

4 Sheet metal work

40 GENERAL

41 LOWER STRUCTURE

43 UPPER SIDE STRUCTURE

44 UPPER REAR STRUCTURE

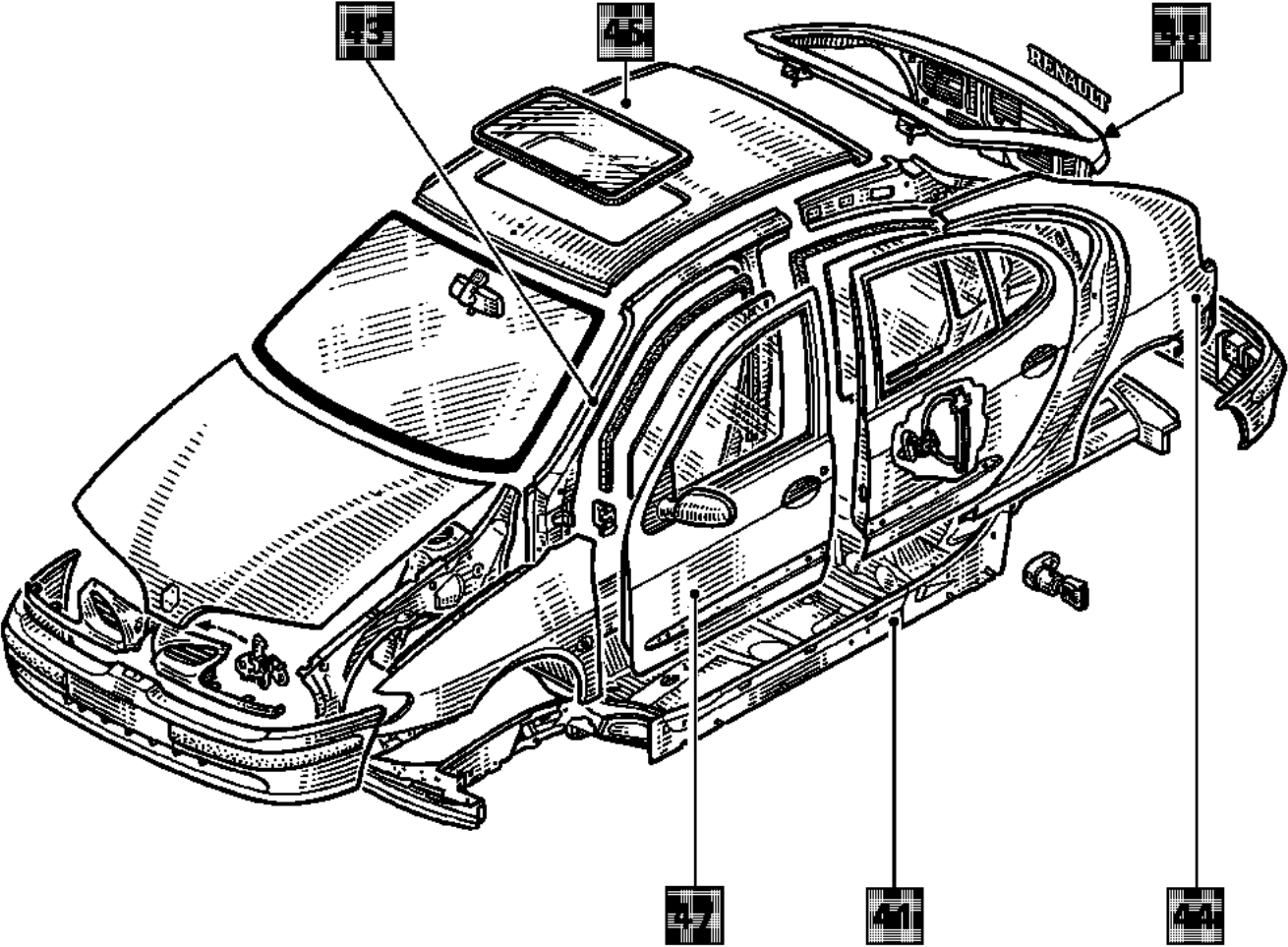
45 TOP OF BODY

47 SIDE OPENING ELEMENTS

48 NON-SIDE OPENING ELEMENTS

KA0X

EXPLODED VIEW

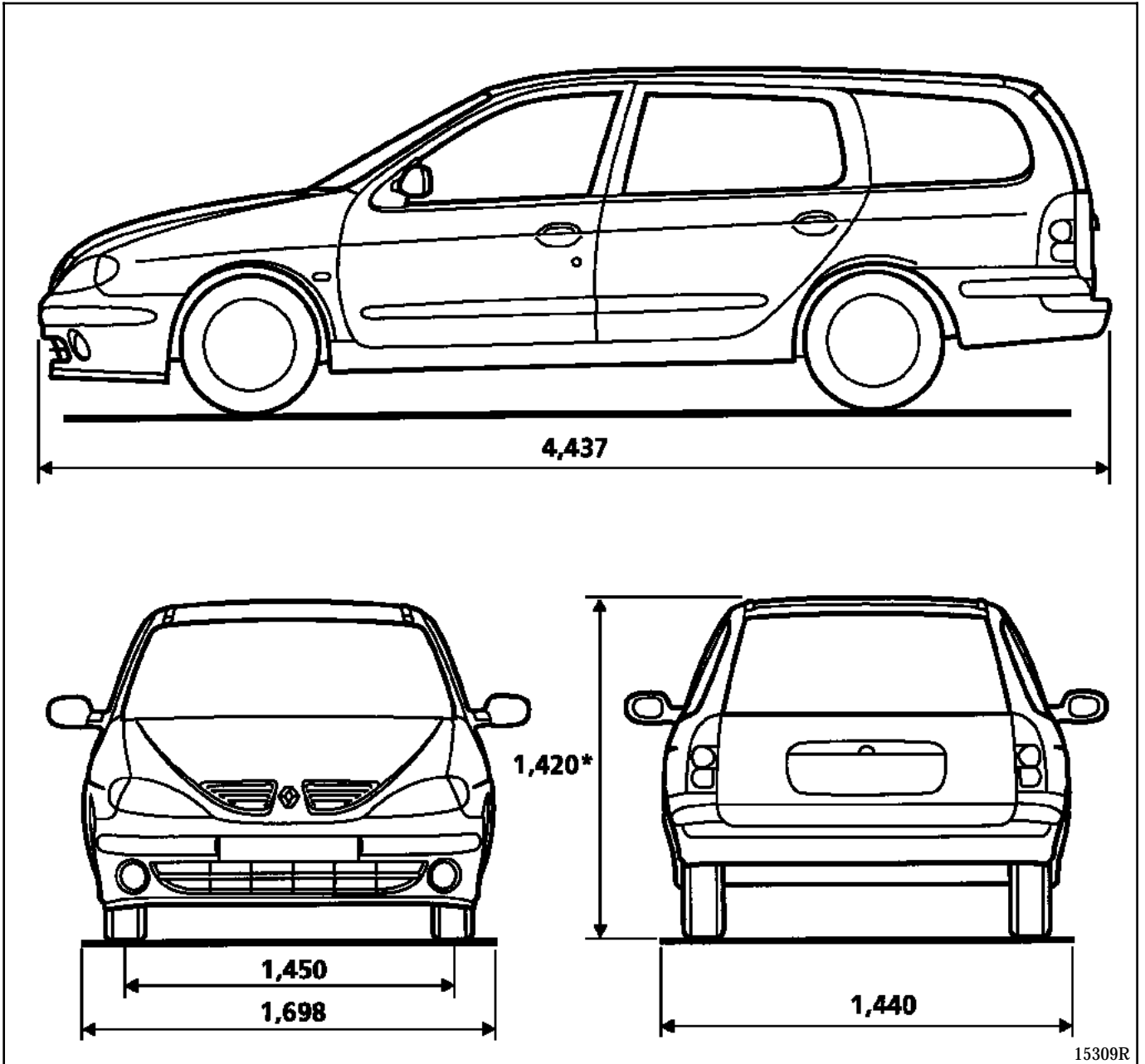


Sheet metal work

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43 UPPER SIDE STRUCTURE			
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Dimensions in metres



* Unladen.

Vehicle type	Version	Engine					
		Type	Ratio	Injection	Capacity (cm ³)	Idle speed (rpm)	Fuel type
KA0M KA0V	1.4 l	E7J	9.5/1	Multipoint	1390	Non-adjustable	Unleaded 95 or 98 (1)
KA0W KA0D	1.4 l 16 V	K4J	10/1	Multipoint	1390	Non-adjustable	Unleaded 95 or 98 (1)
KA04 KA0B	1.6 l 16 V	K4M	10/1	Multipoint	1598	Non-adjustable	Unleaded 95 or 98 (1)
KA0J VA0J	1.9 l D	F8Q	21.5/1	Indirect	1870	825±50	Diesel
KA05 VA05 KA0N VA0N KA01 VA01	1.9 l Dti	F9Q Turbo	18.3/1	Direct	1870	850±50 Non-adjustable	Diesel

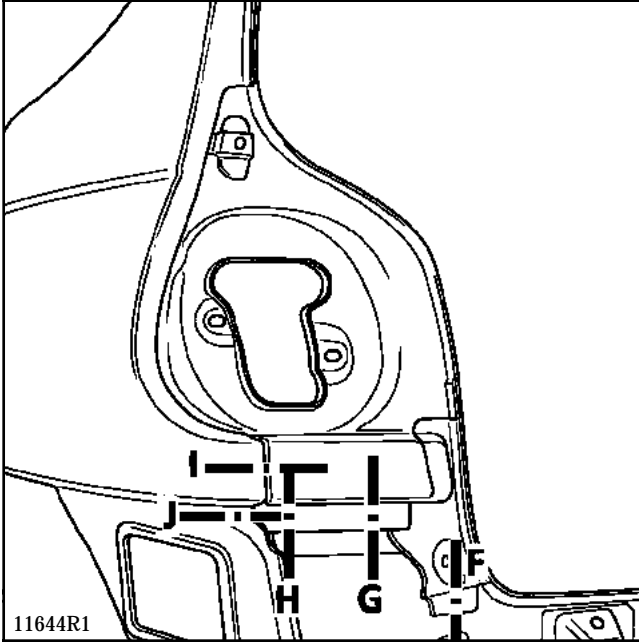
(1) If necessary, unleaded fuel with an octane rating of 91 may be used.

Identification



Vehicle	Rim	Tyres	Tyre inflation pressure - cold (bar) (1)	
			Front	Rear
KA0M/KA0V KA0W/KA0D	5.5 J 14	175/70 R 14	2.2	2.0
KA04/KA0B	6.0 J 15	185/60 R 15	2.2	2.0
KA0J/VA0J	6.0 J 15	175/70 R 14	2.2	2.0
KA0N/VA0N KA05/VA05 KA01/VA01	6.0 J 15	185/60 R 15	2.2	2.0

(1) Fully laden and motorway use.

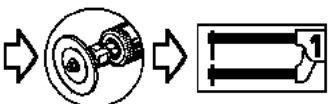
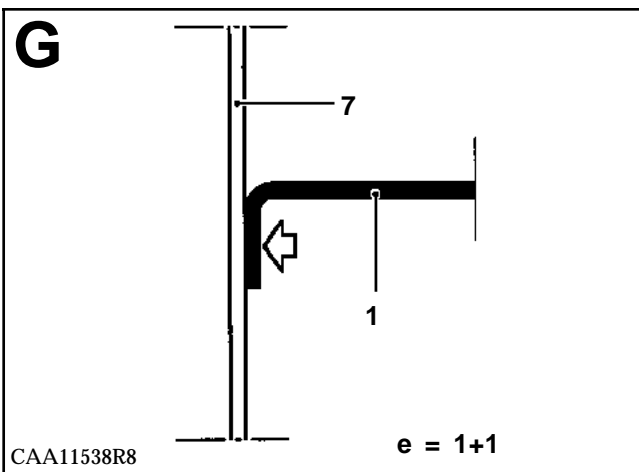
Tightening torque for wheel nuts : **9 daN.m**
Rim run-out: **1.2 mm**




The above diagram shows parts on the vehicle for which a section of the panel butt welding joint is shown by the diagrams which follow.

 This dashed line shows the centre line of the sections
 The point shows the exact position of the weld joint

F - G -
H - I - J
 This letter designates the drawing corresponding to the section (It is given in one of the upper corners of each drawing)




The following indications are found in the section diagrams :

 The part in black is the one which will be removed in the operation

1 and 7 are the part numbers corresponding to the list on the introduction page

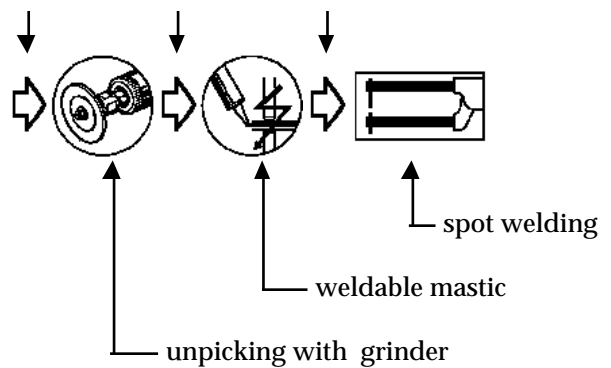
e = 1 + 1 are the thicknesses (in mm) of the panels affected by the spot weld

 This arrow on the diagram designates the access point for the unpicking of spot welds (see specific cases)

It also indicates the logical sequence of operations in the symbols which follow each diagram.

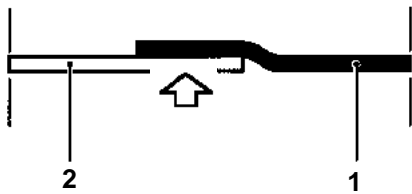
Example :

place of operation and logical sequence

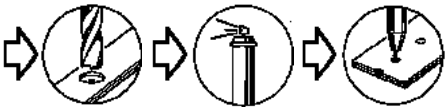


SPECIFIC CASES

J

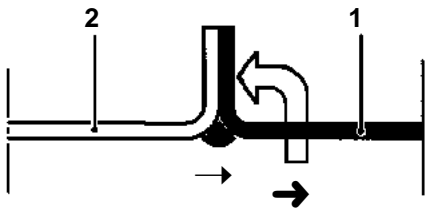


CAA11537-1R6

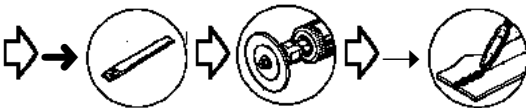


In this example, there is no direct access for removing part 1. The spot welds should be unpicked through part 2, which should be kept.

I



CAQ11697-1R5



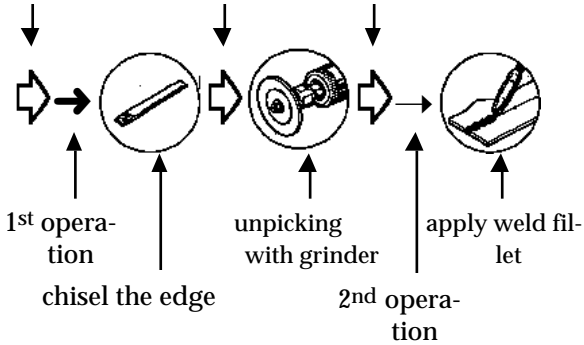
This arrow indicates that it is necessary to cut the part it crosses before accessing the joint.

The references which follow indicate different operations :

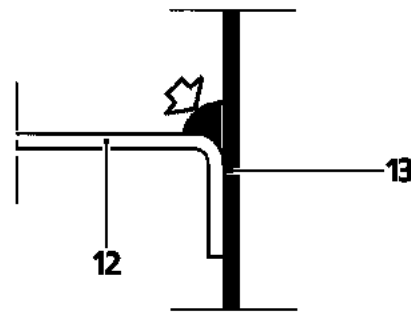
- unpicking
- welding

Under diagram I

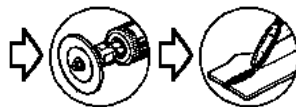
site of operation and order of operations



D

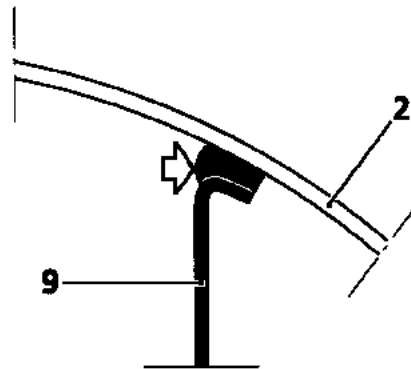


10354R



In this particular case, the arrow indicates that the joint is made by arc welding (MIG).

E




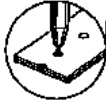







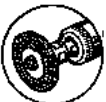








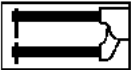
10349R



In this example, the joint is made by bonding.

GENERAL Key to symbols

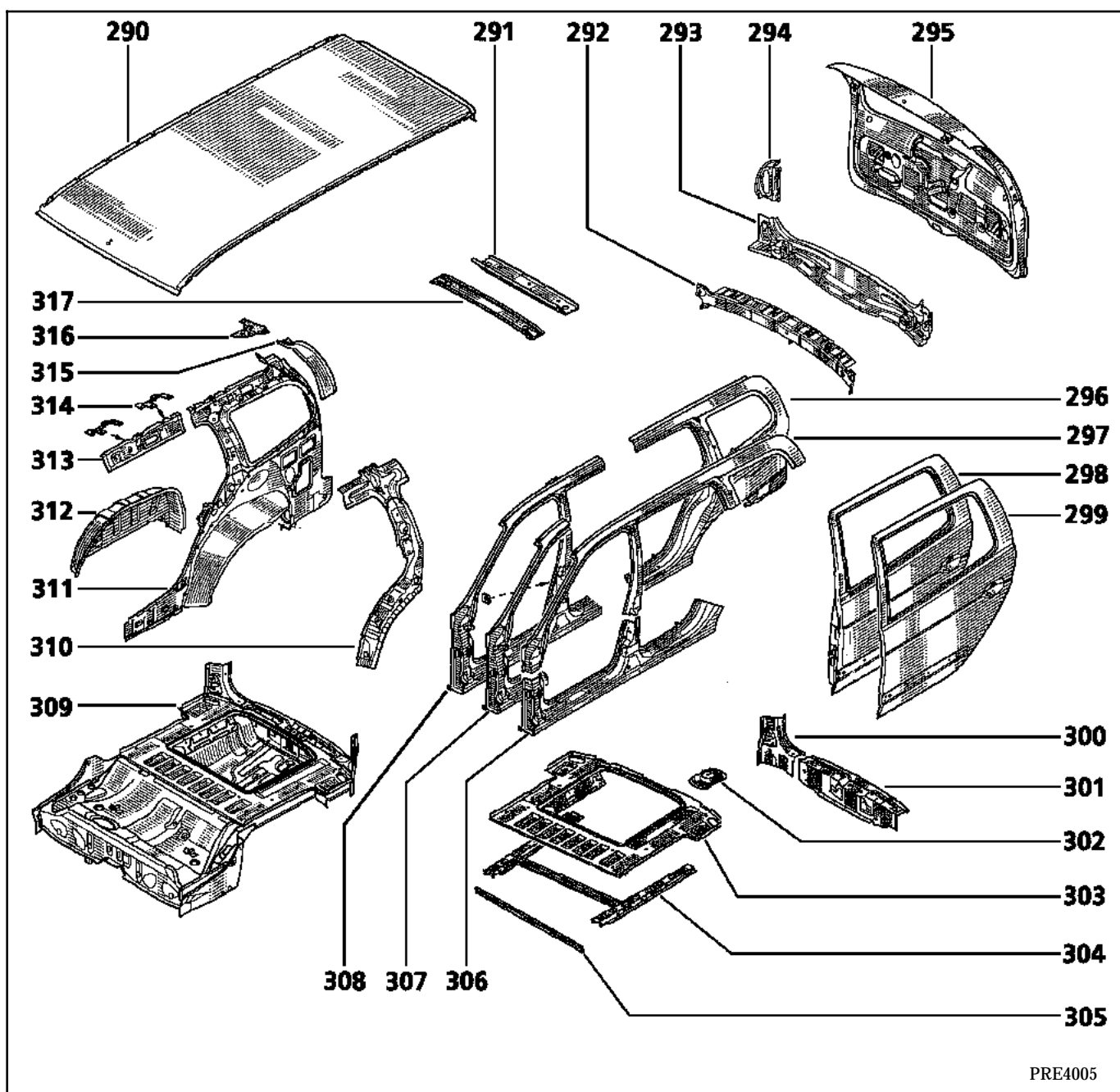
40

	Chiselling		Plug welding. Under MAG gas protection.
	Grind back beads or spot welds. Straight grinding wheel with 75 mm diameter bakelite impregnated disc, thickness 1.8 to 3.2 mm.		Crimping of exterior door panels.
	Grind back spot welds. 20 000 rpm straight grinder with 10 or 16 mm diameter spherical burr.		Safety symbol. This means that the welding operation in question concerns one or more of the vehicle's vital safety components.
	Drill spot welds. Hardened steel bit. Speed of rotation 800 to 1 000 rpm.		Body solder - lead fill. Hot air torch. Nozzle output temperature 600° min. Slipper+ 33 % tin solder + tallow. Note : to a large extent, body solder filling compensates for the heat distortion caused by welding.
	Unpicking		
	Cleaning surfaces to be welded. 100 mm diameter fibre disc.		Application of weldable mastic. This mastic conducts electricity, applied between two panels to be spot welded, it ensures the seal between the panels and avoids corrosion of the spot welds.
	Cutting with a saw. Pneumatic power hacksaw.		
	- Cutting out part by grinding off flange or grinding back remaining traces of spot weld. - Finish surface after welding. - Angle grinder equipped with a rubber pad and a 120 to 180 mm diameter fibre disc grain size P36.		Application of aluminium paint. This is to be applied to the joint faces of each of the parts to be plug welded. The paint conducts electricity and is resistant to high temperatures. It provides anti-corrosion protection around the plug welds.
	Unsoldering.		
	MAG stitch weld Note : to obtain a good quality weld we recommend the use of a gas consisting of argon + 15 % CO2. This is considered to be an active gas (MAG).		Apply a fillet of extruded mastic <ul style="list-style-type: none"> • from a manual or pneumatic spray gun. • one or two pot mastic for crimped and butt joints.
			Spray on sealer <ul style="list-style-type: none"> • spray gun. • two pot anti-gravel and anti-corrosion mastic.
	Spot weld		

GENERAL

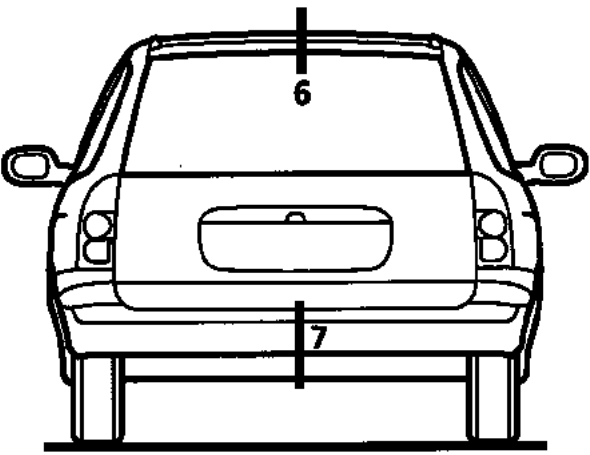
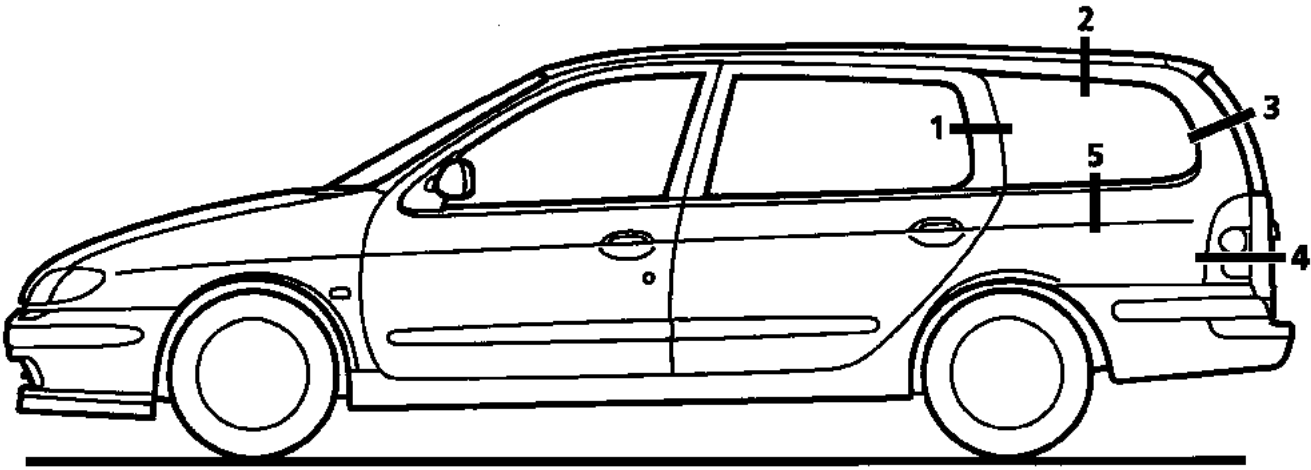
Description of parts (exploded view)

40

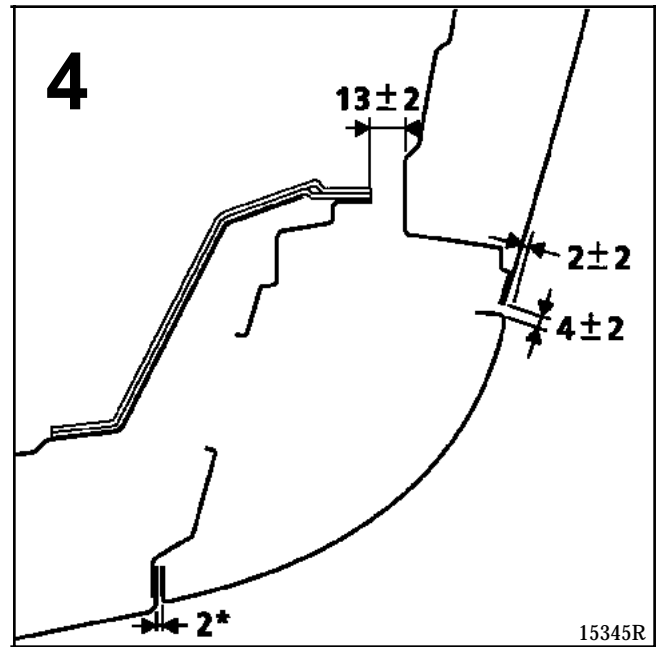
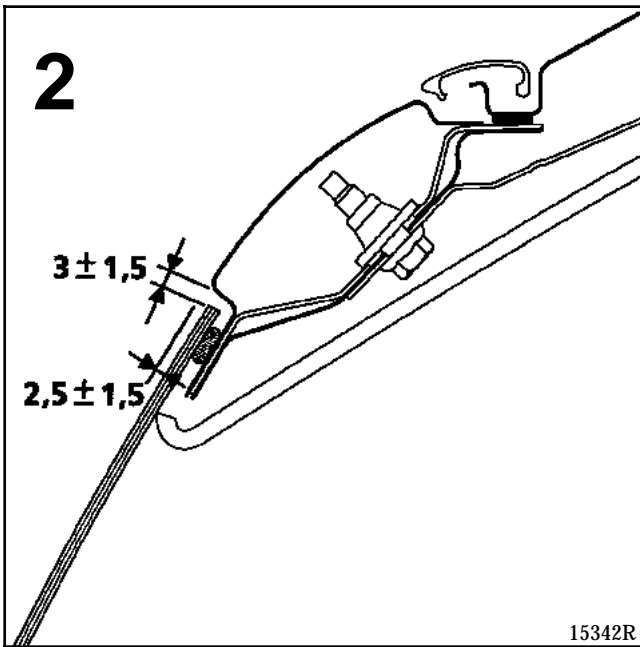
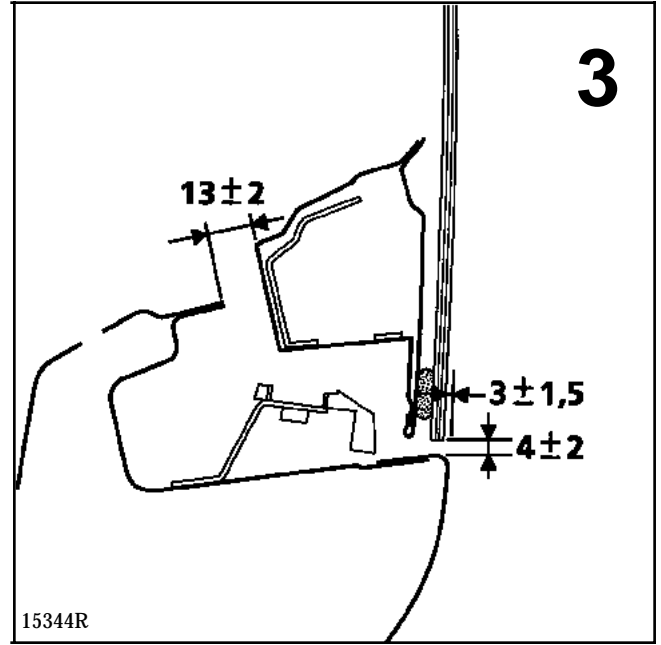
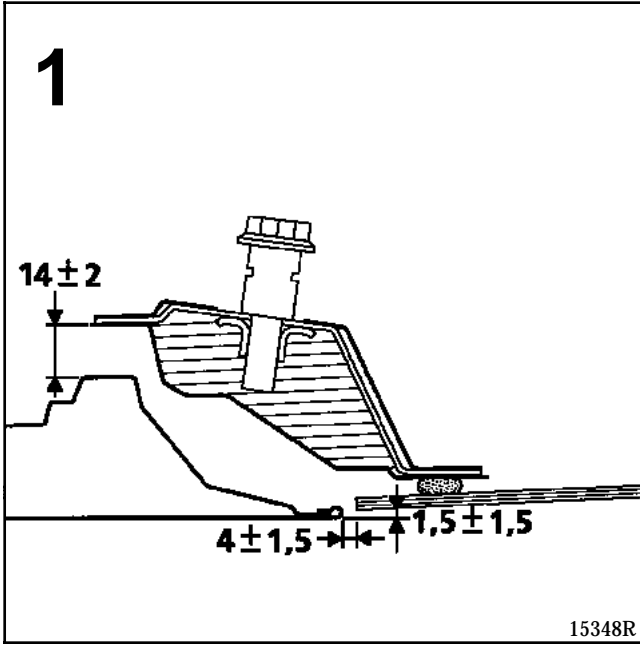


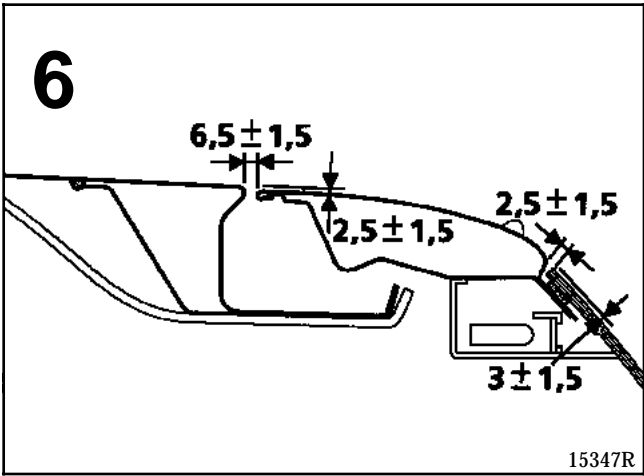
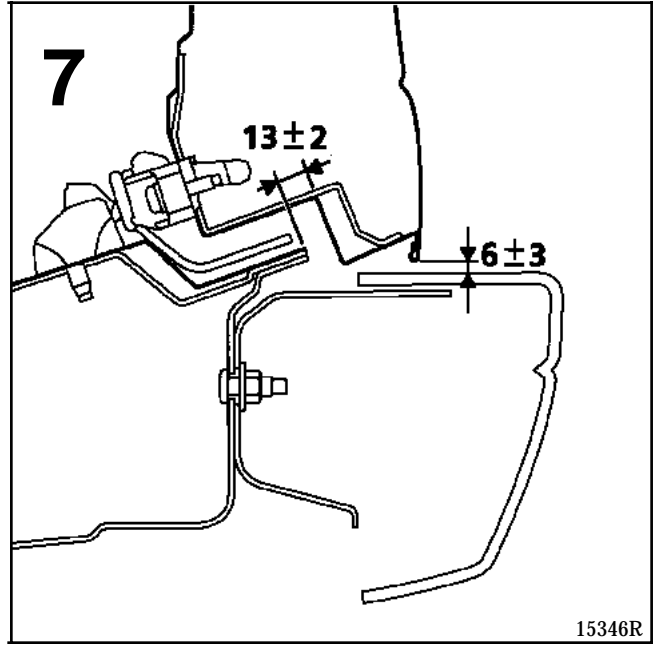
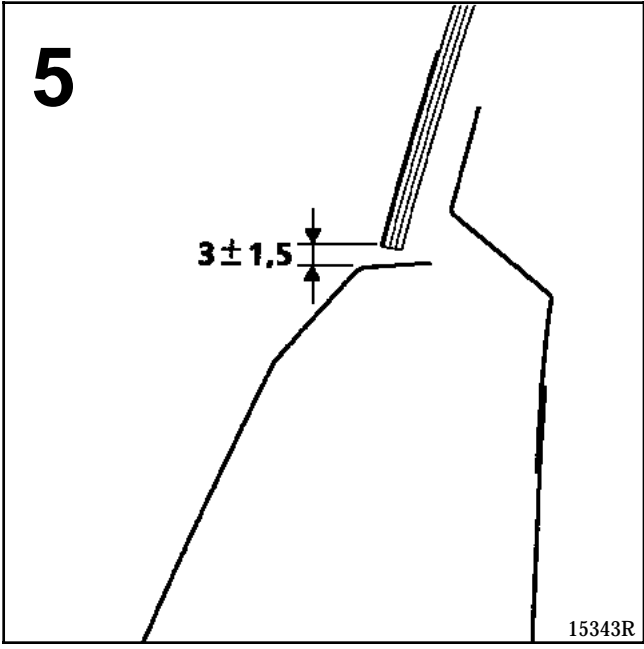
- | | | | |
|-------|--|-------|------------------------------------|
| 290 | Roof | 304 | Base support |
| * 291 | Roof rear cross member | 305 | Base stiffener |
| 292 | Absorber support | * 306 | Sill panel |
| 293 | Rear end panel | * 307 | Front pillar |
| 294 | Lights mounting | * 308 | Body side, front section |
| 295 | Tailgate | 309 | Rear floor unit |
| * 296 | Wing panel | 310 | Rear pillar reinforcement |
| * 297 | Top of body | * 311 | Rear quarter panel lining assembly |
| * 298 | Rear door | 312 | Inner wheel arch |
| * 299 | Rear door panel | 313 | Stretcher extension |
| 300 | Rear end pillar lower reinforcement | 314 | Roof cross member support |
| * 301 | Rear end cross member | * 315 | Wing panel drip moulding |
| 302 | Emergency spare wheel mounting support | 316 | Speaker support |
| 303 | Rear floor base | 317 | Roof stiffener |

* Parts for which repaired areas must be electro zinc plated



15072R2





LOWER STRUCTURE

Absorber support mounting

41**A**

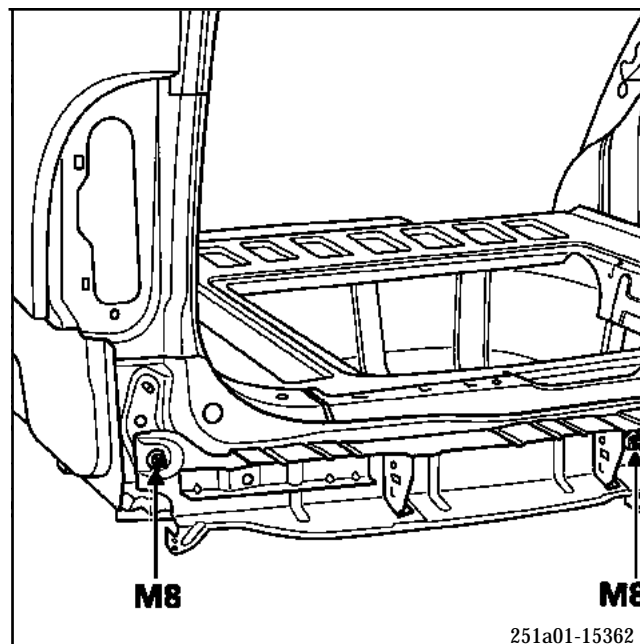
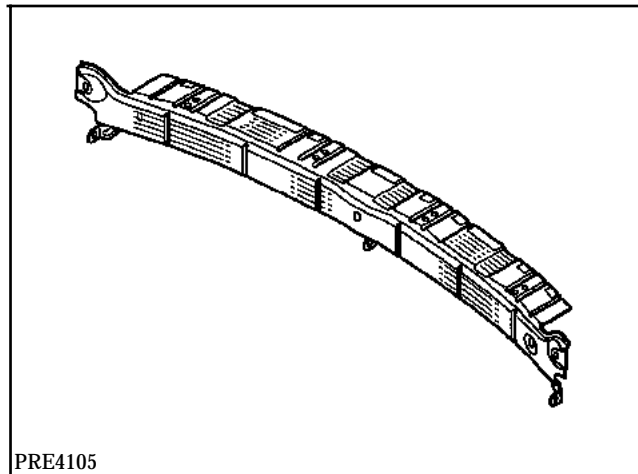
INTRODUCTION

Basic operation for a rear impact.

This part is mounted by three M8 nuts on the rear end panel.

COMPOSITION OF PART FROM PARTS DEPARTMENT

Single part.



LOWER STRUCTURE
Rear floor base

41B

This part may be replaced in two ways:

- A completely, as a complementary operation to the rear end cross member.
- B by part section, as a complementary operation to the rear end pillar lower reinforcement.

The method described only contains descriptions of joints specific to the part concerned. Joints with complementary parts are not included.

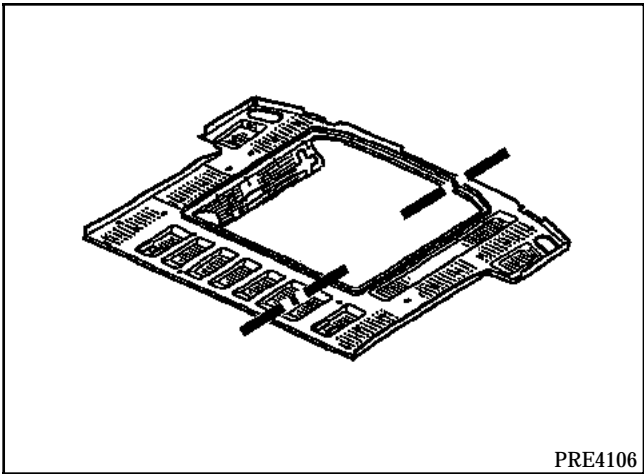
These are dealt with in their respective section (refer to the contents page).

COMPOSITION OF PART FROM PARTS
DEPARTMENT

Single part.

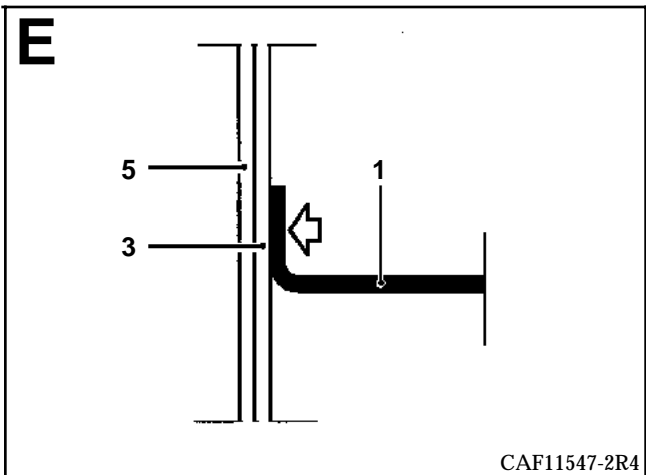
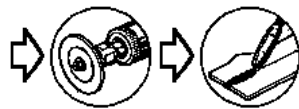
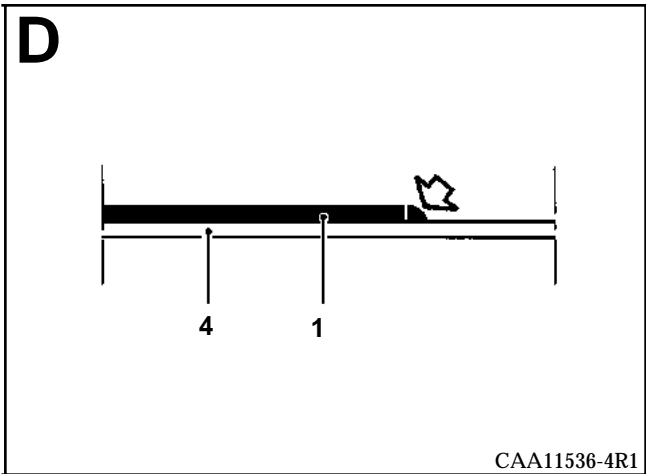
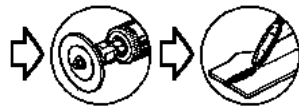
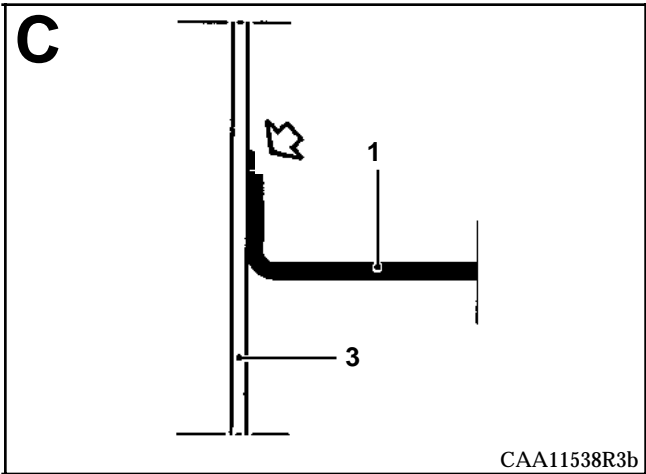
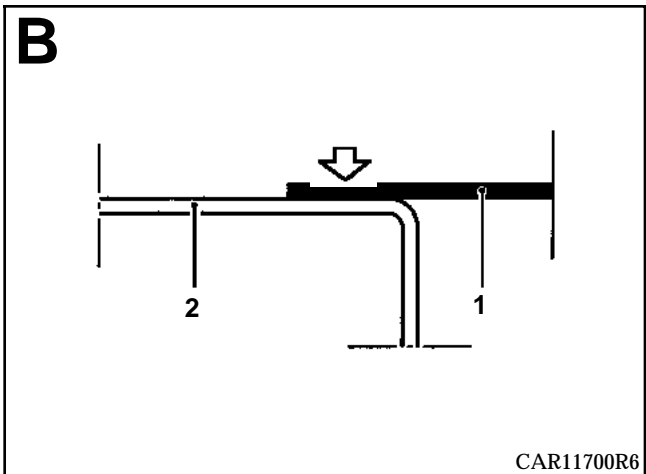
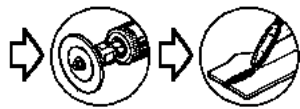
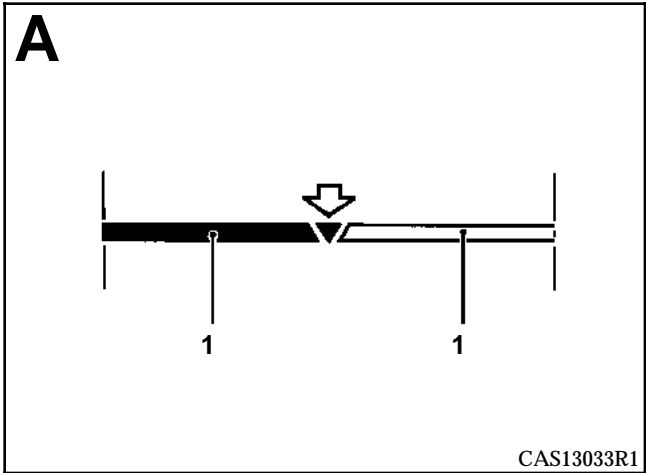
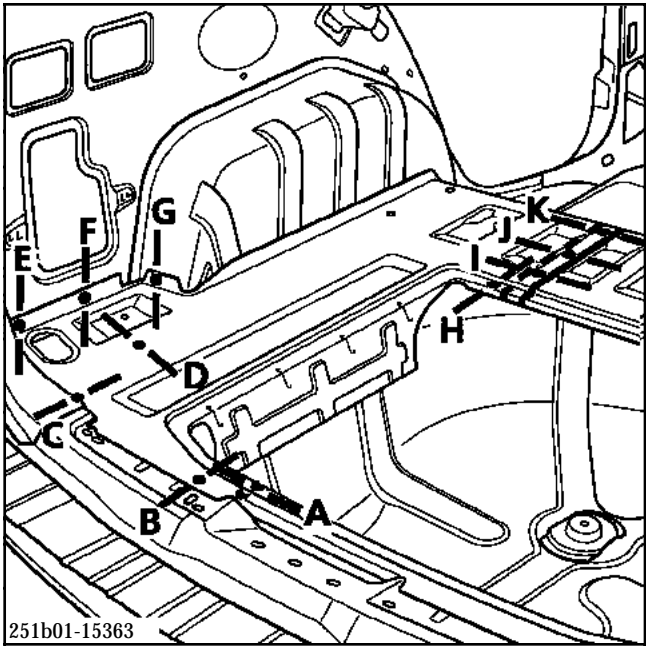
PARTS CONCERNED (thickness in mm) :

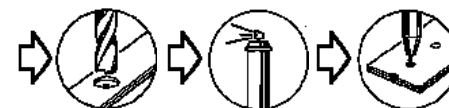
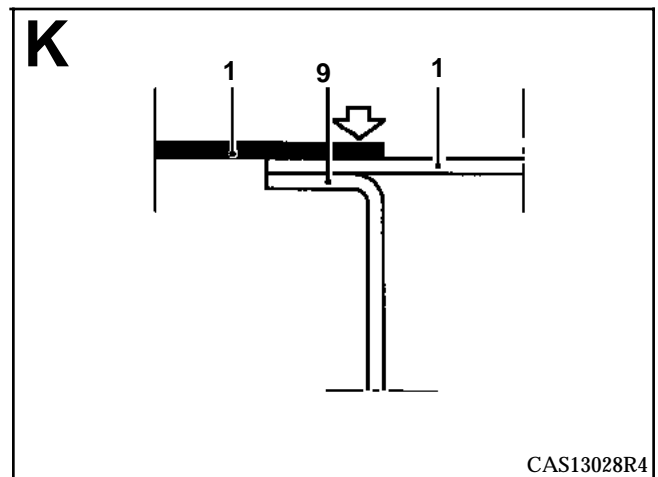
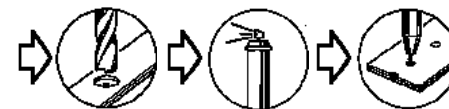
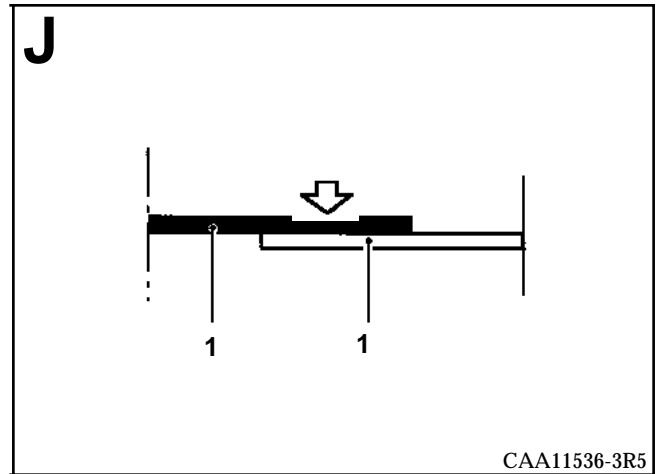
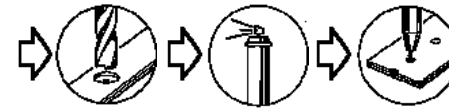
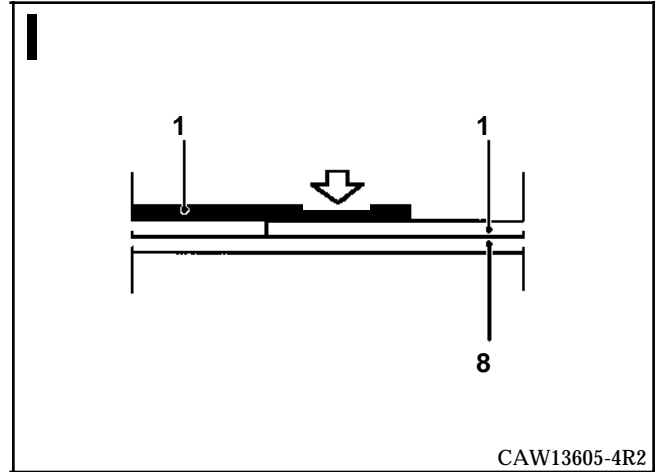
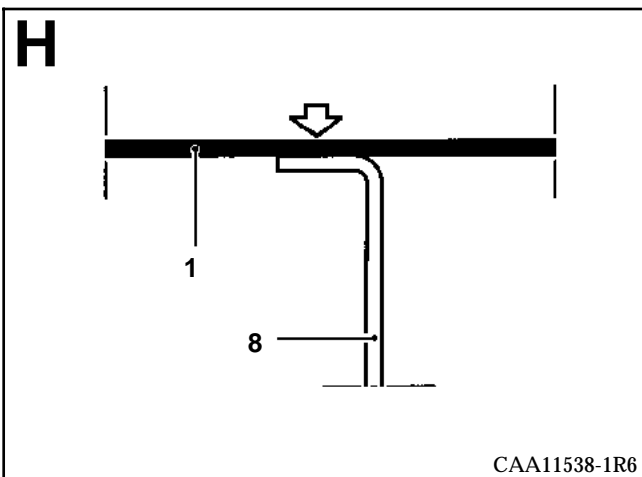
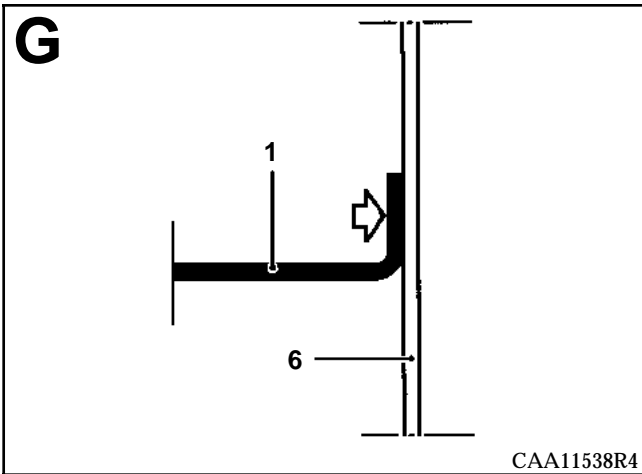
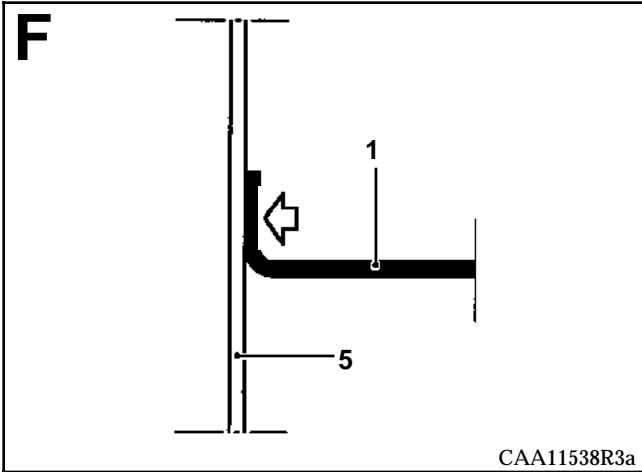
1	Rear floor base	0.8
2	Rear end cross member	0.8
3	Rear end pillar lower reinforcement	1
4	Rear floor	0.7
5	Body side lining	0.7
6	Rear inner wheel arch	0.8
7	Rear floor base side side-member	1
8	Rear floor base intermediate stiffener	0.8
9	Rear floor base front stiffener	0.8



LOWER STRUCTURE
Rear floor base

41 B





INTRODUCTION

The replacement of this part is a complementary operation to the rear floor base.

The method described only contains descriptions of joints specific to the part concerned. Joints with complementary parts are not included.

These are dealt with in their respective section (refer to the contents page).

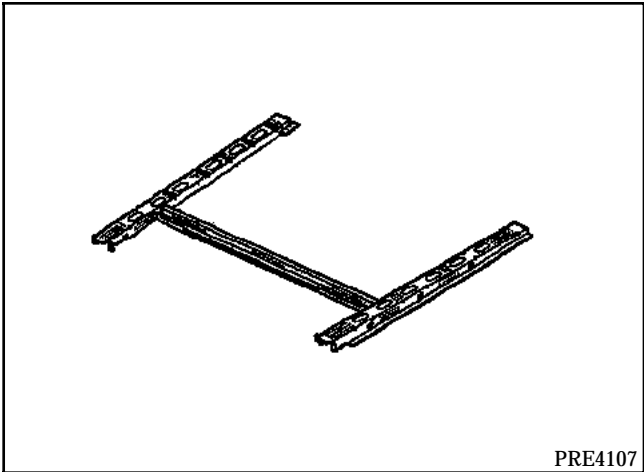
**COMPOSITION OF PART FROM PARTS
DEPARTMENT**

Part assembled with:

- rear floor base side side-member,
- rear floor base intermediate stiffener,
- rear floor base front stiffener.

PARTS CONCERNED (thickness in mm) :

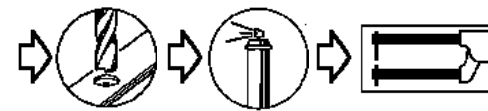
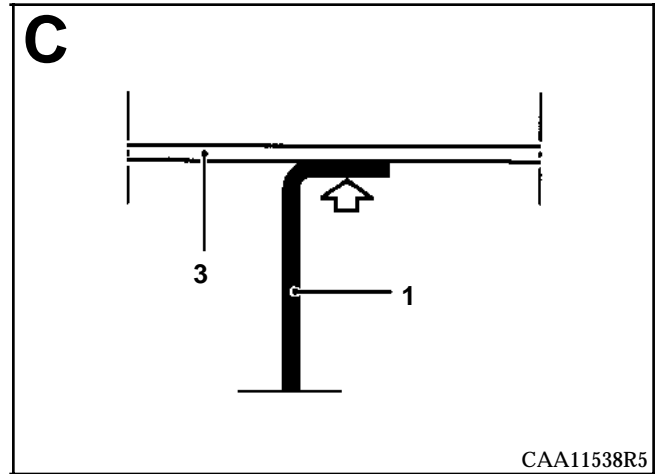
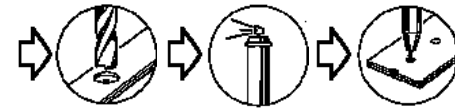
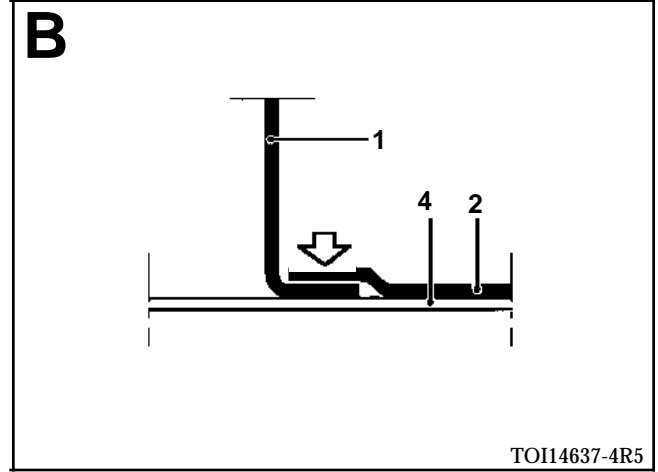
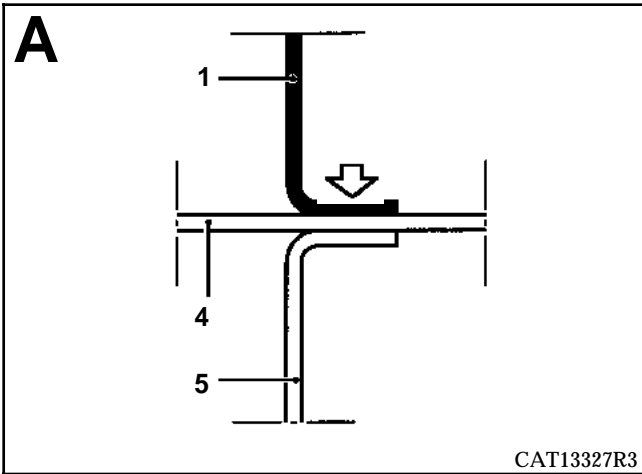
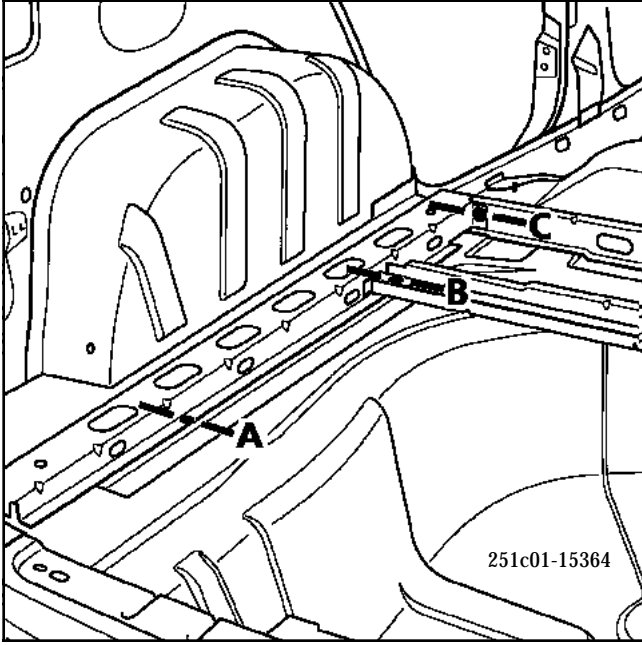
1	Rear floor base side side-member	1
2	Rear floor base intermediate stiffener	0.8
3	Rear floor base front stiffener	0.8
4	Rear floor	0.7
5	Rear side member	1.2



LOWER STRUCTURE

Rear floor base support

41 **C**



LOWER STRUCTURE

Rear floor base front stiffener

41 D

INTRODUCTION

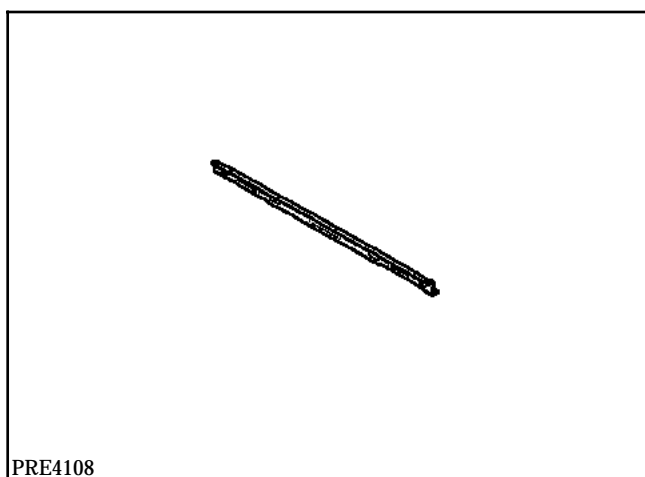
The replacement of this part is a complementary operation to the rear floor base support.

The method described only contains descriptions of joints specific to the part concerned. Joints with complementary parts are not included.

These are dealt with in their respective section (refer to the contents page).

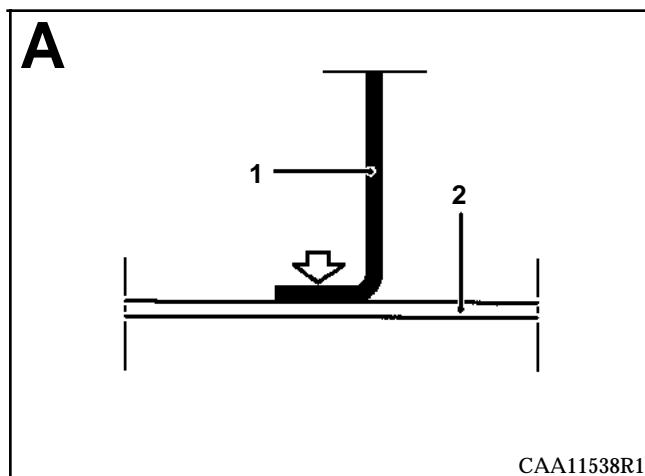
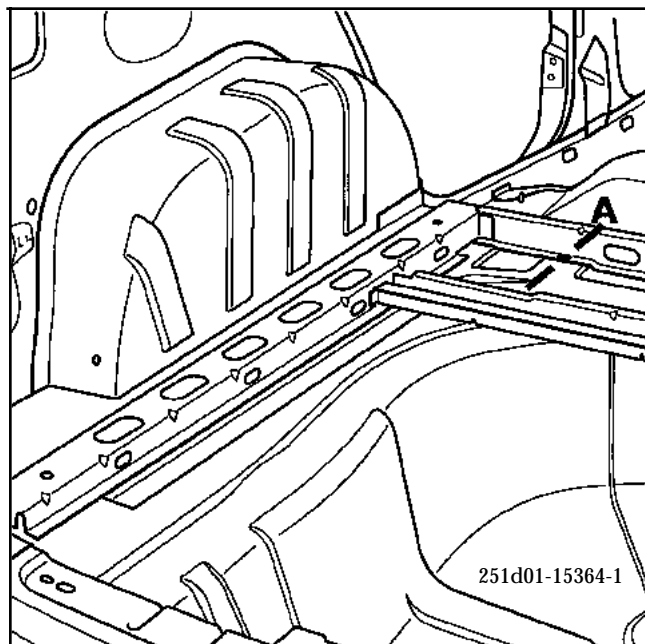
COMPOSITION OF PART FROM PARTS DEPARTMENT

Single part.



PARTS CONCERNED (thickness in mm) :

- | | | |
|---|---------------------------------|-----|
| 1 | Rear floor base front stiffener | 0.8 |
| 2 | Rear floor | 0.7 |



INTRODUCTION

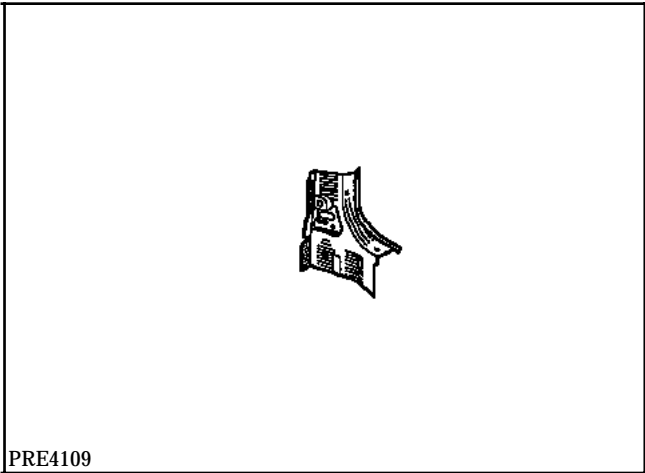
The replacement of this part is a complementary operation to the rear end cross member.

The method described only contains descriptions of joints specific to the part concerned. Joints with complementary parts are not included.

These are dealt with in their respective section (refer to the contents page).

COMPOSITION OF PART FROM PARTS
DEPARTMENT

Part assembled with welded nuts.

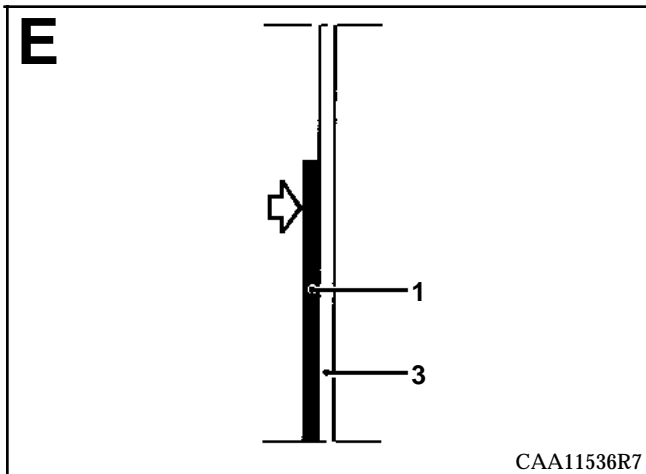
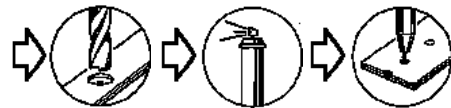
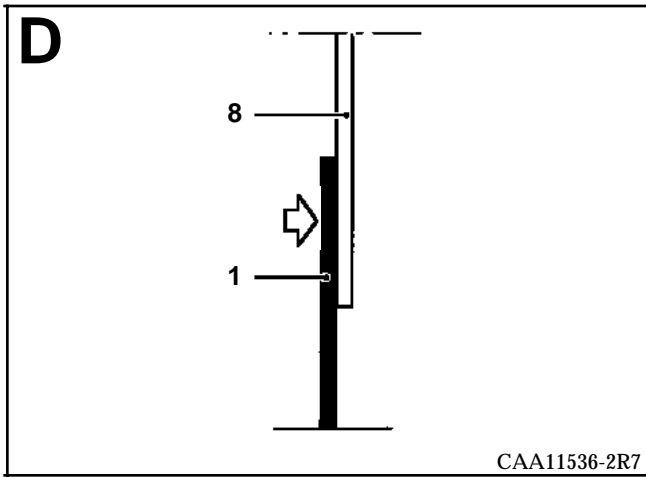
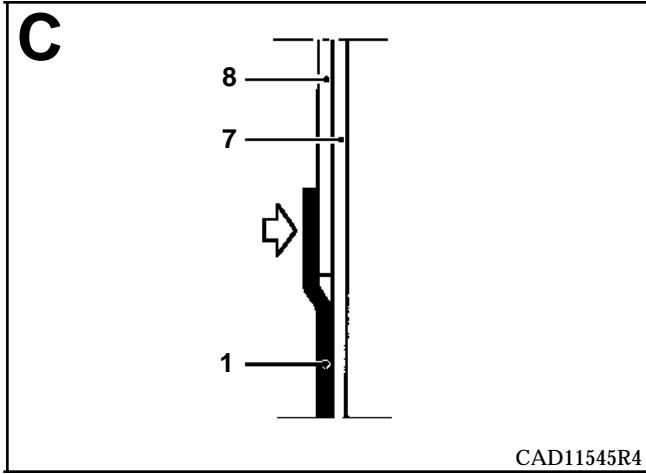
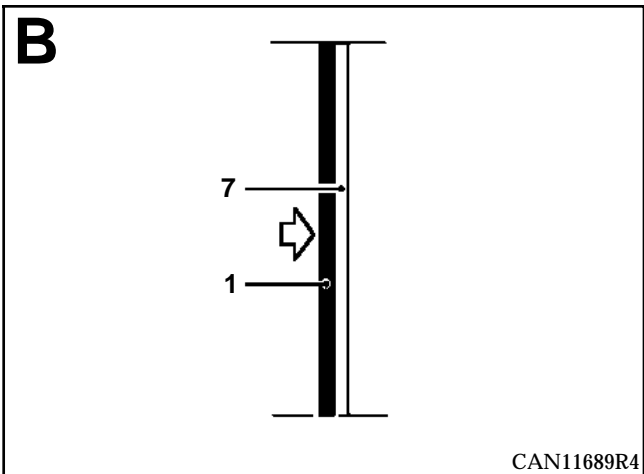
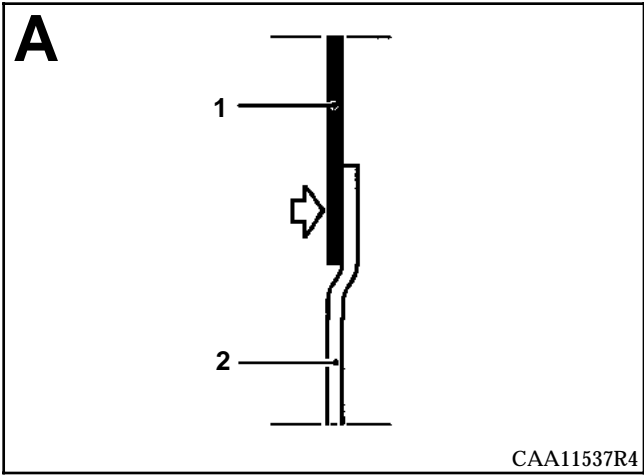
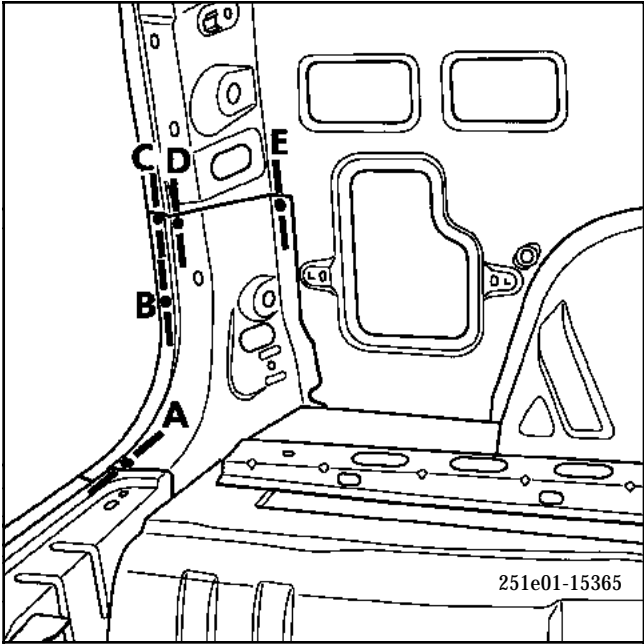


PARTS CONCERNED (thickness in mm) :

1	Rear end pillar lower reinforcement	1
2	Rear end cross member	0.8
3	Body side lining	0.7
4	Rear end pillar lining	1
5	Rear floor	0.7
6	Rear side member	1.2
7	Lights mounting	0.7
8	Rear end pillar lining	1

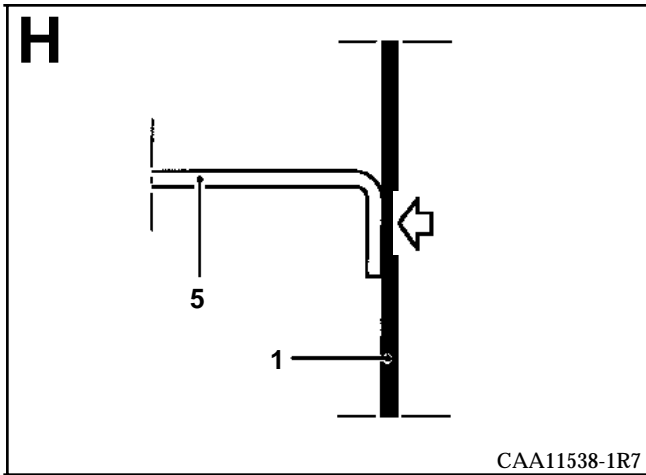
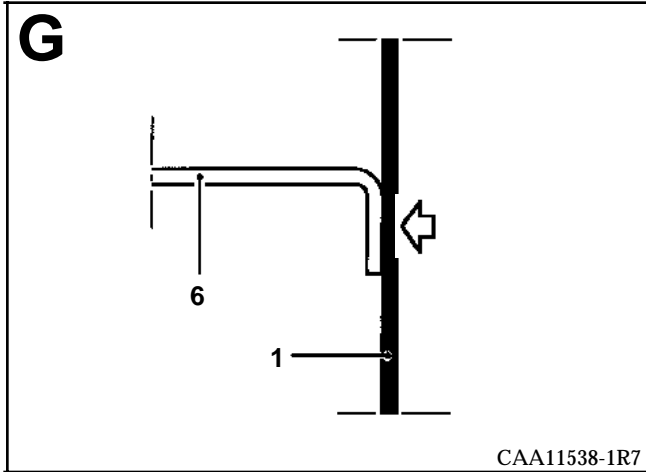
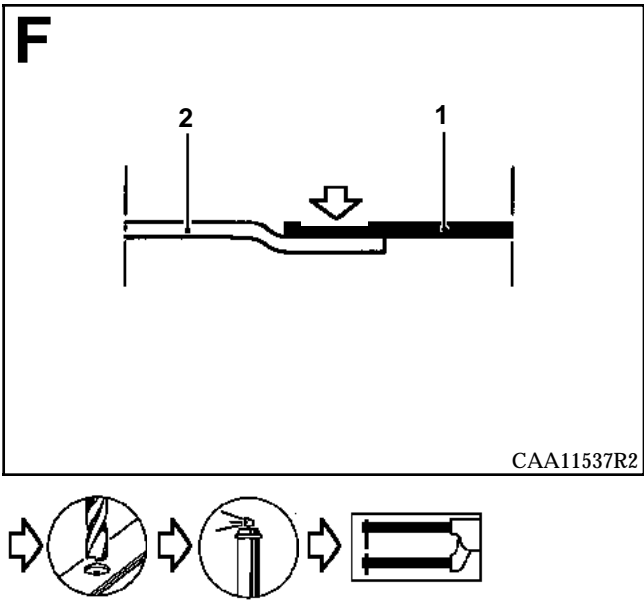
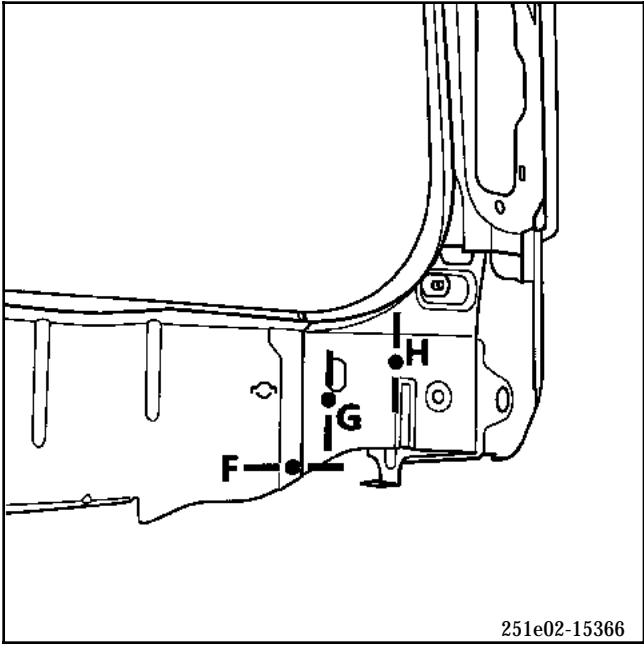
LOWER STRUCTURE
Rear end pillar lower reinforcement

41 **E**



LOWER STRUCTURE
Rear end pillar lower reinforcement

41 **E**



INTRODUCTION

The replacement of this part is a complementary operation to the rear end panel.

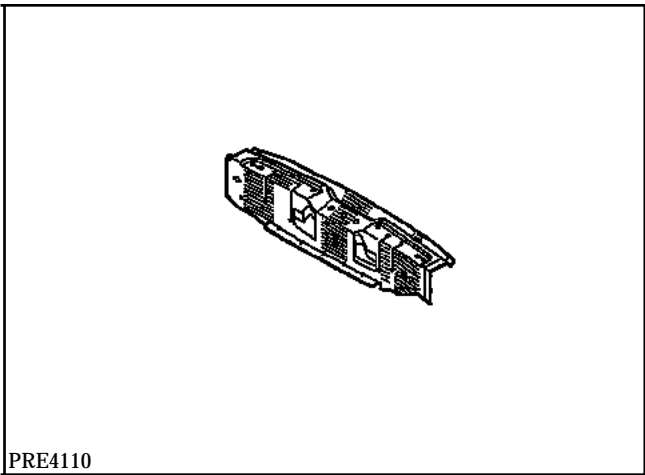
The method described only contains descriptions of joints specific to the part concerned. Joints with complementary parts are not included.

These are dealt with in their respective section (refer to the contents page).

**COMPOSITION OF PART FROM PARTS
DEPARTMENT**

Part assembled with:

- striker plate reinforcement,
- central reinforcement.

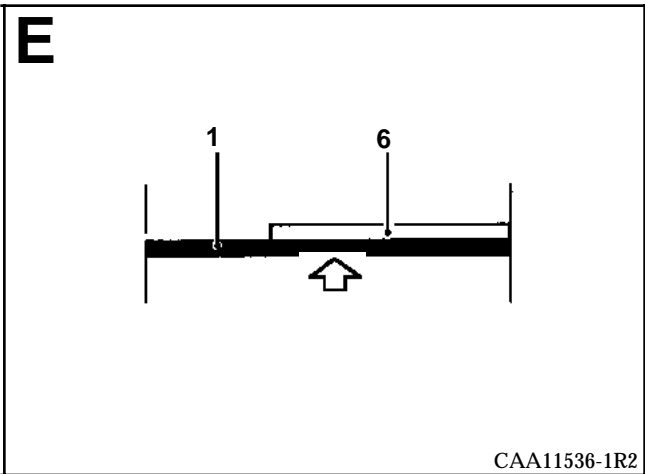
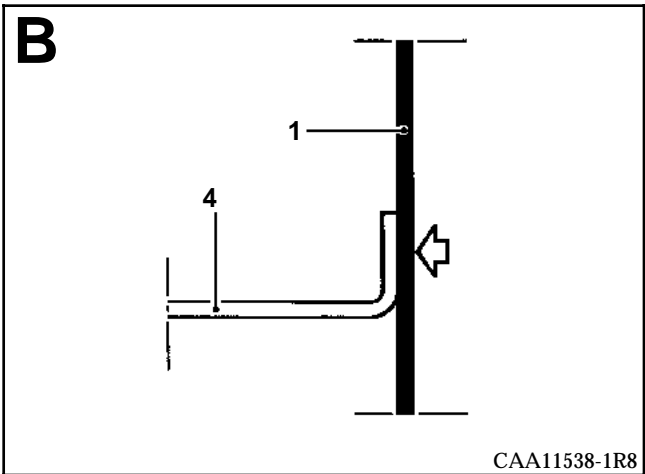
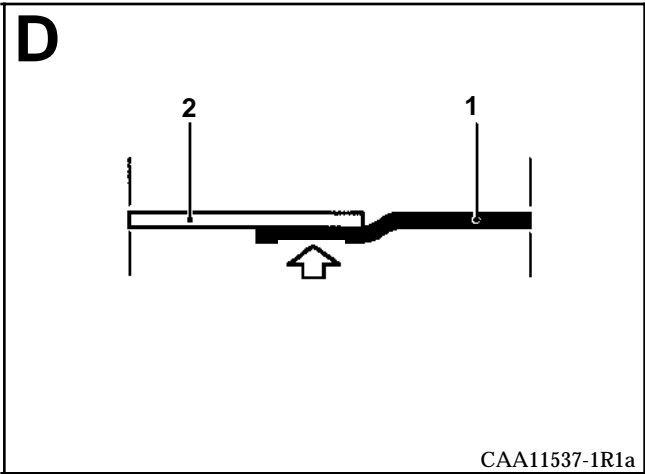
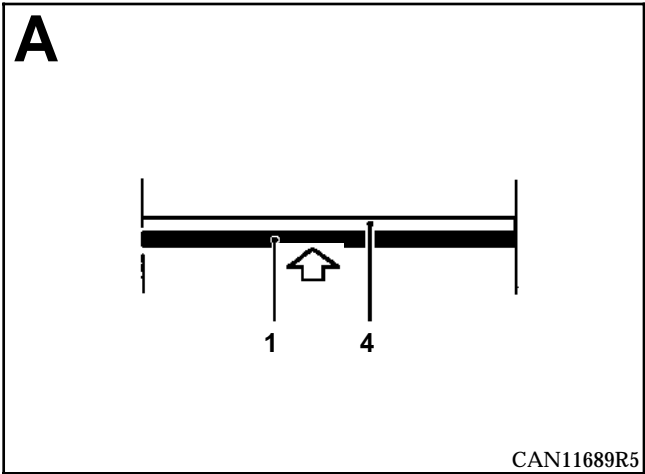
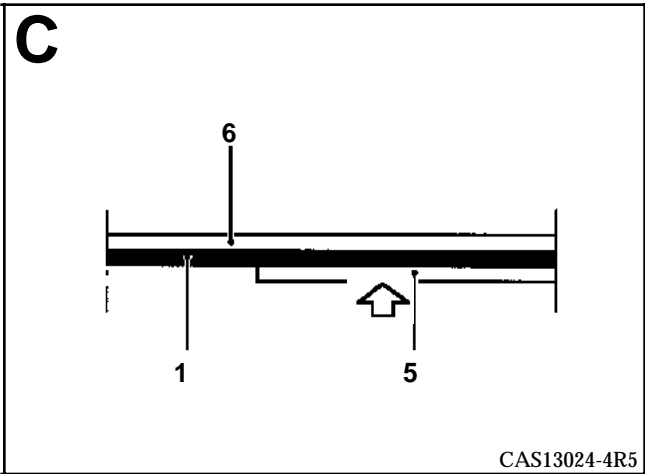
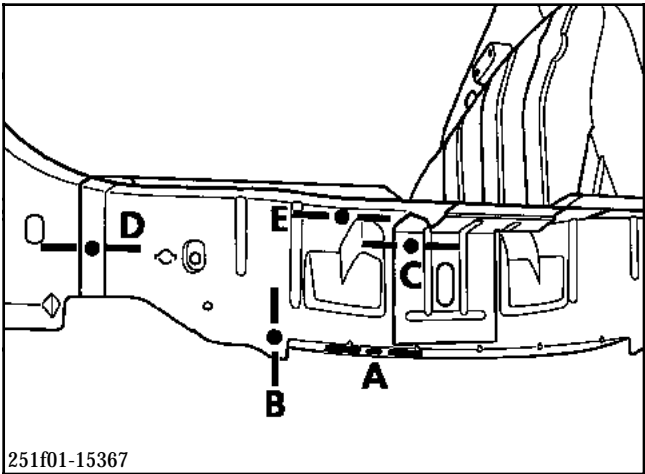


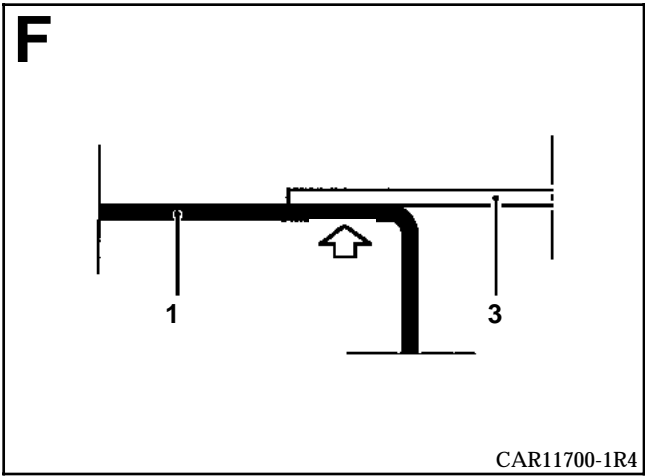
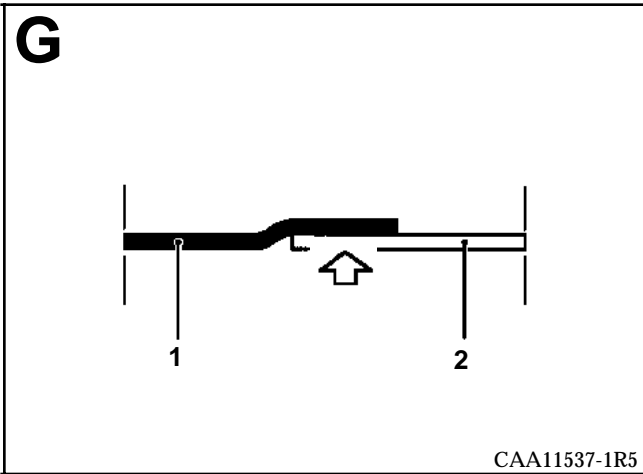
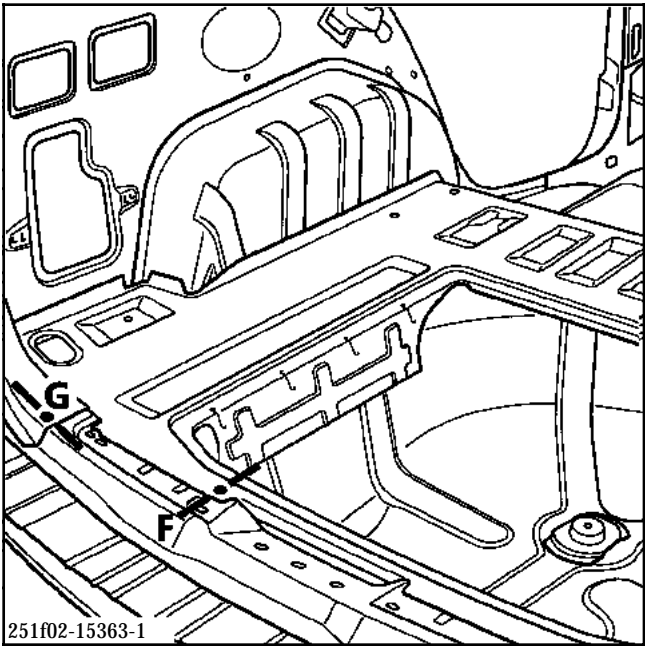
PARTS CONCERNED (thickness in mm) :

1	Rear end cross member	0.8
2	Rear end pillar lower reinforcement	1
3	Rear floor base	0.8
4	Rear floor	0.7
5	Tailgate striker plate central reinforcement	1.2
6	Rear floor central reinforcement	0.8

LOWER STRUCTURE
Rear end cross member assembly

41 F





INTRODUCTION

The replacement of this part is identical to the method described in the basic manual (M.R. 313 - Section 41). Only the joints at the rear end pillar lower reinforcements are different, which are described in this document (section 41-E).

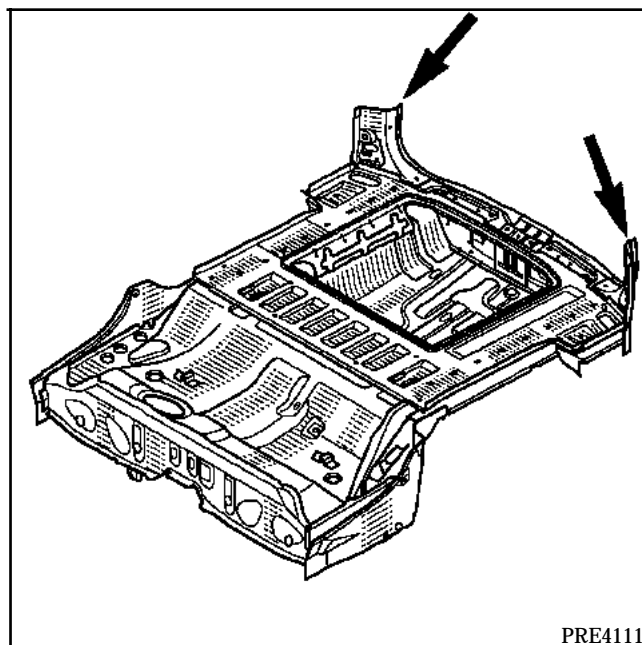
The method described only contains descriptions of joints specific to the part concerned. Joints with complementary parts are not included.

These are dealt with in their respective section (refer to the contents page).

COMPOSITION OF PART FROM PARTS DEPARTMENT

Part assembled with:

- side member assemblies,
- floor assembly,
- cross member under the floor,
- floor base assembly,
- rear end cross member assembly,
- rear end pillar reinforcement.



INTRODUCTION

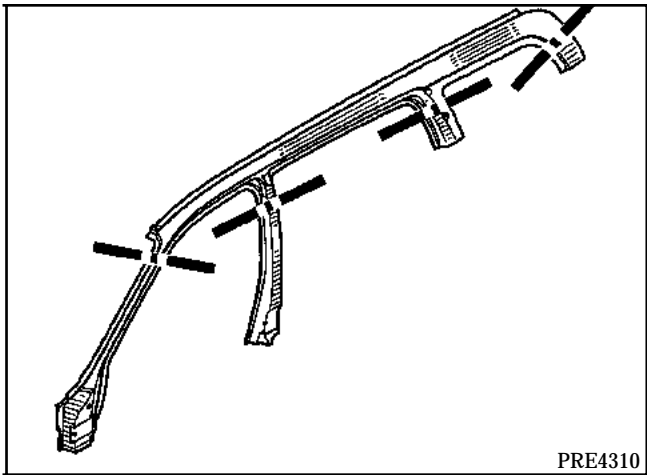
The replacement of this part is a complementary operation to the replacement of the roof for a front side impact.

The method described only contains descriptions of joints specific to the part concerned. Joints with complementary parts are not included.

These are dealt with in their respective section (refer to the contents page) and MR 313 for the front section.

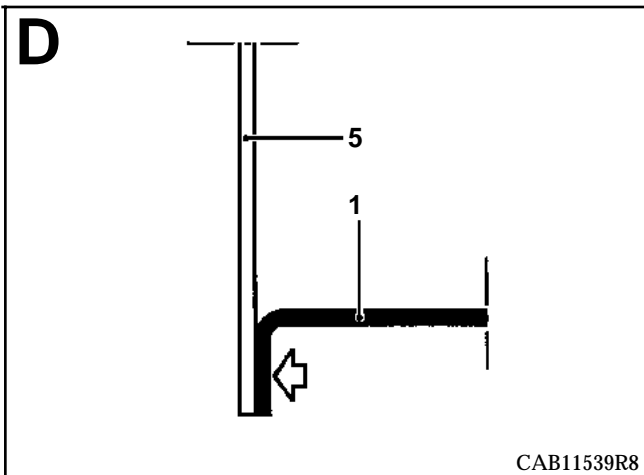
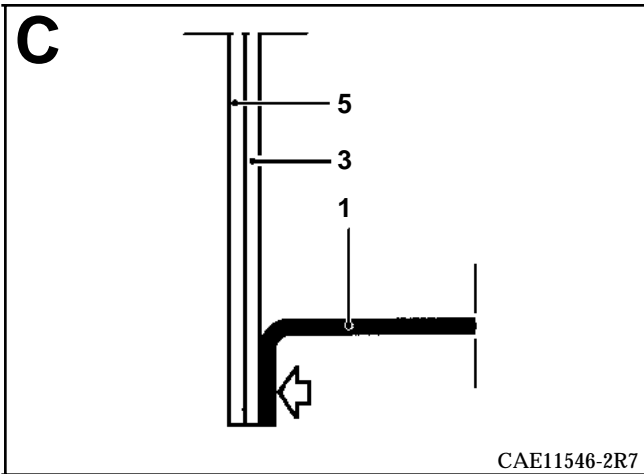
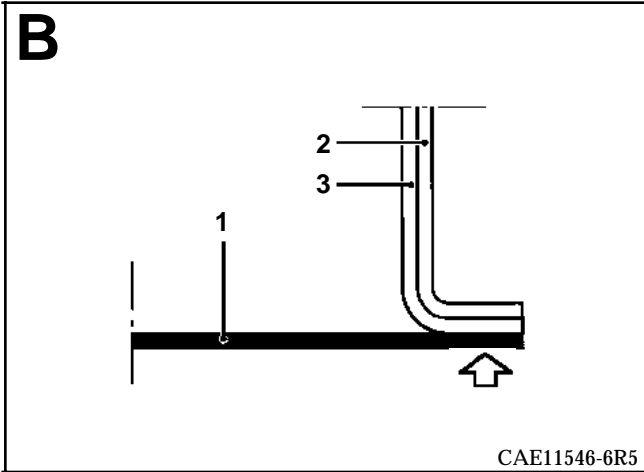
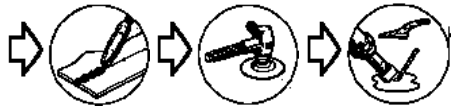
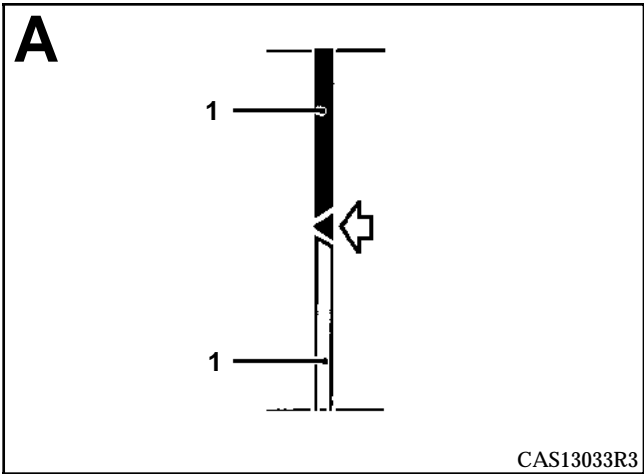
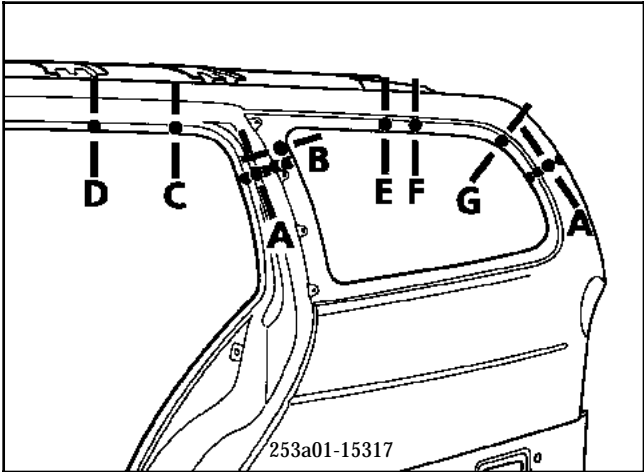
COMPOSITION OF PART FROM PARTS
DEPARTMENT

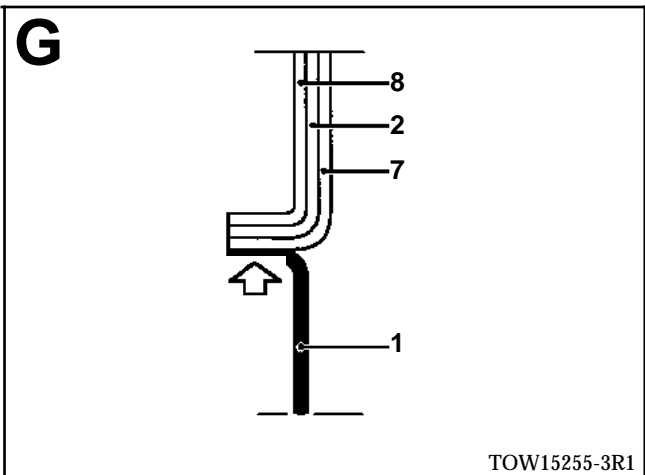
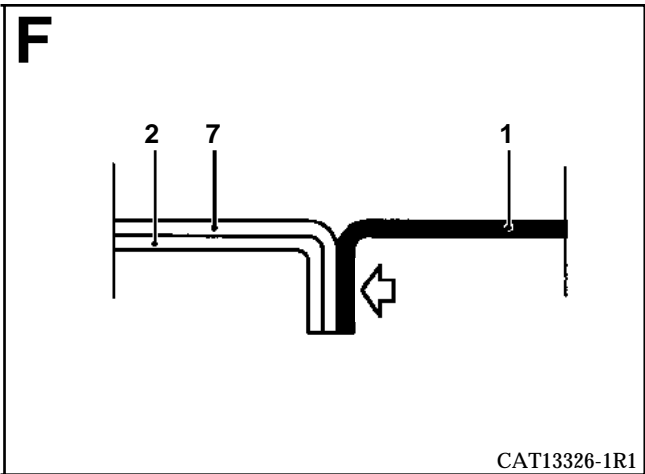
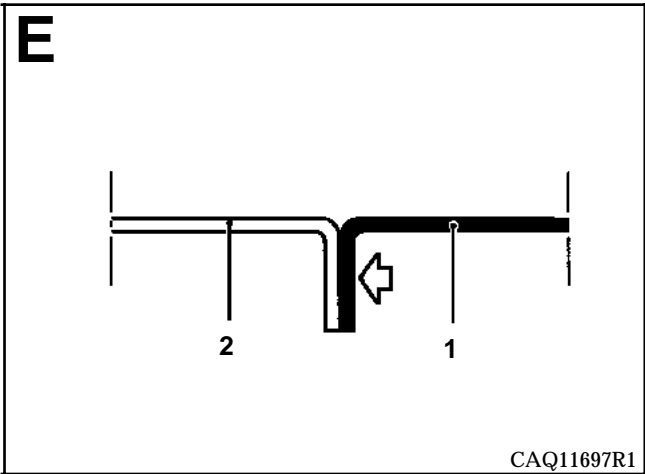
Part assembled with welded pin.



PARTS CONCERNED (thickness in mm) :

1	Body side	0.77
2	Rear quarter panel lining	0.7
3	Rear pillar upper reinforcement	1
4	Rear pillar lower reinforcement	1
5	Stretcher lining	1.2
6	Centre pillar reinforcement	1.5
7	Rear corner reinforcement	1.2
8	Rear end pillar lining	1
9	Rear upper side drip moulding	1

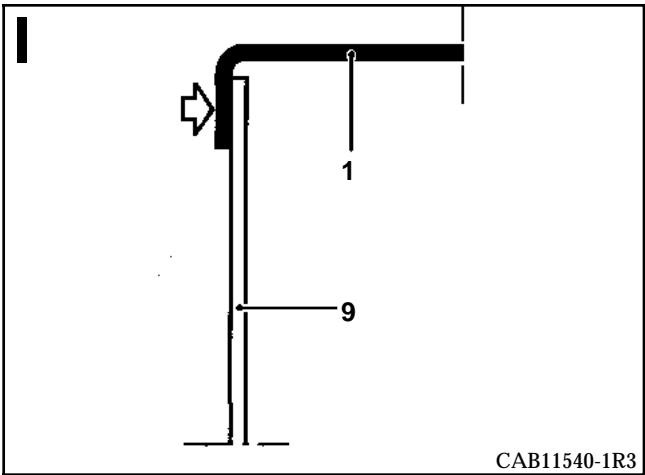
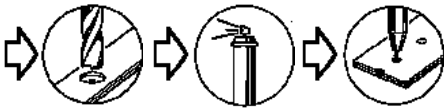
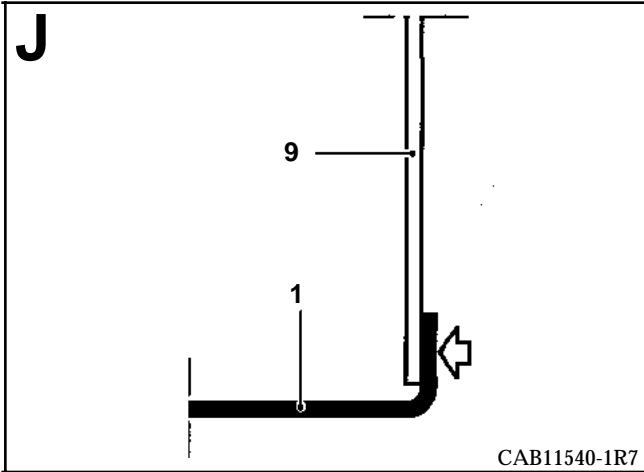
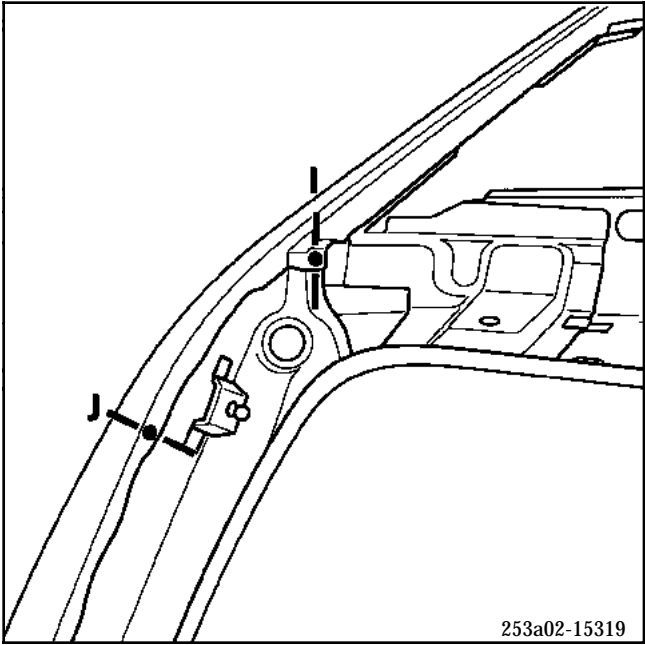




UPPER SIDE STRUCTURE
Top of body

43

A



INTRODUCTION

This part may be replaced in two ways:

- by part section as a basic operation for a rear side impact (see diagram),
- completely, as a complementary operation to the roof.

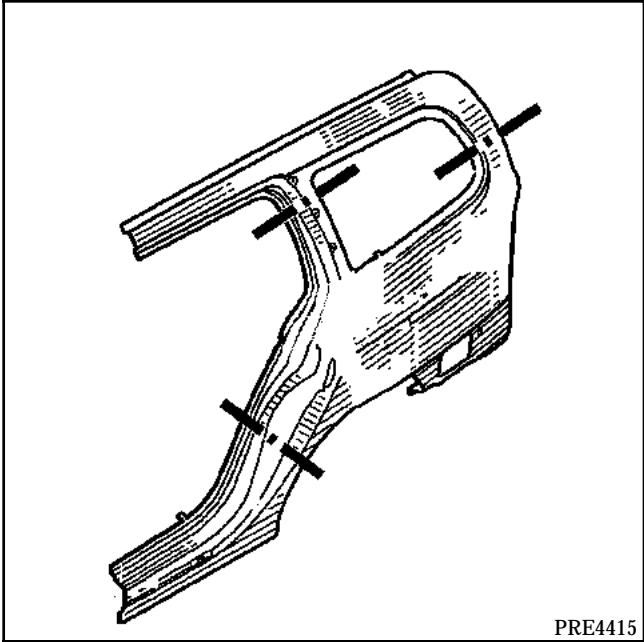
The method described only contains descriptions of joints specific to the part concerned. Joints with complementary parts are not included.

These are dealt with in their respective section (refer to the contents page).

COMPOSITION OF PART FROM PARTS
DEPARTMENT

Part assembled with:

- striker plate reinforcement,
- pin to be welded 3 x2.9,
- soundproofing,
- bumper mounting reinforcement assembly.



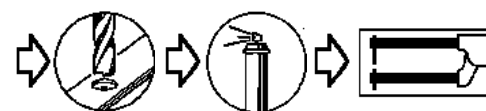
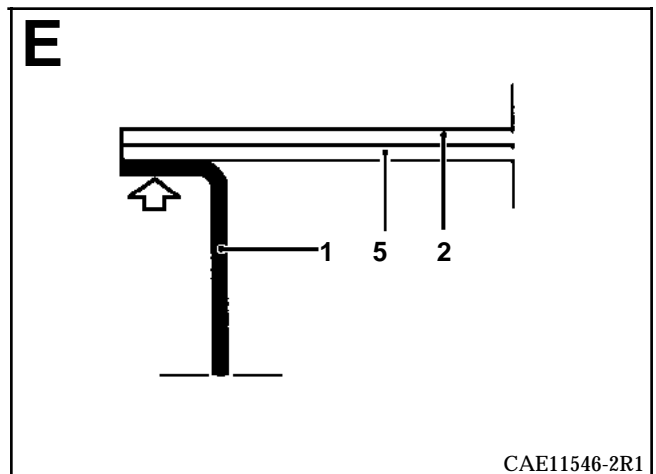
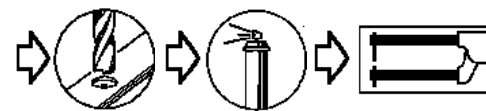
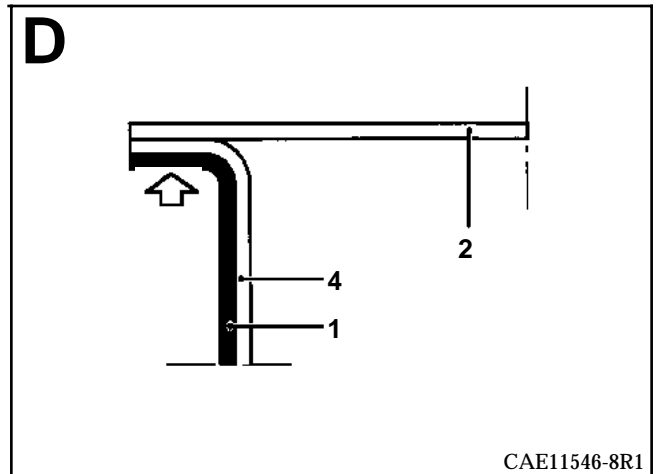
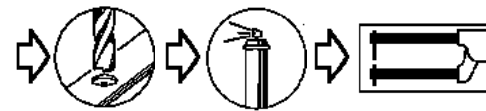
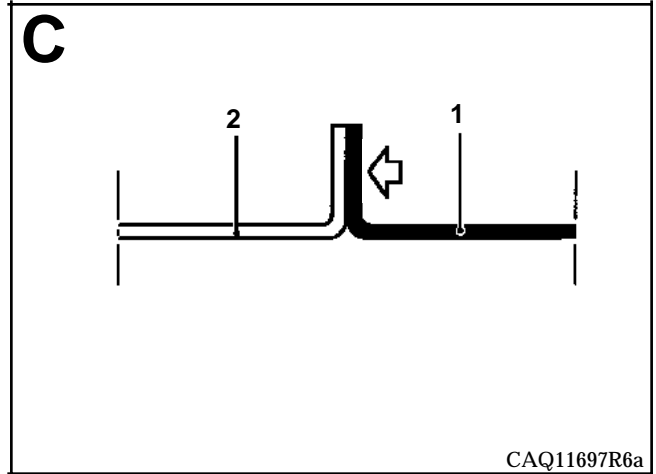
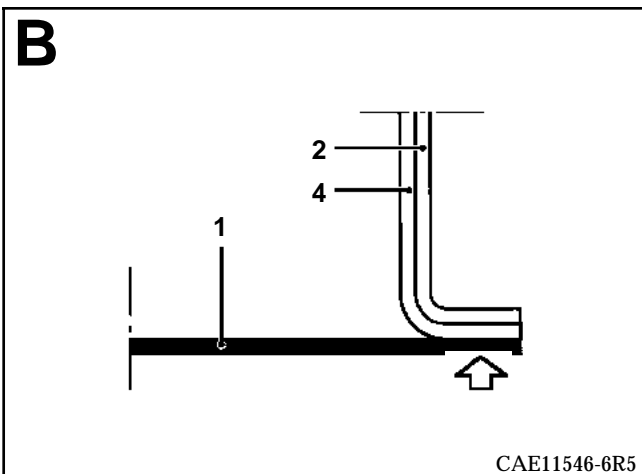
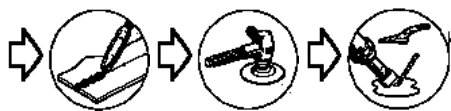
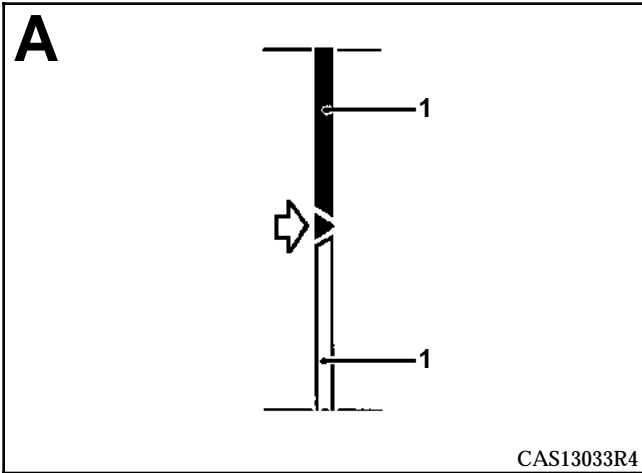
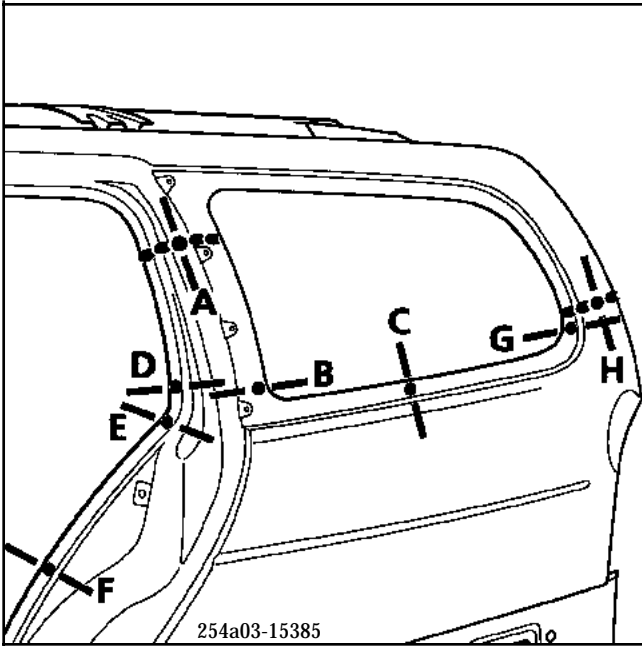
PARTS CONCERNED (thickness in mm) :

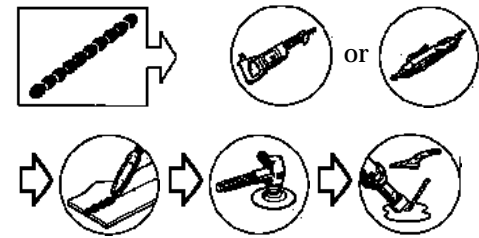
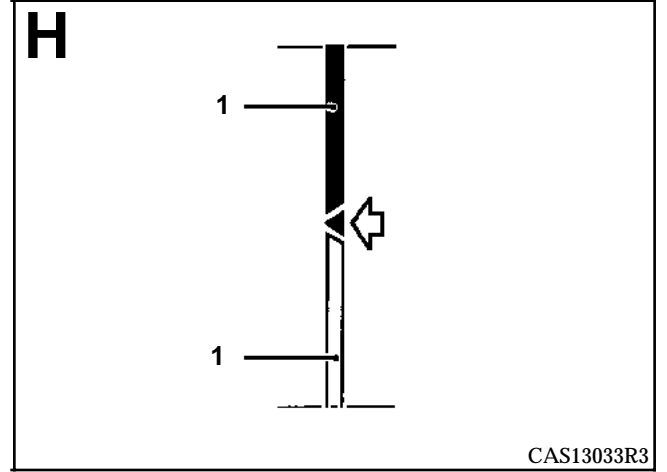
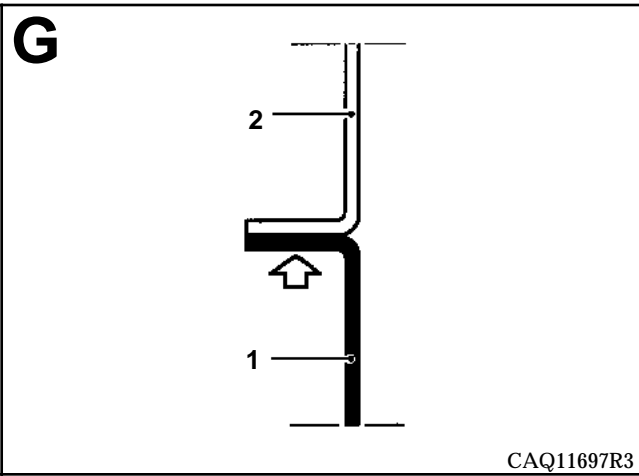
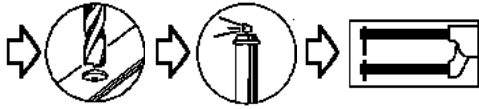
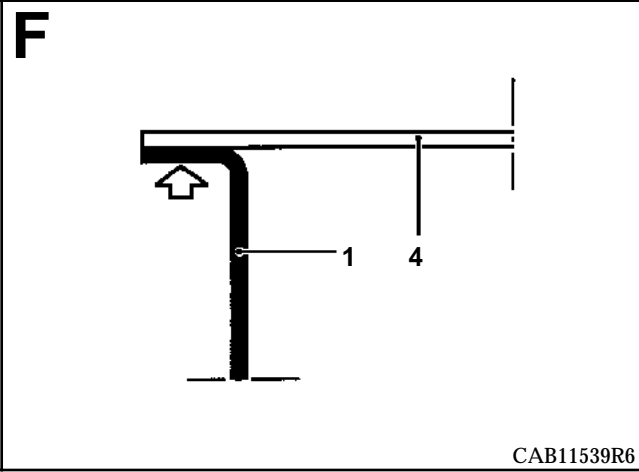
1	Wing panel	0.8
2	Rear quarter panel lining	0.7
3	Sill panel closure panel	1.5
4	Rear pillar reinforcement	1
5	Rear outer wheel arch	0.7
6	Rear upper side drip moulding	1
7	Lights moulding	0.7
8	Rear end pillar lining	1
9	Rear end panel	1
10	Rear end pillar lower reinforcement	1

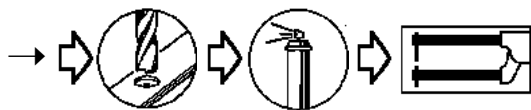
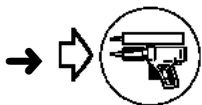
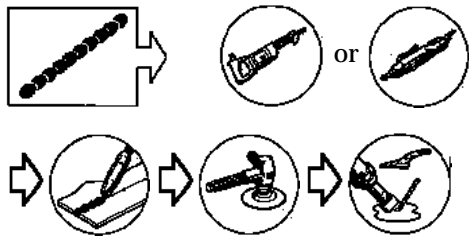
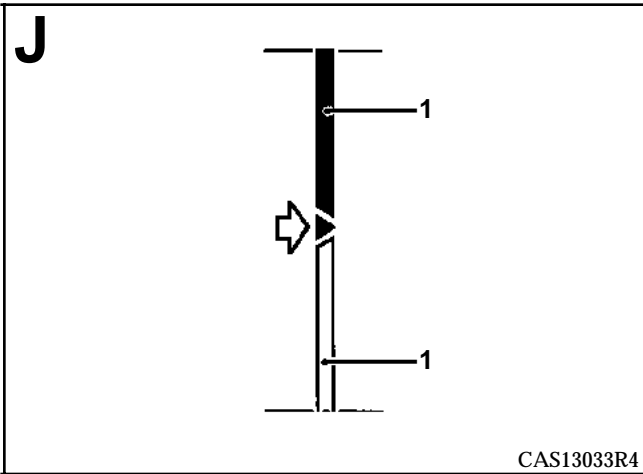
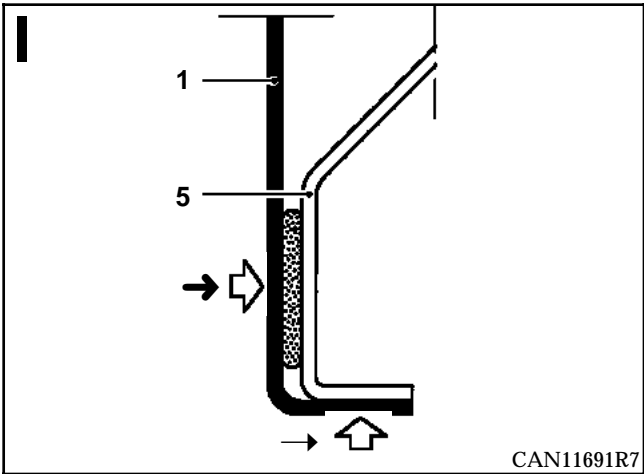
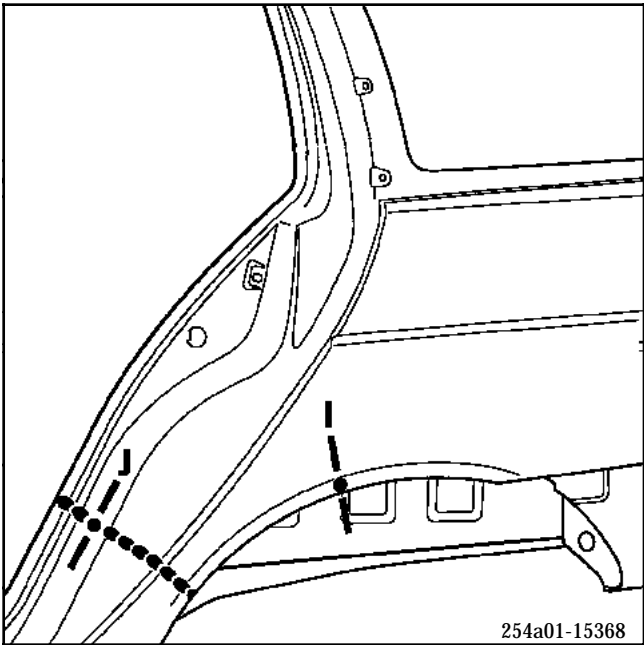
UPPER REAR STRUCTURE

Rear wing panel

44 A



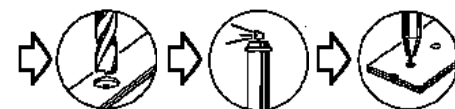
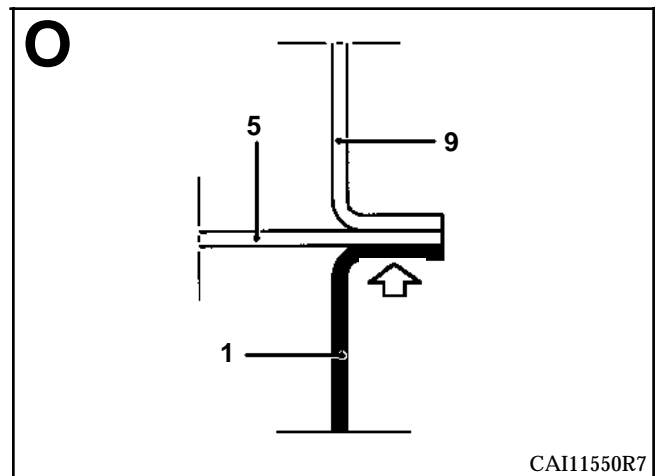
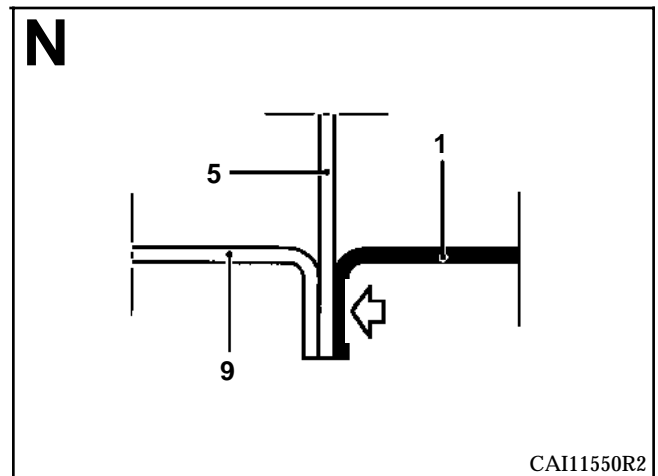
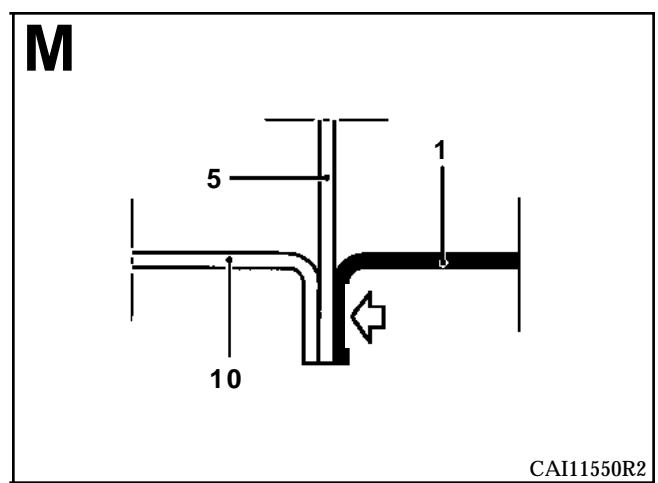
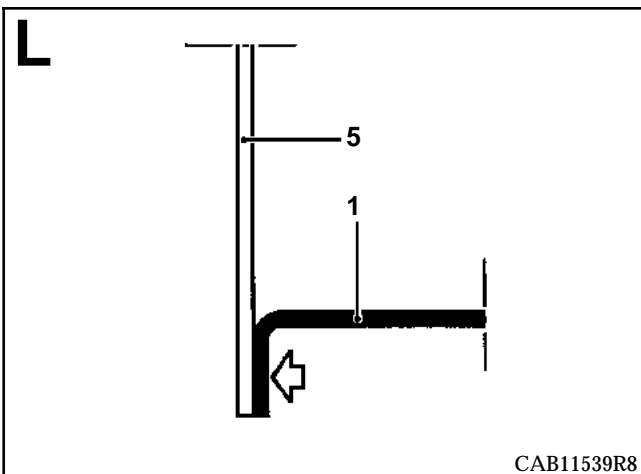
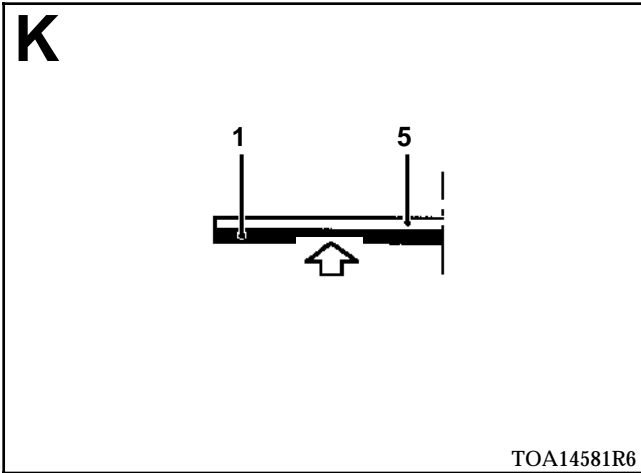
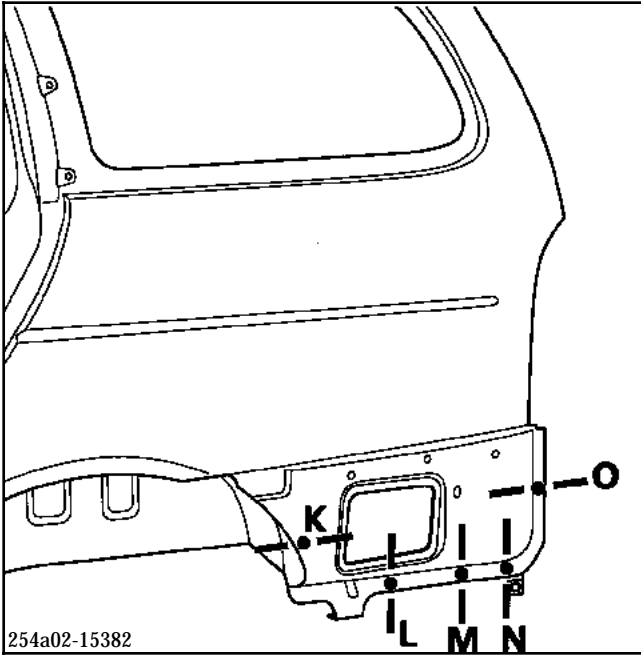


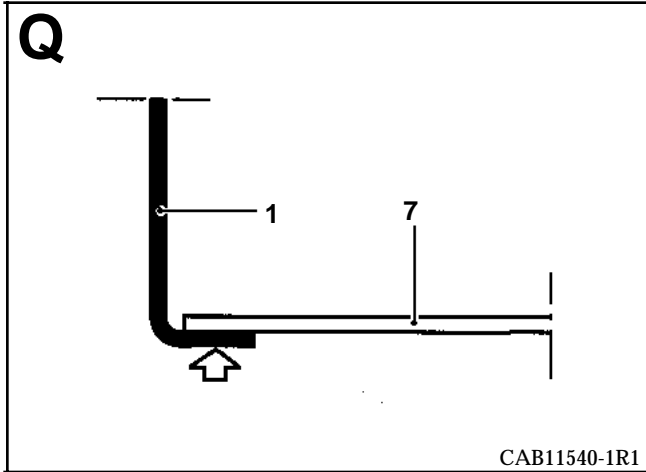
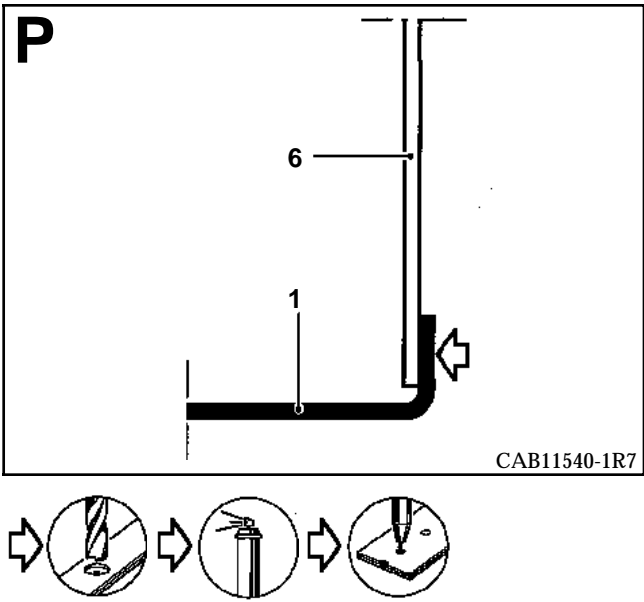
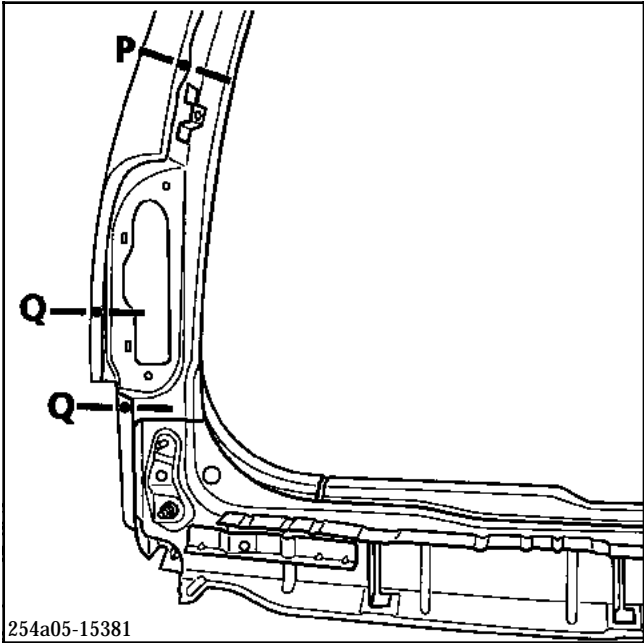


UPPER REAR STRUCTURE

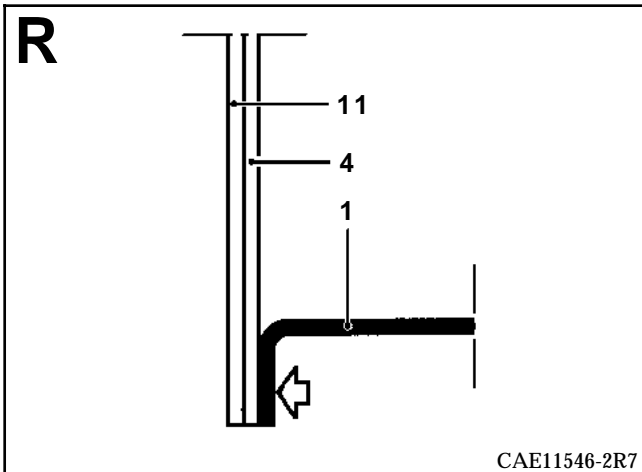
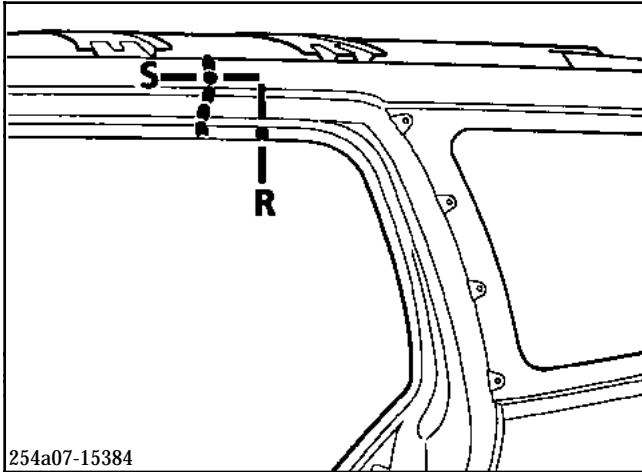
Rear wing panel

44 **A**

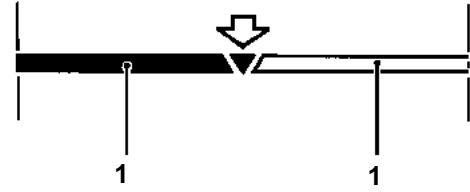




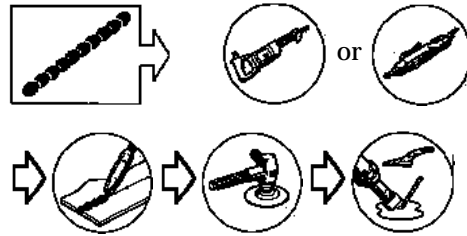
COMPLETE REPLACEMENT (with removal of the roof)

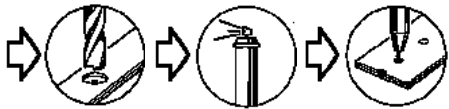
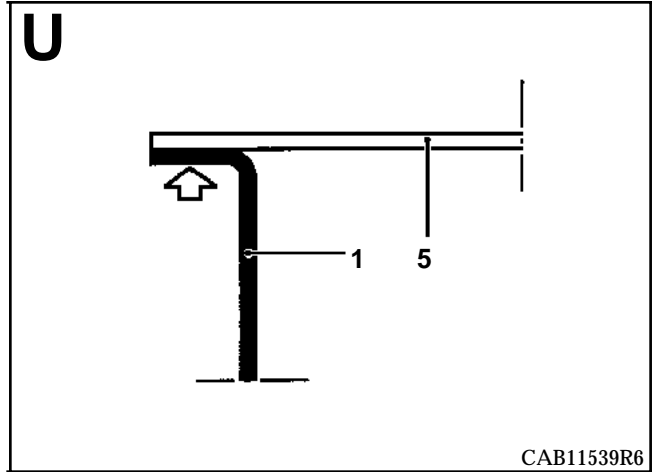
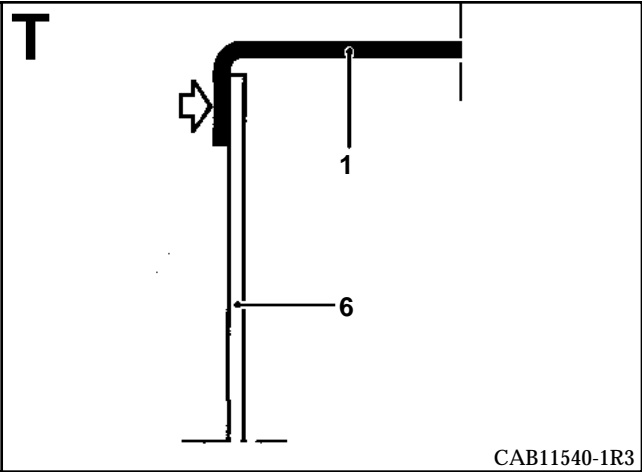
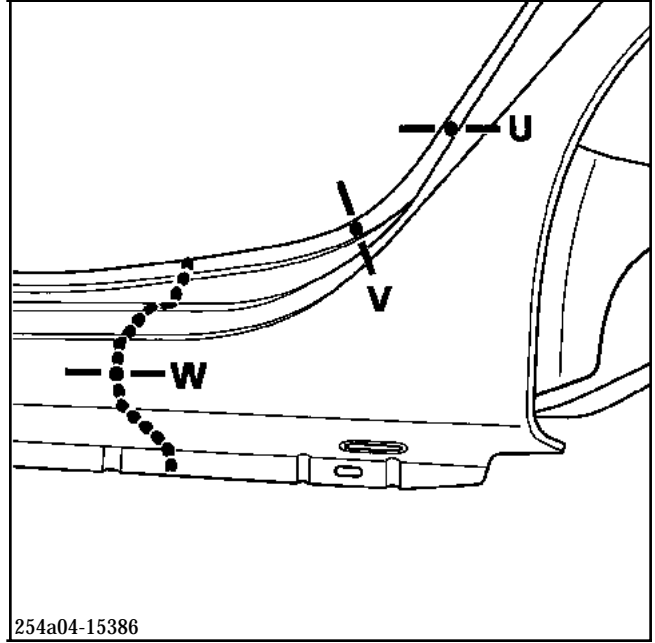
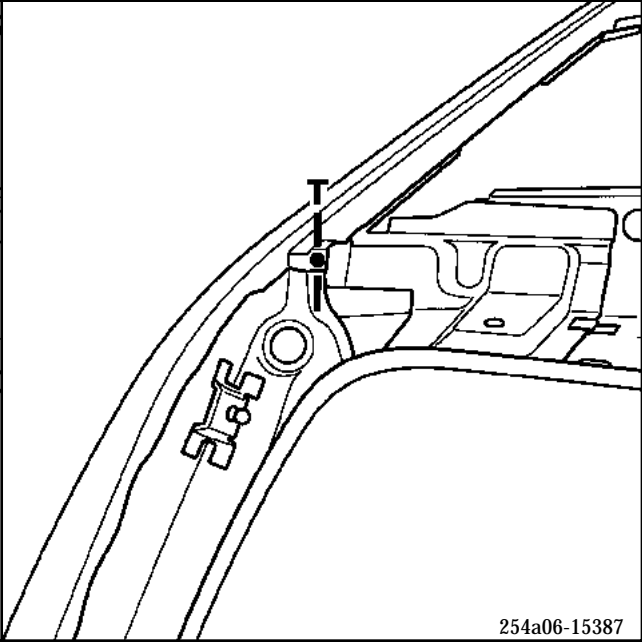


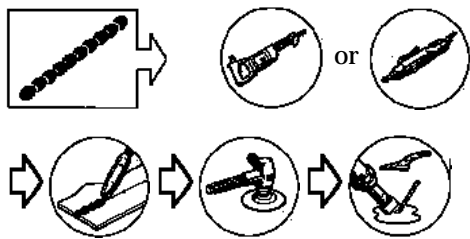
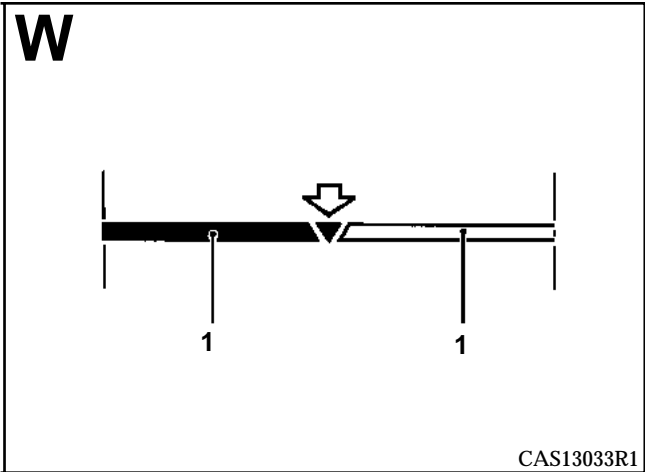
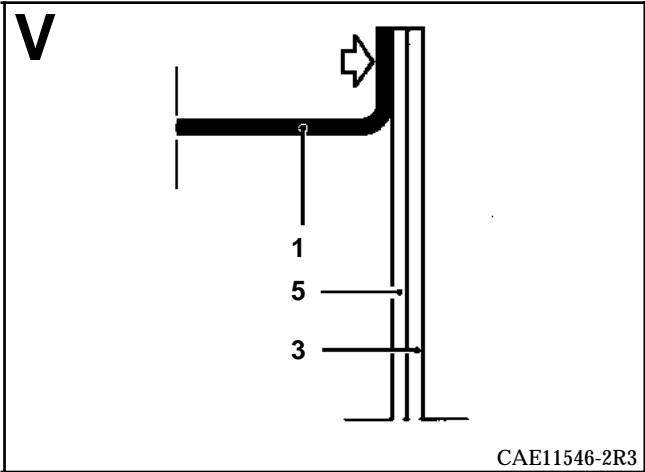
S



CAS13033R1







INTRODUCTION

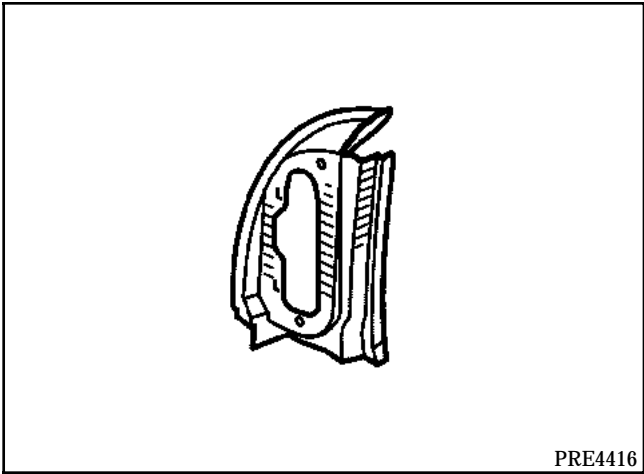
The replacement of this part is a complementary operation to the wing panel.

The method described only contains descriptions of joints specific to the part concerned. Joints with complementary parts are not included.

These are dealt with in their respective section (refer to the contents page).

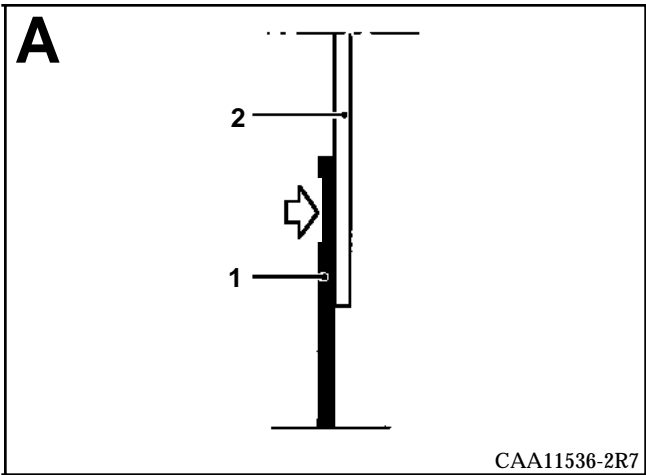
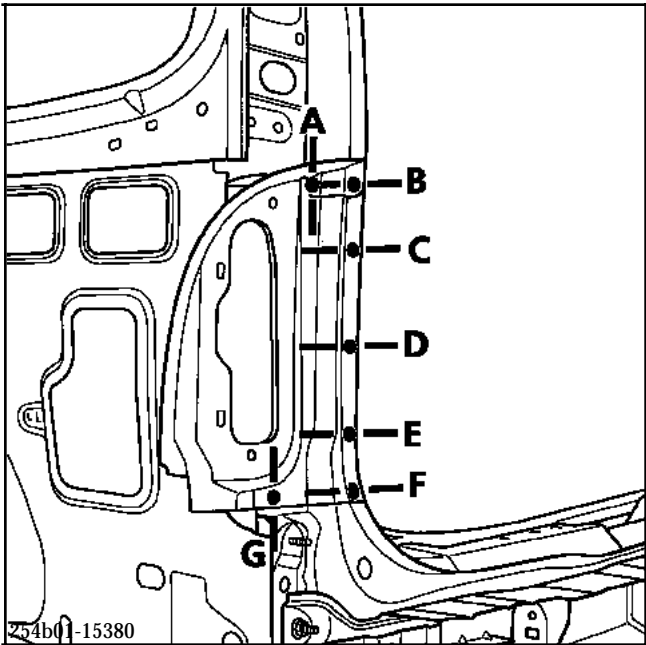
COMPOSITION OF PART FROM PARTS
DEPARTMENT

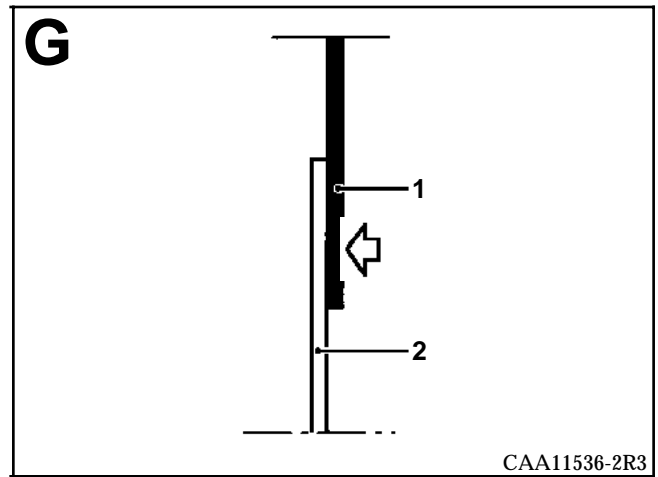
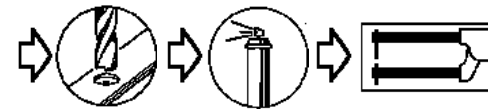
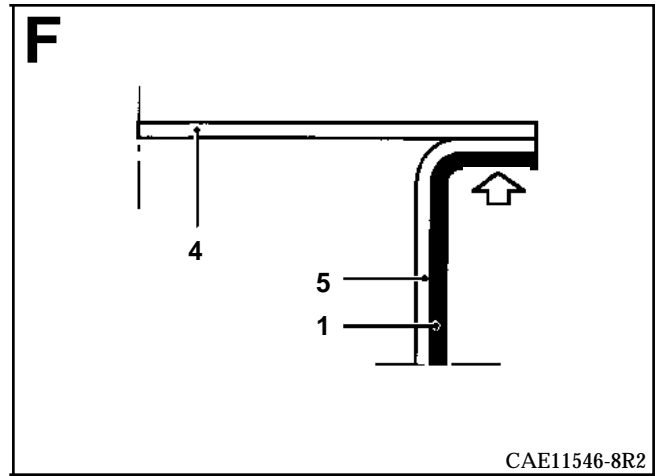
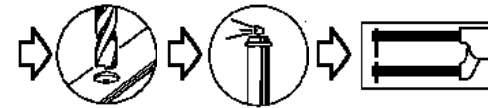
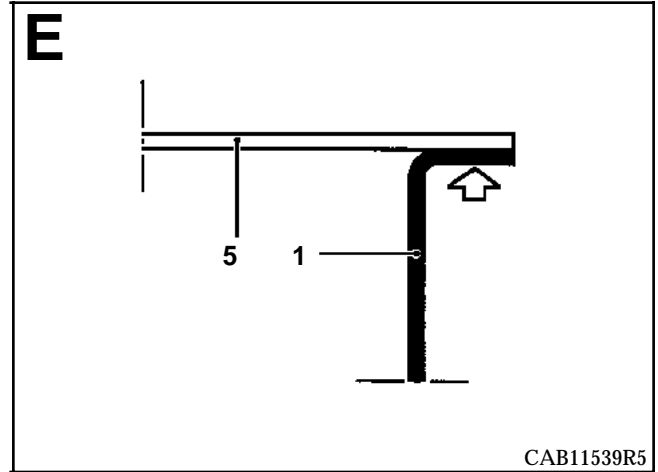
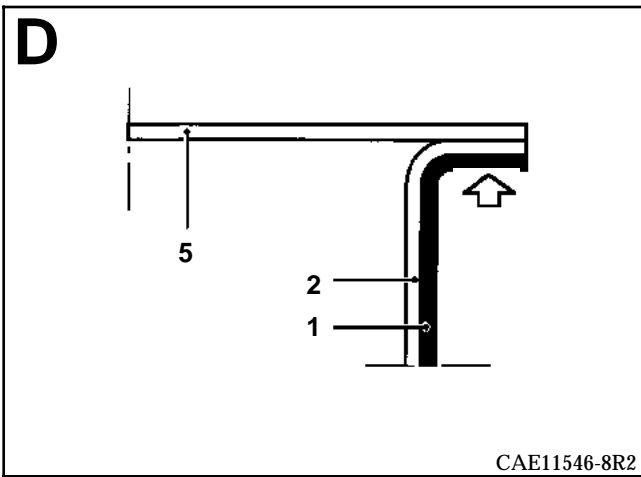
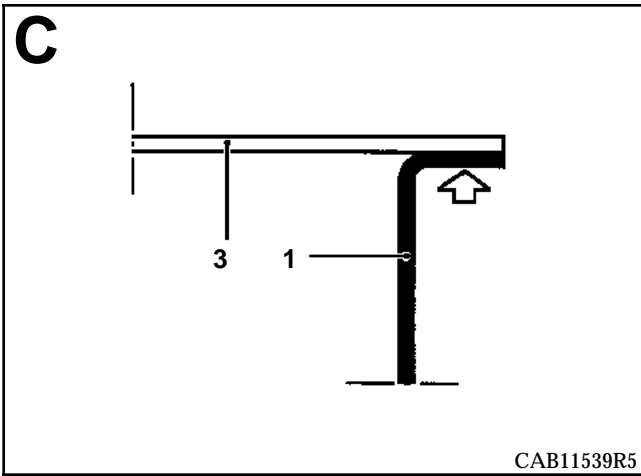
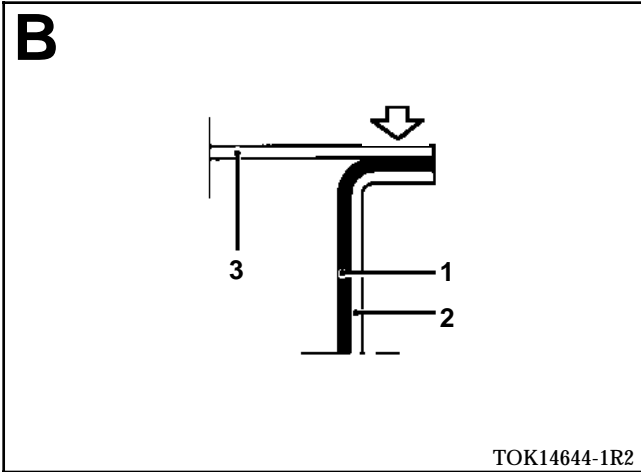
Single part.



PARTS CONCERNED (thickness in mm) :

1	Lights mounting	0.7
2	Rear upper side drip moulding	1
3	Rear end pillar lining	1
4	Rear end panel	1





INTRODUCTION

The replacement of this part is a complementary operation to the rear wing panel.

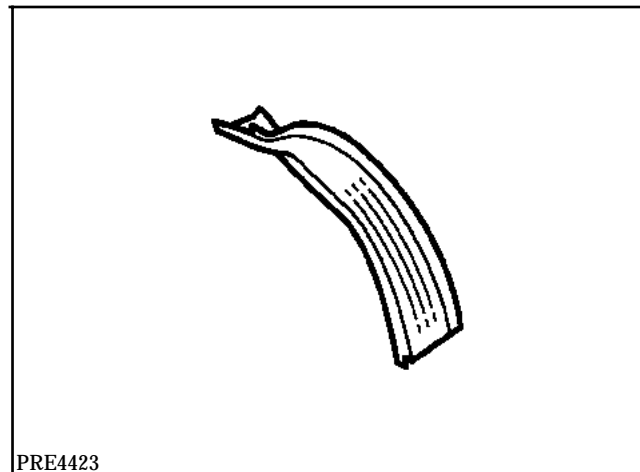
The method described only contains descriptions of joints specific to the part concerned. Joints with complementary parts are not included.

These are dealt with in their respective section (refer to the contents page).

COMPOSITION OF PART FROM PARTS DEPARTMENT

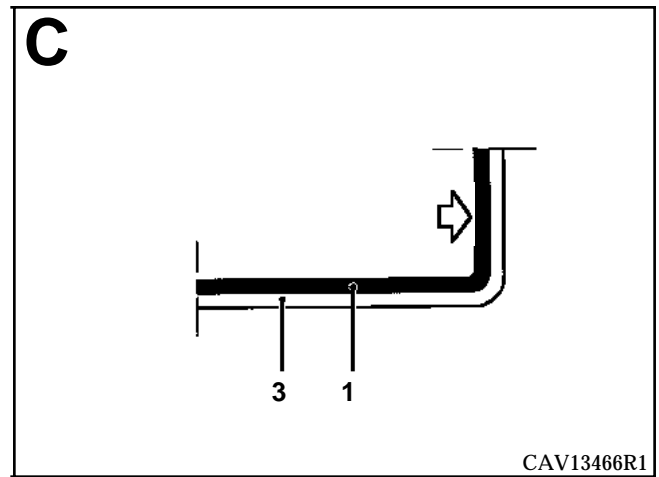
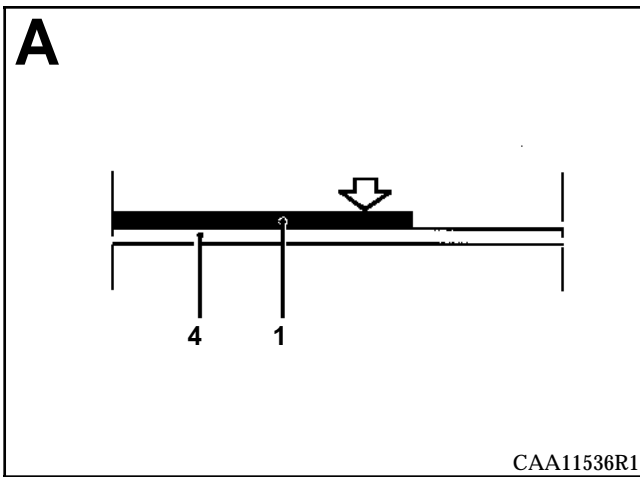
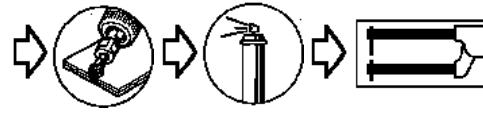
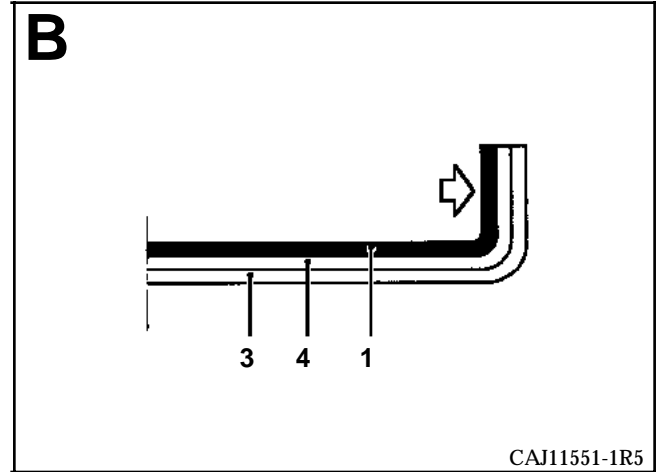
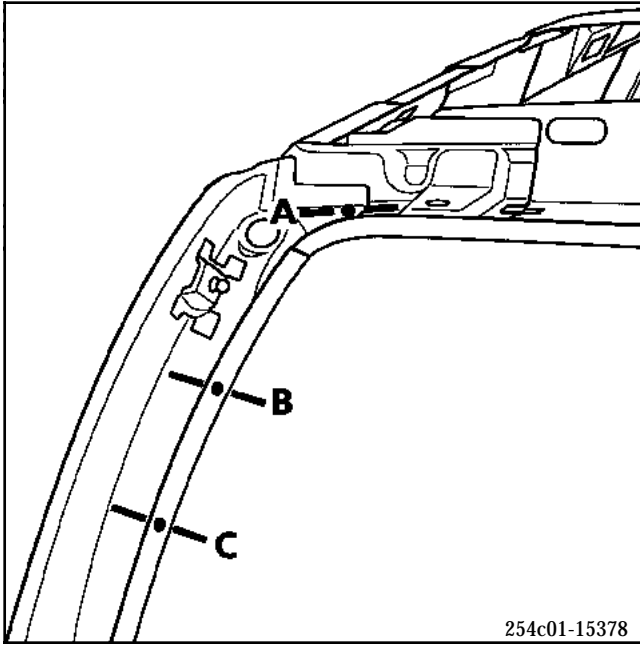
Part assembled with:

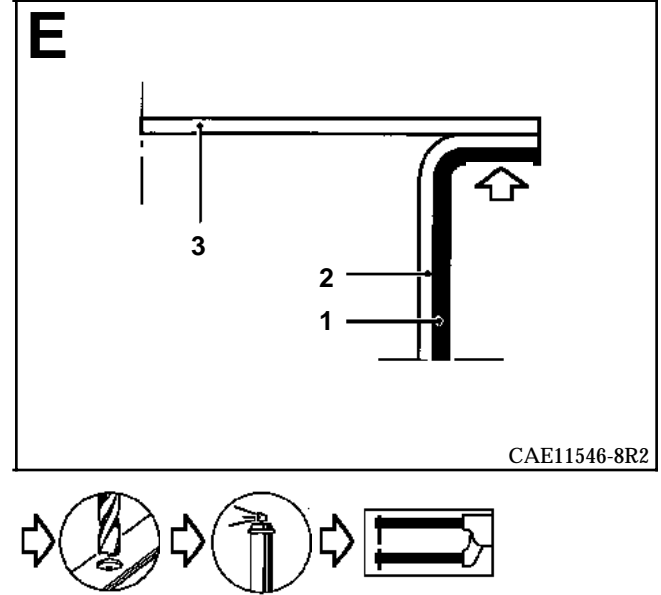
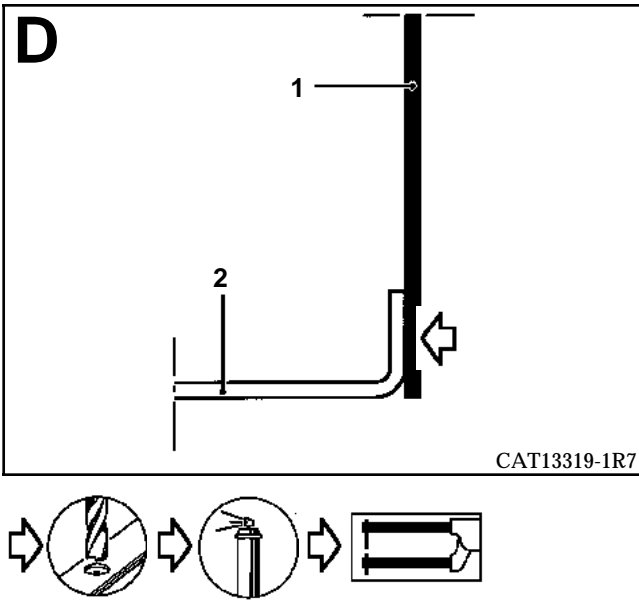
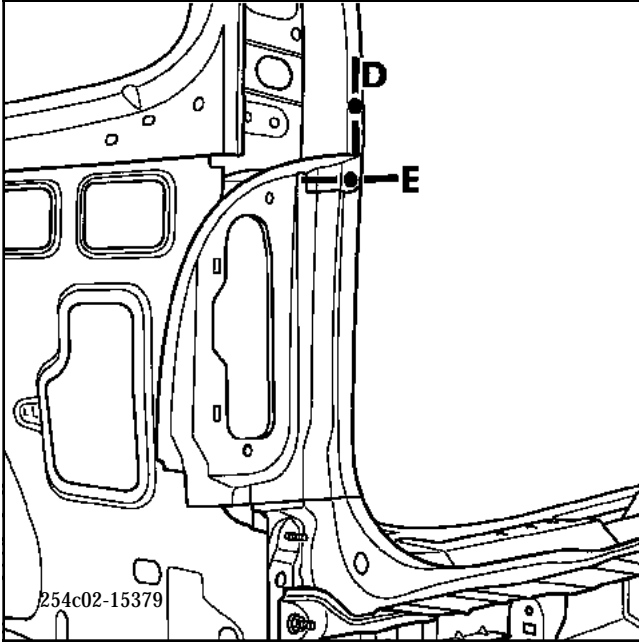
- balancer ball joint,
- parcel shelf mounting.



PARTS CONCERNED (thickness in mm) :

1	Rear upper side drip moulding	1
2	Lights mounting	0.7
3	Rear end pillar lining	1
4	Rear end pillar lower reinforcement	1





INTRODUCTION

The replacement of this part is a complementary operation to the rear wing panel for a rear side impact.

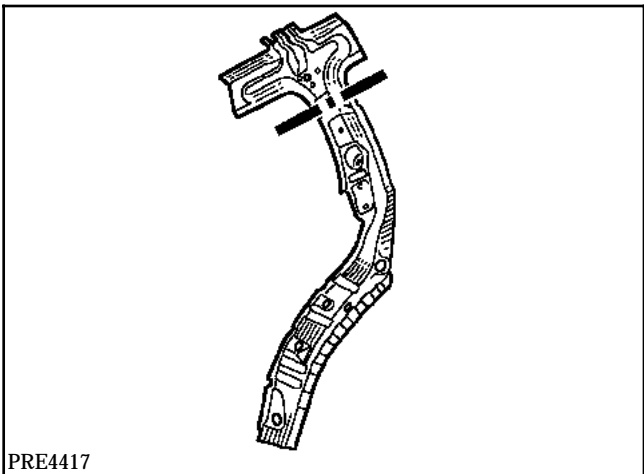
The method described only contains descriptions of joints specific to the part concerned. Joints with complementary parts are not included.

These are dealt with in their respective section (refer to the contents page).

COMPOSITION OF PART FROM PARTS
DEPARTMENT

Part assembled with:

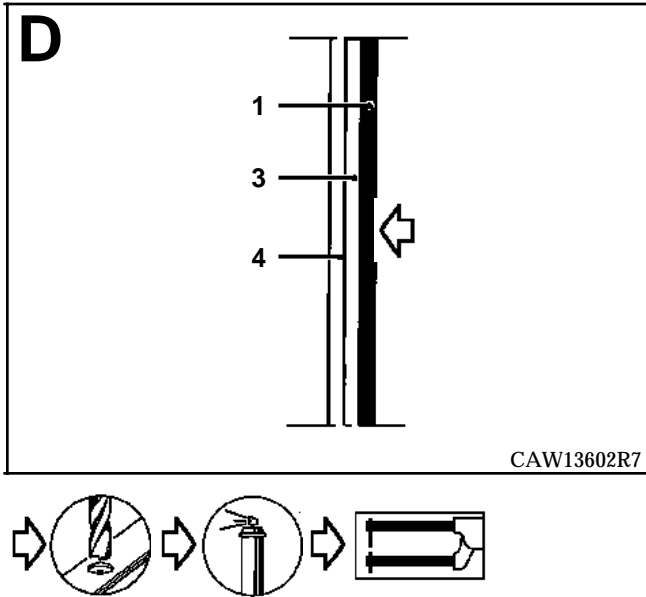
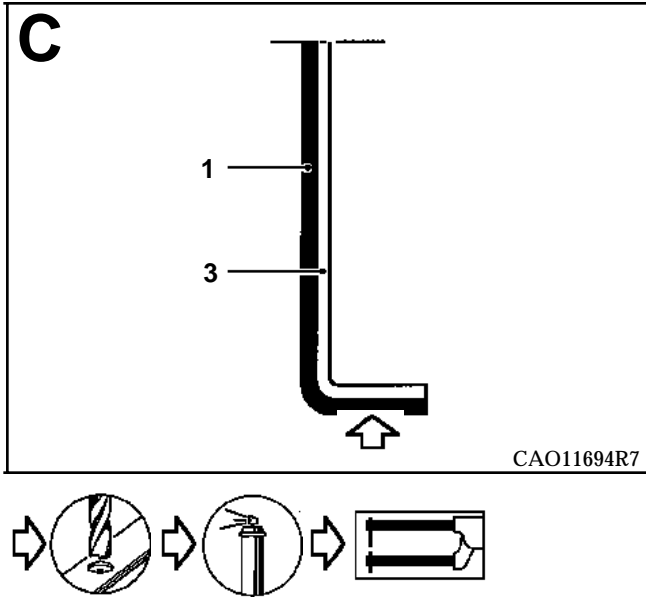
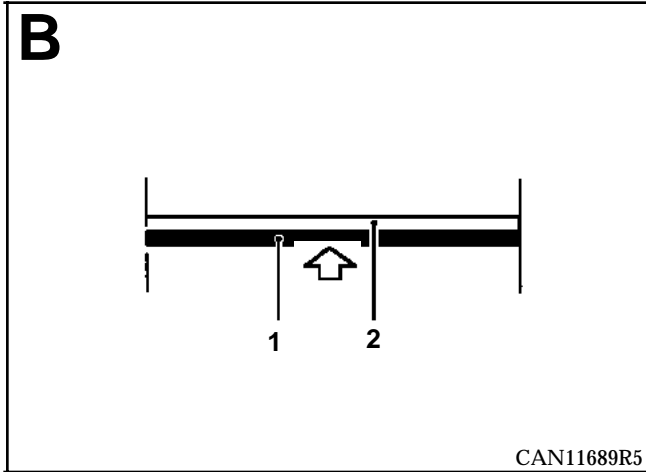
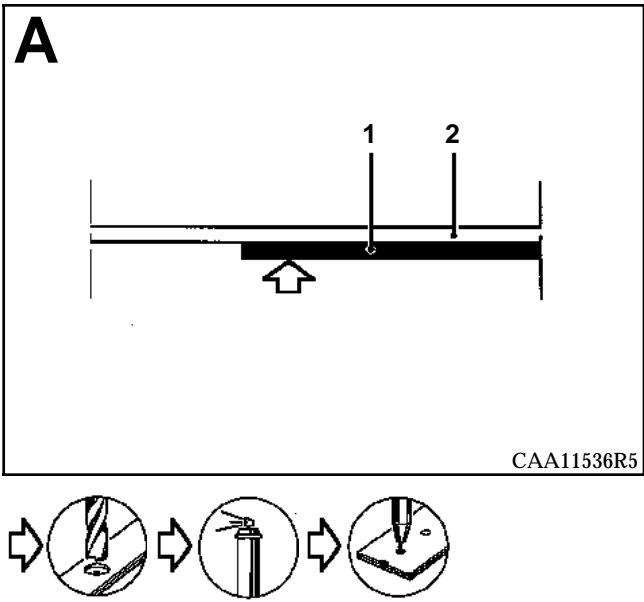
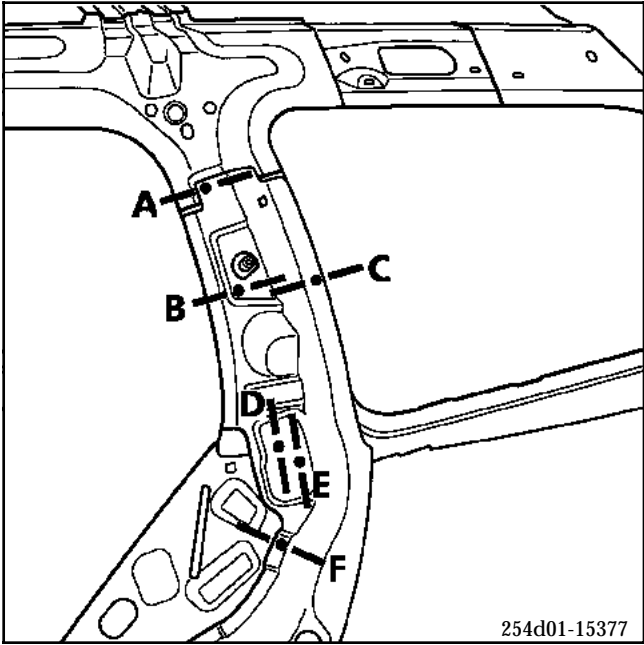
- upper pillar reinforcement,
- mounting nuts,
- lower pillar reinforcement,
- acoustic plug.

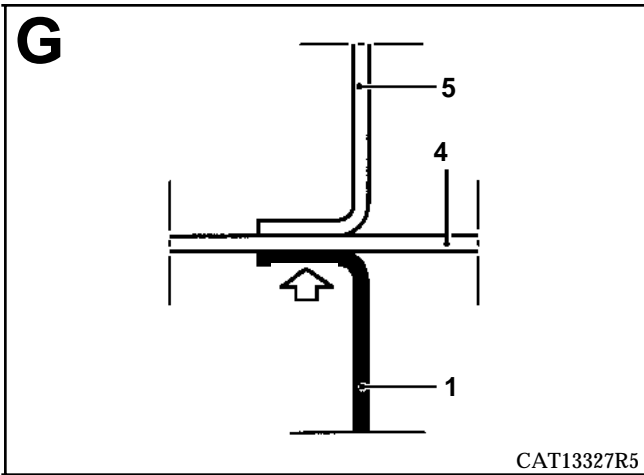
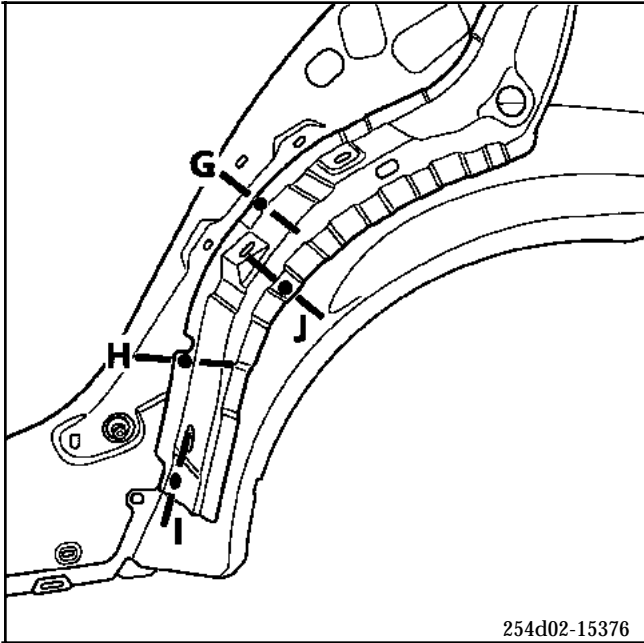
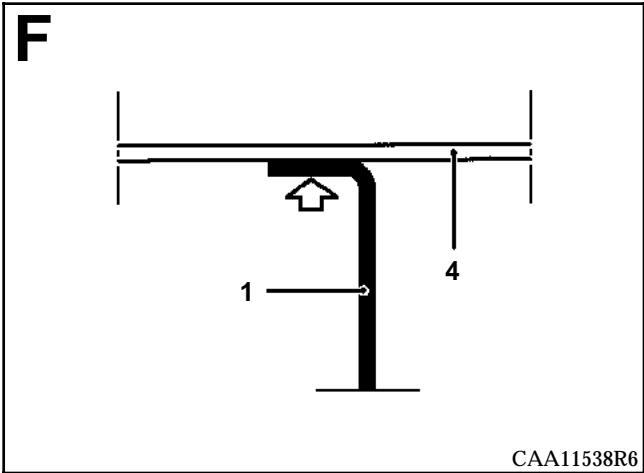
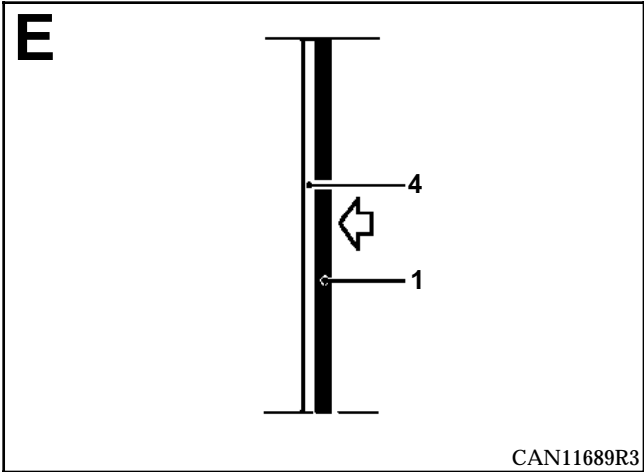


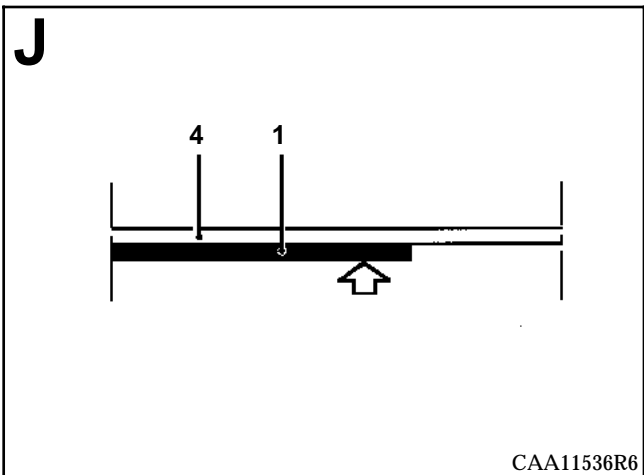
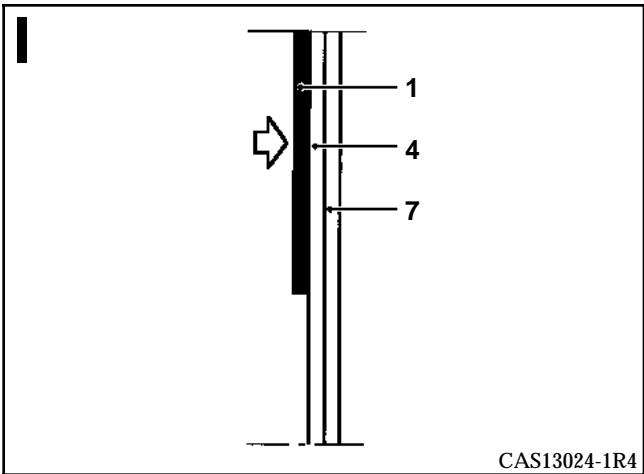
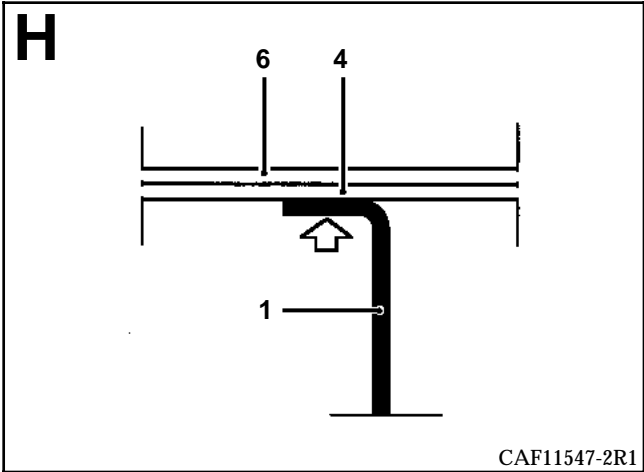
NOTE : for this operation the upper part of the reinforcement must be unpicked on the new part.

PARTS CONCERNED (thickness in mm) :

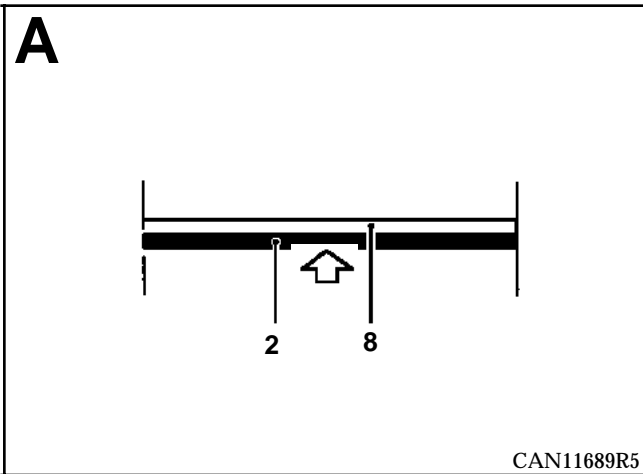
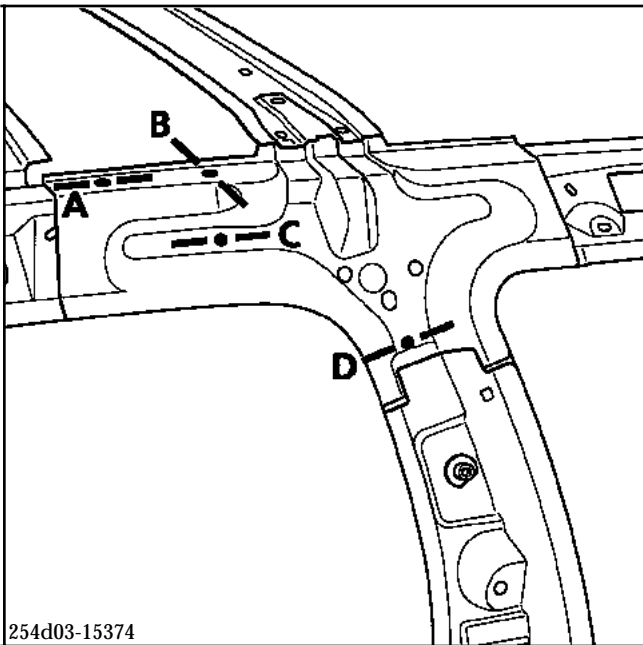
1	Rear pillar lower reinforcement	1
2	Rear pillar upper reinforcement	1
3	Rear quarter panel lining	0.7
4	Rear outer wheel arch	0.7
5	Rear inner wheel arch	0.8
6	Sill panel closure panel	1.5
7	Seat belt mounting reinforcement	1.5
8	Stretcher lining	1.2

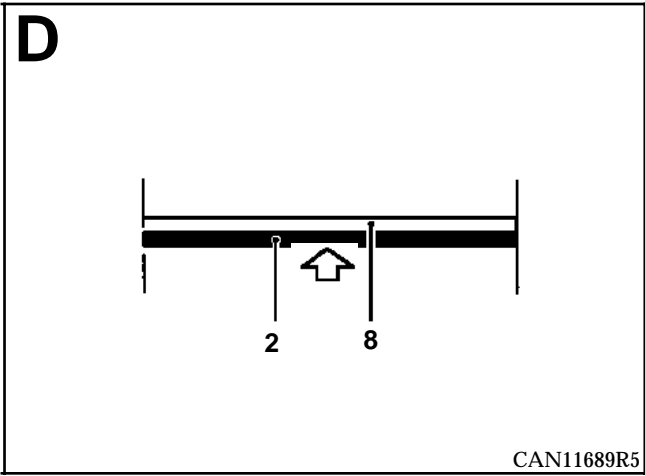
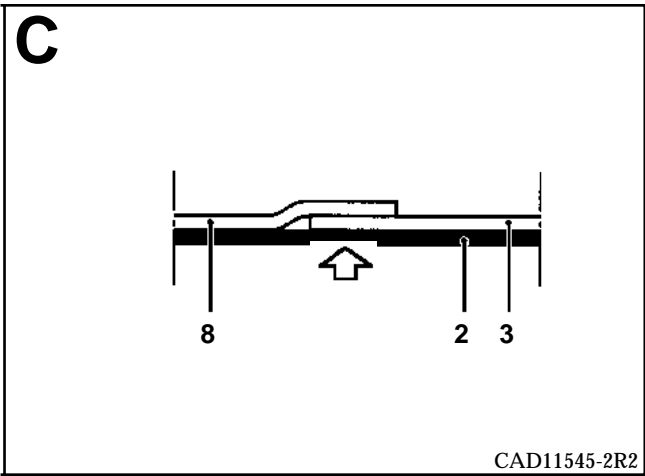
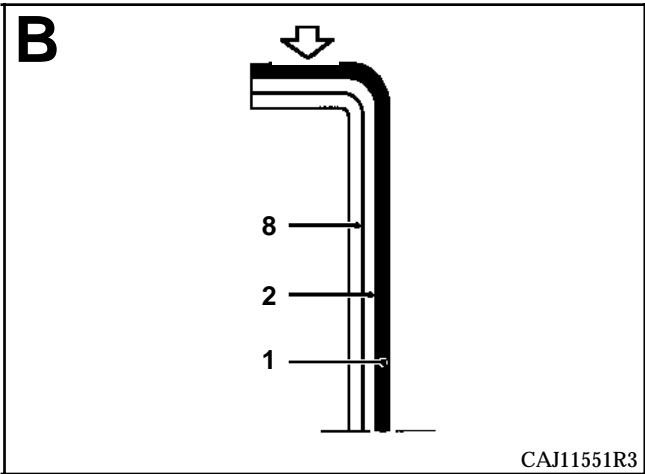






REAR PILLAR UPPER REINFORCEMENT





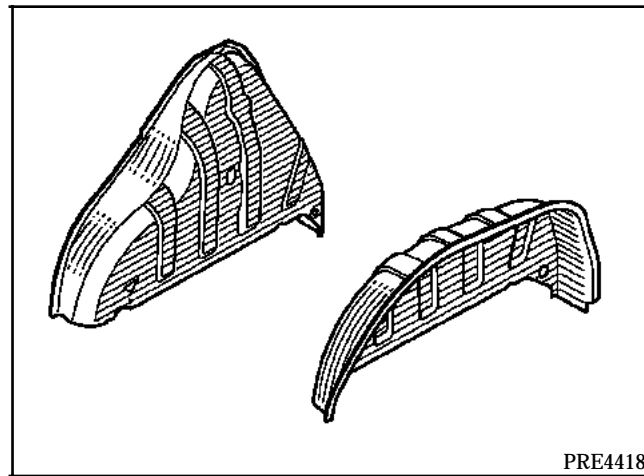
INTRODUCTION

The replacement of this part is a complementary operation to the replacement of a wing panel with rear quarter panel lining or a rear floor unit.

For details of the operation refer to the basic manual (M.R. 313).

COMPOSITION OF PART FROM PARTS DEPARTMENT

Welded stud.



- 1 Right hand side
- 2 Left hand side

INTRODUCTION

The replacement of this part is a complementary operation to a complete wing panel.

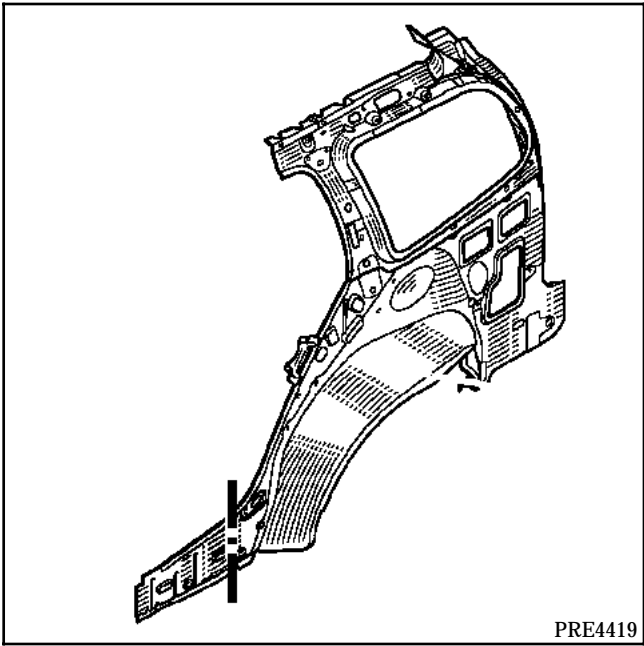
The method described only contains descriptions of joints specific to the part concerned. Joints with complementary parts are not included.

These are dealt with in their respective section (refer to the contents page).

COMPOSITION OF PART FROM PARTS
DEPARTMENT

Part assembled with:

- outer wheel arch,
- seat mounting reinforcement,
- connecting bracket,
- rear end pillar lining assembly,
- upper corner reinforcement assembly.



NOTE : to avoid replacing the part located behind the sill panel, cut the front lower section of the lining, see section (C) in the diagram below.

PARTS CONCERNED (thickness in mm) :

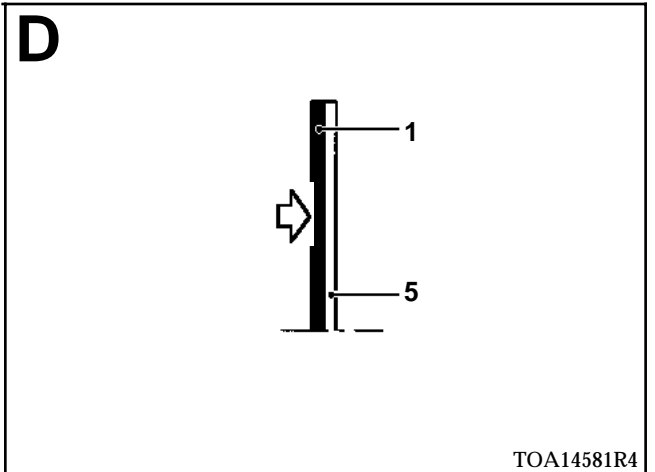
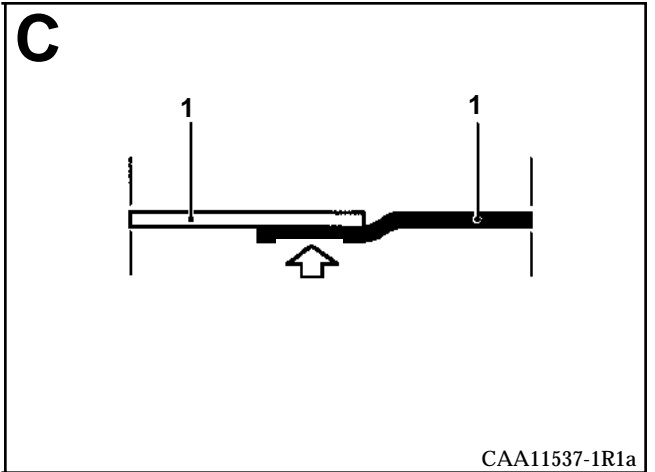
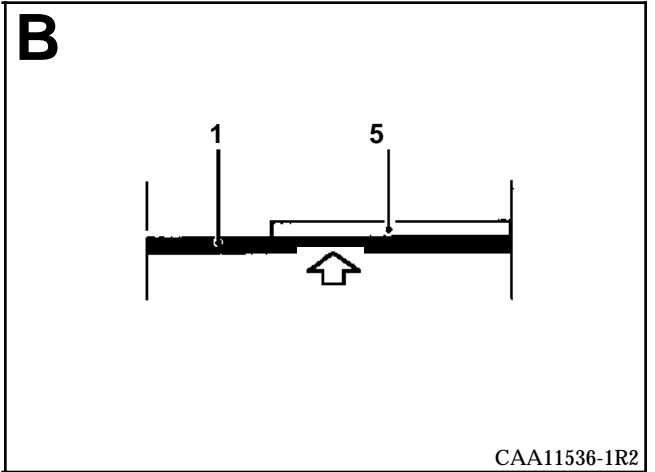
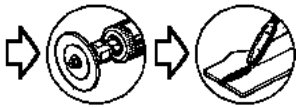
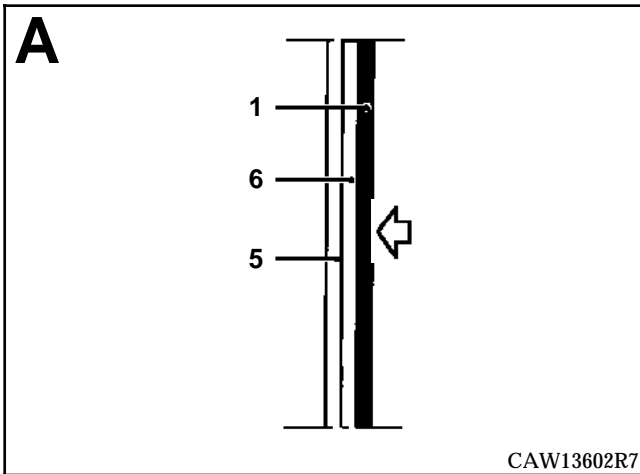
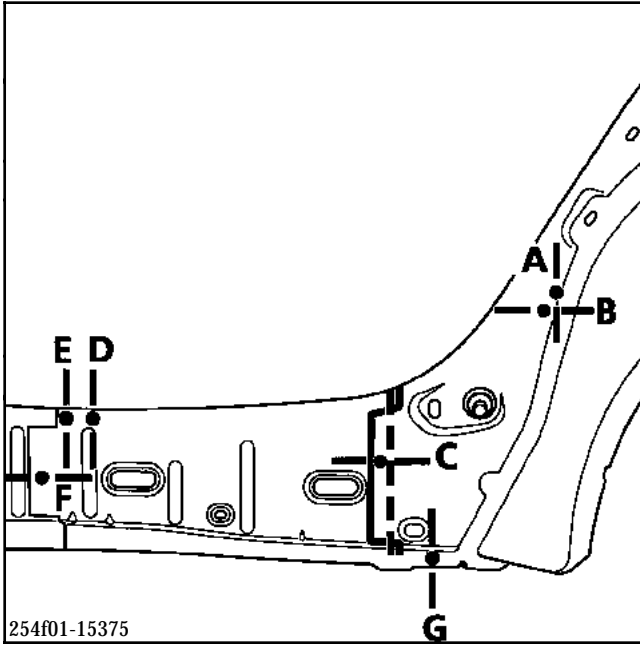
1	Body side lining	0.7
2	Rear quarter panel lining	0.7
3	Centre pillar lining	1.2
4	Front sill closure panel	1.5
5	Rear sill closure panel	0.8
6	Rear inner wheel arch	0.8
7	Seat belt mounting reinforcement	1.5
8	Stretcher lining	1.2
9	Rear floor base	0.8
10	Rear floor	0.7
11	Rear end pillar lining	1
12	Rear end pillar lower reinforcement	1

UPPER REAR STRUCTURE

Rear quarter panel lining assembly

44

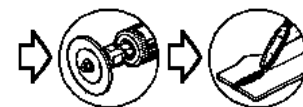
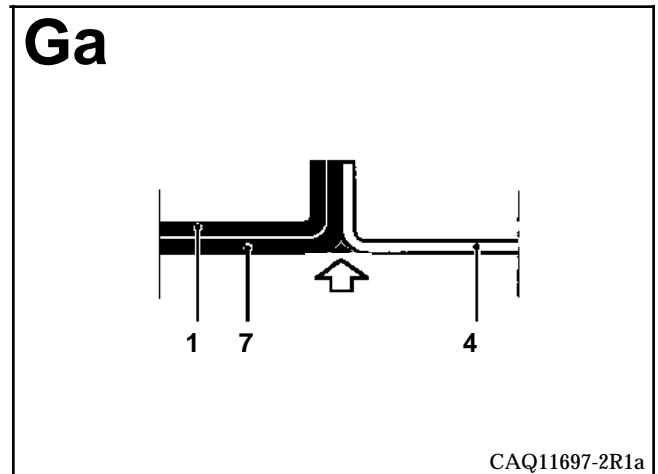
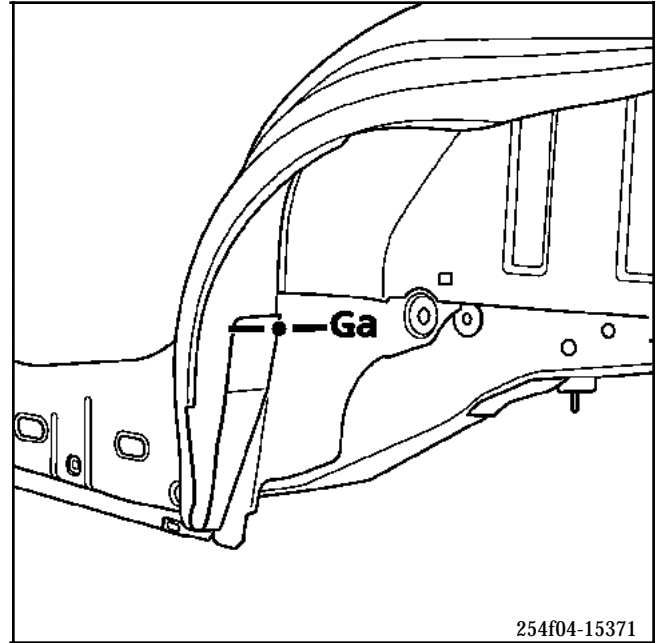
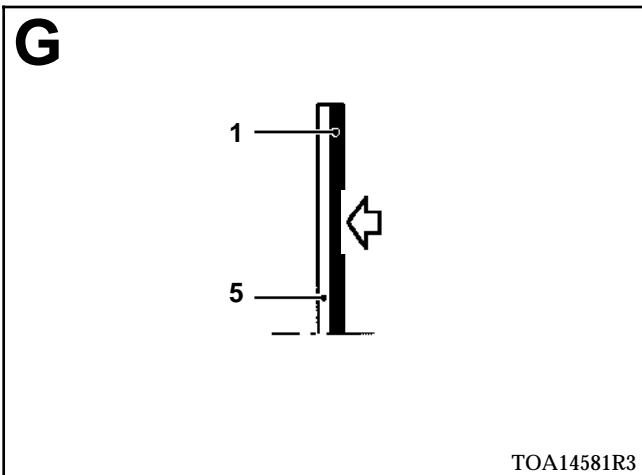
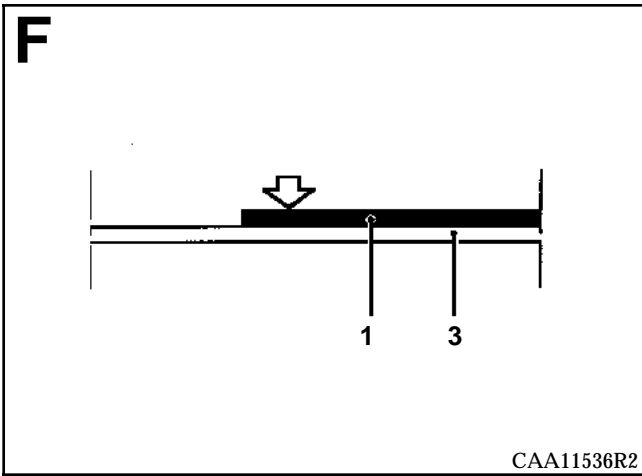
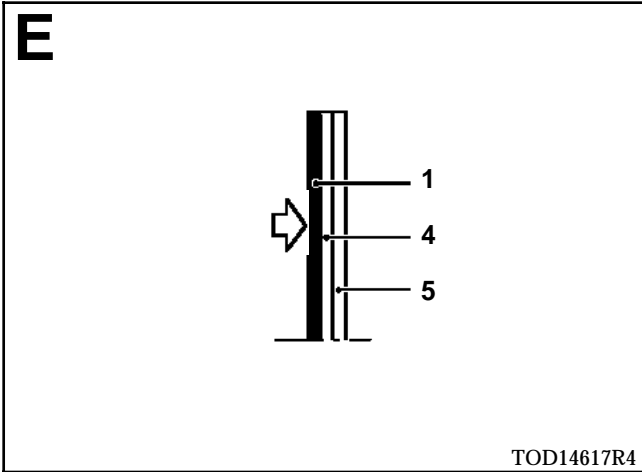
F



UPPER REAR STRUCTURE

Rear quarter panel lining assembly

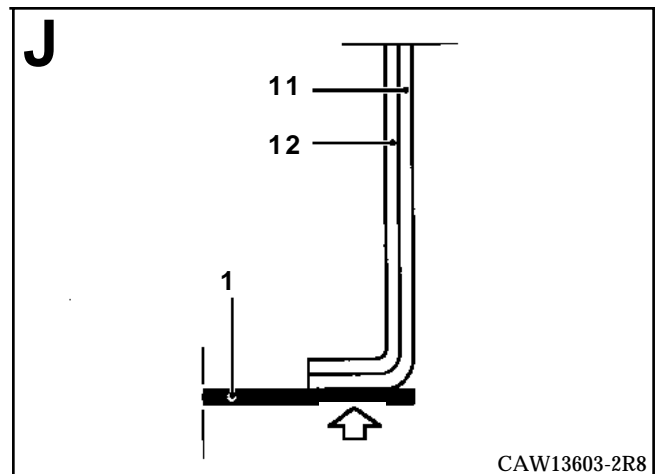
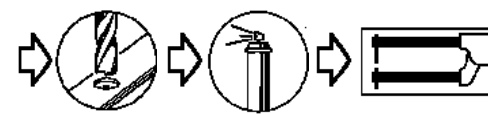
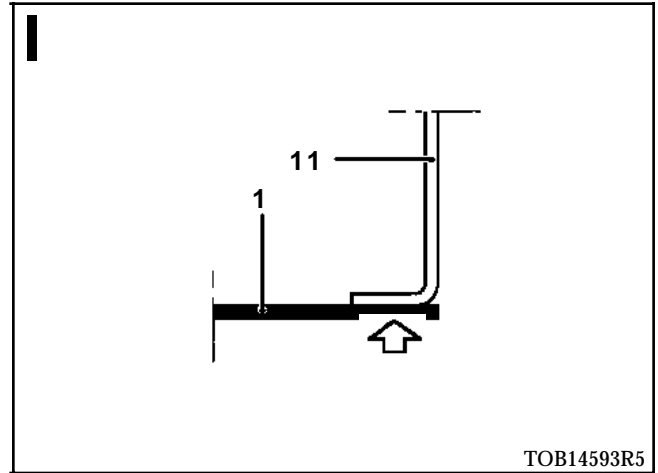
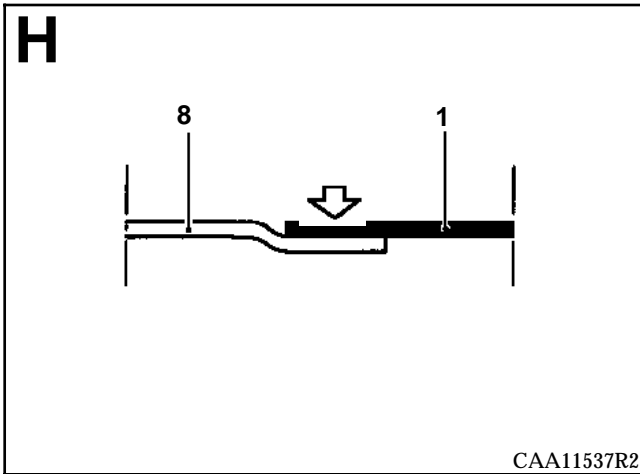
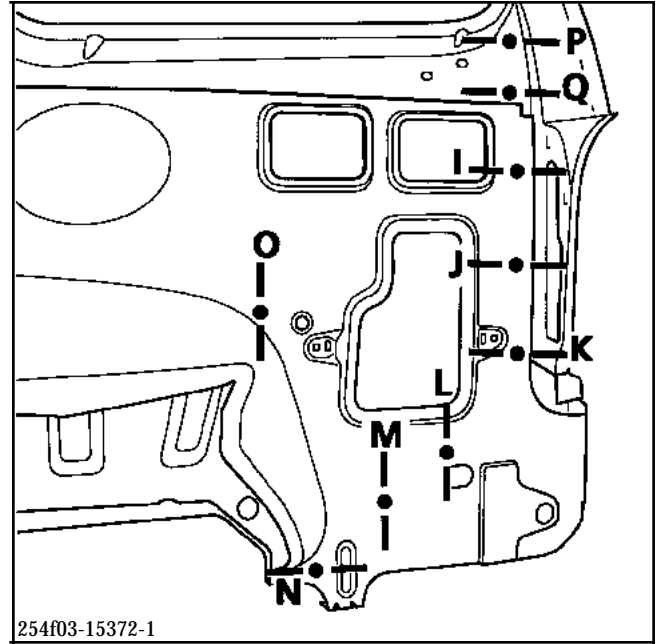
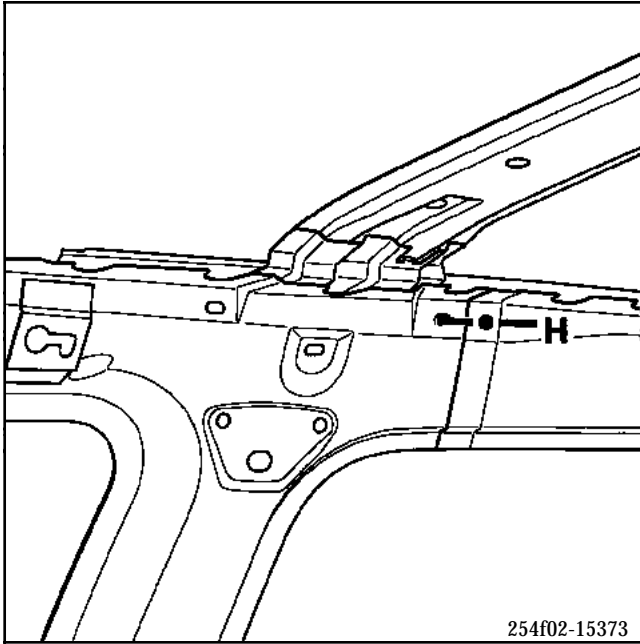
44 **F**

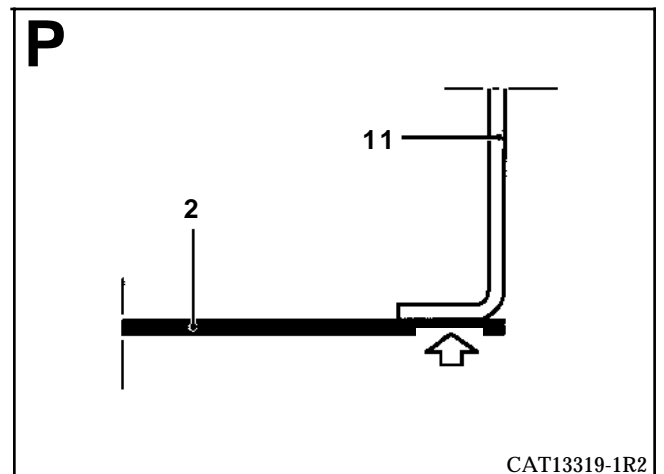
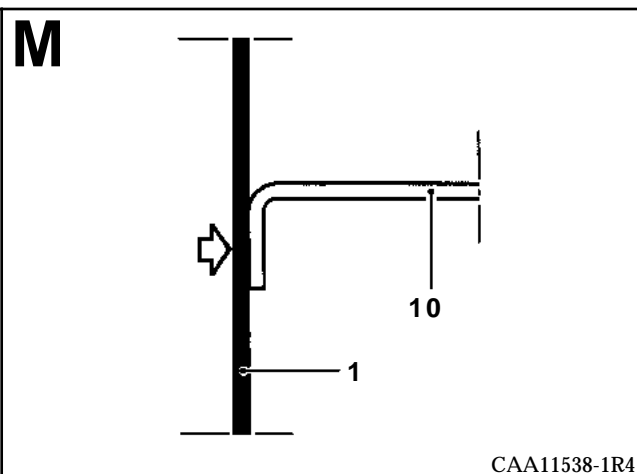
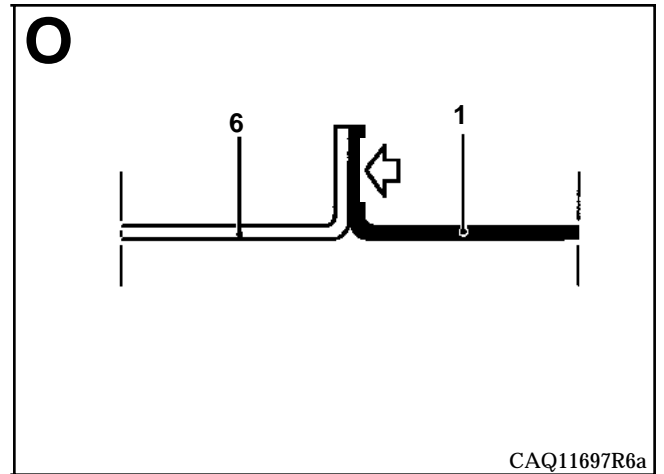
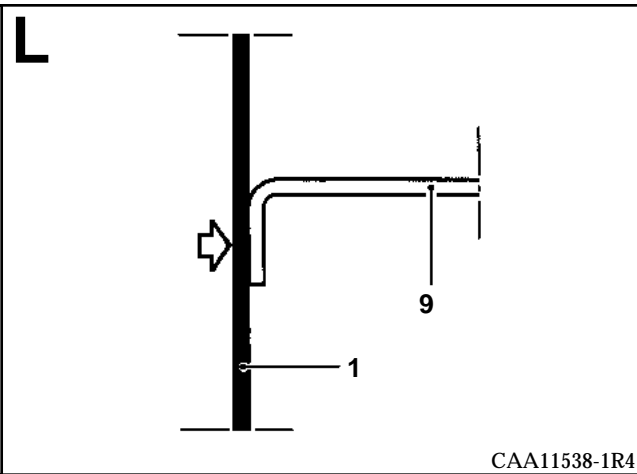
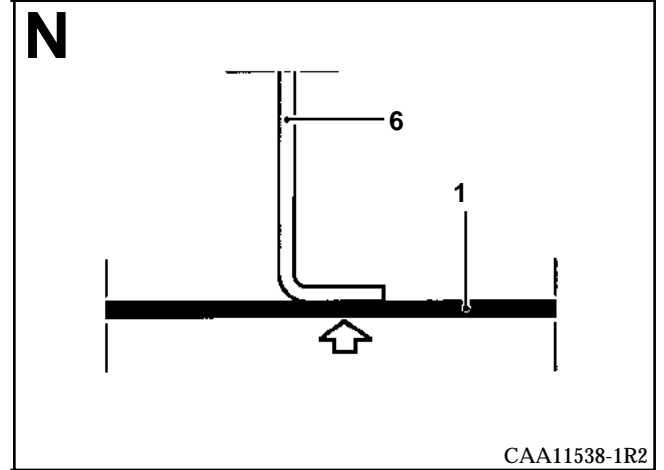
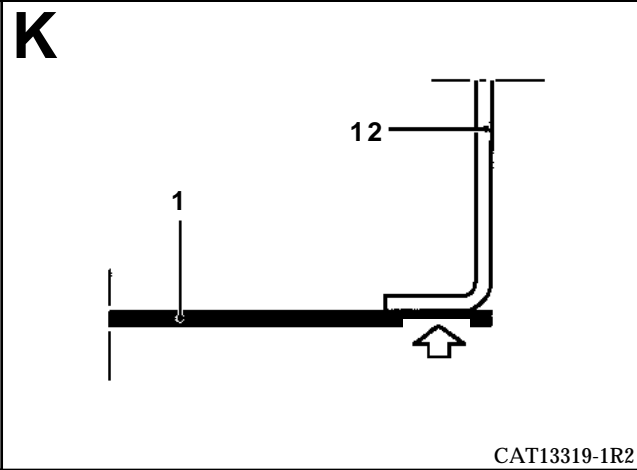


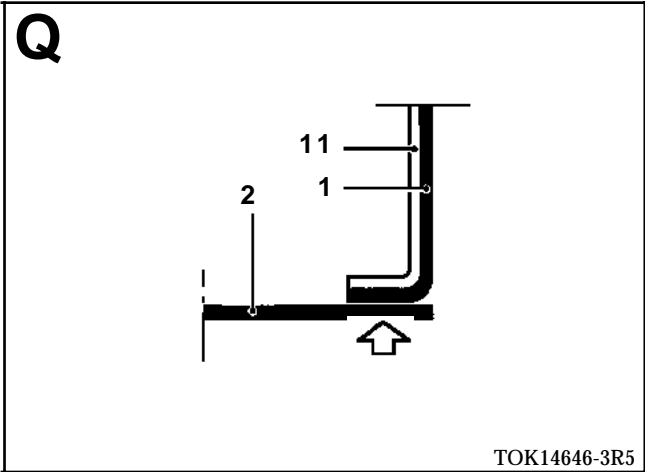
UPPER REAR STRUCTURE

Rear quarter panel lining assembly

44 **F**







INTRODUCTION

This part can be replaced in two ways:

- by **part section A** , complementary to the rear end pillar,
- by **part section B** , complementary to the wing panel.

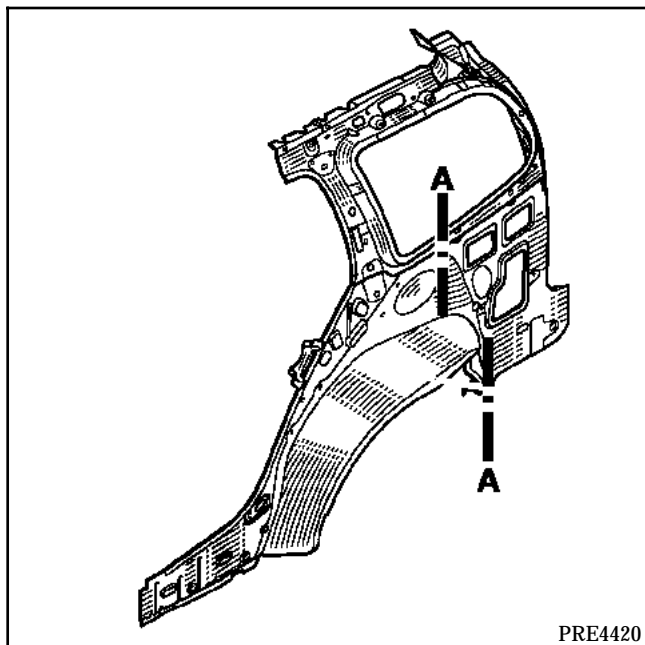
The method described only contains descriptions of joints specific to the part concerned. Joints with complementary parts are not included.

These are dealt with in their respective section (refer to the contents page).

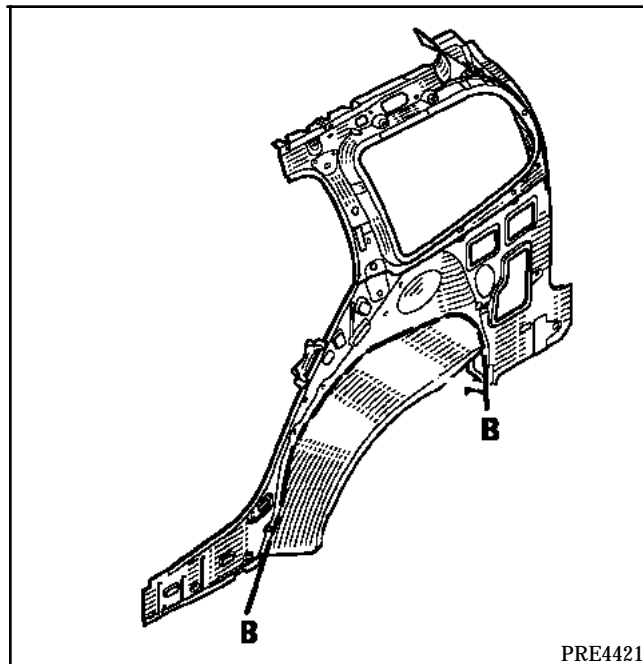
COMPOSITION OF PART FROM PARTS DEPARTMENT

Part assembled with:

- outer wheel arch,
- seat mounting reinforcement,
- connecting bracket,
- rear end pillar lining assembly,
- upper corner reinforcement assembly.



SECTION A : complementary to rear end pillar reinforcement.



SECTION B : complementary to rear wing panel.



PARTS CONCERNED (thickness in mm) :

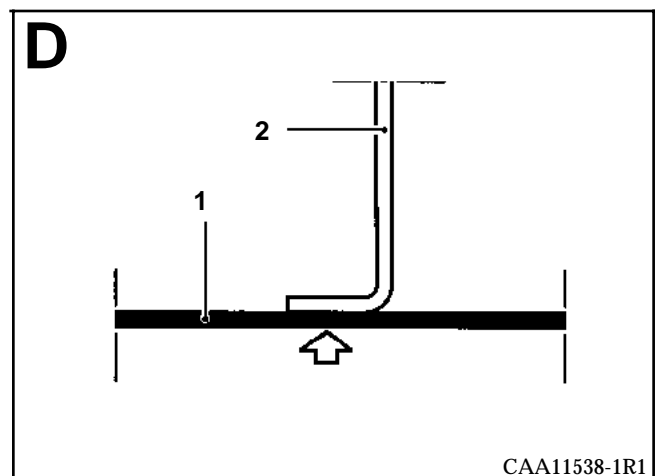
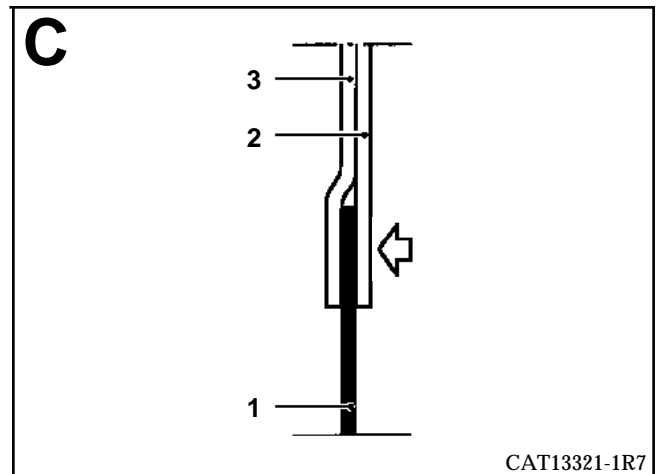
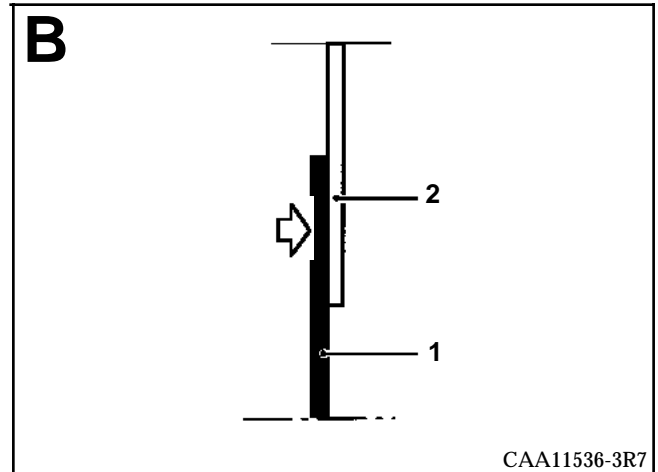
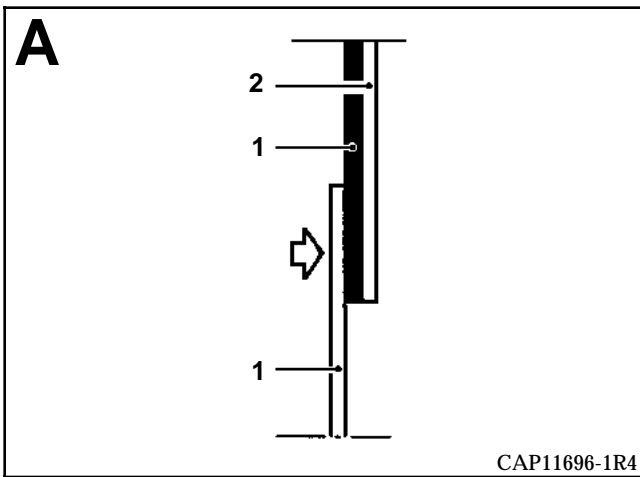
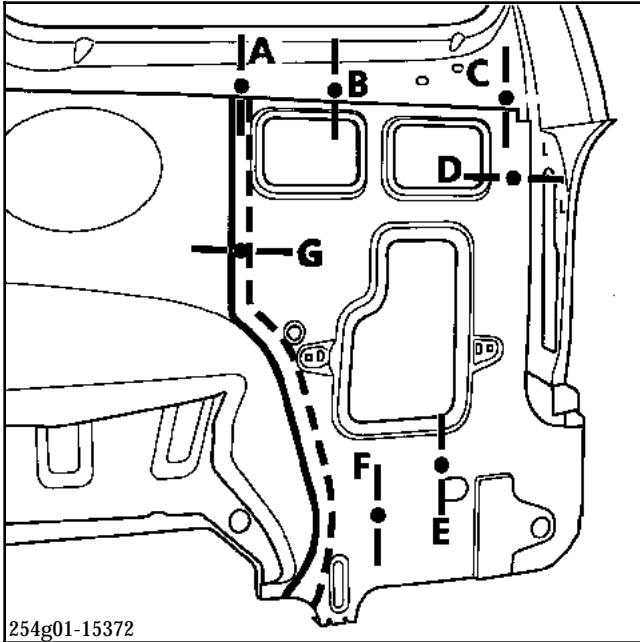
1	Body side lining	0.7
2	Rear quarter panel lining	0.7
3	Rear end pillar lining	1
4	Rear floor base	0.8
5	Rear floor	0.7
6	Rear inner wheel arch	0.8
7	Seat belt mounting reinforcement	1.5

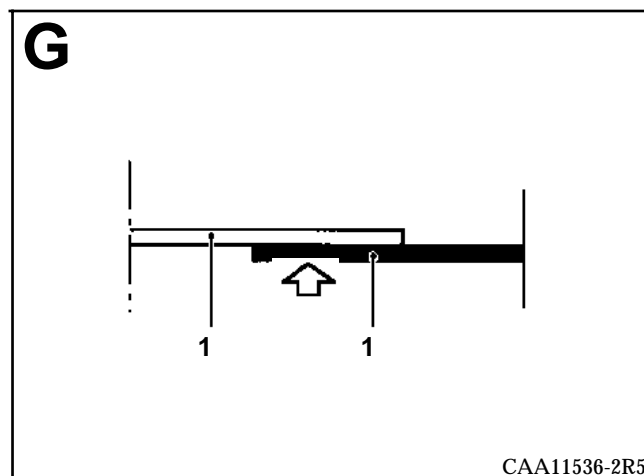
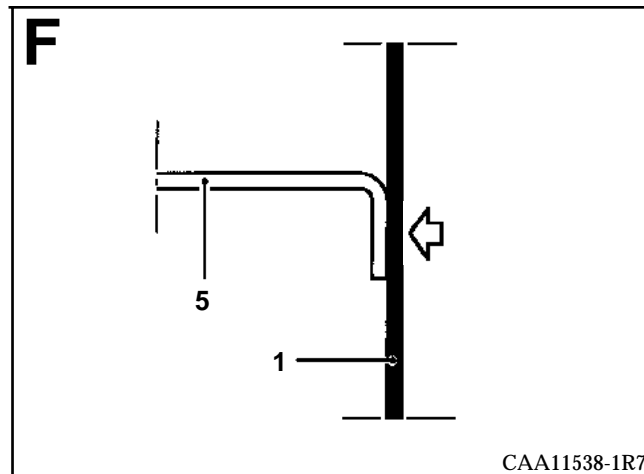
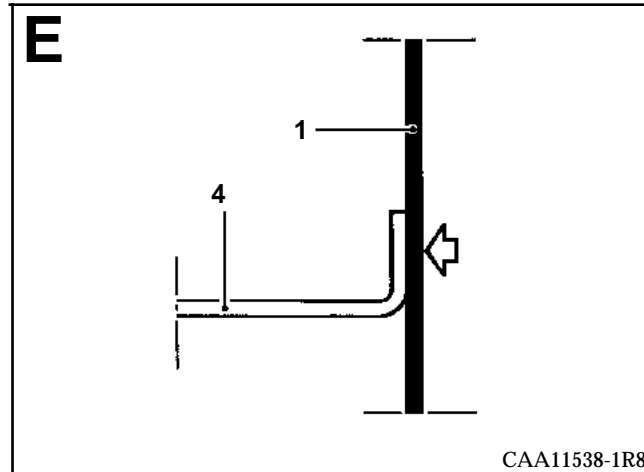
UPPER REAR STRUCTURE

Outer wheel arch

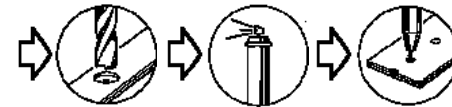
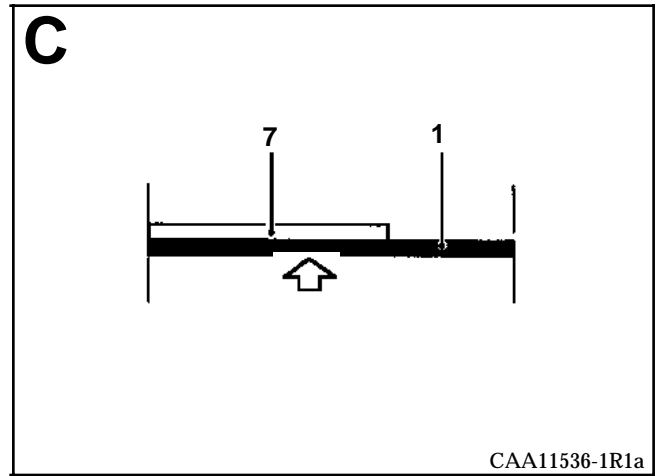
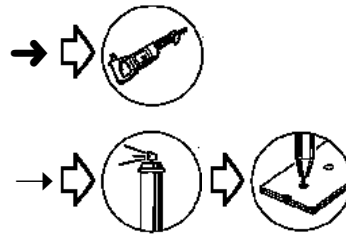
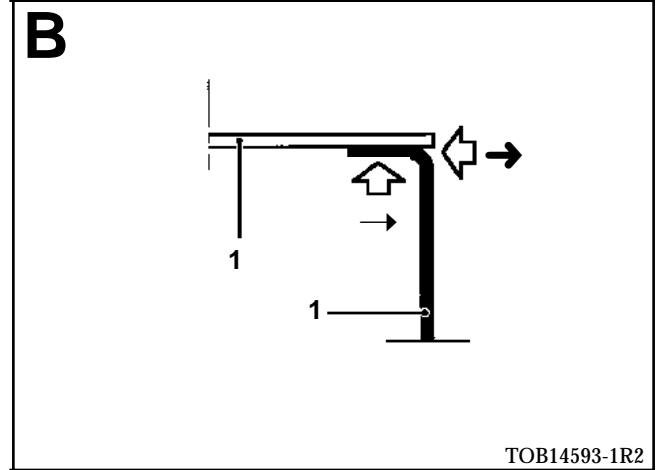
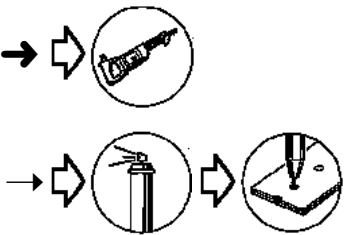
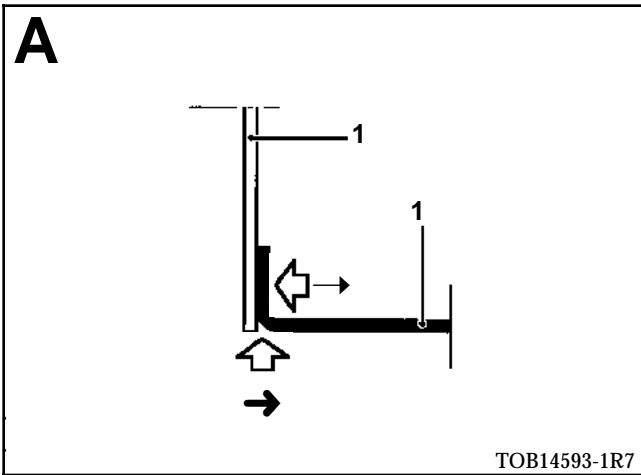
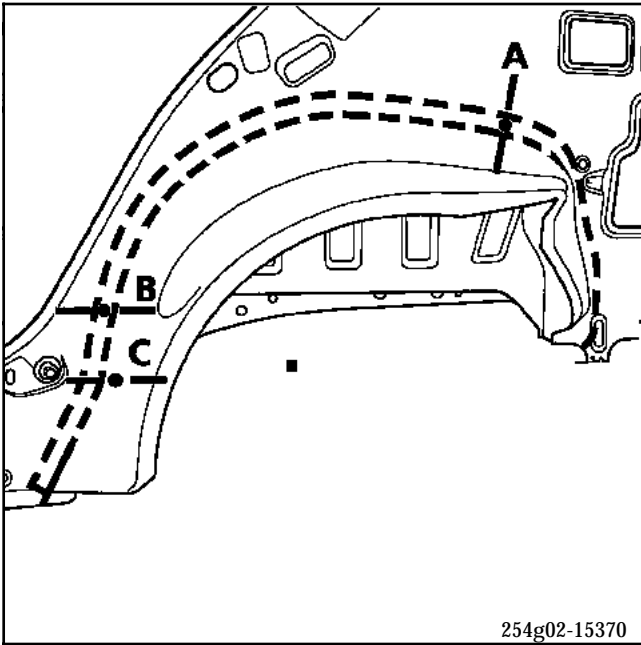
44 **G**

COMPLEMENTARY TO REAR END PILLAR
REINFORCEMENT





COMPLEMENTARY TO REAR WING PANEL



INTRODUCTION

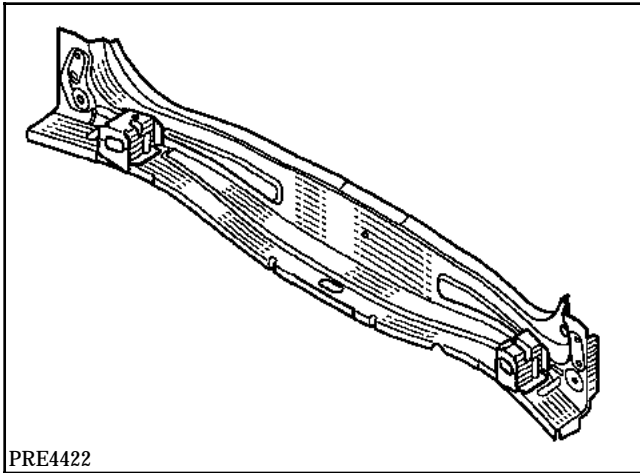
The replacement of this part is a basic operation for a rear impact.

The method described only contains descriptions of joints specific to the part concerned. Joints with complementary parts are not included.

These are dealt with in their respective section (refer to the contents page).

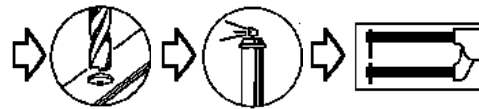
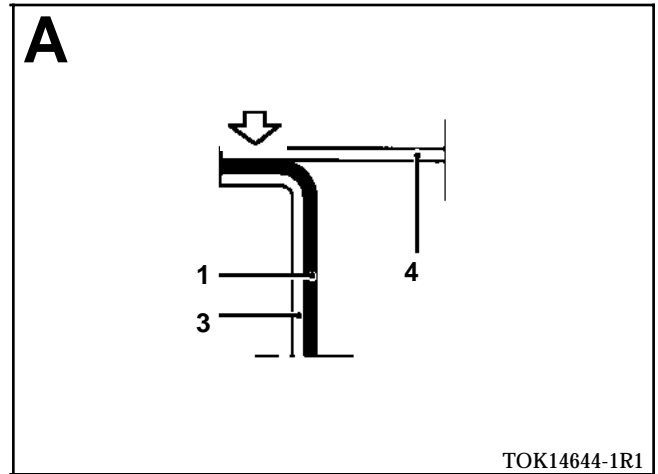
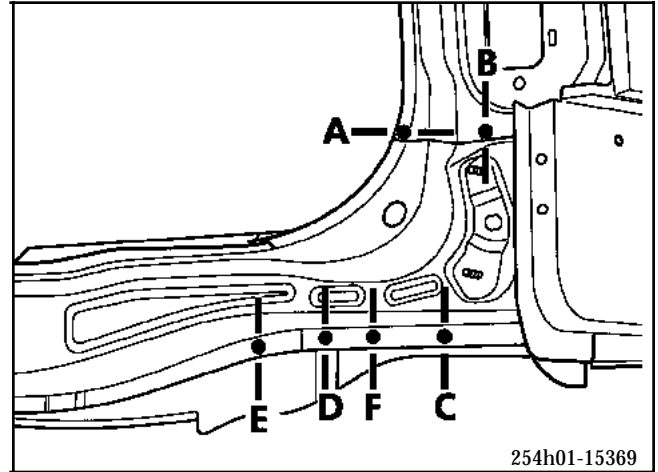
COMPOSITION OF PART FROM PARTS DEPARTMENT

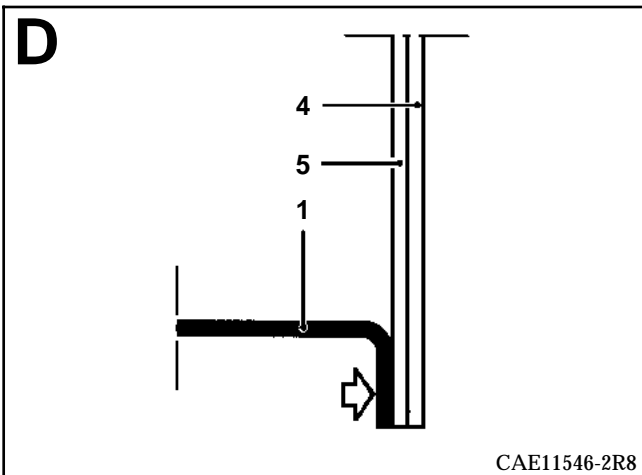
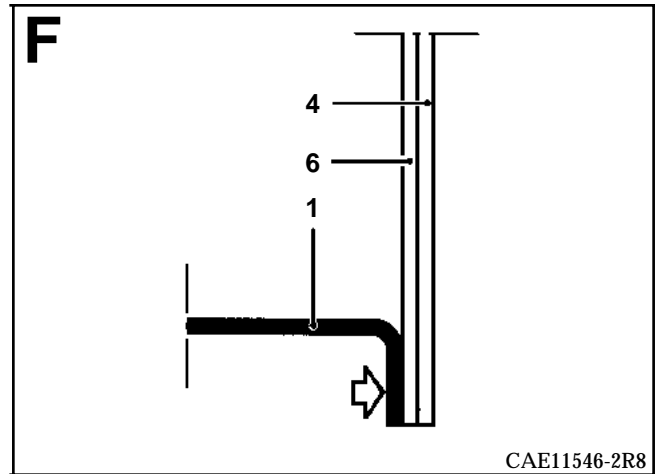
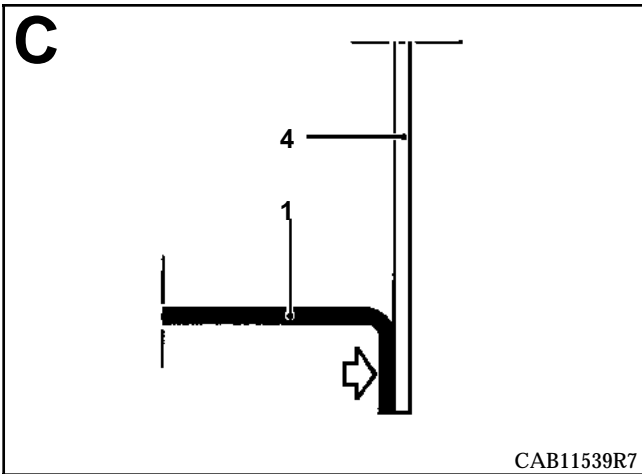
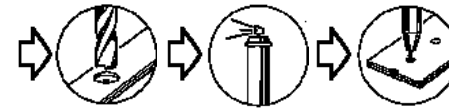
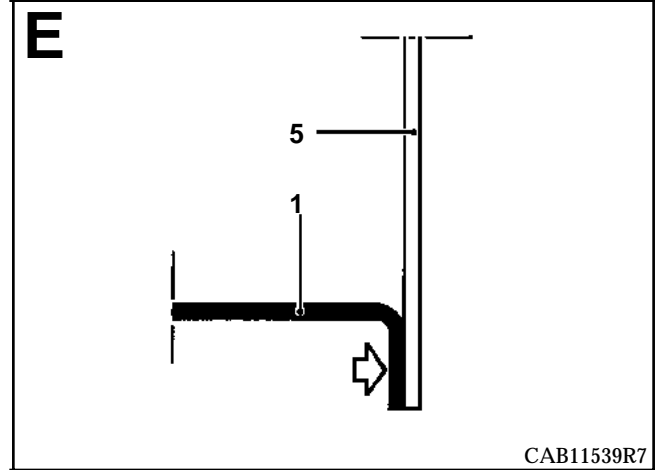
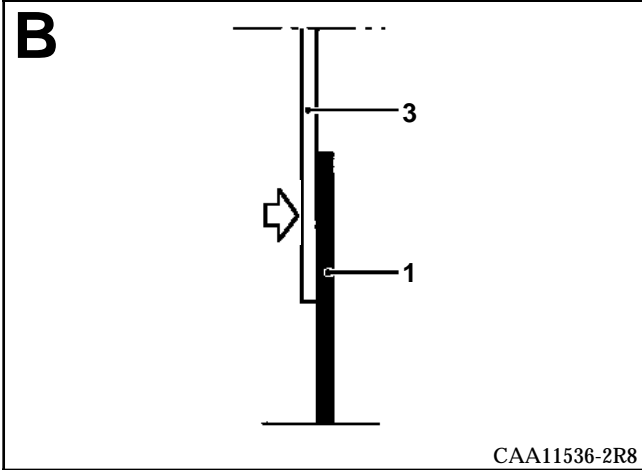
Part assembled with rear end panel lower reinforcement.

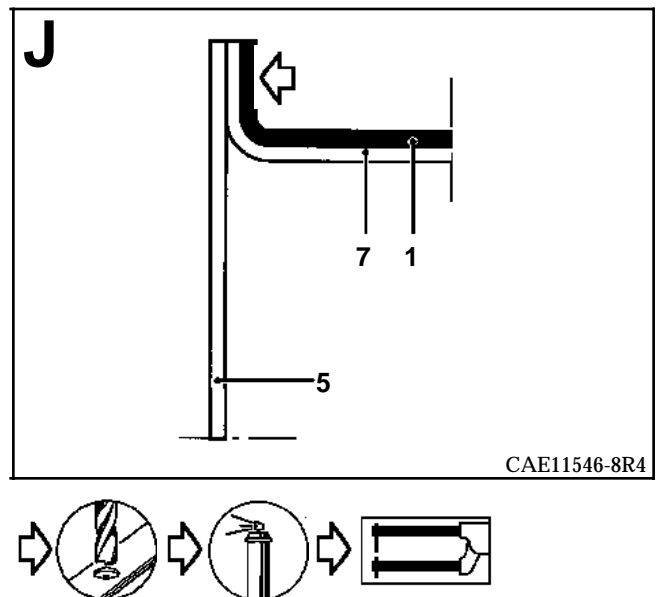
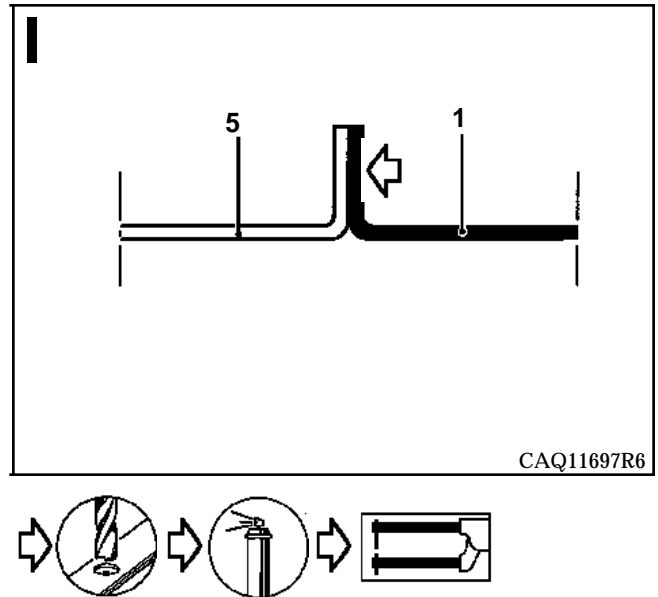
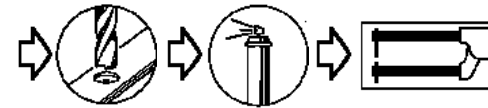
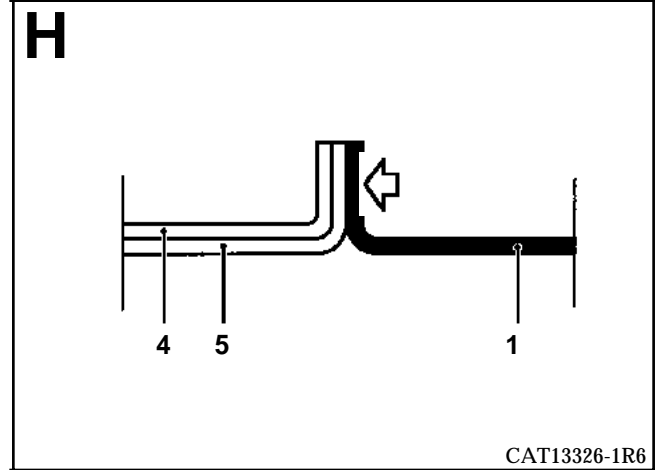
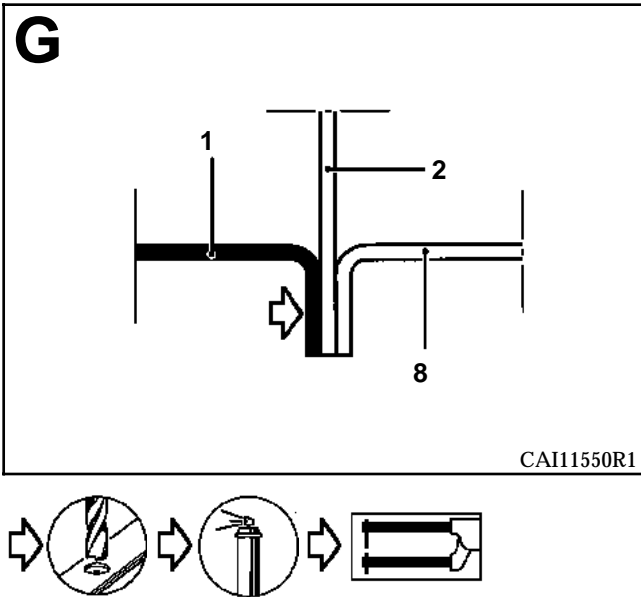
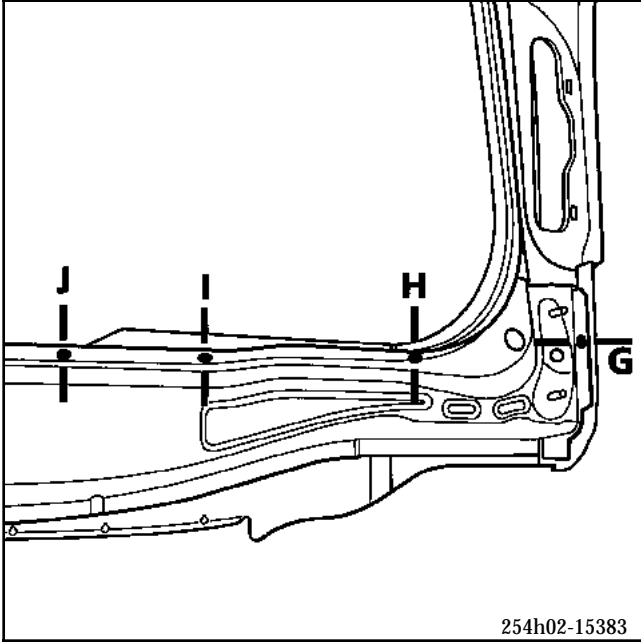


PARTS CONCERNED (thickness in mm) :

1	Rear end panel	1
2	Body side lining	0.7
3	Lights mounting	0.7
4	Rear end pillar lower reinforcement	1
5	Rear end cross member	0.8
6	Rear end panel inner reinforcement	1
7	Tailgate striker plate reinforcement	1.2
8	Rear wing panel	1



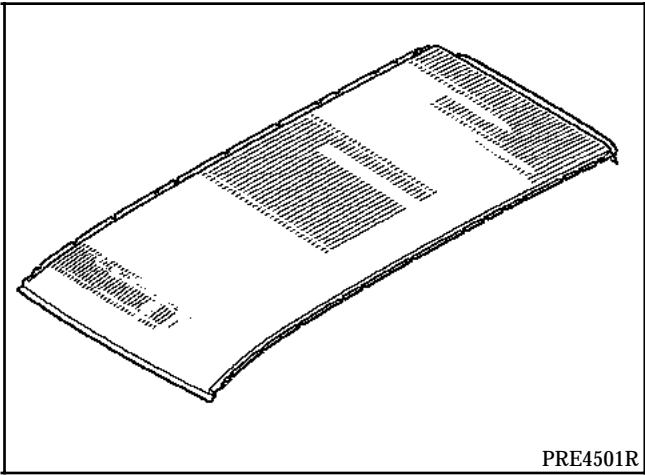




INTRODUCTION

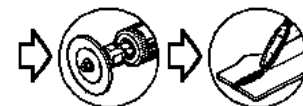
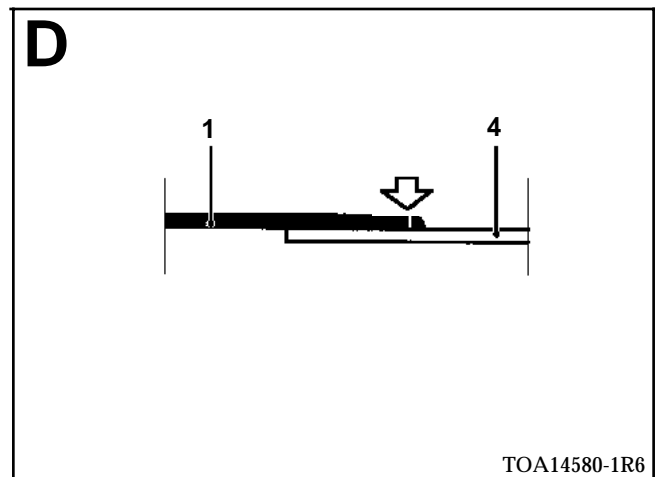
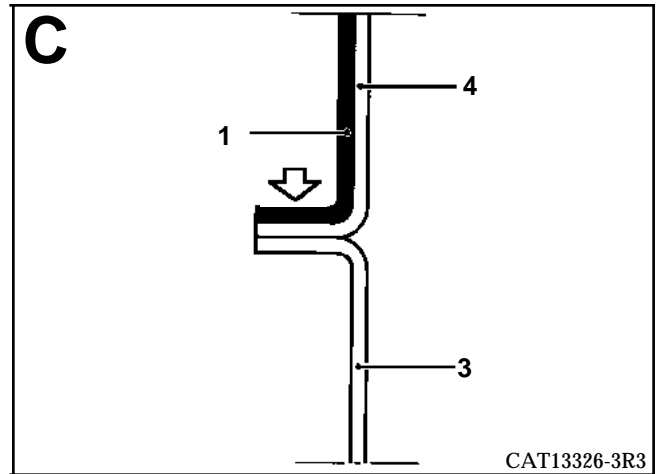
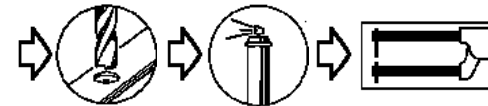
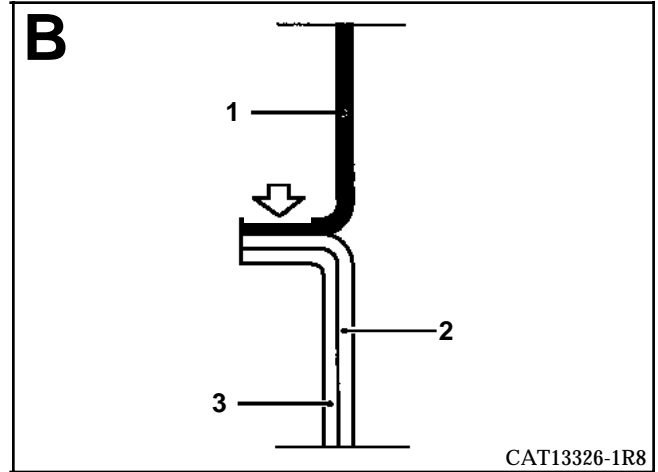
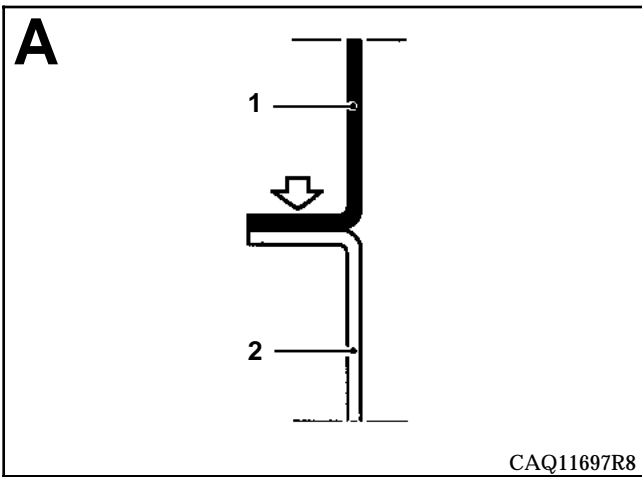
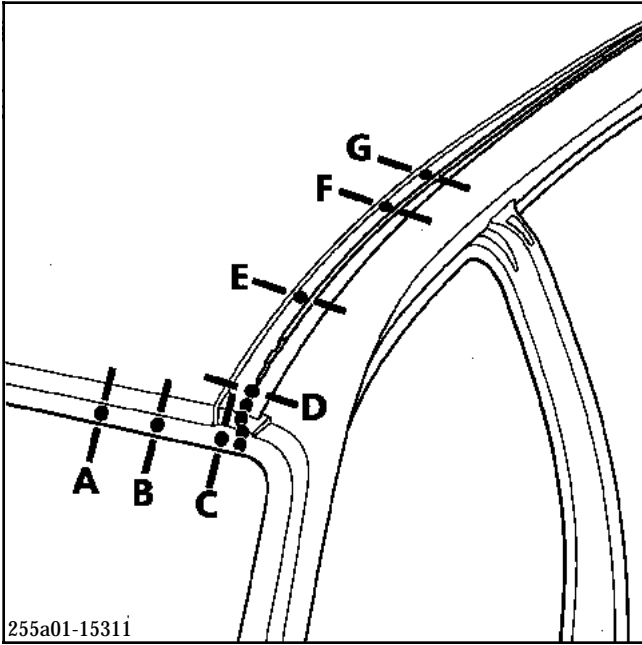
The replacement of this part is a basic operation for a side impact or a roll-over.

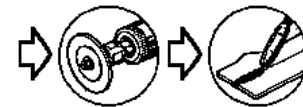
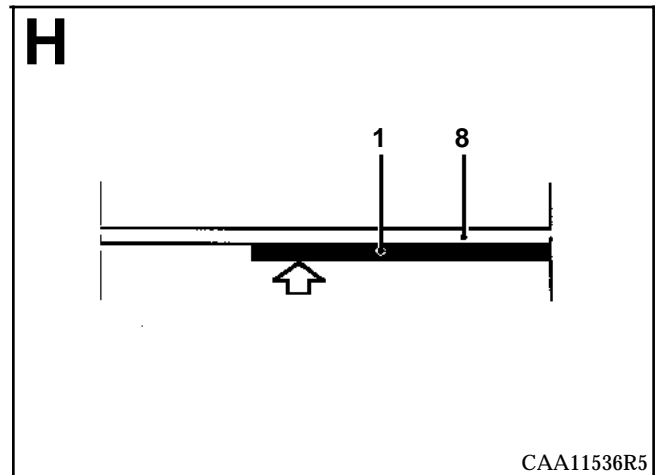
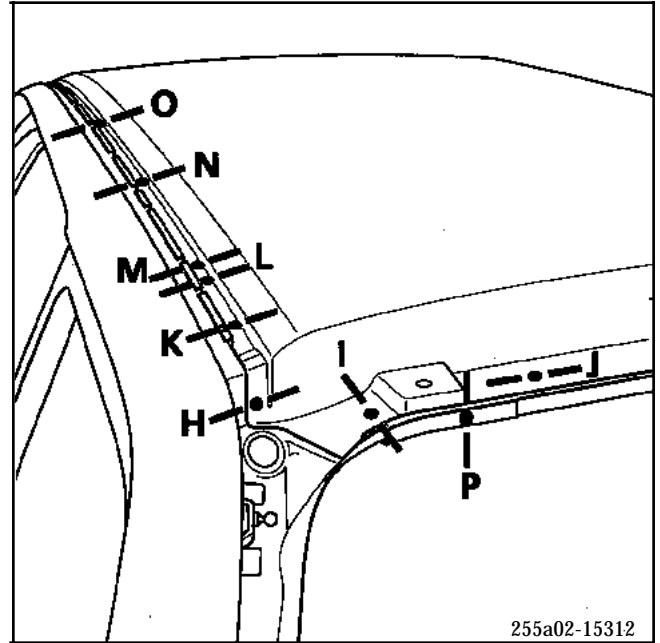
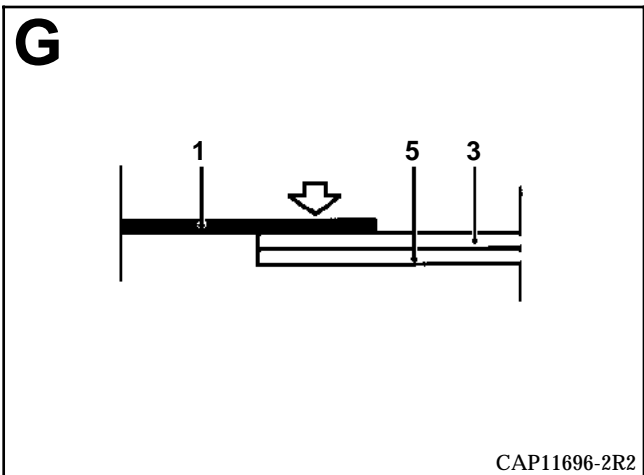
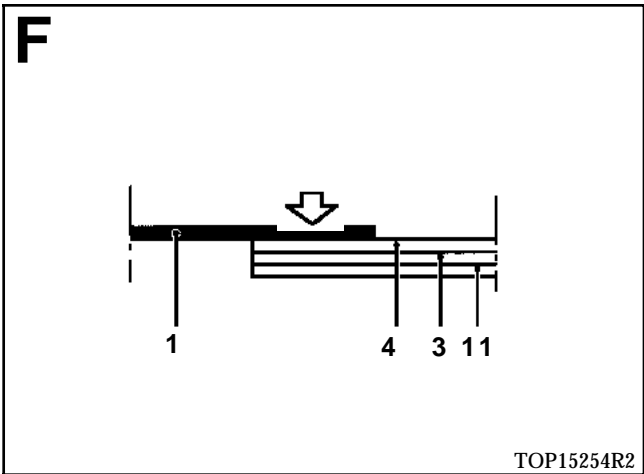
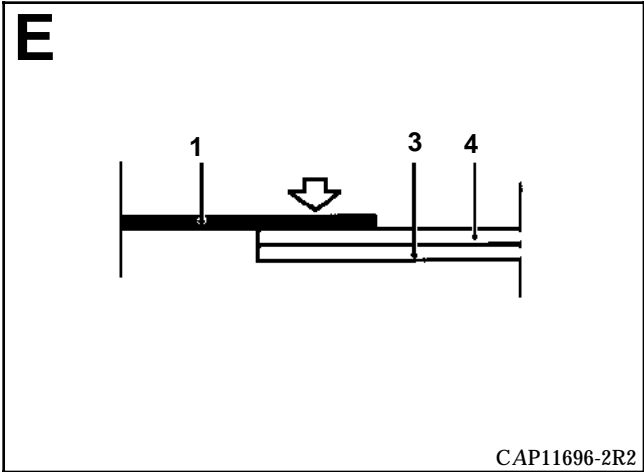
COMPOSITION OF PART FROM PARTS
DEPARTMENT

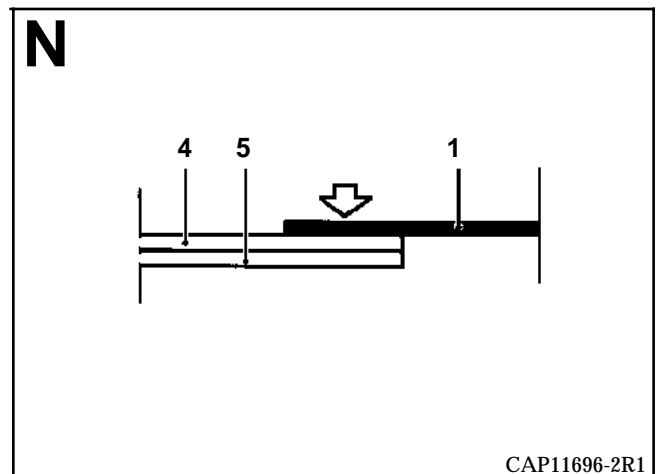
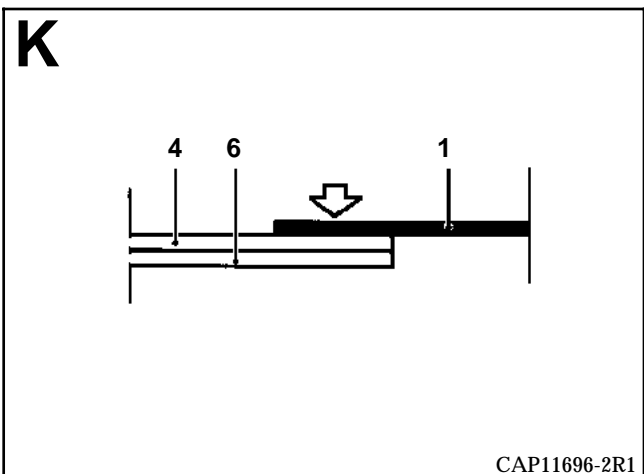
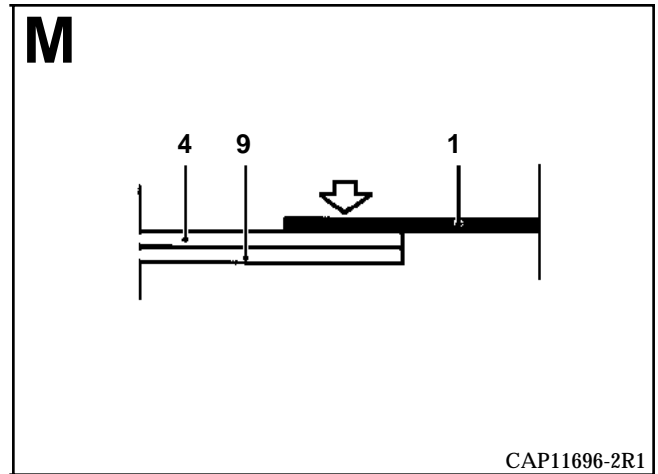
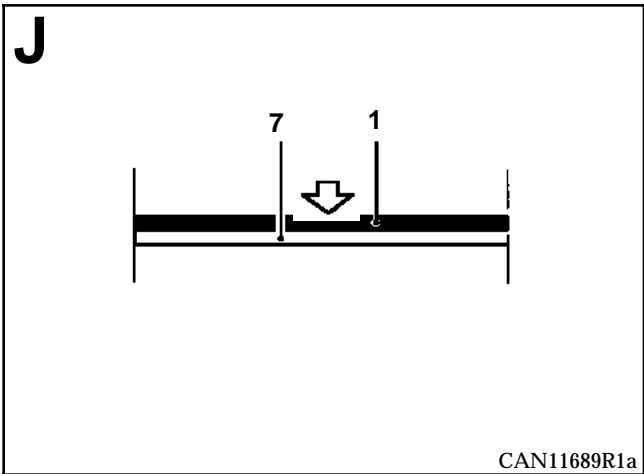
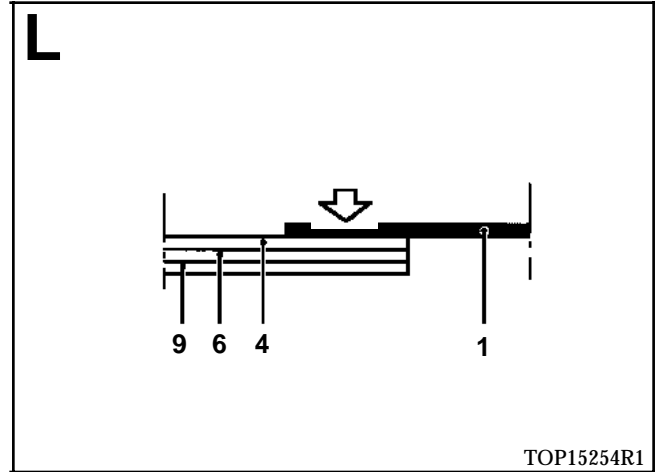
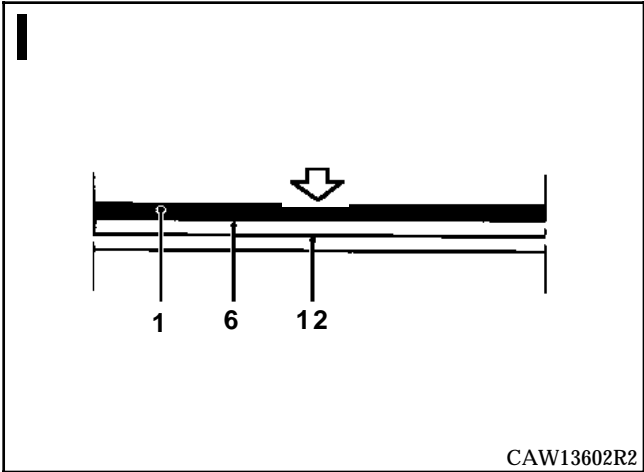


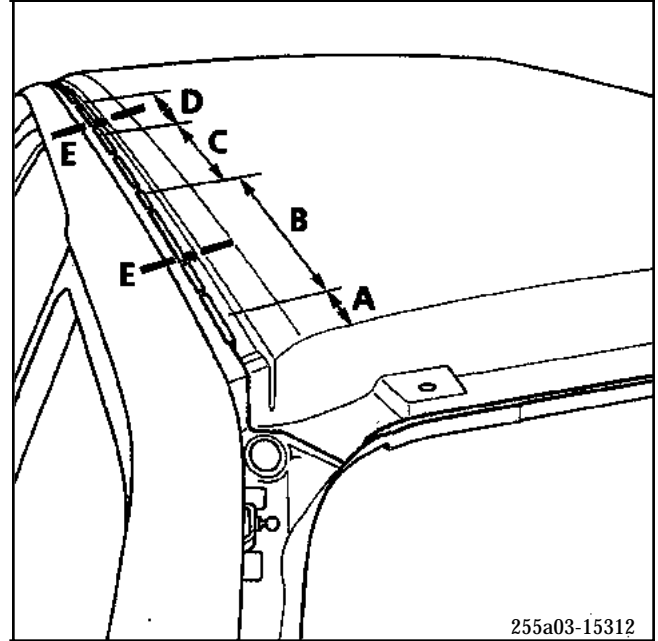
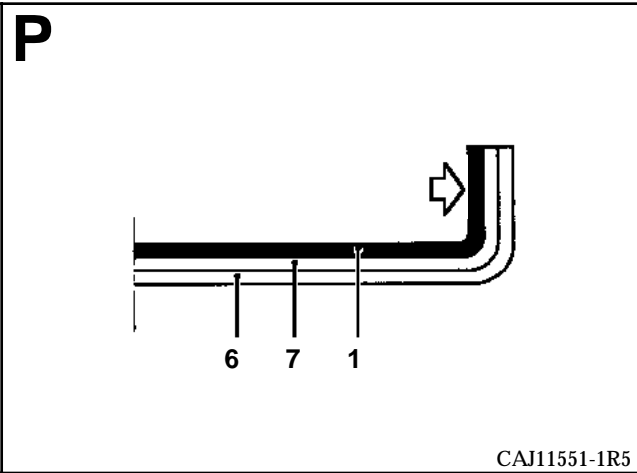
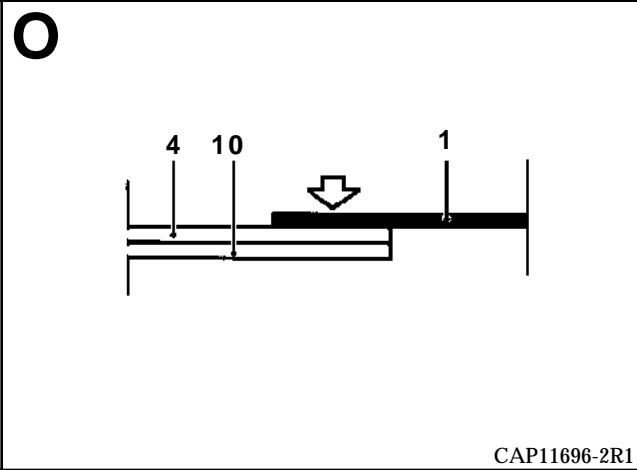
PARTS CONCERNED (thickness in mm) :

1	Roof	0.7
2	Front roof cross member	0.7
3	Windscreen pillar lining	1.5
4	Body side	0.77
5	Centre pillar reinforcement	1.5
6	Rear corner reinforcement	1.2
7	Rear roof cross member	0.7
8	Rear upper side drip moulding	1
9	Rear quarter panel lining	0.7
10	Stretcher lining	1.2
11	Centre pillar lining	1.2
12	Rear end pillar lining	0.9

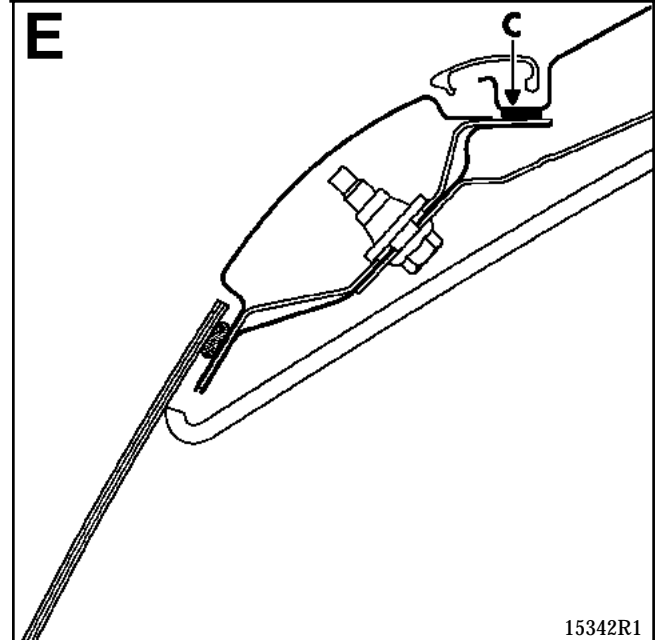








A = 70 mm
B = 500 mm
C = 500 mm
D = 300 mm



Bead C

NOTE : apply a bead of adhesive mastic (C) in zones (B) and (D) of the basic diagram, to reinforce the roof where the roof bars are mounted.

INTRODUCTION

The replacement of this part is a complementary operation to the replacement of the roof for a roll-over.

For reasons of standardisation, the Parts Department only supplies parts for the version without sunroof. Where a sunroof is fitted originally, the roof and the centre roof cross member must be cut according to the diagram below.

These cuts must also be made to fit a sunroof as an accessory.

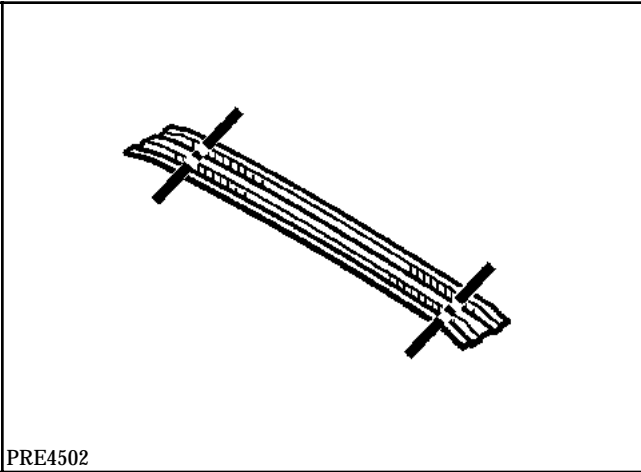
IMPORTANT : the roof cross member has a structural reinforcement function. For the version with sunroof, the sunroof frame fulfils this function. When fitting a sunroof as an accessory it is recommended that only sunroofs approved by the Renault accessories department are used.

The method described only contains descriptions of joints specific to the part concerned. Joints with complementary parts are not included.

These are dealt with in their respective section (refer to the contents page).

COMPOSITION OF PART FROM PARTS DEPARTMENT

Single part.

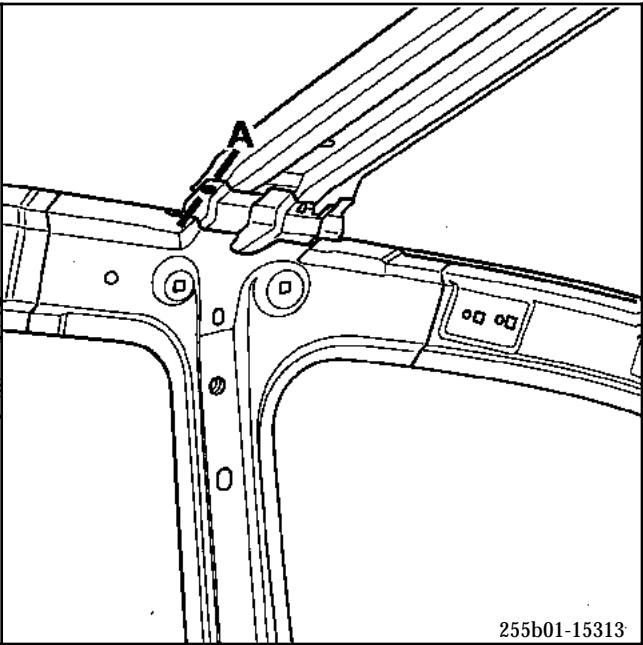


For sunroof

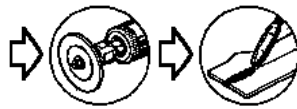
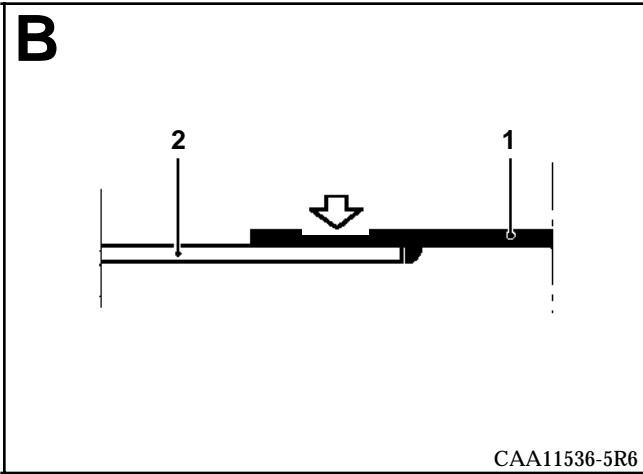
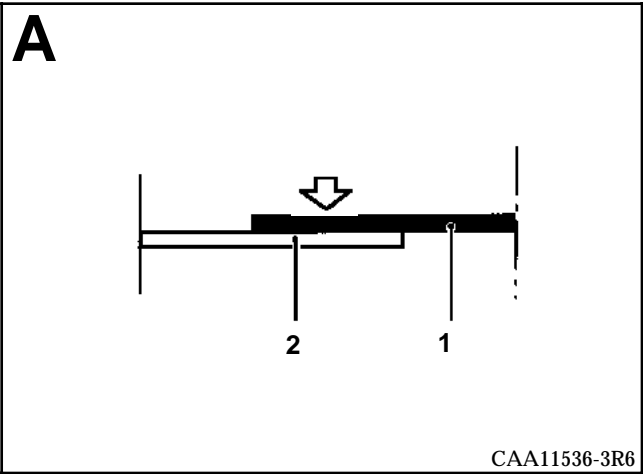
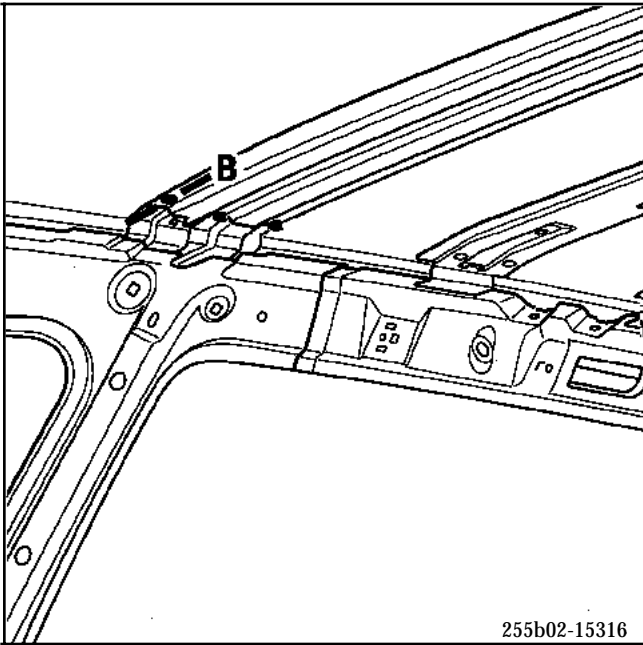
PARTS CONCERNED (thickness in mm) :

- | | | |
|---|-----------------------------|-----|
| 1 | Acoustic cross member | 0.7 |
| 2 | Centre pillar reinforcement | 1.5 |

LEFT HAND SIDE



RIGHT HAND SIDE



INTRODUCTION

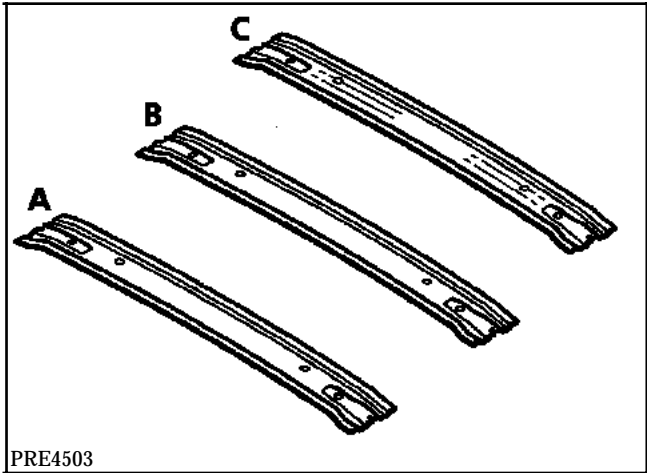
The replacement of this part is a complementary operation to the replacement of the roof for a roll-over.

The method described only contains descriptions of joints specific to the part concerned. Joints with complementary parts are not included.

These are dealt with in their respective section (refer to the contents page).

**COMPOSITION OF PART FROM PARTS
DEPARTMENT**

Single part.

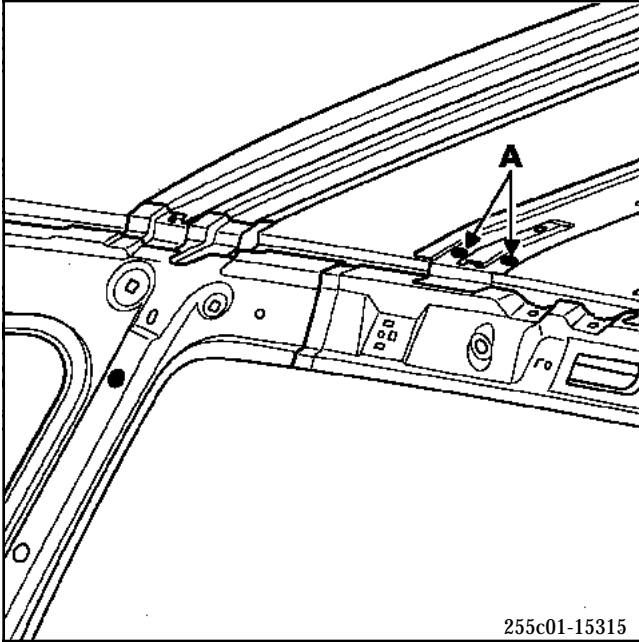


Bows (A) and (B) are mounted by rivets.
Bow (C) is spot welded.

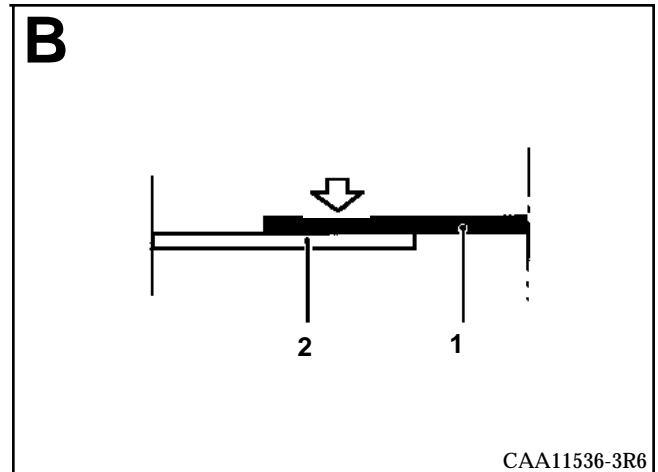
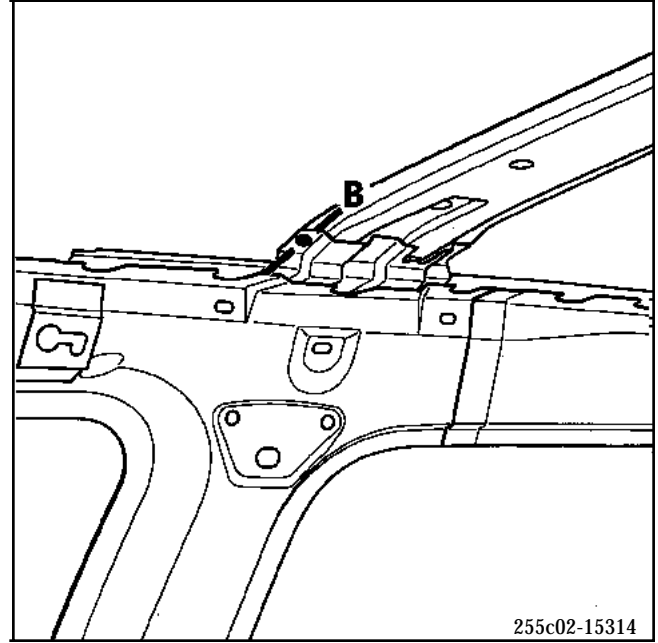
PARTS CONCERNED (thickness in mm) :

1	Roof bow	0.7
2	Rear pillar upper reinforcement	1
3	Roof bow support	1.2

BOWS A and B



A = rivet diameter **4.8 mm**
(joint with bow support)



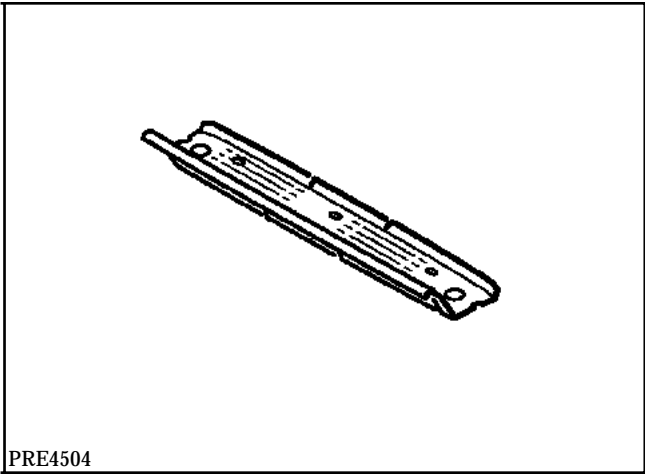
INTRODUCTION

The replacement of this part is a complementary operation to the replacement of the roof for a roll-over.

The method described only contains descriptions of joints specific to the part concerned. Joints with complementary parts are not included. These are dealt with in their respective section (refer to the contents page).

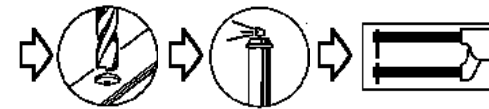
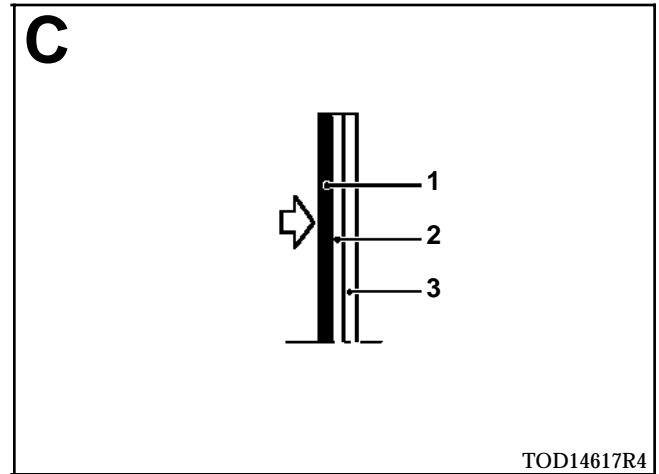
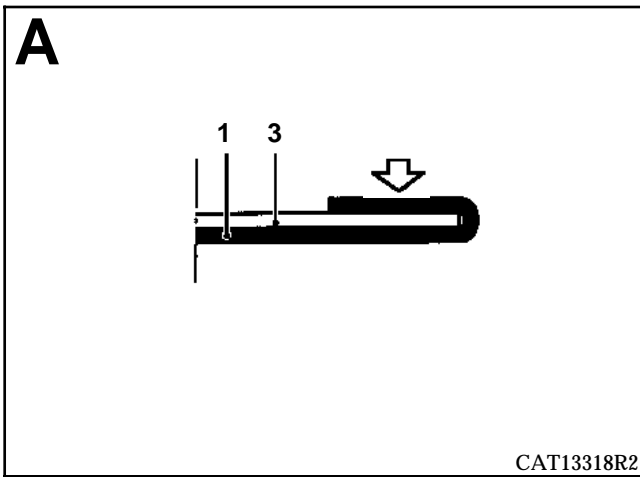
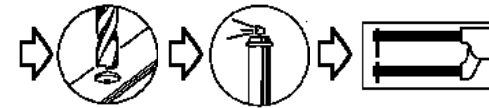
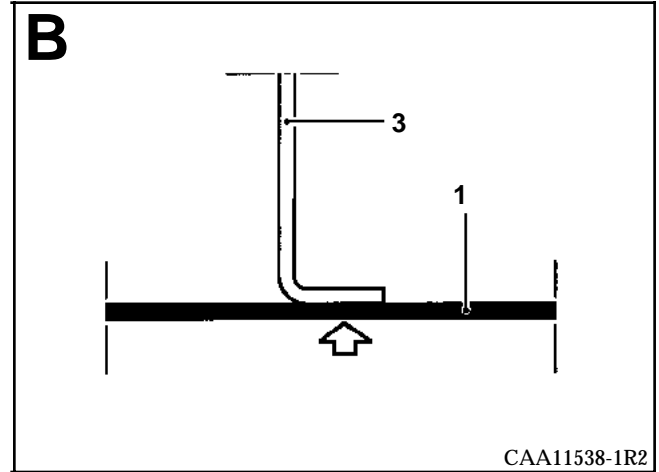
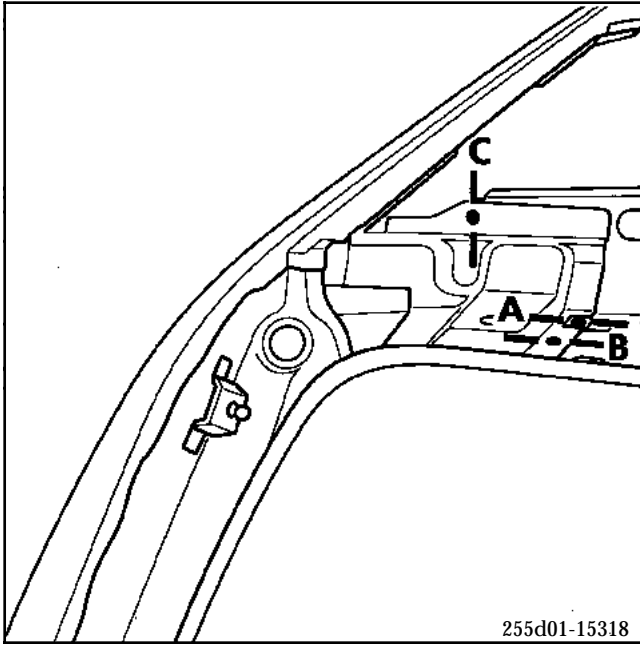
COMPOSITION OF PART FROM PARTS
DEPARTMENT

Single part.



PARTS CONCERNED (thickness in mm) :

1	Roof rear cross member	0.7
2	Rear quarter panel lining	0.7
3	Rear corner reinforcement	1.2



SIDE OPENING ELEMENTS

Rear door panel

47**A**

INTRODUCTION

The replacement of this part is a basic operation for a side impact.

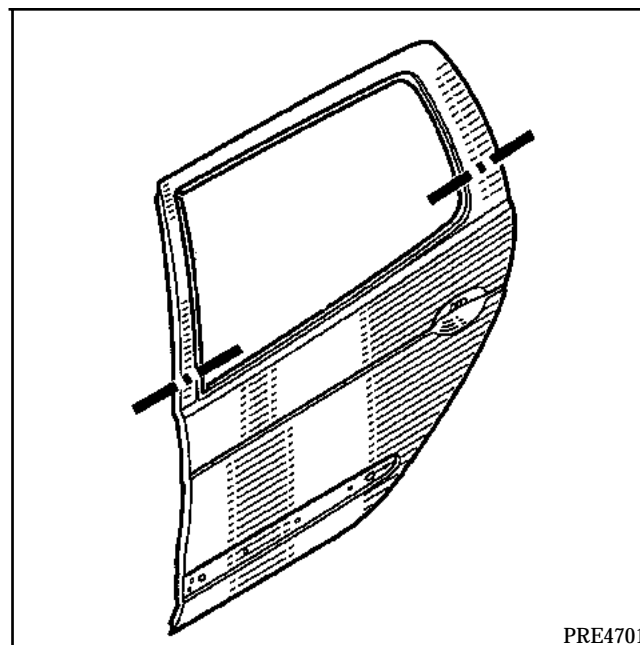
This part may be partially replaced (see cut and method below).

NOTE : the original panels have MIG welded anchorage points. In repair, these points are not made (sections A on the diagram below).

COMPOSITION OF PART FROM PARTS DEPARTMENT

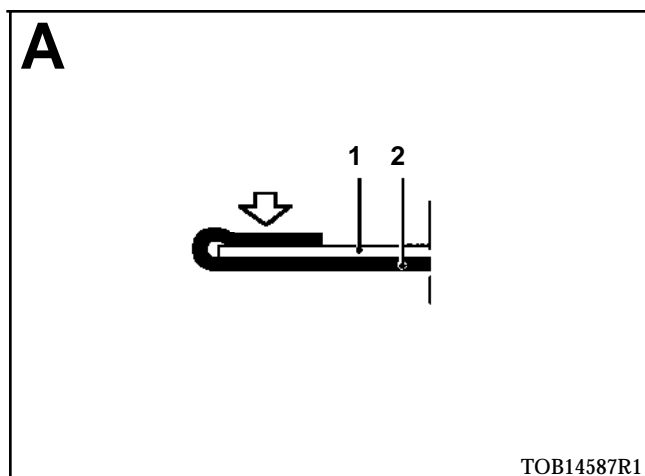
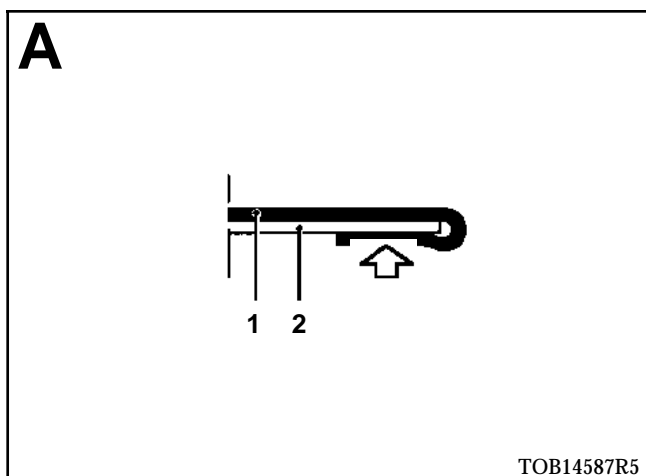
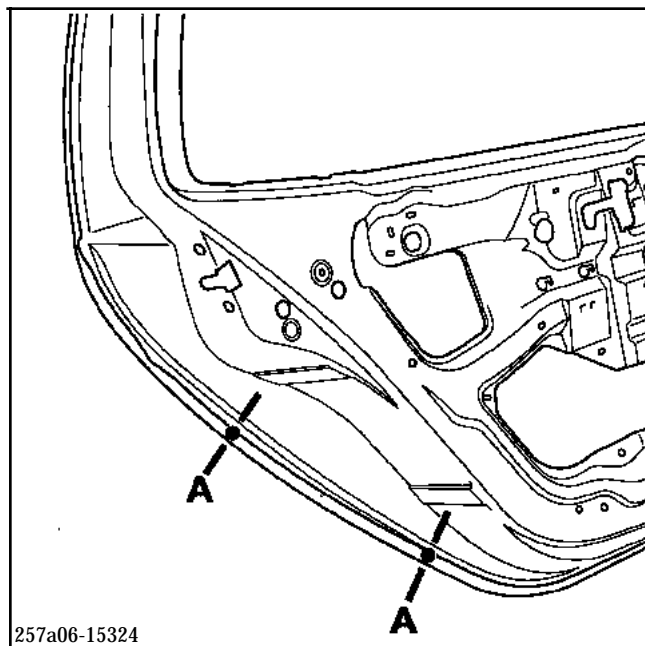
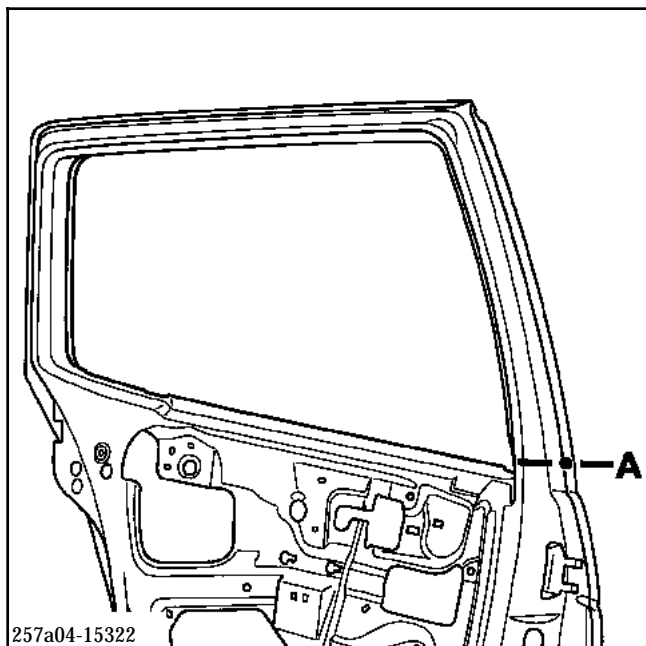
Part assembled with:

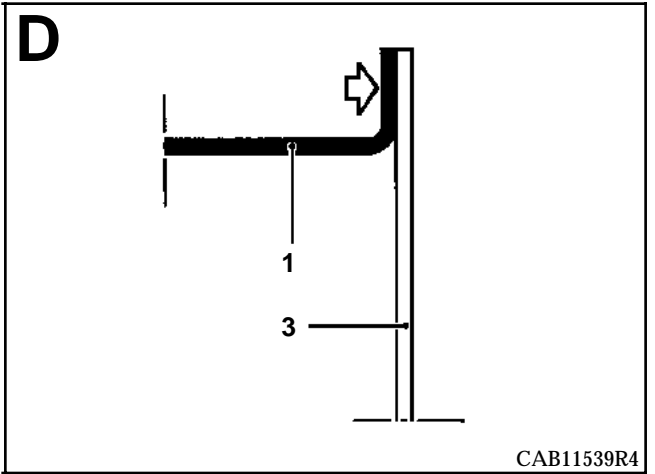
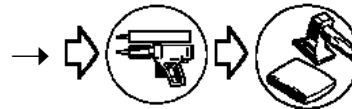
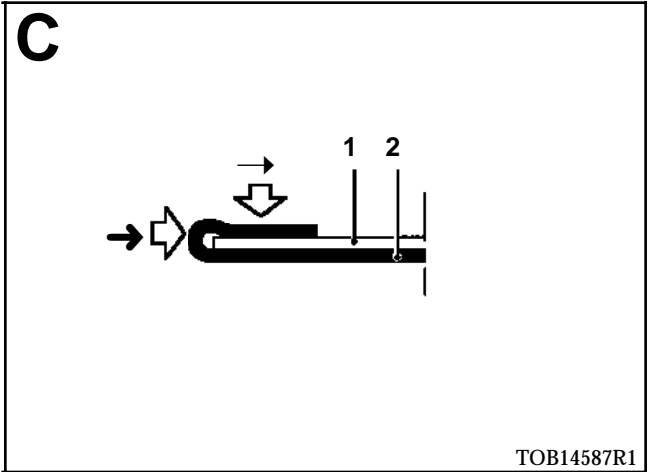
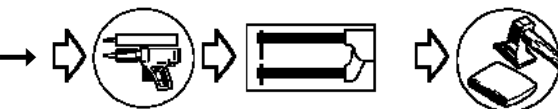
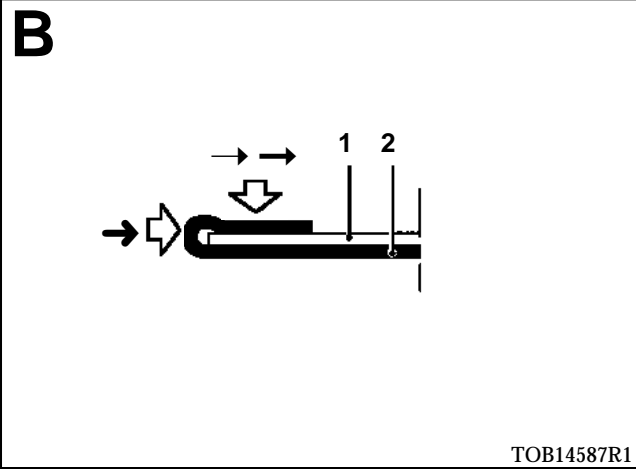
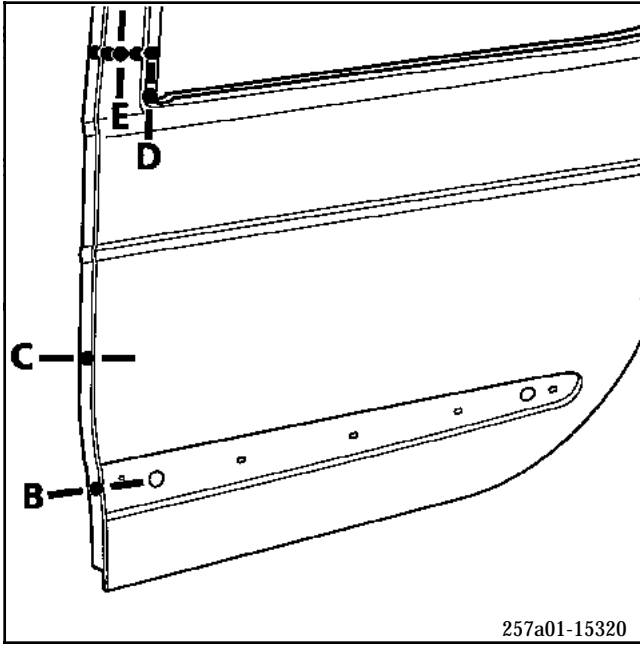
- soundproofing,
- stiffener.

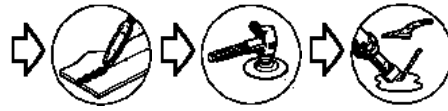
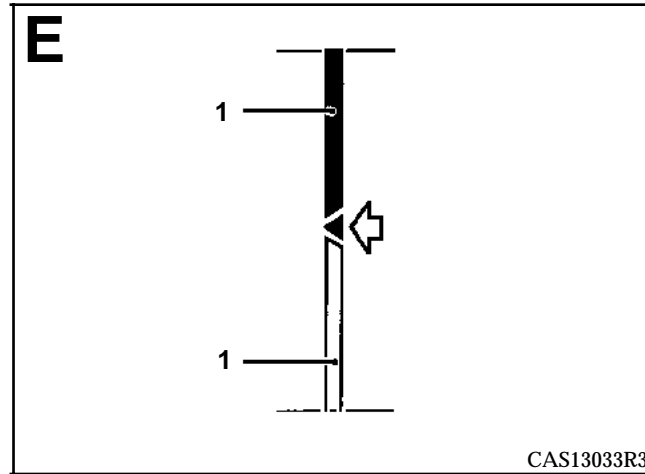


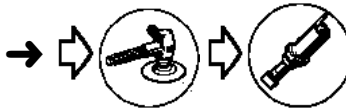
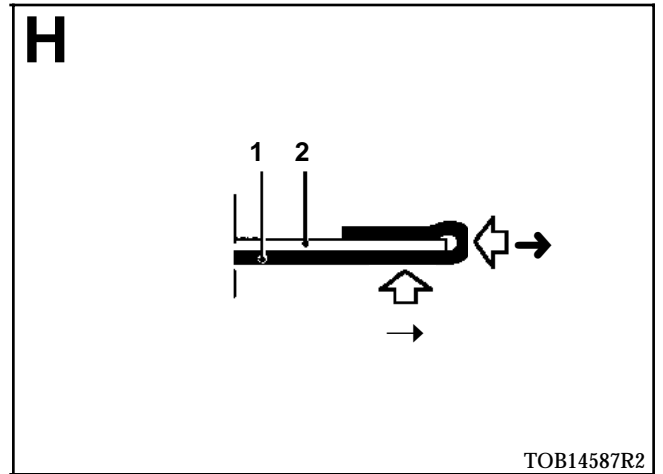
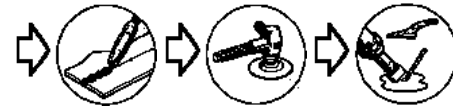
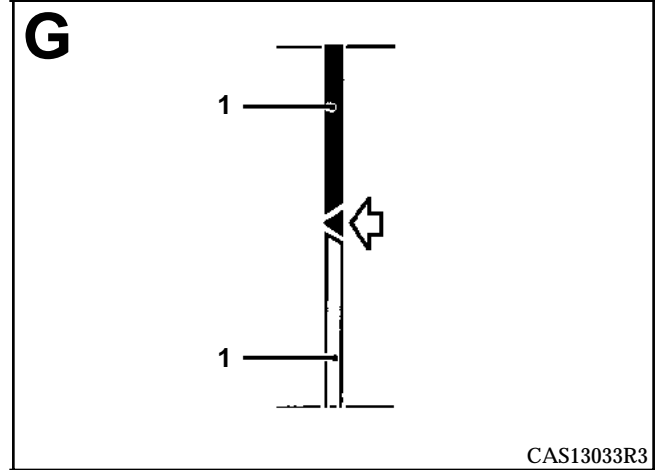
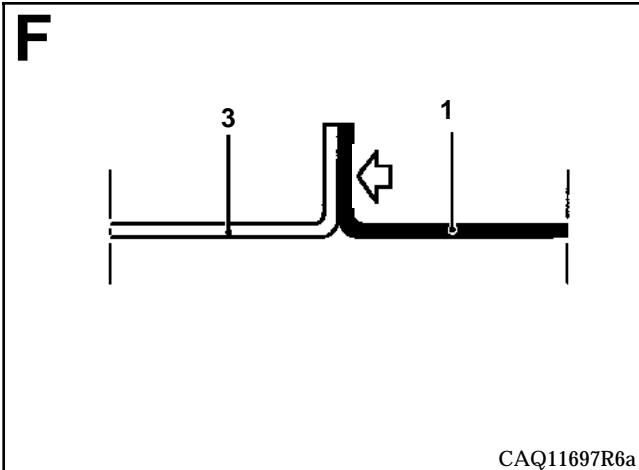
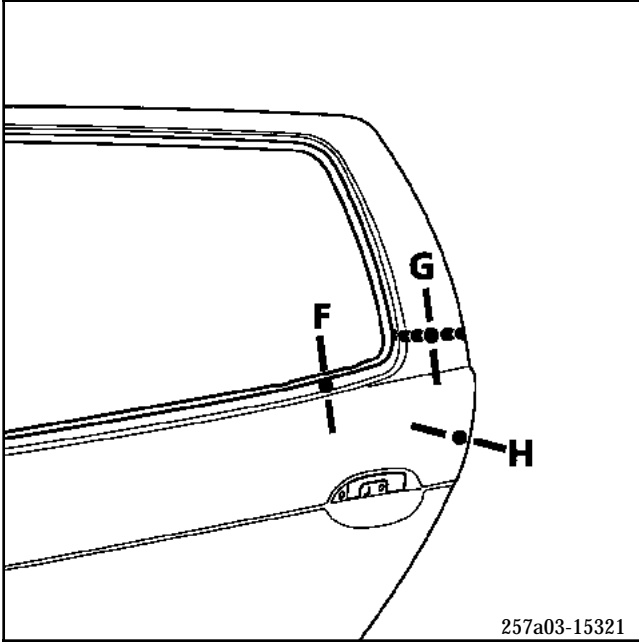
PARTS CONCERNED (thickness in mm) :

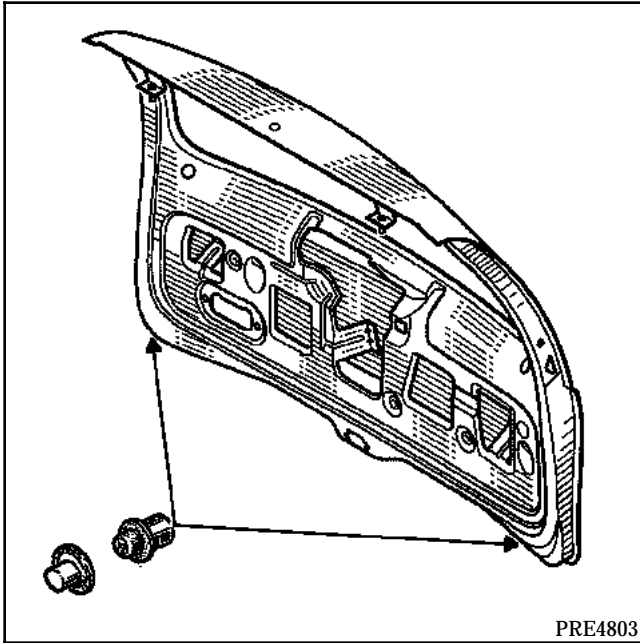
1	Door panel	0.7
2	Door box section	0.7
3	Door frame	0.8









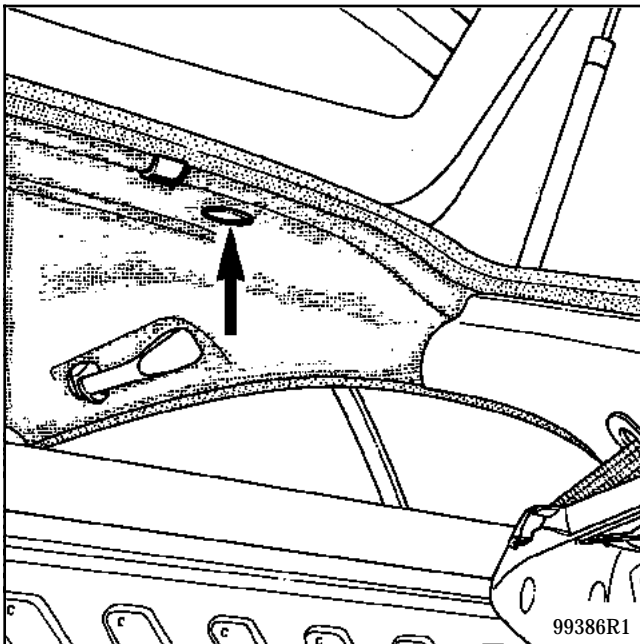


REMOVAL

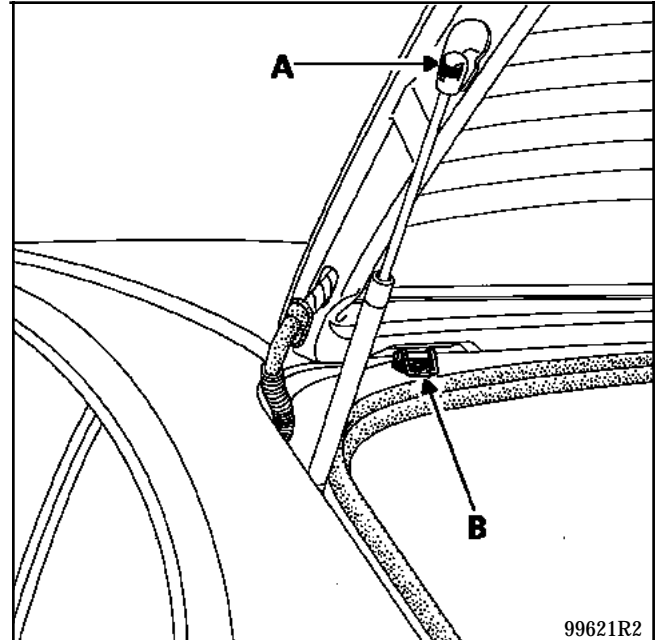
Remove the trim and disconnect the various wiring harnesses (see sections 52 and 71).

Remove:

- the third stop light,
- the rear screen washer jet pipe,
- the wiring harness,



- the headlining plugs using a screwdriver (torx 20).



Unclip the tailgate balancers at (A).

Remove the mounting nuts and remove the hinges (B) (two persons required for this operation).

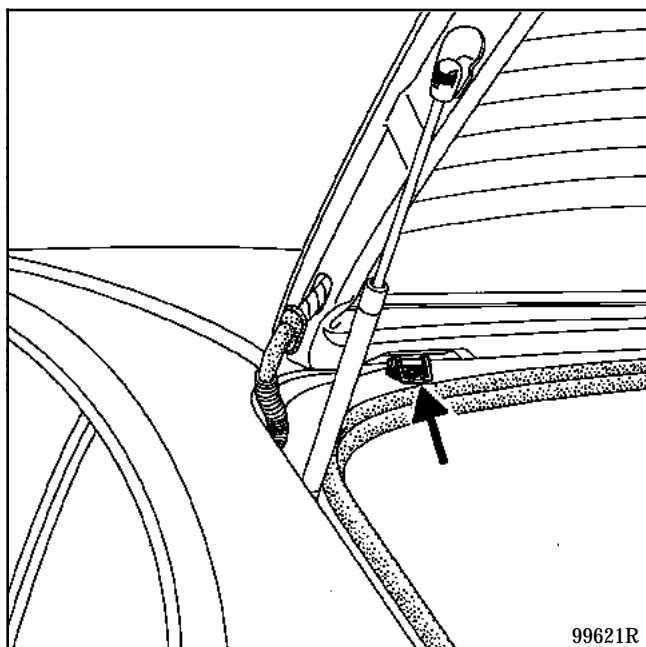
NOTE : if the tailgate or the roof is being replaced, retain the height adjustment shims located under the hinges (B).

To do this, use a cutting tool to destroy the finishing seal around the shims and retain them.

The hinges are welded on the tailgate, so these shims of thickness **1 mm** are used to adjust the clearance between the roof and the tailgate.

Tailgate

REFITTING

**IMPORTANT**

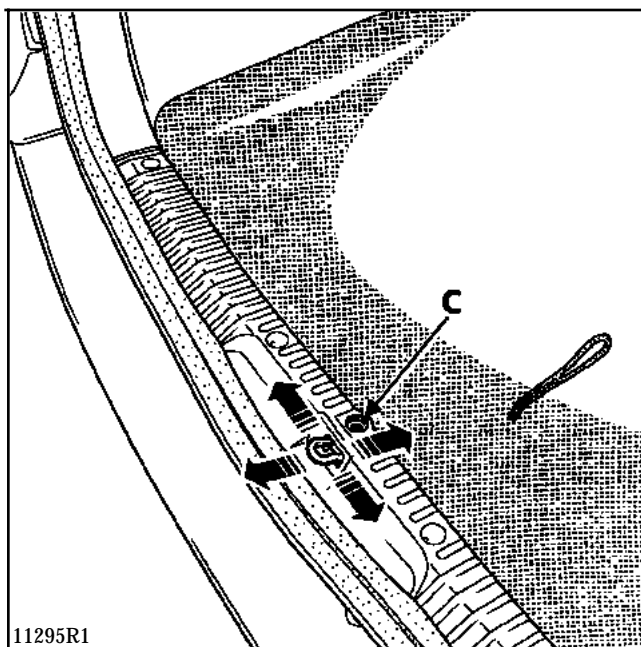
When refitting the hinges, remember to ensure sealing between the sealing washers (under the mounting nuts) and the roof panel.

To do this, use plugging mastic Part Number 77 11 170 230 (refer to Technical Note 396A).

To adjust the tailgate and its lock after refitting, observe the opening clearances 4, 6 and 7 described in section 40.

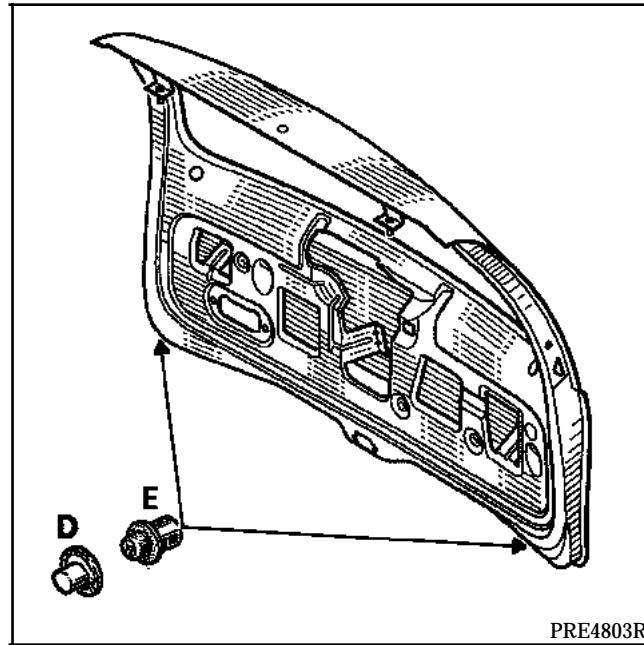
This adjustment must be made with the tailgate fully fitted.

PROCEDURE FOR ADJUSTING THE STRIKER PLATE



NOTE : before beginning the adjustments below, slacken the lock striker plate mounting bolt (C), so there is no resistance to closing.

Tailgate



The adjustment operation is carried out with two persons. To do this, hook the lock on the striker plate and press the tailgate against the lower stops (D) and (E).

At the same time, from inside the vehicle, tighten the striker plate mounting bolt.

At the end of the adjustment operation, apply a bead of paint joint mastic around the three visible faces of the adjusting shims for the hinges.

Carry out an operation to paint these beads.