

RENAULT

4 Panelwork

40A GENERAL VEHICLE INFORMATION

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41B CENTRE LOWER STRUCTURE

41C SIDE LOWER STRUCTURE

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45A TOP OF BODY

47A SIDE OPENING ELEMENTS

48A NON-SIDE OPENING ELEMENTS

X84, and B84 or C84 or G84 or S84

NOVEMBER 2005

Edition Anglaise

"The repair methods given by the manufacturer in this document are based on the technical specifications current when it was prepared.

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Mégane II - Section 4

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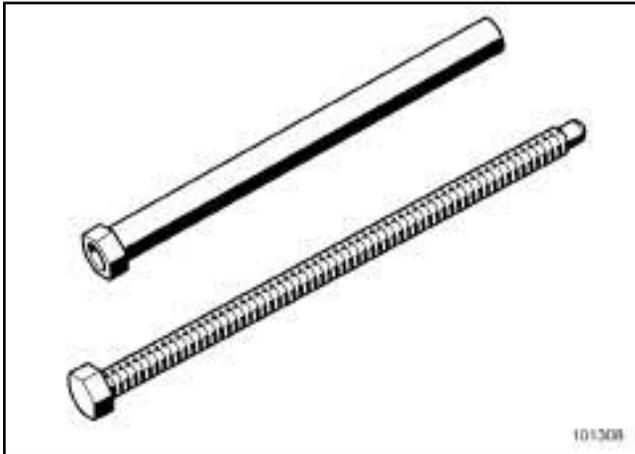
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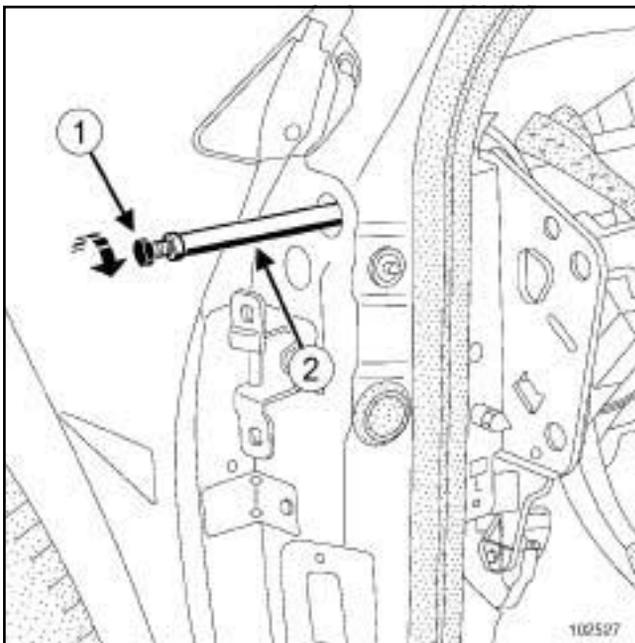
Bodywork special tooling: Use

B84 or C84

USING THE DASHBOARD CROSS MEMBER REMOVAL TOOL Car. 1673

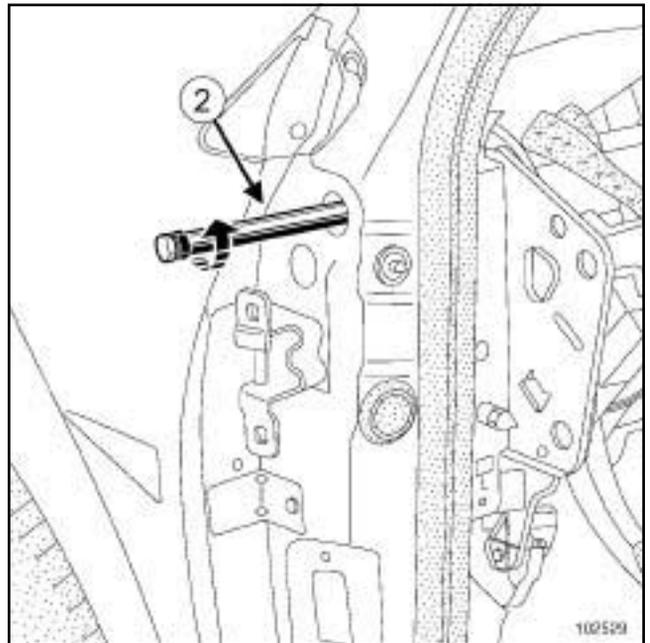


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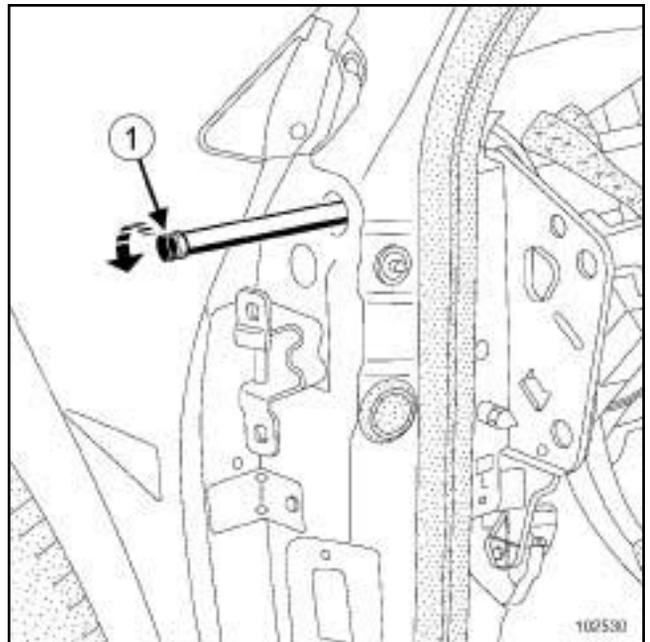
102527

- ❑ Screw the rod (1) onto the body (2) as far as the stop and tighten gently.
- ❑ Insert the assembly into the A-pillar, then screw into the beam as far as the stop.
- ❑ Firmly lock tool body (2) in the same way as a lock nut against the dashboard cross member nut while holding the hexagonal head of bolt (1).



102529

- ❑ Unscrew the tool as far as the stop using hexagon bolt (2) and tighten it gently (during this operation, the beam nut, which has a left-hand thread, screws into the beam and disengages it from the A-pillar).



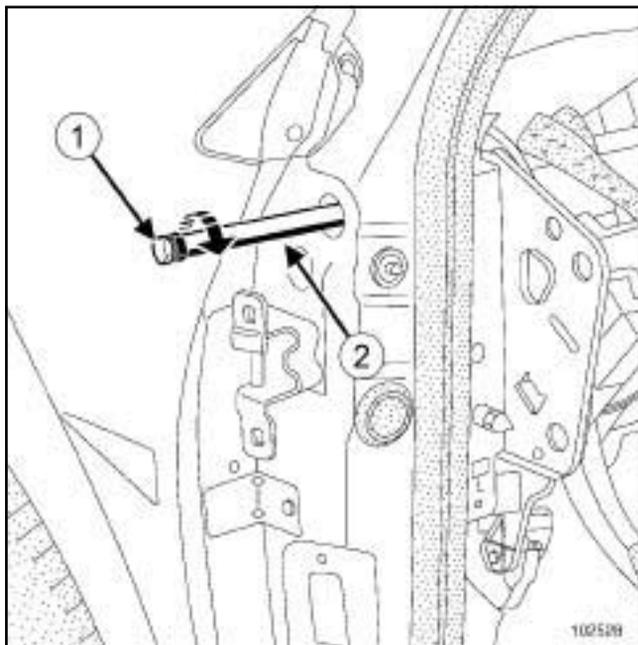
102530

- ❑ Hold the tool body and unlock rod (1) in the same way as a lock nut.
- ❑ Unscrew dashboard cross member rod (1) to remove the tool.
- ❑ Repeat the procedure for the second bolt.

This releases the dashboard cross member from the A-pillar.

B84 or C84

- To refit, screw the lock nut (left-hand thread) fully into the beam.
- Fit the beam with the A-pillar hole.



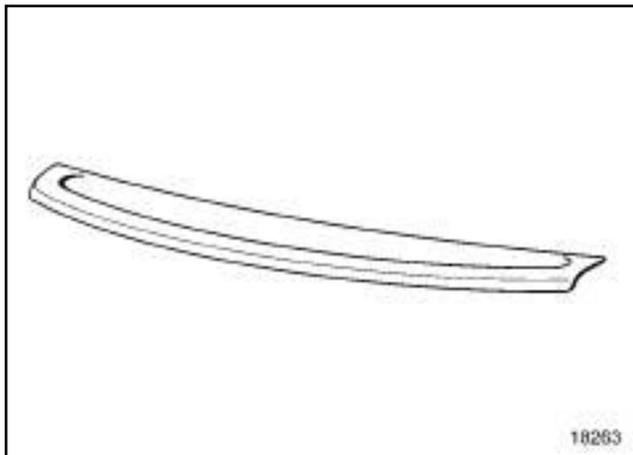
102528

- As for the removal operation, prepare the tool, screw it completely into the beam nut then lock the tool body (2) against the beam nut.
- Simultaneously screw the rod (1) and the body (2) of the tool as far as the stop, tightening gently.
- Hold the body (2) of the tool and unscrew the rod (1) in the same way as a lock nut and then remove the tool.

WARNING

When removing the dashboard cross member, it is possible that the lock nuts may cause the two sides to become incorrectly adjusted. In this case, refit the dashboard to adjust the clearances with the windscreen pillar trim and the door trim.

USING THE DASHBOARD PROTECTION TOOL Car. 1764

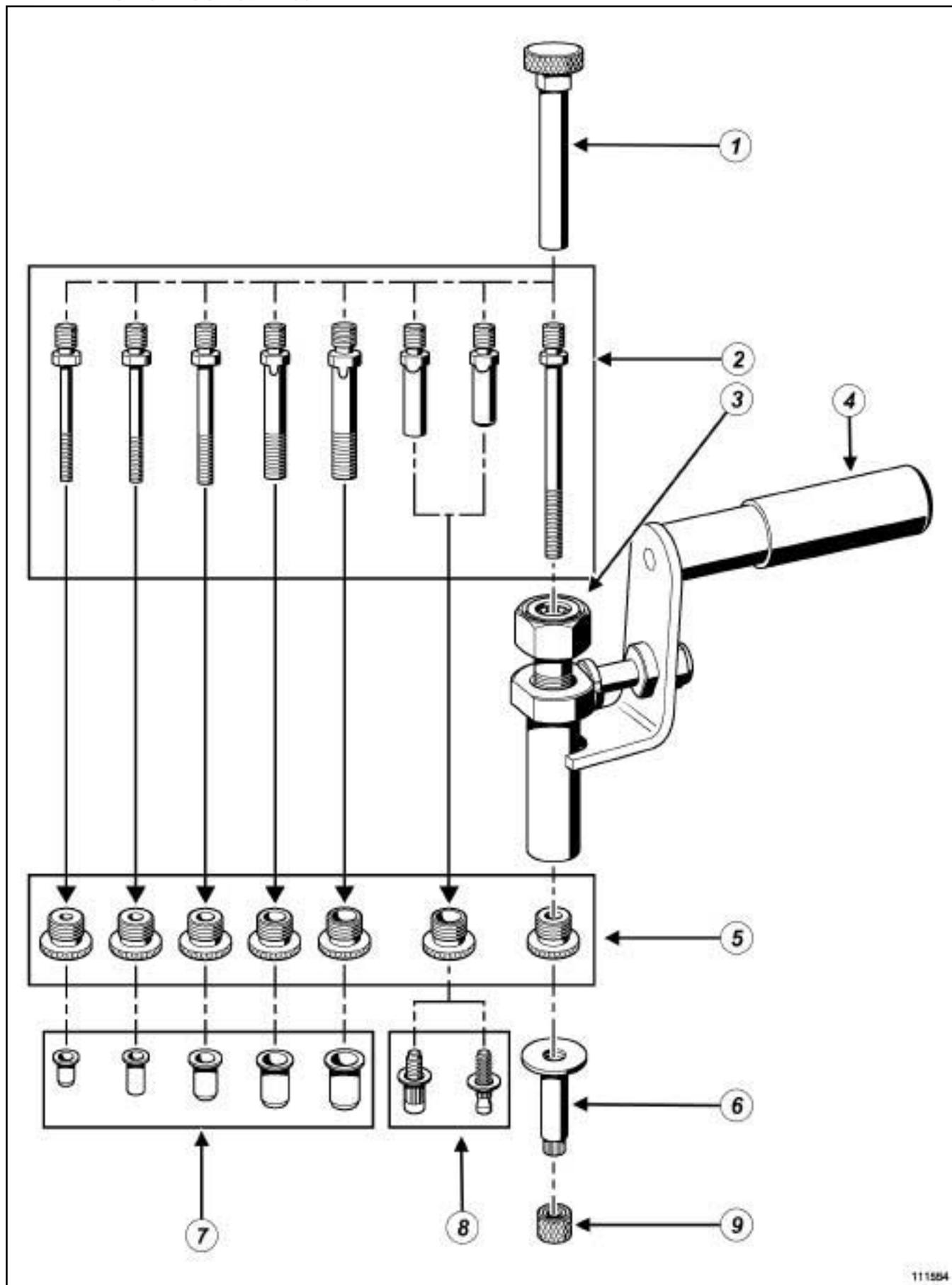


18263

- Use this tool when replacing the windscreen:
 - remove the A-pillar trims,
 - position the dashboard protector to prevent damage.

B84 or C84

PREPARATION OF TOOL Car. 1504



111554

B84 or C84

111554

□ (1) Mandrel mounting

- (2) Mandrels
- (3) Tightening bolt
- (4) Body
- (5) Anvils
- (6) Special nut
- (7) Nuts
- (8) Studs
- (9) Thrust nut

- Select the mandrel, anvil and insert assembly adapted to the crimping operation to be carried out.

- Into the mandrel mounting: (1) screw the mandrel (2) (left-hand thread).

- Tighten the bolt (3) onto the body (4) until the stop (left-hand thread).

- Into the body: (4) screw the anvil (5) (left-hand thread).

- Fit the assembly (1) and (2) into the body of the tool.

- Screw the insert (left-hand thread) onto the pull rod.

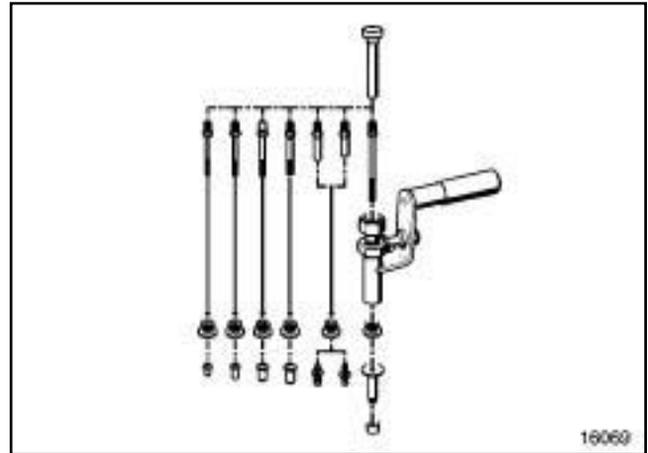
To fit the special nut (6) , position the mandrel across the crimped nut and tighten it onto the thrust nut (9) .

WARNING

Each time a panel is stripped in the workshop (e.g. when drilling), degrease and wipe the area and then use a fine brush to apply the following:

- a pre-treatment primer,
- a two-part primer,
- paint in the vehicle body colour.

USING TOOL CAR. 1504



16069

- Turn the bolt using a 24 spanner, holding the tool handle manually.

WARNING

Completion of the crimping operation should be felt by the operator (increase in the tightening effort). Crimping of the insert is correct when it no longer has any rotational play; this should be checked before removing the pull rod - mandrel assembly.

GENERAL VEHICLE INFORMATION

Sub-frame: Specifications

40A

B84 or C84

	DESCRIPTION	DIMEN- SION X	DIMEN- SION Y	DIMEN- SION Z	DIAMETER (in mm)	ANGLE (in degrees)
A	Front sub-frame rear mounting without mechanical components	301	305	77.8	∅ 24.5; M12	0
	Front sub-frame rear mounting with mechanical components	301	305	6.5	M12	0
B	Rear axle leader pin without mechanical components	2148.2	- 650.8	116	∅ 20.5; M10	0
B1	Rear axle assembly front moun- ting without mechanical compo- nents	2040	-635	116	M10	0
	Rear axle assembly front moun- ting with mechanical components	2040	-635	111	M10	0
B2	Rear axle assembly front moun- ting without mechanical compo- nents	2131	-732.2	116	M10	0
	Rear axle assembly front moun- ting with mechanical components	2131	-732.2	111	M10	0
C	Front sub-frame front mounting	-141.5	-478	252	M10	0
C*	Front sub-frame front mounting	141.4	477.9	261	M12	0
E	Rear shock absorber upper moun- ting	2435	-398	262.5	∅ 10.7; M10	90
F1	Front shock absorber upper stop	-55.1	- 602.1	687.3	M8	
F1*	Front shock absorber upper stop	82.7	601.8	670.4	M8	
F2	Front shock absorber upper stop	50.7	-529.9	672.4	M8	
F2*	Front shock absorber upper stop	-24	530.1	681.4	M8	
F3	Front shock absorber upper stop	73.3	-631.8	672.2	M8	
F3*	Front shock absorber upper stop	-45.4	632.1	686.8	M8	
F4	Front shock absorber mounting leader pin	81.4	-598.2	670.4	17.2 x 17.2	
F4*	Front shock absorber mounting leader pin	-53.9	597.9	687.2	17.2 x 17.2	
G	Front side member rear leader pin	547	-408.6	-9.8	∅ 20.5	0
H	Front side member front leader pin, without mechanical compo- nents	-525	-476	84.5	M12	0

GENERAL VEHICLE INFORMATION

Sub-frame: Specifications

40A

B84 or C84

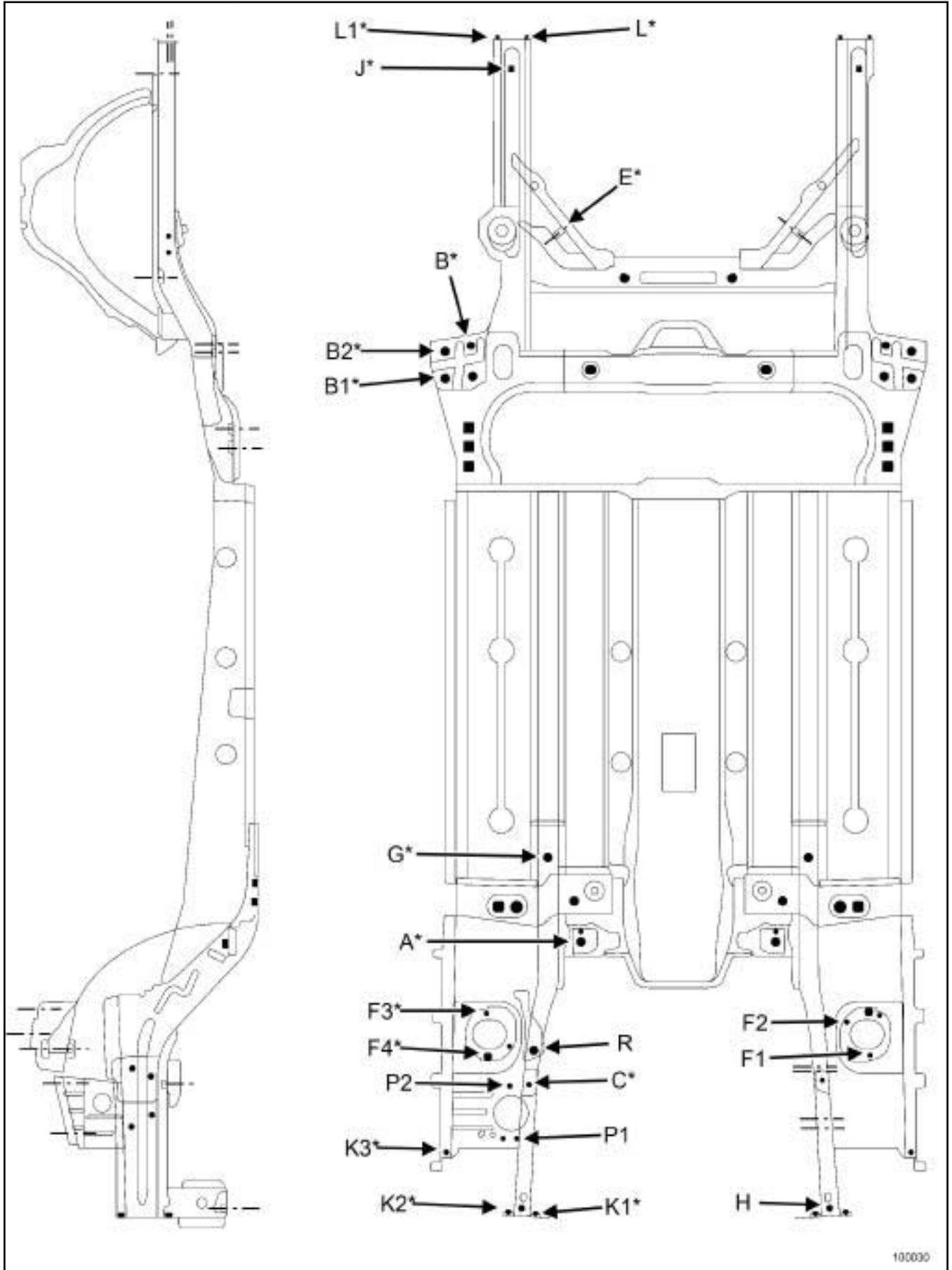
	DESCRIPTION	DIMEN- SION X	DIMEN- SION Y	DIMEN- SION Z	DIAMETER (in mm)	ANGLE (in degrees)
	Front side member front leader pin, with mechanical components	-525	-476	80.7	M12	0
H*	Front side member front leader pin, without mechanical components	-525	492	84	M12	0
	Front side member front leader pin, with mechanical components	-525	492	80.2	M12	0
J	Rear side member rear leader pin	3005	-563.5	235	20x20	0
J*	Rear side member rear leader pin	3005	-523.5	235	20x20	0
K1	Front end cross member	-552.9	-439.3	410.9	M10	90
K1*	Front end cross member	-552.2	447.6	409	M10	90
K2	Front end cross member	-546.2	-535.1	276	M10	90
K2*	Front end cross member	-546.3	-533.6	276	M10	90
K3	Front panel support additional mounting	-312.9	-737	634.5	M6	9.64
L	Rear end cross member	3096.7	-515	315	M8	90
L*	Rear end cross member	3096.7	572.2	315	M8	90
L1	Rear end cross member	3096.7	-612.5	217.5	M8	90
L1*	Rear end cross member	3096.7	474.7	217.5	M8	90
P1	Engine mounting	-309.2	507	528.9	M10	0
P2	Engine mounting	-149.2	529	531.9	M10	0
R	Additional engine mounting (tie-rod)	-35.6	452.6	587	∅ 14.5; M12	0

Note:

The reference points located on the right-hand side of the vehicle are shown by an asterisk.

B84 or C84

A and B = vehicle trim height reference



GENERAL VEHICLE INFORMATION

Sub-frame: Specifications

40A

B84 or C84

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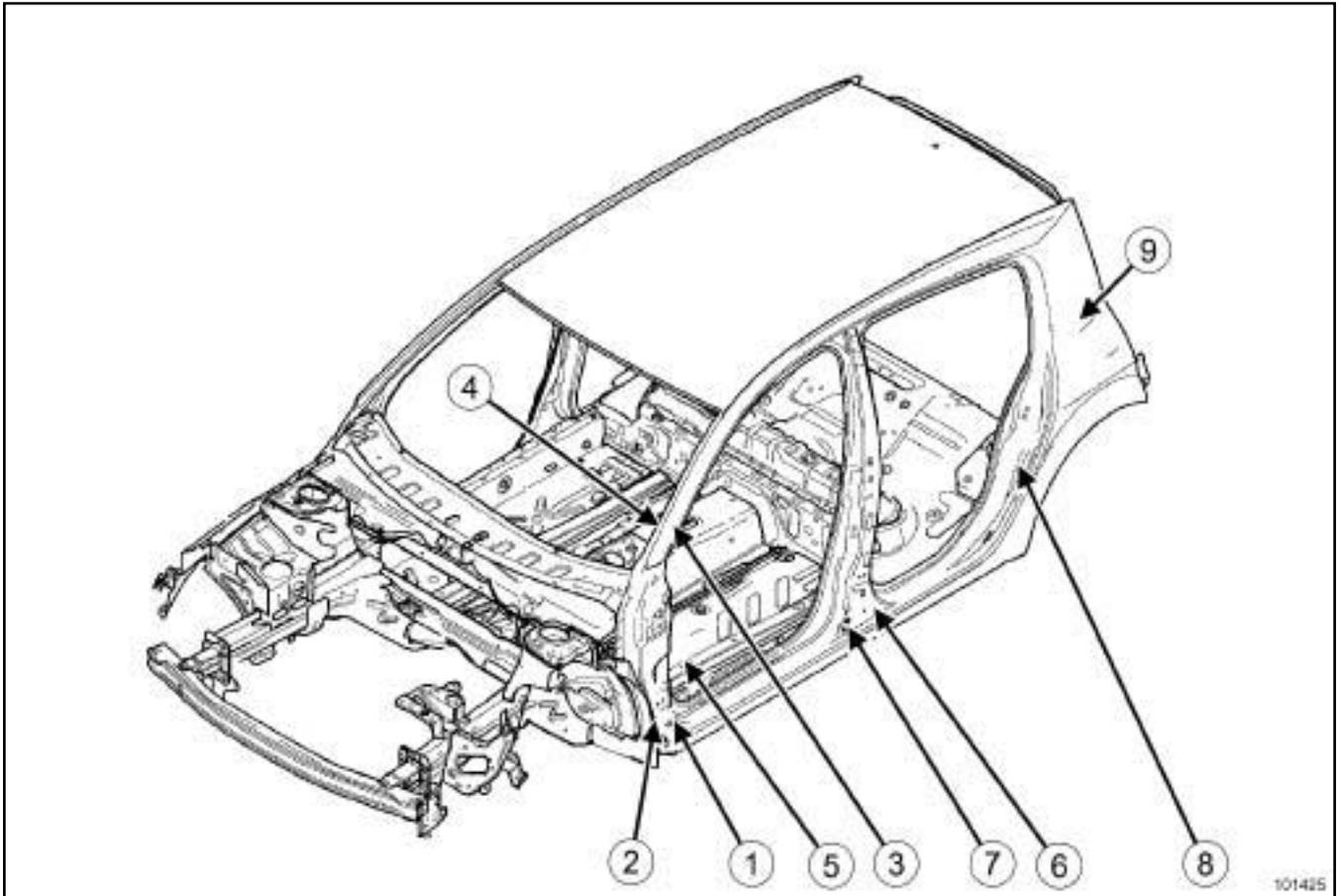
GENERAL VEHICLE INFORMATION

Hollow body parts inserts: List and location of components

40A

B84 or C84

B84



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101425

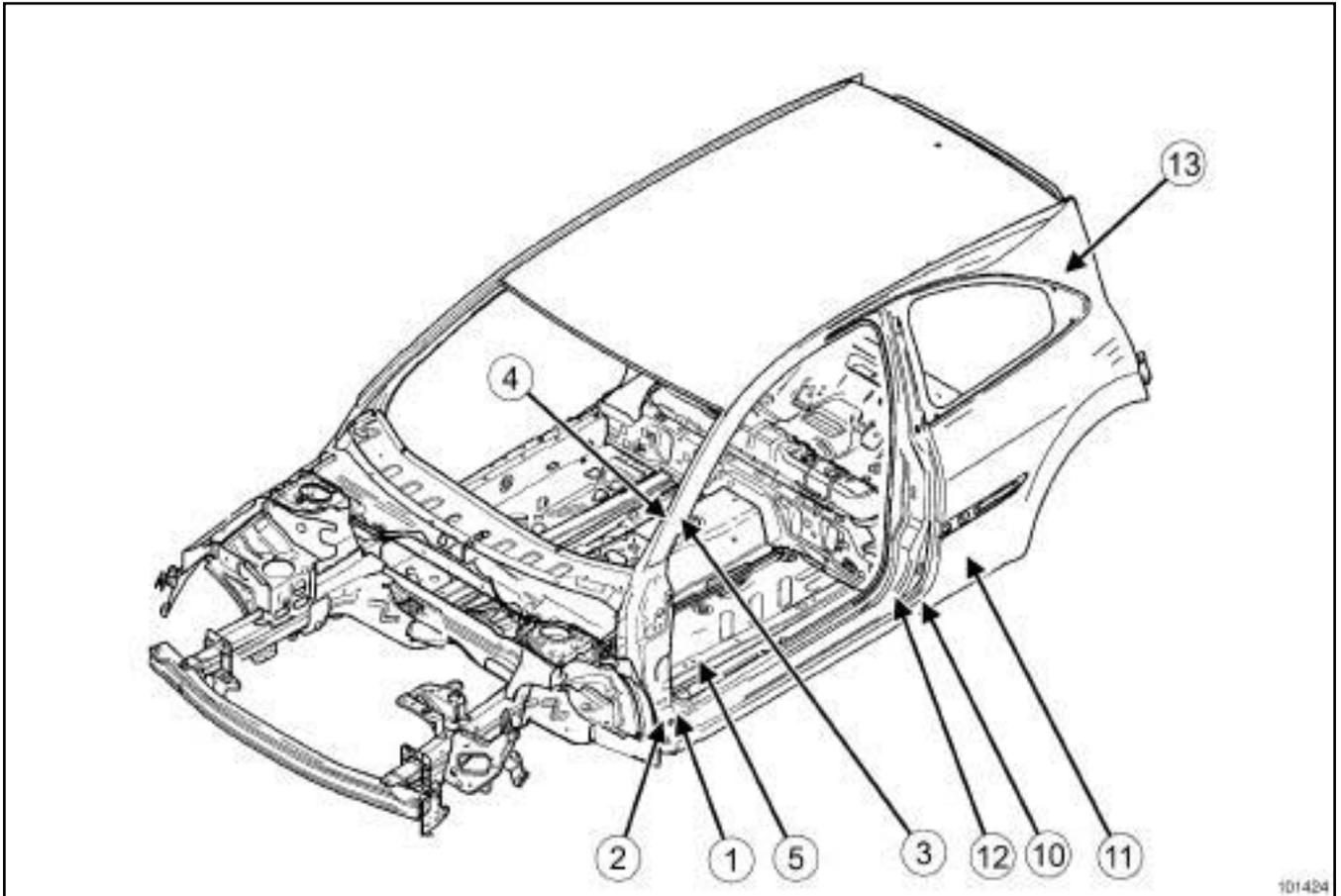
GENERAL VEHICLE INFORMATION

Hollow body parts inserts: List and location of components

40A

B84 or C84

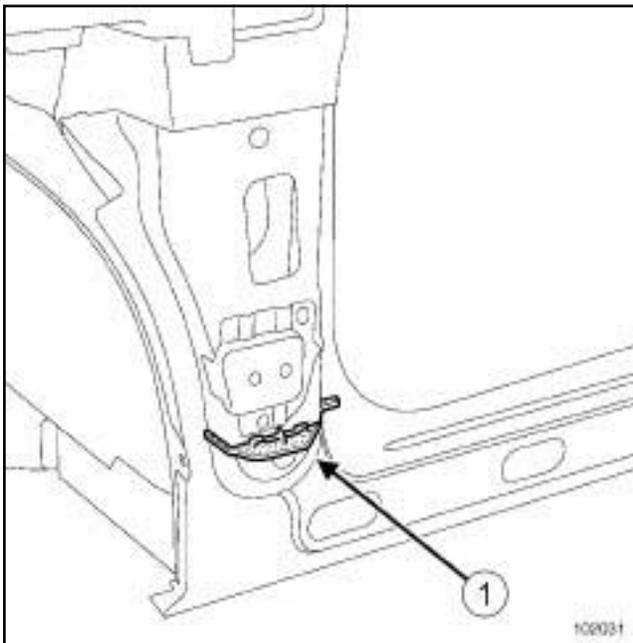
C84



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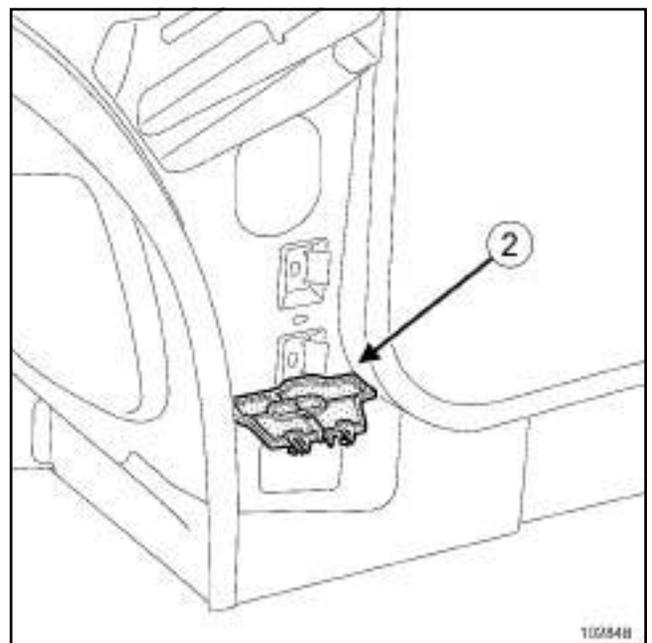
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A-pillar insert (1) .



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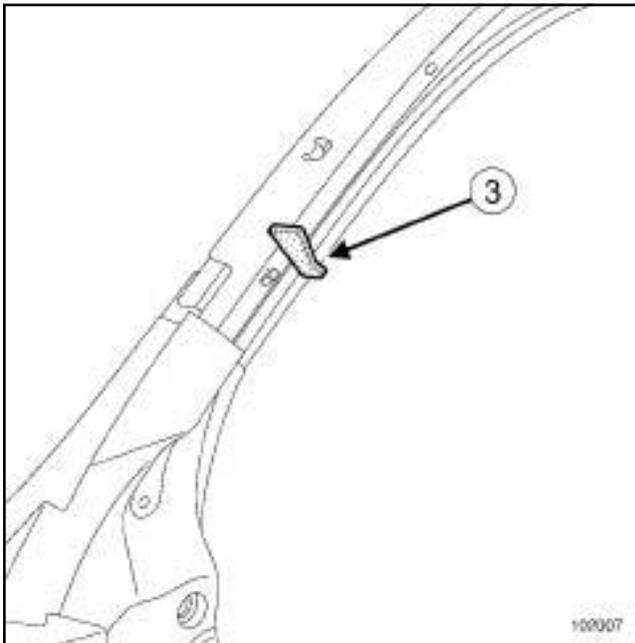


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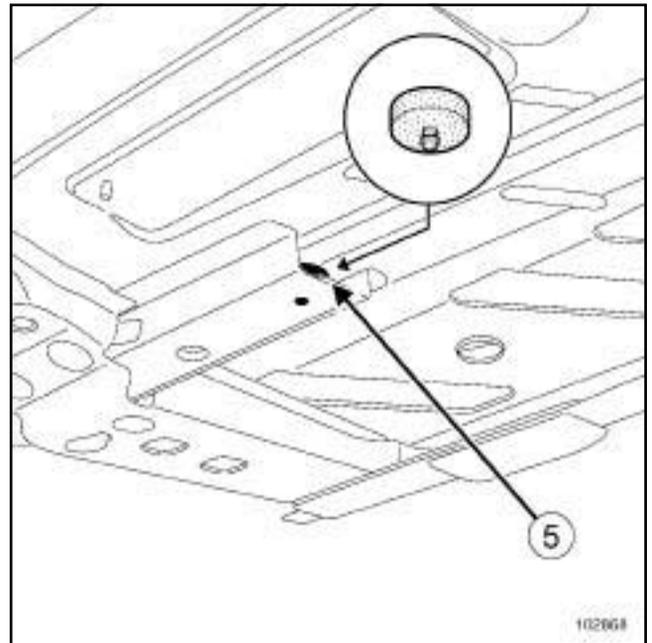
A-pillar reinforcement insert (2) .

B84 or C84



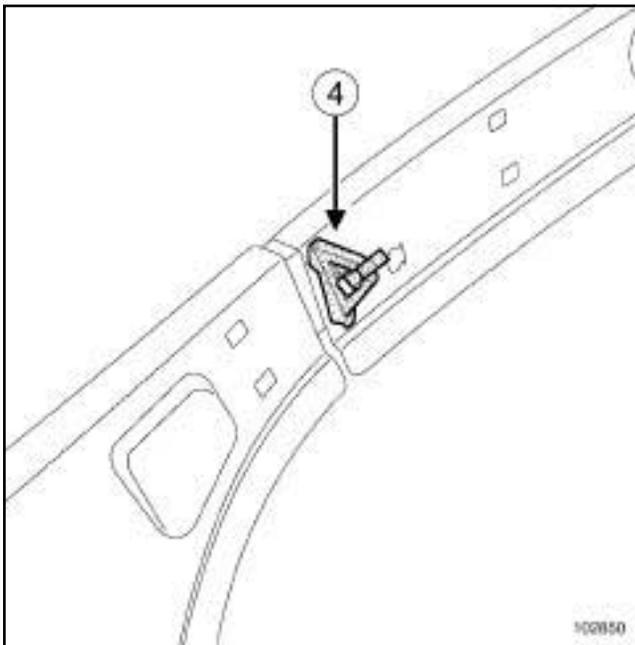
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A-pillar insert (3) .



102868

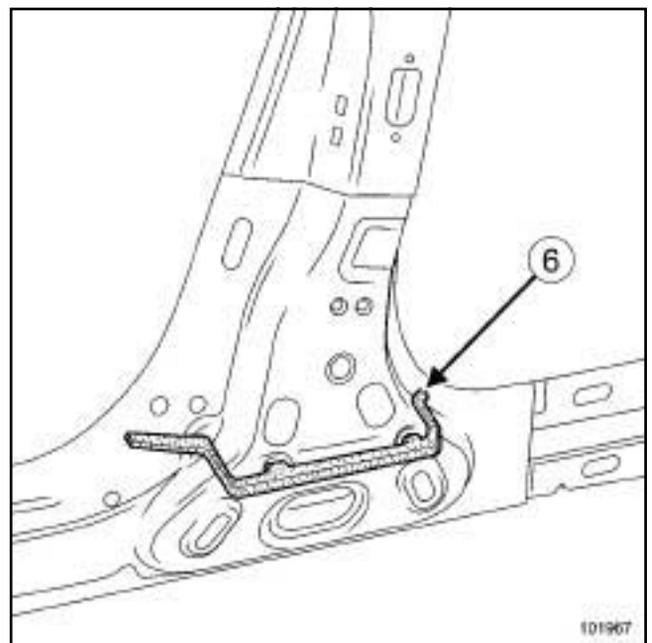
Front side member rear insert (5) .



102850

A-pillar lining insert (4) .

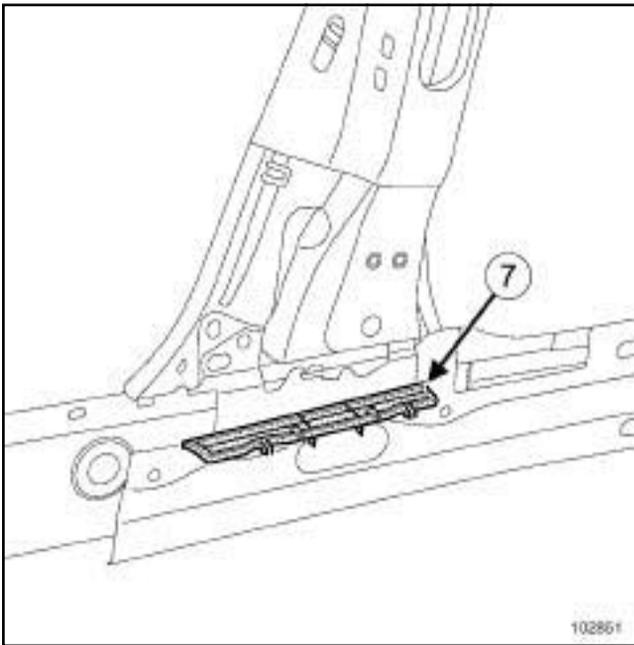
B84



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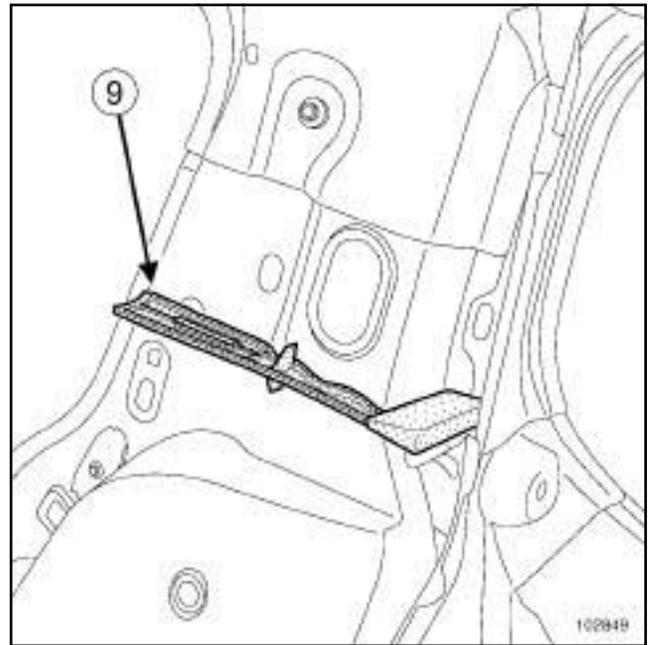
B-pillar insert (6) .

B84 or C84



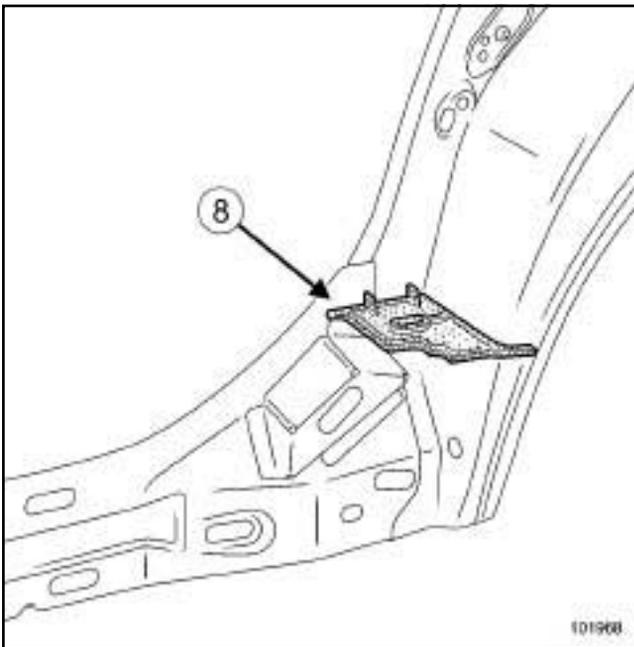
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B-pillar reinforcement insert (7) .



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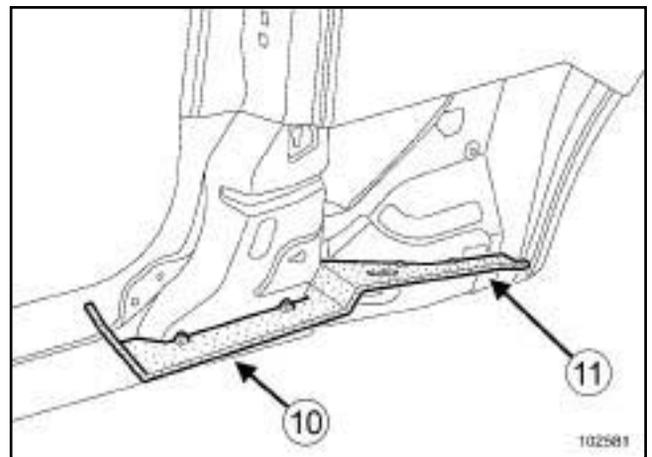
Rear wing panel upper insert (9) .



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Rear wing panel lower insert (8) .

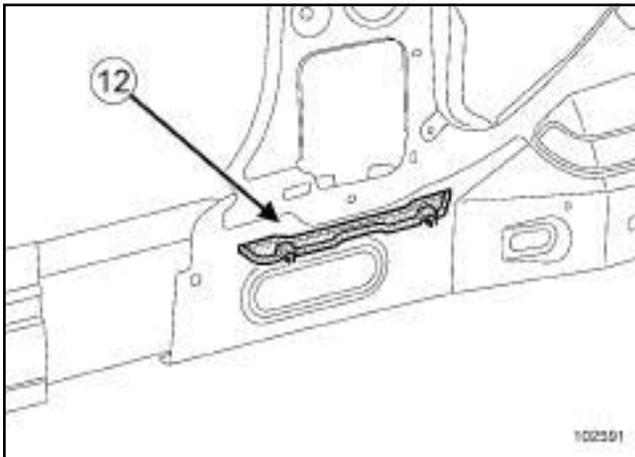
C84



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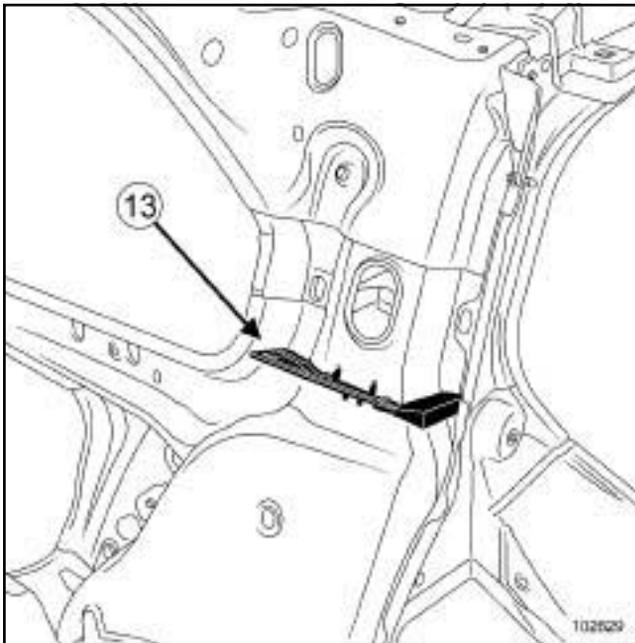
Sill panel rear insert (10) , (11) .

B84 or C84



102591

Sill panel reinforcement insert (12) .



102629

Rear wing panel upper insert (13) .

Hollow body parts inserts: Precautions for repair

B84 or C84

The expanding inserts ensure that the vehicle cavities are sealed and soundproofed. They react to the temperature when the bodywork is immersed in the cataphoretic bath at the factory. These conditions cannot be reproduced on the bodywork.

As inserts are not recoverable, always replace expanding inserts.

The inserts supplied by the **Parts Department** are identical to the original parts.

To obtain the same sealing and soundproofing properties, carry out the following operations:

- clean the bonding surfaces with heptane.
- if necessary, seal the holes in the insert using pieces cut from a soundproofing pad.
- apply a bead of preformed trim sealing mastic around and inside the insert holes.
- fit the insert by compressing the mastic.

WARNING

Do not refit the part after compressing the bead.

When MIG welding, protect the inserts from spatter and heat dispersion.

For example, use a heat shield.

In some cases, it is possible to replace the accessible part of the insert only, which must be cut out of the replacement part.

Earths on the body: List and location of components

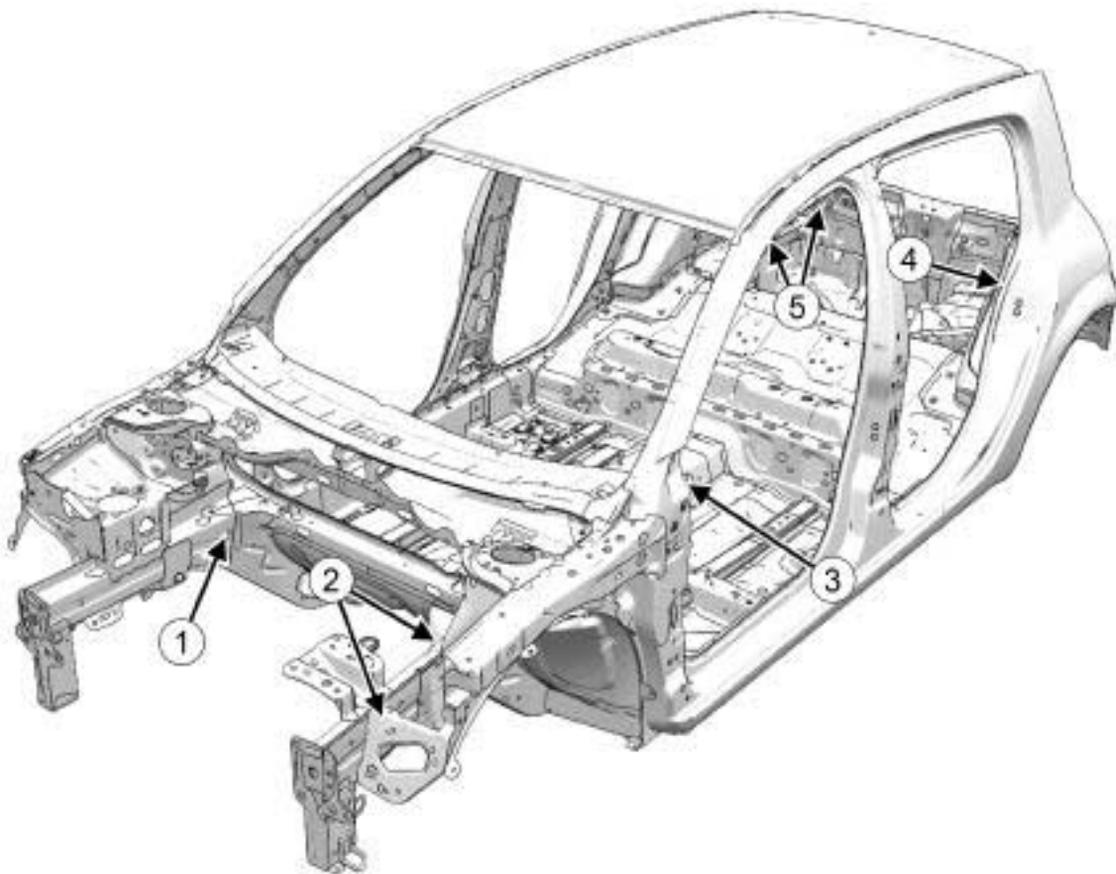
B84 or C84

IMPORTANT

To avoid damaging the vehicle's electric and electronic components, the battery and the earths of any wiring harness near the weld area must be disconnected.

The earth of the welding machine must be placed as close as possible to the weld area.

For the replacement procedure for earth studs, see **MR 400, 40A, General information, Electrical earth screw connections** .



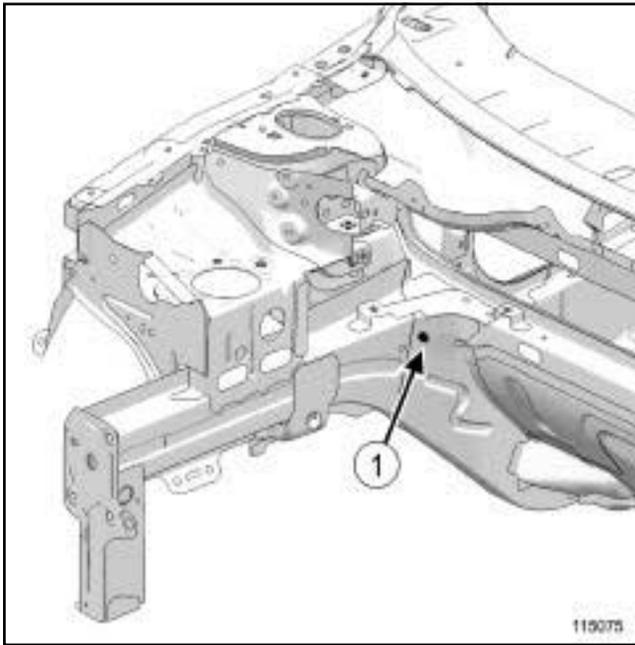
115071

115071

Earths on the body: List and location of components

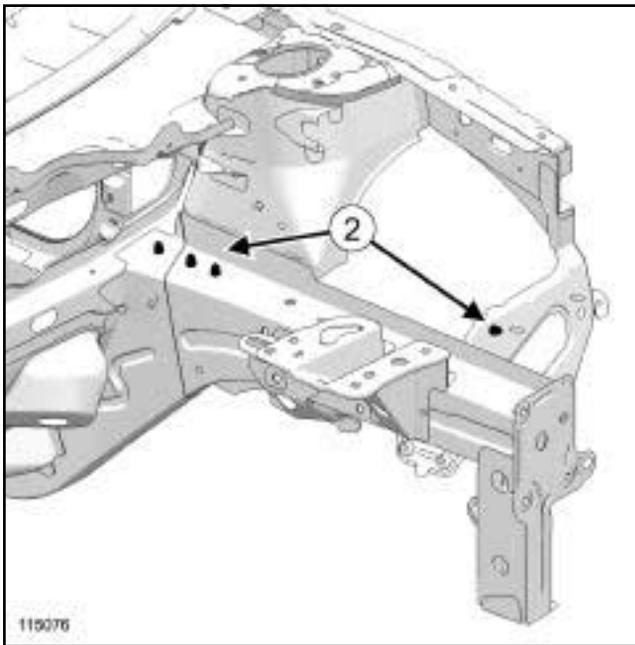
B84 or C84

DETAILED VIEW OF THE POSITION OF EARTHS ON THE VEHICLE



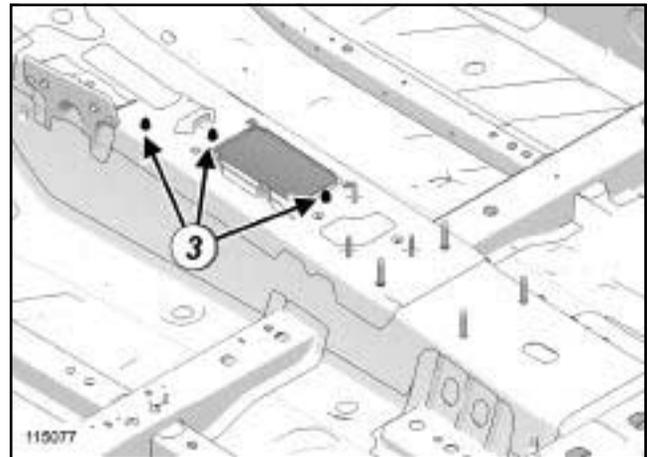
115075

Earth studs (1) on the front right-hand side member.



115076

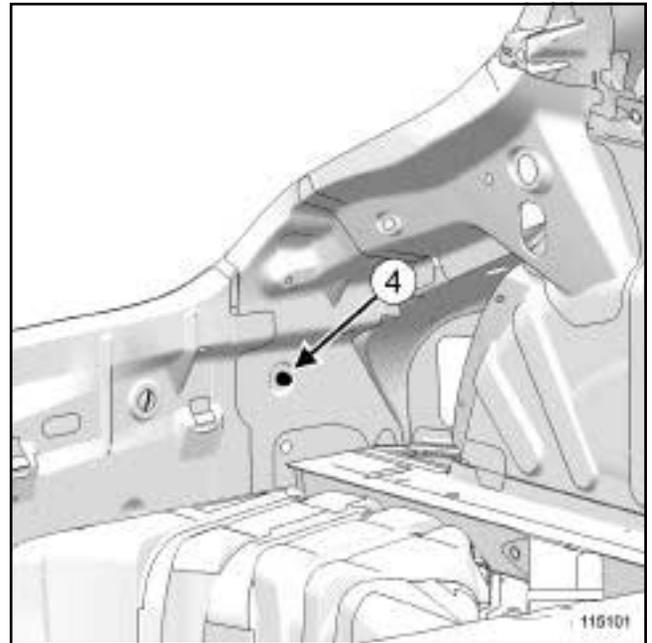
Earth studs (2) on the front left-hand side member and on the front end side cross member.



115077

Earth studs (3) on the tunnel.

Left-hand side



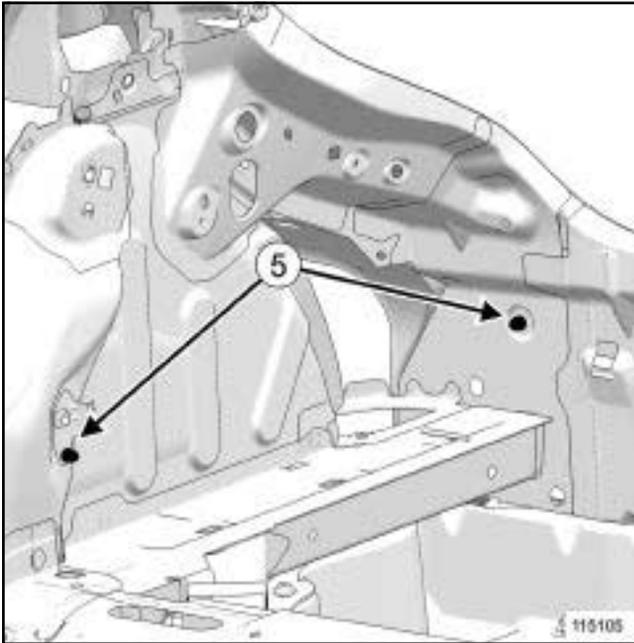
115101

Earths studs (4) on the rear end panel side lining.

Earths on the body: List and location of components

B84 or C84

Right-hand side



115105

Earth studs (5) on the rear end panel side lining and on the inner wheel arch.

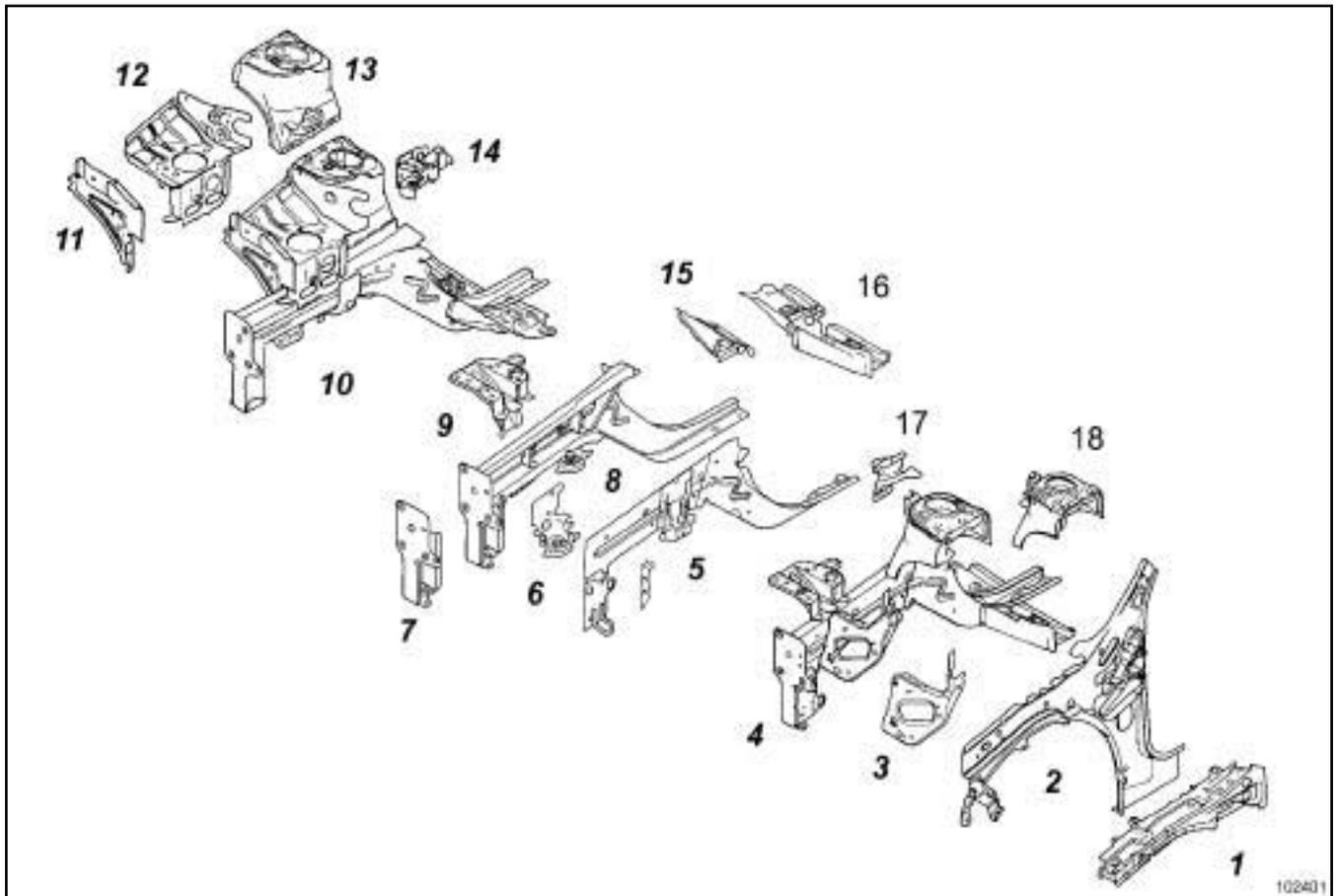
GENERAL VEHICLE INFORMATION

Vehicle front section structure: Description

40A

B84 or C84

FRONT STRUCTURE



102401

102401

Mark	Description	Classification	Type	Thickness (mm)
(1)	Scuttle side panel upper reinforcement	(see 42A, Upper front structure, Scuttle side panel upper reinforcement: Description, page 42A-32)	-	0.9
(2)	Scuttle side panel	(see 42A, Upper front structure, Cowl side panel: Description, page 42A-28)	HLE/ THLE	1/2.5
(3)	Front end side cross member	(see Front end side cross member: Description)	-	1.2
(4)	Left-hand front half unit	(see 41A, Front lower structure, Front half unit: Description, page 41A-39)	HLE/ THLE	1.1/3
(5)	Front section of front side member closure panel	(see 41A, Front lower structure, Front section of front side member closure panel: Description, page 41A-23)	HLE/ THLE	1.7/3

GENERAL VEHICLE INFORMATION

Vehicle front section structure: Description

40A

B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(6)	Front mounting of front sub-frame	(see 41A, Front lower structure, Front mounting of front sub-frame: Description, page 41A-32)	HLE	1.2
(7)	Radiator cross member support	(see 41A, Front lower structure, Radiator cross member support: Description, page 41A-29)	-	1.2/2.5
(8)	Front side member	(see 41A, Front lower structure, Front side member: Description, page 41A-17)	HLE/ THLE	1.2/3
(9)	Battery tray bracket	(see 41A, Front lower structure, Battery tray support: Description, page 41A-27)	-	1.5/2
(10)	Right-hand front half unit	(see 41A, Front lower structure, Front half unit: Description, page 41A-39)	HLE/ THLE	1.1/3
(11)	Front end side cross member	(see Front end side cross member: Description)	-	1.2
(12)	Engine stand	(see 41A, Front lower structure, Engine mounting: Description, page 41A-34)	HLE	1.5/2
(13)	Wheel arch	(see 42A, Upper front structure, Front wheel arch: Description, page 42A-35)	-	1.1/2
(14)	Engine tie-bar mounting		HLE	1
(15)	Sub-frame rear mounting	(see Sub-frame rear mounting: Description)	HLE/ THLE	2/3
(16)	Centre floor front side cross member	(see 41B, Centre lower structure, Centre floor front lateral cross member: Description, page 41B-18)	HLE/ THLE	1.2/3
(17)	Connecting bracket			
(18)	Front wheel arch	(see 42A, Upper front structure, Front wheel arch: Description, page 42A-35)	HLE	1.1/2

GENERAL VEHICLE INFORMATION

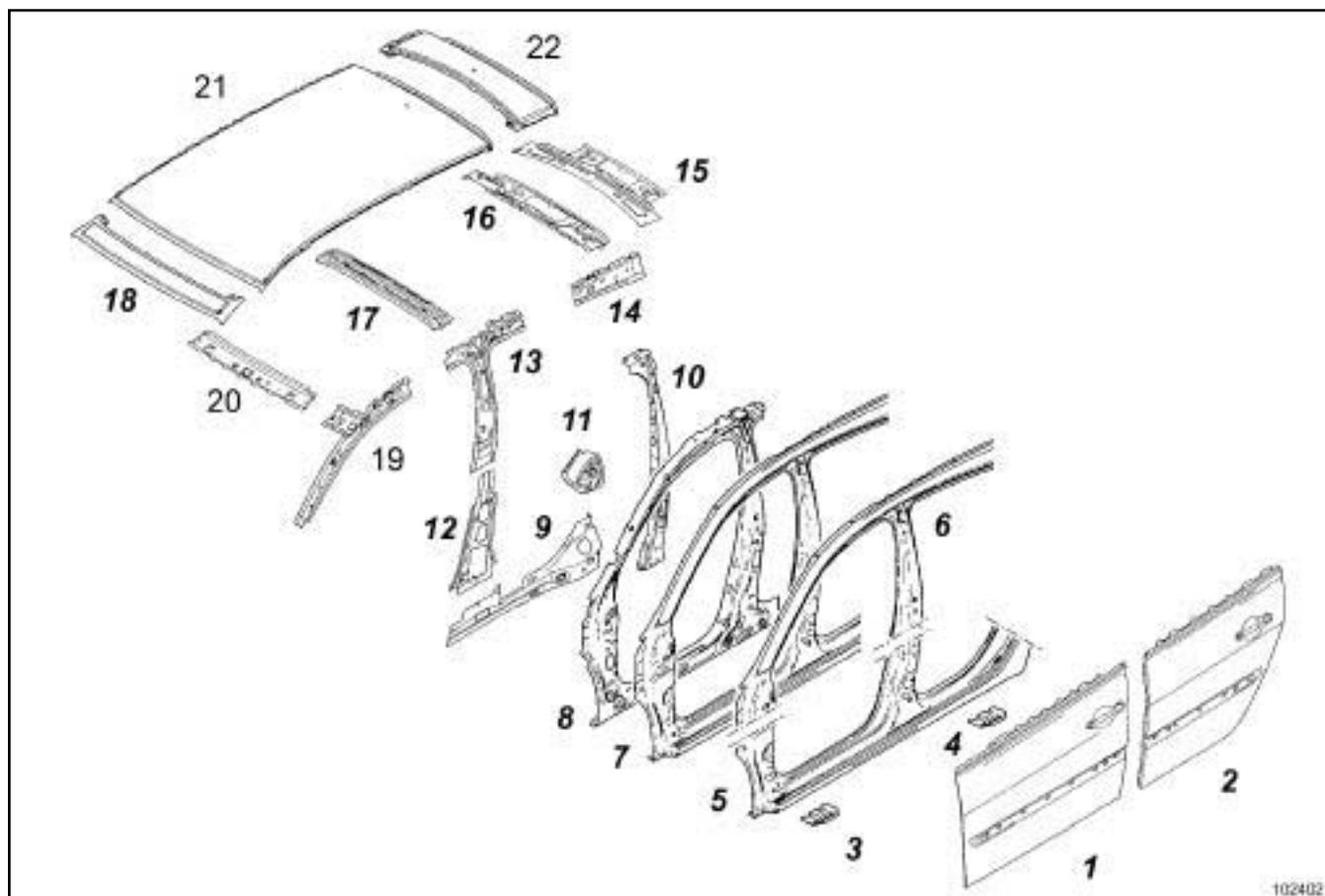
Vehicle side section structure: Description

40A

B84 or C84

SIDE STRUCTURE

B84



102402

Mark	Description	Classification	Type	Thickness (mm)
(1)	Front side door panel	(see Front side door panel: Description)	HLE	0.7/0.95
(2)	Rear side door panel	(see Rear side door panel: Description)	HLE	0.7/0.95
(3)	Front jack support	(see Front jacking point: Description)	HLE	1.8
(4)	Rear jack support	(see Front jacking point: Description)	HLE	1.8
(5)	Sill panel	(see 41C, Side lower structure, Sill panel: Description, page 41C-9)	-	0.7
(6)	Upper body	(see 43A, Side upper structure, Upper body panel: Description, page 43A-47)	-	0.7

GENERAL VEHICLE INFORMATION

Vehicle side section structure: Description

40A

B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(7)	Body side front section	(see 43A, Side upper structure, Body side front section: Description, page 43A-39)	-	0.7
(8)	Body side front section reinforcement	(see 43A, Side upper structure, Body side front section reinforcement: Description, page 43A-42)	HLE	1.2/1.5
(9)	Rear inner sill panel	(see 41C, Side lower structure, Rear inner sill panel: Description, page 41C-23)	HLE	1
(10)	B-pillar reinforcement stiffener	(see B-pillar reinforcement stiffener: Description)	HLE	1.5/2.2
(11)	Anti-intrusion reinforcement			
(12)	B-pillar lower lining	(see B-pillar lower lining: Description)	-	0.7
(13)	B-pillar upper lining	(see B-pillar upper lining: Description)	HLE	1.5
(14)	Rear roof drip moulding lining	(see Roof drip moulding lining: Description)	-	1
(15)	Roof rear cross member with sunroof	(see 45A, Top of body, Roof rear cross member: Description, page 45A-16)	HLE	0.7/0.9
(16)	Roof rear cross member without sunroof	(see 45A, Top of body, Roof rear cross member: Description, page 45A-16)	HLE	0.7/0.9
(17)	Roof middle cross member	(see 45A, Top of body, Roof centre cross member: Description, page 45A-14)	HLE	1.5
(18)	Front section of roof	(see 45A, Top of body, Roof front section: Description, page 45A-9)	-	0.7
(19)	A-pillar lining	(see 43A, Side upper structure, Windscreen pillar lining: Description, page 43A-16)	HLE	1.5/2
(20)	Roof front cross member	(see 45A, Top of body, Roof front cross member: Description, page 45A-12)	HLE	0.7

GENERAL VEHICLE INFORMATION

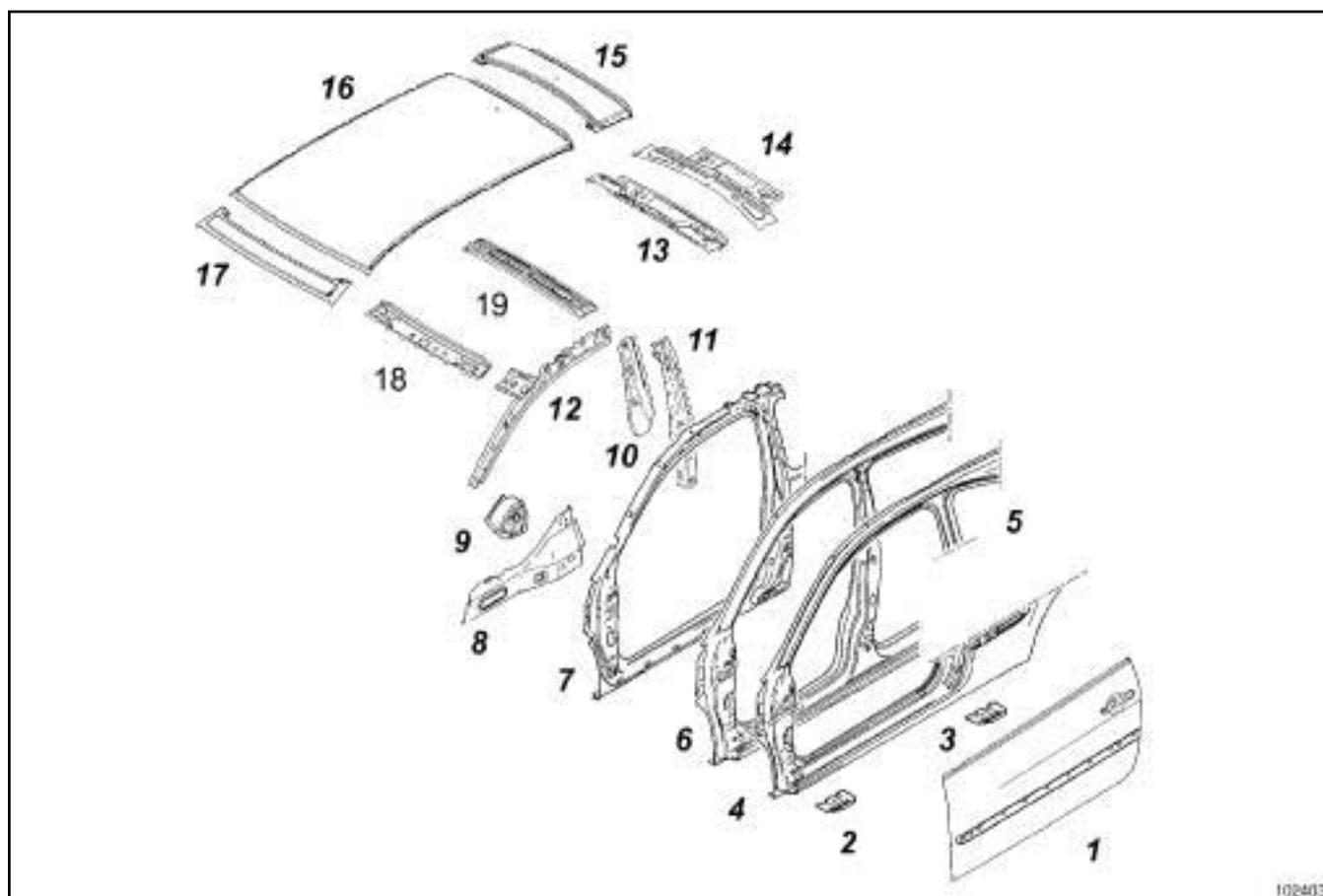
Vehicle side section structure: Description

40A

B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(21)	Roof	(see 45A, Top of body, Roof: Description, page 45A-7)	-	0.7
(22)	Rear section of roof	(see 45A, Top of body, Roof rear section: Description, page 45A-10)	-	0.7

C84



102403
102403

Mark	Description	Classification	Type	Thickness (mm)
(1)	Front side door panel	(see Front side door panel: Description)	HLE	0.7/0.95
(2)	Front jack support	(see Front jacking point: Description)	HLE	1.8
(3)	Rear jack support	(see Front jacking point: Description)	HLE	1.8

GENERAL VEHICLE INFORMATION

Vehicle side section structure: Description

40A

B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(4)	Sill panel	(see 41C, Side lower structure, Sill panel: Description, page 41C-9)	-	0.7
(5)	Upper body	(see 43A, Side upper structure, Upper body panel: Description, page 43A-47)	-	0.7
(6)	Body side front section	(see 43A, Side upper structure, Body side front section: Description, page 43A-39)	-	0.7
(7)	Body side front section reinforcement	(see 43A, Side upper structure, Body side front section reinforcement: Description, page 43A-42)	HLE	1.2/1.5
(8)	Rear inner sill panel	(see 41C, Side lower structure, Rear inner sill panel: Description, page 41C-23)	HLE	1
(9)	Anti-intrusion reinforcement			
(10)	Quarter panel front reinforcement		HLE	1.5
(11)	B-pillar reinforcement stiffener	(see B-pillar reinforcement stiffener: Description)	VHLE	1.8
(12)	A-pillar lining	(see 43A, Side upper structure, Windscreen pillar lining: Description, page 43A-16)	HLE	1.5/2
(13)	Roof rear cross member without sunroof	(see 45A, Top of body, Roof rear cross member: Description, page 45A-16)	HLE	0.7/0.9
(14)	Roof rear cross member with sunroof	(see 45A, Top of body, Roof rear cross member: Description, page 45A-16)	HLE	0.7/0.9
(15)	Rear section of roof	(see 45A, Top of body, Roof rear section: Description, page 45A-10)	-	0.7
(16)	Roof	(see 45A, Top of body, Roof: Description, page 45A-7)	-	0.7
(17)	Front section of roof	(see 45A, Top of body, Roof front section: Description, page 45A-9)	-	0.7

GENERAL VEHICLE INFORMATION
Vehicle side section structure: Description

40A

B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(18)	Roof front cross member	(see 45A, Top of body, Roof front cross member: Description, page 45A-12)	HLE	0.7
(19)	Roof middle cross member	(see 45A, Top of body, Roof centre cross member: Description, page 45A-14)	HLE	1.5



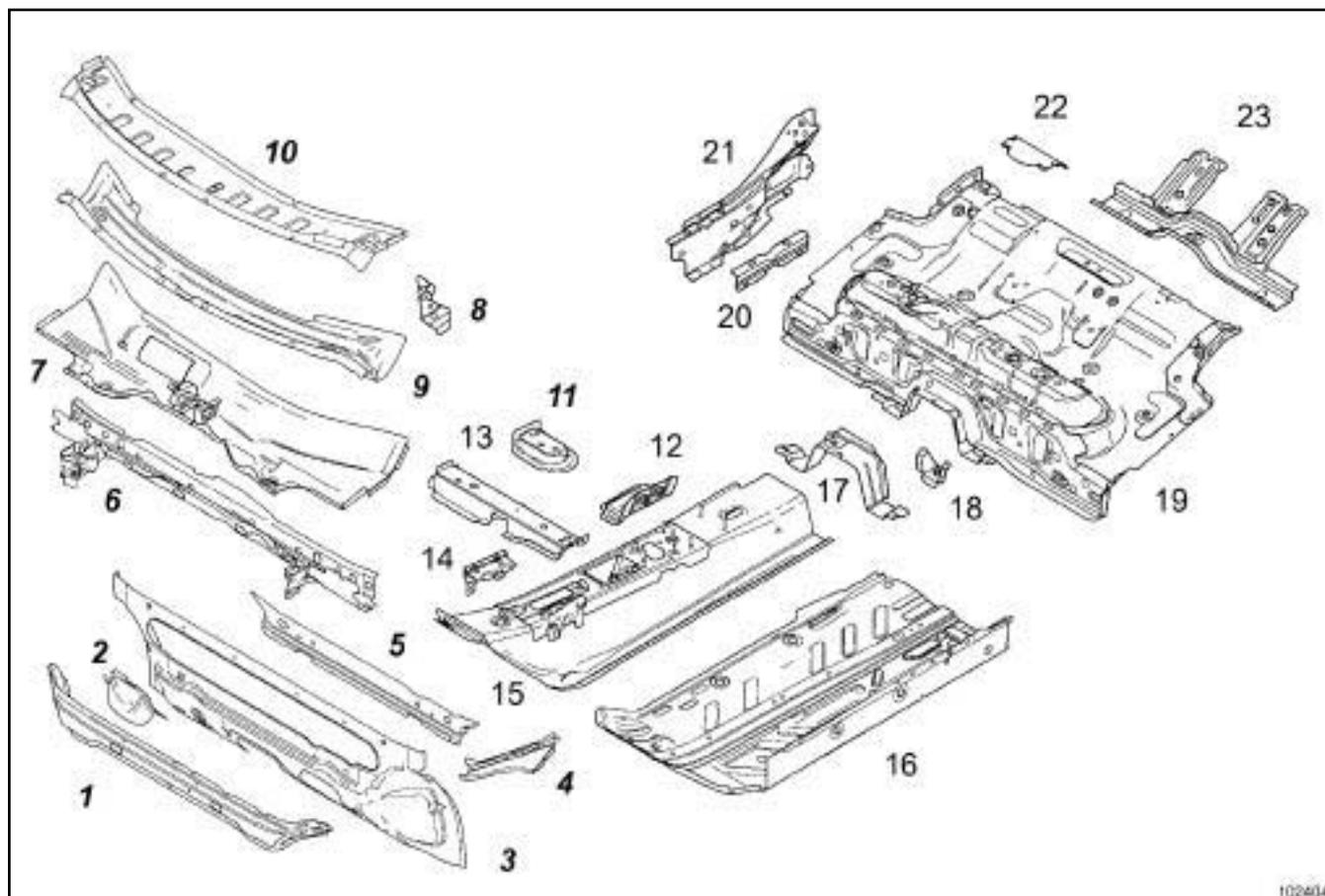
GENERAL VEHICLE INFORMATION

Vehicle central section structure: Description

40A

B84 or C84

CENTRAL STRUCTURE



102404
102404

Mark	Description	Classification	Type	Thickness (mm)
(1)	Bulkhead lower cross member	(see 42A, Upper front structure, Bulkhead lower cross member: Description, page 42A-53)	VHLE	2.5
(2)	Steering column unit		-	1.5
(3)	Bulkhead	(see 42A, Upper front structure, Bulkhead: Description, page 42A-49)	-	0.9
(4)	Bulkhead side reinforcement	(see 42A, Upper front structure, Bulkhead side stiffener: Description, page 42A-59)	UHLE	1.7
(5)	Bulkhead reinforcement	(see 42A, Upper front structure, Bulkhead reinforcement: Description, page 42A-51)	UHLE	1.7

GENERAL VEHICLE INFORMATION

Vehicle central section structure: Description

40A

B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(6)	Bulkhead upper cross member	(see 42A, Upper front structure, Bulkhead upper cross member: Description, page 42A-57)	HLE	0.95/3
(7)	Heater bulkhead	(see 42A, Upper front structure, Heater bulkhead: Description, page 42A-38)	-	0.7/1.2
(8)	Windscreen wiper mounting	(see 42A, Upper front structure, Windscreen wiper mounting: Description, page 42A-61)	-	1.2
(9)	Windscreen aperture lower cross member	(see 42A, Upper front structure, Windscreen aperture lower cross member: Description, page 42A-41)	-	0.7
(10)	Windscreen aperture lower cross member closure panel	(see 42A, Upper front structure, Windscreen aperture lower cross member closure panel: Description, page 42A-47)	-	0.65/1.2
(11)	Front seat mounting exterior unit	(see 41B, Centre lower structure, Front seat rear outer mounting unit: Description, page 41B-26)	HLE	1.5
(12)	Front seat mounting interior unit	(see 41B, Centre lower structure, Front seat rear mounting interior unit: Description, page 41B-25)	HLE	1.5/2.5
(13)	Front cross member under front seat	(see 41B, Centre lower structure, Front cross member under front seat: Description, page 41B-23)	HLE	1.5
(14)	Steering column mounting		-	1.3
(15)	Tunnel	(see 41B, Centre lower structure, Tunnel: Description, page 41B-20)	HLE/ THLE	1/1.6
(16)	Centre floor, side section	(see 41B, Centre lower structure, Central floor, side section: Description, page 41B-13)	VHLE	0.7/2.5
(17)	Exhaust mounting support	(see 41D, Rear lower structure, Exhaust mounting support: Description, page 41D-30)	-	1.2/2.5

GENERAL VEHICLE INFORMATION
Vehicle central section structure: Description

40A

B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(18)	Fuel tank mounting support	(see 41D, Rear lower structure, Tank mounting support: Description, page 41D-31)	-	1.2
(19)	Front section of rear floor	(see 41D, Rear lower structure, Rear floor, front section: Description, page 41D-10)	HLE/ THLE	0.7/2.5
(20)	Sill panel reinforcement stiffener		VHLE	1.8
(21)	Sill panel rear reinforcement	(see 41C, Side lower structure, Sill panel rear reinforcement: Description, page 41C-29)	HLE	1.4
(22)	Fuel gauge closure panel		HLE	0.8
(23)	Rear floor front cross member, centre section	(see 41D, Rear lower structure, Rear floor front cross member, centre section: Description, page 41D-25)	HLE	1.2/2

GENERAL VEHICLE INFORMATION

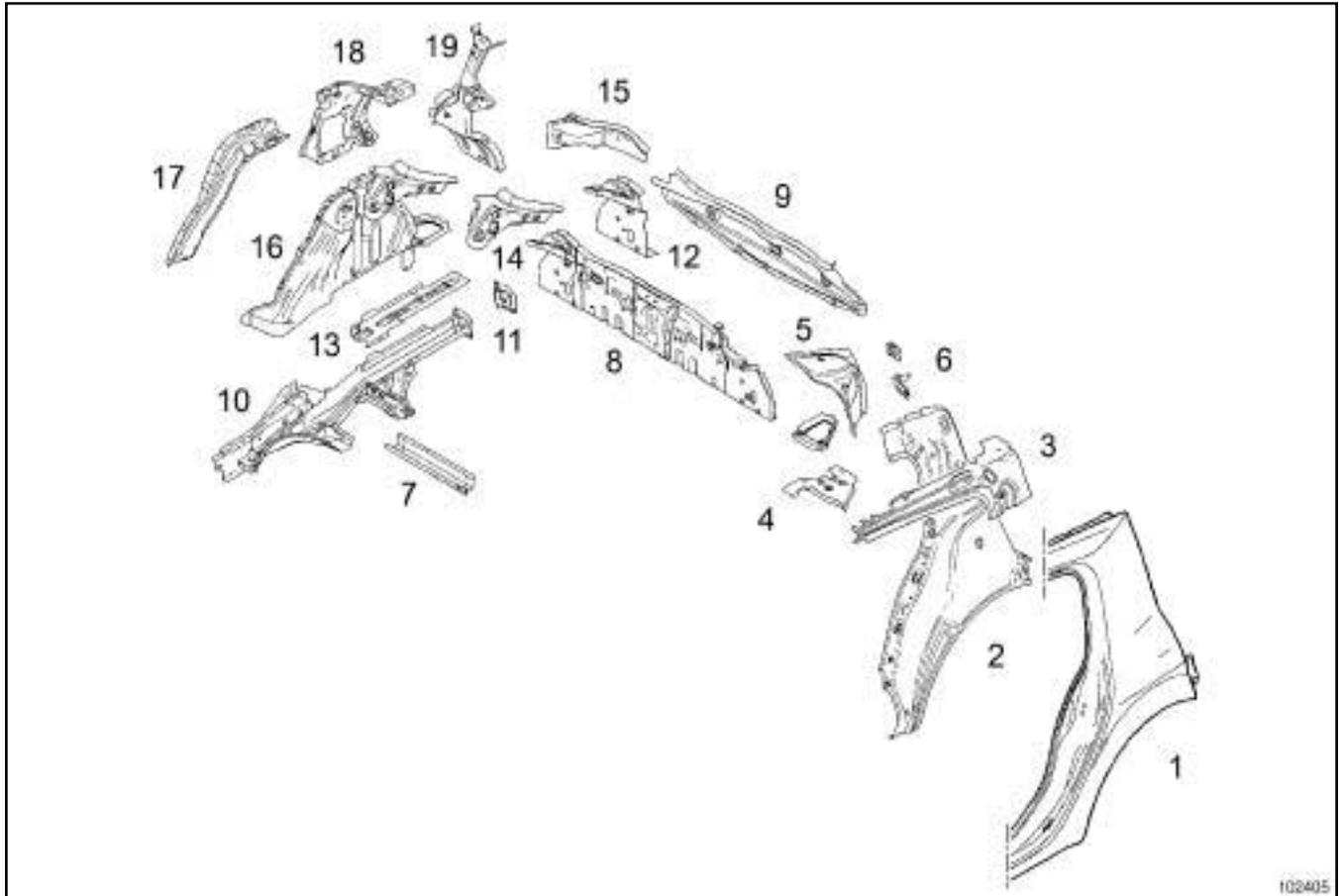
Vehicle structure rear section: Description

40A

B84 or C84

REAR STRUCTURE

B84



102405

102405

Mark	Description	Classification	Type	Thickness (mm)
(1)	Rear wing panel	(see 44A, Rear upper structure, Rear wing panel: Description, page 44A-7)	-	0.7
(2)	Quarter panel lining	(see 44A, Rear upper structure, Quarter panel lining: Description, page 44A-37)	-	0.6
(3)	Rear quarter upper reinforcement	(see 44A, Rear upper structure, Quarter panel upper reinforcement: Description, page 44A-40)	-	0.9
(4)	Far rear lower cross member, side section	(see 41D, Rear lower structure, Far rear lower cross member, side section: Description, page 41D-29)	-	0.95
(5)	Rear wheel arch extender	(see 44A, Rear upper structure, Rear wheel arch extension: Description, page 44A-33)	-	0.7
(6)	Tailgate stop mounting			

GENERAL VEHICLE INFORMATION

Vehicle structure rear section: Description

40A

B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(7)	Rear floor centre cross member	(see 41D, Rear lower structure, Rear floor centre cross member: Description, page 41D-28)	HLE	1/2.5
(8)	Rear end panel assembly	(see 44A, Rear upper structure, Rear end panel assembly: Description, page 44A-46)	HLE/THLE	0.65/2.5
(9)	Rear end panel	(see 44A, Rear upper structure, Rear end panel: Description, page 44A-49)	-	0.65
(10)	Rear side member	(see 41D, Rear lower structure, Rear side member: Description, page 41D-20)	HLE/THLE	0.95/2
(11)	Rear impact cross member mounting stiffener	(see Rear impact cross member mounting stiffener: Description)	HLE	2
(12)	Rear end panel side lining	(see 44A, Rear upper structure, Rear end panel side lining: Description, page 44A-51)	-	0.7
(13)	Rear side member closure panel, rear section	(see 41D, Rear lower structure, Rear side member closure panel, rear section: Description, page 41D-23)	-	0.7
(14)	Light mounting lining	(see 44A, Rear upper structure, Lights support lining: Description, page 44A-21)	HLE	0.95
(15)	Rear light mounting	(see 44A, Rear upper structure, Rear lights support: Description, page 44A-18)	-	0.9
(16)	Inner rear wheel arch	(see 44A, Rear upper structure, Inner wheel arch: Description, page 44A-29)	HLE	0.7/1.5
(17)	Rear wheel arch closure panel	(see 44A, Rear upper structure, Rear wheel arch closure panel: Description, page 44A-31)	-	0.7
(18)	Quarter panel stiffener	(see 44A, Rear upper structure, Quarter panel reinforcement: Description, page 44A-36)	-	0.9
(19)	Rear wing panel rain channel	(see 44A, Rear upper structure, Rear wing panel rain channel: Description, page 44A-15)	HLE	0.85/1



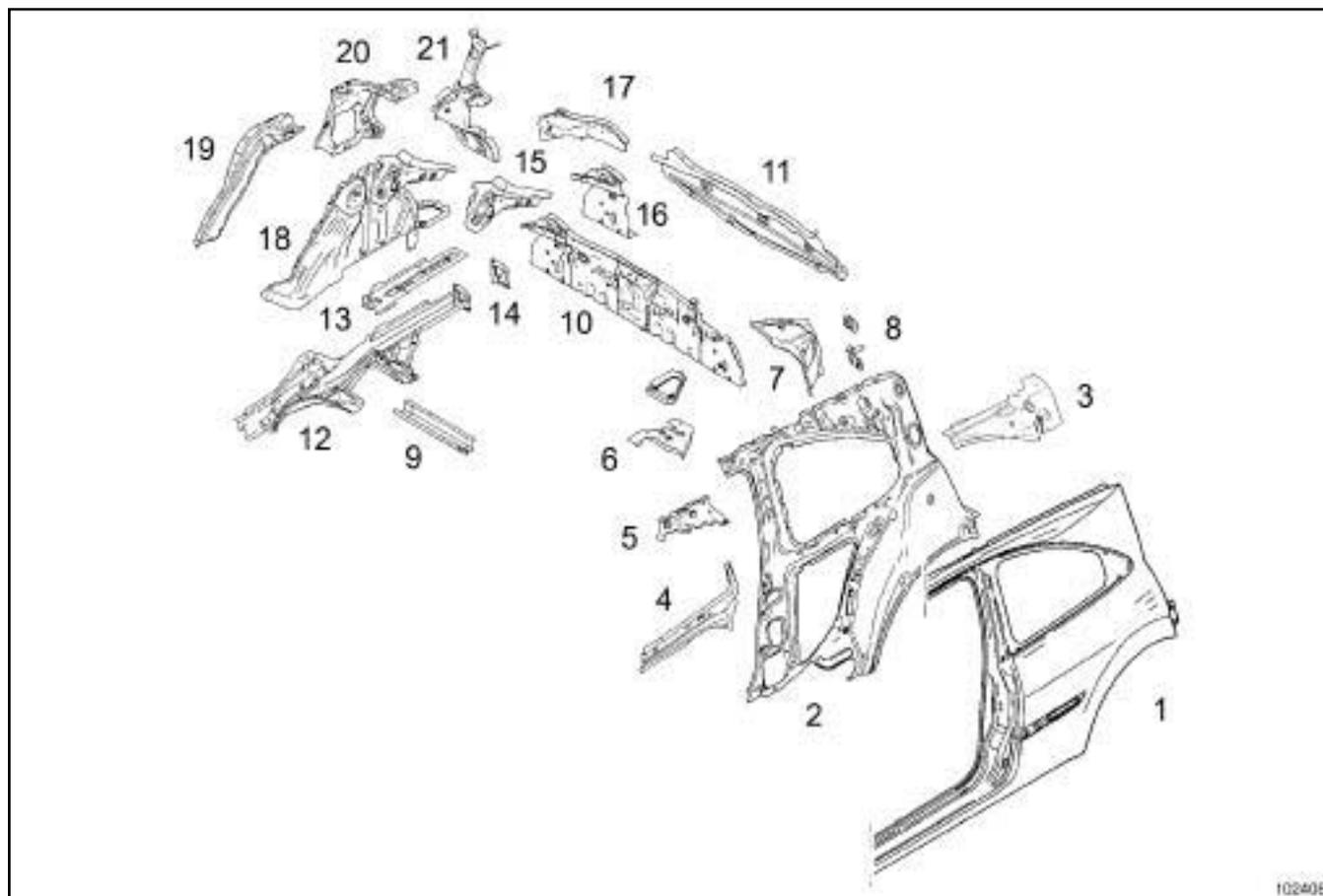
GENERAL VEHICLE INFORMATION

Vehicle structure rear section: Description

40A

B84 or C84

C84



102406

102406

Mark	Description	Classification	Type	Thickness (mm)
(1)	Rear wing panel	(see 44A, Rear upper structure, Rear wing panel: Description, page 44A-7)	-	0.7
(2)	Quarter panel lining	(see 44A, Rear upper structure, Quarter panel lining: Description, page 44A-37)	-	0.6
(3)	Rear quarter upper reinforcement	(see 44A, Rear upper structure, Quarter panel upper reinforcement: Description, page 44A-40)	-	0.9
(4)	Quarter panel centre reinforcement	(see 44A, Rear upper structure, Quarter panel centre reinforcement: Description, page 44A-43)	HLE	1.5
(5)	Rear roof drip moulding lining	(see 44A, Rear upper structure, Roof rear drip moulding lining: Description, page 44A-44)	-	1/2

GENERAL VEHICLE INFORMATION

Vehicle structure rear section: Description

40A

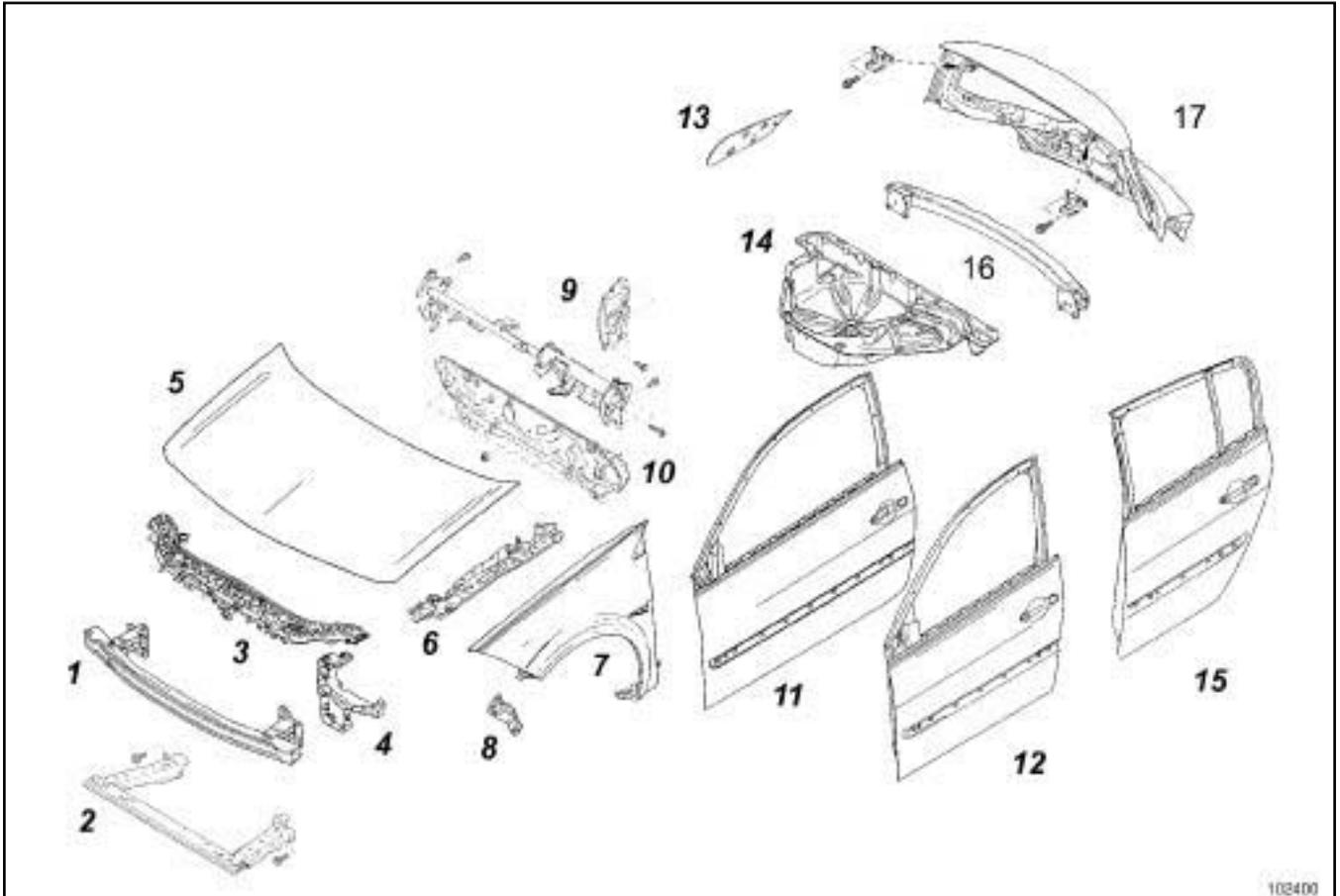
B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(6)	Far rear lower cross member, side part	(see 41D, Rear lower structure, Far rear lower cross member, side section: Description, page 41D-29)	-	0.95
(7)	Rear wheel arch extender	(see 44A, Rear upper structure, Rear wheel arch extension: Description, page 44A-33)	-	0.7
(8)	Tailgate stop mounting			
(9)	Rear floor centre cross member	(see 41D, Rear lower structure, Rear floor centre cross member: Description, page 41D-28)	HLE	1/2.5
(10)	Rear end panel assembly	(see 44A, Rear upper structure, Rear end panel assembly: Description, page 44A-46)	HLE/ THLE	0.65/2.5
(11)	Rear end panel	(see 44A, Rear upper structure, Rear end panel: Description, page 44A-49)	-	0.65
(12)	Rear side member	(see 41D, Rear lower structure, Rear side member: Description, page 41D-20)	HLE/ THLE	0.95/2
(13)	Rear side member closure panel, rear section	(see 41D, Rear lower structure, Rear side member closure panel, rear section: Description, page 41D-23)	-	0.7
(14)	Impact cross member mounting stiffener	(see Rear impact cross member mounting stiffener: Description)	HLE	2
(15)	Light mounting lining	(see 44A, Rear upper structure, Lights support lining: Description, page 44A-21)	HLE	0.95
(16)	Rear end panel side lining	(see 44A, Rear upper structure, Rear end panel side lining: Description, page 44A-51)	-	0.7
(17)	Rear light mounting	(see 44A, Rear upper structure, Rear lights support: Description, page 44A-18)	-	0.9
(18)	Inner rear wheel arch	(see 44A, Rear upper structure, Inner wheel arch: Description, page 44A-29)	HLE	0.7/1.5
(19)	Rear wheel arch closure panel	(see 44A, Rear upper structure, Rear wheel arch closure panel: Description, page 44A-31)	-	0.7
(20)	Quarter panel stiffener	(see 44A, Rear upper structure, Quarter panel reinforcement: Description, page 44A-36)	-	0.9
(21)	Rear wing panel rain channel	(see 44A, Rear upper structure, Rear wing panel rain channel: Description, page 44A-15)	HLE	0.85/1

Vehicle removable section structure: Description

B84 or C84

STRUCTURE WHICH CAN BE DISMANTLED



102400

Mark	Description	Classification	Type
(1)	Frontal impact cross member	(see 41A, Front lower structure, Front impact cross member: Removal - Refitting, page 41A-8)	Aluminium
(2)	Radiator mounting cross member	(see 41A, Front lower structure, Radiator support cross member: Removal - Refitting, page 41A-13)	
(3)	Front end panel centre section	(see 42A, Upper front structure, Front: Removal - Refitting, page 42A-23)	Steel/SMC
(4)	Front end panel side section	(see 42A, Upper front structure, Front: Removal - Refitting, page 42A-23)	SMC
(5)	Bonnet	(see 48A, Non-side opening elements, Bonnet: Removal - Refitting, page 48A-5)	Aluminium

GENERAL VEHICLE INFORMATION

40A

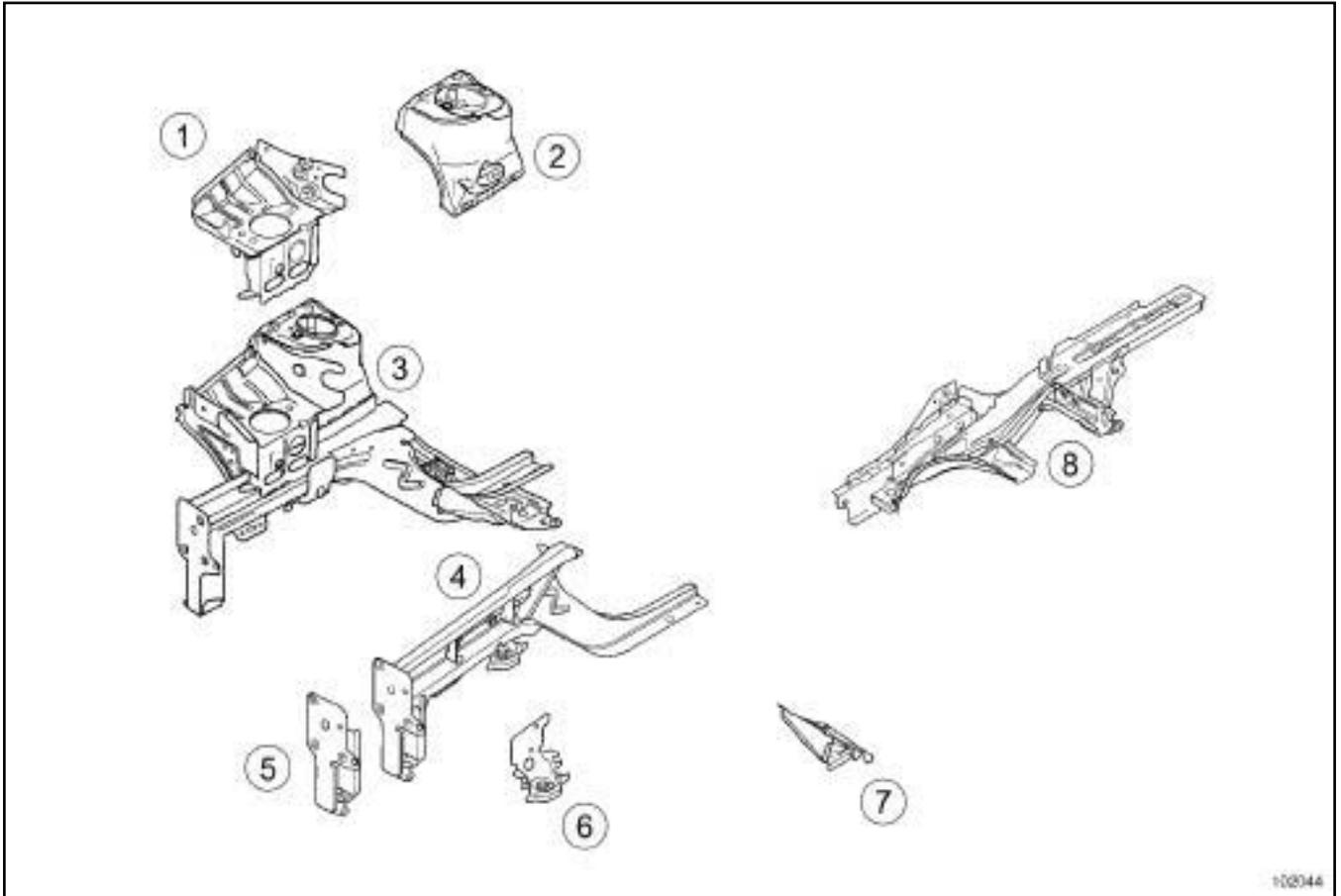
Vehicle removable section structure: Description

B84 or C84

Mark	Description	Classification	Type
(6)	Front wing upper mounting support	(see 42A, Upper front structure, Front wing upper mounting support: Removal - Refitting, page 42A-20)	
(7)	Front wing	(see 42A, Upper front structure, Front wing: Removal - Refitting, page 42A-11)	Noryl
(8)	Front wing lower mounting support	(see 42A, Upper front structure, Front wing lower mounting support: Removal - Refitting, page 42A-18)	
(9)	Dashboard cross member	(see 42A, Upper front structure, Dashboard cross member: Removal - Refitting, page 42A-42)	
(10)	Bulkhead plate	(see 42A, Upper front structure, Bulkhead panel: Removal - Refitting, page 42A-54)	Aluminium
(11)	Front side door, 3-door version	(see 47A, Side opening elements, Front side door: Removal - Refitting, page 47A-5)	
(12)	Front side door, 5-door version	(see 47A, Side opening elements, Front side door: Removal - Refitting, page 47A-5)	
(13)	Fuel filler flap cover	(see 47A, Side opening elements, Fuel filler flap cover: Removal - Refitting, page 47A-27)	Noryl
(14)	Rear section of rear floor	(see Rear floor rear section: Description)	
(15)	Rear side door	(see 47A, Side opening elements, Rear side door: Removal - Refitting, page 47A-18)	
(16)	Rear impact lower cross member	(see 41D, Rear lower structure, Rear impact lower cross member: Removal - Refitting, page 41D-33)	Polypropylene
(17)	Tailgate	(see 48A, Non-side opening elements, Tailgate: Removal - Refitting, page 48A-11)	

B84 or C84

PART REQUIRING REPAIRS IN BODY JIG BENCH



102044

102044

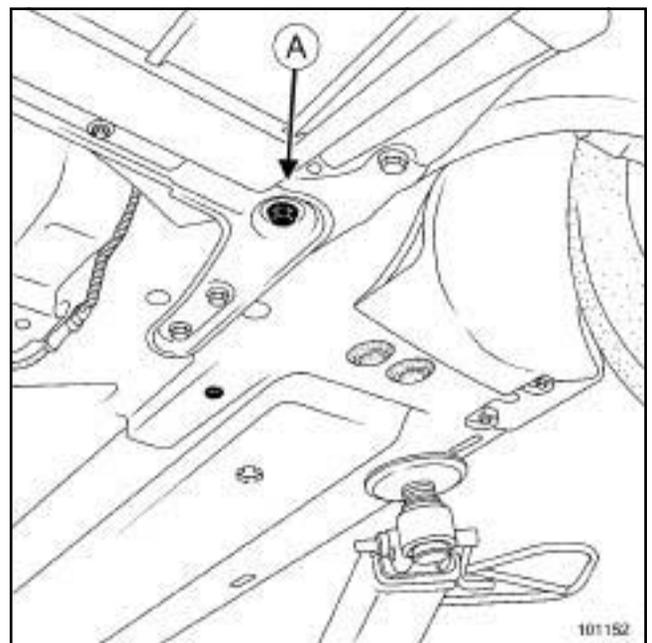
- (1) Engine stand.
- (2) Front wheel arch.
- (3) Front half unit.
- (4) Front side member.
- (5) Radiator cross member mounting.
- (6) Front sub-frame front mounting unit.
- (7) Front sub-frame rear mounting unit.
- (8) Rear side member.

I - PRINCIPAL REFERENCE POINTS FOR SETTING TRIM HEIGHT

1 - A - FRONT SUB-FRAME REAR MOUNTING

This is the principal front reference point for setting the trim height.

a - Front mechanical components in place



101152

101152

The bracket covers the sub-frame mounting bolt (A) .

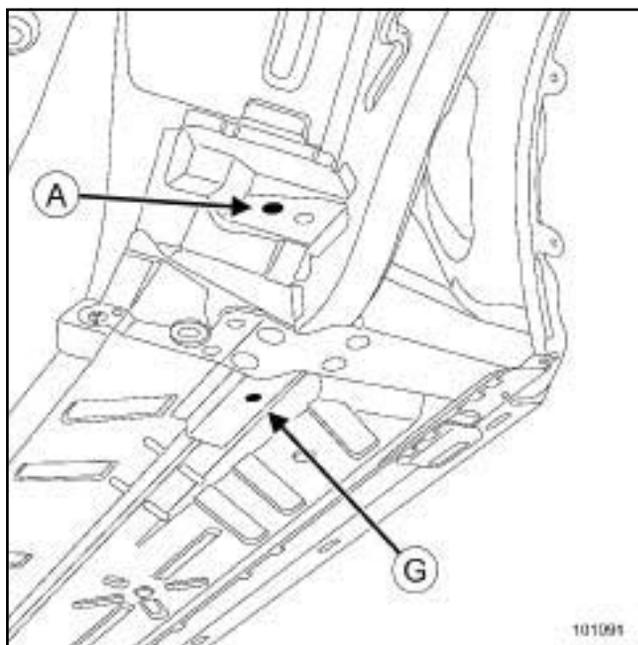
B84 or C84

Two possible cases can arise:

- For rebuilding the rear of the vehicle, these two points alone can be used to align and support the front of the vehicle.
- For a light frontal impact not requiring removal of the front axle sub-frame.

If in doubt about the damage to one of the main reference points (A or B), use the two additional points located in the area not affected by the impact to confirm the trim height.

b - Front mechanical components removed



Note:

- on the left-hand side, the hole is round;
- on the right-hand side, it is a slot.

If replacing the sub-frame rear support, this reference point is replaced temporarily by point (G), located on the rear part of the front side member, point (A) thus being used for positioning the replaced component.

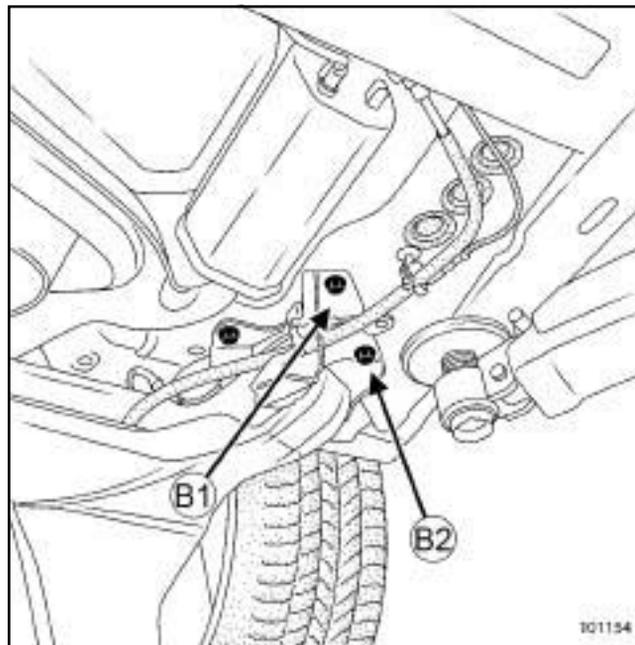
WARNING

This point contributes to ensuring the front axle geometry, it aligns the front axle sub-frame with the body and directly influences all the angles of the front axle.

2 - B - REAR AXLE FRONT MOUNTING

This is the principal rear reference point for setting the trim height.

a - Rear mechanical components in place

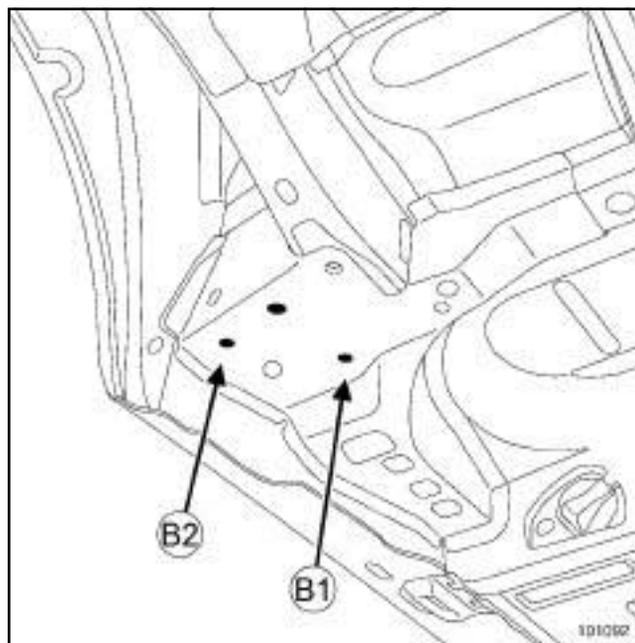


101154

The bracket covers the rear axle bearing mounting bolts.

Used for a frontal impact or a light rear impact.

b - Rear mechanical components removed



101092

B84 or C84

The bracket is supporting the underneath of the rear axle assembly mounting unit and is centred in the threaded holes of the rear axle bearing mounting.

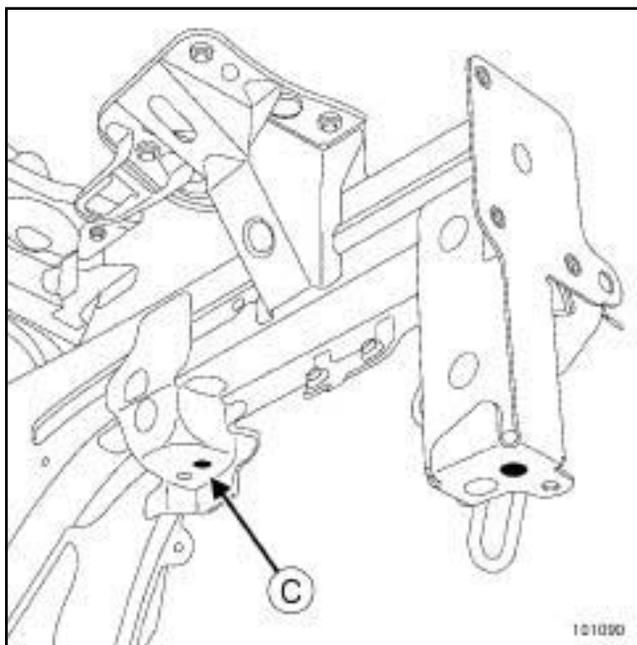
If the complete rear side member is being replaced, this reference point is replaced by point (G) located on the rear section of the front side member, points (B) being used to position the replaced component.

WARNING

These points are used to align the rear axle with the body and directly influence the vehicle trajectory angle.

II - REFERENCE POINTS FOR POSITIONING THE PARTS REPLACED

1 - C - FRONT SUB-FRAME FRONT MOUNTING UNIT



101090

With just the front mechanical components removed, the bracket rests under the front sub-frame front mounting unit and is centred in the threaded hole of the sub-frame mounting.

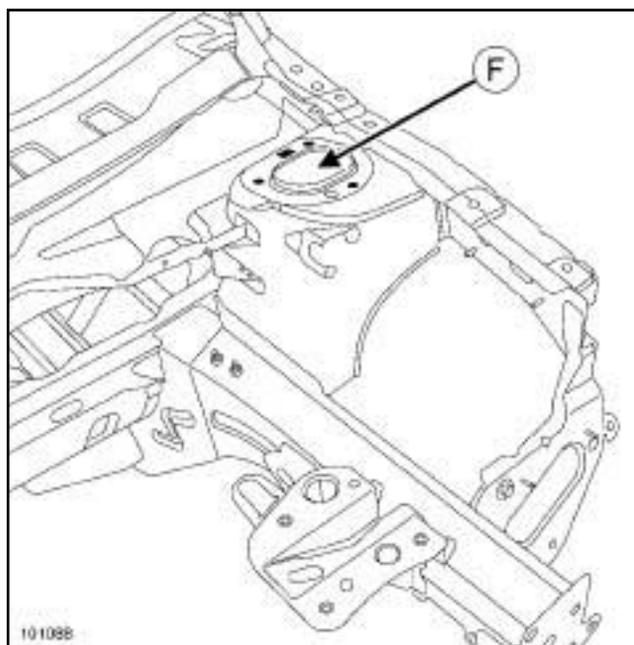
It is used when replacing:

- a partial or complete front side member,
- a half unit.

WARNING

This point helps to maintain the front axle geometry. It directly influences the clearance in the space of the lower wishbone and therefore the variations in castor angle and wheel alignment.

2 - F - FRONT SHOCK ABSORBER UPPER MOUNTING



101088

The bracket rests under the shock absorber cup and is centred in the shock absorber cup hole.

It is used when replacing:

- a wheel arch,
- a front half unit.

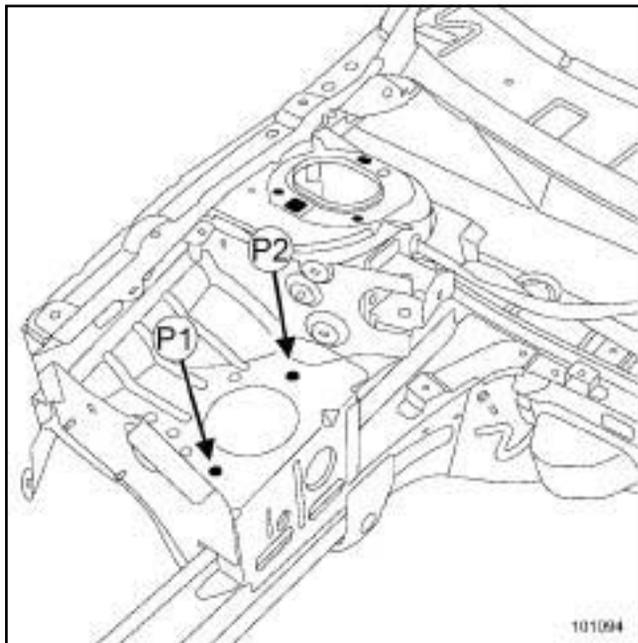
It is also used when straightening.

WARNING

This point helps to maintain the front axle geometry. It directly influences the camber and castor pivot angles.

B84 or C84

3 - P - ENGINE MOUNTING



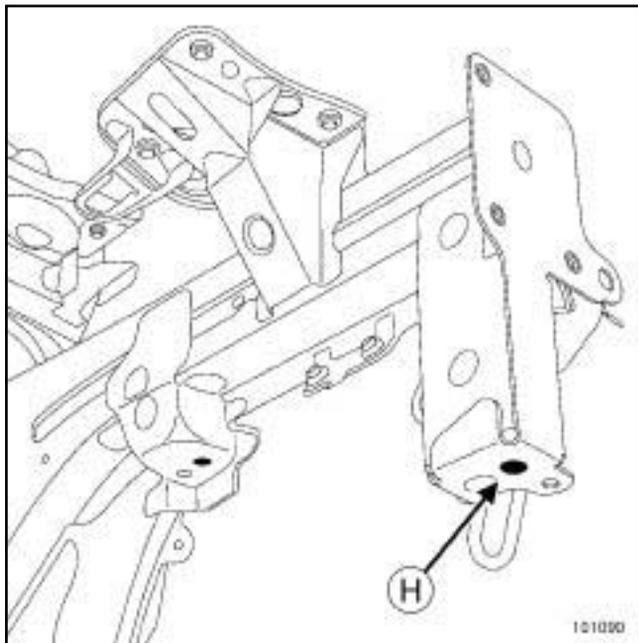
101094

The bracket is positioned from above the engine mounting and is centred in the mounting hole of the axle.

It should be used with the mechanical components removed for the replacement of:

- a front half unit.
- a front wheel arch.

4 - H - END OF FRONT SIDE MEMBER



101090

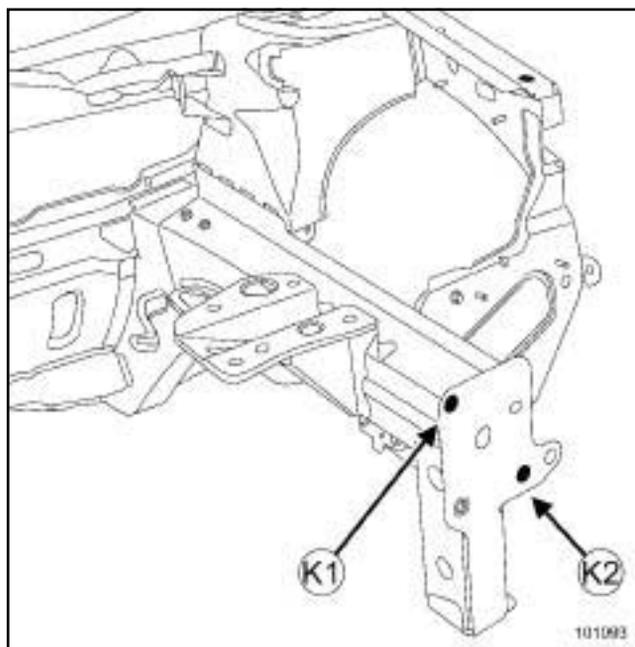
101090

The bracket rests under the side member and is centred in the threaded hole of the radiator mounting cross member.

It should be used with the mechanical components removed for the replacement of:

- a side member,
- a front half unit.
- a radiator cross member mounting support.

5 - K - FRONTAL IMPACT CROSS MEMBER MOUNTING



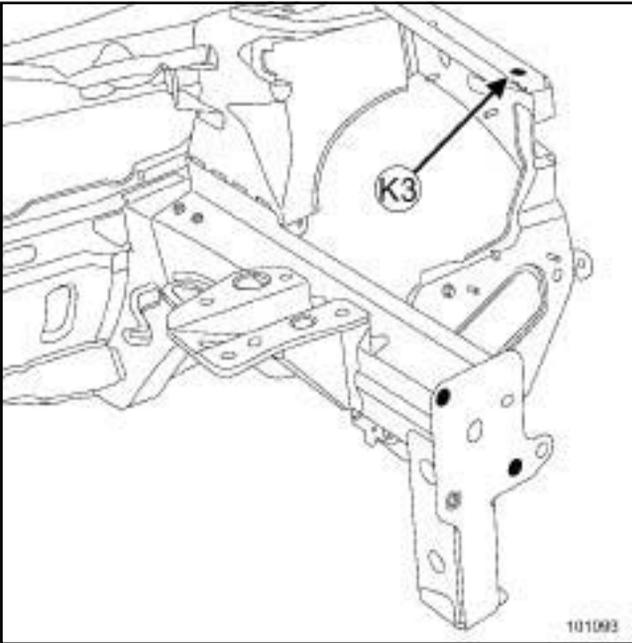
101093

The bracket rests vertically against the radiator cross member mounting and is centred in the threaded mounting holes of the frontal impact cross member.

When rebuilding, points **(K)** are used for replacing:

- a radiator cross member mounting,
- a partial or complete front side member,
- a half unit.

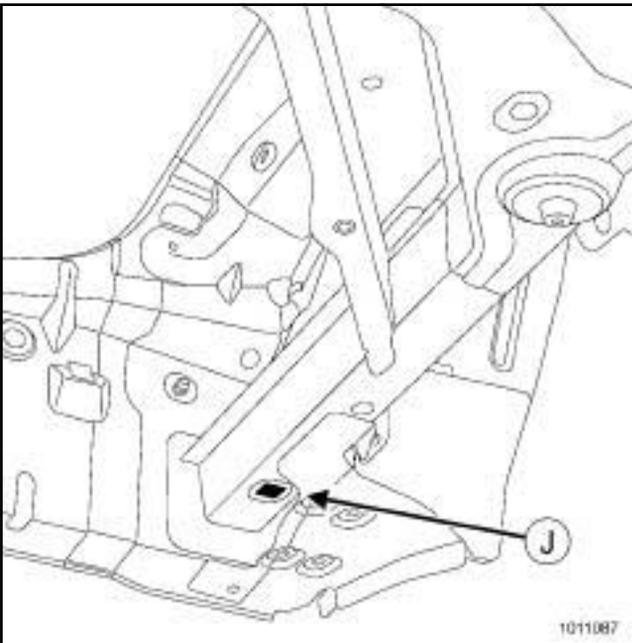
B84 or C84



101093

They are also used as reference points for point (K3) for mounting the front wing upper support.

6 - J - REAR SIDE MEMBER END



101087

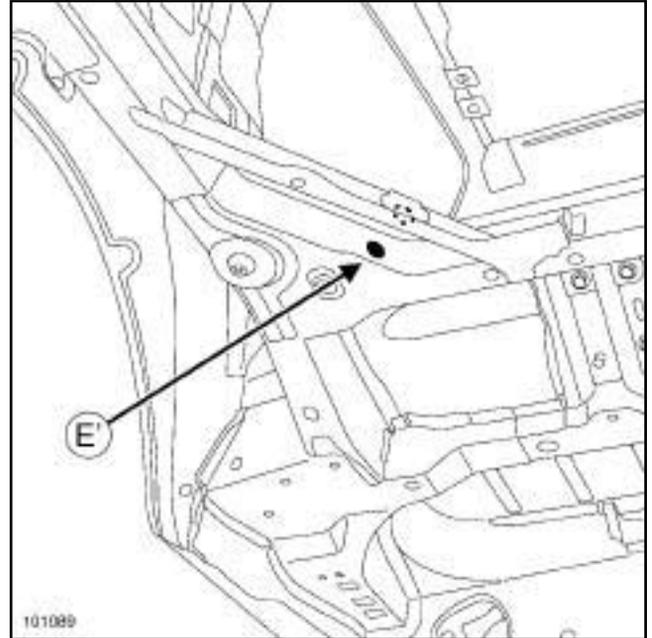
101087

The bracket rests under the side member and is centred in the leader pin hole.

It should be used with the mechanical components in place to realign a side member.

It is also used with the mechanical components removed, in the same conditions, to replace the side member.

7 - E - REAR SHOCK ABSORBER MOUNTING



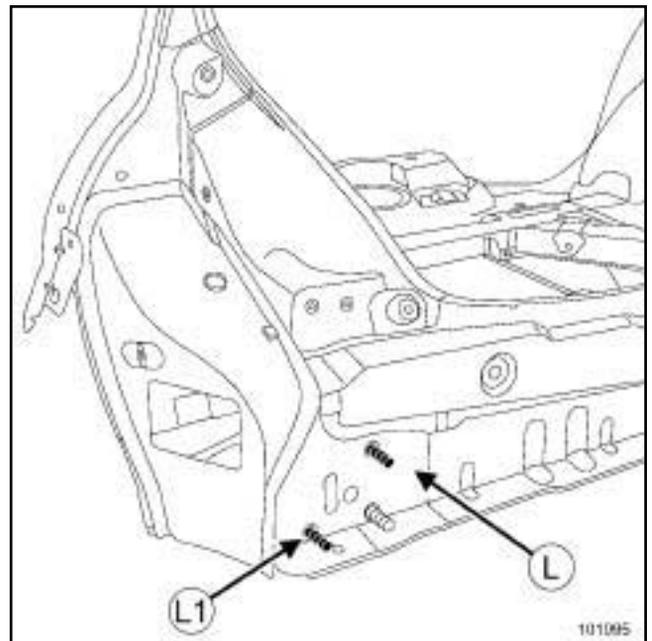
101089

101089

The bracket is centred and attached inside the shock absorber shaft.

It should be used when replacing a complete rear side member.

8 - L - REAR END PANEL CROSS MEMBER



101095

101095

The bracket rests vertically against the side lining of the rear end panel and is centred on the rear impact cross member mounting studs.

GENERAL VEHICLE INFORMATION

Structure components to be positioned on body repair bench: Description

40A

B84 or C84

They are used when replacing:

- an impact cross member mounting stiffener,
- a partial or complete rear side member.

GENERAL VEHICLE INFORMATION

Structural bodywork reference material: Use

40A

B84 or C84

I - - CLASSIFYING INFORMATION

This information is classified in two additional documents:

1 - Vehicle structure bodywork repair procedures (MR of the vehicle concerned)

This document comprises two sections:

a - Section 0:

This section does not contain repair procedures, it only contains descriptive information; It consists of several subsections:

- 01C Vehicle bodywork specifications
- 02A Lifting equipment
- 02B Bodywork innovations
- 03B Collision
- 04E Paintwork
- 05B Bodywork equipment and tooling

b - Section 4:

This section consists of several subsections:

- 40A General information
- 41A Lower front structure
- 41B Lower central structure
- 41C Lower side structure
- 41D Lower rear structure
- 42A Upper front structure
- 43A Upper side structure
- 44A Upper rear structure
- 45A Top of body
- 47A Side opening elements
- 48A Non-side opening elements

These subsections are linked to the Replacement Parts Catalogue and contain two types of information

- Part 1: General description containing information relating to generic structural spare parts and to their design. This information may be the same for several vehicles.
- Part 2: Description, removal and refitting, strip and rebuild, and adjustment; contains information about the structure of the replacement parts and contains special notes about the vehicle being worked on.

WARNING

Always read both parts in order to have all the necessary information to repair the vehicle.

2 - Fundamentals of structural bodywork repair (MR 400)

This document comprises two sections:

a - Section 0:

This section does not contain any repair procedures; it only contains descriptive information and has only one subsection:

- 03B Collision

b - Section 4:

This section contains information for using materials and products, and the fundamental operating ranges which relate to the sheet metal worker's work. This section only contains a single subsection.

- 40A Structure general information

II - INFORMATION SEARCH

Questions	Answers
Specifications of specific tools to repair a given vehicle.	Refer firstly to section 0 of the Vehicle's MR then refer to the « special tooling catalogue » or the « garage equipment catalogue » .
Specifications of specific products to repair a given vehicle.	Firstly refer to section 0 of the Vehicle's MR then refer to the « IXELL product catalogue » .

GENERAL VEHICLE INFORMATION

Structural bodywork reference material: Use

40A

B84 or C84

Questions	Answers
Use of a specific tool to repair a given vehicle.	Firstly refer to subsection 0 of the Vehicle's MR
Using a bodywork tool.	Firstly refer to subsection 40 of the Vehicle MR then MR 400
Information concerning the replacement parts of a given vehicle regarding: <ul style="list-style-type: none"> - The replacement possibilities with the position on the vehicle. - A conversion before assembly. - A cutting area with the special features of this cut. - Special features of right-left symmetry. - Special features of the version or equipment. 	Refer to the subsection which corresponds to the part concerned: 41 to 48 of the Vehicle MR, part 2
Information concerning the spare parts of a given vehicle, the composition and the specifications of each part it contains.	Firstly refer to the parts description exploded view in subsection 40 of the Vehicle MR.
	If this is detailed in the document, refer to subsections 41 to 48 of the Vehicle MR part 2 which corresponds with the part concerned.
	If this does not appear in the description, refer to subsection 41 to 48 for the part in the next level up.
Information concerning: <ul style="list-style-type: none"> - Details of panel overlap on a joint. - A procedure and an operational mode relating to a new type of assembly in Renault. - A procedure for using a tool or a new product which is unfamiliar in Renault. 	Refer to the subsection which corresponds to the part concerned: 41 to 48 of the Vehicle MR then subsection 40 of Vehicle MR 400.
Towing and raising a vehicle after an accident.	Firstly refer to subsection 40 of the Vehicle MR then the equipment catalogue.
Conveyance and handling of a vehicle after an accident.	Firstly refer to subsection 40 of the MR 400 then the equipment catalogue.
Combination of impacts to repair a given vehicle.	Refer to section 0 of the Vehicle's MR
Logic of the impact combination.	Refer to section 0 of the Vehicle's MR
Fault finding on an impact for a given vehicle.	Firstly refer to section 0 of the Vehicle's MR then section 0 of MR 400.

GENERAL VEHICLE INFORMATION
Structural bodywork reference material: Use

40A

B84 or C84

Questions	Answers
Logic of impact fault finding.	Section 0 of MR 400.
General instructions for: - Repair. - Safety. - Preparing a vehicle. - Classification of tools. - Precautions for repair.	Section 0 of MR 400.

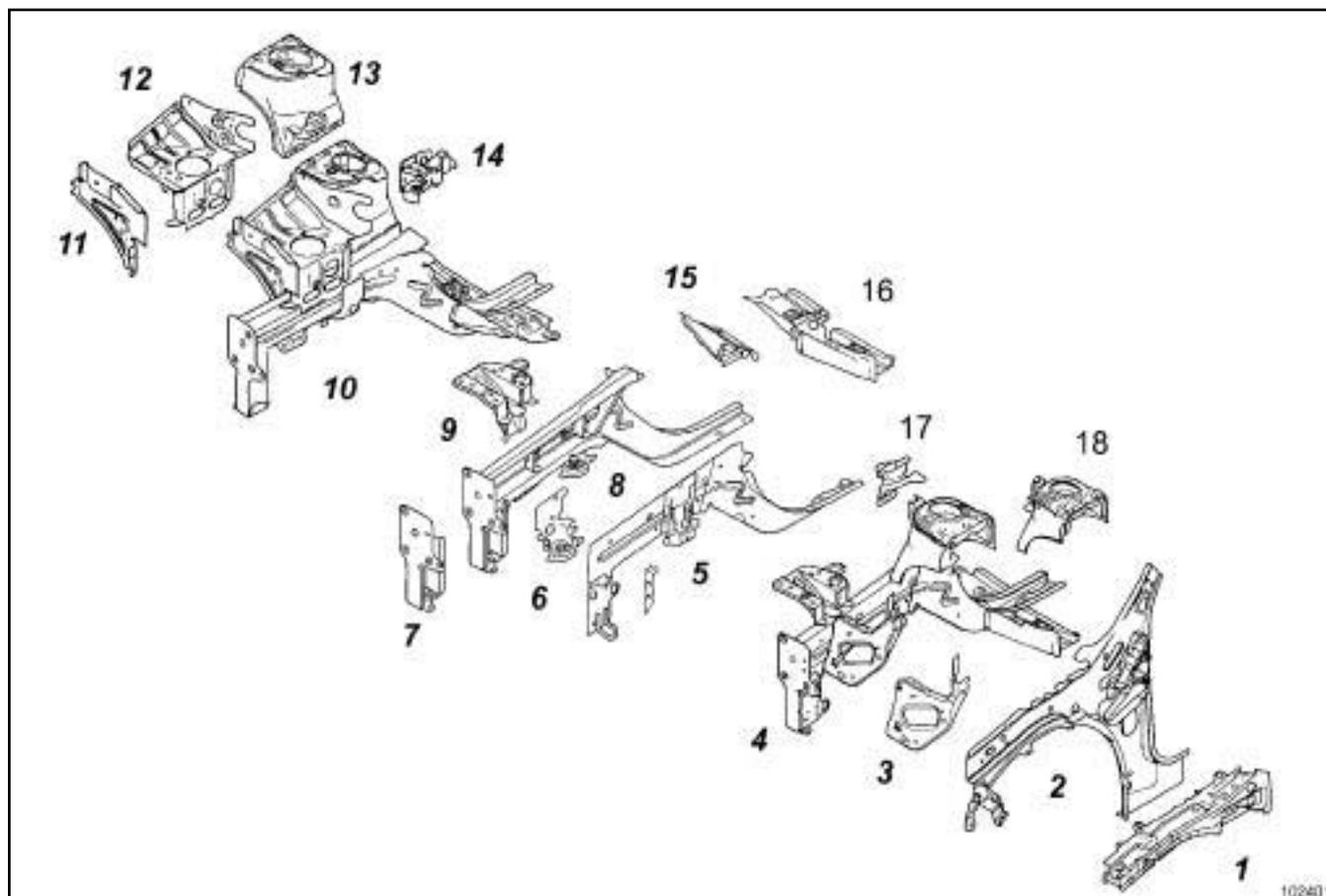
FRONT LOWER STRUCTURE

Vehicle front section structure: Description

41A

B84 or C84

FRONT STRUCTURE



102401

Mark	Description	Classification	Type	Thickness (mm)
(1)	Scuttle side panel upper reinforcement	(see 42A, Upper front structure, Scuttle side panel upper reinforcement: Description, page 42A-32)	-	0.9
(2)	Scuttle side panel	(see 42A, Upper front structure, Cowl side panel: Description, page 42A-28)	HLE/ THLE	1/2.5
(3)	Front end side cross member	(see Front end side cross member: Description)	-	1.2
(4)	Left-hand front half unit	(see 41A, Front lower structure, Front half unit: Description, page 41A-39)	HLE/ THLE	1.1/3
(5)	Front section of front side member closure panel	(see 41A, Front lower structure, Front section of front side member closure panel: Description, page 41A-23)	HLE/ THLE	1.7/3

FRONT LOWER STRUCTURE

Vehicle front section structure: Description

41A

B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(6)	Front mounting of front sub-frame	(see 41A, Front lower structure, Front mounting of front sub-frame: Description, page 41A-32)	HLE	1.2
(7)	Radiator cross member support	(see 41A, Front lower structure, Radiator cross member support: Description, page 41A-29)	-	1.2/2.5
(8)	Front side member	(see 41A, Front lower structure, Front side member: Description, page 41A-17)	HLE/ THLE	1.2/3
(9)	Battery tray bracket	(see 41A, Front lower structure, Battery tray support: Description, page 41A-27)	-	1.5/2
(10)	Right-hand front half unit	(see 41A, Front lower structure, Front half unit: Description, page 41A-39)	HLE/ THLE	1.1/3
(11)	Front end side cross member	(see Front end side cross member: Description)	-	1.2
(12)	Engine stand	(see 41A, Front lower structure, Engine mounting: Description, page 41A-34)	HLE	1.5/2
(13)	Wheel arch	(see 42A, Upper front structure, Front wheel arch: Description, page 42A-35)	-	1.1/2
(14)	Engine tie-bar mounting		HLE	1
(15)	Sub-frame rear mounting	(see Sub-frame rear mounting: Description)	HLE/ THLE	2/3
(16)	Centre floor front side cross member	(see 41B, Centre lower structure, Centre floor front lateral cross member: Description, page 41B-18)	HLE/ THLE	1.2/3
(17)	Connecting bracket			
(18)	Front wheel arch	(see 42A, Upper front structure, Front wheel arch: Description, page 42A-35)	HLE	1.1/2

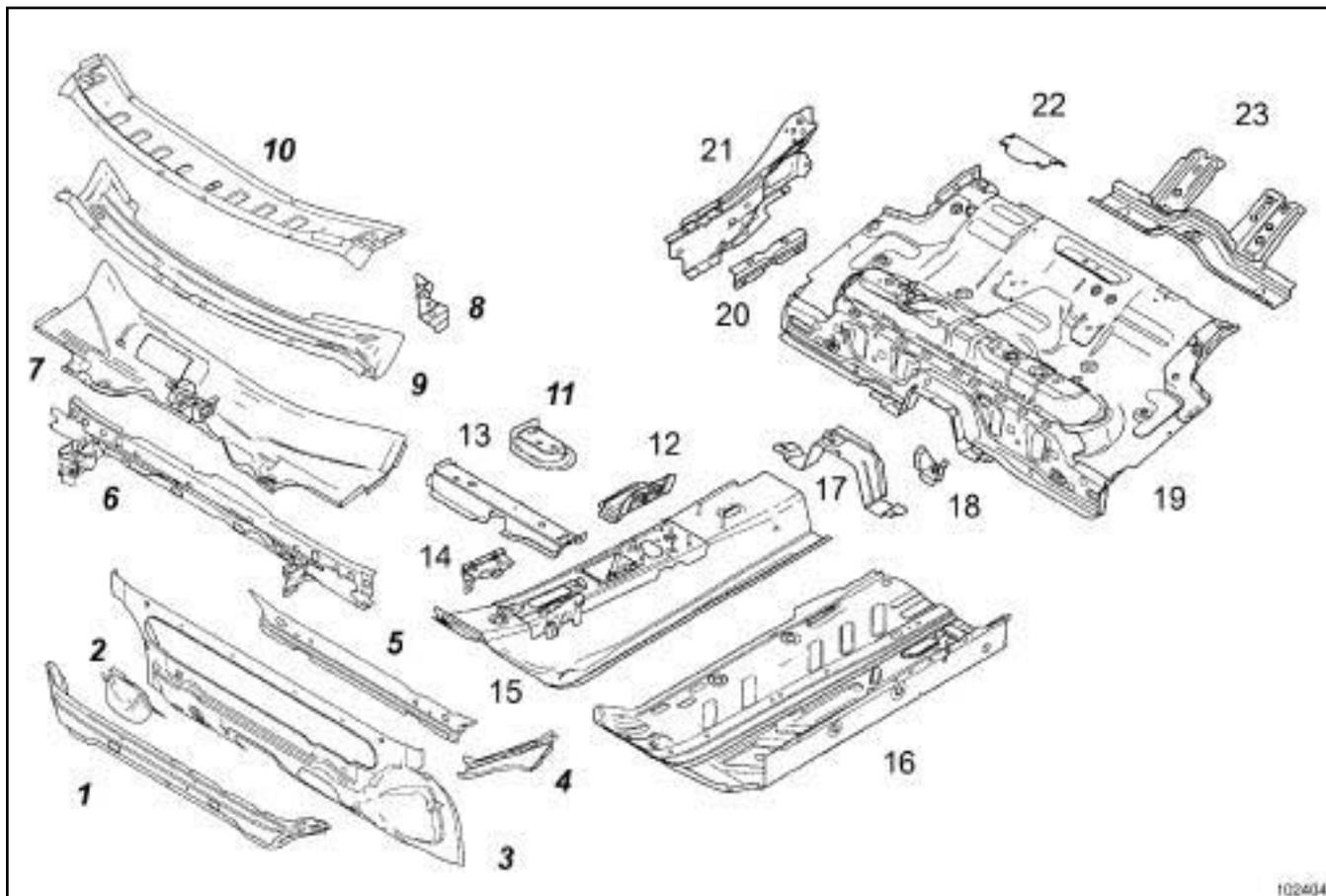
FRONT LOWER STRUCTURE

Vehicle central section structure: Description

41A

B84 or C84

CENTRAL STRUCTURE



102404

102404

Mark	Description	Classification	Type	Thickness (mm)
(1)	Bulkhead lower cross member	(see 42A, Upper front structure, Bulkhead lower cross member: Description, page 42A-53)	VHLE	2.5
(2)	Steering column unit		-	1.5
(3)	Bulkhead	(see 42A, Upper front structure, Bulkhead: Description, page 42A-49)	-	0.9
(4)	Bulkhead side reinforcement	(see 42A, Upper front structure, Bulkhead side stiffener: Description, page 42A-59)	UHLE	1.7
(5)	Bulkhead reinforcement	(see 42A, Upper front structure, Bulkhead reinforcement: Description, page 42A-51)	UHLE	1.7

FRONT LOWER STRUCTURE

Vehicle central section structure: Description

41A

B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(6)	Bulkhead upper cross member	(see 42A, Upper front structure, Bulkhead upper cross member: Description, page 42A-57)	HLE	0.95/3
(7)	Heater bulkhead	(see 42A, Upper front structure, Heater bulkhead: Description, page 42A-38)	-	0.7/1.2
(8)	Windscreen wiper mounting	(see 42A, Upper front structure, Windscreen wiper mounting: Description, page 42A-61)	-	1.2
(9)	Windscreen aperture lower cross member	(see 42A, Upper front structure, Windscreen aperture lower cross member: Description, page 42A-41)	-	0.7
(10)	Windscreen aperture lower cross member closure panel	(see 42A, Upper front structure, Windscreen aperture lower cross member closure panel: Description, page 42A-47)	-	0.65/1.2
(11)	Front seat mounting exterior unit	(see 41B, Centre lower structure, Front seat rear outer mounting unit: Description, page 41B-26)	HLE	1.5
(12)	Front seat mounting interior unit	(see 41B, Centre lower structure, Front seat rear mounting interior unit: Description, page 41B-25)	HLE	1.5/2.5
(13)	Front cross member under front seat	(see 41B, Centre lower structure, Front cross member under front seat: Description, page 41B-23)	HLE	1.5
(14)	Steering column mounting		-	1.3
(15)	Tunnel	(see 41B, Centre lower structure, Tunnel: Description, page 41B-20)	HLE/ THLE	1/1.6
(16)	Centre floor, side section	(see 41B, Centre lower structure, Central floor, side section: Description, page 41B-13)	VHLE	0.7/2.5
(17)	Exhaust mounting support	(see 41D, Rear lower structure, Exhaust mounting support: Description, page 41D-30)	-	1.2/2.5

FRONT LOWER STRUCTURE

Vehicle central section structure: Description

41A

B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(18)	Fuel tank mounting support	(see 41D, Rear lower structure, Tank mounting support: Description, page 41D-31)	-	1.2
(19)	Front section of rear floor	(see 41D, Rear lower structure, Rear floor, front section: Description, page 41D-10)	HLE/ THLE	0.7/2.5
(20)	Sill panel reinforcement stiffener		VHLE	1.8
(21)	Sill panel rear reinforcement	(see 41C, Side lower structure, Sill panel rear reinforcement: Description, page 41C-29)	HLE	1.4
(22)	Fuel gauge closure panel		HLE	0.8
(23)	Rear floor front cross member, centre section	(see 41D, Rear lower structure, Rear floor front cross member, centre section: Description, page 41D-25)	HLE	1.2/2

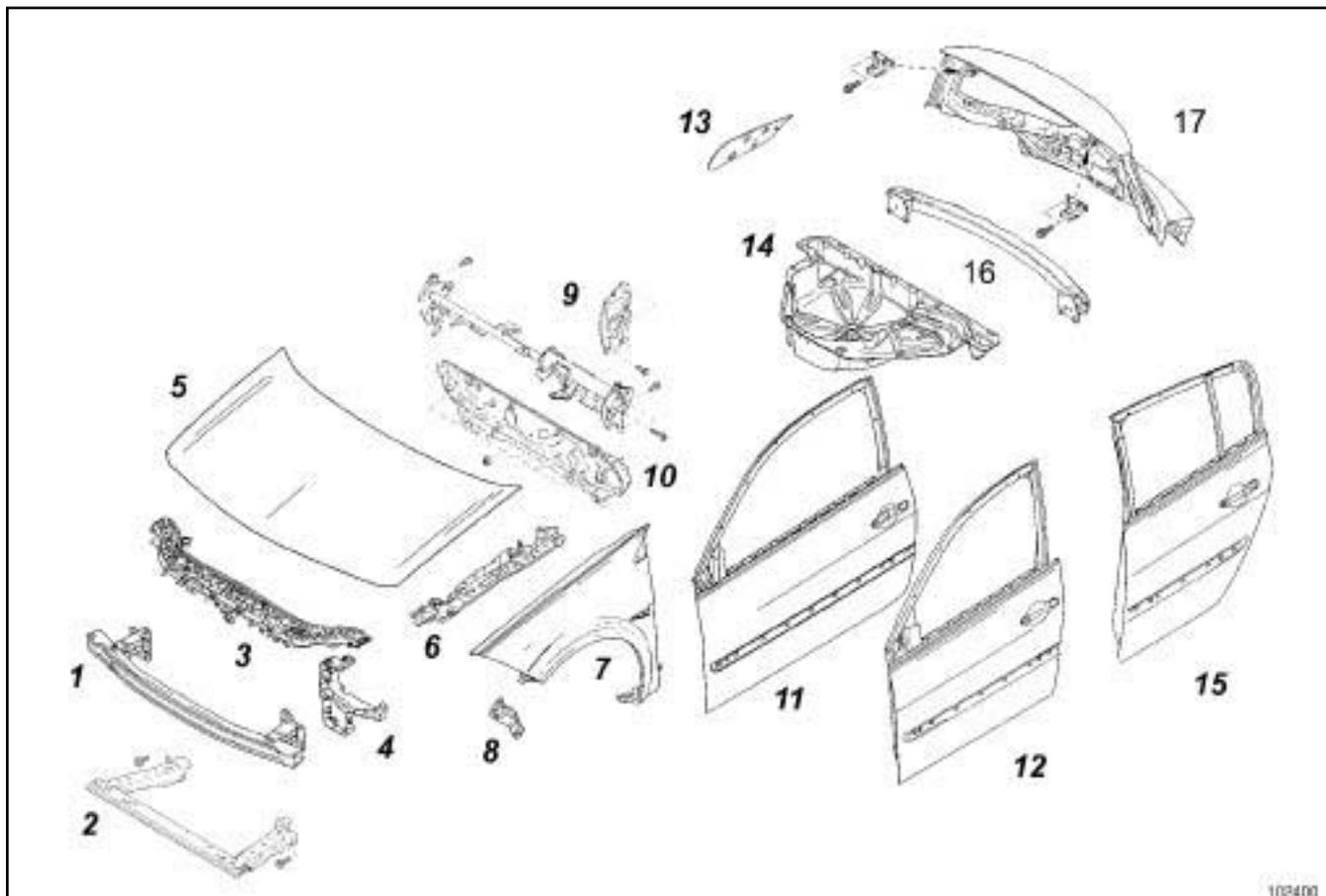
FRONT LOWER STRUCTURE

Vehicle removable section structure: Description

41A

B84 or C84

STRUCTURE WHICH CAN BE DISMANTLED



102400

102400

Mark	Description	Classification	Type
(1)	Frontal impact cross member	(see 41A, Front lower structure, Front impact cross member: Removal - Refitting, page 41A-8)	Aluminium
(2)	Radiator mounting cross member	(see 41A, Front lower structure, Radiator support cross member: Removal - Refitting, page 41A-13)	
(3)	Front end panel centre section	(see 42A, Upper front structure, Front: Removal - Refitting, page 42A-23)	Steel/SMC
(4)	Front end panel side section	(see 42A, Upper front structure, Front: Removal - Refitting, page 42A-23)	SMC
(5)	Bonnet	(see 48A, Non-side opening elements, Bonnet: Removal - Refitting, page 48A-5)	Aluminium

FRONT LOWER STRUCTURE

Vehicle removable section structure: Description

41A

B84 or C84

Mark	Description	Classification	Type
(6)	Front wing upper mounting support	(see 42A, Upper front structure, Front wing upper mounting support: Removal - Refitting, page 42A-20)	
(7)	Front wing	(see 42A, Upper front structure, Front wing: Removal - Refitting, page 42A-11)	Noryl
(8)	Front wing lower mounting support	(see 42A, Upper front structure, Front wing lower mounting support: Removal - Refitting, page 42A-18)	
(9)	Dashboard cross member	(see 42A, Upper front structure, Dashboard cross member: Removal - Refitting, page 42A-42)	
(10)	Bulkhead plate	(see 42A, Upper front structure, Bulkhead panel: Removal - Refitting, page 42A-54)	Aluminium
(11)	Front side door, 3-door version	(see 47A, Side opening elements, Front side door: Removal - Refitting, page 47A-5)	
(12)	Front side door, 5-door version	(see 47A, Side opening elements, Front side door: Removal - Refitting, page 47A-5)	
(13)	Fuel filler flap cover	(see 47A, Side opening elements, Fuel filler flap cover: Removal - Refitting, page 47A-27)	Noryl
(14)	Rear section of rear floor	(see Rear floor rear section: Description)	
(15)	Rear side door	(see 47A, Side opening elements, Rear side door: Removal - Refitting, page 47A-18)	
(16)	Rear impact lower cross member	(see 41D, Rear lower structure, Rear impact lower cross member: Removal - Refitting, page 41D-33)	Polypropylene
(17)	Tailgate	(see 48A, Non-side opening elements, Tailgate: Removal - Refitting, page 48A-11)	

B84 or C84

Tightening torques 	
side mounting bolts	44 Nm
unit bolts	35 Nm

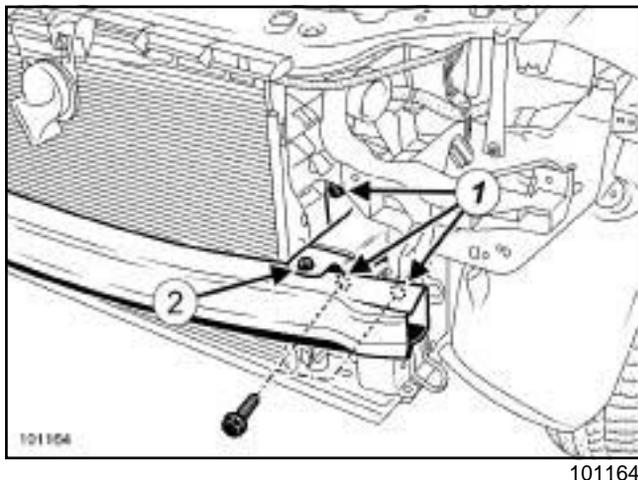
REMOVAL

I - REMOVAL PREPARATION OPERATION

Remove:

- the front bumper((see **Front bumper: Removal - Refitting**) ,
- the headlights((see **Halogen headlight: Removal - Refitting**) .

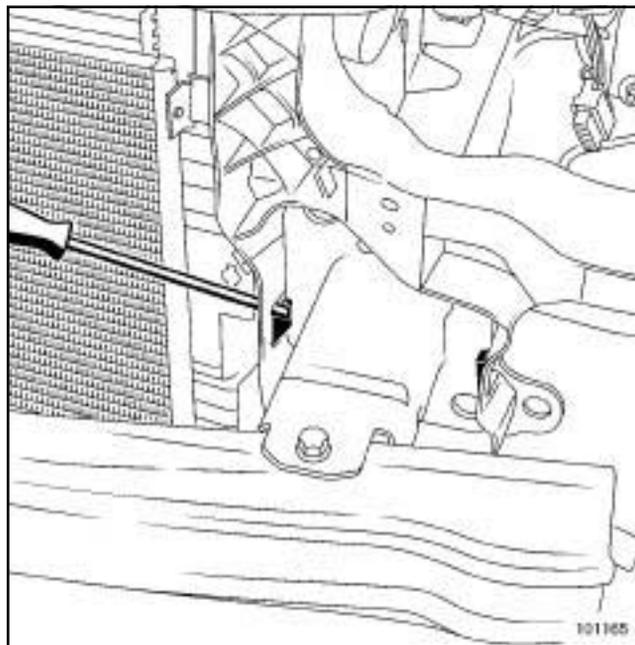
II - OPERATION FOR REMOVAL OF PART CONCERNED



Remove the side mounting bolts (1) (three on either side).

Note:

Depending on the degree of impact, it may be possible to replace the cross member via the unit bolts (2) .



101165

Move the retaining clips on the front end panel away using a flat-blade screwdriver and detach the frontal impact cross member.

REFITTING

I - REFITTING OPERATION FOR PART CONCERNED

Refit:

- the front impact cross member,
- the side mounting bolts (1) (three on each side).

WARNING

The cross member contributes to the structural rigidity of the engine compartment. For this reason, the tightening torque must be observed following any operation.

Tighten to torque:

- the **side mounting bolts (44 Nm)** ,
- the **unit bolts (35 Nm)** .

II - FINAL OPERATION

Refit:

- Refit the headlights((see **Halogen headlight: Removal - Refitting**) ,
- the front bumper((see **Front bumper: Removal - Refitting**) .

Lower front end cross member: General description

B84 or C84

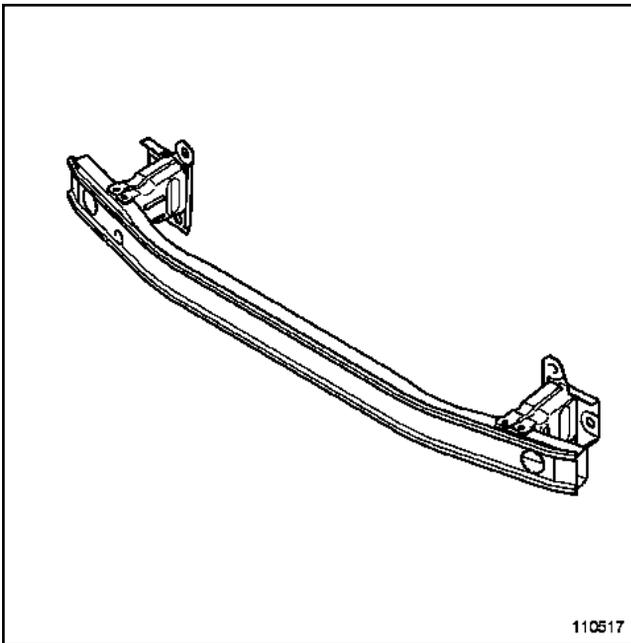
WARNING

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading this general information, check that there are no special notes associated with this vehicle. These special notes will be specified if applicable in other parts of this subsection dealing with the part.

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information**.

DESIGN OF THE STRUCTURAL COMPONENT

110517

A special feature of this part is that it is bolted to the ends of the front side members via the radiator cross member mounting support.

FRONT LOWER STRUCTURE

41A

Front end side cross member: Description

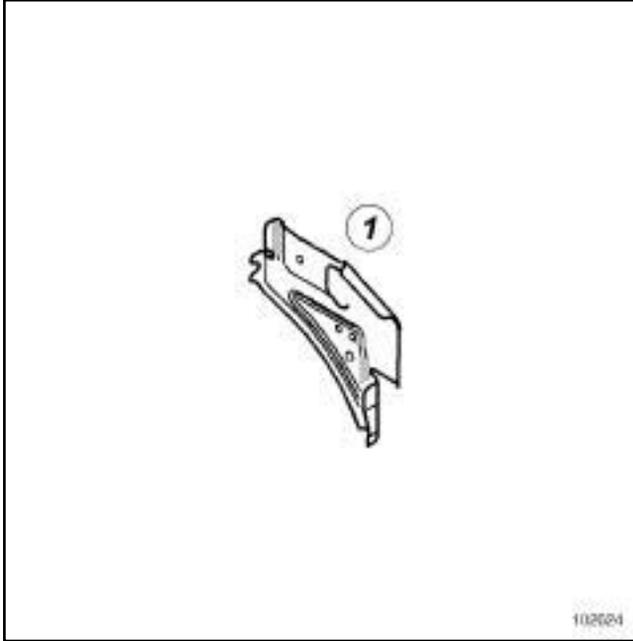
B84 or C84

There is only one way of replacing this part:

- complete replacement.

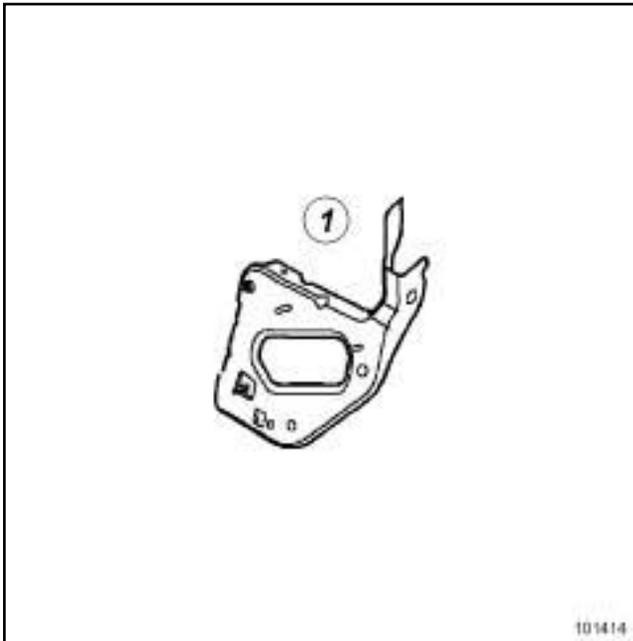
I - COMPOSITION OF THE SPARE PART

Right-hand side



102624

Left-hand side

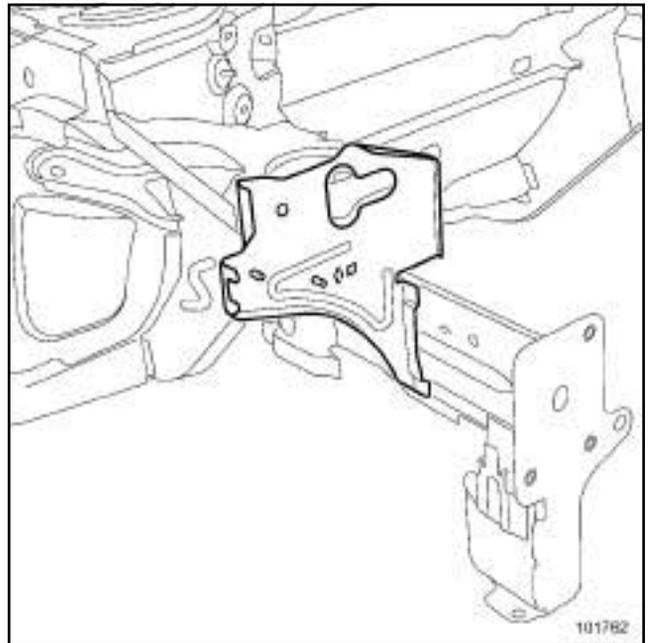


101414

Mark	Description	Type	Thickness (mm)
(1)	Front end side cross member	-	1.2

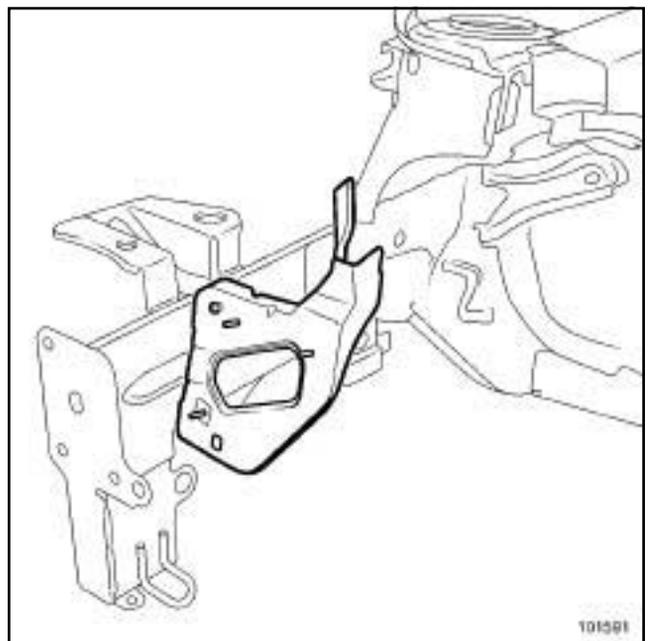
II - PART FITTED

Right-hand side



101762

Left-hand side



101591

FRONT LOWER STRUCTURE

Front end side cross member: Description

41A

B84 or C84

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

Radiator support cross member: General description

B84 or C84

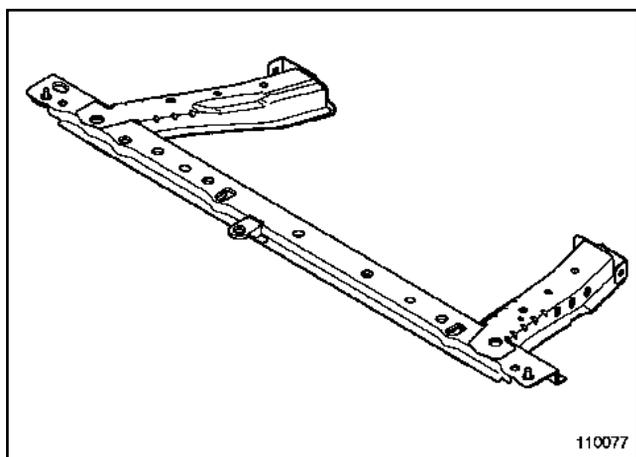
WARNING

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading this general information, check that there are no special notes associated with this vehicle. These special notes will be specified if applicable in other parts of this subsection dealing with the part.

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information**.

DESIGN OF THE STRUCTURAL COMPONENT

110077

110077

The distinctive feature of this part is that it combines two functions:

- distributing the force of frontal impacts,
- radiator mounting cross member.

B84 or C84

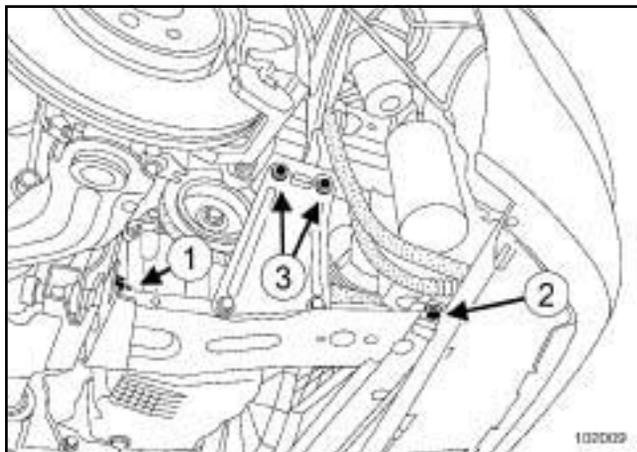
Tightening torques 	
the mounting nut (1)	21 Nm
the mounting bolts (2)	105 Nm
the mounting bolts (3)	62 Nm

REMOVAL

I - REMOVAL PREPARATION OPERATION

- Remove the front bumper((see **Front bumper: Removal - Refitting**) .
- Attach the radiator upper section.
- Remove the engine undertray.

II - OPERATION FOR REMOVAL OF PART CONCERNED



102009

- Remove:
 - the mounting bolts (1) , (2) and (3) ,
 - the radiator mounting cross member.

REFITTING

I - REFITTING OPERATION FOR PART CONCERNED

- Refit:
 - the radiator mounting cross member,
 - the mounting bolts (1) , (2) and (3) .
- Tighten to torque:
 - the mounting nut (1) (21 Nm) ,

- the mounting bolts (2) (105 Nm) ,
- the mounting bolts (3) (62 Nm) .

II - FINAL OPERATION

- Refit the engine undertray.
- Detach the radiator upper section.
- Refit the front bumper((see **Front bumper: Removal - Refitting**) .

FRONT LOWER STRUCTURE

Front side member: General description

41A

B84 or C84

WARNING

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading this general information, check that there are no special notes associated with this vehicle. These special notes will be specified if applicable in other parts of this subsection dealing with the part.

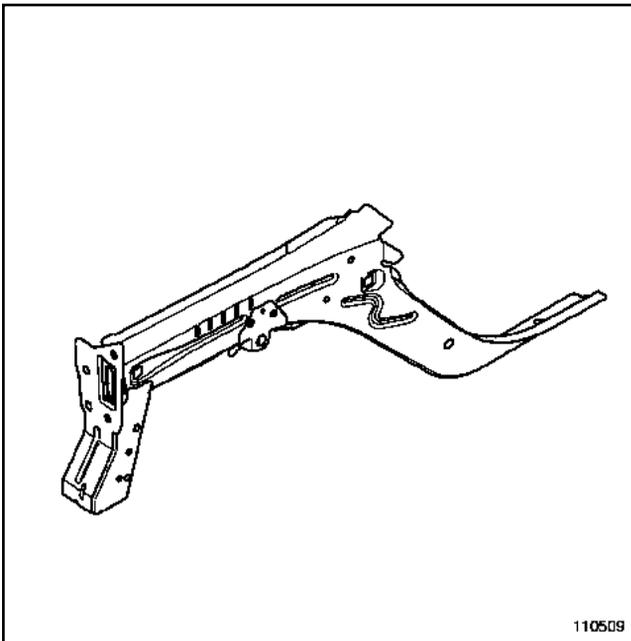
IMPORTANT

The straightening bench must be used.

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information**.

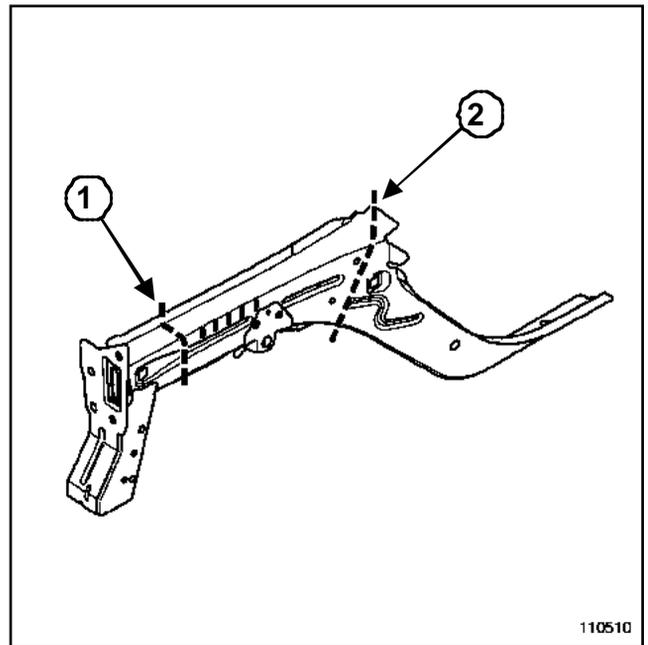
I - DESIGN OF THE STRUCTURAL COMPONENT



110509

The special feature of this type of part is that it combines the functions of front section and rear section of the front side member and that it is made of two different kinds of panels of different thicknesses assembled by laser butt welding.

II - AREA TO BE CUT FOR PARTIAL REPLACEMENT



110510

110510

1 - 1- Cut 1:

This line shows the centre of the area in which it is possible to carry out a partial replacement.

This operation allows you to access the inside of the hollow section of the structural component to straighten it.

Note:

For the partial replacement of parts constituting a single structural component, it is essential to stagger the welds of each of the components.

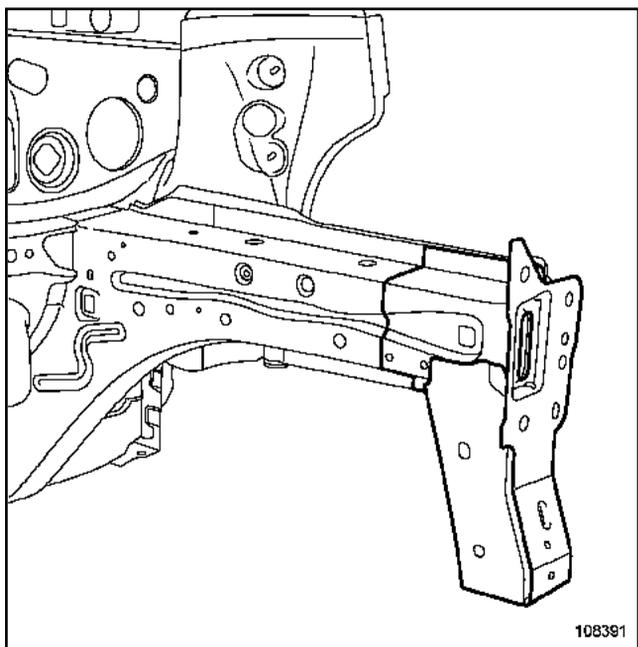
In this case, the side member weld line must be staggered from that of its closure panel.

FRONT LOWER STRUCTURE

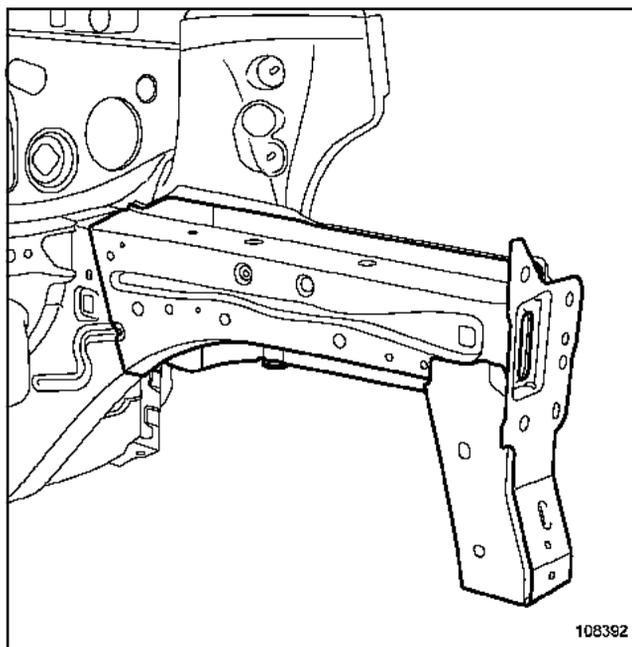
Front side member: General description

41A

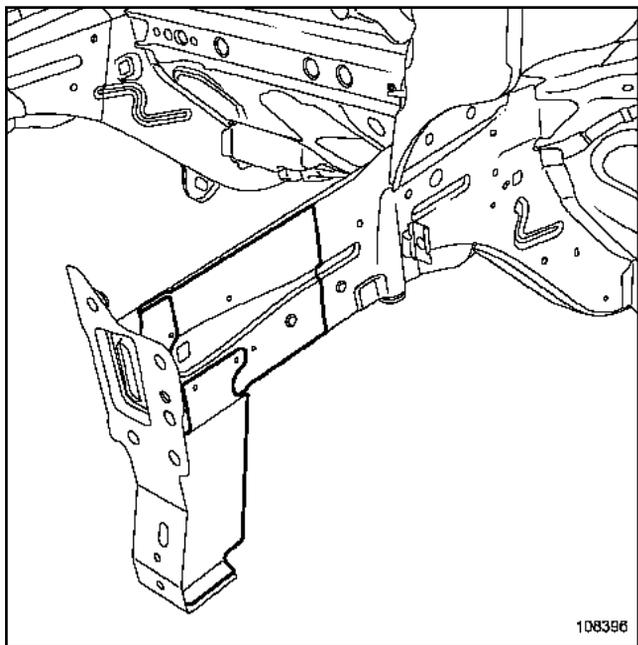
B84 or C84



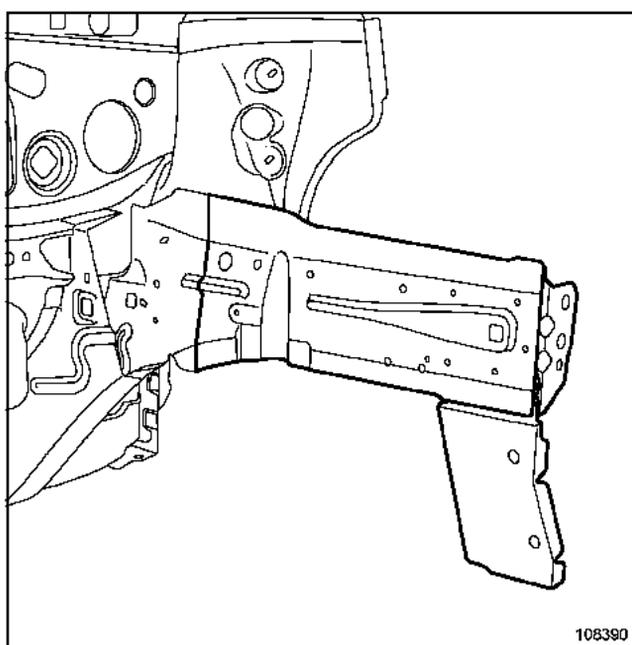
108391
108391



108392
108392



108396
108396



108390
108390

2 - 2 - Cut 2:

The cut is made along the butt weld.

III - ASSEMBLY INSTRUCTIONS FOR A PARTIAL REPLACEMENT

Only the connecting pieces relevant to partial replacement by cutting are shown.

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

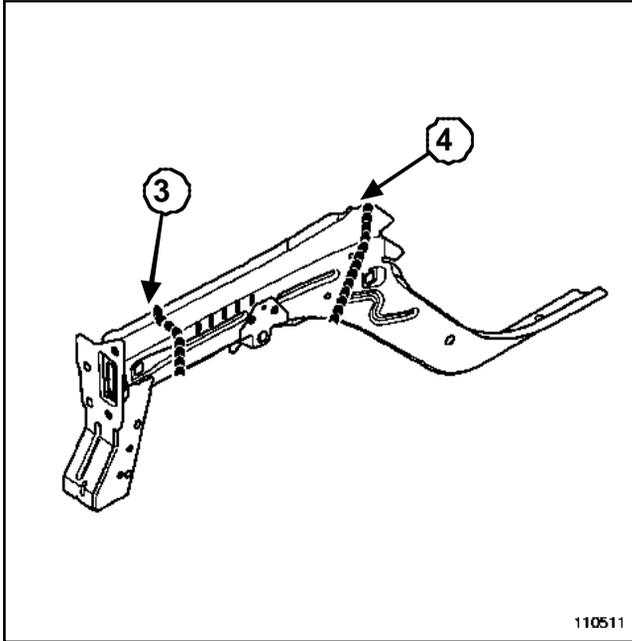
FRONT LOWER STRUCTURE

Front side member: General description

41A

B84 or C84

If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400, 40A, General Information**).



110511

Lines (3) and (4) of the diagram show a butt weld by continuous MAG welding.

Weld (4) along the butt weld line.

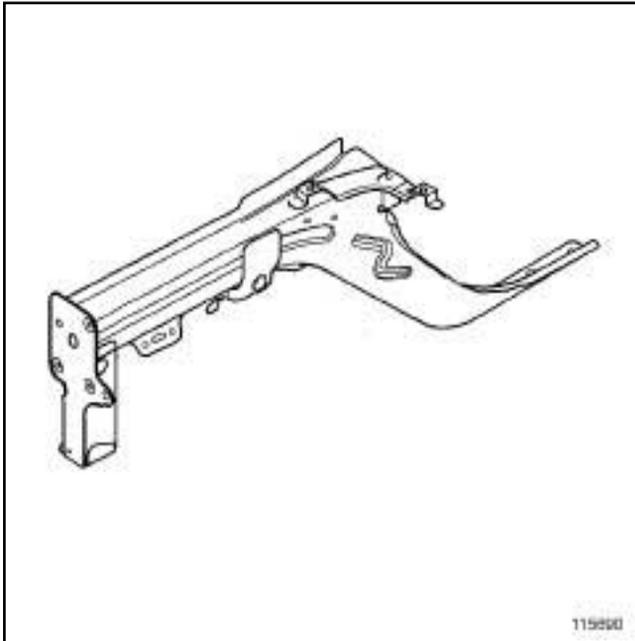
FRONT LOWER STRUCTURE

Front side member: Description

41A

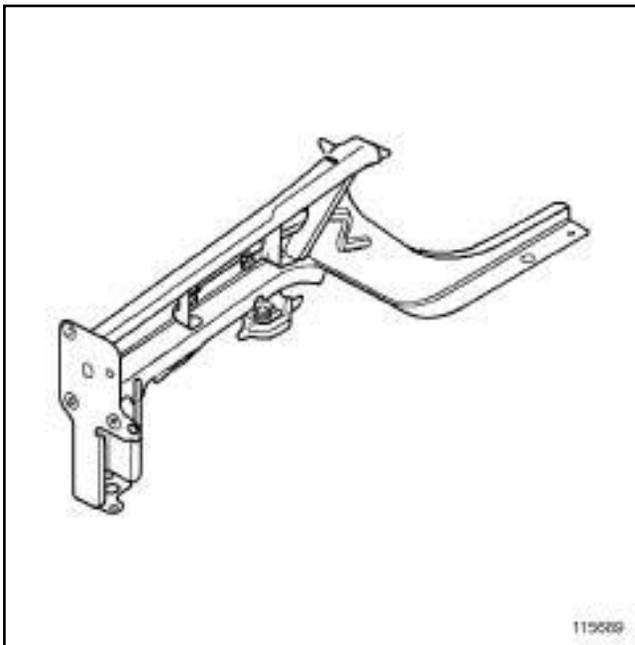
B84 or C84

Right-hand side



115690

Left-hand side



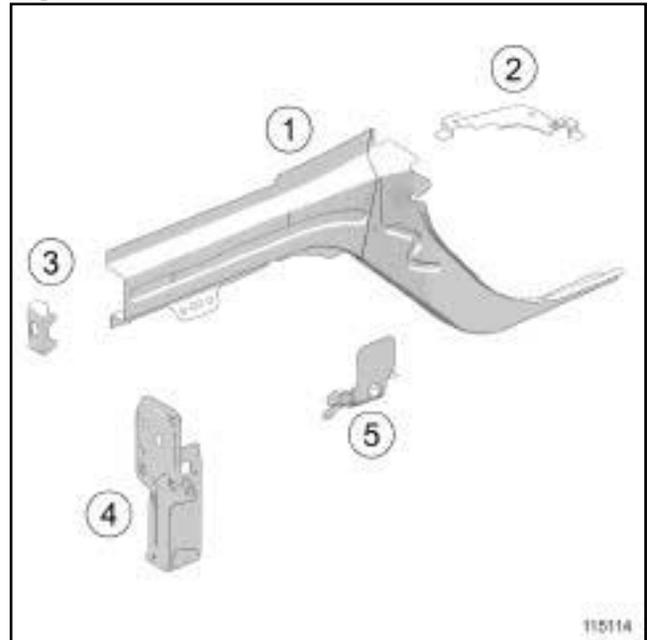
115689

The options for replacing this part are as follows:

- partial replacement of the front section,
- partial replacement.

I - COMPOSITION OF THE SPARE PART

Right-hand side



115114

Left-hand side



115115

FRONT LOWER STRUCTURE

Front side member: Description

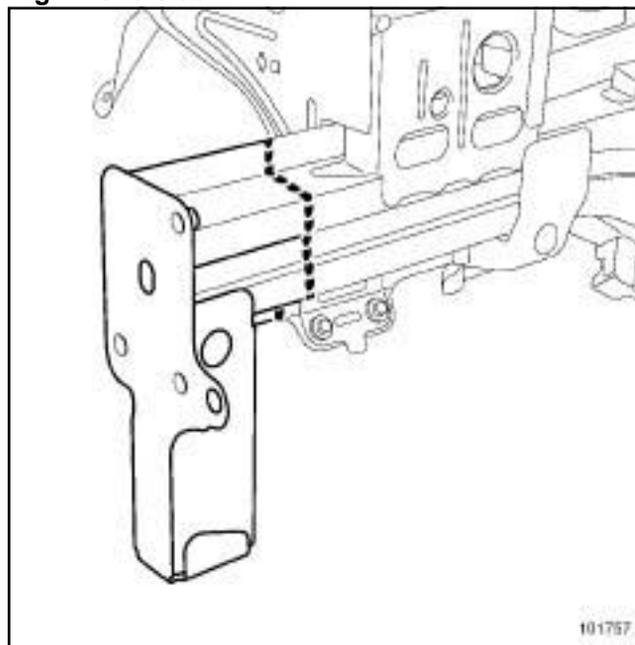
41A

B84 or C84

II - PART FITTED

1 - Partial replacement of the front section

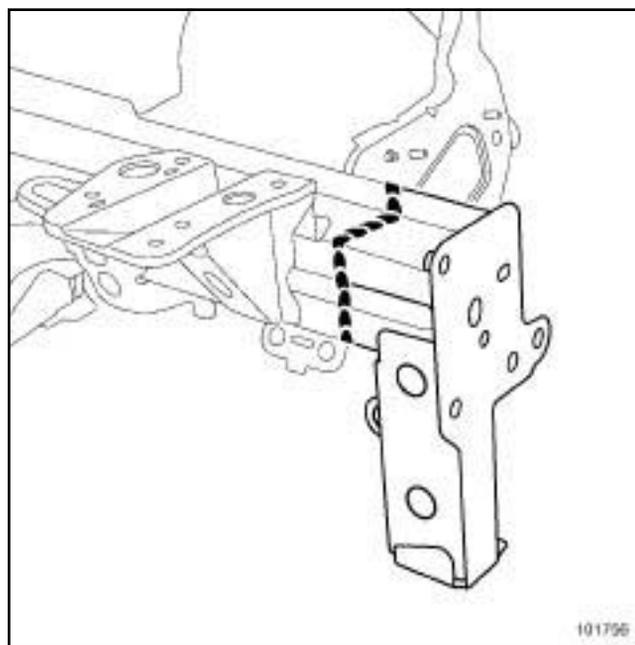
Right-hand side



101757

101757

Left-hand side



101756

101756

Mark	Description	Type	Thickness (mm)
(1)	Front section of front side member	HLE/THLE	1.7/2.5
(2)	Bulkhead cross member right-hand bracket	-	1.5
(3)	Stiffener unit for end of side member	VHLE	1.8
(4)	Impact absorber mounting unit	HLE/THLE	1.2/3
(5)	Sub-frame mounting unit	HLE	1.8/3
(6)	Front side member reinforcement	HLE	1.5
(7)	Reinforcement for gearbox on side member	-	1.5
(8)	Side plate mounting reinforcement	-	1.7

FRONT LOWER STRUCTURE

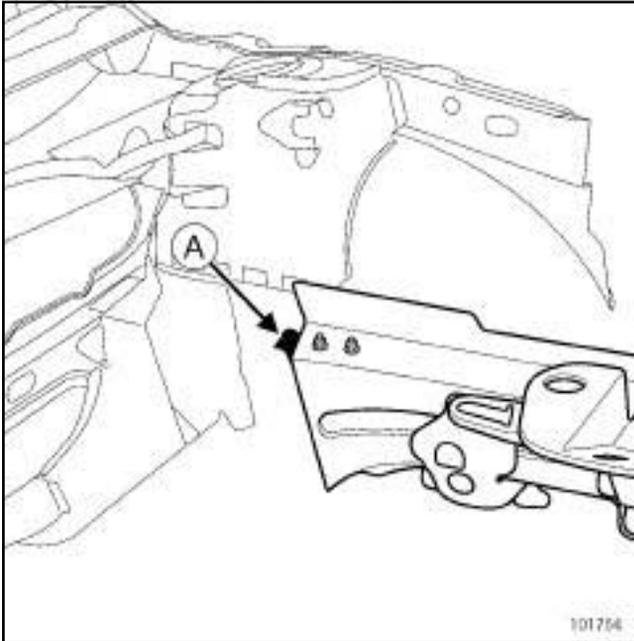
Front side member: Description

41A

B84 or C84

2 - Partial replacement

Preparation of the replacement part

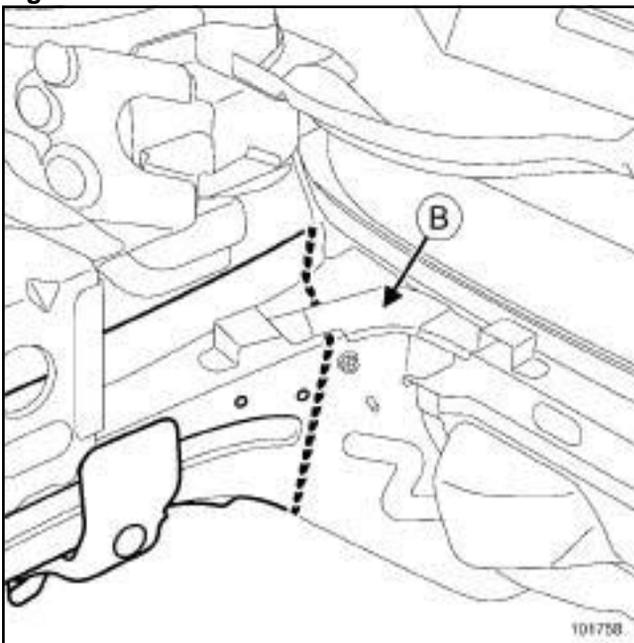


101754
101754

Note:

When cutting, be careful not to damage the rear inner reinforcement (A) .

Right-hand side



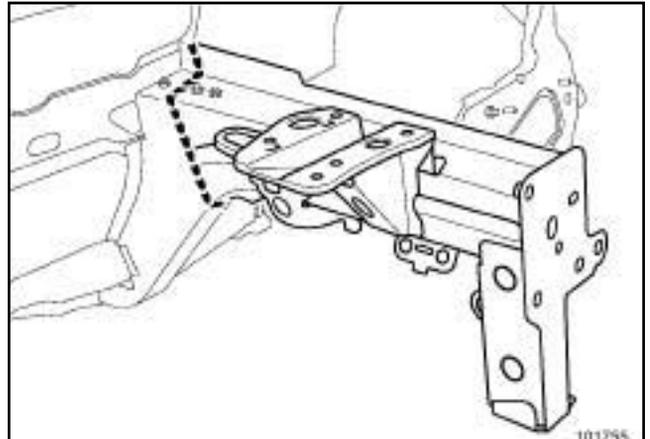
101758
101758

To make the cut, unclip the connecting bracket (B) .

Note:

Do not reuse the connecting bracket previously removed, a new one is available from the **Parts Department** .

Left-hand side

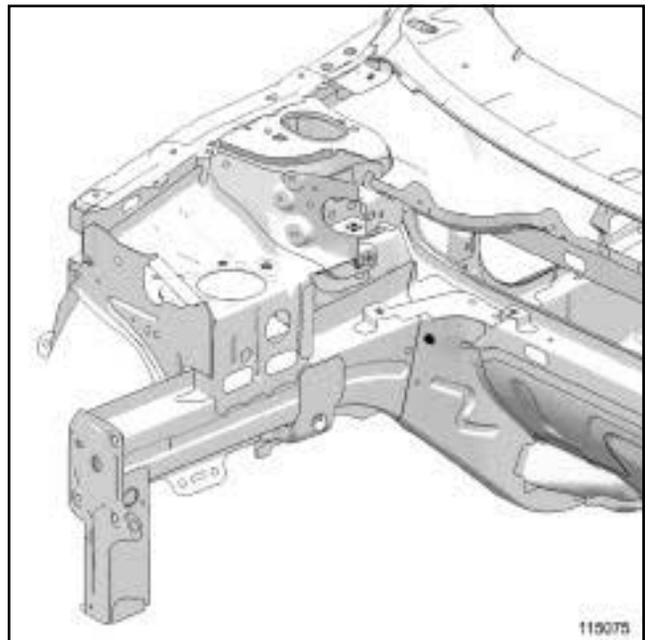


101755
101755

WARNING

The position of this cut must be observed, and is determined according to the position of the internal reinforcements cut or the acoustic inserts.

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



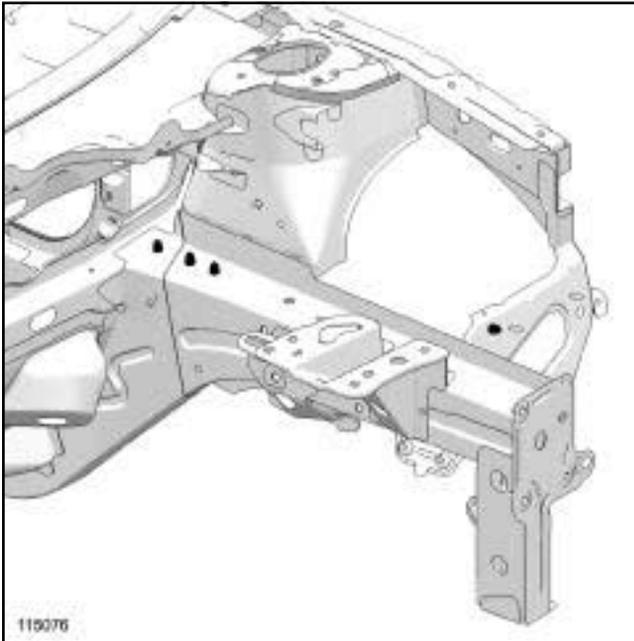
115075
115075

FRONT LOWER STRUCTURE

Front side member: Description

41A

B84 or C84



115076

IMPORTANT

To avoid damaging the vehicle's electric and electronic components, the battery and the earths of any wiring harness near the weld area must be disconnected.

The earth of the welding machine must be placed as close as possible to the weld area.

B84 or C84

WARNING

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the subsection dealing with the component.

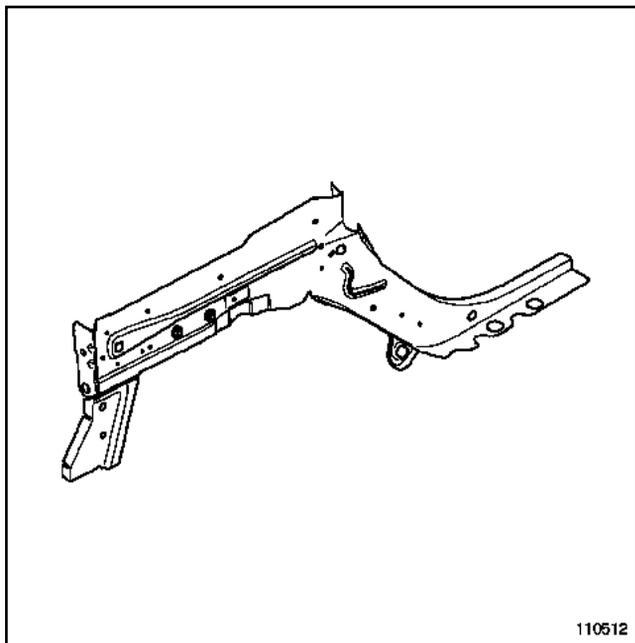
IMPORTANT

The straightening bench must be used.

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information**.

I - DESIGN OF THE STRUCTURAL COMPONENT



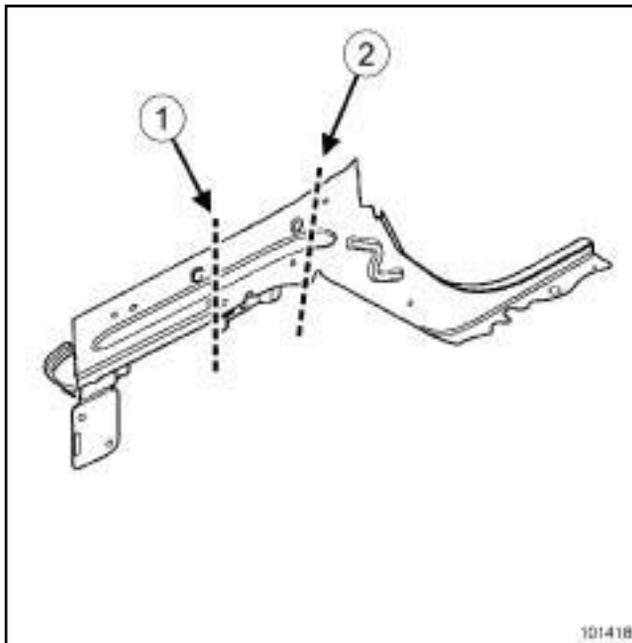
110512

The special feature of this type of part is that it combines the functions of both the front section and rear section of the front side member closure panel and that it is made of two different kinds of panels of different thicknesses assembled by laser butt welding.

II - AREA TO BE CUT FOR PARTIAL REPLACEMENT

Note:

For the partial replacement of parts constituting a single structural component, it is essential to stagger the welds of each of the components.



101418

1 - Cut 1:

This line shows the centre of the area in which it is possible to carry out a partial replacement.

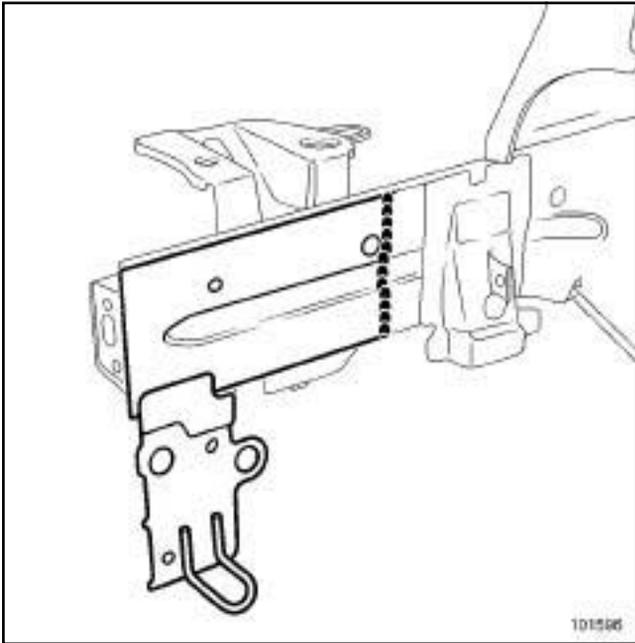
This operation allows you to access the inside of the hollow section of the structural component to straighten it.

FRONT LOWER STRUCTURE

41A

Front section of front side member closure panel: General description

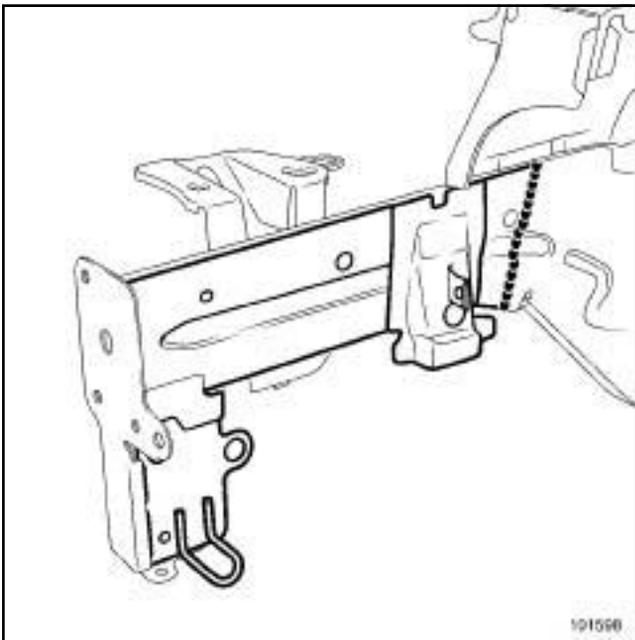
B84 or C84



101596

2 - Cut 2:

The cut must be made on the butt weld.



101598

III - ASSEMBLY INSTRUCTIONS FOR A PARTIAL REPLACEMENT

In this case, the side member weld line must be staggered from that of its closure panel.

Note:

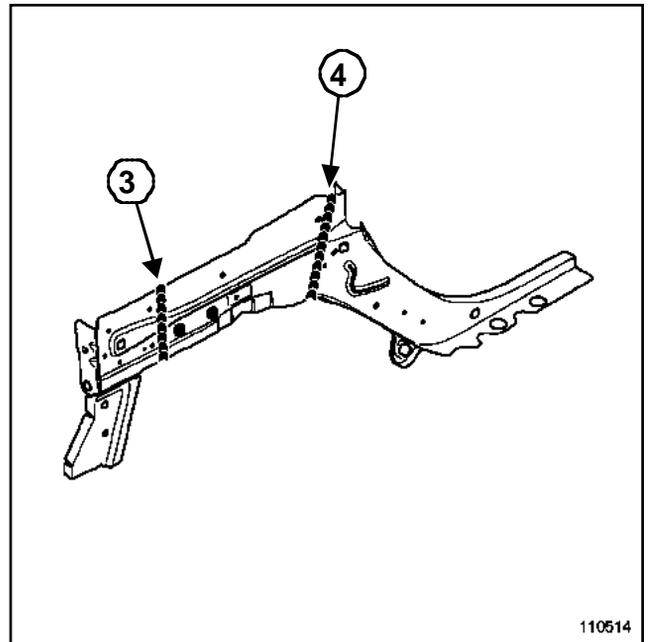
For the partial replacement of parts constituting a single structural component, it is essential to stagger the welds of each of the components.

Only the connecting pieces relevant to partial replacement by cutting are shown.

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

For other issues of access to mating faces, the various replacement options are described in the structural bodywork repair basics (see **MR 400, 40A, General information**).



110514

Lines (3) and (4) of the diagram show a butt weld by continuous MAG welding.

Weld (4) along the butt weld line.

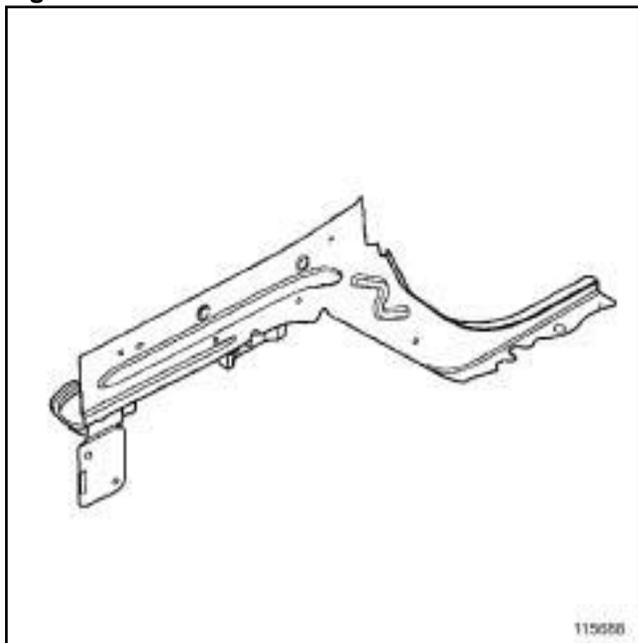
FRONT LOWER STRUCTURE

41A

Front section of front side member closure panel: Description

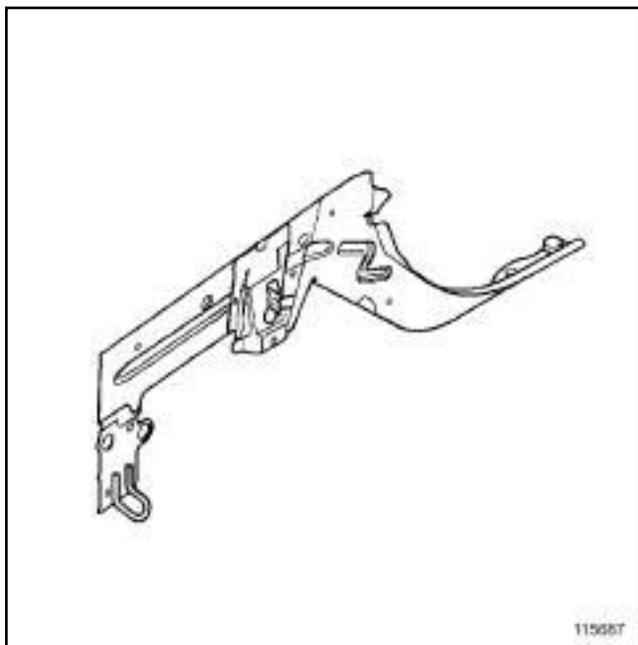
B84 or C84

Right-hand side



115688

Left-hand side



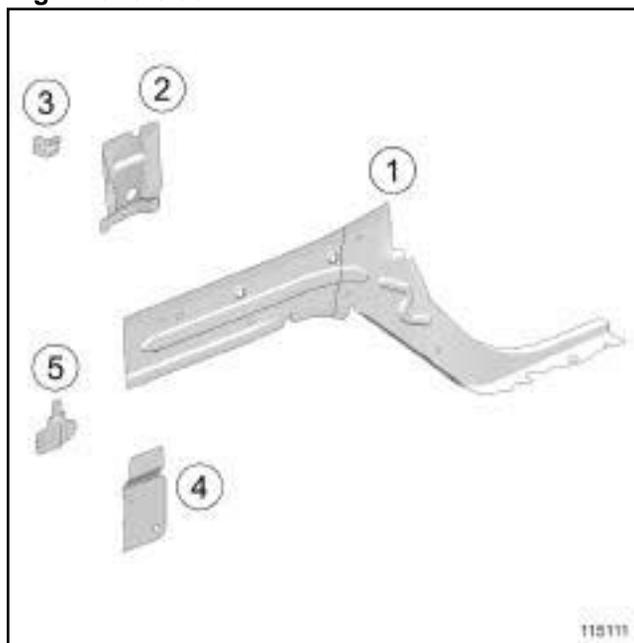
115687

The options for replacing this part are as follows:

- partial replacement of the front section: this operation complements straightening the radiator cross member mounting,
- partial replacement: this operation complements the partial replacement of the front side member,

I - COMPOSITION OF THE SPARE PART

Right-hand side



115111

Left-hand side



115112

FRONT LOWER STRUCTURE

41A

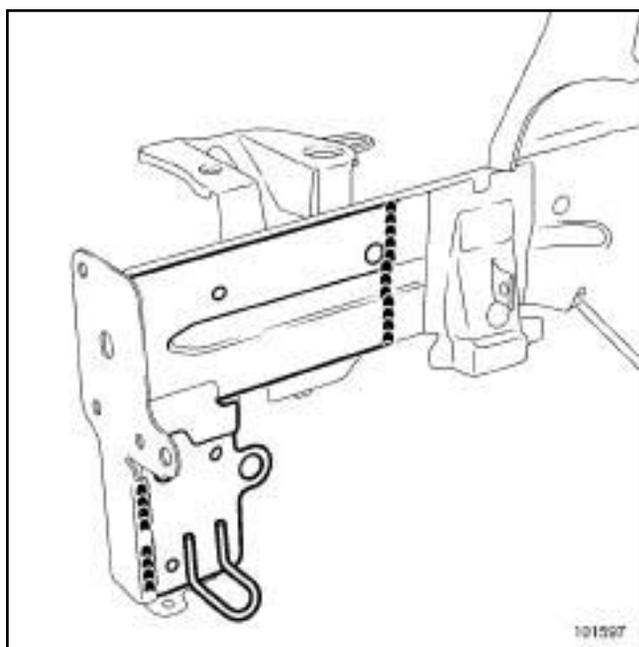
Front section of front side member closure panel: Description

B84 or C84

Mark	Description	Type	Thickness (mm)
(1)	Side member closure panel	HEL/THLE	1.7/2.5
(2)	Front assembly mounting unit closure panel component	HEL	1.8
(3)	Brake hose stop bracket	-	2
(4)	Additional unit interior closure panel component	HEL	1.2
(5)	Washer fluid reservoir mounting	HEL	2
(6)	Interior closure panel component	HEL	1.5
(7)	Front towing ring	-	-

II - PART FITTED

1 - Partial replacement of the front section

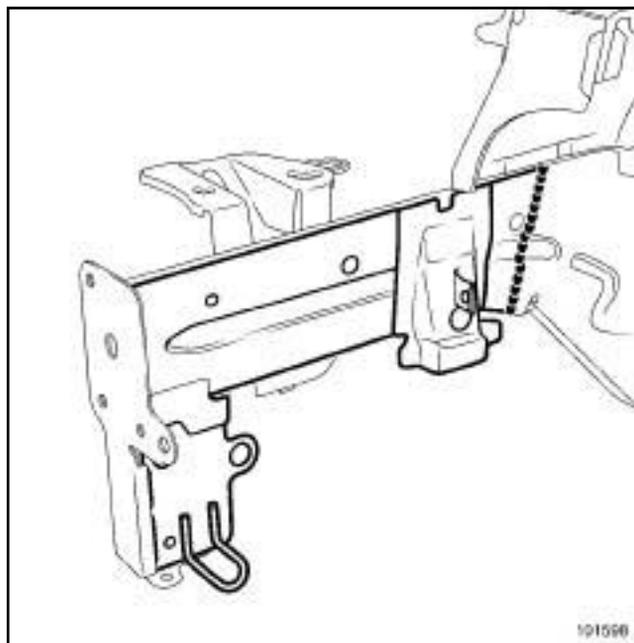


101597

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

2 - Partial replacement



101598

WARNING

Do not move the position of this weld as it is determined by the position of the linings, reinforcements or expanding inserts.

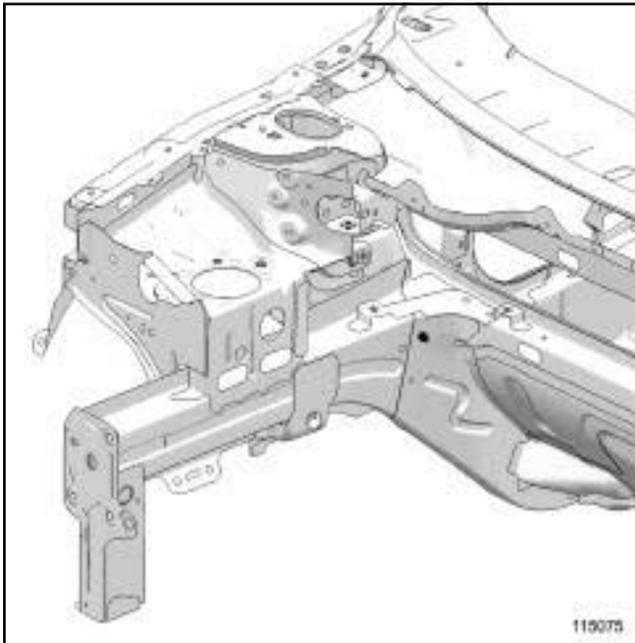
FRONT LOWER STRUCTURE

41A

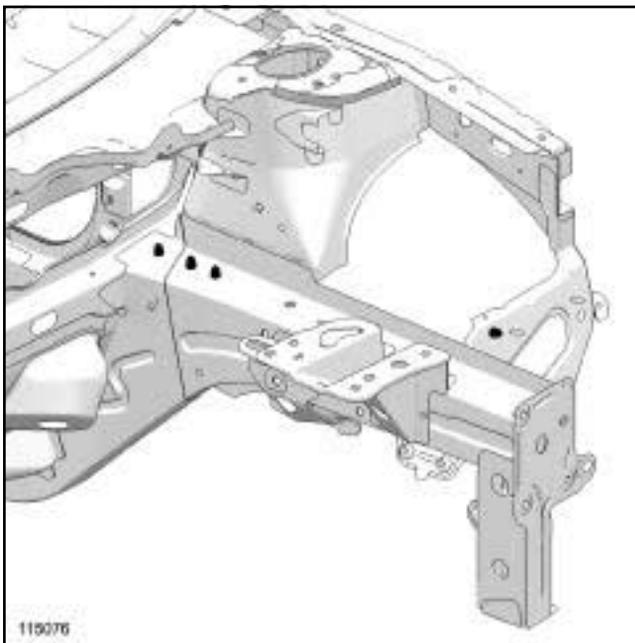
Front section of front side member closure panel: Description

B84 or C84

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



115075



115076

IMPORTANT

To avoid damaging the vehicle's electric and electronic components, the battery and the earths of any wiring harness near the weld area must be disconnected.

The earth of the welding machine must be placed as close as possible to the weld area.

FRONT LOWER STRUCTURE

Battery tray support: General description

41A

B84 or C84

WARNING

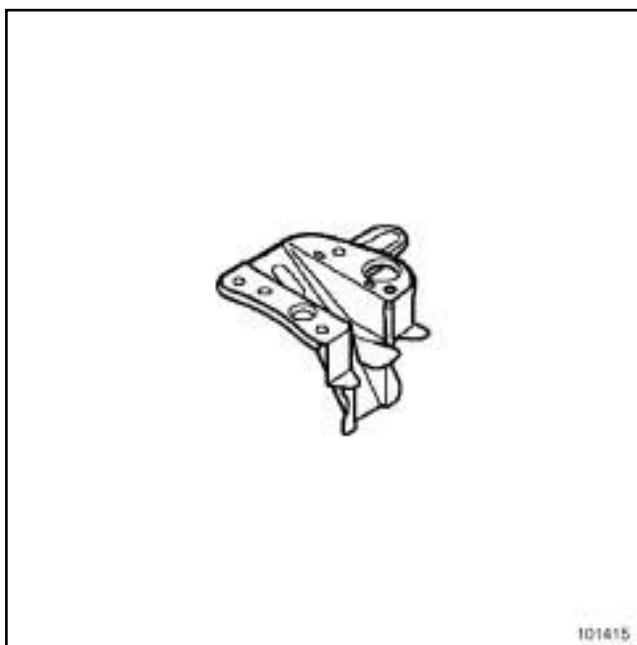
The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information**.

DESIGN OF THE STRUCTURAL COMPONENT



101415

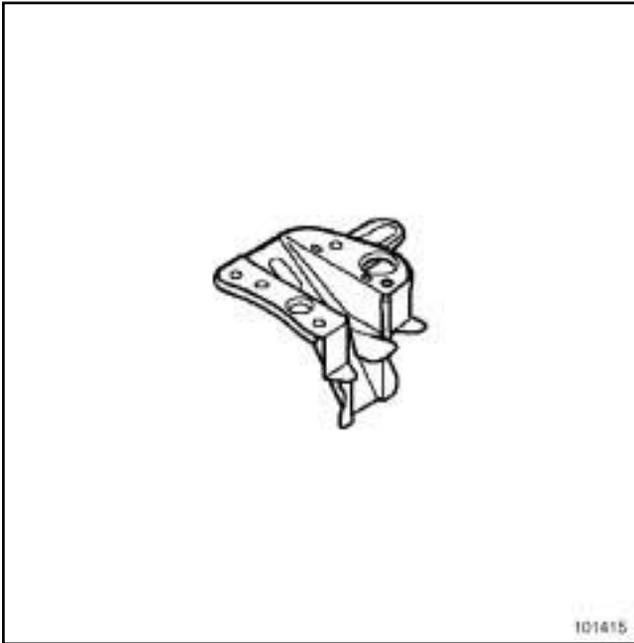
This part functions only as a battery tray bracket. It is welded to the vehicle structure.

FRONT LOWER STRUCTURE

Battery tray support: Description

41A

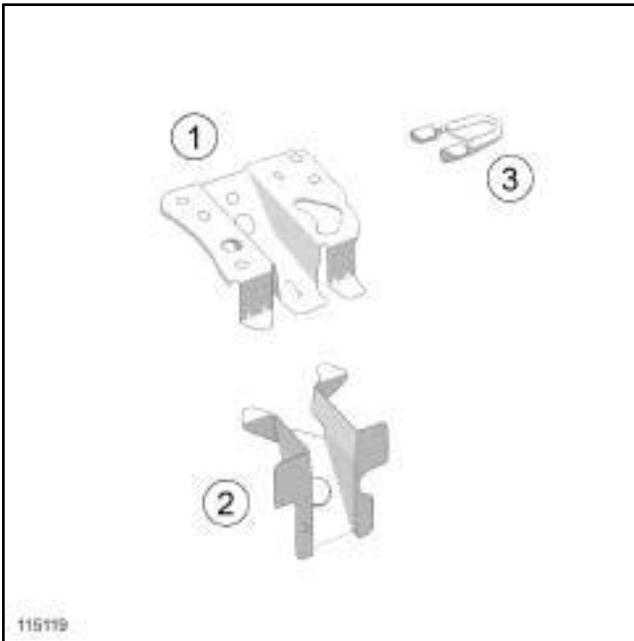
B84 or C84



101415
101415

There is only one way of replacing this part:
- complete replacement.

I - COMPOSITION OF THE SPARE PART

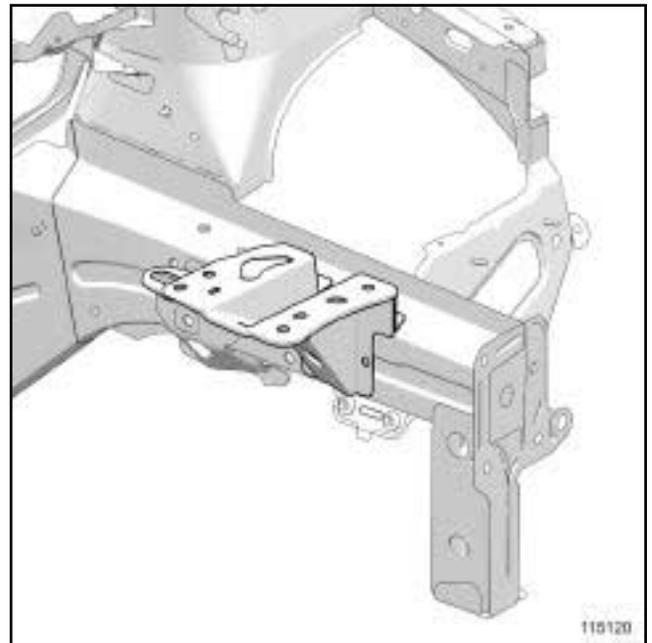


115119
115119

Mark	Description	Type	Thickness (mm)
(1)	Battery tray upper section	-	2
(2)	Battery tray lower section	-	1.5
(3)	Air filter retaining bracket	-	1.2

II - PART FITTED

Complete replacement



115120
115120

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

B84 or C84

WARNING

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

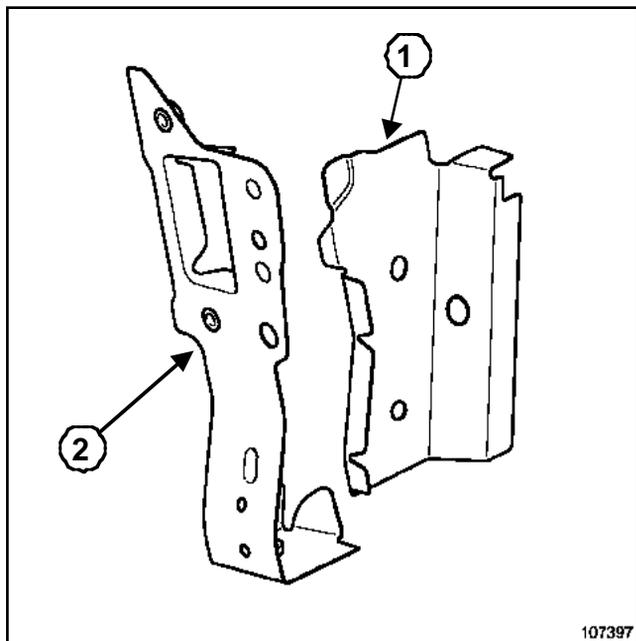
IMPORTANT

The straightening bench must be used.

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information** .

DESIGN OF THE STRUCTURAL COMPONENT



107397

It is composed of the following components:

- cross member mounting component (1) ,
- mounting support unit (2) .

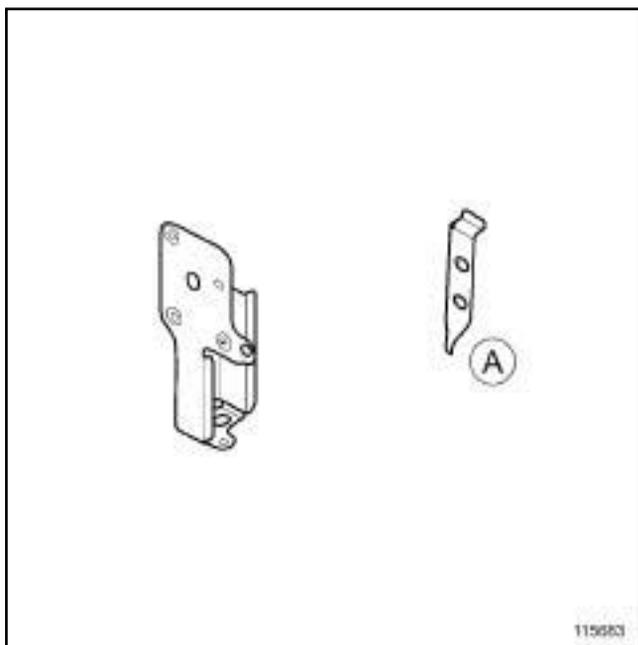
This part acts as:

- a radiator cross member support,
- front end cross member support,

- front end panel support.

Radiator cross member support: Description

B84 or C84



115683

To replace this part, order an additional connecting bracket (A) .

There is only one way of replacing this part:

- complete replacement.

Note:

A straightening bench is essential when simultaneously replacing the left-hand and right-hand parts.

I - COMPOSITION OF THE SPARE PART



115108

115108

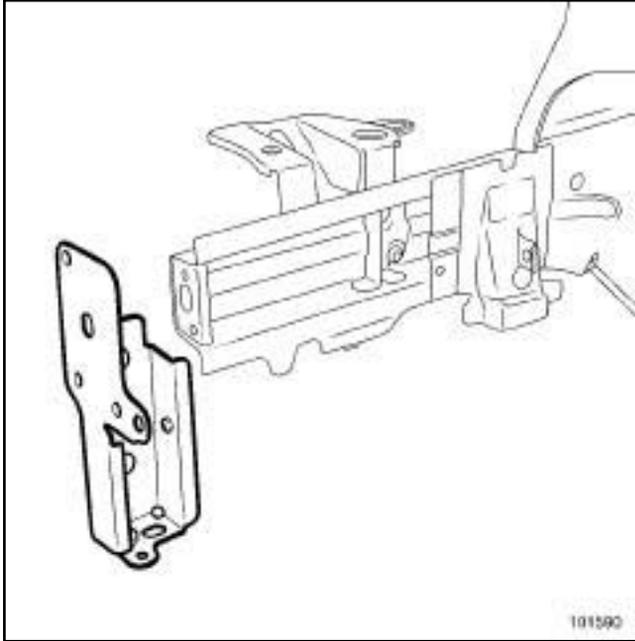
Mark	Description	Type	Thickness (mm)
(1)	Radiator cross member mounting unit	HEL	1.2
(2)	Radiator cross member mounting closure panel	HEL	2.5

Radiator cross member support: Description

B84 or C84

II - PART FITTED

Complete replacement

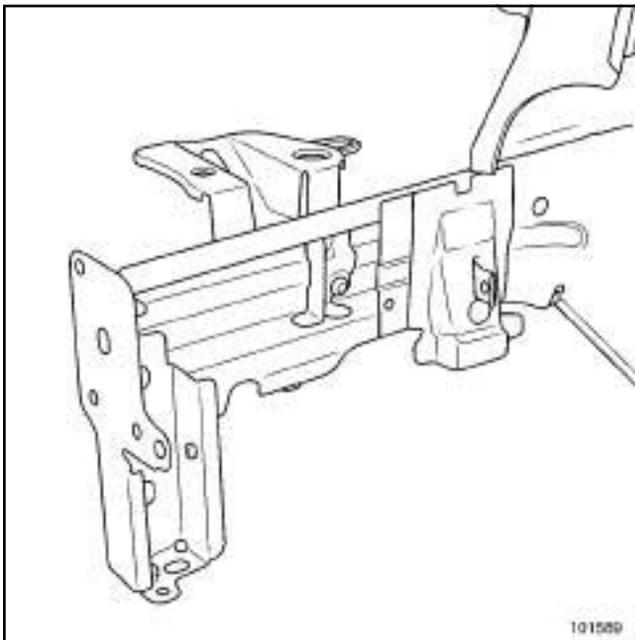


101590

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

III - STRAIGHTENING



101589

Note:

When straightening a radiator cross member mounting, the side member closure panel can be partially replaced to access the damaged area.

B84 or C84

WARNING

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

IMPORTANT

The straightening bench must be used.

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information**.

DESIGN OF THE STRUCTURAL COMPONENT



101422

This is a basic part; it functions only as a front mounting of front sub-frame.

Front mounting of front sub-frame: Description

B84 or C84

There is only one way of replacing this part:

- complete replacement.

Note:

The straightening bench must be used.

I - COMPOSITION OF THE SPARE PART

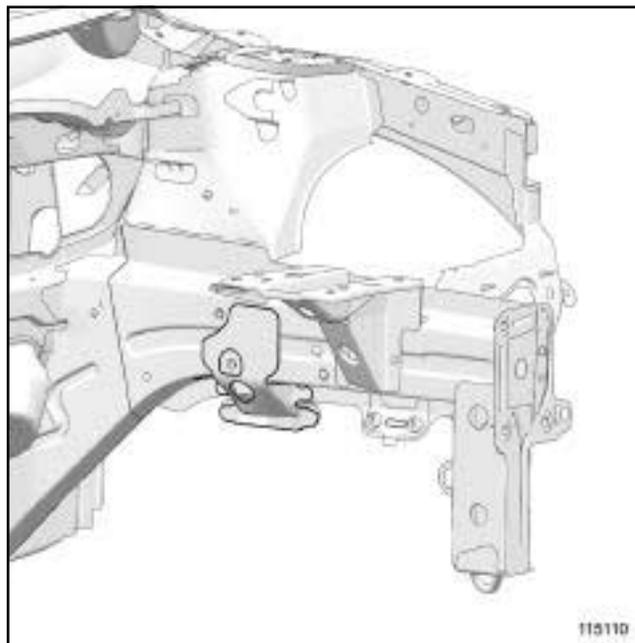


101422

101422

II - PART FITTED

complete replacement



115110

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

Mark	Description	Type	Thickness (mm)
(1)	Front mounting of front sub-frame	HEL	1.8

FRONT LOWER STRUCTURE

Engine mounting: General description

41A

B84 or C84

WARNING

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading this general information, check that there are no special notes associated with this vehicle. These special features will be specified if applicable in other parts of this sub-section dealing with the part.

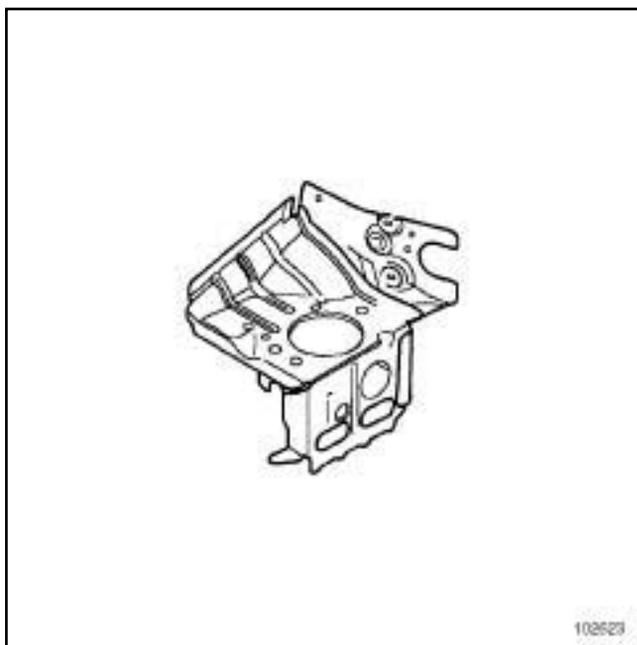
IMPORTANT

The straightening bench must be used.

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information**.

DESIGN OF THE STRUCTURAL COMPONENT



102623

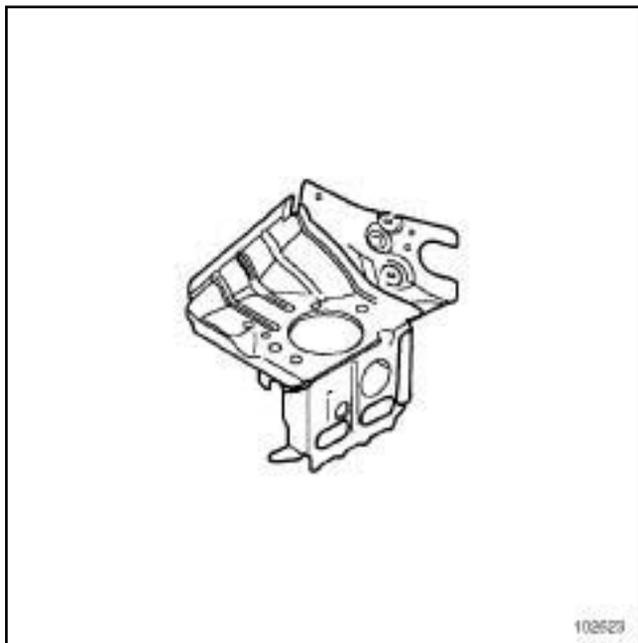
This is a basic part; it only functions as an engine mounting.

FRONT LOWER STRUCTURE

Engine mounting: Description

41A

B84 or C84



102623

102623

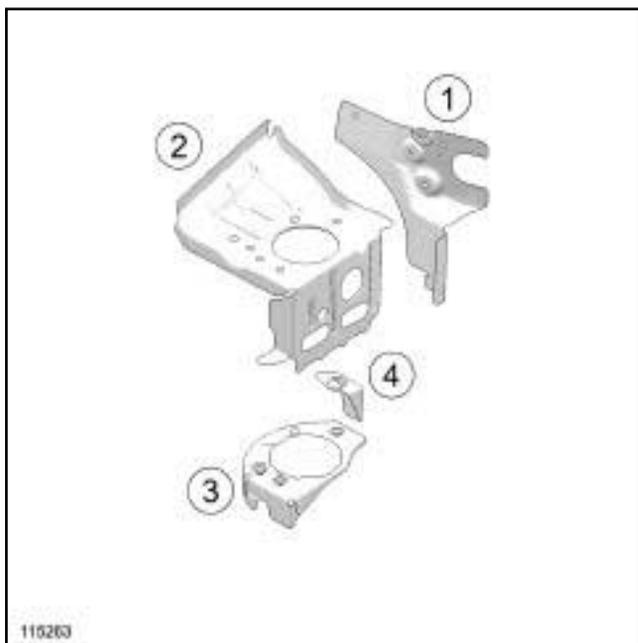
There is only one way of replacing this part:

- complete replacement: this operation complements the replacement of the scuttle panel for a frontal impact and the partial replacement of the front side member and front wheel arch for a right-hand side impact.

Note:

The straightening bench must be used.

I - COMPOSITION OF THE SPARE PART



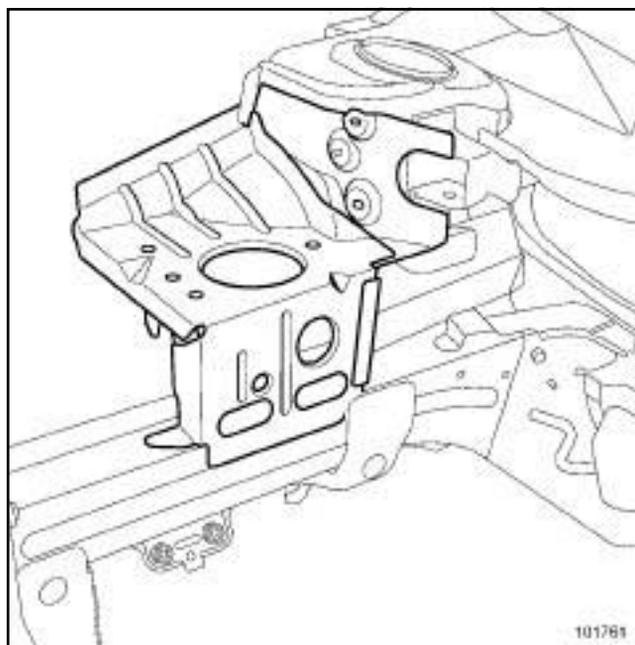
115263

115263

Mark	Description	Type	Thickness (mm)
(1)	Engine mounting rear section	HEL	1.5
(2)	engine mounting upper section	HEL	2
(3)	Engine mounting height adjuster reinforcement	-	2
(4)	Engine mounting rear reinforcement	-	2

II - PART FITTED

Complete replacement



101781

101761

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

B84 or C84

WARNING

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

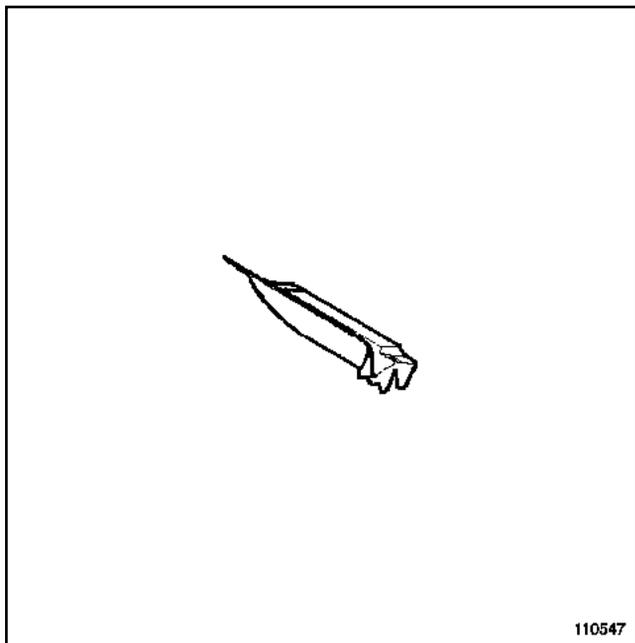
Before reading this general information, check that there are no special notes associated with this vehicle. These special features will be specified if applicable in other parts of this sub-section dealing with the part.

IMPORTANT

The straightening bench must be used.

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information**.

DESIGN OF THE STRUCTURAL COMPONENT

110547

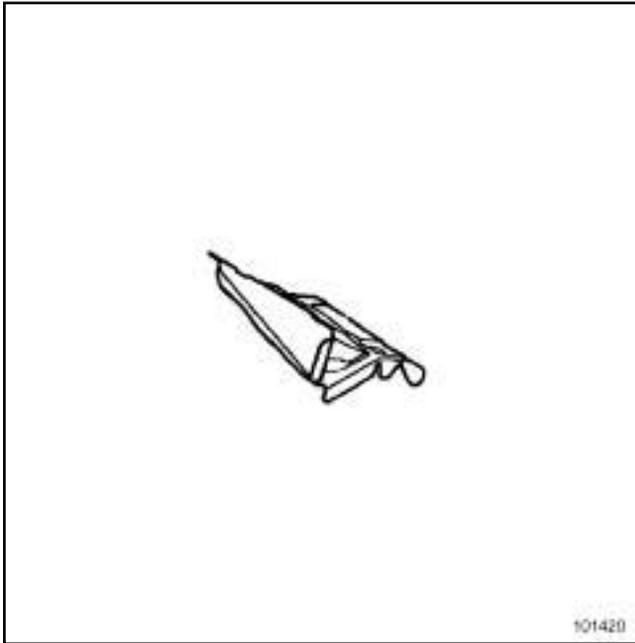
This is a basic part; its only function is that of a front sub-frame rear cross member.

FRONT LOWER STRUCTURE

Sub-frame rear mounting: Description

41A

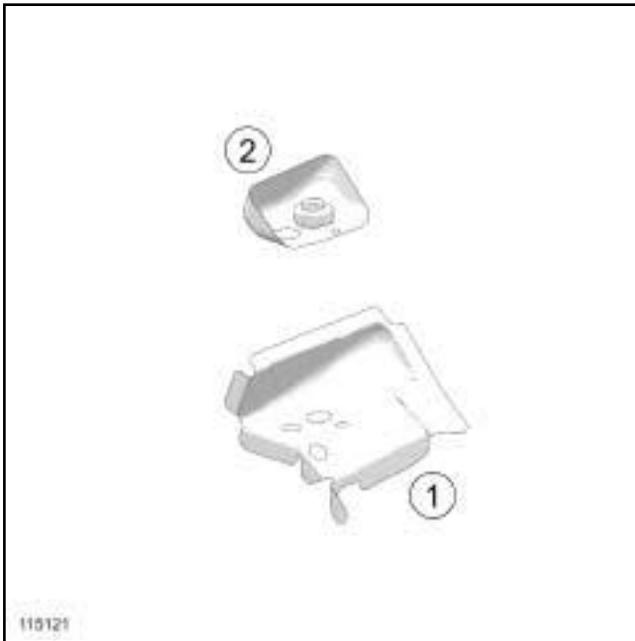
B84 or C84



101420
101420

There is only one way of replacing this part:
- complete replacement.

I - COMPOSITION OF THE SPARE PART

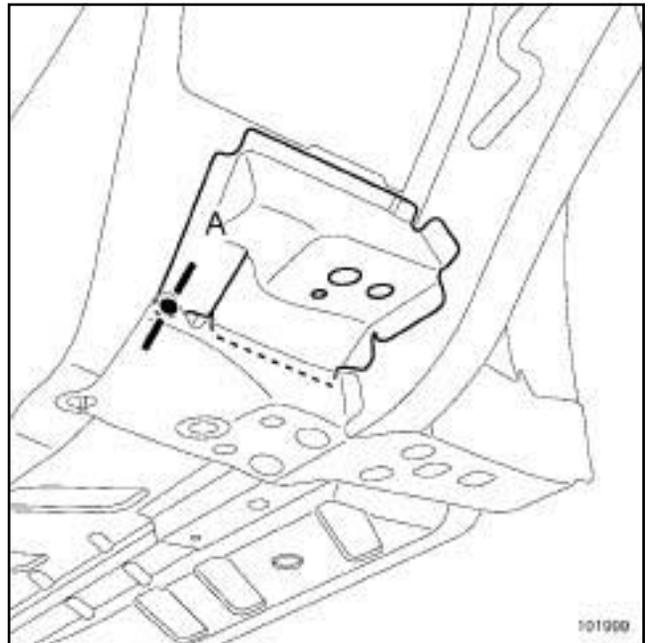


115121
115121

Mark	Description	Type	Thickness (mm)
(1)	Sub-frame rear mounting	HEL	2
(2)	Sub-frame rear mounting reinforcement	THLE	3

II - PART FITTED

Complete replacement



101999
101999

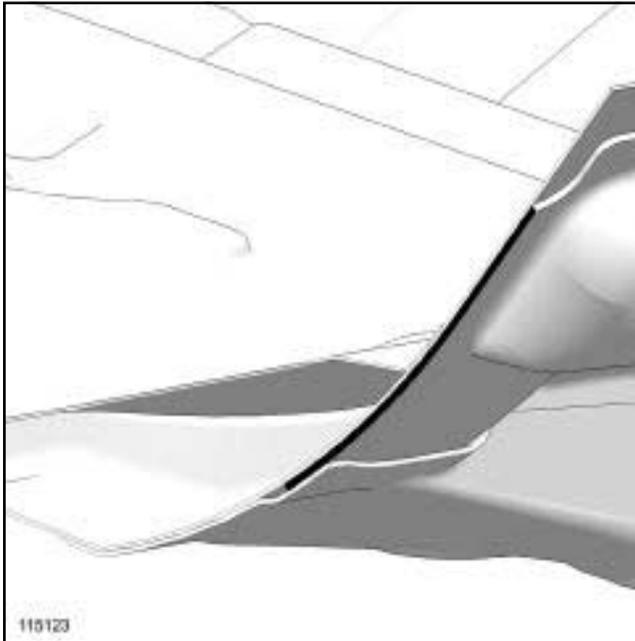
FRONT LOWER STRUCTURE

Sub-frame rear mounting: Description

41A

B84 or C84

Cut A



115123

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

FRONT LOWER STRUCTURE

Front half unit: General description

41A

B84 or C84

WARNING

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

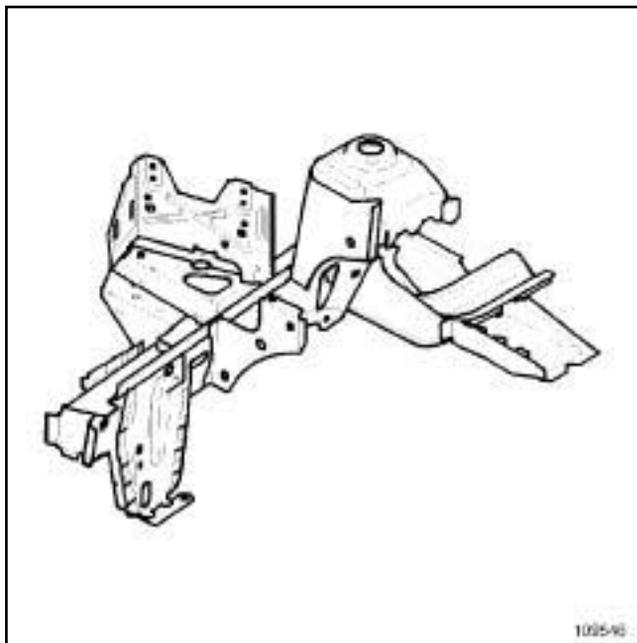
IMPORTANT

The straightening bench must be used.

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information**.

DESIGN OF THE STRUCTURAL COMPONENT



109546

The special feature of this type of part is that it acts simultaneously as front side member, front wheel arch, centre floor front side cross member and front end side cross member and is composed of several different kinds of panels of different thicknesses.

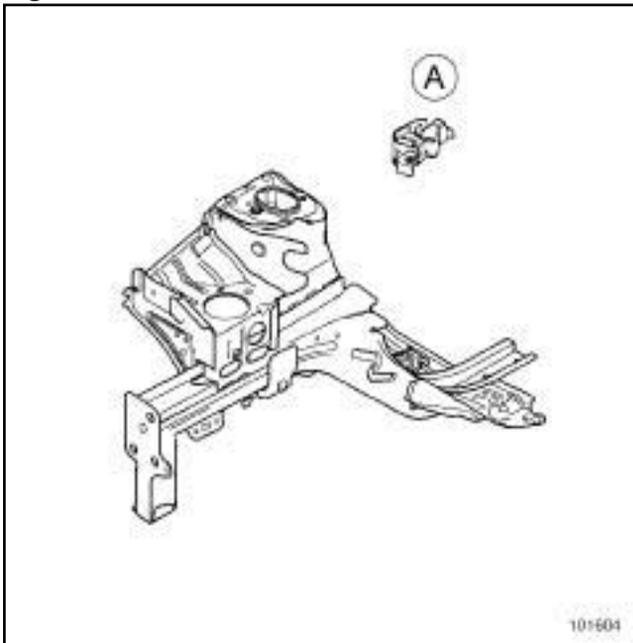
FRONT LOWER STRUCTURE

Front half unit: Description

41A

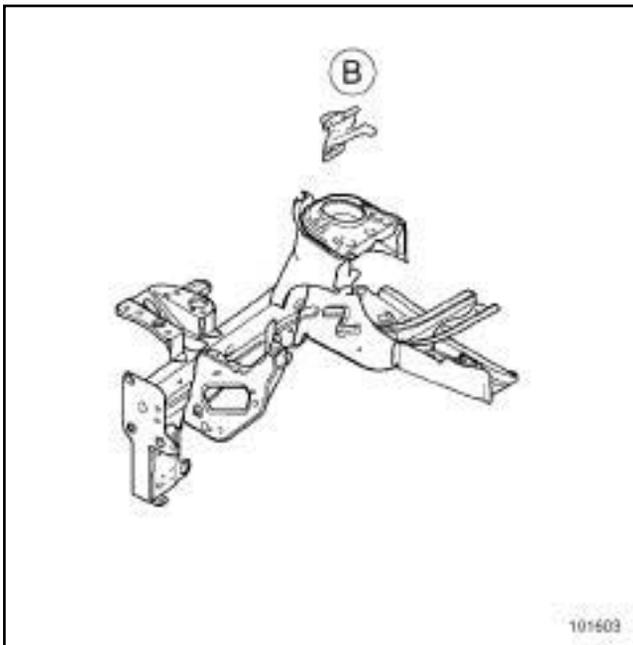
B84 or C84

Right-hand side



101604

Left-hand side



101603

To replace this part, order an additional engine tie-bar mounting (A) or connecting bracket (B) depending on the impact side.

There is only one way of replacing this part:

- complete replacement.

FRONT LOWER STRUCTURE

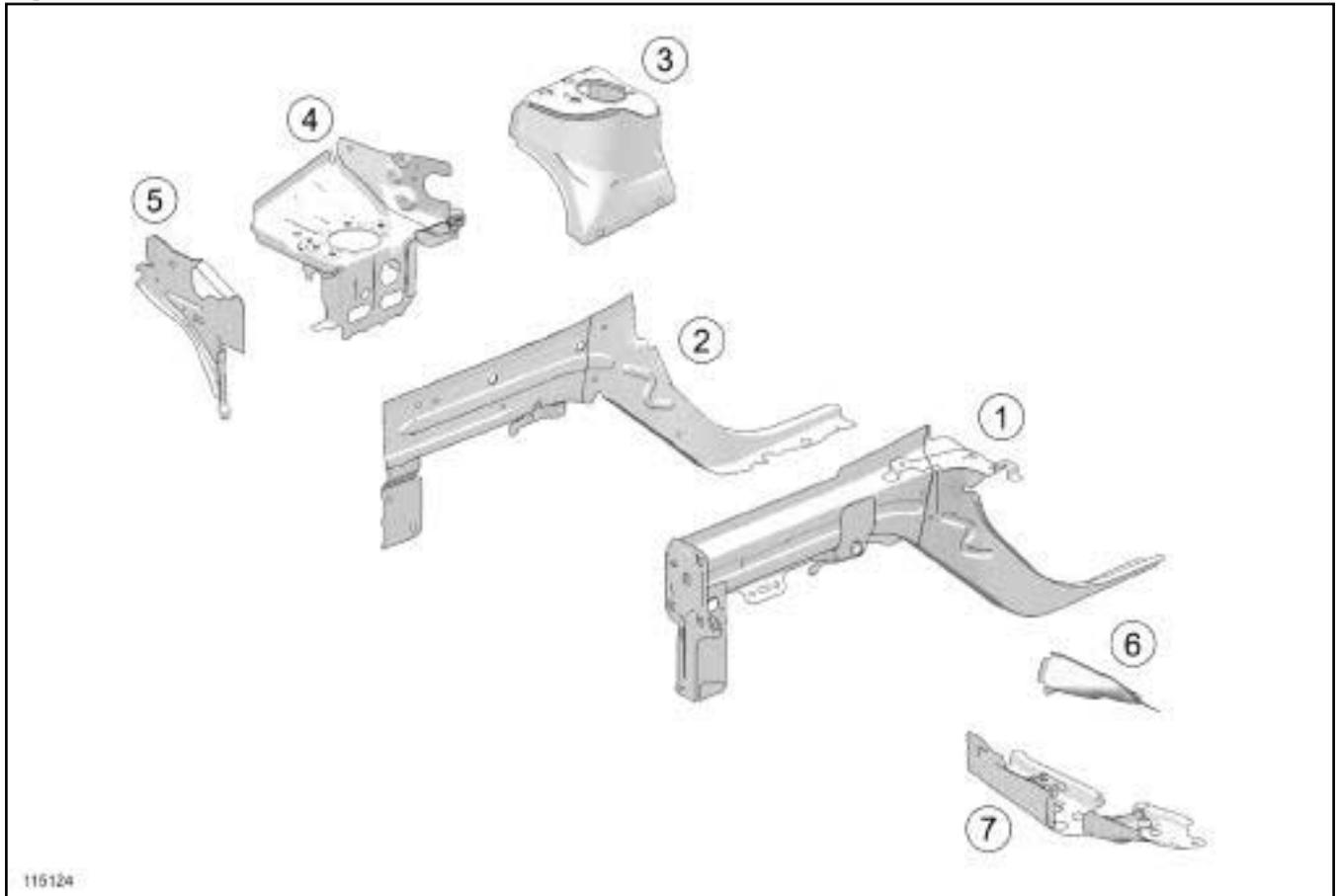
Front half unit: Description

41A

B84 or C84

I - COMPOSITION OF THE SPARE PART

Right-hand side



115124

115124

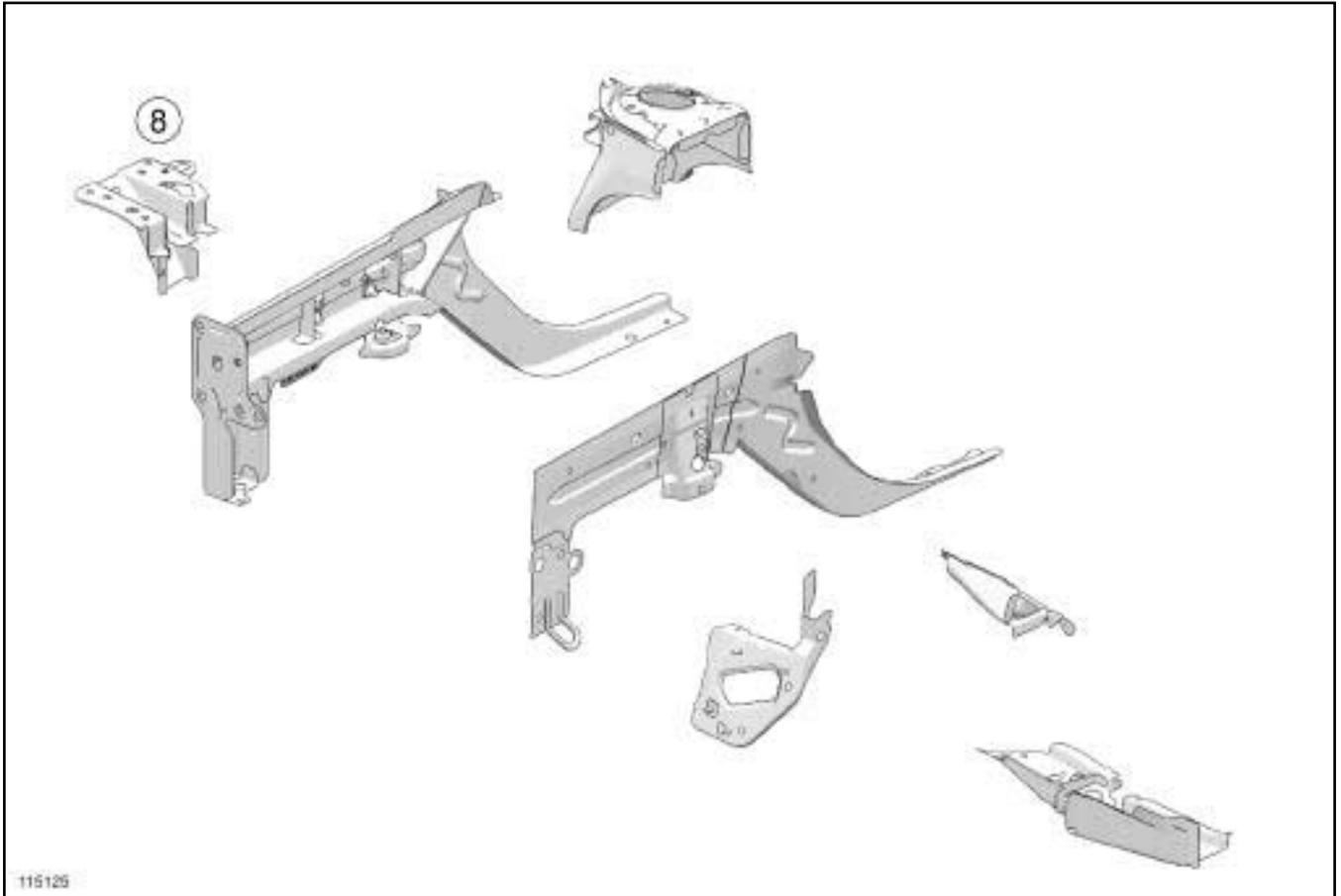
FRONT LOWER STRUCTURE

Front half unit: Description

41A

B84 or C84

Left-hand side

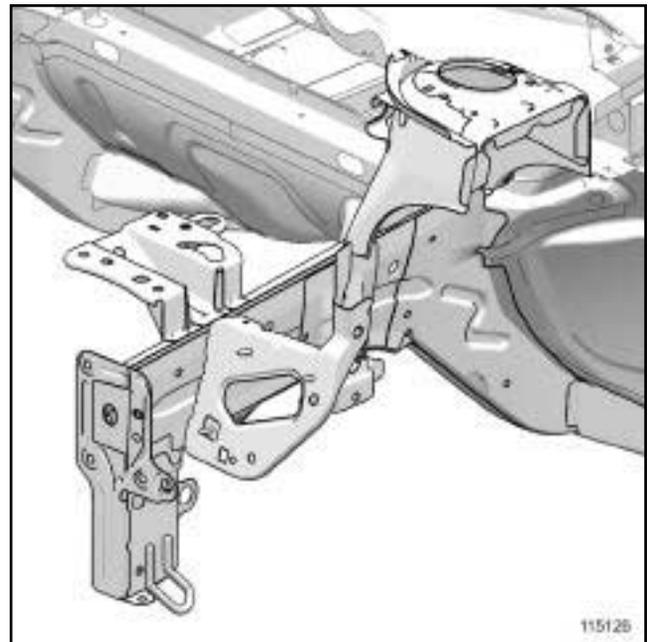


115125

115125

II - PART FITTED

Complete replacement



115125

115126

Mark	Description	Type	Thickness (mm)
(1)	Front side member	HEL/THLE	1.5/3
(2)	Front section of front side member closure panel	HEL/THLE	1.2/2.5
(3)	Front wheel arch	HEL	1.1/2
(4)	Engine support	HEL	1.5/2
(5)	Front end side cross member	HEL	1.5
(6)	Sub-frame rear mounting	HEL/THLE	2/3
(7)	Centre floor front side cross member	HEL/THLE	1.2/3
(8)	Battery tray bracket	-	1.5/2

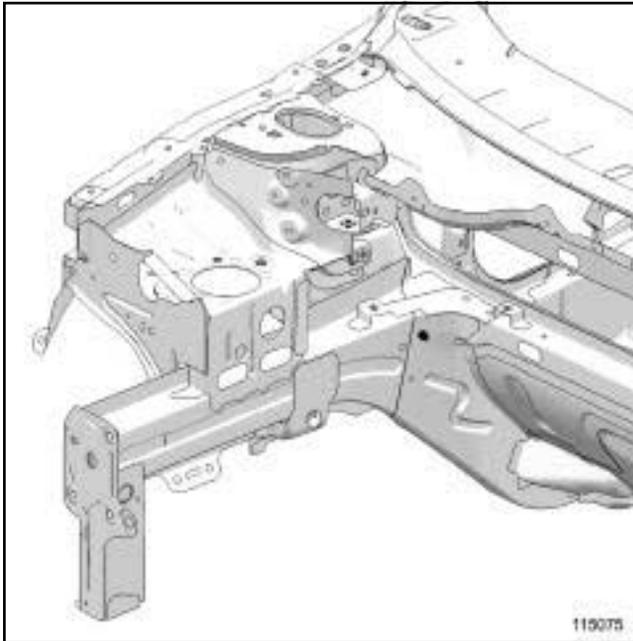
B84 or C84

IMPORTANT

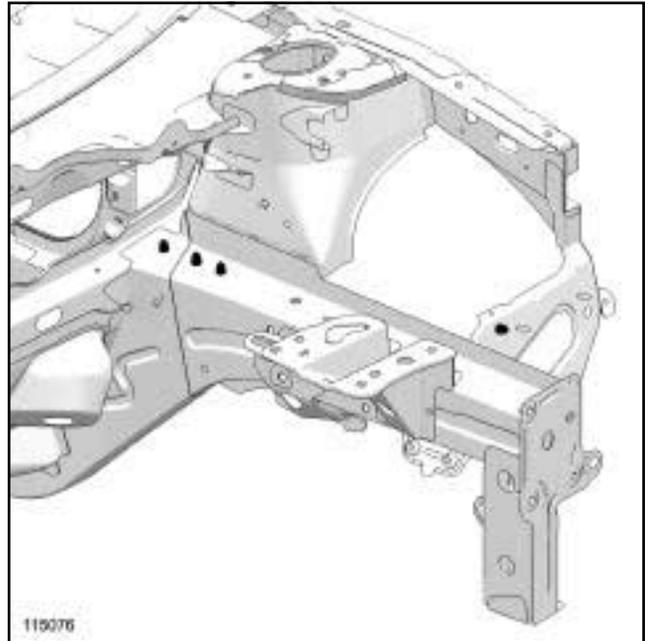
For welded connections in three thicknesses, the spot welds on the part replaced should be made in the same place as for the original joint to retain its mechanical properties.

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

III - POSITIONING OF LOCAL ELECTRICAL EARTHS

115075



115076

IMPORTANT

To avoid damaging the vehicle's electric and electronic components, the battery and the earths of any wiring harness near the weld area must be disconnected.

The earth of the welding machine must be placed as close as possible to the weld area.

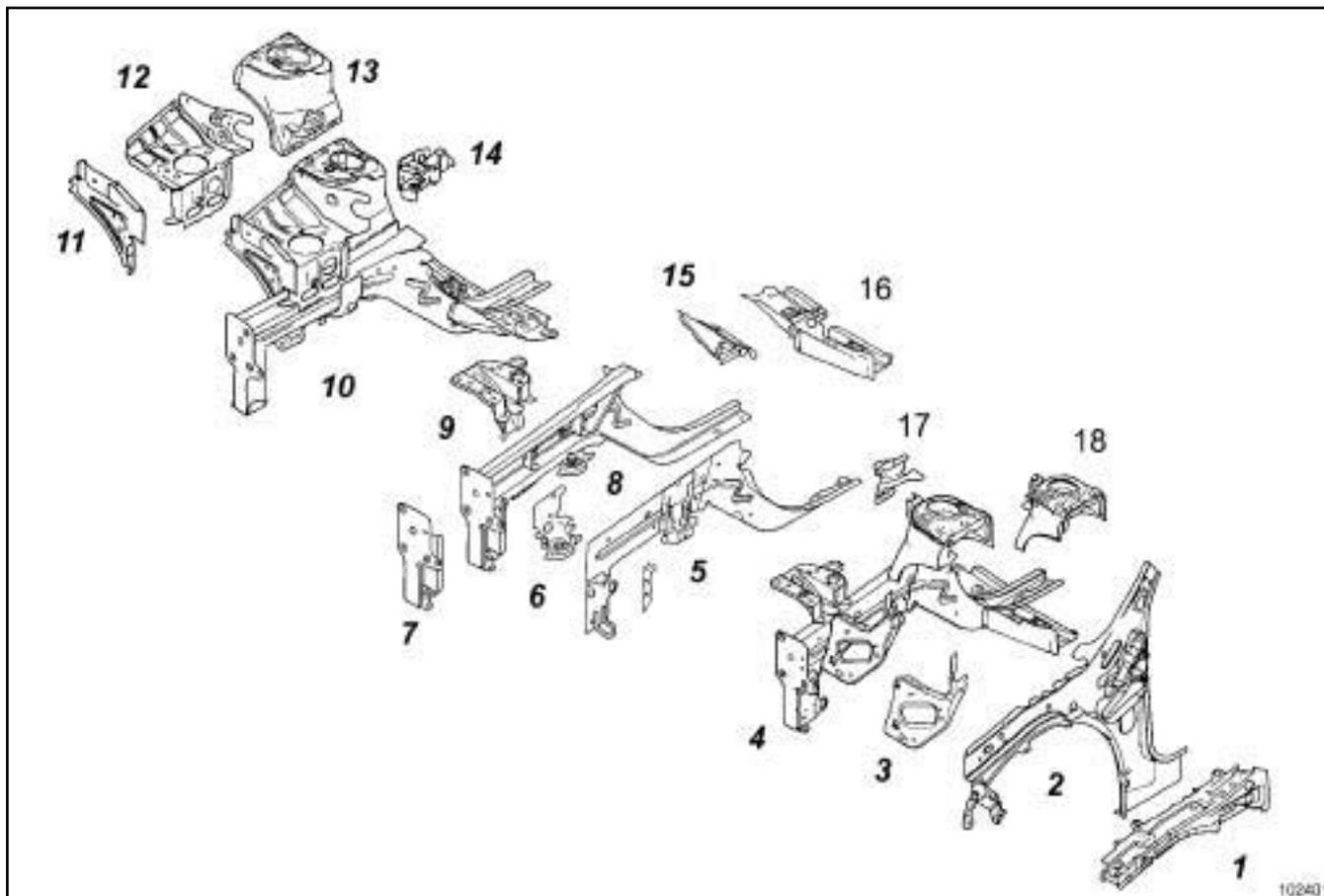
CENTRE LOWER STRUCTURE

Vehicle front section structure: Description

41B

B84 or C84

FRONT STRUCTURE



102401

102401

Mark	Description	Classification	Type	Thickness (mm)
(1)	Scuttle side panel upper reinforcement	(see 42A, Upper front structure, Scuttle side panel upper reinforcement: Description, page 42A-32)	-	0.9
(2)	Scuttle side panel	(see 42A, Upper front structure, Cowl side panel: Description, page 42A-28)	HLE/ THLE	1/2.5
(3)	Front end side cross member	(see Front end side cross member: Description)	-	1.2
(4)	Left-hand front half unit	(see 41A, Front lower structure, Front half unit: Description, page 41A-39)	HLE/ THLE	1.1/3
(5)	Front section of front side member closure panel	(see 41A, Front lower structure, Front section of front side member closure panel: Description, page 41A-23)	HLE/ THLE	1.7/3

CENTRE LOWER STRUCTURE

Vehicle front section structure: Description

41B

B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(6)	Front mounting of front sub-frame	(see 41A, Front lower structure, Front mounting of front sub-frame: Description, page 41A-32)	HLE	1.2
(7)	Radiator cross member support	(see 41A, Front lower structure, Radiator cross member support: Description, page 41A-29)	-	1.2/2.5
(8)	Front side member	(see 41A, Front lower structure, Front side member: Description, page 41A-17)	HLE/ THLE	1.2/3
(9)	Battery tray bracket	(see 41A, Front lower structure, Battery tray support: Description, page 41A-27)	-	1.5/2
(10)	Right-hand front half unit	(see 41A, Front lower structure, Front half unit: Description, page 41A-39)	HLE/ THLE	1.1/3
(11)	Front end side cross member	(see Front end side cross member: Description)	-	1.2
(12)	Engine stand	(see 41A, Front lower structure, Engine mounting: Description, page 41A-34)	HLE	1.5/2
(13)	Wheel arch	(see 42A, Upper front structure, Front wheel arch: Description, page 42A-35)	-	1.1/2
(14)	Engine tie-bar mounting		HLE	1
(15)	Sub-frame rear mounting	(see Sub-frame rear mounting: Description)	HLE/ THLE	2/3
(16)	Centre floor front side cross member	(see 41B, Centre lower structure, Centre floor front lateral cross member: Description, page 41B-18)	HLE/ THLE	1.2/3
(17)	Connecting bracket			
(18)	Front wheel arch	(see 42A, Upper front structure, Front wheel arch: Description, page 42A-35)	HLE	1.1/2

CENTRE LOWER STRUCTURE

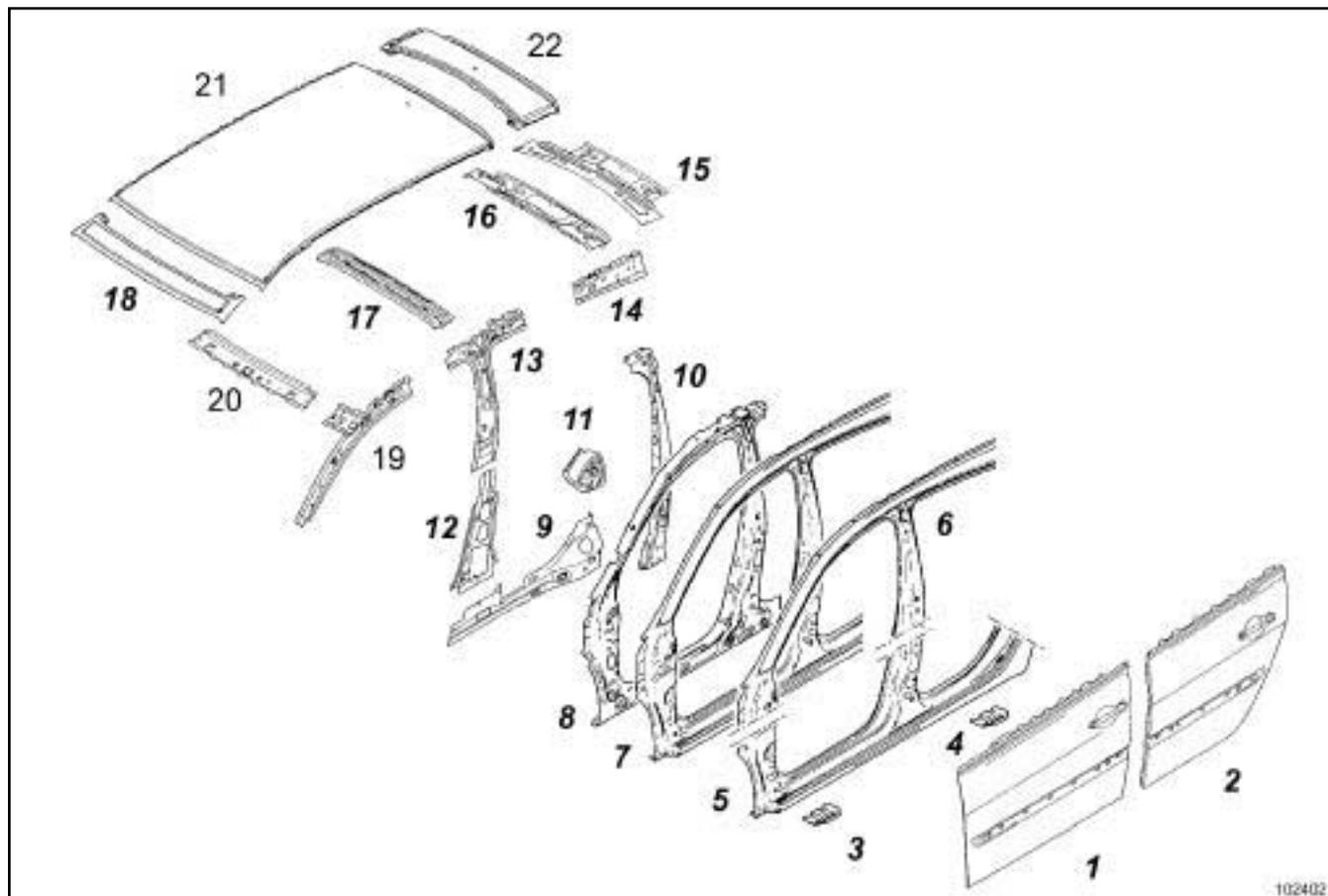
Vehicle side section structure: Description

41B

B84 or C84

SIDE STRUCTURE

B84



102402

102402

Mark	Description	Classification	Type	Thickness (mm)
(1)	Front side door panel	(see Front side door panel: Description)	HLE	0.7/0.95
(2)	Rear side door panel	(see Rear side door panel: Description)	HLE	0.7/0.95
(3)	Front jack support	(see Front jacking point: Description)	HLE	1.8
(4)	Rear jack support	(see Front jacking point: Description)	HLE	1.8
(5)	Sill panel	(see 41C, Side lower structure, Sill panel: Description, page 41C-9)	-	0.7
(6)	Upper body	(see 43A, Side upper structure, Upper body panel: Description, page 43A-47)	-	0.7

CENTRE LOWER STRUCTURE

Vehicle side section structure: Description

41B

B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(7)	Body side front section	(see 43A, Side upper structure, Body side front section: Description, page 43A-39)	-	0.7
(8)	Body side front section reinforcement	(see 43A, Side upper structure, Body side front section reinforcement: Description, page 43A-42)	HLE	1.2/1.5
(9)	Rear inner sill panel	(see 41C, Side lower structure, Rear inner sill panel: Description, page 41C-23)	HLE	1
(10)	B-pillar reinforcement stiffener	(see B-pillar reinforcement stiffener: Description)	HLE	1.5/2.2
(11)	Anti-intrusion reinforcement			
(12)	B-pillar lower lining	(see B-pillar lower lining: Description)	-	0.7
(13)	B-pillar upper lining	(see B-pillar upper lining: Description)	HLE	1.5
(14)	Rear roof drip moulding lining	(see Roof drip moulding lining: Description)	-	1
(15)	Roof rear cross member with sunroof	(see 45A, Top of body, Roof rear cross member: Description, page 45A-16)	HLE	0.7/0.9
(16)	Roof rear cross member without sunroof	(see 45A, Top of body, Roof rear cross member: Description, page 45A-16)	HLE	0.7/0.9
(17)	Roof middle cross member	(see 45A, Top of body, Roof centre cross member: Description, page 45A-14)	HLE	1.5
(18)	Front section of roof	(see 45A, Top of body, Roof front section: Description, page 45A-9)	-	0.7
(19)	A-pillar lining	(see 43A, Side upper structure, Windscreen pillar lining: Description, page 43A-16)	HLE	1.5/2
(20)	Roof front cross member	(see 45A, Top of body, Roof front cross member: Description, page 45A-12)	HLE	0.7

CENTRE LOWER STRUCTURE

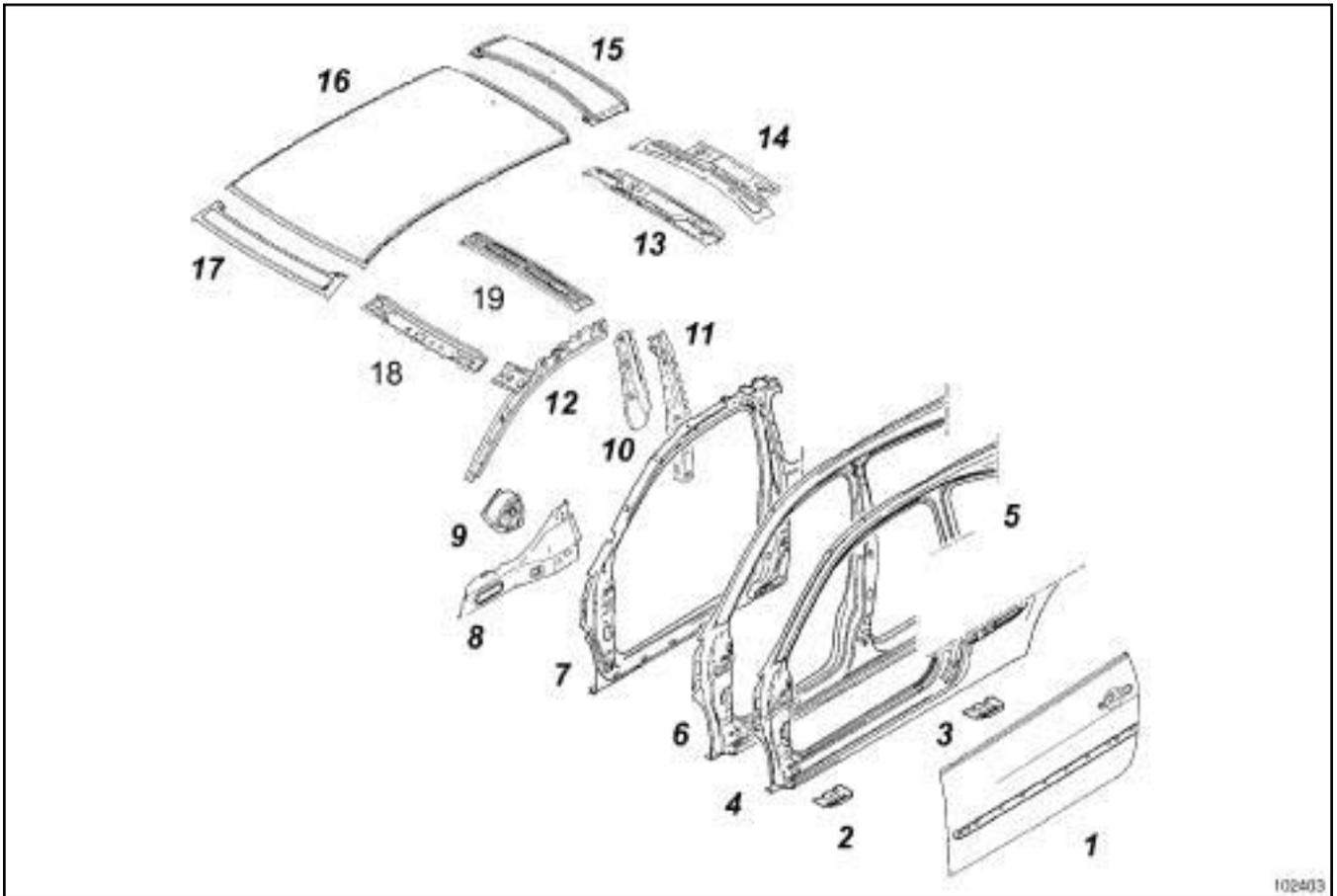
Vehicle side section structure: Description

41B

B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(21)	Roof	(see 45A, Top of body, Roof: Description, page 45A-7)	-	0.7
(22)	Rear section of roof	(see 45A, Top of body, Roof rear section: Description, page 45A-10)	-	0.7

C84



102403

102403

Mark	Description	Classification	Type	Thickness (mm)
(1)	Front side door panel	(see Front side door panel: Description)	HLE	0.7/0.95
(2)	Front jack support	(see Front jacking point: Description)	HLE	1.8
(3)	Rear jack support	(see Front jacking point: Description)	HLE	1.8

CENTRE LOWER STRUCTURE

Vehicle side section structure: Description

41B

B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(4)	Sill panel	(see 41C, Side lower structure, Sill panel: Description, page 41C-9)	-	0.7
(5)	Upper body	(see 43A, Side upper structure, Upper body panel: Description, page 43A-47)	-	0.7
(6)	Body side front section	(see 43A, Side upper structure, Body side front section: Description, page 43A-39)	-	0.7
(7)	Body side front section reinforcement	(see 43A, Side upper structure, Body side front section reinforcement: Description, page 43A-42)	HLE	1.2/1.5
(8)	Rear inner sill panel	(see 41C, Side lower structure, Rear inner sill panel: Description, page 41C-23)	HLE	1
(9)	Anti-intrusion reinforcement			
(10)	Quarter panel front reinforcement		HLE	1.5
(11)	B-pillar reinforcement stiffener	(see B-pillar reinforcement stiffener: Description)	VHLE	1.8
(12)	A-pillar lining	(see 43A, Side upper structure, Windscreen pillar lining: Description, page 43A-16)	HLE	1.5/2
(13)	Roof rear cross member without sunroof	(see 45A, Top of body, Roof rear cross member: Description, page 45A-16)	HLE	0.7/0.9
(14)	Roof rear cross member with sunroof	(see 45A, Top of body, Roof rear cross member: Description, page 45A-16)	HLE	0.7/0.9
(15)	Rear section of roof	(see 45A, Top of body, Roof rear section: Description, page 45A-10)	-	0.7
(16)	Roof	(see 45A, Top of body, Roof: Description, page 45A-7)	-	0.7
(17)	Front section of roof	(see 45A, Top of body, Roof front section: Description, page 45A-9)	-	0.7

CENTRE LOWER STRUCTURE

Vehicle side section structure: Description

41B

B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(18)	Roof front cross member	(see 45A, Top of body, Roof front cross member: Description, page 45A-12)	HLE	0.7
(19)	Roof middle cross member	(see 45A, Top of body, Roof centre cross member: Description, page 45A-14)	HLE	1.5



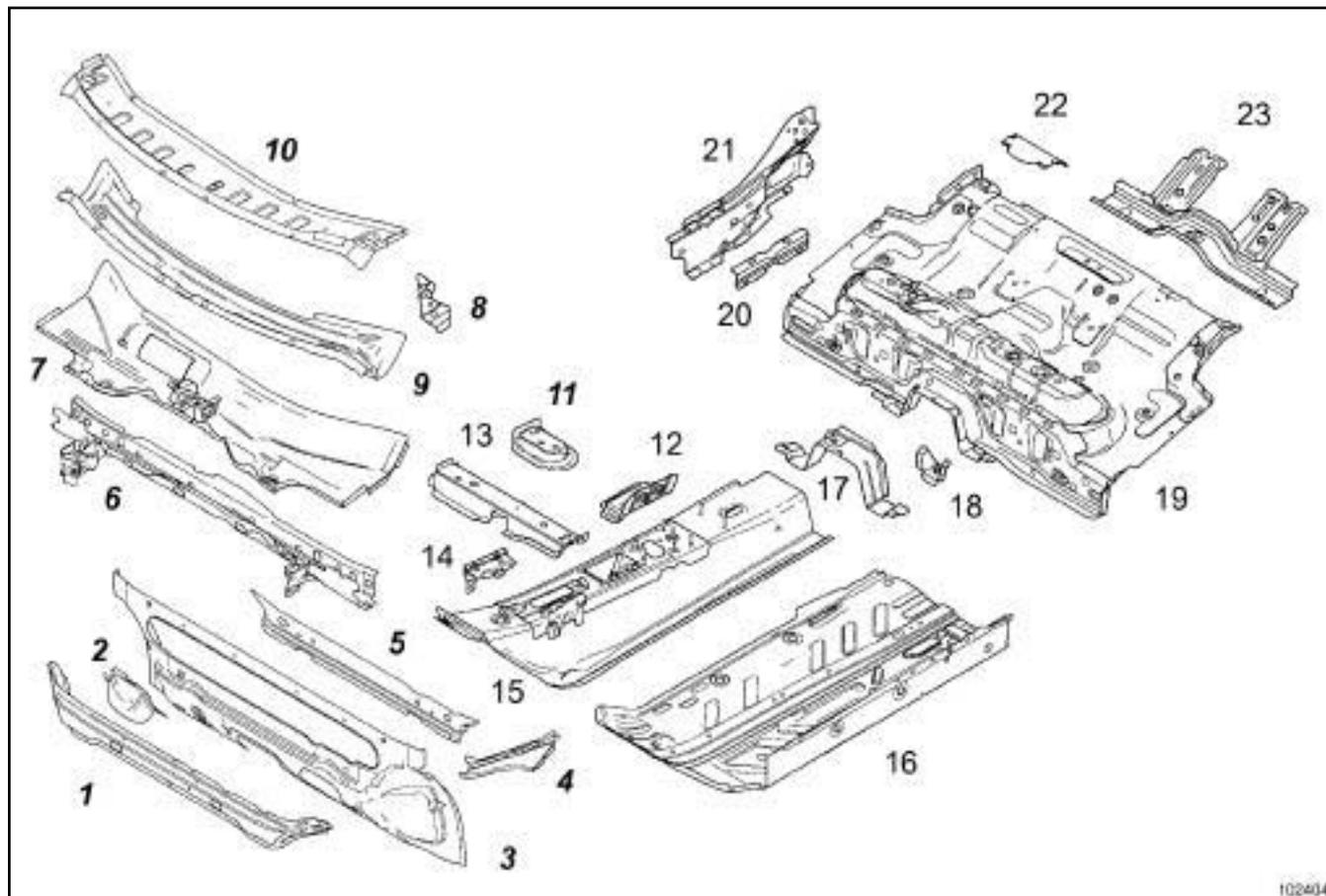
CENTRE LOWER STRUCTURE

Vehicle central section structure: Description

41B

B84 or C84

CENTRAL STRUCTURE



102404

102404

Mark	Description	Classification	Type	Thickness (mm)
(1)	Bulkhead lower cross member	(see 42A, Upper front structure, Bulkhead lower cross member: Description, page 42A-53)	VHLE	2.5
(2)	Steering column unit		-	1.5
(3)	Bulkhead	(see 42A, Upper front structure, Bulkhead: Description, page 42A-49)	-	0.9
(4)	Bulkhead side reinforcement	(see 42A, Upper front structure, Bulkhead side stiffener: Description, page 42A-59)	UHLE	1.7
(5)	Bulkhead reinforcement	(see 42A, Upper front structure, Bulkhead reinforcement: Description, page 42A-51)	UHLE	1.7

CENTRE LOWER STRUCTURE

Vehicle central section structure: Description

41B

B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(6)	Bulkhead upper cross member	(see 42A, Upper front structure, Bulkhead upper cross member: Description, page 42A-57)	HLE	0.95/3
(7)	Heater bulkhead	(see 42A, Upper front structure, Heater bulkhead: Description, page 42A-38)	-	0.7/1.2
(8)	Windscreen wiper mounting	(see 42A, Upper front structure, Windscreen wiper mounting: Description, page 42A-61)	-	1.2
(9)	Windscreen aperture lower cross member	(see 42A, Upper front structure, Windscreen aperture lower cross member: Description, page 42A-41)	-	0.7
(10)	Windscreen aperture lower cross member closure panel	(see 42A, Upper front structure, Windscreen aperture lower cross member closure panel: Description, page 42A-47)	-	0.65/1.2
(11)	Front seat mounting exterior unit	(see 41B, Centre lower structure, Front seat rear outer mounting unit: Description, page 41B-26)	HLE	1.5
(12)	Front seat mounting interior unit	(see 41B, Centre lower structure, Front seat rear mounting interior unit: Description, page 41B-25)	HLE	1.5/2.5
(13)	Front cross member under front seat	(see 41B, Centre lower structure, Front cross member under front seat: Description, page 41B-23)	HLE	1.5
(14)	Steering column mounting		-	1.3
(15)	Tunnel	(see 41B, Centre lower structure, Tunnel: Description, page 41B-20)	HLE/ THLE	1/1.6
(16)	Centre floor, side section	(see 41B, Centre lower structure, Central floor, side section: Description, page 41B-13)	VHLE	0.7/2.5
(17)	Exhaust mounting support	(see 41D, Rear lower structure, Exhaust mounting support: Description, page 41D-30)	-	1.2/2.5

CENTRE LOWER STRUCTURE

Vehicle central section structure: Description

41B

B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(18)	Fuel tank mounting support	(see 41D, Rear lower structure, Tank mounting support: Description, page 41D-31)	-	1.2
(19)	Front section of rear floor	(see 41D, Rear lower structure, Rear floor, front section: Description, page 41D-10)	HLE/ THLE	0.7/2.5
(20)	Sill panel reinforcement stiffener		VHLE	1.8
(21)	Sill panel rear reinforcement	(see 41C, Side lower structure, Sill panel rear reinforcement: Description, page 41C-29)	HLE	1.4
(22)	Fuel gauge closure panel		HLE	0.8
(23)	Rear floor front cross member, centre section	(see 41D, Rear lower structure, Rear floor front cross member, centre section: Description, page 41D-25)	HLE	1.2/2

B84 or C84

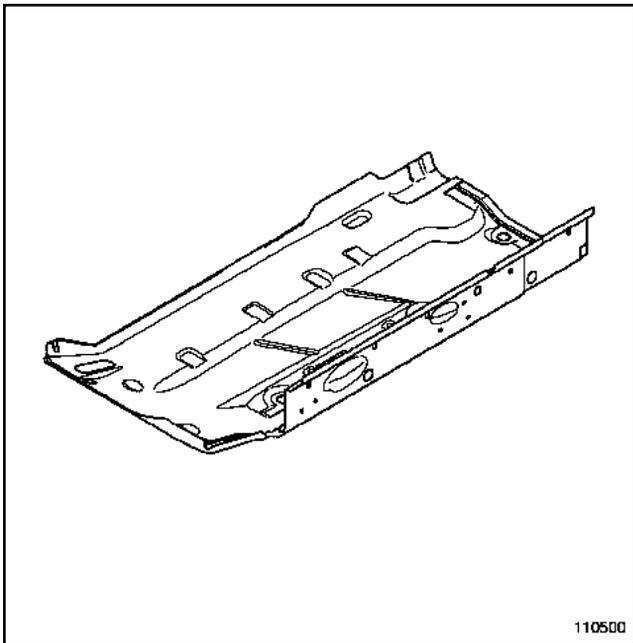
WARNING

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading this general information, check that there are no special notes associated with this vehicle. These special notes will be specified if applicable in other parts of this sub-section dealing with the part.

Note:

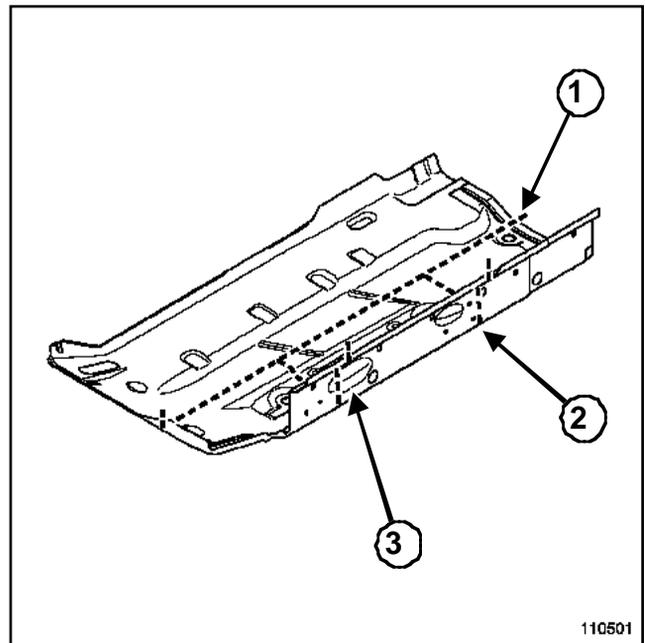
For a detailed description of a particular connection, see **MR 400, 40A, General Information**.

I - DESIGN OF THE STRUCTURAL COMPONENT

110500

110500

The special feature of this type of part is that it is made of two different kinds of panels of different thicknesses assembled by laser butt welding.

II - AREA TO BE CUT FOR PARTIAL REPLACEMENT

110501

110501

These cutting lines show the area in which it is possible to carry out a partial replacement of the centre floor side section.

Cut 1, 2 and 3:

- cut (1) affects the partial replacement of the centre floor side section.
- cuts (1) and (2) affect the partial replacement of the rear section of the centre floor side section.
- cuts (1) and (3) affect the partial replacement of the front section of the centre floor side section.

III - ASSEMBLY INSTRUCTIONS FOR A PARTIAL REPLACEMENT

Only the connecting pieces relevant to partial replacement by cutting are shown.

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

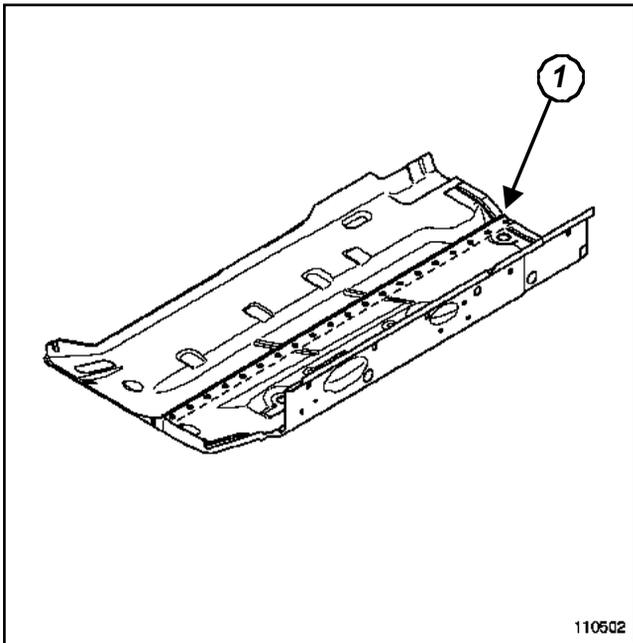
If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400, 40A, General information**).

CENTRE LOWER STRUCTURE

Centre floor, side section: General description

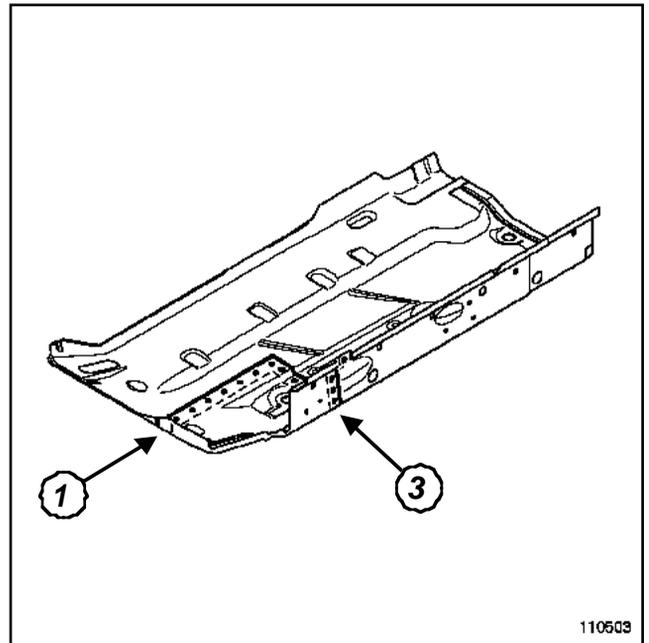
41B

B84 or C84



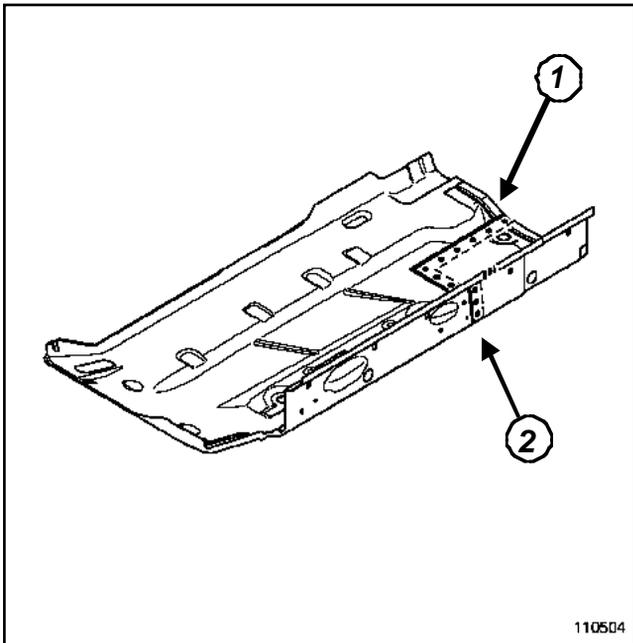
110502
110502

Line (1) in the drawing shows partial replacement and a weld by joggling with plug welds at regular intervals.



110503
110503

Lines (1) and (2) in the diagram show the partial front replacement and a weld by joggling with plug welds at regular intervals.



110504
110504

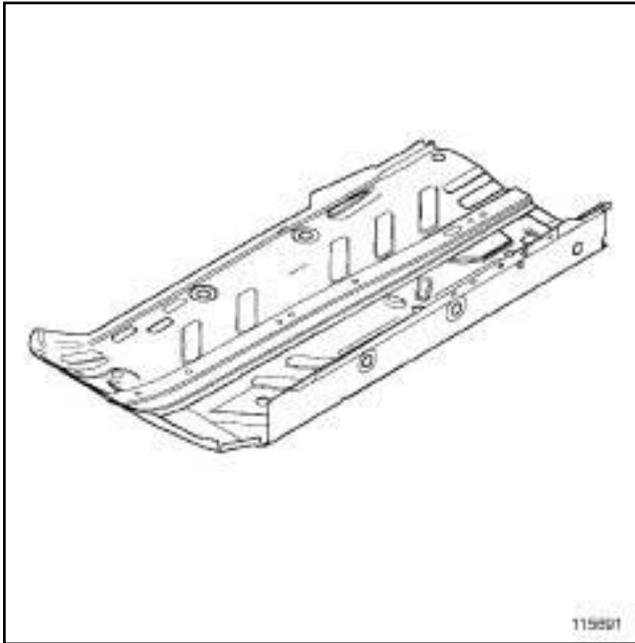
Lines (1) and (2) in the diagram show the partial rear replacement and a weld by joggling with plug welds at regular intervals.

CENTRE LOWER STRUCTURE

Central floor, side section: Description

41B

B84 or C84

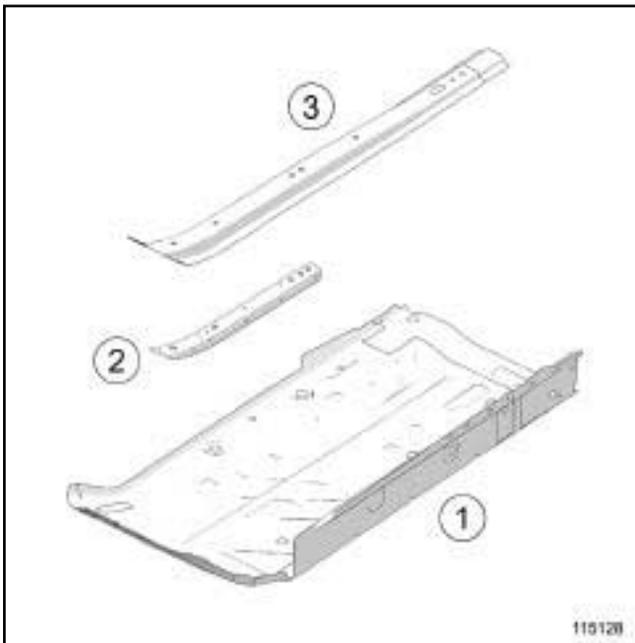


115691

The options for replacing this part are as follows:

- partial replacement of front end section: this operation complements the replacement of the A-pillar reinforcement,
- partial replacement of the front section,
- partial replacement of the rear section: this operation complements the replacement of the B-pillar reinforcement,
- complete replacement.

I - COMPOSITION OF THE SPARE PART

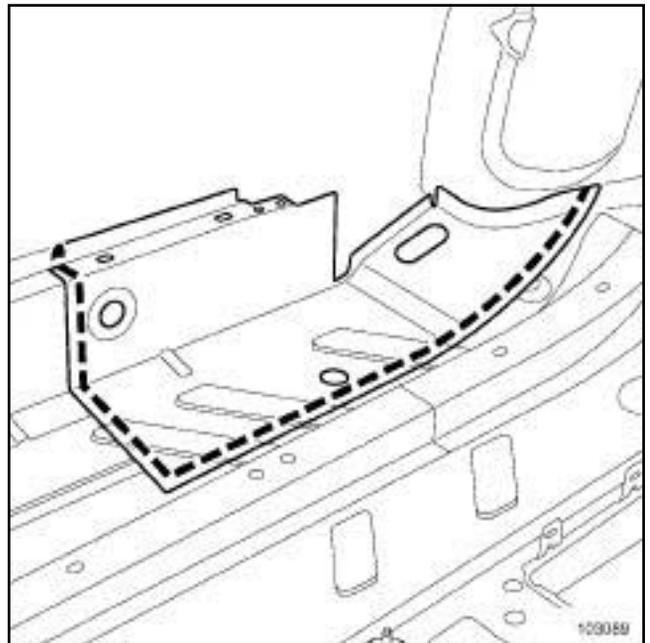


115128

Mark	Description	Type	Thickness (mm)
(1)	Side floor	-	0.7
(2)	Centre side member reinforcement	THLE	2.5
(3)	Centre side member	THLE	2

II - PART FITTED

1 - Partial replacement of the front end section



103089

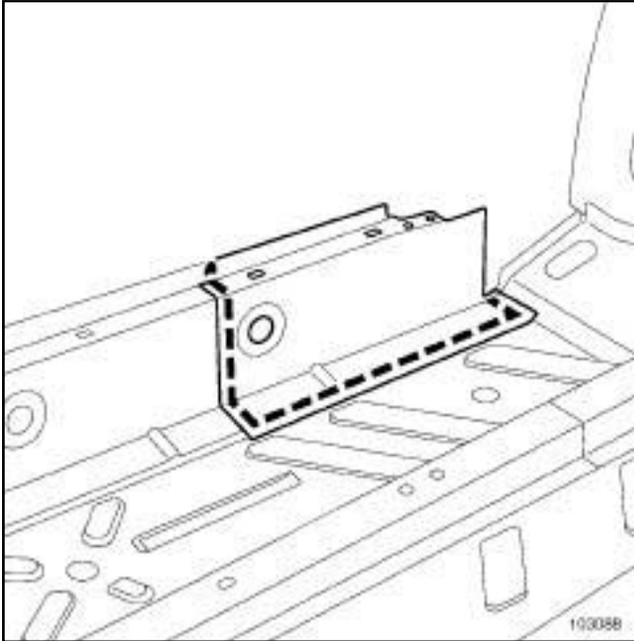
CENTRE LOWER STRUCTURE

Central floor, side section: Description

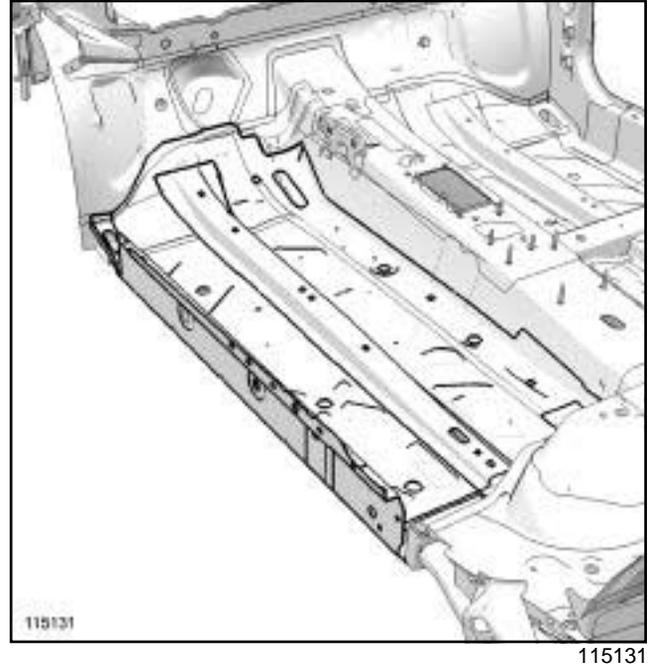
41B

B84 or C84

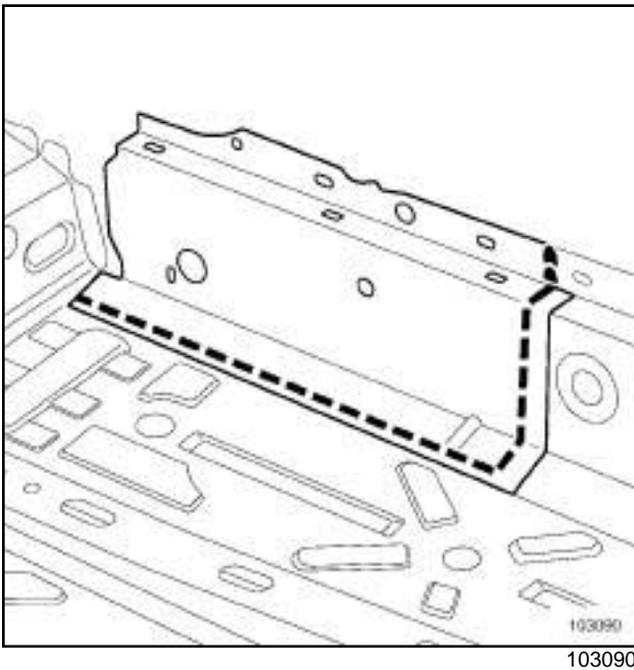
2 - Partial replacement of the front section



4 - Complete replacement



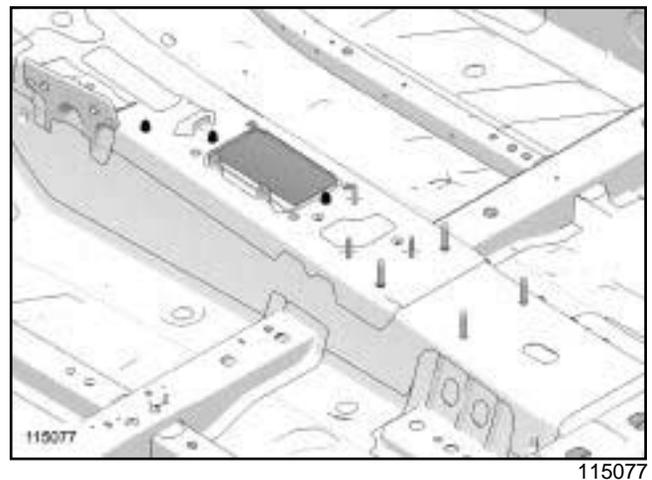
3 - Partial replacement of the rear section



WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



CENTRE LOWER STRUCTURE

Central floor, side section: Description

41B

B84 or C84

IMPORTANT

To avoid damaging the vehicle's electric and electronic components, the battery and the earths of any wiring harness near the weld area must be disconnected.

The earth of the welding machine must be placed as close as possible to the weld area.

B84 or C84

WARNING

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading this general information, check that there are no special notes associated with this vehicle. These special features will be specified if applicable in other parts of this sub-section dealing with the part.

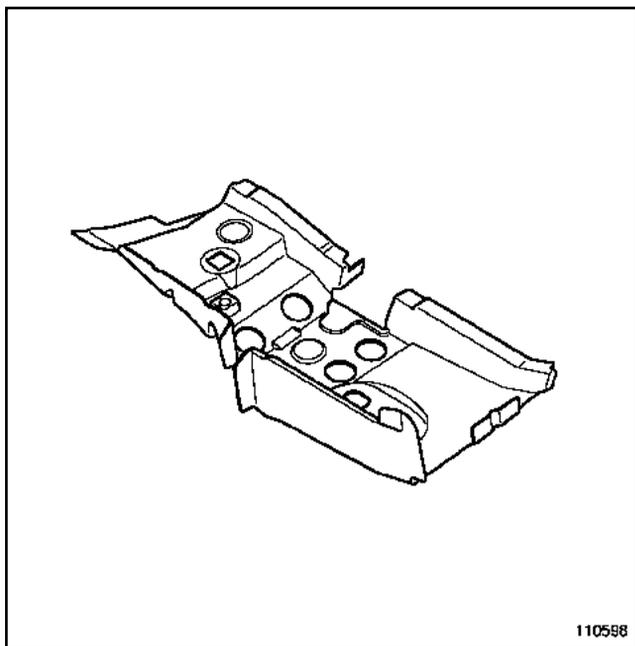
IMPORTANT

For complete replacement, the straightening bench must be used.

Note:

For detailed instructions about a particular join, see **MR400, 40A, General information**.

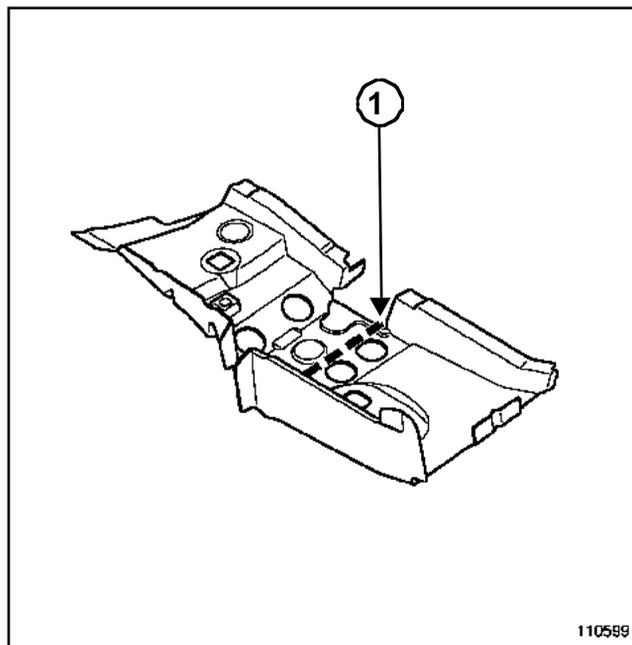
I - DESIGN OF THE STRUCTURAL COMPONENT



110598

This is a basic part; it functions only as a centre floor front side cross member.

II - AREA TO BE CUT FOR PARTIAL REPLACEMENT



110599

Line (1) in the diagram shows the area in which it is possible to carry out a partial replacement.

III - ASSEMBLY INSTRUCTIONS FOR A PARTIAL REPLACEMENT

Only the connecting pieces relevant to partial replacement by cutting are shown.

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

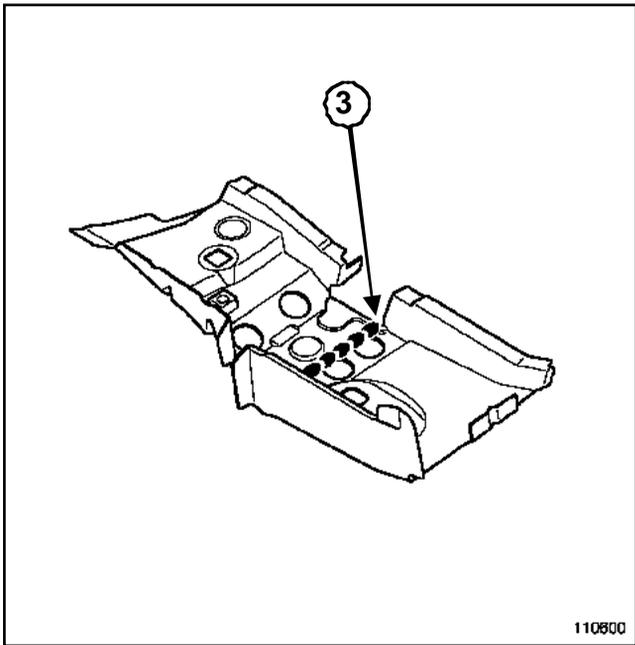
If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400, 40A, General Information**).

CENTRE LOWER STRUCTURE

Centre floor front lateral cross member: General description

41B

B84 or C84

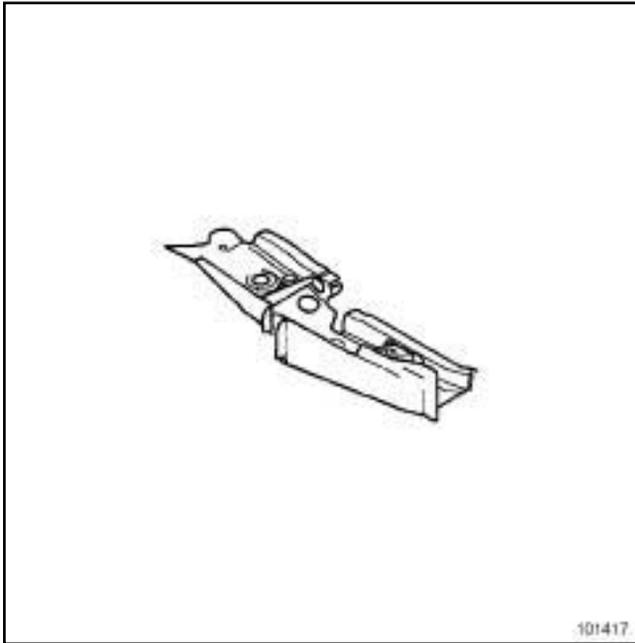


110600

Line (3) of the diagram shows a butt weld by continuous MAG welding.

Centre floor front lateral cross member: Description

B84 or C84

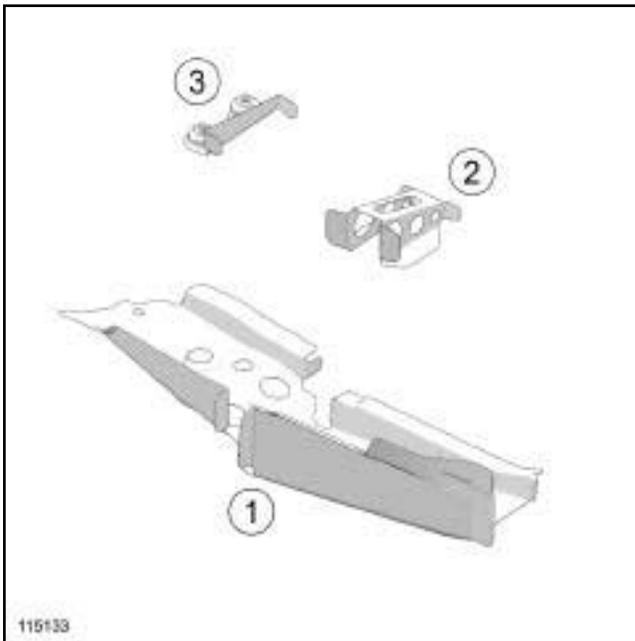


101417
101417

The options for replacing this part are as follows:

- partial replacement,
- complete replacement.

I - COMPOSITION OF THE SPARE PART



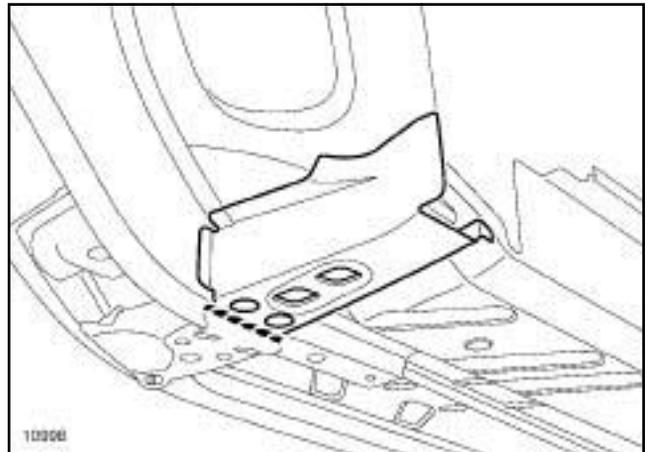
115133

115133

Mark	Description	Type	Thic- kness (mm)
(1)	Front side cross member	HEL	1.2
(2)	Front side cross member reinforcement	-	1.5
(3)	Front side cross member impact reinforcement	THLE	3

II - PART FITTED

1 - Partial replacement



101998

101998

Note:

The cut is made at the end of the front side member.

Centre floor front lateral cross member: Description

B84 or C84

2 - Complete replacement

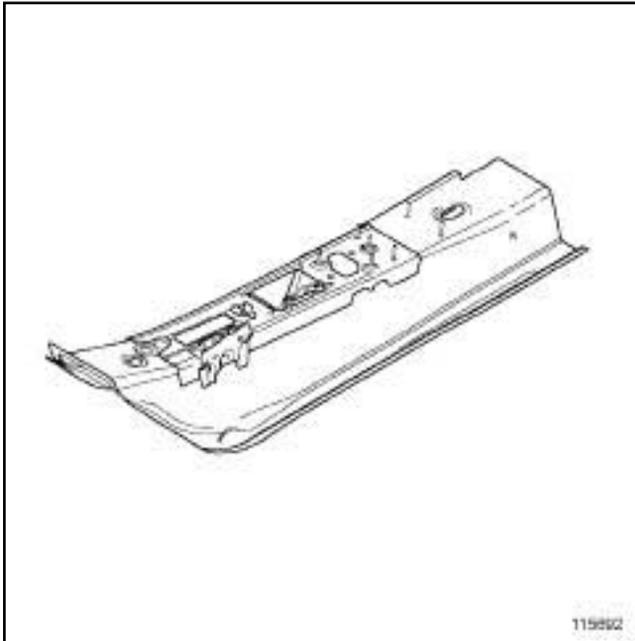


102000

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

B84 or C84



115692

There is only one way of replacing this part:

- complete replacement: this operation complements the replacement of the complete centre floor side section for a side impact.

I - COMPOSITION OF THE SPARE PART



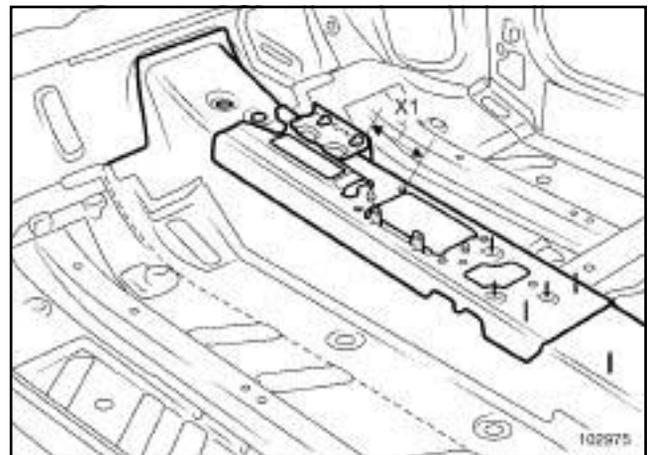
115135

115135

Mark	Description	Type	Thickness (mm)
(1)	Tunnel	-	1
(2)	Centre cross member beneath tunnel	HEL	1.5
(3)	Steering column cross member mounting	-	1.3
(4)	Steering column stay upper bracket	-	1.3
(5)	Tunnel reinforcement	THLE	1.6

II - PART FITTED

Front section



102975

(X1) = 135 mm

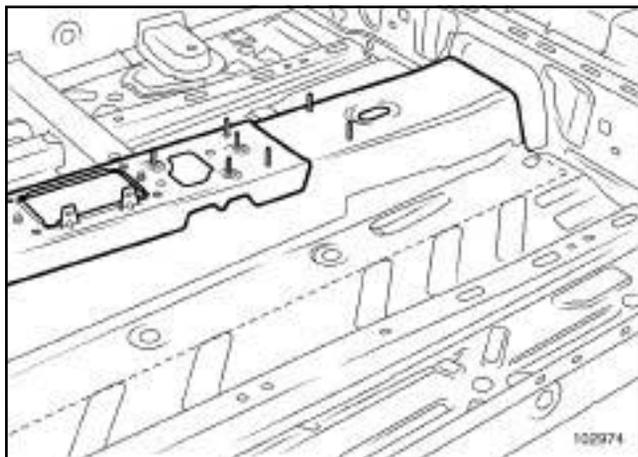
Note:

For right-hand drive vehicles, observe the value indicated before to position the steering column cross member mounting.

Tunnel: Description

B84 or C84

Rear section



102974

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

B84 or C84

WARNING

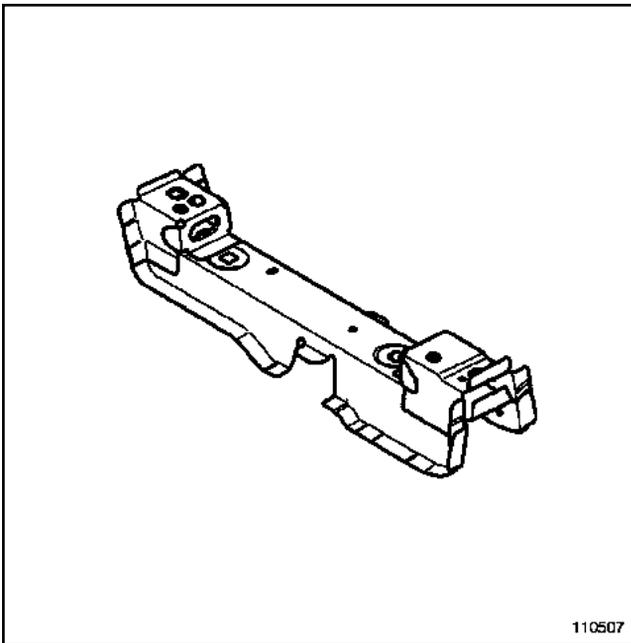
The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading this general information, check that there are no special notes associated with this vehicle. These special notes will be specified if applicable in other parts of this sub-section dealing with the part.

Note:

For detailed instructions about a particular join, see **MR400, 40A, General information** .

DESIGN OF THE STRUCTURAL COMPONENT



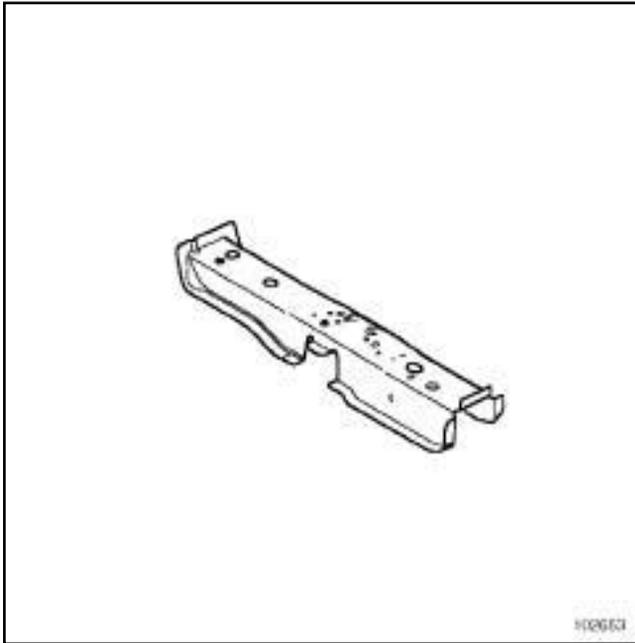
110507

110507

This is a basic part; its function is to secure the front section of the front seat and to stiffen the bodywork in the event of a side impact.

Front cross member under front seat: Description

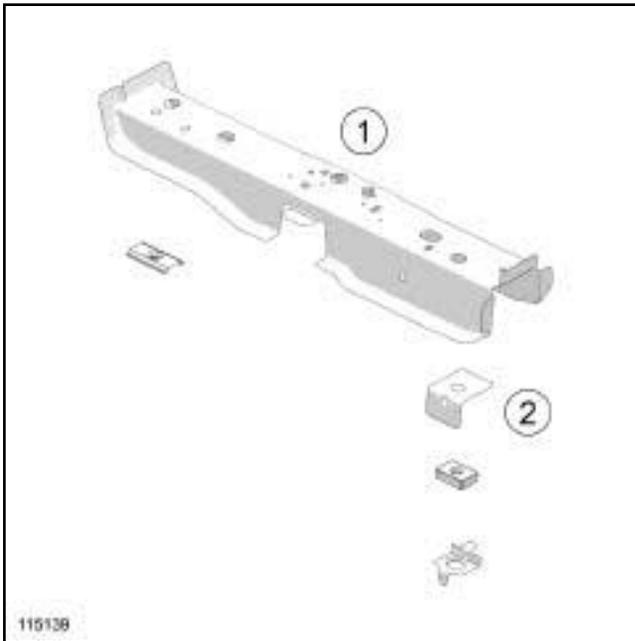
B84 or C84



102653

There is only one way of replacing this part:
- complete replacement.

I - COMPOSITION OF THE SPARE PART



115139

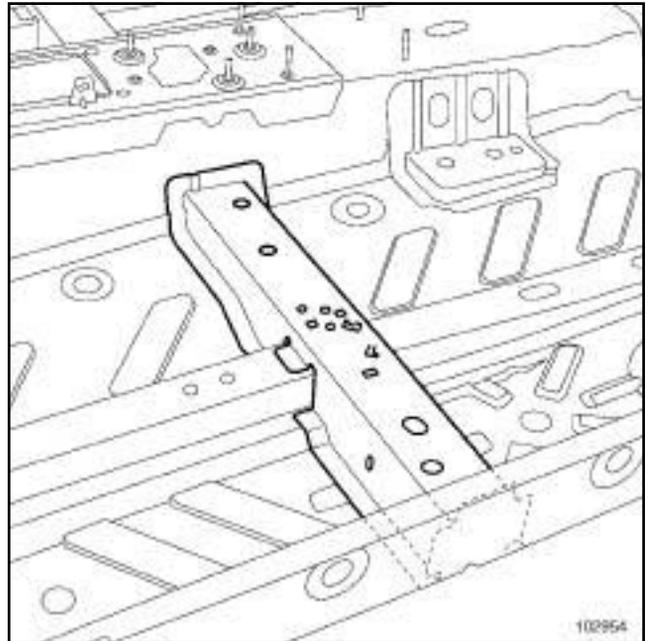
Mark	Description	Type	Thickness (mm)
(1)	Front cross member under front seat	HEL	1.5
(2)	Seat mounting reinforcement	HEL	1.5

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

II - PART FITTED

1 - Complete replacement



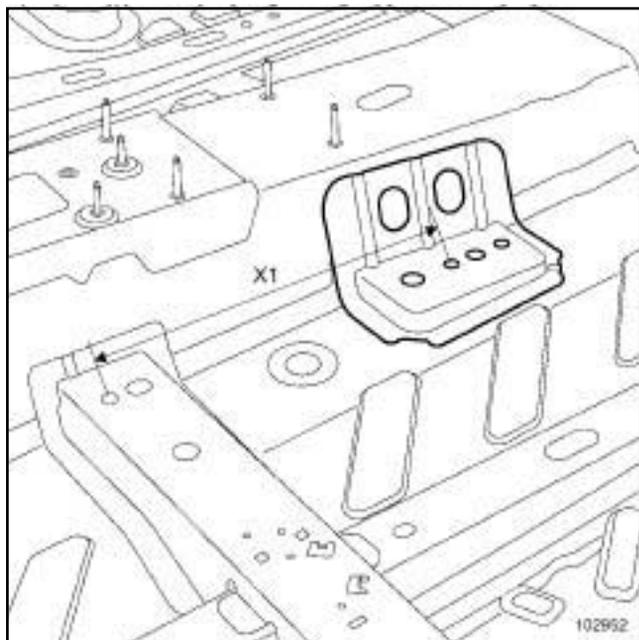
102954

Front cross member under front seat: Description

B84 or C84

2 - Fitting the cross member

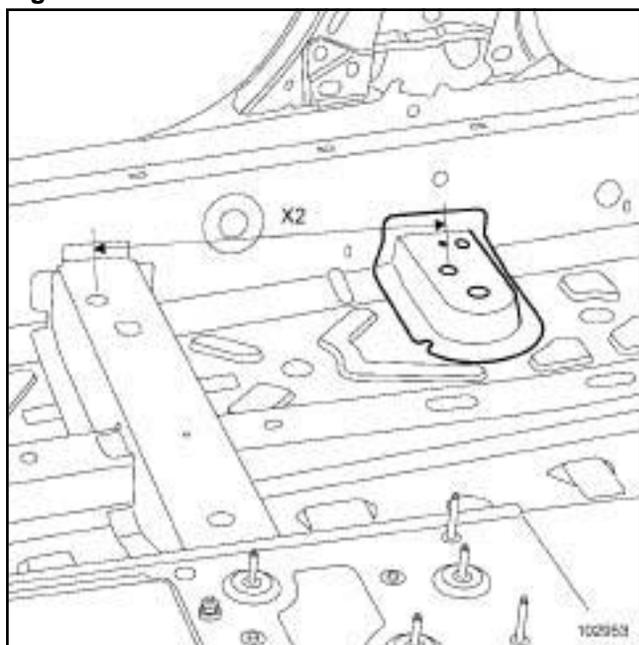
Left-hand side



102952

(X1) = 335 mm

Right-hand side



102953

(X2) = 335 mm

Note:

It is essential to observe the values indicated before.

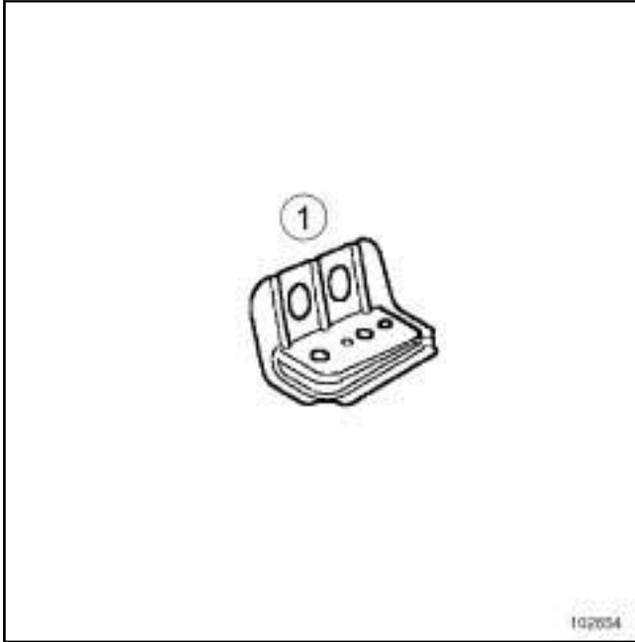
Front seat rear mounting interior unit: Description

B84 or C84

There is only one way of replacing this part:

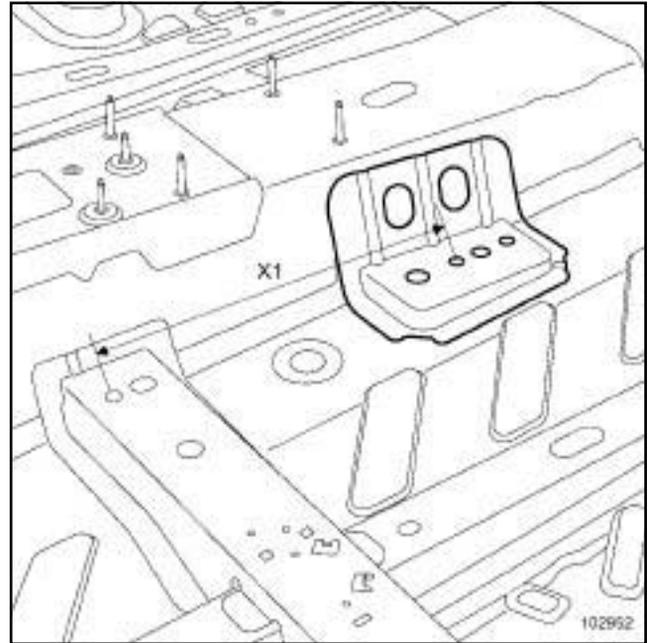
- complete replacement.

I - COMPOSITION OF THE SPARE PART



102654

II - PART FITTED



102952

(X1) = 335 mm

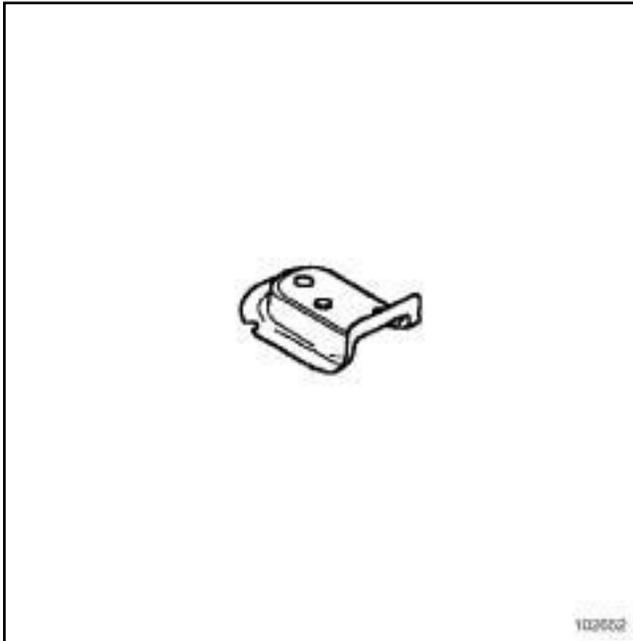
Note:

It is necessary to respect the dimension previously indicated.

Number	Description	Type	Thickness (mm)
(1)	Front seat rear inner mounting unit	HEL	1.5

Front seat rear outer mounting unit: Description

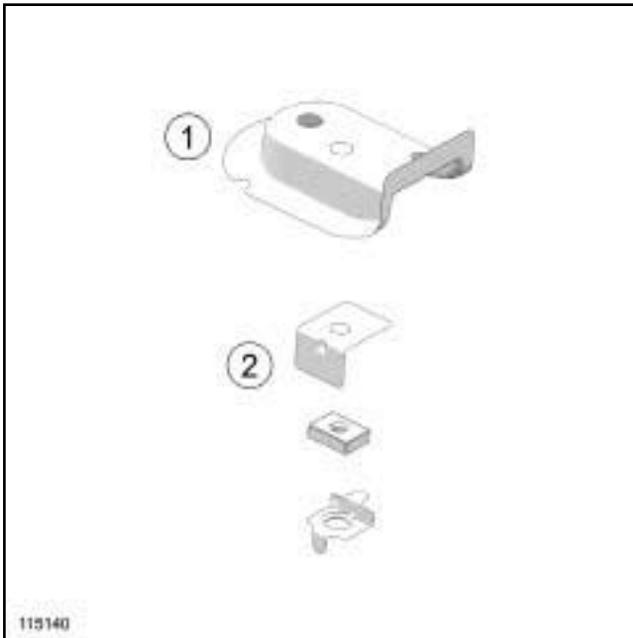
B84 or C84



102652

There is only one way of replacing this part:
- complete replacement.

I - COMPOSITION OF THE SPARE PART



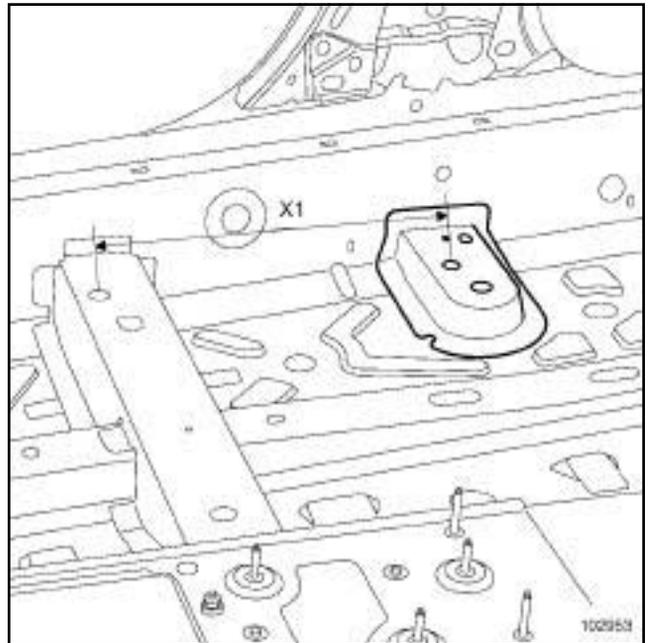
115140

Number	Description	Type	Thickness (mm)
(1)	Front seat mounting unit	HEL	1.5
(2)	Front seat mounting reinforcement	HEL	1.5

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, they should be replaced with plug welds after holes have been drilled in the first panel.

II - PART FITTED



102953

(X1) = 335 mm

Note:

It is necessary to respect the dimension previously indicated.

SIDE LOWER STRUCTURE

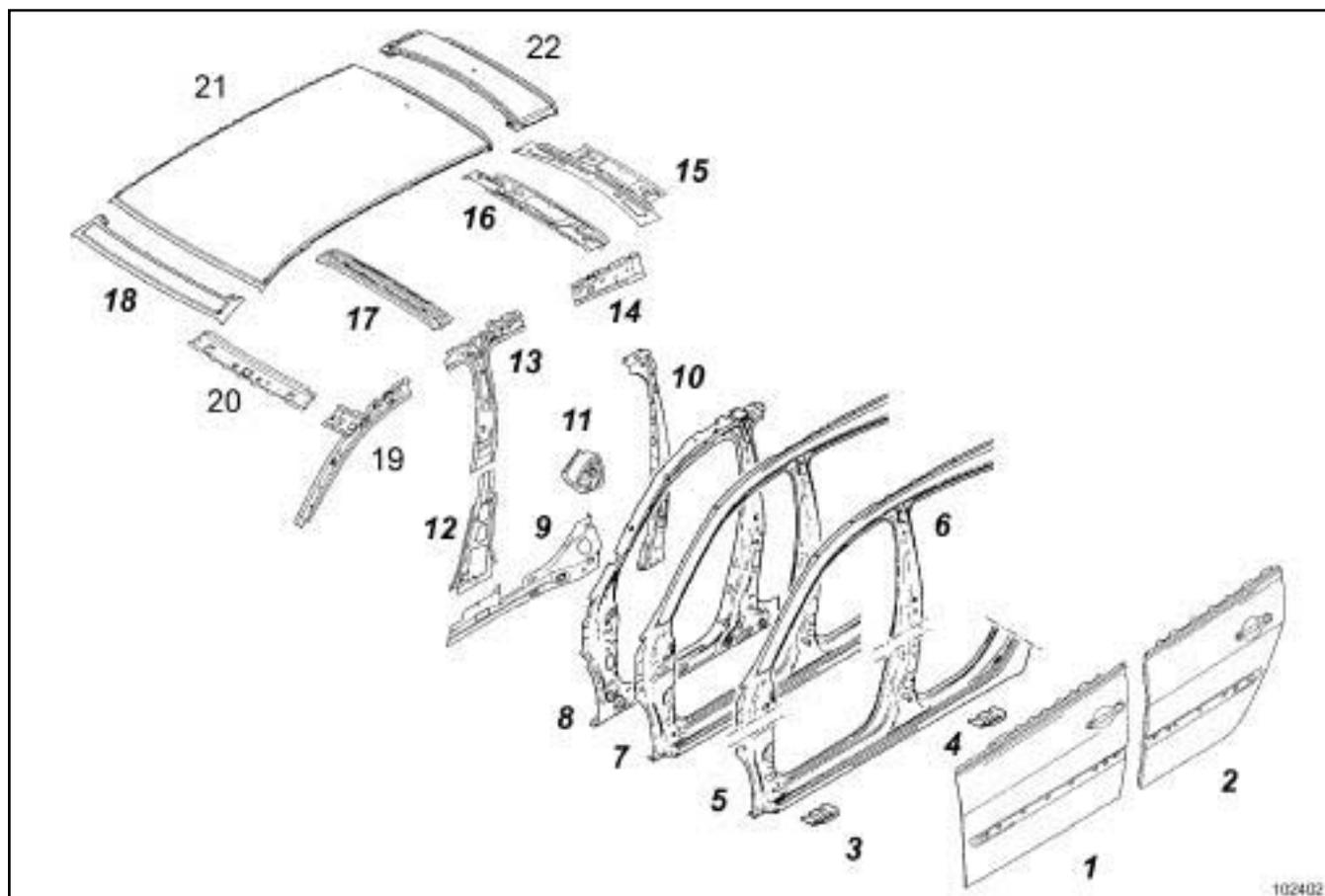
Vehicle side section structure: Description

41C

B84 or C84

SIDE STRUCTURE

B84



102402

102402

Mark	Description	Classification	Type	Thickness (mm)
(1)	Front side door panel	(see Front side door panel: Description)	HLE	0.7/0.95
(2)	Rear side door panel	(see Rear side door panel: Description)	HLE	0.7/0.95
(3)	Front jack support	(see Front jacking point: Description)	HLE	1.8
(4)	Rear jack support	(see Front jacking point: Description)	HLE	1.8
(5)	Sill panel	(see 41C, Side lower structure, Sill panel: Description, page 41C-9)	-	0.7
(6)	Upper body	(see 43A, Side upper structure, Upper body panel: Description, page 43A-47)	-	0.7

SIDE LOWER STRUCTURE

41C

Vehicle side section structure: Description

B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(7)	Body side front section	(see 43A, Side upper structure, Body side front section: Description, page 43A-39)	-	0.7
(8)	Body side front section reinforcement	(see 43A, Side upper structure, Body side front section reinforcement: Description, page 43A-42)	HLE	1.2/1.5
(9)	Rear inner sill panel	(see 41C, Side lower structure, Rear inner sill panel: Description, page 41C-23)	HLE	1
(10)	B-pillar reinforcement stiffener	(see B-pillar reinforcement stiffener: Description)	HLE	1.5/2.2
(11)	Anti-intrusion reinforcement			
(12)	B-pillar lower lining	(see B-pillar lower lining: Description)	-	0.7
(13)	B-pillar upper lining	(see B-pillar upper lining: Description)	HLE	1.5
(14)	Rear roof drip moulding lining	(see Roof drip moulding lining: Description)	-	1
(15)	Roof rear cross member with sunroof	(see 45A, Top of body, Roof rear cross member: Description, page 45A-16)	HLE	0.7/0.9
(16)	Roof rear cross member without sunroof	(see 45A, Top of body, Roof rear cross member: Description, page 45A-16)	HLE	0.7/0.9
(17)	Roof middle cross member	(see 45A, Top of body, Roof centre cross member: Description, page 45A-14)	HLE	1.5
(18)	Front section of roof	(see 45A, Top of body, Roof front section: Description, page 45A-9)	-	0.7
(19)	A-pillar lining	(see 43A, Side upper structure, Windscreen pillar lining: Description, page 43A-16)	HLE	1.5/2
(20)	Roof front cross member	(see 45A, Top of body, Roof front cross member: Description, page 45A-12)	HLE	0.7

SIDE LOWER STRUCTURE

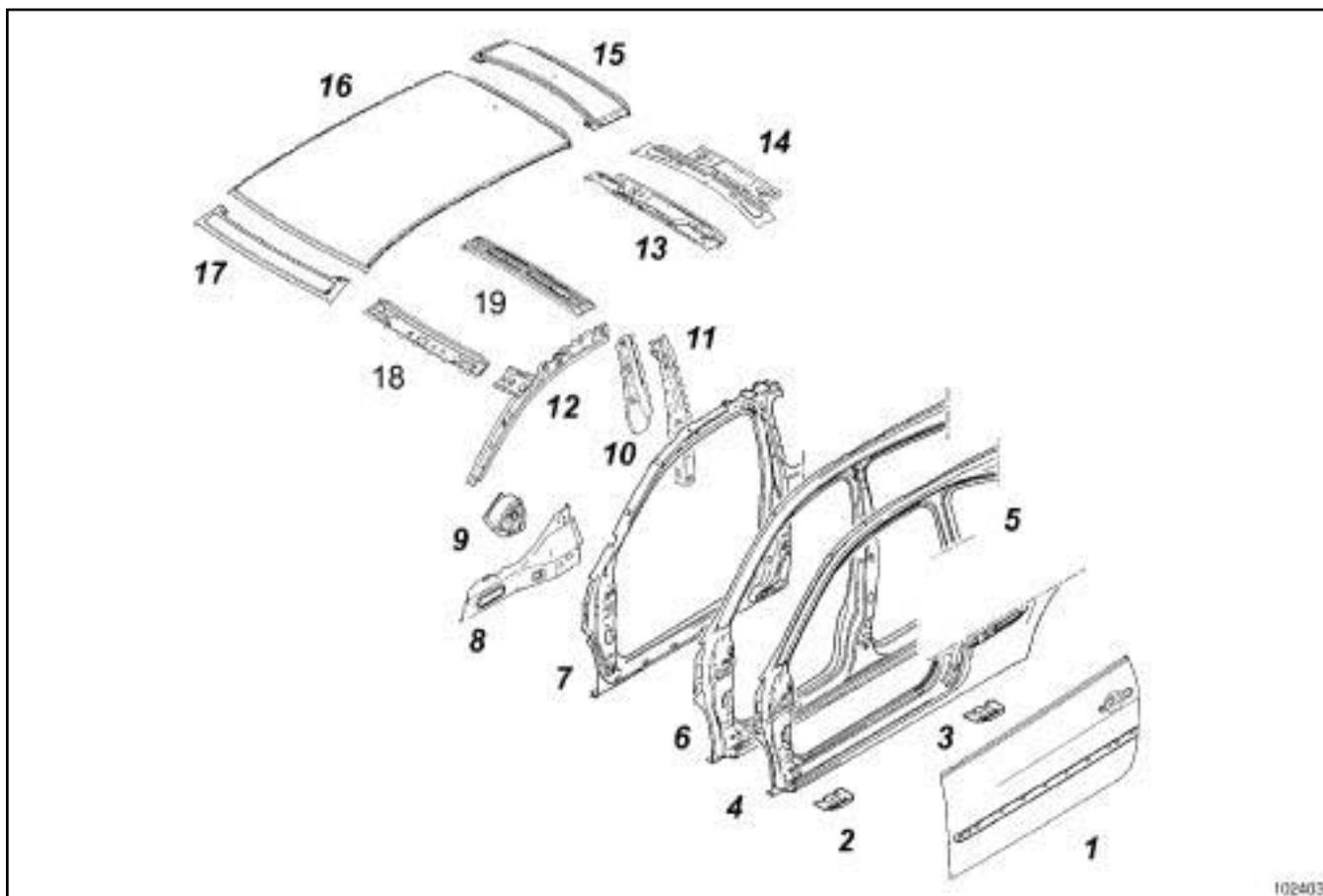
41C

Vehicle side section structure: Description

B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(21)	Roof	(see 45A, Top of body, Roof: Description, page 45A-7)	-	0.7
(22)	Rear section of roof	(see 45A, Top of body, Roof rear section: Description, page 45A-10)	-	0.7

C84



102403

102403

Mark	Description	Classification	Type	Thickness (mm)
(1)	Front side door panel	(see Front side door panel: Description)	HLE	0.7/0.95
(2)	Front jack support	(see Front jacking point: Description)	HLE	1.8
(3)	Rear jack support	(see Front jacking point: Description)	HLE	1.8

SIDE LOWER STRUCTURE

41C

Vehicle side section structure: Description

B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(4)	Sill panel	(see 41C, Side lower structure, Sill panel: Description, page 41C-9)	-	0.7
(5)	Upper body	(see 43A, Side upper structure, Upper body panel: Description, page 43A-47)	-	0.7
(6)	Body side front section	(see 43A, Side upper structure, Body side front section: Description, page 43A-39)	-	0.7
(7)	Body side front section reinforcement	(see 43A, Side upper structure, Body side front section reinforcement: Description, page 43A-42)	HLE	1.2/1.5
(8)	Rear inner sill panel	(see 41C, Side lower structure, Rear inner sill panel: Description, page 41C-23)	HLE	1
(9)	Anti-intrusion reinforcement			
(10)	Quarter panel front reinforcement		HLE	1.5
(11)	B-pillar reinforcement stiffener	(see B-pillar reinforcement stiffener: Description)	VHLE	1.8
(12)	A-pillar lining	(see 43A, Side upper structure, Windscreen pillar lining: Description, page 43A-16)	HLE	1.5/2
(13)	Roof rear cross member without sunroof	(see 45A, Top of body, Roof rear cross member: Description, page 45A-16)	HLE	0.7/0.9
(14)	Roof rear cross member with sunroof	(see 45A, Top of body, Roof rear cross member: Description, page 45A-16)	HLE	0.7/0.9
(15)	Rear section of roof	(see 45A, Top of body, Roof rear section: Description, page 45A-10)	-	0.7
(16)	Roof	(see 45A, Top of body, Roof: Description, page 45A-7)	-	0.7
(17)	Front section of roof	(see 45A, Top of body, Roof front section: Description, page 45A-9)	-	0.7

SIDE LOWER STRUCTURE

Vehicle side section structure: Description

41C

B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(18)	Roof front cross member	(see 45A, Top of body, Roof front cross member: Description, page 45A-12)	HLE	0.7
(19)	Roof middle cross member	(see 45A, Top of body, Roof centre cross member: Description, page 45A-14)	HLE	1.5



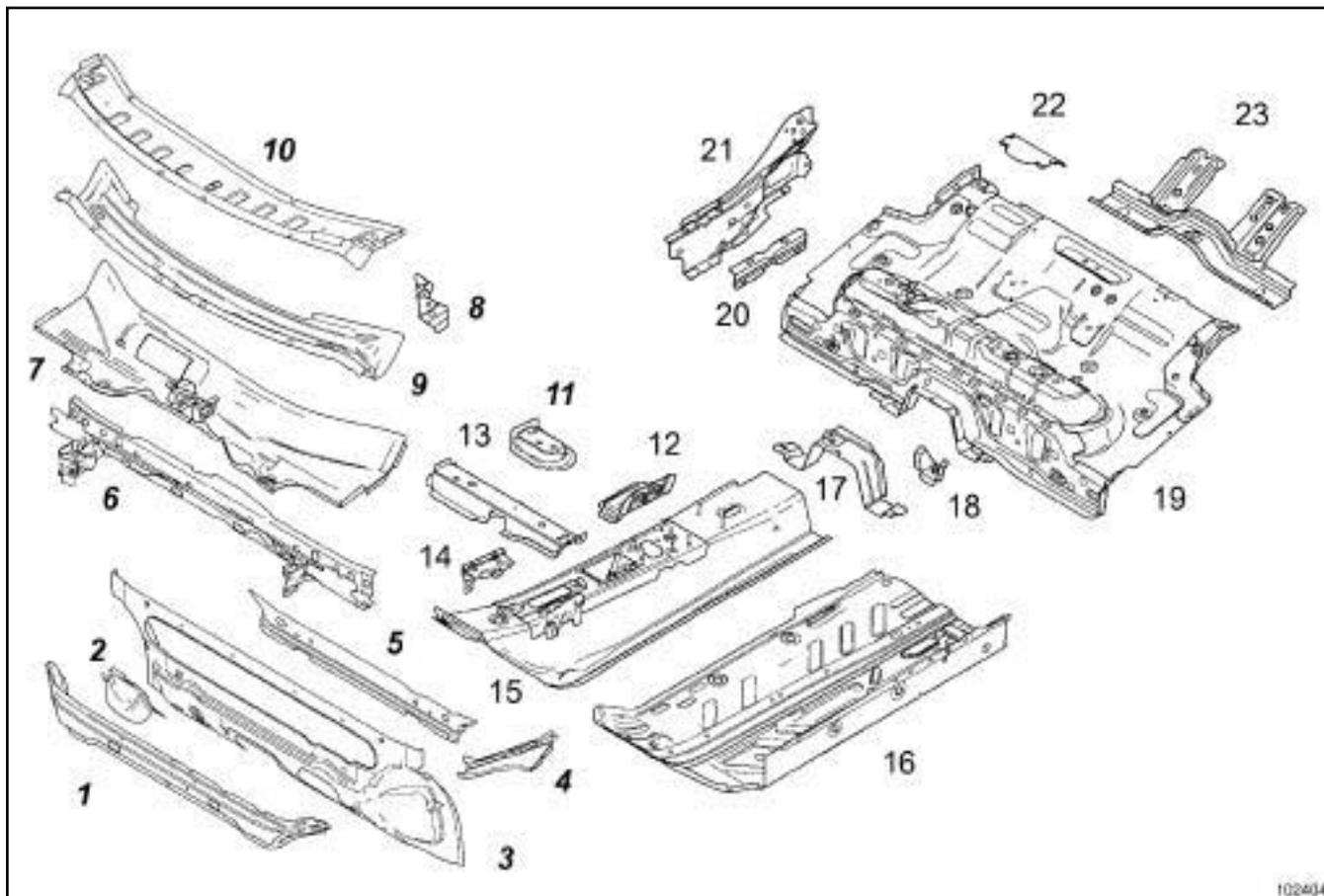
SIDE LOWER STRUCTURE

Vehicle central section structure: Description

41C

B84 or C84

CENTRAL STRUCTURE



102404

102404

Mark	Description	Classification	Type	Thickness (mm)
(1)	Bulkhead lower cross member	(see 42A, Upper front structure, Bulkhead lower cross member: Description, page 42A-53)	VHLE	2.5
(2)	Steering column unit		-	1.5
(3)	Bulkhead	(see 42A, Upper front structure, Bulkhead: Description, page 42A-49)	-	0.9
(4)	Bulkhead side reinforcement	(see 42A, Upper front structure, Bulkhead side stiffener: Description, page 42A-59)	UHLE	1.7
(5)	Bulkhead reinforcement	(see 42A, Upper front structure, Bulkhead reinforcement: Description, page 42A-51)	UHLE	1.7

SIDE LOWER STRUCTURE

Vehicle central section structure: Description

41C

B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(6)	Bulkhead upper cross member	(see 42A, Upper front structure, Bulkhead upper cross member: Description, page 42A-57)	HLE	0.95/3
(7)	Heater bulkhead	(see 42A, Upper front structure, Heater bulkhead: Description, page 42A-38)	-	0.7/1.2
(8)	Windscreen wiper mounting	(see 42A, Upper front structure, Windscreen wiper mounting: Description, page 42A-61)	-	1.2
(9)	Windscreen aperture lower cross member	(see 42A, Upper front structure, Windscreen aperture lower cross member: Description, page 42A-41)	-	0.7
(10)	Windscreen aperture lower cross member closure panel	(see 42A, Upper front structure, Windscreen aperture lower cross member closure panel: Description, page 42A-47)	-	0.65/1.2
(11)	Front seat mounting exterior unit	(see 41B, Centre lower structure, Front seat rear outer mounting unit: Description, page 41B-26)	HLE	1.5
(12)	Front seat mounting interior unit	(see 41B, Centre lower structure, Front seat rear mounting interior unit: Description, page 41B-25)	HLE	1.5/2.5
(13)	Front cross member under front seat	(see 41B, Centre lower structure, Front cross member under front seat: Description, page 41B-23)	HLE	1.5
(14)	Steering column mounting		-	1.3
(15)	Tunnel	(see 41B, Centre lower structure, Tunnel: Description, page 41B-20)	HLE/ THLE	1/1.6
(16)	Centre floor, side section	(see 41B, Centre lower structure, Central floor, side section: Description, page 41B-13)	VHLE	0.7/2.5
(17)	Exhaust mounting support	(see 41D, Rear lower structure, Exhaust mounting support: Description, page 41D-30)	-	1.2/2.5

SIDE LOWER STRUCTURE

Vehicle central section structure: Description

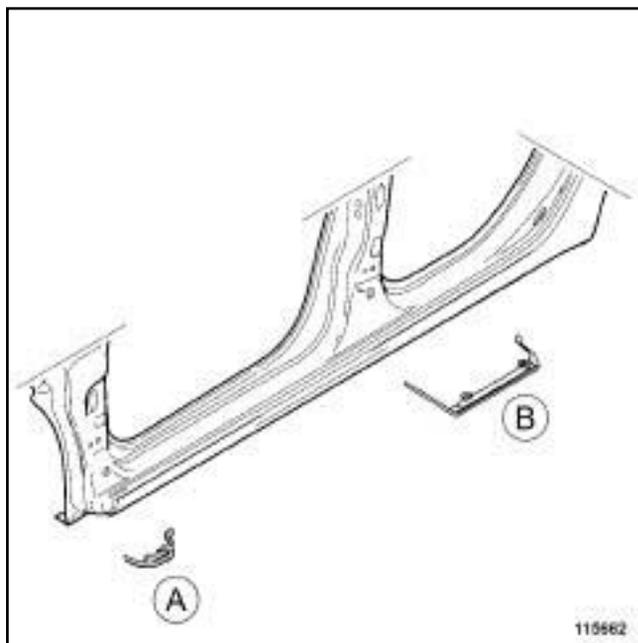
41C

B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(18)	Fuel tank mounting support	(see 41D, Rear lower structure, Tank mounting support: Description, page 41D-31)	-	1.2
(19)	Front section of rear floor	(see 41D, Rear lower structure, Rear floor, front section: Description, page 41D-10)	HLE/ THLE	0.7/2.5
(20)	Sill panel reinforcement stiffener		VHLE	1.8
(21)	Sill panel rear reinforcement	(see 41C, Side lower structure, Sill panel rear reinforcement: Description, page 41C-29)	HLE	1.4
(22)	Fuel gauge closure panel		HLE	0.8
(23)	Rear floor front cross member, centre section	(see 41D, Rear lower structure, Rear floor front cross member, centre section: Description, page 41D-25)	HLE	1.2/2

B84 or C84

B84



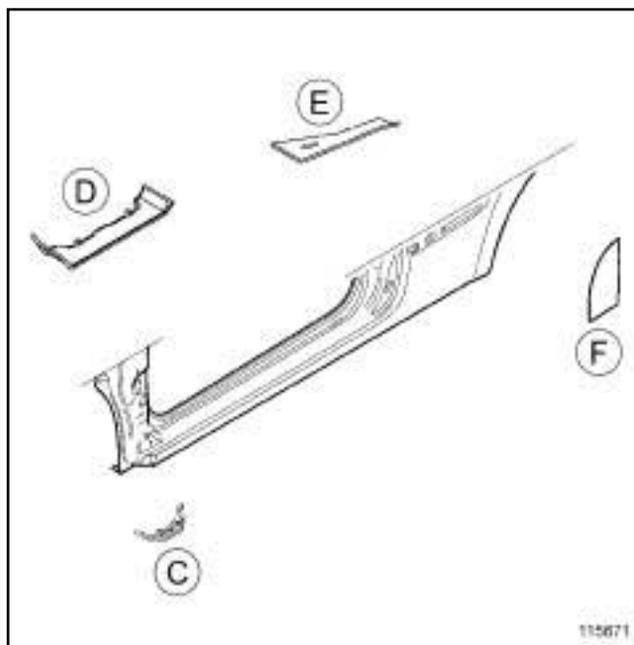
115662

To replace this part, order the expanding inserts corresponding to each of the following cases.

The options for replacing this part are as follows:

- partial replacement of the front end section: order insert **(A)** ,
- partial replacement under door:
- partial replacement centre section: order insert **(B)** ,
- Complete replacement: order inserts **(A)** and **(B)** .

C84



115671

To replace this part, order the expanding inserts corresponding to each of the following cases.

The options for replacing this part are as follows:

- partial replacement of the front end section: order insert **(C)** ,
- partial replacement under door:
- complete replacement: order inserts **(C)** , **(D)** and **(E)** .

For the complete replacement of the sill panel on 3- and 5-door versions, also order anti-grit protective film **(F)** .

SIDE LOWER STRUCTURE

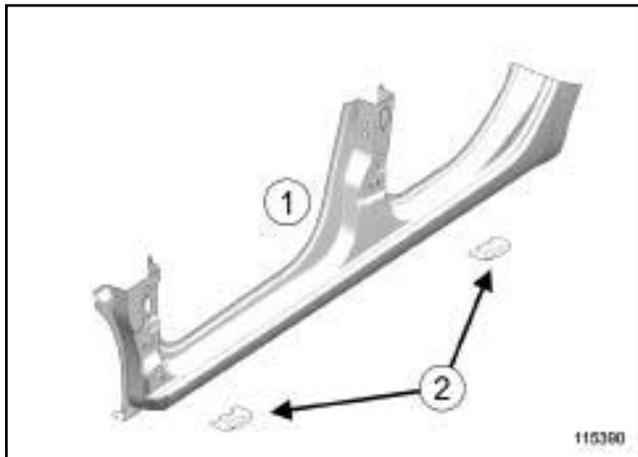
Sill panel: Description

41C

B84 or C84

I - COMPOSITION OF THE SPARE PART

B84



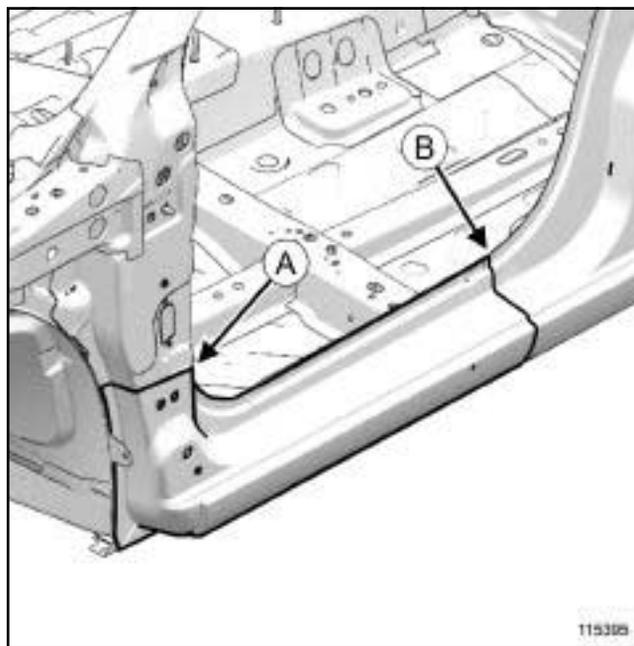
115390
115390

Number	Description	Type	Thickness (mm)
(3)	Sill panel	-	0.7
(4)	Jacking point	HEL	1.8

II - PART FITTED

1 - Partial replacement of the front end section

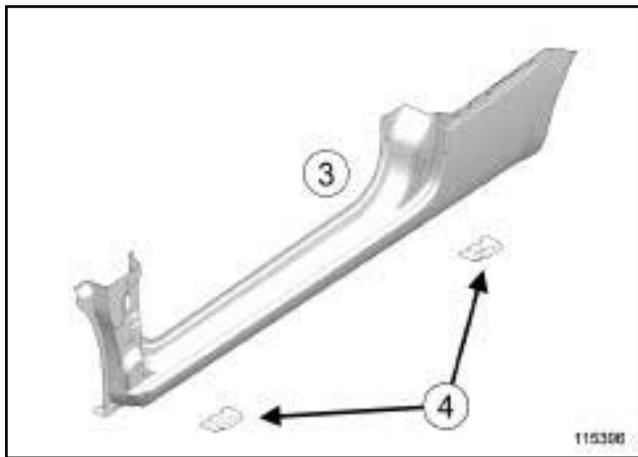
B84



115395
115395

Number	Description	Type	Thickness (mm)
(1)	Sill panel	-	0.7
(2)	Jacking point	HEL	1.8

C84



115396
115396

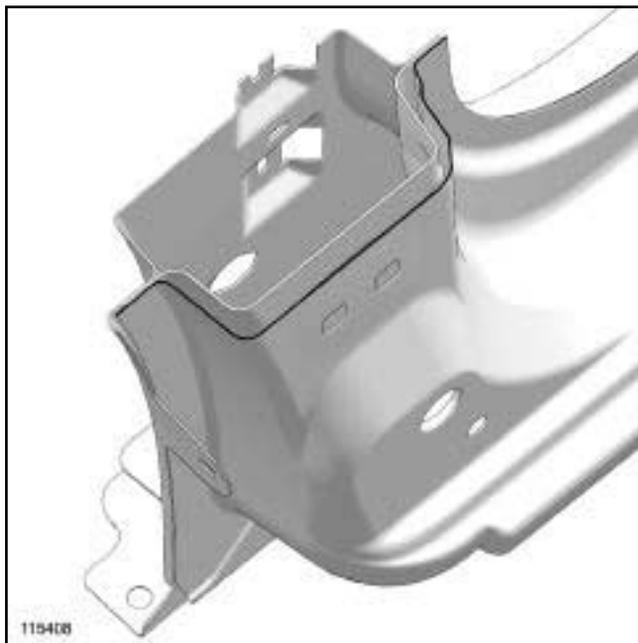
SIDE LOWER STRUCTURE

Sill panel: Description

41C

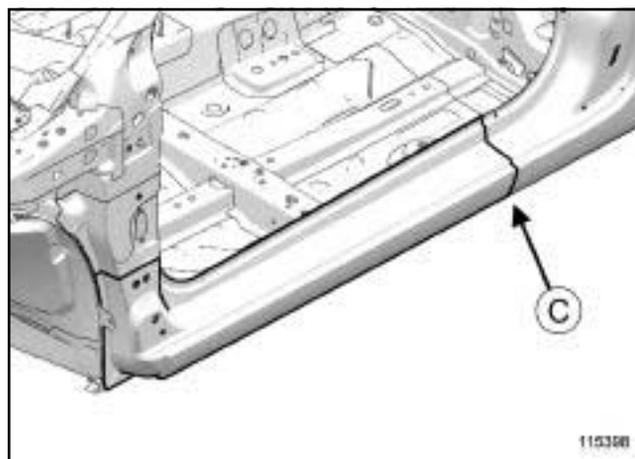
B84 or C84

Cut A



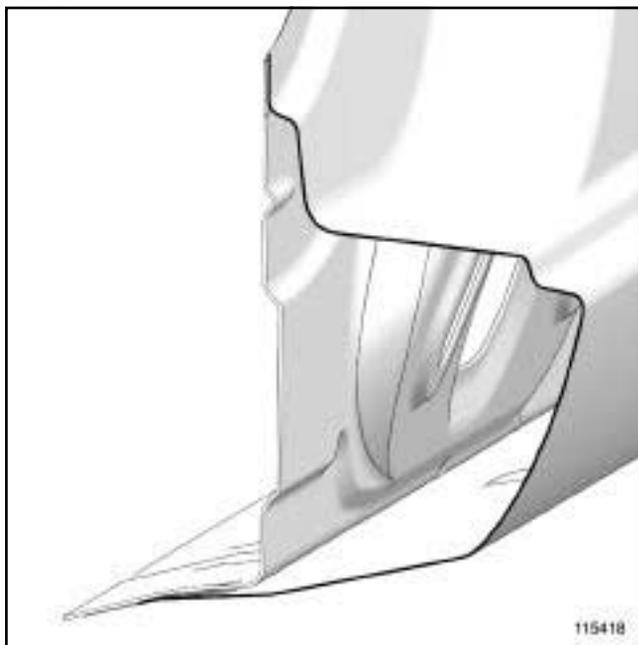
115408

C84



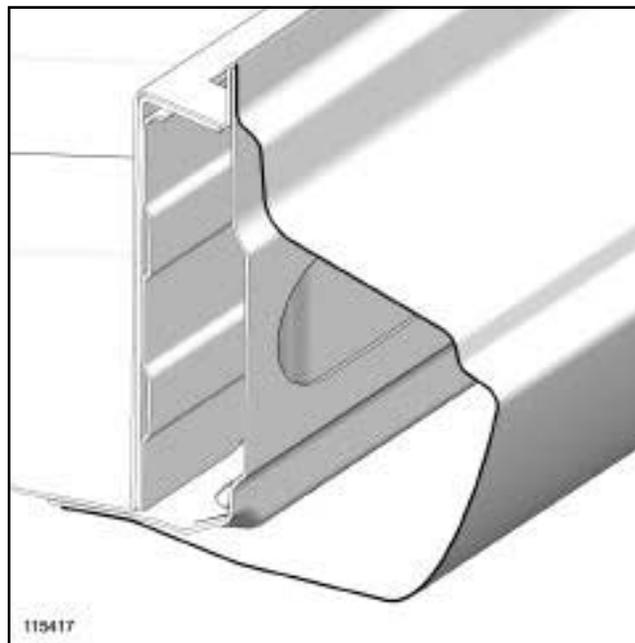
115398

Cut B



115418

Cut C

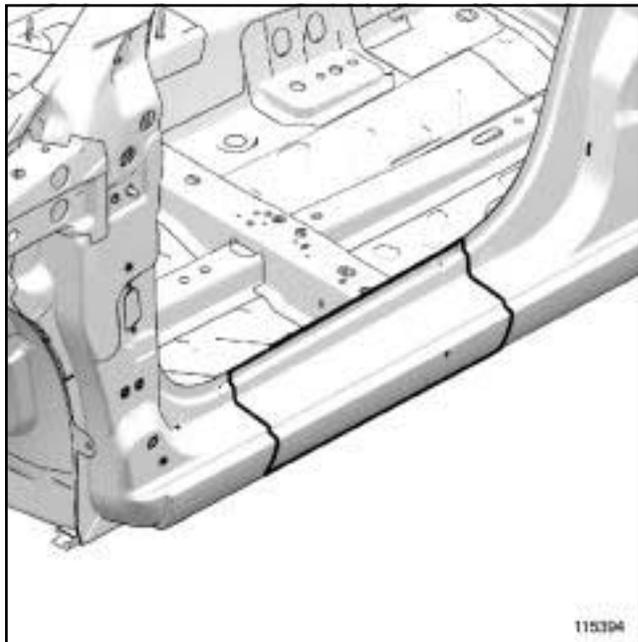


115417

B84 or C84

2 - Partial replacement under door

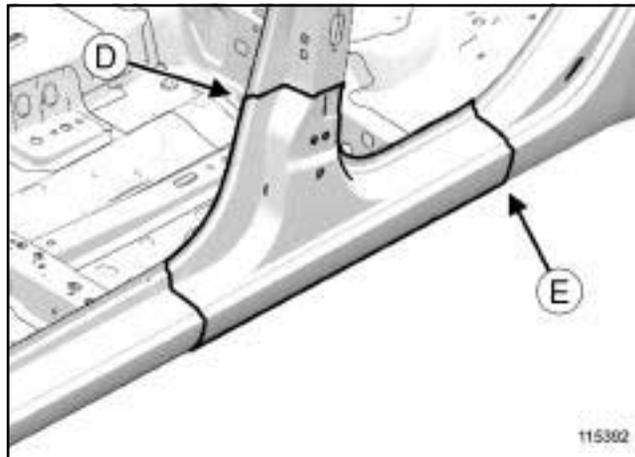
B84



115394

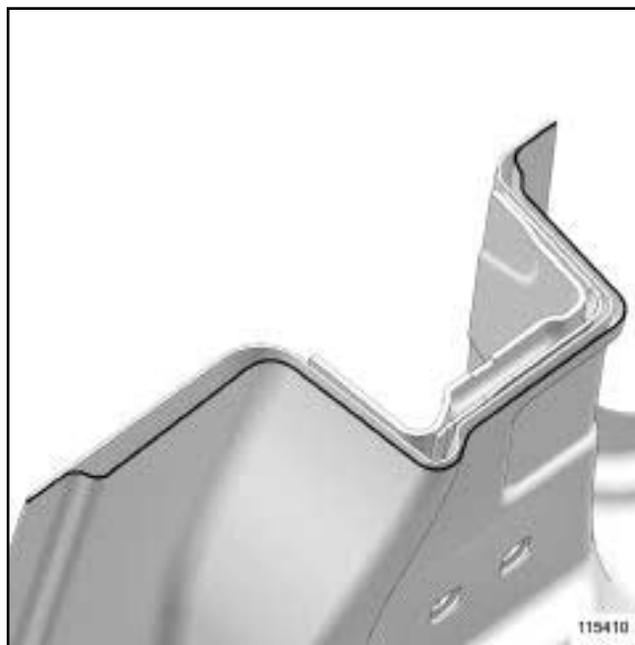
3 - Central partial replacement

B84



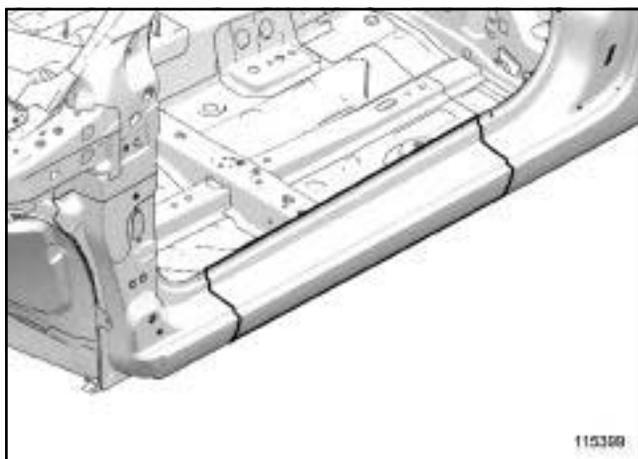
115392

Cut D



115410

C84



115399

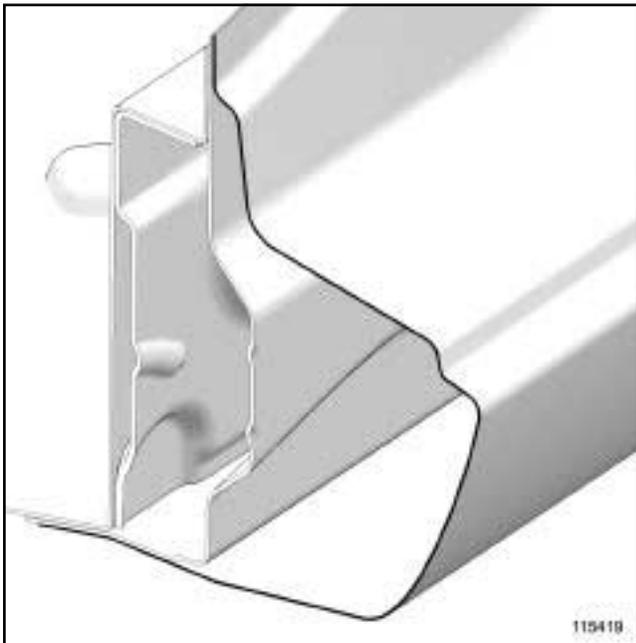
SIDE LOWER STRUCTURE

Sill panel: Description

41C

B84 or C84

Cut E

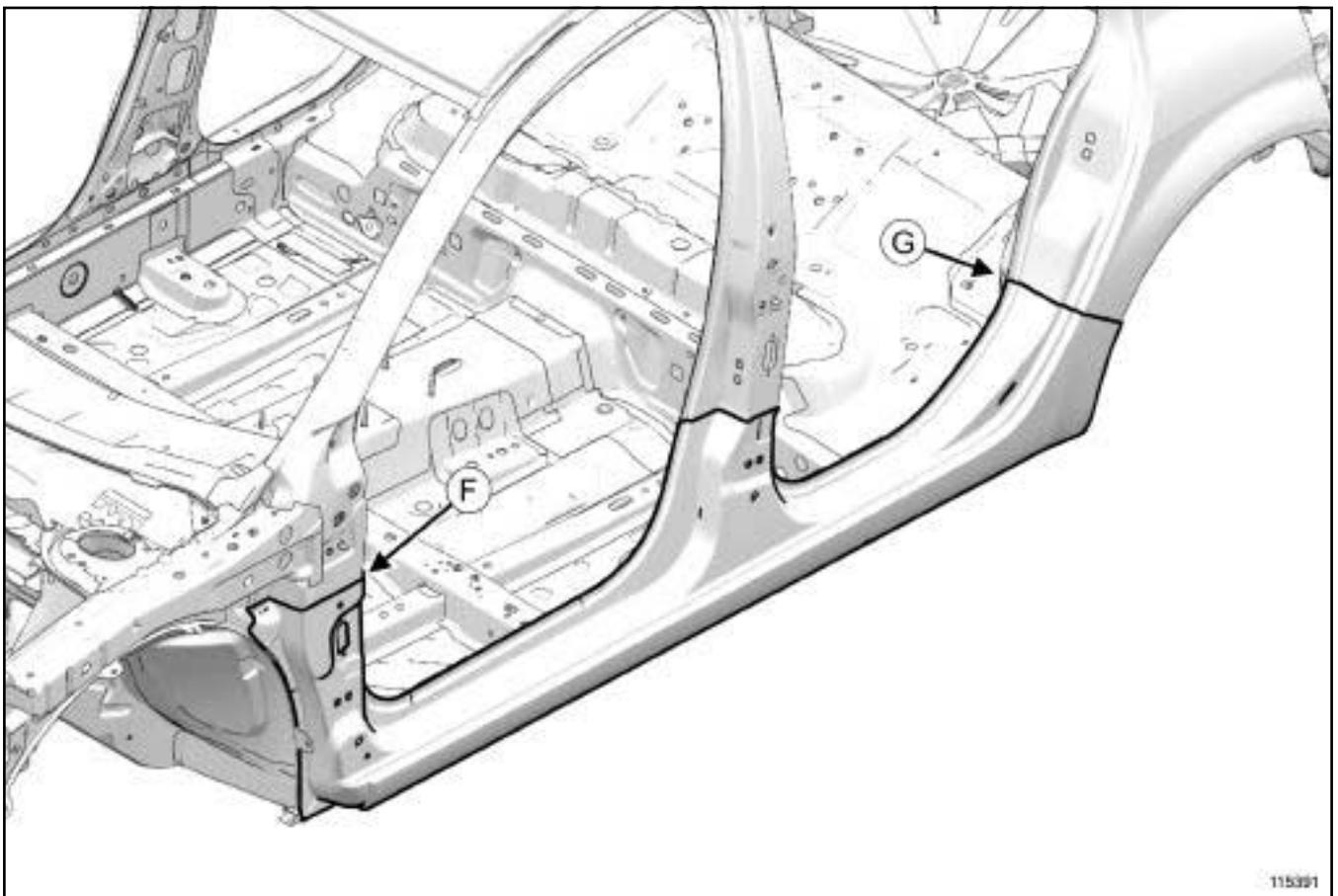


115419

115419

4 - Complete replacement

B84



115391

115391

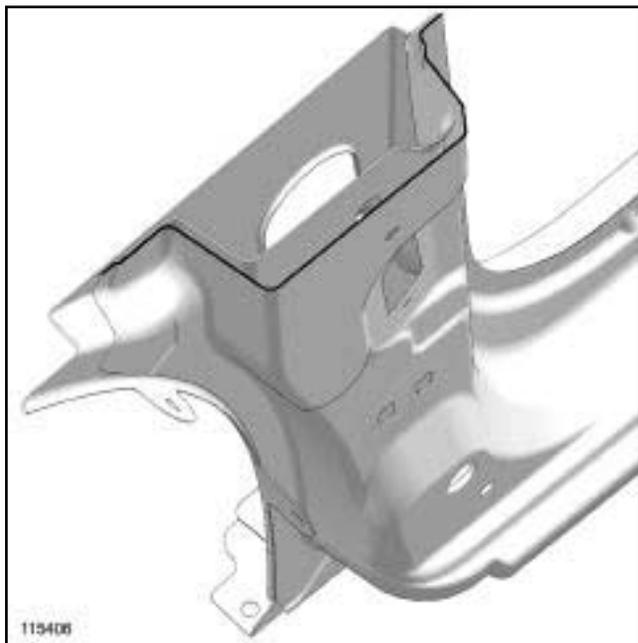
SIDE LOWER STRUCTURE

Sill panel: Description

41C

B84 or C84

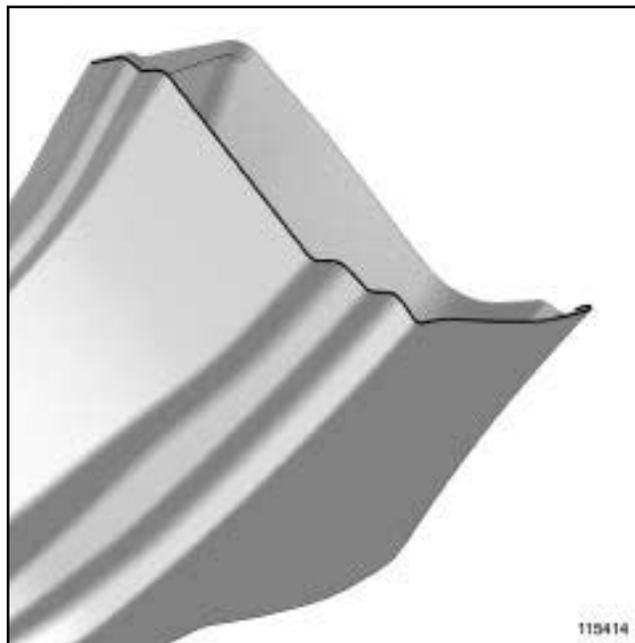
Cut F



115406

115406

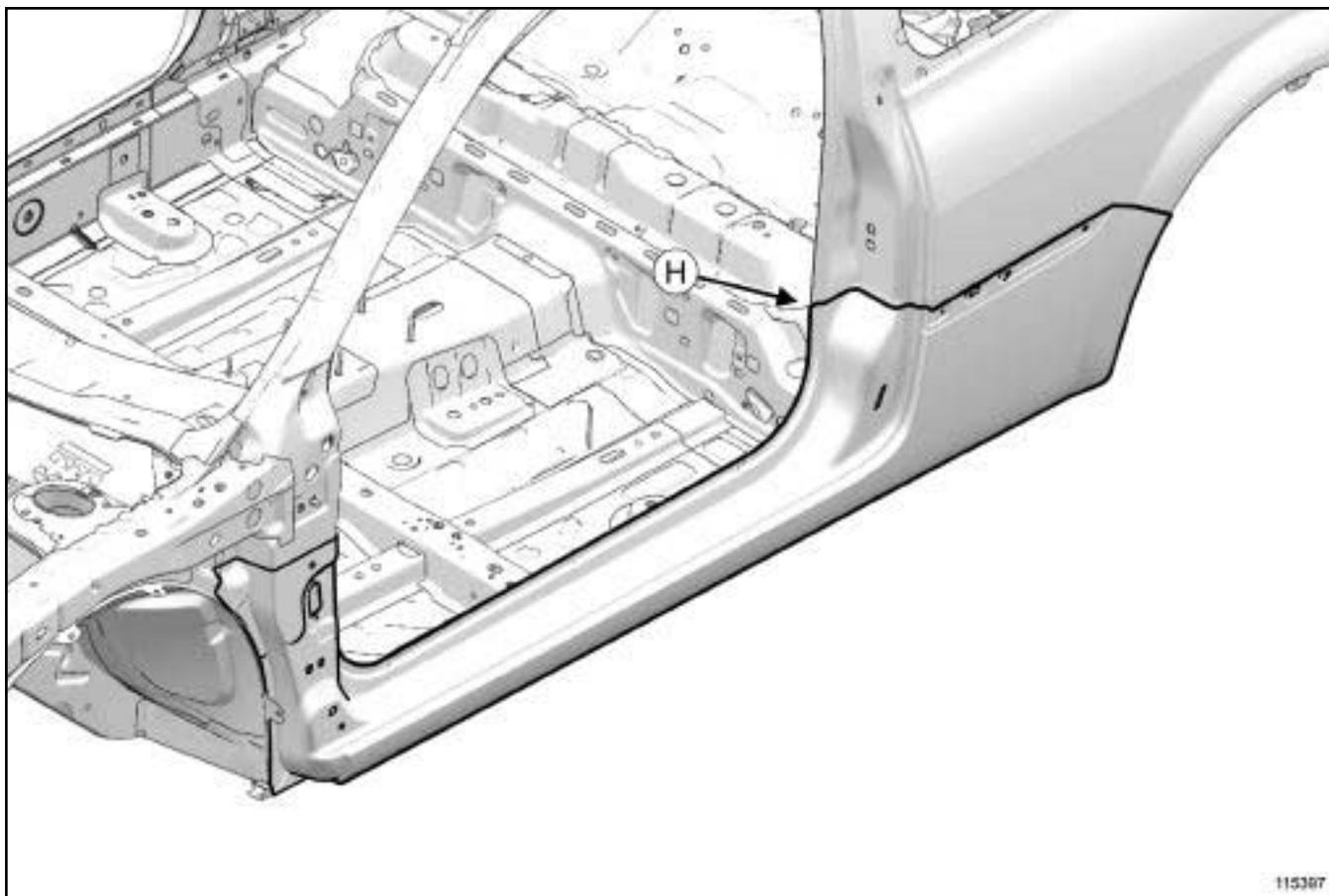
Cut G



115414

115414

C84

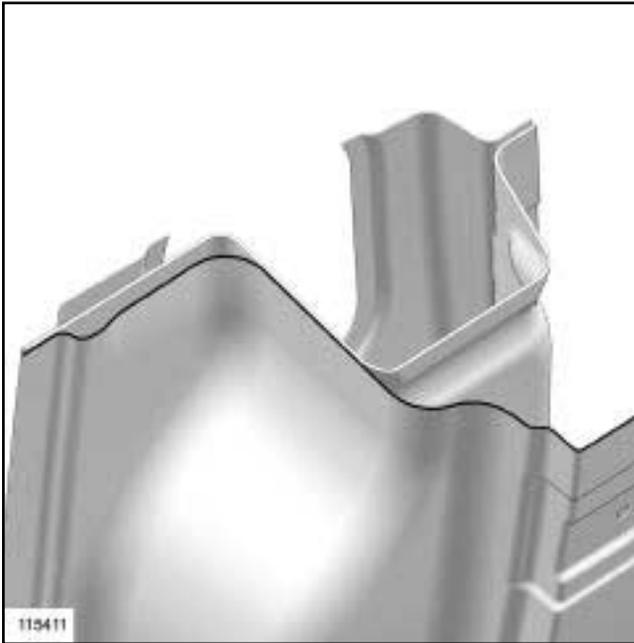


115397

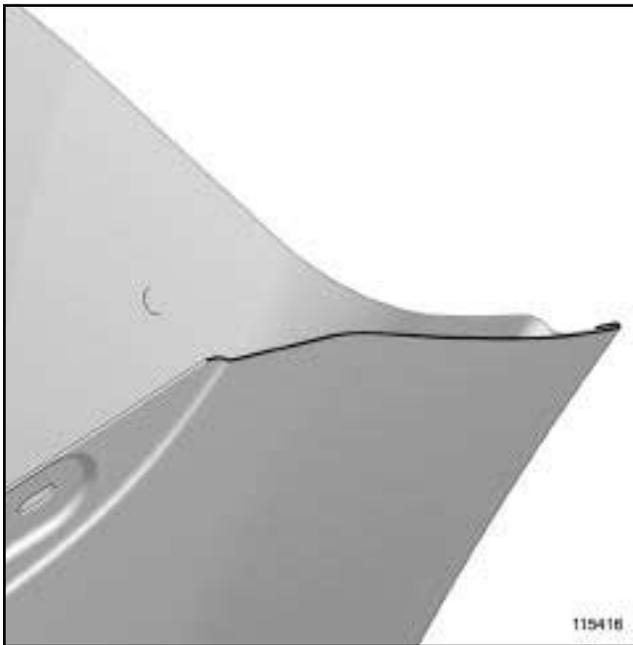
115397

B84 or C84

Cut H



115411



115416

III - ANTI-GRIT PROTECTION

To fit anti-grit protective adhesive film, see **Technical Note 579A, Anti-grit protective adhesive film, 55A, Exterior protection, Anti-grit protective adhesive film** .

WARNING

If the spot welds cannot be made as they were originally using an electric spot welding machine, they should be replaced with plug welds after holes have been drilled in the first panel.

SIDE LOWER STRUCTURE

Complete sill panel: General description

41C

B84 or C84

WARNING

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading this general information, check that there are no special notes associated with this vehicle. These special notes will be specified if applicable in other parts of this sub-section dealing with the part.

Note:

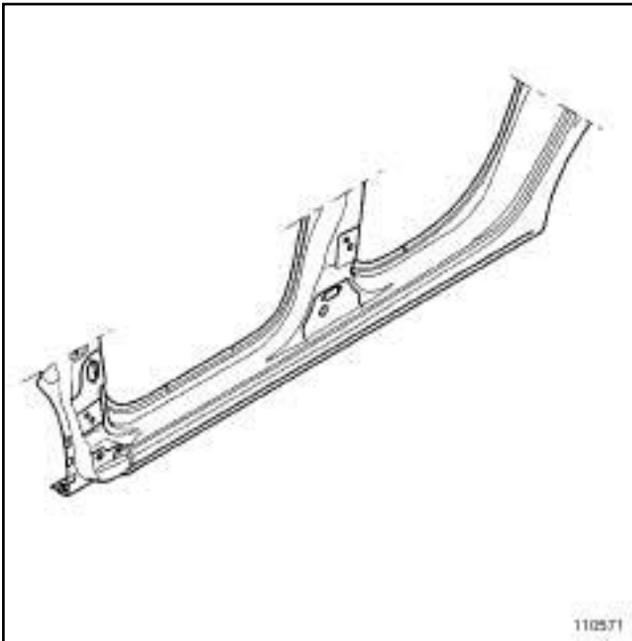
For a detailed description of a particular connection, see **MR 400, 40A, General Information**.

IMPORTANT

Before any operation, remove the front seat belts.

I - DESIGN OF THE STRUCTURAL COMPONENT

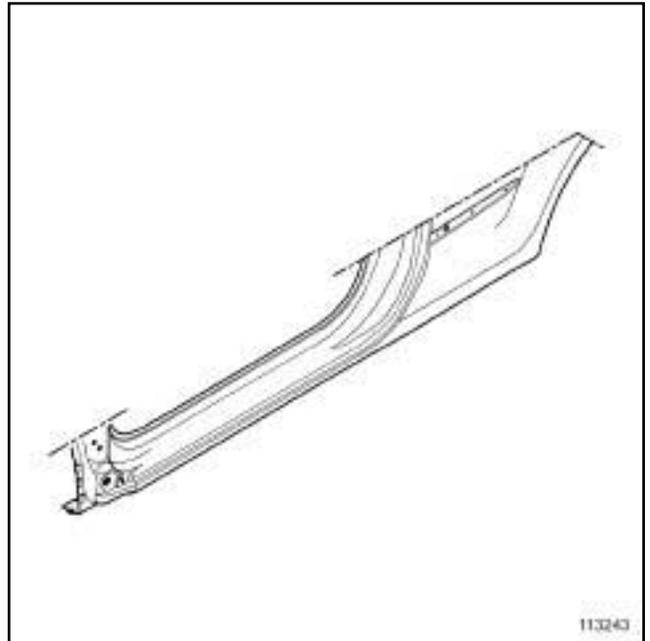
B84



110571

The special feature of this part is that its lower section is butt welded by laser with two different types of panel and two different thicknesses.

C84



113243

The special feature of this part is that its lower section is butt welded by laser with two different types of panel and two different thicknesses.

This is a basic part; it only functions as a sill panel.

SIDE LOWER STRUCTURE

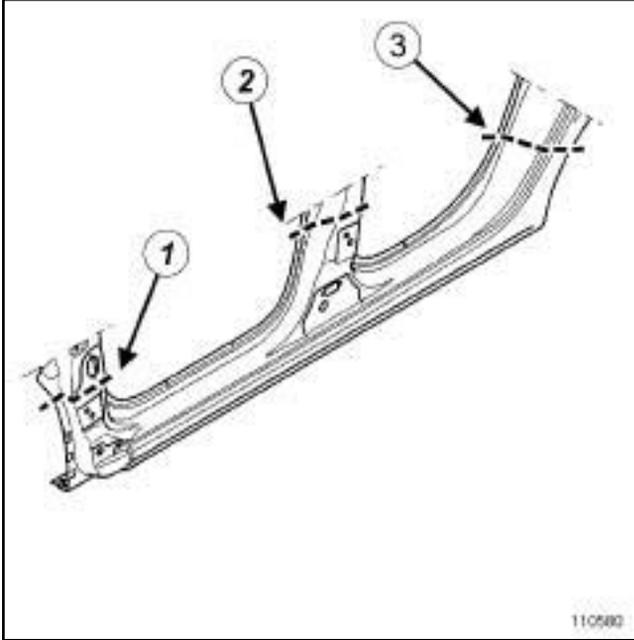
Complete sill panel: General description

41C

B84 or C84

II - AREA TO BE CUT FOR COMPLETE REPLACEMENT

B84



110580

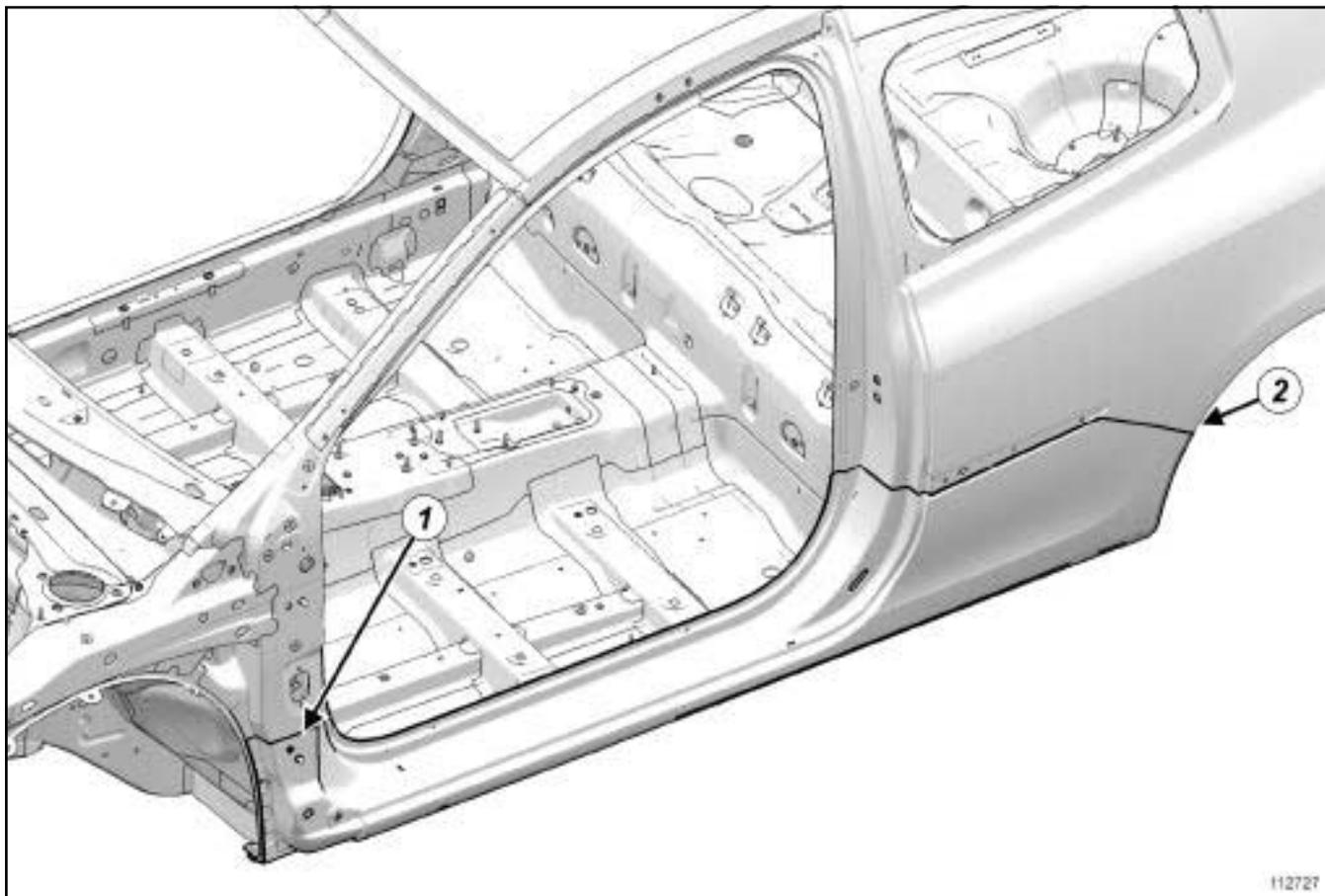
SIDE LOWER STRUCTURE

Complete sill panel: General description

41C

B84 or C84

C84



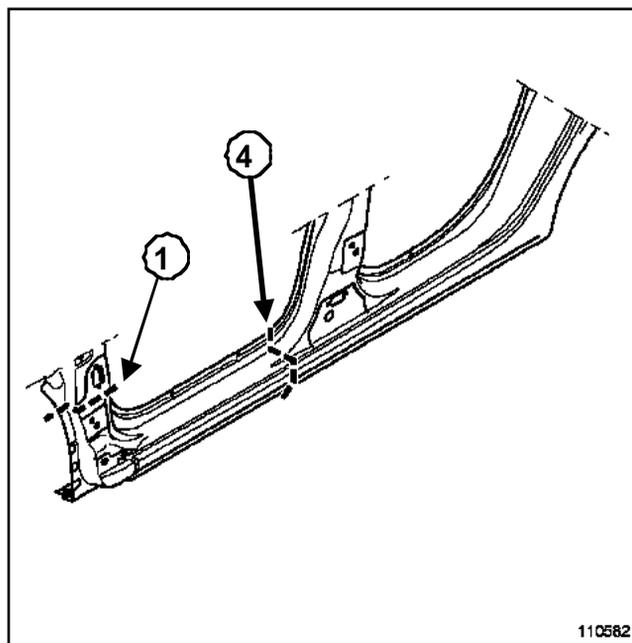
112727

112727

III - AREA TO BE CUT FOR PARTIAL REPLACEMENT

Cut 1, 2 and 3:

These cut lines show the complete replacement of the sill panel.



110582

110582

SIDE LOWER STRUCTURE

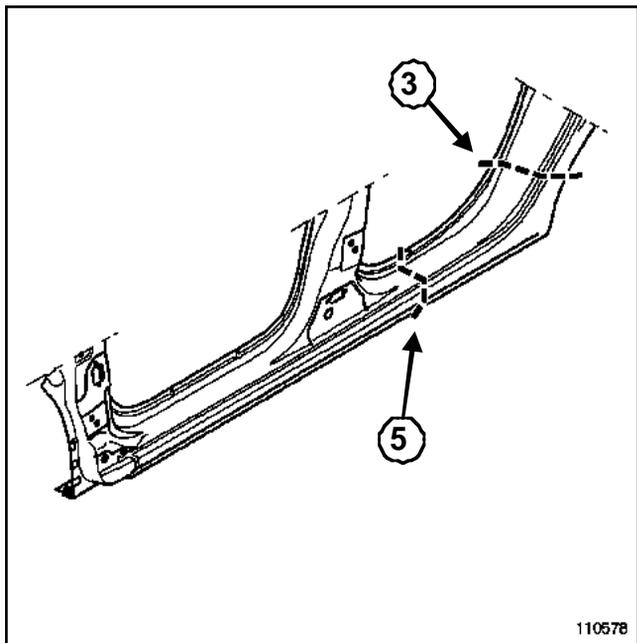
Complete sill panel: General description

41C

B84 or C84

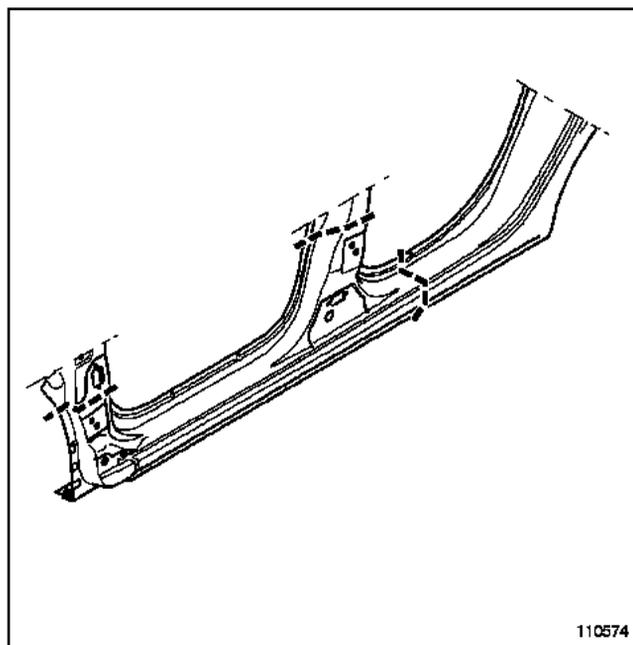
Cut 1 and 4.

These cut lines show the partial front replacement of the sill panel.



110578

110578

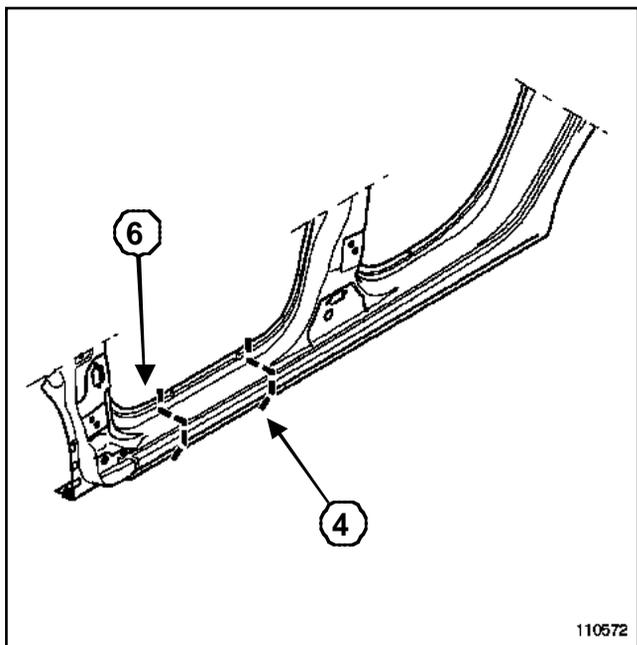


110574

110574

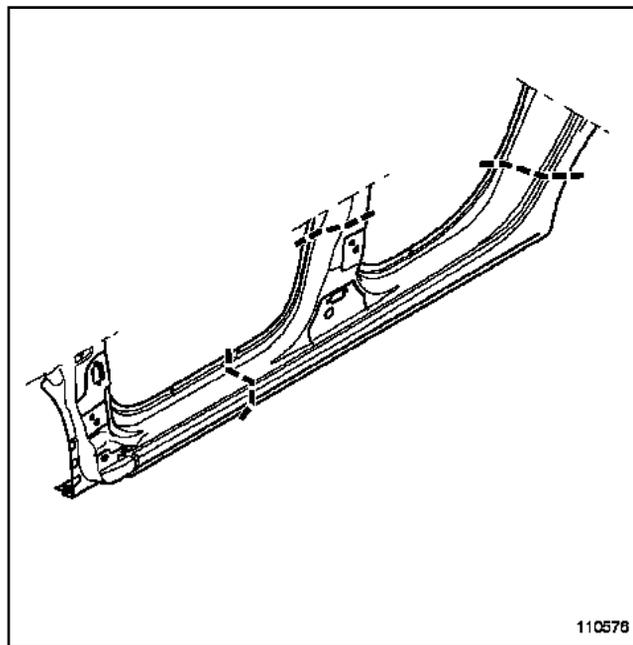
Cut 3 and 5.

These cut lines show the partial rear replacement of the sill panel.



110572

110572



110576

110576

It is possible to use cuts made previously to carry out larger partial replacements:

- front partial replacement,
- rear partial replacement.

These operations allow you to access the inside of the hollow section of the structural component to straighten it.

Cut 4 and 6.

These cut lines show the partial under door replacement of the sill panel.

SIDE LOWER STRUCTURE

Complete sill panel: General description

41C

B84 or C84

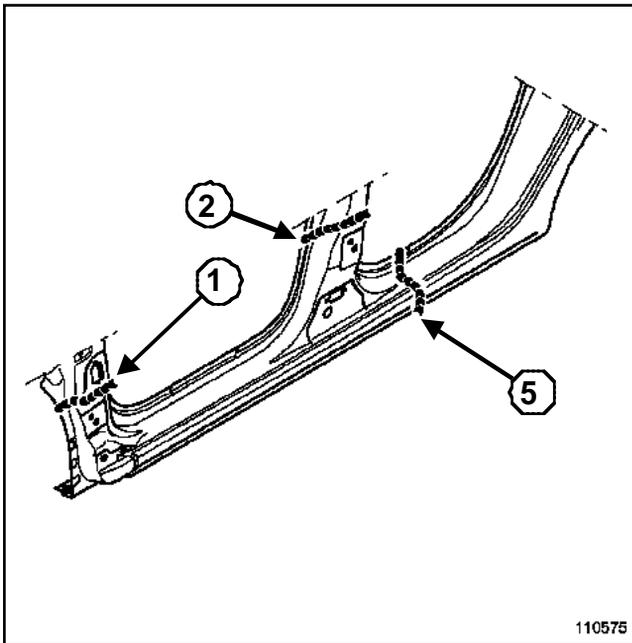
IV - ASSEMBLY INSTRUCTIONS FOR A PARTIAL REPLACEMENT

Only the connecting pieces relevant to partial replacement by cutting are shown.

WARNING

If the spot welds cannot be made as they were originally using an electric spot welding machine, they should be replaced with plug welds after holes have been drilled in the first panel.

If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400, 40A, General information**).



110575

Lines (1) , (2) and (5) of the diagram show a butt weld by continuous MAG welding.

All the welds described in this procedure are identical.

Full inner sill panel: General description

B84 or C84

WARNING

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

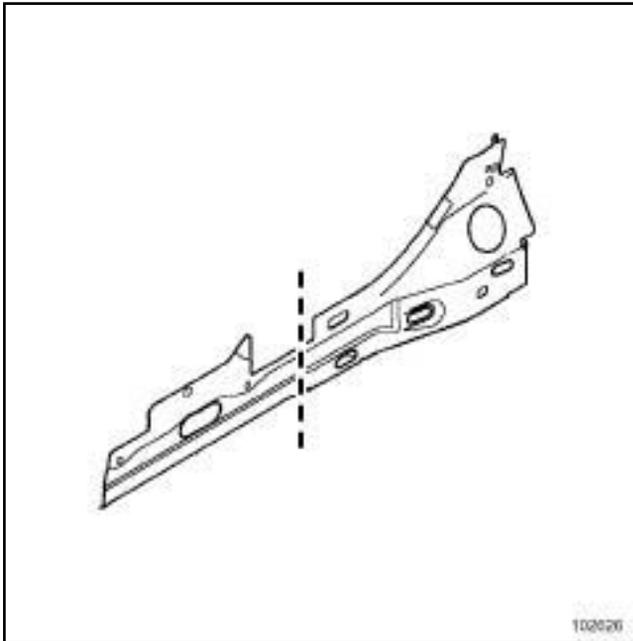
Before reading this general information, check that there are no special notes associated with this vehicle. These special notes will be specified if applicable in other parts of this sub-section dealing with the part.

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information**.

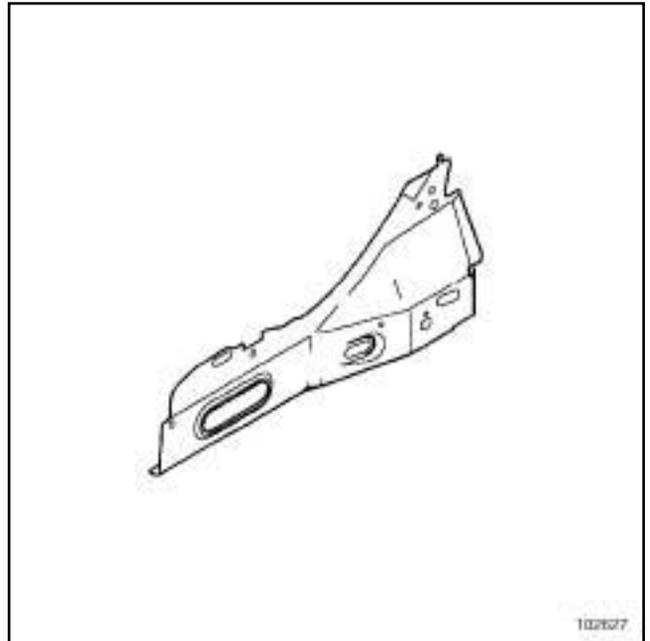
I - DESIGN OF THE STRUCTURAL COMPONENT

B84



This is a basic part; it only functions as an inner sill panel.

C84



102627

This is a basic part; it only functions as an inner sill panel.

II - AREA TO BE CUT FOR PARTIAL REPLACEMENT

C84, and LONG CHASSIS

This part is replaced completely on this type of vehicle.

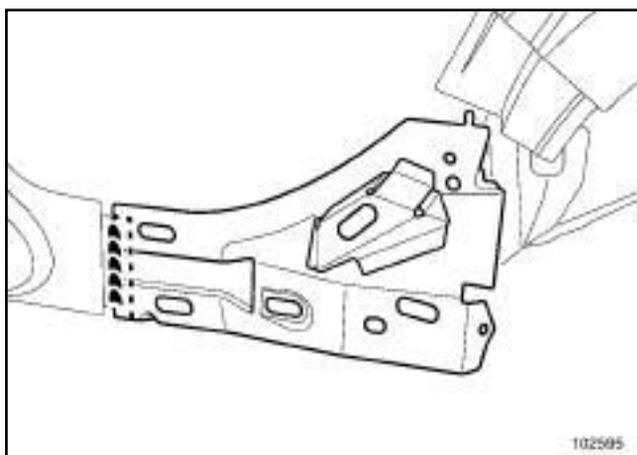
SIDE LOWER STRUCTURE

Full inner sill panel: General description

41C

B84 or C84

B84



102595

Line (1) of the diagram shows a butt weld by continuous MAG welding.

III - ASSEMBLY INSTRUCTIONS FOR A PARTIAL REPLACEMENT

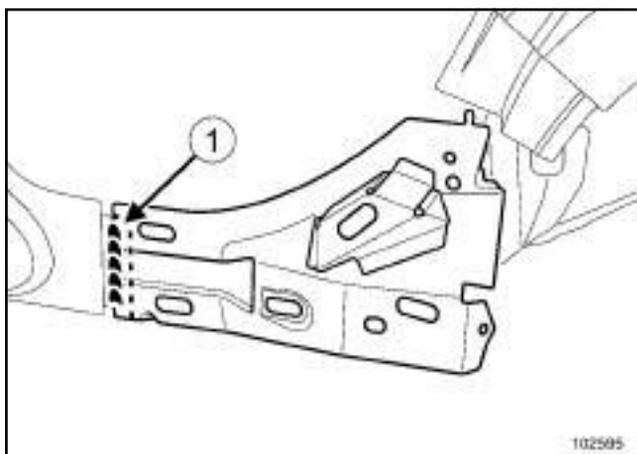
Only the connecting pieces relevant to partial replacement by cutting are shown.

WARNING

If the spot welds cannot be made as they were originally using an electric spot welding machine, they should be replaced with plug welds after holes have been drilled in the first panel.

If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400, 40A, General Information**).

B84



102595

SIDE LOWER STRUCTURE

Rear inner sill panel: Description

41C

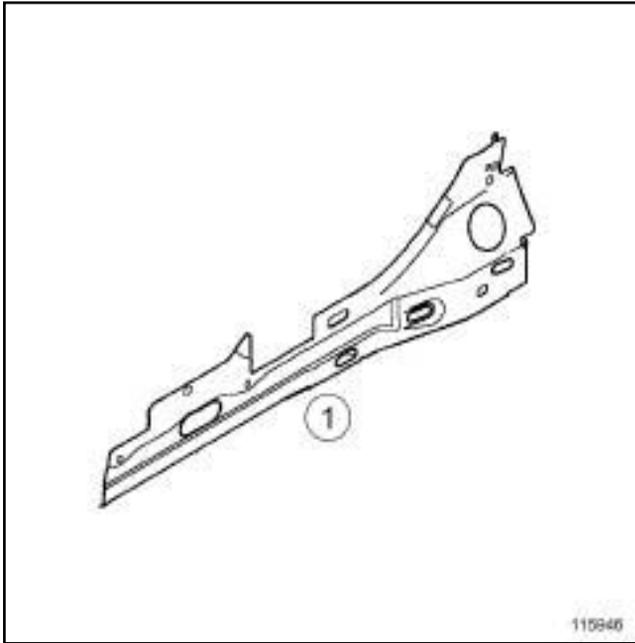
B84 or C84

The options for replacing this part are as follows:

- partial replacement (5-door version),
- complete replacement.

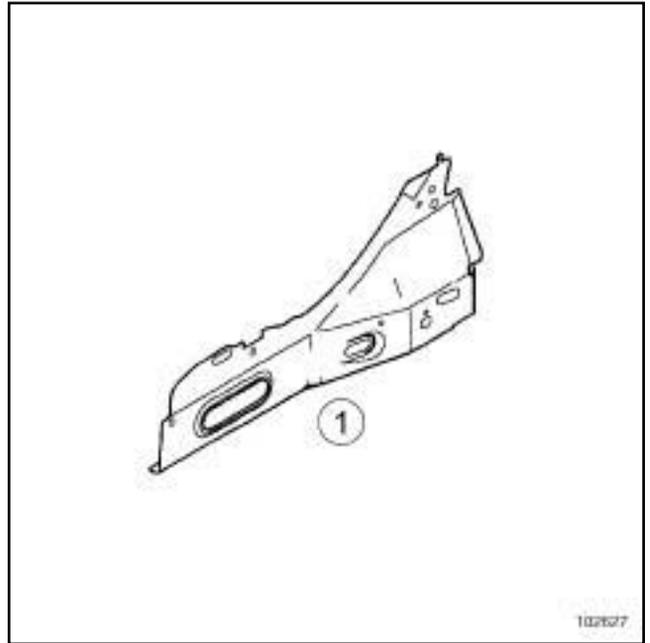
I - COMPOSITION OF THE SPARE PART

B84



115946

C84



102627

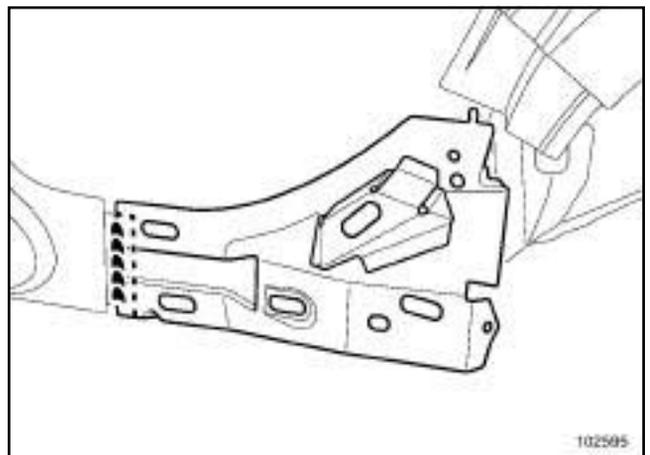
102627

Number	Description	Type	Thickness (mm)
(1)	Rear inner sill panel	-	1

II - PART FITTED

1 - Partial replacement

B84



102595

102595

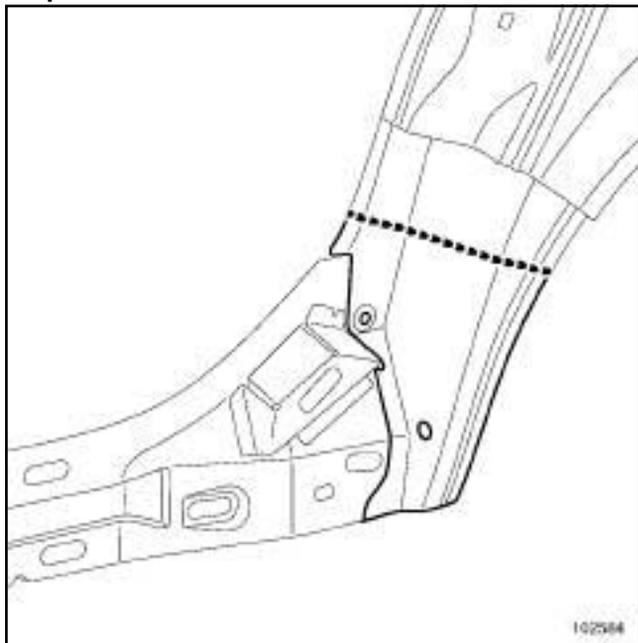
SIDE LOWER STRUCTURE

Rear inner sill panel: Description

41C

B84 or C84

Special note on the replacement of the rear inner sill panel



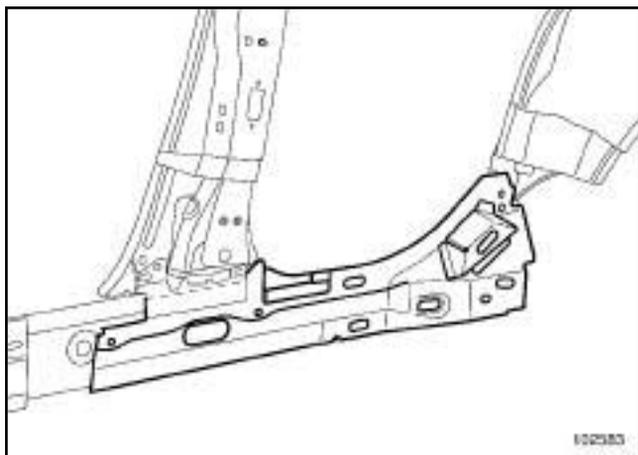
102584

Note:

Make a partial cut on the outer rear wheel arch to unweld the rear inner sill panel.

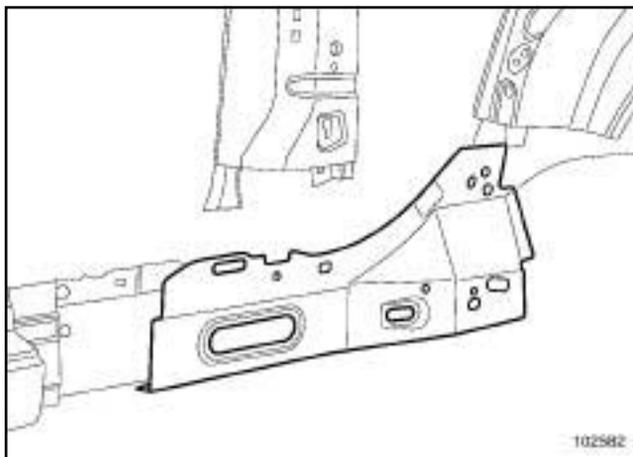
2 - Complete replacement

B84



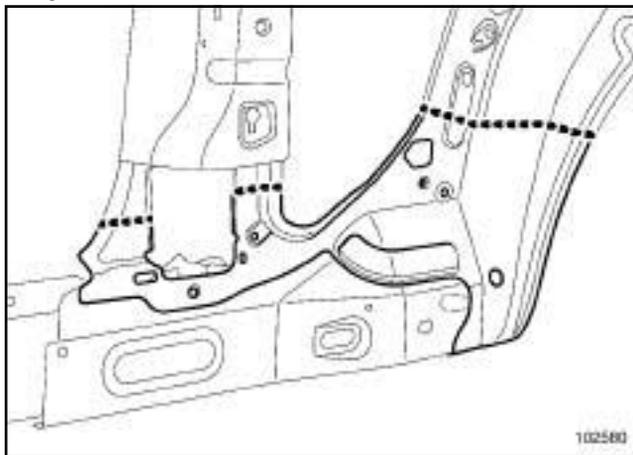
102583

C84



102582

Special note on the replacement of the rear inner sill panel



102580

WARNING

If the spot welds cannot be made as they were originally using an electric spot welding machine, they should be replaced with plug welds after holes have been drilled in the first panel.

Sill panel reinforcement: General description

B84 or C84

WARNING

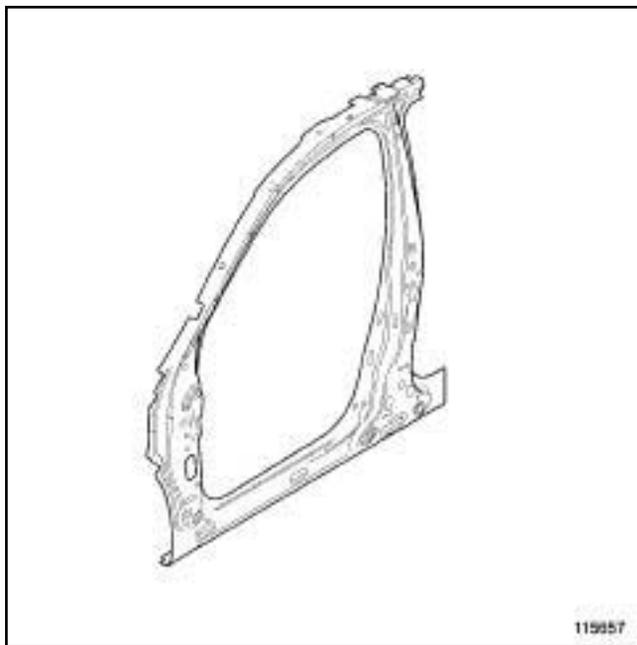
The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading this general information, check that there are no special notes associated with this vehicle. These special notes will be specified if applicable in other parts of this sub-section dealing with the part.

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information**.

I - DESIGN OF THE STRUCTURAL COMPONENT

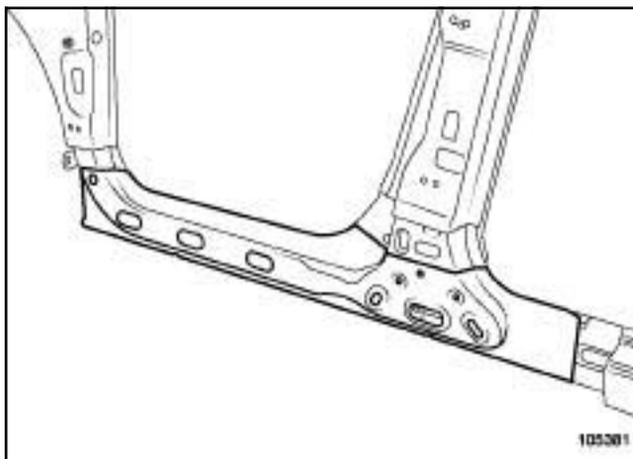


115657

The distinctive feature of this part is that it combines several functions:

- sill panel reinforcement,
- A-pillar reinforcement
- B-pillar reinforcement,
- body side front section reinforcement.

II - AREA TO BE CUT FOR PARTIAL REPLACEMENT



105381

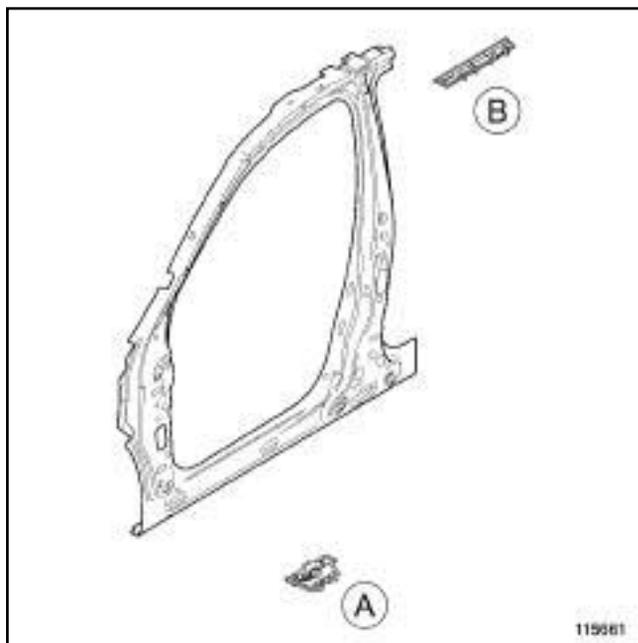
SIDE LOWER STRUCTURE

Sill panel reinforcement: Description

41C

B84 or C84

B84



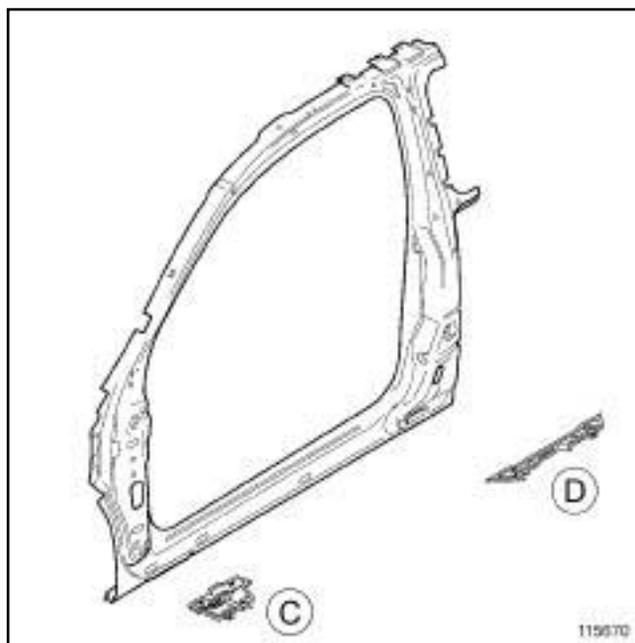
115661

To replace this part, order the expanding inserts corresponding to each of the following cases.

The options for replacing this part are as follows:

- partial replacement of the front section: order insert (A) ,
- Complete replacement: order inserts (A) and (B) .

C84



115670

To replace this part, order the expanding inserts corresponding to each of the following cases.

The options for replacing this part are as follows:

- partial replacement of the front section: order insert (C) ,
- Complete replacement: order inserts (C) and (D) .

SIDE LOWER STRUCTURE

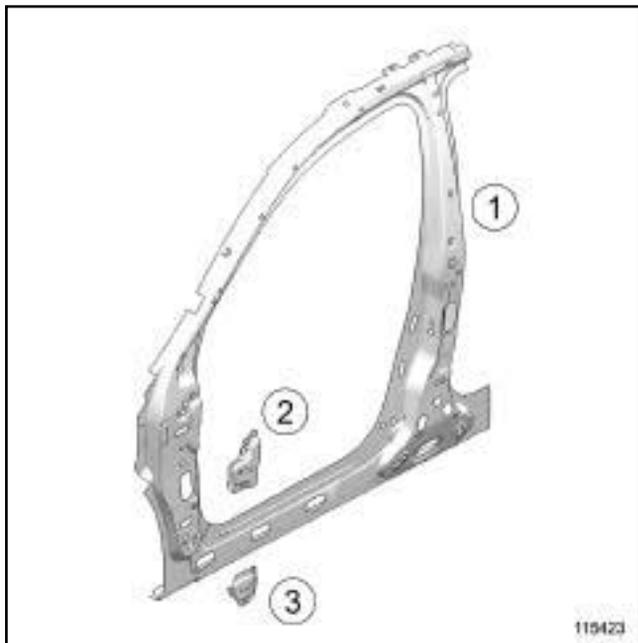
Sill panel reinforcement: Description

41C

B84 or C84

I - COMPOSITION OF THE SPARE PART

B84

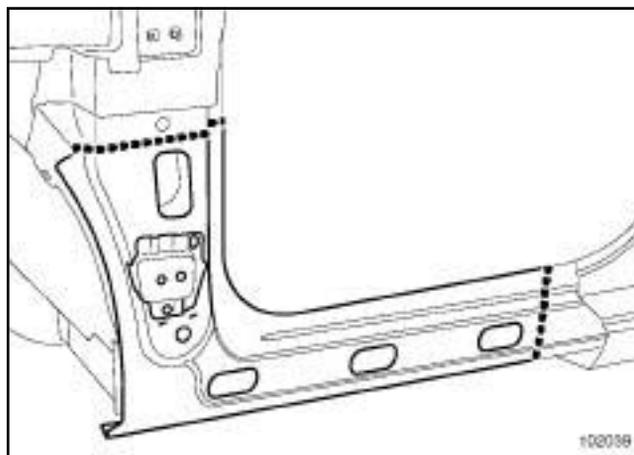


115423

Number	Description	Type	Thickness (mm)
(1)	Body side front section reinforcement	HEL	1.2/1.5
(2)	Upper hinge reinforcement	HEL	2
(3)	Lower hinge reinforcement	VHEL	2

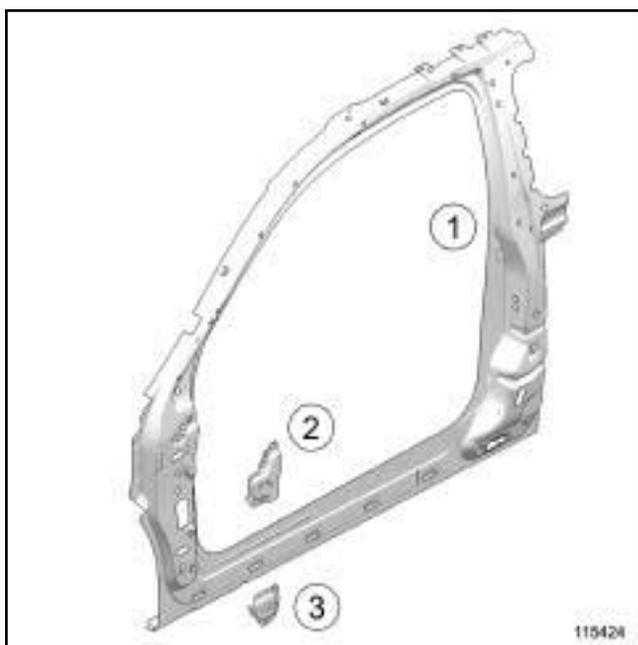
II - PART FITTED

1 - Partial replacement of the front section



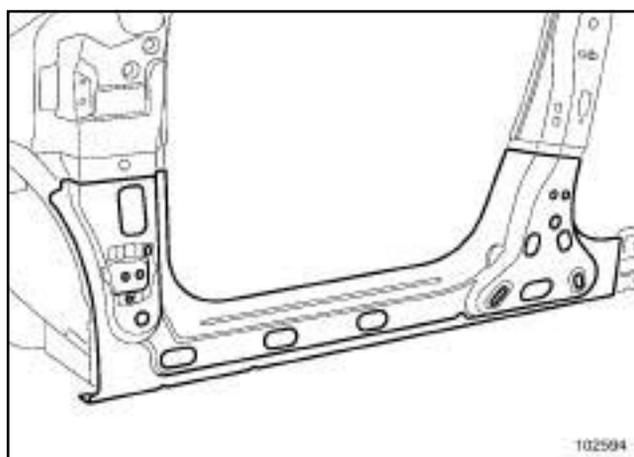
102038

C84



115424

2 - Complete replacement



102594

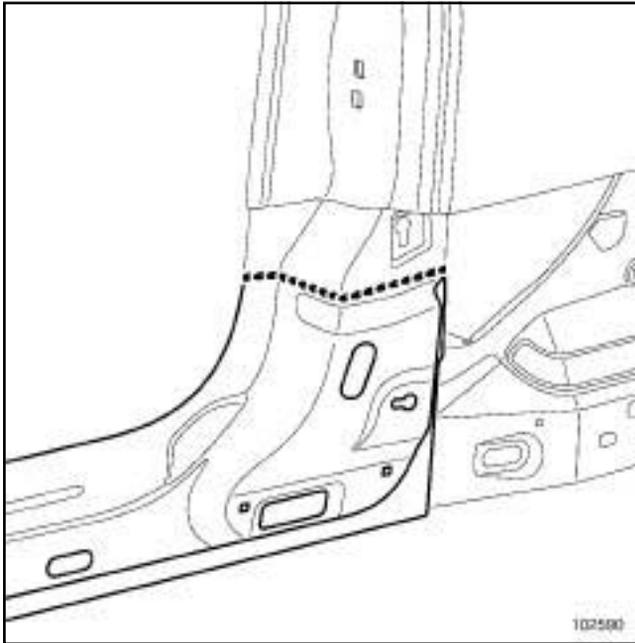
SIDE LOWER STRUCTURE

Sill panel reinforcement: Description

41C

B84 or C84

Special features of the rear cut on the 3-door version



102590

WARNING

If the spot welds cannot be made as they were originally using an electric spot welding machine, they should be replaced with plug welds after holes have been drilled in the first panel.

SIDE LOWER STRUCTURE

Sill panel rear reinforcement: Description

41C

B84 or C84



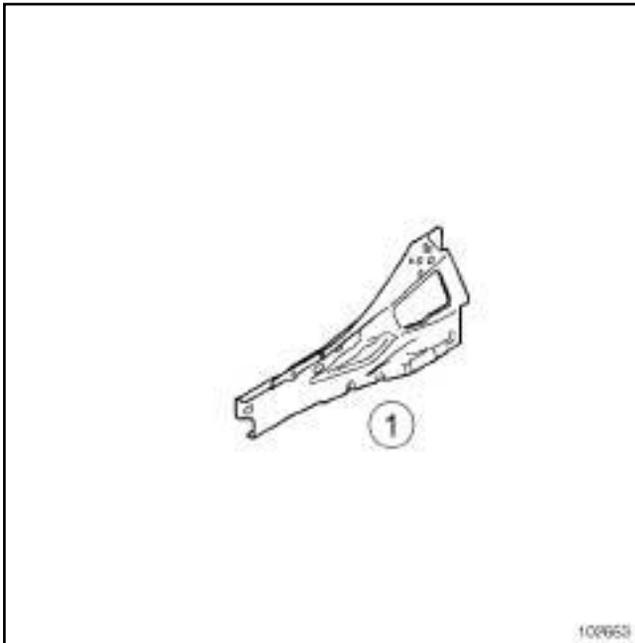
102663

To replace this part, also order the sill panel rear reinforcement stiffener (A) .

There is only one way of replacing this part:

- complete replacement: this operation complements the replacement of the rear inner sill panel.

I - COMPOSITION OF THE SPARE PART

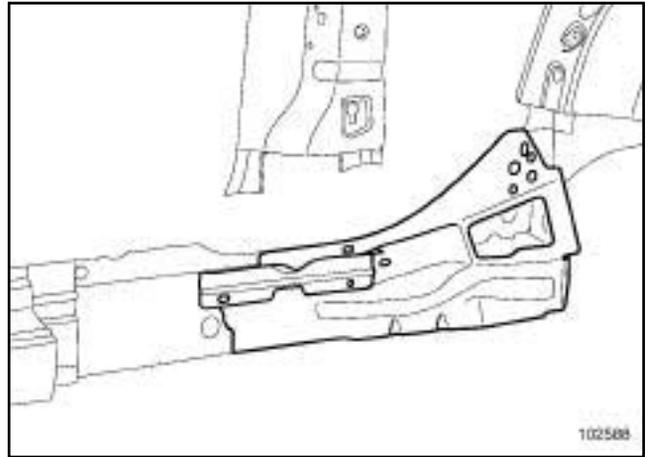


102663

Number	Description	Type	Thickness (mm)
(1)	Sill panel rear reinforcement	HEL	1.4

II - PART FITTED

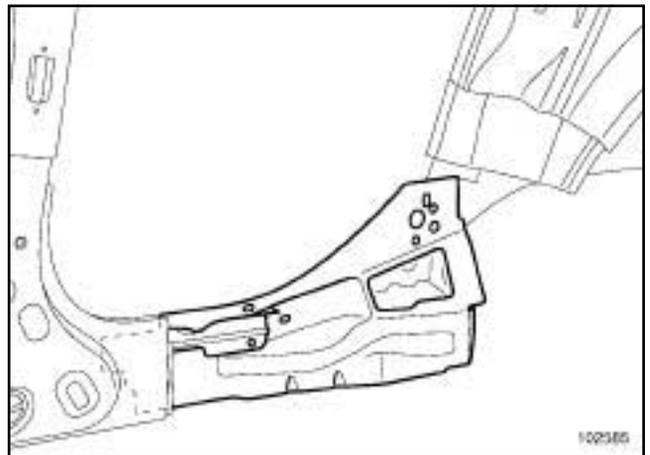
C84



102588

102588

B84



102585

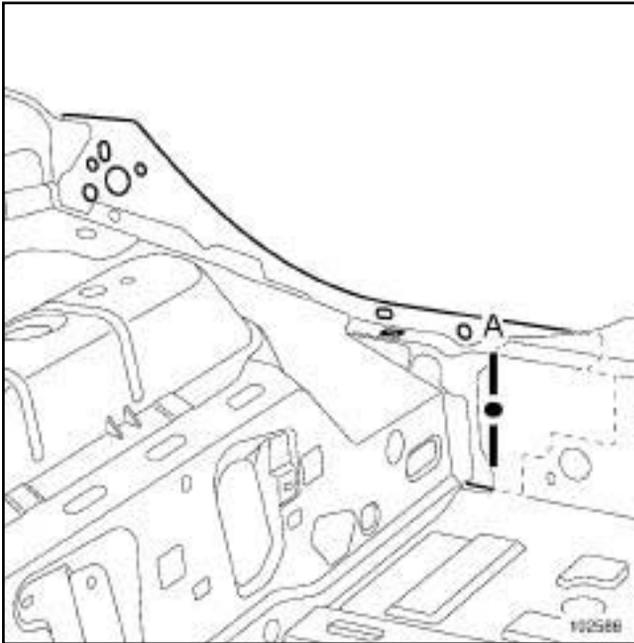
102585

SIDE LOWER STRUCTURE

Sill panel rear reinforcement: Description

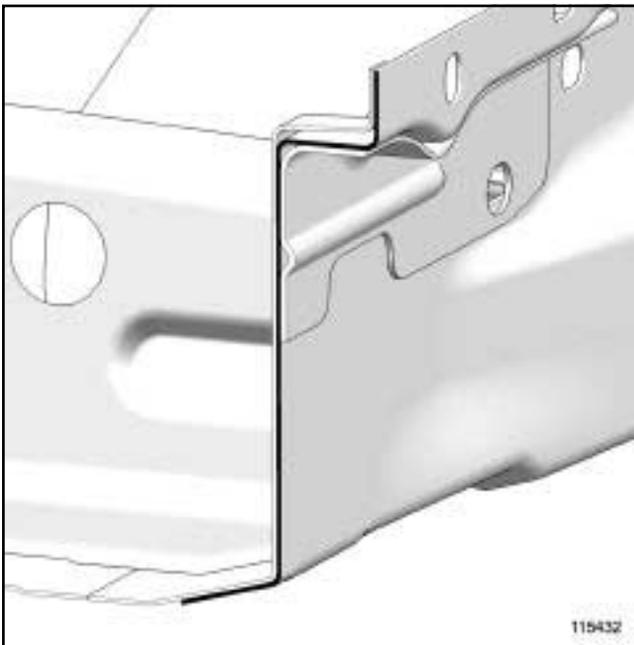
41C

B84 or C84



102586

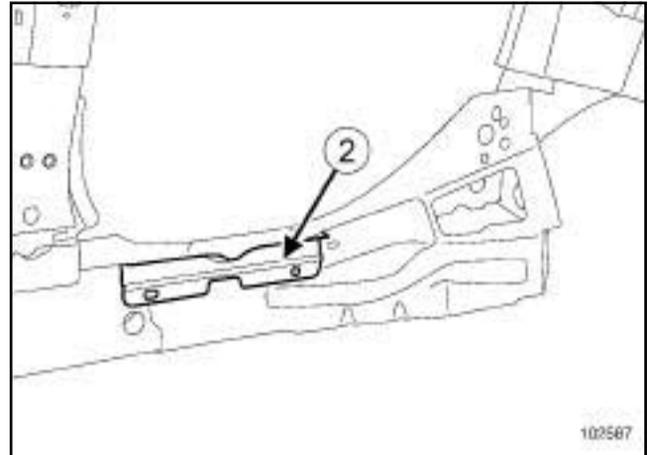
Cut A



115432

Note:

To keep the B-pillar reinforcement if it has not been damaged, the operation is performed from inside the vehicle.



102587

To straighten the sill panel rear reinforcement, desolder the sill panel rear reinforcement stiffener (2) .

WARNING

If the spot welds cannot be made as they were originally using an electric spot welding machine, they should be replaced with plug welds after holes have been drilled in the first panel.

IMPORTANT

To avoid damaging the vehicle's electric and electronic components, the battery and the earths of any wiring harness near the weld area must be disconnected.

The earth of the welding machine must be placed as close as possible to the weld area.

SIDE LOWER STRUCTURE

Front jack support: General description

41C

B84 or C84

WARNING

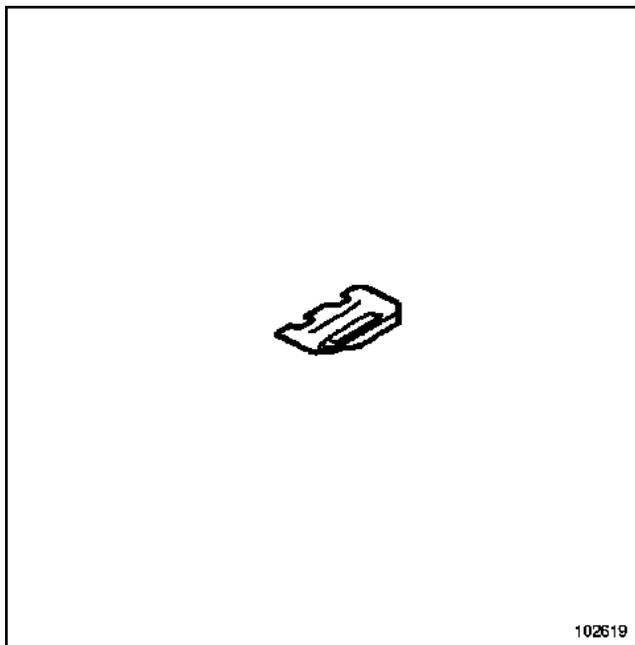
The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading this general information, check that there are no special notes associated with this vehicle. These special notes will be specified if applicable in other parts of this sub-section dealing with the part.

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information**.

DESIGN OF THE STRUCTURAL COMPONENT



102619

The special feature of this part is that it combines the functions of front and rear jacking point.

SIDE LOWER STRUCTURE

Impact absorber unit: Description

41C

B84

There is only one way of replacing this part:

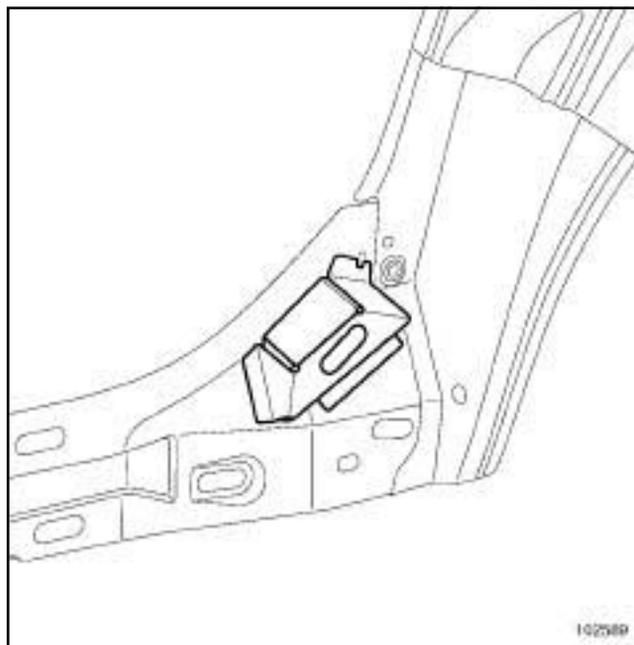
- complete replacement: this operation complements the replacement of the rear wing.

I - COMPOSITION OF THE SPARE PART



102814

II - PART FITTED



102589

Perform a dummy fitting of the sill panel and the rear door to check the positioning of the impact absorber unit.

Note:

Use plug welds.

Number	Description	Type	Thickness (mm)
(1)	Impact absorber unit	-	1

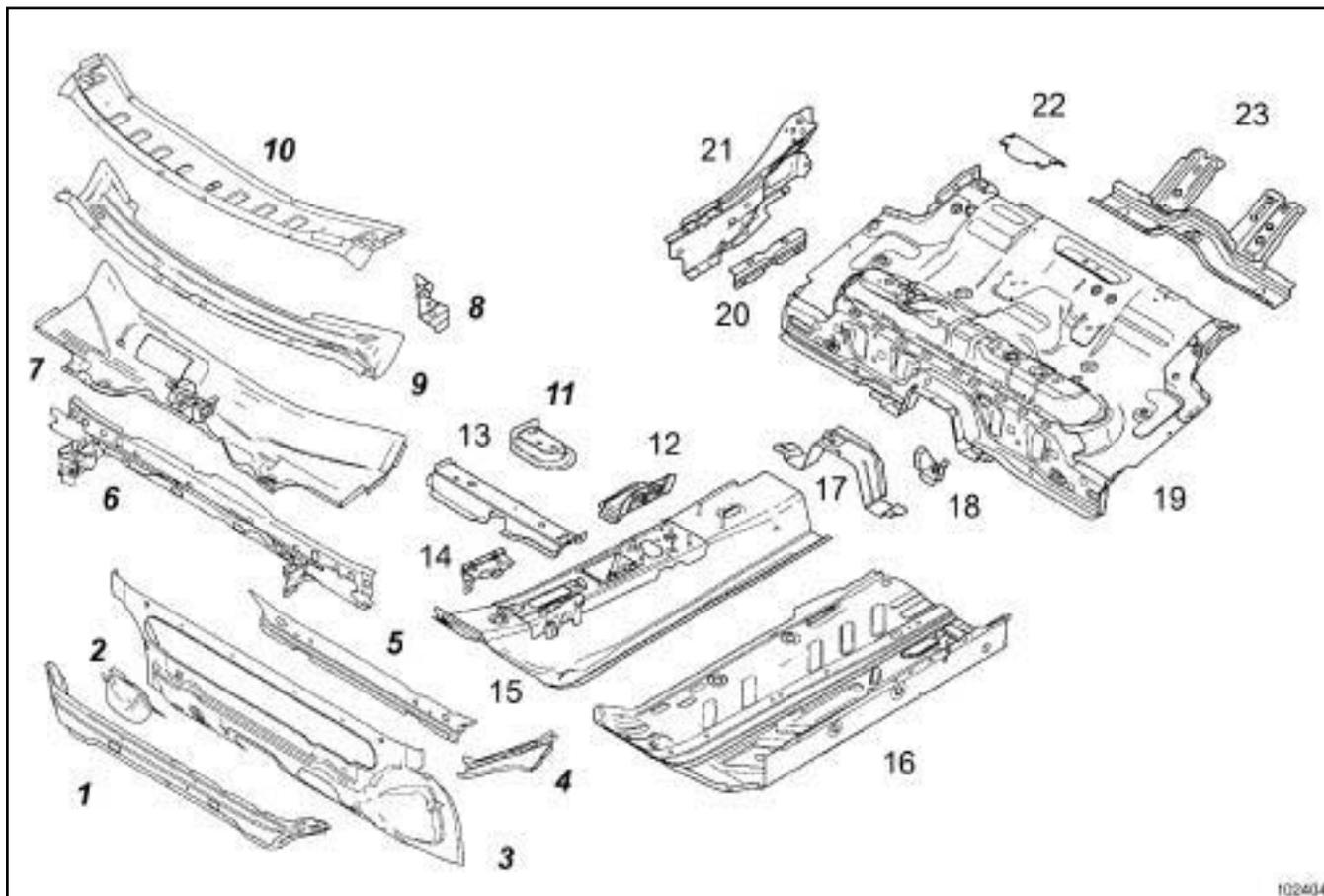
REAR LOWER STRUCTURE

Vehicle central section structure: Description

41D

B84 or C84

CENTRAL STRUCTURE



102404

102404

Mark	Description	Classification	Type	Thickness (mm)
(1)	Bulkhead lower cross member	(see 42A, Upper front structure, Bulkhead lower cross member: Description, page 42A-53)	VHLE	2.5
(2)	Steering column unit		-	1.5
(3)	Bulkhead	(see 42A, Upper front structure, Bulkhead: Description, page 42A-49)	-	0.9
(4)	Bulkhead side reinforcement	(see 42A, Upper front structure, Bulkhead side stiffener: Description, page 42A-59)	UHLE	1.7
(5)	Bulkhead reinforcement	(see 42A, Upper front structure, Bulkhead reinforcement: Description, page 42A-51)	UHLE	1.7

REAR LOWER STRUCTURE

Vehicle central section structure: Description

41D

B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(6)	Bulkhead upper cross member	(see 42A, Upper front structure, Bulkhead upper cross member: Description, page 42A-57)	HLE	0.95/3
(7)	Heater bulkhead	(see 42A, Upper front structure, Heater bulkhead: Description, page 42A-38)	-	0.7/1.2
(8)	Windscreen wiper mounting	(see 42A, Upper front structure, Windscreen wiper mounting: Description, page 42A-61)	-	1.2
(9)	Windscreen aperture lower cross member	(see 42A, Upper front structure, Windscreen aperture lower cross member: Description, page 42A-41)	-	0.7
(10)	Windscreen aperture lower cross member closure panel	(see 42A, Upper front structure, Windscreen aperture lower cross member closure panel: Description, page 42A-47)	-	0.65/1.2
(11)	Front seat mounting exterior unit	(see 41B, Centre lower structure, Front seat rear outer mounting unit: Description, page 41B-26)	HLE	1.5
(12)	Front seat mounting interior unit	(see 41B, Centre lower structure, Front seat rear mounting interior unit: Description, page 41B-25)	HLE	1.5/2.5
(13)	Front cross member under front seat	(see 41B, Centre lower structure, Front cross member under front seat: Description, page 41B-23)	HLE	1.5
(14)	Steering column mounting		-	1.3
(15)	Tunnel	(see 41B, Centre lower structure, Tunnel: Description, page 41B-20)	HLE/ THLE	1/1.6
(16)	Centre floor, side section	(see 41B, Centre lower structure, Central floor, side section: Description, page 41B-13)	VHLE	0.7/2.5
(17)	Exhaust mounting support	(see 41D, Rear lower structure, Exhaust mounting support: Description, page 41D-30)	-	1.2/2.5

REAR LOWER STRUCTURE

Vehicle central section structure: Description

41D

B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(18)	Fuel tank mounting support	(see 41D, Rear lower structure, Tank mounting support: Description, page 41D-31)	-	1.2
(19)	Front section of rear floor	(see 41D, Rear lower structure, Rear floor, front section: Description, page 41D-10)	HLE/ THLE	0.7/2.5
(20)	Sill panel reinforcement stiffener		VHLE	1.8
(21)	Sill panel rear reinforcement	(see 41C, Side lower structure, Sill panel rear reinforcement: Description, page 41C-29)	HLE	1.4
(22)	Fuel gauge closure panel		HLE	0.8
(23)	Rear floor front cross member, centre section	(see 41D, Rear lower structure, Rear floor front cross member, centre section: Description, page 41D-25)	HLE	1.2/2

REAR LOWER STRUCTURE

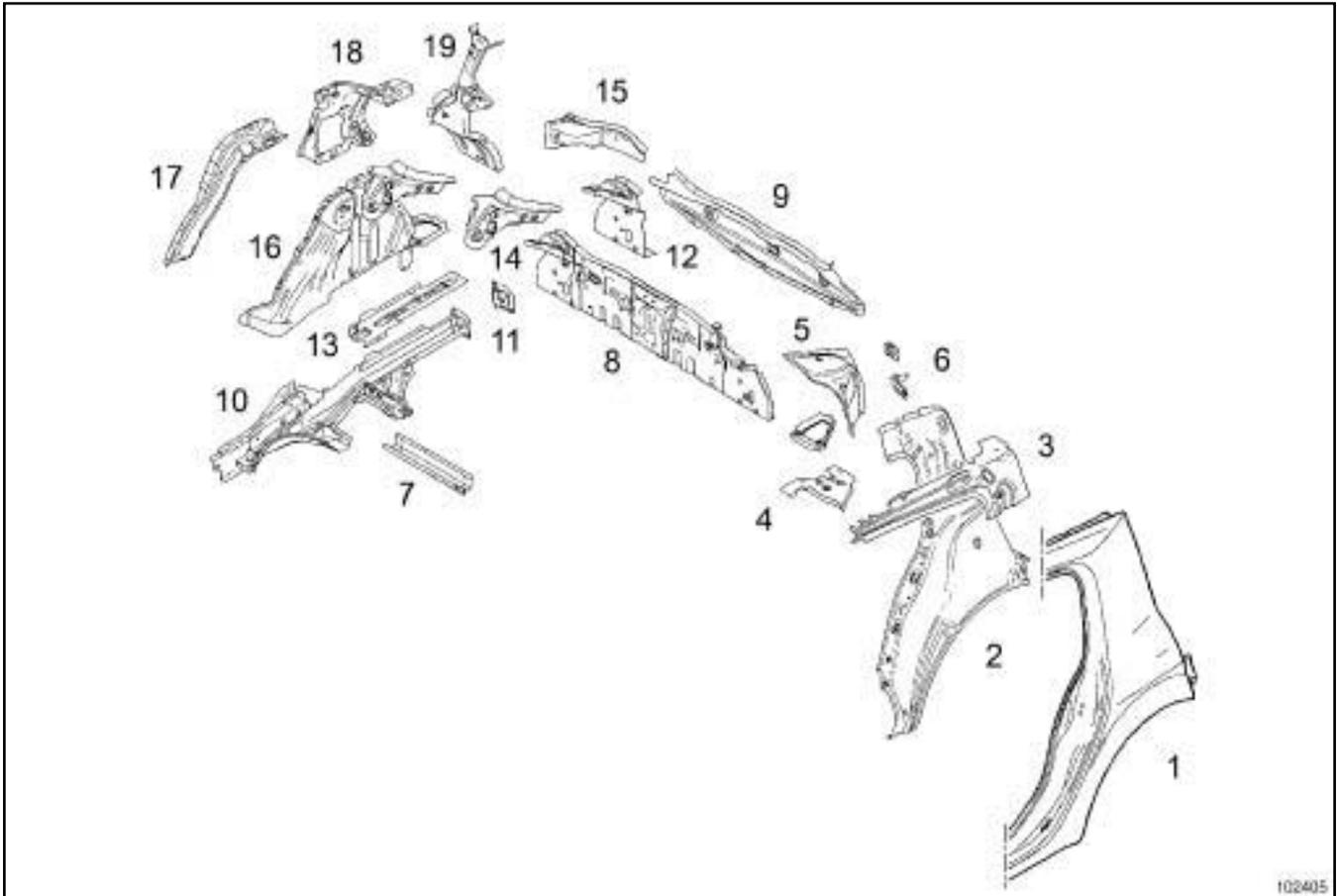
Vehicle structure rear section: Description

41D

B84 or C84

REAR STRUCTURE

B84



102405

102405

Mark	Description	Classification	Type	Thickness (mm)
(1)	Rear wing panel	(see 44A, Rear upper structure, Rear wing panel: Description, page 44A-7)	-	0.7
(2)	Quarter panel lining	(see 44A, Rear upper structure, Quarter panel lining: Description, page 44A-37)	-	0.6
(3)	Rear quarter upper reinforcement	(see 44A, Rear upper structure, Quarter panel upper reinforcement: Description, page 44A-40)	-	0.9
(4)	Far rear lower cross member, side section	(see 41D, Rear lower structure, Far rear lower cross member, side section: Description, page 41D-29)	-	0.95
(5)	Rear wheel arch extender	(see 44A, Rear upper structure, Rear wheel arch extension: Description, page 44A-33)	-	0.7
(6)	Tailgate stop mounting			

REAR LOWER STRUCTURE

41D

Vehicle structure rear section: Description

B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(7)	Rear floor centre cross member	(see 41D, Rear lower structure, Rear floor centre cross member: Description, page 41D-28)	HLE	1/2.5
(8)	Rear end panel assembly	(see 44A, Rear upper structure, Rear end panel assembly: Description, page 44A-46)	HLE/THLE	0.65/2.5
(9)	Rear end panel	(see 44A, Rear upper structure, Rear end panel: Description, page 44A-49)	-	0.65
(10)	Rear side member	(see 41D, Rear lower structure, Rear side member: Description, page 41D-20)	HLE/THLE	0.95/2
(11)	Rear impact cross member mounting stiffener	(see Rear impact cross member mounting stiffener: Description)	HLE	2
(12)	Rear end panel side lining	(see 44A, Rear upper structure, Rear end panel side lining: Description, page 44A-51)	-	0.7
(13)	Rear side member closure panel, rear section	(see 41D, Rear lower structure, Rear side member closure panel, rear section: Description, page 41D-23)	-	0.7
(14)	Light mounting lining	(see 44A, Rear upper structure, Lights support lining: Description, page 44A-21)	HLE	0.95
(15)	Rear light mounting	(see 44A, Rear upper structure, Rear lights support: Description, page 44A-18)	-	0.9
(16)	Inner rear wheel arch	(see 44A, Rear upper structure, Inner wheel arch: Description, page 44A-29)	HLE	0.7/1.5
(17)	Rear wheel arch closure panel	(see 44A, Rear upper structure, Rear wheel arch closure panel: Description, page 44A-31)	-	0.7
(18)	Quarter panel stiffener	(see 44A, Rear upper structure, Quarter panel reinforcement: Description, page 44A-36)	-	0.9
(19)	Rear wing panel rain channel	(see 44A, Rear upper structure, Rear wing panel rain channel: Description, page 44A-15)	HLE	0.85/1



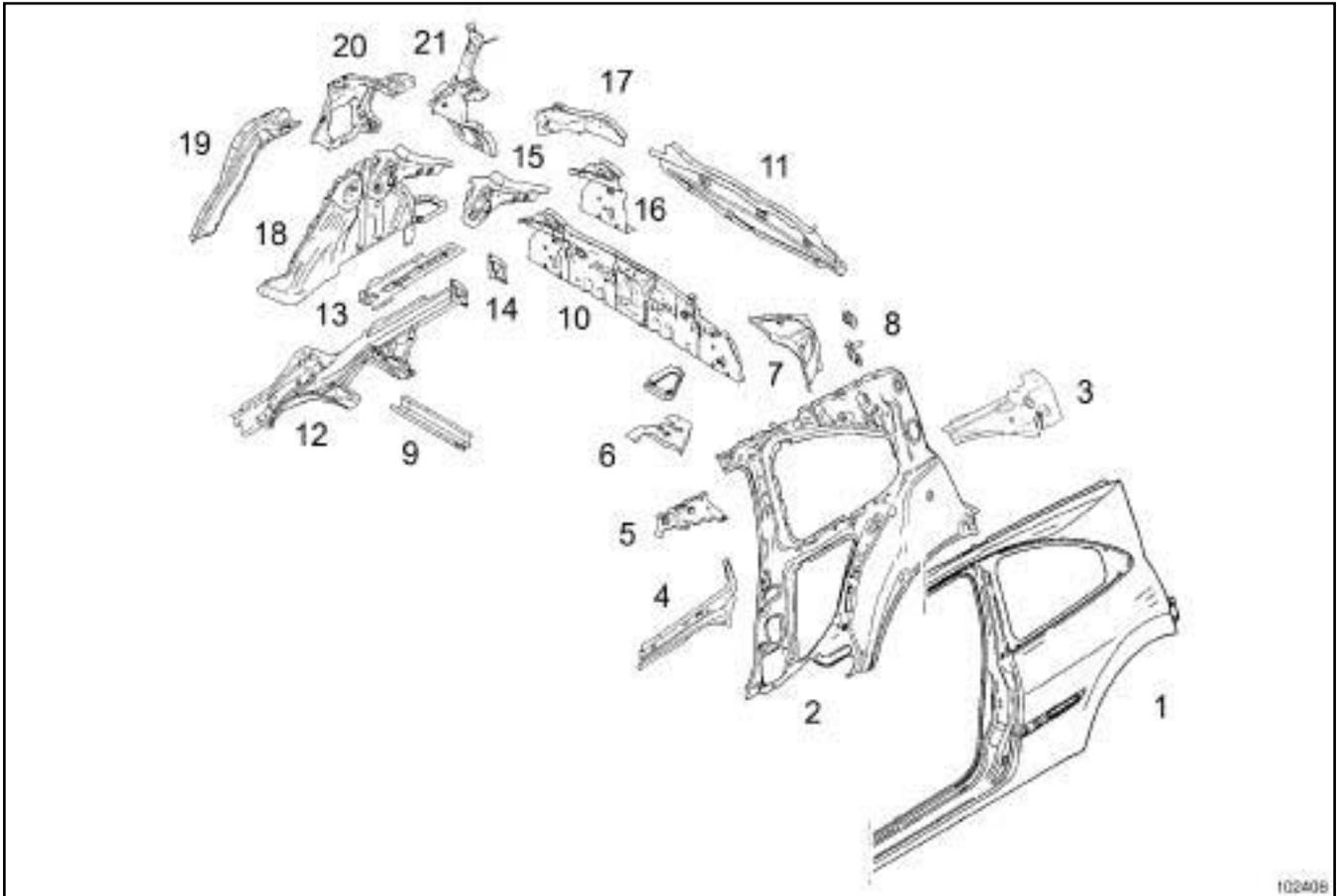
REAR LOWER STRUCTURE

Vehicle structure rear section: Description

41D

B84 or C84

C84



102406

102406

Mark	Description	Classification	Type	Thickness (mm)
(1)	Rear wing panel	(see 44A, Rear upper structure, Rear wing panel: Description, page 44A-7)	-	0.7
(2)	Quarter panel lining	(see 44A, Rear upper structure, Quarter panel lining: Description, page 44A-37)	-	0.6
(3)	Rear quarter upper reinforcement	(see 44A, Rear upper structure, Quarter panel upper reinforcement: Description, page 44A-40)	-	0.9
(4)	Quarter panel centre reinforcement	(see 44A, Rear upper structure, Quarter panel centre reinforcement: Description, page 44A-43)	HLE	1.5
(5)	Rear roof drip moulding lining	(see 44A, Rear upper structure, Roof rear drip moulding lining: Description, page 44A-44)	-	1/2
(6)	Far rear lower cross member, side part	(see 41D, Rear lower structure, Far rear lower cross member, side section: Description, page 41D-29)	-	0.95

REAR LOWER STRUCTURE

Vehicle structure rear section: Description

41D

B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(7)	Rear wheel arch extender	(see 44A, Rear upper structure, Rear wheel arch extension: Description, page 44A-33)	-	0.7
(8)	Tailgate stop mounting			
(9)	Rear floor centre cross member	(see 41D, Rear lower structure, Rear floor centre cross member: Description, page 41D-28)	HLE	1/2.5
(10)	Rear end panel assembly	(see 44A, Rear upper structure, Rear end panel assembly: Description, page 44A-46)	HLE/THLE	0.65/2.5
(11)	Rear end panel	(see 44A, Rear upper structure, Rear end panel: Description, page 44A-49)	-	0.65
(12)	Rear side member	(see 41D, Rear lower structure, Rear side member: Description, page 41D-20)	HLE/THLE	0.95/2
(13)	Rear side member closure panel, rear section	(see 41D, Rear lower structure, Rear side member closure panel, rear section: Description, page 41D-23)	-	0.7
(14)	Impact cross member mounting stiffener	(see Rear impact cross member mounting stiffener: Description)	HLE	2
(15)	Light mounting lining	(see 44A, Rear upper structure, Lights support lining: Description, page 44A-21)	HLE	0.95
(16)	Rear end panel side lining	(see 44A, Rear upper structure, Rear end panel side lining: Description, page 44A-51)	-	0.7
(17)	Rear light mounting	(see 44A, Rear upper structure, Rear lights support: Description, page 44A-18)	-	0.9
(18)	Inner rear wheel arch	(see 44A, Rear upper structure, Inner wheel arch: Description, page 44A-29)	HLE	0.7/1.5
(19)	Rear wheel arch closure panel	(see 44A, Rear upper structure, Rear wheel arch closure panel: Description, page 44A-31)	-	0.7
(20)	Quarter panel stiffener	(see 44A, Rear upper structure, Quarter panel reinforcement: Description, page 44A-36)	-	0.9
(21)	Rear wing panel rain channel	(see 44A, Rear upper structure, Rear wing panel rain channel: Description, page 44A-15)	HLE	0.85/1

Rear floor, front section: General description

B84 or C84

WARNING

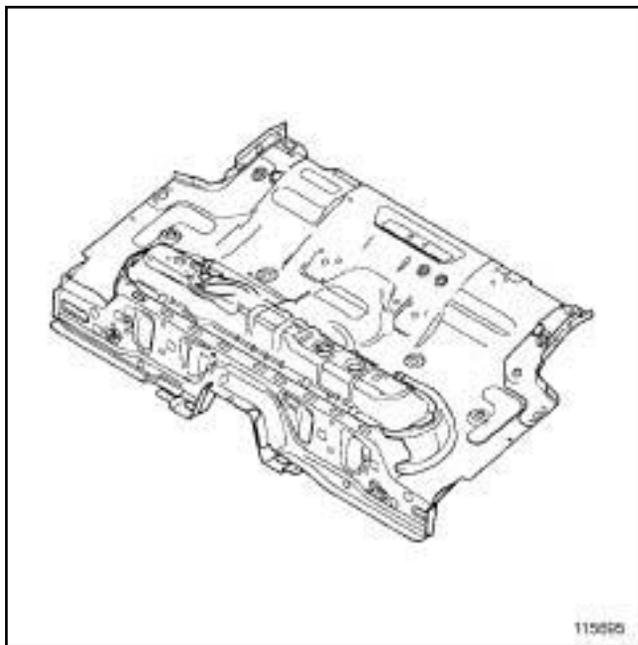
The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information**.

I - DESIGN OF THE STRUCTURAL COMPONENT



115695

This is a basic part; its only function is that of rear floor front section.

II - AREA TO BE CUT FOR PARTIAL REPLACEMENT



102976

102976

Cut 1:

This line marks the area in which it is possible to perform a partial replacement.

III - ASSEMBLY INSTRUCTIONS FOR A PARTIAL REPLACEMENT

Only the connecting pieces relevant to partial replacement by cutting are shown.

WARNING

If the spot welds cannot be made as they were originally using an electric spot welding machine, they should be replaced with plug welds after holes have been drilled in the first panel.

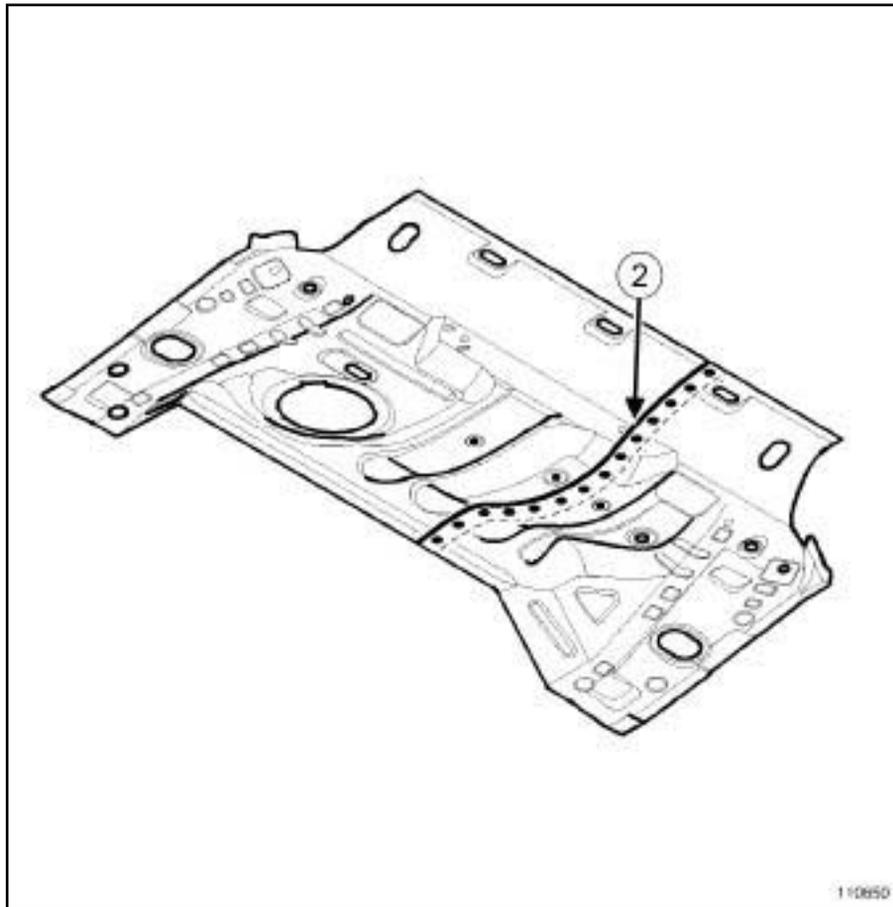
If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400, 40A, General Information**).

REAR LOWER STRUCTURE

Rear floor, front section: General description

41D

B84 or C84



110650
110650

Line (2) on the diagram marks a joggled joint connected with plug welds at regular intervals.

REAR LOWER STRUCTURE

Rear floor, front section: Description

41D

B84 or C84

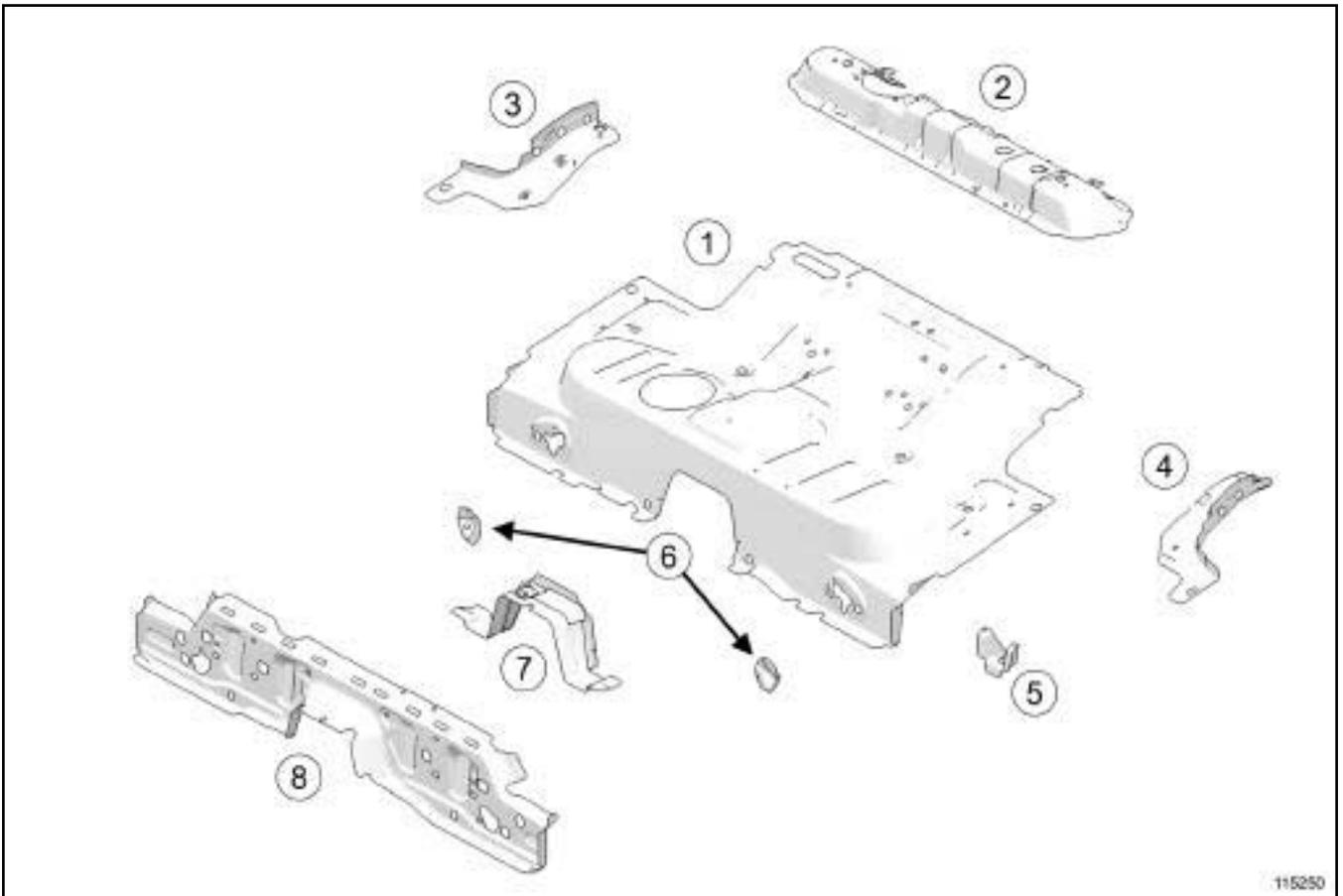


115695

The options for replacing this part are as follows:

- partial replacement: this operation complements the replacement of the rear section of the body side after a side impact,
- complete replacement.

I - COMPOSITION OF THE SPARE PART



115250

REAR LOWER STRUCTURE

Rear floor, front section: Description

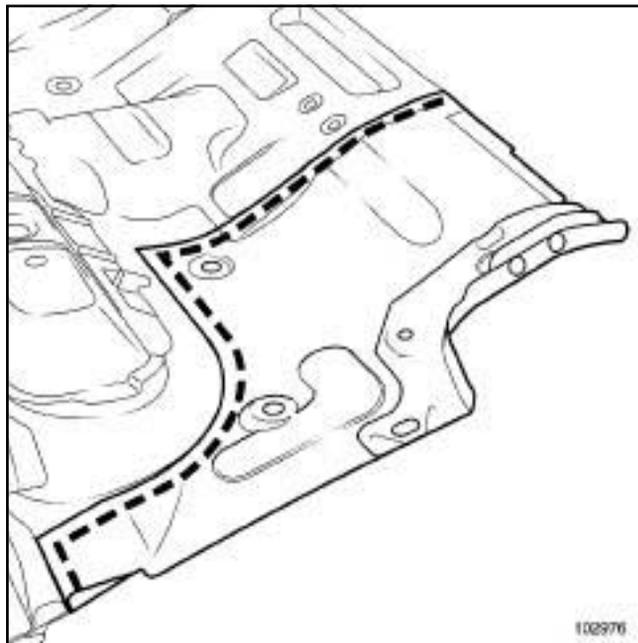
41D

B84 or C84

Number	Description	Type	Thickness (mm)
(1)	Front section of rear floor	-	0.7
(2)	Passenger retaining cross member	HEL	0.9
(3)	Rear seat mounting right-hand side stiffener	HEL	1.65
(4)	Rear seat mounting left-hand side stiffener	HEL	1.65
(5)	Reservoir front mounting stiffener	-	1.2
(6)	Cable sleeve stop support	-	1.2
(7)	Exhaust mounting support	-	1.2/2.5
(8)	Cross member reinforcement	HEL	0.85

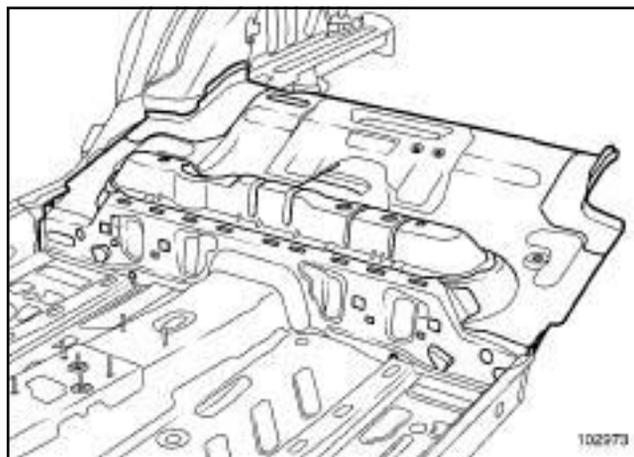
II - PART FITTED

1 - Partial replacement



102976

2 - Complete replacement

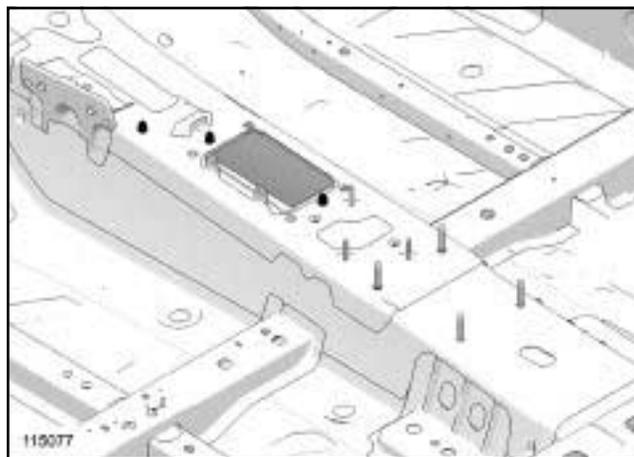


102973

WARNING

If the spot welds cannot be made as they were originally using an electric spot welding machine, they should be replaced with plug welds after holes have been drilled in the first panel.

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



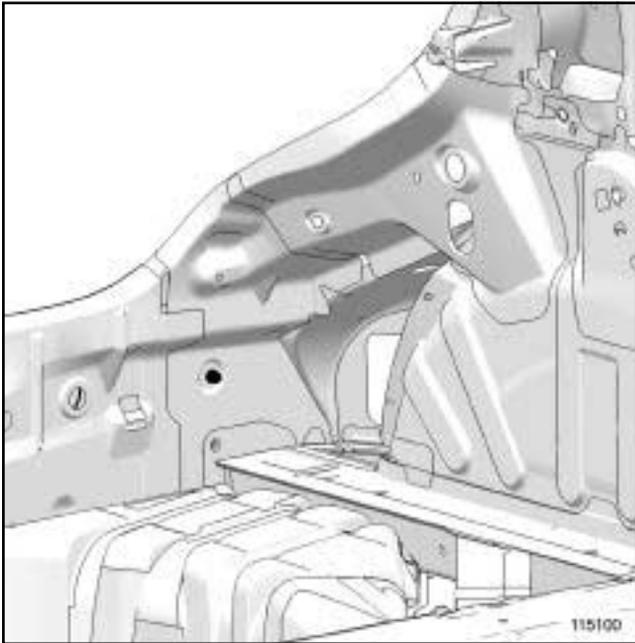
115077

REAR LOWER STRUCTURE

Rear floor, front section: Description

41D

B84 or C84



115100

IMPORTANT

To avoid damaging the vehicle's electric and electronic components, the battery and the earths of any wiring harness near the weld area must be disconnected.

The earth of the welding machine must be placed as close as possible to the weld area.

Rear floor rear section: General description

B84 or C84

WARNING

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

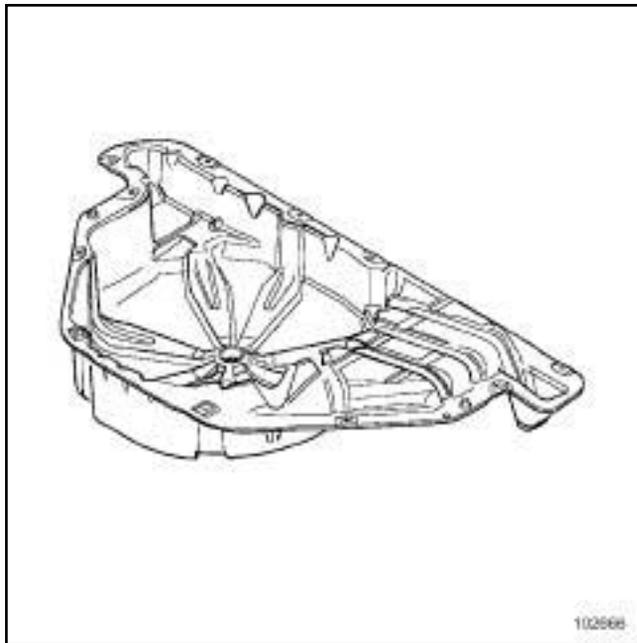
Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, (see **MR 400, 40A, General information**).

I - DESIGN OF THE STRUCTURAL COMPONENT

STANDARD CHASSIS



102666

The special feature of this type of part is that it is affixed to the vehicle by bolts and by a cement bead.

II - ASSEMBLY INSTRUCTIONS FOR A PARTIAL REPLACEMENT

Only the connecting pieces relevant to partial replacement by cutting are shown.

WARNING

If the spot welds cannot be made as they were originally using an electric spot welding machine, they should be replaced with plug welds after holes have been drilled in the first panel.

If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400, 40A, General Information**).

Rear floor rear section: Removal - Refitting

B84 or C84

Tightening torques

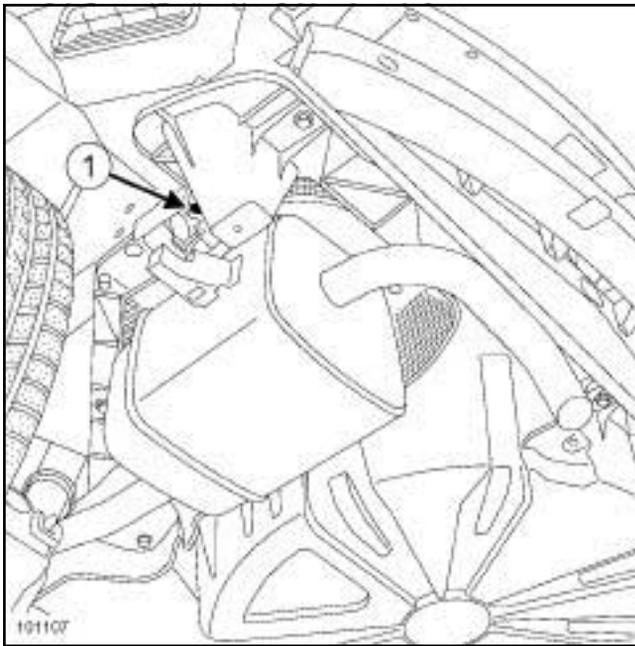
rear floor rear section mounting bolts	21 Nm
--	-------

REMOVAL

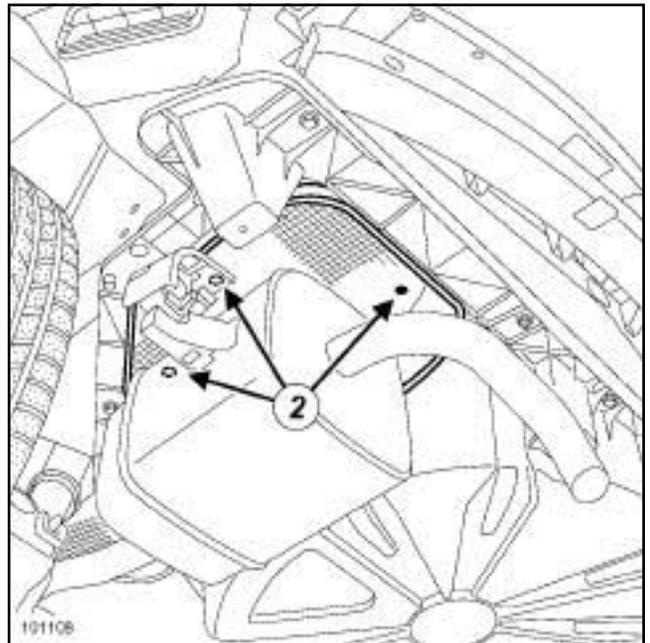
I - REMOVAL PREPARATION OPERATION

Remove:

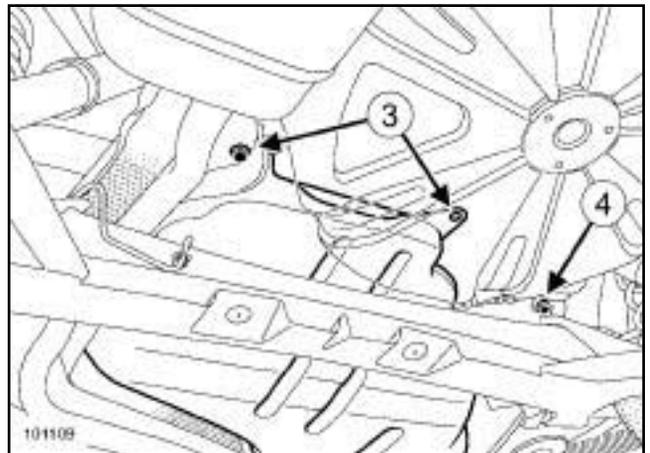
- the rear wheel arch liners((see **Rear wheel arch liner: Removal - Refitting**) ,
- the rear bumper((see **Rear bumper: Removal - Refitting**) ,
- the luggage compartment carpet((see **Luggage compartment carpet: Removal - Refitting**) ,
- the emergency spare wheel and the jack.



- Remove the exhaust silencer mounting bolt (1) .
- Detach the exhaust silencer by pulling it downwards.



- Remove the heat shield mounting bolts (2) .
- Remove the heat shield.



- Remove:
 - the two tank mounting bolts (3) ,
 - the funnel lower mounting bolt (4) .

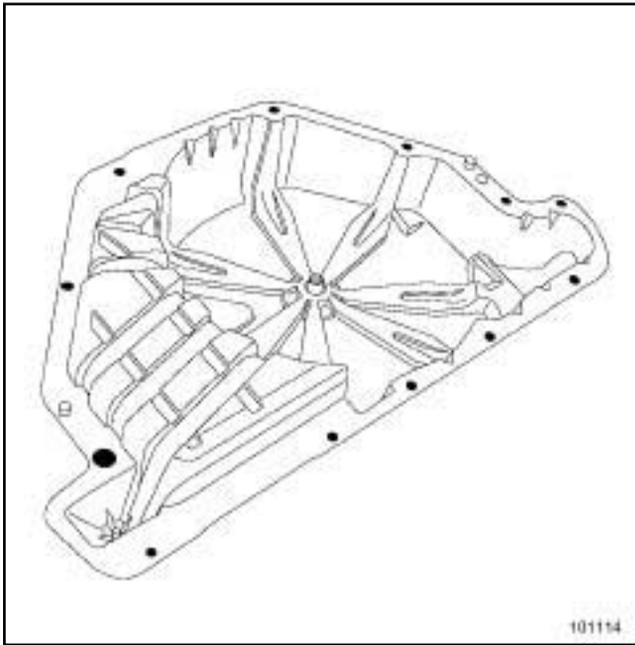
REAR LOWER STRUCTURE

41D

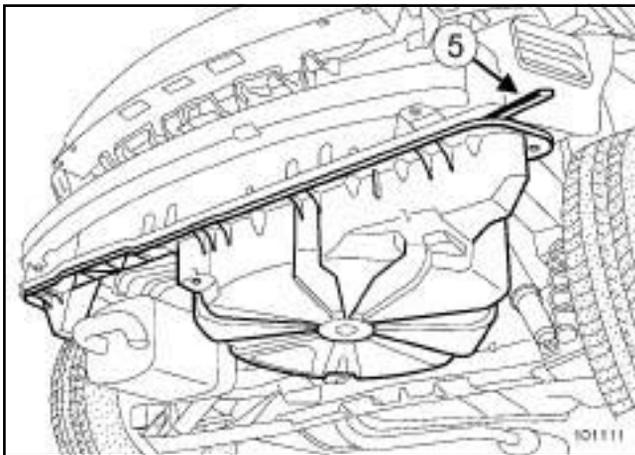
Rear floor rear section: Removal - Refitting

B84 or C84

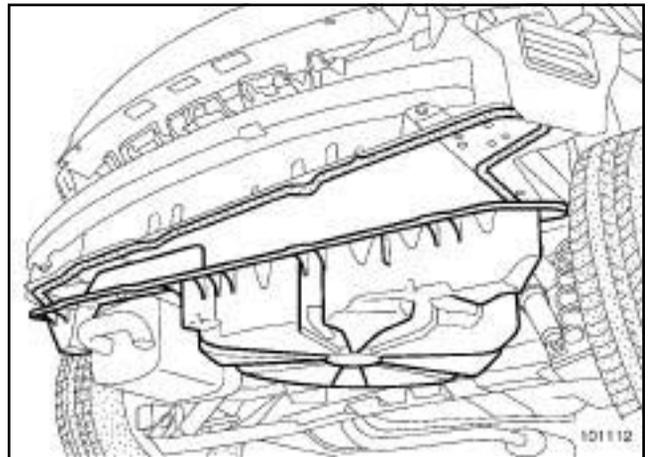
II - OPERATION FOR REMOVAL OF PART CONCERNED



- ❑ Remove all the floor mountings.



- ❑ Insert a flat chisel (5) into the rear right-hand corner of the floor.



- ❑ Use the flat chisel as a lever and carefully detach the floor.

Note:

During the operation, cut the mastic bead using a sectioning tool if there is too much resistance during removal.

REFITTING

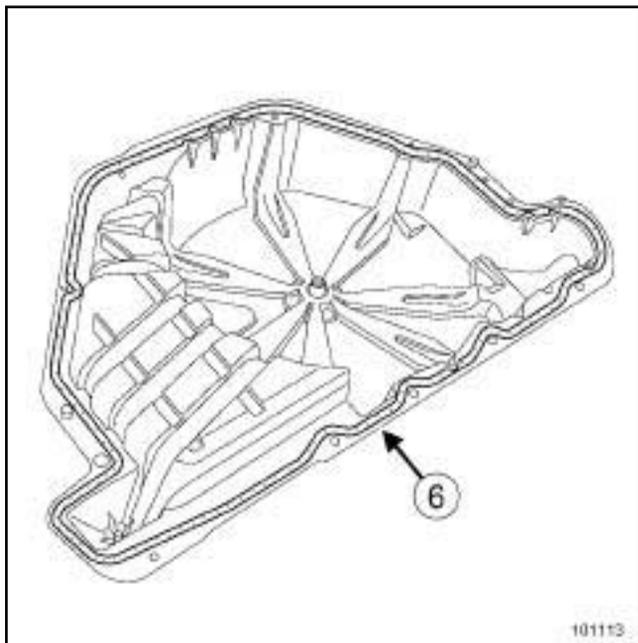
I - REFITTING PREPARATION OPERATION

1 - Preparation of the replacement part

- ❑ Remove the remaining cement bead.
- ❑ Using heptane and a lint-free cloth, clean the surfaces to be attached.

Rear floor rear section: Removal - Refitting

B84 or C84

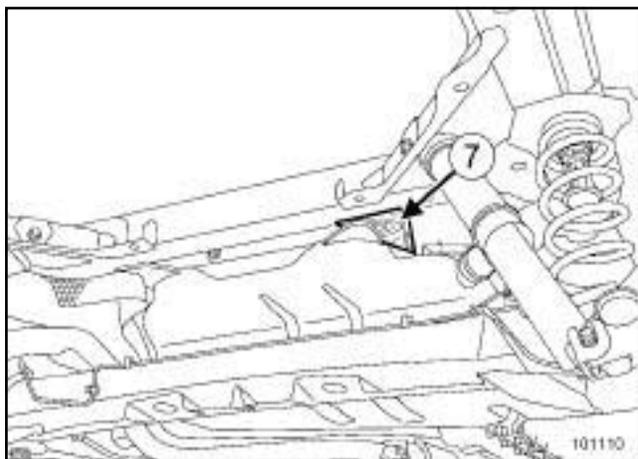


101113

- Apply the sealing mastic (6) .

2 - Preparing the vehicle

- Remove the remaining cement bead.
- Using heptane and a lint-free cloth, clean the surfaces to be attached.



101110

-

Note:

To avoid any risk of damage to the mastic bead and to facilitate the positioning of the floor when it is refitted, move the tank away using a wooden block (7) .

II - REFITTING OPERATION FOR PART CONCERNED

- Refit:
 - the rear floor,
 - all the floor mountings.
- Tighten to torque the **rear floor rear section mounting bolts (21 Nm)** .

Note:

Remove any visible excess mastic from the vehicle interior and exterior.

- Check that the seal between the floor and subframe is sufficient.

III - FINAL OPERATION

- Refit:
 - the lower mounting bolt (4) to the funnel,
 - the two tank mounting bolts (3) ,
 - the silencer heat shield,
 - the bolts (2) securing the heat shield,
 - the exhaust silencer,
 - the silencer mounting bolt (1) ,
 - the emergency spare wheel and the jack.
 - the luggage compartment carpet((see **Luggage compartment carpet: Removal - Refitting**) ,
 - the rear bumper((see **Rear bumper: Removal - Refitting**) ,
 - the rear wheel arch liners((see **Rear wheel arch liner: Removal - Refitting**) .

B84 or C84

WARNING

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading this general information, check that there are no special notes associated with this vehicle. These special notes will be specified if applicable in other parts of this sub-section dealing with the part.

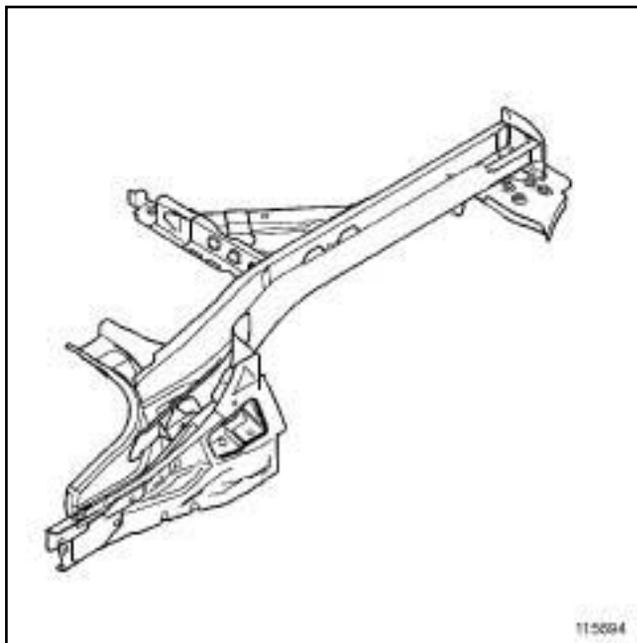
IMPORTANT

The straightening bench must be used.

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information**.

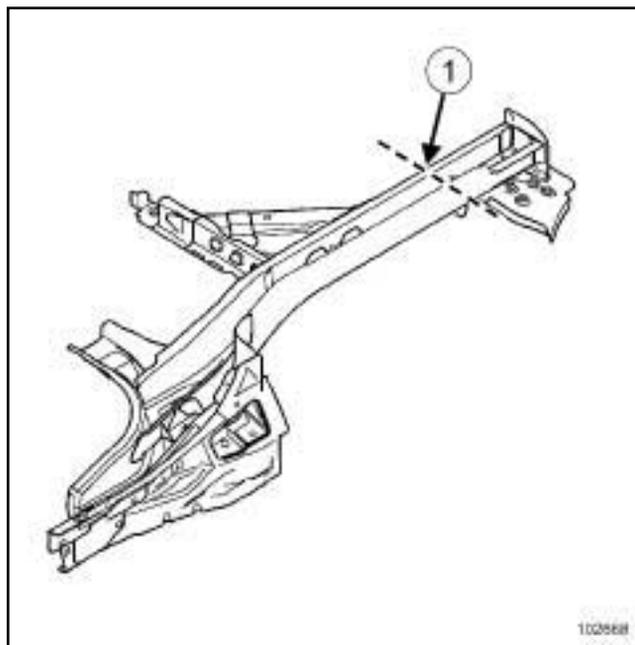
I - DESIGN OF THE STRUCTURAL COMPONENT



115694

This is a basic part; it only functions as a rear side member.

II - AREA TO BE CUT FOR PARTIAL REPLACEMENT



102668

Cut 1:

This line marks the area in which it is possible to perform a partial replacement.

This operation allows you to access the inside of the hollow section of the structural component to straighten it.

III - ASSEMBLY INSTRUCTIONS FOR A PARTIAL REPLACEMENT

Only the connecting pieces relevant to partial replacement by cutting are shown.

WARNING

If the spot welds cannot be made as they were originally using an electric spot welding machine, they should be replaced with plug welds after holes have been drilled in the first panel.

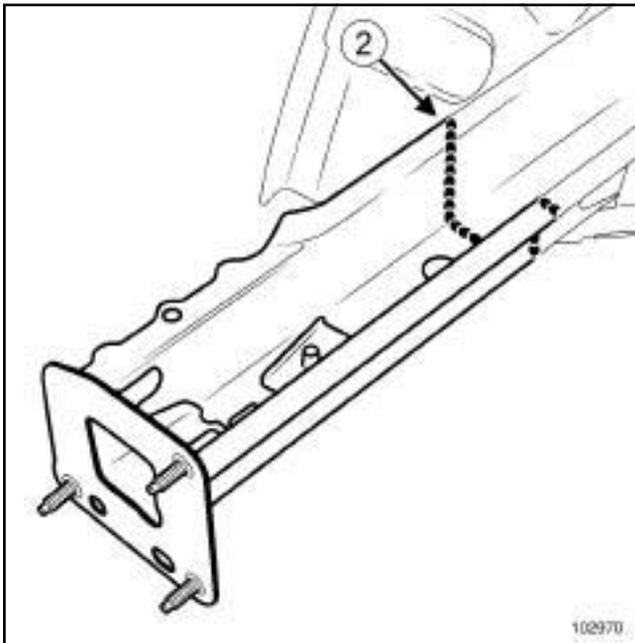
If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400, 40A, General Information**).

REAR LOWER STRUCTURE

Rear side member: General description

41D

B84 or C84



102970

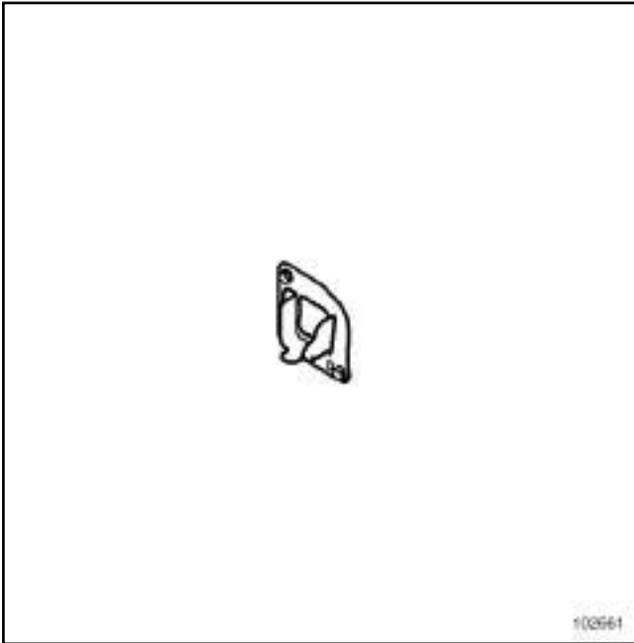
Line (2) of the diagram shows a butt weld by continuous MAG welding.

REAR LOWER STRUCTURE

Rear impact cross member mounting reinforcement: Description

41D

B84 or C84



102661
102661

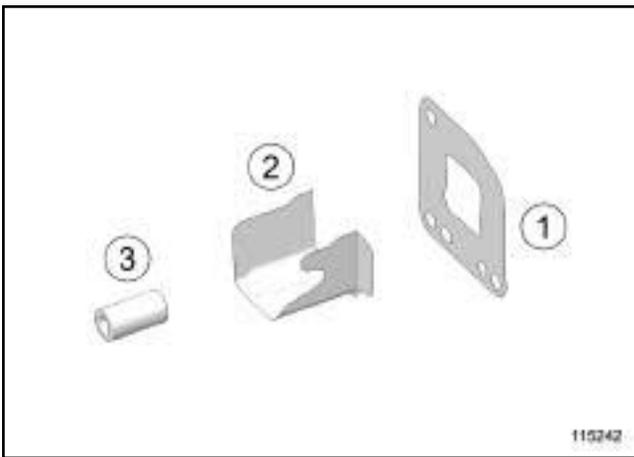
There is only one way of replacing this part:

- complete replacement: this operation complements the replacement of the rear end panel assembly and the rear side member closure panel.

Note:

The body jig bench must be used.

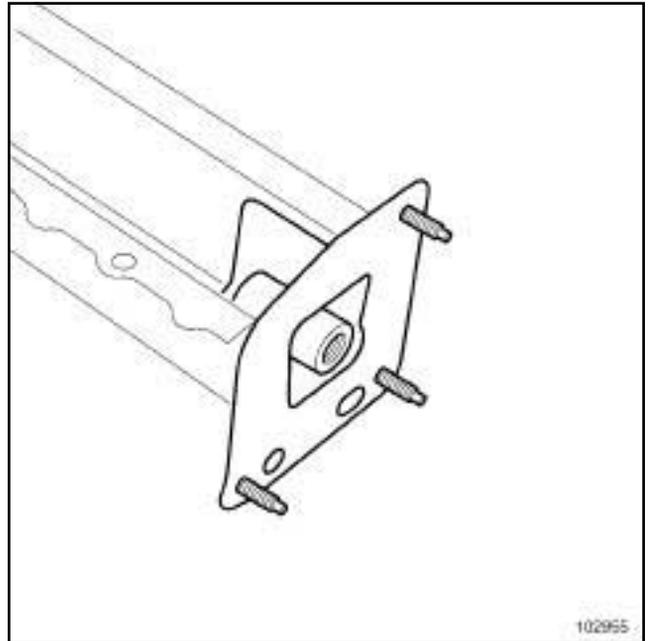
I - COMPOSITION OF THE SPARE PART



115242
115242

Number	Description	Type	Thickness (mm)
(1)	Rear side member closure panel component	VHEL	2
(2)	Rear side member connection component	HEL	2
(3)	Rear towing bushing	-	-

II - PART FITTED



102955
102955

WARNING

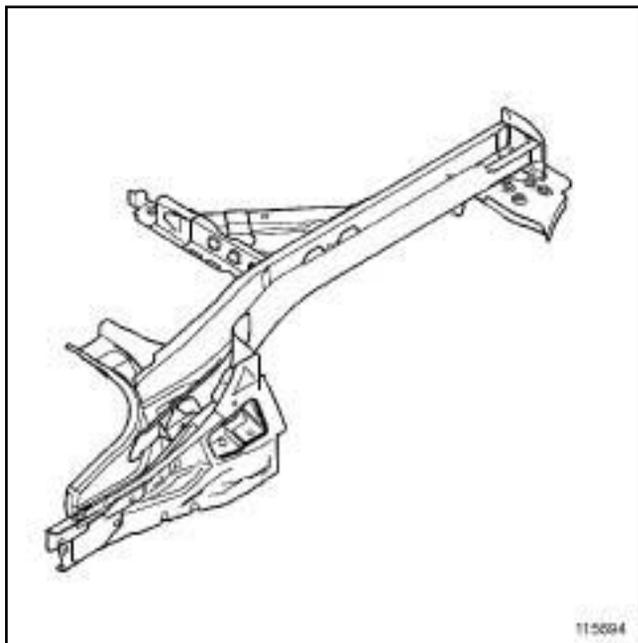
If the spot welds cannot be made as they were originally using an electric spot welding machine, they should be replaced with plug welds after holes have been drilled in the first panel.

REAR LOWER STRUCTURE

Rear side member: Description

41D

B84 or C84



115694

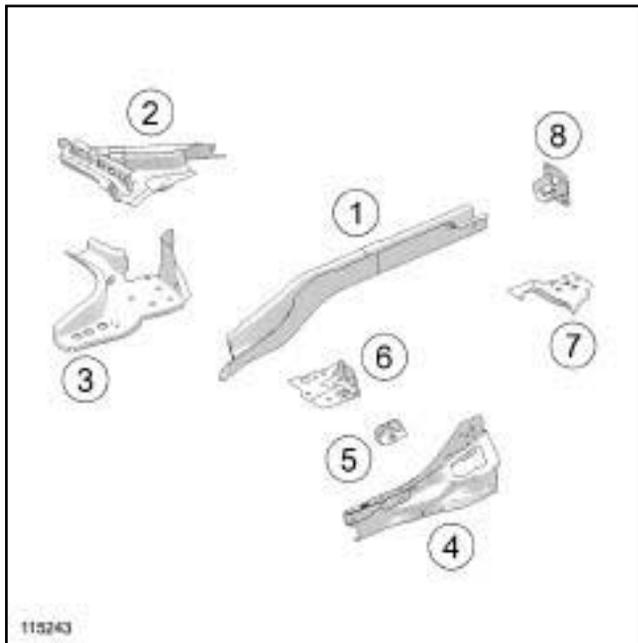
The options for replacing this part are as follows:

- partial replacement,
- Complete replacement: this operation complements the partial replacement of the rear floor front section after a rear impact.

Note:

The body jig bench must be used.

I - COMPOSITION OF THE SPARE PART



115243

115243

Number	Description	Type	Thickness (mm)
(1)	Rear side member	HEL	1.6/2
(2)	Rear cross member/rear side member connection component	HEL/VHEL	1.2/1.8
(3)	Rear axle assembly unit	HEL	1.8
(4)	Sill panel rear reinforcement	HEL	1.4
(5)	Rear side member assembly unit reinforcement connection component	VHEL	2
(6)	Rear axle assembly unit reinforcement	HEL	2
(7)	Far rear lower cross member, side section	-	1
(8)	Rear impact cross member mounting stiffener	HEL/VHEL	2

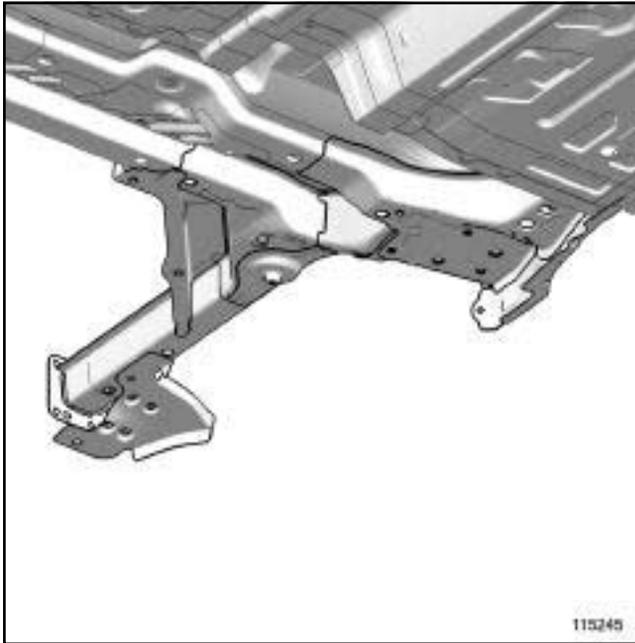
REAR LOWER STRUCTURE

Rear side member: Description

41D

B84 or C84

2 - Complete replacement



115245

WARNING

If the spot welds cannot be made as they were originally using an electric spot welding machine, they should be replaced with plug welds after holes have been drilled in the first panel.

IMPORTANT

To avoid damaging the vehicle's electric and electronic components, the battery and the earths of any wiring harness near the weld area must be disconnected.

The earth of the welding machine must be placed as close as possible to the weld area.

REAR LOWER STRUCTURE

41D

Rear side member closure panel, rear section: Description

B84 or C84

There is only one way of replacing this part:

- complete replacement: this operation complements the replacement of the rear end panel and the rear side member after a rear impact.

I - COMPOSITION OF THE SPARE PART

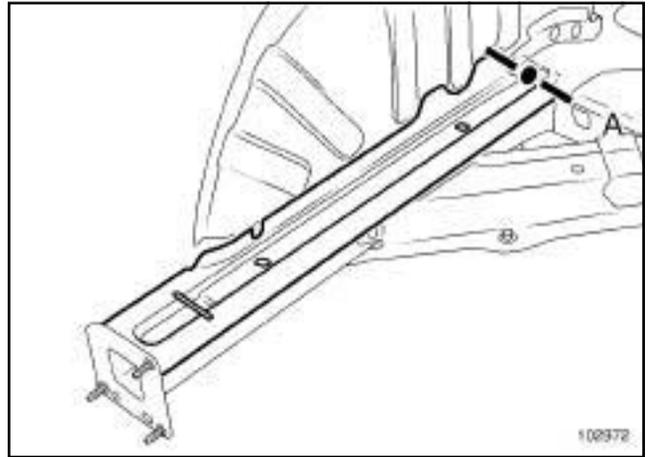


115682

Number	Description	Type	Thickness (mm)
(1)	Rear side member closure panel, rear section	-	0.7

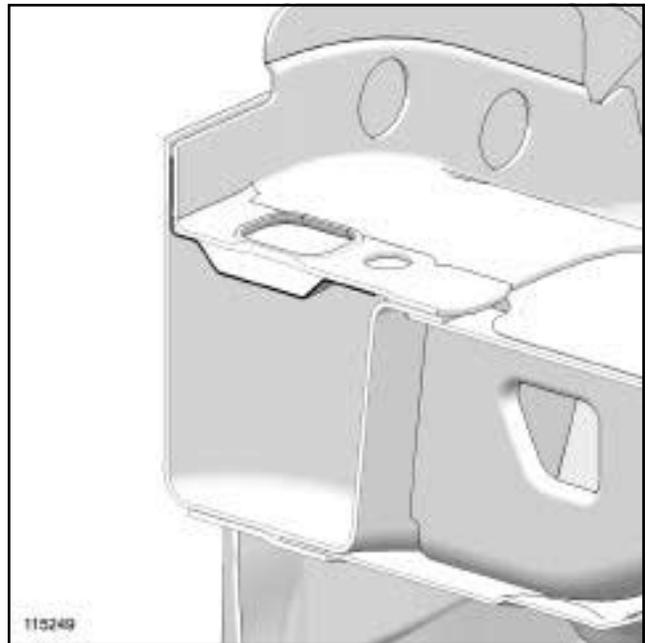
II - PART FITTED

complete replacement



102972

Cut A



115249

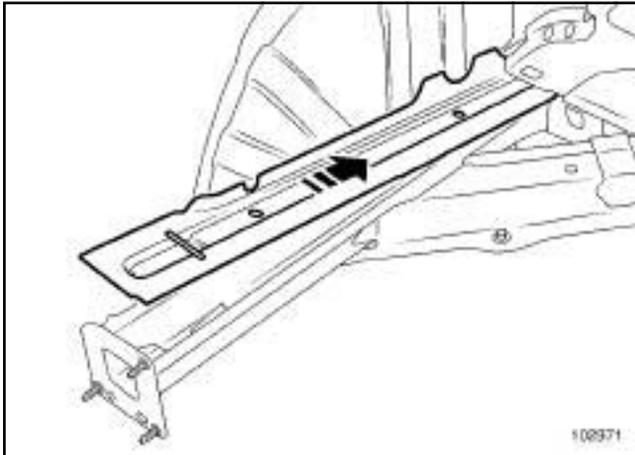
REAR LOWER STRUCTURE

41D

Rear side member closure panel, rear section: Description

B84 or C84

Fitting the side member closure panel



102971

WARNING

If the spot welds cannot be made as they were originally using an electric spot welding machine, they should be replaced with plug welds after holes have been drilled in the first panel.

IMPORTANT

To avoid damaging the vehicle's electric and electronic components, the battery and the earths of any wiring harness near the weld area must be disconnected.

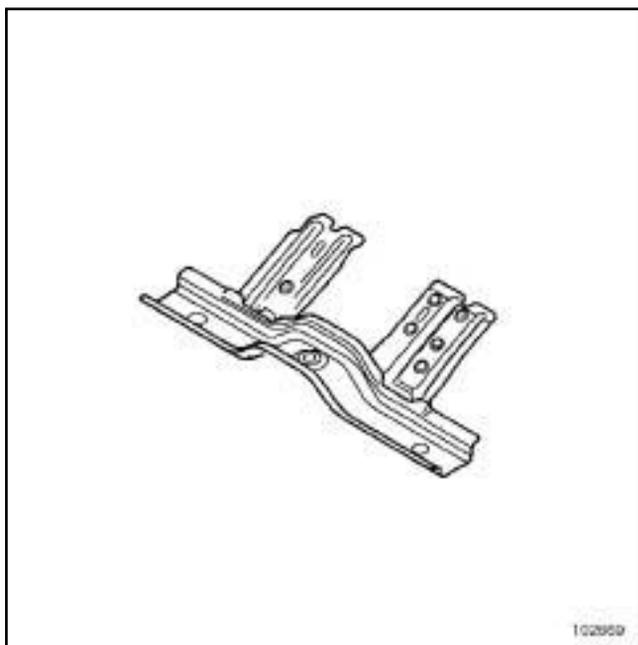
The earth of the welding machine must be placed as close as possible to the weld area.

REAR LOWER STRUCTURE

41D

Rear floor front cross member, centre section: Description

B84 or C84



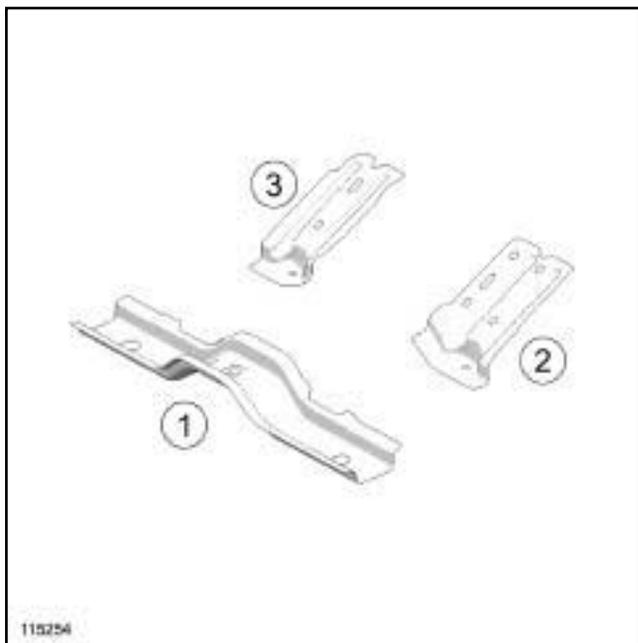
102959

102669

there is only one way of replacing this part:

- complete replacement: this operation complements the replacement of the rear side member after a side impact.

I - COMPOSITION OF THE SPARE PART

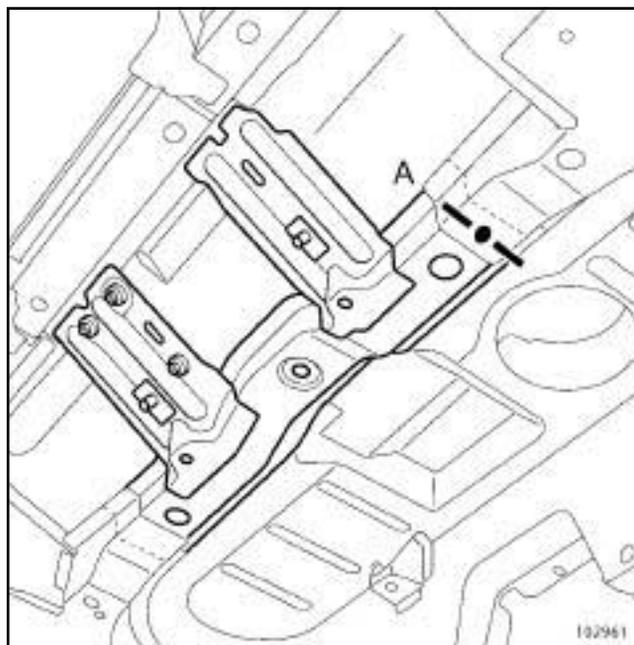


115254

115254

Number	Description	Type	Thickness (mm)
(1)	Rear axle cross member	HEL	1.2
(2)	Rear left-hand seat belt anchorage centre stiffener	HEL	2
(3)	Rear right-hand seat belt anchorage centre stiffener	HEL	1.5

II - PART FITTED



102961

102961

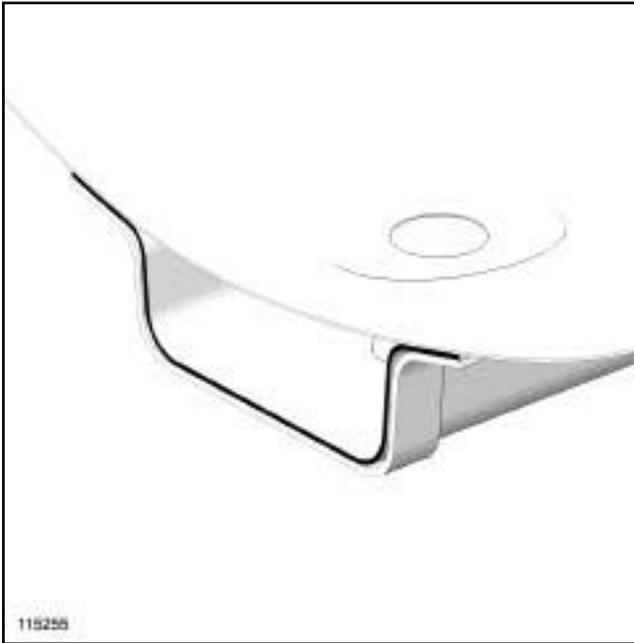
REAR LOWER STRUCTURE

41D

Rear floor front cross member, centre section: Description

B84 or C84

Cut A



115255

WARNING

If the spot welds cannot be made as they were originally using an electric spot welding machine, they should be replaced with plug welds after holes have been drilled in the first panel.

Rear floor centre cross member: General description

B84 or C84

WARNING

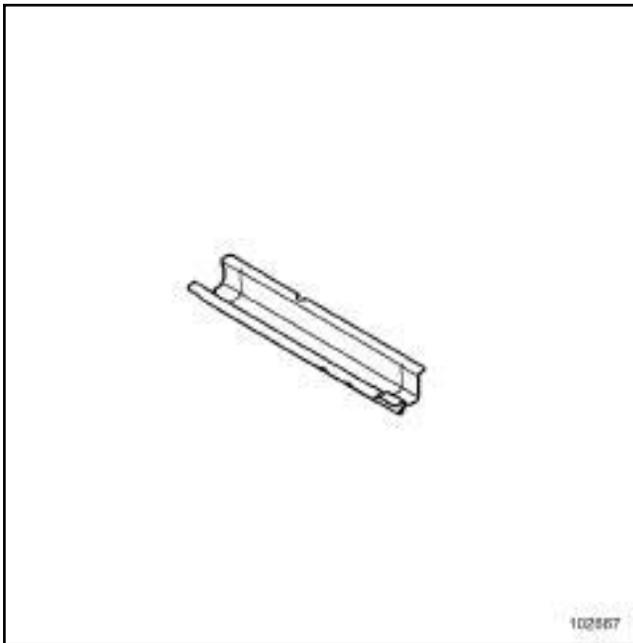
The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading this general information, check that there are no special notes associated with this vehicle. These special features will be specified if applicable in other parts of this sub-section dealing with the part.

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information**.

DESIGN OF THE STRUCTURAL COMPONENT



102667

This is a basic part; it only fulfils the function of a rear floor centre cross member.

REAR LOWER STRUCTURE

41D

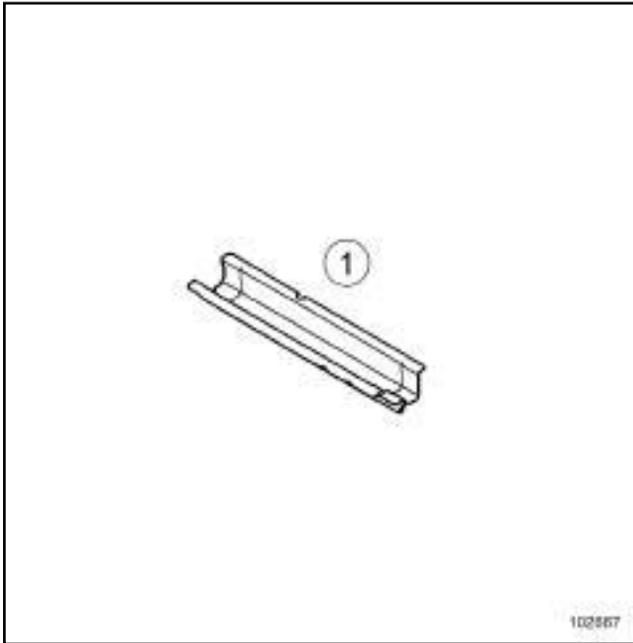
Rear floor centre cross member: Description

B84 or C84

There is only one way of replacing this part:

- complete replacement: this operation supplements the replacement of the rear side member following a rear or side collision.

I - COMPOSITION OF THE SPARE PART

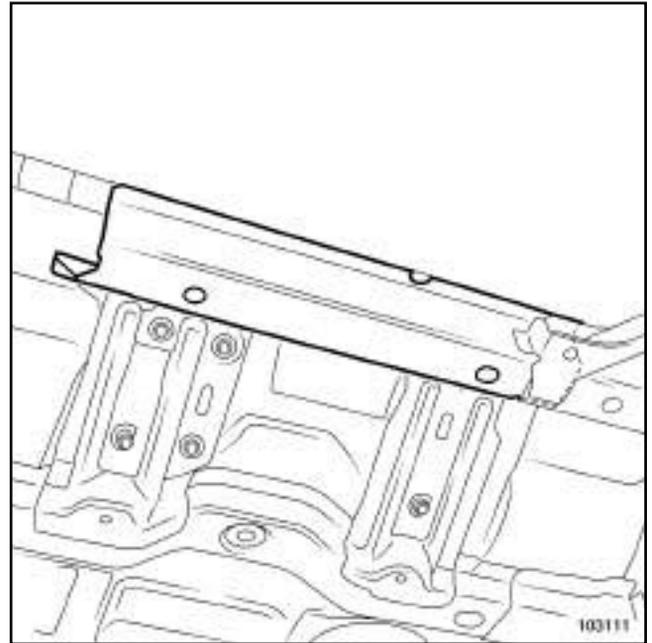


102667

Number	Description	Type	Thic- kness (mm)
(1)	Rear floor centre cross member	HEL	1

II - PART FITTED

Complete replacement



103111

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, they should be replaced with plug welds after holes have been drilled in the first panel.

REAR LOWER STRUCTURE

41D

Far rear lower cross member, side section: Description

B84 or C84

There is only one way of replacing this part:

- complete replacement: this operation supplements the replacement of the rear wheel arch extension, the side lining of the rear end panel and the lower section of the rear wing panel rain channel.

I - COMPOSITION OF THE SPARE PART



102645

II - PART FITTED

Complete replacement



102968

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, they should be replaced with plug welds after holes have been drilled in the first panel.

Number	Description	Type	Thickness (mm)
(1)	Far rear lower cross member, side section	-	1

REAR LOWER STRUCTURE

Exhaust mounting support: Description

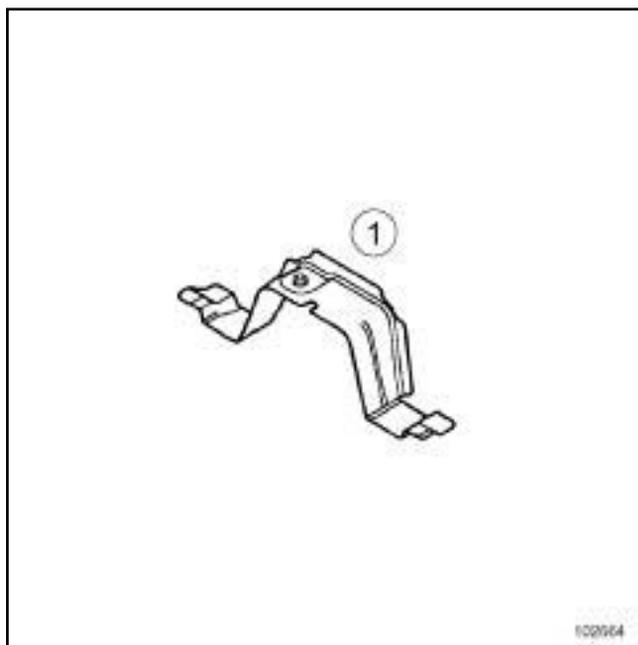
41D

B84 or C84

There is only one way of replacing this part:

- complete replacement: this operation supplements the replacement of the tunnel.

I - COMPOSITION OF THE SPARE PART

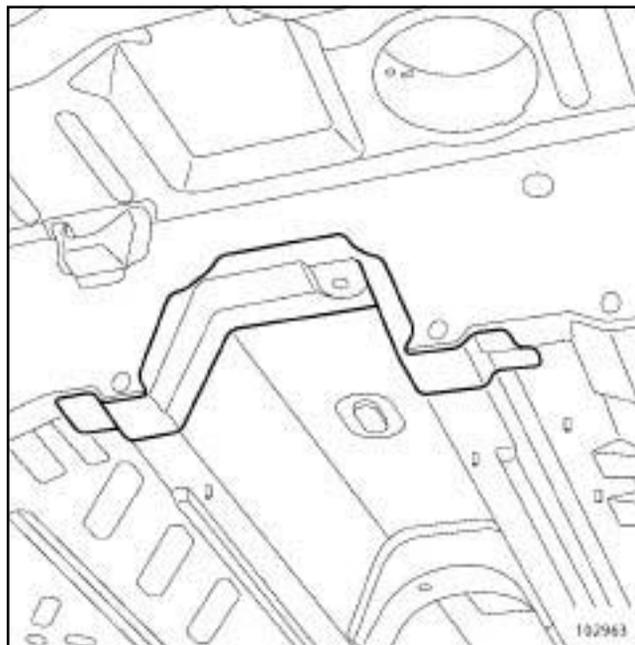


102664

Number	Description	Type	Thickness (mm)
(1)	Exhaust mounting support	-	1.2

II - PART FITTED

complete replacement



102963

Note:

The angle of the exhaust mounting support can be adjusted using the two rivets which should be obtained separately from the **Parts Department** .

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, they should be replaced with plug welds after holes have been drilled in the first panel.

REAR LOWER STRUCTURE

Tank mounting support: Description

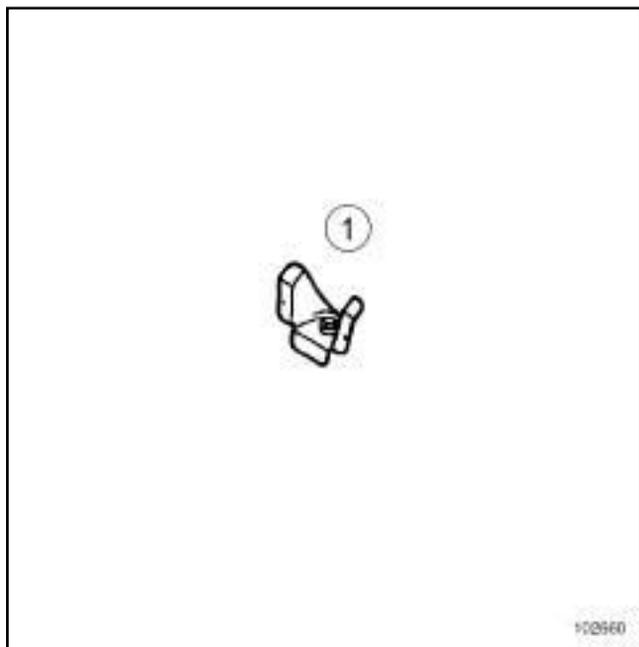
41D

B84 or C84

There is only one way of replacing this part:

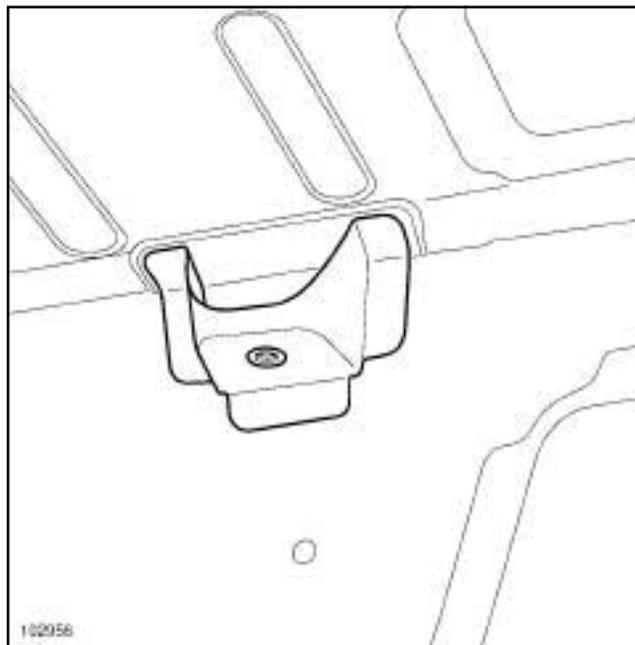
- complete replacement.

I - COMPOSITION OF THE SPARE PART



II - PART FITTED

Complete replacement



WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, they should be replaced with plug welds after holes have been drilled in the first panel.

Number	Description	Type	Thickness (mm)
(1)	Fuel tank mounting support .	-	1.2

Rear impact lower cross member: General description

B84 or C84

WARNING

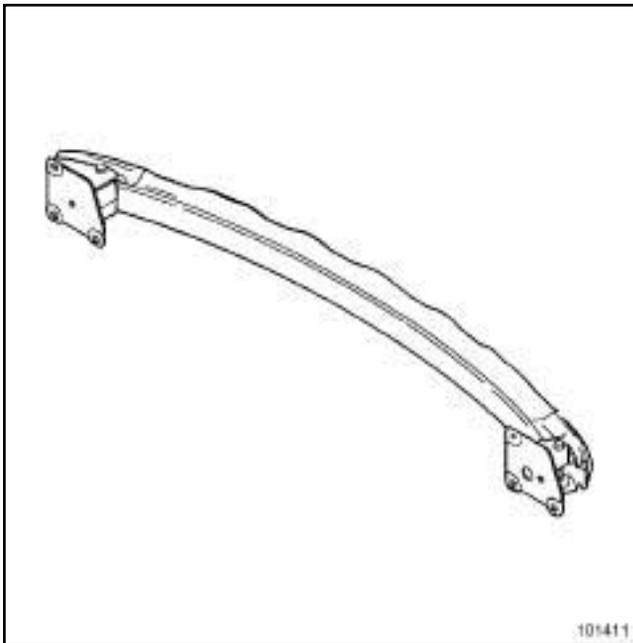
The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the part.

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information**.

DESIGN OF THE STRUCTURAL COMPONENT



101411

This component is made from aluminium.

A feature of this component is that it is attached to the ends of rear side members.

B84 or C84

Tightening torques

rear impact lower cross member mounting nuts	21 Nm
--	-------

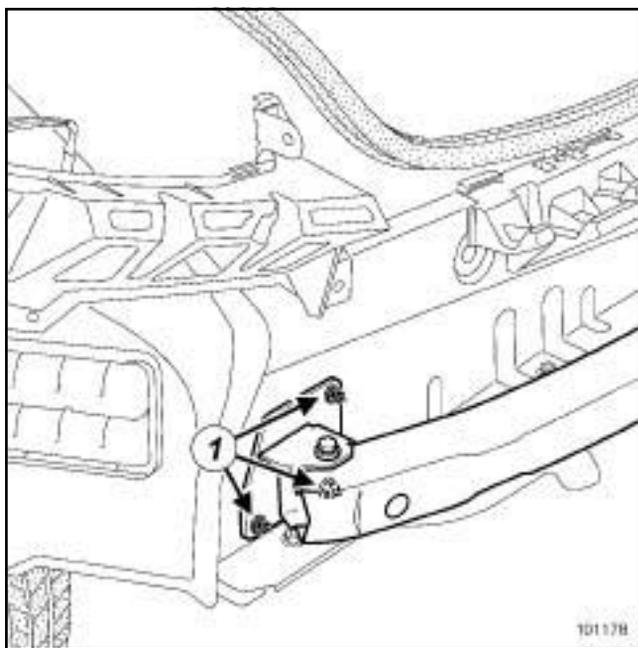
REMOVAL

I - REMOVAL PREPARATION OPERATION

Remove:

- the rear lights((see **Rear light on wing: Removal - Refitting**) ,
- the rear bumper((see **Rear bumper: Removal - Refitting**) .

II - OPERATION FOR REMOVAL OF PART CONCERNED



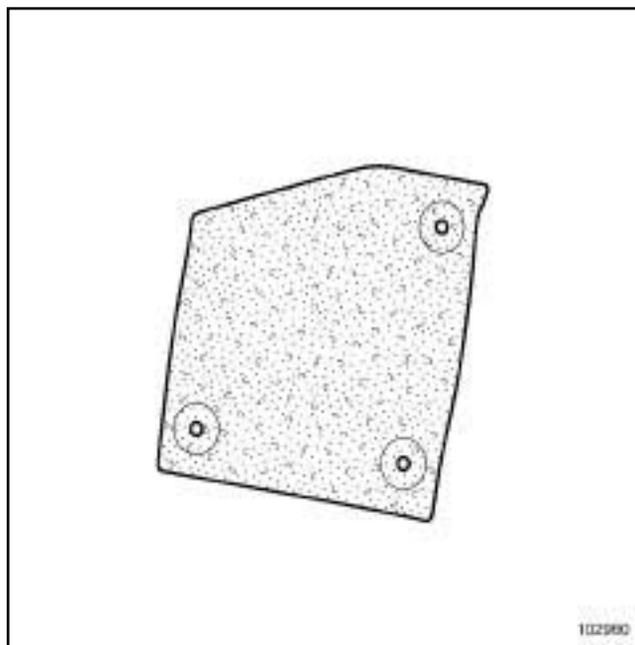
101178

Remove:

- the mounting nuts (1) ,
- the rear impact lower cross member.

REFITTING

I - REFITTING PREPARATION OPERATION



102960

Note:

Replace the foam on the rear impact lower cross member if it has been damaged.

II - REFITTING OPERATION FOR PART CONCERNED

Refit:

- the rear impact lower cross member,
- the mounting nuts (1) .

Tighten to torque the **rear impact lower cross member mounting nuts (21 Nm)** .

III - FINAL OPERATION

Refit:

- the rear bumper((see **Rear bumper: Removal - Refitting**) ,
- the rear lights((see **Rear light on wing: Removal - Refitting**) .

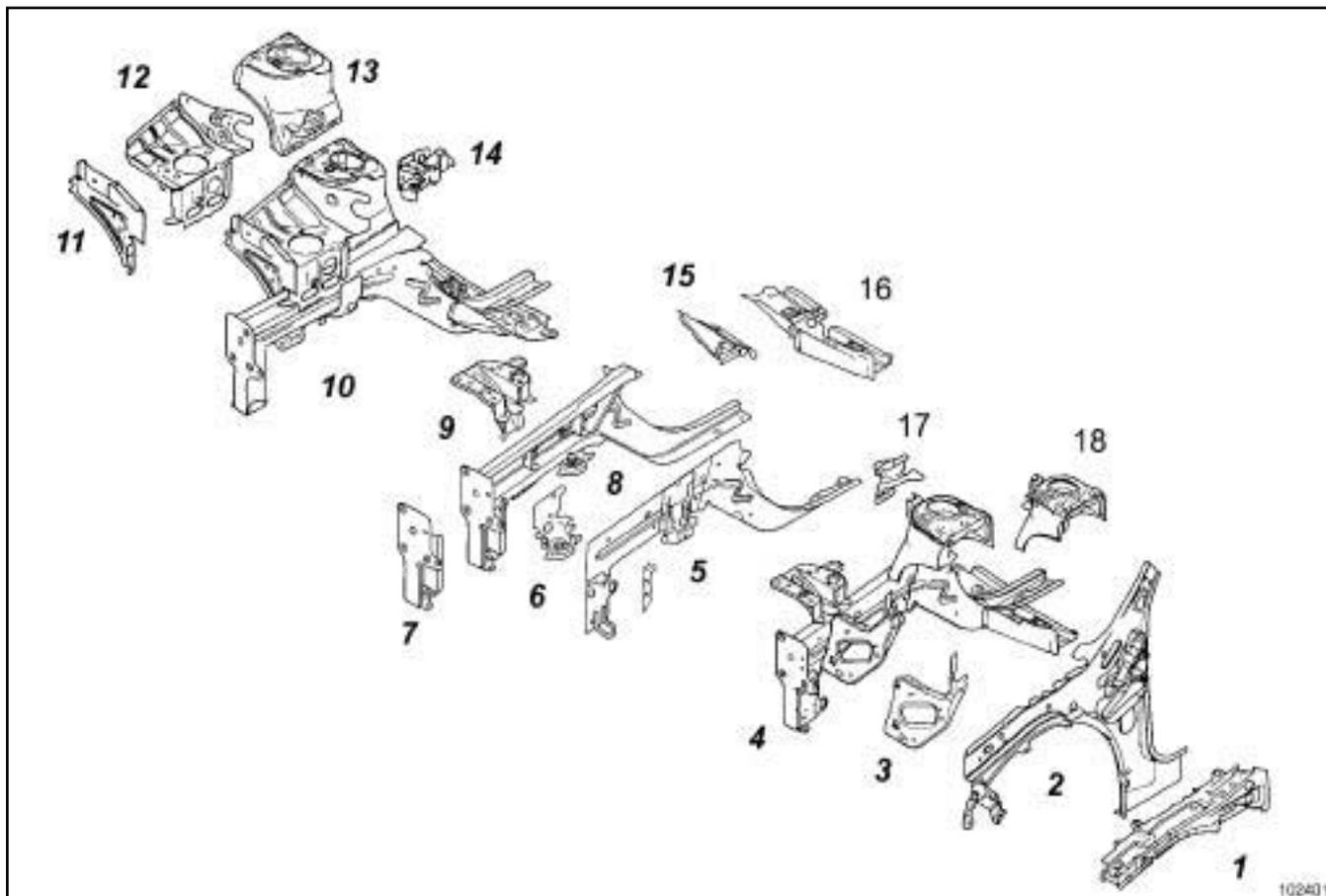
UPPER FRONT STRUCTURE

Vehicle front section structure: Description

42A

B84 or C84

FRONT STRUCTURE



102401

102401

Mark	Description	Classification	Type	Thickness (mm)
(1)	Scuttle side panel upper reinforcement	(see 42A, Upper front structure, Scuttle side panel upper reinforcement: Description, page 42A-32)	-	0.9
(2)	Scuttle side panel	(see 42A, Upper front structure, Cowl side panel: Description, page 42A-28)	HLE/ THLE	1/2.5
(3)	Front end side cross member	(see Front end side cross member: Description)	-	1.2
(4)	Left-hand front half unit	(see 41A, Front lower structure, Front half unit: Description, page 41A-39)	HLE/ THLE	1.1/3
(5)	Front section of front side member closure panel	(see 41A, Front lower structure, Front section of front side member closure panel: Description, page 41A-23)	HLE/ THLE	1.7/3

UPPER FRONT STRUCTURE

Vehicle front section structure: Description

42A

B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(6)	Front mounting of front sub-frame	(see 41A, Front lower structure, Front mounting of front sub-frame: Description, page 41A-32)	HLE	1.2
(7)	Radiator cross member support	(see 41A, Front lower structure, Radiator cross member support: Description, page 41A-29)	-	1.2/2.5
(8)	Front side member	(see 41A, Front lower structure, Front side member: Description, page 41A-17)	HLE/ THLE	1.2/3
(9)	Battery tray bracket	(see 41A, Front lower structure, Battery tray support: Description, page 41A-27)	-	1.5/2
(10)	Right-hand front half unit	(see 41A, Front lower structure, Front half unit: Description, page 41A-39)	HLE/ THLE	1.1/3
(11)	Front end side cross member	(see Front end side cross member: Description)	-	1.2
(12)	Engine stand	(see 41A, Front lower structure, Engine mounting: Description, page 41A-34)	HLE	1.5/2
(13)	Wheel arch	(see 42A, Upper front structure, Front wheel arch: Description, page 42A-35)	-	1.1/2
(14)	Engine tie-bar mounting		HLE	1
(15)	Sub-frame rear mounting	(see Sub-frame rear mounting: Description)	HLE/ THLE	2/3
(16)	Centre floor front side cross member	(see 41B, Centre lower structure, Centre floor front lateral cross member: Description, page 41B-18)	HLE/ THLE	1.2/3
(17)	Connecting bracket			
(18)	Front wheel arch	(see 42A, Upper front structure, Front wheel arch: Description, page 42A-35)	HLE	1.1/2

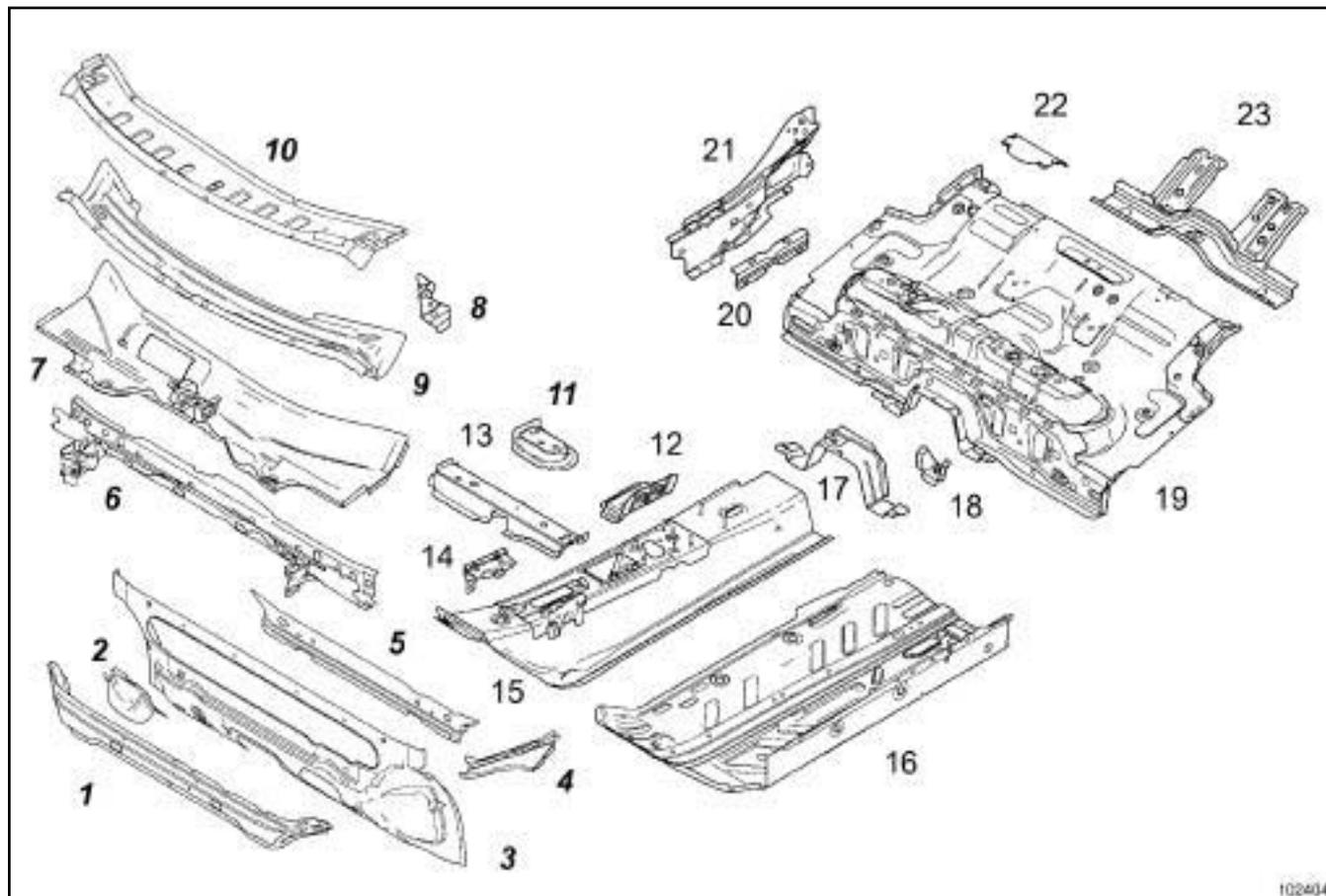
UPPER FRONT STRUCTURE

Vehicle central section structure: Description

42A

B84 or C84

CENTRAL STRUCTURE



102404

102404

Mark	Description	Classification	Type	Thickness (mm)
(1)	Bulkhead lower cross member	(see 42A, Upper front structure, Bulkhead lower cross member: Description, page 42A-53)	VHLE	2.5
(2)	Steering column unit		-	1.5
(3)	Bulkhead	(see 42A, Upper front structure, Bulkhead: Description, page 42A-49)	-	0.9
(4)	Bulkhead side reinforcement	(see 42A, Upper front structure, Bulkhead side stiffener: Description, page 42A-59)	UHLE	1.7
(5)	Bulkhead reinforcement	(see 42A, Upper front structure, Bulkhead reinforcement: Description, page 42A-51)	UHLE	1.7

UPPER FRONT STRUCTURE

Vehicle central section structure: Description

42A

B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(6)	Bulkhead upper cross member	(see 42A, Upper front structure, Bulkhead upper cross member: Description, page 42A-57)	HLE	0.95/3
(7)	Heater bulkhead	(see 42A, Upper front structure, Heater bulkhead: Description, page 42A-38)	-	0.7/1.2
(8)	Windscreen wiper mounting	(see 42A, Upper front structure, Windscreen wiper mounting: Description, page 42A-61)	-	1.2
(9)	Windscreen aperture lower cross member	(see 42A, Upper front structure, Windscreen aperture lower cross member: Description, page 42A-41)	-	0.7
(10)	Windscreen aperture lower cross member closure panel	(see 42A, Upper front structure, Windscreen aperture lower cross member closure panel: Description, page 42A-47)	-	0.65/1.2
(11)	Front seat mounting exterior unit	(see 41B, Centre lower structure, Front seat rear outer mounting unit: Description, page 41B-26)	HLE	1.5
(12)	Front seat mounting interior unit	(see 41B, Centre lower structure, Front seat rear mounting interior unit: Description, page 41B-25)	HLE	1.5/2.5
(13)	Front cross member under front seat	(see 41B, Centre lower structure, Front cross member under front seat: Description, page 41B-23)	HLE	1.5
(14)	Steering column mounting		-	1.3
(15)	Tunnel	(see 41B, Centre lower structure, Tunnel: Description, page 41B-20)	HLE/ THLE	1/1.6
(16)	Centre floor, side section	(see 41B, Centre lower structure, Central floor, side section: Description, page 41B-13)	VHLE	0.7/2.5
(17)	Exhaust mounting support	(see 41D, Rear lower structure, Exhaust mounting support: Description, page 41D-30)	-	1.2/2.5

UPPER FRONT STRUCTURE

Vehicle central section structure: Description

42A

B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(18)	Fuel tank mounting support	(see 41D, Rear lower structure, Tank mounting support: Description, page 41D-31)	-	1.2
(19)	Front section of rear floor	(see 41D, Rear lower structure, Rear floor, front section: Description, page 41D-10)	HLE/ THLE	0.7/2.5
(20)	Sill panel reinforcement stiffener		VHLE	1.8
(21)	Sill panel rear reinforcement	(see 41C, Side lower structure, Sill panel rear reinforcement: Description, page 41C-29)	HLE	1.4
(22)	Fuel gauge closure panel		HLE	0.8
(23)	Rear floor front cross member, centre section	(see 41D, Rear lower structure, Rear floor front cross member, centre section: Description, page 41D-25)	HLE	1.2/2

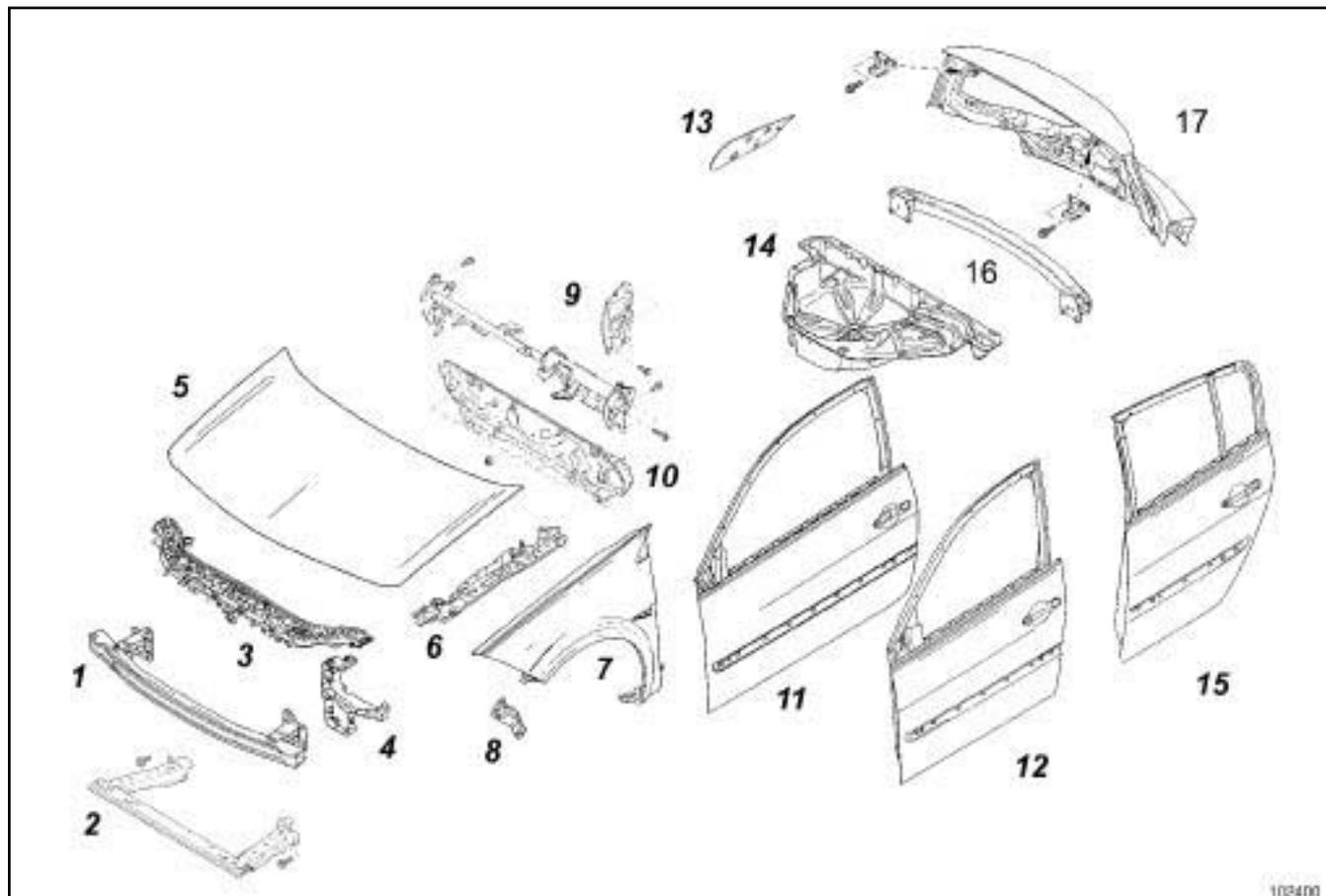
UPPER FRONT STRUCTURE

Vehicle removable section structure: Description

42A

B84 or C84

STRUCTURE WHICH CAN BE DISMANTLED



102400

102400

Mark	Description	Classification	Type
(1)	Frontal impact cross member	(see 41A, Front lower structure, Front impact cross member: Removal - Refitting, page 41A-8)	Aluminium
(2)	Radiator mounting cross member	(see 41A, Front lower structure, Radiator support cross member: Removal - Refitting, page 41A-13)	
(3)	Front end panel centre section	(see 42A, Upper front structure, Front: Removal - Refitting, page 42A-23)	Steel/SMC
(4)	Front end panel side section	(see 42A, Upper front structure, Front: Removal - Refitting, page 42A-23)	SMC
(5)	Bonnet	(see 48A, Non-side opening elements, Bonnet: Removal - Refitting, page 48A-5)	Aluminium

UPPER FRONT STRUCTURE

42A

Vehicle removable section structure: Description

B84 or C84

Mark	Description	Classification	Type
(6)	Front wing upper mounting support	(see 42A, Upper front structure, Front wing upper mounting support: Removal - Refitting, page 42A-20)	
(7)	Front wing	(see 42A, Upper front structure, Front wing: Removal - Refitting, page 42A-11)	Noryl
(8)	Front wing lower mounting support	(see 42A, Upper front structure, Front wing lower mounting support: Removal - Refitting, page 42A-18)	
(9)	Dashboard cross member	(see 42A, Upper front structure, Dashboard cross member: Removal - Refitting, page 42A-42)	
(10)	Bulkhead plate	(see 42A, Upper front structure, Bulkhead panel: Removal - Refitting, page 42A-54)	Aluminium
(11)	Front side door, 3-door version	(see 47A, Side opening elements, Front side door: Removal - Refitting, page 47A-5)	
(12)	Front side door, 5-door version	(see 47A, Side opening elements, Front side door: Removal - Refitting, page 47A-5)	
(13)	Fuel filler flap cover	(see 47A, Side opening elements, Fuel filler flap cover: Removal - Refitting, page 47A-27)	Noryl
(14)	Rear section of rear floor	(see Rear floor rear section: Description)	
(15)	Rear side door	(see 47A, Side opening elements, Rear side door: Removal - Refitting, page 47A-18)	
(16)	Rear impact lower cross member	(see 41D, Rear lower structure, Rear impact lower cross member: Removal - Refitting, page 41D-33)	Polypropylene
(17)	Tailgate	(see 48A, Non-side opening elements, Tailgate: Removal - Refitting, page 48A-11)	

UPPER FRONT STRUCTURE

Front wing: General description

42A

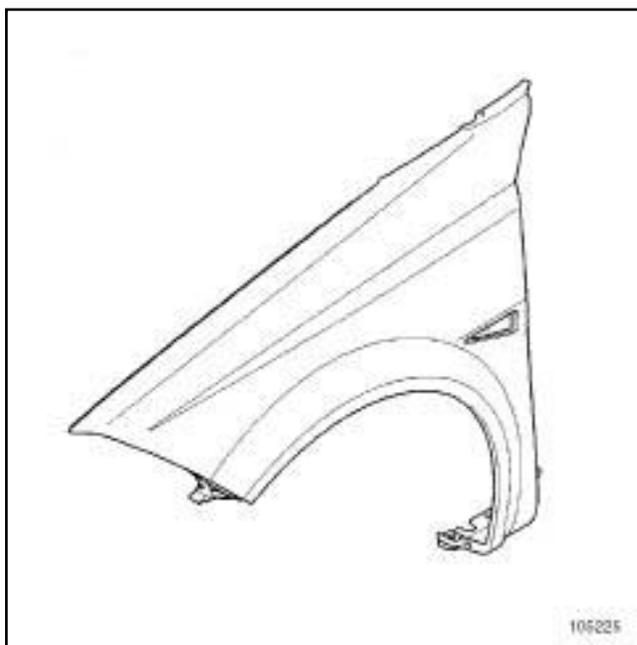
B84 or C84

WARNING

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the part.

I - DESIGN OF THE STRUCTURAL COMPONENT



105225

This type of front wing has the following specifications:

- plastic wing (NORYL),
- wing bolted to its upper mounting support.

II - REMOVAL - REFITTING

Note:

If the component is to be removed and not replaced, mark the position of the mountings before unscrewing them to avoid having making adjustments when refitting the component.

To remove or replace the front wing, remove:

- the scuttle panel grille,
- the engine side trim,
- the front wing upper trim,

- the front wheel arch liner,
- the front section of the sill panel protector,
- the front wing direction indicator,
- the front bumper,
- the front headlight.

III - ADJUSTMENT

Note:

The front wing is the penultimate removable component to be fitted to the vehicle body in the factory.

For final adjustment, correctly position all the other components including the bumper and the headlights for them to be correctly positioned.

Two main areas of adjustment may be identified:

- the adjustment of the rear area,
- the adjustment of the front area

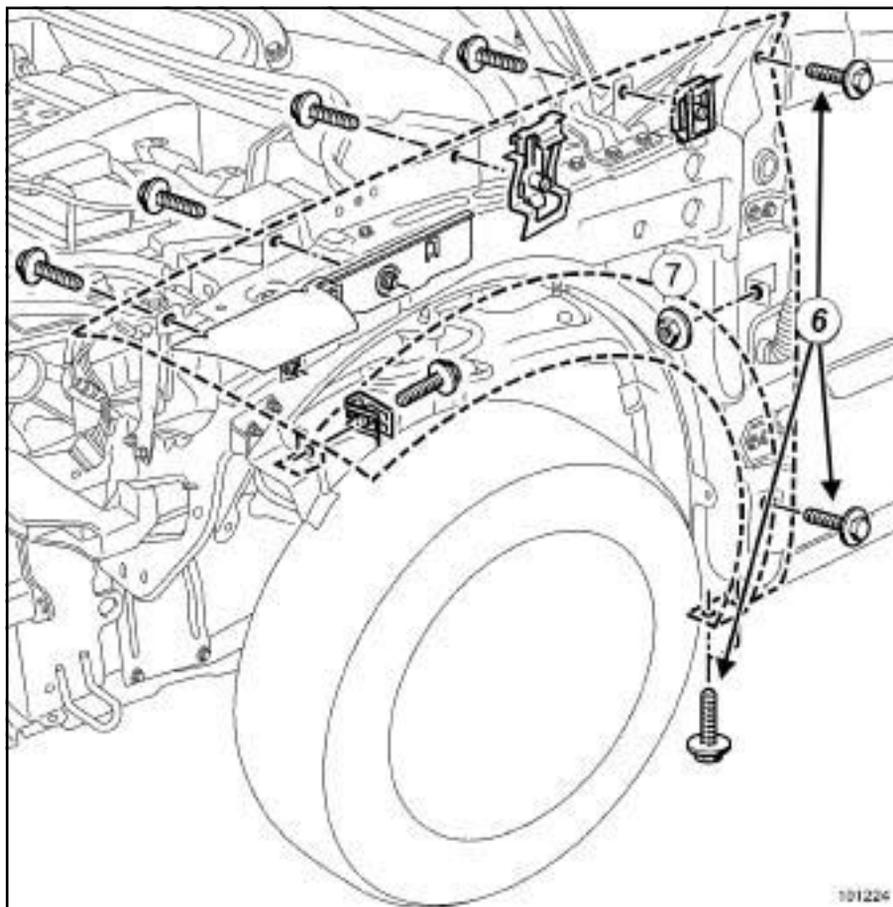
UPPER FRONT STRUCTURE

Front wing: General description

42A

B84 or C84

1 - Adjustment of the rear area:



Adjust the shut lines and alignment with the front door using mountings (6) and (7) .

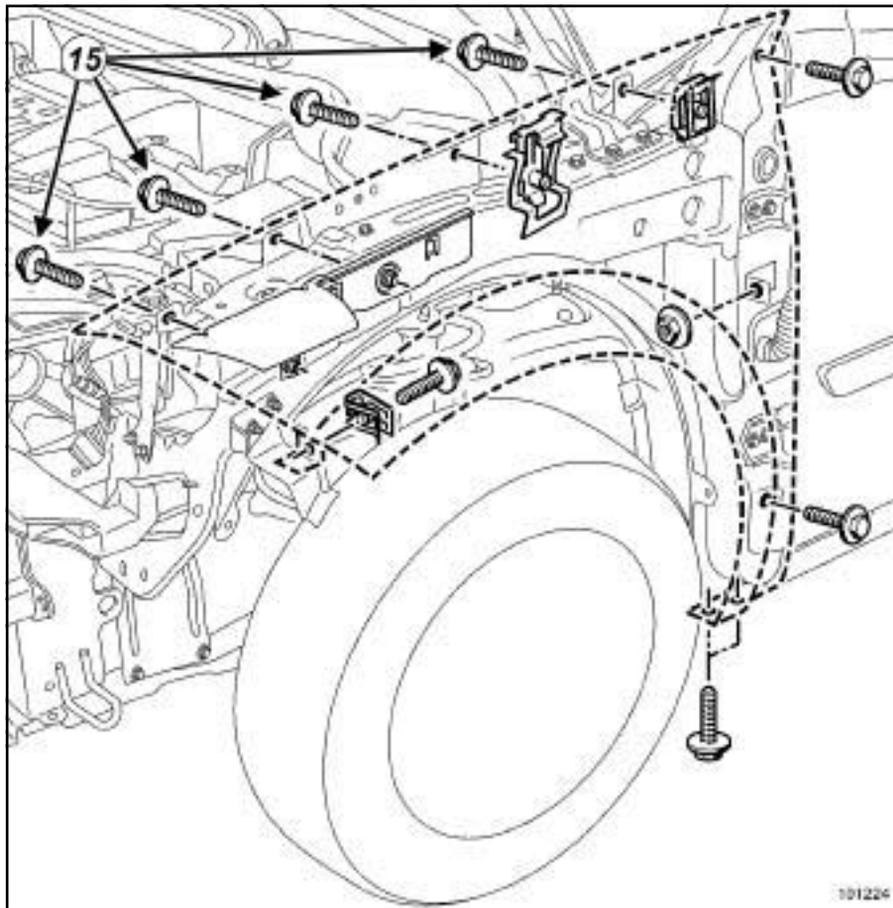
UPPER FRONT STRUCTURE

Front wing: General description

42A

B84 or C84

2 - Adjustment of the front area:



Adjust the alignment of the front wing using mountings (15).

UPPER FRONT STRUCTURE

Front wing: Removal - Refitting

42A

B84 or C84

Tightening torques 	
bolts (A)	6.5 Nm
nut (B)	6.5 Nm

The front wing is a structural bodywork component made of thermoplastic, and can be removed.

REMOVAL

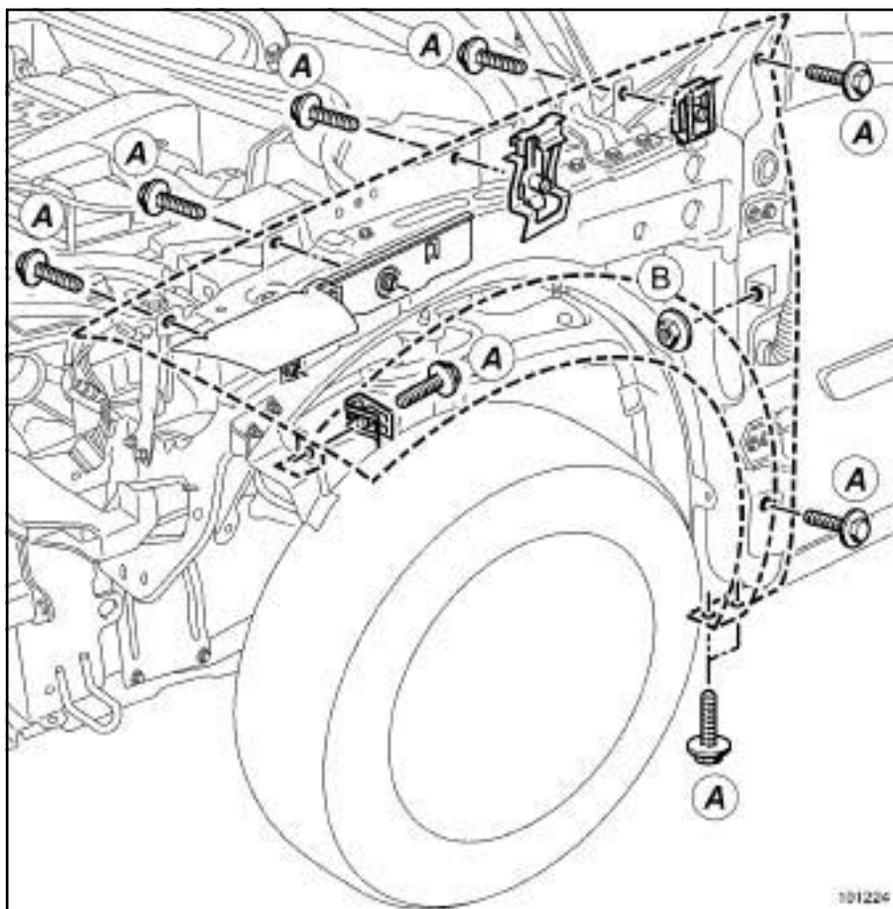
I - REMOVAL PREPARATION OPERATION

Remove:

- the scuttle panel grille(see **Scuttle panel grille: Removal - Refitting**) ,

- the engine side trim,
- the front wing upper trim,
- the front wheel arch liner((see **Front wheel arch liner: Removal - Refitting**)
- the front section of the sill panel protector,
- the front wing direction indicator,
- the front bumper((see **Front bumper: Removal - Refitting**) ,
- the front headlight((see **Halogen headlight: Removal - Refitting**) .

II - OPERATION FOR REMOVAL OF PART CONCERNED



101224

Remove:

- the bolts (A) ,
- the nut (B) ,
- the front wing.

UPPER FRONT STRUCTURE

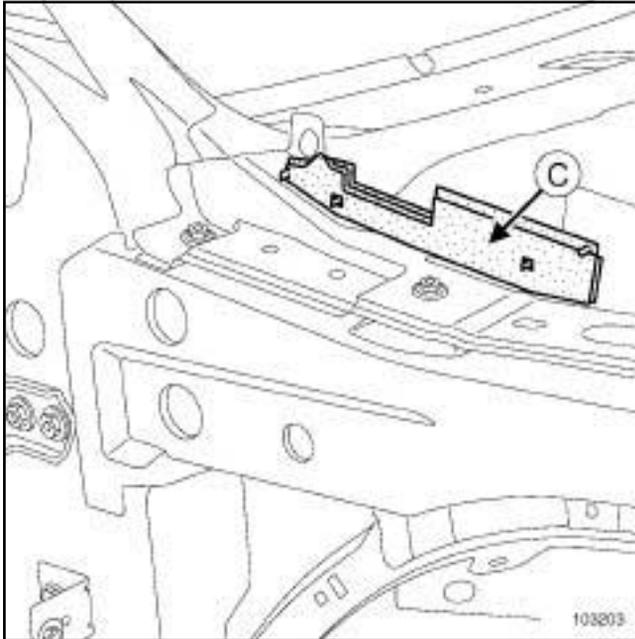
Front wing: Removal - Refitting

42A

B84 or C84

REFITTING

I - REFITTING PREPARATION OPERATION



103203

- Always replace the expanding insert (C) .

II - REFITTING OPERATION FOR PART CONCERNED

- Refit:
 - the front wing,
 - the nut (B) ,
 - the bolts (A) .
- Adjust the shut lines and flush fitting (see **Front wing: Adjustment**) .
- tighten to torque:
 - the bolts (A) (6.5 Nm) ,
 - the nut (B) (6.5 Nm) .

III - FINAL OPERATION

- Refit:
 - the headlight((see **Halogen headlight: Removal - Refitting**) ,
 - the front bumper((see **Front bumper: Removal - Refitting**) ,
 - the front wing direction indicator,
 - the front section of the sill panel protector,
 - the front wheel arch liner((see **Front wheel arch liner: Removal - Refitting**)

- the front wing upper trim,
- the engine side trim,
- the scuttle panel grille((see **Scuttle panel grille: Removal - Refitting**) .

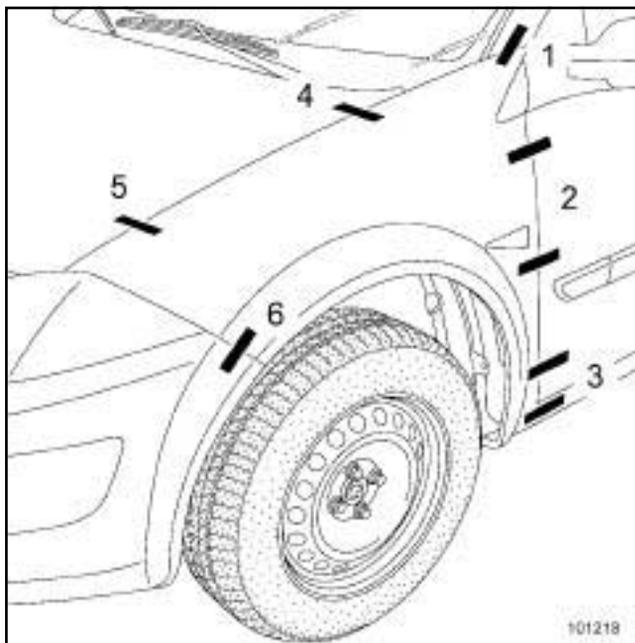
B84 or C84

Tightening torques 	
mounting bolts of the front wing upper mounting support	6.5 Nm
bolts (A)	6.5 Nm
bolt (B)	6.5 Nm
nut (C)	6.5 Nm
bolts (D)	6.5 Nm
bolt (E)	6.5 Nm

ADJUSTMENT VALUES

- For information on front wing adjustment values, (see **Vehicle shut lines: Adjustment value**).

ADJUSTMENT



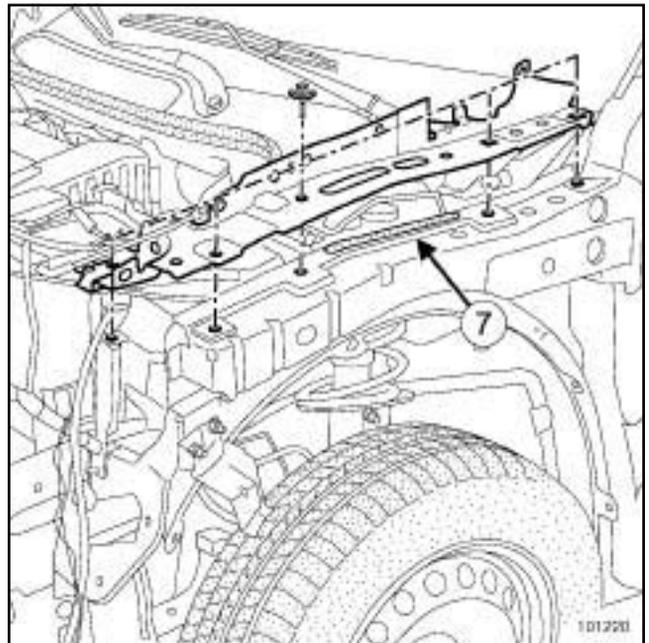
101218

- Observe the adjustment sequence.

I - BASIC ADJUSTMENT

- Remove:
 - the front wing (see **42A, Upper front structure, Front wing: Removal - Refitting**, page **42A-11**),

- the front wing upper mounting support (see **42A, Upper front structure, Front wing upper mounting support: Removal - Refitting**, page **42A-20**)



101220

- Detach and clean the beading (7) .
- Position the support and the wing on the vehicle.
- Finger tighten all the mountings.

B84 or C84



101753

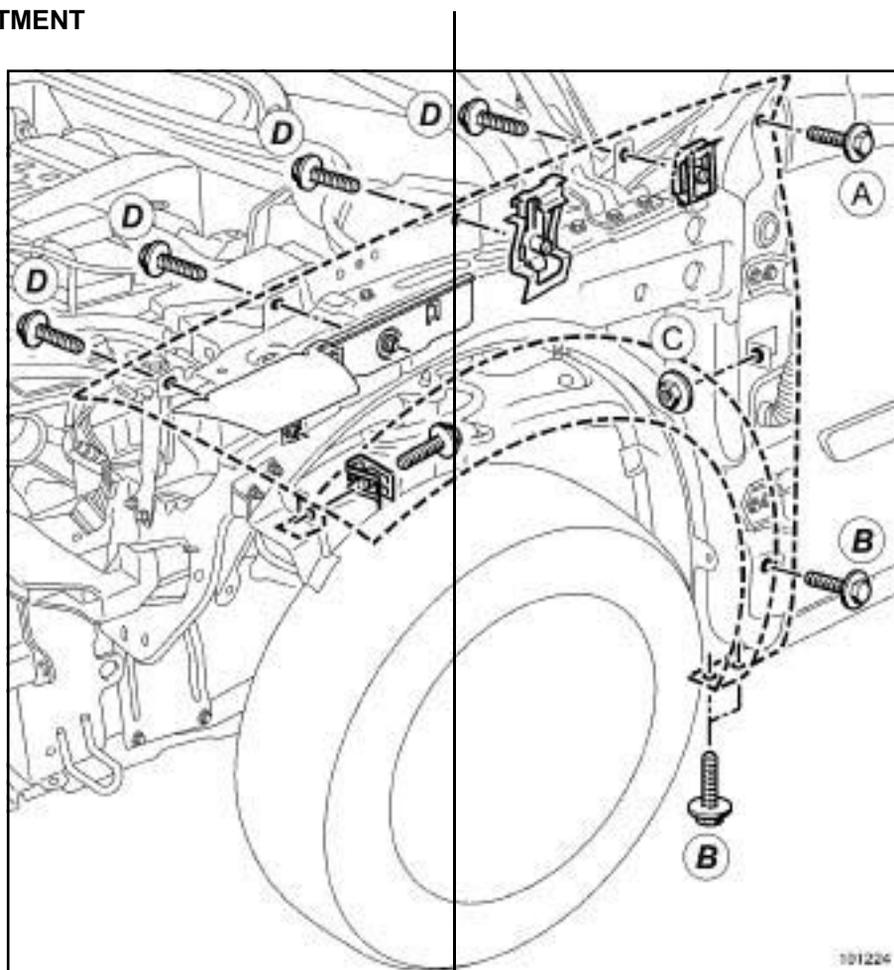
Note:

Only mountings (8) are accessible when the wing is in position.

- Adjust the shut lines and flush fitting between the wing, the door and the bonnet.
- Remove the front wing.
- Mark the position of the upper mounting support then remove it.
- Reapply the cement bead using a **type M.J.Pro setting adhesive** .
- Tighten to torque the **mounting bolts of the front wing upper mounting support (6.5 Nm)** .

B84 or C84

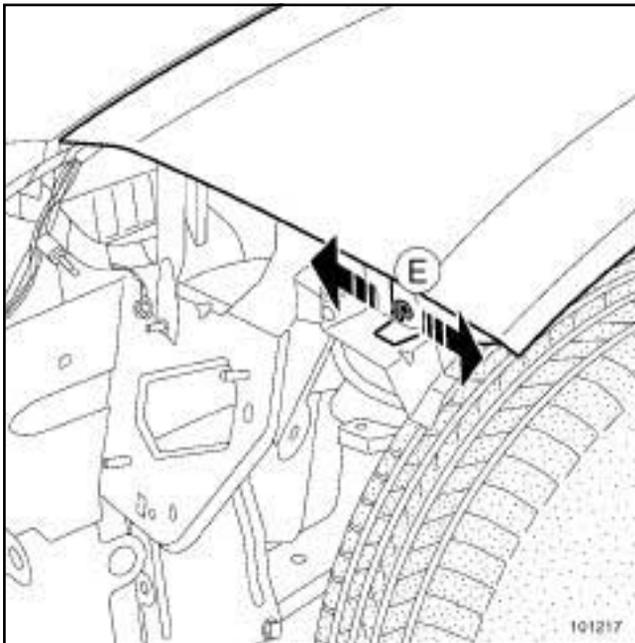
II - FINAL ADJUSTMENT



101224

- Adjust the shut lines and flush fitting of area (1) .
- Tighten to torque **bolts (A) (6.5 Nm)** .
- Adjust the shut lines and flush fitting of areas (2) and (3) .
- Tighten to torque:
 - the **bolt (B) (6.5 Nm)** ,
 - the **nut (C) (6.5 Nm)** .
- Adjust the shut lines and flush fitting of areas (4) and (5) .
- Tighten to torque the **bolts (D) (6.5 Nm)** .

B84 or C84



101217

- Adjust the shut lines and flush fitting of area **(6)** .
- Tighten to torque the **bolt (E) (6.5 Nm)** .
- Adjust the headlight setting if necessary.

Note:

Adjustment cannot be made at the bumper, as it is fitted into the wing lower pressure piece.

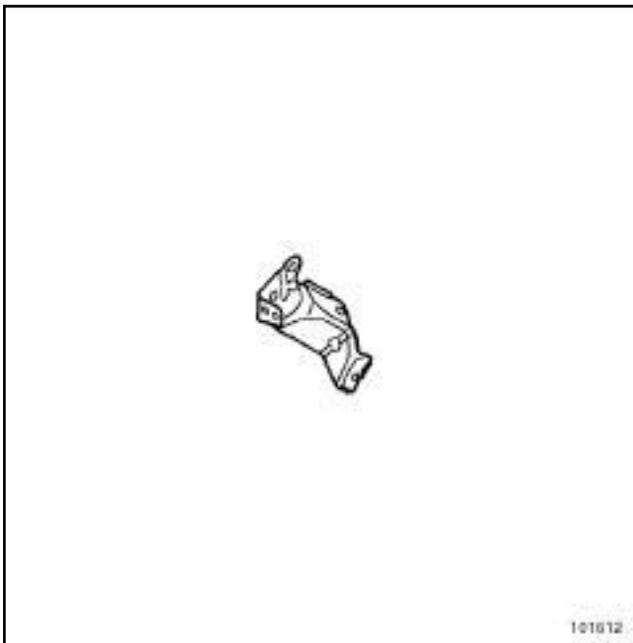
B84 or C84

WARNING

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the part.

DESIGN OF THE STRUCTURAL COMPONENT



101612

This is a basic part, it fulfils the function of a front wing lower mounting support and it enables the front wing to be adjusted in the Y axis.

This part is bolted to the scuttle side panel.

B84 or C84

Tightening torques 	
front wing lower mounting support nuts (2)	6.5 Nm
front wing mounting bolt (1)	6.5 Nm

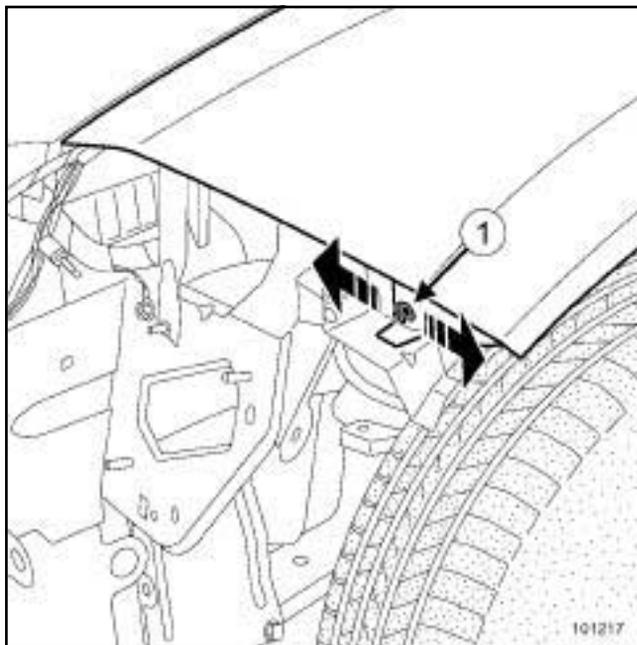
REMOVAL

I - REMOVAL PREPARATION OPERATION

Remove:

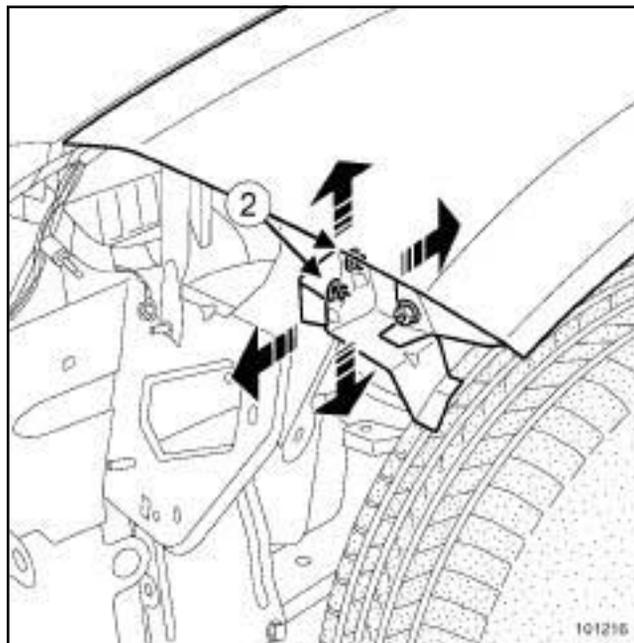
- the front wheel arch liner((see **Front wheel arch liner: Removal - Refitting**) ,
- the front bumper((see **Front bumper: Removal - Refitting**) ,
- the front headlight((see **Halogen headlight: Removal - Refitting**) .

II - OPERATION FOR REMOVAL OF PART CONCERNED



101217

Remove the mounting bolt (1) from the front wing.



101216

Remove:

- the mounting nuts (2) from the support,
- the front wing lower mounting support.

REFITTING

I - REFITTING OPERATION FOR PART CONCERNED

Refit:

- the front wing lower mounting support,
- the mounting nuts (2) from the support,
- the mounting bolt (1) from the front wing.

Tighten to torque:

- the **front wing lower mounting support nuts (2) (6.5 Nm)** ,
- the **front wing mounting bolt (1) (6.5 Nm)** .

II - FINAL OPERATION

Refit:

- the headlight((see **Halogen headlight: Removal - Refitting**) ,
- the front bumper((see **Front bumper: Removal - Refitting**) ,
- the front wheel arch liner((see **Front wheel arch liner: Removal - Refitting**) .

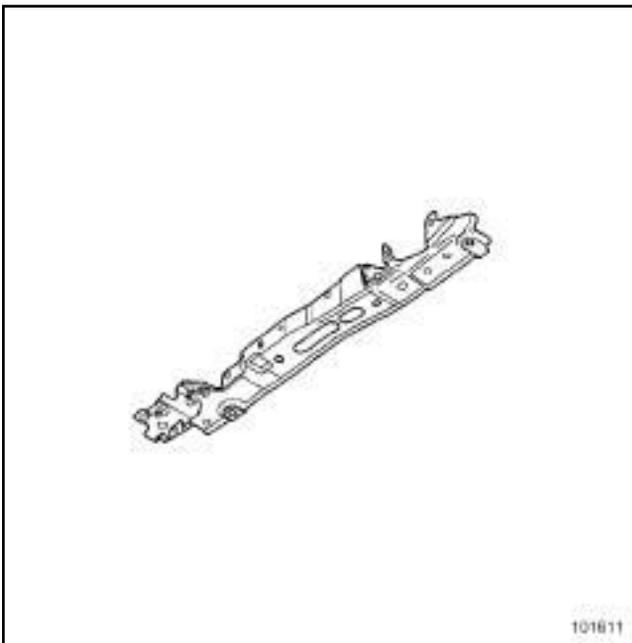
B84 or C84

WARNING

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the part.

DESIGN OF THE STRUCTURAL COMPONENT



101611

This is a basic part, it fulfils the function of front wing upper mounting support and it enables the front wing to be adjusted in the X and Y axes.

B84 or C84

Tightening torques

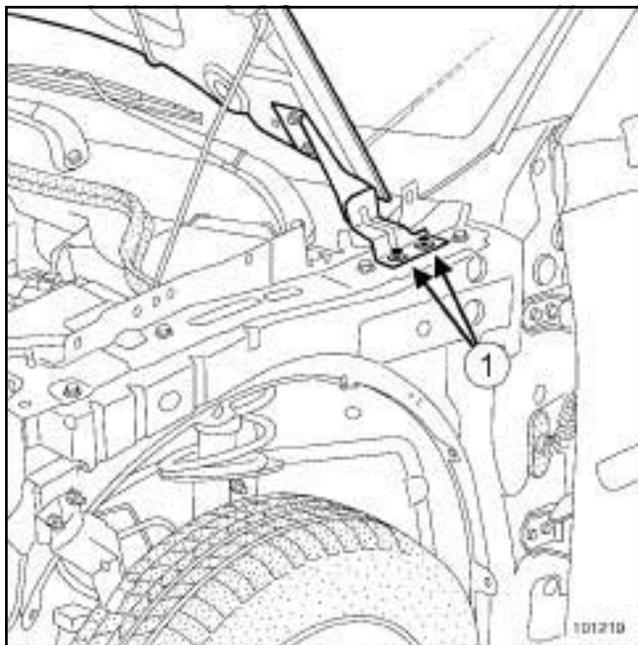
front wing upper mounting support bolts	6.5 Nm
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REMOVAL

I - REMOVAL PREPARATION OPERATION

Remove:

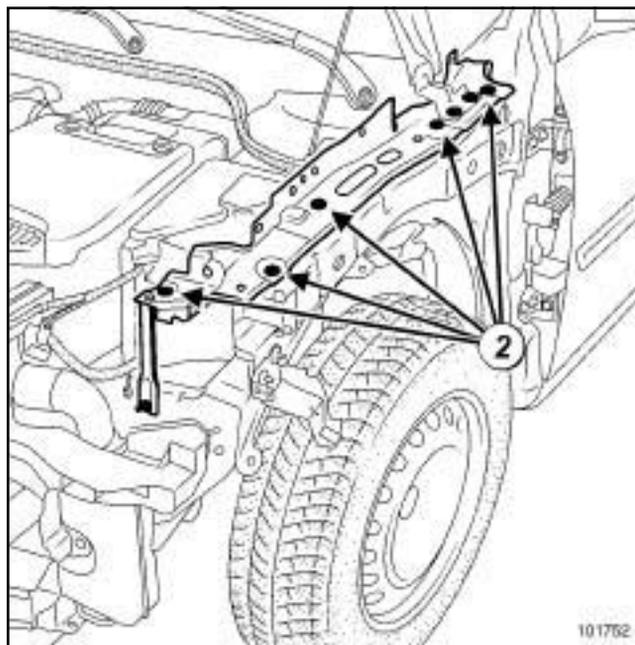
- the front wheel arch liner(see **Front wheel arch liner: Removal - Refitting**) ,
- the front bumper(see **Front bumper: Removal - Refitting**) ,
- the headlight(see **Halogen headlight: Removal - Refitting**) ,
- the front wing (see **42A, Upper front structure, Front wing: Removal - Refitting**, page 42A-11) .



Remove:

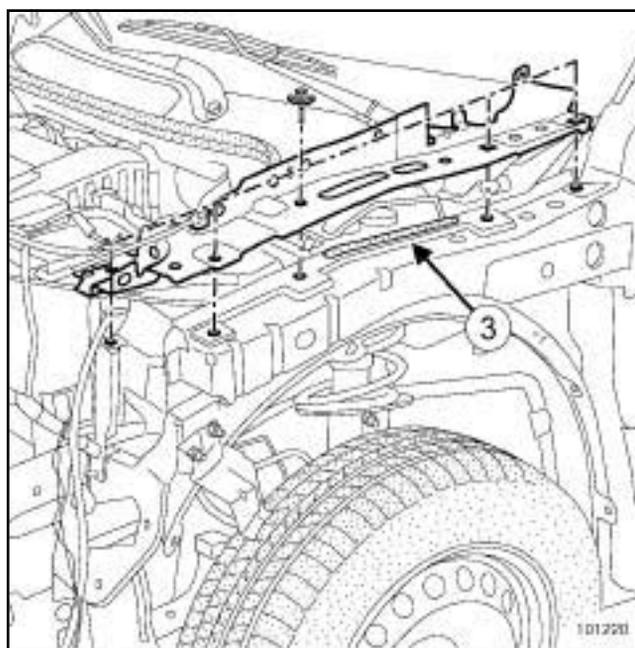
- the mounting bolts (1) from the bonnet hinges,
- the bonnet.

II - OPERATION FOR REMOVAL OF PART CONCERNED



101752

Remove the mounting bolts (2) from the support.



101220

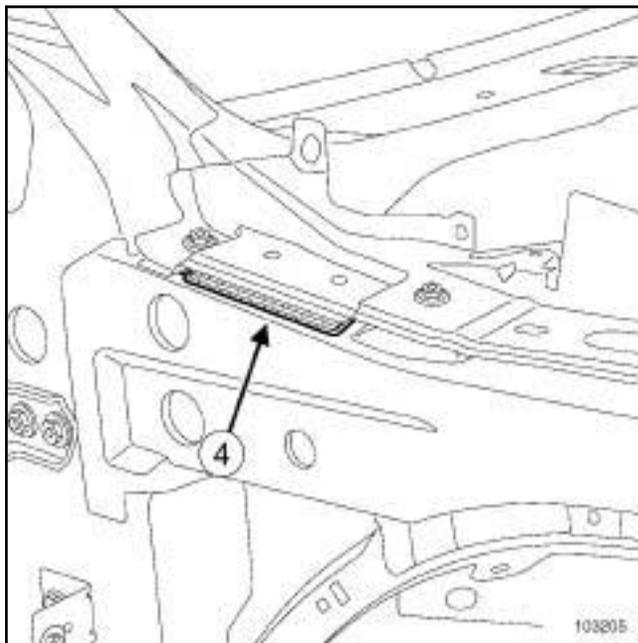
Detach the cement bead (3) .

Remove the front wing upper mounting support.

B84 or C84

REFITTING

I - REFITTING PREPARATION OPERATION



103205

- Always replace the expanding insert (4) .
- Clean and apply a bead (3) of **M.J. PRO setting adhesive** .

WARNING

Before cementing the part, it is advisable to fit the wing and the bonnet provisionally in order to mark the correct position for the front wing upper mounting support.

II - REFITTING OPERATION FOR PART CONCERNED

- Refit:
 - the front wing upper mounting support,
 - the support mounting bolts (2) .
- Tighten to torque the **front wing upper mounting support bolts (6.5 Nm)** .

III - FINAL OPERATION

- Refit:
 - the bonnet,
 - the bonnet mounting bolts (1) ,
 - the front wing (see **42A, Upper front structure, Front wing: Removal - Refitting, page 42A-11**) ,

- the headlight((see **Halogen headlight: Removal - Refitting**) ,
- the front bumper((see **Front bumper: Removal - Refitting**) ,
- the front wheel arch liner((see **Front wheel arch liner: Removal - Refitting**) .

B84 or C84

WARNING

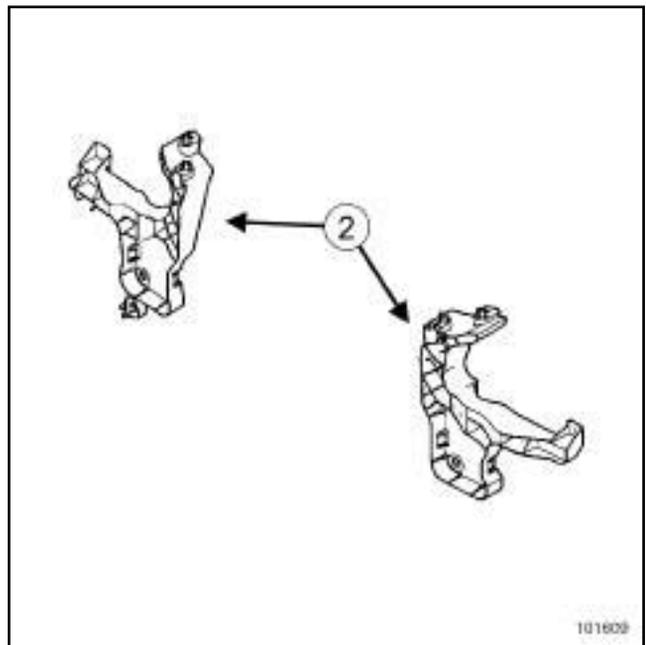
The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the part.

DESIGN OF THE STRUCTURAL COMPONENT



101610



101609

101609

A special feature of this type of component is that it comprises an upper cross member (1) made from steel and composite material and two side sections (2) made from a composite material, which cannot be repaired and which are bolted on the vehicle.

This part is attached to the ends of the front side members and cannot be adjusted.

UPPER FRONT STRUCTURE

Front: Removal - Refitting

42A

B84 or C84

Tightening torques 	
front end panel side section mounting bolts	6.5 Nm
front end panel upper cross member mounting bolt	21 Nm

The side sections are removable structural components made of SMC type composite material.

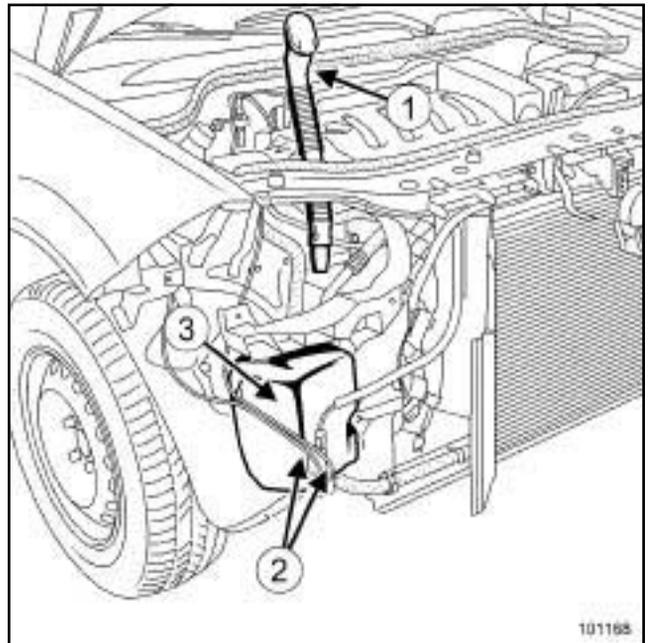
The upper cross member is a component made up of two sections (steel and SMC) which are pressed together.

REMOVAL

I - REMOVAL PREPARATION OPERATION FOR SIDE SECTION

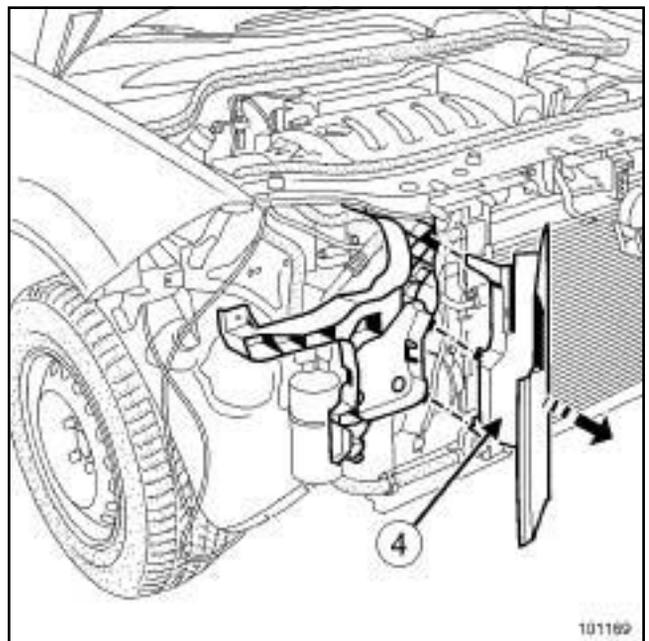
Remove:

- the front wheel arch liners (see **Front wheel arch liner: Removal - Refitting**) ,
- the front bumper (see **Front bumper: Removal - Refitting**) ,
- the front headlights (see **Halogen headlight: Removal - Refitting**) ,
- the front impact cross member (see **41A, Front lower structure, Front impact cross member: Removal - Refitting**, page 41A-8) .



101168

- Pull out the filling pipe (1) .
- Disconnect the pump pipes (2) and detach the reservoir (3) by pulling it strongly towards the front of the vehicle.
- Drain the reservoir if necessary.



101169

- Unclip the radiator air deflector (4) .

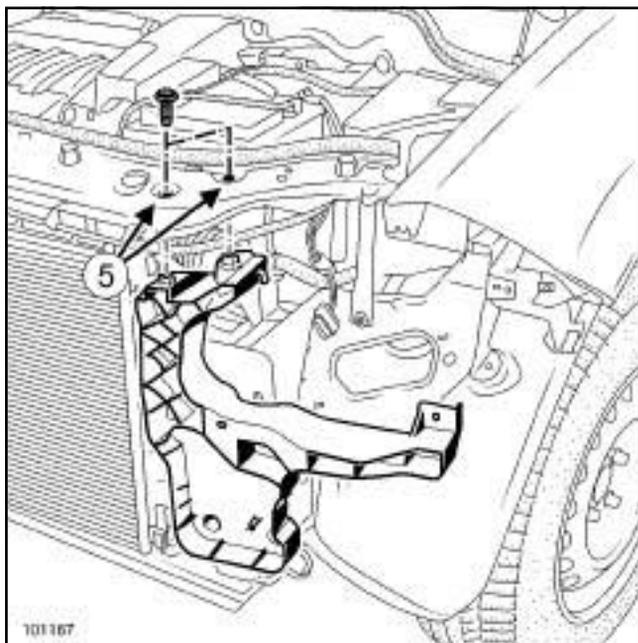
UPPER FRONT STRUCTURE

Front: Removal - Refitting

42A

B84 or C84

II - OPERATION FOR REMOVAL OF SIDE SECTION



101167

❑ Remove:

- the mounting bolts (5) from the side section,
- the side sections from the front end panel.

REFITTING

I - REFITTING OPERATION FOR SIDE SECTION

❑ Refit:

- the side sections to the front end panel.
- the side section mounting bolts (5).

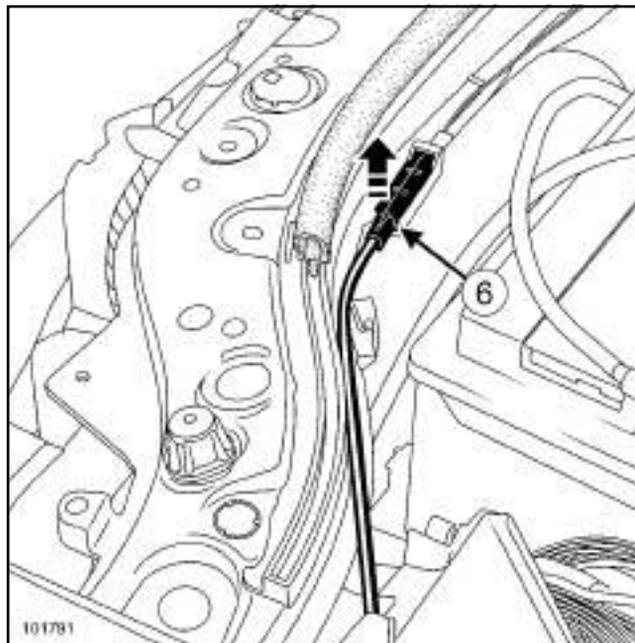
- #### ❑ Tighten to torque the front end panel side section mounting bolts (6.5 Nm).

II - FINAL OPERATION

- ❑ Clip the radiator air deflector (4) into place.
- ❑ Refit the reservoir (3).
- ❑ Connect the pipes (2) to the washer fluid pump.
- ❑ Refit the filler pipe (1).
- ❑ Fill the washer fluid reservoir.

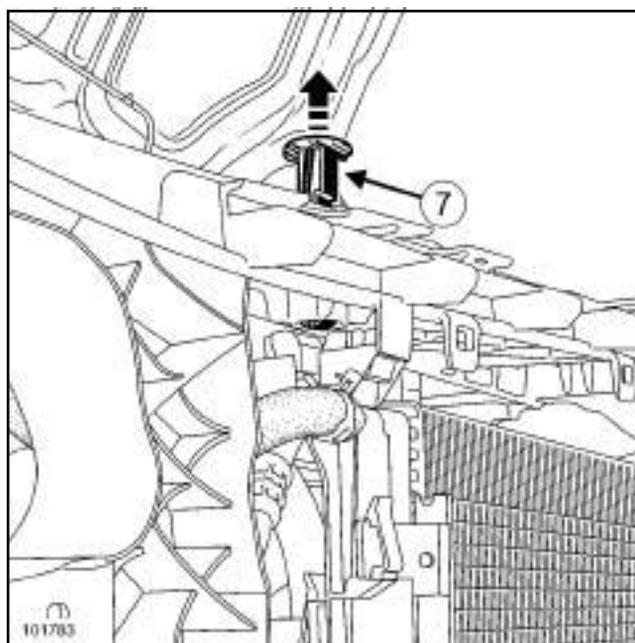
REMOVAL

I - REMOVAL PREPARATION OPERATION FOR THE UPPER CROSS MEMBER



101791

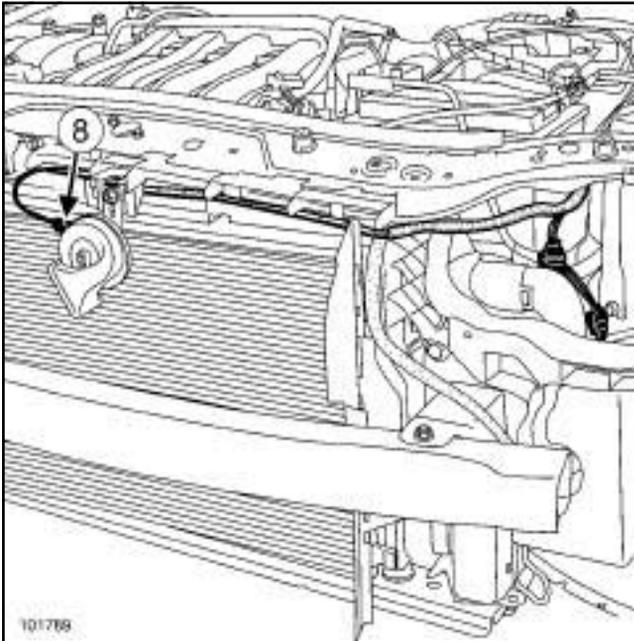
- #### ❑ Unclip the upper section (6) of the plastic union and detach the bonnet opening cable.



101783

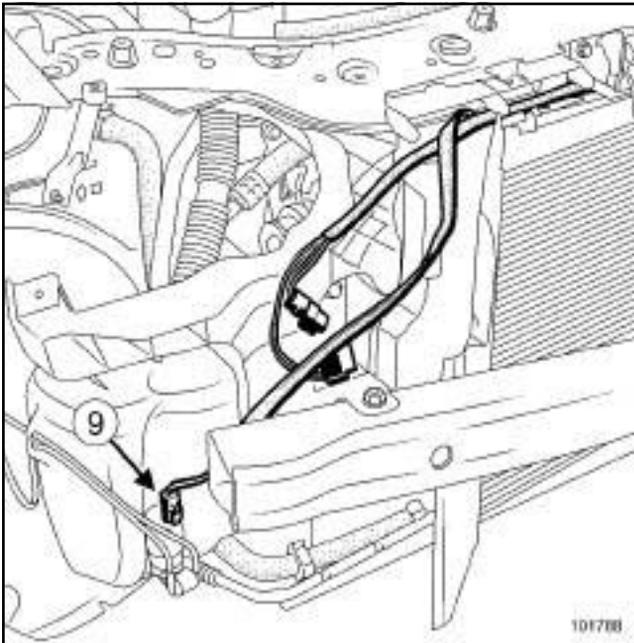
- #### ❑ Using a screwdriver, unclip the radiator indexing pins (7).

B84 or C84



101789

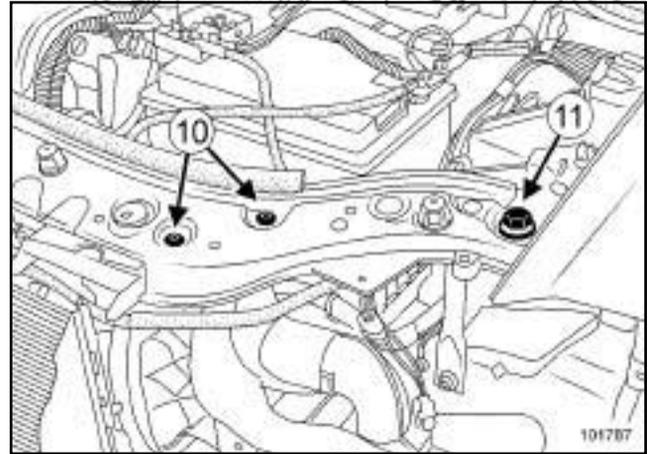
- Disconnect the audible warning connector (8) .



101788

- Disconnect the washer fluid pump connector (9) .
- Detach the wiring harness from the upper cross member.

II - OPERATION FOR REMOVAL OF THE UPPER CROSS MEMBER



101787

- Remove:

- the mounting bolts (10) from the side sections,
- the mounting bolt (11) from the upper cross member,
- the upper cross member.

REFITTING

I - REFITTING OPERATION FOR THE UPPER CROSS MEMBER

- Refit:

- the upper cross member,
- the mounting bolt (11) to the upper cross member,
- the side section mounting bolts (10) .

- Tighten to torque:

- the front end panel upper cross member mounting bolt (21 Nm) ,
- the front end panel side section mounting bolts (6.5 Nm) .

II - FINAL OPERATION

- Refit the wiring harness on the upper cross member.

- Connect:

- the connector (9) to the washer fluid pump,
- the audible warning connector (8) .

- Clip the radiator indexing pins (7) into place.

- Refit the bonnet opening cable to the upper cross member.

UPPER FRONT STRUCTURE

Scuttle side panel: General description

42A

B84 or C84

WARNING

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the part.

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information**.

I - DESIGN OF THE STRUCTURAL COMPONENT

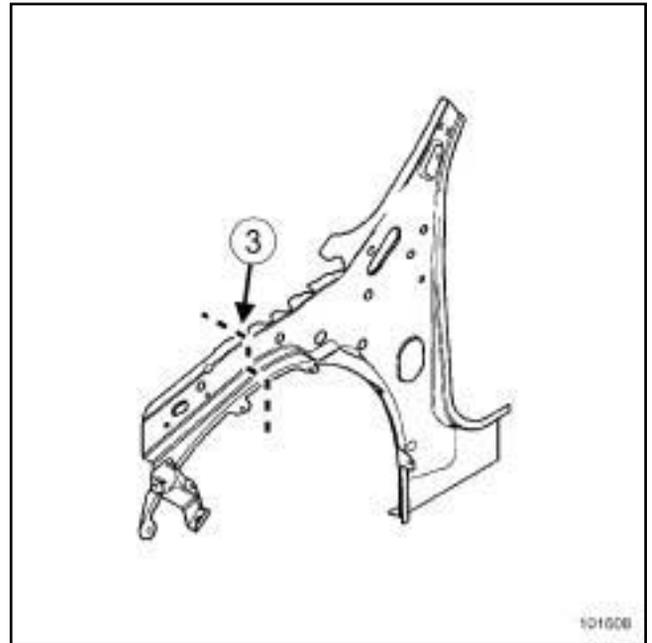


115794

The distinctive feature of this part is that it combines two functions:

- scuttle side panel.
- A-pillar lining.

II - AREA TO BE CUT FOR PARTIAL REPLACEMENT



101608

Cut line (3) marks the area in which it is possible to make a cut.

III - ASSEMBLY INSTRUCTIONS FOR A PARTIAL REPLACEMENT

Only the connecting pieces relevant to partial replacement by cutting are shown.

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

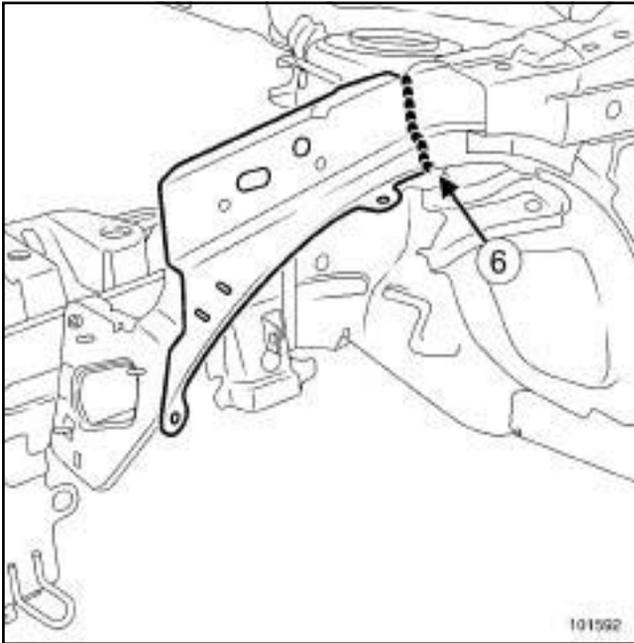
If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400, 40A, General Information**).

UPPER FRONT STRUCTURE

Scuttle side panel: General description

42A

B84 or C84



101592

Line (6) in the drawing marks the partial replacement and a MAG butt weld.

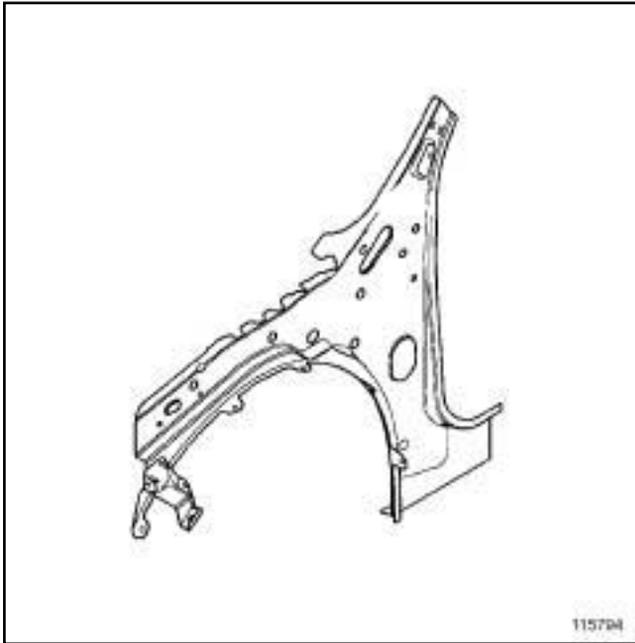
Depending on the exact position of the cut, a weld made by joggling with plug welds at regular intervals may also be used.

UPPER FRONT STRUCTURE

Cowl side panel: Description

42A

B84 or C84

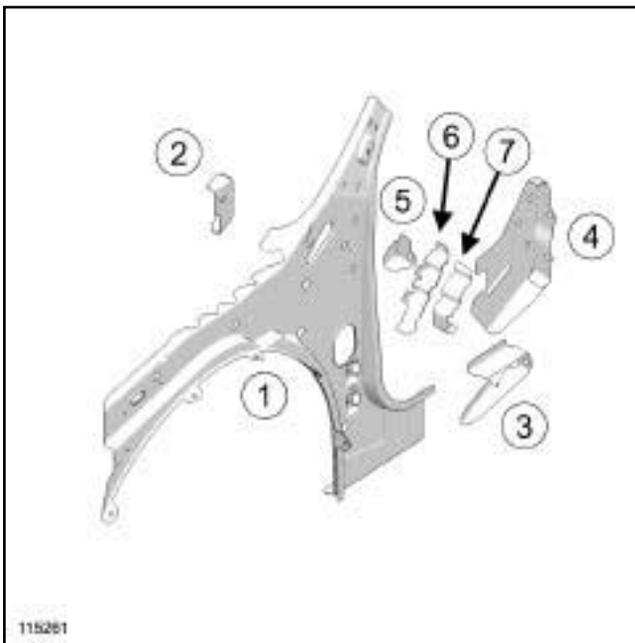


115794

The options for replacing this part are as follows:

- partial replacement of front end section,
- partial replacement of the front section,
- partial replacement of the rear section,
- complete replacement.

I - COMPOSITION OF THE SPARE PART

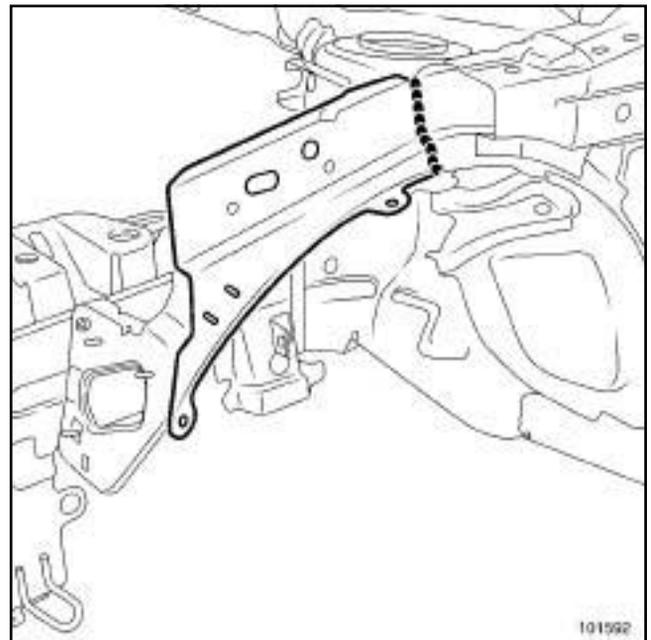


115261

Number	Description	Type	Thickness (mm)
(1)	A-pillar lining	HEL	1
(2)	Dashboard reinforcement bracket	VHEL	2.5
(3)	Dashboard mounting unit reinforcement	VHEL	2
(4)	Dashboard mounting unit	HEL	1.7
(5)	Driver's position mounting bracket	-	1.5
(6)	Dashboard cross member mounting upper spacer	VHEL	2.5
(7)	Dashboard cross member mounting lower spacer	VHEL	2.5

II - PART FITTED

1 - Partial replacement of the front end section



101592

UPPER FRONT STRUCTURE

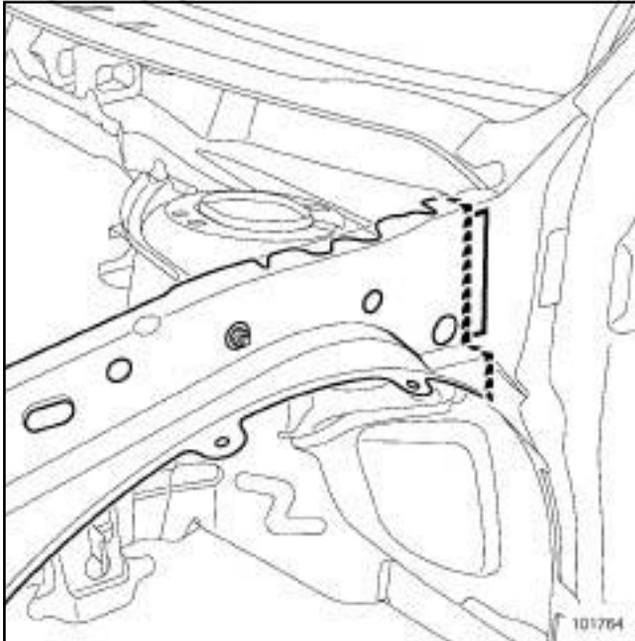
Cowl side panel: Description

42A

B84 or C84

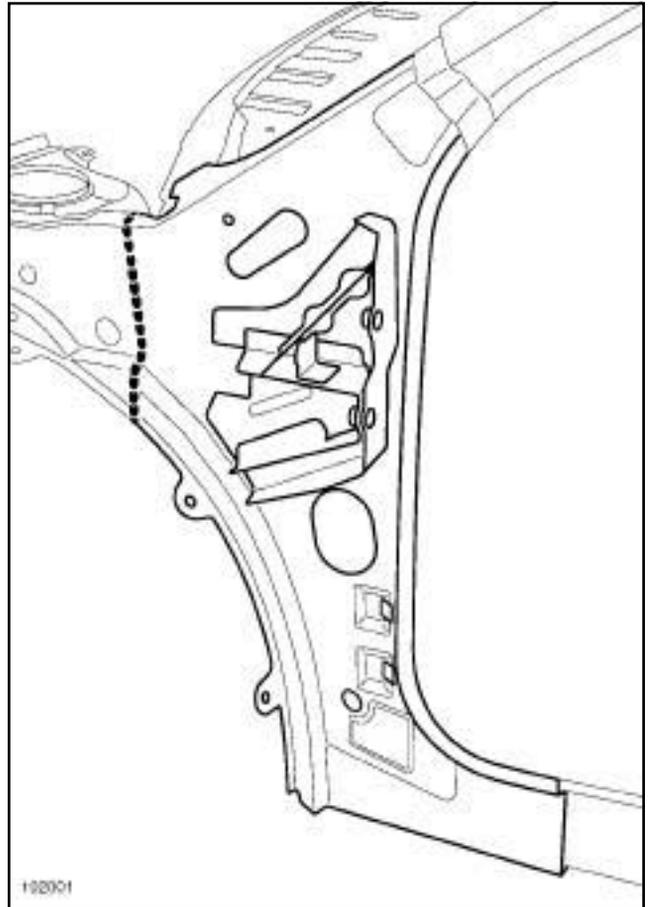
The partial replacement of the front end section is linked to the partial replacement of the upper reinforcement on the scuttle side panel.

2 - Partial replacement of the front section



101764

3 - Partial replacement of the rear section



102001

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, they should be replaced with plug welds after holes have been drilled in the first panel.

4 - Complete replacement

Note:

The complete replacement of the scuttle side panel supplements the replacement of the A-pillar reinforcement.

IMPORTANT

For welded connections in three thicknesses, the spot welds on the part replaced should be made in the same place as for the original joint to retain its mechanical properties.

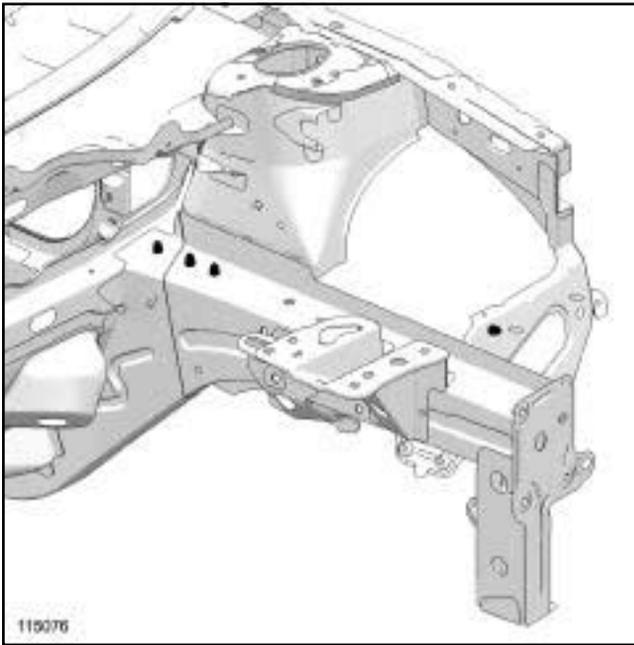
UPPER FRONT STRUCTURE

Cowl side panel: Description

42A

B84 or C84

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



115076

IMPORTANT

To avoid damaging the vehicle's electric and electronic components, the battery and the earths of any wiring harness near the weld area must be disconnected.

The earth of the welding machine must be placed as close as possible to the weld area.

B84 or C84

WARNING

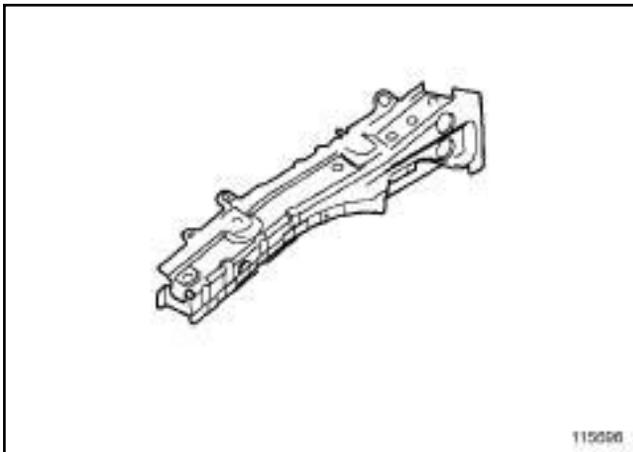
The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the part.

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information**.

DESIGN OF THE STRUCTURAL COMPONENT



115696

This type of part fixes the bonnet hinge mounting and the front wing upper mounting support.

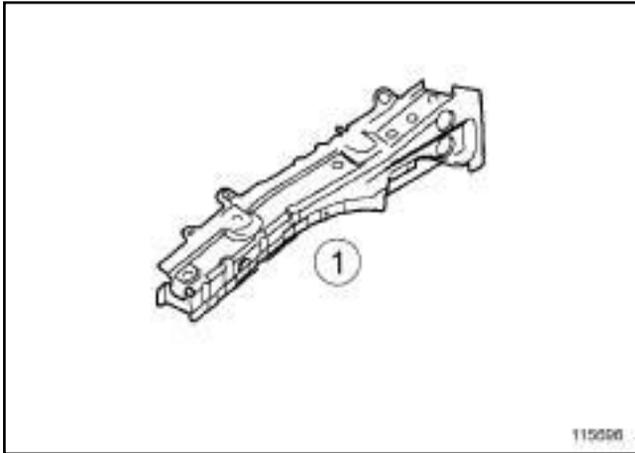
Scuttle side panel upper reinforcement: Description

B84 or C84

The options for replacing this part are as follows:

- partial replacement of the front section,
- complete replacement.

I - COMPOSITION OF THE SPARE PART

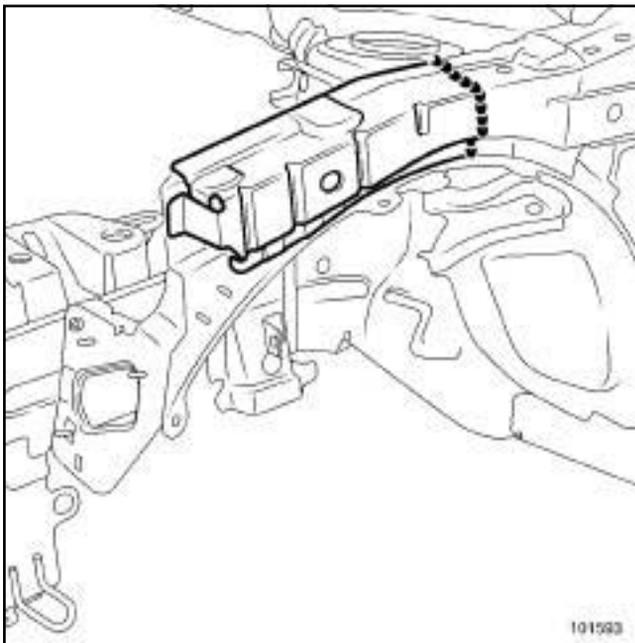


115060
115696

Number	Description	Type	Thickness (mm)
(1)	Scuttle side panel upper reinforcement	-	0.9

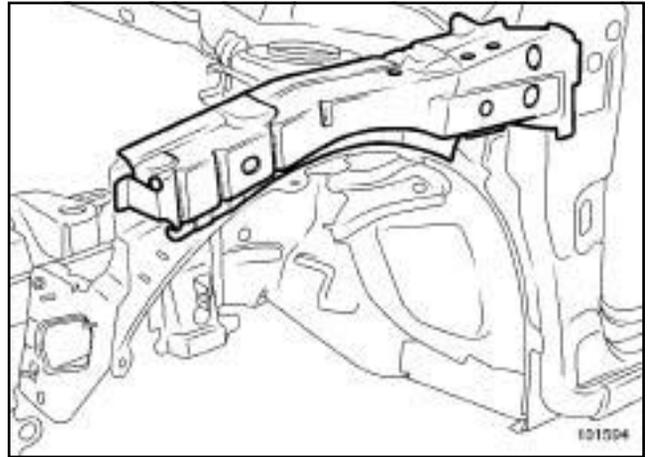
II - PART FITTED

1 - Partial replacement of the front section



101593
101593

2 - Complete replacement

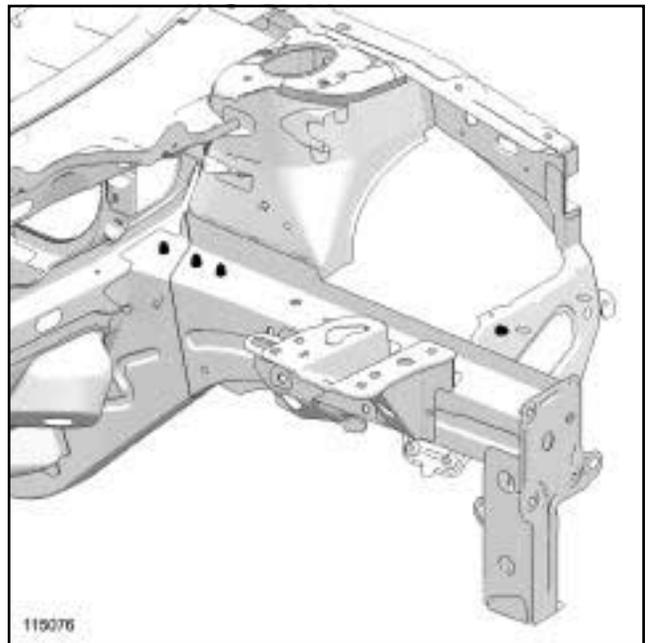


101594

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, they should be replaced with plug welds after holes have been drilled in the first panel.

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



115076
115076

Scuttle side panel upper reinforcement: Description

B84 or C84

IMPORTANT

To avoid damaging the vehicle's electric and electronic components, the battery and the earths of any wiring harness near the weld area must be disconnected.

The earth of the welding machine must be placed as close as possible to the weld area.

UPPER FRONT STRUCTURE

Front wheel arch: General description

42A

B84 or C84

WARNING

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

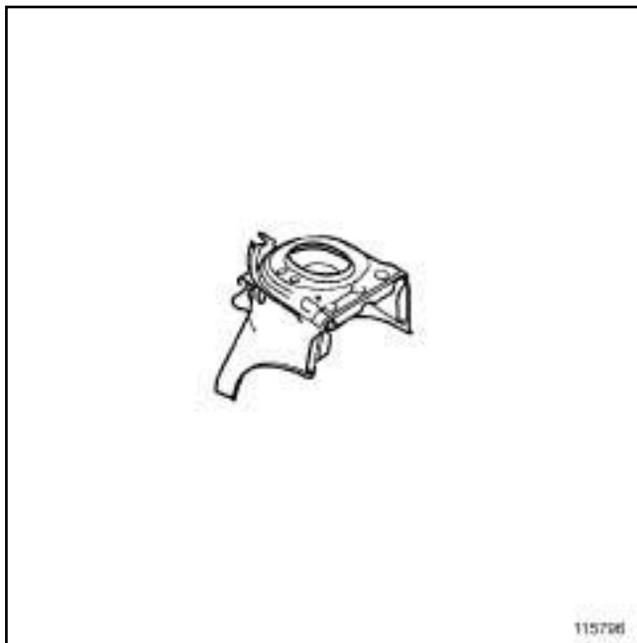
IMPORTANT

The straightening bench must be used.

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information**.

DESIGN OF THE STRUCTURAL COMPONENT



115796

This is a basic part; it only fulfils the function of a front wheel arch.

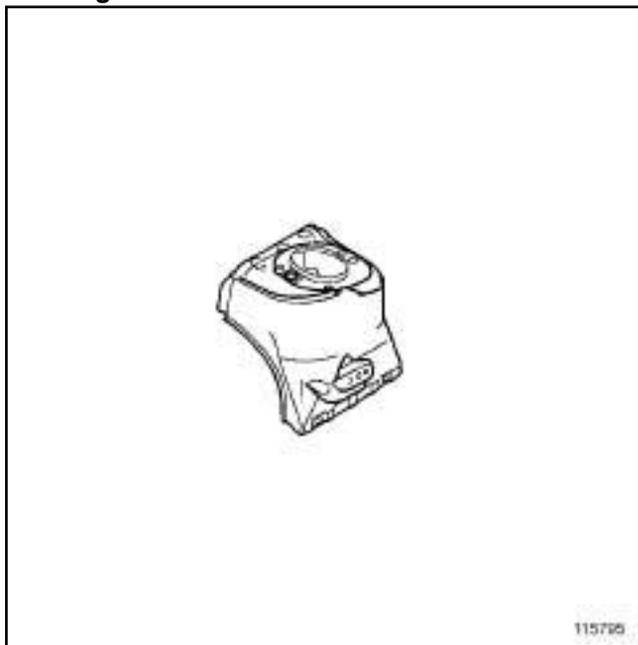
UPPER FRONT STRUCTURE

Front wheel arch: Description

42A

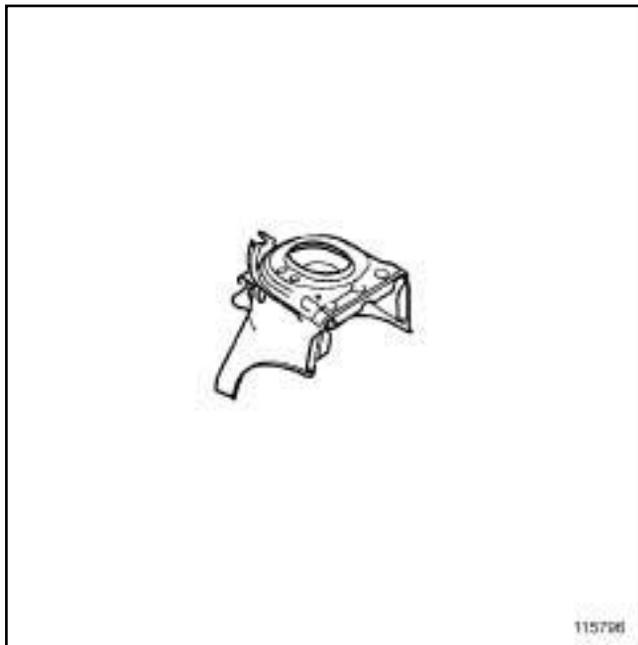
B84 or C84

Front right-hand wheel arch



115795

Front left-hand wheel arch



115796

There is only one way of replacing this part:

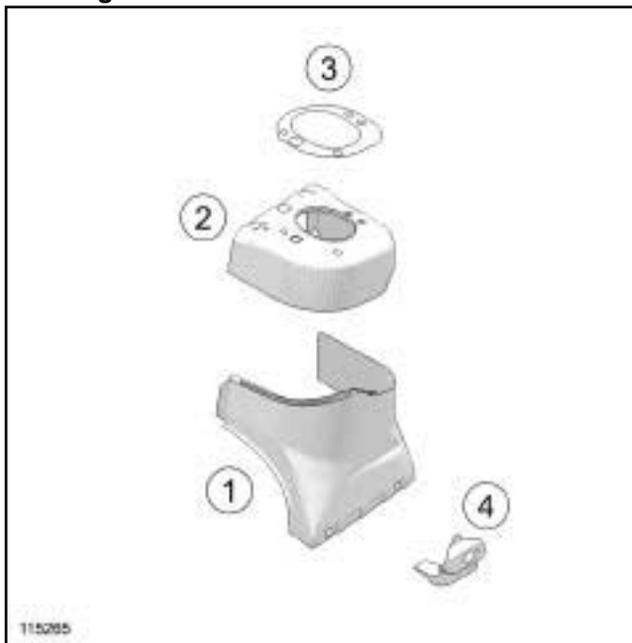
- complete replacement: this operation supplements the replacement of the scuttle side panel for a side impact or the front side member for a frontal impact.

Note:

The body jig bench must be used.

I - COMPOSITION OF THE SPARE PART

Front right-hand wheel arch



115265

Mark	Description	Type	Thickness (mm)
(1)	Shock absorber cup height adjuster	-	1.1
(2)	Shock absorber cup	HLE	2
(3)	Cup reinforcement	-	2
(4)	Engine support connection reinforcement	-	2

UPPER FRONT STRUCTURE

Front wheel arch: Description

42A

B84 or C84

Front left-hand wheel arch

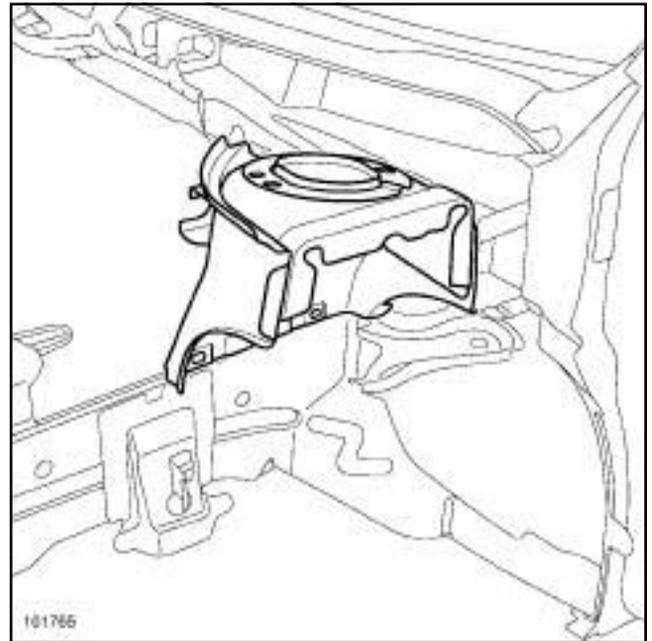


115264

Mark	Description	Type	Thickness (mm)
(5)	Shock absorber cup height adjuster	-	1.1
(6)	Shock absorber cup	HLE	2
(7)	Air filter mounting support	-	1.2

II - PART FITTED

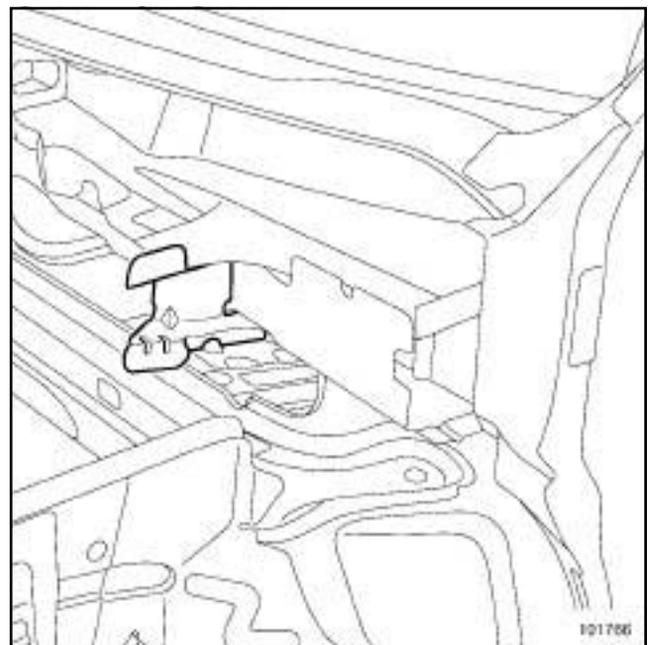
Complete replacement



101765

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.



101766

Do not detach the windscreen aperture lower cross member side bracket to replace the front wheel arch.

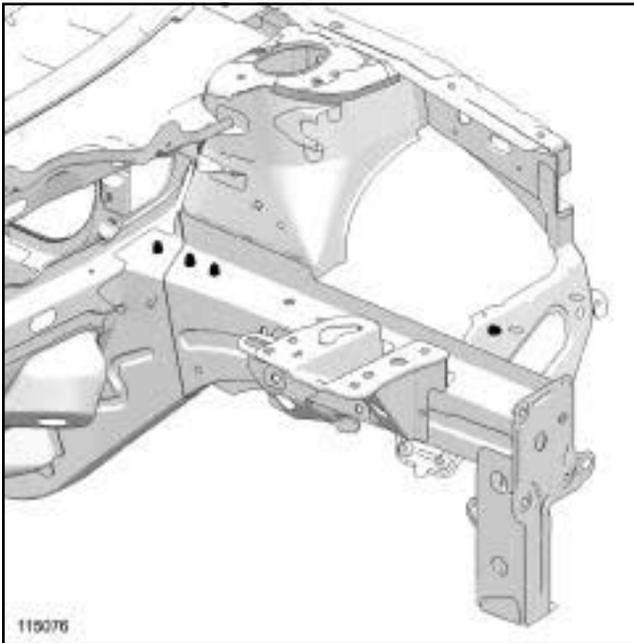
UPPER FRONT STRUCTURE

Front wheel arch: Description

42A

B84 or C84

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



115076

IMPORTANT

To avoid damaging the vehicle's electric and electronic components, the battery and the earths of any wiring harness near the weld area must be disconnected.

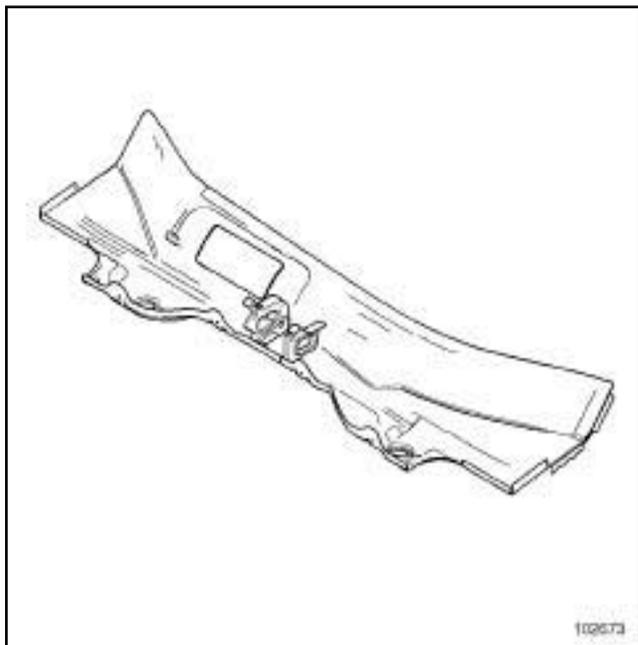
The earth of the welding machine must be placed as close as possible to the weld area.

UPPER FRONT STRUCTURE

Heater bulkhead: Description

42A

B84 or C84

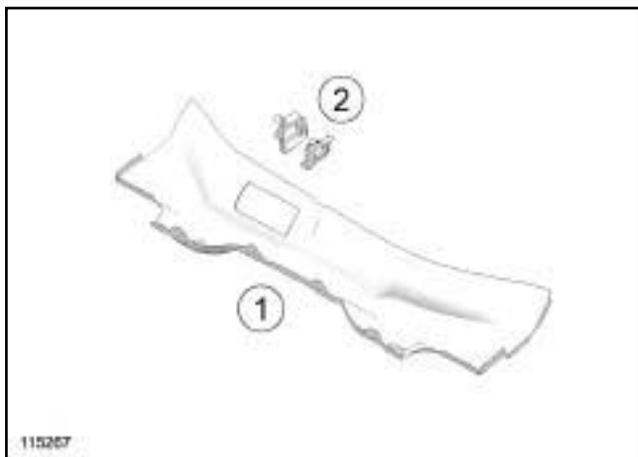


102673

There is only one way of replacing this part:

- complete replacement: this operation supplements the replacement of the front wheel arch or the windscreen aperture lower cross member for a side impact.

I - COMPOSITION OF THE SPARE PART

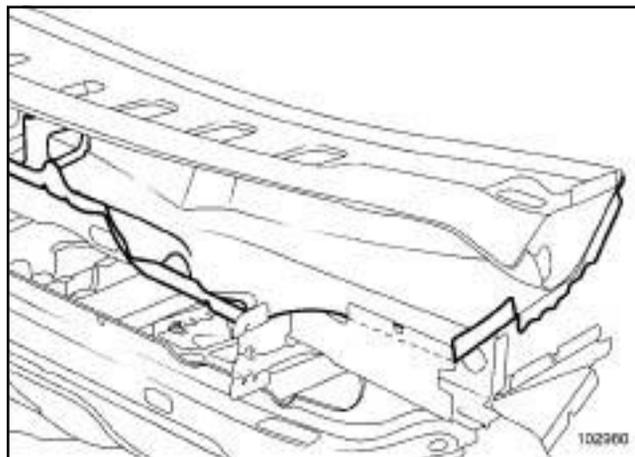


115267

Mark	Description	Type	Thickness (mm)
(1)	Heater bulkhead	-	0.7
(2)	Heater bulkhead brackets	-	1.2

II - PART FITTED

Complete replacement

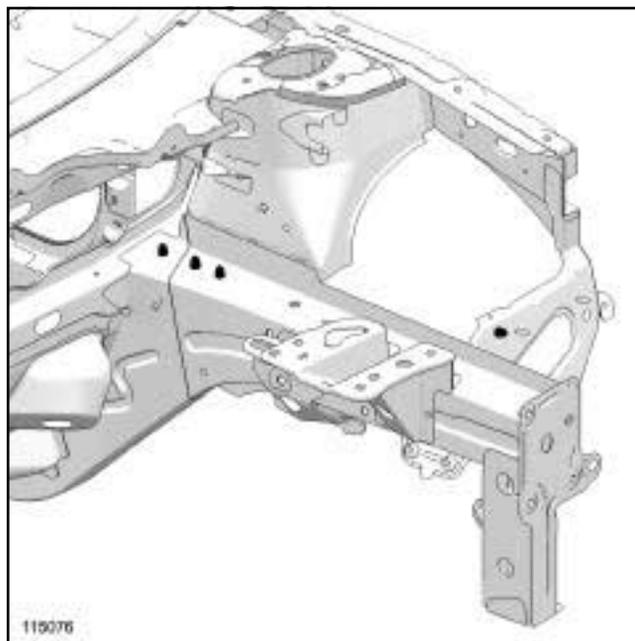


102980

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



115076

UPPER FRONT STRUCTURE

Heater bulkhead: Description

42A

B84 or C84

IMPORTANT

To avoid damaging the vehicle's electric and electronic components, the battery and the earths of any wiring harness near the weld area must be disconnected.

The earth of the welding machine must be placed as close as possible to the weld area.

B84 or C84

WARNING

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information**.

DESIGN OF THE STRUCTURAL COMPONENT



102674

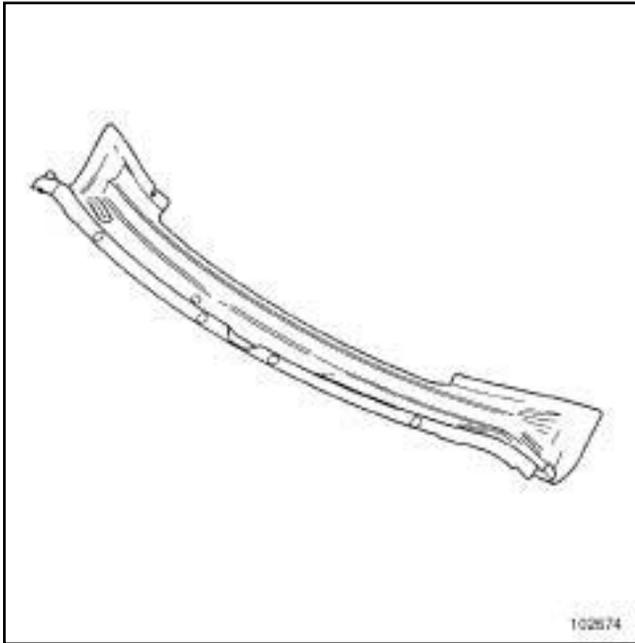
This is a basic part; it only fulfils the function of windscreen aperture lower cross member.

UPPER FRONT STRUCTURE

Windscreen aperture lower cross member: Description

42A

B84 or C84

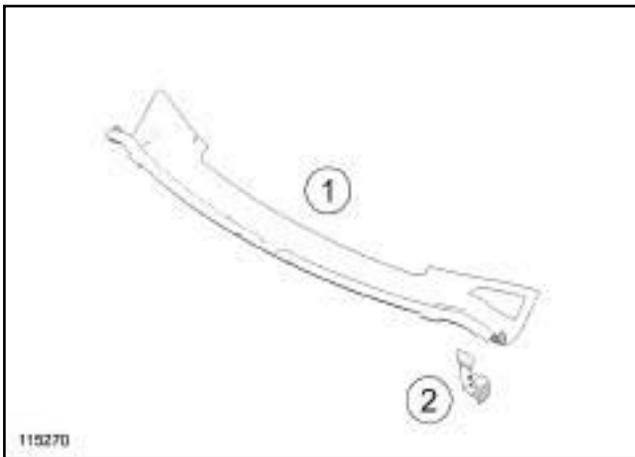


102674
102674

There is only one way of replacing this part:

- complete replacement: this operation supplements the replacement of the windscreen aperture lower cross member closure panel.

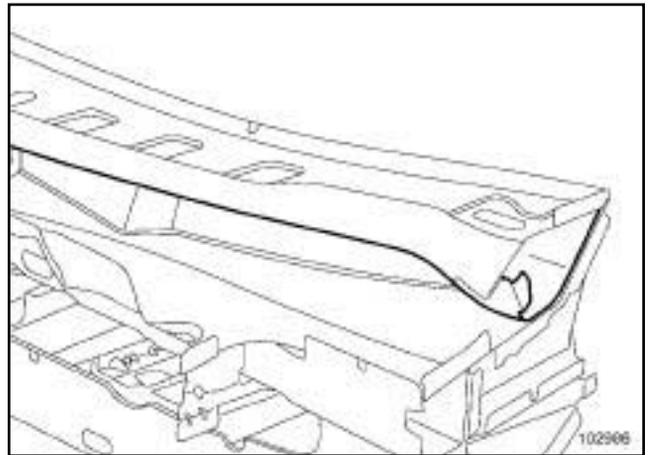
I - COMPOSITION OF THE SPARE PART



115270
115270

Mark	Description	Type	Thic- kness (mm)
(1)	Windscreen aperture lower cross member	-	0.7
(2)	Wiper mounting reinforcement	-	1.2

II - PART FITTED



102986
102986

IMPORTANT

For the weld joints in three thicknesses, the spot welds on the part replaced should be executed in the same place as the originals to retain the mechanical properties of the joint.

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

B84 or C84

Special tooling required

Car. 1765

Dashboard beam play compensation pin repositioning bolts

Tightening torques

centring device (6)	8 Nm
mounting bolt (5)	21 Nm
side mounting bolts (4)	21 Nm
mounting bolts (2)	8 Nm

Note:

In the event of a front impact with triggering of air-bags, check the area of connection between both diameters of the beam. If there is any damage visible to the naked eye, this part must be replaced.

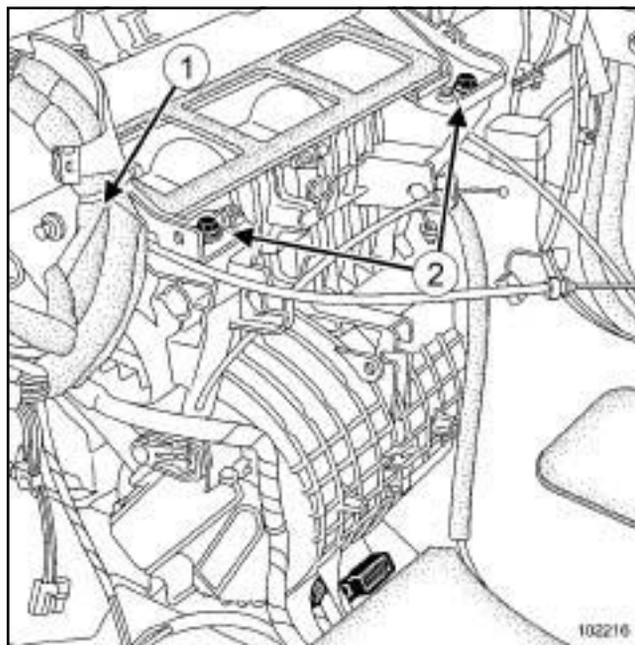
REMOVAL

I - REMOVAL PREPARATION OPERATION

Remove:

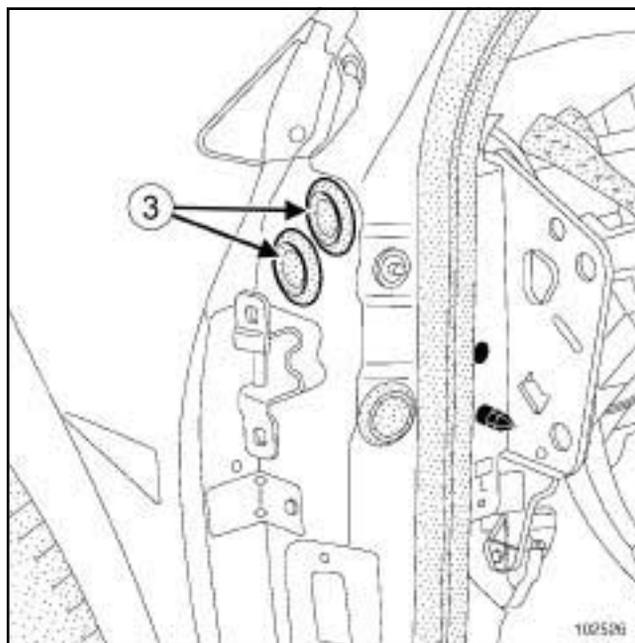
- the front doors (see **47A, Side opening elements, Front side door: Removal - Refitting**, page **47A-5**),
- the dashboard (see **Dashboard: Removal - Refitting**),
- the steering column (see **Steering column: Removal - Refitting**).

II - OPERATION FOR REMOVAL OF PART CONCERNED



102216

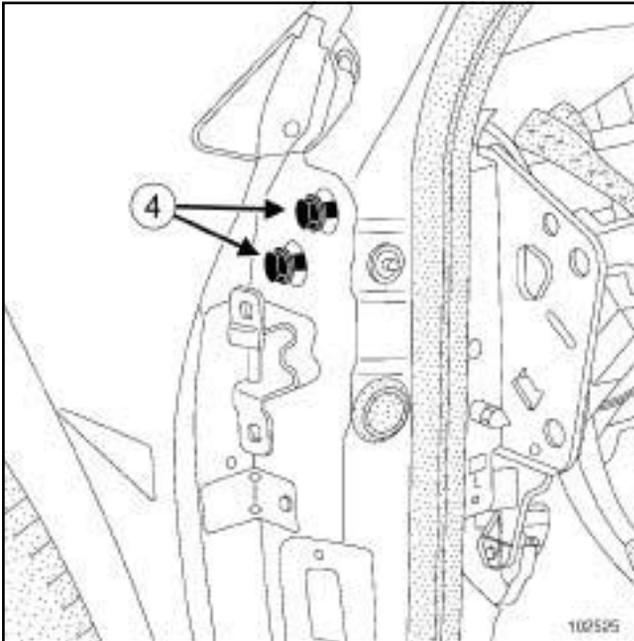
- Unclip the wiring harness (1).
- Remove the mounting bolts (2).



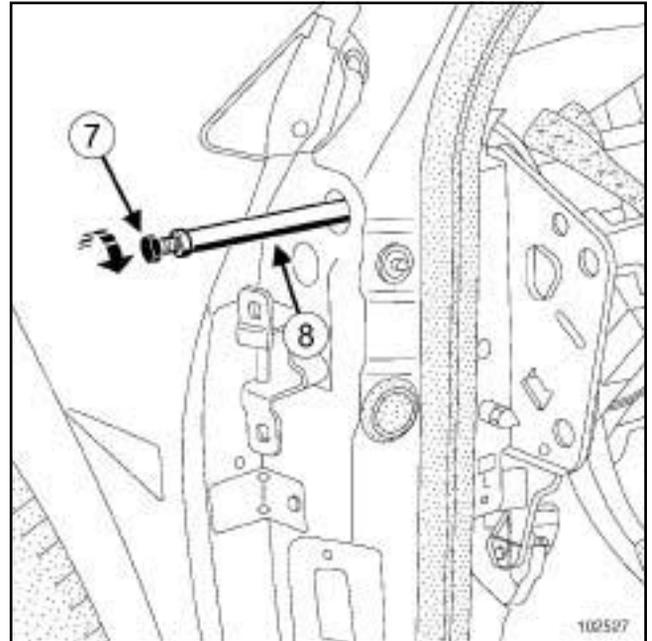
102526

- Remove the blanking covers (3).

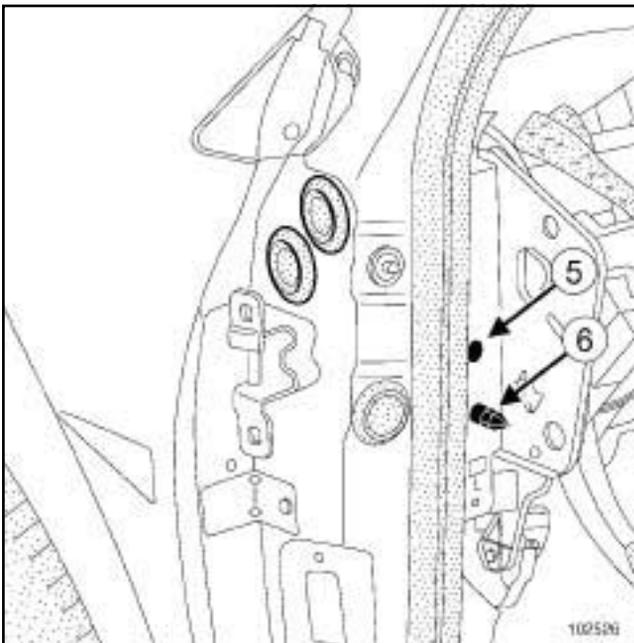
B84 or C84



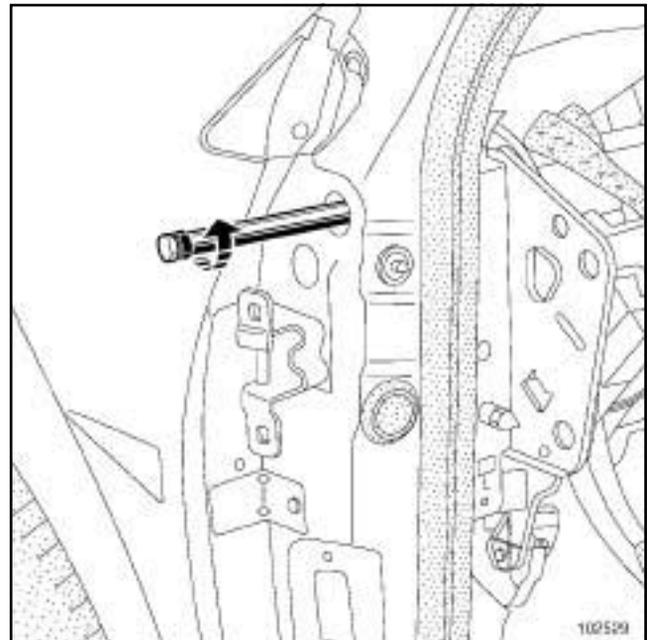
- ❑ Remove the side mounting bolts (4) .



- ❑ Fit the **(Car. 1765)** onto body (8) as far as the stop.
- ❑ Screw the rod (7) fully into the body (8) and tighten gently.
- ❑ Firmly lock the tool body (8) against the dashboard cross member nut in the same way as a lock nut, while holding the hexagon bolt (7) .

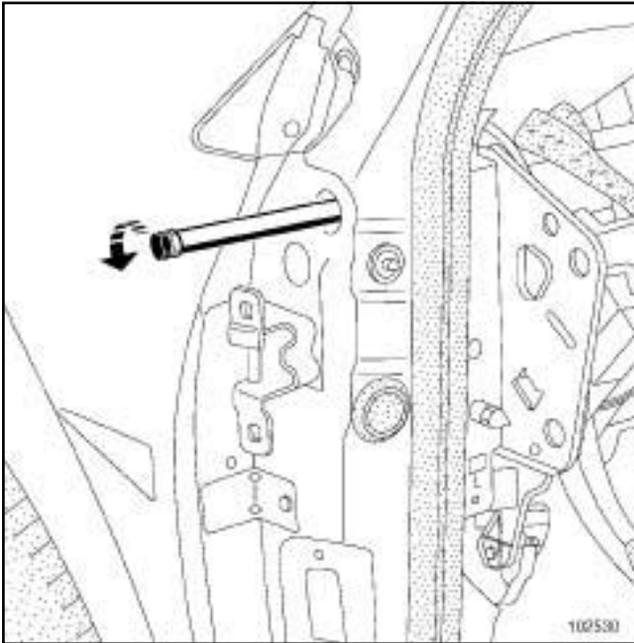


- ❑ Remove the mounting bolt (5) .
- ❑ Loosen the centring device (6) in order to align the holes in the A-pillar lining with the dashboard cross member lock nuts.



- ❑ Unscrew the tool as far as the stop using the hexagon bolt (8) and tighten it gently (during the operation, the beam nut, which has a left-hand thread, screws into the beam and releases it from the A-pillar).

B84 or C84



102530

- Hold tool body **(8)** and unlock rod **(7)**.
- Unscrew dashboard cross member rod **(7)** to remove the tool.
- Remove:
 - the side mounting bolts **(4)** from the other side of the vehicle,
 - the dashboard cross member.

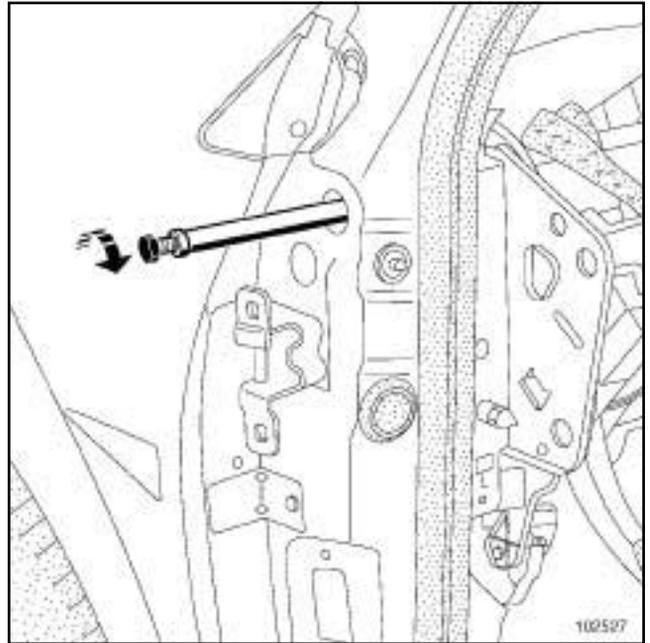
Note:

To maintain the adjustment of the dashboard cross member and therefore make refitting easier, only loosen the lock nut on one side

REFITTING

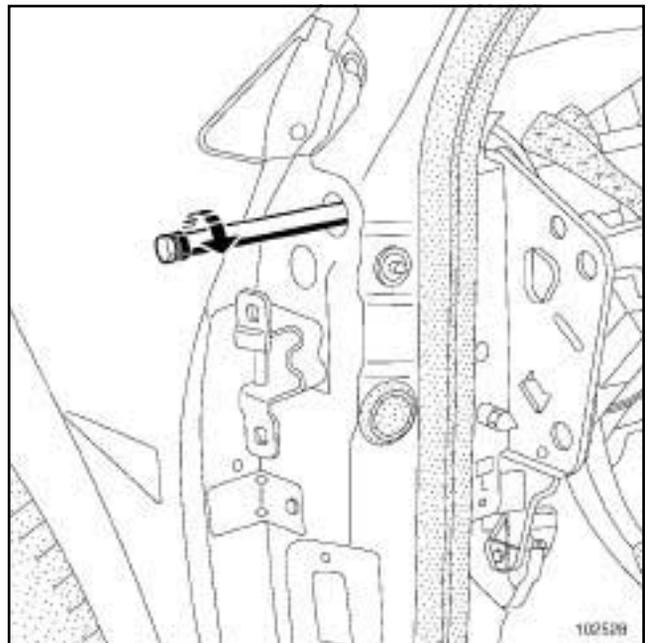
I - REFITTING OPERATION FOR PART CONCERNED

- Fully tighten the locking nut (left-hand thread) in the beam.
- Refit:
 - the dashboard cross member,
 - the side mounting bolts **(4)** on the side on which the lock nut has not been loosened.



102527

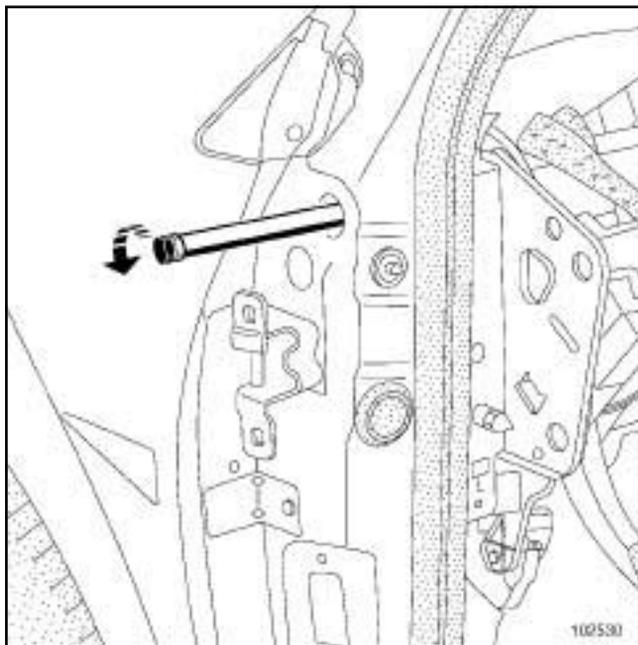
- Fit the **(Car. 1765)** onto body **(8)** as far as the stop.
- Screw the rod **(7)** fully into the body **(8)** and tighten gently.
- Firmly lock tool body in the same way as a lock nut against the dashboard cross member nut while holding the hexagon bolt.



102528

- Simultaneously screw the rod **(7)** and the tool body **(8)** fully, tightening gently.

B84 or C84



102530

- Hold the tool body (8) and release the rod (7) in the same way as a lock nut.
- Unscrew dashboard cross member rod to remove the tool.

WARNING

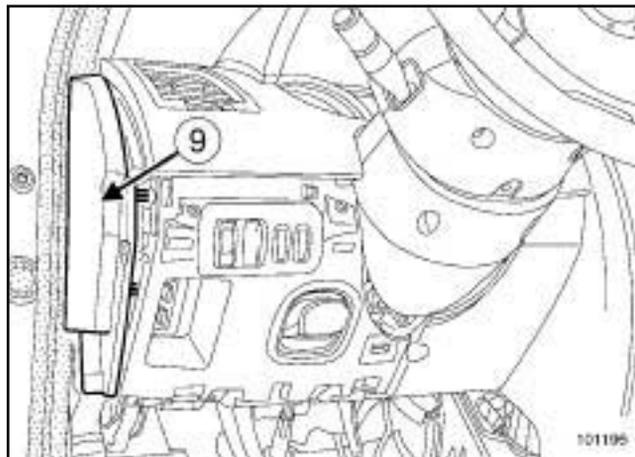
During removal of the dashboard cross member, the lock nuts may loosen on both sides. If this happens, refit the dashboard to adjust its clearances with the windscreen pillar and door trims.

- Tighten to torque the centring device (6) (8 Nm) .
- Refit:
 - the mounting bolt (5) ,
 - the side mounting bolts (4) .
- Tighten to torque:
 - the mounting bolt (5) (21 Nm) ,
 - the side mounting bolts (4) (21 Nm) .
- Refit the blanking covers (3) .
- Refit the mounting bolts (2) .
- Tighten to torque the mounting bolts (2) (8 Nm) .
- Clip the wiring harness (1) .

II - FINAL OPERATION

- Refit:
 - the steering column(see **Steering column: Removal - Refitting**) ,

- the dashboard(see **Dashboard: Removal - Refitting**) ,
- the front doors (see **47A, Side opening elements, Front side door: Removal - Refitting**, page 47A-5) .



101196

- It is possible to adjust the dashboard after it has been refitted to the vehicle, by removing the dashboard side panel (9) to access the mounting bolt (5) and the dashboard cross member centring device (6) .

B84 or C84

WARNING

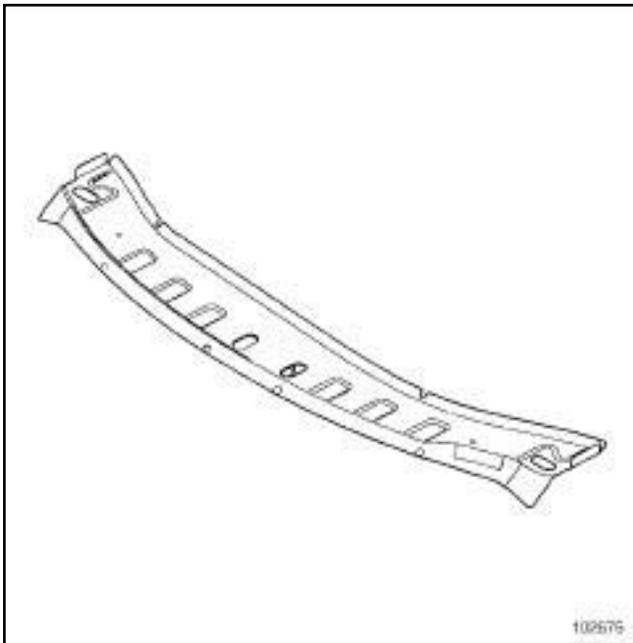
The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information**.

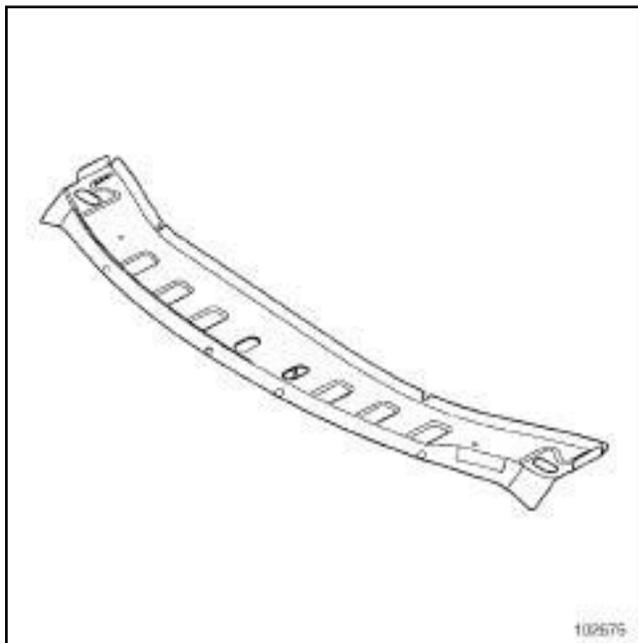
DESIGN OF THE STRUCTURAL COMPONENT



102675

This is a basic part; it only fulfils the function of the windscreen aperture lower cross member closure panel.

B84 or C84

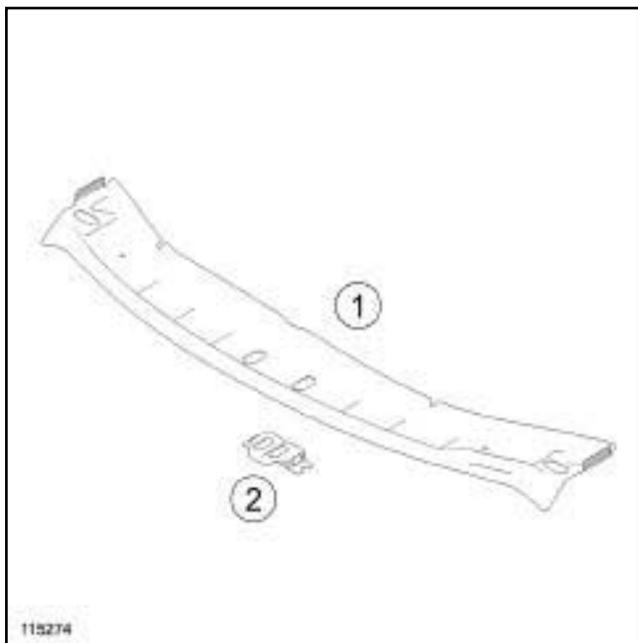


102675

There is only one way of replacing this part:

- Complete replacement: this operation supplements the replacement of the heater bulkhead for a side impact at the A-pillar.

I - COMPOSITION OF THE SPARE PART

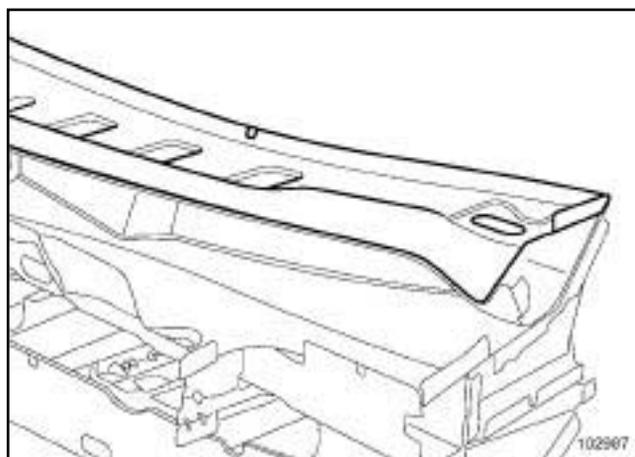


115274

Mark	Description	Type	Thickness (mm)
(1)	Windscreen aperture lower cross member closure panel	-	0.7
(2)	Windscreen aperture lower cross member centre reinforcement	-	1.2

II - PART FITTED

Complete replacement



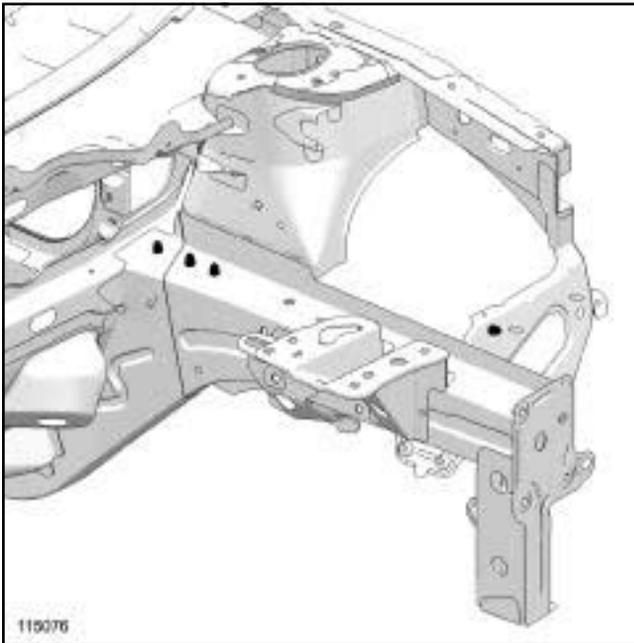
102987

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

B84 or C84

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



115076

IMPORTANT

To avoid damaging the vehicle's electric and electronic components, the battery and the earths of any wiring harness near the weld area must be disconnected.

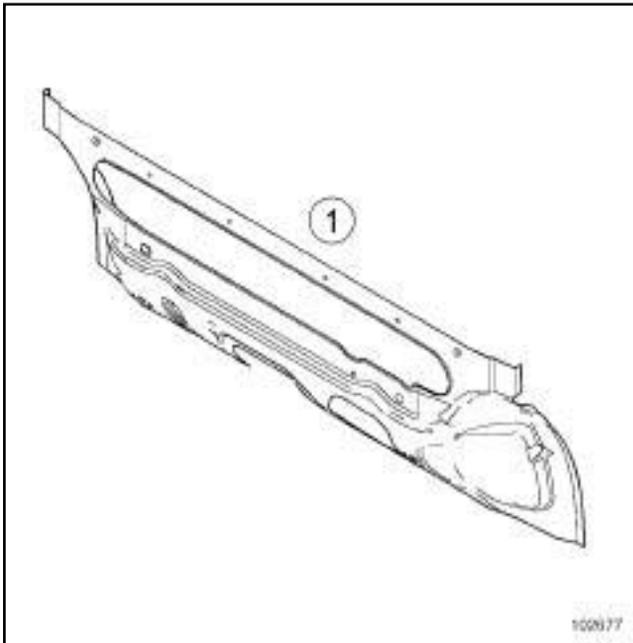
The earth of the welding machine must be placed as close as possible to the weld area.

B84 or C84

The options for replacing this part are as follows:

- partial replacement,
- Complete replacement: this operation supplements the replacement of the bulkhead side reinforcement and the bulkhead lower cross member.

I - COMPOSITION OF THE SPARE PART



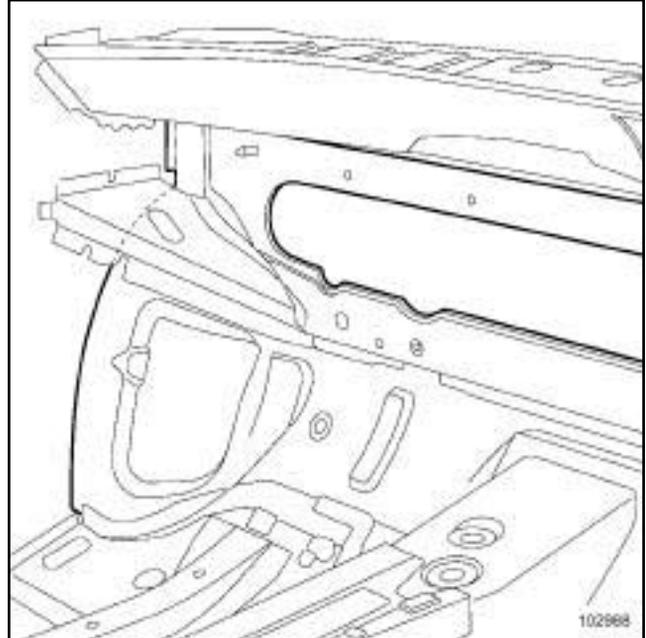
102677

Mark	Description	Type	Thic- kness (mm)
(1)	Bulkhead	-	1

II - PART FITTED

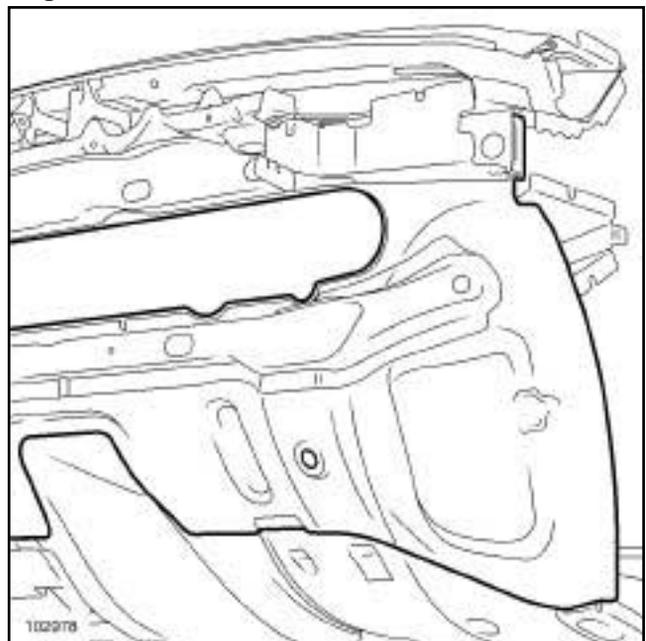
1 - Complete replacement

Passenger compartment side view



102988

Engine side view



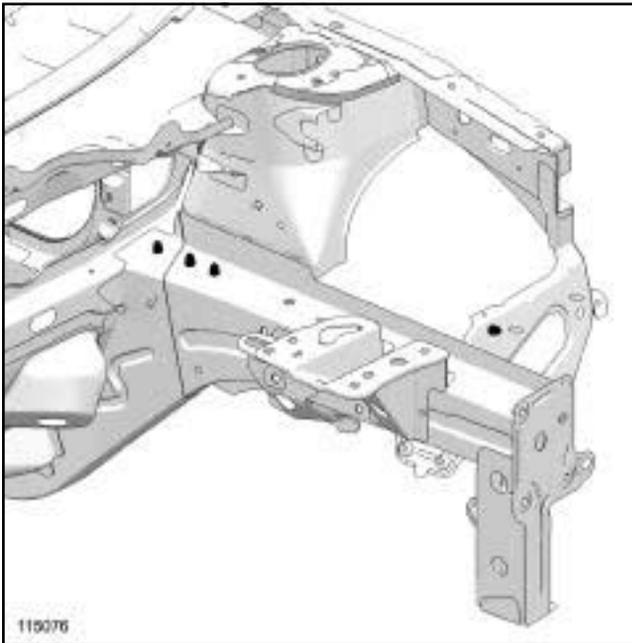
102978

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

B84 or C84

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



115076

IMPORTANT

To avoid damaging the vehicle's electric and electronic components, the battery and the earths of any wiring harness near the weld area must be disconnected.

The earth of the welding machine must be placed as close as possible to the weld area.

UPPER FRONT STRUCTURE

Bulkhead reinforcement: Description

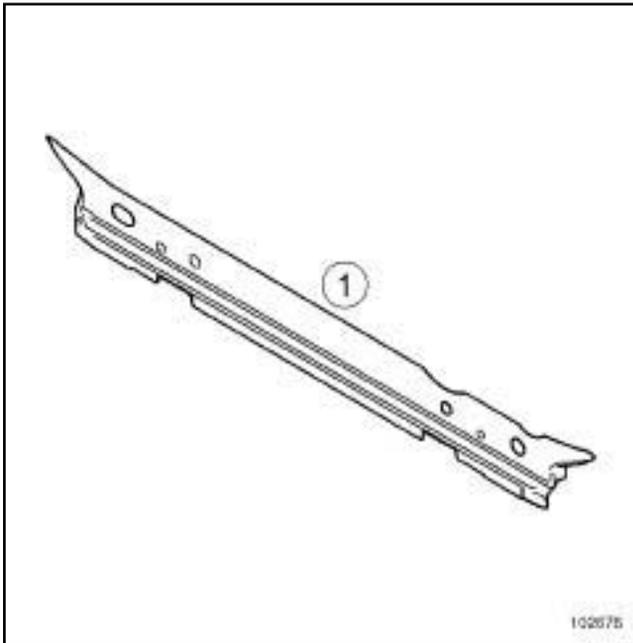
42A

B84 or C84

There is only one way of replacing this part:

- complete replacement.

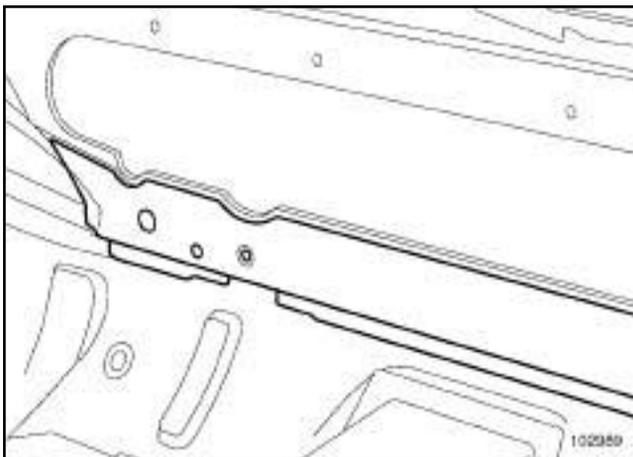
I - COMPOSITION OF THE SPARE PART



102676

Mark	Description	Type	Thickness (mm)
(1)	Bulkhead reinforcement	UHLE	1.7

II - PART FITTED

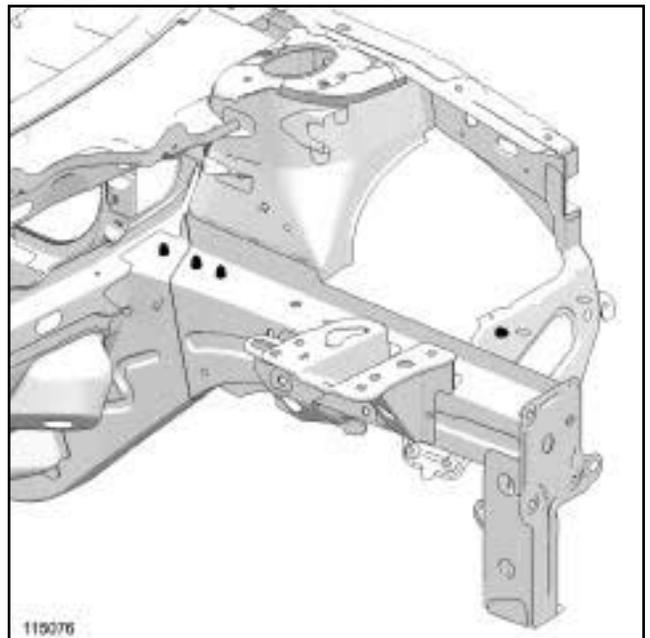


102989

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



115076

IMPORTANT

To avoid damaging the vehicle's electric and electronic components, the battery and the earths of any wiring harness near the weld area must be disconnected.

The earth of the welding machine must be placed as close as possible to the weld area.

Bulkhead lower cross member: General description

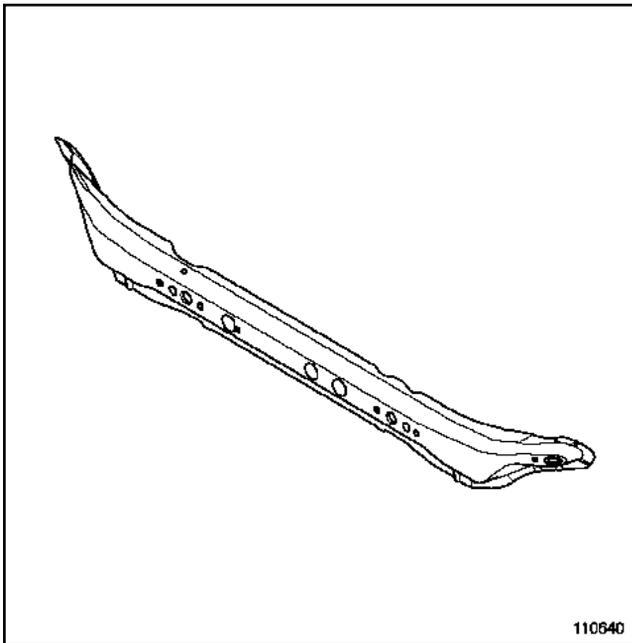
B84 or C84

WARNING

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information**.

DESIGN OF THE STRUCTURAL COMPONENT

110640

This is a basic part; it simply fulfils the function of a bulkhead cross member.

WARNING

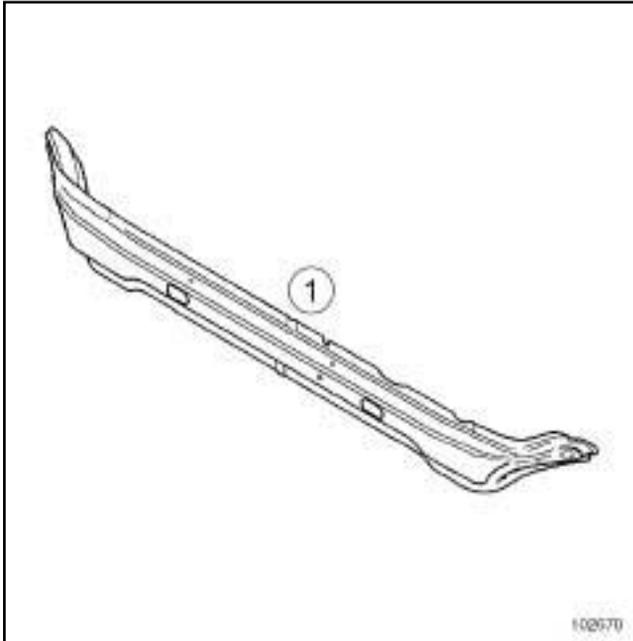
If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

B84 or C84

There is only one way of replacing this part:

- complete replacement.

I - COMPOSITION OF THE SPARE PART



102670

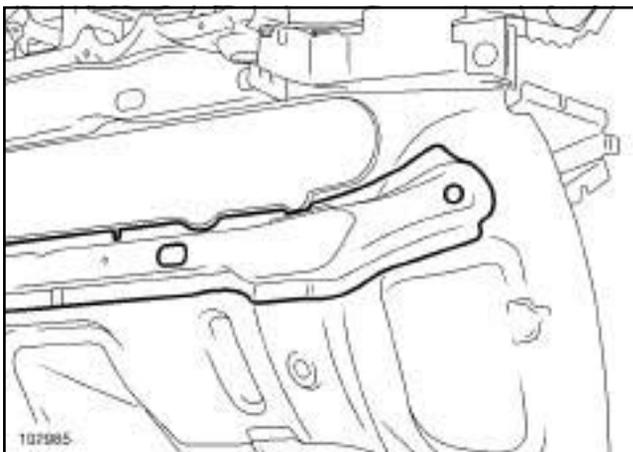
WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

Mark	Description	Type	Thickness (mm)
(1)	Bulkhead lower cross member	THLE	2.5

II - PART FITTED

Complete replacement



102985

UPPER FRONT STRUCTURE

Bulkhead panel: Removal - Refitting

42A

B84 or C84

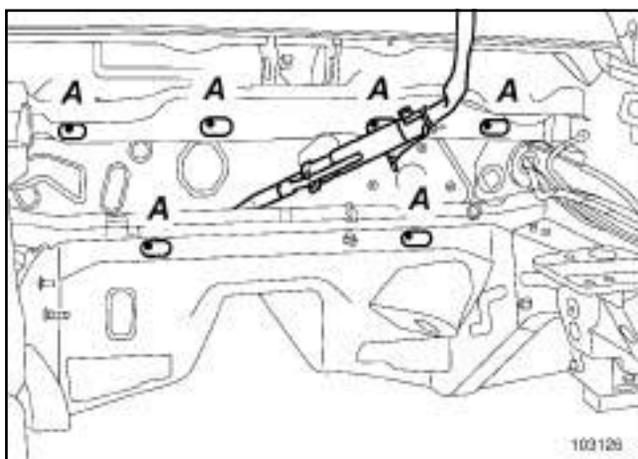
Tightening torques

bolts (A)	8 Nm
-----------	------

The removal/refitting of this part is an operation linked to the replacement of the complete body shell.

REMOVAL

OPERATION FOR REMOVAL OF PART CONCERNED



103126

- Remove the mounting bolts (A) .
- Cut the cement bead using the pneumatic tool (see **Technical Note 414 A**) .

Note:

Wire cutting can be difficult due to the shape of the surrounding components, and the bulkhead panel mounting bolts.

- Remove the bulkhead panel.

REFITTING

REFITTING OPERATION FOR PART CONCERNED

- Refit the bulkhead panel.

Note:

To refit, the bonding procedure is identical to that for replacing a bonded windscreen (refer to **Technical Note 371A**) .

- Refit the mounting bolts (A) .
- Tighten to torque the **bolts (A) (8 Nm)** .

Bulkhead side reinforcement: General description

B84 or C84

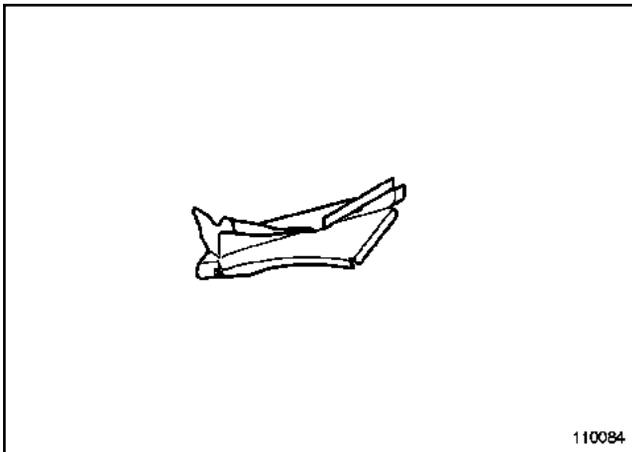
WARNING

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information** .

DESIGN OF THE STRUCTURAL COMPONENT

110084

This is a basic part, it simply fulfils the function of bulkhead side reinforcement.

If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400, 40A, General Information**).

Bulkhead upper cross member: General description

B84 or C84

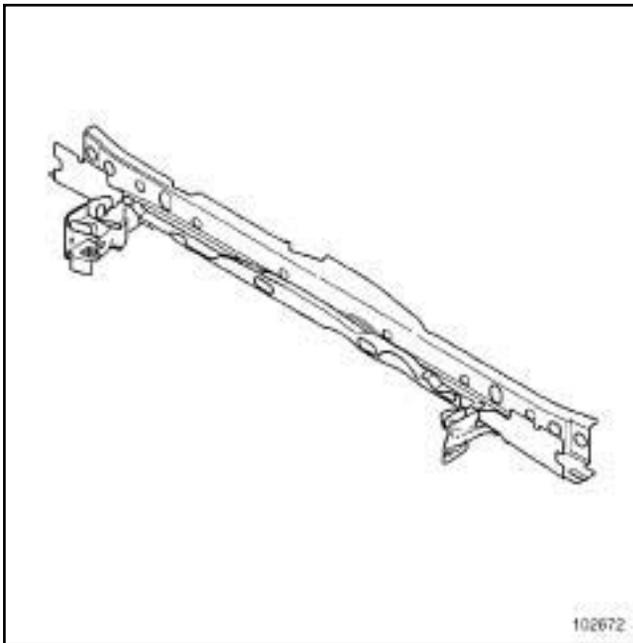
WARNING

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information**.

DESIGN OF THE STRUCTURAL COMPONENT

102672

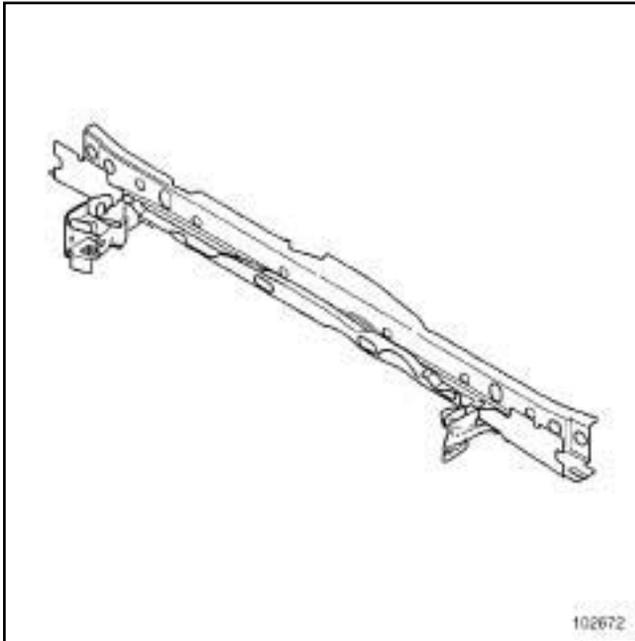
This is a basic part; it only fulfils the function of a bulkhead upper cross member.

UPPER FRONT STRUCTURE

Bulkhead upper cross member: Description

42A

B84 or C84

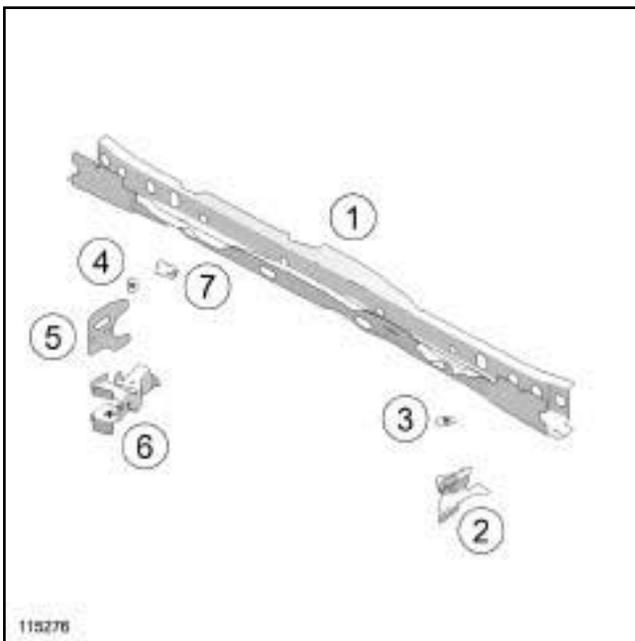


102672

There is only one way of replacing this part:

- Complete replacement: this operation supplements the replacement of the A-pillar.

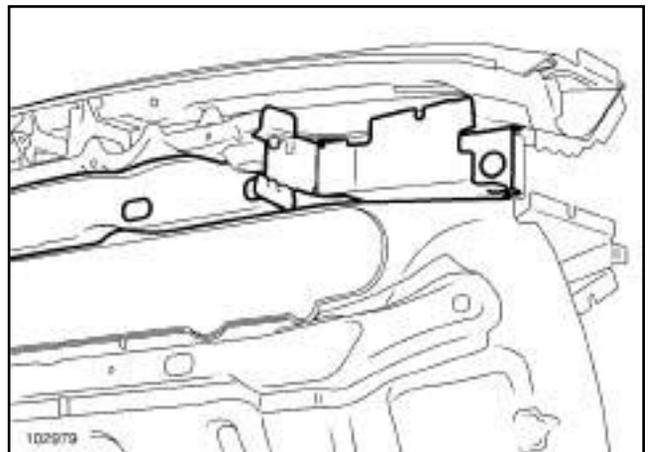
I - COMPOSITION OF THE SPARE PART



115276

Mark	Description	Type	Thickness (mm)
(1)	Bulkhead upper cross member	HLE	1
(2)	Windscreen aperture lower cross member left-hand side angle bracket	-	1.2
(3)	Wiper left-hand mounting pad	-	1
(4)	Wiper right-hand mounting pad	-	1
(5)	Linkage support reinforcement plate	HLE	2
(6)	Tie-bar mounting	HLE	3
(7)	Bulkhead upper cross member bracket	-	2

II - PART FITTED



102979

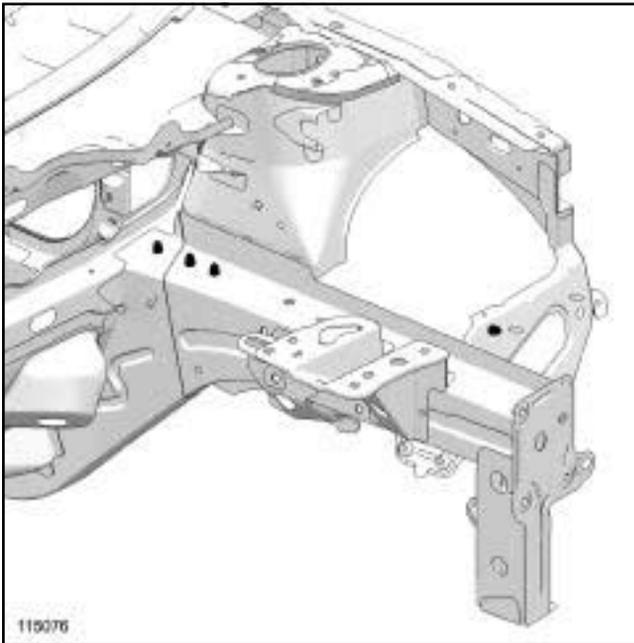
WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

Bulkhead upper cross member: Description

B84 or C84

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



115076

IMPORTANT

To avoid damaging the vehicle's electric and electronic components, the battery and the earths of any wiring harness near the weld area must be disconnected.

The earth of the welding machine must be placed as close as possible to the weld area.

UPPER FRONT STRUCTURE

Bulkhead side stiffener: Description

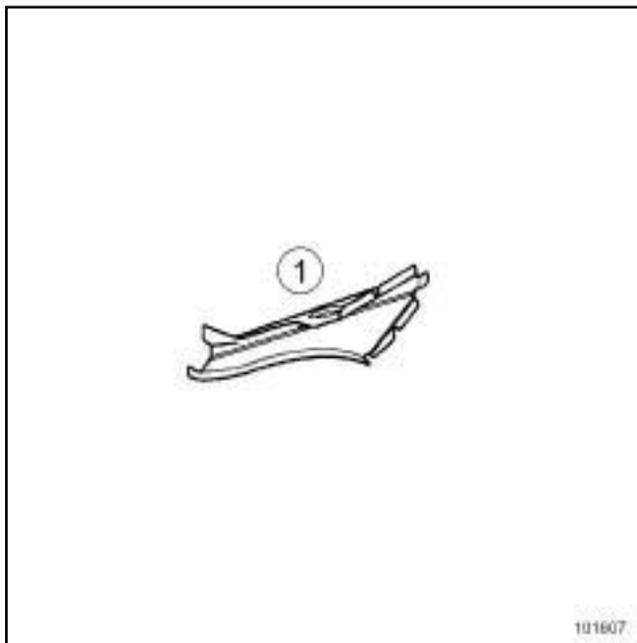
42A

B84 or C84

There is only one way of replacing this part:

- Complete replacement: this operation supplements the replacement of the A-pillar and the A-pillar lining.

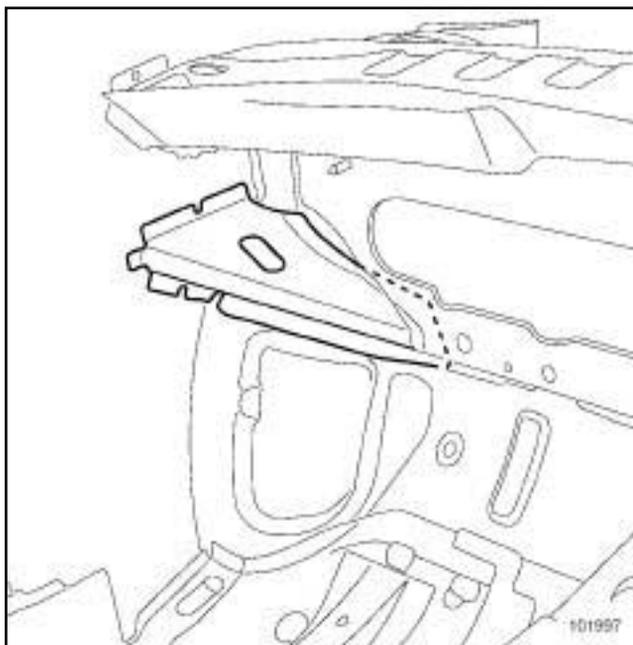
I - COMPOSITION OF THE SPARE PART



101607

Mark	Description	Type	Thickness (mm)
(1)	Bulkhead side reinforcement	-	1.7

II - PART FITTED



101997

IMPORTANT

For the weld joints in three thicknesses, the spot welds on the part replaced should be executed in the same place as the originals to retain the mechanical properties of the joint.

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

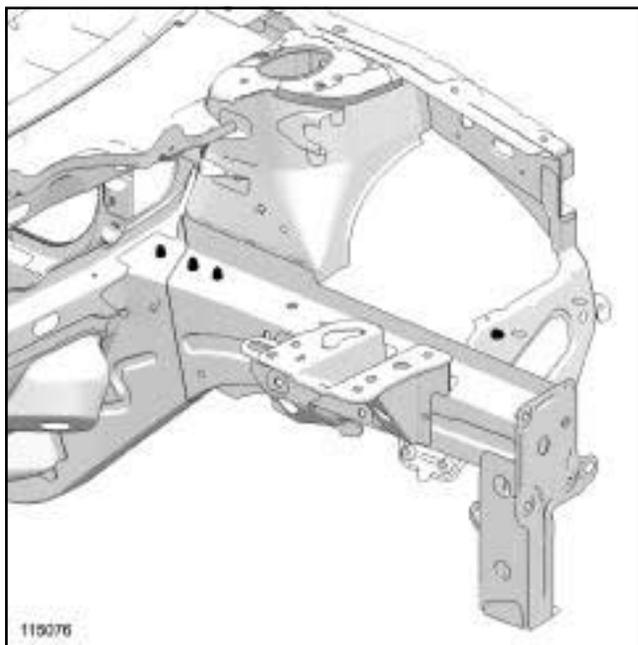
UPPER FRONT STRUCTURE

Bulkhead side stiffener: Description

42A

B84 or C84

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



115076

IMPORTANT

To avoid damaging the vehicle's electric and electronic components, the battery and the earths of any wiring harness near the weld area must be disconnected.

The earth of the welding machine must be placed as close as possible to the weld area.

UPPER FRONT STRUCTURE

Windscreen wiper mounting: Description

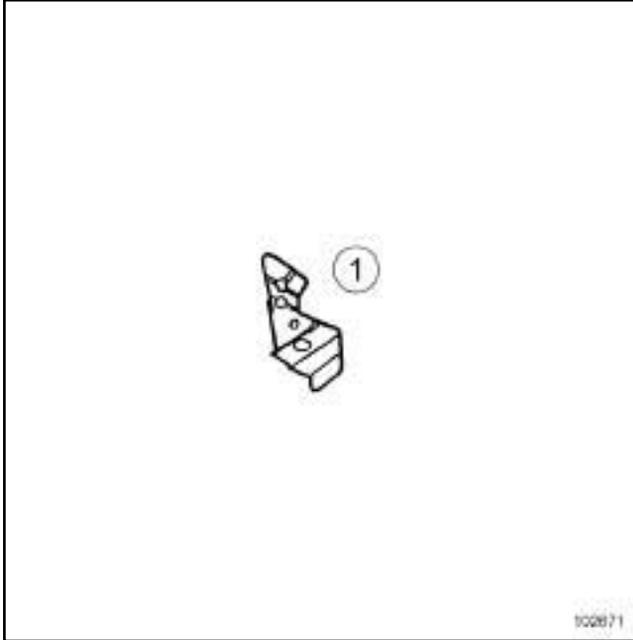
42A

B84 or C84

There is only one way of replacing this part:

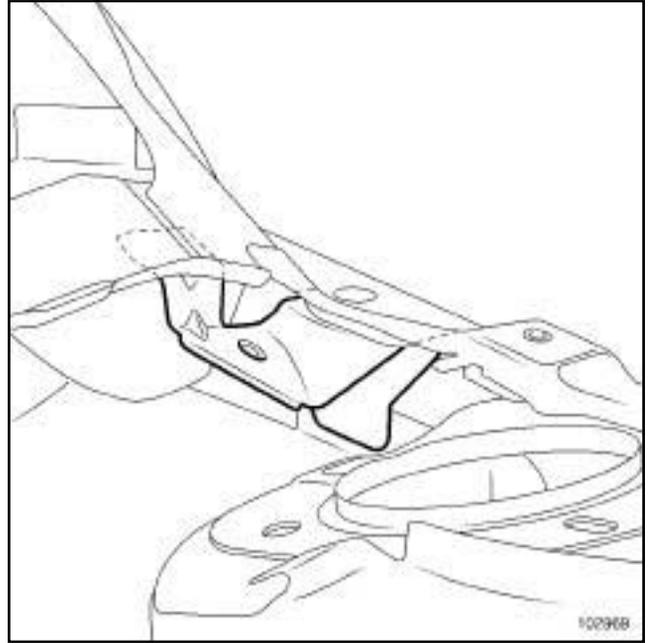
- Complete replacement: this operation supplements the replacement of the scuttle side panel and the scuttle side panel reinforcement

I - COMPOSITION OF THE SPARE PART



102671

II - PART FITTED



102969

IMPORTANT

For welded connections in three thicknesses, the spot welds on the part replaced should be made in the same place as for the original joint to retain its mechanical properties.

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

Mark	Description	Type	Thickness (mm)
(1)	Wiper mounting	-	1.2

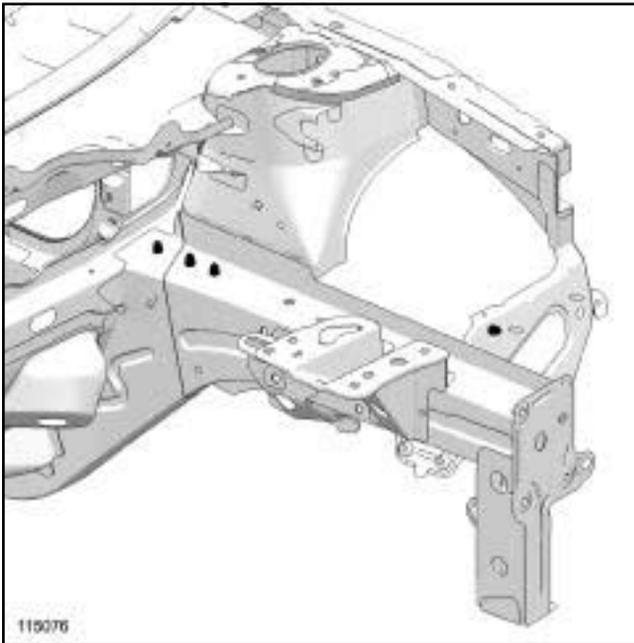
UPPER FRONT STRUCTURE

Windscreen wiper mounting: Description

42A

B84 or C84

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



115076

IMPORTANT

To avoid damaging the vehicle's electric and electronic components, the battery and the earths of any wiring harness near the weld area must be disconnected.

The earth of the welding machine must be placed as close as possible to the weld area.

SIDE UPPER STRUCTURE

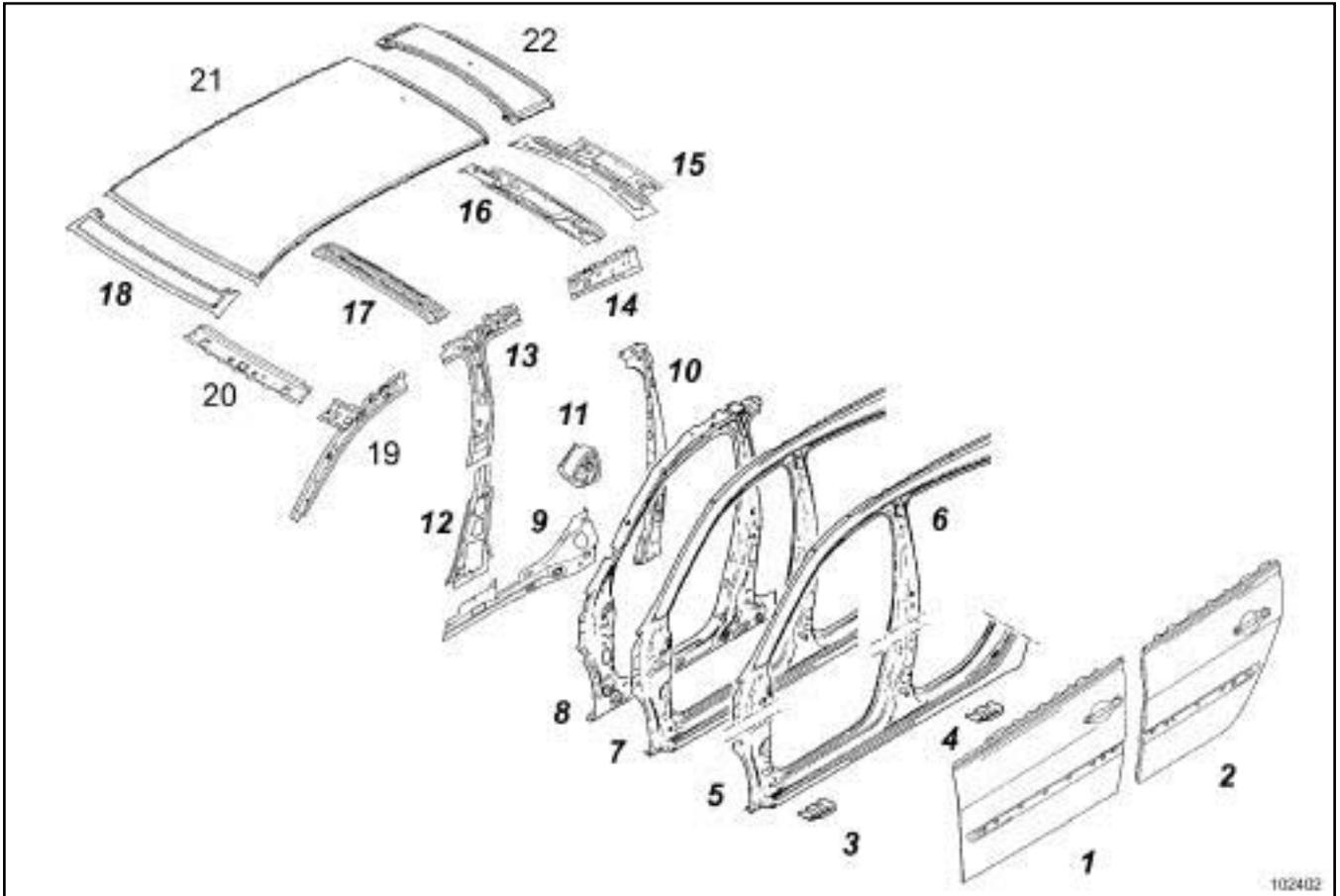
Vehicle side section structure: Description

43A

B84 or C84

SIDE STRUCTURE

B84



102402

102402

Mark	Description	Classification	Type	Thickness (mm)
(1)	Front side door panel	(see Front side door panel: Description)	HLE	0.7/0.95
(2)	Rear side door panel	(see Rear side door panel: Description)	HLE	0.7/0.95
(3)	Front jack support	(see Front jacking point: Description)	HLE	1.8
(4)	Rear jack support	(see Front jacking point: Description)	HLE	1.8
(5)	Sill panel	(see 41C, Side lower structure, Sill panel: Description, page 41C-9)	-	0.7
(6)	Upper body	(see 43A, Side upper structure, Upper body panel: Description, page 43A-47)	-	0.7

SIDE UPPER STRUCTURE

Vehicle side section structure: Description

43A

B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(7)	Body side front section	(see 43A, Side upper structure, Body side front section: Description, page 43A-39)	-	0.7
(8)	Body side front section reinforcement	(see 43A, Side upper structure, Body side front section reinforcement: Description, page 43A-42)	HLE	1.2/1.5
(9)	Rear inner sill panel	(see 41C, Side lower structure, Rear inner sill panel: Description, page 41C-23)	HLE	1
(10)	B-pillar reinforcement stiffener	(see B-pillar reinforcement stiffener: Description)	HLE	1.5/2.2
(11)	Anti-intrusion reinforcement			
(12)	B-pillar lower lining	(see B-pillar lower lining: Description)	-	0.7
(13)	B-pillar upper lining	(see B-pillar upper lining: Description)	HLE	1.5
(14)	Rear roof drip moulding lining	(see Roof drip moulding lining: Description)	-	1
(15)	Roof rear cross member with sunroof	(see 45A, Top of body, Roof rear cross member: Description, page 45A-16)	HLE	0.7/0.9
(16)	Roof rear cross member without sunroof	(see 45A, Top of body, Roof rear cross member: Description, page 45A-16)	HLE	0.7/0.9
(17)	Roof middle cross member	(see 45A, Top of body, Roof centre cross member: Description, page 45A-14)	HLE	1.5
(18)	Front section of roof	(see 45A, Top of body, Roof front section: Description, page 45A-9)	-	0.7
(19)	A-pillar lining	(see 43A, Side upper structure, Windscreen pillar lining: Description, page 43A-16)	HLE	1.5/2
(20)	Roof front cross member	(see 45A, Top of body, Roof front cross member: Description, page 45A-12)	HLE	0.7

SIDE UPPER STRUCTURE

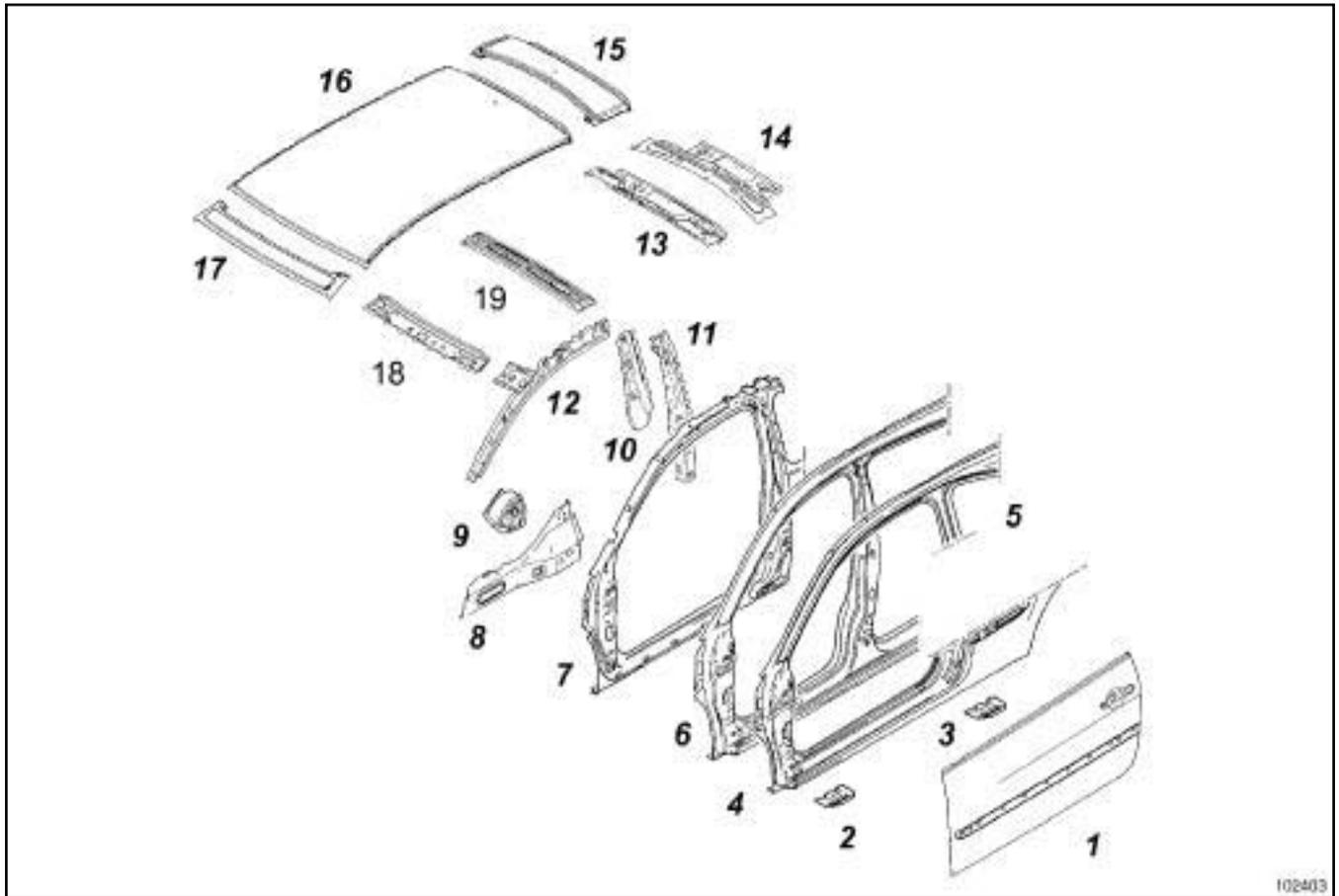
43A

Vehicle side section structure: Description

B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(21)	Roof	(see 45A, Top of body, Roof: Description, page 45A-7)	-	0.7
(22)	Rear section of roof	(see 45A, Top of body, Roof rear section: Description, page 45A-10)	-	0.7

C84



102403

102403

Mark	Description	Classification	Type	Thickness (mm)
(1)	Front side door panel	(see Front side door panel: Description)	HLE	0.7/0.95
(2)	Front jack support	(see Front jacking point: Description)	HLE	1.8
(3)	Rear jack support	(see Front jacking point: Description)	HLE	1.8

SIDE UPPER STRUCTURE

Vehicle side section structure: Description

43A

B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(4)	Sill panel	(see 41C, Side lower structure, Sill panel: Description, page 41C-9)	-	0.7
(5)	Upper body	(see 43A, Side upper structure, Upper body panel: Description, page 43A-47)	-	0.7
(6)	Body side front section	(see 43A, Side upper structure, Body side front section: Description, page 43A-39)	-	0.7
(7)	Body side front section reinforcement	(see 43A, Side upper structure, Body side front section reinforcement: Description, page 43A-42)	HLE	1.2/1.5
(8)	Rear inner sill panel	(see 41C, Side lower structure, Rear inner sill panel: Description, page 41C-23)	HLE	1
(9)	Anti-intrusion reinforcement			
(10)	Quarter panel front reinforcement		HLE	1.5
(11)	B-pillar reinforcement stiffener	(see B-pillar reinforcement stiffener: Description)	VHLE	1.8
(12)	A-pillar lining	(see 43A, Side upper structure, Windscreen pillar lining: Description, page 43A-16)	HLE	1.5/2
(13)	Roof rear cross member without sunroof	(see 45A, Top of body, Roof rear cross member: Description, page 45A-16)	HLE	0.7/0.9
(14)	Roof rear cross member with sunroof	(see 45A, Top of body, Roof rear cross member: Description, page 45A-16)	HLE	0.7/0.9
(15)	Rear section of roof	(see 45A, Top of body, Roof rear section: Description, page 45A-10)	-	0.7
(16)	Roof	(see 45A, Top of body, Roof: Description, page 45A-7)	-	0.7
(17)	Front section of roof	(see 45A, Top of body, Roof front section: Description, page 45A-9)	-	0.7

SIDE UPPER STRUCTURE

Vehicle side section structure: Description

43A

B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(18)	Roof front cross member	(see 45A, Top of body, Roof front cross member: Description, page 45A-12)	HLE	0.7
(19)	Roof middle cross member	(see 45A, Top of body, Roof centre cross member: Description, page 45A-14)	HLE	1.5



SIDE UPPER STRUCTURE

A-pillar: General description

43A

B84 or C84

WARNING

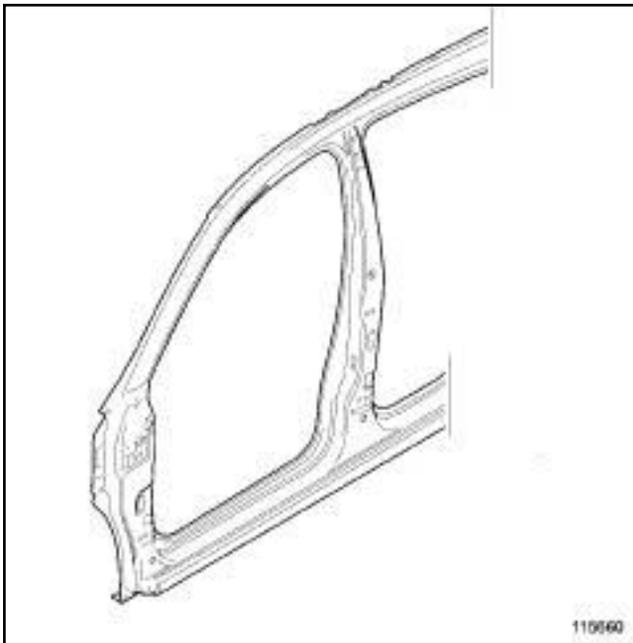
The following information describes the general repair procedure for all vehicles with the same type of design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

DESIGN OF THE STRUCTURAL COMPONENT

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information**.



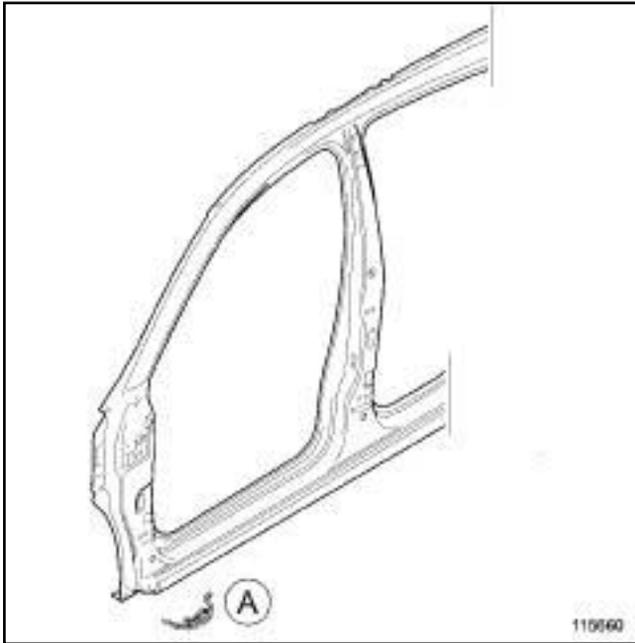
115660

The A-pillar is obtained by extension from the body side front section.

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

B84 or C84



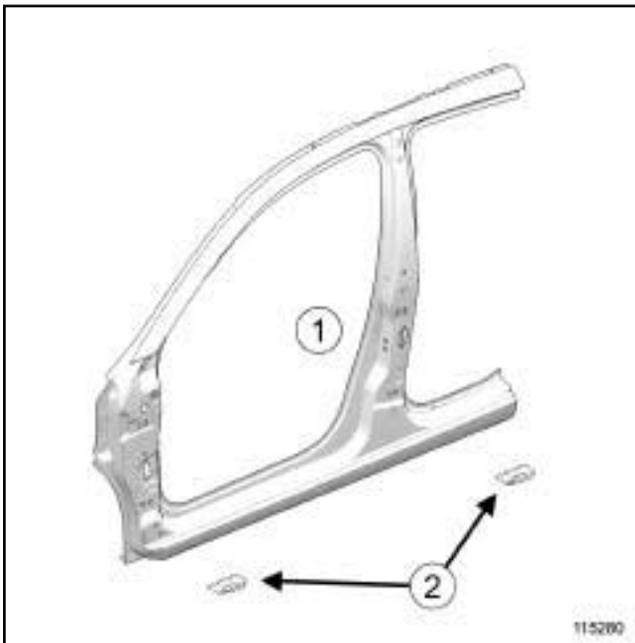
115660
115660

To replace this part, also order insert (A) .

The options for replacing this part are as follows:

- partial replacement,
- partial central replacement: this operation is specific to the replacement of the hinge reinforcement,
- complete replacement.

I - COMPOSITION OF THE SPARE PART

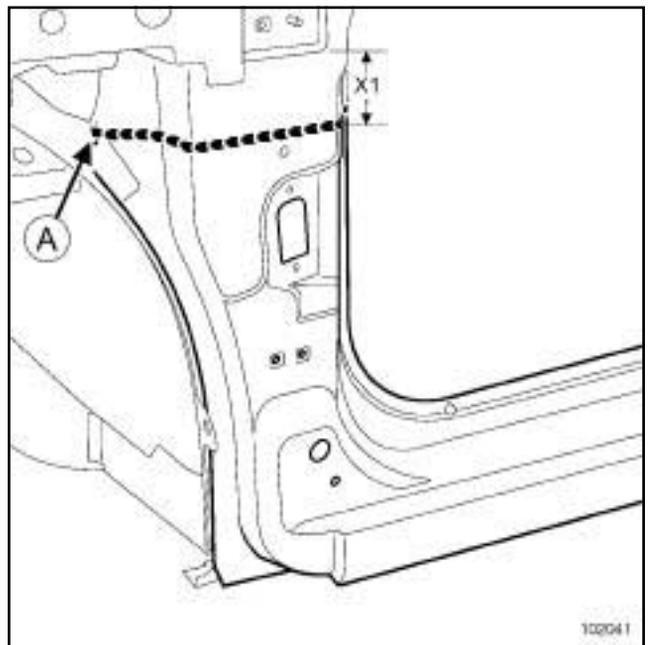


115280
115280

Mark	Description	Type	Thickness (mm)
(1)	Body side	-	0.7
(2)	Jacking point support	HLE	1.8

II - PART FITTED

1 - Partial replacement

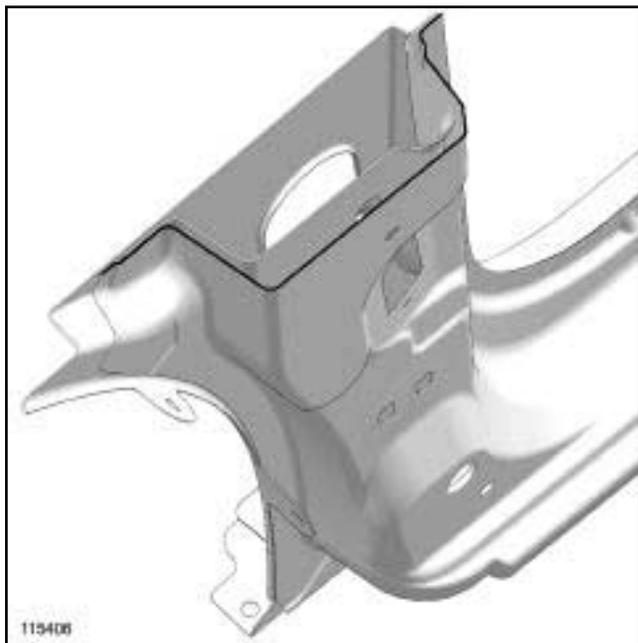


102041
102041

X1 = 60 mm

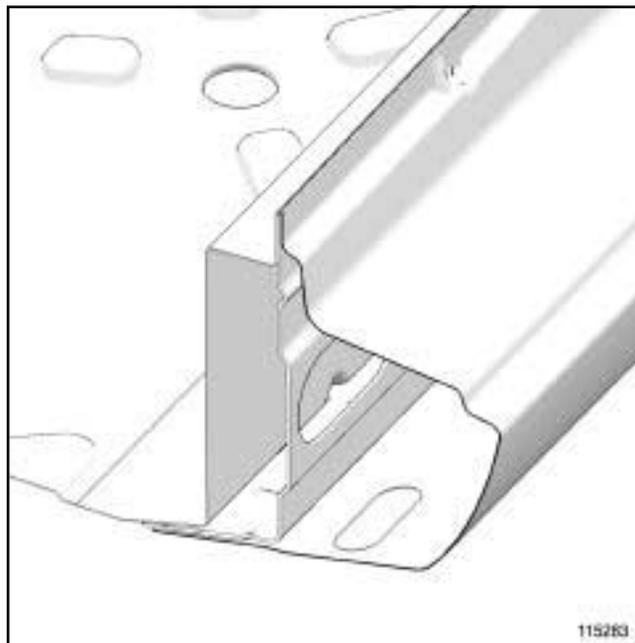
B84 or C84

Cut A



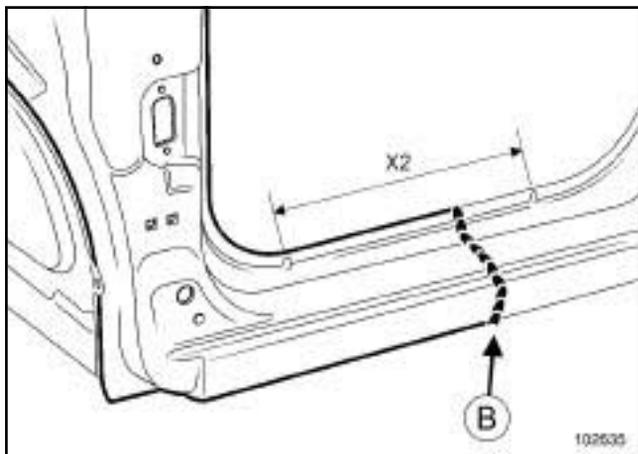
115406

Cut B



115283

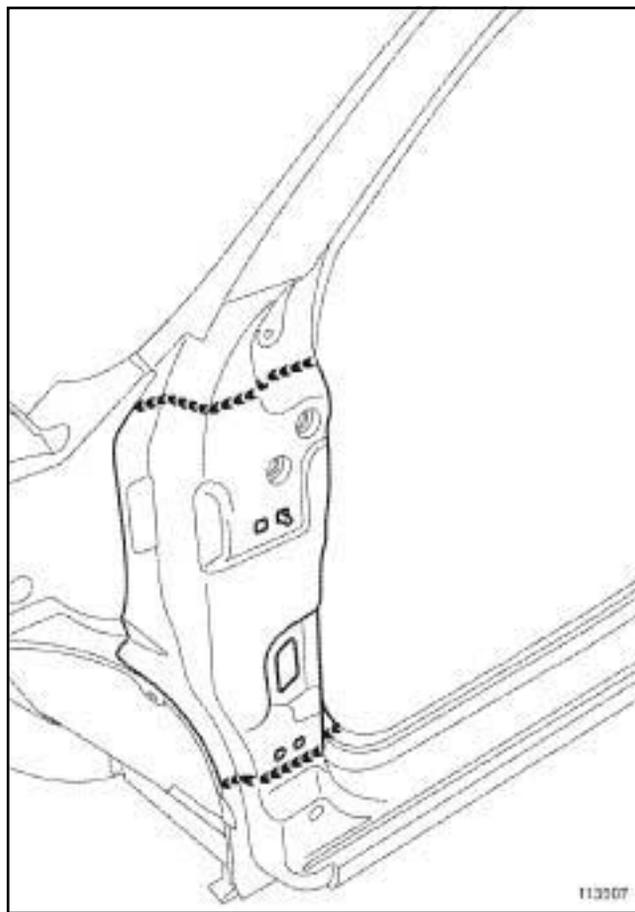
115283



102635

Make the cut in area (X2) .

2 - Partial central replacement



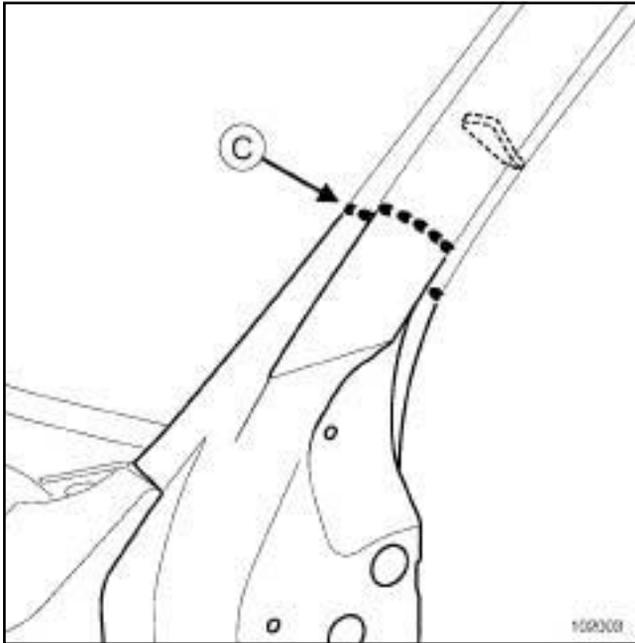
113507

113507

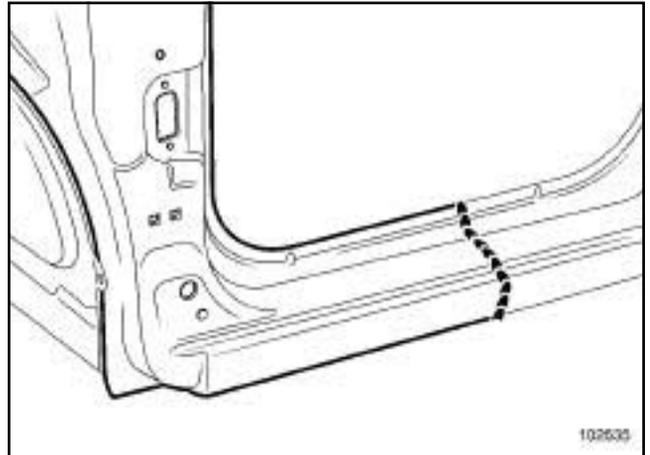
For replacement of the hinge reinforcement (see **43A, Side upper structure, A-pillar reinforcement: Description, page 43A-11**) .

B84 or C84

3 - Complete replacement



102003

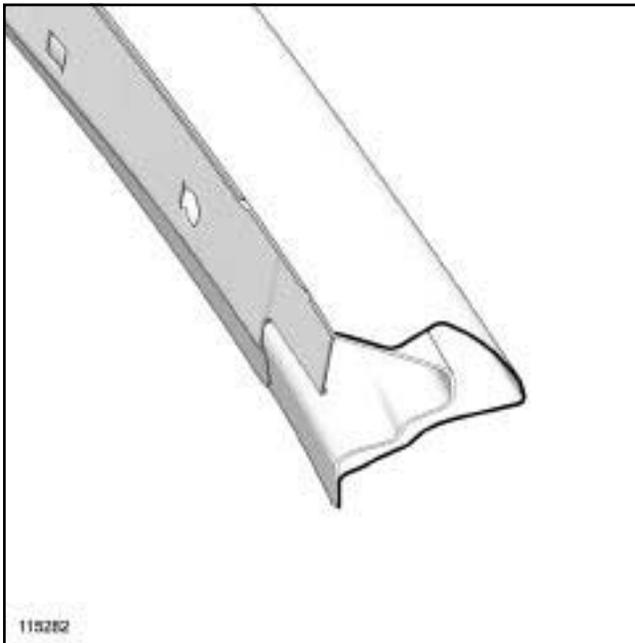


102635

IMPORTANT

For welded connections in three thicknesses, the spot welds on the part replaced should be made in the same place as for the original joint to retain its mechanical properties.

Cut C



115282

Note:

Do not make the cut above this limit as the expanding insert could be cut.

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

B84 or C84

WARNING

The following information describes the general repair procedure for all vehicles with the same type of design for this part.

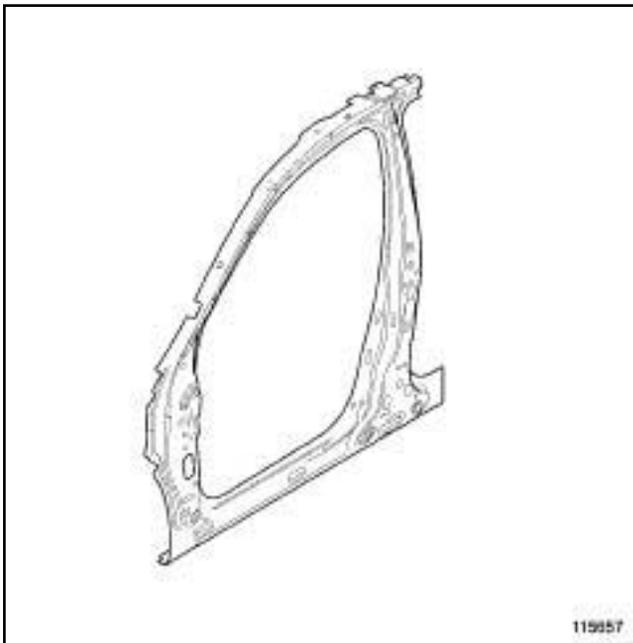
Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information**.

DESIGN OF THE STRUCTURAL COMPONENT

B84

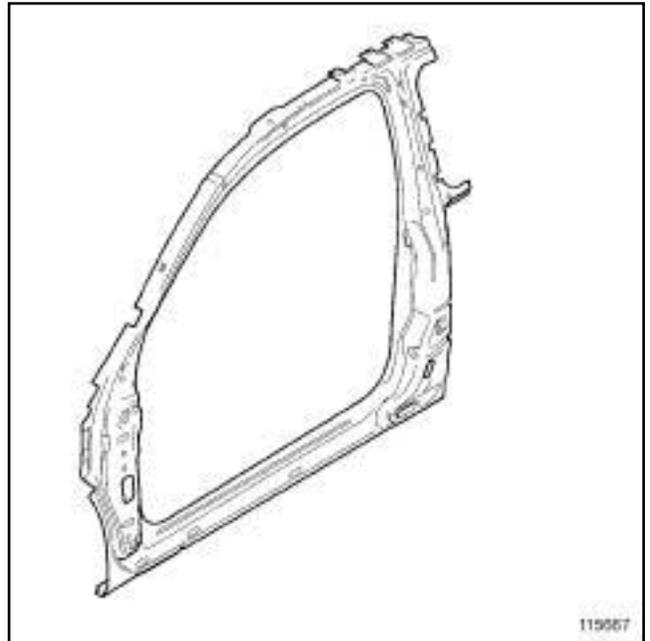


115657

115657

This part's special feature is that it serves as an A-pillar reinforcement, B-pillar reinforcement, body side front section reinforcement and sill panel reinforcement.

C84



115667

115667

This part's special feature is that it serves as an A-pillar reinforcement, B-pillar reinforcement, body side front section reinforcement and sill panel reinforcement.

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

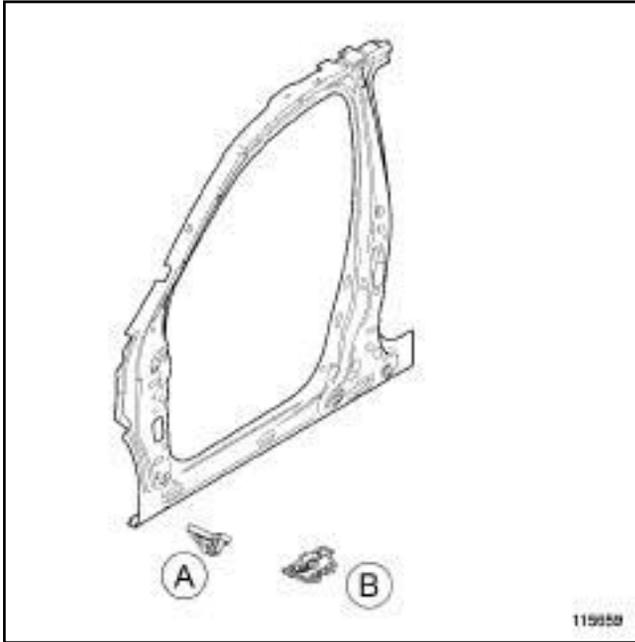
SIDE UPPER STRUCTURE

A-pillar reinforcement: Description

43A

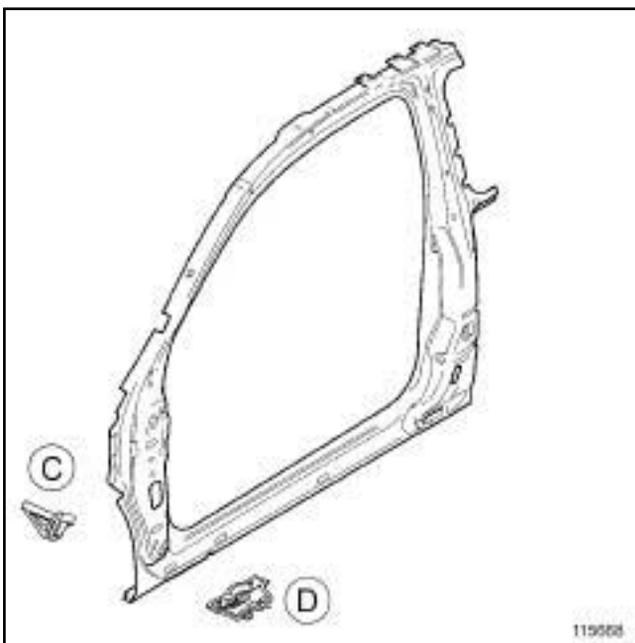
B84 or C84

B84



115659

C84



115668

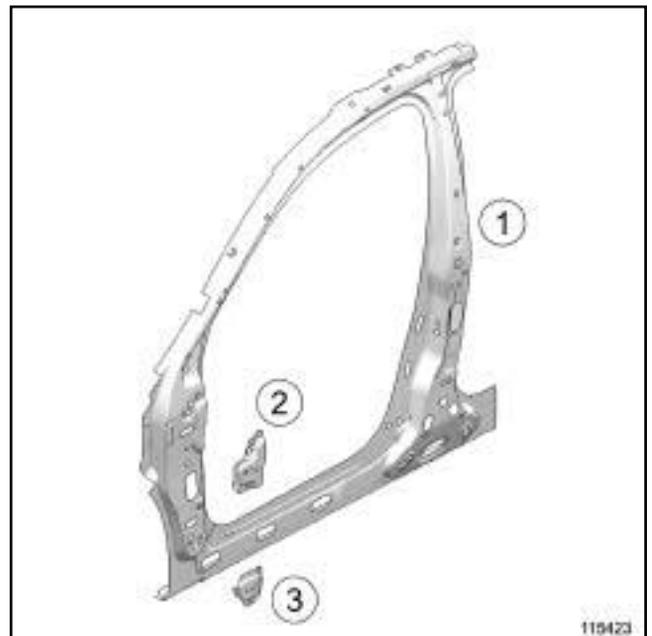
To replace this part, order the expanding inserts corresponding to each of the following cases.

The options for replacing this part are as follows:

- partial replacement of lower section: order insert **(B)** or **(D)**,
- partial replacement: order inserts **(A)** and **(B)** or **(C)** and **(D)**.

I - COMPOSITION OF THE SPARE PART

B84



115423

SIDE UPPER STRUCTURE

A-pillar reinforcement: Description

43A

B84 or C84

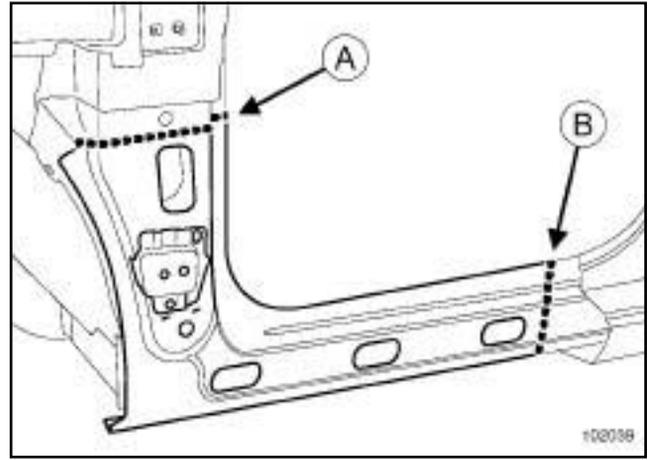
C84



115424

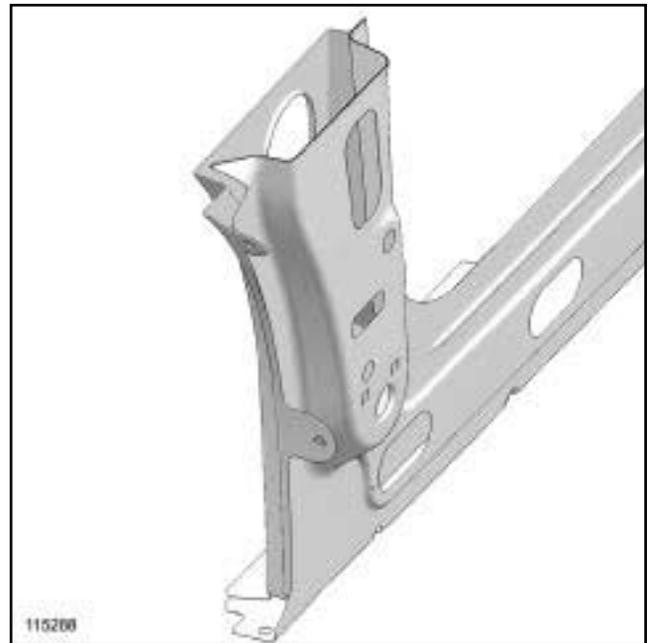
II - PART FITTED

1 - Partial replacement of the lower section



102039

Cut A



115288

Mark	Description	Type	Thic- kness (mm)
(1)	Body side rein- forcement	HLE	1.2
(2)	A-pillar upper hinge reinfor- cement	THLE	2.5
(3)	A-pillar lower hinge reinfor- cement	THLE	2.5

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

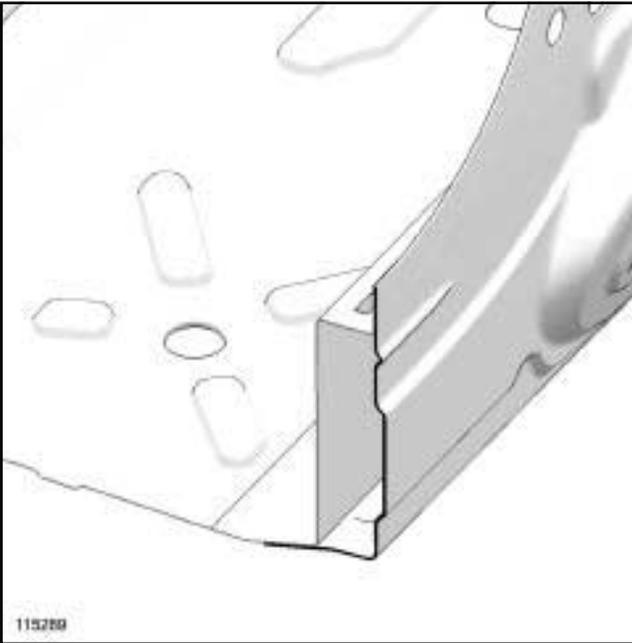
SIDE UPPER STRUCTURE

A-pillar reinforcement: Description

43A

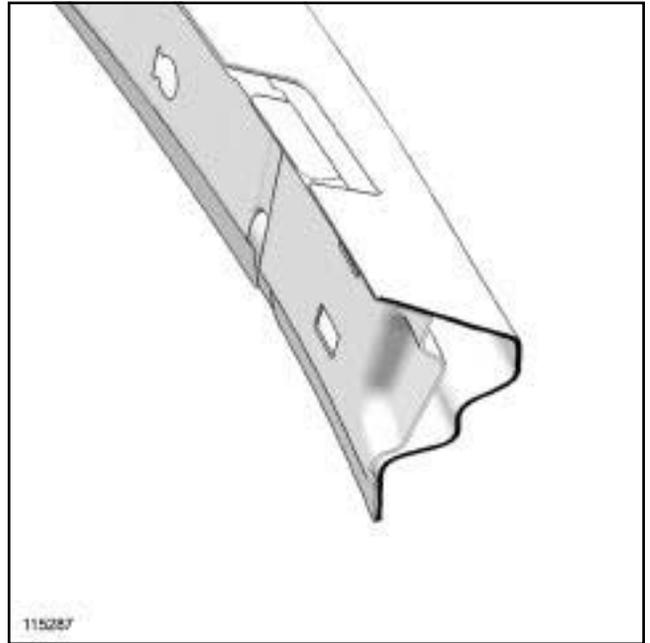
B84 or C84

Cut B



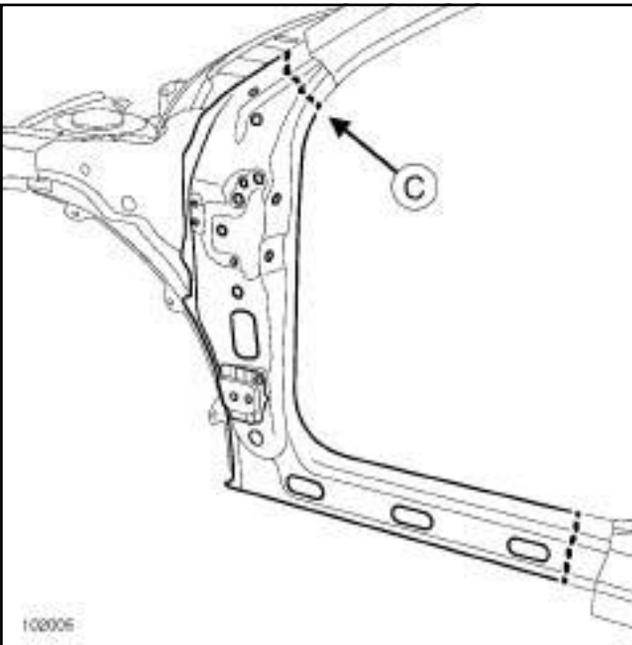
115289

Cut C



115287

2 - Partial replacement

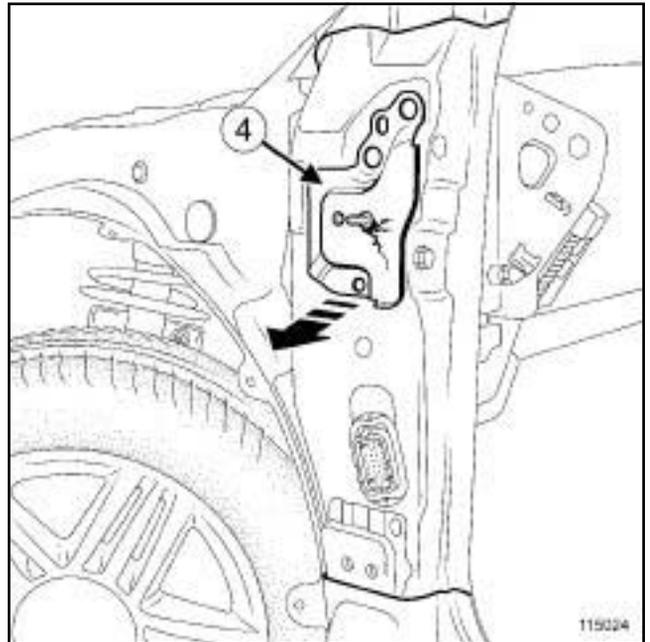


102005

WARNING

Do not alter the position of this weld; it is determined by the position of the lining, reinforcements or expanding inserts.

III - REPLACEMENT OF UPPER HINGE REINFORCEMENT



115024

Unpick the welds and remove the upper hinge reinforcement (4).

SIDE UPPER STRUCTURE

A-pillar reinforcement: Description

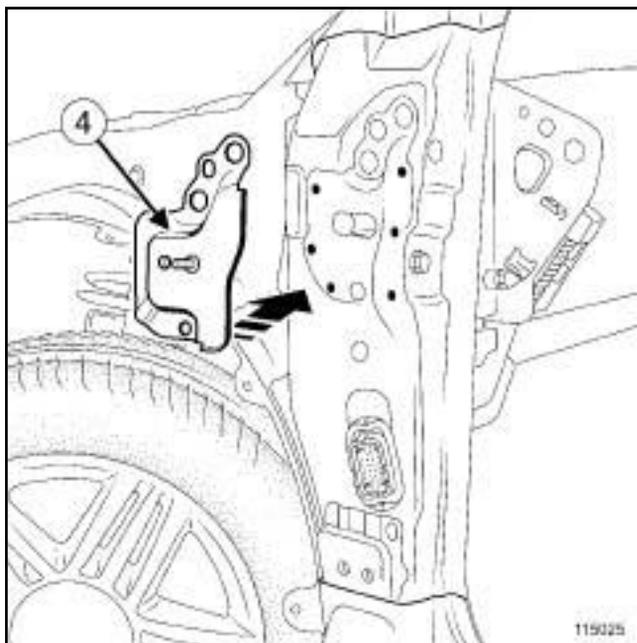
43A

B84 or C84

WARNING

Each time a panel is stripped in the workshop (e.g. when drilling), degrease and wipe the area and then use a fine paintbrush to apply the following:

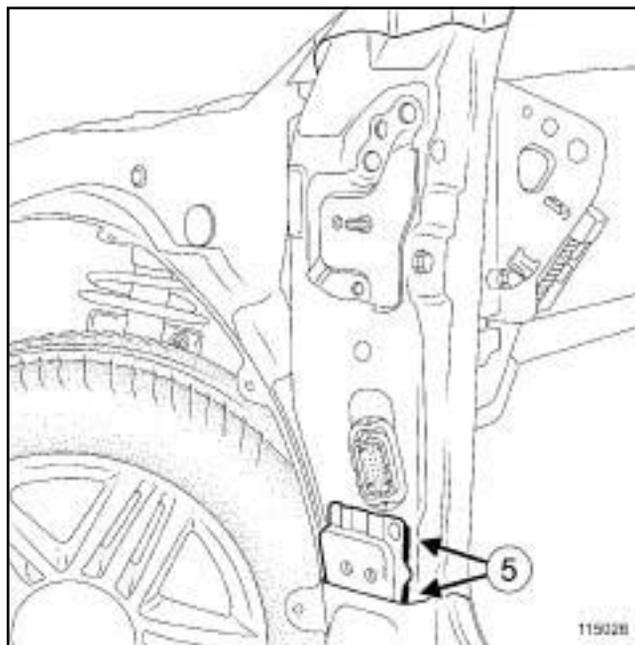
- a pre-treatment primer,
- a two-part primer
- paint in the vehicle body colour.



115025

Position and weld the upper hinge reinforcement (4) with six plug welds after having drilled the replacement part.

IV - SPECIAL NOTE FOR LOWER HINGE REINFORCEMENT



115026

Apply two securing beads (5) of 15 mm to the lower hinge reinforcement.

Windscreen pillar lining: General description

B84 or C84

WARNING

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information** .

DESIGN OF THE STRUCTURAL COMPONENT

102613

This is a basic part, its only function is that of the windscreen pillar lining.

If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400, 40A, General Information**).

SIDE UPPER STRUCTURE

Windscreen pillar lining: Description

43A

B84 or C84

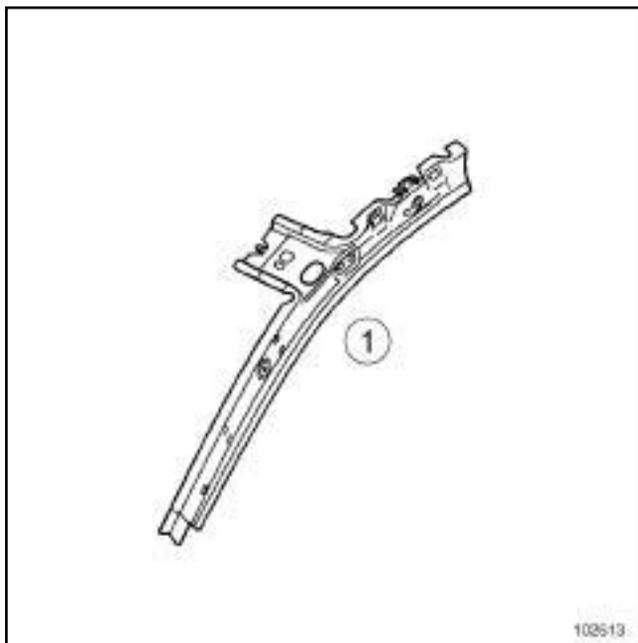
To replace this part, order the expanding insert.

There is only one way of replacing this part:

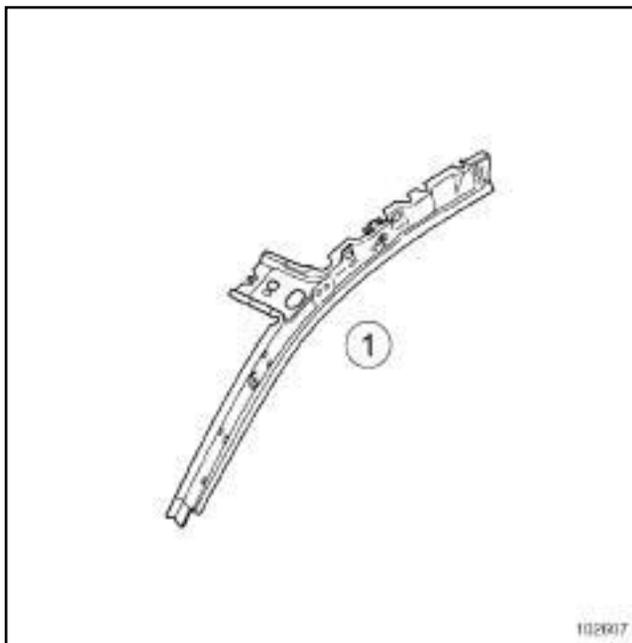
- complete replacement.

I - COMPOSITION OF THE SPARE PART

B84



C84



102607

Mark	Description	Type	Thickness (mm)
(1)	Windscreen pillar lining	HLE	1.5

SIDE UPPER STRUCTURE

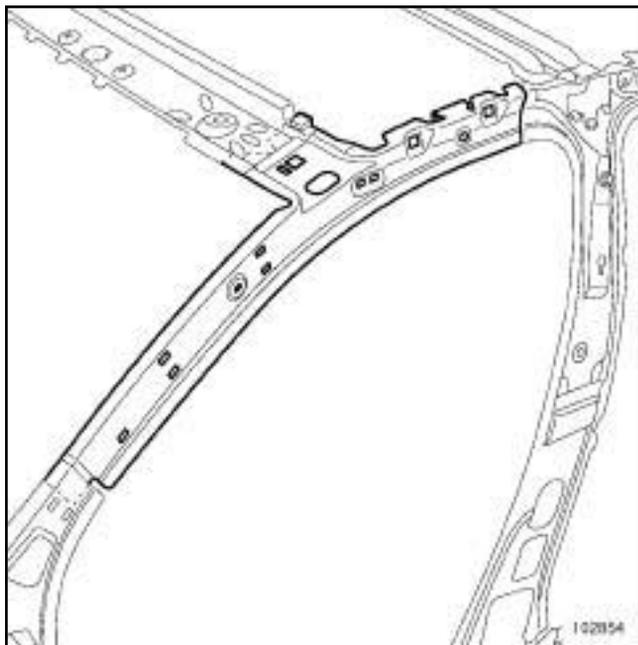
Windscreen pillar lining: Description

43A

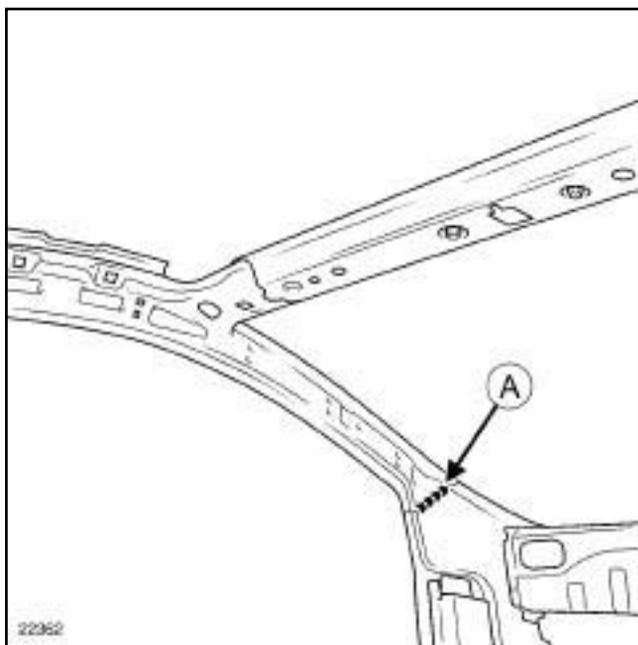
B84 or C84

II - PART FITTED

Complete replacement



102854



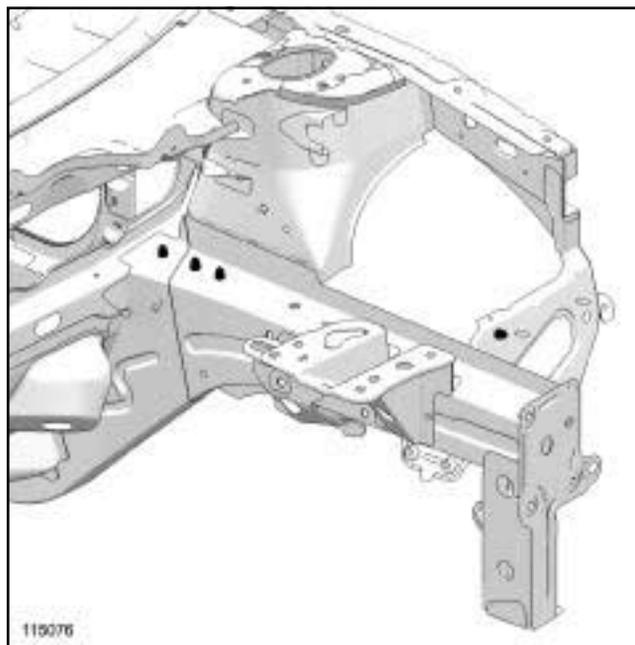
22362

Apply a safety bead (A) .

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



115076

IMPORTANT

To avoid damaging the vehicle's electric and electronic components, the battery and the earths of any wiring harness near the weld area must be disconnected.

The earth of the welding machine must be placed as close as possible to the weld area.

SIDE UPPER STRUCTURE

B-pillar: General description

43A

B84

WARNING

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

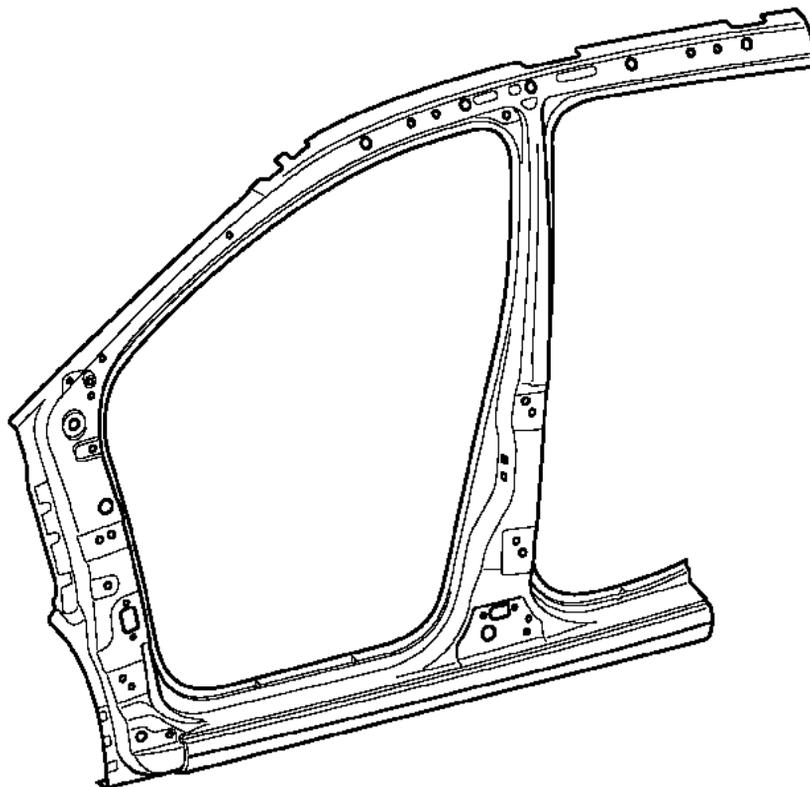
Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information** .

IMPORTANT

Before any operation, remove the front seat belts.

I - DESIGN OF THE STRUCTURAL COMPONENT



110581

110591

The B-pillar is obtained by extension from the front section body side.

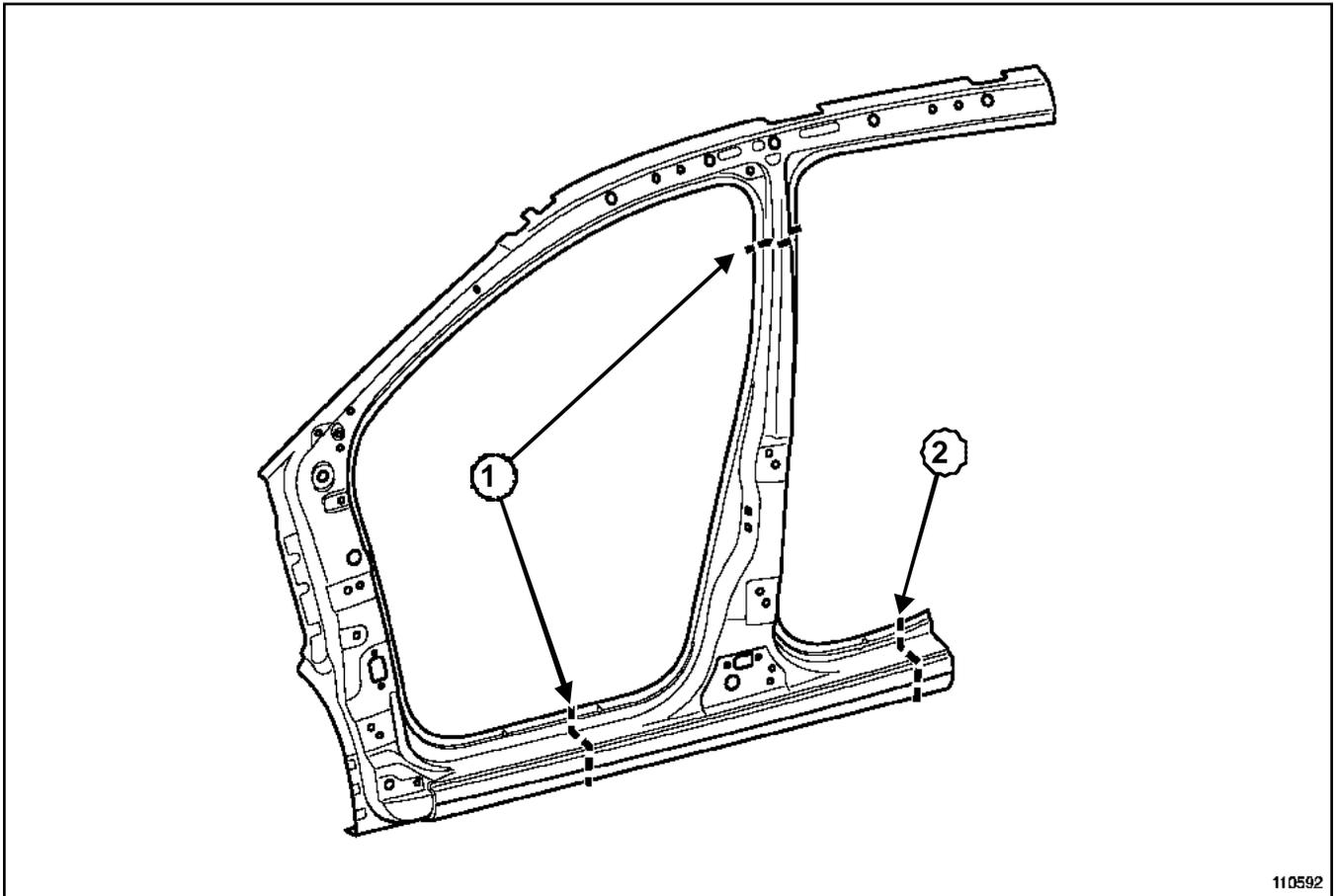
SIDE UPPER STRUCTURE

B-pillar: General description

43A

B84

II - AREA TO BE CUT FOR PARTIAL REPLACEMENT



110592

110592

Cut lines (1) and (2) show the area in which it is possible to carry out a partial replacement.

Make the cut line (2) on the butt weld.

III - ASSEMBLY INSTRUCTIONS FOR A PARTIAL REPLACEMENT

Only the connecting pieces relevant to partial replacement by cutting are shown.

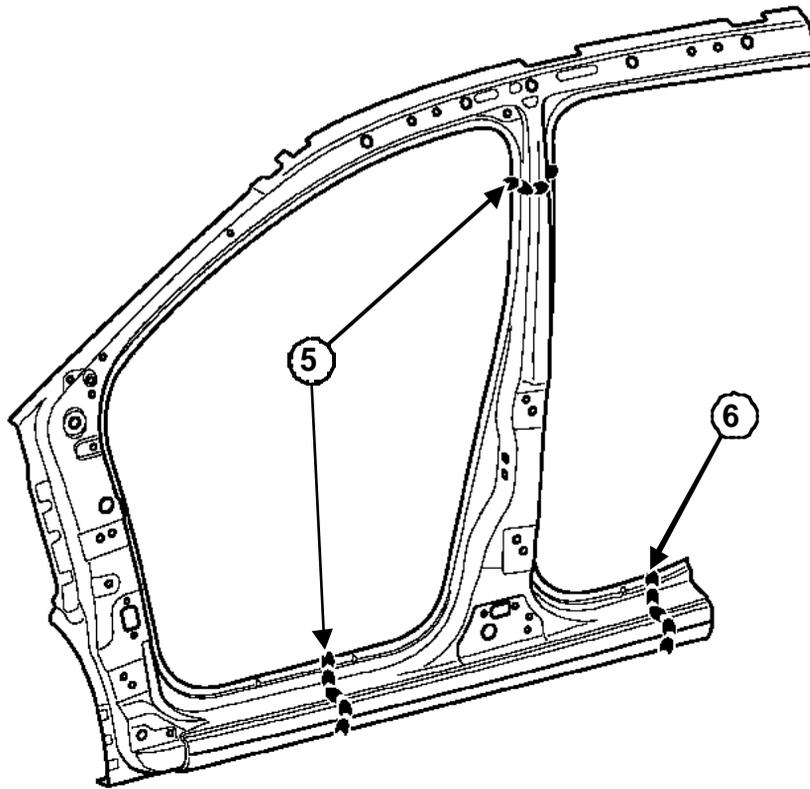
If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400, 40A, General Information**).

SIDE UPPER STRUCTURE

B-pillar: General description

43A

B84



110593

110593

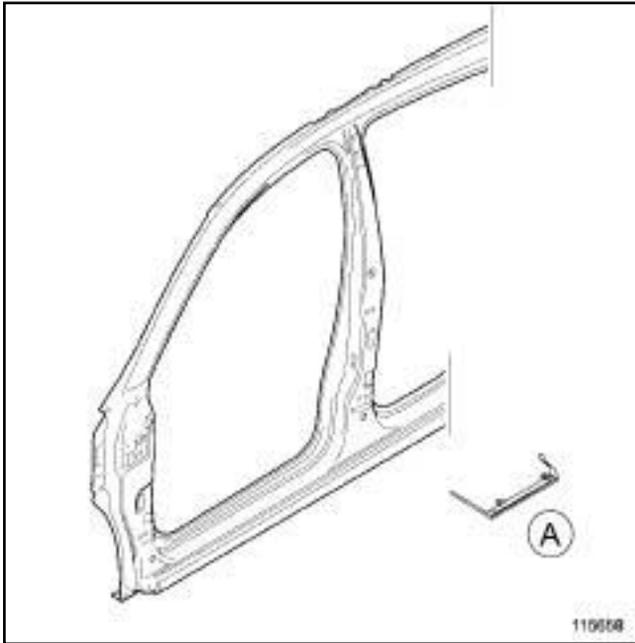
Lines (5) and (6) of the drawing show a butt weld by continuous MAG welding.

Weld (6) along the butt weld line.

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

B84



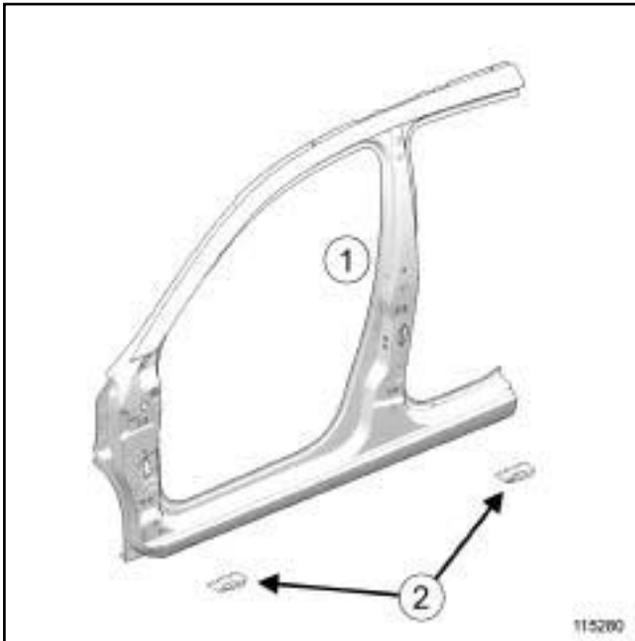
115658

To replace this part, order the expanding insert (A) .

The options for replacing this part are as follows:

- partial replacement,
- complete replacement.

I - COMPOSITION OF THE SPARE PART

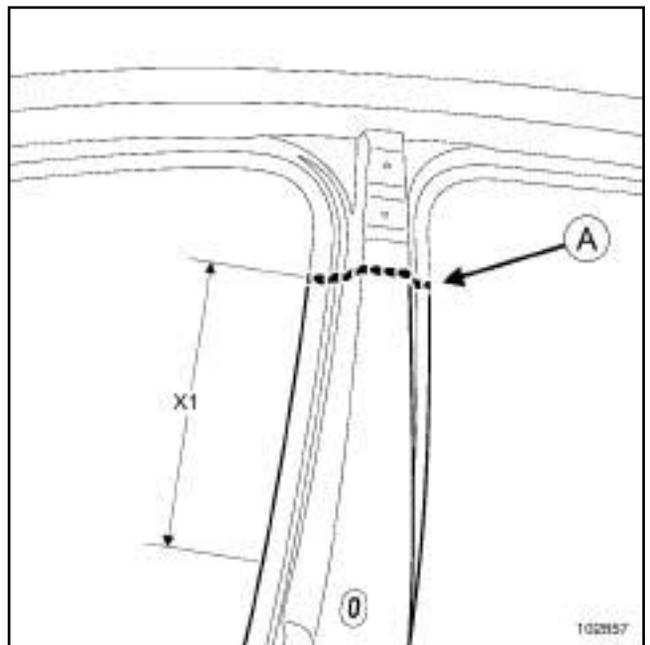


115280

Mark	Description	Type	Thickness (mm)
(1)	Body side	-	0.9
(2)	Jacking point support	HLE	1.8

II - PART FITTED

1 - Partial replacement



102857

It is possible to cut in area (X1) .

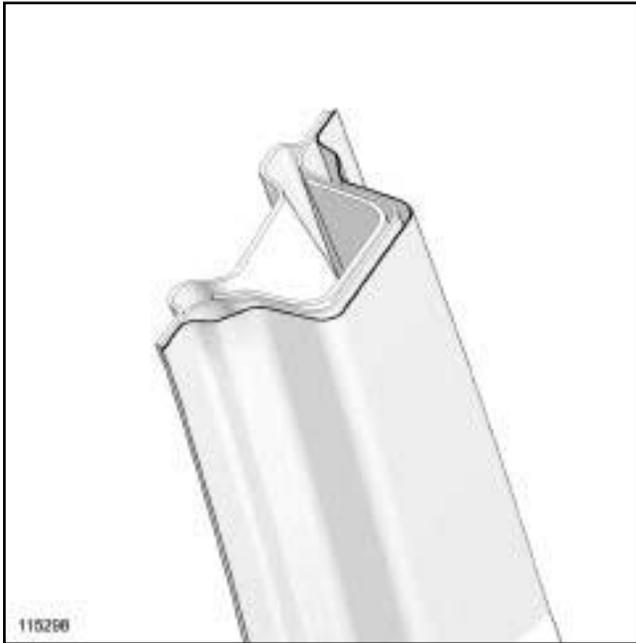
SIDE UPPER STRUCTURE

B-pillar: Description

43A

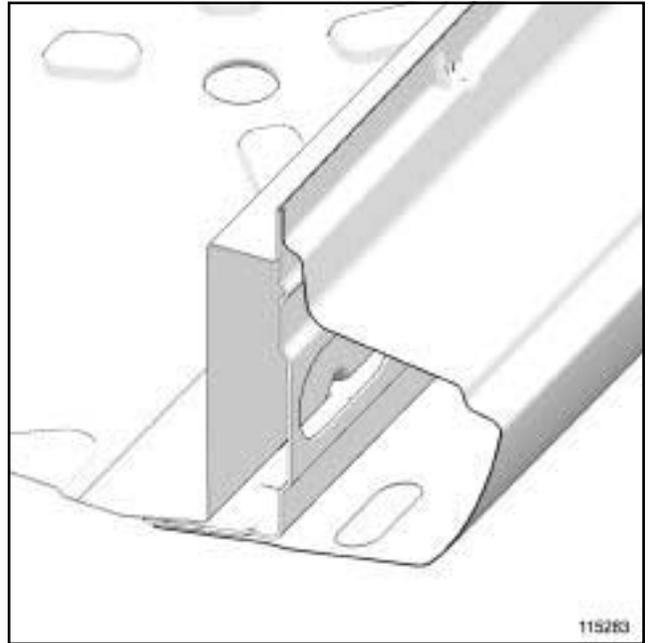
B84

Cut A



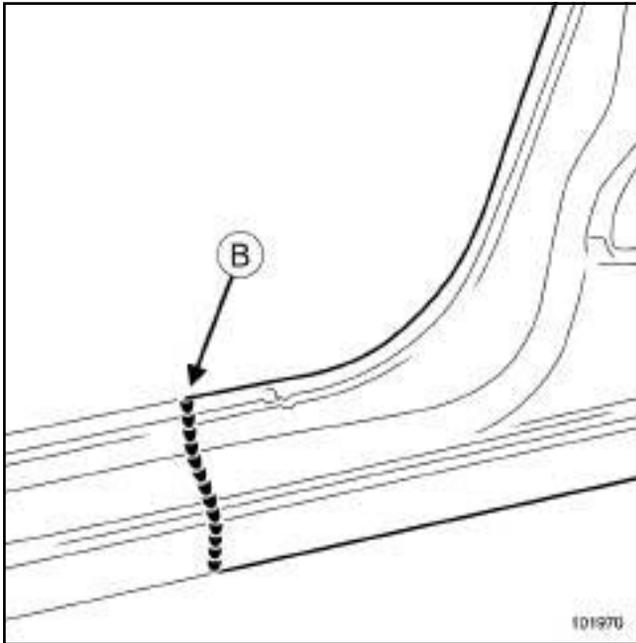
115298

Cut B

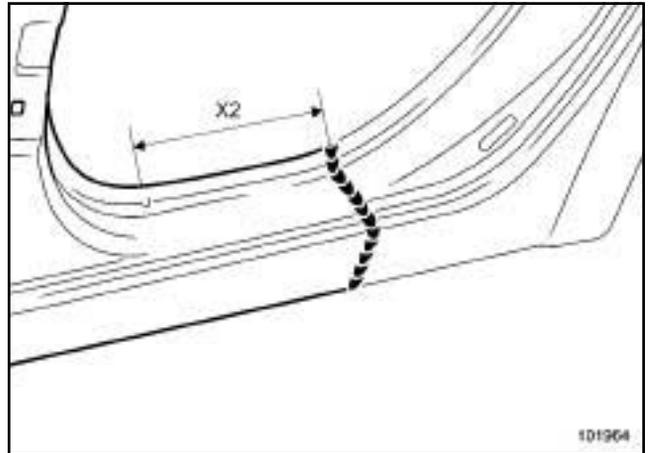


115283

115283



101970



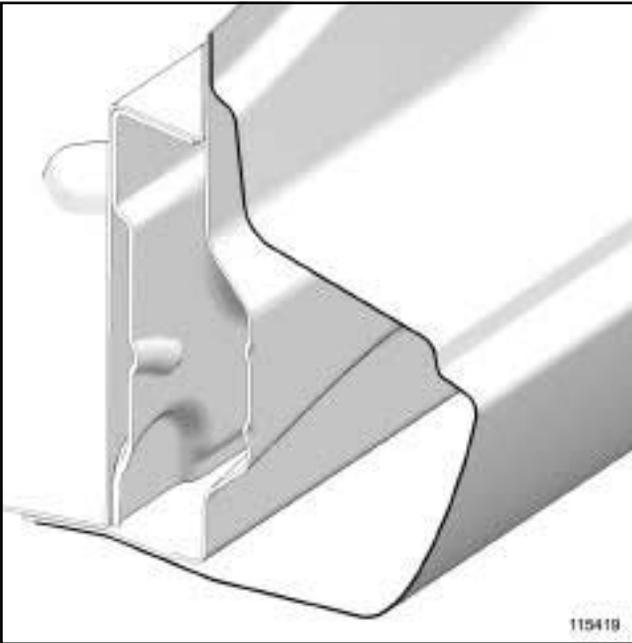
101964

101964

It is possible to cut along the whole length of the sill panel.

B84

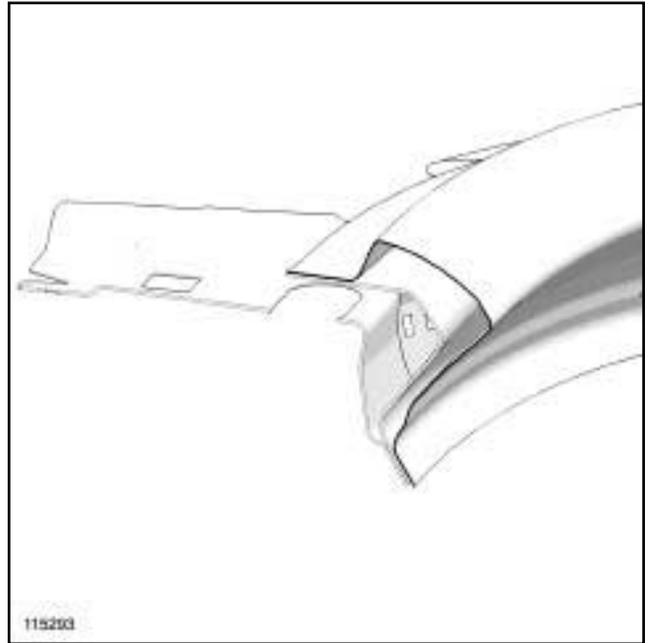
Cut C



115419

115419

Cut D



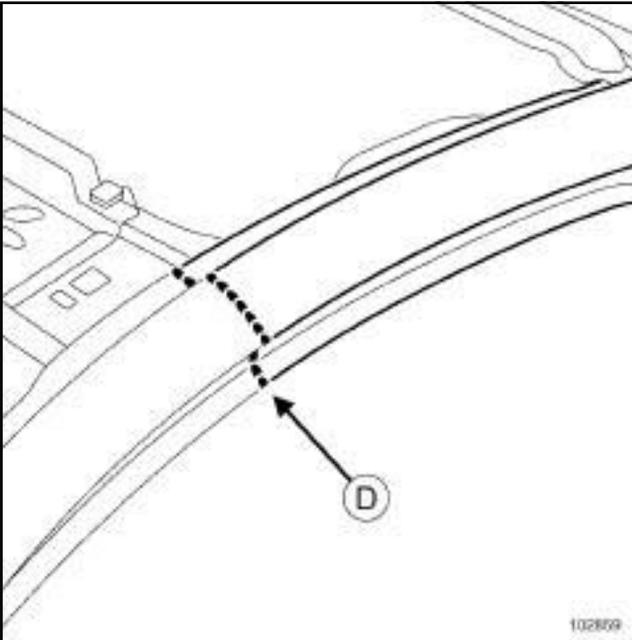
115293

115293

Note:

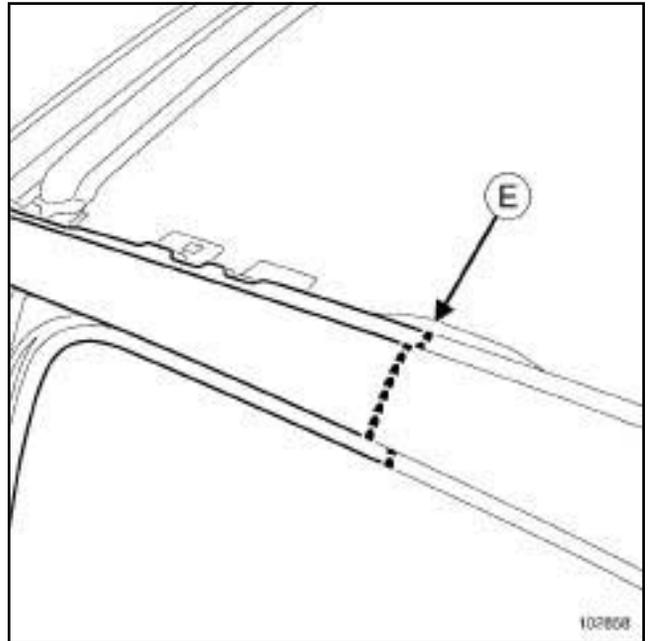
Make the cut outside area (X2) to avoid cutting into the impact absorbing unit and the expanding insert.

2 - Complete replacement



102859

102859



102858

102858

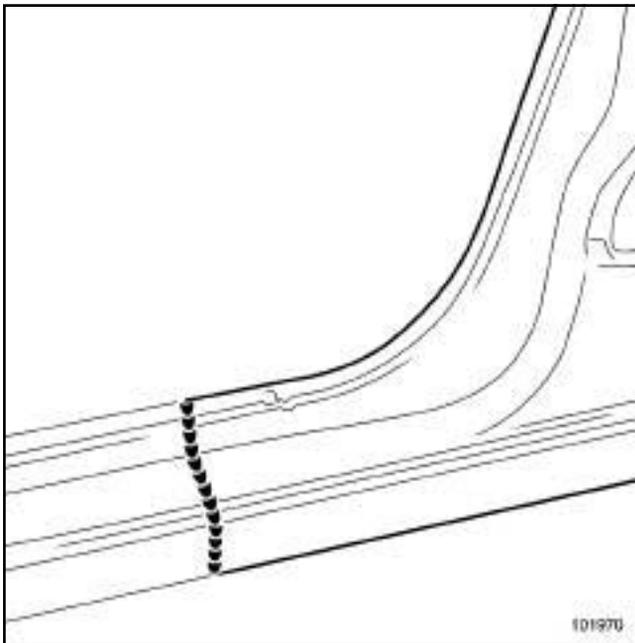
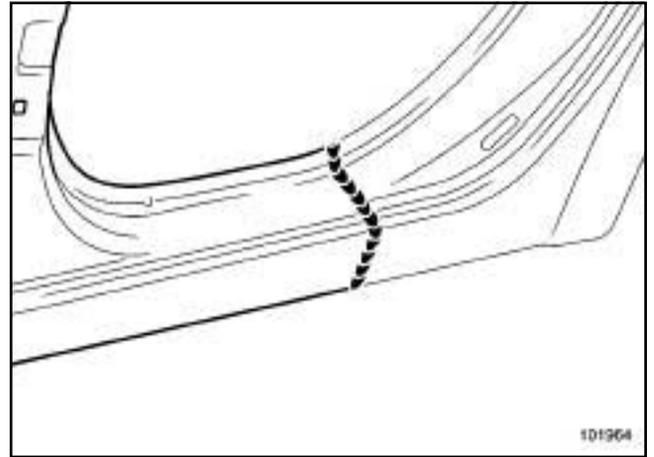
SIDE UPPER STRUCTURE

B-pillar: Description

43A

B84

Cut E



WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

B-pillar reinforcement: General description

B84 or C84

WARNING

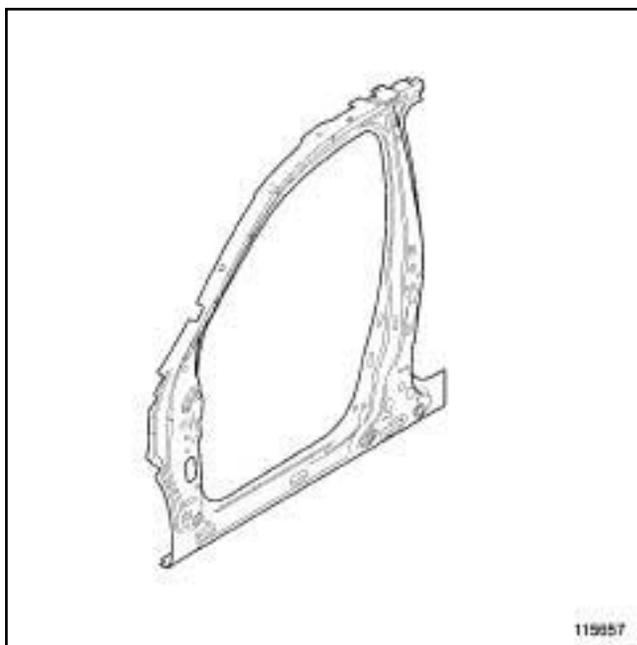
The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information**.

I - DESIGN OF THE STRUCTURAL COMPONENT



115657

The special feature of this part is that it combines several functions:

- B-pillar reinforcement,
- A-pillar reinforcement
- sill panel reinforcement,
- body side front section reinforcement.

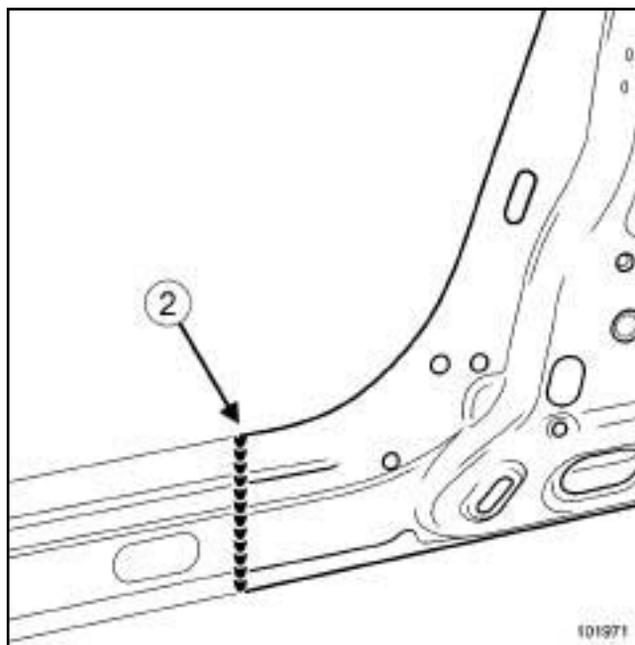
II - ASSEMBLY INSTRUCTIONS FOR A PARTIAL REPLACEMENT

Only the connecting pieces relevant to partial replacement by cutting are shown.

WARNING

If the spot welds cannot be made as they were originally using an electric spot welding machine, they should be replaced with plug welds after holes have been drilled in the first panel.

If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400, 40A, General Information**).



101971

Line (2) of the diagram shows a butt weld by continuous MAG welding.

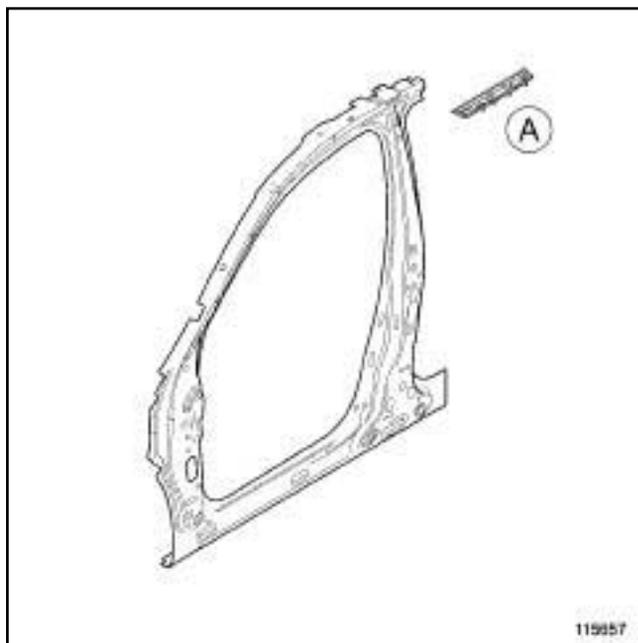
SIDE UPPER STRUCTURE

B-pillar reinforcement: Description

43A

B84 or C84

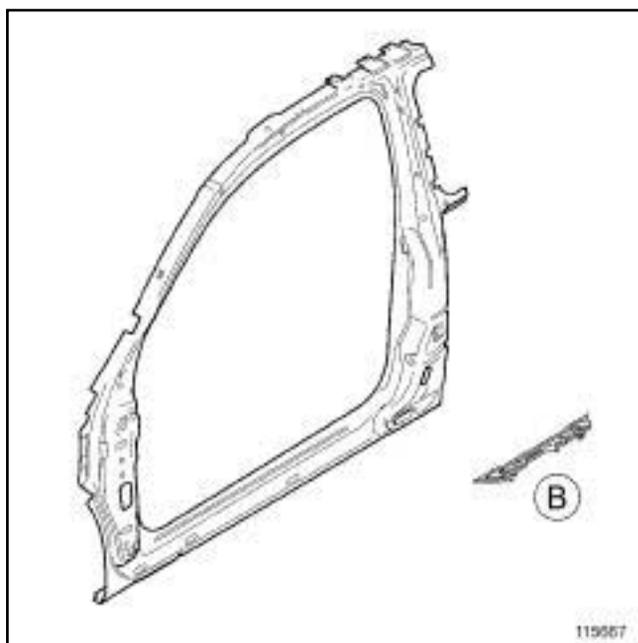
B84



115657

To replace this part, order the expanding insert (A) .

C84



115667

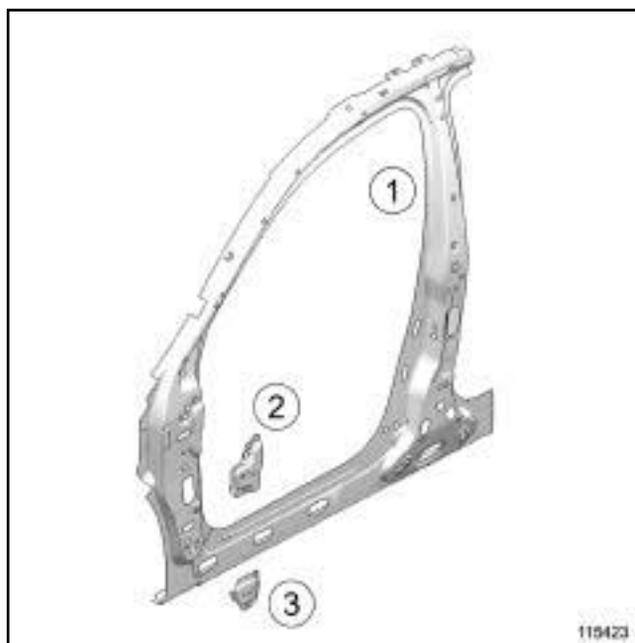
To replace this part, order the expanding insert (B) .

There is only one way of replacing this part:

- partial replacement.

I - COMPOSITION OF THE SPARE PART

B84



115423

115423

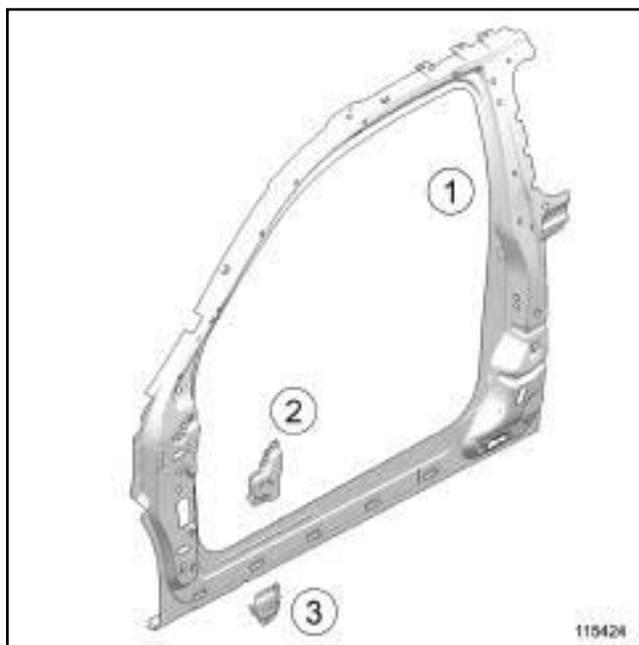
SIDE UPPER STRUCTURE

B-pillar reinforcement: Description

43A

B84 or C84

C84

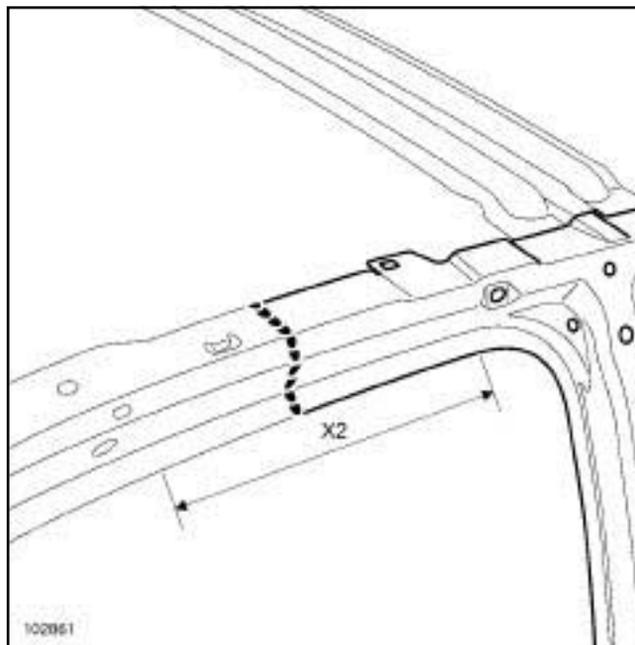


115424

II - PART FITTED

Partial replacement

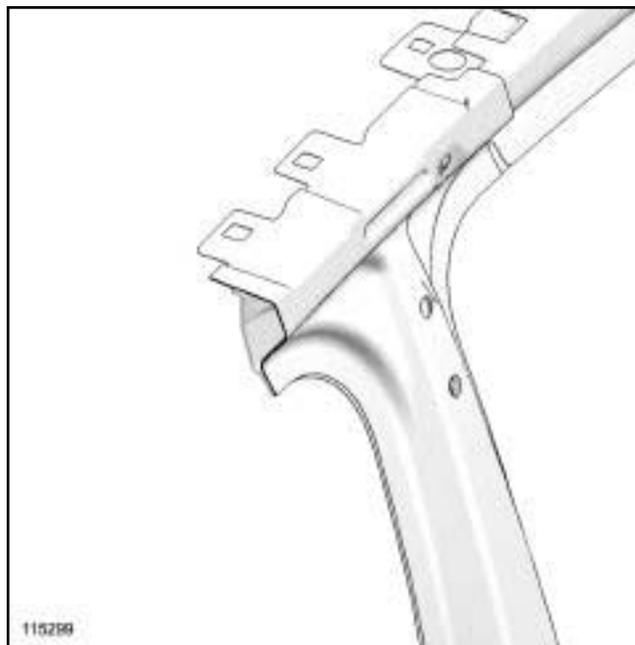
B84



102861

It is possible to make the cut in area (X1) .

Cut A



115299

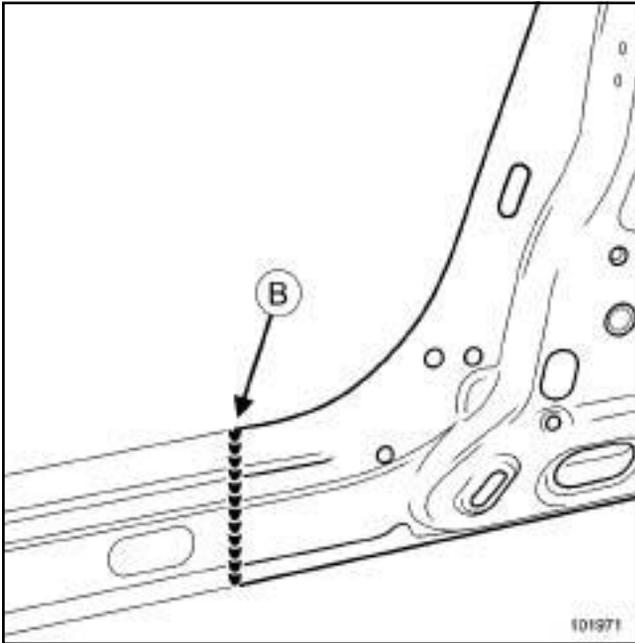
Number	Description	Type	Thic- kness (mm)
(1)	Body side rein- forcement	HLE	1.2
(2)	Upper hinge reinforcement	HLE	2
(3)	Lower hinge reinforcement	THLE	2

SIDE UPPER STRUCTURE

B-pillar reinforcement: Description

43A

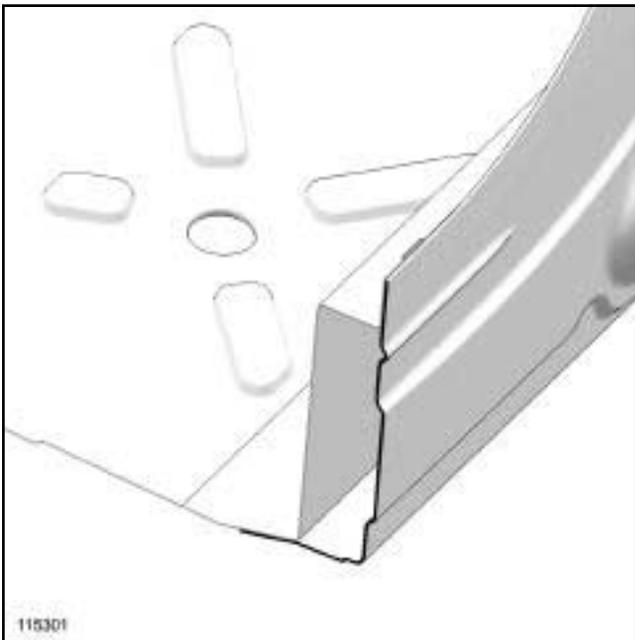
B84 or C84



101971

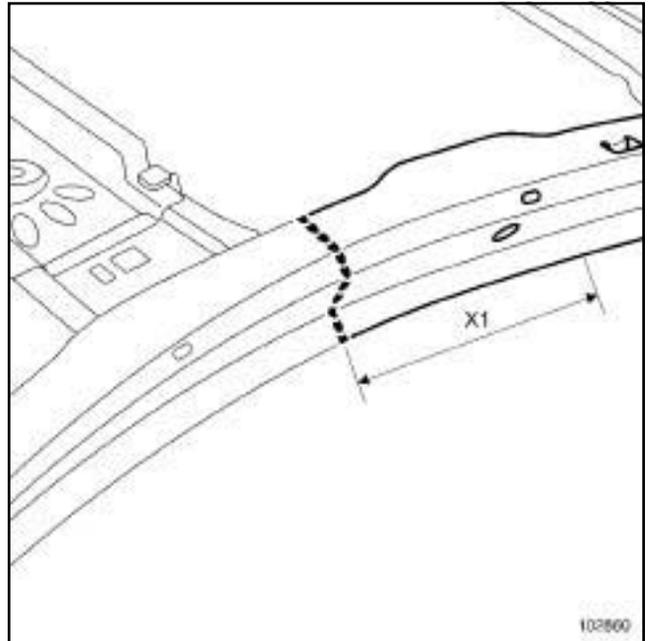
It is possible to make the cut along the length of the sill panel reinforcement.

Cut B



115301

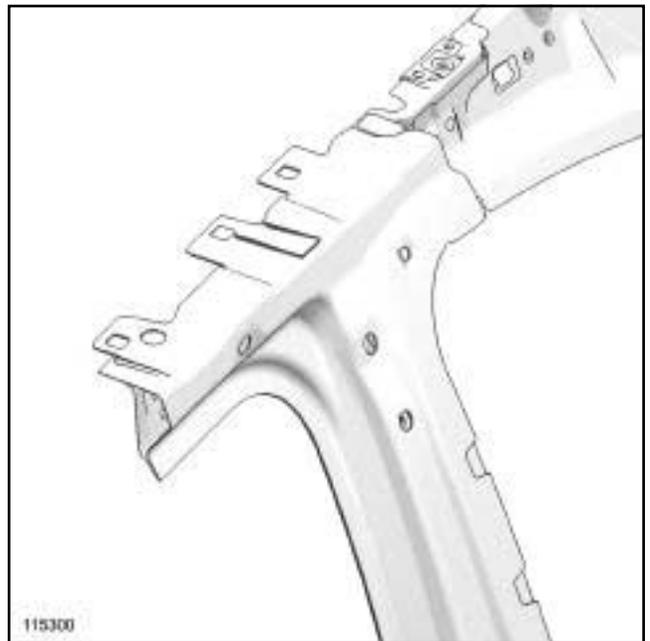
C84



102860

It is possible to make the cut in area (X3) .

Cut C



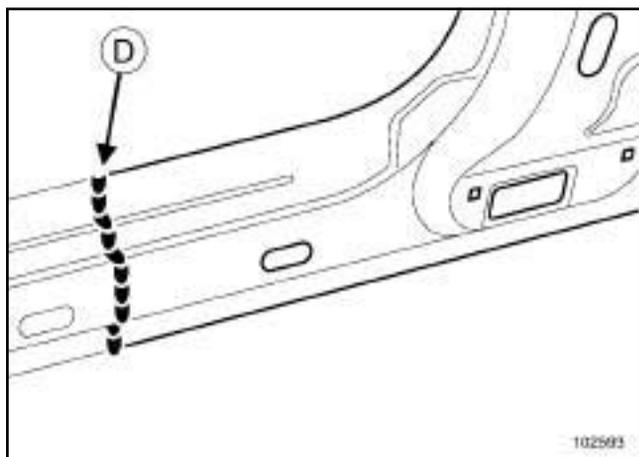
115300

SIDE UPPER STRUCTURE

B-pillar reinforcement: Description

43A

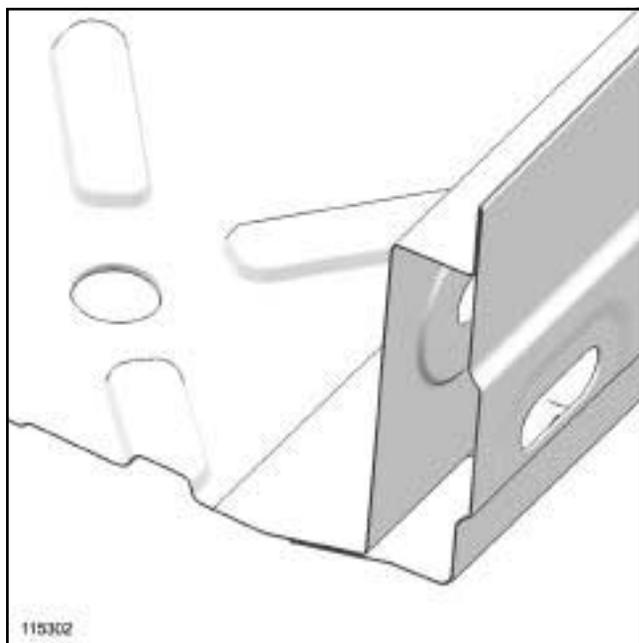
B84 or C84



102593

It is possible to make the cut along the length of the sill panel reinforcement.

Cut D



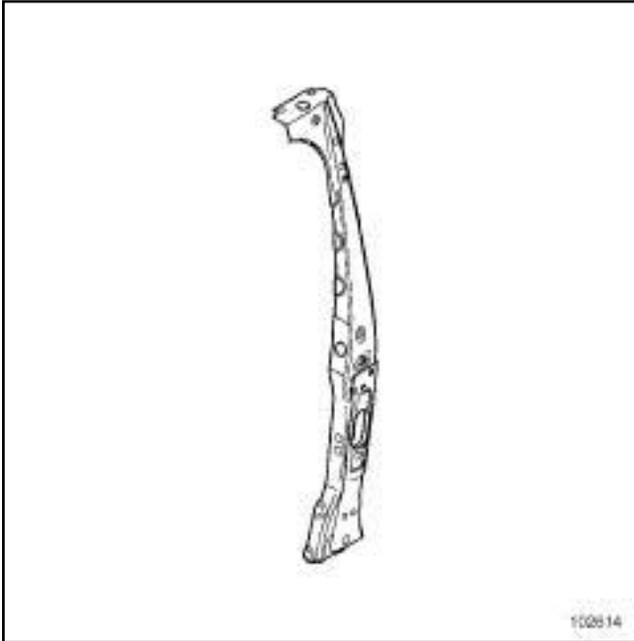
115302

WARNING

If the spot welds cannot be made as they were originally using an electric spot welding machine, they should be replaced with plug welds after holes have been drilled in the first panel.

B84 or C84

B84



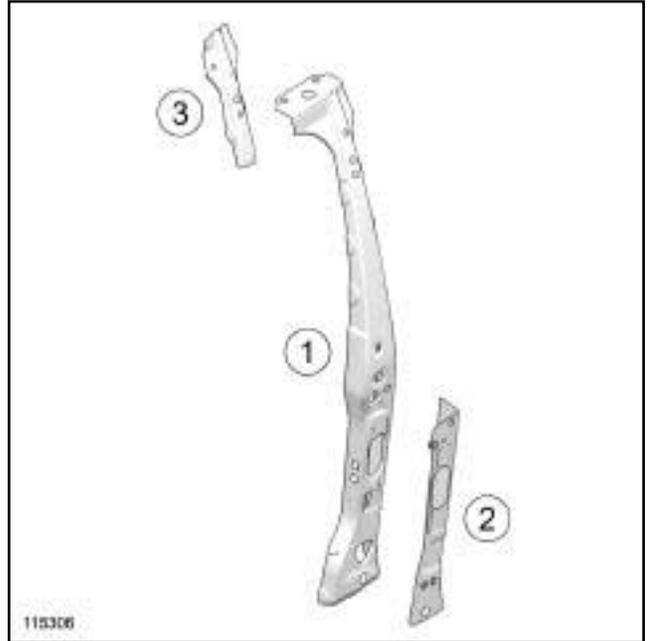
102614

There is only one way of replacing this part:

- complete replacement: this operation supplements the replacement of the B-pillar reinforcement.

I - COMPOSITION OF THE SPARE PART

B84



115306

Number	Description	Type	Thickness (mm)
(1)	B-pillar impact reinforcement	HLE	2.2
(2)	B-pillar reinforcement central stiffener	HLE	1.5
(3)	B-pillar reinforcement upper stiffener	HLE	2

SIDE UPPER STRUCTURE

B-pillar reinforcement stiffener: Description

43A

B84 or C84

C84

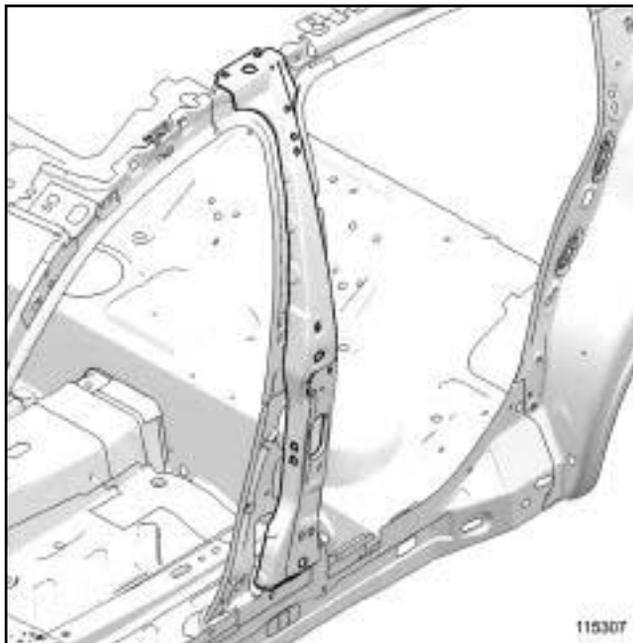


102609

II - PART FITTED

Complete replacement

B84

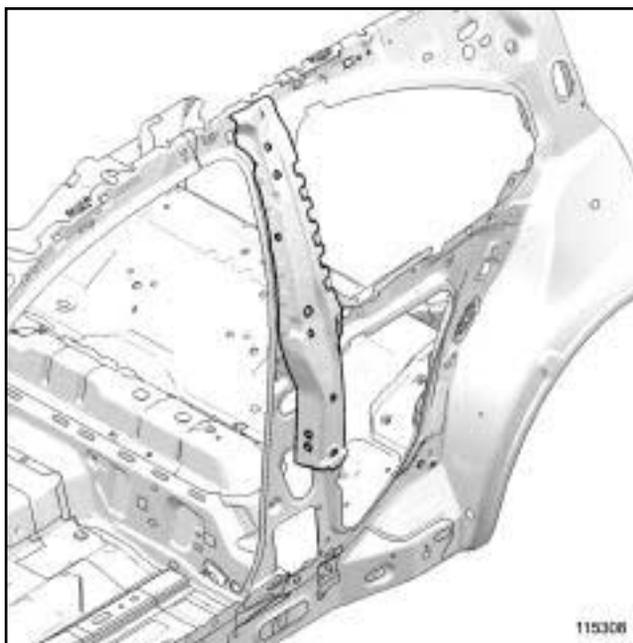


115307

115307

Number	Description	Type	Thic- kness (mm)
(4)	B-pillar reinforce- ment stiffener	THLE	1.8

C84



115308

115308

B-pillar reinforcement stiffener: Description

B84 or C84

WARNING

If the spot welds cannot be made as they were originally using an electric spot welding machine, they should be replaced with plug welds after holes have been drilled in the first panel.

SIDE UPPER STRUCTURE

B-pillar lining: General description

43A

B84 or C84

WARNING

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information**.

DESIGN OF THE STRUCTURAL COMPONENT

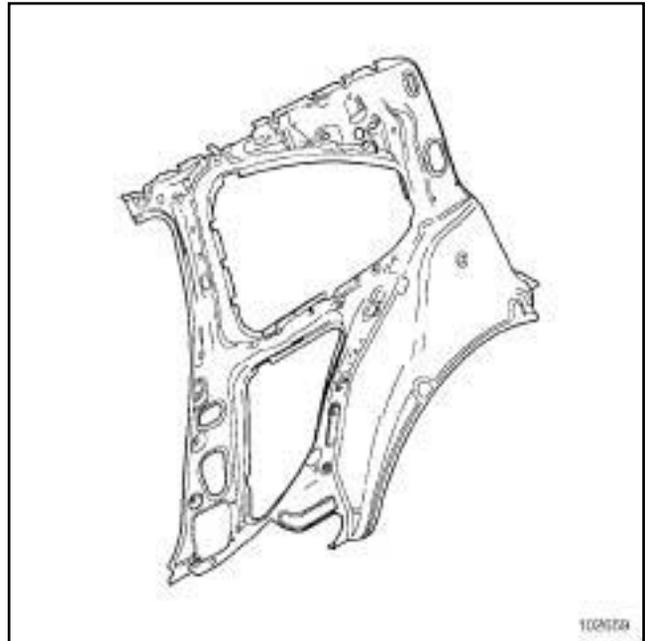
B84



102615

This is a basic part, its only function is that of the B-pillar lining.

C84



102659

The special feature of this part is that it is extended from the rear quarter lining.

WARNING

If the spot welds cannot be made as they were originally using an electric spot welding machine, they should be replaced with plug welds after holes have been drilled in the first panel.

SIDE UPPER STRUCTURE

B-pillar lining: Description

43A

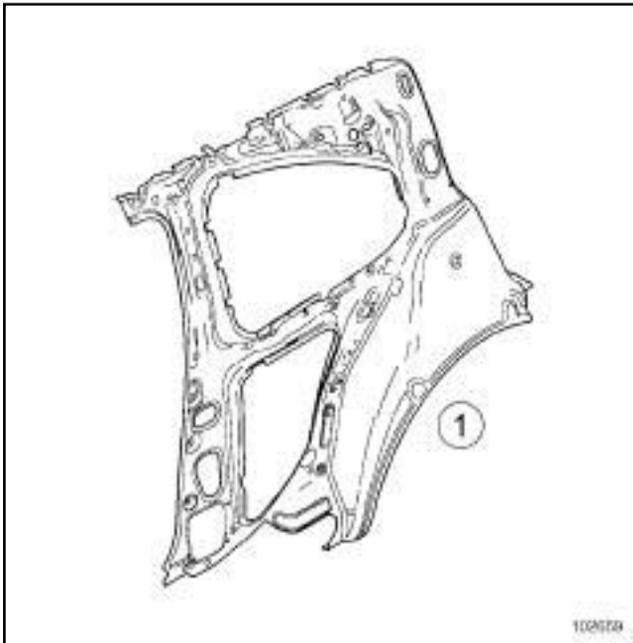
C84

To replace this part, order the complete rear quarter lining.

There is only one way of replacing this part:

- partial replacement: this operation supplements the replacement of the B-pillar reinforcement.

I - COMPOSITION OF THE SPARE PART



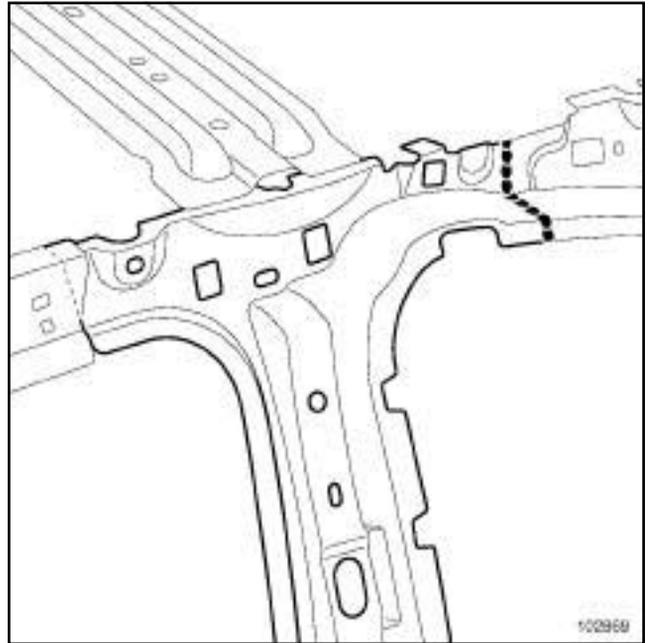
102659

Number	Description	Type	Thickness (mm)
(1)	Quarter panel lining	-	0.6

WARNING

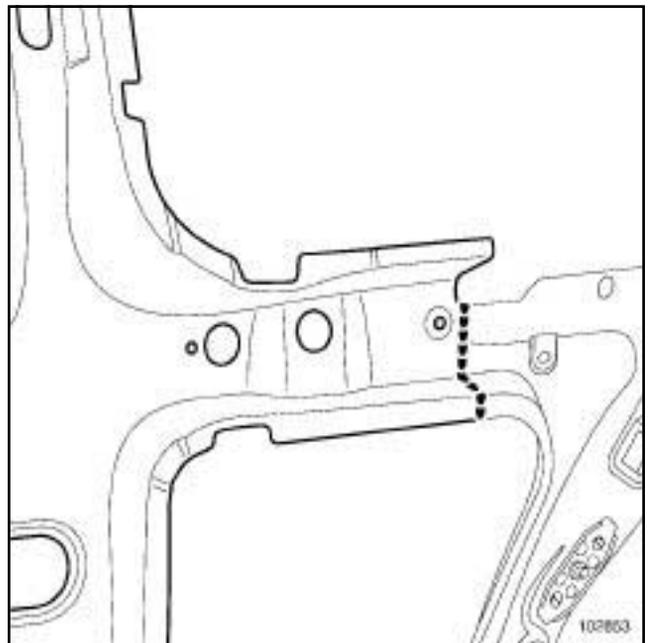
If the spot welds cannot be made as they were originally using an electric spot welding machine, they should be replaced with plug welds after holes have been drilled in the first panel.

II - PART FITTED



102869

102869



102863

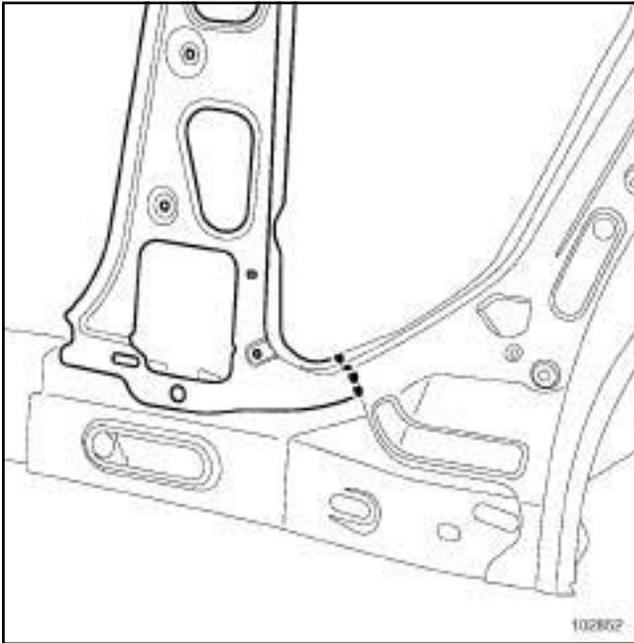
102853

SIDE UPPER STRUCTURE

B-pillar lining: Description

43A

C84



102852

WARNING

The position of this cut must be observed, and is determined according to the position of the internal reinforcements or acoustic inserts cut.

SIDE UPPER STRUCTURE

B-pillar lower lining: Description

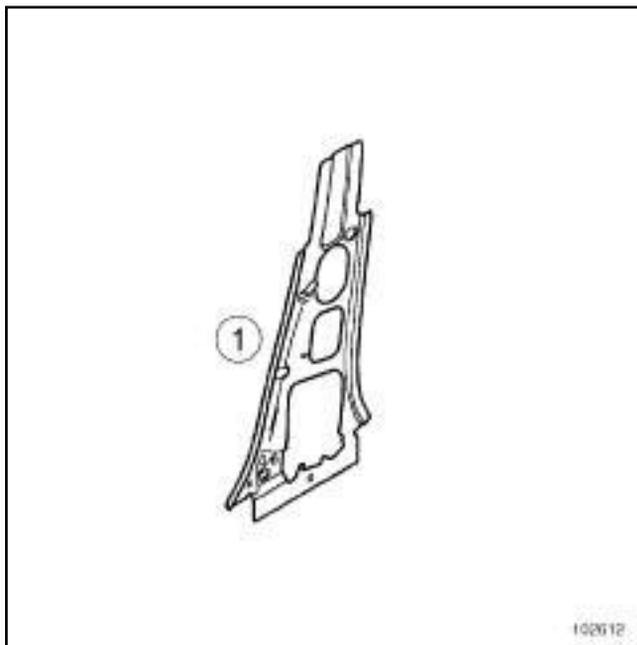
43A

B84

There is only one way of replacing this part:

- complete replacement: this operation supplements the replacement of the B-pillar reinforcement after a side impact.

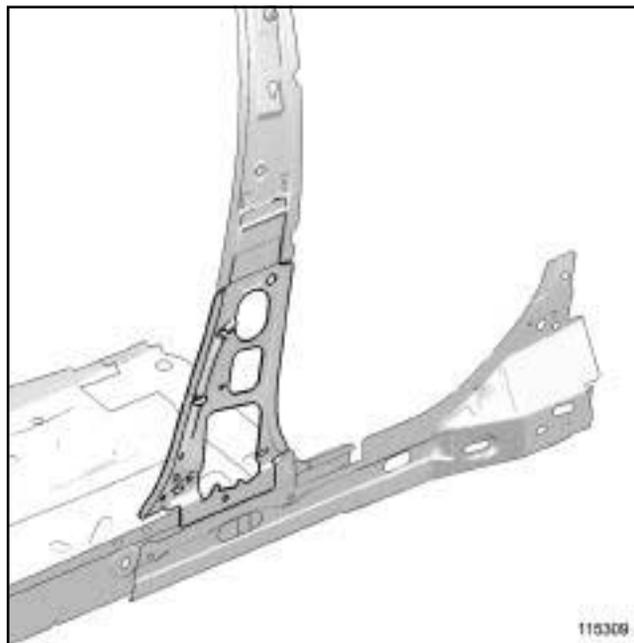
I - COMPOSITION OF THE SPARE PART



102612

II - PART FITTED

Complete replacement



115309

WARNING

If the spot welds cannot be made as they were originally using an electric spot welding machine, they should be replaced with plug welds after holes have been drilled in the first panel.

Number	Description	Type	Thickness (mm)
(1)	B-pillar lower lining	-	0.7

SIDE UPPER STRUCTURE

B-pillar upper lining: Description

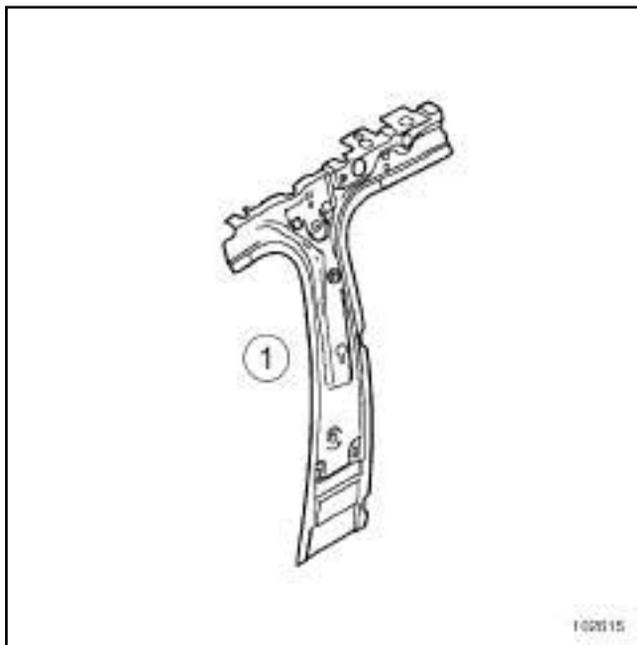
43A

B84

There is only one way of replacing this part:

- complete replacement: this operation supplements the replacement of the B-pillar reinforcement after a side impact.

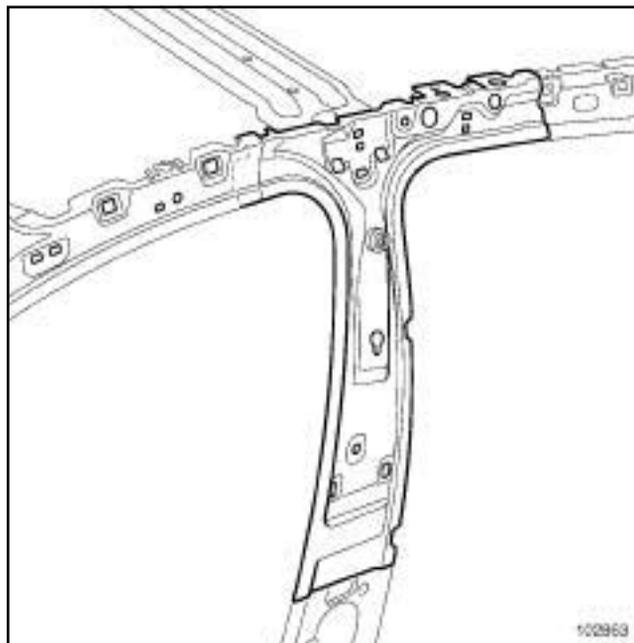
I - COMPOSITION OF THE SPARE PART



102615

II - PART FITTED

Complete replacement



102863

WARNING

If the spot welds cannot be made as they were originally using an electric spot welding machine, they should be replaced with plug welds after holes have been drilled in the first panel.

Number	Description	Type	Thickness (mm)
(1)	B-pillar upper lining	HLE	1.5

Body side front section: General description

B84 or C84

WARNING

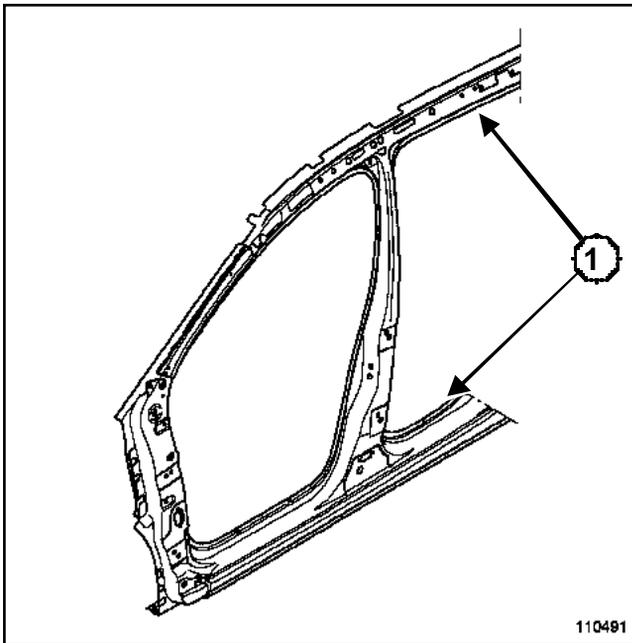
The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information**.

DESIGN OF THE STRUCTURAL COMPONENT



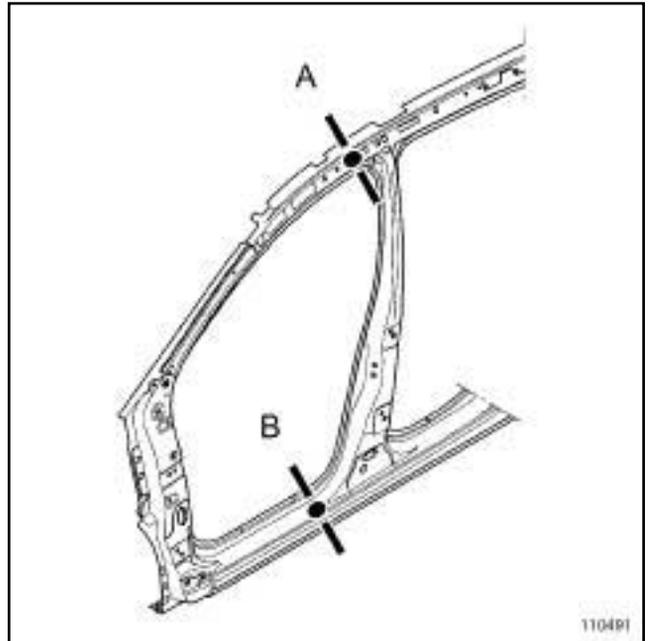
110491

110491

This part has two special features:

- it is welded under the roof,
- it is butt welded at section (1).

C84



110491

110491

This part is obtained by removing the front section of the body side, 5-door version.

WARNING

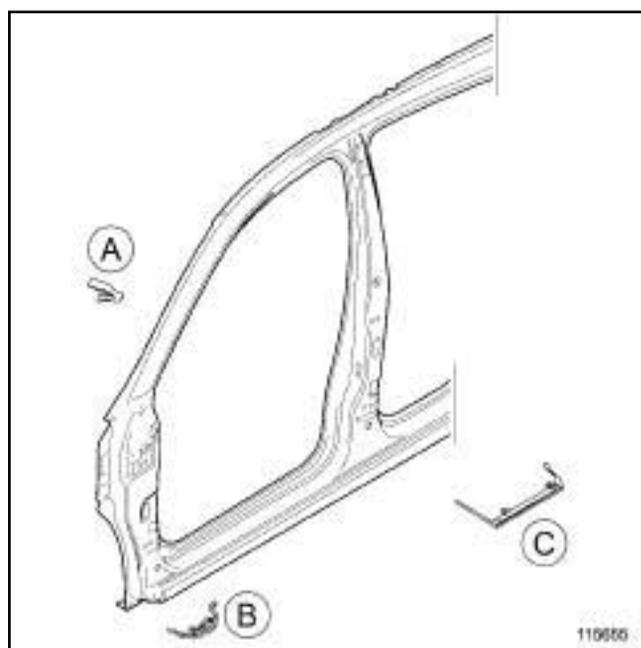
If the spot welds cannot be made as they were originally using an electric spot welding machine, they should be replaced with plug welds after holes have been drilled in the first panel.

SIDE UPPER STRUCTURE

Body side front section: Description

43A

B84 or C84



115655

Note:

The Parts Department only supplies the front section of the body sides for 5-door versions.

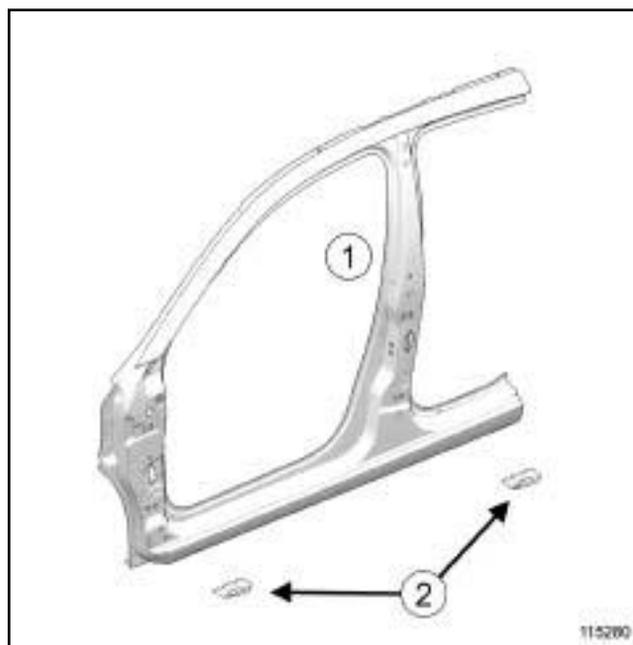
For 3-door versions, keep the section common to 5-door versions (A-pillar) and dispose of the B-pillar.

To replace this part, order expanding inserts (A) , (B) and (C) .

The options for replacing this part are as follows:

- partial replacement (3-door version),
- complete replacement (5-door version).

I - COMPOSITION OF THE SPARE PART



115280

Number	Description	Type	Thickness (mm)
(1)	Body side front section	-	0.7
(2)	Jacking point support	HLE	1.8

SIDE UPPER STRUCTURE

Body side front section: Description

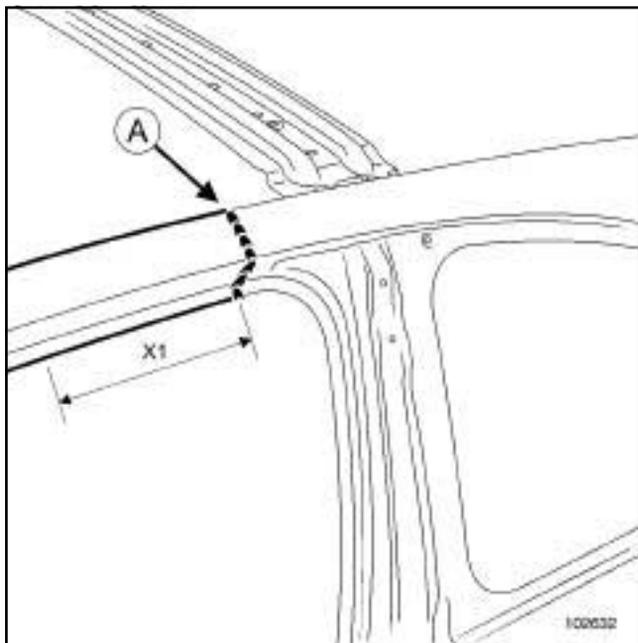
43A

B84 or C84

II - PART FITTED

1 - Partial replacement

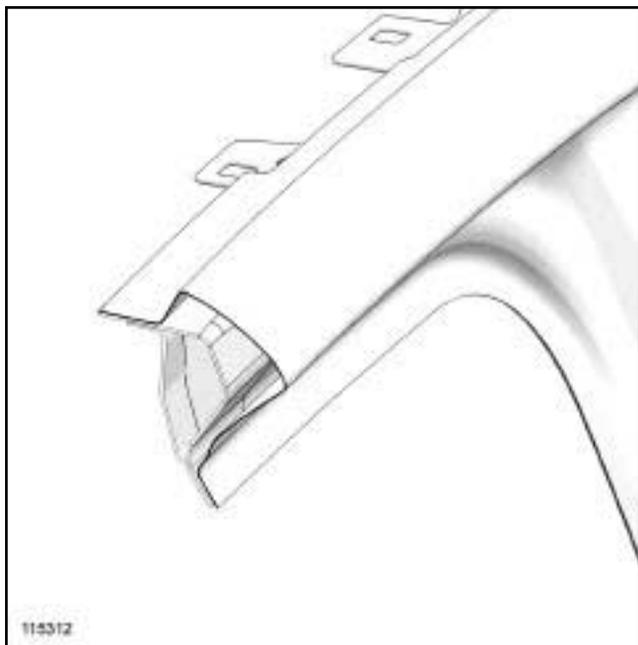
C84



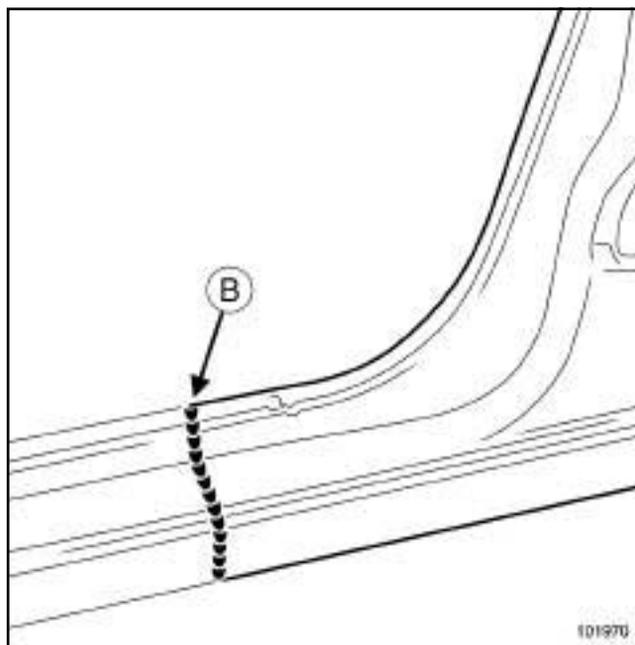
102632

It is possible to make the cut in area (X1) .

Cut A

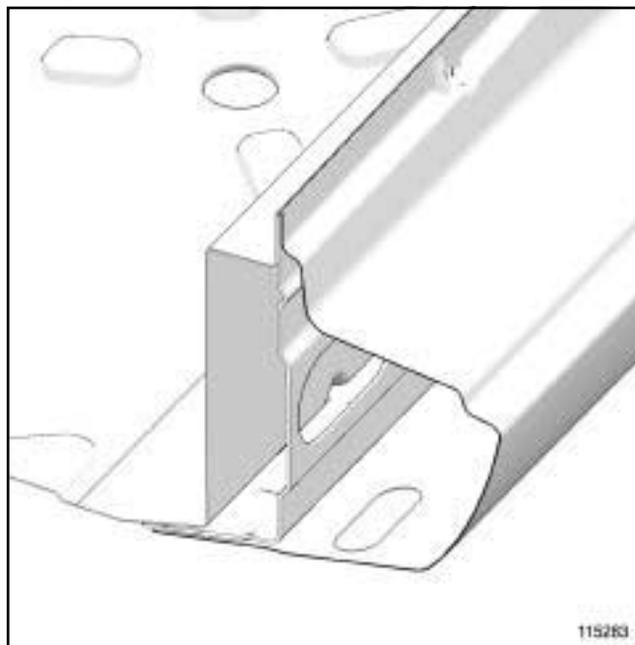


115312



101970

Cut B



115283

WARNING

If the spot welds cannot be made as they were originally using an electric spot welding machine, they should be replaced with plug welds after holes have been drilled in the first panel.

SIDE UPPER STRUCTURE

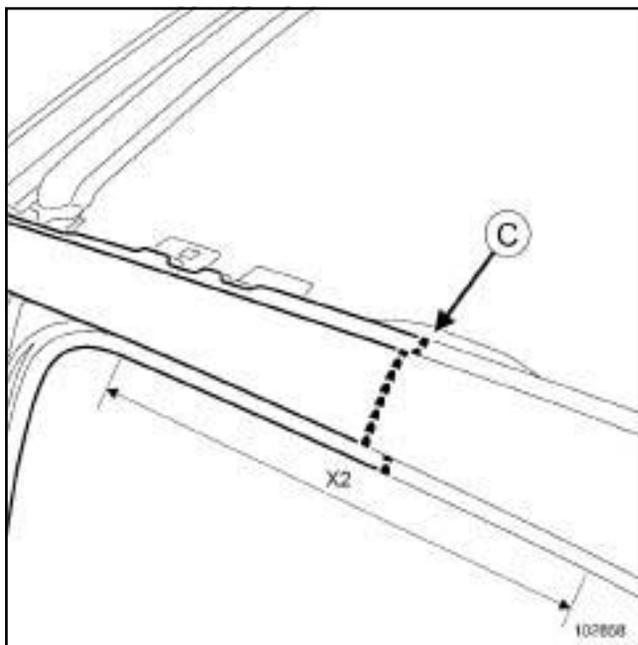
Body side front section: Description

43A

B84 or C84

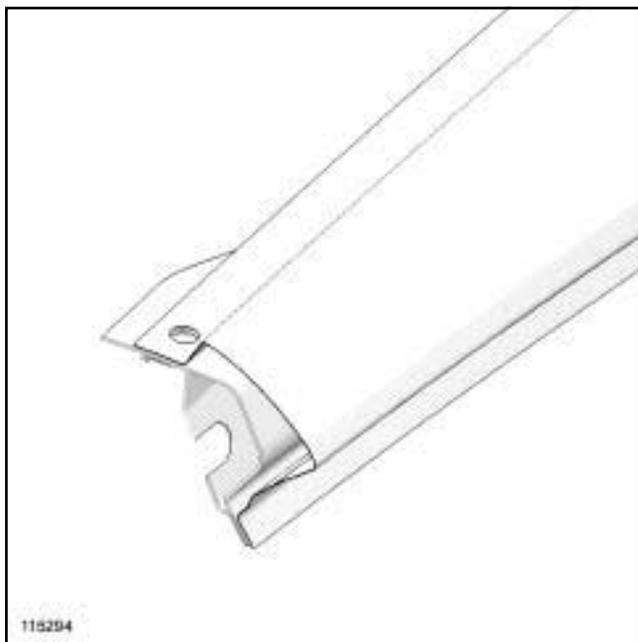
2 - Complete replacement

B84

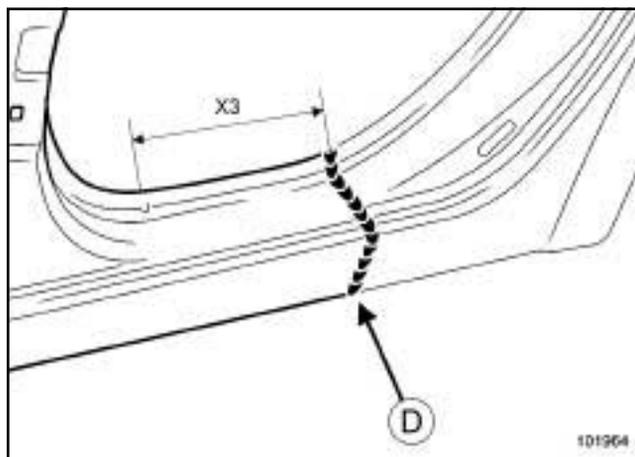


It is possible to make the cut in area (X2) .

Cut C



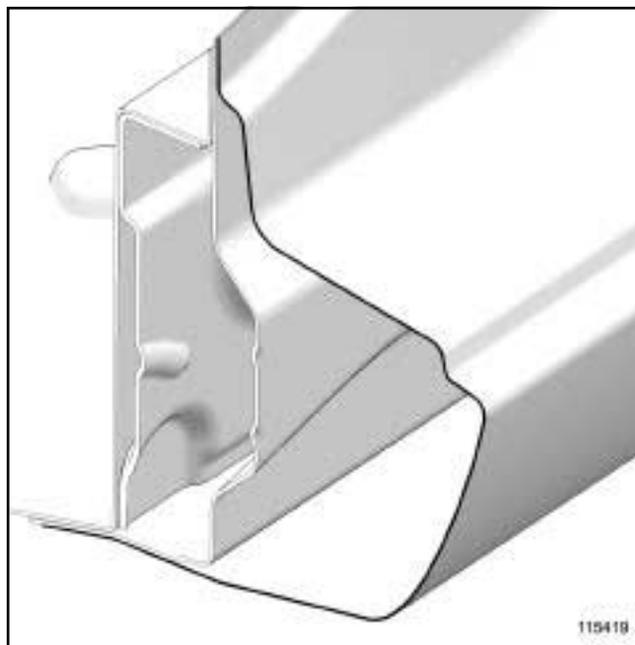
115294



101964

It is possible to make the cut in area (X3) .

Cut D



115419

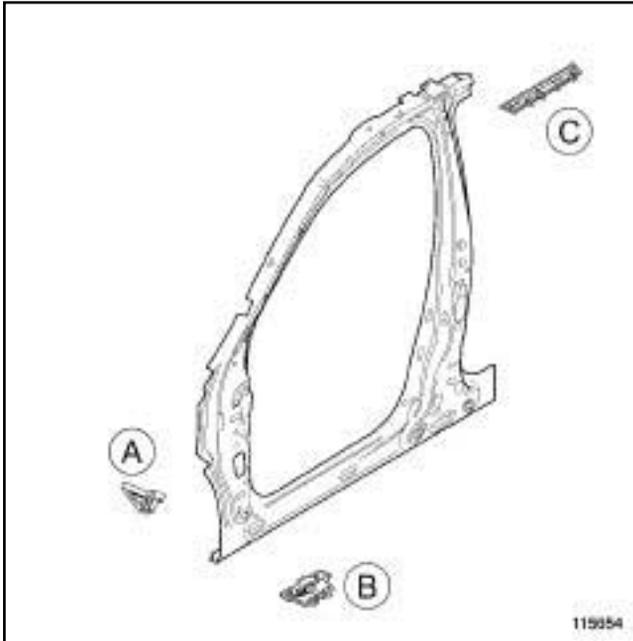
WARNING

The position of this cut must be observed, and is determined according to the position of the internal reinforcements or acoustic inserts cut.

Body side front section reinforcement: Description

B84 or C84

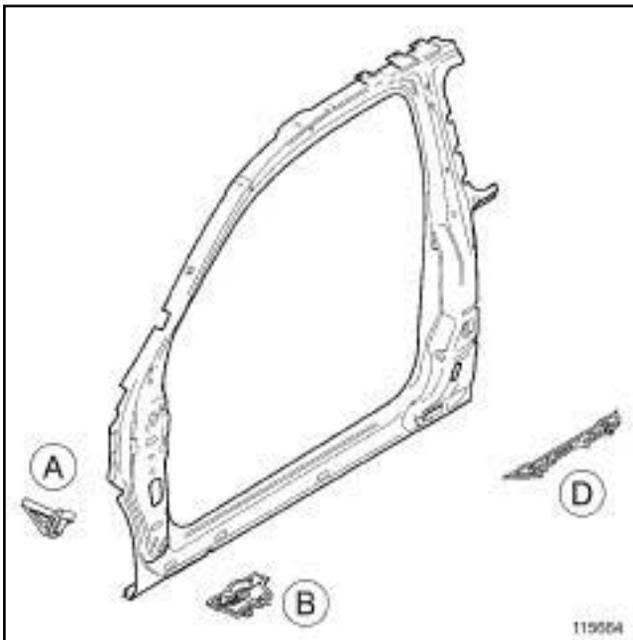
B84



115654

To carry out this operation, order expanding inserts (A), (B) and (C).

C84



115664

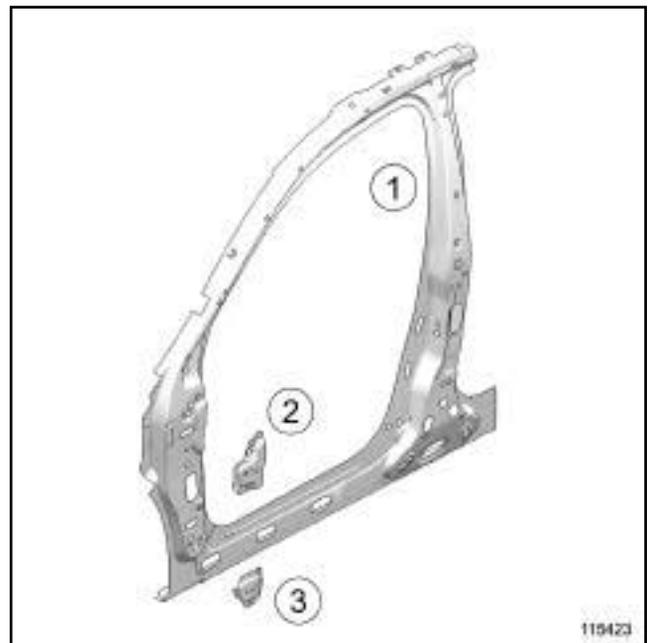
To carry out this operation, order expanding inserts (A), (B) and (D).

There is only one way of replacing this part:

- complete replacement: this operation supplements the replacement of the body side after a side impact.

I - COMPOSITION OF THE SPARE PART

B84



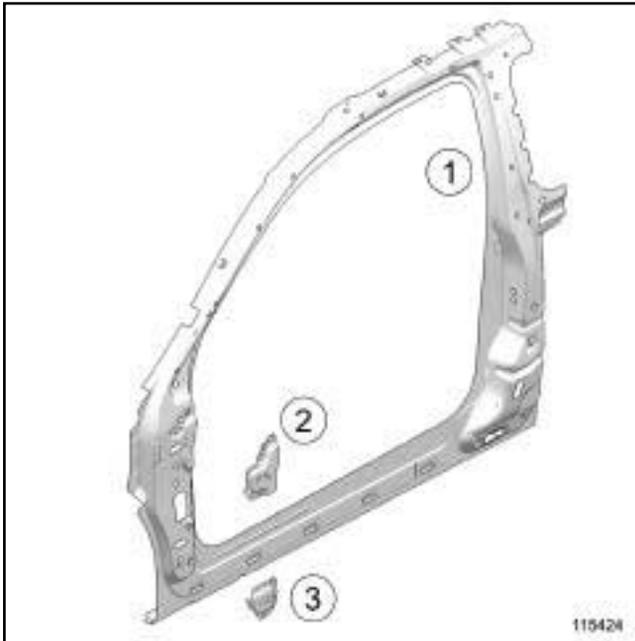
115423

115423

Body side front section reinforcement: Description

B84 or C84

C84

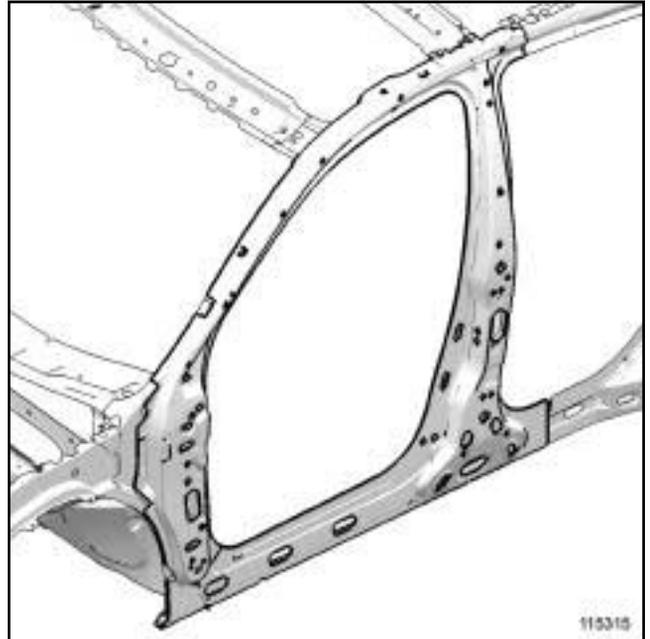


115424

II - PART FITTED

Complete replacement

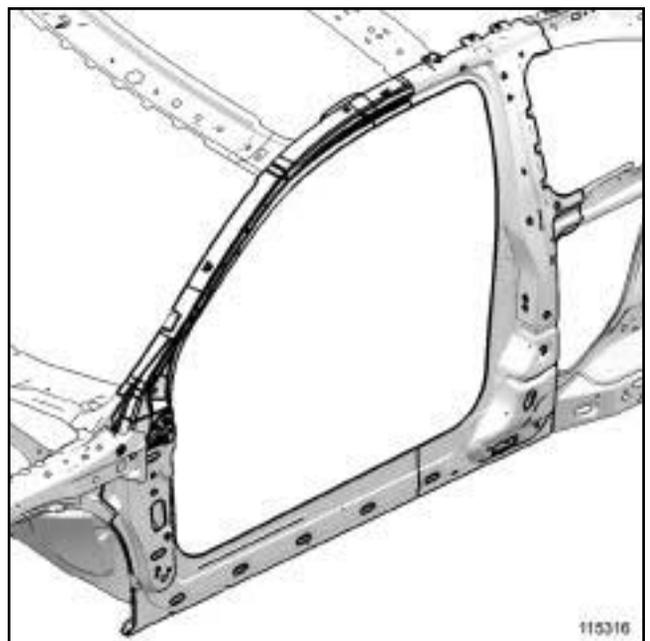
B84



115315

Number	Description	Type	Thickness (mm)
(1)	Body side reinforcement	HLE	1.2
(2)	Upper hinge reinforcement	THLE	2.5
(3)	Lower hinge reinforcement	THLE	2.5

C84



115316

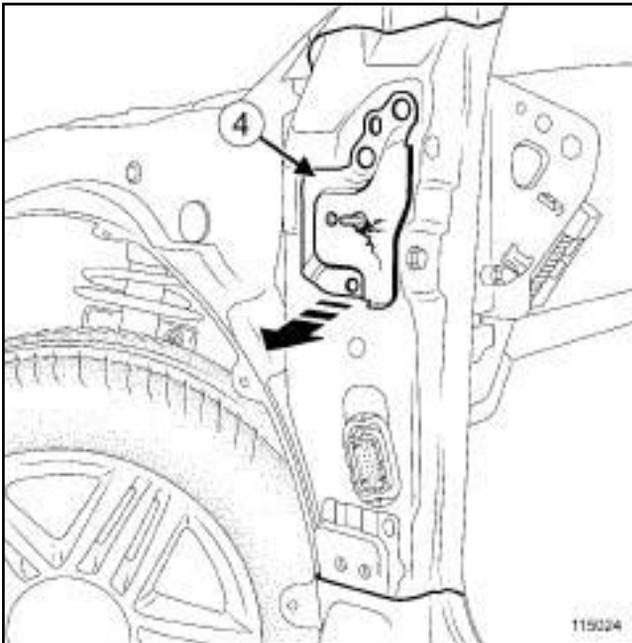
Body side front section reinforcement: Description

B84 or C84

WARNING

If the spot welds cannot be made as they were originally using an electric spot welding machine, they should be replaced with plug welds after holes have been drilled in the first panel.

III - REPLACEMENT OF THE UPPER HINGE REINFORCEMENT



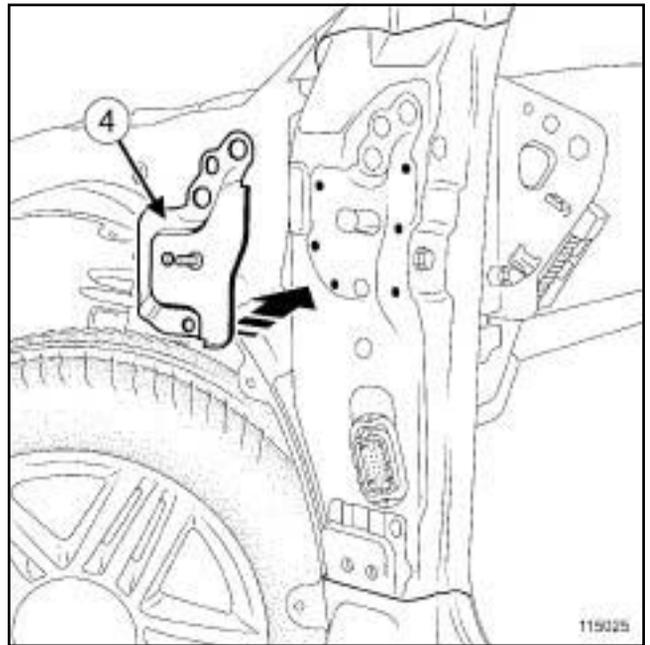
115024

Remove the welds from and then remove the upper hinge reinforcement (4) .

WARNING

Each time a panel is stripped in the workshop (e.g. when drilling), degrease and wipe the area and then use a fine paintbrush to apply the following:

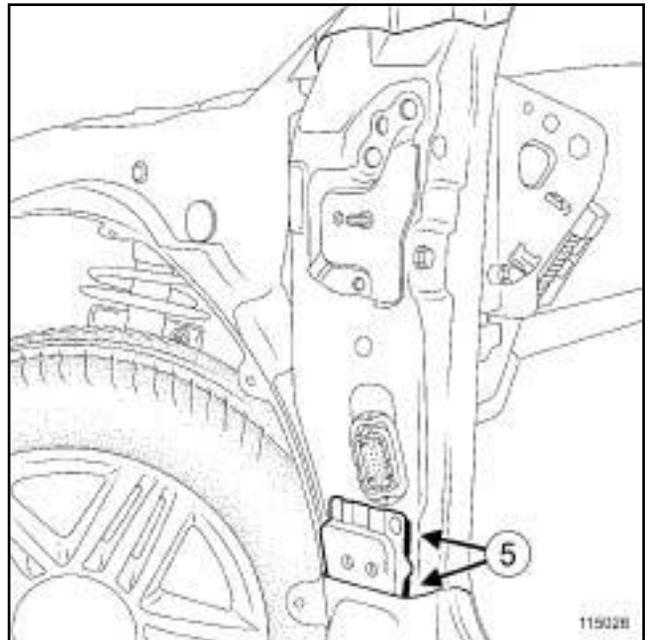
- a pre-treatment primer,
- a two-part primer,
- paint in the vehicle body colour.



115025

Position then weld the upper hinge reinforcement (4) with six plug welds, after drilling the replacement part.

IV - SPECIAL NOTE ON THE LOWER HINGE REINFORCEMENT



115026

On the lower hinge reinforcement, apply two securing beads (5) of 15 mm .

SIDE UPPER STRUCTURE

Upper body panel: General description

43A

B84 or C84

WARNING

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

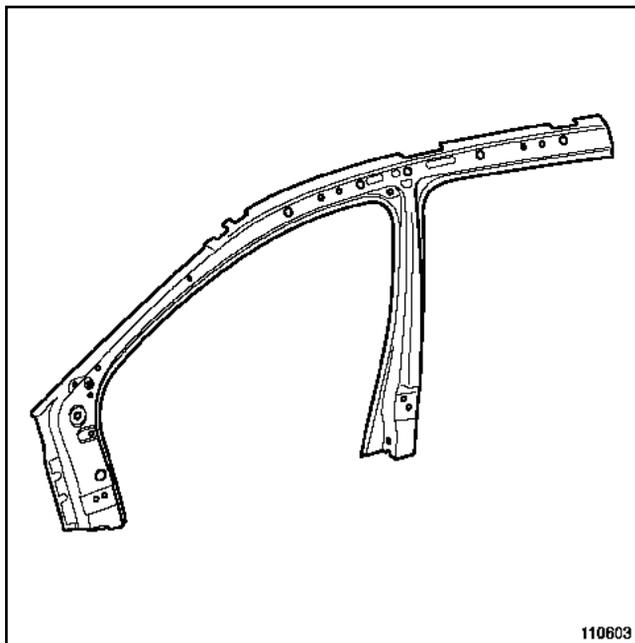
Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information**.

IMPORTANT

Before any operation, remove the front seat belts.

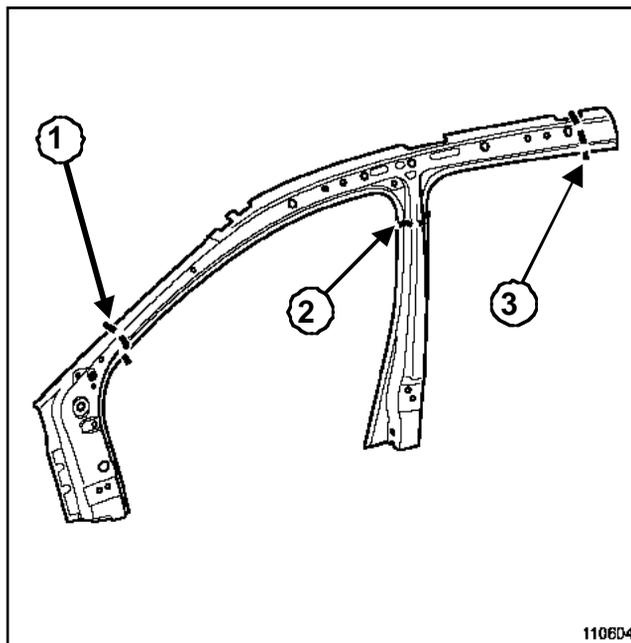
I - DESIGN OF THE STRUCTURAL COMPONENT



This is a basic part; its only function is that of an upper body.

II - AREA TO BE CUT FOR PARTIAL REPLACEMENT

B84



Lines (1), (2) and (3) in the illustration show the area in which a partial replacement may be carried out.

III - ASSEMBLY INSTRUCTIONS FOR A PARTIAL REPLACEMENT

B84

Only the connecting pieces relevant to partial replacement by cutting are shown.

WARNING

If the spot welds cannot be made as they were originally using an electric spot welding machine, they should be replaced with plug welds after holes have been drilled in the first panel.

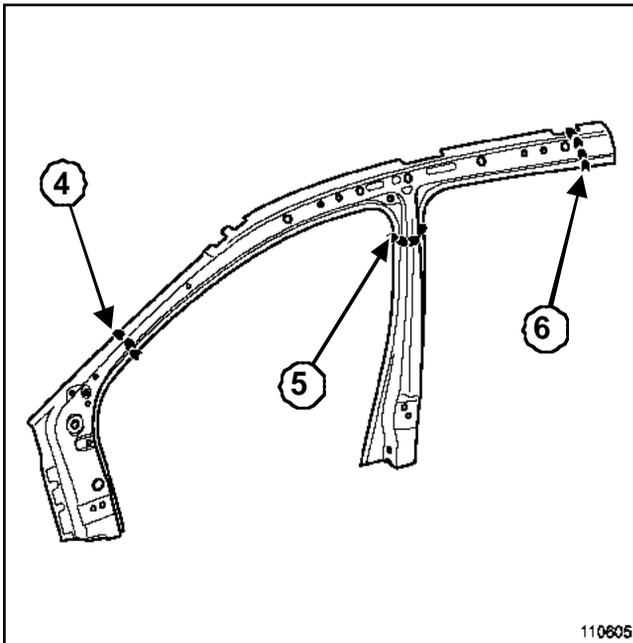
If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400, 40A, General Information**).

SIDE UPPER STRUCTURE

Upper body panel: General description

43A

B84 or C84



110605

110605

Lines (4) , (5) and (6) of the drawing show a butt weld by continuous MAG welding.

Weld (6) along the butt weld.

SIDE UPPER STRUCTURE

Upper body panel: Description

43A

B84 or C84

B84

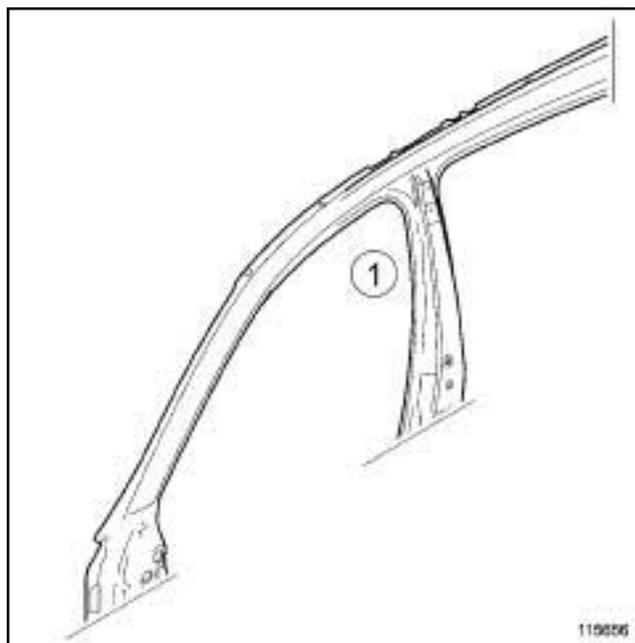


115656

There is only one way of replacing this part:
- partial replacement.

I - COMPOSITION OF THE SPARE PART

B84



115656

115656

C84



115666

115666

To replace this part, order the expanding insert (A).

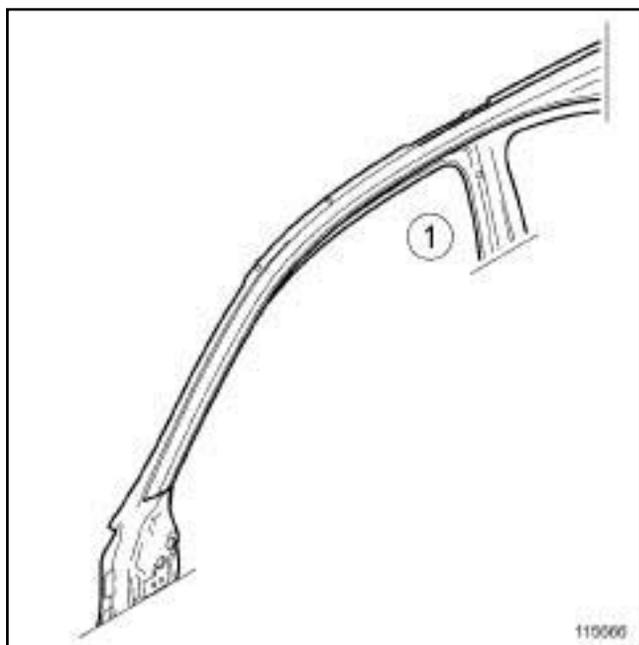
SIDE UPPER STRUCTURE

Upper body panel: Description

43A

B84 or C84

C84



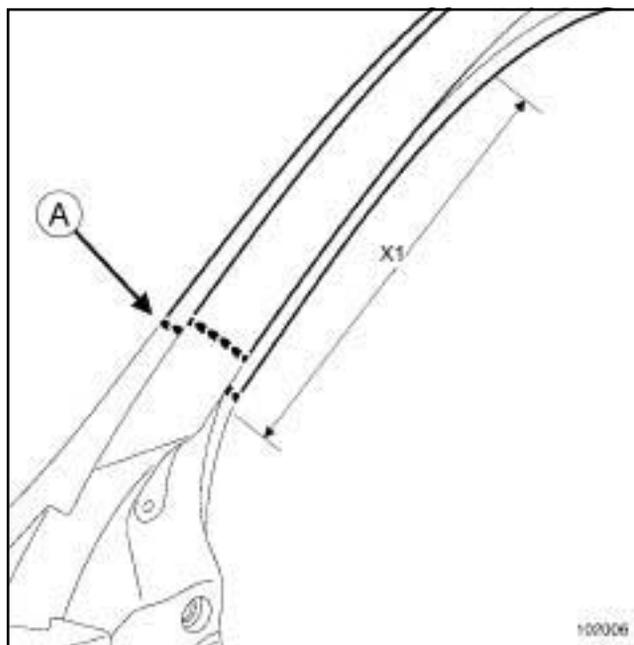
115566

115666

II - PART FITTED

Partial replacement

B84

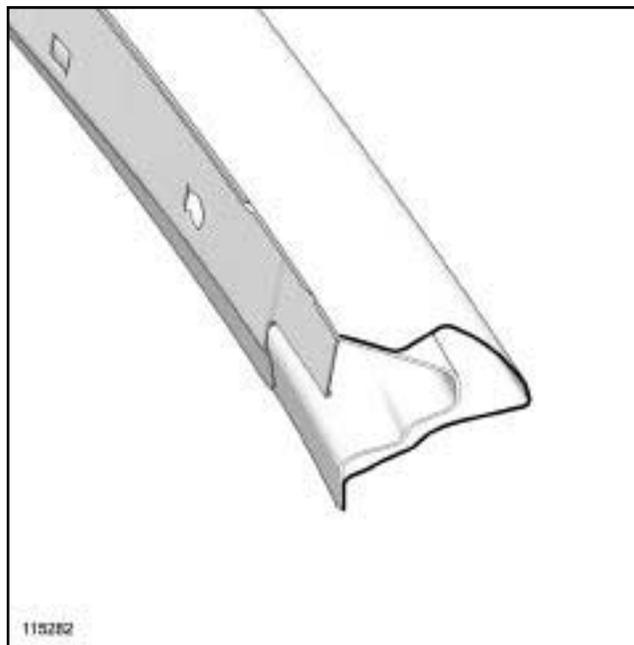


102006

102006

It is possible to make the cut in area (X1) .

Cut A



115282

115282

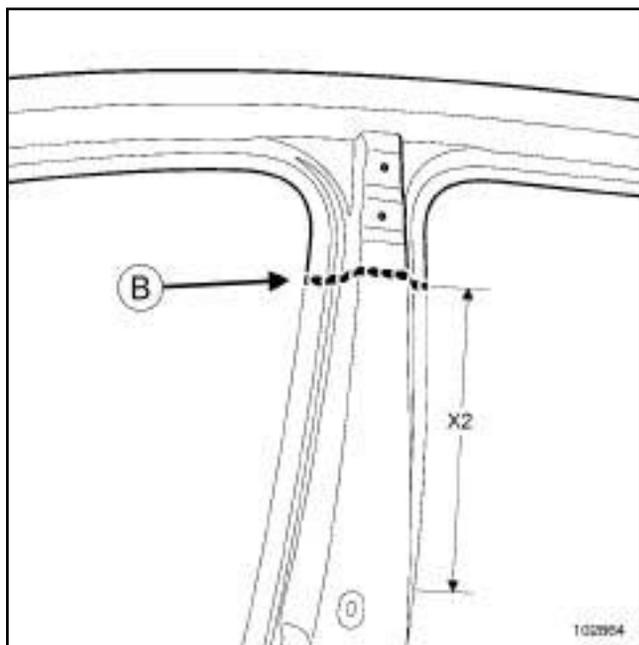
Number	Description	Type	Thickness (mm)
(1)	Upper body	-	0.7

SIDE UPPER STRUCTURE

Upper body panel: Description

43A

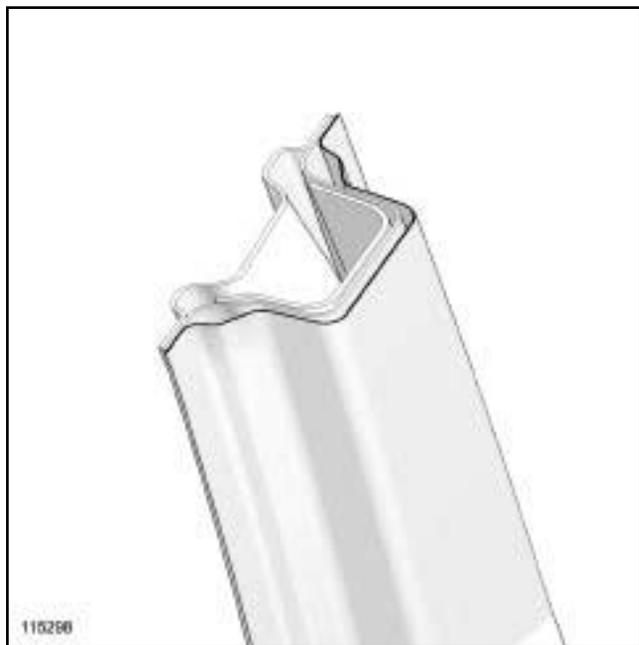
B84 or C84



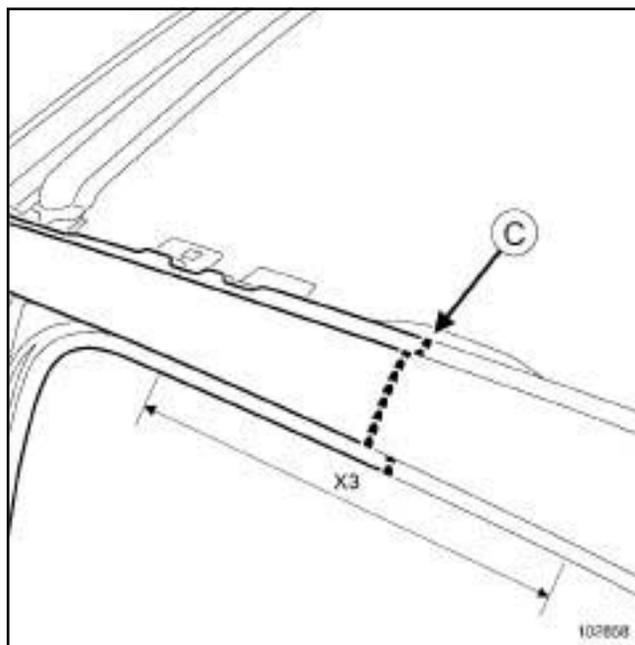
102864

It is possible to make the cut in area (X2) .

Cut B



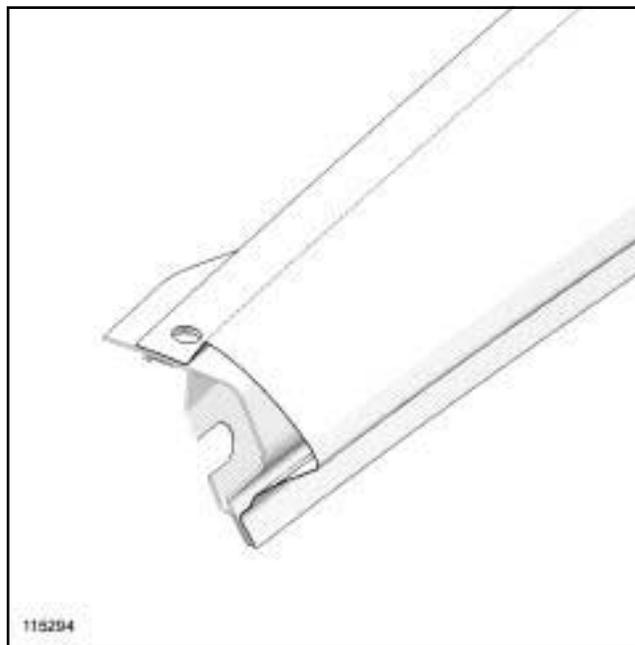
115298



102858

It is possible to make the cut in area (X3) .

Cut C



115294

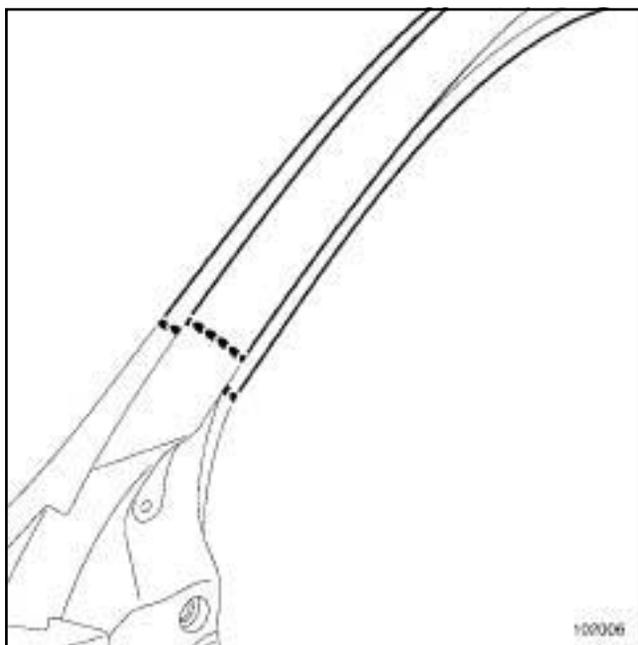
SIDE UPPER STRUCTURE

Upper body panel: Description

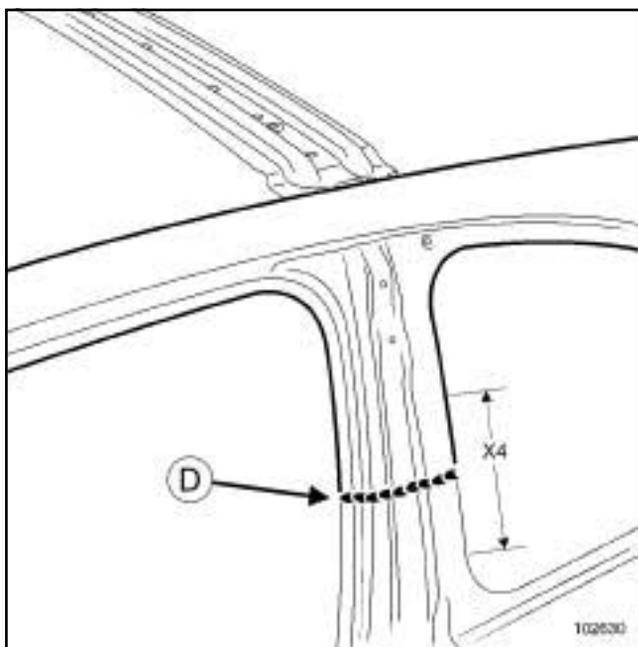
43A

B84 or C84

C84



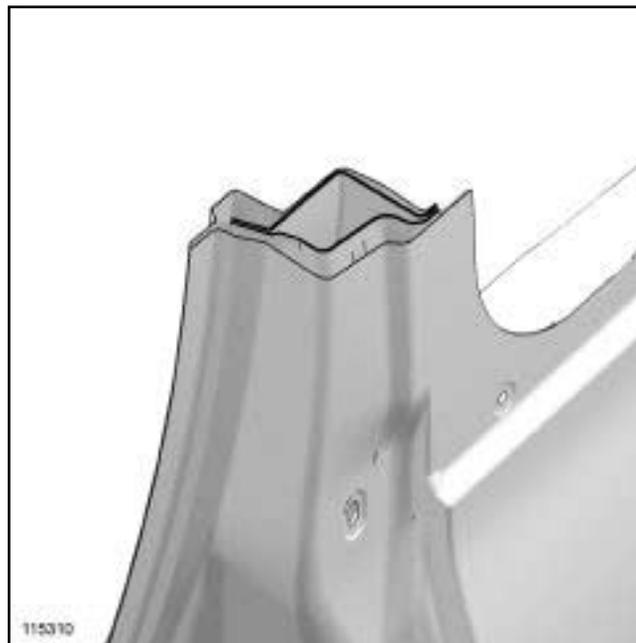
102006



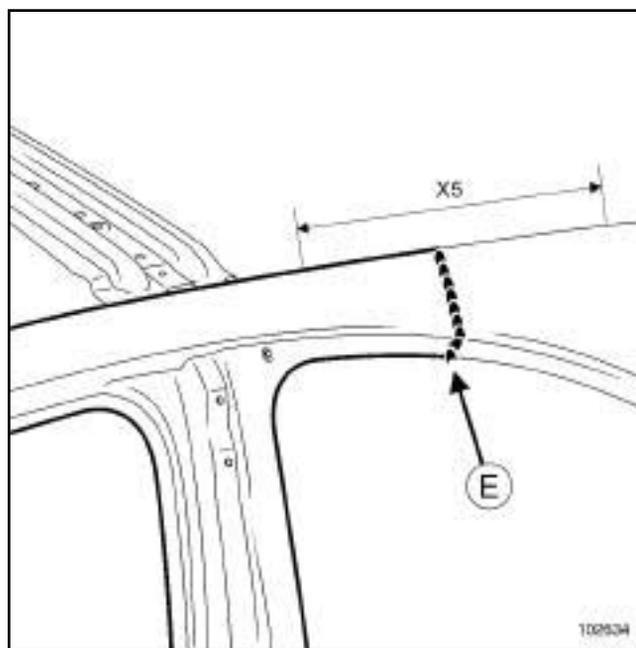
102630

It is possible to make the cut in area (X4) .

Cut D



115310



102634

It is possible to make the cut in area (X5) .

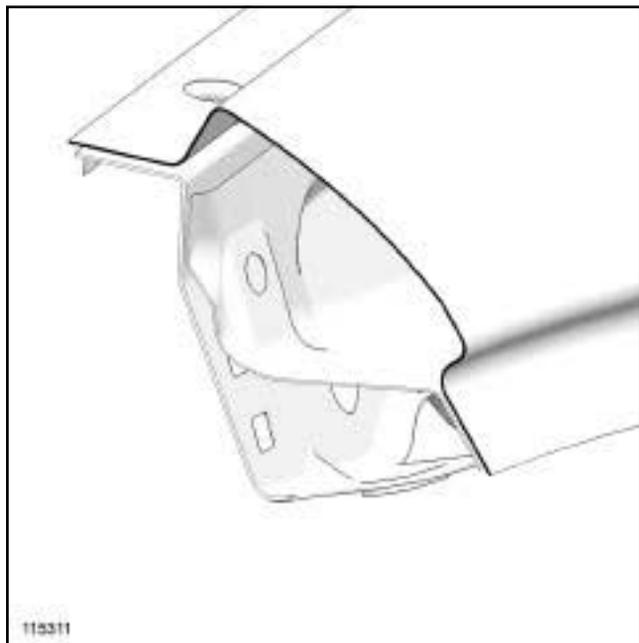
SIDE UPPER STRUCTURE

Upper body panel: Description

43A

B84 or C84

Cut E



115311

WARNING

If the spot welds cannot be made as they were originally using an electric spot welding machine, they should be replaced with plug welds after holes have been drilled in the first panel.

REAR UPPER STRUCTURE

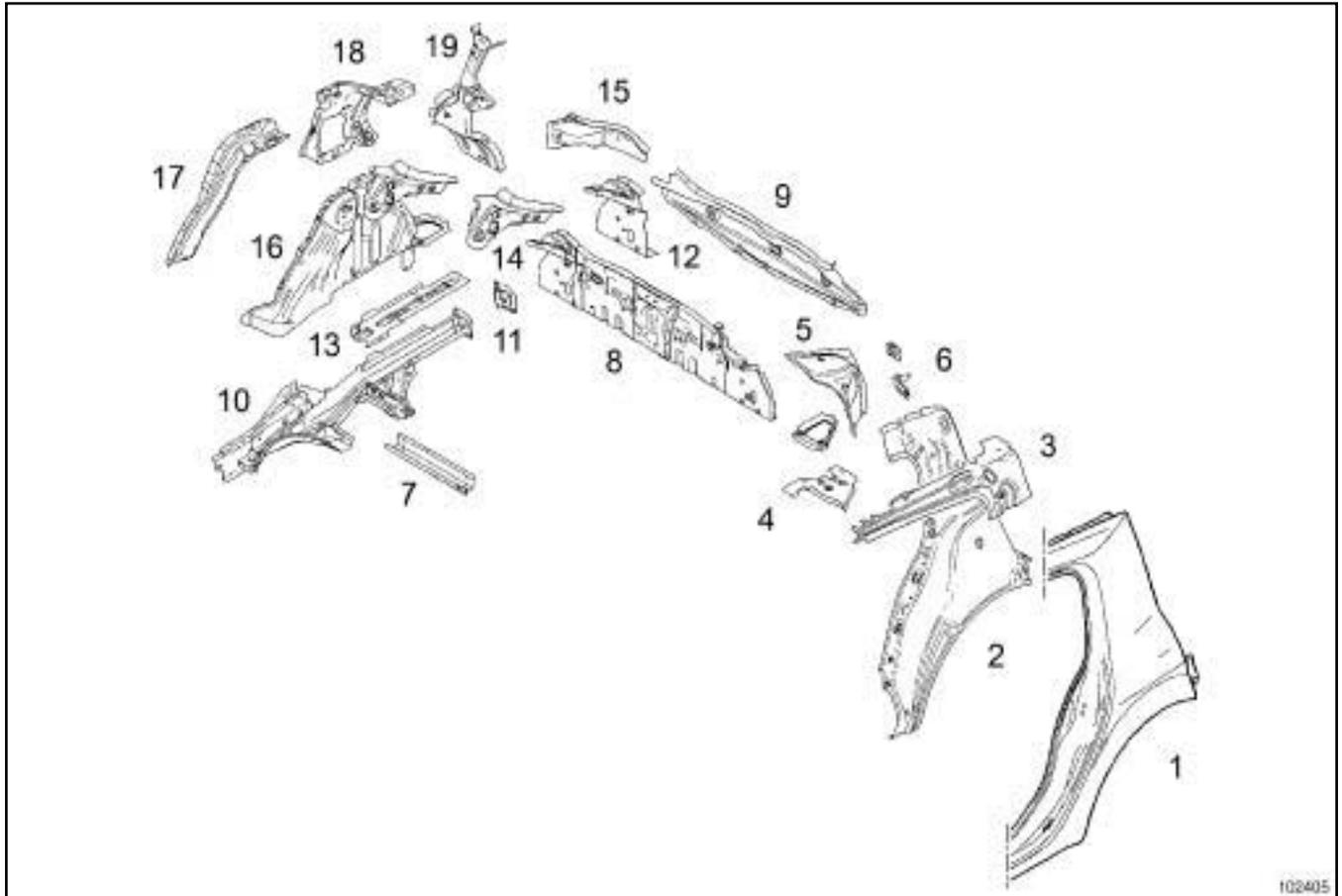
Vehicle structure rear section: Description

44A

B84 or C84

REAR STRUCTURE

B84



102405

102405

Mark	Description	Classification	Type	Thickness (mm)
(1)	Rear wing panel	(see 44A, Rear upper structure, Rear wing panel: Description, page 44A-7)	-	0.7
(2)	Quarter panel lining	(see 44A, Rear upper structure, Quarter panel lining: Description, page 44A-37)	-	0.6
(3)	Rear quarter upper reinforcement	(see 44A, Rear upper structure, Quarter panel upper reinforcement: Description, page 44A-40)	-	0.9
(4)	Far rear lower cross member, side section	(see 41D, Rear lower structure, Far rear lower cross member, side section: Description, page 41D-29)	-	0.95
(5)	Rear wheel arch extender	(see 44A, Rear upper structure, Rear wheel arch extension: Description, page 44A-33)	-	0.7
(6)	Tailgate stop mounting			

REAR UPPER STRUCTURE

Vehicle structure rear section: Description

44A

B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(7)	Rear floor centre cross member	(see 41D, Rear lower structure, Rear floor centre cross member: Description, page 41D-28)	HLE	1/2.5
(8)	Rear end panel assembly	(see 44A, Rear upper structure, Rear end panel assembly: Description, page 44A-46)	HLE/THLE	0.65/2.5
(9)	Rear end panel	(see 44A, Rear upper structure, Rear end panel: Description, page 44A-49)	-	0.65
(10)	Rear side member	(see 41D, Rear lower structure, Rear side member: Description, page 41D-20)	HLE/THLE	0.95/2
(11)	Rear impact cross member mounting stiffener	(see Rear impact cross member mounting stiffener: Description)	HLE	2
(12)	Rear end panel side lining	(see 44A, Rear upper structure, Rear end panel side lining: Description, page 44A-51)	-	0.7
(13)	Rear side member closure panel, rear section	(see 41D, Rear lower structure, Rear side member closure panel, rear section: Description, page 41D-23)	-	0.7
(14)	Light mounting lining	(see 44A, Rear upper structure, Lights support lining: Description, page 44A-21)	HLE	0.95
(15)	Rear light mounting	(see 44A, Rear upper structure, Rear lights support: Description, page 44A-18)	-	0.9
(16)	Inner rear wheel arch	(see 44A, Rear upper structure, Inner wheel arch: Description, page 44A-29)	HLE	0.7/1.5
(17)	Rear wheel arch closure panel	(see 44A, Rear upper structure, Rear wheel arch closure panel: Description, page 44A-31)	-	0.7
(18)	Quarter panel stiffener	(see 44A, Rear upper structure, Quarter panel reinforcement: Description, page 44A-36)	-	0.9
(19)	Rear wing panel rain channel	(see 44A, Rear upper structure, Rear wing panel rain channel: Description, page 44A-15)	HLE	0.85/1

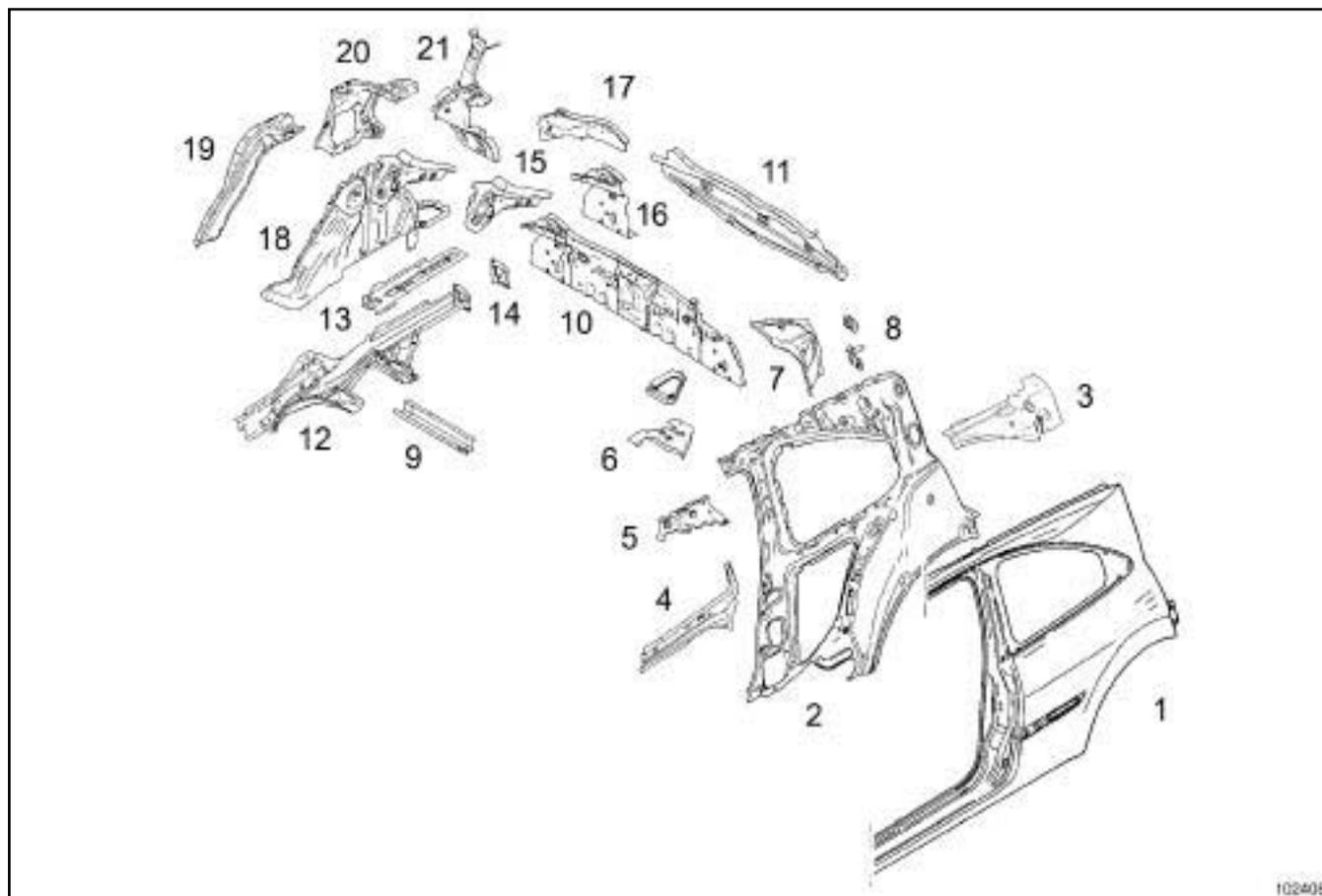
REAR UPPER STRUCTURE

Vehicle structure rear section: Description

44A

B84 or C84

C84



102406

102406

Mark	Description	Classification	Type	Thickness (mm)
(1)	Rear wing panel	(see 44A, Rear upper structure, Rear wing panel: Description, page 44A-7)	-	0.7
(2)	Quarter panel lining	(see 44A, Rear upper structure, Quarter panel lining: Description, page 44A-37)	-	0.6
(3)	Rear quarter upper reinforcement	(see 44A, Rear upper structure, Quarter panel upper reinforcement: Description, page 44A-40)	-	0.9
(4)	Quarter panel centre reinforcement	(see 44A, Rear upper structure, Quarter panel centre reinforcement: Description, page 44A-43)	HLE	1.5
(5)	Rear roof drip moulding lining	(see 44A, Rear upper structure, Roof rear drip moulding lining: Description, page 44A-44)	-	1/2
(6)	Far rear lower cross member, side part	(see 41D, Rear lower structure, Far rear lower cross member, side section: Description, page 41D-29)	-	0.95

REAR UPPER STRUCTURE

Vehicle structure rear section: Description

44A

B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(7)	Rear wheel arch extender	(see 44A, Rear upper structure, Rear wheel arch extension: Description, page 44A-33)	-	0.7
(8)	Tailgate stop mounting			
(9)	Rear floor centre cross member	(see 41D, Rear lower structure, Rear floor centre cross member: Description, page 41D-28)	HLE	1/2.5
(10)	Rear end panel assembly	(see 44A, Rear upper structure, Rear end panel assembly: Description, page 44A-46)	HLE/THLE	0.65/2.5
(11)	Rear end panel	(see 44A, Rear upper structure, Rear end panel: Description, page 44A-49)	-	0.65
(12)	Rear side member	(see 41D, Rear lower structure, Rear side member: Description, page 41D-20)	HLE/THLE	0.95/2
(13)	Rear side member closure panel, rear section	(see 41D, Rear lower structure, Rear side member closure panel, rear section: Description, page 41D-23)	-	0.7
(14)	Impact cross member mounting stiffener	(see Rear impact cross member mounting stiffener: Description)	HLE	2
(15)	Light mounting lining	(see 44A, Rear upper structure, Lights support lining: Description, page 44A-21)	HLE	0.95
(16)	Rear end panel side lining	(see 44A, Rear upper structure, Rear end panel side lining: Description, page 44A-51)	-	0.7
(17)	Rear light mounting	(see 44A, Rear upper structure, Rear lights support: Description, page 44A-18)	-	0.9
(18)	Inner rear wheel arch	(see 44A, Rear upper structure, Inner wheel arch: Description, page 44A-29)	HLE	0.7/1.5
(19)	Rear wheel arch closure panel	(see 44A, Rear upper structure, Rear wheel arch closure panel: Description, page 44A-31)	-	0.7
(20)	Quarter panel stiffener	(see 44A, Rear upper structure, Quarter panel reinforcement: Description, page 44A-36)	-	0.9
(21)	Rear wing panel rain channel	(see 44A, Rear upper structure, Rear wing panel rain channel: Description, page 44A-15)	HLE	0.85/1

REAR UPPER STRUCTURE

Rear wing panel: General description

44A

B84 or C84

WARNING

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

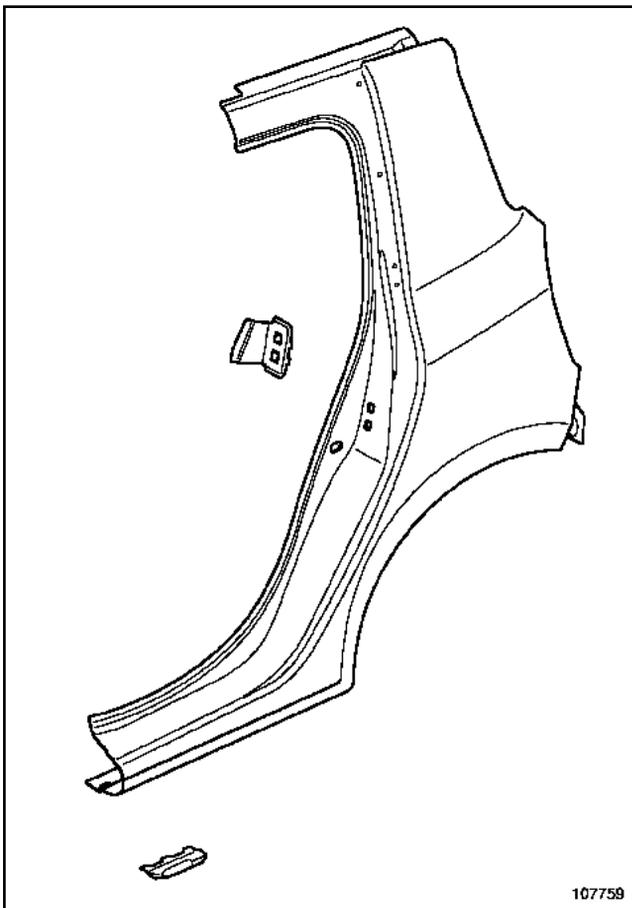
Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information**.

IMPORTANT

Before any operation is carried out, remove the seat belts and curtain airbag.

I - DESIGN OF THE STRUCTURAL COMPONENT



107759

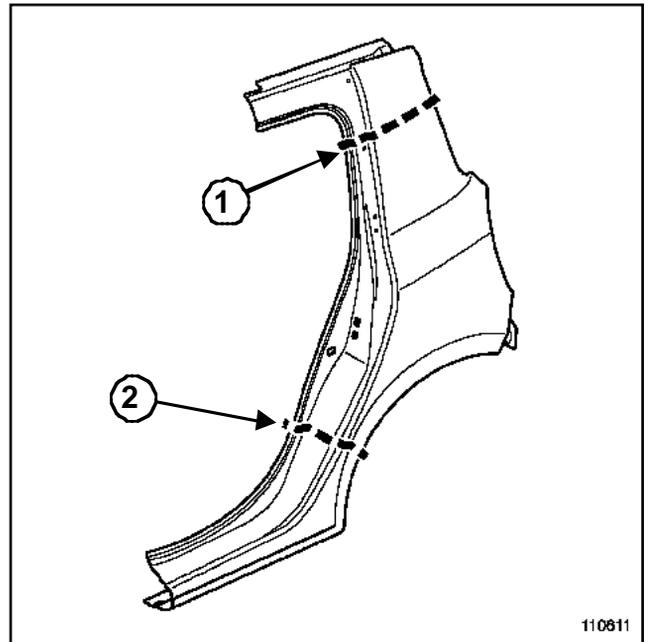
107759

This part has three special features:

- it is welded under the roof,
- it is butt welded on the body side front section.
- it is supplementary to the body side front section for a complete body side replacement.

II - AREA TO BE CUT FOR PARTIAL REPLACEMENT

B84



110611

110611

Lines (1) and (2) of the drawing show the areas in which it is possible to carry out a partial replacement.

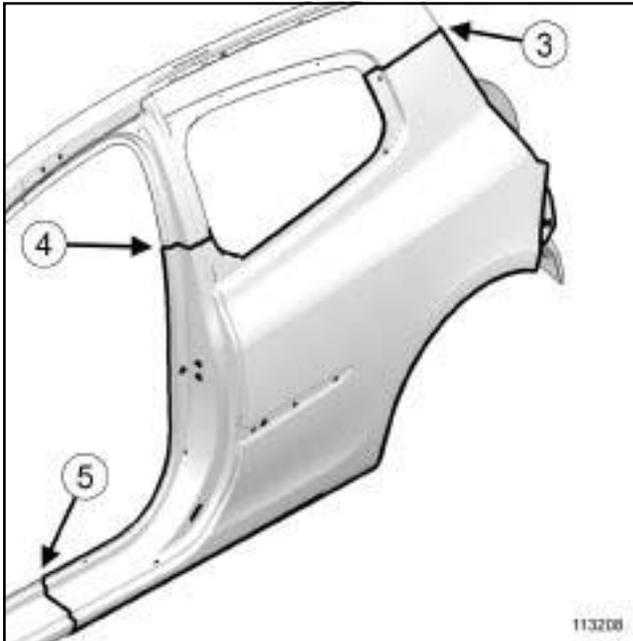
REAR UPPER STRUCTURE

Rear wing panel: General description

44A

B84 or C84

C84



Lines (3) , (4) and (5) in the drawing show the areas in which it is possible to carry out a partial replacement.

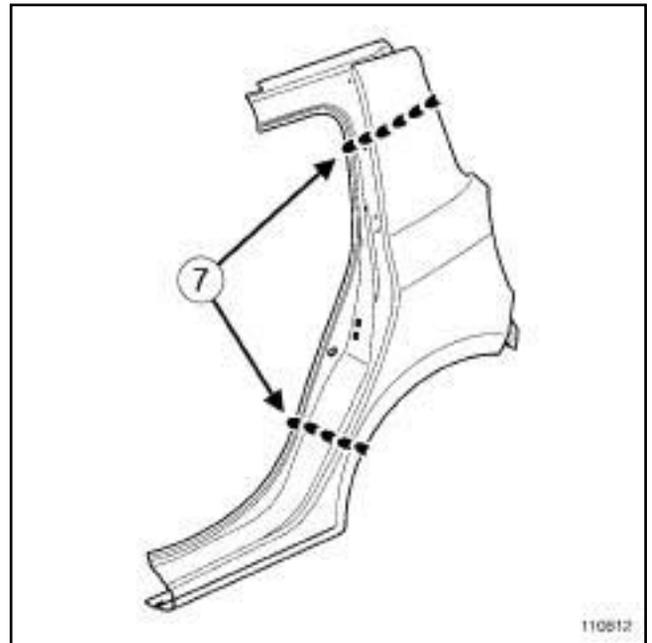
III - ASSEMBLY INSTRUCTIONS FOR A PARTIAL REPLACEMENT

Only the connections relevant to partial replacement by cutting are shown.

WARNING

If the spot welds cannot be made as they were originally using an electric spot welding machine, they should be replaced with plug welds after holes have been drilled in the first panel.

If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400, 40A, General Information**).



Lines (7) in the drawing show a butt weld by continuous MAG welding.

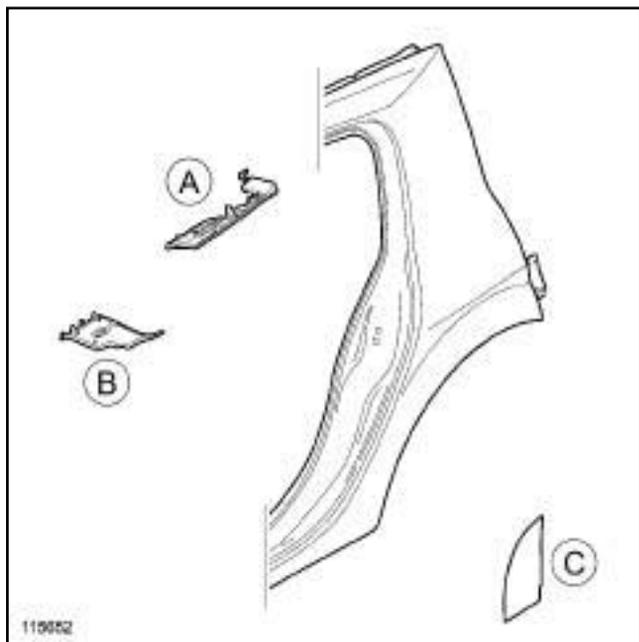
REAR UPPER STRUCTURE

Rear wing panel: Description

44A

B84 or C84

B84

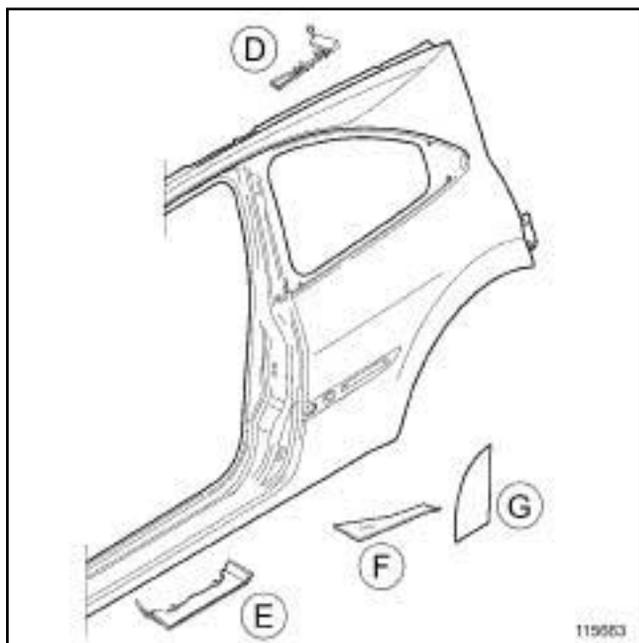


115652

The options for replacing this part are as follows:

- partial replacement: order insert (A) ,
- Complete replacement: order inserts (A) and (B) and anti-gravel protective film (C) .

C84



115663

The options for replacing this part are as follows:

- partial replacement: order inserts (E) and (F) and anti-gravel protective film (G) ,
- complete replacement: order inserts (D) , (E) and (F) and anti-gravel protective film (G) .

I - COMPOSITION OF THE SPARE PART

B84



115811

Number	Description	Type	Thickness (mm)
(1)	Rear wing panel	-	0.7
(2)	Door striker plate stiffener	-	1
(3)	Jacking point support	HLE	1.8

REAR UPPER STRUCTURE

Rear wing panel: Description

44A

B84 or C84

C84



115823

Number	Description	Type	Thickness (mm)
(4)	Rear wing panel	-	0.7
(5)	Door striker plate stiffener	-	1
(6)	Jacking point support	HLE	1.8

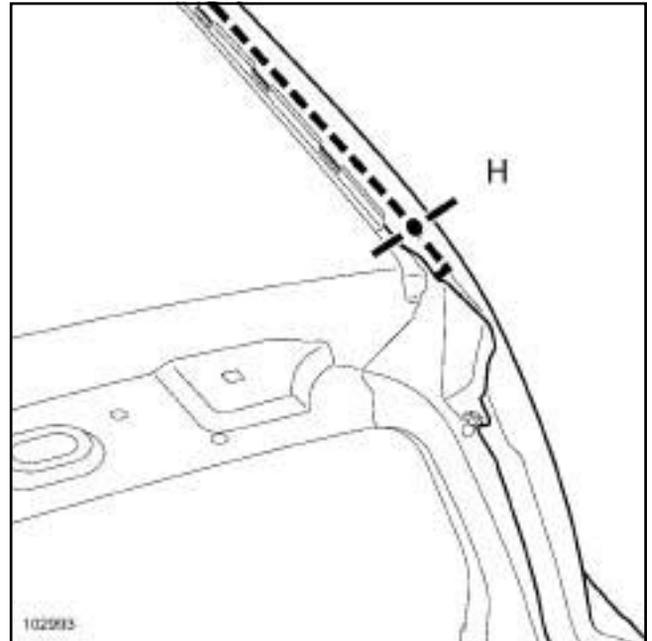
WARNING

If the spot welds cannot be made as they were originally using an electric spot welding machine, they should be replaced with plug welds after holes have been drilled in the first panel.

II - PART FITTED

1 - Partial replacement

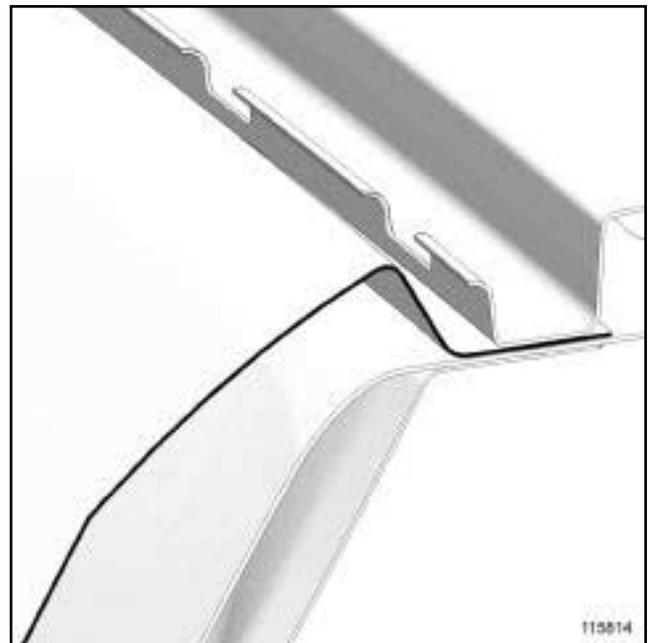
B84



102993

102993

Cut H



115814

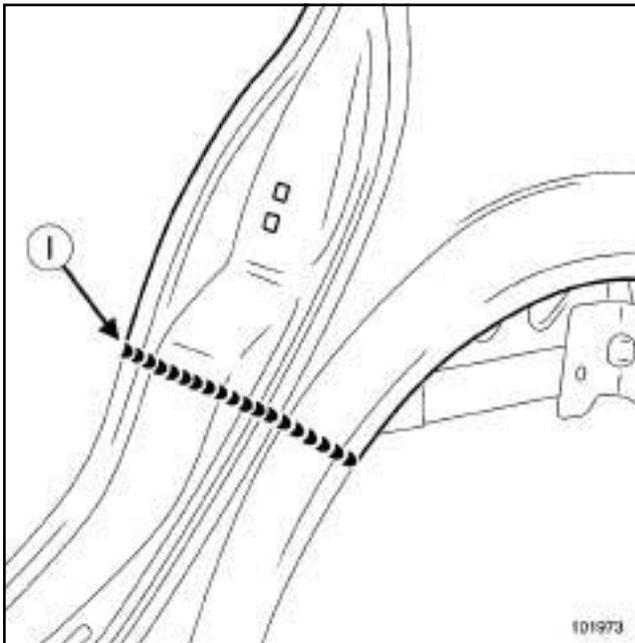
115814

REAR UPPER STRUCTURE

Rear wing panel: Description

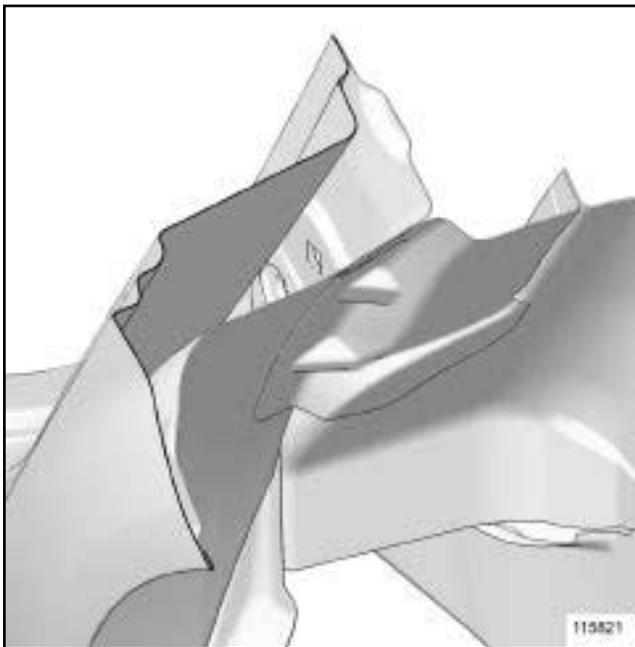
44A

B84 or C84



101973

Cut I

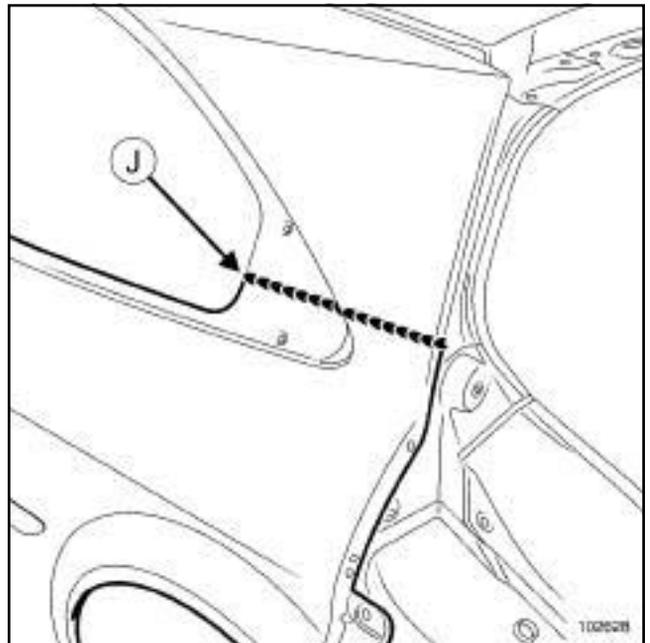


115821

WARNING

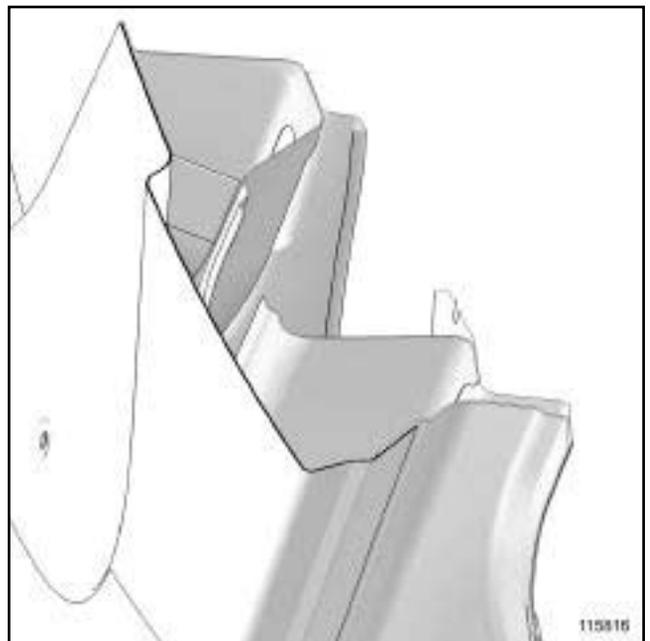
Do not alter the positioning of this weld; it is determined by that of the linings, reinforcements or expanding inserts.

C84



102628

Cut J



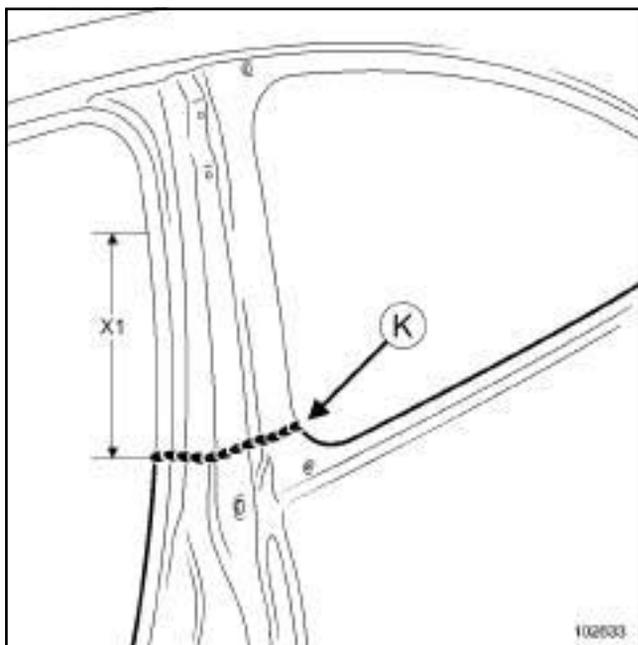
115816

REAR UPPER STRUCTURE

Rear wing panel: Description

44A

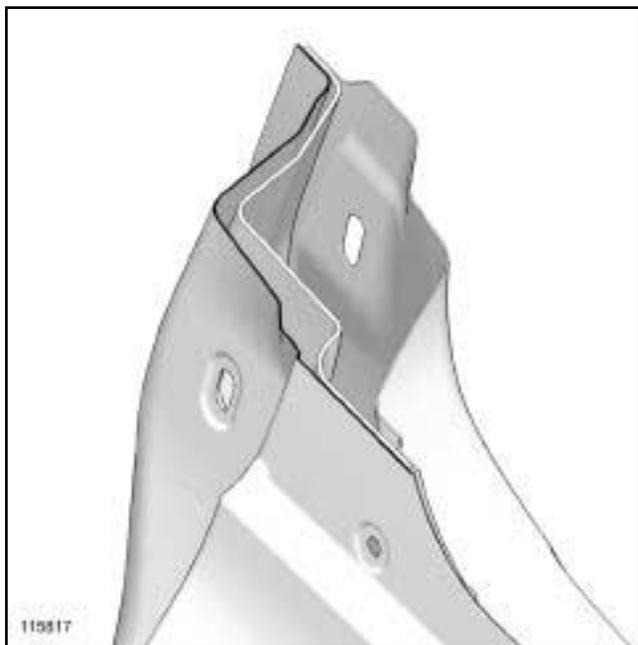
B84 or C84



102633

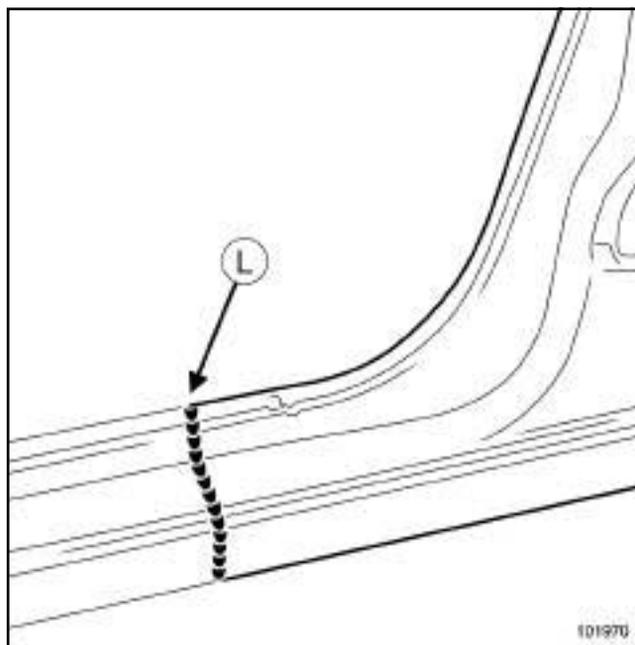
It is possible to make the cut in area (X1) .

Cut K



115817

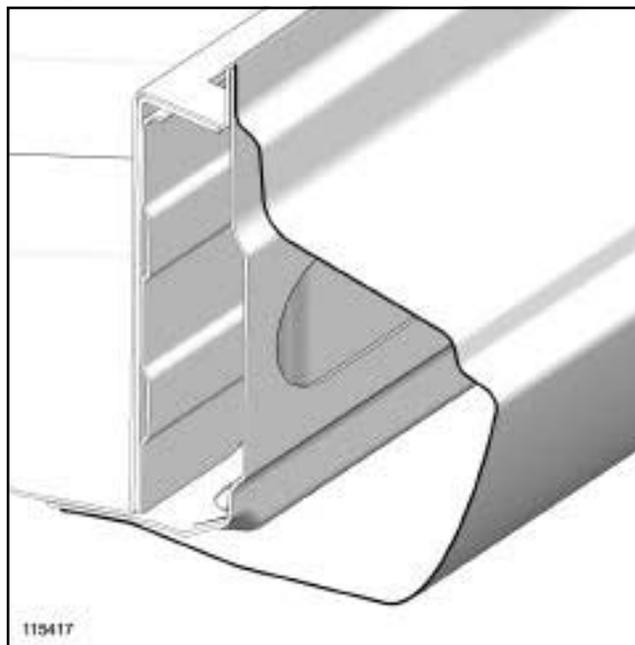
115817



101970

101970

Cut L



115417

115417

REAR UPPER STRUCTURE

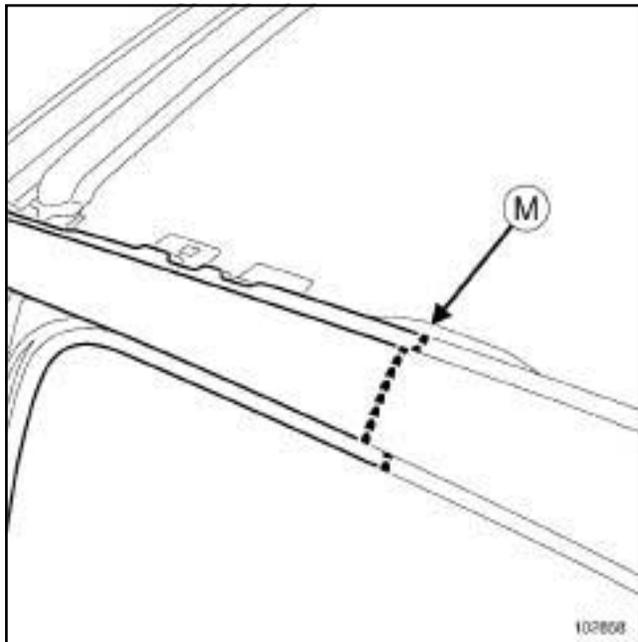
Rear wing panel: Description

44A

B84 or C84

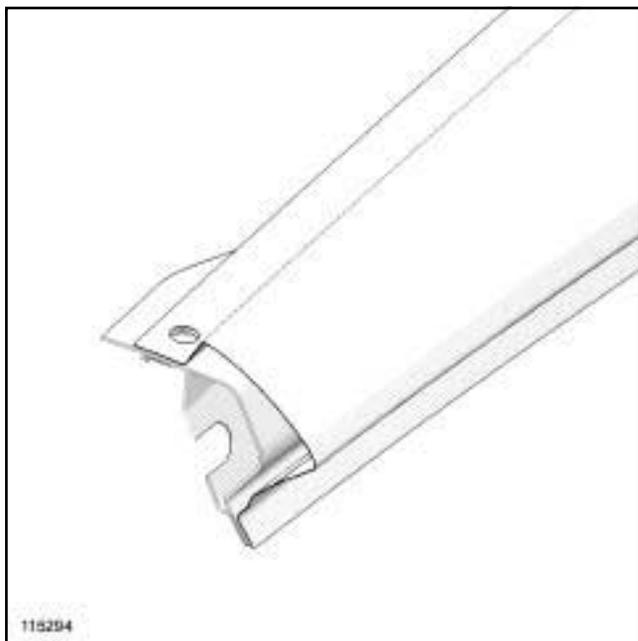
2 - Complete replacement

B84

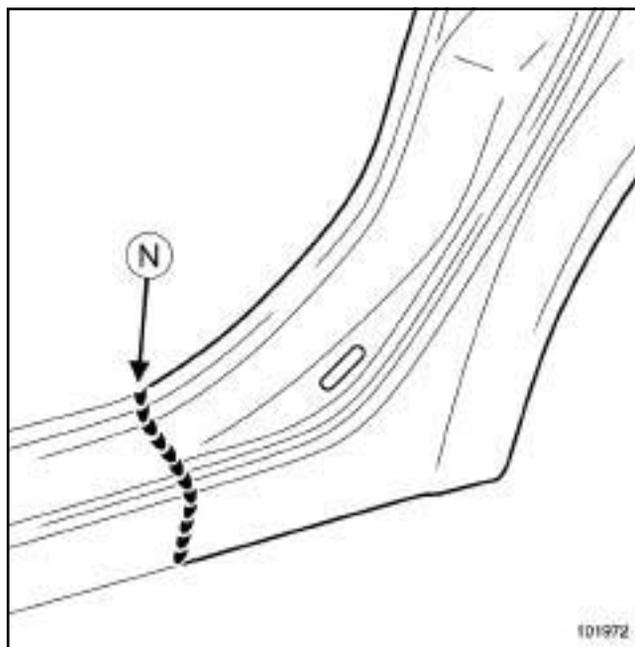


102858

Cut M



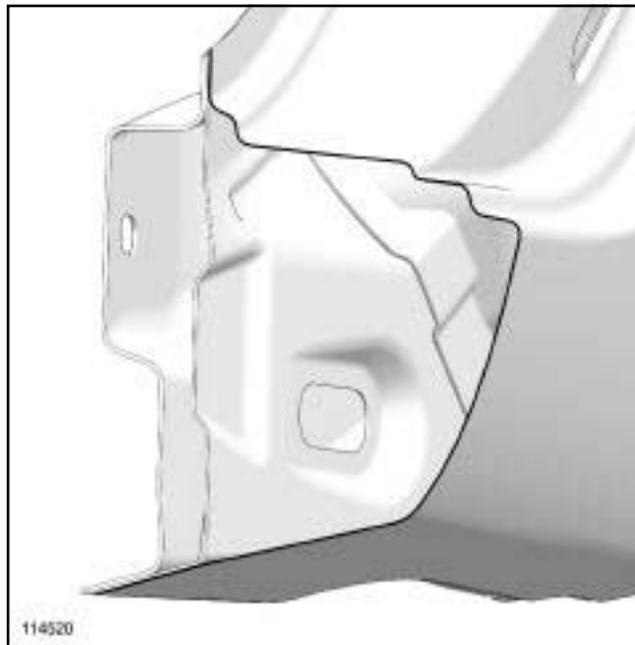
115294



101972

101972

Cut N



114520

115420

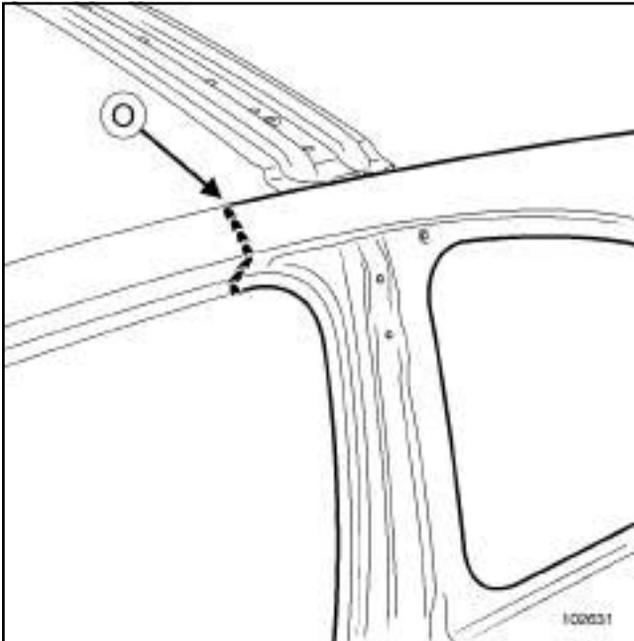
REAR UPPER STRUCTURE

Rear wing panel: Description

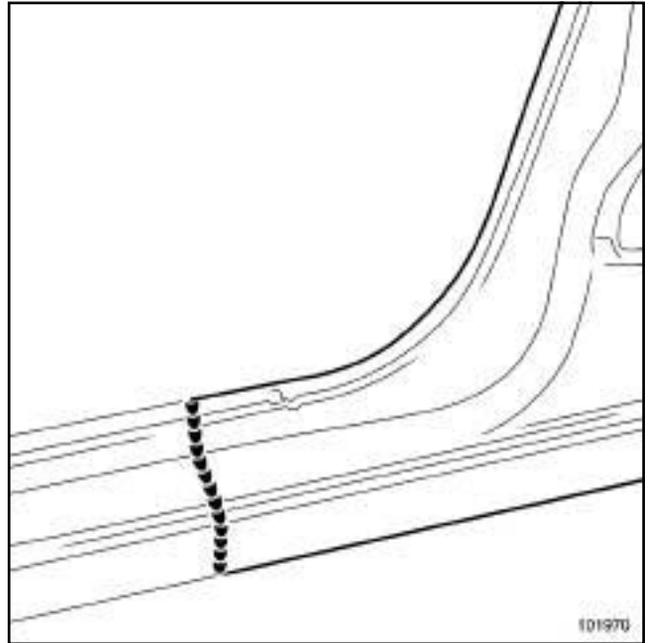
44A

B84 or C84

C84

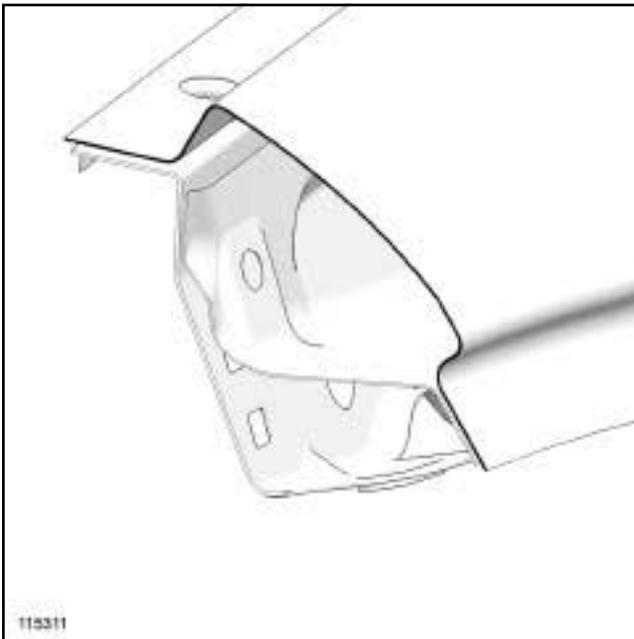


102631



101970

Cut O

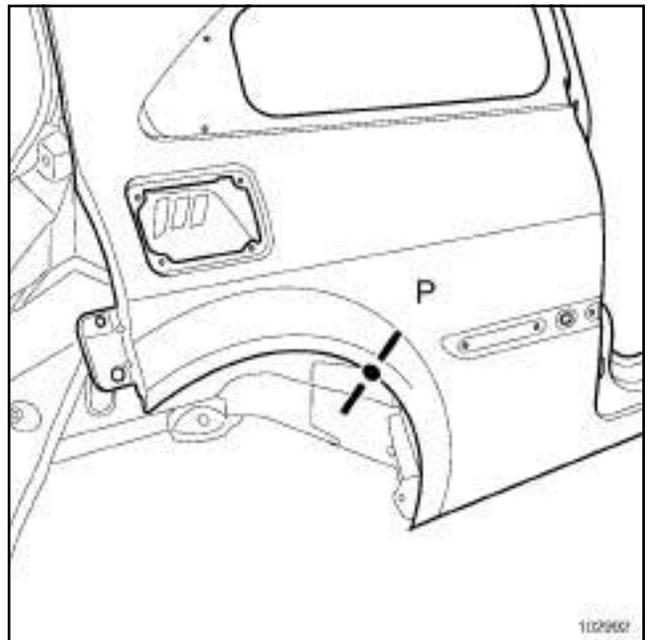


115311

IMPORTANT

For welded connections in three thicknesses, the spot welds on the part replaced should be made in the same place as for the original joint to retain its mechanical properties.

3 - Special note on replacing the rear wing panel



102992

REAR UPPER STRUCTURE

Rear wing panel: Description

44A

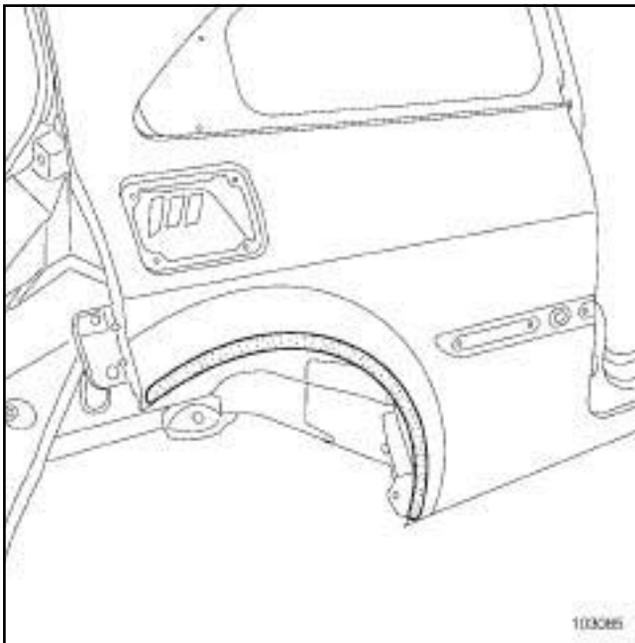
B84 or C84

The procedure for crimping the rear wing panel is identical to that for replacing a door panel.

Cut P



115822



103085

Note:

Use **structural adhesive** on the crimping area.

Use an **MJ Pro** type adhesive to ensure correct appearance and sealing after crimping of the rear wing panel.

III - ANTI-GRAVEL PROTECTION

To fit anti-gravel protective adhesive film, see **Technical note 579A, Anti-gravel protective adhesive film, 55A, Exterior protection, Anti-gravel protective adhesive film** .

Rear wing panel rain channel: General description

B84 or C84

WARNING

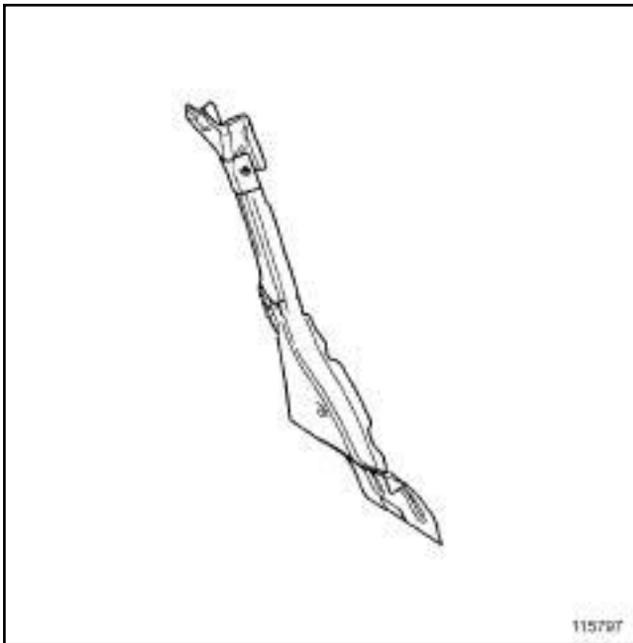
The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information** .

DESIGN OF THE STRUCTURAL COMPONENT



115797

This is a basic part; its only function is that of rear wing panel rain channel.

If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400, 40A, General Information**).

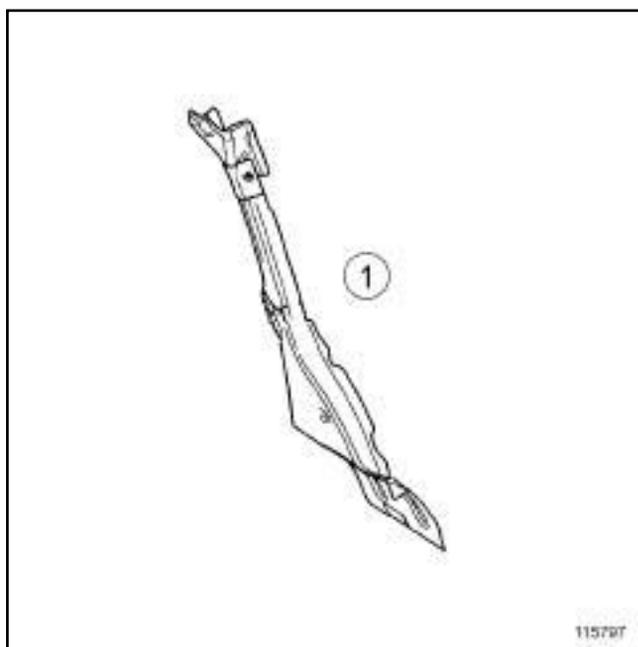
Rear wing panel rain channel: Description

B84 or C84

The options for replacing this part are as follows:

- partial replacement of the bottom section of the rear wing panel rain channel: this operation avoids the need to remove the rear wing,
- replacement of the bottom section of the rain channel: this operation supplements the rear wheel arch extension and the side closure of the far rear lower cross member.
- complete replacement: this operation supplements the replacement of the roof, rear wing and the rear wheel arch extension.

I - COMPOSITION OF THE SPARE PART

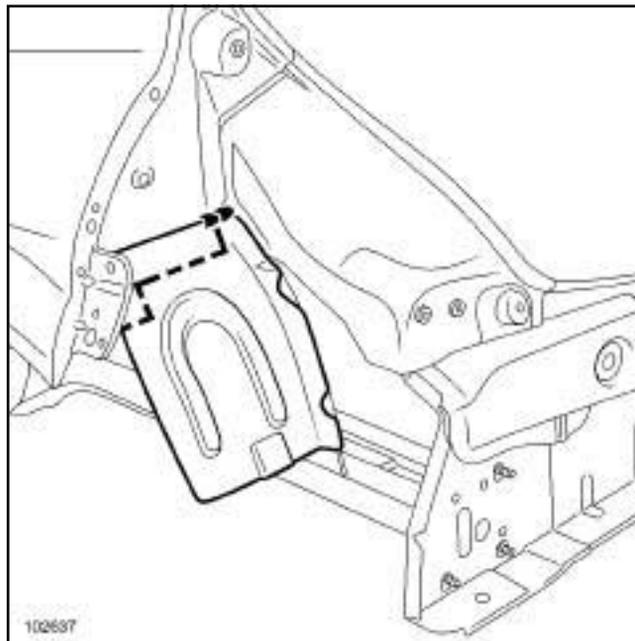


115797

Number	Description	Type	Thickness (mm)
(1)	Rear side rain channel	HLE	0.9/1

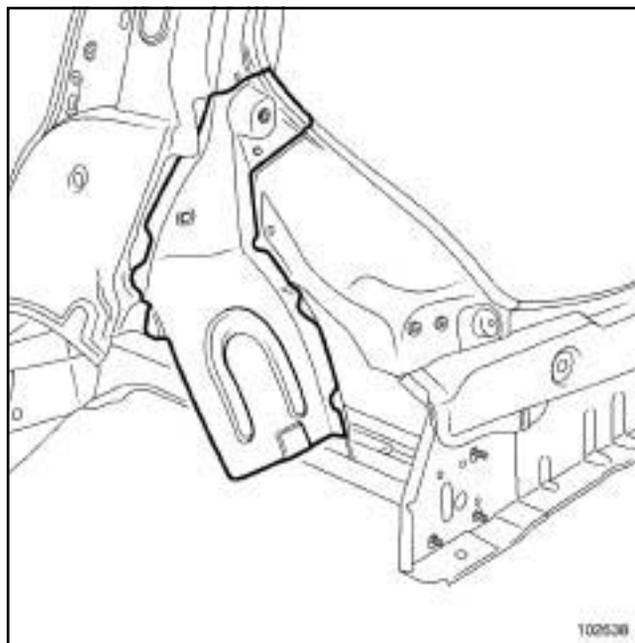
II - PART FITTED

1 - Partial replacement of the bottom section of the rear wing panel rain channel



102637

2 - Replacement of the bottom section of the rear wing panel rain channel

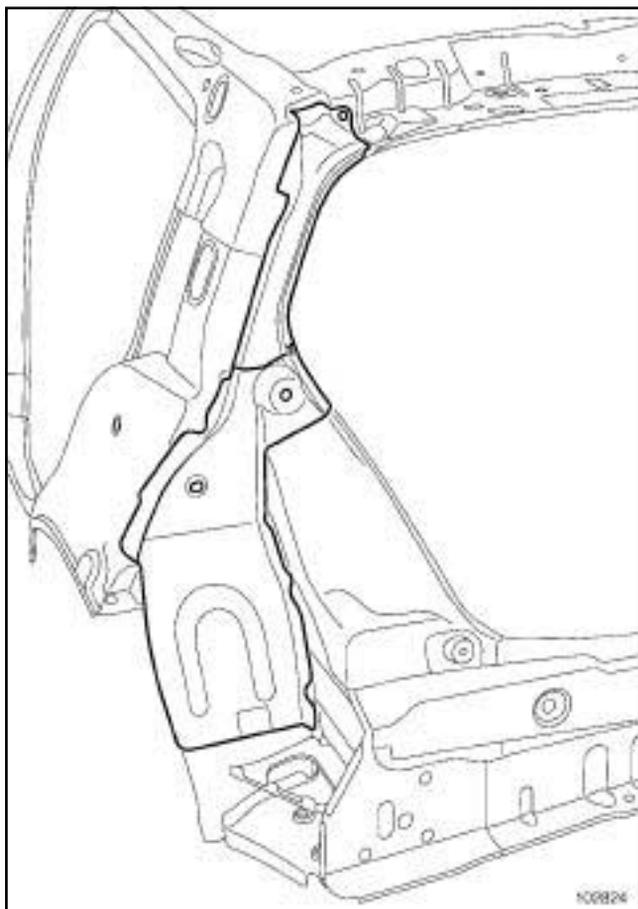


102638

Rear wing panel rain channel: Description

B84 or C84

3 - Complete replacement of the rear wing panel rain channel

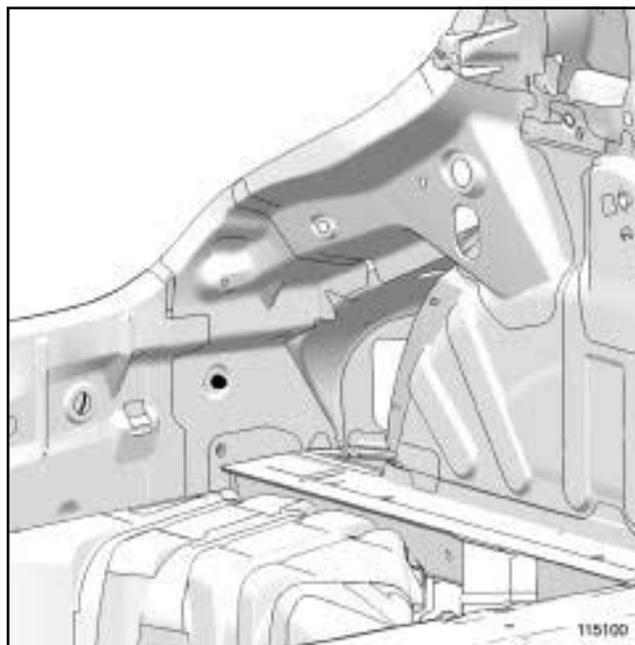


102824

WARNING

If the spot welds cannot be made as they were originally using an electric spot welding machine, they should be replaced with plug welds after holes have been drilled in the first panel.

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



115100

IMPORTANT

To avoid damaging the vehicle's electric and electronic components, the battery and the earths of any wiring harness near the weld area must be disconnected.

The earth of the welding machine must be placed as close as possible to the weld area.

REAR UPPER STRUCTURE

Rear lights support: General description

44A

B84 or C84

WARNING

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information** .

DESIGN OF THE STRUCTURAL COMPONENT



101408

This is a basic part; its only function is that of a rear lights support and it is part of the rear wing panel rain channel connection.

This is a basic part; its only function is that of a rear lights support.

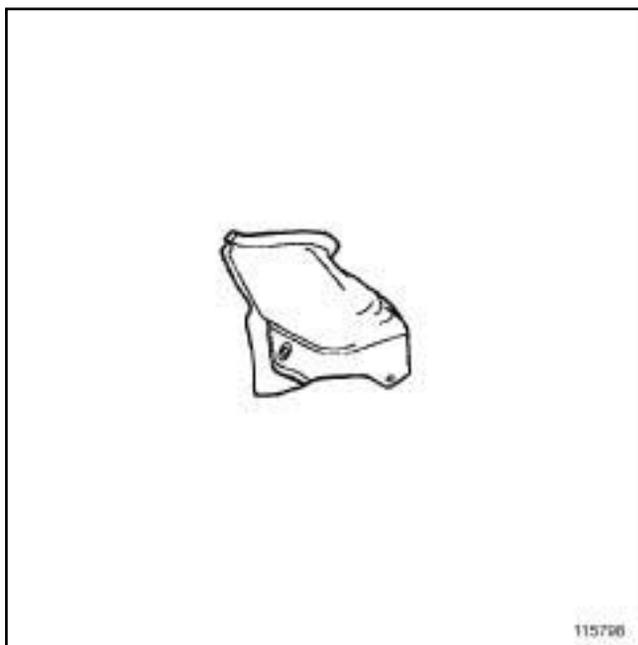
If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400, 40A, General Information**).

REAR UPPER STRUCTURE

Rear lights support: Description

44A

B84 or C84



115788

115798

There is only one way of replacing this part:

- complete replacement: this operation supplements the replacement of the rear end panel assembly.

I - COMPOSITION OF THE SPARE PART

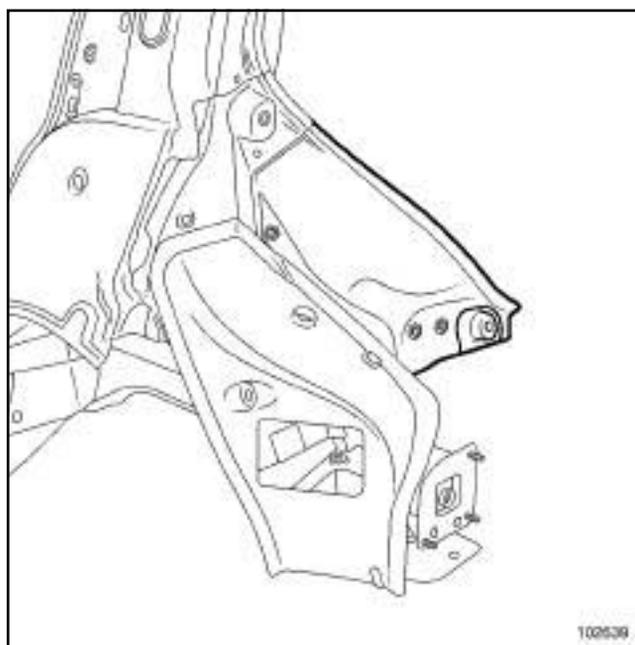


101408

101408

Number	Description	Type	Thickness (mm)
(1)	Rear lights support	-	0.9
(2)	Luggage compartment lid side stop mounting	-	1

II - PART FITTED



102639

102639

IMPORTANT

For welded connections in three thicknesses, the spot welds on the part replaced should be made in the same place as for the original joint to retain its mechanical properties.

WARNING

If the spot welds cannot be made as they were originally using an electric spot welding machine, they should be replaced with plug welds after holes have been drilled in the first panel.

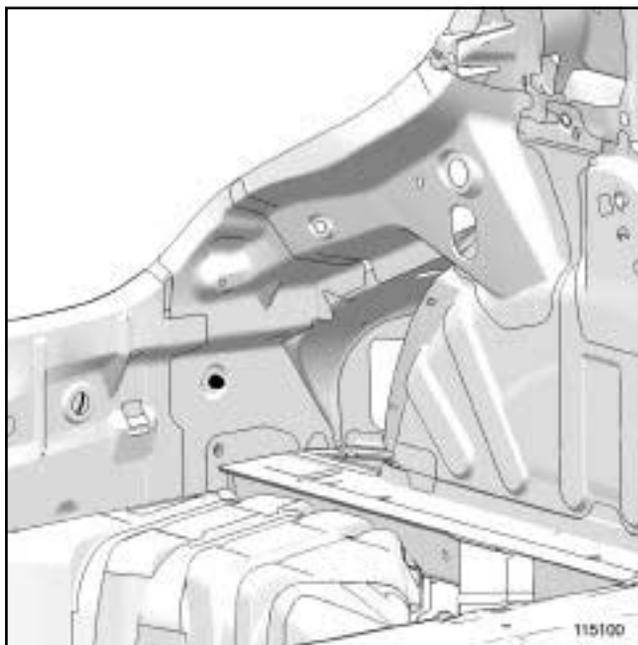
REAR UPPER STRUCTURE

Rear lights support: Description

44A

B84 or C84

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



115100

IMPORTANT

To avoid damaging the vehicle's electric and electronic components, the battery and the earths of any wiring harness near the weld area must be disconnected.

The earth of the welding machine must be placed as close as possible to the weld area.

REAR UPPER STRUCTURE

Lights support lining: General description

44A

B84 or C84

WARNING

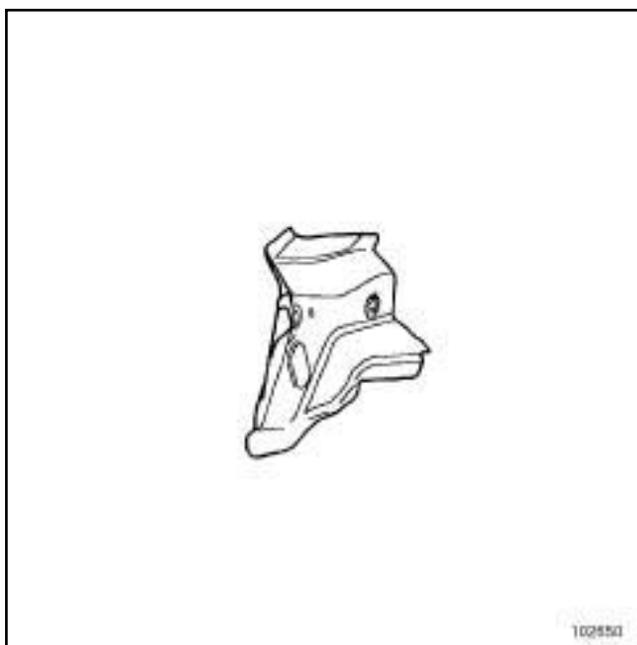
The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information**.

DESIGN OF THE STRUCTURAL COMPONENT



102650

This is a basic part, its only function is that of the light mounting lining.

REAR UPPER STRUCTURE

Lights support lining: Description

44A

B84 or C84

There is only one way of replacing this part:

- complete replacement: this operation supplements the replacement of the rear end panel assembly.

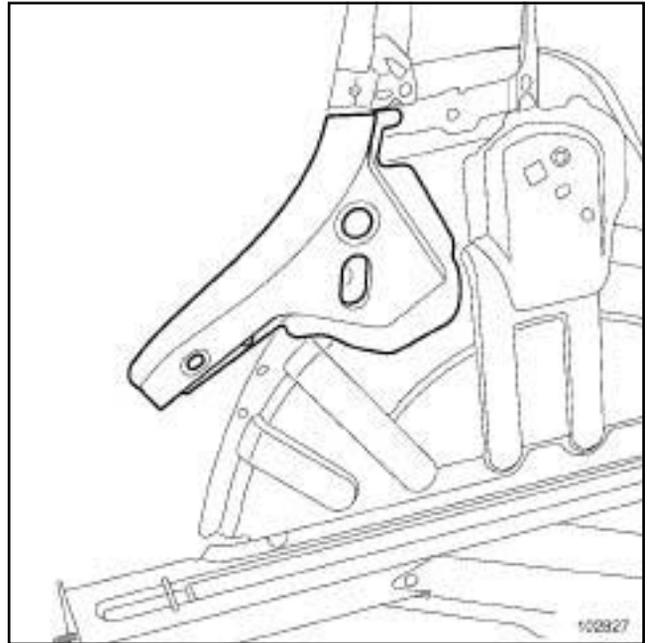
I - COMPOSITION OF THE SPARE PART



102650

II - PART FITTED

Complete replacement



102827

WARNING

If the spot welds cannot be made as they were originally using an electric spot welding machine, they should be replaced with plug welds after holes have been drilled in the first panel.

Number	Description	Type	Thickness (mm)
(1)	Lights support lining	-	1

Outer rear wheel arch: General description

B84 or C84

WARNING

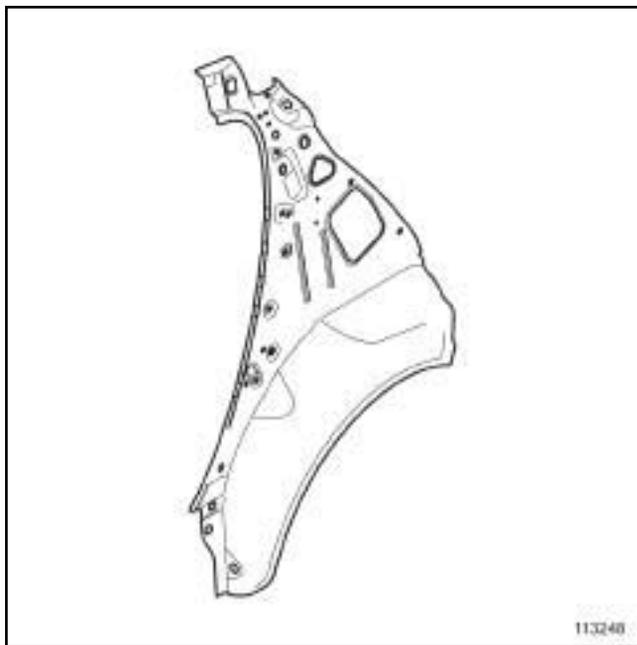
The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information**.

I - DESIGN OF THE STRUCTURAL COMPONENT

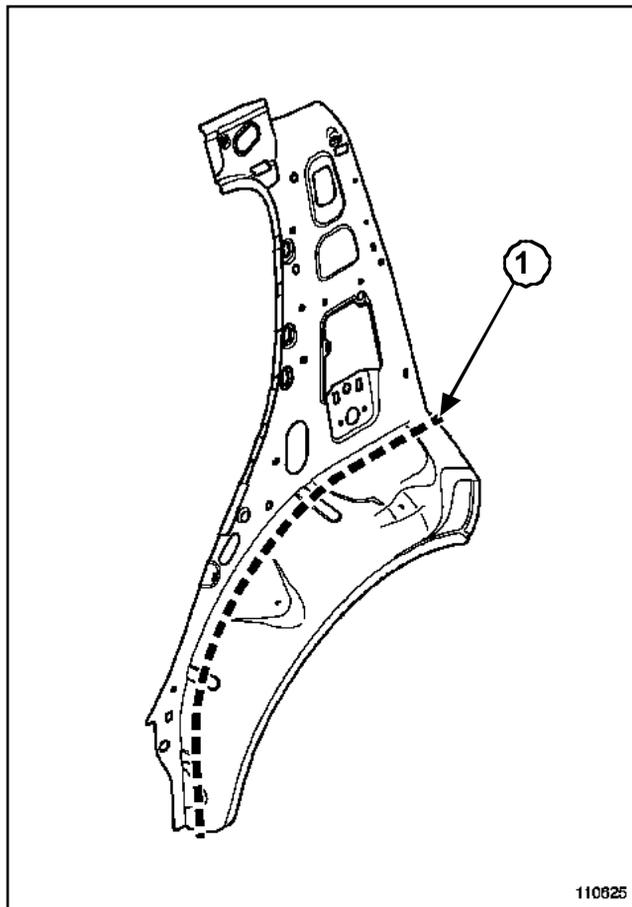


113248

The special feature of this part is its extension from the quarter panel lining to create the external rear wheel arch.

II - AREA TO BE CUT FOR PARTIAL REPLACEMENT

C84



110625

110625

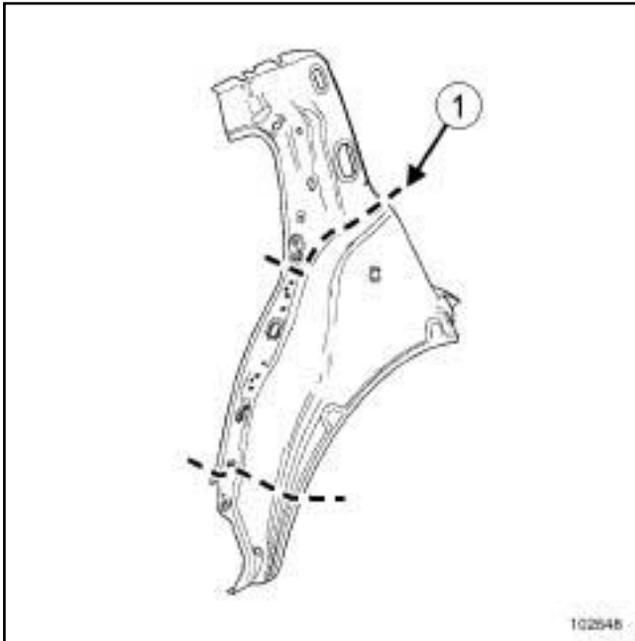
REAR UPPER STRUCTURE

Outer rear wheel arch: General description

44A

B84 or C84

B84



102648

The line (1) of the drawing shows the area in which it is possible to carry out a partial replacement.

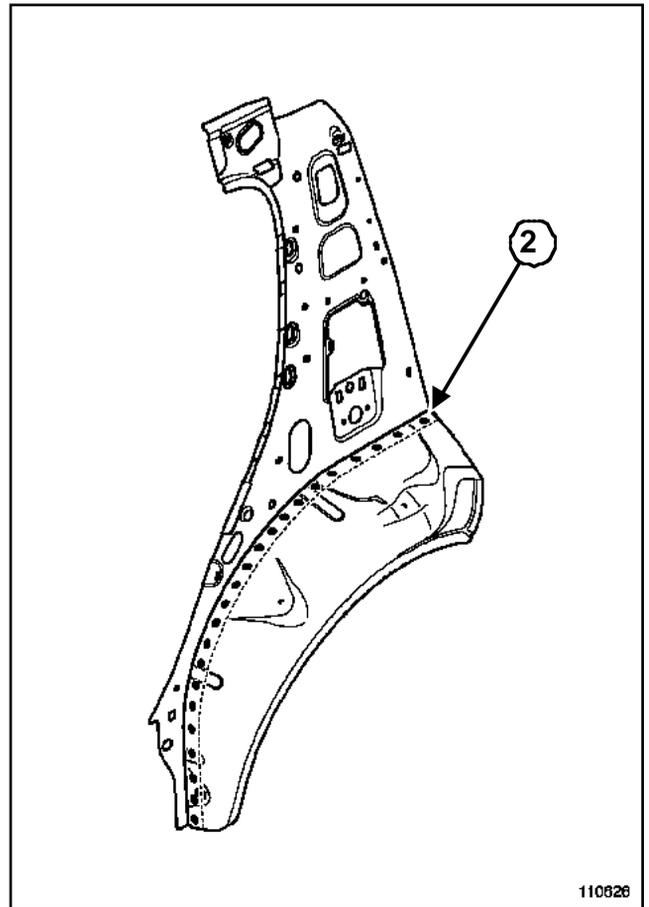
III - ASSEMBLY INSTRUCTIONS FOR A PARTIAL REPLACEMENT

Only the connecting pieces relevant to partial replacement by cutting are shown.

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400, 40A, General Information**).



110626

110626

Line (2) in the drawing shows partial replacement and a weld by joggling with plug welds at regular intervals.

REAR UPPER STRUCTURE

Outer rear wheel arch: Description

44A

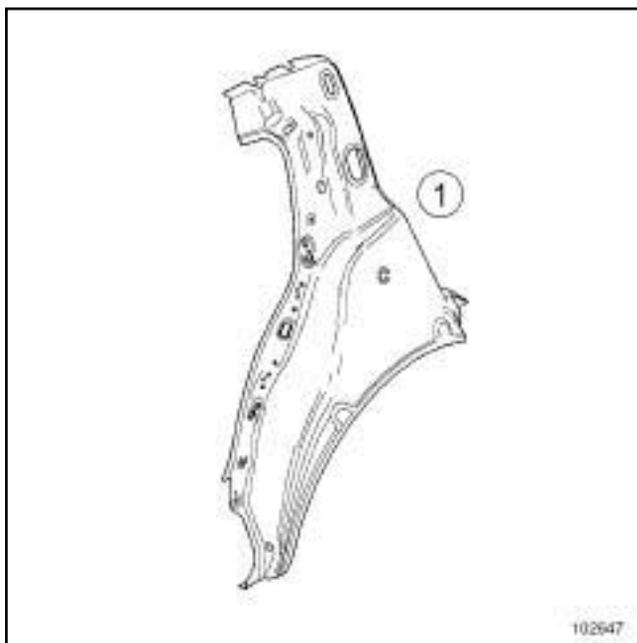
B84 or C84

The options for replacing this part are as follows:

- partial replacement (3-door version): this operation does not require removal of the quarter panel centre stiffener,
- complete replacement.

I - COMPOSITION OF THE SPARE PART

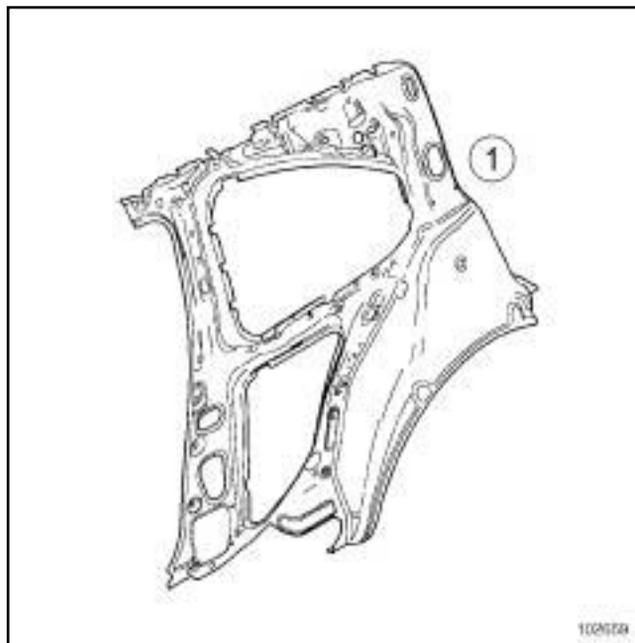
B84



102647

102647

C84



102659

102659

Mark	Description	Type	Thickness (mm)
(1)	Quarter panel lining	HEL	0.6

REAR UPPER STRUCTURE

Outer rear wheel arch: Description

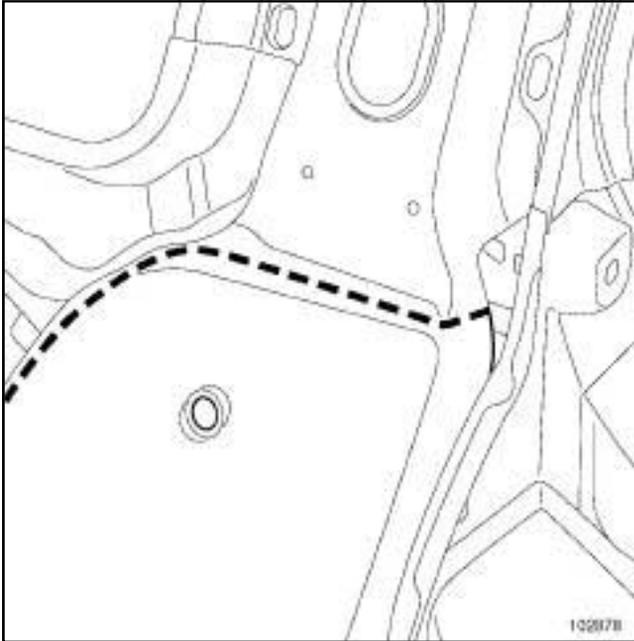
44A

B84 or C84

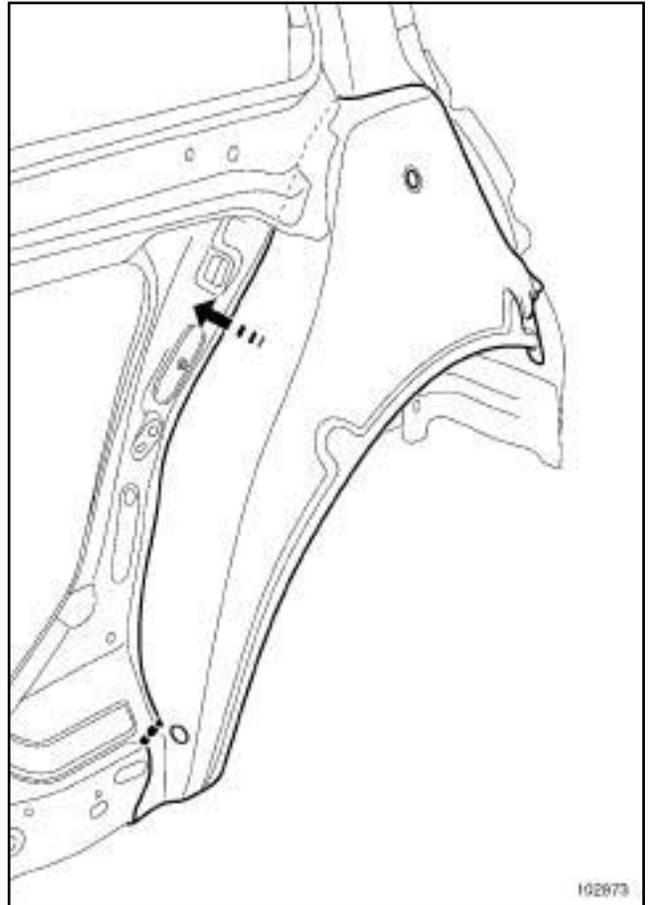
II - PART FITTED

1 - Partial replacement

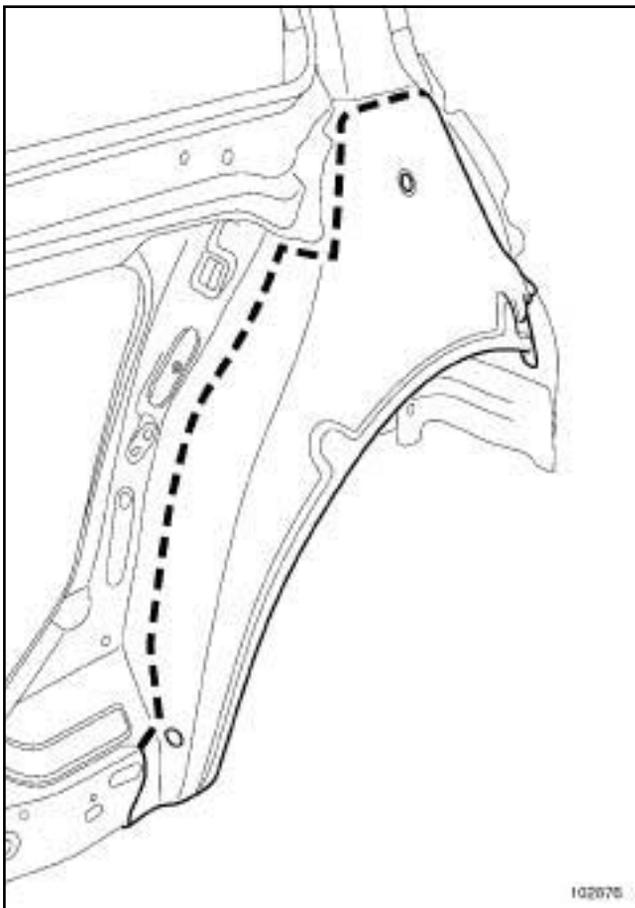
C84



102878



102873



102876

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

REAR UPPER STRUCTURE

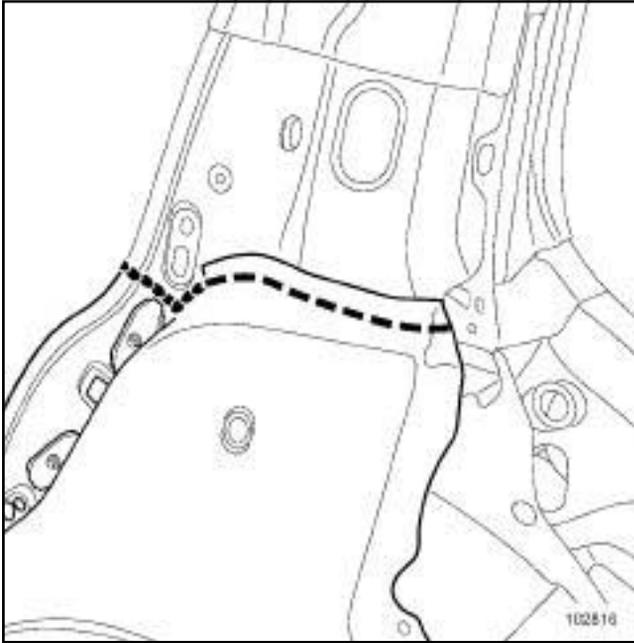
Outer rear wheel arch: Description

44A

B84 or C84

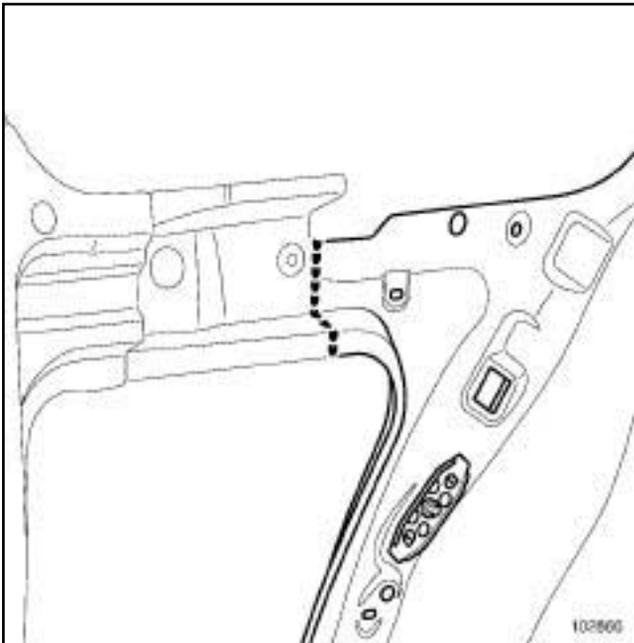
2 - Complete replacement

B84

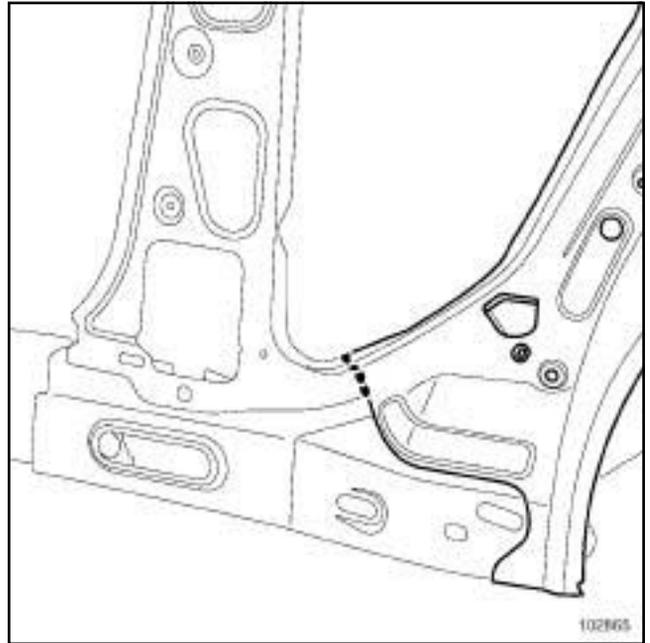


102816

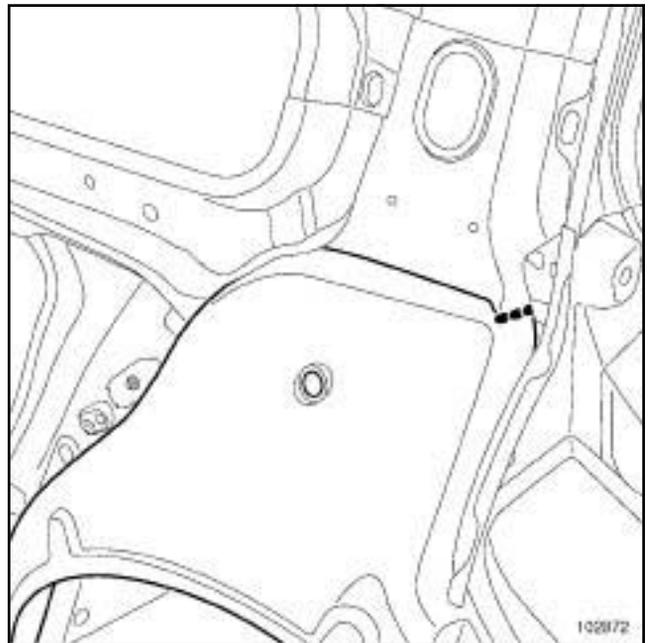
C84



102866



102865



102872

IMPORTANT

For welded connections in three thicknesses, the spot welds on the part replaced should be made in the same place as for the original joint to retain its mechanical properties.

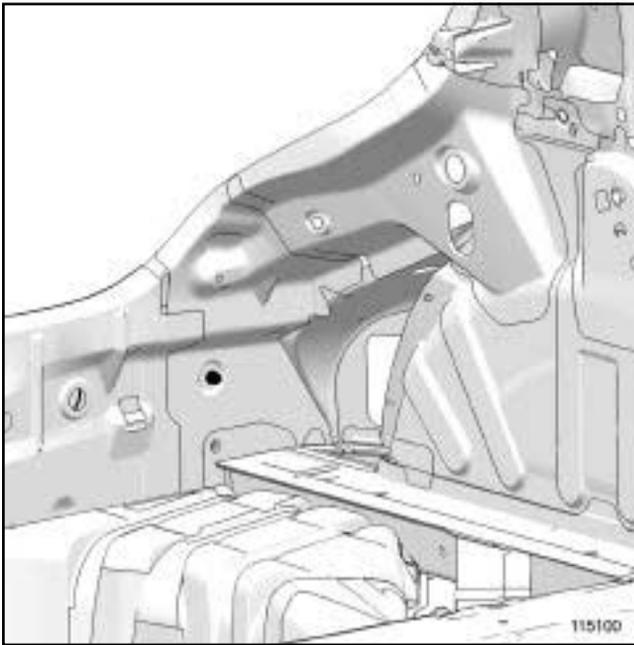
REAR UPPER STRUCTURE

Outer rear wheel arch: Description

44A

B84 or C84

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



115100

IMPORTANT

To avoid damaging the vehicle's electric and electronic components, the battery and the earths of any wiring harness near the weld area must be disconnected.

The earth of the welding machine must be placed as close as possible to the weld area.

REAR UPPER STRUCTURE

Inner wheel arch: General descriptions

44A

B84 or C84

WARNING

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

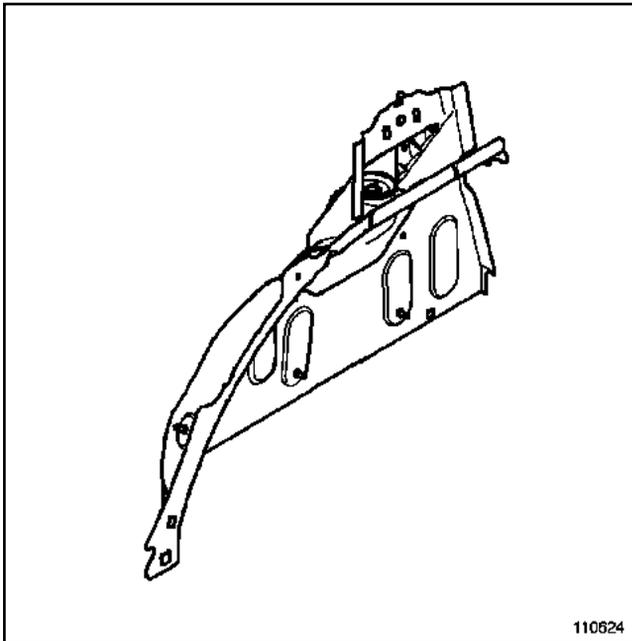
IMPORTANT

The straightening bench must be used.

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information** .

DESIGN OF THE STRUCTURAL COMPONENT



110624

This is a basic part; its only function is that of an internal rear wheel arch and rear shock absorber mounting.

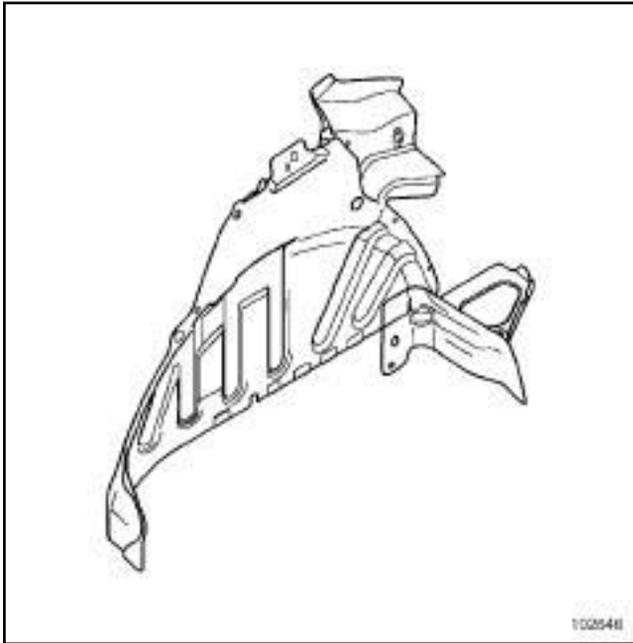
If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400, 40A, General Information**).

REAR UPPER STRUCTURE

Inner wheel arch: Description

44A

B84 or C84

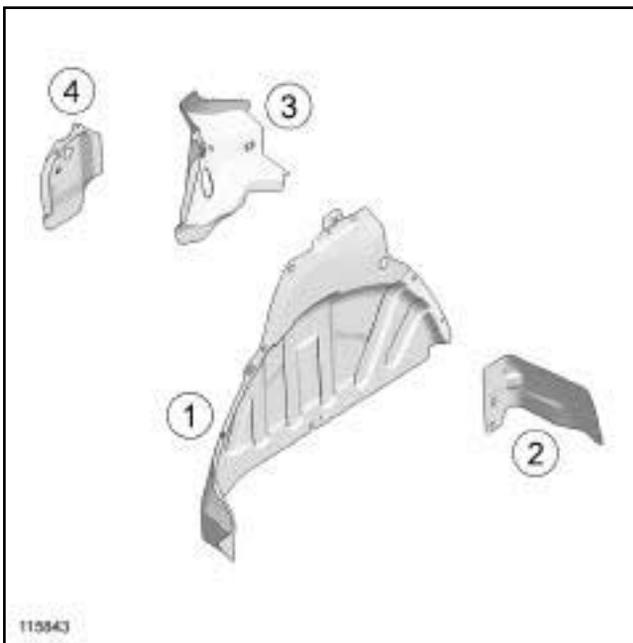


102646

There is only one way of replacing this part:

- Complete replacement: this operation complements the replacement of the rear wheel arch closure panel.

I - COMPOSITION OF THE SPARE PART

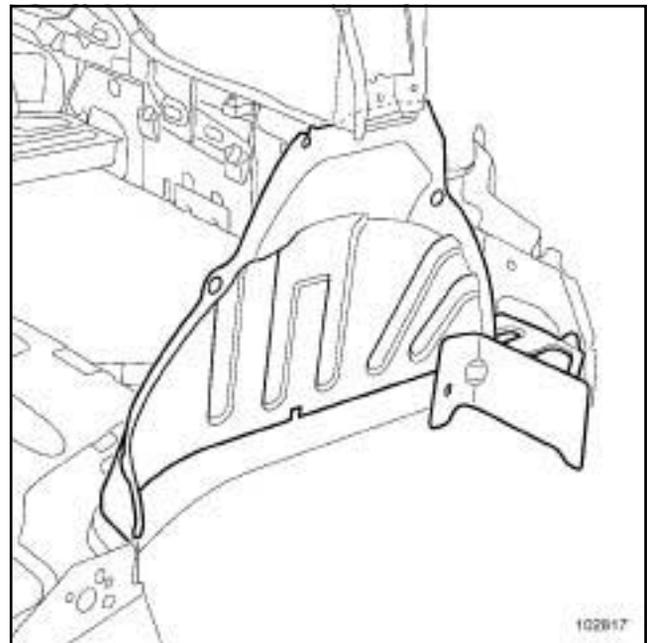


115843

115843

Mark	Description	Type	Thickness (mm)
(1)	Inner rear wheel arch	HEL	0.7
(2)	Rear section of rear wheel arch	HEL	0.7
(3)	Rear light mounting lining	HEL	1
(4)	Rear seat seat-back upper mounting support	HEL	1.5

II - PART FITTED



102817

102817

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

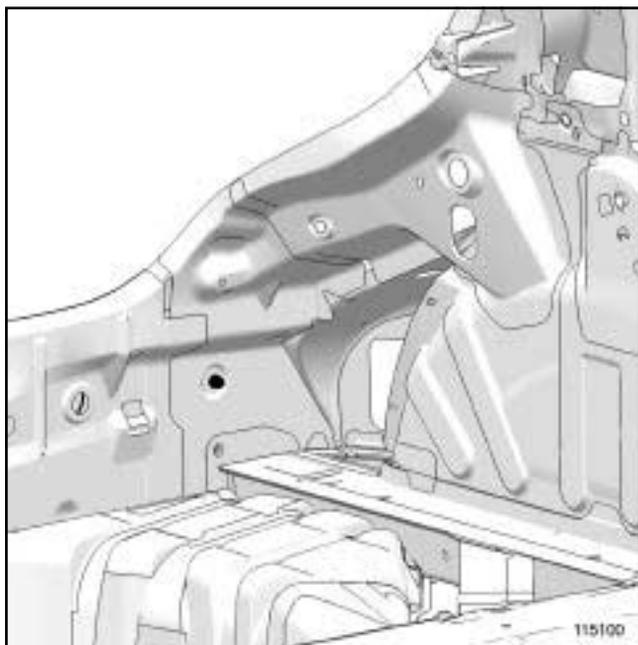
REAR UPPER STRUCTURE

Inner wheel arch: Description

44A

B84 or C84

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



115100

IMPORTANT

To avoid damaging the vehicle's electric and electronic components, the battery and the earths of any wiring harness near the weld area must be disconnected.

The earth of the welding machine must be placed as close as possible to the weld area.

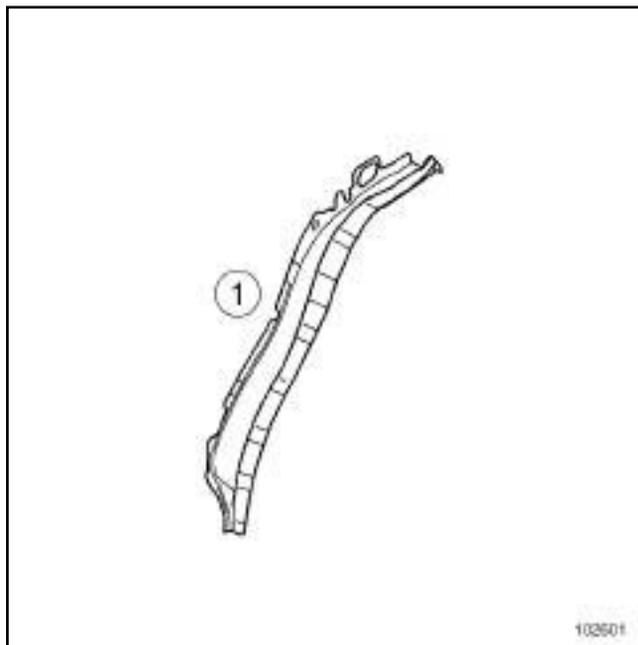
Rear wheel arch closure panel: Description

B84 or C84

There is only one way of replacing this part:

- complete replacement: this operation complements the replacement of the rear outer wheel arch for a side impact.

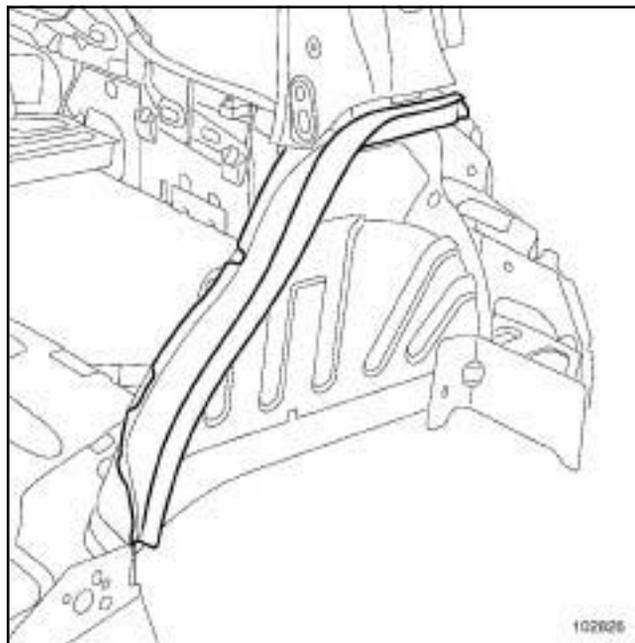
I - COMPOSITION OF THE SPARE PART



102601

II - PART FITTED

Complete replacement



102826

WARNING

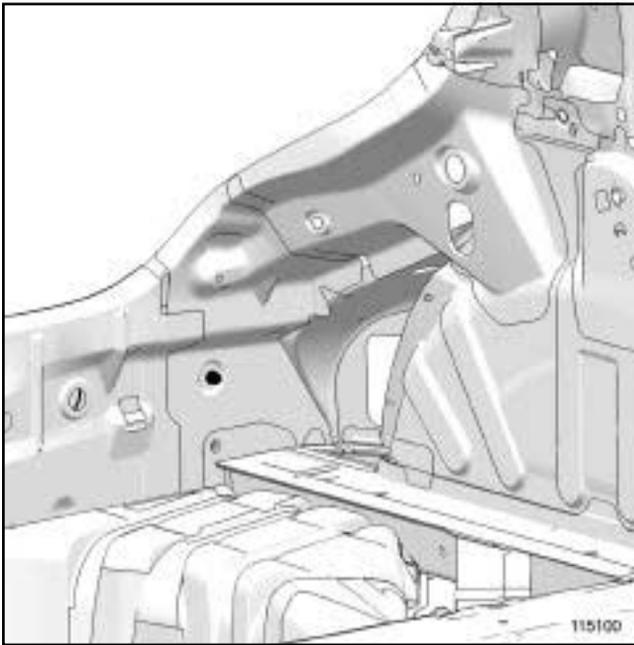
If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

Mark	Description	Type	Thickness (mm)
(1)	Rear wheel arch closure panel	-	0.7

Rear wheel arch closure panel: Description

B84 or C84

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



115100

IMPORTANT

To avoid damaging the vehicle's electric and electronic components, the battery and the earths of any wiring harness near the weld area must be disconnected.

The earth of the welding machine must be placed as close as possible to the weld area.

B84 or C84

There is only one way of replacing this part:

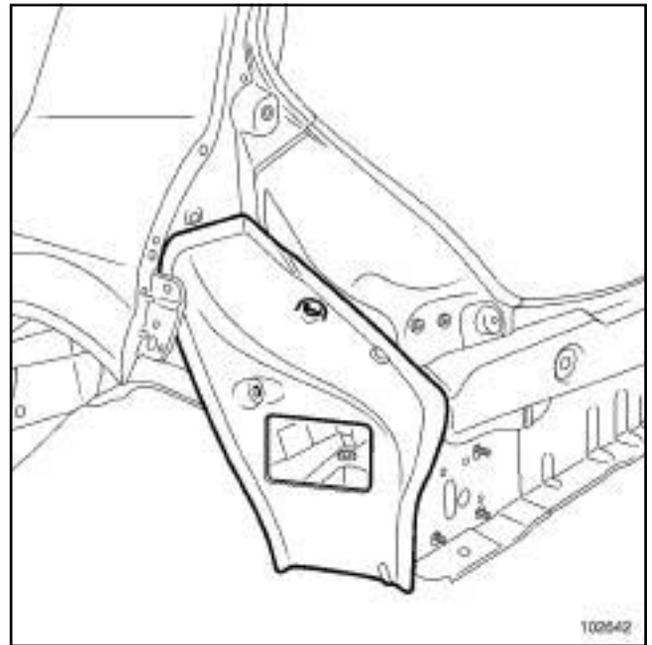
- complete replacement.

I - COMPOSITION OF THE SPARE PART



II - PART FITTED

Complete replacement



WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

Mark	Description	Type	Thickness (mm)
(1)	Rear wheel arch extender.	-	0.7

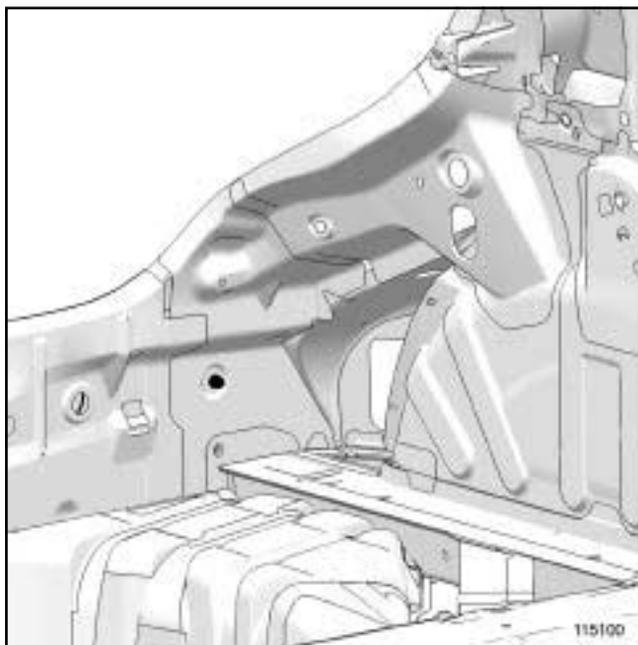
REAR UPPER STRUCTURE

Rear wheel arch extension: Description

44A

B84 or C84

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



115100

IMPORTANT

To avoid damaging the vehicle's electric and electronic components, the battery and the earths of any wiring harness near the weld area must be disconnected.

The earth of the welding machine must be placed as close as possible to the weld area.

REAR UPPER STRUCTURE

Quarter panel lining: General description

44A

B84 or C84

WARNING

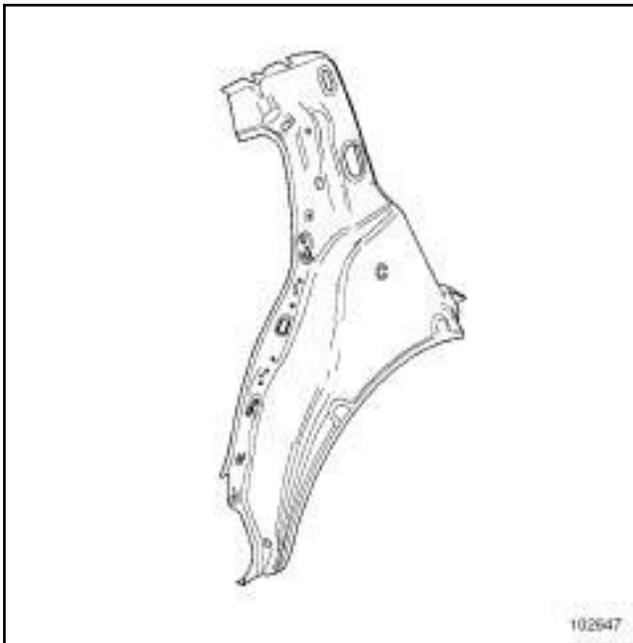
The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information**.

DESIGN OF THE STRUCTURAL COMPONENT



102647

The distinctive feature of this part is that it combines two functions:

- quarter panel lining,
- outer rear wheel arch.

If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400, 40A, General Information**).

REAR UPPER STRUCTURE

Quarter panel reinforcement: Description

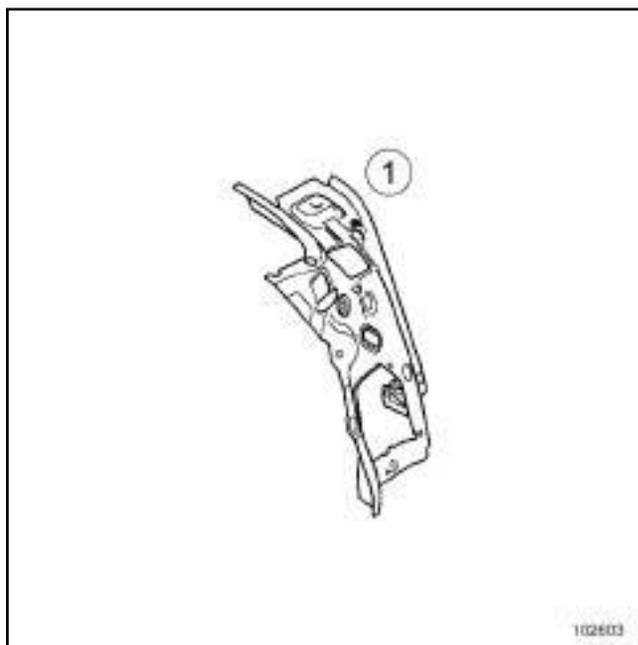
44A

B84 or C84

There is only one way of replacing this part:

- complete replacement: this operation complements the replacement of the quarter panel lining for a side impact.

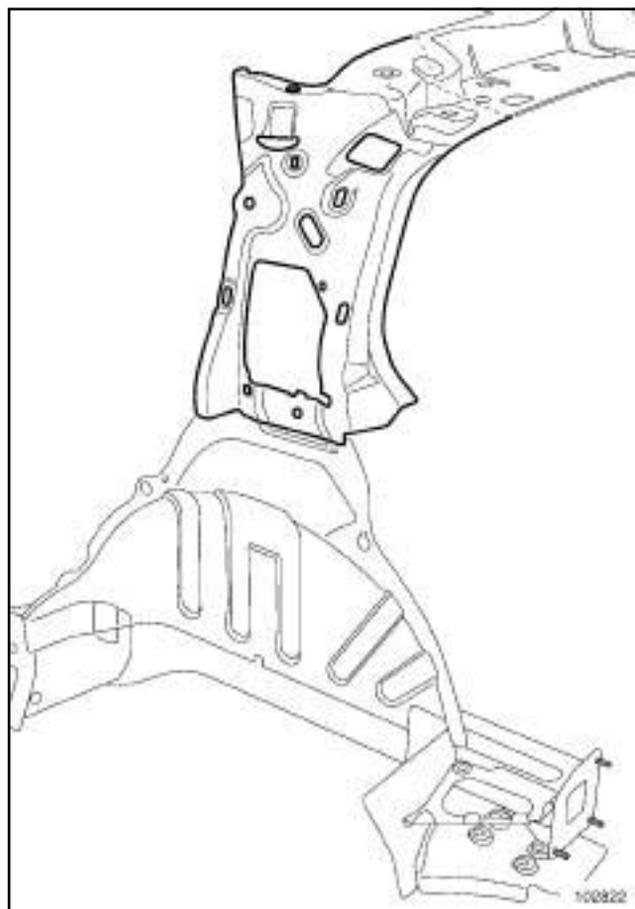
I - COMPOSITION OF THE SPARE PART



102603

II - PART FITTED

Complete replacement



102822

Mark	Description	Type	Thickness (mm)
(1)	Quarter panel stiffener	-	0.9

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

REAR UPPER STRUCTURE

Quarter panel lining: Description

44A

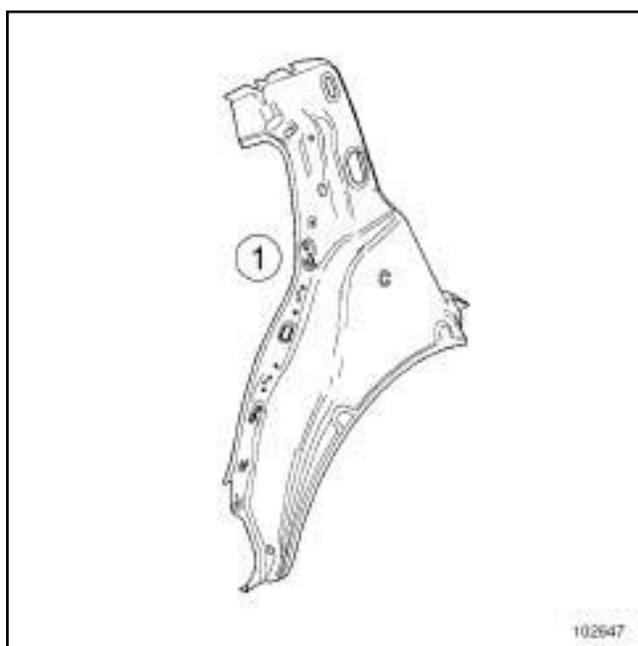
B84 or C84

There is only one way of replacing this part:

- complete replacement: this operation complements the replacement of the rear end panel and rear side member for a rear impact or the rear body side and rear quarter upper reinforcement for a rear side impact.

I - COMPOSITION OF THE SPARE PART

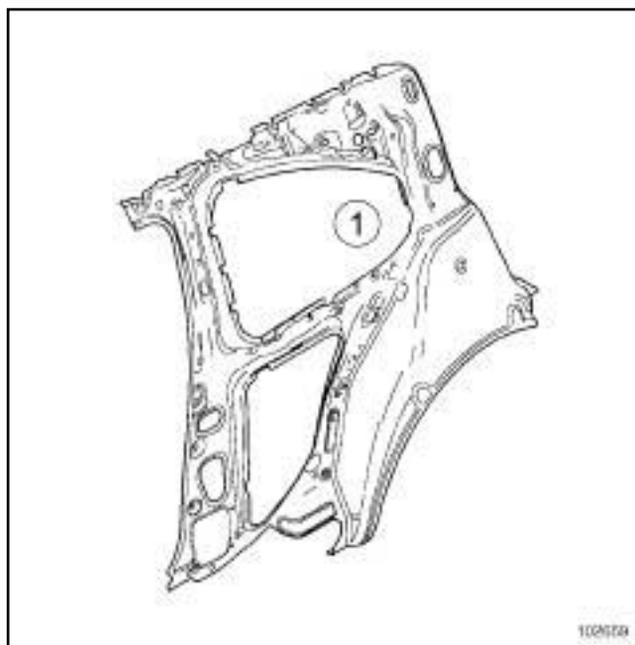
B84



102647

102647

C84



102659

102659

Mark	Description	Type	Thickness (mm)
(1)	Quarter panel lining	-	0.6

REAR UPPER STRUCTURE

Quarter panel lining: Description

44A

B84 or C84

II - PART FITTED

Complete replacement

B84



102825

102825

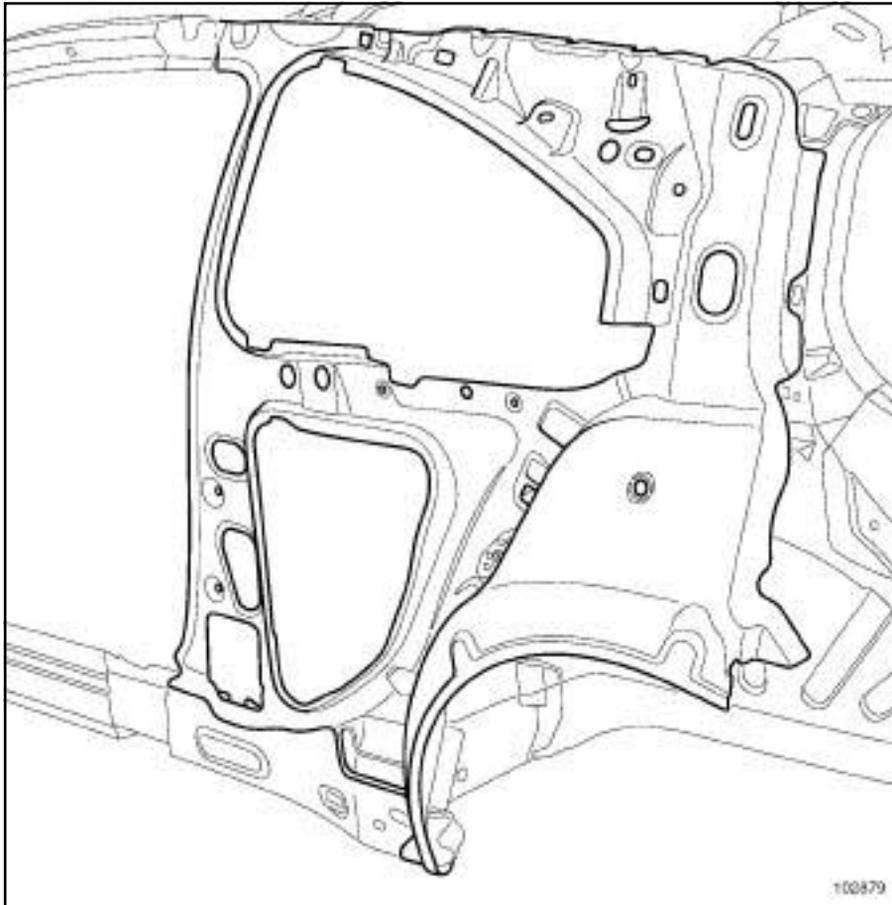
REAR UPPER STRUCTURE

Quarter panel lining: Description

44A

B84 or C84

C84



102879

102879

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

Quarter panel upper reinforcement: Description

B84 or C84

There is only one way of replacing this part:

- complete replacement: this operation complements the replacement of the complete body side or the upper body for a side impact.

I - COMPOSITION OF THE SPARE PART

B84



102617

C84



102610

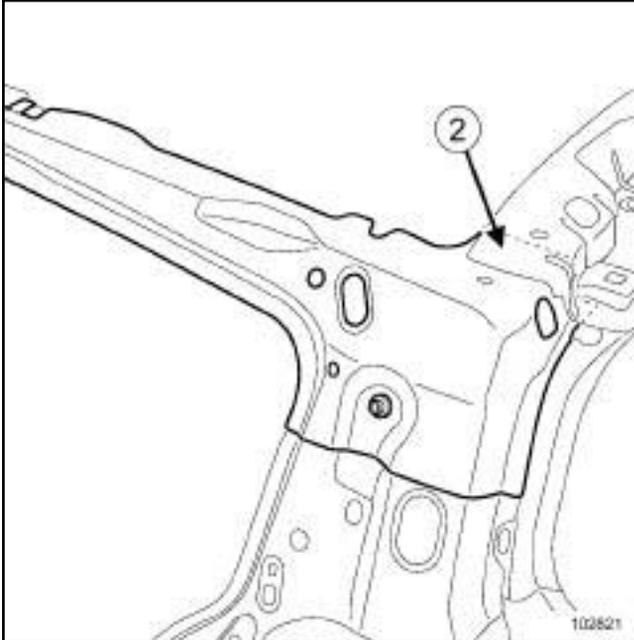
Mark	Description	Type	Thic-kness (mm)
(1)	Quarter panel upper reinforcement	-	0.9

B84 or C84

II - PART FITTED

Complete replacement

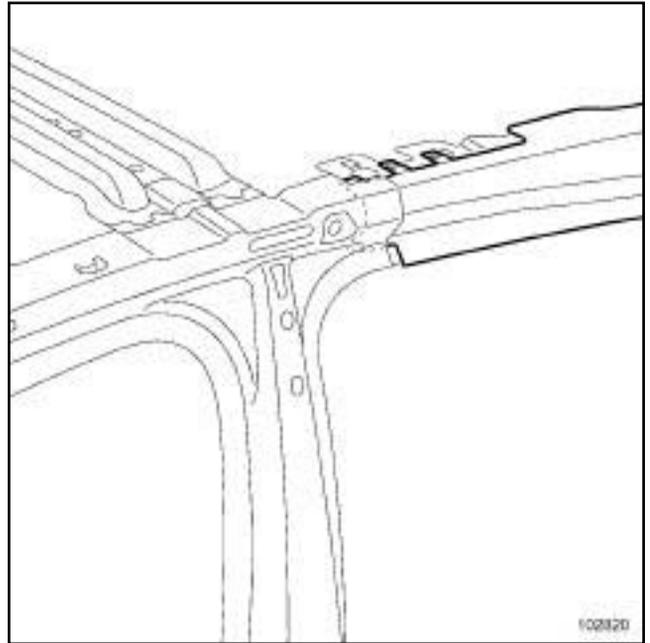
B84



102821

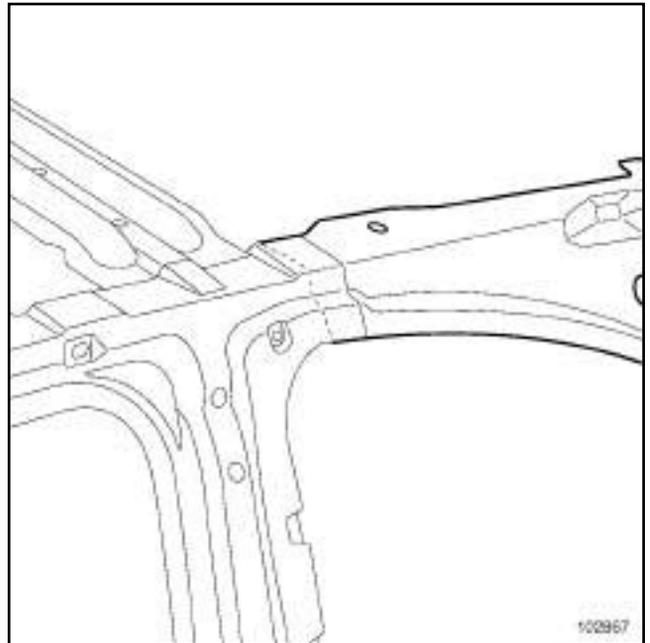
Note:

To replace this part, partially detach the side lining (2) from the roof rear cross member.



102820

C84



102867

Note:

The rear section of the **3-door** version is identical to the **5-door** version.

REAR UPPER STRUCTURE

44A

Quarter panel upper reinforcement: Description

B84 or C84

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

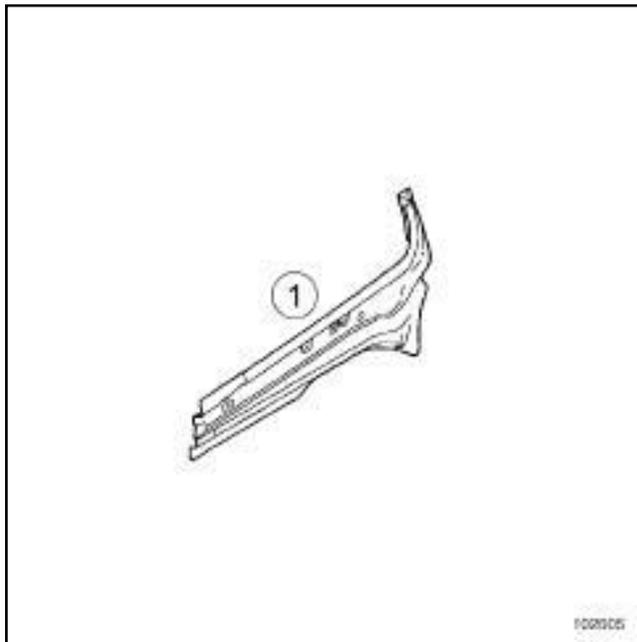
Quarter panel centre reinforcement: Description

C84

There is only one way of replacing this part:

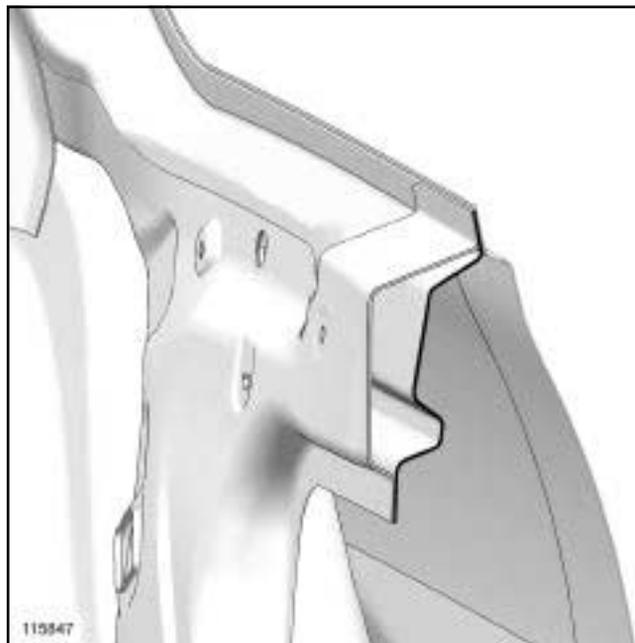
- complete replacement: this operation complements the replacement of the rear wing panel for a rear side impact.

I - COMPOSITION OF THE SPARE PART



102605

Cut A



115847

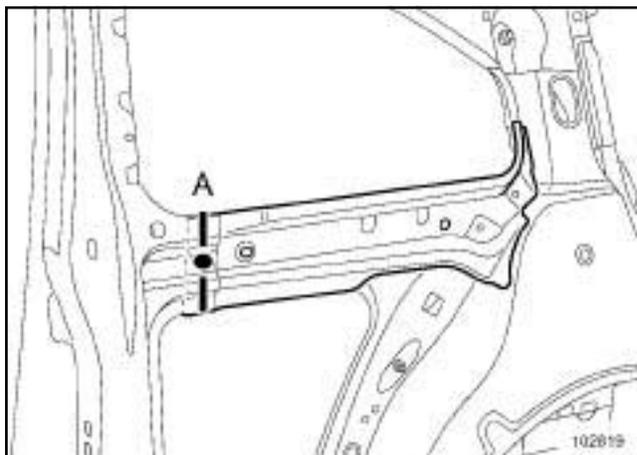
WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

Mark	Description	Type	Thickness (mm)
(1)	Quarter panel centre reinforcement	-	0.9

II - PART FITTED

Complete replacement



102819

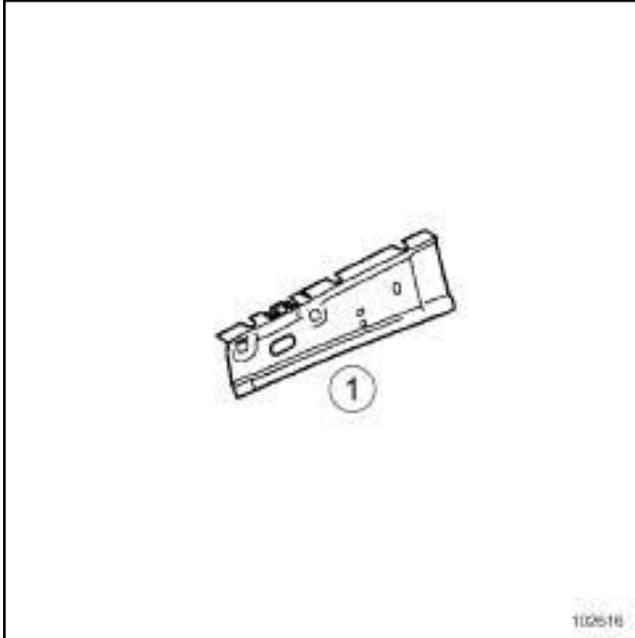
B84 or C84

There is only one way of replacing this part:

- complete replacement: this operation complements the replacement of the complete body side or the upper body for a side impact.

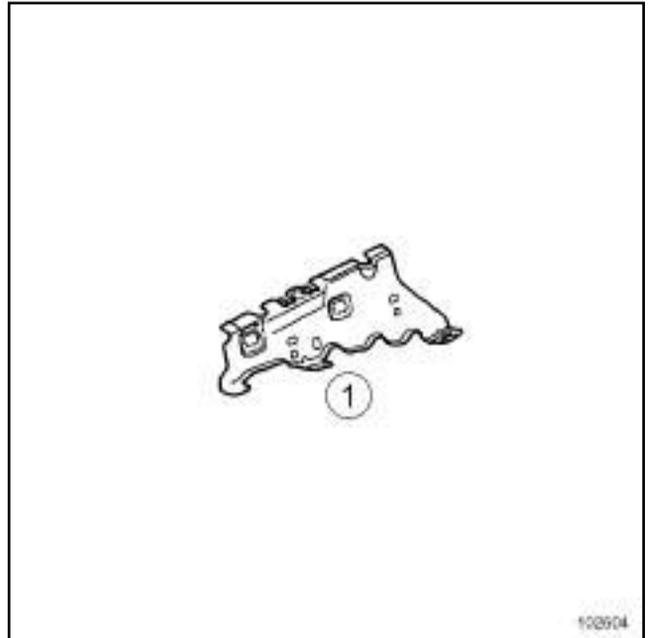
I - COMPOSITION OF THE SPARE PART

B84



102616

C84

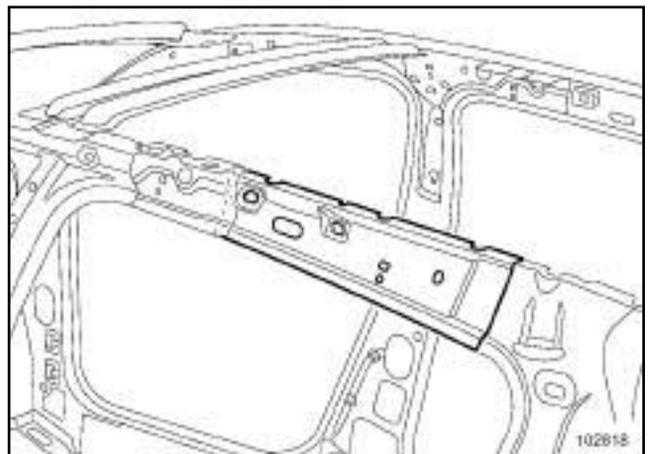


102604

Mark	Description	Type	Thickness (mm)
(1)	Rear roof drip moulding lining	-	0.9

II - PART FITTED

B84



102818

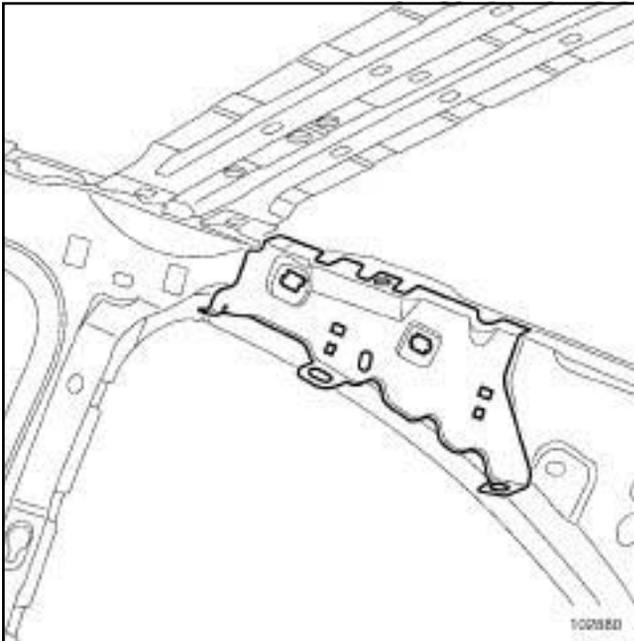
REAR UPPER STRUCTURE

Roof rear drip moulding lining: Description

44A

B84 or C84

C84



102880

WARNING

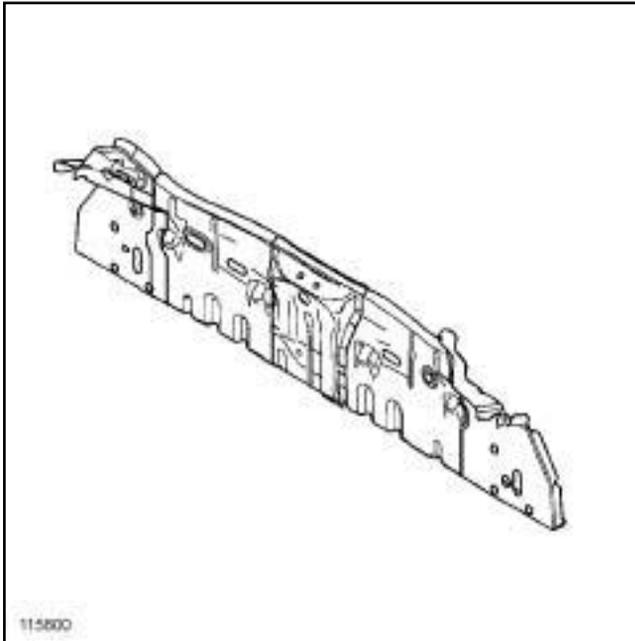
If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

REAR UPPER STRUCTURE

Rear end panel assembly: Description

44A

B84 or C84

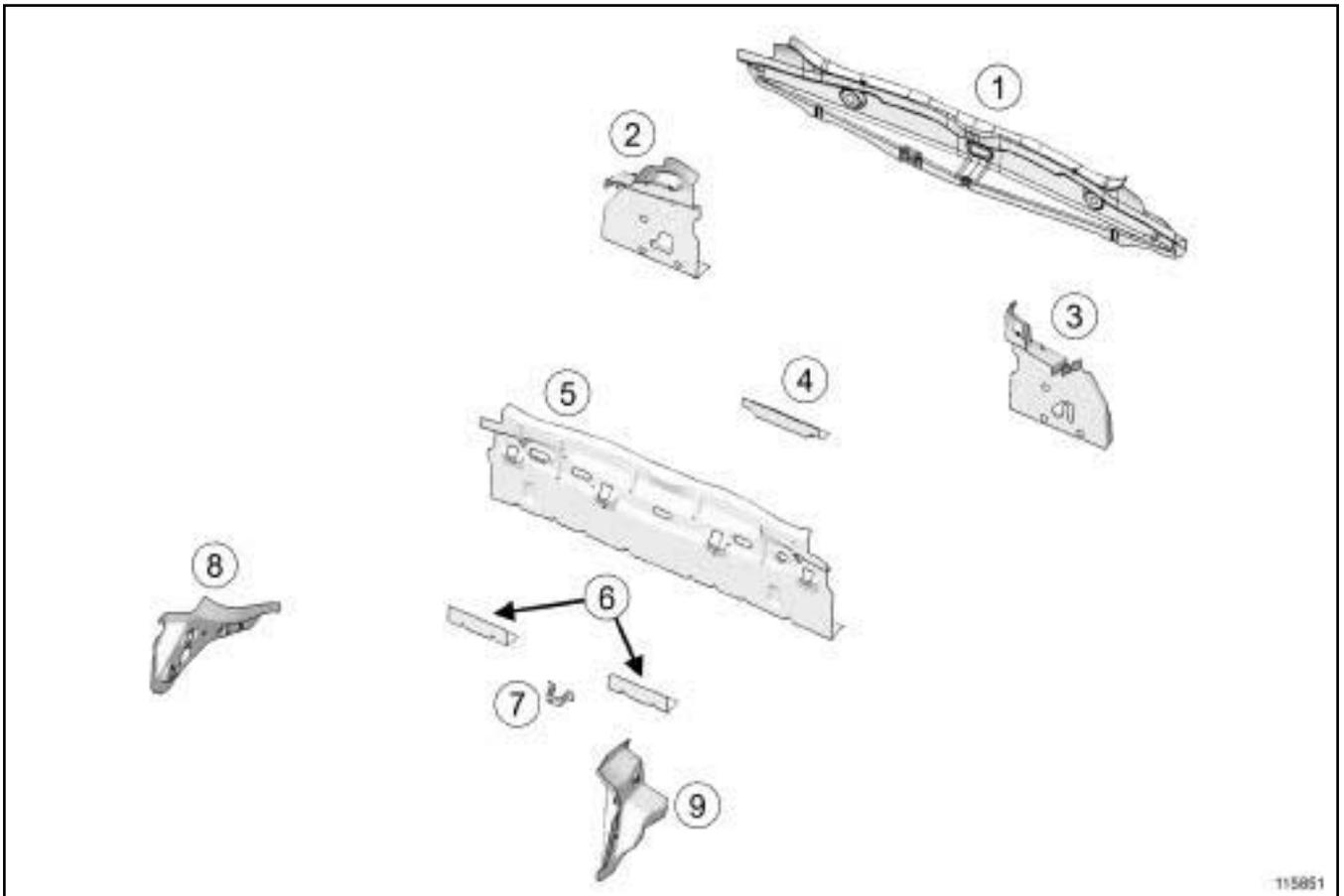


115800

There is only one way of replacing this part:

- complete replacement: this operation complements the replacement of the light mounting lining for a rear impact.

I - COMPOSITION OF THE SPARE PART



115851

REAR UPPER STRUCTURE

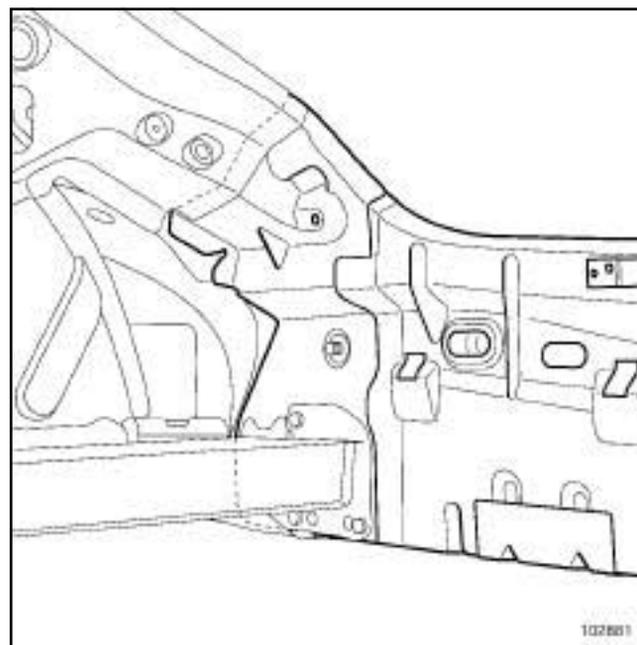
Rear end panel assembly: Description

44A

B84 or C84

II - PART FITTED

Complete replacement



102881

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

Mark	Description	Type	Thickness (mm)
(1)	Rear end panel	-	0.7
(2)	Rear end panel lining, right-hand side section	-	0.7
(3)	Rear end panel lining, left-hand side section	-	0.7
(4)	Rear end panel lining reinforcement	VHEL	1.8
(5)	Rear end panel lining, centre section	-	0.7
(6)	Rear end panel lining trim mounting bridge piece	-	1
(7)	Tank mounting reinforcement	VHEL	2.5
(8)	Rear floor rear right-hand section mounting reinforcement	HEL	2
(9)	Rear floor rear left-hand section mounting reinforcement	HEL	2

REAR UPPER STRUCTURE

Rear end panel: General description

44A

B84 or C84

WARNING

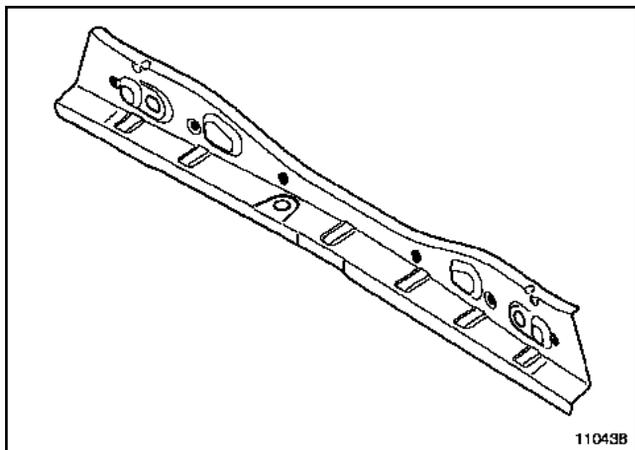
The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information** .

DESIGN OF THE STRUCTURAL COMPONENT



110438

This is a basic part, and its only function is that of the rear end panel.

If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400, 40A, General Information**).

REAR UPPER STRUCTURE

Rear end panel: Description

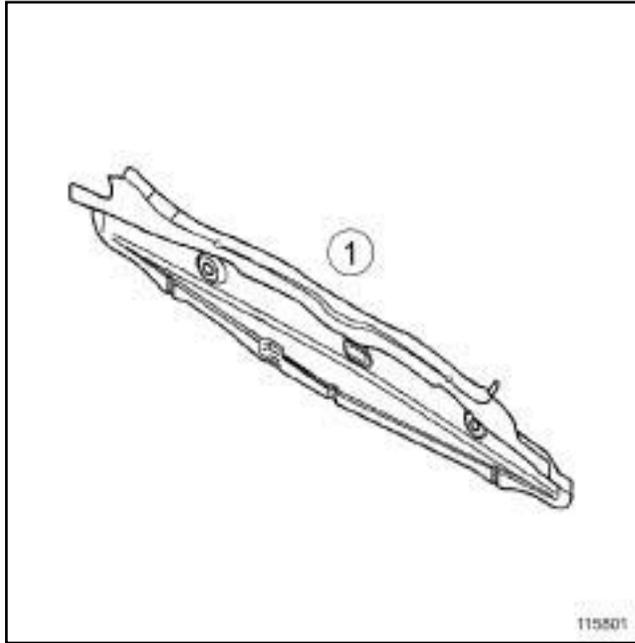
44A

B84 or C84

The options for replacing this part are as follows:

- partial replacement,
- complete replacement.

I - COMPOSITION OF THE SPARE PART

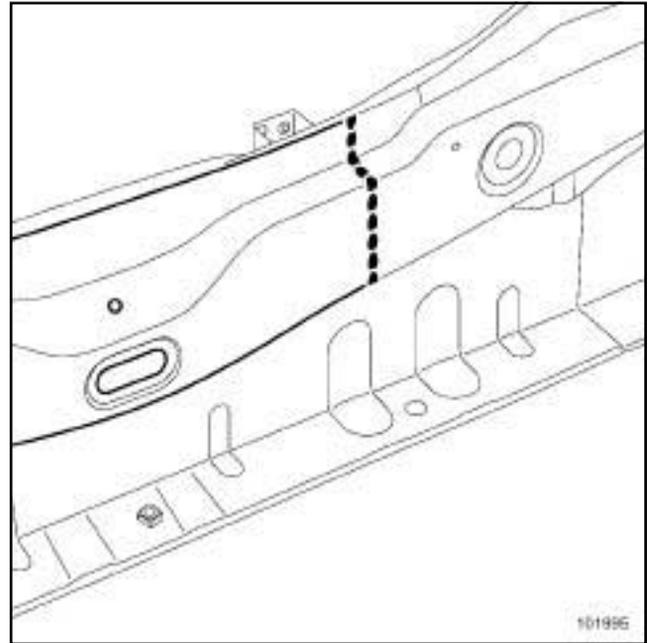


115801

Mark	Description	Type	Thickness (mm)
(1)	Rear end panel	-	0.7

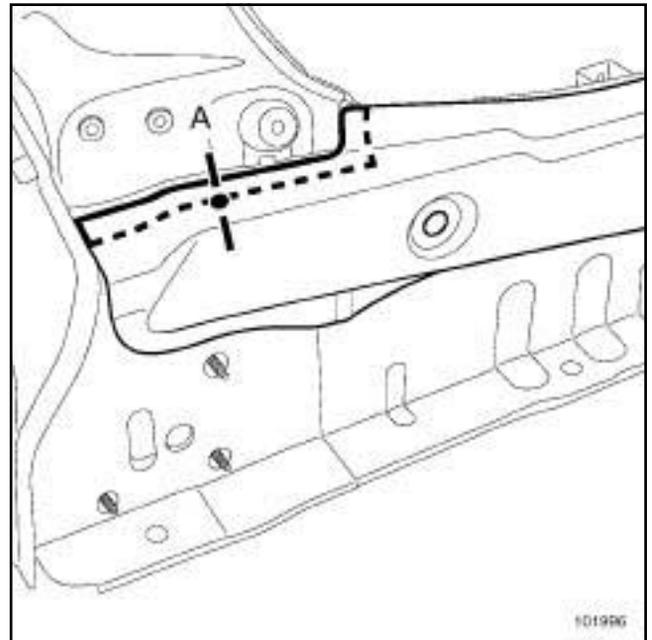
II - PART FITTED

1 - Partial replacement



101996

2 - Complete replacement



101996

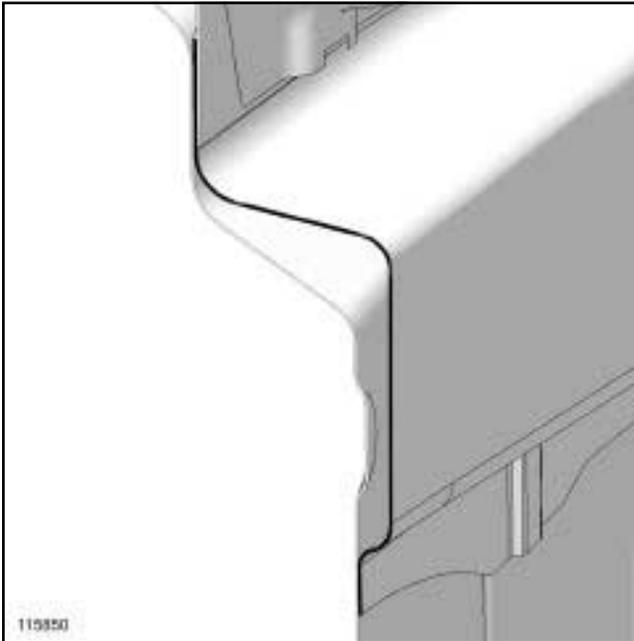
REAR UPPER STRUCTURE

Rear end panel: Description

44A

B84 or C84

Cut A



115850

IMPORTANT

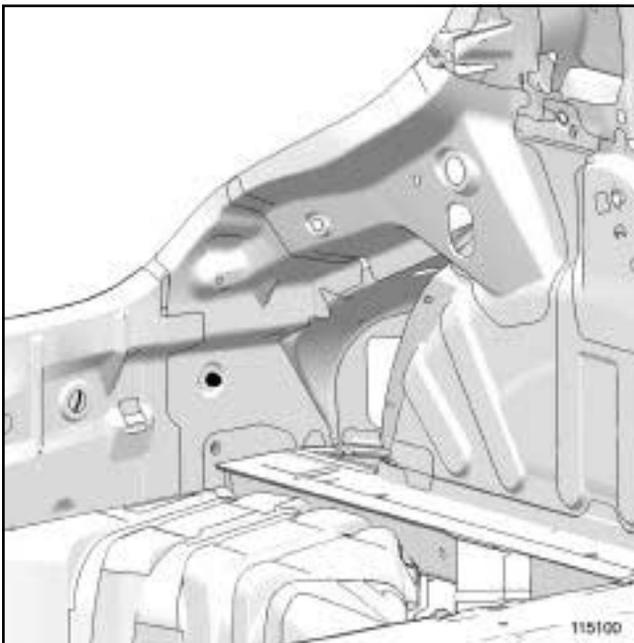
To avoid damaging the vehicle's electric and electronic components, the battery and the earths of any wiring harness near the weld area must be disconnected.

The earth of the welding machine must be placed as close as possible to the weld area.

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

III - POSITIONING OF LOCAL ELECTRICAL EARTHS



115100

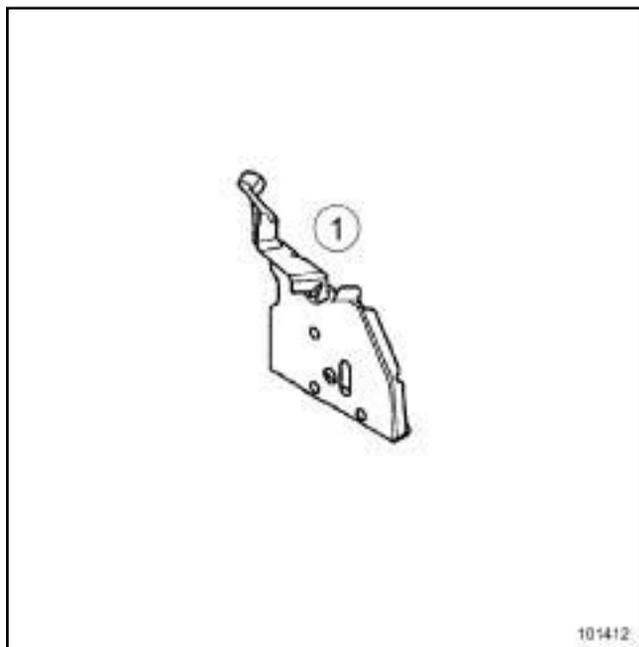
Rear end panel side lining: Description

B84 or C84

There is only one way of replacing this part:

- partial replacement.

I - COMPOSITION OF THE SPARE PART



101412
101412

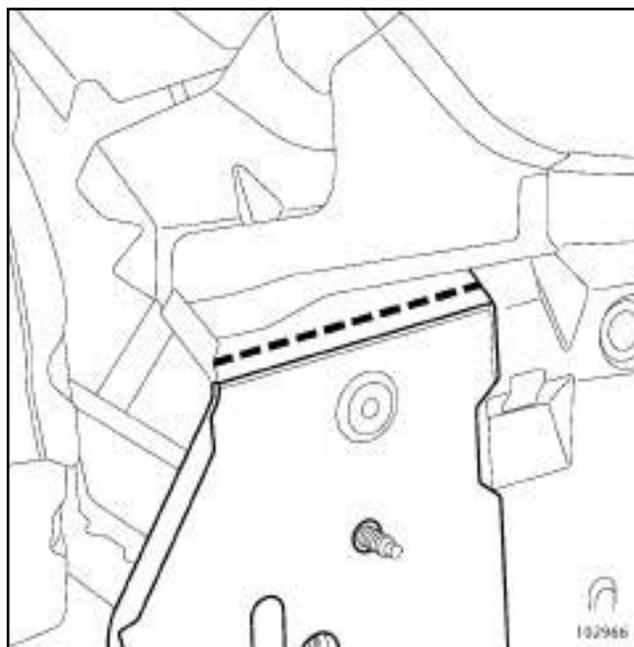
II - PART FITTED

Partial replacement



102965
102965

Detailed view of the cut



102966
102966

Mark	Description	Type	Thickness (mm)
(1)	Rear end panel side lining	-	0.7

WARNING

If the spot welds cannot be made as they were originally using an electrical spot welding machine, these should be replaced with plug welds after holes have been drilled in the first panel.

TOP OF BODY

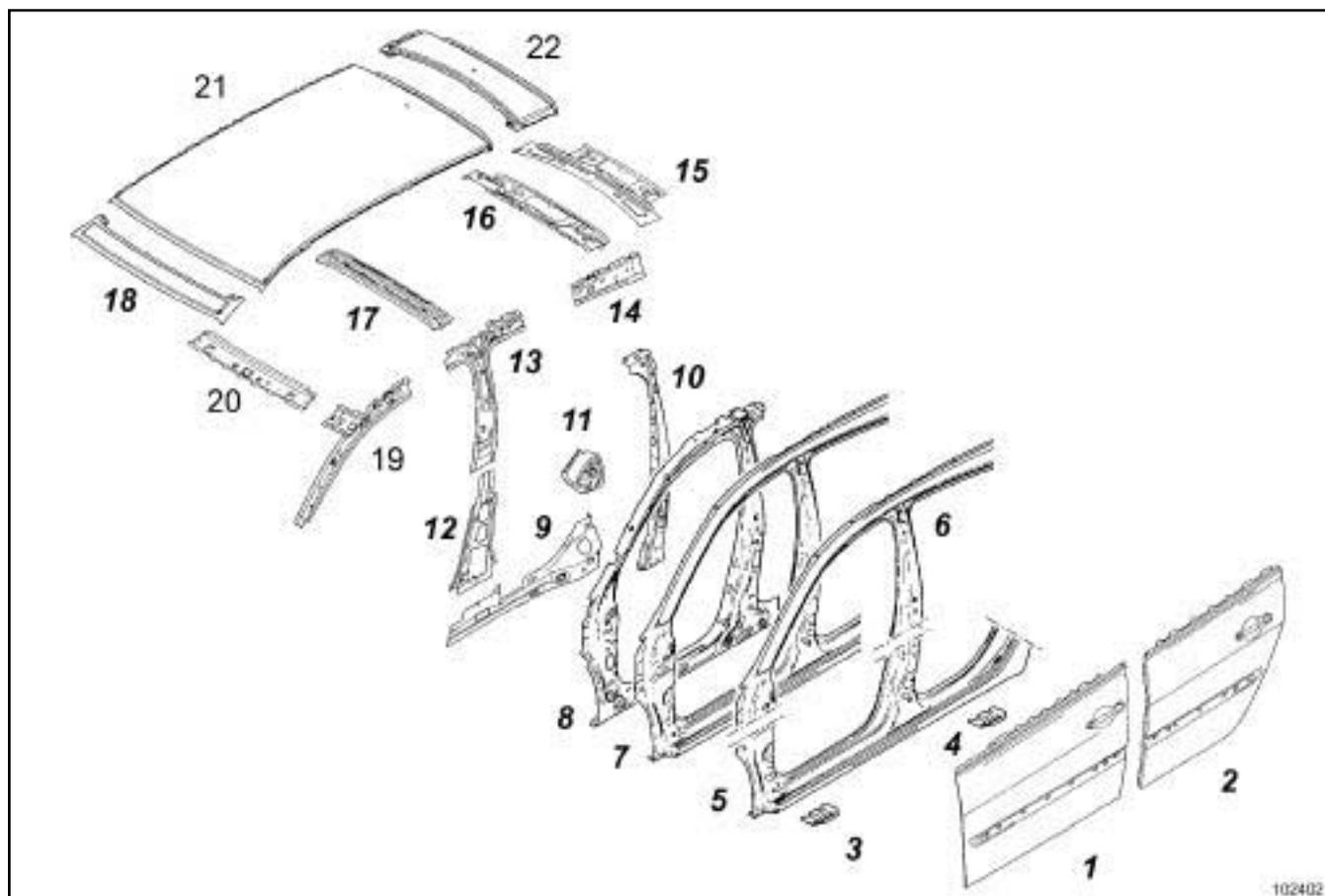
Vehicle side section structure: Description

45A

B84 or C84

SIDE STRUCTURE

B84



102402

Mark	Description	Classification	Type	Thickness (mm)
(1)	Front side door panel	(see Front side door panel: Description)	HLE	0.7/0.95
(2)	Rear side door panel	(see Rear side door panel: Description)	HLE	0.7/0.95
(3)	Front jack support	(see Front jacking point: Description)	HLE	1.8
(4)	Rear jack support	(see Front jacking point: Description)	HLE	1.8
(5)	Sill panel	(see 41C, Side lower structure, Sill panel: Description, page 41C-9)	-	0.7
(6)	Upper body	(see 43A, Side upper structure, Upper body panel: Description, page 43A-47)	-	0.7

Vehicle side section structure: Description

B84 or C84

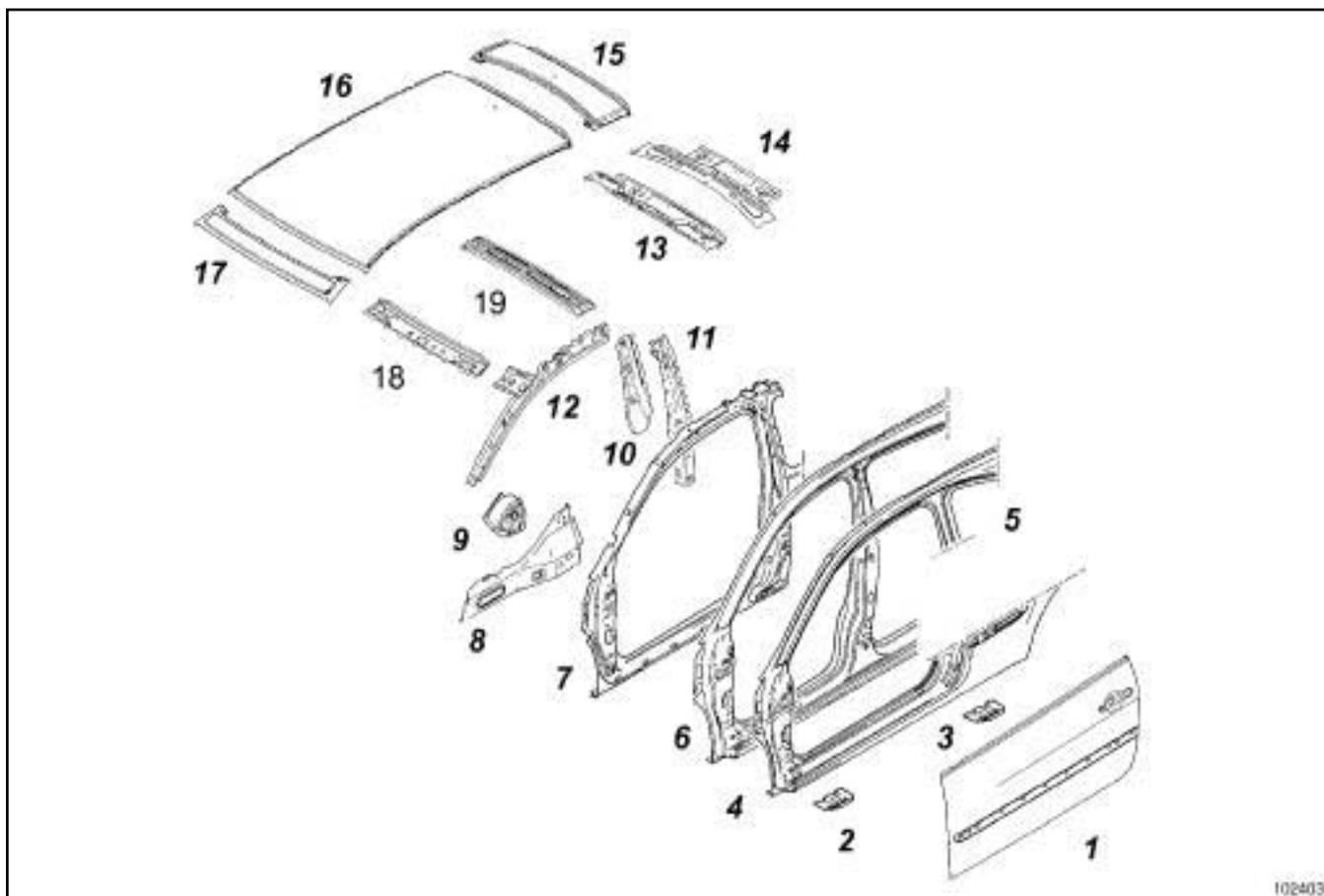
Mark	Description	Classification	Type	Thickness (mm)
(7)	Body side front section	(see 43A, Side upper structure, Body side front section: Description, page 43A-39)	-	0.7
(8)	Body side front section reinforcement	(see 43A, Side upper structure, Body side front section reinforcement: Description, page 43A-42)	HLE	1.2/1.5
(9)	Rear inner sill panel	(see 41C, Side lower structure, Rear inner sill panel: Description, page 41C-23)	HLE	1
(10)	B-pillar reinforcement stiffener	(see B-pillar reinforcement stiffener: Description)	HLE	1.5/2.2
(11)	Anti-intrusion reinforcement			
(12)	B-pillar lower lining	(see B-pillar lower lining: Description)	-	0.7
(13)	B-pillar upper lining	(see B-pillar upper lining: Description)	HLE	1.5
(14)	Rear roof drip moulding lining	(see Roof drip moulding lining: Description)	-	1
(15)	Roof rear cross member with sunroof	(see 45A, Top of body, Roof rear cross member: Description, page 45A-16)	HLE	0.7/0.9
(16)	Roof rear cross member without sunroof	(see 45A, Top of body, Roof rear cross member: Description, page 45A-16)	HLE	0.7/0.9
(17)	Roof middle cross member	(see 45A, Top of body, Roof centre cross member: Description, page 45A-14)	HLE	1.5
(18)	Front section of roof	(see 45A, Top of body, Roof front section: Description, page 45A-9)	-	0.7
(19)	A-pillar lining	(see 43A, Side upper structure, Windscreen pillar lining: Description, page 43A-16)	HLE	1.5/2
(20)	Roof front cross member	(see 45A, Top of body, Roof front cross member: Description, page 45A-12)	HLE	0.7

Vehicle side section structure: Description

B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(21)	Roof	(see 45A, Top of body, Roof: Description, page 45A-7)	-	0.7
(22)	Rear section of roof	(see 45A, Top of body, Roof rear section: Description, page 45A-10)	-	0.7

C84



102403

102403

Mark	Description	Classification	Type	Thickness (mm)
(1)	Front side door panel	(see Front side door panel: Description)	HLE	0.7/0.95
(2)	Front jack support	(see Front jacking point: Description)	HLE	1.8
(3)	Rear jack support	(see Front jacking point: Description)	HLE	1.8

Vehicle side section structure: Description

B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(4)	Sill panel	(see 41C, Side lower structure, Sill panel: Description, page 41C-9)	-	0.7
(5)	Upper body	(see 43A, Side upper structure, Upper body panel: Description, page 43A-47)	-	0.7
(6)	Body side front section	(see 43A, Side upper structure, Body side front section: Description, page 43A-39)	-	0.7
(7)	Body side front section reinforcement	(see 43A, Side upper structure, Body side front section reinforcement: Description, page 43A-42)	HLE	1.2/1.5
(8)	Rear inner sill panel	(see 41C, Side lower structure, Rear inner sill panel: Description, page 41C-23)	HLE	1
(9)	Anti-intrusion reinforcement			
(10)	Quarter panel front reinforcement		HLE	1.5
(11)	B-pillar reinforcement stiffener	(see B-pillar reinforcement stiffener: Description)	VHLE	1.8
(12)	A-pillar lining	(see 43A, Side upper structure, Windscreen pillar lining: Description, page 43A-16)	HLE	1.5/2
(13)	Roof rear cross member without sunroof	(see 45A, Top of body, Roof rear cross member: Description, page 45A-16)	HLE	0.7/0.9
(14)	Roof rear cross member with sunroof	(see 45A, Top of body, Roof rear cross member: Description, page 45A-16)	HLE	0.7/0.9
(15)	Rear section of roof	(see 45A, Top of body, Roof rear section: Description, page 45A-10)	-	0.7
(16)	Roof	(see 45A, Top of body, Roof: Description, page 45A-7)	-	0.7
(17)	Front section of roof	(see 45A, Top of body, Roof front section: Description, page 45A-9)	-	0.7

TOP OF BODY

45A

Vehicle side section structure: Description

B84 or C84

Mark	Description	Classification	Type	Thickness (mm)
(18)	Roof front cross member	(see 45A, Top of body, Roof front cross member: Description, page 45A-12)	HLE	0.7
(19)	Roof middle cross member	(see 45A, Top of body, Roof centre cross member: Description, page 45A-14)	HLE	1.5



TOP OF BODY

Roof: General description

45A

B84 or C84

WARNING

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information** .

DESIGN OF THE STRUCTURAL COMPONENT



112147

This is a basic part; its only function is that of a roof.

The roof is welded onto the body sides.

There are also models with an aperture for a sunroof.

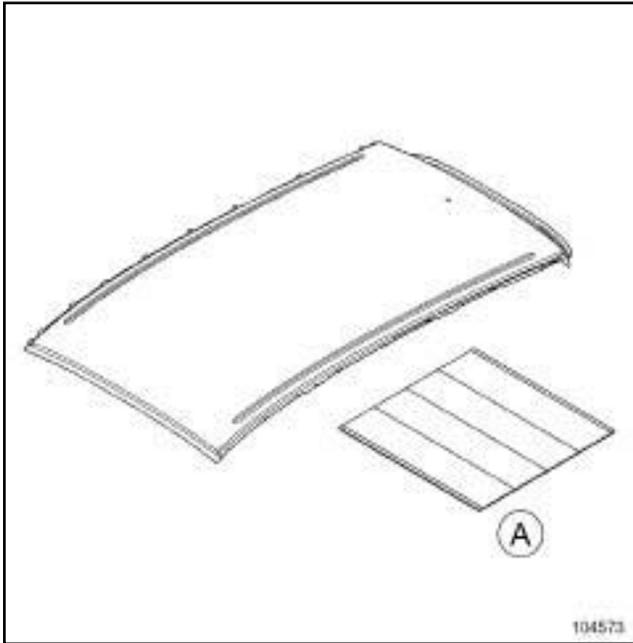
If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400, 40A, General Information**).

TOP OF BODY

Roof: Description

45A

B84 or C84



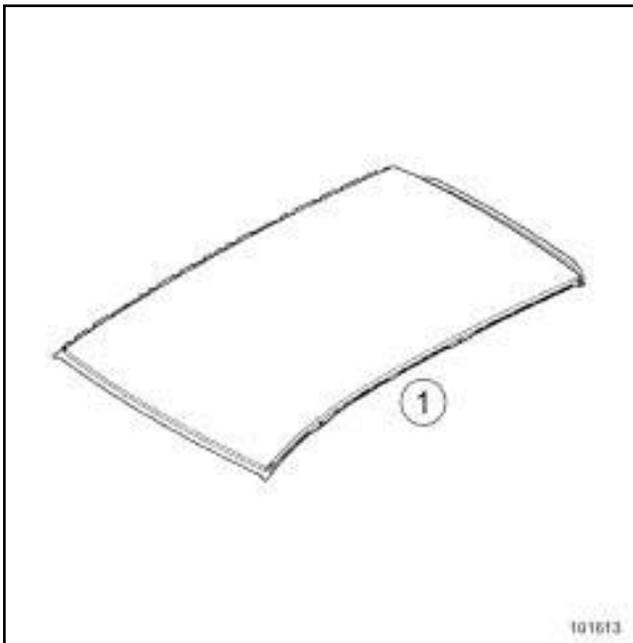
104573

To replace this part, also order the roof stiffener material (A) (see **Parts Catalogue**).

There is only one way of replacing this part:

- complete replacement.

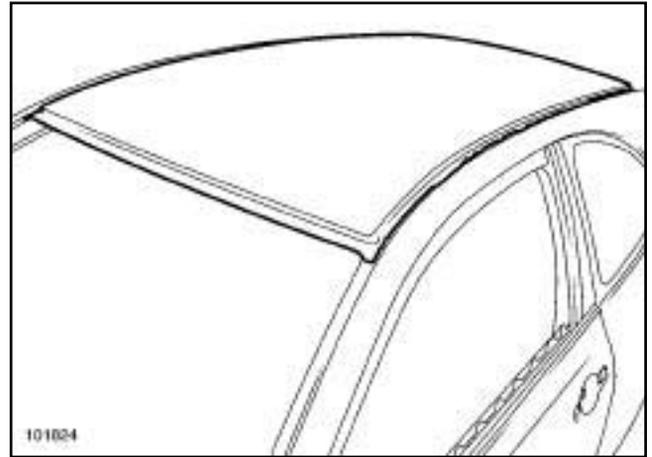
I - COMPOSITION OF THE SPARE PART



101613

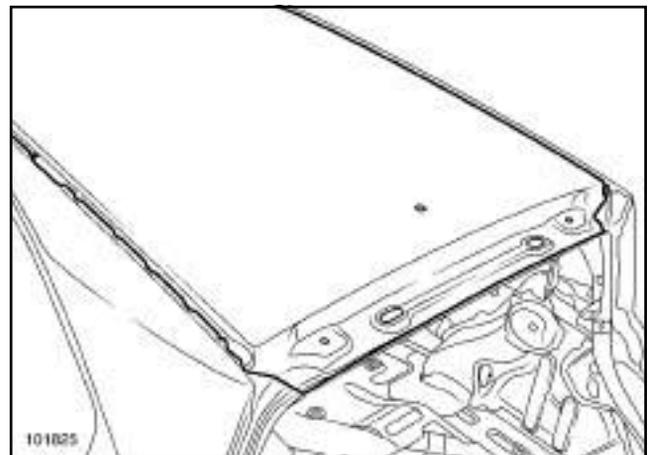
101613

II - PART FITTED



101824

101824



101825

101825

WARNING

If the spot welds cannot be made as they were originally using an electric spot welding machine, they should be replaced with plug welds after holes have been drilled in the first panel.

Note:

The procedure presents no difficulties.

Mark	Description	Type	Thickness (mm)
(1)	Roof	-	0.7

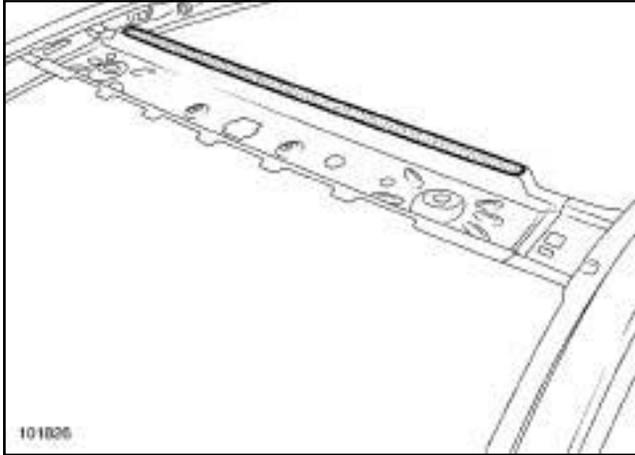
TOP OF BODY

Roof: Description

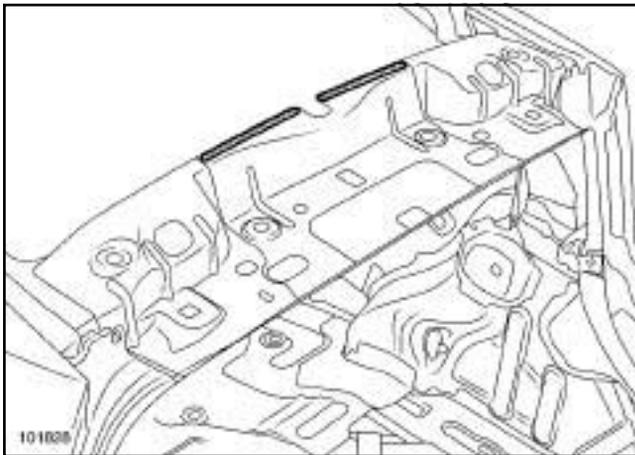
45A

B84 or C84

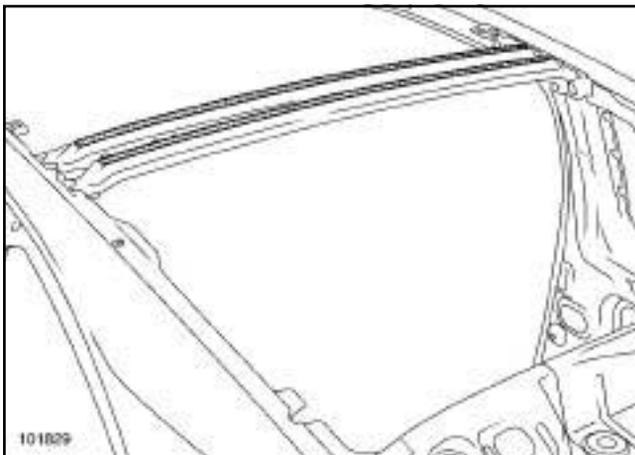
Bonding area



101826



101828



101829

For a detailed description of a particular connection (see **MR 400, 40A, General information**).

TOP OF BODY

Roof front section: Description

45A

B84 or C84

There is only one way of replacing this part:

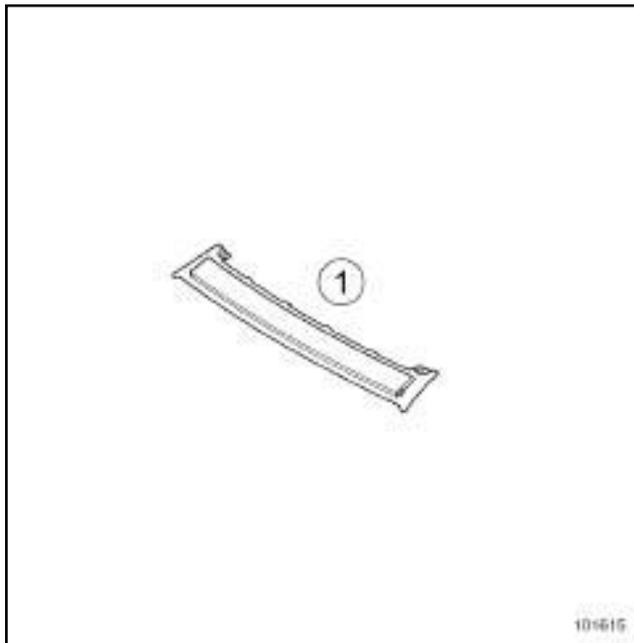
- complete replacement.

This operation only affects versions equipped with a sunroof.

Note:

The procedure for replacing this part has no special notes, and joints can all be made as originally.

I - COMPOSITION OF THE SPARE PART

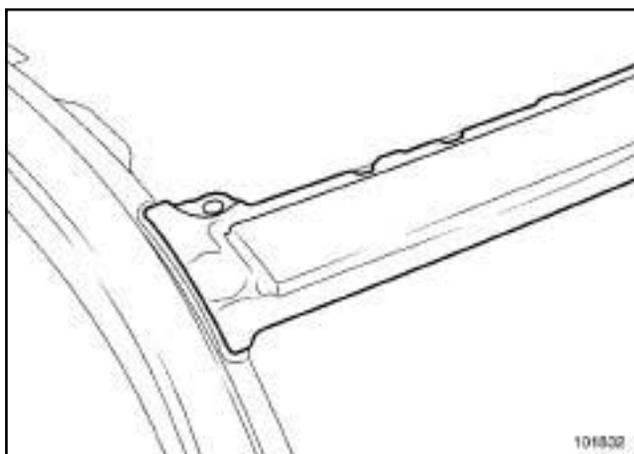


101615

Part supplied on its own.

Mark	Description	Type	Thickness (mm)
(1)	Front section of roof	-	0.7

II - PART FITTED



101832

TOP OF BODY

Roof rear section: Description

45A

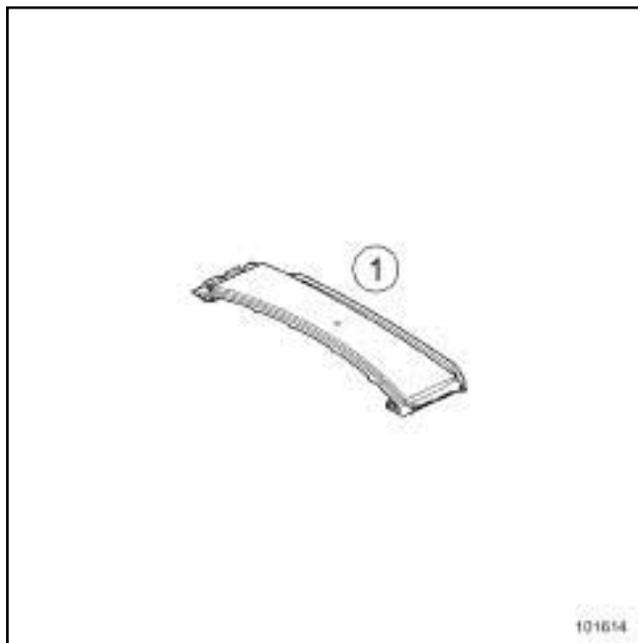
B84 or C84

There is only one way of replacing this part:

- complete replacement.

This operation only affects versions equipped with a sunroof.

I - COMPOSITION OF THE SPARE PART



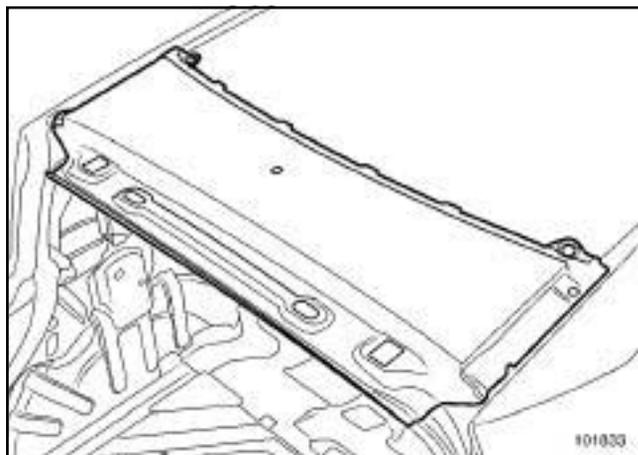
101614

101614

Part supplied on its own.

Mark	Description	Type	Thickness (mm)
(1)	Rear section of roof	-	0.7

II - PART FITTED



101833

101833

WARNING

If the spot welds cannot be made as they were originally using an electric spot welding machine, they should be replaced with plug welds after holes have been drilled in the first panel.

Roof front cross member: General description

B84 or C84

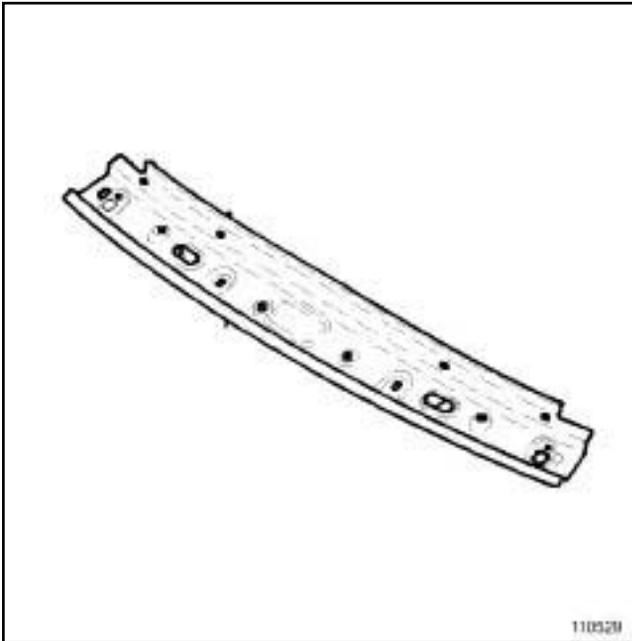
WARNING

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

DESIGN OF THE STRUCTURAL COMPONENT**Note:**

For a detailed description of a particular connection, see **MR 400, 40A, General Information**.



110529

This is a basic part; its only function is that of a roof front cross member and roof stiffener by means of a cemented connection.

If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400, 40A, General Information**).

TOP OF BODY

Roof front cross member: Description

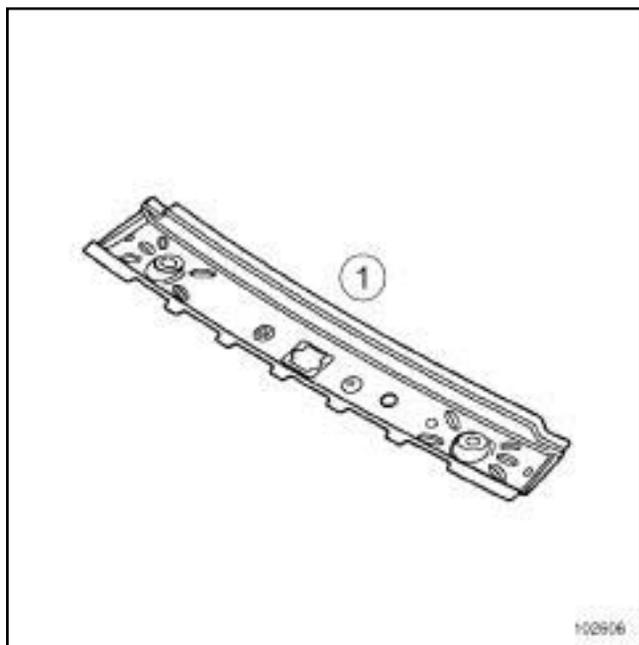
45A

B84 or C84

There is only one way of replacing this part:

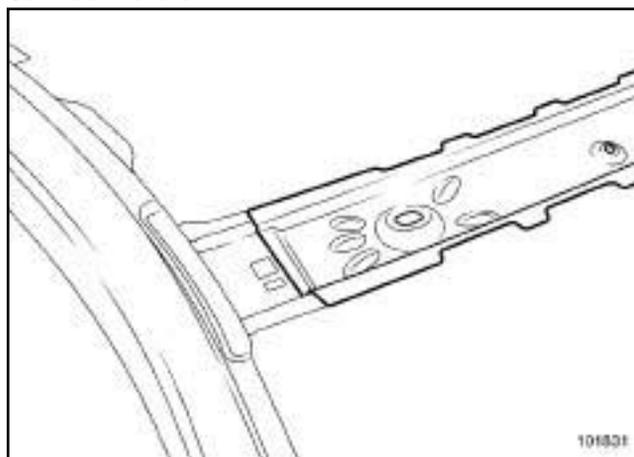
- Complete replacement: this operation supplements the replacement of the roof for the normal roof version and the roof front section for the sunroof version.

I - COMPOSITION OF THE SPARE PART



102606

Sunroof version



101831

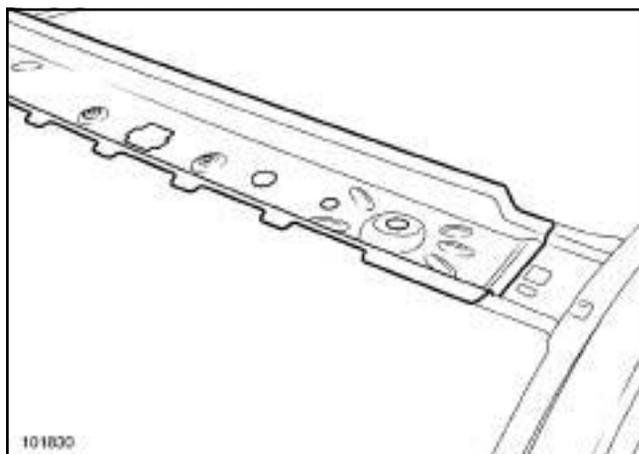
Note:

There is no specific procedure for replacing this part; all connections can be made as they originally were.

Mark	Description	Type	Thickness (mm)
(1)	Roof front cross member	HLE	0.7

II - PART FITTED

Standard roof version



101830

Roof centre cross member: General description

B84 or C84

WARNING

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information**.

DESIGN OF THE STRUCTURAL COMPONENT

112723

This is a basic part; its only function is that of a roof centre cross member and roof stiffener by means of a cemented connection.

If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400, 40A, General Information**).

TOP OF BODY

Roof centre cross member: Description

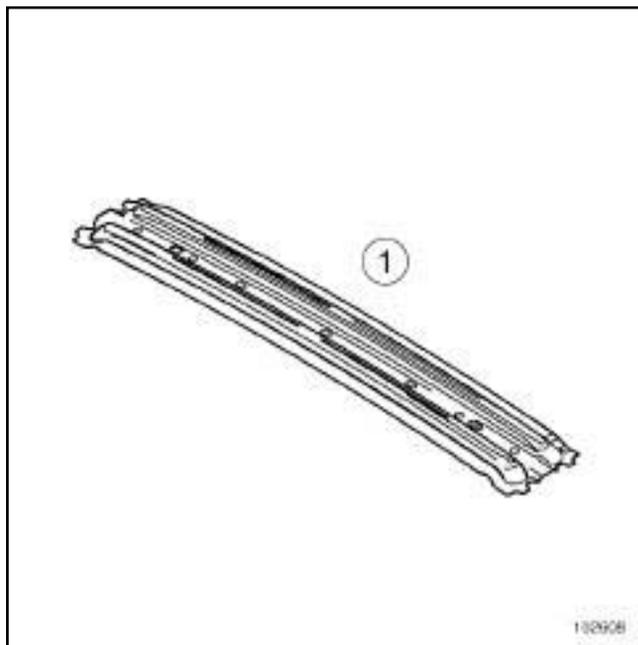
45A

B84 or C84

There is only one way of replacing this part:

- Complete replacement: this operation supplements the replacement of the roof.

I - COMPOSITION OF THE SPARE PART



102608

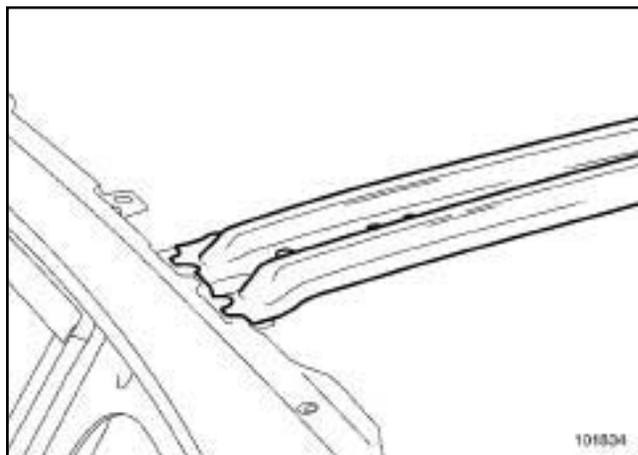
Part supplied on its own.

Note:

There is no specific procedure for replacing this part; all connections can be made as they originally were.

Mark	Description	Type	Thickness (mm)
(1)	Roof centre cross member	HLE	1.5

II - PART FITTED



101834

Roof rear cross member: General description

B84 or C84

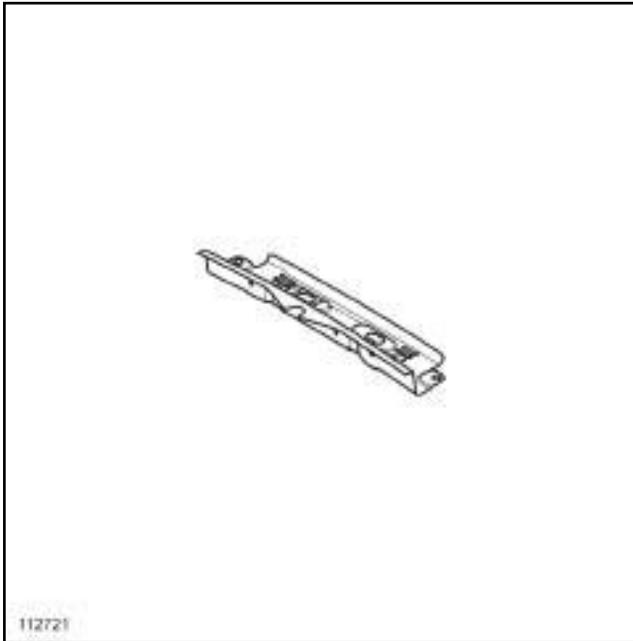
WARNING

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

Note:

For a detailed description of a particular connection, see **MR 400, 40A, General Information**.

DESIGN OF THE STRUCTURAL COMPONENT

112721

This is a basic part; its only function is that of roof rear cross member as well as roof stiffener by means of a cemented connection.

If there are other issues regarding access to mating faces, the various replacement options are described in the basic instructions for structural bodywork repair (see **MR 400, 40A, General Information**).

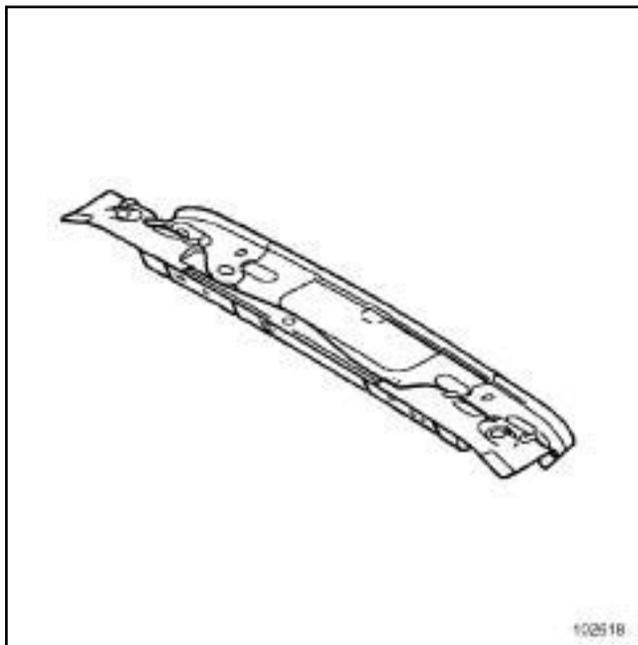
TOP OF BODY

Roof rear cross member: Description

45A

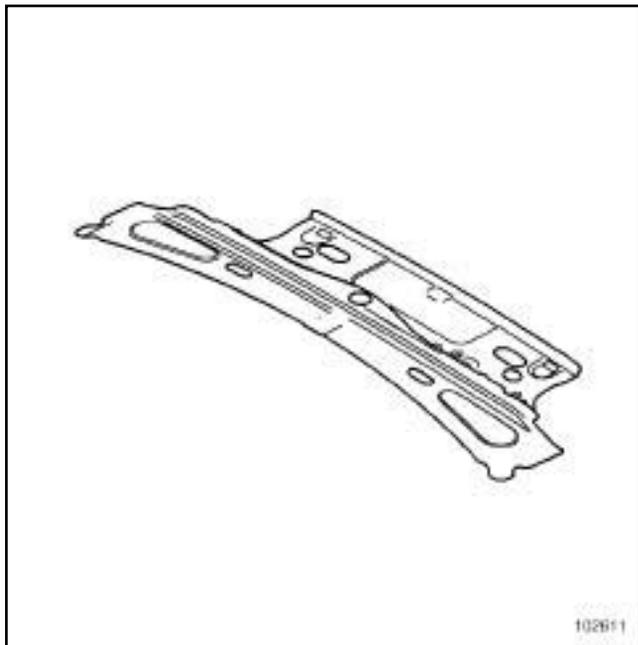
B84 or C84

Standard roof version



102618

Sunroof version

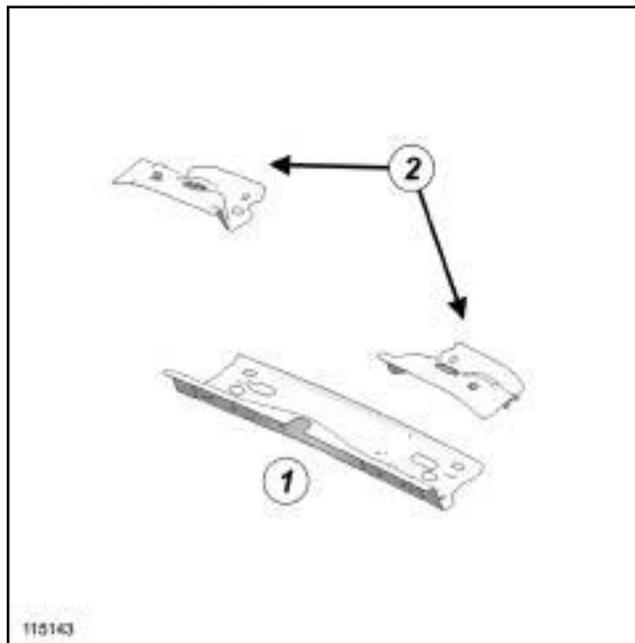


102611

There is only one way of replacing this part:
- complete replacement.

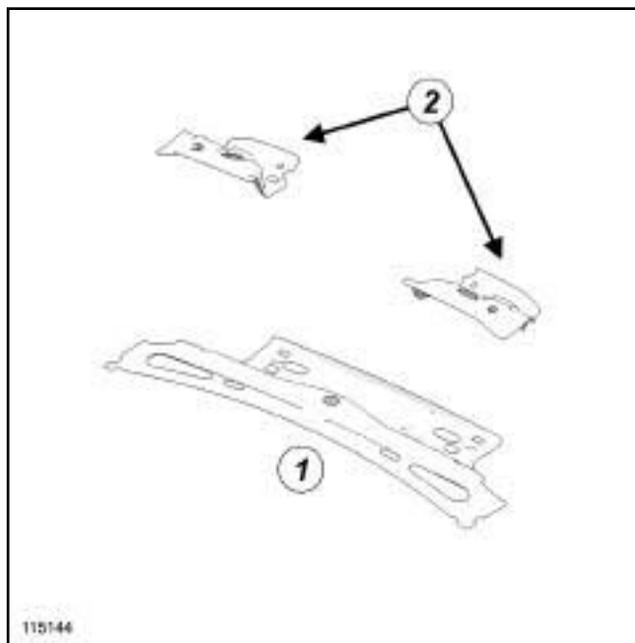
I - COMPOSITION OF THE SPARE PART

Standard roof version



115143

Sunroof version



115144

TOP OF BODY

Roof rear cross member: Description

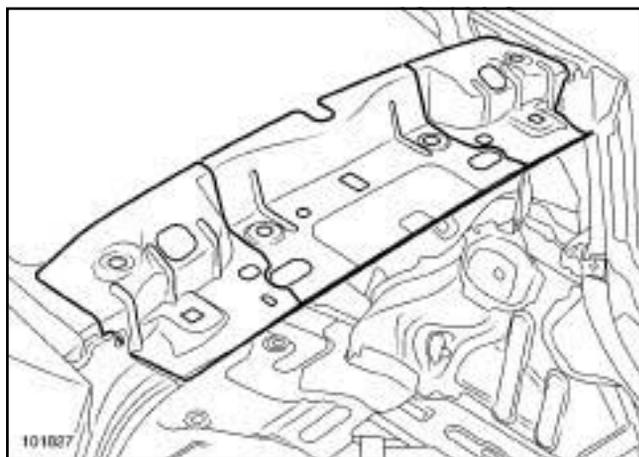
45A

B84 or C84

Mark	Description	Type	Thickness (mm)
(1)	Roof rear cross member	-	0.7
(2)	Rear cross member side lining	HLE	0.9

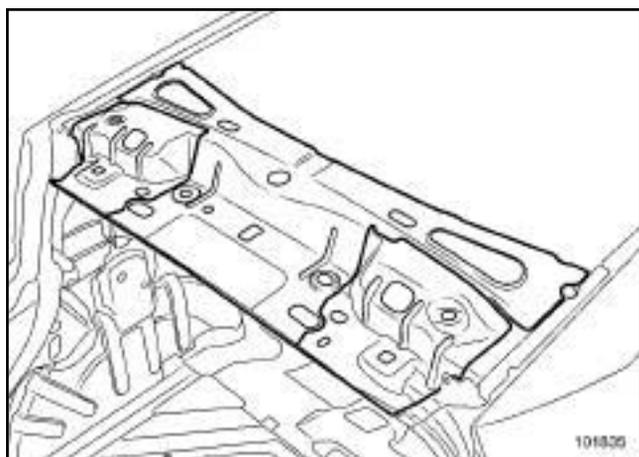
II - PART FITTED

Standard roof version



101827

Sunroof version



101835

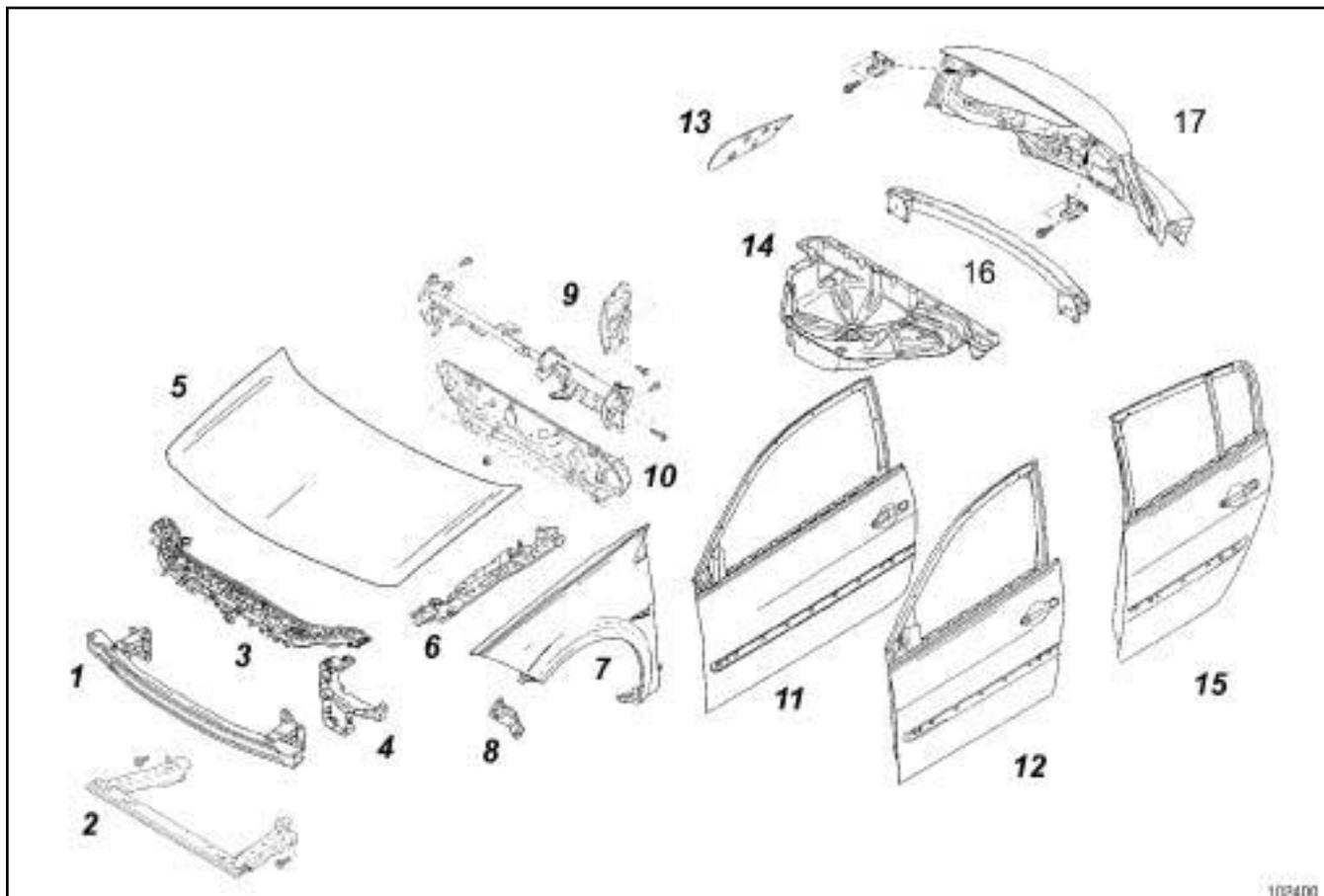
Note:

There is no specific procedure for replacing this part; all connections can be made as they originally were.

Vehicle removable section structure: Description

B84 or C84

STRUCTURE WHICH CAN BE DISMANTLED



102400

102400

Mark	Description	Classification	Type
(1)	Frontal impact cross member	(see 41A, Front lower structure, Front impact cross member: Removal - Refitting, page 41A-8)	Aluminium
(2)	Radiator mounting cross member	(see 41A, Front lower structure, Radiator support cross member: Removal - Refitting, page 41A-13)	
(3)	Front end panel centre section	(see 42A, Upper front structure, Front: Removal - Refitting, page 42A-23)	Steel/SMC
(4)	Front end panel side section	(see 42A, Upper front structure, Front: Removal - Refitting, page 42A-23)	SMC
(5)	Bonnet	(see 48A, Non-side opening elements, Bonnet: Removal - Refitting, page 48A-5)	Aluminium

SIDE OPENING ELEMENTS

47A

Vehicle removable section structure: Description

B84 or C84

Mark	Description	Classification	Type
(6)	Front wing upper mounting support	(see 42A, Upper front structure, Front wing upper mounting support: Removal - Refitting, page 42A-20)	
(7)	Front wing	(see 42A, Upper front structure, Front wing: Removal - Refitting, page 42A-11)	Noryl
(8)	Front wing lower mounting support	(see 42A, Upper front structure, Front wing lower mounting support: Removal - Refitting, page 42A-18)	
(9)	Dashboard cross member	(see 42A, Upper front structure, Dashboard cross member: Removal - Refitting, page 42A-42)	
(10)	Bulkhead plate	(see 42A, Upper front structure, Bulkhead panel: Removal - Refitting, page 42A-54)	Aluminium
(11)	Front side door, 3-door version	(see 47A, Side opening elements, Front side door: Removal - Refitting, page 47A-5)	
(12)	Front side door, 5-door version	(see 47A, Side opening elements, Front side door: Removal - Refitting, page 47A-5)	
(13)	Fuel filler flap cover	(see 47A, Side opening elements, Fuel filler flap cover: Removal - Refitting, page 47A-27)	Noryl
(14)	Rear section of rear floor	(see Rear floor rear section: Description)	
(15)	Rear side door	(see 47A, Side opening elements, Rear side door: Removal - Refitting, page 47A-18)	
(16)	Rear impact lower cross member	(see 41D, Rear lower structure, Rear impact lower cross member: Removal - Refitting, page 41D-33)	Polypropylene
(17)	Tailgate	(see 48A, Non-side opening elements, Tailgate: Removal - Refitting, page 48A-11)	

SIDE OPENING ELEMENTS

Front side door: General description

47A

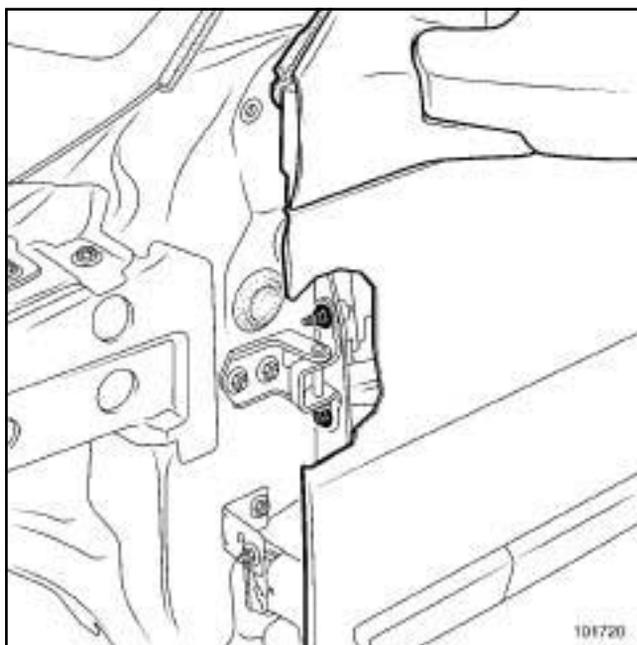
B84 or C84

WARNING

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

I - COMPONENT DESIGN



101720

This part has the following specifications:

- "bolted and bolted" hinges mounted vertically on the A-pillar and the door box section,
- a door check rod integrated in the lower hinge.

II - REMOVAL - REFITTING

If the front door hinge mountings are the "bolted and bolted" type it is possible to remove the front side door, depending on the operations to be performed:

- either by unscrewing the mountings on the component in the event of replacement of the front side door,
- or with the hinges by removing the mountings on the A-pillar in the event of replacement of the body.

Note:

If the component is to be removed and not replaced, mark the position of the mountings before unscrewing them to avoid having making adjustments when refitting the component.

III - ADJUSTMENT

Note:

The front side door is the component positioned after the rear side door, in the order of assembly of removable components in the factory.

For it to be completely adjusted, position all the other components correctly.

There are four main areas where adjustments can be made:

- adjustment of the front area,
- adjustment of the rear area,
- adjustment of the upper area,
- adjustment of the lower area.

Always begin the adjustments on the hinge side with the lock striker plate loose and the stops in place.

1 - Adjustment of the front area:

Adjust the shut lines and alignment with the front wing using the front door hinge mountings.

2 - Adjustment of the rear area

Adjust the shut lines and alignment with the rear door and the closure firmness using the striker plate mountings.

IMPORTANT

In this case, compromise between the closure firmness and the rear shut lines of the front door by giving priority to closing in such a way that the door presses sufficiently onto the seal to avoid floating of the rear of the door.

3 - Adjustment of the upper area

Adjust the shut lines and alignment with the roof and A-pillar using the front side door hinge mountings.

SIDE OPENING ELEMENTS

Front side door: General description

47A

B84 or C84

4 - Adjustment of the lower area

Adjust the shut lines and alignment with the sill panel using the front side door hinge mountings.

B84 or C84

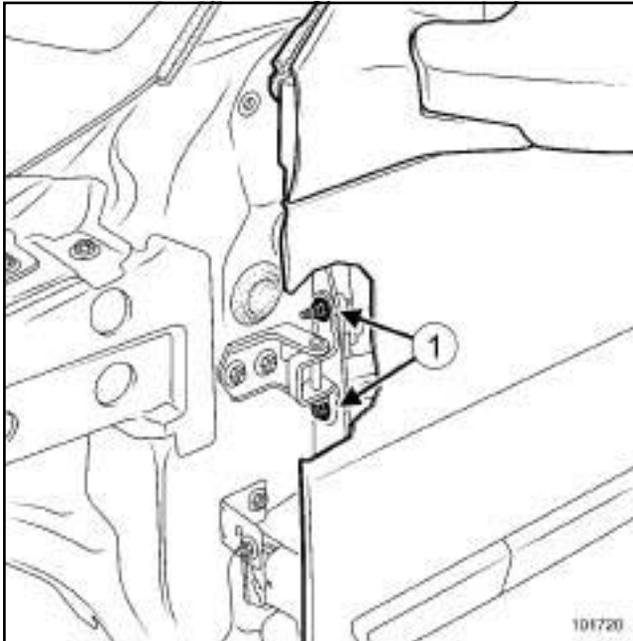
Tightening torques 	
door mounting bolts	21 Nm
door hinge mounting bolts	27 Nm
door retention device	0.8 Nm
door retention device mounting bolts	2.1 Nm

I - REMOVAL WITHOUT THE HINGES

1 - REMOVAL PREPARATION OPERATION

- Disconnect the door wiring harness supply connector.

2 - OPERATION FOR REMOVAL OF PART CONCERNED



101720

- Remove:
 - the four mounting bolts (1) from the door,
 - the door.

II - REFITTING WITHOUT THE HINGES

1 - REFITTING OPERATION FOR PART CONCERNED

- Refit:
 - the door,
 - the door's four mounting bolts (1).
- Adjust the door clearances and shut lines.
- Tighten to torque the **door mounting bolts (21 Nm)**.

2 - FINAL OPERATION

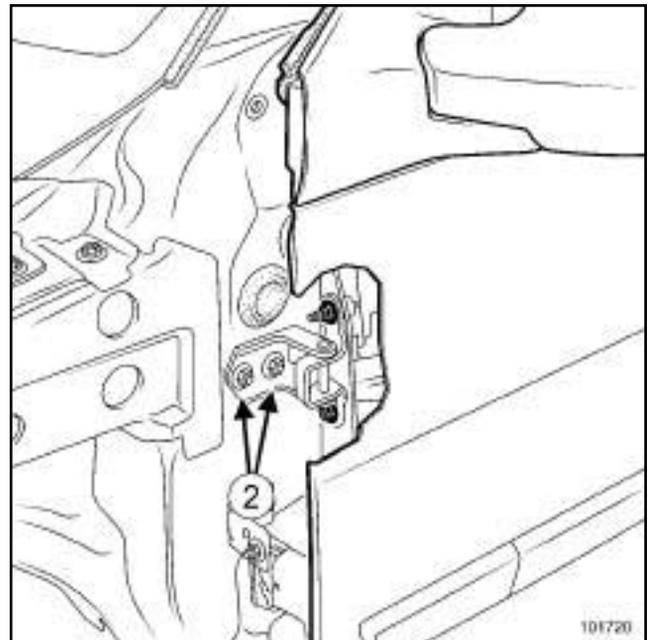
- Connect the door wiring harness supply connector.

III - REMOVAL WITH HINGES

1 - REMOVAL PREPARATION OPERATION

- Remove the front wing.
- Disconnect the door wiring harness supply connector.

2 - OPERATION FOR REMOVAL OF PART CONCERNED



101720

- Remove:
 - the door hinge mounting bolts (2),
 - the door.

B84 or C84

IV - REFITTING WITH HINGES

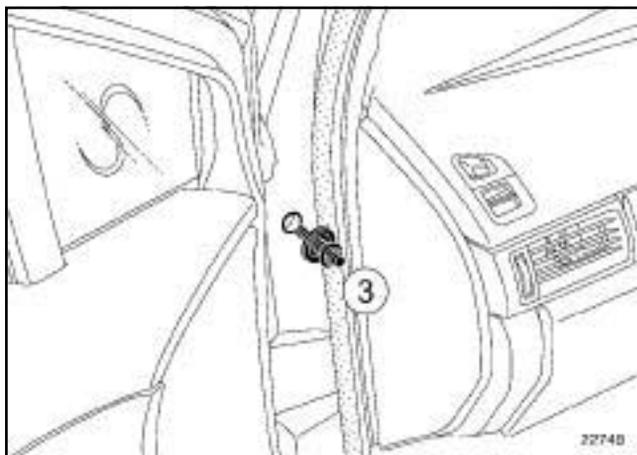
1 - REFITTING OPERATION FOR PART CONCERNED

- Refit:
 - the door,
 - the door hinge mounting bolts (2).
- Adjust the door clearances and shut lines.
- Tighten to torque the **door hinge mounting bolts (27 Nm)**.

2 - FINAL OPERATION

- Connect the door's wiring harness supply connector.
- Refit the front wing.

V - PASSIVE SAFETY

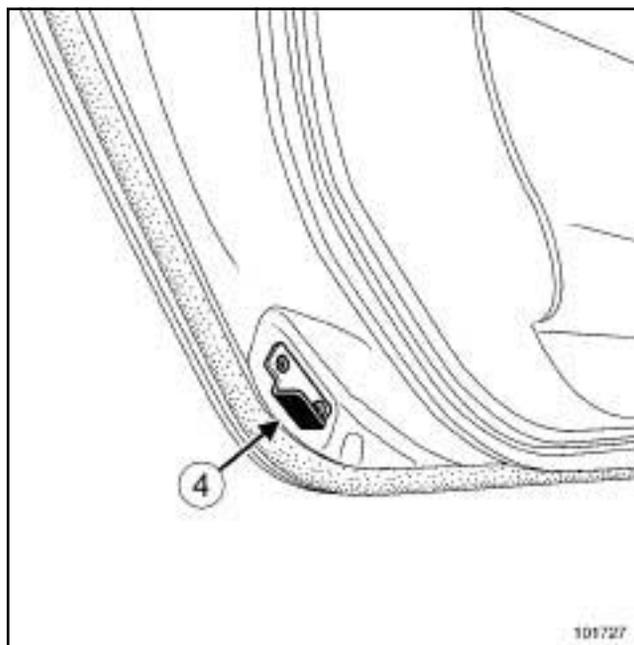


22749

- At the end of the operation, check the presence and condition of the door retention device (3).
- Tighten to torque the **door retention device (0.8 Nm)**.

Note:

The function of this part is essential in the event of a frontal impact. The door retention device keeps the door in its longitudinal plane, thereby absorbing impact energy efficiently.



101727

101727

- On 3-door models, check the presence and condition of the additional door retention device (4) located on the lower section.

Tighten to torque the **door retention device mounting bolts (2.1 Nm)**.

SIDE OPENING ELEMENTS

Front side door: Adjustment

47A

B84 or C84

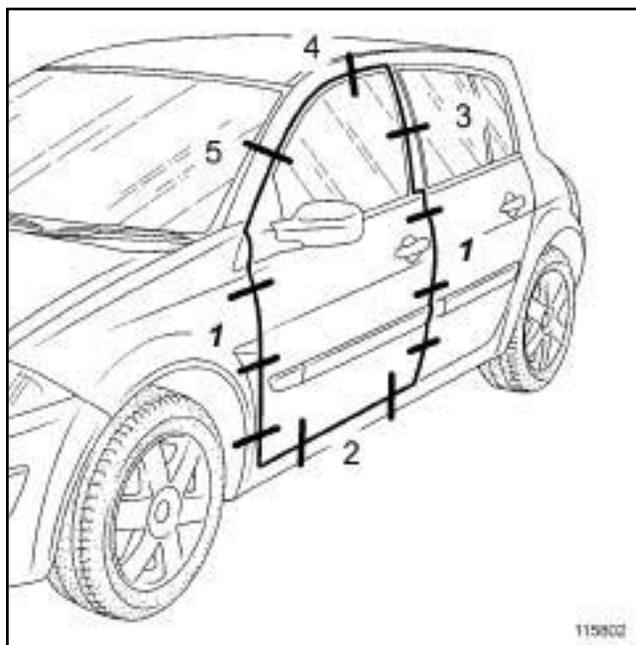
Tightening torques 	
hinge mounting bolts	27 Nm
door box section mounting bolts	21 Nm
striker plate bolts	21 Nm

ADJUSTMENT VALUES

- ❑ For information on the front side door adjustment values, (see **Vehicle shut lines: Adjustment value**).

ADJUSTMENT

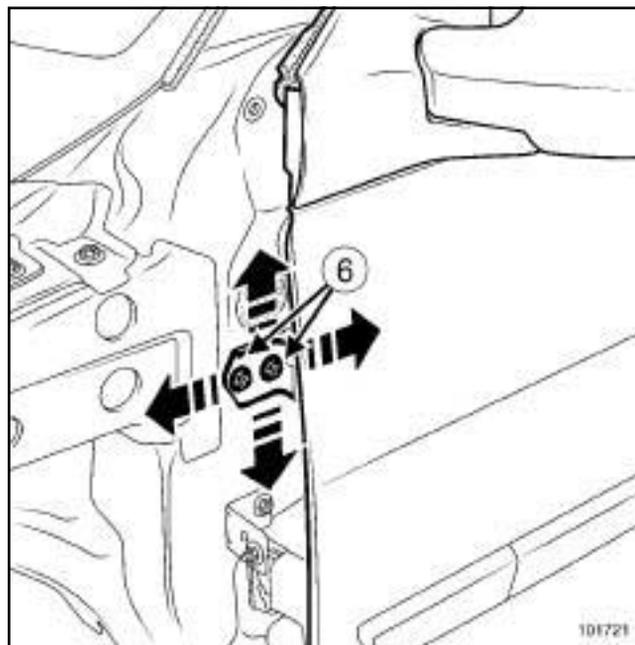
- ❑ There are two options for adjusting the door:
 - by means of the mountings on the door box section (opening clearance adjustment),
 - by means of the mountings on the A-pillar (shut line adjustment):
- ❑ The front wing needs to be removed for this operation.



115802

- ❑ Observe the adjustment sequence.

I - REAR DOOR SHUT LINE ADJUSTMENT



101721

101721

- ❑ Undo the hinge mounting bolts (6) .
- ❑ Adjust the shut lines with the rear door.
- ❑ Tighten to torque the **hinge mounting bolts (27 Nm)** .

SIDE OPENING ELEMENTS

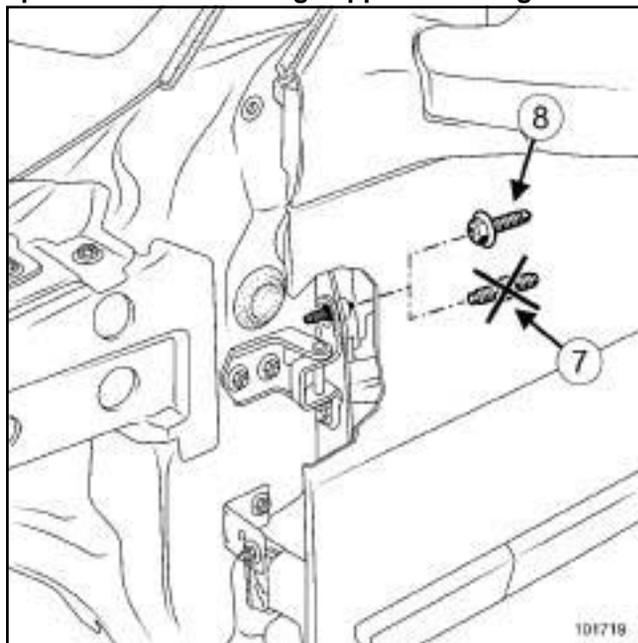
Front side door: Adjustment

47A

B84 or C84

II - ADJUSTMENT OF FLUSH FITTING WITH THE FRONT WING AND THE REAR DOOR

Special note on the hinge upper mounting

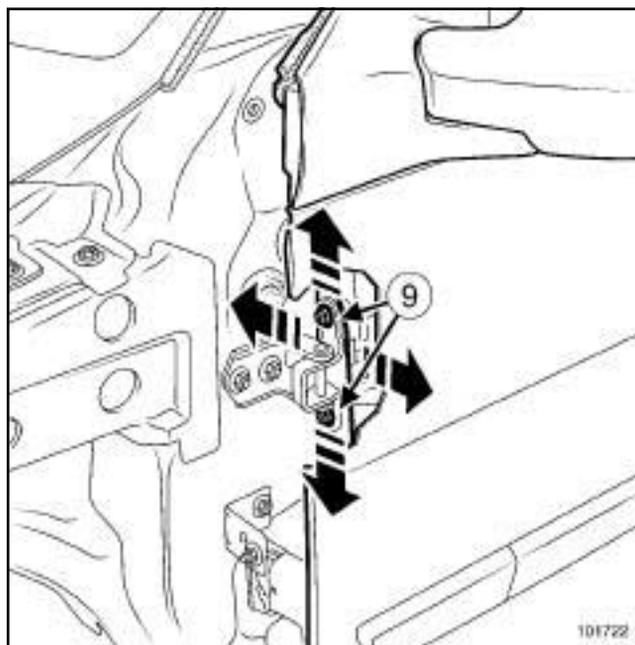


- Replace the original indexing studs (7) with bolts (8) , available from the **Parts Department** , to enable flush fitting adjustment.

Note:

To increase the adjustment available, enlarge the upper holes on the original hinges.

After-Sales hinges are supplied with square slots.

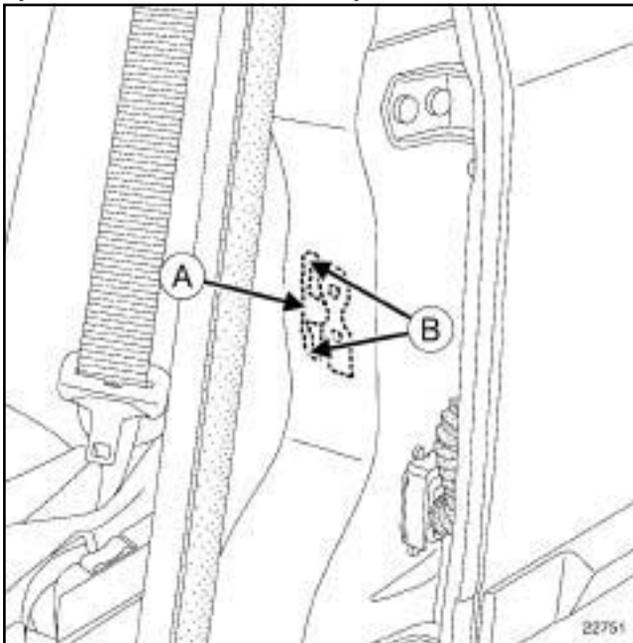


101722

- Undo the door box section mounting bolts (9) .
- Adjust the flush fitting with the front wing.
- Tighten to torque the **door box section mounting bolts (21 Nm)** .

B84 or C84

Special notes on the striker plate

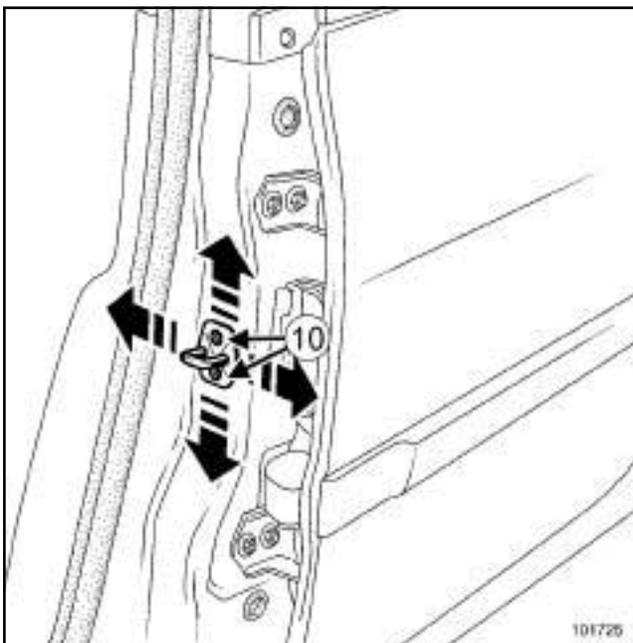


22751

- ❑ The striker plate is spot-welded at (A) on the reinforcement inside the B-pillar.

To carry out adjustments, bend the fusible sections (B) of the plate.

This operation can only be performed by exerting a relatively strong force on the striker (e.g. by using a hammer).



101725

- ❑ Undo the striker plate bolts (10) .
- ❑ Adjust the flush fitting with the rear door, the contact and the closure firmness.
- ❑ Tighten to torque the **striker plate bolts (21 Nm)** .

SIDE OPENING ELEMENTS

Front side door: Stripping - Restoring

47A

B84 or C84

The order of the operations described applies specifically to replacing the door.

Note:

It is possible to carry out the stripping operations on the vehicle before removing the door.

STRIPPING

□ Remove:

- the door mirror((see **Door mirror: Removal - Refitting**) ,
- the sliding window((see **Sliding window in front side door: Removal - Refitting**) ,
- the interior trim((see **Front side door trim: Removal - Refitting**) ,
- the exterior handle((see **Door exterior handle: Removal - Refitting**) ,
- the door lock((see **Front side door lock: Removal - Refitting**) .

WARNING

For vehicles equipped with the hands-free function, remove the exterior handle and the door lock when the door interior trim is removed and leave the lock assembly in the interior trim during removal.

□ Remove:

- the door lower interior weatherstrip((see **Front side door interior weatherstrip: Removal - Refitting**) ,
- the door lower exterior weatherstrip((see **Front door side exterior weather strip: Removal - Refitting**) ,
- the exterior door frame seal((see **Front side door frame seal: Removal - Refitting**) ,
- the exterior strip((see **Front door protective strip: Removal - Refitting**) .

REASSEMBLING

□ Refit:

- the exterior strip((see **Front door protective strip: Removal - Refitting**) .
- the exterior door frame seal((see **Front side door frame seal: Removal - Refitting**) ,

- the door lower exterior weatherstrip((see **Front door side exterior weather strip: Removal - Refitting**) ,
- the door lower interior weatherstrip((see **Front side door interior weatherstrip: Removal - Refitting**) ,
- the door lock((see **Front side door lock: Removal - Refitting**) ,
- the exterior handle((see **Door exterior handle: Removal - Refitting**) ,
- the interior trim((see **Front side door trim: Removal - Refitting**) ,
- the sliding window((see **Sliding window in front side door: Removal - Refitting**) ,
- the door mirror((see **Door mirror: Removal - Refitting**) .

SIDE OPENING ELEMENTS

Front side door panel: Description

47A

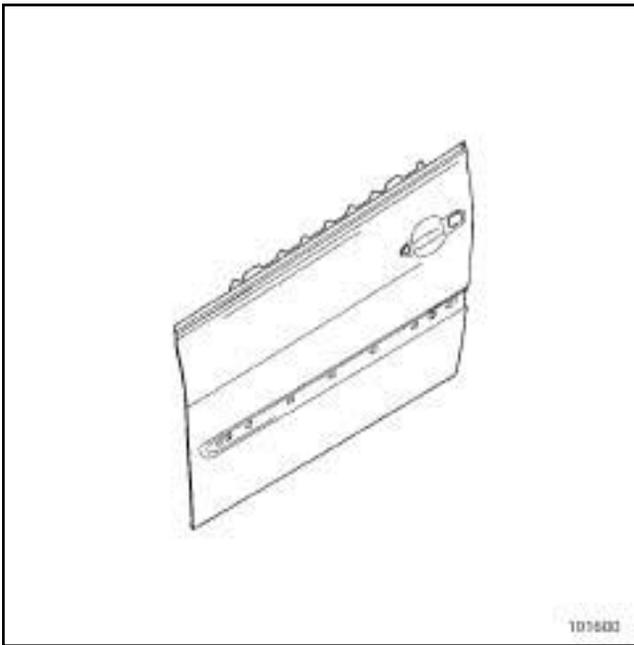
B84 or C84

Special tooling required

Car. 1657

Door panel uncrimping
pliers.

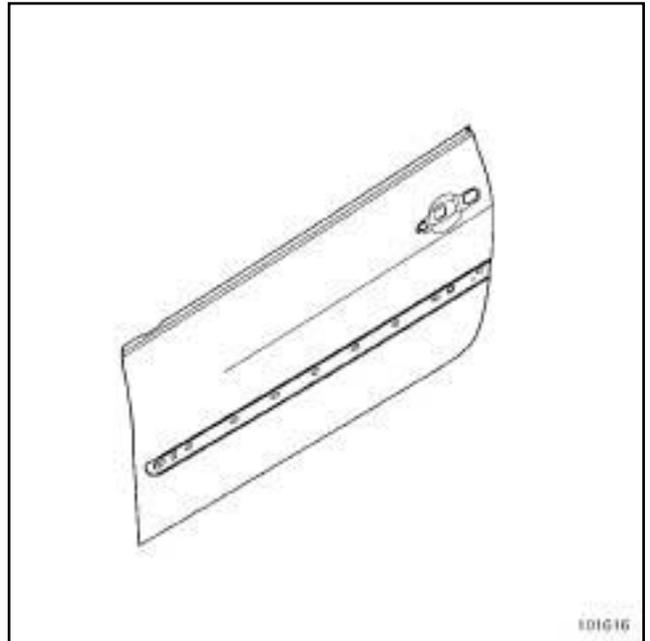
B84



101600

101600

C84



101616

101616

There is only one way of replacing this part:
- complete replacement.

SIDE OPENING ELEMENTS

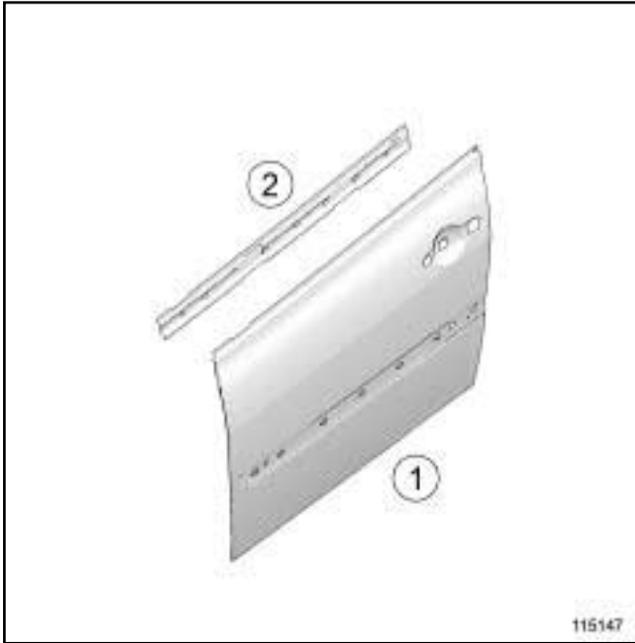
Front side door panel: Description

47A

B84 or C84

I - COMPOSITION OF THE SPARE PART

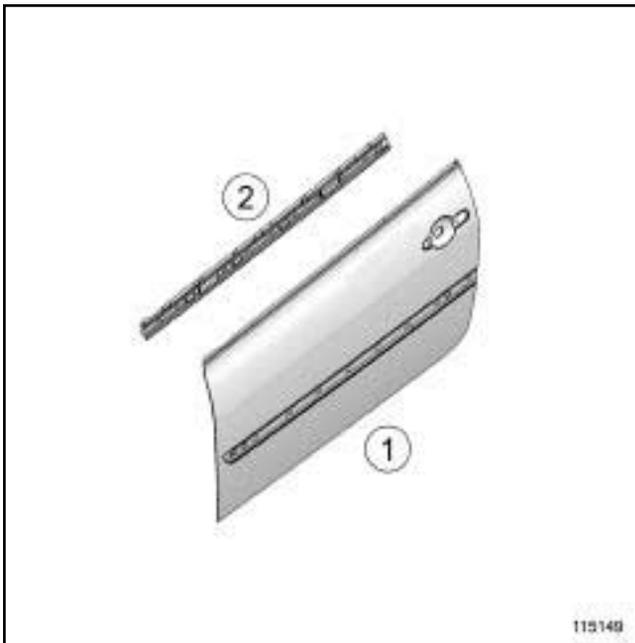
B84



115147

115147

C84



115148

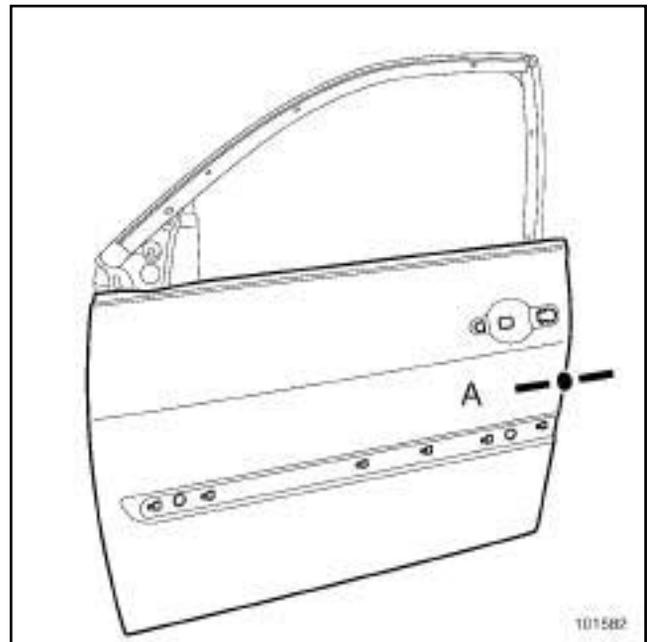
115149

Mark	Description	Type	Thickness (mm)
(1)	Front side door panel	HLE	0.7
(2)	Door panel reinforcement	HLE	1.5

II - PART FITTED

1 - Complete replacement

B84



101582

101582

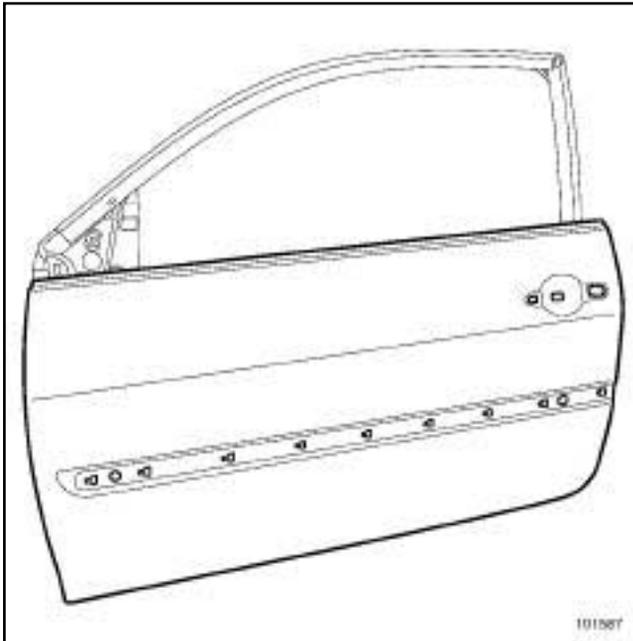
SIDE OPENING ELEMENTS

Front side door panel: Description

47A

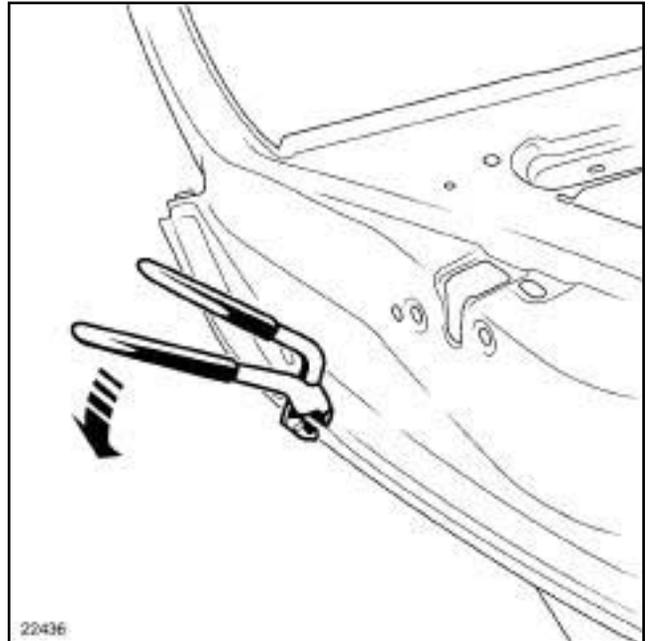
B84 or C84

C84



101587

Special note for removal of the door panel

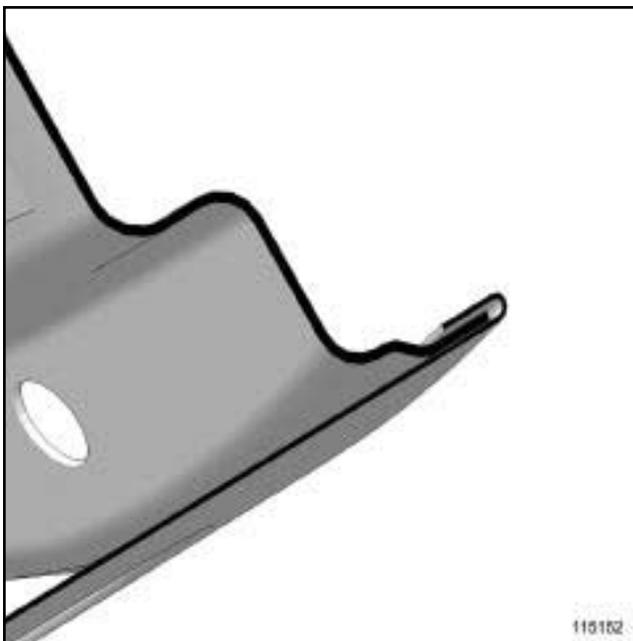


22436

The door panel can be removed using the (Car. 1657) .

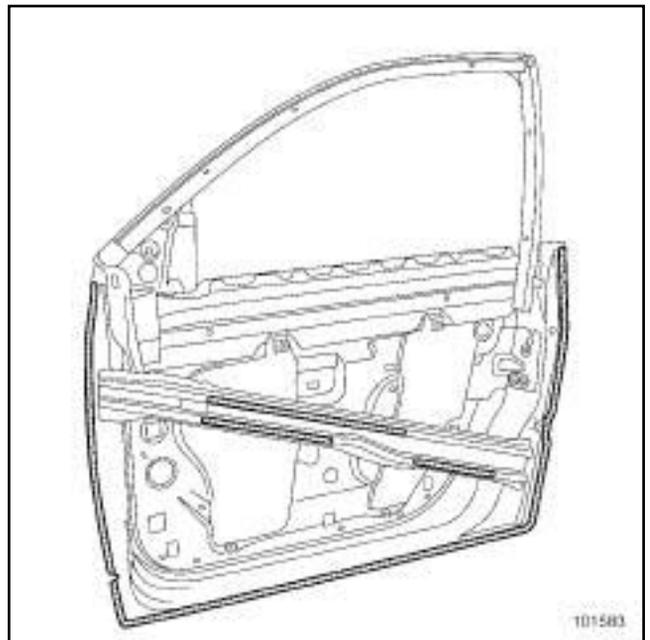
2 - Applying the structural adhesive

Cut A



115152

B84



101583

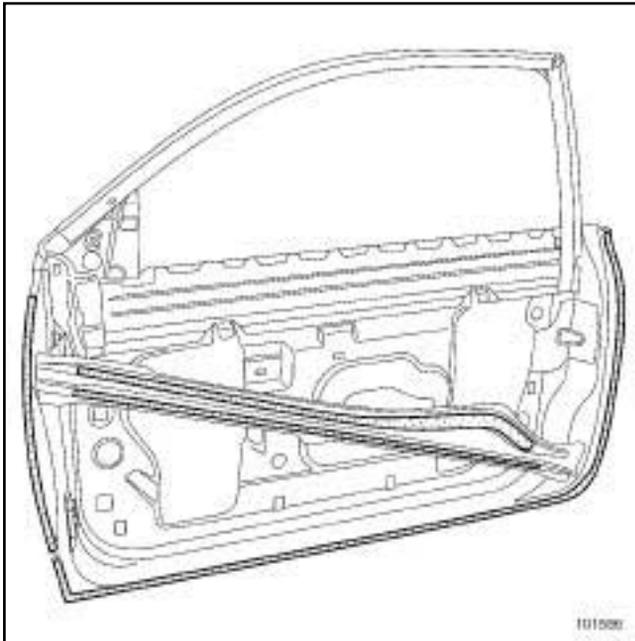
SIDE OPENING ELEMENTS

Front side door panel: Description

47A

B84 or C84

C84

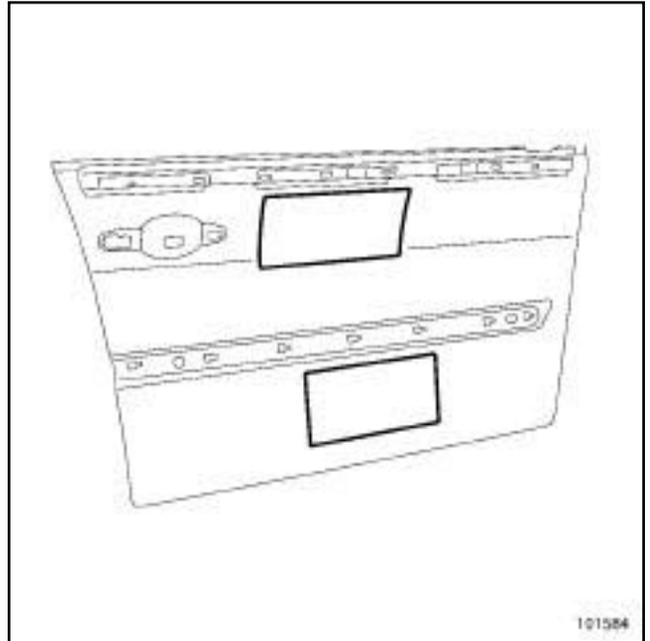


101586

Use an **M. J. Pro** type setting adhesive.

3 - Positioning the panel soundproofing

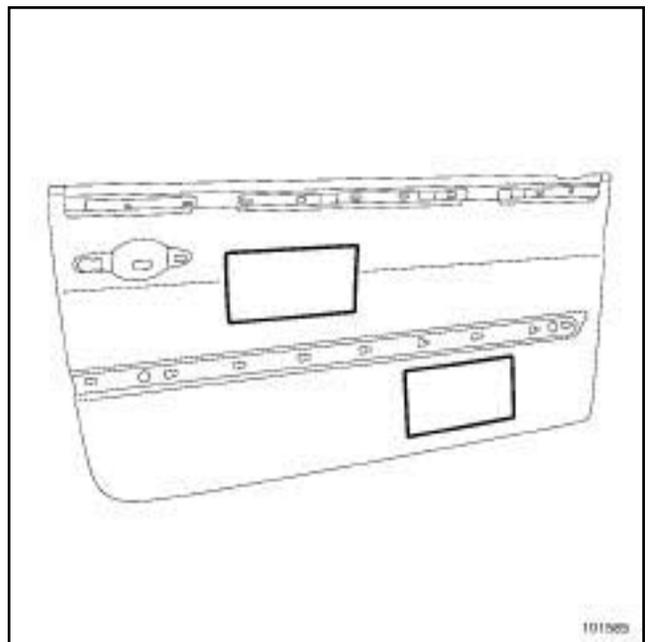
B84



101584

101584

C84



101585

101585

SIDE OPENING ELEMENTS

Front side door panel: Description

47A

B84 or C84

Note:

If a panel straightening operation requiring even partial removal of soundproofing is necessary, the soundproofing must be replaced.

Rear side door: General description

B84

WARNING

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

I - COMPONENT DESIGN



101730

This part has the following specifications:

- "bolted and bolted" hinges mounted vertically on the B-pillar and the door box section,
- a door check rod integrated in the lower hinge.

II - REMOVAL - REFITTING

If the front side door hinge mountings are the "bolted and bolted" type it is possible to remove the rear side door, depending on the operations to be performed:

- either by unscrewing the mountings on the component in the event of replacement of the rear side door,
- or with the hinges by removing the mountings on the A-pillar in the event of replacement of the body.

Note:

If the component is to be removed and not replaced, mark the position of the mountings before unscrewing them to avoid having making adjustments when refitting the component.

III - ADJUSTMENT

Note:

The rear side door is the component positioned first in the order of assembly of removable components in the factory.

For it to be completely adjusted, correctly position all the other components.

There are four main areas where adjustments can be made:

- adjustment of the front area,
- adjustment of the rear area,
- adjustment of the upper area,
- adjustment of the lower area.

Always begin the adjustments on the hinge side with the lock striker plate loose and the stops in place.

1 - Adjustment of the front area:

Adjust the shut lines and alignment with the front side door using the rear side door hinge mountings.

2 - Adjustment of the rear area:

Adjust the shut lines and alignment with the rear wing and the closure firmness using the striker plate mountings.

IMPORTANT

In this case, compromise between the closure firmness and the rear shut lines of the rear side door by giving priority to closing in such a way that the door presses sufficiently onto the seal to avoid floating of the rear of the door.

3 - Adjustment of the upper area:

Adjust the shut lines and alignment with the roof and the quarter panel using the rear side door hinge mountings.

SIDE OPENING ELEMENTS

47A

Rear side door: General description

B84

4 - Adjustment of the lower area:

Adjust the shut lines and alignment with the sill panel using the rear side door hinge mountings.

SIDE OPENING ELEMENTS

Rear side door: Removal - Refitting

47A

B84

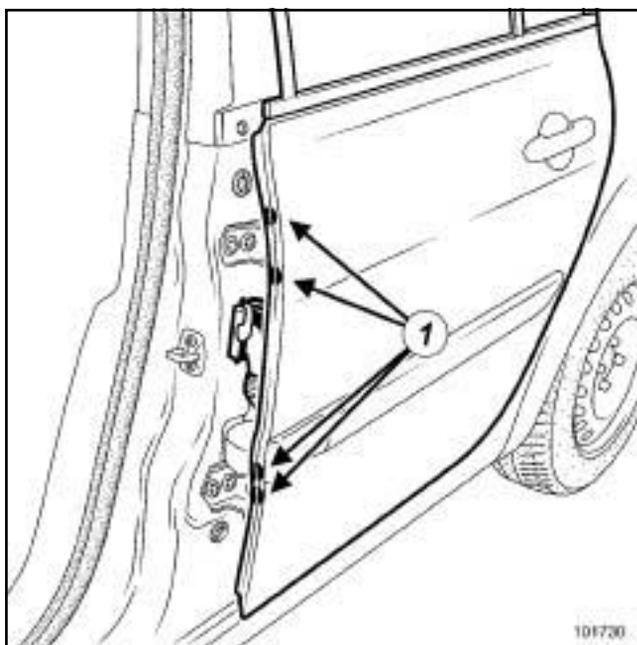
Tightening torques	
door mounting bolts	21 Nm
hinge mounting bolts	27 Nm
door retention device mounting bolts	21 Nm

I - REMOVAL WITHOUT THE HINGES

1 - REMOVAL PREPARATION OPERATION

- Disconnect the door wiring harness supply connector.

2 - OPERATION FOR REMOVAL OF PART CONCERNED



- Remove:
 - the door mounting bolts (1) ,
 - the door.

II - REFITTING WITHOUT HINGES

1 - REFITTING OPERATION FOR PART CONCERNED

- Refit:
 - the door,
 - the door mounting bolts (1) .

- Adjust the door shut lines and flush fitting (see **Vehicle shut lines: Adjustment value**) .

- Tighten to torque the **door mounting bolts (21 Nm)** .

2 - FINAL OPERATION

- Connect the door wiring harness supply connector.

III - REMOVAL WITH HINGES

1 - REMOVAL PREPARATION OPERATION

- Disconnect the door wiring harness supply connector.

2 - OPERATION FOR REMOVAL OF PART CONCERNED



- Remove:
 - the hinge mounting bolts (2) ,
 - the door.

IV - REFITTING WITH HINGES

1 - REFITTING OPERATION FOR PART CONCERNED

- Refit:
 - the door,
 - the hinge mounting bolts (2) .

SIDE OPENING ELEMENTS

Rear side door: Removal - Refitting

47A

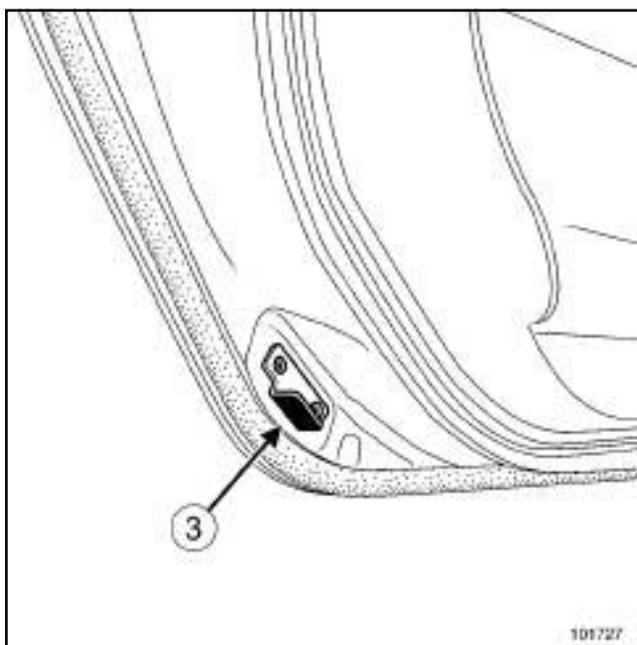
B84

- Adjust the door shut lines and flush fitting (see **Vehicle shut lines: Adjustment value**).
- Tighten to torque the **hinge mounting bolts (27 Nm)** .

2 - FINAL OPERATION

- Connect the door's wiring harness supply connector.

V - PASSIVE SAFETY



101727

- At the end of the operation, check the presence and condition of the door retention device (3) .
- Tighten to torque the **door retention device mounting bolts (21 Nm)** .

REMINDER:

This part's function is essential in the event of a rear collision. The door retention device keeps the door in its longitudinal plane, thereby absorbing impact energy efficiently.

B84

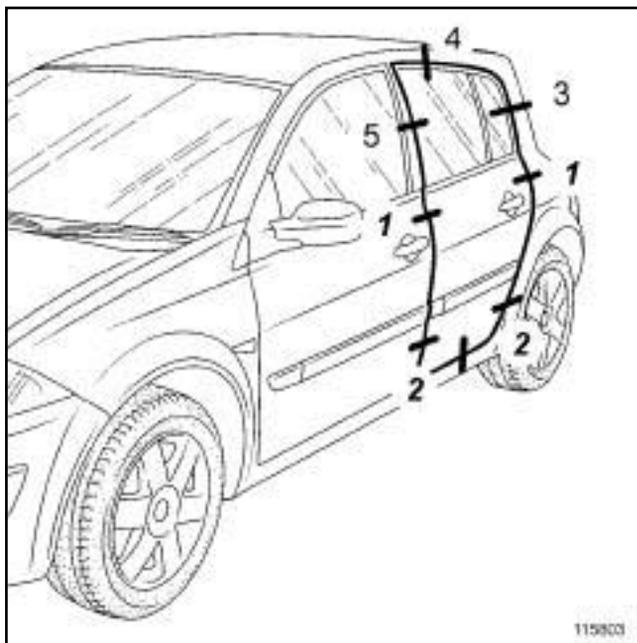
Tightening torques 	
hinge mounting bolts	27 Nm
door box section mounting bolts	21 Nm
striker plate bolts	21 Nm

ADJUSTMENT VALUES

- ❑ For information on the rear side door adjustment values, (see **Vehicle shut lines: adjustment value**).

ADJUSTMENT

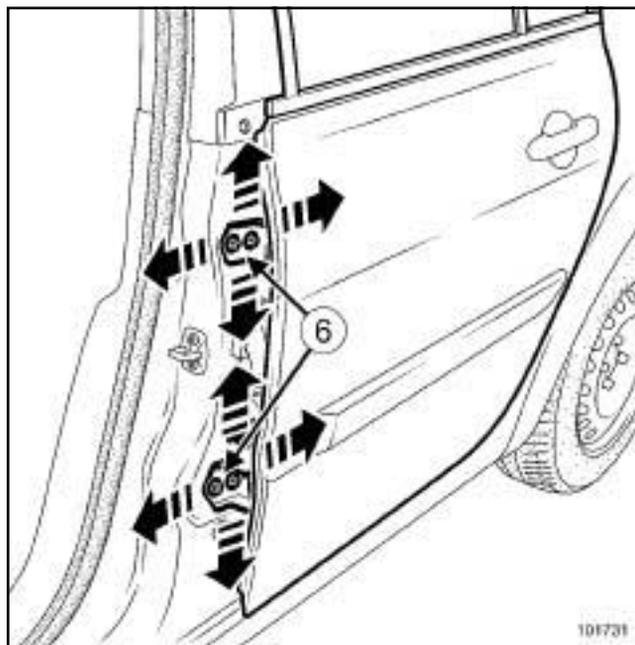
- ❑ There are two options for adjusting the door:
 - by means of the mountings on the door box section (opening clearance adjustment),
 - by means of the mountings on the A-pillar (shut line adjustment):



115803

- ❑ Observe the adjustment sequence.

I - ADJUSTMENT OF FLUSH FITTING WITH THE FRONT DOOR AND THE REAR WING



101731

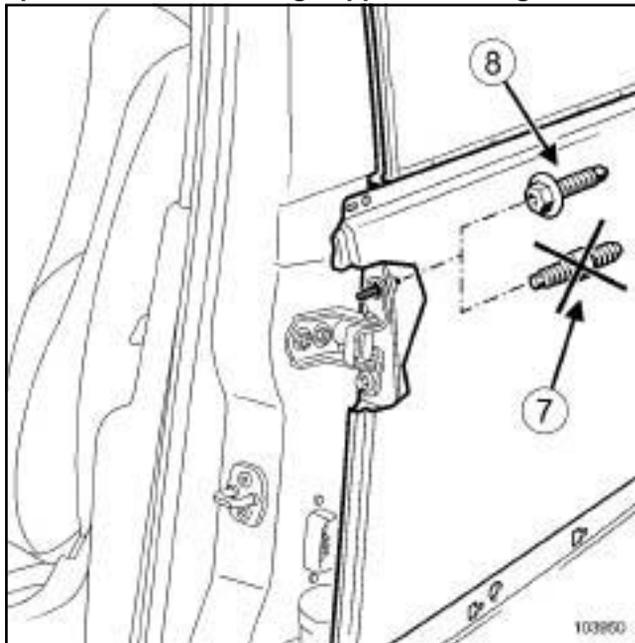
101731

- ❑ Undo the hinge mounting bolts (6) .
- ❑ Adjust the shut lines with the rear door.
- ❑ Tighten to torque the **hinge mounting bolts (27 Nm)** .

B84

II - ADJUSTMENT OF FLUSH FITTING WITH THE FRONT DOOR AND THE REAR WING

Special note on the hinge upper mounting

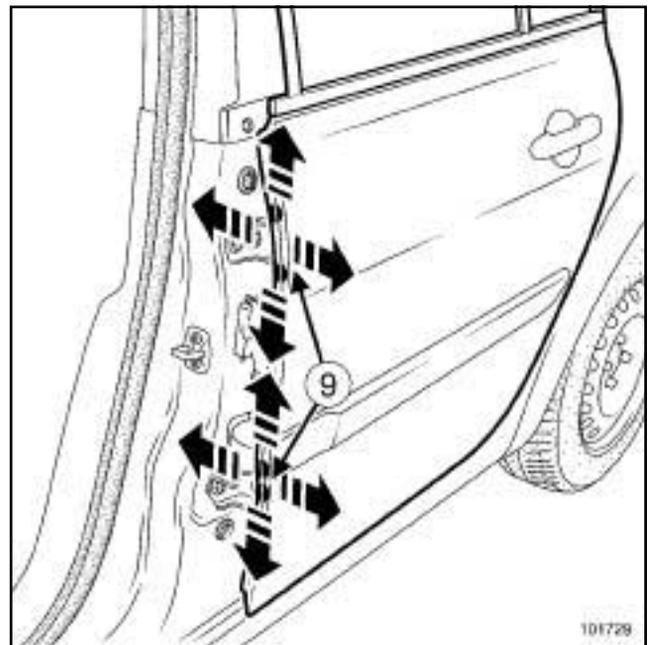


- Replace the original indexing studs (7) with bolts (8) available from the **Parts Department** , to enable flush fitting adjustment.

Note:

To increase the adjustment available, enlarge the upper holes on the original hinges.

After-Sales hinges are supplied with square slots.

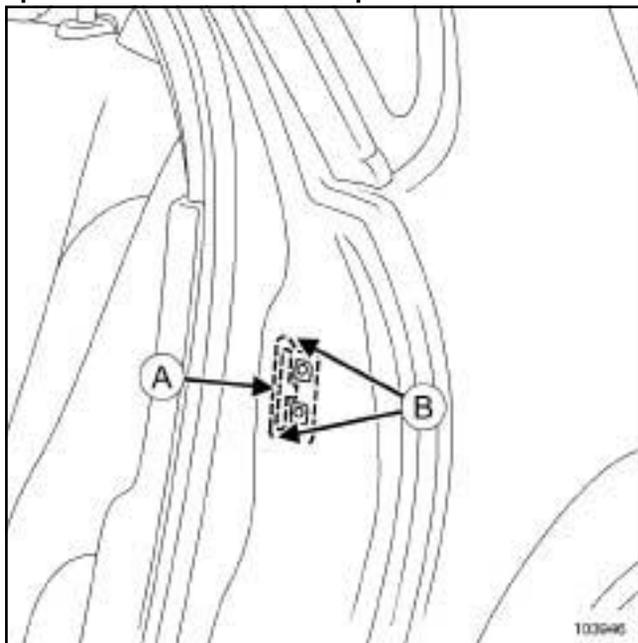


101729

- Undo the door box section mounting bolts (9) .
- Adjust the flush fitting with the front door and the rear wing.
- Tighten to torque the **door box section mounting bolts (21 Nm)** .

B84

Special notes on the striker plate

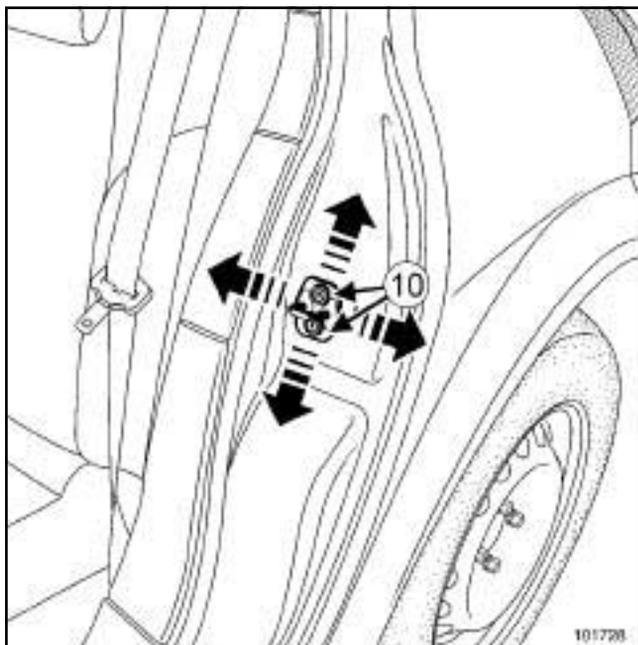


103946

- The striker plate is spot-welded to the rear wing reinforcement at (A) .

To carry out adjustments, bend the fusible sections (B) of the plate.

This operation can only be performed by exerting a relatively strong force on the striker (e.g. by using a hammer).



101728

- Undo the striker plate bolts (10) .
- Adjust the flush fitting with the rear wing, the contact and the closure firmness.
- Tighten to torque the **striker plate bolts (21 Nm)** .

Rear side door: Stripping - Restoring

B84

The order of the operations described applies specifically to replacing the door.

Note:

It is possible to carry out the stripping operations on the vehicle before removing the door.

STRIPPING

□ Remove:

- the sliding window((see **Sliding window in rear side door: Removal - Refitting**) ,
- the interior trim((see **Rear side door trim: Removal - Refitting**) ,
- the exterior handle((see **Interior door handle on rear side door**) ,
- the door lock((see **Rear side door lock: Removal - Refitting**) .

WARNING

For vehicles equipped with the hands-free function, remove the exterior handle and the door lock when the door interior trim is removed and leave the lock-exterior handle support assembly in the trim during removal.

□ Remove:

- the door lower weatherstrip((see **Rear side door interior weather strip: Removal - Refitting**) ,
- the fixed window and exterior door frame seal((see **Rear side door frame seal: Removal - Refitting**) ,
- the exterior door moulding((see **Rear door protective strip: Removal - Refitting**) .

REASSEMBLING

□ Refit:

- the exterior door moulding((see **Rear door protective strip: Removal - Refitting**) ,
- the fixed window and exterior door frame seal((see **Rear side door frame seal: Removal - Refitting**) ,
- the door lower weatherstrip((see **Rear side door interior weather strip: Removal - Refitting**) ,
- the door lock((see **Rear side door lock: Removal - Refitting**) ,
- the exterior handle((see **Interior door handle on rear side door**) ,

- the interior trim((see **Rear side door trim: Removal - Refitting**) ,
- the sliding window((see **Sliding window in rear side door: Removal - Refitting**) .

SIDE OPENING ELEMENTS

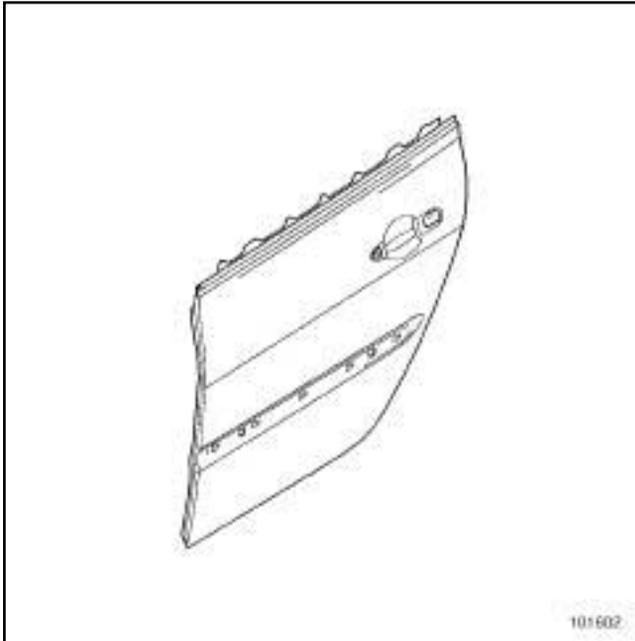
Rear side door panel: Description

47A

B84

Special tooling required

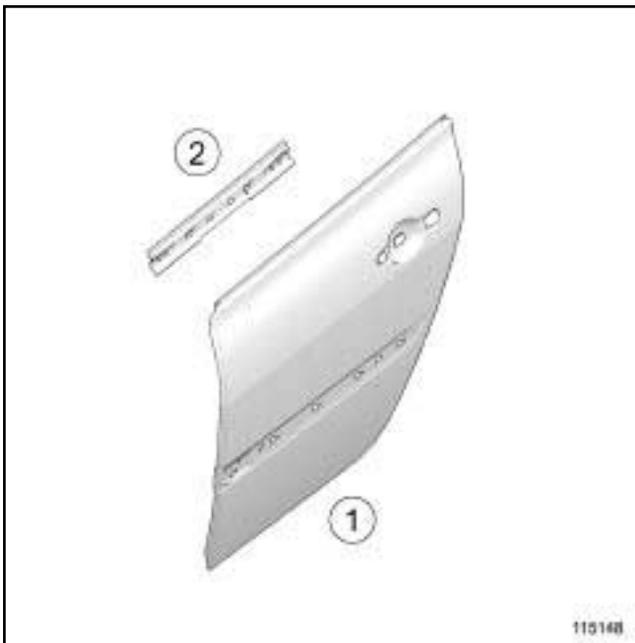
Car. 1657	Door panel uncrimping pliers.
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101602

There is only one way of replacing this part:
- complete replacement.

I - COMPOSITION OF THE SPARE PART

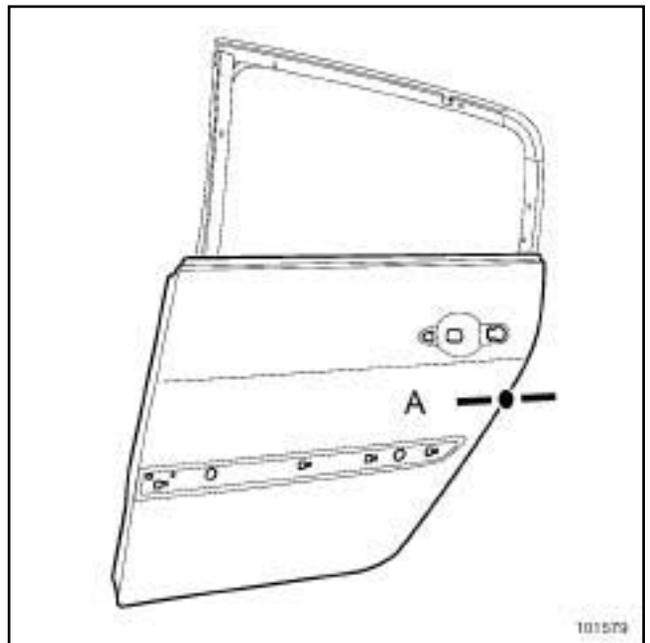


115148

Mark	Description	Type	Thickness (mm)
(1)	Rear side door panel	HLE	0.7
(2)	Door panel reinforcement	-	1

II - PART FITTED

1 - Complete replacement



101579

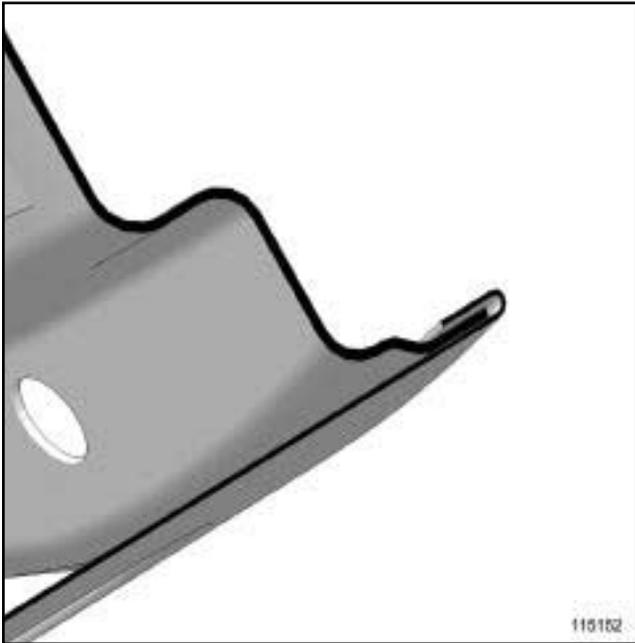
SIDE OPENING ELEMENTS

Rear side door panel: Description

47A

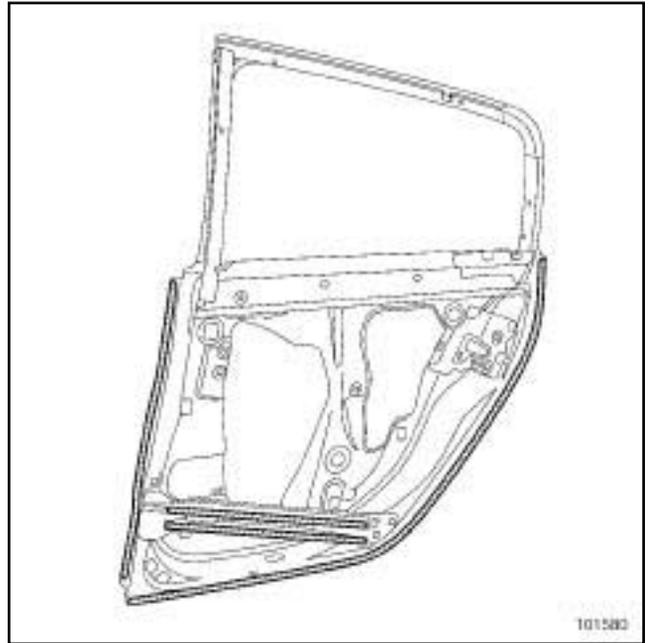
B84

Cut A



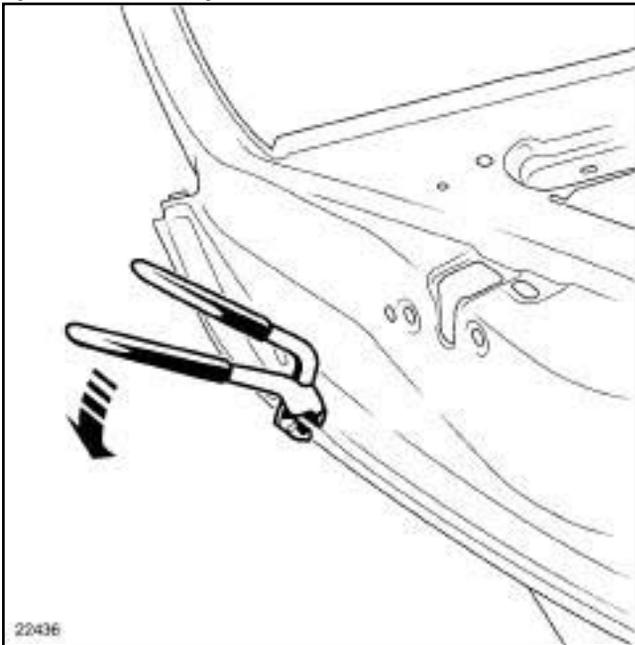
115152

2 - Applying the structural adhesive



101580

Special note for panel removal

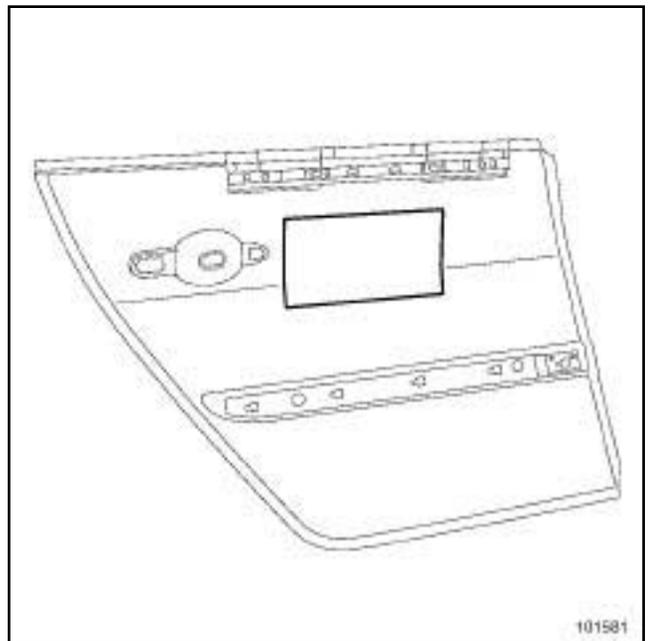


22436

The door panel can be removed using the **(Car. 1657)**.

Use an **M. J. Pro** type setting adhesive.

3 - Positioning the panel soundproofing



101581

Note:

If a panel straightening operation requiring even partial removal of soundproofing is necessary, the soundproofing must be replaced.

SIDE OPENING ELEMENTS

Fuel filler flap cover: General description

47A

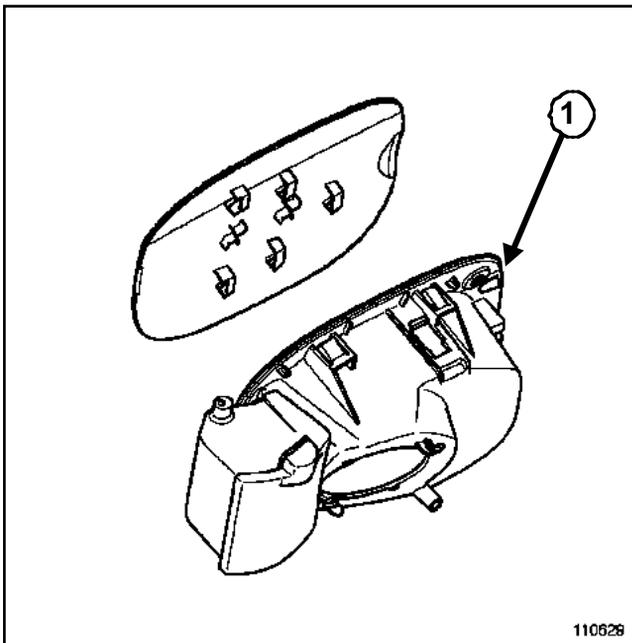
B84 or C84

WARNING

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

COMPONENT DESIGN



110629

The fuel filler flap has two special features:

- it is made of plastic (NORYL),
- it is slotted into its plastic mounting (1) .

SIDE OPENING ELEMENTS

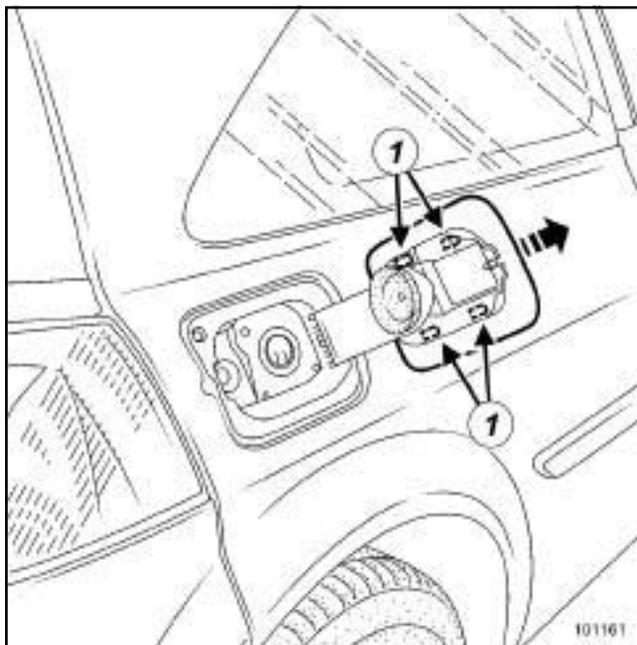
Fuel filler flap cover: Removal - Refitting

47A

B84 or C84

REMOVAL

OPERATION FOR REMOVAL OF PART CONCERNED

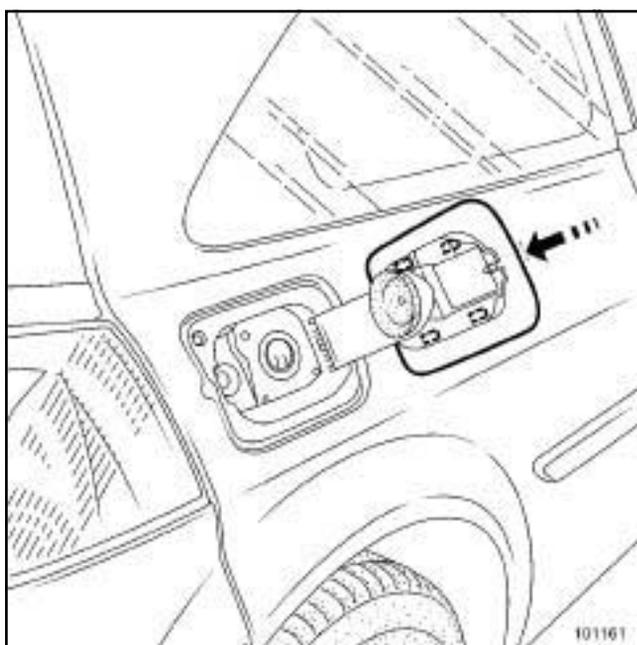


101161

- ❑ Press gently with your fingers to disengage the cover of the four clips (1) and pull the cover outwards.

REFITTING

REFITTING OPERATION FOR PART CONCERNED



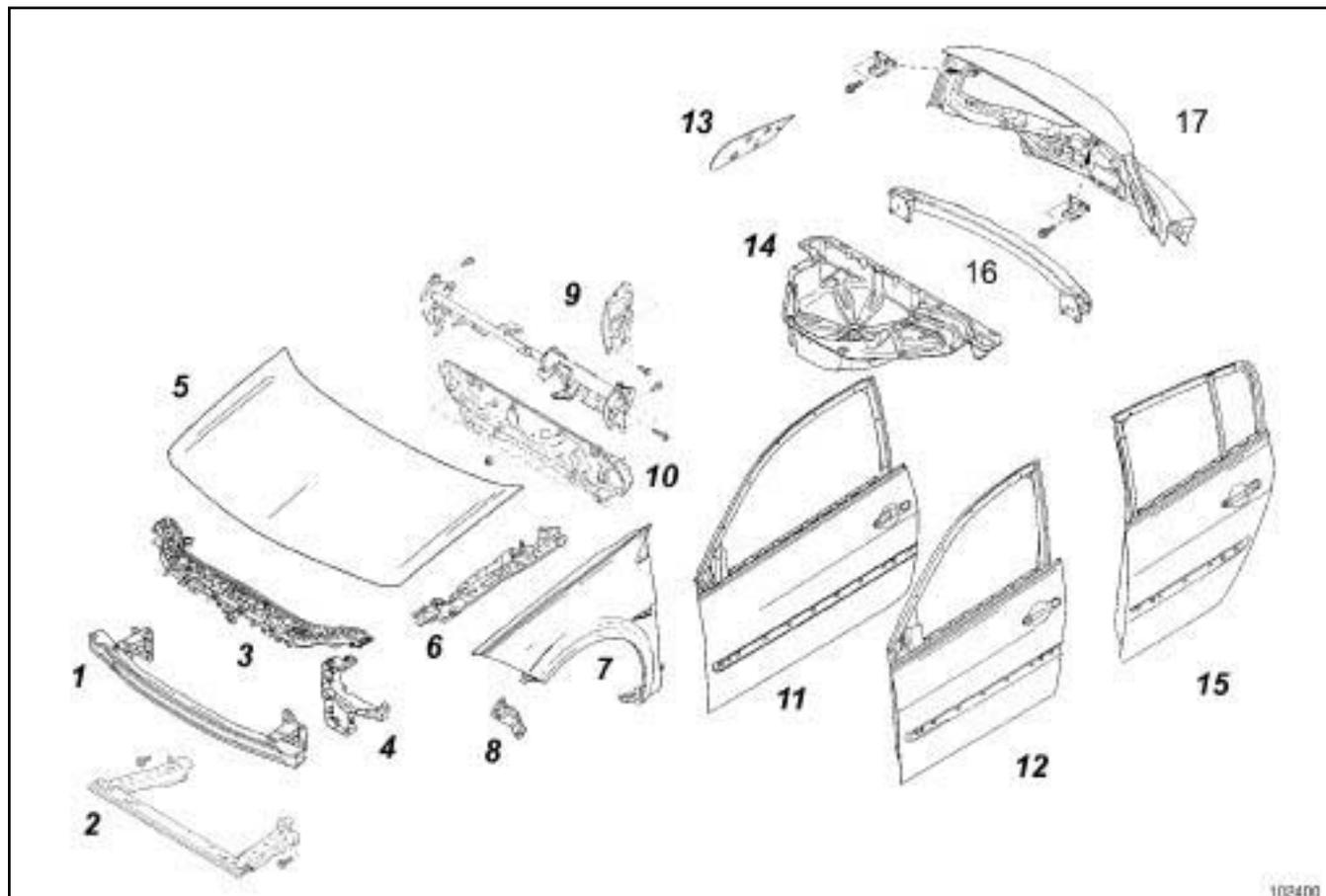
101161

- ❑ Clip the fuel filler flap cover onto its mounting.

Vehicle removable section structure: Description

B84 or C84

STRUCTURE WHICH CAN BE DISMANTLED



102400

102400

Mark	Description	Classification	Type
(1)	Frontal impact cross member	(see 41A, Front lower structure, Front impact cross member: Removal - Refitting, page 41A-8)	Aluminium
(2)	Radiator mounting cross member	(see 41A, Front lower structure, Radiator support cross member: Removal - Refitting, page 41A-13)	
(3)	Front end panel centre section	(see 42A, Upper front structure, Front: Removal - Refitting, page 42A-23)	Steel/SMC
(4)	Front end panel side section	(see 42A, Upper front structure, Front: Removal - Refitting, page 42A-23)	SMC
(5)	Bonnet	(see 48A, Non-side opening elements, Bonnet: Removal - Refitting, page 48A-5)	Aluminium

NON-SIDE OPENING ELEMENTS

48A

Vehicle removable section structure: Description

B84 or C84

Mark	Description	Classification	Type
(6)	Front wing upper mounting support	(see 42A, Upper front structure, Front wing upper mounting support: Removal - Refitting, page 42A-20)	
(7)	Front wing	(see 42A, Upper front structure, Front wing: Removal - Refitting, page 42A-11)	Noryl
(8)	Front wing lower mounting support	(see 42A, Upper front structure, Front wing lower mounting support: Removal - Refitting, page 42A-18)	
(9)	Dashboard cross member	(see 42A, Upper front structure, Dashboard cross member: Removal - Refitting, page 42A-42)	
(10)	Bulkhead plate	(see 42A, Upper front structure, Bulkhead panel: Removal - Refitting, page 42A-54)	Aluminium
(11)	Front side door, 3-door version	(see 47A, Side opening elements, Front side door: Removal - Refitting, page 47A-5)	
(12)	Front side door, 5-door version	(see 47A, Side opening elements, Front side door: Removal - Refitting, page 47A-5)	
(13)	Fuel filler flap cover	(see 47A, Side opening elements, Fuel filler flap cover: Removal - Refitting, page 47A-27)	Noryl
(14)	Rear section of rear floor	(see Rear floor rear section: Description)	
(15)	Rear side door	(see 47A, Side opening elements, Rear side door: Removal - Refitting, page 47A-18)	
(16)	Rear impact lower cross member	(see 41D, Rear lower structure, Rear impact lower cross member: Removal - Refitting, page 41D-33)	Polypropylene
(17)	Tailgate	(see 48A, Non-side opening elements, Tailgate: Removal - Refitting, page 48A-11)	

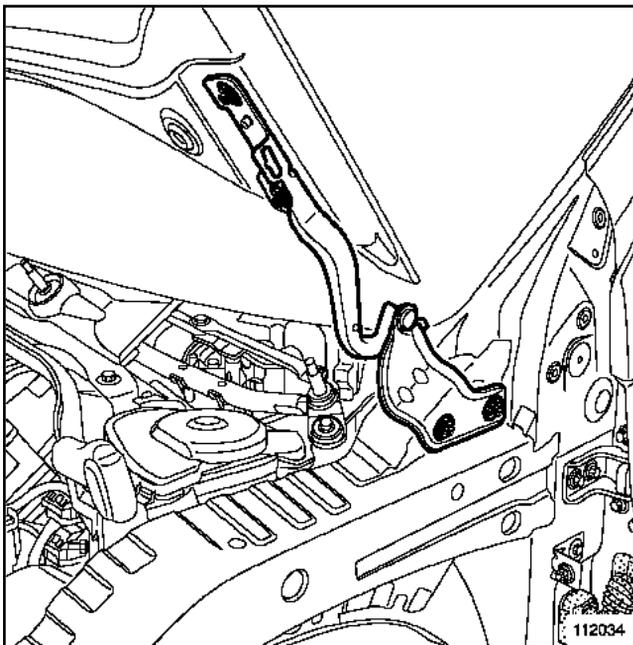
Bonnet: General description

B84 or C84

WARNING

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

I - DESIGN OF THE STRUCTURAL COMPONENT

112034

This type of bonnet has the following specifications:

- opening at the front, « bolted and bolted », type hinges at the rear, mounted vertically on the bonnet hinge mounting and flat mounted and indexed on the bonnet lining,
- side stay mounted on the front wing mounting support,
- side stops mounted with pedestrian impact absorbers built into the front upper cross member,
- central lock with built-in safety retainer,
- with built-in and removable windscreen washer jets.

II - REMOVAL - REFITTING

If the bonnet hinge mountings are of the « bolted and bolted » type, following the operations to be performed, it is possible to remove the bonnet:

- either by unscrewing the mountings on the component if the bonnet is to be replaced or removed for mechanical work,
- or with the hinges by removing the mountings on the aperture if the body is to be replaced.

Note:

If the component is to be removed and not replaced, mark the position of the mountings before unscrewing them to avoid having making adjustments when refitting the component.

III - ADJUSTMENT**Note:**

The bonnet is the last of the removable components to be fitted on the body in the factory assembly process.

For final adjustment, correctly position all the other components including the bumper and the headlights for them to be correctly positioned.

There are two main areas where adjustments can be made:

- adjustment of the rear area,
- adjustment of the front area.

Always begin the adjustments on the hinge side with the lock striker plate loose and the stops in place.

Adjustment of the rear area:

Adjust the shut lines and alignment with the scuttle aperture and the front wings using the bonnet hinge mountings.

Adjustment of the front area:

Shut lines with the wings and clearance from the bumper and headlights are not adjustable because the bonnet stops on the front upper cross member are fixed.

Only the closure firmness is adjustable by the fittings securing the lock.

B84 or C84

Note:

In this case, compromise between the closure firmness and the front height of the bonnet by giving priority to closing in such a way as to retain a minimum bonnet drag in the direction of the support on the stops to avoid the front of the bonnet floating.

B84 or C84

Tightening torques 	
bonnet mounting bolts	8 Nm
bonnet hinge mounting bolts	8 Nm

I - REMOVAL BY MEANS OF THE BONNET BOLTS

1 - REMOVAL PREPARATION OPERATION

- Remove:
 - the bonnet soundproofing((see **Bonnet soundproofing: Removal - Refitting**) ,
 - the tube supplying the washer jets on the bonnet.

2 - OPERATION FOR REMOVAL OF PART CONCERNED



101162

- Remove:
 - the bonnet mounting bolts (1) ,
 - the bonnet.

II - REFITTING BY MEANS OF THE BONNET BOLTS

1 - REFITTING OPERATION FOR PART CONCERNED

- Refit:
 - the bonnet,

- the bonnet mounting bolts (1) .

- Adjust the opening clearances and shut lines (see **48A, Non-side opening elements, Bonnet: Adjustment, page 48A-7**) .
- Torque tighten the **bonnet mounting bolts (8 Nm)** .

2 - FINAL OPERATION

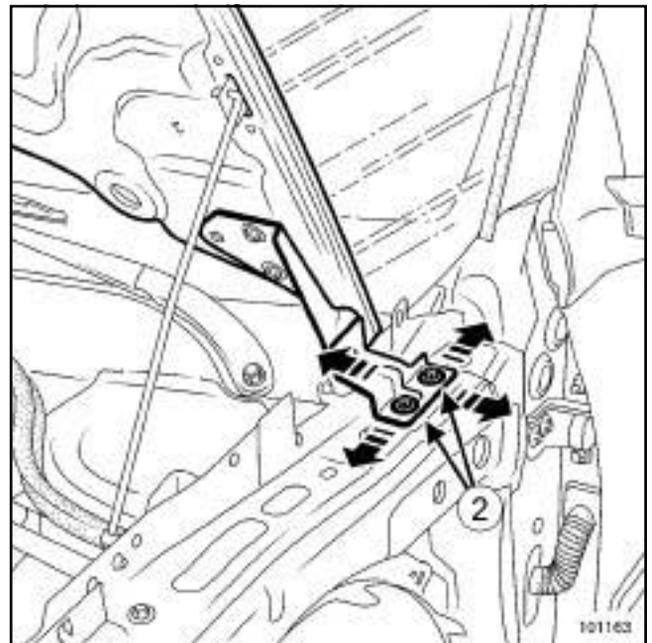
- Refit:
 - the tube supplying the washer jets on the bonnet,
 - the bonnet soundproofing((see **Bonnet soundproofing: Removal - Refitting**) .

III - REMOVAL BY MEANS OF THE BONNET HINGE BOLTS

1 - REMOVAL PREPARATION OPERATION

- Remove:
 - the front wing (see **42A, Upper front structure, Front wing: Removal - Refitting, page 42A-11**) ,
 - the bonnet soundproofing((see **Bonnet soundproofing: Removal - Refitting**) ,
 - the tube supplying the washer jets on the bonnet.

2 - OPERATION FOR REMOVAL OF PART CONCERNED



101163

- Remove:
 - the bonnet hinge mounting bolts (2) ,

B84 or C84

- the bonnet.

IV - REFITTING BY MEANS OF THE BONNET HINGE BOLTS

1 - REFITTING OPERATION FOR PART CONCERNED

Refit:

- the bonnet,

- the bonnet hinge mounting bolts (2) .

Adjust the opening clearances and shut lines (see **48A, Non-side opening elements, Bonnet: Adjustment**, page **48A-7**) .

Torque tighten the **bonnet hinge mounting bolts (8 Nm)** .

2 - FINAL OPERATION

Refit:

- the tube supplying the washer jets on the bonnet,

- the bonnet soundproofing((see **Bonnet soundproofing: Removal - Refitting**) ,

- the front wing (see **42A, Upper front structure, Front wing: Removal - Refitting**, page **42A-11**) .

Bonnet: Adjustment

B84 or C84

Tightening torques 	
bonnet mounting bolts	8 Nm
bonnet hinge mounting bolts	8 Nm
safety catch mounting bolts	8 Nm

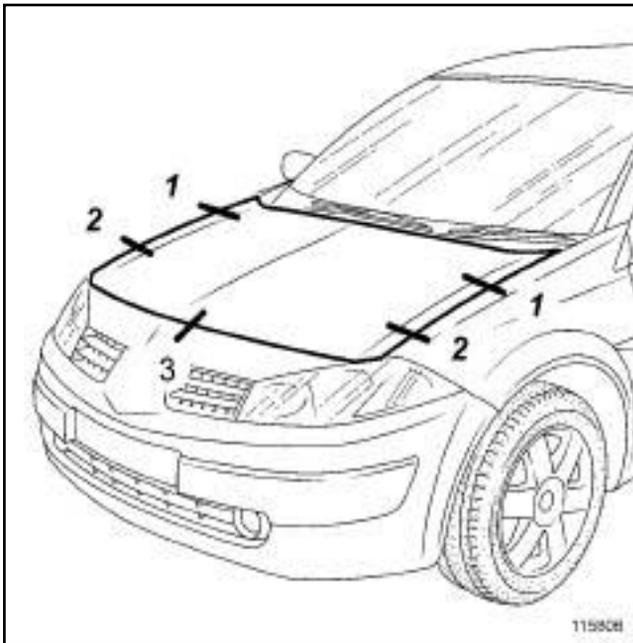
ADJUSTMENT VALUES

- ❑ For any information regarding bonnet adjustment values, see **Vehicle shut lines: Adjustment value** .

ADJUSTMENT

- ❑ There are two options for adjusting the bonnet:
 - by means of the bonnet mounting bolts,
 - by means of the bonnet hinge mounting bolts: the front wing needs to be removed for this operation.

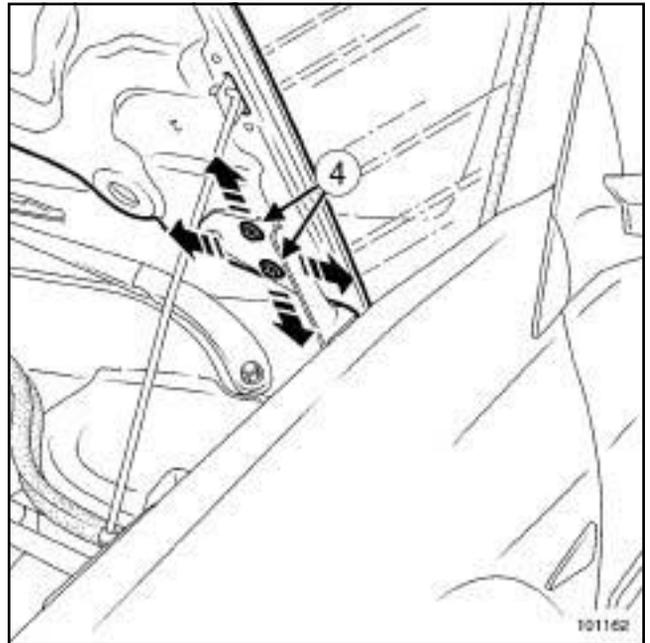
The bonnet striker must be adjusted in addition to the bonnet adjustment.



115806

- ❑ Observe the adjustment sequence.

I - ADJUSTMENT BY MEANS OF THE BONNET MOUNTING BOLTS



101162

- ❑ Undo the bonnet mounting bolts (4) .
- ❑ Adjust the bonnet shut lines.
- ❑ Torque tighten the **bonnet mounting bolts (8 Nm)**

Bonnet: Adjustment

B84 or C84

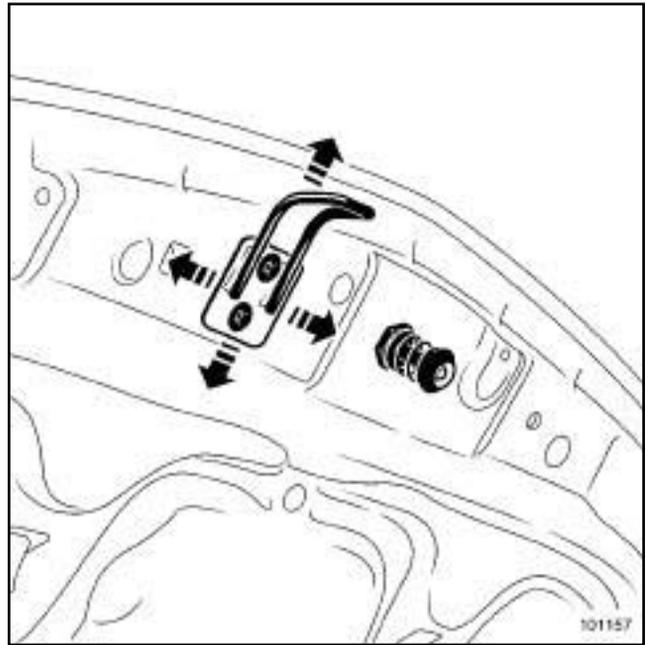
II - ADJUSTMENT BY MEANS OF THE BONNET HINGE MOUNTING BOLTS



101163

- Remove the front wing (see **42A, Upper front structure, Front wing: Removal - Refitting**, page **42A-11**).
- Undo the bonnet hinge bolts (5).
- Position the front wing on the vehicle.
- Adjust the bonnet shut lines.
- Remove the front wing.
- Torque tighten the **bonnet hinge mounting bolts (8 Nm)**.
- Refit the front wing (see **42A, Upper front structure, Front wing: Removal - Refitting**, page **42A-11**)

III - ADJUSTMENT OF THE CLOSING PLUNGER AND SAFETY CATCH



101157

-

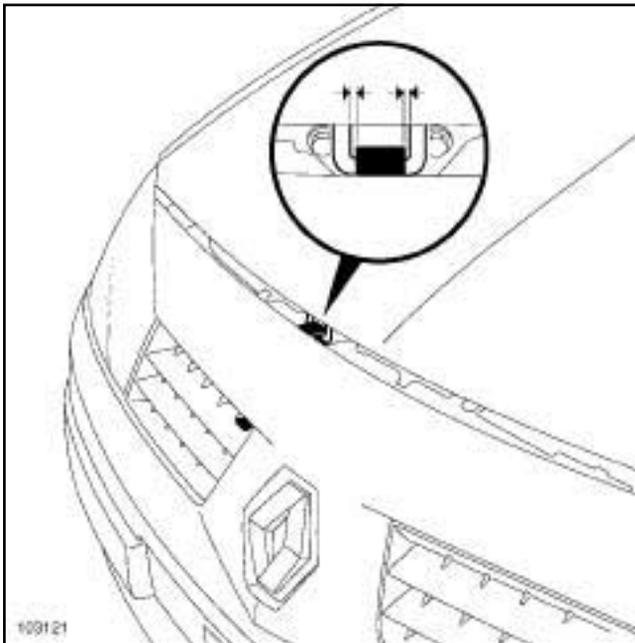
Note:

When adjusting the closing plunger and safety catch, it is essential to remove the closing plunger and catch, and touch up the bonnet paintwork with anti-corrosion protection.

- Adjust the closing plunger with the bonnet lock.

Bonnet: Adjustment

B84 or C84



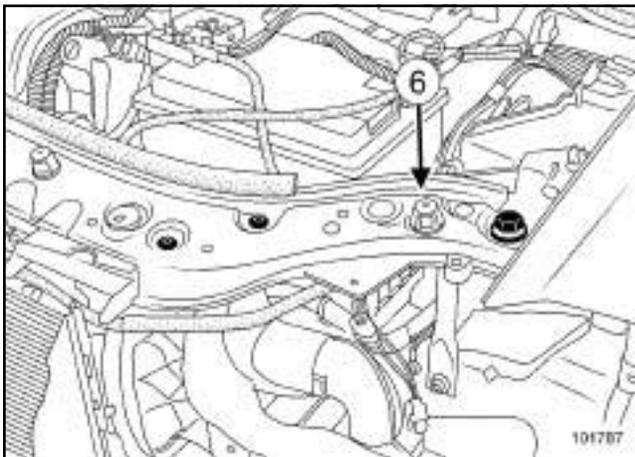
103121

- Adjust the safety catch.

Note:

It is essential to check that the safety catch operates correctly following adjustment of the bonnet and lock mechanism.

- Tighten to torque the **safety catch mounting bolts (8 Nm)** .



101787

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Note:

When in the closed position, the bonnet should rest on stops (6) .

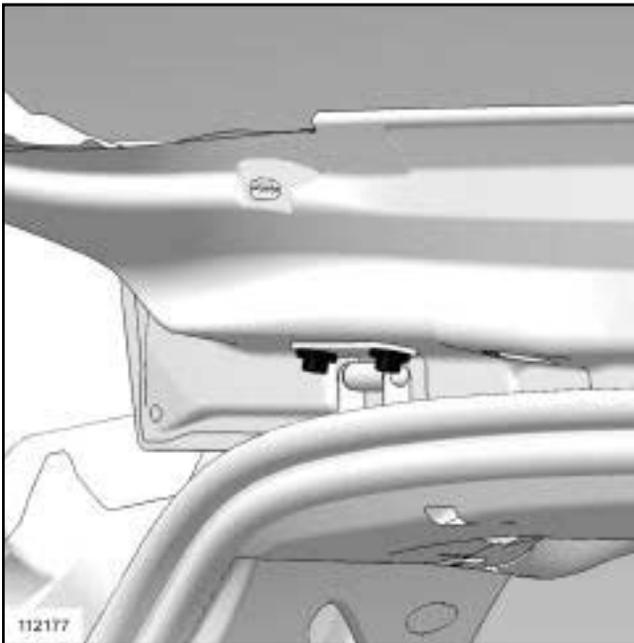
Tailgate: General description

B84 or C84

WARNING

The information contained in the following describes the general repair procedure for all vehicles having the same design for this part.

Before reading the following general information, make sure that there are no special notes associated with the vehicle. These special notes are specified if necessary in other parts of the sub-section dealing with the component.

I - DESIGN OF THE STRUCTURAL COMPONENT

112177

This type of tailgate has the following specifications:

- bottom opening, hinges at the top of the "bolted and bolted" type, fixed vertically on the tailgate hinge reinforcements and flat mounted on the tailgate lining,
- side stays fixed onto the rain channels of the rear wings,
- fixed side stops built into the tailgate lining,
- central lock.

II - REMOVAL - REFITTING

When the tailgate hinge mountings are of the "bolted and bolted" type, following the operations to be performed it is possible to remove the tailgate:

- either by unscrewing the mountings on the component if the tailgate is to be replaced,
- or with the hinges by removing the mountings on the roof rear cross member if the body is to be replaced.

Note:

If the component is to be removed and not replaced, mark the position of the mountings before unscrewing them to avoid having making adjustments when refitting the component.

III - ADJUSTMENT

Note:

For final adjustment, correctly position the rear lights and the bumper so that they remain correctly positioned.

Two main areas of adjustment may be identified:

- adjustment of the upper area,
- adjustment of the lower area.

always begin the adjustments on the hinge side with the lock striker plate loose and the stops in place.

Adjustment of the upper area:

Adjust the shut lines and alignment with the roof and the rear wings using the tailgate hinge mountings.

Adjustment of the lower area:

Shut lines with the wings and clearance from the bumper and rear lights are not adjustable because the tailgate stops on the tailgate lining are fixed.

Only the closure firmness is adjustable by the fittings securing the lock.

Note:

In this case, compromise between the closure length and the lower shut lines of the tailgate by giving priority to closing in such a way as to retain sufficient pressure by the tailgate on the stops to prevent the tailgate floating.

B84 or C84

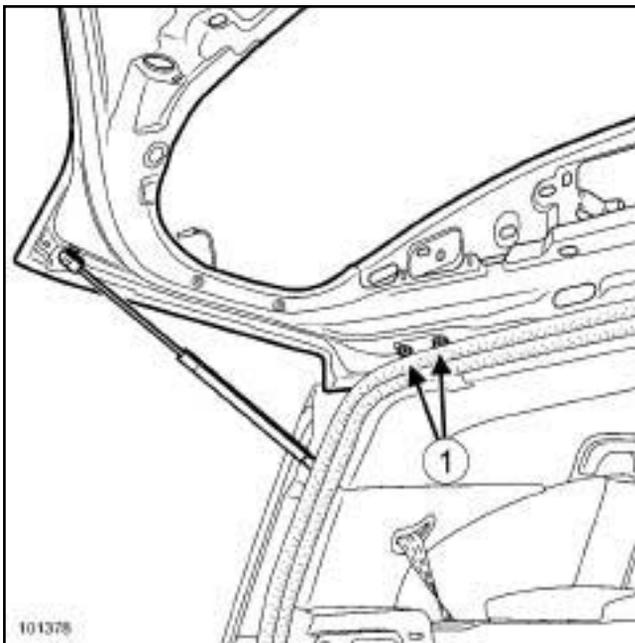
Tightening torques 	
tailgate mounting bolts	8 Nm
hinge mounting bolt	21 Nm

I - REMOVAL WITHOUT THE HINGES

1 - REMOVAL PREPARATION OPERATION

- Remove the tailgate trim((see **Tailgate lining: Removal - Refitting**) .
- Disconnect the electrical connectors to:
 - the rear screen wiper motor,
 - the tailgate lock,
 - the heated rear screen.
- Remove:
 - the tailgate electrical supply harness,
 - the washer jet pipes,
 - the tailgate gas struts.

2 - OPERATION FOR REMOVAL OF PART CONCERNED



- Remove:
 - the tailgate mounting bolts (1) from each side of the vehicle.
 - the tailgate.

II - REFITTING WITHOUT HINGES

1 - REFITTING OPERATION FOR PART CONCERNED

- Refit:
 - the tailgate,
 - the tailgate mounting bolts (1) to each side of the vehicle.
- Torque tighten the **tailgate mounting bolts (8 Nm)** .

2 - FINAL OPERATION

- Refit:
 - the tailgate gas struts,
 - the washer jet pipes,
 - the tailgate electrical feed harness.
- Connect the electrical connectors to:
 - the heated rear screen,
 - the tailgate lock,
 - the rear screen wiper motor,
- Refit the tailgate trim((see **Tailgate lining: Removal - Refitting**) .

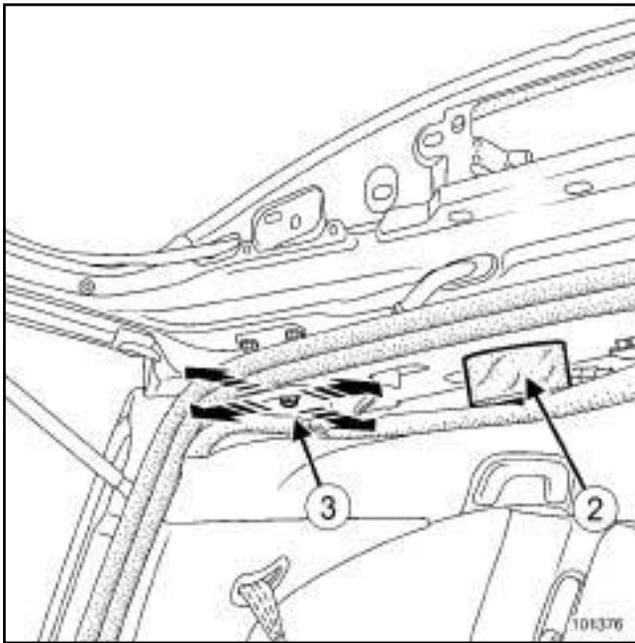
III - REMOVAL WITH HINGES

1 - REMOVAL PREPARATION OPERATION

- Remove the tailgate trim((see **Tailgate lining: Removal - Refitting**) .
- Disconnect the electrical connectors to:
 - the rear screen wiper motor,
 - the tailgate lock,
 - the heated rear screen.
- Remove:
 - the tailgate electrical supply harness,
 - the washer jet pipes,
 - the tailgate gas struts.

B84 or C84

2 - OPERATION FOR REMOVAL OF PART CONCERNED



101376

- Keep the headlining to one side using a wedge (2) .
- Remove:
 - the hinge mounting bolt (3) from each side of the vehicle,
 - the tailgate.

IV - REFITTING WITH HINGES

1 - REFITTING OPERATION FOR PART CONCERNED

- Refit:
 - the tailgate,
 - the hinge mounting bolt (3) to each side of the vehicle,
- Tighten to torque the **hinge mounting bolt (21 Nm)** .
- Fit the headlining.

2 - FINAL OPERATION

- Refit:
 - the tailgate gas struts,
 - the washer jet pipes,
 - the tailgate electrical feed harness.
- Connect the electrical connectors to:
 - the heated rear screen,

- the tailgate lock,
- the rear screen wiper motor,

- Refit the tailgate trim((see **Tailgate lining: Removal - Refitting**) .

B84 or C84

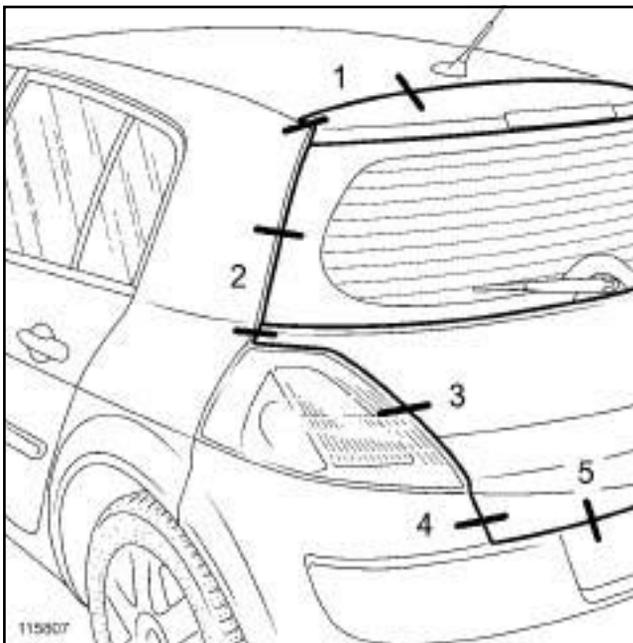
Tightening torques 	
tailgate mounting bolts	8 Nm
tailgate hinge mounting bolt	21 Nm
tailgate striker plate mounting bolts	21 Nm

ADJUSTMENT VALUES

- For any information regarding tailgate adjustment values, see **Vehicle shut lines: Adjustment value** .

ADJUSTMENT

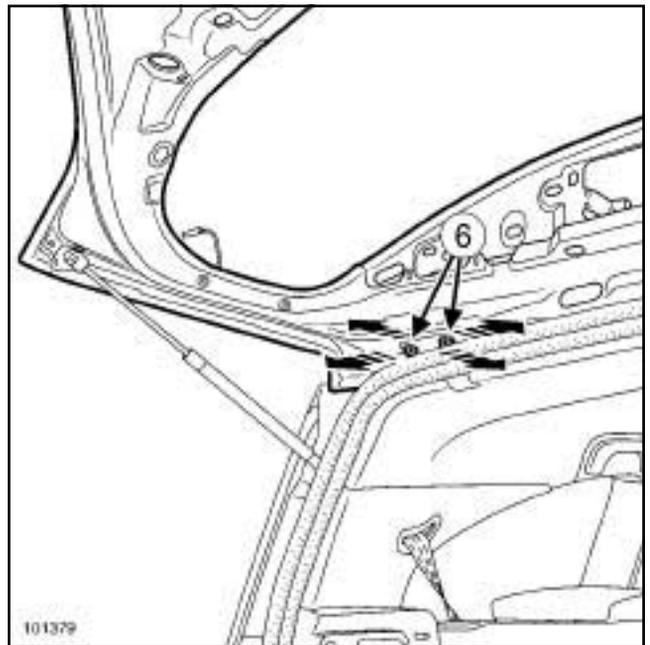
- There are two options for adjusting the tailgate:
 - by means of the tailgate mounting bolts,
 - by means of the tailgate hinge mounting bolts:
- The tailgate striker plate must be adjusted in addition to the tailgate adjustment.



115807

- Observe the adjustment sequence.

I - ADJUSTMENT BY MEANS OF THE TAILGATE MOUNTING BOLTS



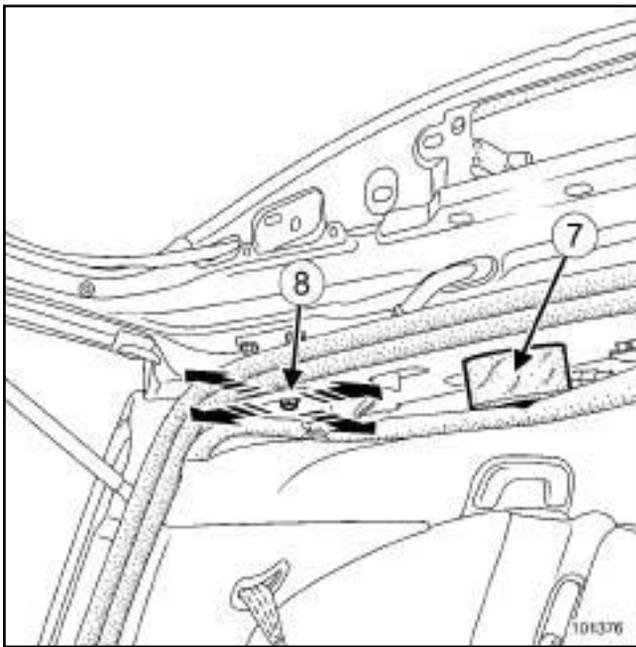
101379

- Loosen the tailgate mounting bolts (6) .
- Adjust the tailgate shut lines.
- Torque tighten the **tailgate mounting bolts (8 Nm)** .

Tailgate: Adjusting

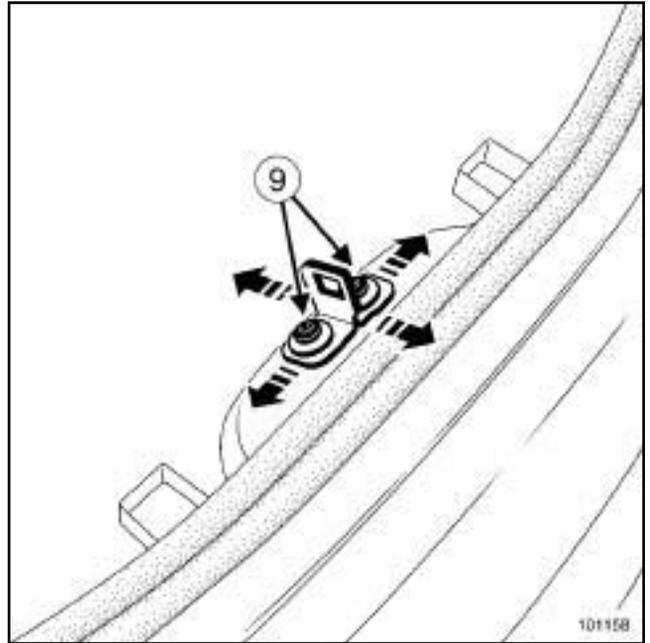
B84 or C84

II - ADJUSTMENT BY MEANS OF THE TAILGATE HINGE MOUNTING BOLTS

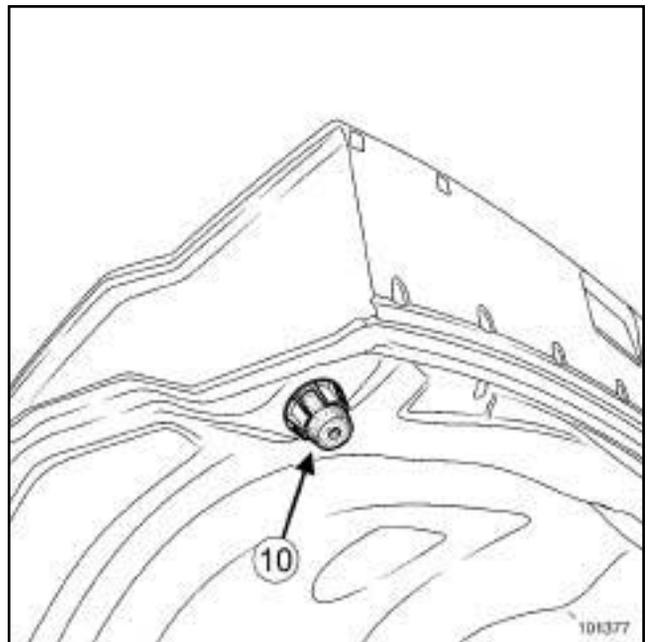


- Keep the headlining to one side using a wedge (7) .
- Loosen the tailgate hinge mounting bolt (8) .
- Adjust the tailgate shut lines.
- Tighten to torque the **tailgate hinge mounting bolt (21 Nm)** .
- Fit the headlining.

III - TAILGATE STRIKER PLATE ADJUSTMENT



- Loosen the tailgate striker plate mounting bolts (9) .
- Adjust the tailgate lower section shut lines.
- Tighten to torque the **tailgate striker plate mounting bolts (21 Nm)** .



Note:

When in the closed position, the stops (10) should rest on the body.

B84 or C84

Described below is a special sequence of operations for tailgate replacement.

Note:

It is possible to carry out the trim removal operations on the vehicle before removing the tailgate.

STRIPPING

Remove:

- the tailgate trim((see **Tailgate lining: Removal - Refitting**) ,
- the rear screen wiper motor((see **Rear screen wiper motor: Removal - Refitting**) ,
- the tailgate lock((see **Tailgate lock: Removal - Refitting**) ,
- the tailgate opening control((see **Tailgate exterior opening control: Removal - Refitting**) ,
- the high level brake light((see **Third brake light: Removal - Refitting**) ,
- the rear screen((see **Rear screen glass: Removal - Refitting**) ,
- the wiring harness.

REASSEMBLING

Refit:

- the wiring harness,
- the rear screen((see **Rear screen glass: Removal - Refitting**) ,
- the high level brake light((see **Third brake light: Removal - Refitting**) ,
- the tailgate opening control((see **Tailgate exterior opening control: Removal - Refitting**) ,
- the tailgate lock((see **Tailgate lock: Removal - Refitting**) ,
- the rear screen wiper motor((see **Rear screen wiper motor: Removal - Refitting**) ,
- the tailgate trim((see **Tailgate lining: Removal - Refitting**) .