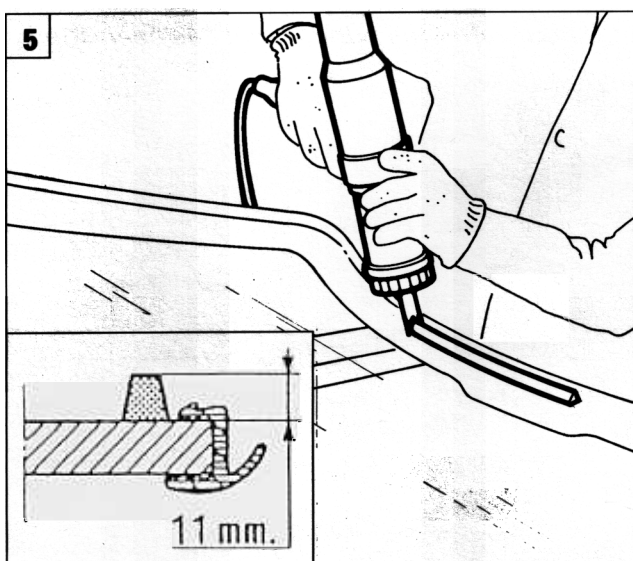
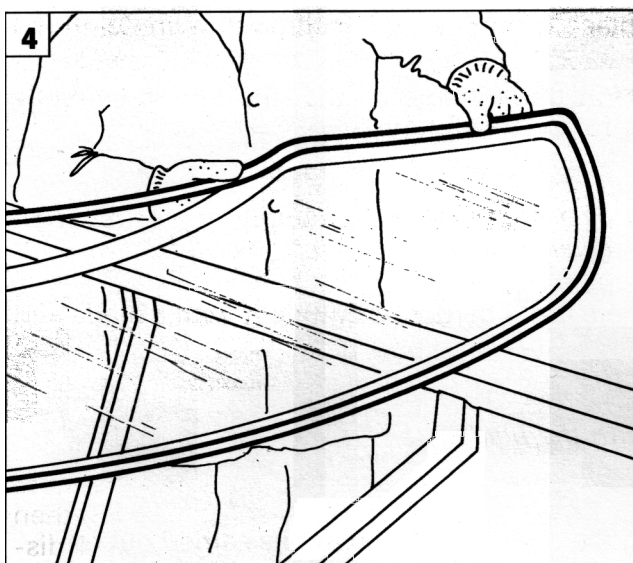


P3W047M03



1. After levelling the sealant, the serigraphed area of the windscreen must be completely degreased using heptane and disposable paper.

2-3. Clean the serigraphed area using a wad of paper soaked in de-greasing adhesion promoter. Using a special pad, apply the adhesion promoter taking care not to go outside of the serigraphed area.

**NOTE** Leave the adhesion promoter to dry at ambient temperature for at least 15 minutes and not longer than 24 hours.

4. Fit the seal along the perimeter of the window, avoiding touching the area previously treated with your hands.

5. Using a spray gun, apply the sealant on the front windscreen.

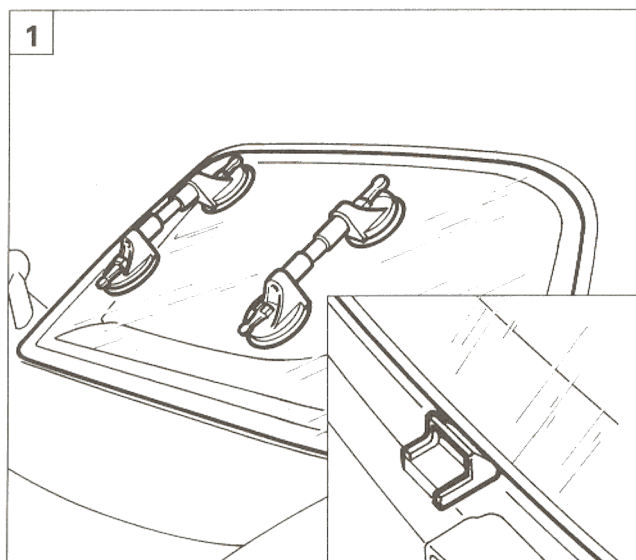
**NOTE** Cut the plastic tapered nozzle for applying the sealant so that the sealant coming out is of the dimensions shown in the inset.



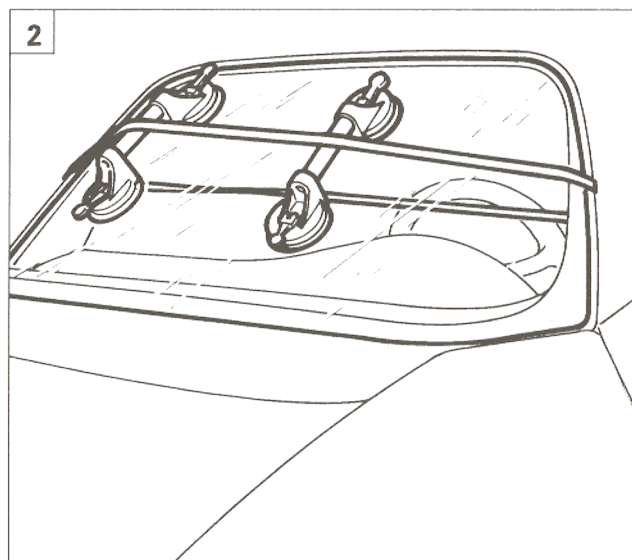
The bead of adhesive should not be either too large or too small and it should be even, in addition the end section should meet up with the beginning thereby forming a seal; any unevenness can be corrected using the container as appropriate.

Position the windscreen on the vehicle no more than 10 minutes after applying the sealant.

## 70.



P3W048/M01-02



P3W048/M03

1. Straight after applying the sealant fit the window in place taking care to position it in line with the lower reference blocks shown in the inset.
2. Using suitable belts and shims, exert slight pressure on the window so that the trim is correctly aligned with the pillars. Keep the glass under pressure for at least 6 hours.

**NOTE** *During this period it is possible to let water run over the window to identify any penetration points and accelerate the polymerization of the sealant.*

Remove any excess sealant on the inside of the pillars where it has hardened cutting it with a blade and removing it with pliers.



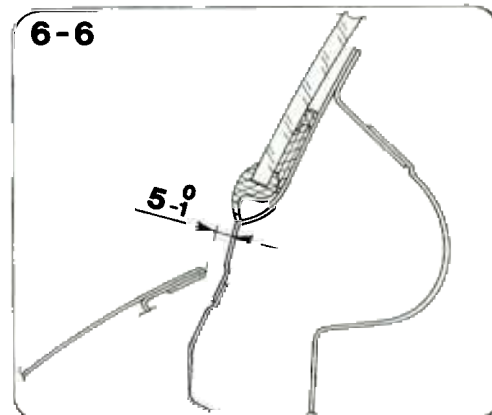
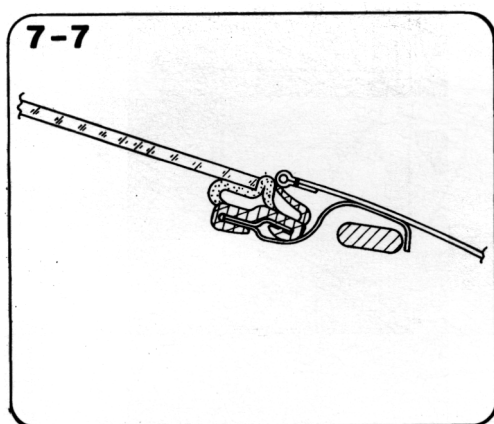
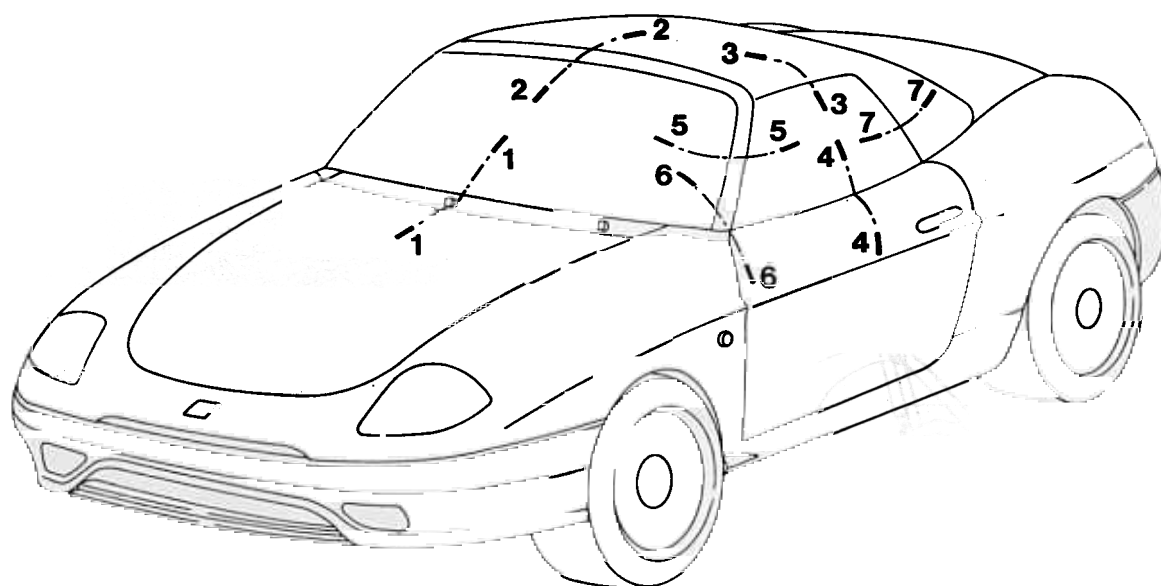
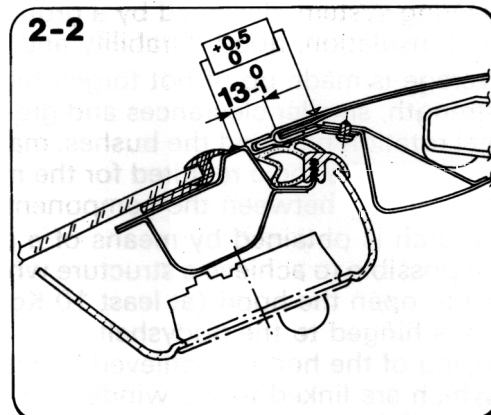
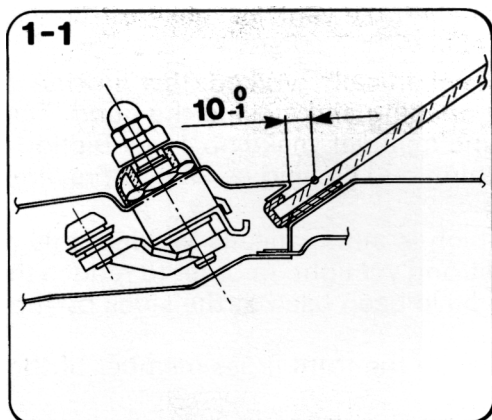
*Take care not to damage the serigraphed area with the blade.*

Complete the refitting of the elements removed, reversing the order of the operations carried out for the removal, then clean the window.

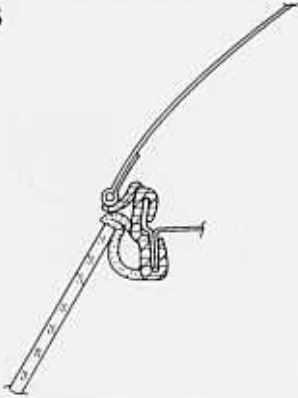


*The vehicle should not be handed over for at least 20 hours after the windscreen has been stuck.*

The following diagram shows the main sections and fitting clearances between the windscreen and the trims and between the side windows and the hood.

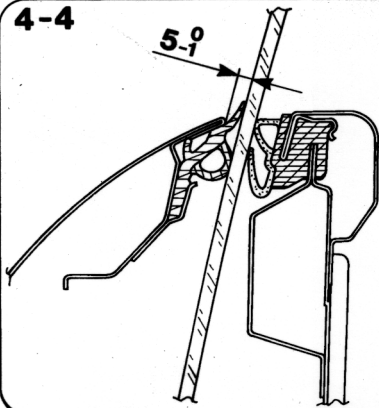


3-3

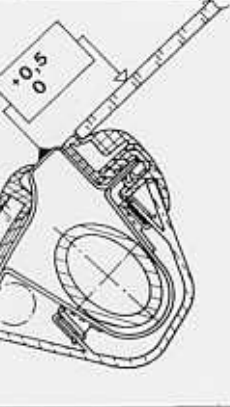


4-4

5-0



5-5





#### The hood

The hood, a distinctive element of the Fiat Spider, is made by superimposing a PVC covered cloth which integrates the rear windscreen made from metal acrylate with a steel frame made up of an arch and a series of ribs and levers.

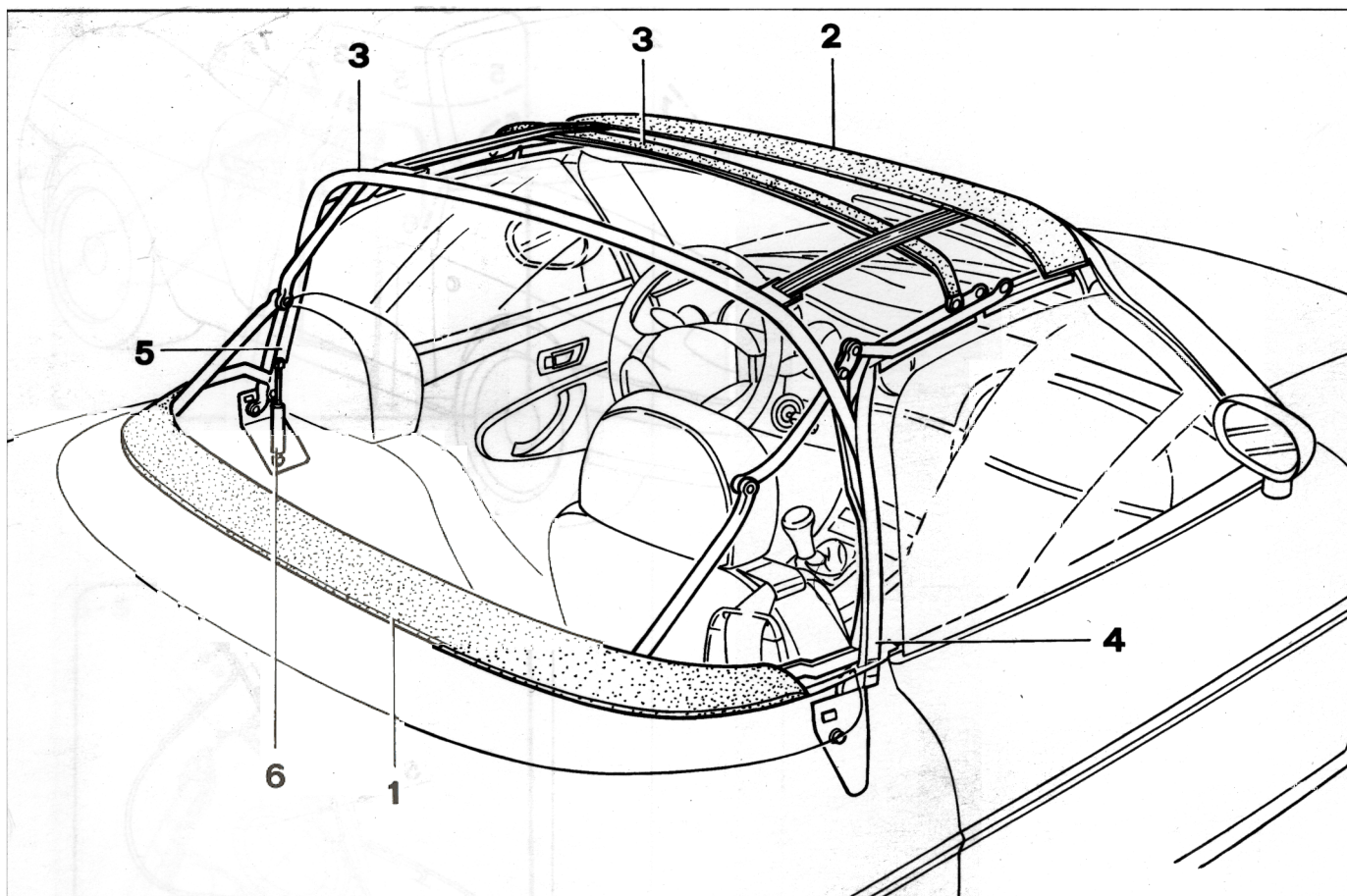
The covering system, designed by a group of specialists in convertible vehicles, ensures the maximum degree of insulation, good durability and ease of manoeuvrability.

The leverage is made up of hot forged brackets which are mechanically worked: this process ensures great strength, smaller clearances and greater stability when opening and closing the hood. The stainless steel rotation pins and the bushes, made from a compound material, make up a low friction system which reduces the force required for the manoeuvres of opening and closing as well as preventing the formation of rust between the components.

The rear arch is obtained by means of a panel with bars which is automatically welded; this process makes it possible to achieve a structure which is particularly strong yet light. In order to reduce the force required to open the hood (at least 10 Kg) two gas springs have been used at the sides by the points where it is hinged to the bodyshell.

The closing of the hood is achieved by means of two handles on the front cross member of the actual hood which are linked to the windscreen cross member.

The shape of the arch and the fabric tensioning arms has made it possible to eliminate the tiresome phenomena of bulging and vibration typical of vehicles fitted with hoods.

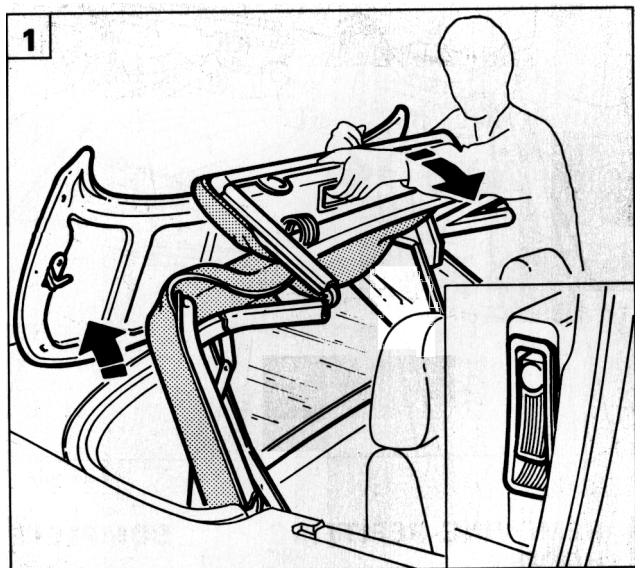


- 1. Arch
- 2. Front cross member

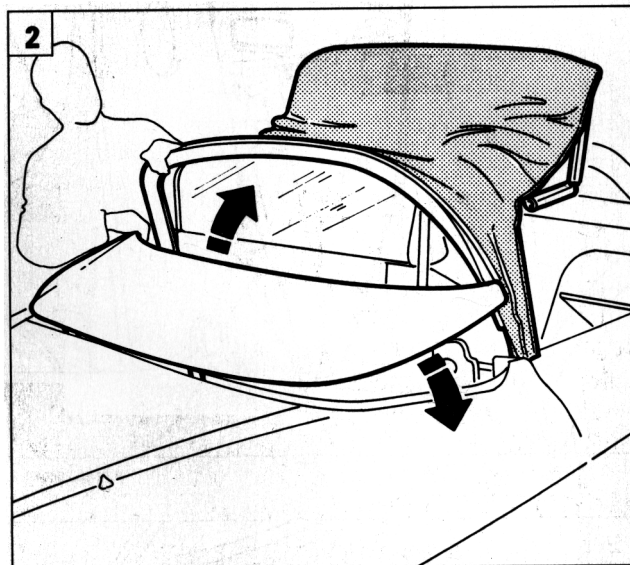
- 3. Ribs
- 4. Right side rod

- 5. Left side rod
- 6. Gas springs

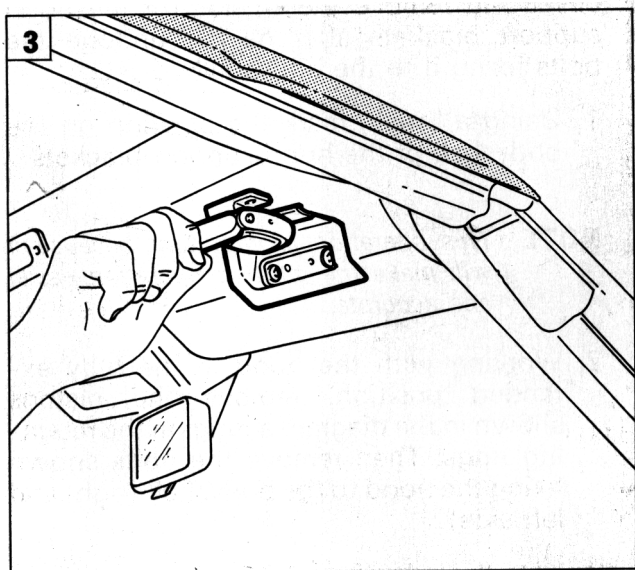
The hood, when it is folded over, is housed in a special compartment in the rear part of the vehicle; this compartment is covered by a flap which is opened manually by a lever in the rear of the driver's door.



P3W12AM01



P3W12AM02



P3W12AM03

In order to open and close the hood, refer to the following procedure:



*Make sure that the luggage compartment lid is closed before proceeding with opening the hood. If this is not the case, an audible signal will point out that the boot lid is not properly closed.*

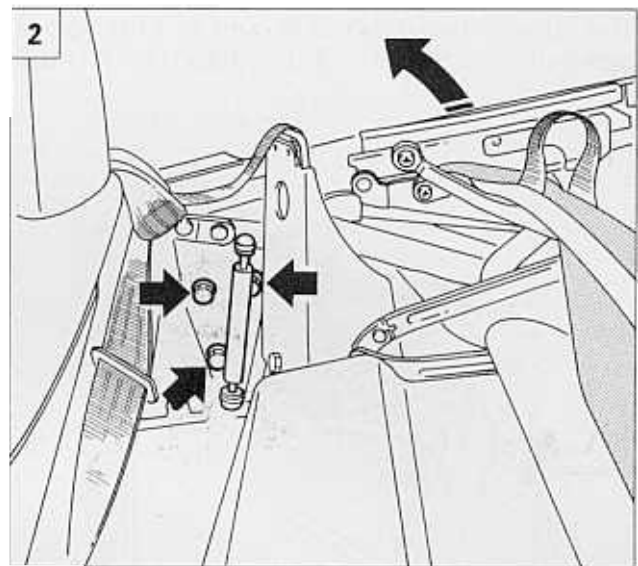
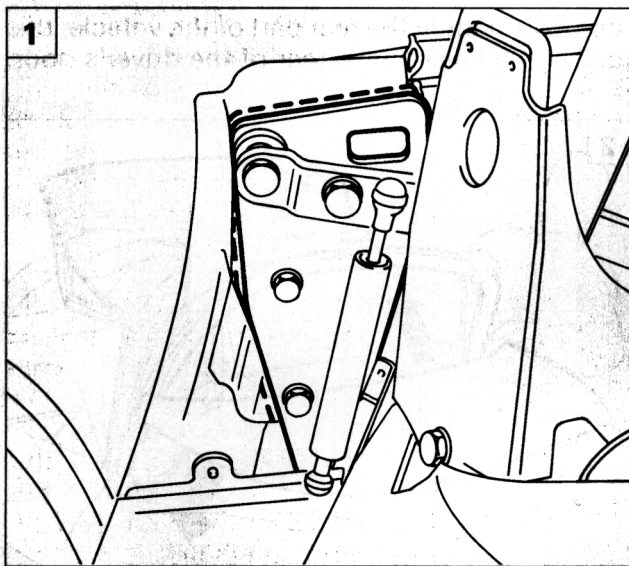
1. Unlock the hood cover flap lock by operating the control lever, then, always working from the left hand side of the vehicle, lift up the hood cover flap with your right hand.
2. Extract the hood working with your left hand on the centre part of the hood front cross member, directing it towards the front of the vehicle until it is fully extended.

Raise the rear arch of the hood until it is in a vertical position, then close the hood cover flap making sure that both locks are properly closed and lower the arch onto the actual hood cover flap.

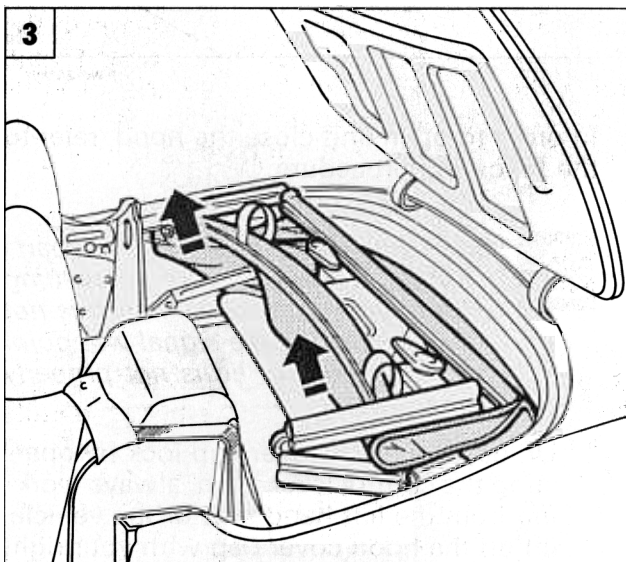
3. Rest the front cross member of the hood on the upper windscreen cross member then, working from inside the vehicle, rotate the two fixing handles to allow the locking of the hood.

In order to close the hood again, follow the procedure reversing the operations described for the opening, always making sure that the boot lid is closed and, if necessary, easing the packing of the hood to avoid wrinkles being formed on the surface of the rearscreen.

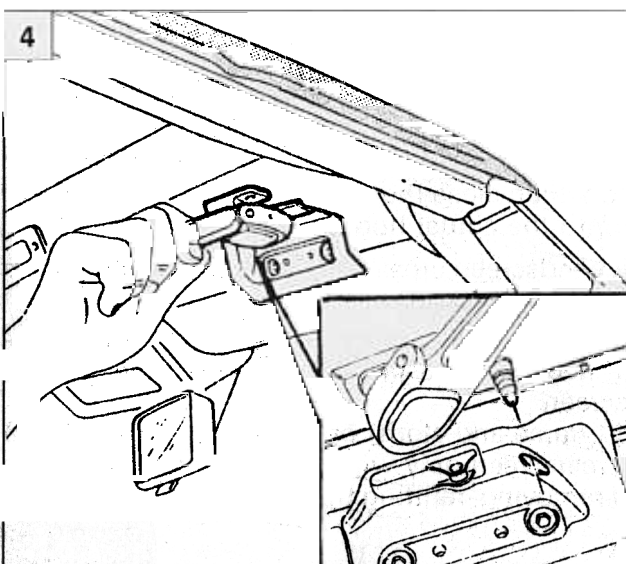
If necessary, the hood can be removed either completely (frame and cloth) or partly (outer cloth only) from the vehicle; in addition, it is possible to replace the rearscreen only without having to remove the hood. The pages which follow contain the procedures for removing-refitting the above mentioned components.



P3W052M07



P3W052M06



#### REMOVING-REFITTING

#### COMPLETE HOOD



Move both seats forwards, lift up the hood cover and remove the shields for the hood support brackets after having undone the bolts fixing it to the bodyshell.

- 1 Using a brush, mark the position on the bodyshell of the hood support brackets.

**NOTE** *This operation is important because it will make the refitting operation easier and accurate.*

2. Working with the hood in the fully extended position, remove the pistons shown in the diagram acting on the retaining rings. Then remove the bolts shown fixing the hood to the bodyshell (right and left side).

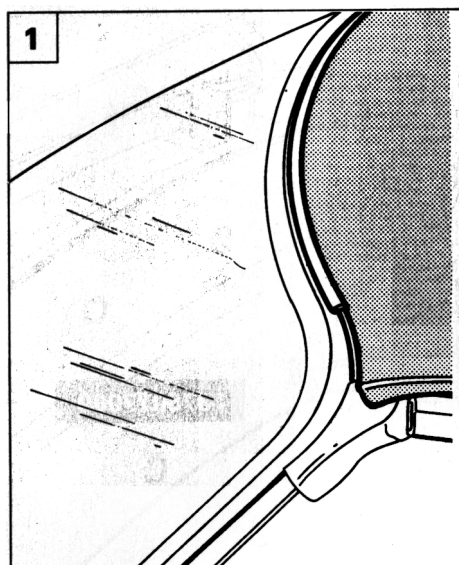
3. With the help of a second operator, extract the hood from its housing.

#### Refitting hood

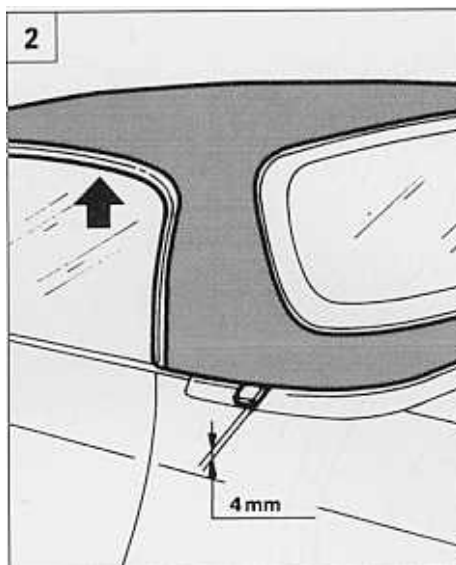
Position the hood in the special housing paying attention to the marks made previously; tighten the bolts fixing the brackets to the bodyshell and fix the pistons to facilitate the opening of the hood.

4. Place the hood in the fully extended position; check the perfect alignment between the hood centering pins and the openings in the two attachments for the actual handles.



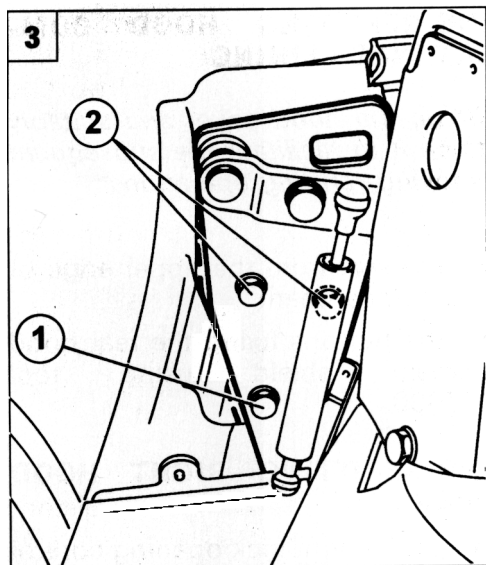


P3W053M01



P3W053M05

1. Working from inside the vehicle, rotate the hood locking handles into the closed position, then check the perfect alignment between the latter and the upper edge of the front window glass.
2. Check: the correct matching between the seals for the hood and the side window glasses; that the rear arch seal rests correctly on the hood cover and that there is a distance of 4 mm between the latter and the cloth stitching.

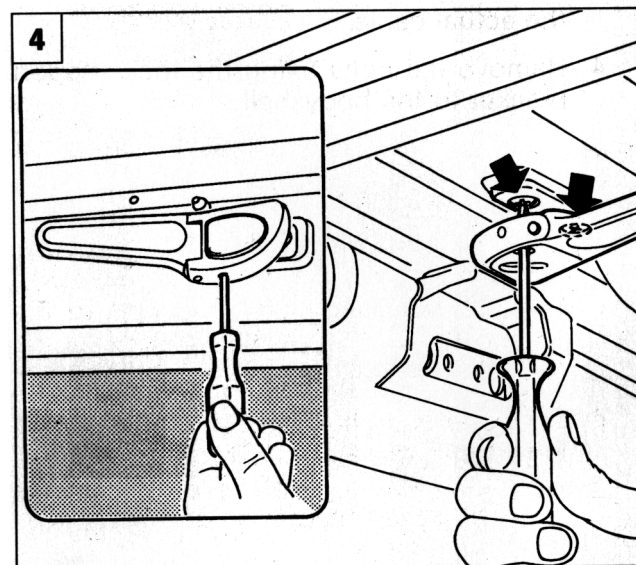


P3W053M06

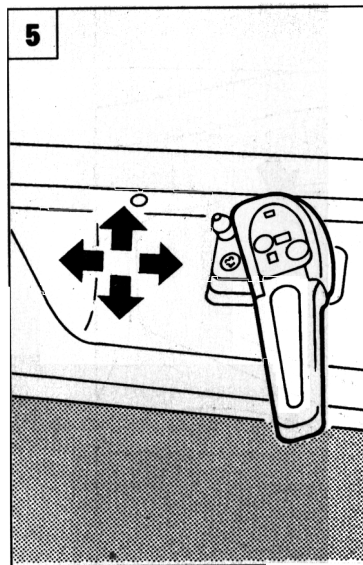


3. If the alignments are not correct, the position of the brackets must be altered by loosening the bolts (1 and 2) for the vertical alignment of the hood and the bolts (2) for the longitudinal movement only in order to achieve the 4 mm distance mentioned previously.

### REMOVING-REFITTING AND ADJUSTING HOOD HANDLES



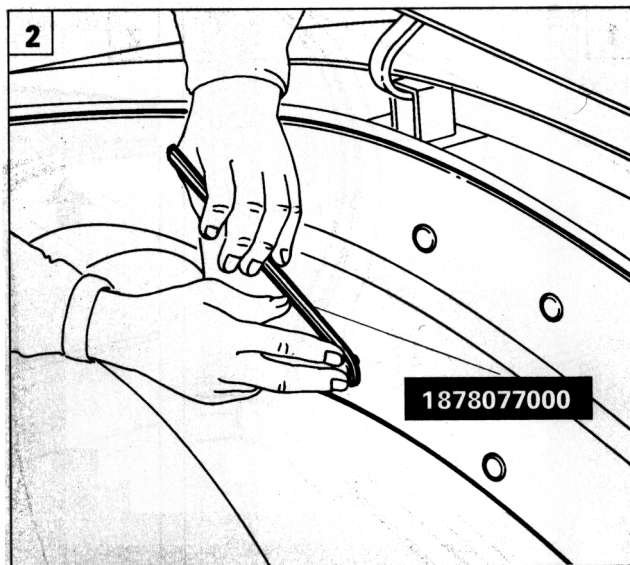
P3W053M03



P3W053M02

4. The hood handle is fixed by two bolts. One bolt is accessible by suitably rotating the handle itself; to gain access to the second bolt, remove the plastic handle trim, inserting a screwdriver into the opening shown in the inset to press on the retaining tab for the actual trim. In this way it is possible to gain access to the opening through which the second handle fixing bolt can be reached.
5. Adjust the position of the handles; the arrows indicate the possible movements. This operation is necessary if the hood is to be correctly closed (alignment between front window glass upper hood edge - pressure of rear arch on hood cover) and if the hood is to be centered on the front window glass.





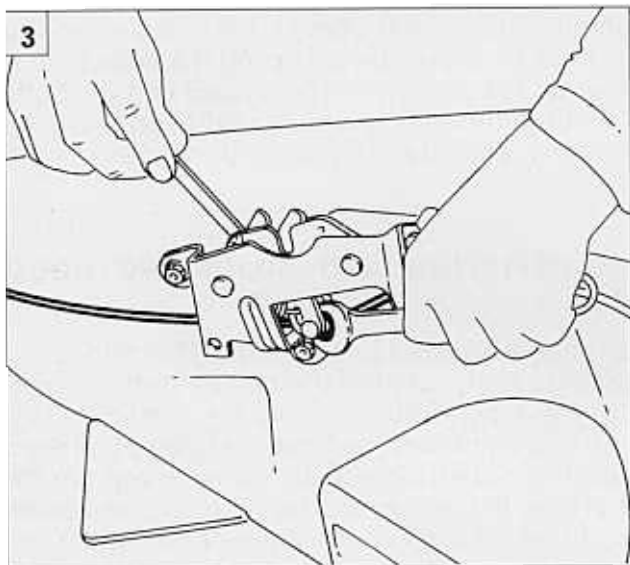
P3W054M02



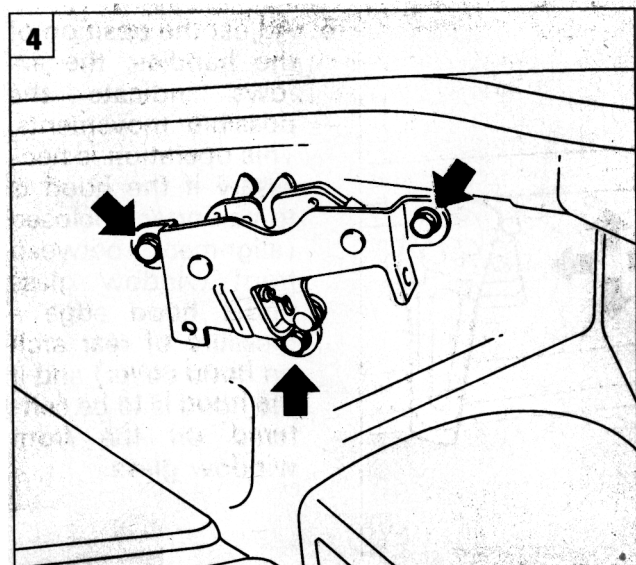
#### REMOVING-REFITTING HOOD COMPARTMENT INNER LINING



*Lift up the hood cover and suitably attach it to facilitate the subsequent removing-refitting operations.*



P3W054M03

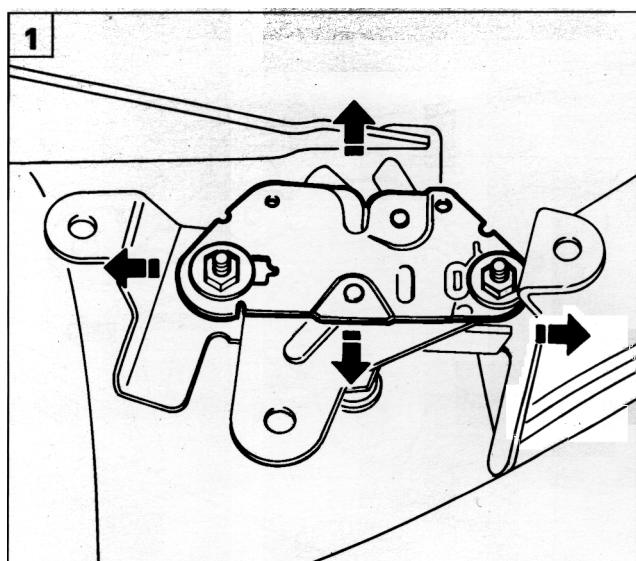


P3W054M04

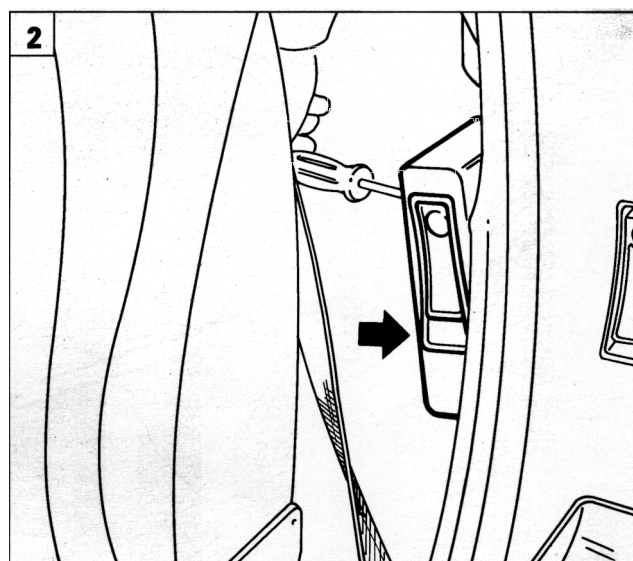
1. Remove the seal from the upper edge of the hood compartment.
2. Remove the buttons fixing the rear hood compartment shield using tool 1878077000.

#### REMOVING-REFITTING RIGHT HOOD COVER LOCK

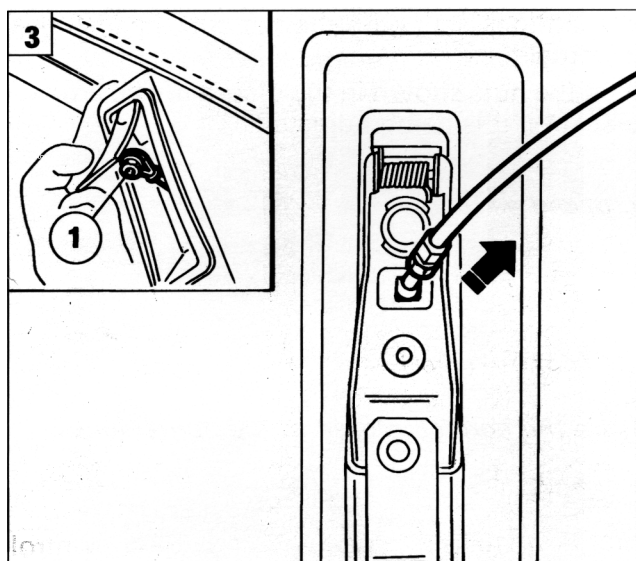
3. Disconnect the right lock opening control cable acting as shown in the diagram on the fixing nut and lock nut, then remove the actual cable.
4. Remove the bolts fixing the lock support bracket to the bodyshell.



P3W055M01



P3W055M02



- 1 Separate the right lock from the mounting bracket acting on the two nuts shown in the diagram. The arrows indicate the possible movements for an adjustment during fitting.

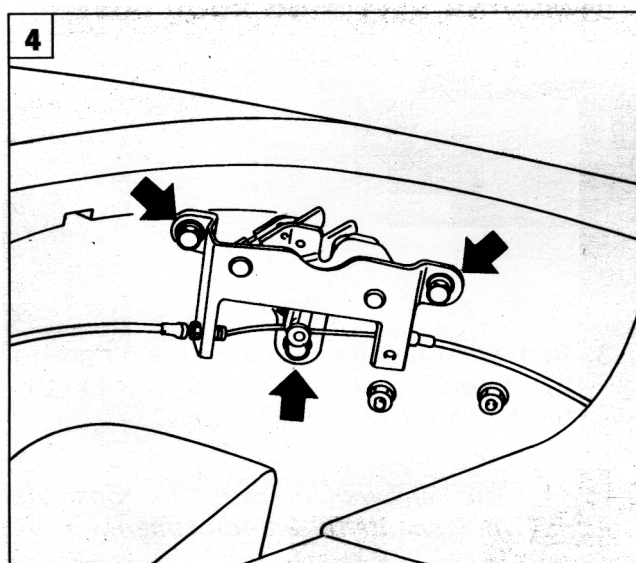


### REMOVING-REFITTING LEFT HOOD COVER LOCK AND REPLACING CONTROL CABLE

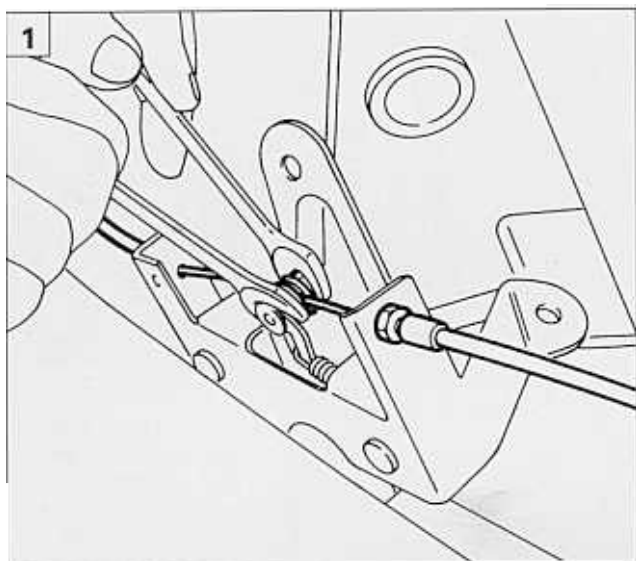
2. Undo the two bolts fixing the hood cover lock opening control lever trim.
3. Undo the nut (1) retaining the lock opening control cable, then remove it from the rear part of the control lever, as shown in the diagram.



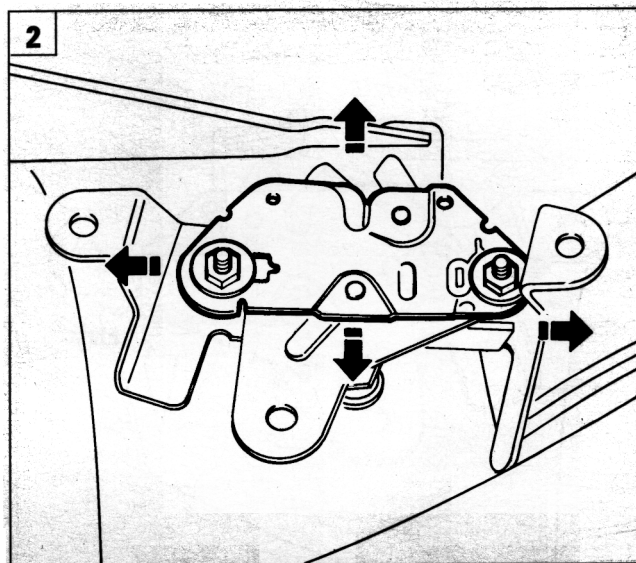
*This operation is necessary to allow the removal of the left lock control cable. It will also be necessary to carry out this operation if replacing the actual cable.*



4. Remove the bolts fixing the mounting bracket for the left lock to the bodyshell.



P3W056M01



F3VV056M02

1. Disconnect the hood cover lock opening cable from the left lock acting on the nut and the lock nut shown in the diagram, then remove the cable from the actual lock.
2. Remove the left lock from the mounting bracket acting on the nuts shown in the diagram. The arrows indicate the possible movements for the lock on the bracket if it is being adjusted.

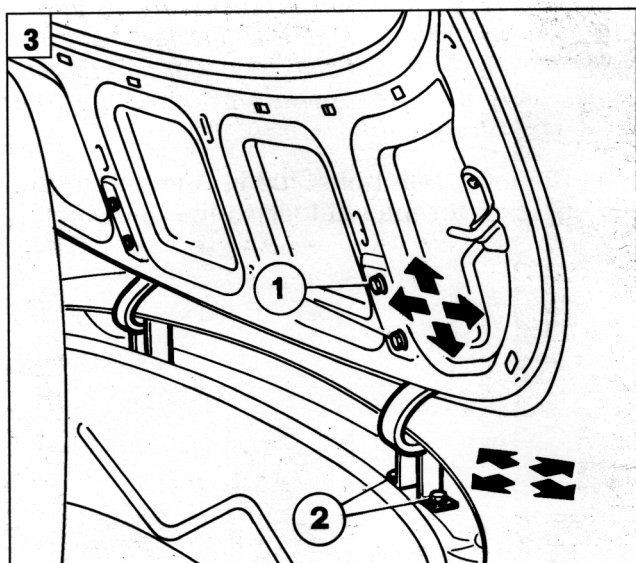


*To replace the hood cover lock opening cable, proceed as follows:*

- disconnect the cable from the right lock;
- release the cable from the left lock;
- disconnect the cable from the control lever;
- extract the cable working from inside the vehicle (control lever).



*Adjust the hood cover lock opening cable to ensure the correct release of the actual locks.*



P3W056M03



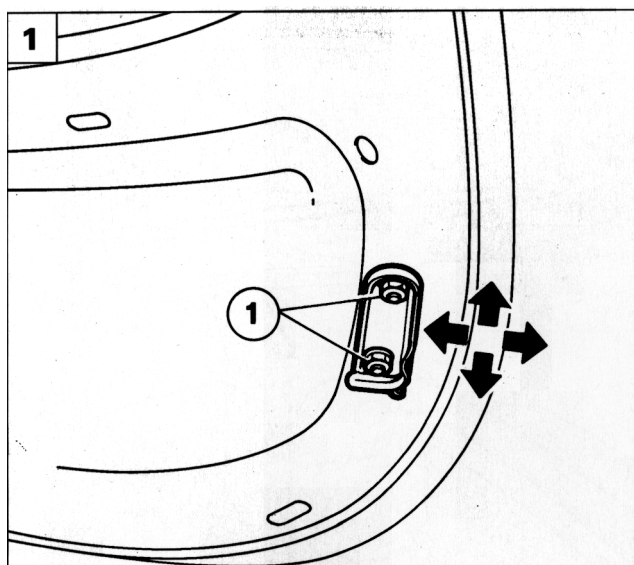
## REMOVING-REFITTING HOOD COVER

3. Remove the bolts (1) fixing the hinges to the hood cover. The bolts (2) fix the hinges to the bodyshell.

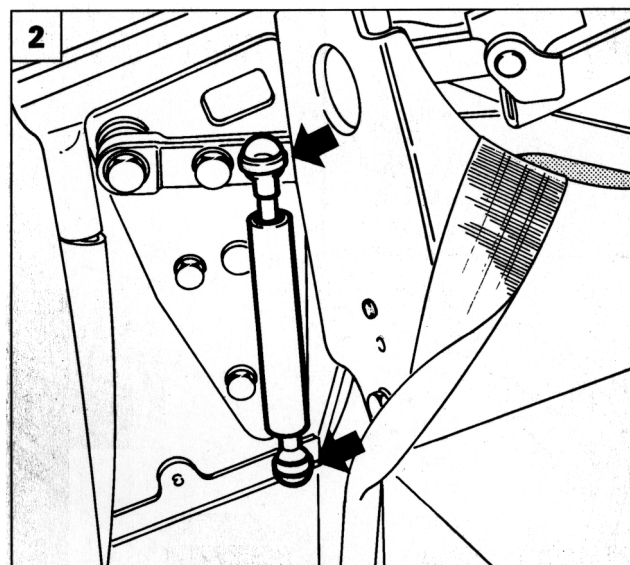


*The arrows indicate the possible movements for an adjustment.*

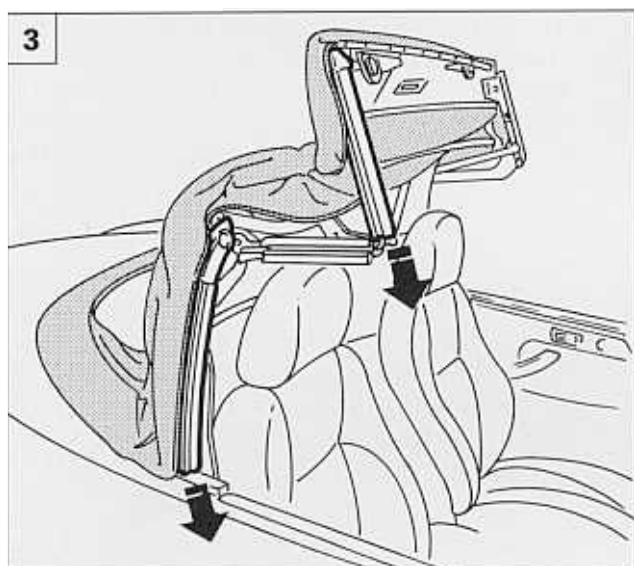




P3W057M01



P3W057M02



P3W057M05



1. To remove the hood cover lock striker, remove the nuts (1) which fix the actual striker to the hood cover. The arrows indicate the possible movements for the adjustment.

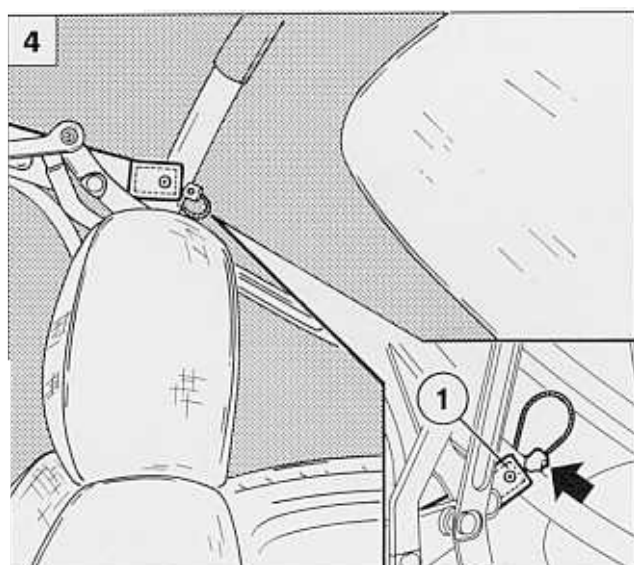
### REMOVING-REFITTING HOOD OPENING PISTONS (GAS SPRINGS)

2. To facilitate the opening of the hood there are two pistons fitted where the hood is fixed to the bodyshell. The removal and refitting of these pistons should take place with the hood in the fully extended position so that the compression of the internal spring is discharged. For their removal it is necessary to act on the two retaining rings shown in the diagram.

### REMOVING-REFITTING HOOD CLOTH



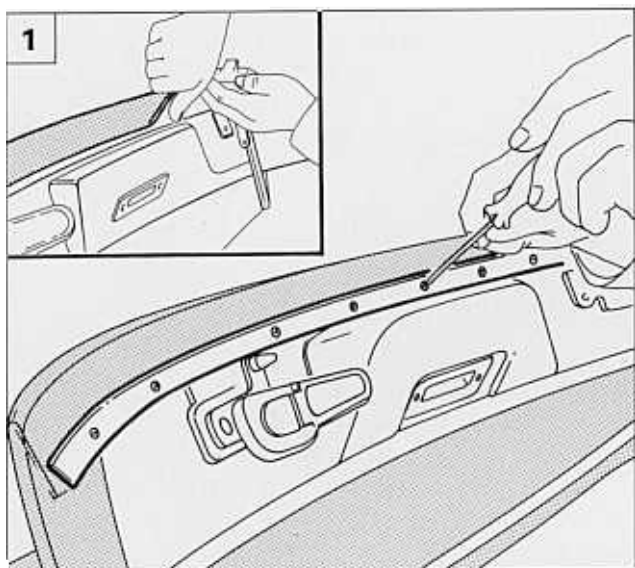
*Work with the hood in the fully extended position without, however, attaching the locking handles to the windscreen upper cross member.*



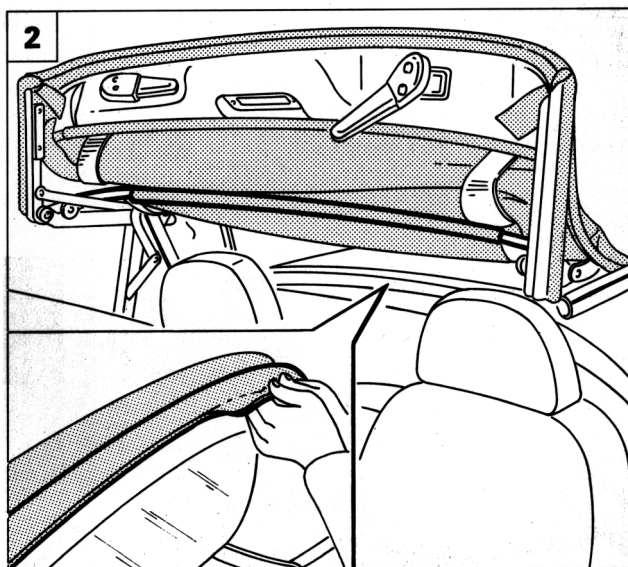
P3W057M06

3. Extract the side trims shown in the diagram fitted to the lowering window by removing them from their housing in the direction shown by the arrows.
4. Working from inside the vehicle, using a drill, remove the rivet (1) retaining the flexible rod shown. Also disconnect the steel cable (rod) releasing it from the clip by rotating the bolt shown in the diagram, then remove it from its housing.

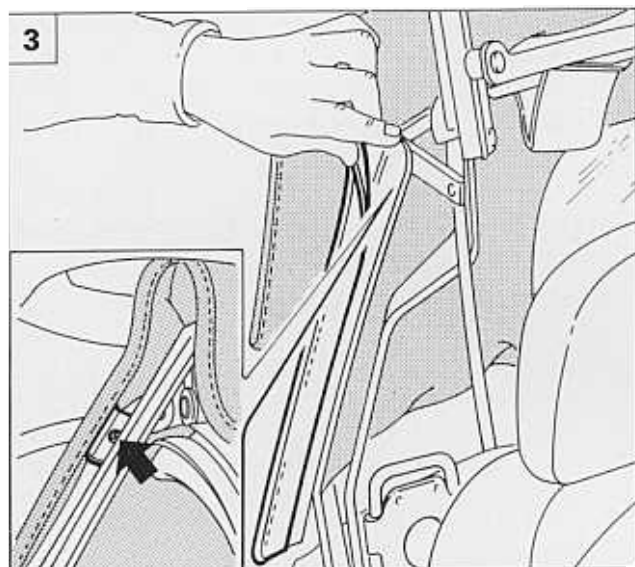




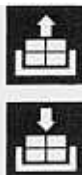
P3W058M06



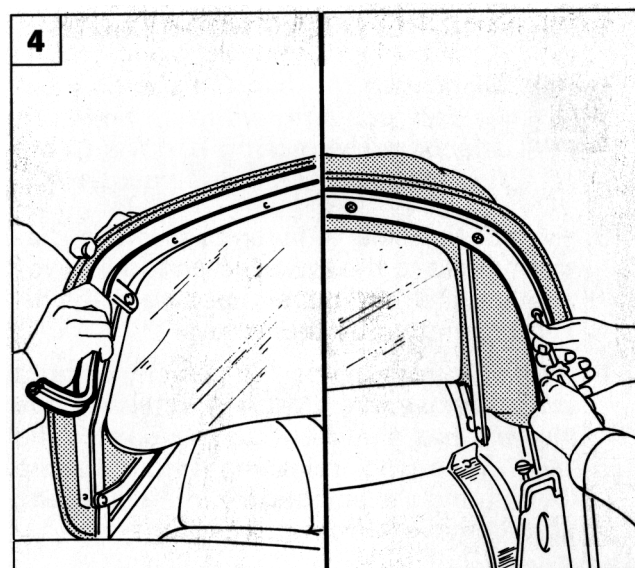
P3W058M07



P3W058M08

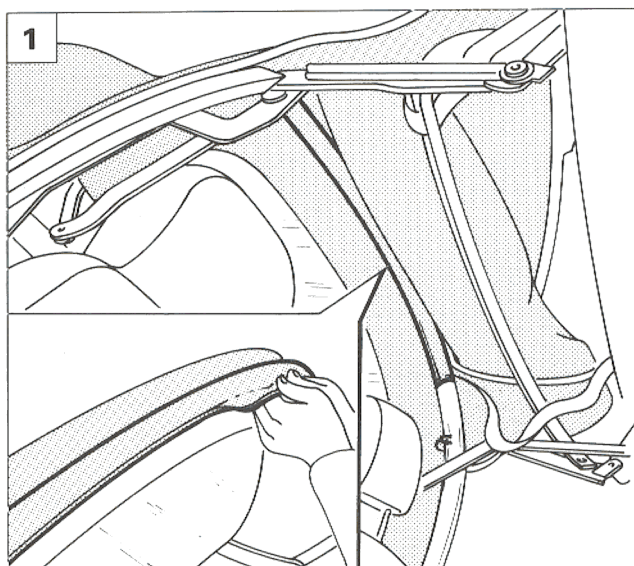


1. Undo the bolts fixing the metal retaining band for the front edge of the hood cloth from the front cross member. Then remove the cloth from the front cross member working as illustrated in the inset.
2. Remove the two edges of the hood cloth from the front centre rib working as illustrated in the inset.
3. Undo the bolt fixing the upper plate retaining the hood cloth on the side pillar, as shown in the diagram; then remove the cloth from the side pillars.
4. Lift up the rear arch and suitably attach it so that the operation of removing-refitting the hood cloth is made easier. Remove the trim shown in the diagram, then undo the bolts fixing the metal retaining band for the rear edge of the hood cloth. Then remove the cloth from the rear arch.

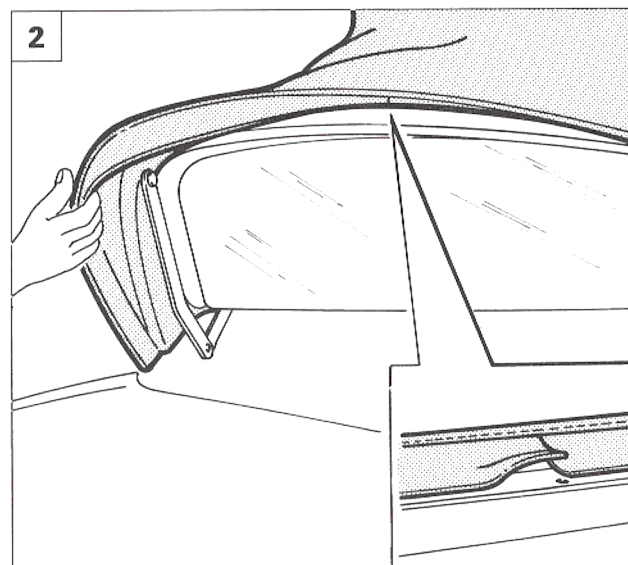


P3W058M09

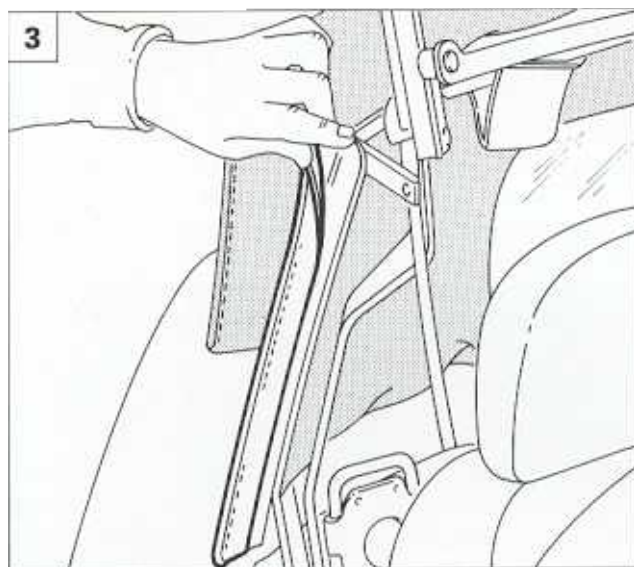




P3W059M05



P3W059M06



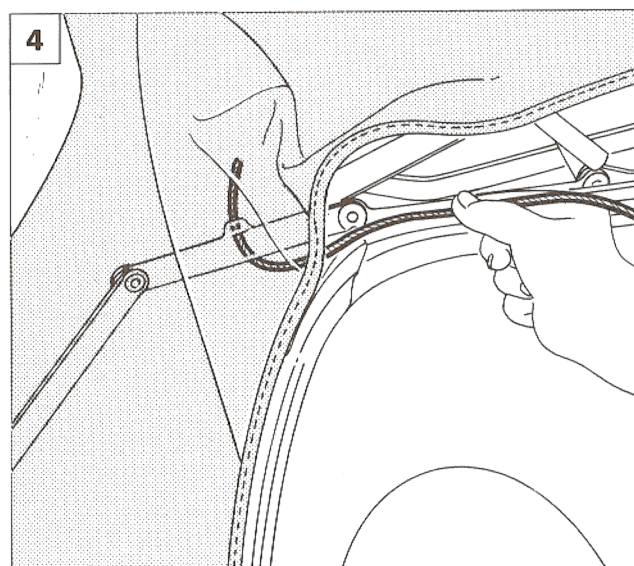
P3W059M07



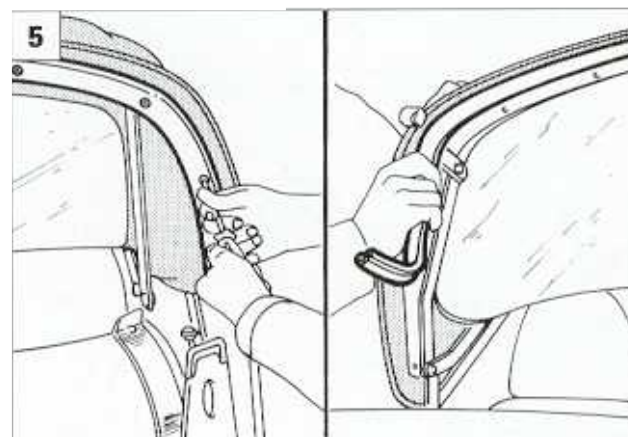
1. Remove the two edges of the hood cloth from the rear centre rib, then remove the actual cloth from the frame.

#### REFITTING HOOD CLOTH

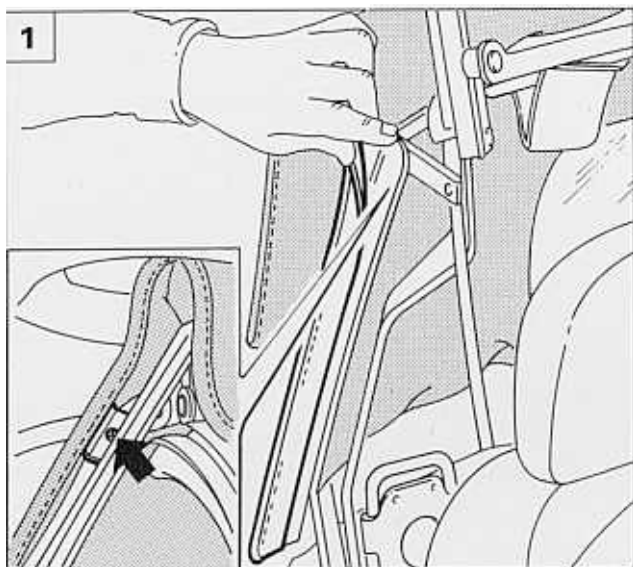
2. Position the hood cloth fitting it on the rear arch taking care that the two notches in the actual cloth (shown in the inset) coincide with the opening in the centre of the arch.
3. Fit the side part of the cloth on the appropriate pillars, then position the cloth on the front cross member so that it fits over the corners of the actual cross members.
4. Position the steel cable in the appropriate housing passing it through the opening in the side levers for the hood frame.
5. Before sticking, check that the hood cloth is correctly positioned, then apply the adhesive to the edge of the arch, wait several minutes and fix the cloth using the appropriate metal band; then place the seal in position.



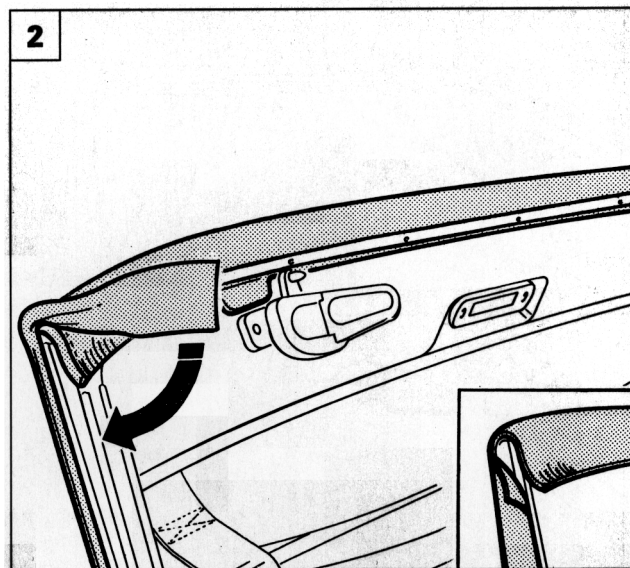
P3W059M08



### 70.



P3W060M03

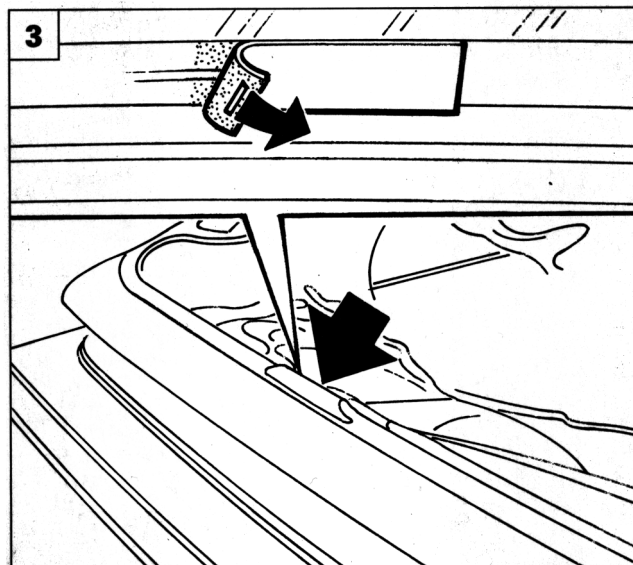


P3W060M03

1. Apply the adhesive to the edge of the side pillar, wait for several minutes, then fix the side part of the hood cloth to the pillar, taking care to insert the edge of the cloth between the two fixed plates on the actual pillar. Place the upper plates retaining the cloth in position and fix them using the appropriate fixing bolts.
2. Apply the adhesive to the edge of the front cross member, wait for several minutes, then fix the front part of the hood cloth to the cross member using the appropriate metal retaining band. Stick the two edges of the cloth to the corners of the internal cross member using loctite and cut off the excess cloth.  
Finish the fitting operation by fixing the internal flexible rods using rivets and lock the steel cable using the appropriate bolt, as described for the removal. Apply the double-sided transparent adhesive tape on both edges of the cloth to be fixed to the centre ribs (front and rear); fix the inner edge to the rib first, then position the outer edge so that it is fixed to the part of the cloth already in position.

## REPLACING HOOD REAR WINDSCREEN

Before carrying out the operations of removing-refitting the rear windscreen, refer to the following warnings:



P3W24AM01

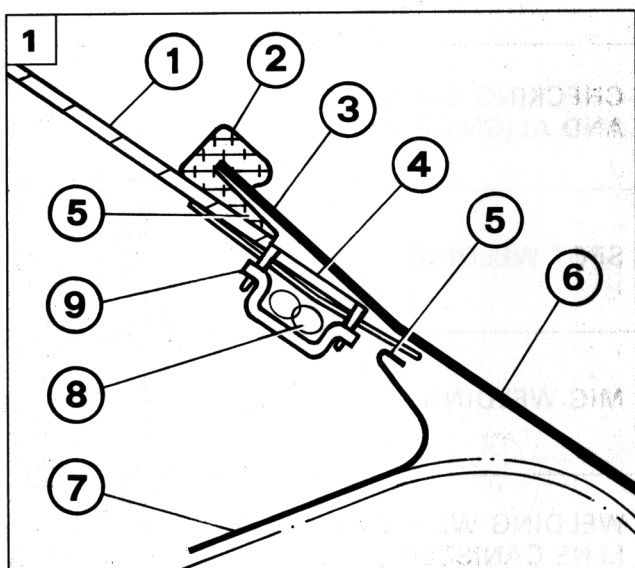


### REMOVING

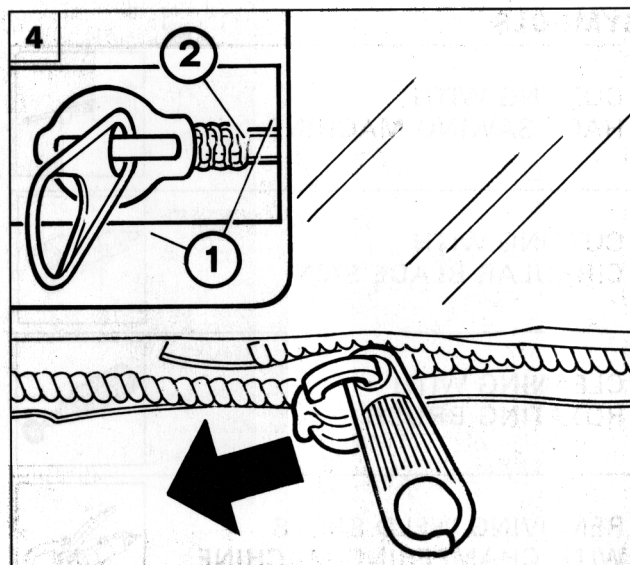
- Work with the vehicle at ambient temperature (20 °C approx);
- Avoid the rear screen and the hood coming into contact with solvents, grease, etc.;
- Work with the help of a second operator;
- Work with the side windows completely lowered, release the hood and raise it to about 20 cm from the closing point;
- Suitably protect the hood cover to prevent it from being damaged during the removing-refitting operations.

3. From inside the vehicle remove the protective band for the rear screen fixing hinge in the centre lower part of the rear screen.

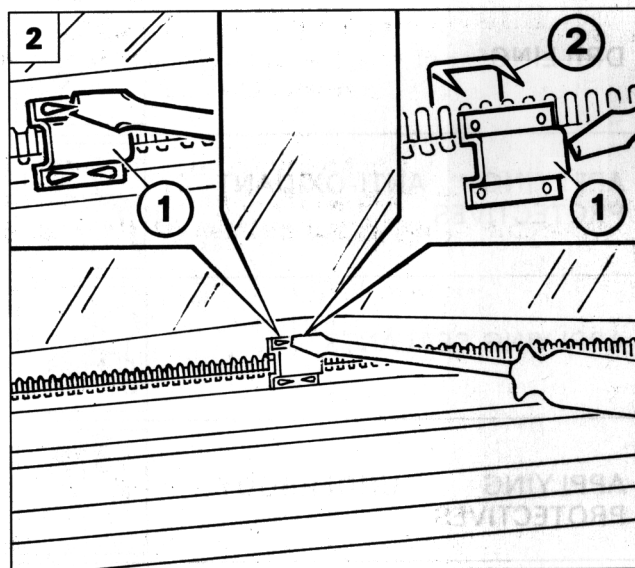




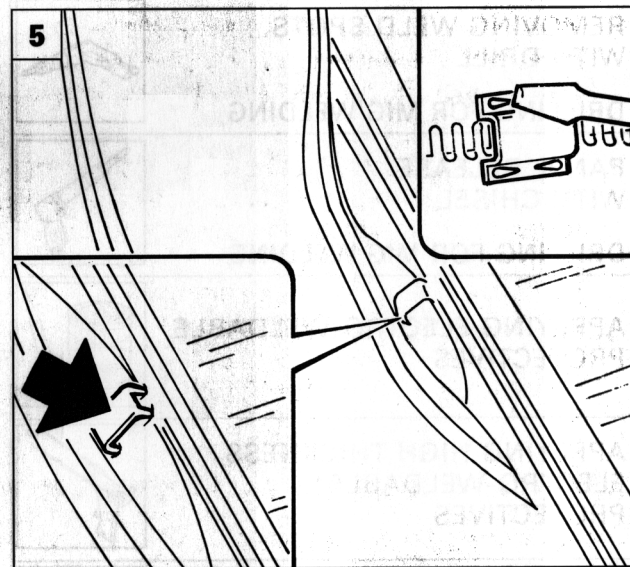
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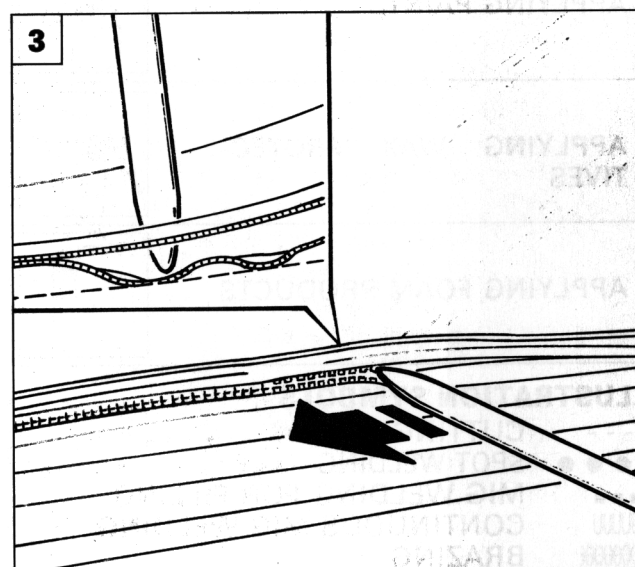
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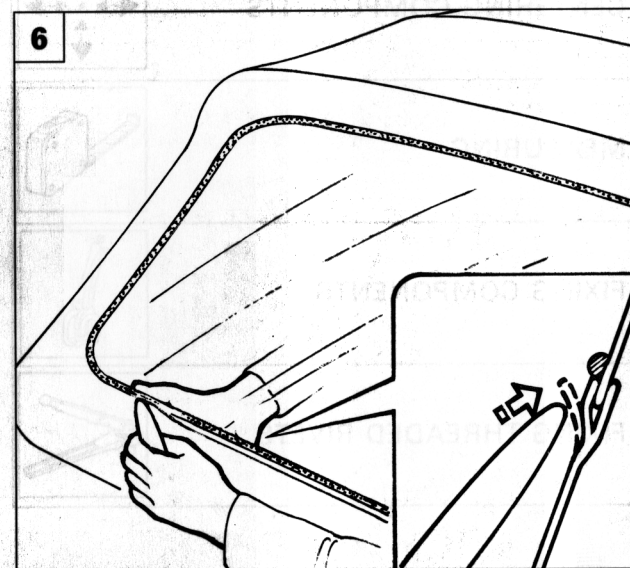
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P3W26AM01



P3W25AM02

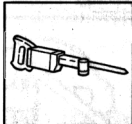


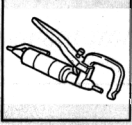

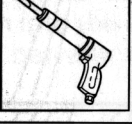

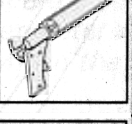
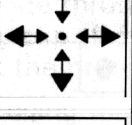
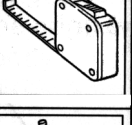
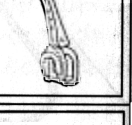
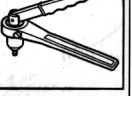
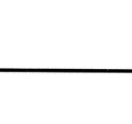



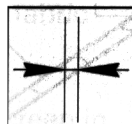
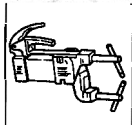
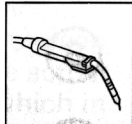
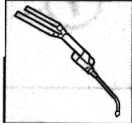
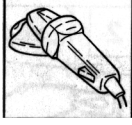

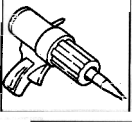
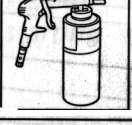
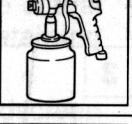
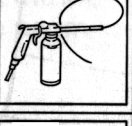
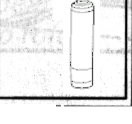
P3W26AM02



# 70.

### SYMBOLS

CUTTING WITH HACK SAWING MACHINE	
CUTTING WITH CIRCULAR BLADE SAW	
CLEANING WITH ROTATING BRUSH	
REMOVING WELD SPOTS WITH CHAMFERING MACHINE	
REMOVING WELD SPOTS WITH DRILL	
DRILLING FOR MIG WELDING	
PANEL RELEASE WITH CHISEL	
DRILLING FOR MIG WELDING	
APPLYING ELECTRO-WELDABLE PROTECTIVES	
APPLYING HIGH THICKNESS ELECTRO-WELDABLE PROTECTIVES	
CENTERING COMPONENTS	
MEASURING	
FIXING COMPONENTS	
FIXING THREADED RIVETS	

CHECKING GAPS AND ALIGNMENTS	
SPOT WELDING	
MIG WELDING	
WELDING WITH OXY-ACETYLENE CANISTER	
DRILLING	
APPLYING ANTI-OXIDANT PROTECTIVES	
APPLYING SEALANTS	
APPLYING UNDERBODY PROTECTIVES	
APPLYING PAINTS	
APPLYING WAX PROTECTIVES	
APPLYING FOAM PRODUCTS	

### ILLUSTRATION SYMBOLS

---	CUTTING LINE
● ● ● ●	SPOT WELDING
■■■■	MIG WELDING FOR FILLING
UUUUU	CONTINUOUS MIG WELDING
XXXXXXX	BRAZING

---

The diagram shows the section of the point where the rearscreen is fixed to the hood cloth.

1. Rear windscreen - 2. PVC trim - 3. Sealing edge - 4. Safety clip - 5. Stitching - 6. Hood fabric - 7. Rearscreen upper section fabric - 8. Hinge - 9. Safety clip projection.

2. Using a screwdriver, lift up the four teeth for the safety clip working on the inside of the rearscreen in the lower centre part.

**NOTE** *During this operation take care not to damage the rearscreen fixing hinge.*

Remove the projection (1) for the safety clip from the inside of the rearscreen and the safety clip (2) from the outside.

3. Working from the inside, insert the special tool supplied in the kit for fitting the rearscreen between the two edges of the hinge and slide it along the entire perimeter of the rearscreen to open the actual hinge. At this point the rearscreen is only held by the sealant along the edge on account of which in order to remove it it is simply necessary to press lightly from the outside inwards.

**NOTE** *Manually remove any residues of sealant from the contact surfaces, without using any solvent.*

## REFITTING

The rearscreen is supplied as spares complete with a fitting kit made up of a cursor for the hinges, a safety clip and projection, a protective adhesive band for the safety clip and a plastic tool for opening the hinge.

4. Fit the cursor for the hinge on the tab, on the inside of the rearscreen at the bottom. Introduce the second half of the hinge on the hood cloth into the cursor so that both the tabs (1) are level with the hinge. The maximum permissible movement between the hinge links (2) is one link to the left or right.



- *During the entire fitting procedure do not remove the special protective velcro from the rear windscreen which protects it from possible damage.*
- *During the operation of fixing the hinge a second operator should hold the rearscreen from the outside and pay attention that the hinge itself does not get stuck.*
- *Slowly close the hinge and when the operation is completed, check that the rearscreen is correctly closed along the entire perimeter and that the hinge does not tend to open at the starting point; then remove the cursor from the hinge and close the hood without locking it.*

5. Clean the surface which is to be stuck using alcohol or methanol and leave it to dry for about 5 minutes. Fit the safety clip from the outside through the hinge by the attachment point for the actual hinge. Fit the projection for the safety clip (from the inside) and fold back the appropriate retaining teeth as shown in the diagram. Stick the protective band, supplied in the kit, by the clip.
6. Completely close the hood and fix it using the appropriate handles. Fit the edge of the windscreen which must be stuck under the outer edge of the hood cloth. Using the tool which comes with the kit, lift up the PVC trim so that it covers the edge of the cloth and press forcefully along the entire perimeter so that the sealant adheres perfectly.



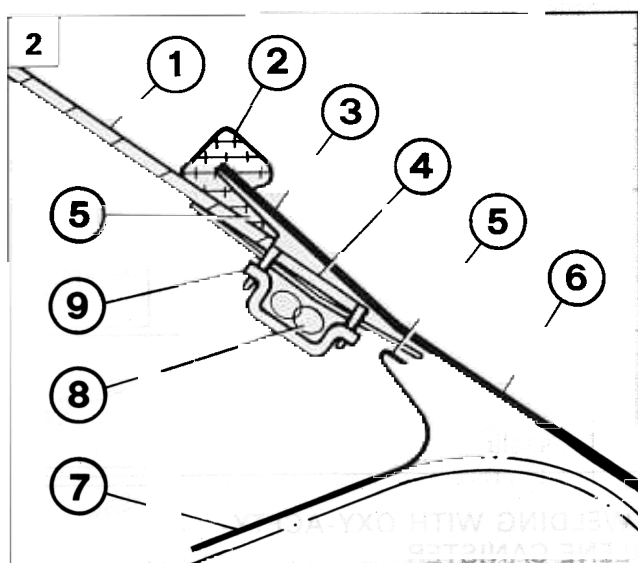
*During this last operation a second operator must exert a counter pressure from the inside at the points where the operator on the outside is causing the sealant to adhere. There can be no folds. There is a danger of damaging the windscreen.*

When the operation is completed, remove the card and the protective velcro.

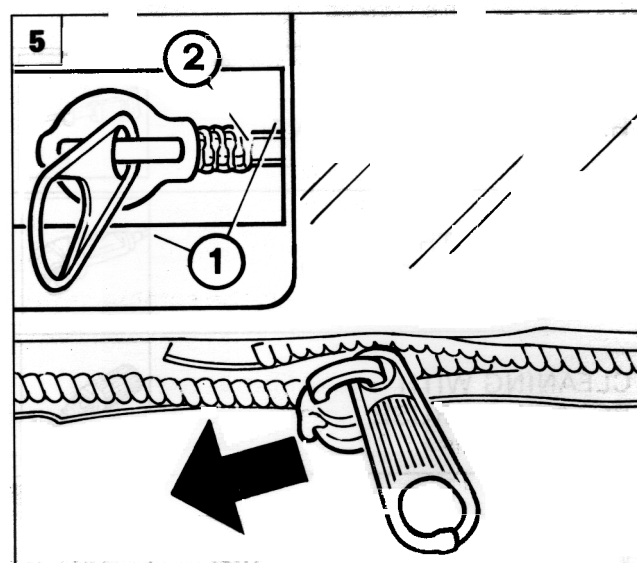


*The sealing edge should harden, therefore the hood should remain taut and should not be folded in the 24 hours following the operation to facilitate the polymerization process of the sealant.*

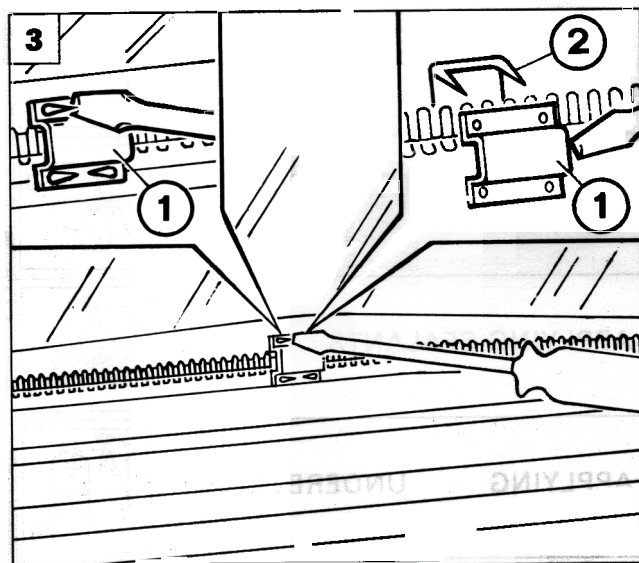
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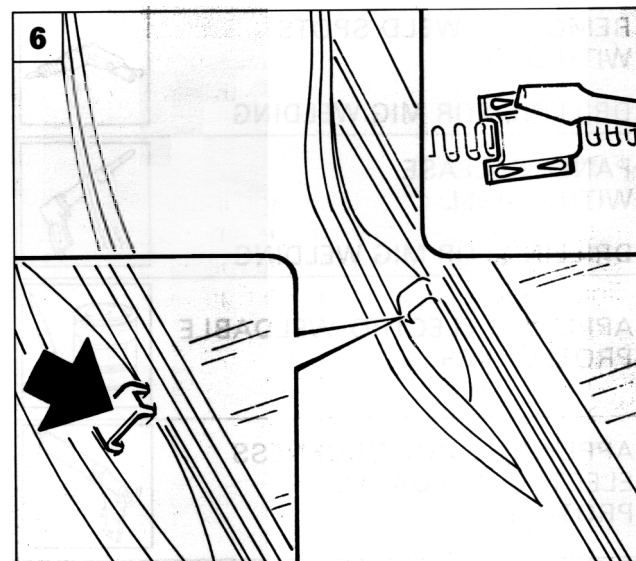
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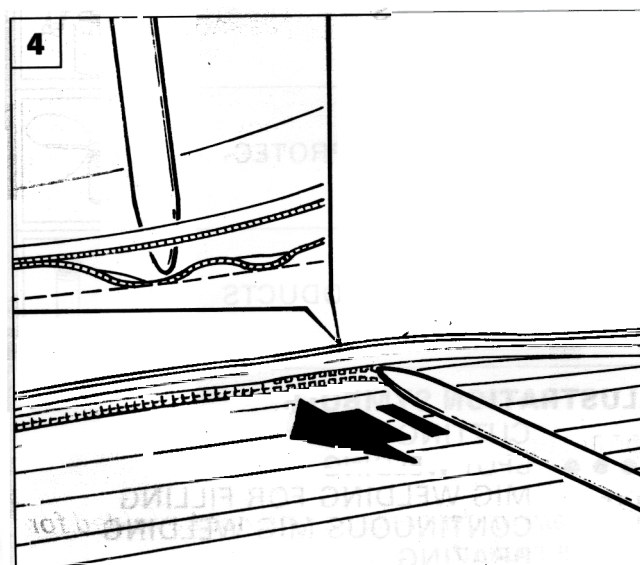
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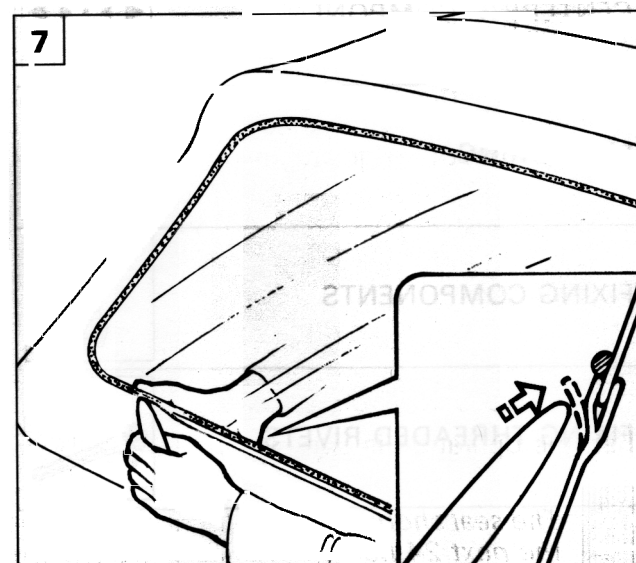
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P3W26AM01



P3W25AM02

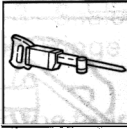
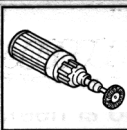
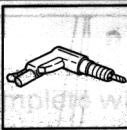

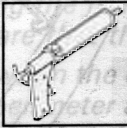
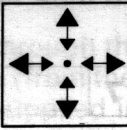
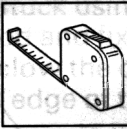
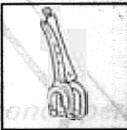



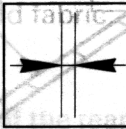
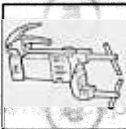
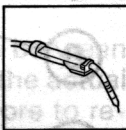
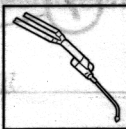
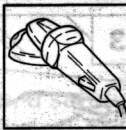
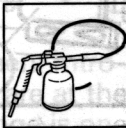
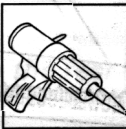
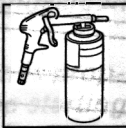
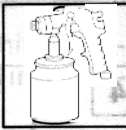
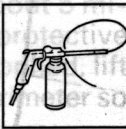
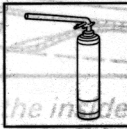
P3W26AM02



## 70.

### SYMBOLS

CUTTING WITH HACK SAWING MACHINE	
CUTTING WITH CIRCULAR BLADE SAW	
CLEANING WITH ROTATING BRUSH	
REMOVING WELD SPOTS WITH CHAMFERING MACHINE	
REMOVING WELD SPOTS WITH DRILL	
DRILLING FOR MIG WELDING	
PANEL RELEASE WITH CHISEL	
DRILLING FOR MIG WELDING	
APPLYING ELECTRO-WELDABLE PROTECTIVES	
APPLYING HIGH THICKNESS ELECTRO-WELDABLE PROTECTIVES	
CENTERING COMPONENTS	
MEASURING	
FIXING COMPONENTS	
FIXING THREADED RIVETS	

CHECKING GAPS AND ALIGNMENTS	
SPOT WELDING	
MIG WELDING	
WELDING WITH OXY-ACETYLENE CANISTER	
DRILLING	
APPLYING ANTI-OXIDANT PROTECTIVES	
APPLYING SEALANTS	
APPLYING UNDERBODY PROTECTIVES	
APPLYING PAINTS	
APPLYING WAX PROTECTIVES	
APPLYING FOAM PRODUCTS	

### ILLUSTRATION SYMBOLS

---	CUTTING LINE
● ● ● ●	SPOT WELDING
■ ■ ■ ■	MIG WELDING FOR FILLING
UUUUUU	CONTINUOUS MIG WELDING
XXXXXX	BRAZING



2. The diagram shows the section of the point where the rear windscreen is fixed to the hood cloth.  
1. Rear windscreen - 2. PVC seal - 3. Sealed edge - 4. Safety clip - 5. Stitching - 6. Hood fabric - 7. Upper rear windscreen fabric - 8. Hinge - 9. Safety clip projection.
3. With the help of a screwdriver, lift up the four teeth for the safety clip working on the inside of the rear windscreen in the lower central part.

**NOTE** *During this operation, take care not to damage the hinge fixing the rear windscreen.*

Remove the projection (1) on the safety clip from the inside of the rear windscreen and the safety clip (2) from the outside.

4. Working from the inside, insert the special tool supplied in the fitting kit for the rearscreen between the two edges of the hinge and slide it along the entire perimeter of the rearscreen to open the actual hinge. At this point the rear windscreen is only held by the sealant along the edge, therefore to remove it simply press lightly from the outside inwards taking care not to damage the actual rearscreen in case it has to be reused.

**NOTE** *Manually remove any residues of sealant from the contact surfaces without using any solvent.*

## REFITTING

The rearscreen is supplied as spares complete with a fitting kit made up of a cursor for the hinge, a safety clip and projection, a protective adhesive band for the safety clip and a plastic tool for opening the hinge.

5. Insert the cursor for the hinge in the corresponding tab, in the lower, inner part of the rearscreen. Introduce the second half of the hinge on the hood cloth in the cursor so that both the tabs (1) are at the same level as the hinge. The maximum permissible movement between the links (2) of the hinge is one link to either the left or the right.



- *During the entire fitting procedure do not remove the special protective velcro from the rearscreen so that it does not get damaged.*
- *During the operation of fixing the hinge, a second operator should hold the rear windscreen from the outside and take care that the hinge does not get stuck.*
- *Slowly close the hinge and when the operation is complete check that the rearscreen is properly closed along the entire perimeter and that the hinge does not tend to open at the starting point; then remove the cursor from the hinge and close the hood without locking it.*

6. Fit the safety clip from the outside through the hinge at the attachment point for the actual hinge. Insert the projection for the safety clip (from the inside) and fold the retaining teeth, as shown in the diagram. Stick the protective band, supplied in the kit, by the clip.
7. Clean the surface which should be stuck using alcohol or methanol and leave it to dry for about 5 minutes, then completely close the hood and fix it using the appropriate handles. Remove the protective paper from the edge and insert it below the outer edge of the hood cloth. Using the tool supplied, lift up the PVC seal so that it covers the edge of the cloth and press strongly along the entire perimeter so that the sealant adheres perfectly.



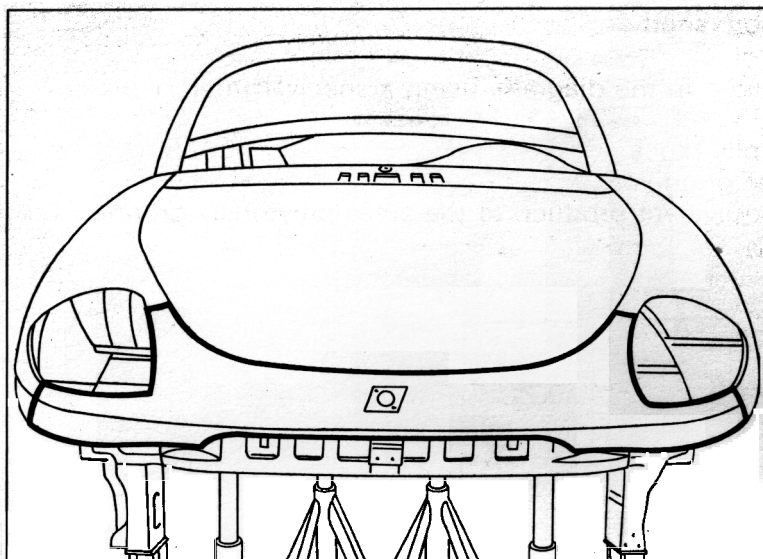
*During this last operation a second operator is required to exert counter-pressure from the inside at the points where the outside operator is causing the sealant to stick. Folds are not permissible. There is a danger of damaging the rearscreen.*

When the operation is completed, remove the card and protection.



*The seal should harden, therefore the hood should remain under pressure and not be folded for the next 24 hours to facilitate the polymerization of the sealant.*

#### REPLACING EXTERNAL FRONT COVER



P3W063M01

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

#### Preliminary procedures

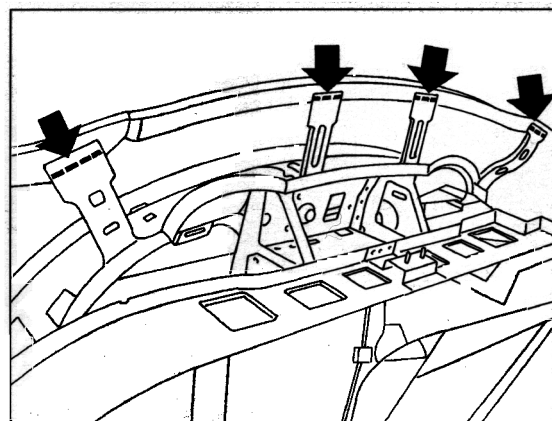
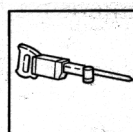
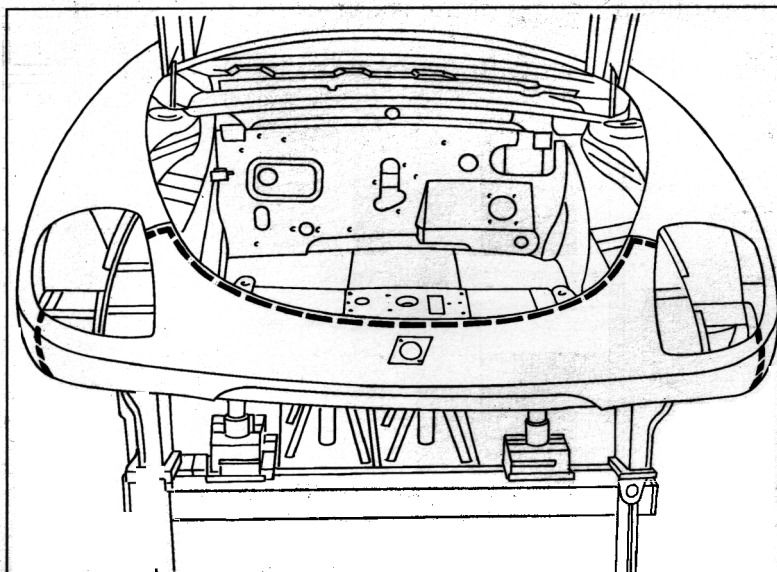
Establish the extent of the damage, check if there are distortions to the connected components by checking the bodyshell alignment figures, using suitable methods (jigs, templates or gauges). Carry out any straightening operations required to the bodyshell before cutting the component. After this operation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

#### Preliminary dismantling

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

#### Removing

Cut the external front cover for the vehicle using a power saw following the dotted lines shown in the diagrams below.



P3W063M03



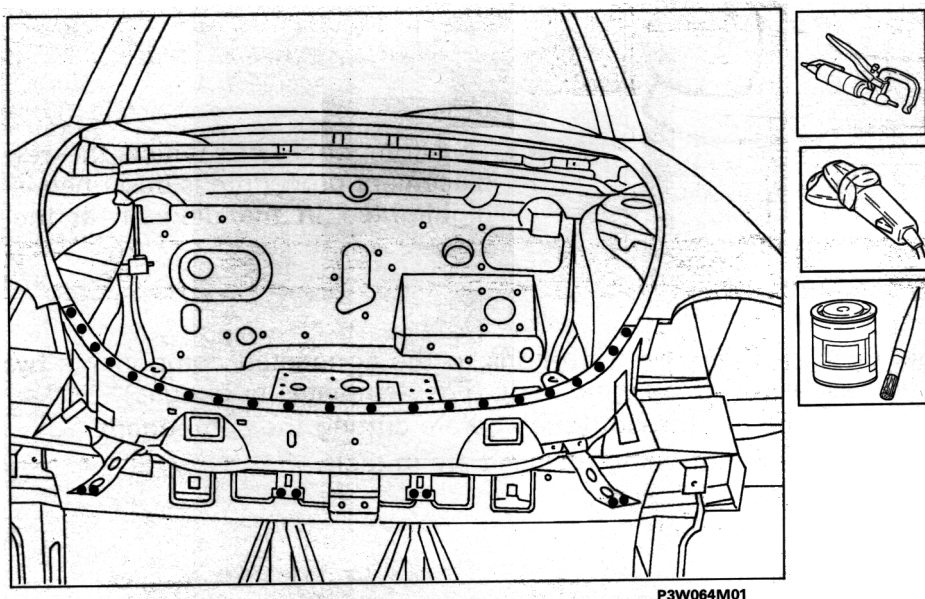
*When carrying out the operations described, adhere strictly to the safety procedures. Wear protective shoes, ear-muffs and gloves during the cutting operations, masks for welding and gloves during the welding operations, and a protective mask and gloves during the painting operations.*



## 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 of the replacement part using a disc grinder.
2. Apply the electro-galvanizing paint to the edges in contact with the bodyshell.

