

Mégane

4 Panels

40 GENERAL

41 LOWER STRUCTURE

43 UPPER SIDE STRUCTURE

44 UPPER REAR STRUCTURE

48 OPENINGS OTHER THAN SIDE DOORS

Bodywork

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43 UPPER SIDE STRUCTURE

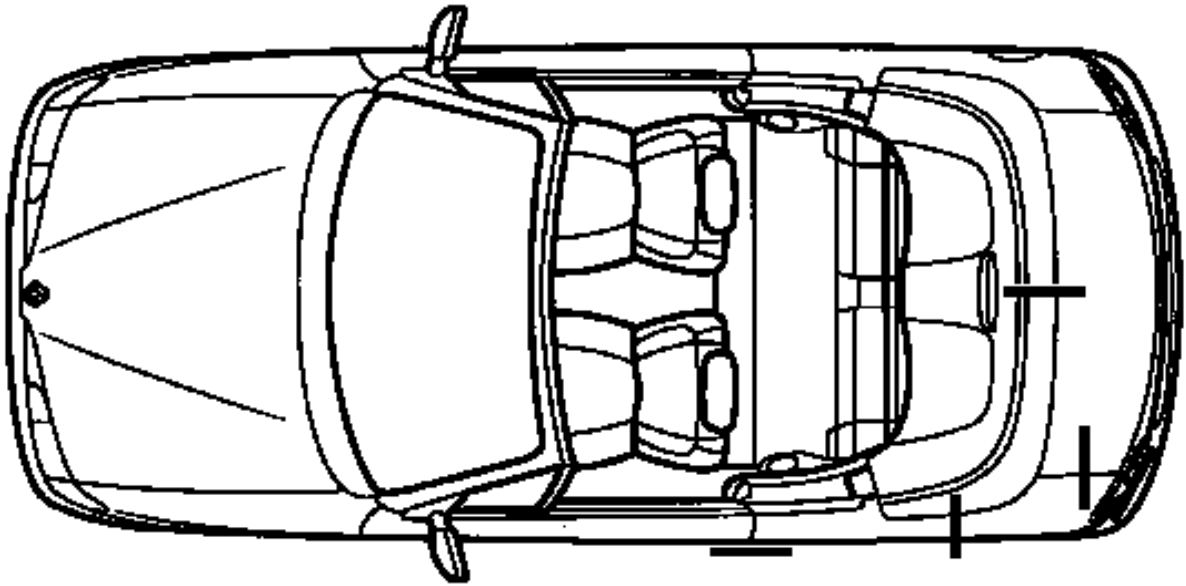
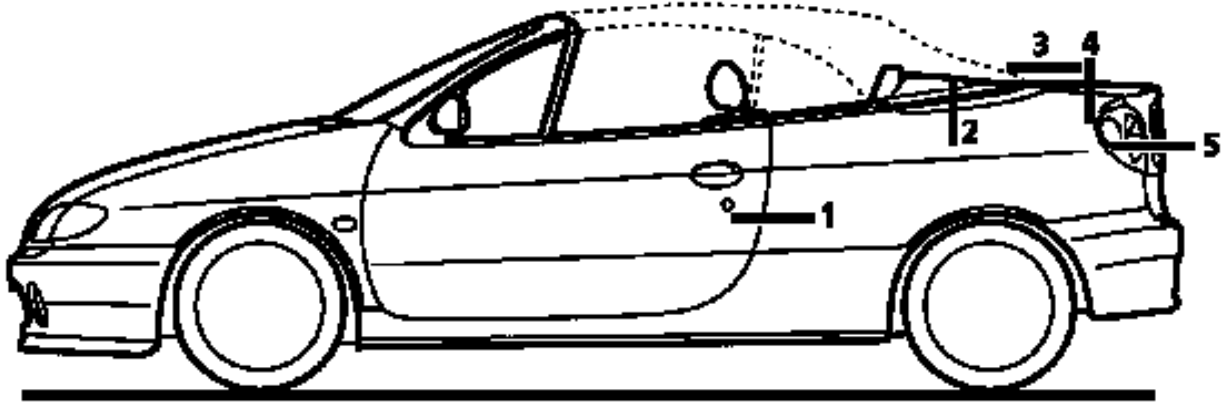
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44 UPPER REAR STRUCTURE

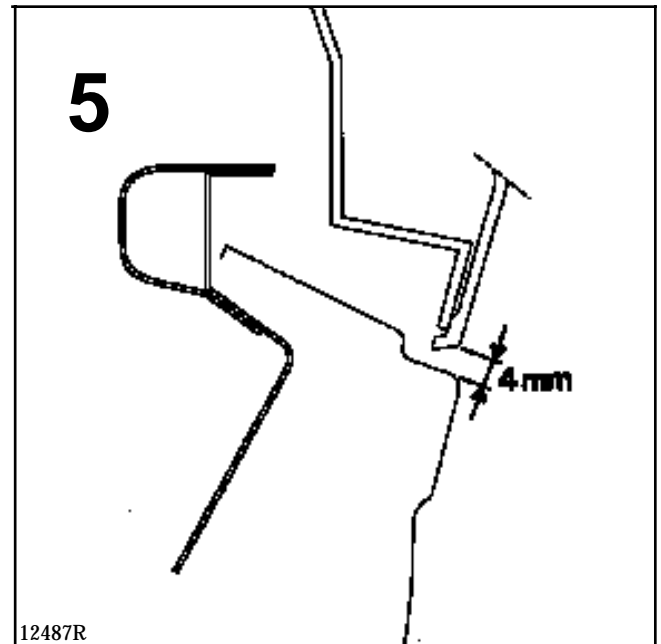
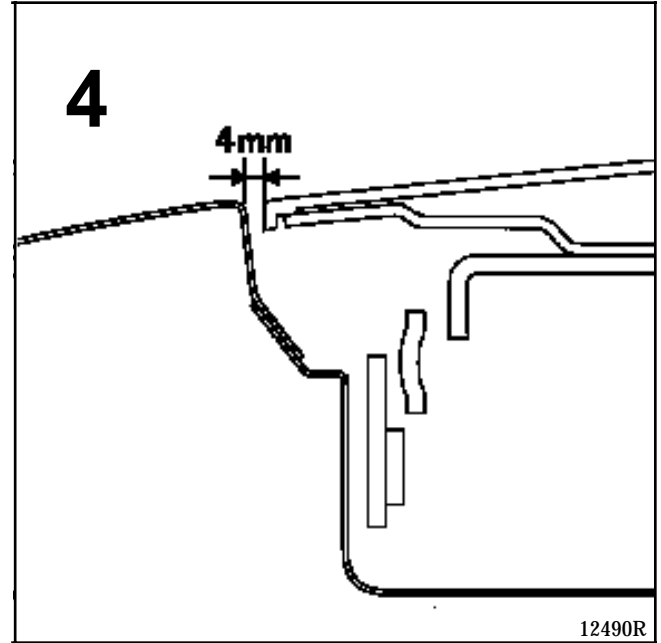
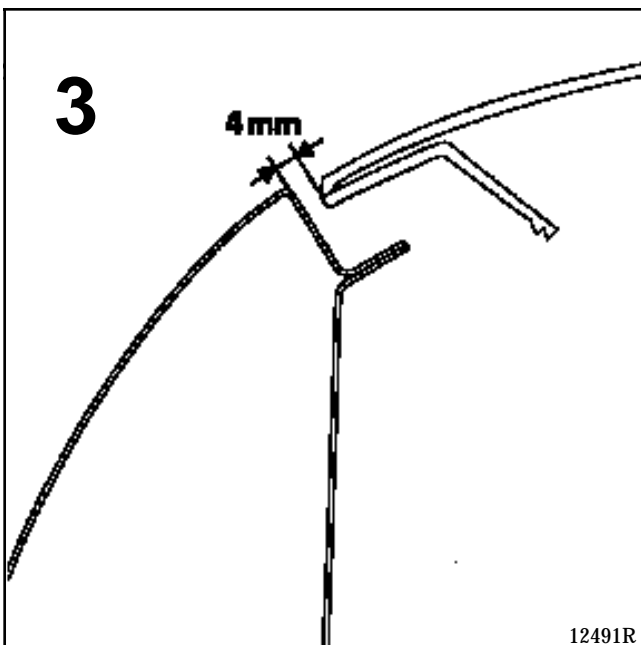
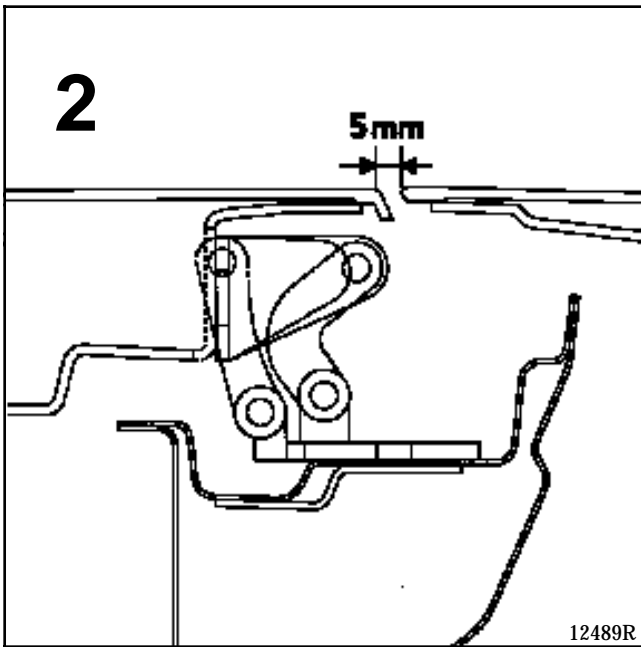
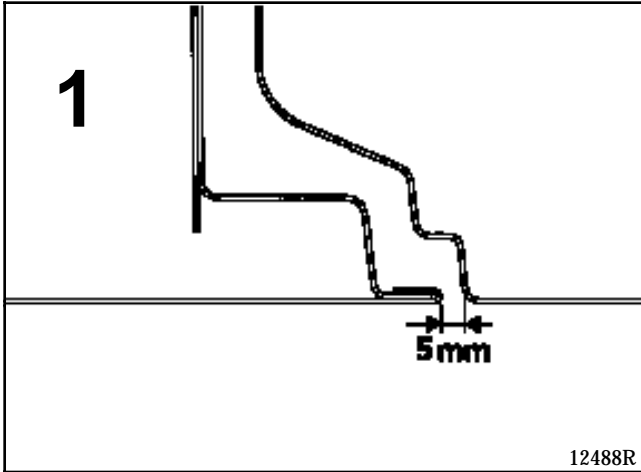
A Hydraulic pump bracket	44-1
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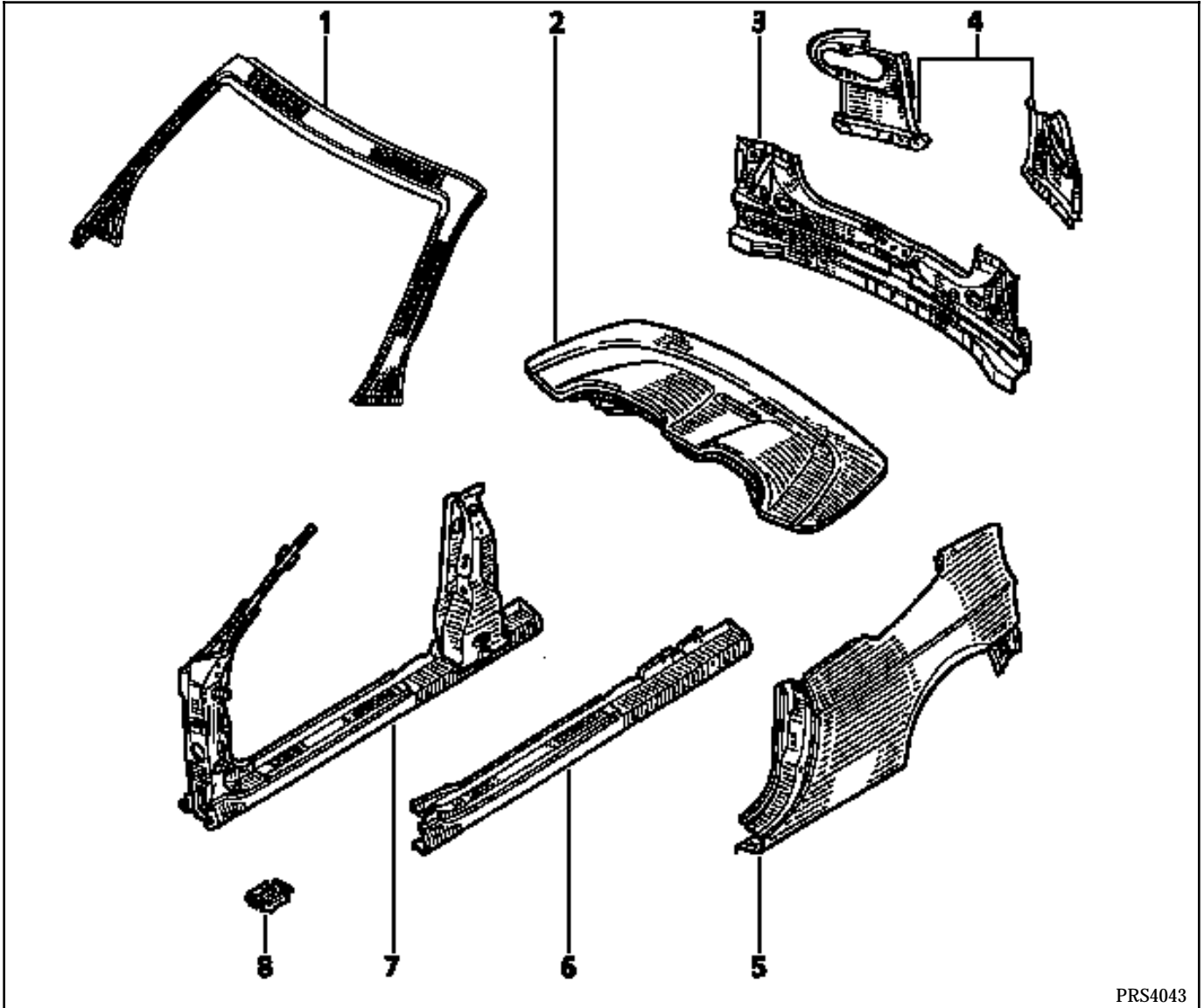
48 OPENINGS OTHER THAN SIDE DOORS

Boot	48-1
Hood cover	48-2



11632R





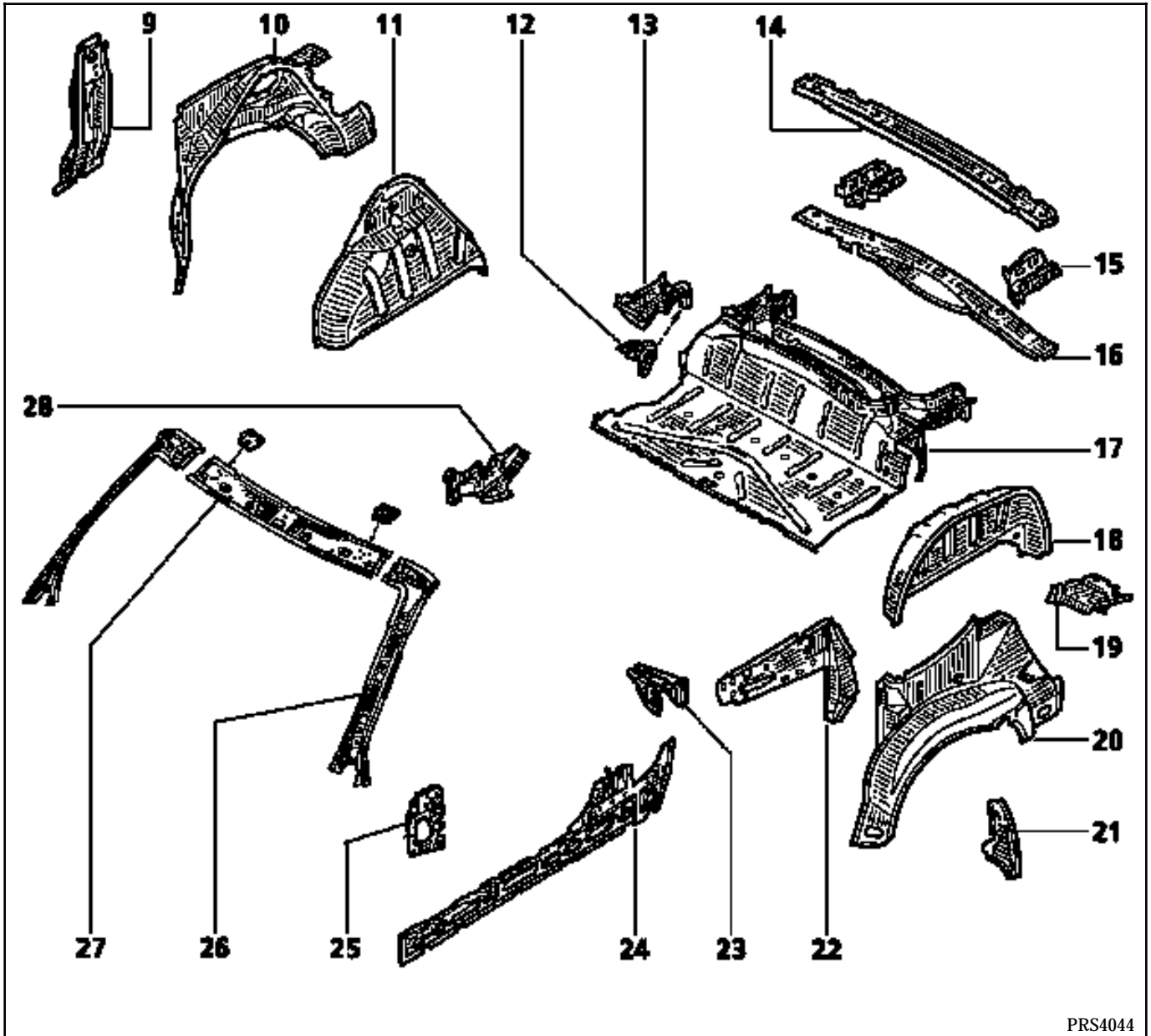
PRS4043

- 1 Windscreen frame
- 2 Hood cover lid (composite)
- 3 Rear end panel assembly
- 4 Lights bracket
- 5 Rear wing panel
- 6 Sill panel
- 7 "A" post assembly
- 8 Front jacking pad

GENERAL

Description of parts

40



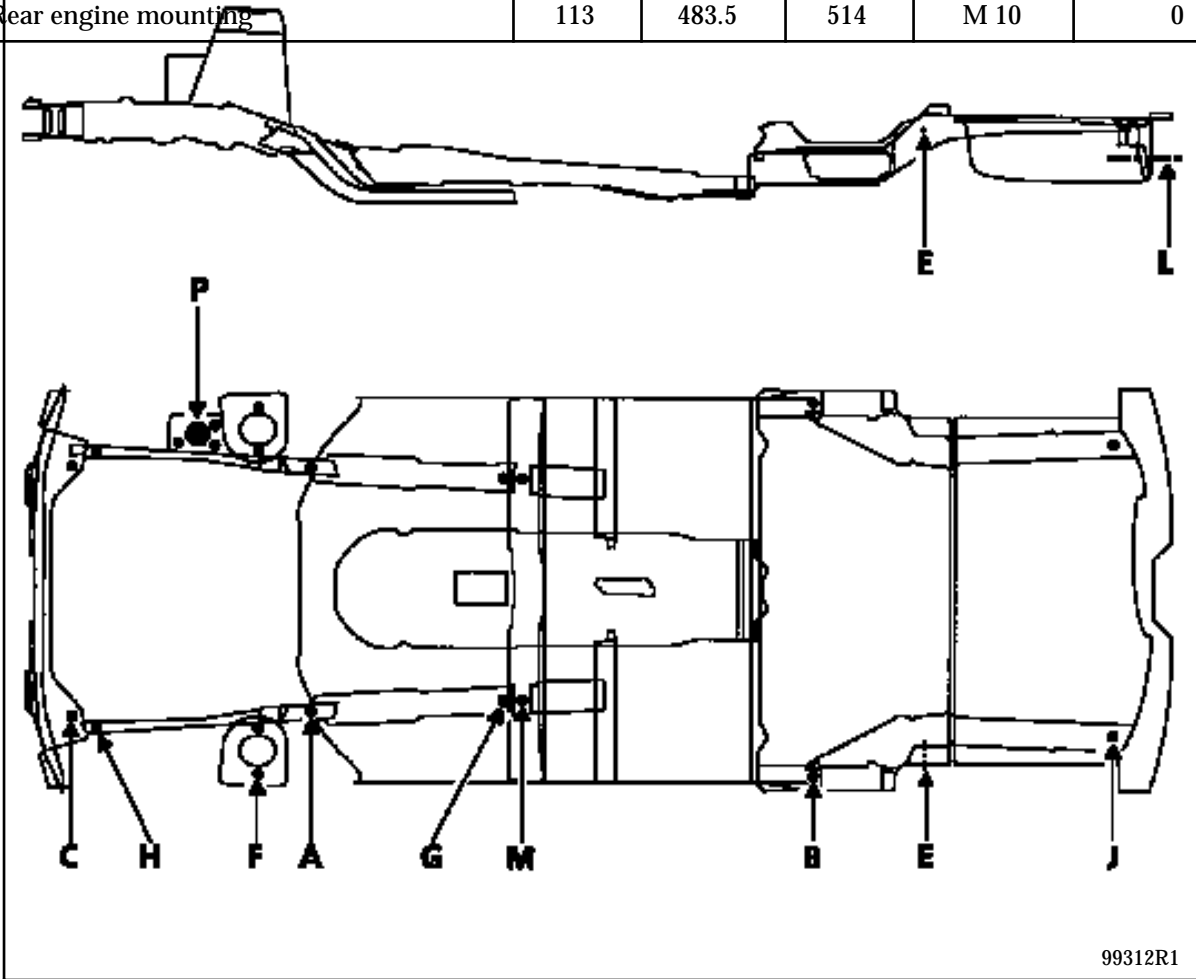
PRS4044

- | | | | |
|----|---------------------------------|----|---------------------------------|
| 9 | Post finisher | 19 | Hydraulic pump bracket |
| 10 | Right-hand panel finisher | 20 | Left-hand panel finisher |
| 11 | Interior right-hand wheel arch | 21 | Wing panel closing device |
| 12 | Lights bracket strengthener | 22 | Wing panel upper finisher |
| 13 | Wing panel drip moulding | 23 | "B" post strengthener |
| 14 | Upper rear floor extender | 24 | Door sill stiffener |
| 15 | Side member extender | 25 | "A" post trim strengthener |
| 16 | Lower rear floor extender | 26 | Frame upright finisher |
| 17 | Hood compartment rear partition | 27 | Windscreen frame crossmember |
| 18 | Interior left-hand wheel arch | 28 | Seat belt mounting strengthener |

GENERAL
Sub-frame dimensions

40

	DESCRIPTION	DIMENSION X	DIMENSION Y	DIMENSION Z	DIAMETER	SLOPE
A	Front sub-frame rear mounting	203	402.5	71	M 12	0
B	Rear axle front mounting	1966	634.12	70	M 12	0
C	Front sub-frame front mounting	- 593	412	237.5	M 10	0
E	Rear shock absorber upper mounting	2194	503.2 (65)	259	M 14	y: 90°
F	Front shock absorber upper mounting (interior)	15.7	477.8	636.7	8.5	x: 3°45' ; y: 7°
	Front shock absorber upper mounting (exterior)	5.5	610.8	654.2	8.5	x: 3°45' ; y: 7°
G	Front side member rear end	880	369	7	18.5	x: 1°
H	Front side member front end	- 547.5	467.4	236.5	10.2 x 12.2	0
J	Rear side member rear end G	2826	484.6	231	12.2	0
	Rear side member rear end D	2788	483	231	14.5	0
L	Extreme rear crossmember (skirt) G	2937	394.5	170	14.25	x: 90° ; y: 10°15'
	Extreme rear crossmember (skirt) D	2916	397	170	14.25	x: 90° ; y: 12°30'
M	Crossmember under the central floor	937	375	1.5	14.5	0
	Front engine mounting	247	483.5	514	M 10	0
	Rear engine mounting	113	483.5	514	M 10	0



99312R1

INTRODUCTION

The central floor of the E64 vehicle is identical to that of the B64 and about the same length. The E64 part can be obtained from the B64 part by cutting the rear section by 112 mm as shown on the diagram below.

The complete changing of this part is a basic operation to be carried out in the event of an impact underneath the vehicle when coming off the road.

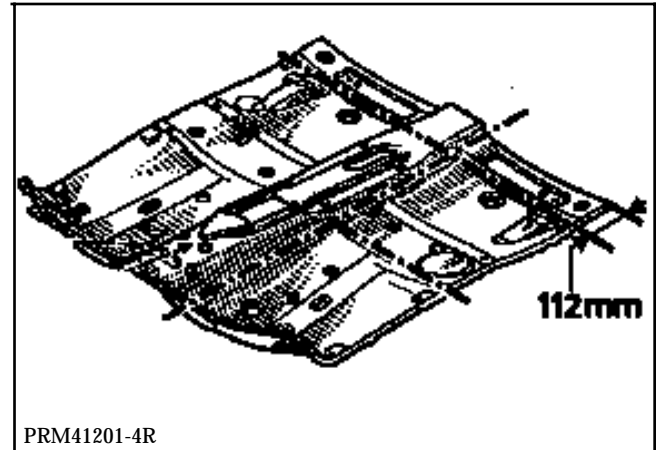
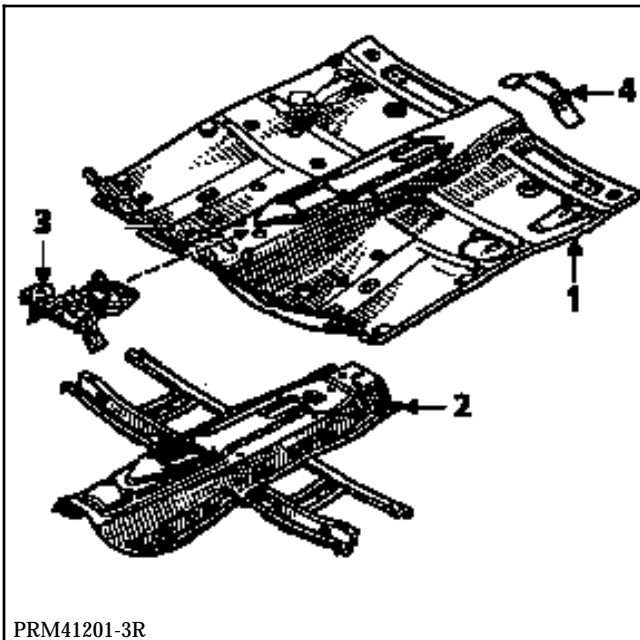
In this case, these additional parts must be ordered:

- the tunnel strengthener assembly,
- the instrument panel console bracket and sheath end.

This part can be partially changed by cutting as described in the following pages in the event of a side impact in addition to a sill panel or an "A" post.

COMPOSITION OF PART

- 1 Central floor
- 2 Tunnel strengthener
- 3 Console bracket
- 4 Sheath end

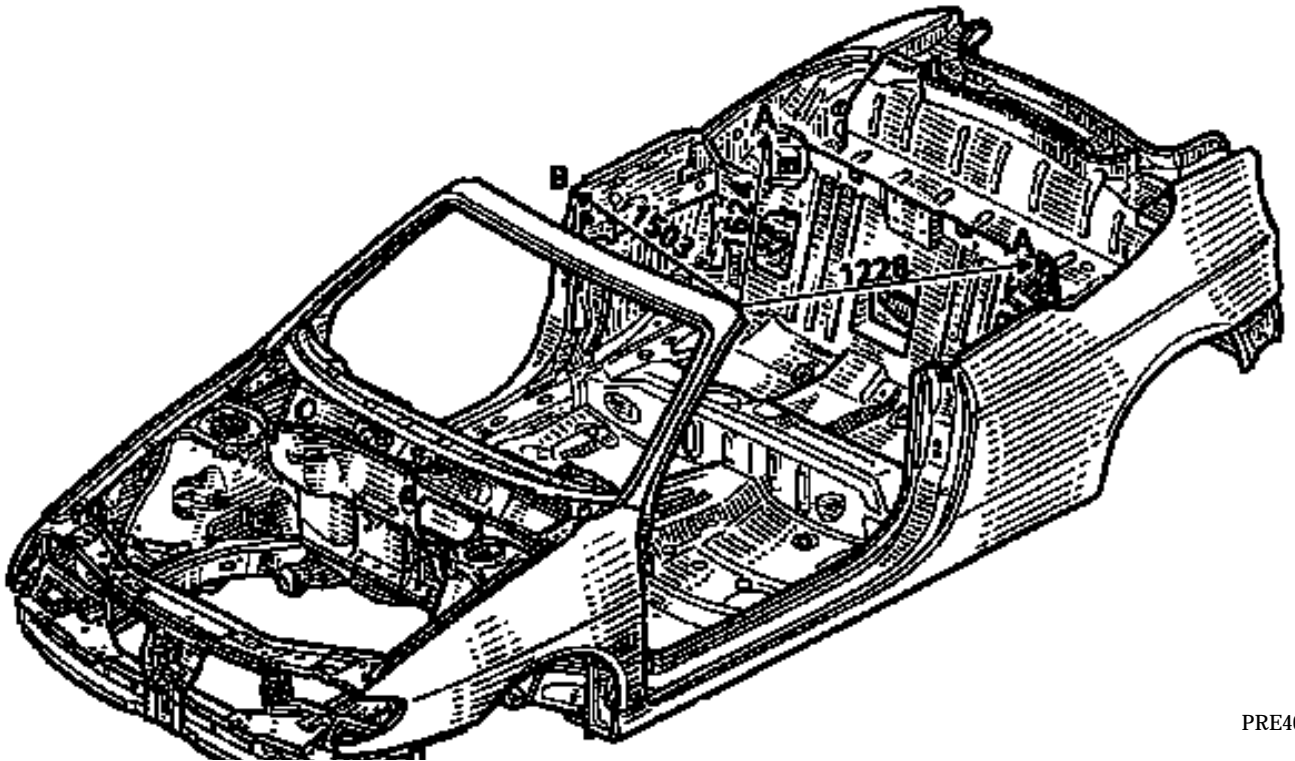


GENERAL

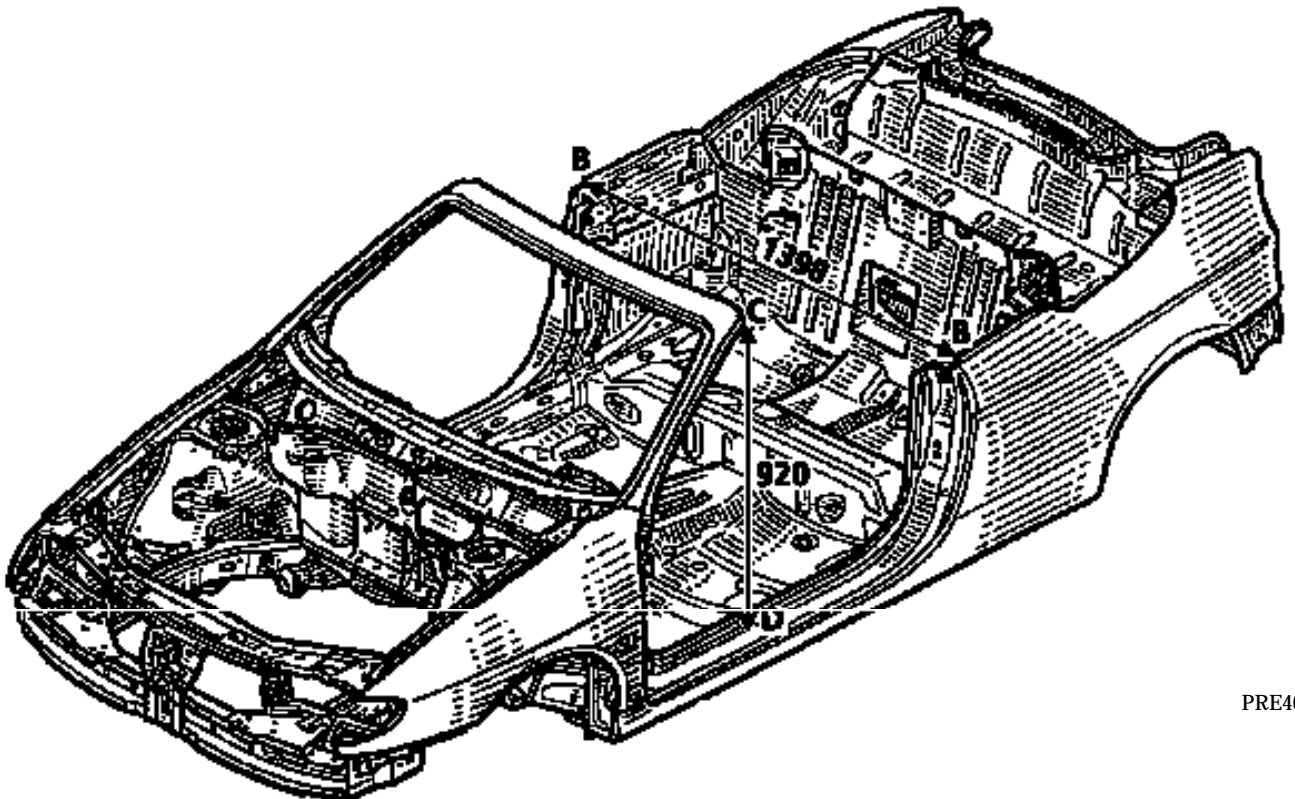
Main bodywork dimensions

40

NOTE: these dimensions are measured in the centreline of the various welded nuts.



PRE4001

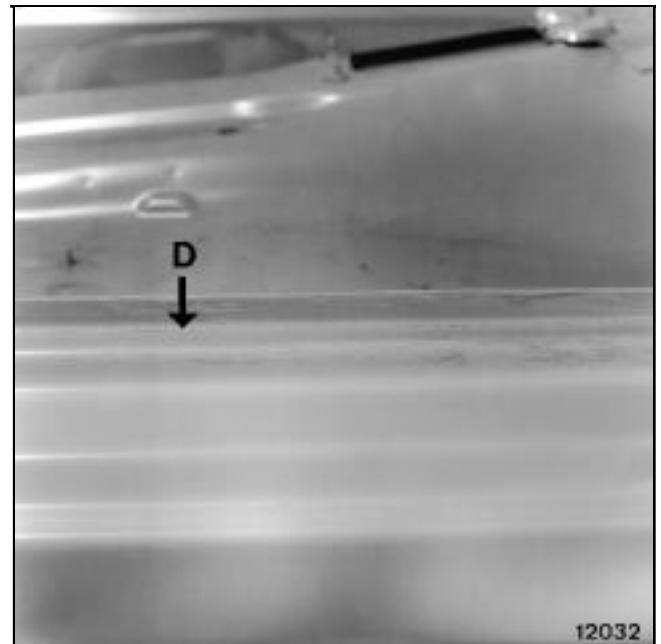
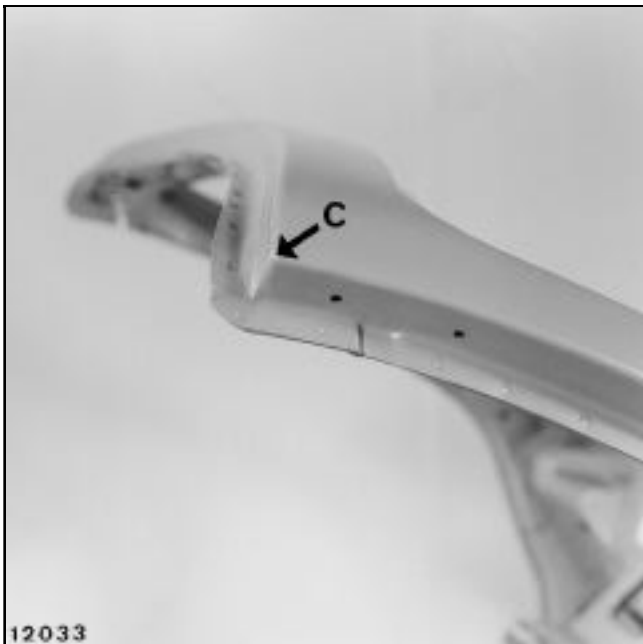
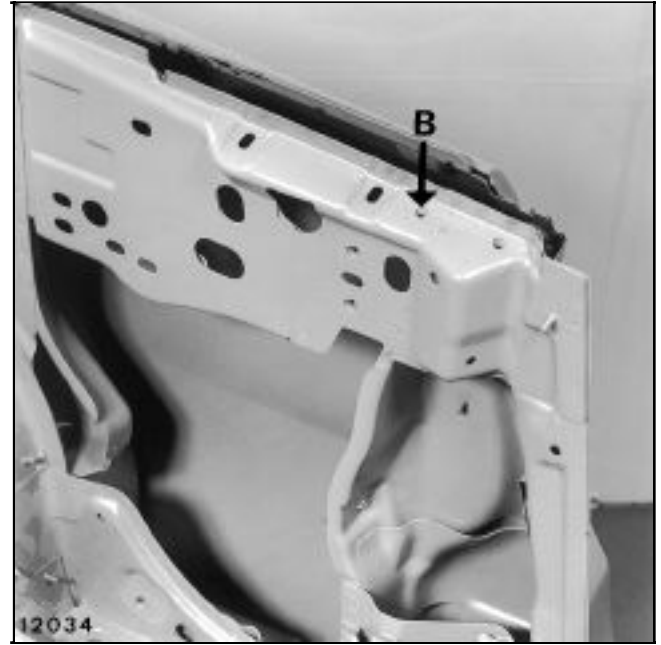
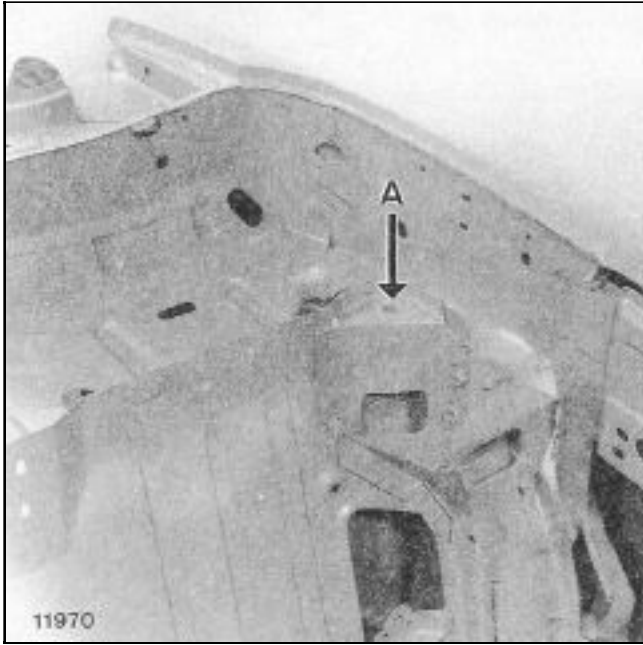


PRE4002

GENERAL

Main bodywork dimensions

40

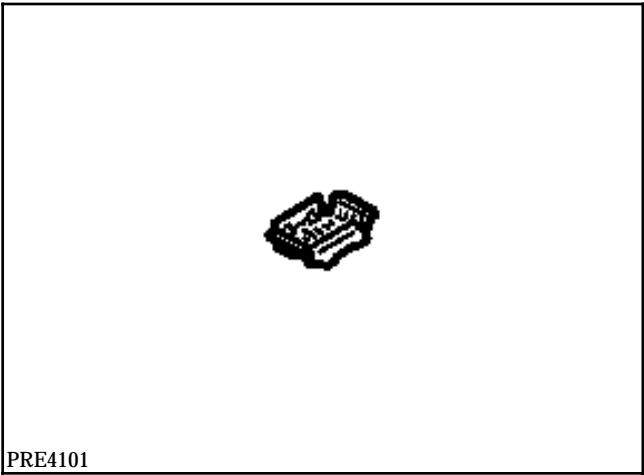


INTRODUCTION

The changing of this part is an additional operation to the changing of the front side crossmember.

COMPOSITION OF THE REPLACEMENT PART

Part only.



1 CONNECTION TO THE FRONT SIDE CROSSMEMBER

Thickness of the panels concerned (mm)

Front jacking pad	2.5
Side crossmember	1

Unpicking



3 MAG weld seams
30 mm long

Welding

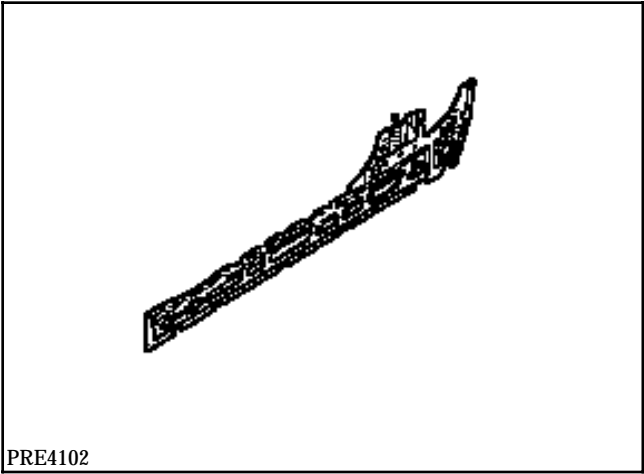


INTRODUCTION

The changing of this part is an additional operation to the changing of an "A" post or a sill panel in the event of a side collision.

COMPOSITION OF THE REPLACEMENT PART

Complete part with reel.



1 CONNECTION TO SILL PANEL CLOSER

Thickness of the panels concerned (mm)

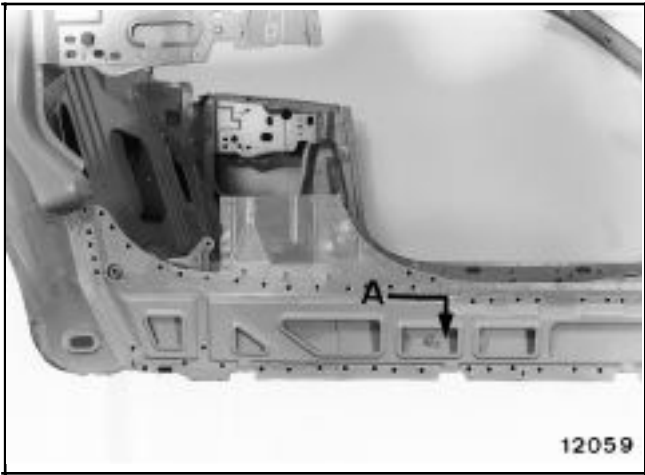
Sill panel stiffener	1.5
Sill panel closer	1.8

Unpicking

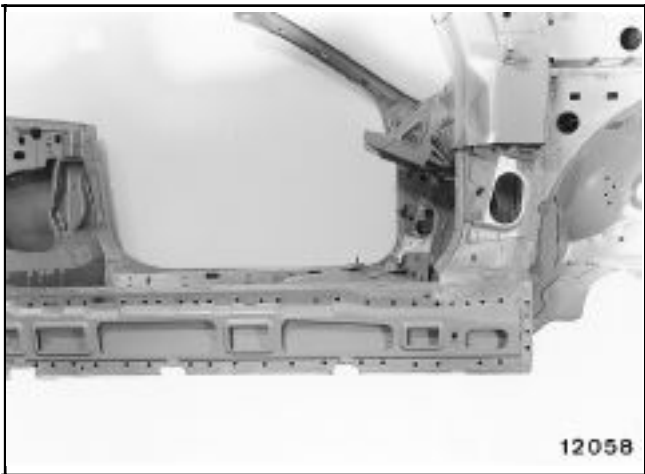


77 spot welds on 1.5 mm thickness

Welding



NOTE: at (A), welding of 3 thicknesses.

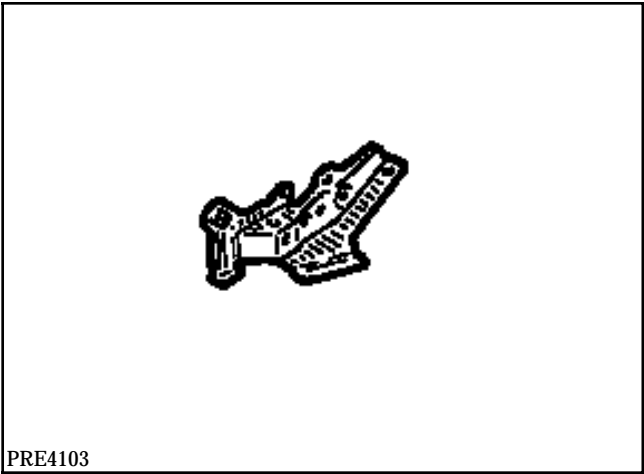


INTRODUCTION

The changing of this part is an additional operation to the changing of the front section of the rear floor.

COMPOSITION OF THE REPLACEMENT PART

Part only.



1 CONNECTION TO THE FRONT SECTION OF THE REAR FLOOR

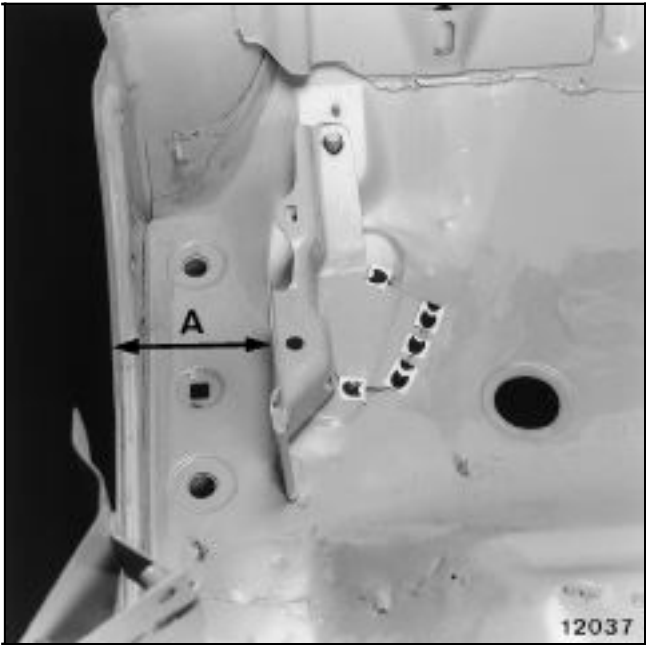
Thickness of the panels concerned (mm)

Mounting strengthener	2
Front section of rear floor	0.7

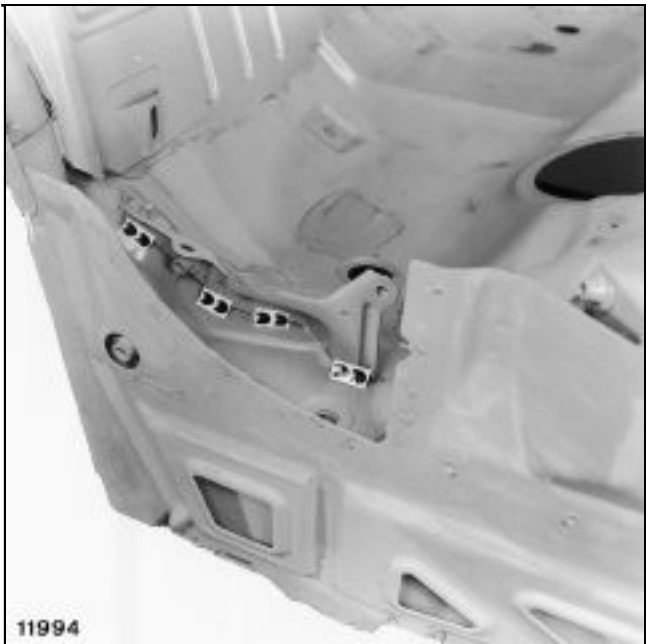
Unpicking

- 4 MAG weld seams 20 mm long
- 2 MAG weld seams 15 mm long
- 3 MAG weld seams 10 mm long

Welding



A = 90 mm



LOWER STRUCTURE

Extreme rear crossmember

41 D

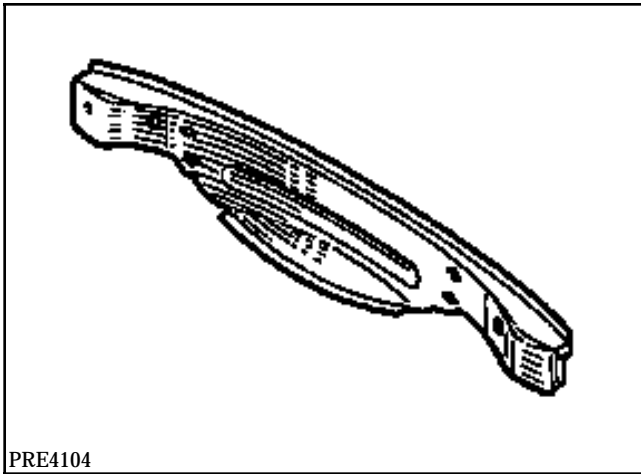
INTRODUCTION

The changing of this part is an additional operation to the changing of a rear end panel assembly.

The edge of the rear panel must be folded back.

COMPOSITION OF THE REPLACEMENT PART

Part only.



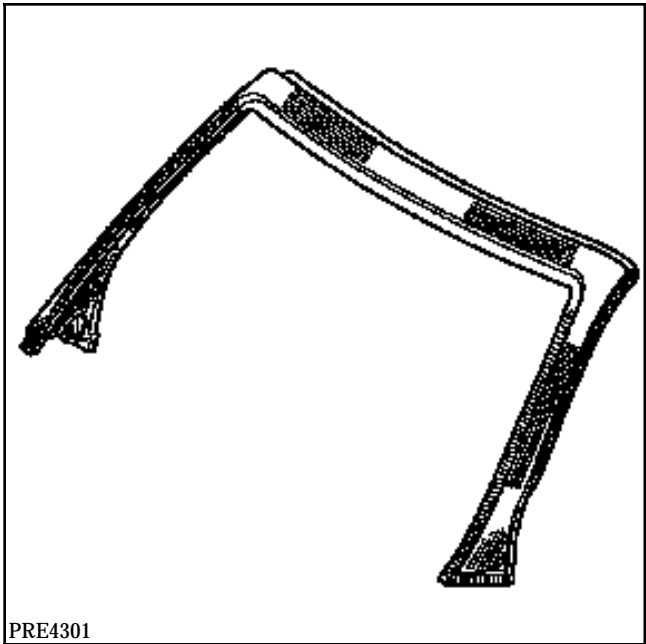
INTRODUCTION

The changing of this part is a basic operation to be carried out in the event of a side collision or rollover.

This part is partially changed in addition to changing of the "A" post.

COMPOSITION OF THE REPLACEMENT PART

Part only.



1 CONNECTION TO THE "A" POST

Thickness of the panels concerned (mm)

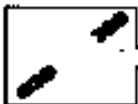
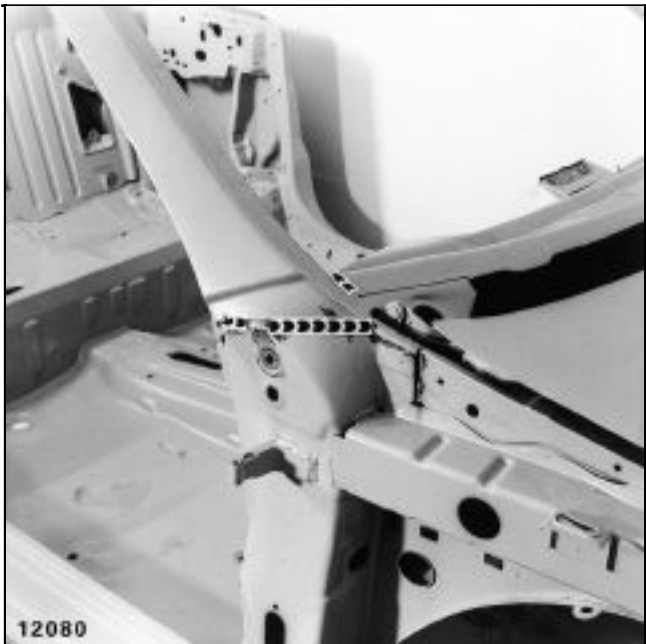
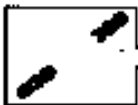
Frame	1.5
"A" post	1.25

Unpicking



- 1 MAG weld seam 90 mm long
- 4 MAG weld seams 30 mm long
- 1 MAG weld seam 20 mm long

Welding



2 CONNECTION TO THE FRAME UPRIGHT
FINISHER

Thickness of the panels concerned (mm)

Opening frame	1.5
Opening finisher	2
Strengthening securing connecting arch	1

Unpicking



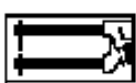
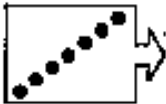
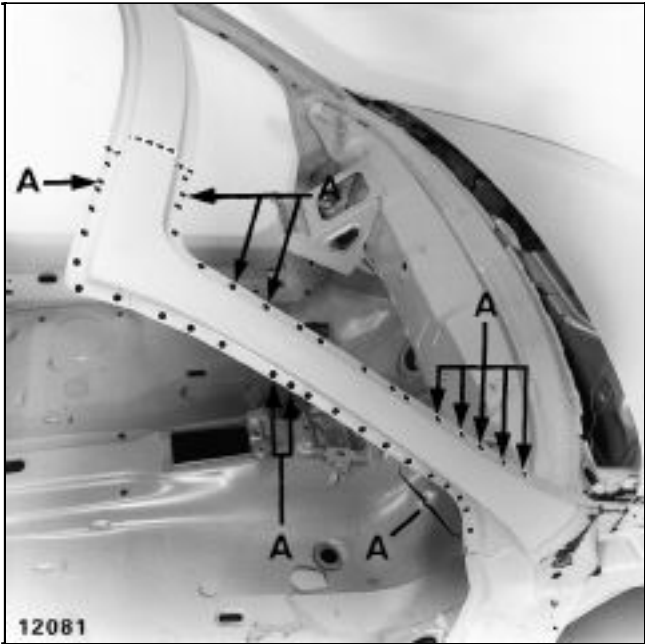
112 spot welds 1.5 mm panel thickness
2 MAG weld seams 45 mm long

Partial cut off



150 mm on 1.5 mm thickness

Welding



NOTE: at (A), welding of 3 thicknesses.

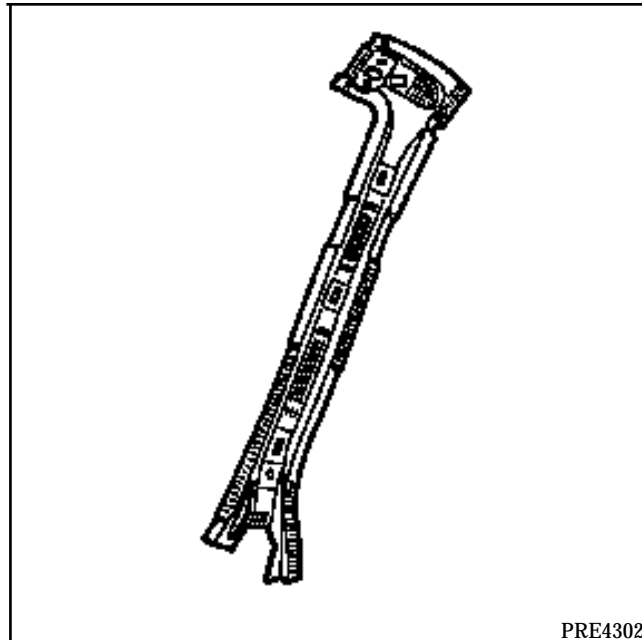
INTRODUCTION

The changing of this part is an additional operation to the changing of the "A" post and the windscreen frame.

For safety reasons, the finisher must not be cut.

COMPOSITION OF THE REPLACEMENT PART

Part only.




1 CONNECTION TO THE OPENING LOWER
CROSSMEMBER

Thickness of the panels concerned (mm)

Opening finisher	2
Lower crossmember	1.2

Unpicking



2 MAG weld seams 30 mm long
2 MAG weld seams 20 mm long

Welding




2 CONNECTION TO THE OPENING UPPER
CROSSMEMBER

Thickness of the panels concerned (mm)

Opening finisher	2
Upper crossmember	0.9

Unpicking



2 spot welds on
2 mm thickness

Welding



INTRODUCTION

The replacement of this part is a basic operation to be carried out in the event of a front side collision.

It is obtained by cutting the sill panel observing the dimensions.

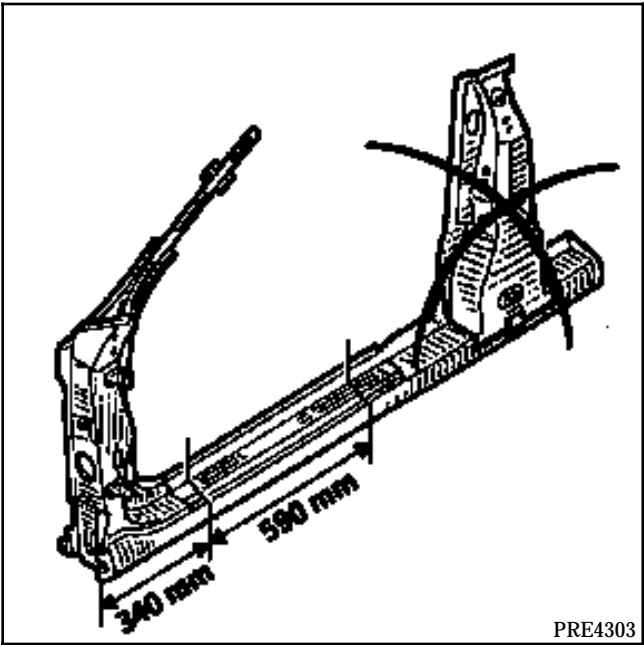
For reasons of stability, the strengthener must not be cut.

COMPOSITION OF THE REPLACEMENT PART

Complete part including:

- "A" post,
- "A" post upper finisher,
- strengthener tube,
- "B" post finisher,
- sill panel,
- "B" post finisher strengthener,
- sill panel blanking piece.

NOTE: it is possible to change just the "A" post .
The sill panel must be unpicked.



1 CONNECTION TO THE SILL PANEL CLOSING PLATE

Thickness of the panels concerned (mm)

Sill panel	2
Sill panel stiffener	1.5
Sill panel closer	1.8

Unpicking

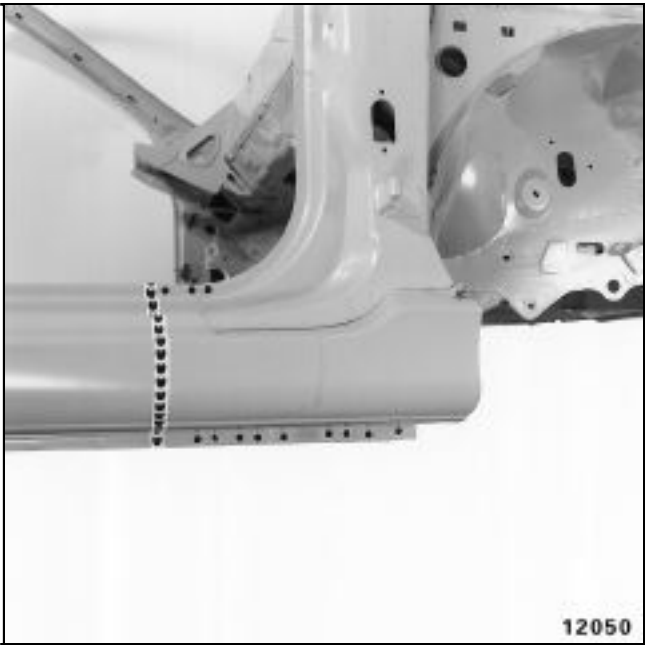


14 spot welds on 2 mm thickness



345 mm on 2 mm thickness

Welding



NOTE: welding of 3 thicknesses.



2 CONNECTION TO THE OPENING FINISHER

Thickness of the panels concerned (mm)

Post upper finisher	1.25
Strengthenener securing connecting arch	1
Opening finisher	2

Unpicking



12 spot welds on 1.25 mm thickness
4 spot welds on 1mm thickness

Welding



NOTE: welding of 3 thicknesses.



NOTE: at (A), welding of 3 thicknesses.

3 CONNECTION TO THE POST FINISHER
(SCUTTLE SIDE)

Thickness of the panels concerned (mm)

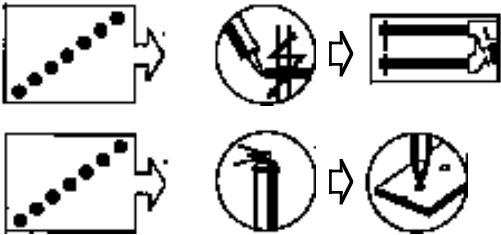
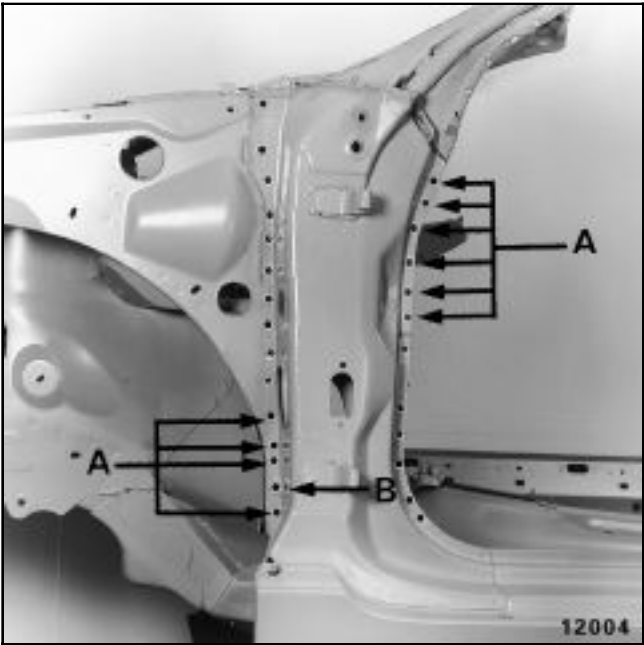
"A" post	1.5
Post finisher	1.2
Sill panel	2

Unpicking



27 spot welds on 1.5mm thickness
3 MAG plug welds

Welding



NOTE: at (A), welding of 3 thicknesses
at (B), welding of 4 thicknesses

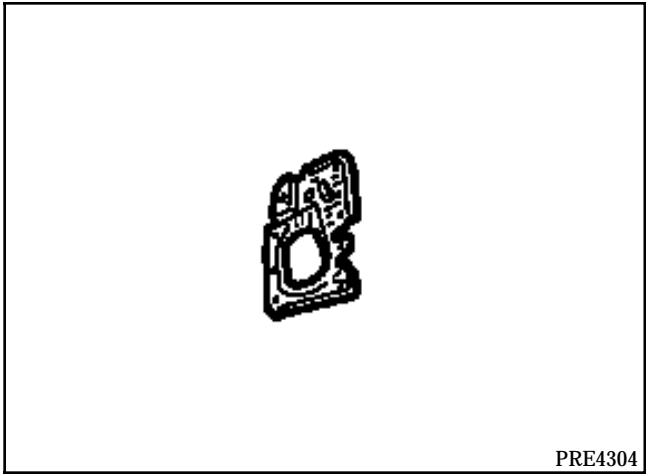


INTRODUCTION

The changing of this part is an additional operation to the changing of the "A" post finisher.

COMPOSITION OF THE REPLACEMENT PART

Part only.



1 CONNECTION TO THE "A" POST FINISHER
(SCUTTLE SIDE)

Thickness of the panels concerned (mm)

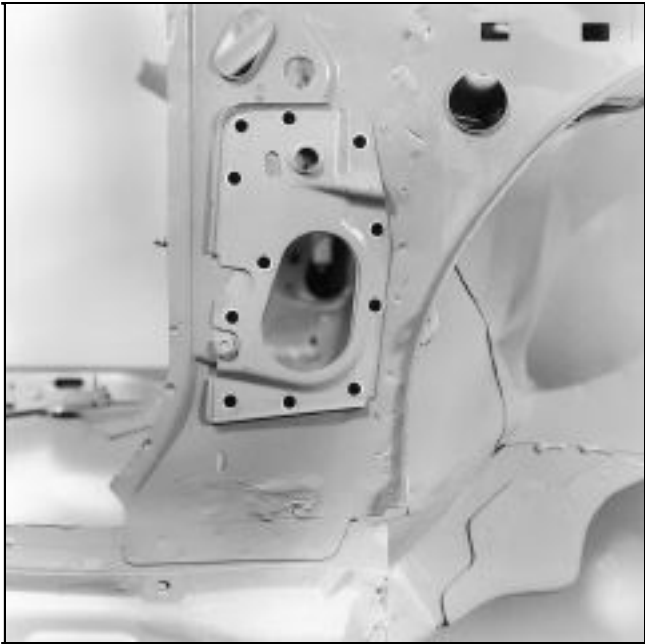
Finisher strengthener	1.5
Post finisher	1.2

Unpicking



11 spot welds on 1.5 mm thickness

Welding



UPPER SIDE STRUCTURE

"A" post finisher (scuttle side)

43 E

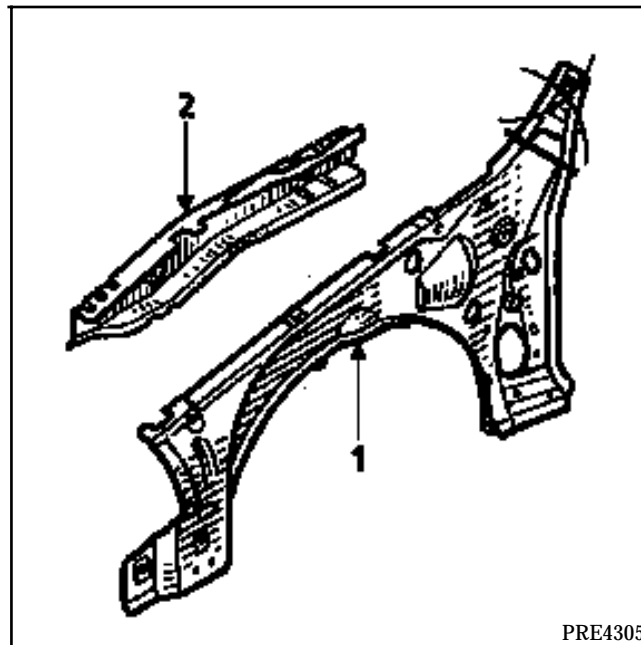
INTRODUCTION

The design of the vehicle is such that the scuttle side and the "A" post finisher are in one piece. Also, when one of these parts is changed, the part supplied by the Parts Department has to be partially cut.

The changing of this part is an additional operation to changing of the "A" post. On the right-hand side, the scuttle side upper strengthener, which must be ordered separately, must also be changed.

COMPOSITION OF THE REPLACEMENT PART

- 1 Scuttle side ("A" post finisher)
- 2 Scuttle side upper strengthener

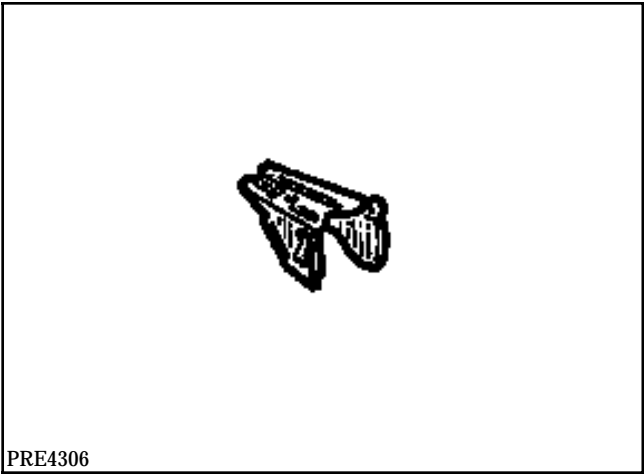


INTRODUCTION

The changing of this part is an additional operation to the changing of the wing panel.

COMPOSITION OF THE REPLACEMENT PART

Part only.



1 CONNECTION TO THE SILL PANEL CLOSER

Thickness of the panels concerned (mm)

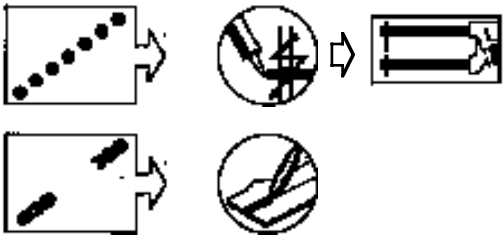
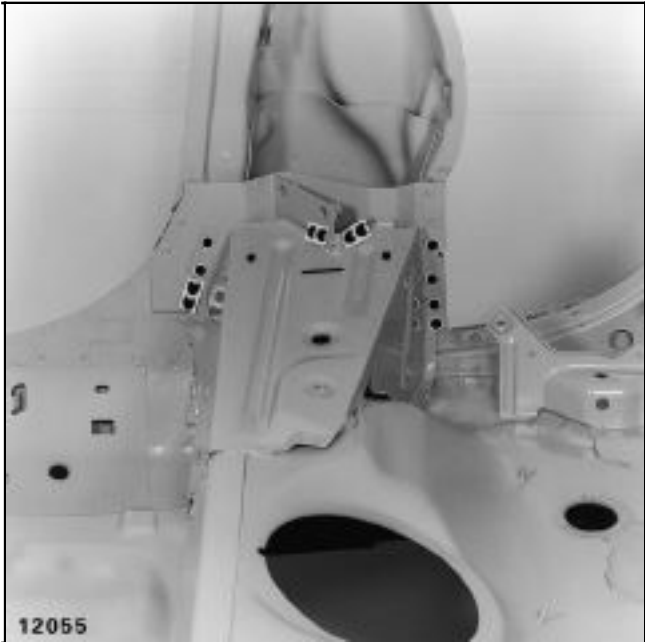
Post finisher	1.5
Sill panel closer	1.5

Unpicking



6 spot welds on 1.5 mm thickness
3 MAG weld seams 20 mm long

Welding



NOTE: welding of 3 thicknesses

UPPER SIDE STRUCTURE "B" post strengthener

43 F

2 CONNECTION TO THE FRONT SECTION OF THE REAR FLOOR

Thickness of the panels concerned (mm)

Post finisher	1.5
Rear floor	0.7

Unpicking

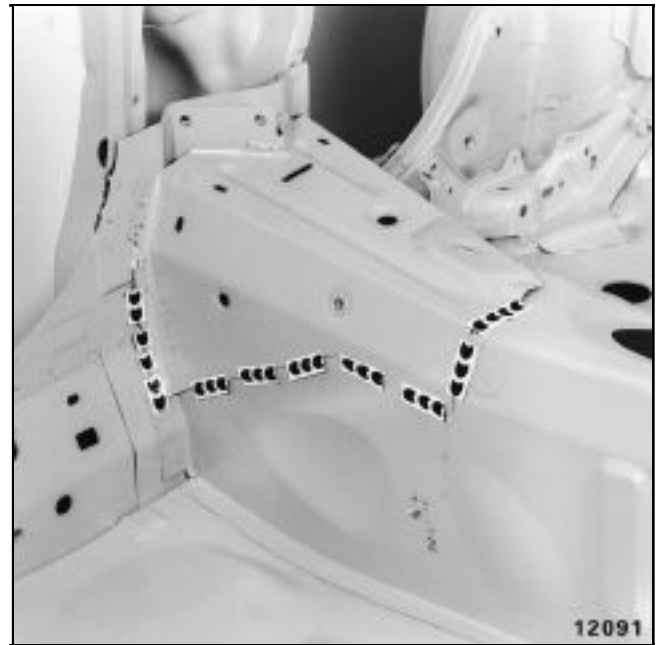
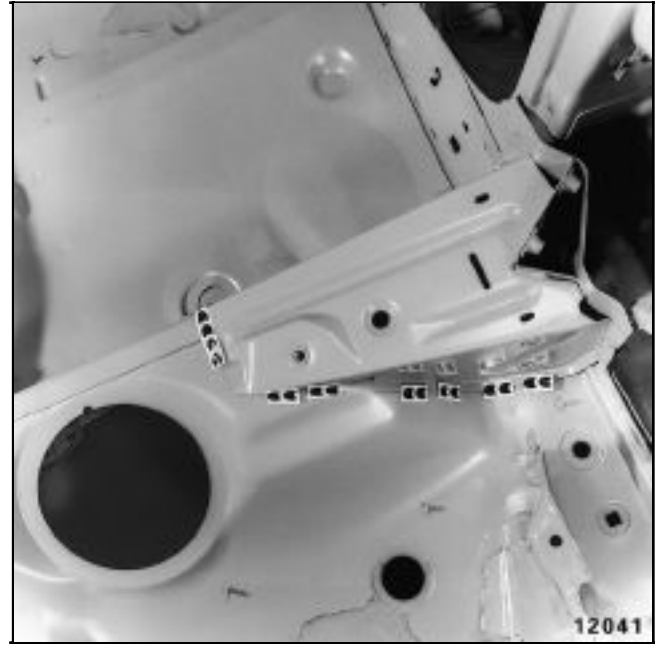
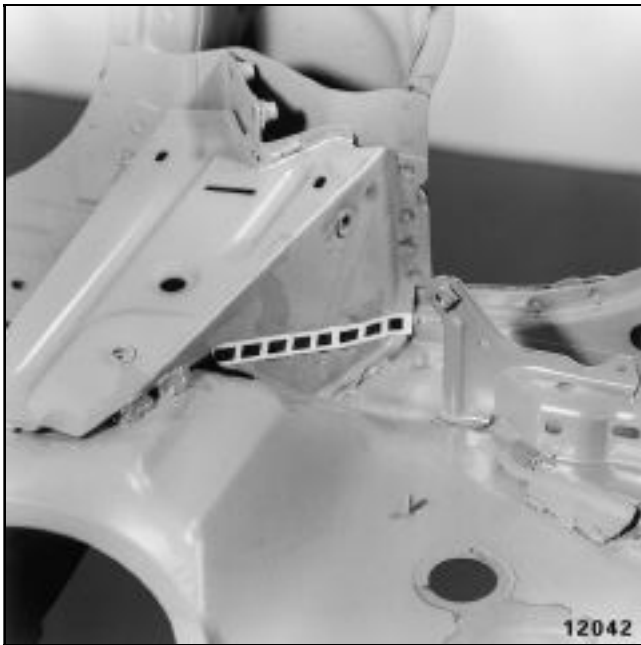


17 MAG weld seams 40 mm long
10 MAG weld seams 30 mm long
4 MAG weld seams 20 mm long
2 MAG weld seams 10 mm long



200 mm at 1.5 mm thickness

Welding



INTRODUCTION

The changing of this part is an additional operation to the changing of the wing panel.

To maintain stiffness, the strengthener must not be cut.

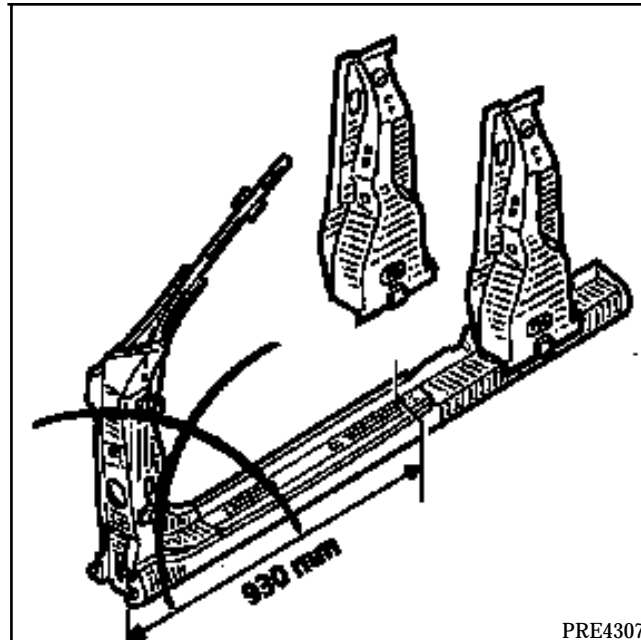
NOTE: the "B" post strengthener must be removed in order to gain access to the interior spot welds.

It is possible to change just the "B" post finisher.

COMPOSITION OF THE REPLACEMENT PART

Complete part including:

- "A" post,
- "B" post finisher finisher,
- sill panel,
- "B" post finisher strengthener,
- sill panel blanking piece,
- "A" post upper finisher,
- strengthener tube.



1 CONNECTION TO THE PANEL FRONT UPPER FINISHER ASSEMBLY

Thickness of the panels concerned (mm)

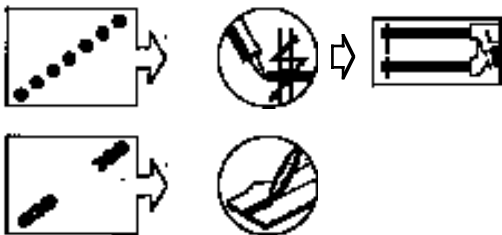
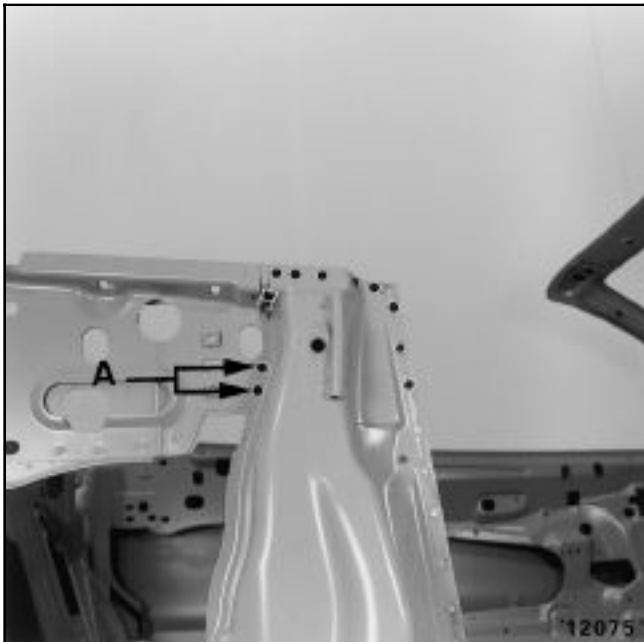
Post finisher	1.5
Upper finisher	1.5

Unpicking



10 spot welds on 1.5 mm thickness
1 MAG weld seam 15 mm long

Welding



NOTE: at (A), welding of 3 thicknesses.

2 CONNECTION TO THE PANEL REAR FINISHER

Thickness of the panels concerned (mm)

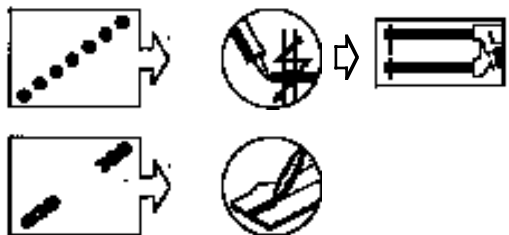
Sill panel	2
Rear finisher	0.9

Unpicking



8 spot welds on 2 mm thickness
1 MAG weld seam 20 mm long

Welding



3 CONNECTION TO THE SILL PANEL STIFFENER

Thickness of the panels concerned (mm)

Sill panel	2
Sill panel stiffener	1.5
Sill panel closer	1.8

Unpicking



35 spot welds on 2 mm thickness

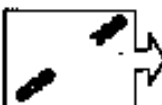
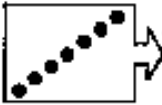
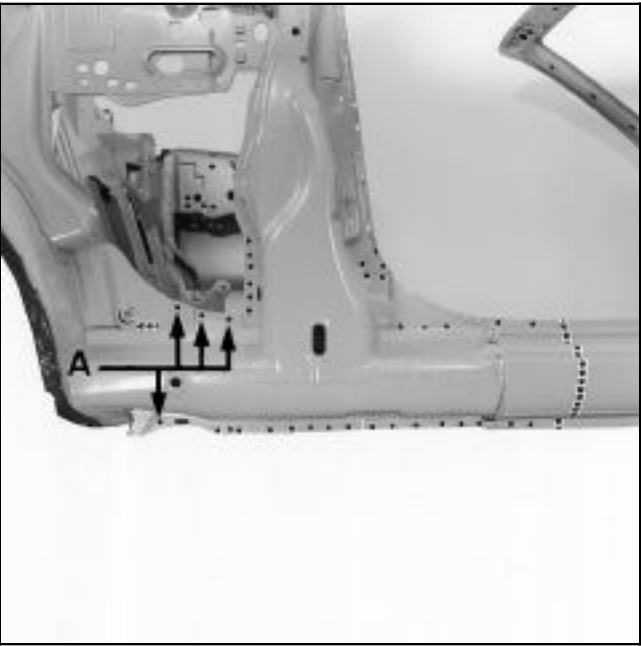


3 spot welds on 1.5 mm thickness

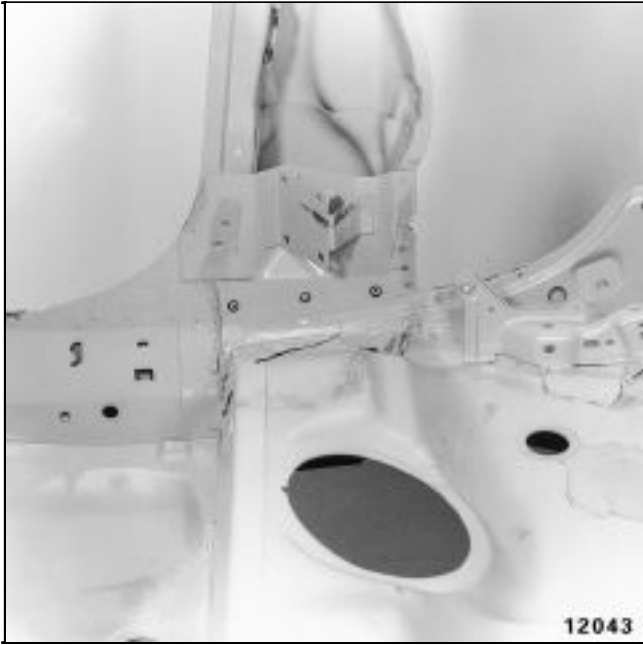


345 mm at 2 mm thickness

Welding



NOTE: at (A), welding of 3 thicknesses.



NOTE: welding of 3 thicknesses

1 CONNECTION TO THE PANEL FRONT UPPER FINISHER ASSEMBLY

Thickness of the panels concerned (mm)

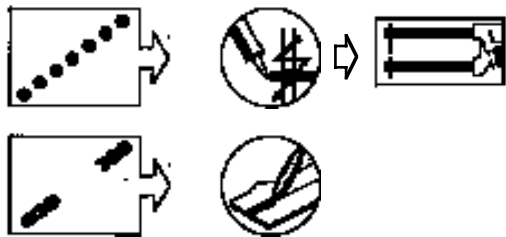
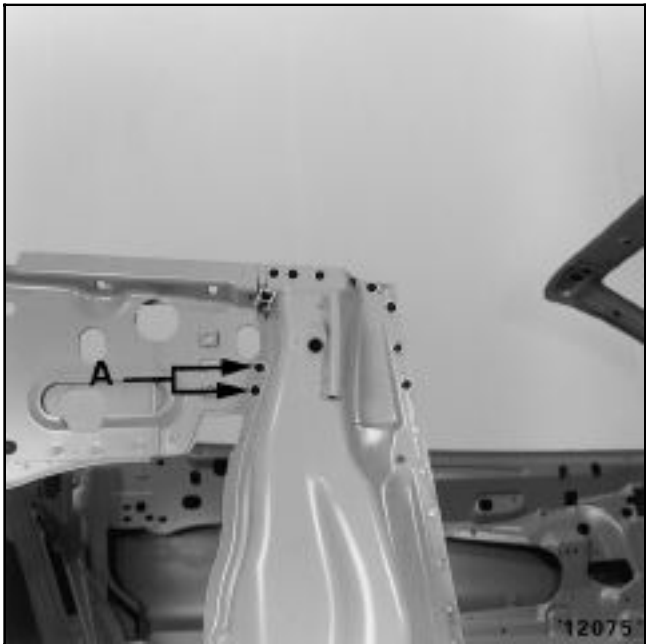
Post finisher	1.5
Upper finisher	1.5

Unpicking



10 spot welds on 1.5 mm thickness
1 MAG weld seam 15 mm long

Welding



NOTE: at (A), welding of 3 thicknesses.

2 CONNECTION TO SILL PANEL STIFFENER

Thickness of the panels concerned (mm)

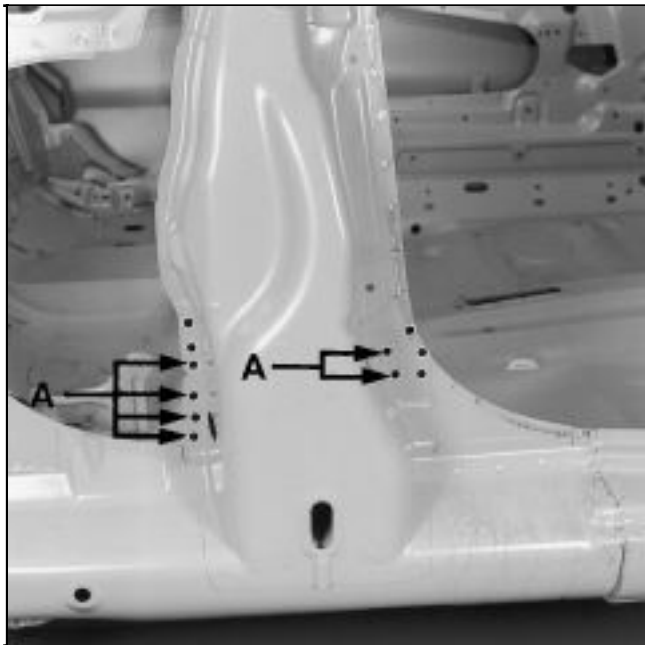
Post finisher	1.5
Sill panel stiffener	1.5

Unpicking



11 spot welds on 1.5 mm thickness

Welding



NOTE: at (A), welding of 3 thicknesses.

3 CONNECTION TO THE REAR SECTION OF THE
SILL PANEL

Thickness of the panels concerned (mm)

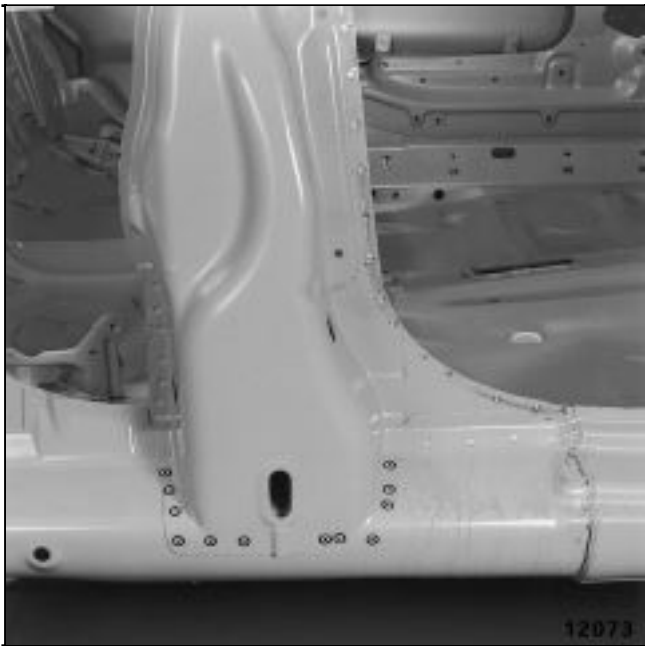
Post finisher	1.5
Sill panel	2

Unpicking



12 spot welds on 1.5 mm thickness

Welding



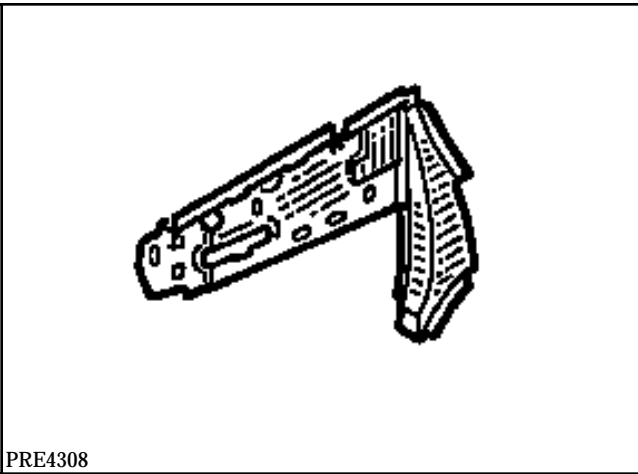
INTRODUCTION

The changing of this part is an additional operation to the changing of:

- side panel,
- "B" post finisher,
- side panel finisher.

COMPOSITION OF THE REPLACEMENT PART

Complete part including stiffener.



1 CONNECTION TO THE "B" POST FINISHER

Thickness of the panels concerned (mm)

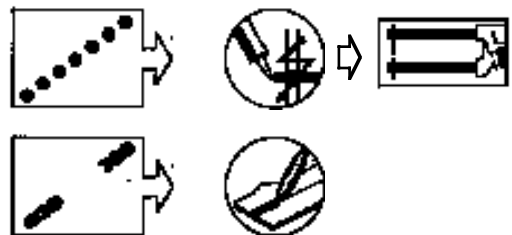
Upper finisher	1,5
Post finisher	1,5

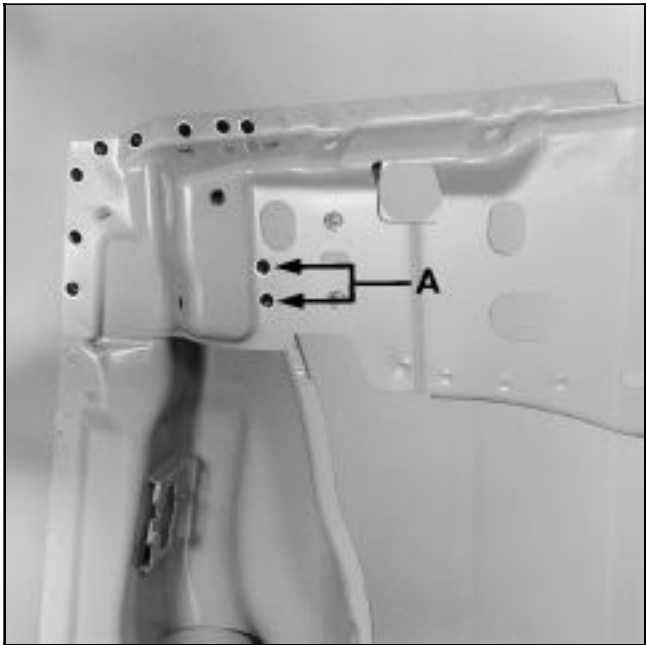
Unpicking



10 spot welds on 1.5 mm thickness
1 MAG weld seam 15 mm long

Welding





2 CONNECTION TO THE PANEL REAR FINISHER

Thickness of the panels concerned (mm)

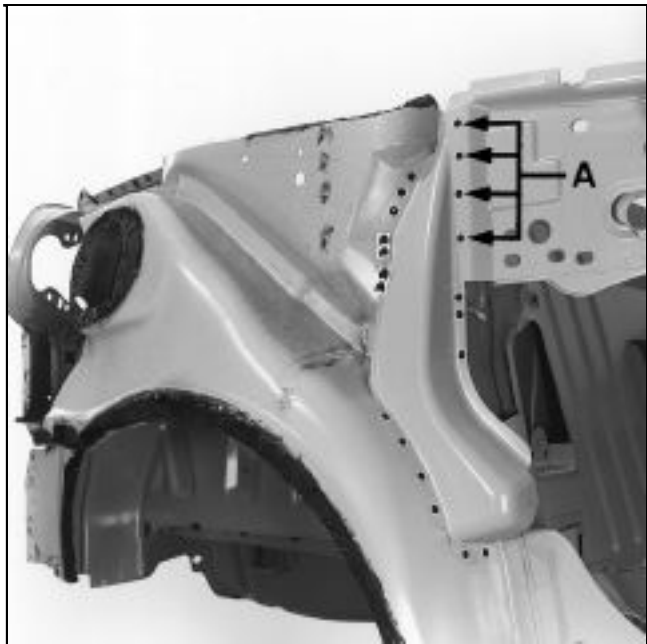
Exterior finisher panel	1,5
Interior finisher panel	1,5
Rear finisher	0,9

Unpicking

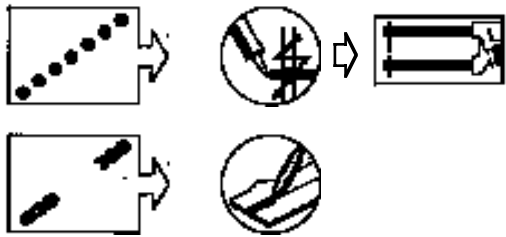


16 spot welds on 1.5 mm thickness
2 MAG weld seams 20 mm long

Welding



NOTE: at (A), welding of 3 thicknesses.



NOTE: at (A), welding of 3 thicknesses.

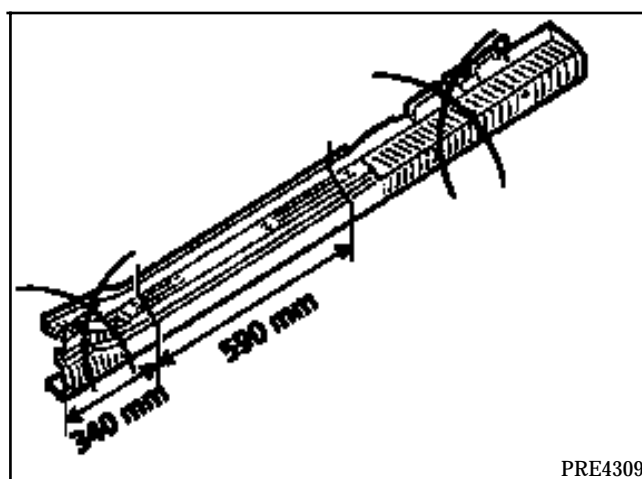
INTRODUCTION

The changing of this part is a basic operation to be carried out in the event of a side impact.

It is obtained by cutting the sill panel observing the dimensions.

COMPOSITION OF THE REPLACEMENT PART

Part only.



1 CONNECTION TO THE PARTIAL CUT OFFS

Thickness of the panels concerned (mm)

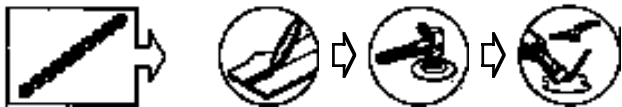
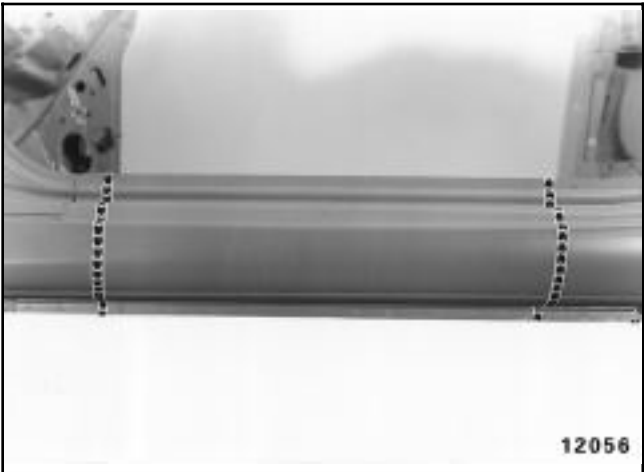
Sill panel 2

Unpicking



2 x 345 mm at 2 mm thickness

Welding



2 CONNECTION TO THE SILL PANEL CLOSER AND STIFFENER

Thickness of the panels concerned (mm)

Sill panel 2

Sill panel closer 1.8

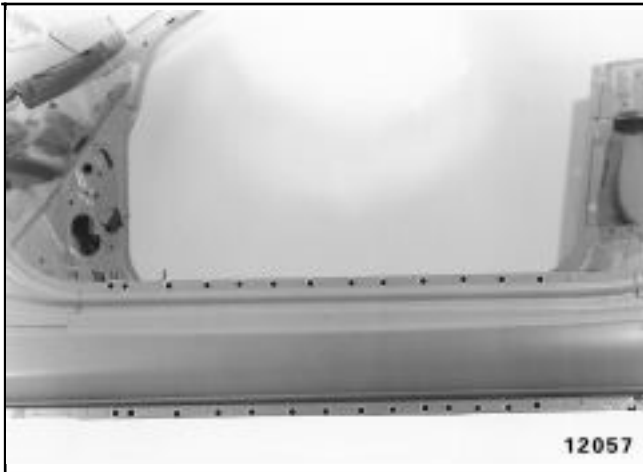
Sill panel stiffener 1.5

Unpicking



27 spot welds on 2 mm thickness

Welding

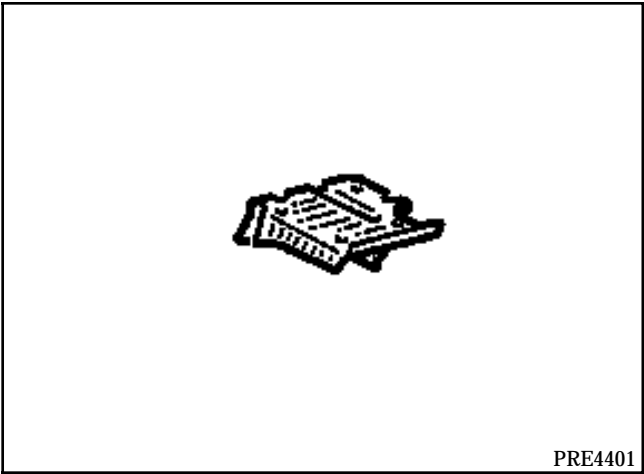


INTRODUCTION

The replacement of this part is an additional operation to the changing of the interior wheel arch.

COMPOSITION OF THE REPLACEMENT PART

Part only.



1 CONNECTION TO THE REAR WHEEL ARCH

Thickness of the panels concerned (mm)

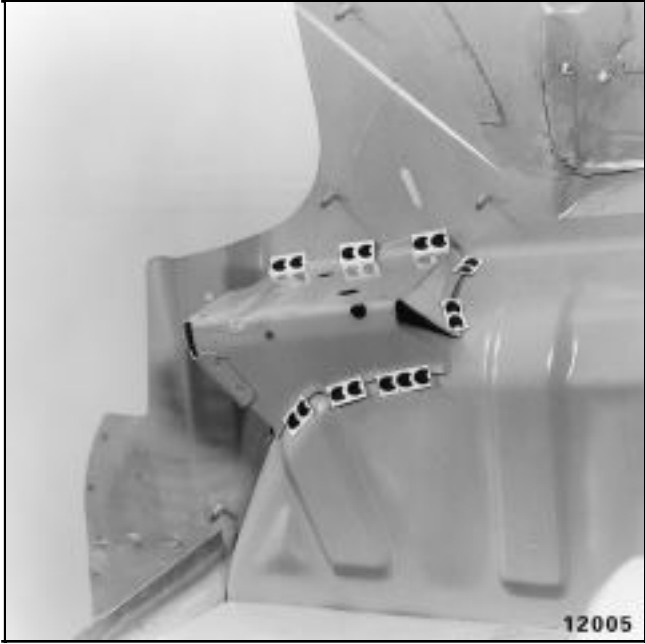
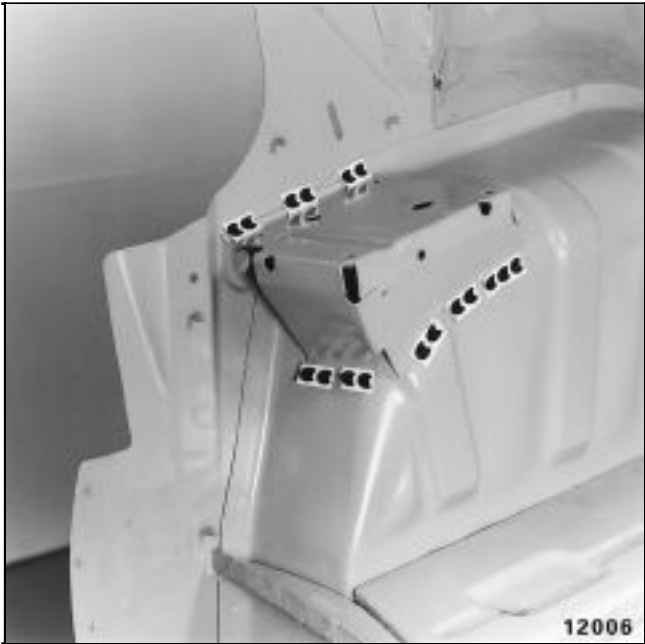
Hydraulic pump bracket 1.5

Unpicking



10 MAG weld seams 15 mm long

Welding

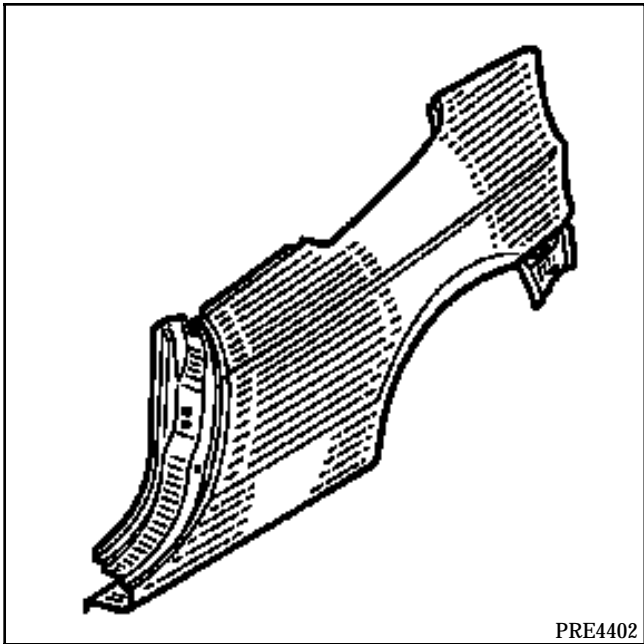


INTRODUCTION

The replacement of this part is a basic operation to be carried out in the event of a rear collision.

COMPOSITION OF THE REPLACEMENT PART

- Part including:
- bumper support plate,
 - panel stiffener.



1 CONNECTION TO THE "B" POST FINISHER

Thickness of the panels concerned (mm)

Wing panel	0.8
Post finisher	1.5
Interior finisher panel	1.5
Lower inlet side member closing plate	1.5

Unpicking

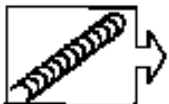
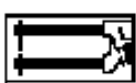
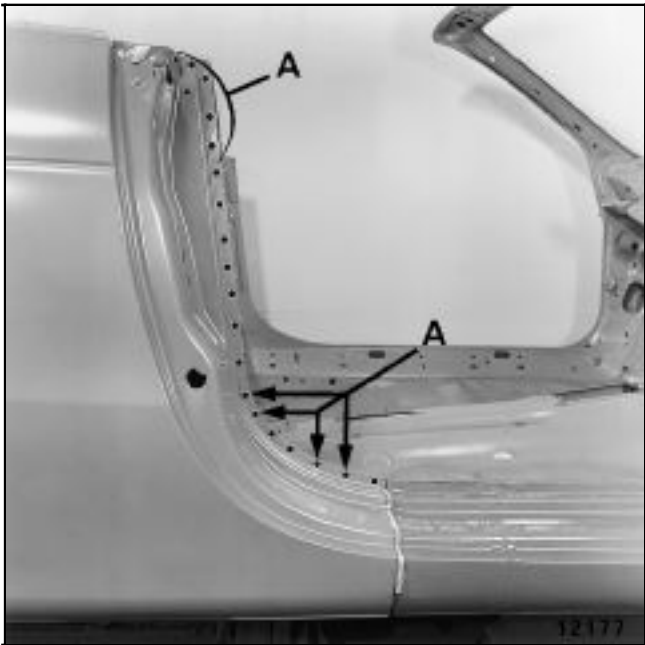


19 spot welds on 0.8 mm thickness



180 mm braze

Welding



NOTE: at (A), welding of 3 thicknesses.

2 CONNECTION TO THE LOWER EXTERIOR SIDE MEMBER

Thickness of the panels concerned (mm)

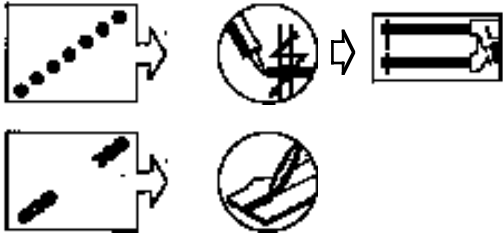
Wing panel	0.8
Sill panel	2
Sill panel stiffener	1.5

Unpicking



18 spot welds on 0.8 mm thickness
1 MAG weld seam 75 mm long

Welding



NOTE: at (A), welding of 3 thicknesses.

3 CONNECTION TO THE REAR PANEL FINISHER

Thickness of the panels concerned (mm)

Wing panel	0.8
Panel finisher	0.9
Rear end panel	0.7

Unpicking

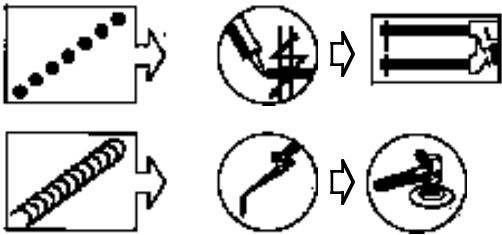
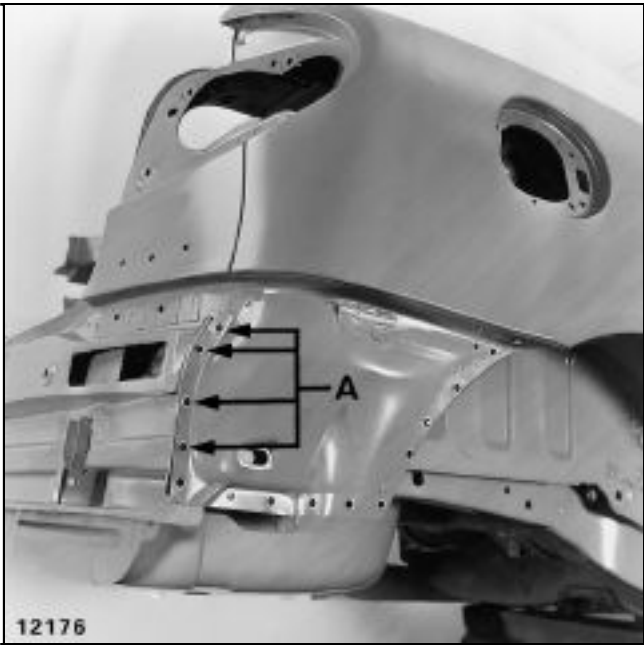


38 spot welds on 0.8 mm thickness

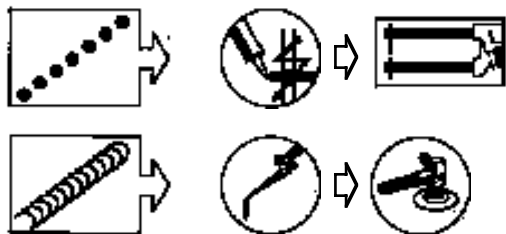
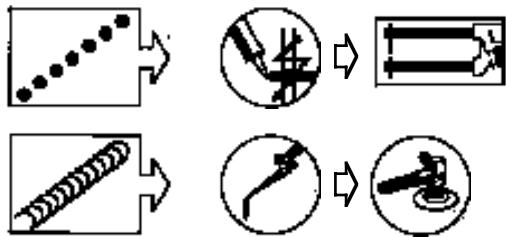
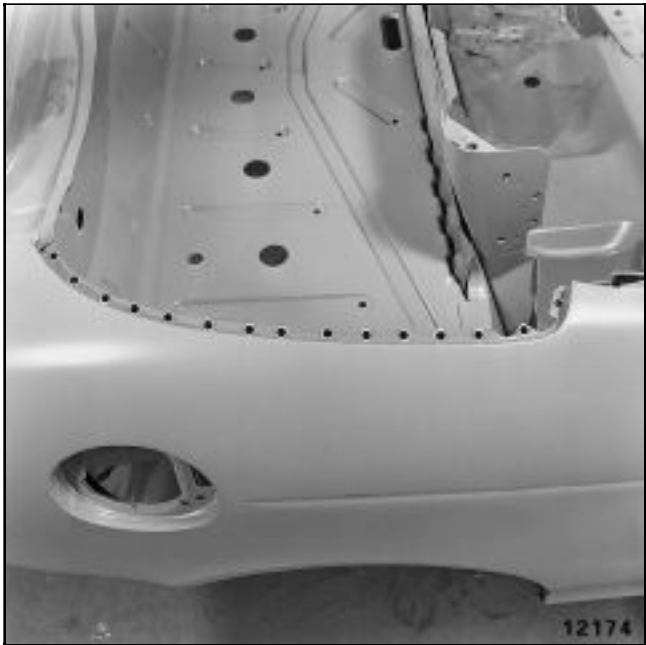


30 mm braze

Welding



NOTE: at (A), welding of 3 thicknesses.

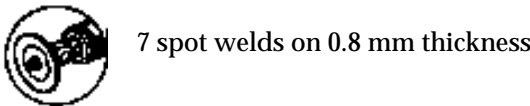


4 CONNECTION TO THE TANK FILLER NECK

Thickness of the panels concerned (mm)

Bracket	0.8
Wing panel	0.9

Unpicking



Welding



5 CONNECTION TO THE LIGHTS BRACKET

Thickness of the panels concerned (mm)

Wing panel	0.8
Lights bracket	0.7

Unpicking

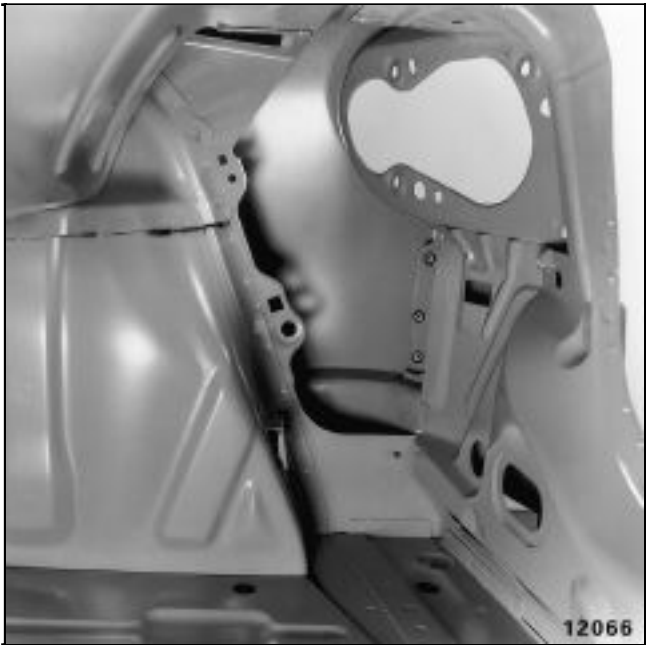
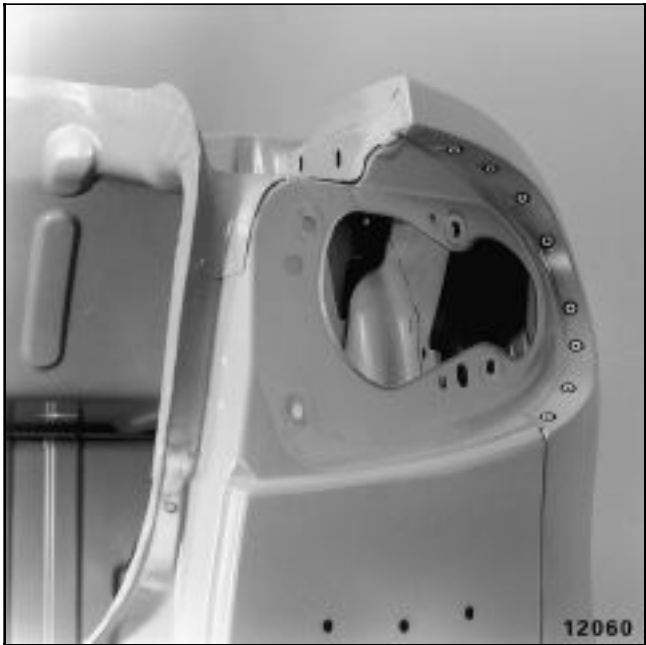


8 spot welds on 0.8 mm thickness



3 spot welds on 0.7 mm thickness

Welding



6 CONNECTION TO THE WING PANEL DRIP
MOULDING

Thickness of the panels concerned (mm)

Wing panel	0.8
Panel drip moulding	1.25

Unpicking

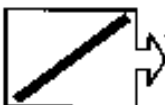
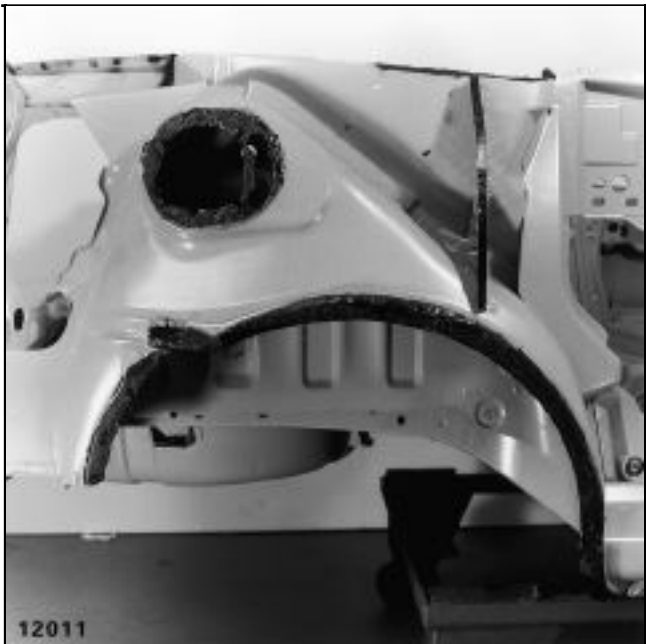
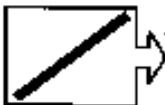


6 spot welds on 0.8 mm thickness



1 70 mm braze
1 30 mm braze

Welding

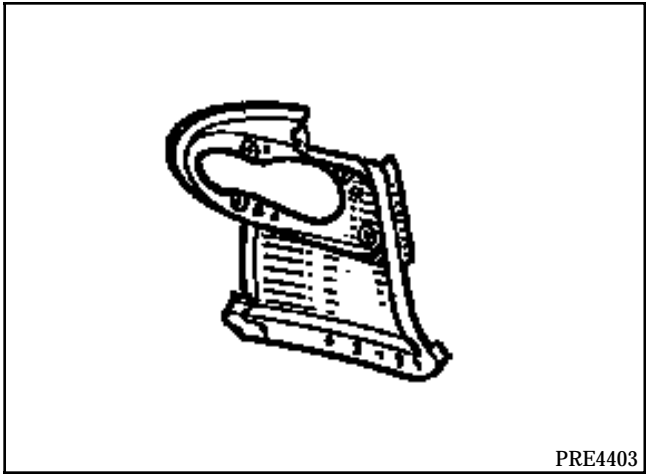


INTRODUCTION

The changing of this part is an additional operation to the changing of a wing panel or the rear end panel.

COMPOSITION OF THE REPLACEMENT PART

Part only.



1 CONNECTION TO THE REAR END PANEL

Thickness of the panels concerned

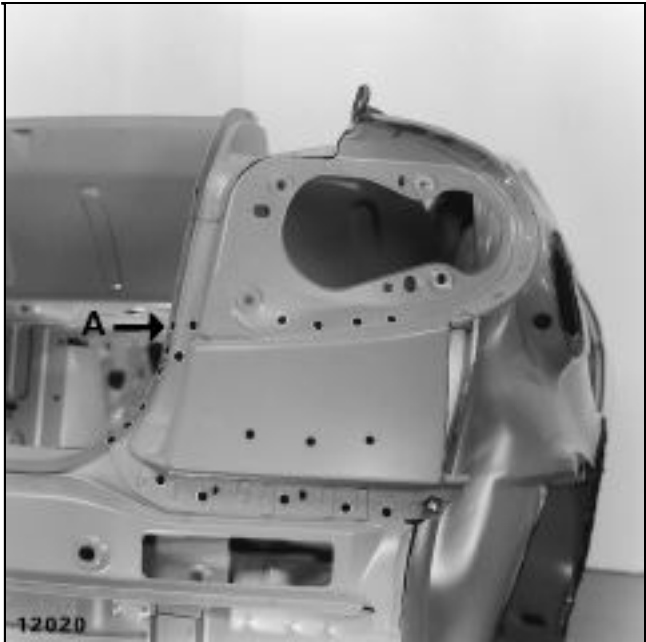
Lights bracket	0.7
Rear end panel	0.7
Lights support strengthener	1

Unpicking



16 spot welds on 1 mm thickness

Welding



NOTE: at (A), welding of 3 thicknesses.

2 CONNECTION TO THE WING PANEL DRIP
MOULDING

Thickness of the panels concerned (mm)

Lights bracket	0.7
Panel drip moulding	1.25

Unpicking

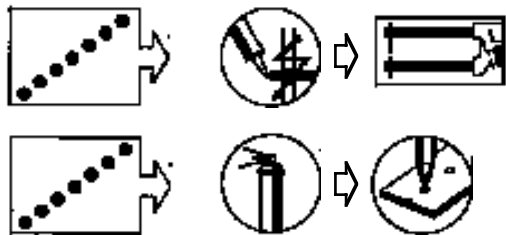
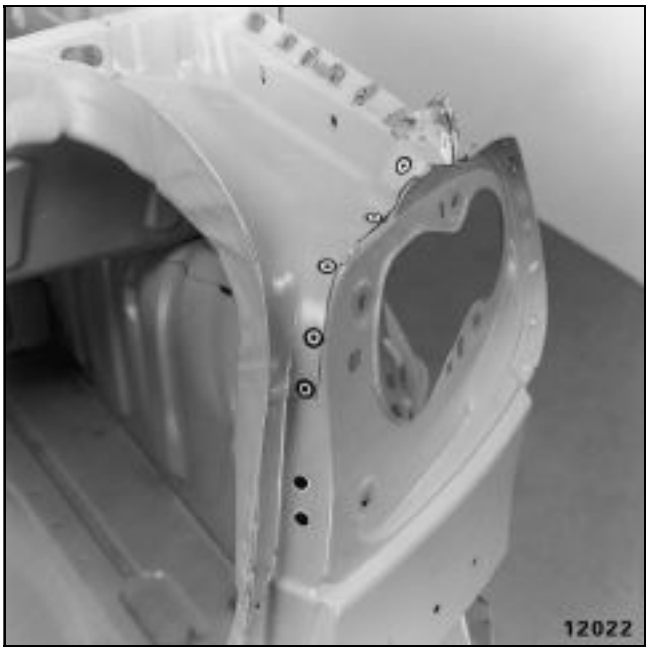


2 spot welds on 0.7 mm thickness



5 spot welds on 1.25 mm thickness

Welding



3 CONNECTION TO THE LIGHTS BRACKET
STRENGTHENER

Thickness of the panels concerned (mm)

Lights bracket	0.7
Lights bracket strengthener	1
Panel drip moulding	1.25

Unpicking



3 spot welds on 0.7 mm thickness

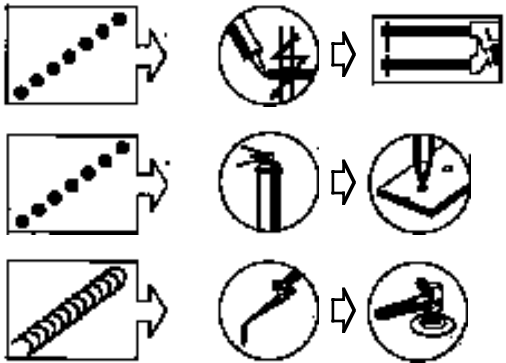
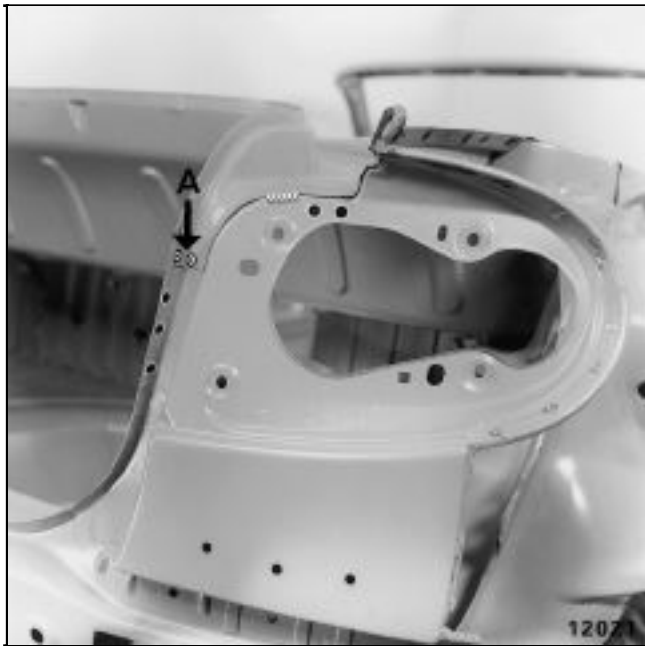


2 spot welds on 1 mm thickness



A 25 mm braze

Welding



NOTE: at (A), welding of 3 thicknesses

4 CONNECTION TO THE WING PANEL

Thickness of the panels concerned (mm)

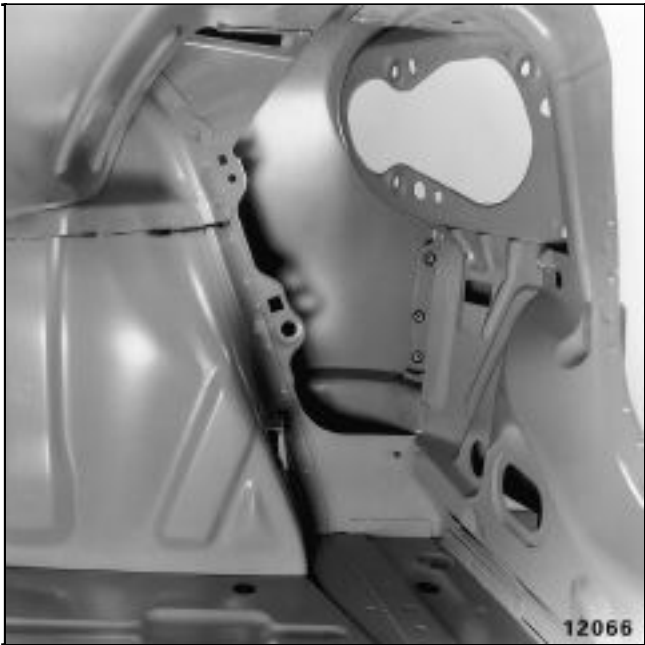
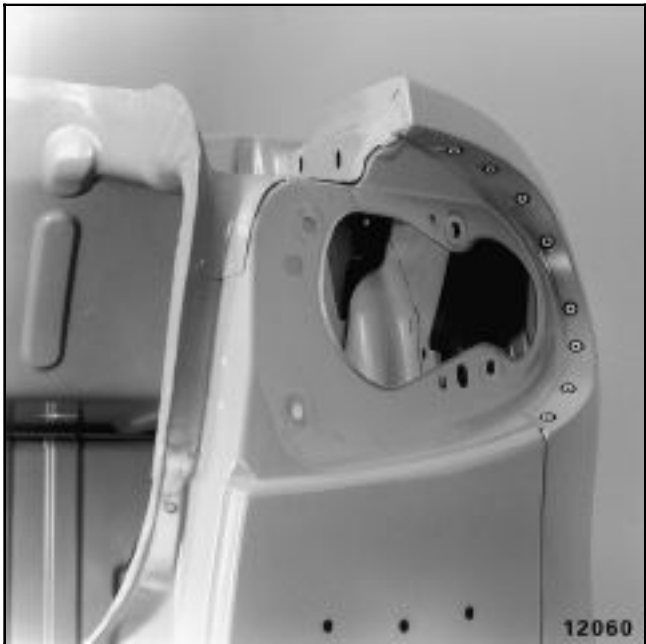
Lights bracket	0.7
Wing panel	0.8

Unpicking



8 spot welds on 0.8 mm thickness
3 spot welds on 0.7 mm thickness

Welding

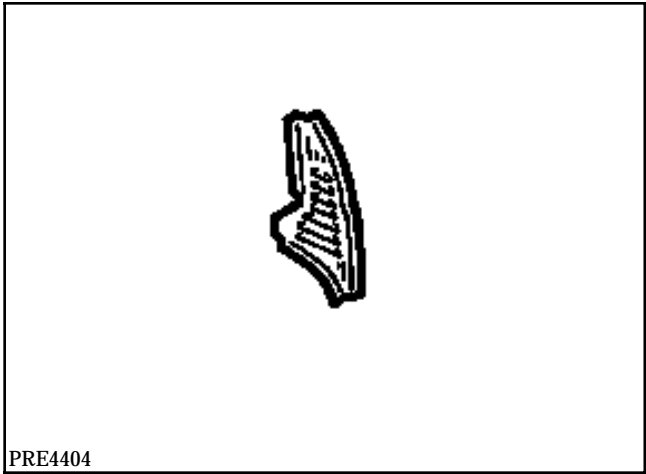


INTRODUCTION

The changing of this part is an additional operation to the changing of the wing panel finisher.

COMPOSITION OF THE REPLACEMENT PART

Part only.



1 CONNECTION TO THE WING PANEL Finisher

Thickness of the panels concerned (mm)

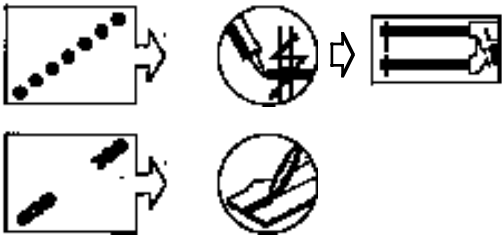
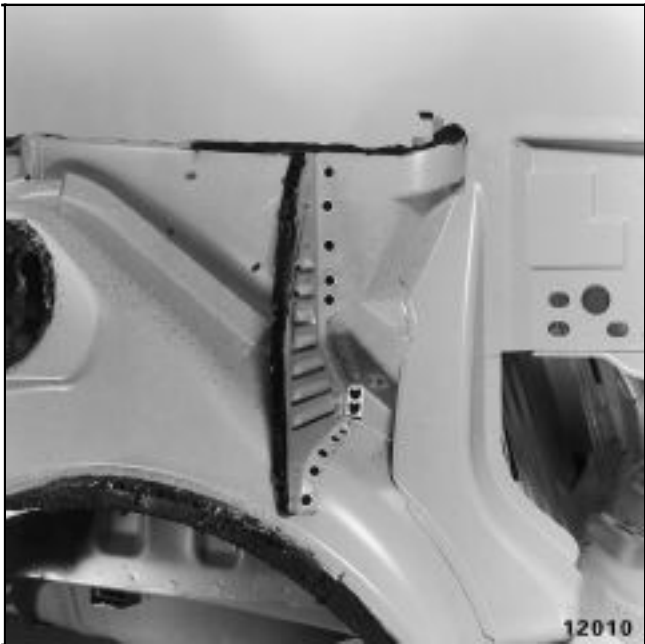
Closing device	0.75
Panel finisher	0.9

Unpicking



10 spot welds on 0.75 mm thickness
1 MAG weld seam 25 mm thickness

Welding



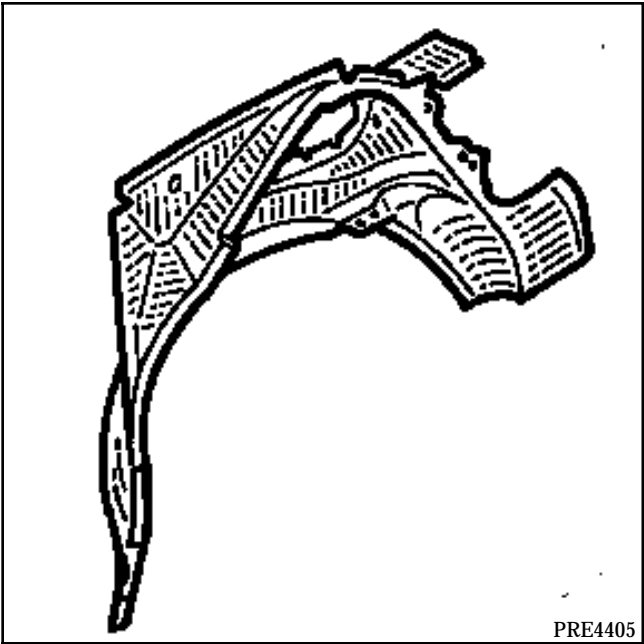
INTRODUCTION

The changing of this part is an additional operation to the changing of a wing panel.

NOTE: if the sill panel is not changed, a partial cut must be made in the lower section of the exterior wheel arch.

COMPOSITION OF THE REPLACEMENT PART

Part only.



1 CONNECTION TO THE FRONT UPPER FINISHER ASSEMBLY

Thickness of the panels concerned (mm)

Panel finisher	0.9
Upper exterior finisher	1.5
Upper interior finisher	1.5

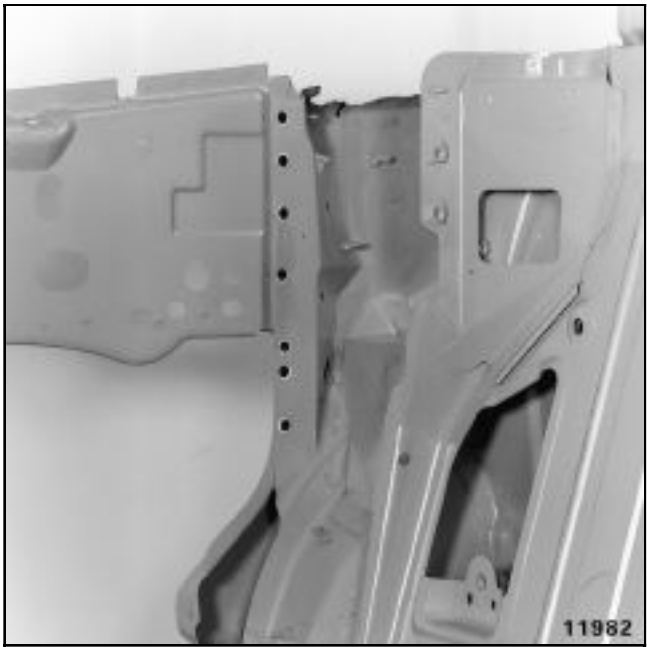
Unpicking



16 spot welds on 0.9 mm thickness
2 MAG weld seams 20 mm long

Welding





2 CONNECTION TO THE BOOT CENTRE
PARTITION STRENGTHENER

Thickness of the panels concerned (mm)

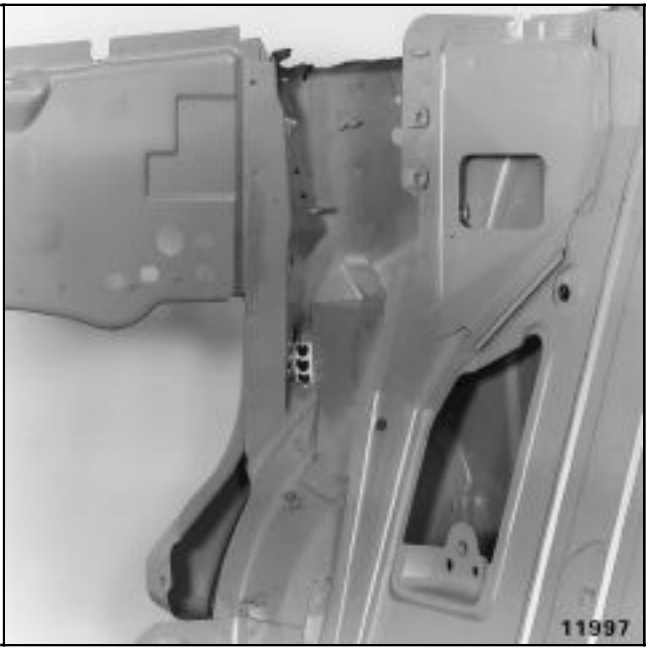
Panel finisher	0.9
Partition strengthener	0.75

Unpicking



1 MAG weld seam 35 mm long

Welding



3 CONNECTION TO THE REAR END PANEL

Thickness of the panels concerned (mm)

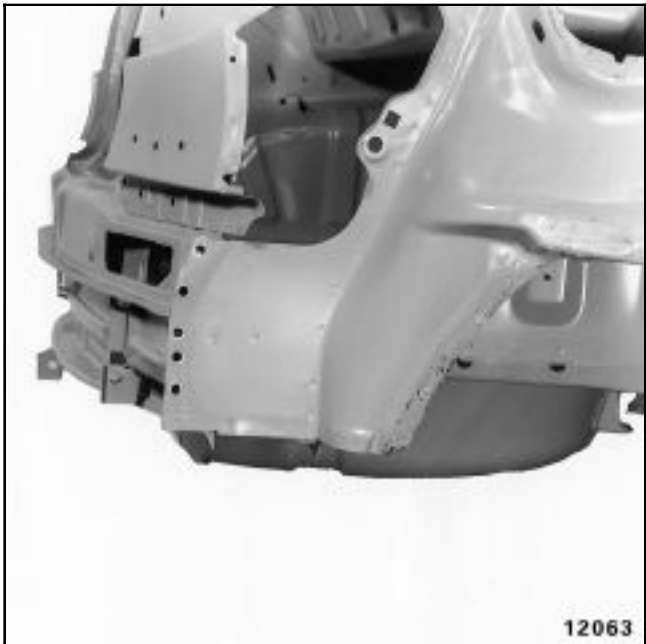
Panel finisher	0.9
Rear end panel	0.7

Unpicking



5 spot welds on 0.9 mm thickness

Welding



NOTE: welding of 3 thicknesses.

4 CONNECTION TO THE FLOOR EXTENDER

Thickness of the panels concerned (mm)

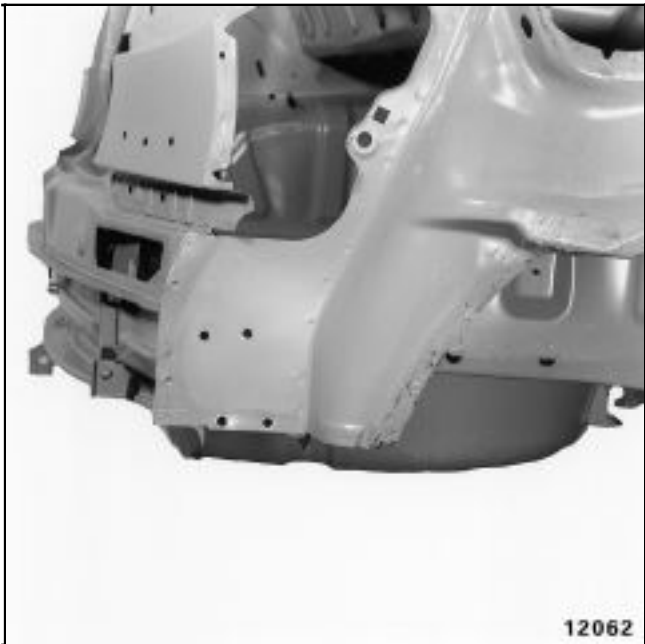
Panel finisher	0.9
Upper extender	1
Lower extender	1

Unpicking



4 spot welds on 0.9 mm thickness

Welding



NOTE: welding of 3 thicknesses.

5 CONNECTION TO THE HOOD COMPARTMENT
PARTITIONS ASSEMBLIES

Thickness of the panels concerned (mm)

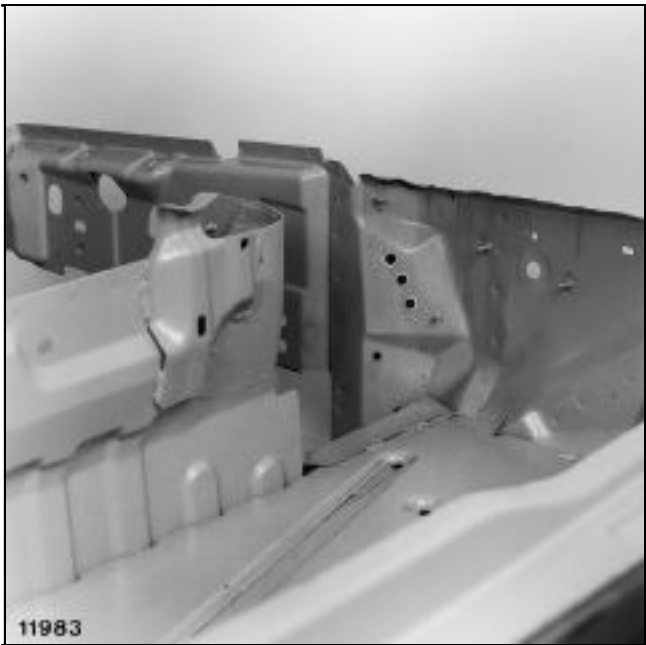
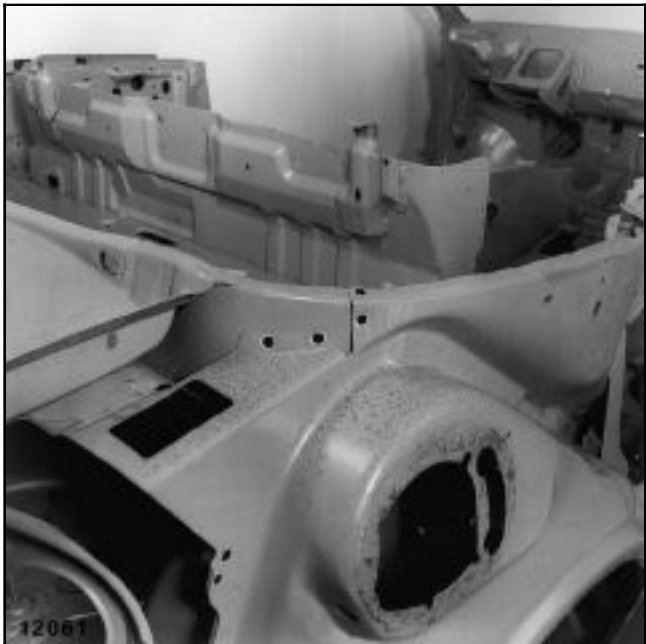
Panel partition	0.9
Boot rear partition	0.7
Boot rear upper connection	1

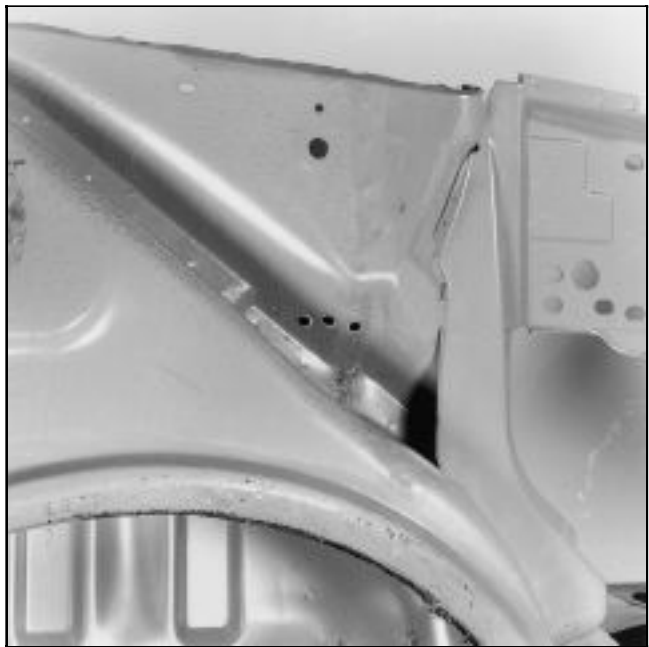
Unpicking



13 spot welds on 0.9 mm thickness

Welding





6 CONNECTION TO THE INTERIOR WHEEL ARCH

Thickness of the panels concerned

Panel finisher	0.9
Interior wheel arch	0.7
Wheel arch upper section	1

Unpicking

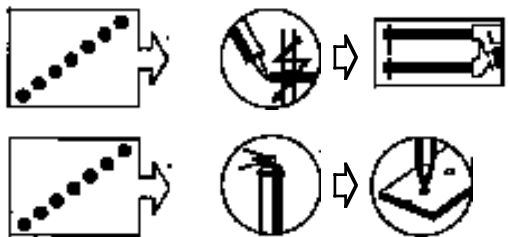
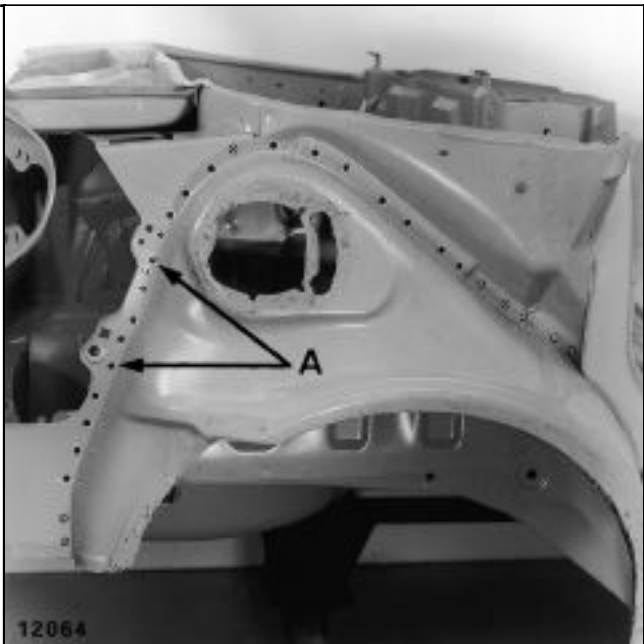


25 spot welds on 2 mm thickness
4 MAG weld seams 35 mm long



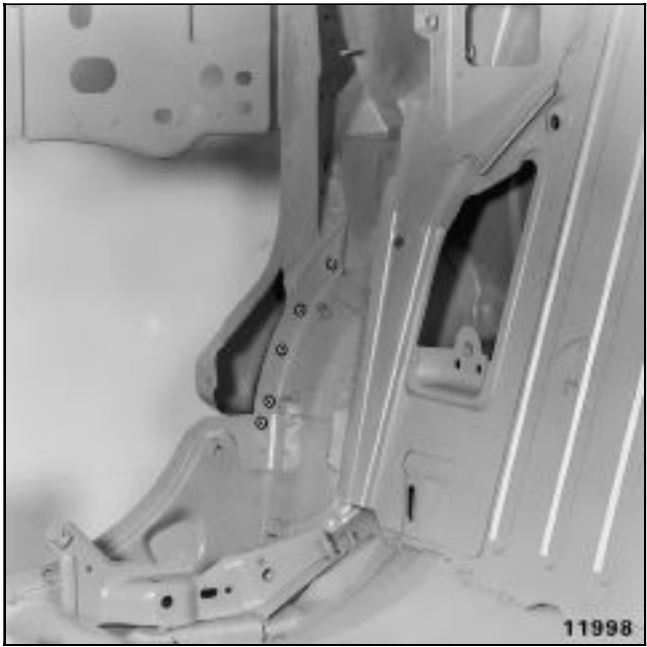
12 spot welds on 0.9 mm thickness

Welding



NOTE: at (A), welding of 3 thicknesses.





7 CONNECTION TO THE REAR SIDE MEMBER ASSEMBLY

Thickness of the panels concerned (mm)

Panel finisher	0.9
Rear side strengthener	0.7

Unpicking

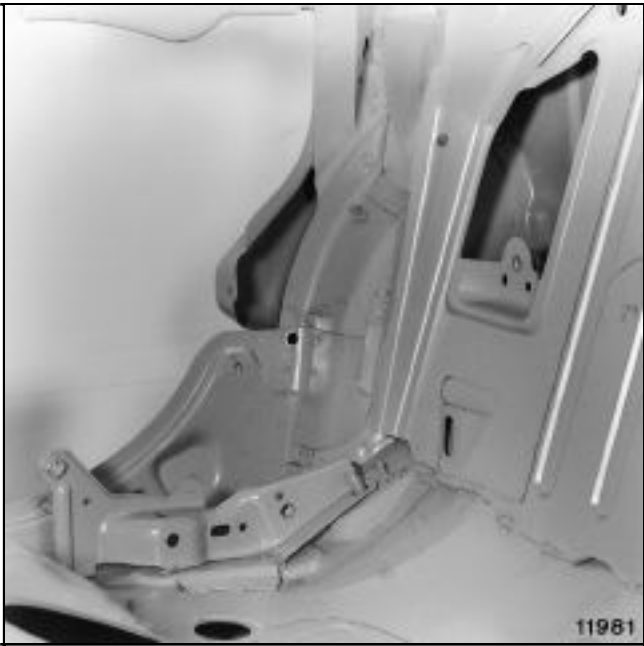
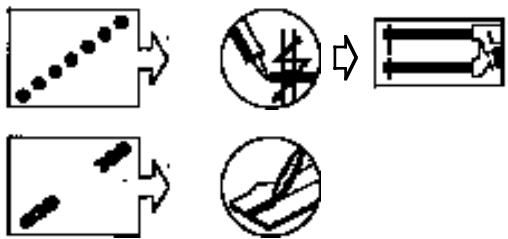


4 spot welds on 0.9 mm thickness
2 MAG weld seams 20 mm long



1 spot welds on 0.7 mm thickness

Welding



NOTE: welding of 3 thicknesses.

8 PARTIAL CUT OFF

Thickness of the panels concerned (mm)

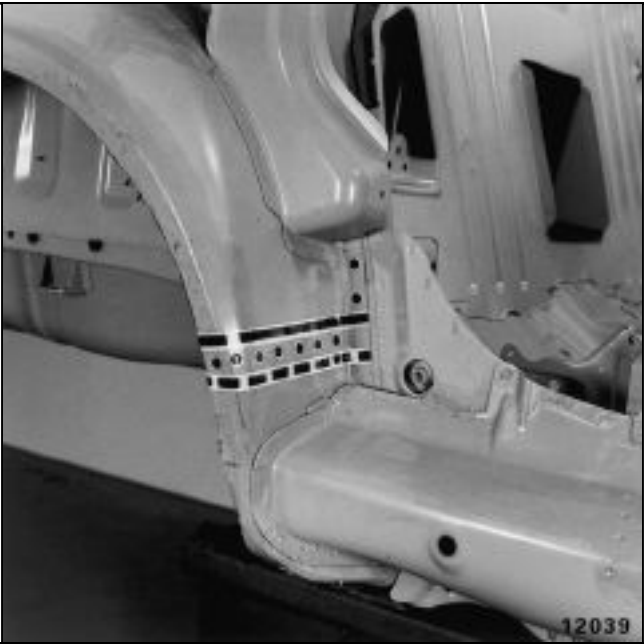
Panel finisher	0.9
Rear side strengthener	0.7

Unpicking



200 mm on 0.9 mm thickness

Welding



INTRODUCTION

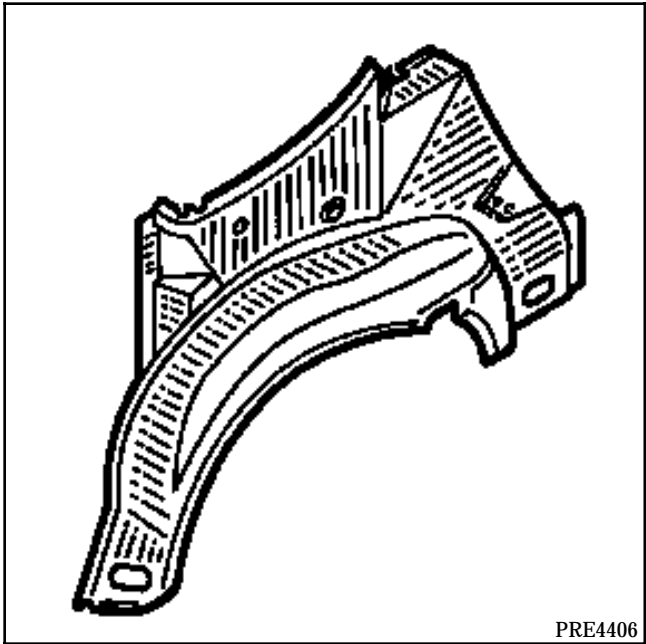
The changing of this part is an additional operation to the changing of a wing panel.

NOTE: if the sill panel is not changed, a cut must be made in the the lower section of the exterior wheel arch.

The description of the changing of the left-hand panel finisher only includes the connections which are different from the changing of the right-hand panel finisher.

COMPOSITION OF THE REPLACEMENT PART

Complete part including including balancer bracket.



PRE4406

1 CONNECTION TO THE HOOD COMPARTMENT
UPPER PARTITION

Thickness of the panels concerned (mm)

Panel finisher	0.9
Upper partition	1
Balancer bracket	1.5

Unpicking

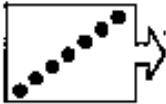


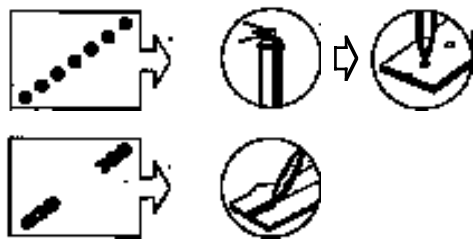
4 spot welds on 0.9 mm thickness.
1 MAG weld seam 20 mm long



1 spot weld on 1.5 mm thickness

Welding



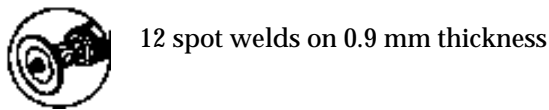


2 CONNECTION TO THE REAR BOOT PARTITION

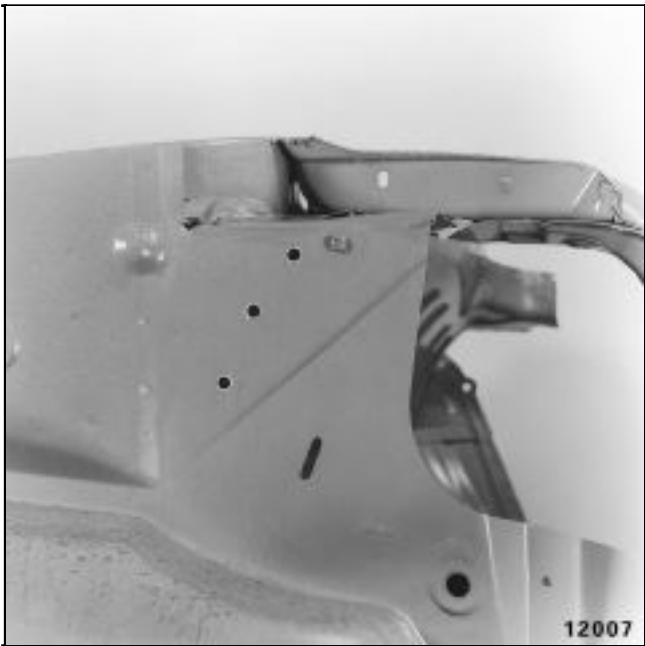
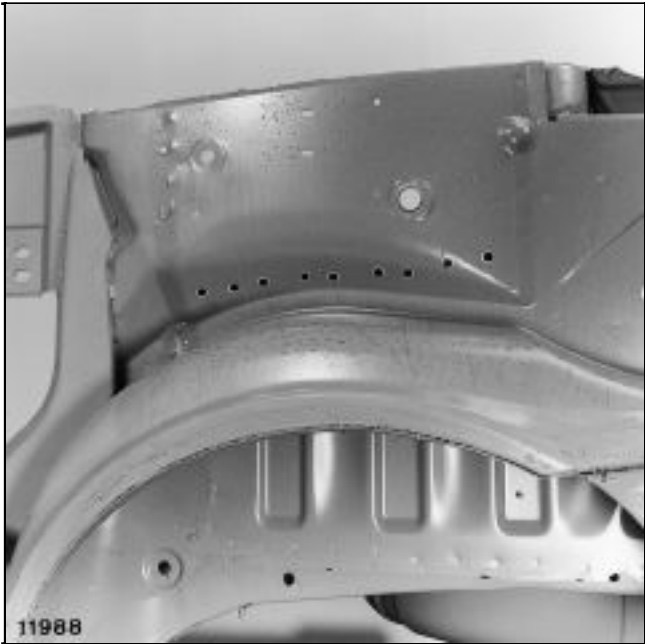
Thickness of the panels concerned (mm)

Panel finisher	0.9
Rear boot partition	0.7

Unpicking



Welding



3 CONNECTION TO THE INTERIOR WHEEL ARCH

Thickness of the panels concerned (mm)

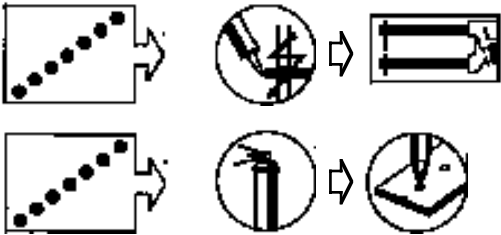
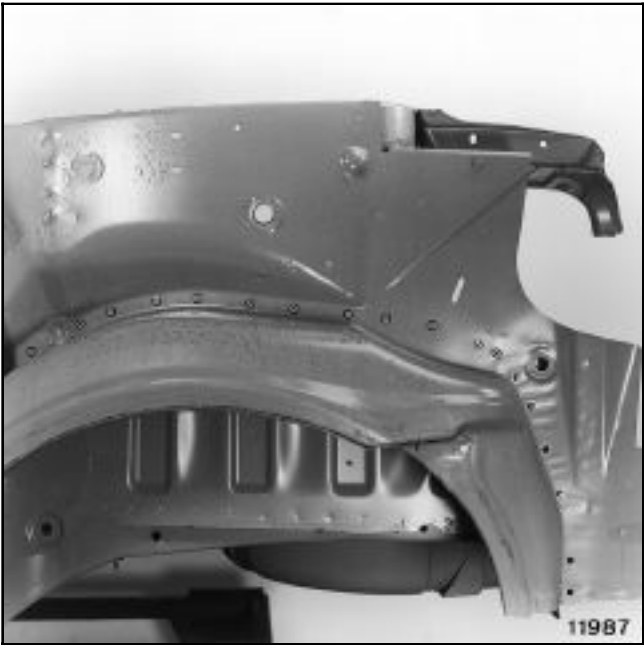
Panel finisher	0.9
Wheel arch	0.7

Unpicking



18 spot welds on 0.9 mm thickness

Welding



4 CONNECTION TO THE HYDRAULIC PUMP BRACKET

Thickness of the panels concerned (mm)

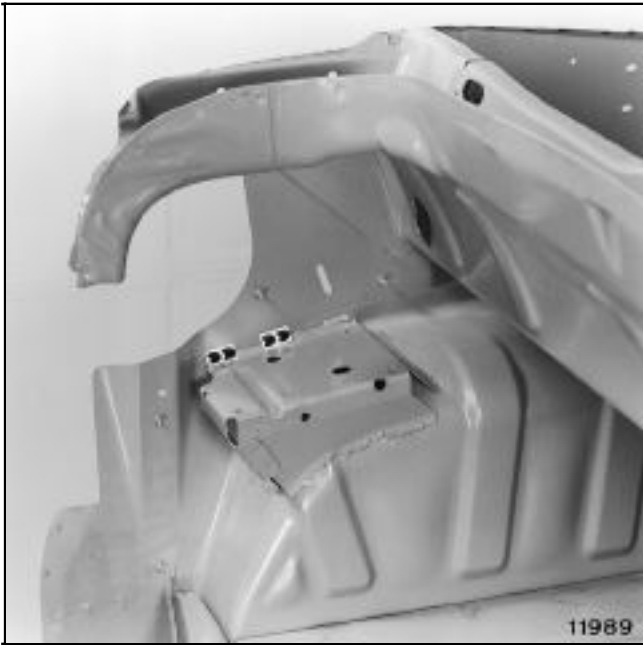
Panel finisher	0.9
Pump bracket	1.5

Unpicking



3 MAG weld seams 15 mm long

Welding

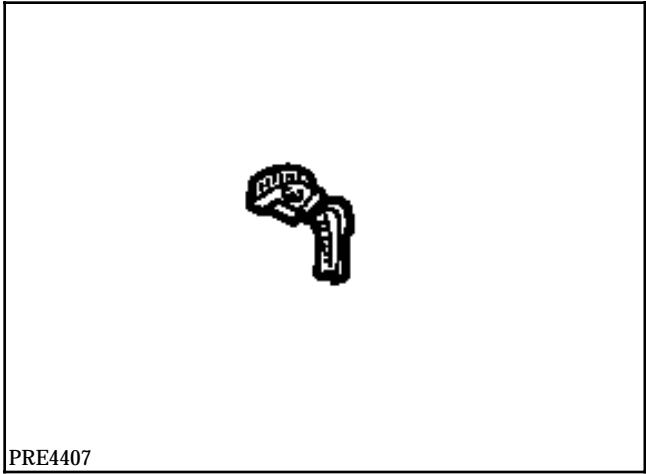


INTRODUCTION

The changing of this part is an additional operation to the changing of the rear lights bracket.

COMPOSITION OF THE REPLACEMENT PART

Part only.



1 CONNECTION TO THE REAR LIGHTS BRACKET

Thickness of the panels concerned (mm)

Rear lights strengthener	1
Rear lights bracket	0.7
Drip panel moulding	1.25

Unpicking

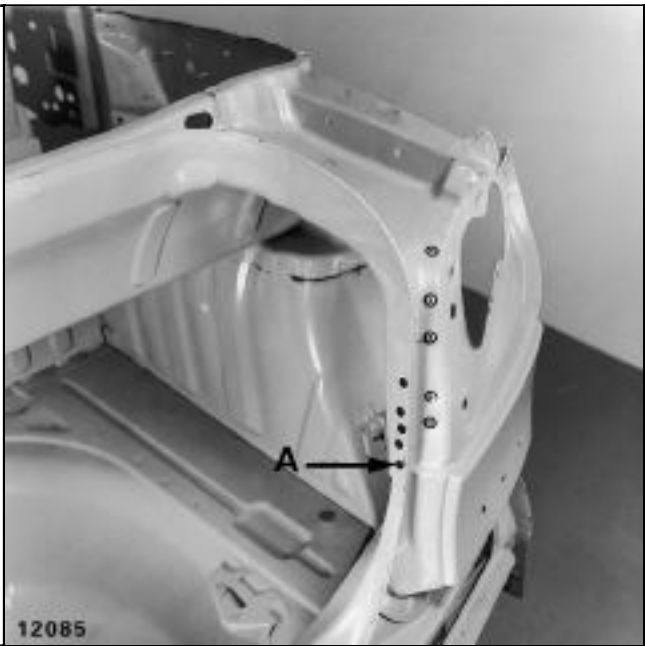


5 spot welds on 1 mm thickness



3 spot welds on 0.7 mm thickness
2 spot welds on 1.95 mm thickness

Welding



NOTE: at (A), welding of 3 thicknesses.

2 CONNECTION TO THE WING Drip panel
moulding

Thickness of the panels concerned (mm)

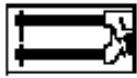
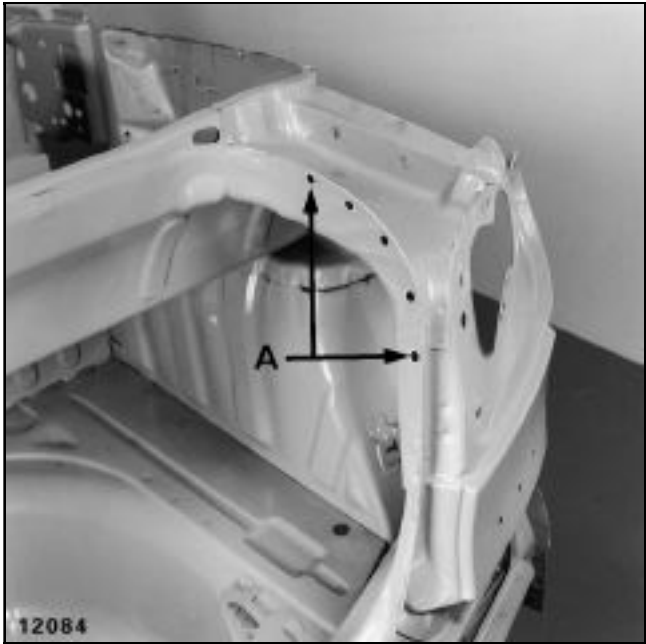
Rear lights strengthener	1
Rear lights bracket	0.7
Drip moulding panel	1.25

Unpicking

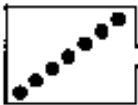
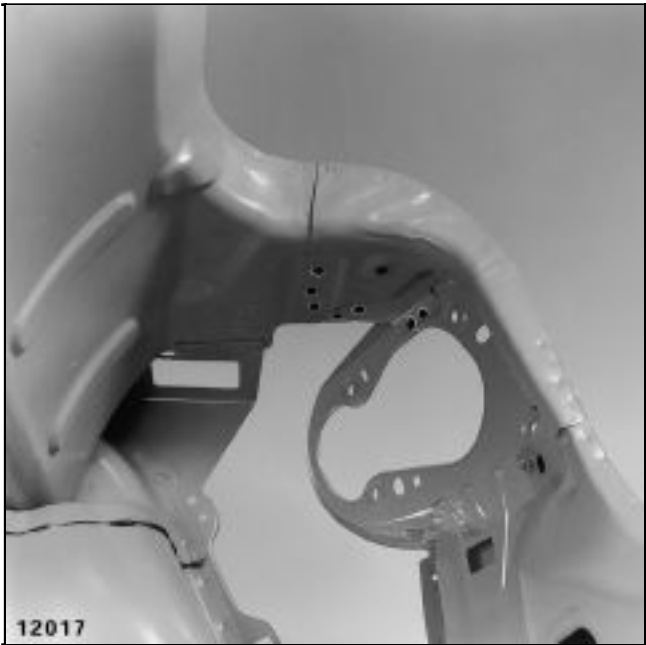


12 spot welds on 1 mm thickness

Welding



NOTE: at (A), welding of 3 thicknesses.



INTRODUCTION

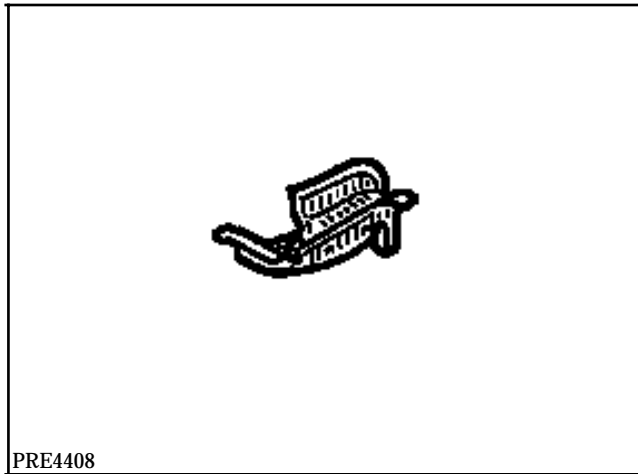
The changing of this part is a basic operation to be carried out in the event of a rear impact.

In addition to the changing of this part, the rear light bracket strengthener must also be changed.

The changing of this part is an additional operation to the changing of the wing panel or a lights bracket.

COMPOSITION OF THE REPLACEMENT PART

Part only.



1 CONNECTION TO THE WING PANEL

Thickness of the panels concerned (mm)

Drip panel moulding	1.25
Wing panel	0.8

Unpicking

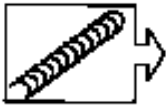


6 spot welds on 0.8 mm thickness



70 mm braze
30 mm braze

Welding



2 CONNECTION TO THE HOOD COMPARTMENT
REAR PARTITION DRIP MOULDING

Thickness of the panels concerned (mm)

Drip panel moulding	1.25
D drip moulding partition	1.25
Compartment upper partition	1
Compartment rear partition	0.7

Unpicking

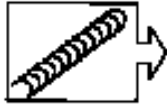
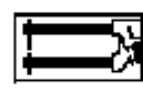


6 spot welds on 1.25 mm thickness



3 30 mm brazes

Welding



NOTE: at (A), welding of 3 thicknesses.

3 CONNECTION TO THE REAR LIGHTS BRACKET
STRENGTHENER

Thickness of the panels concerned (mm)

Drip panel moulding	1.25
Rear lights bracket strengthener	1

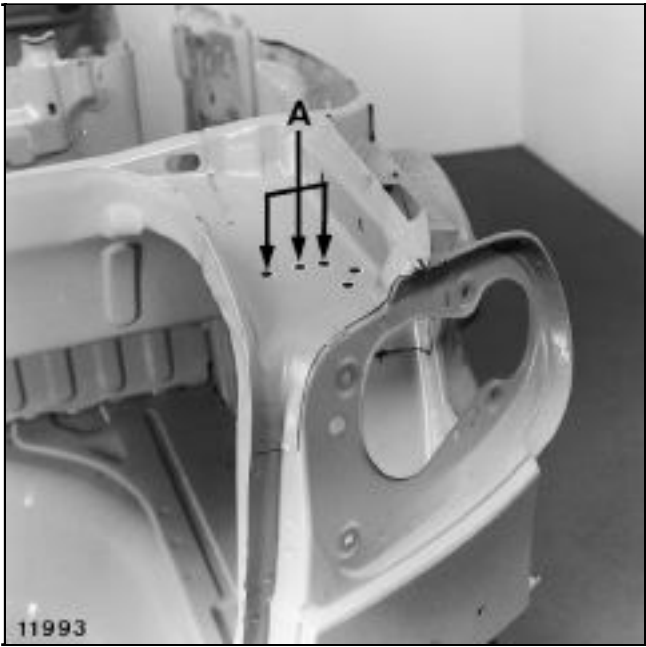
Unpicking



Welding



NOTE: at (A), welding of 3 thicknesses.



NOTE: at (A), welding of 3 thicknesses.

4 CONNECTION TO THE REAR LIGHTS BRACKET

Thickness of the panels concerned (mm)

Drip panel moulding	1.25
Rear lights bracket	0.7

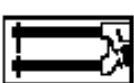
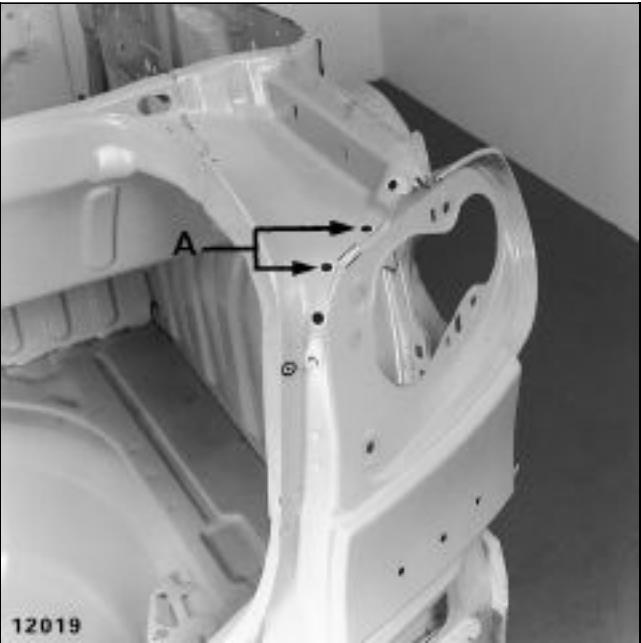
Unpicking



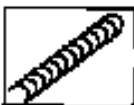
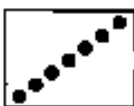
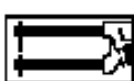
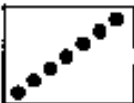
7 spot welds on 1.25 mm thickness



25 mm brazes



NOTE: at (A), welding of 3 thicknesses.



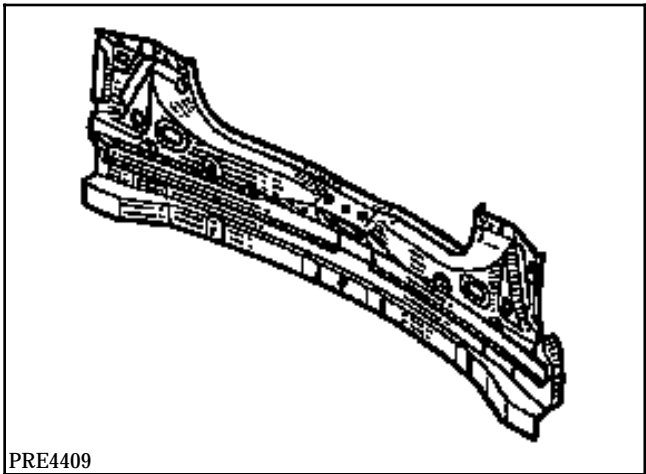
NOT: at (A), welding of 3 thicknesses.

INTRODUCTION

The changing of this part is a basic operation to be carried out in the event of a rear collision.

COMPOSITION OF THE REPLACEMENT PART

- Assembled part with:
- end panel,
 - end panel finisher.



1 CONNECTION TO THE REAR FLOOR UPPER EXTENDER

Thickness of the panels concerned (mm)

End panel	0.7
Upper extender	1

Unpicking



24 spot welds on 0.7 mm thickness

Welding



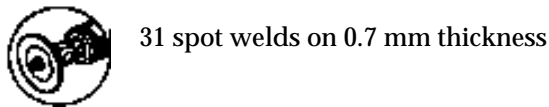
NOTE: welding of 3 thicknesses.

2 CONNECTION TO THE REAR FLOOR LOWER
EXTENDER

Thickness of the panels concerned (mm)

End panel	0.7
Lower extender	1

Unpicking



Welding

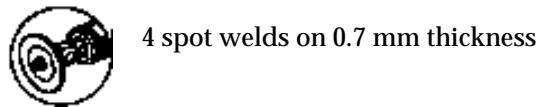


3 CONNECTION TO THE WING PANEL FINISHER

Thickness of the panels concerned (mm)

End panel	0.7
Finisher	0.9

Unpicking



Welding



NOTE: welding of 3 thicknesses.

4 CONNECTION TO THE REAR LIGHTS BRACKET
STRENGTHENER

Thickness of the panels concerned (mm)

End panel	0.7
Rear lights bracket strengthener	1
Rear lights bracket	0.7

Unpicking



1 spot weld on 1 mm thickness

Welding



NOTE: welding of 3 thicknesses.

5 CONNECTION TO THE REAR LIGHTS BRACKET

Thickness of the panels concerned (mm)

End panel	0.7
Rear lights bracket	0.7

Unpicking

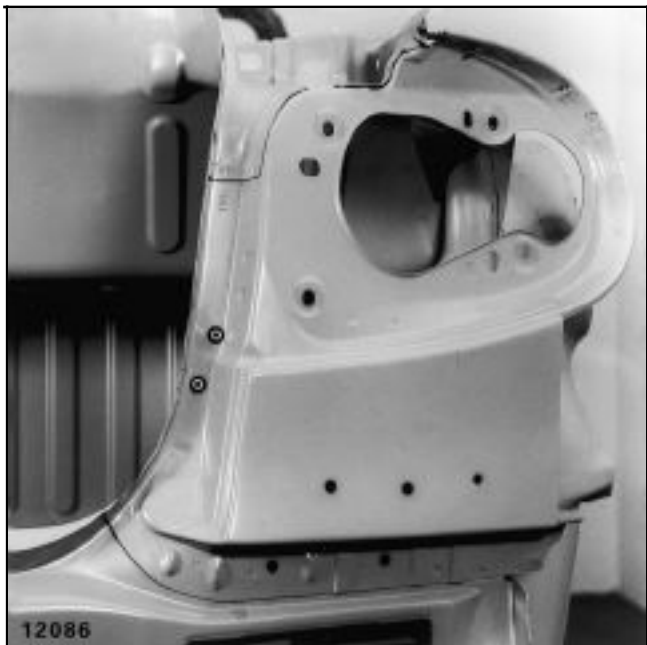


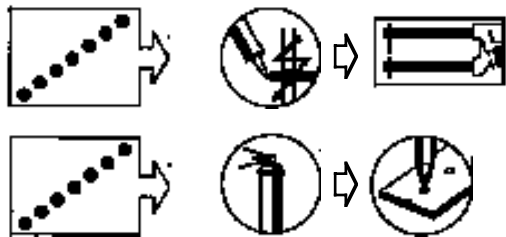
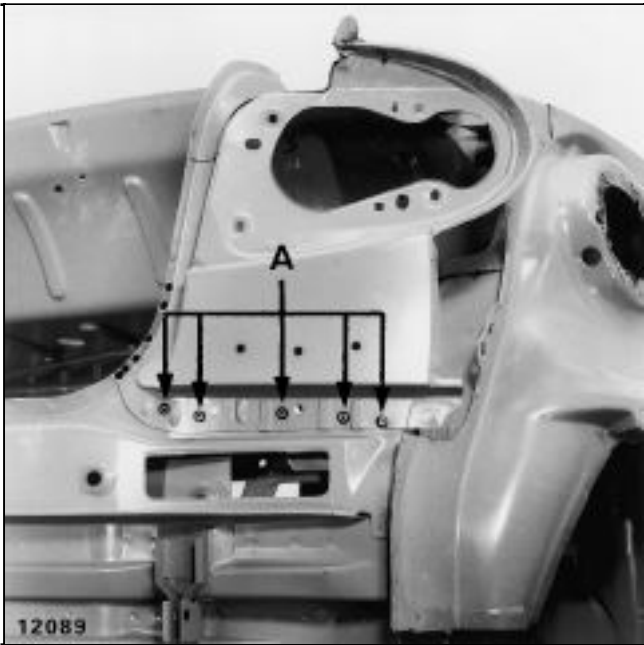
9 spot welds on 0.7 mm thickness



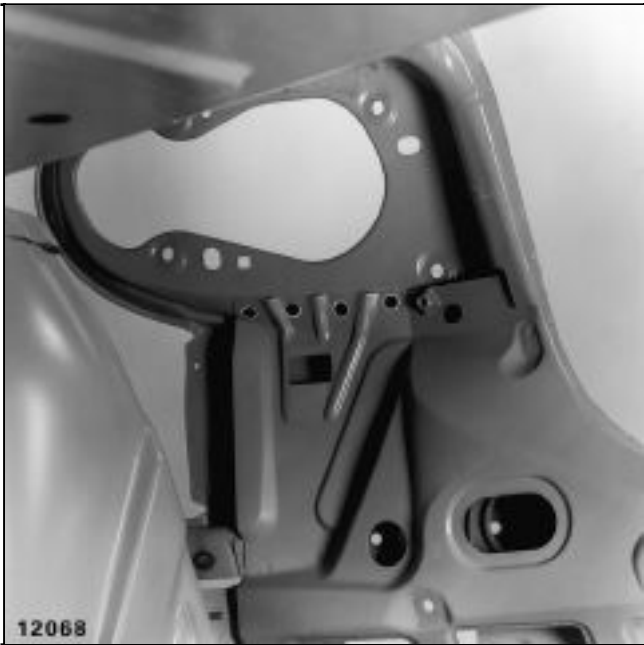
7 spot welds on 0.7 mm thickness

Welding





NOTE: at (A), welding of 3 thicknesses.



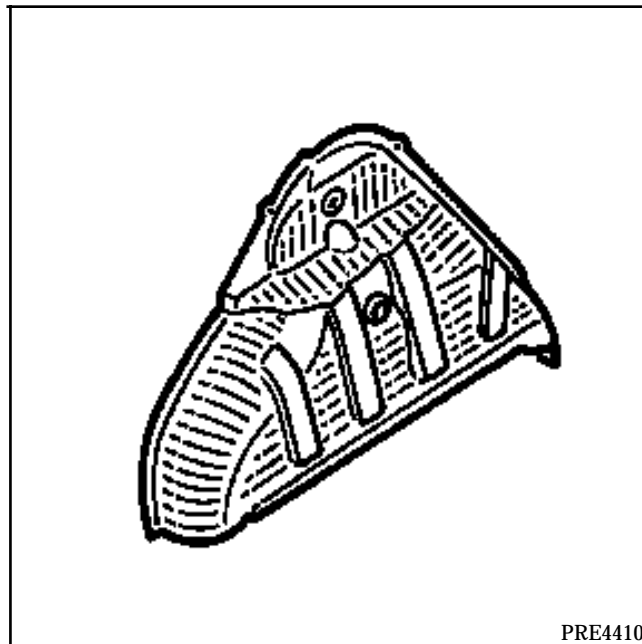
INTRODUCTION

The changing of this part is an additional operation to the changing of a wing panel finisher.

COMPOSITION OF THE REPLACEMENT PART

Assembled part with:

- wheel arch upper component,
- interior wheel arch.



PRE4410

1 CONNECTION TO THE REAR PARTITION

Thickness of the panels concerned (mm)

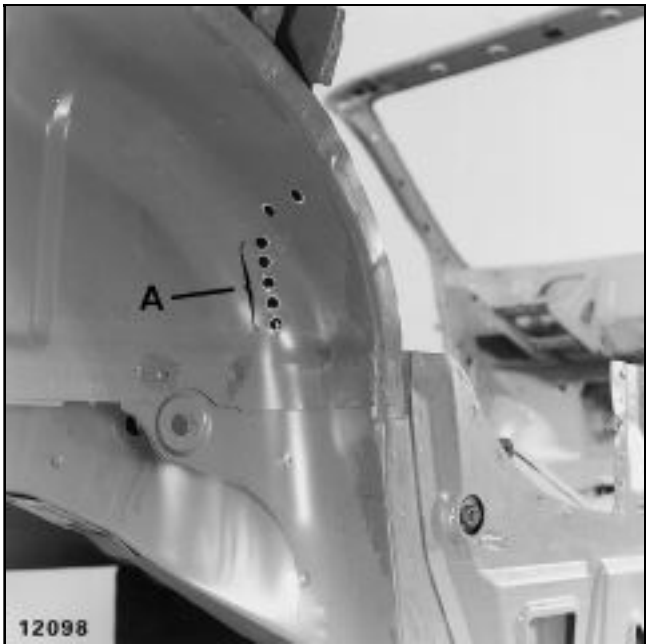
Interior wheel arch	0.7
Central boot partition	0.75

Unpicking



7 spot welds on 0.7 mm thickness

Welding



NOTE: at (A), welding of 3 thicknesses.

2 CONNECTION TO THE REAR PARTITION
STRENGTHENER

Thickness of the panels concerned (mm)

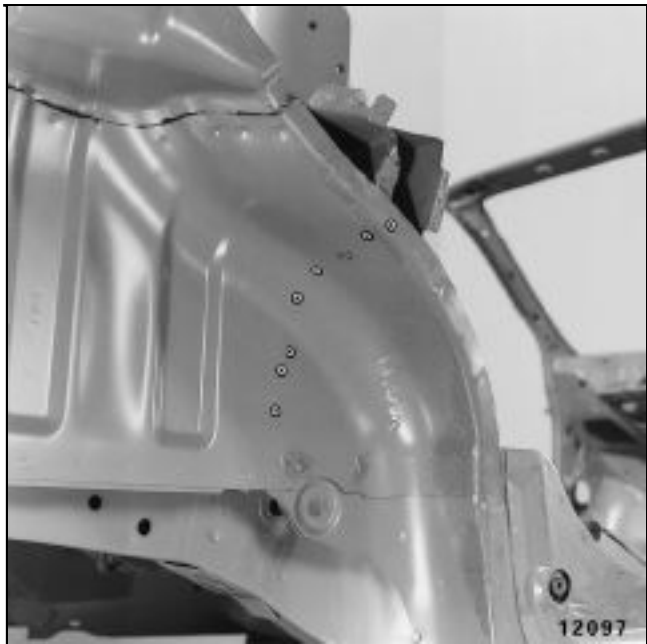
Wheel arch	0.7
Rear partition strengthener	0.75

Unpicking



8 spot welds on 0.7 mm thickness

Welding



3 CONNECTION TO THE REAR SECTION OF THE
REAR FLOOR

Thickness of the panels concerned (mm)

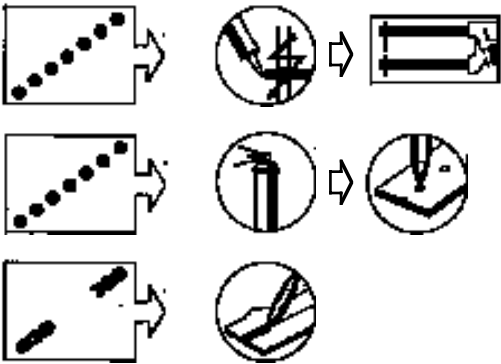
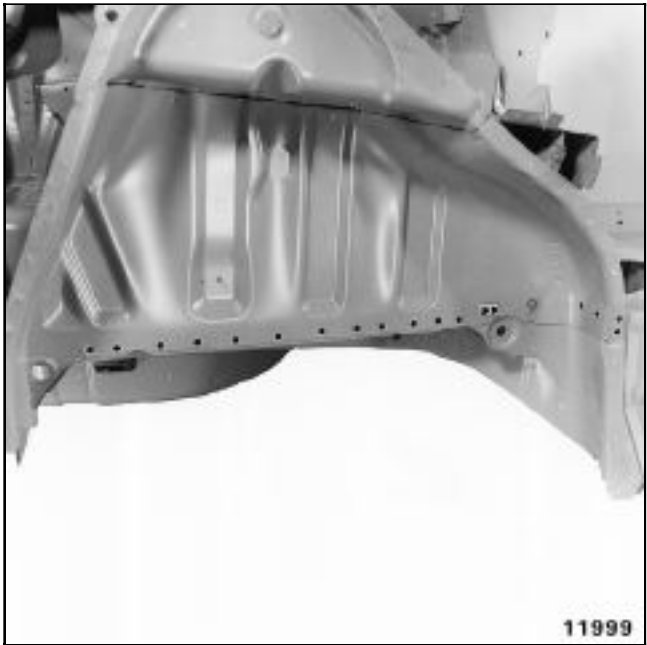
Interior wheel arch	0.7
Rear section of the rear floor	0.75

Unpicking



16 spot welds on 0.7 mm thickness
1 MAG spot weld Ø 8 mm
1 MAG weld seam 20 mm long

Welding



4 CONNECTION TO THE REAR CROSSMEMBER

Thickness of the panels concerned (mm)

Interior wheel arch	0.7
Rear crossmember	0.8

Unpicking



7 spot welds on 0.7 mm thickness

Welding



NOTE: at (A), welding of 3 thicknesses.

5 CONNECTION TO THE HOOD COMPARTMENT
REAR PARTITION

Thickness of the panels concerned (mm)

Upper interior wheel arch	1
Compartment rear upper partition	1
Compartment rear partition	0.7

Unpicking

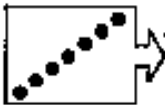
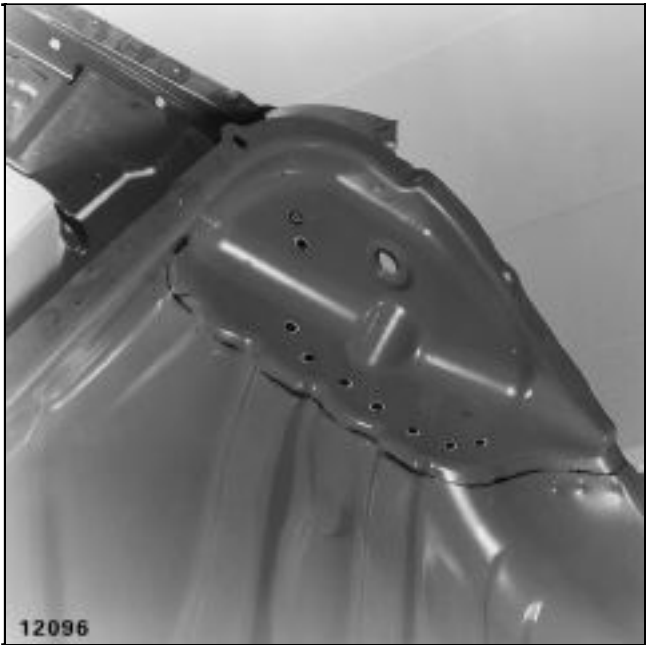
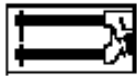


4 spot welds on 1 mm thickness



9 spot welds on 0.7 mm thickness

Welding

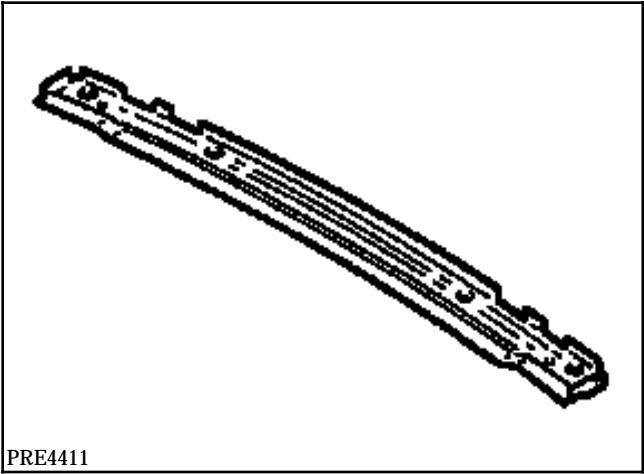


INTRODUCTION

The changing of this part is an additional operation to the changing of a rear end panel assembly.

COMPOSITION OF THE REPLACEMENT PART

Part only.



1 CONNECTION TO THE WING PANEL

Thickness of the panels concerned (mm)

Rear floor extender	1
Wing panel	0.9

Unpicking



2 spot welds on 1 mm thickness

Welding



NOTE: welding of 3 thicknesses.

2 CONNECTION TO THE REAR CROSSMEMBER

Thickness of the panels concerned (mm)

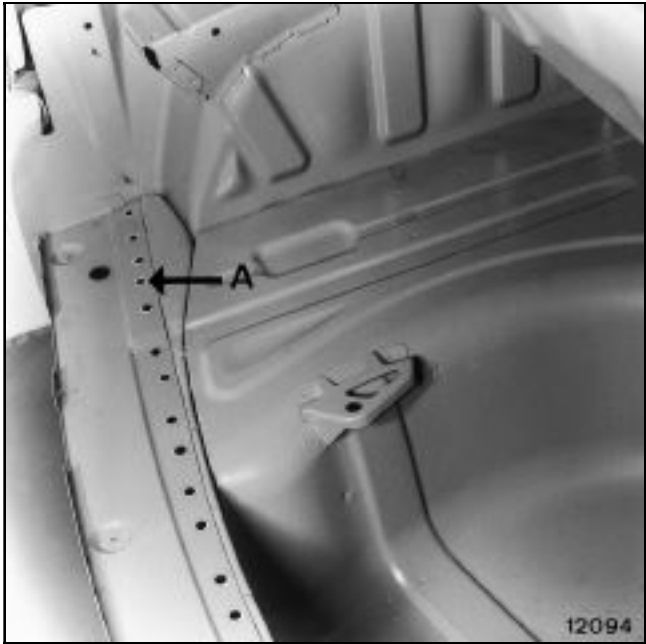
Rear floor extender	1
Rear crossmember	0.8

Unpicking



27 spot welds on 1 mm thickness

Welding



NOTE: at (A), welding of 3 thicknesses.

3 CONNECTION TO THE REAR SIDE MEMBER EXTENDER

Thickness of the panels concerned (mm)

Rear floor extender	1
Rear side member extender	1

Unpicking



4 spot welds on 1 mm thickness

Welding

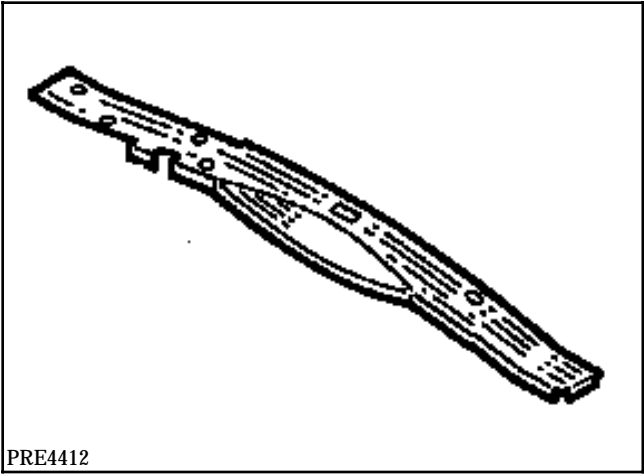


INTRODUCTION

The changing of this part is an additional operation to the changing of a rear end panel assembly.

COMPOSITION OF THE REPLACEMENT PART

Assembled part with strengthener.



1 CONNECTION TO THE SIDE PANEL

Thickness of the panels concerned (mm)

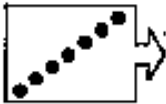
Rear floor extender	1
Wing panel	0.7

Unpicking



2 spot welds on 1 mm thickness

Welding



NOTE: welding of 3 thicknesses.

2 CONNECTION TO THE REAR CROSSMEMBER

Thickness of the panels concerned (mm)

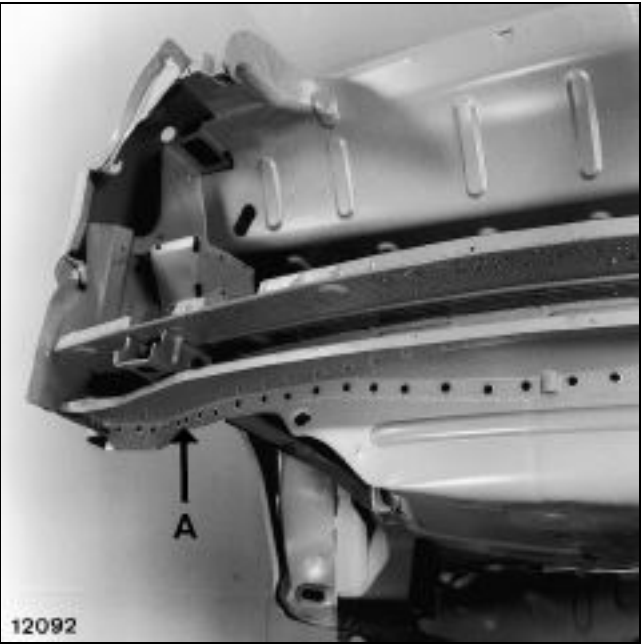
Rear floor extender	1
Rear crossmember	0.8
Strengthenener	2.5

Unpicking



36 spot welds on 1 mm thickness

Welding



NOTE: at (A), welding of 3 thicknesses.



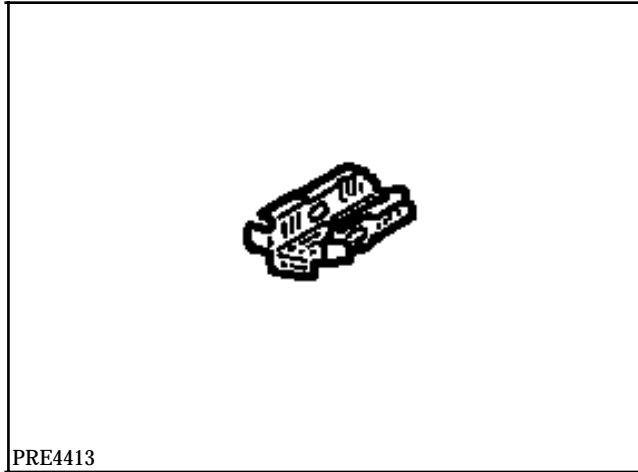
NOTE: at (A), welding of 3 thicknesses.

INTRODUCTION

The changing of this part is an additional operation to the changing of a rear end panel assembly.

COMPOSITION OF THE REPLACEMENT PART

Part only.



1 CONNECTION TO THE REAR FLOOR EXTENDER

Thickness of the panels concerned (mm)

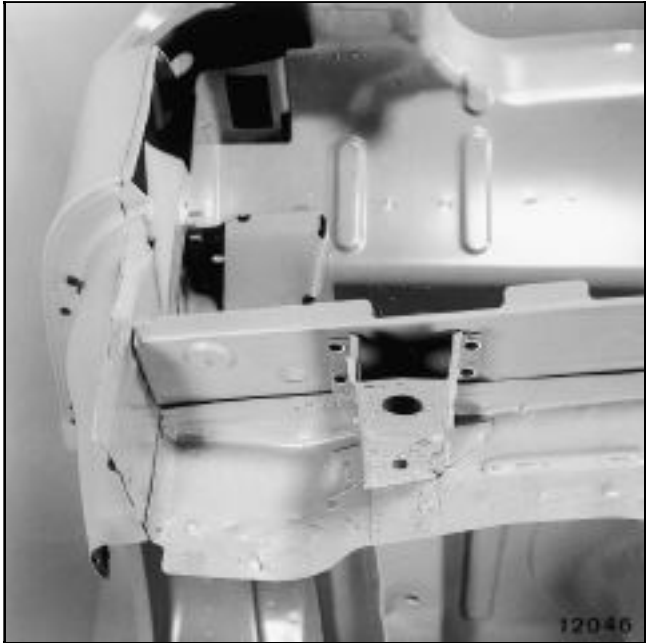
Rear side member extender	1
Rear floor extender	1

Unpicking



4 spot welds on 1 mm thickness

Welding



2 CONNECTION TO THE REAR CROSSMEMBER

Thickness of the panels concerned (mm)

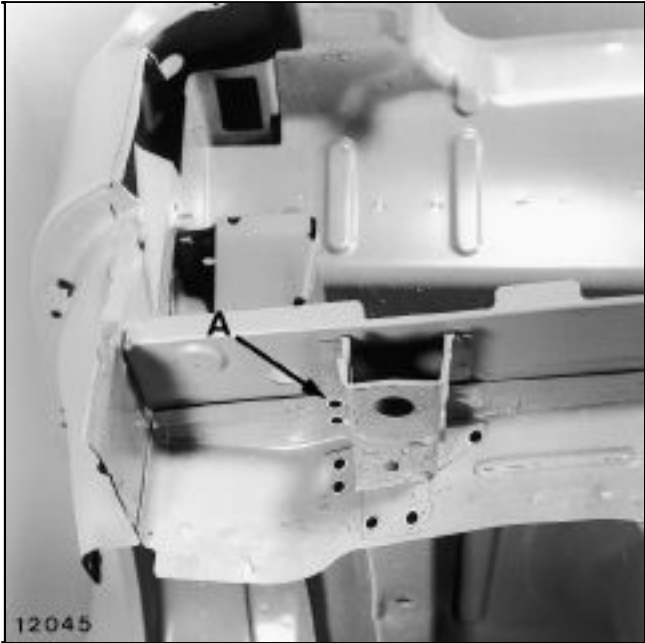
Rear side member extender	1
Rear crossmember	0.8

Unpicking



7 spot welds on 1 mm thickness

Welding



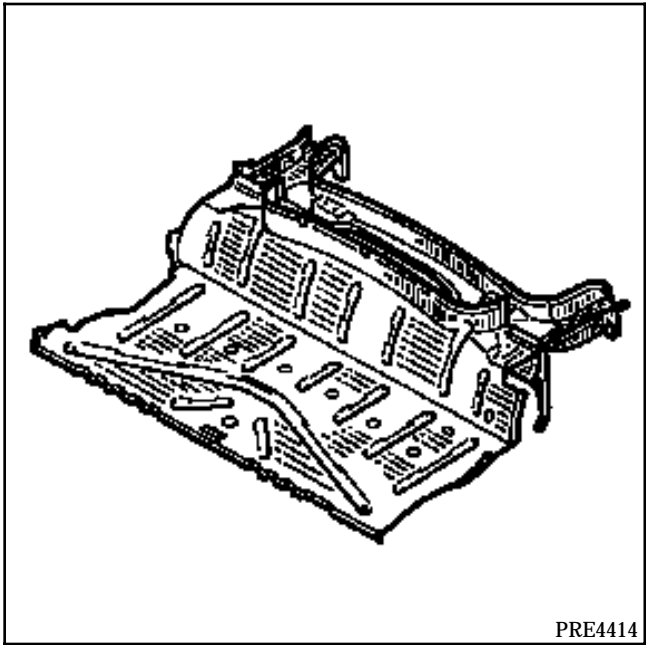
NOTE: at (A), welding of 3 thicknesses.

INTRODUCTION

The changing of this part is an additional operation to the changing of the side drip moulding or the interior wheel arch

COMPOSITION OF THE REPLACEMENT PART

- Assembled part with:
- compartment rear partition,
 - compartment upper rear partition
 - central drip moulding,
 - hinge strengtheners.



1 CONNECTION TO THE REAR PARTITION STRENGTHENER

Thickness of the panels concerned (mm)

Compartment rear partition	0.7
Rear partition strengthener	0.85

Unpicking

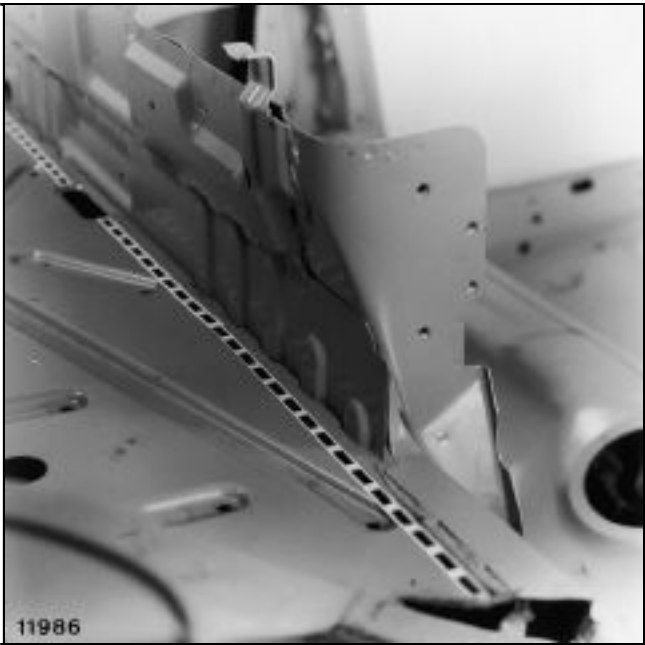


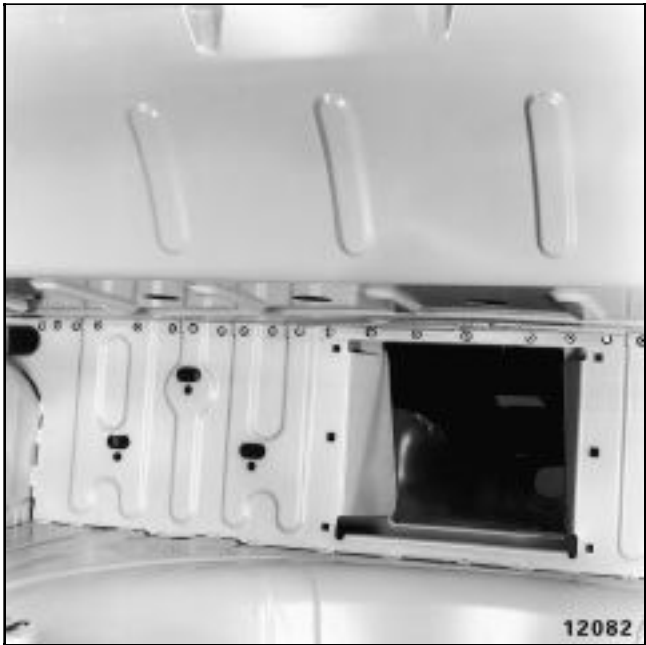
37 spot welds on 0.7 mm thickness



1450 mm at 0.7 mm thickness

Welding





2

CONNECTION TO THE LEFT-HAND REAR SIDE PARTITION

Thickness of the panels concerned (mm)

Compartment rear partition	0.7
Rear side partition	1.5
Rear partition strengthener	0.85

Unpicking



3 spot welds on 2.25 mm thickness

Welding



NOTE: triple layer welding (on the left-hand side only).

3

CONNECTION TO THE RIGHT-HAND PANEL TRIM

Thickness of the panels concerned (mm)

Compartment upper rear partition	1
Panel trim	0.9

Unpicking



3 spot welds on 0.7 mm thickness

Welding



4

CONNECTION TO THE RIGHT-HAND INTERIOR WHEEL ARCH (UPPER SECTION)

Thickness of the panels concerned (mm)

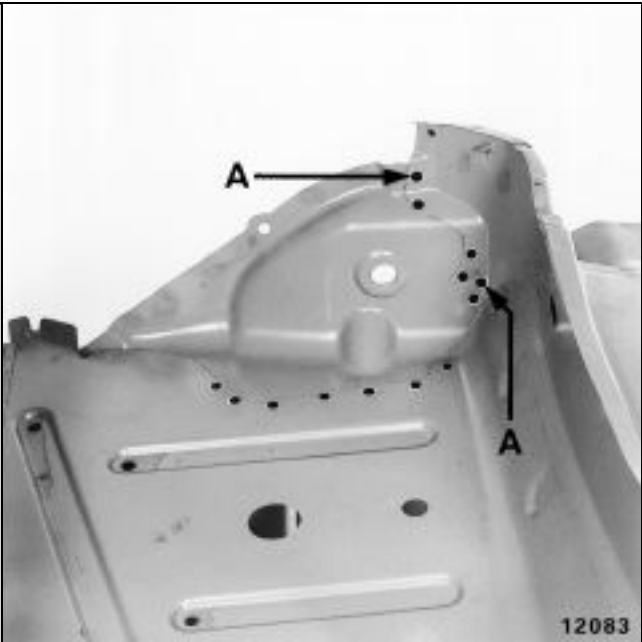
Compartment upper rear partition	1
Wheel arch	1

Unpicking



14 spot welds on 0.7 mm thickness

Welding



NOTE: at (A), triple layer welding.

5 CONNECTION TO THE LEFT-HAND PANEL TRIM

Thickness of the panels concerned (mm)

Compartment upper rear partition	1
Panel trim	0.9
Balancer bracket	1.5

Unpicking

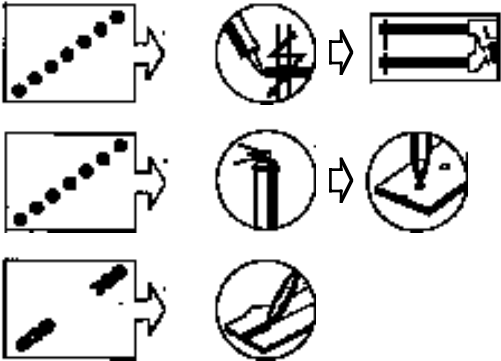
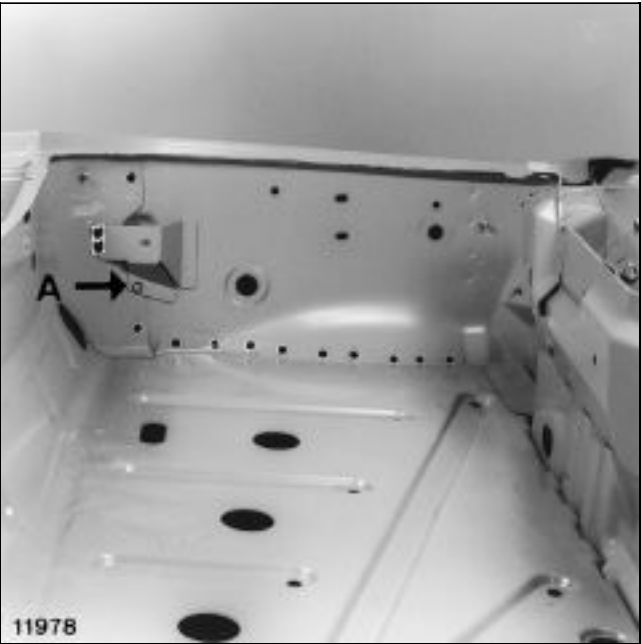


17 spot welds on 0,7 mm thickness
1 MAG welds seam 20 mm long

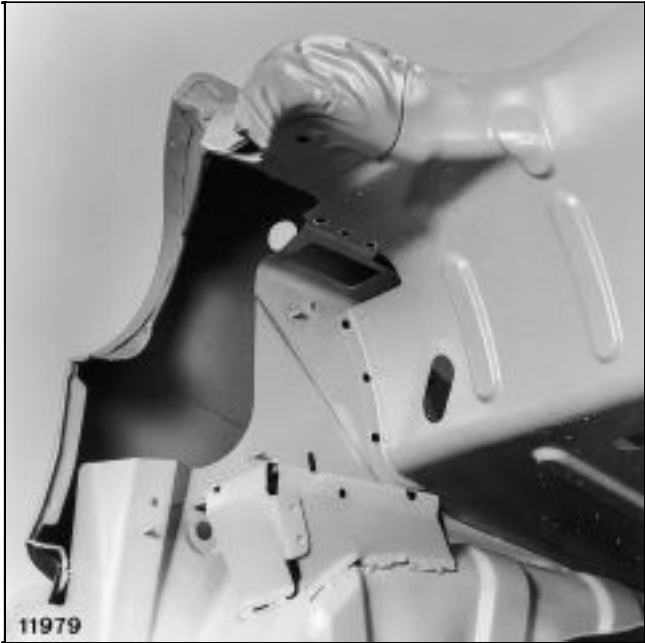


1 spot weld on 2.2 mm thickness

Welding



NOTE: at (A), triple layer welding.



6

CONNECTION TO THE WING PANEL

Thickness of the panels concerned (mm)

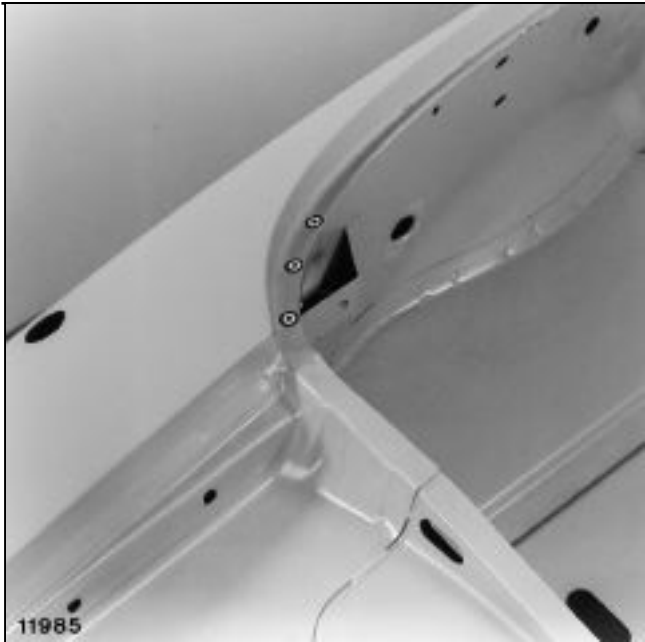
Compartment upper rear partition	1
Wing panel	0.8

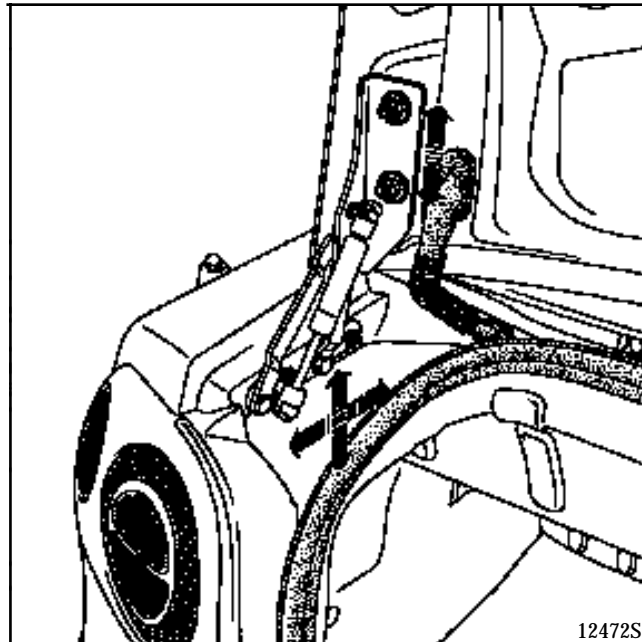
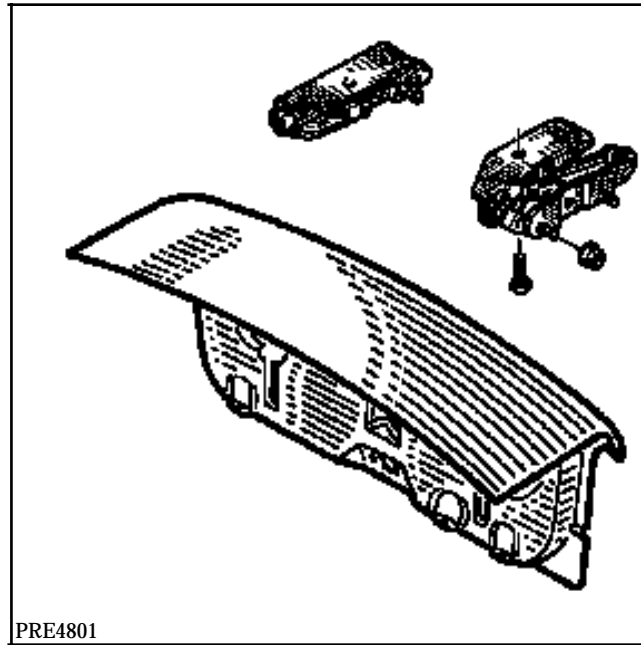
Unpicking



3 spot welds on 0.8 mm thickness

Welding





Disconnect and remove the electrical wiring.

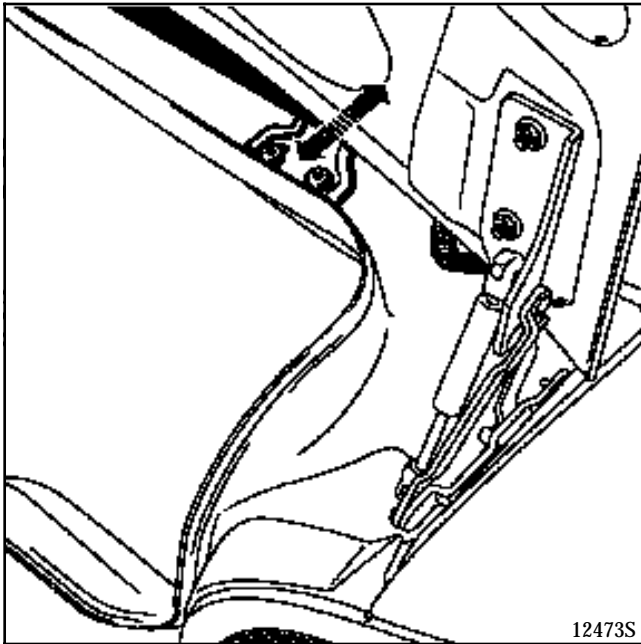
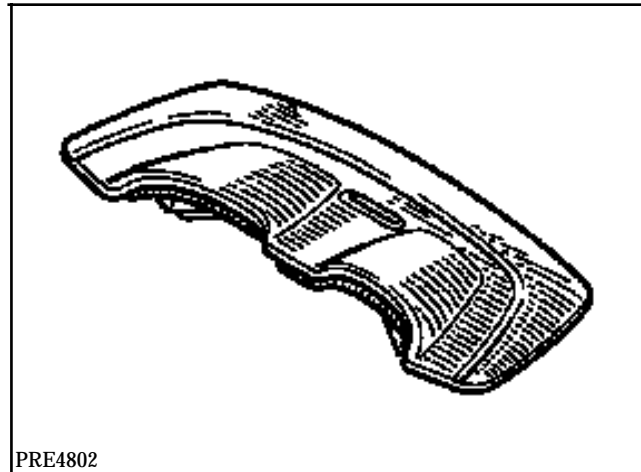
Remove the nuts.

NOTE: the light unit must be removed in order to gain access to the lower mounting bolts. When re-fitting the struts, seal using preformed mastic for detachable components.

OPENINGS OTHER THAN SIDE DOORS

Hood cover

48



Disconnect the electrical wiring.

Separate the rams.

Remove the bolts.

