Espace

4 Sheet metal work

5 Mechanisms and accessories

JE0 AL - JE0 EL - JE0 HL

77 11 196 742 DECEMBER 1997 **Edition Anglaise**

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

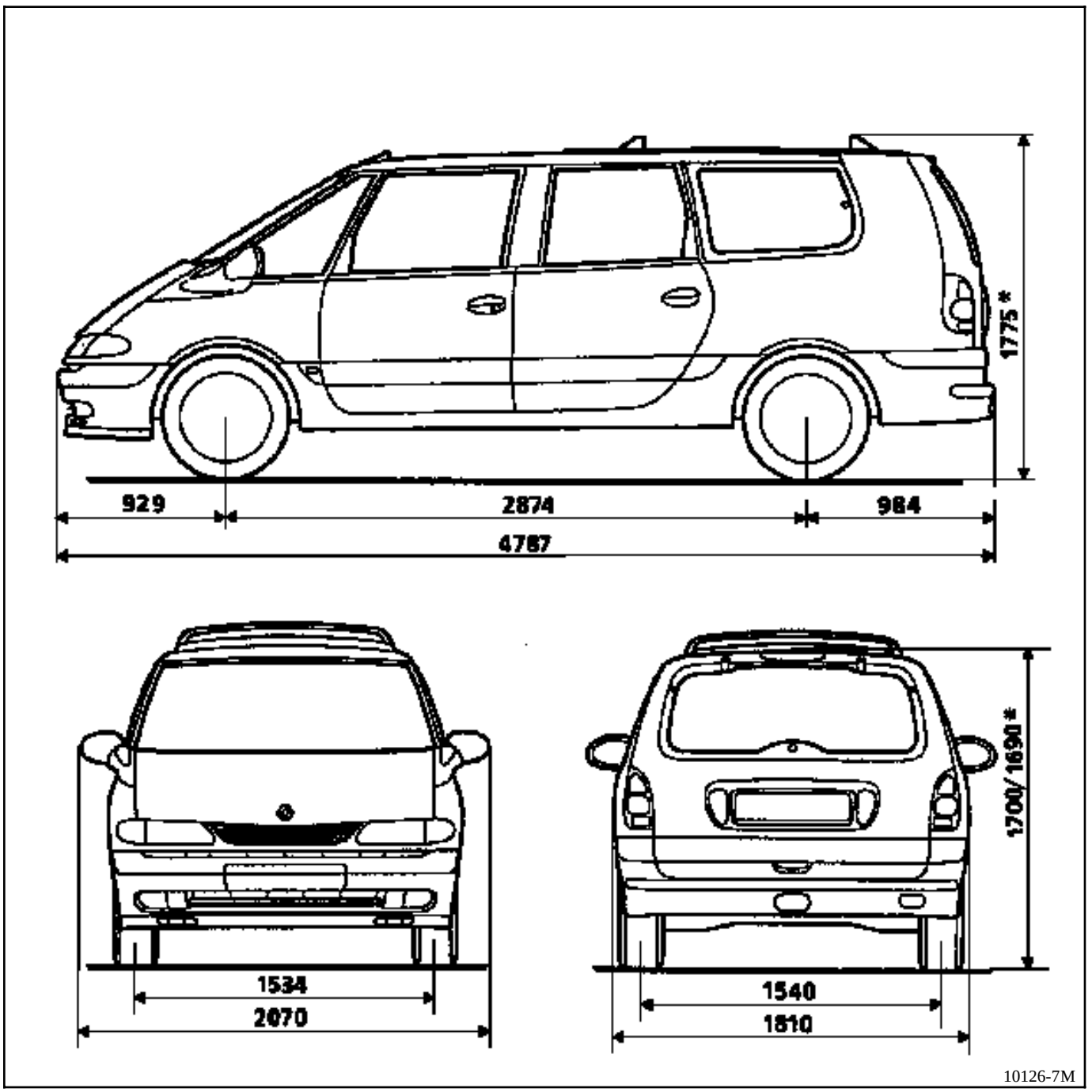
The methods may be modified as a result of changes introduced by the manufacturer in the production of the various component units and accessories from which his vehicles are constructed."

Sheet metal work

Contents

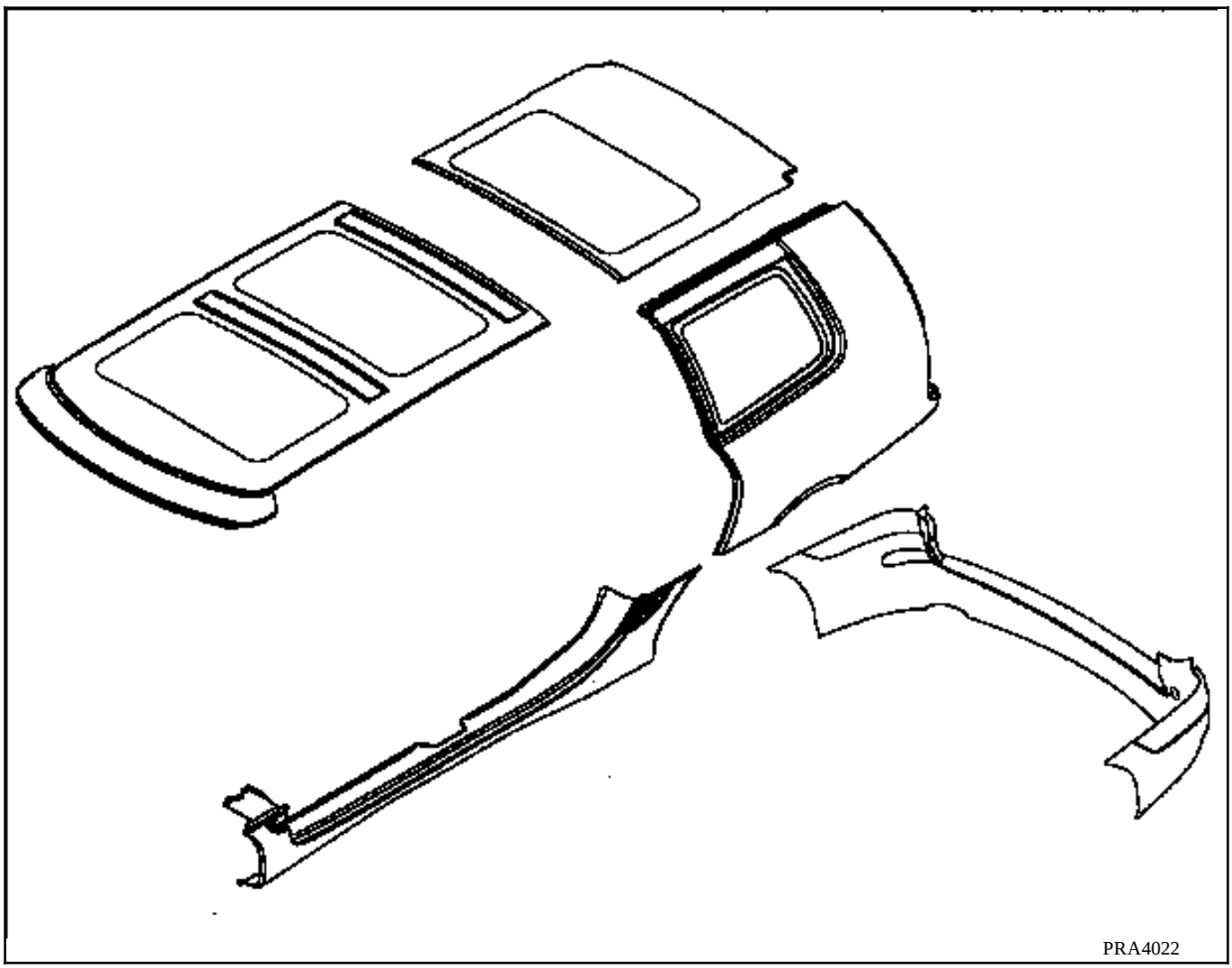
Mechanisms and accessories

Contents



* Unladen ** Depending on version
Dimensions in millimetres

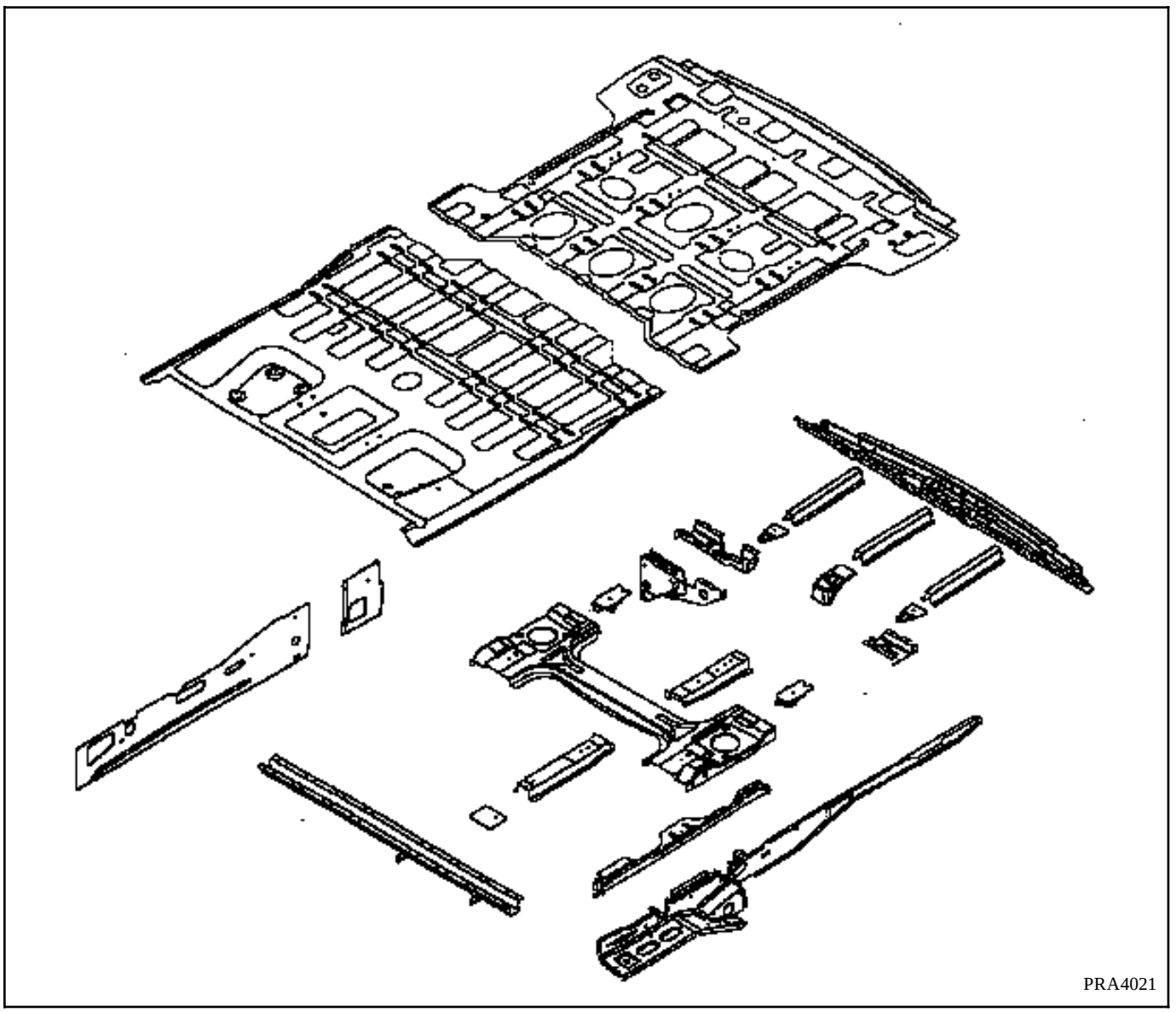
Vehicle type	Engine		Clutch type	Gearbox type
	Type	Capacity		
JE0 AL5	F3R 768	1998	215 DBRN 4400	JC5 061
JE0 EL5	G8T 716	2188	B02300308	PK1 064
JE0 HL5	G8T 714	2188	B02300308	PK1 064



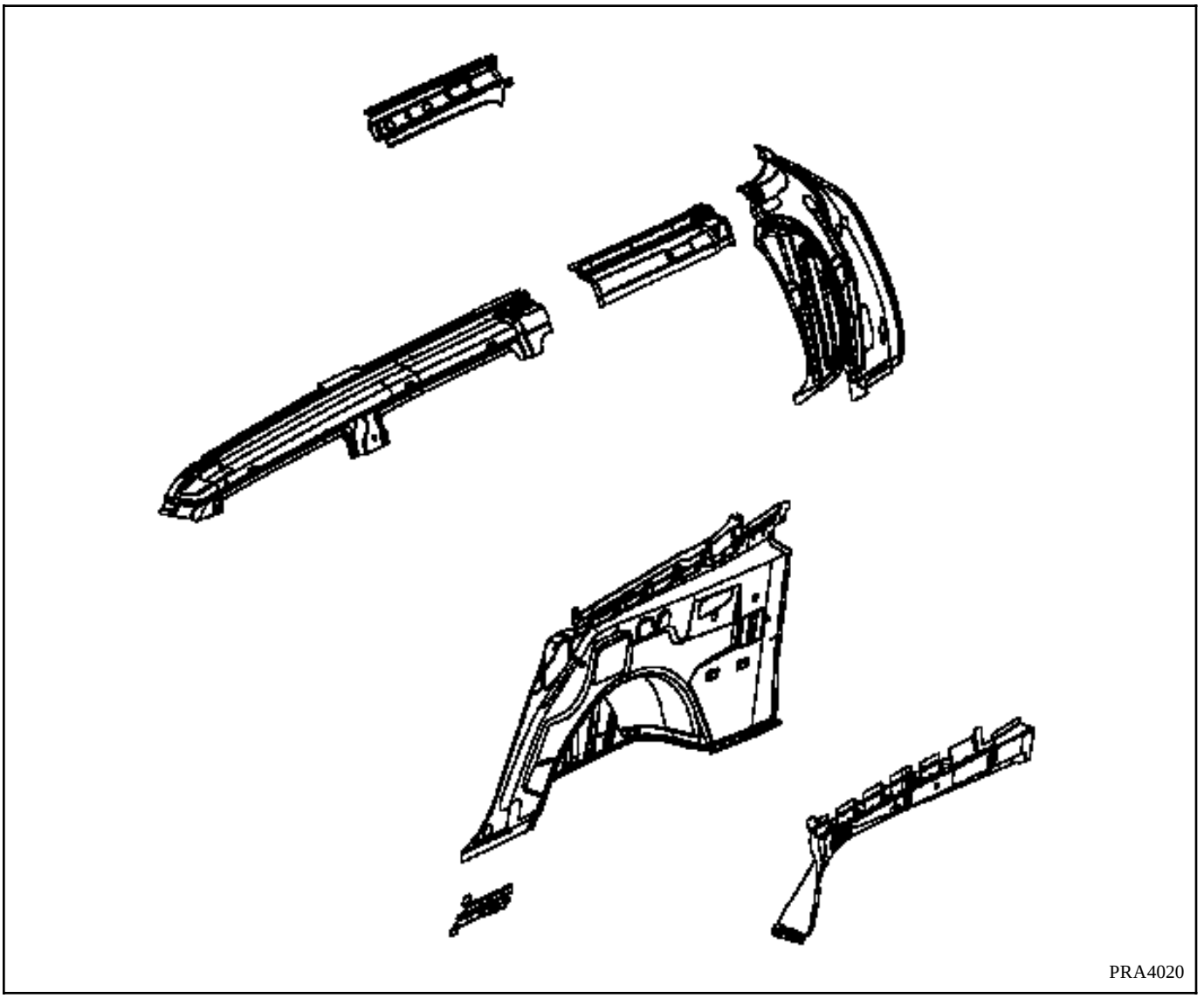
PLASTIC STRUCTURE

PARTS SPECIFIC TO THE "GRAND ESPACE"

1 Front roof
2 Rear roof
3 Rear wing
4 Sill panel
5 Rear bumper

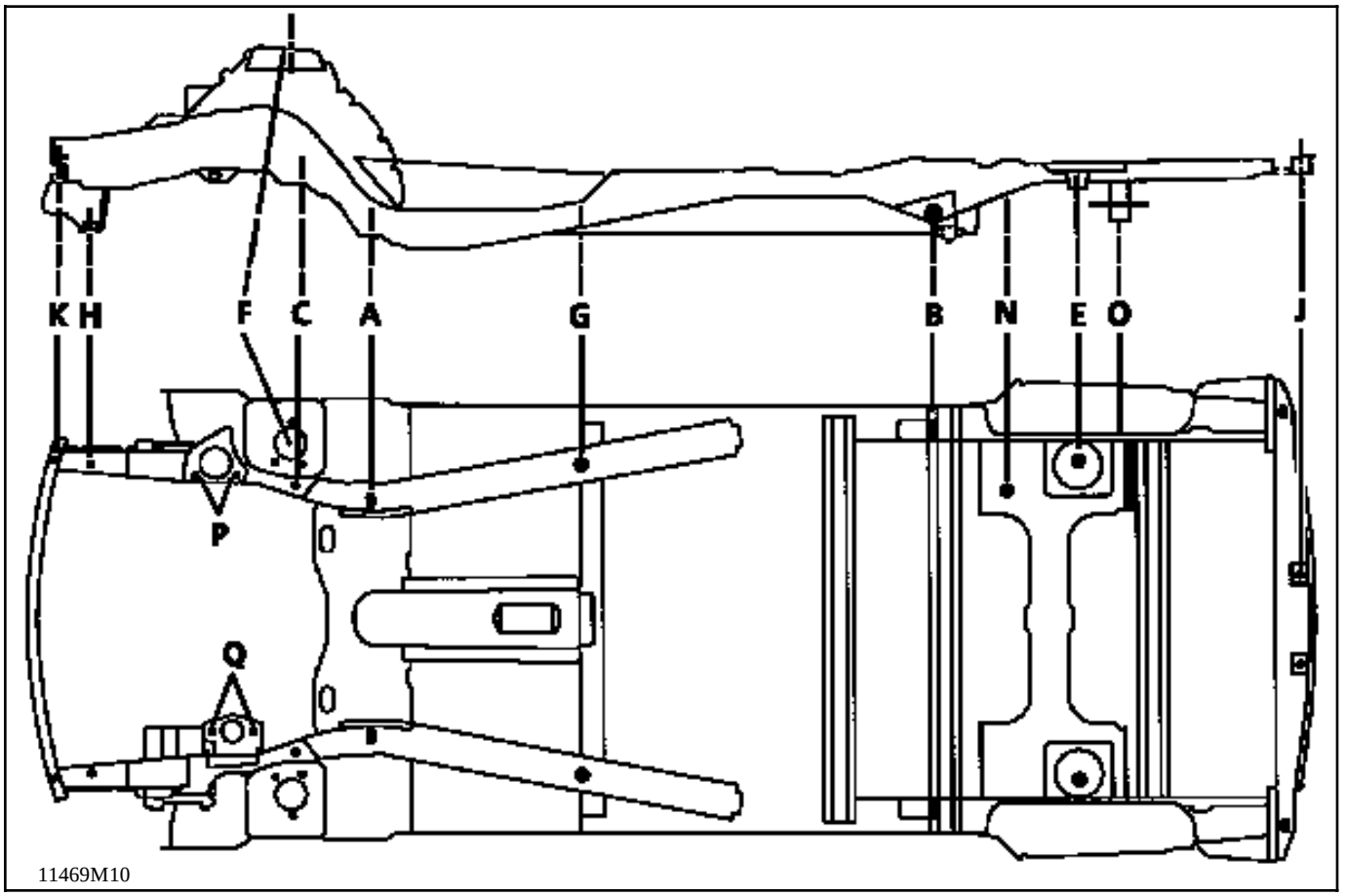


1 Front cross member of seats
2 Centre floor
3 Valance rear closure panel
4 Rear floor
5 Valance extension
6 Right hand side indexing plate
7 Side members under rear floor
8 Guiding clevice
9 Left hand side indexing plate
10 Third row seat mounting side member
11 Third row seat mounting reinforcement
12 Rear cross member side reinforcement
13 Rear side member, assembled
14 Third row seats, front mounting plates
15 Third row seat, front mounting side member
16 Rear axle cross member
17 Rear corner plate under the floor
18 Lower rear cross member

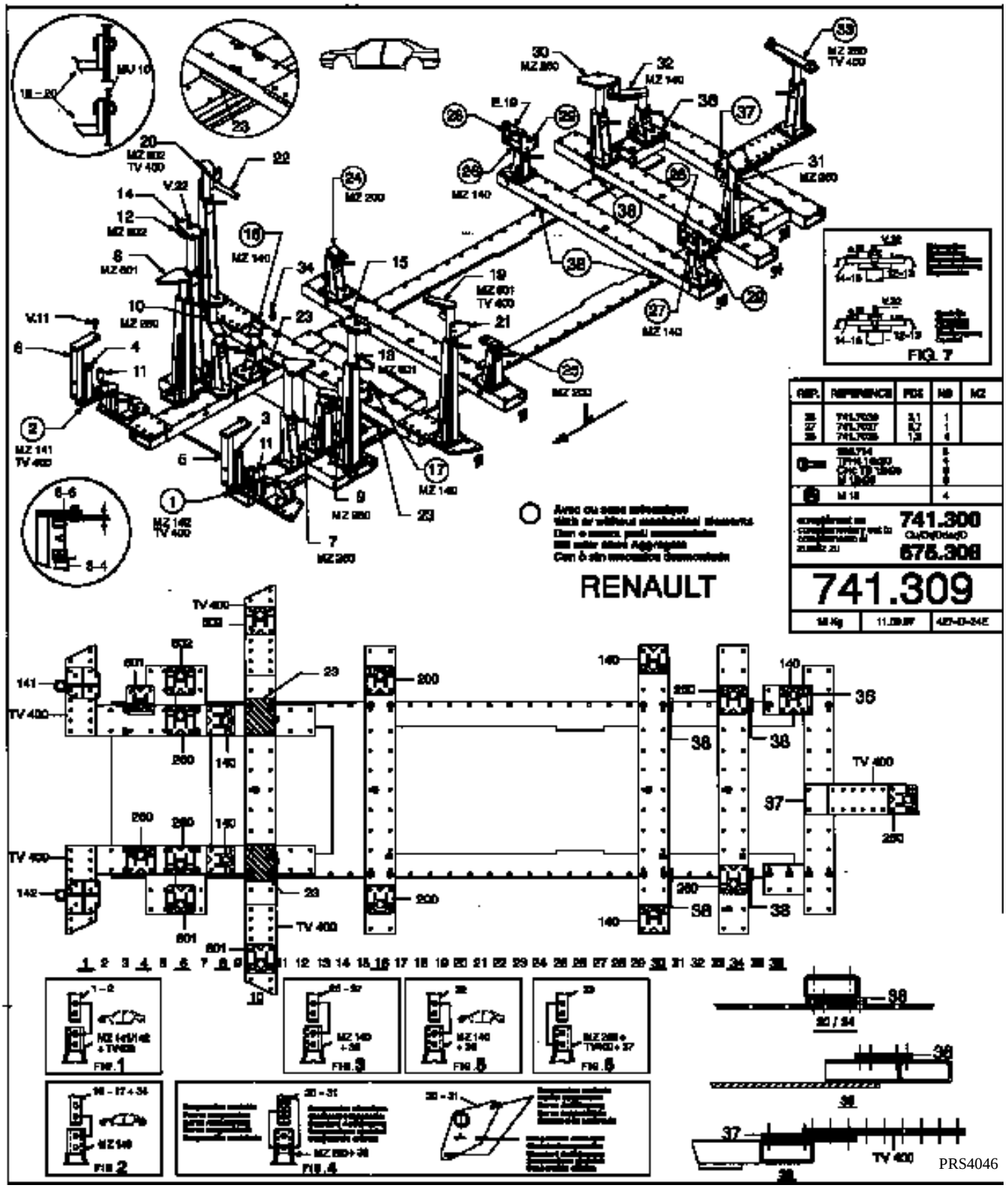


1 Front bonding bridge
2 Whole wheel arch
3 Rear quarter panel window lower stretchers
4 Rear quarter panel lining
5 Upper rear stretcher
6 Upper rear stretcher lining
7 Upper stretcher

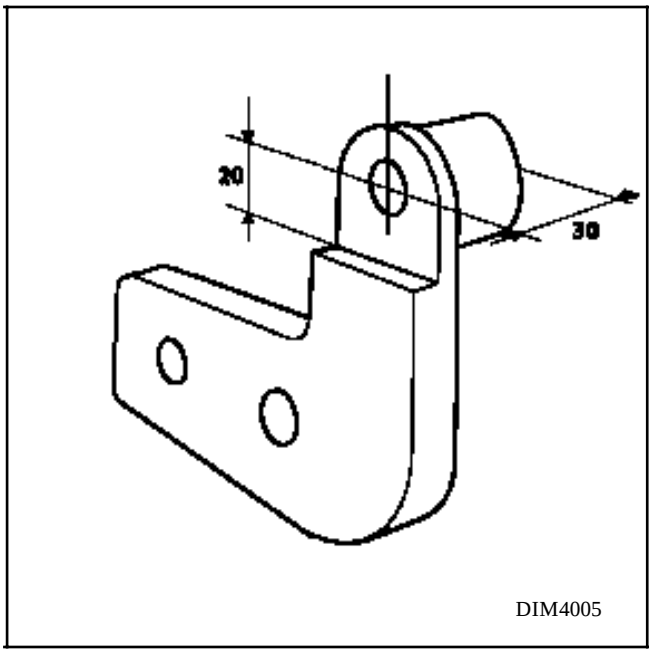
P52	DESCRIPTION	X	Y	Z	DIAMETER	SLOPE %
A	Front sub-frame rear mounting	299	397	19	20.5	0
B	Rear axle assembly tie-rod mounting	2327	630	79.7		
C	Front sub-frame front mounting	39.5	459.5	210	15.5	0
K	Front end cross member mounting	-777.8	543.7	196		00
F	Front shock absorber mounting support	23.2	598.7	629.6	10.2	0
O	Guide bar mounting	2953	560	69.7	10.2	0
H	Front end of front side member	-653.5	525	37	14.5	0
G	Rear section of front side member	995	525	31	24.4	0
E	Bumper mounting	2717	527.35	163.6	hexagonal	0
J	Rear end cross member	3656.5	145	222.7	14	0
P	Front engine mounting	-299	492	500	M10	0
P_1	Rear engine mounting	-159	492	500	M10	00
Q	Front gearbox mounting	-258.3	-411.5	359	M12	0
Q_1	Rear gearbox mounting	-124.8	-411.5	359	M12	0
N	Rear axle cross member reference point	2618	477		15	0


K
H
F
C
A
G
B
N
E
O
J
P
Q
11469M10

FITTING CELETTE BRACKETS



MODIFICATION OF CELETTE TOOLING



Countersink the upper parts of :
part n° 741.70. 28. with head n° 26.
part n° 741.70. 29. with head n° 27.
Consult the fitting plan for Celettebrackets.

Parts modified in this way become multi-purpose, or they can be ordered under Celette part number: 741.308.

PART NUMBERS FOR SPECIAL TOOLS

Specific support for the **CELETTE Repair Bench , MZ SYSTEM**

Order from : Consult your After Sales Head Office

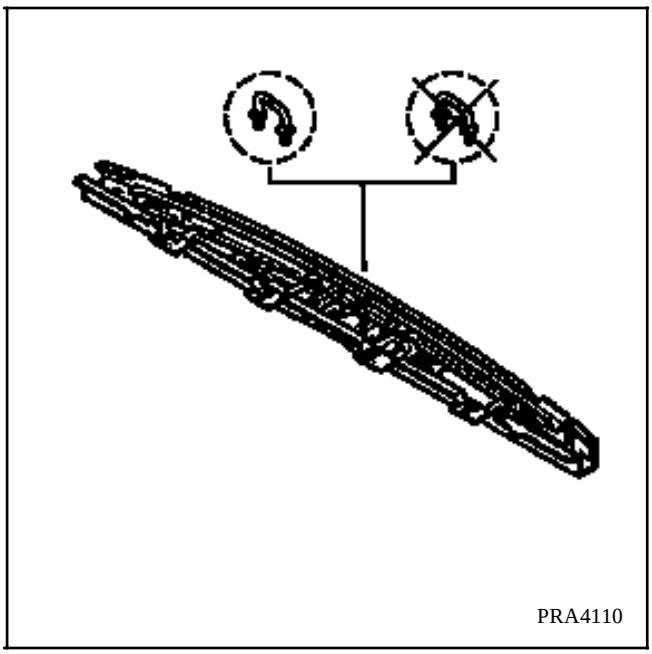
Supplier's part number :
- complete fitting 741.300
- complementary fitting 741.309

INTRODUCTION

The replacement of this part is a basic operation for a rear impact or is complementary to the rear end pillar for a side impact.

The repair should be carried out using a repair bench.

COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT



Preliminary operations.

Remove:
- the mud guards,
- the bumper,
- the bumper cross member,
- the tailgate seal,
- the wheel arch trim,
- the anchoring covers,
- the floor trim,
- the emergency spare wheel,
- the exhaust,
- part of the wiring loom,
- part of the soundproofing.

1 JOINT WITH EXTERIOR SIDE MEMBER

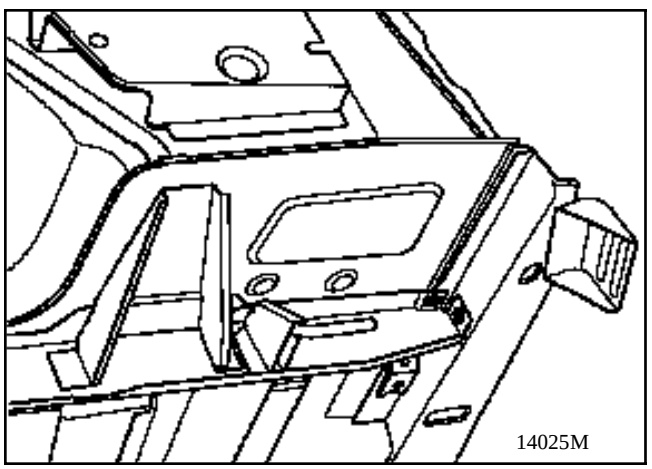
Thickness of the panels (mm)

Lower rear cross member	2.0
Exterior side member	2.5

Unpick

2 spot welds on a thickness of 2.0

Weld



2 JOINT WITH CONNECTING PANEL

Thickness of the panels (mm)

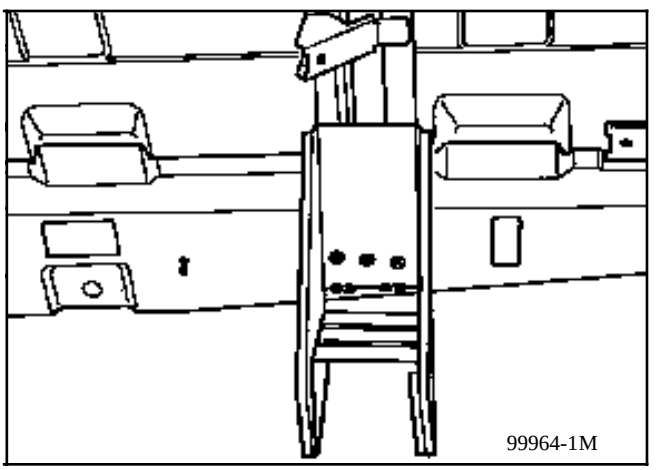
Lower rear cross member	2.0
Connecting panel	2.0

Unpick

3 spot welds on a thickness of 2.0

+ 2 x 15 mm weld beads

Weld



3 JOINT WITH REAR CENTRE CONNECTING PLATE

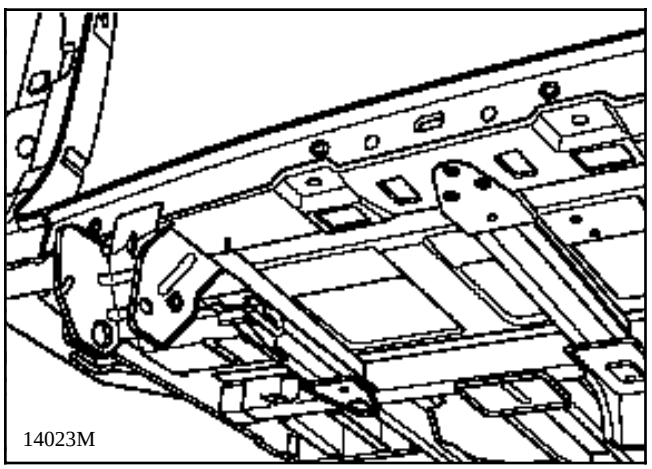
Thickness of the panels (mm)

Lower rear cross member	2.0
Rear centre connecting plate	1.5

Unpick

3 spot welds on a thickness of 2.0

Weld



4 JOINT WITH STRIKER PLATE MOUNTING REAR GUSSET

Thickness of the panels (mm)

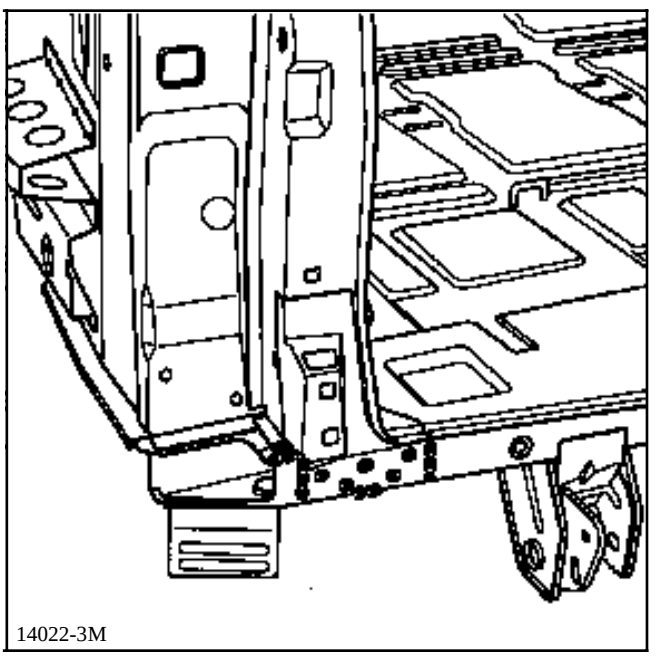
Lower rear cross member	2.0
Striker plate mounting rear gusset	2.0

Unpick

6 spot welds on a thickness of 2.0

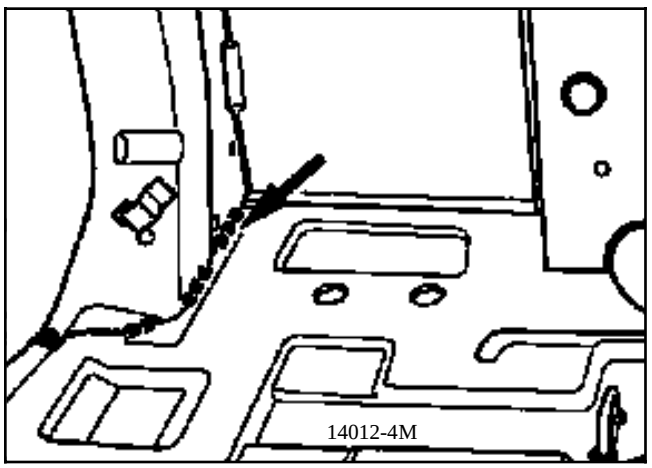
+2 x 30 mm MAG weld beads
+2 x 20 mm MAG weld beads

Weld



5 JOINT WITH REAR END PILLAR

REMINDER: refer to operations **44-D-3**, 3 x 30 mm welds and 1 spot weld.



6 JOINT WITH REAR FLOOR

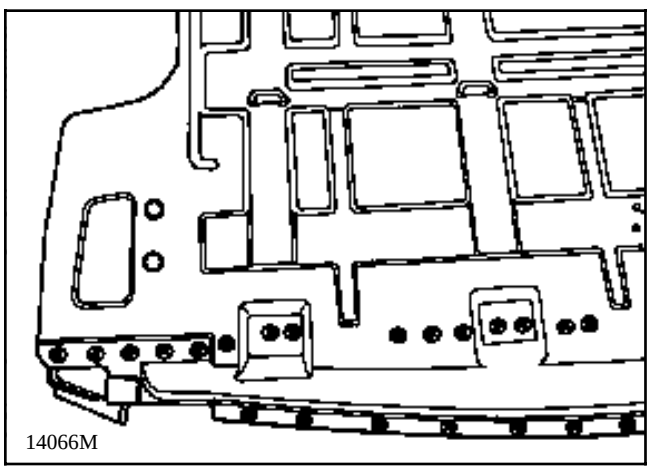
Thickness of the panels (mm)

Lower rear cross member	2.0
Floor	0.8

Unpick

45 spot welds on a thickness of 2.0

Weld

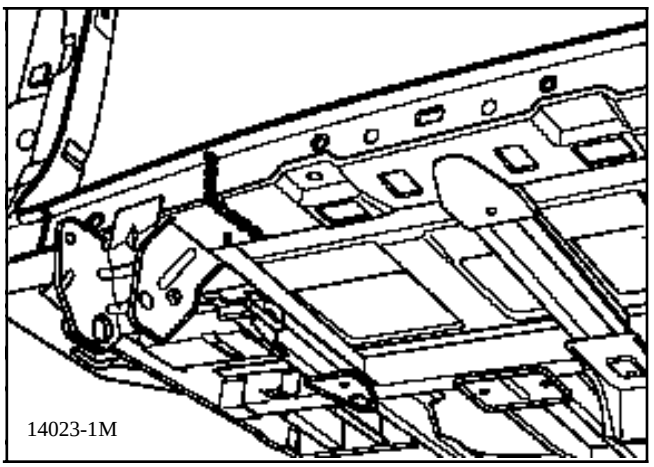


7 PARTIAL CUT

Unpick

250 mm on a thickness of 2.0

Weld

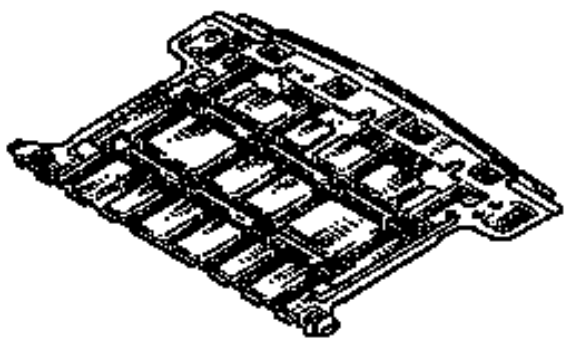


NOTE : refer to Paint Workshop Repair Manual 601, section 95, for protection and sealing .

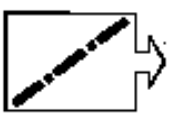
INTRODUCTION

The replacement of this part is a complementary operation to the replacement of the lower rear cross member, the rear side member, and the rear end pillar for a rear impact, or of the wheel arch after a side impact.

COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT



PRA4124



Preliminary operations.

Remove:
- the bumper,
- the bumper cross member,
- the rear light,
- the rear wing panel,
- the tailgate seal,
- the wheel arch trim,
- the anchoring covers,
- the floor trim,
- the emergency spare wheel,
- the fuel tank
- the exhaust.

NOTE : for cutting and preparation before welding , refer to section 40, General.

NOTE : refer to Paint Workshop Repair Manual 601, section 95, for protection and sealing .

1 JOINT WITH FLOOR

Thickness of the panels (mm)

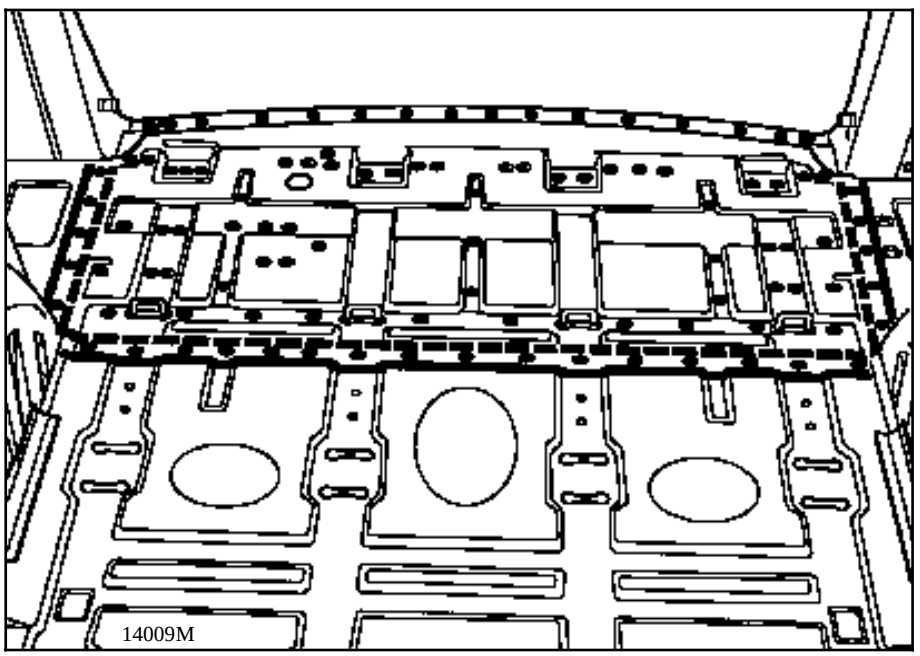
Rear floor	0.8
Exterior side member	2.5
Rear side member	1.5
Lower rear cross member	2.0

Unpick

93 spot welds on a thickness of 0.8

2690 mm weld on a thickness of 0.8

Weld



1 JOINT WITH FLOOR

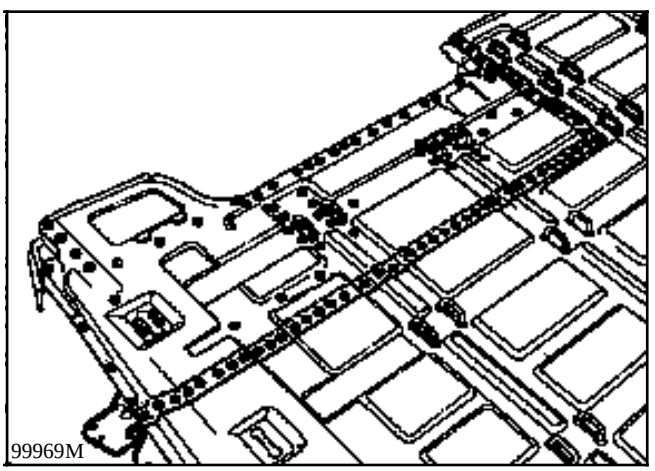
Thickness of the panels (mm)

Floor	0.8
Rear axle assembly cross member	2.0
Rear cross member of 3rd row seats	2.0
Rear side member	1.5
Lower rear cross member	2.0

Unpick

43 spot welds on a thickness of 0.8
+1500 mm on a thickness of 0.8

Weld



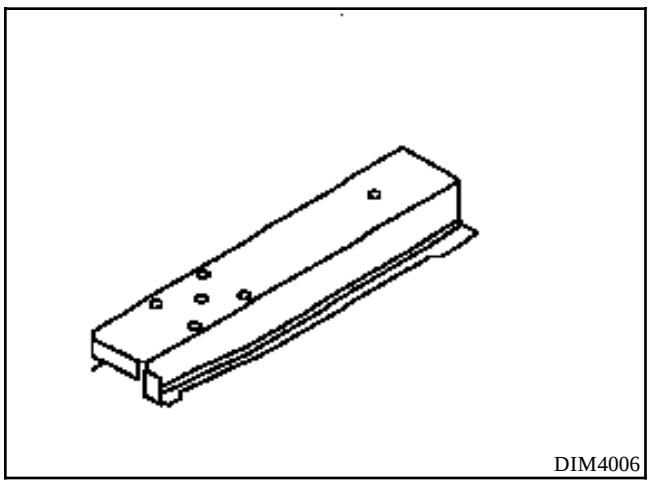
NOTE : refer to section 40, General, for cutting and preparation before welding .

NOTE : refer to Paint Workshop Repair Manual 601, section 95, for protection and sealing .

INTRODUCTION

The replacement of this part is a complementary operation to the replacement of the side floor, part section or the rear floor, part section.

COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT


DIM4006

Preliminary operations.

Remove:
- the emergency spare wheel,
- the wheel arch trim,
- the anchoring covers,
- the rear floor trim,
- part of the wiring loom,

on the right hand side
- the exhaust ,
- the emergency spare wheel winch,
- the fuel tank.

1 JOINT WITH FLOOR

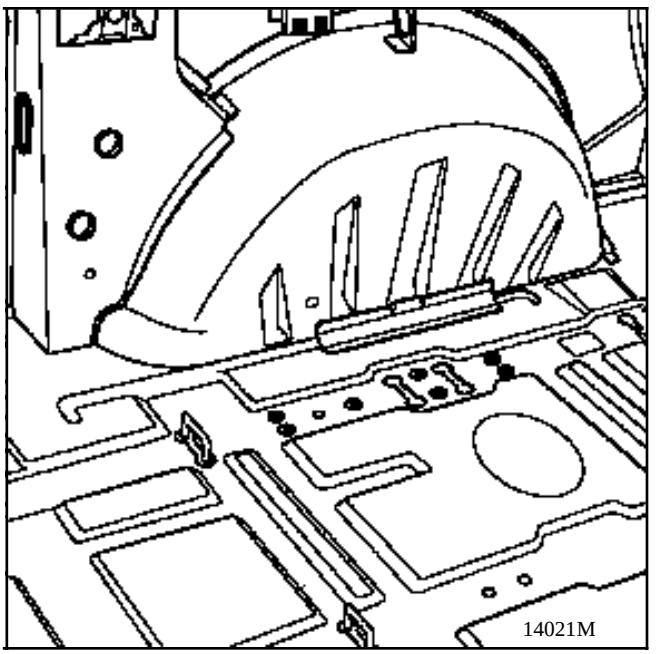
Thickness of the panels (mm)

Rear side member	2.0
Floor	0.8

Unpick


7 spot welds on a thickness of 0.8

Weld


14021M

2 JOINT WITH CONNECTING PLATE

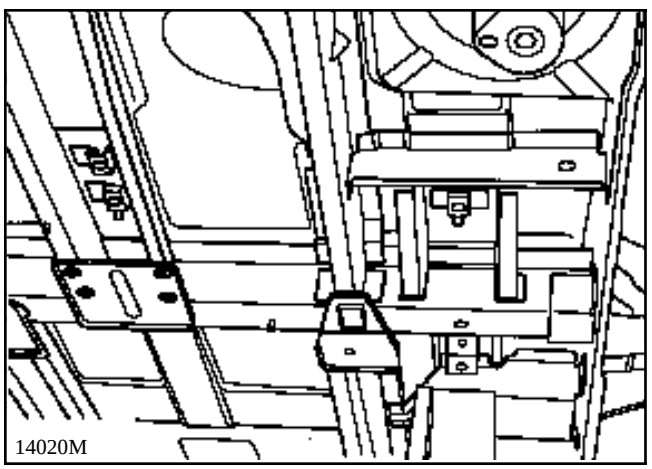
Thickness of the panels (mm)

Rear side member	2.0
Connecting plate	1.5

Unpick

4 spot welds on a thickness of 1.5

Weld



3 JOINT WITH REAR AXLE CROSS MEMBER

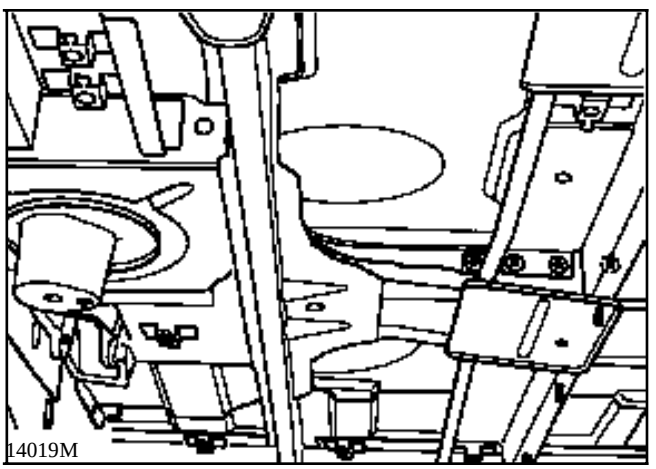
Thickness of the panels (mm)

Rear side member	2.0
Rear axle assembly cross member	2.0

Unpick

4 spot welds on a thickness of 2.0

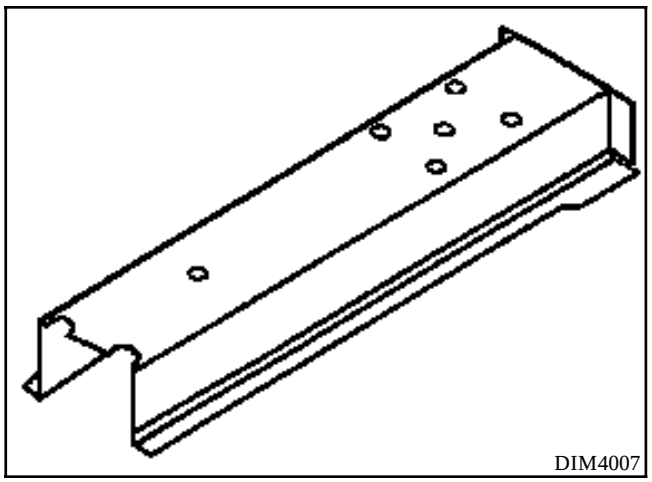
Weld



INTRODUCTION

The replacement of this part is a complementary operation to the replacement of the side floor, part section or the rear floor, part section.

COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT


DIM4007

Preliminary operations

Remove:
- the emergency spare wheel,
- the wheel arch trim,
- the anchoring covers,
- the rear floor trim,
- part of the wiring loom,

on the right hand side:
- the exhaust ,
- the emergency spare wheel winch,
- the fuel tank.

1 JOINT WITH FLOOR

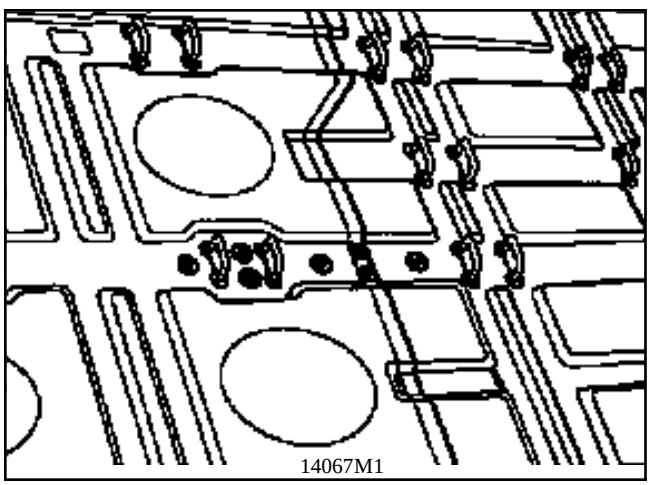
Thickness of the panels (mm)

Floor	0.8
Rear side member	2.0

Unpick

7 spot welds on a thickness of 0.8

Weld



2 JOINT WITH CONNECTING PLATE

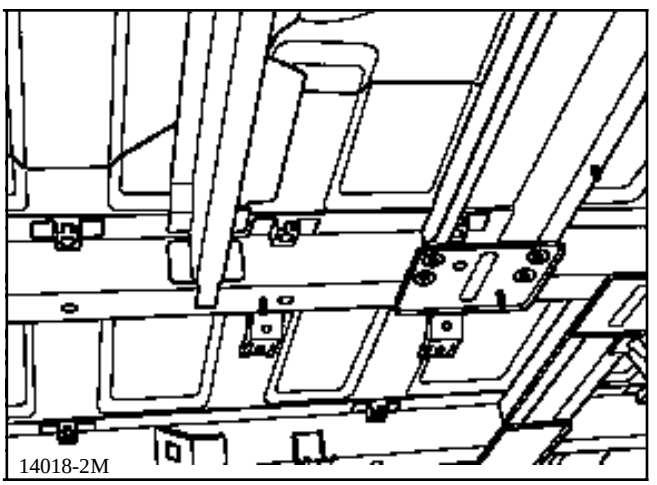
Thickness of the panels (mm)

Connecting plate	1.5
Rear side member	2.0

Unpick

4 spot welds on a thickness of 1.5

Weld



NOTE : refer to Paint Workshop Repair Manual 601, section 95, for protection and sealing .

3 JOINT WITH REAR AXLE ASSEMBLY CROSS MEMBER

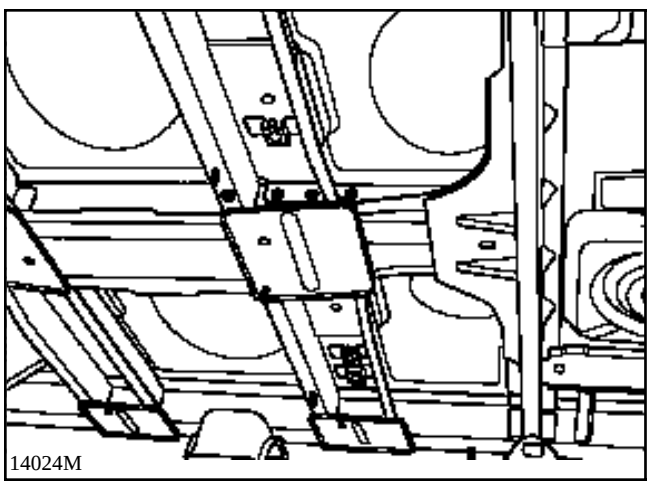
Thickness of the panels (mm)

Rear axle assembly cross member	2.0
Rear side member	2.0

Unpick

4 spot welds on a thickness of 2.0

Weld

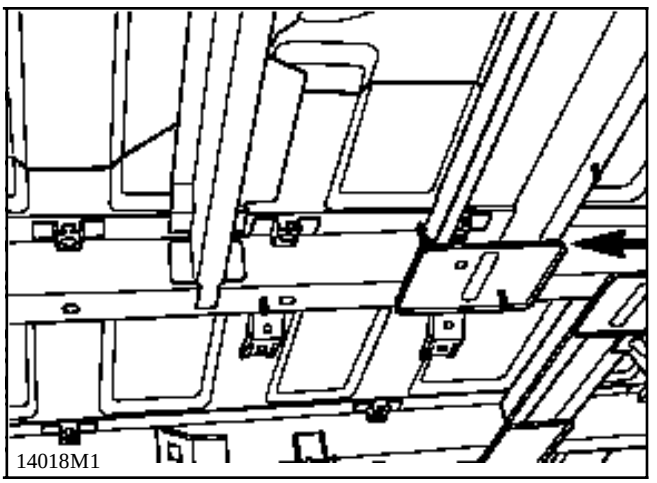


4 JOINT WITH 2nd ROW SEAT CROSS MEMBER

Unpick

2 x 20 mm weld beads, each on a thickness of 2.0

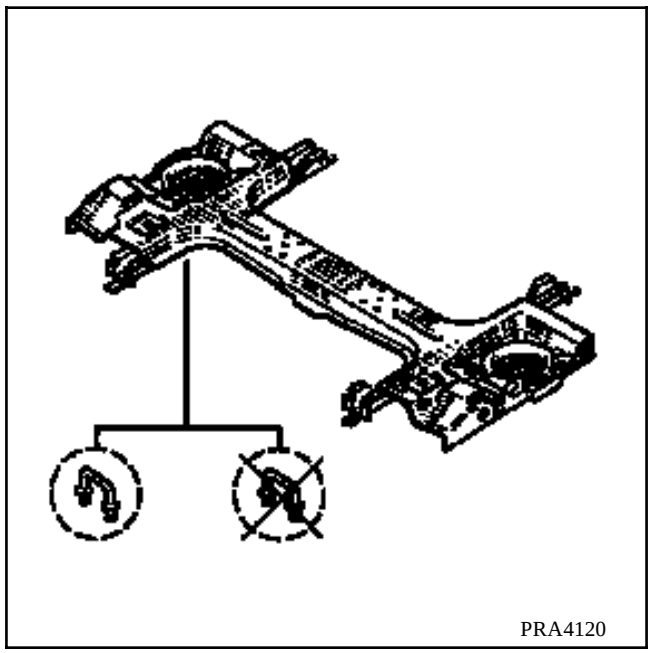
Weld



INTRODUCTION

The replacement of this part is a complementary operation to the replacement of the side floor, part section, of the whole wheel arch, and the complete side member for a side impact.

COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT


PRA4120

Preliminary operations.

Remove:
- the rear axle assembly,
- the exhaust,
- the fuel tank on the right hand side,
- the wheel arch trim,
- the anchoring covers,
- the floor trim .

1 JOINT WITH EXTERIOR SIDE MEMBER

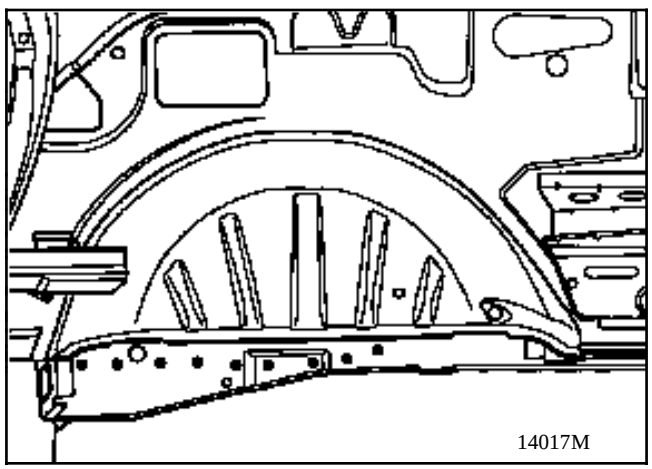
Thickness of the panels (mm)

Exterior side member	2.5
Rear axle assembly cross member, side reinforcement	2.0

Unpick

9 spot welds on a thickness of 2.0

Weld



2 JOINT WITH 2nd ROW SEAT REAR CROSS MEMBER

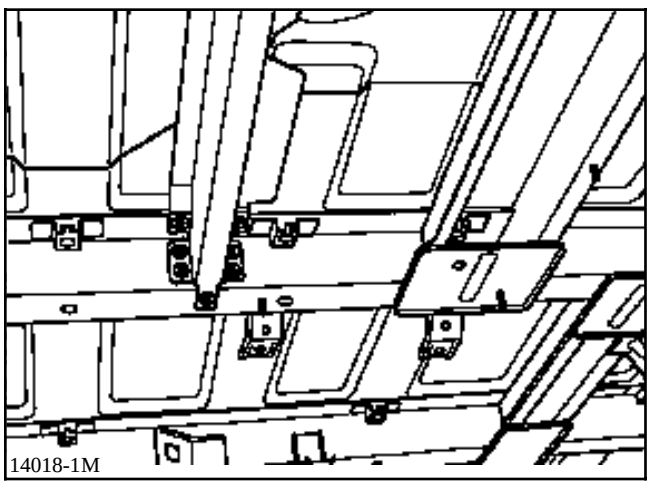
Thickness of the panels (mm)

Rear cross member of 2nd row seat	2.0
Side reinforcement of rear axle assembly cross member	2.0

Unpick

7 spot welds on a thickness of 2.0

Weld



3 JOINT WITH MIDDLE SIDE CONNECTING PLATE

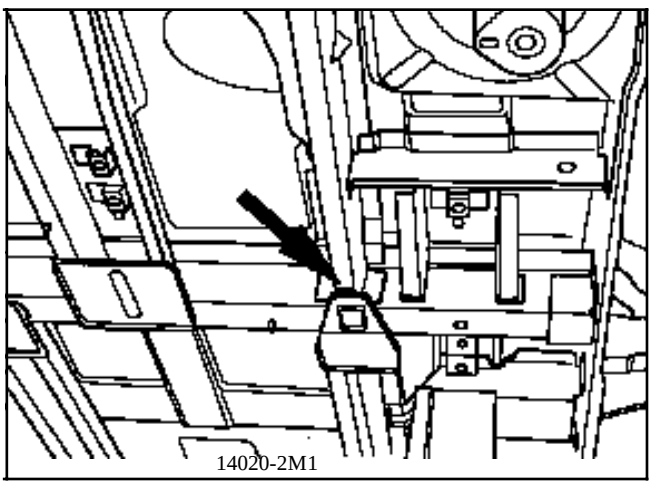
Thickness of the panels (mm)

Middle side connecting plate	1.2
Side reinforcement of rear axle assembly cross member	2.0

Unpick

1 x 15 mm MAG weld bead

Weld



4 JOINT WITH REAR CROSS MEMBER OF 3rd ROW SEATS

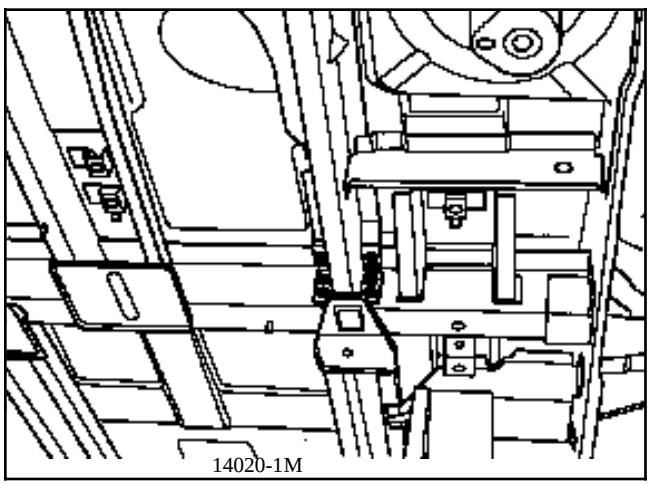
Thickness of the panels (mm)

Rear cross member of 3rd row seats	2.0
Side reinforcement of rear axle assembly cross member	2.0

Unpick

6 spot welds on a thickness of 2.0

Weld



5 JOINT WITH FLOOR

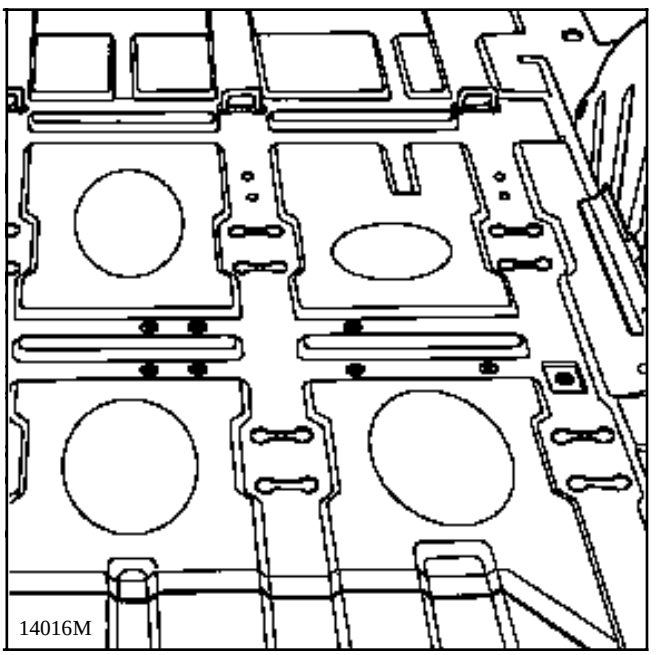
Thickness of the panels (mm)

Floor	0.8
Side reinforcement of rear axle assembly cross member	2.0

Unpick

8 spot welds on a thickness of 2.0

Weld



6 JOINT WITH CROSS MEMBER/SIDE MEMBER PLATE

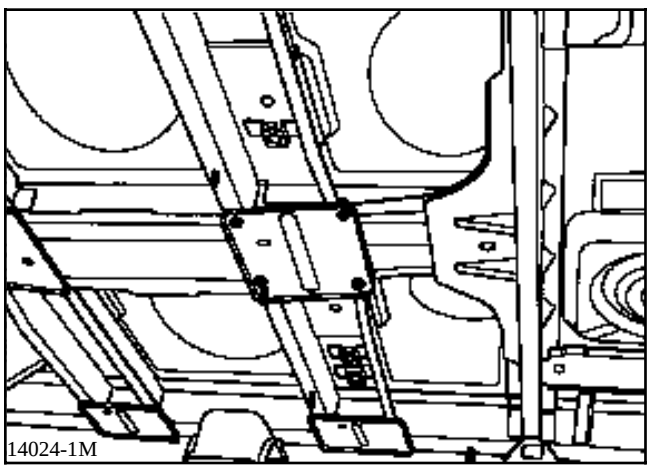
Thickness of the panels (mm)

Rear axle assembly cross member	2.0
Plate	1.5

Unpick

4 spot welds on a thickness of 1.5

Weld



7 JOINT WITH 3RD ROW SEATS MOUNTING SIDE MEMBER

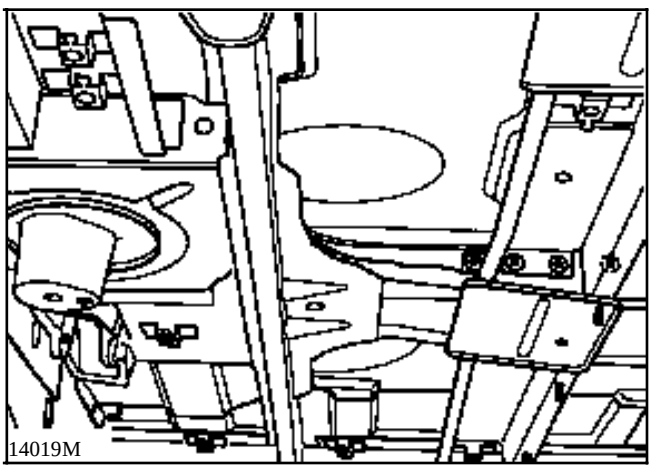
Thickness of the panels (mm)

Rear axle assembly cross member	2.0
3rd row mounting side member	2.0

Unpick

4 spot welds on a thickness of 2.0

Weld



Before welding check :

For versions with a ring, measure the centre distance between the rings.

For versions with a rail :
Secure the rails without blocking them.
Position a seat to check the centre distance.
Lock the rail bolts to a torque of 1.2 daN.m

8 PARTIAL CUT

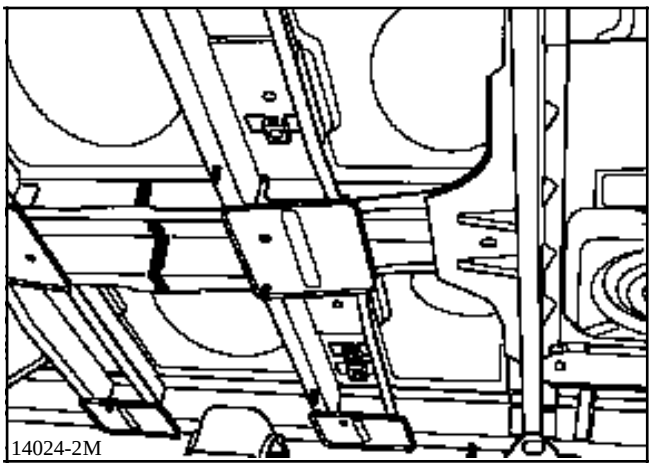
Thickness of the panels (mm)

Rear axle assembly cross member	2.0

Cutting

340 mm on a thickness of 2 mm

Weld

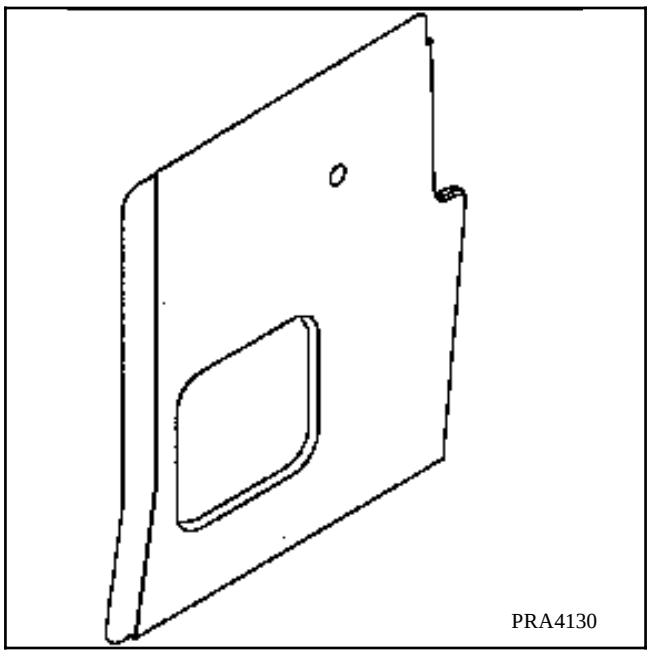


NOTE: Refer to the Paint Workshop Repair Manual 601, section 95, for protection and sealing.

INTRODUCTION

The replacement of this part is a complementary operation to the replacement of :
- the complete rear side member,
- the rear wheel arch.

COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT



Preliminary operations.

Remove:
- the inner sill protection,
- the door seal,
- the floor trim ,
- part of the wiring loom,
- the valance.

1 JOINT WITH VALANCE SIDE PANEL CLOSURE PANEL

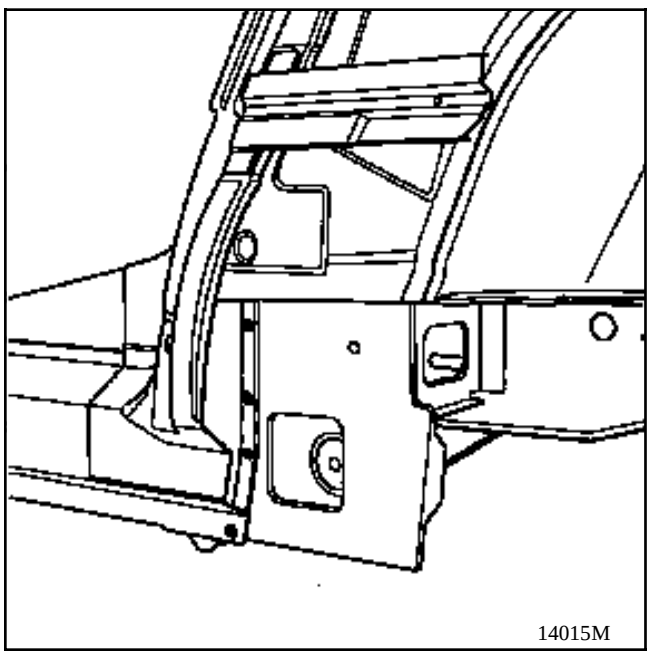
Thickness of the panels (mm)

Valance extension	0.7
Valance side panel closure panel	0.7

Unpick

4 spot welds

Weld



2 JOINT WITH LEFT HAND SIDE WHEEL ARCH CONCEALING TRIM SECTION

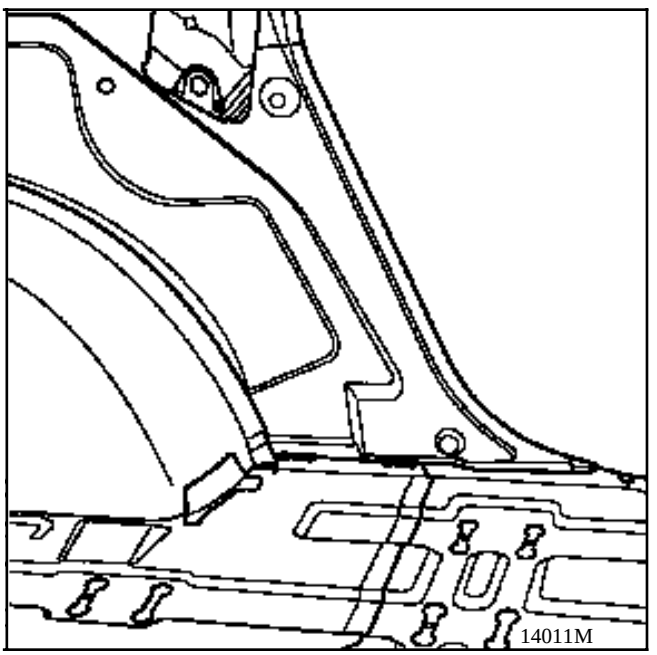
Thickness of the panels (mm)

Concealing trim section	0.7
Valance extension	0.7

Unpick

2 x 20 mm welds

Weld



3 JOINT WITH VALANCE SIDE PANEL CLOSURE PANEL FLANGE

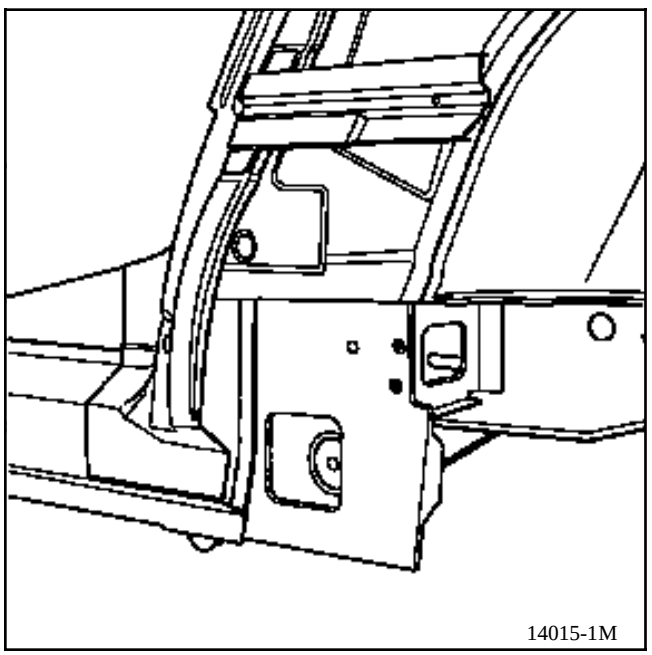
Thickness of the panels (mm)

Valance extension	0.7
Valance side panel closure panel	0.7

Unpick

2 spot welds

Weld



4 JOINT WITH OUTER FLANGE OF THE REAR SUSPENSION MOUNTING ARMS

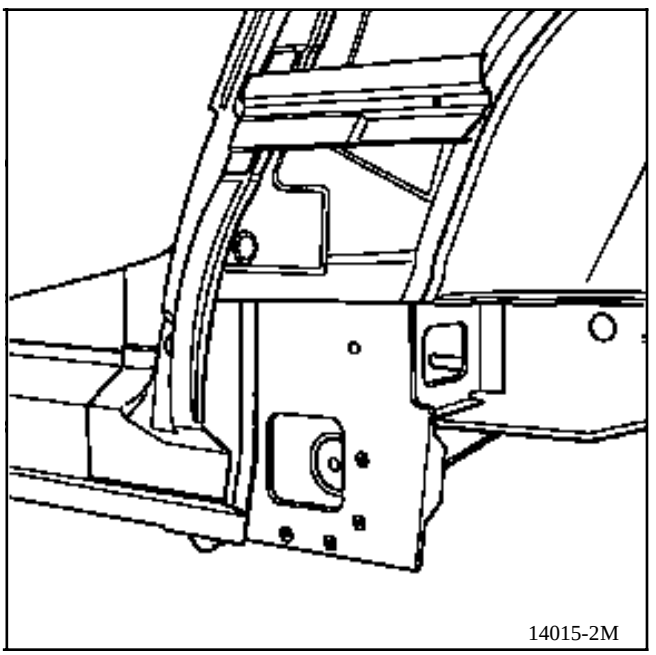
Thickness of the panels (mm)

Flange	0.7
Valance extension	0.7

Unpick

4 spot welds

Weld

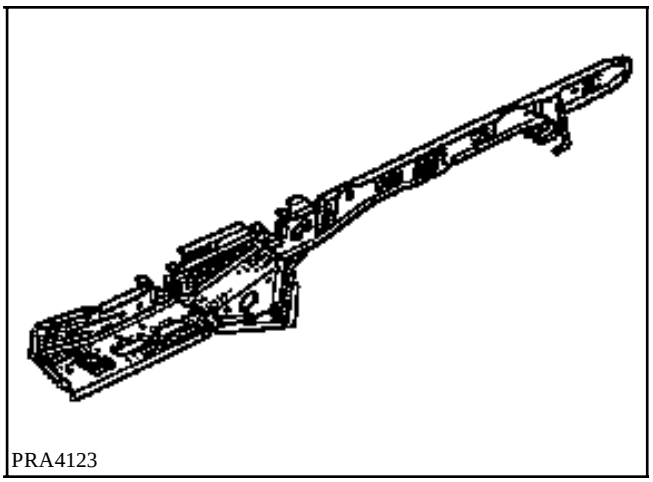


INTRODUCTION

The replacement of this part is a complementary operation to the replacement of the whole wheel arch, with valance and side floor (part section) reinforcement for a side impact.

This must be carried out on a repair bench.

COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT



PRA4123

Preliminary operations.

Remove :
- the mudguard,
- the exhaust,
- the fuel tank on the right hand side,
- the rear axle assembly,
- the anchoring covers,
- the wheel arch trim,
- the floor trim .

1 JOINT WITH VALANCE

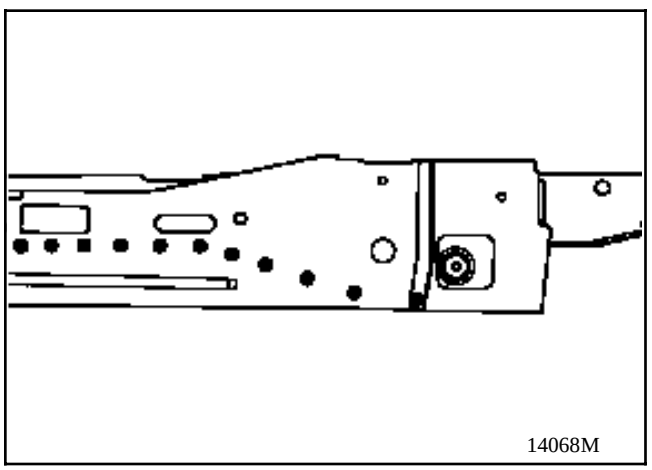
Thickness of the panels (mm)

Valance	0.7
Jack mounting	2.0
Jack mounting closure panel	2.0
Closure panel outer flange	1.5
Valance closure panel side flange	1.5
Valance closure panel lower panel	0.8

Unpick

11 spot welds on a thickness of 0.7

Weld



2 JOINT WITH CROSS MEMBER BETWEEN CENTRE PILLARS

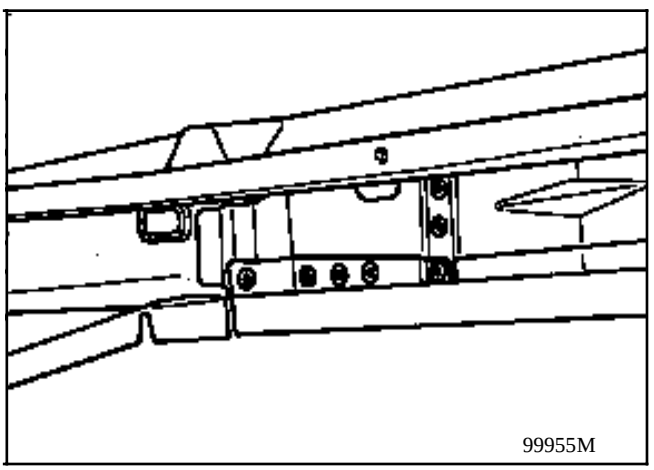
Thickness of the panels (mm)

Cross member between centre pillars	1.5
Exterior side member	2.5
Valance closure panel	1.2

Unpick

7 spot welds on a thickness of 1.5

Weld



3 JOINT WITH VALANCE CLOSURE PANEL, LOWER PANEL

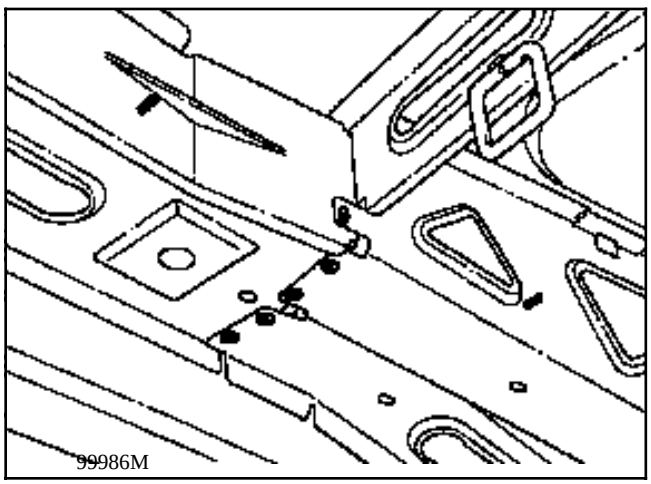
Thickness of the panels (mm)

Valance closure panel, lower panel	0.8
Valance closure panel, lower front panel	0.8
Side member extension	1.2

Unpick

5 spot welds on a thickness of 0.8 and 1.2

Weld



4 JOINT WITH FRONT CROSS MEMBER OF 2ND ROW OF SEATS

Thickness of the panels (mm)

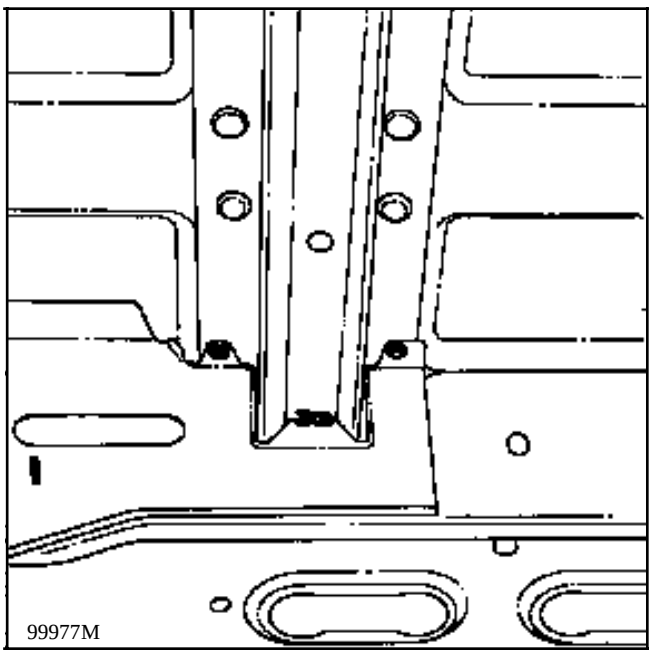
Suspension arms inner flange	1.5
Front cross member of 2nd row of seats	2.0

Unpick

3 spot welds on a thickness of 2.0

1 x 10 mm MAG weld bead on a thickness of 2.0

Weld



5 JOINT WITH REAR CROSS MEMBER OF 2nd ROW OF SEATS

Thickness of the panels (mm)

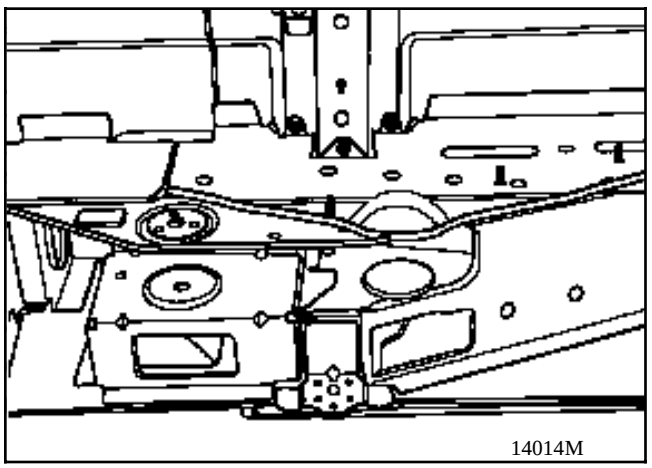
Inner flange	1.5
Rear cross member of 2nd row of seats	2.0

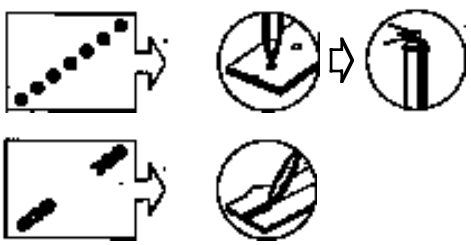
Unpick

3 spot welds on a thickness of 2.0

1 x 10 mm MAG weld bead on a thickness of 2.0

Weld





6 JOINT WITH JACK MOUNTING

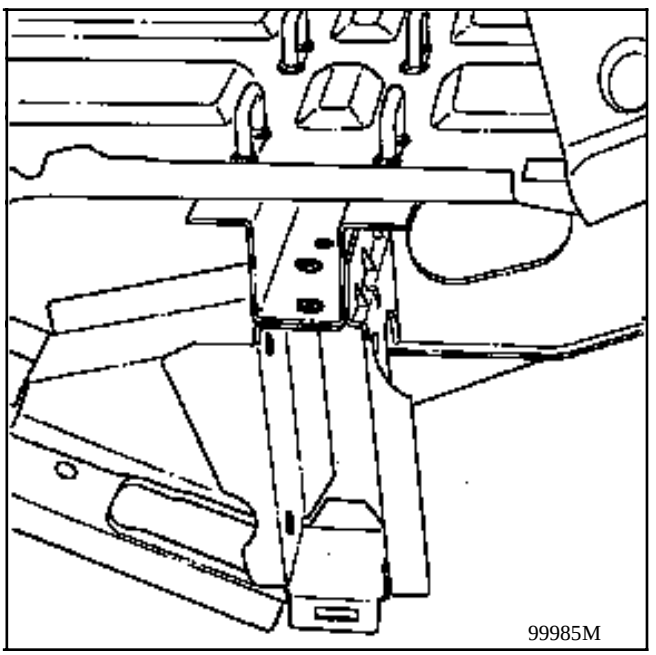
Thickness of the panels (mm)

Jack mounting	2.0
Rear cross member of 2nd row of seats	2.0

Unpick

2 spot welds on a thickness of 2.0

Weld



7 JOINT WITH VALANCE CLOSURE PANEL SIDE PANEL REAR FLANGE

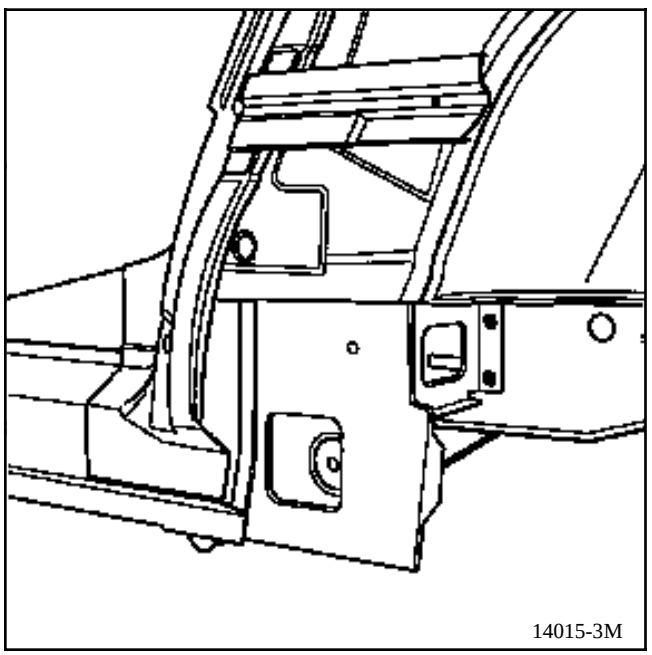
Thickness of the panels (mm)

Floor	0.8
Valance side panel extension	0.7

Unpick

2 spot welds on a thickness of 0.8 and 0.7

Weld



8 JOINT WITH JACK MOUNTING CLOSURE PANEL

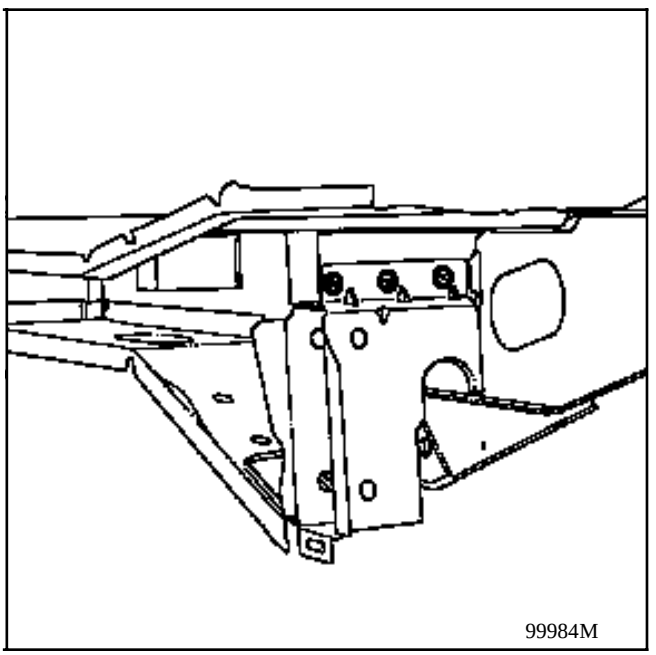
Thickness of the panels (mm)

Jack mounting	2.0
Rear cross member of 2nd row of seats	2.0

Unpick

3 spot welds on a thickness of 2.0

Weld



9 JOINT WITH REAR AXLE ASSEMBLY CROSS MEMBER

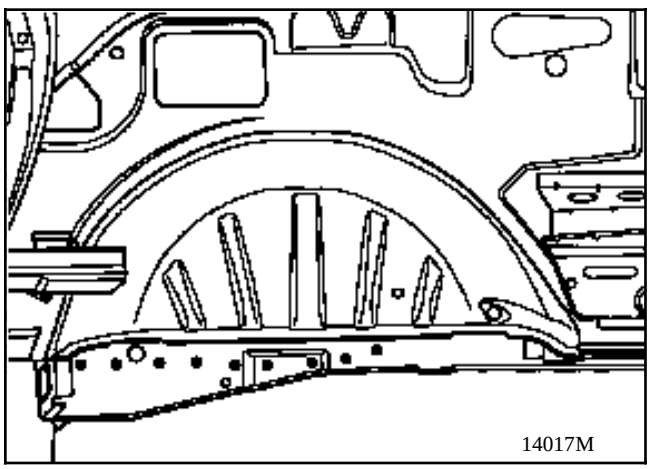
Thickness of the panels (mm)

Exterior side member	2.5
Rear axle assembly cross member	2.0

Unpick

9 spot welds on a thickness of 2.0

Weld



10 JOINT WITH CROSS MEMBER OF 3rd ROW OF SEATS

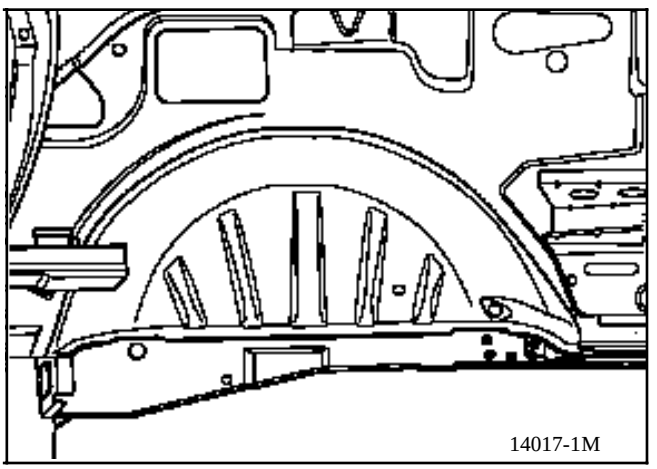
Thickness of the panels (mm)

Exterior side member	2.5
Third row cross member	2.0

Unpick

5 spot welds on a thickness of 2.0

Weld



11 JOINT WITH REAR CORNER PLATE UNDER FLOOR

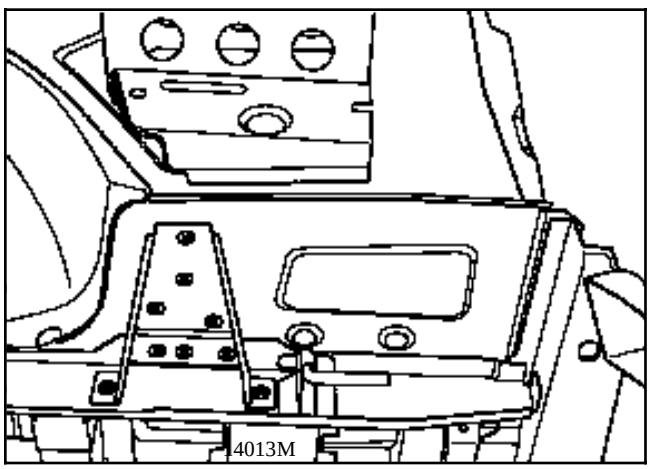
Thickness of the panels (mm)

Exterior side member	2.5
Rear corner plate under floor	1.5

Unpick

9 spot welds on a thickness of 1.5

Weld



12 JOINT WITH INDEXING PLATE

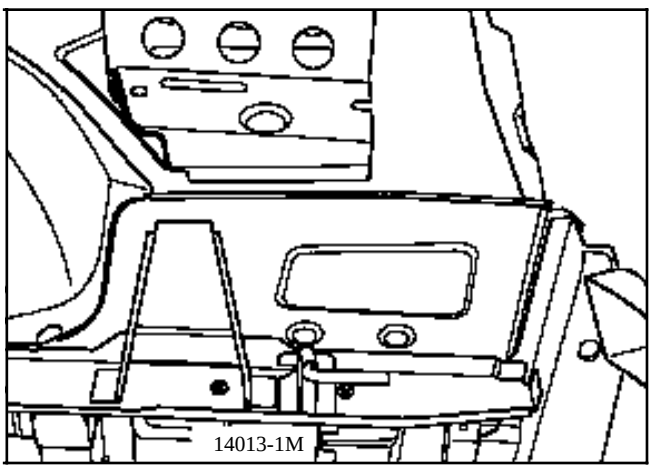
Thickness of the panels (mm)

Exterior side member	2.5
Indexing plate	2.0

Unpick

2 spot welds on a thickness of 2.5

Weld



13 JOINT WITH LOWER CROSS MEMBER

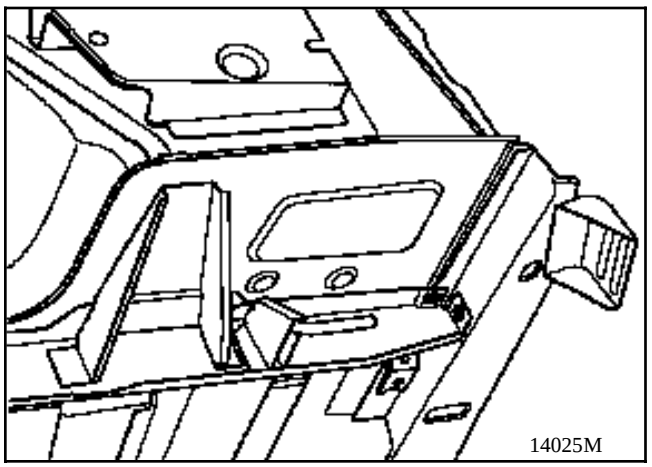
Thickness of the panels (mm)

Exterior side member	2.5
Lower cross member	2.0

Unpick

2 spot welds on a thickness of 2.5

Weld



14 JOINT WITH FLOOR

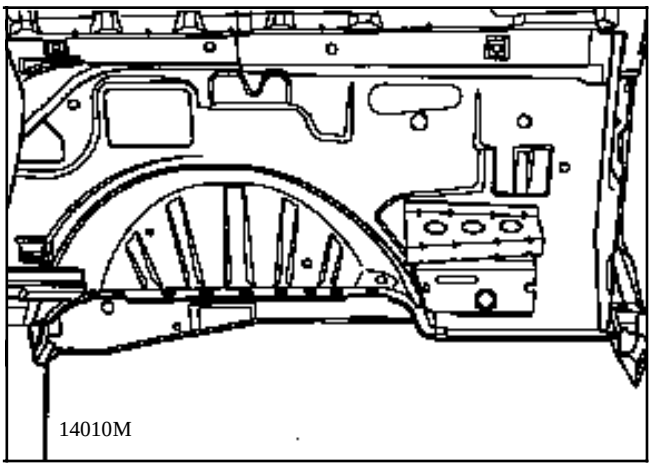
Thickness of the panels (mm)

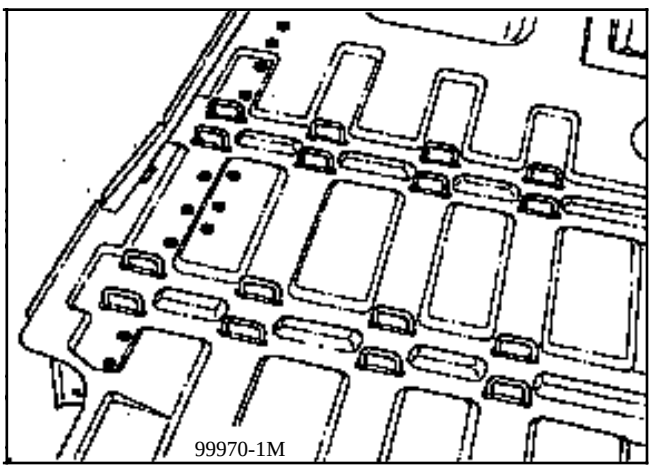
Exterior side member	2.5
Floor	0.8

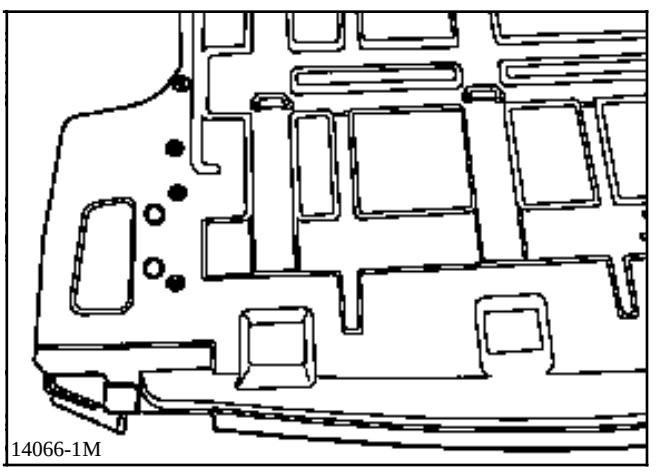
Unpick

25 spot welds on a thickness of 0.8

Weld







15 PARTIAL CUT

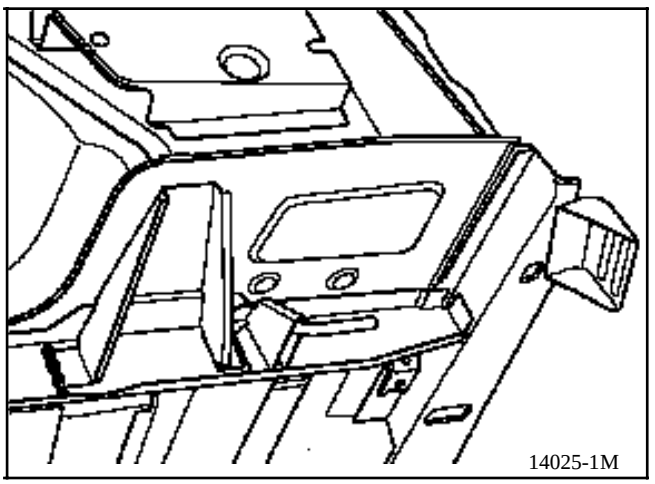
Thickness of the panels (mm)

Rear side member, part section 2.5

Unpick

150 mm on a thickness of 2.5

Weld

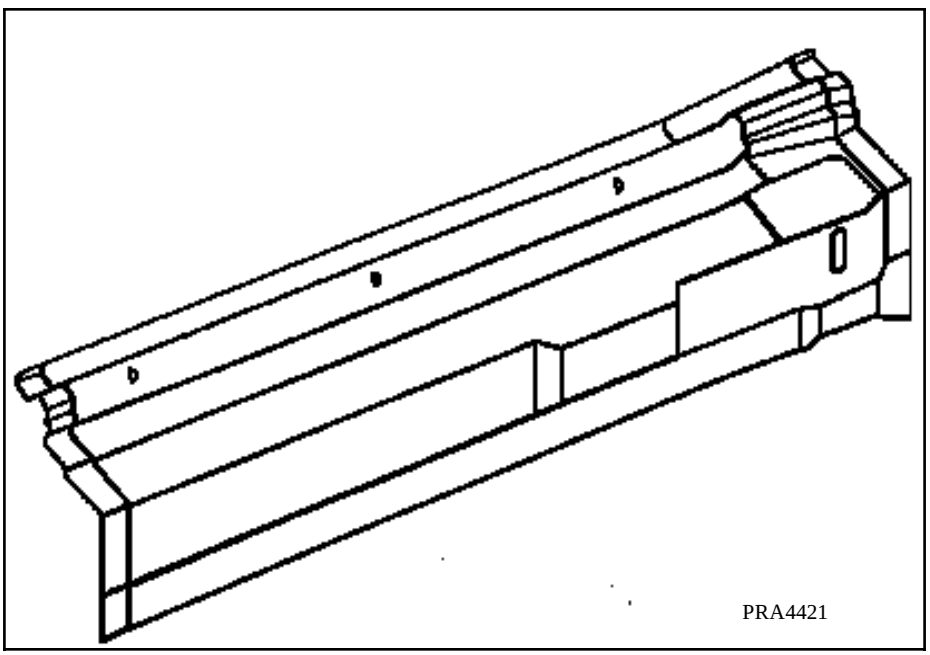


NOTE : refer to Paint Workshop Repair Manual 601, section 95 for protection and sealing .

INTRODUCTION

The replacement of this part is a complementary operation to the replacement of the roof in the rear section and the rear wing.

COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT



REPLACEMENT

Preliminary operations.

Remove:
- the quarter panel window,
- the rear roof,
- the rear wing.

1 JOINT WITH UPPER STRUCTURE

Thickness of the panels (mm)

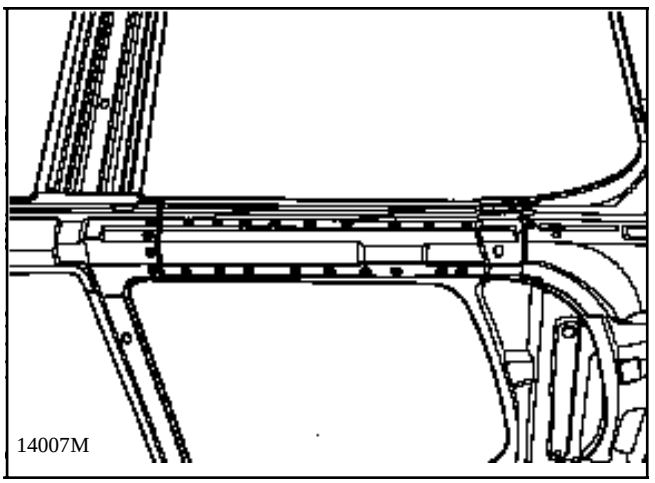
Upper structure	1.5
Upper stretcher	1.5

Unpick

25 spot welds on a thickness of 1.5

2 x 40 mm weld beads on a thickness of 1.5

Weld

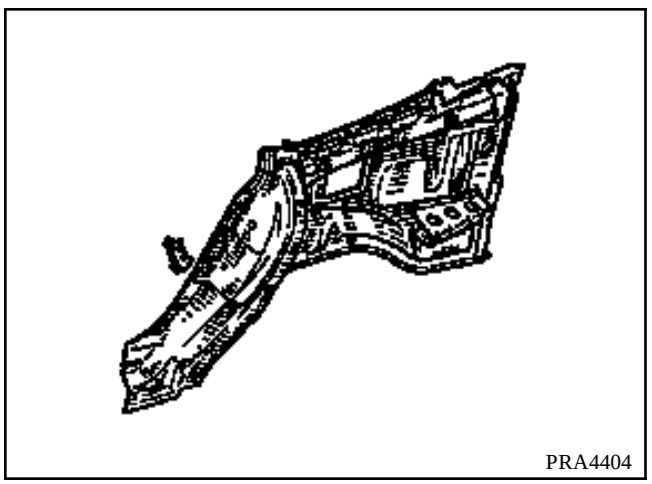


NOTE: refer to Paint Workshop Repair Manual 601, section 95 for protection and sealing.

INTRODUCTION

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

COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT


PRA4404

Preliminary operations.

Remove:
- the inner sill,
- part of the door seal,
- the sill panel,
- the quarter panel window,
- the rear light,
- the rear wing,
- the wheel arch trim,
- part of the upper trim,
- the tailgate,
- the rear wheel,
- the mudguard,
- the bumper,
- part of the wiring loom,
- the seat belt,
- the fuel flap locking mechanism,
- the floor trim, part section.

1 JOINT WITH VALANCE REINFORCEMENT

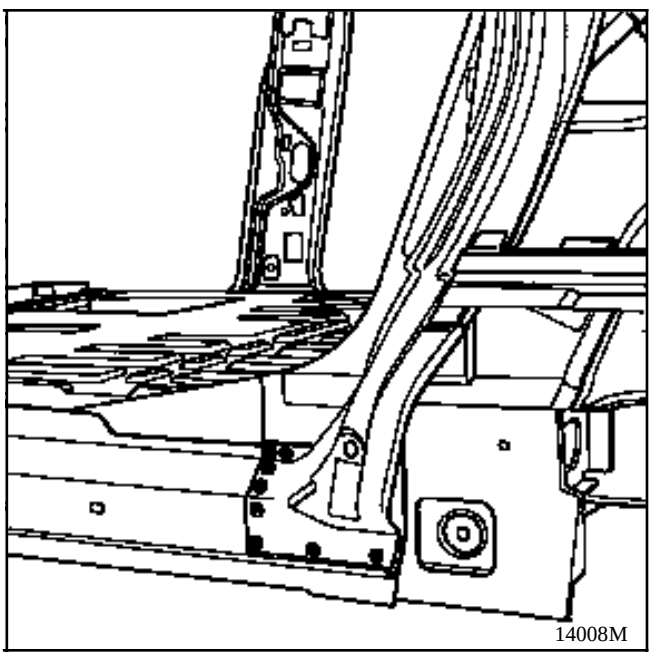
Thickness of the panels (mm)

Valance reinforcement	0.8
Rear pillar	0.7

Unpick

8 spot welds on a thickness of 0.8

Weld


14008M

2 JOINT WITH FRONT PILLAR OF QUARTER PANEL WINDOW

Thickness of the panels (mm)

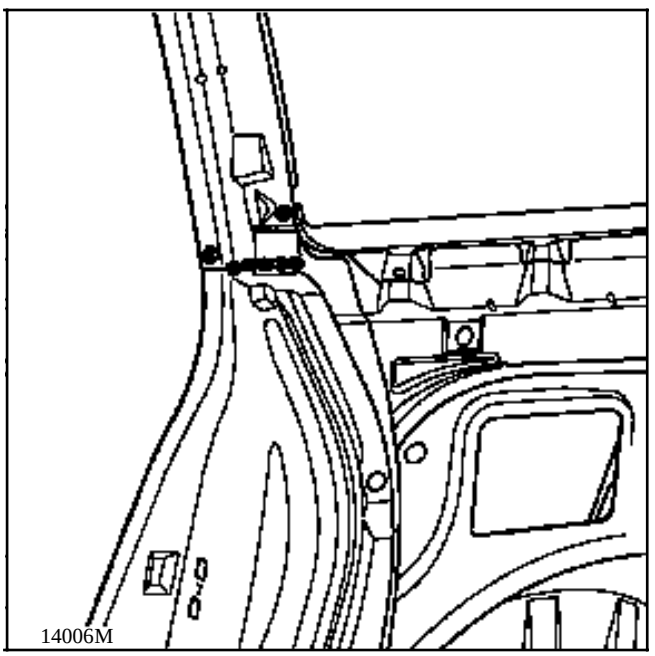
Front pillar of quarter panel window	1.2
Rear pillar	0.7
Wheel arch	0.7

Unpick

2 spot welds on a thickness of 1.2+0.7+0.7

+1 x 40 mm MAG weld bead

Weld



3 JOINT WITH QUARTER PANEL WINDOW PILLAR LINING

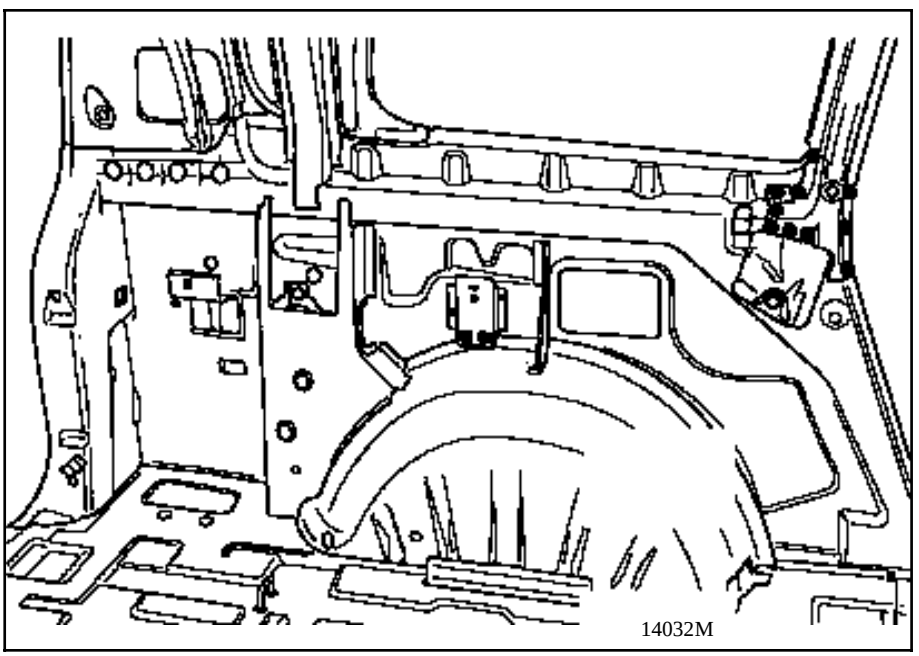
Thickness of the panels (mm)

Lining of the quarter panel window pillar	0.8
Wheel arch	0.7

Unpick

10 spot welds on a thickness of 0.8

Weld



4 JOINT WITH QUARTER PANEL LINING

Thickness of the panels (mm)

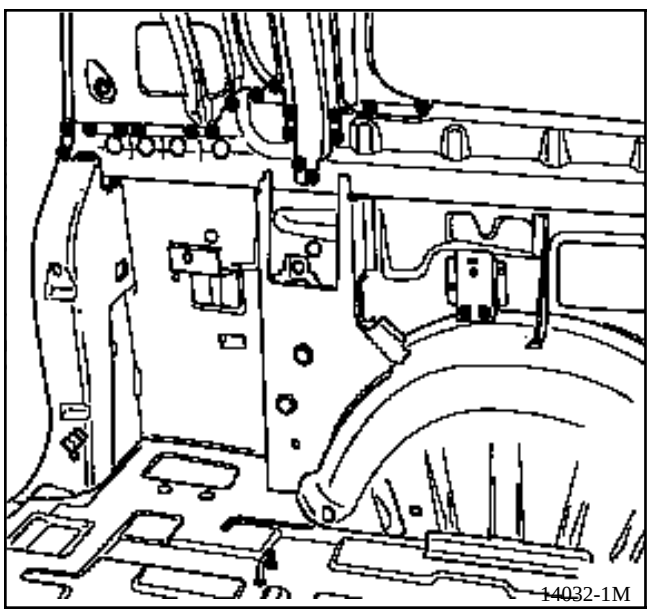
Quarter panel lining	0.8
Wheel arch	0.7
Lower stretcher of quarter panel window	0.7
Rear rain channel, upper section	0.7
Rain channel lining	0.7

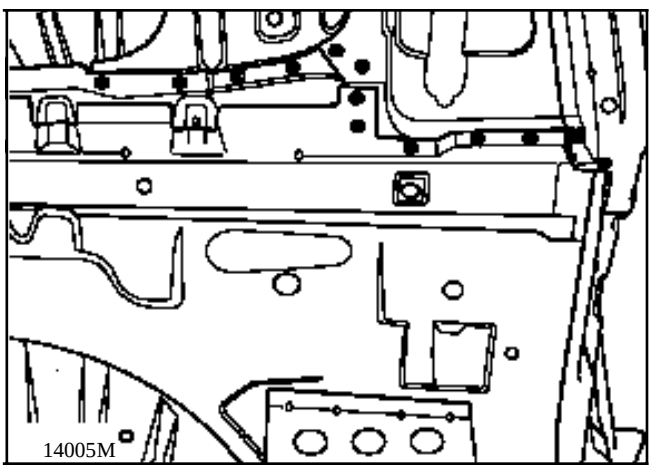
Unpick

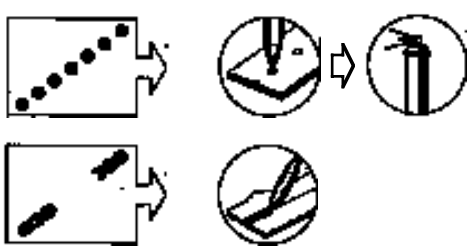
31 spot welds on a thickness of 0.7

+2 x 20 mm MAG weld beads

Weld







5 JOINT WITH FLOOR

Thickness of the panels (mm)

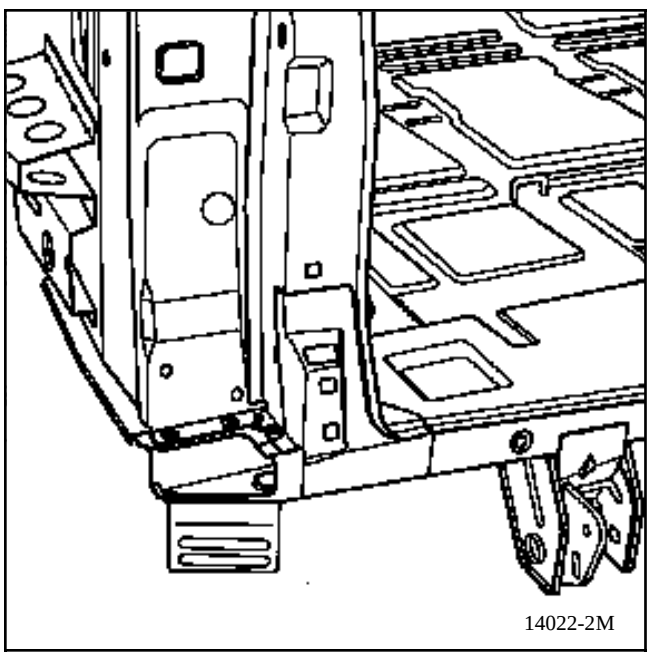
Floor	0.8
Rear end pillar	0.7

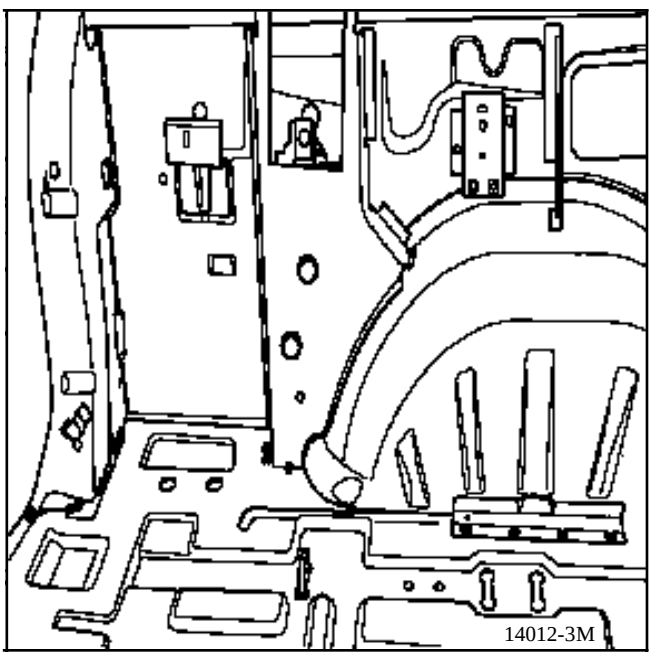
Unpick

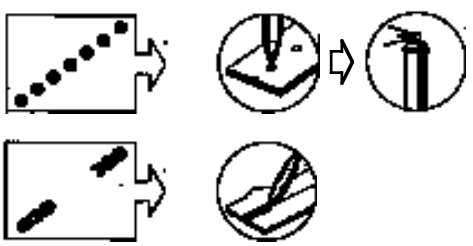
3 spot welds on a thickness of 0.8

+ 4 plug welds
+ 6 x 20 mm MAG weld beads

Weld







Preparing the new part.

Level any uneven parts of the zinc on the surface to be welded, position the parts and secure them using vice grips.

6 JOINT WITH FLOOR

Thickness of the panels (mm)

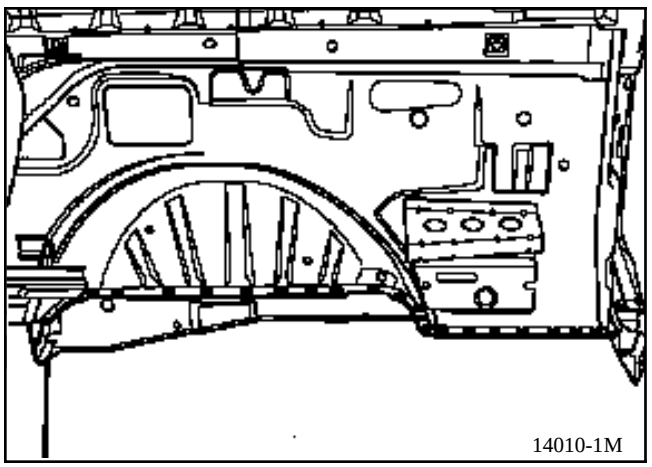
Floor	0.8
Wheel arch	0.7

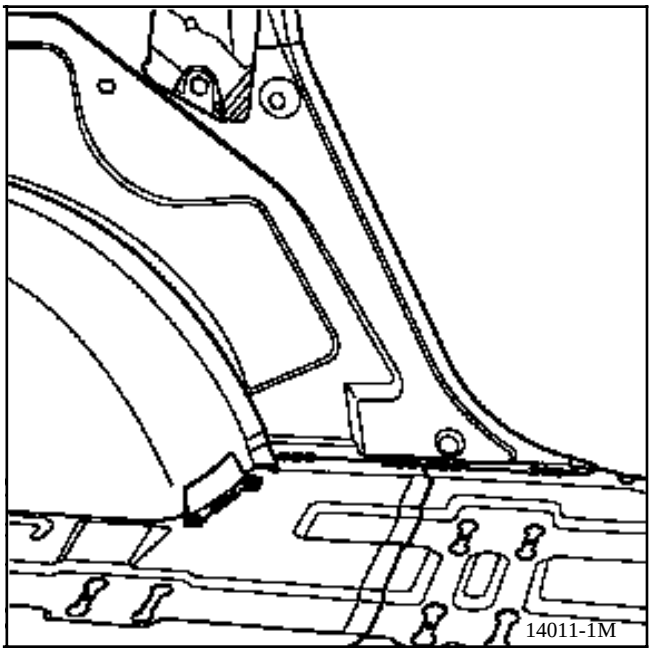
Unpick

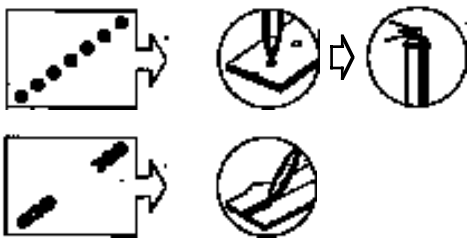
23 spot welds on a thickness of 0.8

+ 2 plug welds
+ 5 x 25mm MAG weld beads

Weld







NOTE : for positioning and drilling of the counter blade reinforcement, refer to section **44-E** of Workshop Repair Manual 316.

7 JOINT WITH LOWER REAR CROSS MEMBER

Remove the bumper cross member

Thickness of the panels (mm)

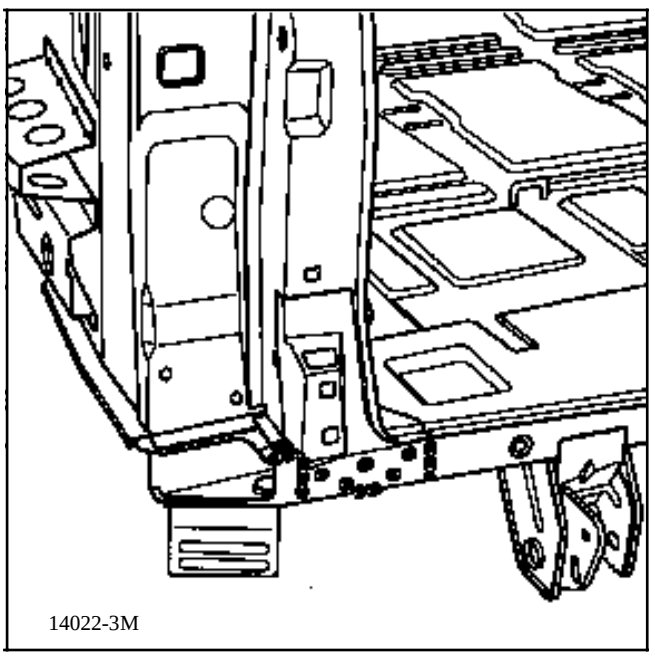
Lower rear cross member	2.0
Striker plate mounting rear gusset	2.0

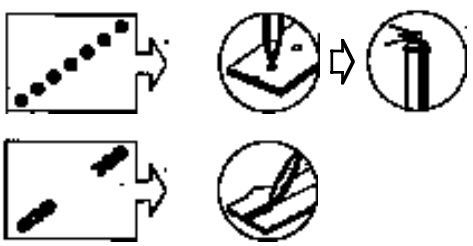
Unpick

6 spot welds on a thickness of 2.0

2 x 50 mm MAG weld beads
2 x 20 mm MAG weld beads

Weld





NOTE: refer to Paint Workshop Repair Manual 601, section 95 for protection and sealing.

INTRODUCTION

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

Preliminary operations.

Remove:
- the bumper,
- the counter blade reinforcement,
- the wing,
- the quarter panel,
- the light,
- the mudguard,
- the wheel,
- part of the tailgate seal,
- the wheel arch trim.

1 JOINT WITH WHEEL ARCH

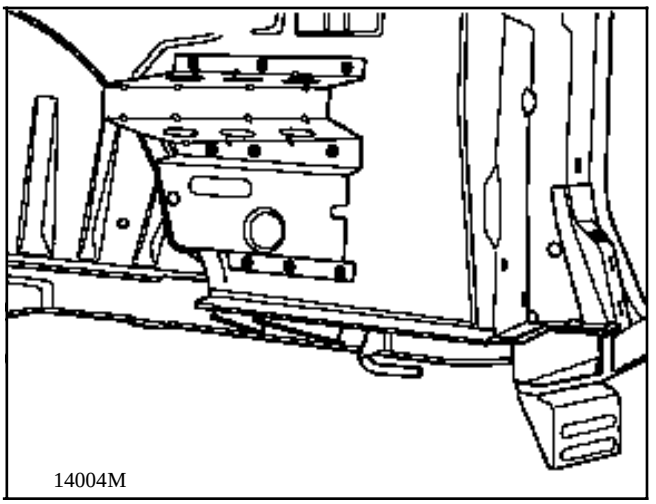
Thickness of the panels (mm)

Wheel arch	0.7
Bumper mounting side support	0.7

Unpick

9 spot welds on a thickness of 0.7

Weld



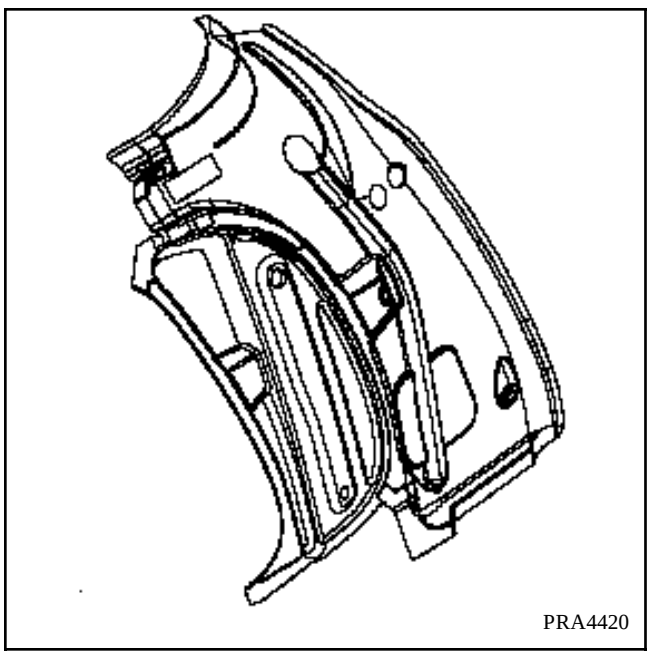
NOTE : Counter-bore the holes to a diameter of 10 mm.

NOTE: refer to Paint Workshop Repair Manual 601, section 95 for protection and sealing.

INTRODUCTION

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

COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT


PRA4420

1 JOINT WITH QUARTER PANEL LINING

Thickness of the panels (mm)

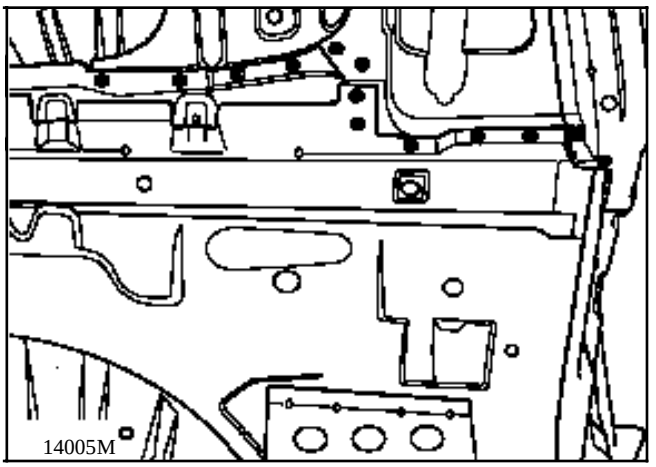
Quarter panel lining	0.8
Wheel arch	0.7
Quarter panel window lower stretcher	0.7
Rear rain channel upper section	0.7
Rain channel lining	0.7

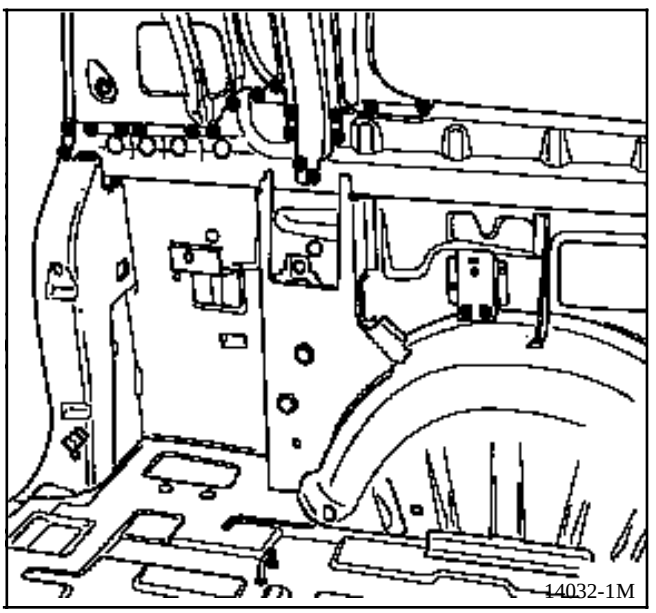
Unpick


31 spot welds on a thickness of 0.7


+2 x 20 mm MAG weld beads

Weld


14005M


14032-1M

2 JOINT WITH CONNECTING GUSSET

Thickness of the panels (mm)

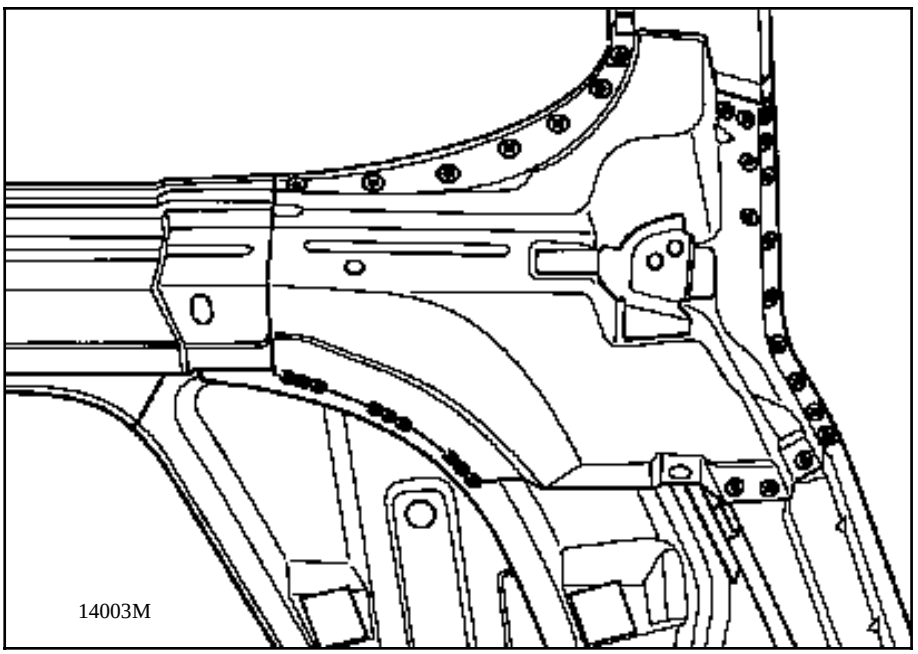
Connecting gusset	1.0
Quarter panel lining	0.8
Upper stretcher	0.7

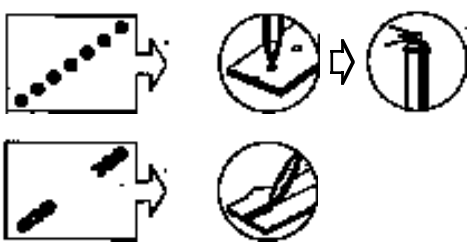
Unpick

23 spot welds on a thickness of 1.0

3 x 20 mm MAG weld beads

Weld





3 JOINT WITH REAR CROSS MEMBER UPPER LINING

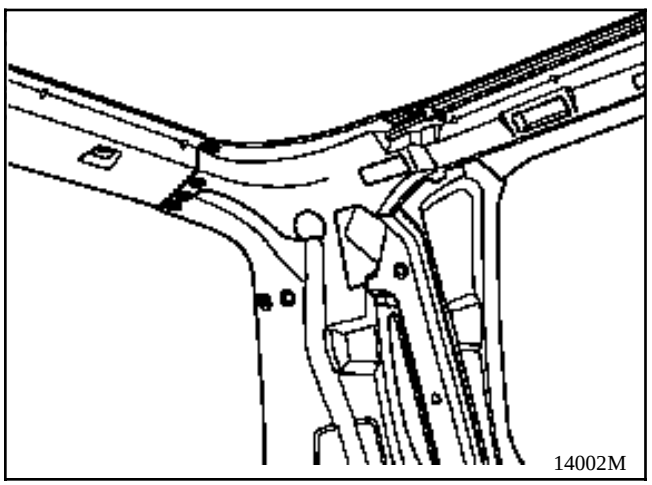
Thickness of the panels (mm)

Upper lining	0.7
Quarter panel lining	0.8

Unpick

4 spot welds on a thickness of 0.7
1 plug weld

Weld



4 JOINT WITH REAR STRETCHER LINING

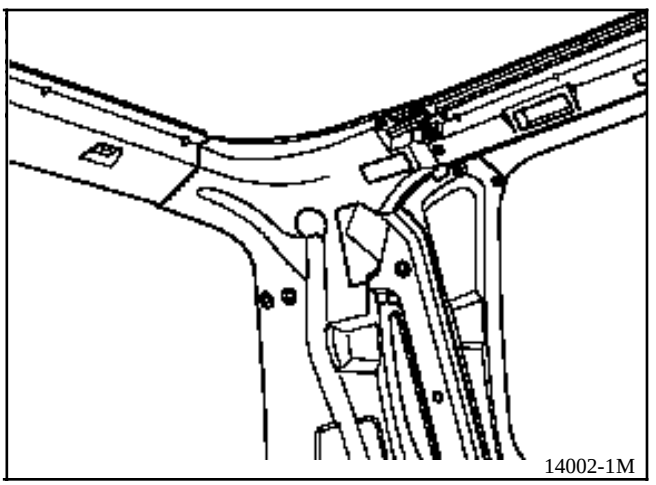
Thickness of the panels (mm)

Rear stretcher lining	0.7
Quarter panel lining	0.8

Unpick

6 spot welds on a thickness of 0.7

Weld

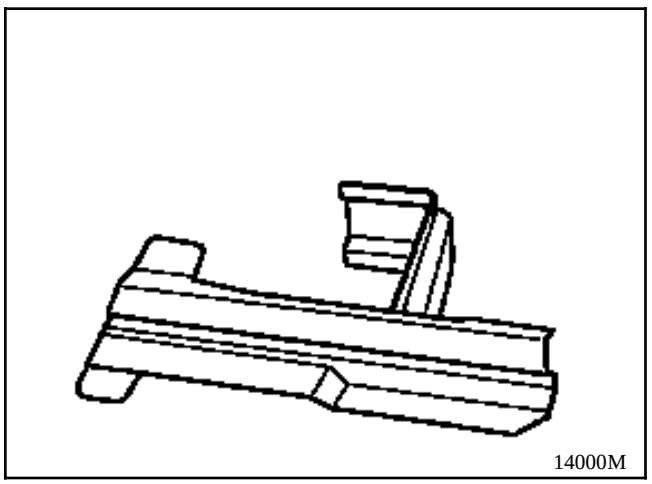


NOTE: refer to Paint Workshop Repair Manual 601, section 95 for protection and sealing.

INTRODUCTION

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

COMPOSITION OF THE PART FROM THE PARTS DEPARTMENT


14000M

Remove:

- the rear lights,
- the rear bumper,
- the mudguards,
- the rear wing,
- the sill panel.

1 JOINT WITH WHEEL ARCH

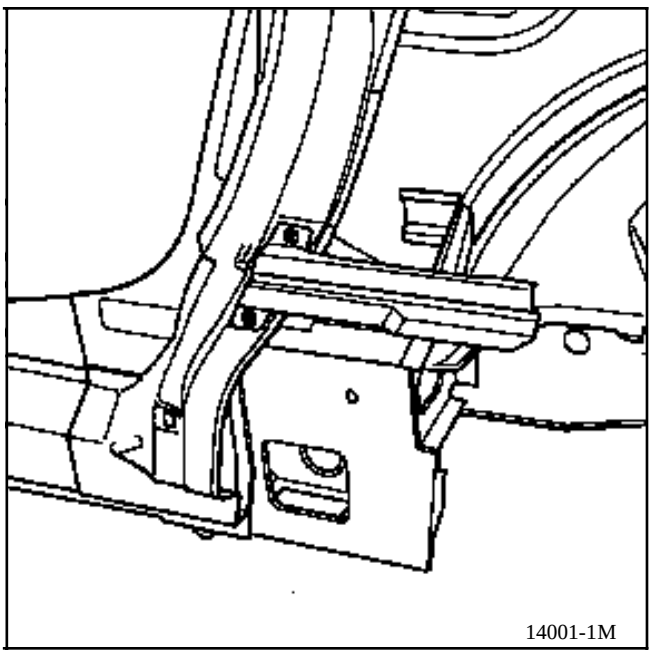
Thickness of the panels (mm)

Wheel arch	0.7
Bonding bridge	0.8

Unpick

2 spot welds on a thickness of 0.8

Weld


14001-1M

2 JOINT WITH REAR PILLAR

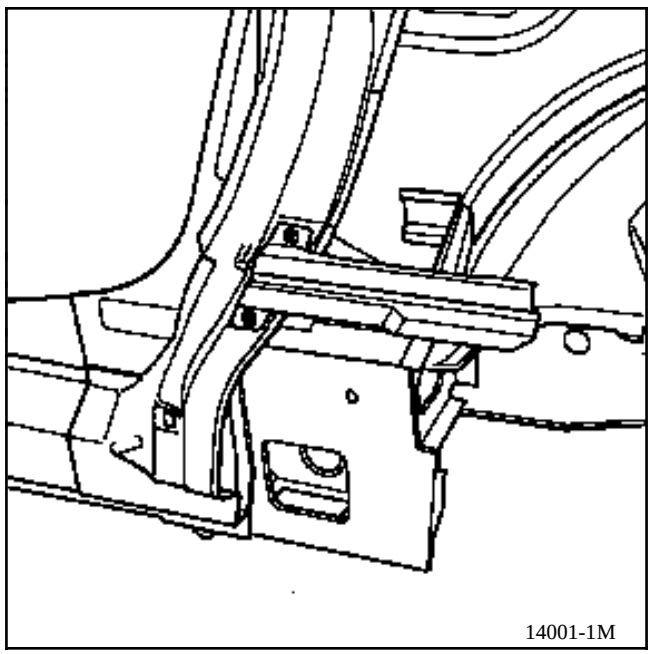
Thickness of the panels (mm)

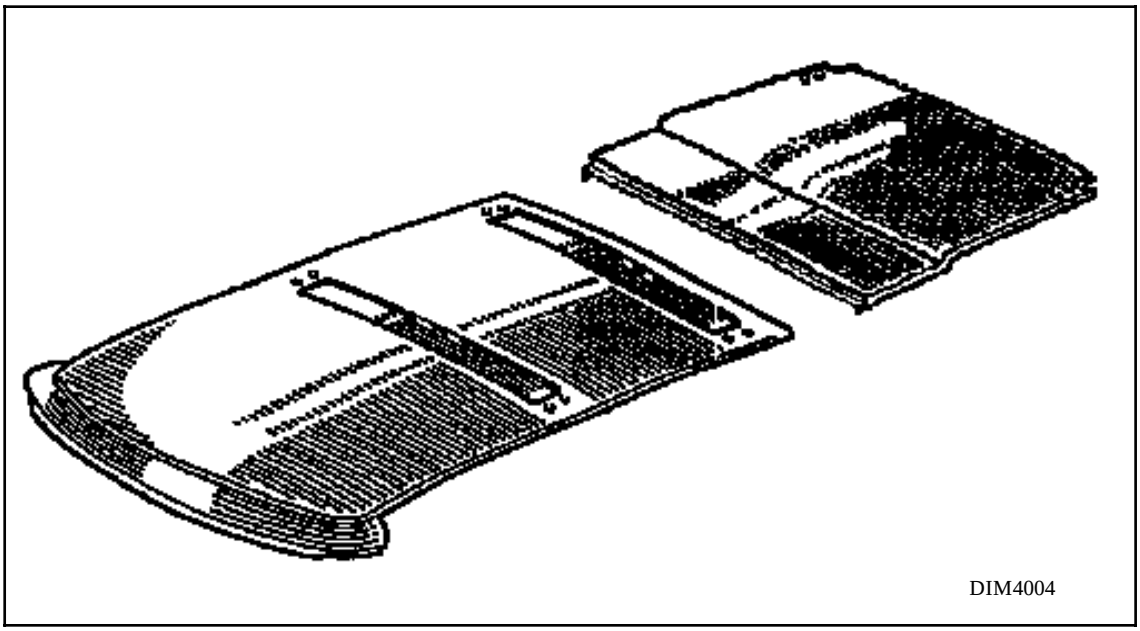
Rear pillar	0.7
Bonding bridge	0.8

Unpick

2 spot welds on a thickness of 0.8

Weld





REPLACEMENT

Parts to be replaced systematically:
The concealing trim section of the rear roof.

Tooling required:
Oscillating cutter or equivalent
Sharp edged spatula
Extrusion gun
2 bonding kits 60 25 170 306

REMOVAL

Remove:
- the roof rack,
- the sunroof,
- the telephone aerial,
- the hinge embellishers,
- all the rear seats.

Partially remove the roof trim on the rear surround.

NOTE:
Carefully protect the inside of the vehicle from the dust produced when cutting, as well as around the roof extension with thick adhesive tape (the tailgate, the tops of the wings, and the rear section of the front roof).

For your comfort whilst working, use a 50 cm scaffold.

CUTTING

Make two cuts (diagram)

1 - The section inside the strip to :

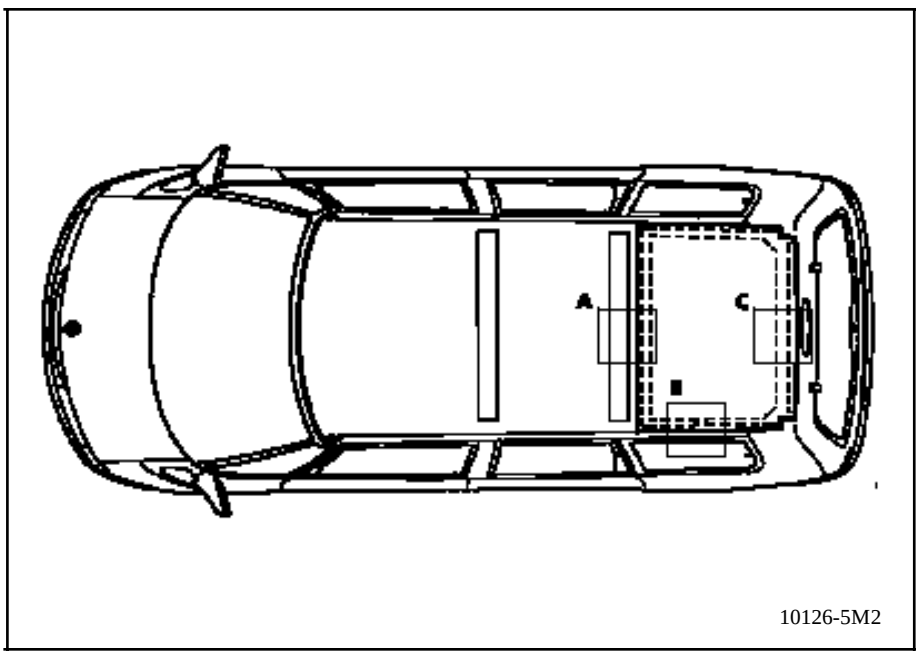
- 40 mm from the side edge (A)
- 15 mm from the edge of the front roof (B)
- 65 mm from the edge of the tailgate (C)

See (A) (B) (C) on the diagram.

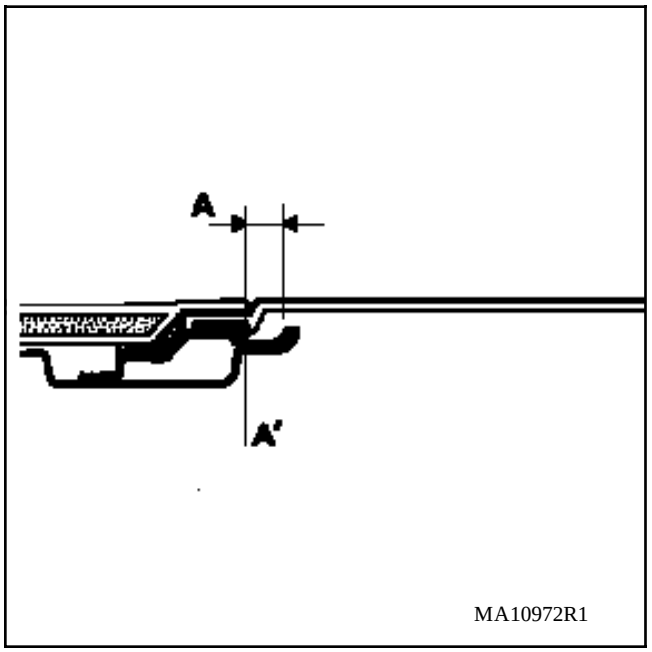
2 - The section outside the strip to :

- vertical to the front roof cut (A')
- 5 mm from the side edge (B')
- 15mm from the edge of the tailgate (C')

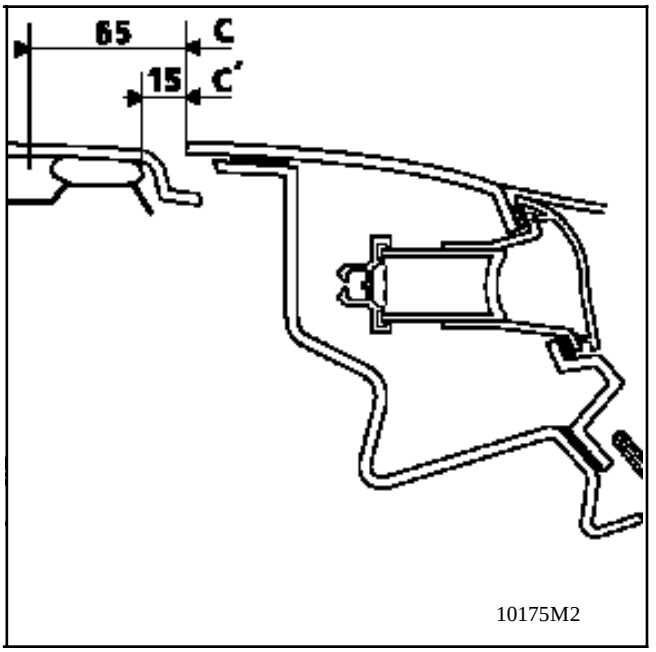
See (A') (B') (C') on the diagram.



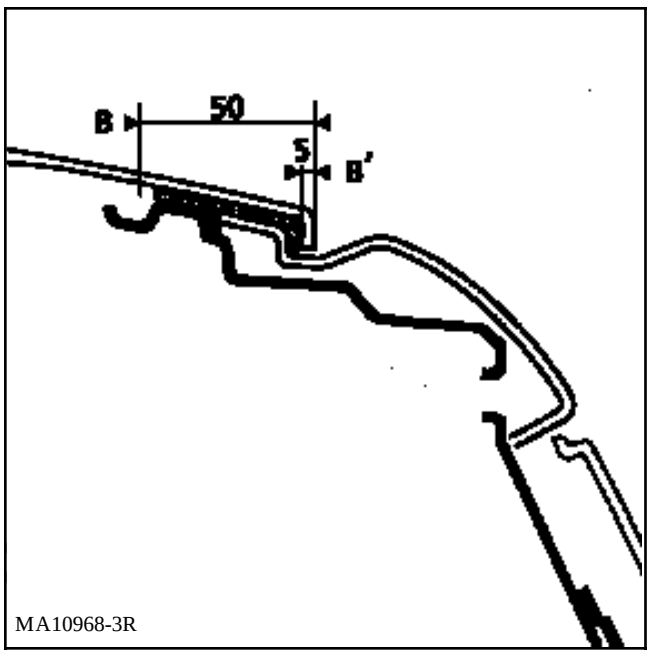
10126-5M2



MA10972R1



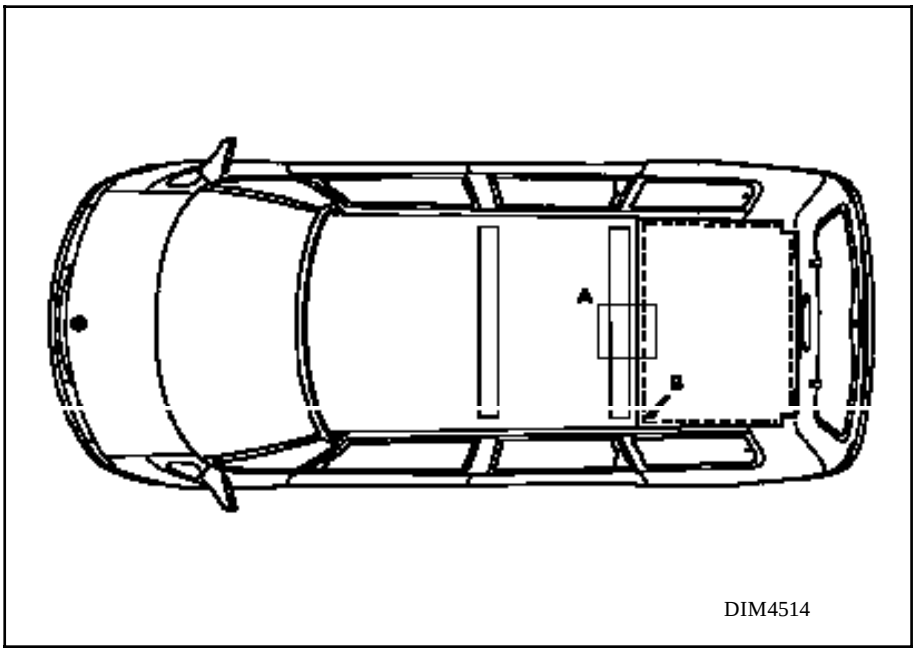
10175M2



MA10968-3R

Using a cutting tool, remove the rest of the roof and the bonding bead.

Clean the areas being bonded without totally removing the bonding bead on the panel.



DIM4514

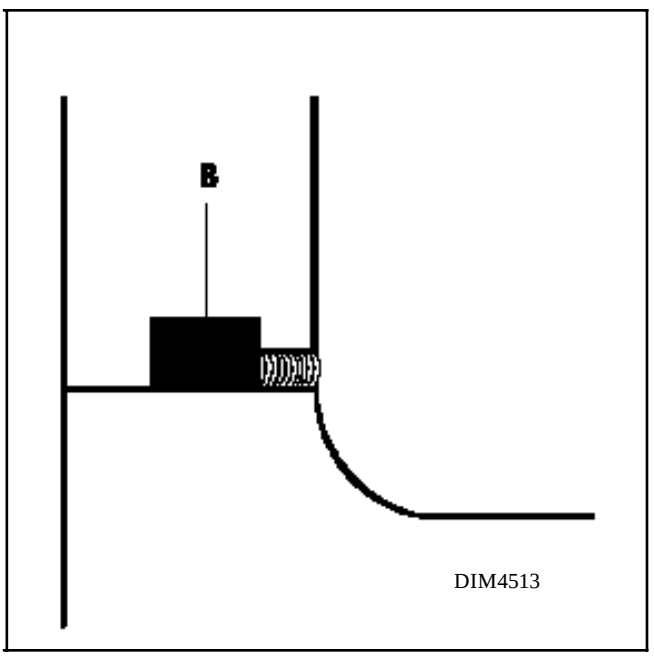
FITTING (cont)

Preparing for the bonding.
Prepare all the necessary areas (roof, structure)

Fit the beads (diagram) on the structure using the precut nozzle.

For the front of the roof, extrude a 7 mm bead (C) using the round nozzle (diagram). This avoids too much adhesive getting into the seam channel.

DIM4011



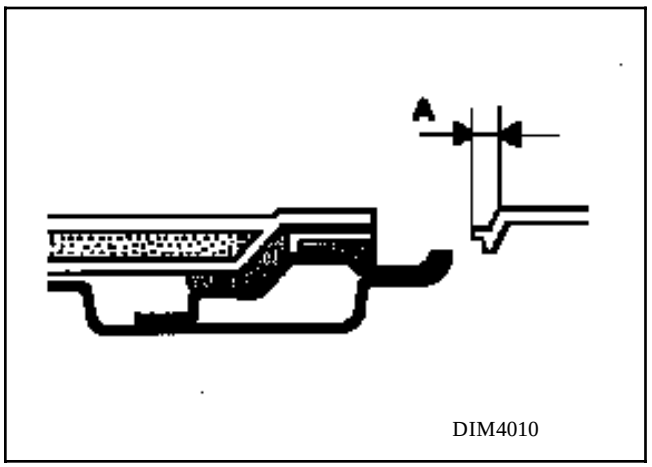
DIM4513

IMPORTANT : To ensure sealing, apply a small amount of adhesive in the cavities (B) located where the quarter panel front pillar lining and the rear roof cross member meet (diagram).

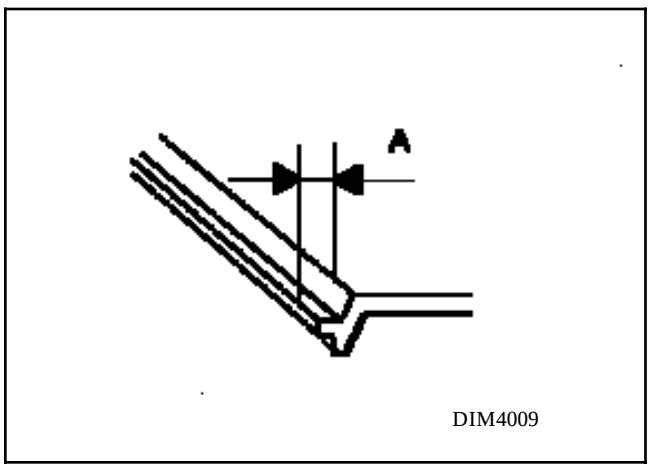
FITTING

Preparing the roof extension.
From the drop section of the old roof, take off the side section, (see A on the diagram) and refer to the new part.

Cut.



DIM4010

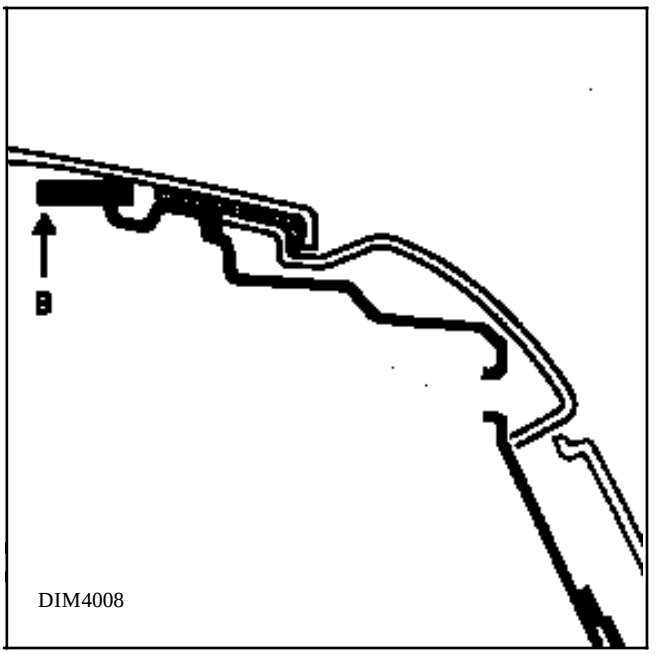


DIM4009

Place the roof on the vehicle.

Place the padding blocks on the edge of the trim seam channels (diagram) to judge its appearance in relation to the front roof (diagram).

If necessary, make the cut again to make adjustments.



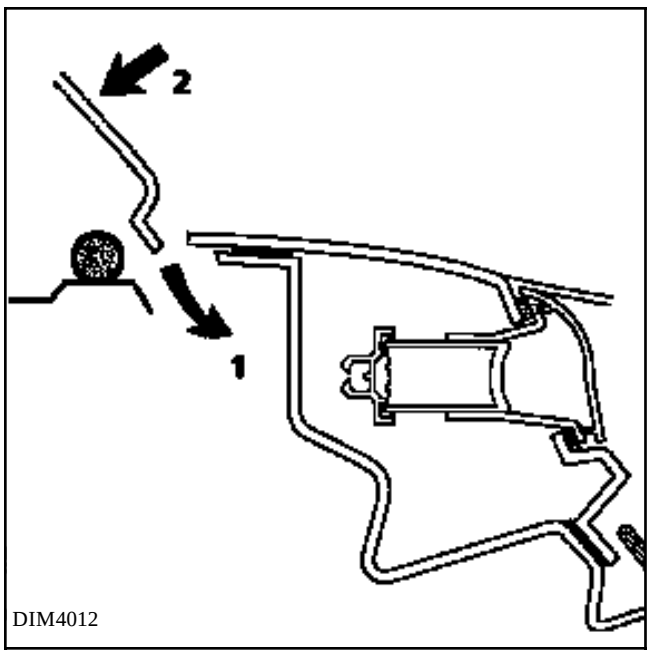
DIM4008

FITTING THE ROOF EXTENSION

Fit the suckers on the extension.

Two people must handle the part.

Place it carefully below the upper swaging of the tailgate, taking care not to crush the bonding bead.



DIM4012

Check the blocks and reposition if necessary.

Adjust the compression and alignment in relation to the front roof and the tailgate.

Apply adhesive tape either side of the front and rear roof joins to help with removal of excess adhesive.

Cut the round nozzle of the second kit to the diameter of the junction groove.

Apply a bead to the groove.

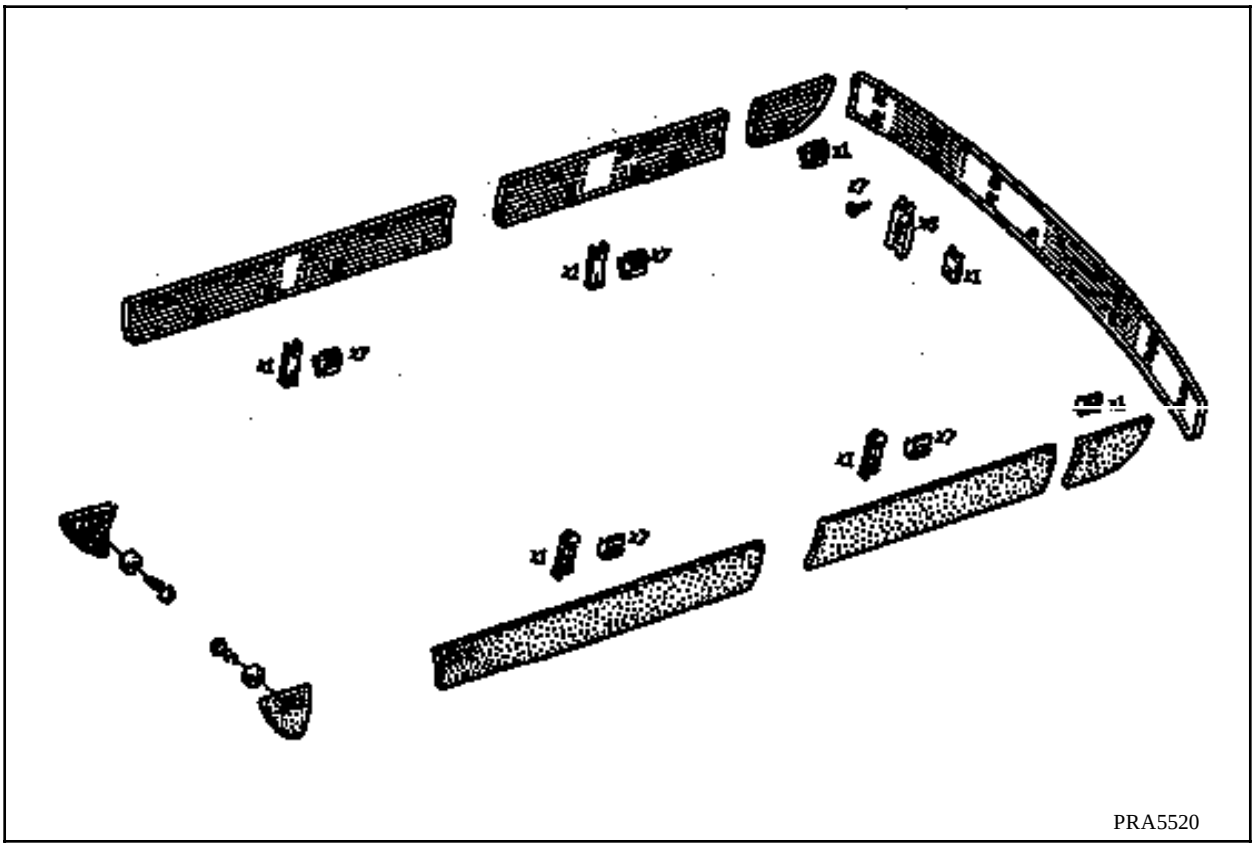
Smooth with a soaped glove, taking care not to move the bonded panel.

Remove the two strips of adhesive tape immediately without waiting for complete polymerisation.

Use water to check the sealing.

Remove the protective strips inside once polymerisation has occurred .

Side protection strips



The strips are clipped from the inside and are secured at both ends with double sided adhesive.

REMOVING THE VALANCE STRIP

Partially release the rear mudguards.

Unclip the inner retaining clip.

Pull off the double sided adhesive on the strip.

Remove the valance strip.

REFITTING

Refitting is the reverse of removal.