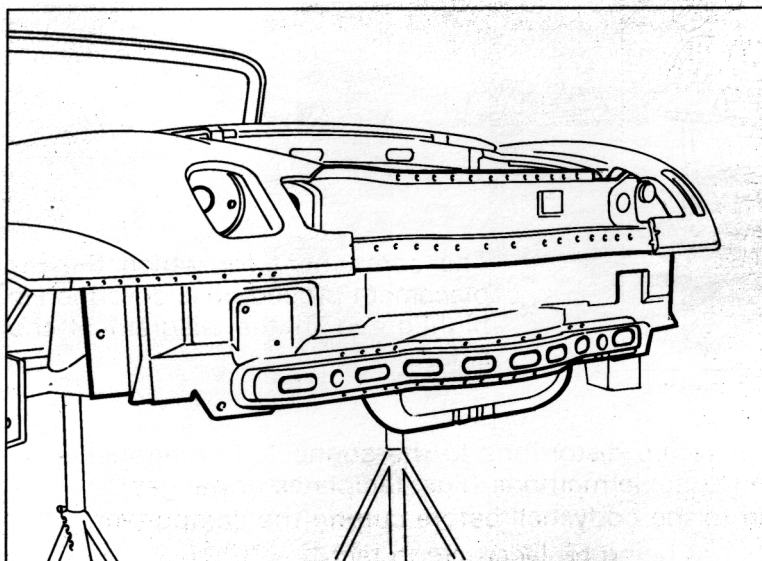


Finishing operations

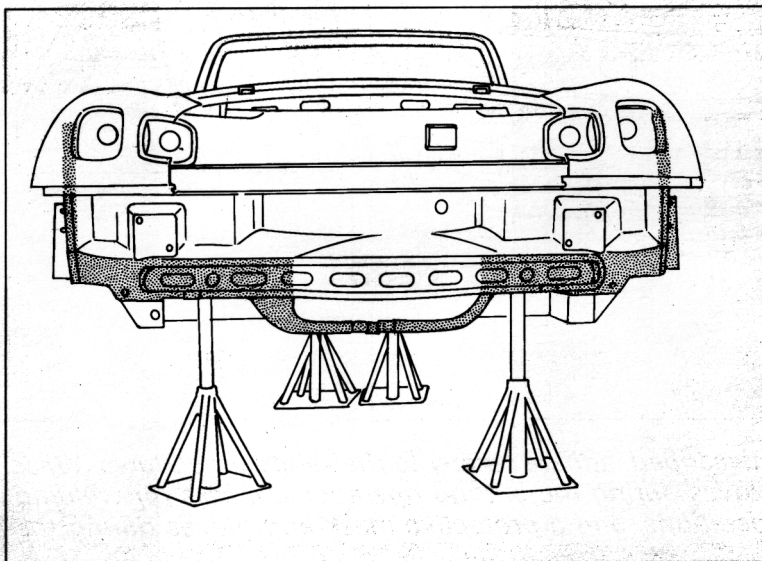
1. Correct any distortions to the panel using a hammer and dolly block.
2. Remove any weld slag using a disc grinder.



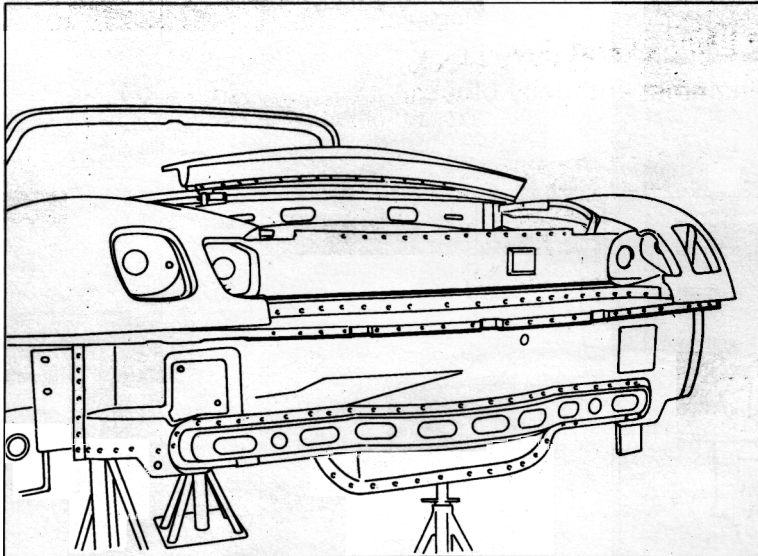
P3W112M01

Protections

1. Apply the electro-phoretic protective treatment to the areas previously welded.
2. Seal the joins 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.



P3W115M01



P3W116M01

REPLACING REAR COVER SUPPORT

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

Preliminary procedures

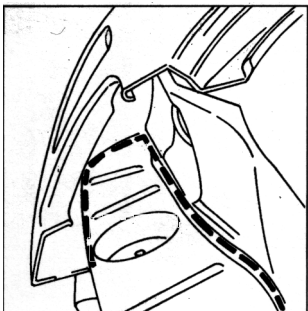
Establish the extent of the damage, check if there are distortions to the connected components by checking the bodyshell alignment figures, using suitable methods (jigs, templates or gauges). Carry out any straightening operations required to the bodyshell before cutting the component. After this operation check that the components not being replaced are in tact.

Preliminary dismantling

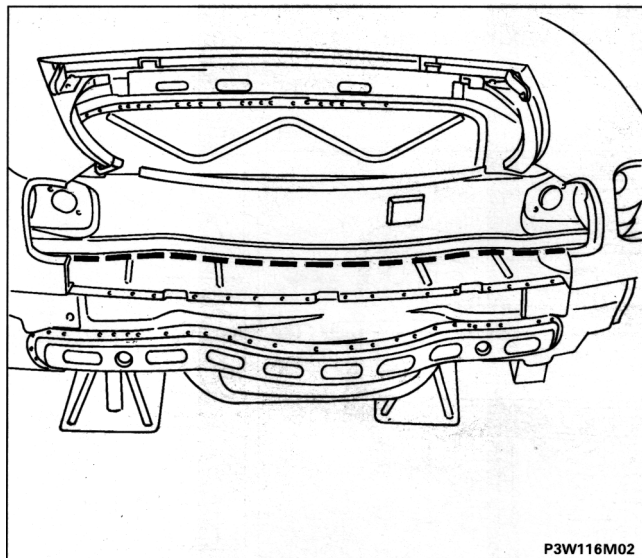
Remove the moveable parts of the bodywork and the electrical components which could impede the repair operations or be damaged during them. Also remove the outer rear cover.

Removing

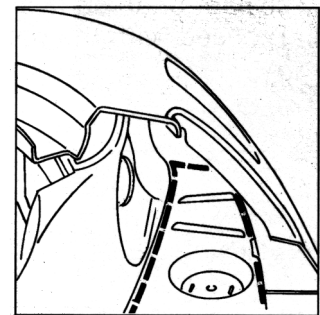
Cut the rear cover support using a power saw following the dotted lines shown in the diagrams below.



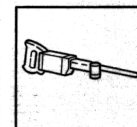
P3W116M03



P3W116M02



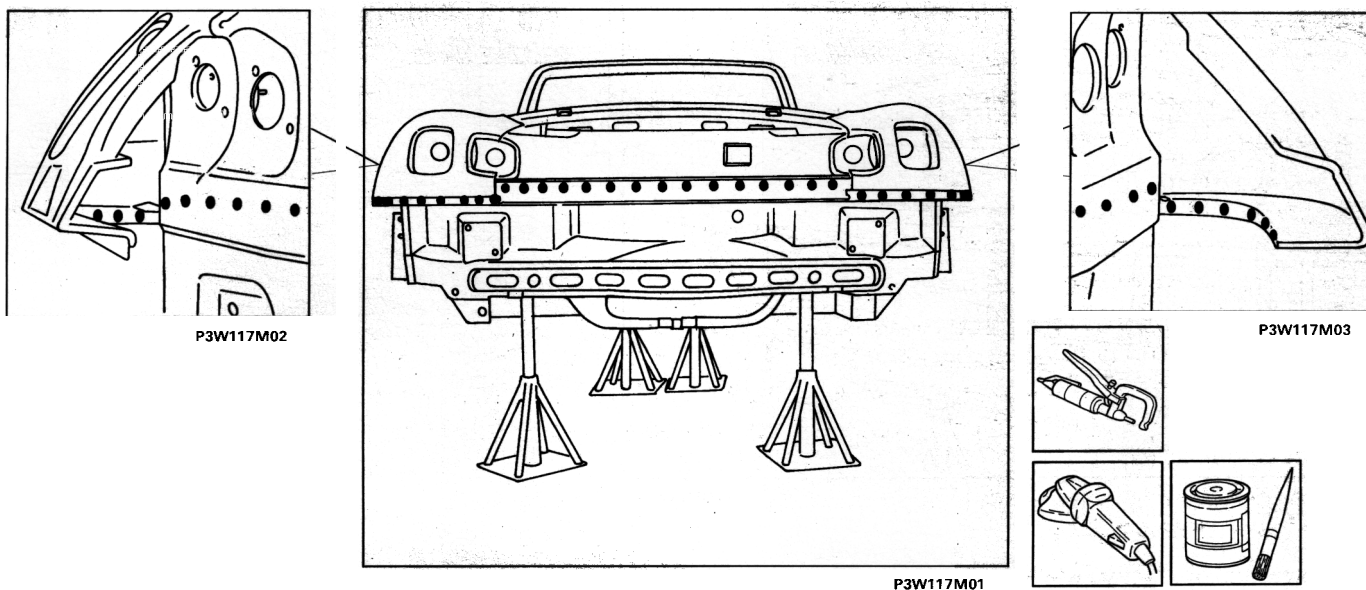
P3W116M04



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.

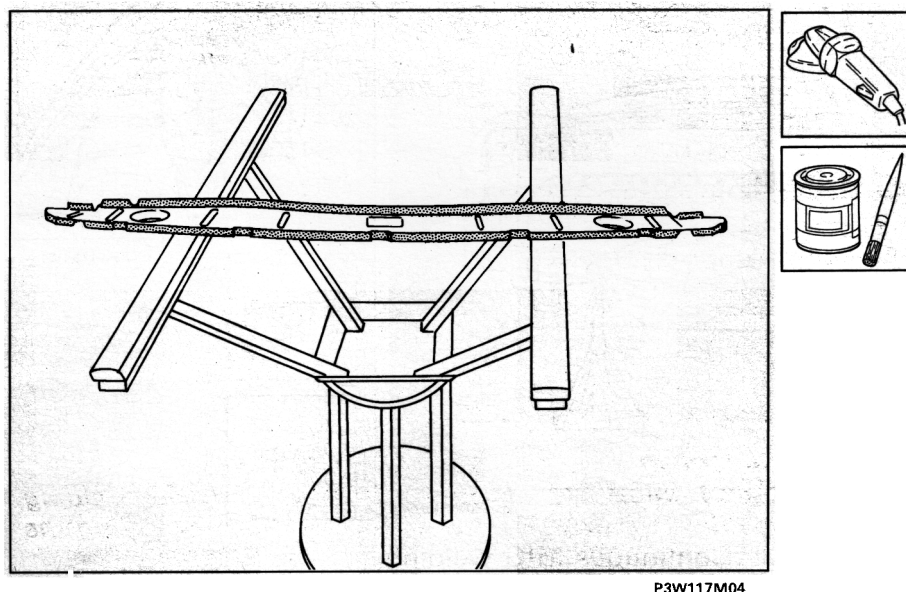
Removing off cuts and preparing edges of bodyshell

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.



Bodywork

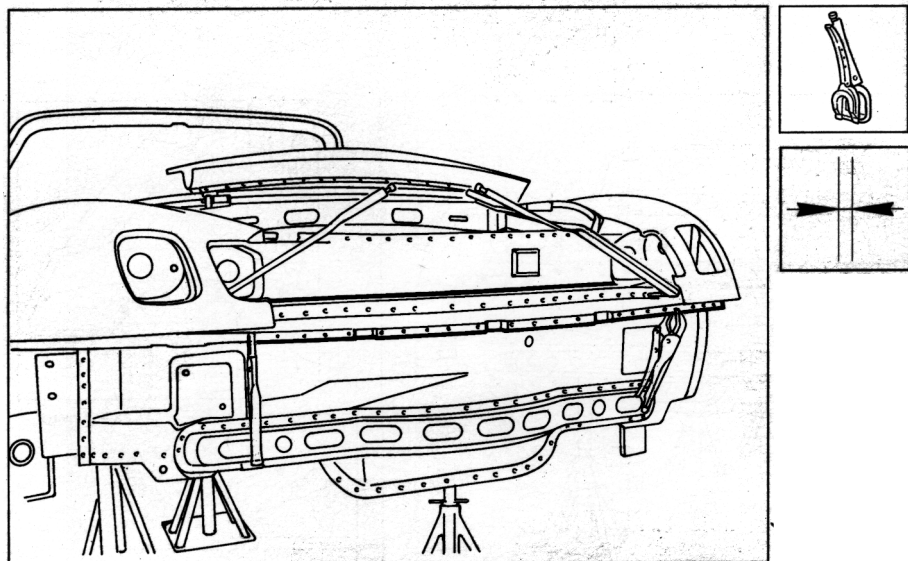
Replacing body panels

70.

Fiat barchetta

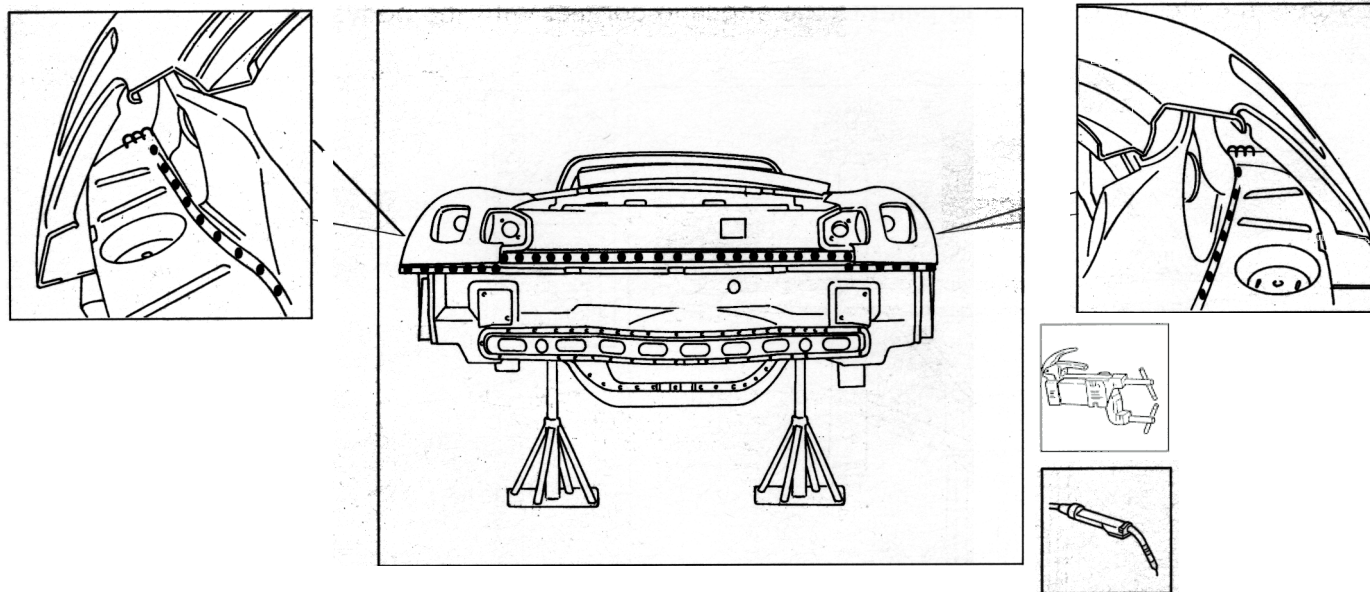
Positioning the replacement part

1. Carefully place the replacement part in position.
2. Fix the replacement part to the bodysell using self-locking pliers.
3. Check that it is correctly positioned in relation to the left and right rear wings.



Welding the spare part

1. Carry out spot welding using a spot welder in the contact area between the cover support and the rear cross member and the edges of the left and right rear wings.
2. Carry out continuous MIG welding at the two edges of the replacement part in the contact area with the rear wings.



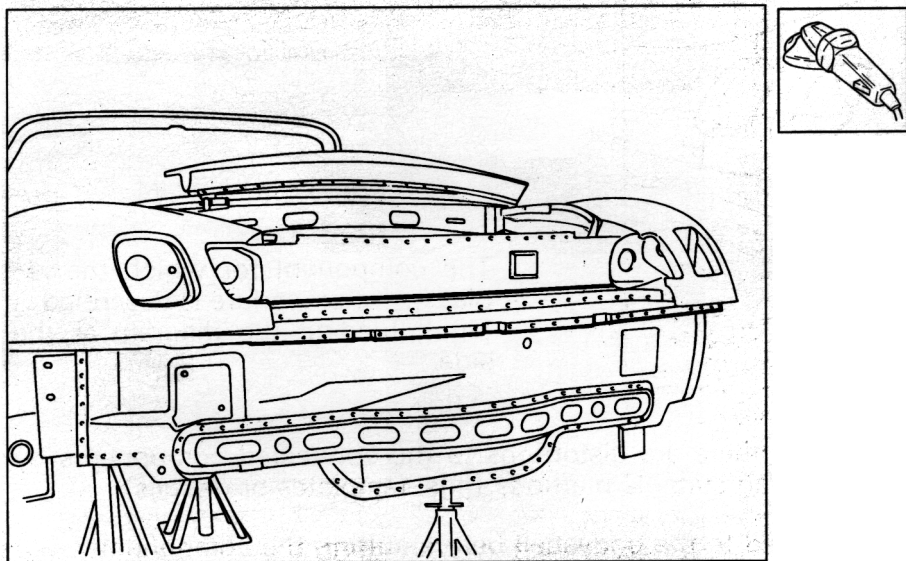
● ● ● ● Spot welding

~~~~~ Continuous MIG welding



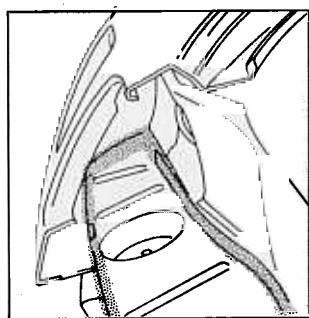
#### Finishing operations

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

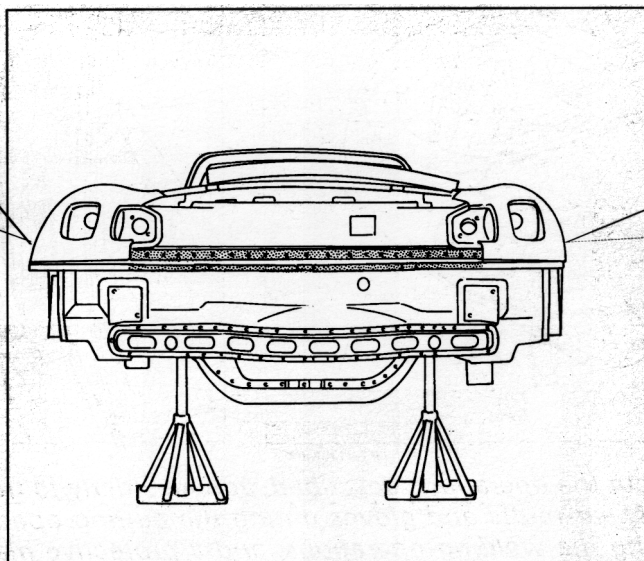


#### Protections

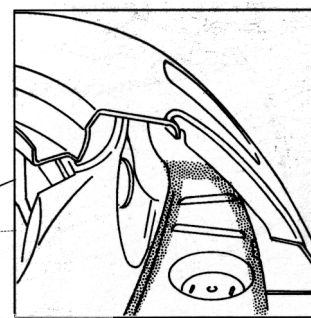
1. Apply the electro-phoretic protective treatment to the reas previously welded.
2. Seal the joints between the replacement part and the bodyshell using IVI 854210 transparent acrylic sealant or an equivalent product.
3. Proceed with the painting and waxing stage.



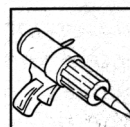
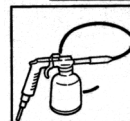
P3W119M02

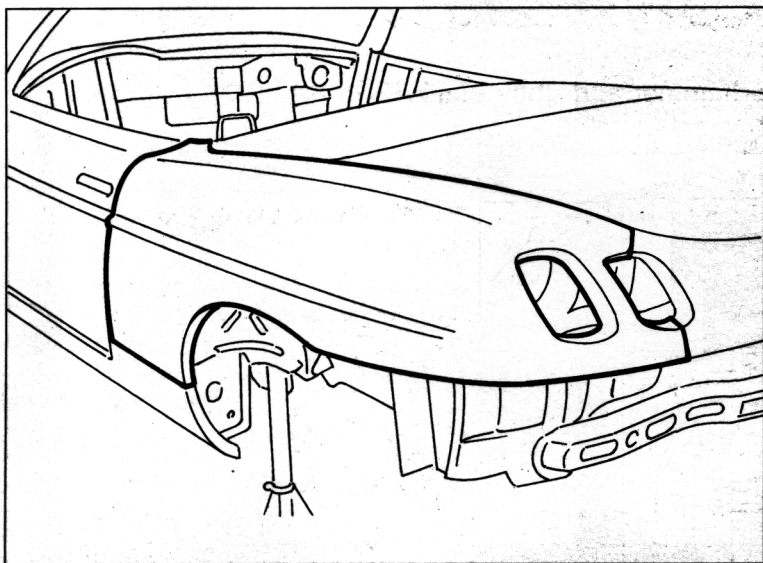


P3W119M01



P3W119M03





#### REPLACING REAR WING

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.

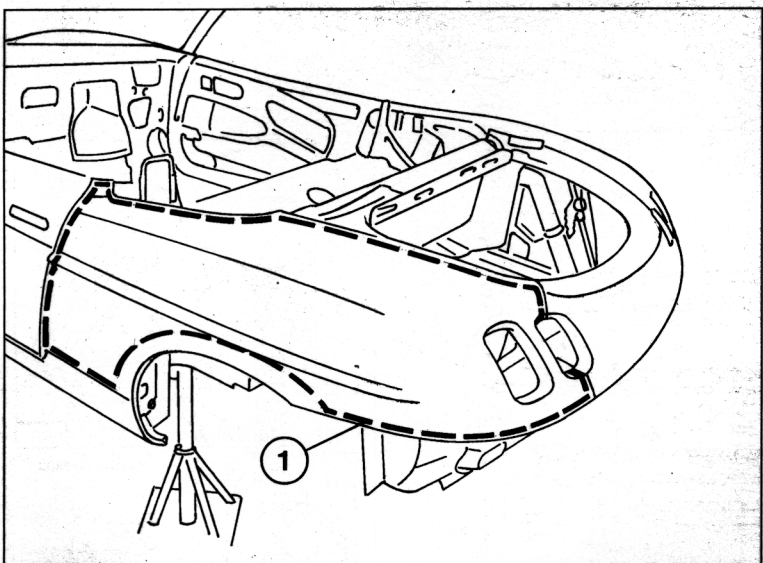
After this operation check that the components not being replaced are in tact.

#### Preliminary dismantling

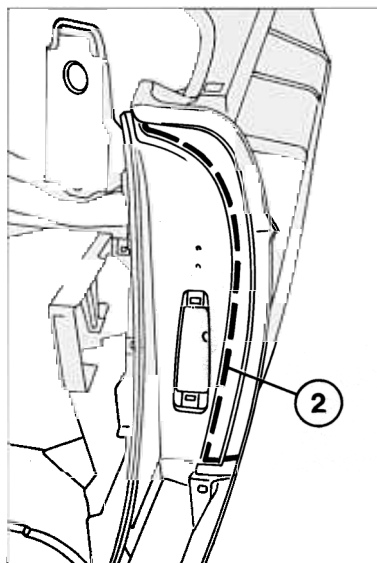
Remove the moveable parts of the bodywork and the electrical components which could impede the repair operations or be damaged during them.

#### Removing

1. Cut the rear wing using a power saw following the dotted lines (1), and using a hammer and chisel along the dotted lines (2) taking care not to damage the reinforcements underneath.



P3W120M02



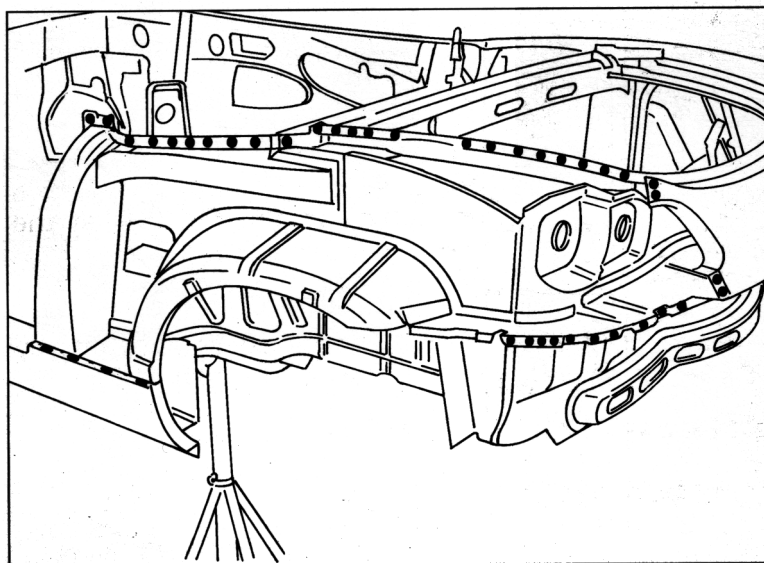
P3W120M03



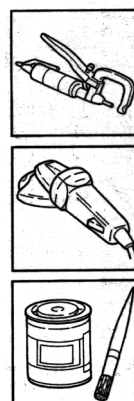
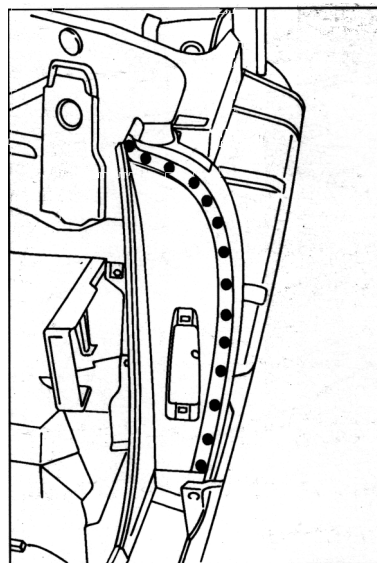
*When carrying out the operations described, adhere strictly to the safety procedures. Wear protective shoes, ear-muffs and gloves during the cutting operations, masks for welding and gloves during the welding operations, and a protective mask and gloves during the painting operations.*

#### 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.

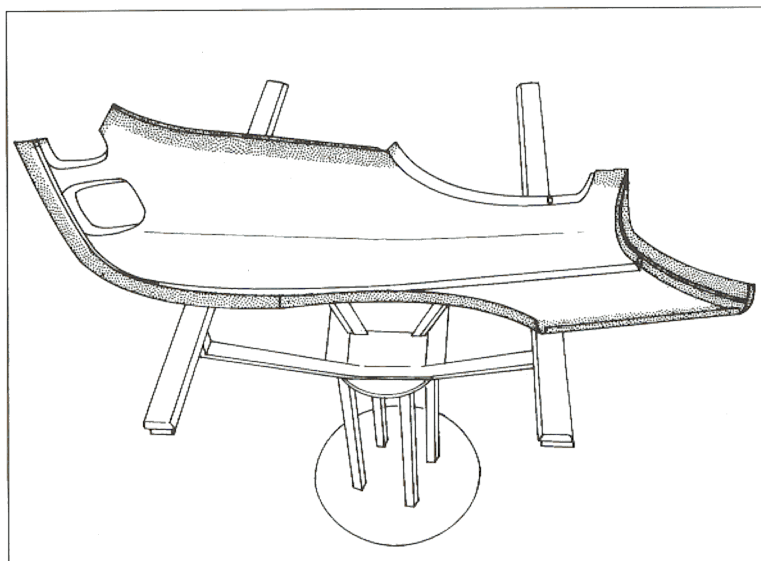


P3W121 M01

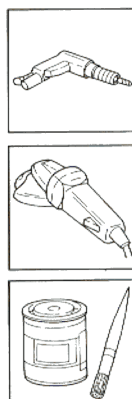


#### Preparing the spare part

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.



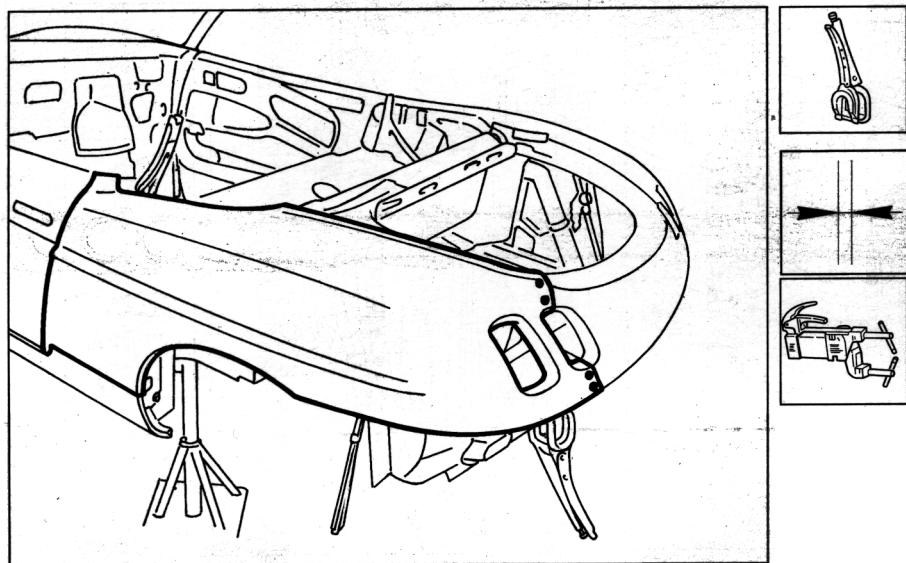
P3W121 M03



## 70.

### Positioning the replacement part

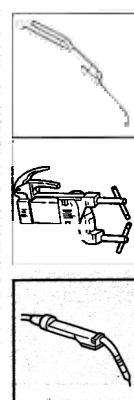
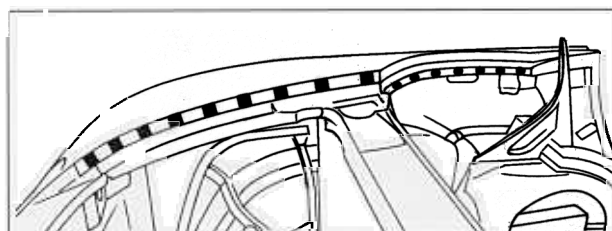
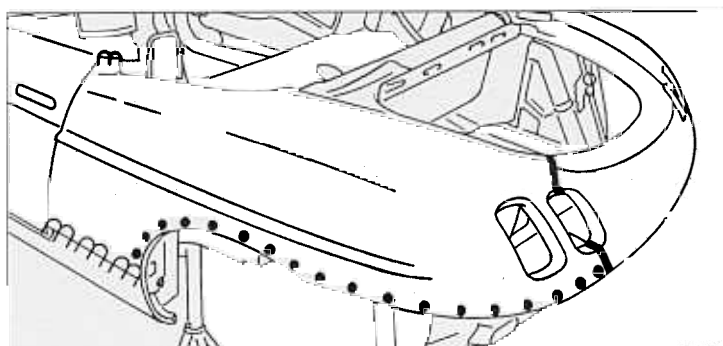
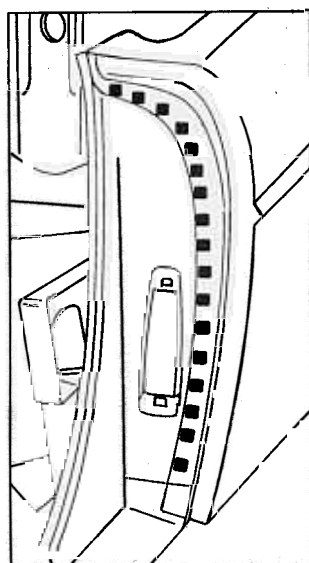
1. Carefully place the replacement part in position.
2. Fix the replacement part to the bodyshell using self-locking pliers and several spot welds as illustrated in the diagram.
3. Temporarily position the boot lid and the hood compartment cover, check that they are correctly positioned checking the alignment and the uniformity of the opening with the door, the hood compartment lid, the rear cover, the underdoor side member and the boot lid, then remove the previously positioned components and proceed with welding the replacement part.



P3W122M01

### Welding the spare part

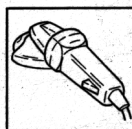
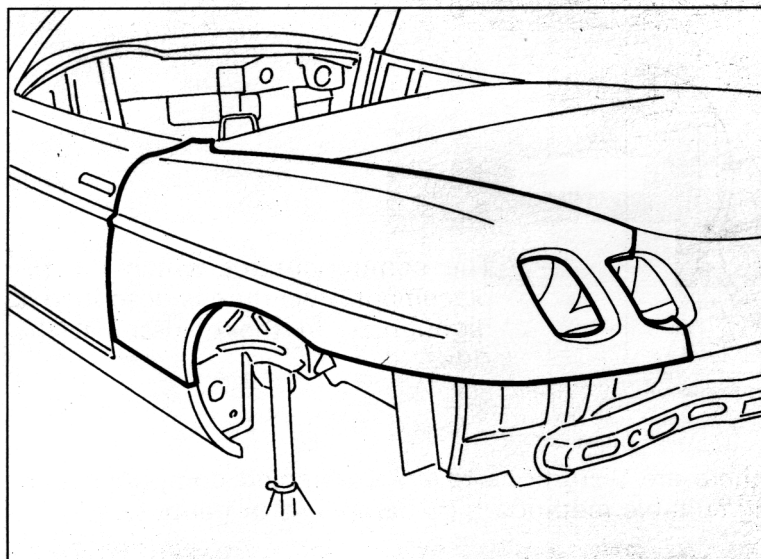
1. Carry out brass welding using an oxy-acetylene canister by the areas which are joined with the rear cover.
2. Carry out spot welding using a spot welder by the area in contact with the luggage compartment, the rear cover support and the rear wheel arch.
3. Carry out MIG welding for filling by the area in contact with the luggage compartment.
4. Carry out continuous MIG welding by the area in contact with the pillar and the underdoor side member.





#### Finishing operations

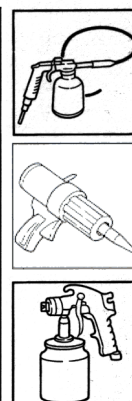
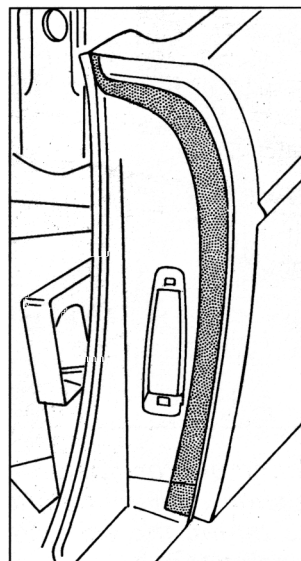
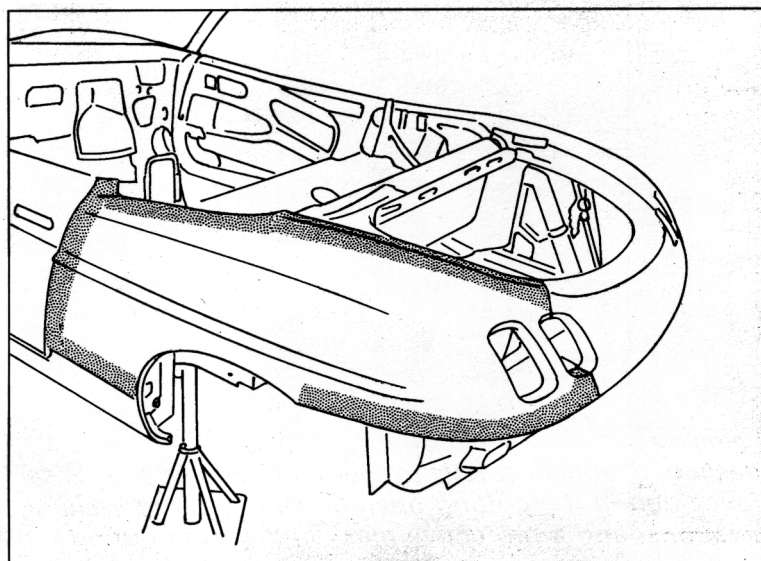
1. Correct any distortions to the panel using a hammer and dolly block.
2. Remove any weld slag using a disc grinder.



P3W120M01

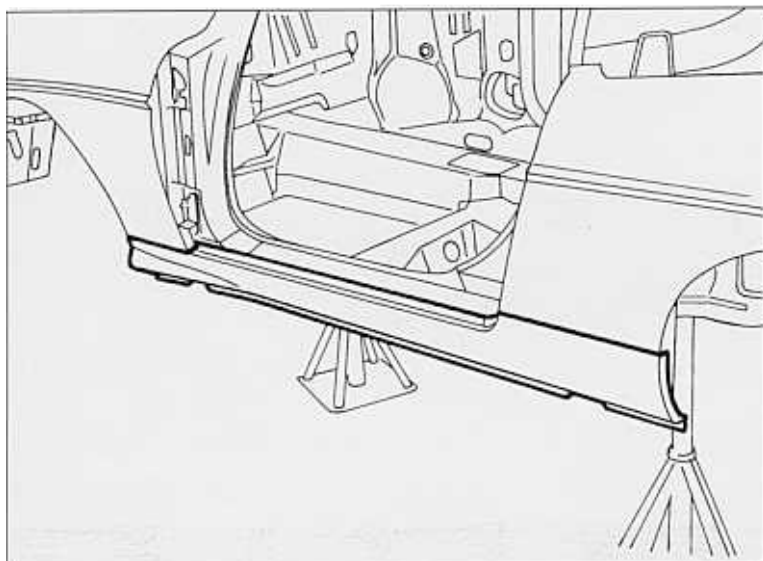
#### Protections

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.



P3W123M01

### 70.



#### REPLACING UNDERDOOR SIDE 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 bodysell alignment figures, using suitable methods (jigs, templates or gauges).

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

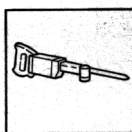
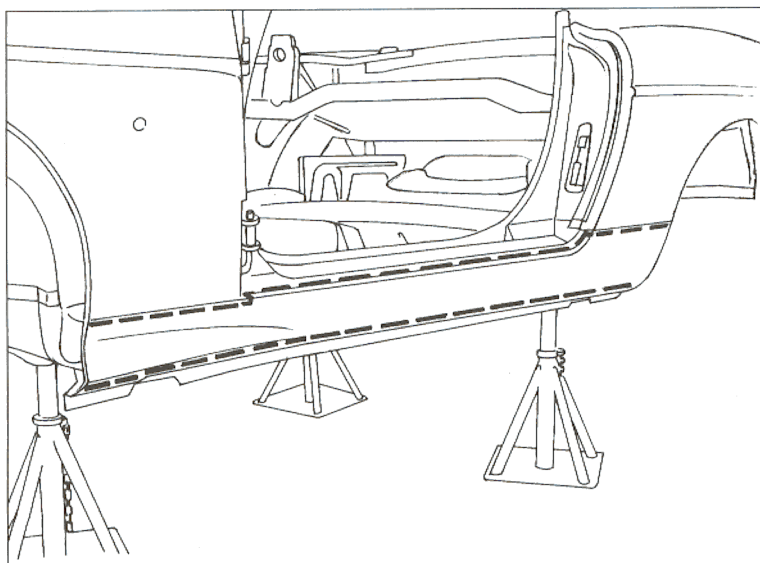
After this operation check that the components not being replaced are in tact.

#### Preliminary dismantling

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

#### Removing

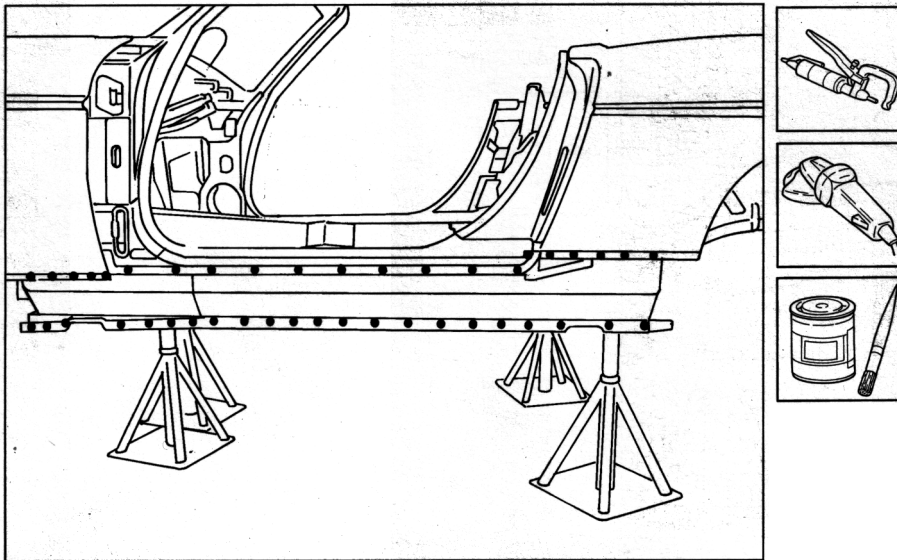
Cut the underdoor side member using a power saw following the dotted line in the diagram below.



*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

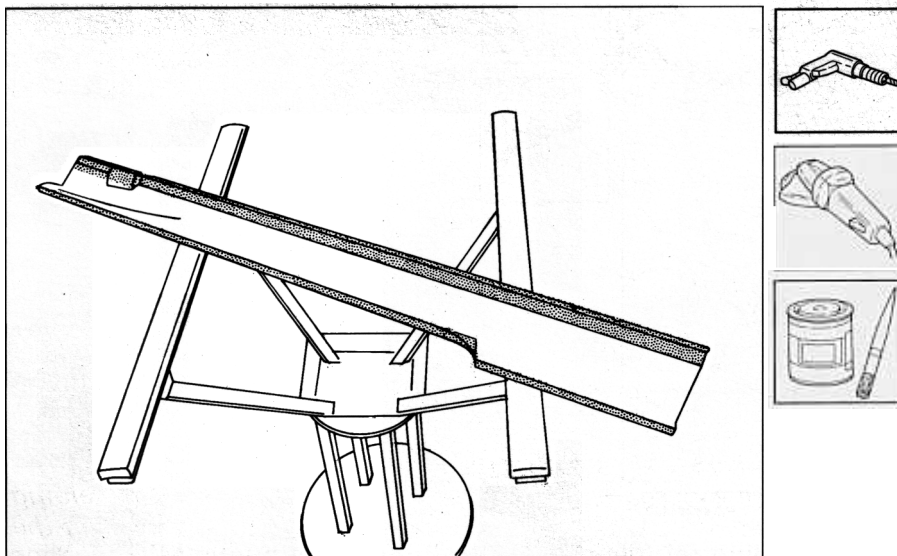
1. Remove the weld points in the areas illustrated in the diagram, using a special cutter.
2. Remove the metal off cuts using pliers.
3. Straighten the edges with a hammer and dolly block.
4. Remove the spot weld residues using a disc grinder.
5. Apply the electro-galvanizing paint or an equivalent product,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



P3W125M01

### Preparing the spare part

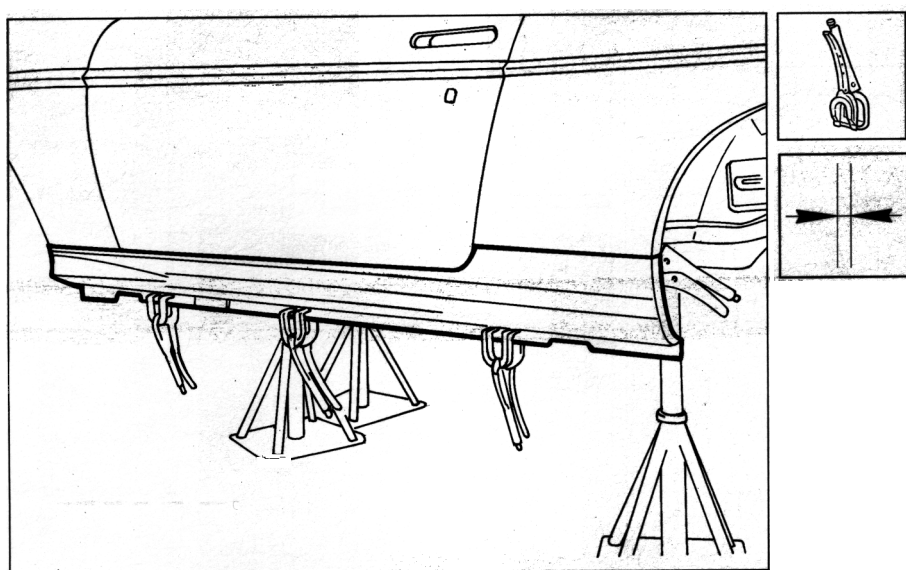
1. Remove the anti-corrosion treatment from the entire perimeter of the inside and the outside of the replacement part using a disc grinder.
2. Apply the electro-galvanizing paint to the edges in contact with the bodyshell.



P3W125M02

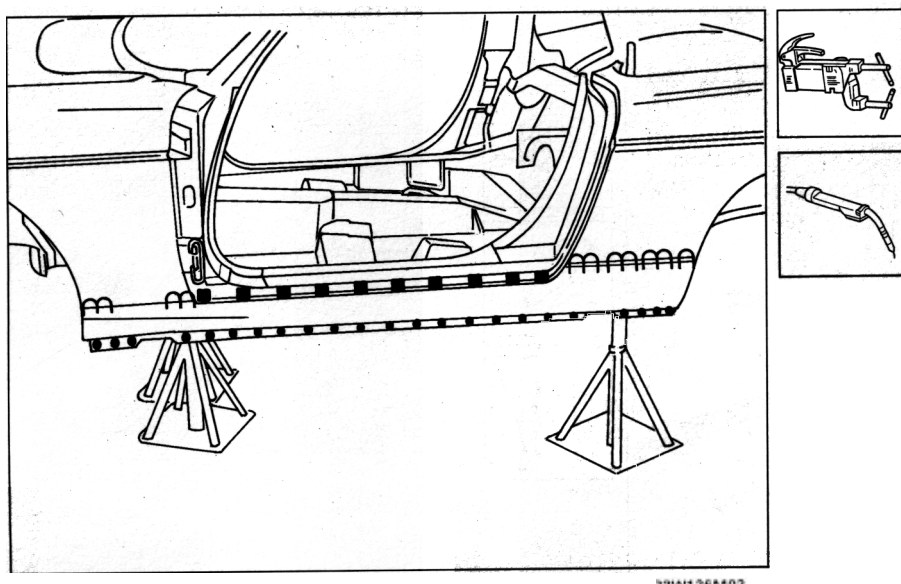
### Positioning the replacement part

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 door, the front wing and with the rear wing.



### Welding the spare part

1. Carry out spot welding using a spot welder along the lower part in contact with the underdoor panel.
2. Carry out MIG welding for filling along the upper part in contact with the underdoor panel.
3. Carry out continuous MIG welding along the areas in contact with the rear wing and with the edges of the front wing.



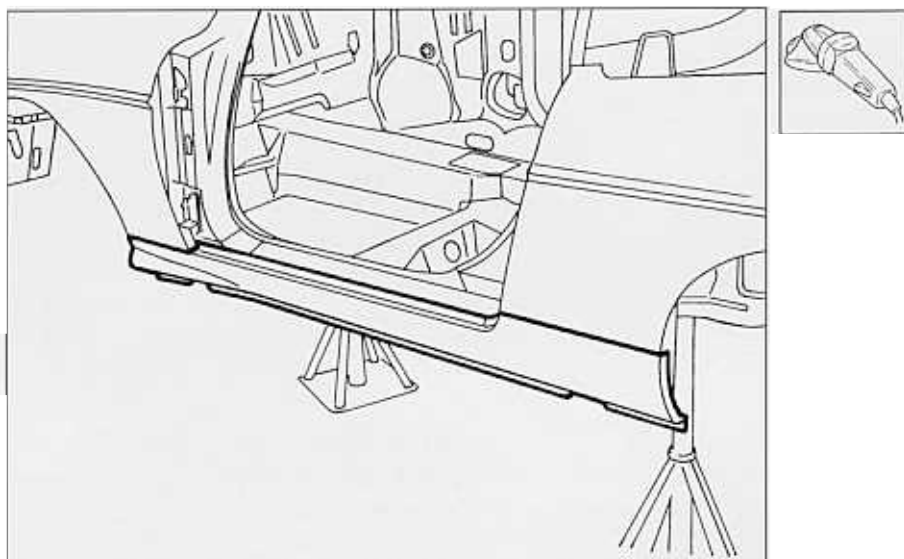
●●●● Spot welding

■■■■ MIG welding for filling

~~~~~ Continuous MIG welding

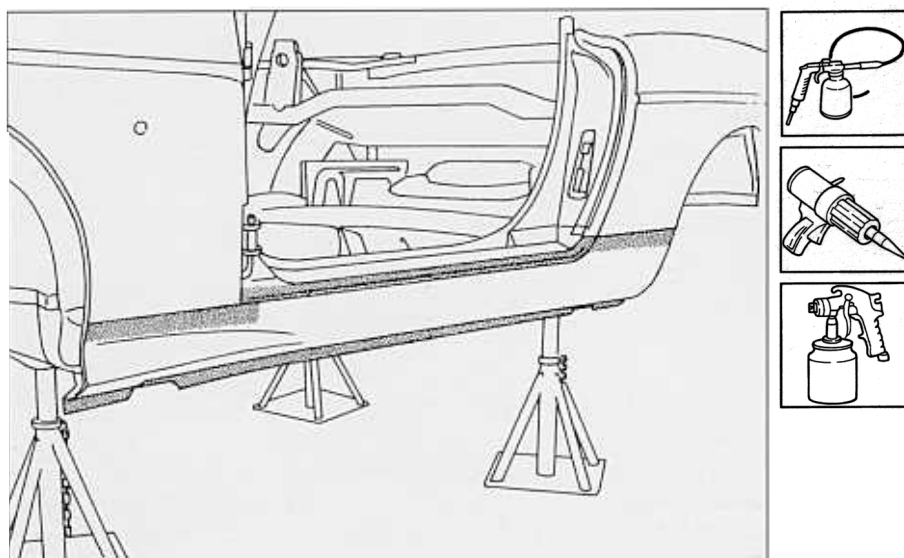

Finishing operations

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



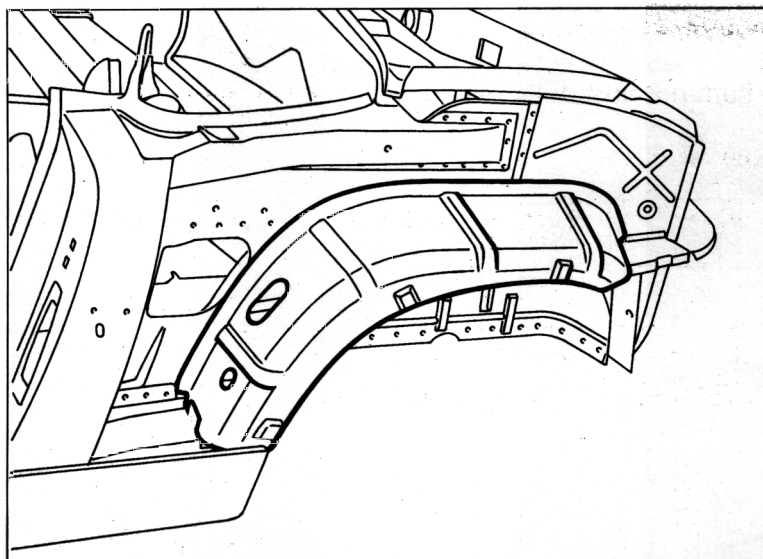
Protections

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.



P3W127M01

70.



P3W128M01

REPLACING REAR WHEEL ARCH

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.

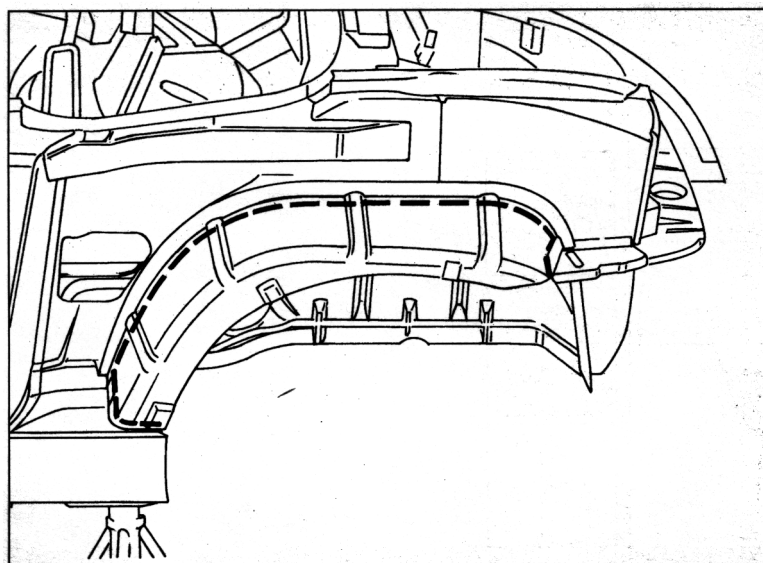
After this operation check that the components not being replaced are in tact.

Preliminary dismantling

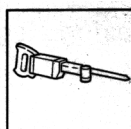
Remove the moveable parts of the bodywork and the electrical components which could impede the repair operations or be damaged during them. Also remove the rear wing as described previously.

Removing

Cut the rear wheel arch using a power saw following the dotted lines shown in the diagram below.



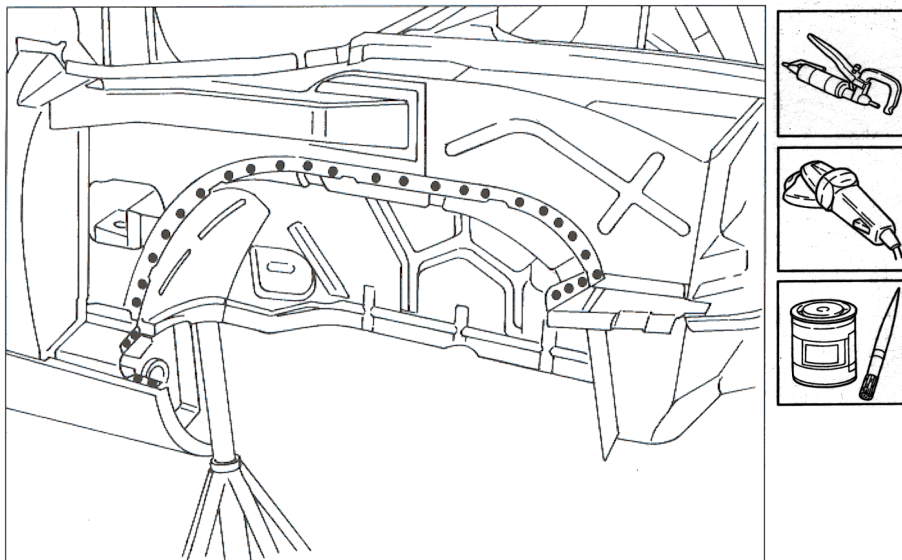
P3W128M02



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

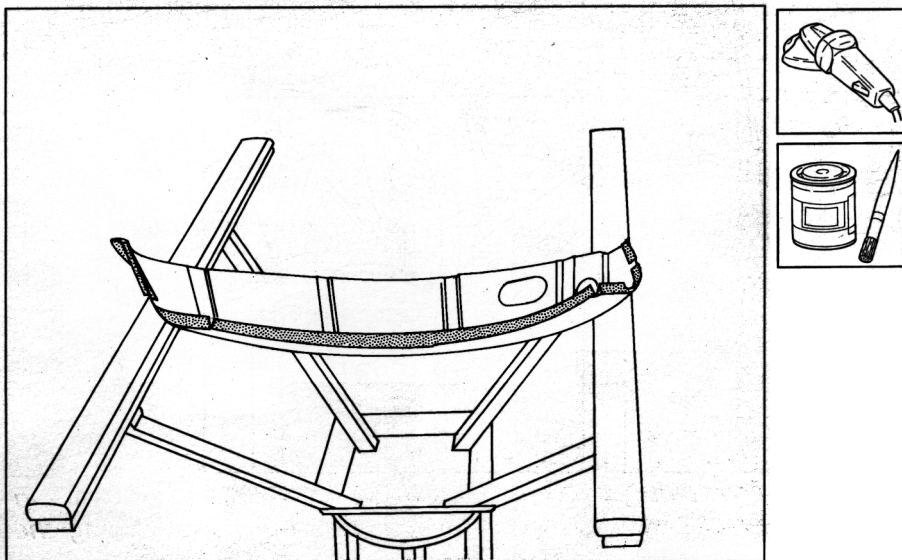
1. Remove the weld points in the areas illustrated in the diagram, using a special cutter.
2. Remove the metal off cuts using pliers.
3. Straighten the edges with a hammer and dolly block.
4. Remove the spot weld residues using a disc grinder.
5. Apply the electro-galvanizing paint or an equivalent product,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



P3W129M01

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.

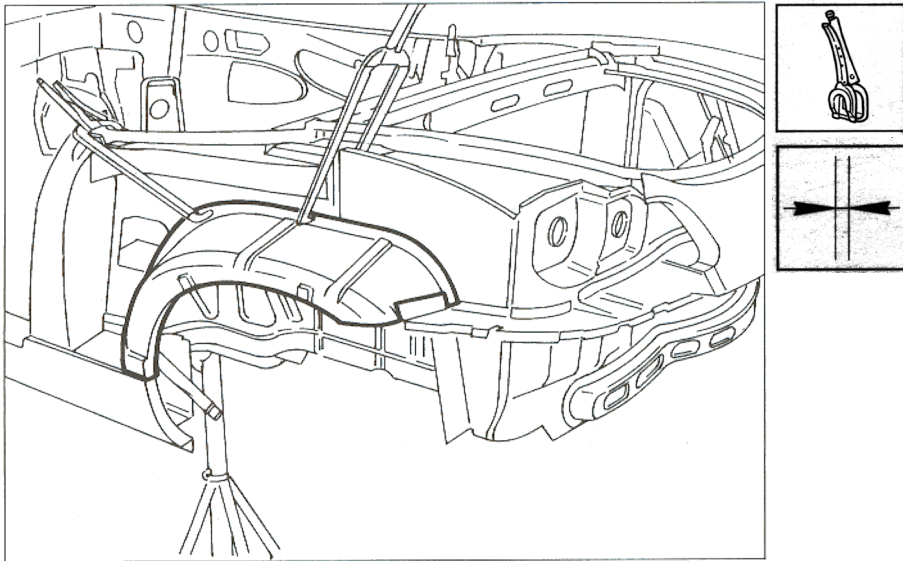


P3W129M02

70.

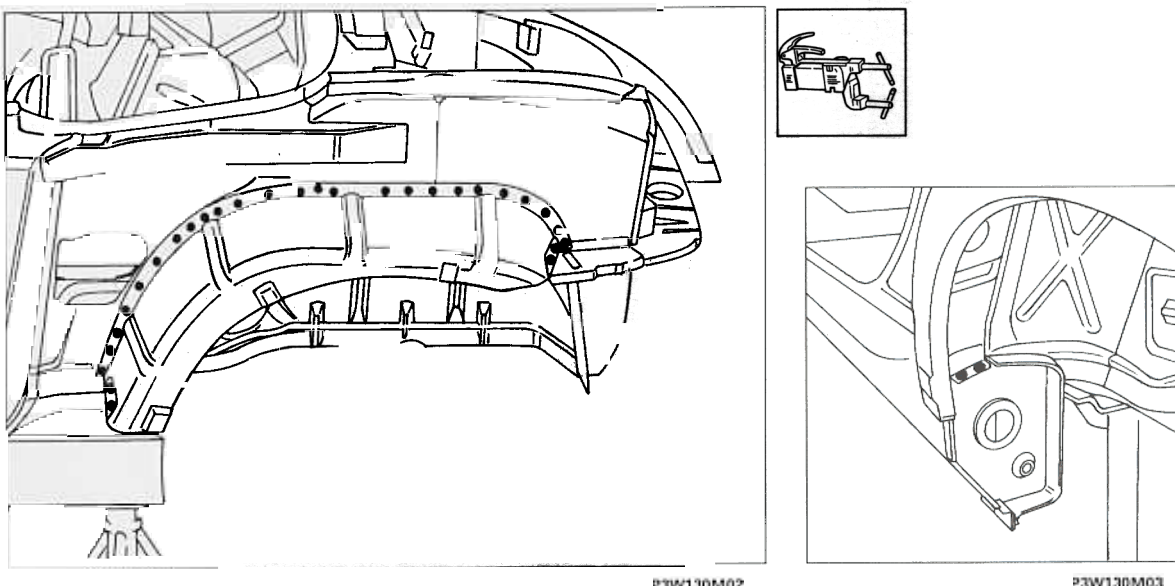
Positioning the replacement part

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



Welding the spare part

Carry out spot welding, using a spot welder, along the entire areas in contact with the bodyshell.



01W110M02

P3W130M01

● ● ● ● Spot welding