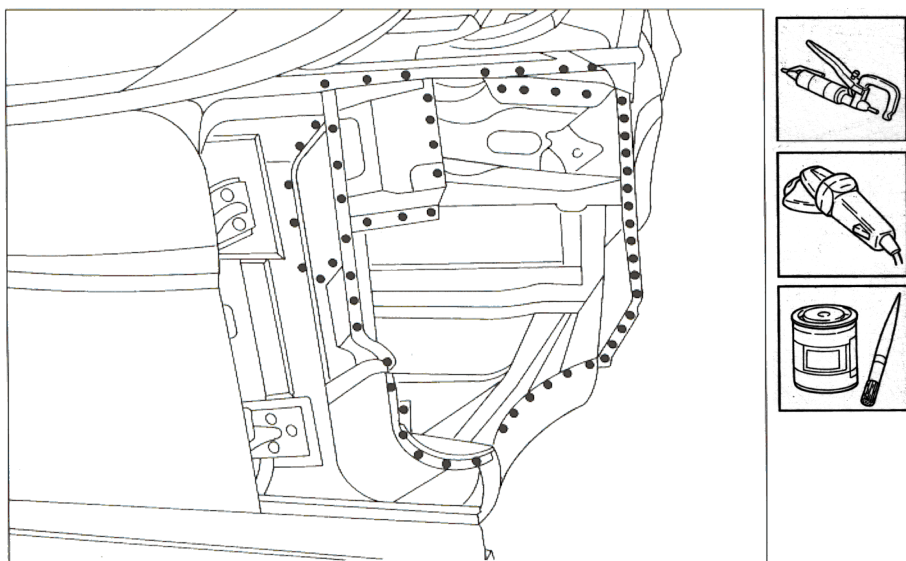


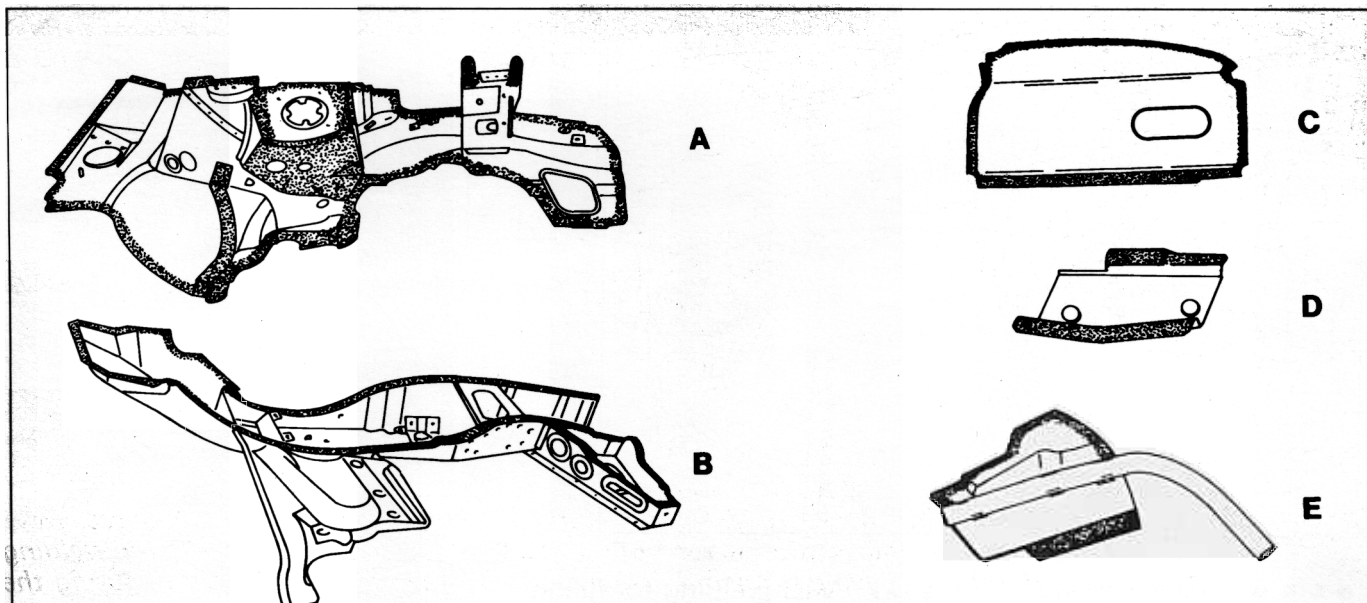
Removing off cuts and preparing edges of bodyshell

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

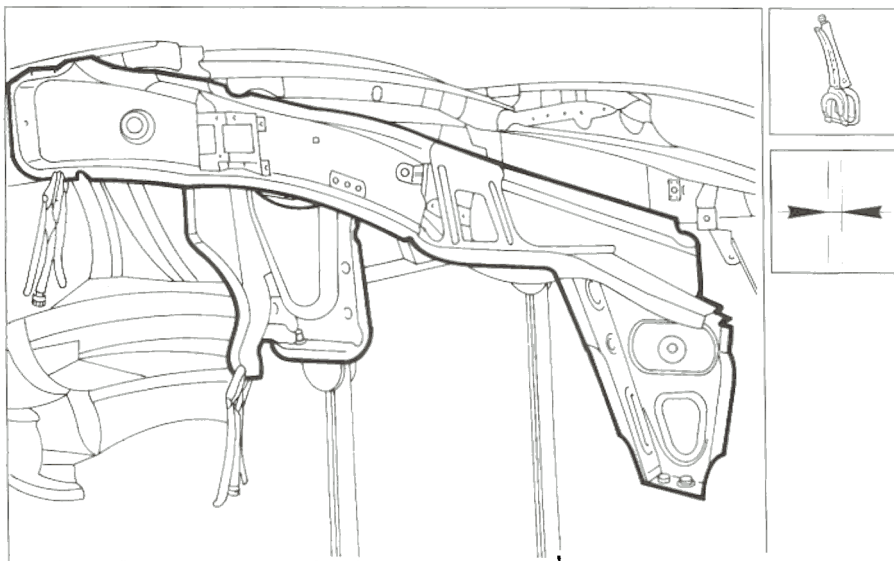
1. A- Outer panel. B- Inner panel. C- Pillar reinforcement bracket. D- Front bumper attachment bracket. E- Tow hook mounting bracket
2. Remove the anti-corrosion treatment from the entire perimeter of the inside and the outside of the replacement parts using a disc grinder.
3. Apply the electro-galvanizing paint to the edges previously treated.



70.

Positioning the replacement inner panel

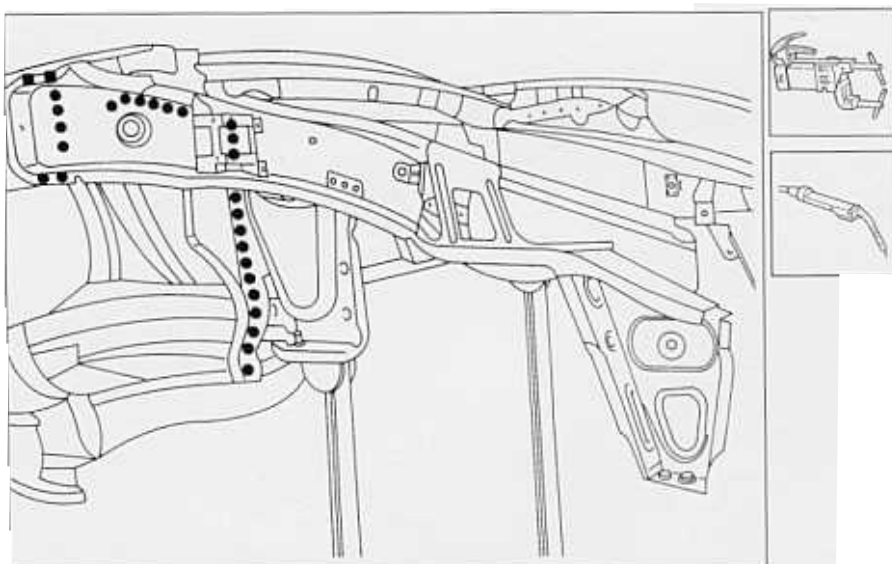
1. Carefully place the replacement inner panel in position.
2. Fix the replacement part to the bodyshell using self-locking pliers.
3. Check that it is correctly positioned using special templates.



P3W092M01

Welding the spare part

1. Spot weld using a spot welder in the areas illustrated in the diagram
2. Carry out MIG welding for filling as shown in the illustration below.



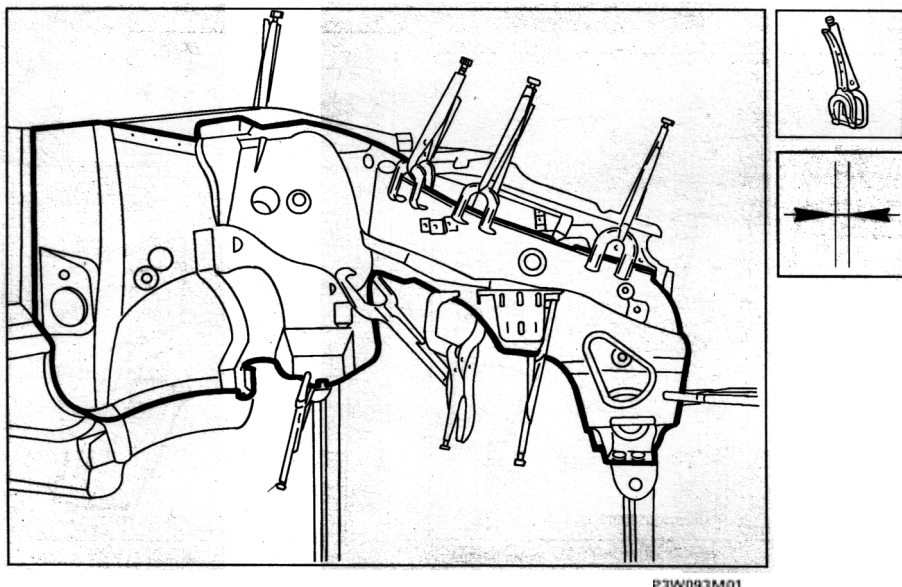
P3W092M02

● ● ● ● Spot welding

■ ■ ■ ■ MIG welding for filling

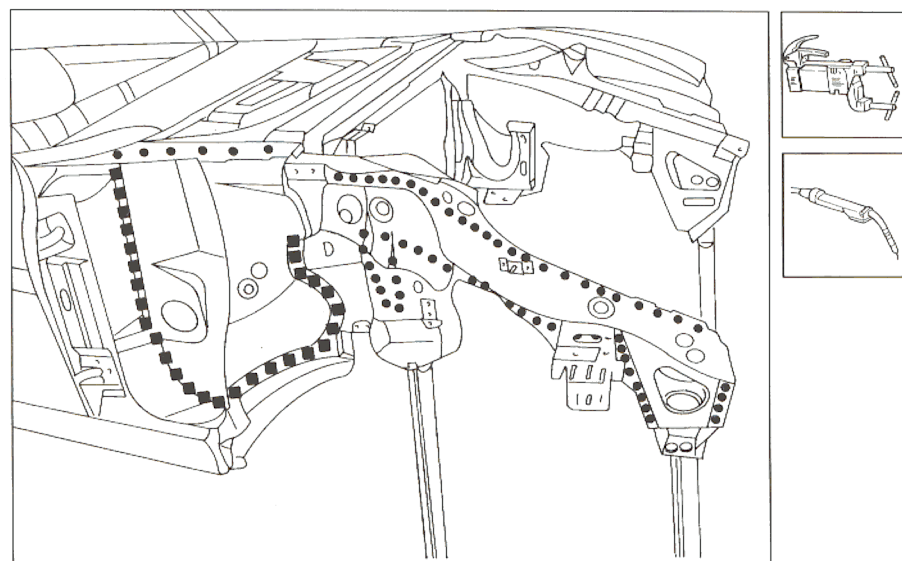
Positioning the replacement outer panel

1. Carefully place the replacement outer panel in position.
2. Fix the replacement part to the bodyshell using self-locking pliers.
3. Check that it is correctly positioned using the special templates and that it is perfectly aligned with the inner panel.



Welding the spare part

1. Spot weld using a spot welder in the areas illustrated in the diagram.
2. Carry out MIG welding for filling as shown in the illustration below.

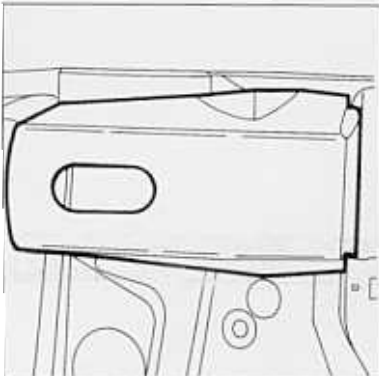


●●●● Spot welding ■■■■ MIG welding for filling

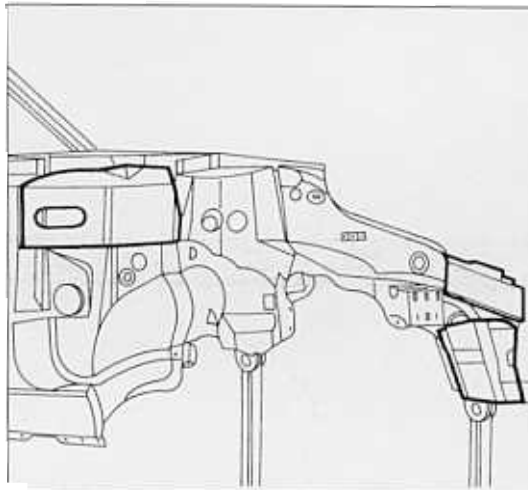
70.

Positioning the connected replacement parts

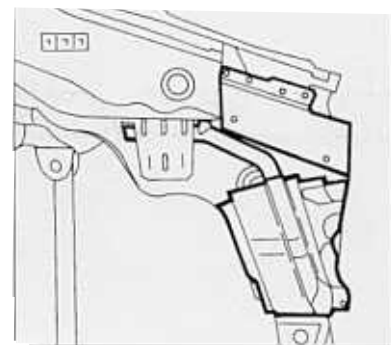
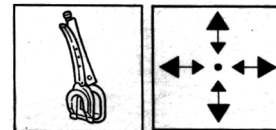
1. Carefully position the replacement parts for the front bumper attachment bracket, the tow hook mounting bracket and the pillar reinforcement bracket.
2. Fix the replacement part to the bodyshell using self-locking pliers.
3. Check that it is correctly positioned in relation to the panel.



P3W094M01



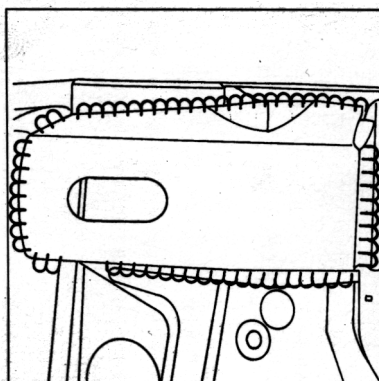
P3W094M02



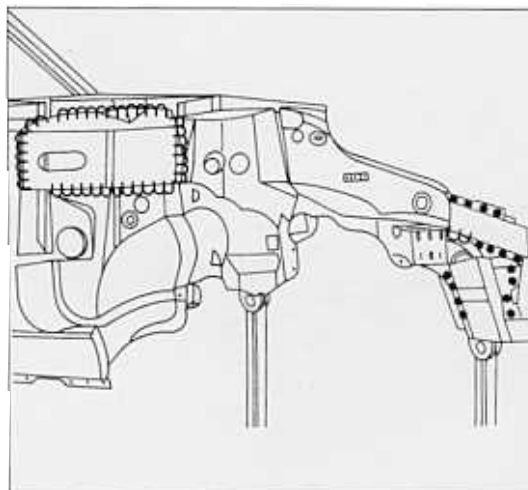
P3W094M03

Welding replacement parts

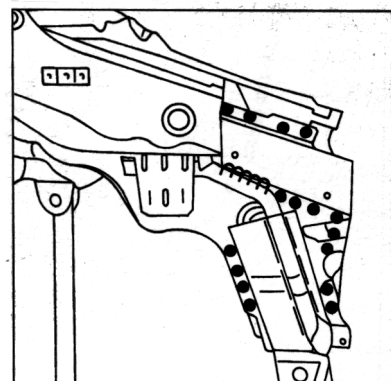
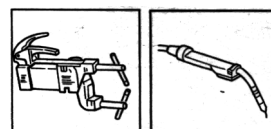
1. Spot weld using a spot welder in the areas illustrated in the diagram.
2. Carry out continuous MIG welding as shown in the illustration below.



P3W094M04



P3W094M05



P3W094M06

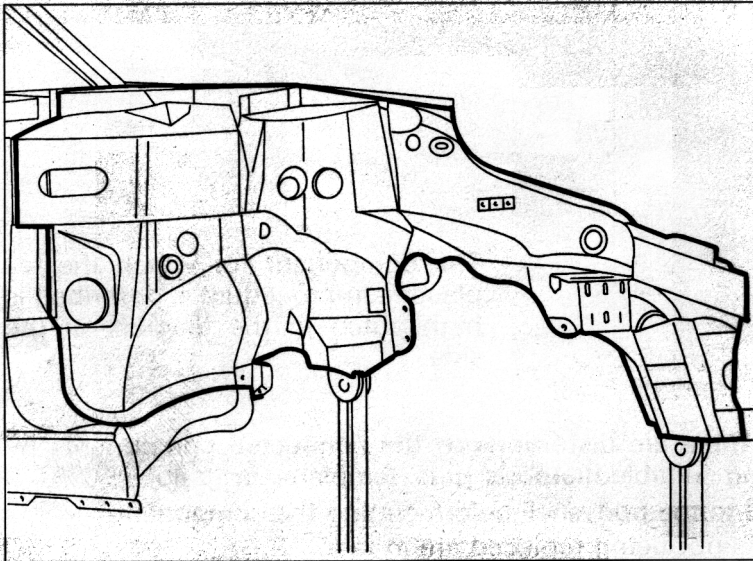
● ● ● ● Spot welding

~~~~~ Continuous MIG welding

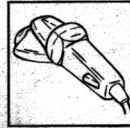


#### Finishing operations

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

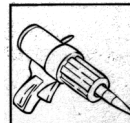
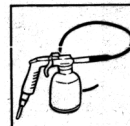
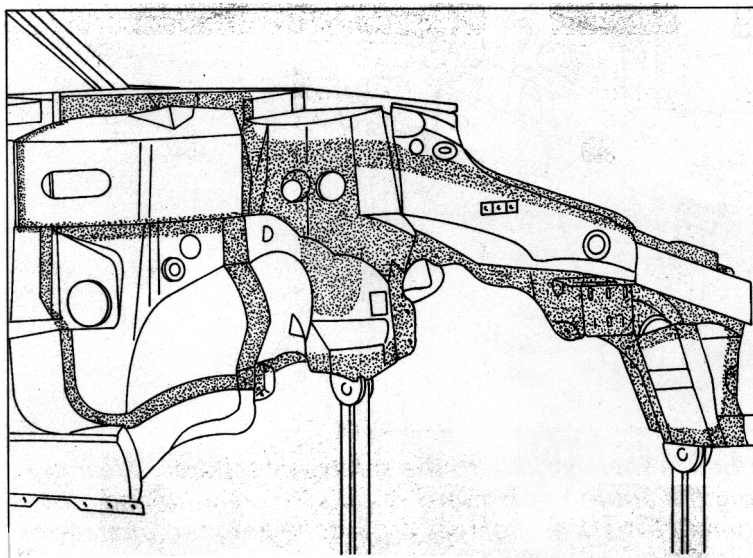


P3W090M01

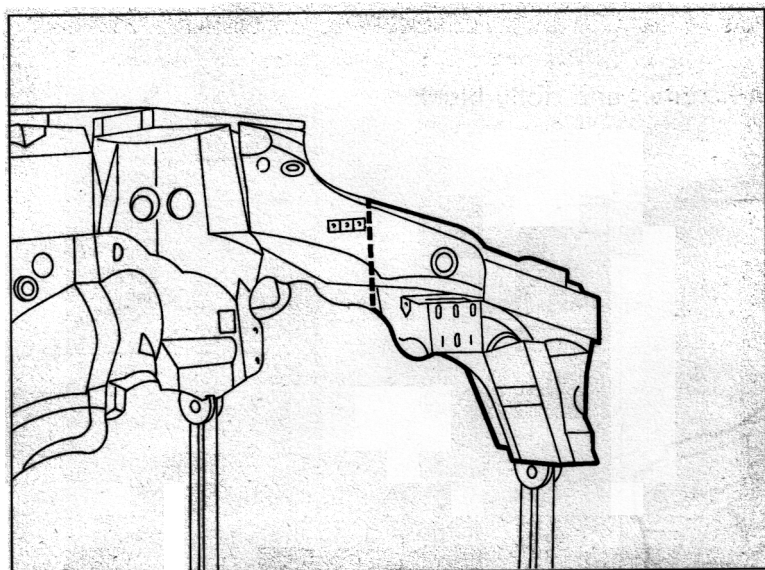


#### Protections

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



### 70.



#### REPLACING PARTIAL FRONT SIDE PANEL

Procedure for replacing right side 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 bodyshell alignment figures, using suitable methods (jigs, templates or gauges).

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

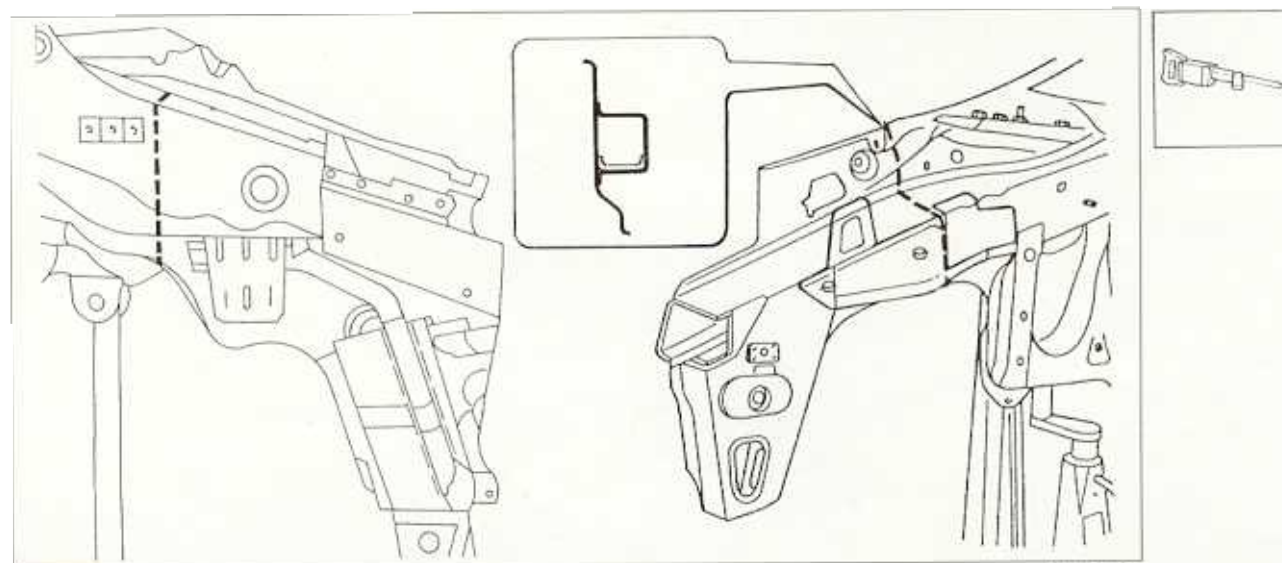
After this operation check that the components not being replaced are in tact.

#### Preliminary dismantling

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

#### Partial removal of front side panel

1. Make the first cut in the vehicle front side panel using a power saw following the dotted lines shown in the diagram below.
- The inset shows the section involved in the cutting.



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.

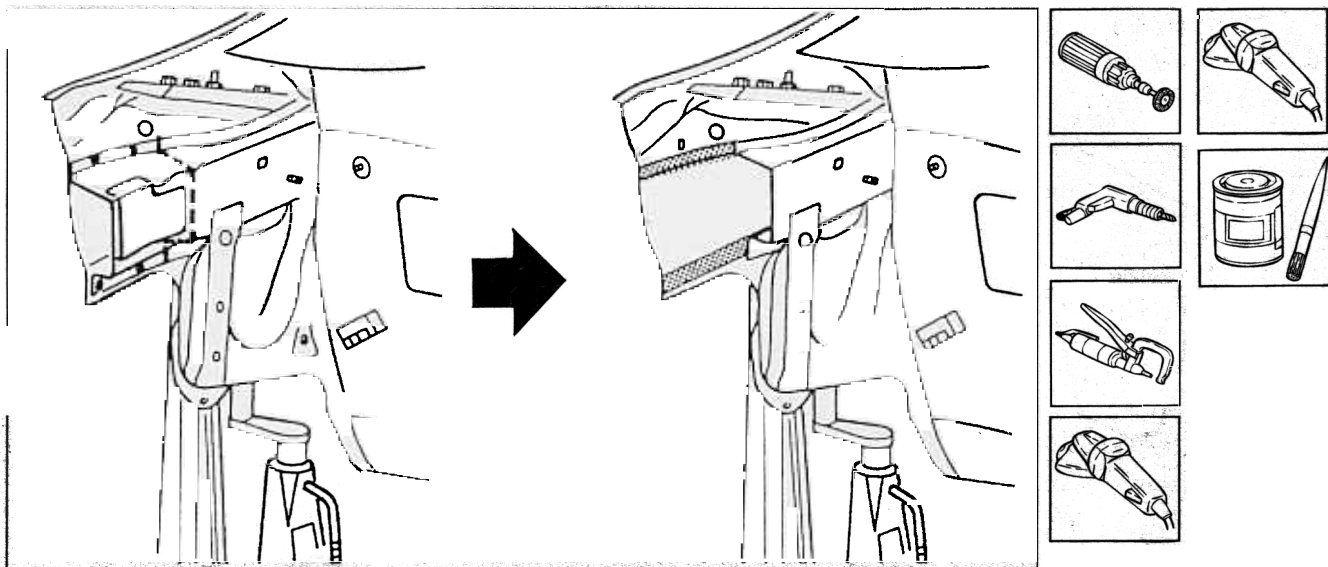


#### Continuing with the removal of the side panel

1. Using a rotating brush, clean the area to be chamfered for to highlight the spot welds.
2. Remove the weld points using a drill and the chamfering machine.
3. Cut the inner panel using a circular blade saw, following the line shown in the diagram, without damaging the part underneath.

#### Preparing the edges of the bodyshell

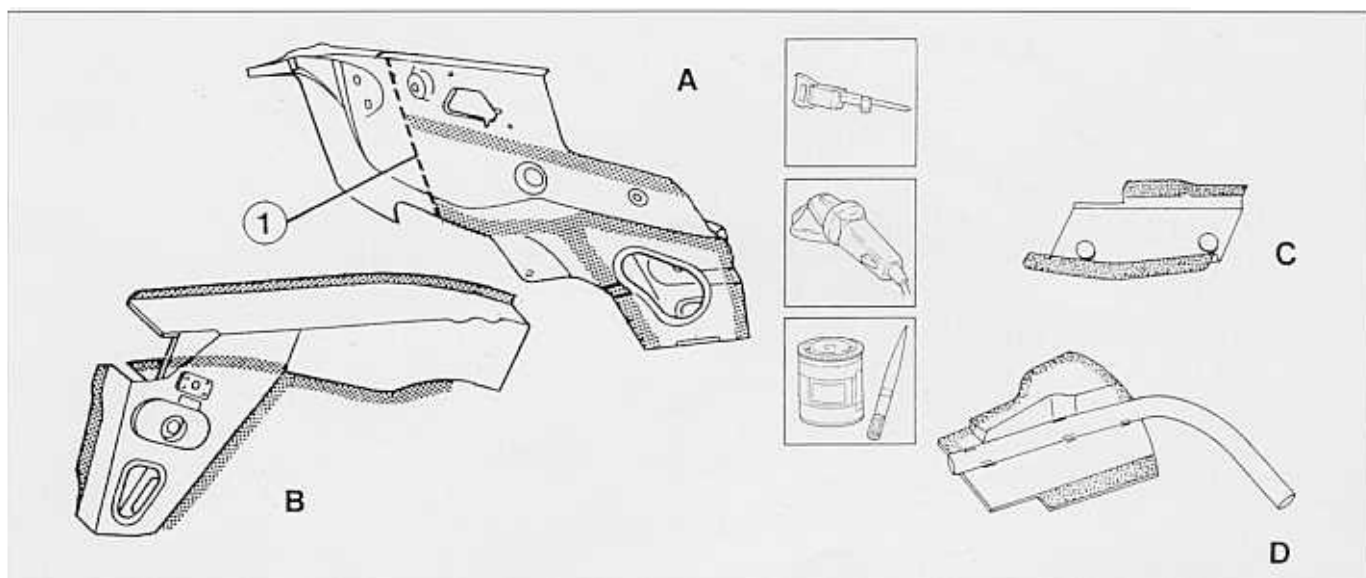
1. Straighten the edges of the bodyshell.
2. Remove the weld residues using a disc grinder.
3. Apply the electro-galvanizing paint on the areas involved in the spot welding.



P3W152M03

#### Preparing the spare part

1. A- Outer panel. B- Inner panel. C- Front bumper mounting bracket. D- Tow hook mounting bracket.
2. Reduce the excess parts of the replacement inner and outer panels along the cutting line 1, using a power saw.
3. Remove the anti-corrosion treatment from the entire perimeter of the inner and outer replacement parts using a disc grinder.
4. Apply the electro-galvanizing paint to the edges treated previously.

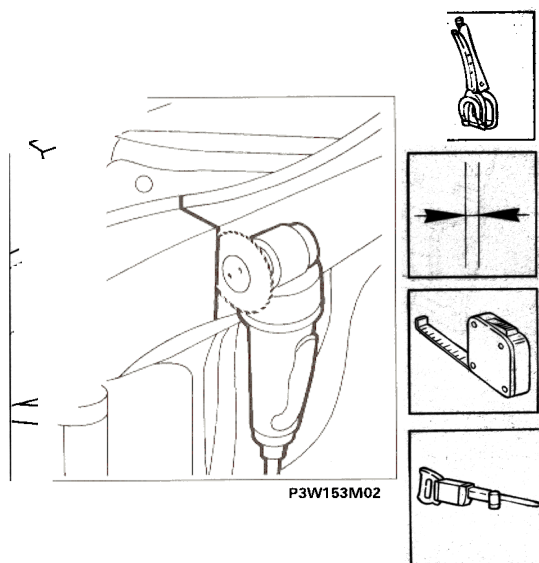
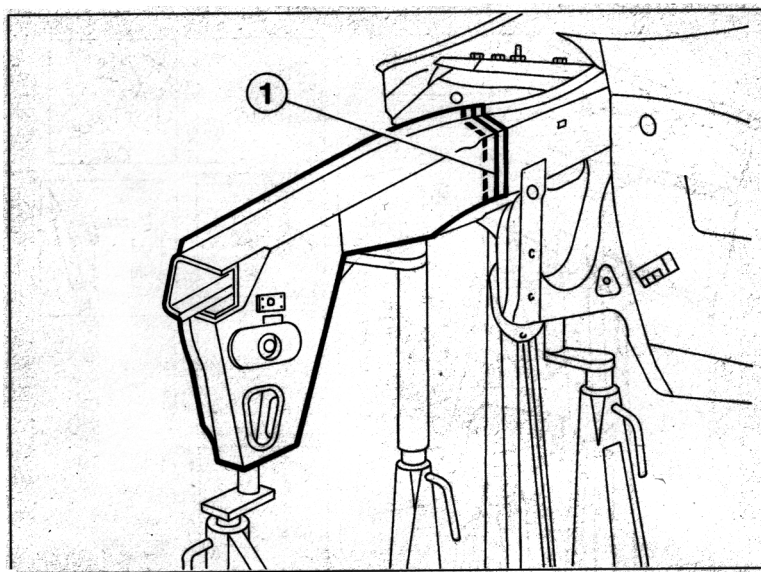


P3W152M04

## 70.

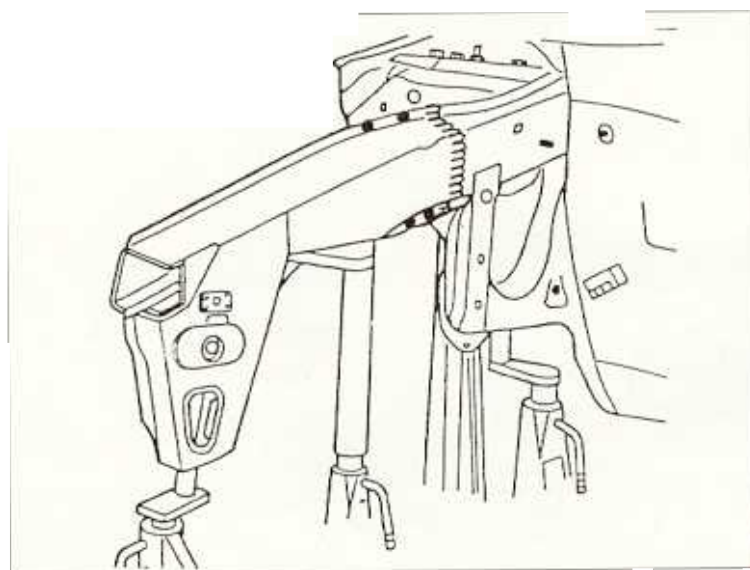
### Positioning the replacement inner panel.

1. Carefully place the replacement inner panel in position.
2. Fix the replacement part to the bodyshell using self-locking pliers.
3. Check that it is correctly positioned using special templates.
4. Trace the cutting line 1 in a symmetrical position in relation to the areas where the two edges of the side panel on the vehicle and the replacement part overlap.
5. Then cut the two edges of the panel along the cutting line 1, so that the join line is perfect.



### Welding the spare part - Inner panel

1. Carry out a continuous weld, using a MIG welder
2. Carry out spot welding working as illustrated in the diagram.

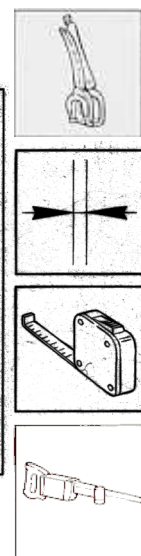
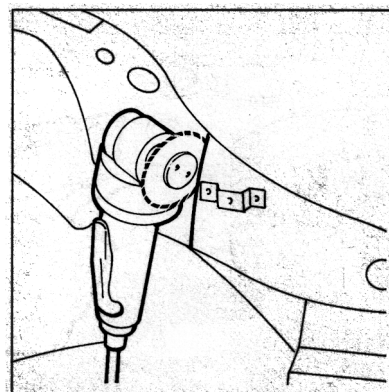
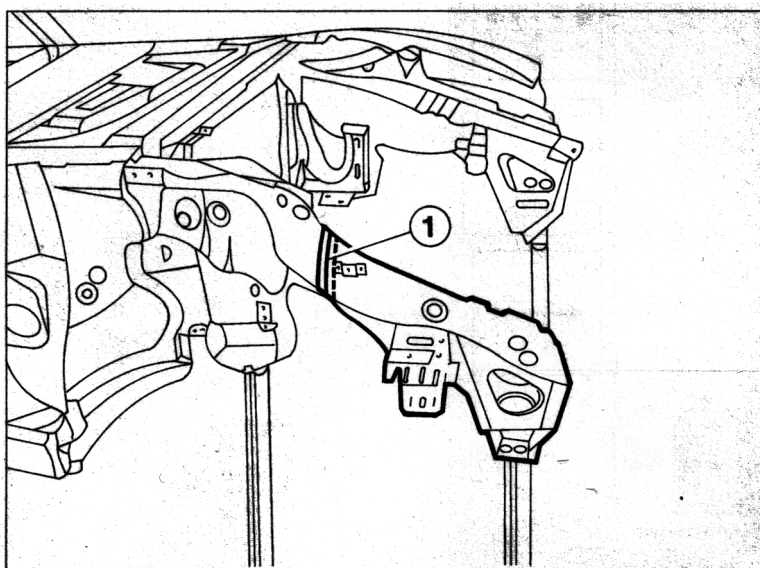


UUUUUU Continuous MIG welding



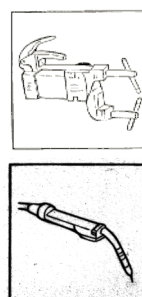
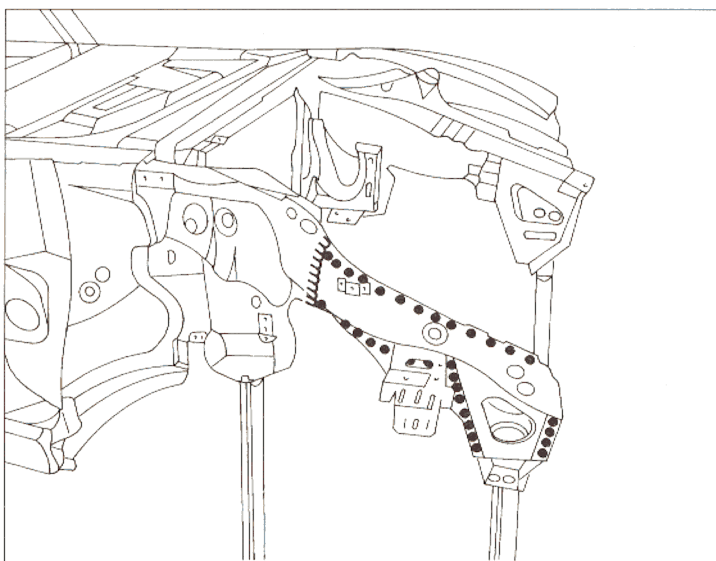
### Positioning the replacement partial outer panel

1. Carefully place the replacement outer panel in position.
2. Fix the replacement part to the bodyshell using self-locking pliers.
3. Check that it is correctly positioned using special templates.
4. Trace the cutting line 1 in a symmetrical position in relation to the areas where the two edges of the side panel on the vehicle and the replacement part overlap.
5. Then cut the two edges of the panel along the cutting line 1, so that the join line is perfect.



### Welding the spare part

1. Carry out spot welding in the areas illustrated in the diagram.
2. Carry out continuous MIG welding as shown in the illustration below.



● ● ● ● Spot welding

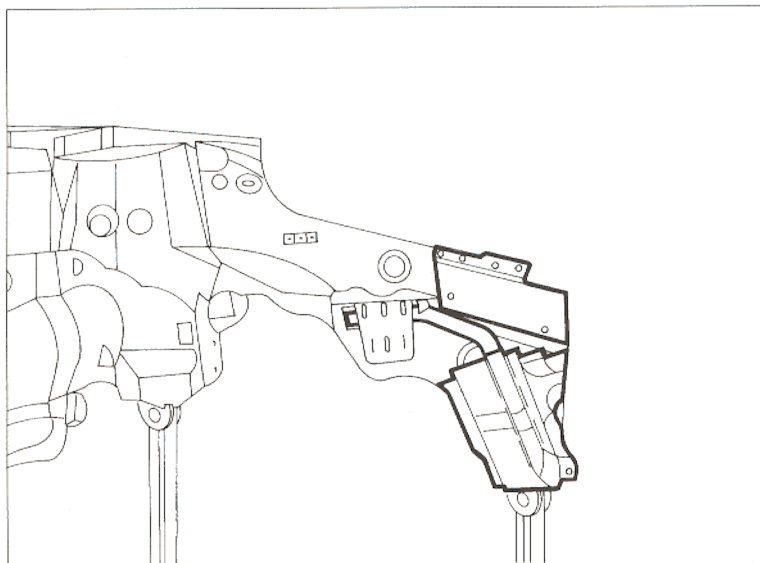
~~~~~ Continuous MIG welding

Replacing body panels

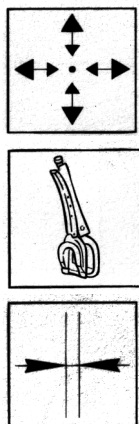
70.

Positioning the connected replacement parts

1. Carefully position the replacement front bumper mounting bracket and the tow hook mounting bracket.
2. Fix the replacement parts to the bodyshell using self-locking pliers.
3. Check that it is correctly positioned with the side panel.

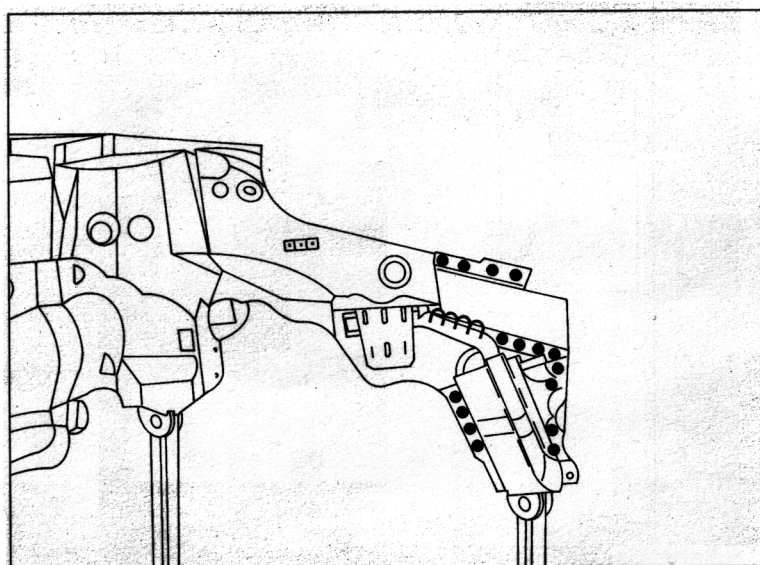


'3W155M01



Welding replacement parts

1. Carry out spot welding in the areas illustrated in the diagram.
2. Carry out continuous MIG welding as shown in the illustration below.



P3W155M02

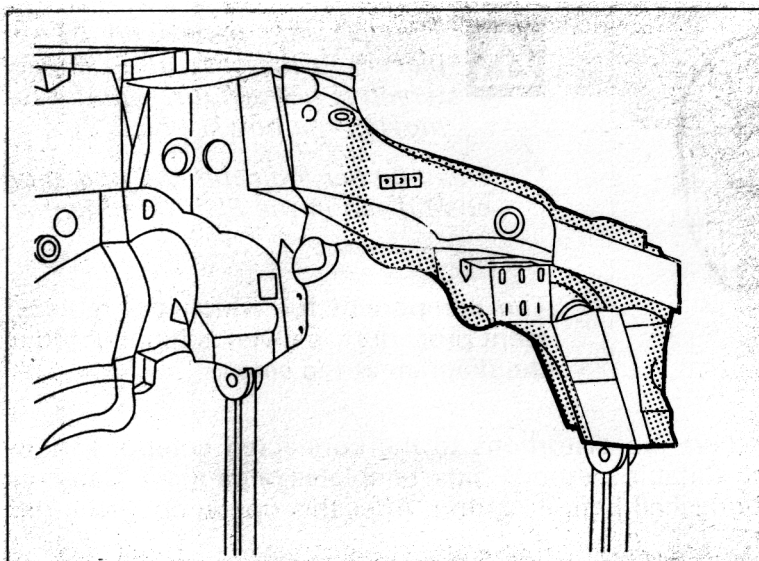


● ● ● ● Spot welding

UUUUUU Continuous MIG welding

Finishing operations

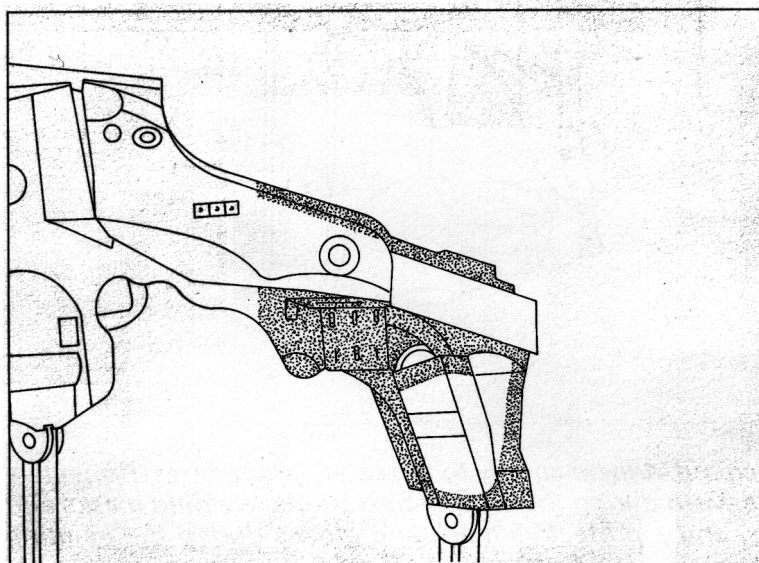
1. Correct any distortions to the panel using a hammer and dolly block.
2. Remove any weld slag using a disc grinder.



P3W156M02

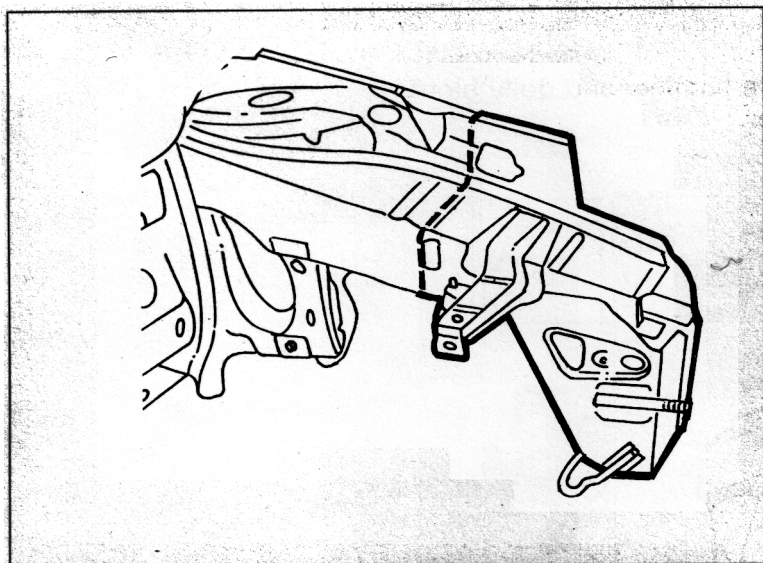
Protections

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



P3W156M01

70.



REPLACING PARTIAL FRONT SIDE PANEL (7090G 12)*

Procedure for left side panel



The left side panel can be replaced, in the case of an impact which is not serious, without removing the power unit.

() This number indicates the operation code given in the Flat Rate Manual.*

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

F3WV1001010103

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

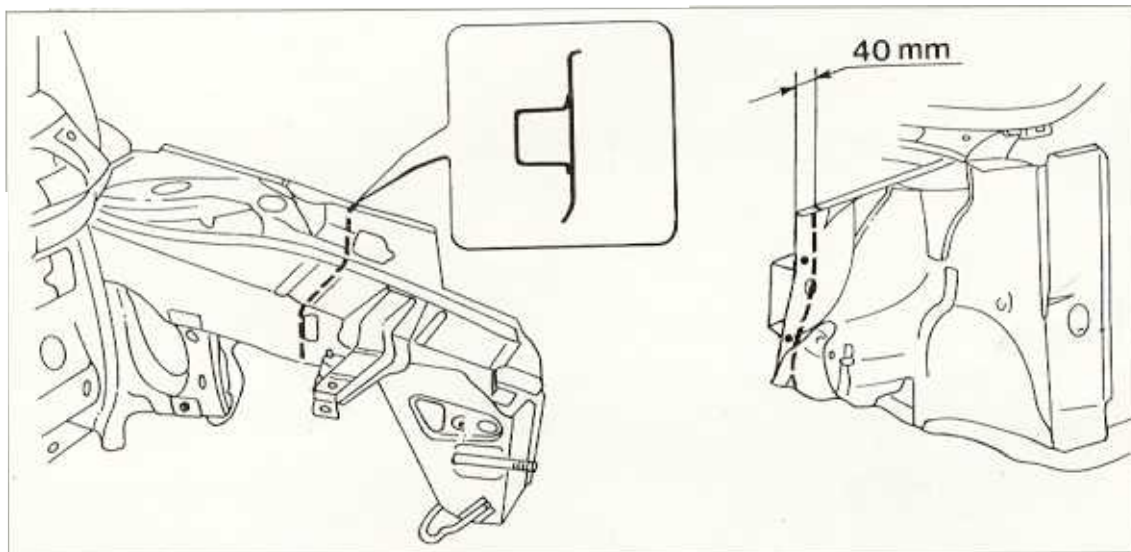
PRELIMINARY DISMANTLING

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

Remove the front cross member cover (see: "Replacing front crossmember cover").

REMOVING

1. Cut along the line shown in the diagram, using a hack sawing machine.
2. Using a rotating brush, clean the area to be chamfered in order to highlight the weld spots, shown in the diagrams below.
3. Using the circular blade saw, cut along the cutting line.
4. Trim the weld spots and, using a hammer and chisel, remove the metal offcuts.



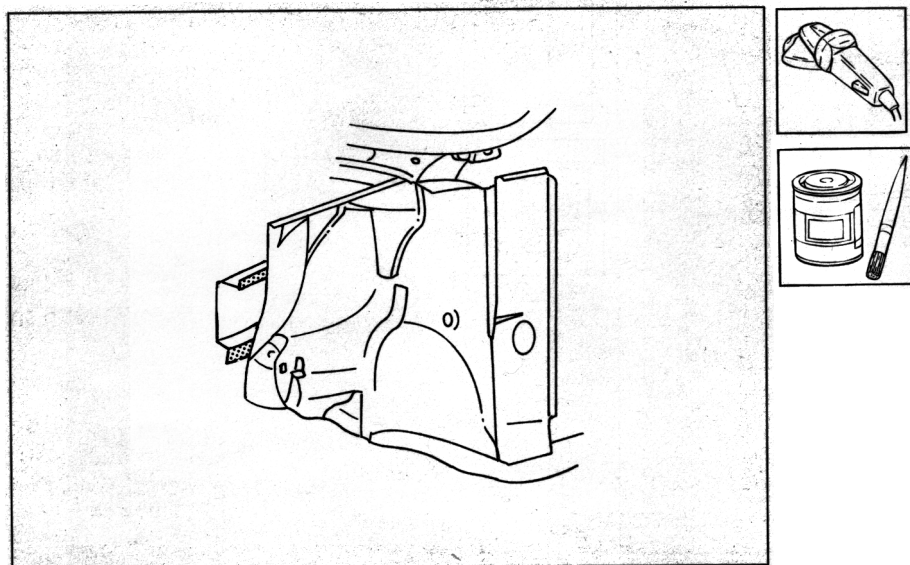
F3WV1001010103



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, welding masks and gloves during the welding operations, and a protective mask and gloves during the painting operations.

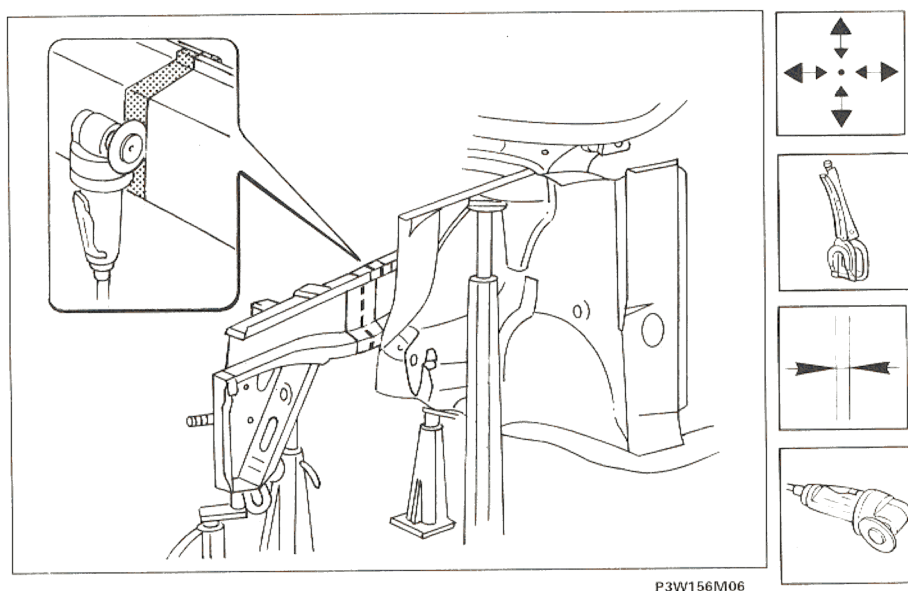
Preparing the edges of the bodyshell

1. Straighten the edges of the bodyshell with a hammer and dolly block.
2. Remove the weld residues using a disc grinder.
3. Apply electro-weldable paint to the areas previously ground.



Positioning the replacement part - Inner panel

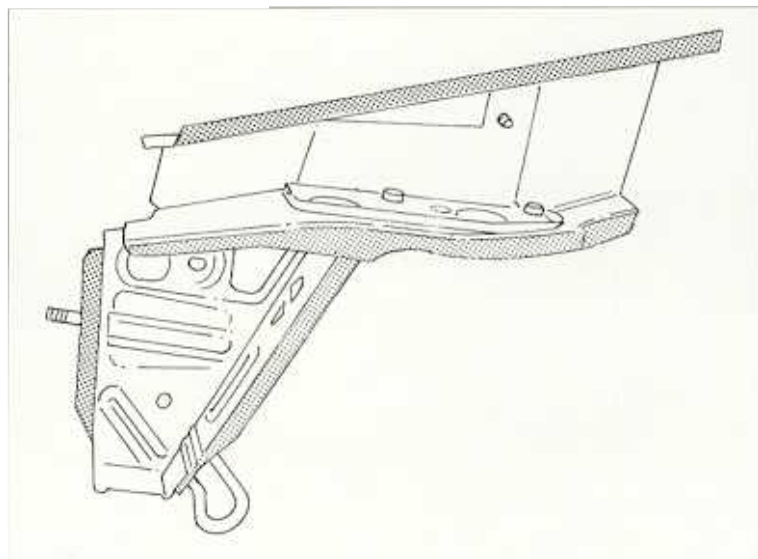
1. Correctly position the inner panel, using the template.
2. Superimpose and secure the components to be welded matching the edges and checking the alignment.
3. Remove the excess parts of the panels using a circular blade saw.



P3W156M06

Preparing the replacement inner panel

1. Using the rotary brush, remove the anti-corrosion treatment from the areas affected by the welding.
2. Apply electro-weldable paint to the areas affected by the spot welding.

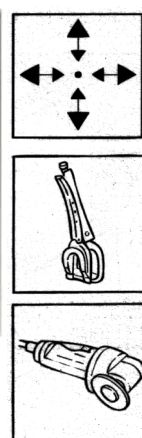
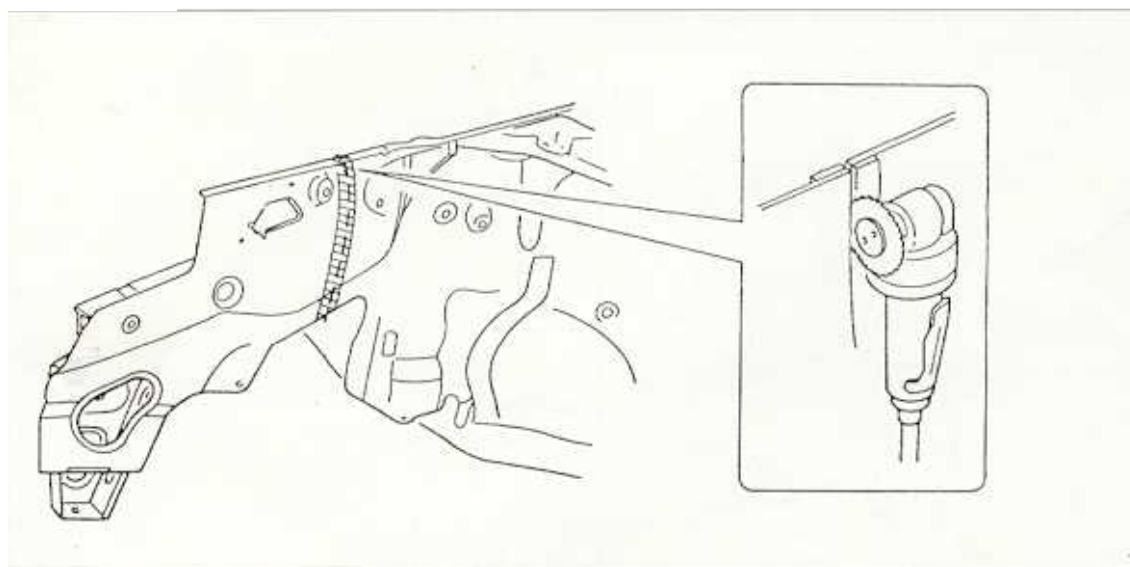


P.3W156M07



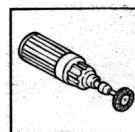
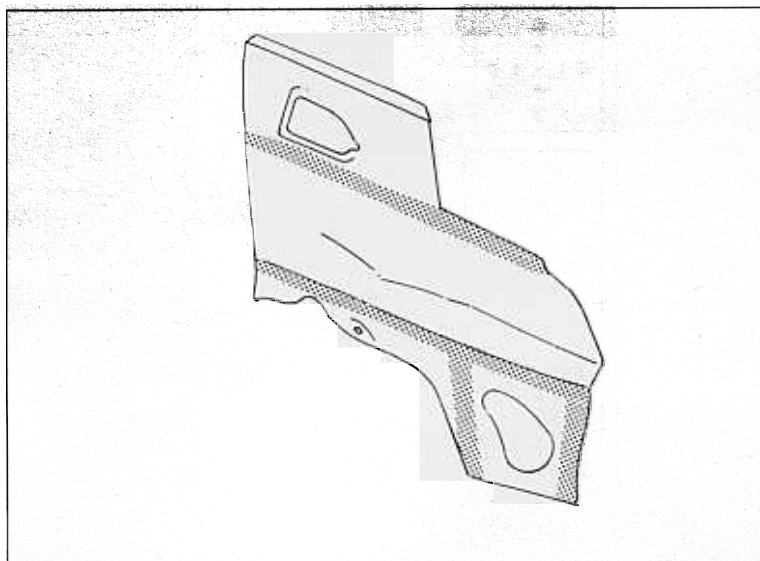
Positioning the replacement outer panel

1. Correctly position the inner and outer panels.
2. Superimpose and secure the components to be welded, matching the edges and checking the alignment.
3. Remove the excess parts of the panels, using a circular blade saw.

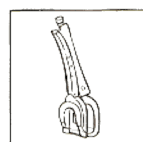
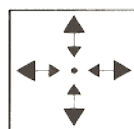
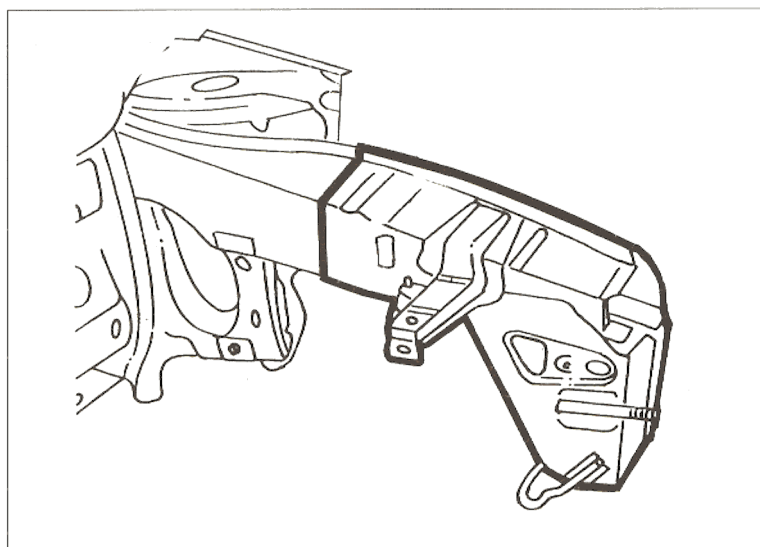


Preparing the replacement outer panel

1. Using a rotary brush, remove the anti-corrosion treatment from the areas affected by the welding.
2. Apply electro-weldable paint to the areas affected by the spot welding.

**Repositioning the replacement inner panel**

1. Correctly position the inner panel on the vehicle.
2. Secure the inner panel using the special self-locking clamps.
3. Check that the alignment is perfect.



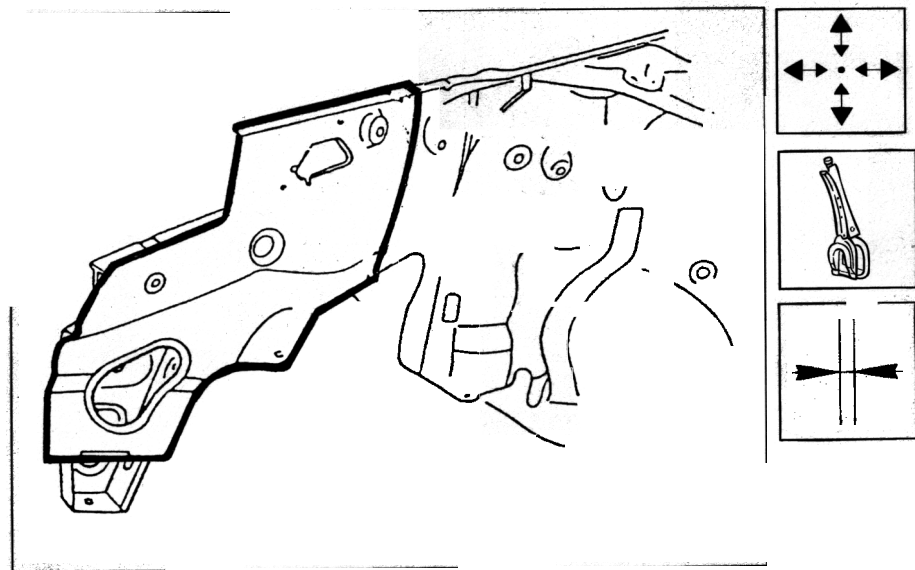
P3W156M10

Replacing body panels

70.

Repositioning the replacement outer panel

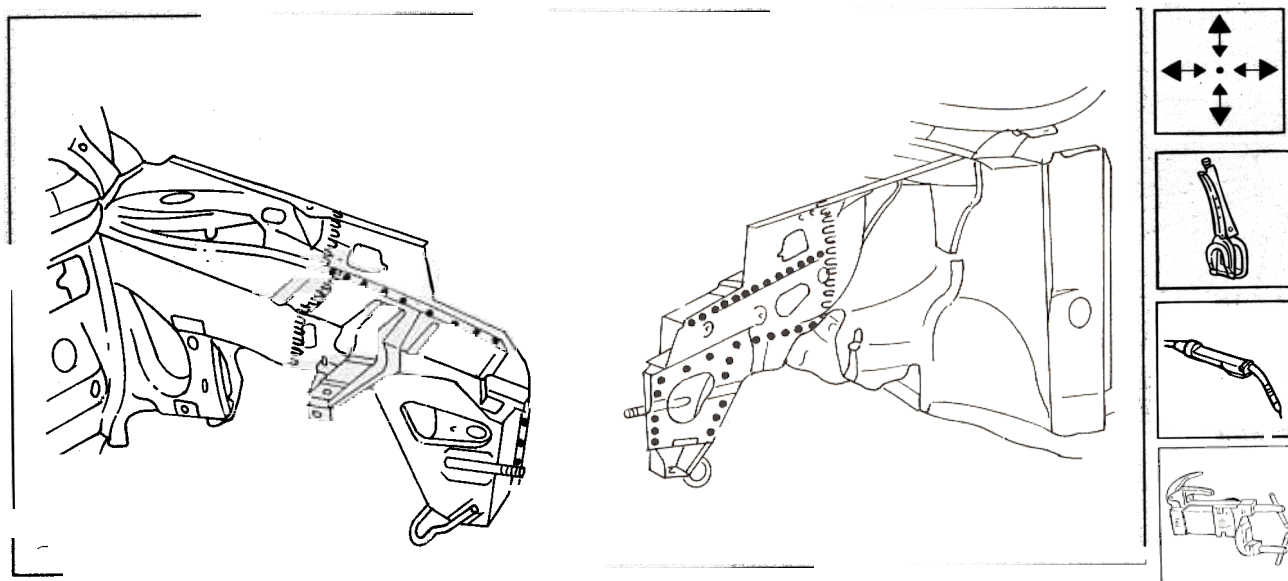
1. Correctly position the outer panel on the vehicle.
2. Secure the outer panel using the special self-locking clamps.
3. Check that the alignment is perfect.



P3W156M11

Welding replacement parts

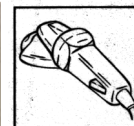
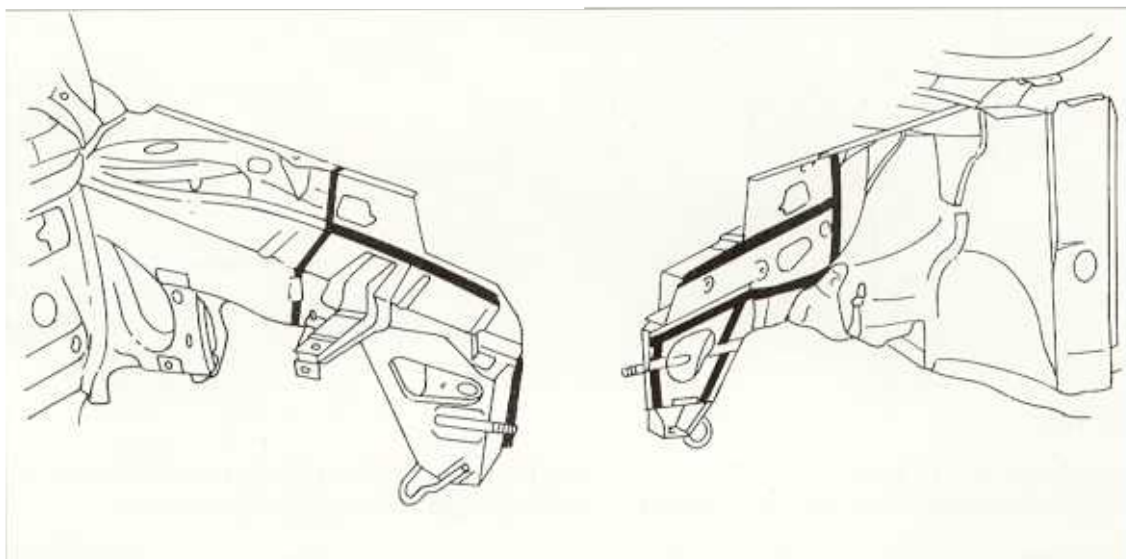
1. Place the parts in position using the template and the self-locking clamps.
2. Carry out continuous welding using the MIG welder in the areas shown in the diagram.
3. Use spot welding in the areas shown in the diagram.



3W604M

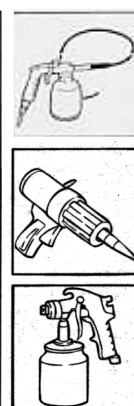
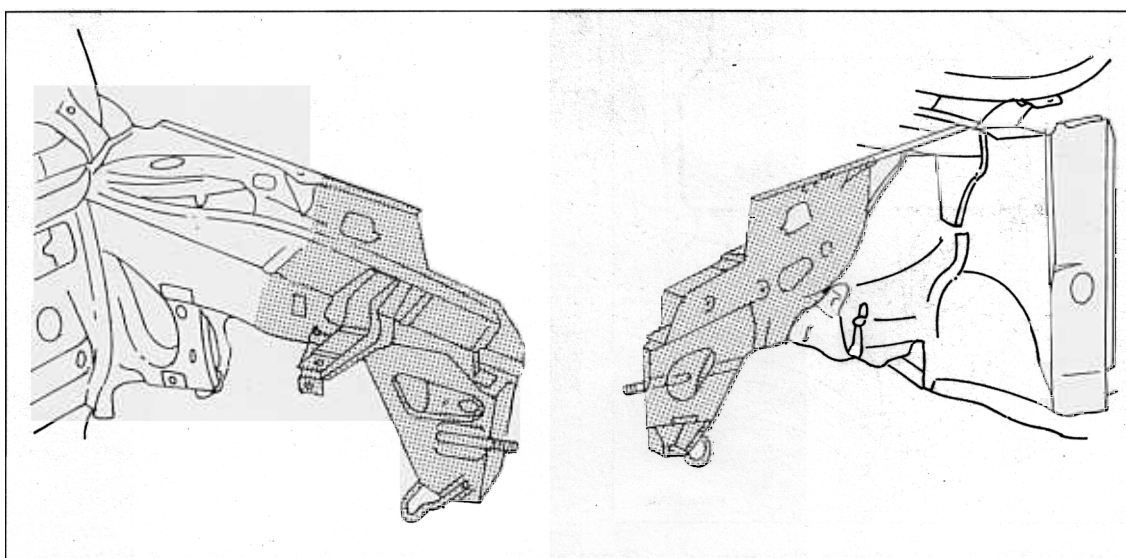
Finishing operations

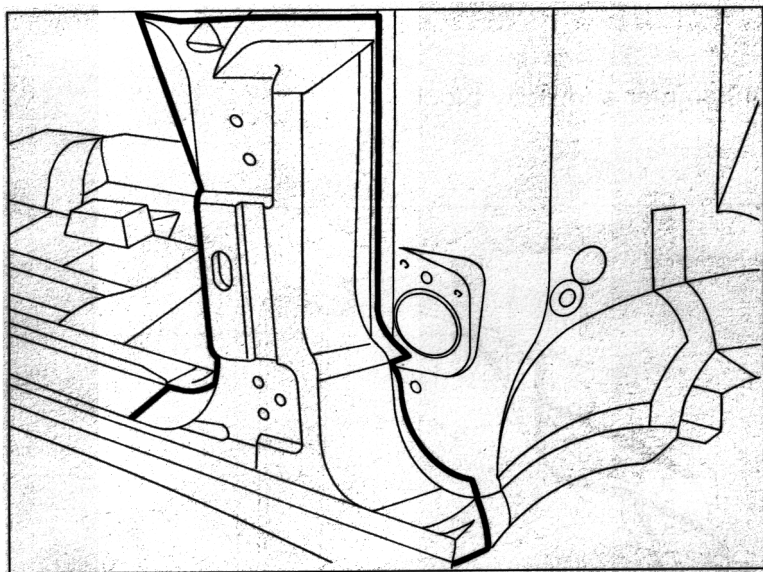
1. Correct any distortions to the panel using a hammer and dolly block.
2. Remove any weld slag using a disc grinder.



Protections

1. Apply anti-oxidant protective treatment to the areas previously affected by the welding.
2. Seal the joints between the spares and the bodyshell using IVI 854210 transparent acrylic sealant or an equivalent product.
3. Proceed with the painting and waxing stage.





REPLACING FRONT 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 bodyshell alignment figures, using suitable methods (jigs, templates or gauges).

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

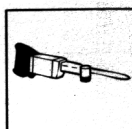
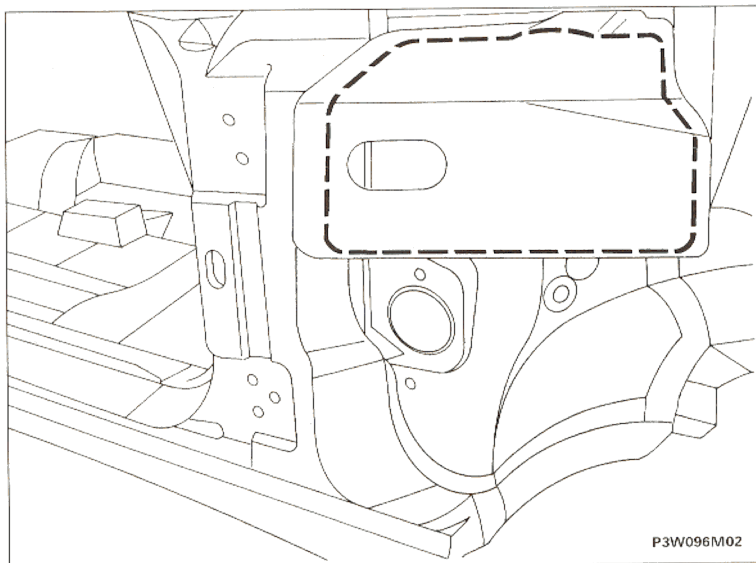
After this operation check that the components not being replaced are in tact.

Preliminary dismantling

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

Removing the pillar reinforcement

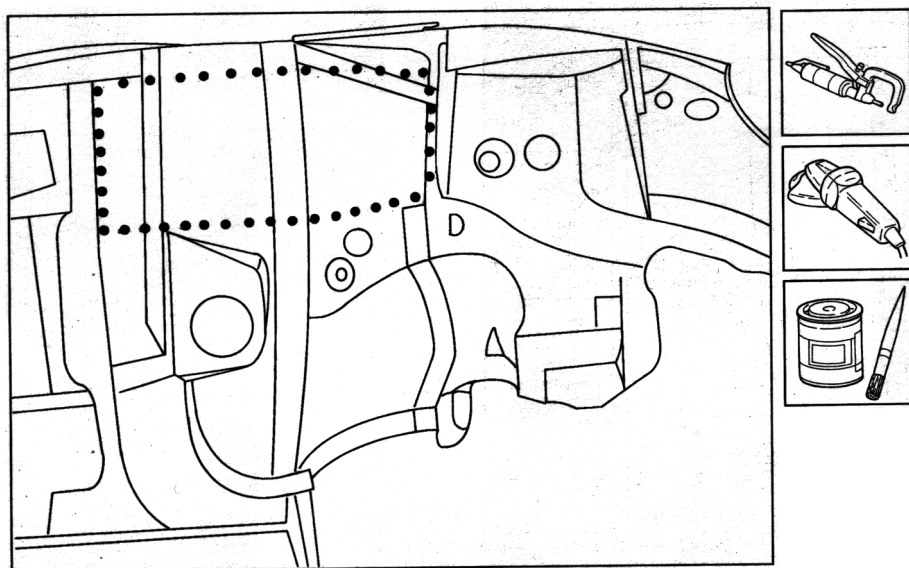
1. Cut the front pillar reinforcement using a power saw following the dotted lines shown in the diagram below.



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

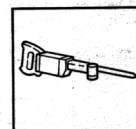
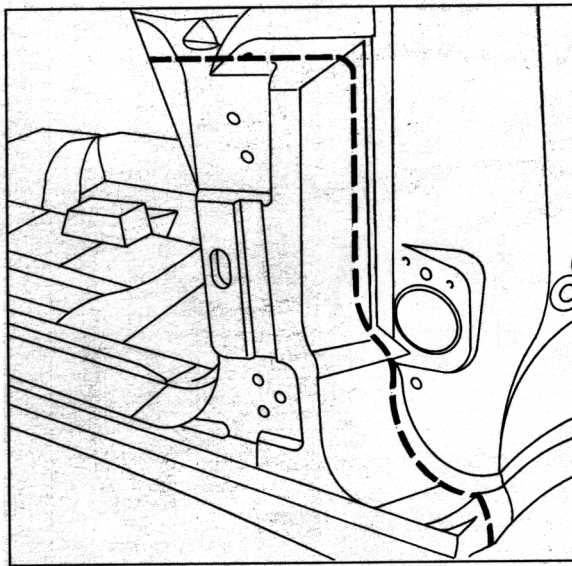
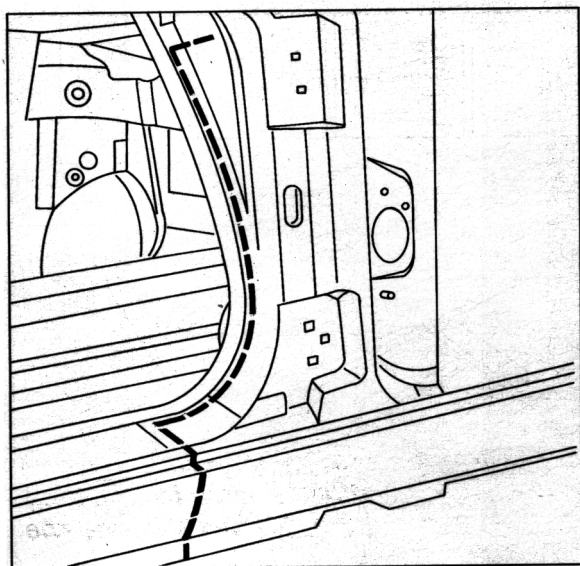
1. Remove the weld points in the areas illustrated in the diagram, using a special cutter.
2. Remove the metal off cuts using pliers.
3. Straighten the edges with a hammer and dolly block.
4. Remove the spot weld residues using a disc grinder.
5. Apply the electro-galvanizing paint or an equivalent product,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



For the operations of preparing, positioning and welding the replacement part see the paragraph on replacing the panel.

Removing the complete pillar

- 1 Cut the complete front pillar using the power saw following the dotted lines shown in the diagrams below.

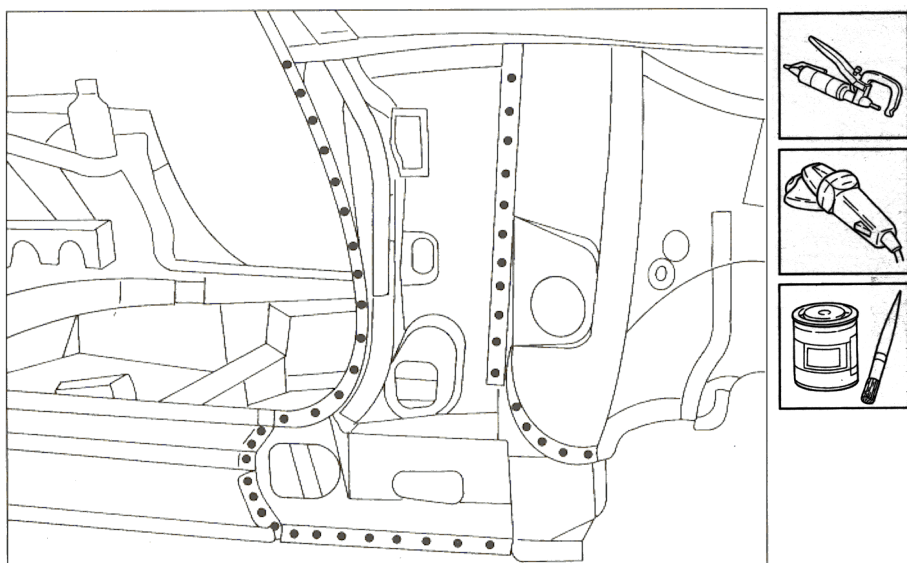


Replacing body panels

70.

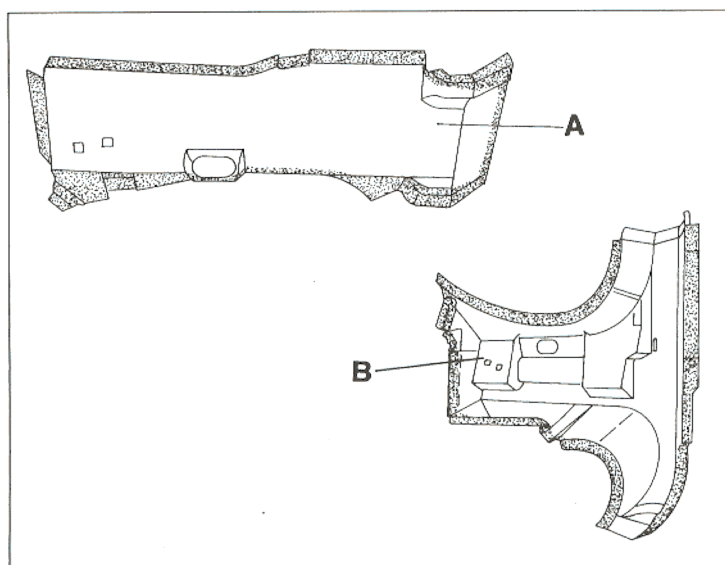
Removing off cuts and preparing edges of bodyshell

1. Remove the weld points in the areas illustrated in the diagram, using a special cutter.
2. Remove the 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.

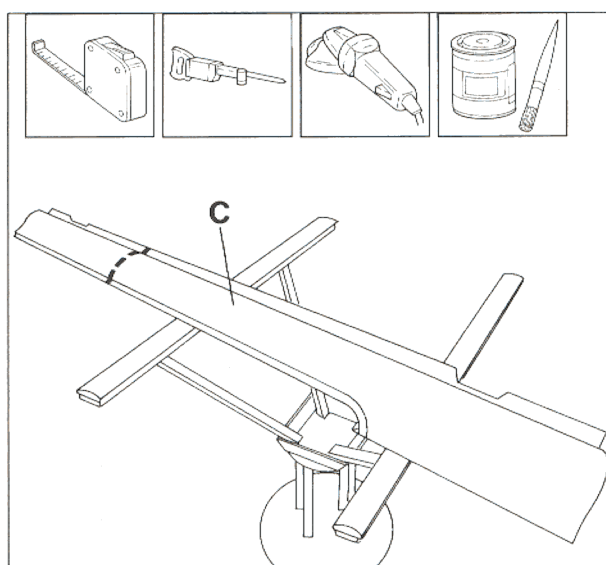


Preparing the replacement parts

1. A- Internal pillar reinforcement. B- Pillar cover. C- Underdoor side member.
2. Reduce the excess parts of the underdoor side member replacement part by cutting.
3. Remove the anti-corrosion treatment from the entire perimeter of the inside and the outside of the replacement parts using a disc grinder.
4. Apply the electro-galvanizing paint to the edges in contact with the bodyshell.



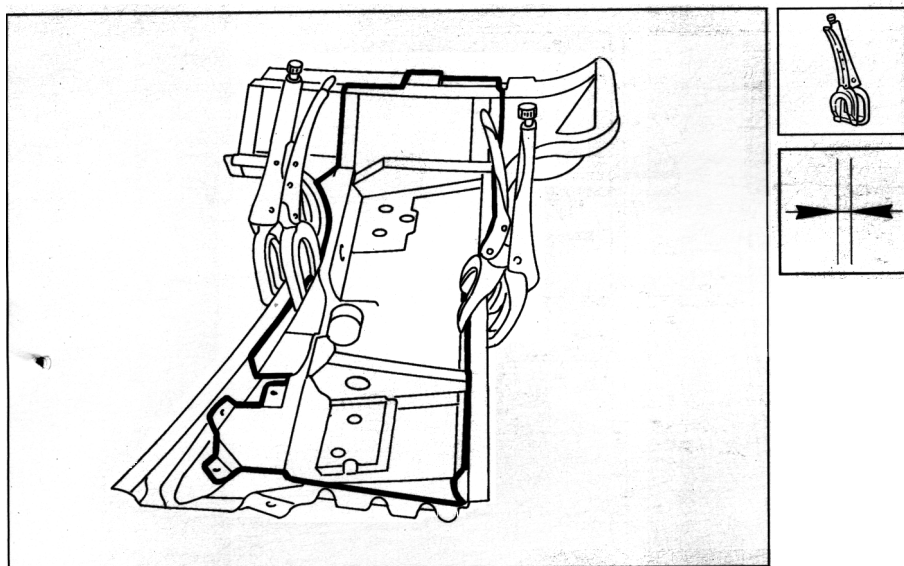
P3W098M02



P3W098M03

Positioning the replacement part

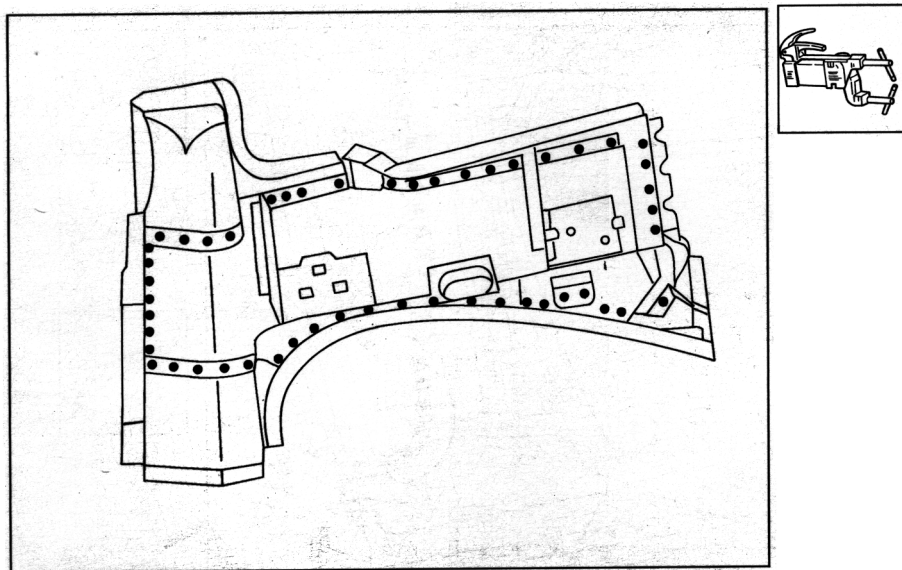
1. Carefully place the internal reinforcement replacement part in the pillar cover replacement part.
2. Fix the replacement part to the cover using self-locking pliers as illustrated in the diagram.
3. Check that the internal reinforcement is correctly positioned in relation to the cover checking the alignment between the holes in the hinge in the reinforcement and the ones in the cover.



P3W099M01

Welding internal reinforcement and pillar cover replacement parts

- 1 Carry out spot welding using a spot welder in the contact area between the internal reinforcement and the pillar cover.



P3W099M02

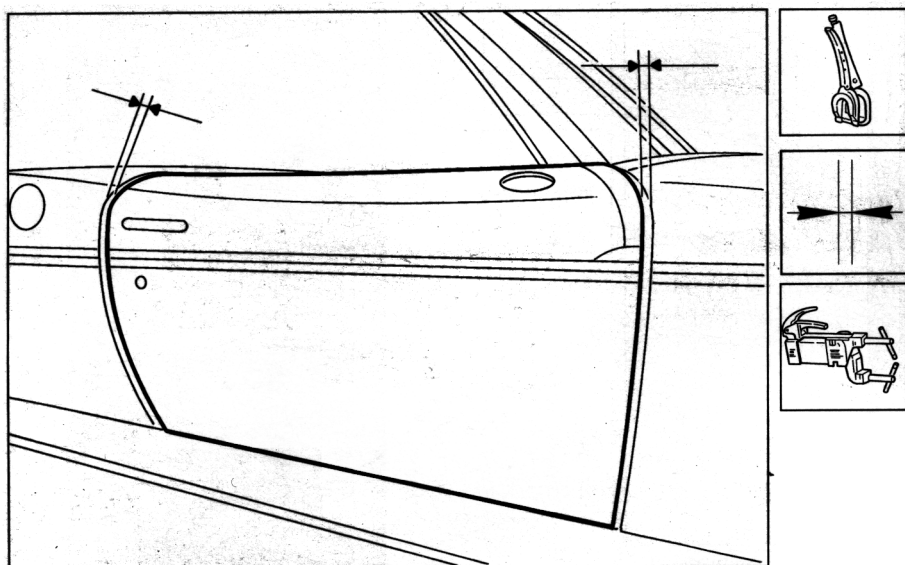
● ● ● ● Spot welding

Replacing body panels

70.

Positioning the replacement part on the bodyshell

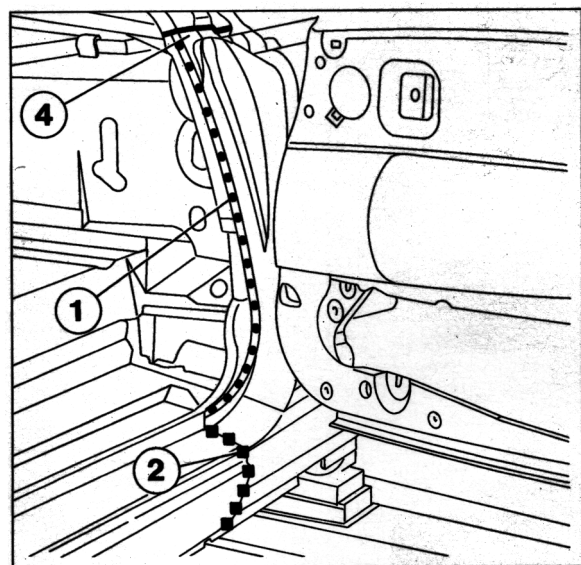
1. Carefully position the complete pillar replacement part.
2. Fix the replacement part to the bodyshell using self-locking pliers.
3. Tack the replacement part to the bodyshell with several spot welds.
4. Temporarily fit the front wing and the door, then check that the alignment is correct and that the gap between the replacement part and the front wing and the door and the rear wing is even. At the end of the check remove the front wing.



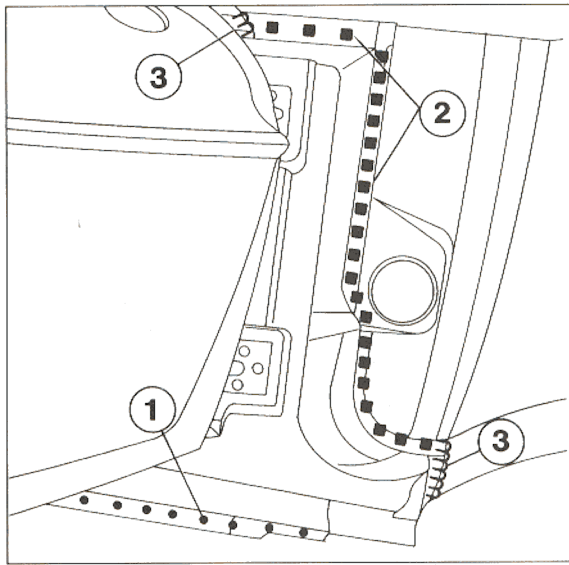
P3W100M01

Welding the spare part to the bodyshell

1. Carry out spot welding using a spot welder in the areas illustrated (1).
2. Carry out MIG welding for filling in the areas illustrated (2)
3. Carry out continuous MIG welding in the areas illustrated (3)
4. Carry out brass welding using an oxy-acetylene canister in the area illustrated (4)
5. Weld the pillar reinforcement as described in the paragraph "Replacing complete panel" in this manual



P3W100M02

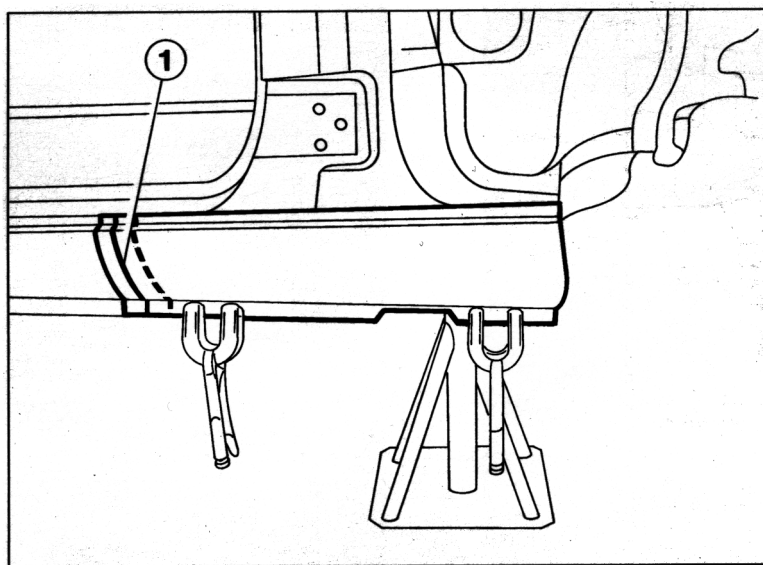


P3W100M03

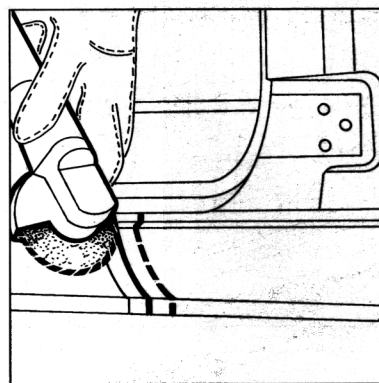
● ● Spot welding ■ ■ MIG welding for filling UUU Continuous MIG welding brass welding

Positioning the replacement underdoor side member

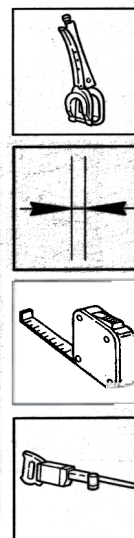
1. Carefully position the underdoor side member replacement part.
2. Fix the replacement part to the bodyshell using self-locking pliers.
3. Trace the cutting line 1 symmetrical to the areas where the two edges of the underdoor side member and the replacement part are superimposed.
4. Then cut the two edges of the panel along the cutting line 1, so that a perfect join line is obtained.
5. Check that the replacement part is correctly positioned checking the alignment and the uniformity of the opening between the door, previously fitted and the actual replacement part.



P3W101M01

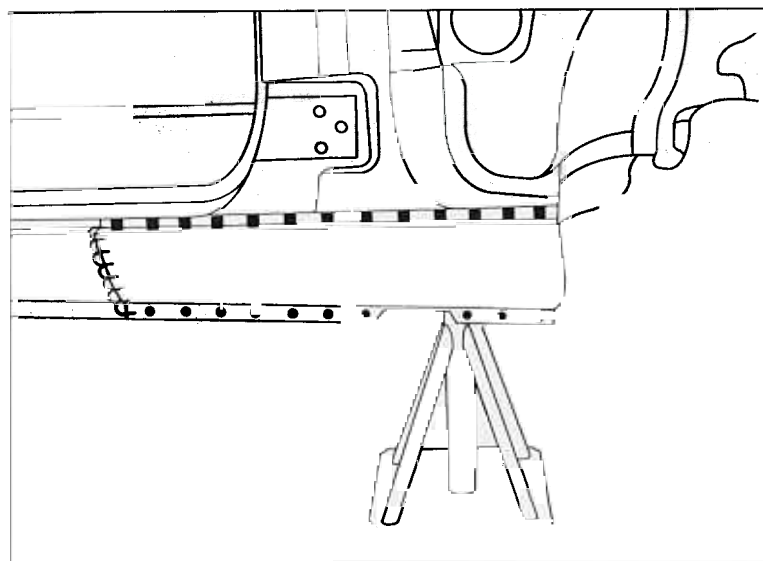


P3W101M02

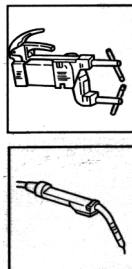


Welding the underdoor side member replacement part

1. Carry out spot welding using a spot welder along the lower contact area between the edges of the internal reinforcement and the replacement part.
2. Carry out MIG welding for filling in the upper area in contact with the internal reinforcement.
3. Carry out continuous MIG welding in the area involved in the cutting.



P3W101M03



● ● ● ● Spot welding

■ ■ ■ ■ MIG welding for filling

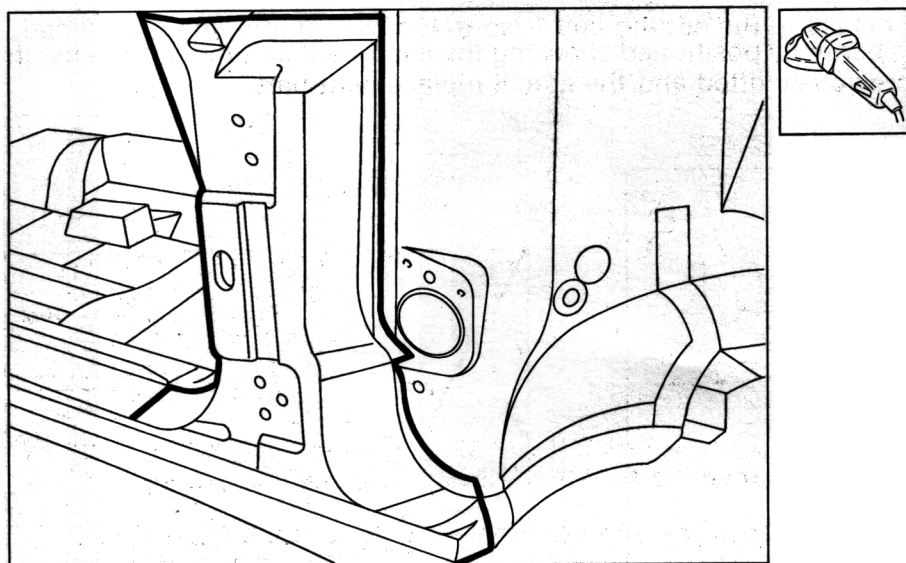
~~~~~ Continuous MIG welding



## 70.

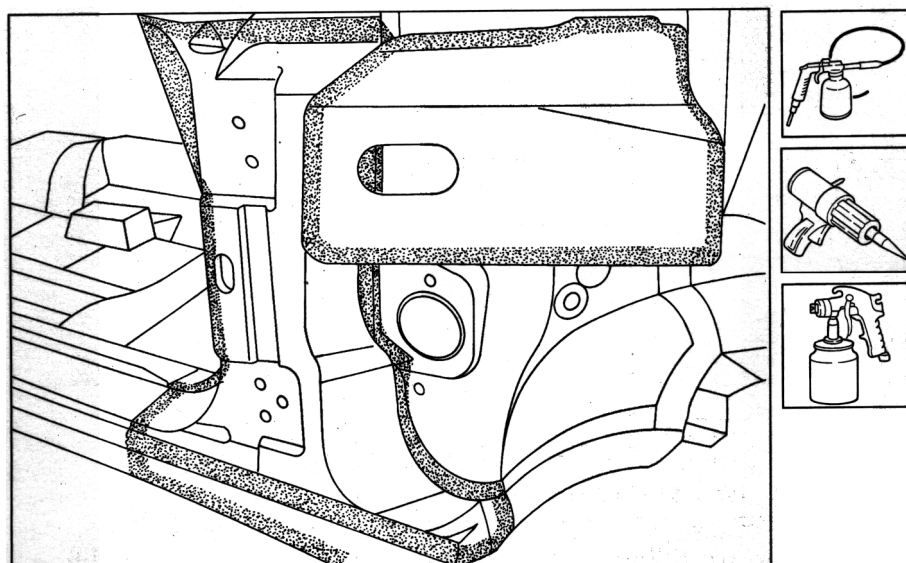
### Finishing operations

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

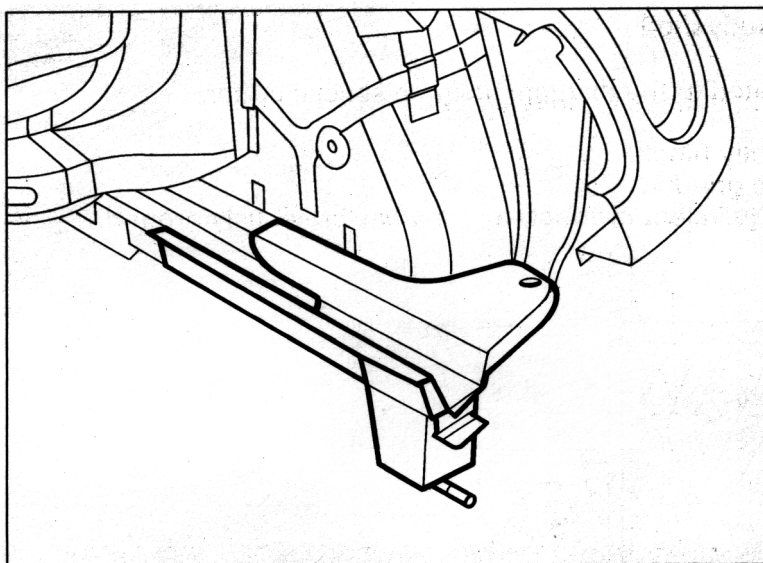


### Protections

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



#### REPLACING PARTIAL REAR SIDE MEMBER



P3W103M01

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.

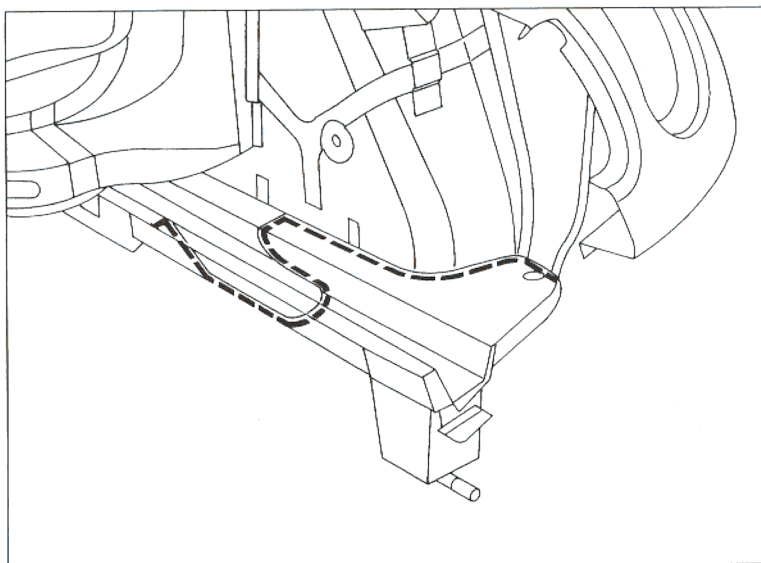
After this operation check that the components not being replaced are in tact.

#### Preliminary dismantling

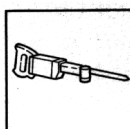
Remove the moveable parts of the bodywork and the mechanical and electrical components which could impede the repair operations or be damaged during them. Also remove the rear cover complete with reinforcement, the rear cross member and the rear floor panel as described previously.

#### Removing

Cut the rear side member using a power saw following the dotted lines shown in the diagram below.



P3W103M02

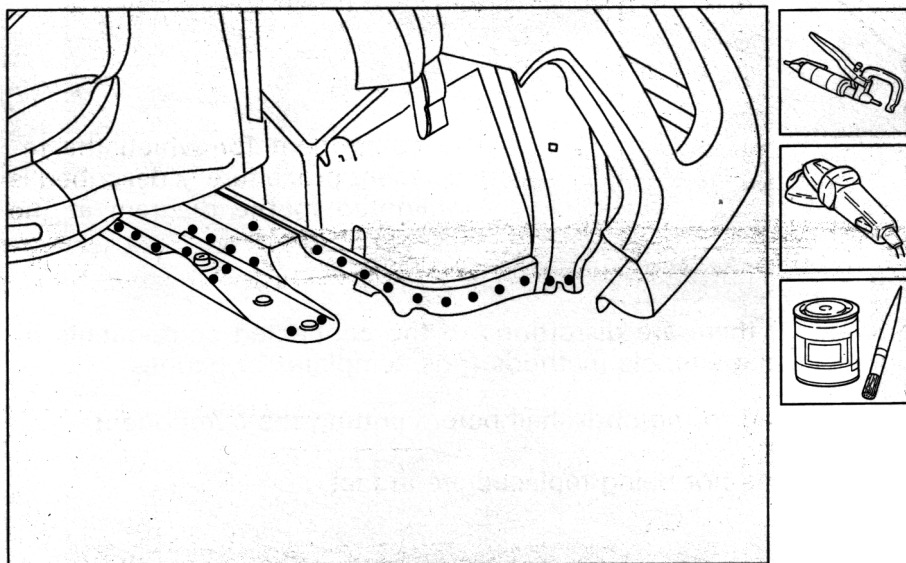


*When carrying out the operations described, adhere strictly to the safety procedures. Wear protective shoes, ear-muffs and gloves during the cutting operations, masks for welding and gloves during the welding operations, and a protective mask and gloves during the painting operations.*

## 70.

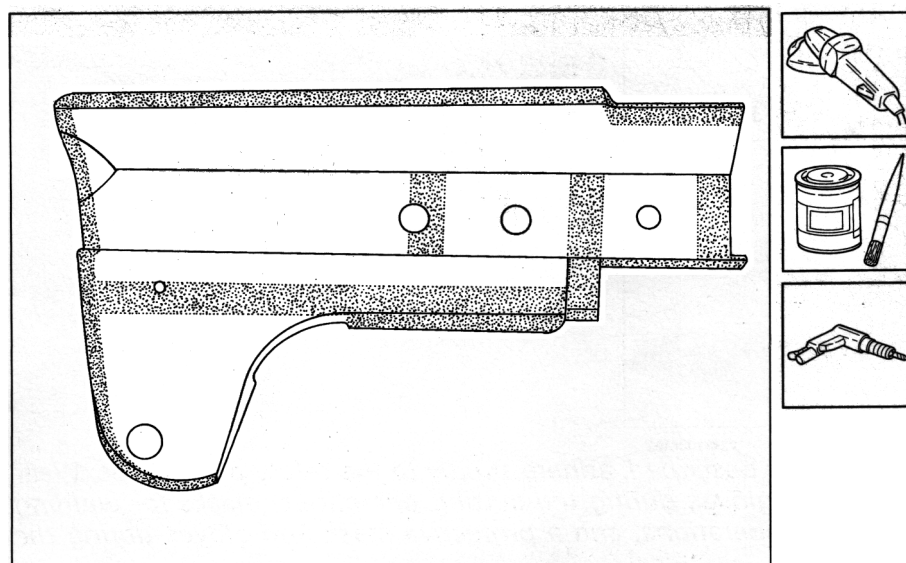
### Removing off cuts and preparing edges of bodyshell

1. Remove the weld points in the areas illustrated in the diagram, using a special cutter.
2. Remove the 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.

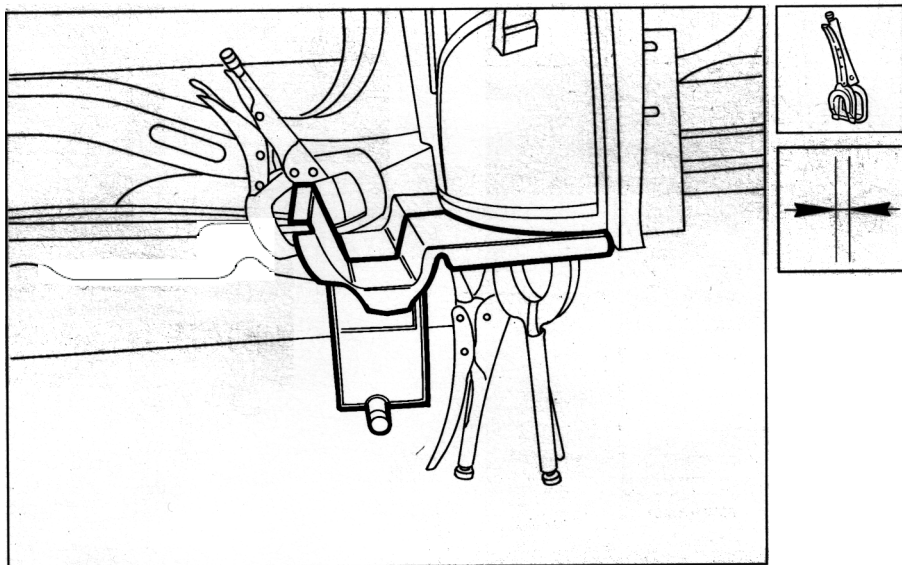


51411/000003



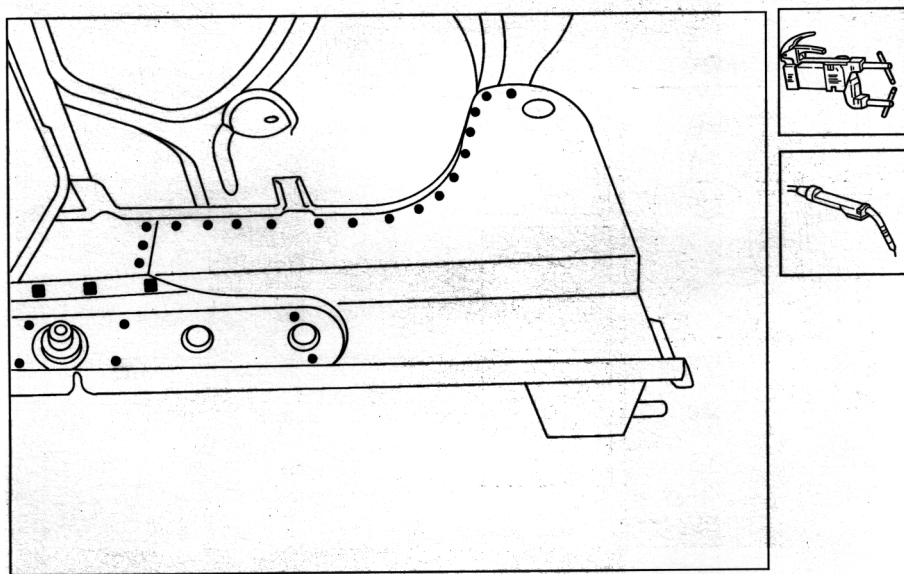
### Positioning the replacement part

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 with the wheel arch and the part of the side member not removed and also check the alignment figures using special templates.



### Welding the spare part

1. Carry out MIG welding for filling in the contact area with the side member not removed previously.
2. Carry out spot welding using a spot welder in the area in contact with the side member not removed previously and the areas in contact with the wheel arch.



P3W105M02

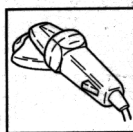
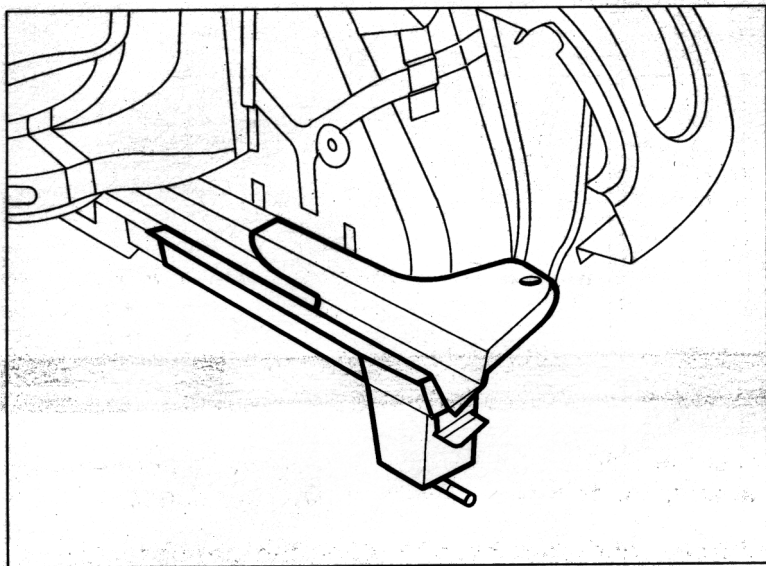
●●●● Spot welding

■■■■ MIG welding for filling

## 70.

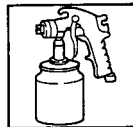
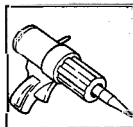
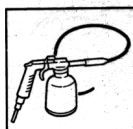
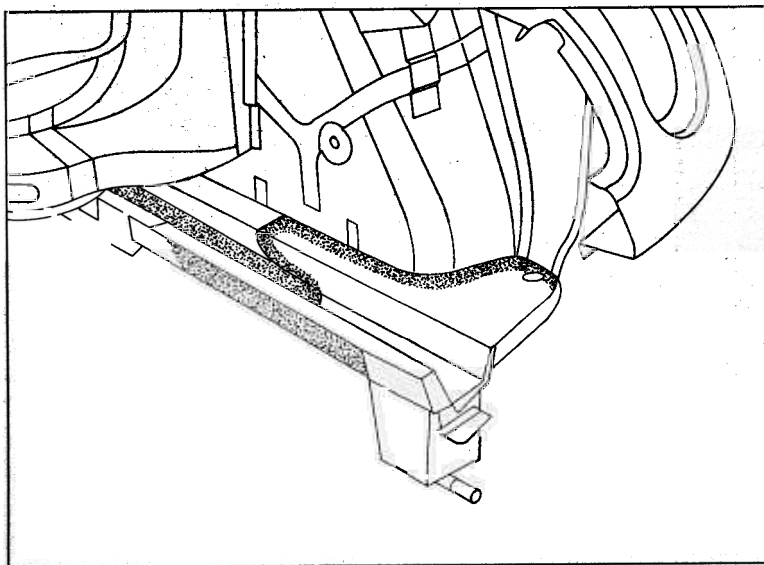
### Finishing operations

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

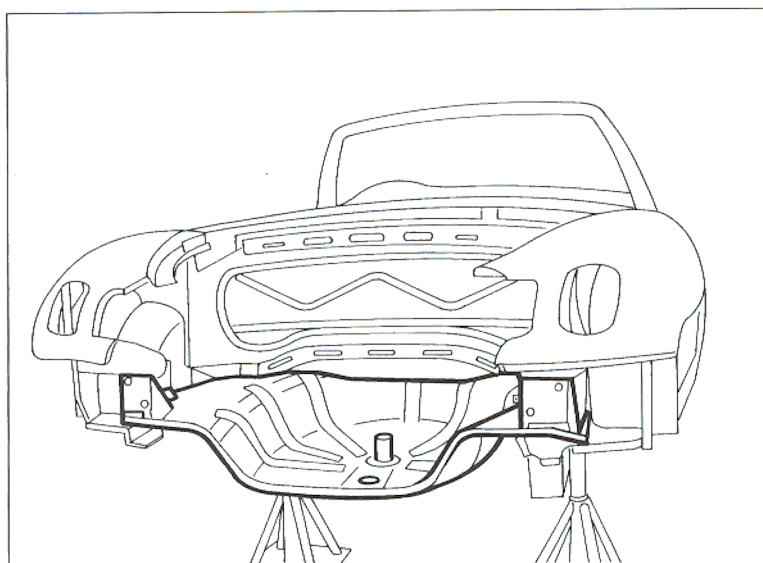


### Protections

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 REAR FLOOR



P3W107M01

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.

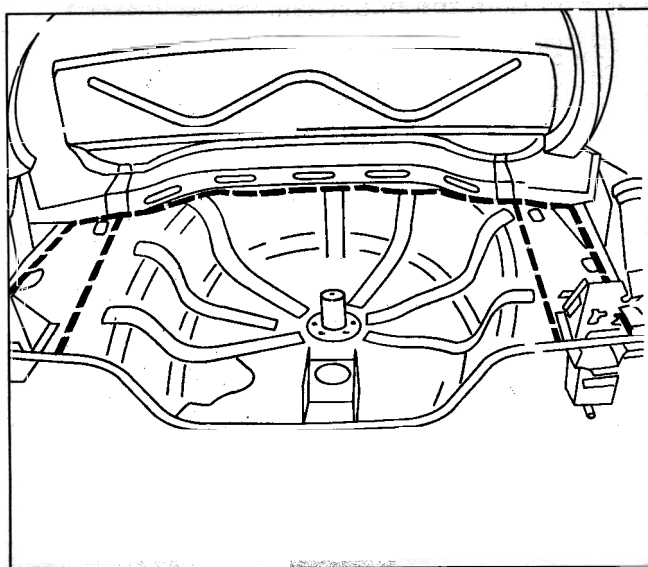
After this operation check that the components not being replaced are in tact.

#### Preliminary dismantling

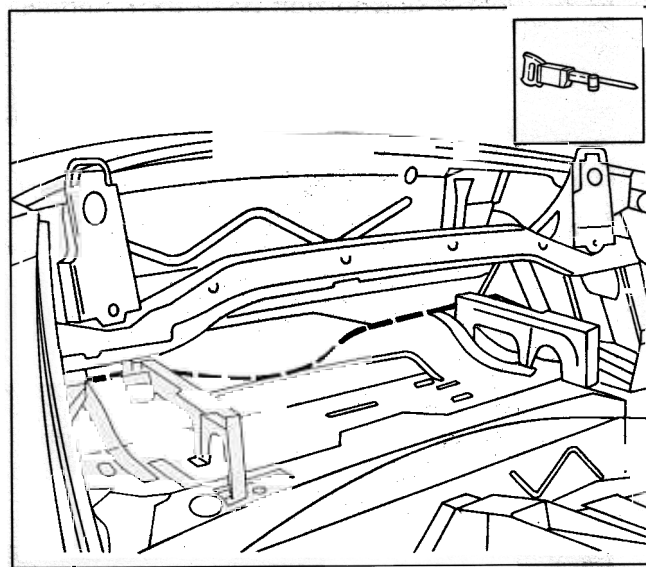
Remove the moveable parts of the bodywork the mechanical and electrical components which could impede the repair operations or be damaged during them. Also remove the rear cover complete with support and the rear cross member, as described previously.

#### Removing

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



P3W107M02



P3W107M03



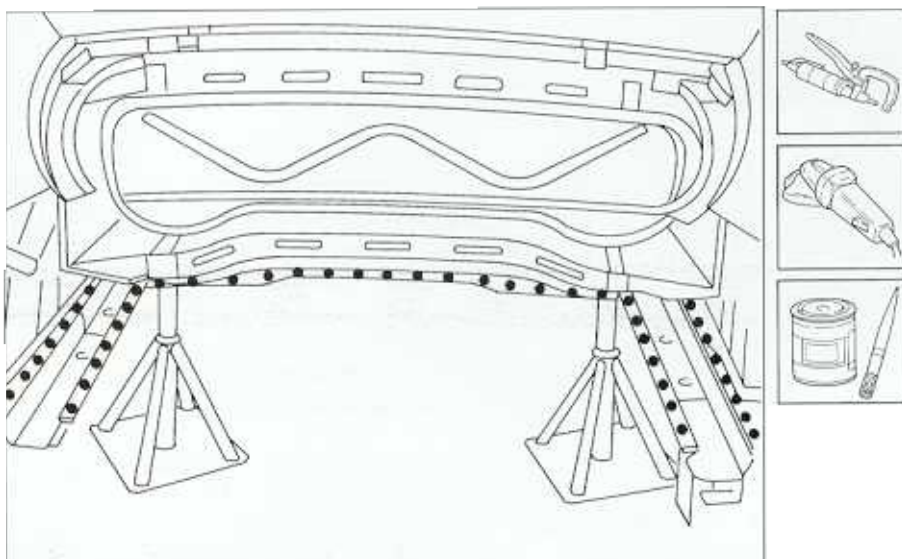
*When carrying out the operations described, adhere strictly to the safety procedures. Wear protective shoes, ear-muffs and gloves during the cutting operations, masks for welding and gloves during the welding operations, and a protective mask and gloves during the painting operations.*



## 70.

### Removing off cuts and preparing edges of bodyshell

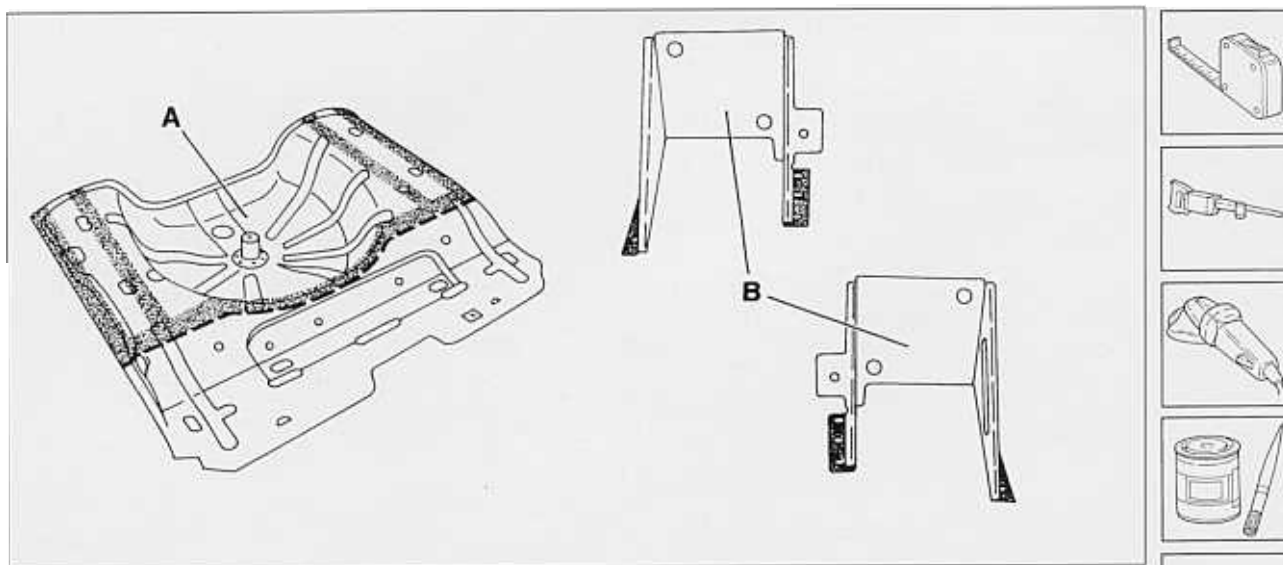
1. Remove the weld points in the areas illustrated in the diagram, using a special cutter.
2. Remove the metal off cuts using pliers.
3. Straighten the edges with a hammer and dolly block.
4. Remove the spot weld residues using a disc grinder.
5. Apply the electro-galvanizing paint or an equivalent product,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



P3W108M01

### Preparing the replacement parts

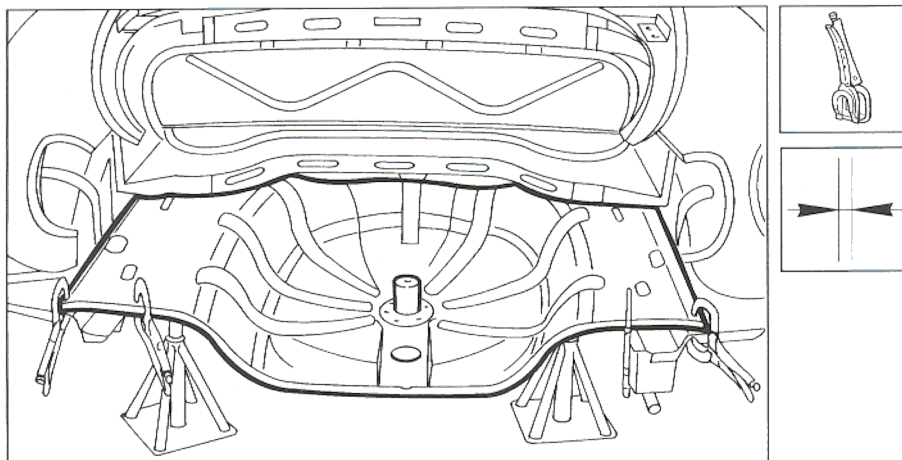
1. A- Rear floor panel B- Rear bumper mounting brackets
2. Reduce the rear floor panel replacement part along the cutting line shown in the diagram in order to be able to adapt it to the bodyshell.
3. Remove the anti-corrosion treatment from the entire perimeter of the inside and the outside of the replacement parts using a disc grinder.
4. Apply the electro-galvanizing paint to the edges in contact with the bodyshell.



P3W108M02

## Positioning the replacement rear floor panel

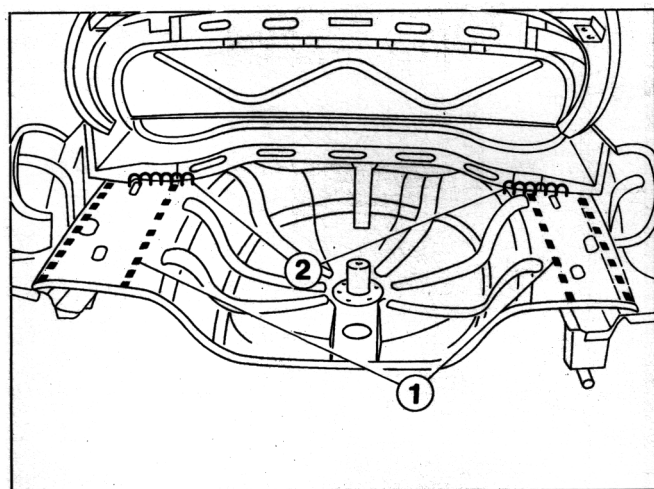
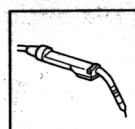
1. Carefully place the replacement part in position inserting it between the two edges of the bodyshell near the contact area between the bulkhead for the tank housing and the rear side members.
2. Fix the replacement part to the bodyshell using self-locking pliers.
3. Check that it is correctly positioned checking the alignment of the edges of the replacement part with those of the rear side members and then with the alignment figures.



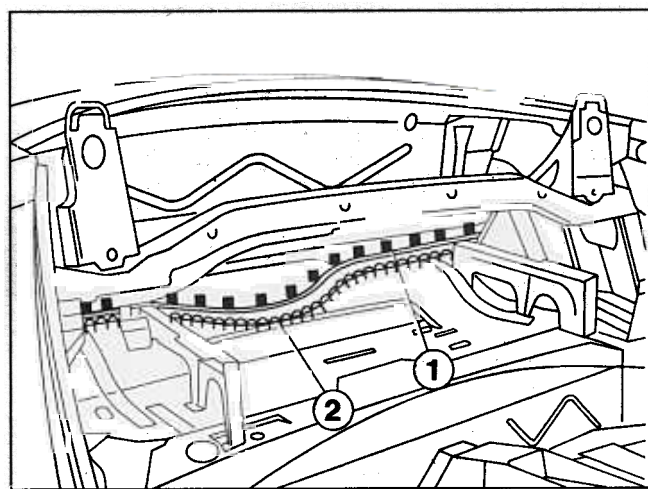
P3W109M01

## Welding the replacement rear floor panel

1. Carry out MIG welding for filling (1) in the contact areas between the replacement part and the side members
2. Carry out continuous MIG welding (2) in the contact area between the side members and the tank housing separating bulkhead.
3. Carry out MIG welding for filling (1) between the upper edge inside the tank housing and the replacement part.
4. Carry out continuous MIG welding (2) in the contact areas between the inner part of the replacement part and the tank housing.
5. Carry out continuous MIG welding (2) in the contact areas between the replacement part and the underbody.
6. Apply sealant to the contact areas between the replacement part and the tank housing.



P3W109M02



MIG welding for filling

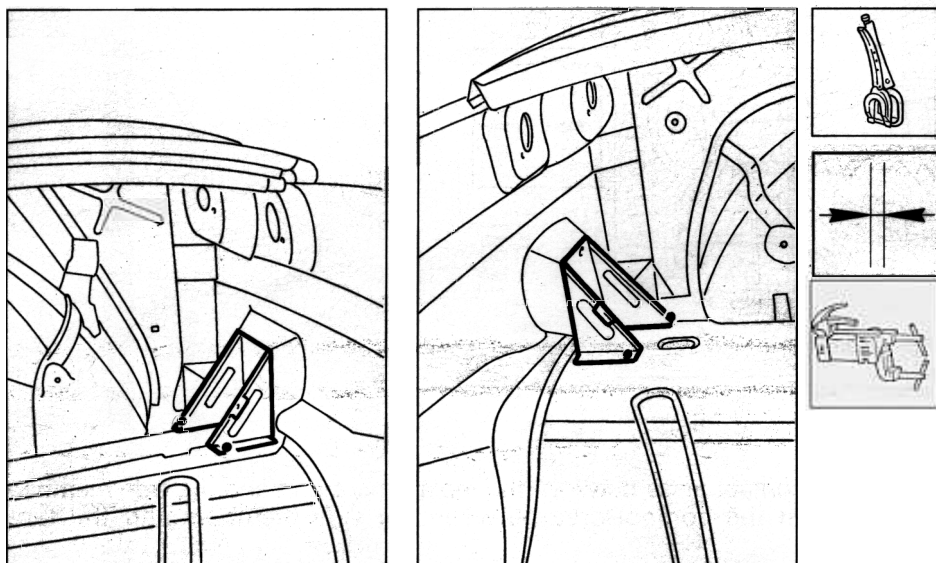


Continuous MIG welding

## 70.

### Positioning the rear bumper mounting bracket replacement part

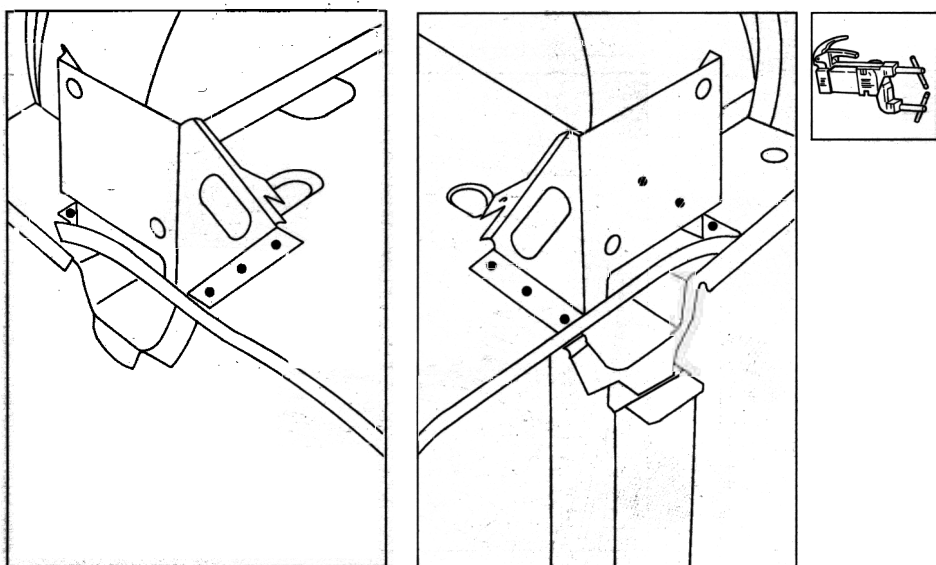
1. Carefully position the replacement parts on the rear floor panel by the two rear side members.
2. Check that it is correctly positioned temporarily fitting the cross member and checking that the openings in the bracket for fixing the bumper coincide with those in the rear cross member; the cross member should be aligned with the surrounding components (wheel arch, rear floor panel and rear wing).
3. Fix the brackets in the correct position using several spot welds, then remove the rear cross member to facilitate the complete welding.



P3W110M02

### Weldign rear bumper mounting bracket replacement parts

1. Carry out spot welding using a spot welder in the contact areas between the brackets and the rear floor panel.



P3W110M03

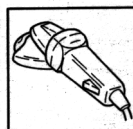
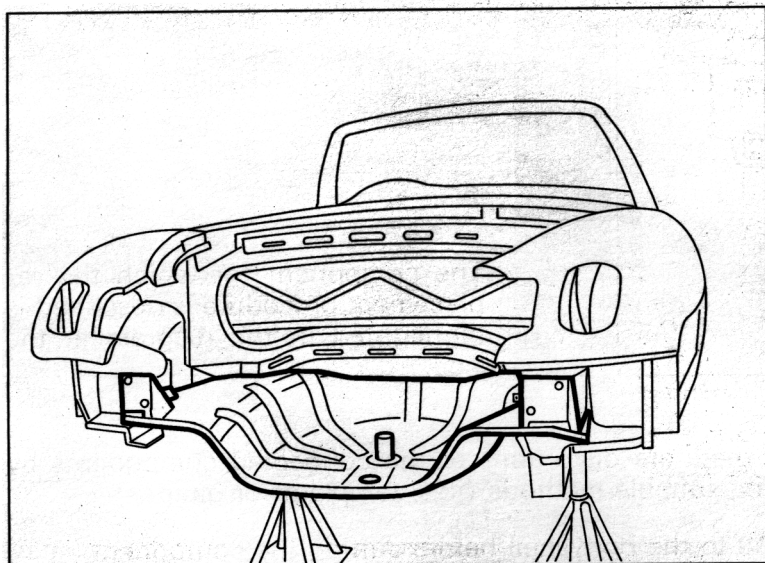
P3W110M04

● ● ● ● Spot welding



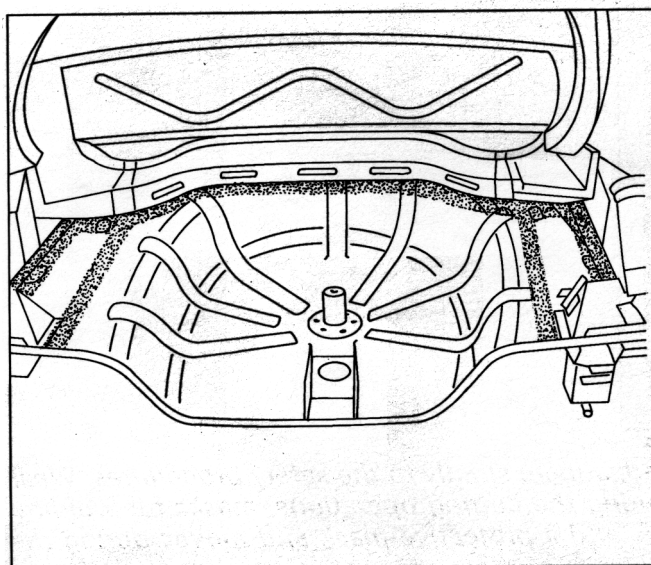
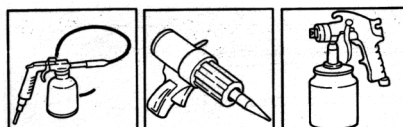
### Finishing operations

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

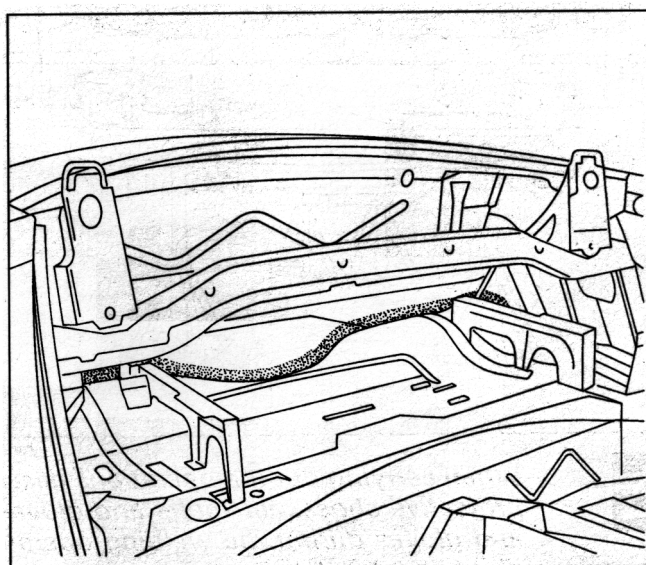


### Protections

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.

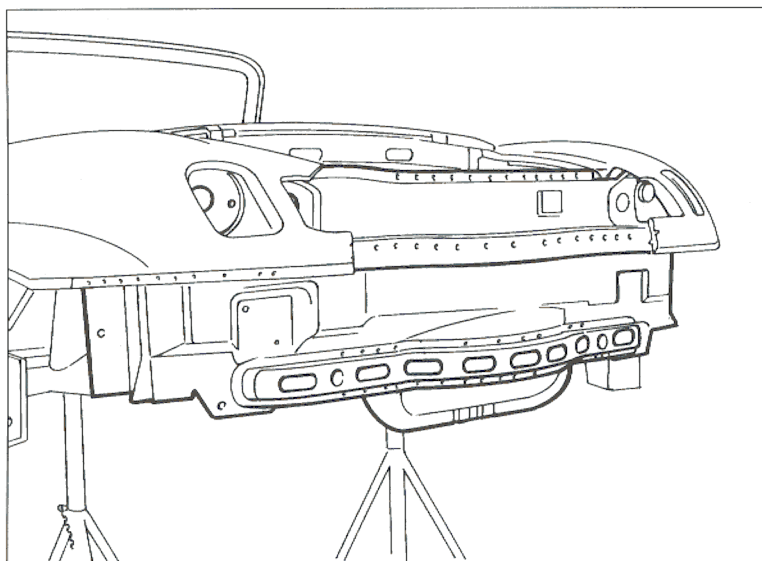


P3W111M01



P3W111M02

## 70.



P3W112M01

### REPLACING REAR 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.

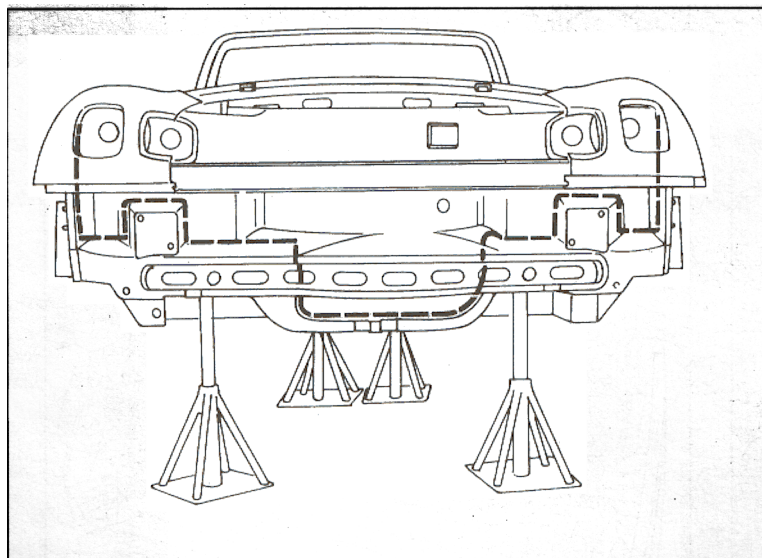
After this operation check that the components not being replaced are in tact.

#### Preliminary dismantling

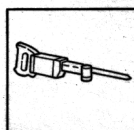
Remove the moveable parts of the bodywork and the electrical components which could impede the repair operations or be damaged during them. Also remove the outer rear cover complete with support.

#### Removing

Cut the rear cross member using a power saw following the dotted lines shown in the diagram below.



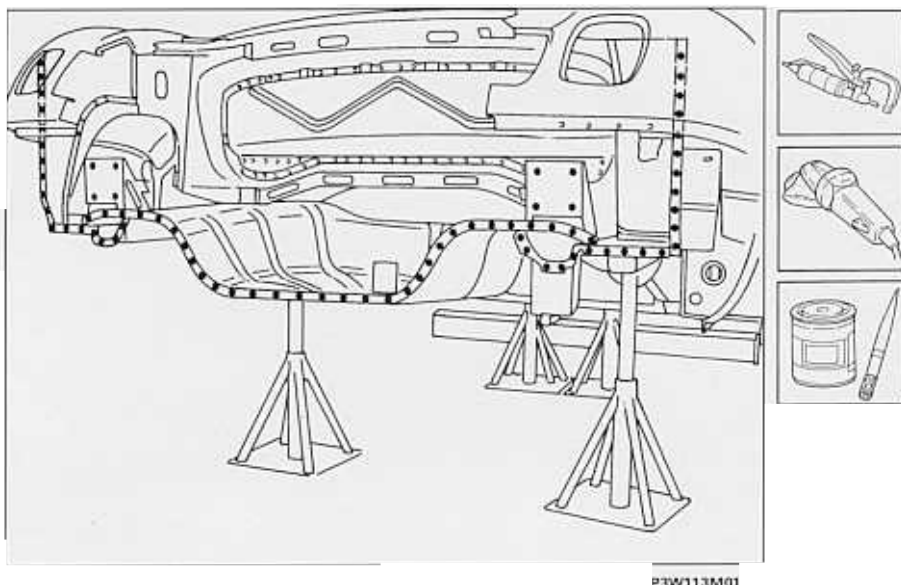
P3W112M02



*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.*

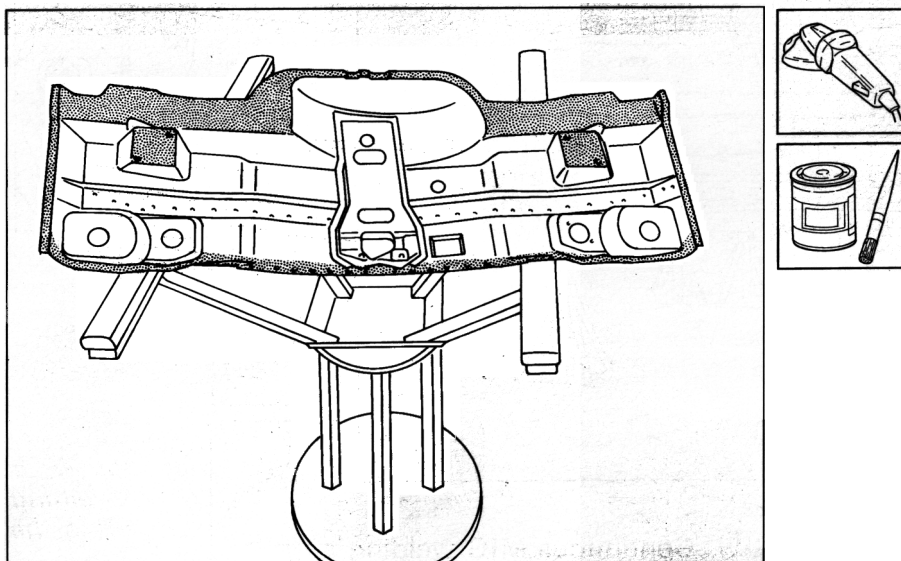
#### Removing off cuts and preparing edges of bodyshell

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.

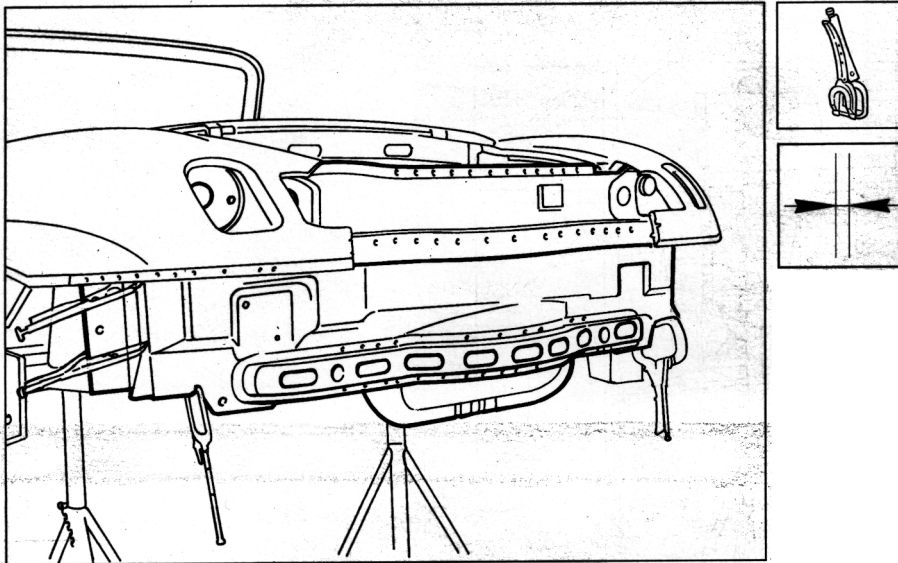




## 70.

### Positioning the replacement part

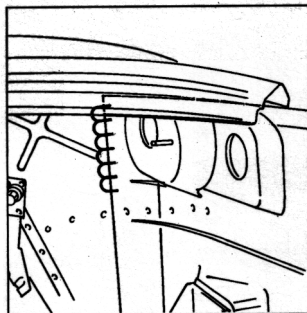
1. Carefully place the replacement part in position.
2. Fix the replacement part to the bodyshell using self-locking pliers
3. Check that it is correctly positioned checking the alignment and the uniformity of the opening with the wheel arch, the rear wings and the rear floor panel and check that the two fixing openings for the rear bumper correspond with the openings in the previously fixed brackets.



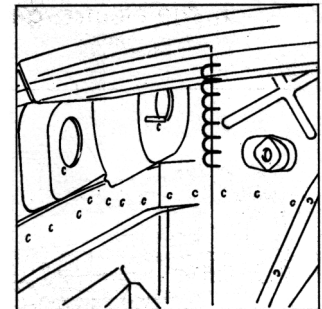
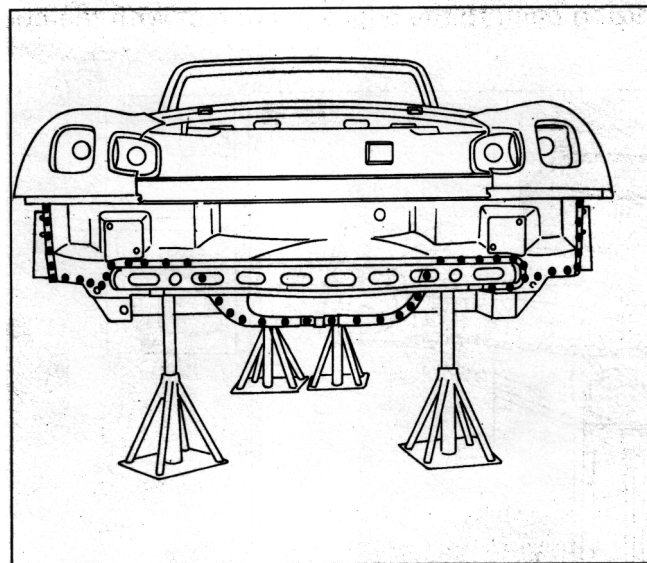
P3W114M01

### Welding the spare part

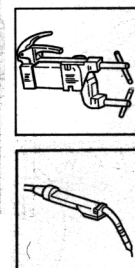
1. Spot weld, using a spot welder, along the area in contact with the rear floor panel, the two outer edges of the wheel arch and the two side members.
2. Carry out continuous MIG welding between the edges of the panel along the upper part of the cross member by the rear wings.



P3W114M03



P3W114M04



● ● ● ● Spot welding

~~~~~ Continuous MIG welding