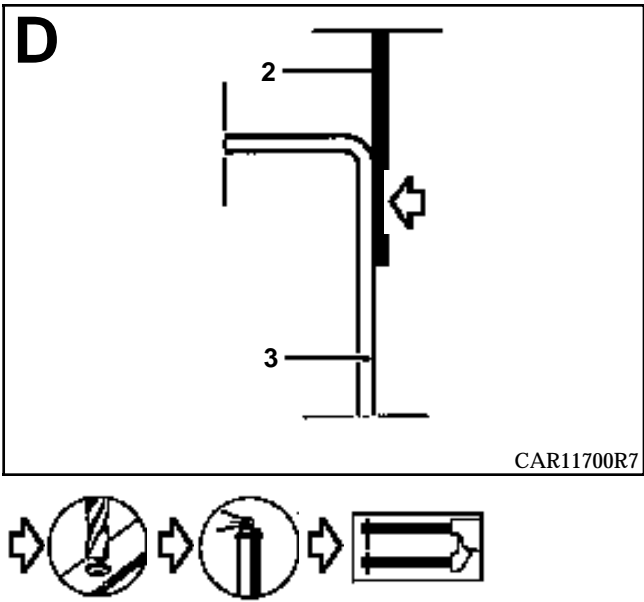
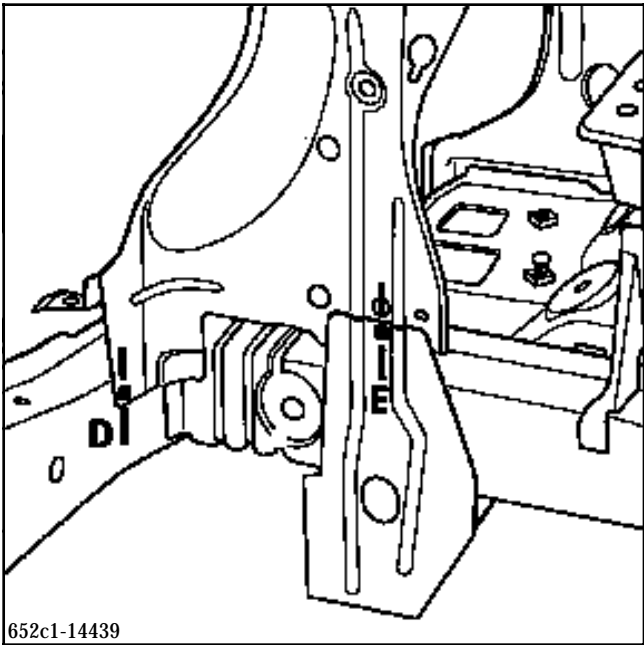


CAA11536R3



CAX13937-4R7







INTRODUCTION

The replacement of this part is a complementary operation to the :

- 1 - **replacement of the bonnet for a frontal impact**, in this case, this operation is carried out partially (see cut and method below),
- 2 - **replacement of the front pillar**, in this case, this operation is carried out completely.

In the operation described below, there are only descriptions of the joints specific to the part concerned.

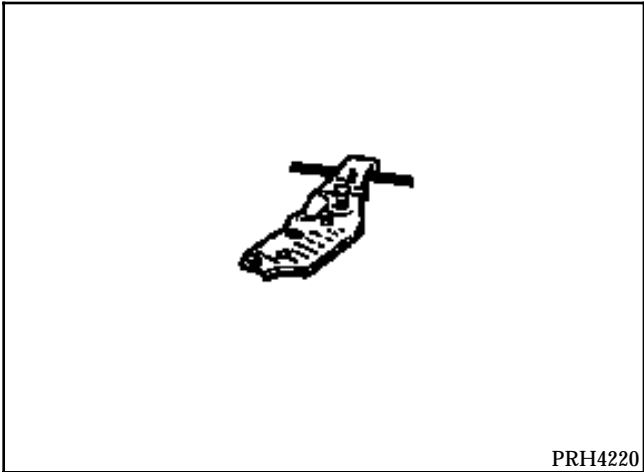
Information concerning additional parts will be dealt with in the respective section (see contents).

COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

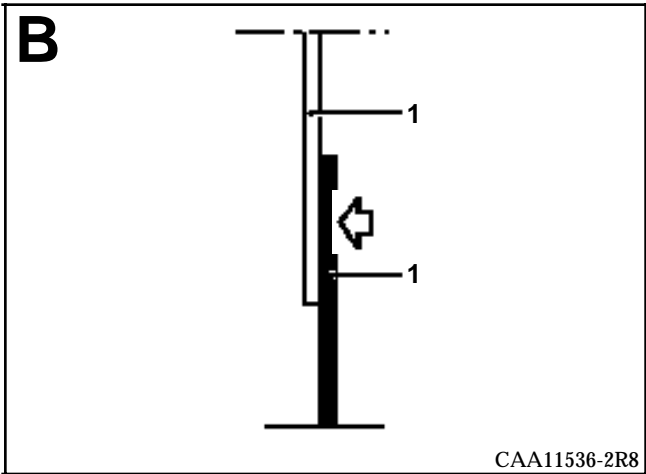
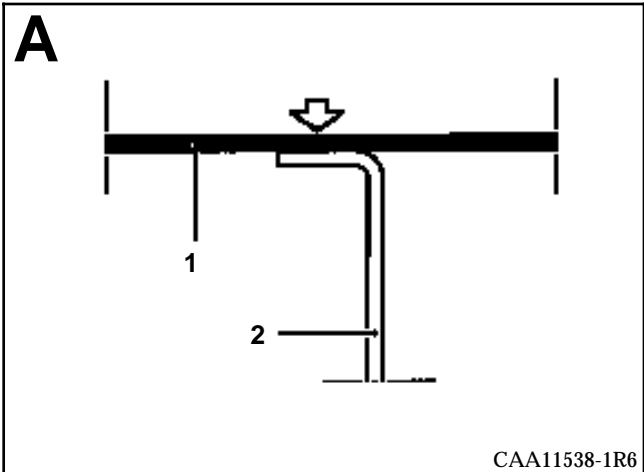
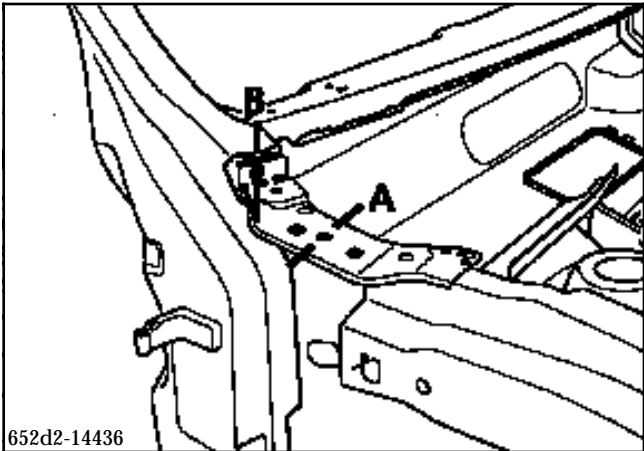
Part assembled with welded nut.

PARTS CONCERNED (thickness in mm) :

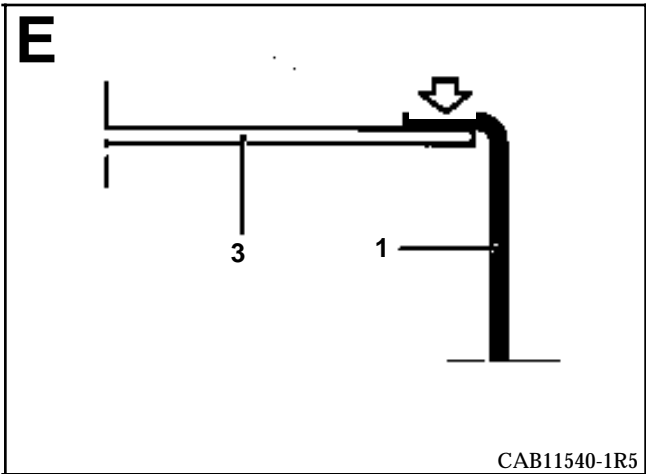
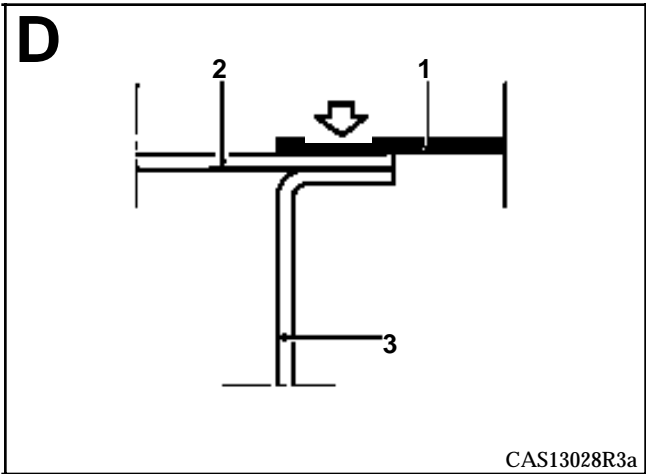
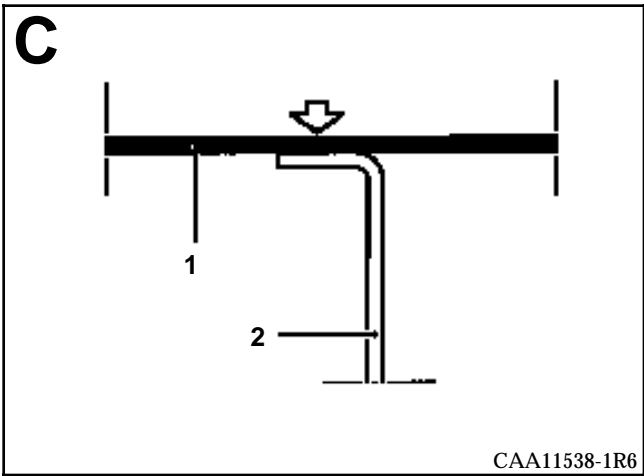
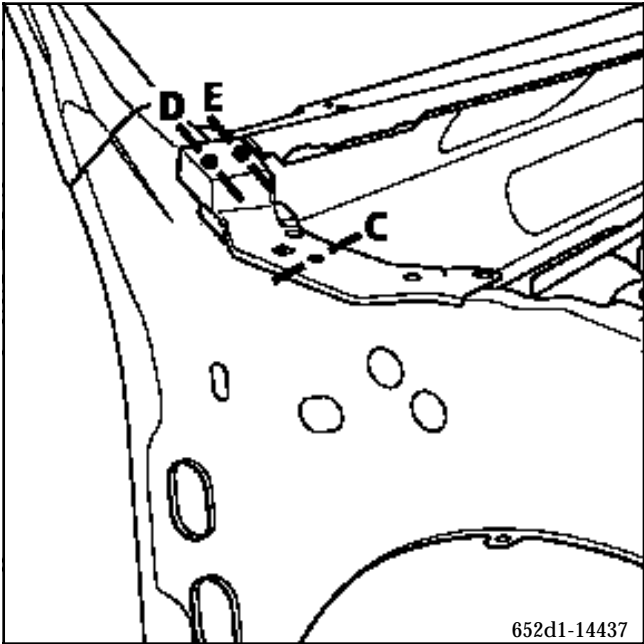
- |   |  |     |
|---|--|-----|
| 1 | Bonnet hinge mounting                  | 1.2 |
| 2 | Cowl side pillar lining                | 1.2 |
| 3 | Windscreen aperture lower cross member | 1.2 |



PARTIAL REPLACEMENT



COMPLETE REPLACEMENT



### INTRODUCTION

The replacement of this part is a complementary operation to the replacement of the headlight carrier panel for a frontal impact.

This operation is carried out partially (see cut and method below).

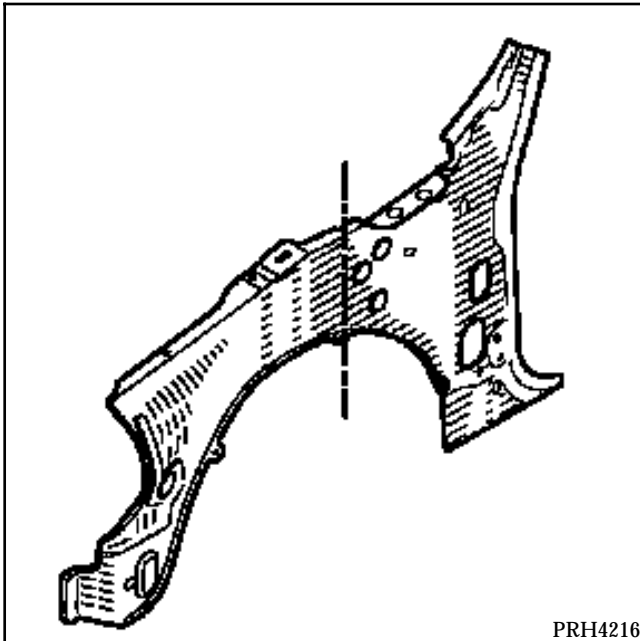
In the operation described below there are only descriptions of the joints specific to the part concerned.

Information concerning additional parts will be dealt with in the respective section (see contents).

### COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

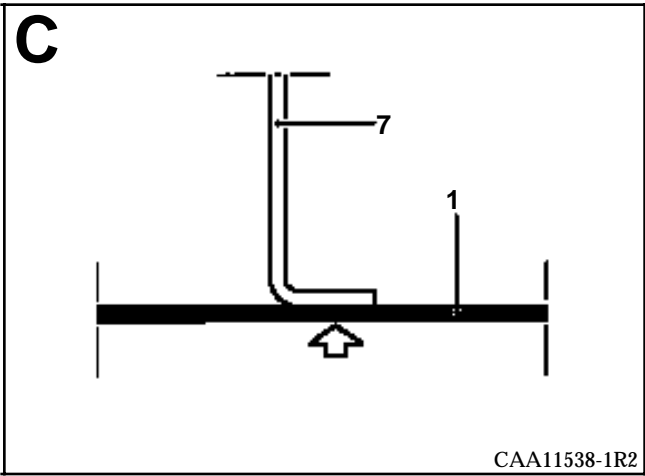
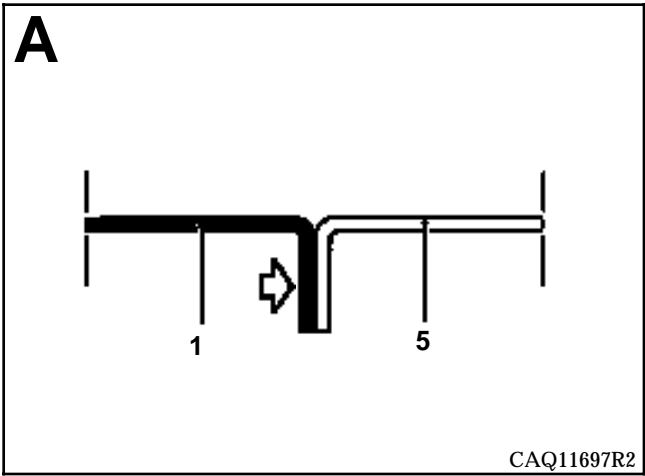
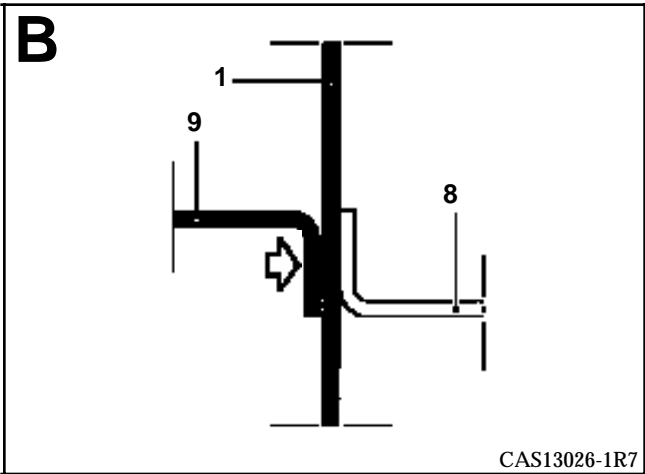
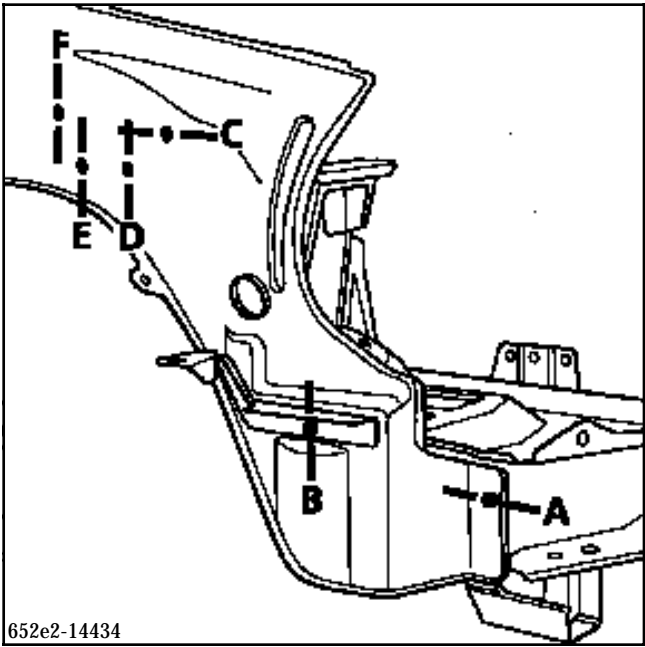
Part assembled with:

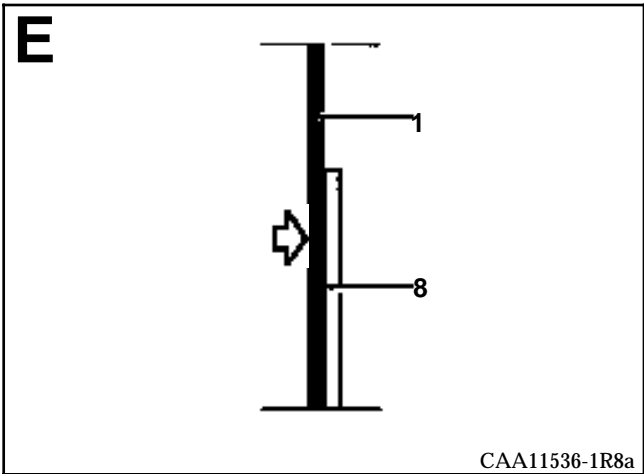
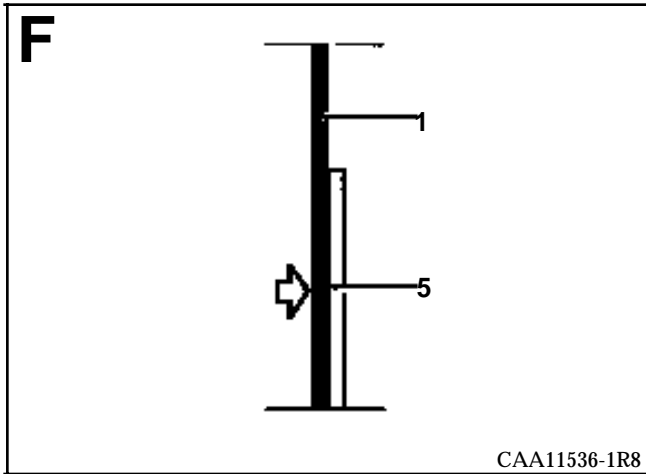
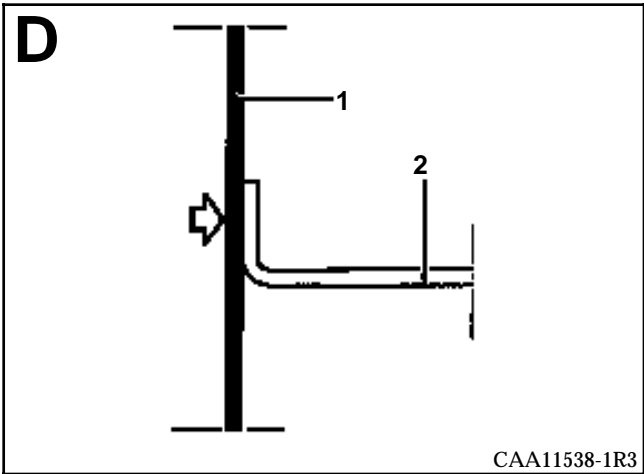
- nut to be crimped,
- bonnet hinge mounting,
- dashboard mounting bracket,
- welded nuts,
- wing mounting support.

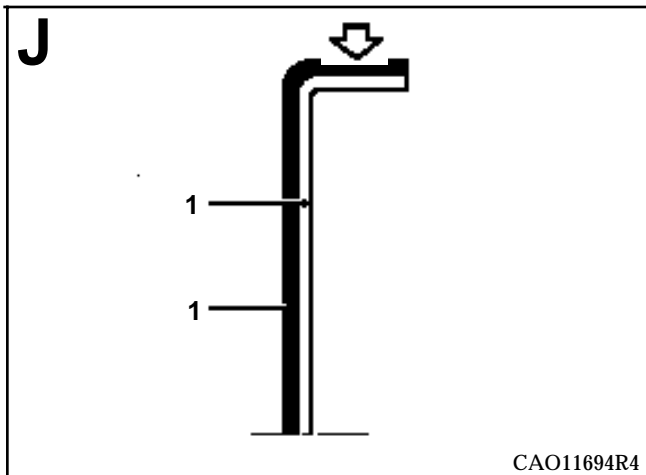
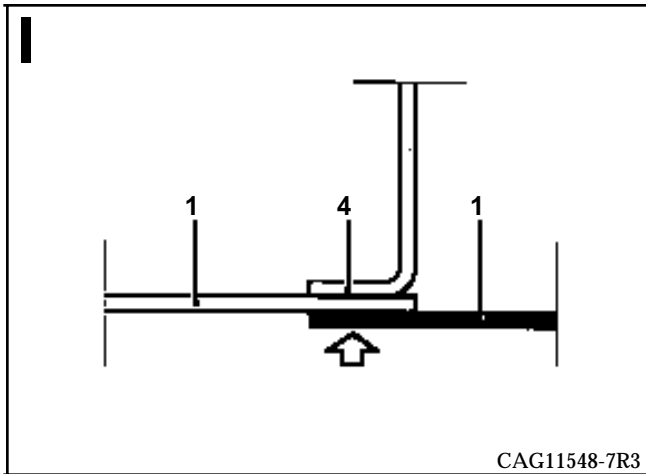
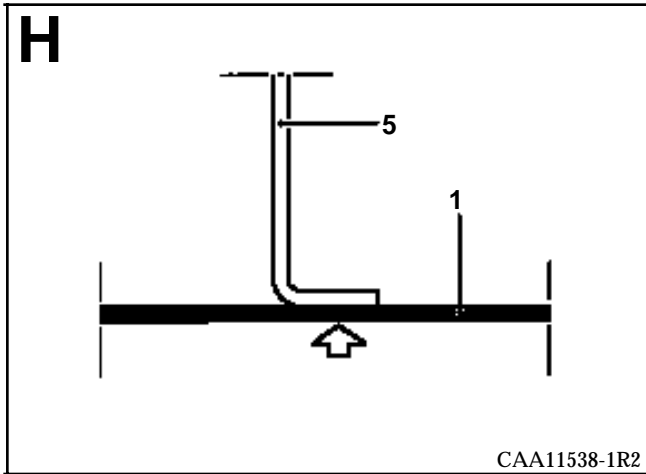
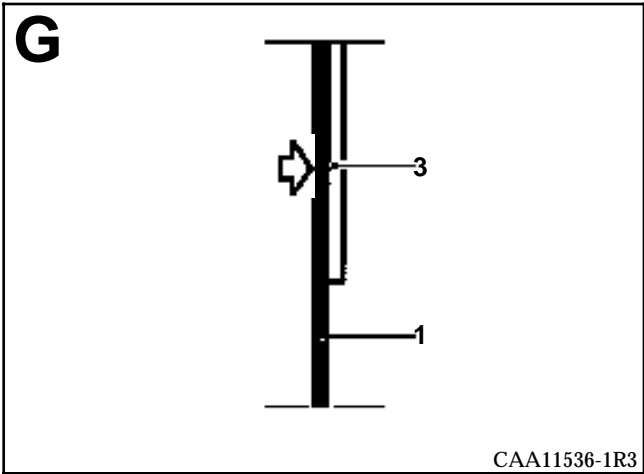
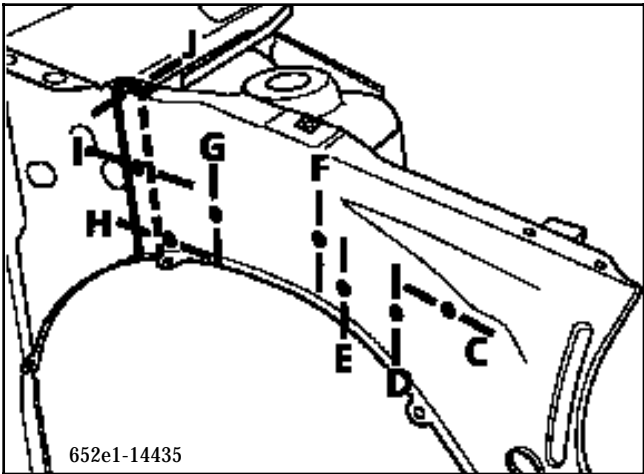


### PARTS CONCERNED (thickness in mm) :

1	Cowl side panel pillar lining	1.2
2	Engine support plate	2
3	Front shock absorber cup	2
4	Side plenum chamber	1
5	Shock absorber cup height adjuster	1.2
6	Front end cross member	1.8
7	Engine support plate corner plate	1.5
8	Wheel arch	0.8
9	Bumper mounting corner plate	0.8







### INTRODUCTION

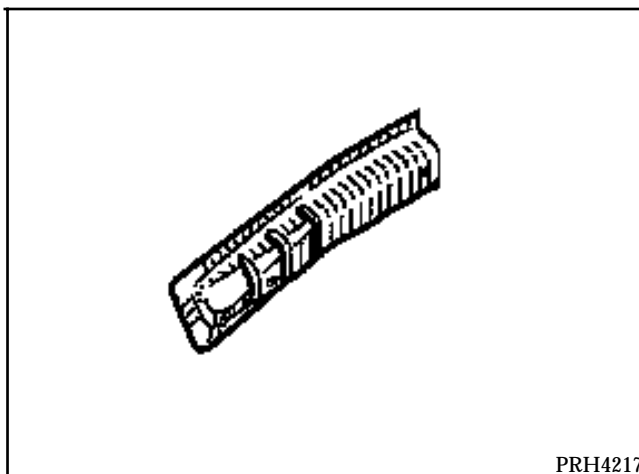
The replacement of this part is a complementary operation to the replacement of the cowl side panel for a frontal impact.

In the operation described below there are only descriptions of the joints specific to the part concerned.

Information concerning additional parts will be dealt with in the respective section (see contents).

### COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

Part on its own.



### PARTS CONCERNED (thickness in mm) :

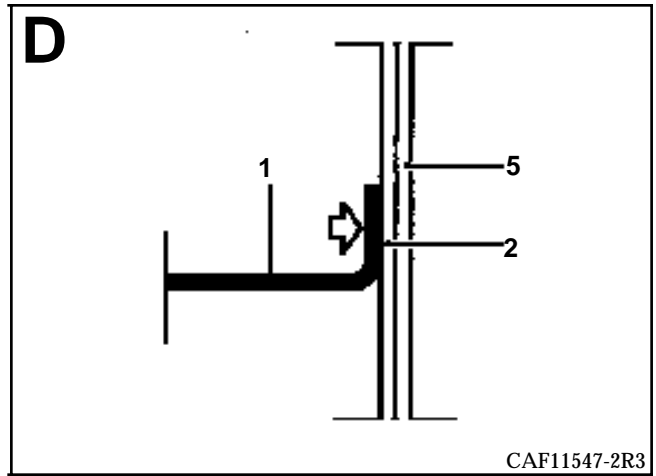
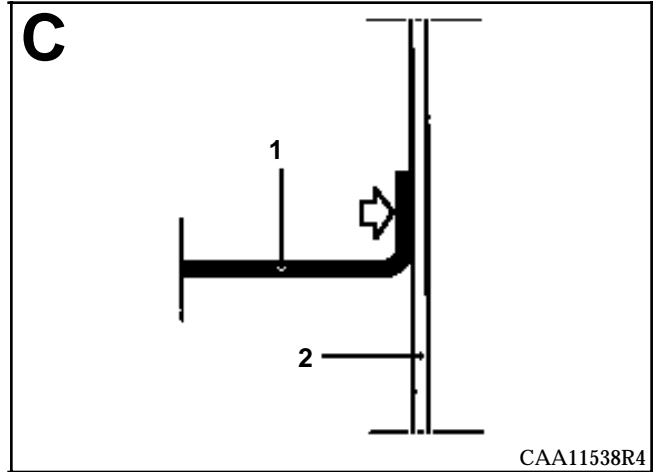
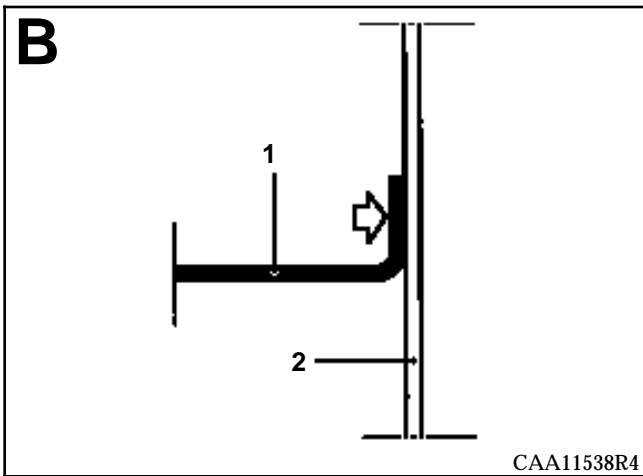
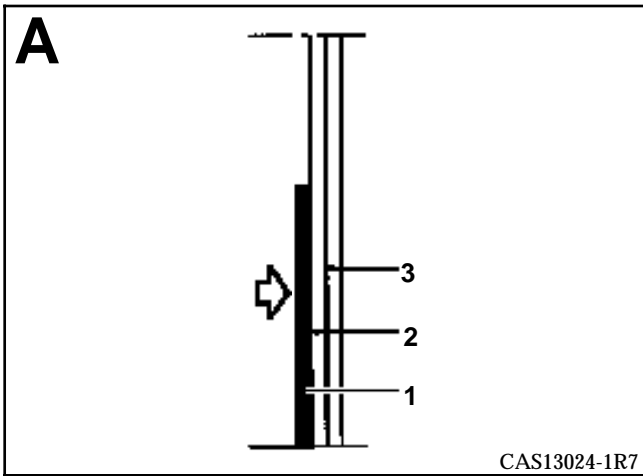
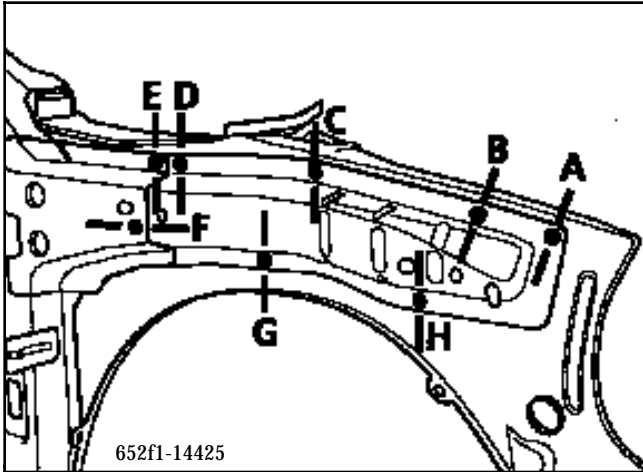
1	Cowl side panel upper front reinforcement	1
2	Cowl side panel pillar lining	1.2
3	Headlight carrier panel	1.2
4	Engine support plate	2
5	Side plenum chamber	1
6	Cowl side panel upper rear reinforcement	1
7	Wheel arch	0.8

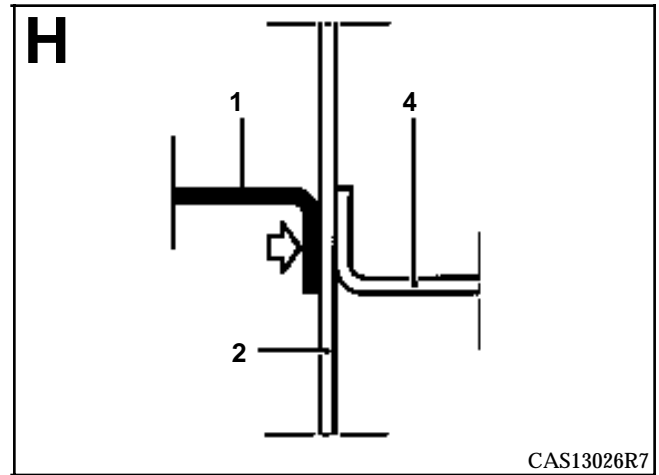
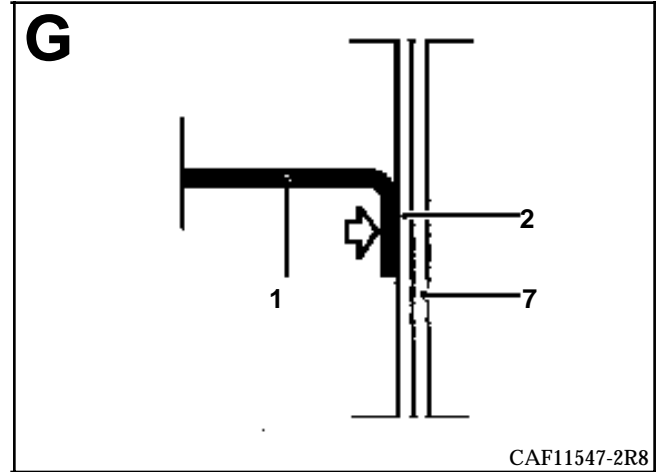
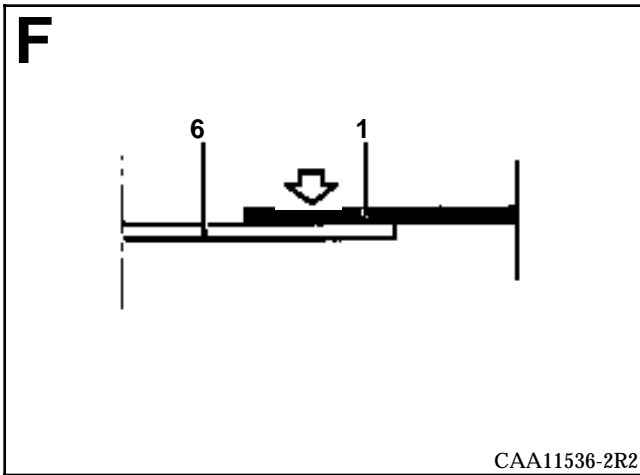
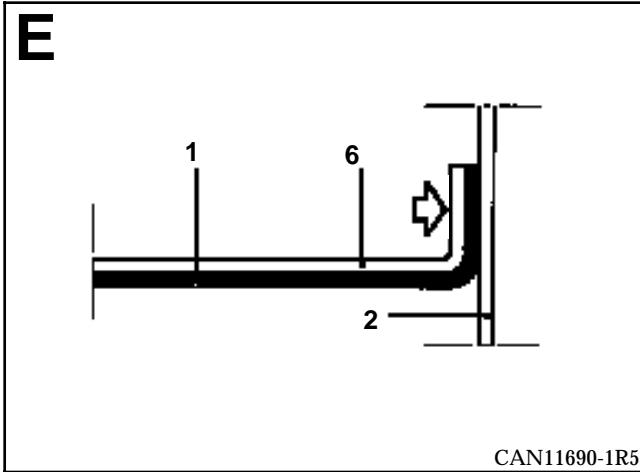


# UPPER FRONT STRUCTURE

Cowl side panel upper reinforcement, front section

42 F





### INTRODUCTION

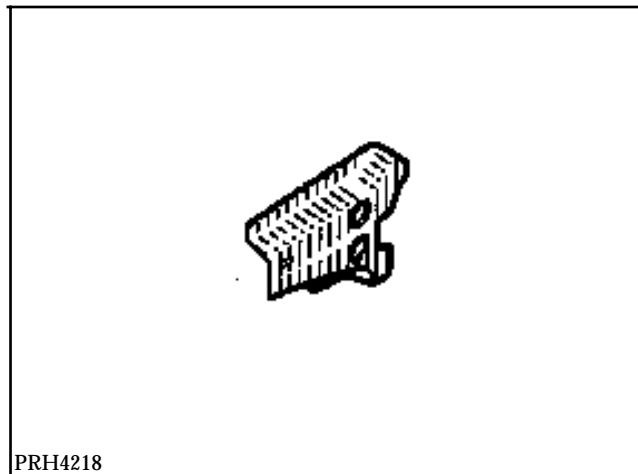
The replacement of this part is a complementary operation to the replacement of the front pillar for a frontal impact.

In the operation described below there are only descriptions of the joints specific to the part concerned.

Information concerning additional parts will be dealt with in the respective section (see contents).

### COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

Part assembled with welded shaft.



PRH4218

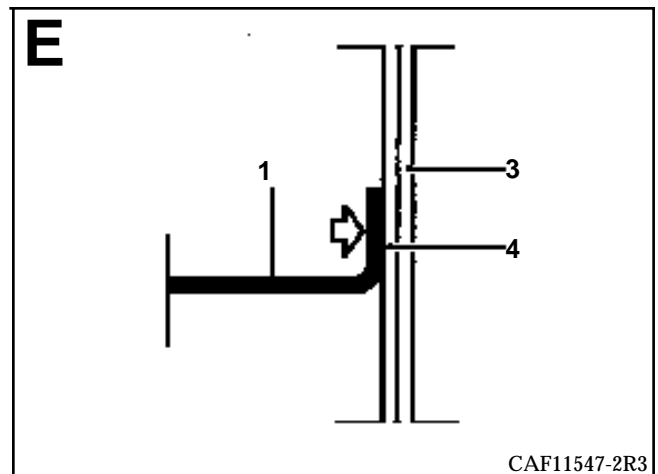
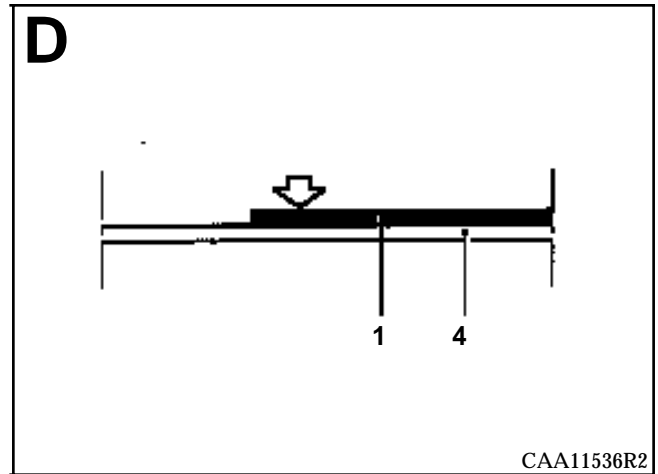
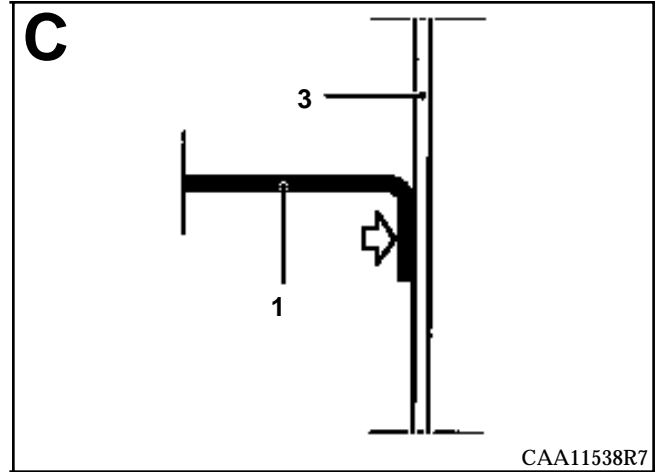
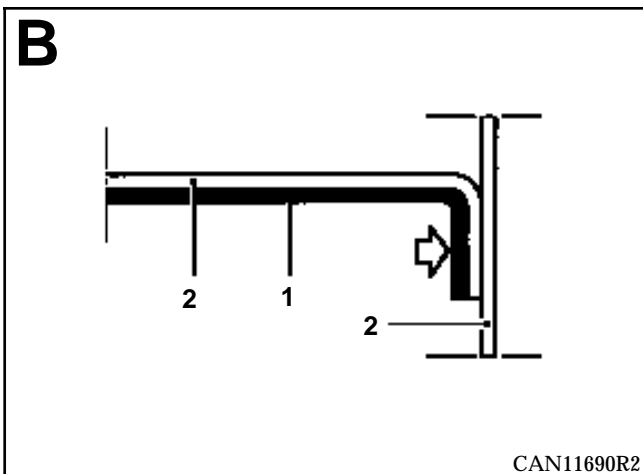
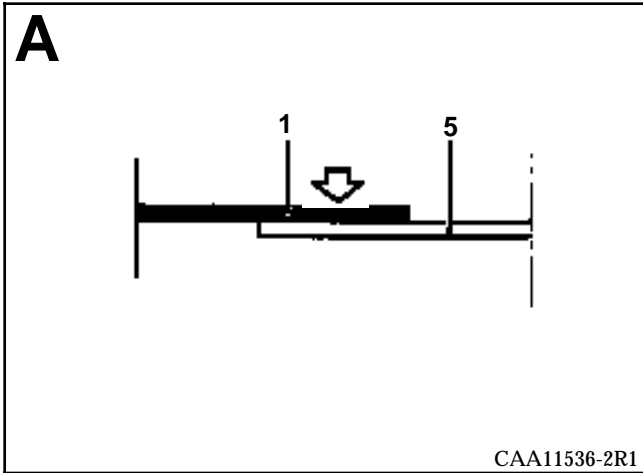
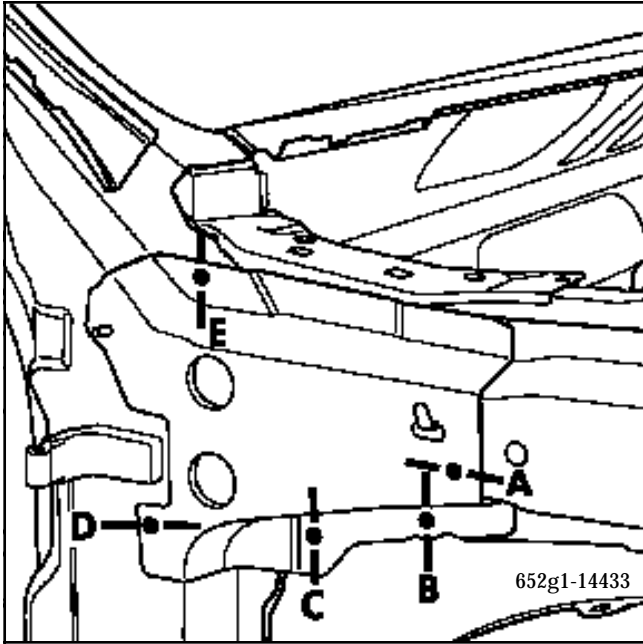
### PARTS CONCERNED (thickness in mm) :

- |   |   |     |
|---|---|-----|
| 1 | Cowl side panel upper rear reinforcement  | 1   |
| 2 | Cowl side panel upper front reinforcement | 1   |
| 3 | Cowl side panel pillar lining             | 1.2 |
| 4 | Front pillar                              | 1.2 |

# UPPER FRONT STRUCTURE

Cowl side panel upper rear reinforcement, rear section

42 **G**



INTRODUCTION

The replacement of this part is an operation for a frontal impact and is complementary to the replacement of the cowl side panel (pillar lining).

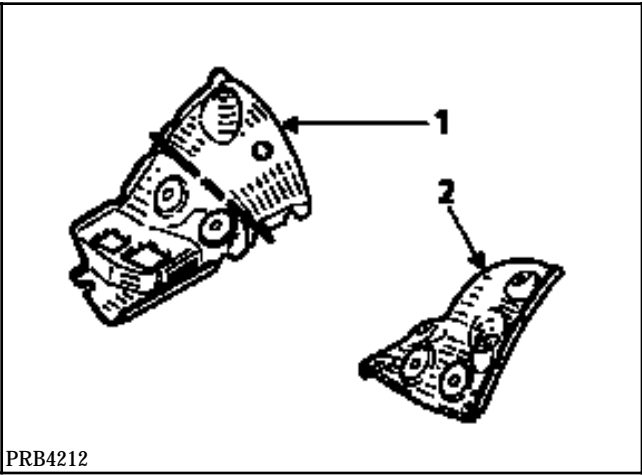
It can be carried out partially from the right hand side (see cut, diagram and method below).

In the operation described below there are only descriptions of the joints specific to the part concerned.

Information concerning other parts will be dealt with in the respective section (see contents).

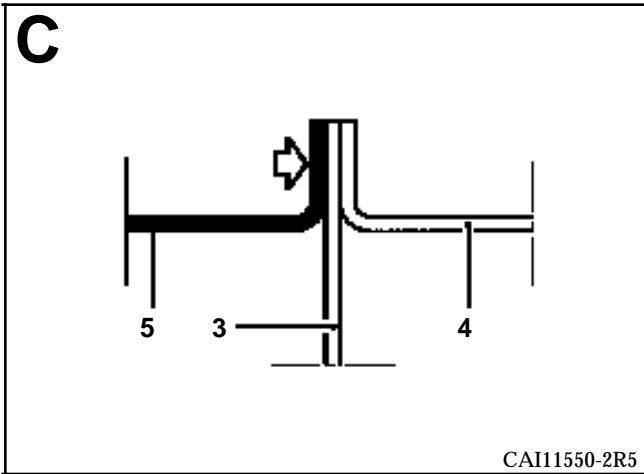
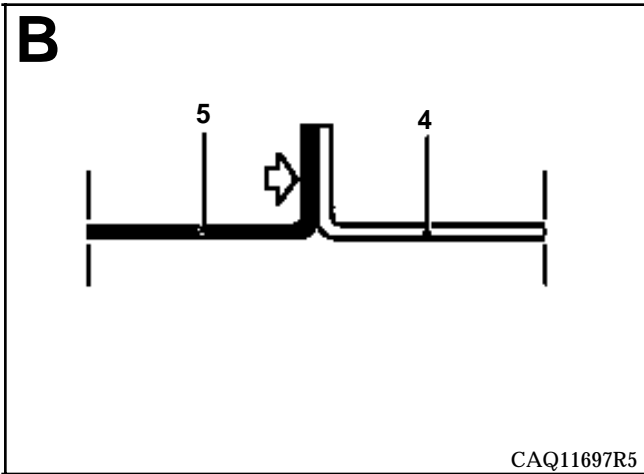
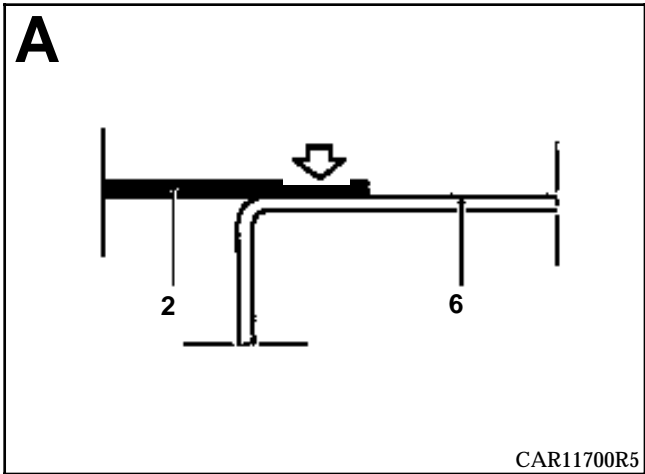
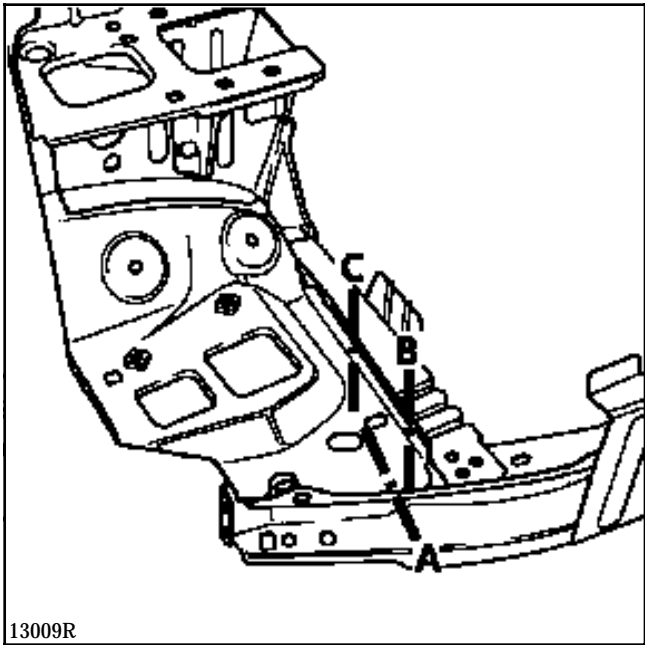
COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

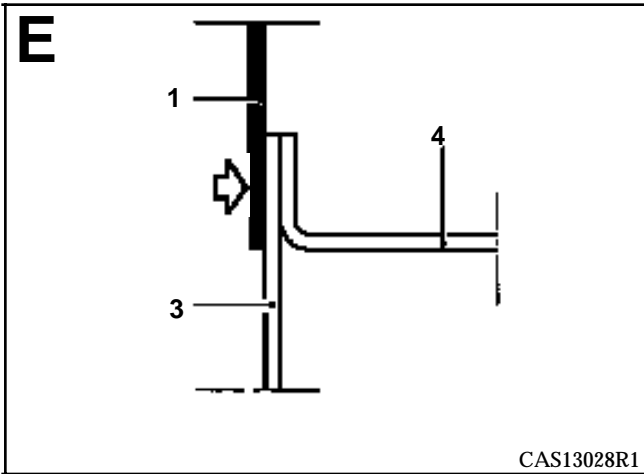
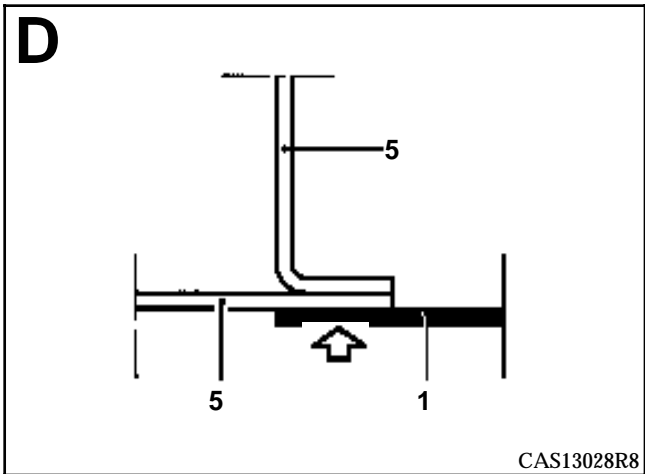
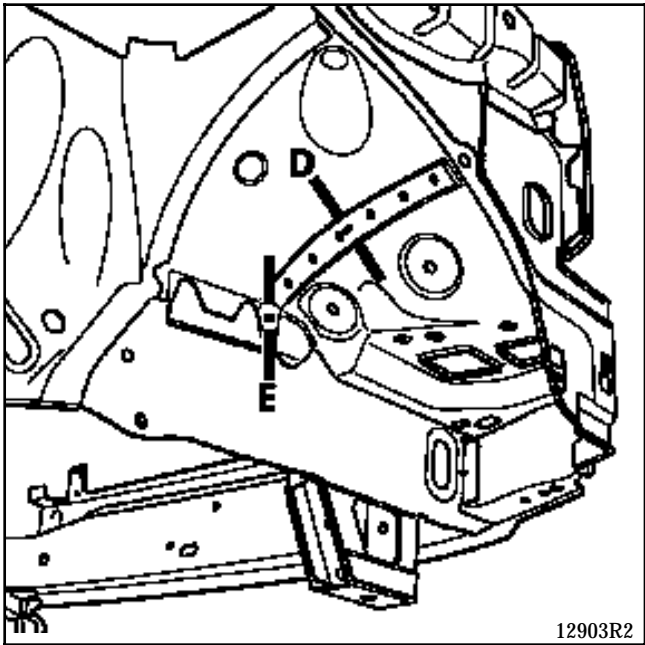
- 1 - Part only (right hand side).
- 2 - Part only (left hand side).

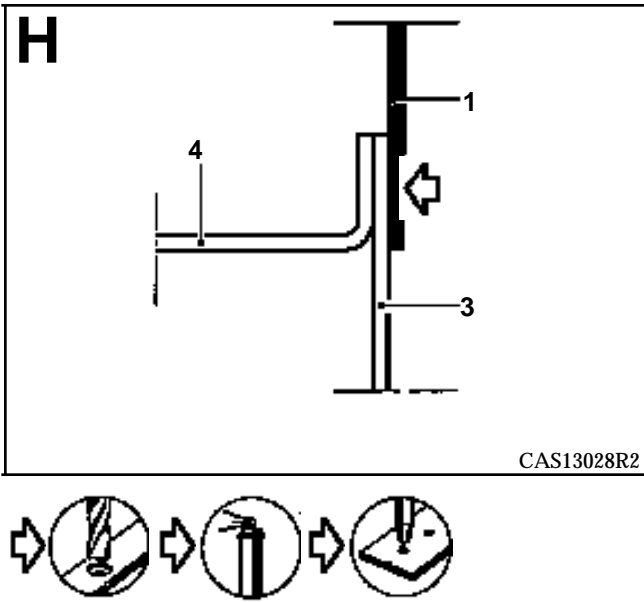
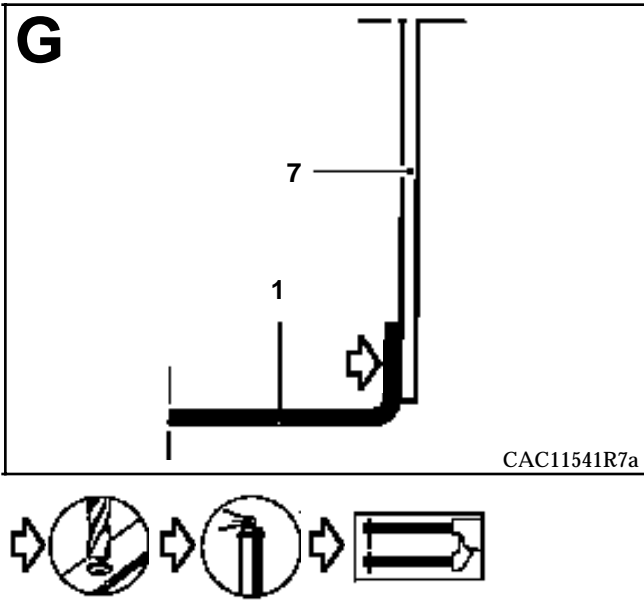
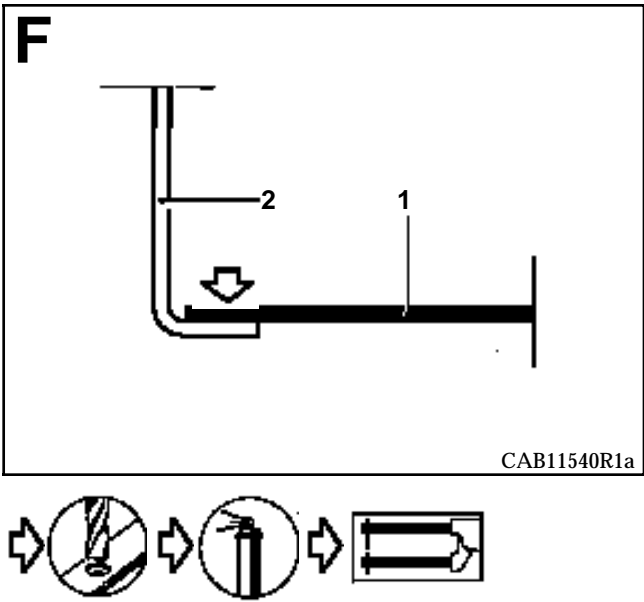
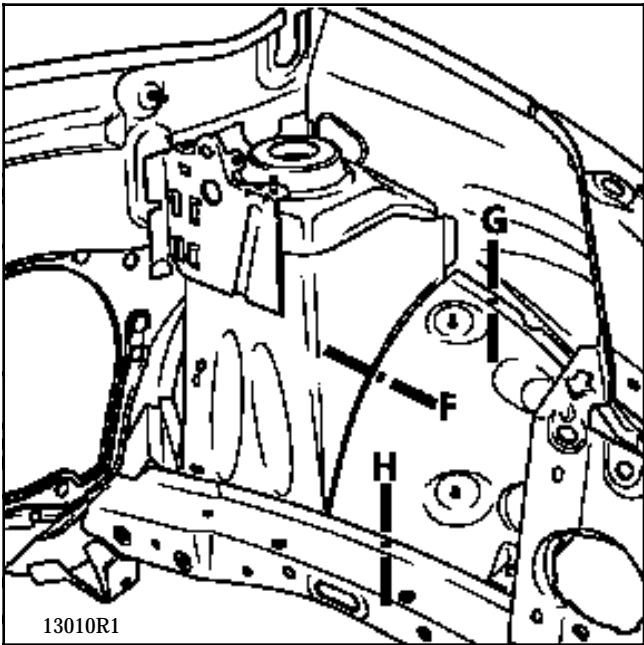


PARTS CONCERNED (thickness in mm):

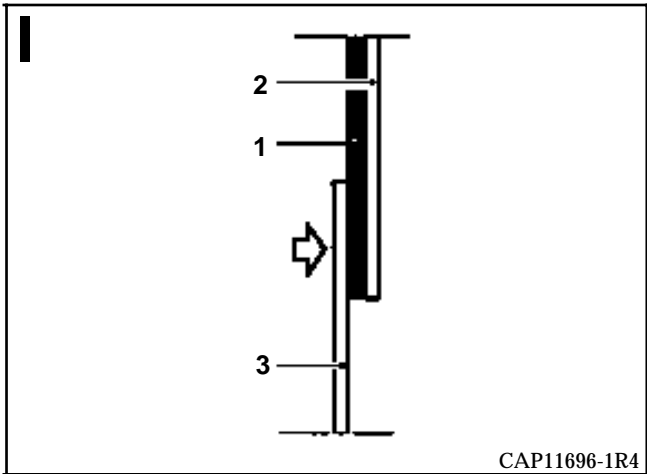
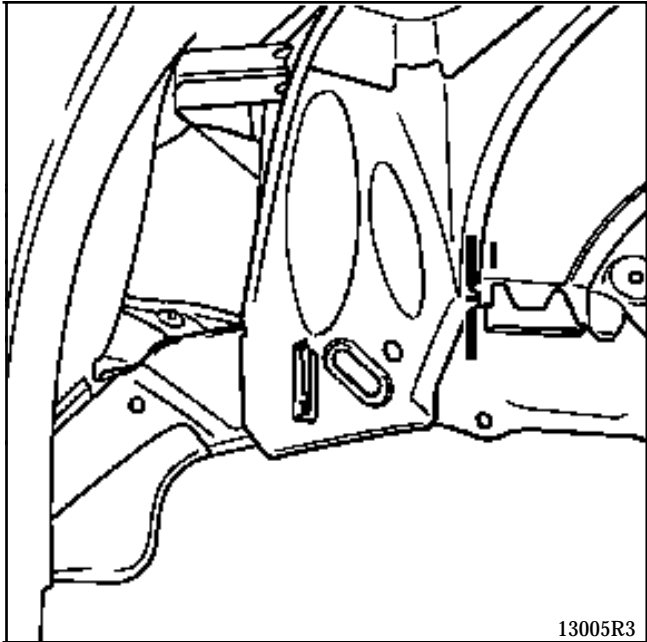
1	Engine mounting height adjuster	1.8
2	Shock absorber cup height adjuster	1.5
3	Side member closure panel	1.2
4	Side member, front section	1.5
5	Front wheel arch	0.8
6	Front end cross member	1.8
7	Cowl side panel (pillar lining)	1.2











INTRODUCTION

The replacement of this part is a complementary operation to the replacement of the cowl side panel (pillar lining) for a frontal impact.

It also requires the replacement of the cowl side panel upper reinforcements (pillar lining), and the use of the repair bench.

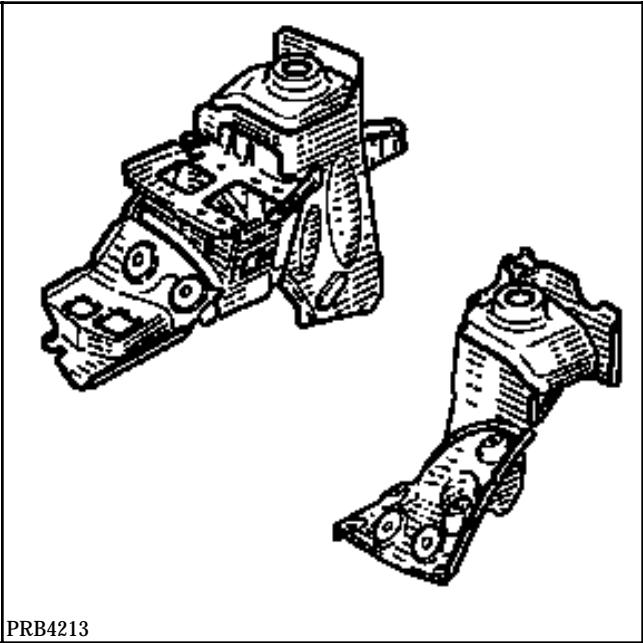
In the operation described below there are only descriptions of the joints specific to the part concerned.

Information concerning other parts will be dealt with in the respective section (see contents).

COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

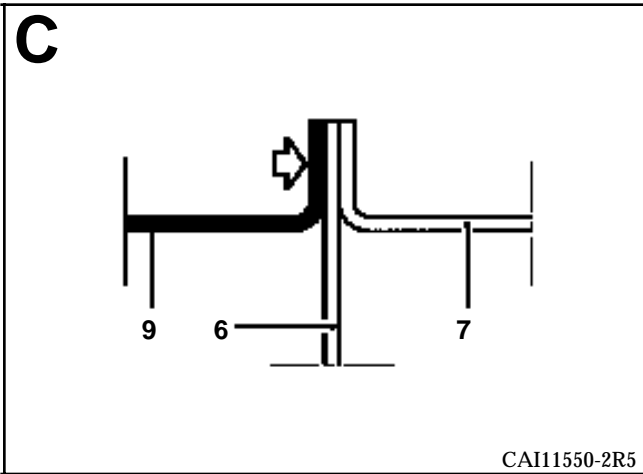
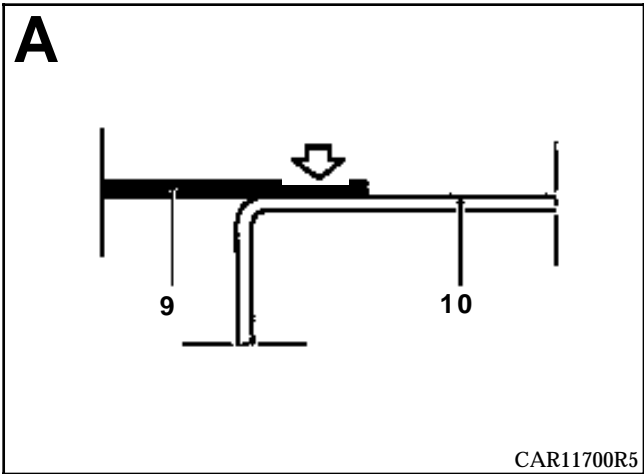
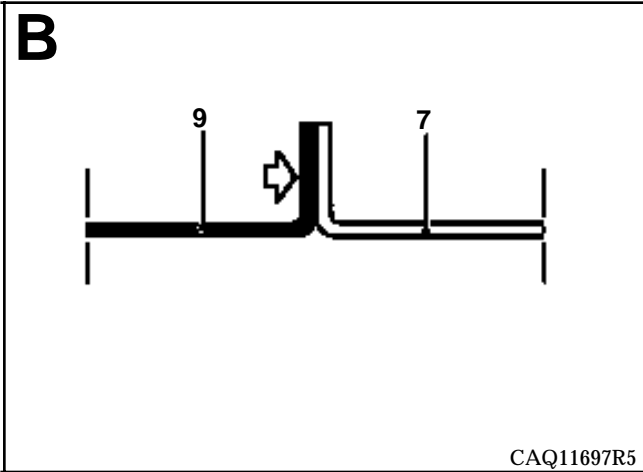
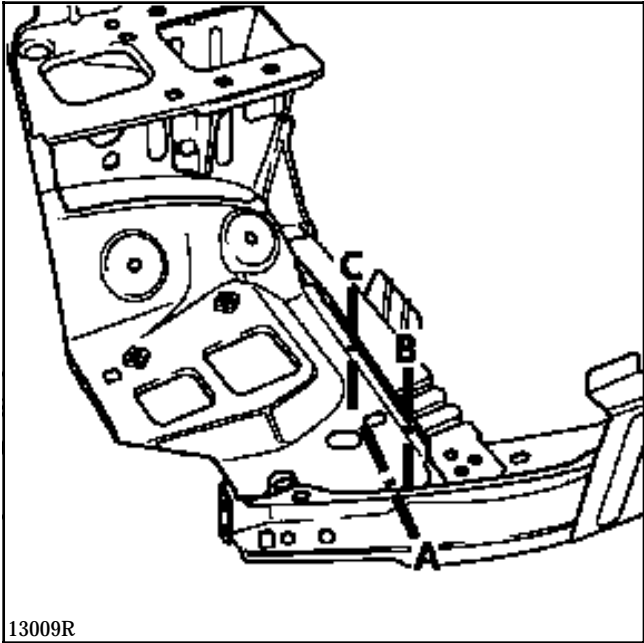
Part assembled with :

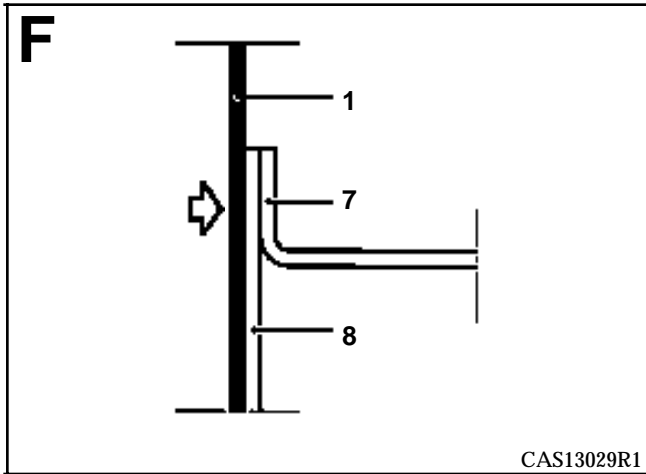
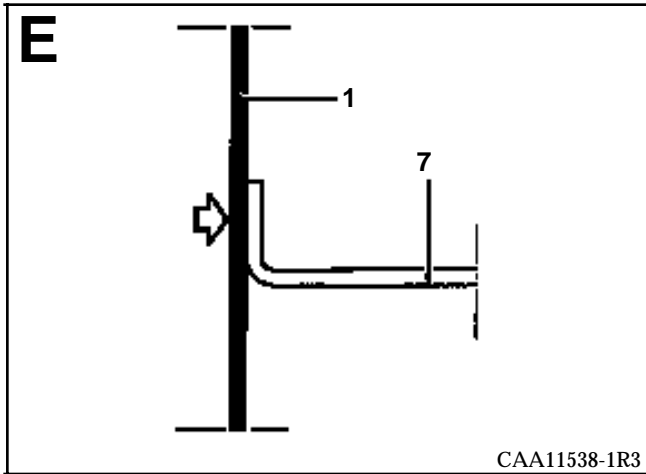
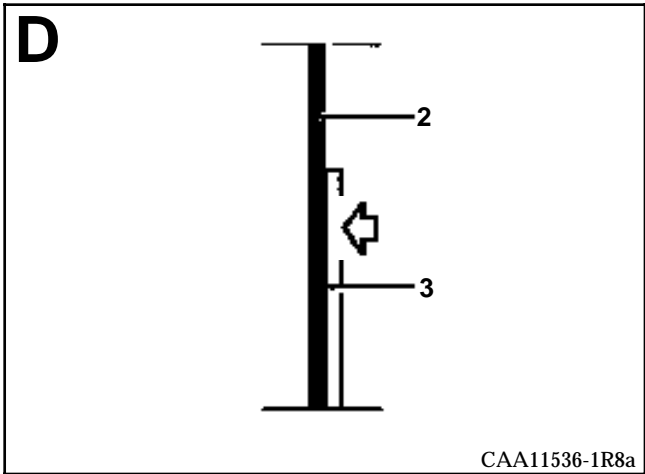
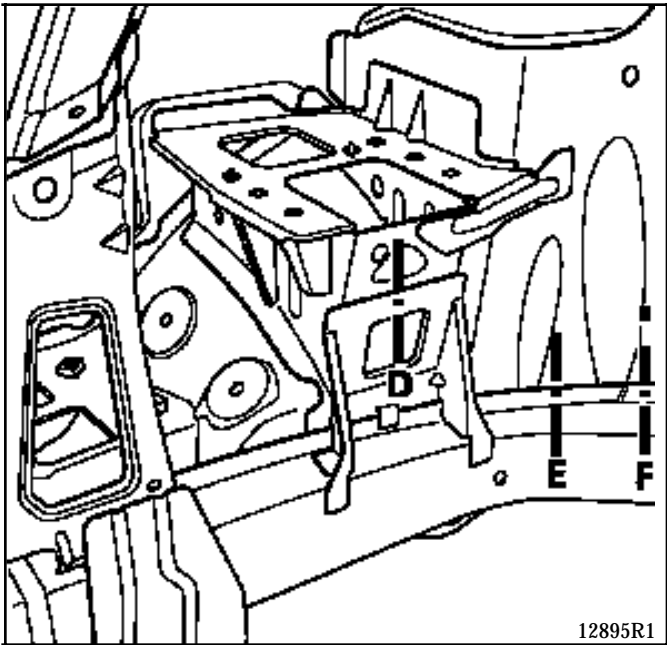
- engine mounting height adjuster (right hand side),
- engine support plate (right hand side),
- wheel arch ,
- shock absorber cup ,
- shock absorber cup height adjuster ,
- ABS mounting (right hand side),
- injection unit and impact sensor mounting (left hand side).

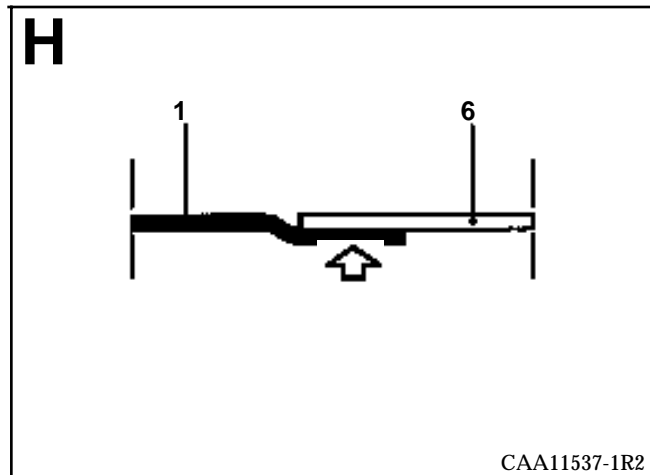
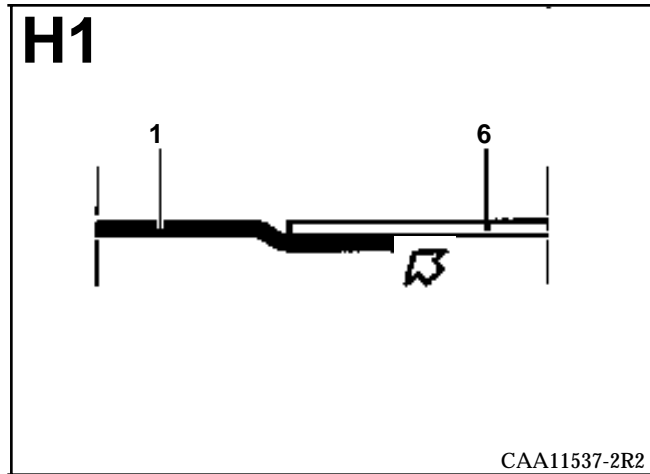
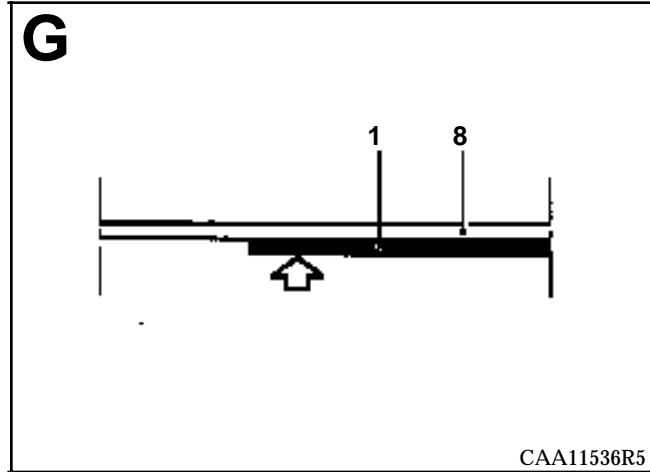
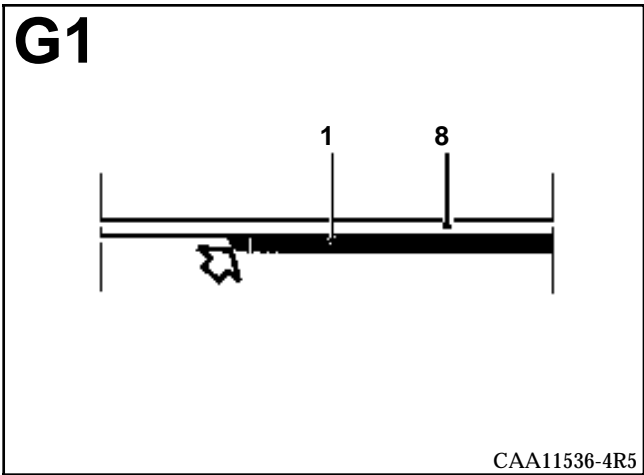
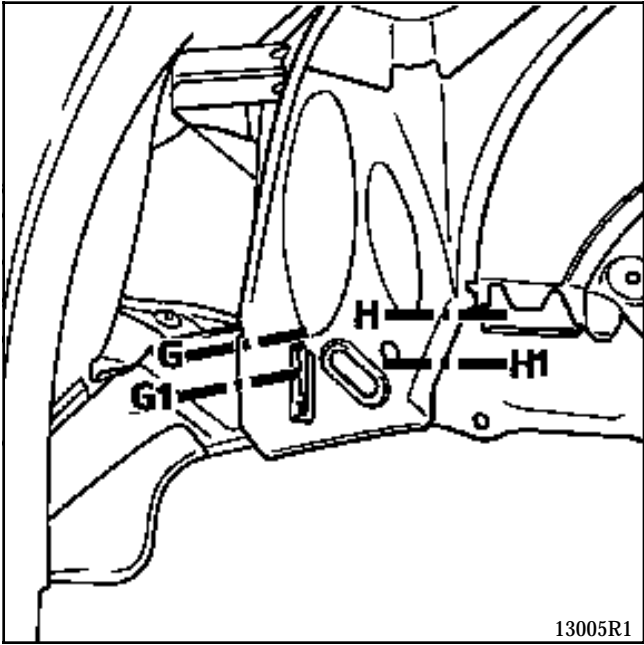


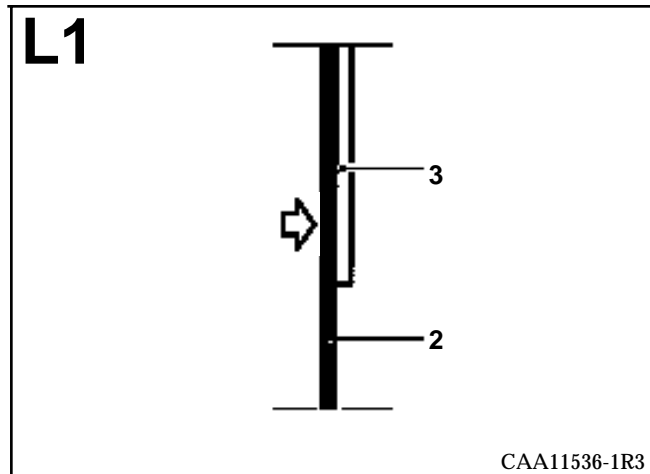
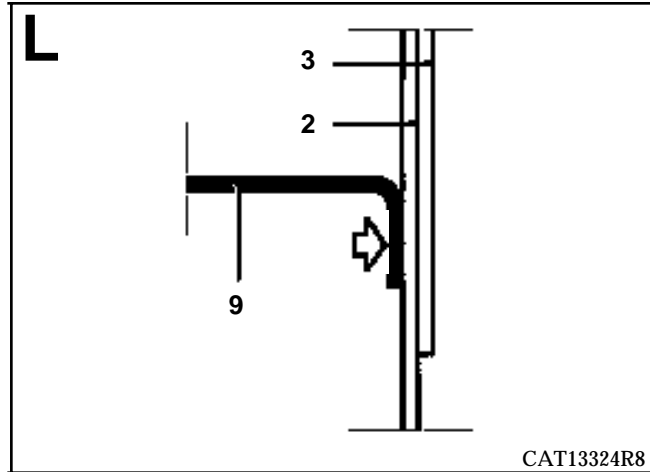
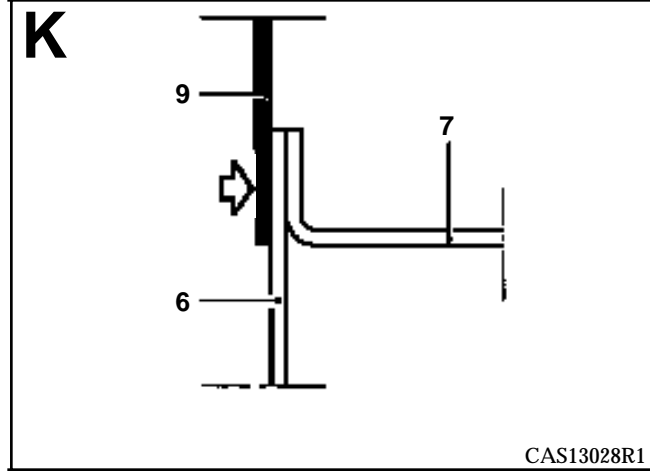
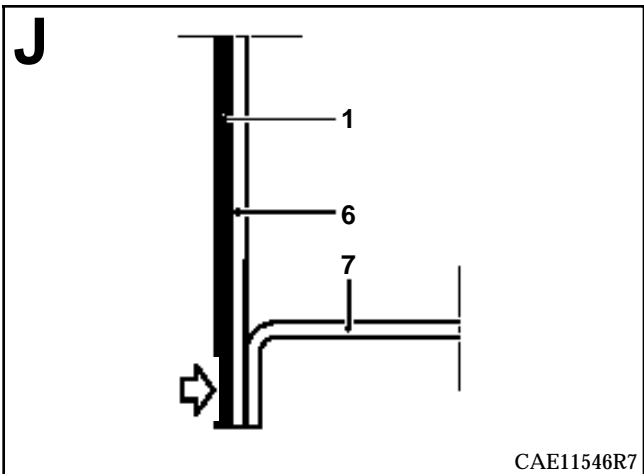
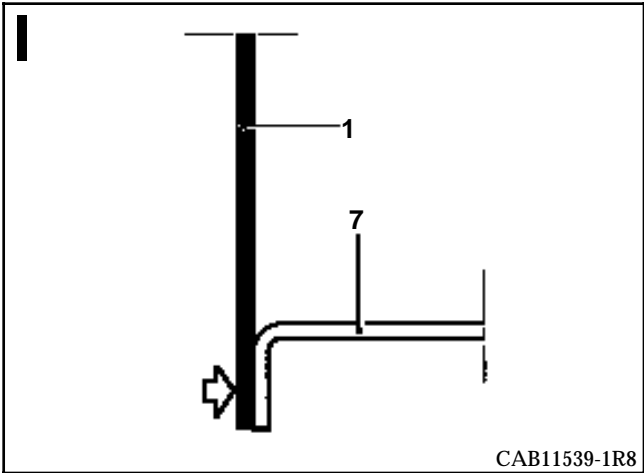
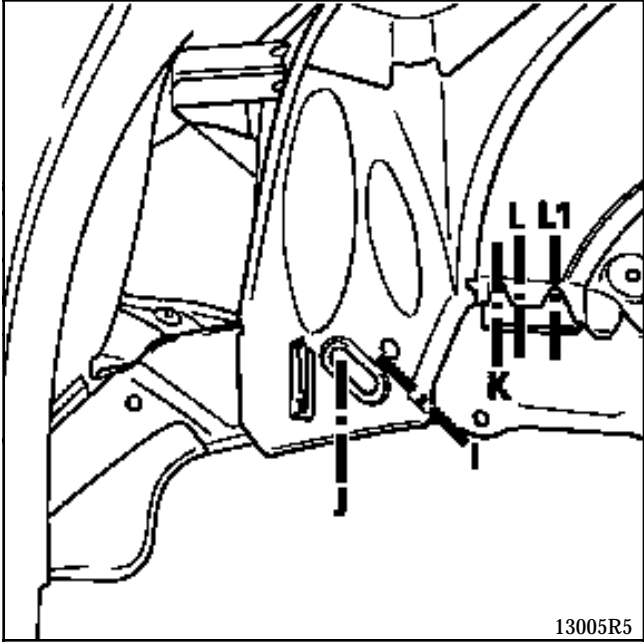
PARTS CONCERNED (thickness in mm):

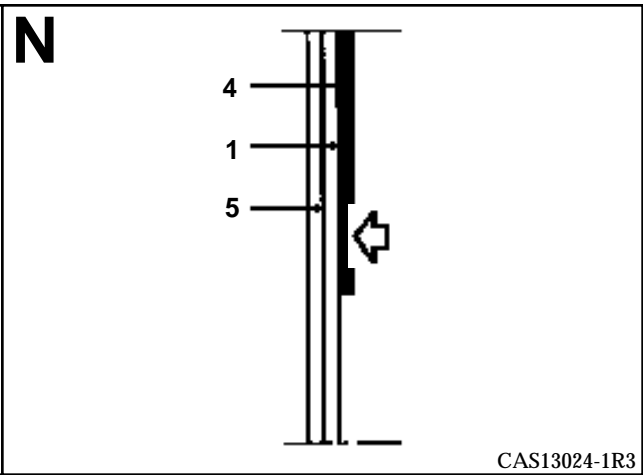
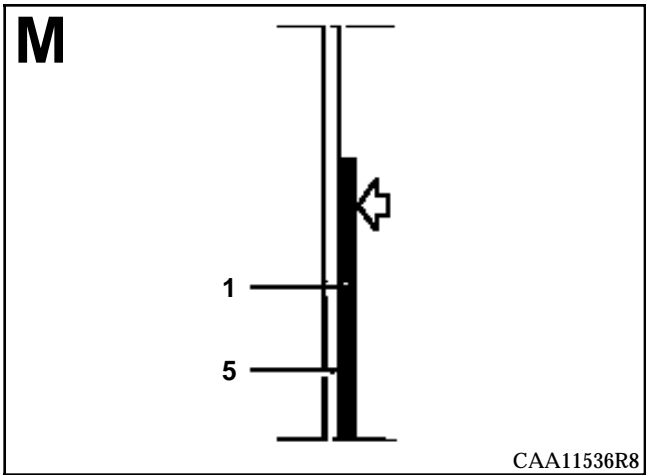
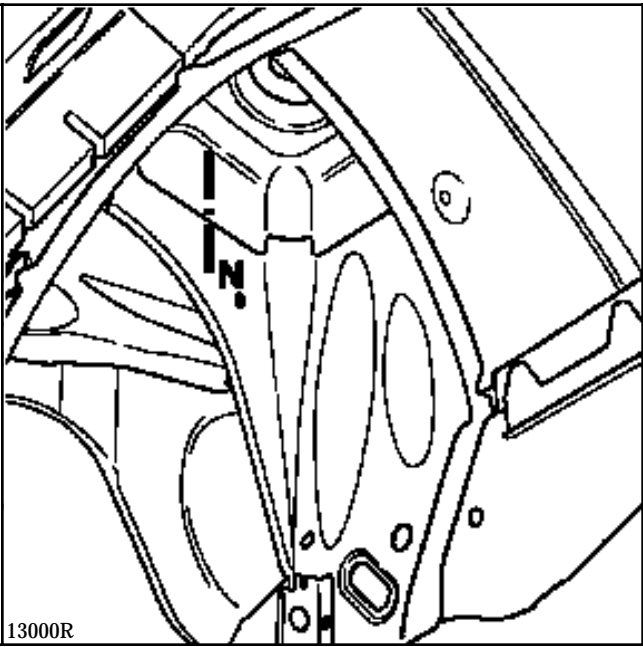
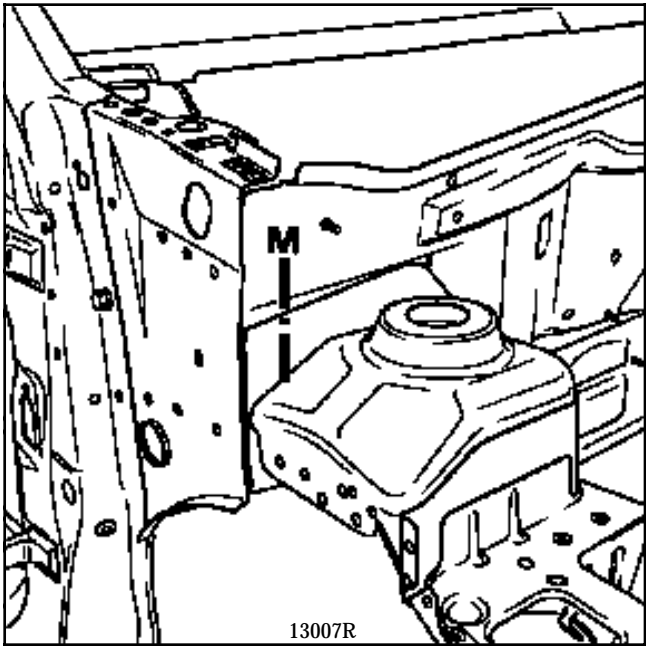
1	Shock absorber cup height adjuster	1.5
2	Engine mounting height adjuster	1.8
3	Engine mounting reinforcement	1.5
4	Shock absorber cup	2
5	Side plenum chamber	1
6	Side member closure panel	1.2
7	Front side member, front section	1.5
8	Front side member, rear section	2
9	Front wheel arch	0.8
10	Front end cross member	1.8
11	Shock absorber cup height adjuster / plenum chamber joining component	1.5

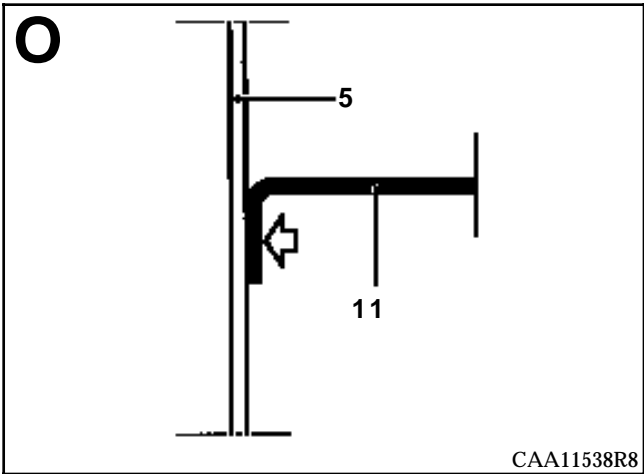
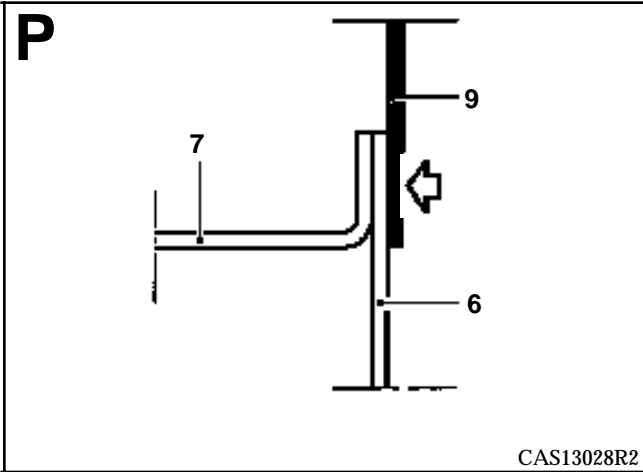
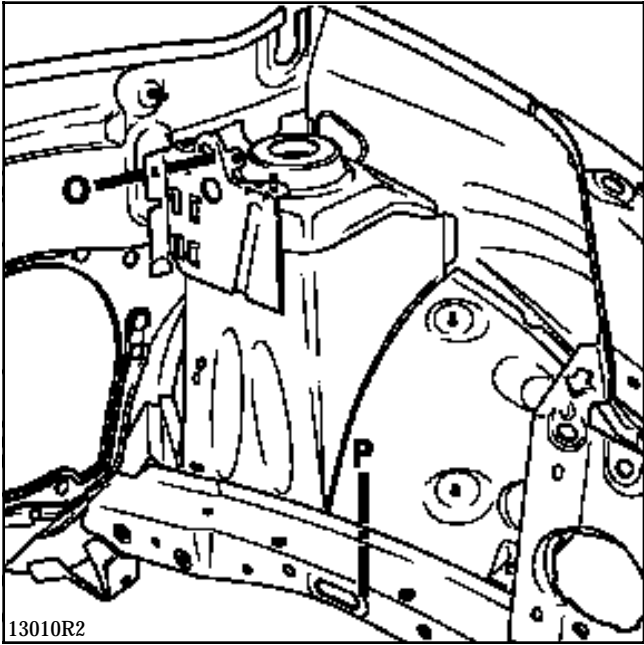














INTRODUCTION

The replacement of this part is a complementary operation to the replacement of the front half unit.

In the operation described below there are only descriptions of the joints specific to the part concerned.

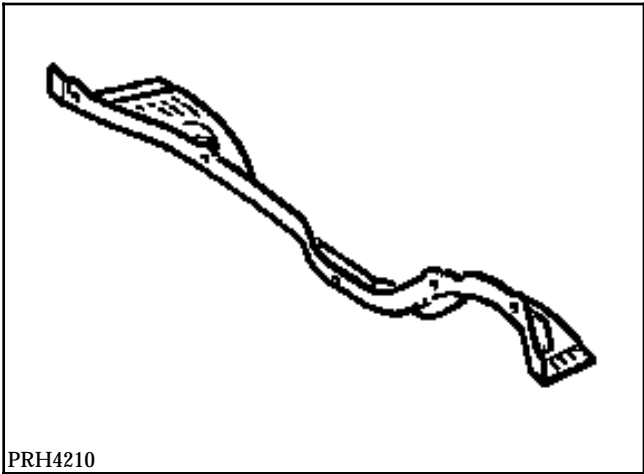
Information concerning other parts will be dealt with in the respective sections (see contents).

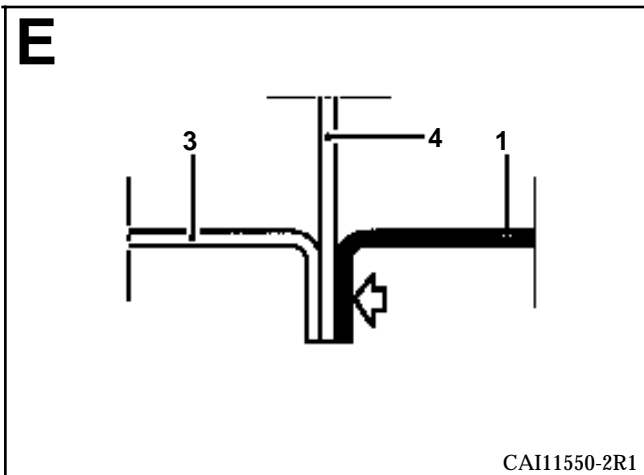
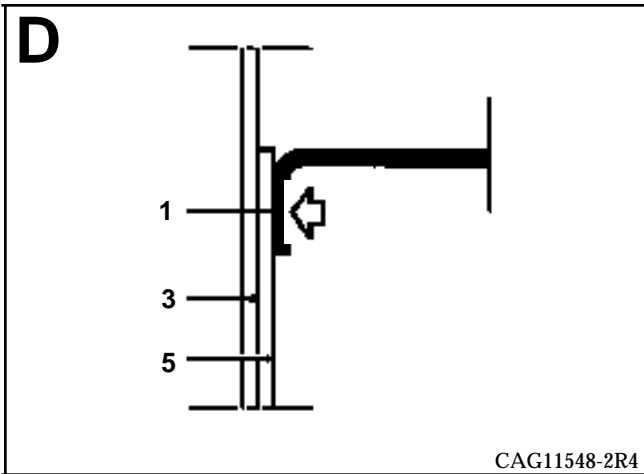
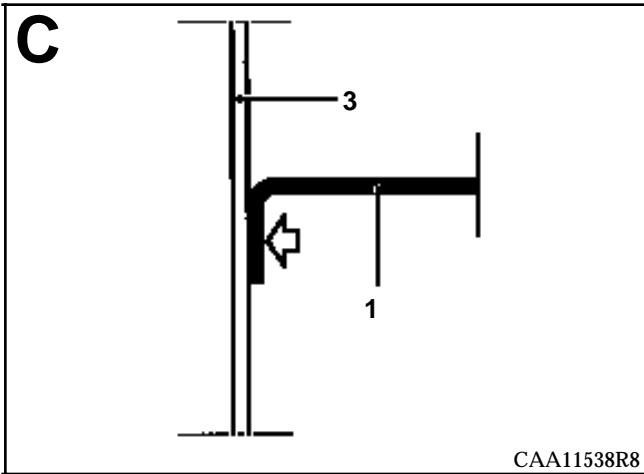
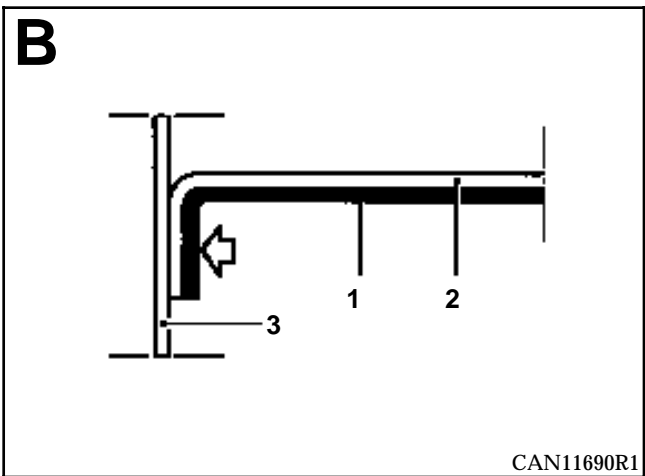
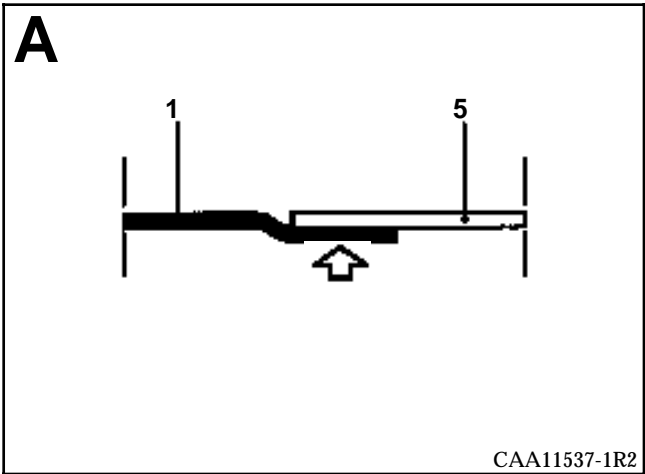
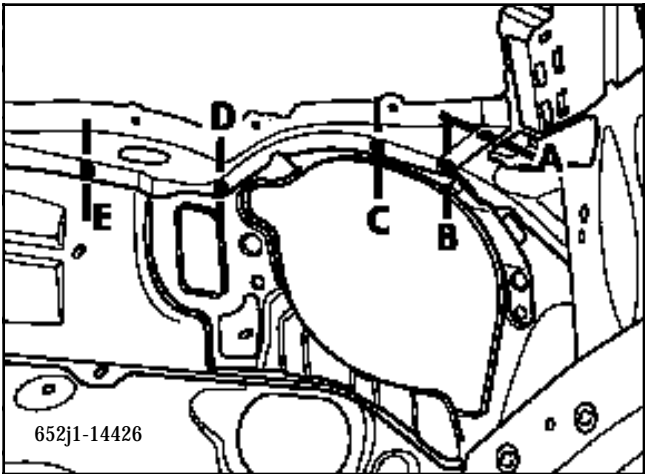
COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

- Part assembled with :
- nut to be welded,
  - shaft to be welded.

PARTS CONCERNED (thickness in mm):

1	Central plenum chamber	1
2	Side plenum chamber	1
3	Bulkhead	0.7
4	Windscreen wiper plate centre reinforcement	1.2
5	Pedal plate reinforcement	1





INTRODUCTION

The replacement of this part is a complementary operation to the replacement of the front pillar for a front side impact.

In the operation described below there are only descriptions of the joints specific to the part concerned.

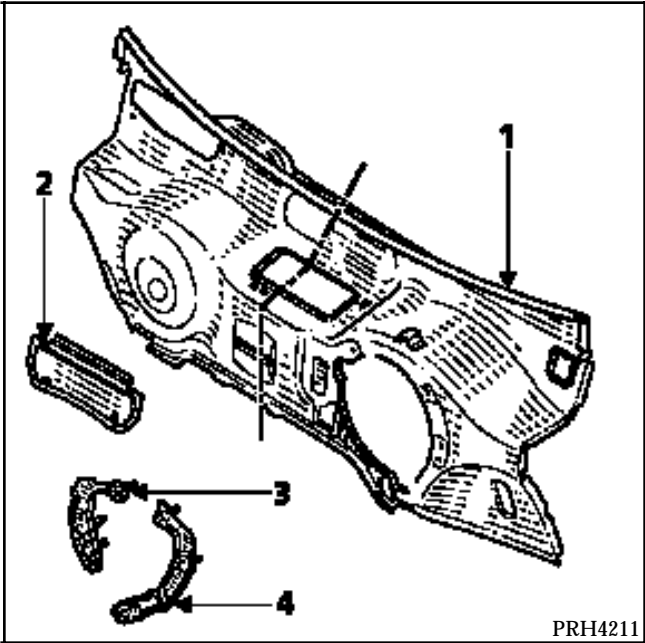
Information concerning other parts will be dealt with in the respective sections (see contents).

**NOTE :** for vehicles not fitted with air conditioning, the blanking cover (2) will also have to be ordered, which will be mounted at its lower section by two rivets whose sealing will be ensured by a paint sealing mastic.

For driving school vehicles, parts (3 and 4) will have to be ordered separately, and the specific pedal mounting will have to be used as a drilling template.

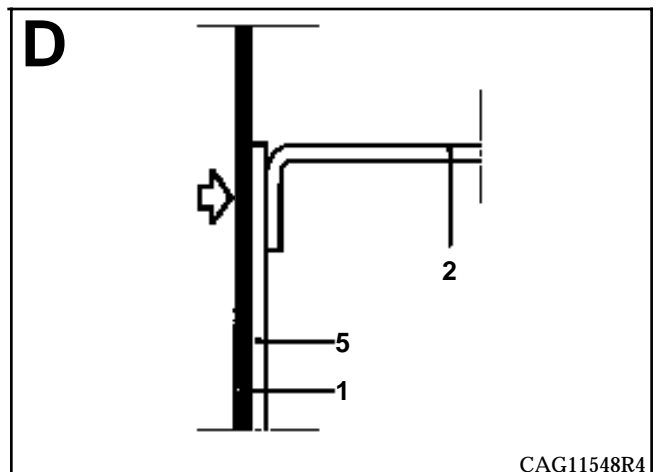
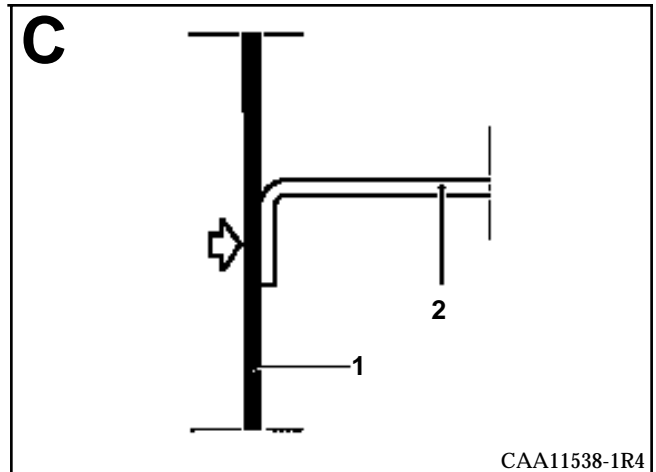
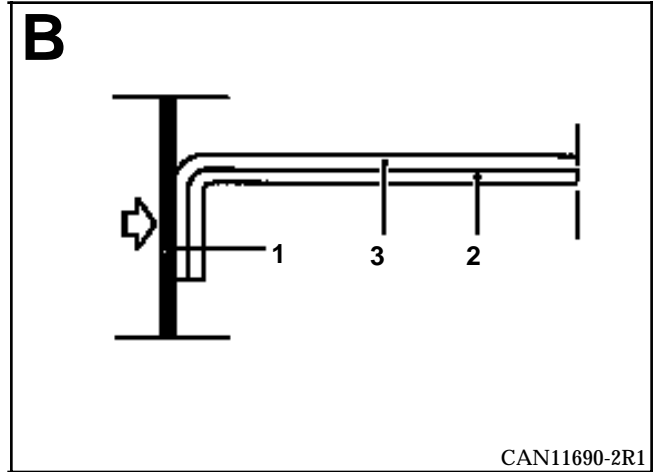
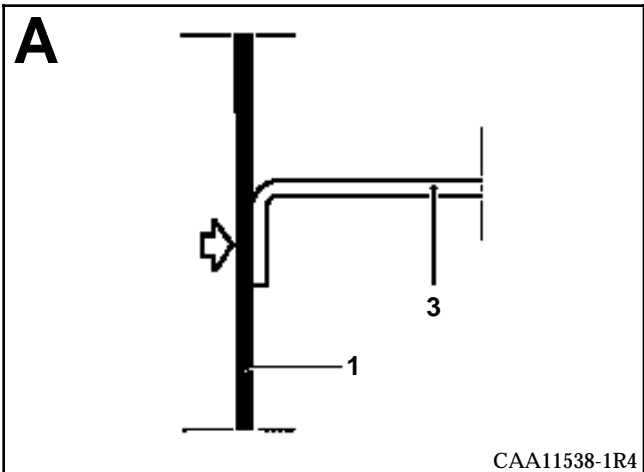
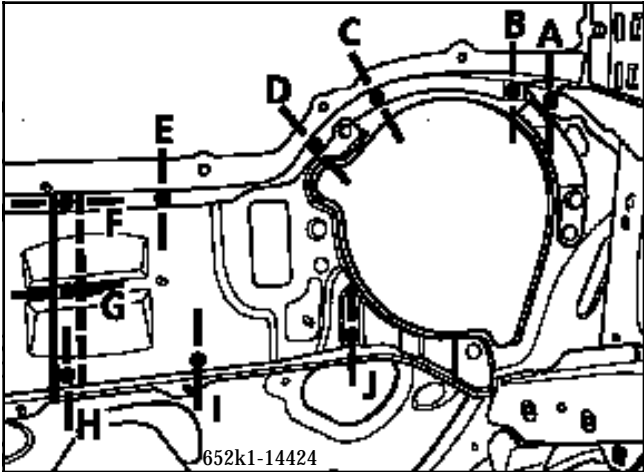
COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

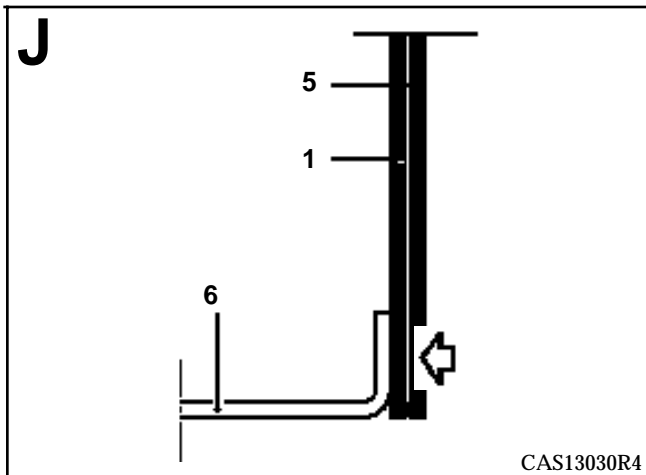
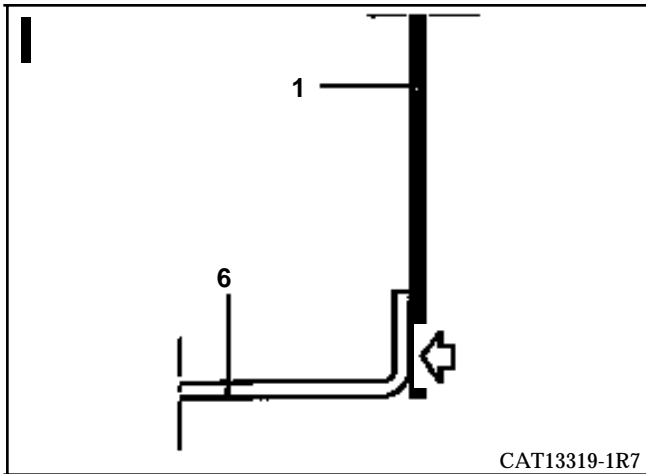
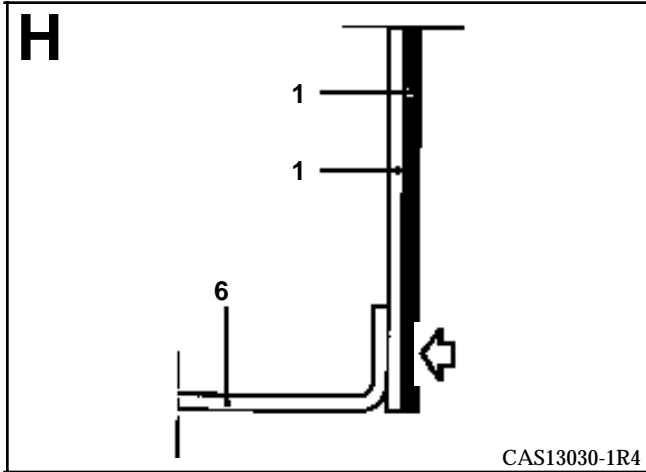
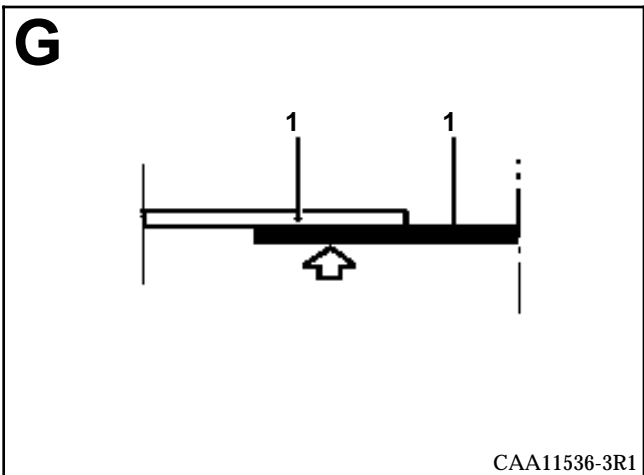
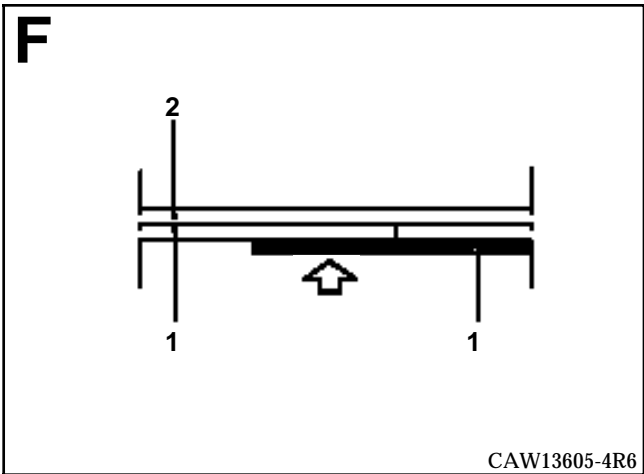
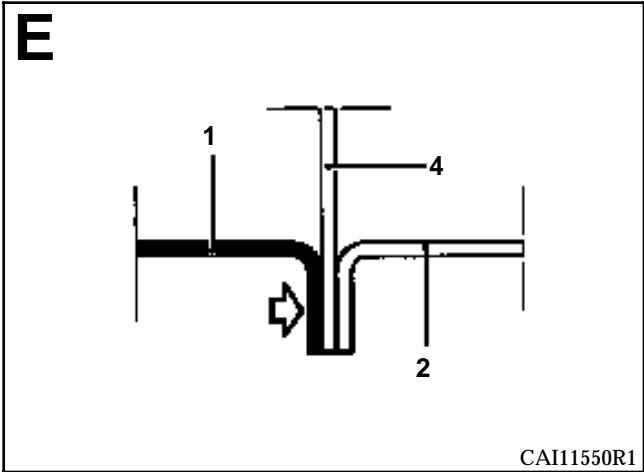
- 1 - **Bulkhead** : Part assembled with welded studs.
- 2 - **Blanking cover** : part only.
- 3 and 4 - **Pedal reinforcement** : Part assembled with welded bolt.

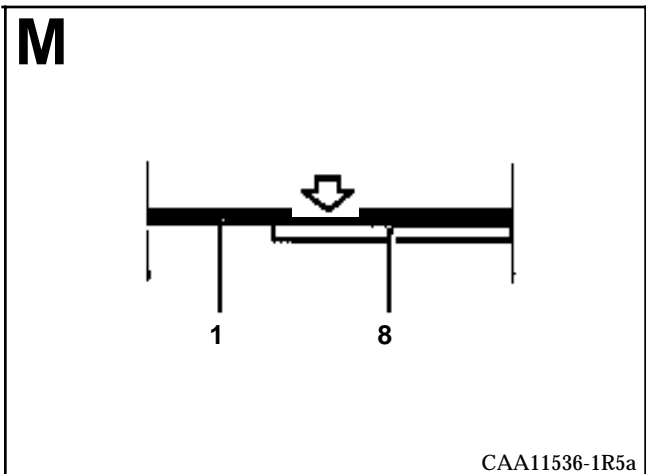
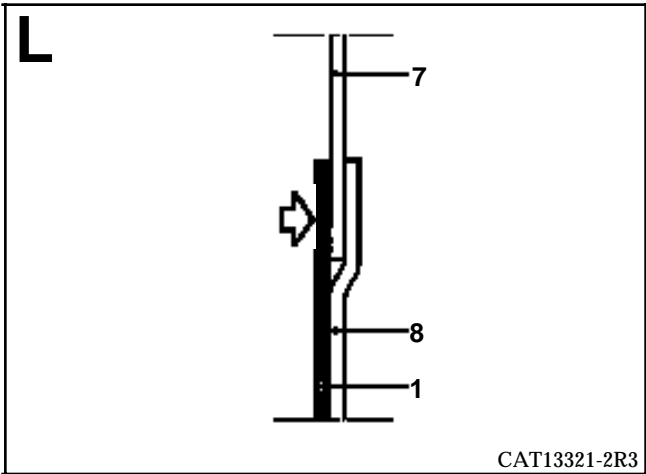
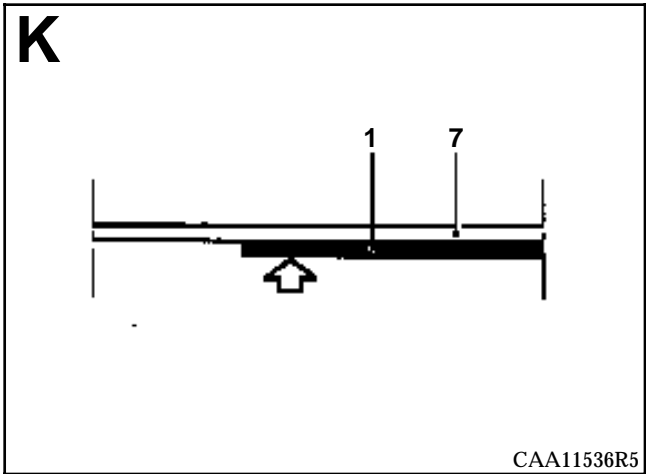
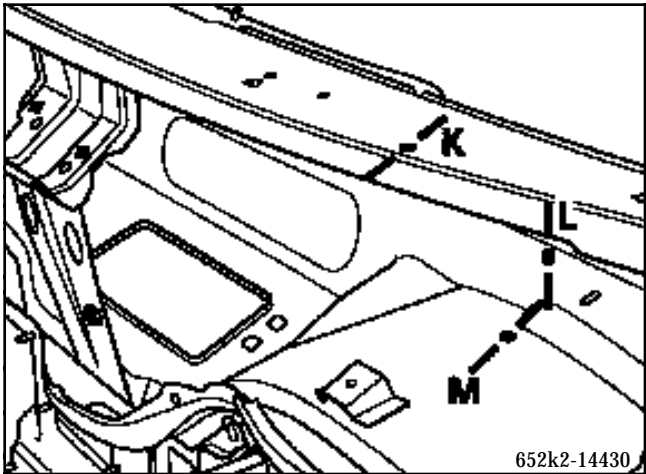


PARTS CONCERNED (thickness in mm):

1	Bulkhead	0.7
2	Central plenum chamber	1
3	Side plenum chamber	1
4	Windscreen wiper plate	
	centre reinforcement	1.2
5	Pedal plate reinforcement	1
6	Centre floor	0.7
7	Windscreen aperture lower cross member	1.2
8	Steering mounting unit, upper section	2







INTRODUCTION

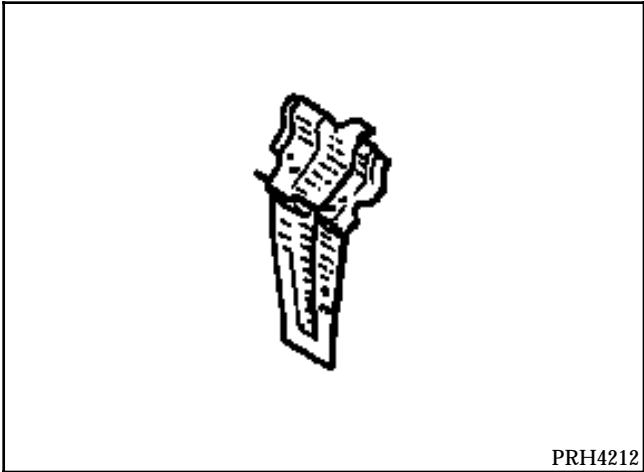
The replacement of this part is a complementary operation to the replacement of the windscreen aperture lower cross member for a frontal impact.

In the operation described below there are only descriptions of the joints specific to the part concerned.

Information concerning other parts will be dealt with in the respective sections (see contents).

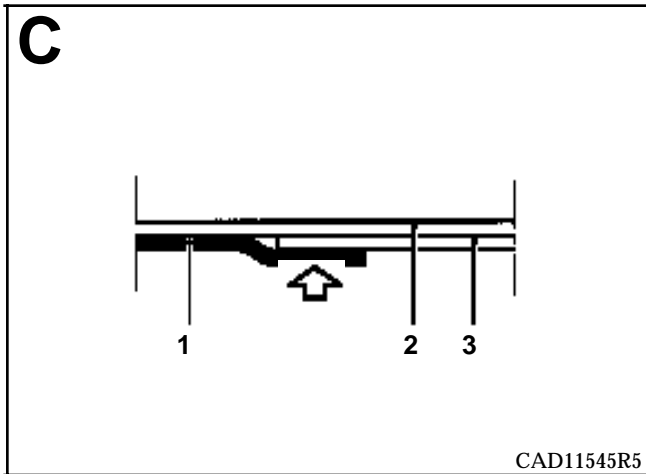
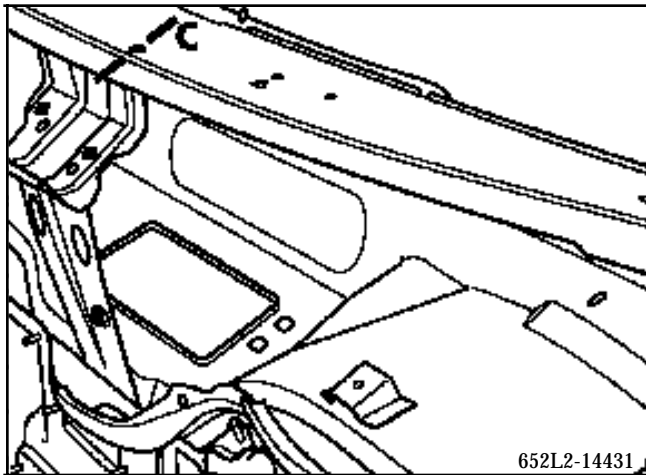
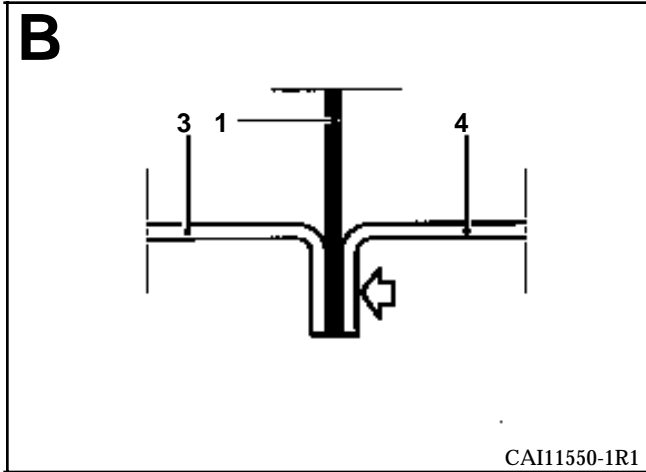
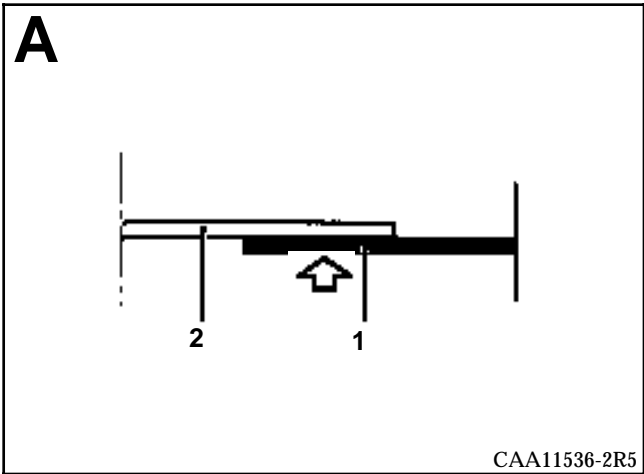
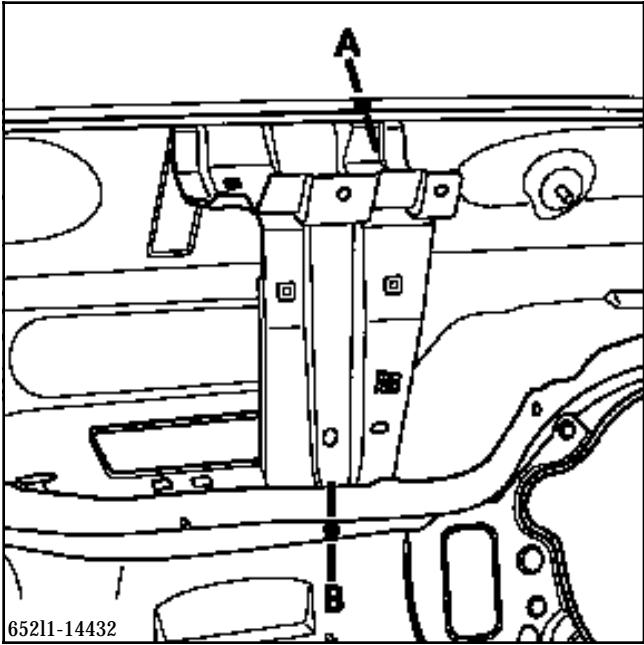
COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

Part assembled with upper and lower section with welded nuts.



PARTS CONCERNED (thickness in mm):

1	Windscreen wiper plate centre reinforcement	1.2
2	Windscreen aperture lower cross member	1.2
3	Bulkhead	0.7
4	Central plenum chamber	1





INTRODUCTION

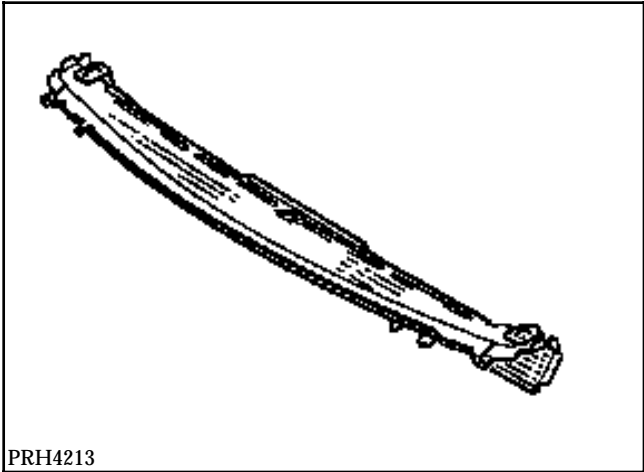
The replacement of this part is a complementary operation to the replacement of the front pillar lining for a front side impact.

In the operation described below there are only descriptions of the joints specific to the part concerned.

Information concerning other parts will be dealt with in the respective sections (see contents).

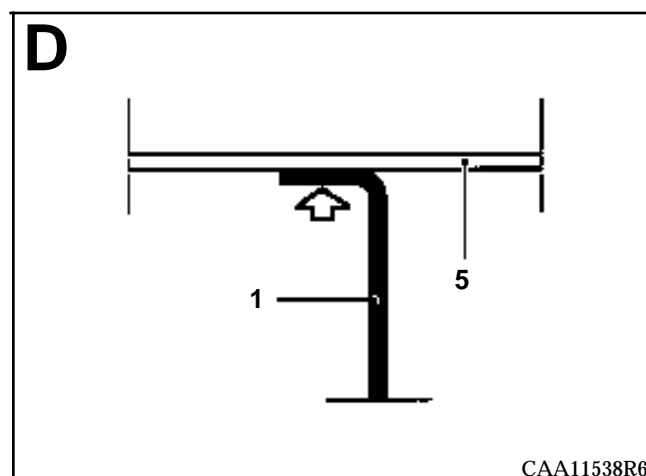
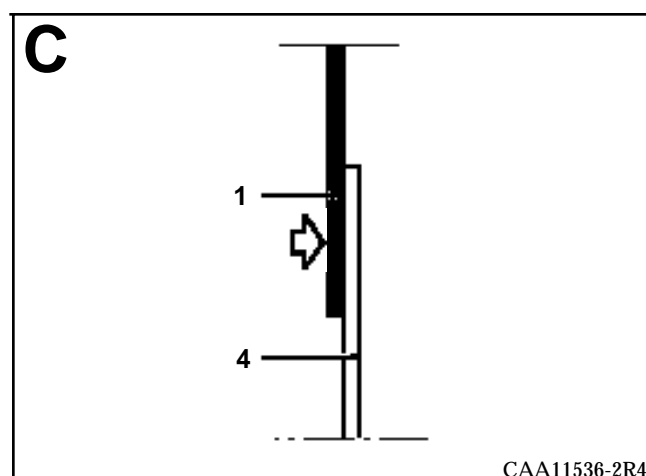
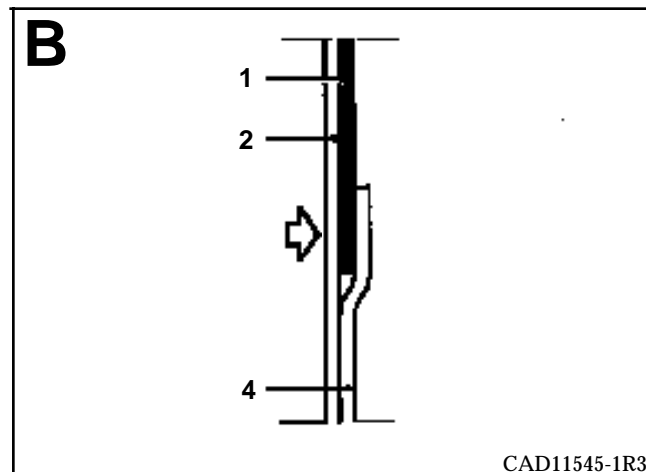
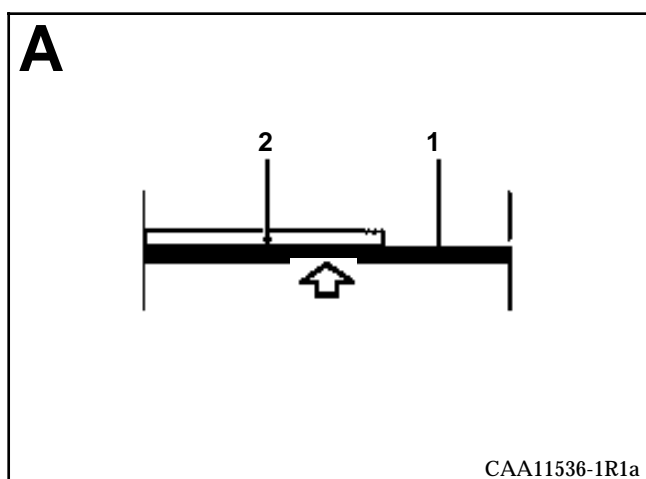
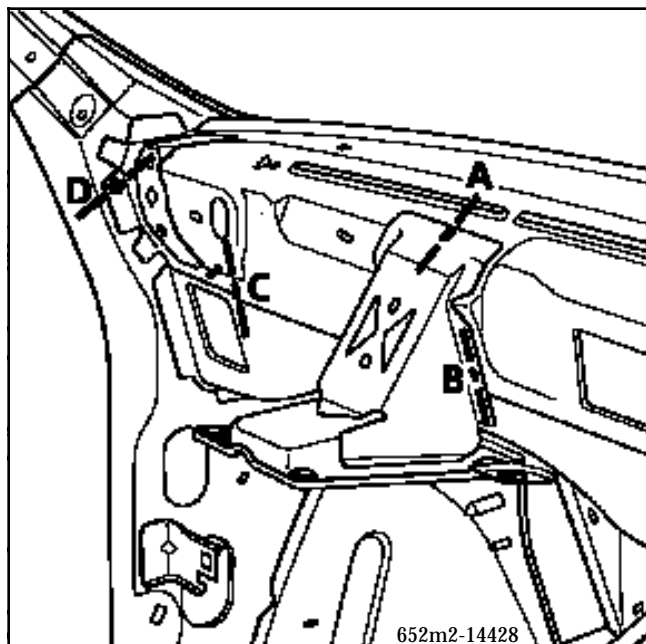
COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

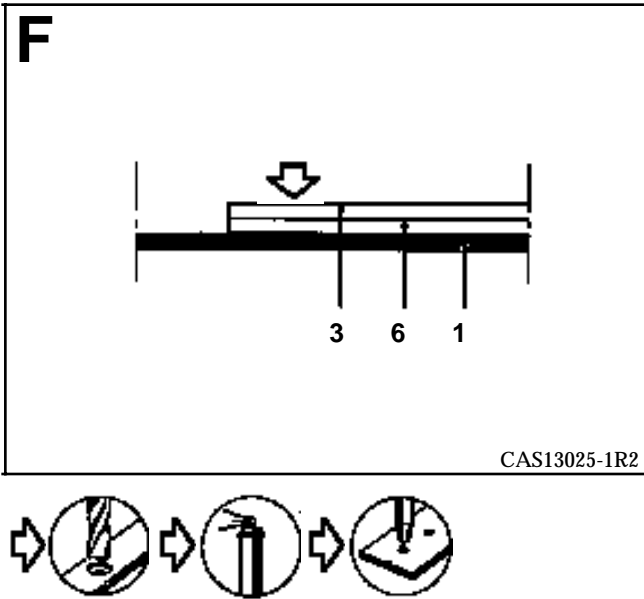
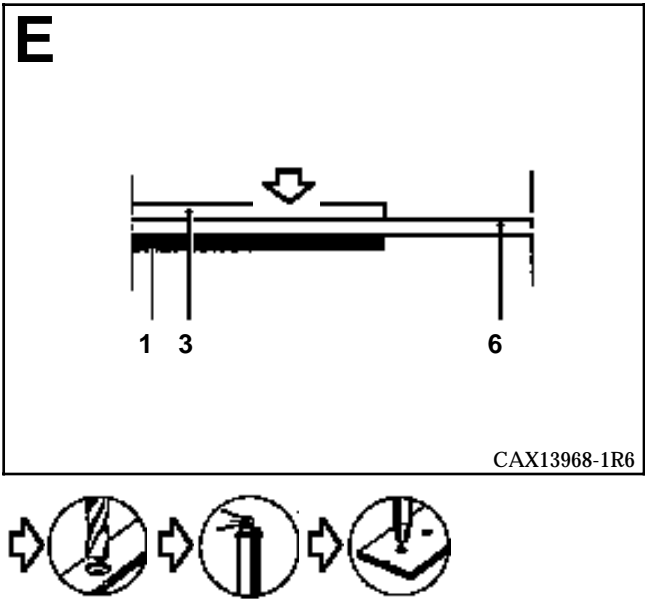
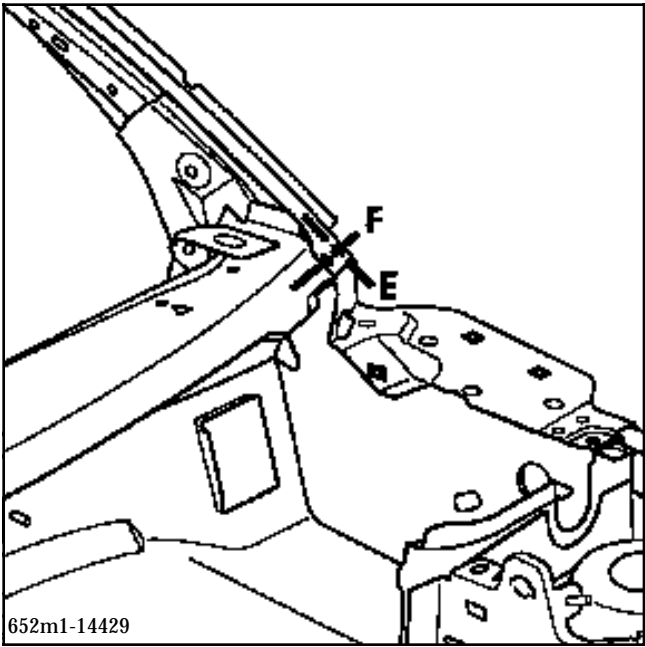
Part assembled with steering column mountings and dashboard mountings.



PARTS CONCERNED (thickness in mm):

- |   |  |     |
|---|--|-----|
| 1 | Windscreen aperture lower cross member | 1.2 |
| 2 | Steering mounting unit, upper section  | 2   |
| 3 | Front pillar                           |     |
| 4 | Bulkhead                               | 0.7 |
| 5 | Cowl side panel pillar lining          | 1.2 |
| 6 | Bonnet hinge mounting                  | 1.2 |





INTRODUCTION

The replacement of this part is a basic operation for damage to the steering column when the vehicle has been stolen.

In the operation described below there are only descriptions of the joints specific to the part concerned.

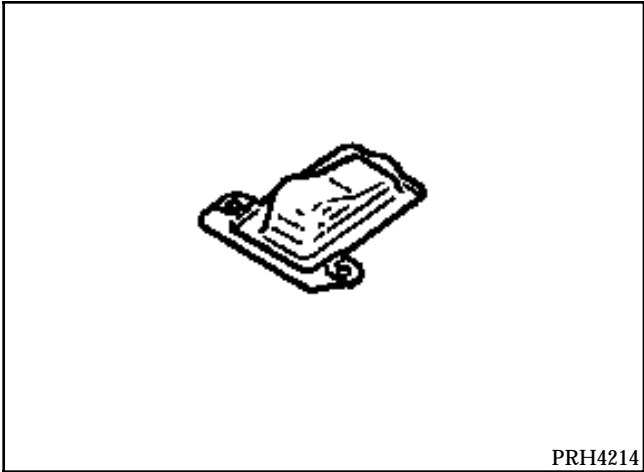
Information concerning other parts will be dealt with in the respective sections (see contents).

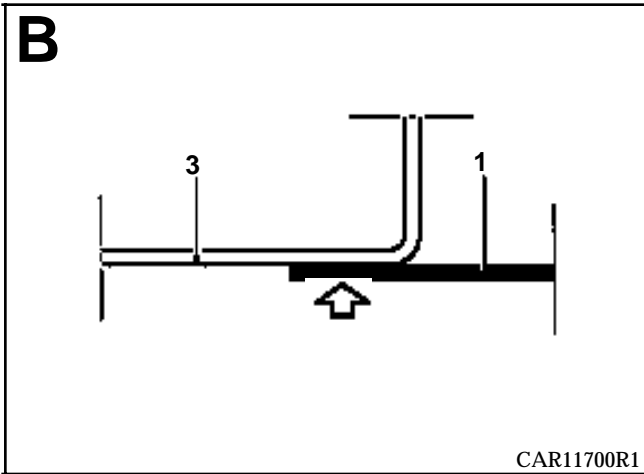
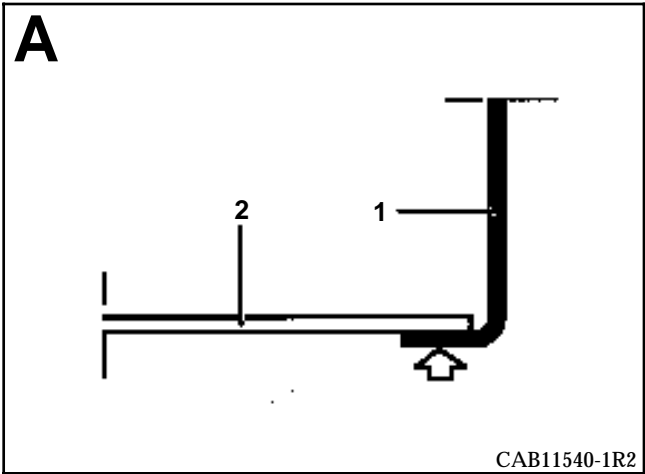
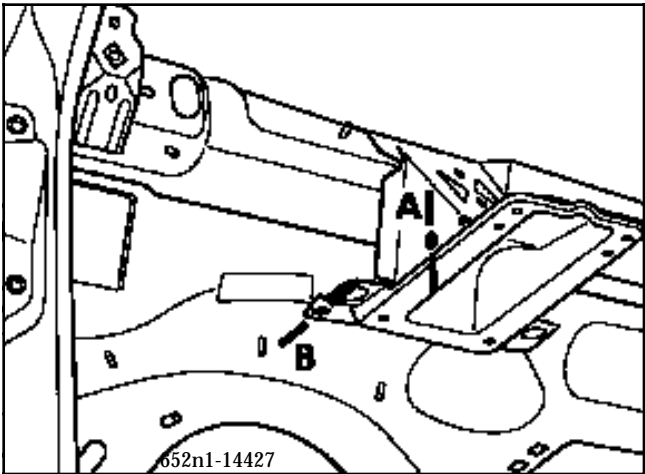
COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

Part assembled with welded nuts.

PARTS CONCERNED (thickness in mm):

1	Steering mounting unit, upper section	2
2	Steering mounting unit, lower section	2
3	Bulkhead	0.7





INTRODUCTION

The replacement of this part is a basic operation for a front side impact.

The front pillar is removed for replacement by cutting the assembled body side, front section, from which the windscreen aperture pillar double seal mounting must be unclipped.

The cowl side panel reinforcement, rear section, will have to be ordered separately.

In the operation described below there are only descriptions of the joints specific to the part concerned.

Information concerning other parts will be dealt with in the respective section (see contents).

COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

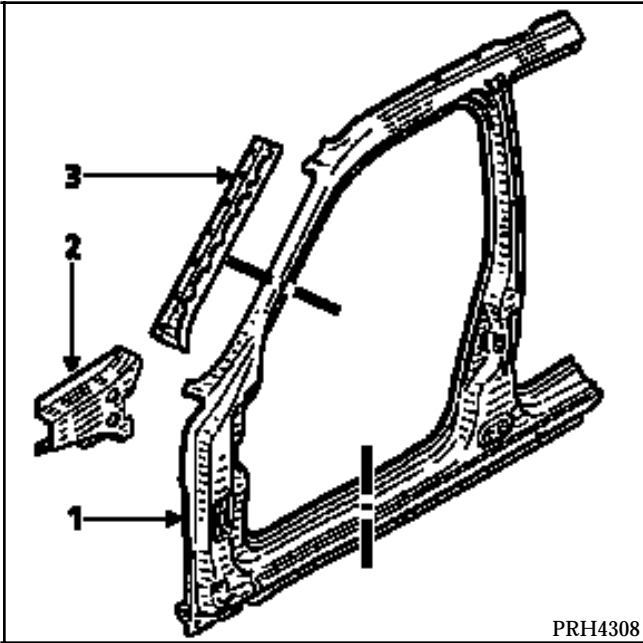
1 - Front pillar

Part assembled with :

- front pillar reinforcement ,
- windscreen aperture pillar double seal mounting,
- welded nuts,
- wing mounting bracket,
- cowl side panel upper reinforcement,
- welded stud,
- door hinge.

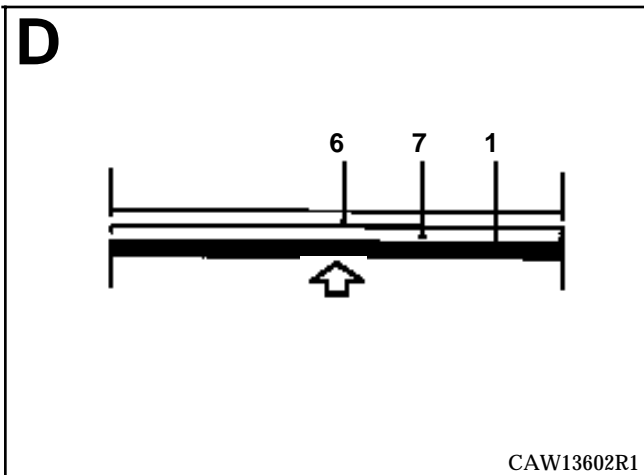
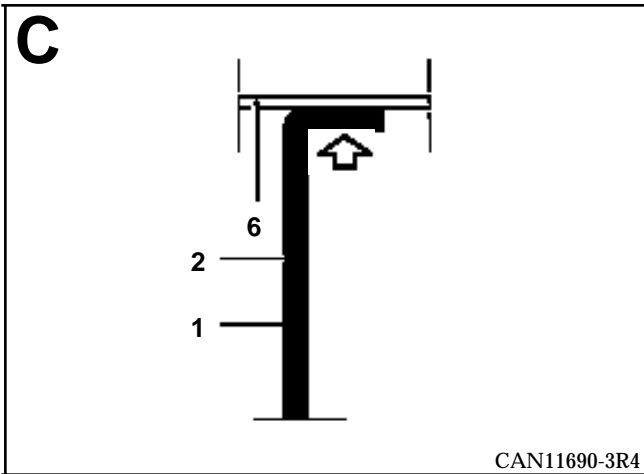
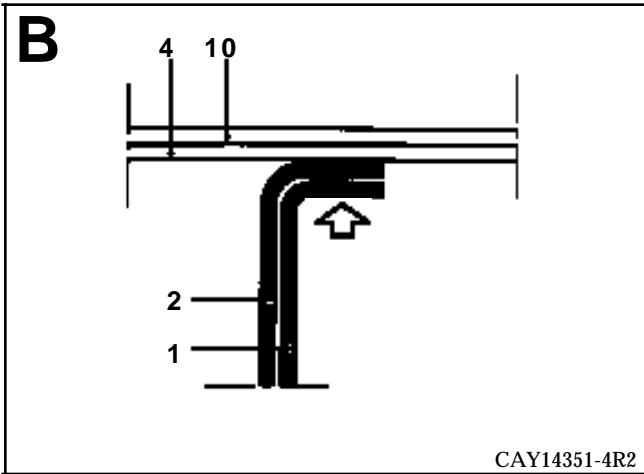
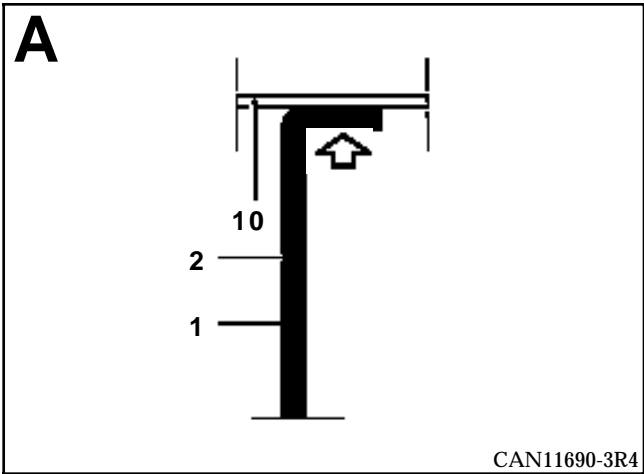
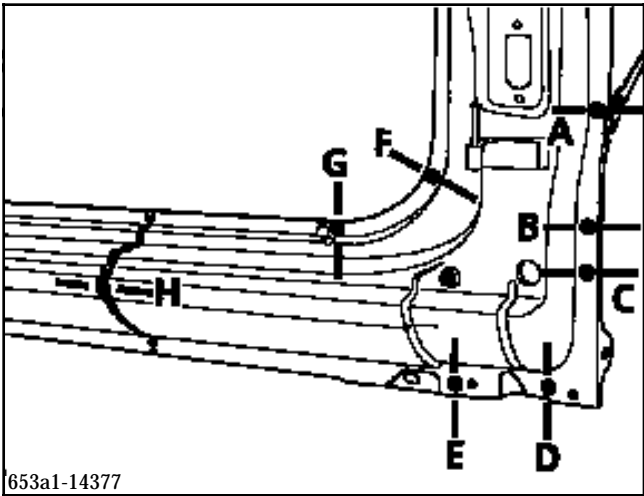
2 - Cowl side panel reinforcement, rear section  
Part only

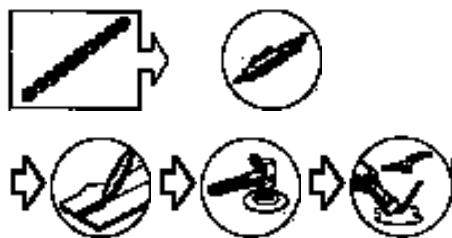
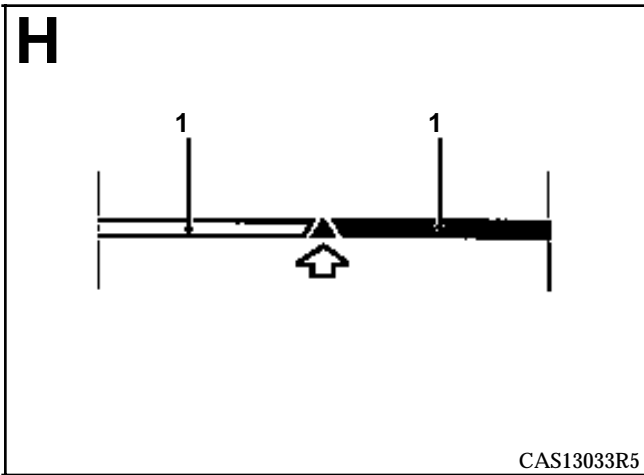
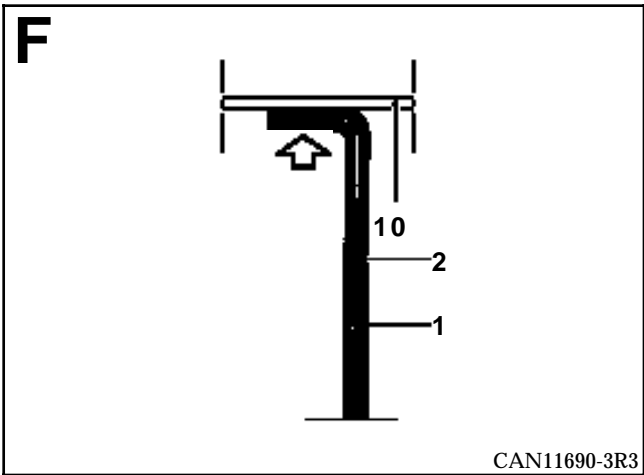
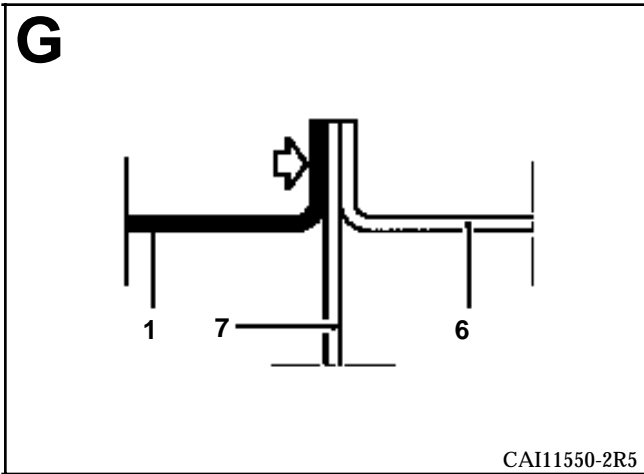
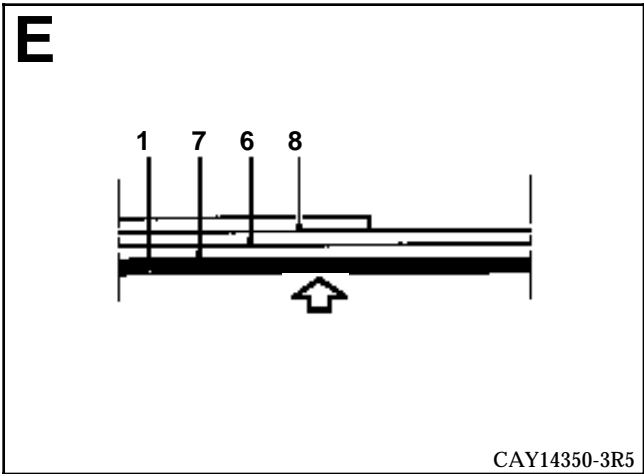
3 - Windscreen aperture pillar double seal joint mounting  
Part only



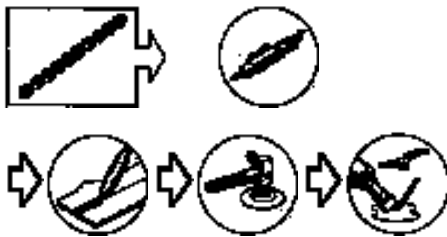
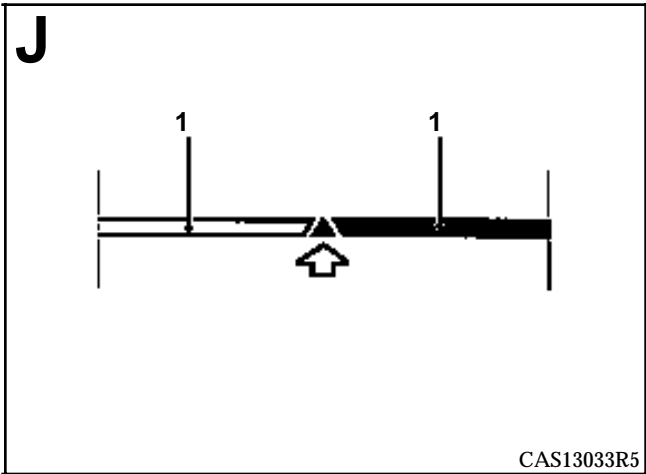
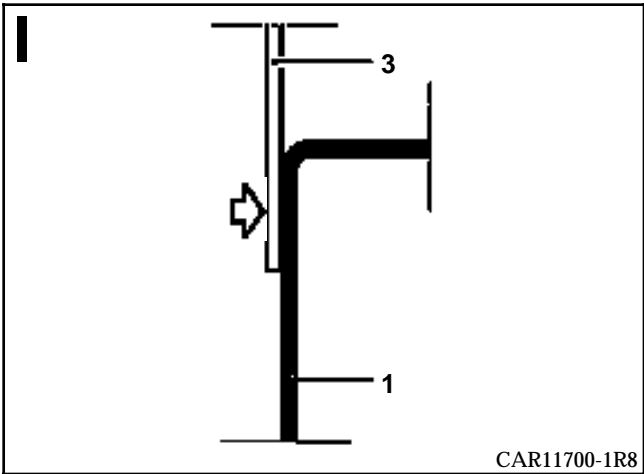
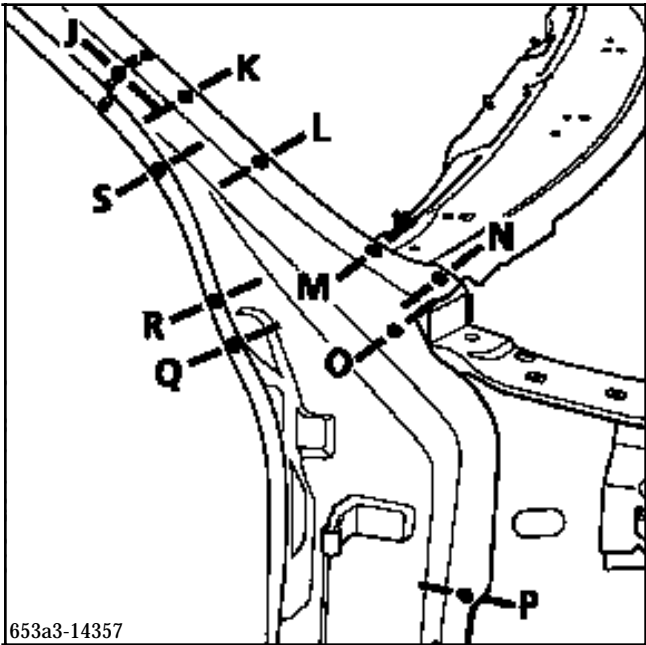
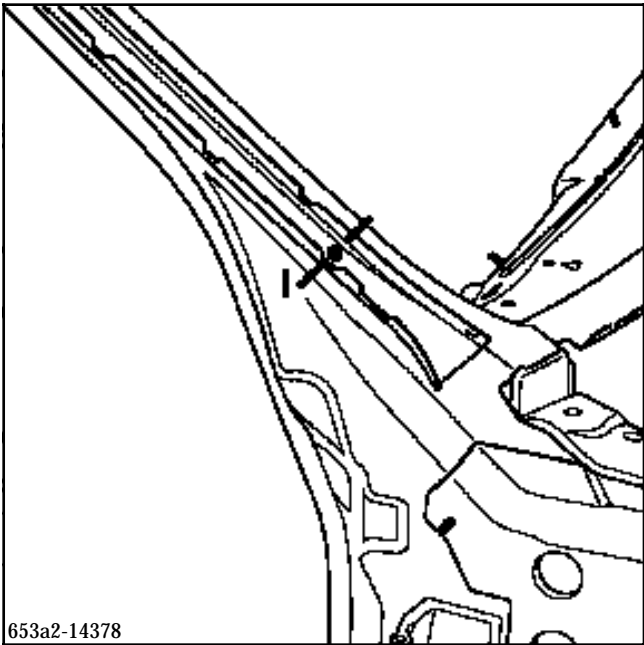
PARTS CONCERNED (thickness in mm) :

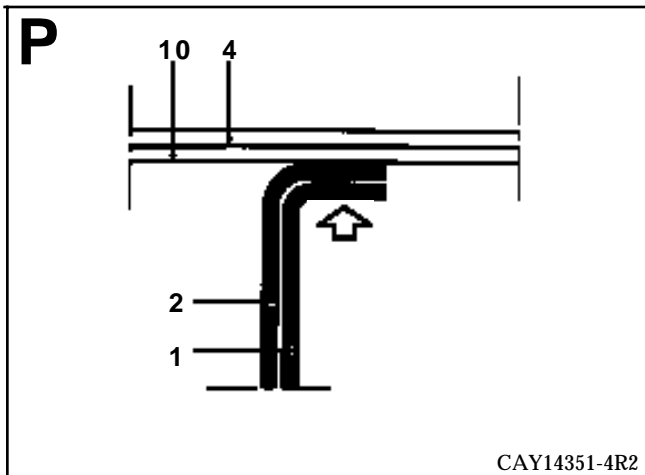
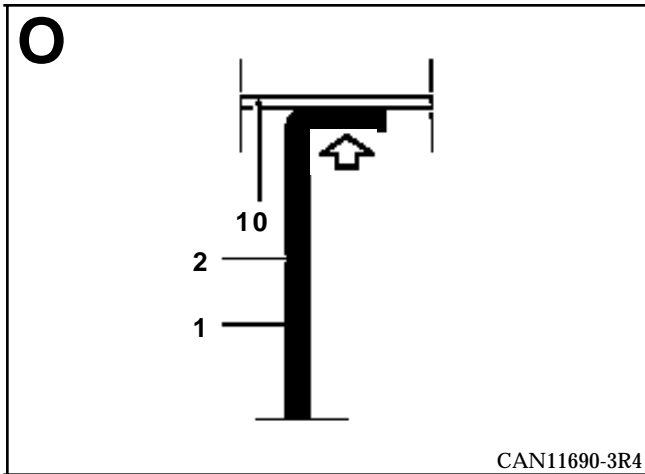
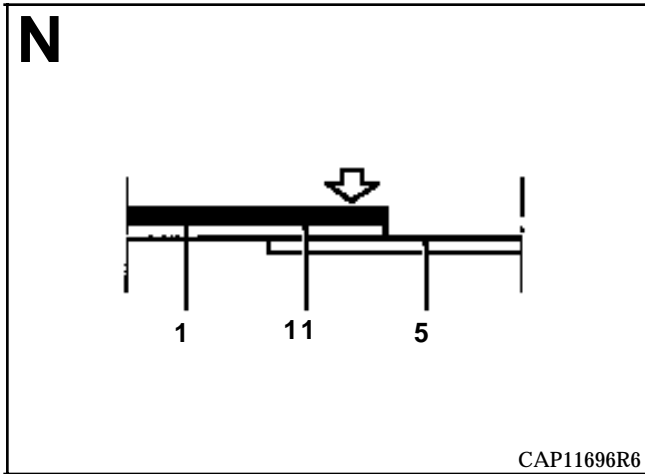
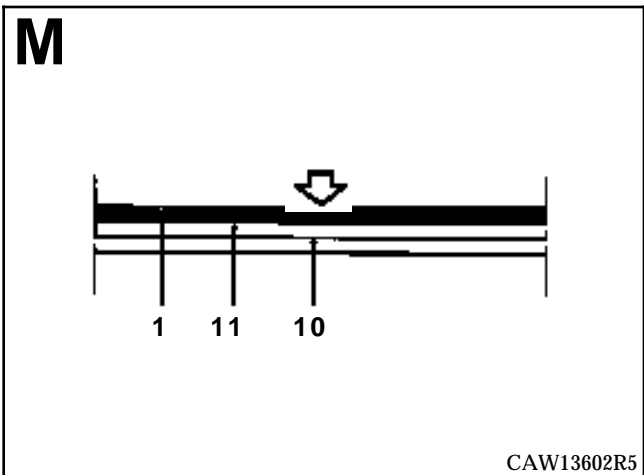
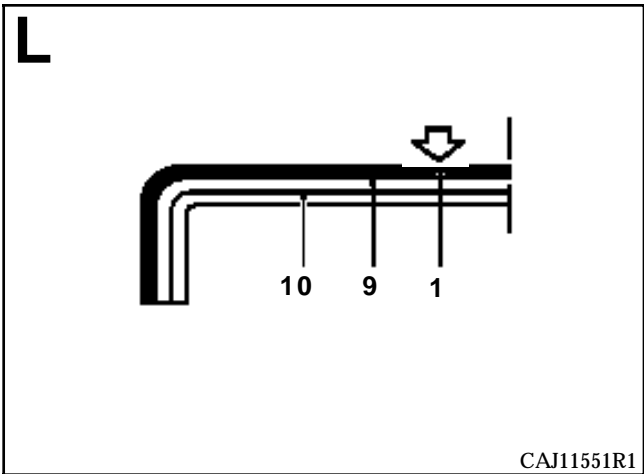
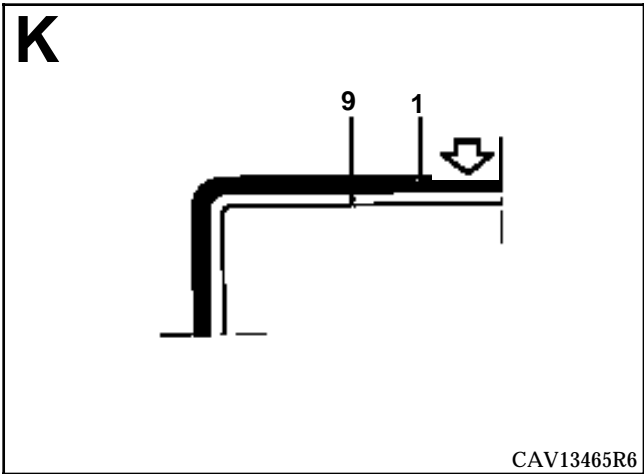
1	Front pillar	1.2
2	Front pillar reinforcement	1
3	Windscreen aperture pillar double seal mounting	0.7
4	Bulkhead	0.7
5	Windscreen aperture lower cross member	1.2
6	Sill panel closure panel	1
7	Sill panel reinforcement	1
8	Front side cross member	1
9	Windscreen aperture pillar lining	1.2
10	Cowl side panel pillar lining	1.2
11	Bonnet hinge mounting	1.2

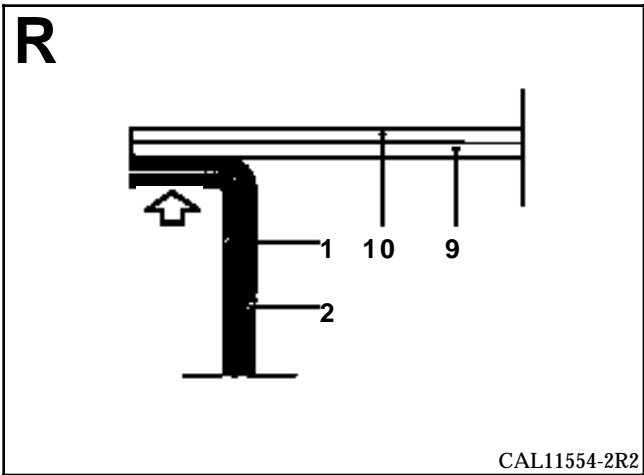
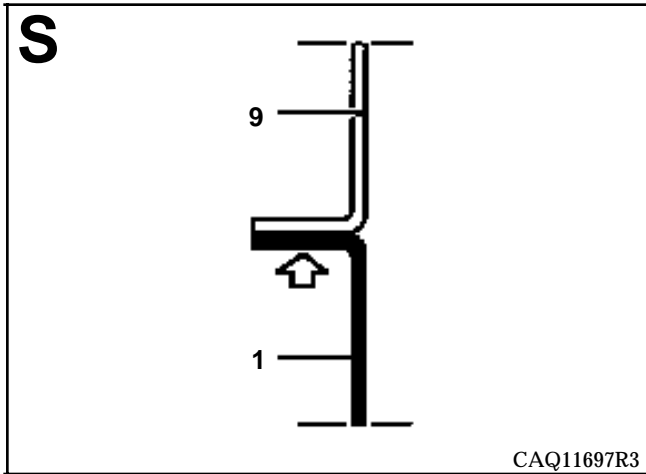
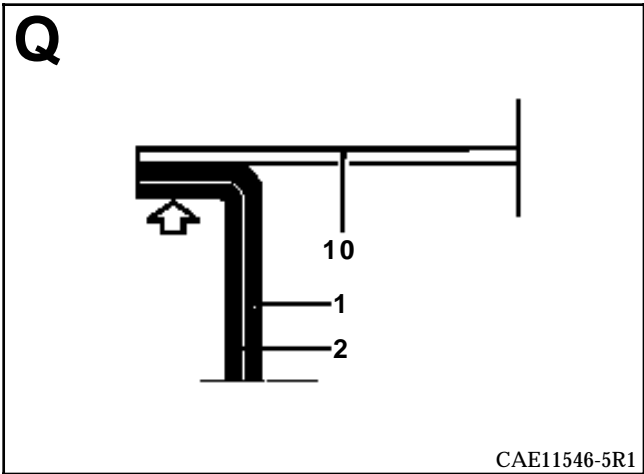












INTRODUCTION

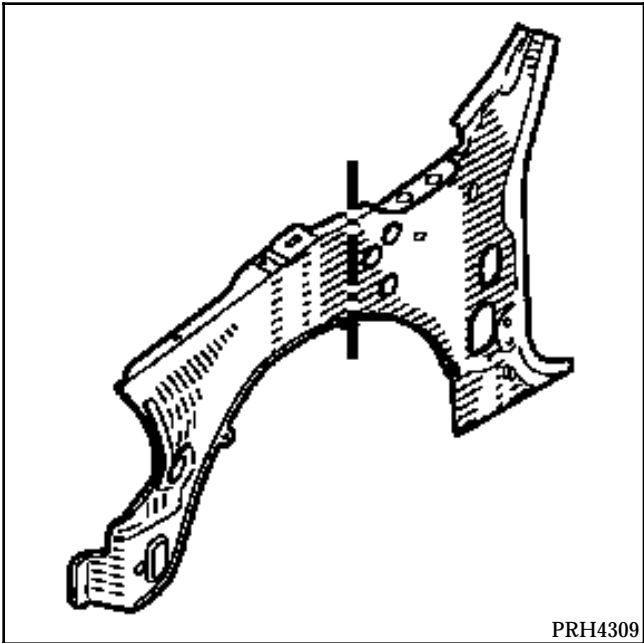
The replacement of this part is a basic operation for a front side impact.

In the operation described below there are only descriptions of the joints specific to the part concerned.

Information concerning other parts will be dealt with in the respective section (see contents).

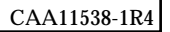
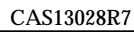
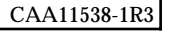
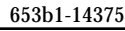
COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

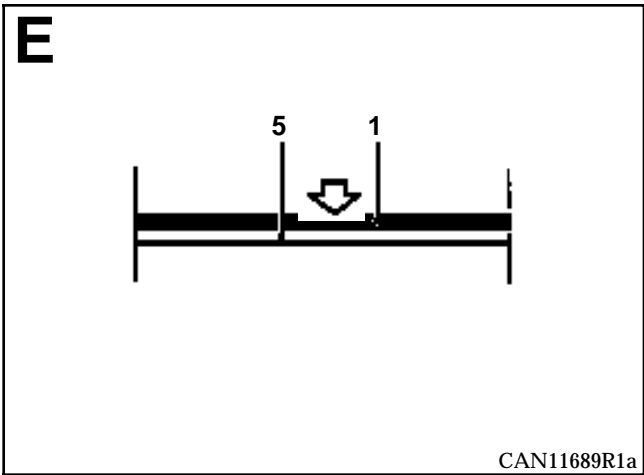
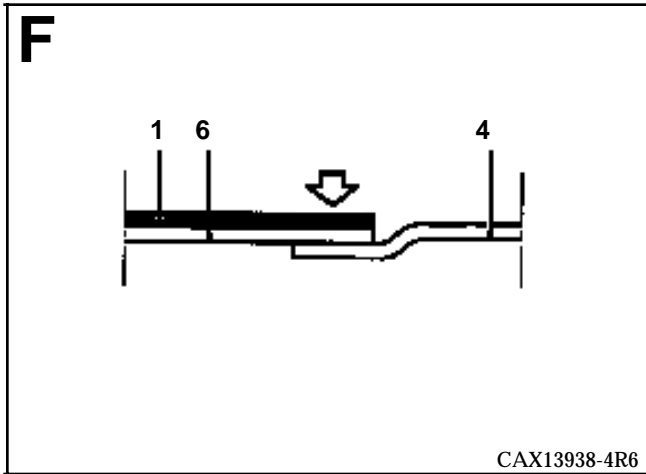
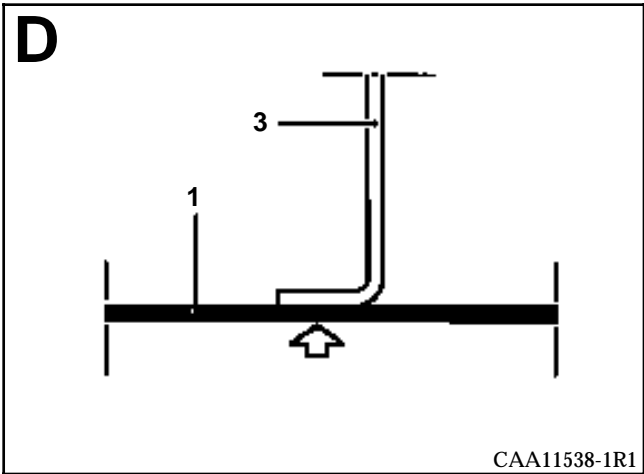
Part only

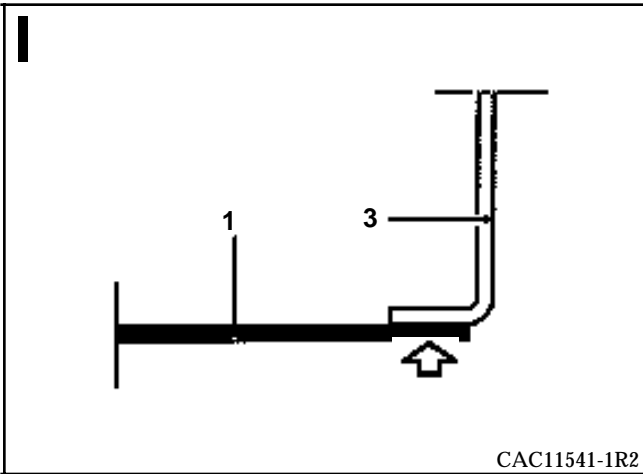
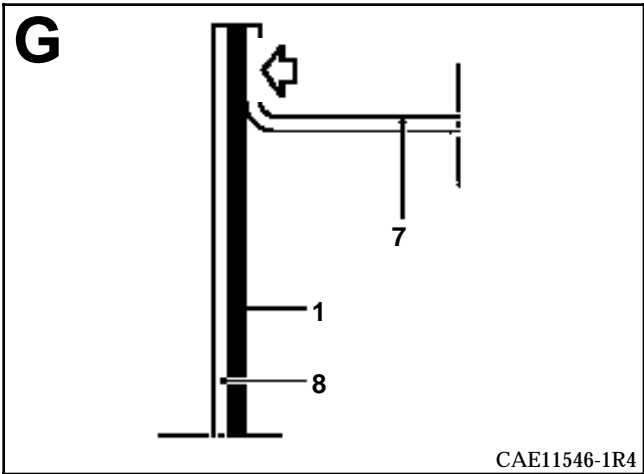
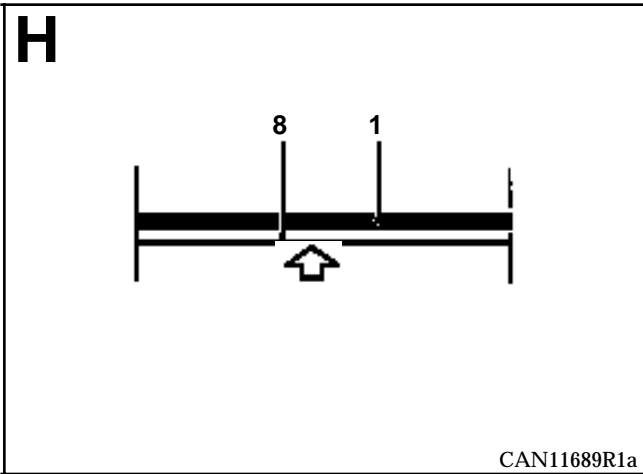
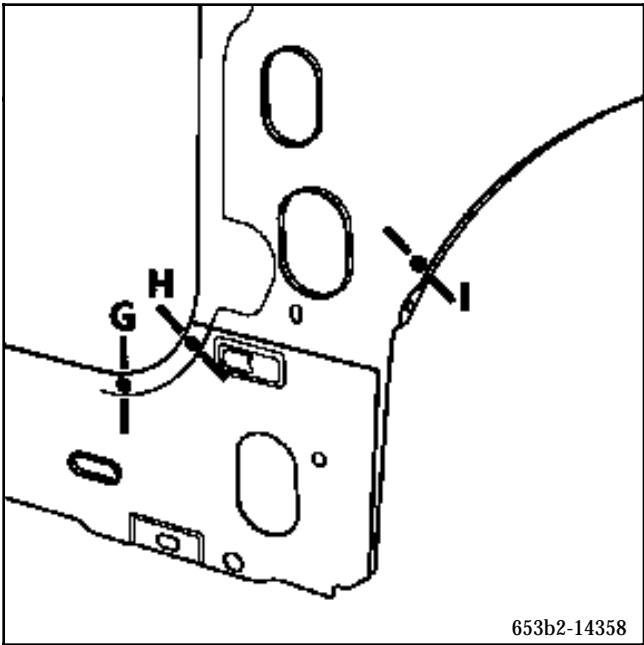


PARTS CONCERNED (thickness in mm) :

1	Cowl side panel pillar lining	1.2
2	Side plenum chamber	1
3	Bulkhead	0.7
4	Windscreen aperture lower cross member	1.2
5	Windscreen aperture pillar lining	1.2
6	Bonnet hinge mounting	1.2
7	Sill panel closure panel	1
8	Sill panel reinforcement	1







INTRODUCTION

The replacement of this part is a complementary operation to the replacement of the front pillar for a front side impact.

The Parts Department part is identical for the two versions, BUT, for version B it must be cut as shown below.

In the operation described below there are only descriptions of the joints specific to the part concerned.

Information concerning other parts will be dealt with in the respective section (see contents).

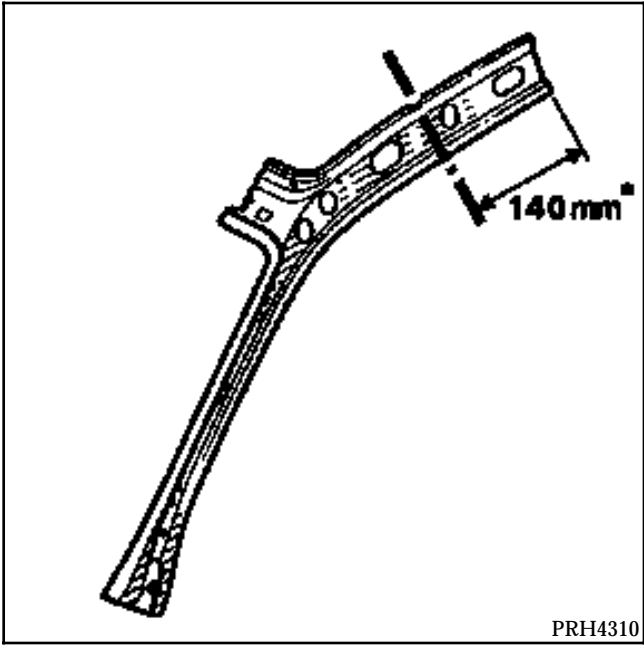
COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

Part assembled with :

- windscreen aperture pillar lining,
- windscreen aperture pillar reinforcement.

PARTS CONCERNED (thickness in mm) :

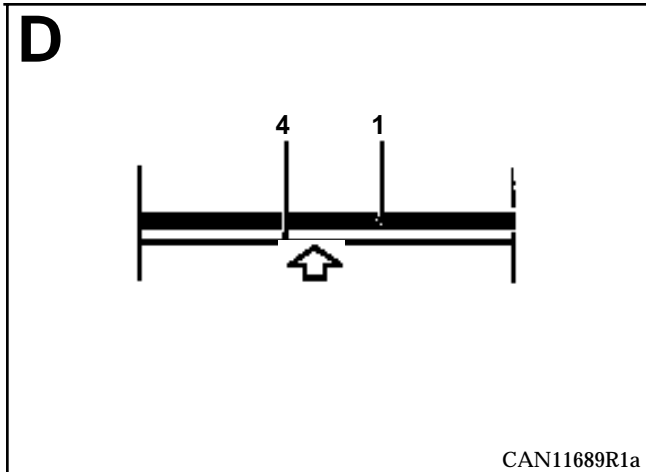
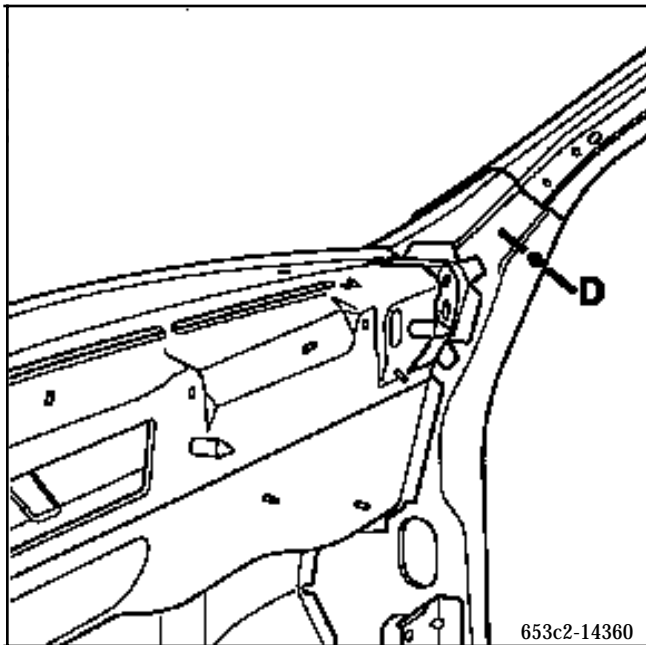
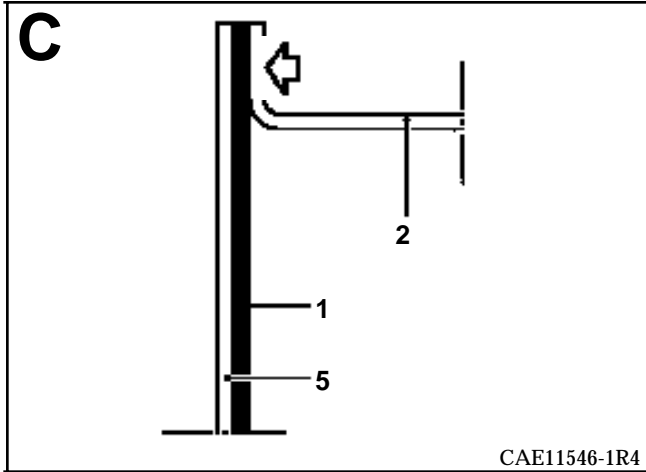
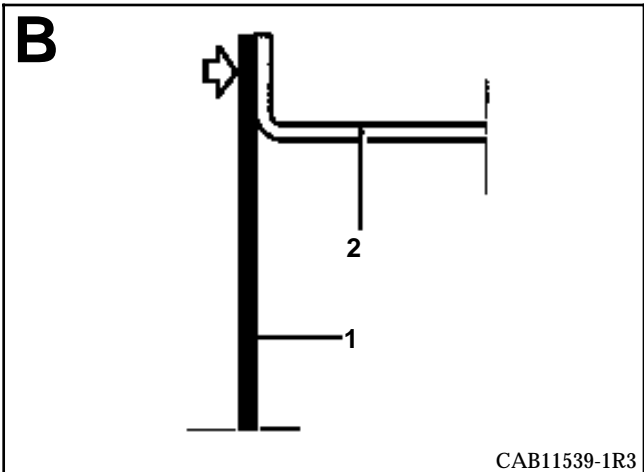
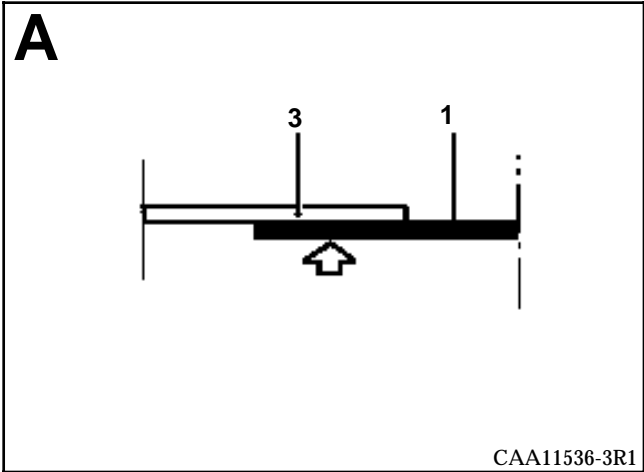
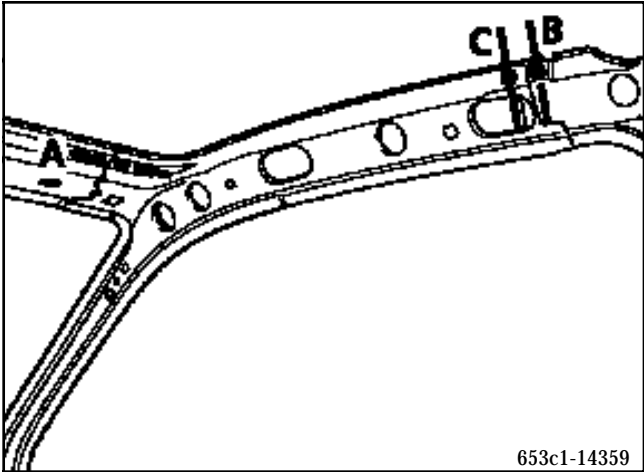
1	Windscreen aperture pillar lining	1.2
2	Body side lining	0.7
3	Roof front cross member	1.2
4	Cowl side panel pillar lining	1.2
5	Centre pillar reinforcement	1



\* Cut for version B (140 mm)







INTRODUCTION

The replacement of this part is a basic operation for a side impact.

The centre pillar is removed for replacement by cutting the assembled front section of the body side.

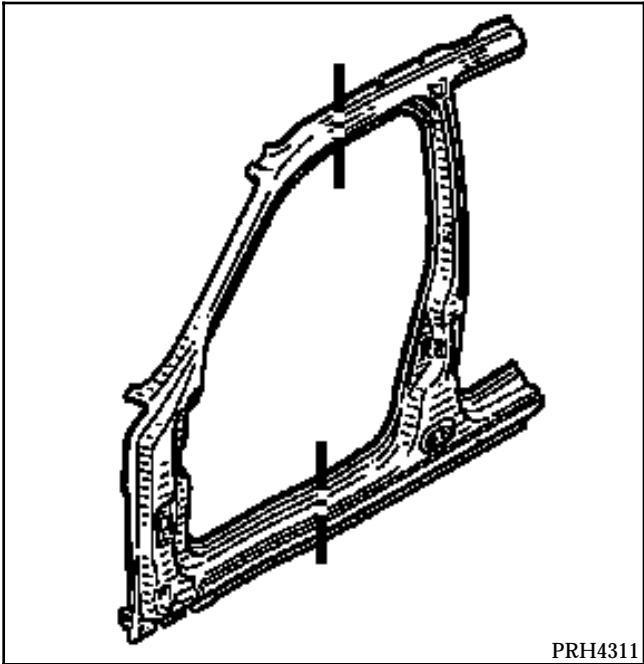
In the operation described below there are only descriptions of the joints specific to the part concerned.

Information concerning other parts will be dealt with in the respective section (see contents).

COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

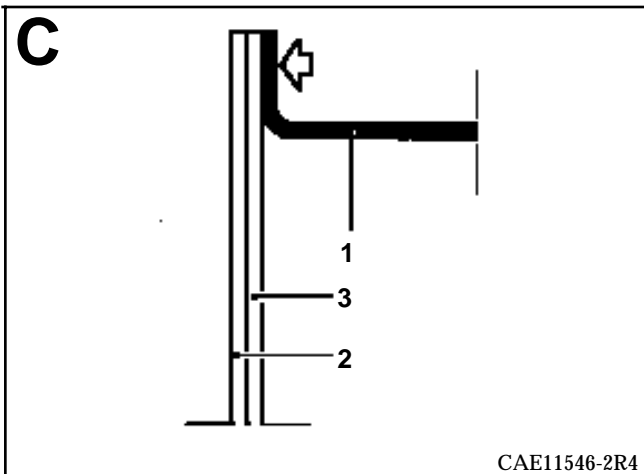
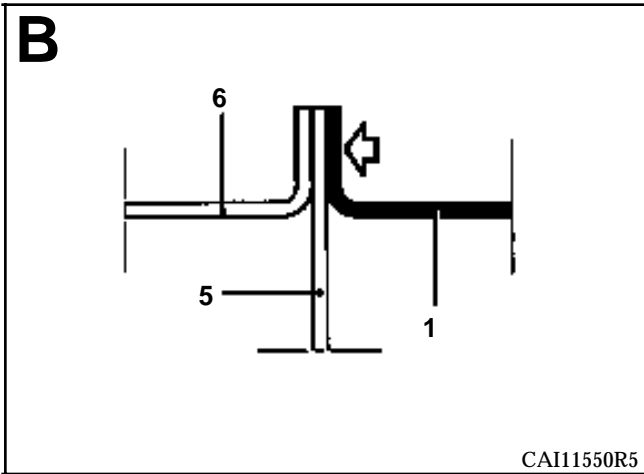
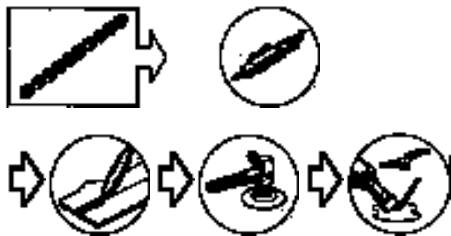
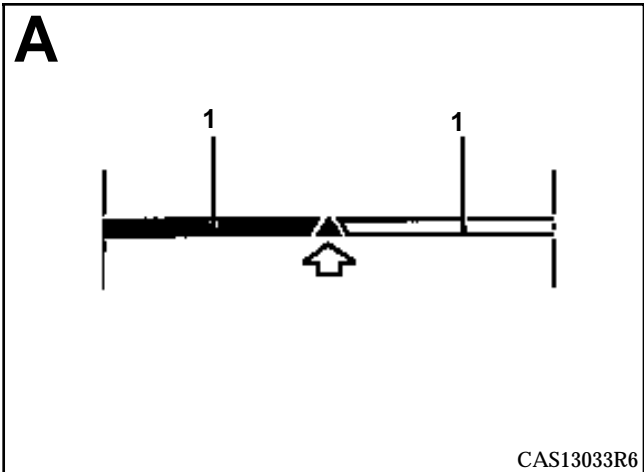
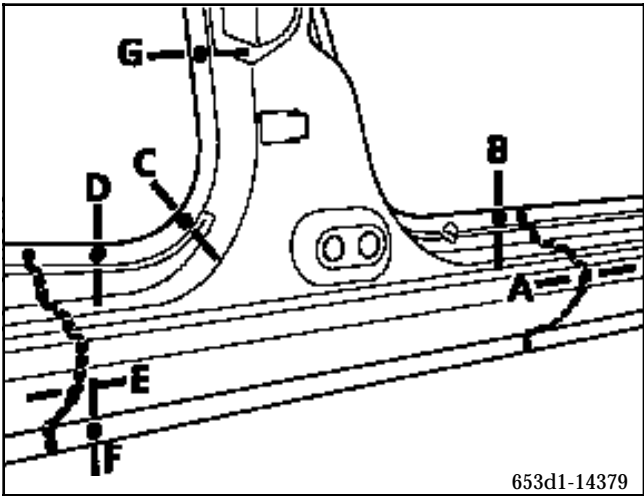
Three parts assembled with :

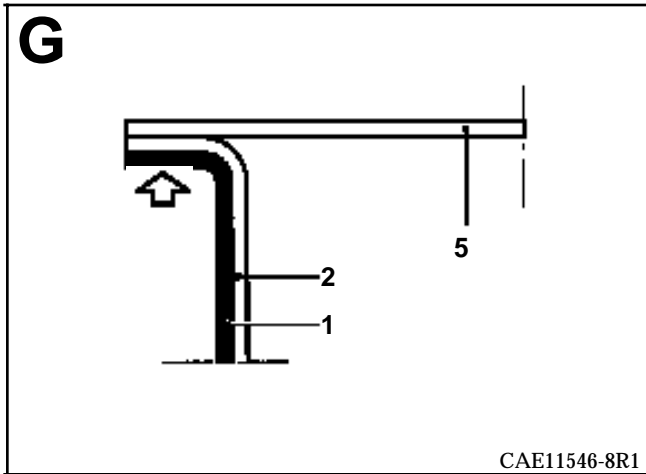
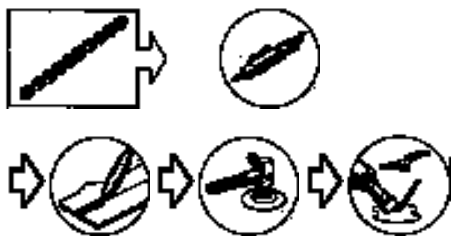
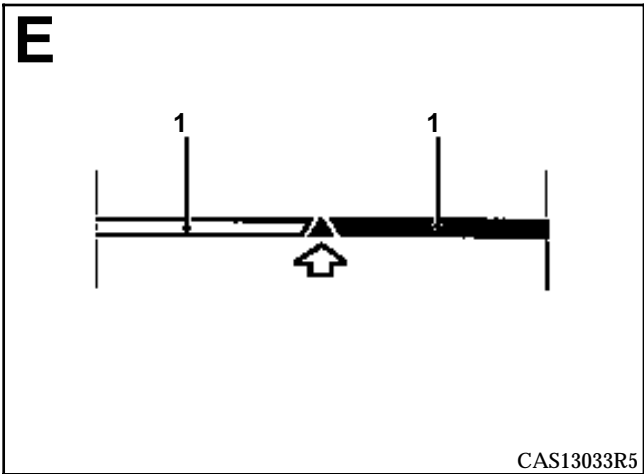
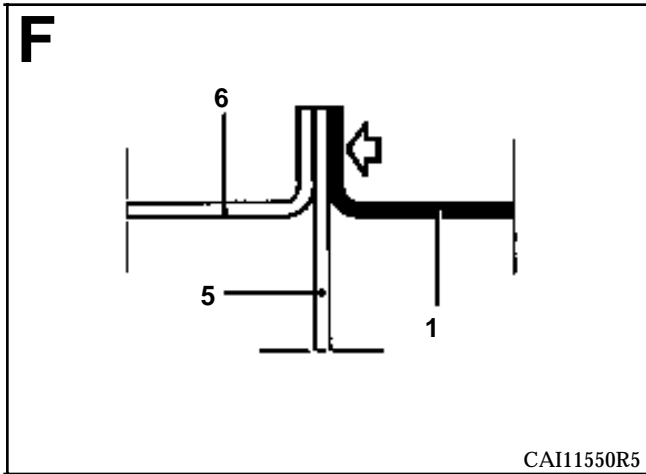
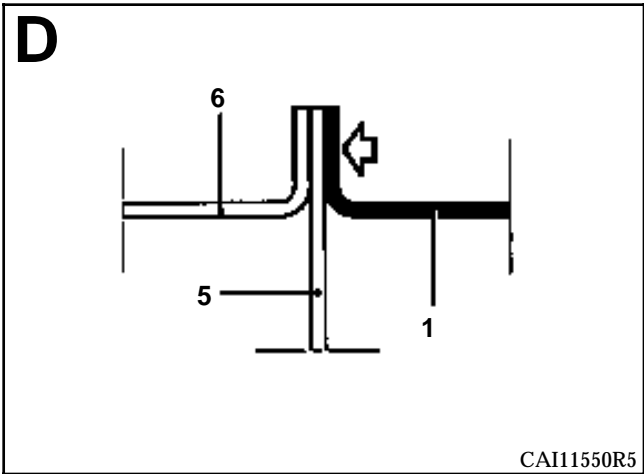
- front pillar reinforcement ,
- windscreen aperture double seal mounting,
- welded nuts,
- wing mounting bracket,
- cowl side panel upper reinforcement,
- welded stud,
- door hinge.

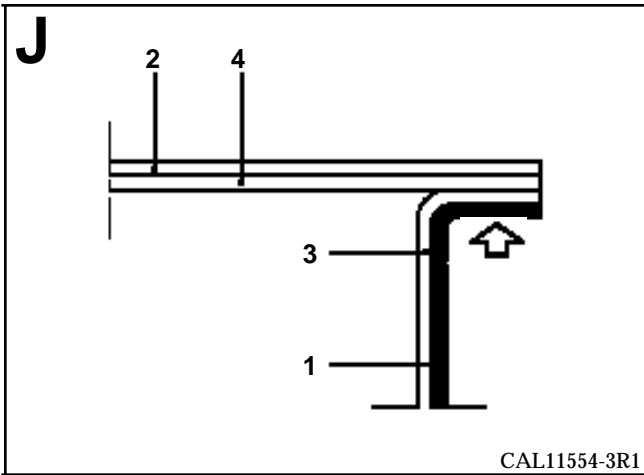
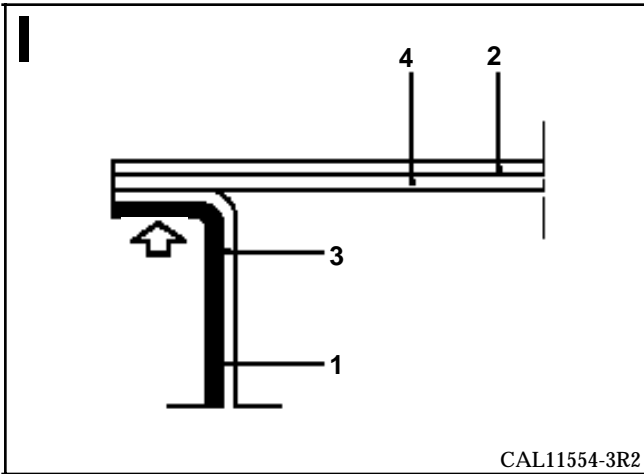
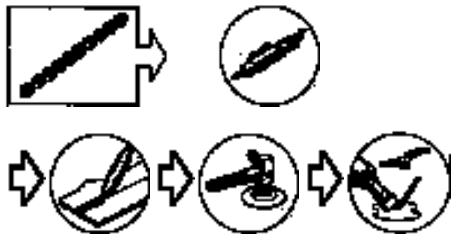
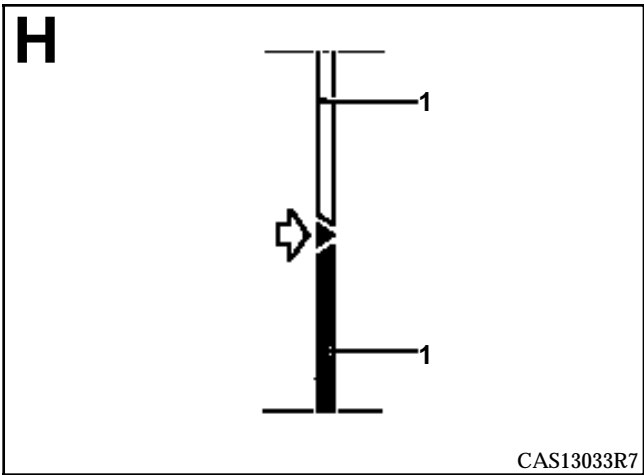
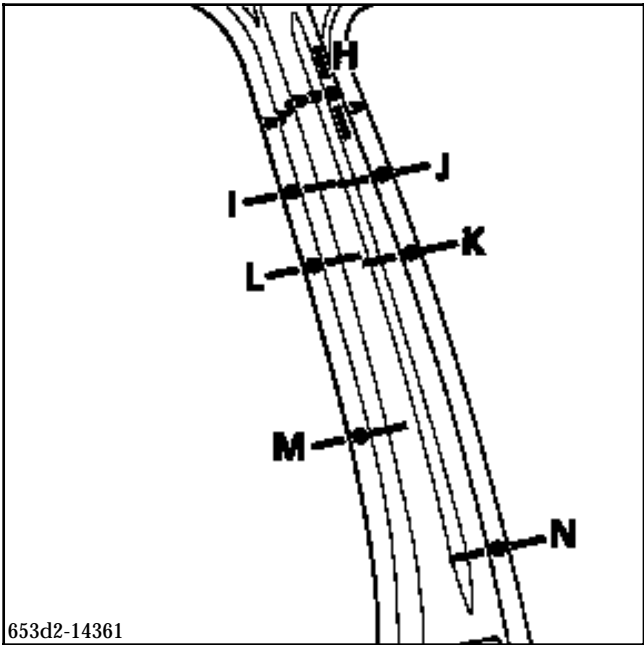


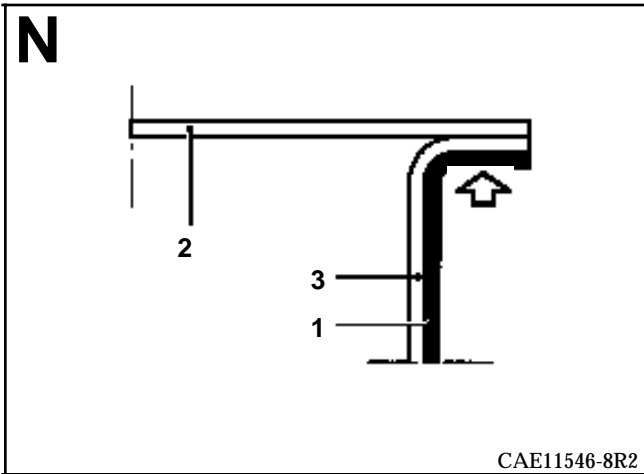
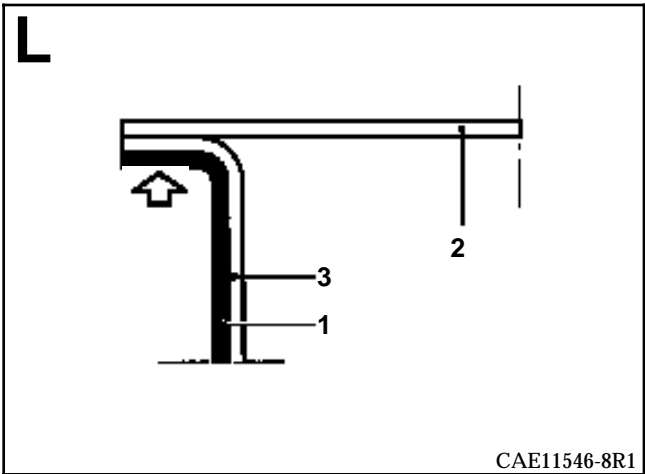
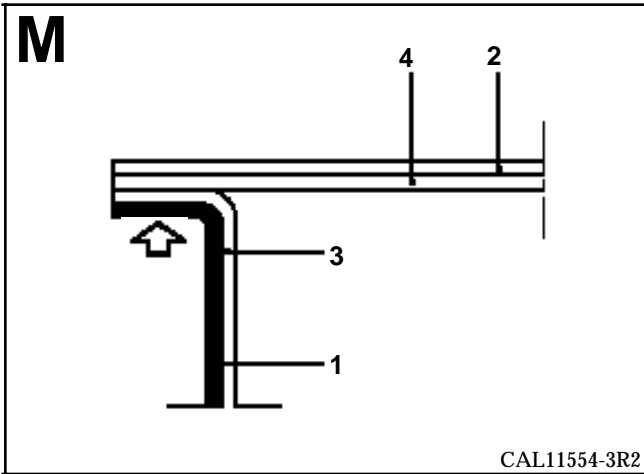
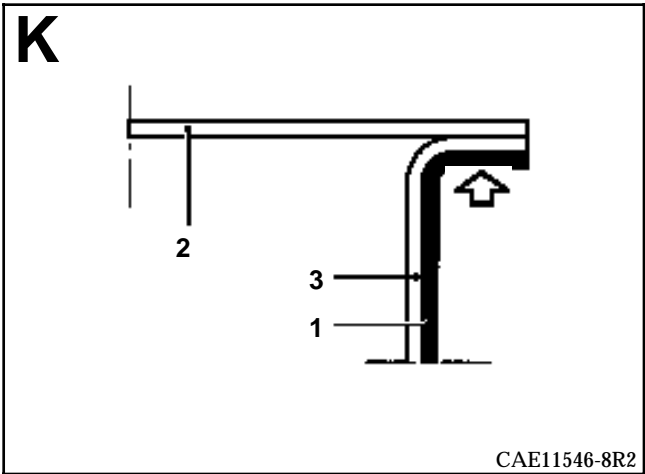
PARTS CONCERNED (thickness in mm) :

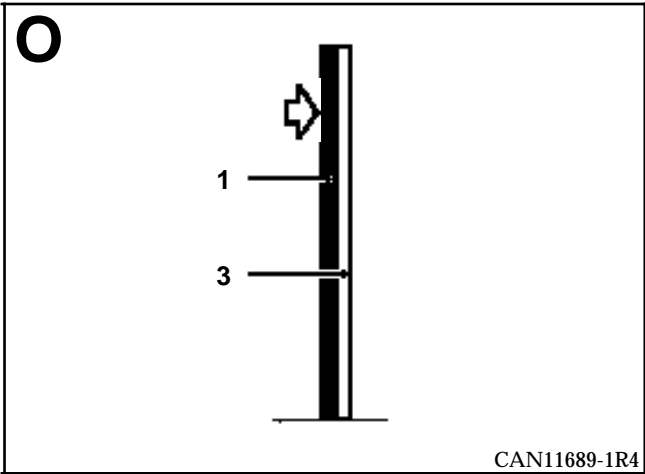
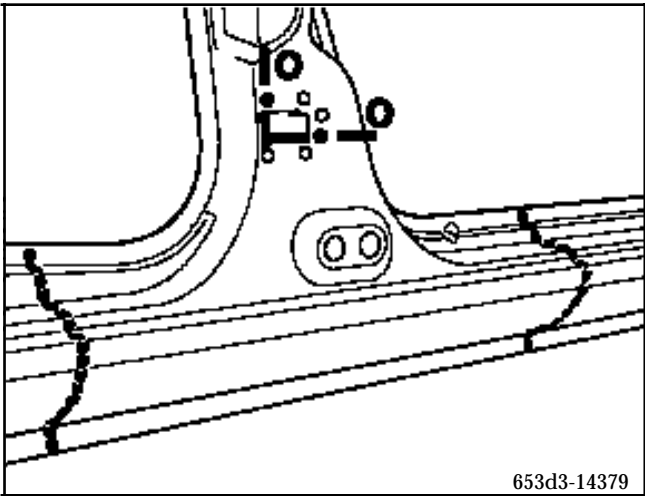
1	Centre pillar	1.2
2	Centre pillar closure panel	0.7
3	Centre pillar reinforcement	1
4	Seat belt mounting centre pillar upper reinforcement	1.2
5	Sill panel reinforcement	1
6	Sill panel closure panel	1











INTRODUCTION

The replacement of this part is a complementary operation to the centre pillar for version B, the rear wing panel for version C for a side impact.

In the operation described below there are only descriptions of the joints specific to the part concerned.

Information concerning other parts will be dealt with in the respective section (see contents).

COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

Part assembled with :

VERSION B (1)

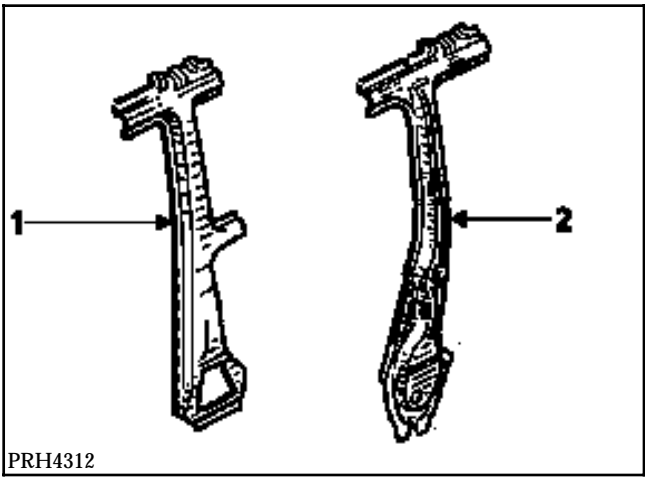
- lock striker plate reinforcement,
- seat belt mounting upper reinforcement,
- nuts to be welded.

VERSION C (2)

- lock striker plate reinforcement,
- seat belt mounting upper reinforcement,
- nuts to be welded.

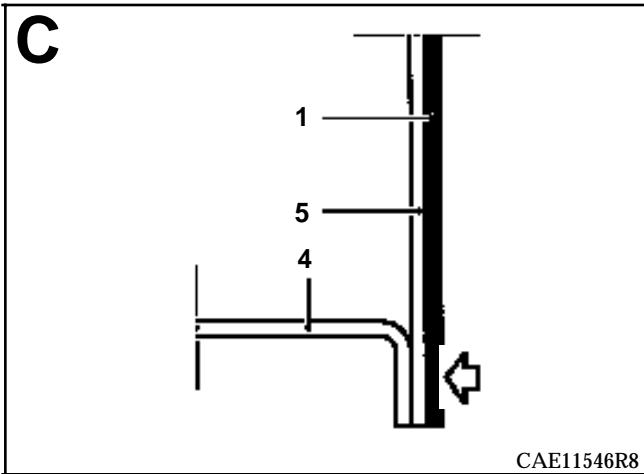
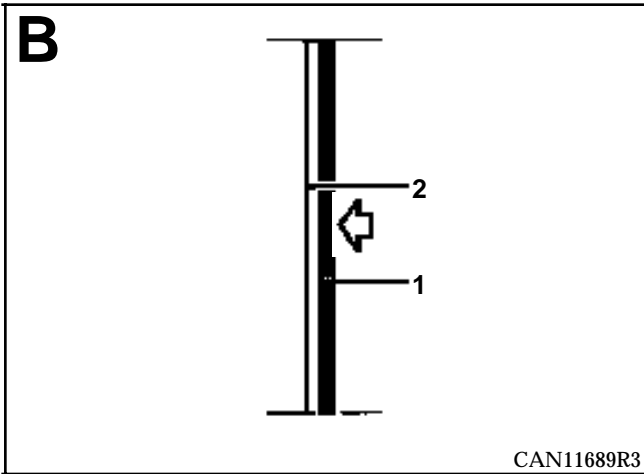
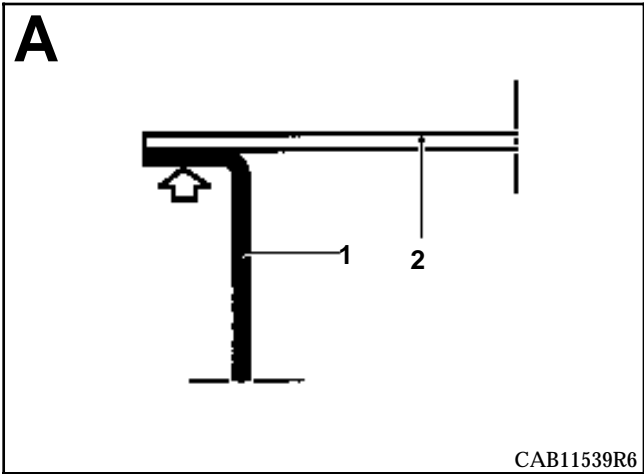
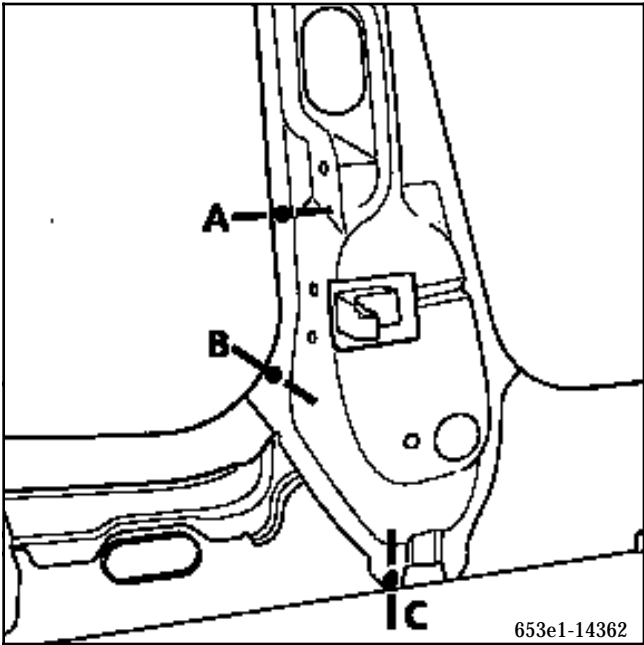
PARTS CONCERNED (thickness in mm) :

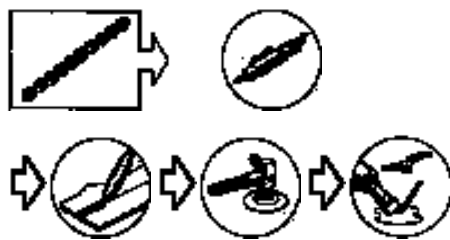
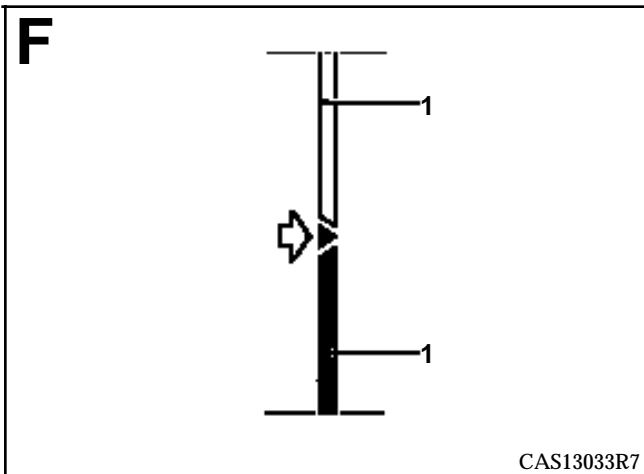
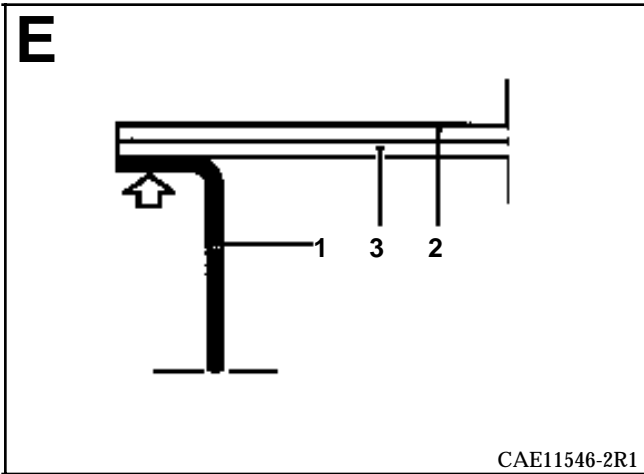
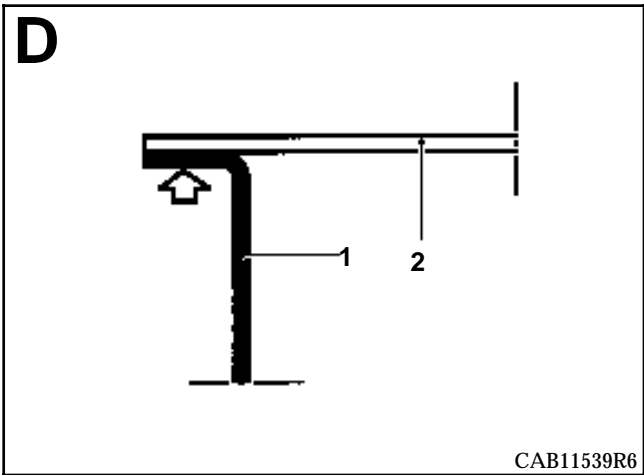
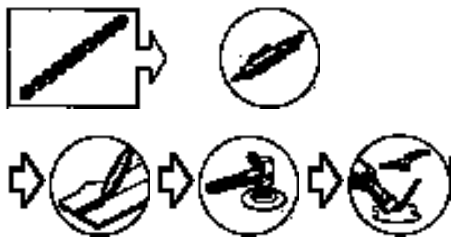
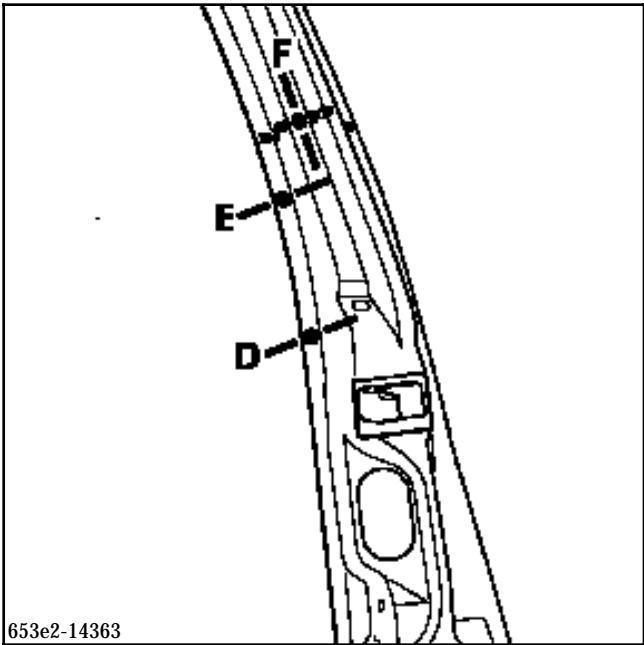
1	Centre pillar lining	1
2	Centre pillar closure panel	0.7
3	Seat belt mounting centre pillar upper reinforcement	1.2
4	Sill panel closure panel	1
5	Sill panel reinforcement	1



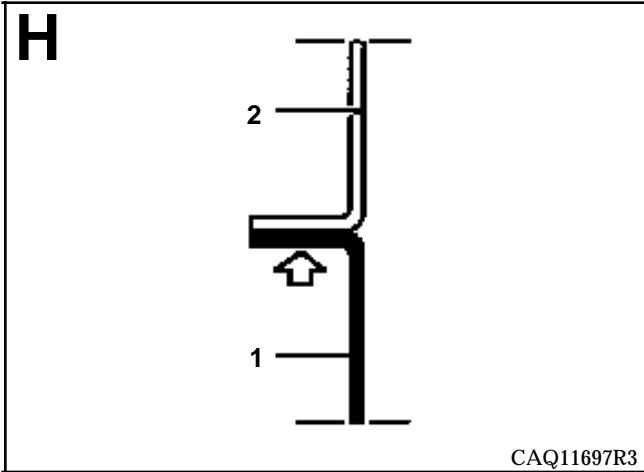
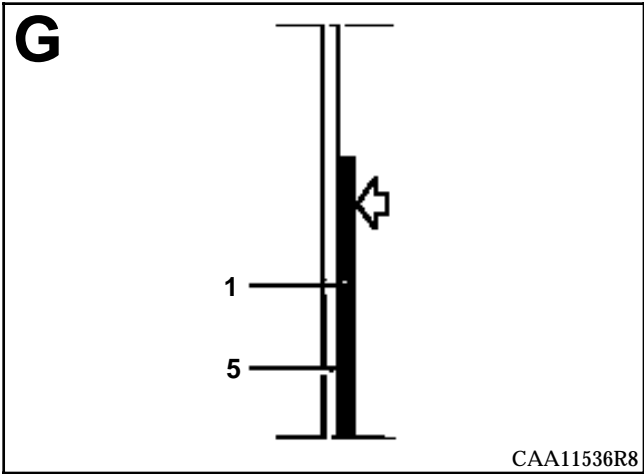
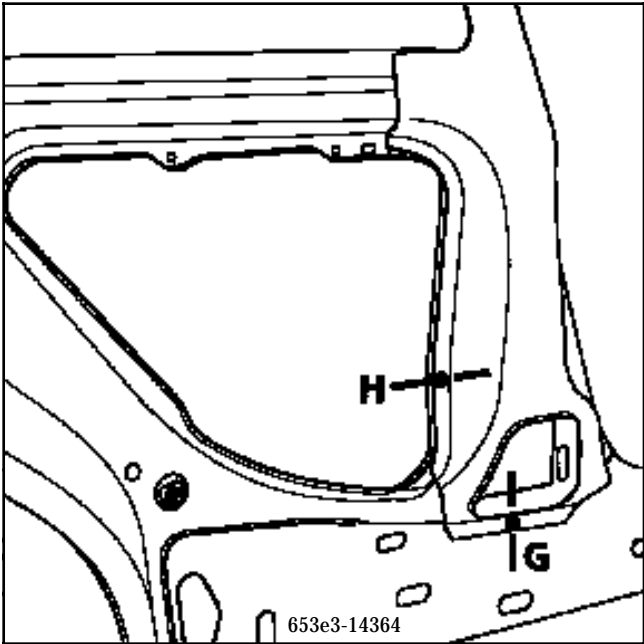


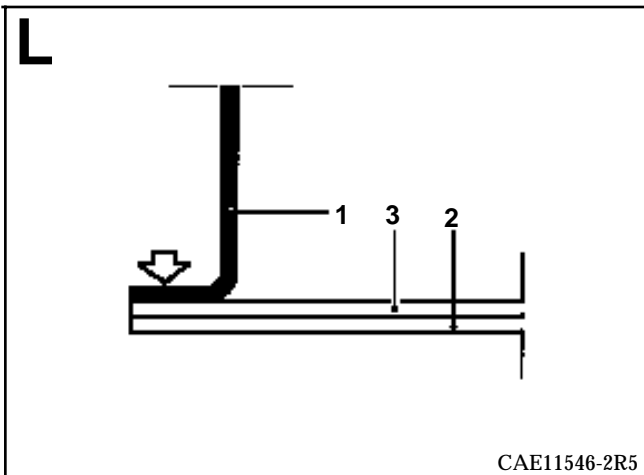
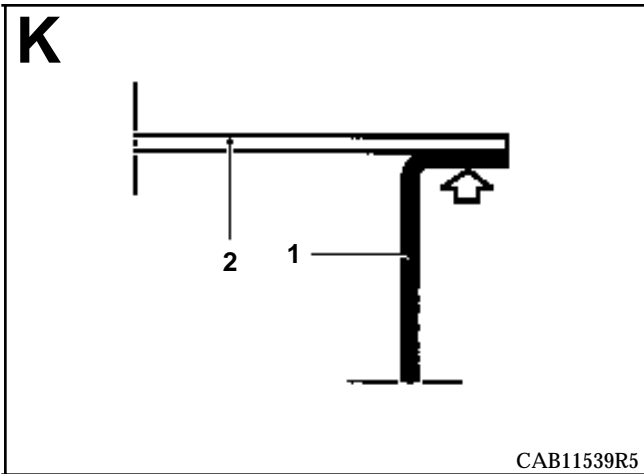
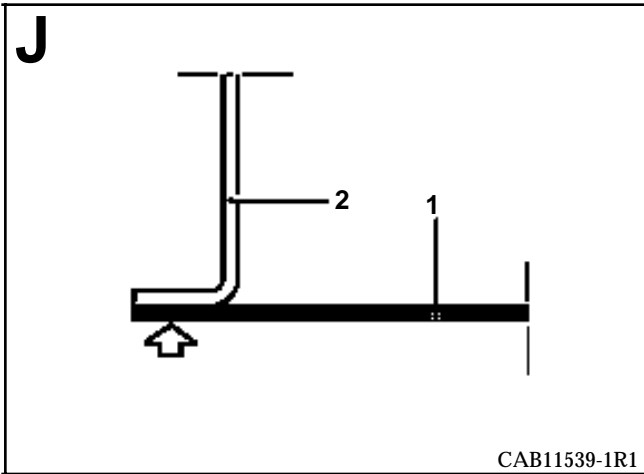
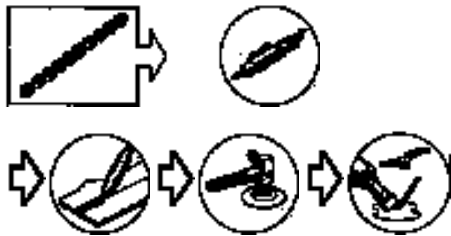
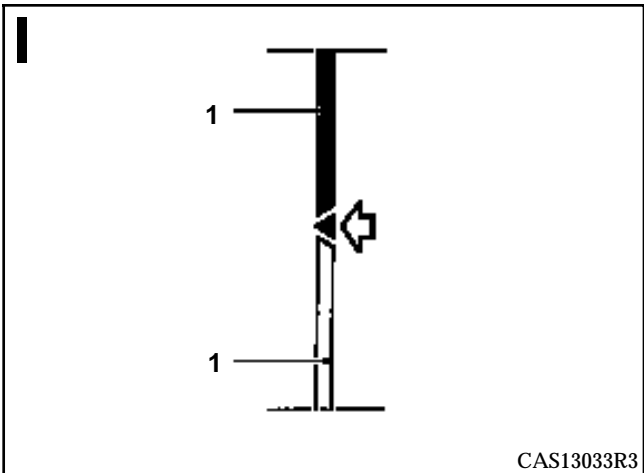
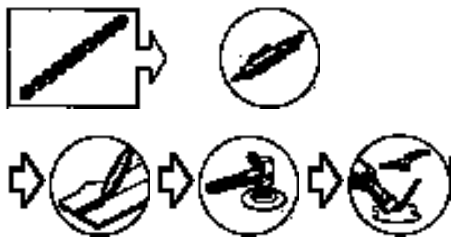
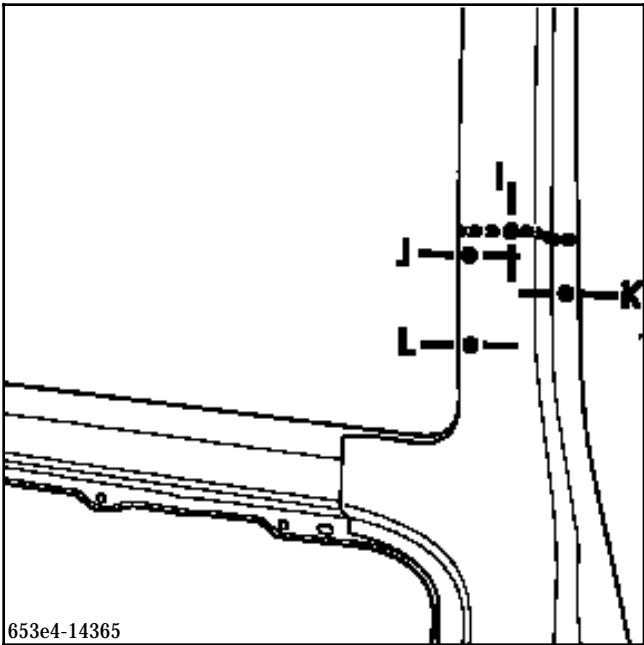
VERSION B





VERSION C





INTRODUCTION

The replacement of this part is a complementary operation to the centre pillar for version B, the rear wing panel for C, for a side impact.

In the operation described below there are only descriptions of the joints specific to the part concerned.

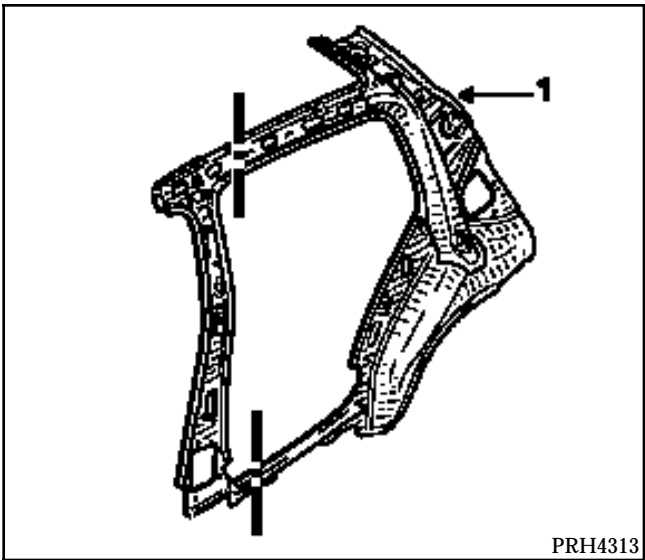
Information concerning other parts will be dealt with in the respective section (see contents).

COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

Part assembled with :

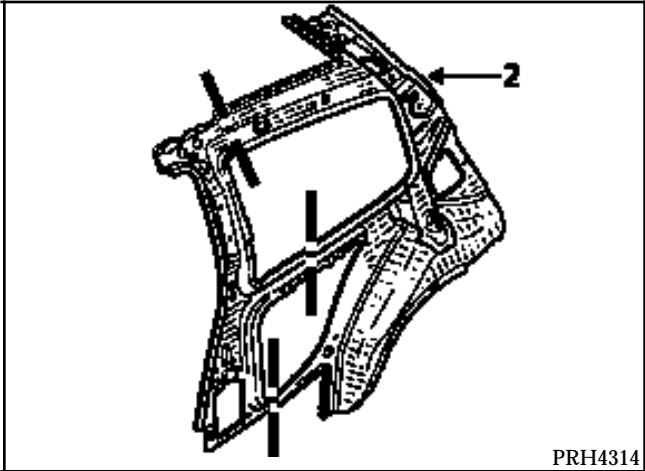
VERSION B (1)

- quarter panel lower reinforcement,
- quarter panel upper reinforcement,
- inflating insert,
- quarter panel lining,
- seat belt mounting nuts.



VERSION C (2)

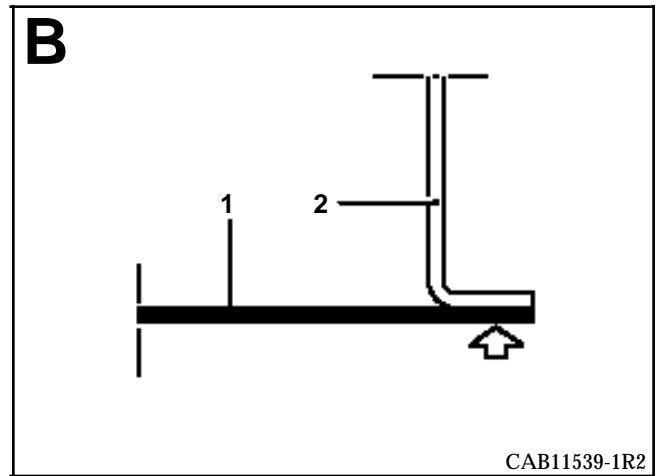
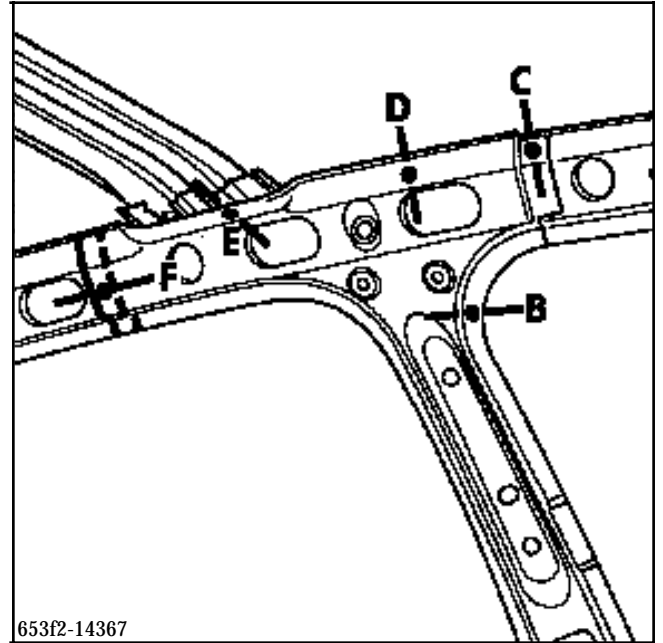
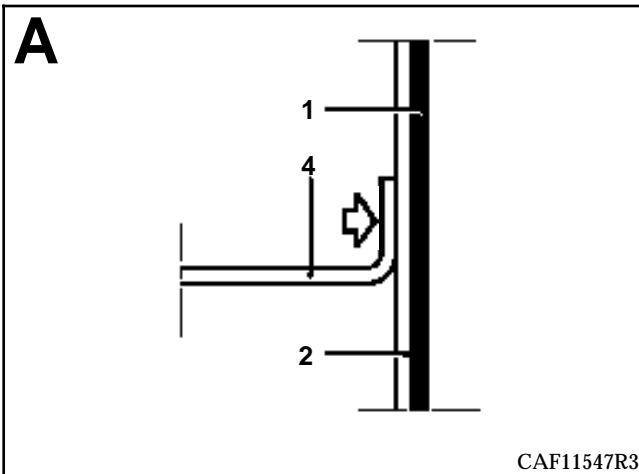
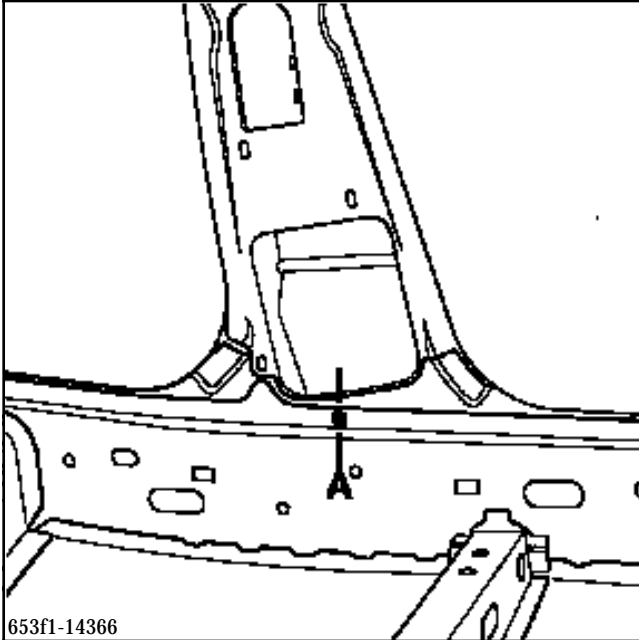
- quarter panel lower reinforcement,
- quarter panel upper reinforcement,
- inflating insert,
- quarter panel lining,
- seat belt mounting nuts,
- stretcher extension.

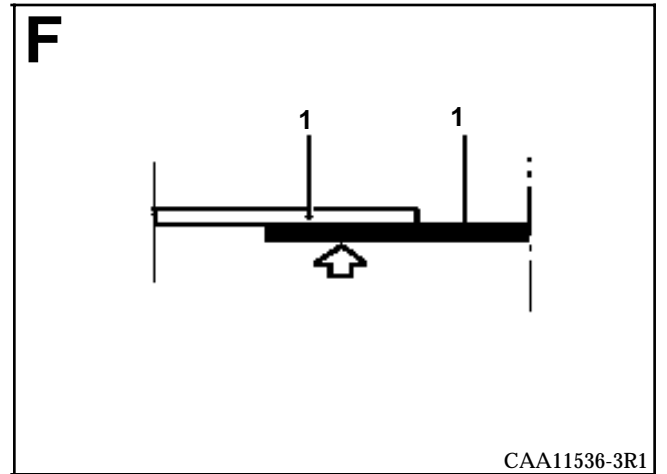
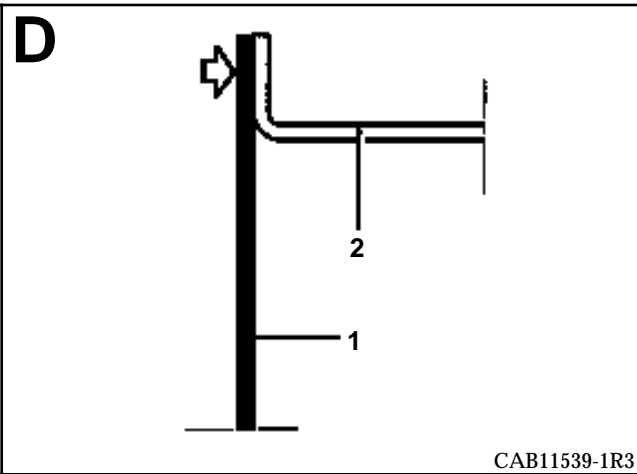
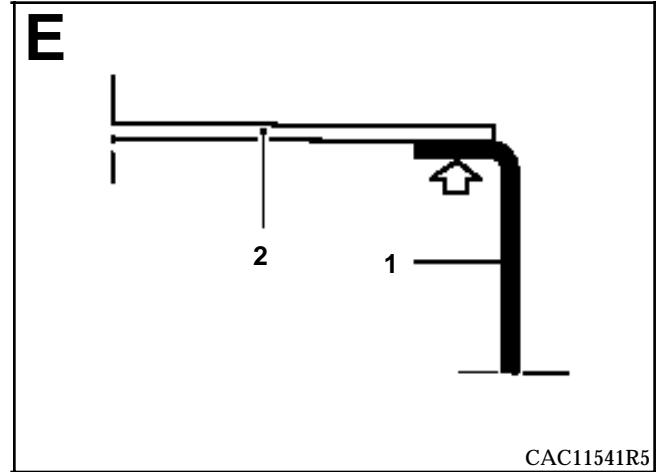
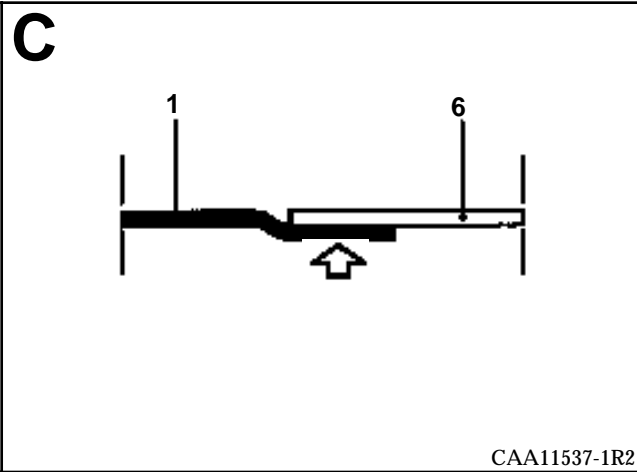


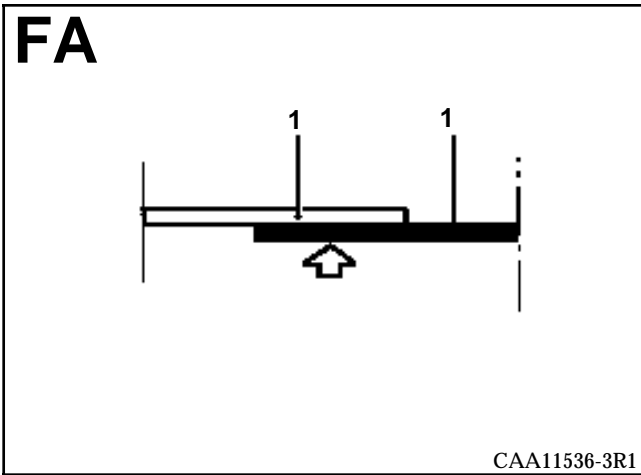
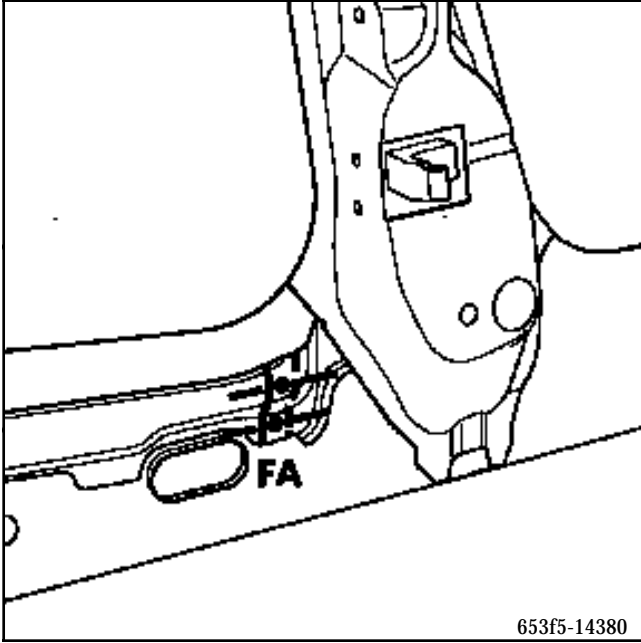
PARTS CONCERNED (thickness in mm) :

1	Centre pillar reinforcement	1
2	Centre pillar lining	0.7
3	Seat belt mounting centre pillar upper reinforcement	1.2
4	Sill panel closure panel	1
5	Sill panel reinforcement	1
6	Windscreen aperture pillar lining	1.2

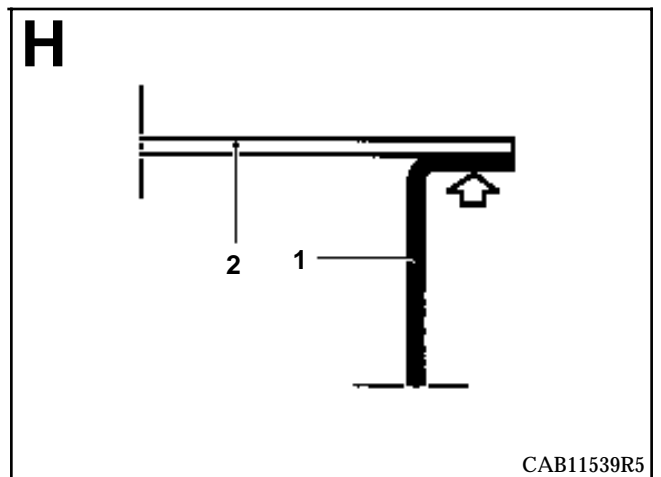
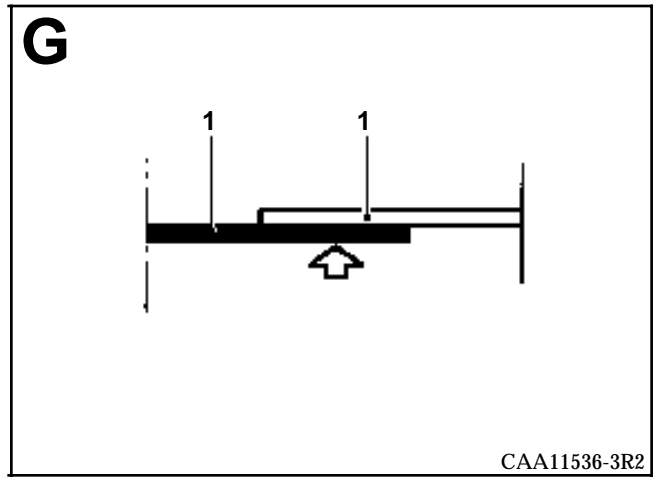
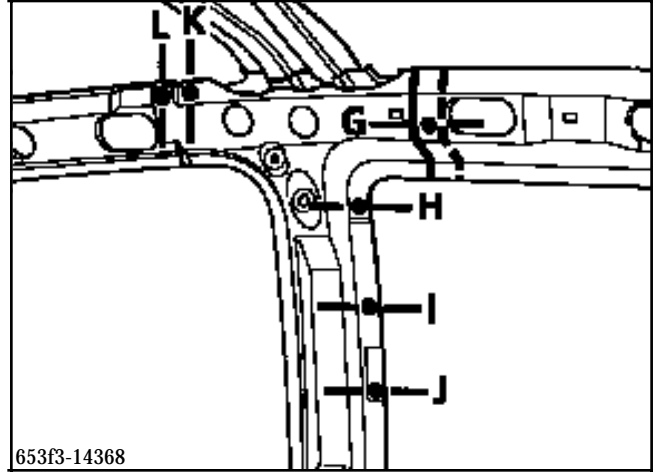
### VERSION B



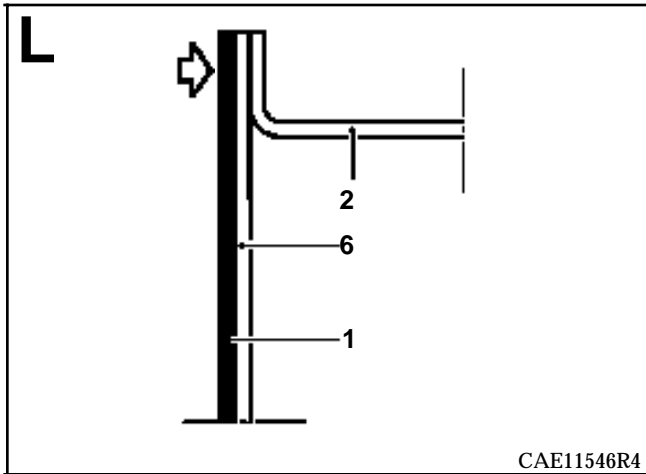
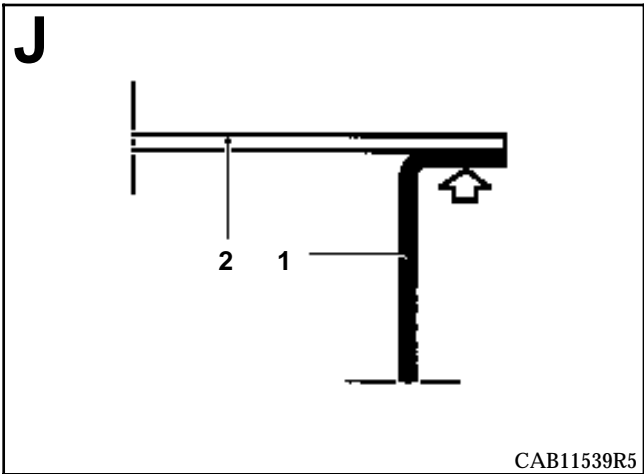
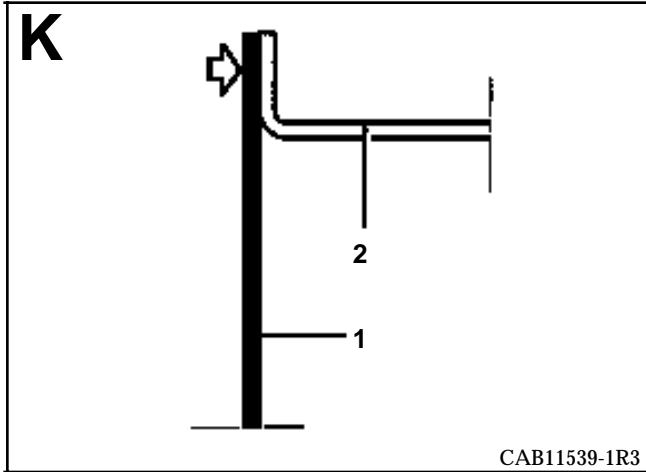
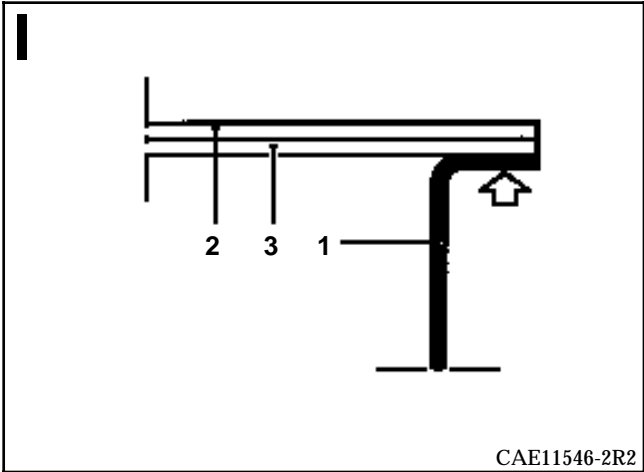


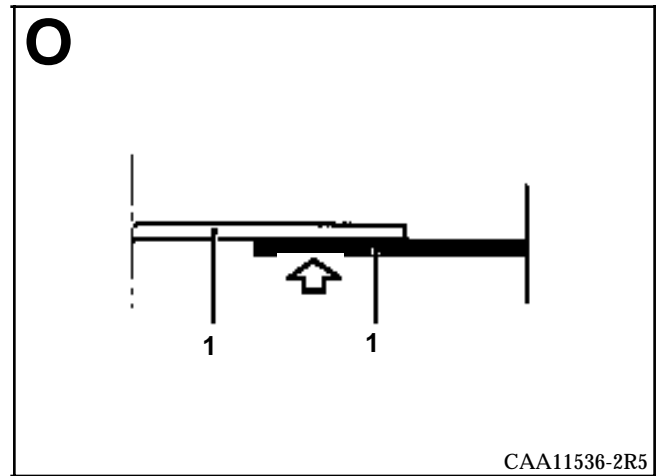
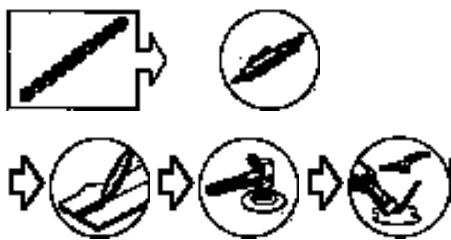
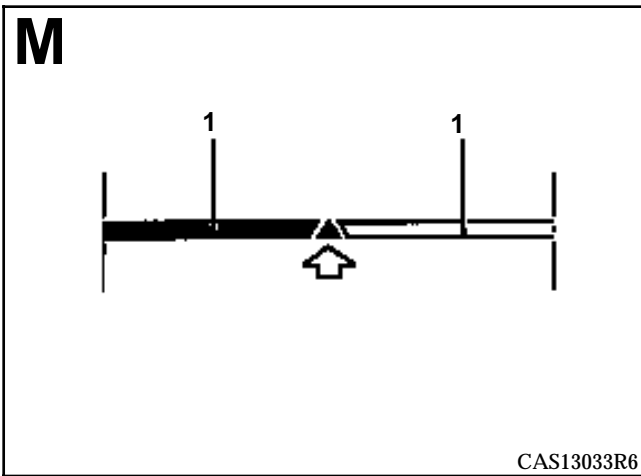
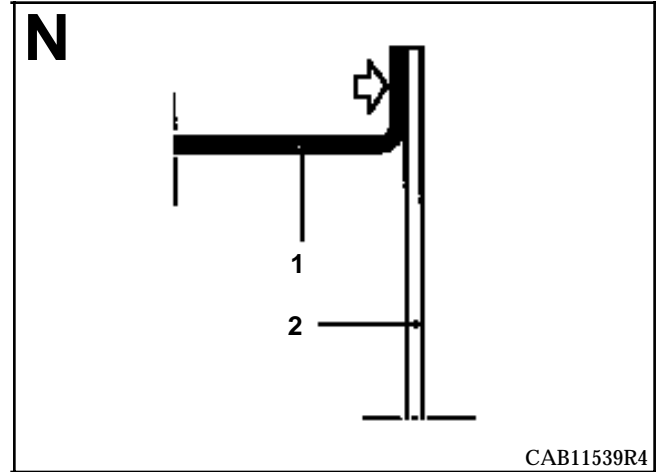
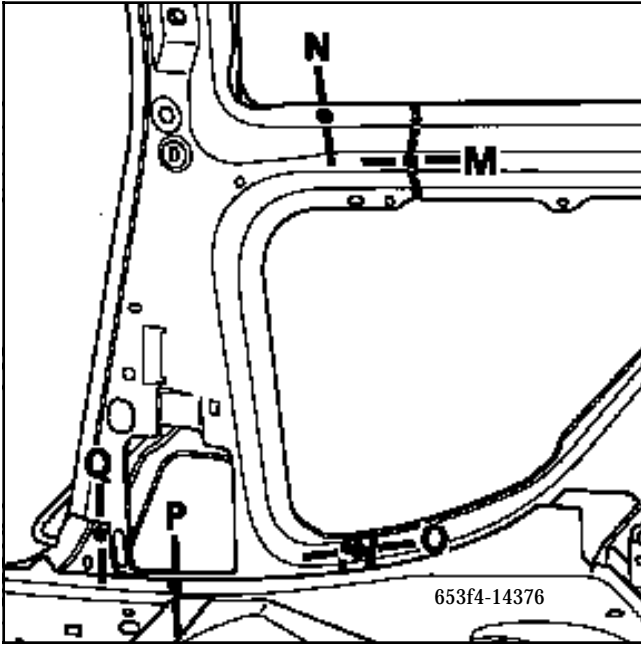


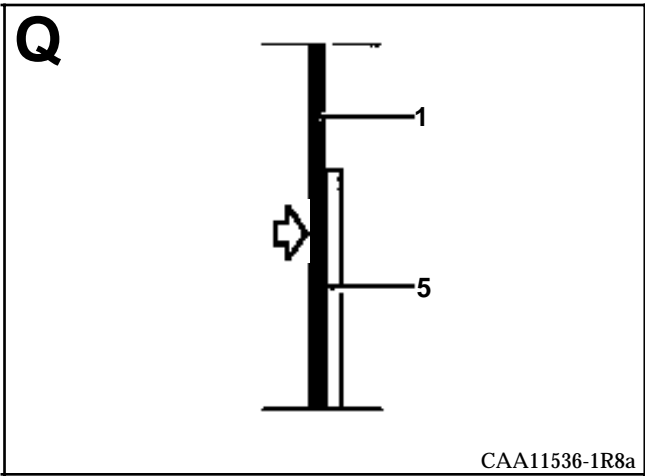
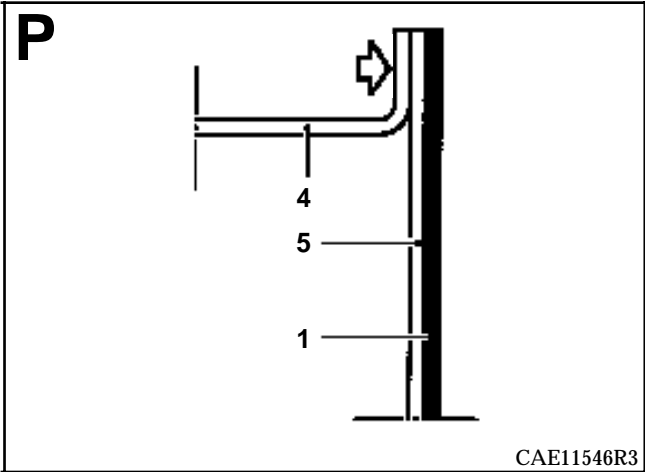
### VERSION C











### INTRODUCTION

The replacement of this part is a basic operation for a front side impact.

In the operation described below there are only descriptions of the joints specific to the part concerned.

Information concerning other parts will be dealt with in the respective section (see contents).

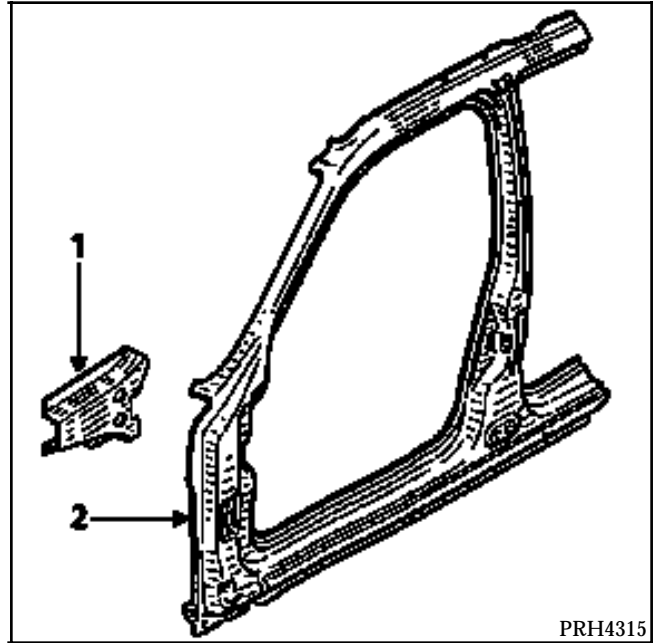
### COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

**1 - Cowl side panel upper reinforcement, rear section**  
Part only.

**2 - Body side, front section**

Part assembled with :

- front pillar reinforcement,
- windscreen aperture pillar double seal mounting,
- welded nuts,
- wing mounting bracket,
- cowl side panel upper reinforcement,
- welded stud,
- door hinge.



**NOTE : for replacing this part, refer to operations 43A and 43D.**

INTRODUCTION

The replacement of this part is a complementary operation to the base reinforcement for a side impact.

This operation is carried out partially for version B and completely for version C.

In the operation described below there are only descriptions of the joints specific to the part concerned.

Information concerning other parts will be dealt with in the respective section (see contents).

COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

VERSION B (1)

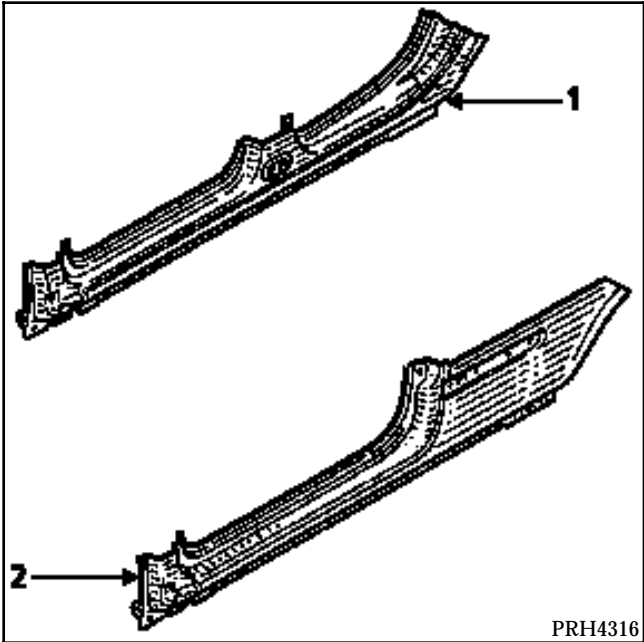
Part assembled with welded stud.

VERSION C (2)

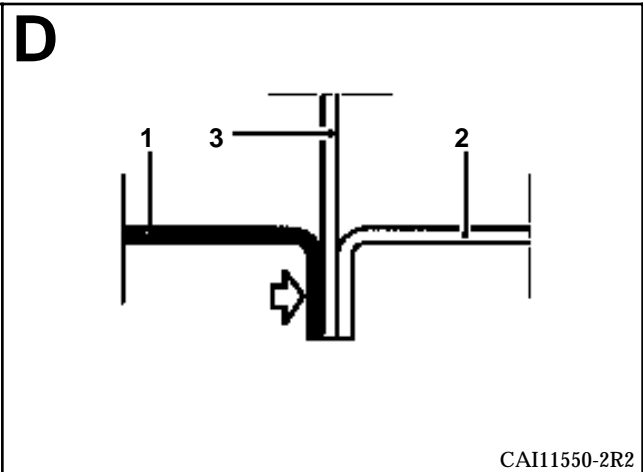
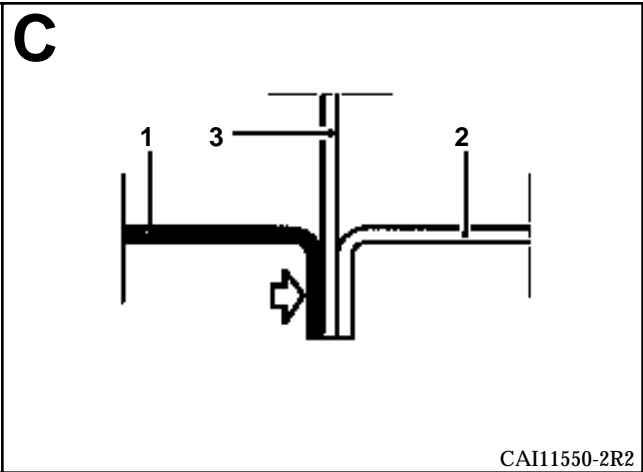
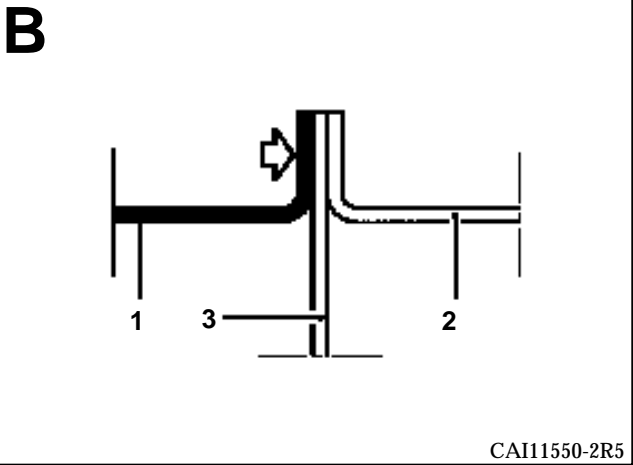
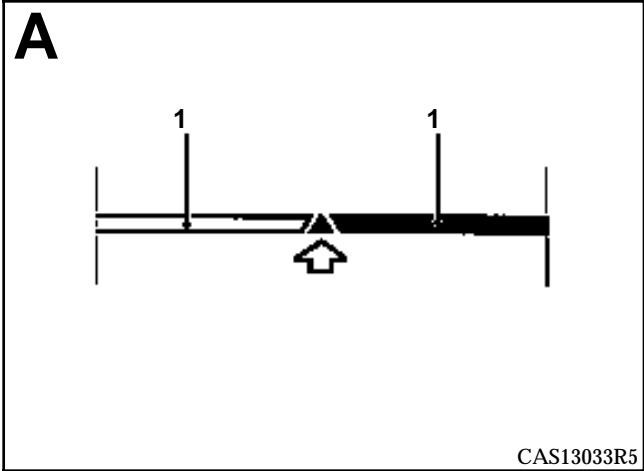
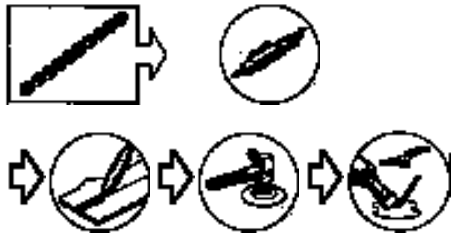
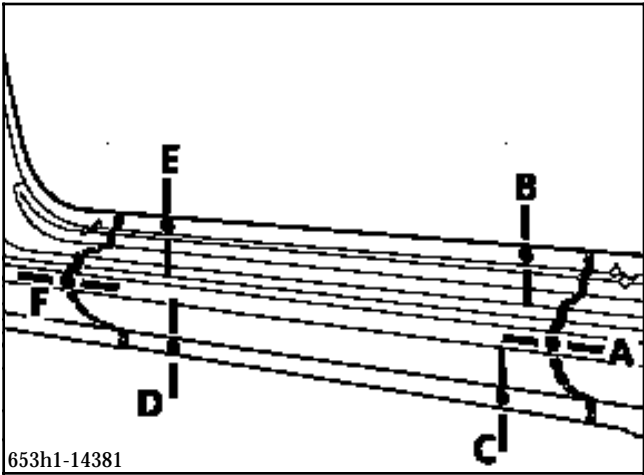
Part assembled with welded stud.

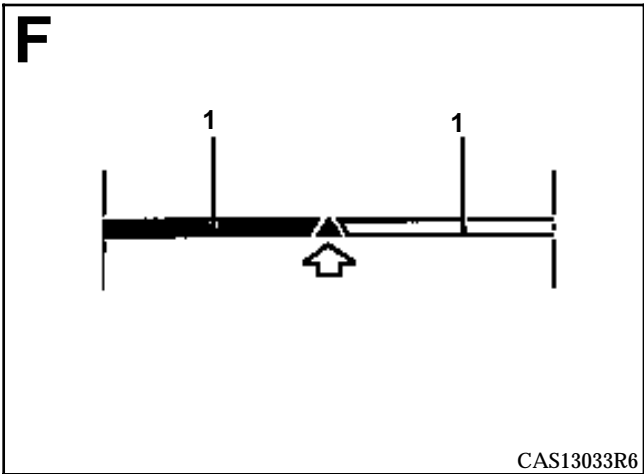
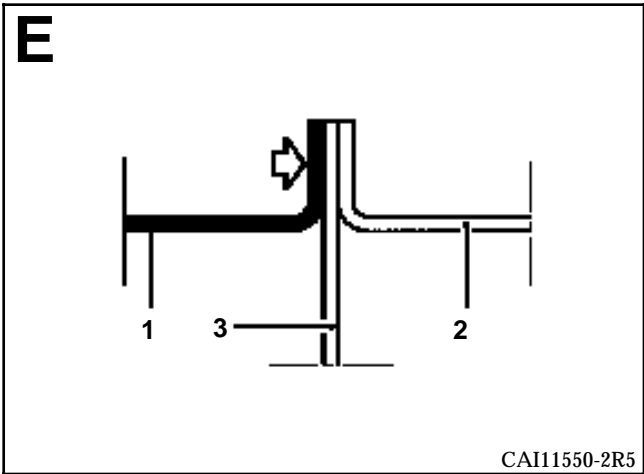
PARTS CONCERNED (thickness in mm) :

1	Sill panel	1.2
2	Sill panel closure panel	1
3	Sill panel reinforcement	1
4	Cowl side panel pillar lining	1.2
5	Centre pillar reinforcement	1
6	Centre pillar closure panel	0.7

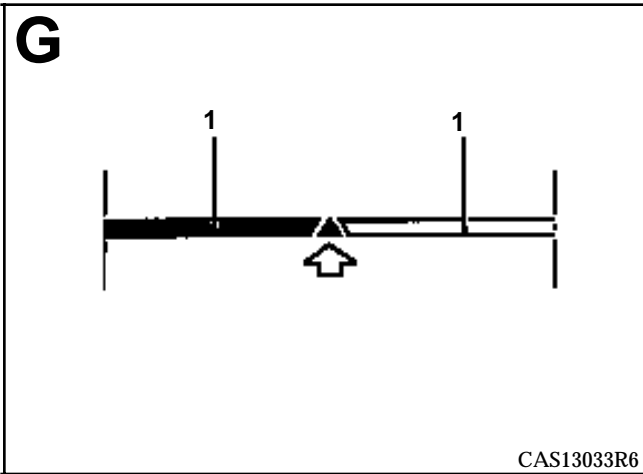
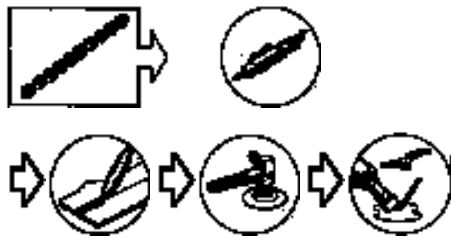
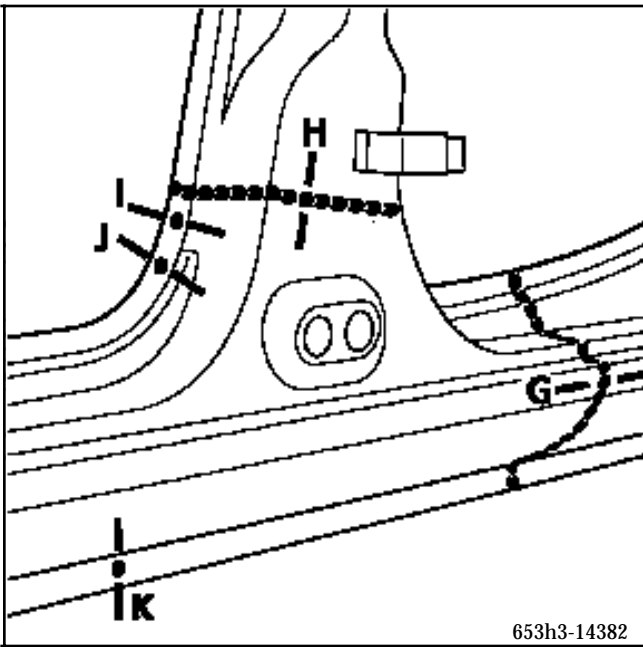


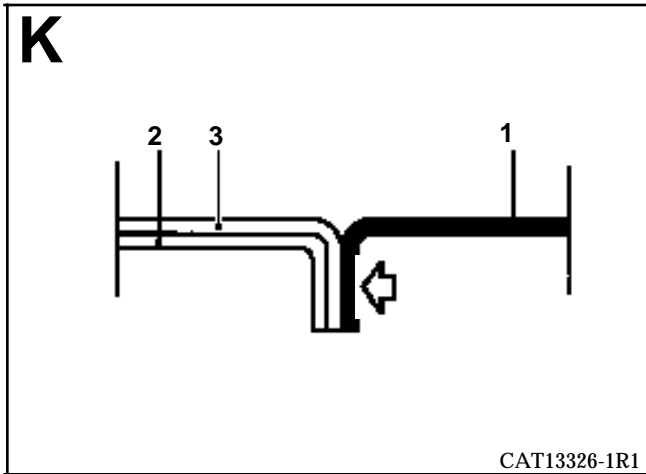
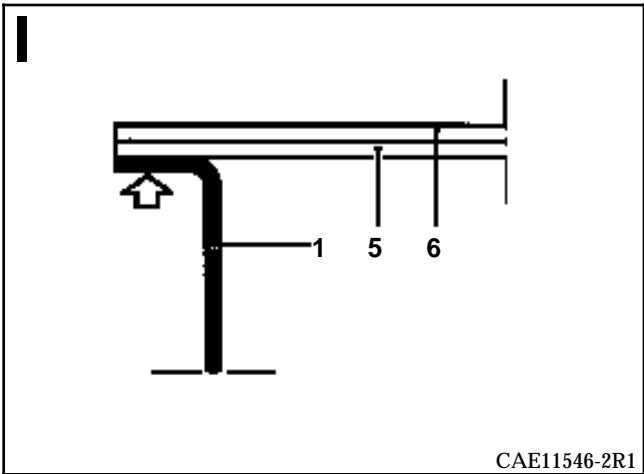
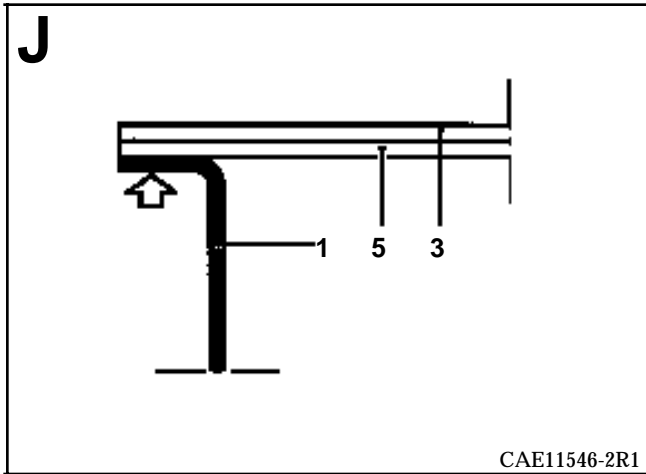
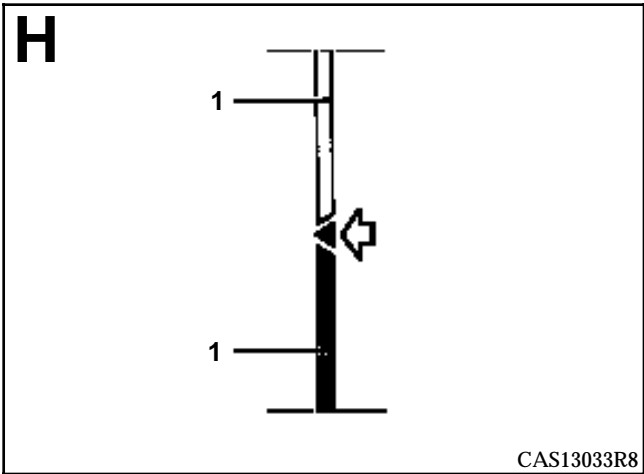
VERSION C



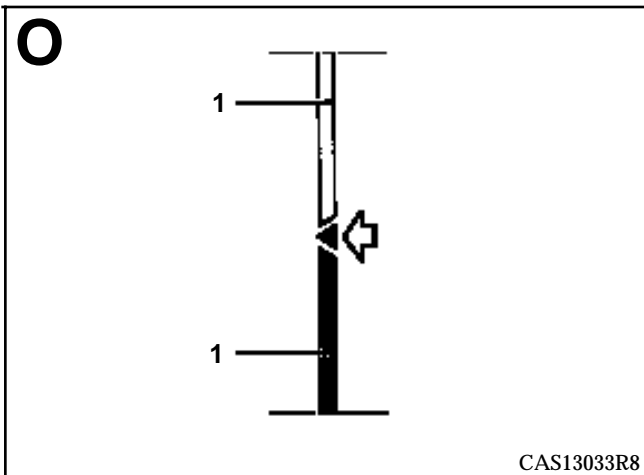
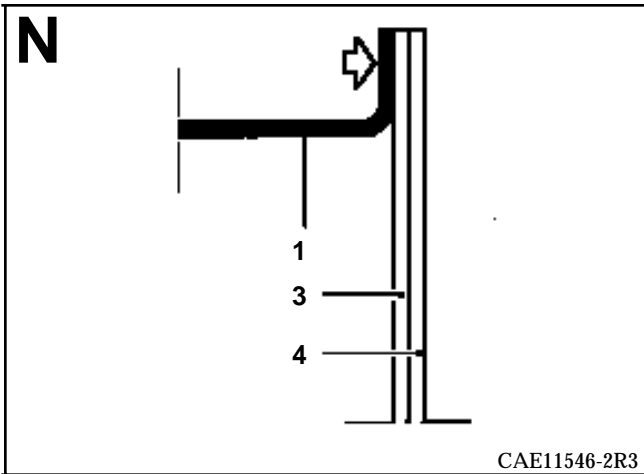
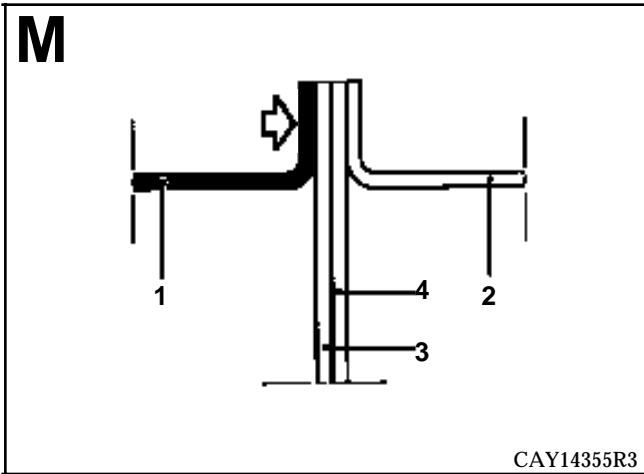
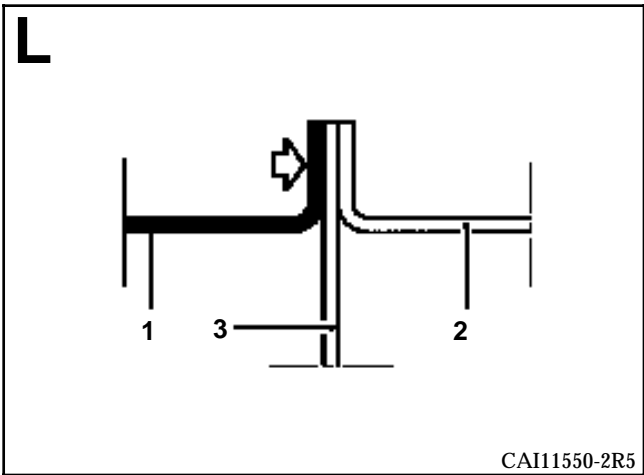
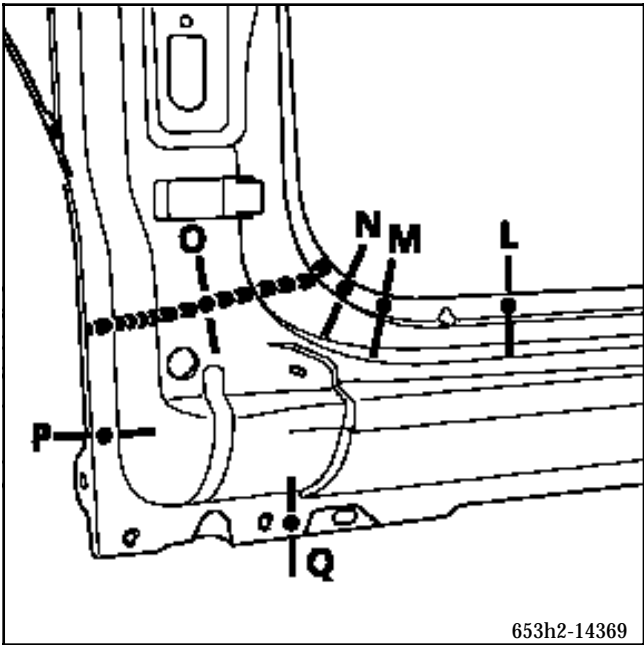


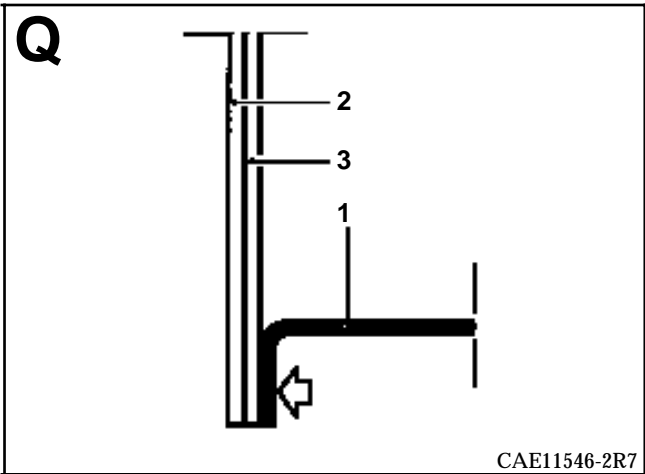
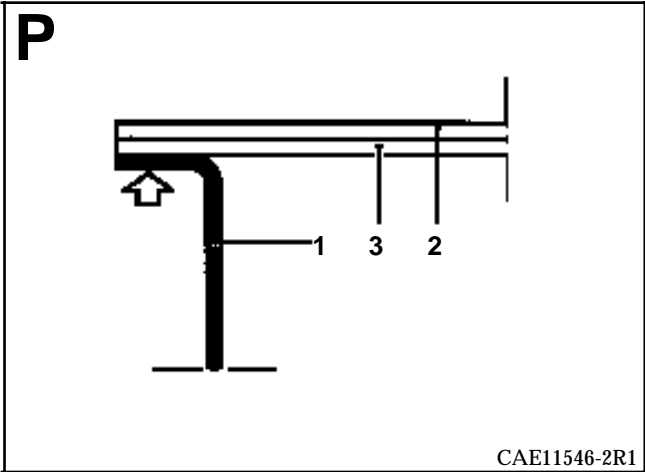
**VERSION B**











INTRODUCTION

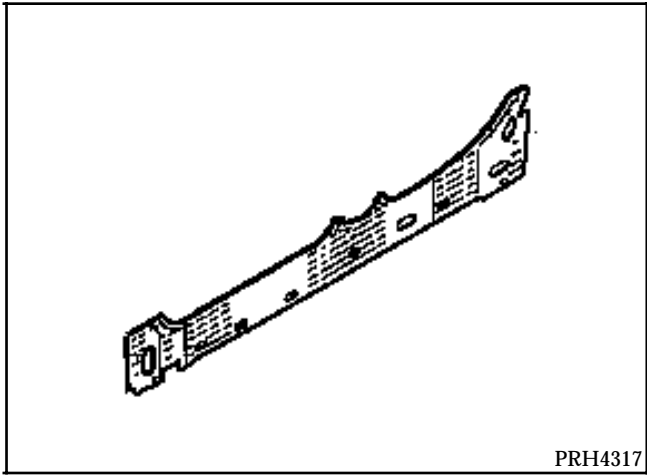
The replacement of this part is a complementary operation to the sill panel .

In the operation described below there are only descriptions of the joints specific to the part concerned.

Information concerning other parts will be dealt with in the respective section (see contents).

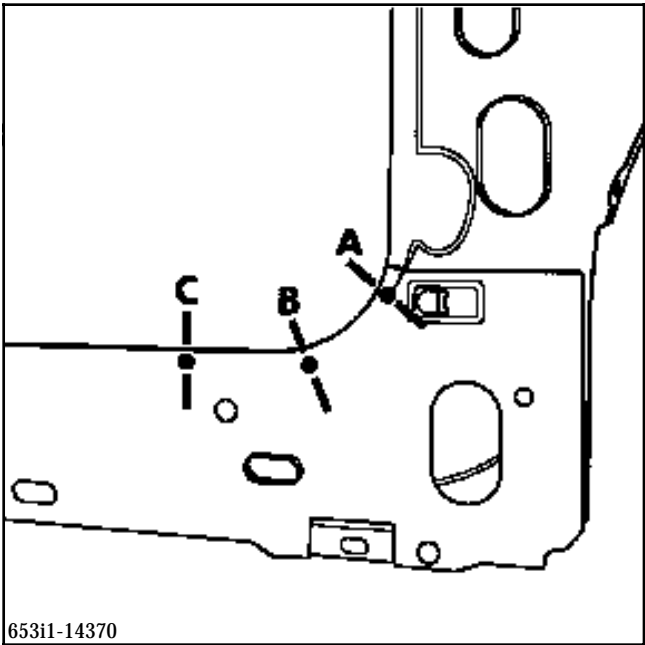
COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

Part only.

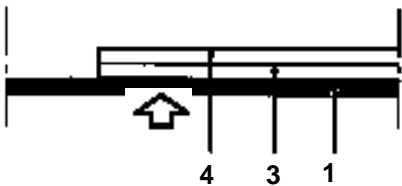


PARTS CONCERNED (thickness in mm) :

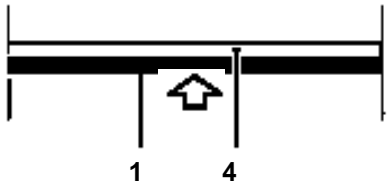
1	Sill panel reinforcement	1
2	Body side lining	0.7
3	Sill panel closure panel	1
4	Cowl side panel pillar lining	1.2
5	Rear axle assembly mounting unit	1



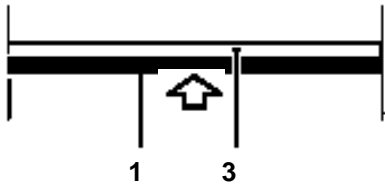
B

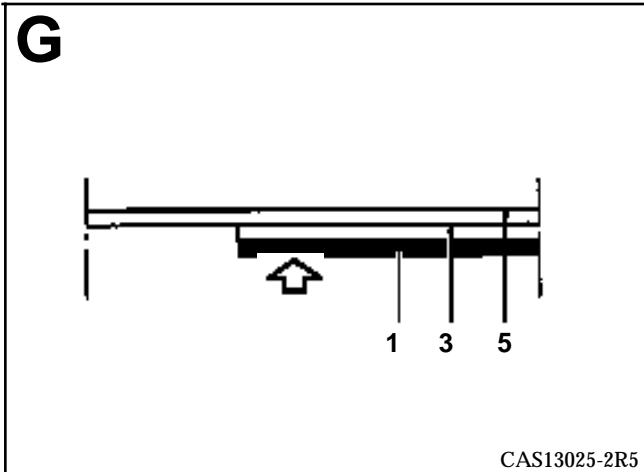
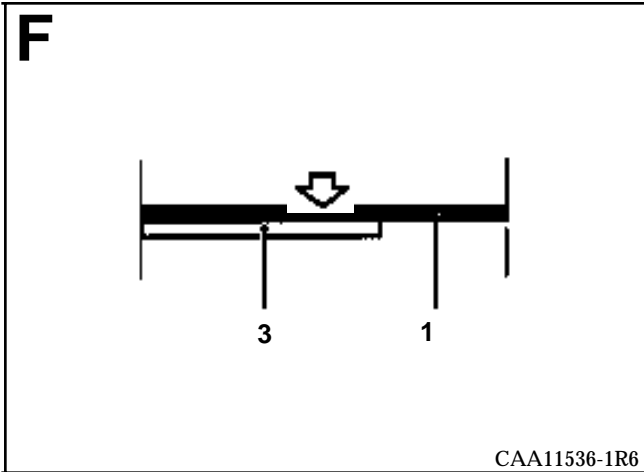
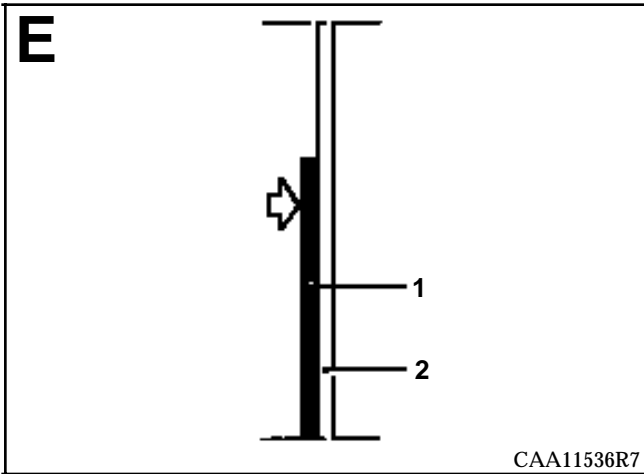
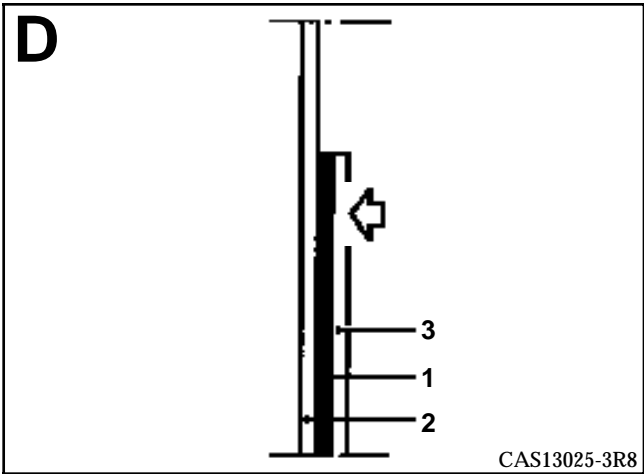
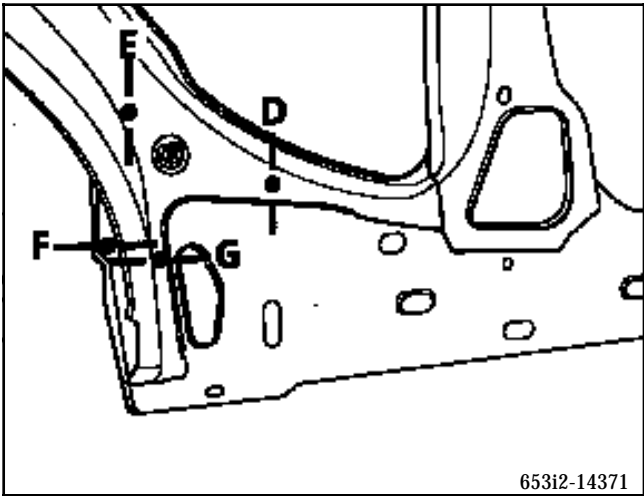


A



C





INTRODUCTION

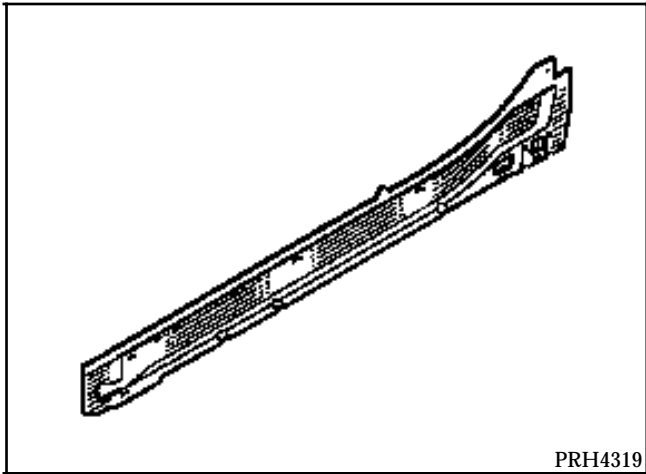
The replacement of this part is a complementary operation to the sill panel reinforcement for a side impact (versions B and C).

In the operation described below there are only descriptions of the joints specific to the part concerned.

Information concerning other parts will be dealt with in the respective section (see contents).

COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

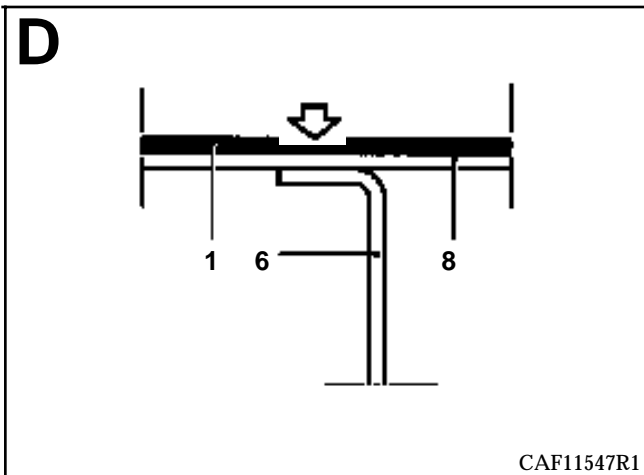
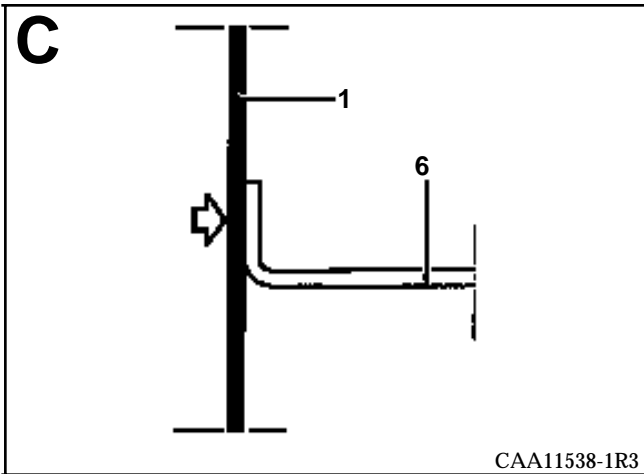
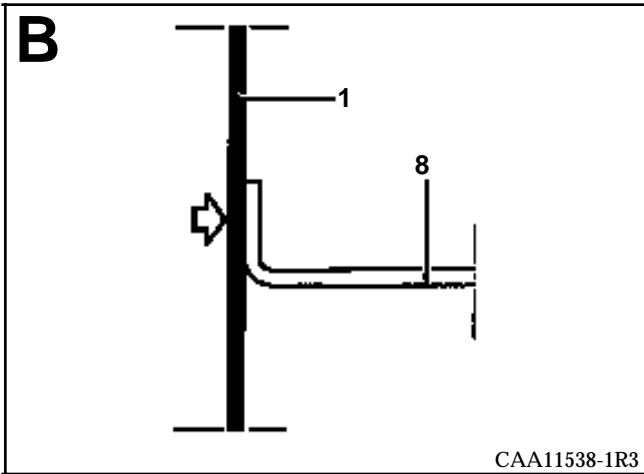
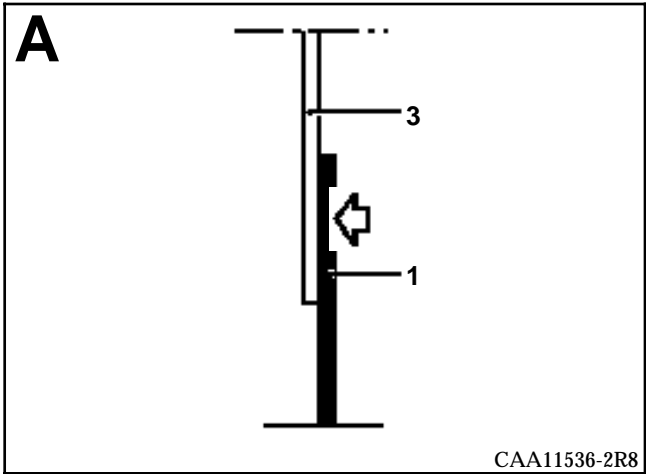
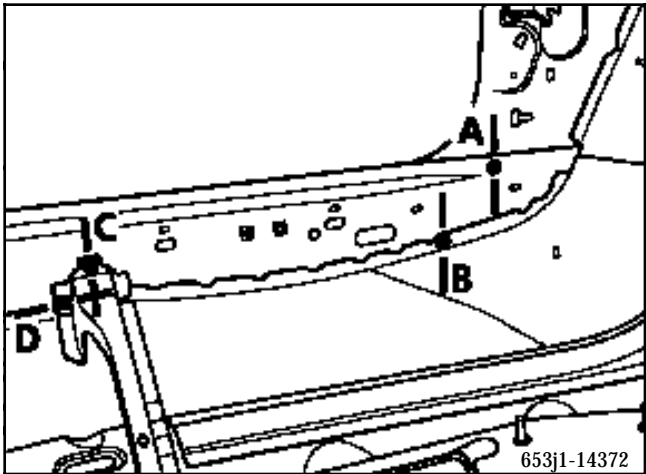
- Part assembled with :
- reinforcement plate,
  - nuts to be welded.

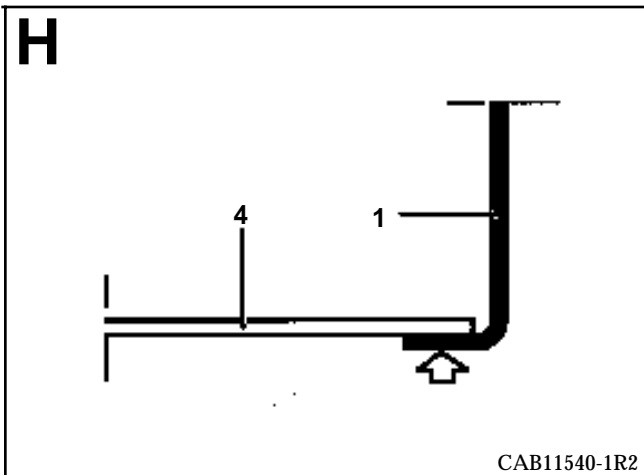
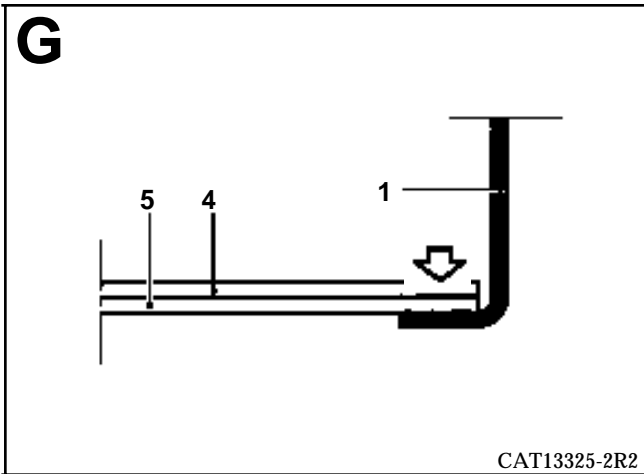
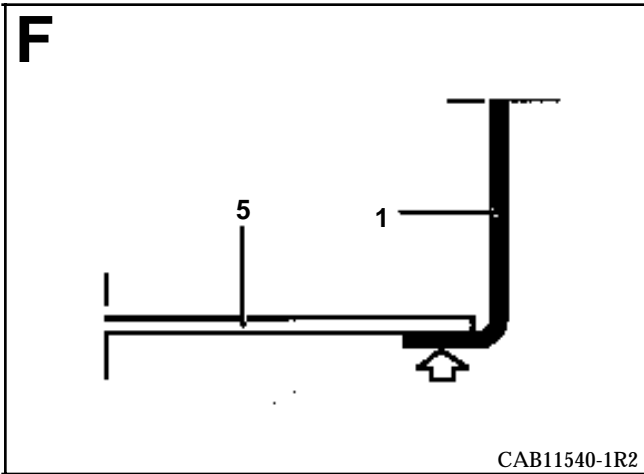
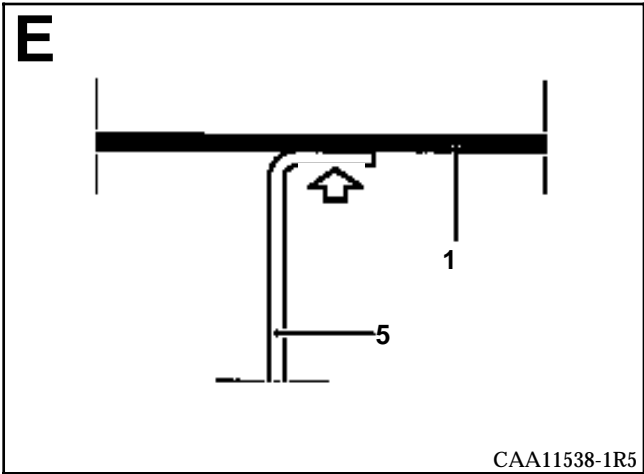
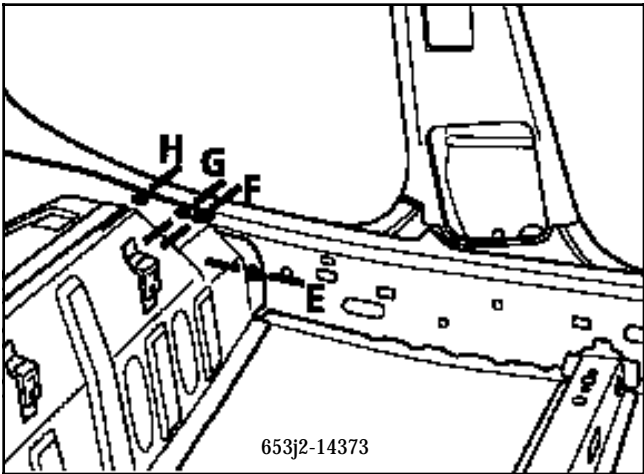


PRH4319

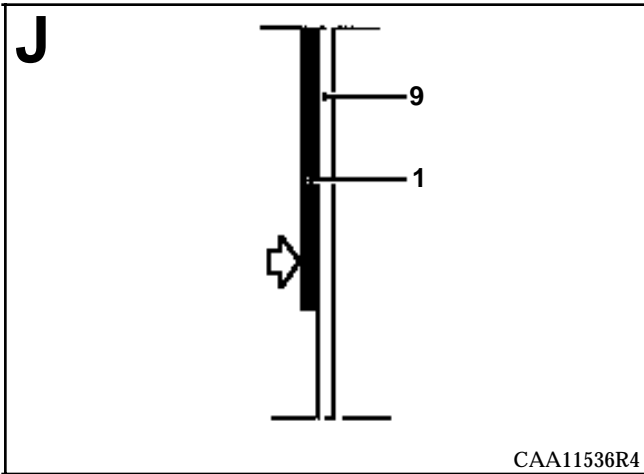
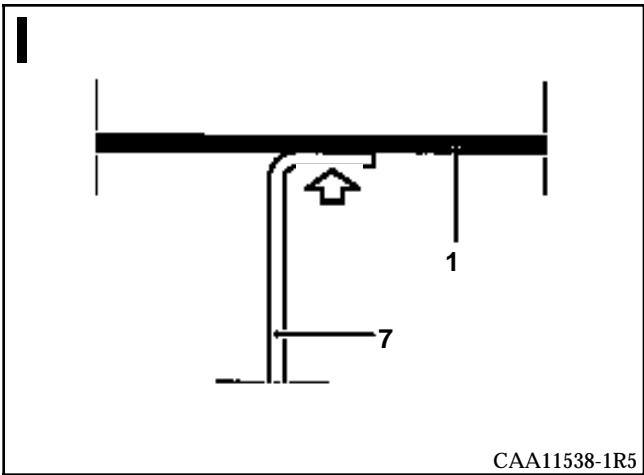
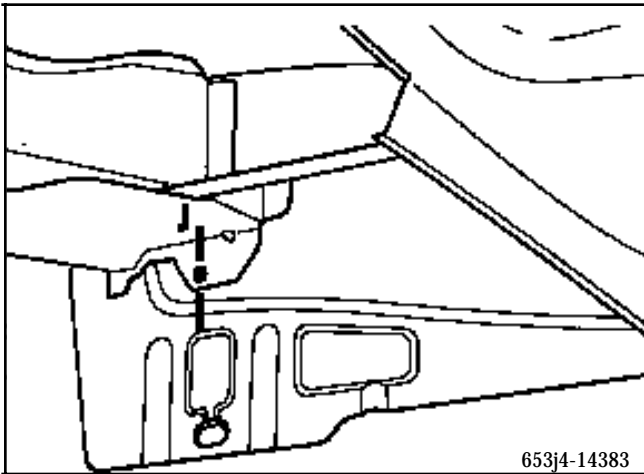
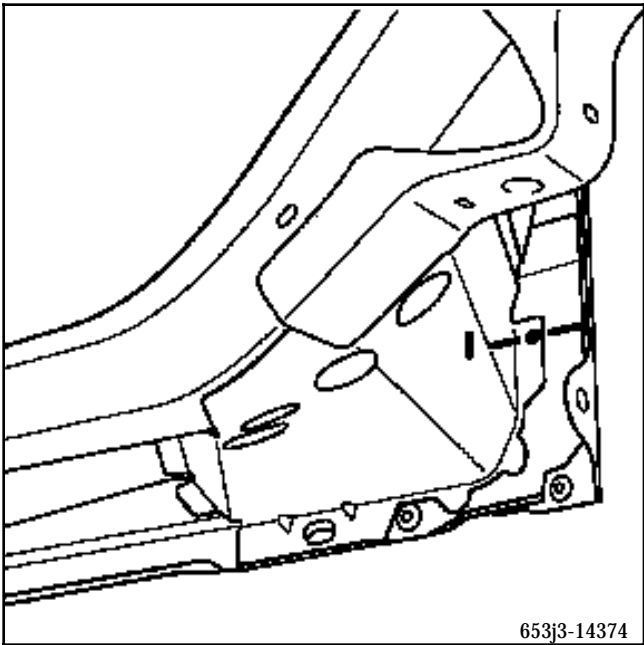
PARTS CONCERNED (thickness in mm) :

1	Sill panel closure panel	1
2	Sill panel reinforcement	1
3	Cowl side panel pillar lining	1.2
4	Rear floor	0.7
5	Cross member of rear floor cross member	1.5
6	Cross member under front seat	1
7	Front side cross member	1
8	Centre floor	1.47
9	Rear axle assembly mounting unit	1









### INTRODUCTION

The replacement of this part is a complementary operation to the replacement of the roof for a front side impact.

In the operation described below there are only descriptions of the joints specific to the part concerned.

Information concerning other parts will be dealt with in the respective section (see contents).

### COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

#### 1 - Upper reinforcement of cowl side panel, rear section

Part only

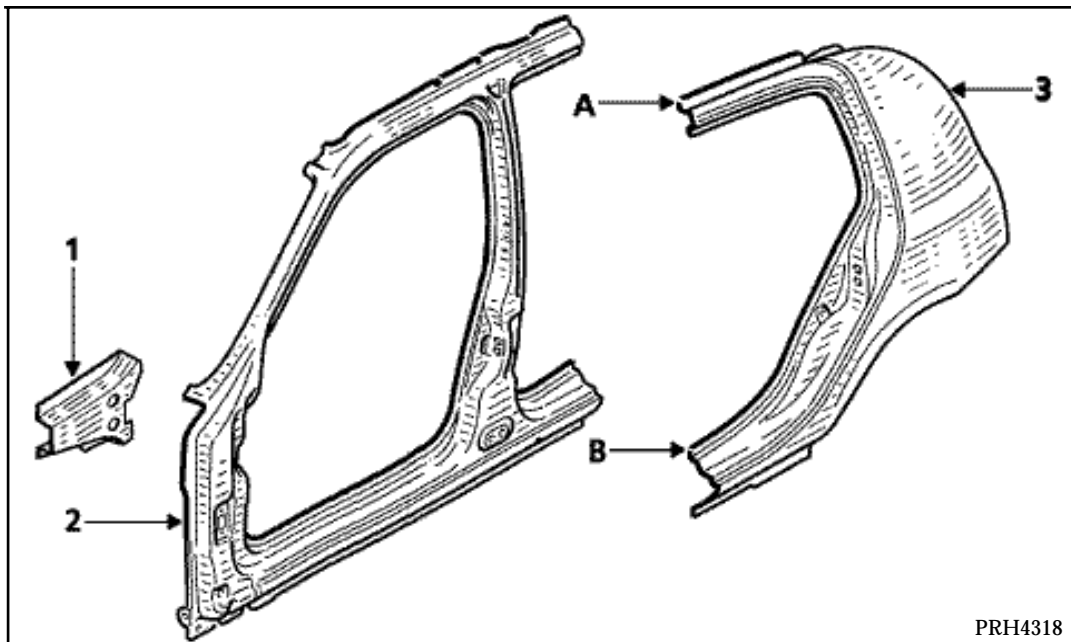
#### 2 - Body side, front section

Part assembled with :

- front pillar reinforcement,
- windscreen aperture pillar double seal mounting,
- welded nuts,
- wing mounting bracket,
- cowl side panel upper reinforcement,
- welded stud,
- door hinge.

#### 3 - Rear wing panel

Part assembled with striker plate reinforcement.



PRH4318

**NOTE 1 :** to replace these parts, refer to operations 43A, 43D and 44A.

**NOTE 2 :** sections A and B of part 3 are big enough to be cut where they overlap with the sections corresponding to part 2.

**INTRODUCTION**

The replacement of this part is a basic operation for a rear side impact.

It will be replaced partially.

**For version B :** along cut A, diagram below (the double seal mounting will have to be ordered separately).

**For version C :** along cut B.

**NOTE :** complete replacement will be complementary to the roof.

In the operation described below there are only descriptions of the joints specific to the part concerned.

Information concerning the other parts will be dealt with in the respective section (see contents).

**COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT**

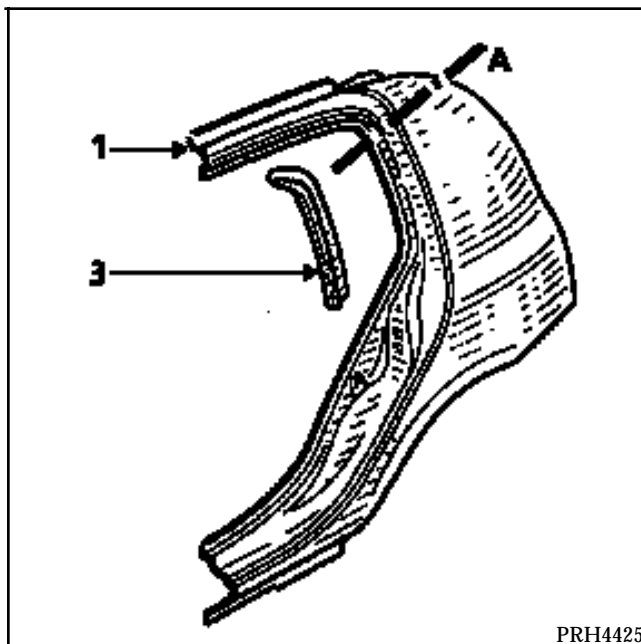
Part assembled with :

**VERSION B (1)**

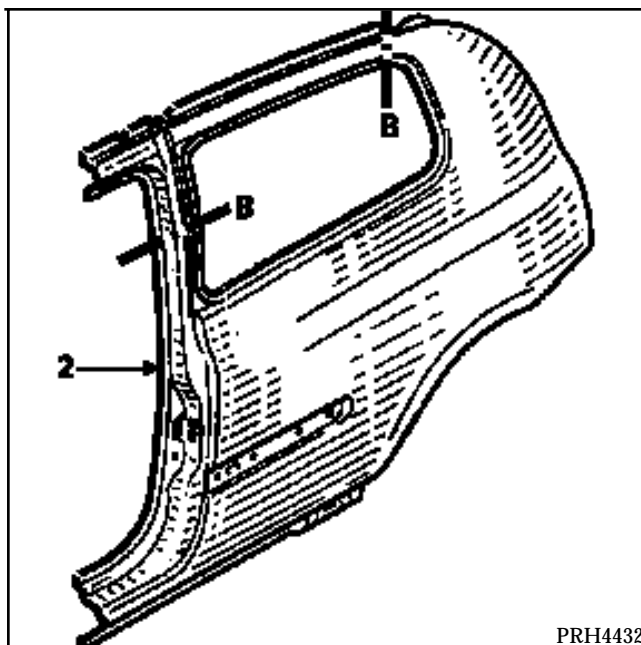
- bumper reinforcement,
- door striker plate reinforcement,
- striker plate reinforcement plate,
- double seal mounting (part 3) (to be ordered separately for version B).

**VERSION C (2)**

- stiffener,
- adjustable seal,
- bumper reinforcement.



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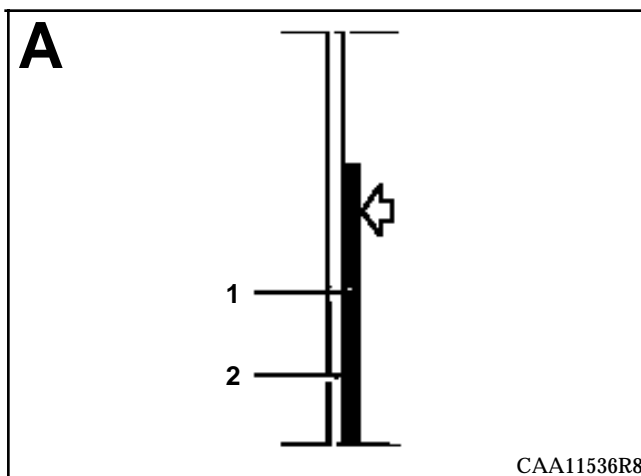
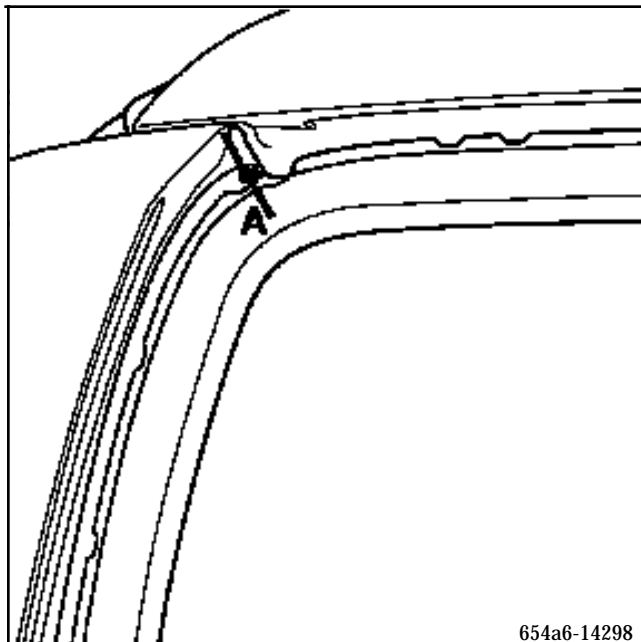


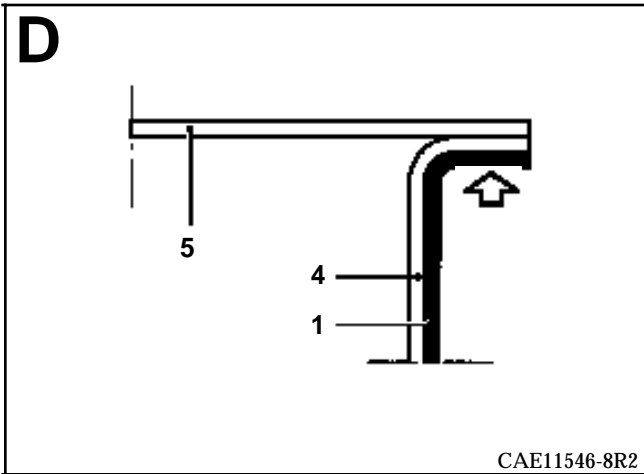
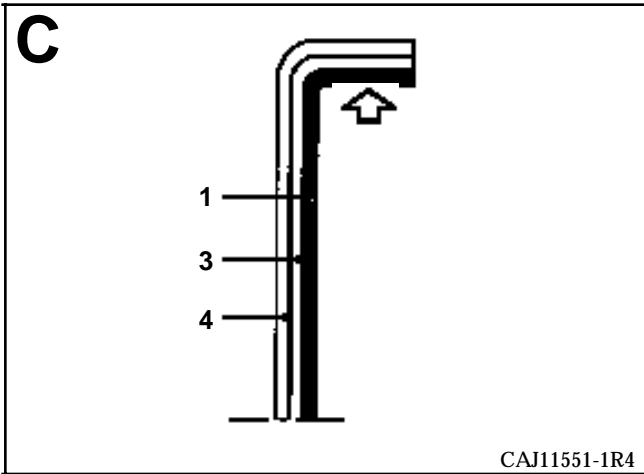
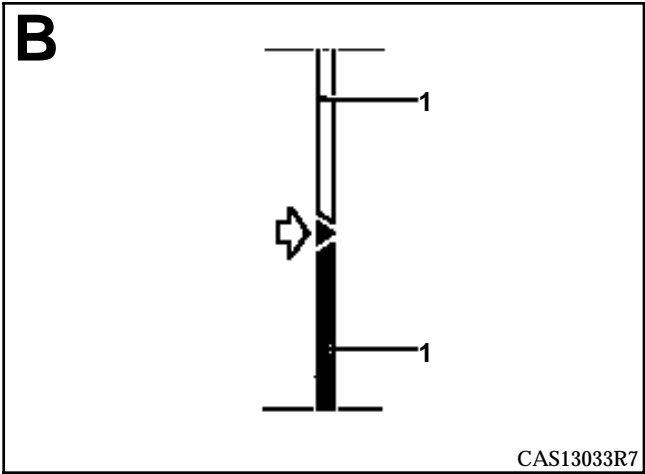
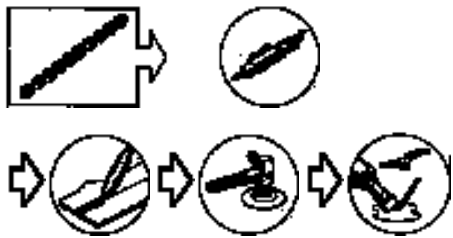
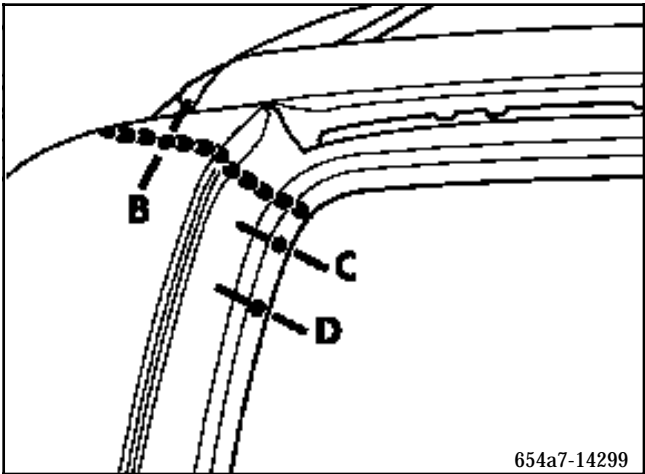
PRH4432



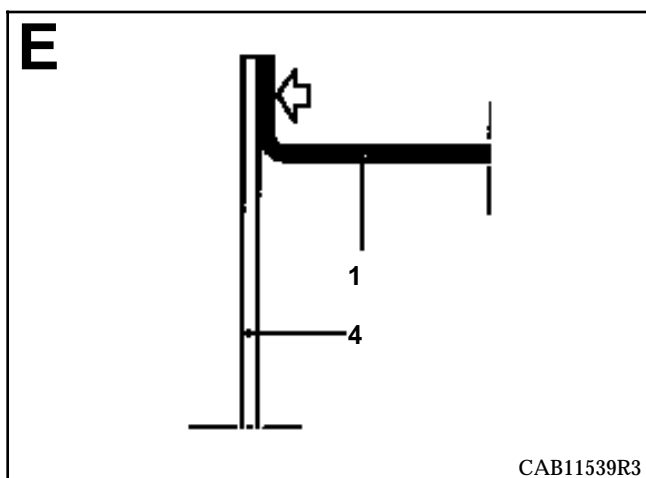
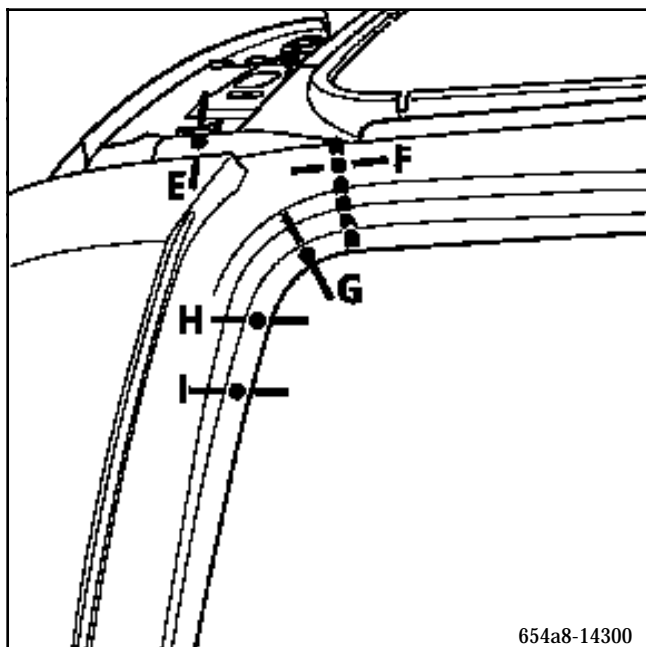
**PARTS CONCERNED (thickness in mm):**

1	Rear wing panel	0.8
2	Quarter panel double seal mounting	0.7
3	Rear quarter panel upper rear reinforcement	1.2
4	Rear quarter panel lower rear reinforcement	1.2
5	Body side lining	0.7
6	Door striker plate reinforcement	1.2
7	Sill panel reinforcement	1
8	Sill panel closure panel	1
9	Seat belt mounting centre pillar upper reinforcement	1.2
10	Centre pillar reinforcement	1
11	Upper rear side rain channel	1
12	Lower rear side rain channel	0.7

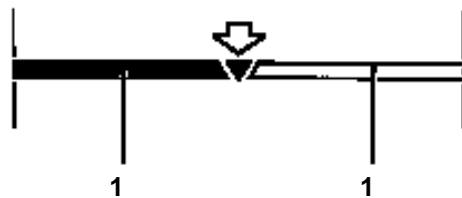




## COMPLETE REPLACEMENT (with removal of roof)



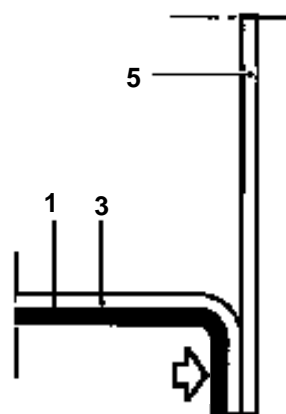
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CAS13033R1

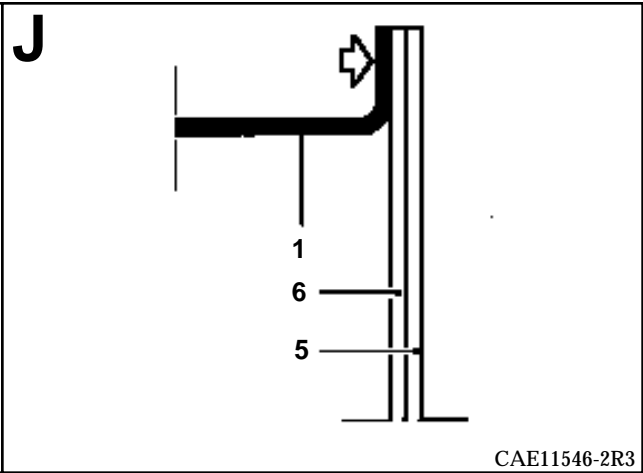
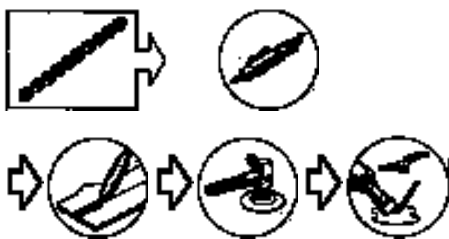
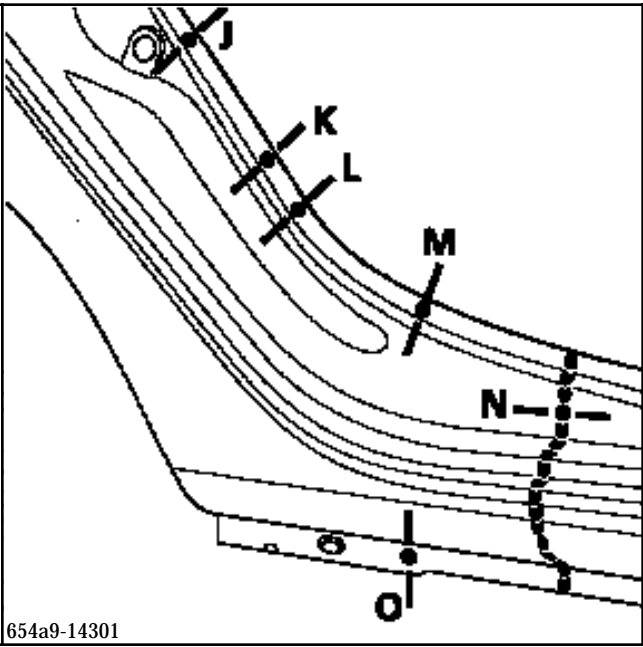
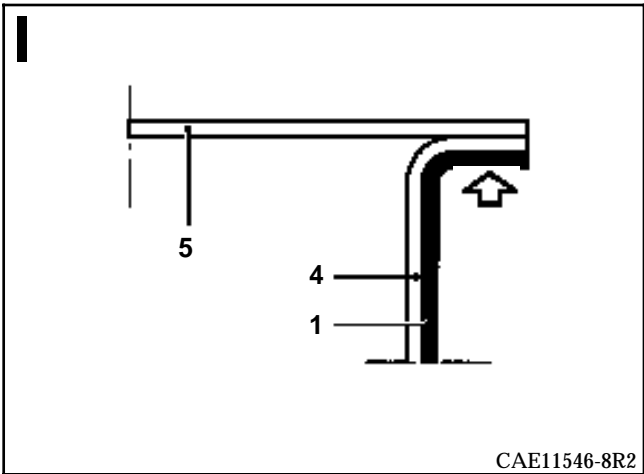
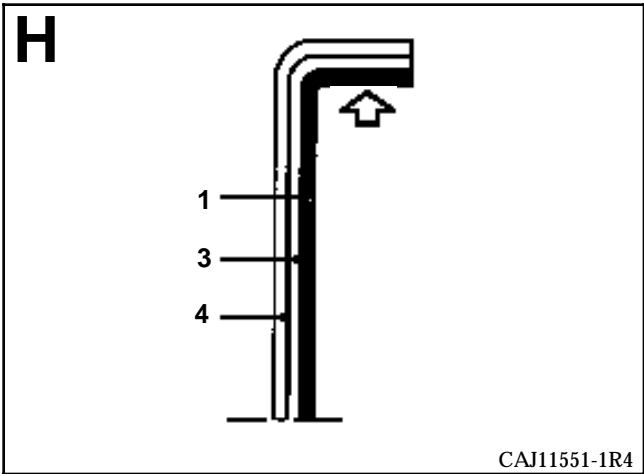


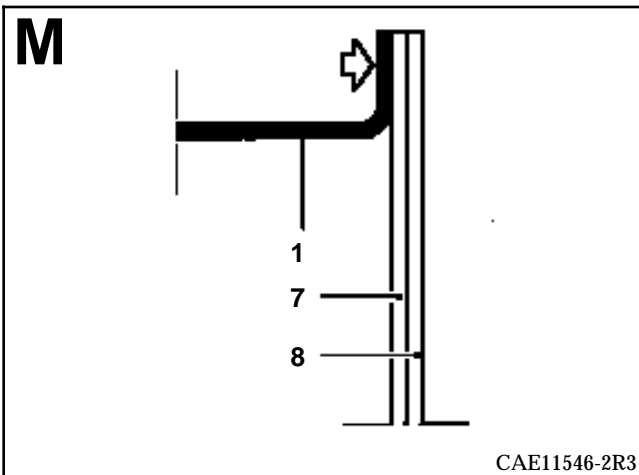
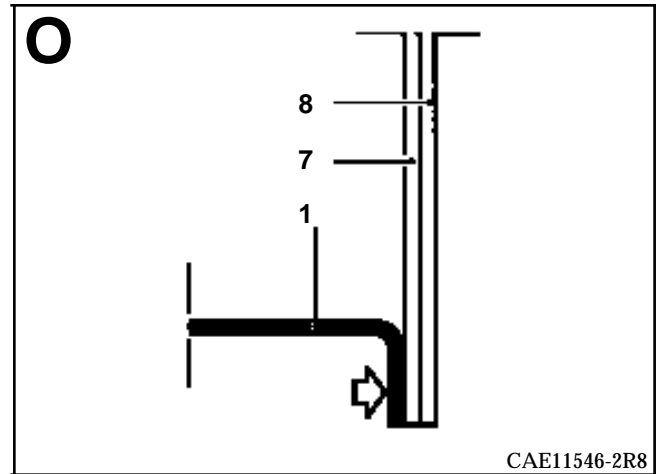
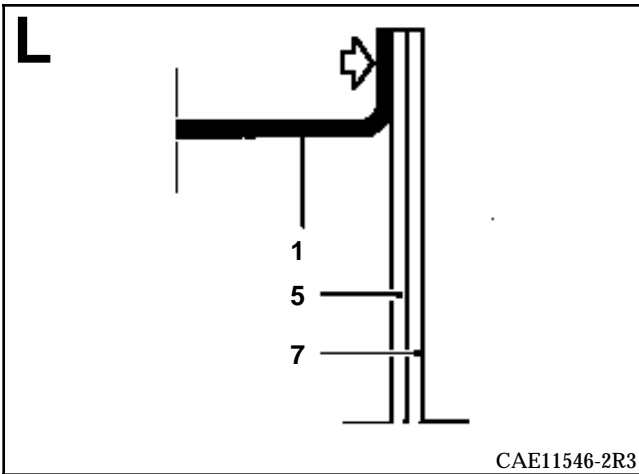
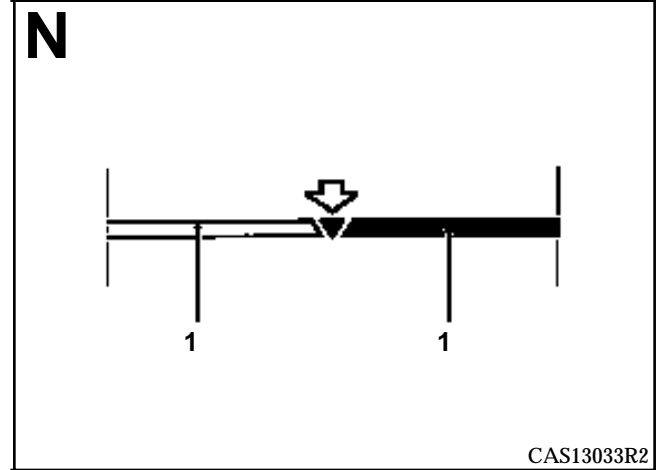
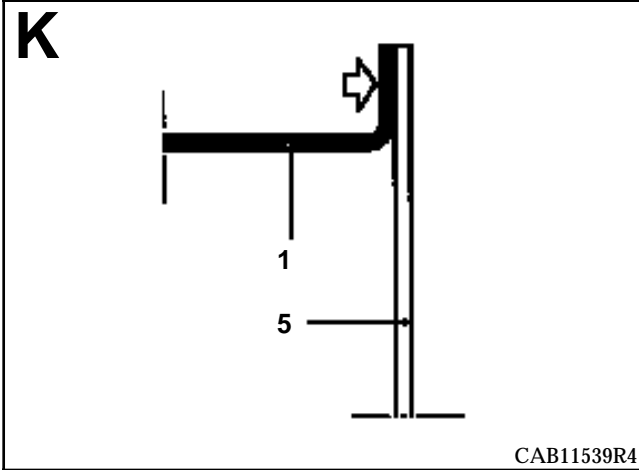
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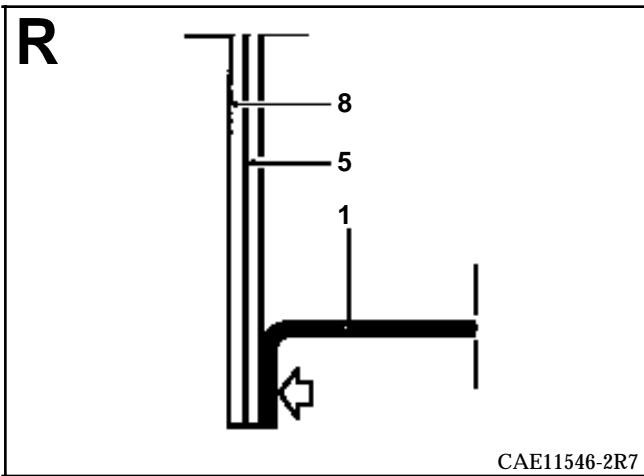
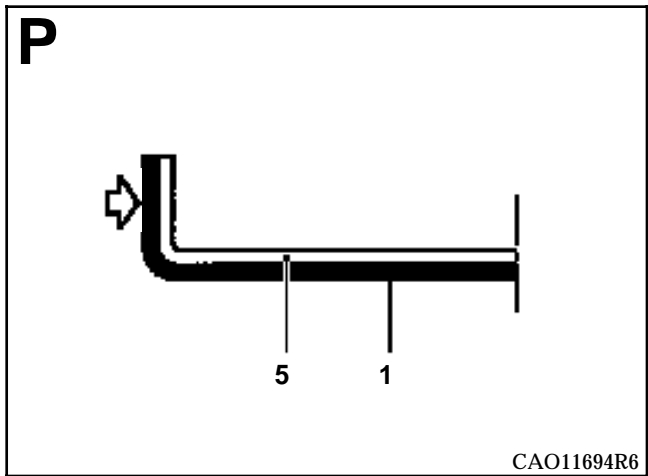
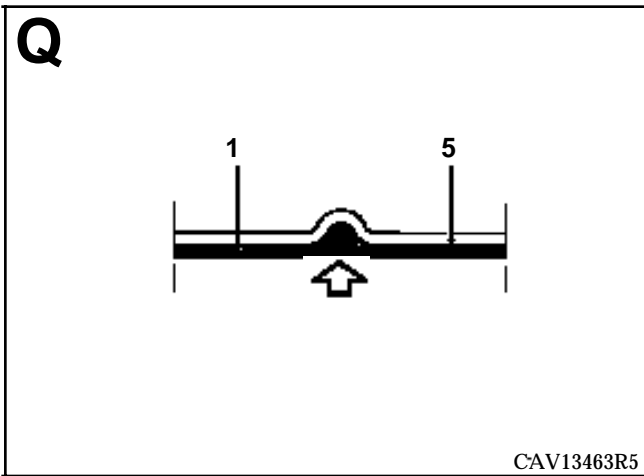
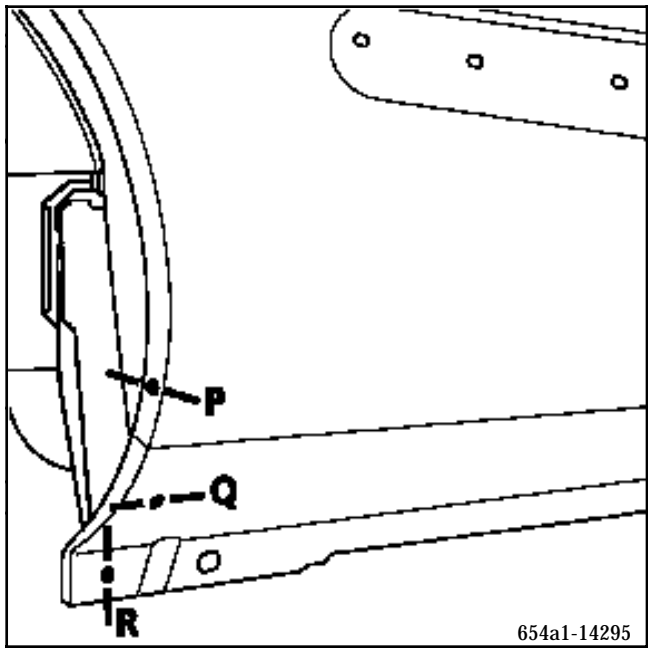
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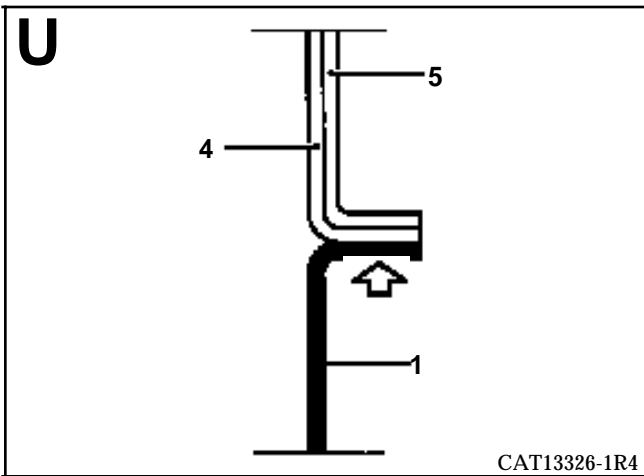
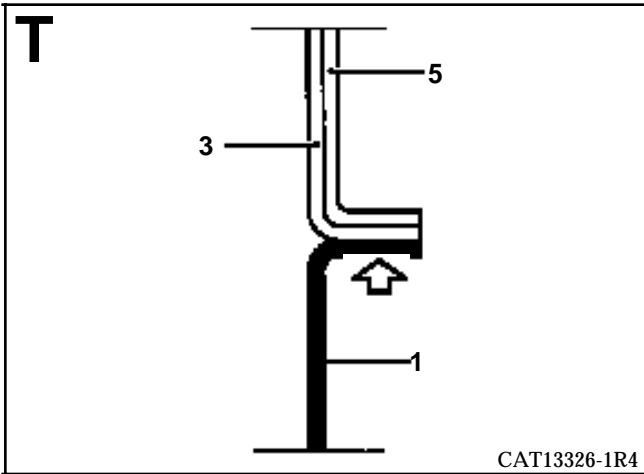
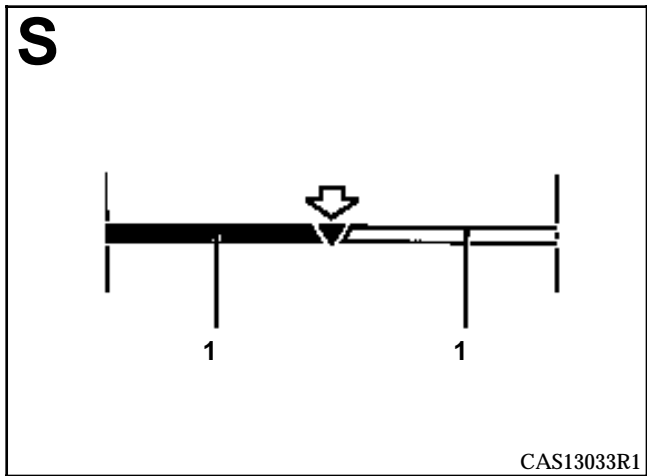
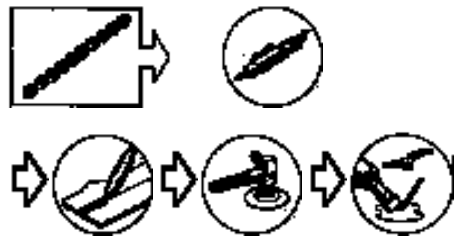
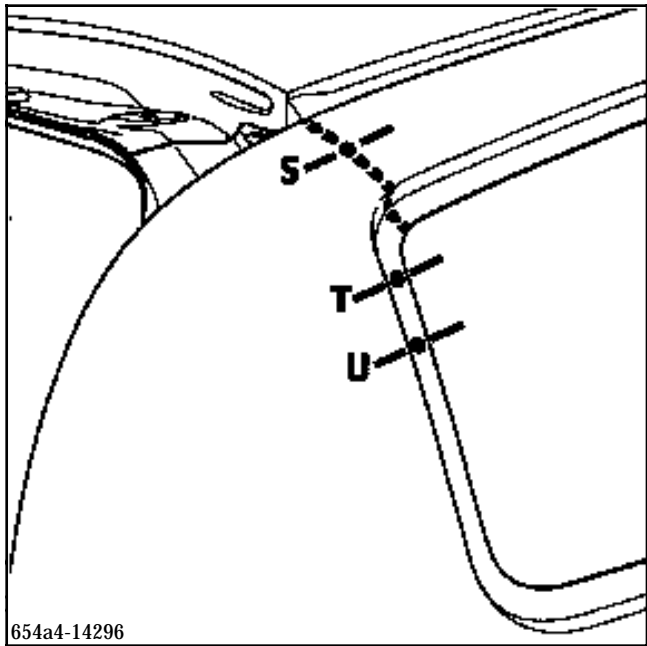


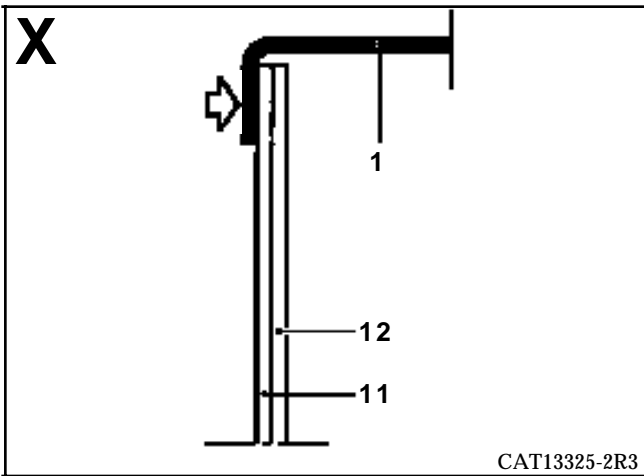
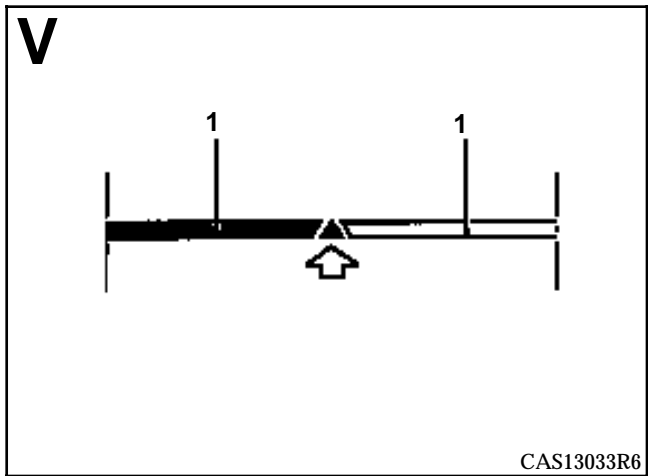
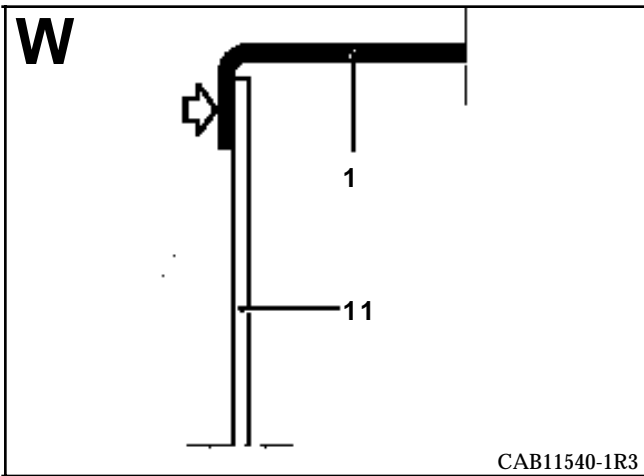
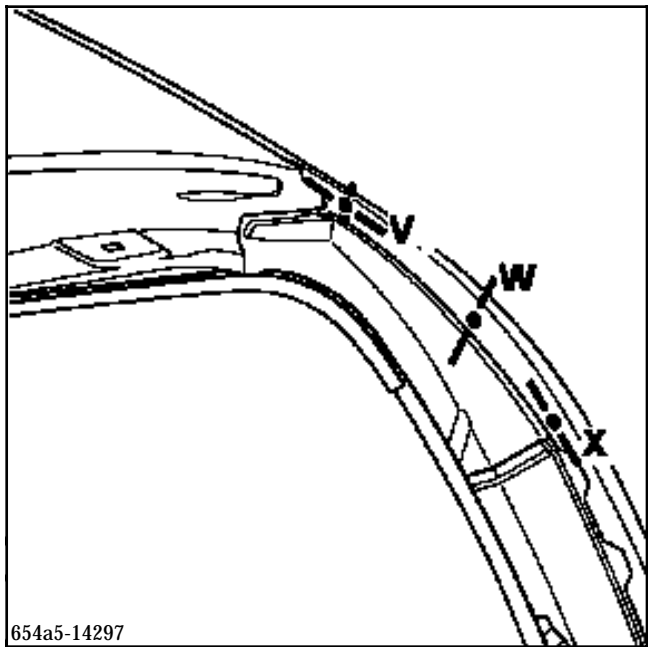


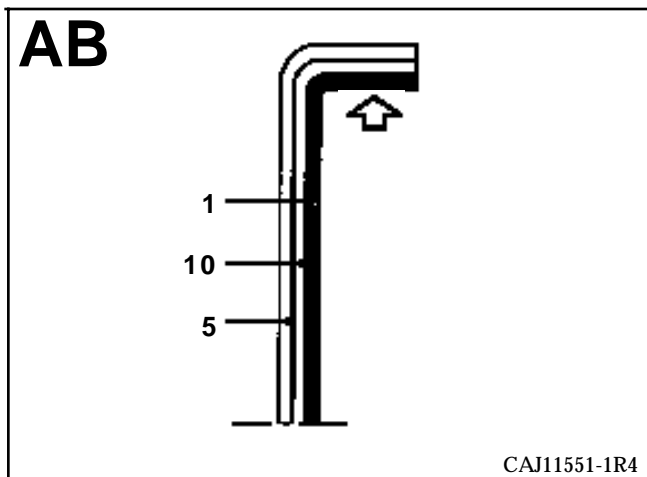
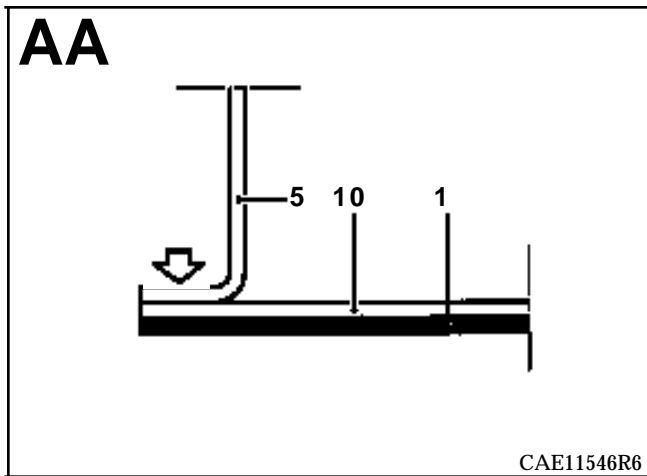
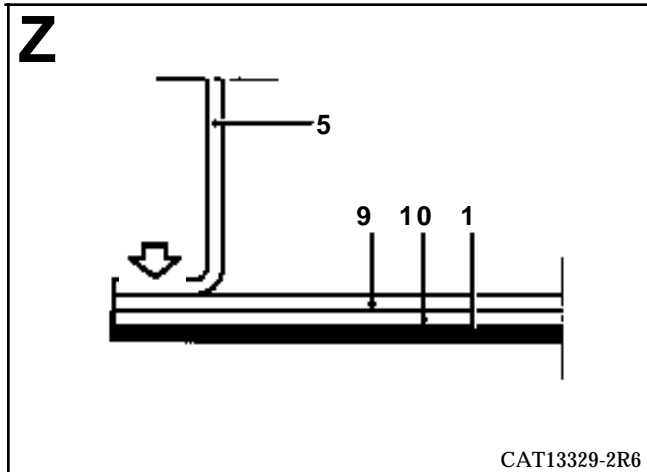
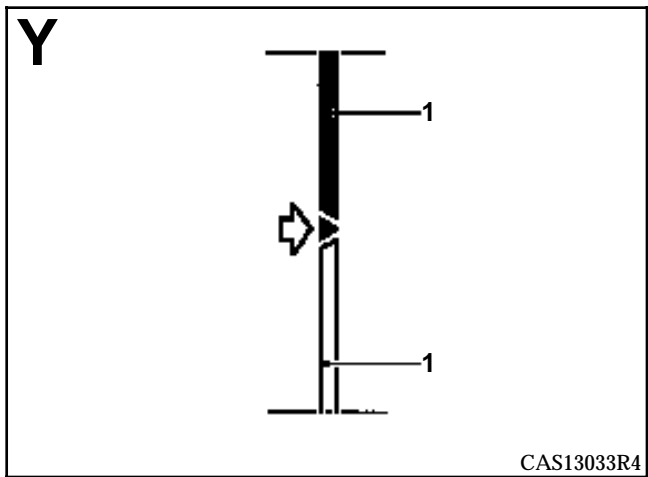
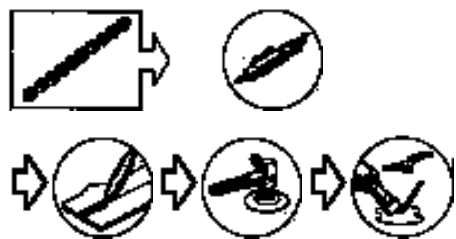
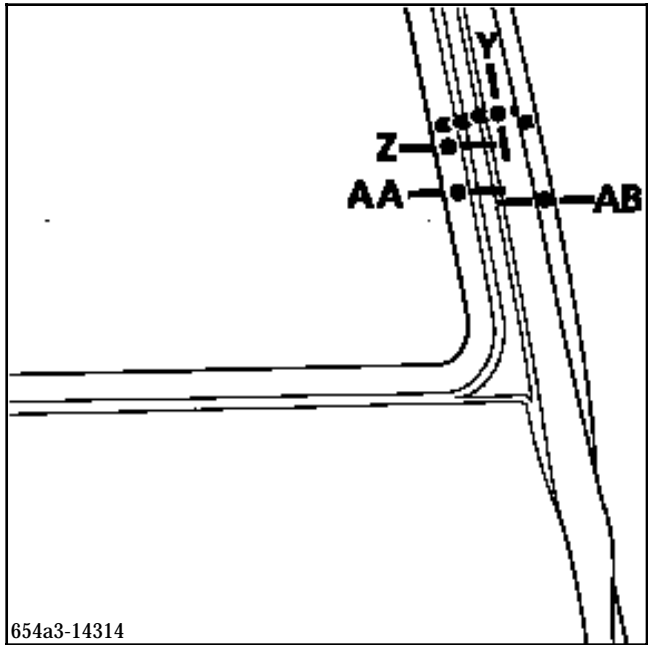


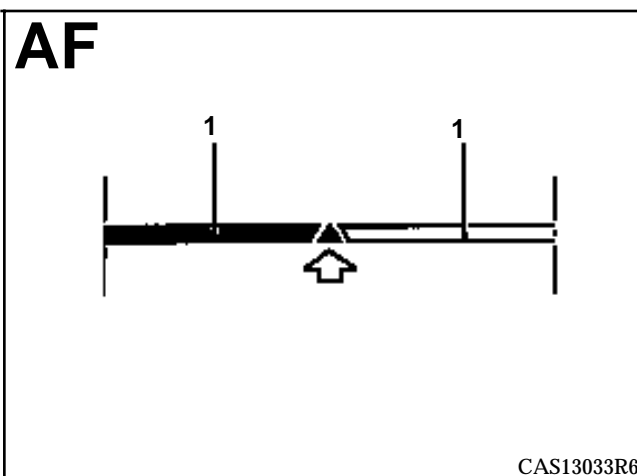
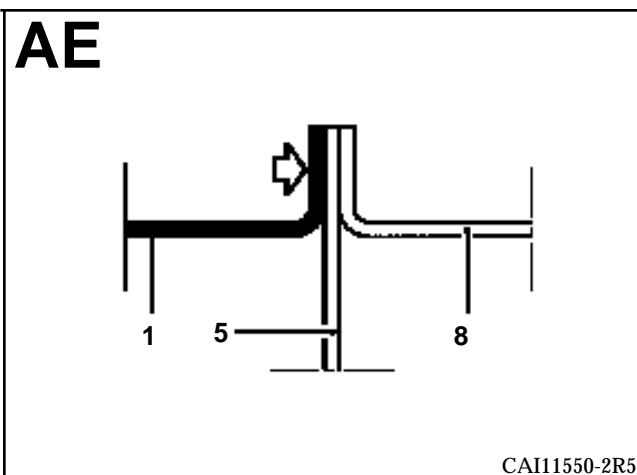
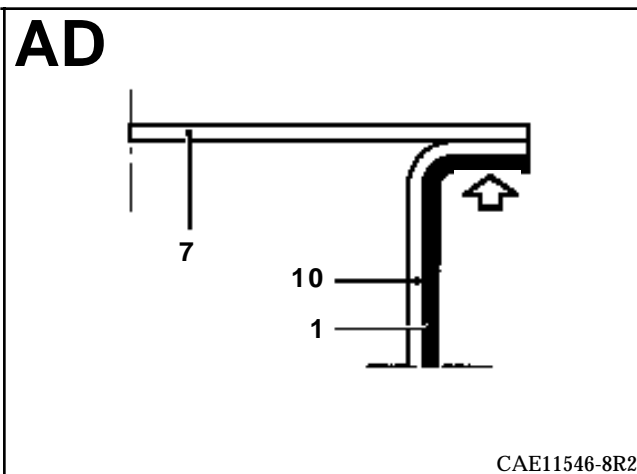
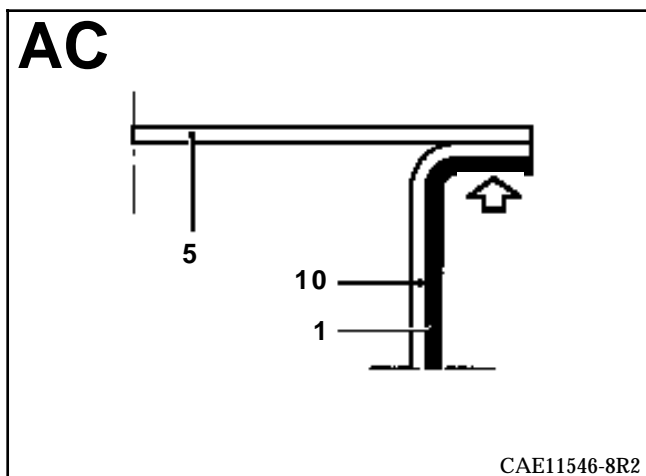
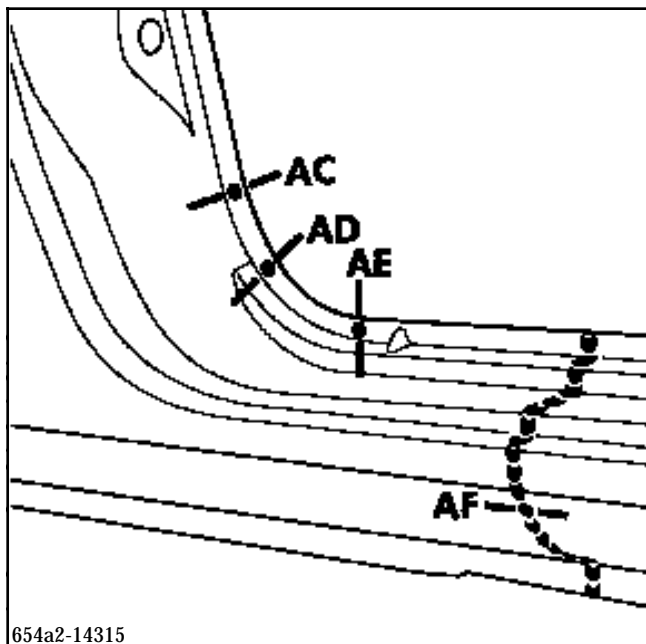


SPECIAL NOTE FOR VERSION C









INTRODUCTION

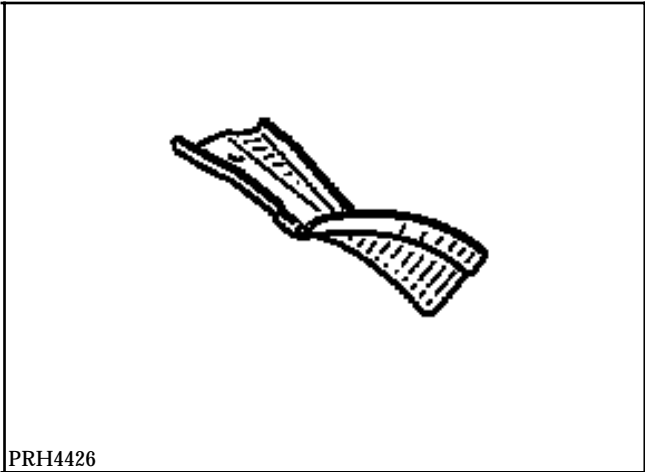
The replacement of this part is a complementary operation to the roof and to the rear wing panel.

In the operation described below there are only descriptions of the joints specific to the part concerned.

Information concerning the other parts will be dealt with in the respective section (see contents).

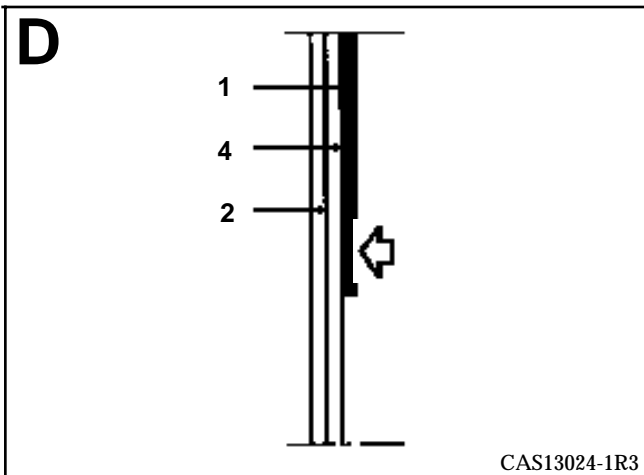
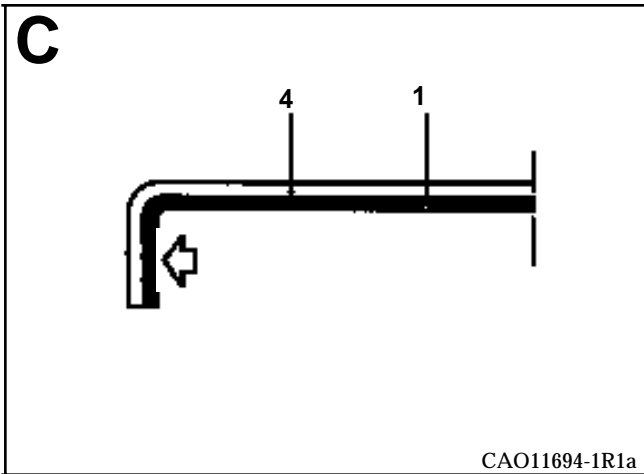
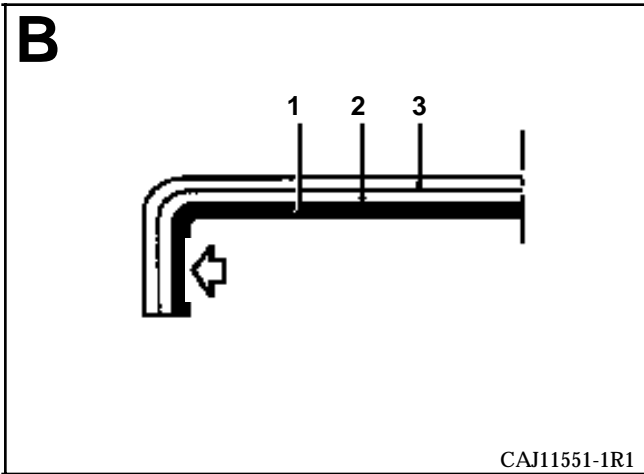
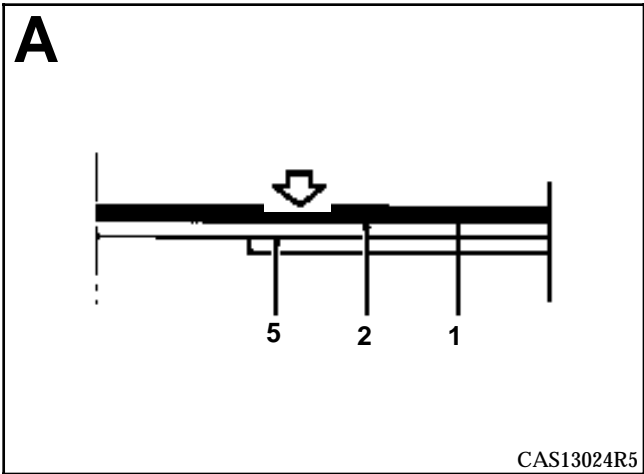
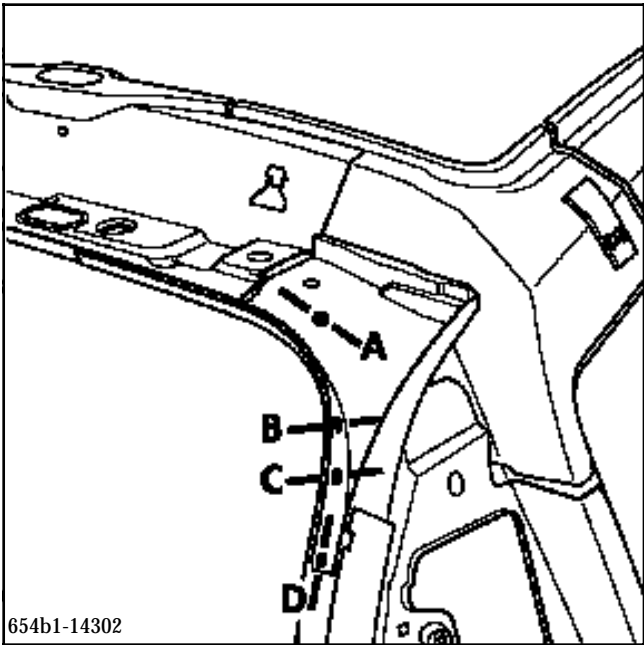
COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

Part only.



PARTS CONCERNED (thickness in mm):

1	Rear upper side rain channel	1
2	Rear lower side rain channel	0.7
3	Rear quarter panel upper rear reinforcement	1.2
4	Rear quarter panel lower rear reinforcement	1.2
5	Body side lining	0.7



INTRODUCTION

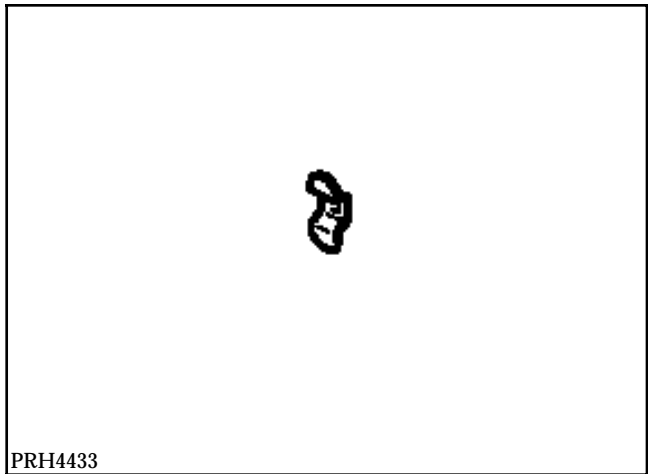
The replacement of this part is a basic operation for cases where the ball joint breaks.

In the operation described below there are only descriptions of the joints specific to the part concerned.

Information concerning the other parts will be dealt with in the respective section (see contents).

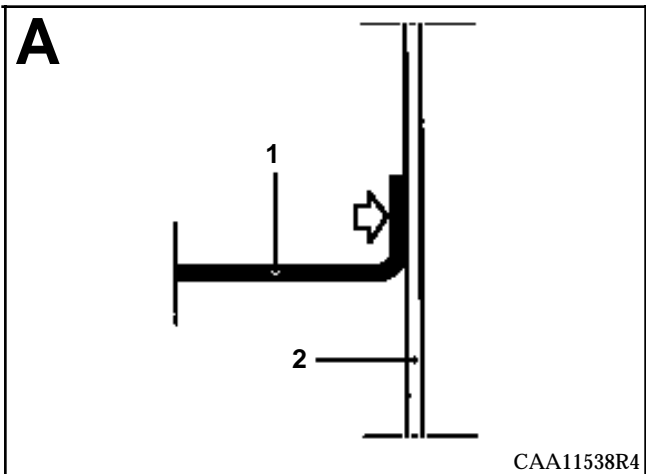
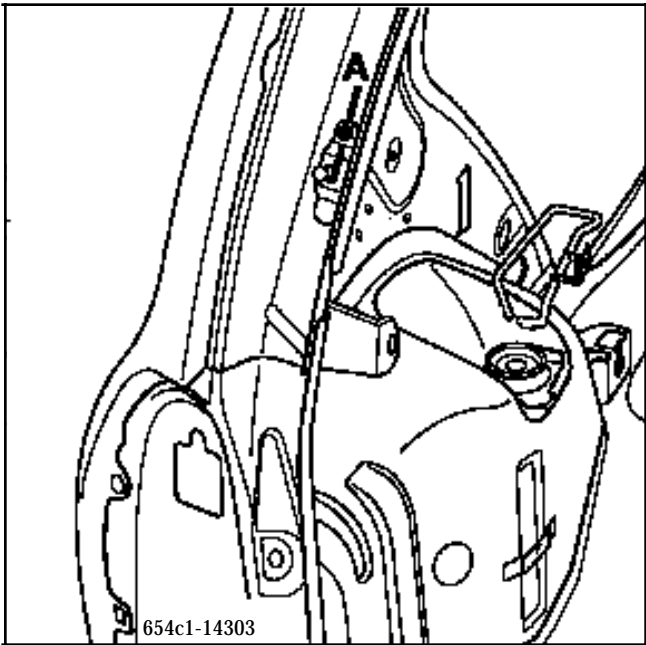
COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

Part only.



PARTS CONCERNED (thickness in mm):

1	Tailgate balancing ball joint	1.5
2	Rear lower side rain channel	0.7





**INTRODUCTION**

The replacement of this part is a complementary operation to the rear wing panel and lights mounting panel.

This operation is carried out partially (see cut and method below).

In the operation described below there are only descriptions of the joints specific to the part concerned.

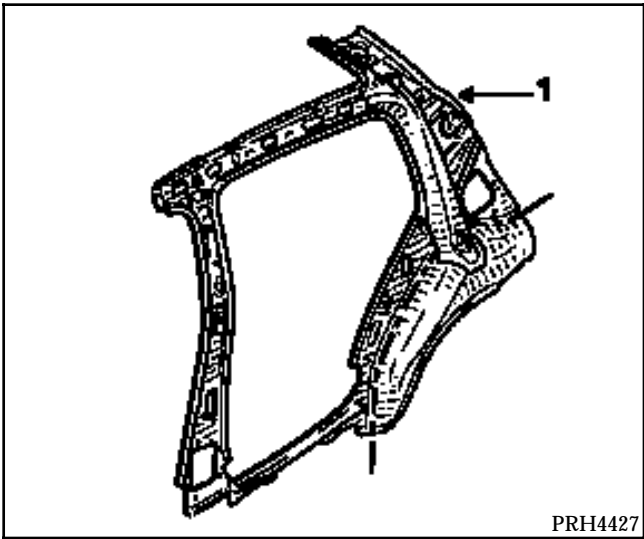
Information concerning the other parts will be dealt with in the respective section (see contents).

**COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT**

Part assembled with :

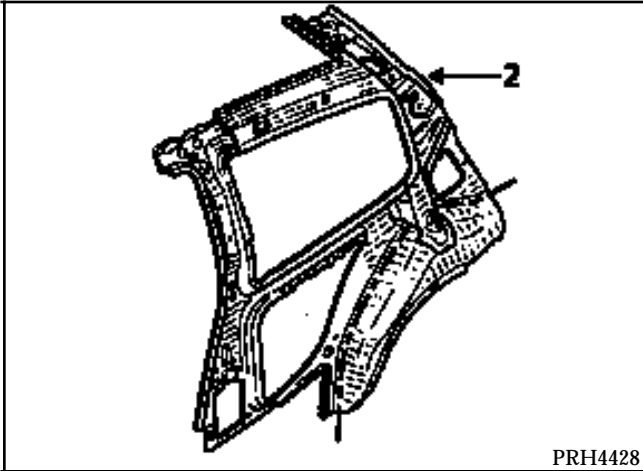
**VERSION B (1)**

- rear quarter panel lower reinforcement,
- rear quarter panel upper reinforcement,
- inflatable insert,
- rear quarter panel lining,
- seat belt mounting nuts.



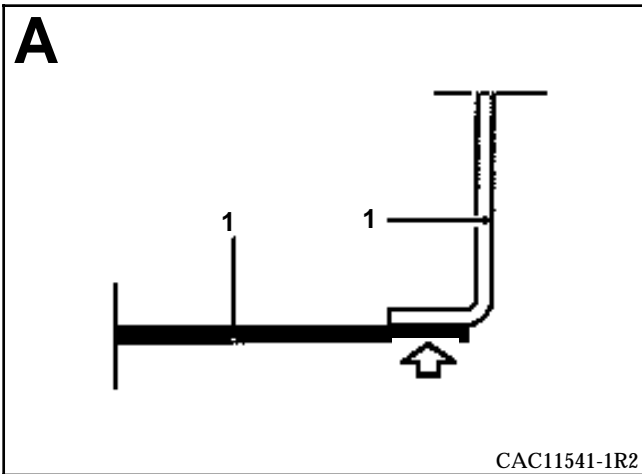
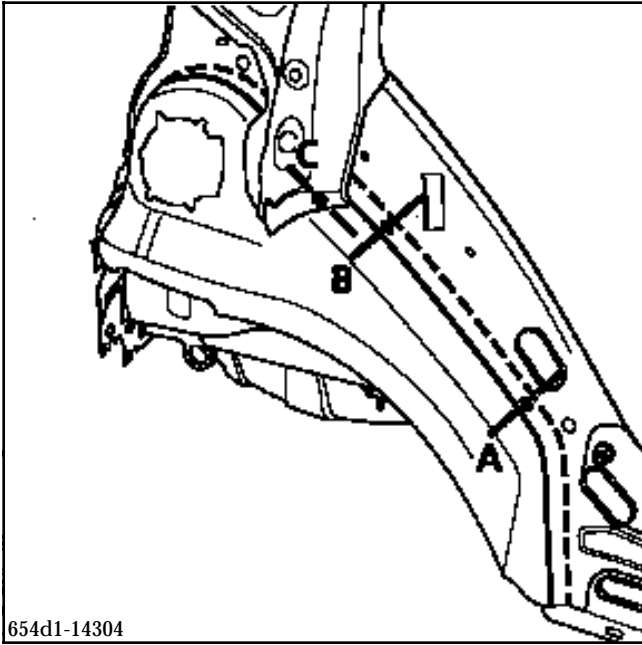
**VERSION C (2)**

- rear quarter panel lower reinforcement,
- rear quarter panel upper reinforcement,
- inflatable insert,
- rear quarter panel lining,
- seat belt mounting nuts,
- stretcher extension.

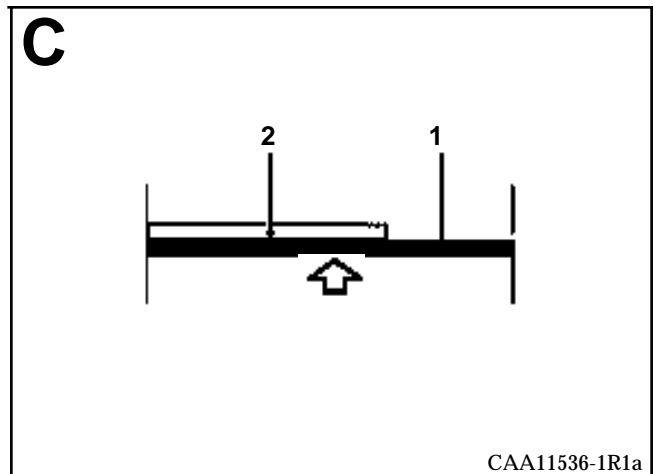
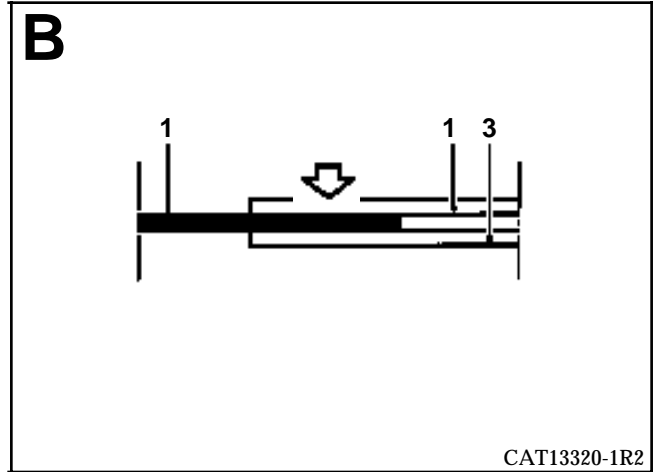


**PARTS CONCERNED (thickness in mm):**

1	Body side lining	0.7
2	Rear quarter panel lower rear reinforcement	1.2
3	Shock absorber cup height adjuster	1.5



**NOTE :** plug weld under the rear quarter panel lower reinforcement.



INTRODUCTION

The replacement of this part is a complementary operation to the body side lining, rear section and the lights mounting for a rear side impact.

In the operation described below there are only descriptions of the joints specific to the part concerned.

Information concerning the other parts will be dealt with in the respective section (see contents).

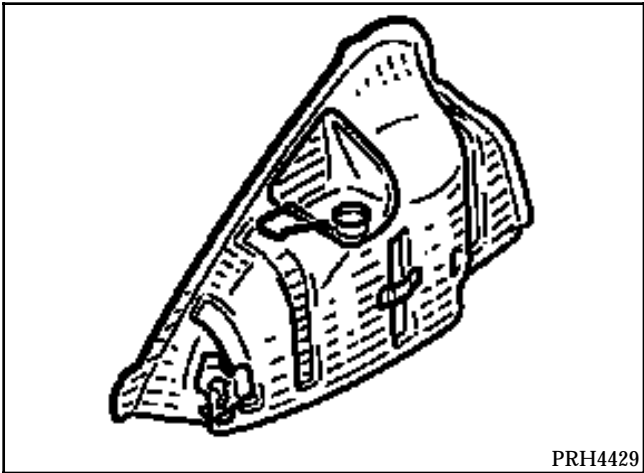
COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

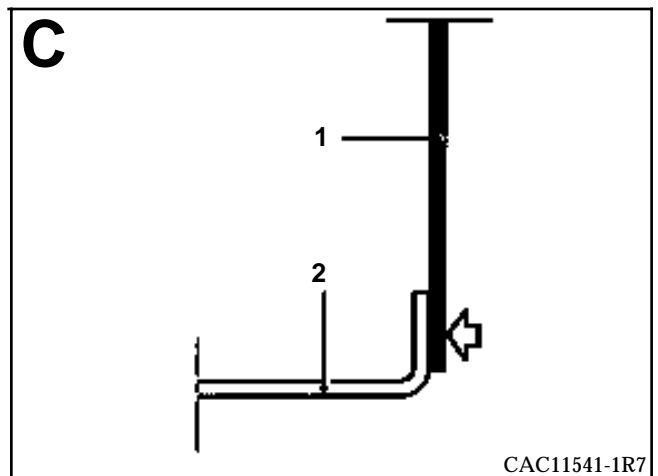
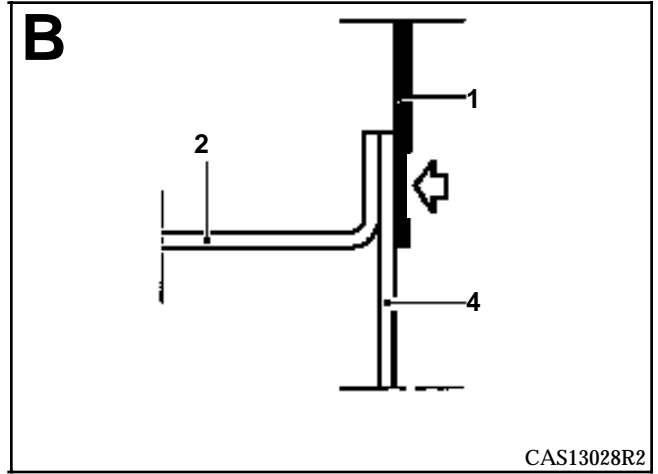
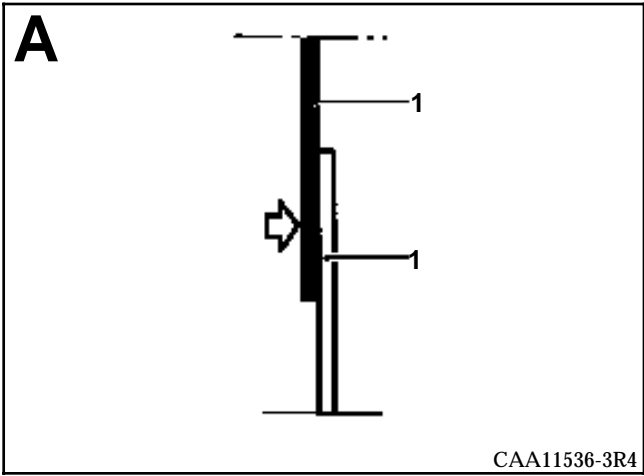
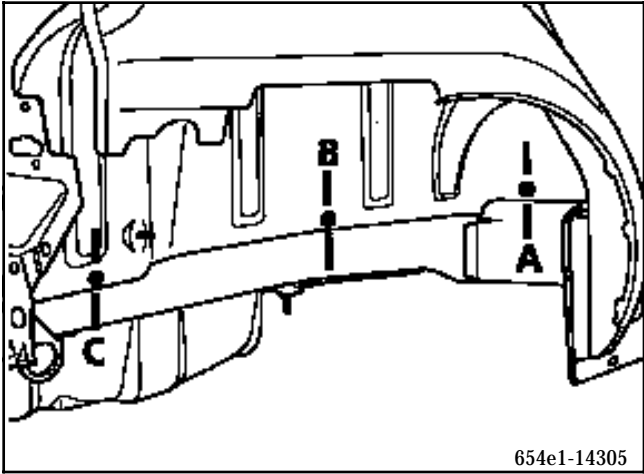
Part assembled with :

- shock absorber mounting cup,
- shock absorber mounting cup reinforcement,
- parcel shelf side mounting,
- shock absorber cup height adjuster,
- rear seat mounting hook,
- rear seat mounting.

PARTS CONCERNED (thickness in mm):

1	Rear inner wheel arch	0.8
2	Rear floor	0.7
3	Rear axle assembly mounting unit	1
4	Rear side member	1.2





INTRODUCTION

The replacement of this part is a complementary operation to the rear wing panel.

This operation is carried out partially (see cut and method below).

The method below deals with the special features of versions B and C. In both cases, the upper rain channel will have to be ordered separately.

In the operation described below there are only descriptions of the joints specific to the part concerned.

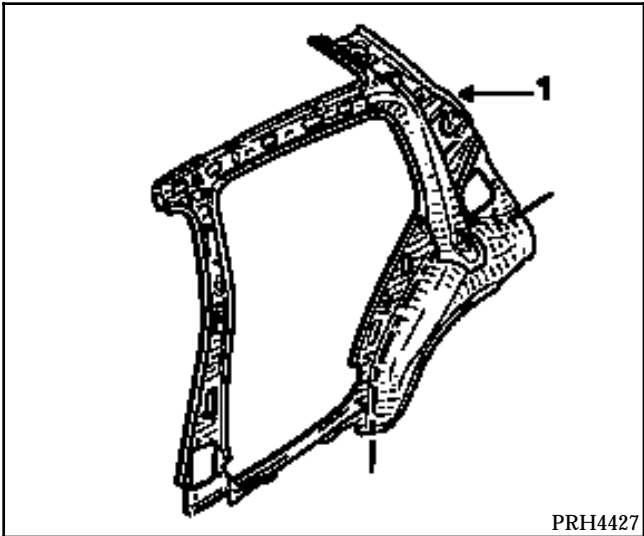
Information concerning the other parts will be dealt with in the respective section (see contents).

COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

Part assembled with :

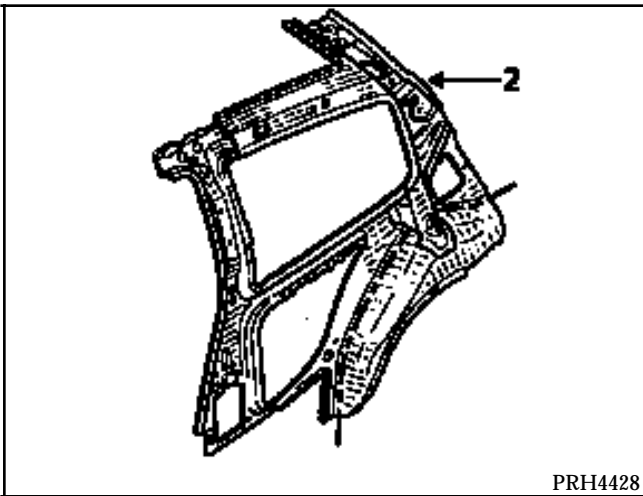
VERSION B (1)

- rear quarter panel lower reinforcement,
- rear quarter panel upper reinforcement,
- inflatable insert,
- rear quarter panel lining,
- seat belt mounting nuts.



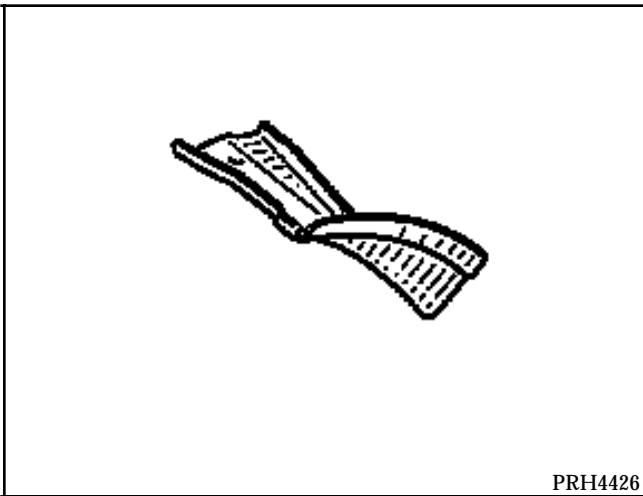
VERSION C (2)

- rear quarter panel lower reinforcement,
- rear quarter panel upper reinforcement,
- inflatable insert,
- rear quarter panel lining,
- seat belt mounting nuts,
- stretcher extension.



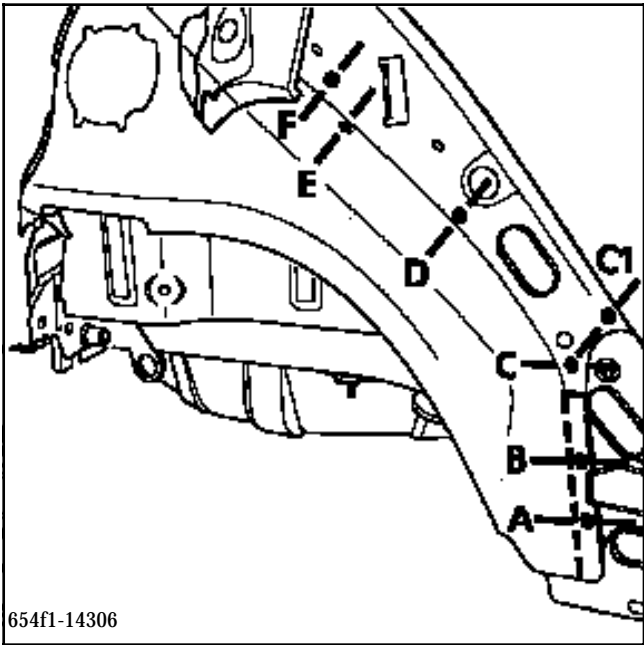
Upper rain channel

Part only.

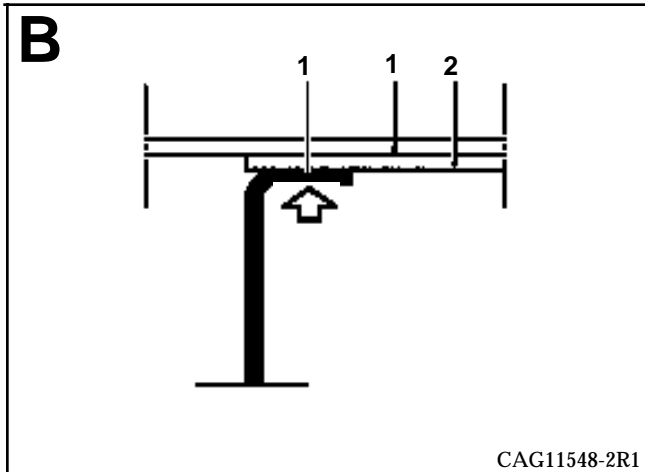
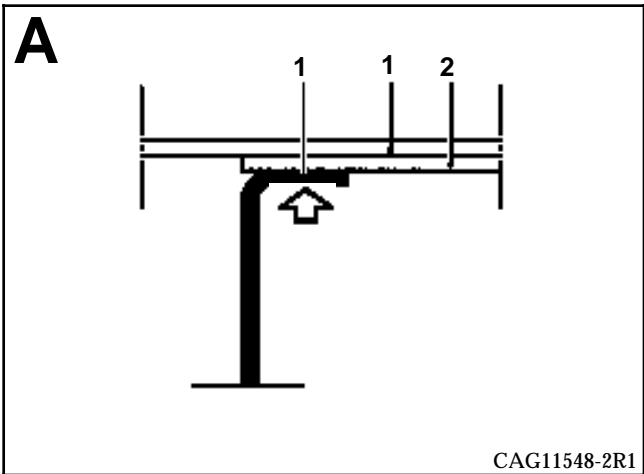


PARTS CONCERNED (thickness in mm):

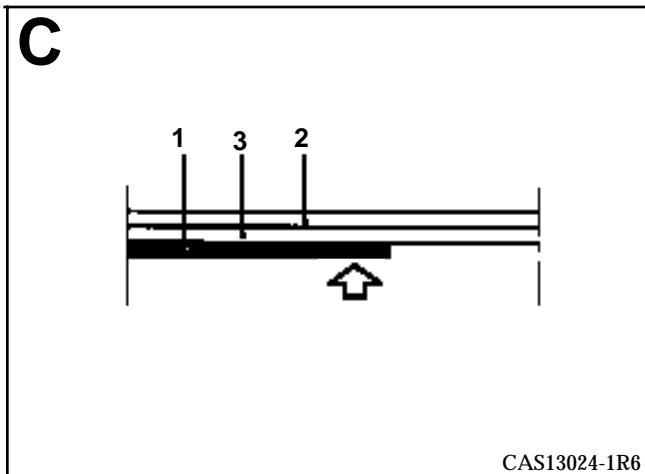
1	Body side lining	0.7
2	Sill panel reinforcement	1
3	Rear inner wheel arch	0.8
4	Shock absorber cup height adjuster	1.5
5	Rear upper side rain channel	1
6	Rear quarter panel lower rear reinforcement	1.2
7	Rear quarter panel upper rear reinforcement	1.2
8	Roof rear cross member	1
9	Sill panel closure panel	1



654f1-14306



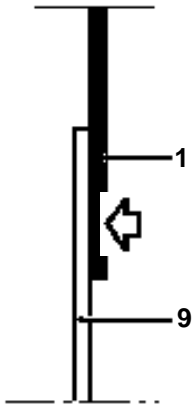
CAG11548-2R1



CAS13024-1R6



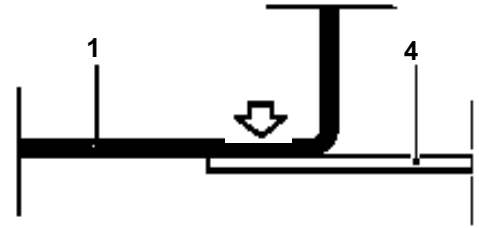
### C1



CAA11536-2R3



### E



CAR11700-1R1



### D



CAQ11697R5a

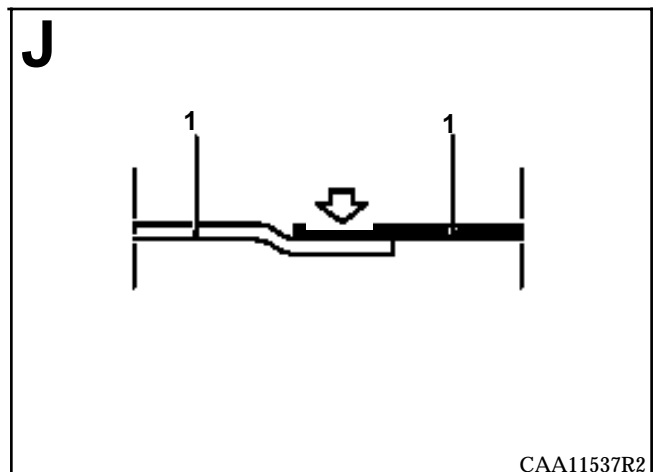
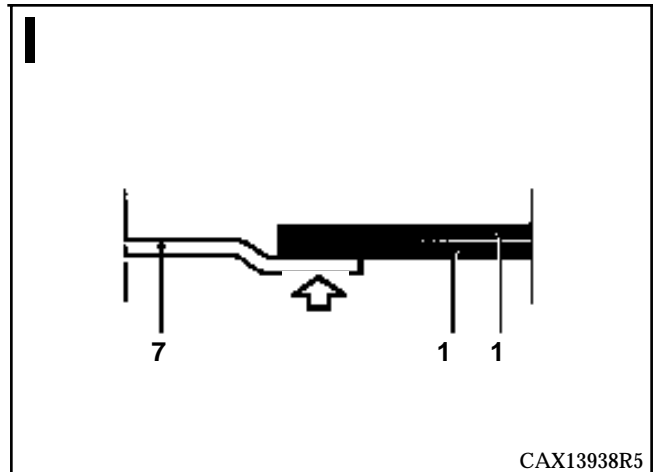
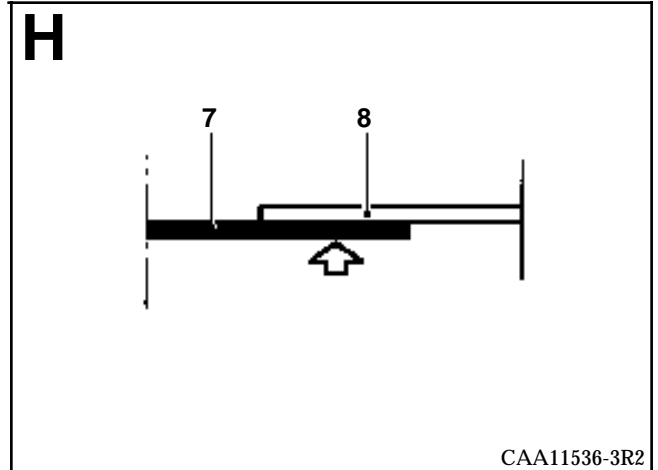
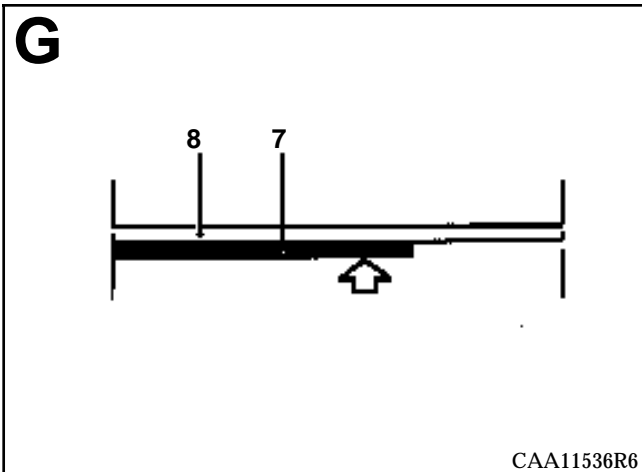
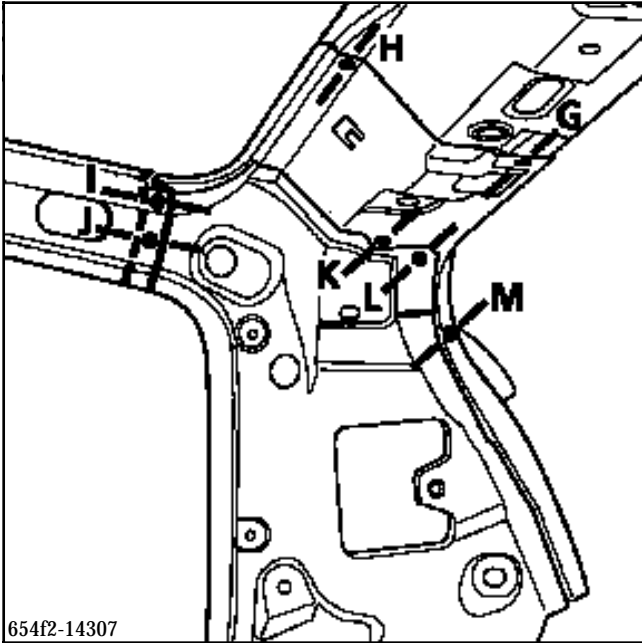


### F

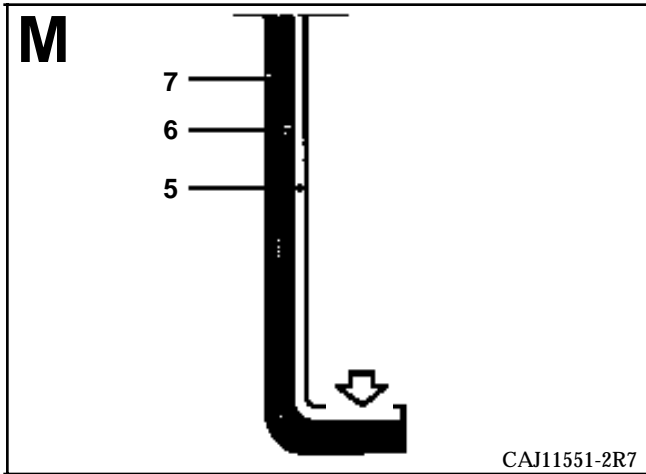
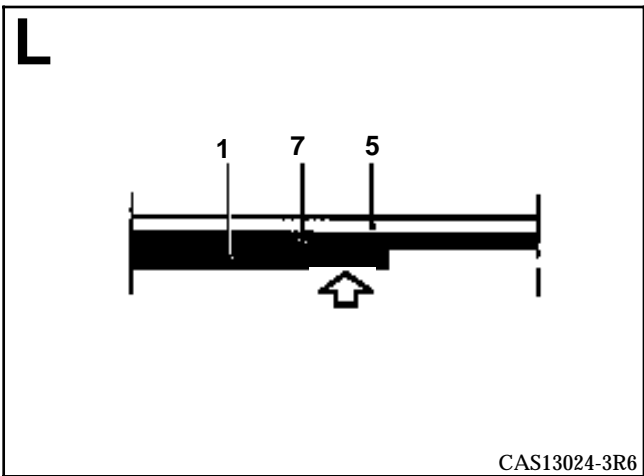
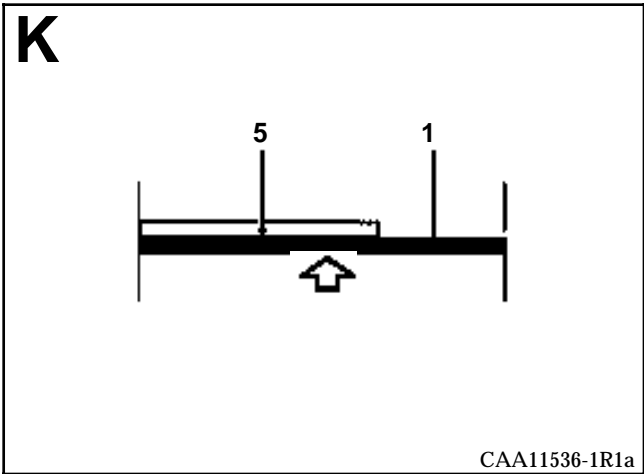


CAT13326-1R7

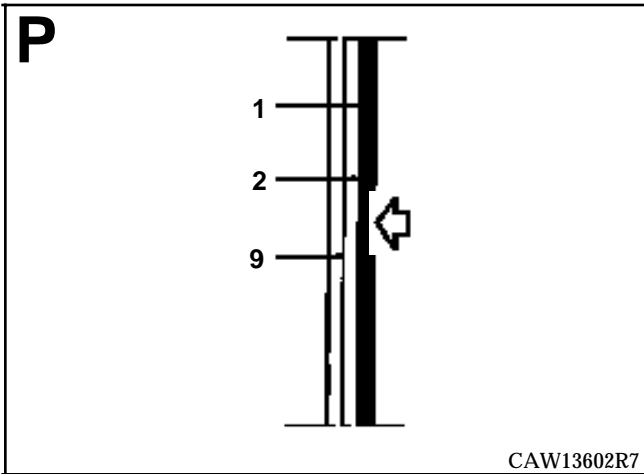
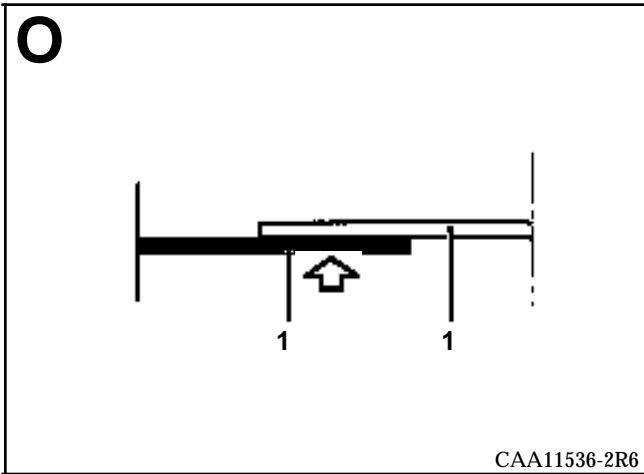
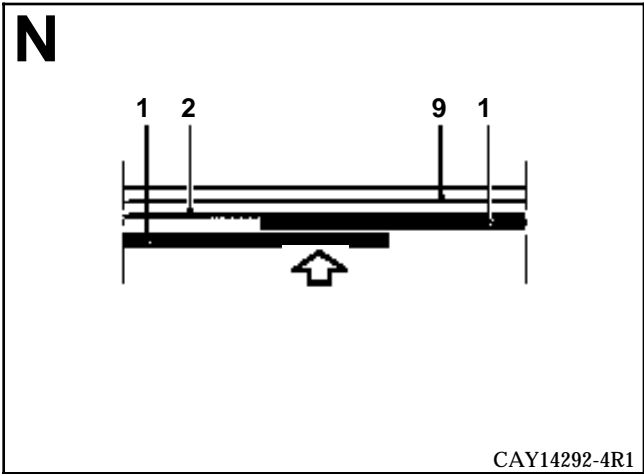
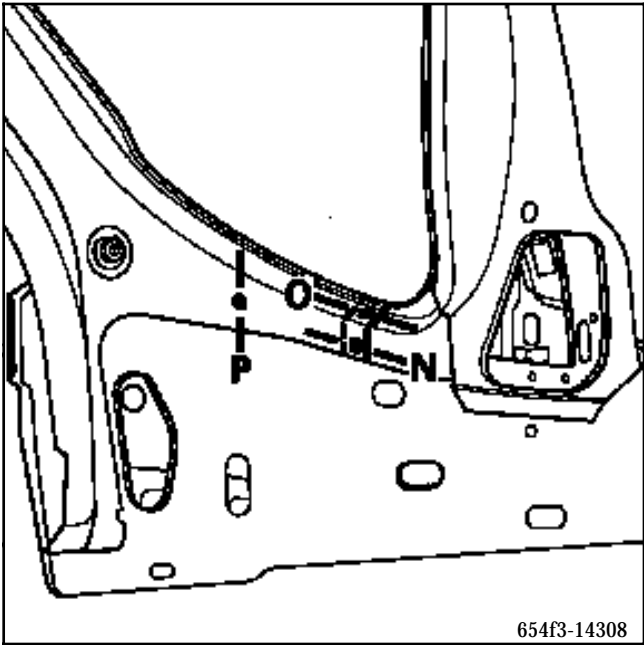


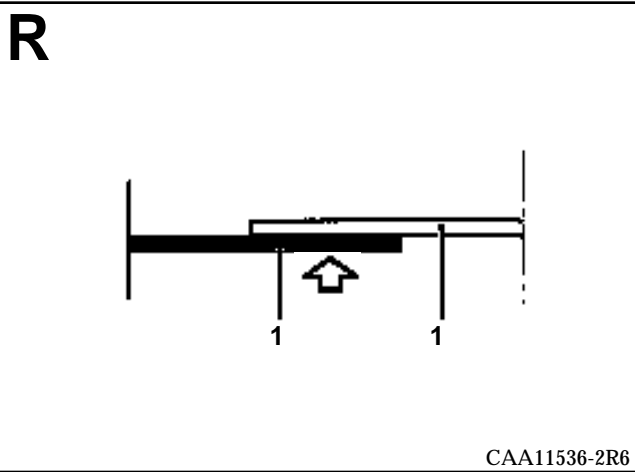
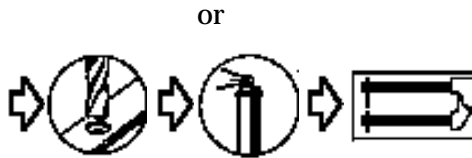
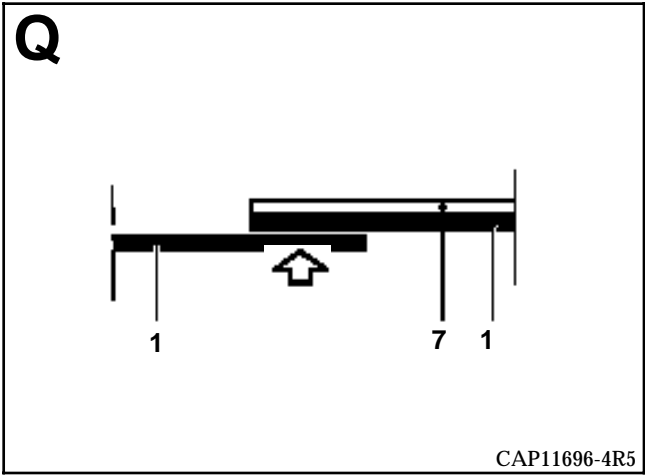
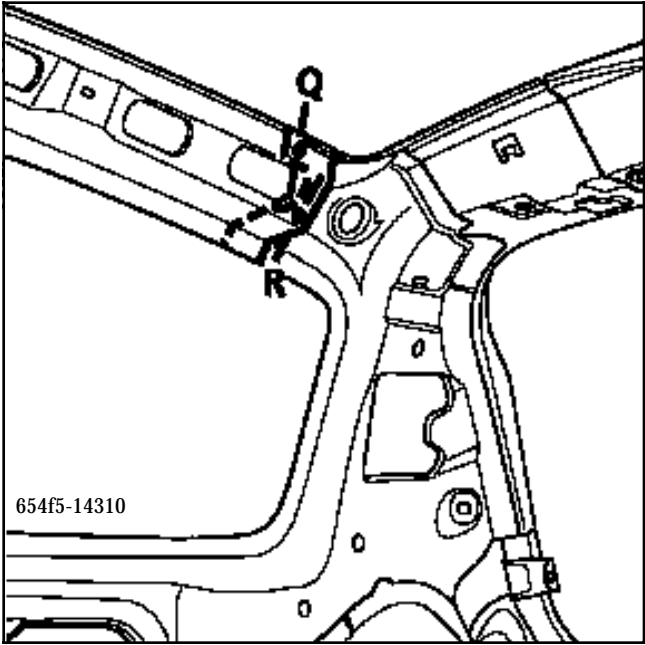






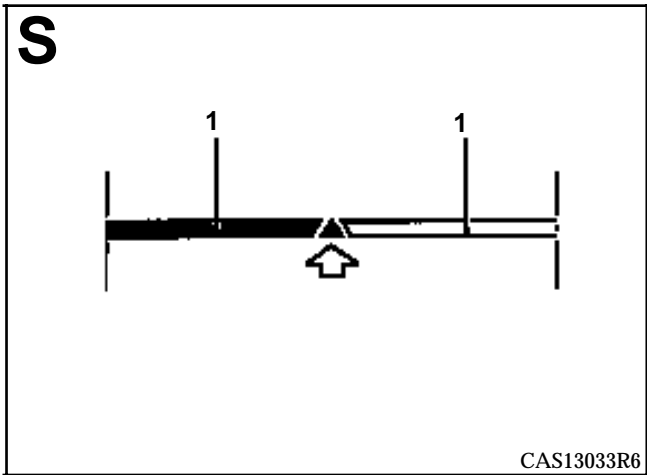
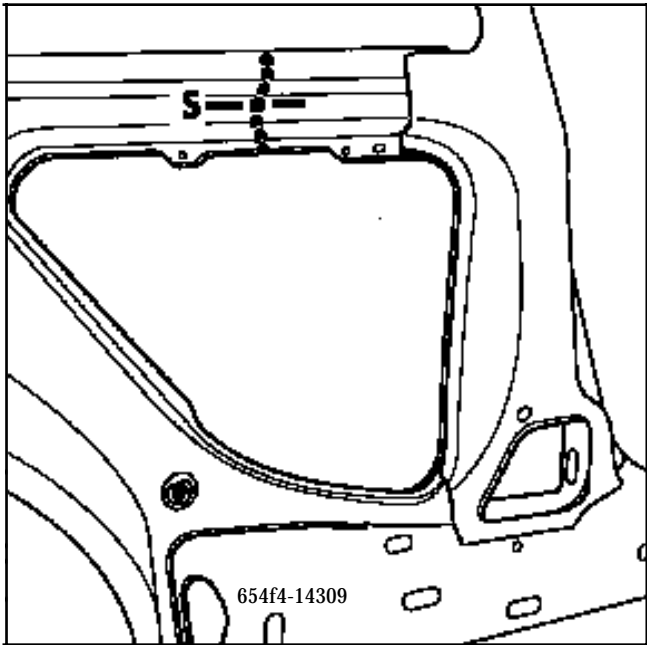
SPECIAL FEATURES OF VERSION C





or





INTRODUCTION

The replacement of this part is a basic operation for a rear impact.

In the operation described below there are only descriptions of the joints specific to the part concerned.

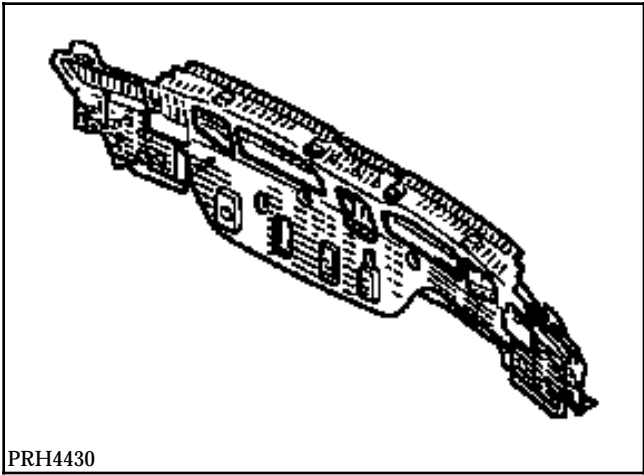
Information concerning other parts will be dealt with in the respective section (see contents).

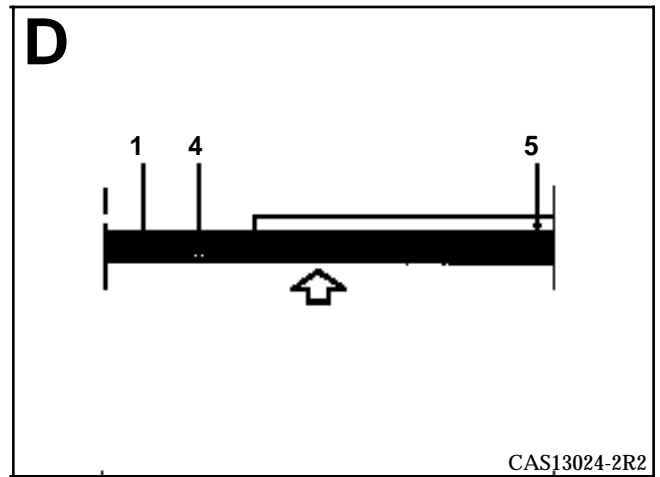
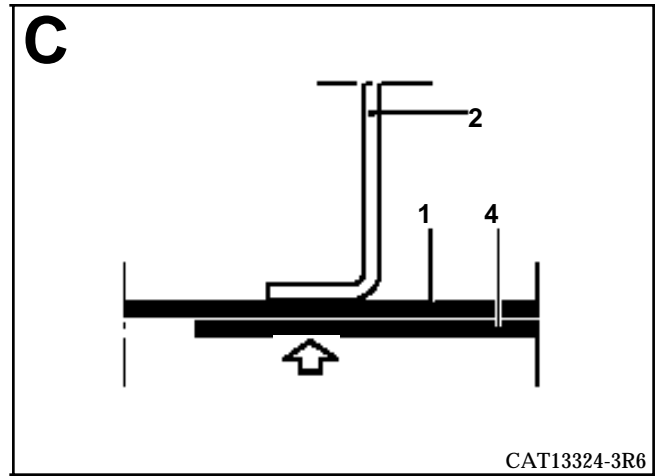
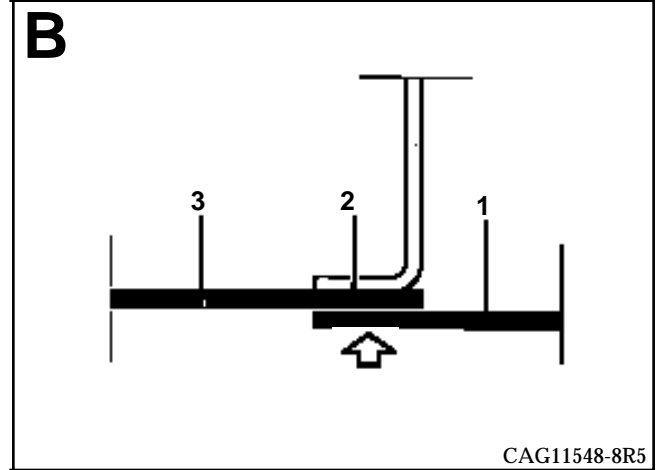
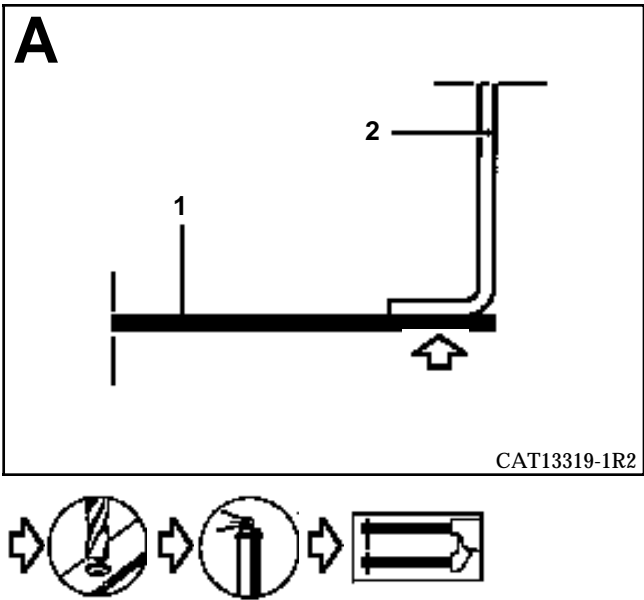
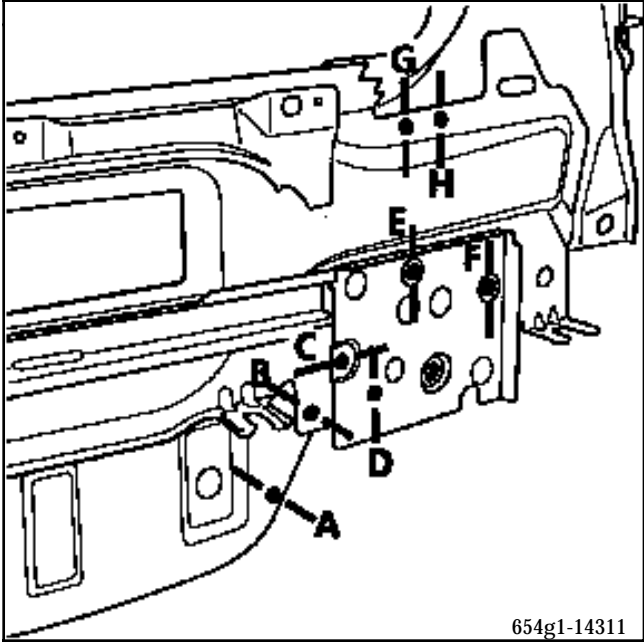
COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

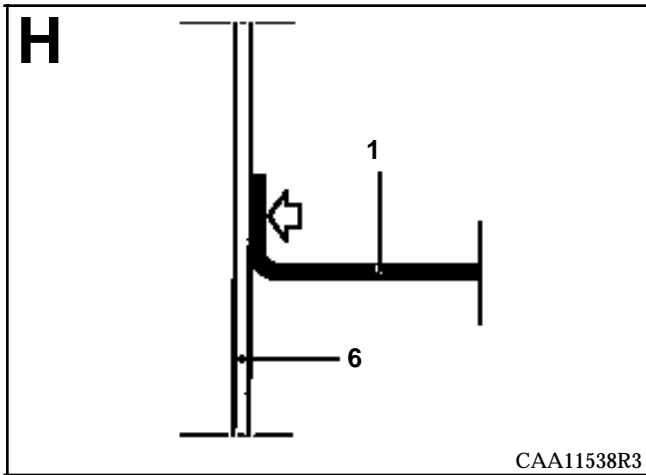
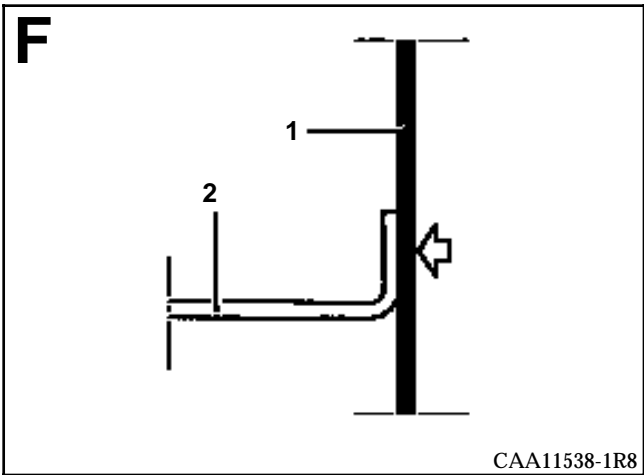
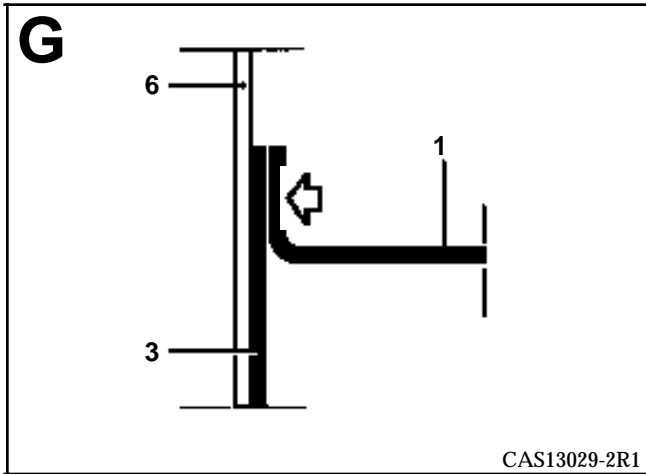
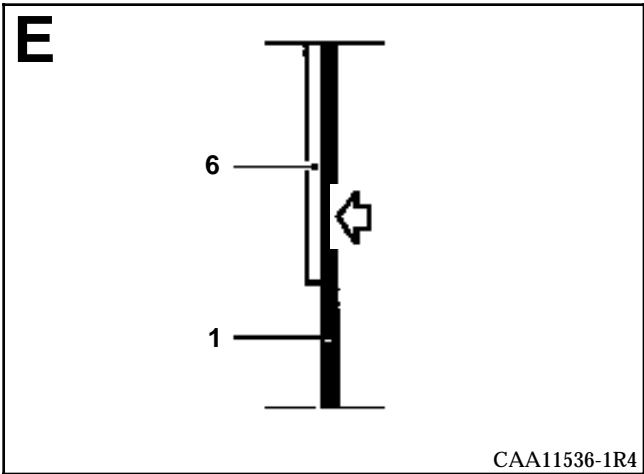
- Part assembled with :
- rear end panel lining,
  - rear end panel striker plate reinforcement,
  - bumper support corner plate,
  - absorber mounting,
  - bumper mounting support corner plate

PARTS CONCERNED (thickness in mm):

1	Rear end panel	1
2	Rear floor	0.7
3	Rear end panel lining	0.7
4	Absorber mounting	1.2
5	Rear side member	1.2
6	Lights mounting	1







INTRODUCTION

The replacement of this part is a complementary operation :

- to the rear end panel for a rear impact, for this operation, the rain channel on the Parts Department part will have to be removed,
- to the wing panel for a rear side impact.

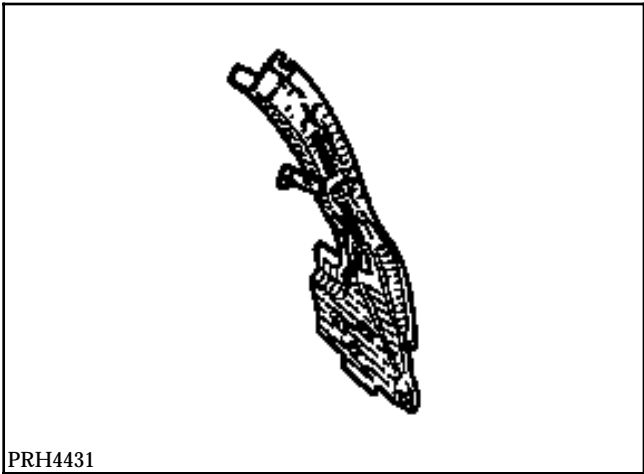
This operation is carried out partially (see method below).

For the complementary operation to the rear end panel, the lower rear side rain channel will have to be removed according to (X) below, keeping the lower parcel shelf mounting.

COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

Part assembled with :

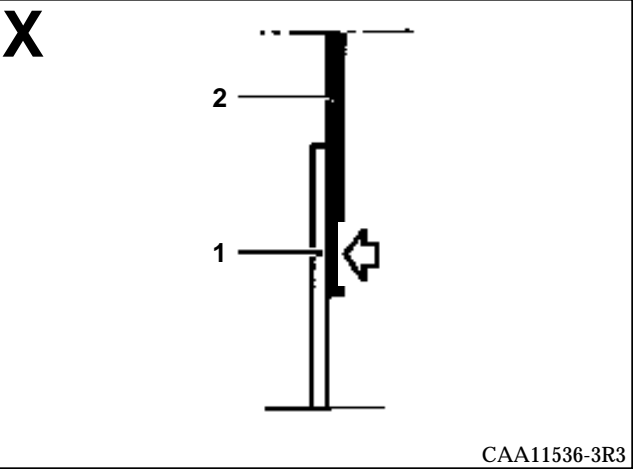
- rear lower side rain channel,
- parcel shelf lower mounting,
- balancing reinforcement (ball joint mounting support),
- balancing ball joint.



PRH4431

PARTS CONCERNED (thickness in mm):

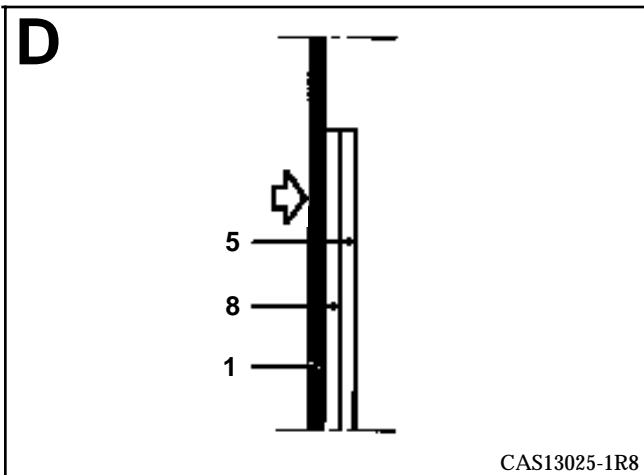
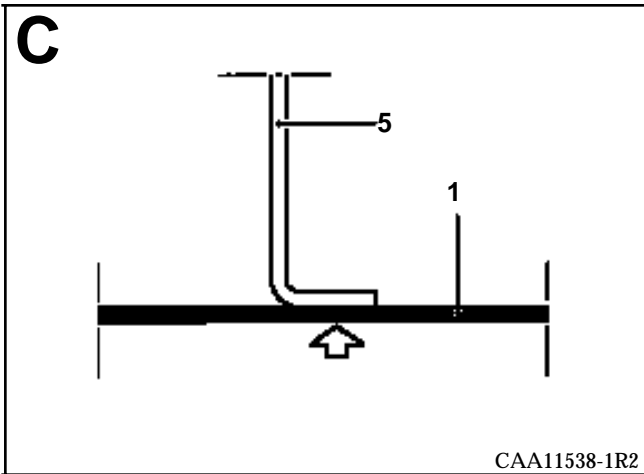
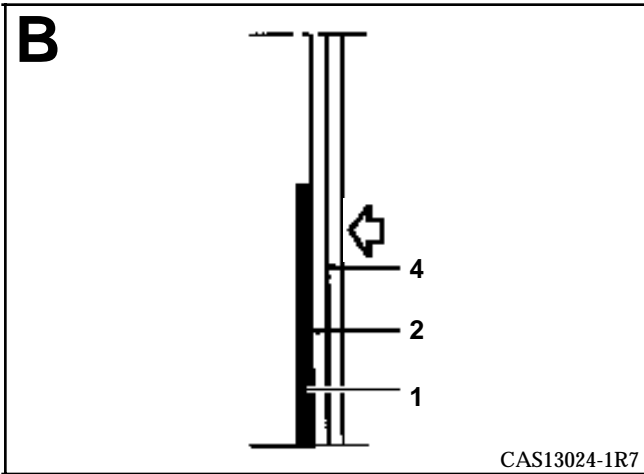
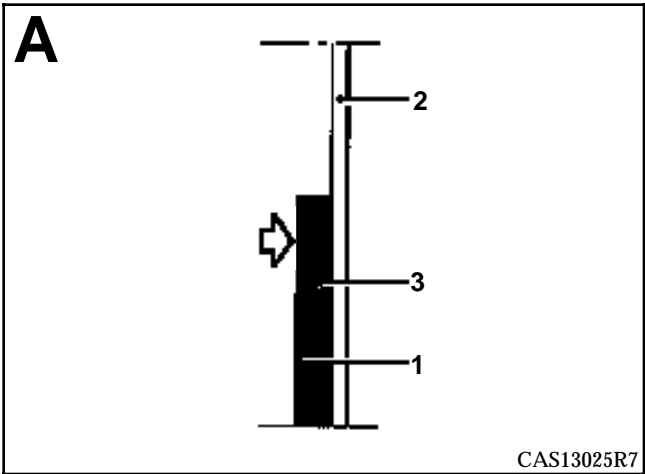
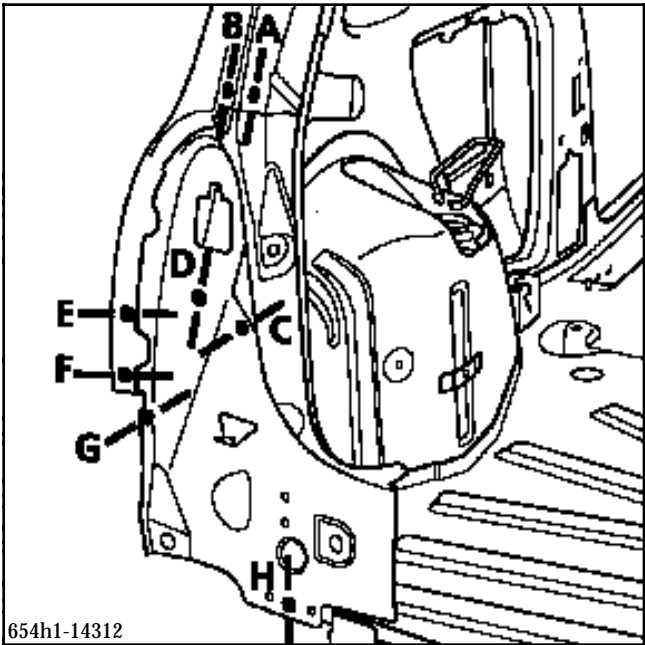
1	Lights mounting	1
2	Rear lower side rain channel	0.7
3	Parcel shelf lower mounting	1
4	Rear wing panel	0.8
5	Wheel arch	0.8
6	Absorber mounting	1.2
7	Rear bumper mounting side reinforcement	1.2
8	Rear quarter panel lining	0.7
9	Rear floor	0.7
10	Rear quarter panel lower rear reinforcement	1.2
11	Rear upper side rain channel	1

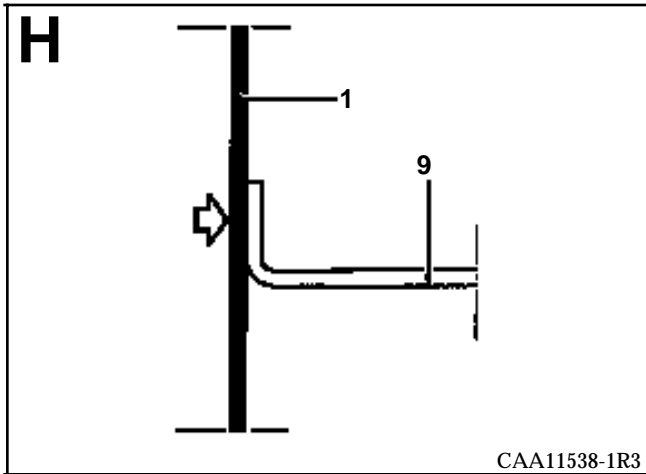
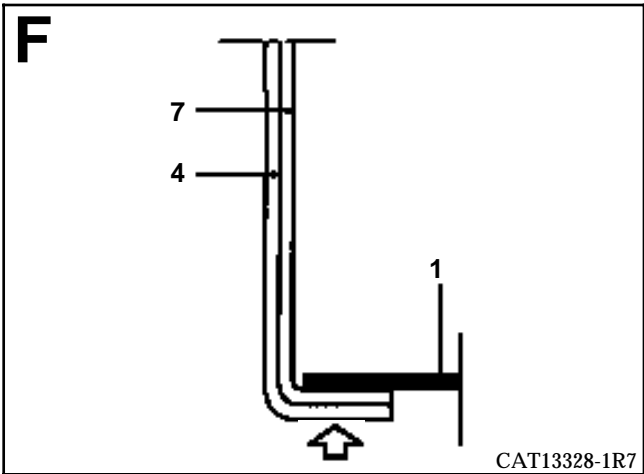
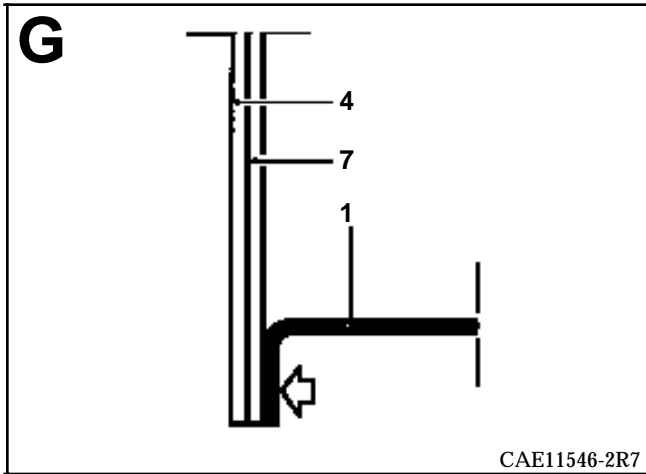
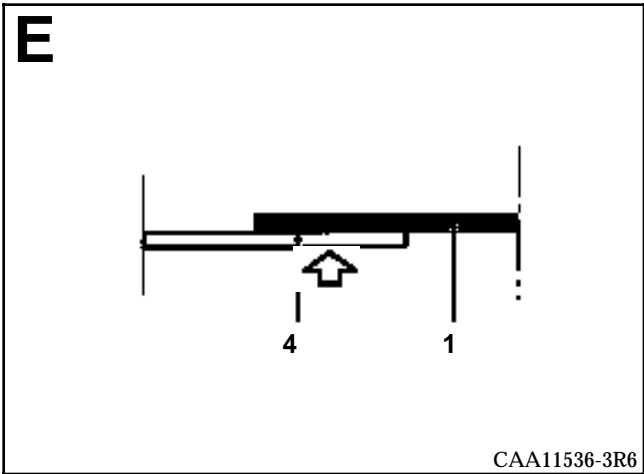


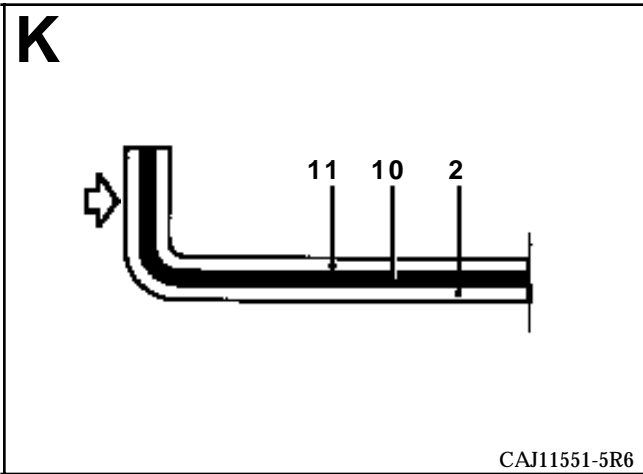
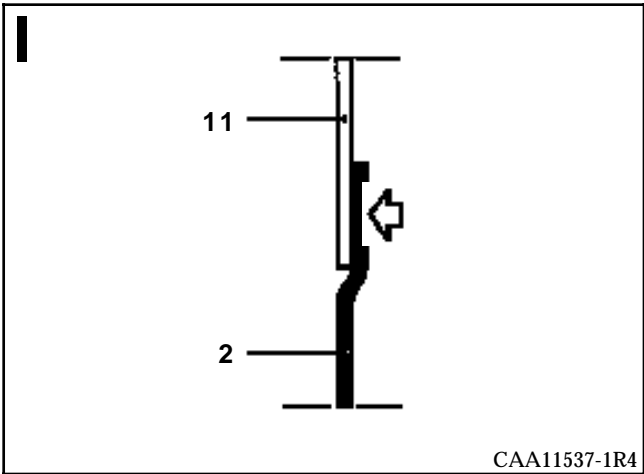
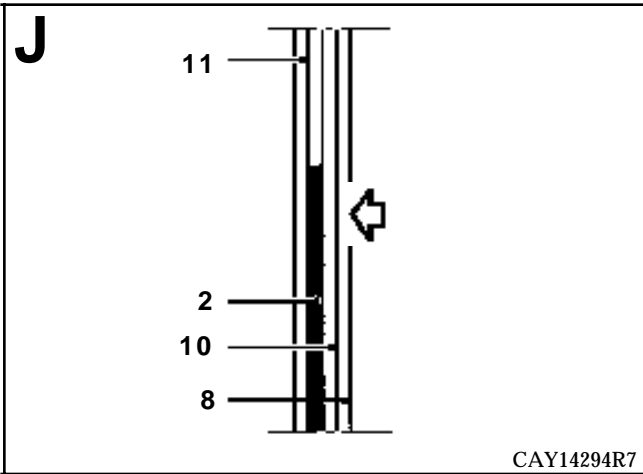
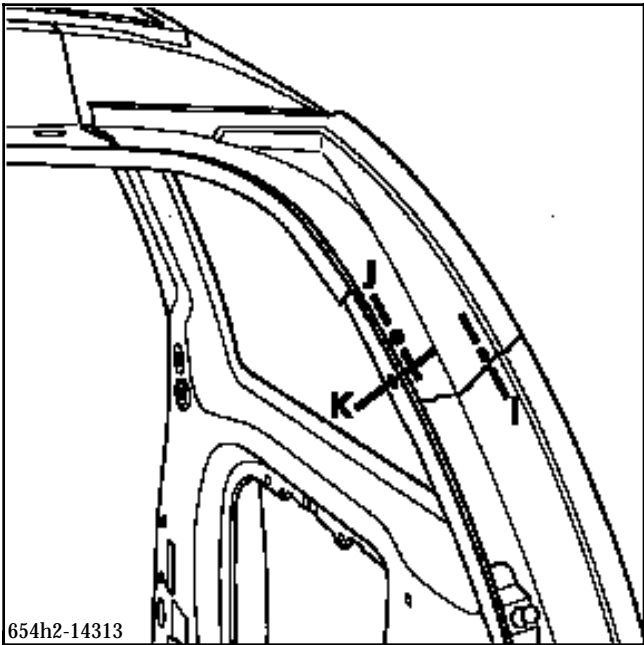
CAA11536-3R3











## INTRODUCTION

The replacement of this part is a basic operation.

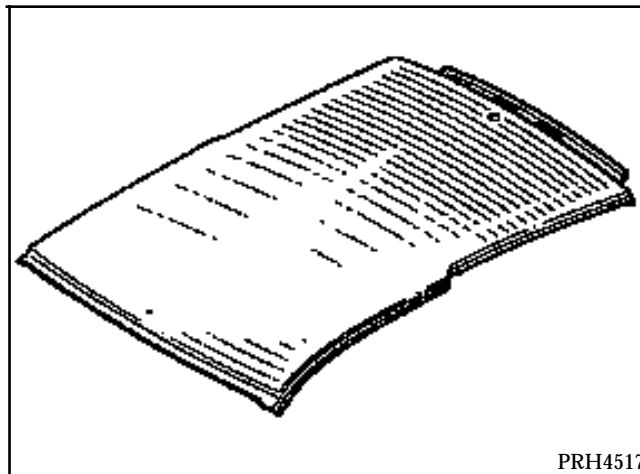
In the operation described below there are only descriptions of the joints specific to the part concerned.

Information concerning other parts will be dealt with in the respective section (see contents).

## COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

Part assembled with :

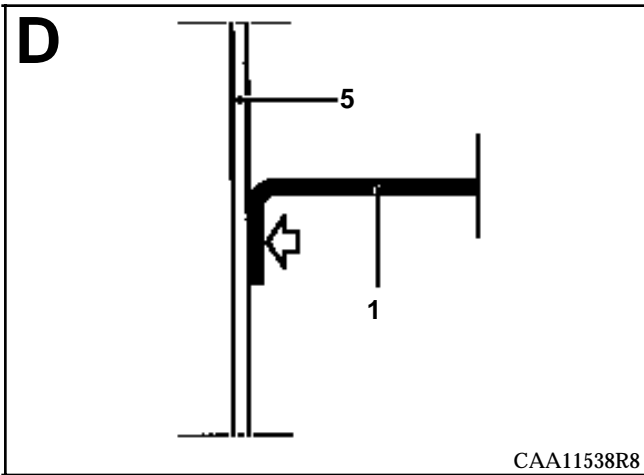
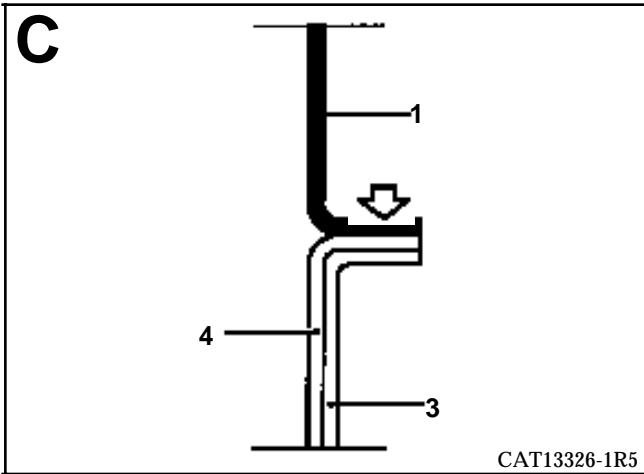
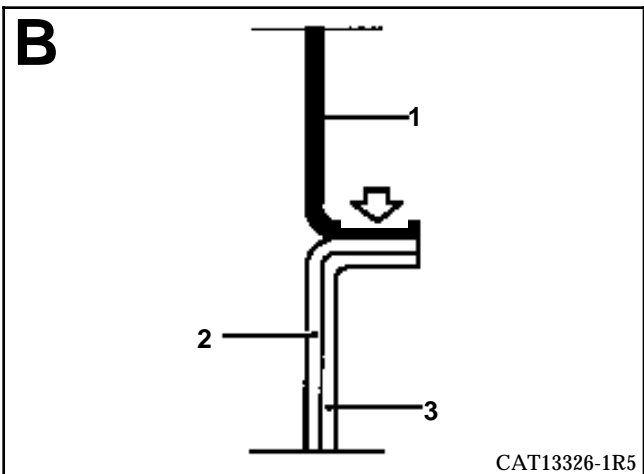
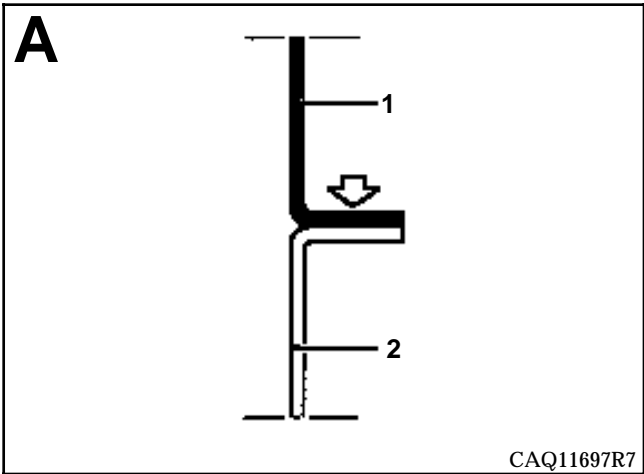
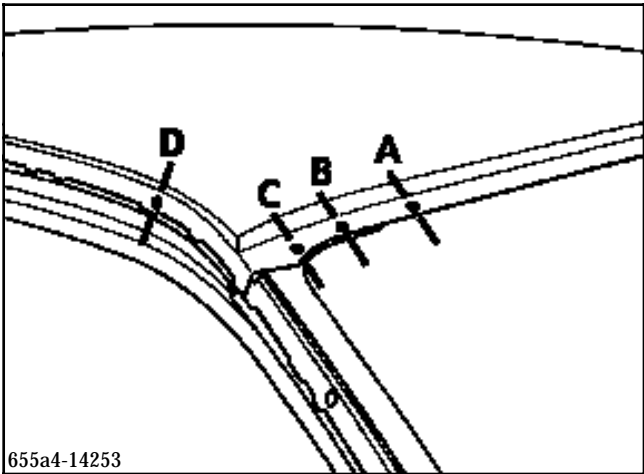
- soundproofing,
- earthing washer.

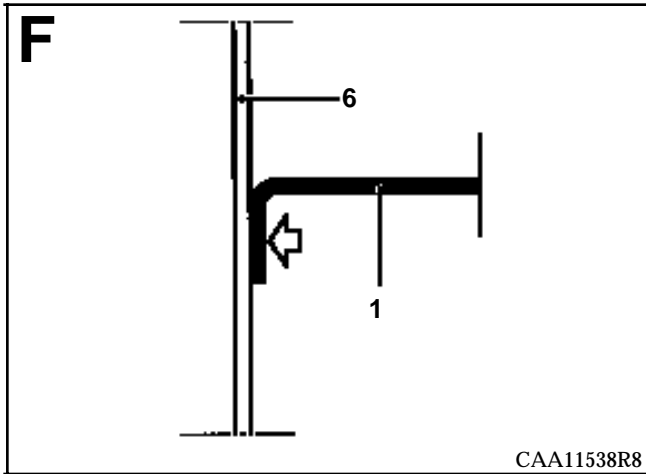
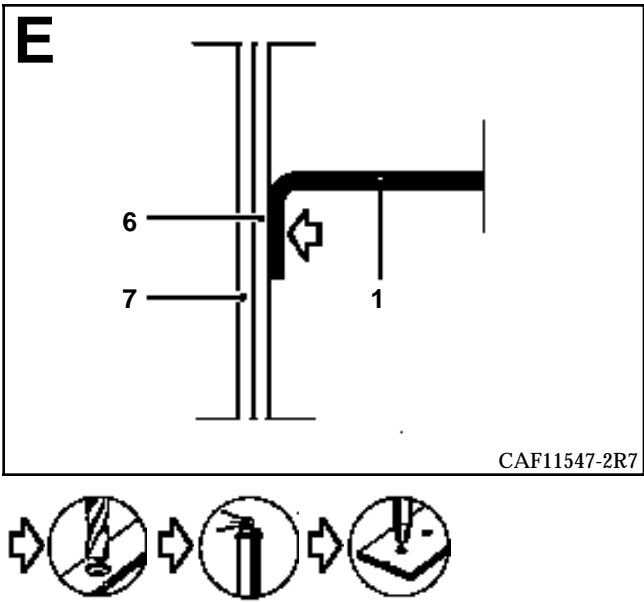
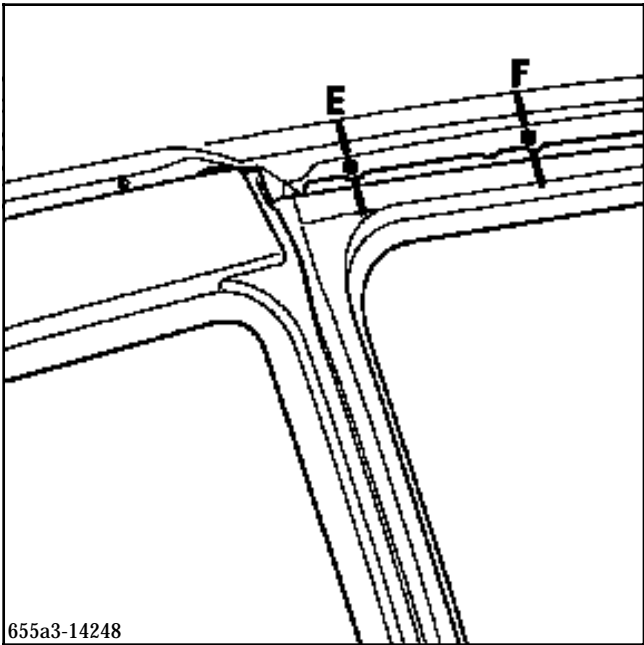


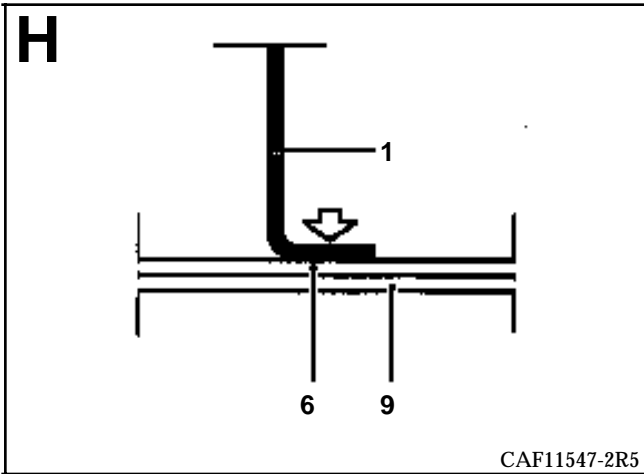
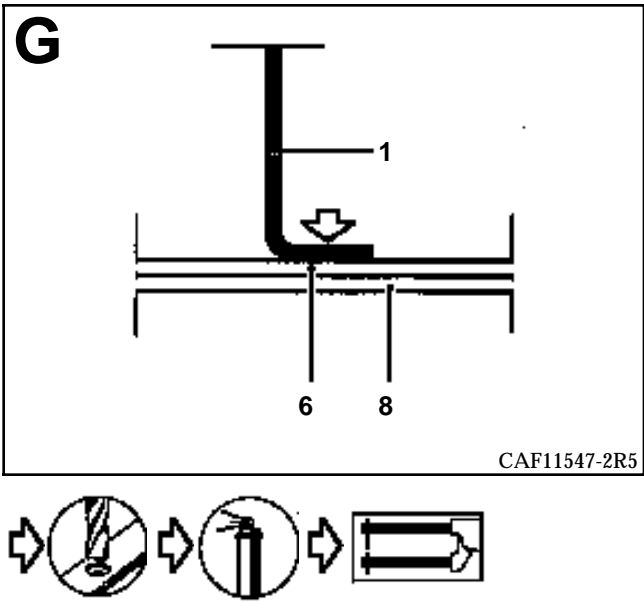
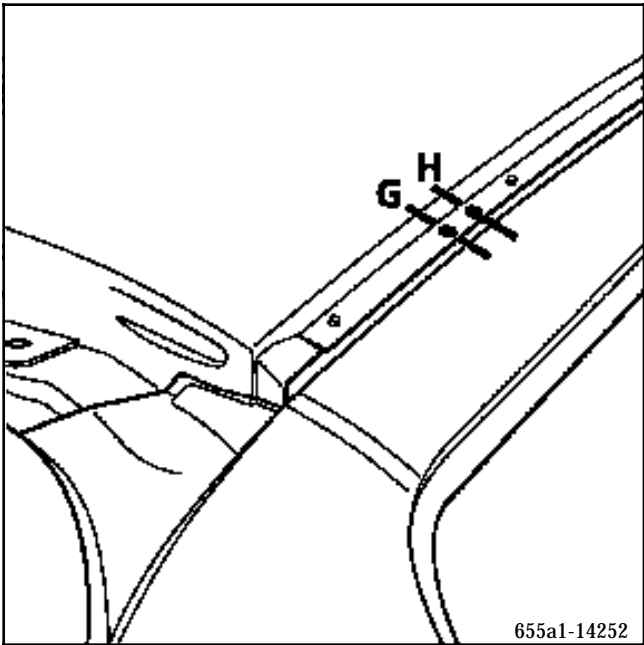
PRH4517

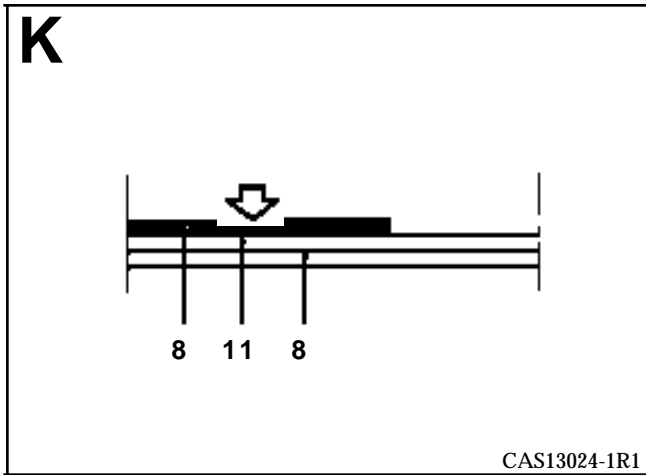
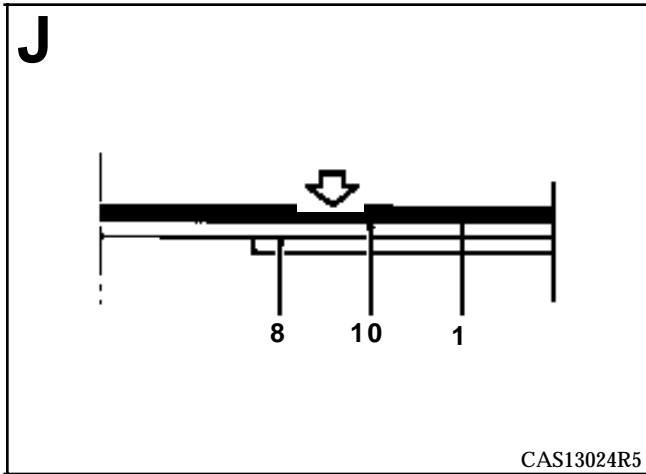
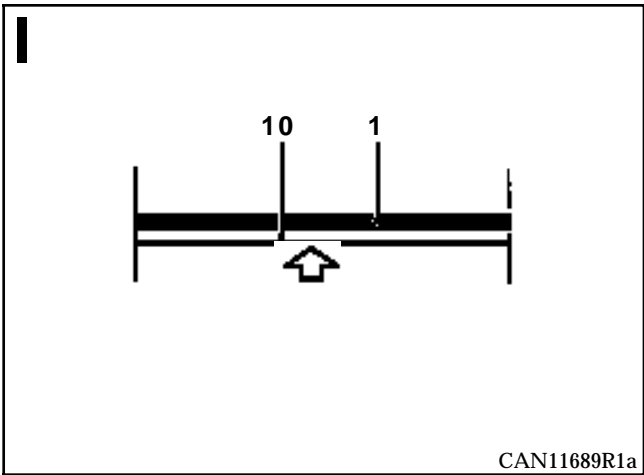
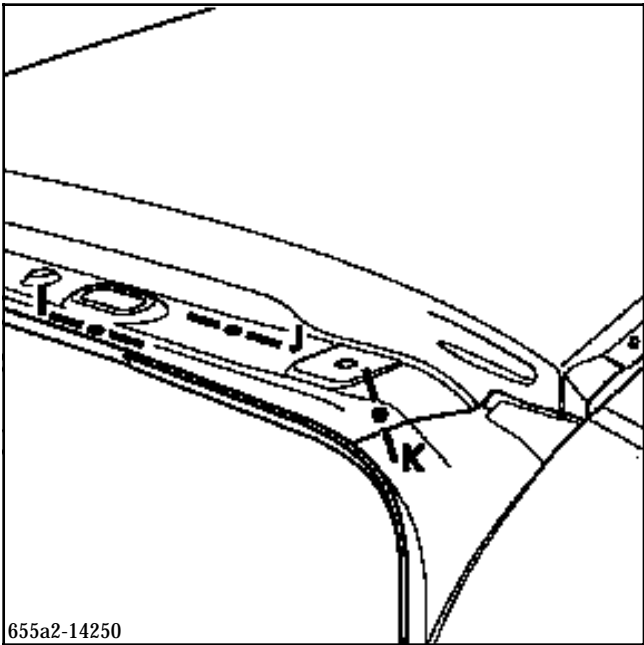
## PARTS CONCERNED (thickness in mm):

1	Roof	0.7
2	Roof front cross member	1.2
3	Windscreen aperture pillar lining	1.2
4	Front pillar	1.2
5	Body side, front section	1.2
6	Rear wing panel	0.8
7	Centre pillar reinforcement	1
8	Rear quarter panel upper rear reinforcement	1.2
9	Body side lining	0.7
10	Roof rear cross member	1
11	Upper side rain channel	0.7



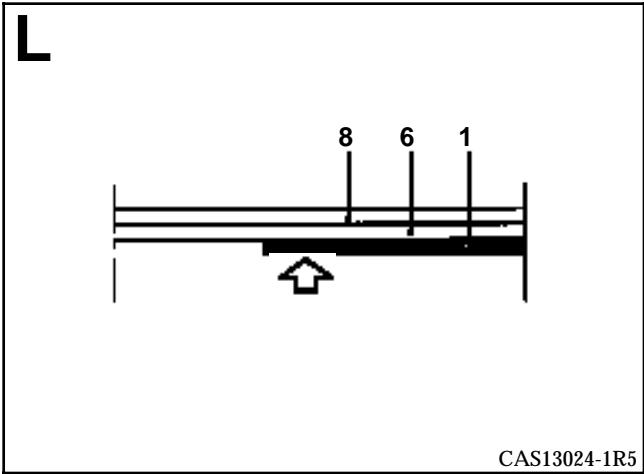
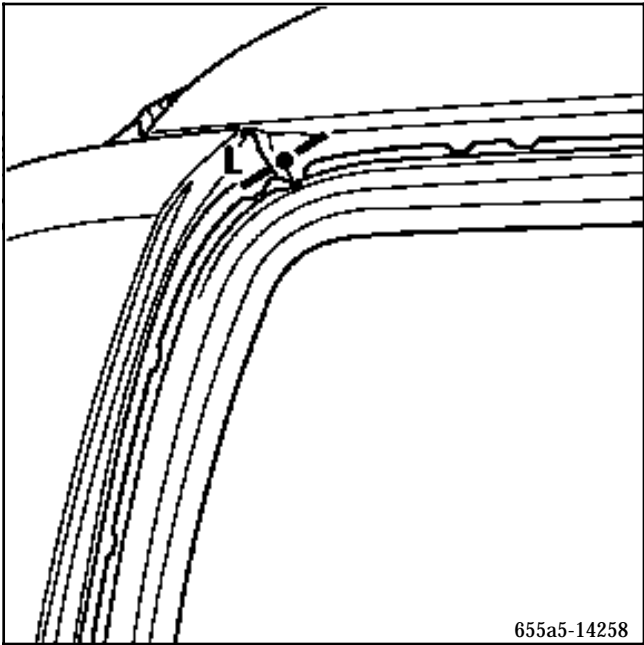






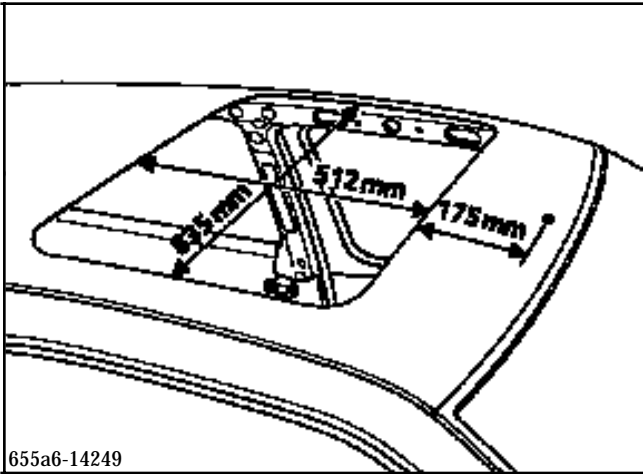


VERSION B



SUNROOF VERSION

When replacing the body or roof of a vehicle fitted with a sunroof, the roof will have to be cut to the following dimensions.



**NOTE :** a radius of 73 mm on the four corners must be respected.

INTRODUCTION

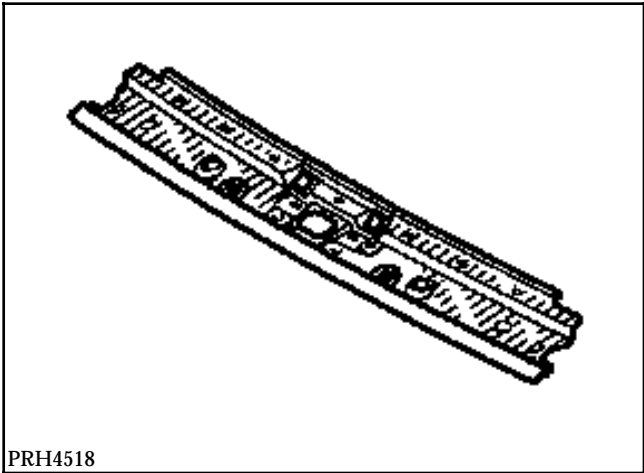
The replacement of this part is a complementary operation to the roof.

In the operation described below there are only descriptions of the joints specific to the part concerned.

Information concerning other parts will be dealt with in the respective section (see contents).

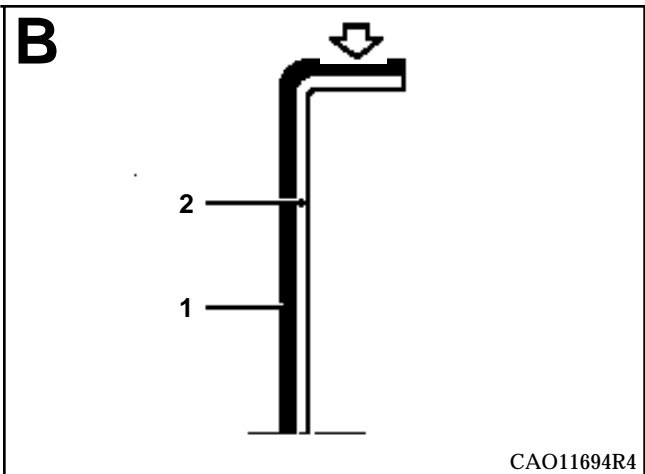
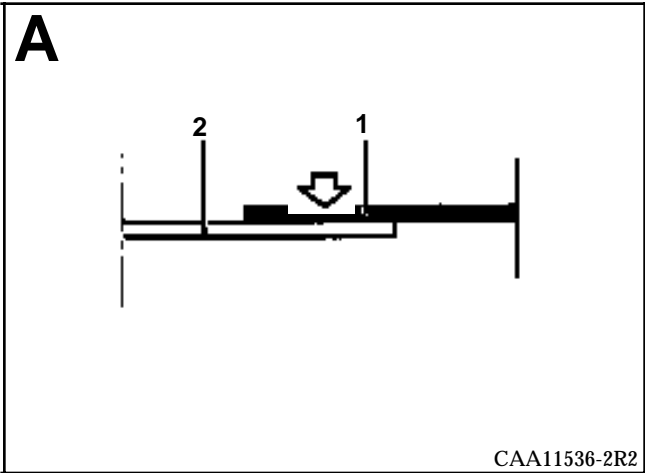
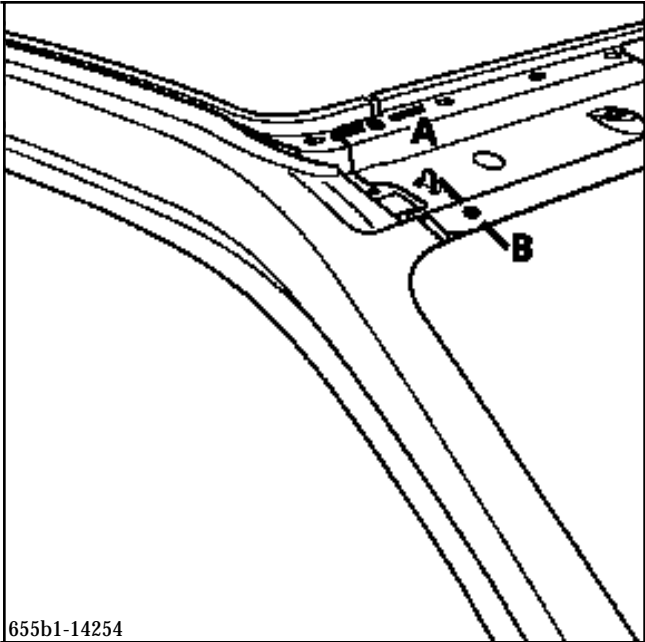
COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

Part assembled with roof cross member closure panel.



PARTS CONCERNED (thickness in mm):

- |   |                                   |     |
|---|-----------------------------------|-----|
| 1 | Roof front cross member           | 1.2 |
| 2 | Windscreen aperture pillar lining | 1.2 |



INTRODUCTION

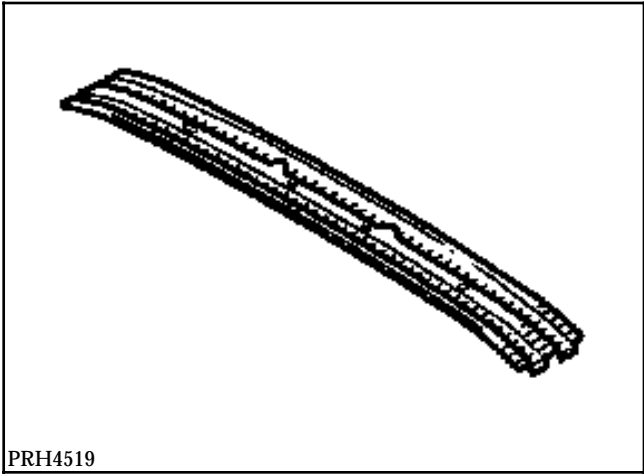
The replacement of this part is a complementary operation to the roof.

In the operation described below there are only descriptions of the joints specific to the part concerned.

Information concerning other parts will be dealt with in the respective section (see contents).

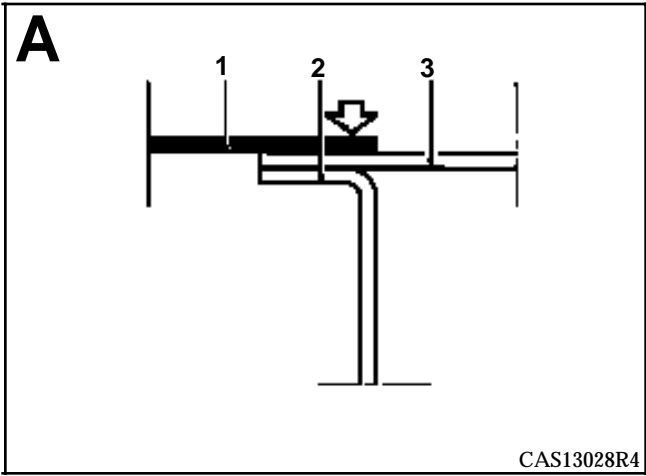
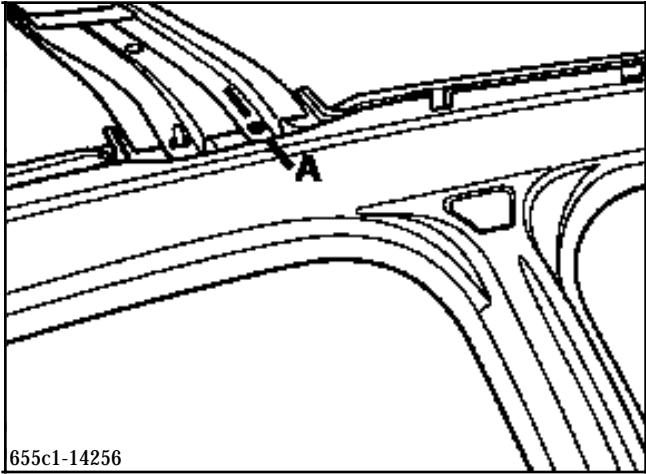
COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

Part assembled with an acoustic weight.



PARTS CONCERNED (thickness in mm):

- |   |                             |     |
|---|-----------------------------|-----|
| 1 | Roof front cross member     | 1.2 |
| 2 | Body side lining            | 0.7 |
| 3 | Centre pillar reinforcement | 1   |



INTRODUCTION

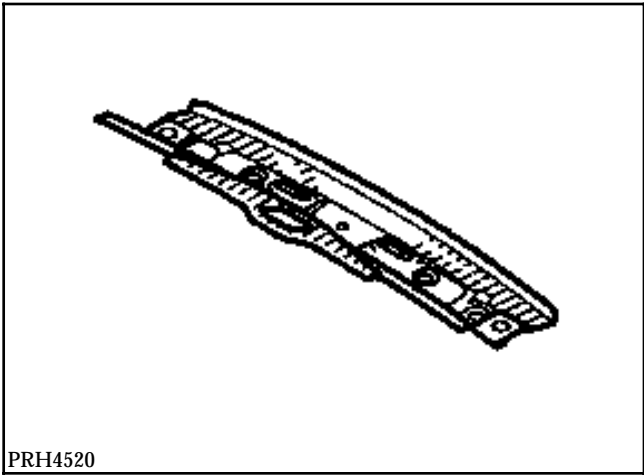
The replacement of this part is a complementary operation to the roof.

In the operation described below there are only descriptions of the joints specific to the part concerned.

Information concerning other parts will be dealt with in the respective section (see contents).

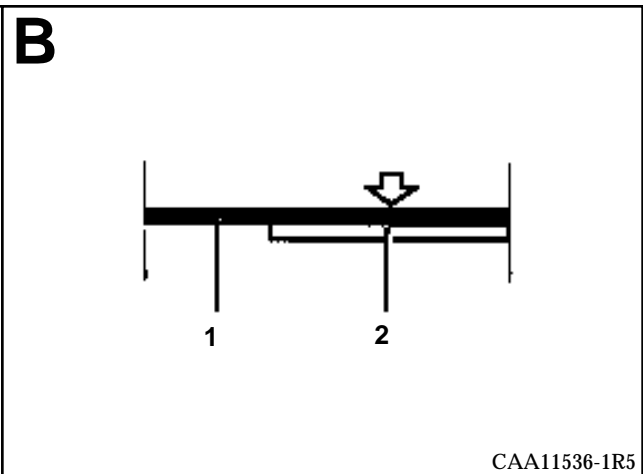
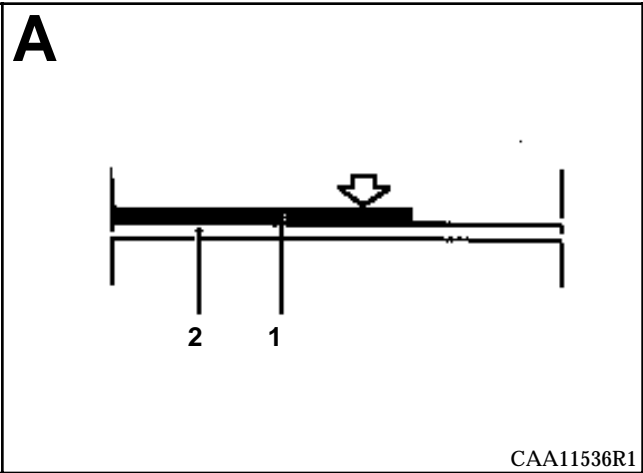
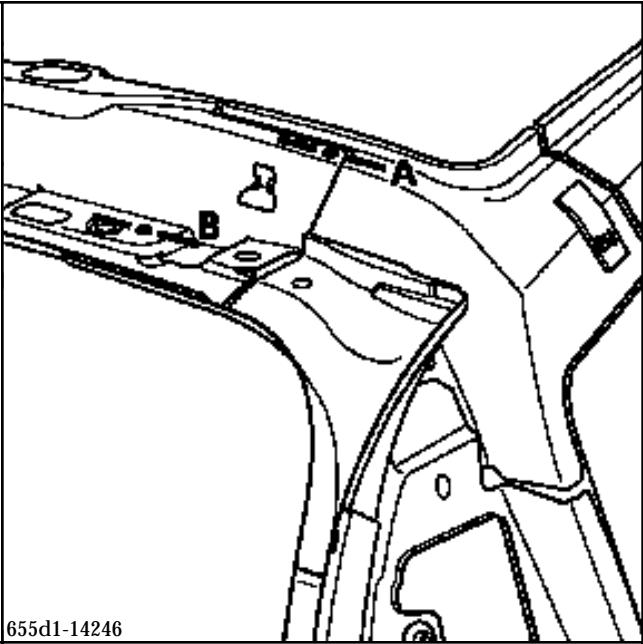
COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

Part only.



PARTS CONCERNED (thickness in mm):

- |   |   |     |
|---|---|-----|
| 1 | Roof rear cross member                      | 1   |
| 2 | Rear quarter panel upper rear reinforcement | 1.2 |



INTRODUCTION

The replacement of this part is a complementary operation to the roof.

This operation is carried or partially (see cut and method for versions B and C below).

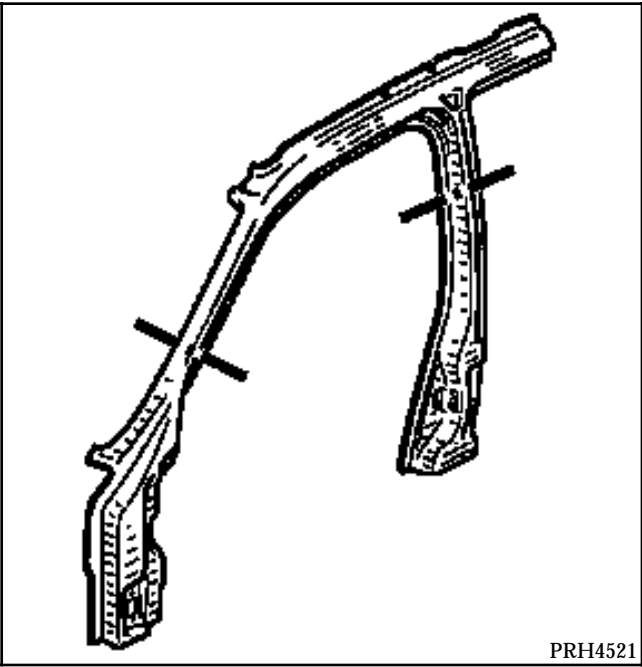
In the operation described below there are only descriptions of the joints specific to the part concerned.

Information concerning other parts will be dealt with in the respective section (see contents).

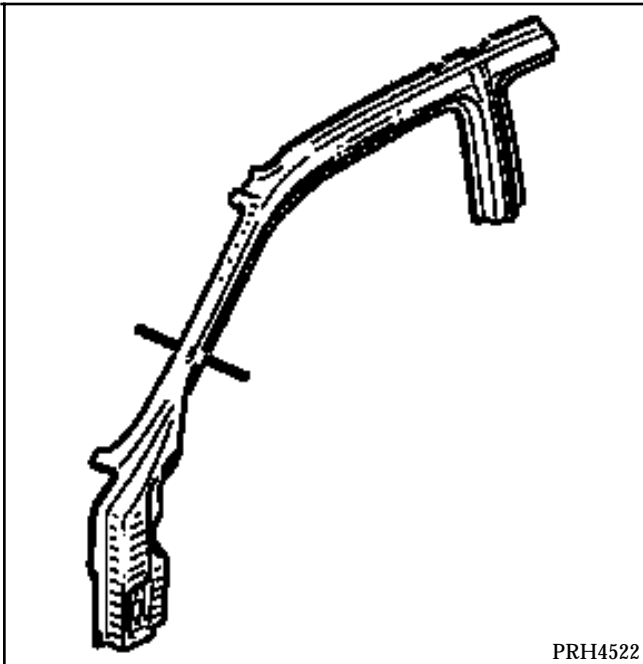
COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

Part only.

VERSION B

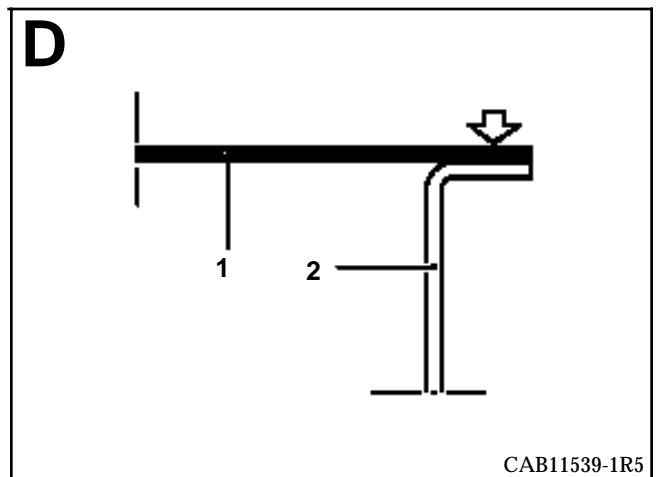
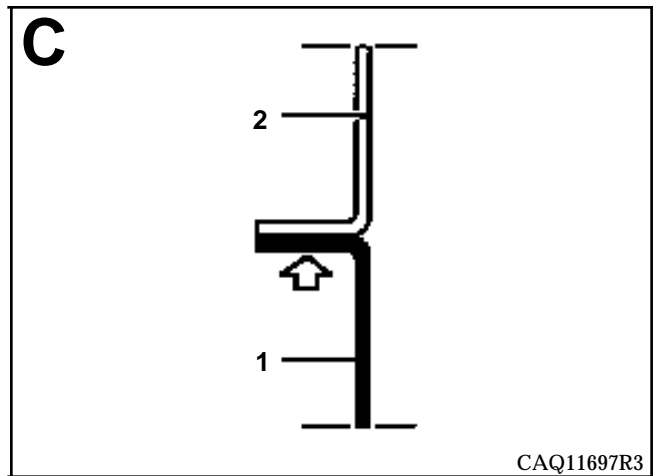
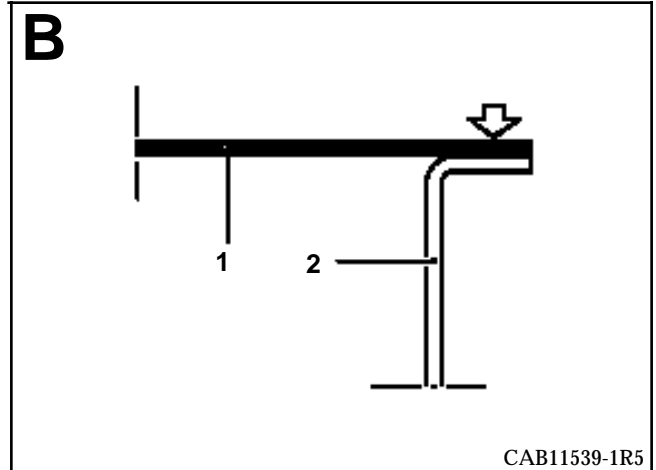
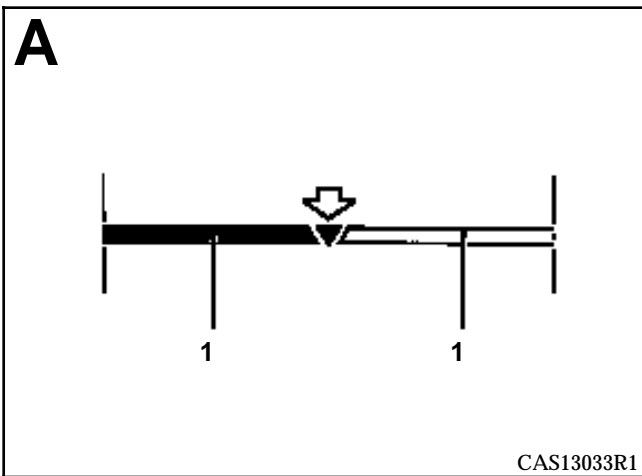
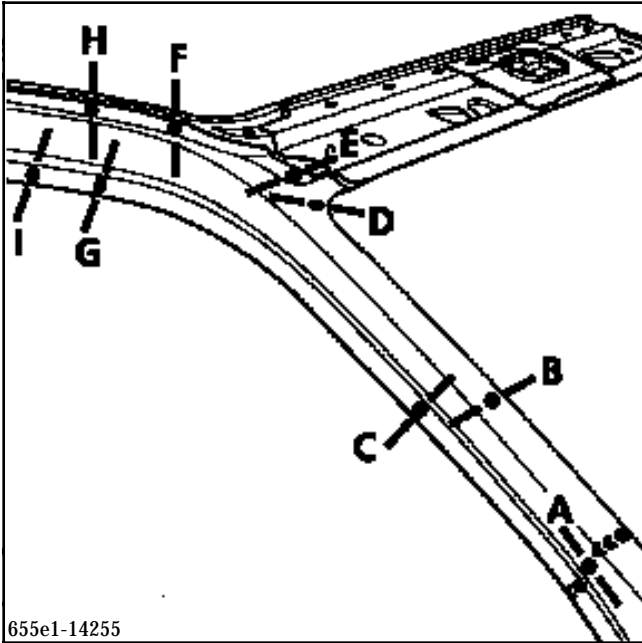


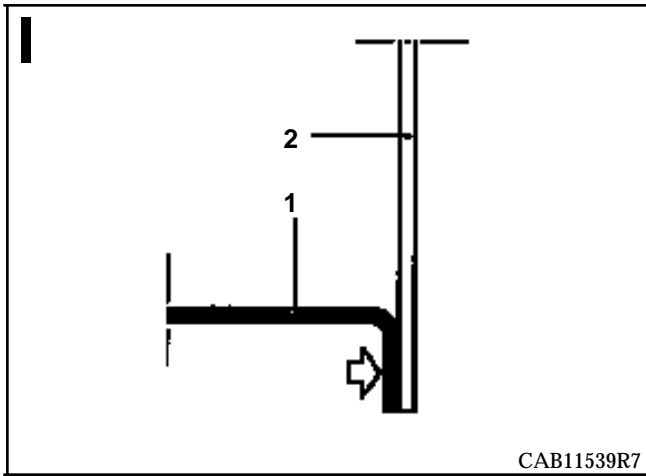
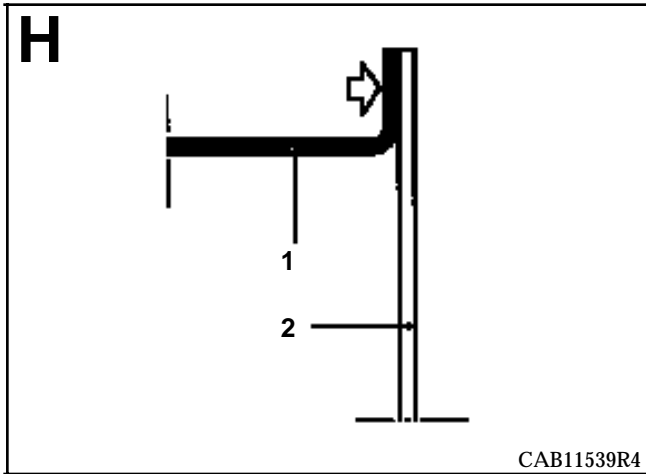
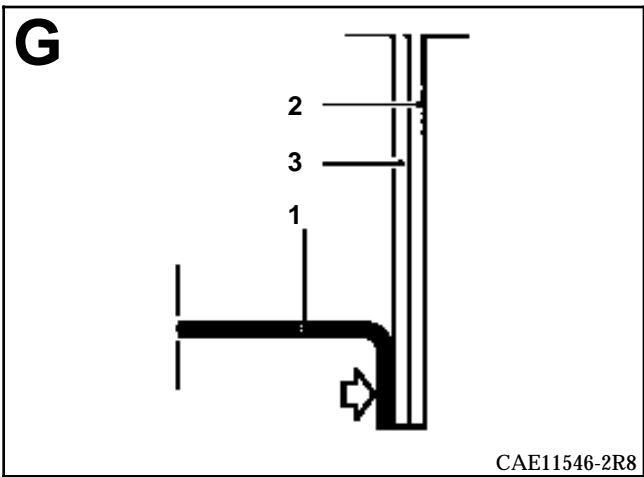
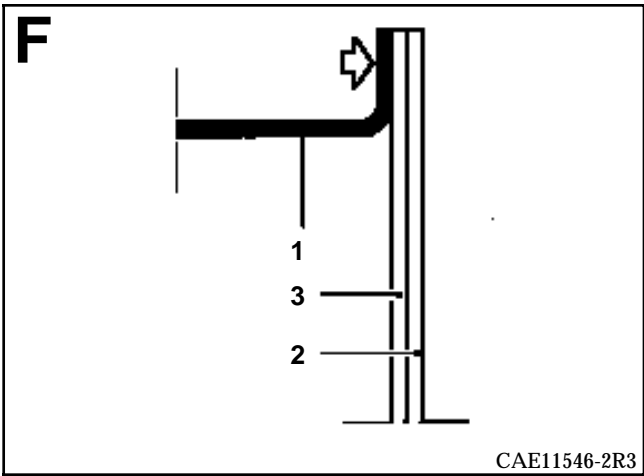
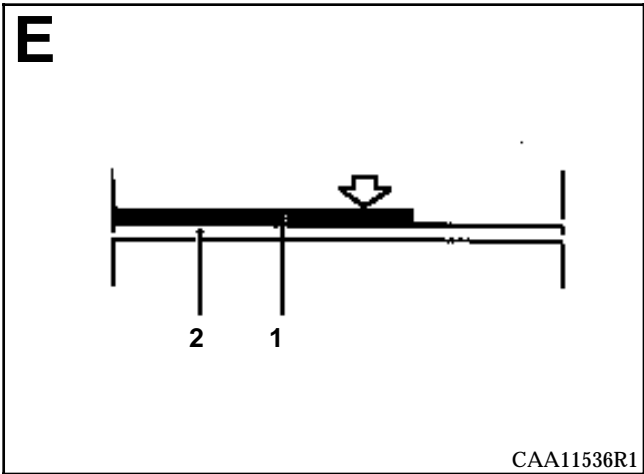
VERSION C



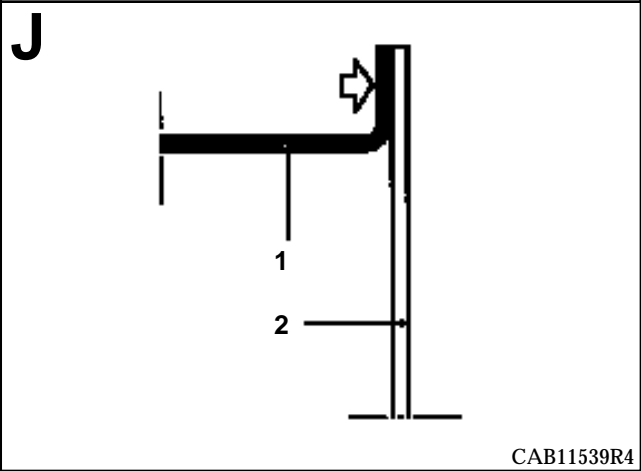
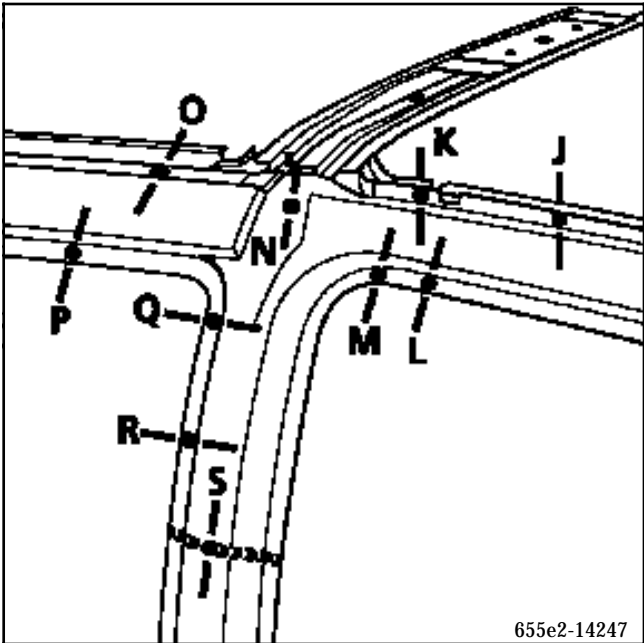
PARTS CONCERNED (thickness in mm):

1	Top of body	1.2
2	Windscreen aperture pillar lining	1.2
3	Windscreen aperture pillar upper reinforcement	1
4	Centre pillar reinforcement	1
5	Body side lining	0.7
6	Body side upper stretcher (version C)	1
7	Centre pillar	1.2
8	Seat belt mounting centre pillar upper reinforcement	1.2
9	Rear quarter panel upper rear reinforcement	1.2
10	Rear quarter panel lower rear reinforcement	1.2

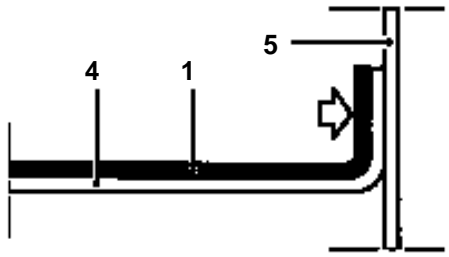




VERSION C



K



CAN11690R5



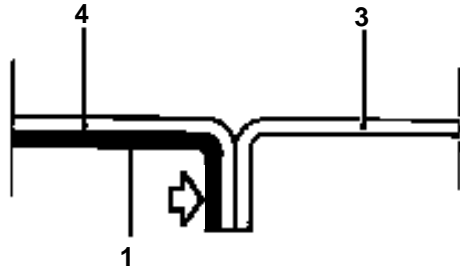
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CAQ11697R2



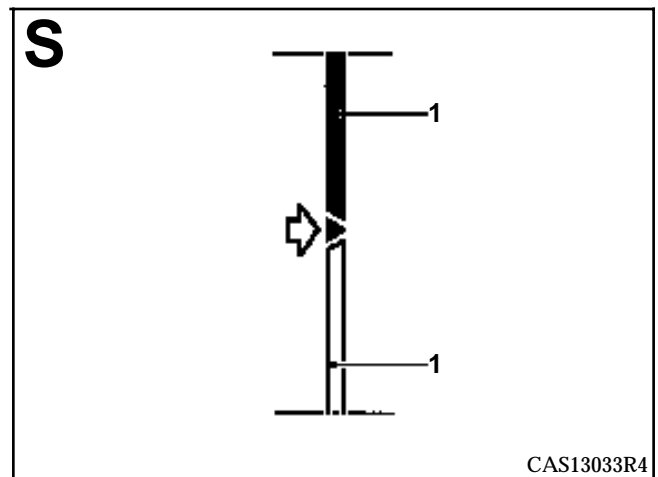
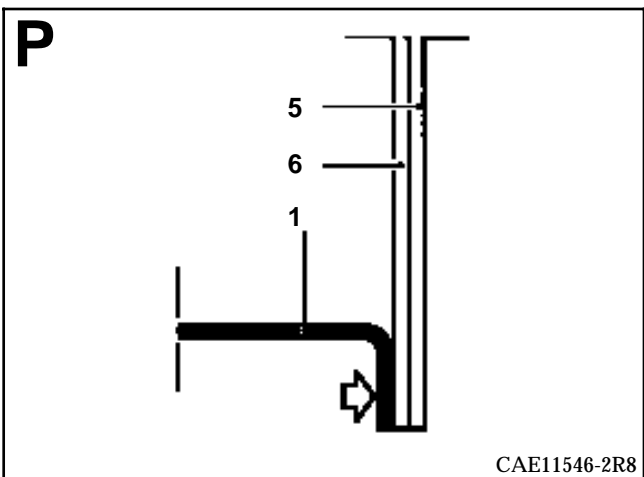
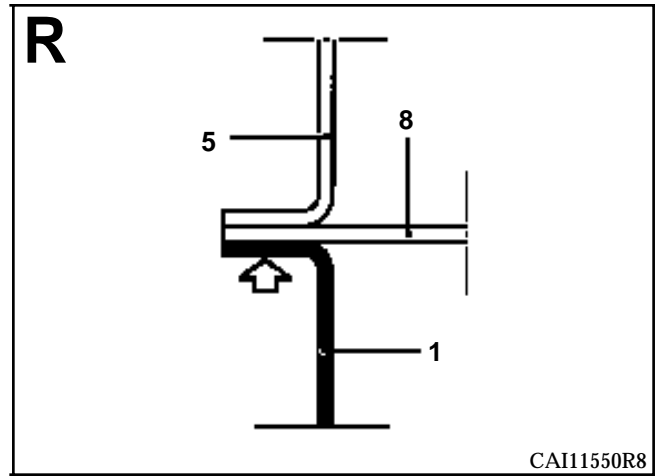
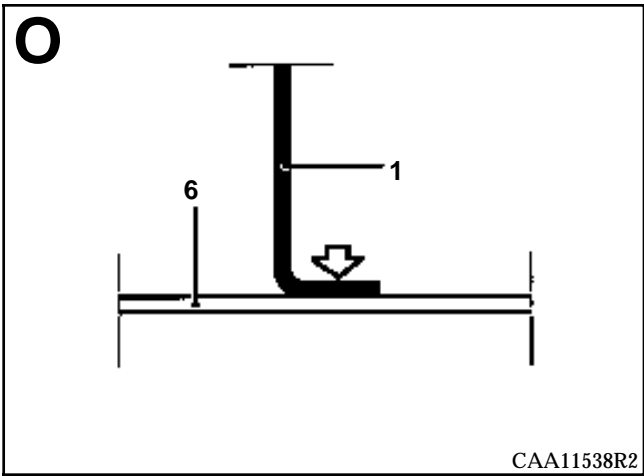
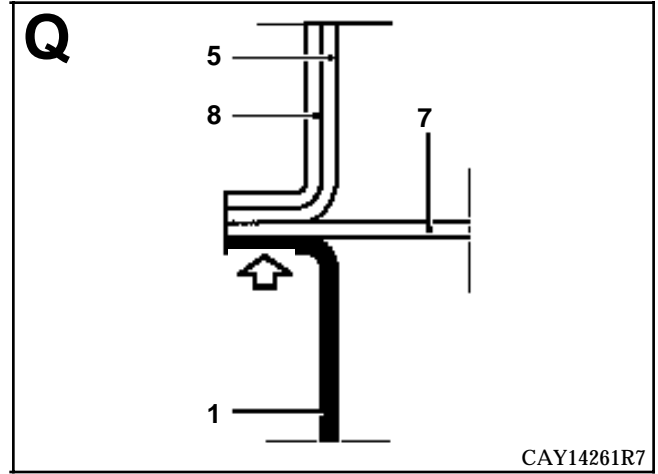
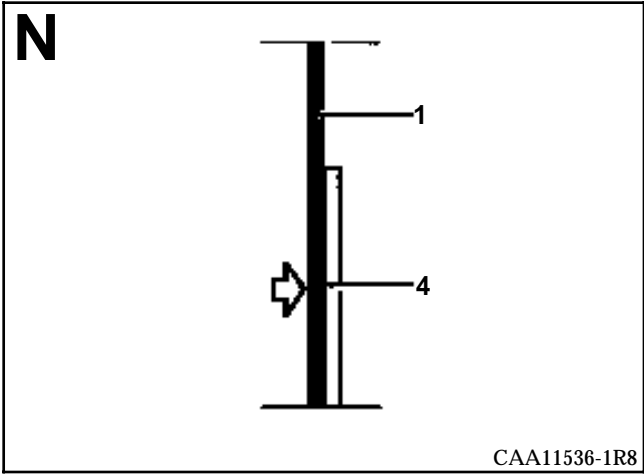
M



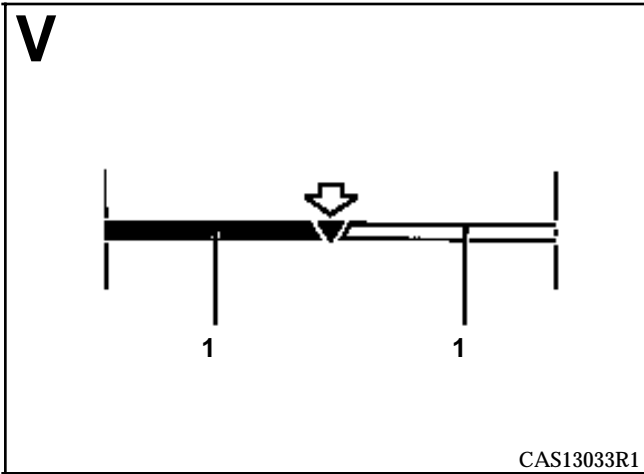
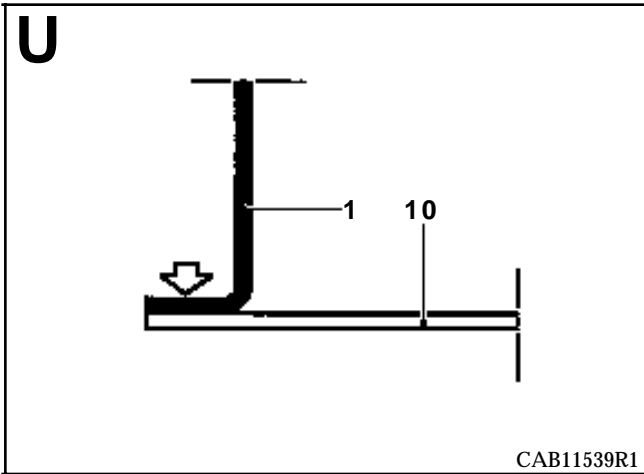
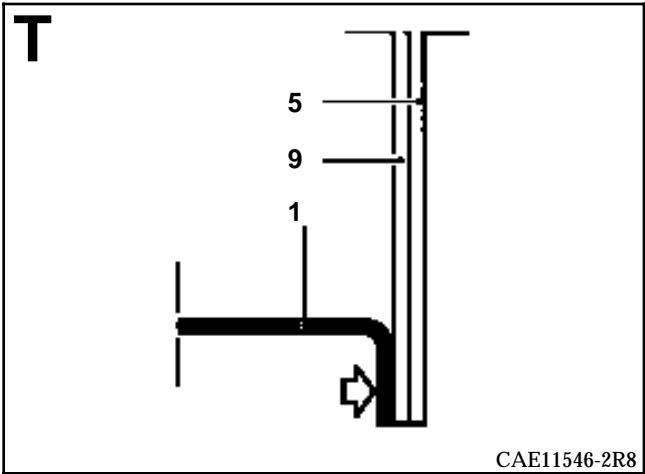
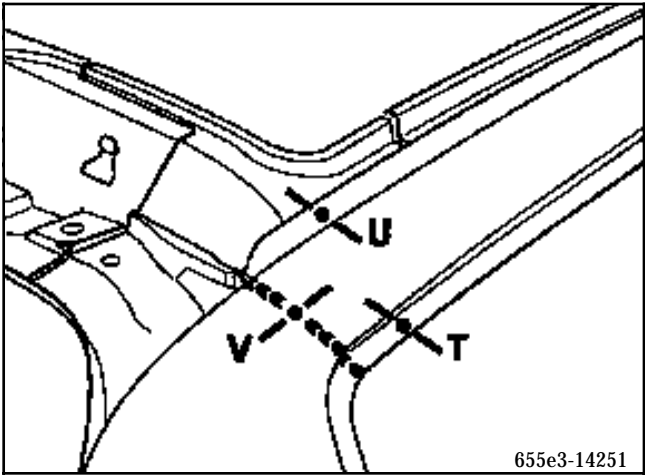
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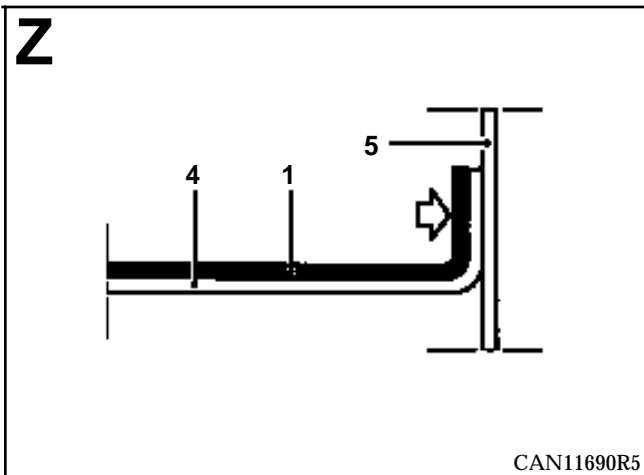
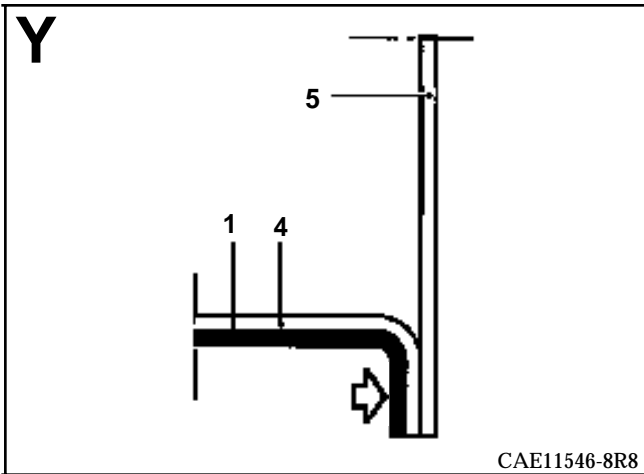
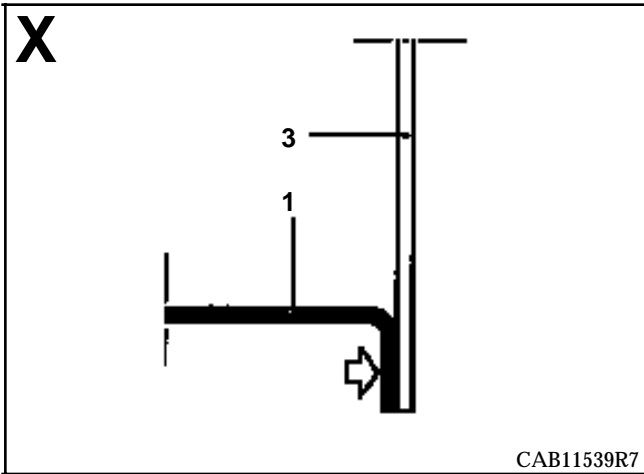
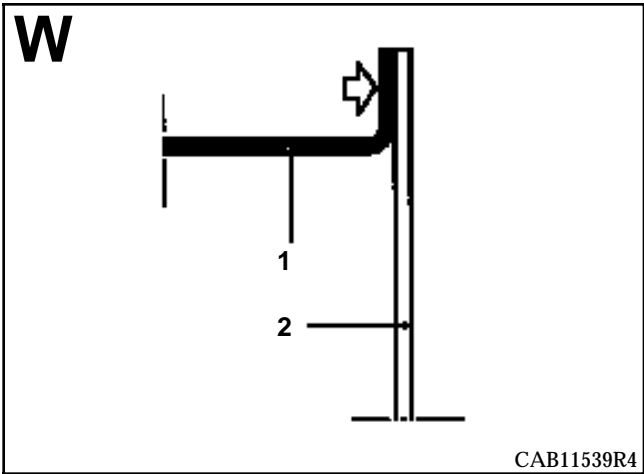
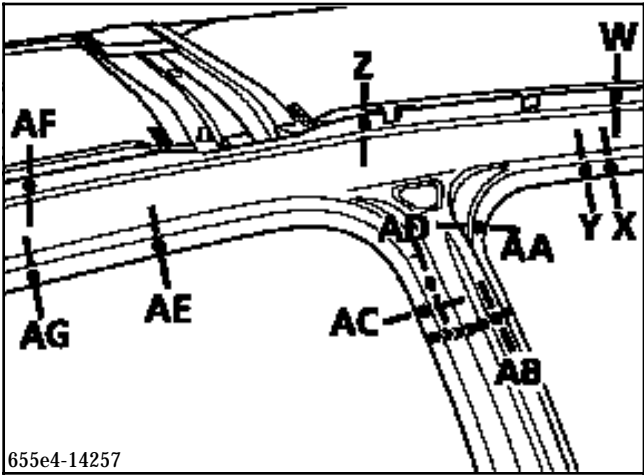


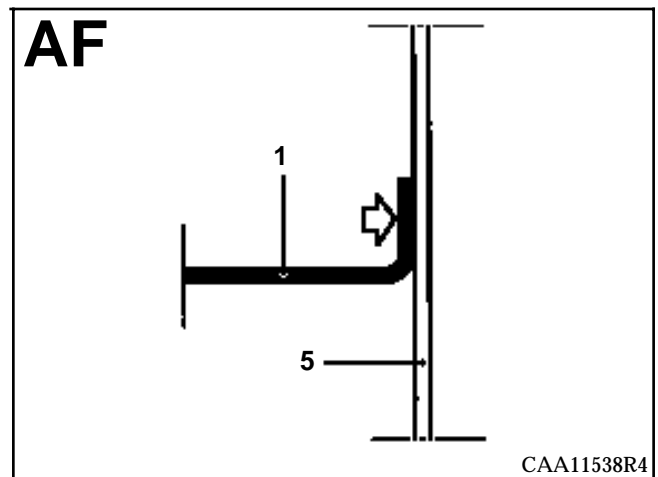
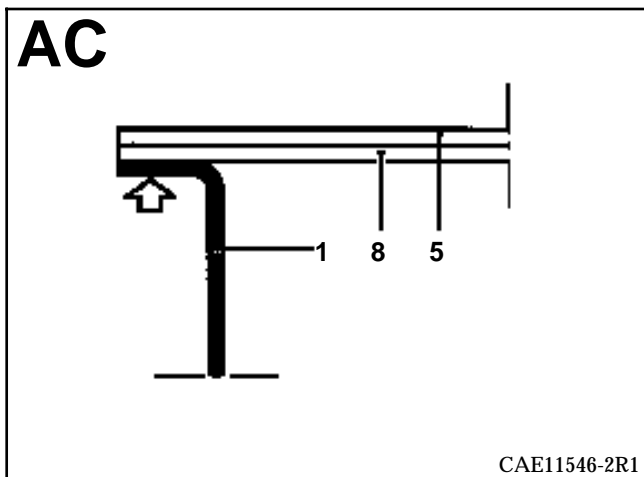
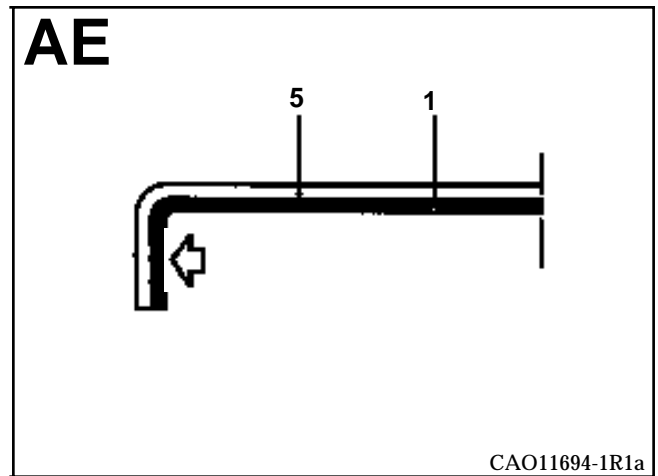
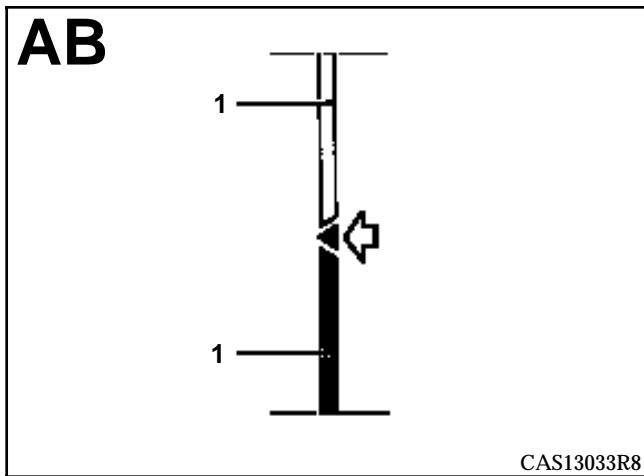
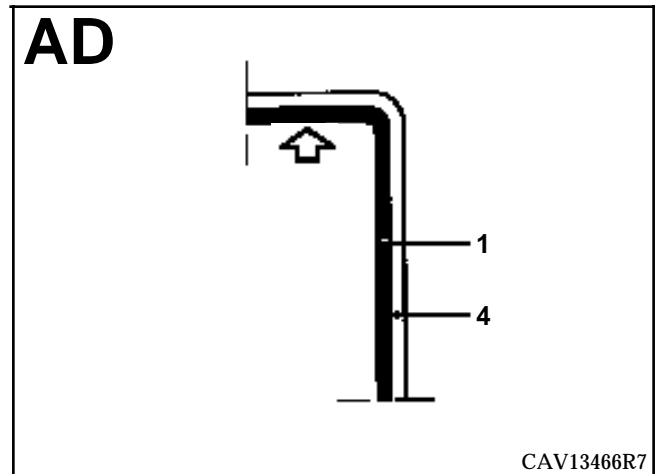
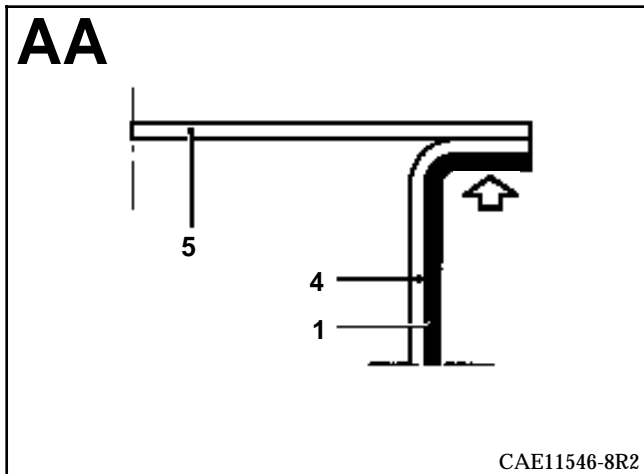


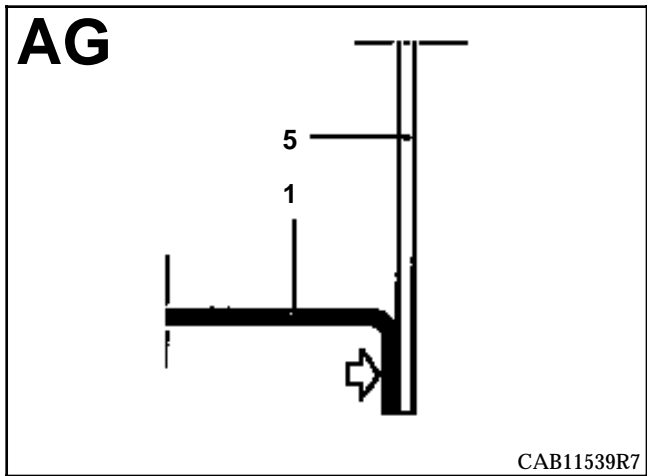
VERSION C



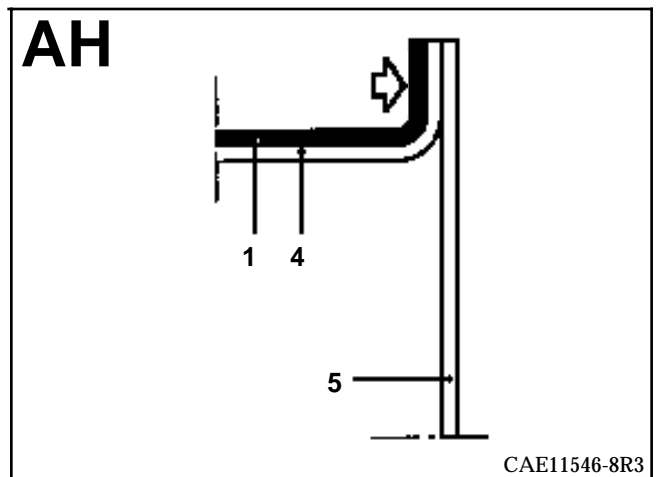
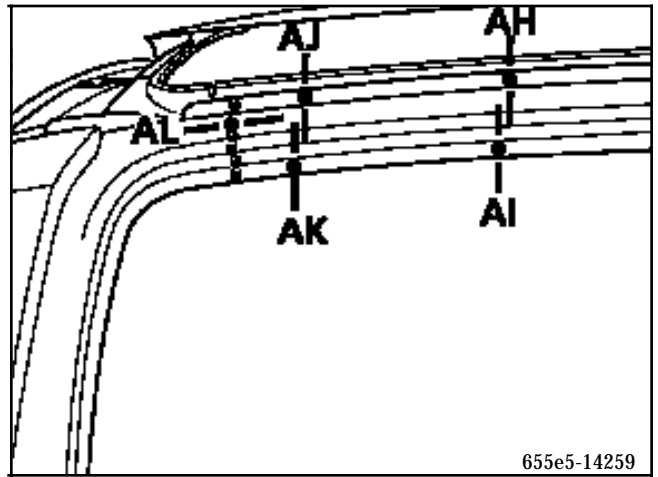
VERSION B

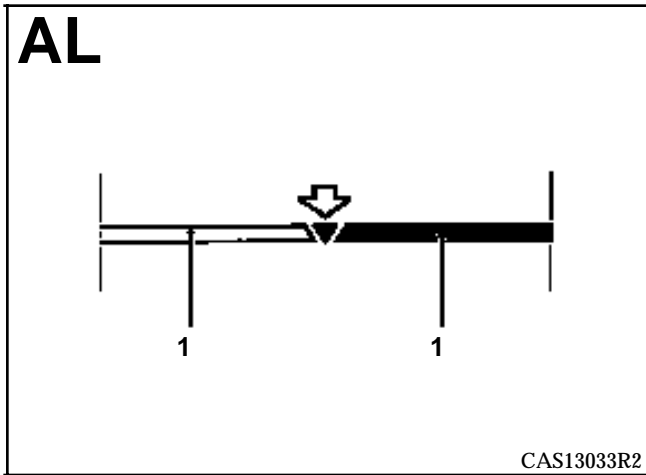
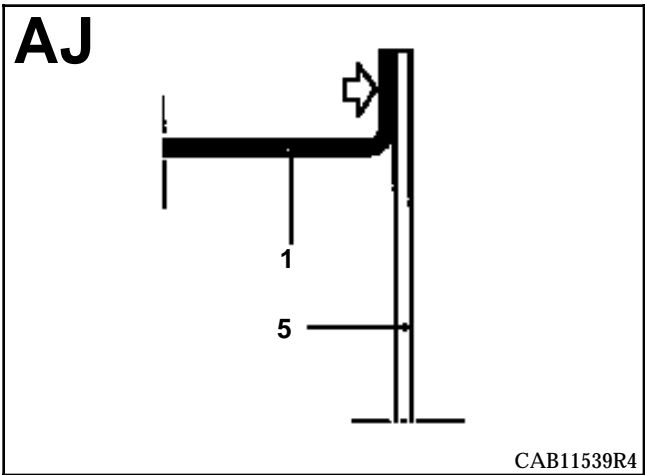
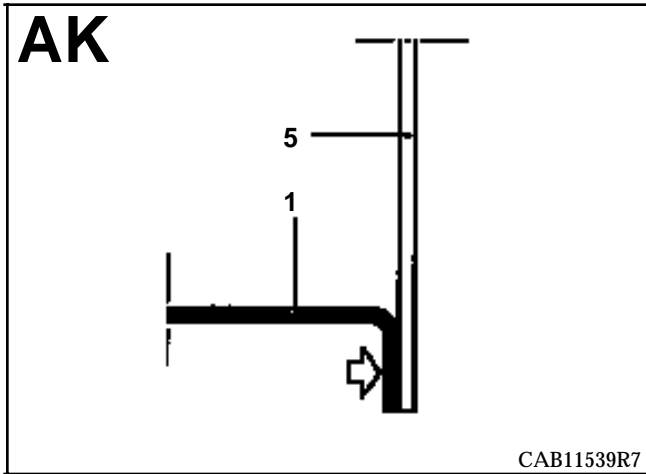
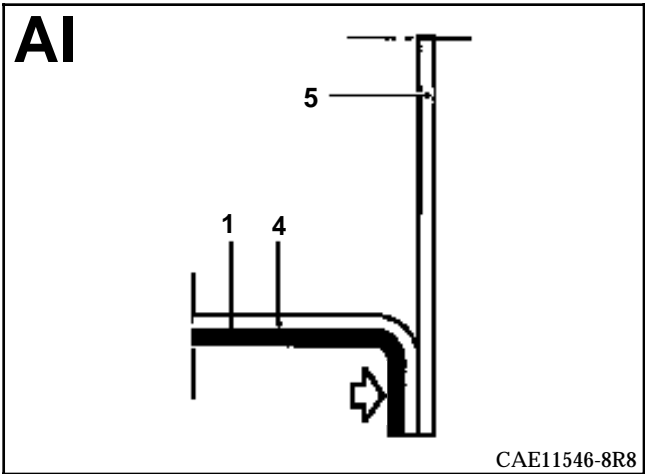






VERSION B

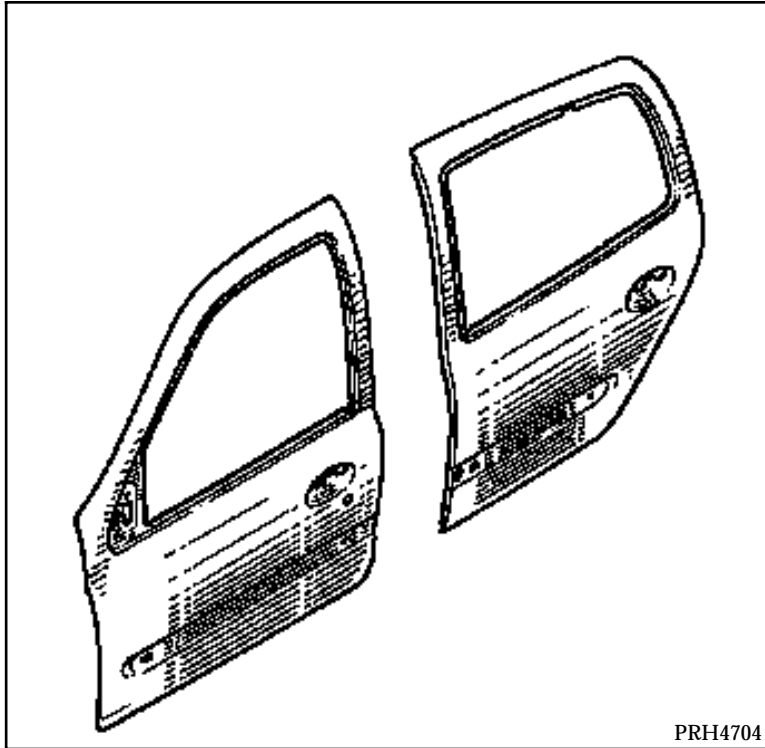




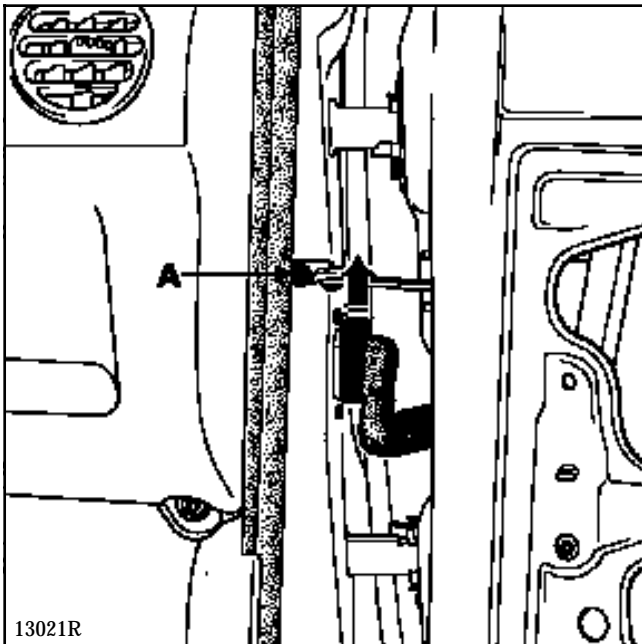
# SIDE OPENING ELEMENTS

## Front and rear doors

47 A



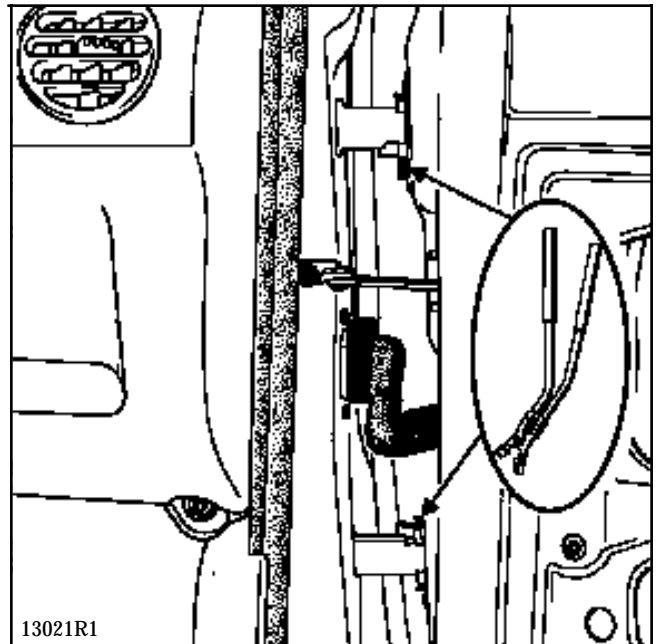
### REMOVAL



Fit the door support tool (see section 50B).

Disconnect the door wiring by pushing the clip upwards.

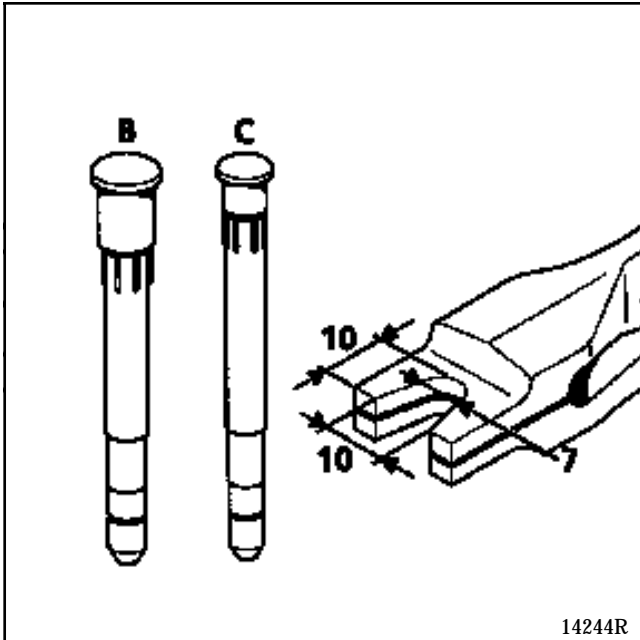
Remove the bolt on the door support bar (A).



Remove the door hinge pins using tool Car. 1415 (see section 50B).

**NOTE :** tool Car. 1415 has to be modified (see following page).

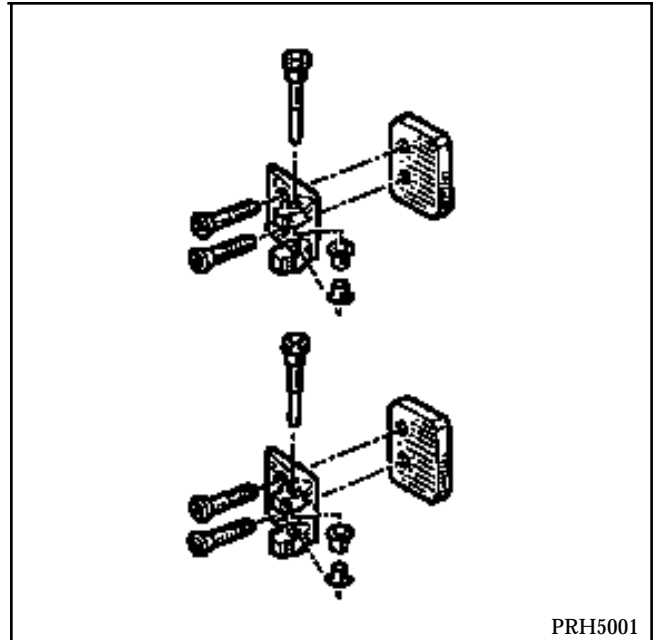
### MODIFYING THE TOOL FOR REMOVING THE HINGE PINS



Using a flat file and a round file, file the end of the tool blade and the bottom of the neck to obtain the precise dimensions indicated on the diagram below.

Following this modification, it is also possible to remove the pins on the X65 (B) and the pins on the MEGANE (C).

### REFITTING AND ADJUSTING

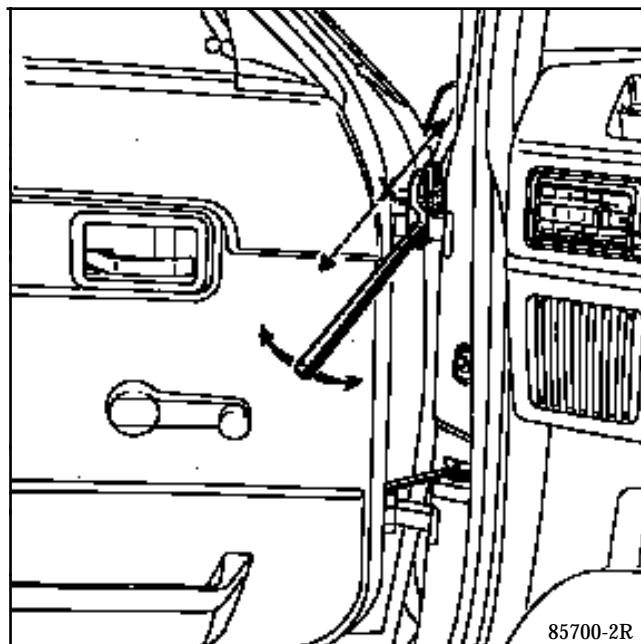


Refitting is the opposite of removal. Refer to the section "Opening clearances" to make adjustments.

**NOTE :** when changing the door or when changing the body but replacing original opening elements, the correct type of after sales bolted hinges will have to be used which ensure the correct height adjustment of the door.

Use the Parts Department kit, part number **77 01 468 331**.

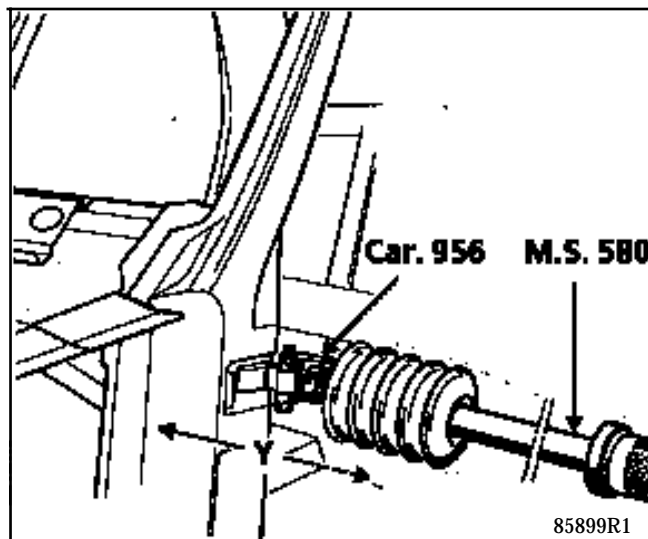




### Adjusting the doors by tilting

Use special tool, **WILMONDA**, part number **BHA** (Supplier **Z. INTERNATIONAL**).

This tool allows position "X" of the welded hinge to be modified on the front pillar or the centre pillar.



### Flush fitting adjustment of the doors

Adjustment range : 3 mm.

### INTRODUCTION

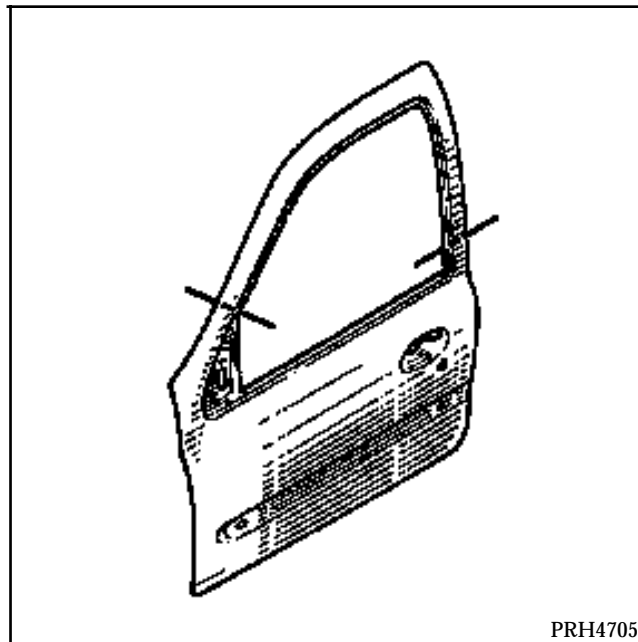
The replacement of this part is a basic operation for a side impact.

This part can be replaced partially (see cut and method below).

### COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

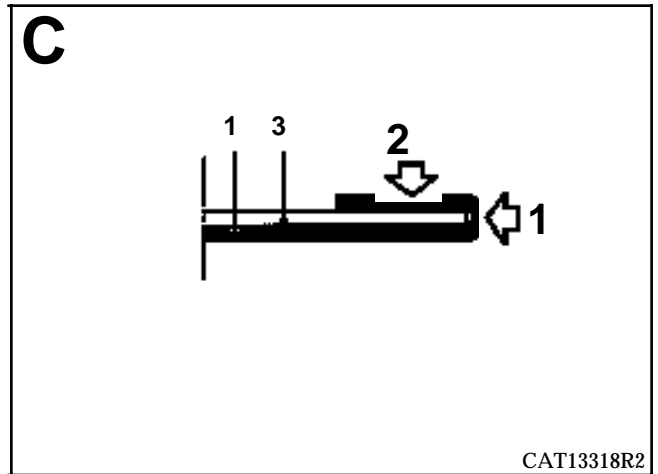
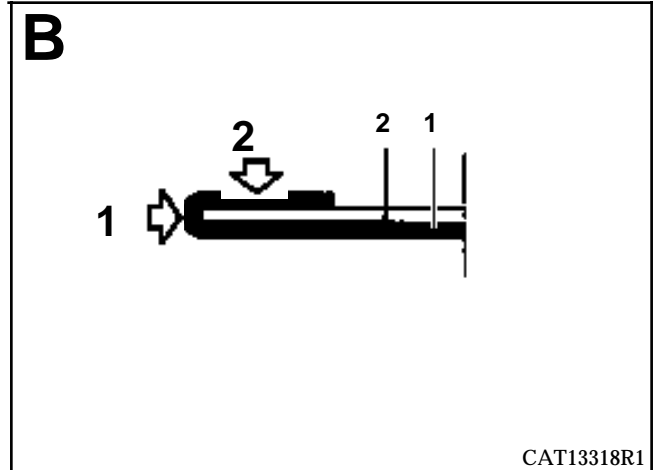
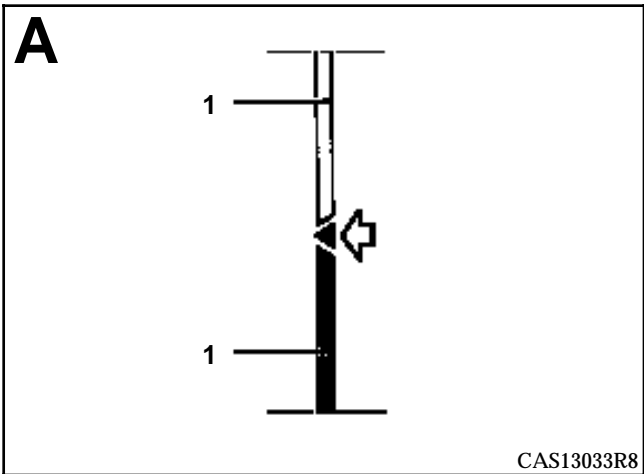
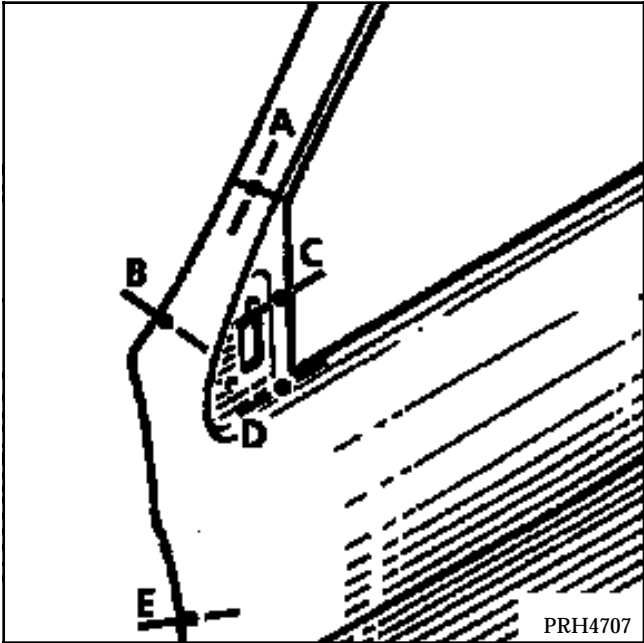
Part assembled with :

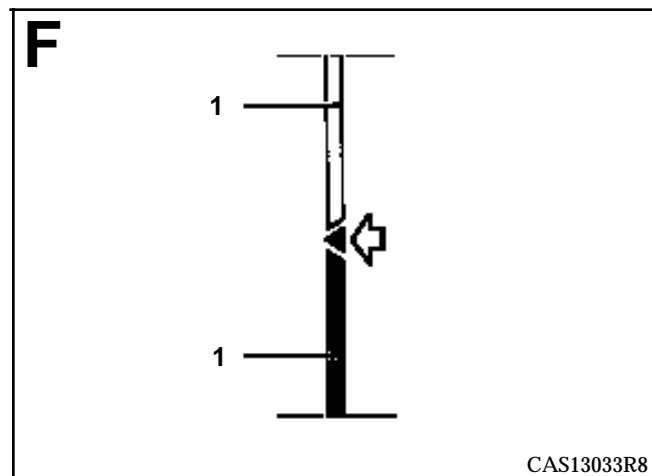
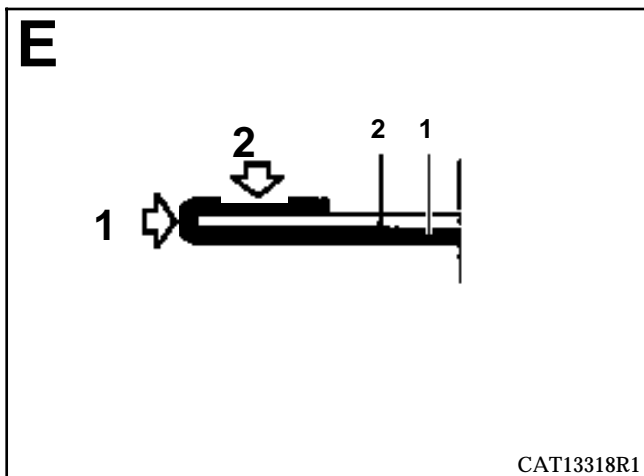
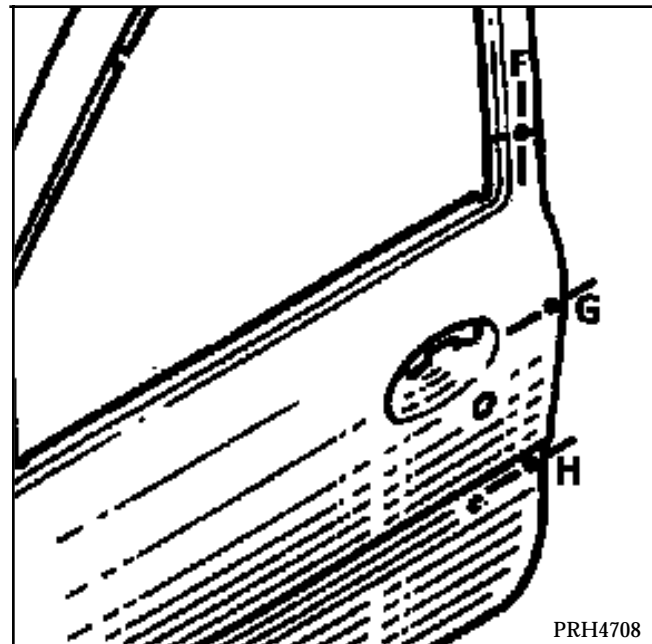
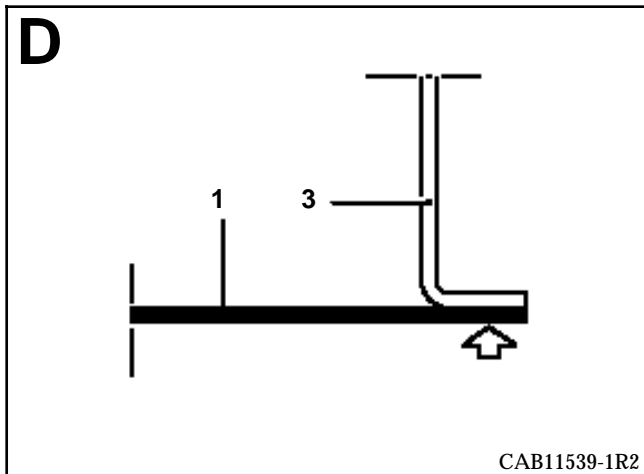
- upper reinforcement of door trim,
- soundproofing pads,
- vertical stiffener (version **B**).

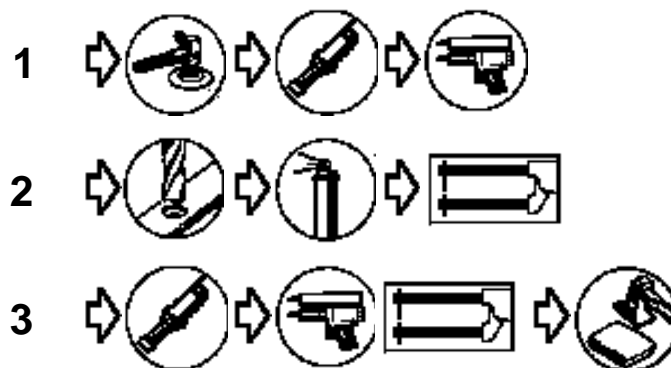
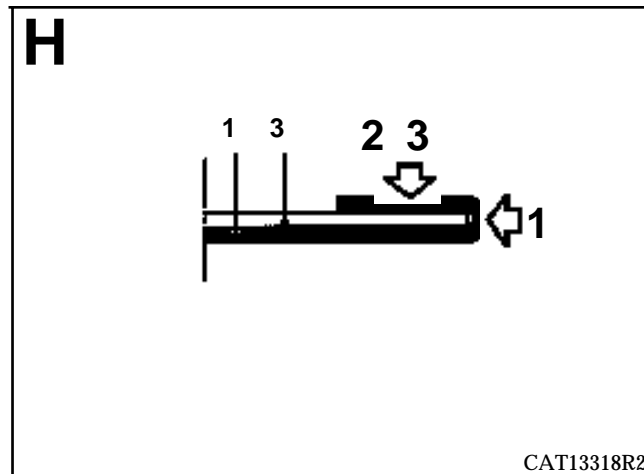
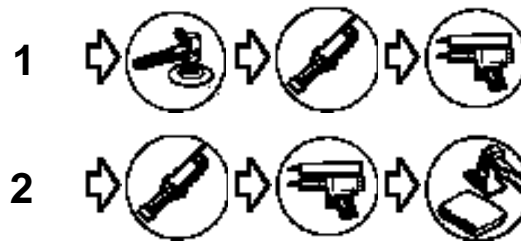
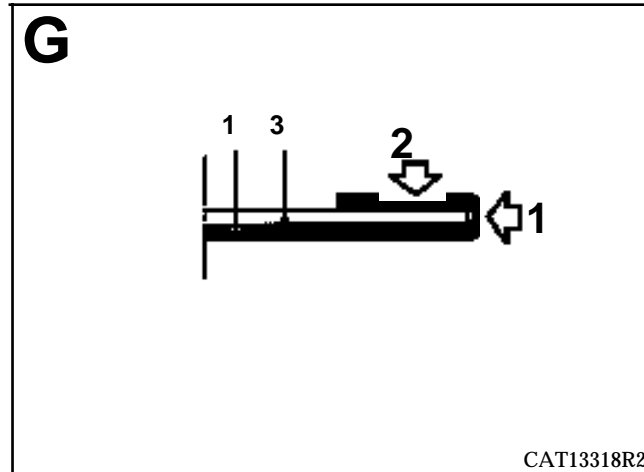


### PARTS CONCERNED (thickness in mm):

1	Door panel	0.7
2	Door box section	0.7
3	Door frame	0.8







### INTRODUCTION

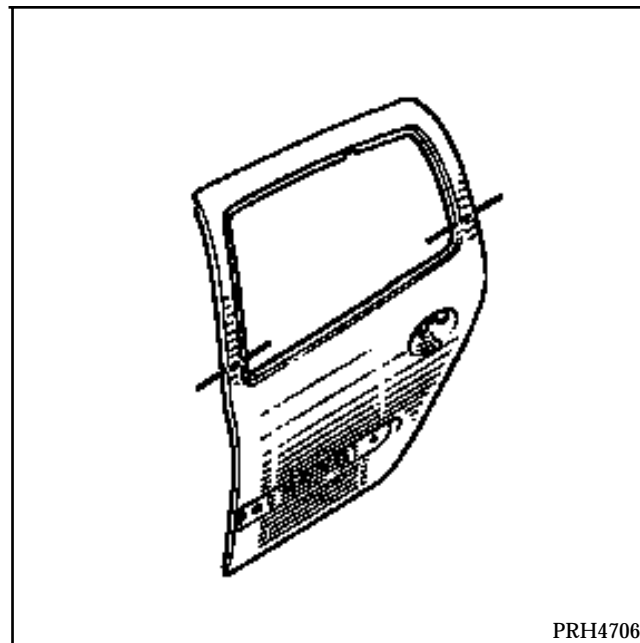
The replacement of this part is a basic operation for a side impact.

This part can be replaced partially (see cut and method below).

### COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT

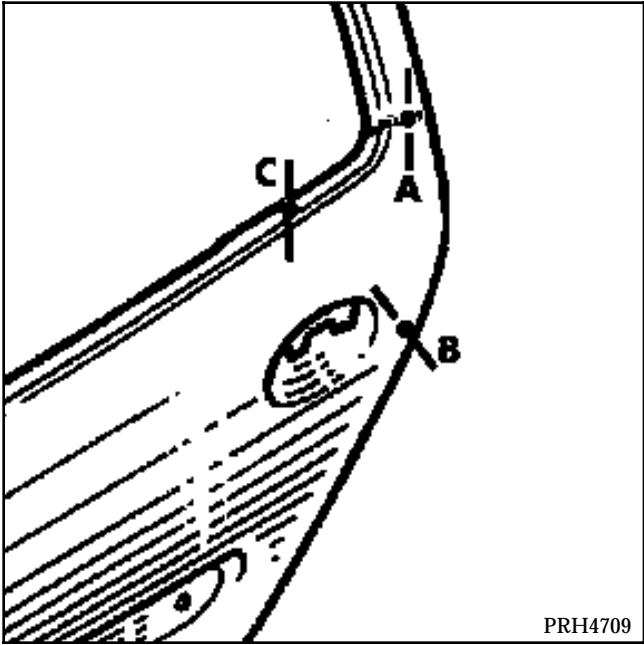
Part assembled with :

- soundproofing pads,
- stiffener.

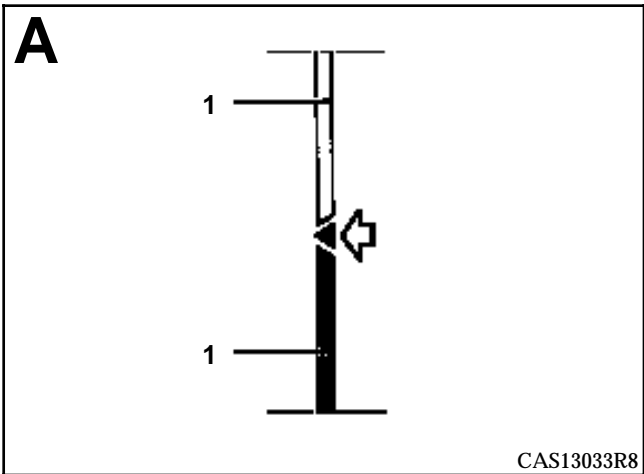


### PARTS CONCERNED (thickness in mm):

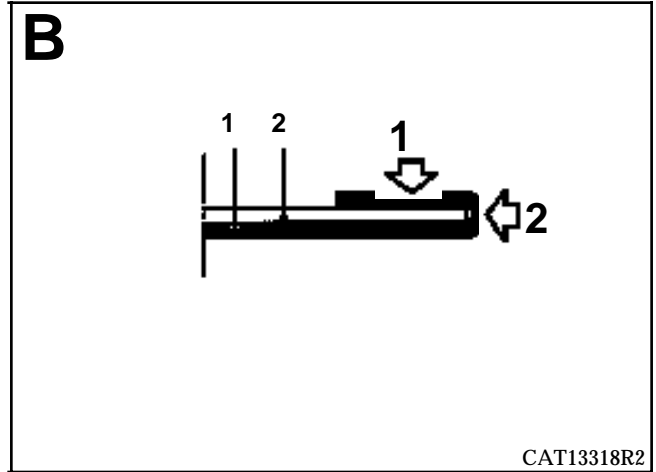
1	Door panel	0.7
2	Door box section	0.7
3	Door frame	0.8



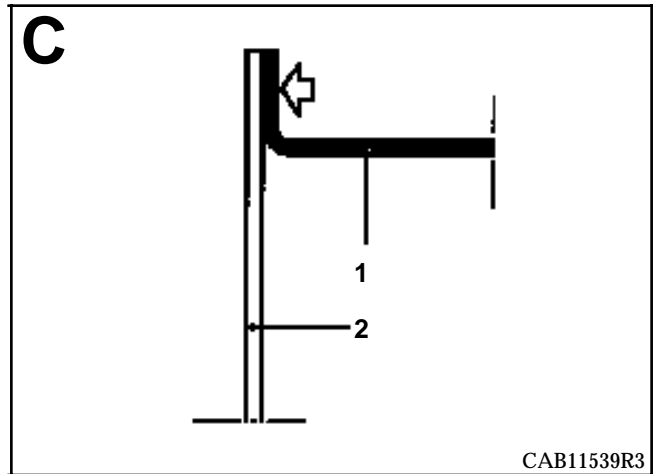
PRH4709



CAS13033R8

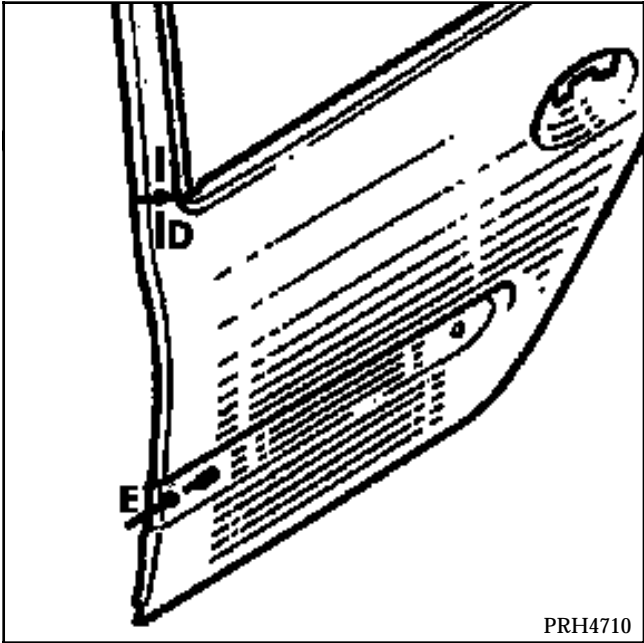


CAT13318R2

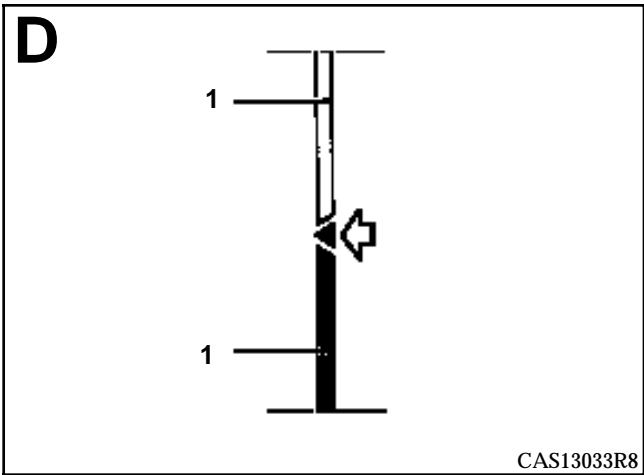


CAB11539R3

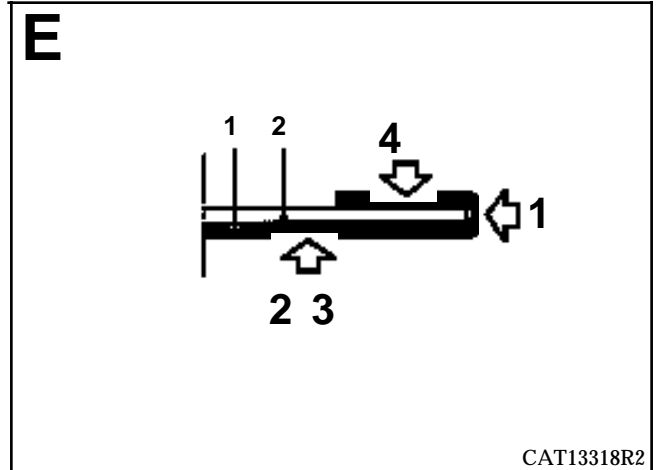




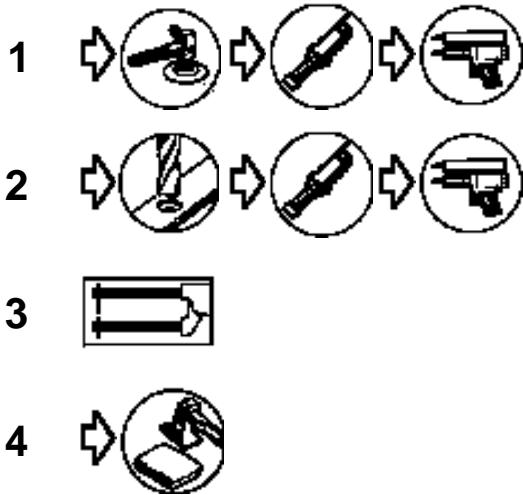
PRH4710



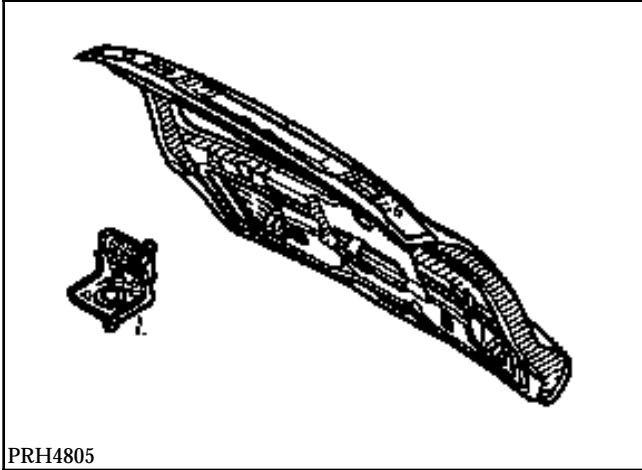
CAS13033R8



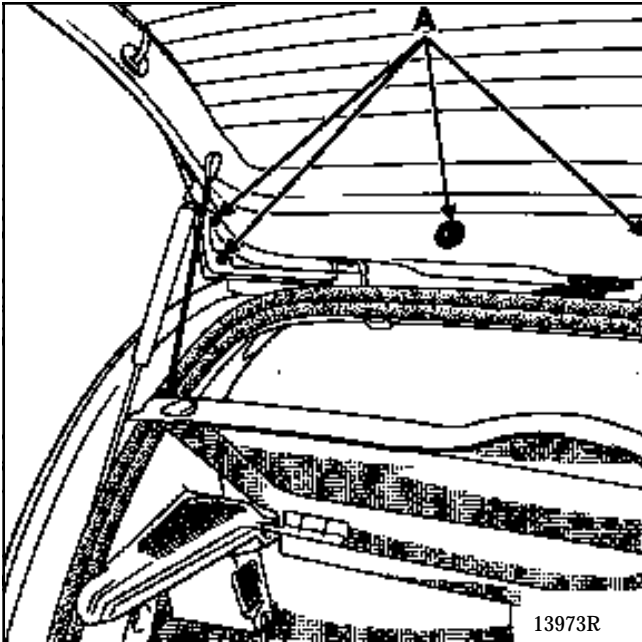
CAT13318R2



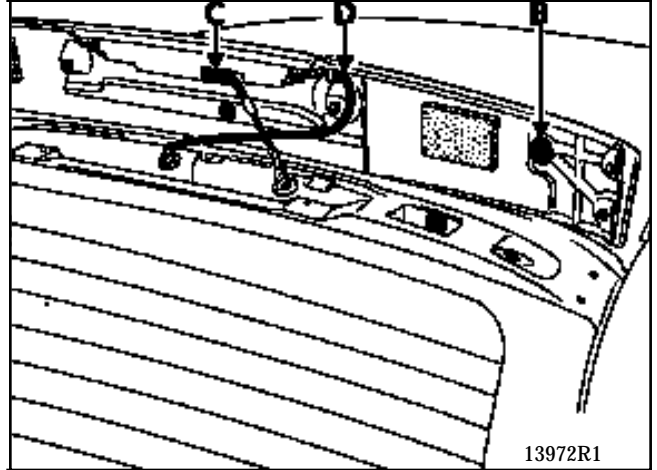




### REMOVAL



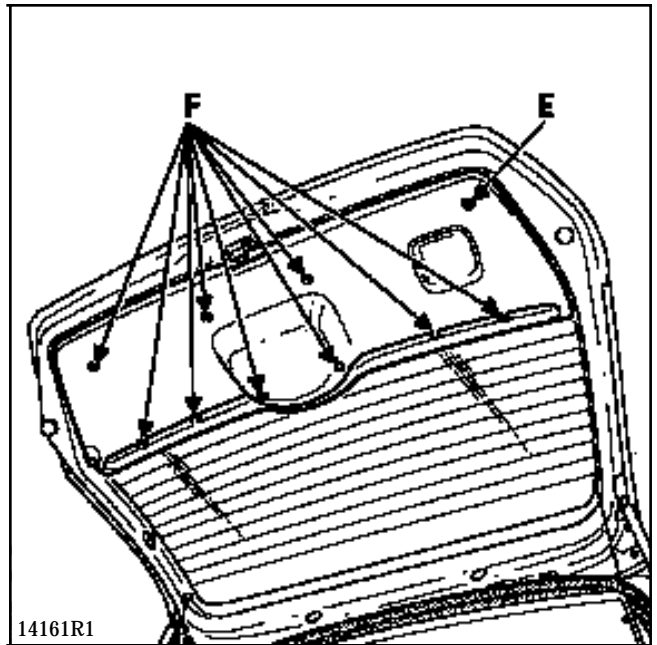
Remove the spoiler on the tailgate (mounting bolt (A)).



Pull the spoiler upwards to unclip it (B).

Disconnect the third stop light (C).

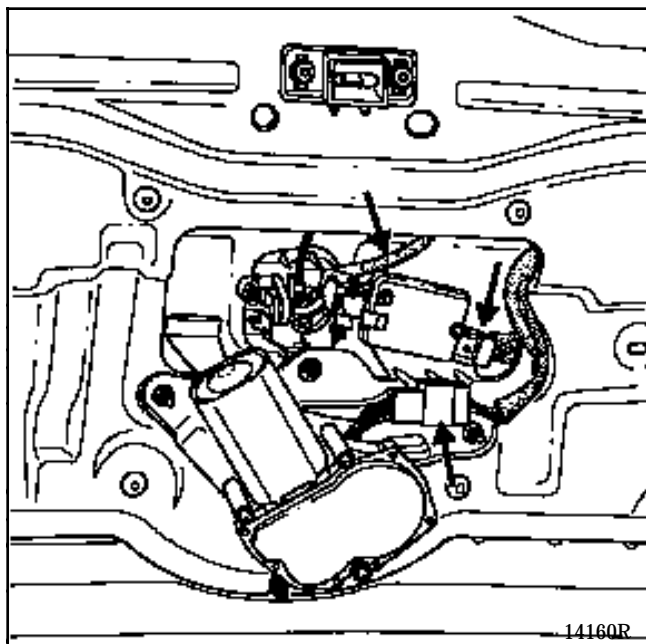
Remove the supply pipe from the rear screen jet (D).



Remove the mounting bolt (E).

Unclip the trim using the unpicking pliers (clips (F)).

Remove the tailgate trim.

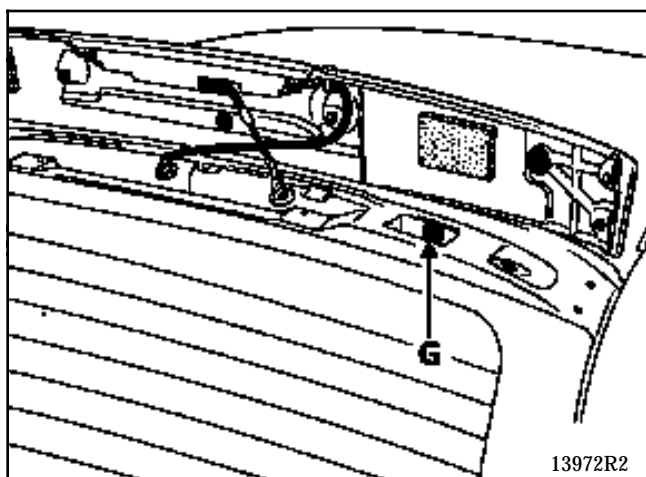


### Disconnect:

- the supply connectors from the screen wiper and tailgate lock motors,
- the supply terminals from the screen de-icing network.

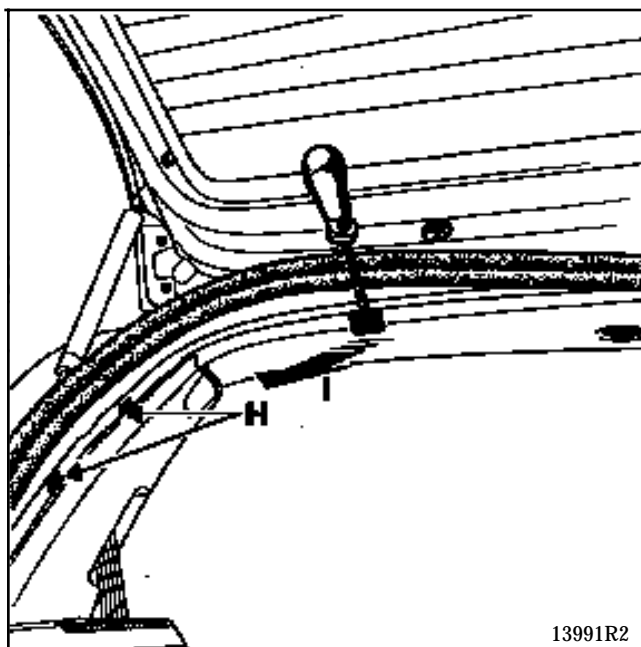
### Remove:

- the wiring loom from the tailgate box section and the screen jet supply pipe,



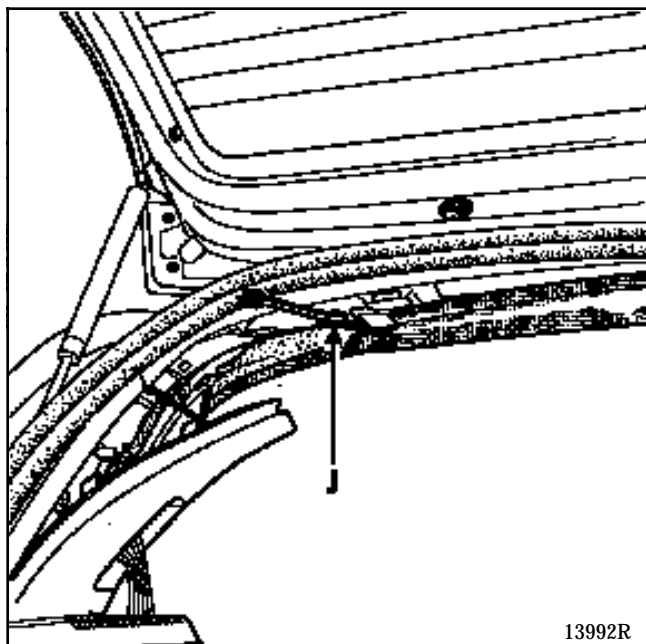
- the tailgate balancers and the mounting nuts (G),
- the tailgate .

### REMOVING THE HINGES



Partially pull back the luggage compartment seal in the area which comes into contact with the upper section of the side parcel shelf (H).

Using a flat blade screwdriver, remove the headlining retaining clips (I).

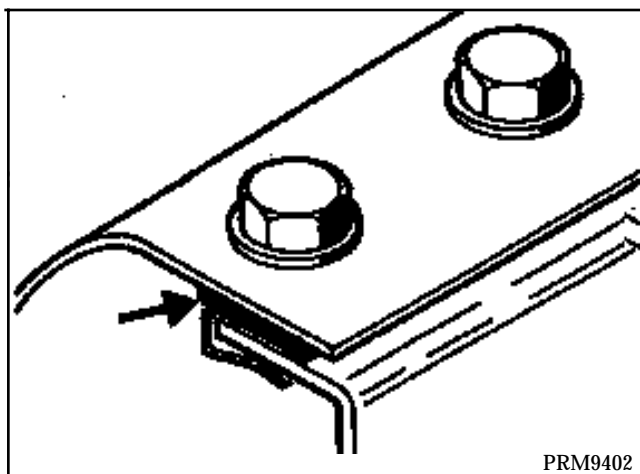


Unclip and pull the trim to one side.

Fit an open wrench between the lining and the headlining to hold the headlining to one side while the hinges are being removed.

Carefully pull the headlining to one side as indicated below to gain access to the hinge mounting nuts (J) ( 13 mm hexagonal nuts).

### REFITTING



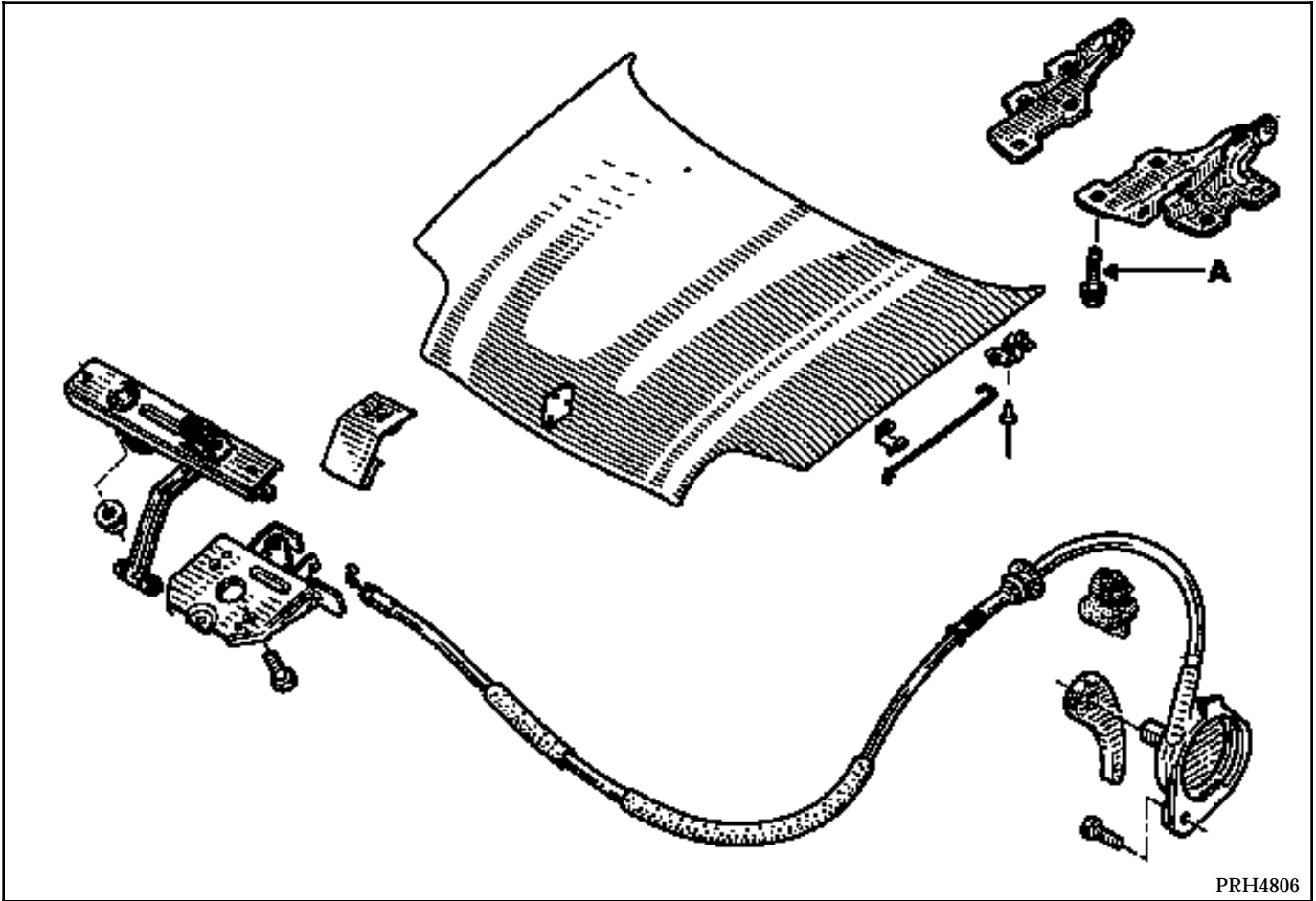
### IMPORTANT

**When refitting the hinges, do not forget to ensure the seal between them and the roof panel.**

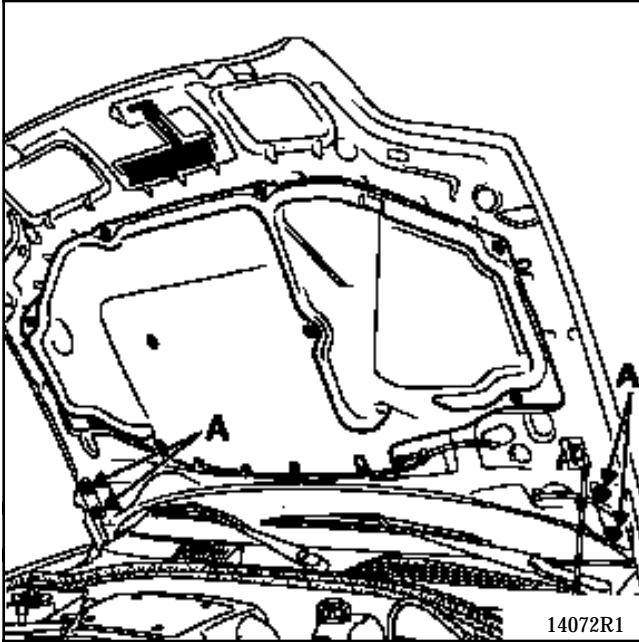
**To do this, use the mastic sealing bead, part number 77 11 170 230 (refer to the Technical Note 396A).**

**To adjust the tailgate and the tailgate lock after refitting, respect the opening clearances in section 40.**

**Adjustments must be made when the tailgate is fully refitted.**



### REMOVAL

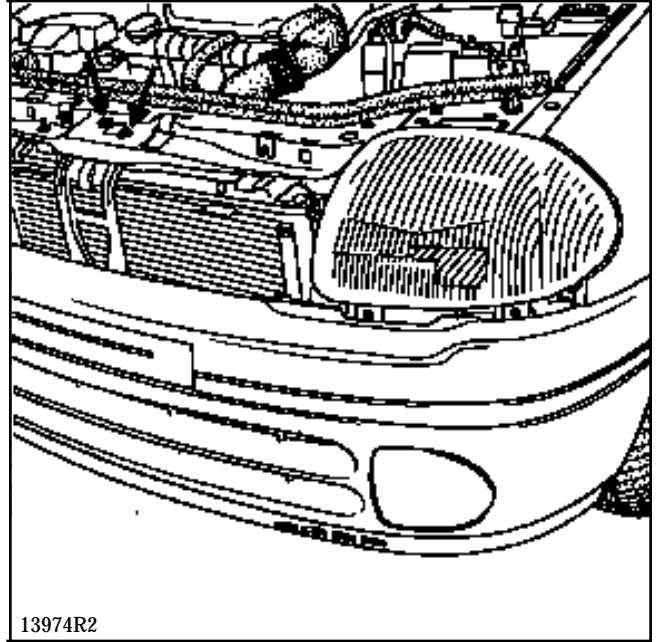


Disconnect the supply pipe from the nozzles fitted on the bonnet.

Remove:

- the mounting nuts (A) of the bonnet struts,
- the bonnet (two people).

### REFITTING



To correctly adjust the bonnet, move the lock and the bonnet struts to ensure the opening clearances specified in section 40.