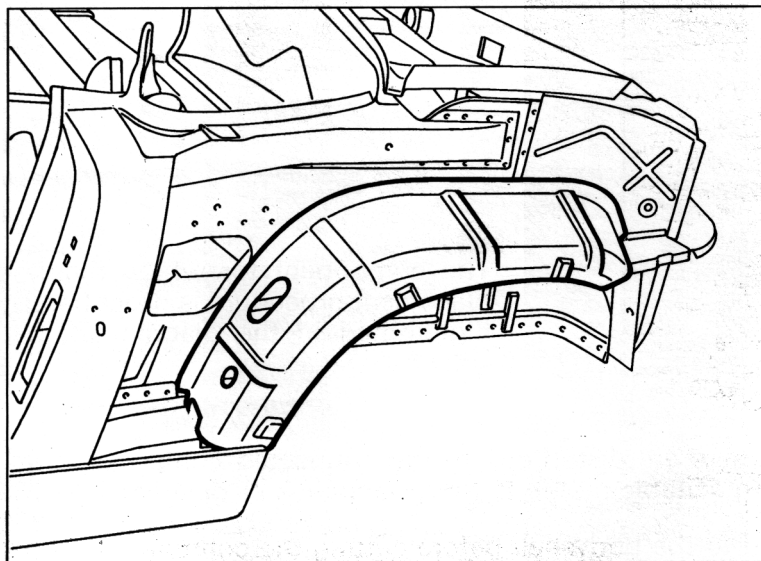
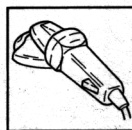


Finishing operations

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

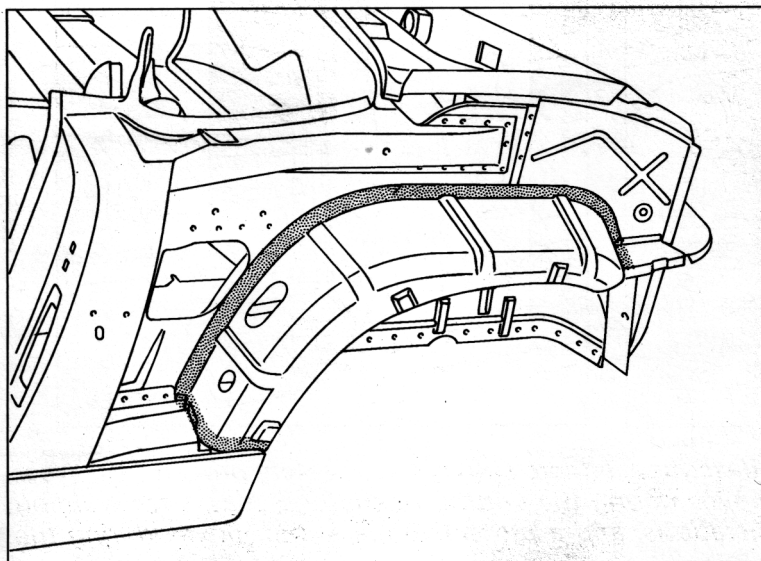


P3W128M01

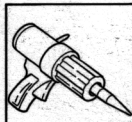


Protections

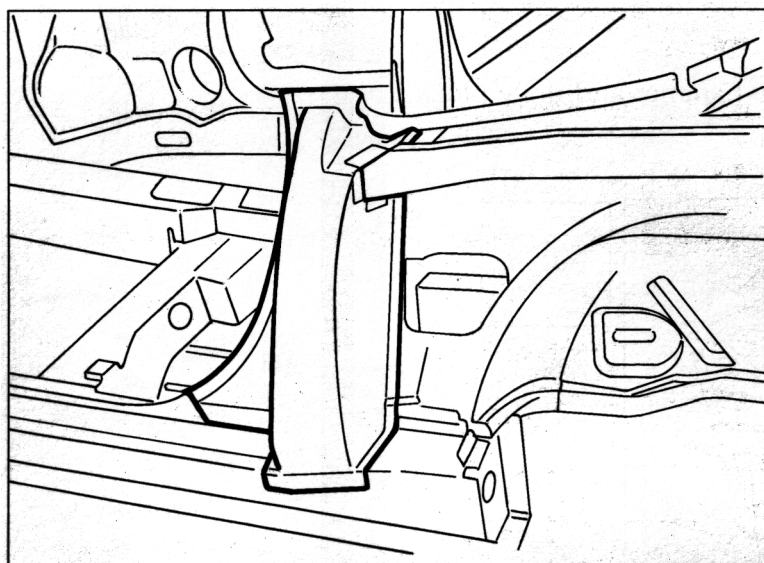
1. Apply the electro-phoretic protective treatment to the areas previously welded.
2. Seal the joints between the replacement part and the bodyshell using IVI 854210 transparent acrylic sealant or an equivalent product.
3. Proceed with the painting and waxing stage.



P3W131M01



70.



REPLACING REAR PILLAR

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.

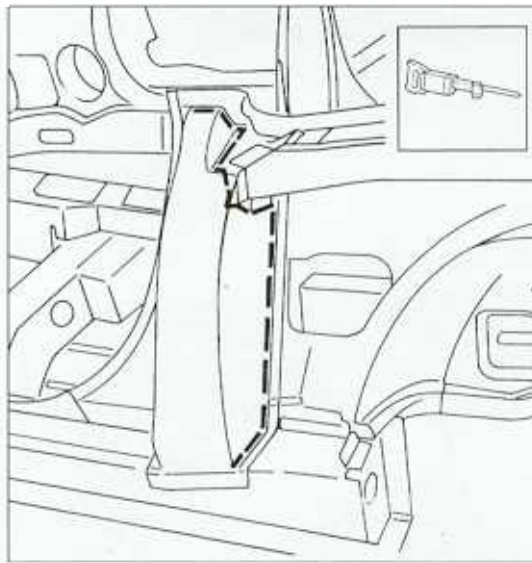
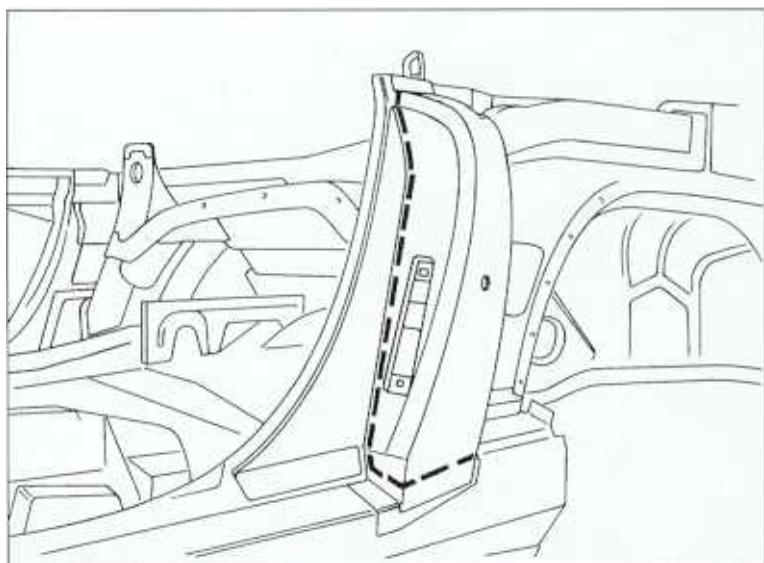
Preliminary dismantling

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

Also remove the rear wing and the underdoor side member, as described previously.

Removing

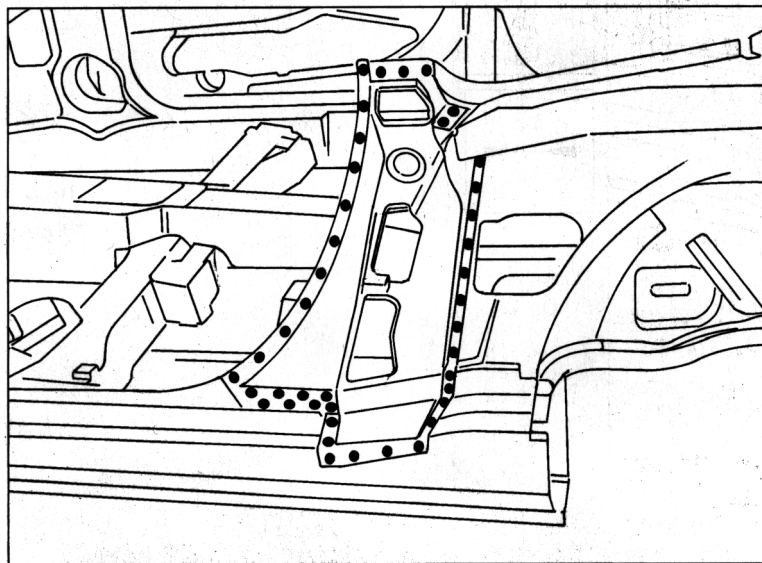
Cut the rear pillar using a power saw following the dotted lines shown in the diagrams below.



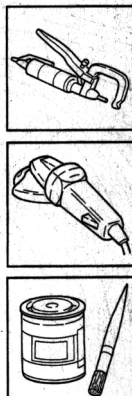
When carrying out the operations described, adhere strictly to the safety procedures. Wear protective shoes, ear-muffs and gloves during the cutting operations, masks for welding and gloves during the welding operations, and a protective mask and gloves during the painting operations.

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.

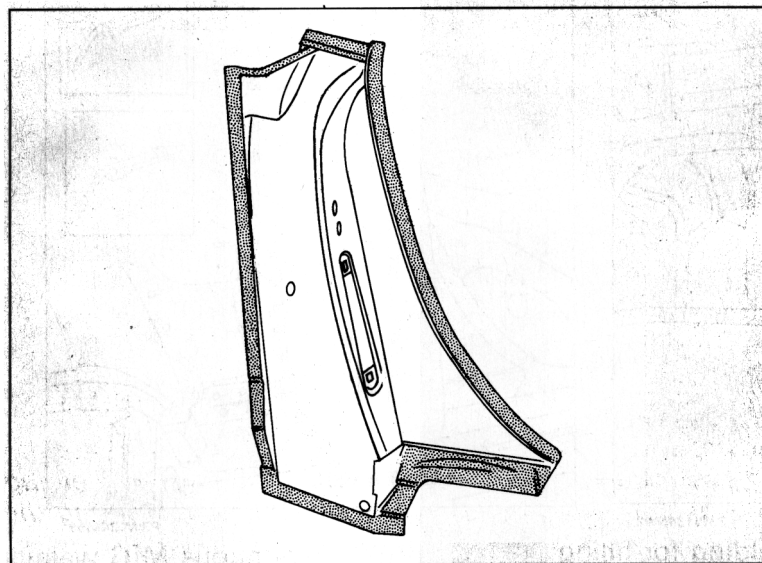


P3W133M01

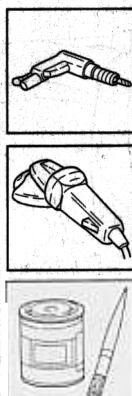


Preparing the spare part

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.

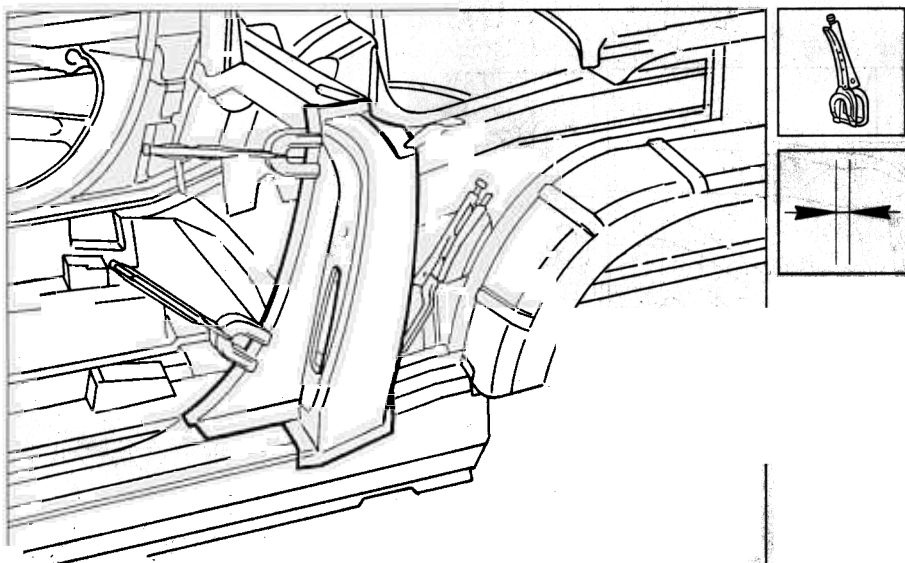


P3W133M02



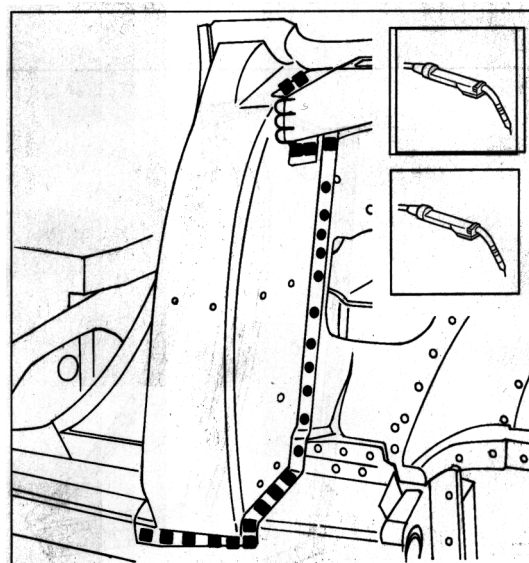
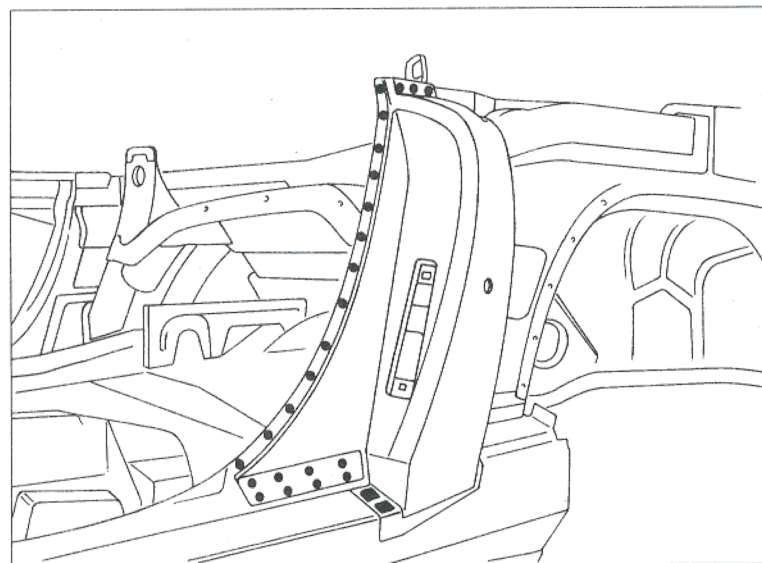
Positioning the replacement part

1. Carefully place the replacement part in position.
2. Fix the replacement part to the bodyshell using self-locking pliers.
3. Check that it is correctly positioned checking the alignment and the uniformity of the opening with the rear wing and the door.



Welding the spare part

1. Carry out spot welding using a spot welder in the areas in contact with the rear panel and with the underdoor panel.
2. Carry out MIG welding for filling in the contact area between the replacement part and the underdoor panel and in the join area with the rear panel reinforcement.
3. Carry out continuous MIG welding in the contact area with the rear panel reinforcement.



P3W134M03

●●●● Spot welding

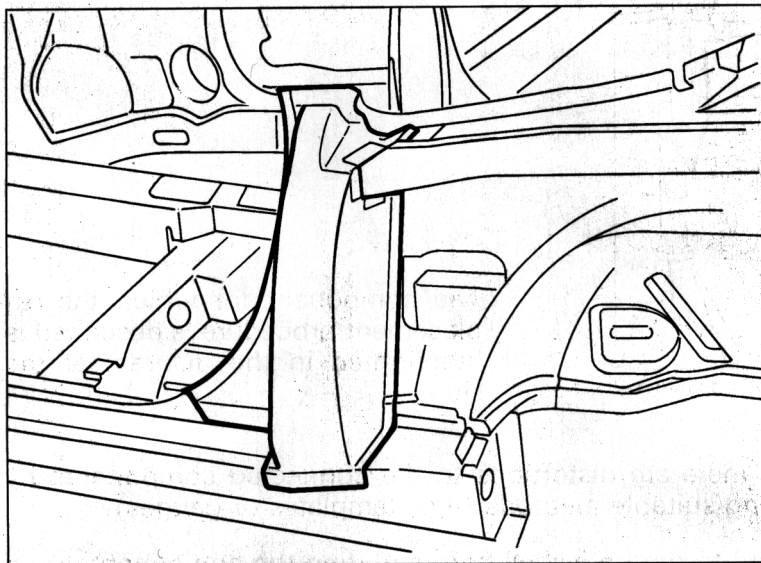
■■■■ MIG welding for filling

~~~~~ Continuous MIG welding

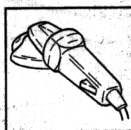


#### Finishing operations

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

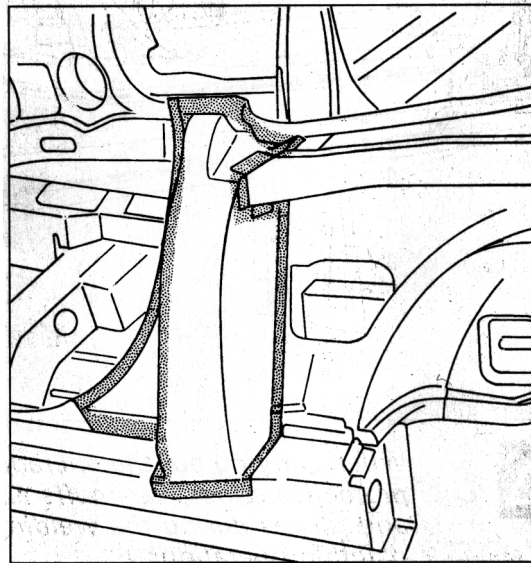
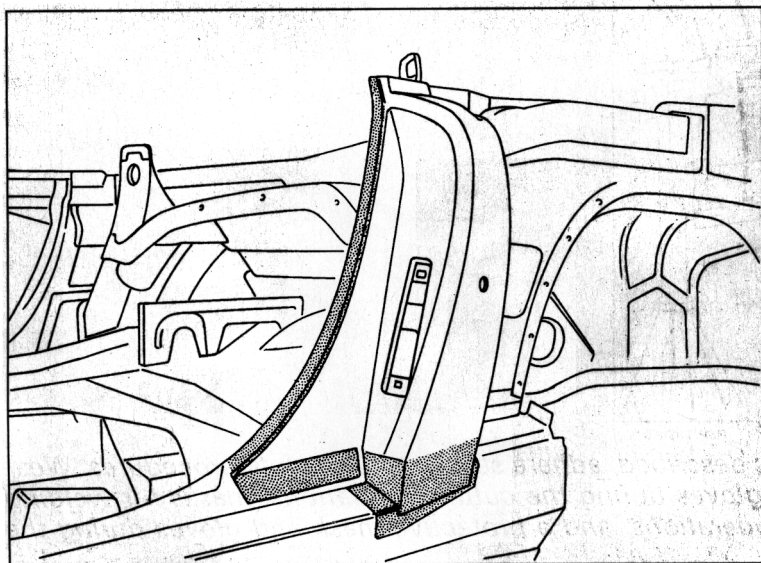
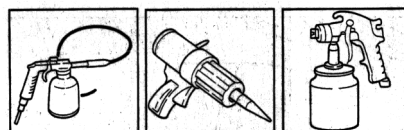


P3W132M01

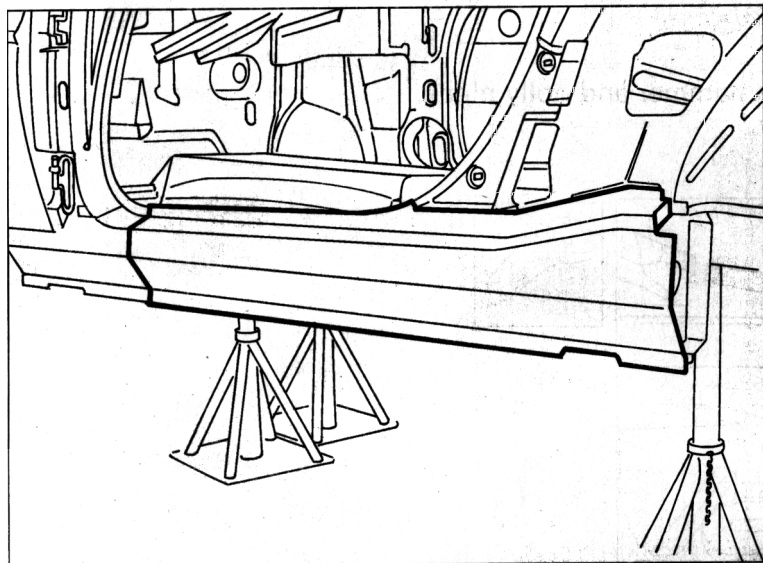


#### Protections

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.



P3W135M02



### REPLACING OUTER UNDER-DOOR 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 bodysheel alignment figures, using suitable methods (jigs, templates or gauges).

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

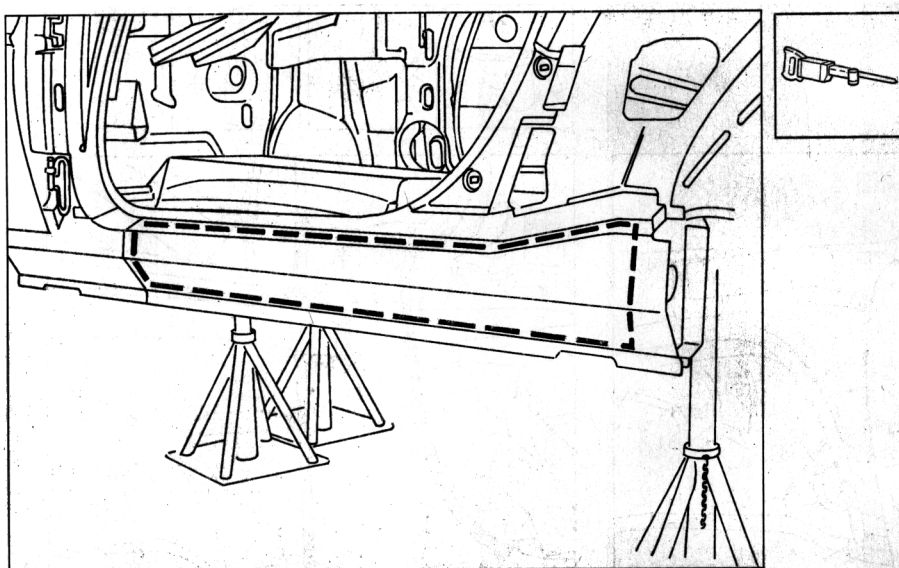
After this operation check that the components not being replaced are in tact.

#### Preliminary dismantling

Remove the moveable parts of the bodywork the electrical components and the interior fittings which could impede the repair operations or be damaged during them. Also remove the rear wing and the rear pillar as described previously.

#### Removing

Cut the outer underdoor panel using a power saw following the dotted lines shown in the diagram below.

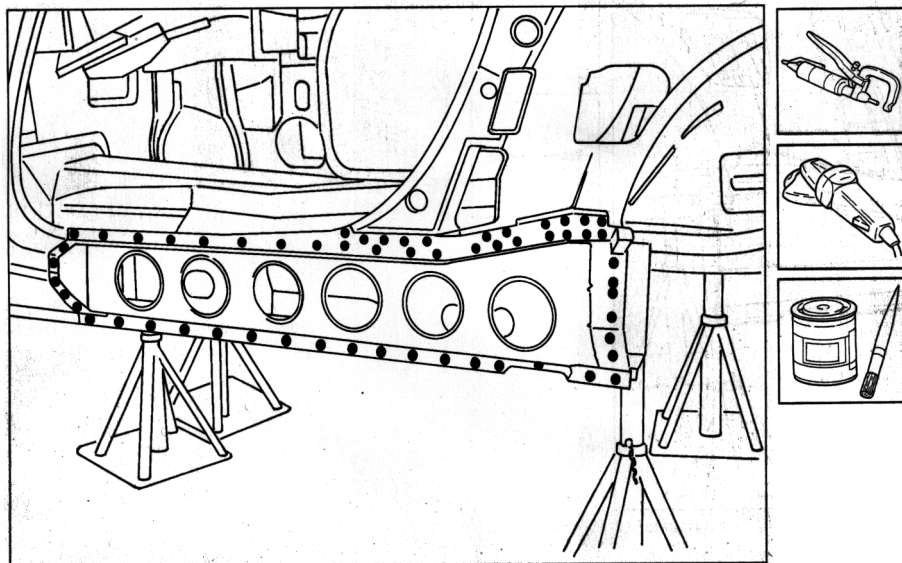


*When carrying out the operations described, adhere strictly to the safety procedures. Wear protective shoes, ear-muffs and gloves during the cutting operations, masks for welding and gloves during the welding operations, and a protective mask and gloves during the painting operations.*



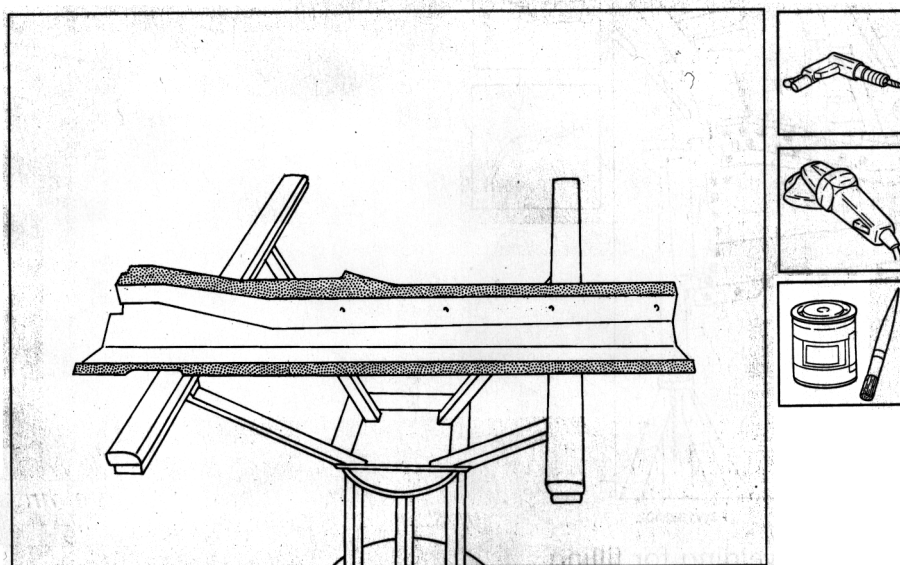
#### Removing off cuts and preparing edges of bodyshell

1. Remove the weld points 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



#### 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.



P3W137M02

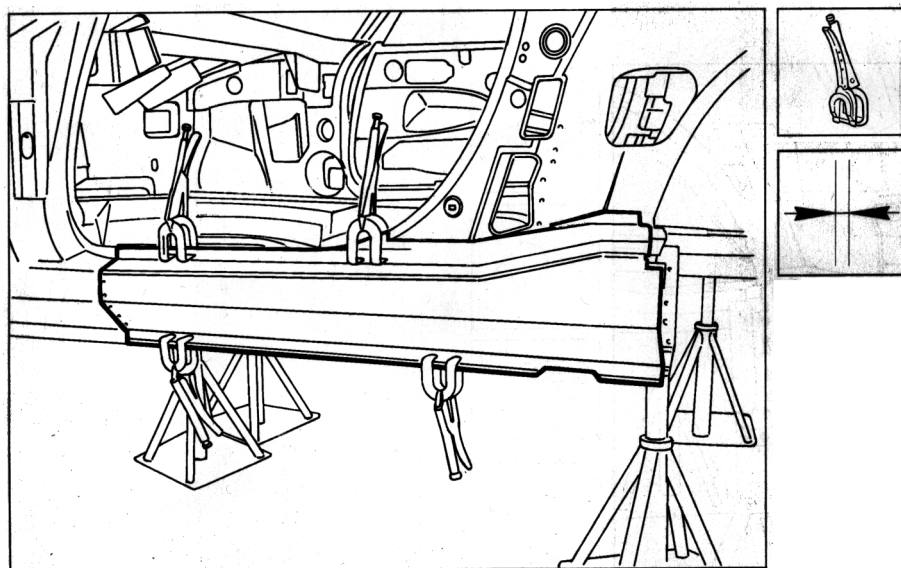


## Replacing body panels

### 70.

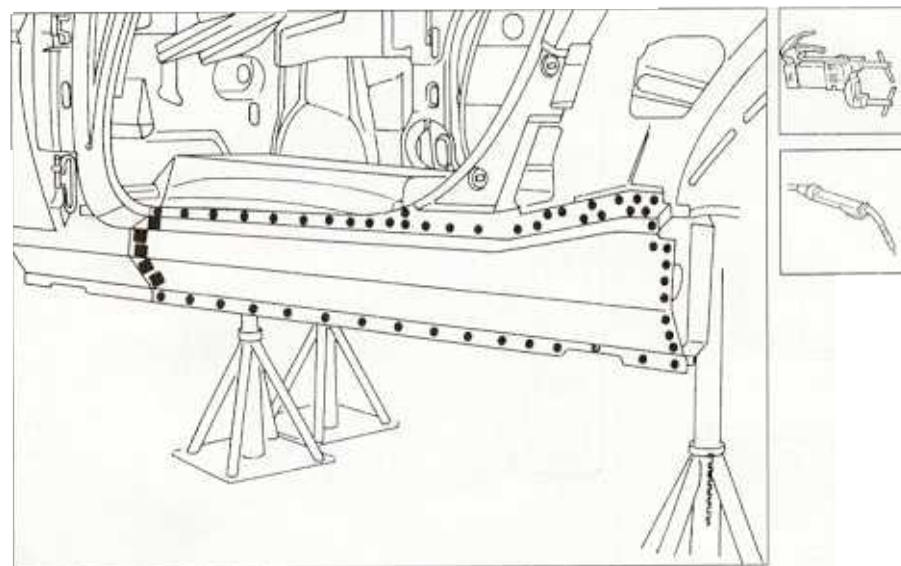
#### Positioning the replacement part

1. Carefully place the replacement part in position.
2. Fix the replacement part to the bodyshell using self-locking pliers.
3. Check that it is correctly positioned checking that the edges of the replacement part are in line with those of the internal underdoor panel.



#### Welding the spare part

1. Carry out spot welding, using a spot welder, in the areas in contact with the internal underdoor panel.
2. Carry out MIG welding for filling in the rear in contact with the front pillar.

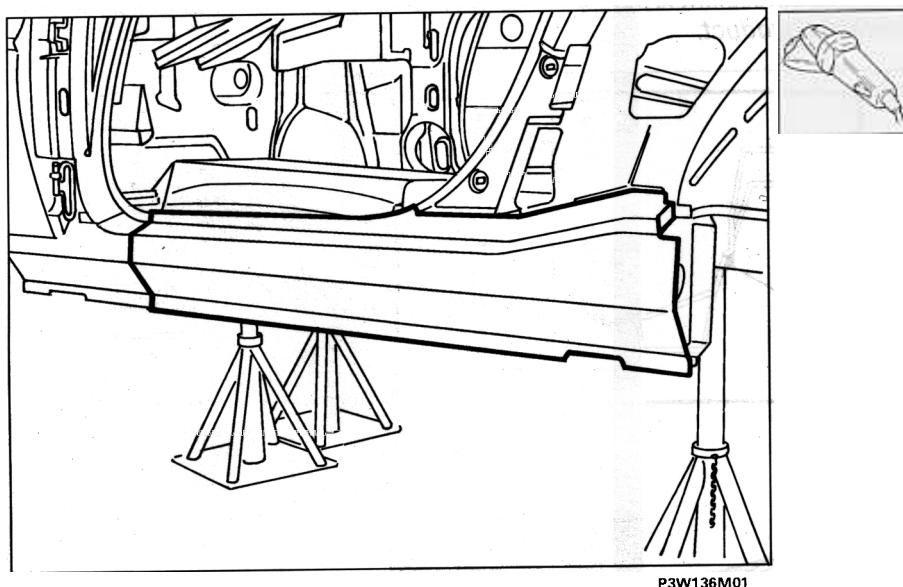


P3W138M02

●●●● Spot welding      ■■■■ MIG welding for filling

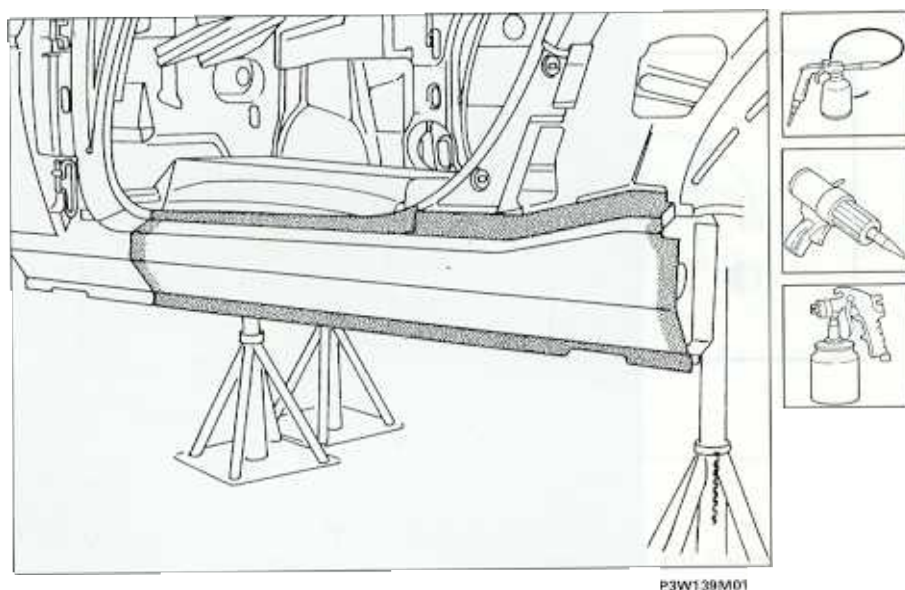
#### Finishing operations

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



#### 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.

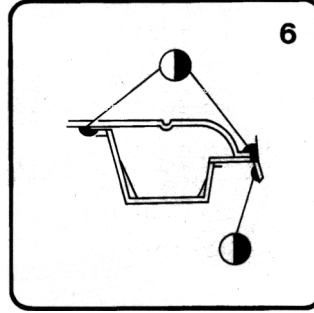
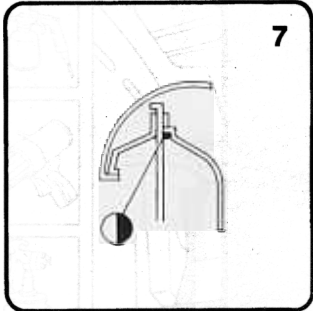
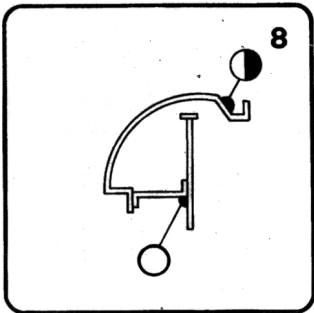
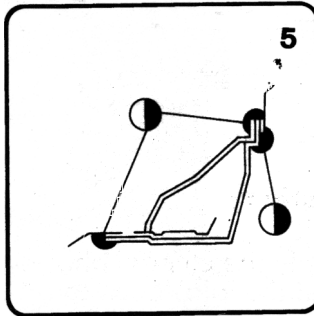
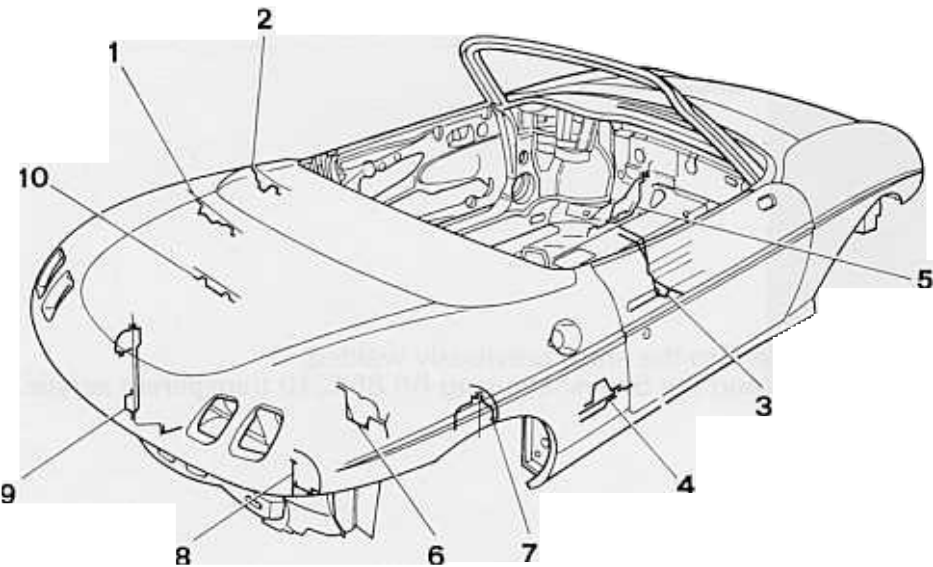
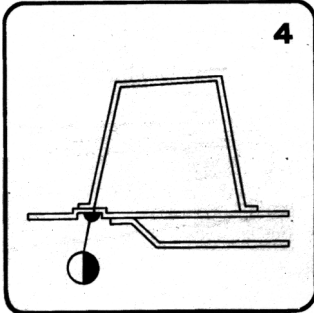
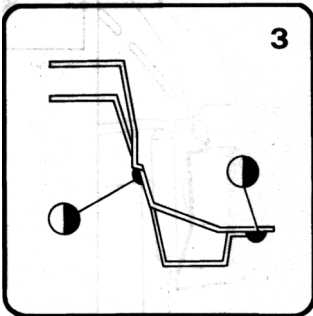
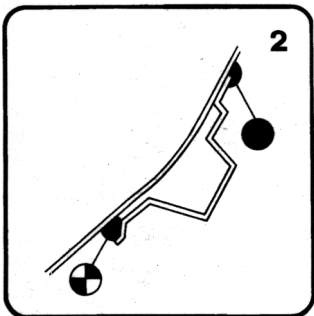


70.

SEALANTS AND ANTI-ABRASION VINYL PROTECTIVE

The beads of sealant and the areas where the anti-abrasion vinyl protective is applied are highlighted in the sections below and overleaf.

**NOTE** In the case of restoring the areas where the sealant is applied, use an air drying type transparent acrylic sealant like IVI 854210 or an equivalent product.

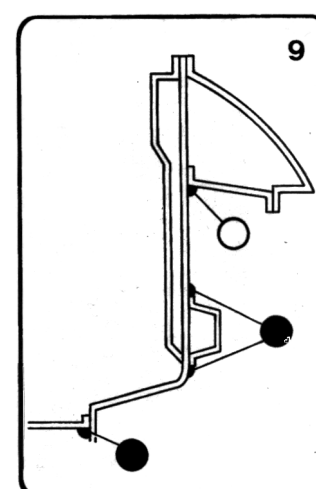
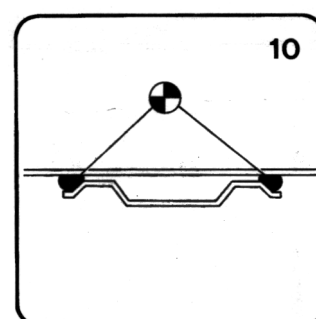
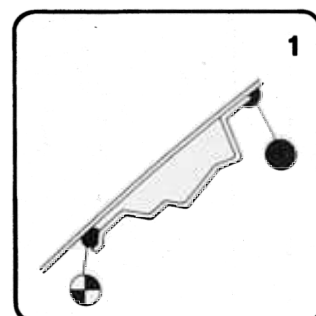




Hot hardening filler  
Hot hardening sealant for exteriors

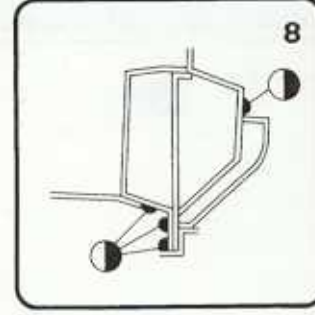
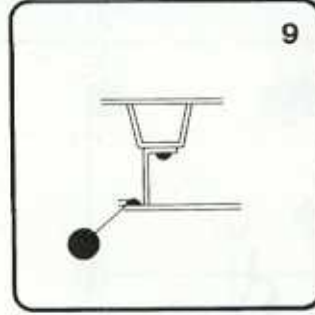
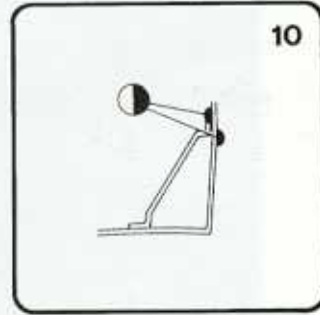
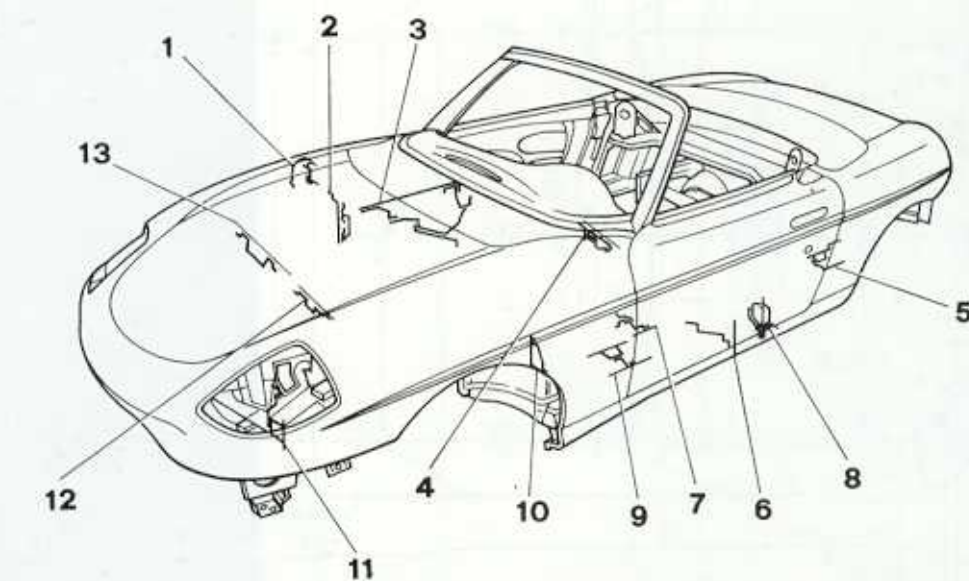
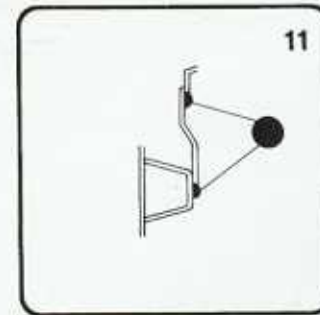
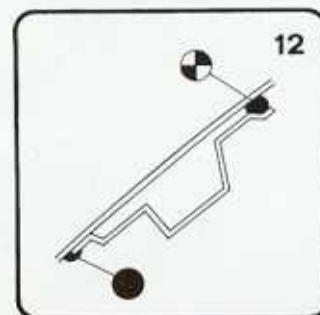
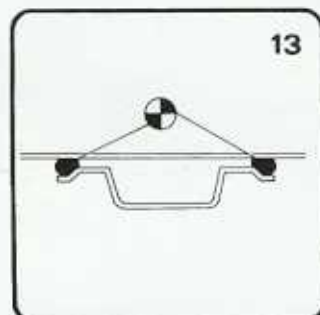
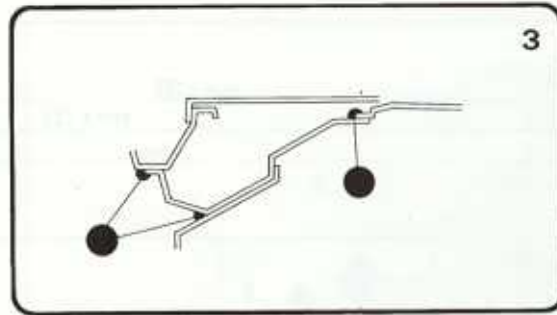
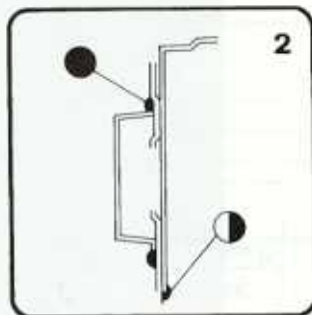
○ Hot hardening filler  
● Hot hardening sealant for interiors

Hot hardening sealant  
for exteriors



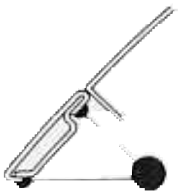


 Expandable series  
 Hot hardening

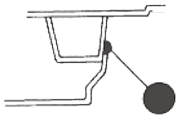


- Expandable sealant
- ⊗ Hot hardening sealant for exteriors
- Hot hardening filler
- ◐ Hot hardening sealant for interiors
- Hot hardening sealant for exteriors

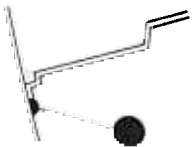
4



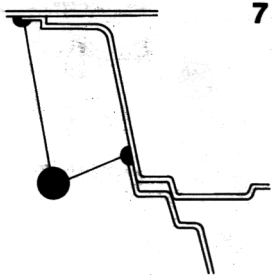
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6



7

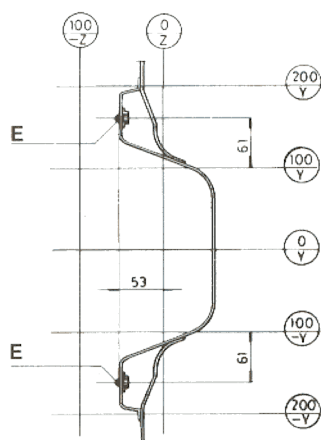
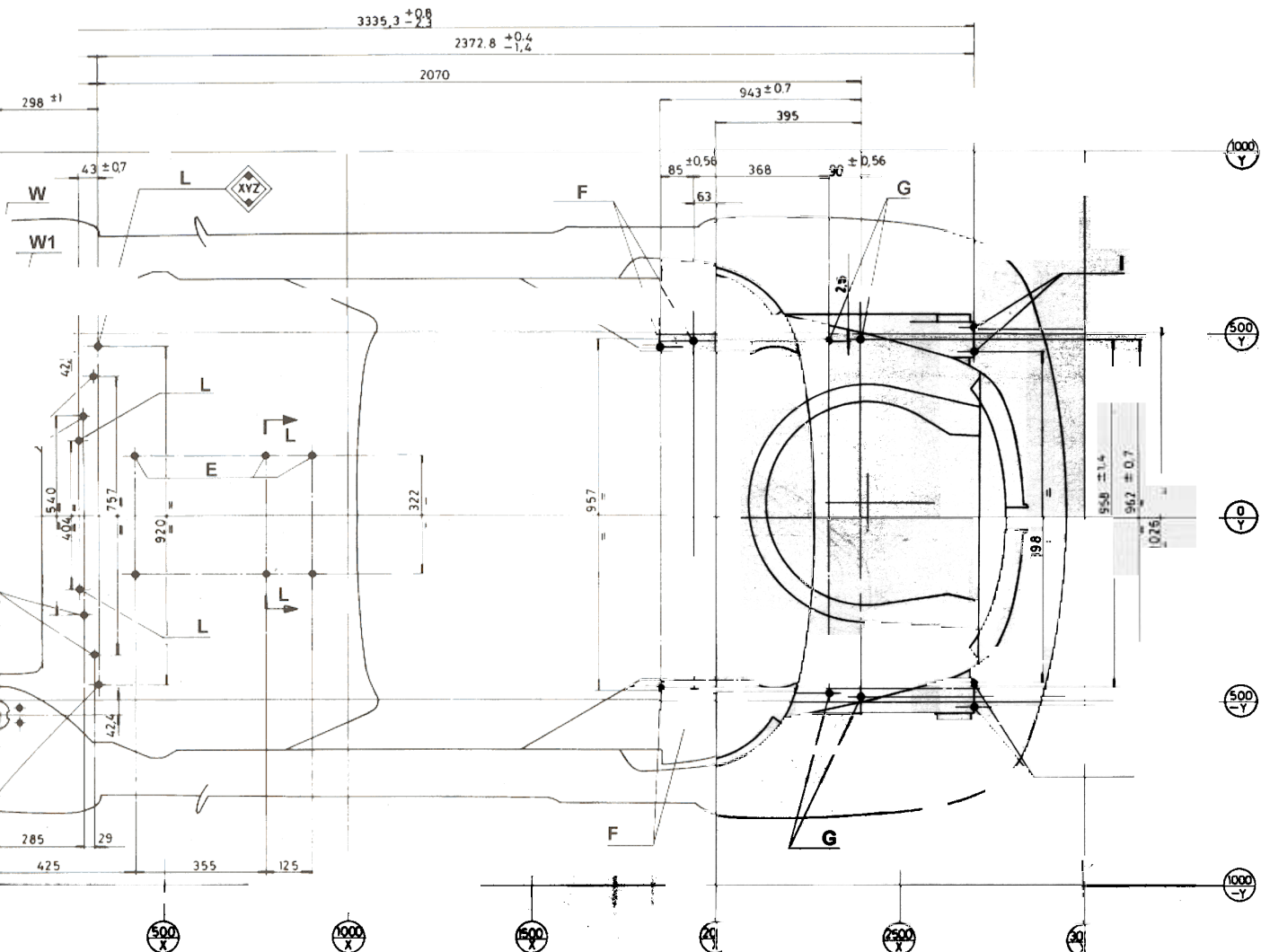


P3W141M01



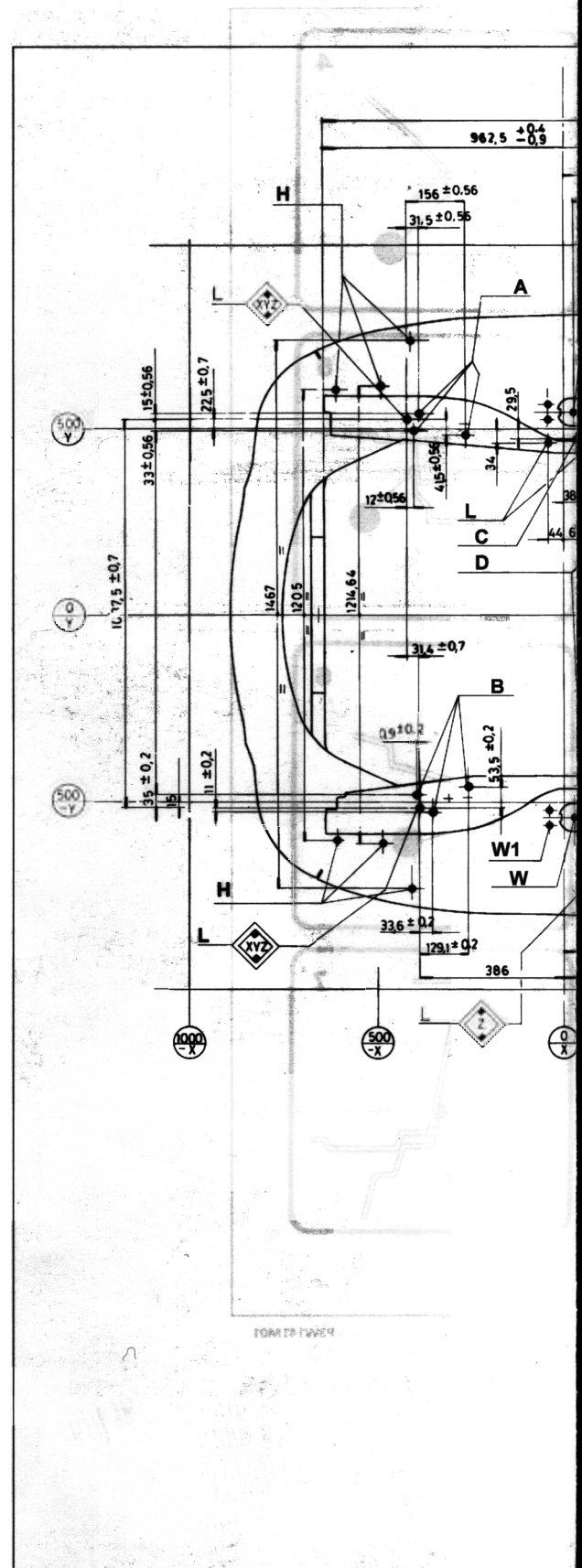
## 70.

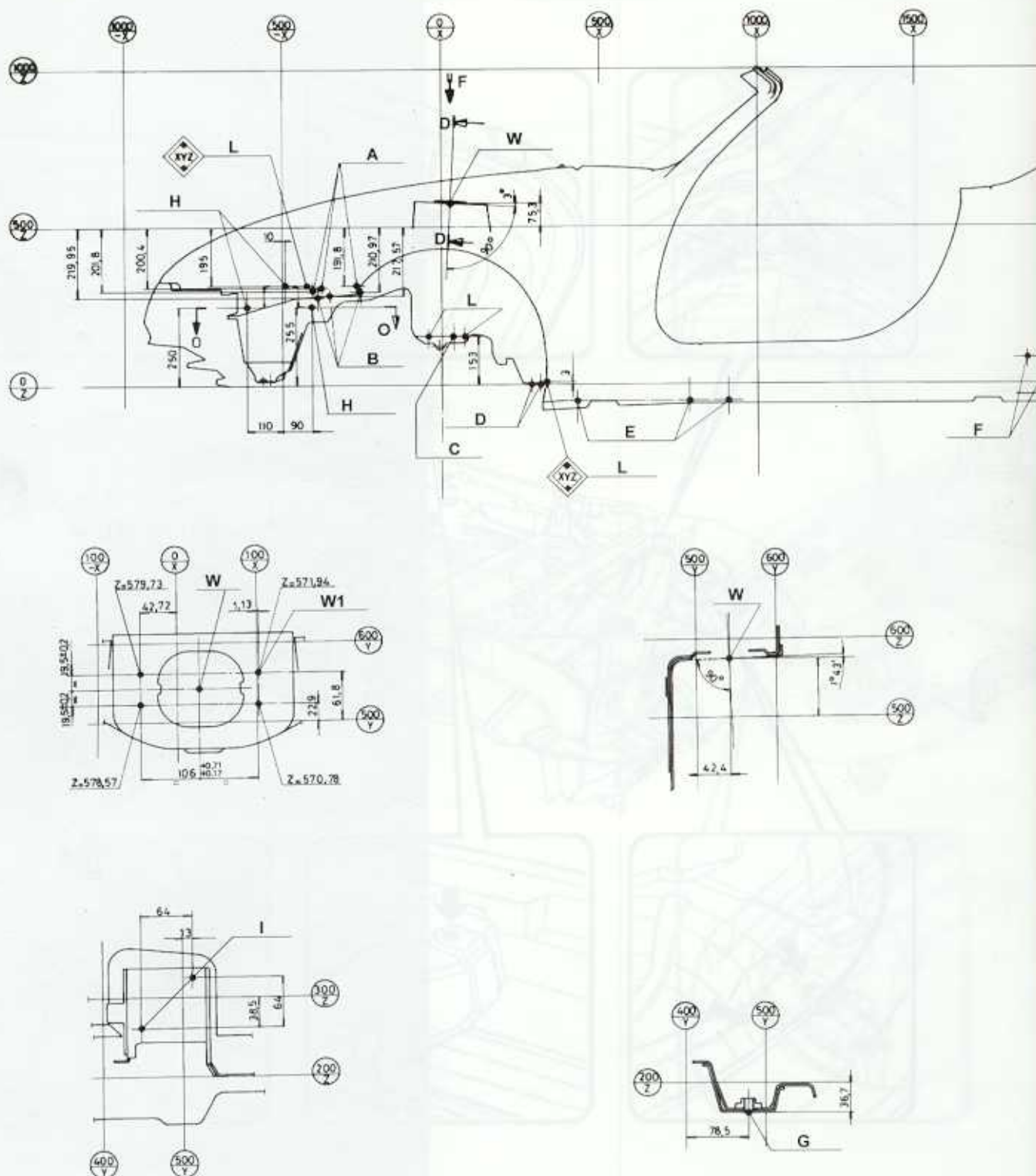
### DIAGRAM FOR CHECKING UNDERBODY



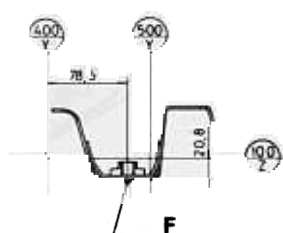
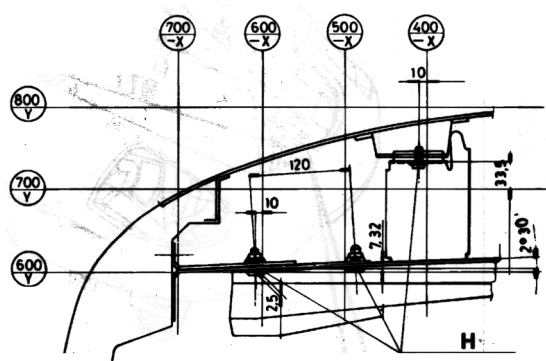
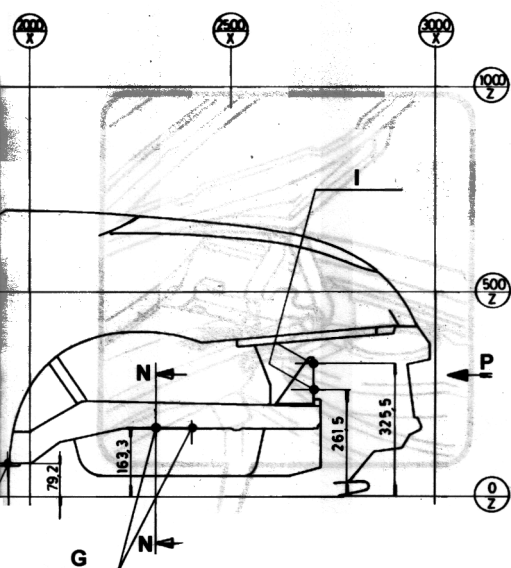
- A. Engine fixing
- B. Gearbox fixing
- C. Front suspension fixing
- D. Front suspension fixing
- E. Gearbox operation fixing
- F. Rear suspension fixing
- G. Rear suspension fixing
- H. Front bumper fixing
- Rear bumper fixing
- L. Main fixing
- W W1. Front suspension shock absorber fixing

P3W148M01



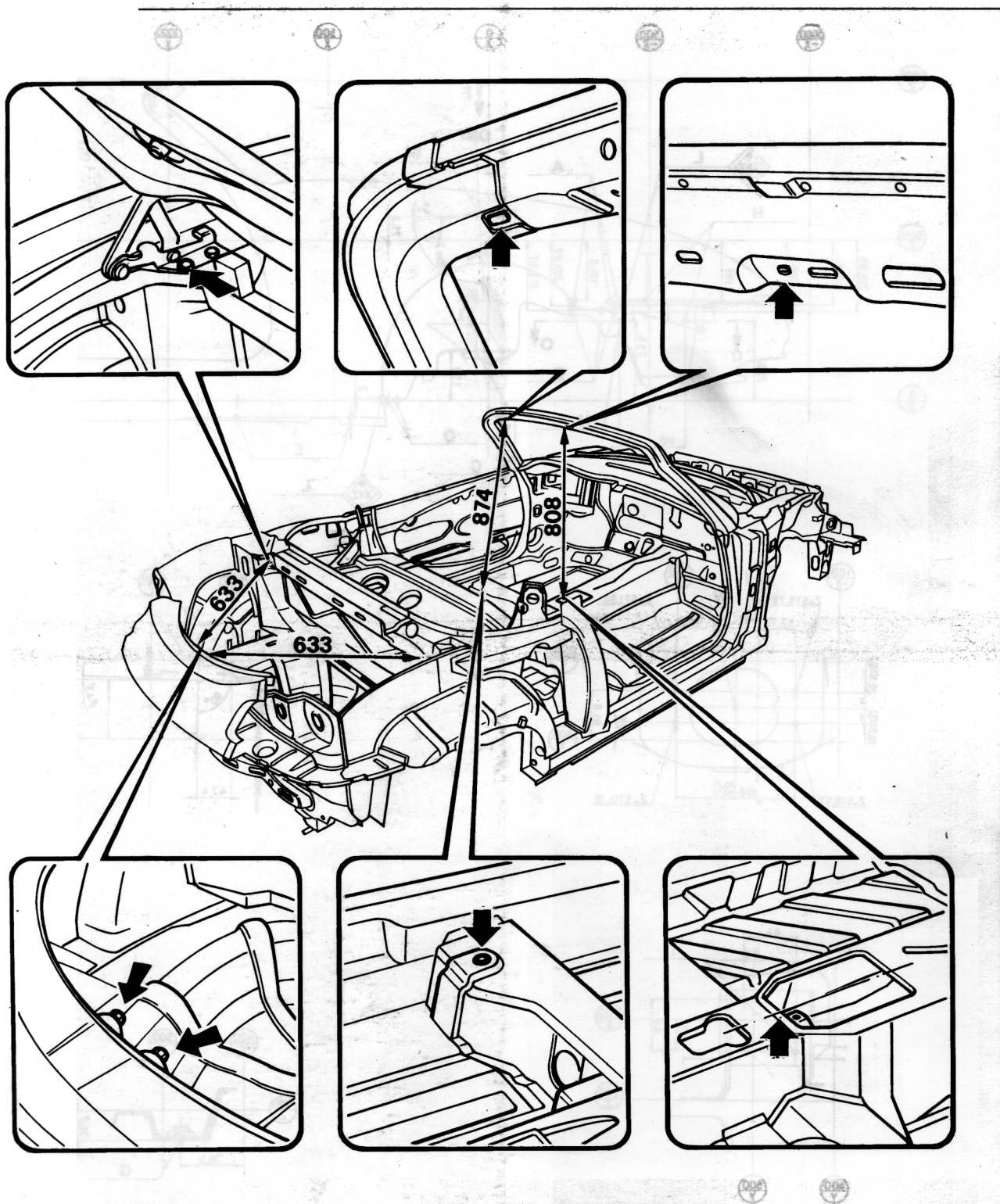






**70.**

**DIAGRAM SHOWING BODYSHELL DIMENSIONS**



P3W150M01

