

REMOVING - REFITTING : ROOF CONSOLE (SHELF ABOVE WINDSCREEN)

1. Recommended tools

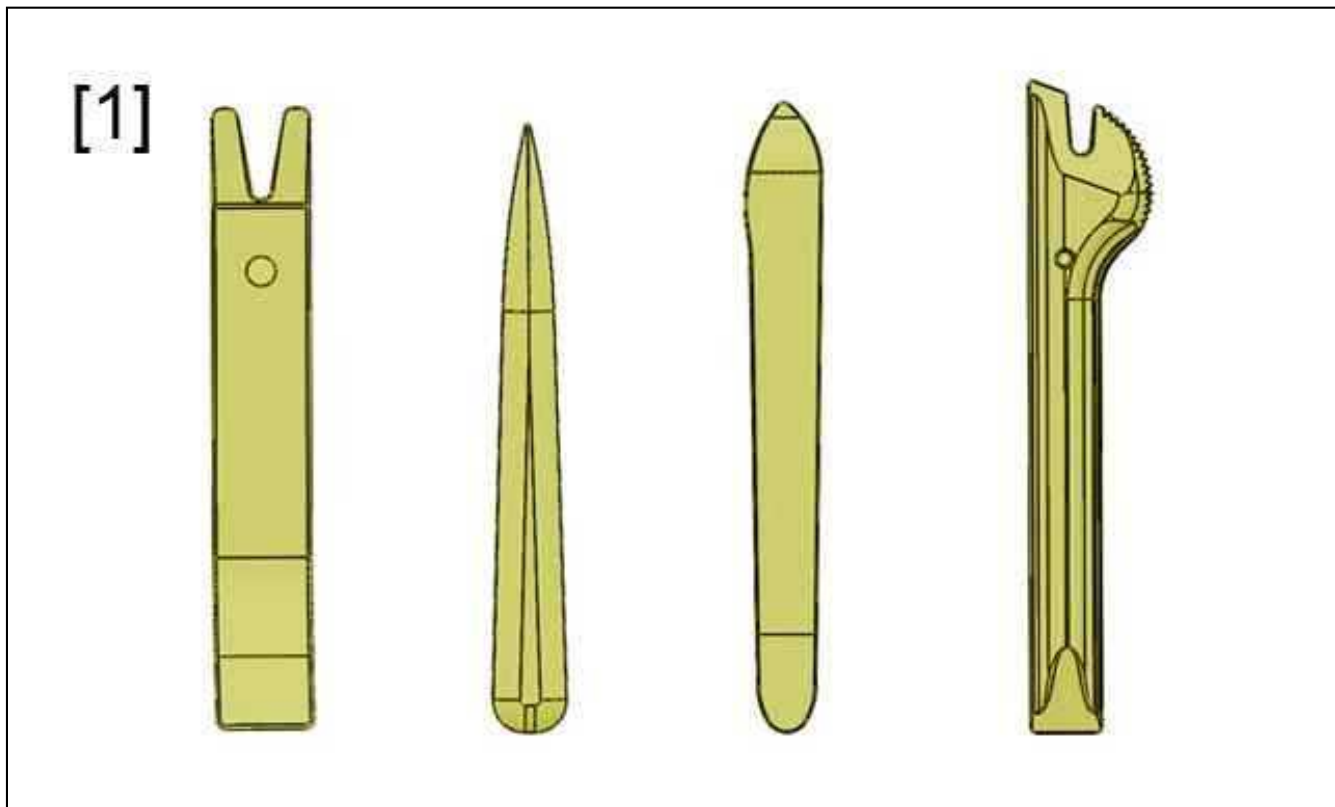


Figure : E5AP30WD

[1] Stripping tool (-).1350-ZZ.

2. Removing



Figure : C5FP19DD

Detach the central trim (2) from the roof console (1) (at "a") ; Using tool [1].

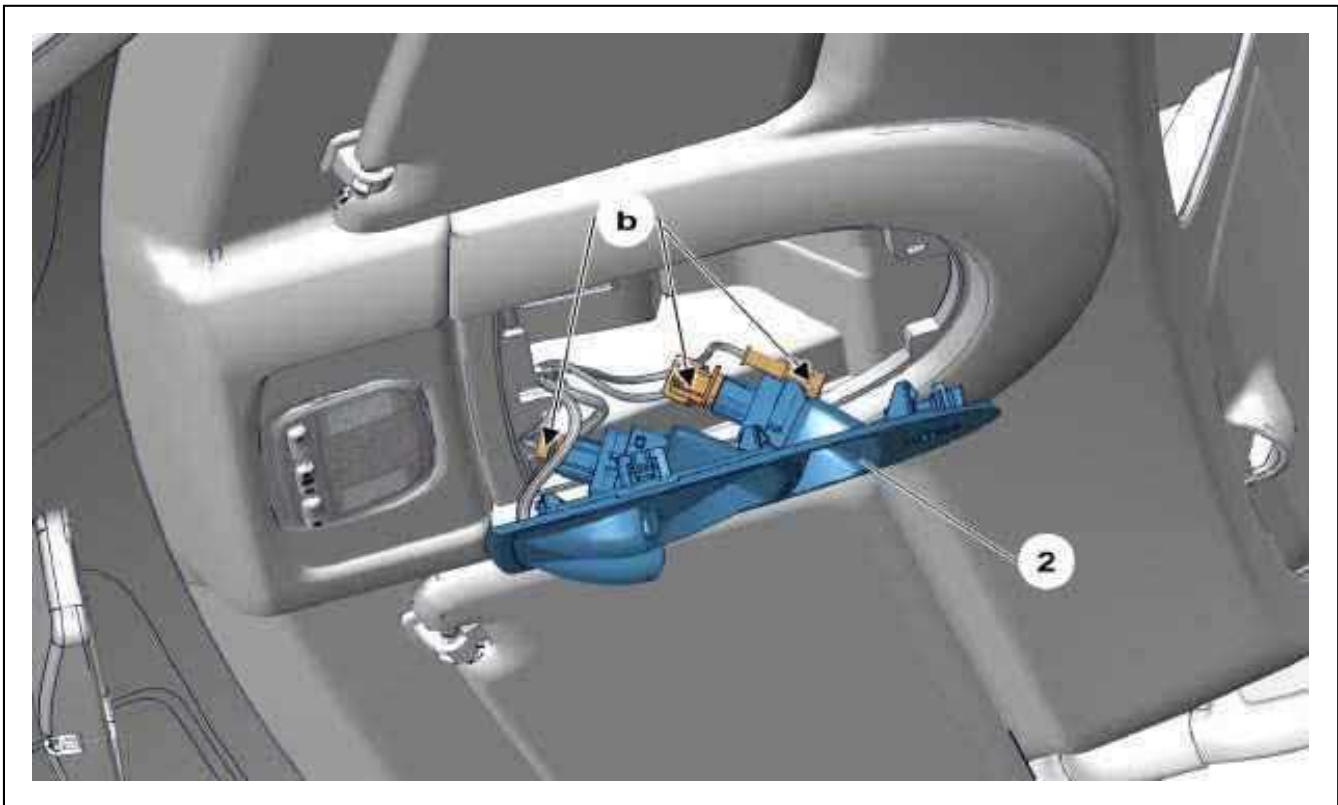


Figure : C5FP19ED

Disconnect the connectors (b).
Detach the central trim (2).

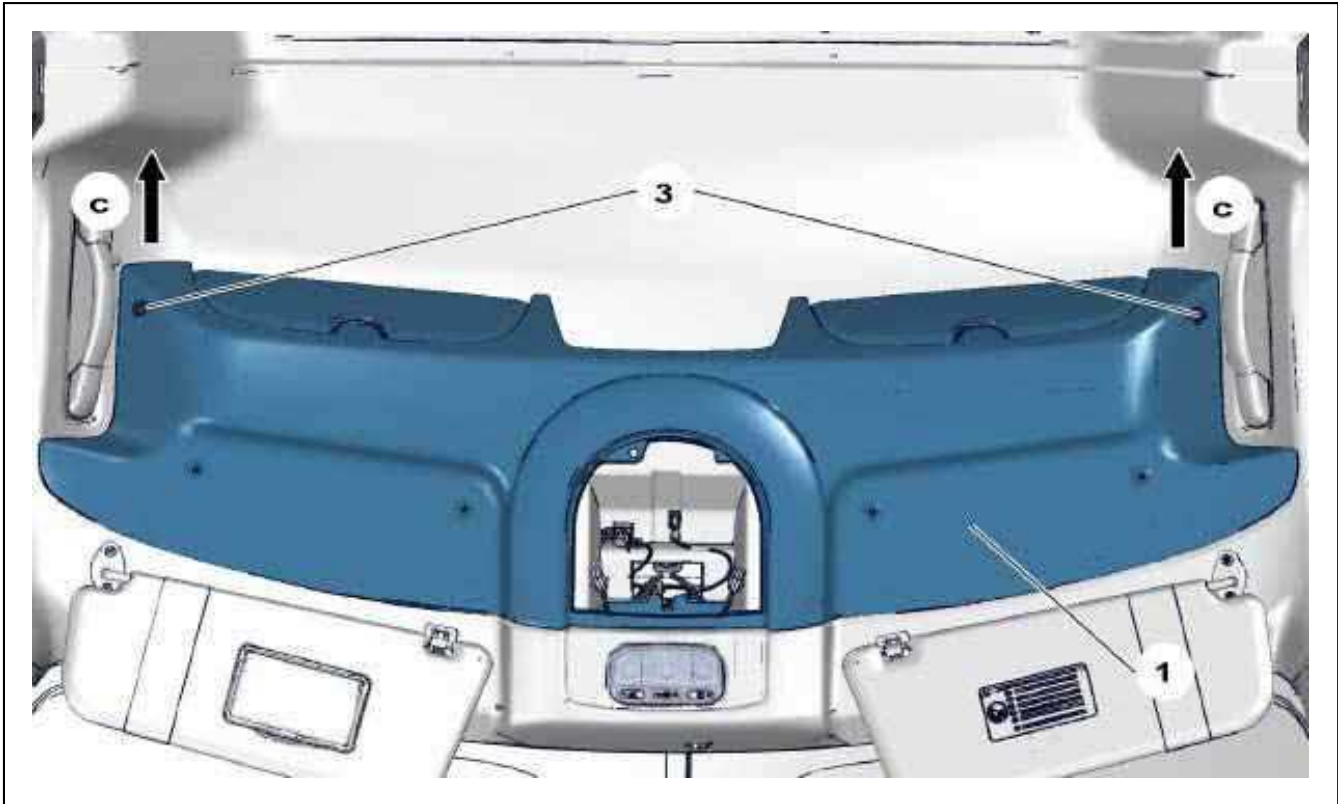


Figure : C5FP19FD

Detach the sun visors from their support.

Remove the bolts (3).

Disengage the roof console (1) (following "c").

Remove the roof console (1).

3. Refitting

Proceed in the reverse order to removal.

Check the electrical operation of the equipment.

REMOVING - REFITTING : ROOF CONSOLE

1. Recommended tools

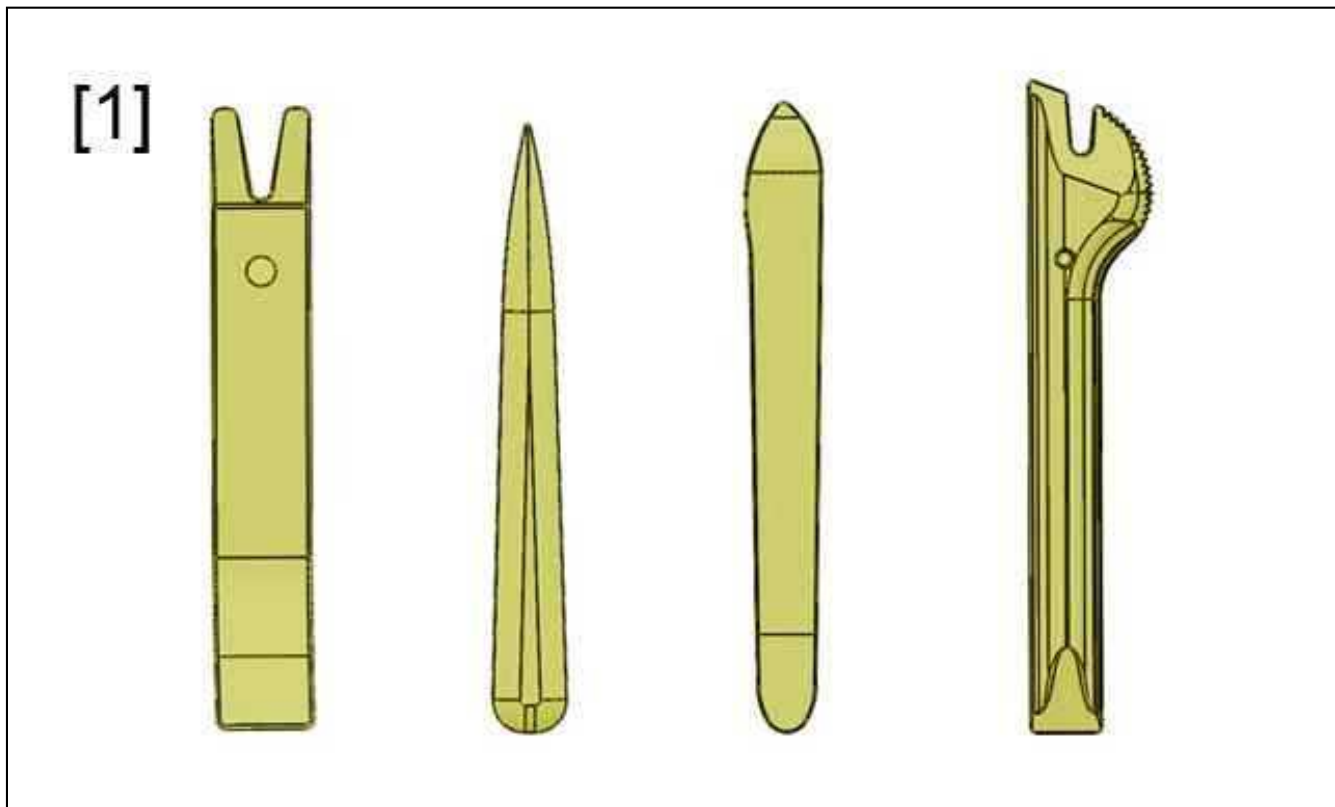


Figure : E5AP30WD

[1] Stripping tools (-).1350-ZZ.

2. Removing

Perform the following operations :

- Switch off the ignition
- Wait 3 minutes before disconnecting the battery
- Disconnect the battery

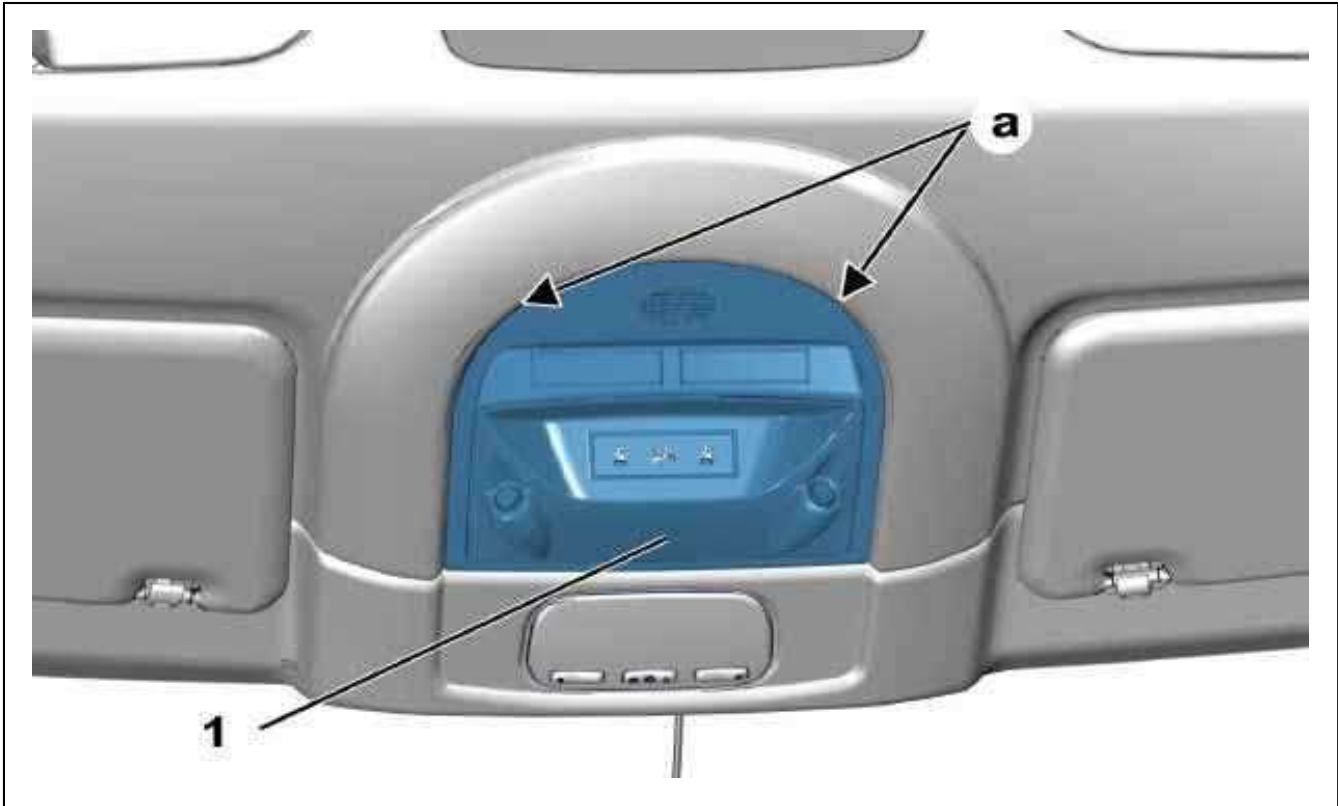


Figure : C4DP0CHD

Unclip the roof console (1) (at "a") ; Using tool [1].

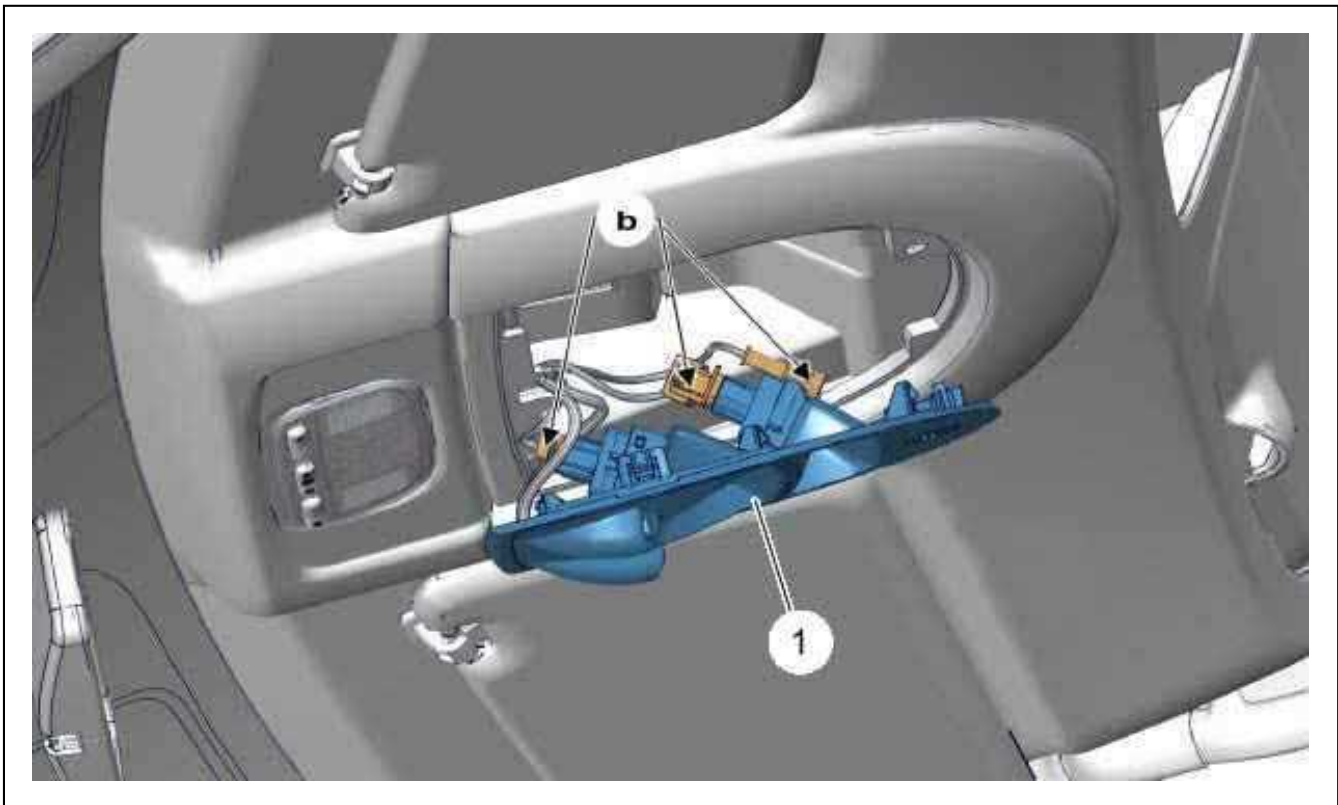


Figure : C5FP1C7D

Disconnect the connectors of the roof console (1) (at "b") (according to equipment).



Figure : C5FP1C8D

Remove the roof console (1).

3. Refitting

Proceed in the reverse order to removal.

Reconnect the battery.

CAUTION : Perform the operations to be carried out following reconnection of the battery ⓘ .

Check all the equipment works.

REPLACEMENT : HIGH VERSION ROOF EXTENSION

ESSENTIAL : Depending on the operation to be carried out, observe the instructions for chocking up the vehicle.

ESSENTIAL : Deactivate the pneumatic suspension before lifting the vehicle ⓘ (2 or 4 post lift, workshop jack or customer's jack ⓘ).

CAUTION : All of the stripped surfaces must be protected by means of the approved electrolytic rezincing process .

ESSENTIAL : Observe the elementary rules of hygiene and safety (wear a face mask to protect against fumes and vapour - work in a well ventilated space).

1. Preliminary operations

Disconnect the ancillaries battery.

Release the wiring harnesses.

Protect the interior of the passenger compartment.

Replace the high version roof ⓘ .

2. Identification of the replacement parts

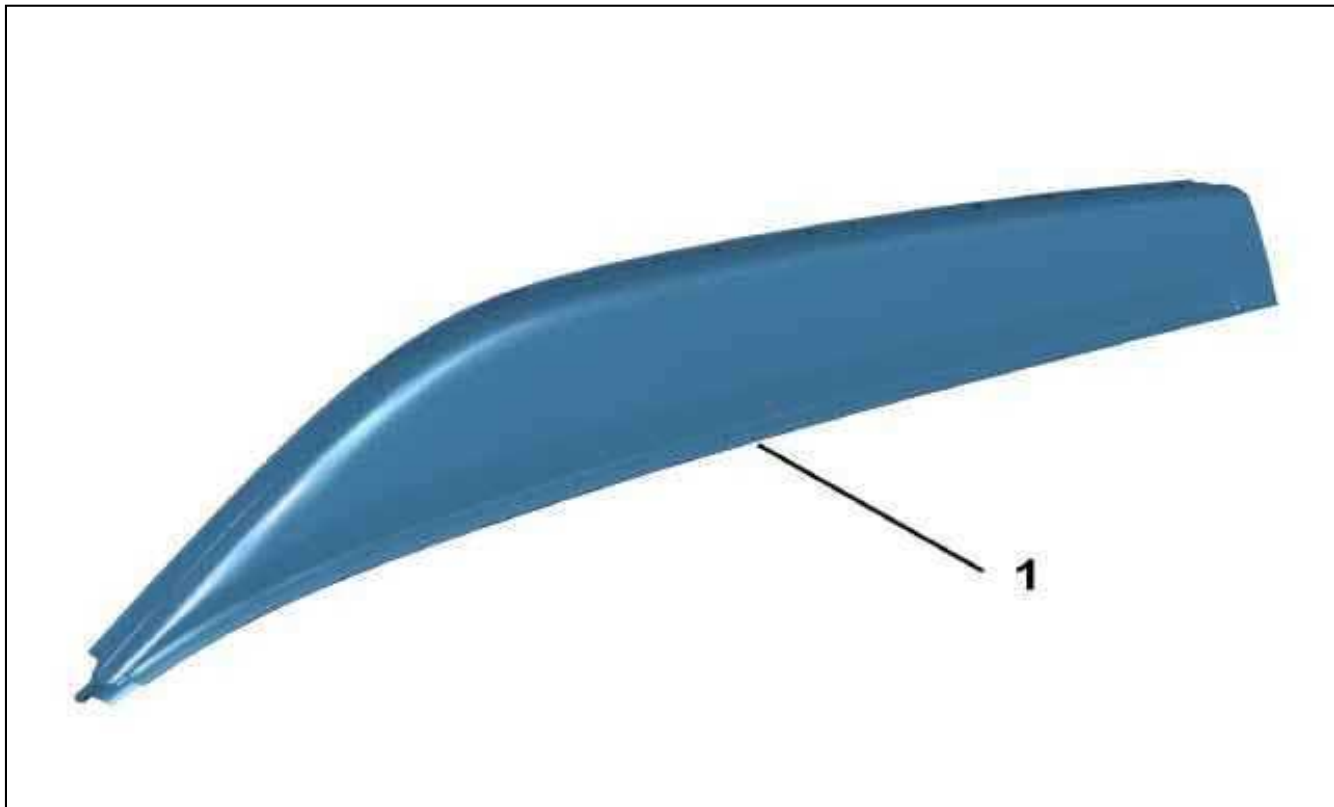


Figure : C4DP0DXD

Reference	Designation	Thickness	Nature/classification
(1)	High version roof blank	0,67 mm	Mild steel

3. Replacement part preparation

Paint the inside of the component before bonding it.

4. Removing

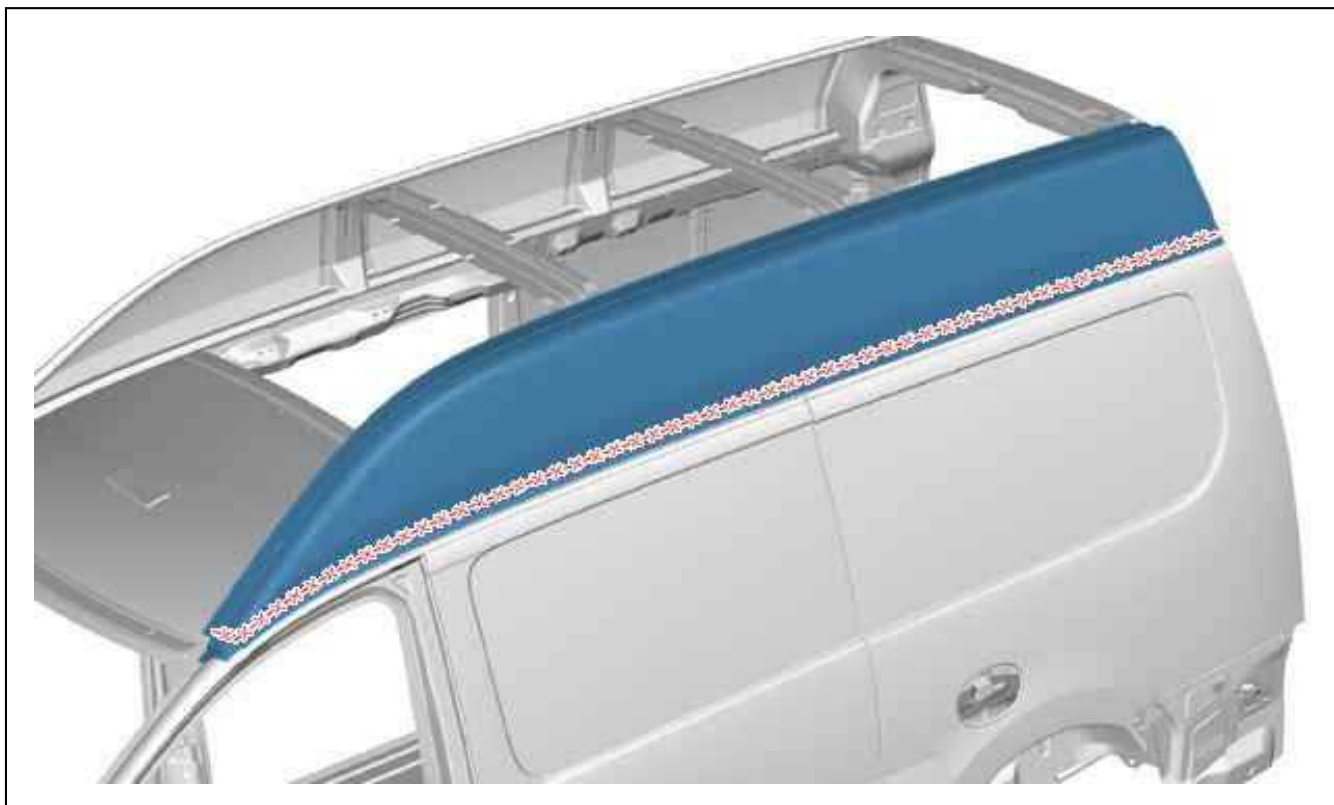


Figure : C4DP0DYD

Mark then cut.

Remove the partial roof extension .

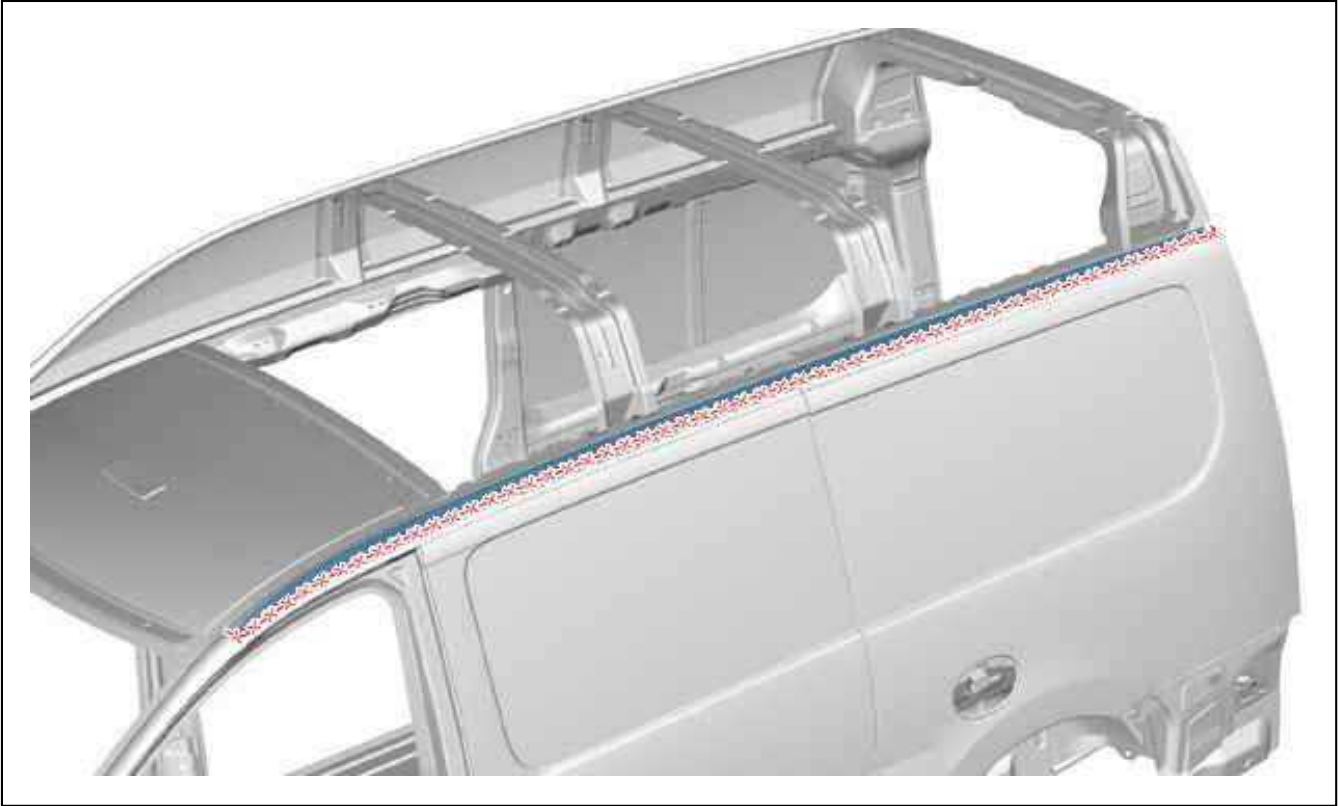


Figure : C4DP0DZD

Cut the remainder of the roof .

Remove the roof extension .

5. Bodywork cleaning and preparation

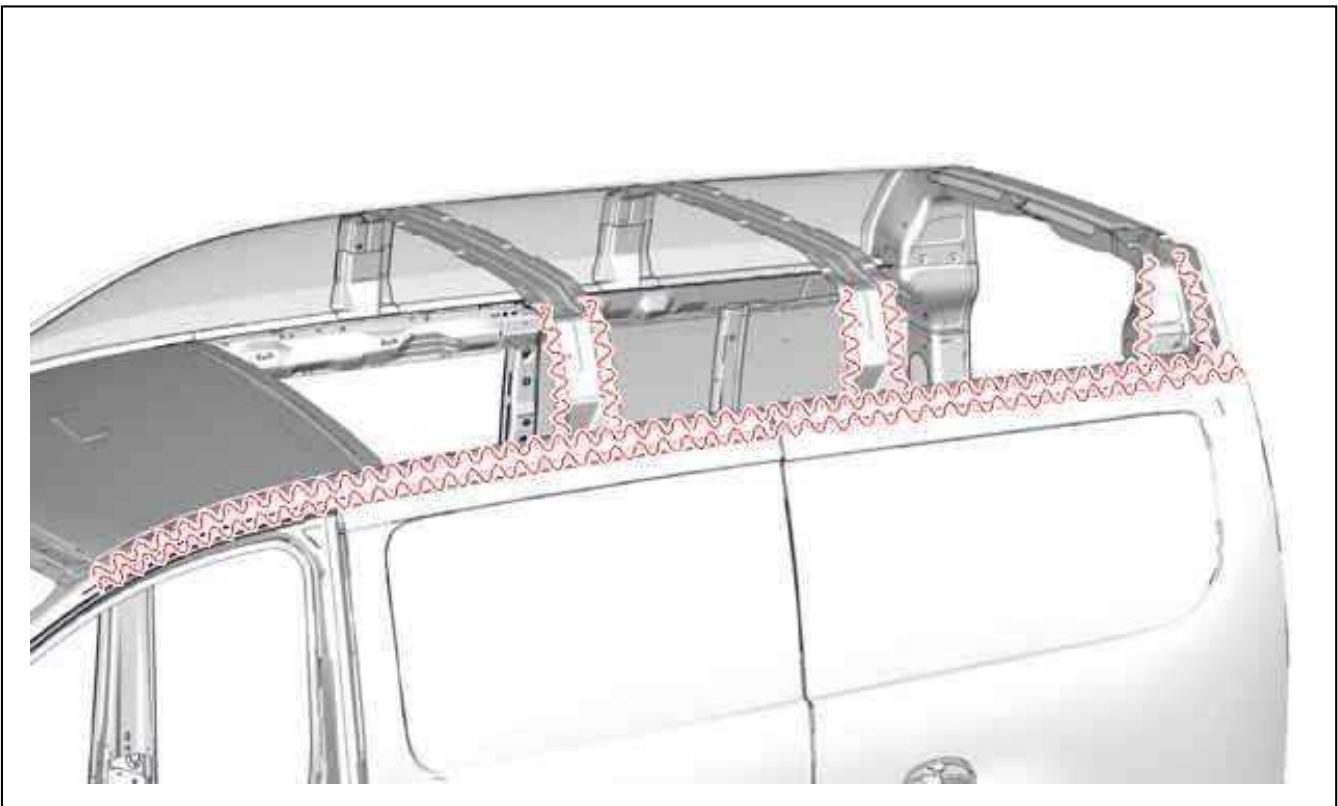


Figure : C4DP0E0D

Level off :

- The bead of filling adhesive
- The bead of mastic sealant

Apply :

- A filling adhesive (index "B8")
- A sealing mastic (index "A1")

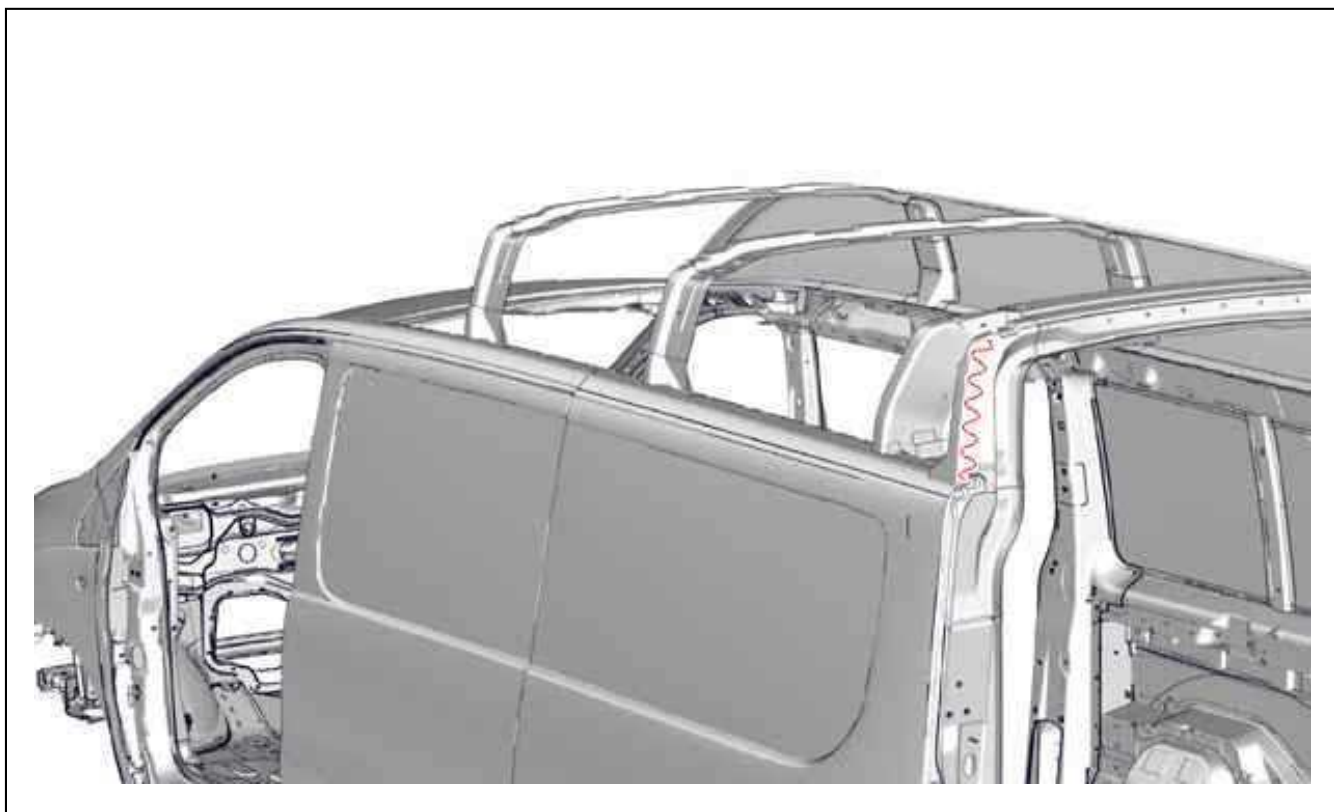


Figure : C4DP0E1D

Level off the bead of filling adhesive .

Apply a filling adhesive (index "B8").

6. Adjustment

Position :

- The roof extension
- The roof

Check the fit.

Remove the roof.

7. Sealing

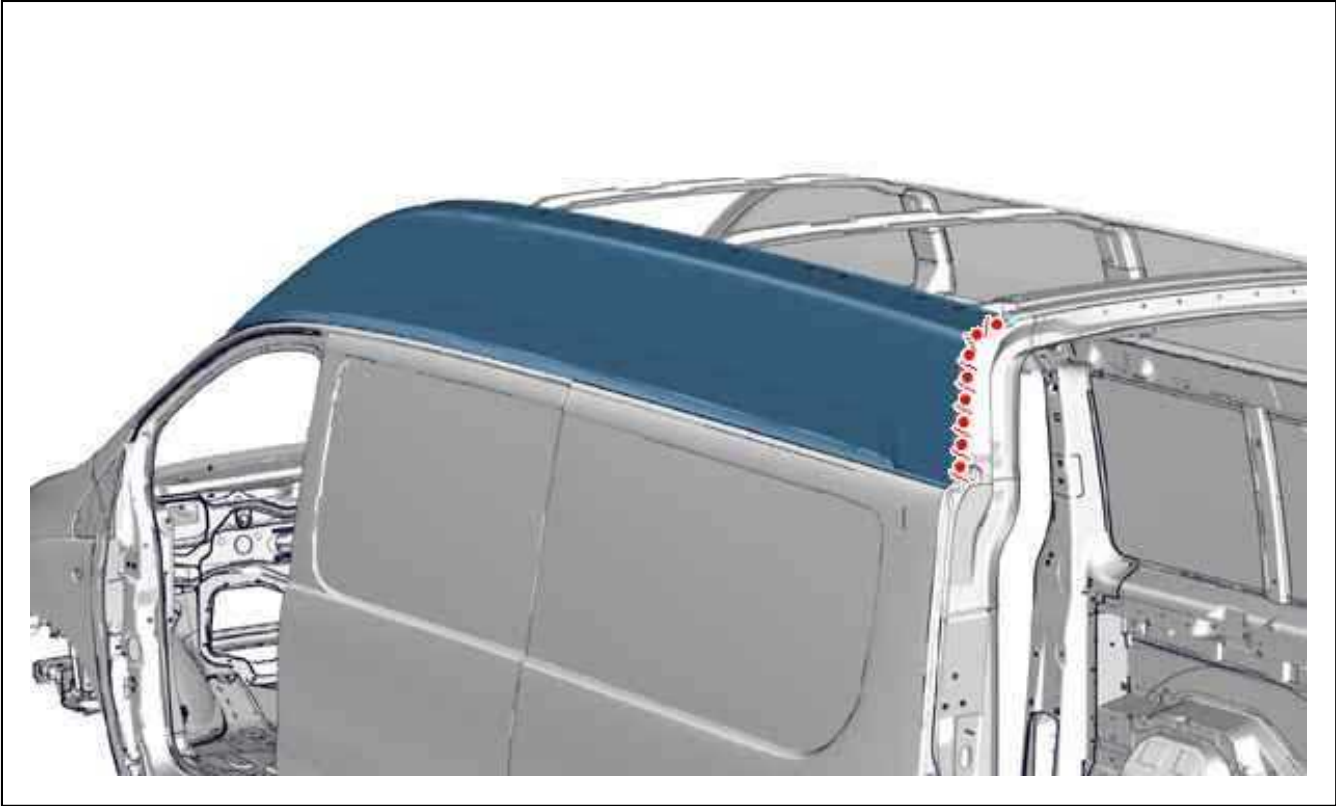


Figure : C4DP0E2D

Apply a sealing mastic (index "A4").

8. Reinitialisation

CAUTION : Perform the operations that are required following a reconnection of the ancillaries battery.

Reconnect the ancillaries battery.

REPLACEMENT : SHORT ROOF CROSSMEMBERS AND BOWS

ESSENTIAL : Depending on the operation to be carried out, observe the instructions for chocking up the vehicle.

ESSENTIAL : Deactivate the pneumatic suspension before lifting the vehicle ⓘ (2 or 4 post lift, workshop jack or customer's jack ⓘ).

ESSENTIAL : : Observe the elementary rules of hygiene and safety (wear a face mask to protect against fumes and vapour - work in a well ventilated space).

CAUTION : : All of the stripped surfaces must be protected by means of the approved electrolytic rezincing process .

1. Additional operations

Disconnect the battery.

Release the wiring harnesses.

Protect the interior of the passenger compartment.

Replacement ⓘ : Short roof ⓘ .

2. Identification of replacement parts

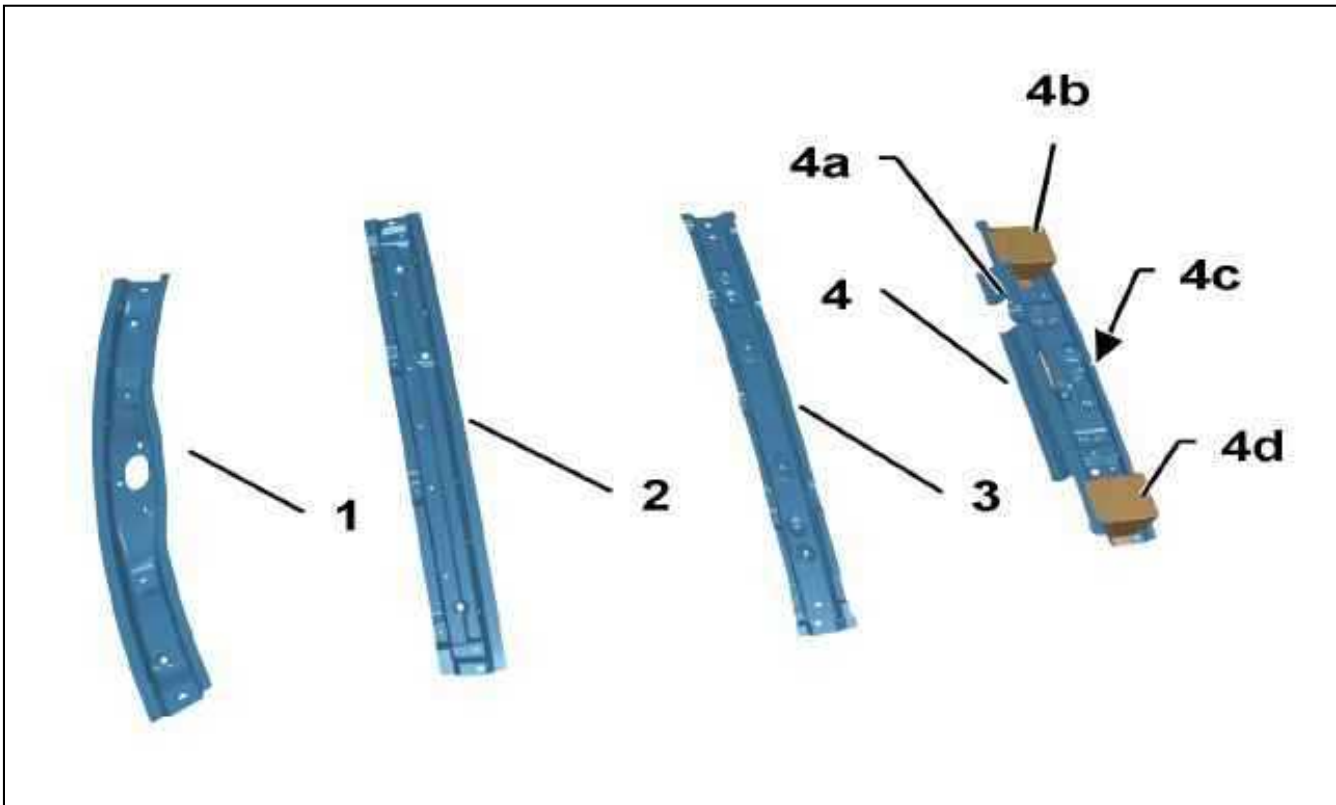


Figure : C4DP0CJD

Reference	Designation	Thickness (mm)	Nature/classification
(1)	Front roof crossmember	0,97	ADX (*)

(2)	Front roof bow	0,97	ADX (*)
(3)	Rear roof member	0,77	ADX (*)
(*) ADX = Mild steel			

(4) Rear cross member assembly			
Reference	Designation	Thickness (mm)	Nature/classification
(4a)	Roof rear crossmember	0,97	ADX (*)
(4b)	Right-hand tailgate hinge strengthener	1,47	High strength (*)
(4c)	Hinged door striker fixing support	1,47	ADX (*)
(4d)	Left-hand tailgate hinge strengthener	1,47	High strength (*)
(*) ADX = Mild steel ; (*) High strength = High strength steel			

3. Cutting out

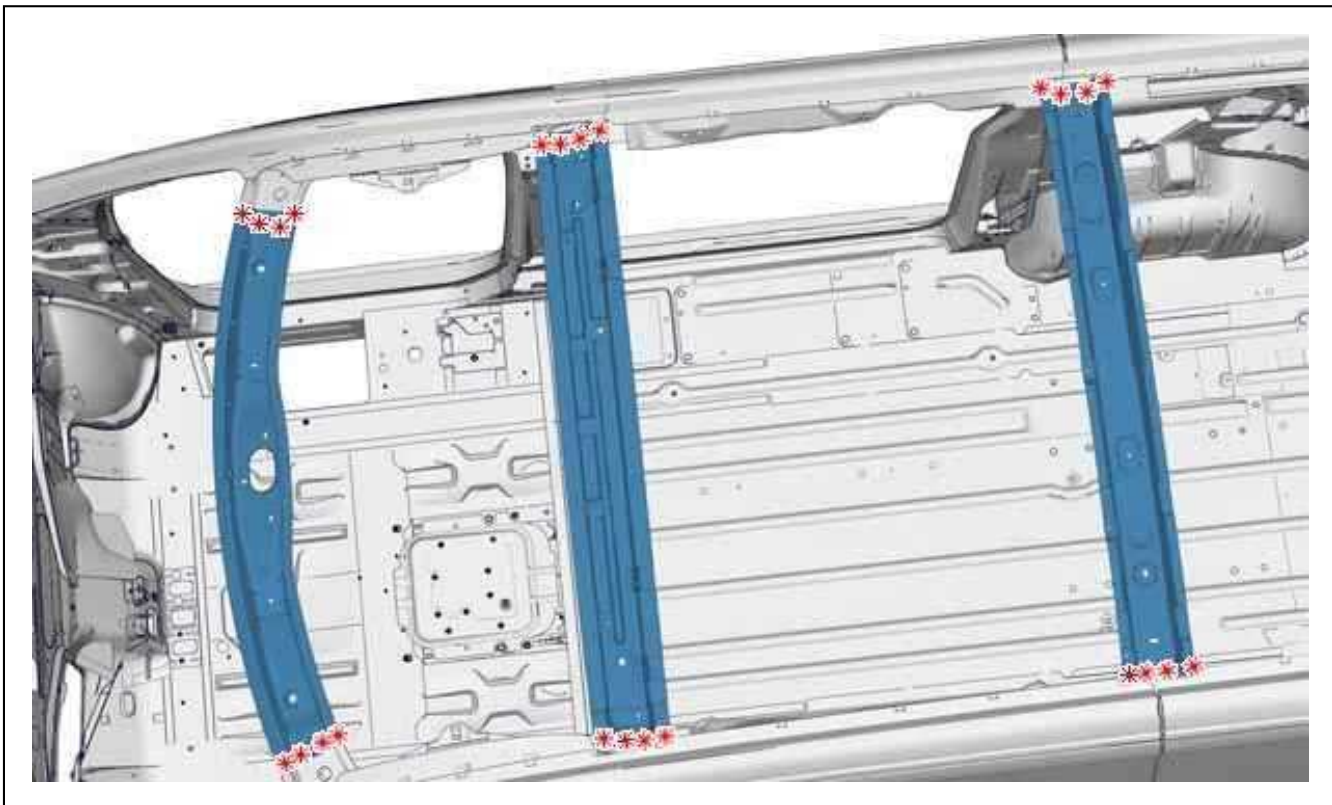


Figure : C4DP0CKD

Cut out the spot welds .

Remove :

- The front roof crossmember
- The roof front bow
- The roof rear bow

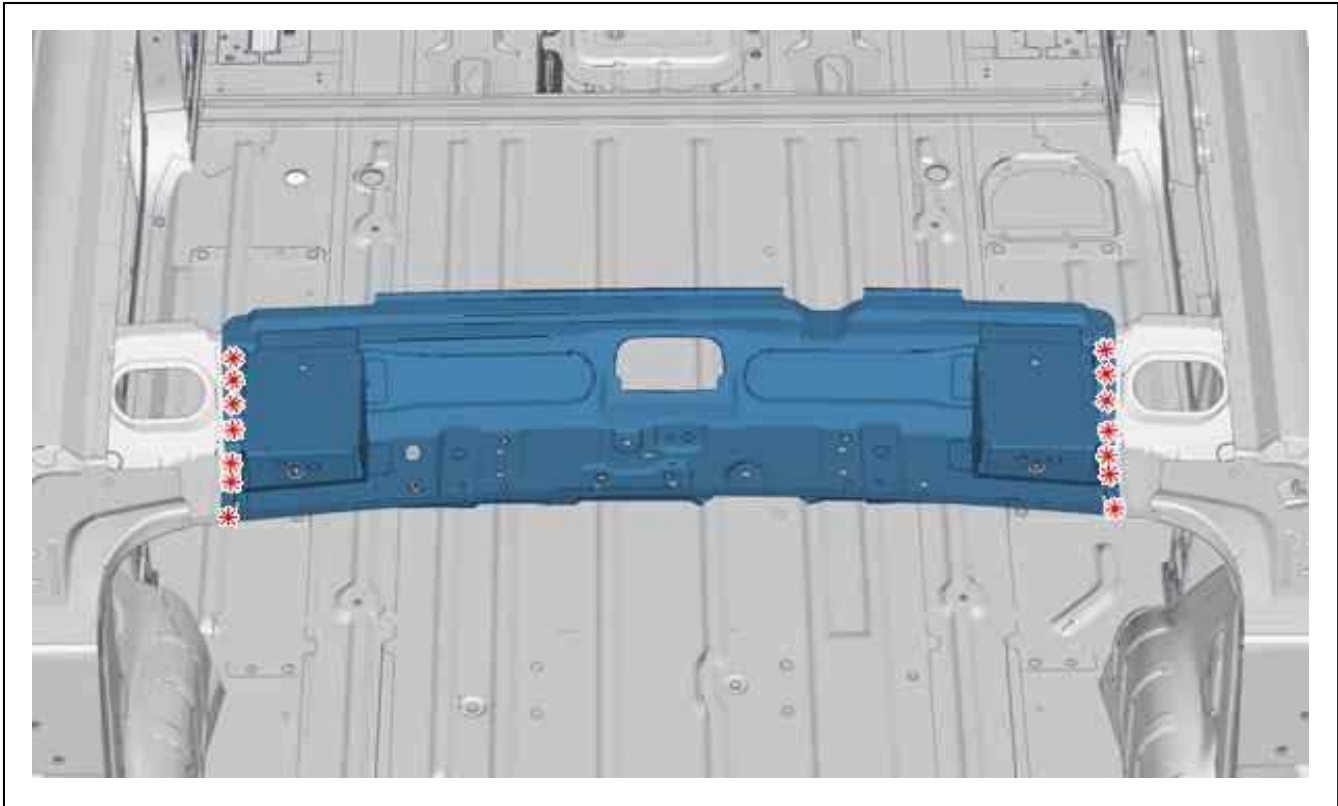


Figure : C4DP0CLD

Cut out the spot welds .

Remove the rear crossmember.

4. Bodywork cleaning and preparation

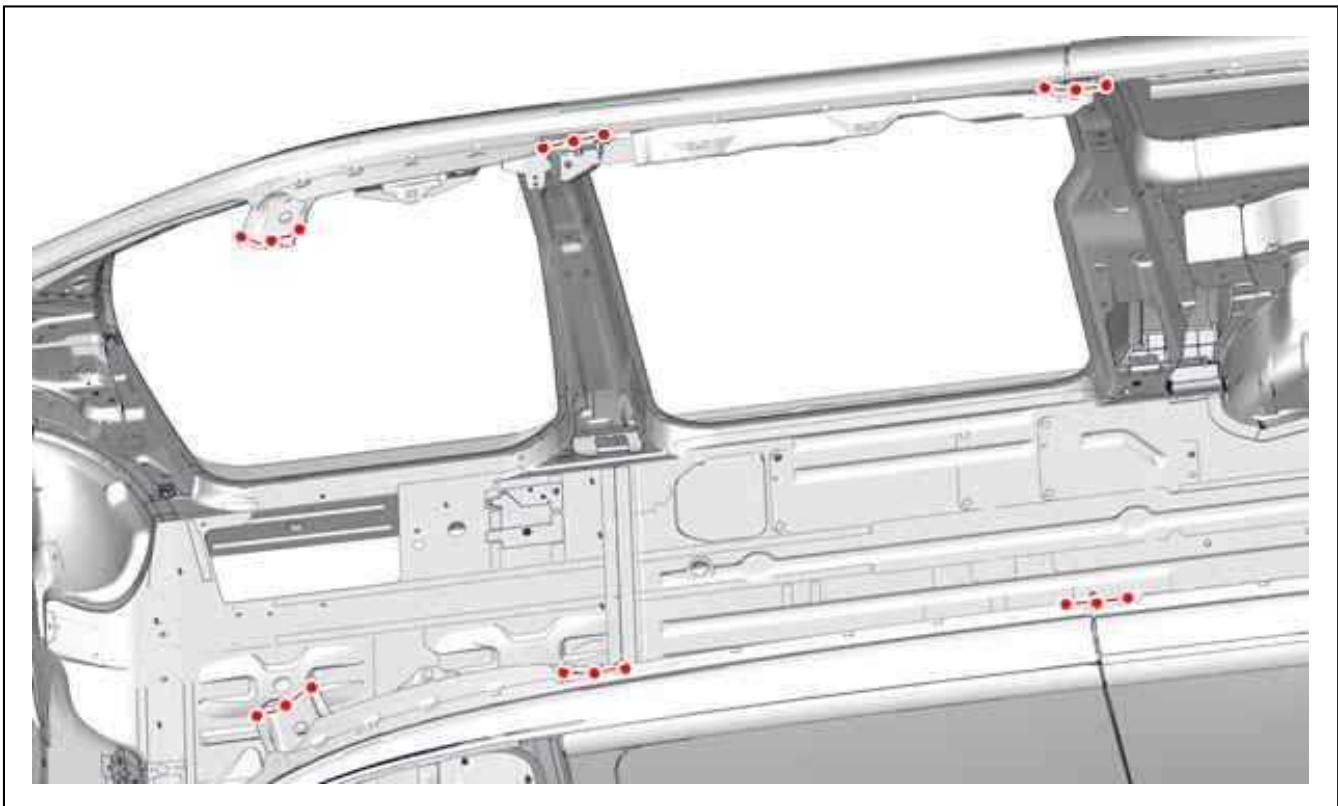


Figure : C4DP0CMD

Prepare the mating edges and protect them using a weldable primer .

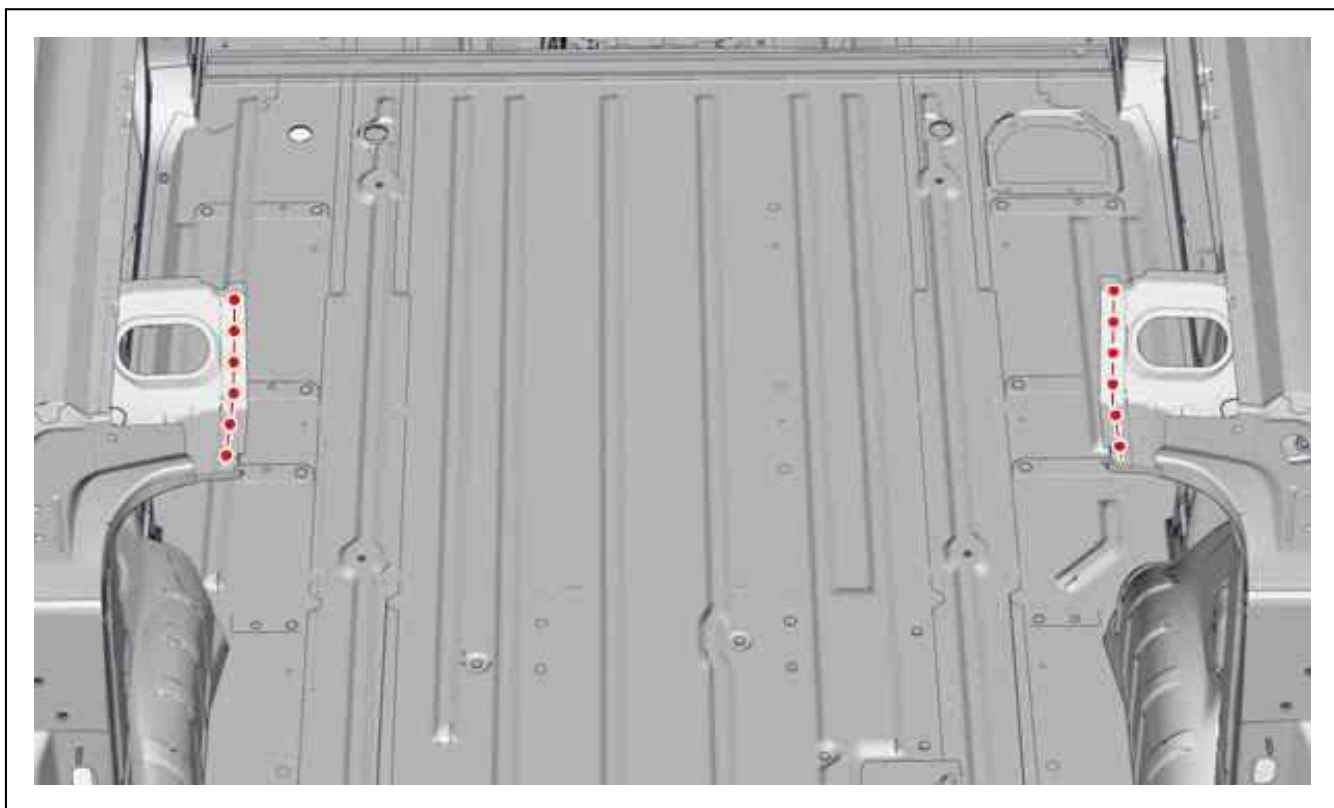


Figure : C4DP0CND

Prepare the mating edges and protect them using a weldable primer .

5. Adjustment

Fit :

- The short roof front crossmember
- The short roof front bow
- The short roof rear bow
- The short roof rear crossmember

Check the fit.

6. Welding

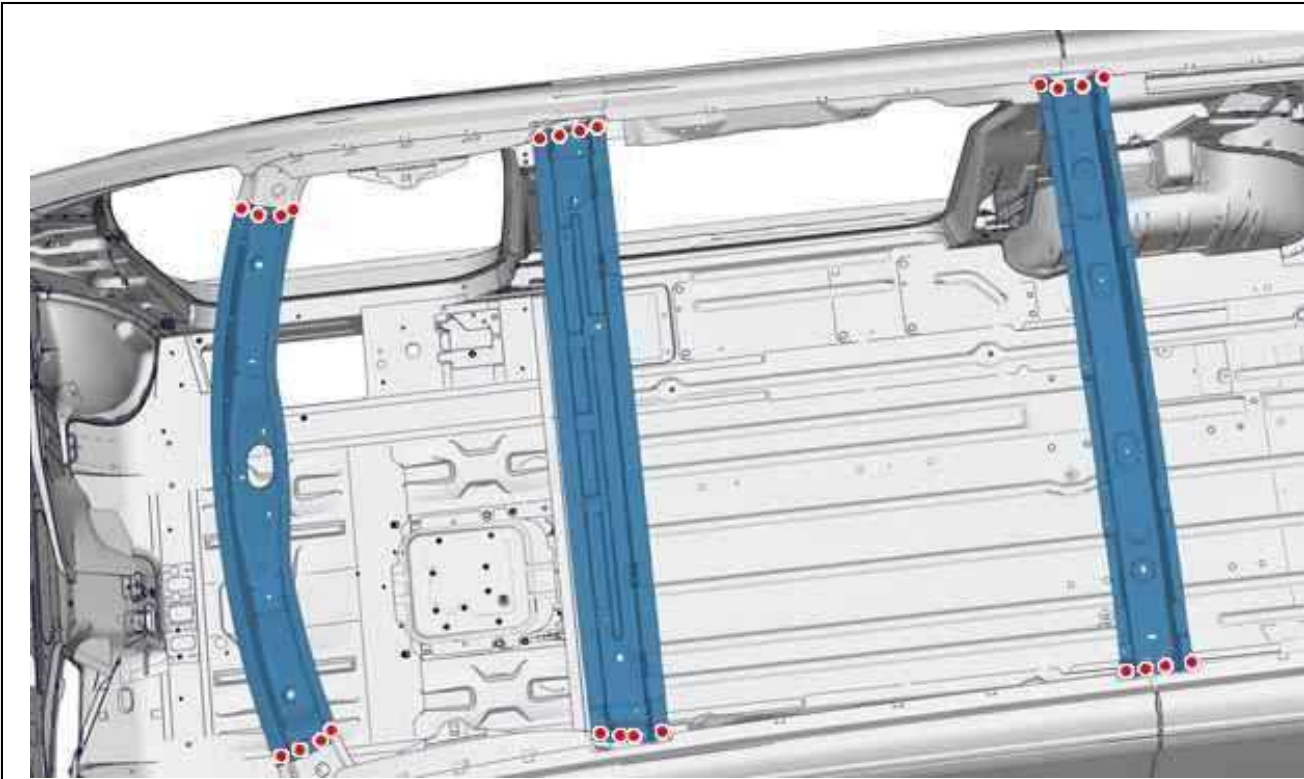


Figure : C4DP0CPD

Weld with electric spot welds ⓘ .

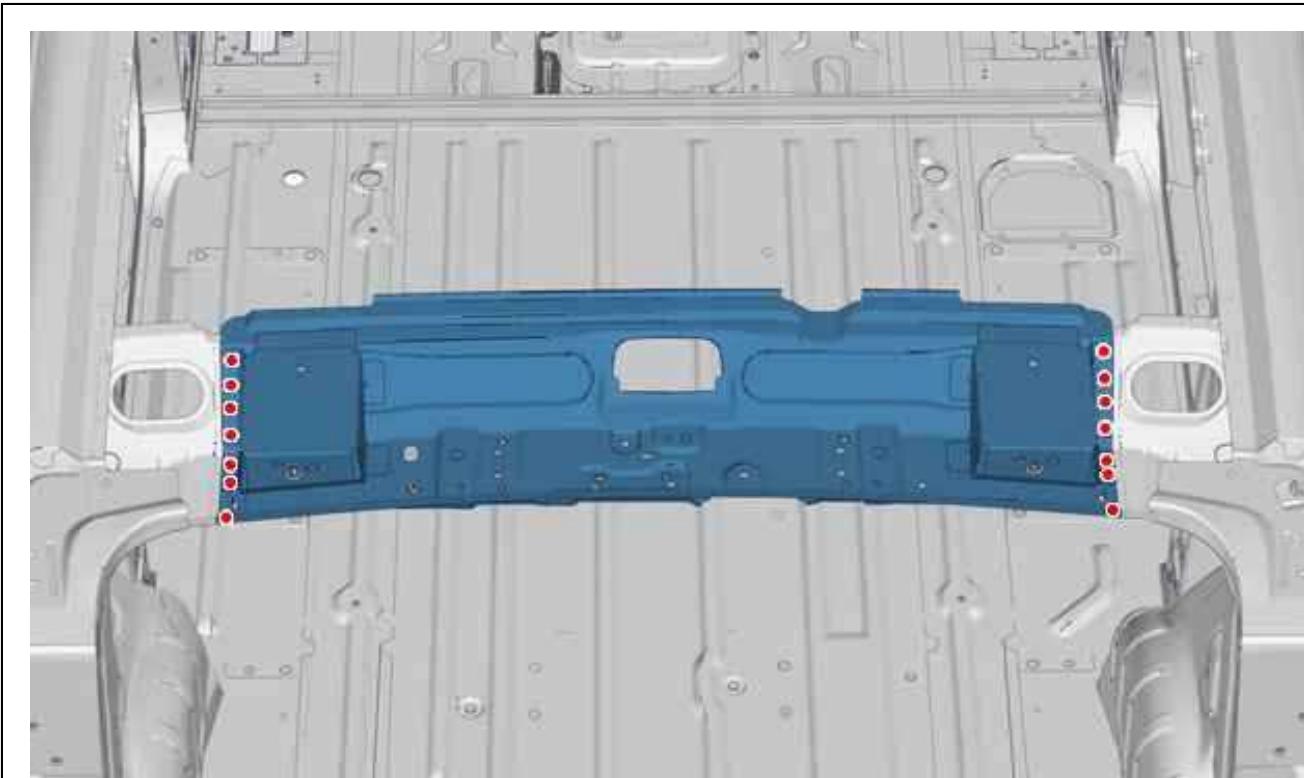


Figure : C4DP0CQD

Weld with electric spot welds ⓘ .

7. Reinitialisation

Carry out the additional operations.

CAUTION : Perform the operations to be carried out following reconnection of the battery  .

REPLACEMENT : LONG ROOF CROSSMEMBERS AND BOWS

ESSENTIAL : Depending on the operation to be carried out, observe the instructions for chocking up the vehicle.

ESSENTIAL : Deactivate the pneumatic suspension before lifting the vehicle ⓘ (2 or 4 post lift, workshop jack or customer's jack ⓘ).

ESSENTIAL : Observe the elementary rules of hygiene and safety (wear a face mask to protect against fumes and vapour - work in a well ventilated space).

CAUTION : All of the stripped surfaces must be protected by means of the approved electrolytic reznicing process .

1. Additional operations

Disconnect the battery.

Release the wiring harnesses.

Protect the interior of the passenger compartment.

Replacement ⓘ : Long roof ⓘ .

2. Identification of the replacement parts

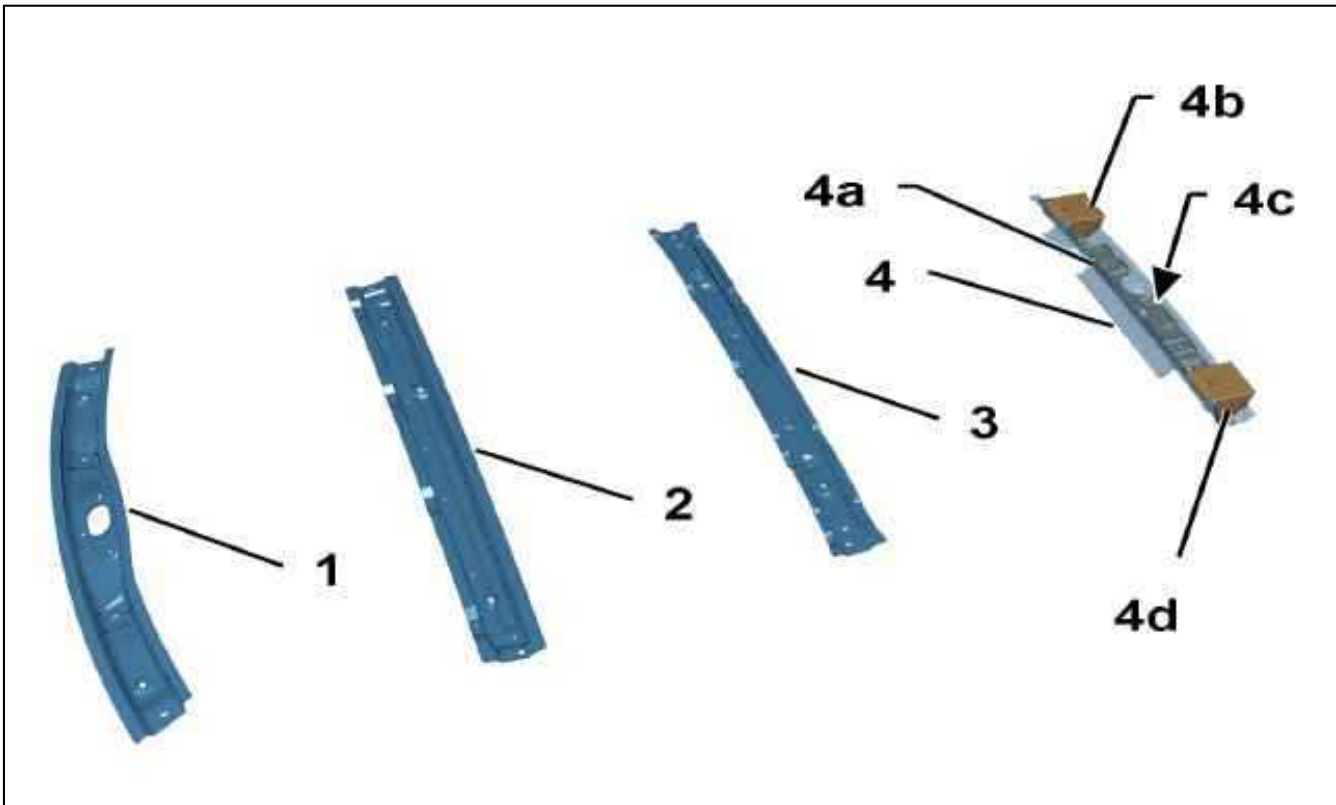


Figure : C4DP0CRD

Reference	Designation	Thickness (mm)	Nature/classification
(1)	Front roof crossmember	0,97	ADX (*)

(2)	Front roof bow	0,97	ADX (*)
(3)	Rear roof member	0,77	ADX (*)
(*) ADX = Mild steel			

(4) Rear cross member assembly			
Reference	Designation	Thickness (mm)	Nature/classification
(4a)	Roof rear crossmember	0,97	ADX (*)
(4b)	Right-hand tailgate hinge strengthener	1,47	High strength (*)
(4c)	Left-hand tailgate hinge strengthener	1,47	High strength (*)
(4d)	Hinged doors striker fixing support	1,95	-
(*) ADX = Mild steel ; (*) High strength = High strength steel			

3. Cutting out

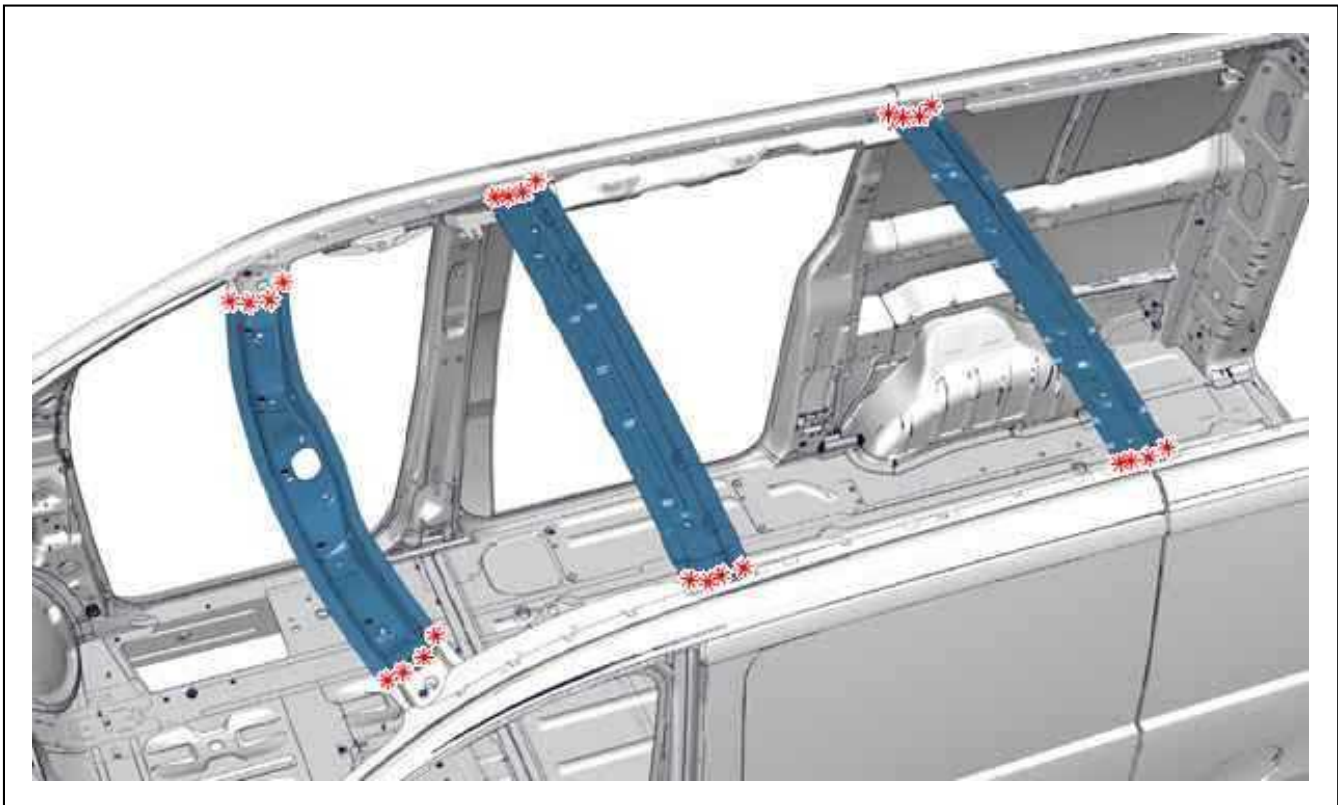


Figure : C4DP0CSD

Cut out the spot welds .

Remove :

- The front roof crossmember
- The roof front bow
- The roof rear bow



Figure : C4DP0CTD

Cut out the spot welds .

Remove the rear crossmember assembly .

4. Bodywork cleaning and preparation

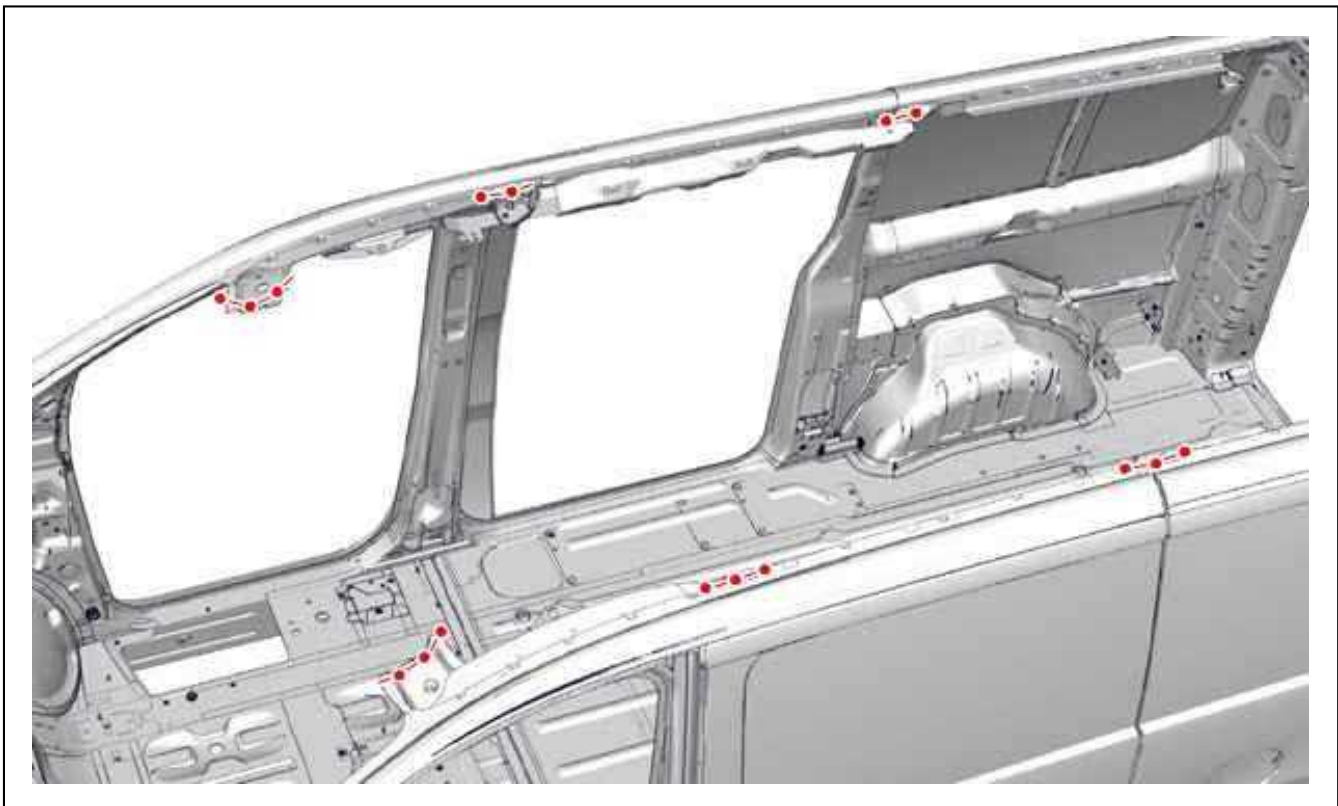


Figure : C4DP0CUD

Prepare the mating edges and protect them using a weldable primer .



Figure : C4DP0CVD

Prepare the mating edges and protect them using a weldable primer .

5. Adjustment

Fit :

- The long roof front crossmember
- The long roof front bow
- The long roof rear bow
- The long roof rear crossmember

Check the fit.

6. Welding

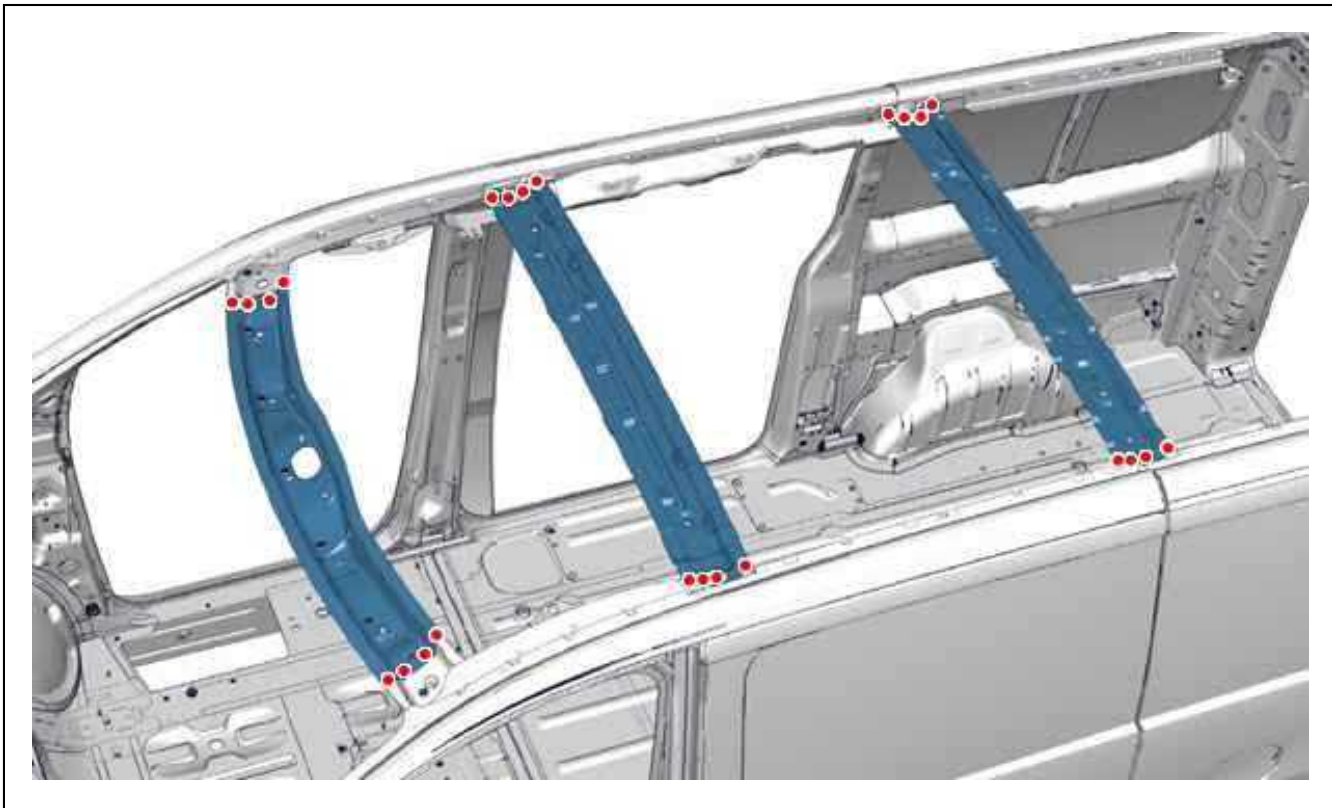


Figure : C4DP0CWD

Weld with electric spot welds ⓘ .

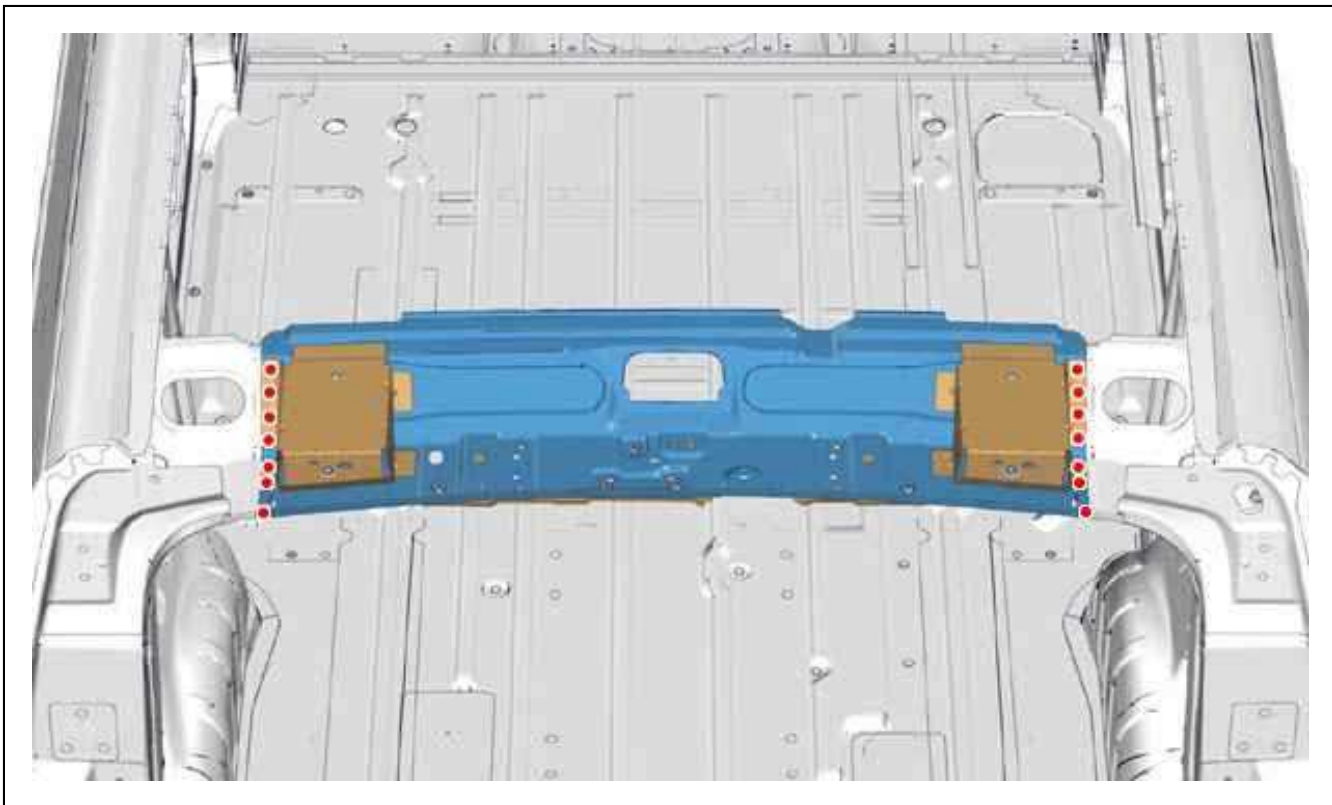


Figure : C4DP0CXD

Weld with electric spot welds ⓘ .

7. Reinitialisation

Carry out the additional operations.

CAUTION : Perform the operations to be carried out following reconnection of the battery  .

REPLACEMENT : SHORT ROOF

ESSENTIAL : Observe the safety and cleanliness recommendations ⓘ .

ESSENTIAL : Depending on the operation to be carried out, observe the instructions for chocking up the vehicle.

ESSENTIAL : Deactivate the pneumatic suspension before lifting the vehicle ⓘ (2 or 4 post lift, workshop jack or customer's jack ⓘ).

CAUTION : All of the stripped surfaces must be protected by means of the approved electrolytic rezincing process .

CAUTION : The number of spot welds necessary for the assembly of a new part must be identical to the number of spot welds fixing the original part.

1. Additional operations

Disconnect the battery.

Remove-refit the following components :

- The windscreen
- The rear doors or the tailgate (according to model)
- The sliding side doors (according to model)

Detrim-trim the following components :

- The front roof panel
- The rear roof panel

Release the wiring harnesses.

Protect the interior of the passenger compartment.

2. Identification of the replacement parts

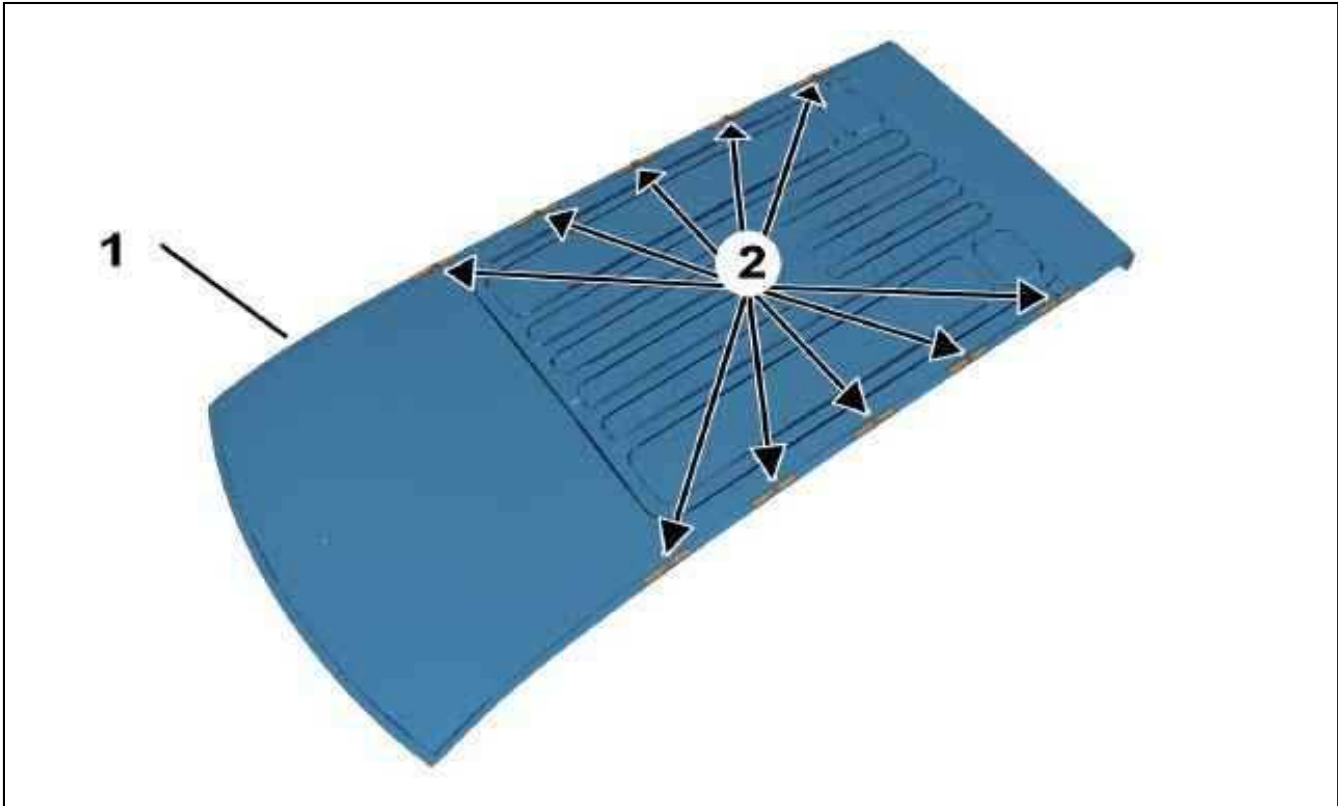


Figure : C4DP0CYD

Reference	Designation	Thickness	Nature/classification
(1)	Short roof	0,77 mm	ADX (*)
(2)	Luggage carrier fixing U bracket	2,44 mm	HLE (**)
(*) ADX : soft steel ; (**) HLE : high-strength steel			

3. Replacement part preparation

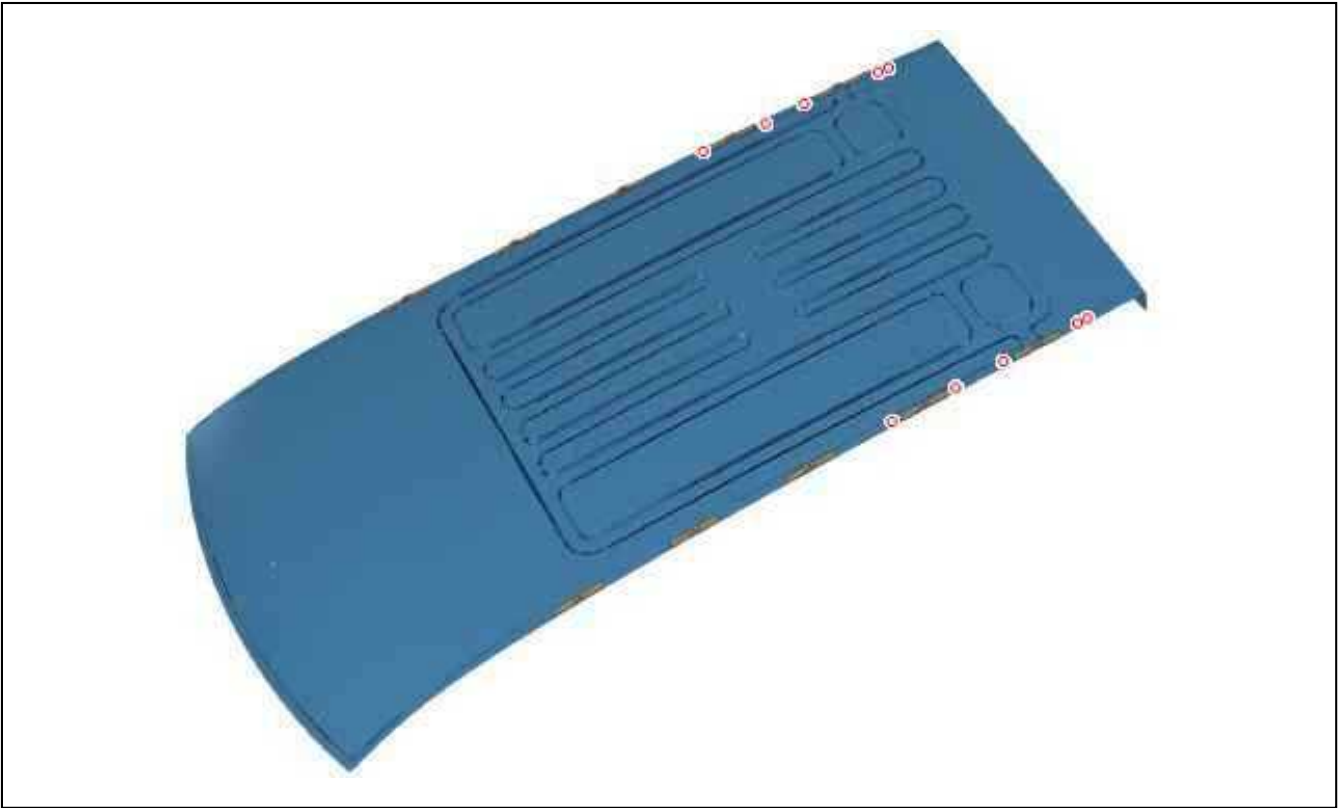


Figure : C4DP0CZD

Drill to a diameter of 6,5 mm for later MAG plug welding.
Prepare the mating edges and protect them using a weldable primer .

4. Cutting out

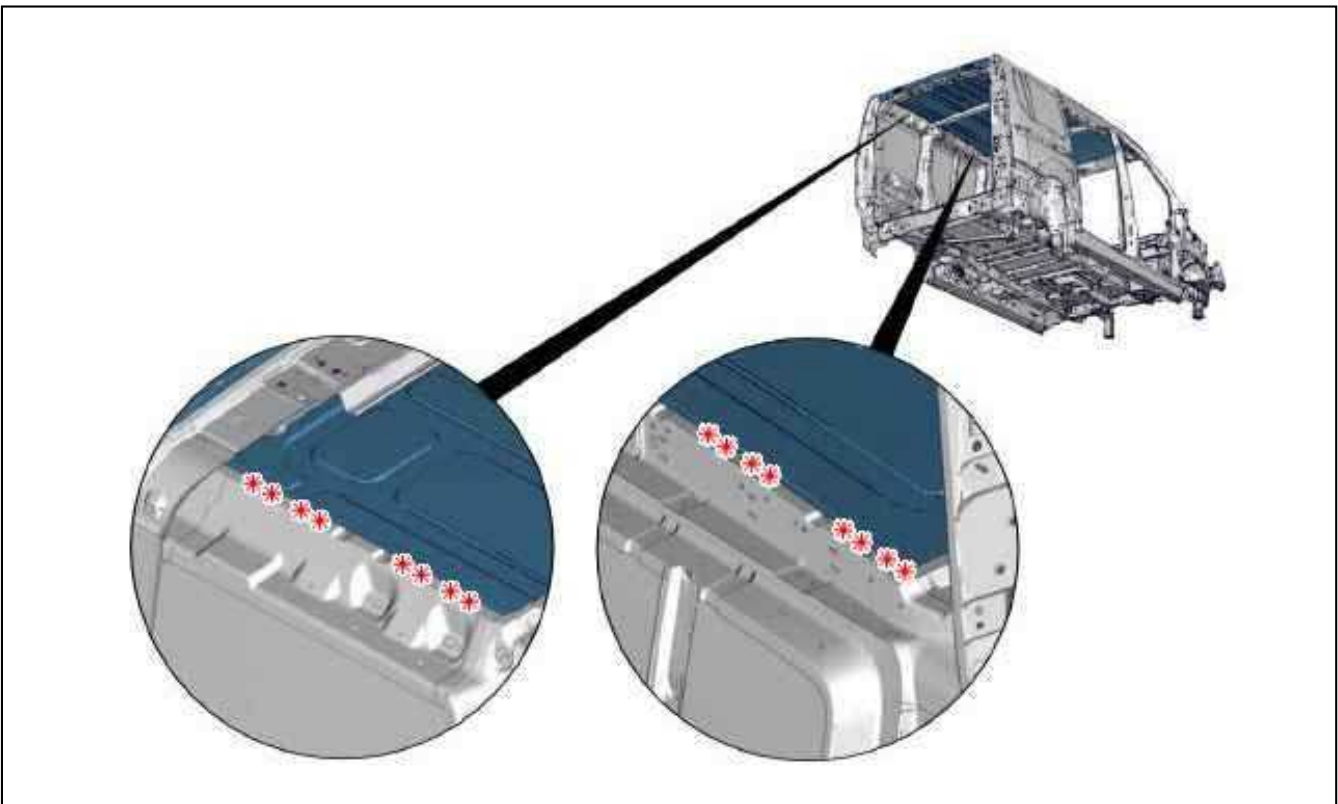


Figure : C4EP19VD

Cut out the spot welds (Symmetrical operation).

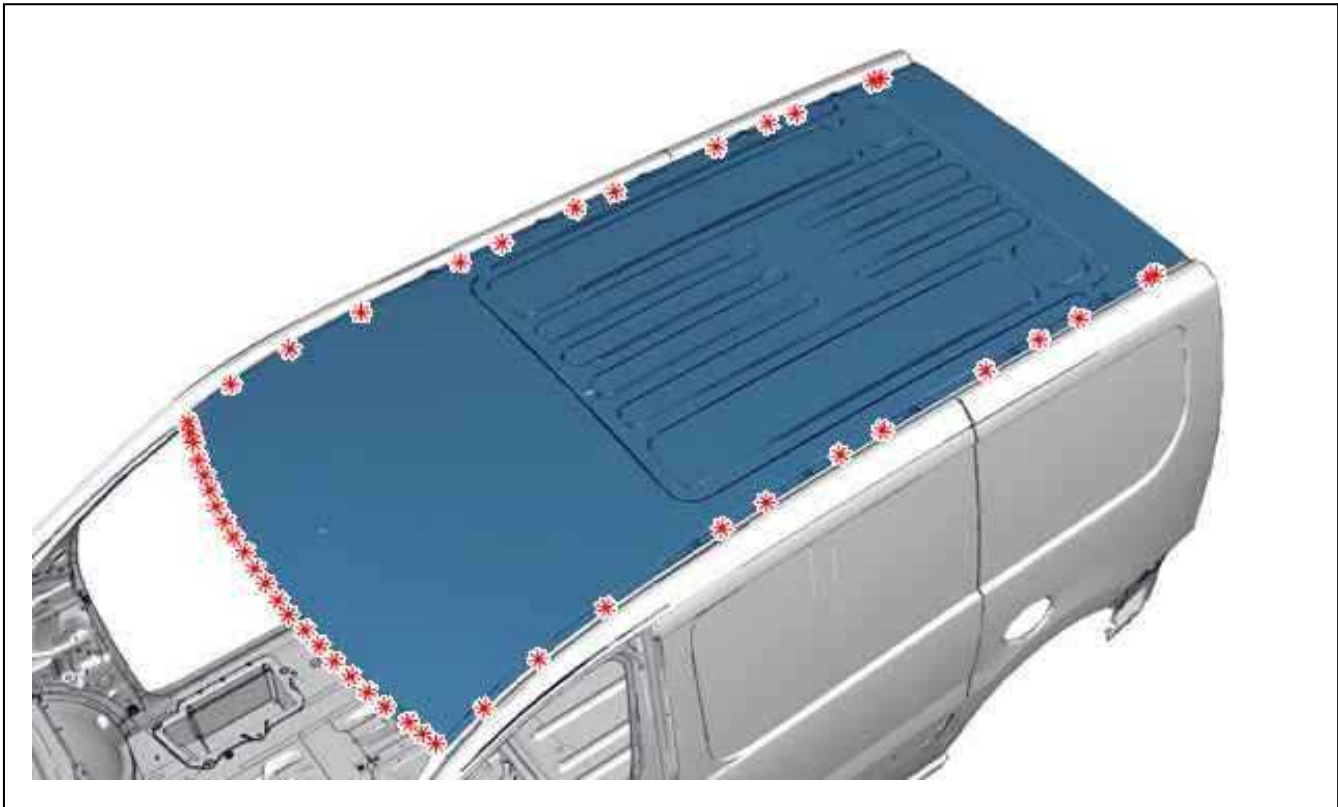


Figure : C4DP0D0D

Cut out the spot welds .

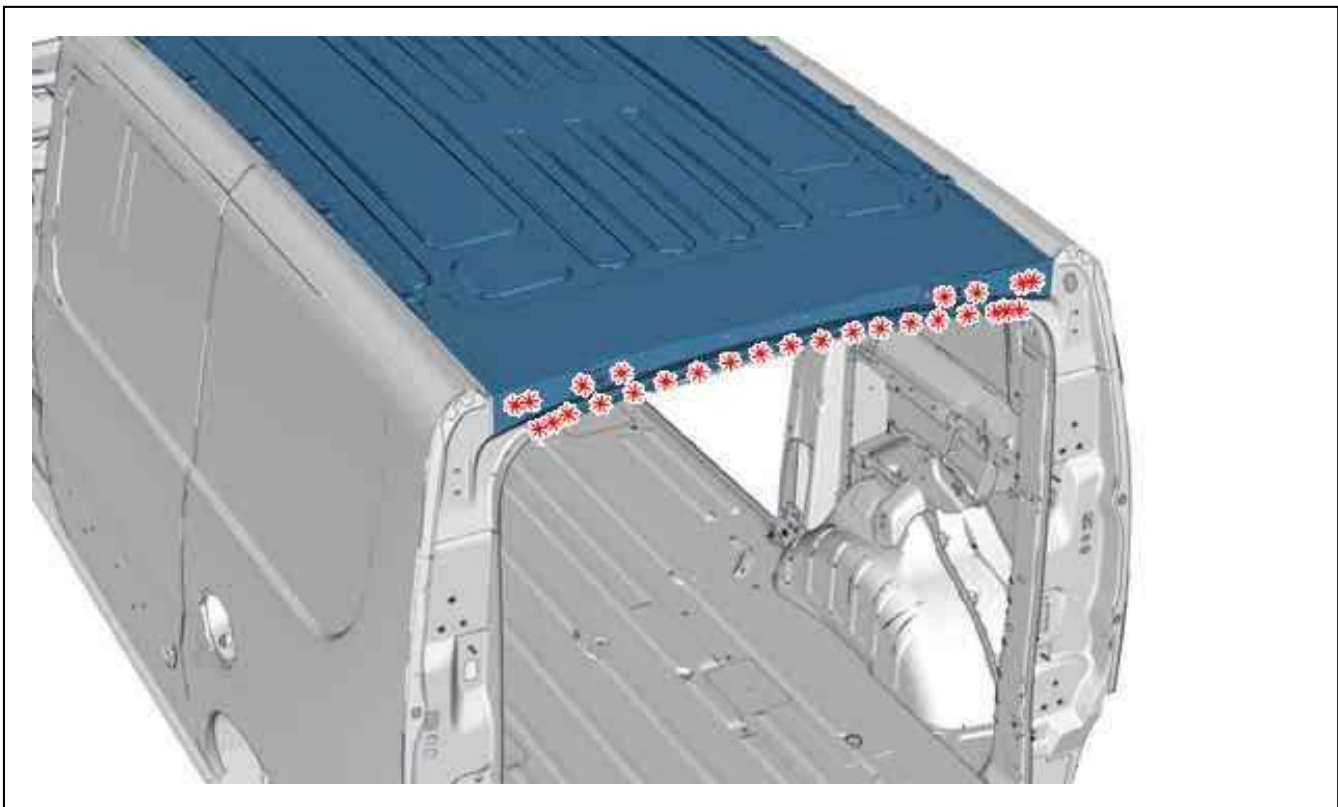


Figure : C4DP0D1D

Cut out the spot welds .
Remove the short roof .

5. Bodywork cleaning and preparation

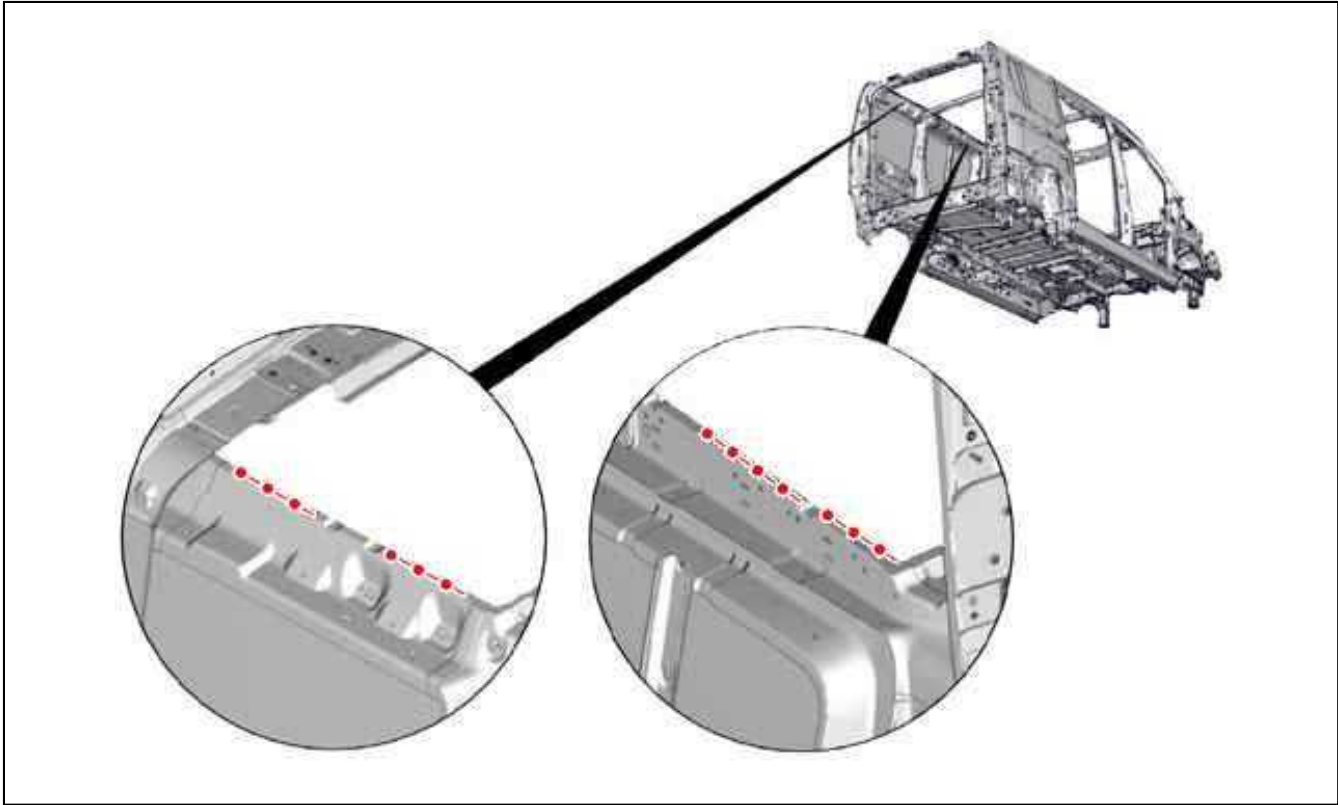


Figure : C4EP19WD

Prepare the mating edges and protect them using a weldable primer (Symmetrical operation).

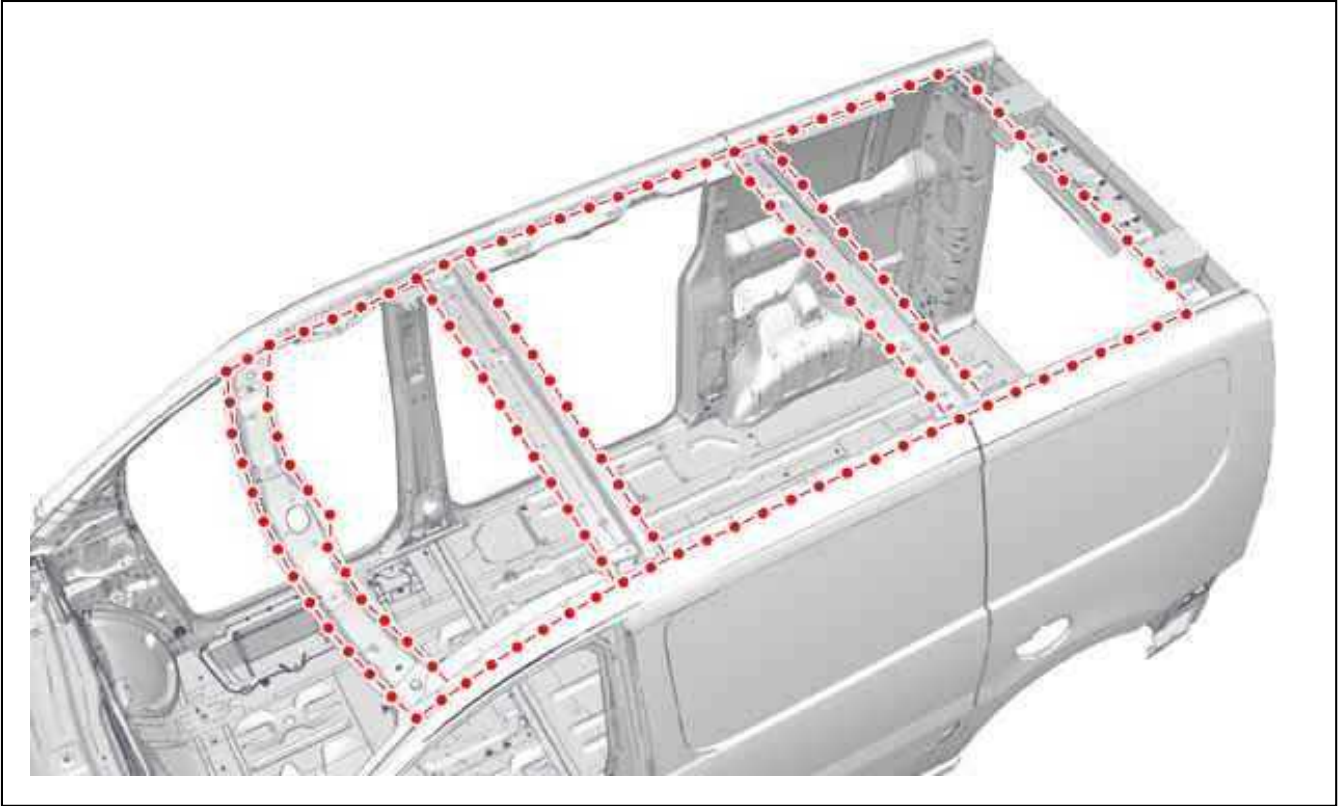


Figure : C4DP0D2D

Prepare the mating edges and protect them using a weldable primer .

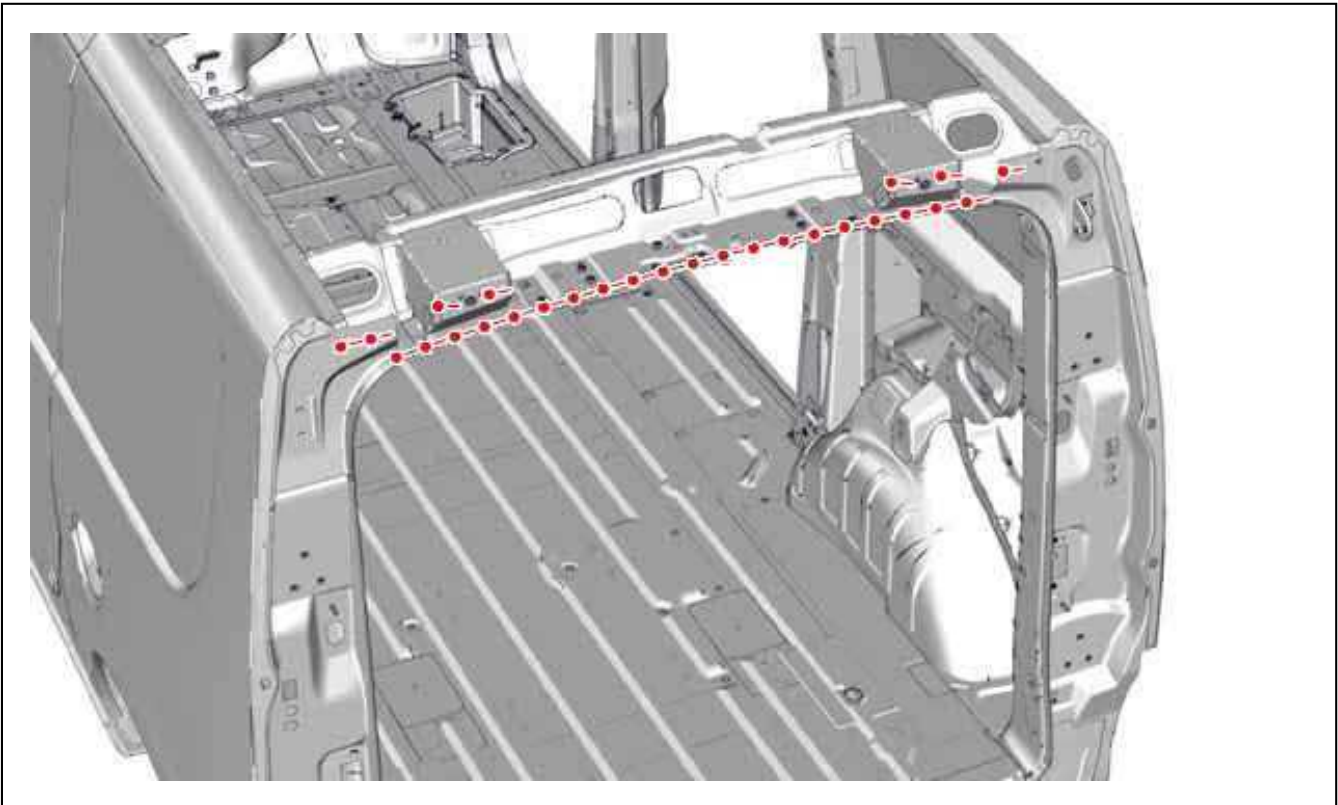


Figure : C4BP224D

Prepare the mating edges and protect them using a weldable primer .

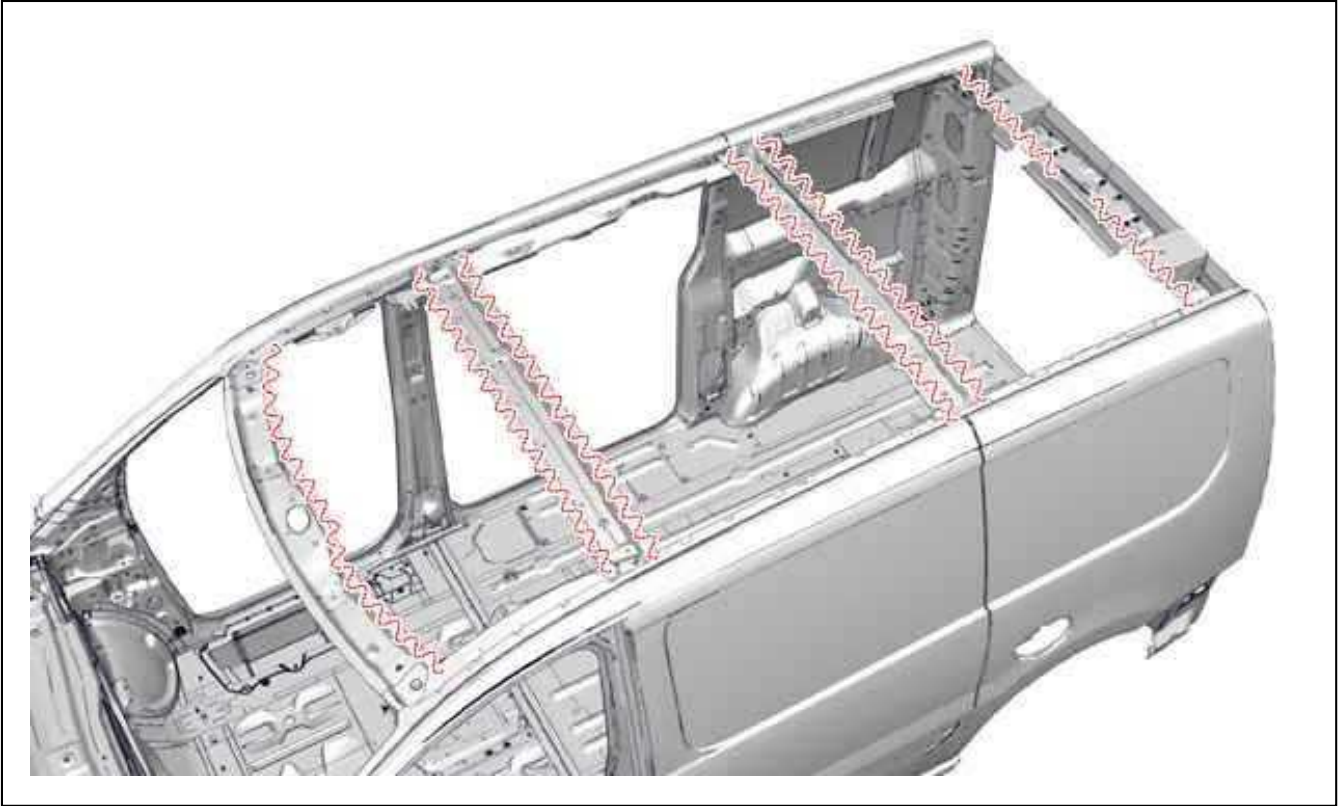


Figure : C4DP0D3D

Apply a filling adhesive "B5".

6. Adjustment

Fit the short roof .
Check the fit.

7. Welding

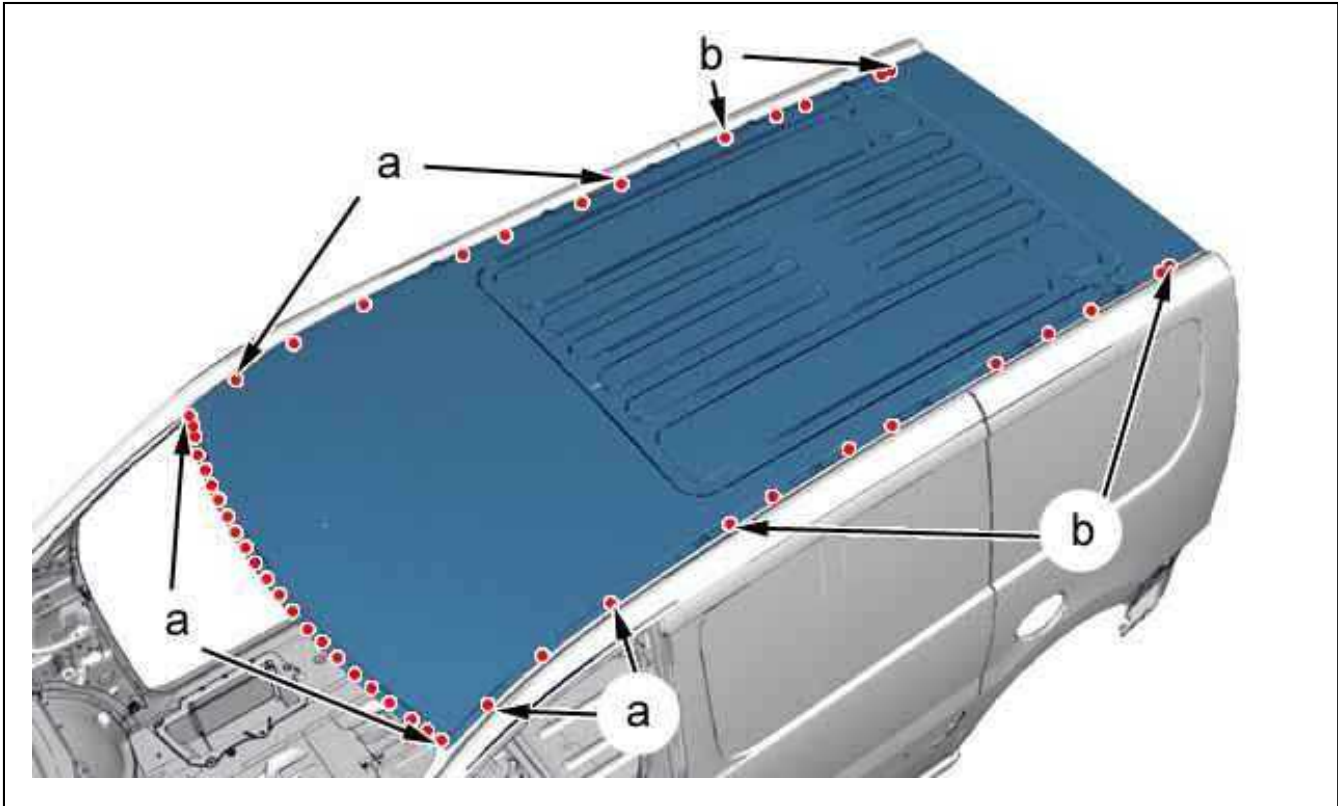


Figure : C4DP0D4D

Weld with electric spot welds (at "a").
 Weld with MAG plug welds (at "b").
 Grind the MAG plug welds.

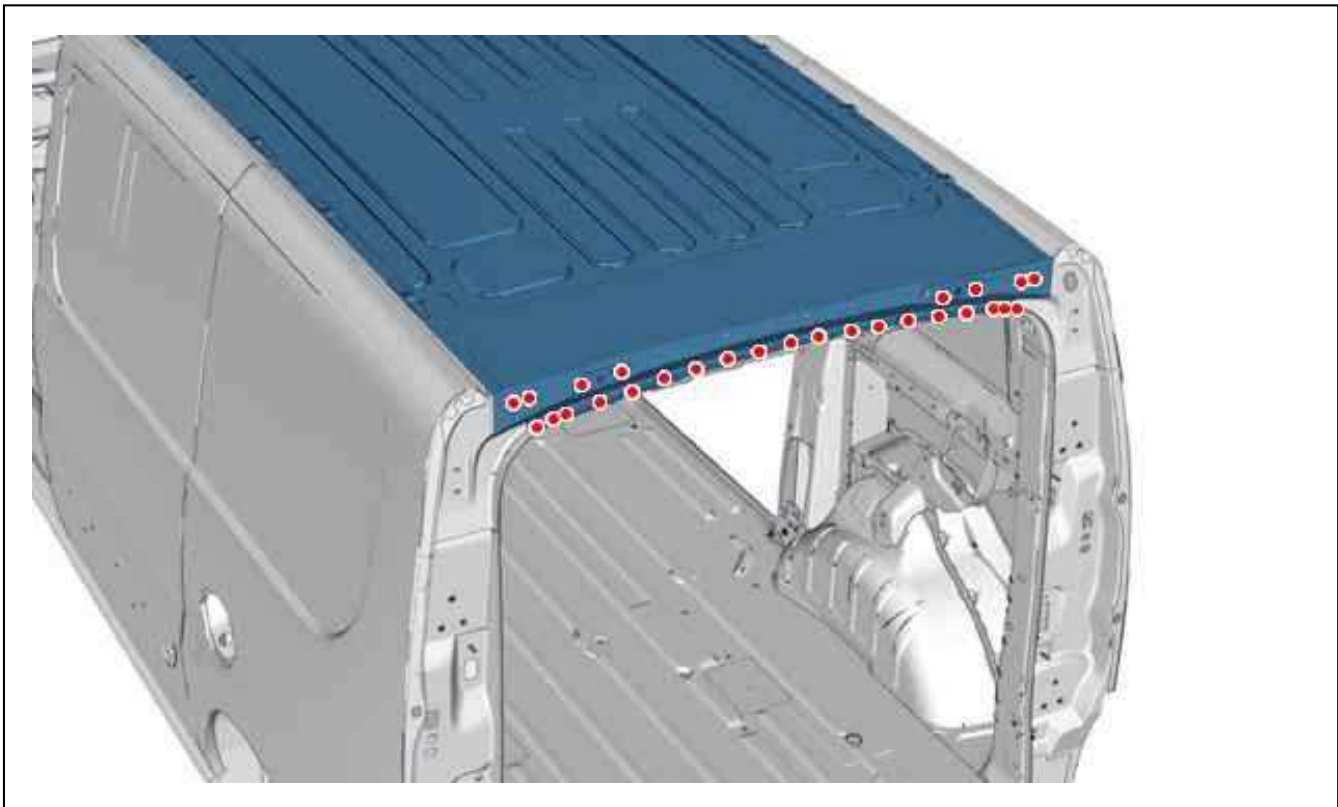


Figure : C4DP0D5D

Weld with electric spot welds.

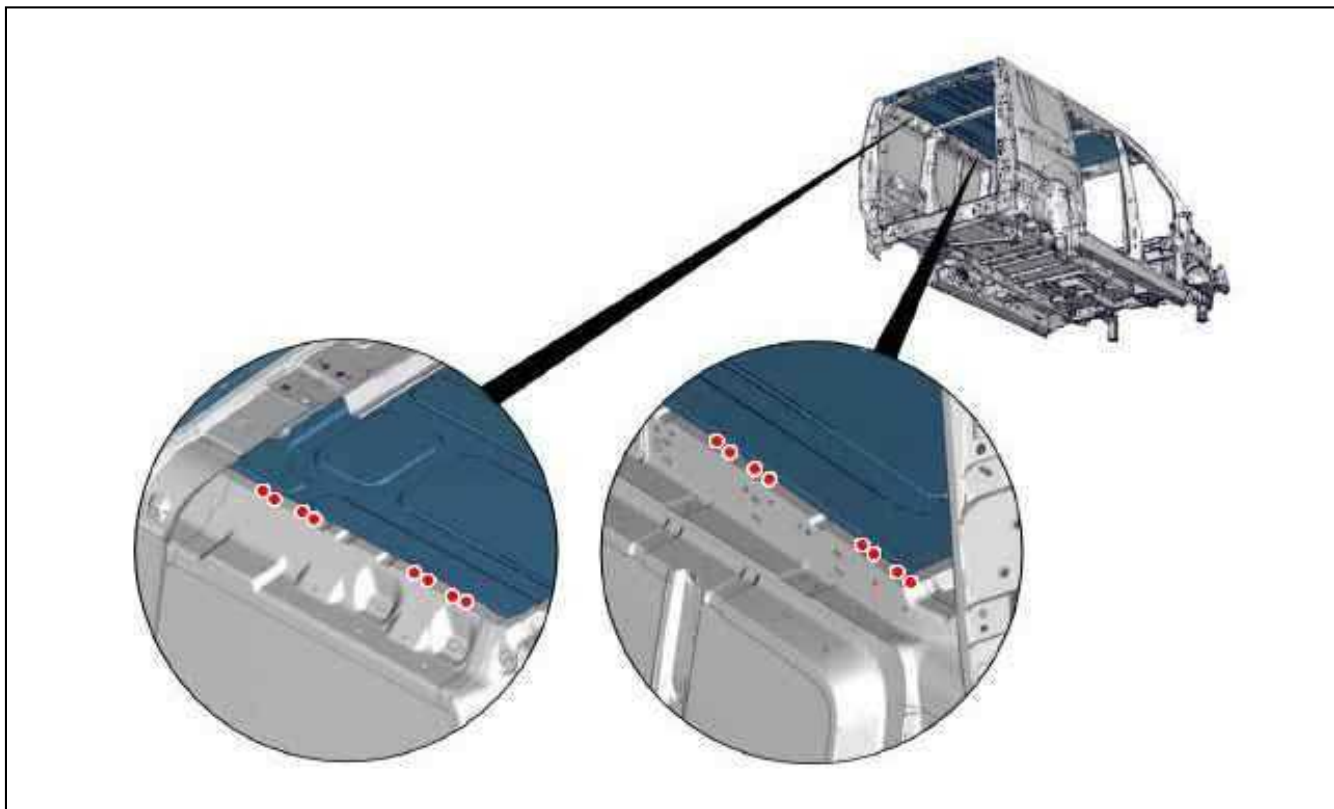


Figure : C4EP19XD

Weld with MAG plug welds (Symmetrical operation).

8. Sealing protection

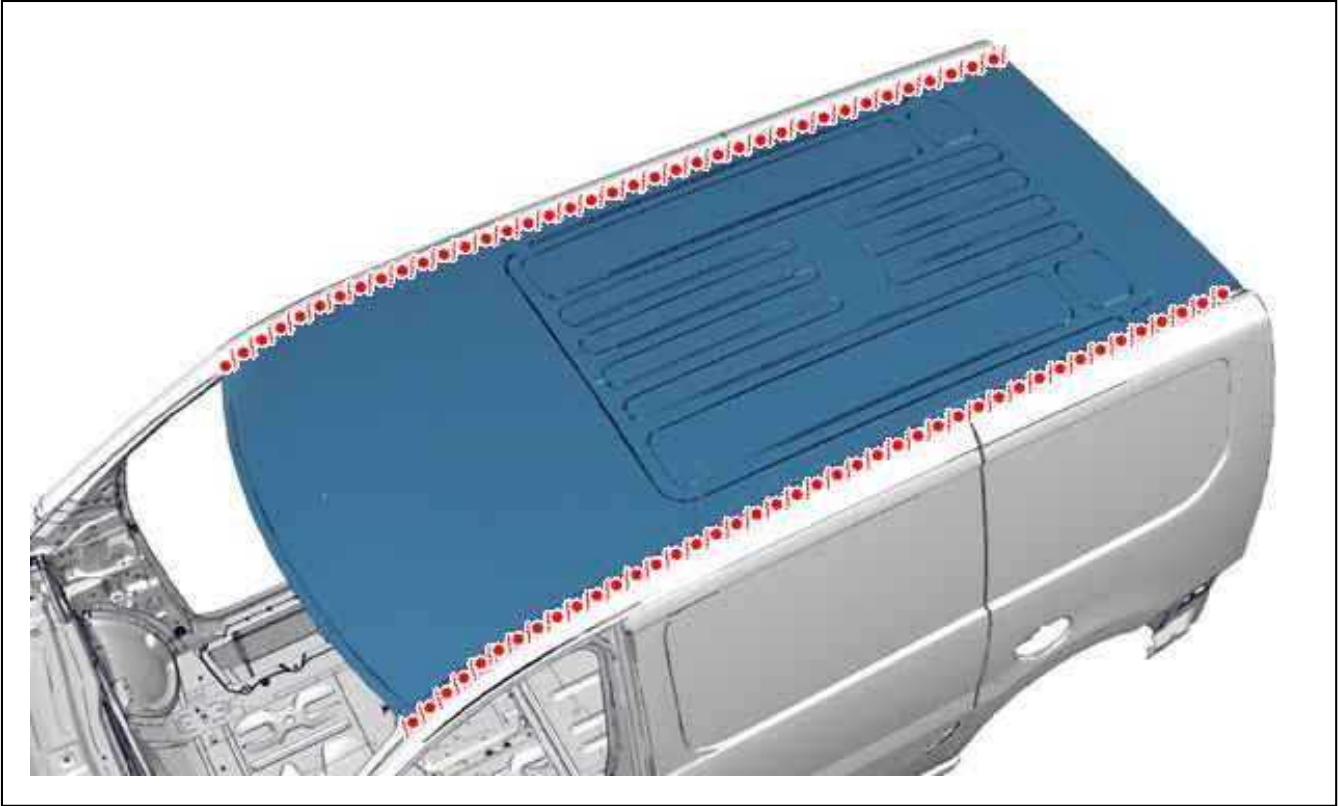


Figure : C4DP0D6D

Apply a phosphate-print layer to the zones laid bare.

Apply a sealing mastic of type "A1".

Paint then spray into the hollow sections, product index C5, in the repair zone.

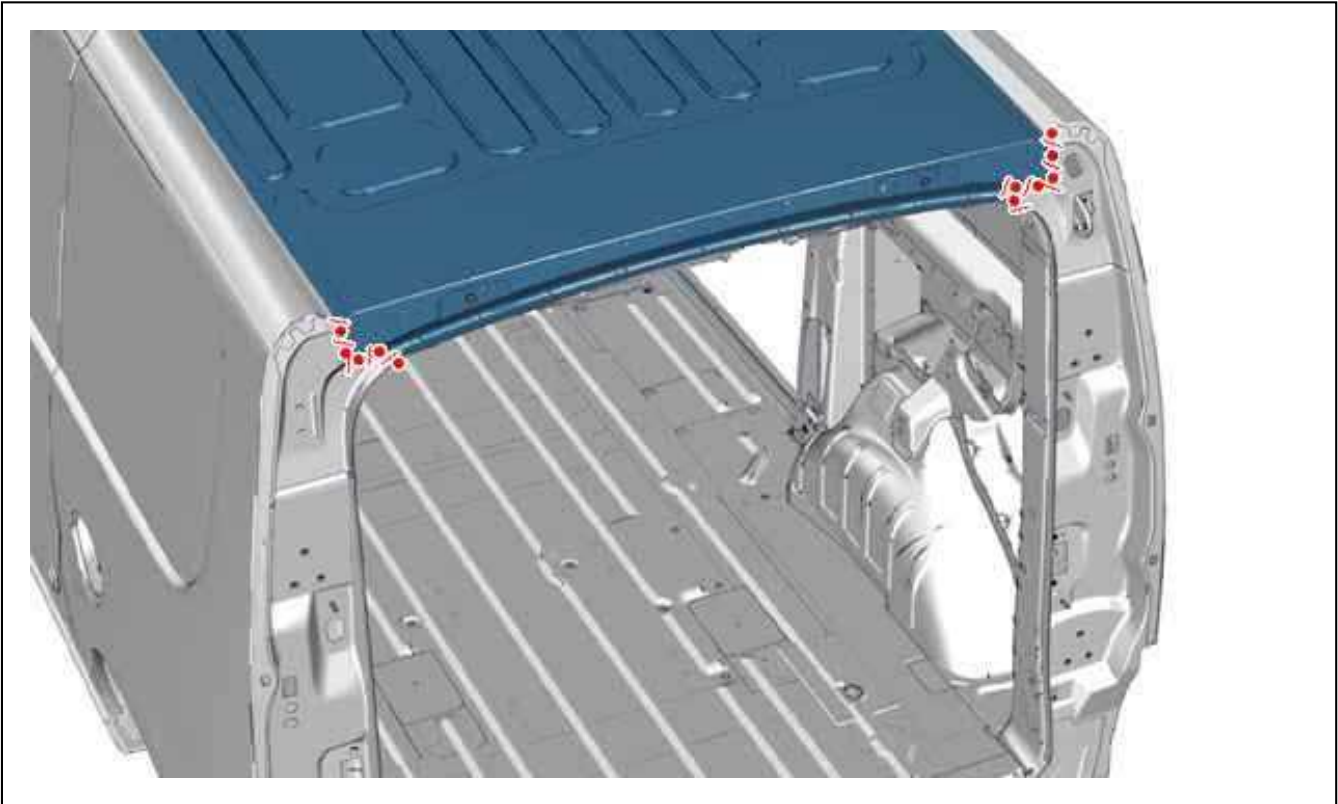


Figure : C4BP225D

Apply a phosphate-print layer to the zones laid bare.

Apply a sealing mastic of type "A4".

Paint then spray into the hollow sections, product index C5, in the repair zone.

9. Reinitialisation

Carry out the additional operations.

CAUTION : Perform the operations to be carried out following reconnection of the battery ⓘ .

REPLACEMENT : HIGH VERSION CAB ROOF

ESSENTIAL : Depending on the operation to be carried out, observe the instructions for chocking up the vehicle.

ESSENTIAL : Deactivate the pneumatic suspension before lifting the vehicle ⓘ (2 or 4 post lift, workshop jack or customer's jack ⓘ).

ESSENTIAL : Observe the elementary rules of hygiene and safety (wear a face mask to protect against fumes and vapour - work in a well ventilated space).

CAUTION : All of the stripped surfaces must be protected by means of the approved electrolytic rezing process .

1. Additional operations

Disconnect the battery.

Detrim-retrim : The high version front roof .

Release the wiring harnesses.

Protect the interior of the passenger compartment.

Replacement ⓘ : **High version roof** ⓘ .

2. Identification of the replacement parts

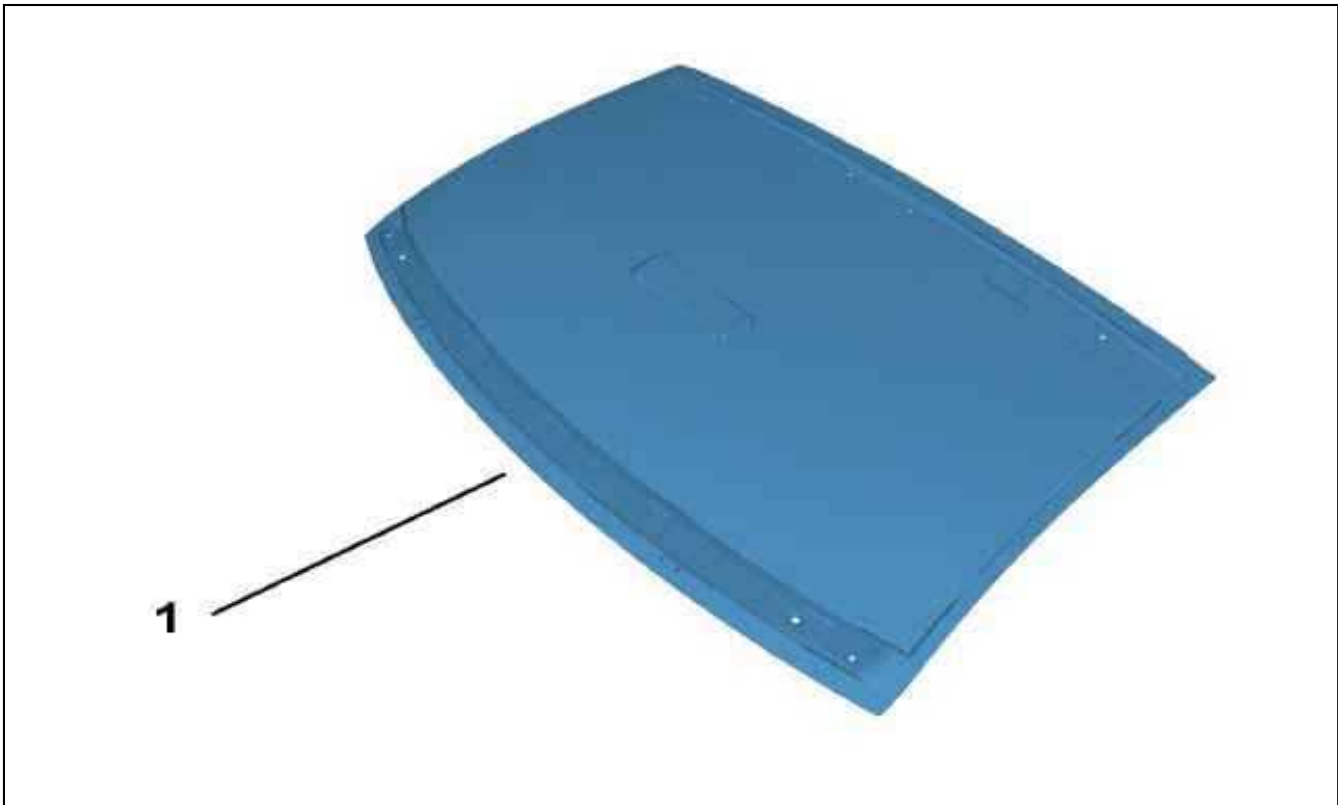


Figure : C4DP0D7D

Reference	Designation	Thickness (mm)	Nature/classification
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(1)	High version cab roof	0,77	ADX (*)
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(*) ADX : Mild steel.

3. Cutting out

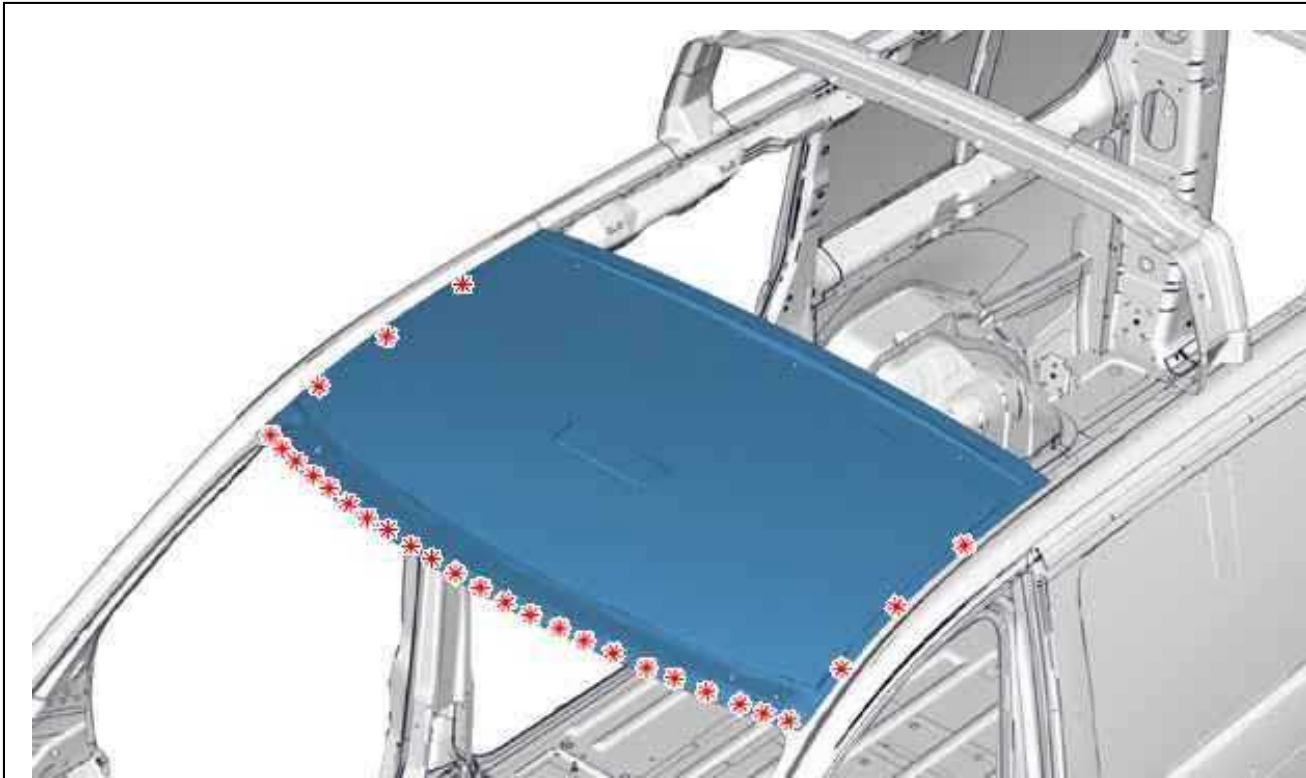


Figure : C4DP0D8D

Cut out the spot welds .

Remove the high version cab roof .

4. Bodywork cleaning and preparation

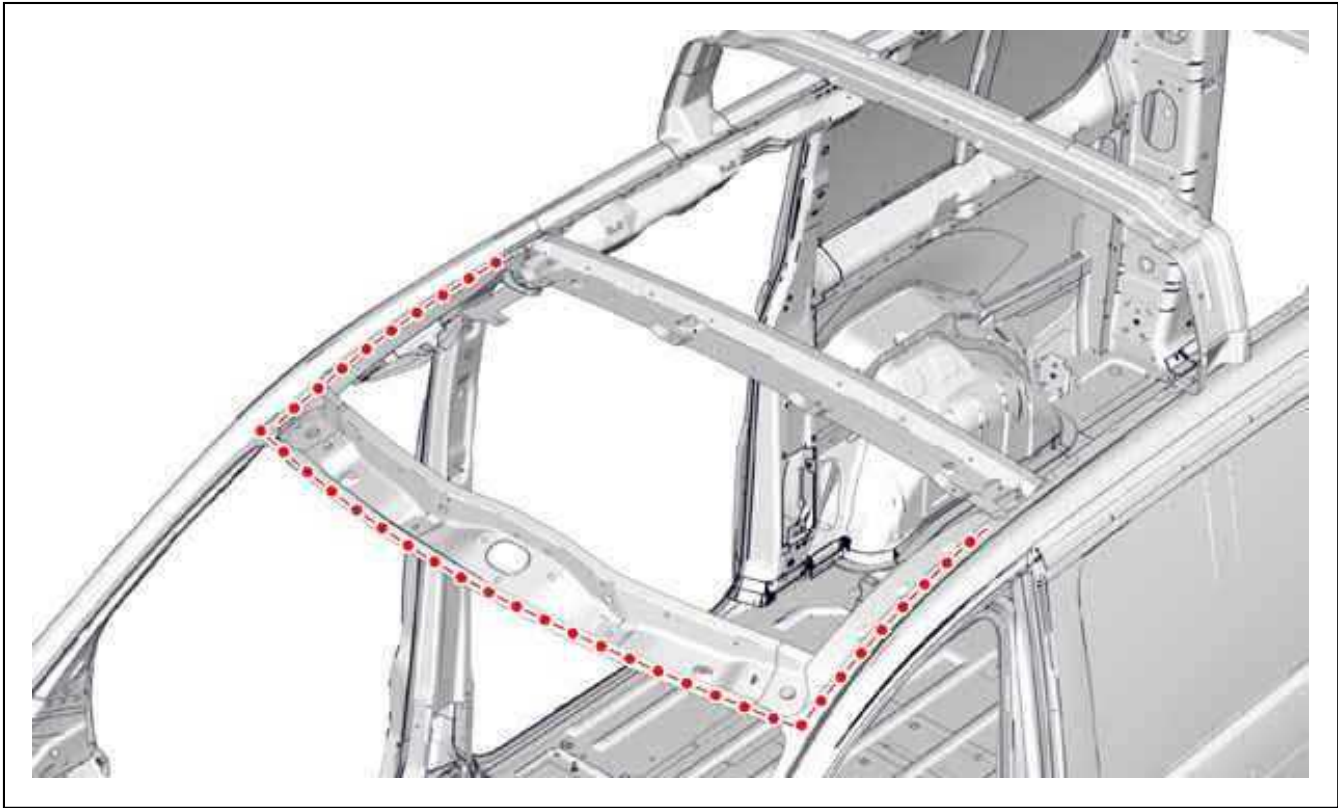


Figure : C4DP0D9D

Prepare the mating edges and protect them using a weldable primer .

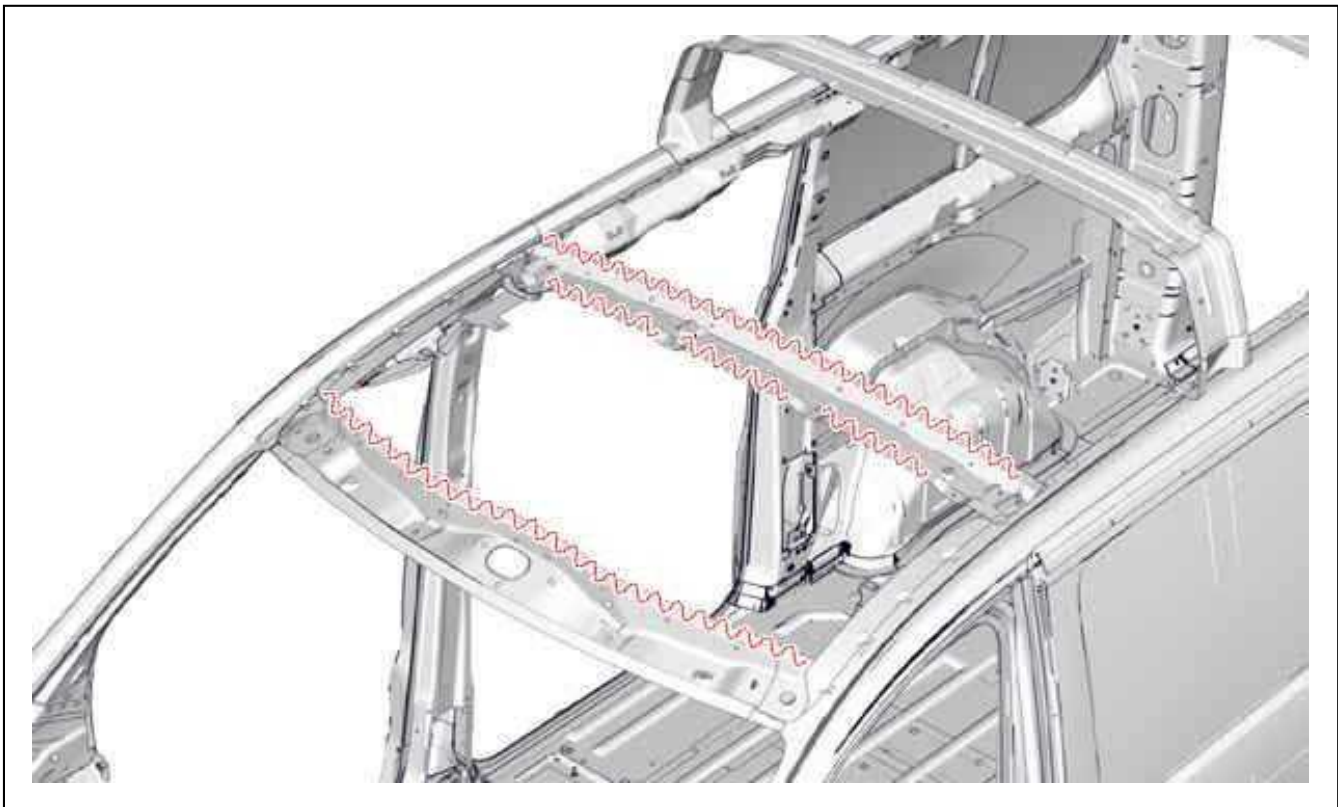


Figure : C4DP0DAD

Apply a filling adhesive "B5".

5. Adjustment

Fit the high version cab roof .
Check the fit.

6. Welding

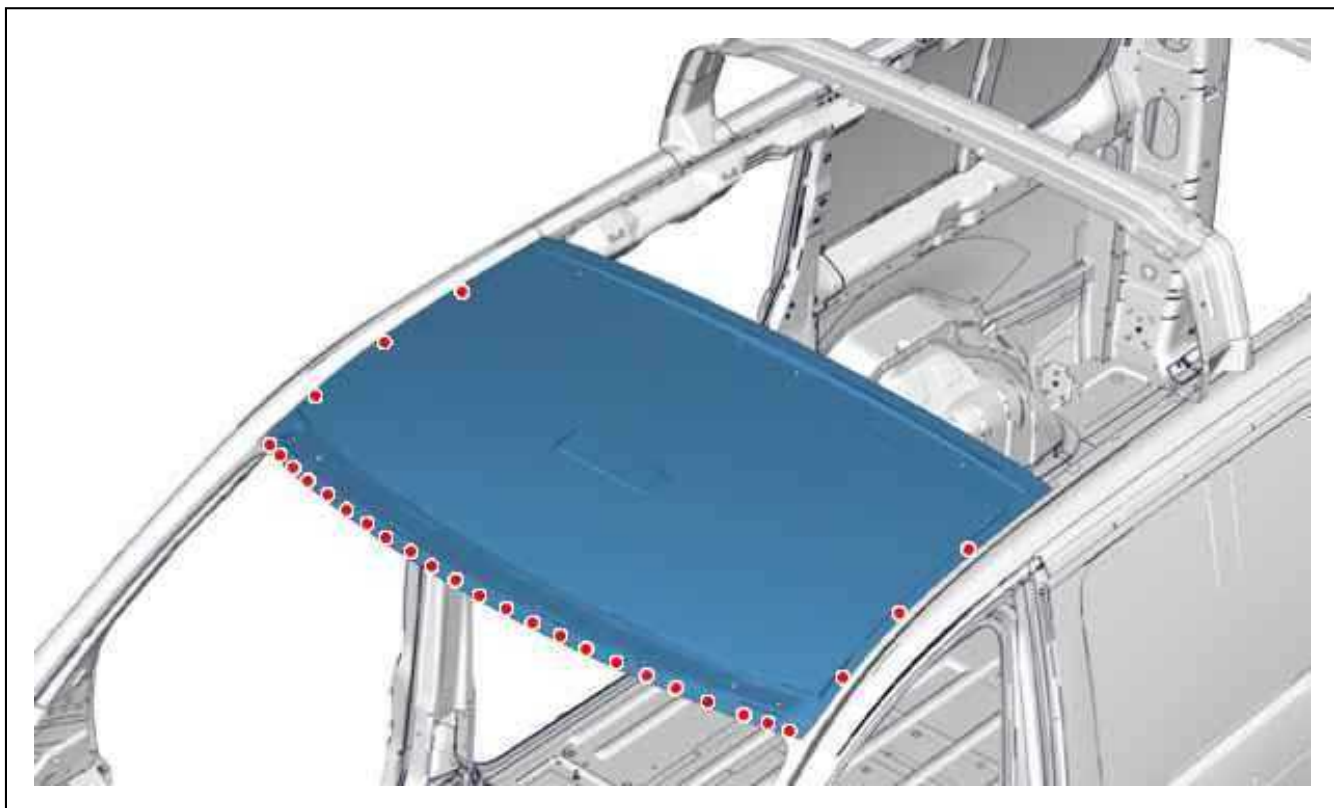


Figure : C4DP0DBD

Weld with electric spot welds ⓘ .

7. Sealing protection

Apply a phosphate-print layer to the zones laid bare.

8. Reinitialisation

Carry out the additional operations.

CAUTION : Perform the operations to be carried out following reconnection of the battery ⓘ .

REPLACEMENT : LONG ROOF

ESSENTIAL : Depending on the operation to be carried out, observe the instructions for chocking up the vehicle.

ESSENTIAL : Deactivate the pneumatic suspension before lifting the vehicle ⓘ (2 or 4 post lift, workshop jack or customer's jack ⓘ).

ESSENTIAL : Observe the elementary rules of hygiene and safety (wear a face mask to protect against fumes and vapour - work in a well ventilated space).

CAUTION : All of the stripped surfaces must be protected by means of the approved electrolytic rezincing process .

1. Additional operations

Disconnect the battery.

Remove-refit the following components :

- The windscreen
- The hinged rear doors or the tailgate (according to model)
- The sliding side doors (according to model)

Detrim-trim the following components :

- The front roof panel
- The rear roof panel

Release the wiring harnesses.

Protect the interior of the passenger compartment.

2. Identification of the replacement parts

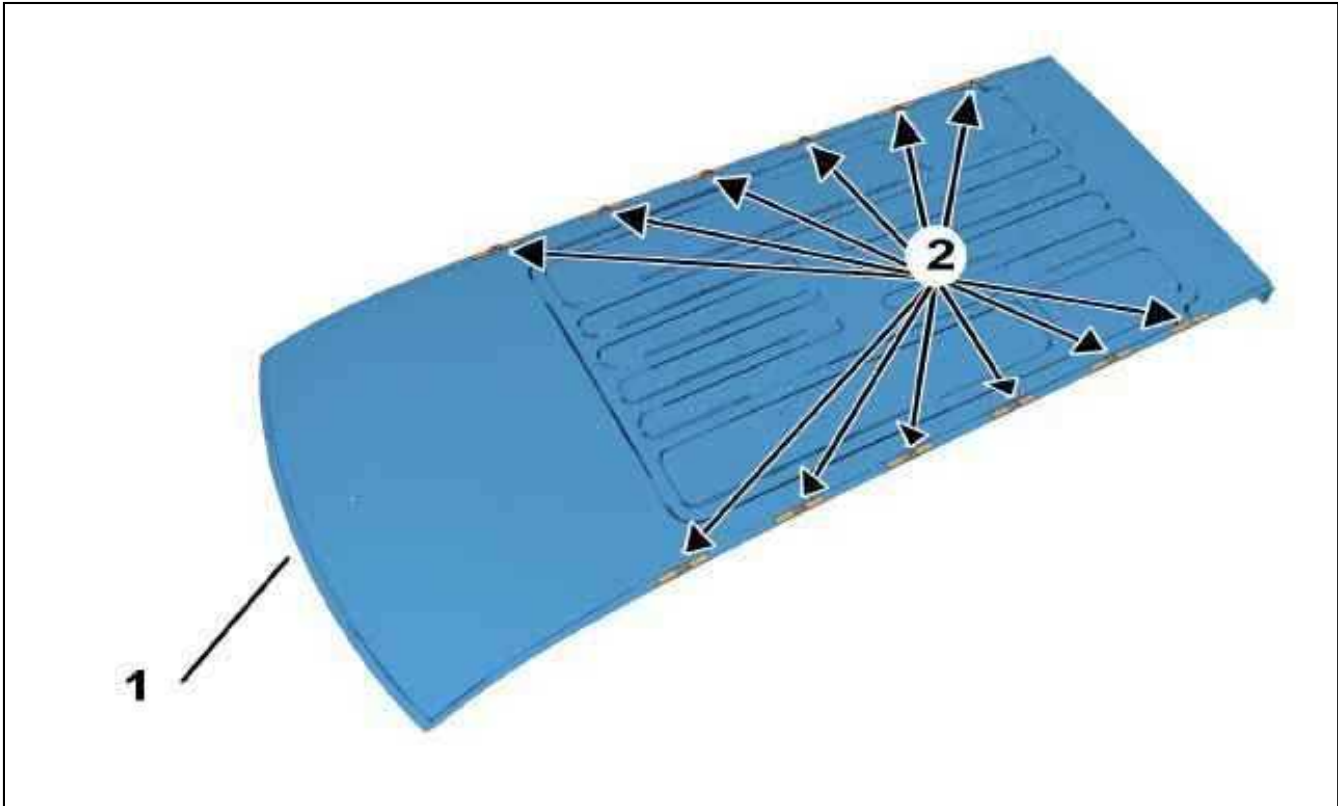


Figure : C4DP0DCD

Reference	Designation	Thickness (mm)	Nature/classification
(1)	Long roof	0,77	ADX (*)
(2)	Luggage carrier fixing U bracket	2,44	High strength (*)
(*) ADX = Mild steel ; (*) High strength = High strength steel			

3. Replacement part preparation

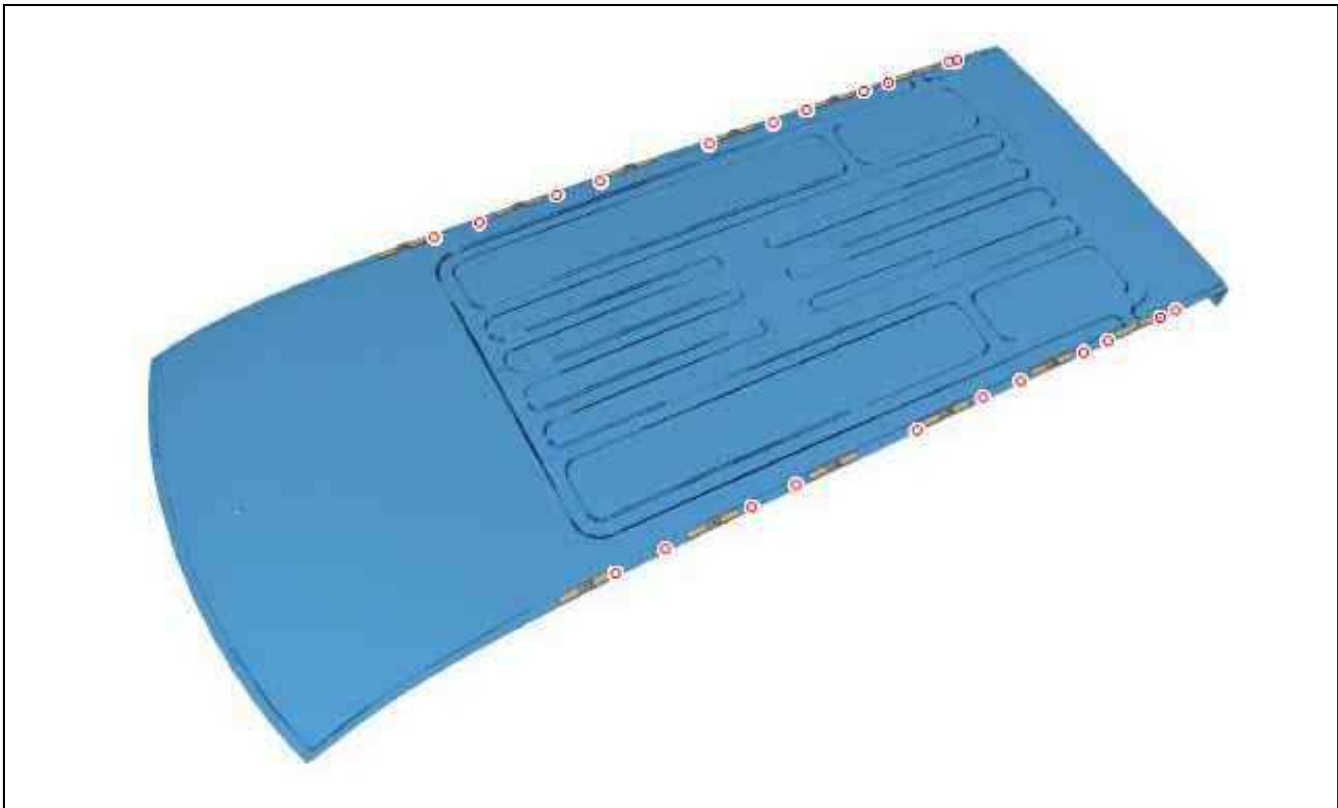


Figure : C4DP0DDD

Drill 6,5 mm holes for later plug welding MAG.

Prepare the mating edges and protect them using a weldable primer .

4. Cutting out

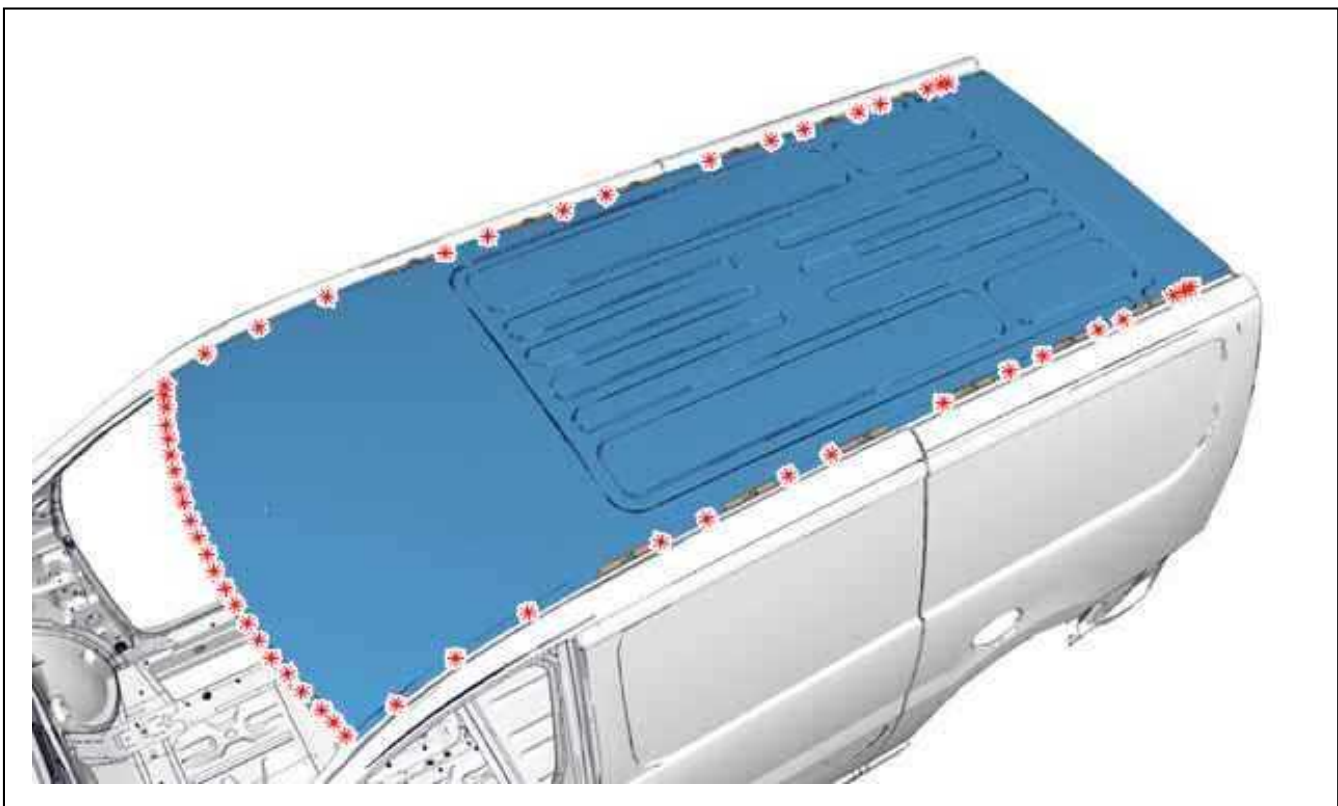


Figure : C4DP0DED

Cut out the spot welds .

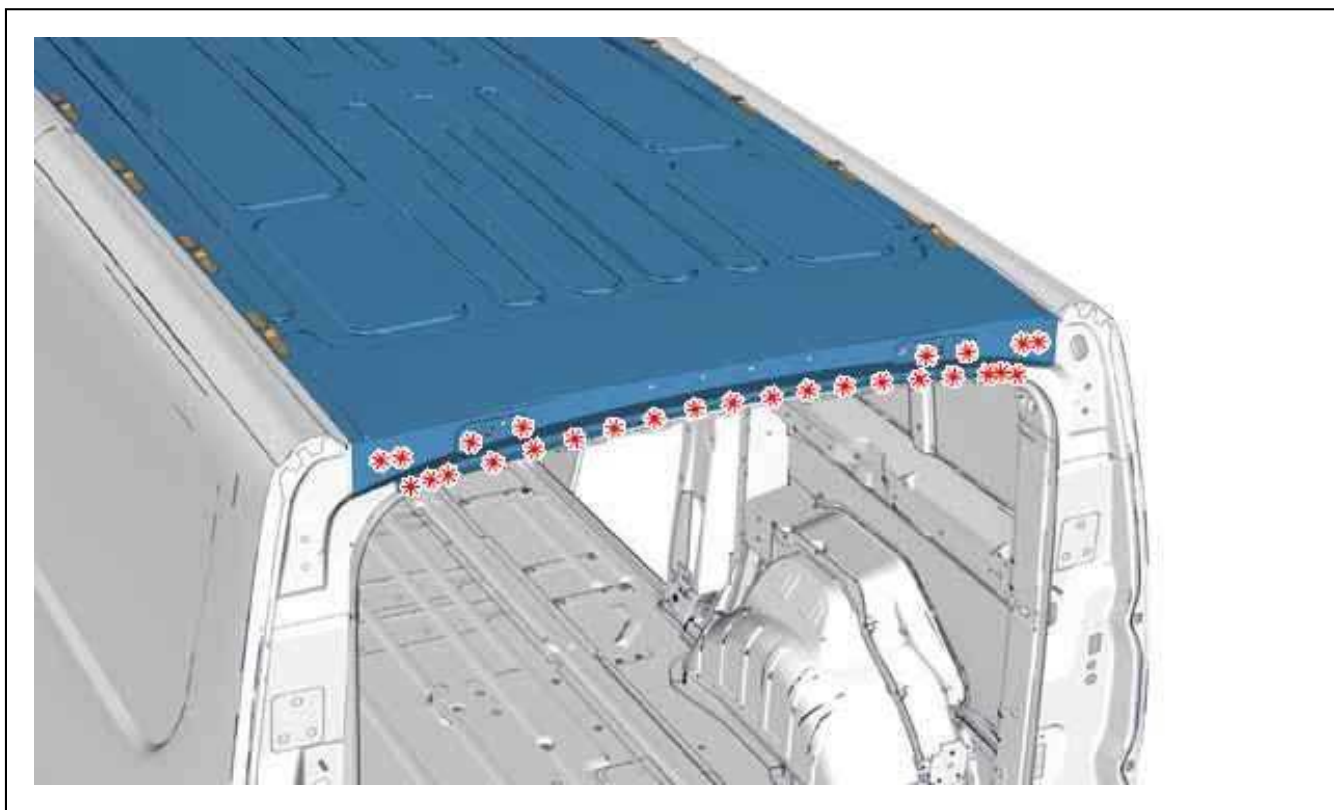


Figure : C4DP0DFD

Cut out the spot welds .

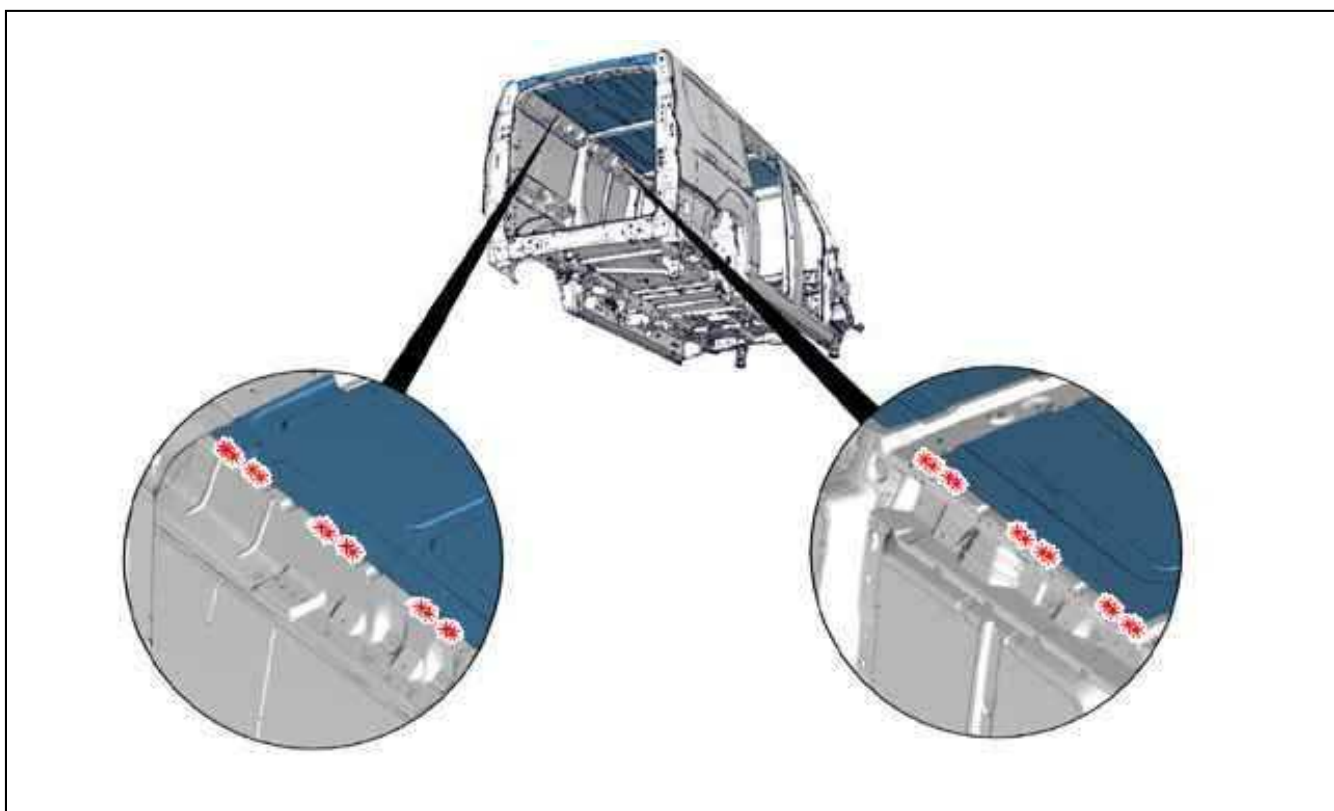


Figure : C4EP19YD

Cut out the spot welds (Symmetrical operation).
Remove the long roof .

5. Bodywork cleaning and preparation

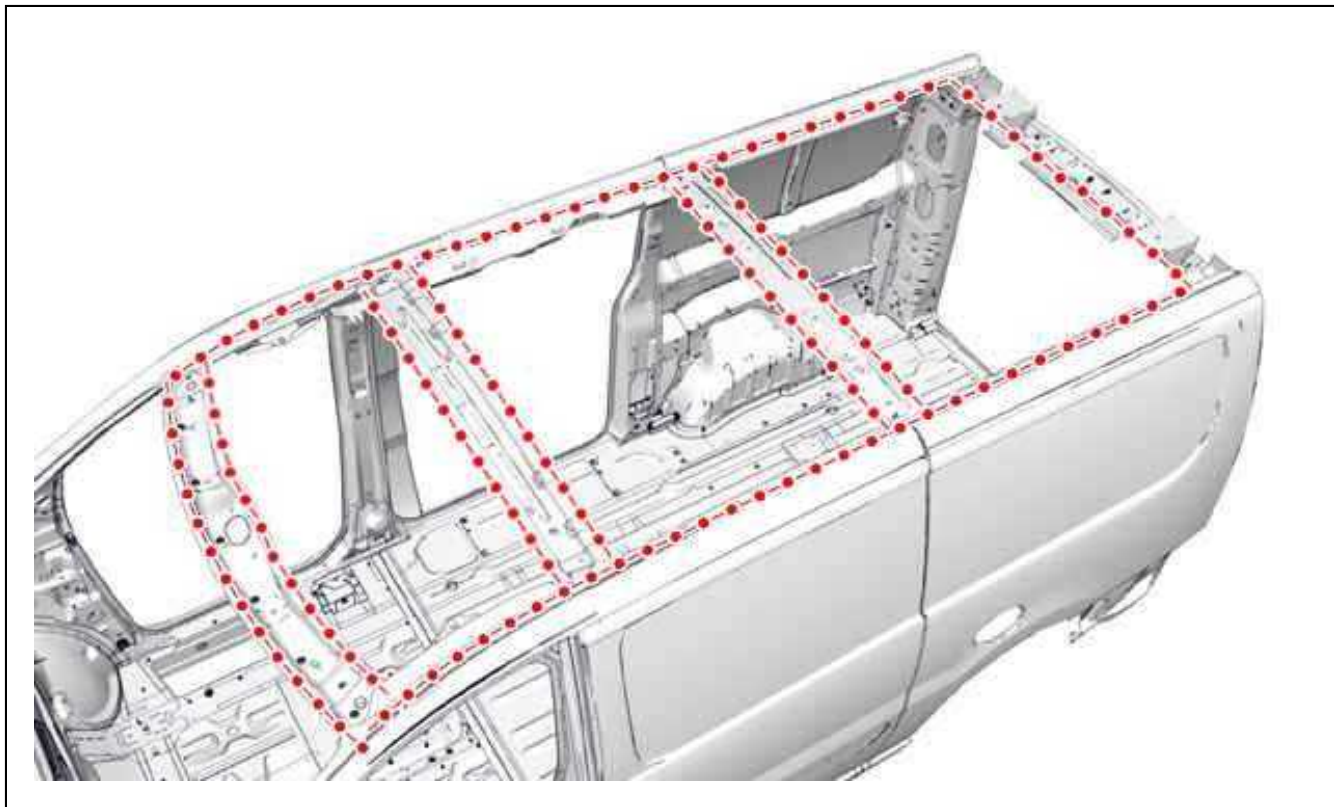


Figure : C4DP0DGD

Prepare the mating edges and protect them using a weldable primer .

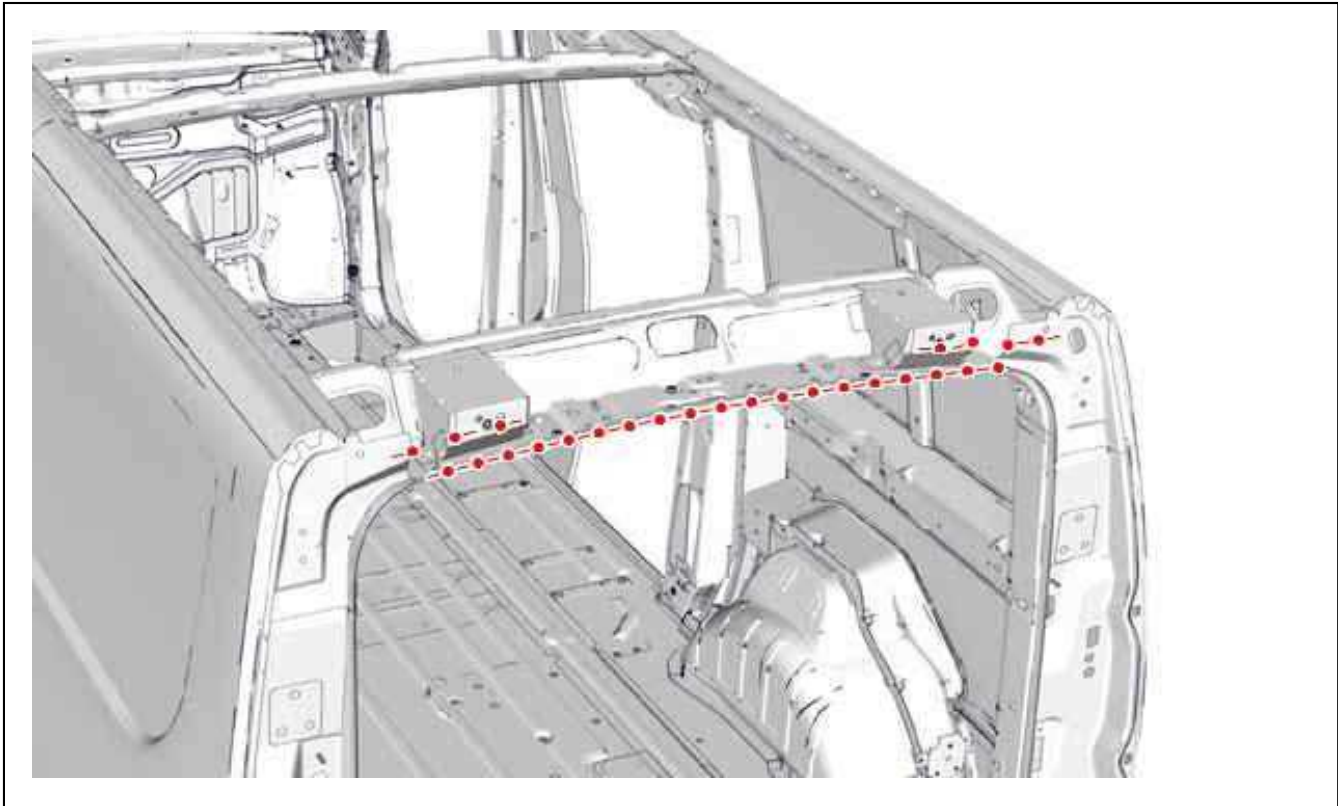


Figure : C4DP0DHD

Prepare the mating edges and protect them using a weldable primer .

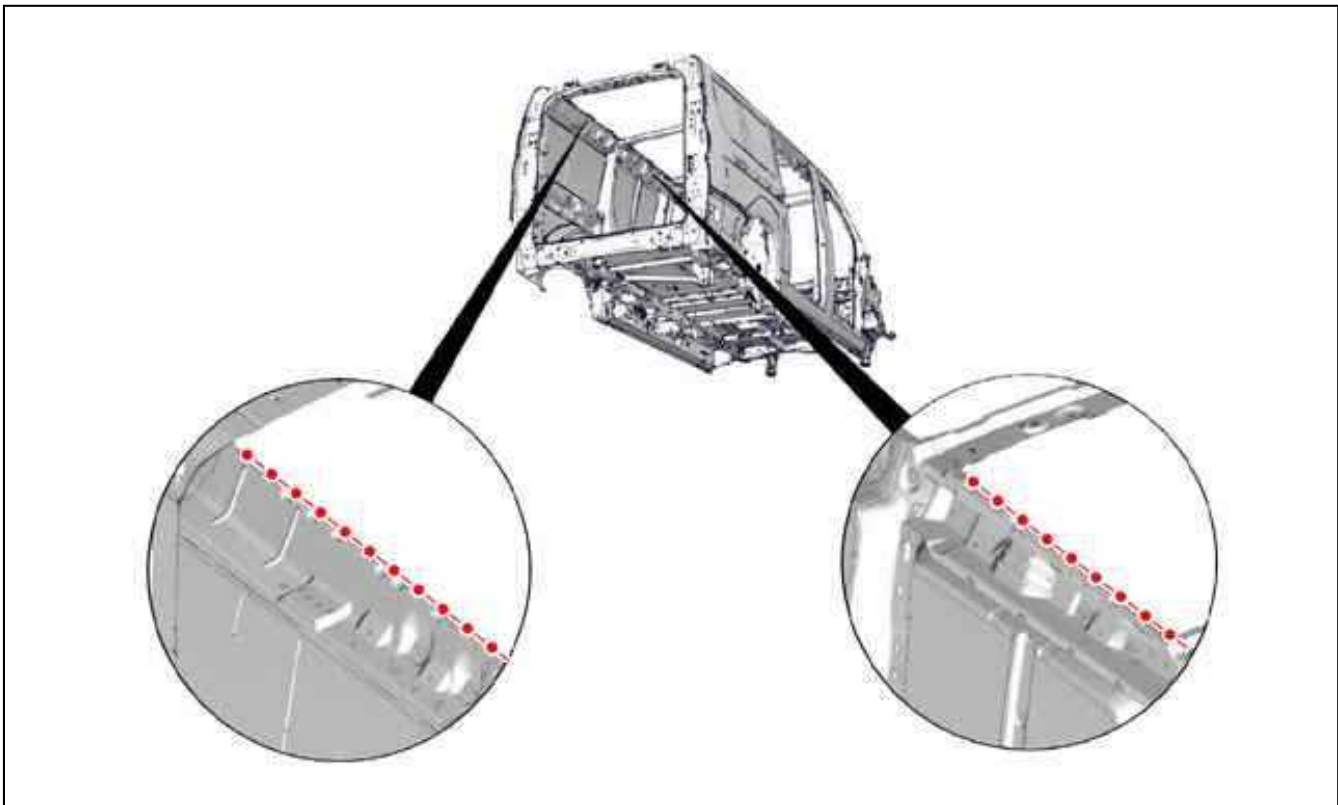


Figure : C4EP19ZD

Prepare the mating edges and protect them using a weldable primer (Symmetrical operation).

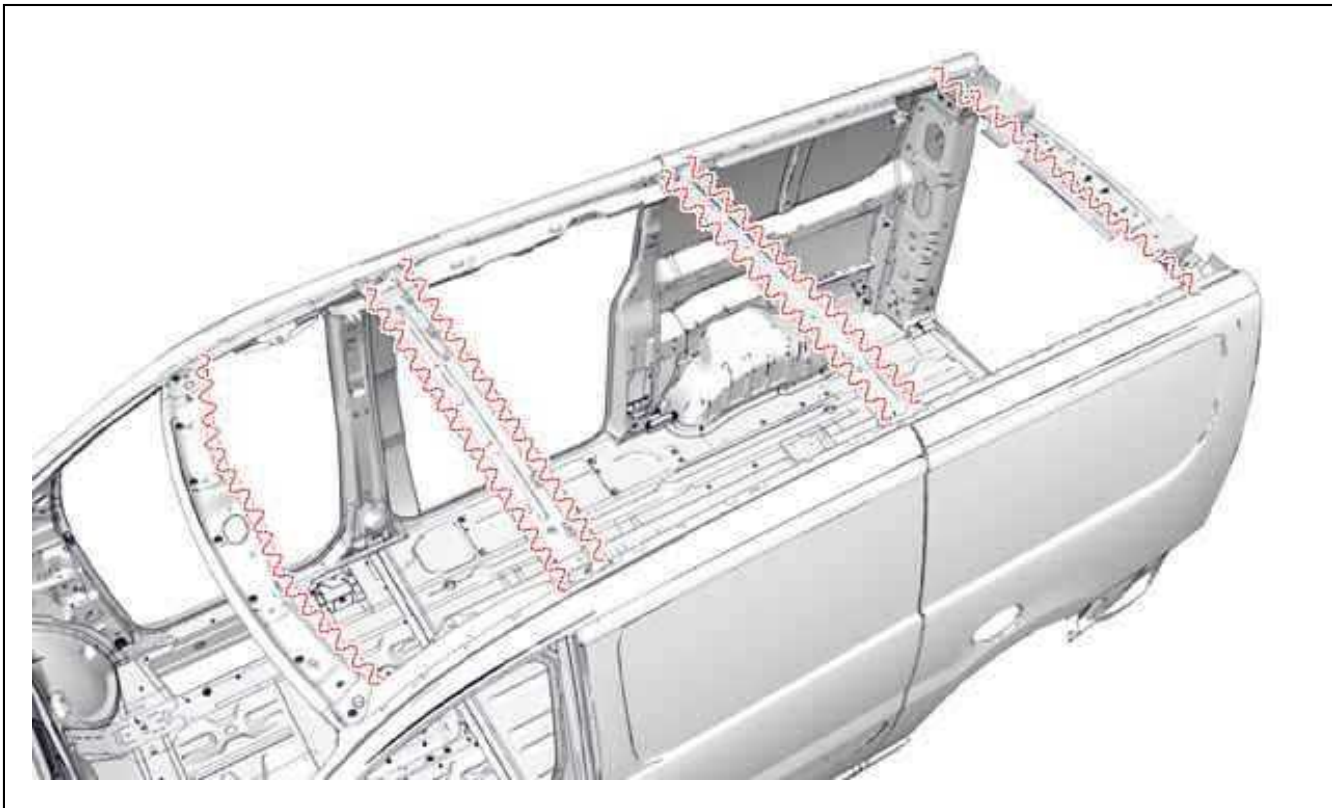


Figure : C4DP0DJJD

Apply a filling adhesive "B5".

6. Adjustment

Fit the long roof .

Check the fit.

7. Welding

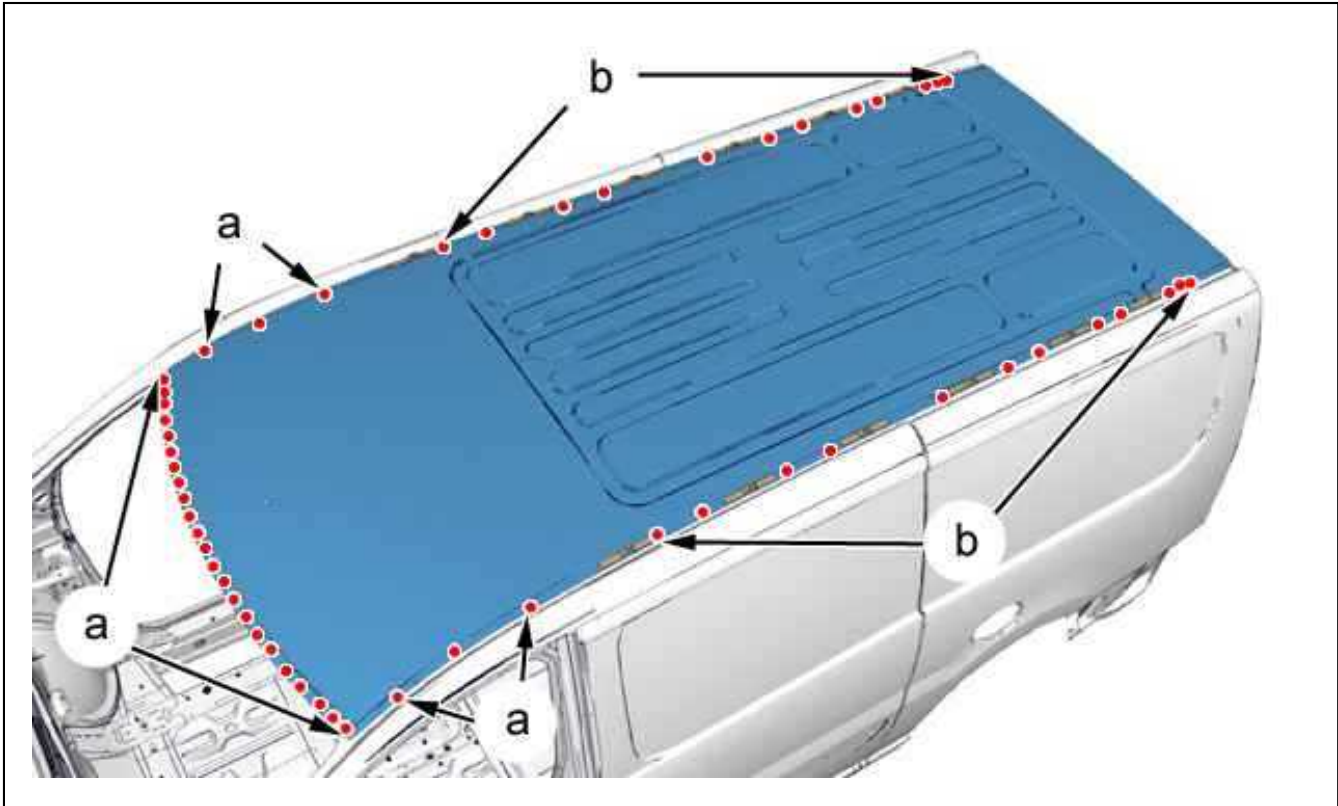


Figure : C4DP0DKD

Weld with electric spot welds ⓘ (at "a").

Weld with MAG plug welds (at "b").

Grind the MAG plug welds.

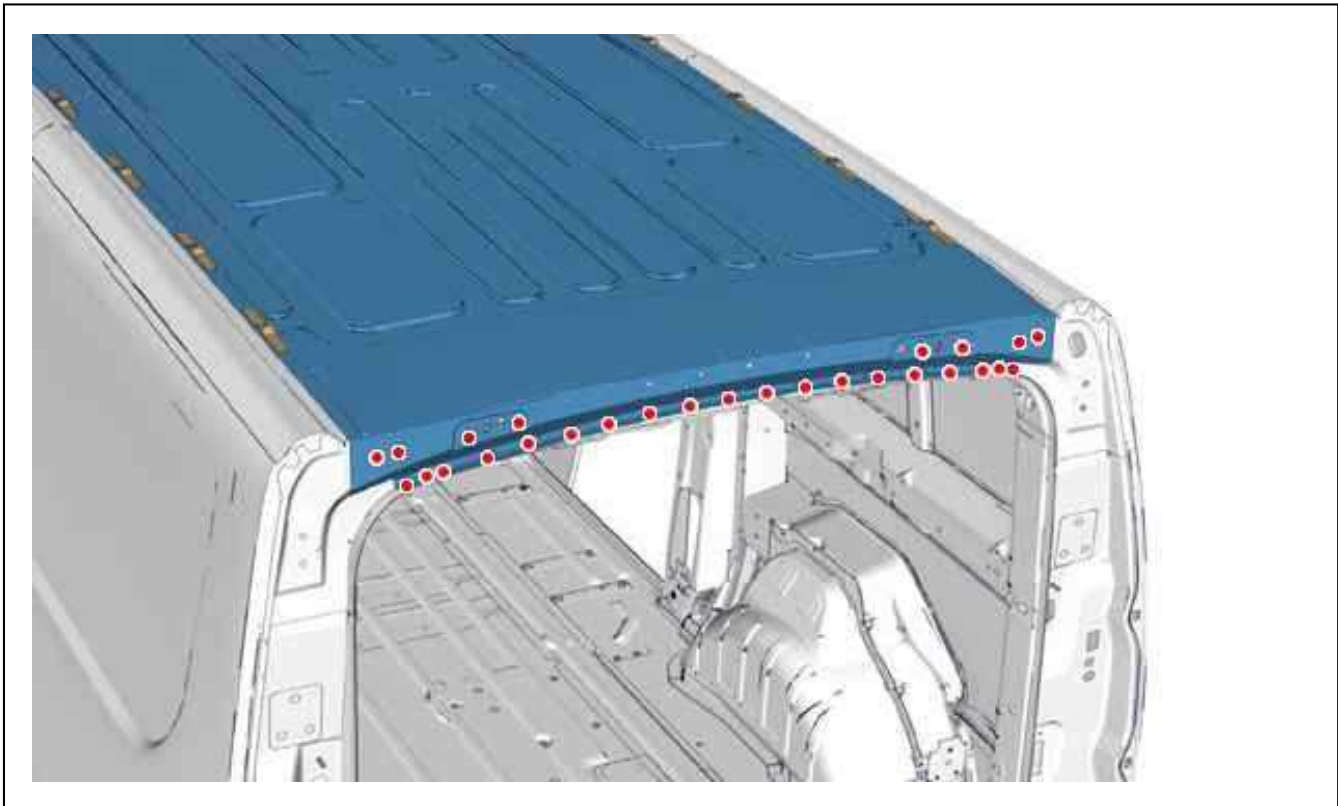


Figure : C4DP0DLD

Weld with electric spot welds  .

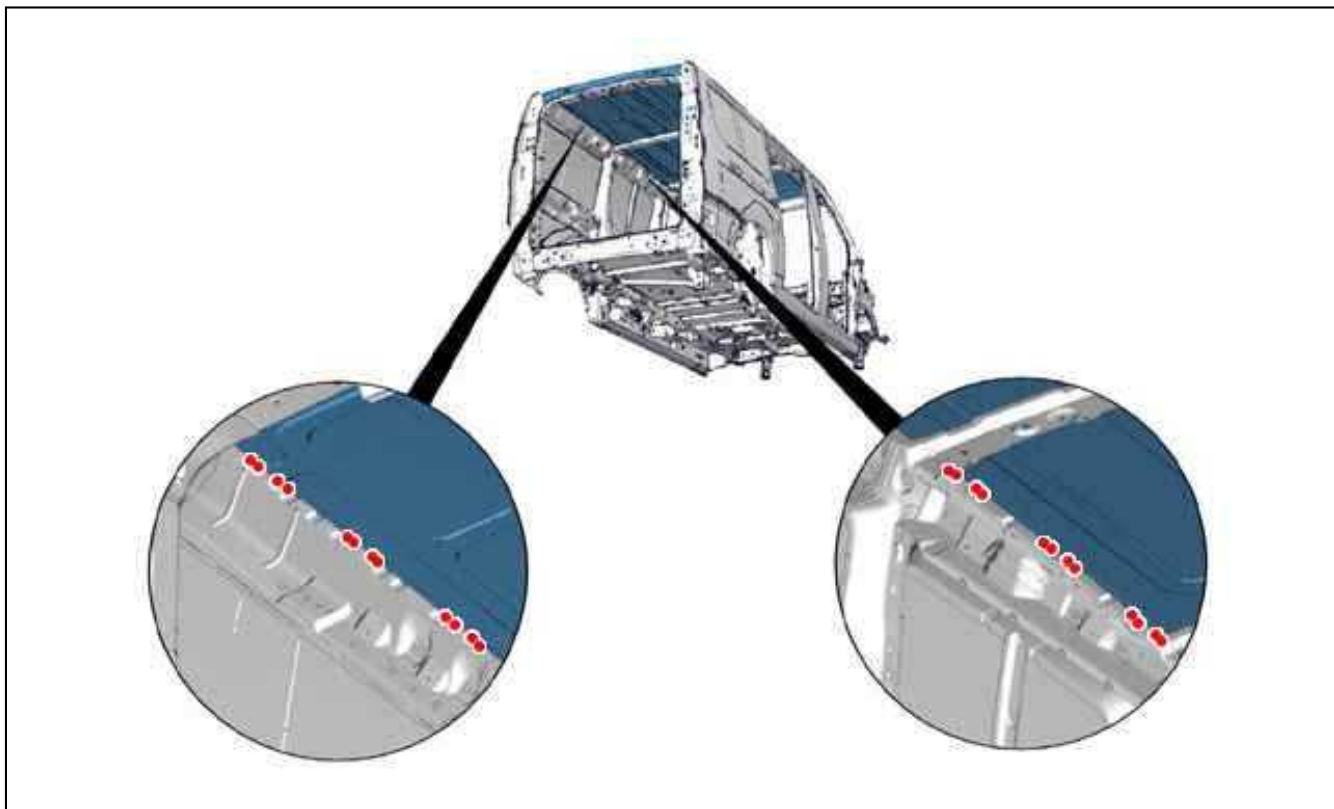


Figure : C4EP1A0D

Weld with MAG plug welds (Symmetrical operation).

8. Sealing protection

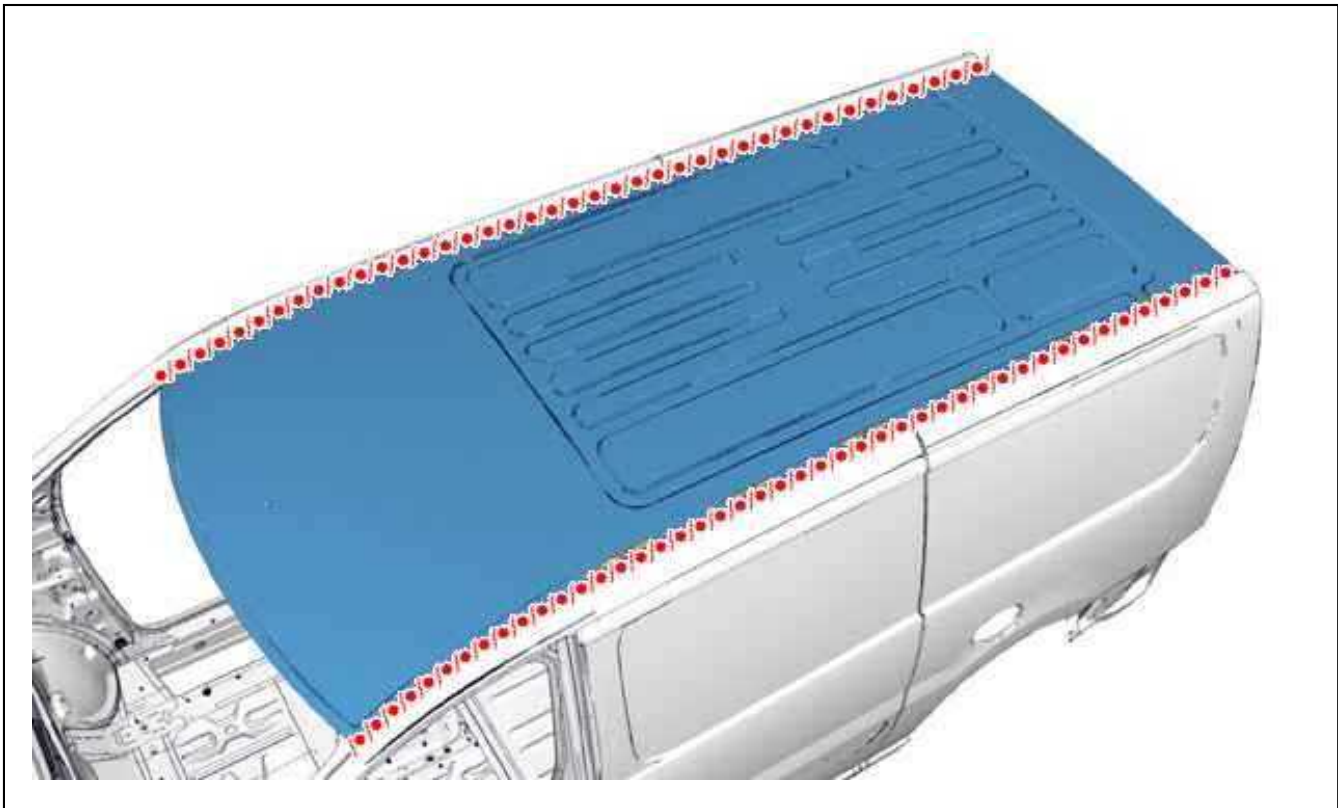


Figure : C4DP0DMD

Apply a phosphate-print layer to the zones laid bare.

Apply a sealing mastic index "A1".

Paint then spray into the hollow sections, product index C5, in the repair zone.

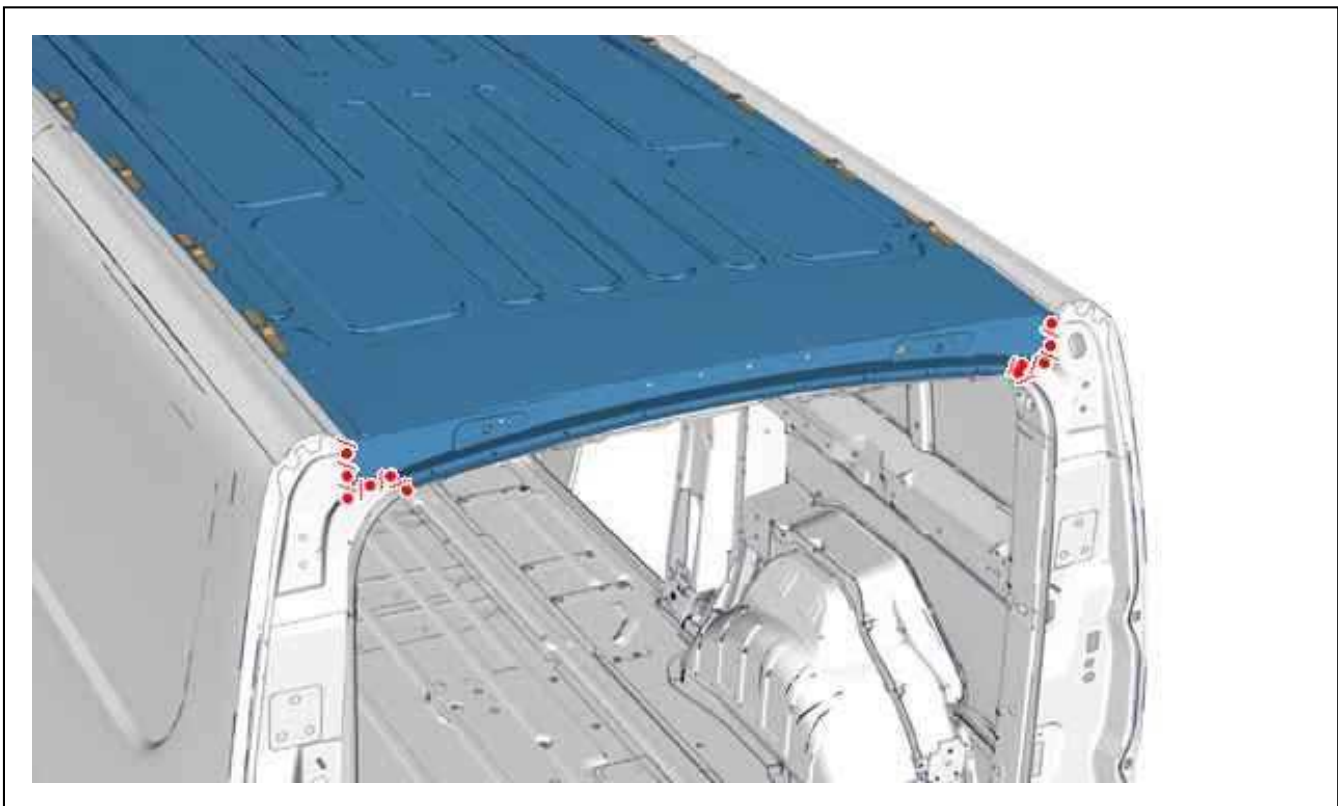


Figure : C4DP0DND

Apply a phosphate-print layer to the zones laid bare.

Apply a sealing mastic index "A4".

Paint then spray into the hollow sections, product index C5, in the repair zone.

9. Reinitialisation

Carry out the additional operations.

CAUTION : Perform the operations to be carried out following reconnection of the battery ⓘ .

REPLACEMENT : HIGH VERSION ROOF

ESSENTIAL : Depending on the operation to be carried out, observe the instructions for chocking up the vehicle.

ESSENTIAL : Deactivate the pneumatic suspension before lifting the vehicle ⓘ (2 or 4 post lift, workshop jack or customer's jack ⓘ).

ESSENTIAL : Observe the elementary rules of hygiene and safety (wear a face mask to protect against fumes and vapour - work in a well ventilated space).

CAUTION : All of the stripped surfaces must be protected by means of the approved electrolytic rezincing process .

1. Additional operations

Disconnect the battery.

Remove-refit the following components :

- The windscreen
- The lateral embellisher (left and right)
- The roof trim

Release the wiring harnesses.

Protect the interior of the passenger compartment.

2. Identification of the replacement parts

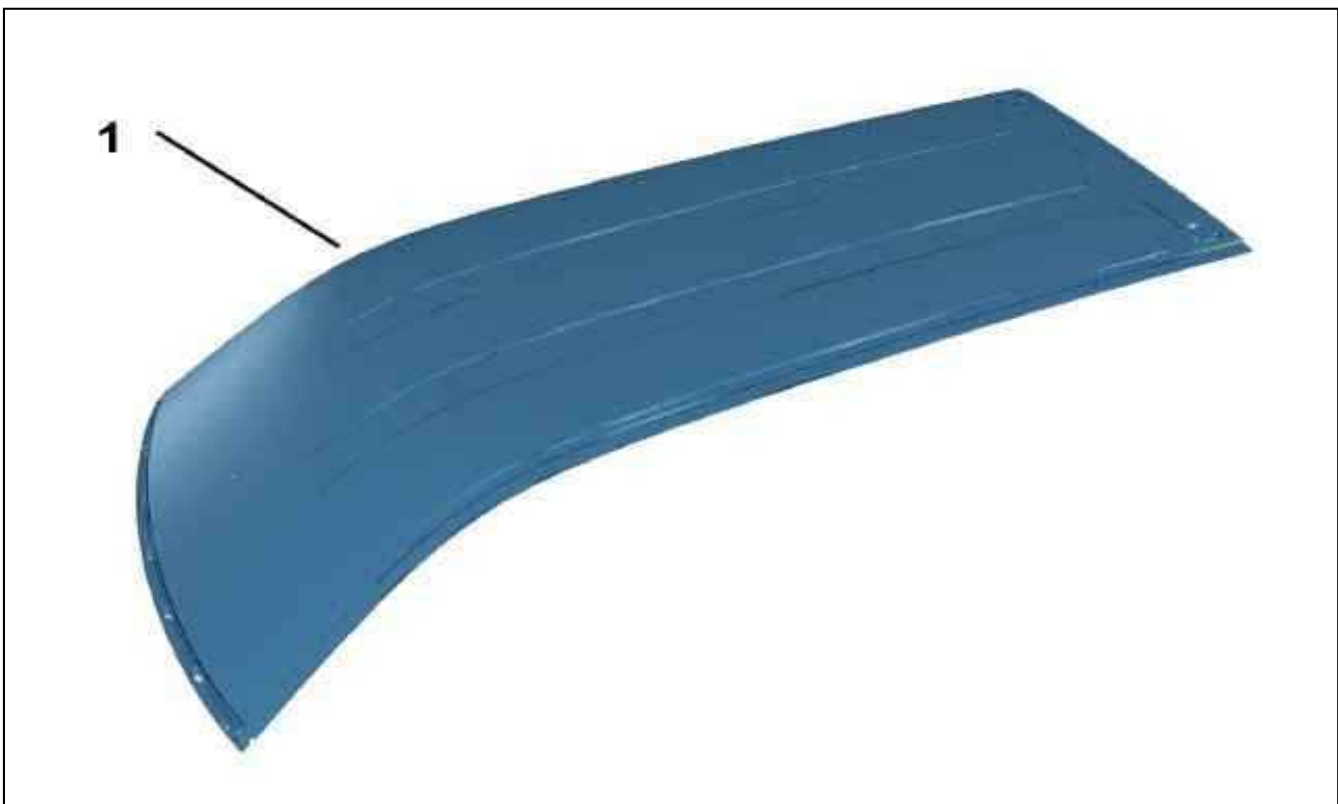


Figure : C4DP0DPD

Reference	Designation	Thickness (mm)	Nature/classification
(1)	High version roof	0,77	ADX (*)
(*) ADX = Mild steel			

3. Replacement part preparation

Painting of the mating edges before bonding.

After painting, lightly sand the bonding zones on the periphery using fine abrasive, to permit attachment of the bead of adhesive.

4. Cutting out

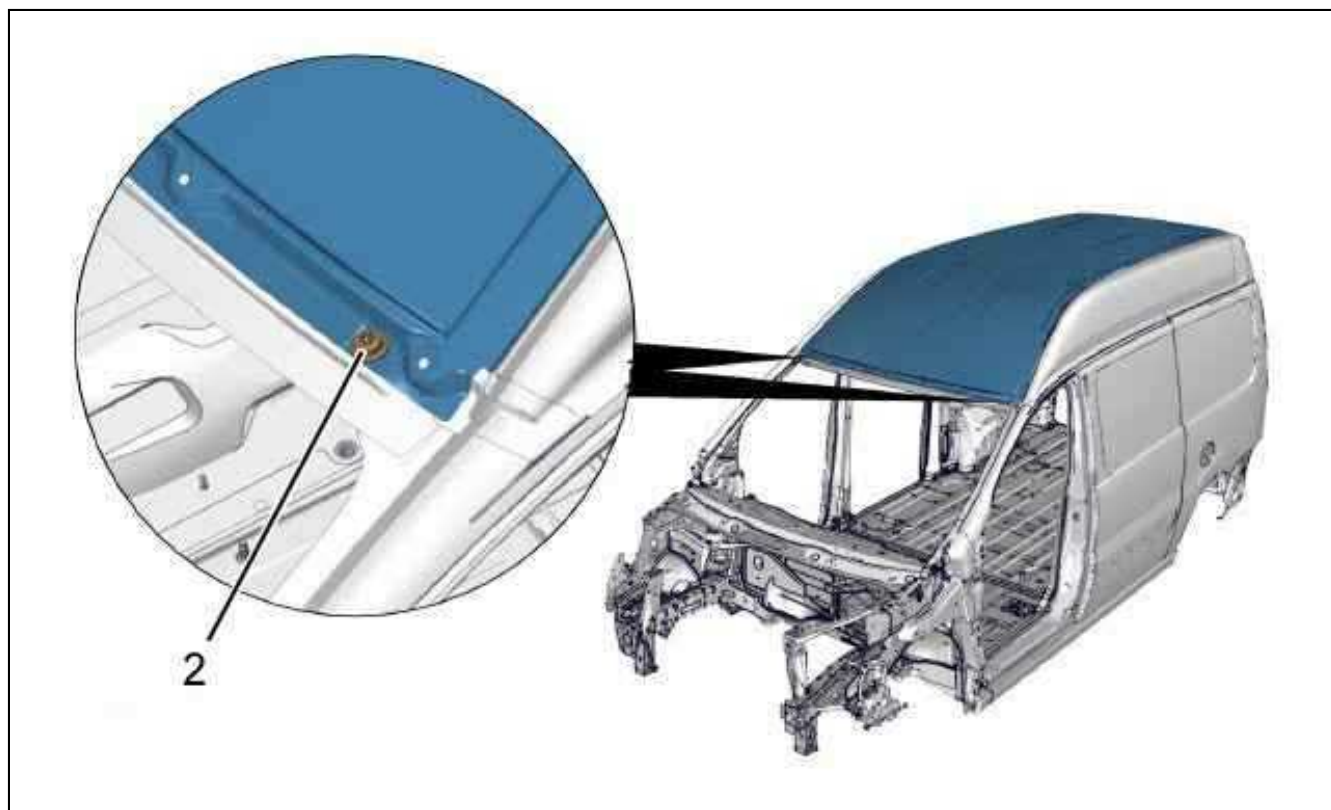


Figure : C4EP1A1D

Remove the bolts "2".



Figure : C4DP0DQD

Mark then cut.
Remove the partial roof .

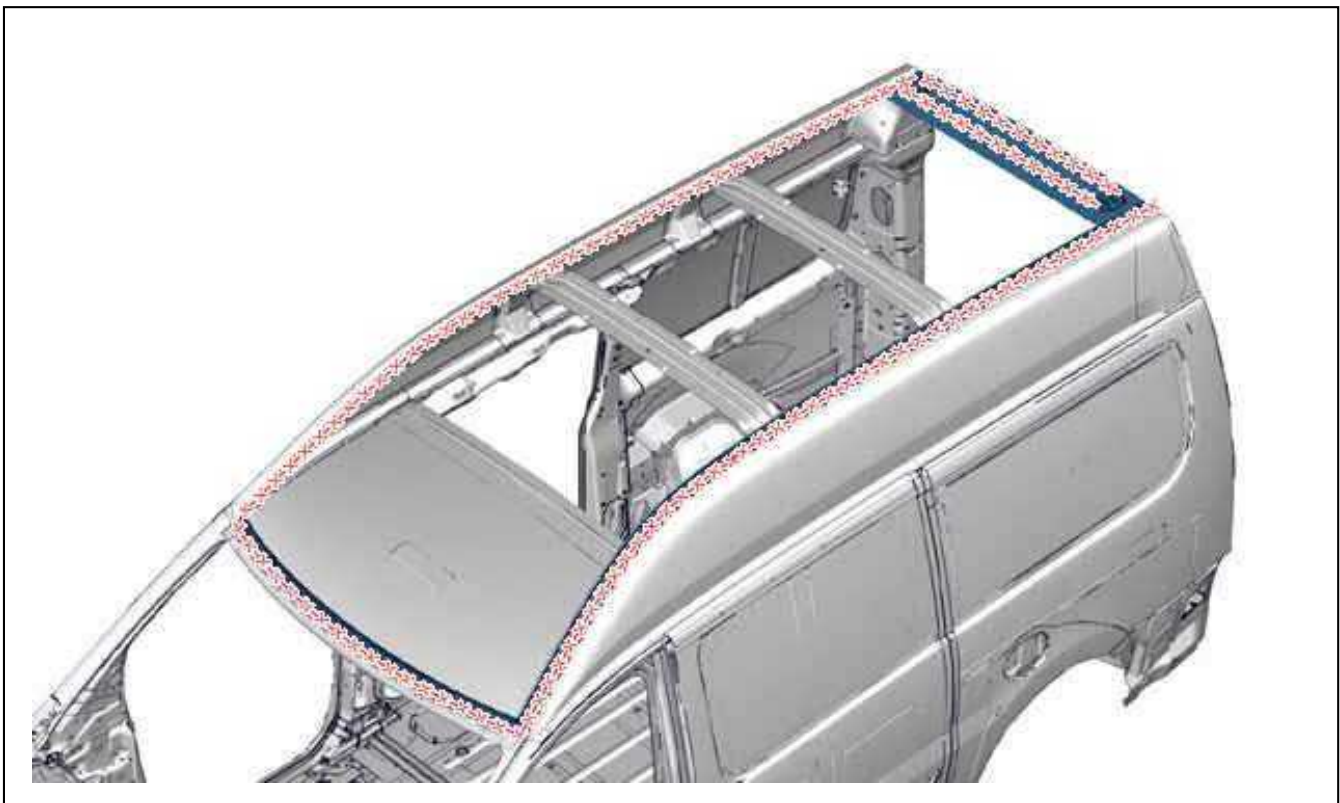


Figure : C4DP0DRD

Cut the remaining part of the roof .

Remove the roof.

5. Bodywork cleaning and preparation

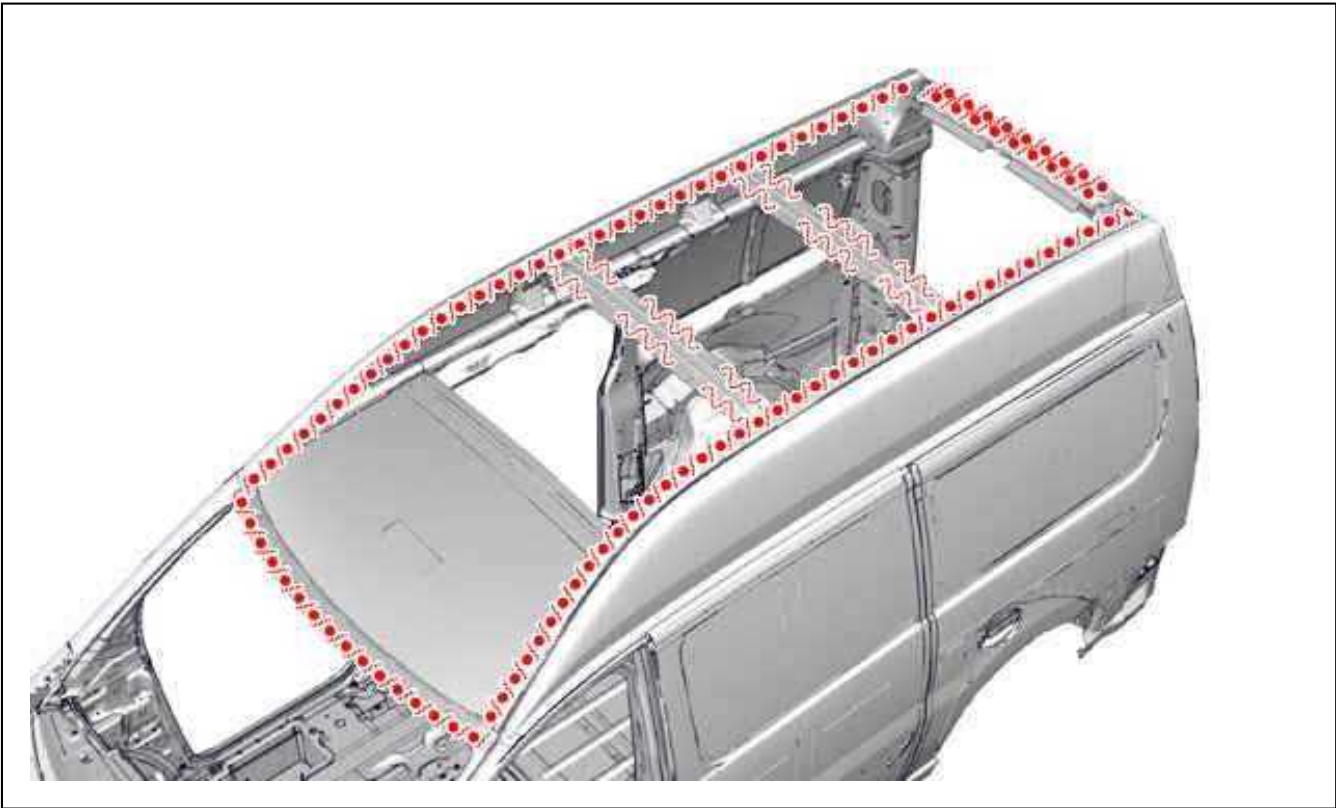


Figure : C4DP0DSD

Level off the beads of adhesive.

Apply structural adhesive index "B8".

Apply a sealing mastic index "A1".

6. Adjustment

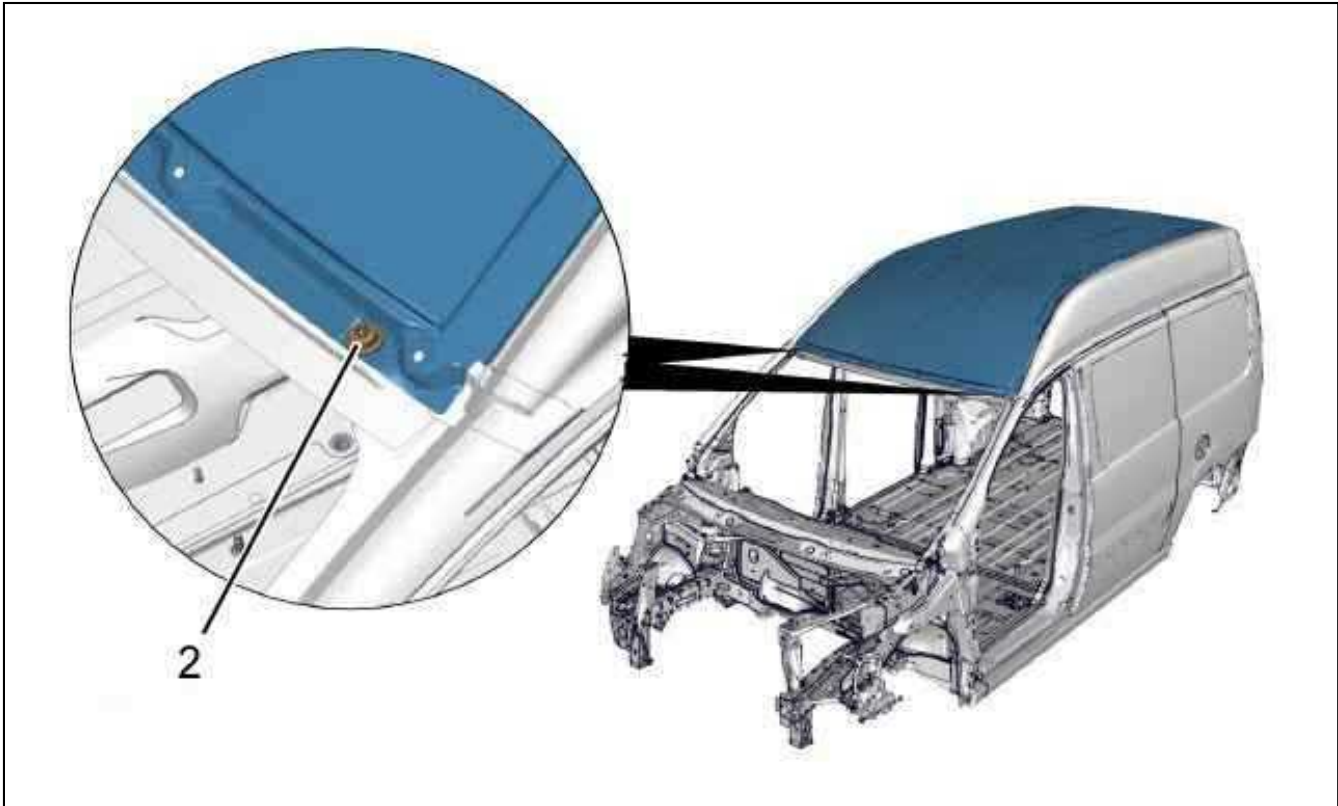


Figure : C4EP1A1D

Fit the roof panel.
Check the fit.
Position a strap to support the high version roof .
Refit the bolts (2).

7. Sealing protection

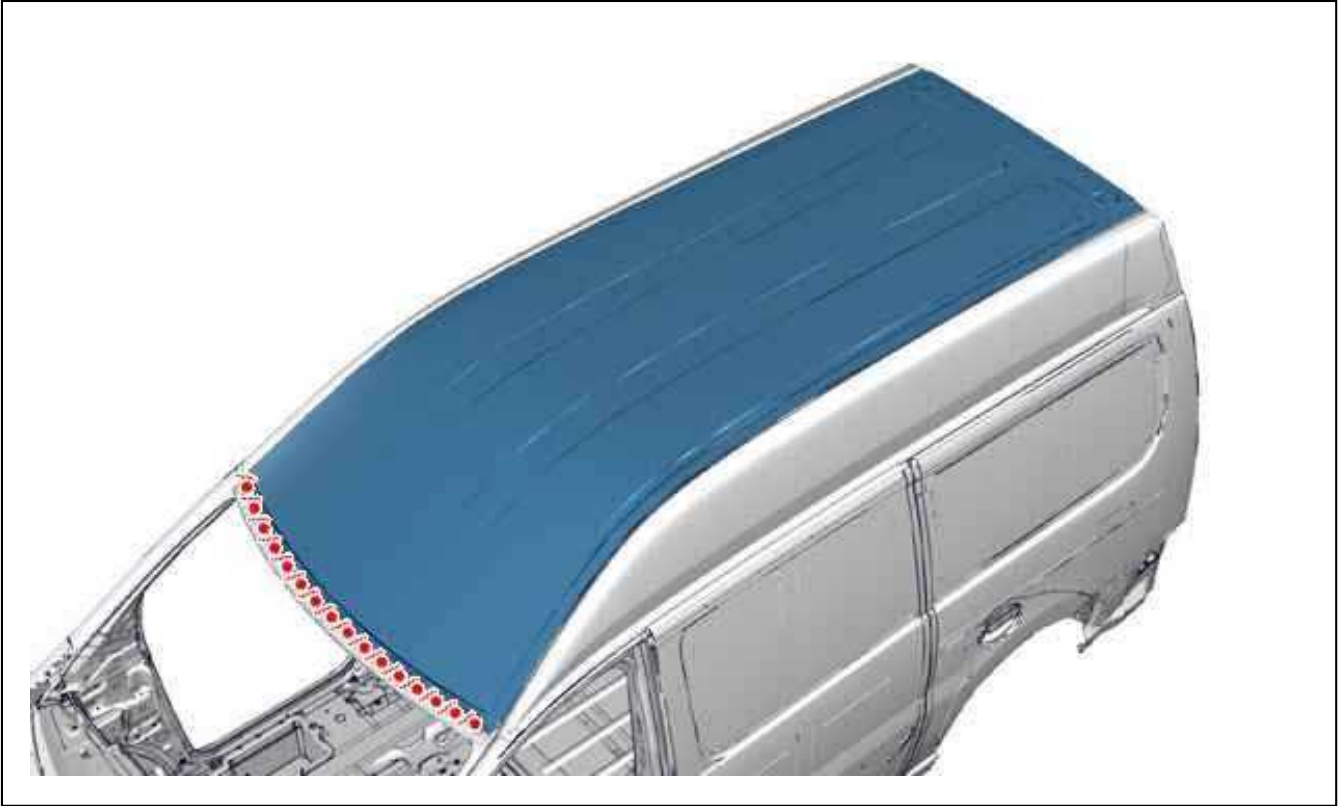


Figure : C4DP0DTD

Apply a sealing mastic index "A1".

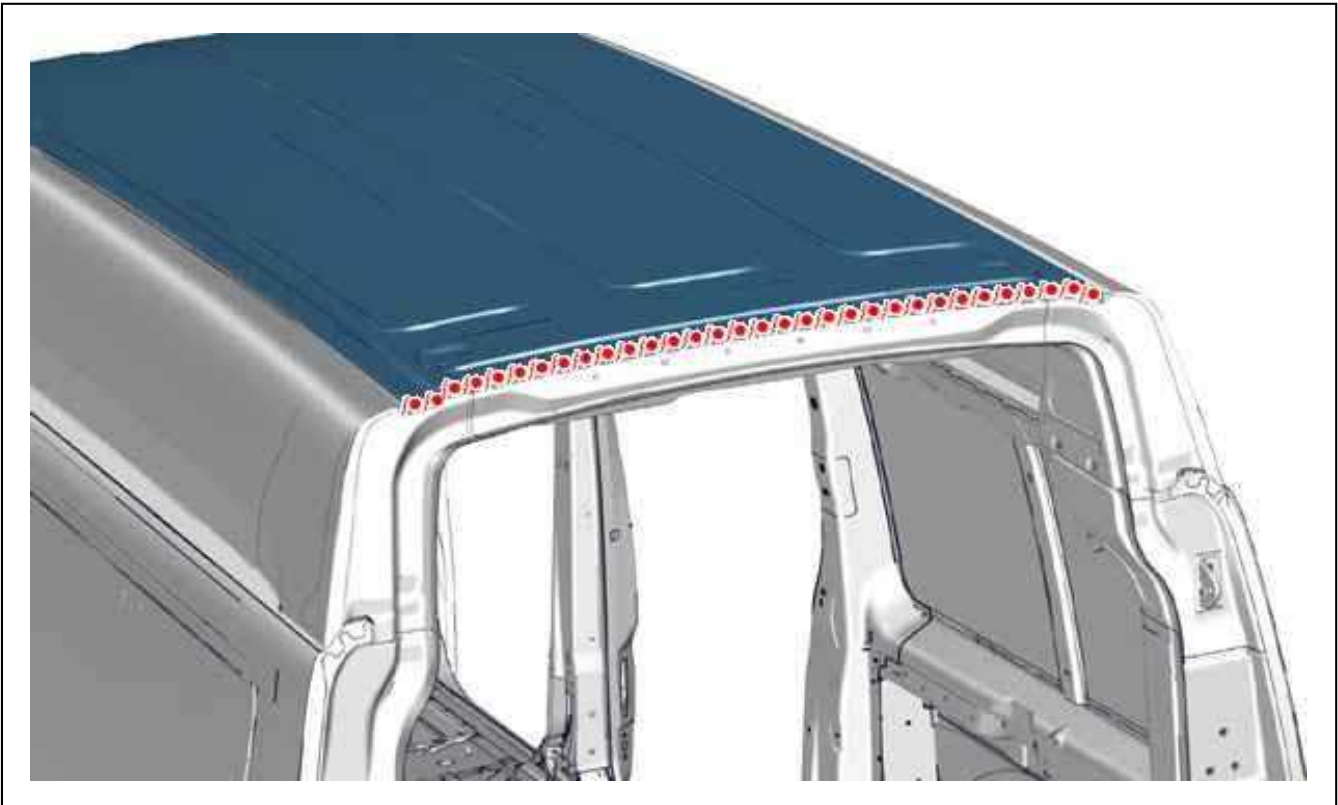


Figure : C4DP0DUD

Apply a sealing mastic index "A1".

8. Reinitialisation

Carry out the additional operations.

CAUTION : Perform the operations to be carried out following reconnection of the battery  .

REPLACEMENT : CROSSMEMBERS - ROOF PANEL AND ITS ARCHES (HIGH VERSION)

ESSENTIAL : Observe the safety and cleanliness recommendations ⓘ .

ESSENTIAL : Depending on the operation to be carried out, observe the instructions for chocking up the vehicle.

ESSENTIAL : Deactivate the pneumatic suspension before lifting the vehicle ⓘ (2 or 4 post lift, workshop jack or customer's jack ⓘ).

CAUTION : All of the stripped surfaces must be protected by means of the approved electrolytic rezincing process .

CAUTION : The number of spot welds necessary for the assembly of a new part must be identical to the number of spot welds fixing the original part.

1. Additional operations

Release the wiring harnesses.

Protect the interior of the passenger compartment.

Replace the roof extensions ⓘ .

2. Identification of replacement parts

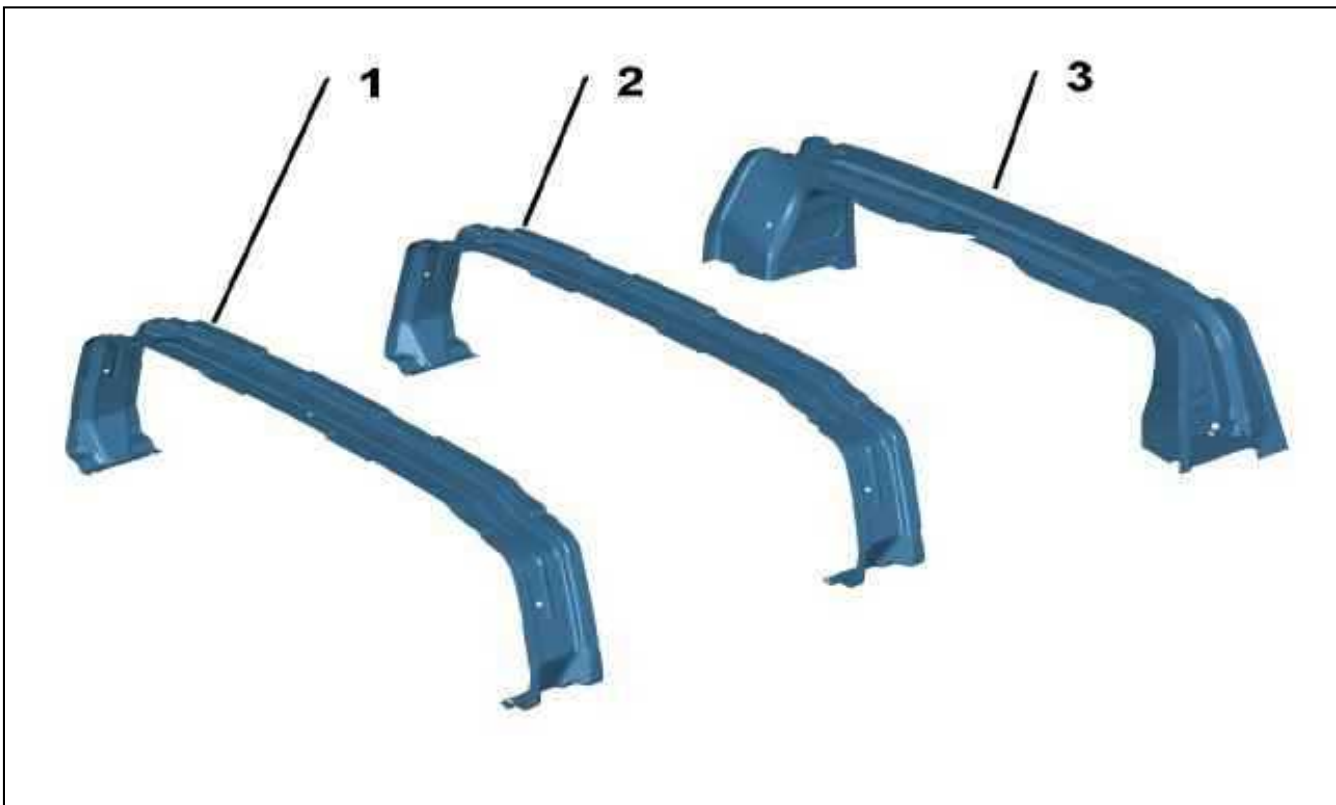


Figure : C4DP0DVD

(1) Intermediate cross member.

- (2) Intermediate bow.
- (3) Rear cross member assembly.

3. Removing

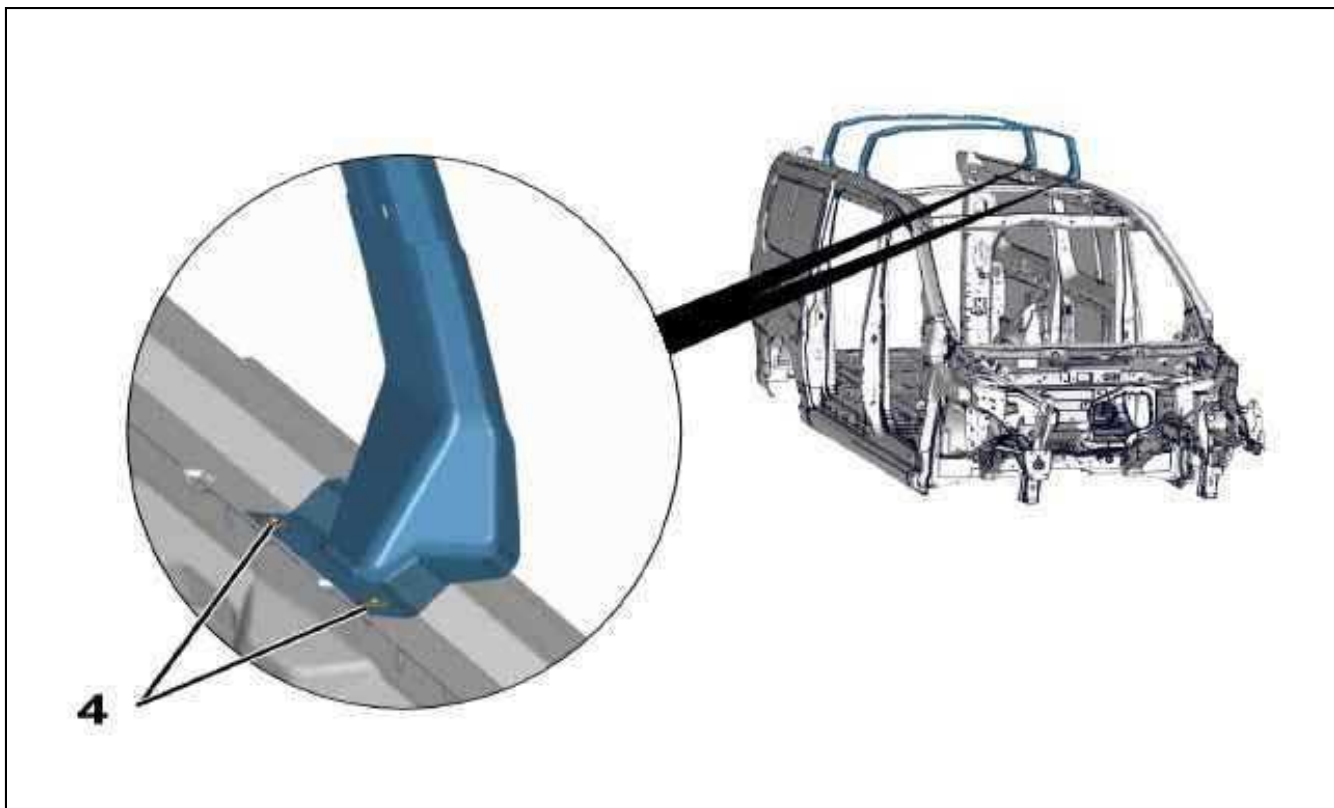


Figure : C4EP1A2D

Drill the rivets (4) (Symmetrical operation).

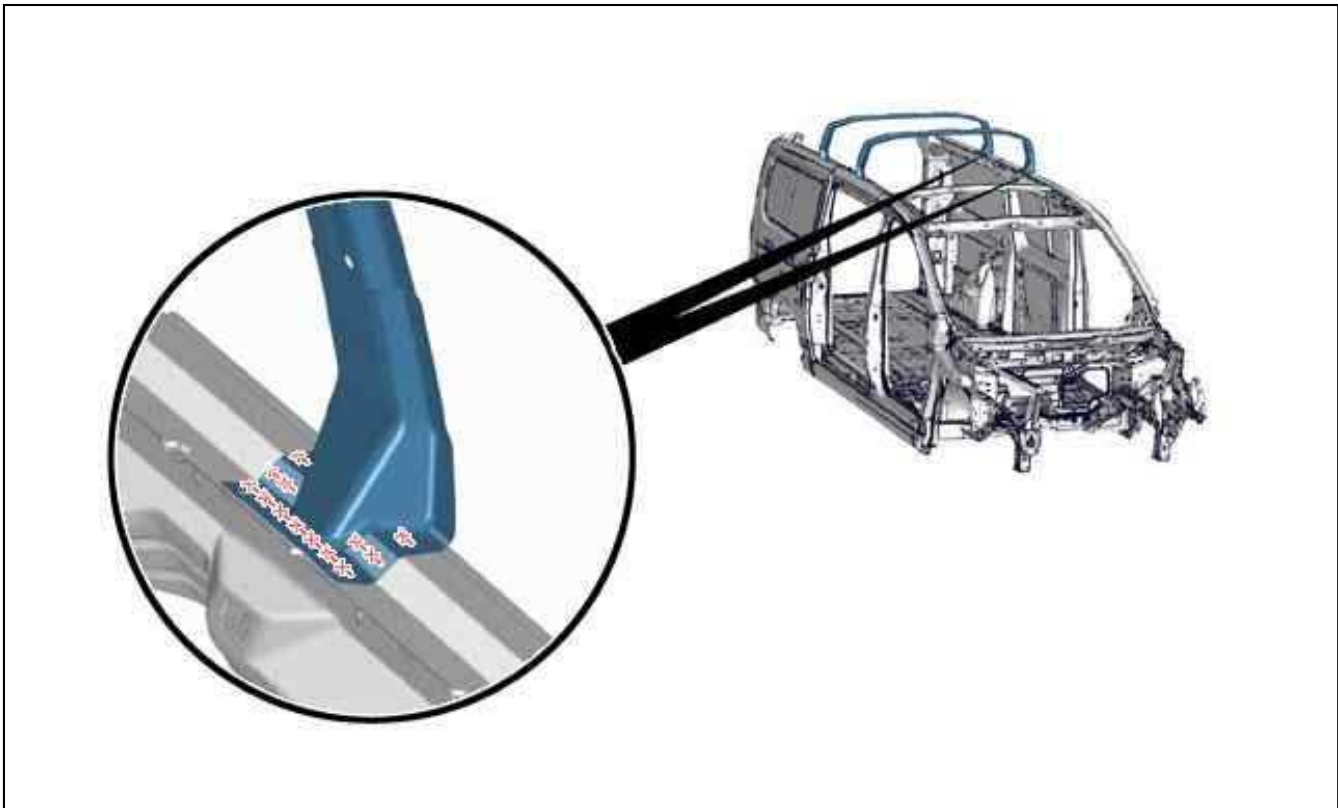


Figure : C4EP1A3D

Cut the filling adhesive (Symmetrical operation).

Remove :

- The roof intermediate crossmember
- The roof intermediate bow

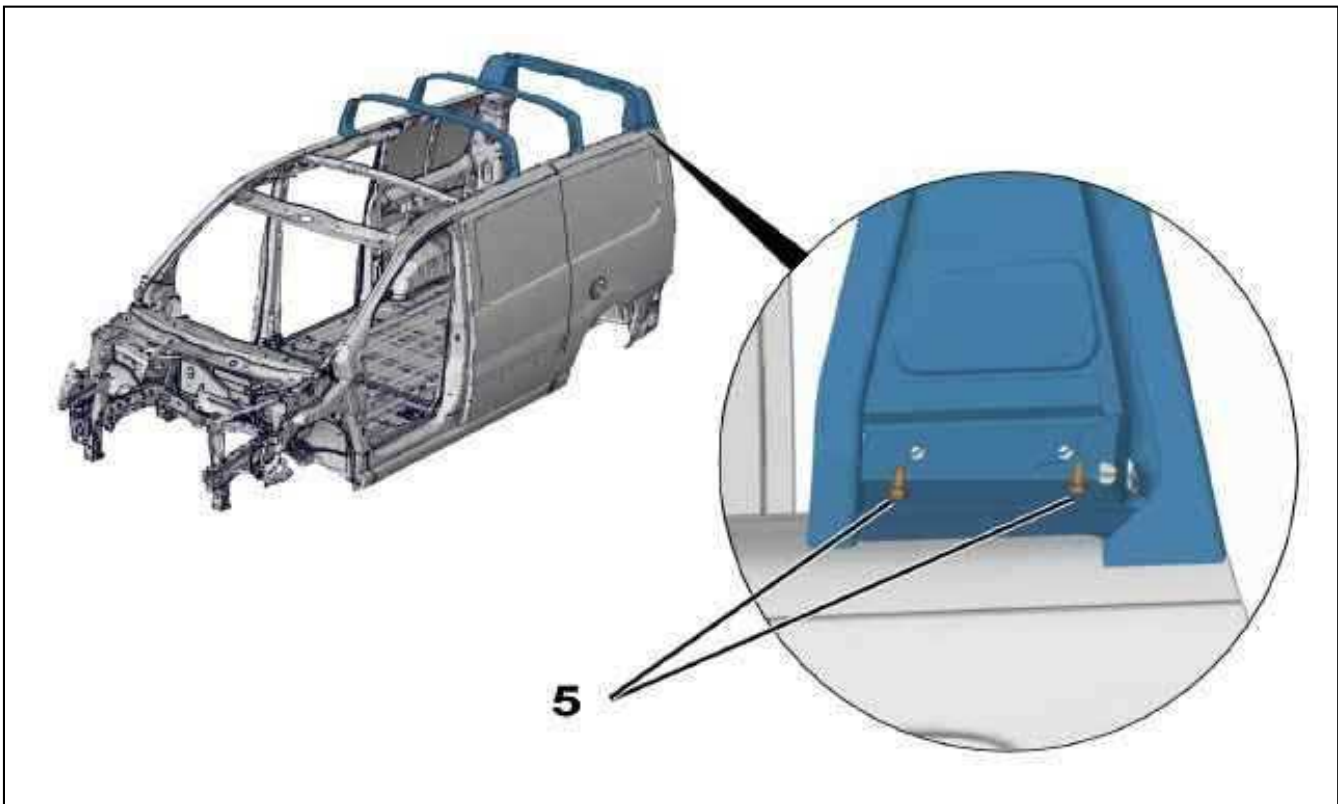


Figure : C4EP1A4D

Remove the nuts (5) (Symmetrical operation).

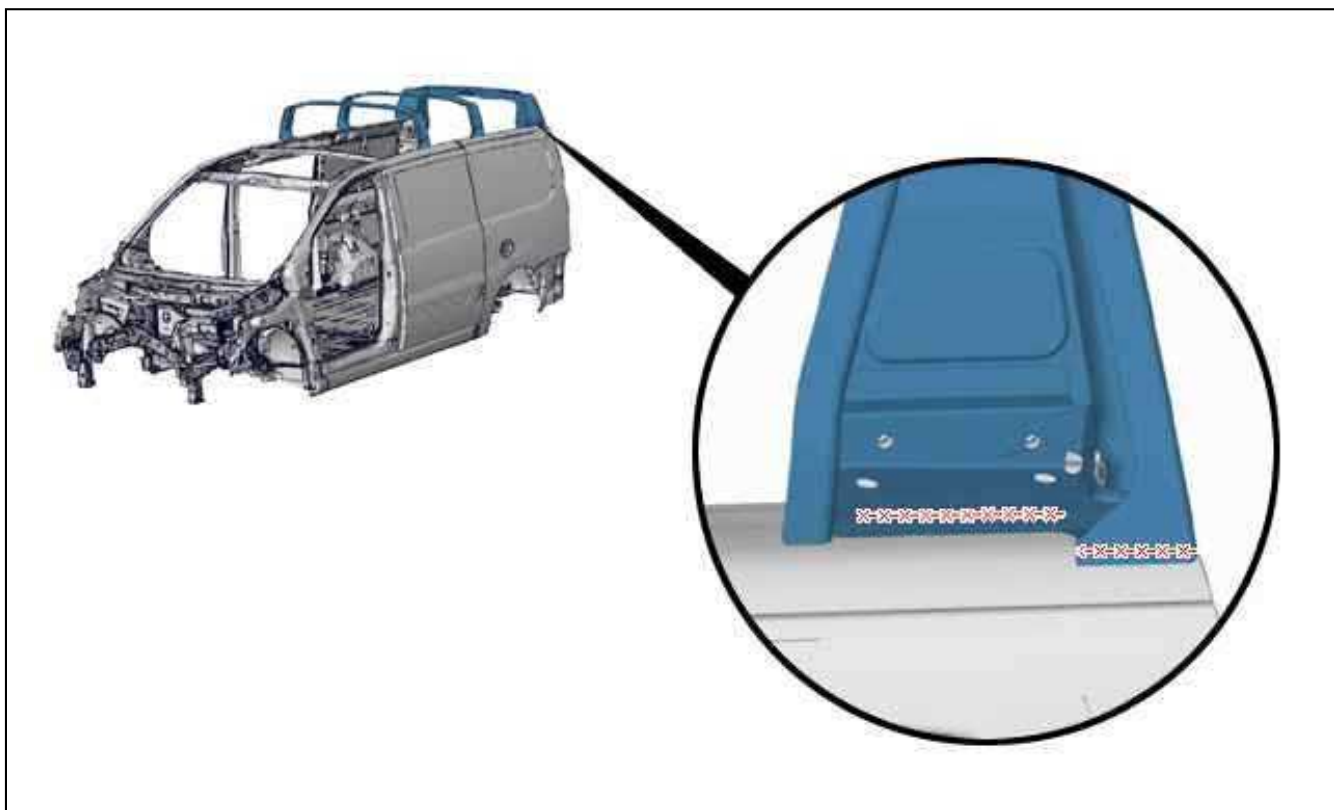


Figure : C4EP1A5D

Cut the filling adhesive (Symmetrical operation).

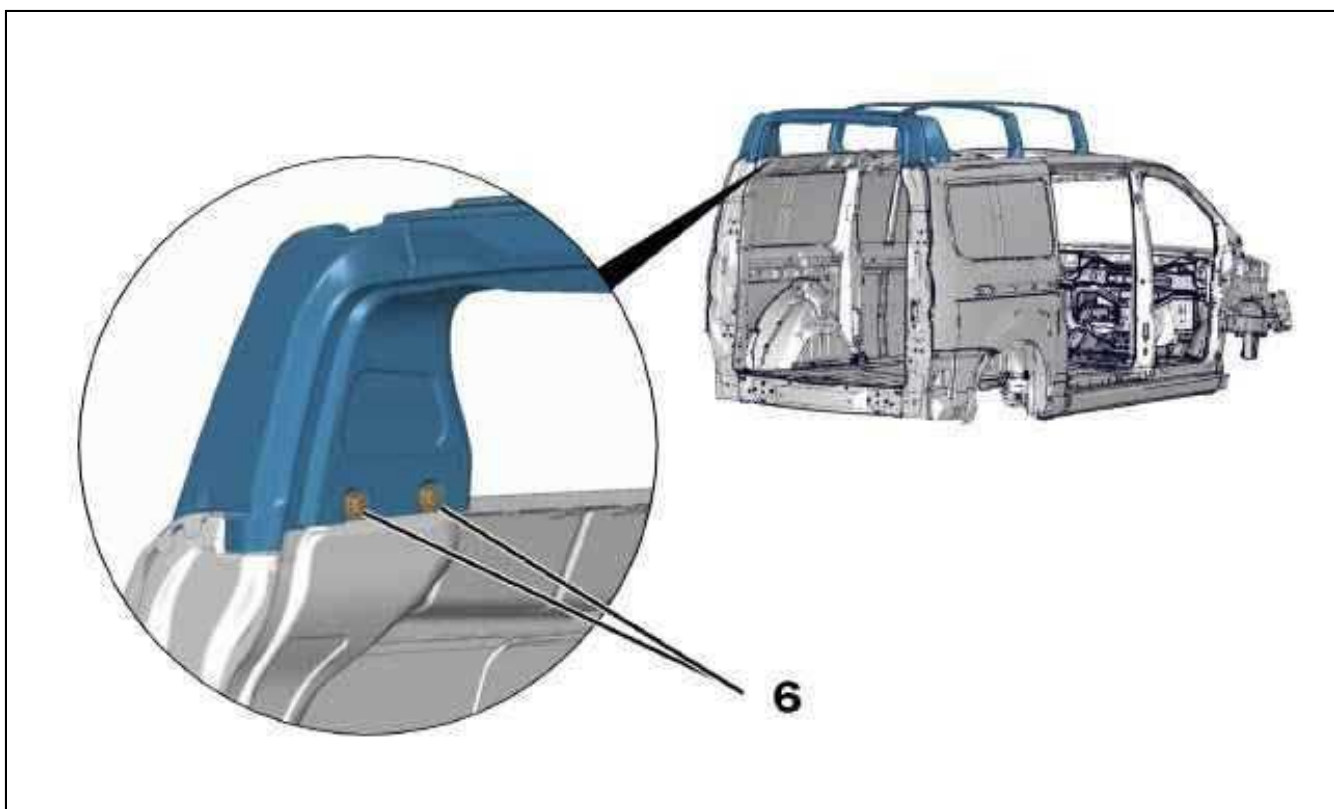


Figure : C4EP1A6D

Remove the bolts (6) (Symmetrical operation).

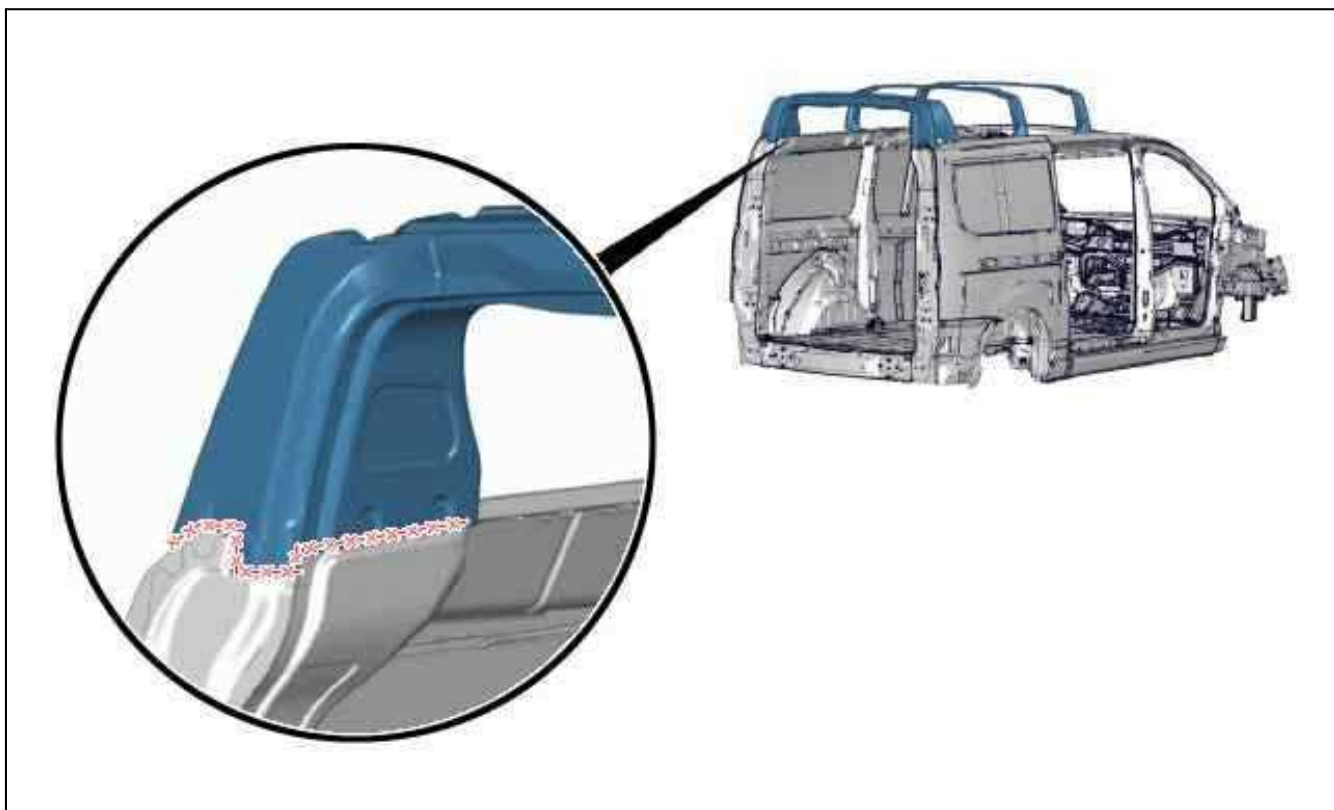


Figure : C4EP1A7D

Cut the filling adhesive (Symmetrical operation).
Remove the rear crossmember assembly.

4. Bodywork cleaning and preparation

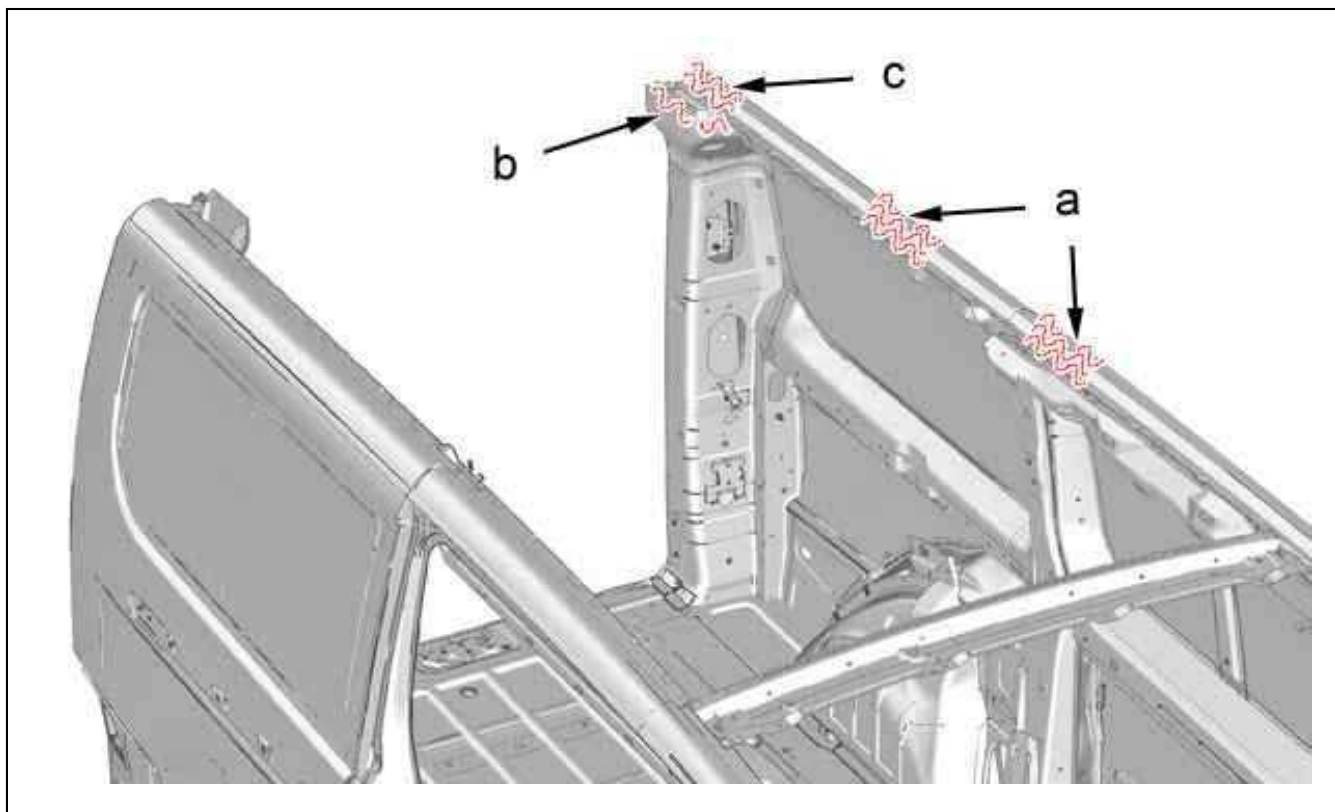


Figure : C4DP0DWD

Level off the adhesive seals .

Apply an index "B5" shimming mastic (at "a", "b", "c") ; (Symmetrical operation).

5. Adjustment

Position :

- The roof intermediate crossmember
- The roof intermediate bow
- The rear crossmember assembly

Check the fit.

6. Refitting

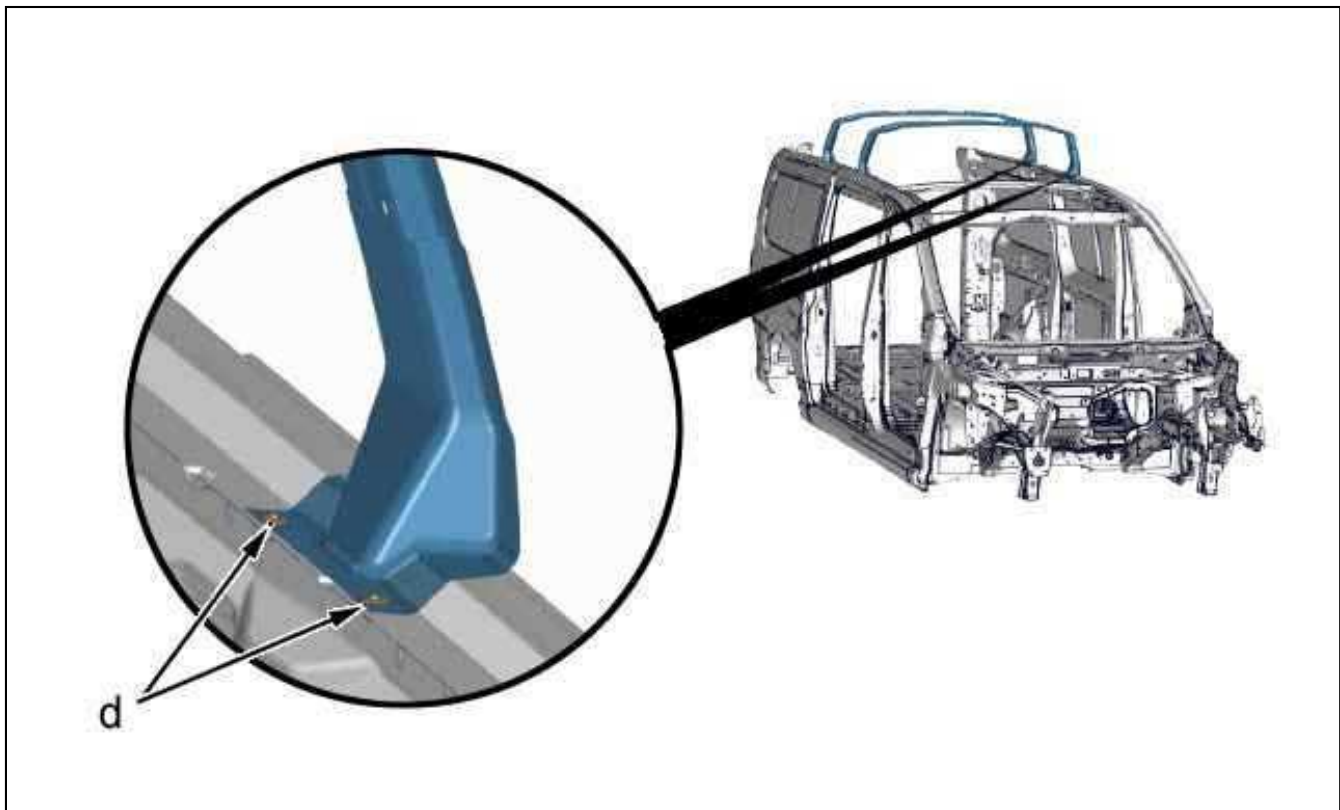


Figure : C4EP1A8D

Bond then rivet the roof bow extensions (at "d") ; (Symmetrical operation).

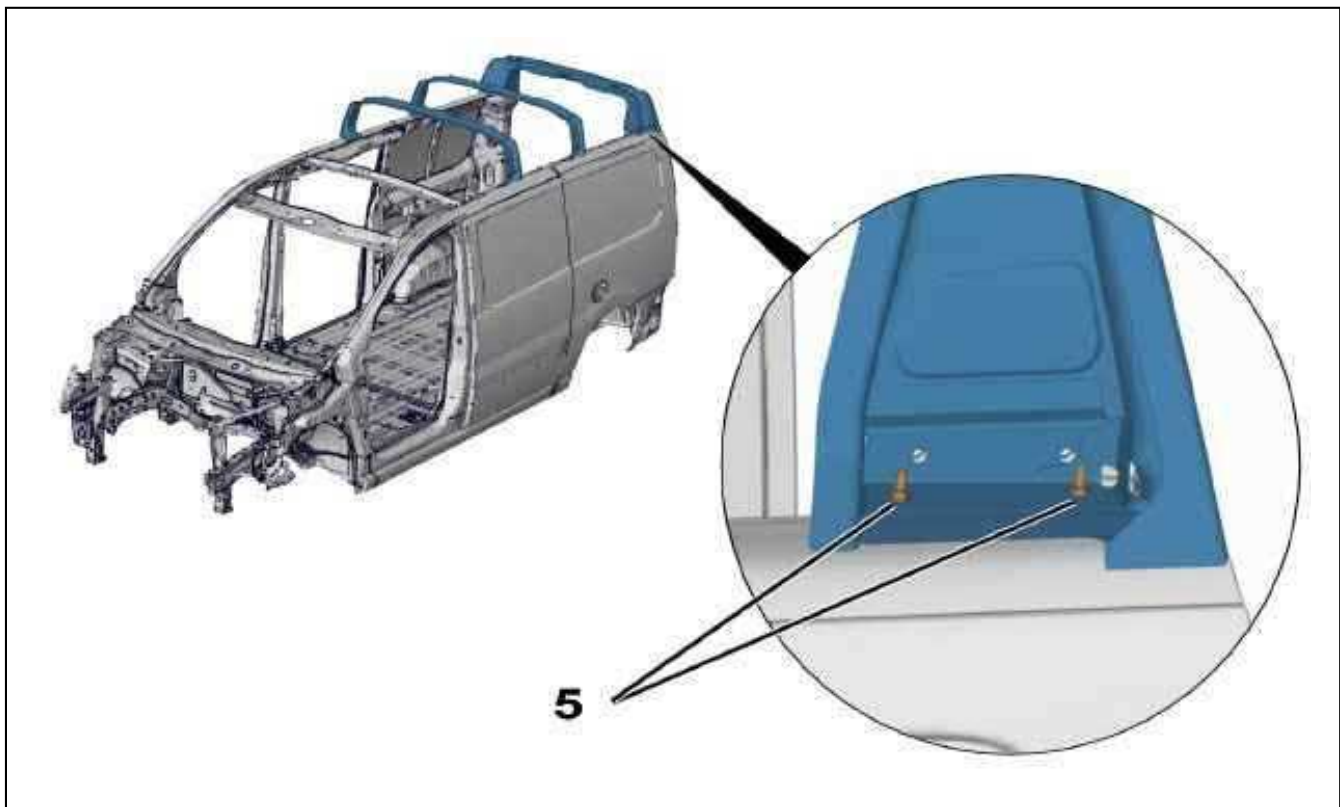


Figure : C4EP1A4D

Bond the roof rear crossmember then screw on the nuts (5) (Symmetrical operation).

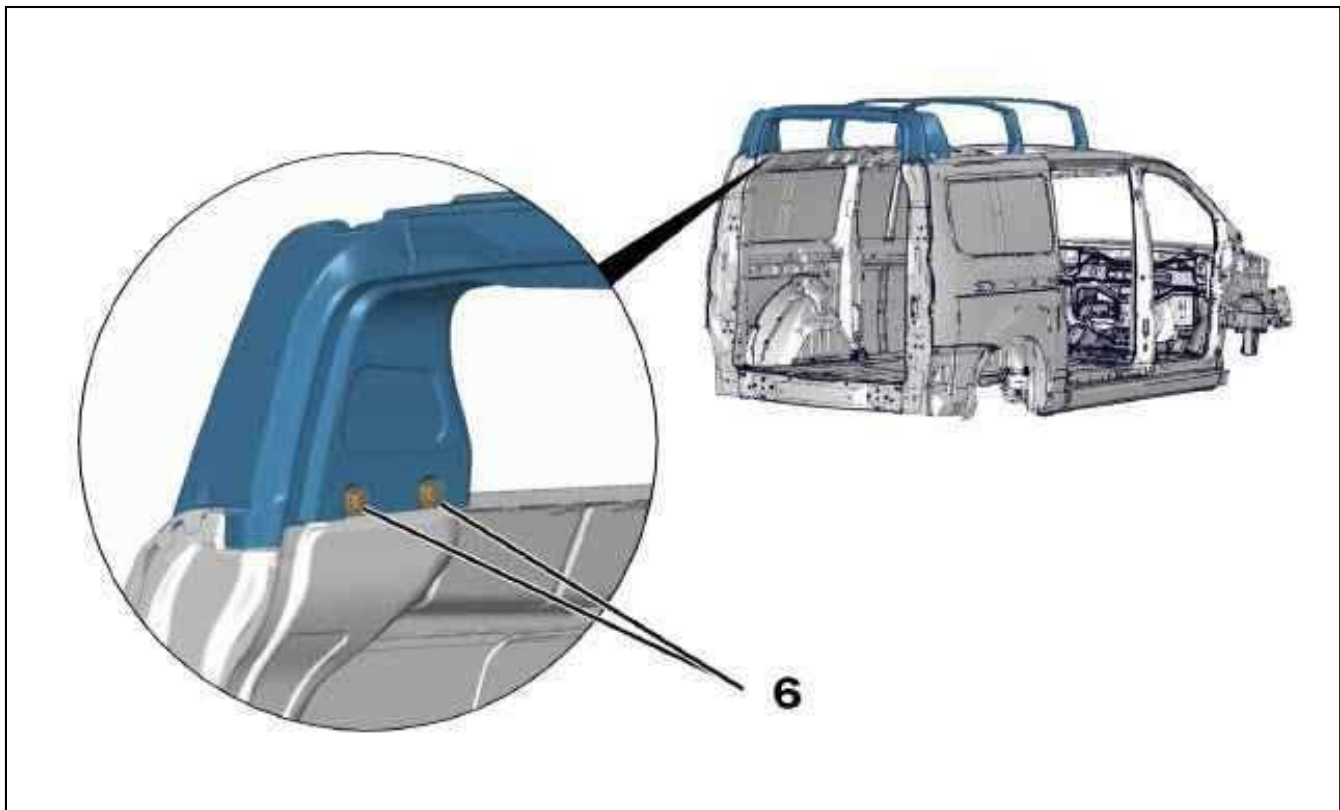


Figure : C4EP1A6D

Screw on the nuts (6) (Symmetrical operation).

7. Sealing protection

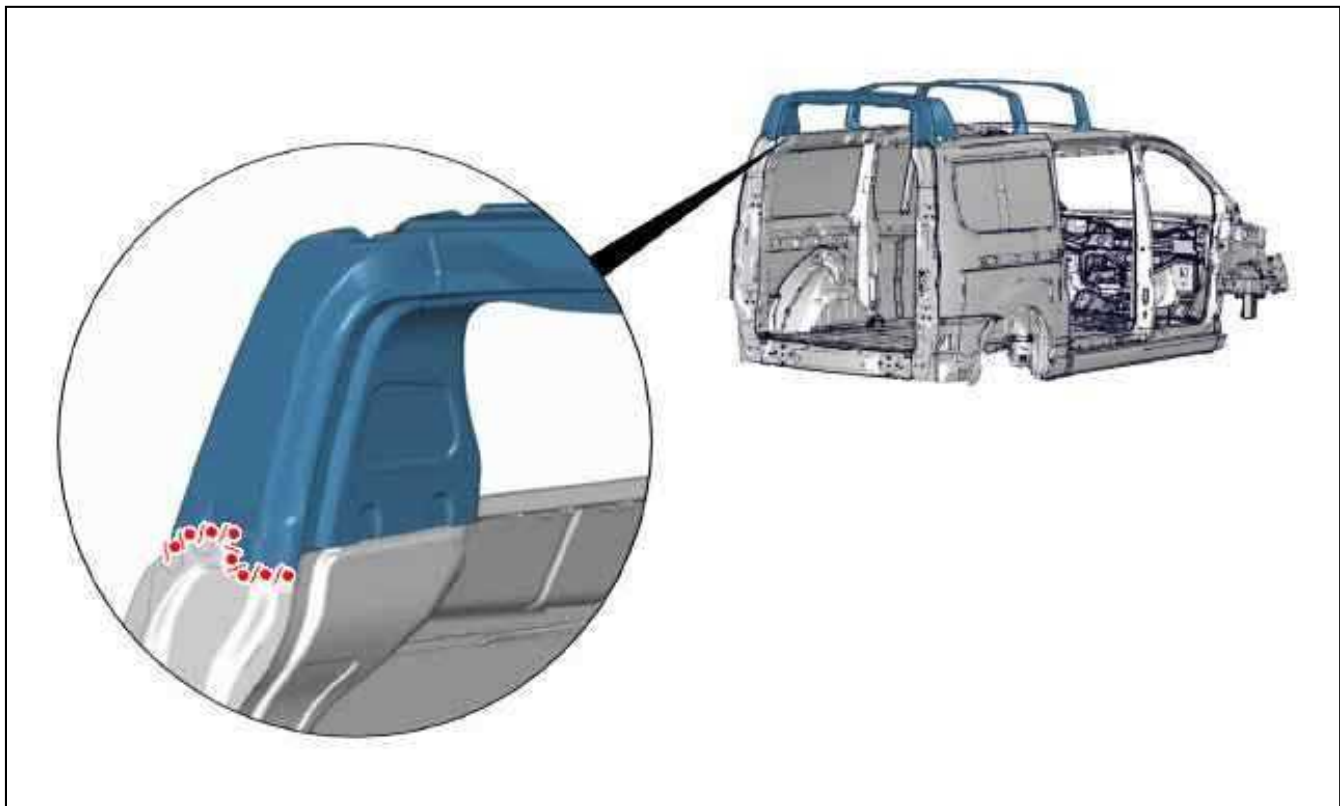


Figure : C4EP1A9D

Apply a sealing mastic : index "A4".

8. Reinitialisation

Carry out the additional operations.

RESISTANCE WELDING PARAMETERS : PASSENGER COMPARTMENT SIDE STRENGTHENERS AND INNER PANELS

ESSENTIAL : Depending on the operation to be carried out, observe the instructions for chocking up the vehicle.

ESSENTIAL : Deactivate the pneumatic suspension before lifting the vehicle ⓘ (2 or 4 post lift, workshop jack or customer's jack ⓘ).

CAUTION : All of the stripped surfaces must be protected by means of the approved electrolytic rezincing process .

ESSENTIAL : Observe the elementary rules of hygiene and safety (wear a face mask to protect against fumes and vapour - work in a well ventilated space).

1. Introduction

Key :

- ADX : soft steel
- HLE : high-strength steel
- THLE: very high-strength steel

The welding parameter values indicated are validated with the stations approved by the manufacturer.

The welding parameters are applied on coated panels and may vary in relation to the following criteria :

- Power of the workshop's electrical and pneumatic equipment
- Type of anti-corrosion protection applied to the components to be welded (weldable primer or index "C8" electrolytic re-zincing)
- Thickness of the weld-through primer used for the preparation of the mating edges
- Nature of the weldable primer (zinc, aluminium or copper)
- Quality of the preparation of the lining up of the welded edges on the components replaced
- Diameter of the spot weld to be applied

N.B. : The diameter of the spot weld applied must be identical and correspond to the diameter of the original spot weld

3 electrode arm lengths are approved on all of the welding stations :

- 120 mm
- 260 mm
- 400 mm

CAUTION : Before carrying out a welding operation on the vehicle, check the settings of the welding station (spot weld removal test).

Use the test specimens available from the parts department :

- kit : Reference 97 80 46
- Sample kit refills : Reference 97 80 20

Carry out the spot weld removal test before each change of :

- Of panel stack
- Of grade of steel
- Of panel thickness

2. Side panel front reinforcement

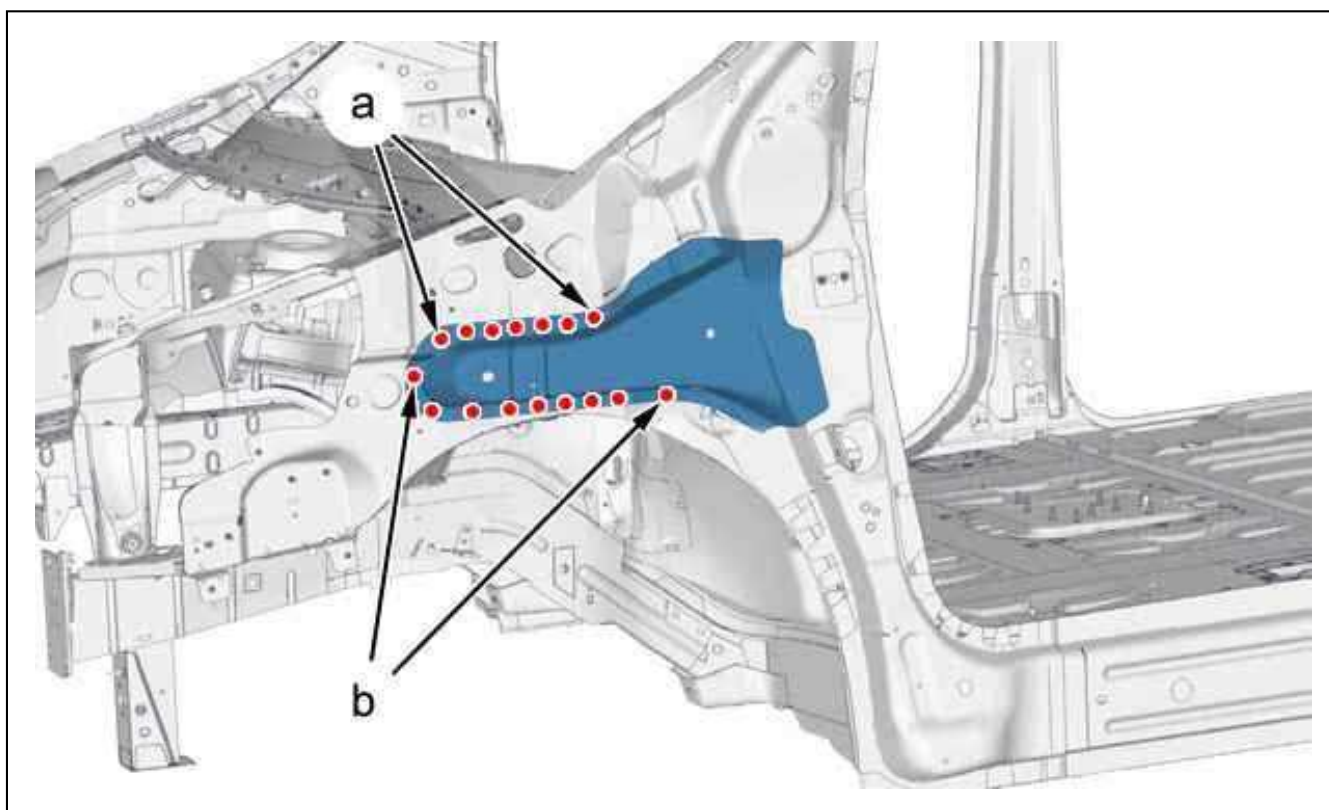


Figure : C4AM00ND

Weld with electric spot welds.

Electrodes = 120 mm (Symmetrical welding)						
Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"a"	7	0,97/1,47	ADX/HLE	450	11300	800
"b"	9	0,97/1,47/1,47	ADX/HLE/HLE	450	11300	800

Electrodes = 260 mm (Symmetrical welding)						
Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"a"	7	0,97/1,47	ADX/HLE	208	9500	850
"b"	9	0,97/1,47/1,47	ADX/HLE/HLE	208	9500	850

Electrodes = 400 mm (Symmetrical welding)						
Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"a"	7	0,97/1,47	ADX/HLE	135	850	9500
"b"	9	0,97/1,47/1,47	ADX/HLE/HLE	135	850	9500

3. Front pillar strengthener

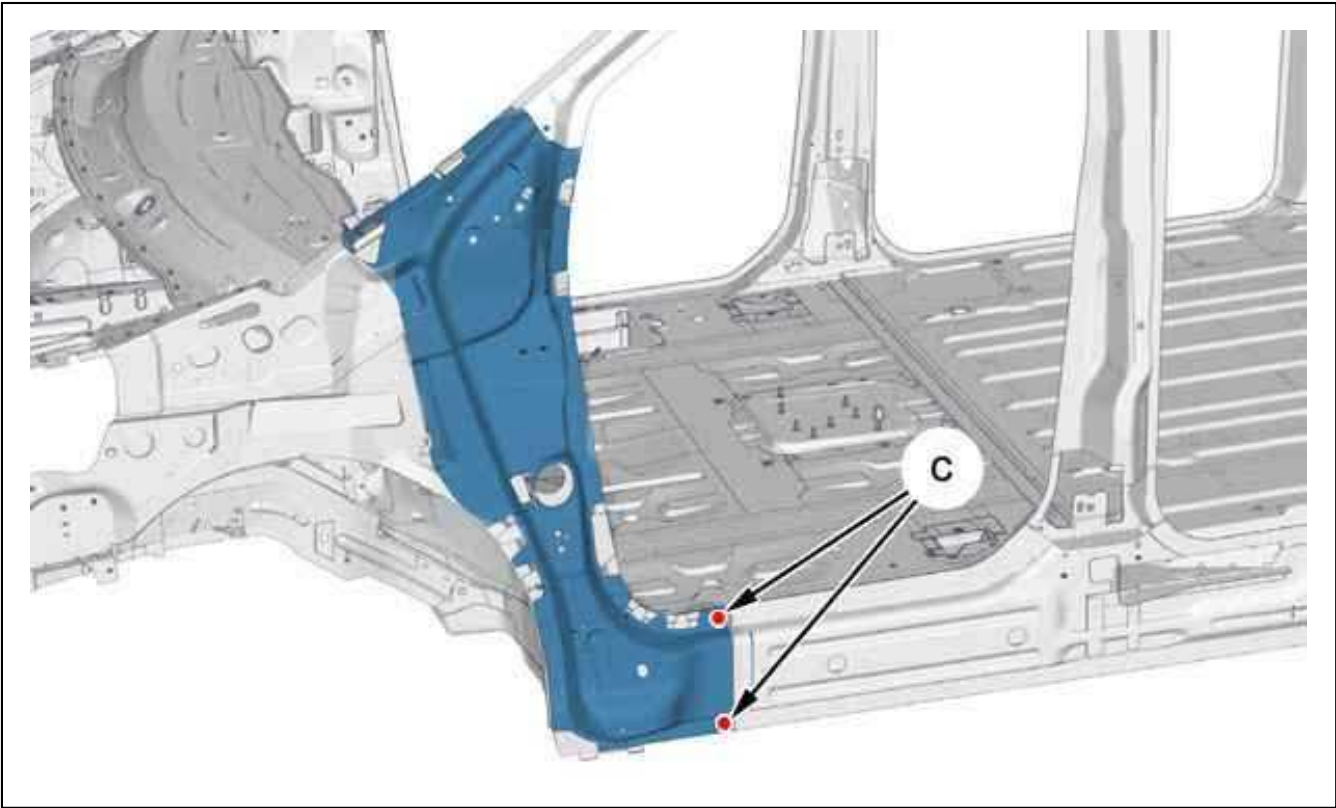


Figure : C4AM00PD

N.B. : Spot weld lines are welded with the passenger compartment side ⓘ .

Electrodes = 120 mm (Symmetrical welding)						
Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"c"	2	1,76/1,17/1,17	HLE/ADX/ADX	350	11300	450

Electrodes = 260 mm (Symmetrical welding)						
Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"c"	2	1,76/1,17/1,17	HLE/ADX/ADX	208	9600	700

Electrodes = 400 mm (Symmetrical welding)						
Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"c"	2	1,76/1,17/1,17	HLE/ADX/ADX	135	9600	700

4. Front wing inner panel extension

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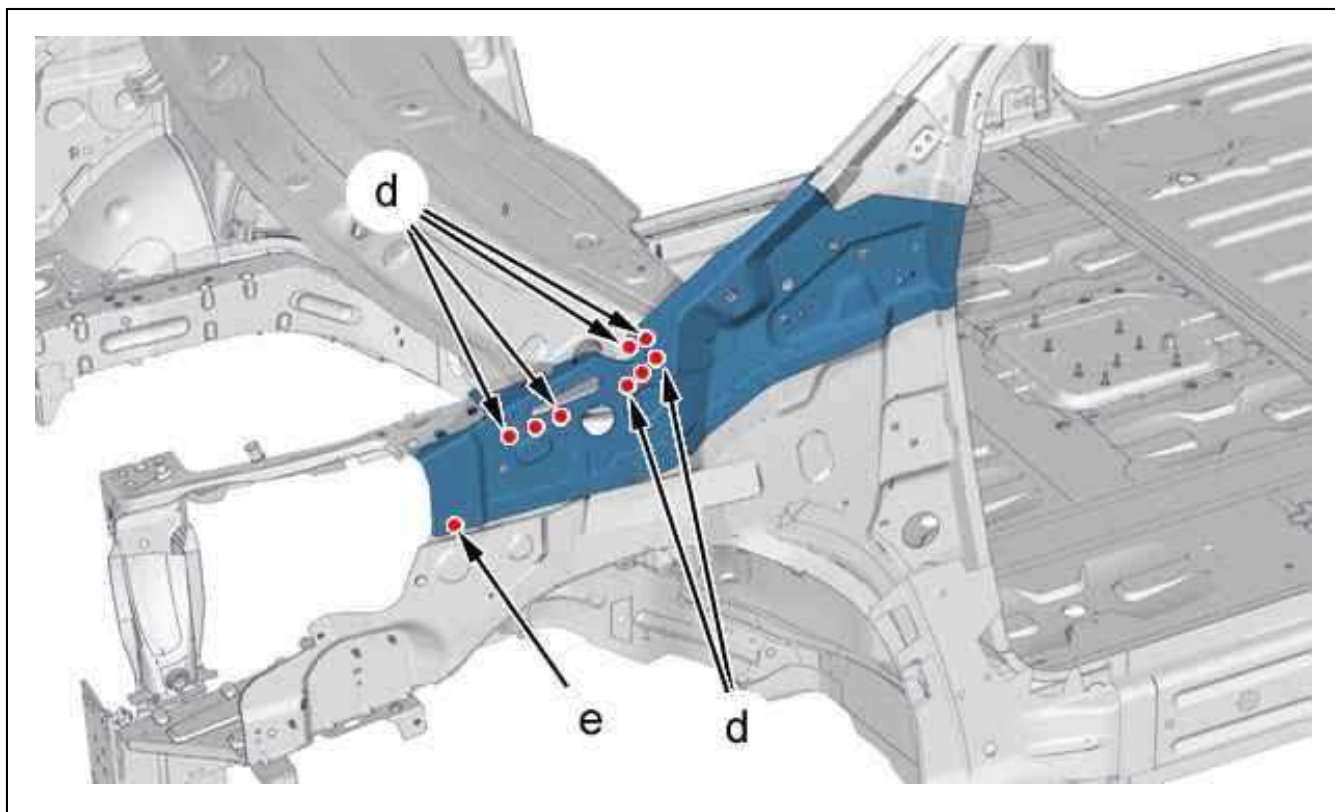


Figure : C4AM00QD

Electrodes = 120 mm (Symmetrical welding)						
Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"d"	8	1,47/0,97	HLE/ADX	350	11300	450
"e"	1	1,47/0,97/0,67	HLE/ADX/ADX	350	11300	450

Electrodes = 260 mm (Symmetrical welding)						
Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"d"	8	1,47/0,97	HLE/ADX	208	9600	700
"e"	1	1,47/0,97/0,67	HLE/ADX/ADX	208	9600	700

Electrodes = 400 mm (Symmetrical welding)						
Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"d"	8	1,47/0,97	HLE/ADX	135	9600	700
"e"	1	1,47/0,97/0,67	HLE/ADX/ADX	135	9600	700

5. Front wing inner panel

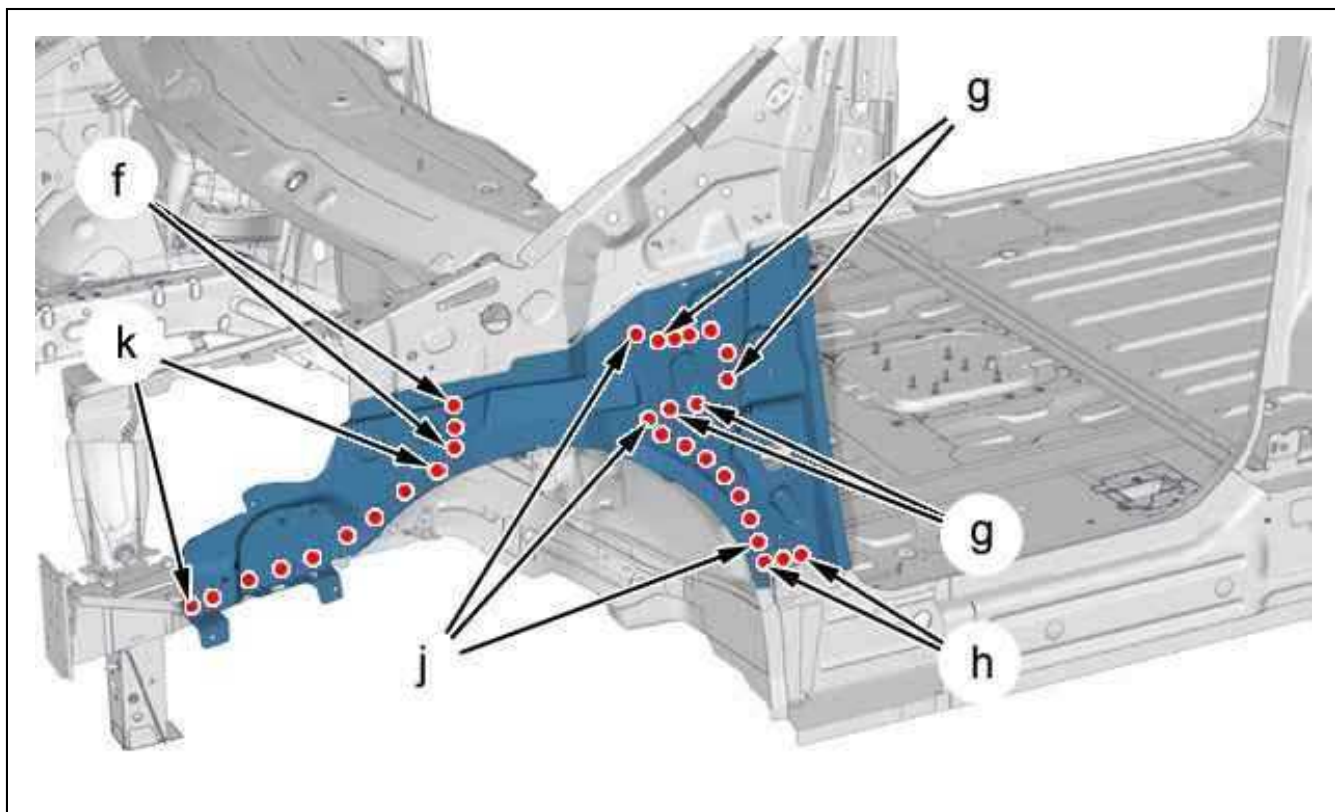


Figure : C4AM00RD

Electrodes = 120 mm (Symmetrical welding)						
Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"f"	3	1,47/1,17	HLE/ADX	350	11300	450
"g"	8	1,47/1,47	HLE/ADX	450	11300	800
"h"	3	1,47/1,17	HLE/ADX	350	11300	450
"j"	9	1,47/0,97	HLE/ADX	350	11300	450
"k"	9	1,47/0,77	HLE/ADX	350	11300	450

Electrodes = 260 mm (Symmetrical welding)						
Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"f"	3	1,47/1,17	HLE/ADX	208	700	9600
"g"	8	1,47/1,47	HLE/ADX	208	850	9500
"h"	3	1,47/1,17	HLE/ADX	208	700	9600
"j"	9	1,47/0,97	HLE/ADX	208	700	9600
"k"	9	1,47/0,77	HLE/ADX	208	700	9600

Electrodes = 400 mm (Symmetrical welding)						
Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"f"	3	1,47/1,17	HLE/ADX	135	9500	850
"g"	8	1,47/1,47	HLE/ADX	135	9600	700
"h"	3	1,47/1,17	HLE/ADX	135	9500	850
"j"	9	1,47/0,97	HLE/ADX	135	9500	850
"k"	9	1,47/0,77	HLE/ADX	135	9500	850

6. Windscreen pillar web (windscreen) - Windscreen pillar inner panel - Centre pillar stiffener

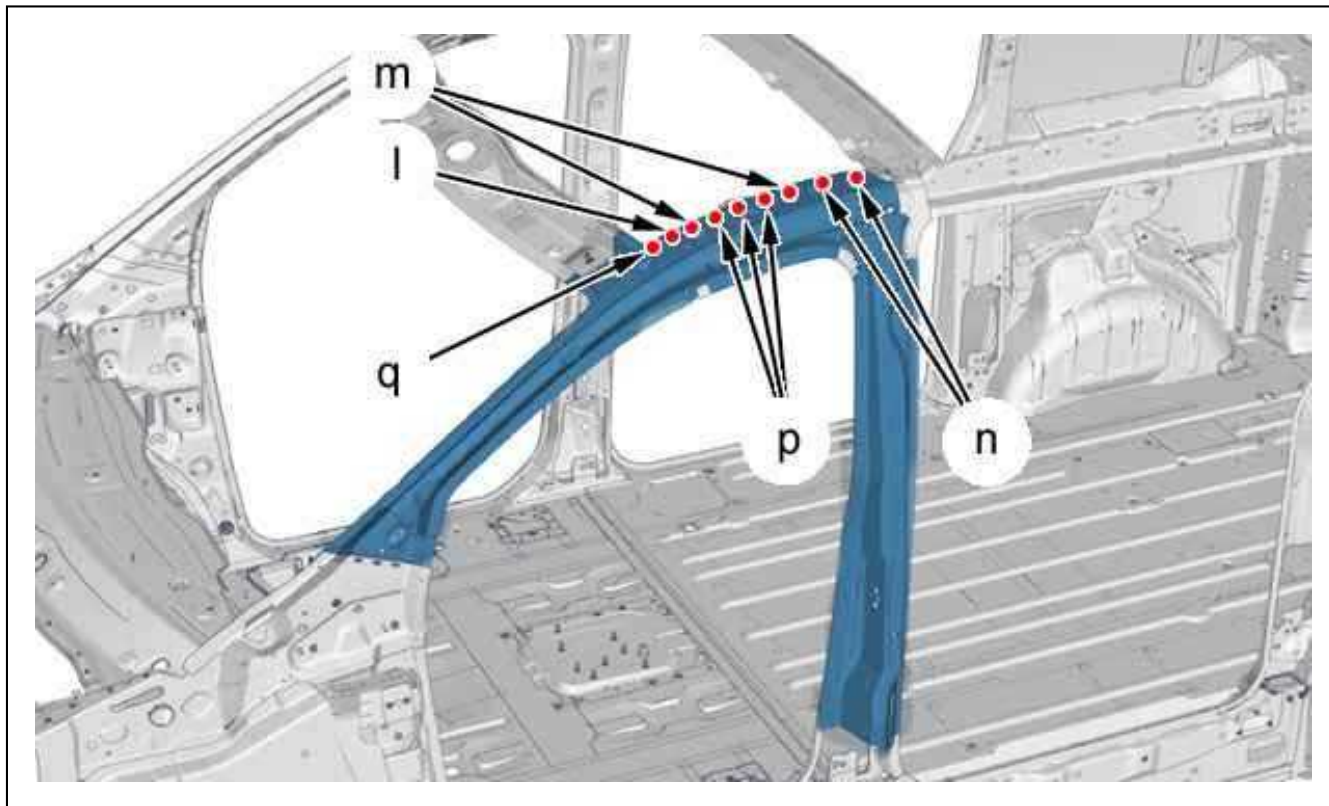


Figure : C4CM027D

N.B. : Spot weld lines are welded with the passenger compartment side  ; Lines of spot welds are welded with the roof, the crossmembers and the roll-over hoops .

Electrodes = 120 mm (Symmetrical welding)						
Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"l"	1	1,17/1,17/1,47	HLE/HLE/ADX	350	11300	450
"m"	2	1,17/1,47/1,47	HLE/ADX/ADX	450	11300	800
"n"	2	1,17/1,76/1,47	HLE/HLE/ADX	450	11300	800
"p"	3	1,17/1,47/1,47	HLE/ADX/ADX	450	11300	800
"q"	1	1,17/1,17	HLE/HLE	350	11300	450

Electrodes = 260 mm (Symmetrical welding)						
Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"l"	1	1,17/1,17/1,47	HLE/HLE/ADX	208	9600	700
"m"	2	1,17/1,47/1,47	HLE/ADX/ADX	208	9500	850
"n"	2	1,17/1,76/1,47	HLE/HLE/ADX	208	9500	850
"p"	3	1,17/1,47/1,47	HLE/ADX/ADX	208	9500	850
"q"	1	1,17/1,17	HLE/HLE	208	9600	700

Electrodes = 400 mm (Symmetrical welding)						

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"l"	1	1,17/1,17/1,47	HLE/HLE/ADX	135	9600	700
"m"	2	1,17/1,47/1,47	HLE/ADX/ADX	135	9500	850
"n"	2	1,17/1,76/1,47	HLE/HLE/ADX	135	9500	850
"p"	3	1,17/1,47/1,47	HLE/ADX/ADX	135	9500	850
"q"	1	1,17/1,17	HLE/HLE	135	9600	700

7. Passenger compartment side stiffener

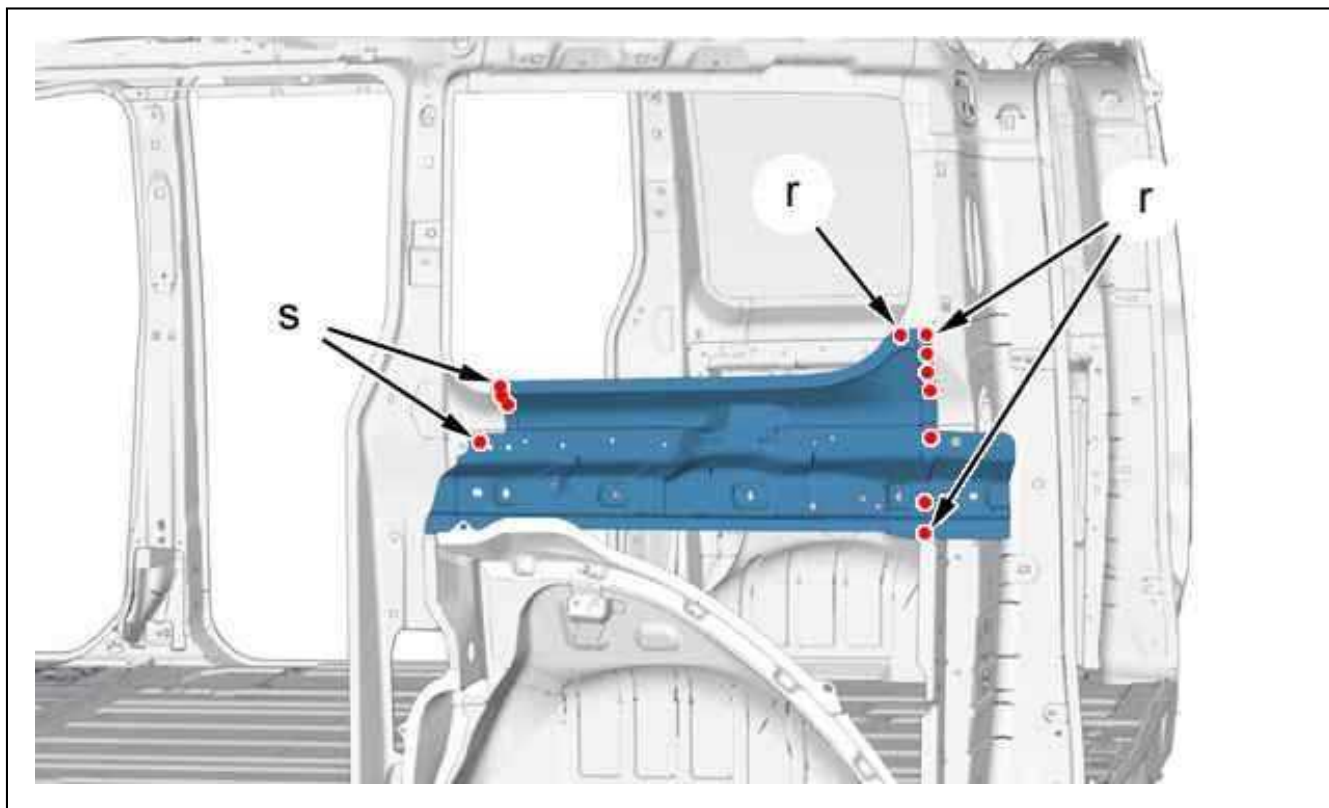


Figure : C4CM028D

Electrodes = 120 mm (Symmetrical welding)

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"r"	8	0,77/1,17	ADX/ADX	350	11300	450
"s"	4	0,77/1,17	ADX/ADX	350	11300	450

Electrodes = 260 mm (Symmetrical welding)

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"r"	8	0,77/1,17	ADX/ADX	208	9600	700
"s"	4	0,77/1,17	ADX/ADX	208	9600	700

Electrodes = 400 mm (Symmetrical welding)

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"r"	8	0,77/1,17	ADX/ADX	135	9600	700
"s"	4	0,77/1,17	ADX/ADX	135	9600	700

8. Rear wheel arch upper part - Front section of the rear wheelarch

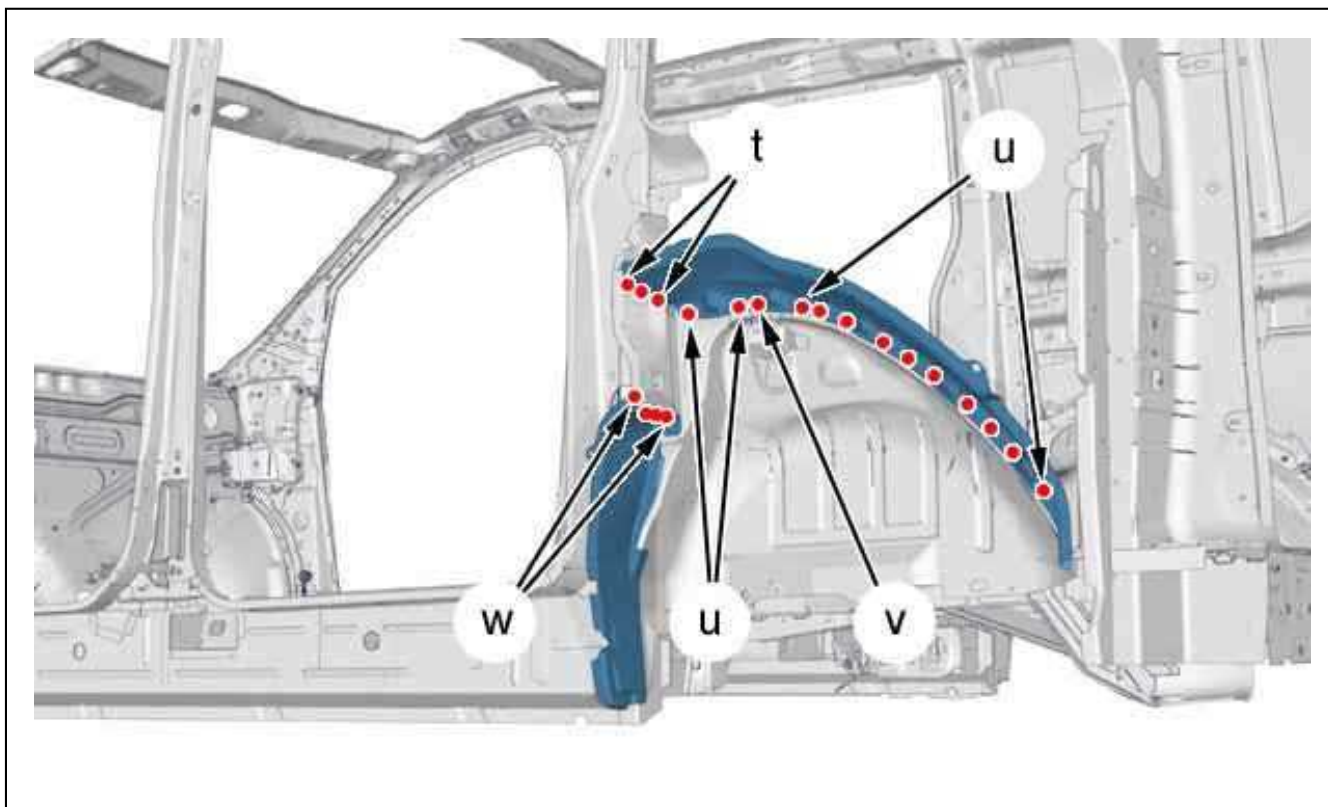


Figure : C4BM017D

Electrodes = 120 mm (Symmetrical welding)

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"t"	3	0,77/1,17	ADX/ADX	350	11300	450
"u"	12	0,77/1,17	ADX/ADX	350	11300	450
"v"	1	0,77/0,77/1,17	ADX/ADX/ADX	350	11300	450
"w"	4	0,77/1,17	ADX/ADX	350	11300	450

Electrodes = 260 mm (Symmetrical welding)

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"t"	3	0,77/1,17	ADX/ADX	208	700	9600
"u"	12	0,77/1,17	ADX/ADX	208	700	9600
"v"	1	0,77/0,77/1,17	ADX/ADX/ADX	208	700	9600
"w"	4	0,77/1,17	ADX/ADX	208	700	9600

Electrodes = 400 mm (Symmetrical welding)

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"t"	3	0,77/1,17	ADX/ADX	135	700	9600
"u"	12	0,77/1,17	ADX/ADX	135	700	9600
"v"	1	0,77/0,77/1,17	ADX/ADX/ADX	135	700	9600
"w"	4	0,77/1,17	ADX/ADX	135	700	9600

9. Rear wheelarch

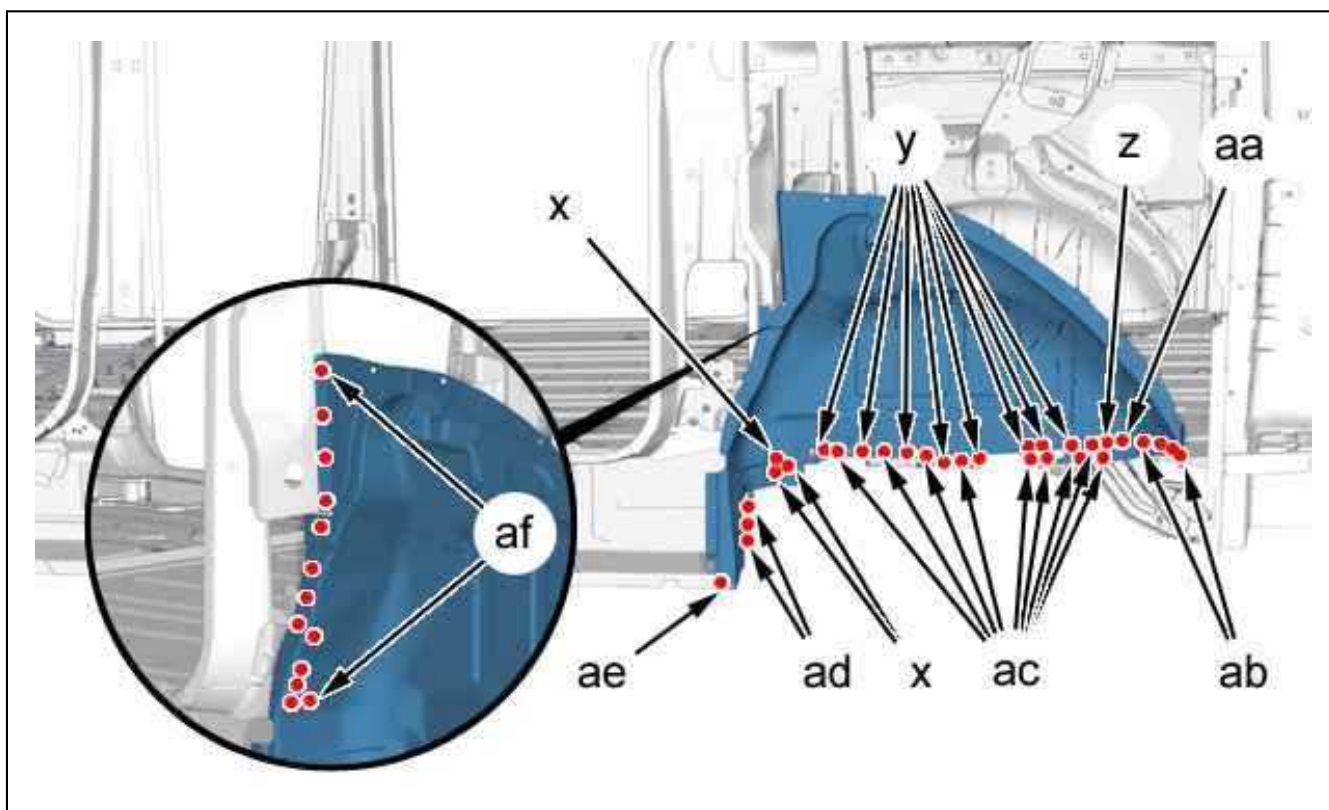


Figure : C4BM061D

Electrodes = 120 mm (Symmetrical welding)						
Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"x"	3	1,17/1,95	ADX/HLE	450	11300	800
"y"	8	1,17/0,77/1,95	ADX/HLE/HLE	350	11300	450
"z"	1	1,17/0,77	ADX/HLE	350	11300	450
"aa"	1	1,17/0,77/0,77	ADX/ADX/HLE	350	11300	450
"ab"	4	1,17/0,77	ADX/ADX	350	11300	450
"ac"	9	1,17/0,77	ADX/HLE	350	11300	450
"ad"	3	1,17/1,17/1,76	ADX/ADX/HLE	350	11300	450
"ae"	1	1,17/1,17	ADX/ADX	350	11300	450
"af"	13	1,17/1,17	ADX/ADX	350	11300	450

Electrodes = 260 mm (Symmetrical welding)						
Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"x"	3	1,17/1,95	ADX/HLE	208	9500	850
"y"	8	1,17/0,77/1,95	ADX/HLE/HLE	208	9600	700
"z"	1	1,17/0,77	ADX/HLE	208	9600	700
"aa"	1	1,17/0,77/0,77	ADX/ADX/HLE	208	9600	700
"ab"	4	1,17/0,77	ADX/ADX	208	9600	700
"ac"	9	1,17/0,77	ADX/HLE	208	9600	700
"ad"	3	1,17/1,17/1,76	ADX/ADX/HLE	208	9600	700

"ae"	1	1,17/1,17	ADX/ADX	208	9600	700
"af"	13	1,17/1,17	ADX/ADX	208	9600	700

Electrodes = 400 mm (Symmetrical welding)						
Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"x"	3	1,17/1,95	ADX/HLE	135	9500	850
"y"	8	1,17/0,77/1,95	ADX/HLE/HLE	135	9600	700
"z"	1	1,17/0,77	ADX/HLE	135	9600	700
"aa"	1	1,17/0,77/0,77	ADX/ADX/HLE	135	9600	700
"ab"	4	1,17/0,77	ADX/ADX	135	9600	700
"ac"	9	1,17/0,77	ADX/HLE	135	9600	700
"ad"	3	1,17/1,17/1,76	ADX/ADX/HLE	135	9600	700
"ae"	1	1,17/1,17	ADX/ADX	135	9600	700
"af"	13	1,17/1,17	ADX/ADX	135	9600	700

10. Tailgate pillar

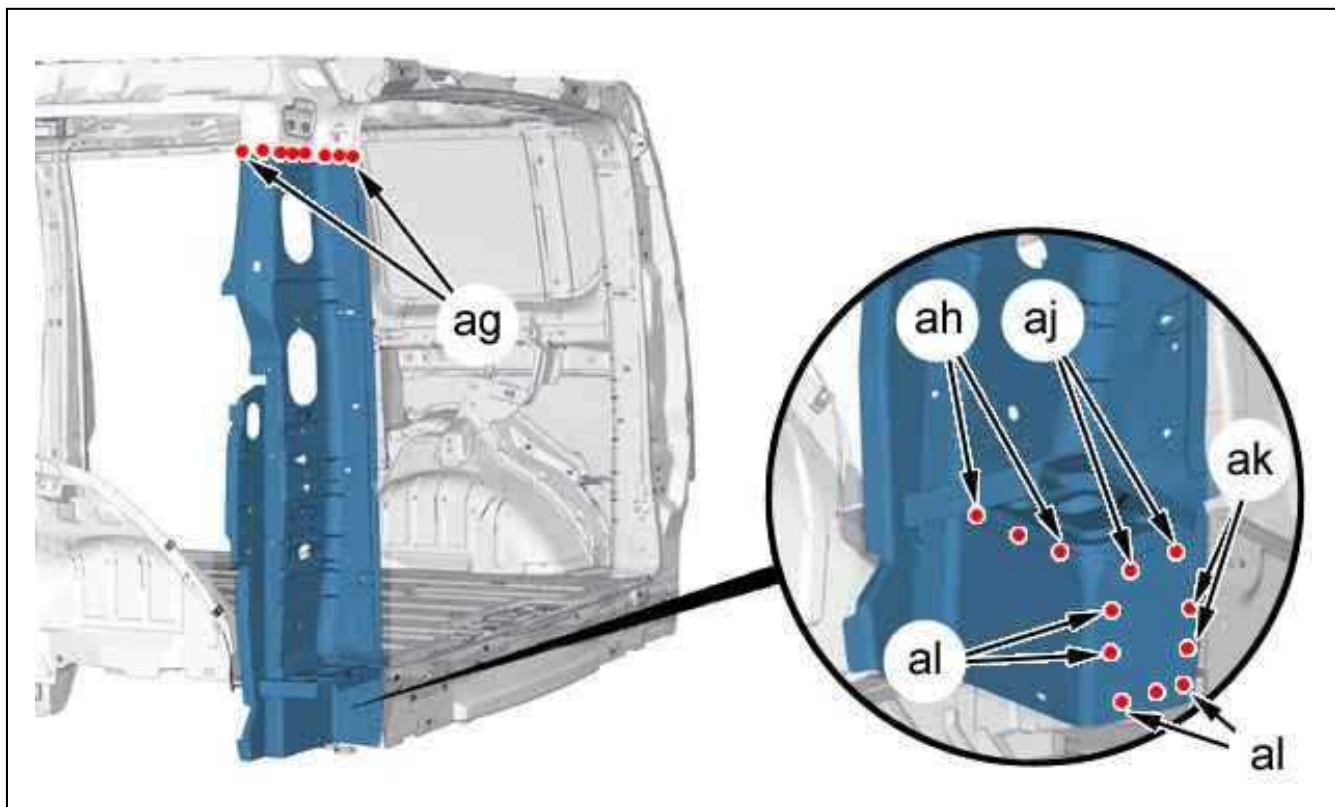


Figure : C4BM018D

N.B. : Spot weld lines are welded with the passenger compartment side ⓘ.

Electrodes = 120 mm (Symmetrical welding)						
Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"ag"	8	1,17/1,76	ADX/HLE	450	11300	800
"ah"	3	1,17/1,17/0,77	ADX/ADX/ADX	350	11300	450

"aj"	2	1,17/0,77	ADX/HLE	350	11300	450
"ak"	2	1,17/1,76	ADX/ADX	450	11300	800
"al"	5	1,17/1,47	ADX/ADX	450	11300	800

Electrodes = 260 mm (Symmetrical welding)

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"ag"	8	1,17/1,76	ADX/HLE	208	9500	850
"ah"	3	1,17/1,17/0,77	ADX/ADX/ADX	208	9600	700
"aj"	2	1,17/0,77	ADX/HLE	208	9600	700
"ak"	2	1,17/1,76	ADX/ADX	208	9500	850
"al"	5	1,17/1,47	ADX/ADX	208	9500	850

Electrodes = 400 mm (Symmetrical welding)

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"ag"	8	1,17/1,76	ADX/HLE	135	9500	850
"ah"	3	1,17/1,17/0,77	ADX/ADX/ADX	135	9600	700
"aj"	2	1,17/0,77	ADX/HLE	135	9600	700
"ak"	2	1,17/1,76	ADX/ADX	135	9500	850
"al"	5	1,17/1,47	ADX/ADX	135	9500	850

11. Cantrail inner panel (rear) - Tailgate rear upper gutter

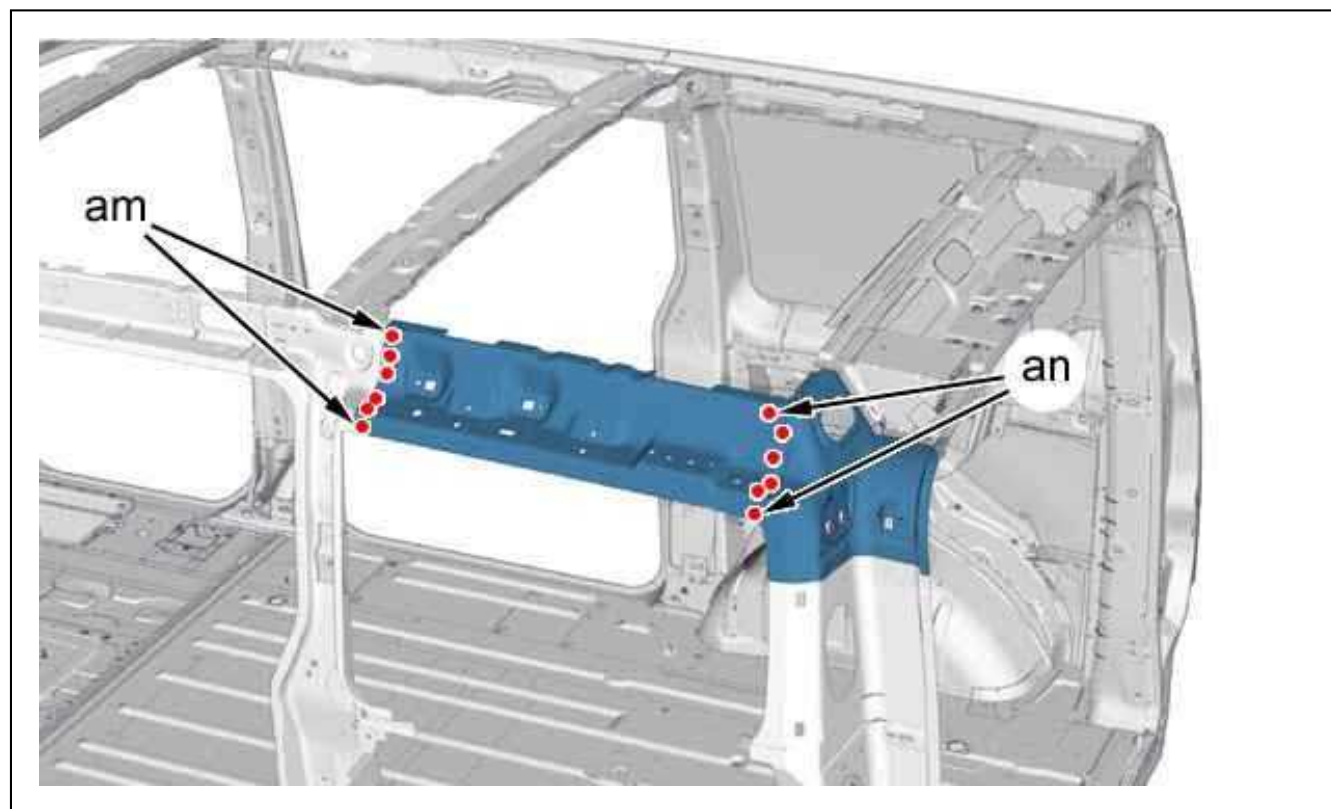


Figure : C4BM019D

N.B. : Spot weld lines are welded with the passenger compartment side ⓘ .

Electrodes = 120 mm (Symmetrical welding)

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"am"	6	1,47/1,17	ADX/ADX	350	11300	450
"an"	6	1,47/1,76	ADX/HLE	450	11300	800

Electrodes = 260 mm (Symmetrical welding)

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"am"	6	1,47/1,17	ADX/ADX	208	9600	700
"an"	6	1,47/1,76	ADX/HLE	208	9500	850

Electrodes = 400 mm (Symmetrical welding)

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"am"	6	1,47/1,17	ADX/ADX	135	9600	700
"an"	6	1,47/1,76	ADX/HLE	135	9500	850

12. Rear pillar

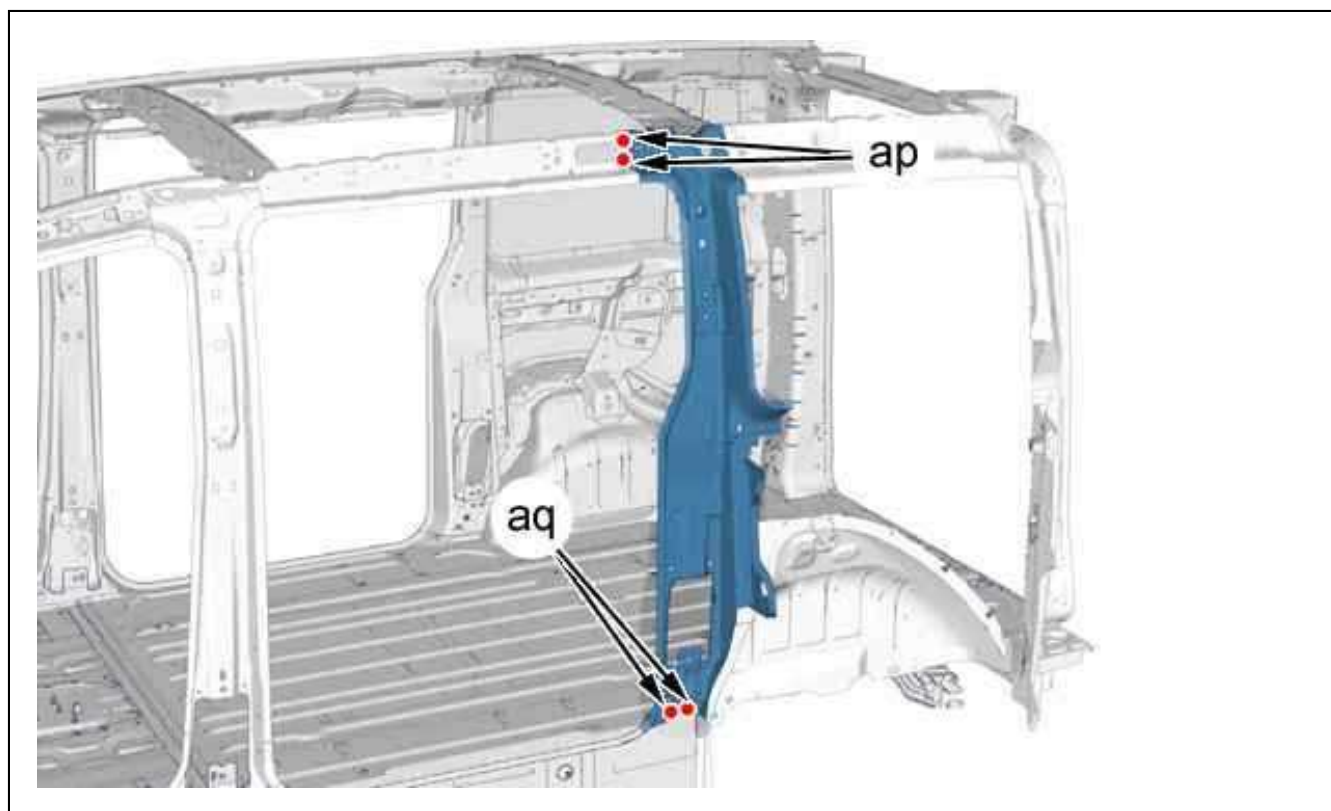


Figure : C4BM01AD

N.B. : Spot weld lines are welded with the passenger compartment side ⓘ .

Electrodes = 120 mm (Symmetrical welding)

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"ap"	2	1,47/1,17	ADX/ADX	350	11300	450
"aq"	2	1,17/1,17/0,77	ADX/ADX/HLE	350	11300	450

Electrodes = 260 mm (Symmetrical welding)

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"ap"	2	1,47/1,17	ADX/ADX	208	9600	700
"aq"	2	1,17/1,17/ 0,77	ADX/ADX/HLE	208	9600	700

Electrodes = 400 mm (Symmetrical welding)

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"ap"	2	1,47/1,17	ADX/ADX	135	9600	700
"aq"	2	1,17/1,17/0,77	ADX/ADX/HLE	135	9600	700

13. Centre pillar inner panel

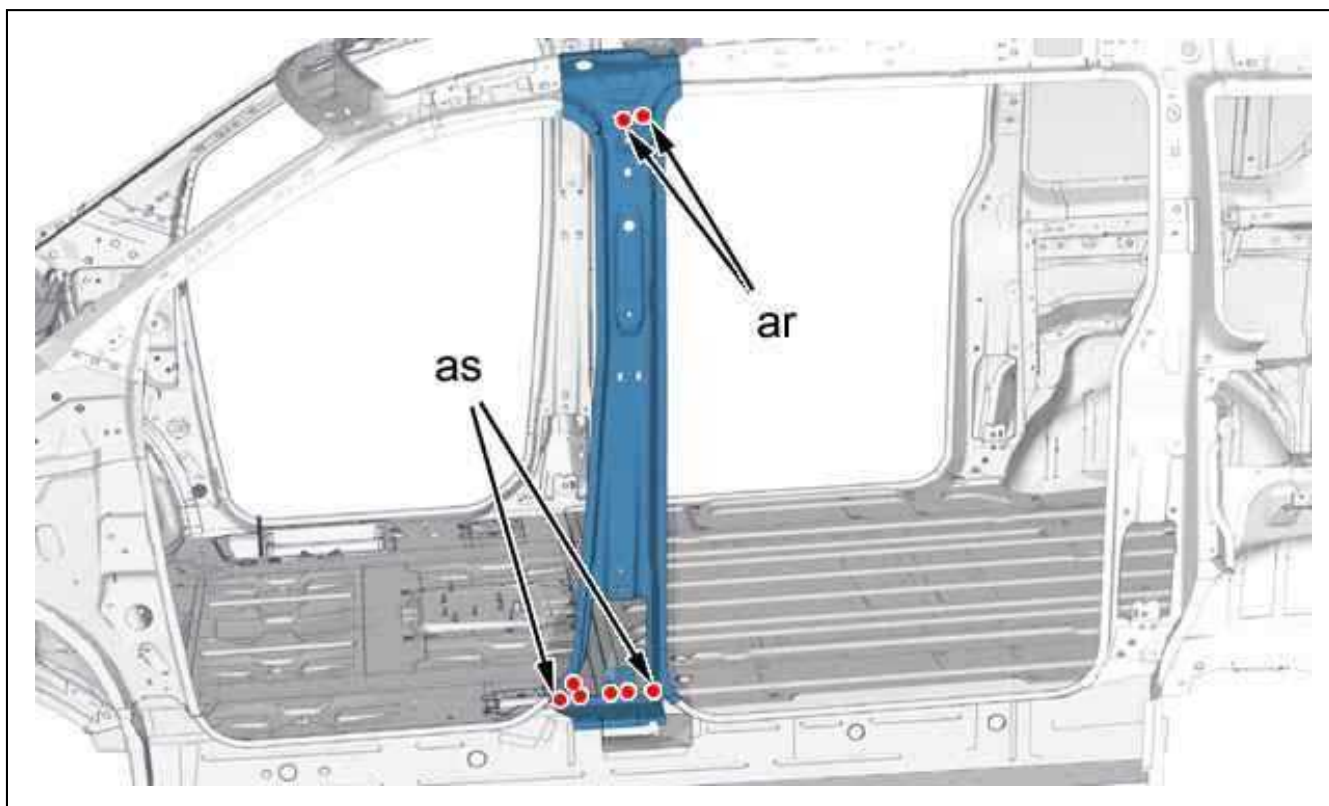


Figure : C4CM029D

N.B. : Spot weld lines are welded with the passenger compartment side ⓘ.

Electrodes = 120 mm (Symmetrical welding)

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"ar"	2	1,76/1,47	HLE/ADX	450	11300	800
"as"	6	1,76/1,95/1,17	HLE/HLE/ADX	450	11300	800

Electrodes = 260 mm (Symmetrical welding)

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"ar"	2	1,76/1,47	HLE/ADX	208	9500	850
"as"	6	1,76/1,95/1,17	HLE/HLE/ADX	208	9500	850

Electrodes = 400 mm (Symmetrical welding)						
Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"ar"	2	1,76/1,47	HLE/ADX	135	9500	850
"as"	6	1,76/1,95/1,17	HLE/HLE/ADX	135	9500	850

14. Cantrail inner panel

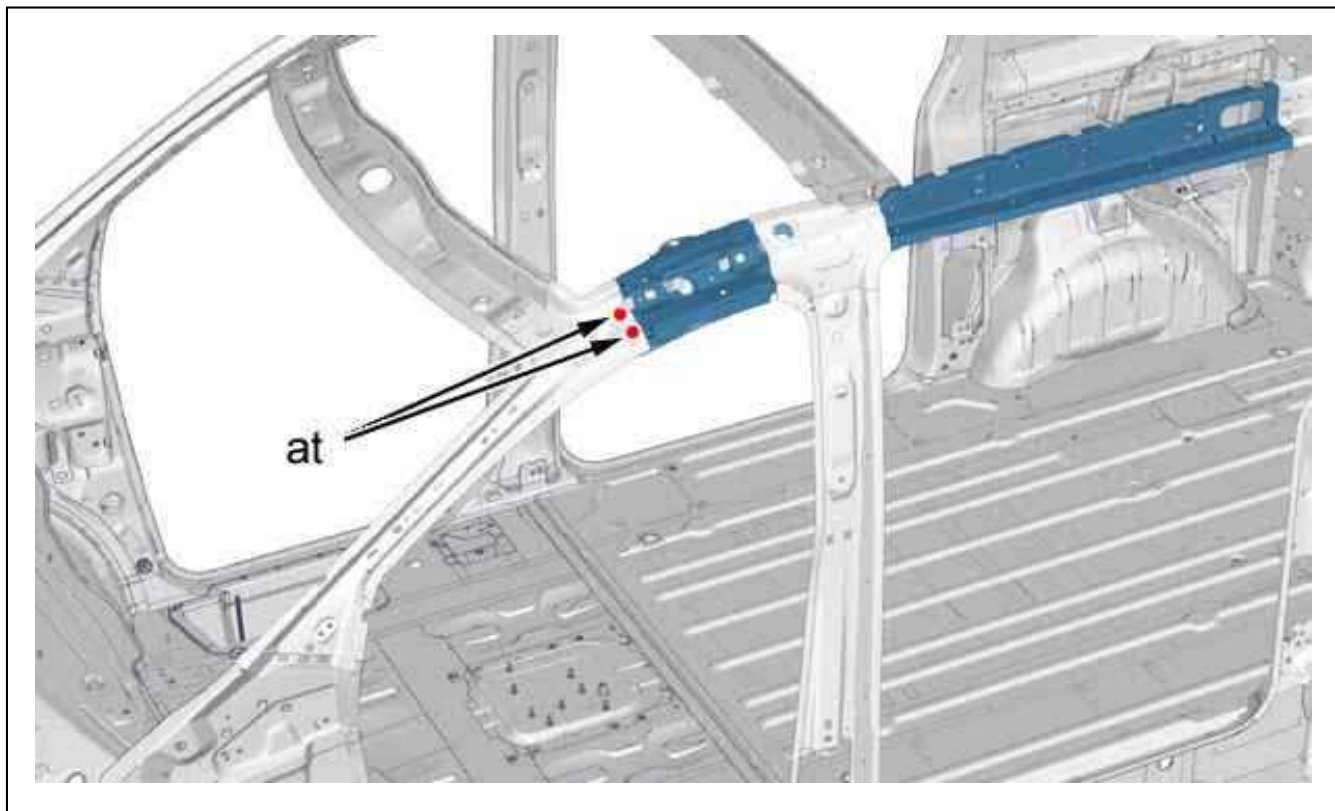


Figure : C4CM02AD

Electrodes = 120 mm (Symmetrical welding)						
Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"at"	2	1,17/1,47	HLE/ADX	450	11300	800

Electrodes = 260 mm (Symmetrical welding)						
Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"at"	2	1,17/1,47	HLE/ADX	208	850	9500

Electrodes = 400 mm (Symmetrical welding)						
Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"at"	2	1,17/1,47	HLE/ADX	135	9500	800

15. Inner sill

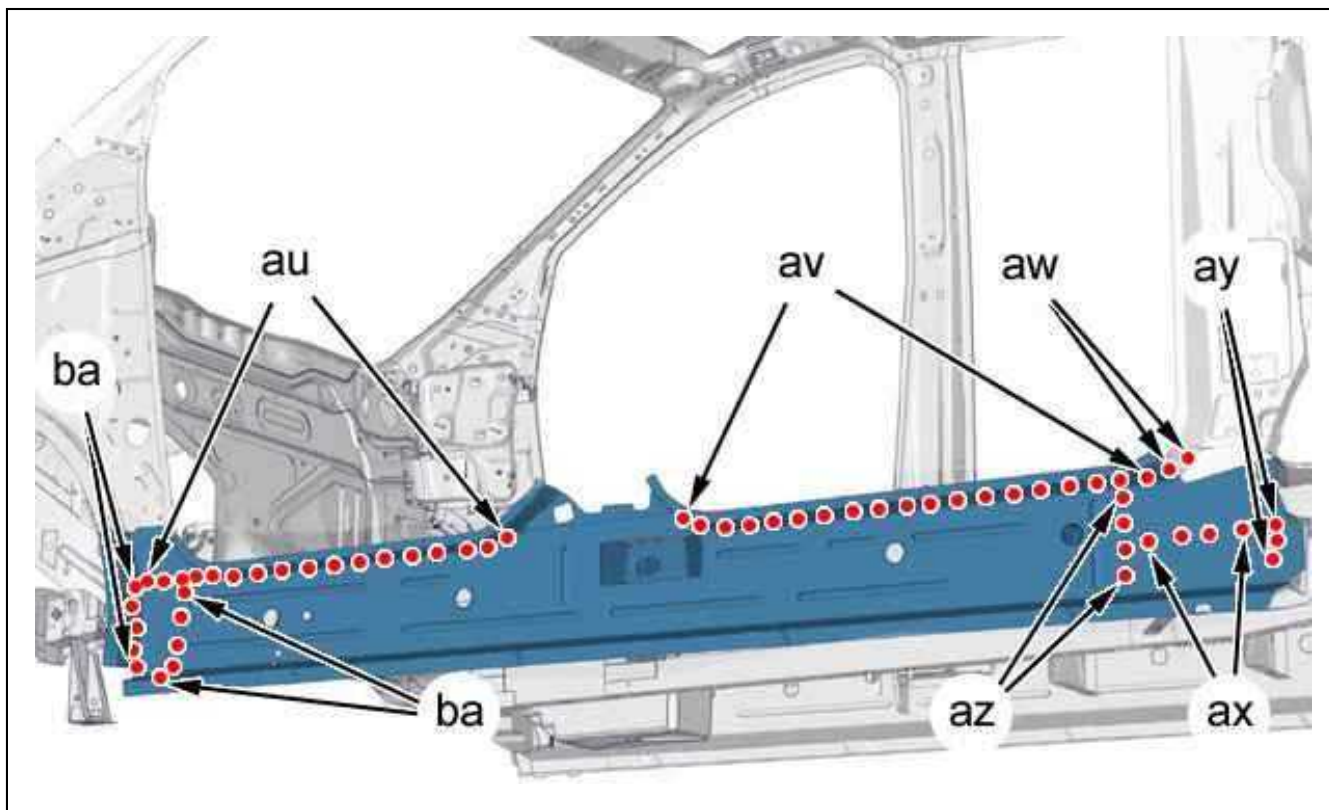


Figure : C4CM02BD

N.B. : Spot weld lines are welded with the passenger compartment side ⓘ .

Electrodes = 120 mm (Symmetrical welding)						
Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"au"	17	1,17/0,67	ADX/ADX	350	11300	450
"av"	19	1,17/0,77	ADX/HLE	350	11300	450
"aw"	2	1,17/1,17	ADX/ADX	350	11300	450
"ax"	4	1,17/1,95	ADX/HLE	450	11300	800
"ay"	3	1,17/1,76	ADX/HLE	450	11300	800
"az"	4	1,17/1,47	ADX/HLE	450	11300	800
"ba"	10	1,17/1,17	ADX/ADX	350	11300	450

Electrodes = 260 mm (Symmetrical welding)						
Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"au"	17	1,17/0,67	ADX/ADX	208	9600	700
"av"	19	1,17/0,77	ADX/HLE	208	9600	700
"aw"	2	1,17/1,17	ADX/ADX	208	9600	700
"ax"	4	1,17/1,95	ADX/HLE	208	9500	850
"ay"	3	1,17/1,76	ADX/HLE	208	9500	850
"az"	4	1,17/1,47	ADX/HLE	208	9500	850
"ba"	10	1,17/1,17	ADX/ADX	208	9600	700

Electrodes = 400 mm (Symmetrical welding)						
Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)

"au"	17	1,17/0,67	ADX/ADX	135	9600	700
"av"	19	1,17/0,77	ADX/HLE	135	9600	700
"aw"	2	1,17/1,17	ADX/ADX	135	9600	700
"ax"	4	1,17/1,95	ADX/HLE	135	9500	850
"ay"	3	1,17/1,76	ADX/HLE	135	9500	850
"az"	4	1,17/1,47	ADX/HLE	135	9500	850
"ba"	10	1,17/1,17	ADX/ADX	135	9600	700

16. Rear wheelarch closing panel

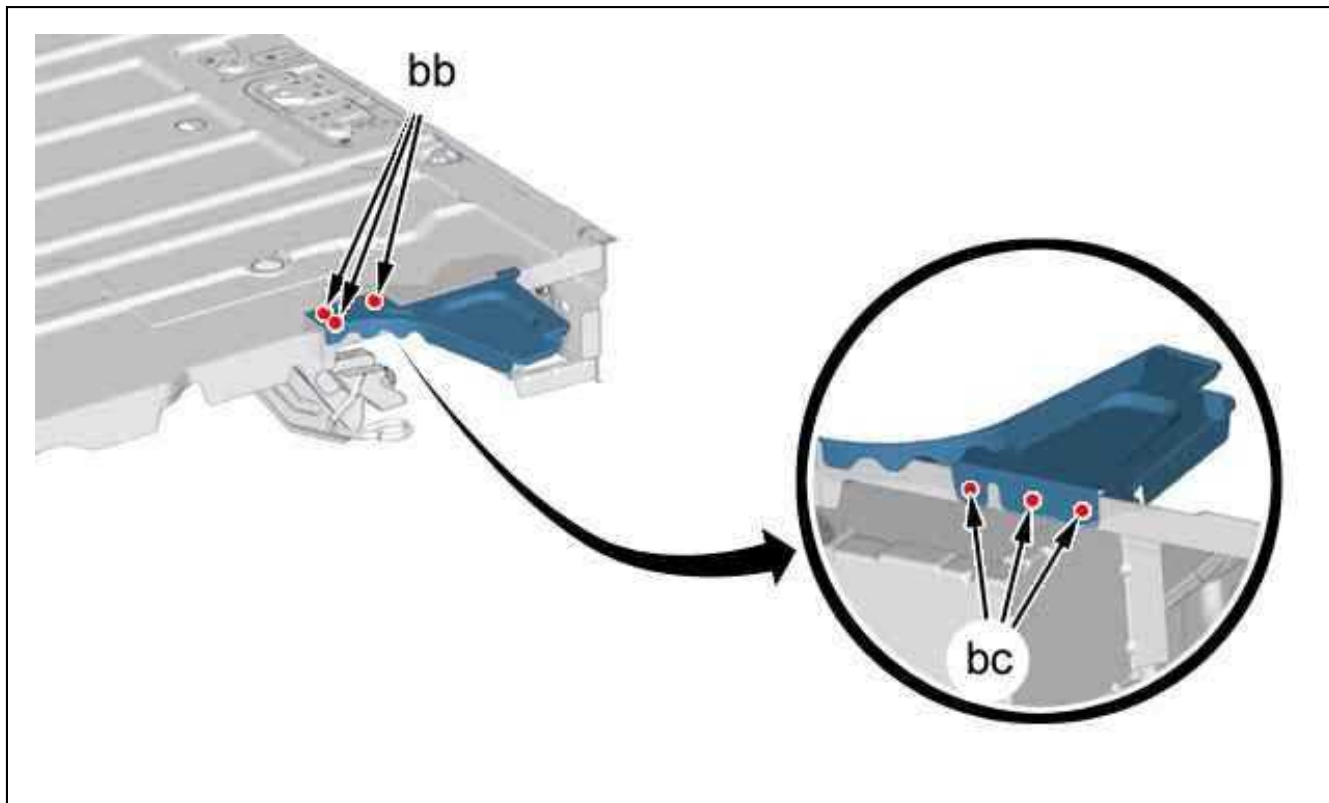


Figure : C4BM01BD

Electrodes = 120 mm (Symmetrical welding)						
Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"bb"	3	0,77/0,77	ADX/HLE	350	11300	450
"bc"	3	0,77/0,77	ADX/HLE	350	11300	450

Electrodes = 260 mm (Symmetrical welding)						
Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"bb"	3	0,77/0,77	ADX/HLE	208	9600	700
"bc"	3	0,77/0,77	ADX/HLE	208	9600	700

Electrodes = 400 mm (Symmetrical welding)						
Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"bb"	3	0,77/0,77	ADX/HLE	135	9600	700

"bc"	3	0,77/0,77	ADX/HLE	135	9600	700
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RESISTANCE WELDING PARAMETERS : FRONT STRUCTURE

ESSENTIAL : Depending on the operation to be carried out, observe the instructions for chocking up the vehicle.

ESSENTIAL : Deactivate the pneumatic suspension before lifting the vehicle ⓘ (2 or 4 post lift, workshop jack or customer's jack).

CAUTION : All of the stripped surfaces must be protected by means of the approved electrolytic re-zincing process .

ESSENTIAL : Observe the elementary rules of hygiene and safety (wear a face mask to protect against fumes and vapour - work in a well ventilated space).

1. Introduction

Key :

- ADX : soft steel
- HLE : high-strength steel
- THLE : Very high-strength steel

The welding parameter values indicated are validated with the stations approved by the manufacturer.

The welding parameters are applied on coated panels and may vary in relation to the following criteria :

- Power of the workshop's electrical and pneumatic equipment
- Type of anticorrosion protection applied to the components to be welded Weld-through primer or index C8 electrolytic re-zincing
- Thickness of the weld-through primer used for the preparation of the mating edges
- Nature of the weldable primer (zinc, aluminium or copper)
- Quality of the preparation of the lining up of the welded edges on the components replaced
- Diameter of the spot weld to be applied

N.B. : The diameter of the spot weld applied must be identical and correspond to the diameter of the original spot weld

3 electrode arm lengths are approved on all of the welding stations :

- 120 mm
- 260 mm
- 400 mm

CAUTION : Before carrying out a welding operation on the vehicle, check the settings of the welding station (spot weld removal test).

Use the test specimens available from the parts department :

- Kit part number 978046
- Samples kit refills part number 978020

Carry out the spot weld removal test before each change of :

- Of panel stack
- Of grade of steel
- Of panel thickness

If the spot welds cannot be applied in the same way as the originals, replace the spot welds with plug welds, applied using the MAG type electric arc process, after drilling the first panel.

N.B. : The welding parameters are symmetrical.

2. Front sill section

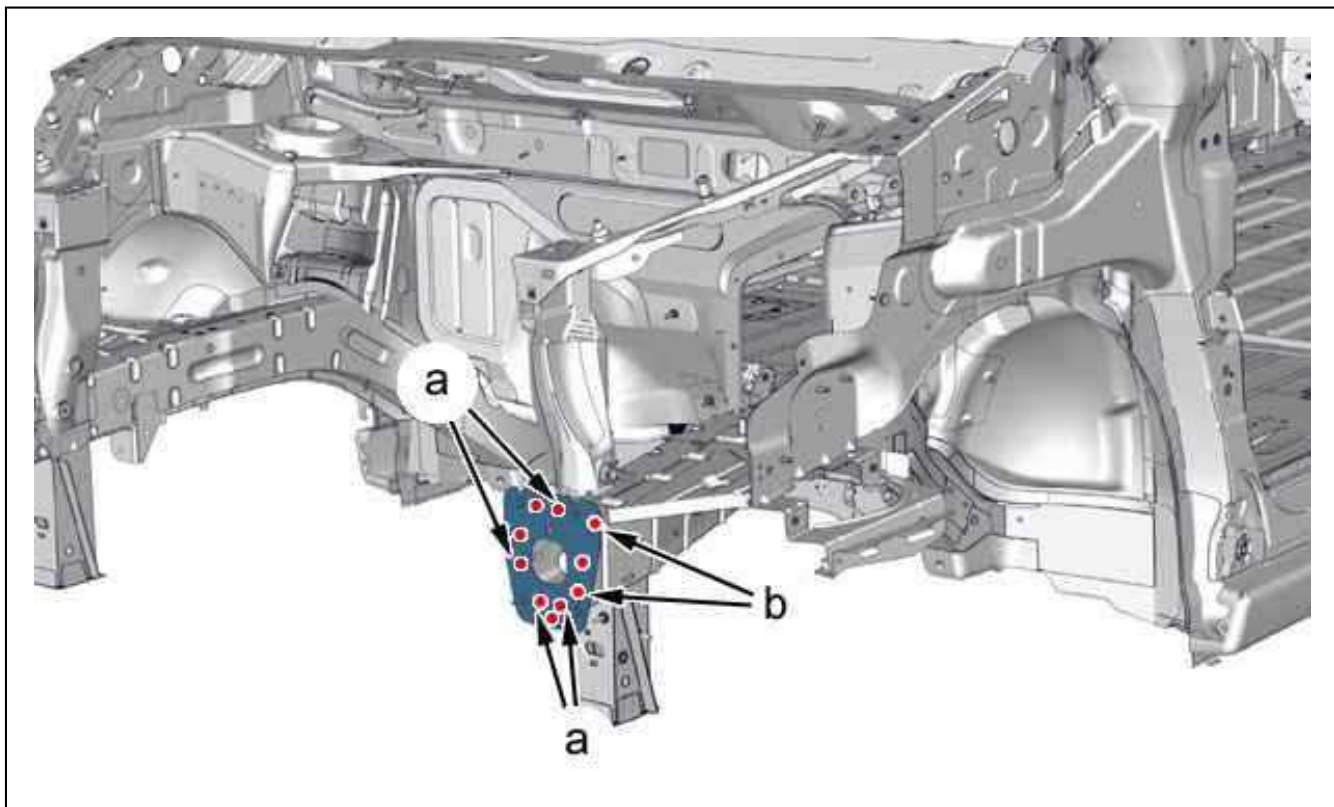


Figure : C4AP1XPD

Weld with electric spot welds.

Electrodes=120 mm (symmetrical welding).

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"a"	7	2/ 1,95	ADX/ ADX	450	11300	800
"b"	3	2/ 2,44	ADX/ HLE	450	11300	800

Electrodes=260 mm (symmetrical welding).

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"a"	7	2/ 1,95	ADX/ ADX	450	11300	800
"b"	3	2/ 2,44	ADX/ HLE	450	11300	800

Electrodes=400 mm (symmetrical welding).

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"a"	7	2/ 1,95	ADX/ ADX	450	11300	800
"b"	3	2/ 2,44	ADX/ HLE	450	11300	800

3. Engine compartment front half panel assembly

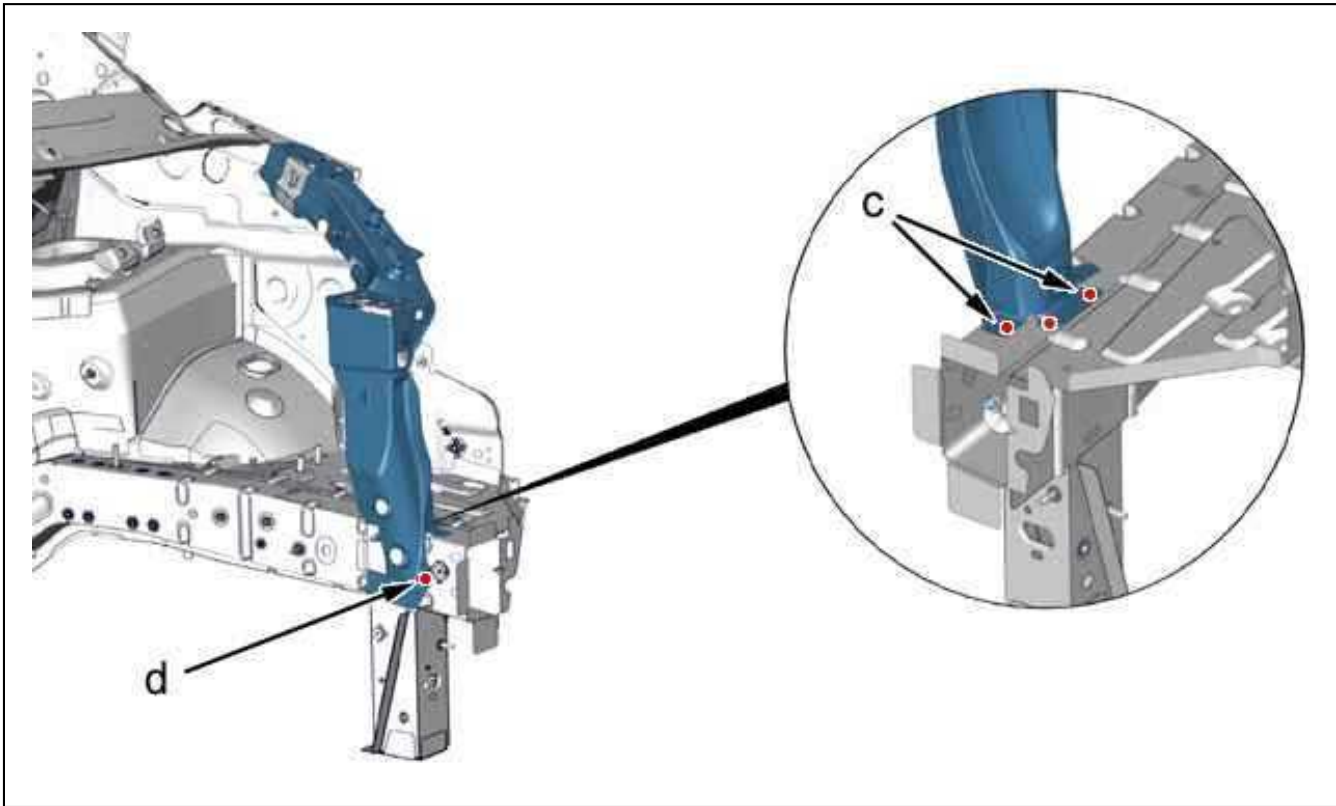


Figure : C4AP1XQD

Weld with electric spot welds.

Electrodes=120 mm (symmetrical welding).

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"c"	3	0,97/ 1,95/ 0,97	ADX/ ADX/ HLE	450	11300	800
"d"	1	0,97/ 1,95/0,97	ADX/ ADX/ HLE	450	11300	800

Electrodes=260 mm (symmetrical welding).

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"c"	3	0,97/ 1,95/ 0,97	ADX/ ADX/ HLE	208	9500	850
"d"	1	0,97/ 1,95/0,97	ADX/ ADX/ HLE	208	9500	850

Electrodes= 400 mm (symmetrical welding).

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"c"	3	0,97/ 1,95/ 0,97	ADX/ ADX/ HLE	135	9500	850
"d"	1	0,97/ 1,95/0,97	ADX/ ADX/ HLE	135	9500	850

4. Side sill closure panel- Chassis leg end piece

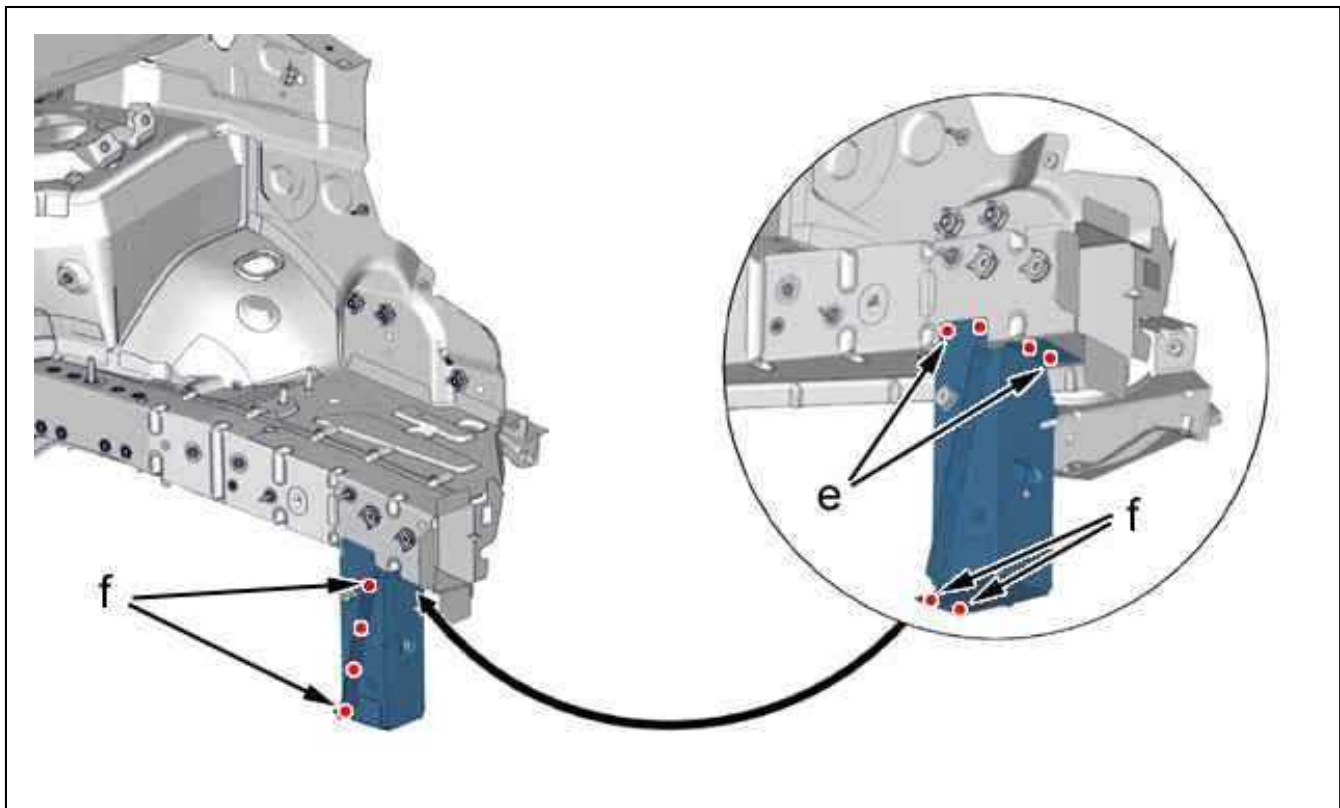


Figure : C4AP1XRD

Weld with electric spot welds.

Electrodes=120 mm (symmetrical welding).

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"e"	2	1,47/ 1,95/0,97	ADX/ ADX/ HLE	450	11300	800
"f"	6	1,47/ 1,47	ADX/ ADX	450	11300	800

Electrodes=260 mm (symmetrical welding).

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"e"	2	1,47/ 1,95/0,97	ADX/ ADX/ HLE	208	9500	850
"f"	6	1,47/ 1,47	ADX/ ADX	208	9500	850

Electrodes= 400 mm (symmetrical welding).

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"e"	2	1,47/ 1,95/0,97	ADX/ ADX/ HLE	135	9500	850
"f"	6	1,47/ 1,47	ADX/ ADX	135	9500	850

5. Front wheelarch assembly

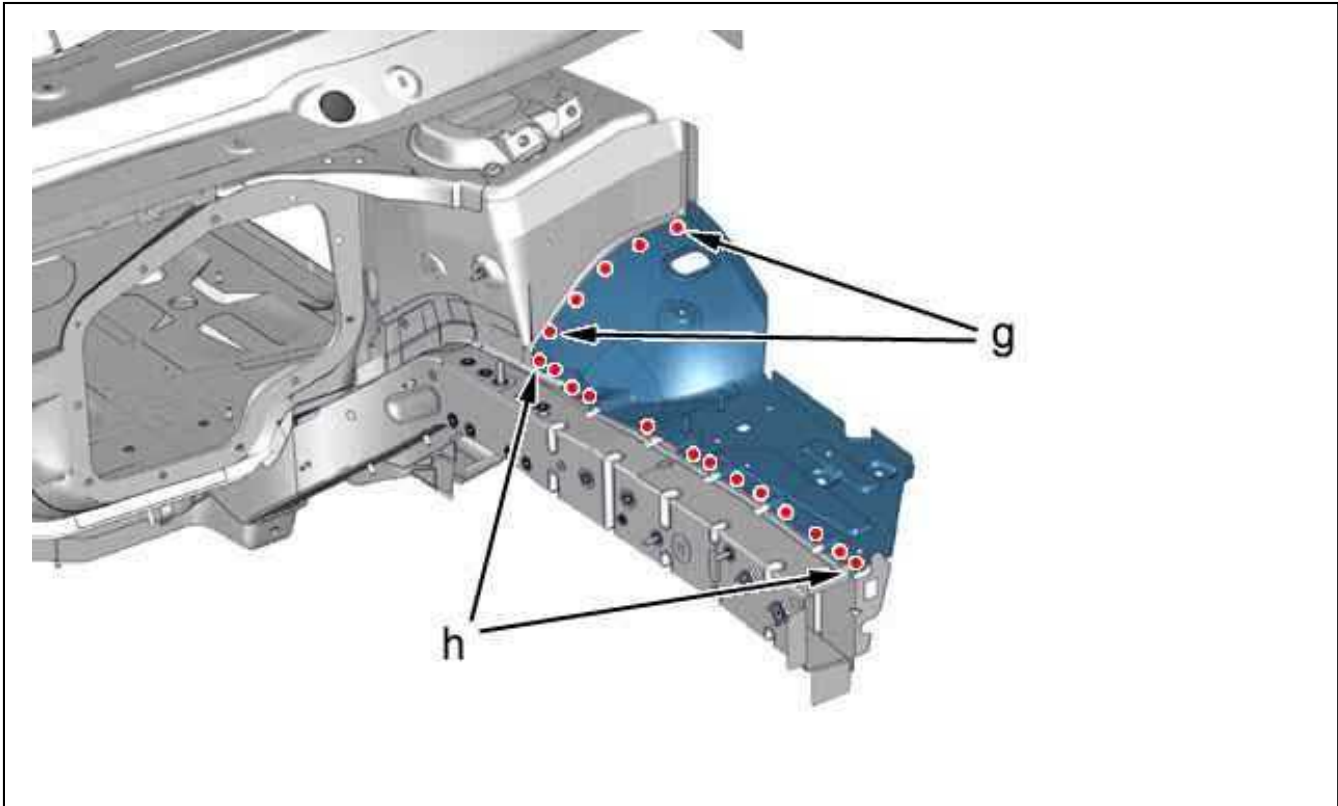


Figure : C4AP1XSD

N.B. : Spot weld lines are applied with the passenger compartment side strengtheners and inner panels ⓘ.

Weld with electric spot welds.

Electrodes= 120 mm (symmetrical welding).

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"g"	5	0,97/ 1,17	ADX/	350	11300	450
"h"	11	0,97/ 1,95/ 1,76	ADX/ ADX/ ADX	450	11300	800

Electrodes=260 mm (symmetrical welding).

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"g"	5	0,97/ 1,17	ADX/ ADX	208	9600	700
"h"	11	0,97/ 1,95/ 1,76	ADX/ ADX/ ADX	208	9500	850

Electrodes= 400 mm (symmetrical welding).

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"g"	5	0,97/ 1,17	ADX/ ADX	135	9600	700
"h"	11	0,97/ 1,95/ 1,76	ADX/ ADX/ ADX	135	9500	850

6. Front suspension support assembly

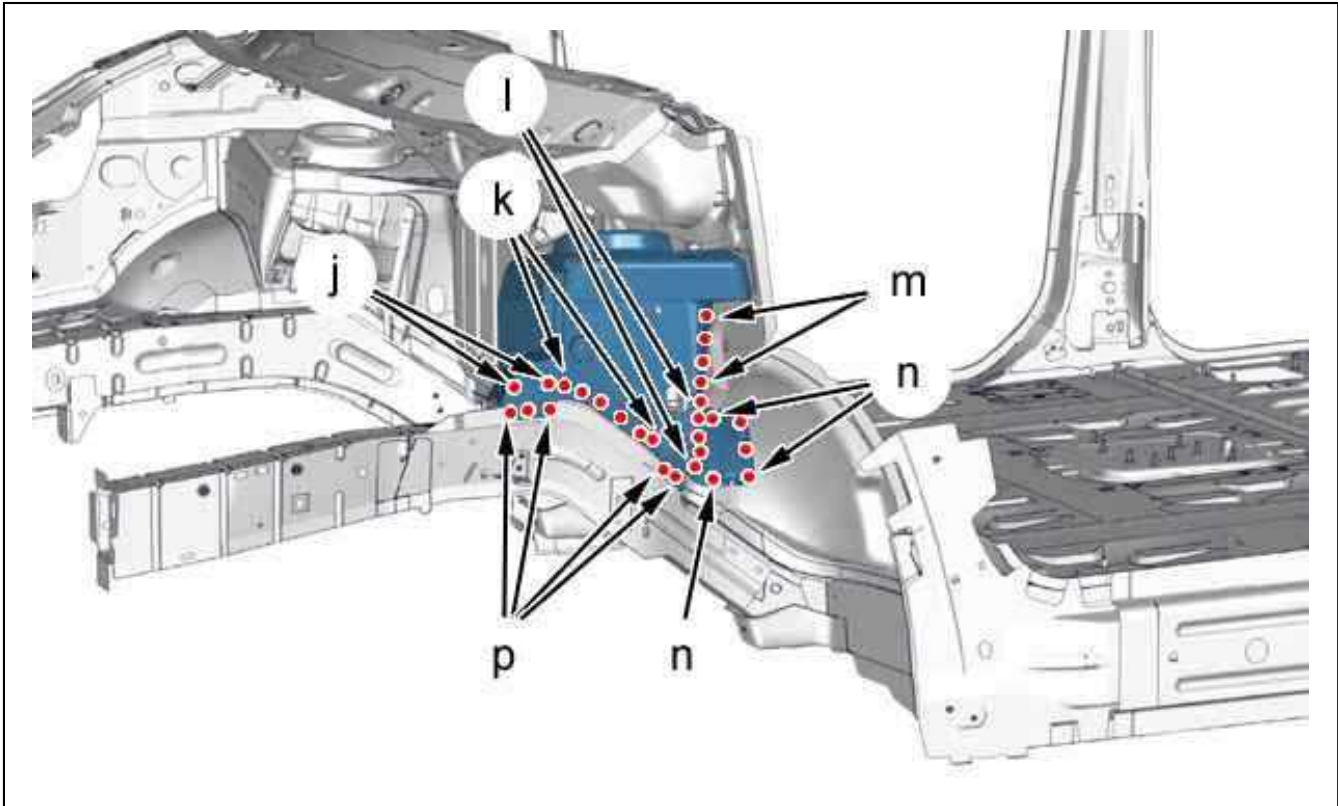


Figure : C4AP1XTD

Weld with electric spot welds.

Electrodes= 120 mm (symmetrical welding).

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"j"	2	1,17/2,44	ADX/ADX	450	11300	800
"k"	6	1,17/2,44/ 1,95	ADX/ ADX/ ADX	450	11300	800
"l"	5	1,17/ 1,76/ 0,97	ADX/ HLE/ADX	450	11300	800
"m"	4	1,17/0,97	ADX/ ADX	350	11300	450
"n"	5	1,76/0,97	HLE/ ADX	350	11300	450
"p"	5	1,17/2,44/ 1,95	ADX/ ADX/ ADX	450	11300	800

Electrodes= 260 mm (symmetrical welding).

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"j"	2	1,17/2,44	ADX/ADX	208	9500	850
"k"	6	1,17/2,44/ 1,95	ADX/ ADX/ ADX	208	9500	850
"l"	5	1,17/ 1,76/ 0,97	ADX/ HLE/ADX	208	9500	850
"m"	4	1,17/0,97	ADX/ ADX	208	9600	700
"n"	5	1,76/0,97	HLE/ ADX	208	9600	700
"p"	5	1,17/2,44/ 1,95	ADX/ ADX/ ADX	208	9500	850

Electrodes= 400 mm (symmetrical welding).

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"j"	2	1,17/2,44	ADX/ADX	135	9500	850
"k"	6	1,17/2,44/ 1,95	ADX/ ADX/ ADX	135	9500	850
"l"	5	1,17/ 1,76/ 0,97	ADX/ HLE/ADX	135	9500	850

"m"	4	1,17/0,97	ADX/ ADX	135	9600	700
"n"	5	1,76/0,97	HLE/ ADX	135	9600	700
"p"	5	1,17/2,44/ 1,95	ADX/ ADX/ ADX	135	9500	850

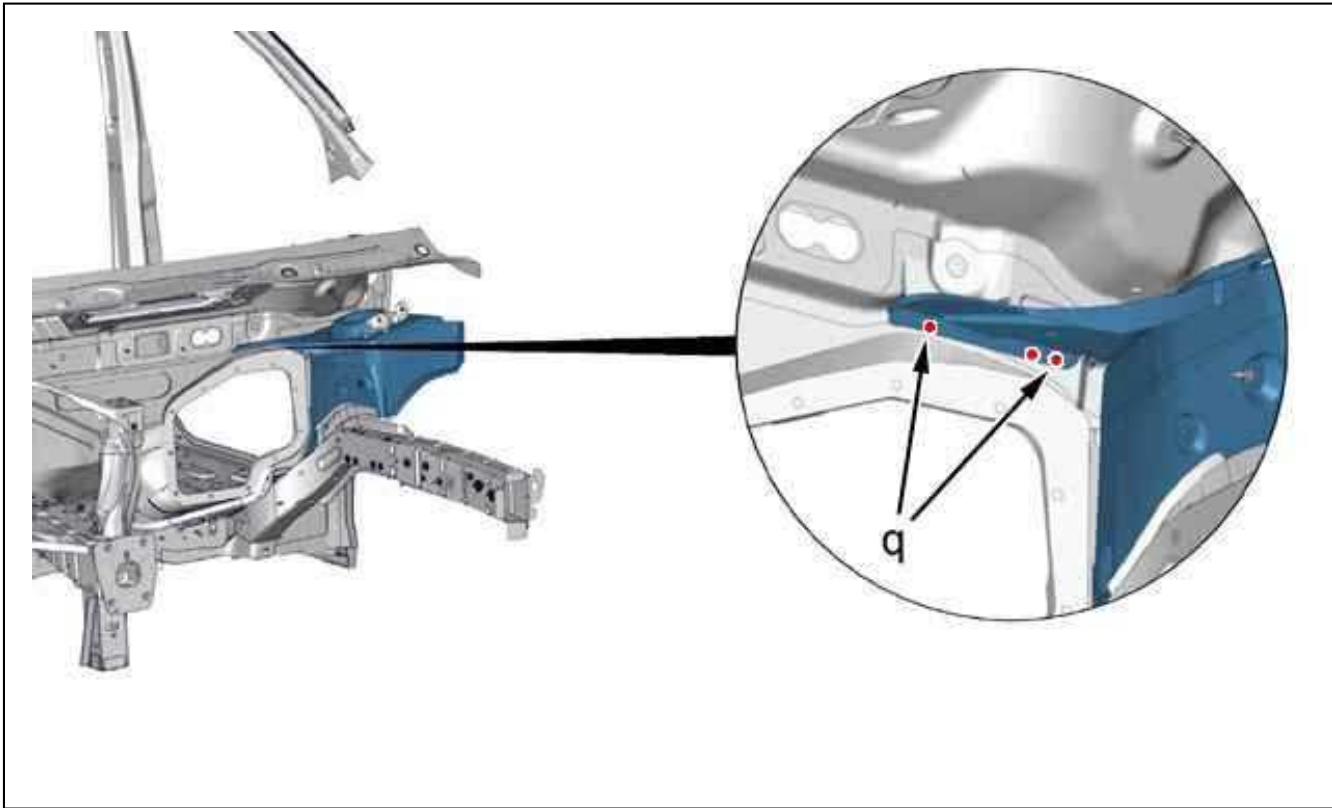


Figure : C4AP1XUD

Electrodes= 120 mm (symmetrical welding).

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"q"	3	1,17/1,47/0,97	ADX/HLE/ ADX	450	11300	800

Electrodes=260 mm (symmetrical welding).

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"q"	3	1,17/1,47/0,97	ADX/HLE/ ADX	208	9500	850

Electrodes=400 mm (symmetrical welding).

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"q"	3	1,17/1,47/0,97	ADX/HLE/ ADX	130	9500	850

7. Front sill closing panel

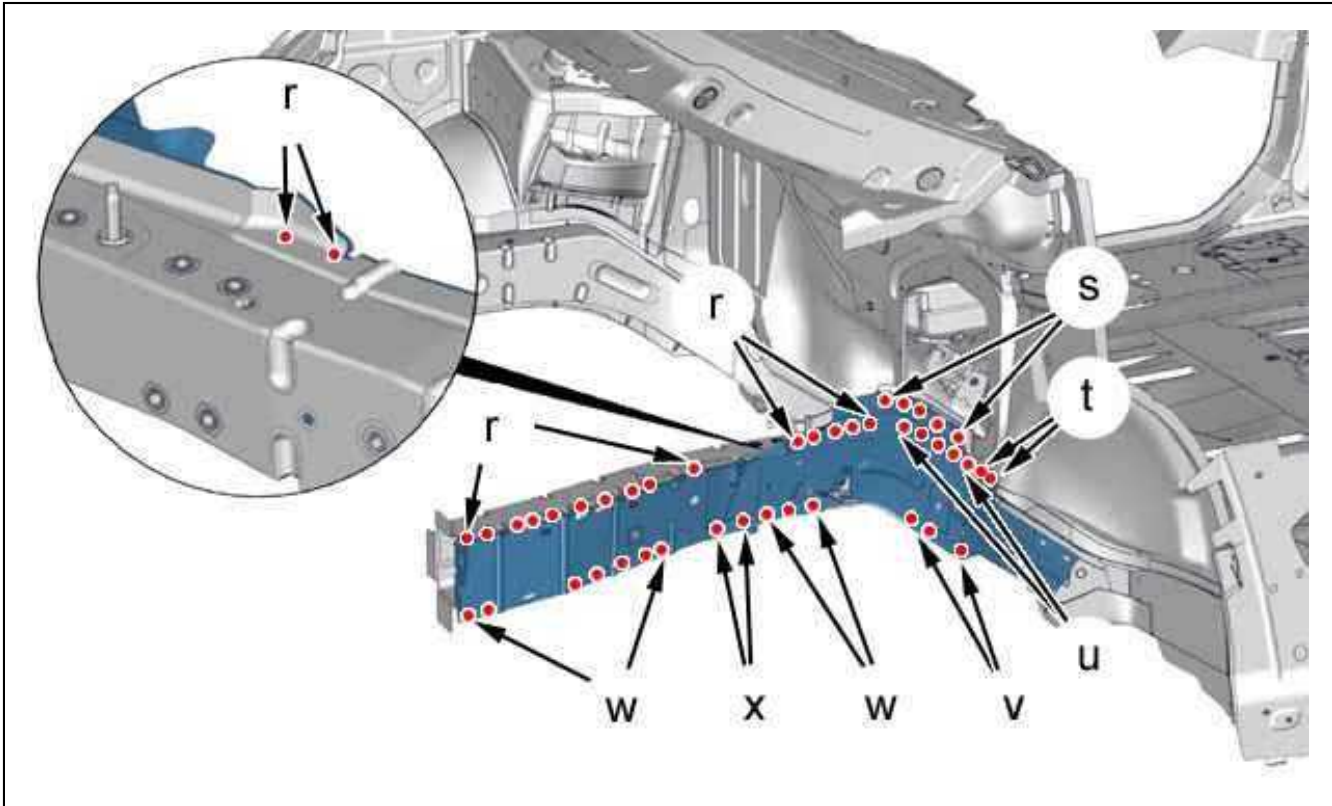


Figure : C4AP1XVD

Electrodes= 120 mm (symmetrical welding).

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"r"	17	1,95/ 1,76	ADX/ ADX/	450	11300	800
"s"	5	1,95/ 1,95	ADX/ ADX	450	11300	800
"t"	2	2,44/ 1,95	ADX/ ADX/ ADX	450	11300	800
"u"	5	2,44/ 1,95/ 1,95	ADX/ ADX/ ADX	450	11300	800
"v"	3	2,44/ 1,95	ADX/ ADX	450	11300	800
"w"	10	1,76/ 1,95	ADX/ ADX	450	11300	800
"x"	2	1,76/ 1,76/ 1,95	ADX/ ADX/ ADX	450	11300	800

Electrodes= 260 mm (symmetrical welding).

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"r"	17	1,95/ 1,76	ADX/ ADX/	208	9500	850
"s"	5	1,95/ 1,95	ADX/ ADX	208	9500	850
"t"	2	2,44/ 1,95	ADX/ ADX/ ADX	208	9500	850
"u"	5	2,44/ 1,95/ 1,95	ADX/ ADX/ ADX	208	9500	850
"v"	3	2,44/ 1,95	ADX/ ADX	208	9500	850
"w"	10	1,76/ 1,95	ADX/ ADX	208	9500	850
"x"	2	1,76/ 1,76/ 1,95	ADX/ ADX/ ADX	208	9500	850

Electrodes= 400 mm (symmetrical welding).

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"r"	17	1,95/ 1,76	ADX/ ADX	135	9500	850
"s"	5	1,95/ 1,95	ADX/ ADX	135	9500	850

"t"	2	2,44/ 1,95	ADX/ ADX/ ADX	135	9500	850
"u"	5	2,44/ 1,95/ 1,95	ADX/ ADX/ ADX	135	9500	850
"v"	3	2,44/ 1,95	ADX/ ADX	135	9500	850
"w"	10	1,76/ 1,95	ADX/ ADX	135	9500	850
"x"	2	1,76/ 1,76/ 1,95	ADX/ ADX/ ADX	135	9500	850

RESISTANCE WELDING PARAMETERS : ROOF PANEL - CROSSMEMBERS - BOWS

ESSENTIAL : Depending on the operation to be carried out, observe the instructions for chocking up the vehicle.

ESSENTIAL : Deactivate the pneumatic suspension before lifting the vehicle ⓘ (2 or 4 post lift, workshop jack or customer's jack).

CAUTION : All of the stripped surfaces must be protected by means of the approved electrolytic re-zincing process .

ESSENTIAL : Observe the elementary rules of hygiene and safety (wear a face mask to protect against fumes and vapour - work in a well ventilated space).

1. Introduction

Key :

- ADX : soft steel
- HLE : high-strength steel
- THLE: very high-strength steel

The welding parameter values indicated are validated with the stations approved by the manufacturer.

The welding parameters are applied on coated panels and may vary in relation to the following criteria :

- Power of the workshop's electrical and pneumatic equipment
- Type of anti-corrosion protection applied to the components to be welded (weldable primer or index "C8" electrolytic re-zincing)
- Thickness of the weld-through primer used for the preparation of the mating edges
- Nature of the weldable primer (zinc, aluminium or copper)
- Quality of the preparation of the lining up of the welded edges on the components replaced
- Diameter of the spot weld to be applied

N.B. : The diameter of the spot weld applied must be identical and correspond to the diameter of the original spot weld

3 electrode arm lengths are approved on all of the welding stations :

- 120 mm
- 260 mm
- 400 mm

CAUTION : Before carrying out a welding operation on the vehicle, check the settings of the welding station (spot weld removal test).

Use the test specimens available from the parts department :

- Kit part number : 978046
- Samples kit refills part number : 978020

Carry out the spot weld removal test before each change of :

- Of panel stack
- Of grade of steel
- Of panel thickness

If the spot welds cannot be applied in the same way as the originals, replace the spot welds with plug welds, applied using the MAG type electric arc process, after drilling the first panel.

N.B. : The welding parameters are symmetrical.

2. Roof panel

2.1. Welding the roof

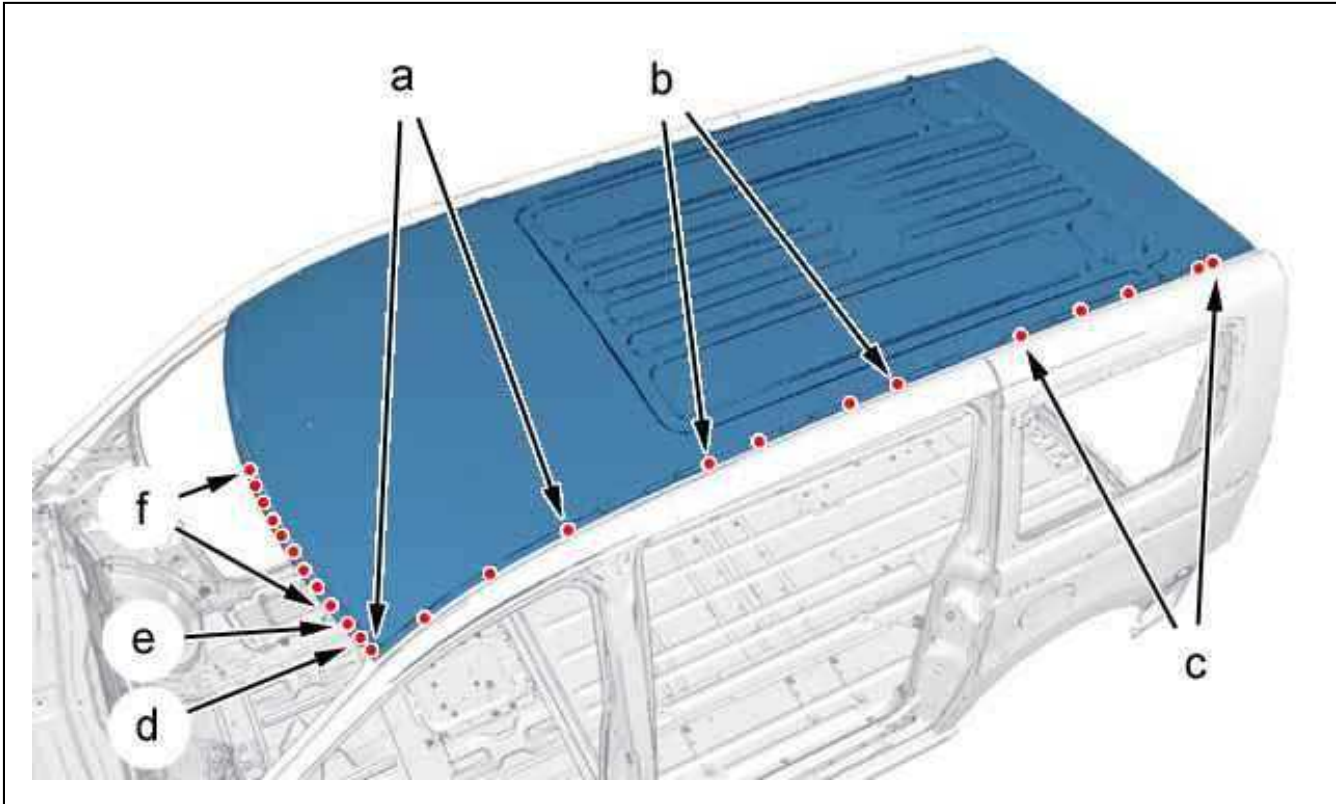


Figure : C4DM001D

Weld with electric spot welds.

Electrodes = 120 mm (symmetrical welding)						
Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"a"	4	0,77/ 0,97 / 1,17	ADX/ ADX /HLE	350	11300	450
"b"	4	0,77/0,97 / 1,47	ADX/ ADX / ADX	350	11300	450
"c"	5	0,77 / 0,77 / 1,47	ADX / ADX / ADX	350	11300	450
"d"	1	0,77 / 1,17	ADX / HLE	350	11300	450
"e"	1	0,77 / 0,97 / 1,17	ADX / ADX / HLE	350	11300	450
"f"	9	0,77/ 0,97	ADX/ ADX	350	11300	450

Electrodes = 260 mm (symmetrical welding)						
Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"a"	4	0,77/ 0,97 / 1,17	ADX/ ADX /HLE	208	9600	700
"b"	4	0,77/0,97 / 1,47	ADX/ ADX / ADX	208	9600	700
"c"	5	0,77 / 0,77 / 1,47	ADX / ADX / ADX	208	9600	700

"d"	1	0,77 / 1,17	ADX / HLE	208	9600	700
"e"	1	0,77 / 0,97 / 1,17	ADX / ADX / HLE	208	9600	700
"f"	9	0,77/ 0,97	ADX/ ADX	208	9600	700

Electrodes = 400 mm (symmetrical welding)

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"a"	4	0,77/ 0,97 / 1,17	ADX/ ADX /HLE	135	9600	700
"b"	4	0,77/0,97 / 1,47	ADX/ ADX / ADX	135	9600	700
"c"	5	0,77 / 0,77 / 1,47	ADX / ADX / ADX	135	9600	700
"d"	1	0,77 / 1,17	ADX / HLE	135	9600	700
"e"	1	0,77 / 0,97 / 1,17	ADX / ADX / HLE	135	9600	700
"f"	9	0,77/ 0,97	ADX/ ADX	135	9600	700

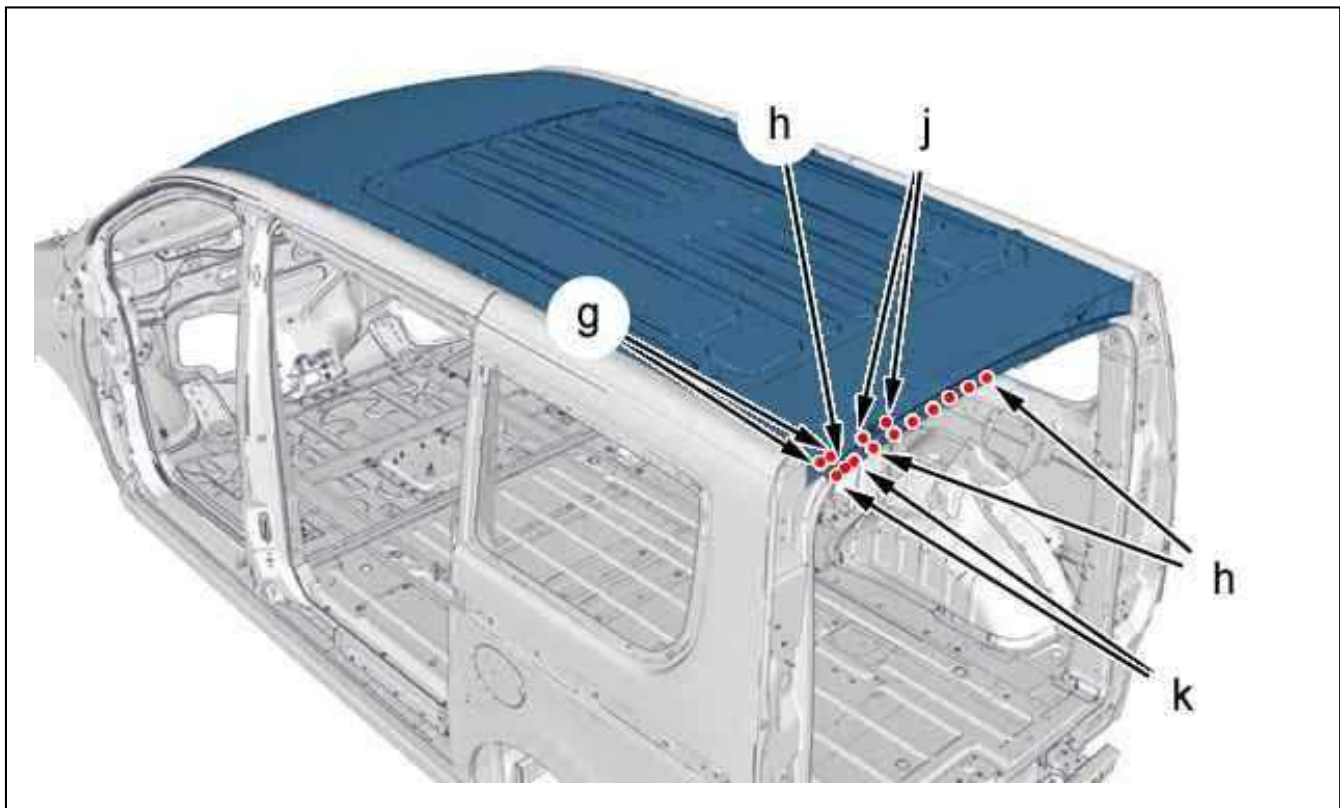


Figure : C4DM002D

Weld with electric spot welds.

Electrodes = 120 mm (symmetrical welding)

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"g"	2	0,77/ 1,95	ADX/ ADX	450	11300	800
"h"	8	0,77/ 0,97	ADX/ ADX	350	11300	450
"j"	2	0,77/ 1,47	ADX/ HLE	450	11300	800
"k"	2	0,77/ 1,95/ 0,97	ADX/ ADX/ ADX	450	11300	800

Electrodes = 260 mm (symmetrical welding)

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"g"	2	0,77/ 1,95	ADX/ ADX	208	9500	850

"h"	8	0,77/ 0,97	ADX/ ADX	208	9600	700
"j"	2	0,77/ 1,47	ADX/ HLE	208	9500	850
"k"	2	0,77/ 1,95/ 0,97	ADX/ ADX/ ADX	208	9500	850

Electrodes = 400 mm (symmetrical welding)

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"g"	2	0,77/ 1,95	ADX/ ADX	135	9500	850
"h"	8	0,77/ 0,97	ADX/ ADX	135	9600	700
"j"	2	0,77/ 1,47	ADX/ HLE	135	9500	850
"k"	2	0,77/ 1,95/ 0,97	ADX/ ADX/ ADX	135	9500	850

2.2. Front roof crossmember

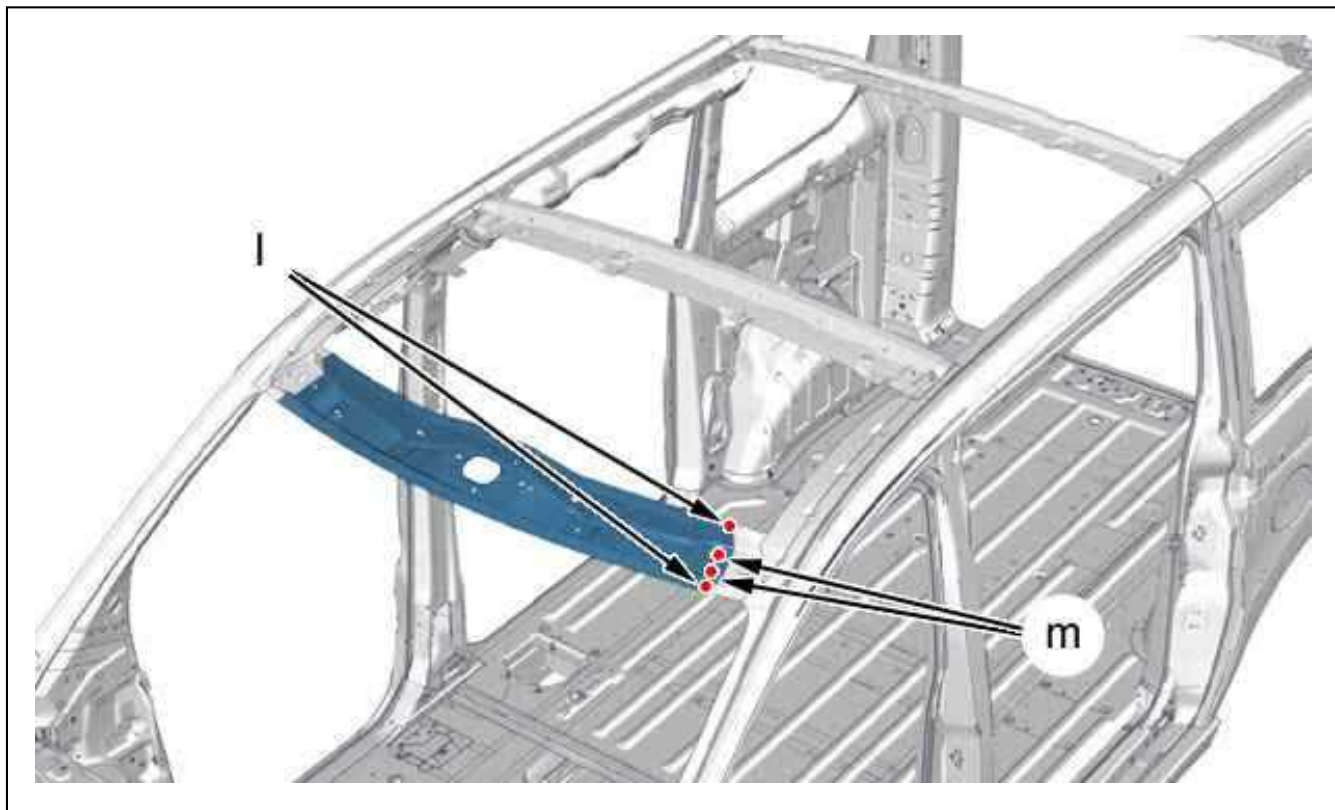


Figure : C4DM003D

Weld with electric spot welds.

Electrodes = 120 mm (symmetrical welding)

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"l"	2	0,97 / 1,17	ADX/ HLE	350	11300	450
"m"	2	0,97/ 1,17/ 1,17	ADX/ HLE/ HLE	350	11300	450

Electrodes = 260 mm (symmetrical welding)

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"l"	2	0,97 / 1,17	ADX/ HLE	208	9600	700
"m"	2	0,97/ 1,17/ 1,17	ADX/ HLE/ HLE	208	9600	700

Electrodes = 400 mm (symmetrical welding)

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"l"	2	0,97 / 1,17	ADX/ HLE	135	9600	700
"m"	2	0,97/ 1,17/ 1,17	ADX/ HLE/ HLE	135	9600	700

2.3. Roof rear crossmember

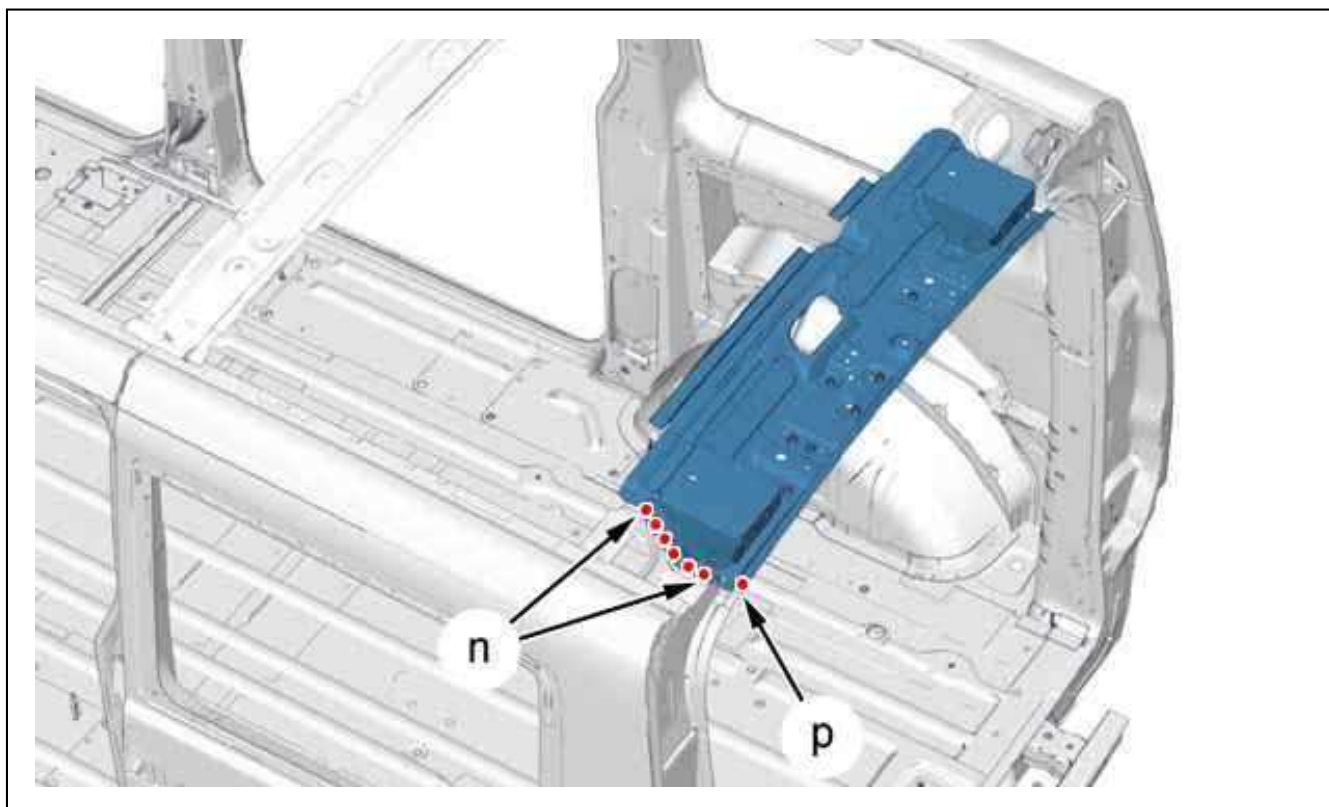


Figure : C4DM004D

Weld with electric spot welds.

Electrodes = 120 mm (symmetrical welding)

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"n"	6	1,47/0,97/1,76	HLE/ ADX/ HLE	350	11300	450
"p"	1	0,97/ 1,76	ADX/ HLE	350	11300	450

Electrodes = 260 mm (symmetrical welding)

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"n"	6	1,47/0,97/1,76	HLE/ ADX/ HLE	208	9600	700
"p"	1	0,97/ 1,76	ADX/ HLE	208	9600	700

Electrodes = 400 mm (symmetrical welding)

Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"n"	6	1,47/0,97/1,76	HLE/ ADX/ HLE	135	9600	700
"p"	1	0,97/ 1,76	ADX/ HLE	135	9600	700

2.4. Roof bow (front)

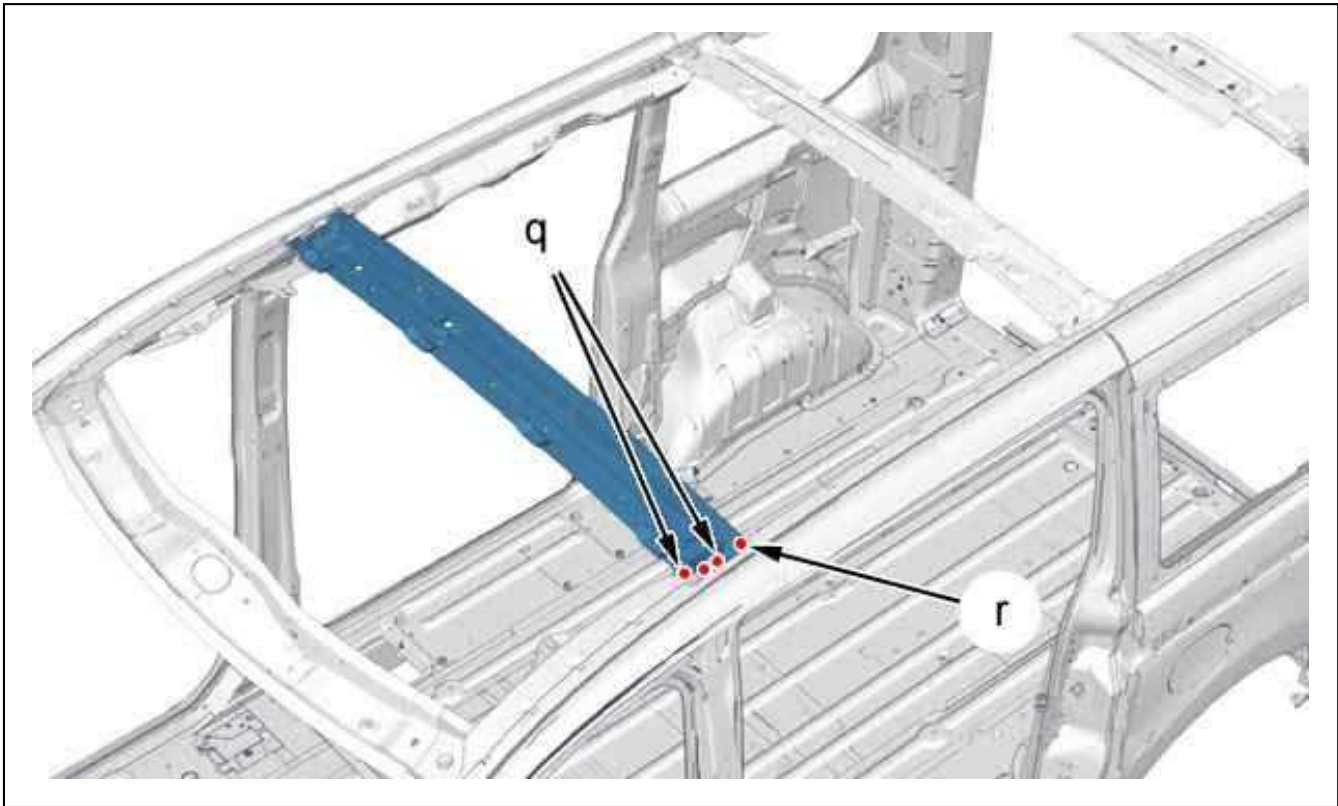


Figure : C4DM005D

Weld with electric spot welds.

Electrodes = 120 mm (symmetrical welding)						
Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"q"	3	0,97 /1,76/1,47	ADX/ HLE/ ADX	450	11300	800
"r"	1	0,97/ 1,47	ADX/ ADX	450	11300	800

Electrodes = 260 mm (symmetrical welding)						
Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"q"	3	0,97 /1,76/1,47	ADX/ HLE/ ADX	208	9500	850
"r"	1	0,97/ 1,47	ADX/ ADX	208	9500	850

Electrodes = 400 mm (symmetrical welding)						
Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"q"	3	0,97 /1,76/1,47	ADX/ HLE/ ADX	135	9500	850
"r"	1	0,97/ 1,47	ADX/ ADX	135	9500	850

2.5. Rear roof member

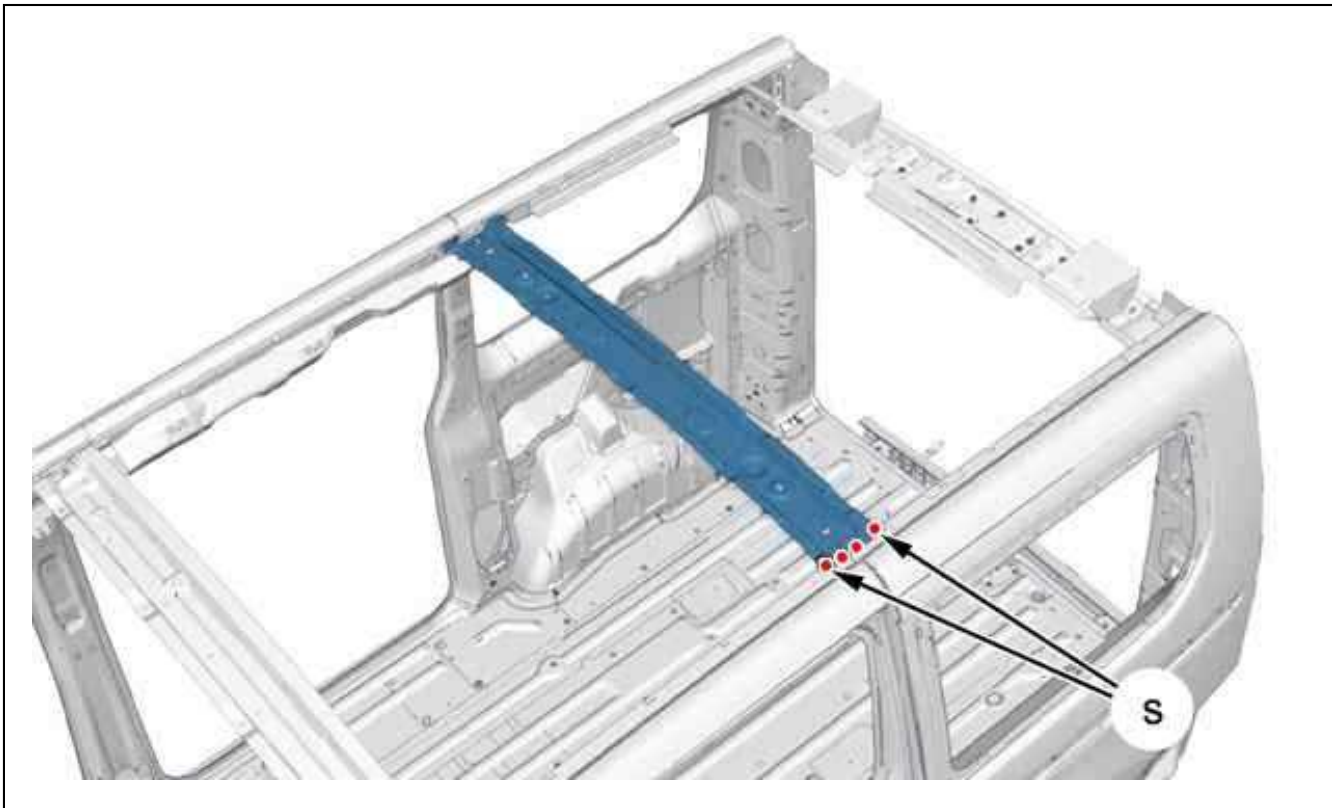


Figure : C4DM006D

Weld with electric spot welds.

Electrodes = 120 mm (symmetrical welding)						
Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"s"	4	0,77/ 1,17	ADX/ ADX	350	11300	450

Electrodes = 260 mm (symmetrical welding)						
Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"s"	4	0,77/ 1,17	ADX/ ADX	208	9600	700

Electrodes = 400 mm (symmetrical welding)						
Reference	Number of spot welds	Thickness (mm)	Nature/classification	Force (daN)	Power (A)	Time (ms)
"s"	4	0,77/ 1,17	ADX/ ADX	135	9600	700

1. Removing

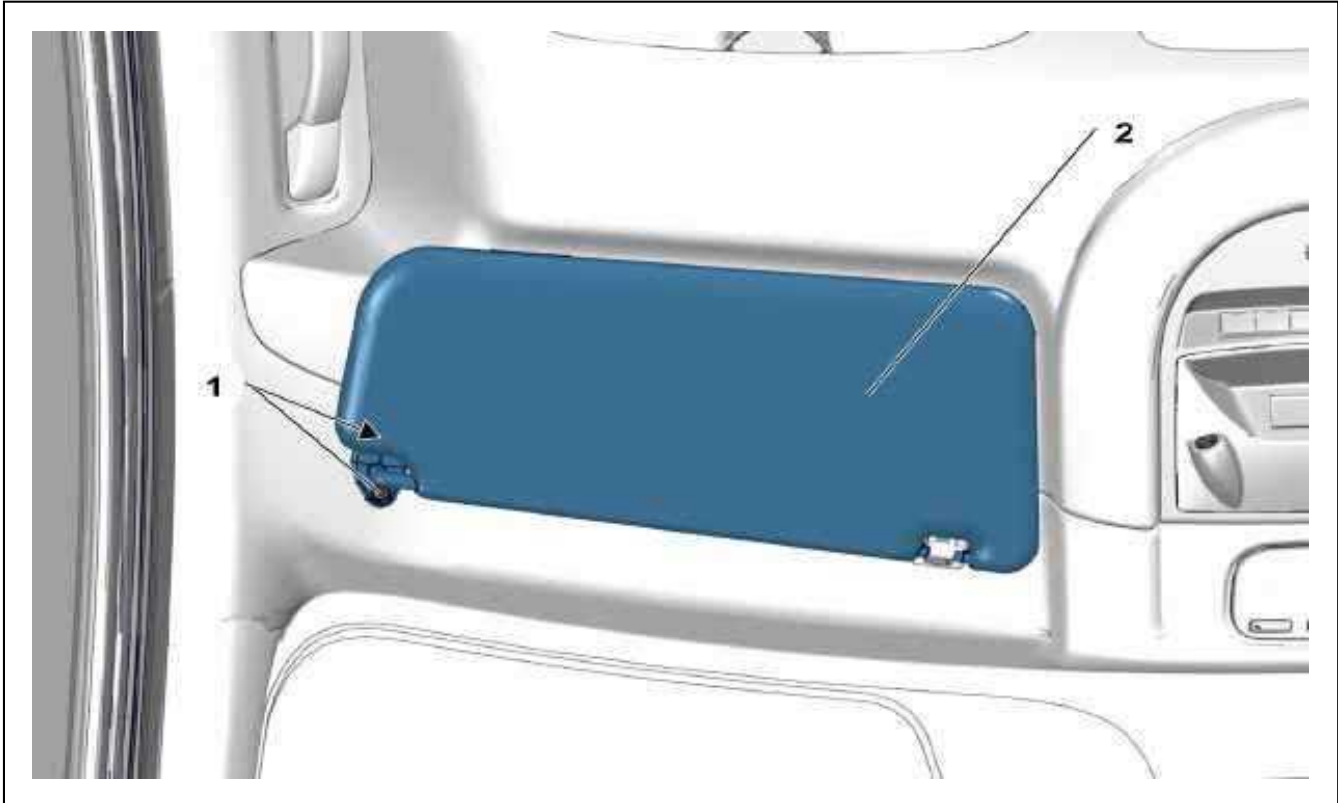


Figure : C5FP19GD

Remove :

- The bolts (1)
- The sun visor (2)

Proceed in the same way for the other side.

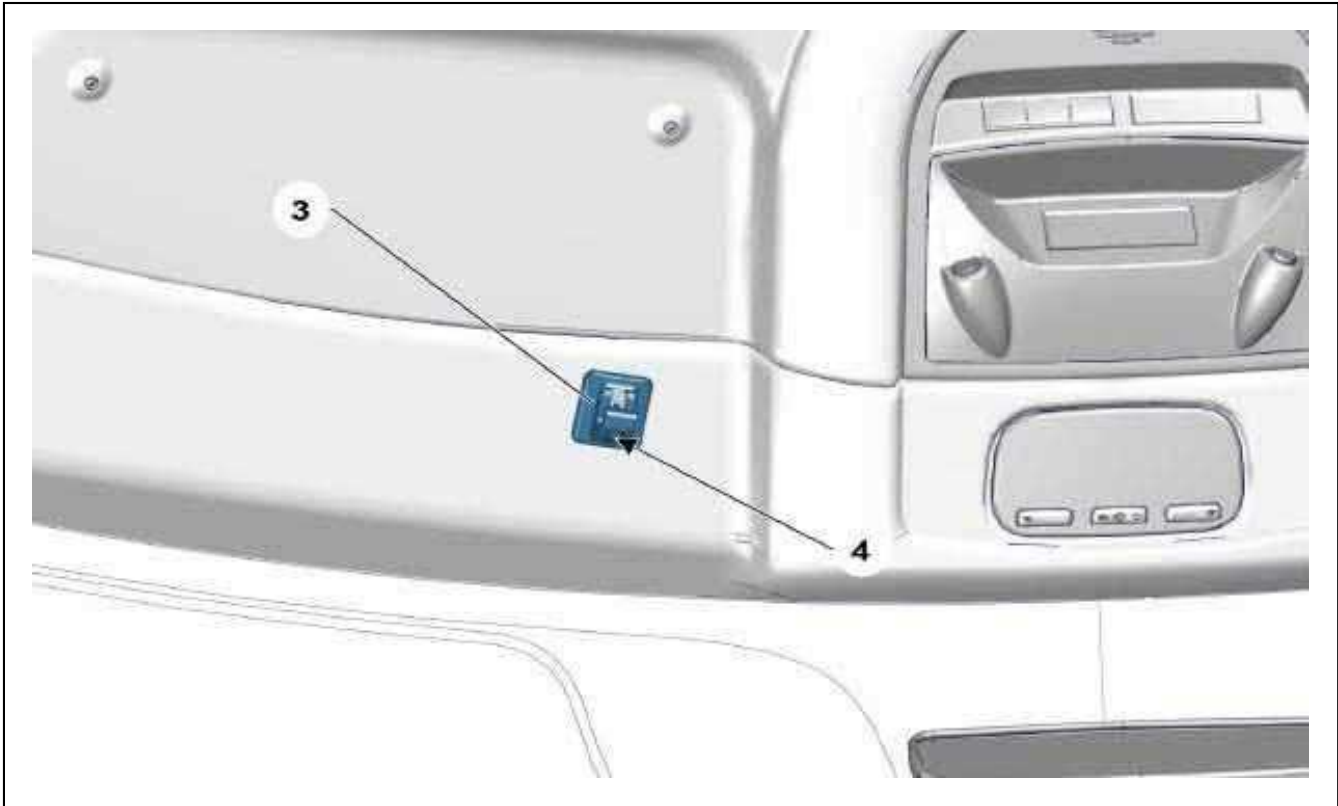


Figure : C5FP19HD

Remove :

- The (4) bolt
- The sun visor anchorage (3)

Proceed in the same way for the other side.

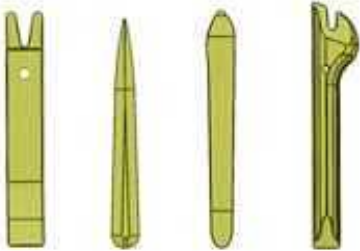
2. Refitting

Proceed in the reverse order to removal.

REMOVING - REFITTING : HEADLINING (CREW CAB)

ESSENTIAL : Observe the safety and cleanliness recommendations ⓘ .

1. Tooling

tool	Reference	Description
[1350-ZZ]  Figure : E5AB03HT	[1350-ZZ]	Stripping tools

2. Preliminary operation

Disconnect the battery ⓘ .

Pull off the door seal .

3. Removing

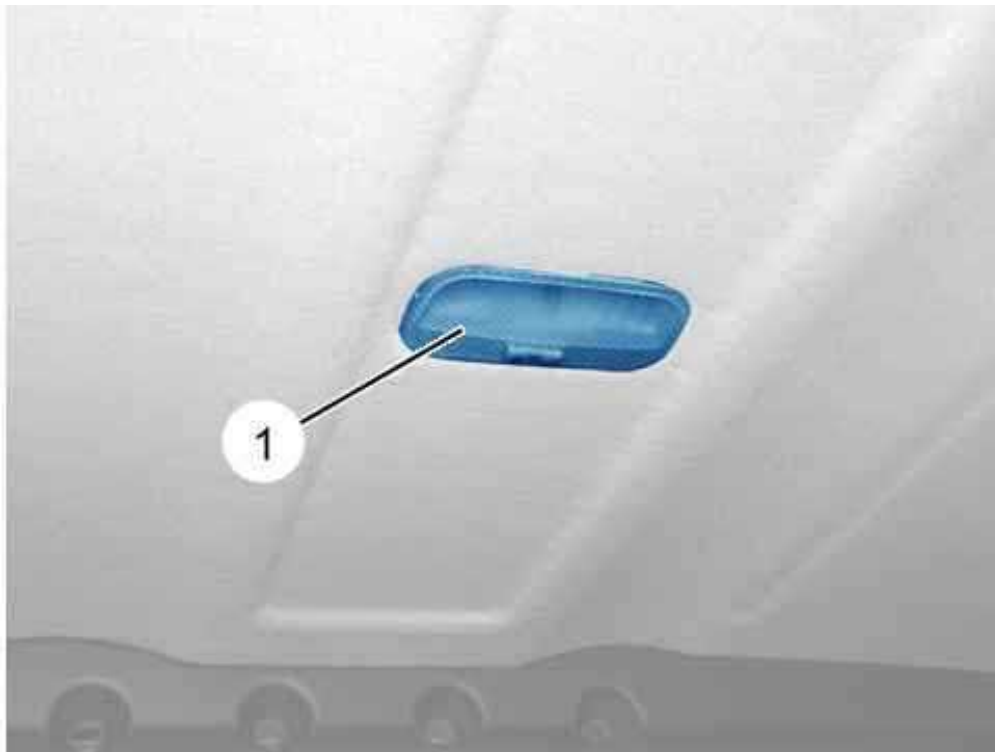


Figure : C5GG167D

Detach the lamp (1) ; Using tool [1350-ZZ].
Disconnect the lighting (1).
Remove the light (1).

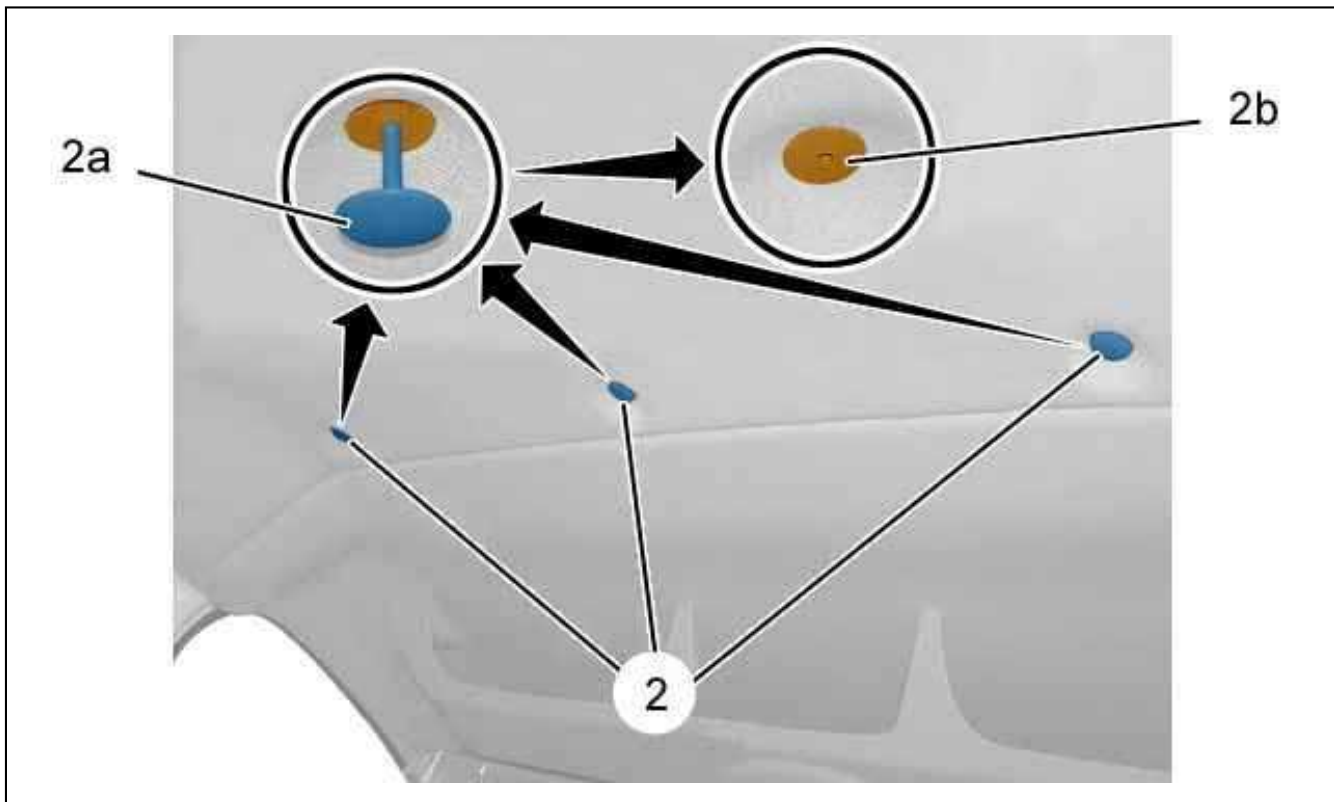


Figure : C5GG168D

Remove the clips (2) :

- Unclip the pin (2a) ; Using tool [1350-ZZ]
- Unclip the clip (2b) ; Using tool [1350-ZZ]

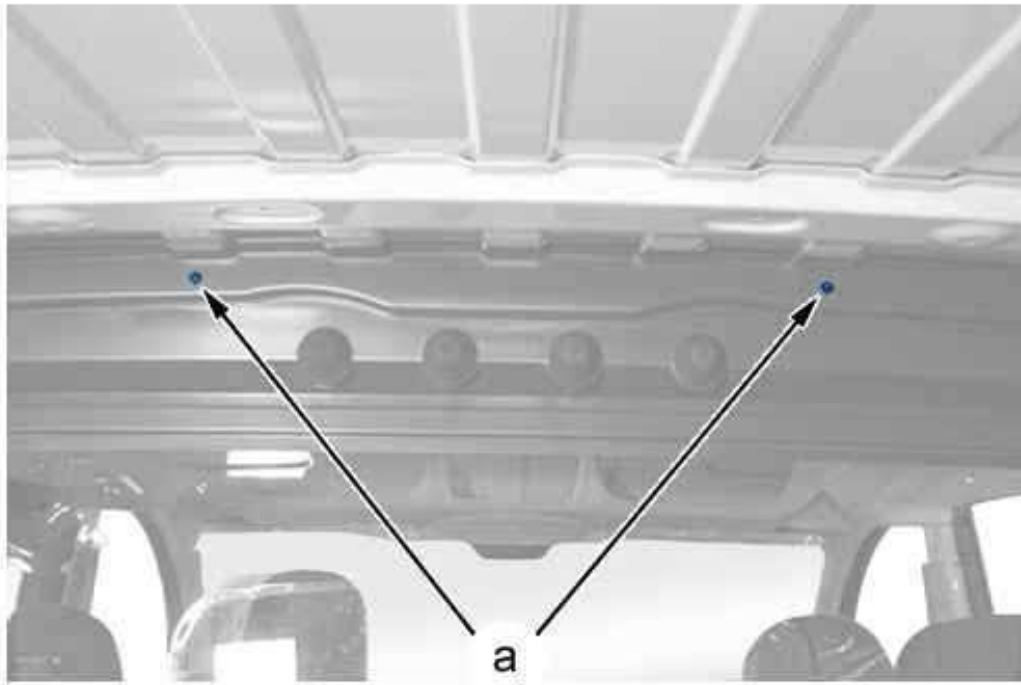


Figure : C5GG16ID

Remove the bolts (at "a").

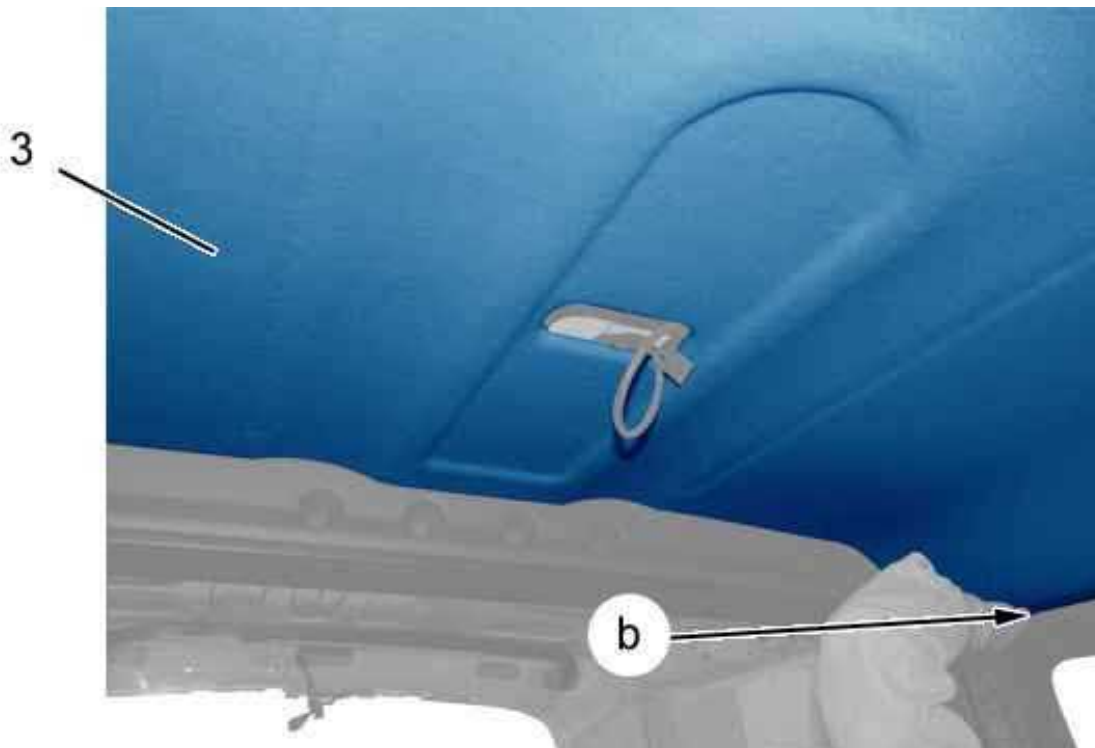


Figure : C5GG16JD

Detach the headlining (3) (at "b").

Remove the headlining (3).

Level the bead of adhesive remaining on the vehicle.

Clean the areas where there is adhesive ; Using degreaser index "J1".

N.B. : Always replace the headlining if there is any damage or marking.

4. Refitting

Proceed in the reverse order to removal.

Apply the adhesive (at "b") ; Using a multi use adhesive index "A6".

CAUTION : Perform the operations to be carried out following reconnection of the battery.

Reconnect the battery.

Check all the equipment works.

REMOVING - REFITTING : FRONT ROOF PANEL TRIM

ESSENTIAL : Observe the safety and cleanliness recommendations ⓘ .

1. Tooling

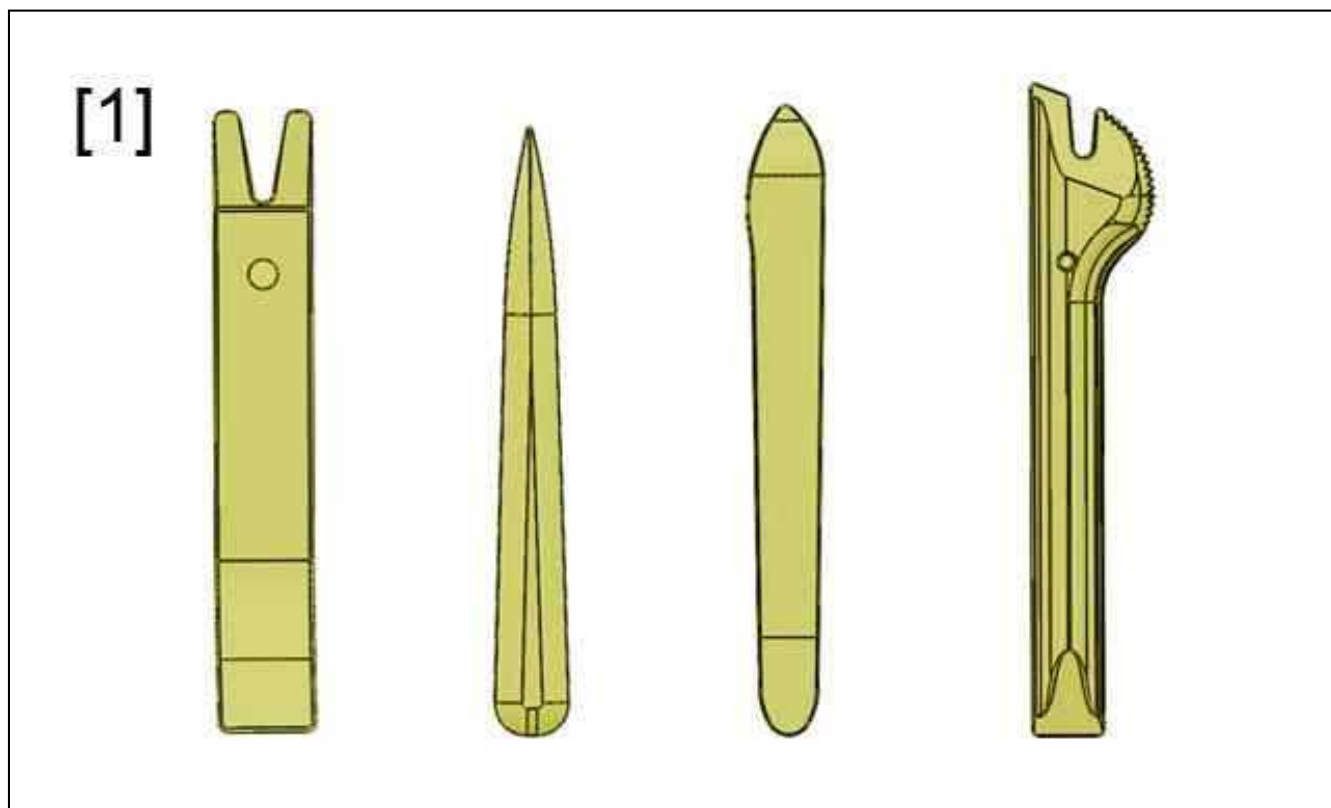


Figure : E5AP30WD

[1] Stripping tools(-).1350-ZZ.

2. Removing

Perform the following operations :

- Switch off the ignition
- Wait 3 minutes before disconnecting the battery
- Disconnect the ancillaries battery

Remove :

- The roof rear trim ⓘ (Combi version)
- The screen pillar trim pads ⓘ (Utility version)
- The screen pillar trim pads ⓘ (Combi version)
- The roof console ⓘ
- The sun visors ⓘ

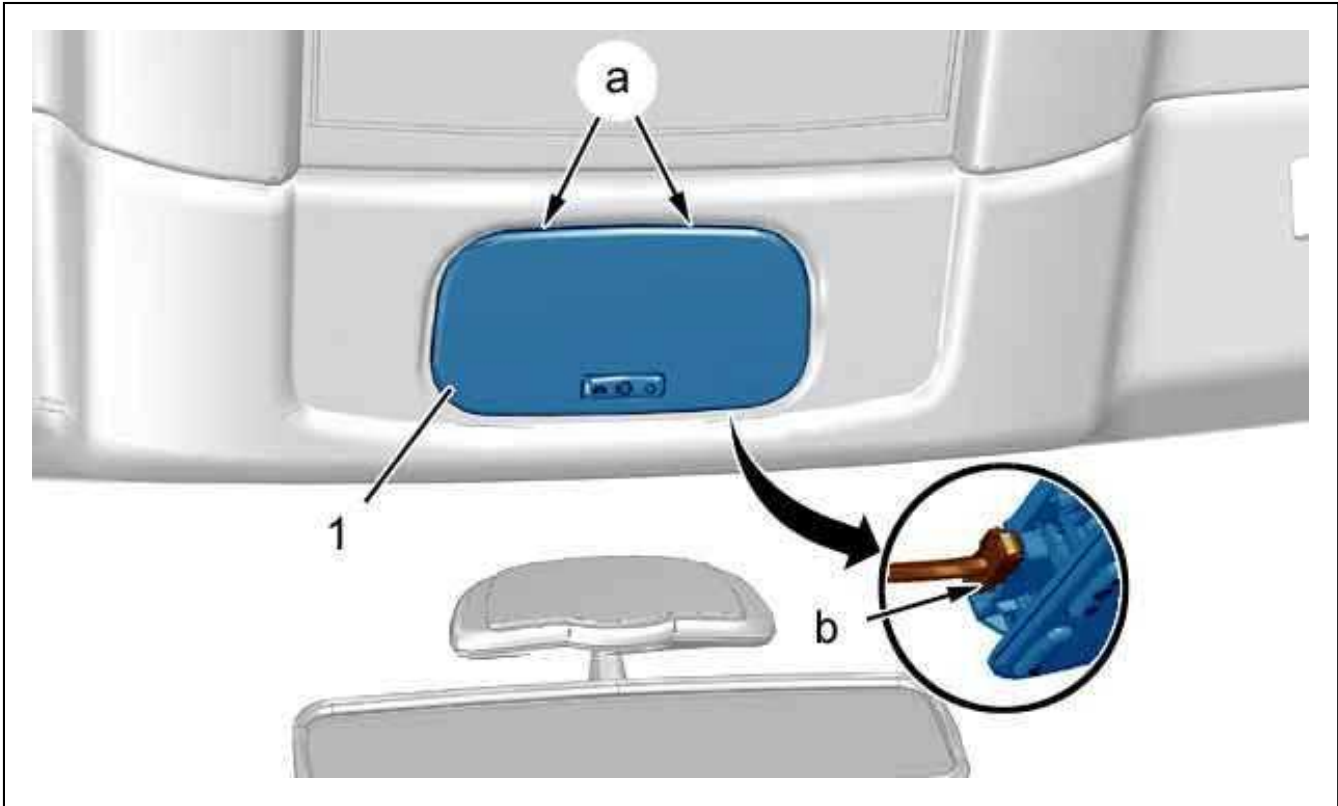


Figure : C5GP100D

Unclip the interior lamp (1) (at "a").
Disconnect the connectors (at "b") (according to equipment).
Remove the interior lamp (1).

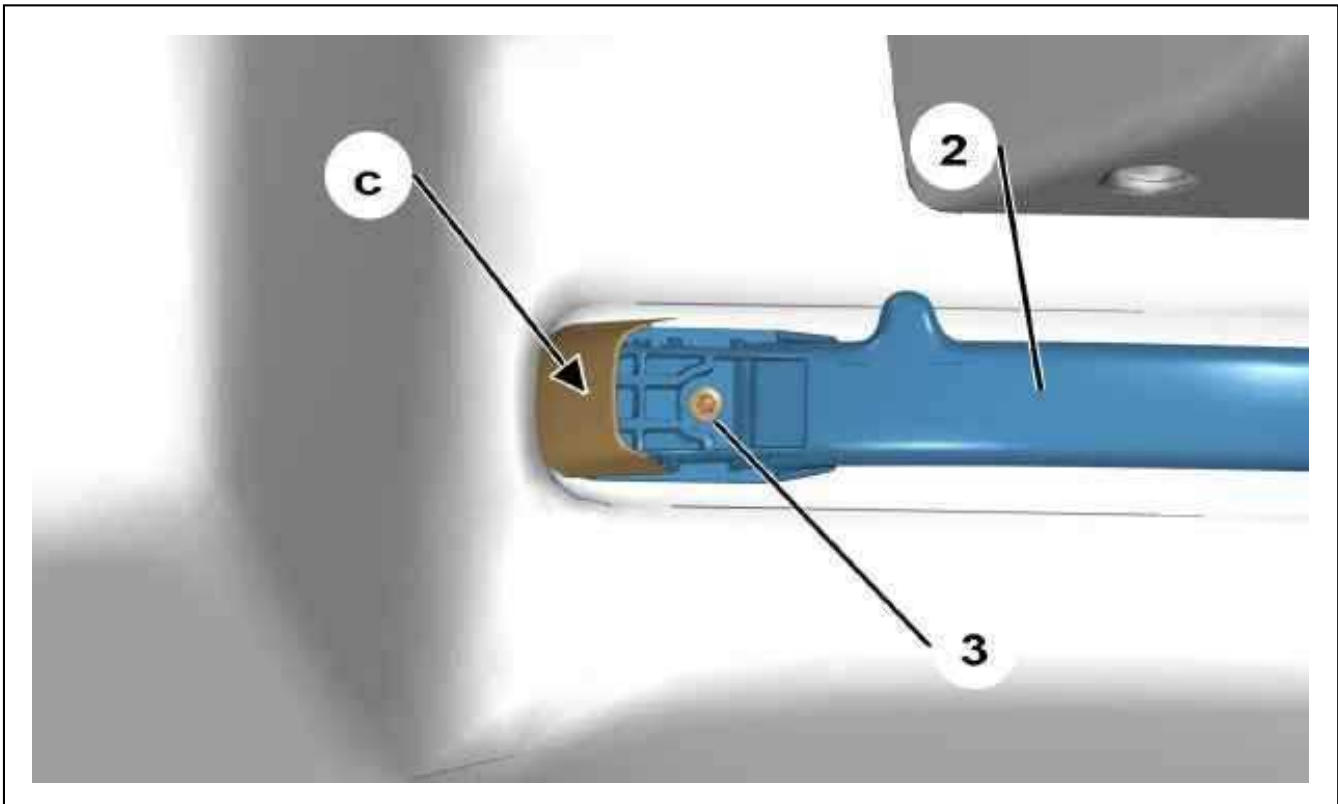


Figure : C5GP101D

Unclip the hinged cover "c" ; Using tool [1].

Remove :

- The (3) bolt
- The grab handle (2)

N.B. : Carry out the same operation on the other side.

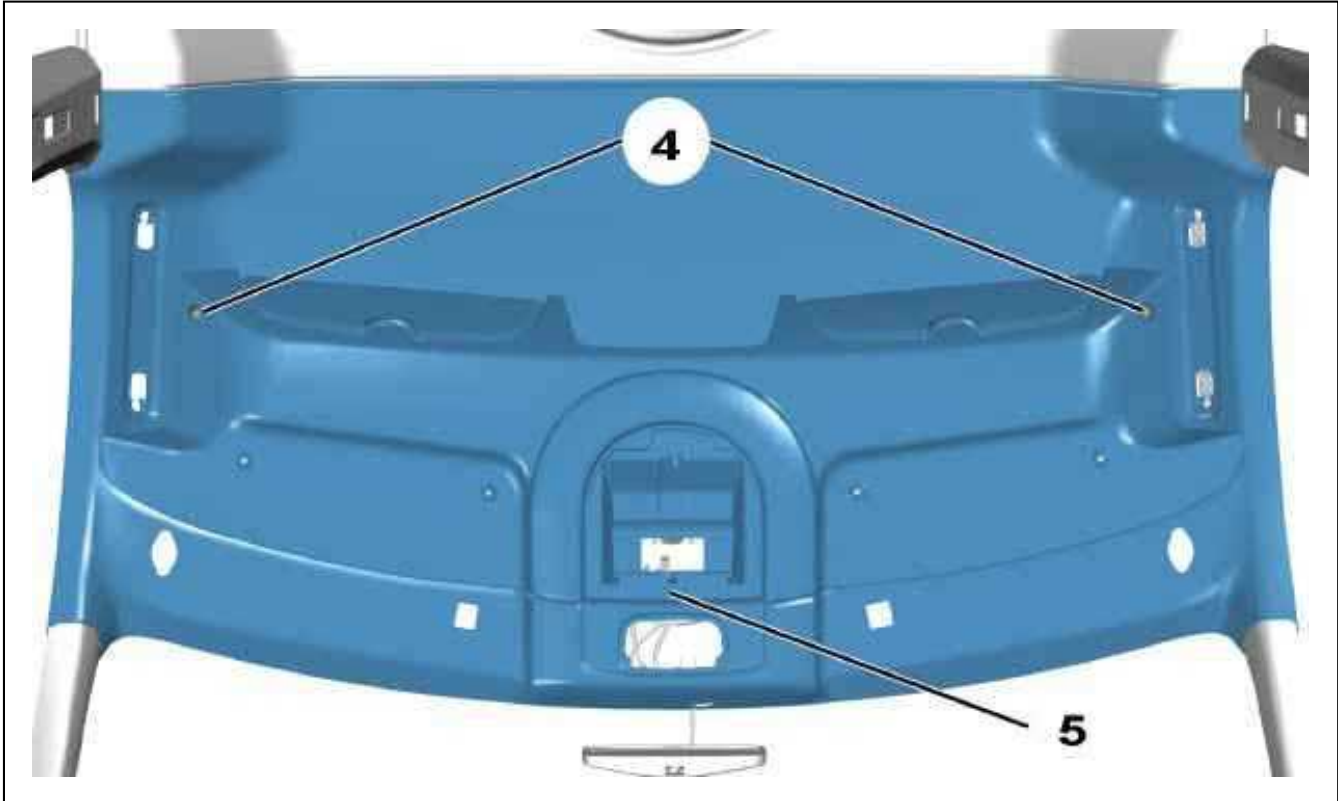


Figure : C5GP102D

Remove :

- The bolts (4)
- The headlining and overhead storage compartment assembly (5)

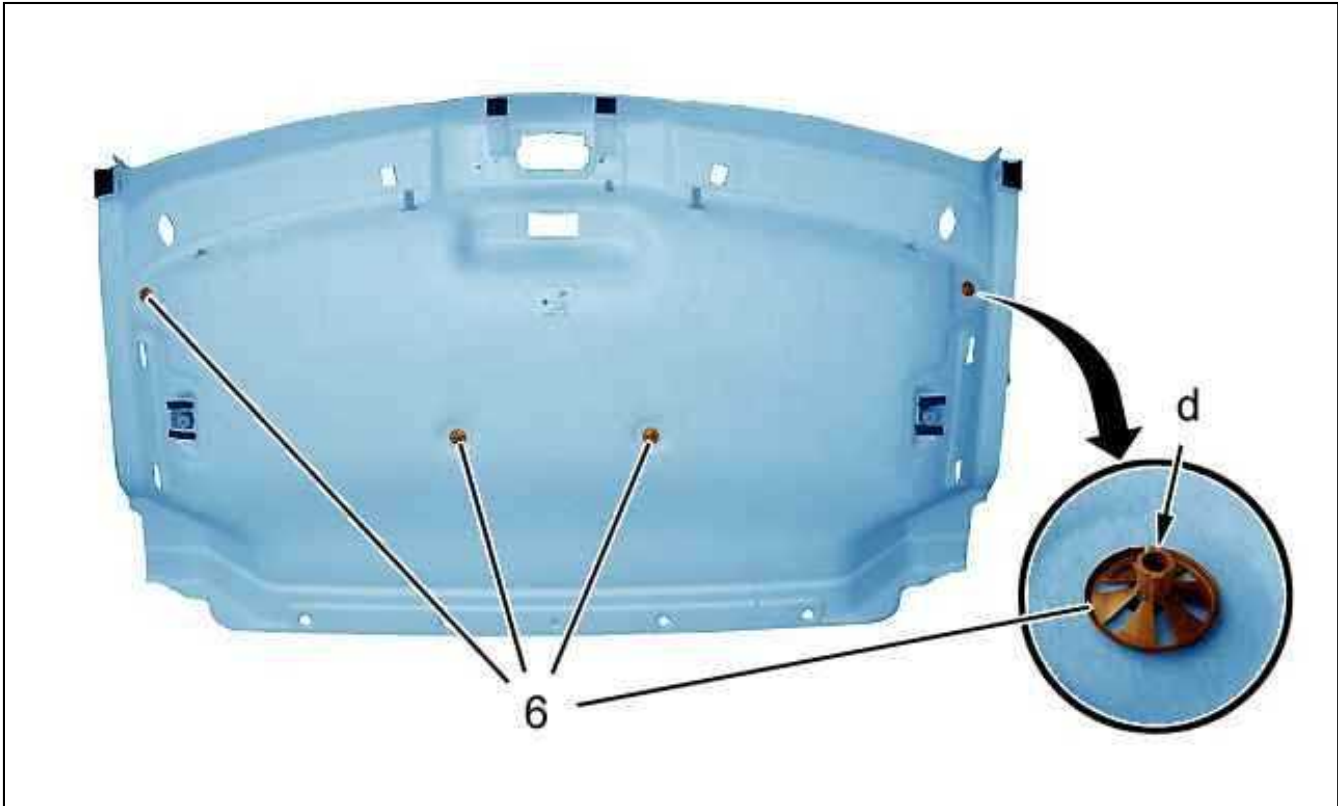


Figure : C5GP103D

Cut the locking clips (6) ; Using a cutter.

CAUTION : Do not damage the overhead storage compartment fixing shafts (at "d").

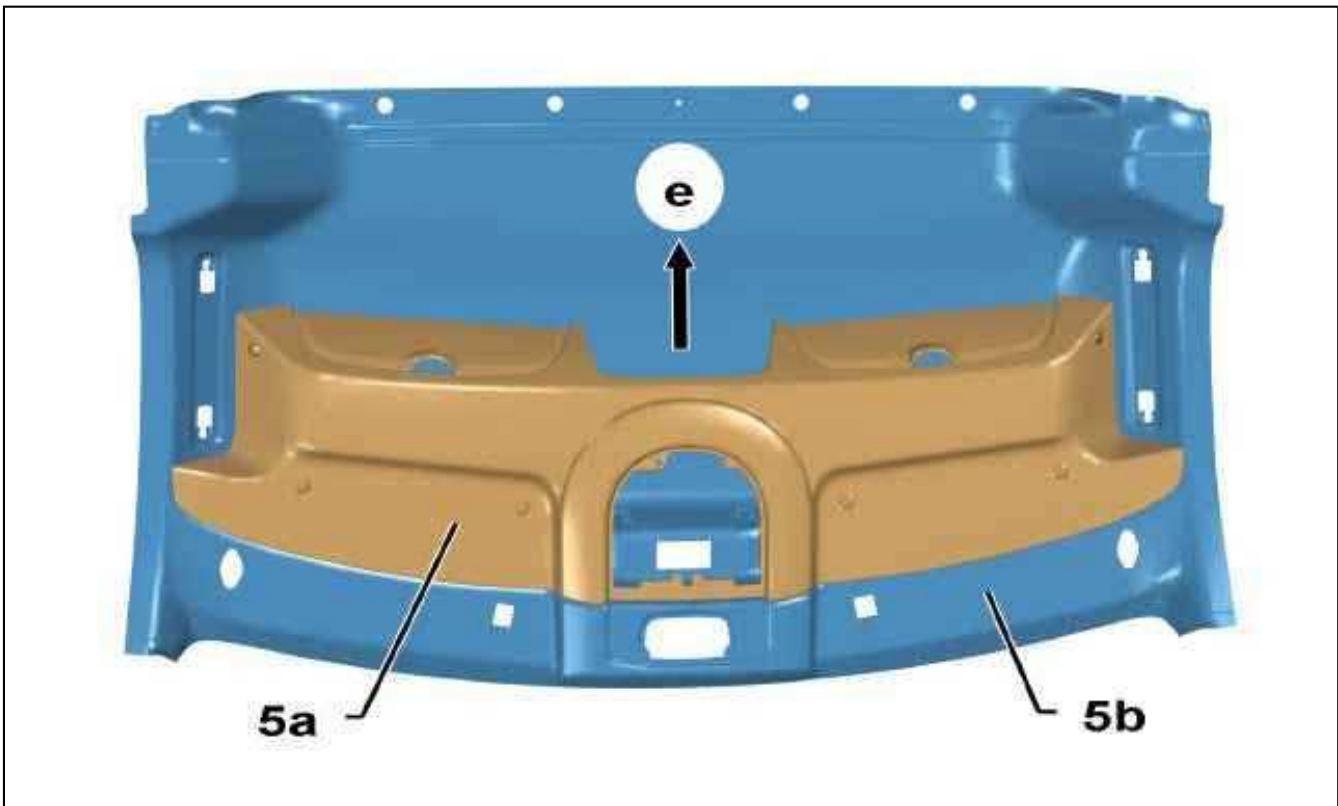


Figure : C5GP104D

Detach the overhead storage compartment (5a) (following the arrow "e").
Remove the front headlining (5b).

3. Refitting

CAUTION : Always replace the locking clips (6).

Fit the locking clips (6) (new).
Proceed in the reverse order to removal.
Tighten the bolts (3) to 0,2 daN.m.

CAUTION : Perform the operations that are required following a reconnection of the ancillaries battery.

Reconnect the ancillaries battery.
Check all the equipment works.

REMOVING - REFITTING : REAR HEADLINING

1. Recommended tools

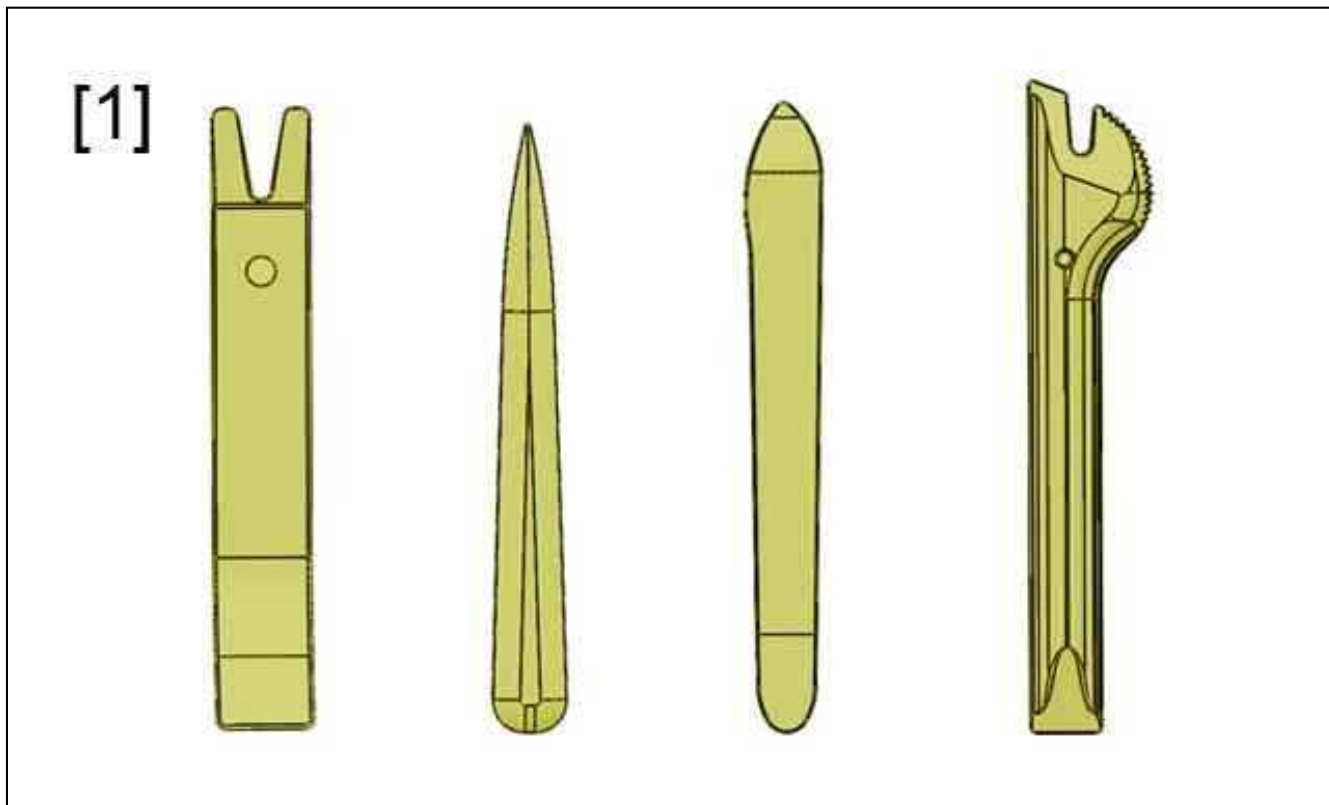


Figure : E5AP30WD

[1] Stripping tool (-).1350-ZZ.

2. Removing

2.1. Combi version

Perform the following operations :

- Switch off the ignition
- Wait 3 minutes before disconnecting the battery
- Disconnect the battery

Dislodge (partly) (left and right hand sides) :

- The front door aperture seal
- The tailgate aperture seal (according to equipment)
- The hinged rear door aperture seal (according to equipment)

Remove (On both sides) :

- The door pillar upper trim ⓘ
- The rear wing trim ⓘ
- The quarter window surround ⓘ
- The rear pillar trim ⓘ

Remove the rear seats  (3 rd row ) (according to equipment) .

Tilt the rear seats forward  (2 rd row ) .

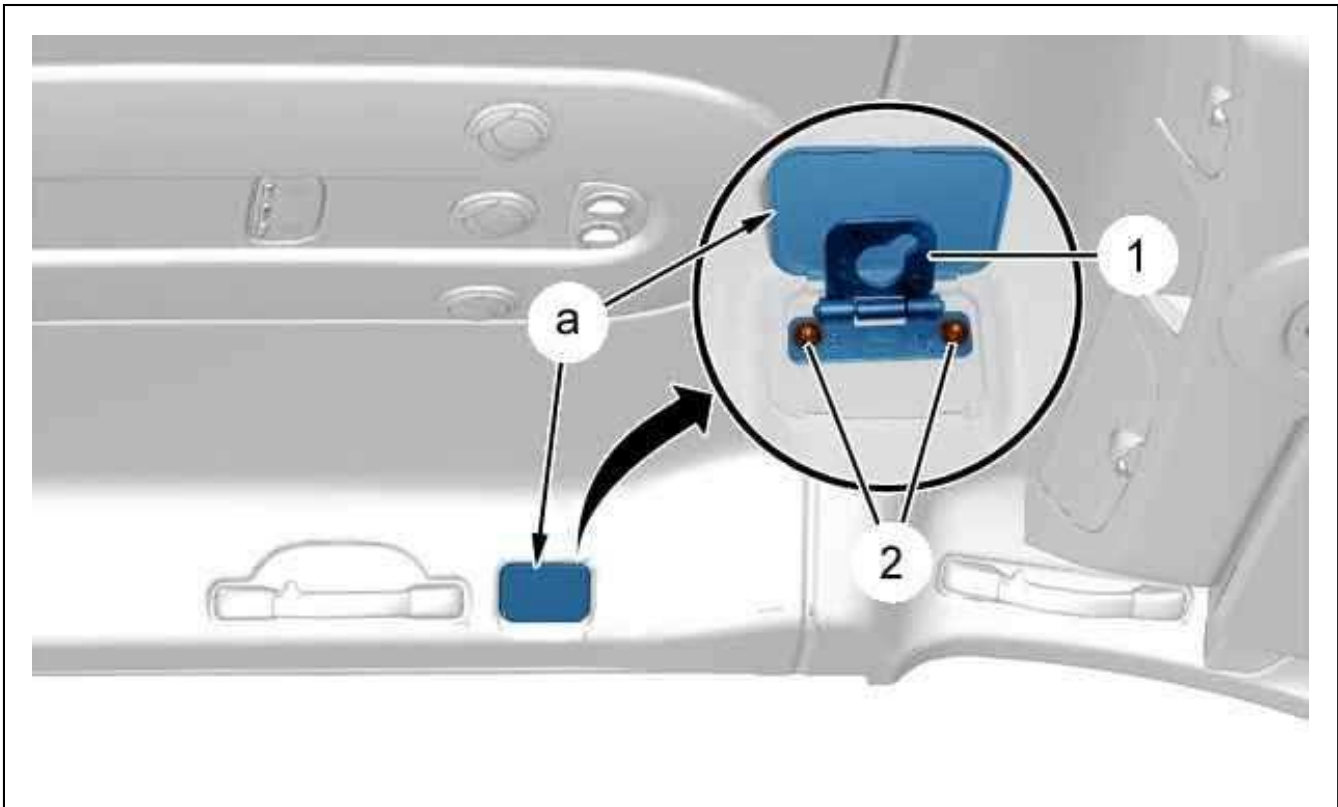


Figure : C5GP11AD

Open trim cover "a".

Remove :

- The bolts (2)
- The protective net fixing support (1)

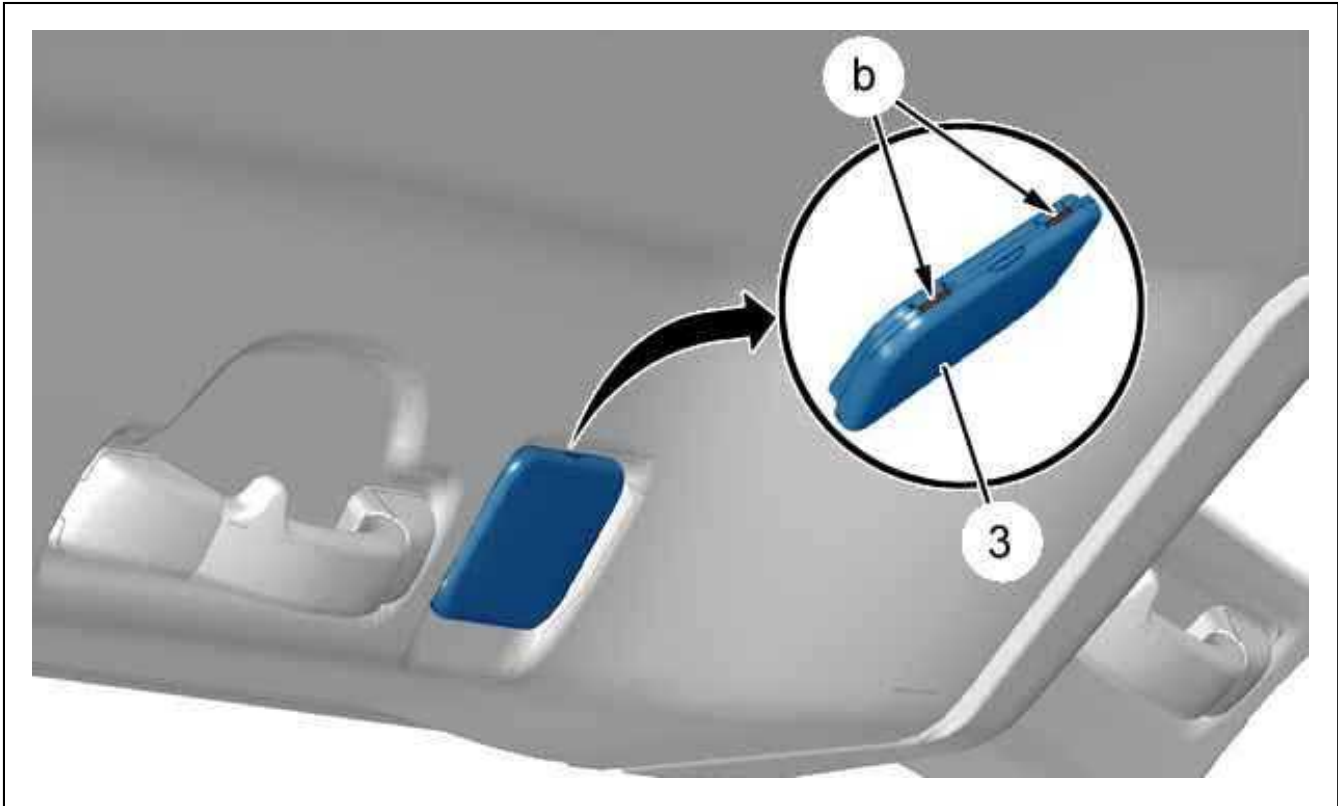


Figure : C5GP11BD

Unclip the protective net fixing housing (3) (as "b") ; Using tool [1].
Disengage and remove the protective net fixing housing (3).

N.B. : Proceed in the same way for the 3 other assemblies.

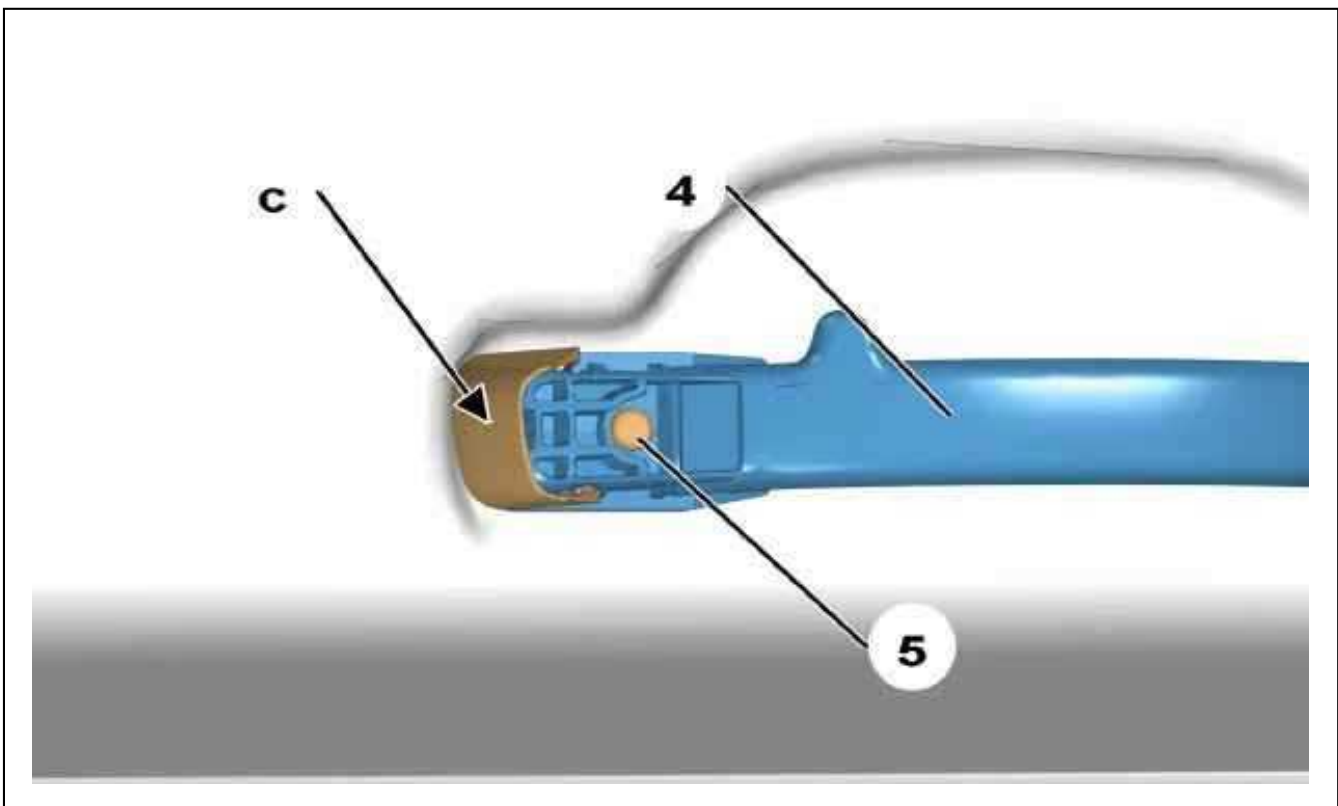


Figure : C5GP11CD

Unclip the hinged cover (as "c") : Using tool [1] (Symmetrical operation).
Remove bolts (5) (Symmetrical operation).
Remove the grab handle (4).

N.B. : Proceed in the same way for the other grab handles .

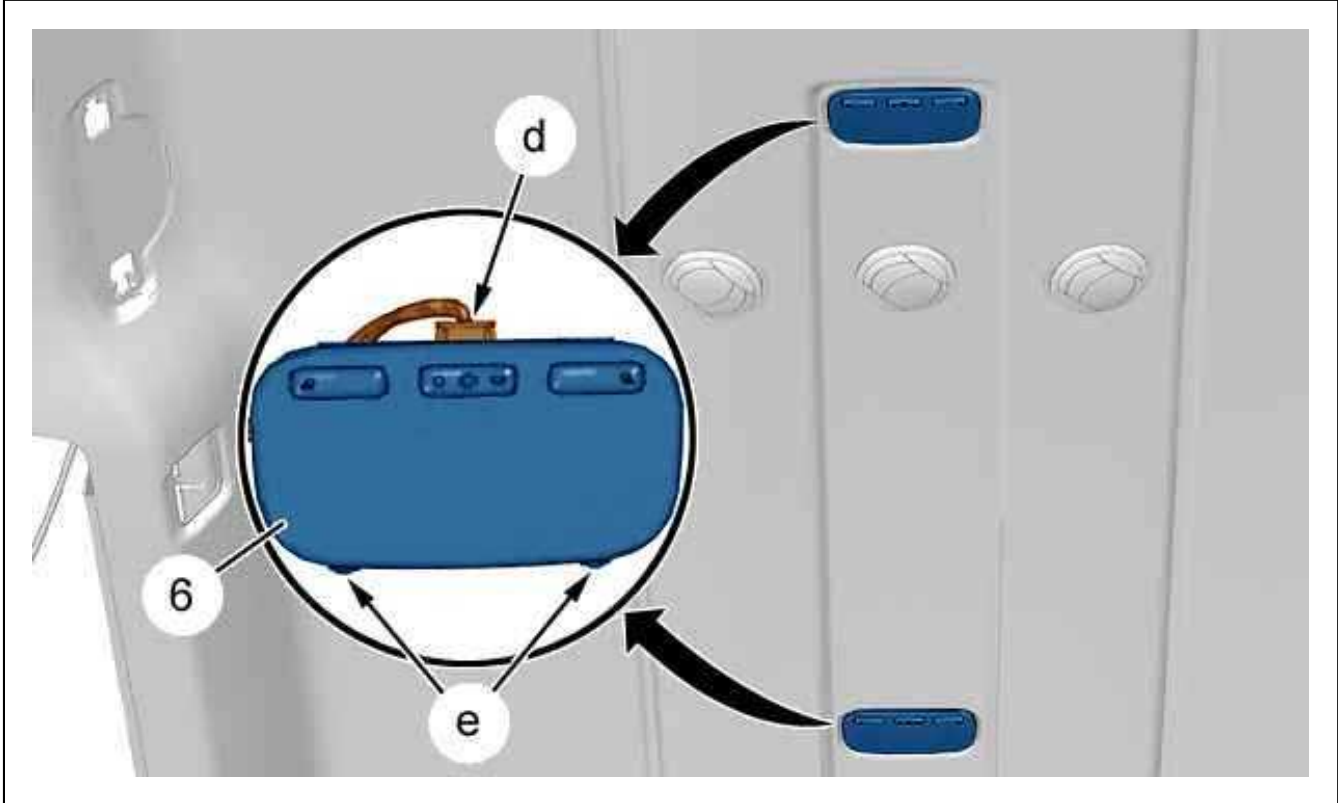


Figure : C5GP11DD

Unclip the roof lamp (6) (as "e") ; Using tool [1].
Disconnect the connector(s) (as "d") (According to equipment).
Remove the roof lamp (6).

N.B. : Proceed in the same way for the other roof lamp .

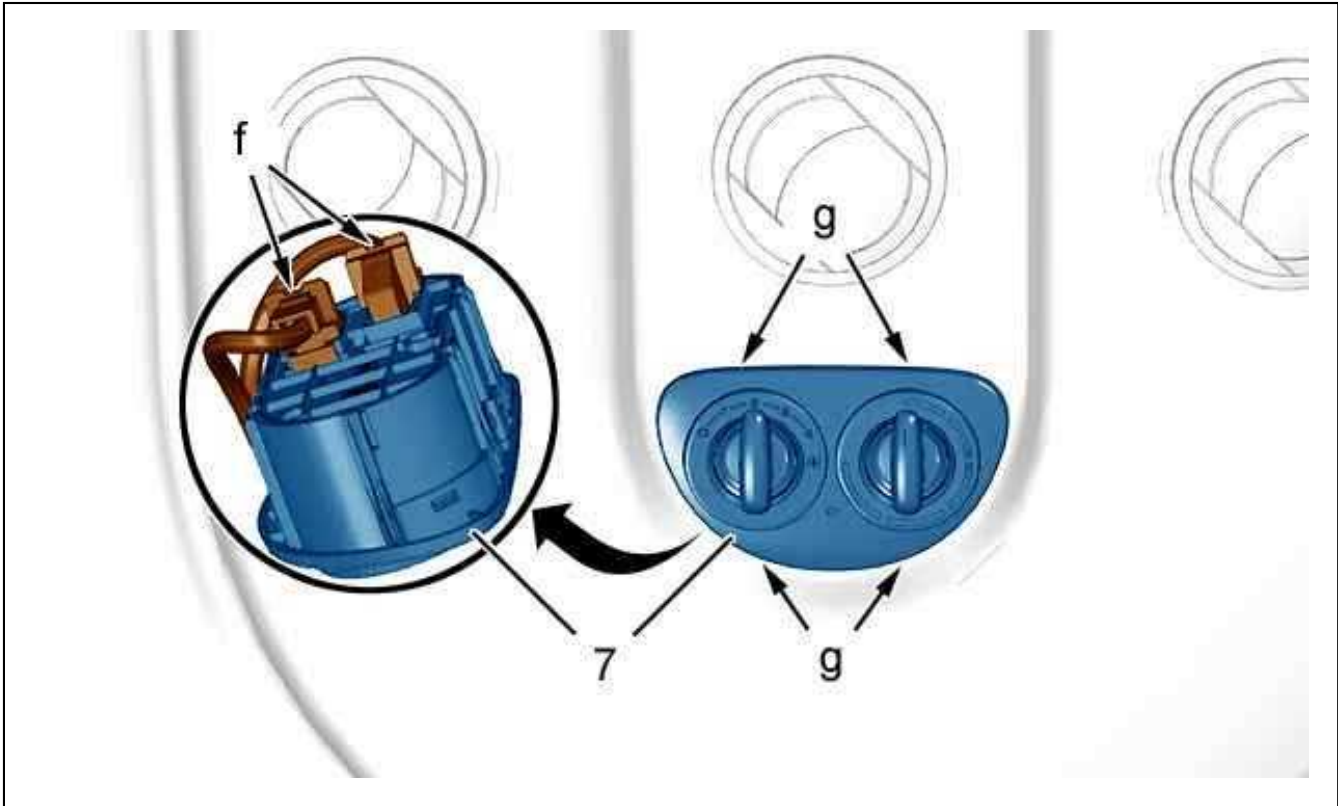


Figure : C5GP11ED

Unclip the rear air conditioning (7) control unit (as "g") ; Using tool [1].
Disconnect the connectors (as "f").
Remove the rear air conditioning (7) control unit .

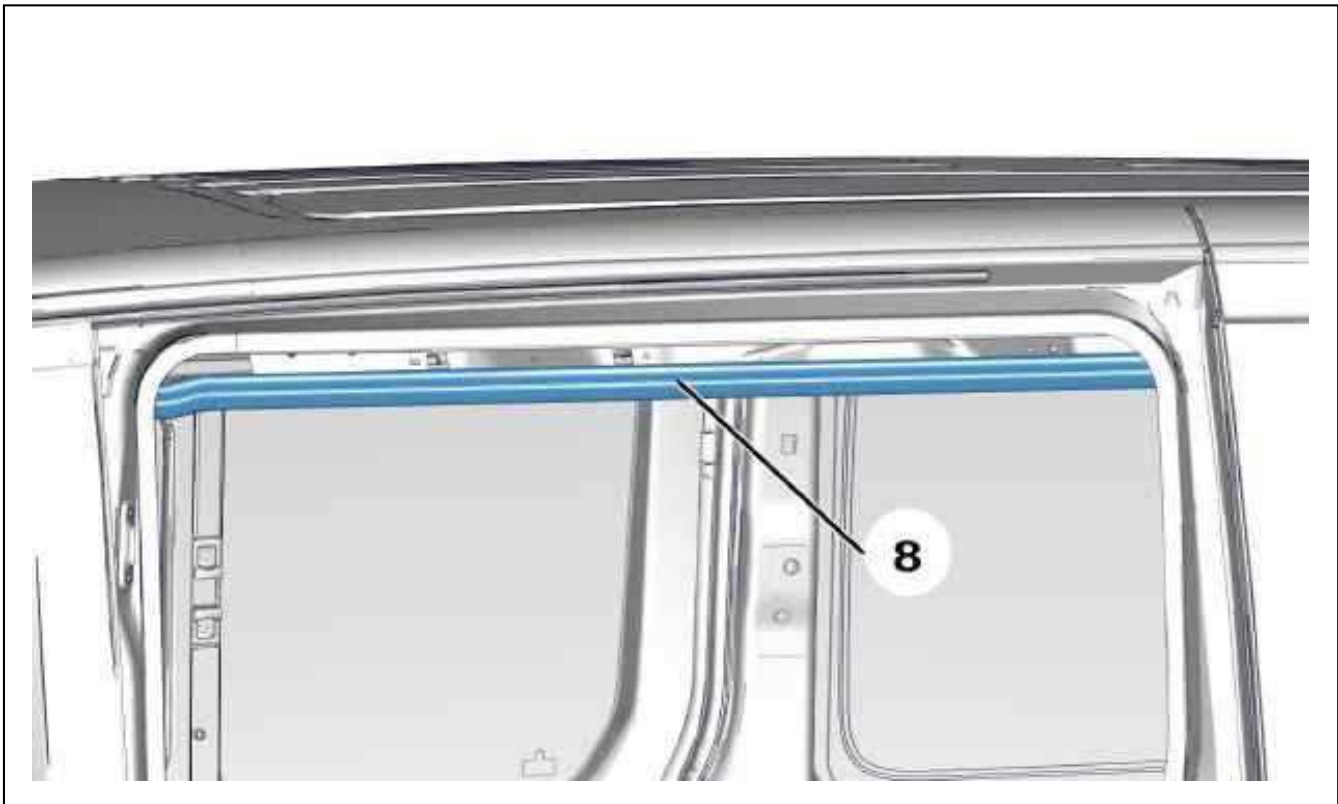


Figure : C5GP11FD

Remove the sliding door (8) rail seal (On both sides) ; Using tool [1].

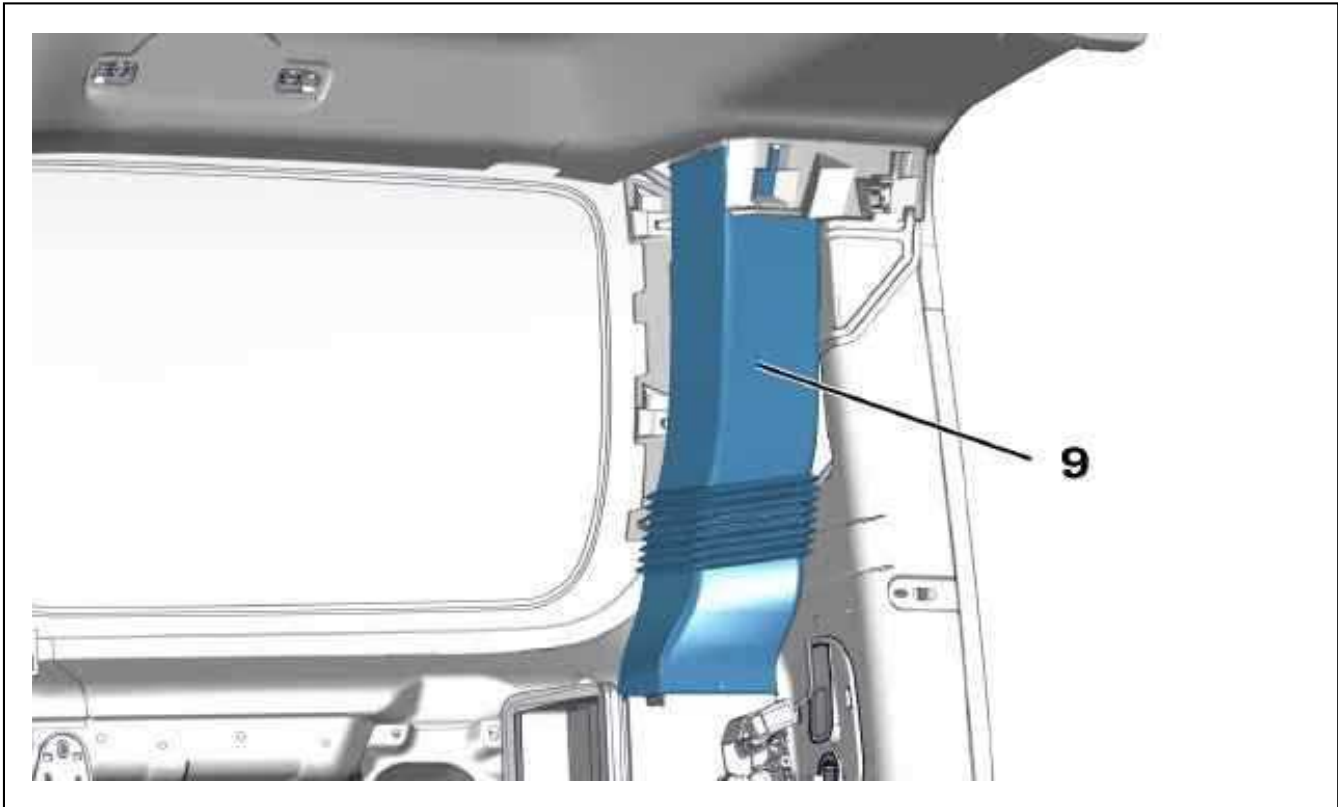


Figure : C5GP11GD

Remove the air conduit (9).

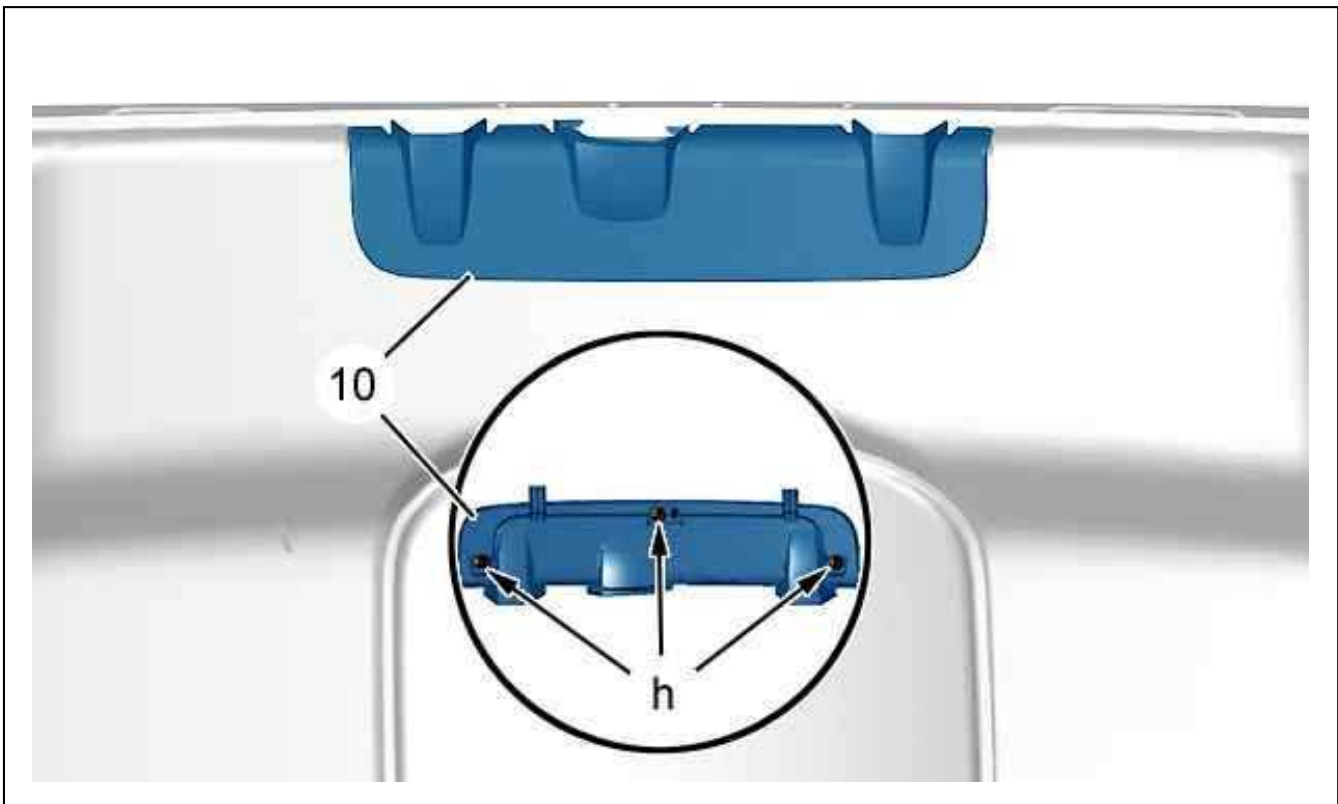


Figure : C5GP11HD

Unclip the cover (10) clips (as "h") ; Using tool [1].
Remove the cover (10).

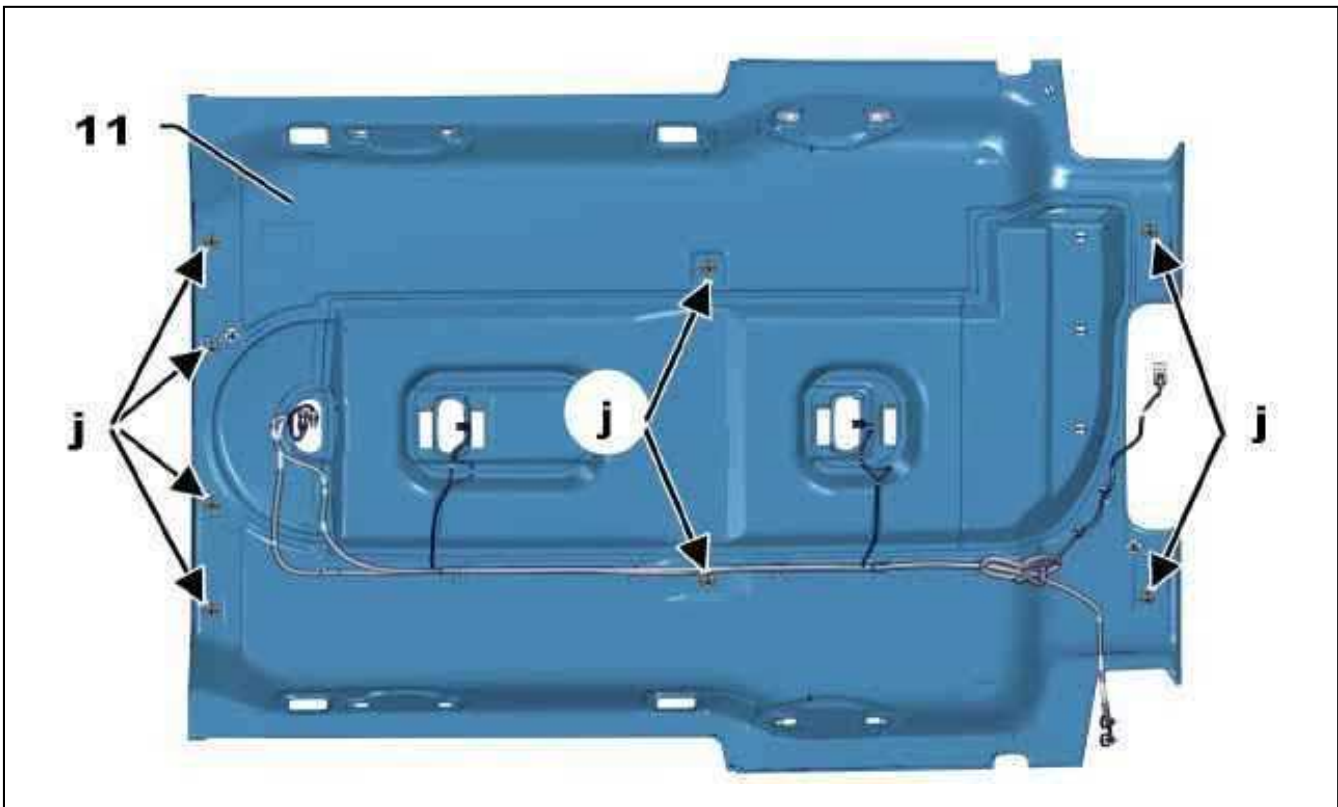


Figure : C5GP11JD

Unclip the rear headlining (11) clips (at "j").
Disengage the rear headlining (11).

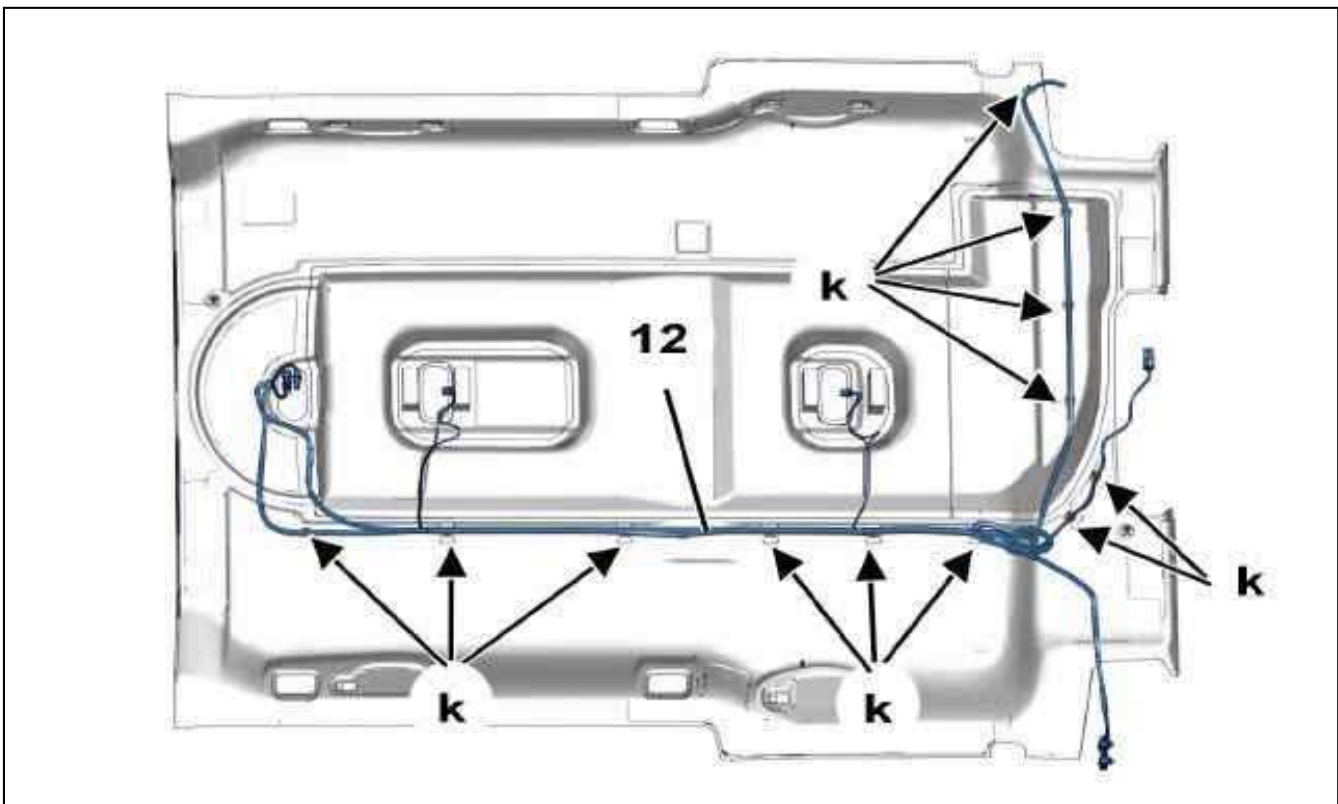


Figure : C5GP11KD

Unclip the rear headlining electrical harness (12) clips (as "k").
Disengage the rear headlining electrical harness (12).

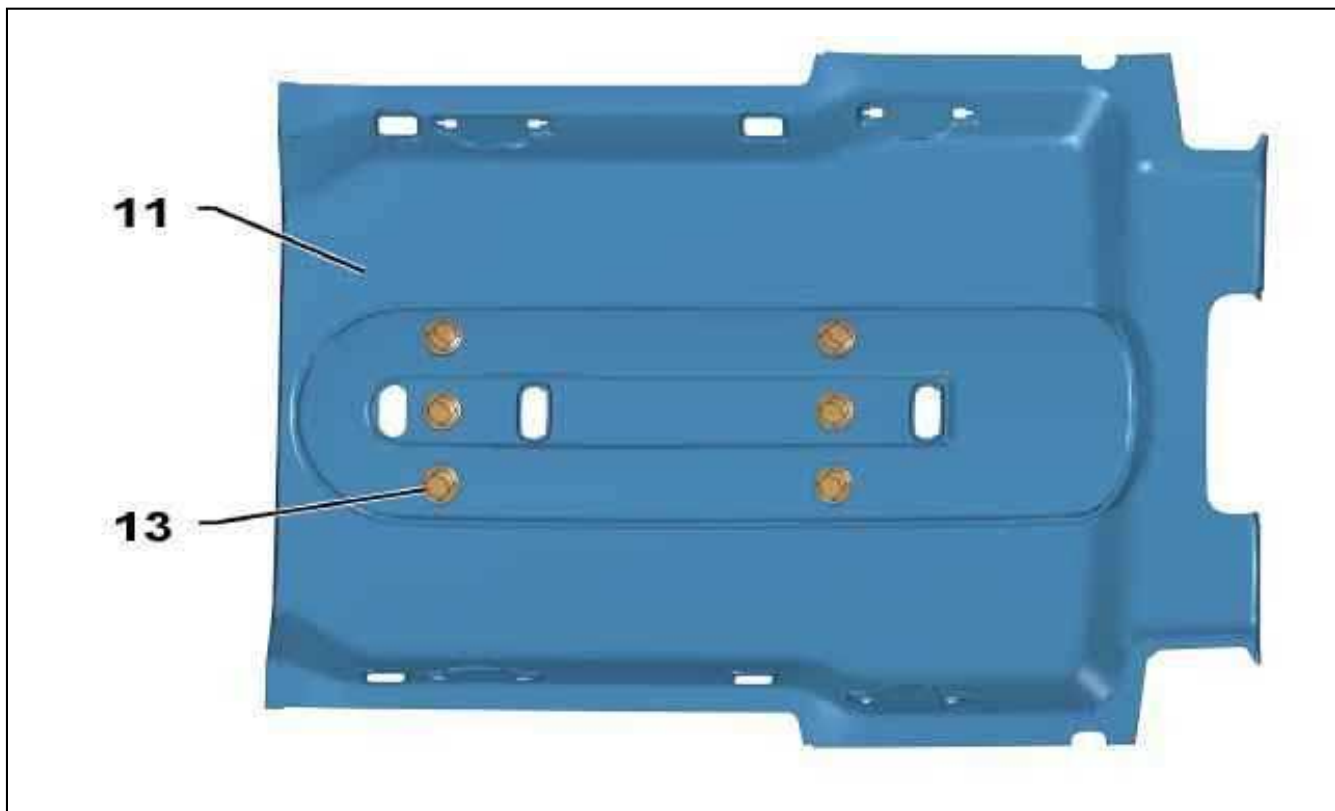


Figure : C5GP11LD

Remove the rear headlining assembly (11) with the air vents (13).

N.B. : Operation requiring two people.

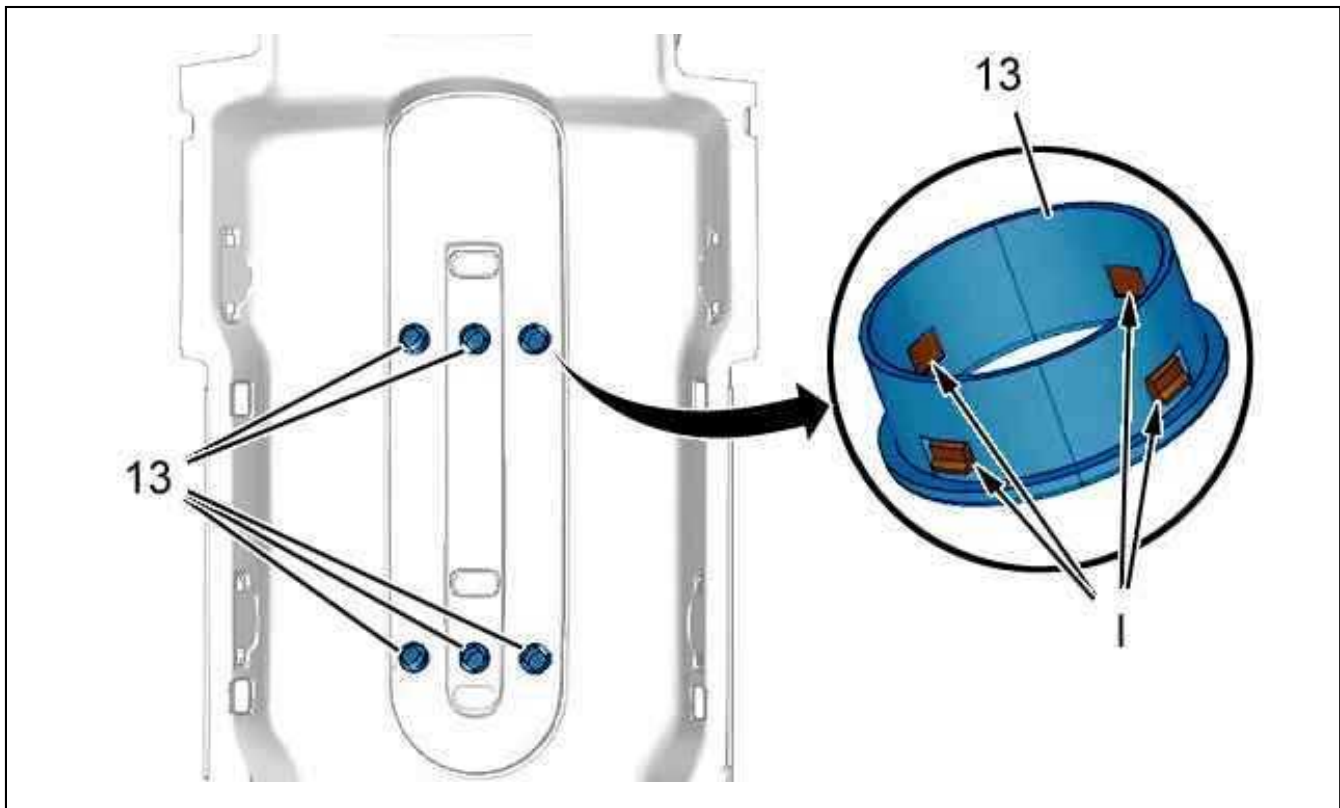


Figure : C5GP11MD

Unclip the air vent (13) (as "I") ; Using tool [1].

Remove the air vent (13).

N.B. : Proceed in the same way for the other vents .

2.2. Utility version

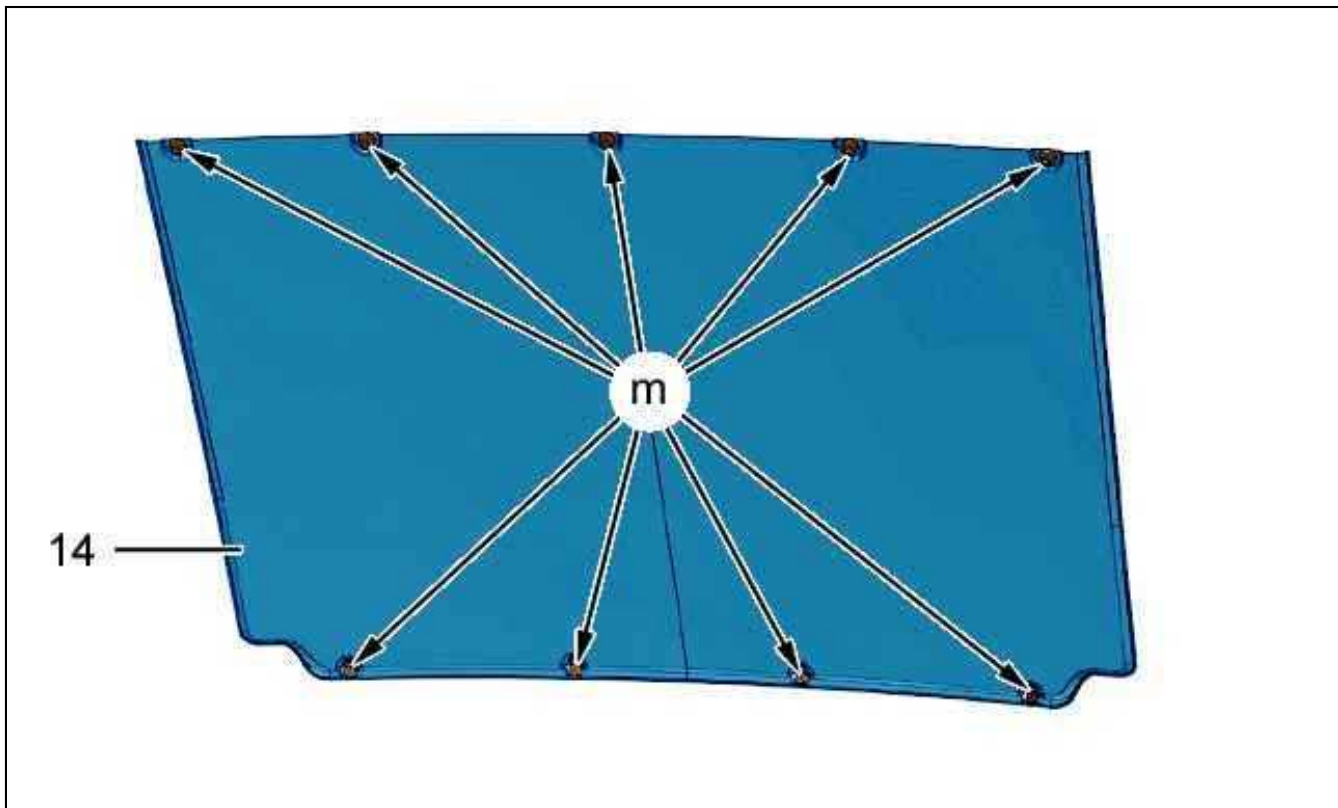


Figure : C5GP11ND

Unclip the rear headlining (14) clips (as "m") (*) ; Using tool [1].
Remove the rear headlining (14) (*).

N.B. : (*) According to equipment.

3. Refitting

CAUTION : Always replace the clips (as "h", "j", "m").

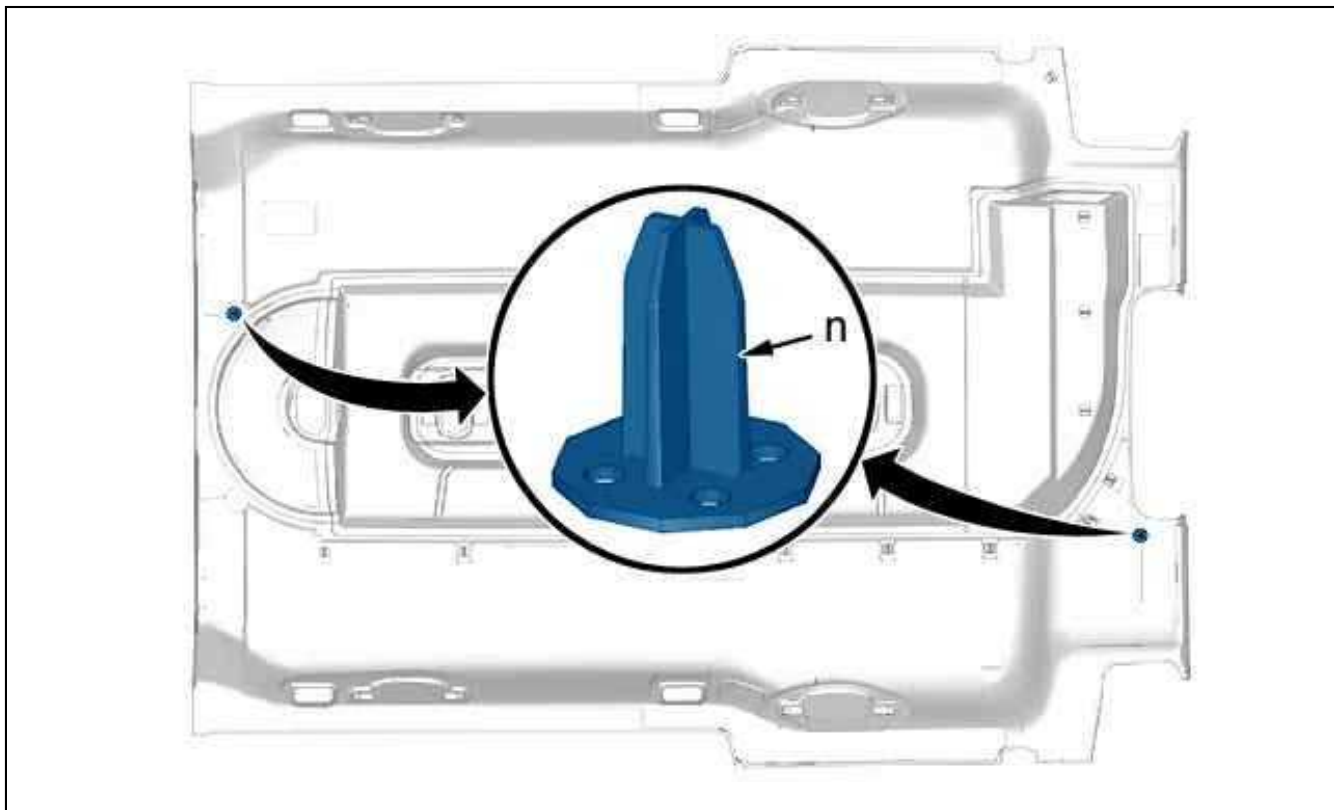


Figure : C5GP11PD

Position the rear headlining using the centring pins "n".

Proceed in the reverse order to removal.

Tighten :

- Screw (2) to $0,5 \pm 0,1$ daNm
- Screw (5) to $0,2 \pm 0,1$ daNm

Reconnect the battery.

CAUTION : Perform the operations to be carried out following reconnection of the battery ⓘ.

Check all the equipment works.