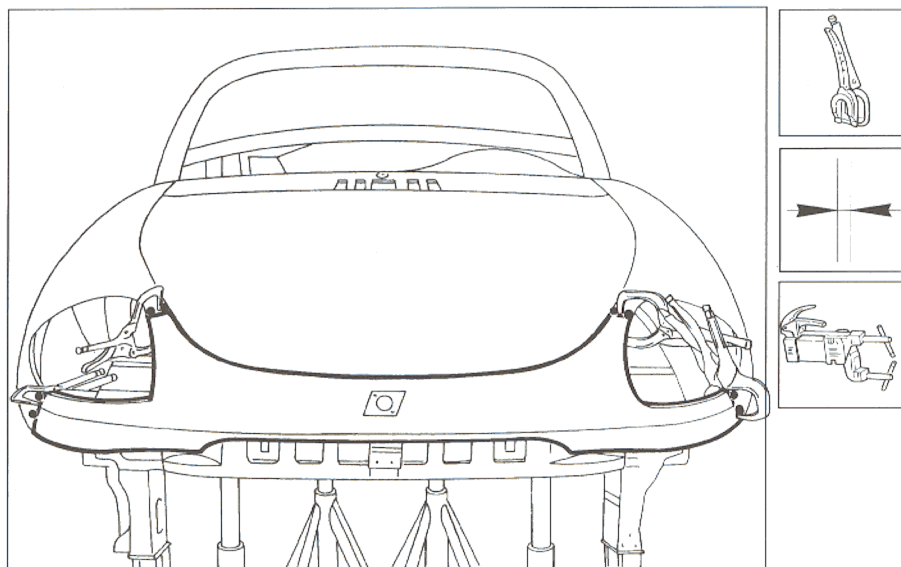


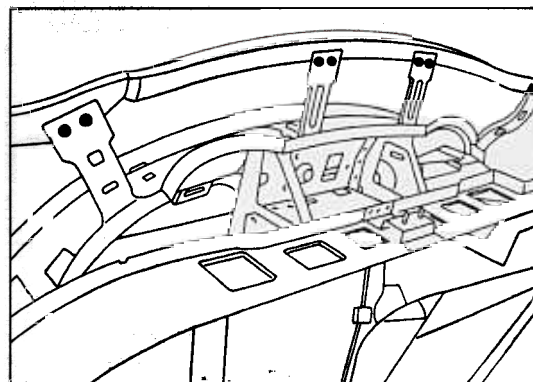
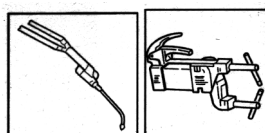
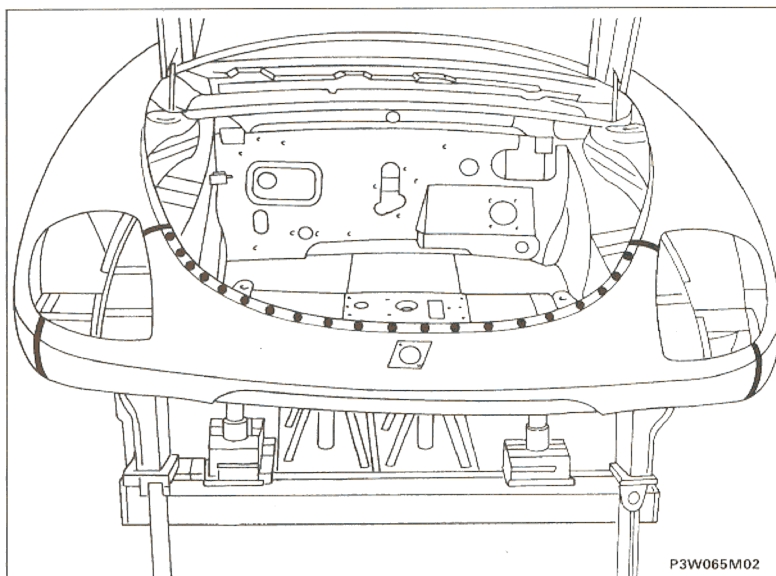
Positioning the replacement part

1. Carefully place the replacement part in position.
2. Fix the replacement part to the bodyshell using self-locking pliers and several spot welds as illustrated in the diagram.
3. Check that it is correctly positioned checking the alignment with the right and left front wings and with the bonnet lid.



Welding the spare part

1. Weld the areas which are joined with the left and right wings using an oxyacetylene canister.
2. Spot weld, using a spot welder, along the contact area between the support underneath and the outer front cover



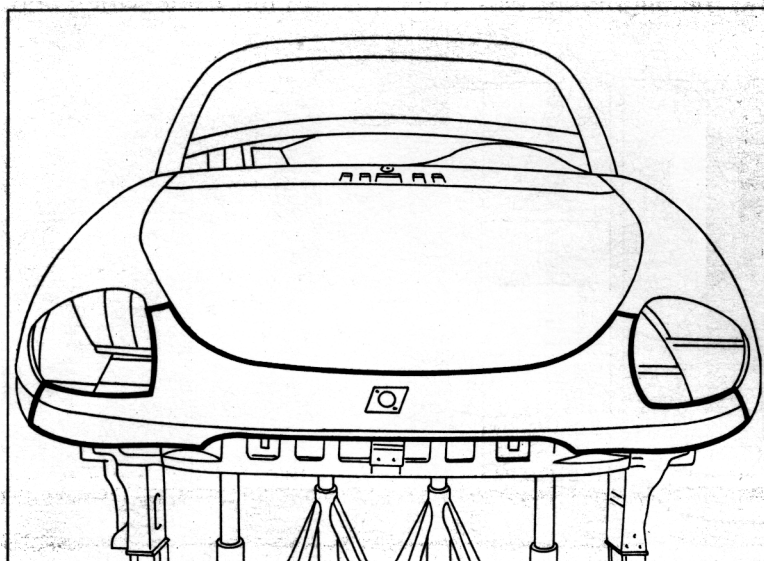
● ● ● ● Spot welding

Brass welding

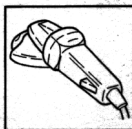
70.

Finishing operations

1. Correct any distortions to the panel using a hammer and dolly block.
2. Remove any weld slag using a disc grinder.

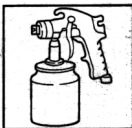
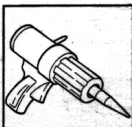
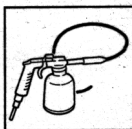
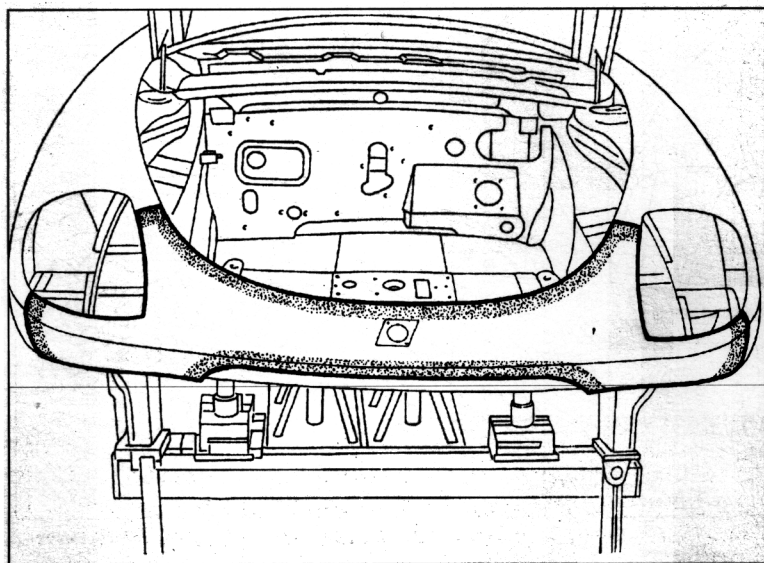


P3W063M01

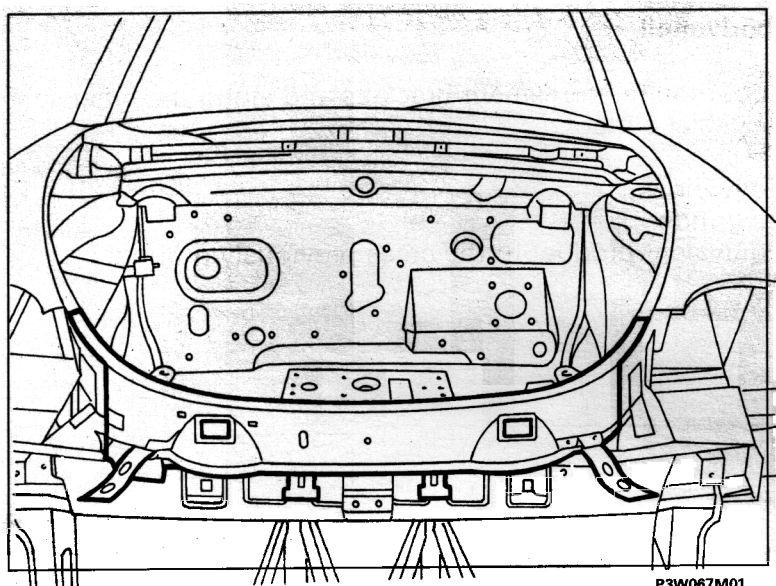


Protections

1. Apply the electro-phoretic protective treatment to the areas previously welded.
2. Seal the joints between the replacement part and the bodyshell using IVI 854210 transparent acrylic sealant or an equivalent product.
3. Proceed with the painting and waxing stage.



REPLACING OUTER COVER SUPPORT



The component for which the replacement procedure is described is highlighted in the diagram at the side.

Preliminary procedures

Establish the extent of the damage, check if there are distortions to the connected components by checking the bodyshell alignment figures, using suitable methods (jigs, templates or gauges).

Carry out any straightening operations required to the bodyshell before cutting the component.

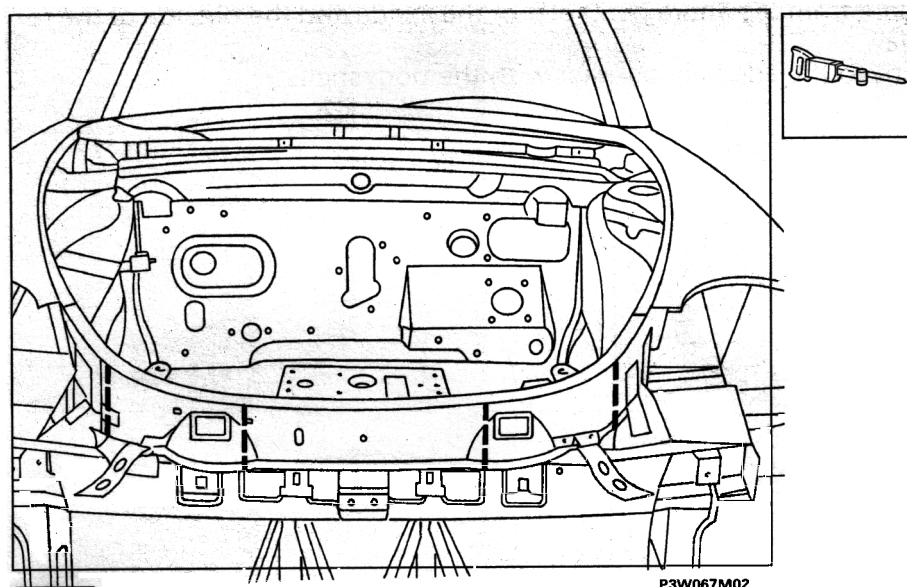
After this operation check that the components not being replaced are in tact.

Preliminary dismantling

Remove the moveable parts of the bodywork and the electrical and mechanical components which could impede the repair operations or be damaged during them. Also remove the outer front cover as described previously.

Removing

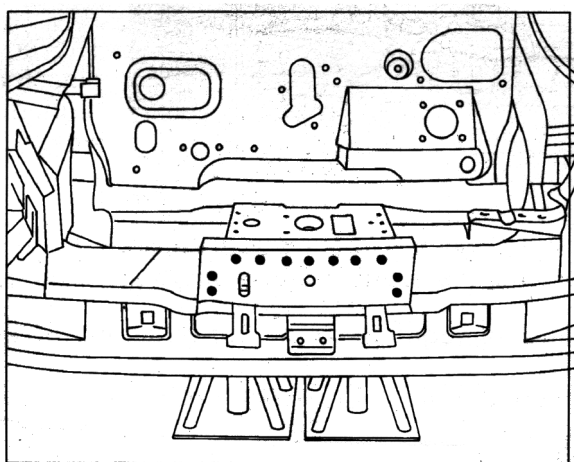
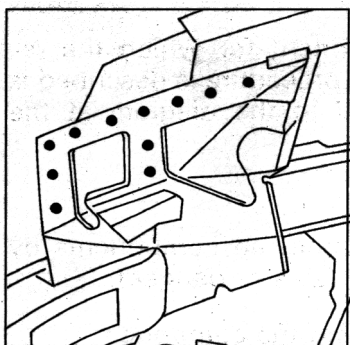
Cut the cover support using a power saw following the dotted lines shown in the diagram below.



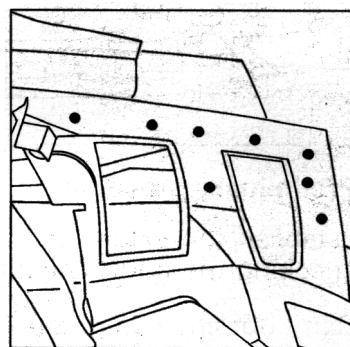
When carrying out the operations described, adhere strictly to the safety procedures. Wear protective shoes, ear-muffs and gloves during the cutting operations, masks for welding and gloves during the welding operations, and a protective mask and gloves during the painting operations.

Removing off cuts and preparing edges of bodyshell

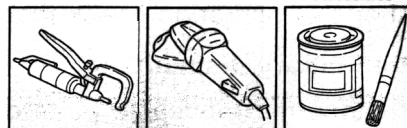
1. Remove the weld points along the perimeter of the reinforcement brackets and along the inner surface of the bonnet lid lock support using a special cutter.
2. Remove the metal off cuts using pliers.
3. Straighten the edges with a hammer and dolly block.
4. Remove the spot weld residues using a disc grinder.
5. Apply the electro-galvanizing paint or an equivalent product to the areas previously ground.



P3W068M01

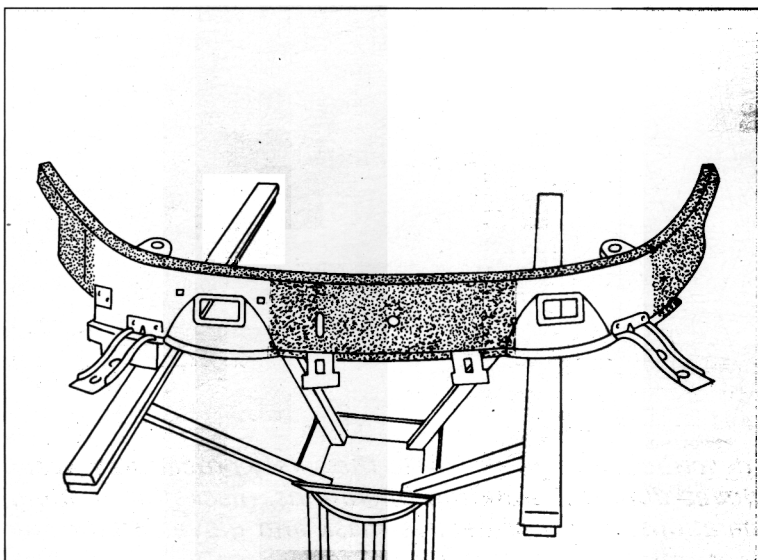


P3W068M03



Preparing the spare part

1. Remove the anti-corrosion treatment from the entire perimeter of the inside and the outside of the replacement part using a disc grinder.
2. Apply the electro-galvanizing paint to the edges in contact with the bodyshell.

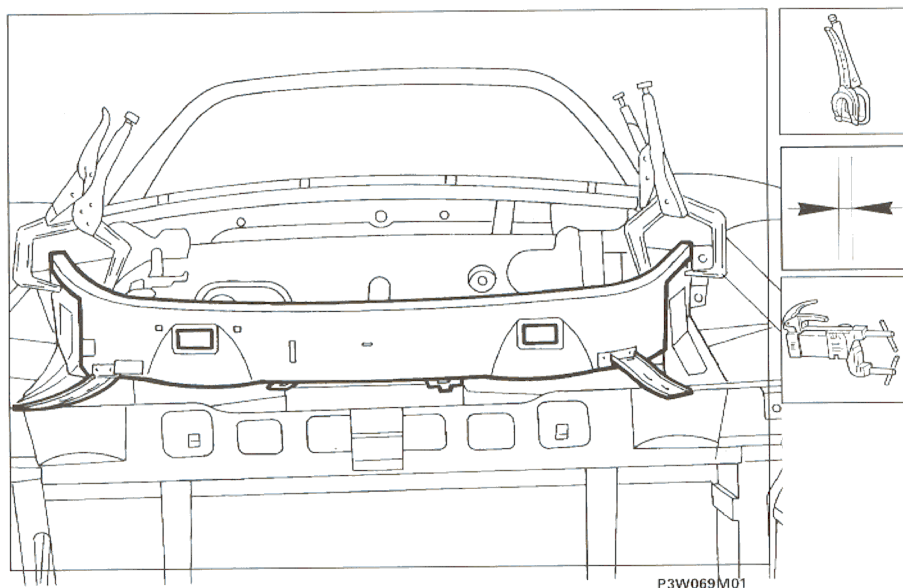


P3W068M04



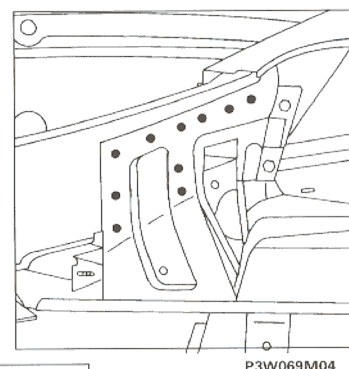
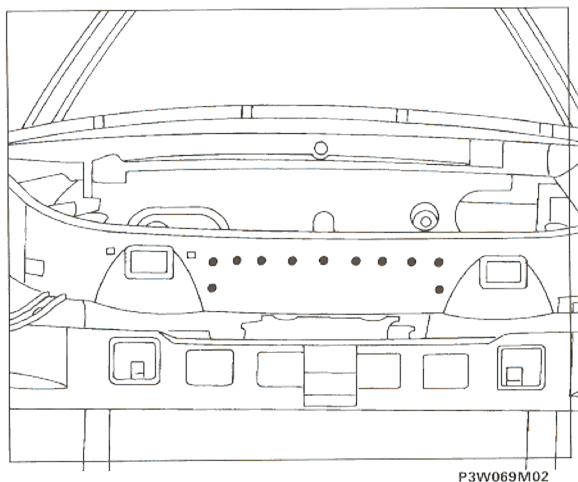
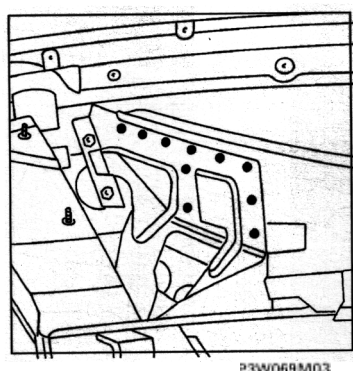
Positioning the replacement part

1. Carefully place the replacement part in position.
2. Fix the replacement part to the bodyshell using self-locking pliers.
3. Check that the support is correctly positioned on the bodyshell.



Welding the spare part

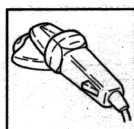
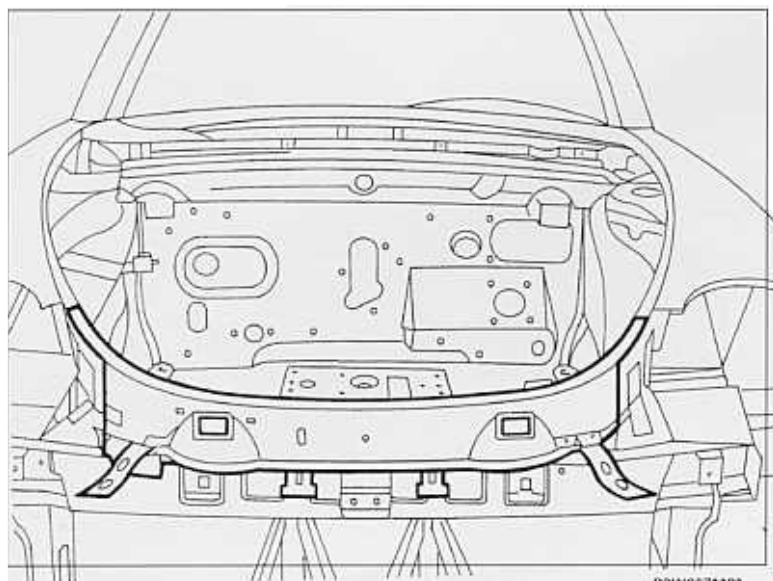
- 1 Carry out the spot welding using a spot welder along the contact area between the front cover support, the two side reinforcement brackets and the bonnet lid lock housing support.



● ● ● ● Spot welding

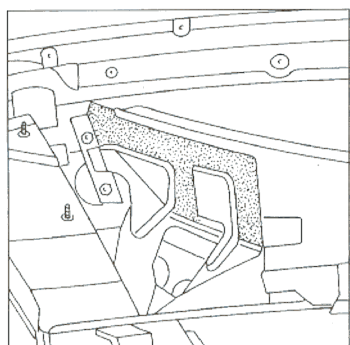
Finishing operations

1. Correct any distortions to the panel using a hammer and dolly block.
2. Remove any weld slag using a disc grinder.

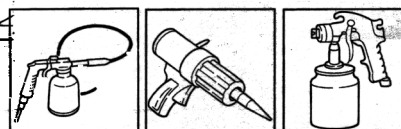
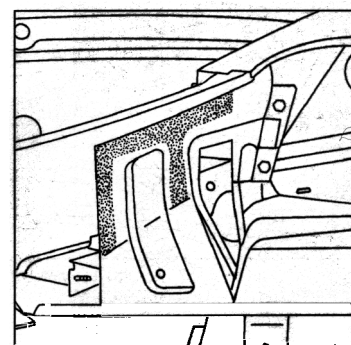
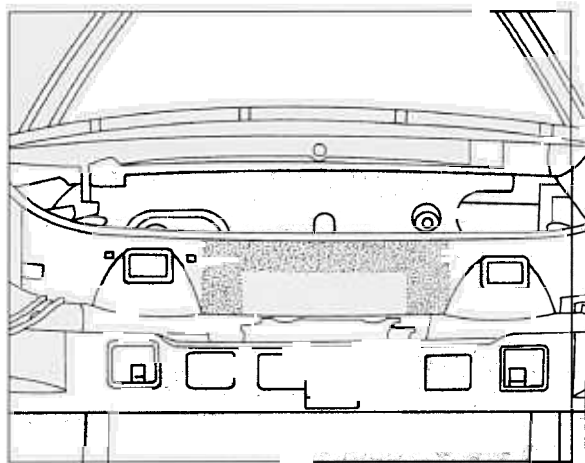


Protections

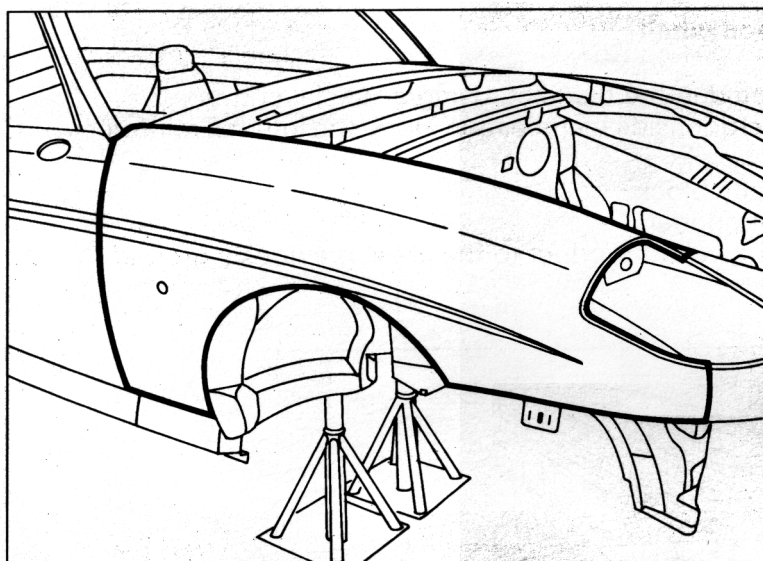
1. Apply the electro-phoretic protective treatment to the areas previously welded.
2. Seal the joints between the replacement part and the bodyshell using IVI 854210 transparent acrylic sealant or an equivalent product.
3. Proceed with the painting and waxing stage.



P3W070M02



REPLACING FRONT WING



P3W071M01

The component for which the replacement procedure is described is highlighted in the diagram at the side.

Preliminary procedures

Establish the extent of the damage, check if there are distortions to the connected components by checking the bodyshell alignment figures, using suitable methods (jigs, templates or gauges).

Carry out any straightening operations required to the bodyshell before cutting the component.

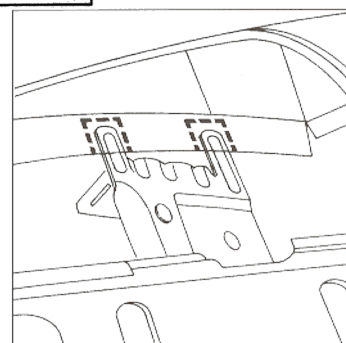
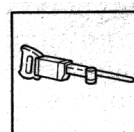
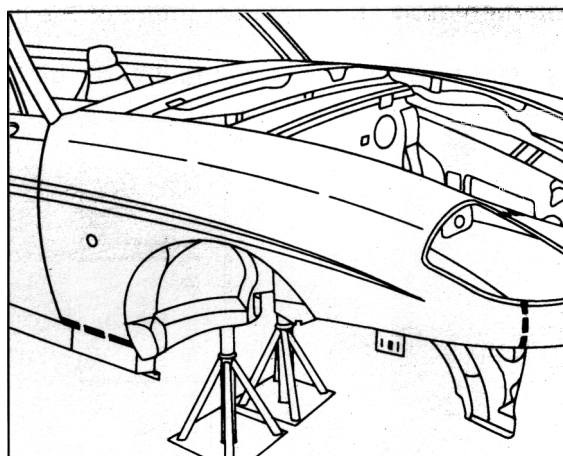
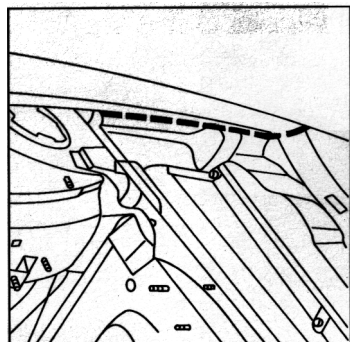
After this operation check that the components not being replaced are in tact.

Preliminary dismantling

Remove the moveable parts of the bodywork and the electrical components which could impede the repair operations or be damaged during them.

Removing

Cut the front wing using a power saw following the dotted lines shown in the diagrams below.

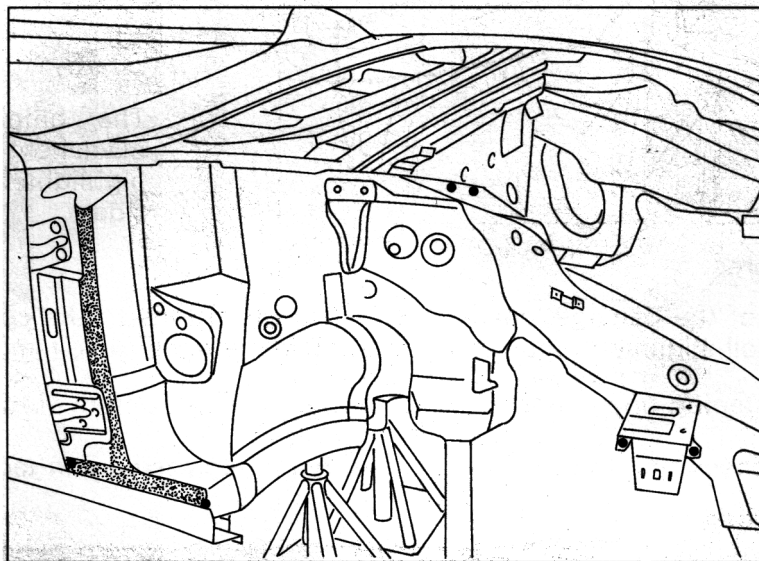
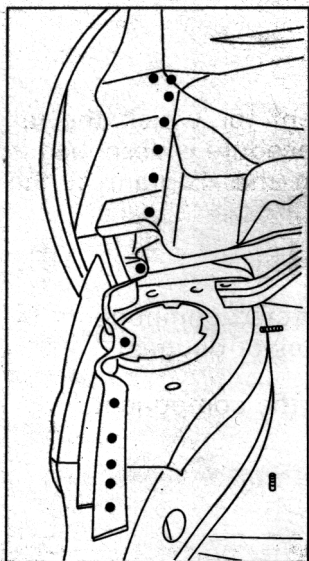


When carrying out the operations described, adhere strictly to the safety procedures. Wear protective shoes, ear-muffs and gloves during the cutting operations, masks for welding and gloves during the welding operations, and a protective mask and gloves during the painting operations.

70.

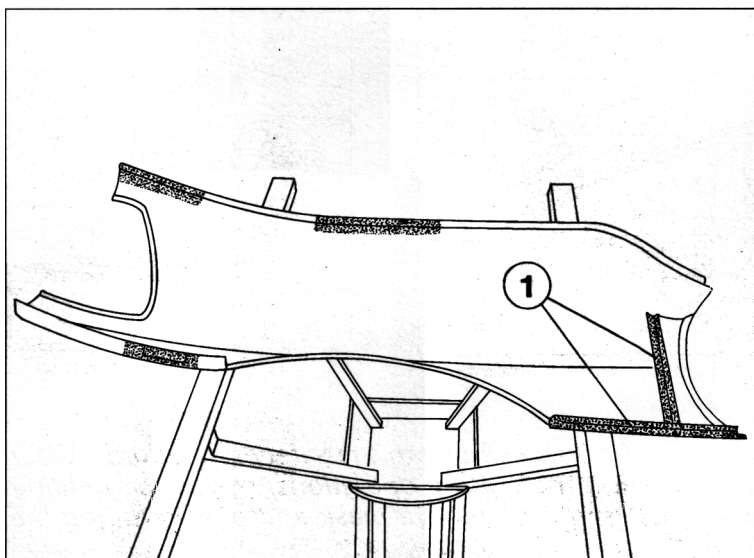
Removing off cuts and preparing edges of bodyshell

1. Remove the weld points in the areas illustrated in the diagram, using a special cutter.
2. Remove the sealant on the edges of the underdoor side member and along the internal reinforcement.
3. Remove the metal off cuts using pliers.
4. Straighten the edges with a hammer and dolly block.
5. Remove the spot weld residues using a disc grinder.
6. Apply the electro-galvanizing paint or an equivalent product to the areas previously ground.



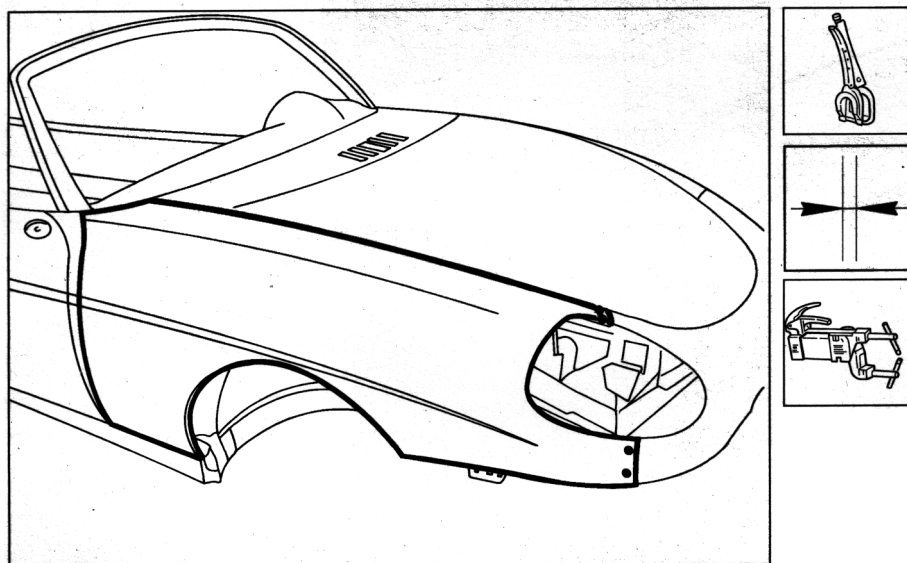
Preparing the spare part

1. Renew the sealant (1) on the replacement part in the areas illustrated.
2. Remove the anti-corrosion treatment from the entire perimeter of the inside and the outside of the replacement part using a disc grinder.
3. Apply the electro-galvanizing paint to the edges in contact with the bodyshell.



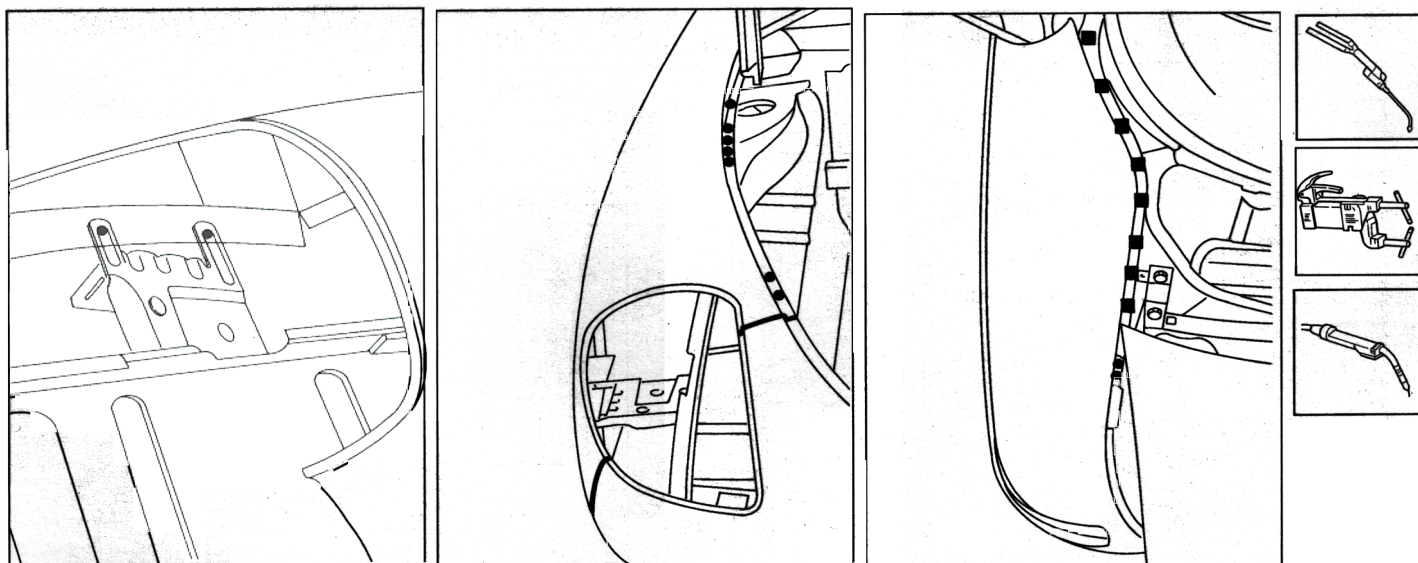
Positioning the replacement part

1. Carefully place the replacement part in position.
2. Fix the replacement part to the bodyshell using self-locking pliers and several spot welds as illustrated in the diagram.
3. Check that it is correctly positioned checking the alignment and the uniformity of the opening with the door, the bonnet lid, the air intake cover and the external front cover.
4. After having carried out the appropriate checks, tack the replacement part with several spot welds along the areas in contact with the front cover.



Welding the spare part

1. Carry out brass welding using an oxy-acetylen canister in the areas in contact with the external front cover.
2. Carry out spot welding using a spot welder along the area where the front suspension turret and mounting bracket are in contact.
3. Carry out MIG welding for filling along the area in contact with the side panel.
4. Carry out continuous MIG welding at the edges where the wing is in contact with the underdoor side member.



P3W073M02

P3W073M03

●●●● Spot welding

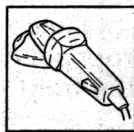
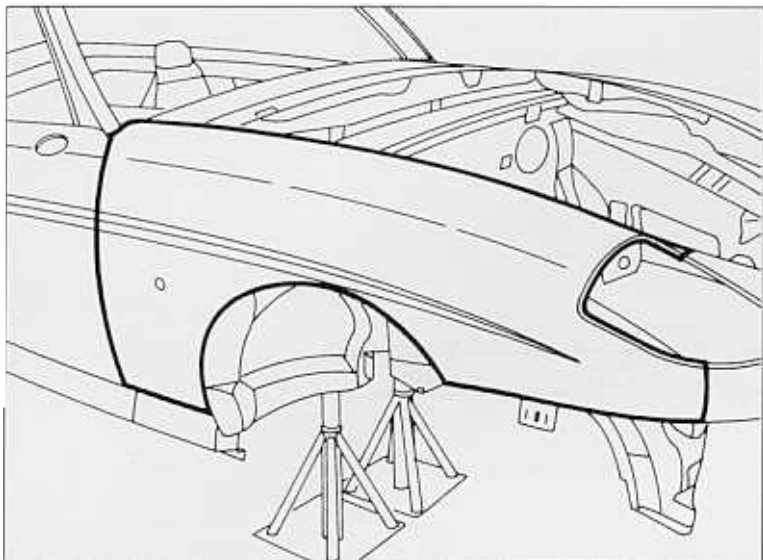
■■■■ MIG welding for filling

Brass welding

70.

Finishing operations

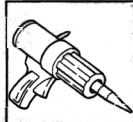
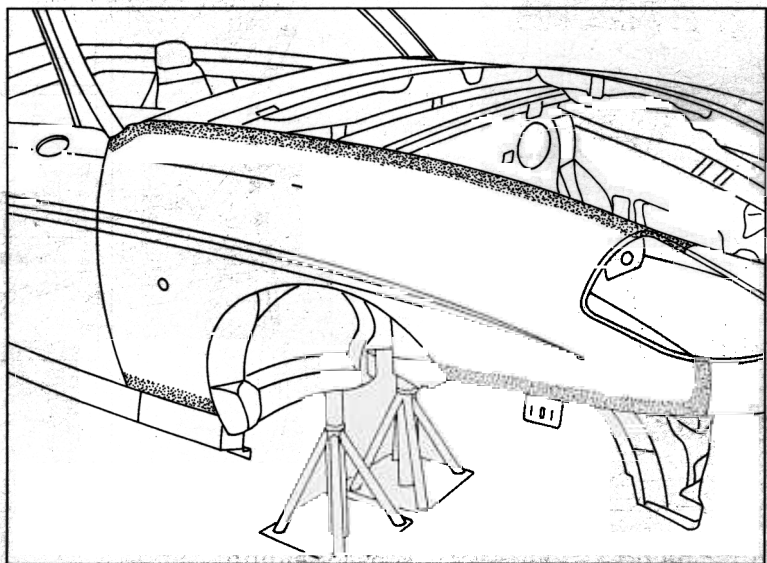
1. Correct any distortions to the panel using a hammer and dolly block.
2. Remove any weld slag using a disc grinder.



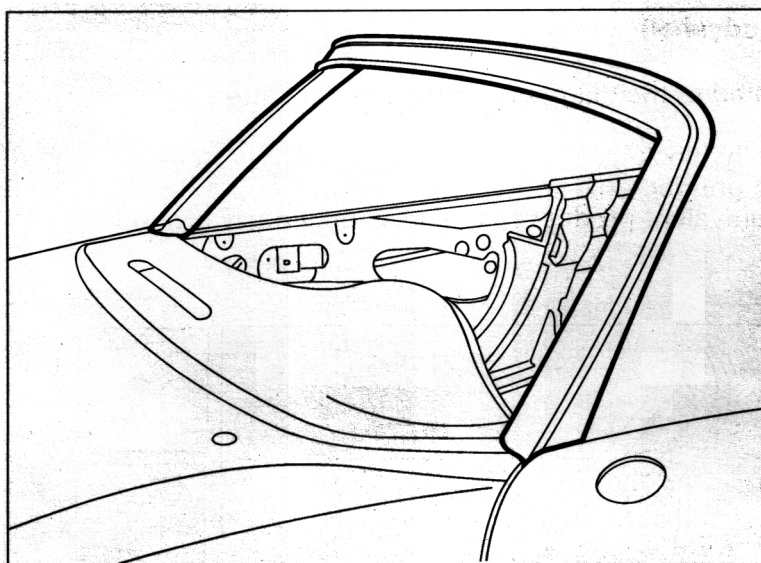
P3W071 M01

Protections

1. Apply the electro-phoretic protective treatment to the areas previously welded.
2. Seal the joints between the replacement part and the bodysell using IVI 854210 transparent acrylic sealant or an equivalent product.
3. Proceed with the painting and waxing stage.



REPLACING COMPLETE WIND-SCREEN SEAL



P3W075M01

The component for which the replacement procedure is described is highlighted in the diagram at the side.

Preliminary procedures

Establish the extent of the damage, check if there are distortions to the connected components by checking the bodyshell alignment figures, using suitable methods (jigs, templates or gauges).

Carry out any straightening operations required to the bodyshell before cutting the component.

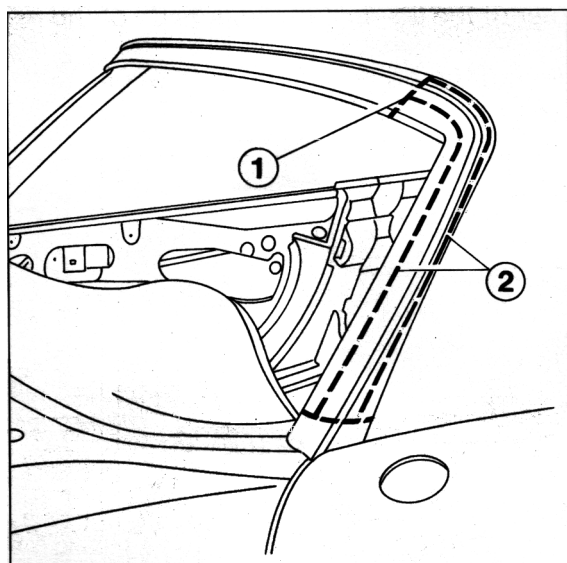
After this operation check that the components not being replaced are in tact.

Preliminary dismantling

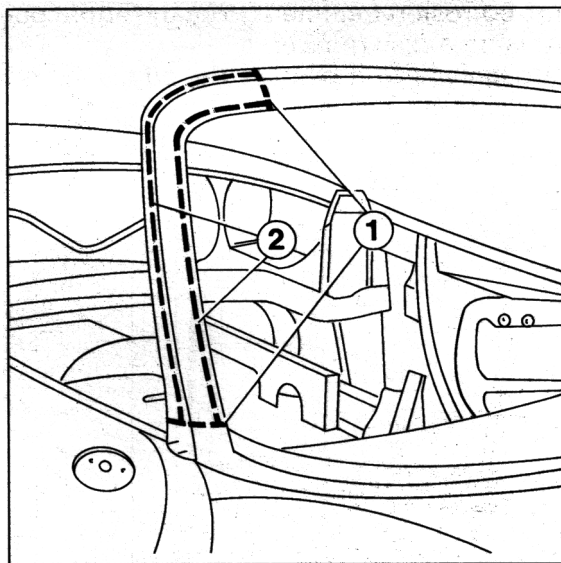
Remove the moveable parts of the bodywork and the interior fittings which could impede the repair operations or be damaged during them.

Removing

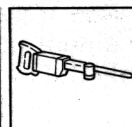
Cut the windscreen seal cover using a power saw along the dotted lines (1) and using a hammer and chisel along the dotted lines (2), shown in the diagrams below.



P3W075M02



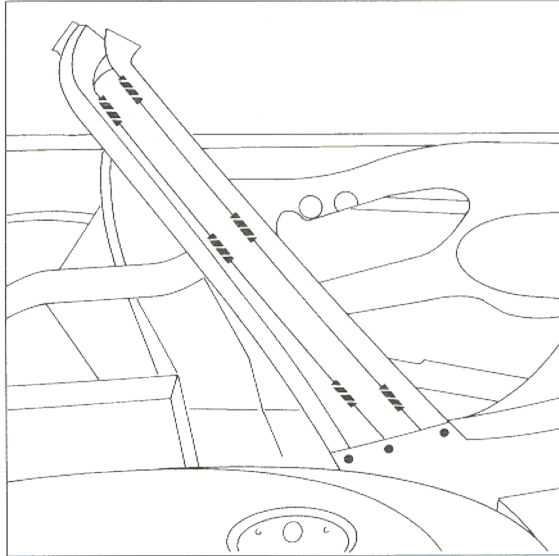
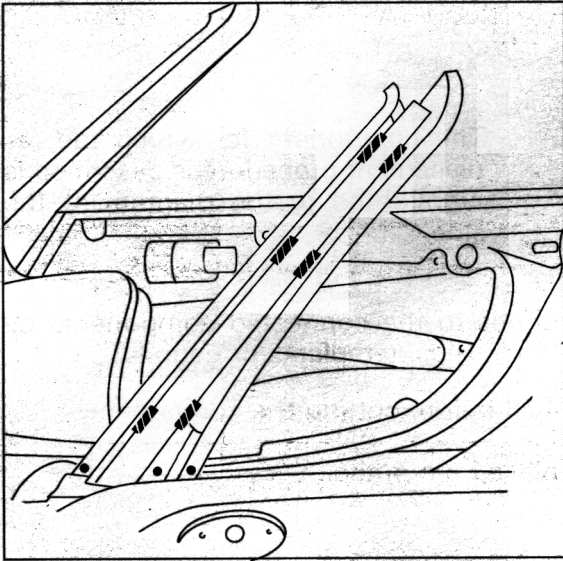
P3W075M03



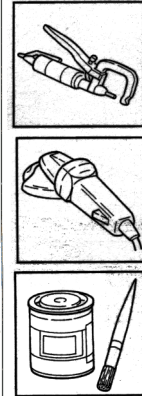
When carrying out the operations described, adhere strictly to the safety procedures. Wear protective shoes, ear-muffs and gloves during the cutting operations, masks for welding and gloves during the painting operations.

Removing off cuts and preparing edges of bodyshell

1. Remove the weld points in the areas illustrated in the diagram using a special cutter.
2. Remove the metal off cuts using pliers.
3. Straighten the edges with a hammer and dolly block.
4. Remove the spot weld residues using a disc grinder.
5. Apply the electro-galvanizing paint or an equivalent product to the areas previously ground.

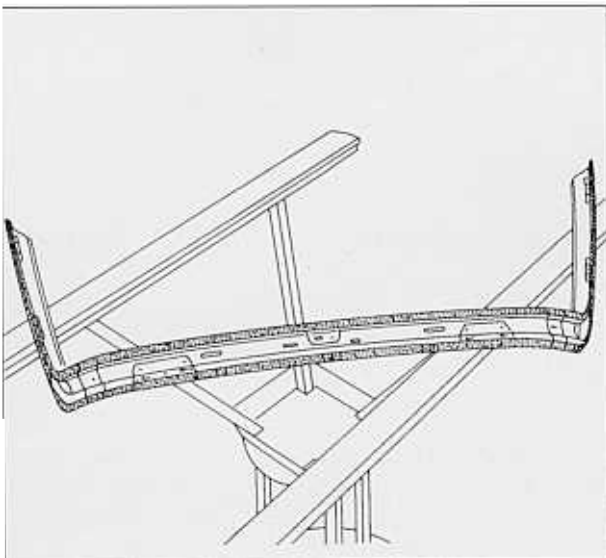


P3W076M02

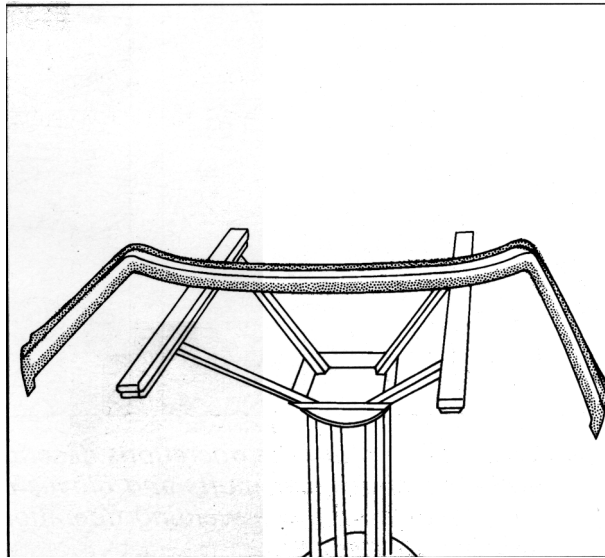


Preparing the replacement internal reinforcement and the outer cover for the windscreen seal

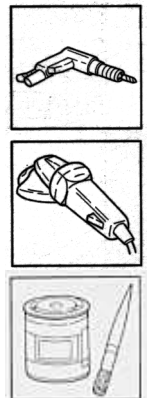
1. Remove the anti-corrosion treatment from the entire perimeter of the inside and the outside of the replacement part using a disc grinder.
2. Apply the electro-galvanizing paint to the edges in contact with the bodyshell.



P3W076M03

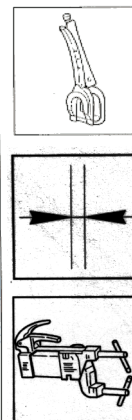
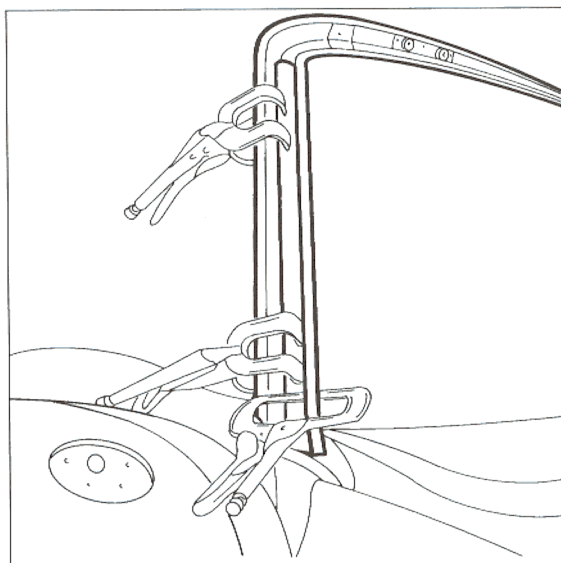
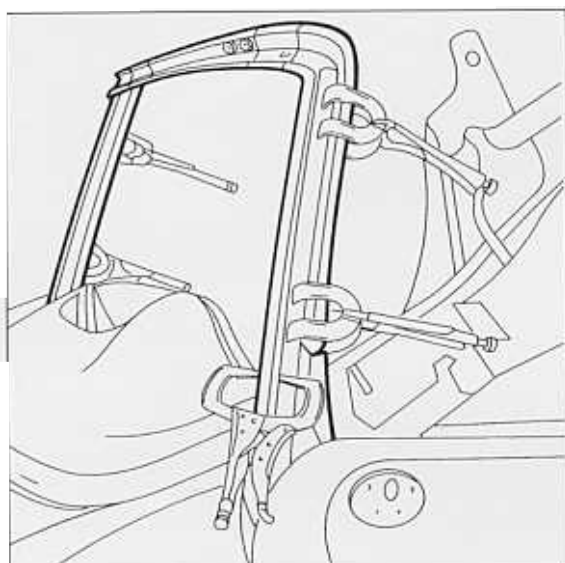


P3W076M04



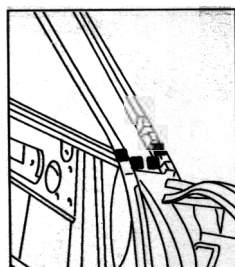
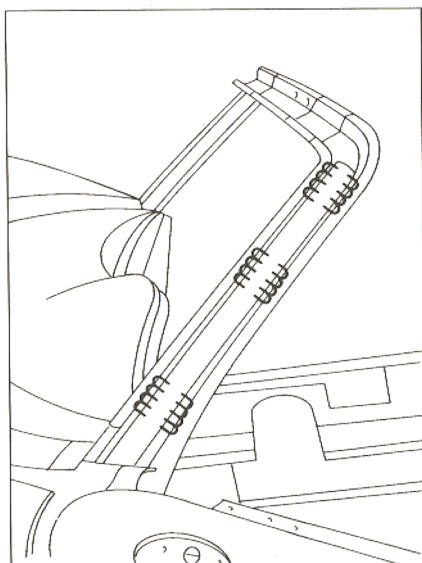
Positioning the replacement internal reinforcement

1. Carefully place the replacement part in position.
2. Fix the replacement part to the bodyshell using self-locking pliers
3. Check that it is correctly positioned checking the alignment figures for the reinforcement.

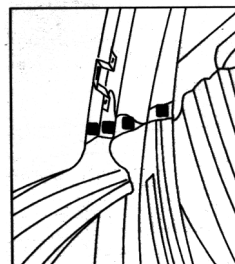


Welding the spare part

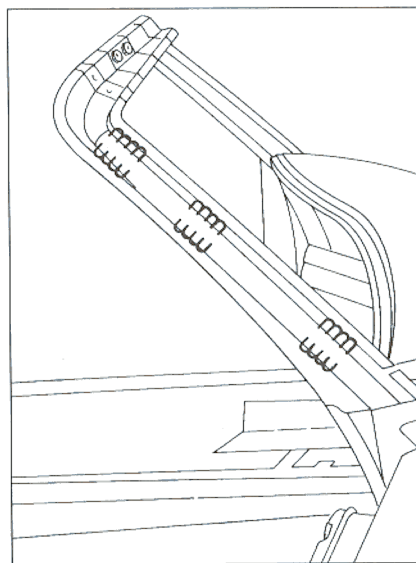
1. Carry out continuous MIG welding along the windscreen pillar reinforcement.
2. Carry out MIG welding for filling along the contact area between the reinforcement and the pillar cover.



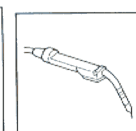
P3W077M04



P3W077M05



P3W077M06



■■■■ MIG welding for filling

~~~~~ Continuous MIG welding

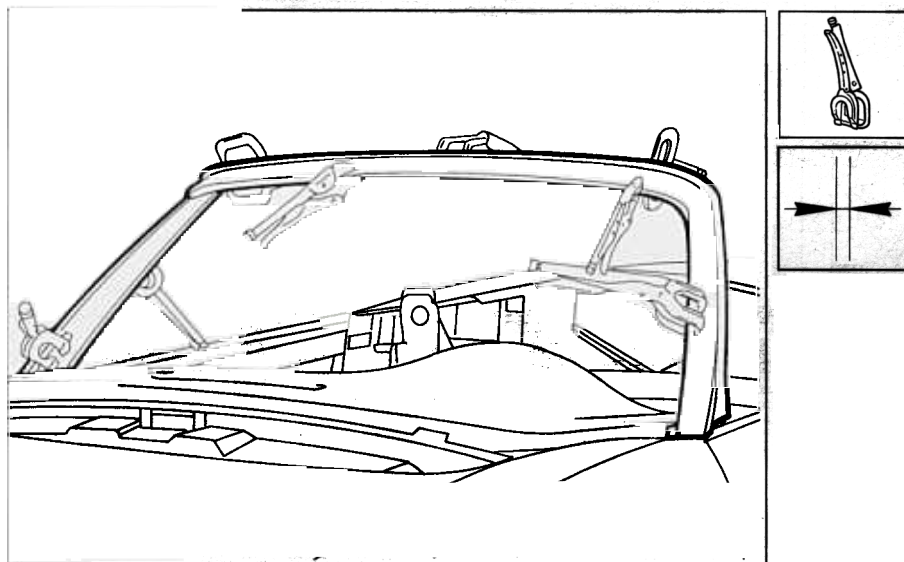


### Replacing body panels

#### 70.

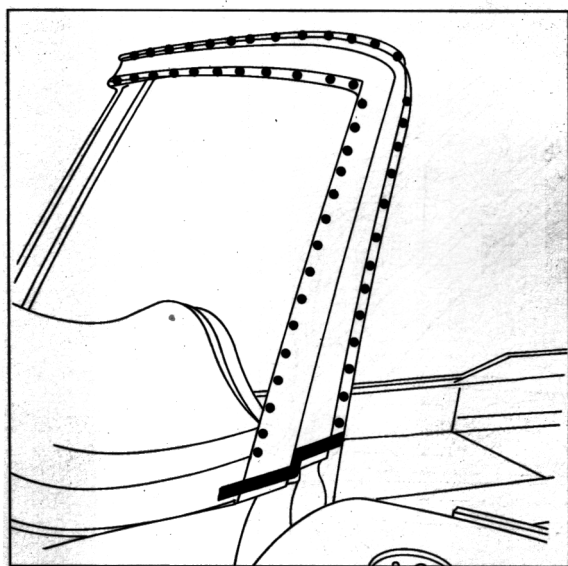
##### Positioning the replacement windscreen seal cover

1. Carefully place the replacement part in position.
2. Fix the replacement part to the bodyshell using self-locking pliers
3. Check that it is correctly positioned checking the alignment with the lowering window glass and with the windscreen.

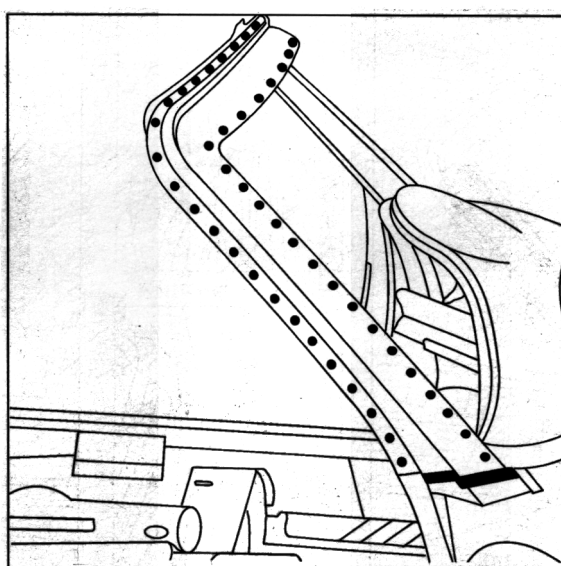


##### Welding the spare part

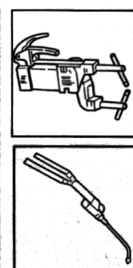
1. Carry out spot welding using a spot welder along the outer edges of the replacement part..
2. Carry out brass welding using an oxy-acetylene canister in the area in contact with the front pillar cover.



Spot welding

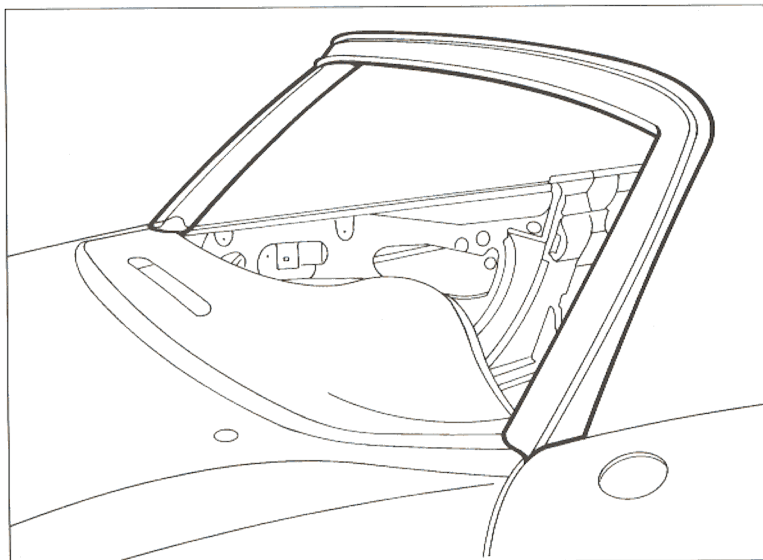


Brass welding

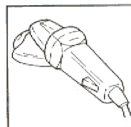


#### Finishing operations

1. Correct any distortions to the panel using a hammer and dolly block.
2. Remove any weld slag using a disc grinder.

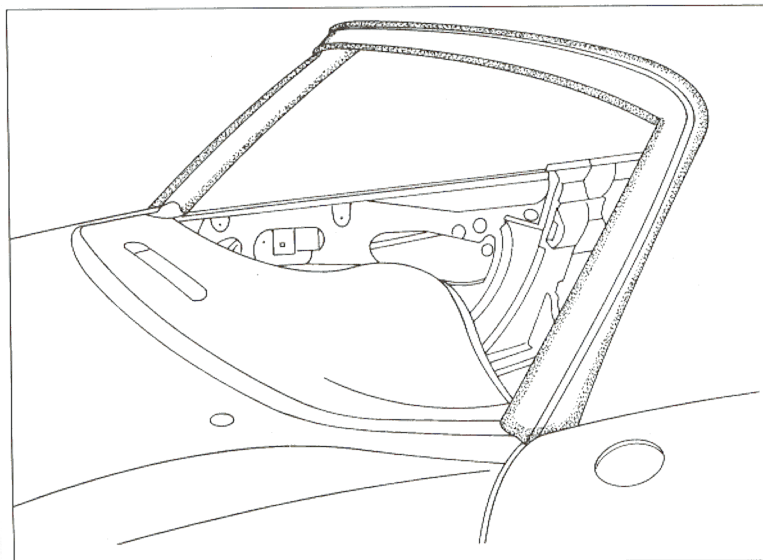


P3W075M01

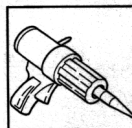


#### Protections

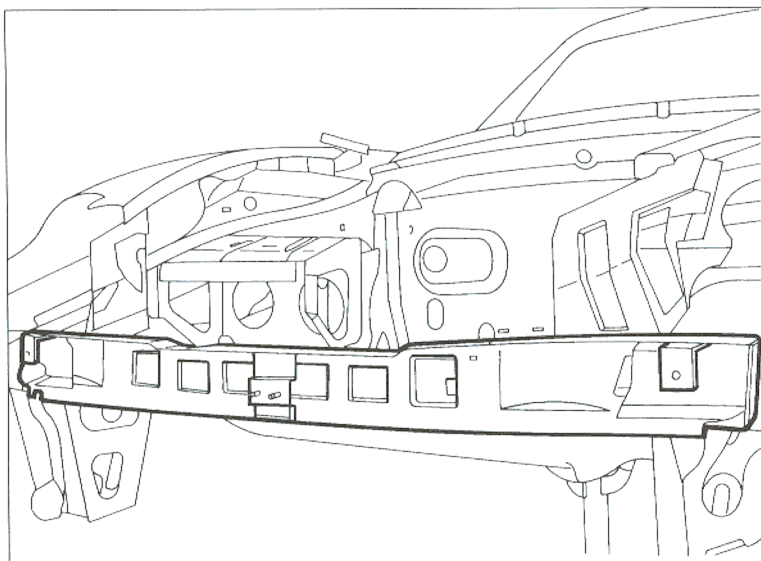
1. Apply the electro-phoretic protective treatment to the reas previously welded.
2. Seal the joins between the two parts and with the bodyshell using IVI 854210 transparent acrylic sealant or an equivalent product.
3. Proceed with the painting and waxing stage.



P3W078M01



## 70.



P3W080M01

### REPLACING FRONT CROSS MEMBER

The component for which the replacement procedure is described is highlighted in the diagram at the side.

#### Preliminary procedures

Establish the extent of the damage, check if there are distortions to the connected components by checking the bodyshell alignment figures, using suitable methods (jigs, templates or gauges).

Carry out any straightening operations required to the bodyshell before cutting the component.

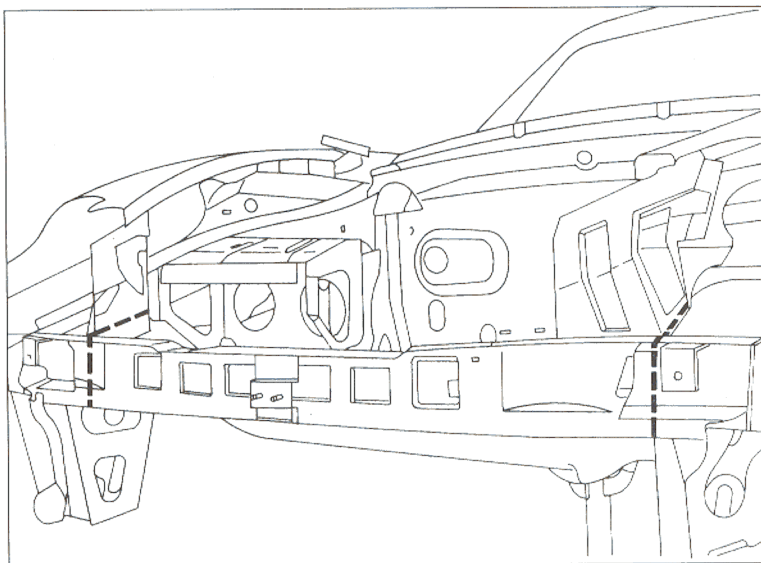
After this operation check that the components not being replaced are in tact.

#### Preliminary dismantling

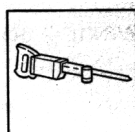
Remove the moveable parts of the bodywork and the electrical and mechanical components which could impede the repair operations or be damaged during them. Also remove the external front cover complete with support, as illustrated previously in this manual.

#### Removing

Cut the front cross member using a power saw along the side reinforcement brackets and the edges of the actual cross member.



P3W080M02

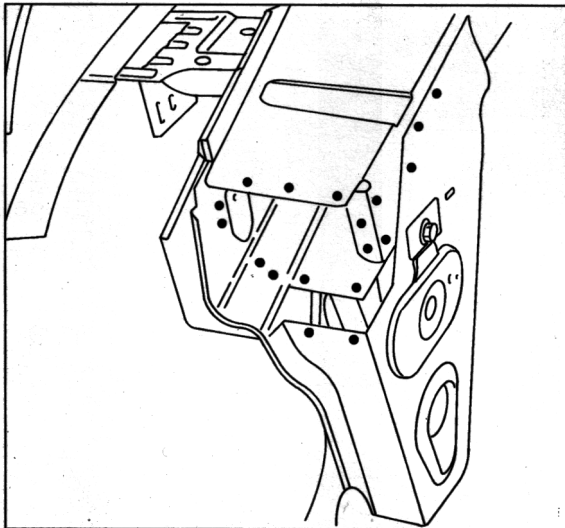


*When carrying out the operations described, adhere strictly to the safety procedures. Wear protective shoes, ear-muffs and gloves during the cutting operations, masks for welding and gloves during the welding operations, and a protective mask and gloves during the painting operations.*

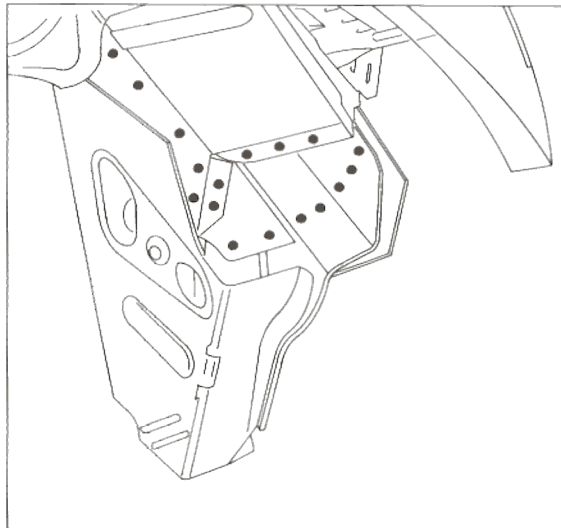


### Removing off cuts and preparing edges of bodyshell

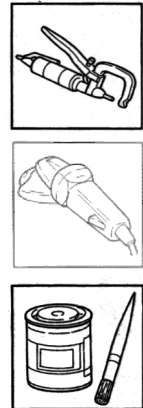
1. Remove the weld points in the areas illustrated in the diagram using a special cutter.
2. Remove the metal off cuts using pliers.
3. Straighten the edges with a hammer and dolly block.
4. Remove the spot weld residues using a disc grinder.
5. Apply the electro-galvanizing paint or an equivalent product, to the areas previously ground.



P3W081 M01

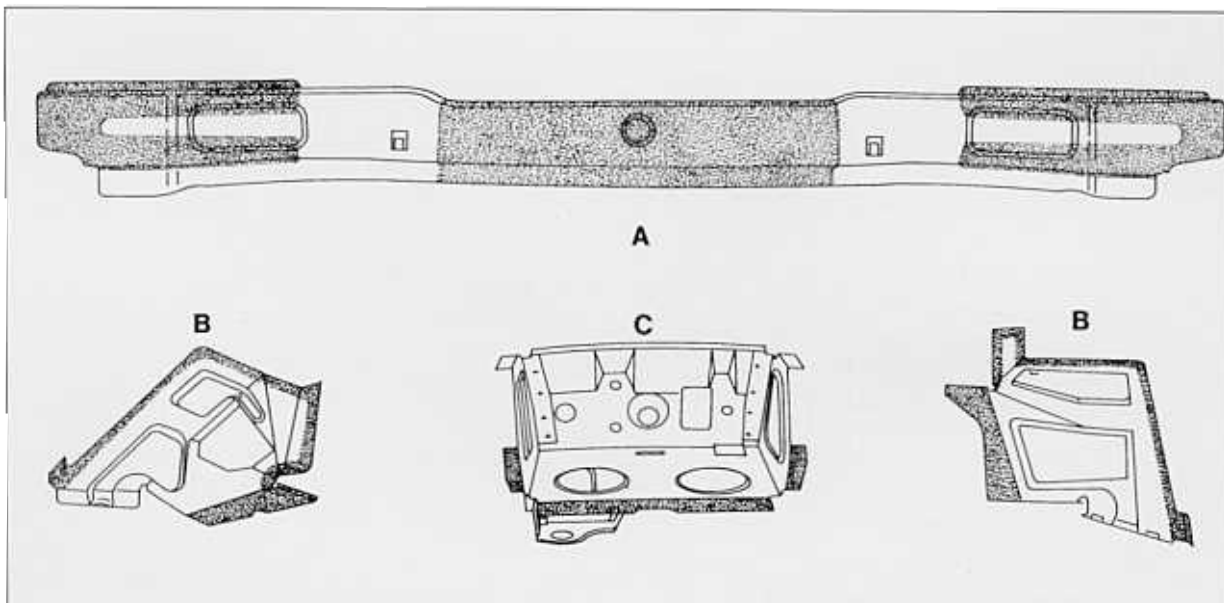


P3W081 M02



### Preparing the replacement parts

1. A- Front cross member; B- Reinforcement brackets; C- Bonnet lid lock support.
1. Remove the anti-corrosion treatment from the entire perimeter of the inside and the outside of the replacement part using a disc grinder.
2. Apply the electro-galvanizing paint to the edges in contact with the bodyshell.

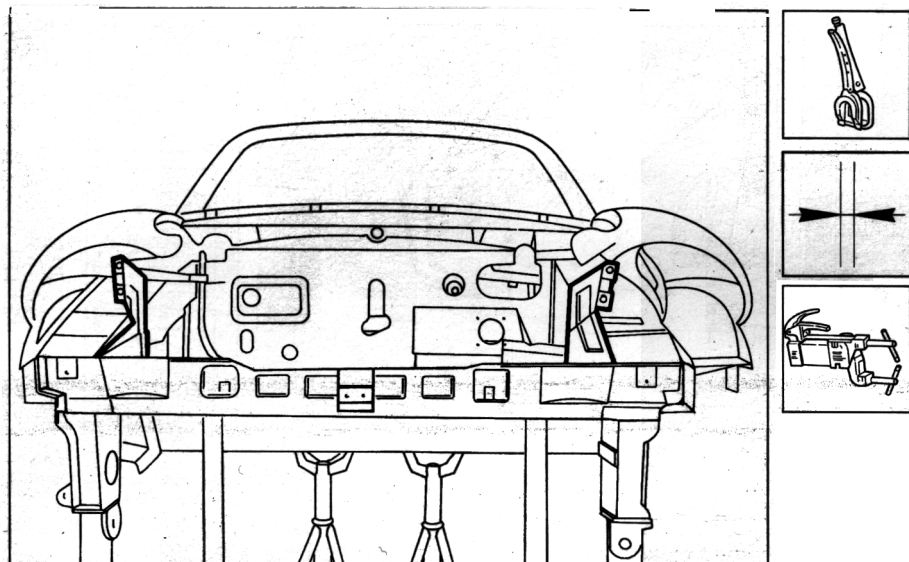


### Replacing body panels

#### 70.

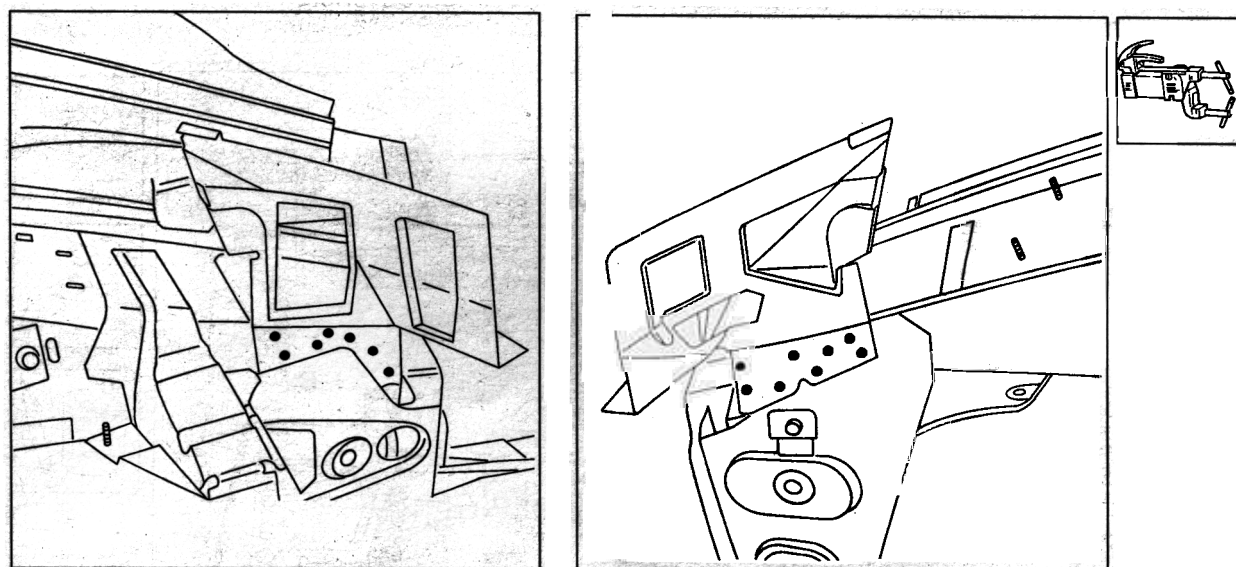
##### Positioning replacement reinforcement brackets

1. Position the front cross member and the two reinforcement brackets.
2. Fix the replacement parts to the bodyshell using self-locking pliers and with several spot welds fix the brackets to the side panel.
3. Check that the brackets are correctly positioned in relation to the cross member, then remove the front cross member.



##### Welding the spare part

- 1 Spot weld the reinforcement brackets to the side panels using a spot welder.

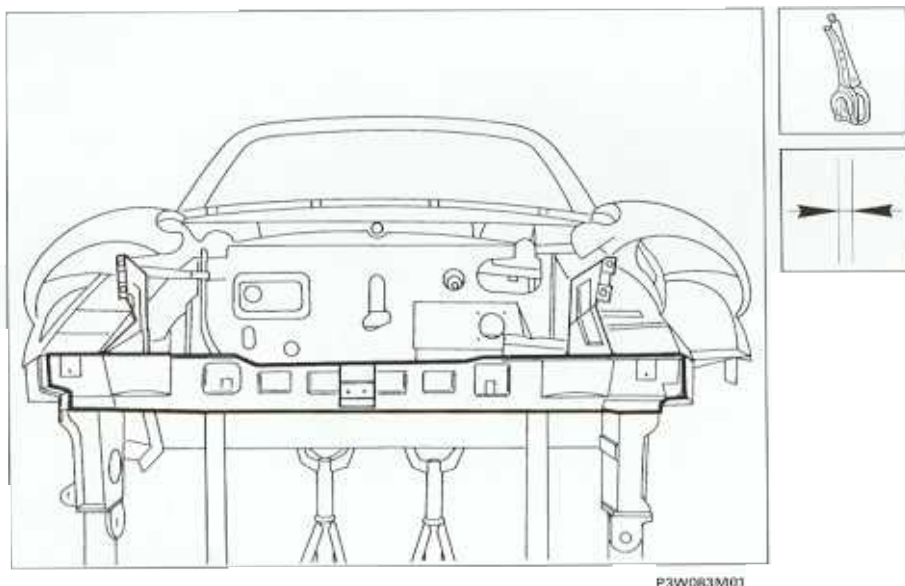


P3W082M03

● ● ● ● Spot welding

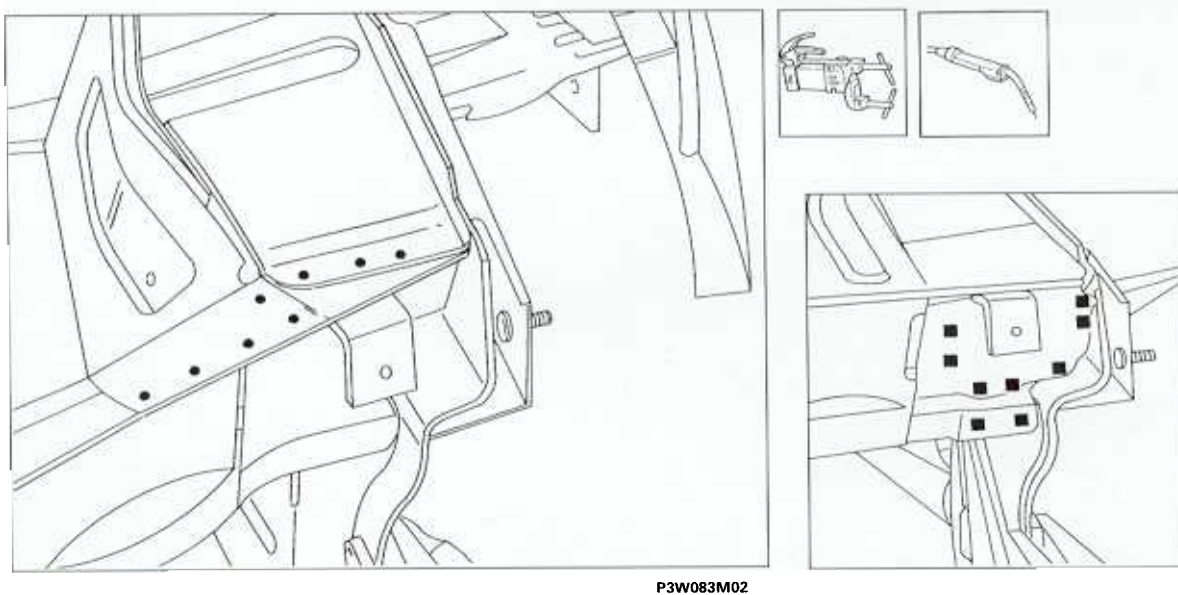
#### Positioning the replacement cross member

1. Place the replacement cross member in position.
2. Fix the replacement part to the bodyshell and to the reinforcement brackets using self-locking pliers and with several spot welds fix the front cross member to the side panels.
3. Check that the cross member is correctly positioned using the appropriate templates.



#### Welding the spare part

1. Carry out MIG welding for filling in the contact areas between the cross member and the side panels.
2. Spot weld the reinforcement brackets to the cross member using a spot welder.
3. Carry out the same welding operations on the other side of the replacement part not shown in the diagram.



●●●● Spot welding

■ ■ ■ ■ MIG welding for filling



# Bodywork

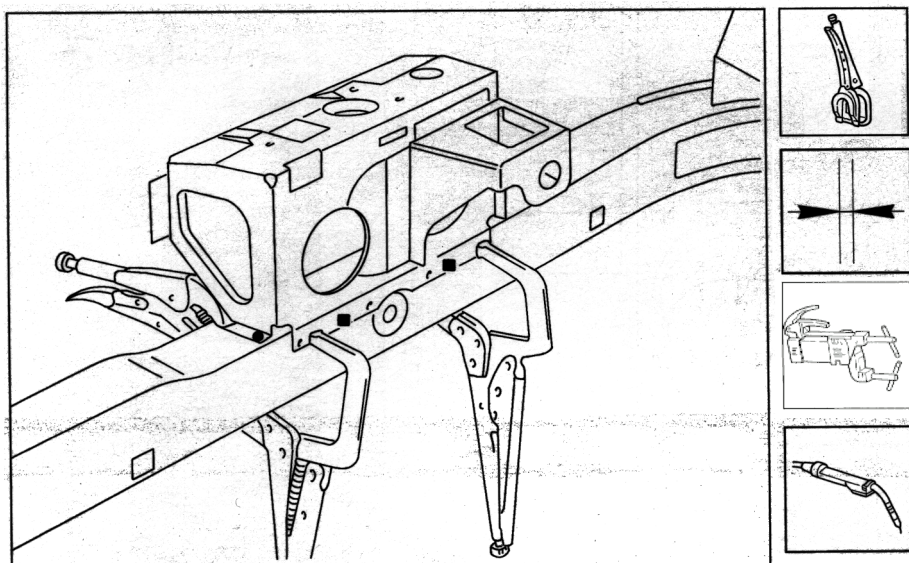
## Replacing body panels

### 70.

**Fiat barchetta**

#### Positioning the replacement bonnet lid lock support

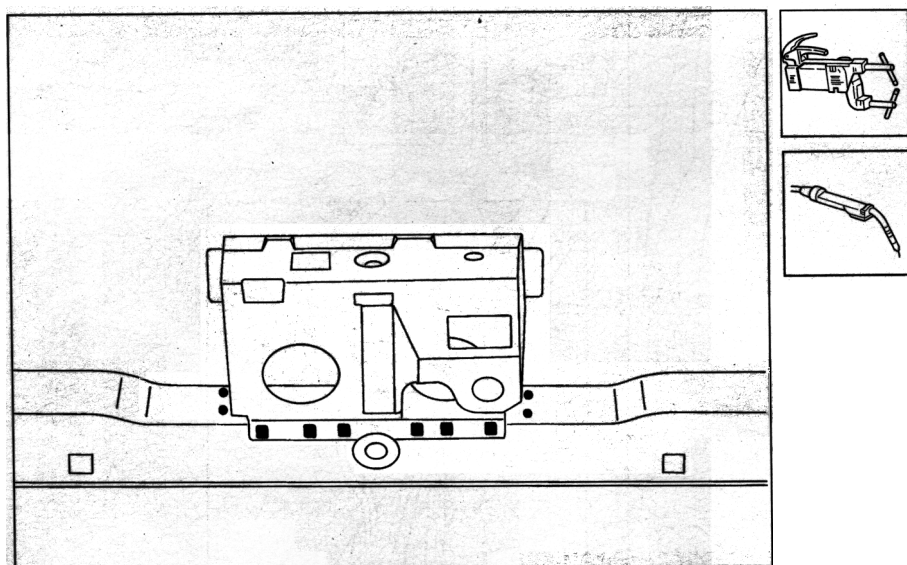
1. Place the bonnet lid lock support in position.
2. Fix the replacement part to the cross member using self-locking pliers and fix it temporarily with several spot welds.
3. Check that the replacement part is correctly positioned on the cross member.



P3W084M01

#### Welding the spare part

1. Carry out MIG welding for filling in the inner contact area between the support and the cross member.
2. Spot weld the lock support in the side areas in contact with the cross member.



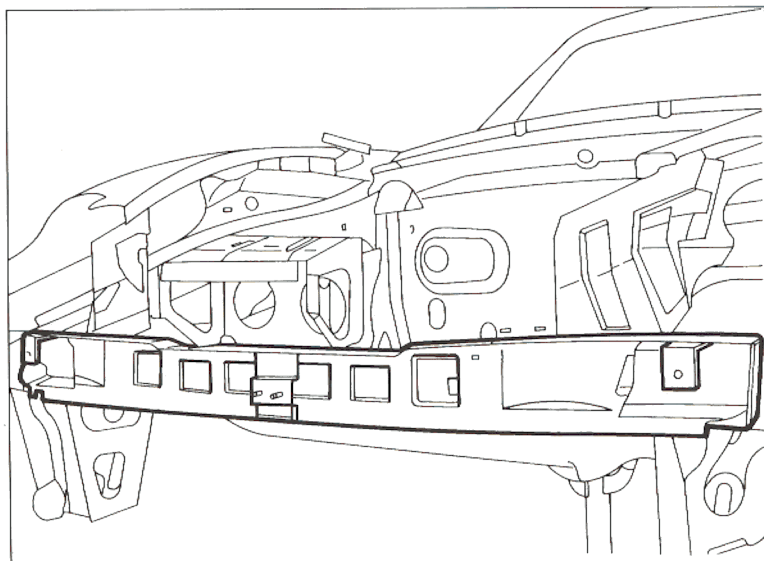
P3W084M02

●●●● Spot welding

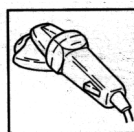
■■■■ MIG welding for filling

#### Finishing operations

1. Correct any distortions to the panel using a hammer and dolly block.
2. Remove any weld slag using a disc grinder.

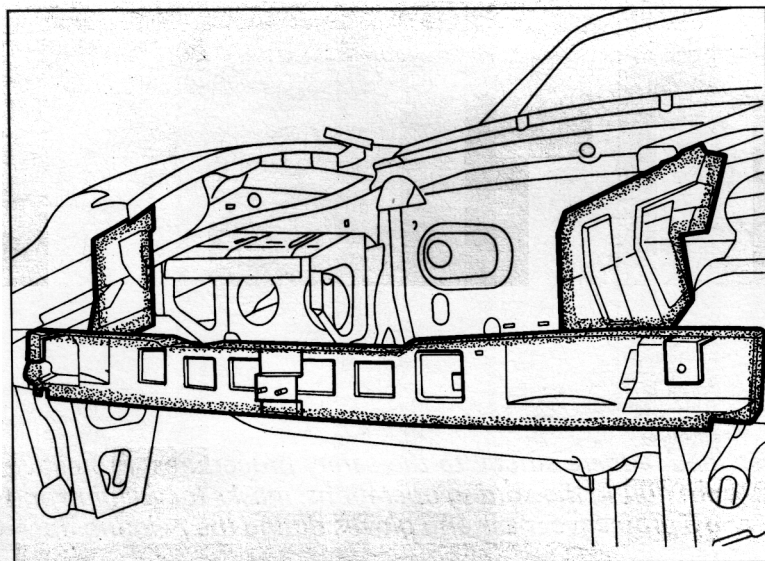


P3W080M01

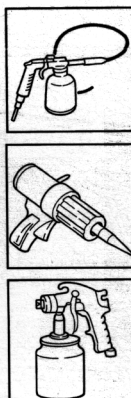


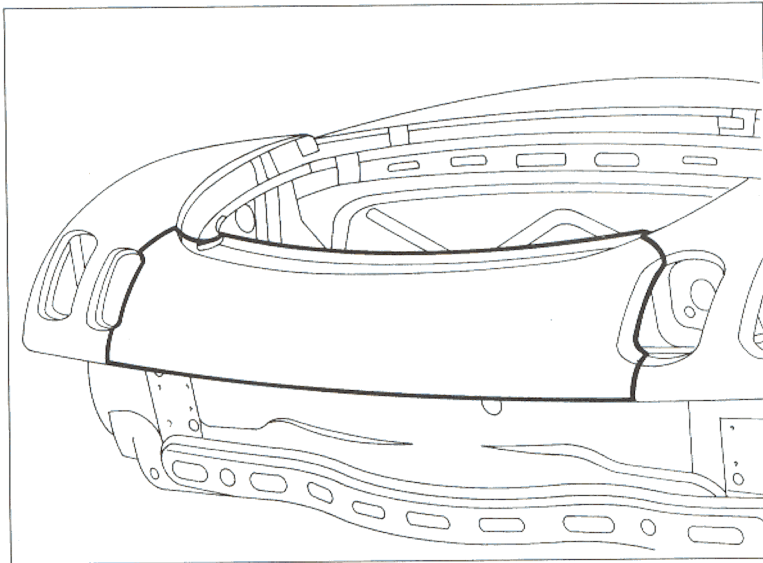
#### Protections

1. Apply the electro-phoretic protective treatment to the areas previously welded.
2. Seal the joints between the two parts and with the bodysell using IVI 854210 transparent acrylic sealant or an equivalent product.
3. Proceed with the painting and waxing stage.



P3W085M01





#### REPLACING OUTER REAR COVER

The component for which the replacement procedure is described is highlighted in the diagram at the side.

Establish the extent of the damage, check if there are distortions to the connected components by checking the bodyshell alignment figures, using suitable methods (jigs, templates or gauges).

Carry out any straightening operations required to the bodyshell before cutting the component.

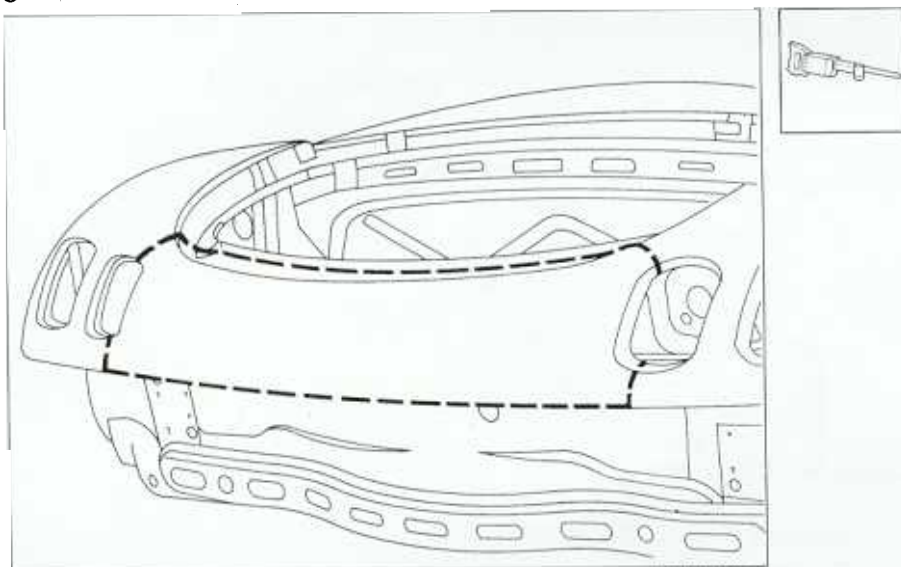
After this operation check that the components not being replaced are in tact.

#### Preliminary dismantling

Remove the moveable parts of the bodywork and the electrical components which could impede the repair operations or be damaged during them.

#### Removing

Cut the rear outer cover for the vehicle using a power saw following the dotted lines shown in the diagram below.



P3W086M02

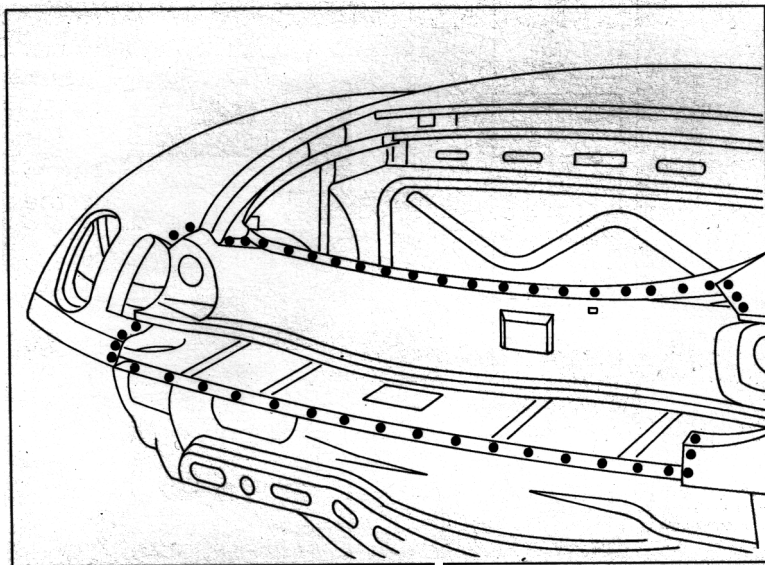


When carrying out the operations described, adhere strictly to the safety procedures. Protective shoes, ear-muffs and gloves should be worn during the cutting operations, masks for welding and gloves during the welding operations, and a protective mask and gloves during the painting operations.

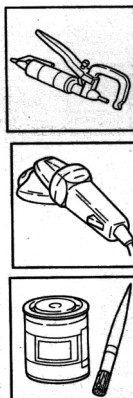


#### Removing off cuts and preparing edges of bodyshell

1. Remove the weld points in the areas illustrated in the diagram using a special cutter.
2. Remove the metal off cuts using pliers.
3. Straighten the edges with a hammer and dolly block.
4. Remove the spot weld residues using a disc grinder.
5. Apply the electro-galvanizing paint or an equivalent product, to the areas previously ground.

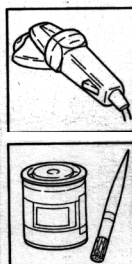
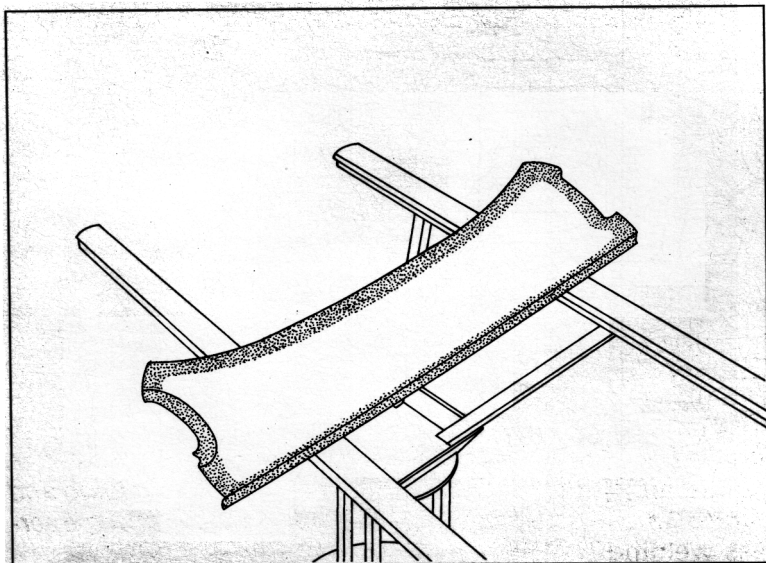


P3W087M01



#### Preparing the spare part

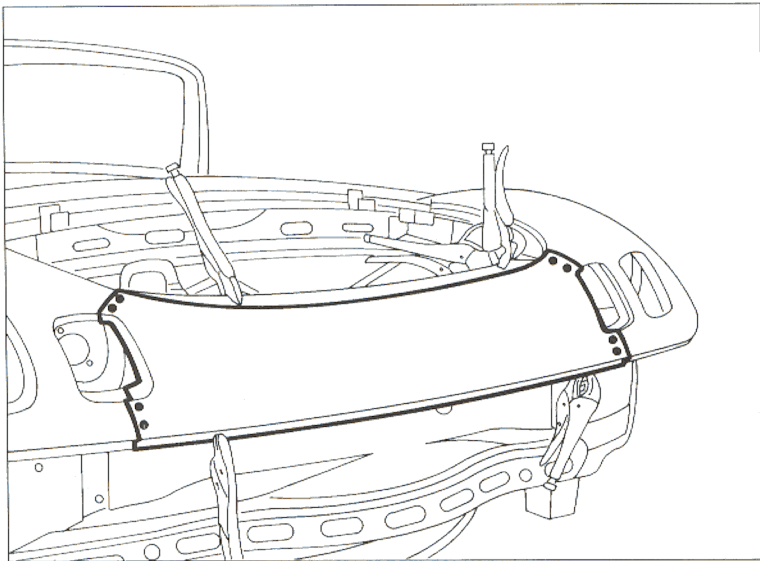
1. Remove the anti-corrosion treatment from the entire perimeter of the inside and the outside of the replacement part using a disc grinder.
2. Apply the electro-galvanizing paint to the edges in contact with the bodyshell.



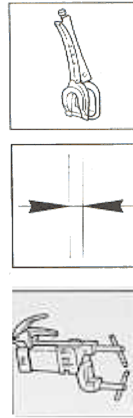
## 70.

### Positioning the replacement part

1. Carefully place the replacement part in position.
2. Fix the replacement part to the bodyshell using self-locking pliers and several spot welds as illustrated in the diagram.
3. Check that it is correctly positioned checking the alignment with the wings and also check the uniformity of the opening with the boot lid.

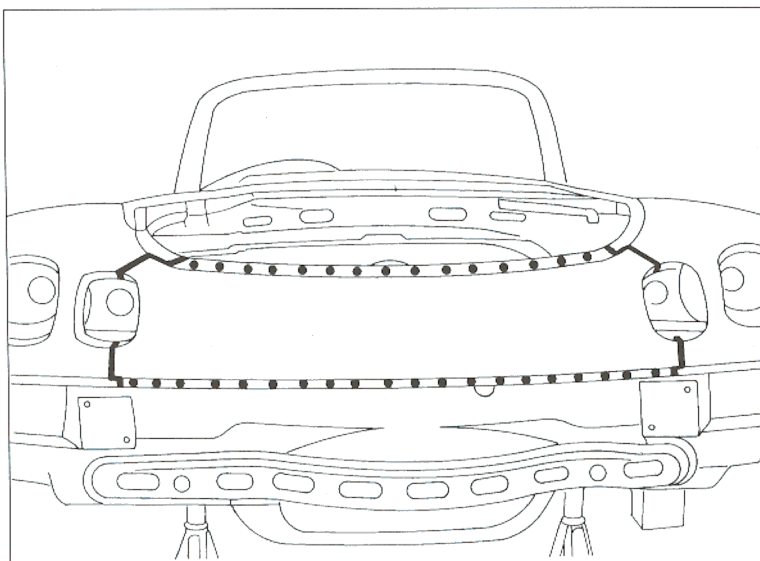


P3W088M01

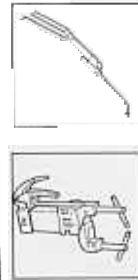


### Welding the spare part

1. Spot weld using a spot welder along the areas in contact with the rear wings, then brass weld using an oxy-acetylene canister by the previously welded areas.
2. Spot weld using a spot welder along the contact area between the outer cover and the support for the actual cover and in the contact area with the rear cross member.



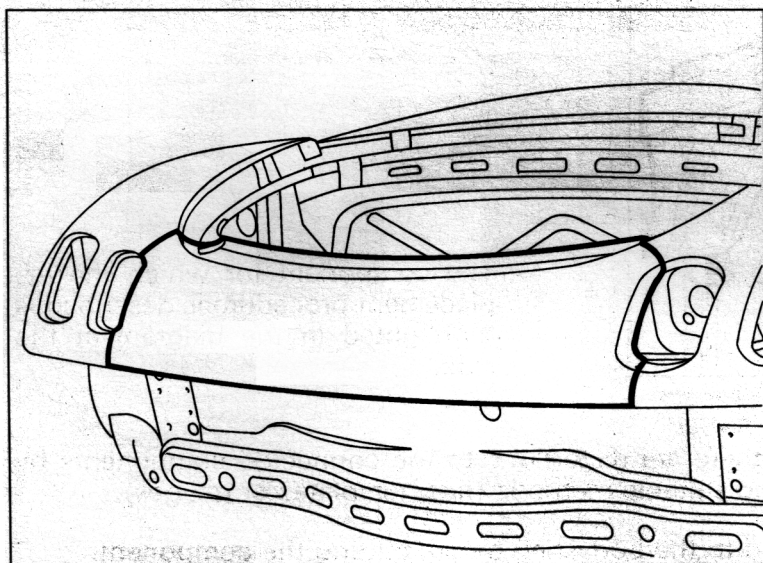
P3W088M02



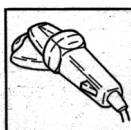
● ● ● ● Spot welding      — Brass welding

#### Finishing operations

1. Correct any distortions to the panel using a hammer and dolly block.
2. Remove any weld slag using a disc grinder.

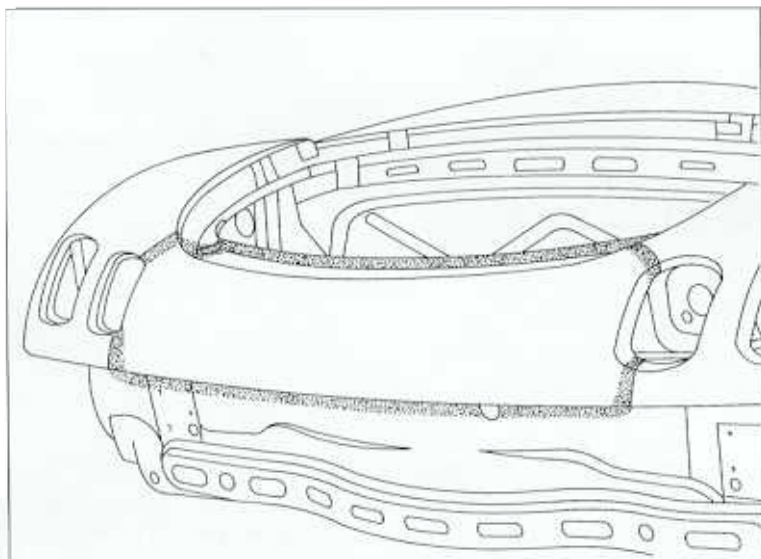


P3W086M01

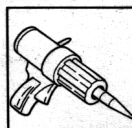
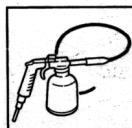


#### Protections

1. Apply the electro-phoretic protective treatment to the areas previously welded.
2. Seal the joints between the replacement part and the bodyshell using IVI 854210 transparent acrylic sealant or an equivalent product.
3. Proceed with the painting and waxing stage.

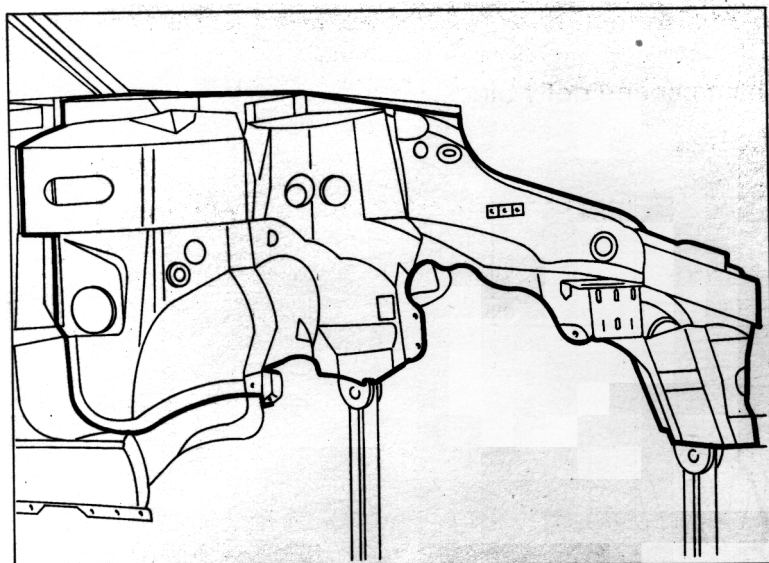


P3W089M01





## 70.



### REPLACING FRONT PANEL

The component for which the replacement procedure is described is highlighted in the diagram at the side.

#### Preliminary procedures

Establish the extent of the damage, check if there are distortions to the connected components by checking the bodysell alignment figures, using suitable methods (jigs, templates or gauges).

Carry out any straightening operations required to the bodysell before cutting the component.

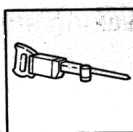
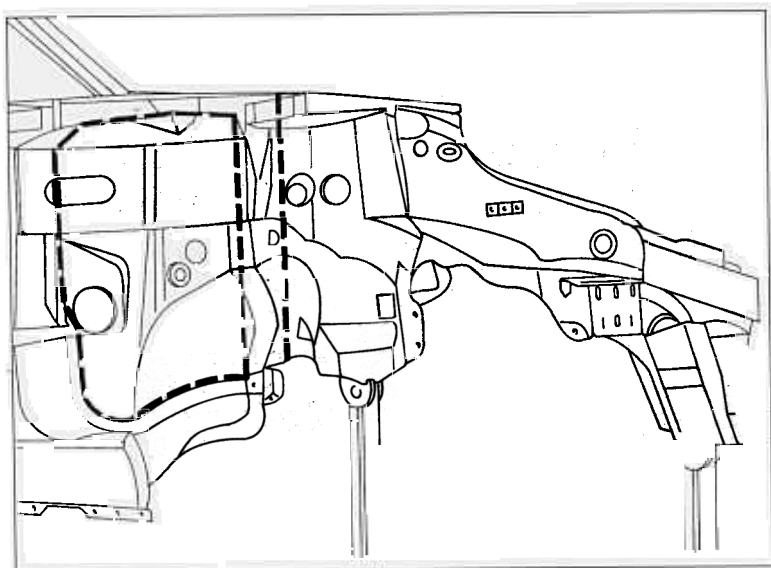
After this operation check that the components not being replaced are in tact.

#### Preliminary dismantling

Remove the moveable parts of the bodywork and the mechanical and electrical components which could impede the repair operations or be damaged during them. Also remove the front wing and the front cover complete with support as described previously.

#### Removing

Cut the front panel of the vehicle using a power saw following the dotted lines illustrated in the diagram below.



*When carrying out the operations described, adhere strictly to the safety procedures. Wear protective shoes, ear-muffs and gloves during the cutting operations, masks for welding and gloves during the welding operations, and a protective mask and gloves during the painting operations.*