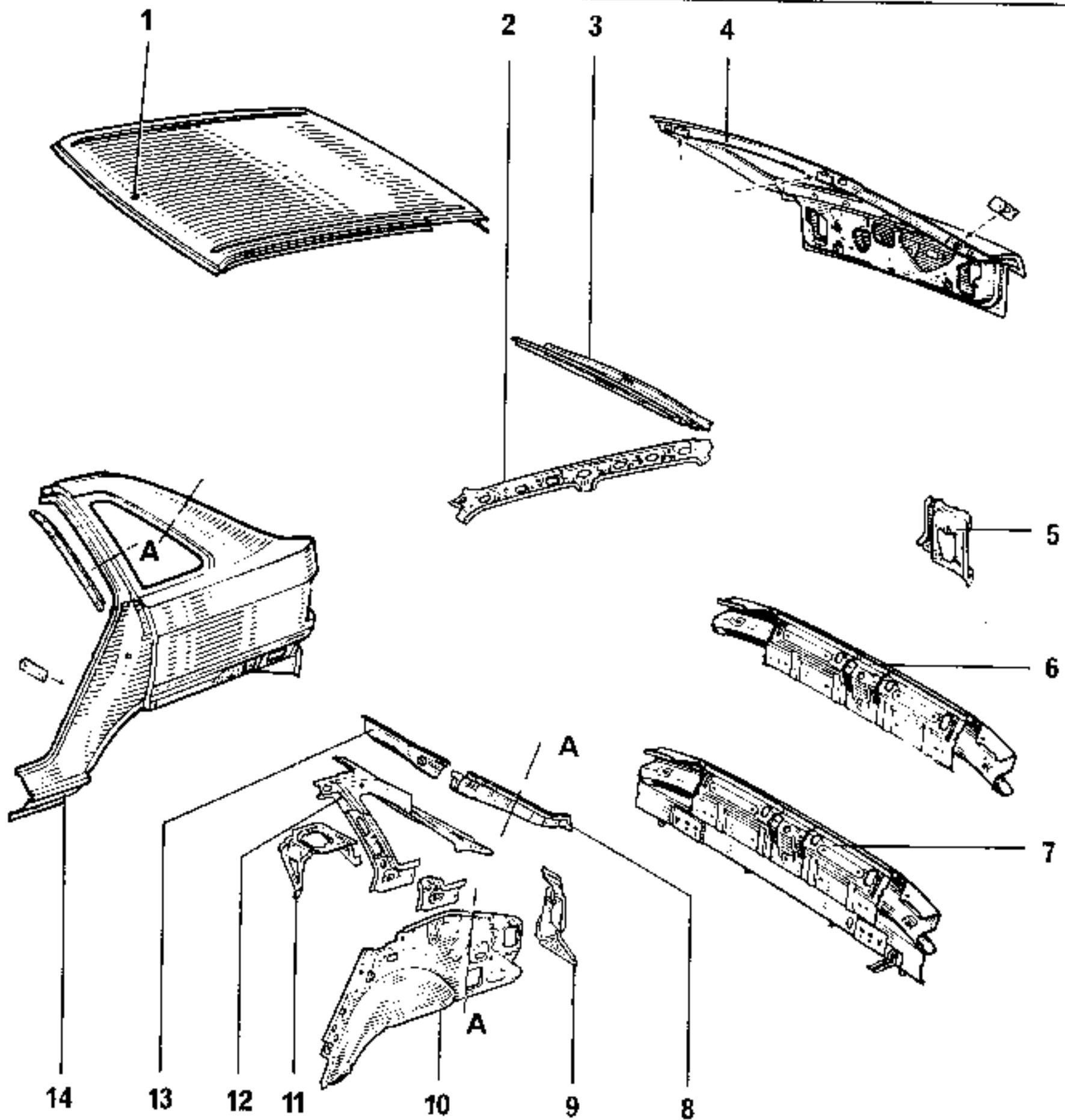
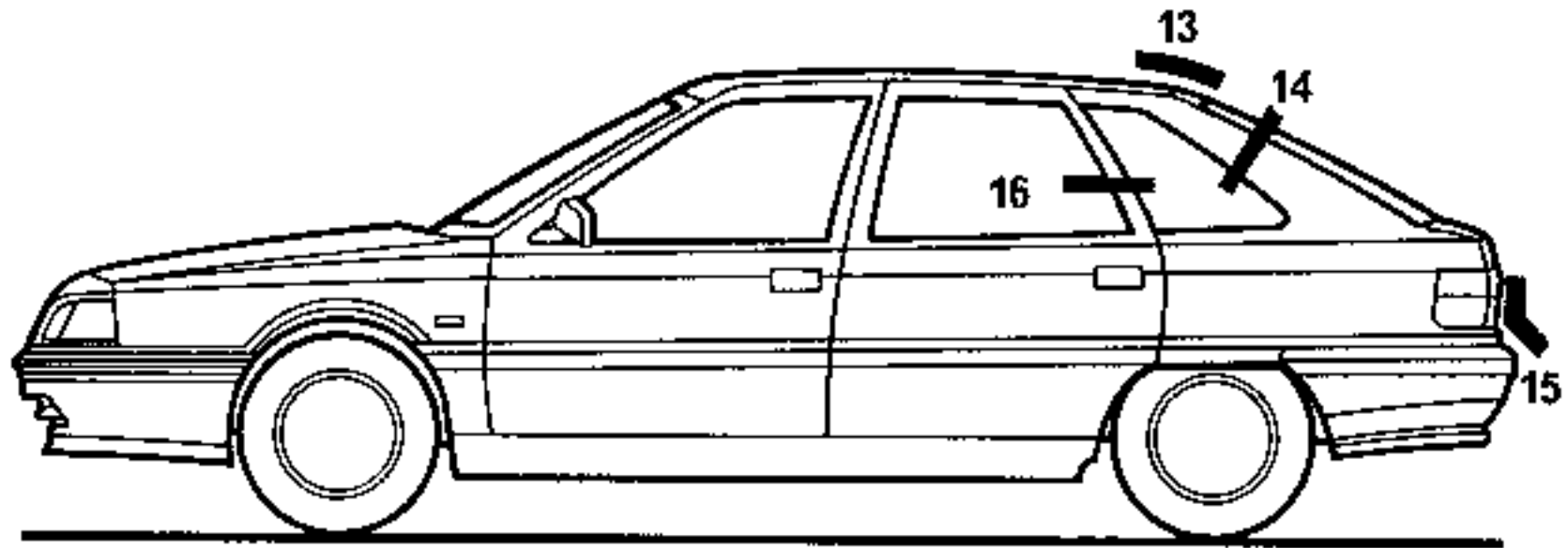


93070

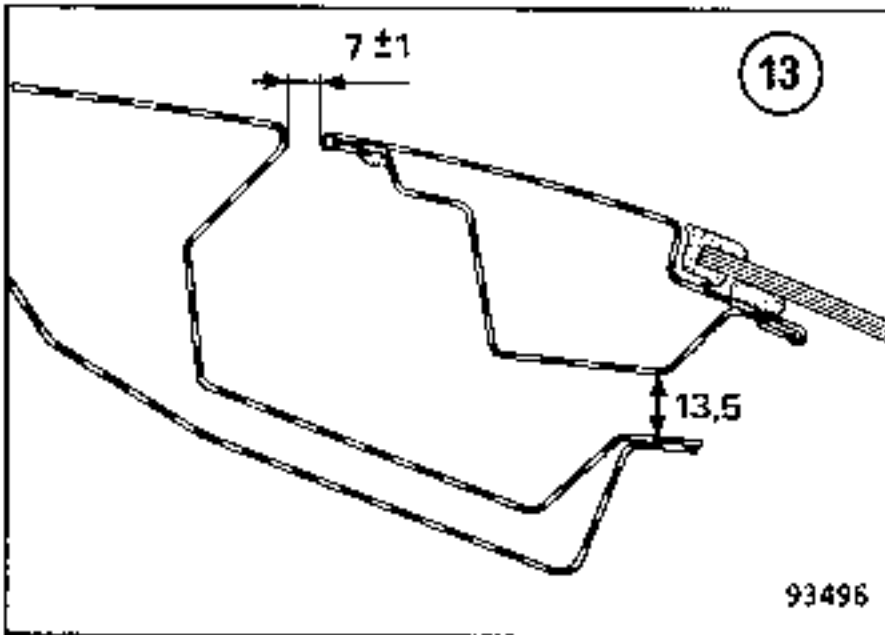
Mark	Dimensions in metres			
	transverse	in-line		4 x 4
A	2659	2600		2594
B	4461			
C	1400	1390	TURBO D	1425
			1395	
D	1435	1454		
E	1400	1400	ABS	ABS
			1408	1423
F	1726			



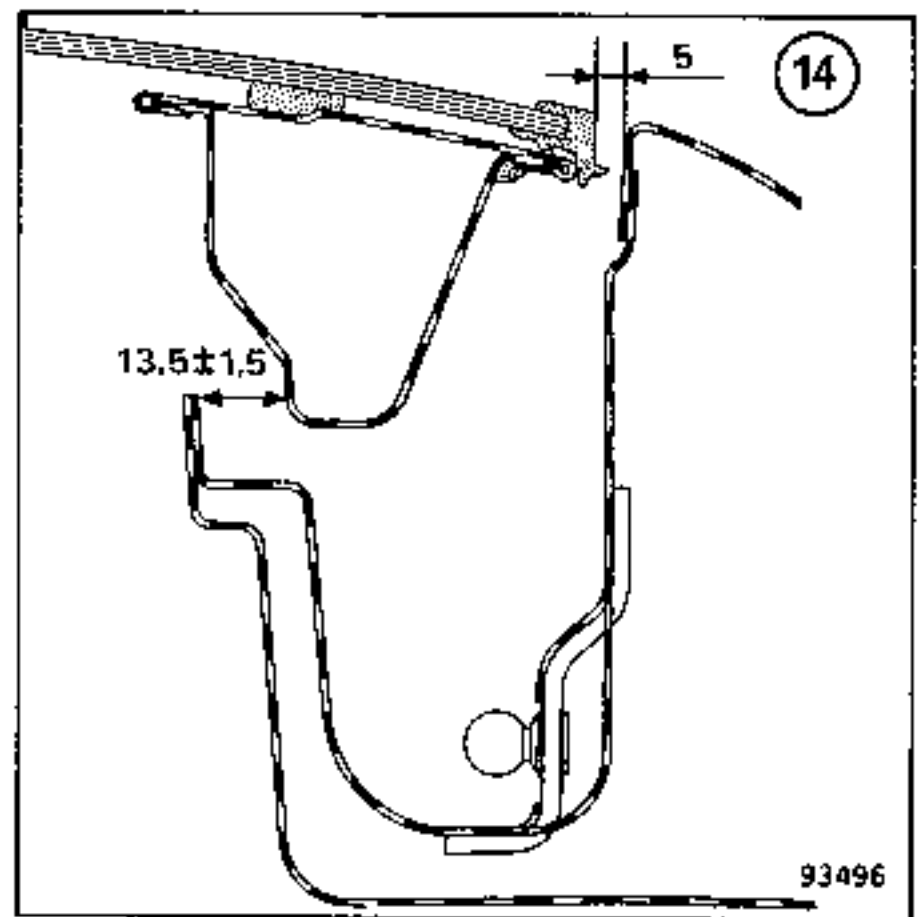
- |                                 |  |
|---------------------------------|--|
| 1. Roof                         | 12. Rear quarter panel lining assembly |
| 2. Stretcher lining             | 13. Rain channel upper gusset          |
| 3. Roof rear cross-member       | 14. Complete wing panel                |
| 4. Tailgate                     | 14A. Part wing panel                   |
| 5. Light unit mounting panel    |  |
| 6. Rear end panel with lining   |  |
| 7. Rear end panel assembly      |  |
| 8. Side rain channel            |  |
| 8A. Part side rain channel      |  |
| 9. Lower far rear pillar lining |  |
| 10. Outer wheel arch            |  |
| 10A. Part outer wheel arch      |  |
| 11. Rear parcel shelf mounting  |  |



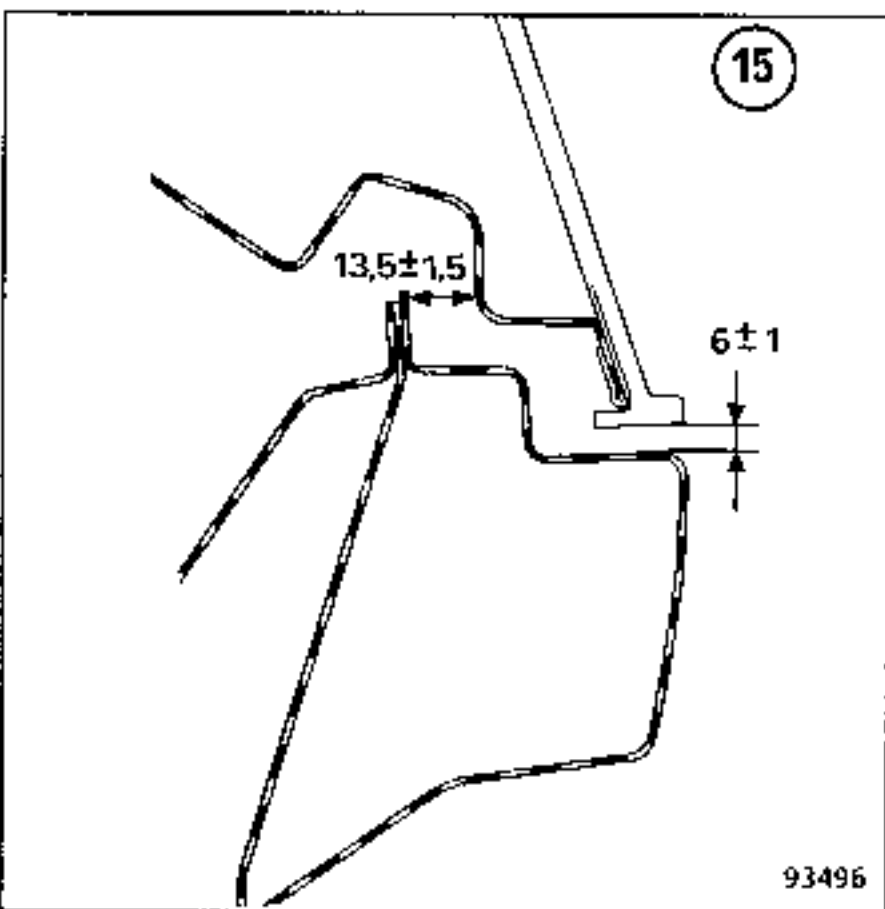
93070



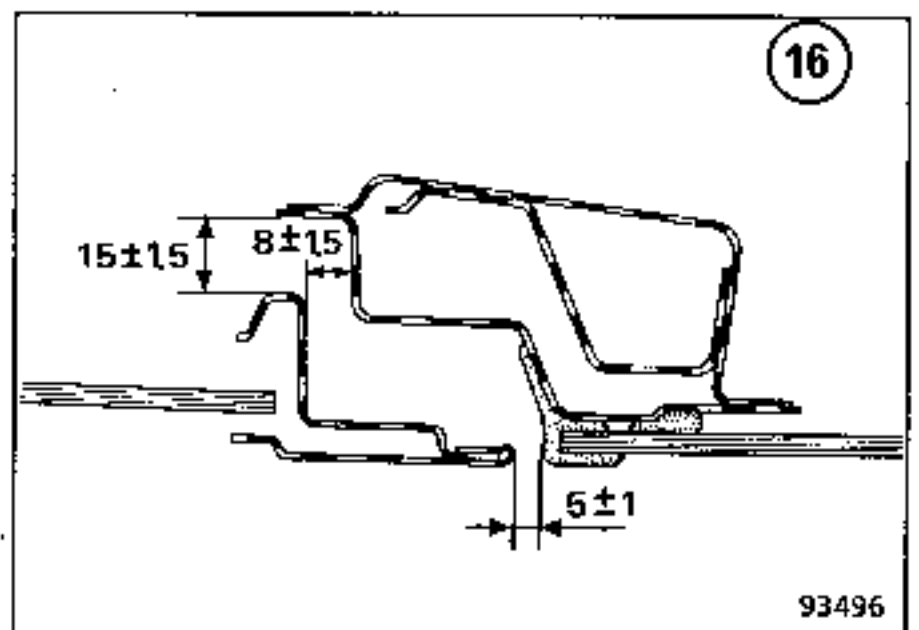
93496



93496



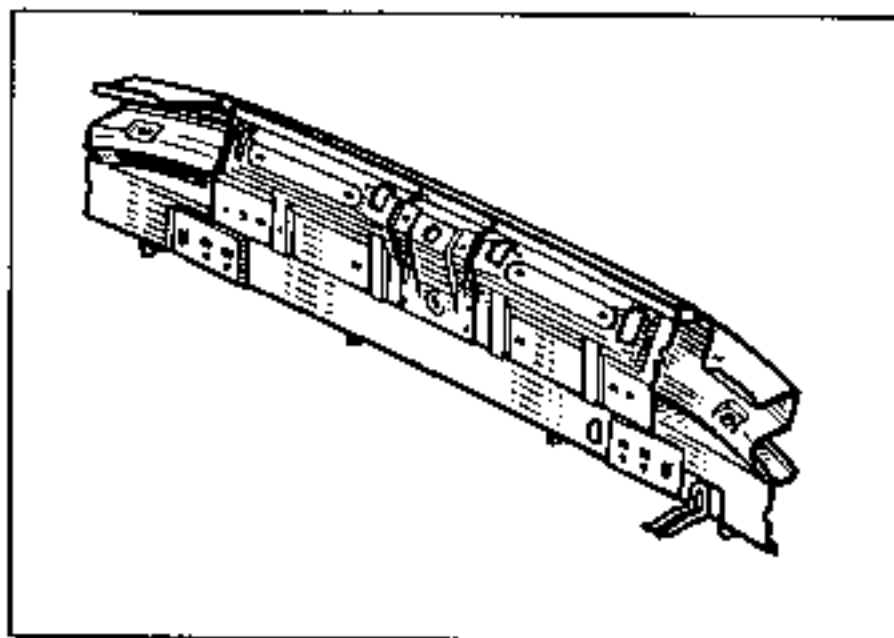
93496



93496

COMPOSITION OF PARTS AS SUPPLIED BY THE PARTS DEPARTMENT.

Assembled part comprising:  
floor panel rear cross-member  
rear end panel  
rear end panel lining  
striker plate strengthener



# 1 CONNECTION WITH LIGHT UNIT MOUNTING PANEL

Panel thickness (mm)

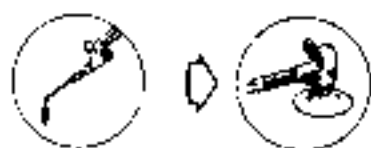
Rear end panel	0.67
Light unit mounting panel	0.87
Lower far rear pillar lining	0.77



Unpicking

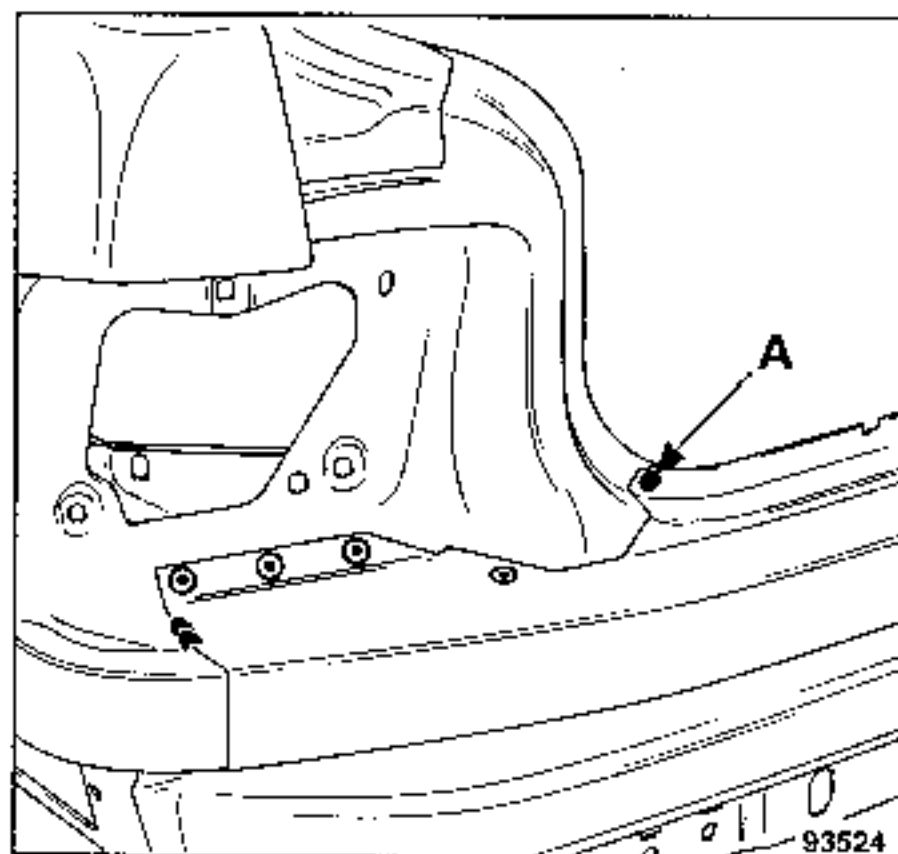


5 - 5 electric spot welds



1 + 1 10 mm soldering joint bead

## WELDING



1 + 1 10 mm M.I.G. welded bead



(A) 1 weld through 3 thicknesses

## 2 CONNECTION WITH WING PANEL

Panel thickness (mm)

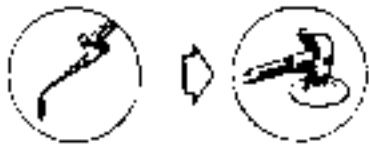
Rear end panel	0.67
Wing panel	0.77
Rear lower cross-member	1.20



Unpicking

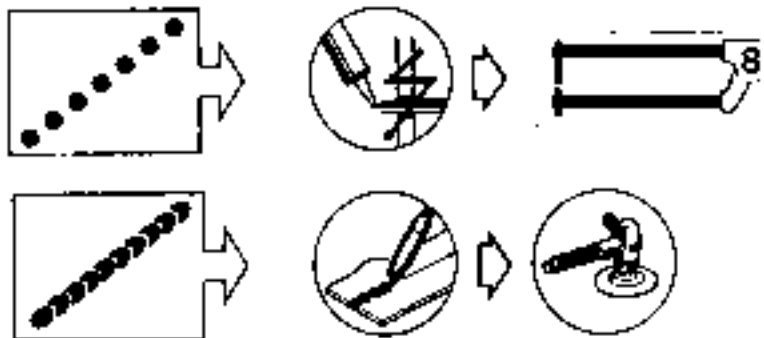
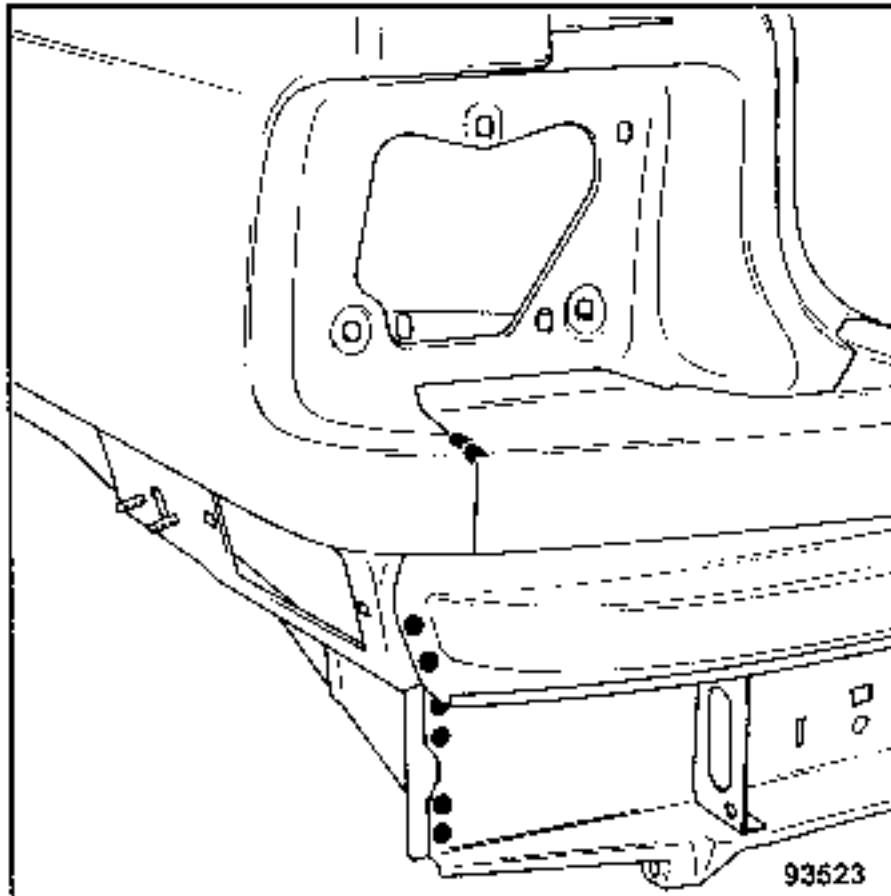


6 + 6 electric spot welds



1 + 1 10 mm soldering joint bead

### WELDING



1 + 1 10 mm M.T.G. welding bead



### 3 CONNECTION WITH LOWER FAR REAR PILLAR LINING

Panel thickness (mm)

Rear end panel	0.67
Rear end panel lining	0.67
Lower far rear pillar lining	0.77
Rear lower cross-member	1.20

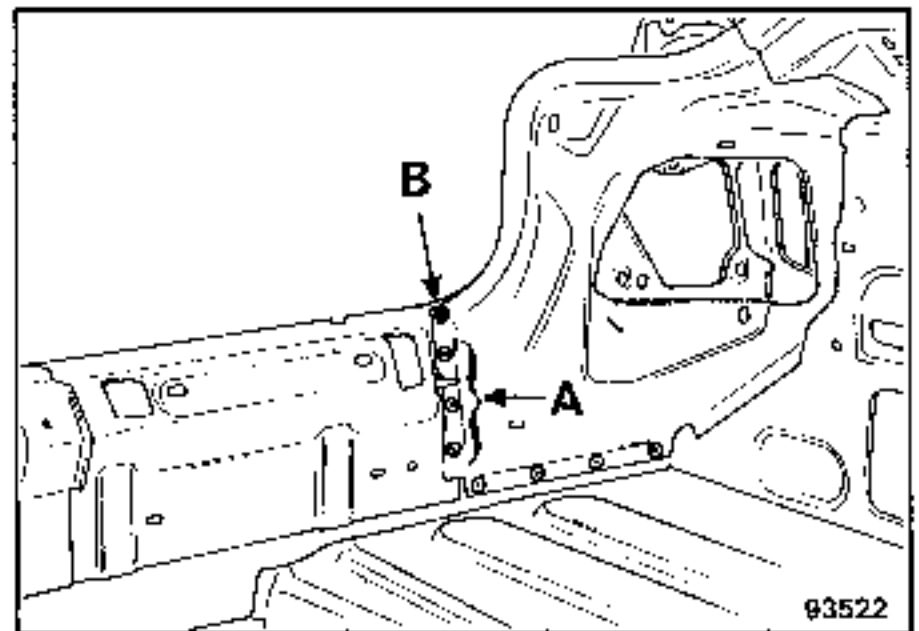
### Unpicking



(A) See "welding"

8 + 8 electric spot welds

### Welding



(B) 1 weld through 3 thicknesses



**4** CONNECTION WITH REAR SIDE MEMBER

Panel thickness (mm)

Rear lower cross-member 1.20

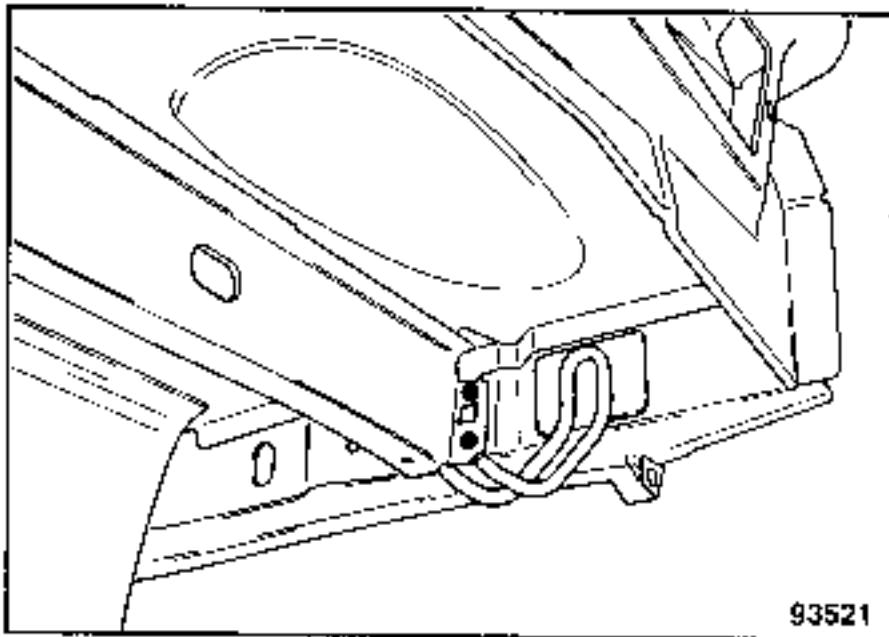
Rear side member 1.50

Unpicking

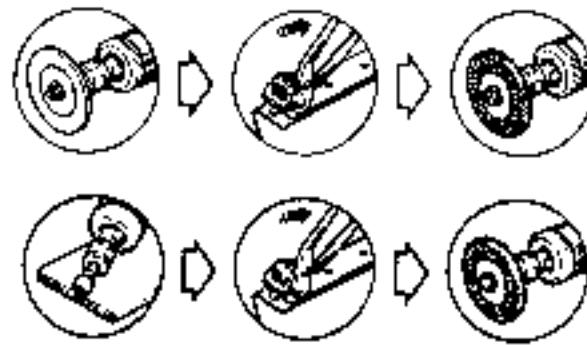


2 + 2 electric spot welds

Welding

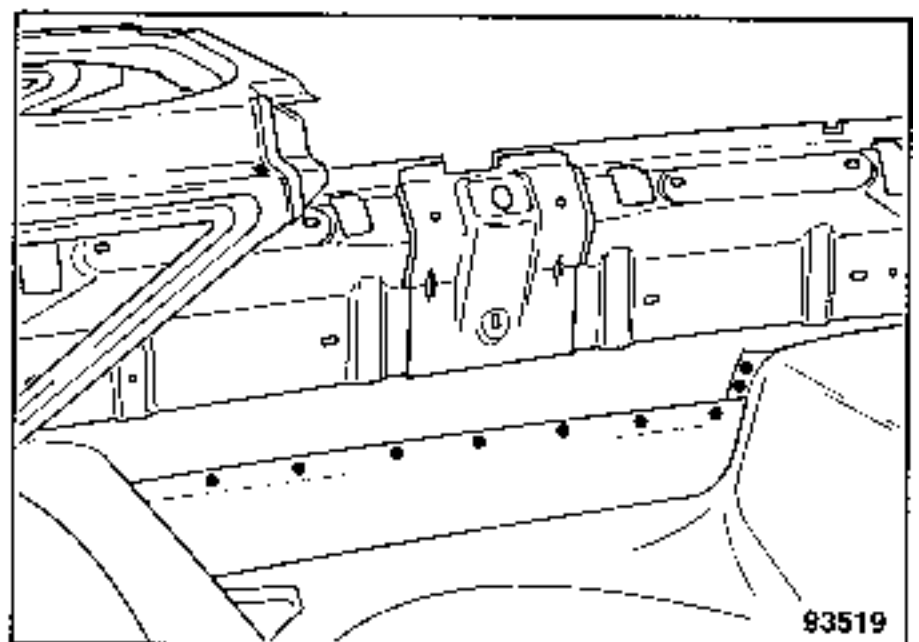
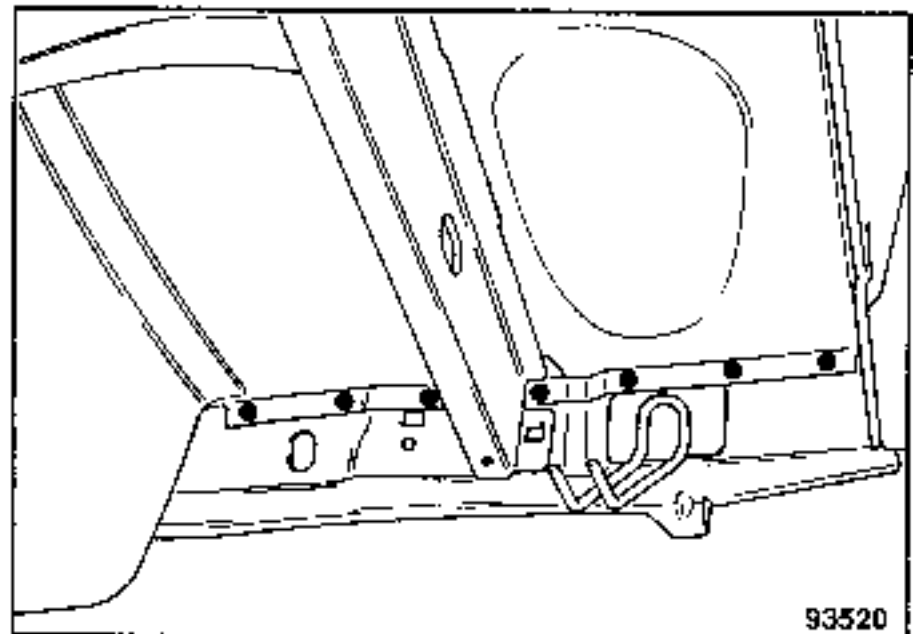


Unpicking



26 electric spot welds

Welding



**5** CONNECTION WITH REAR FLOOR PANEL  
REAR SECTION

Panel thickness (mm)

Lower rear cross-member 1.20

Floor panel closure plate 0.62

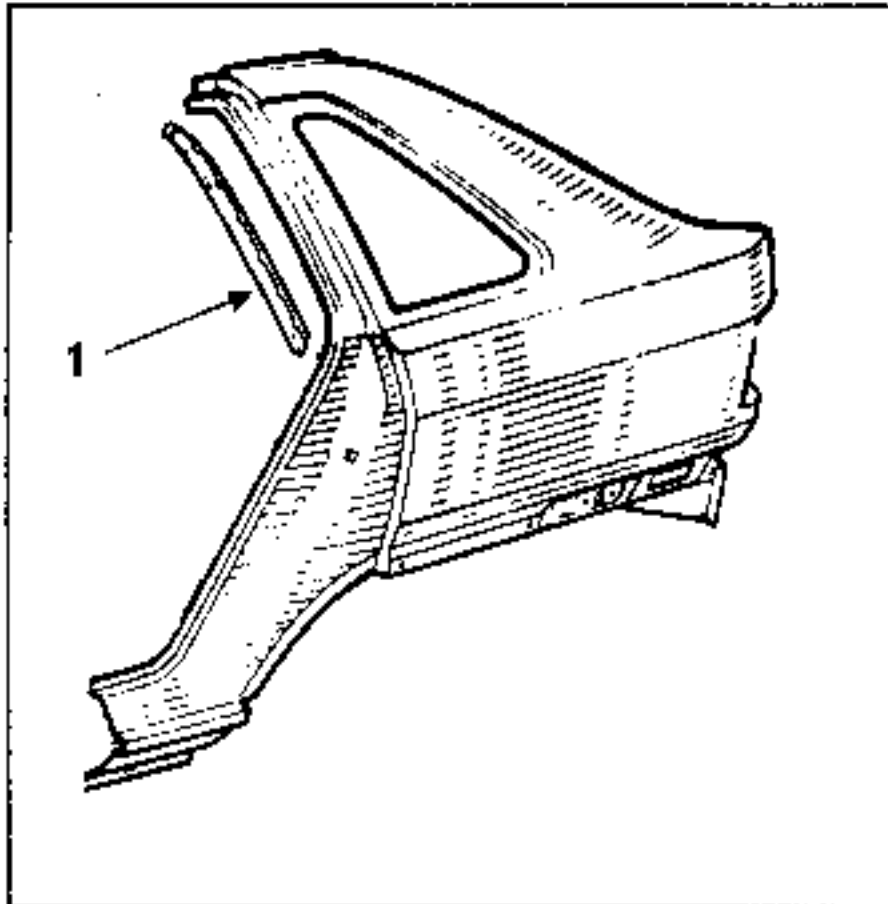
Rear floor panel rear section 0.60



This operation can only be performed when the roof has been removed.

COMPOSITION OF PARTS AS SUPPLIED BY THE PARTS DEPARTMENT.

Single part, seal support (1) is to be ordered separately.



# 1 CONNECTION WITH BODY TOP

Panel thickness (mm)

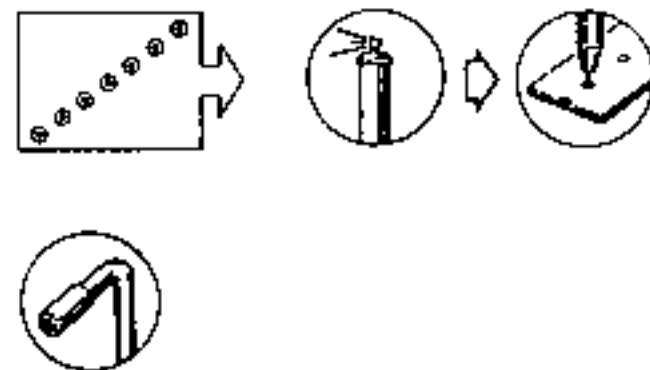
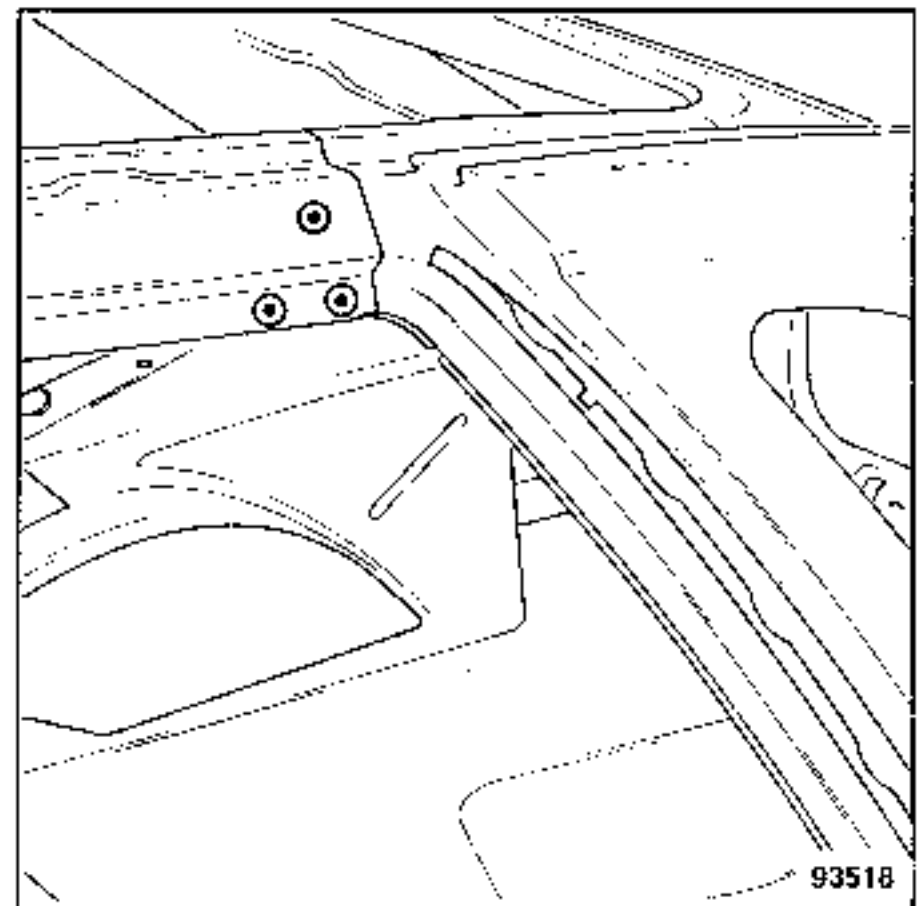
Wing panel	0.77
Body side	0.77
Stretcher lining	0.67
Upper strengthener	0.97

Unpicking



3 electric spot welds

Welding



# 2 RAIN CHANNEL AND UPPER GUSSET CONNECTION

Panel thickness (mm)

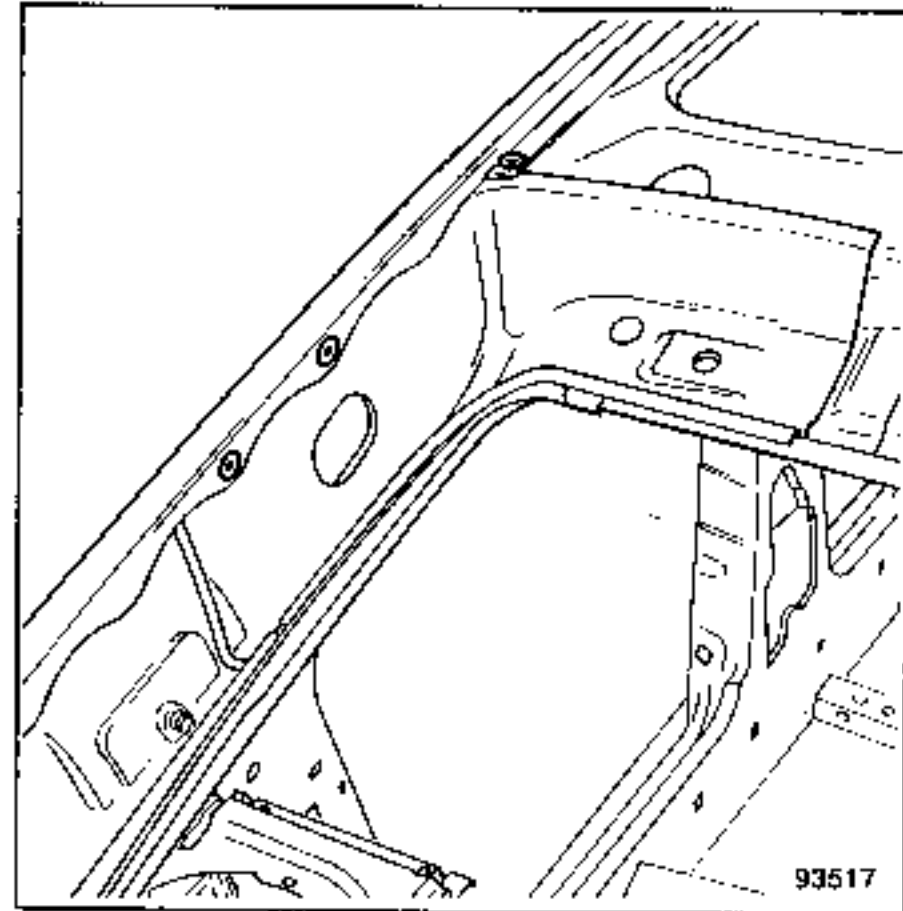
Wing panel	0.77
Rain channel	
upper gusset	1.50

Unpicking

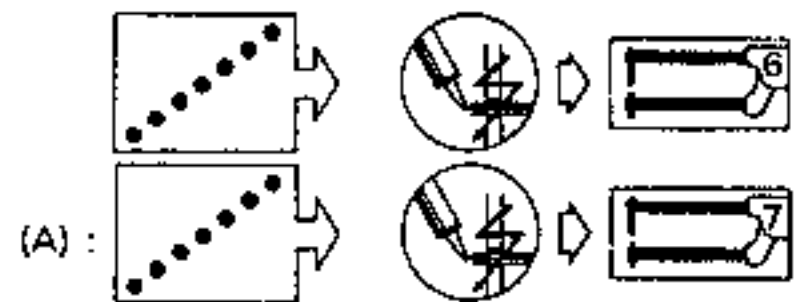
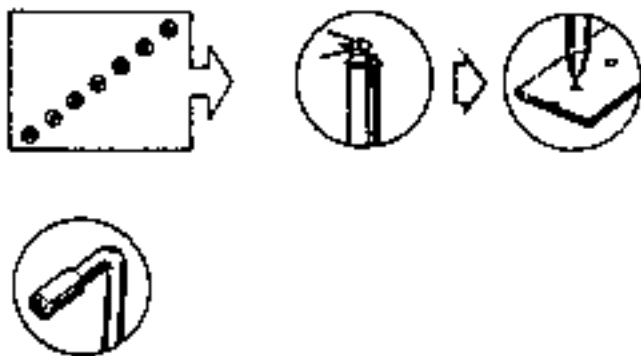
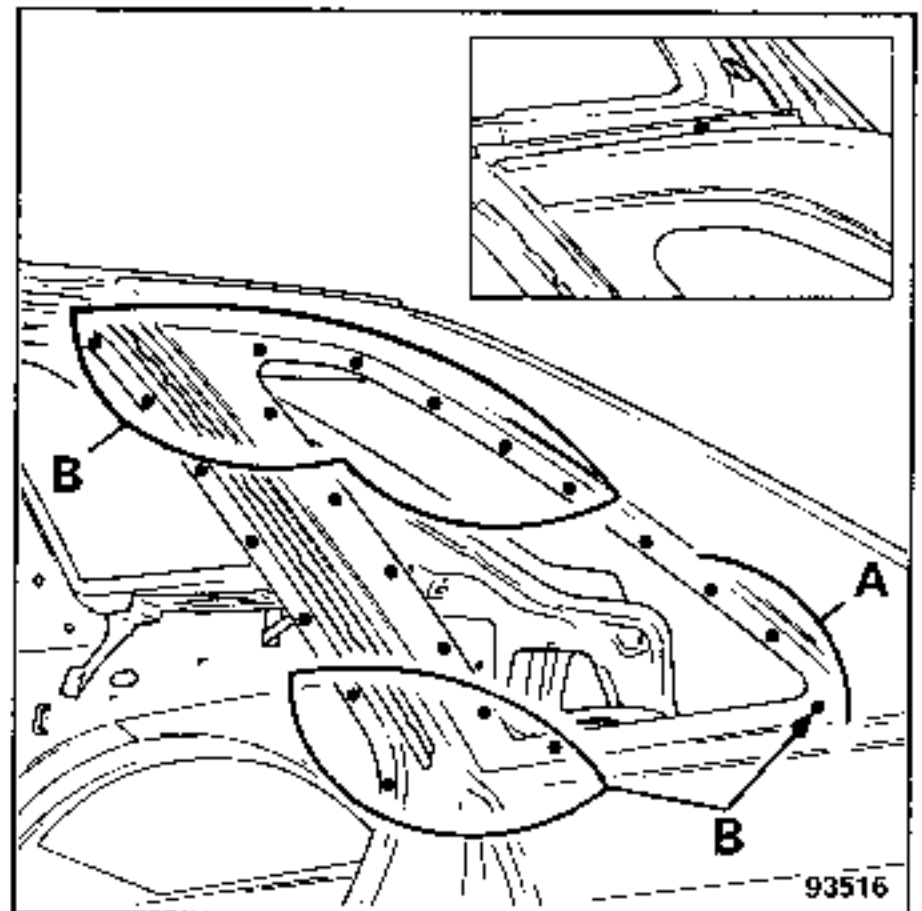


3 electric spot welds

Welding



Welding



3

CONNECTION WITH REAR QUARTER  
PANEL LINING

Panel thickness (mm)

Wing panel	0.77
Rear quarter panel lining	0.67
Upper strengthener	0.97
Upper far rear pillar lining	0.77
Outer wheel arch	0.67
Seat mounting strengtheners	1.50

(B) : 13 welds through 3 thicknesses



Unpicking

23 electric spot welds



**4** CONNECTION WITH SIDE RAIN CHANNEL

Panel thickness (mm)

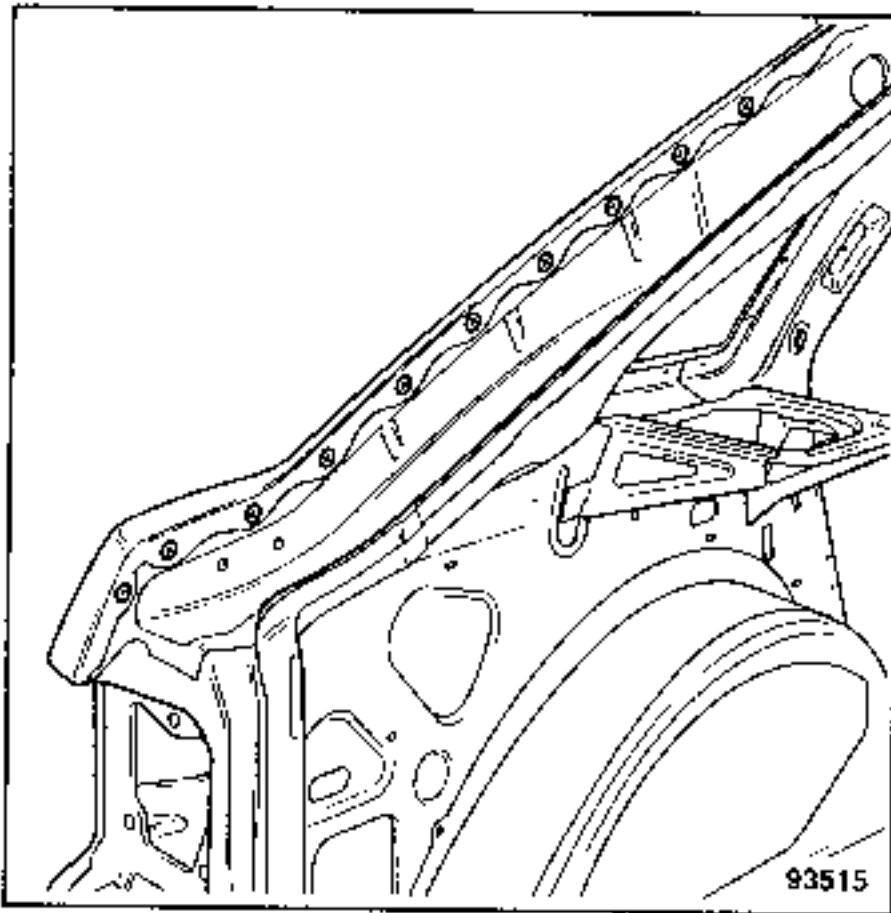
Wing panel	0.77
Side rain channel	0.77

Unpicking



10 electric spot welds

Welding



**5** LIGHT UNIT CARRIER PANEL CONNECTION

Panel thickness (mm)

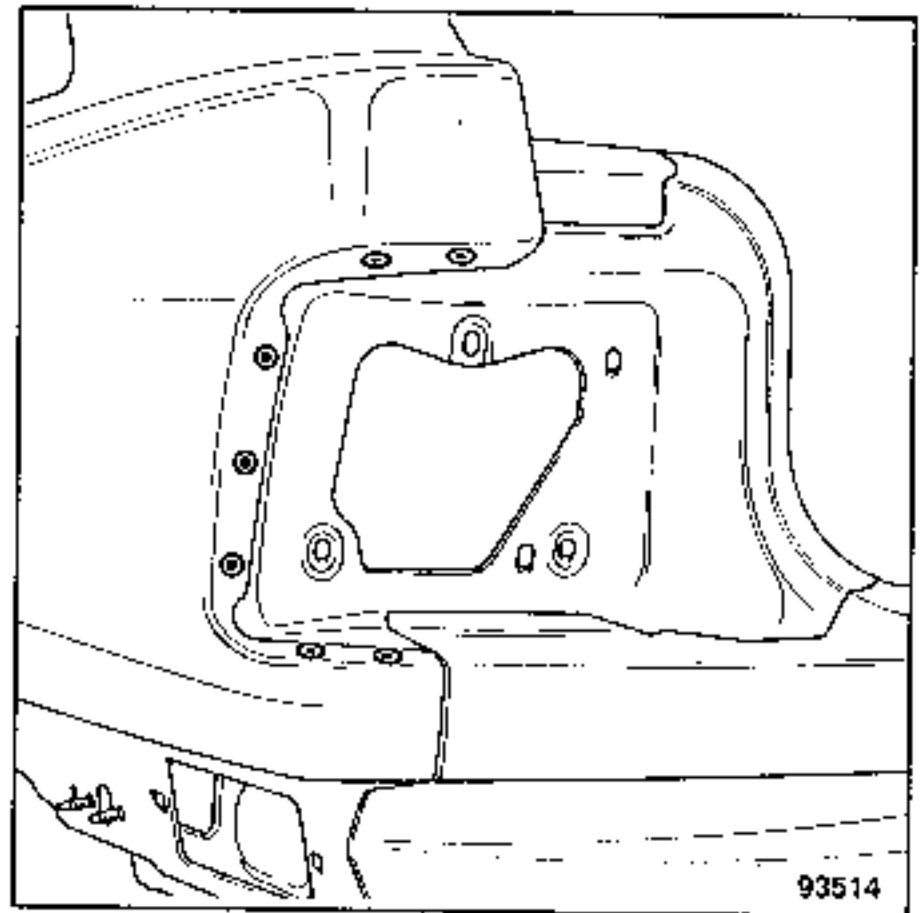
Wing panel	0.77
light unit carrier panel	0.87

Unpicking



7 electric spot welds

Welding



## 6 CONNECTION WITH REAR END PANEL

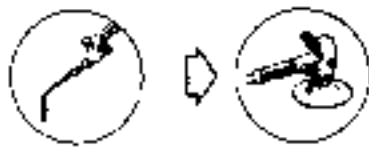
Panel thickness (mm)

Wing panel	0.77
Rear end panel	0.67

Unpicking

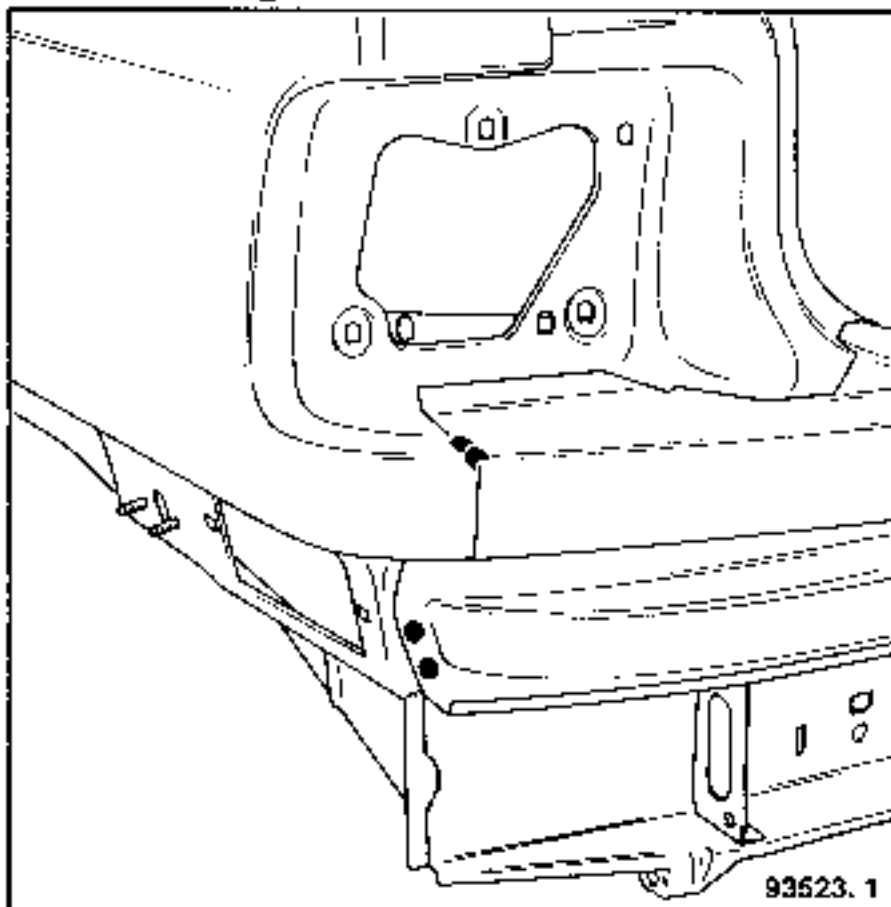


2 electric spot welds



1 10 mm soldering joint bead

Welding



1 10 mm M.I.G. welding bead



## 7 CONNECTION WITH REAR LOWER CROSS-MEMBER

Panel thickness (mm)

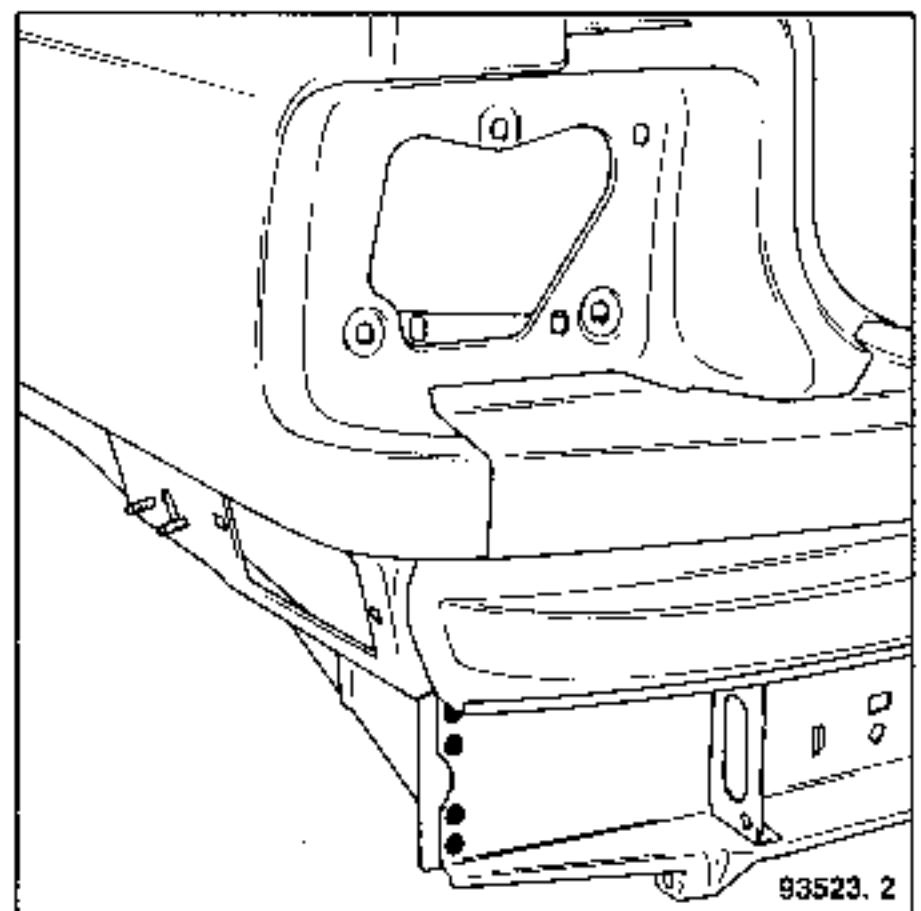
Wing panel	0.77
Rear lower cross-member	1.20

Unpicking



4 electric spot welds

Welding



## 8 CONNECTION WITH REAR SECTION OF REAR FLOOR PANEL

Panel thickness (mm)

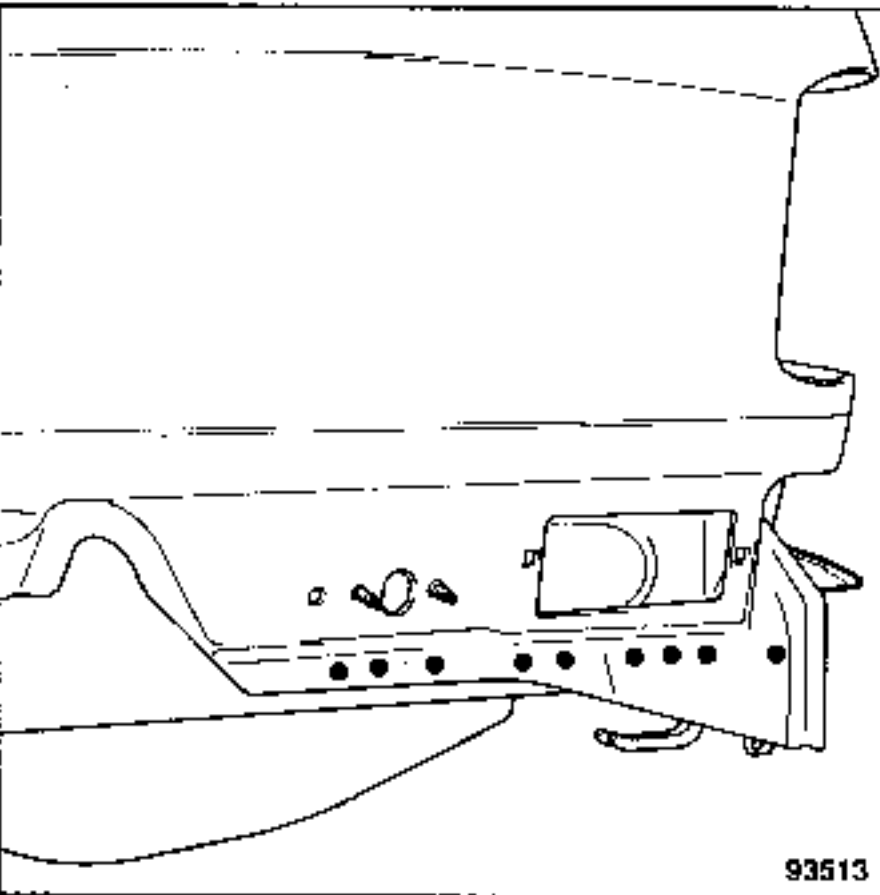
Wing panel	0.77
Outer wheel arch	0.67
Rear section of rear floor panel	0.60

# Unpicking



9 electric spot welds

# Welding



9 electric spot welds

## 9 CONNECTION WITH OUTER WHEEL ARCH

Panel thickness (mm)

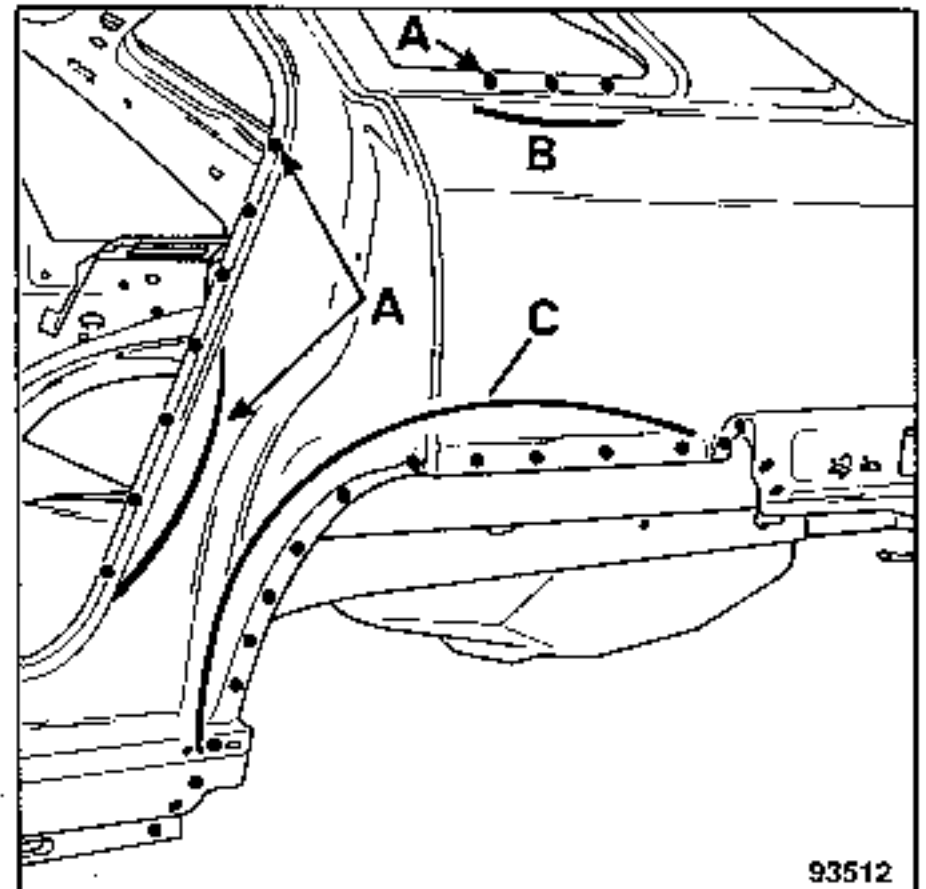
Wing panel	0.77
Outer wheel arch	0.67
Seat mounting strengtheners	1.50
Rear pillar strengtheners	0.97



28 electric spot welds

# Unpicking

# Welding



6 welds through 3 thicknesses



Electrode with pivot pin for  
11 spots for appearance



## 10 CONNECTION WITH VALENCE CLOSURE PANEL

Panel thickness (mm)

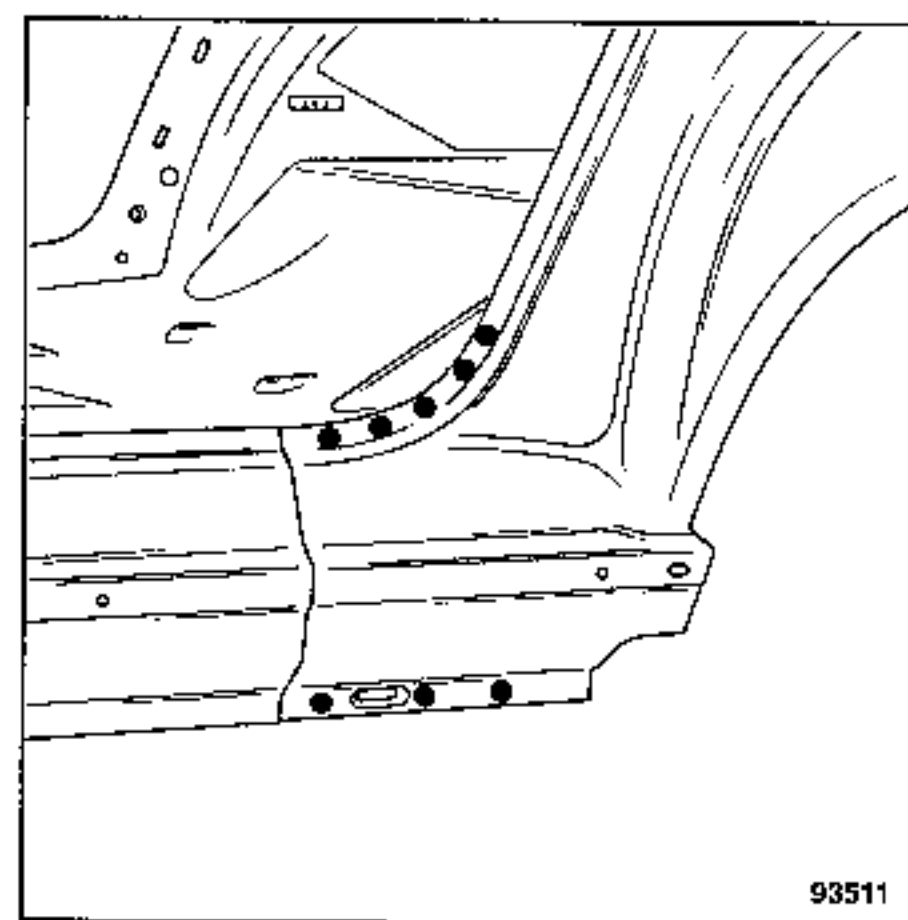
Valence closure panel	1.50
Wing panel	0.77
Rear pillar strengtheners	0.97

# Unpicking



8 electric spot welds

Welding



93511



8 plug welds through 3 thicknesses

**11** CONNECTION WITH BODY SILL

Panel thickness (mm)

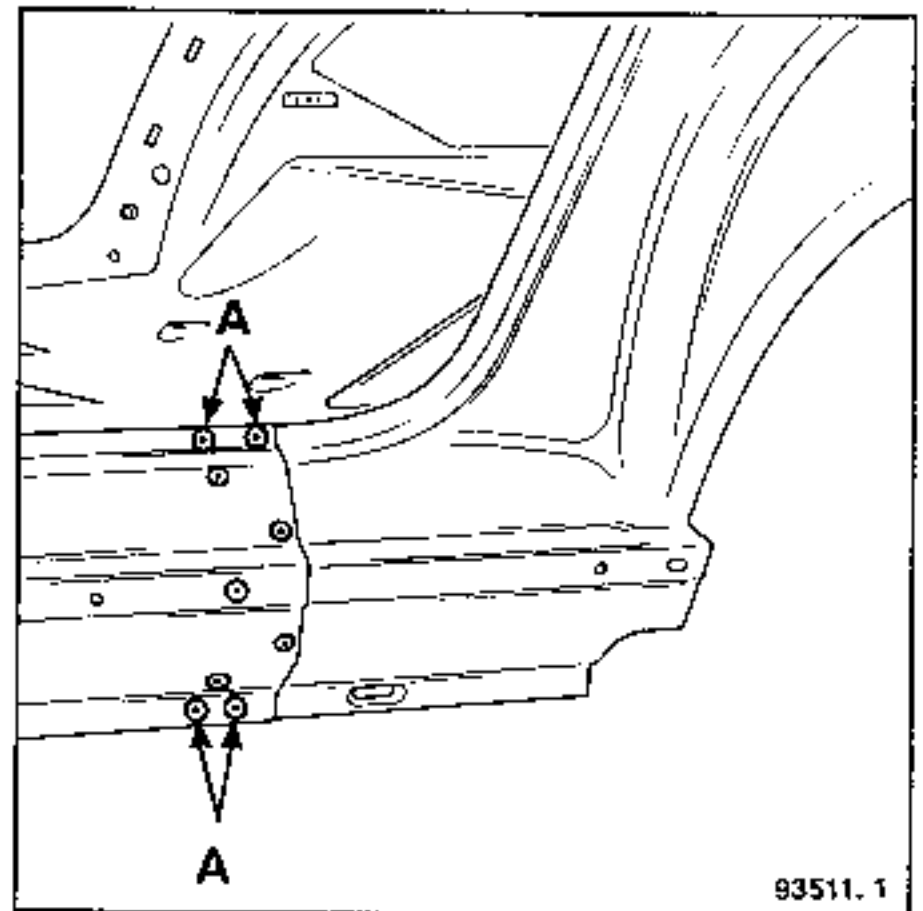
Wing panel	0.77
Body sill	0.77
Valance closure panel	1.50

Unpicking



9 electric spot welds

Welding



93511.1



(A) 4 plug welds through 3 thicknesses



**12** CONNECTION WITH ROOF

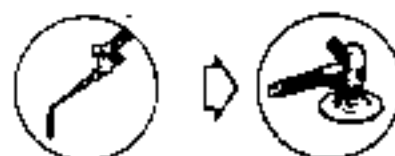
Panel thickness (mm)

Roof panel	0.77
Wing panel	0.77
Body side	0.77

Unpicking



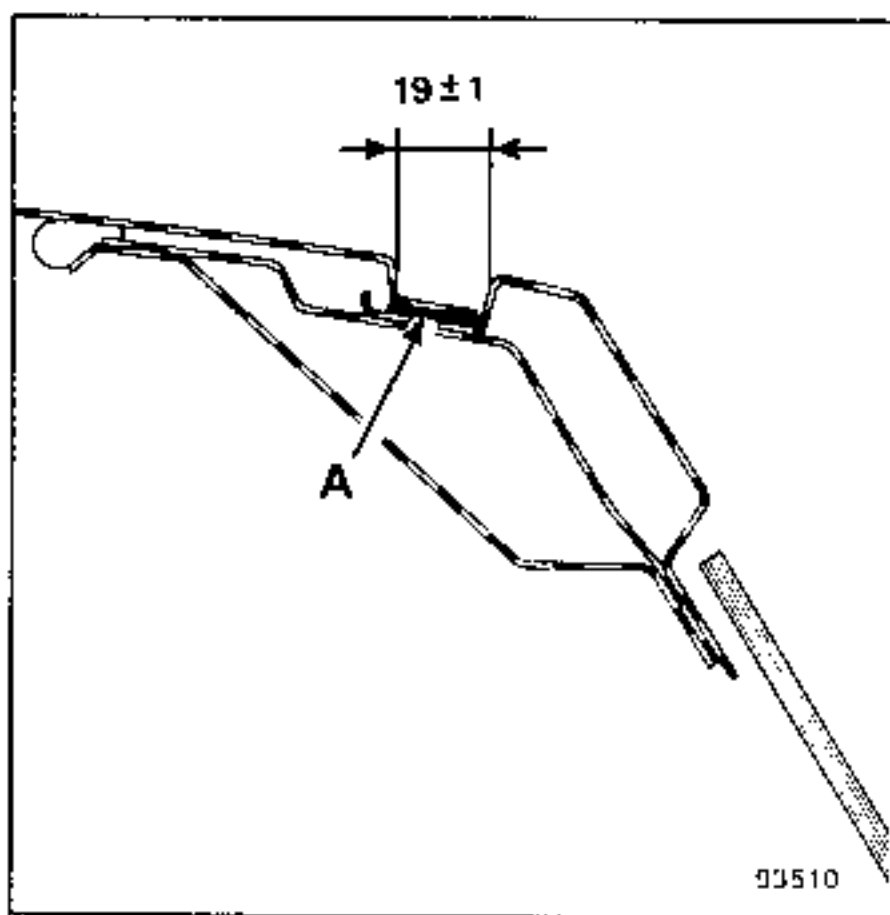
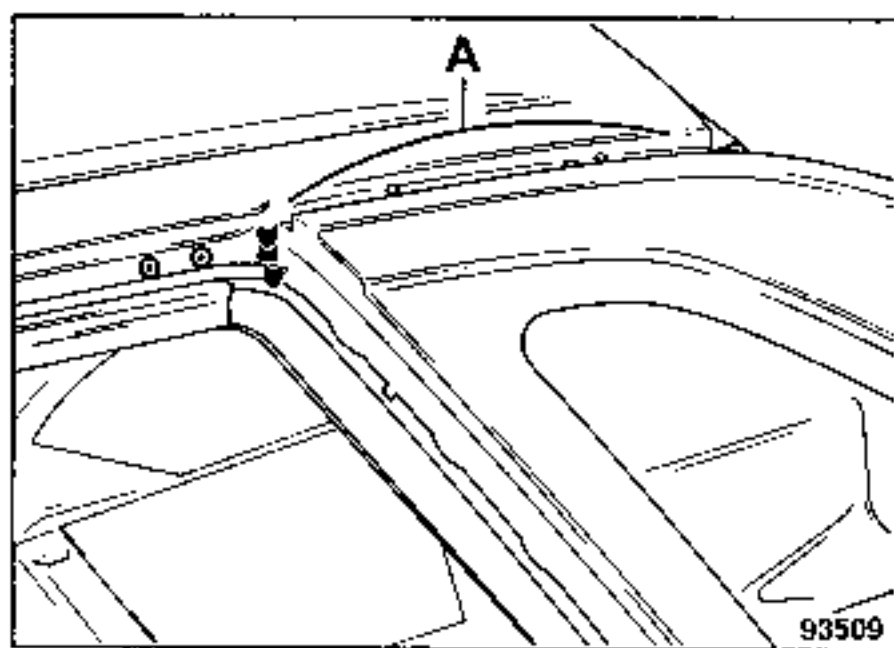
2 electric spot welds



1 50 mm soldering joint bead

At (A, see "welding") the roof is bonded to the wing panel. Use a hot air torch to separate the 2 parts.

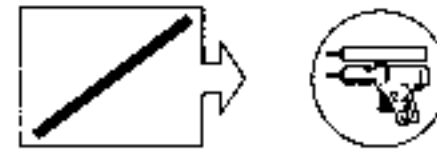
# Welding



Plug welding through 3 thicknesses



1 50 mm M.I.G. welding bead



(A) 1 250 mm bead of bonding mastic for metal.



## 13 CONNECTION WITH SEALING MOUNTING

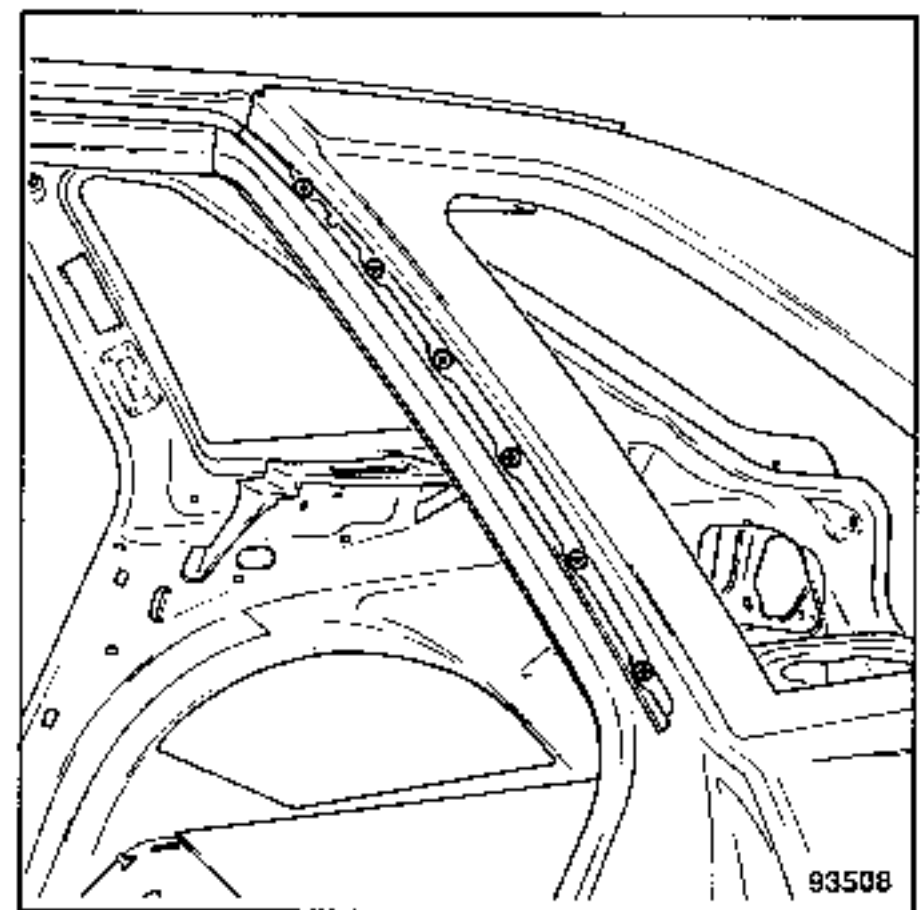
Panel thickness (mm)

Wing panel	0.77
Sealing mounting	0.67

Unpicking

This part cannot be recovered and must be ordered with the wing panel.

# Welding



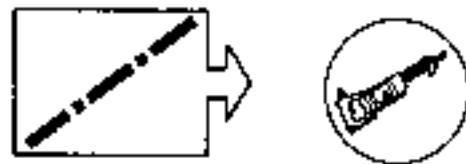
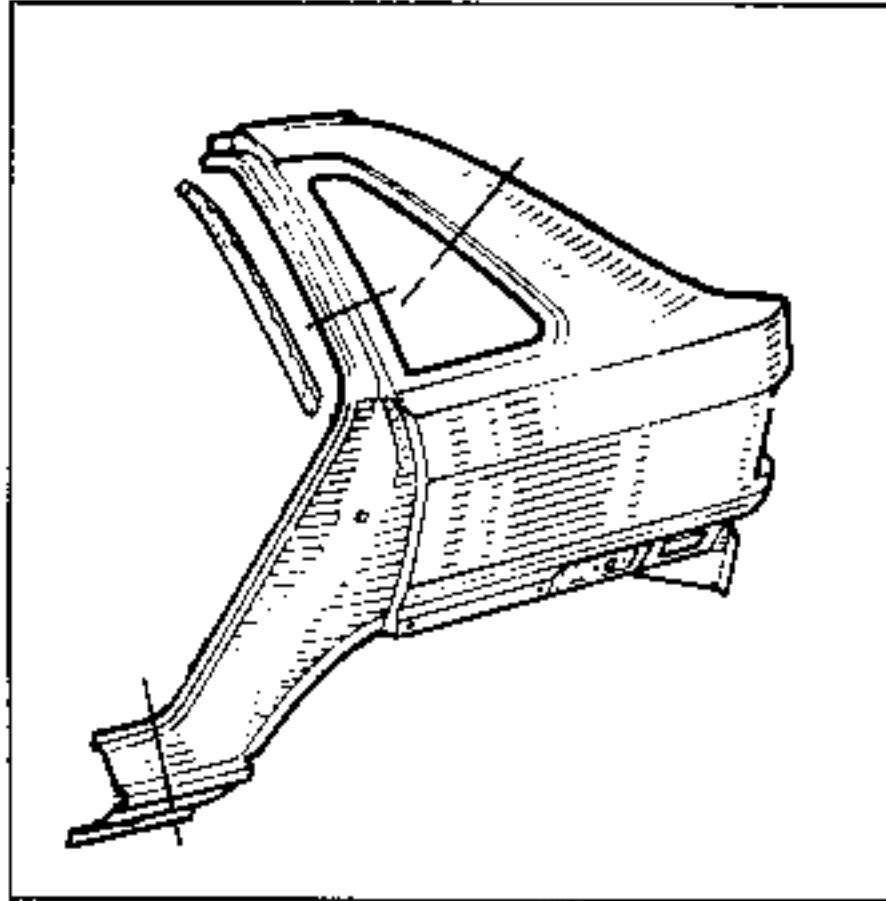
6 plug welds



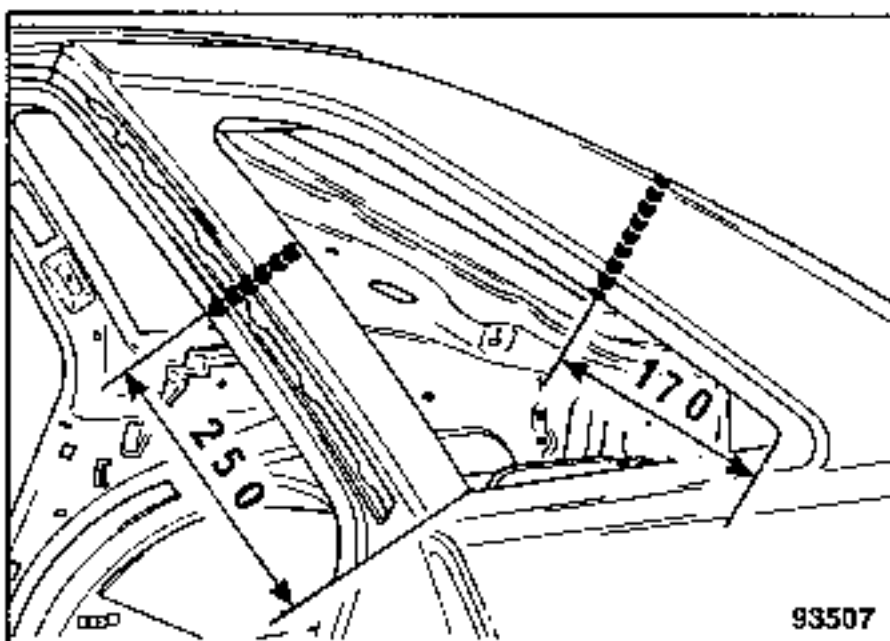
This operation is a variant of the preceding ones. Only the special points of this operation will be dealt with below.

COMPOSITION OF THE PARTS AS SUPPLIED BY THE PARTS DEPARTMENT.

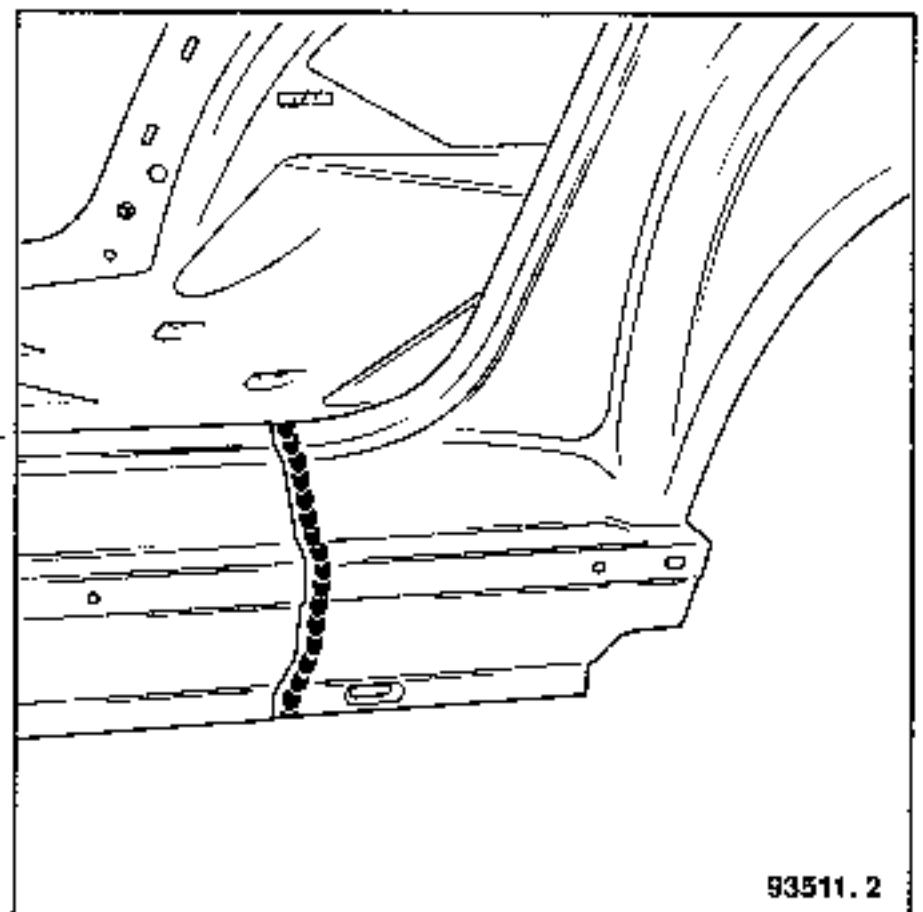
Identical to the preceding part.



Welding



93507

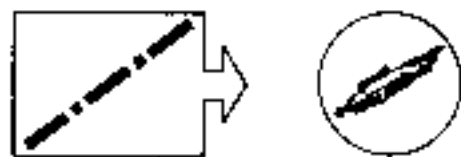
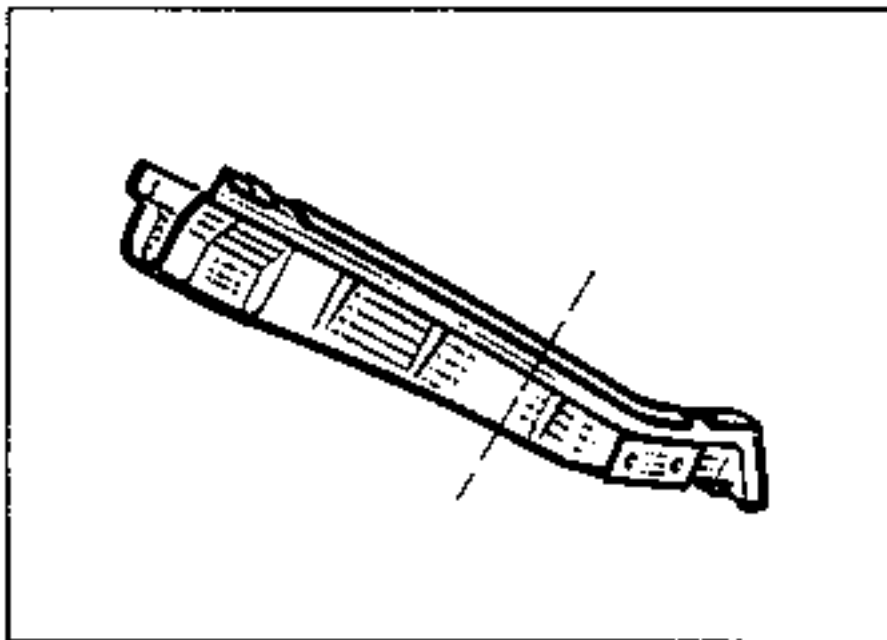


93511.2

This operation can only be performed when the wing panel has been removed.

COMPOSITION OF PARTS AS SUPPLIED BY THE PARTS DEPARTMENT.

Part alone.



# 1 CONNECTION WITH LIGHT UNIT CARRIER PANEL

Panel thickness (mm)

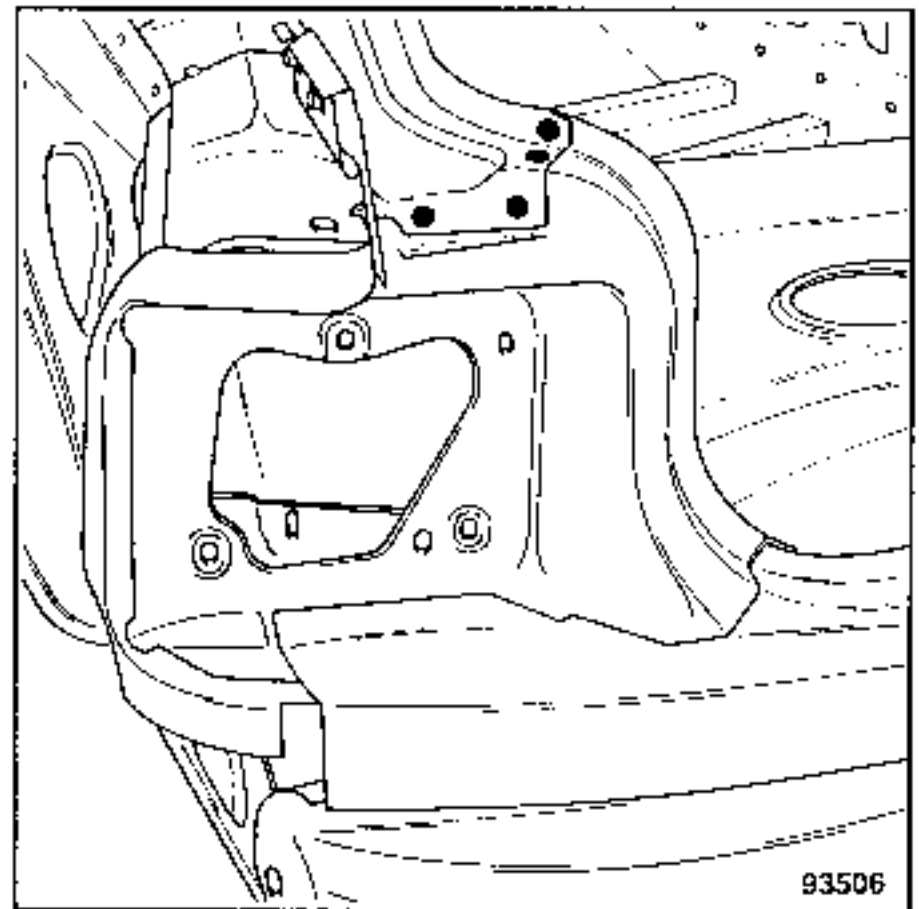
Side rain channel	0.67
Light unit carrier panel	0.87
Lower far rear pillar lining	0.77

Unpicking



4 electric spot welds

Welding



# (A) 1 weld through 3 thicknesses

## 2 CONNECTION WITH FAR REAR PILLAR LINING

Panel thickness (mm)

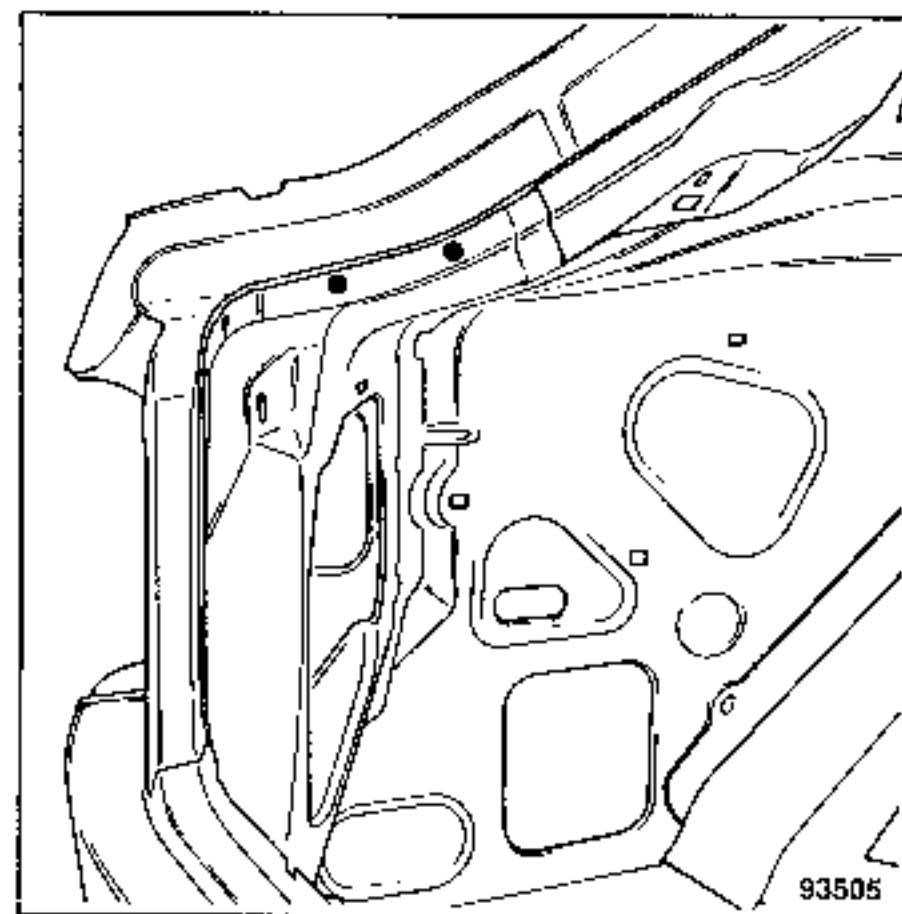
Side rain channel	0.67
Lower far rear pillar lining	0.77

Unpicking



2 electric spot welds

Welding



### 3 CONNECTION WITH REAR QUARTER PANEL LINING AND SECTION

Panel thickness (mm)

Upper far rear pillar lining	0.77
Lower far rear pillar lining	0.77
Side rain channel	0.67

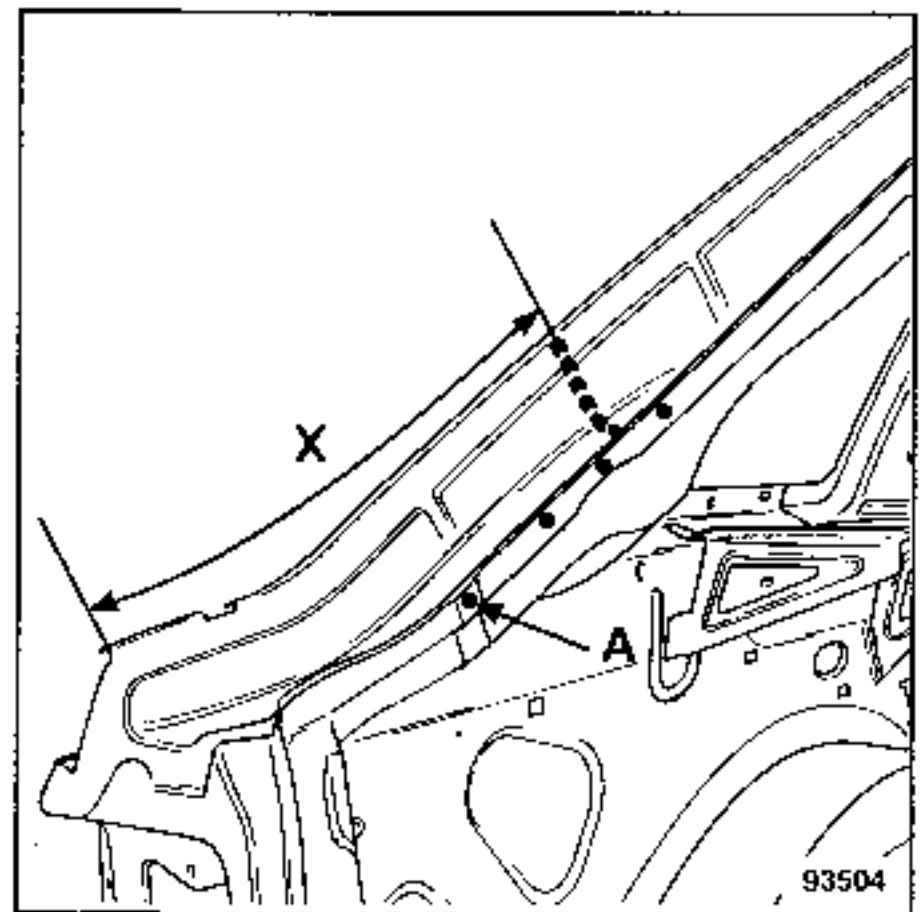
Unpicking



4 electric spot welds



Welding

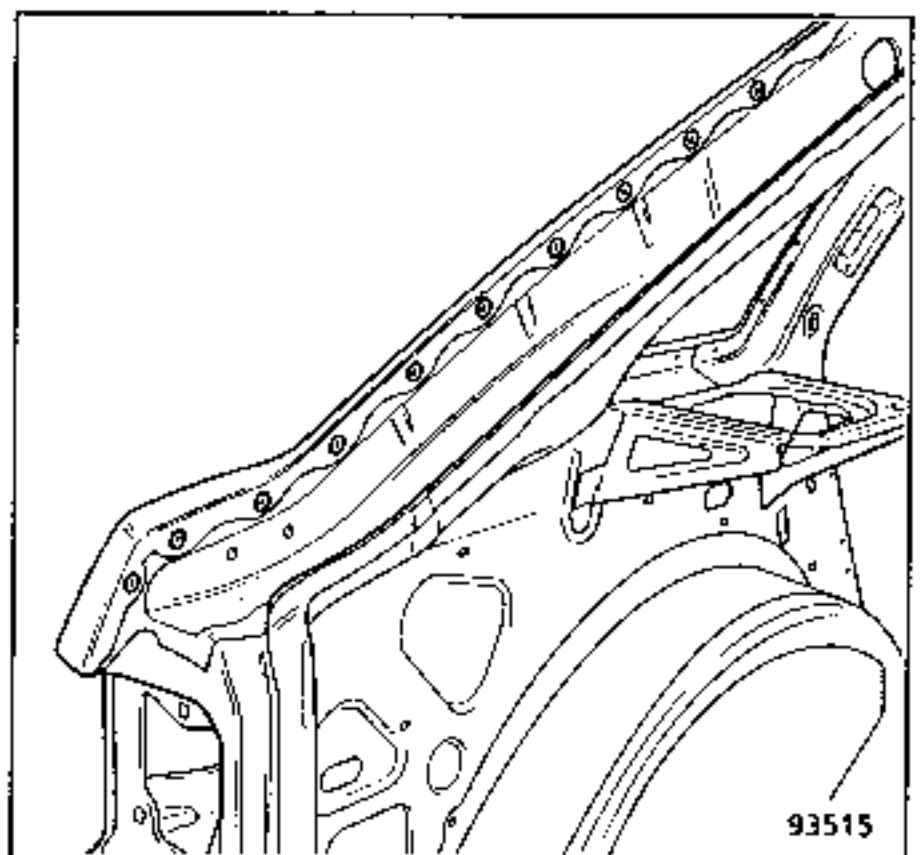


(A) 1 weld through 3 thicknesses  
X = 370 mm



### 4 CONNECTION WITH WING PANEL

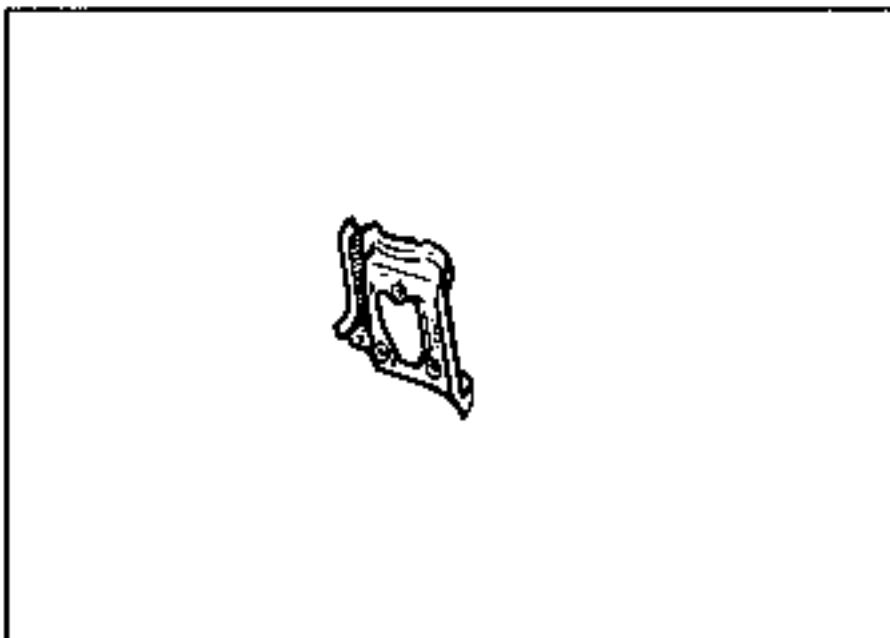
Remember: See 44-A-4





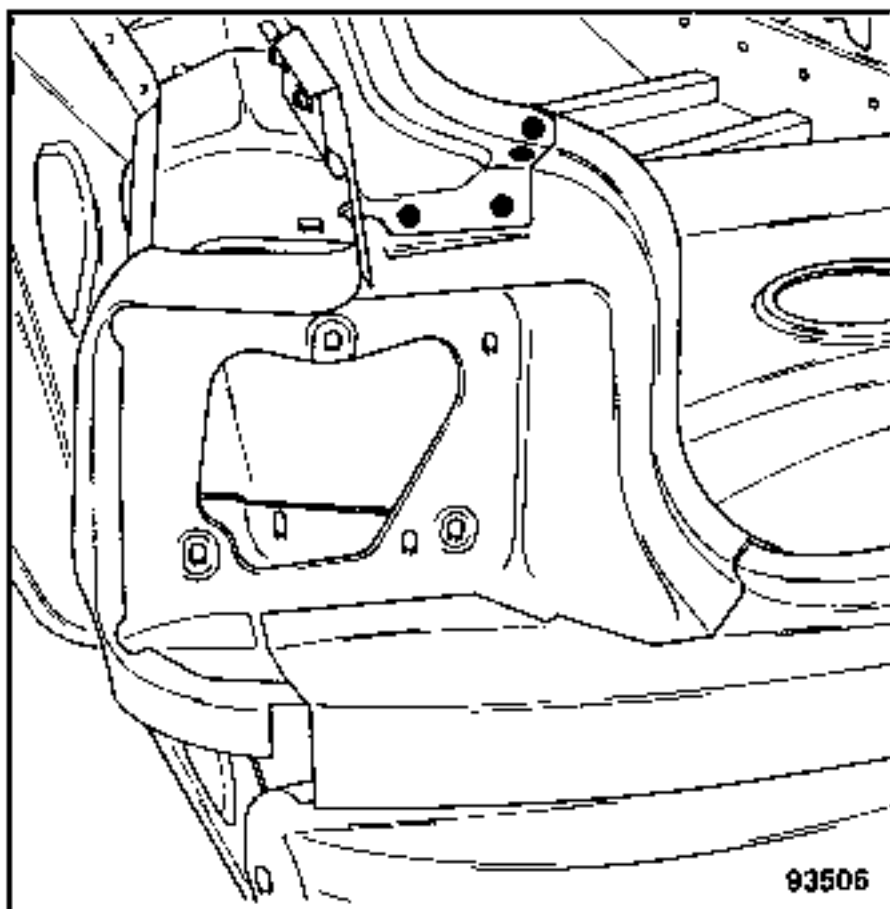
COMPOSITION OF PARTS AS SUPPLIED BY THE  
PARTS DEPARTMENT.

Part alone.



**1** CONNECTION WITH SIDE RAIN CHANNEL

Remember: See 44-C-1



**2** CONNECTION WITH OUTER WHEEL ARCH

Panel thickness (mm)

Outer wheel arch 0.67

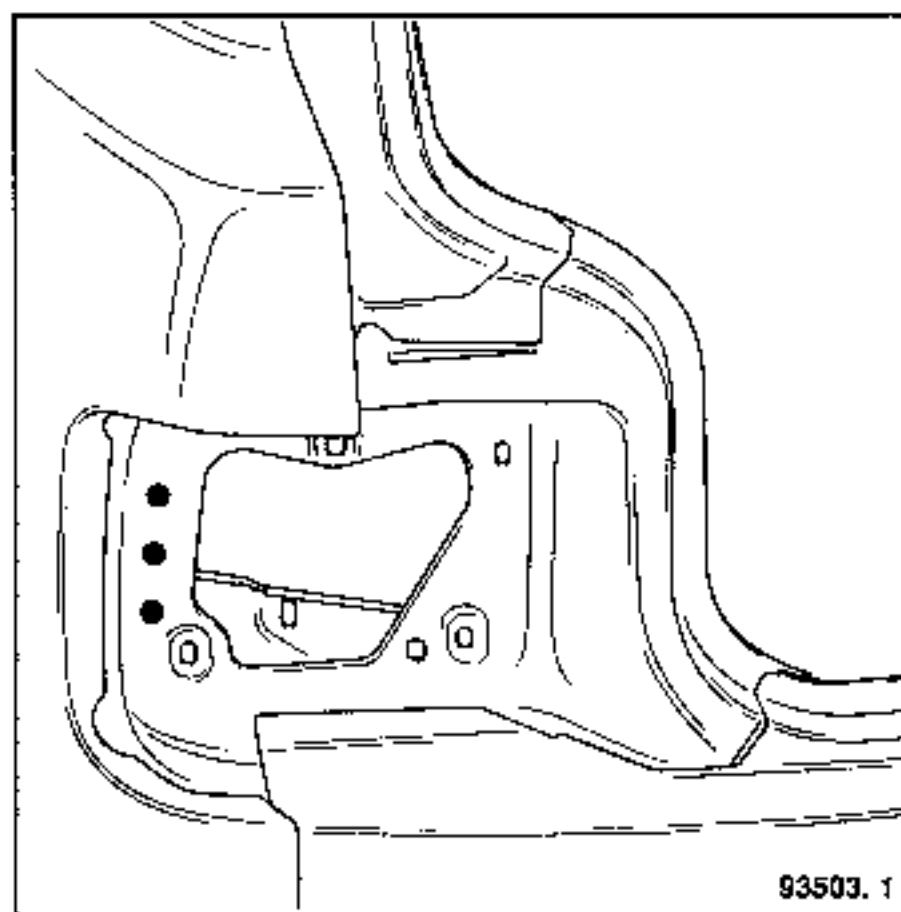
Light unit carrier panel 0.87

Unpicking



3 electric spot welds

Welding



**3** CONNECTION WITH LOWER FAR REAR  
PILLAR LINING

Panel thickness (mm)

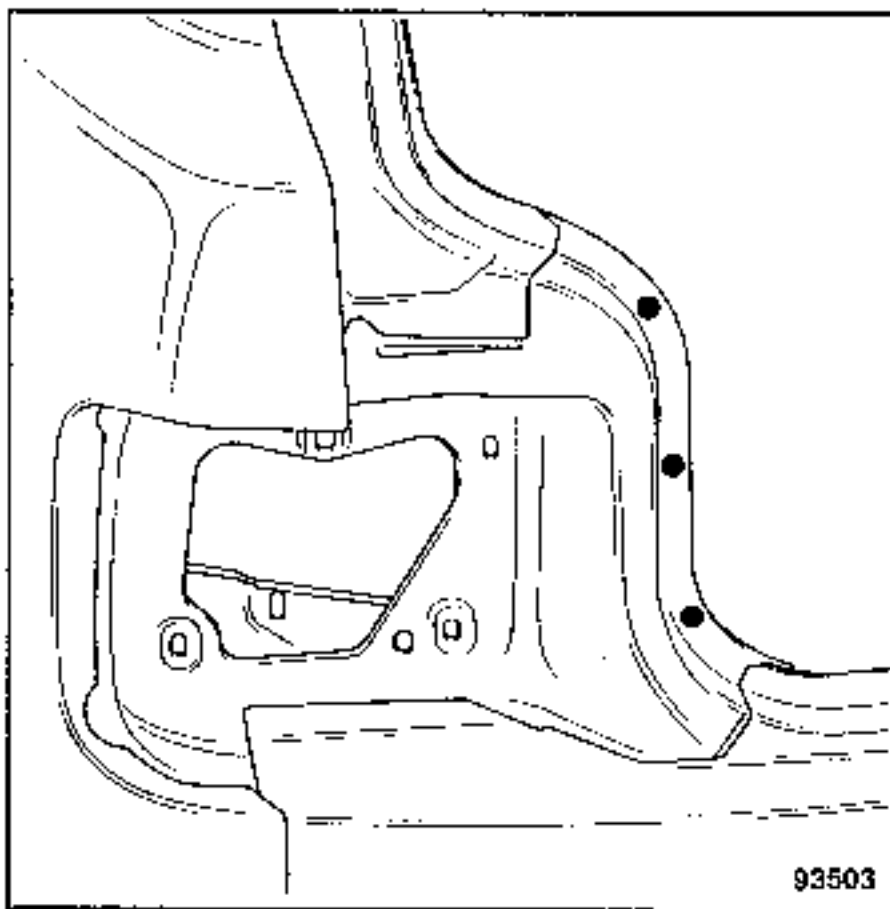
Light unit carrier panel	0.87
Far rear pillar lining	0.77

Unpicking



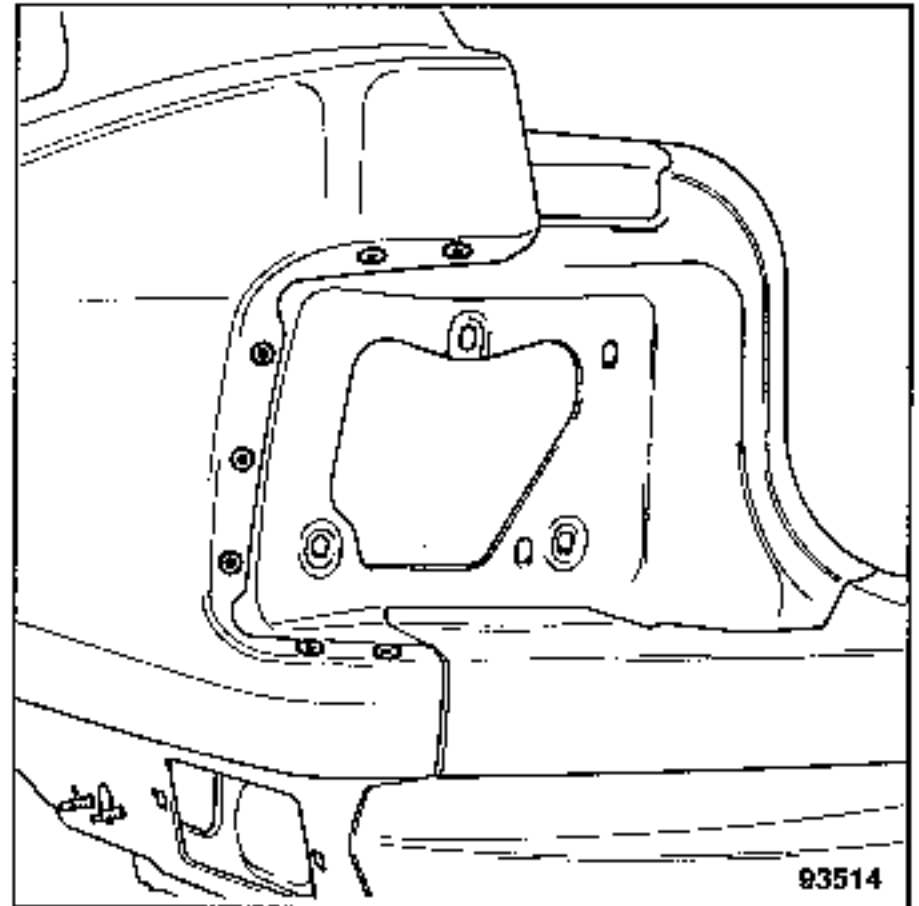
3 electric spot welds

Welding



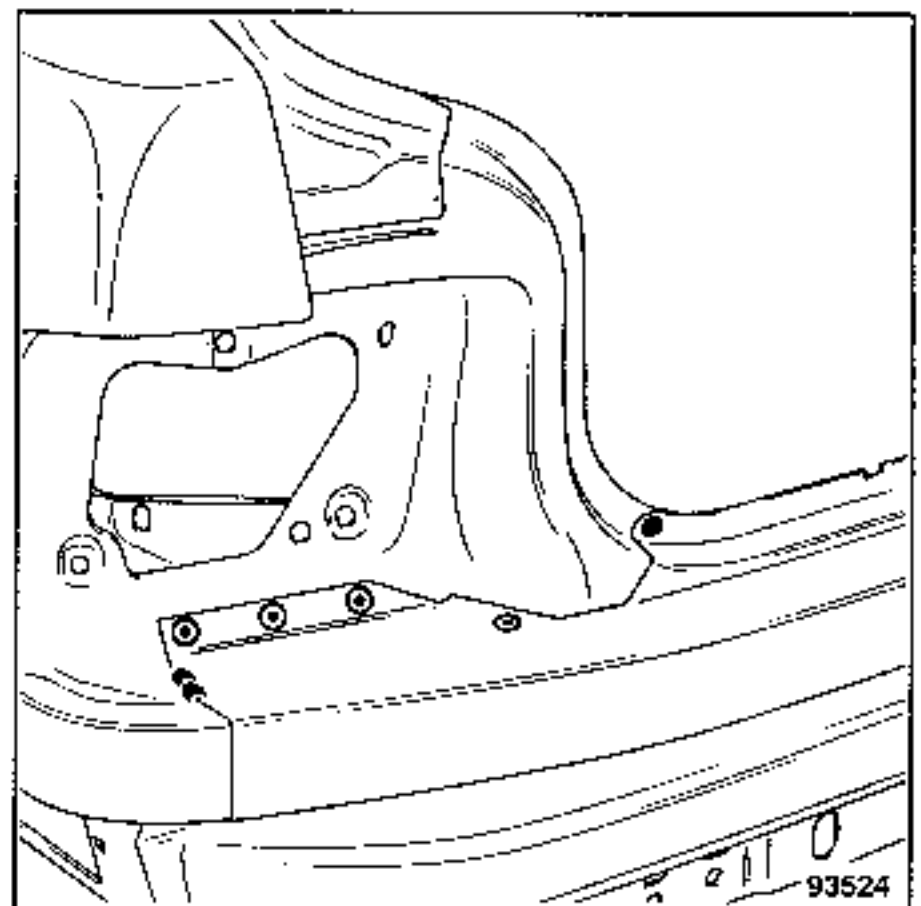
**4** CONNECTION WITH WING PANEL

Remember: See 44-A-5



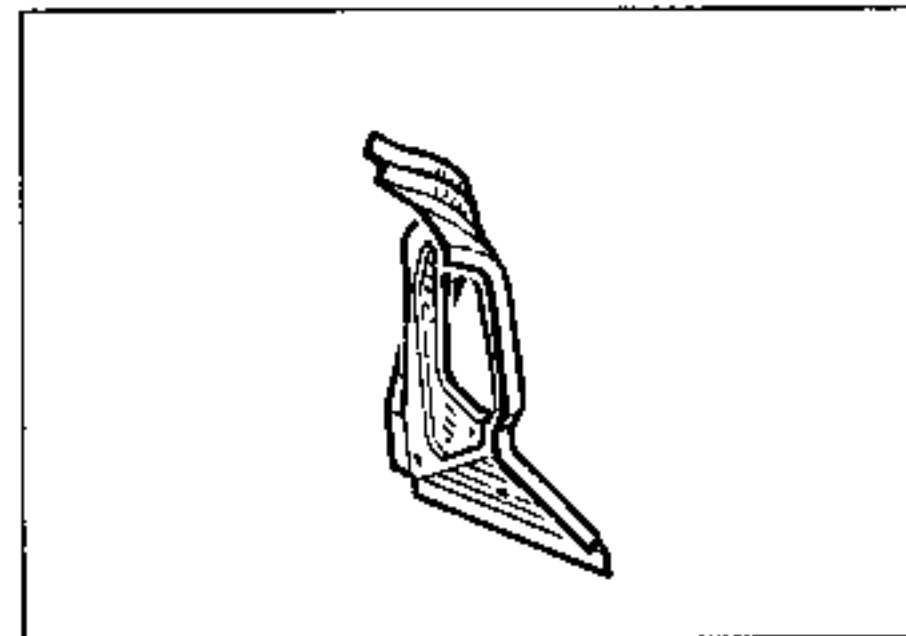
**5** CONNECTION WITH REAR END PANEL

Remember: See 41-A-1



COMPOSITION OF PARTS AS SUPPLIED BY THE  
PARTS DEPARTMENT.

Single part.



# 1 CONNECTION WITH REAR QUARTER PANEL LINING

Panel thickness (mm)

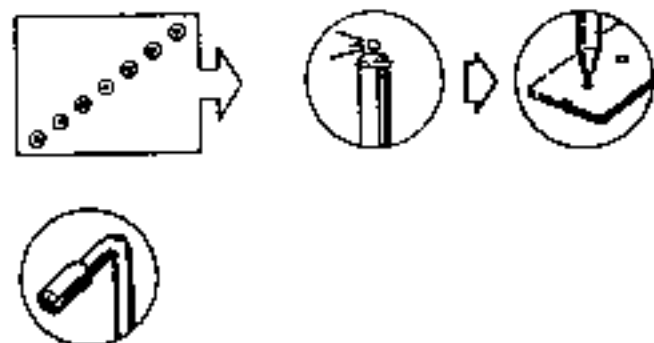
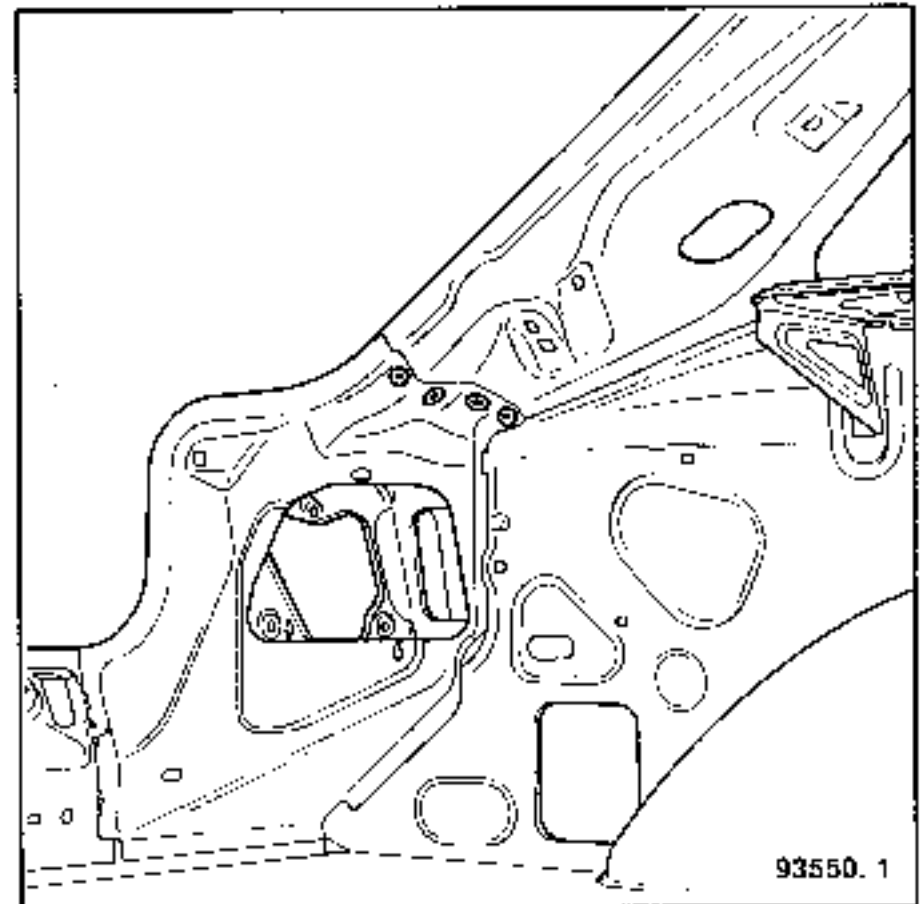
Lower far rear pillar lining 0.77  
Upper far rear pillar lining 0.77

Unpicking



4 electric spot welds

Welding



# 2 CONNECTION WITH OUTER WHEEL ARCH

Panel thickness (mm)

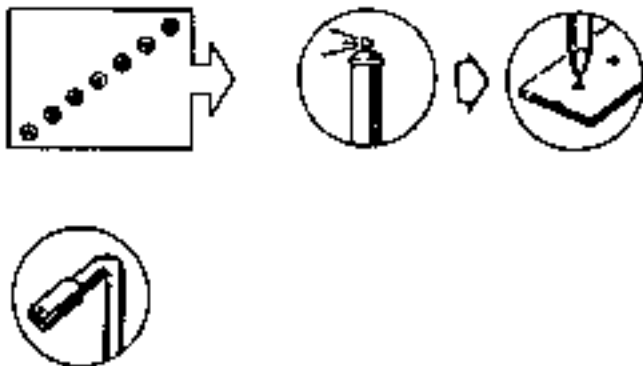
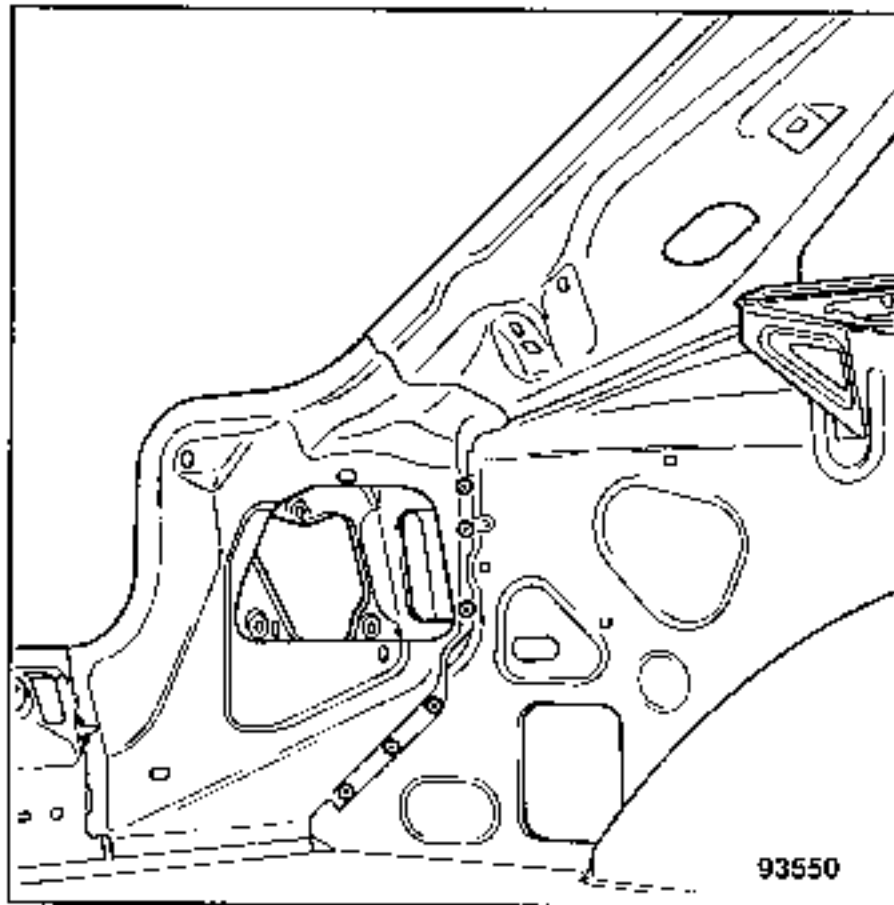
Lower far rear pillar lining 0.  
Outer wheel arch 0.

Unpicking



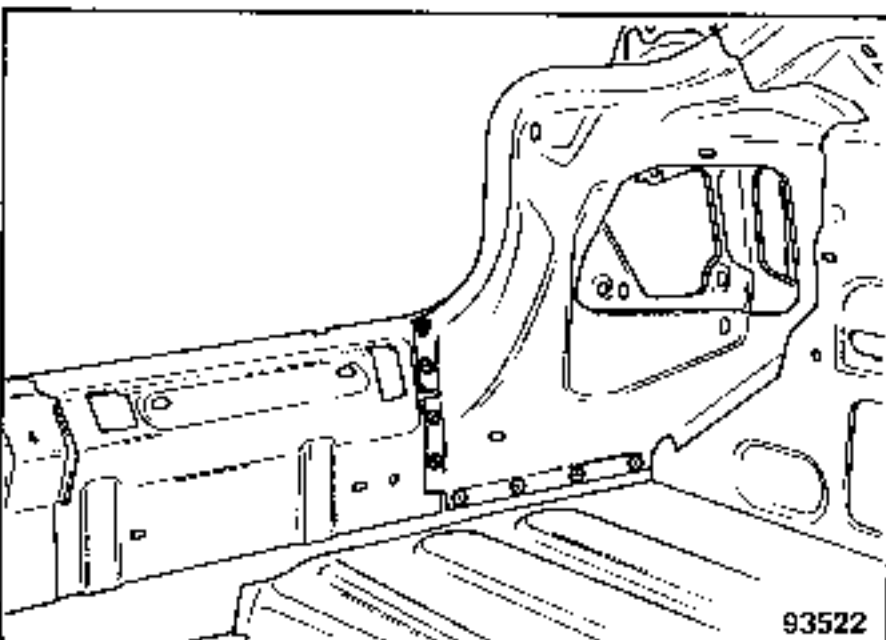
6 electric spot welds

Welding



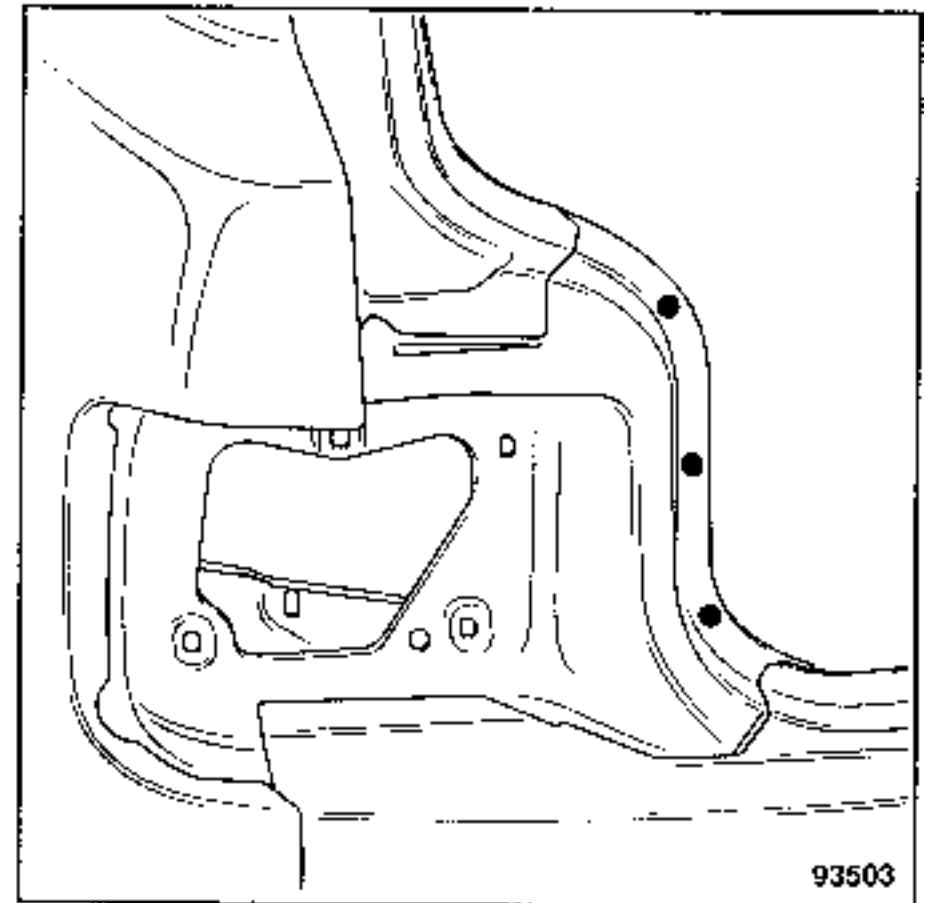
**3** CONNECTION WITH REAR END PANEL ASSEMBLY

Remember: See 41-A-3



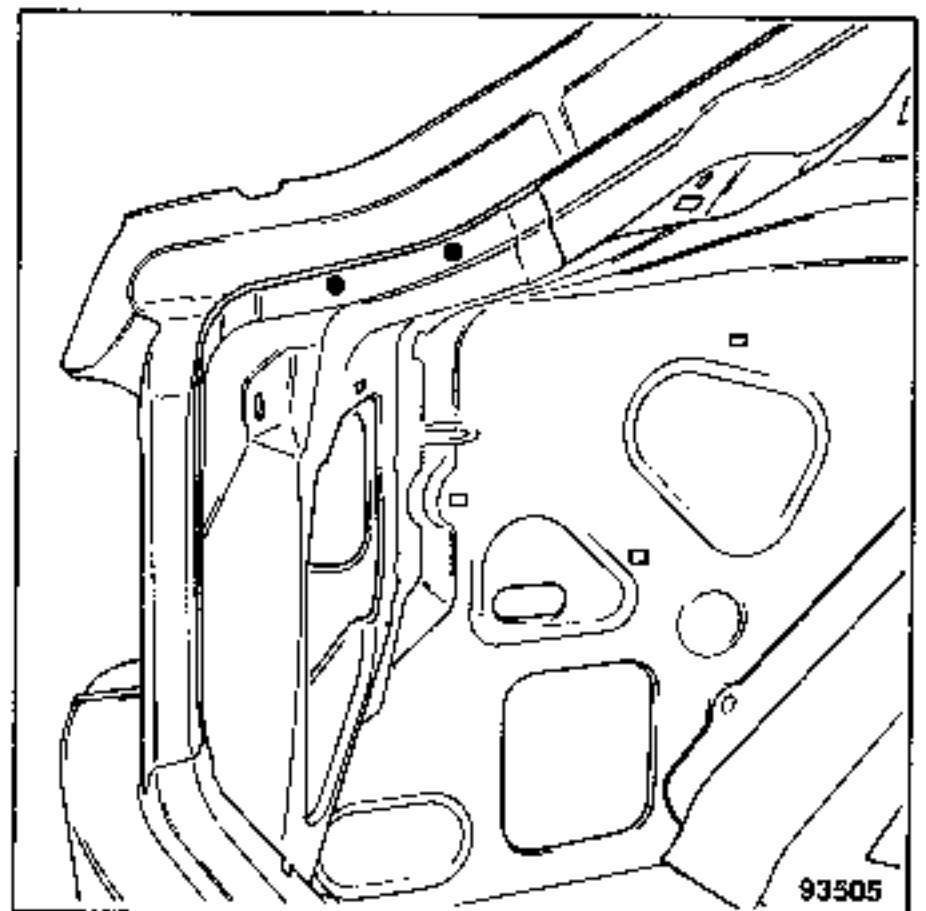
**4** CONNECTION WITH LIGHT UNIT CARRIER PANEL

Remember: See 44-D-3



**5** CONNECTION WITH SIDE RAIN CHANNEL

Remember: See 44-C-2



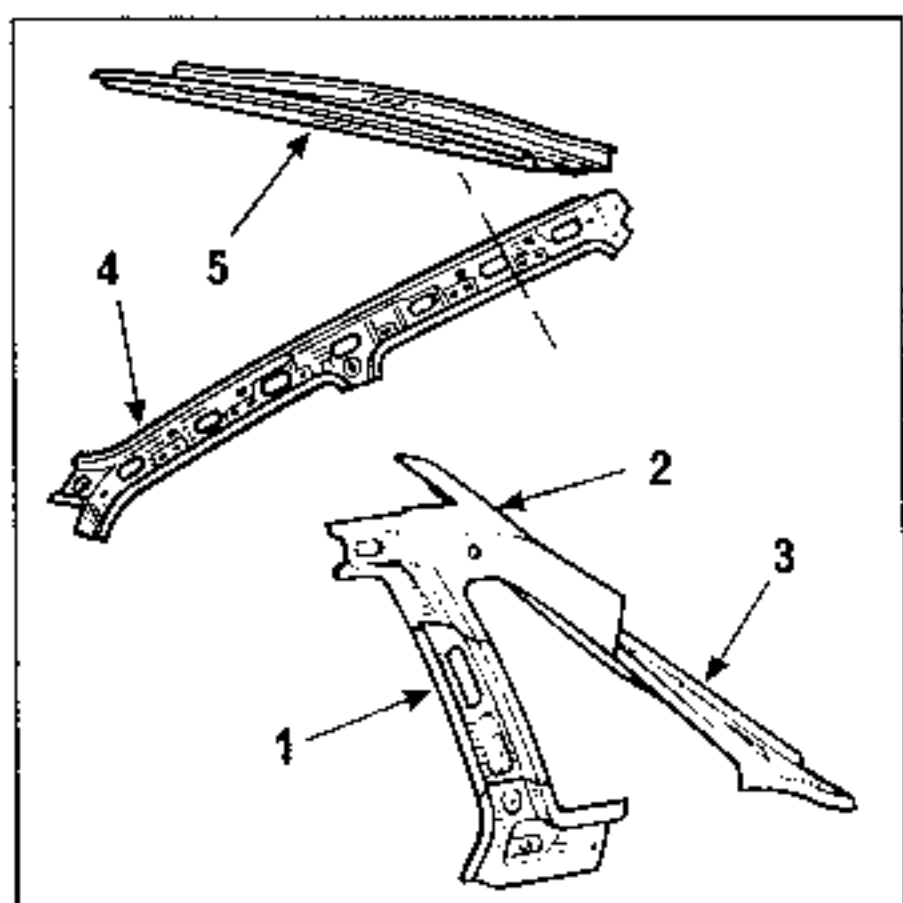
COMPOSITION OF PARTS AS SUPPLIED BY THE PARTS DEPARTMENT.

Assembled part comprising:

- 1. Rear quarter panel lining
- 2. Upper strengthener
- 3. Upper far rear pillar lining

Parts to be ordered in addition for this operation:

- 4. Stretcher lining
- 5. Roof rear cross-member



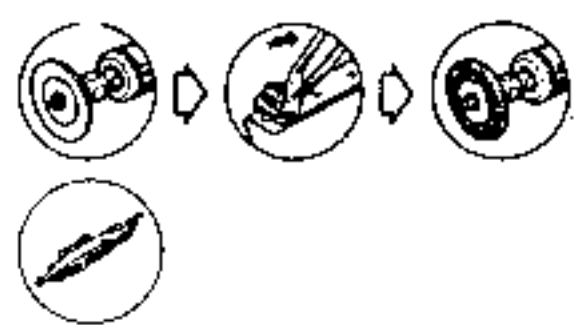
**1 CONNECTION WITH BODY TOP**

Panel thickness (mm)	
Rear quarter panel lining	0.67
Stretcher lining	0.67
Upper strengthener	0.97
Body side	0.77

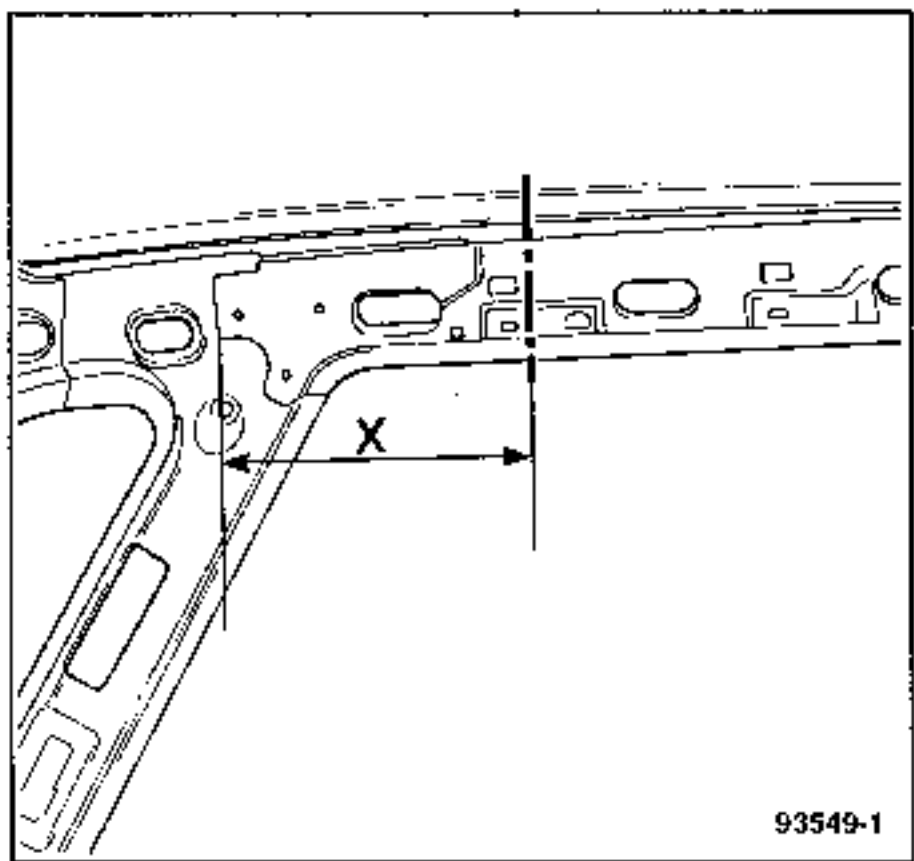
Unpicking



10 electric spot welds

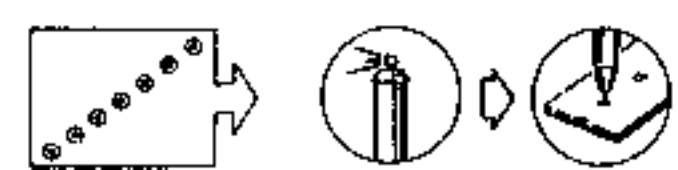
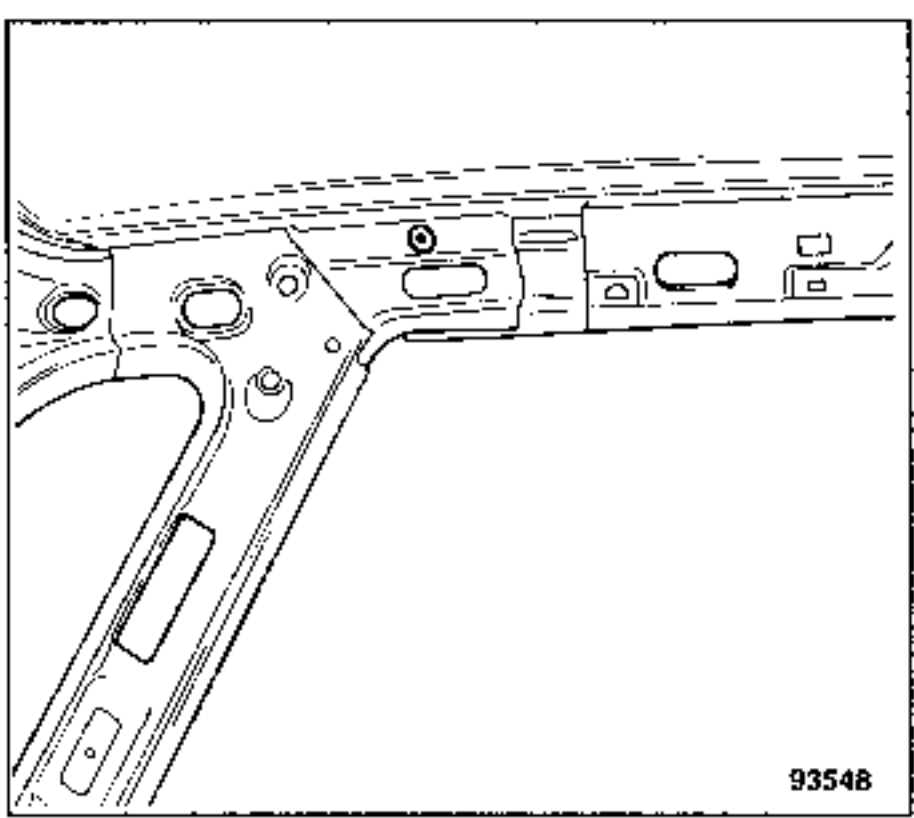


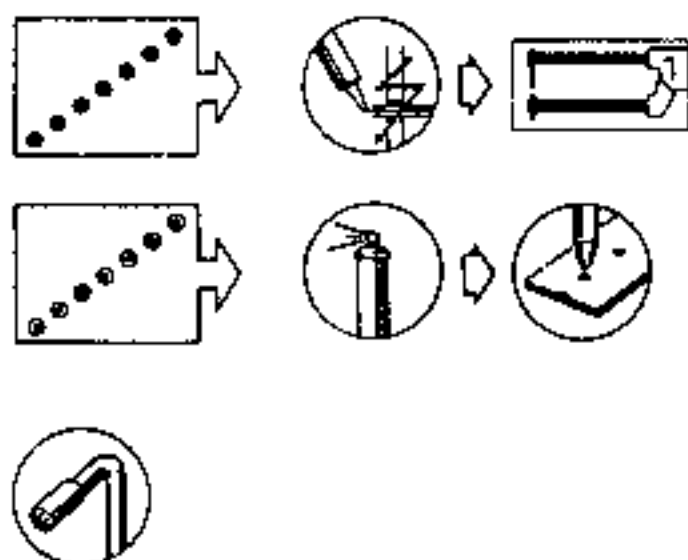
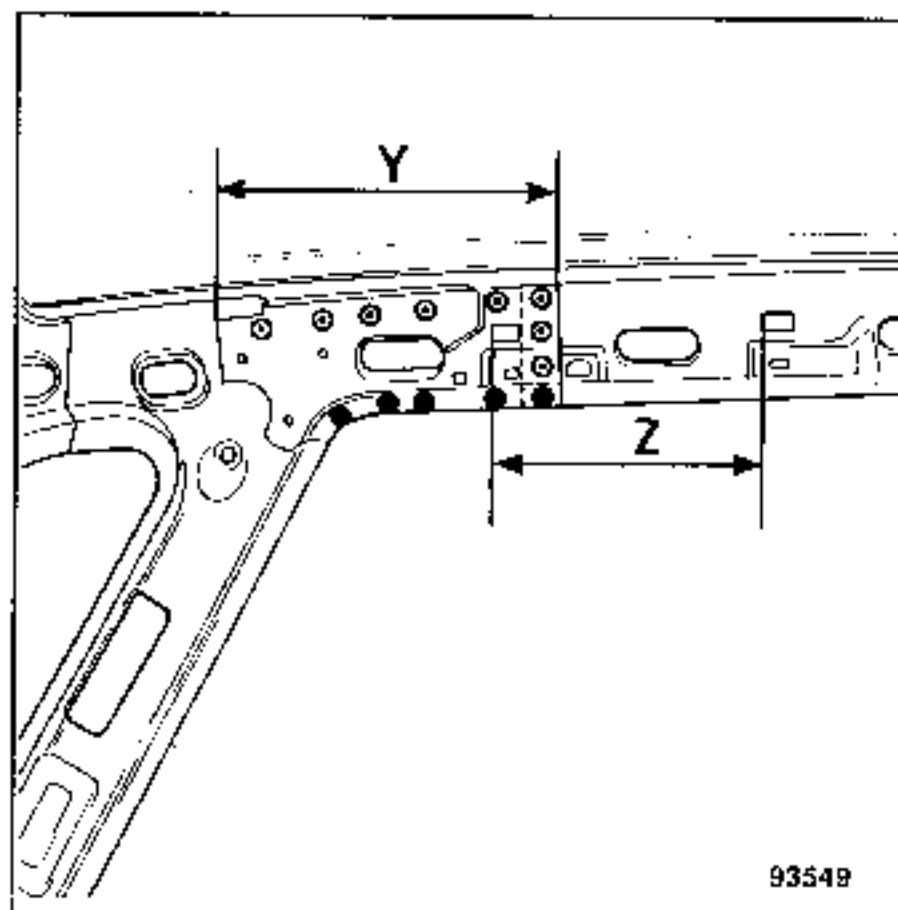
Special point concerning removal



Part of the stretcher lining must be removed in order to reach the welding point for the upper strengthener  
 $x = 200 \text{ mm}$

Welding





On the diagram above the dotted line represents the cut to be made on the vehicle during the unpicking operation. Dimension Y indicates the cut to be made on the new part. Dimension Z is to be used for positioning the new part.  
y = 220 mm    z = 170 mm

## 2 CONNECTION WITH ROOF REAR CROSS-MEMBER

Panel thickness (mm)

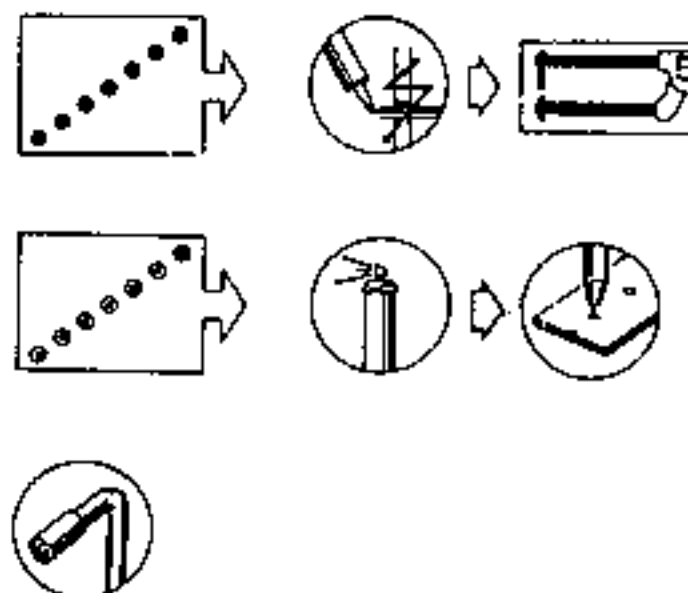
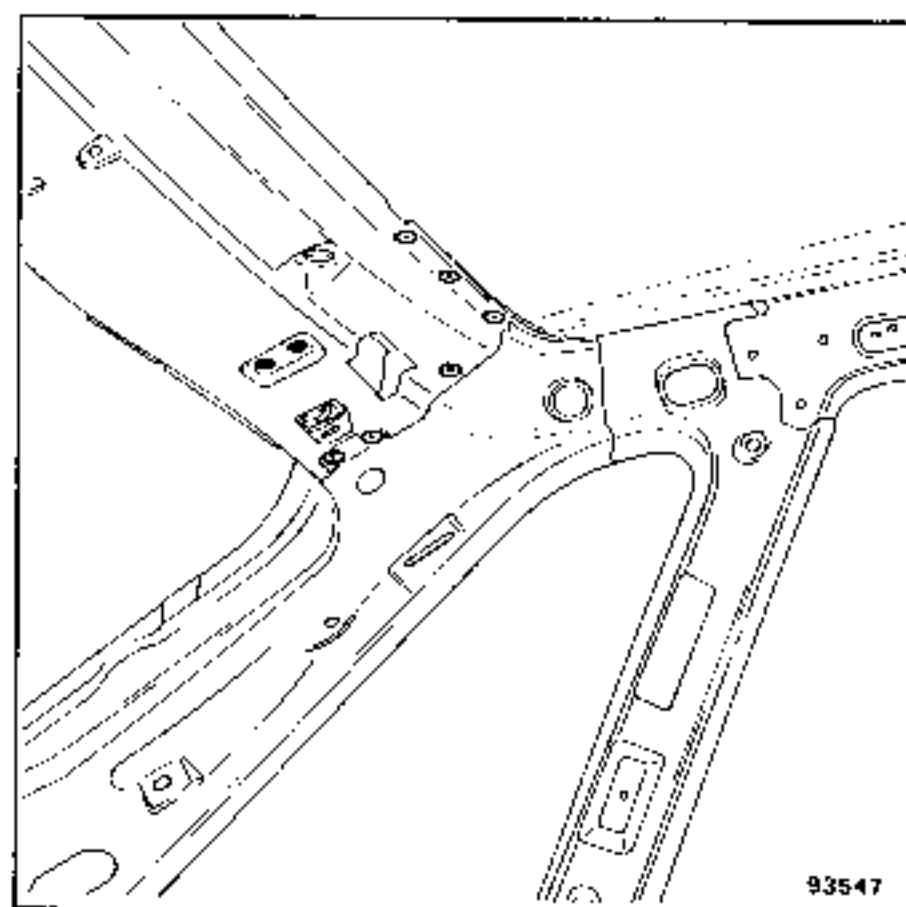
Upper far rear pillar lining	0.77
Roof rear cross-member	0.67
Upper strengthener	0.97
Roof	0.77
Rain channel upper gusset	1.50

## Unpicking



8 electric spot welds

## Welding

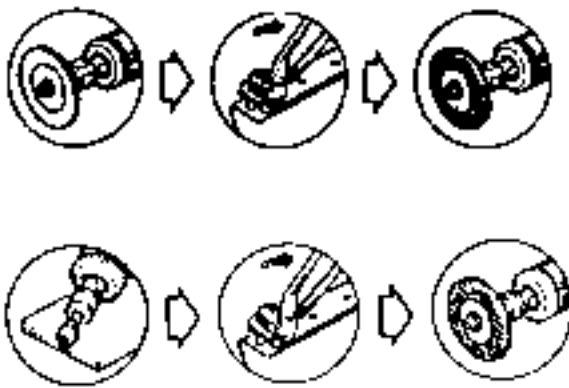


**3** CONNECTION WITH OUTER WHEEL ARCH

Panel thickness (mm)

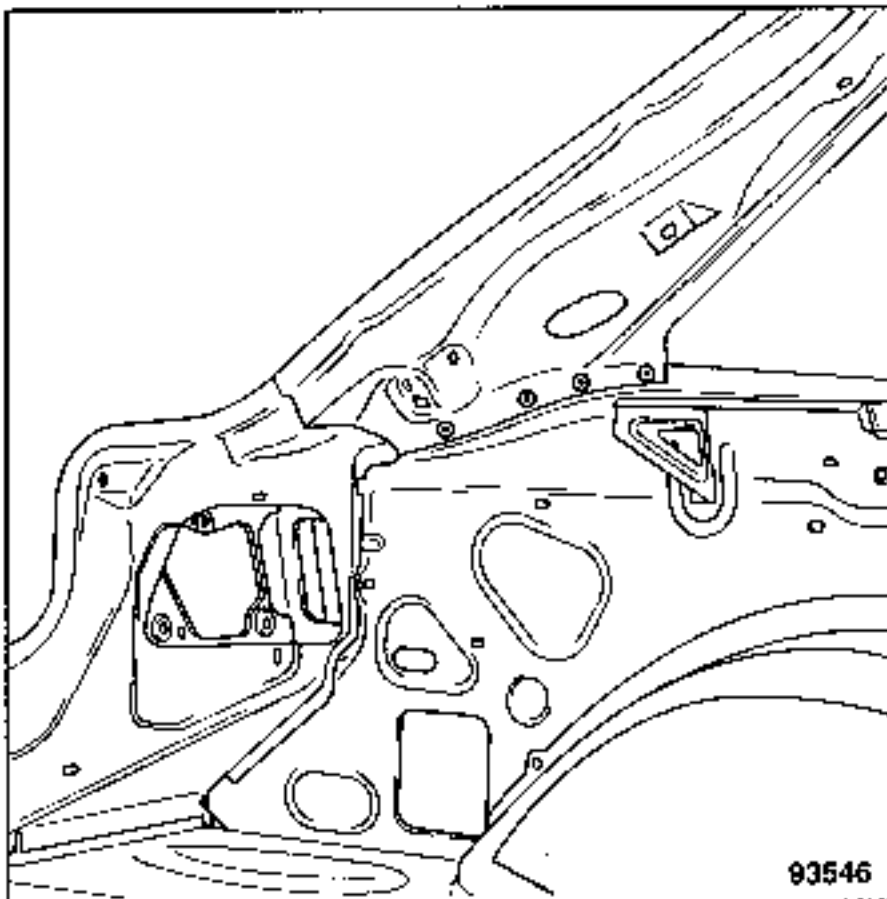
Rear quarter panel lining	0.67
Lower far rear pillar lining	0.77
Outer wheel arch	0.67
Seat mounting strengthener	1.50

Unpicking

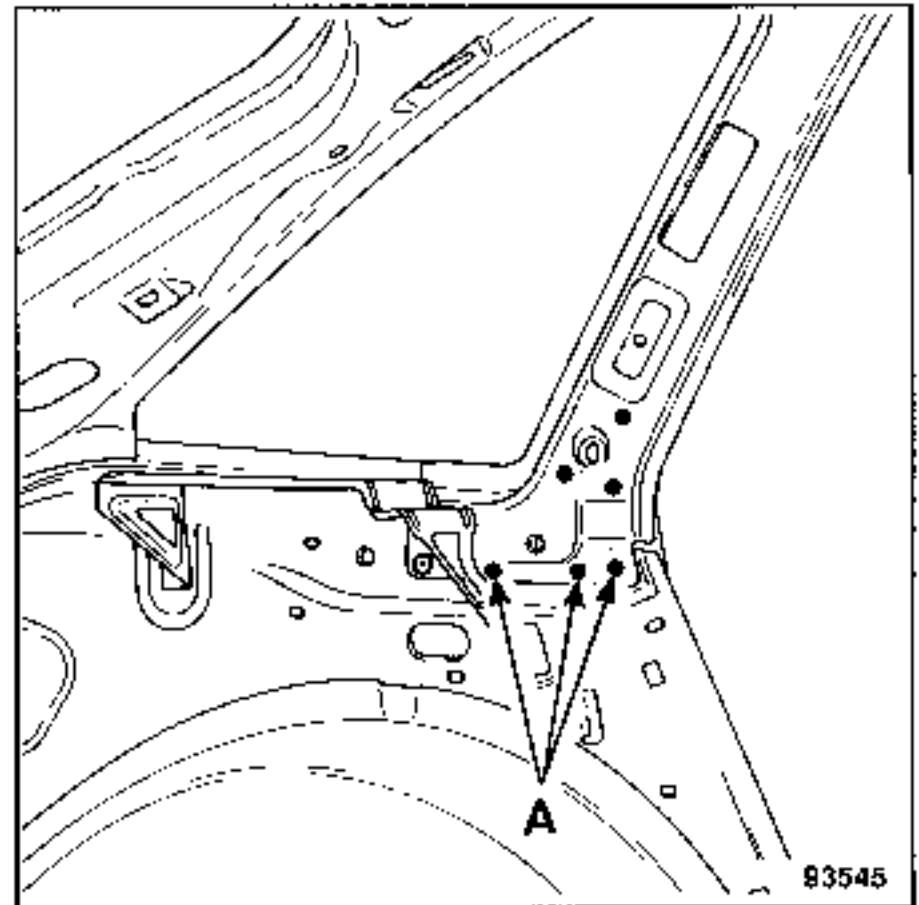


11 electric spot welds

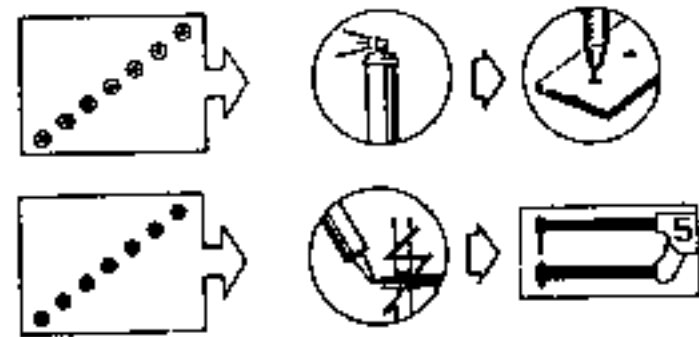
Welding



93546



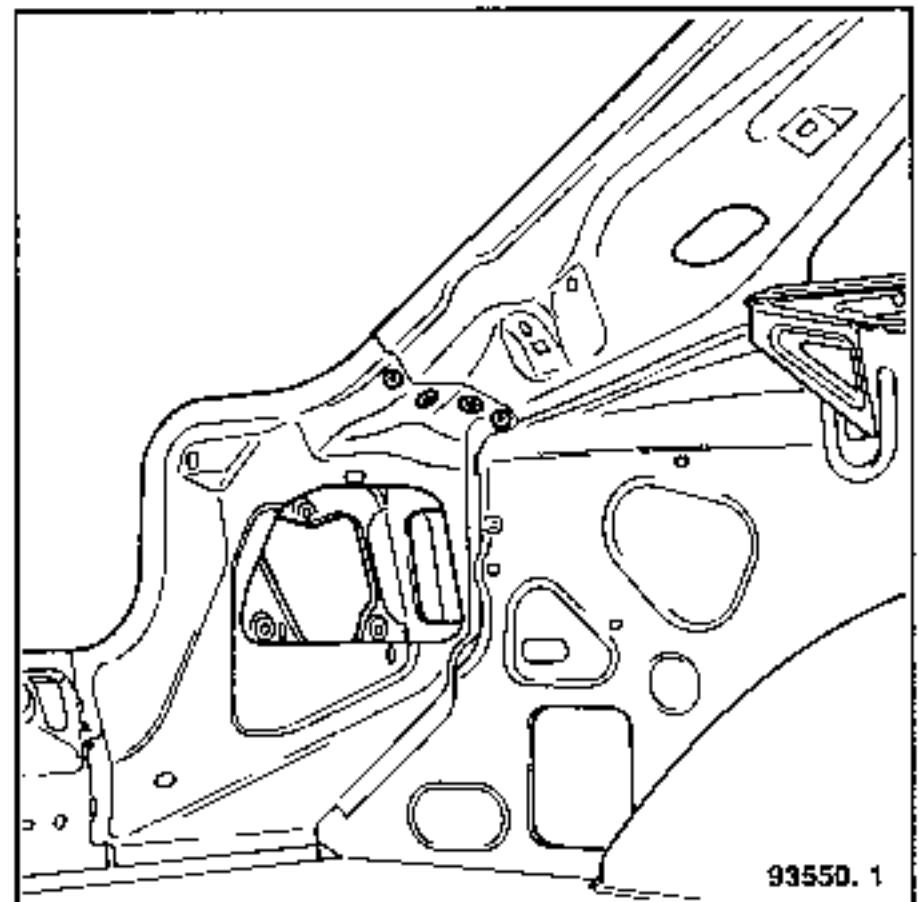
93545



(A) 3 welds through 3 thicknesses

**4** CONNECTION WITH LOWER FAR REAR PILLAR LINING

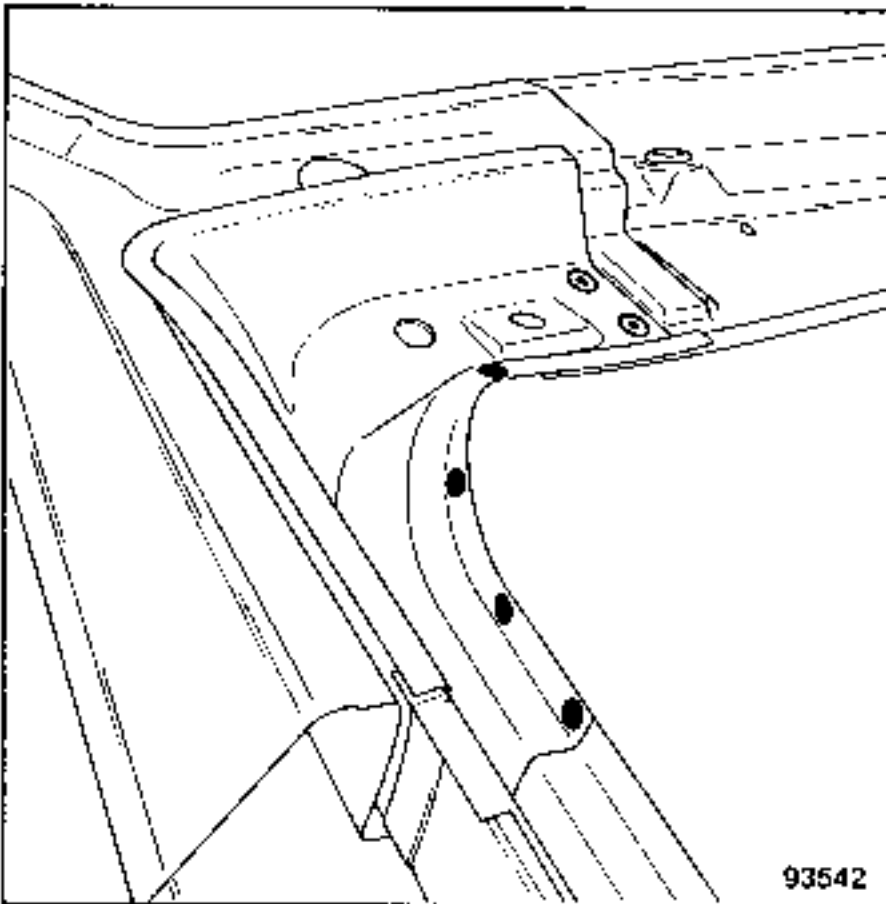
Remember: See 44-E-1



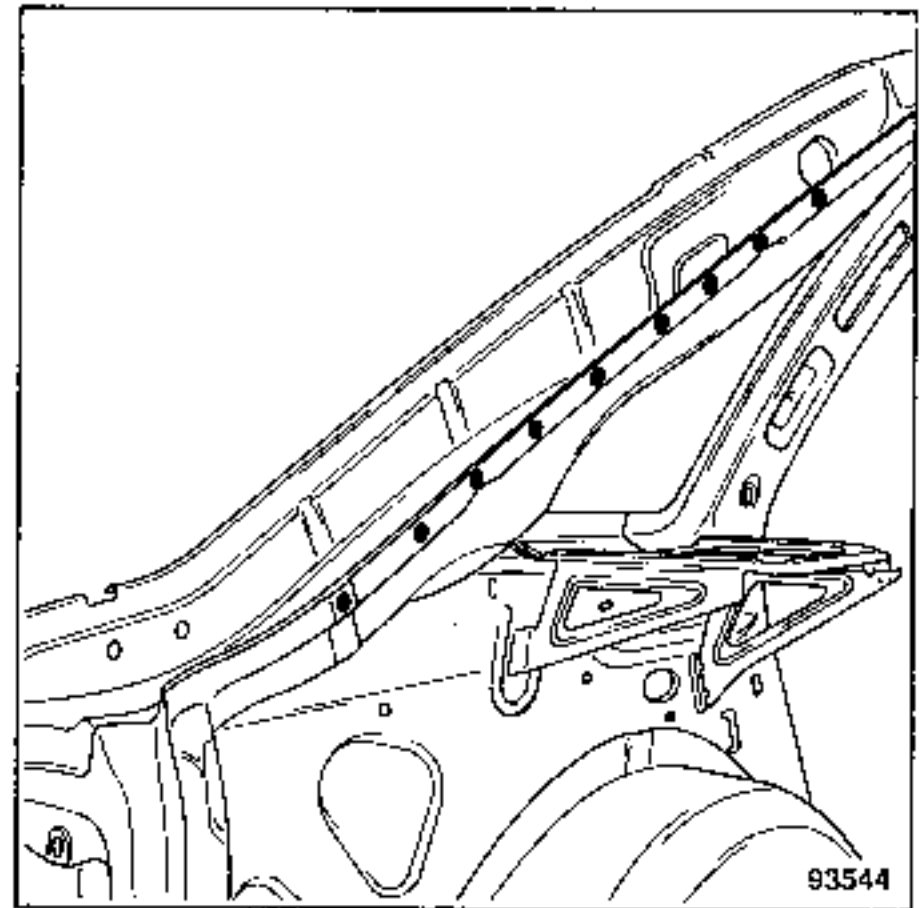
93550.1

**5** CONNECTION WITH RAIN CHANNEL. UPPER GUSSET

Remember: See 44-G-1



Welding



(A) 1 weld through 3 thicknesses

**6** CONNECTION WITH SIDE RAIN CHANNEL

Panel thickness (mm)

Upper far rear pillar lining	0.77
Lower far rear pillar lining	0.77
Side rain channel	0.67

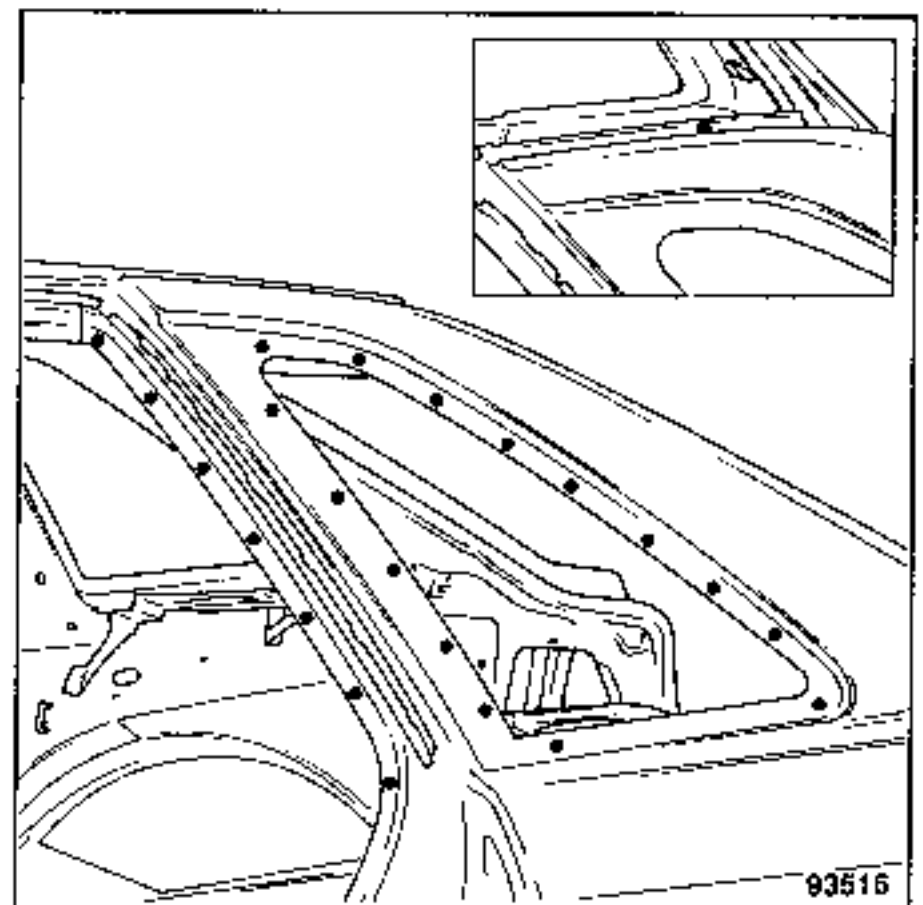
Unpicking



<sup>9</sup> electric spot welds

**7** CONNECTION WITH WING PANEL

Remember: See 44-A-3





# 8 CONNECTION WITH ROOF

Panel thickness (mm)

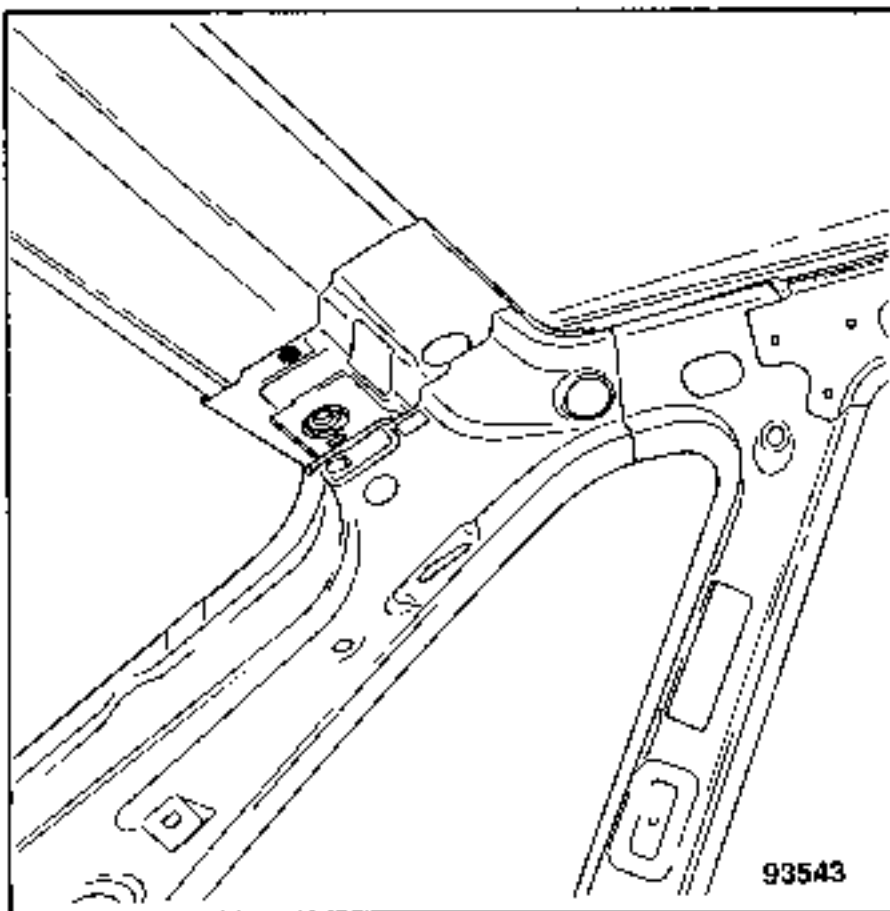
Upper strengthener	0.97
Roof panel	0.77

Unpicking

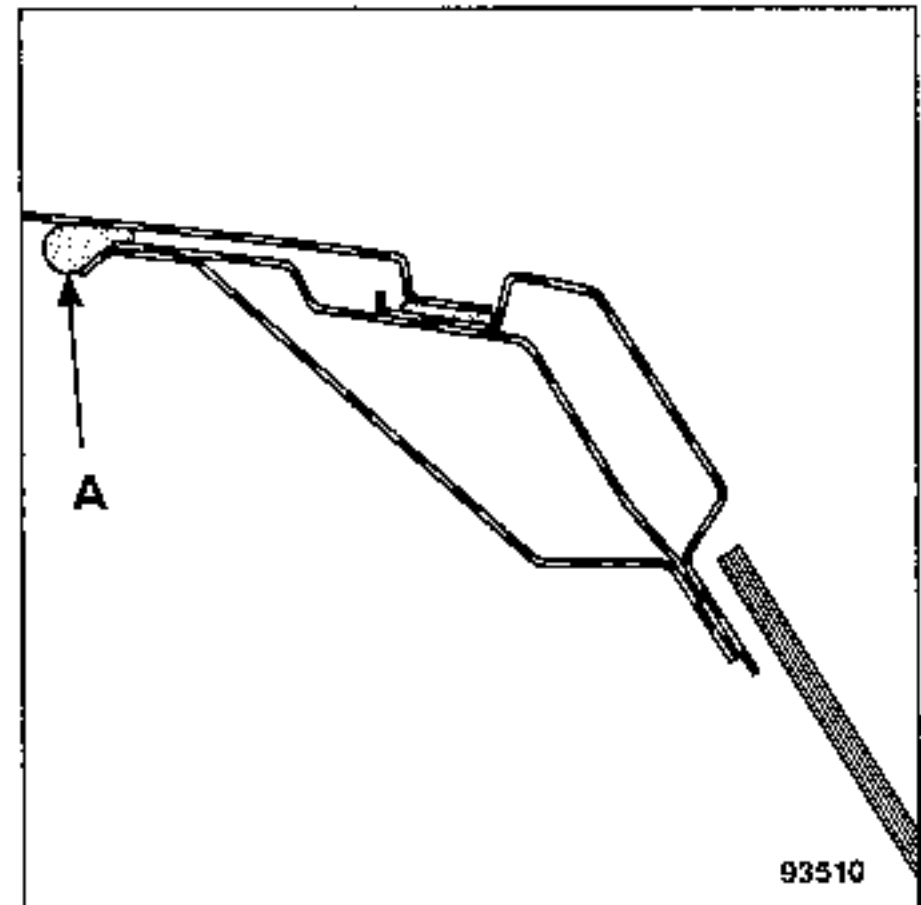
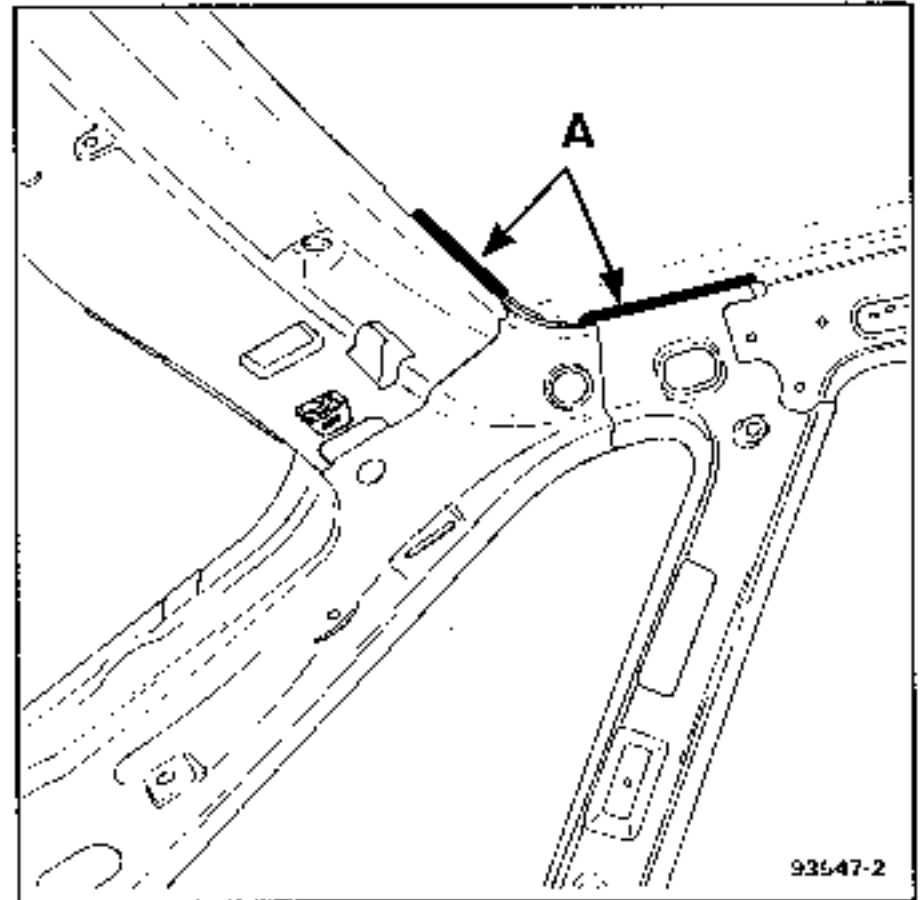


<sup>1</sup> electric spot weld

Welding



Bonding

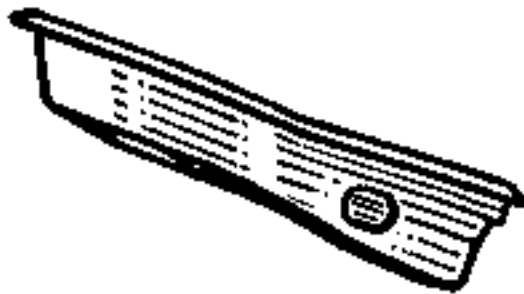


(A)



COMPOSITION OF PARTS AS SUPPLIED BY  
THE PARTS DEPARTMENT.

Single part.



# 1 CONNECTION WITH REAR QUARTER PANEL LINING

Panel thickness (mm)

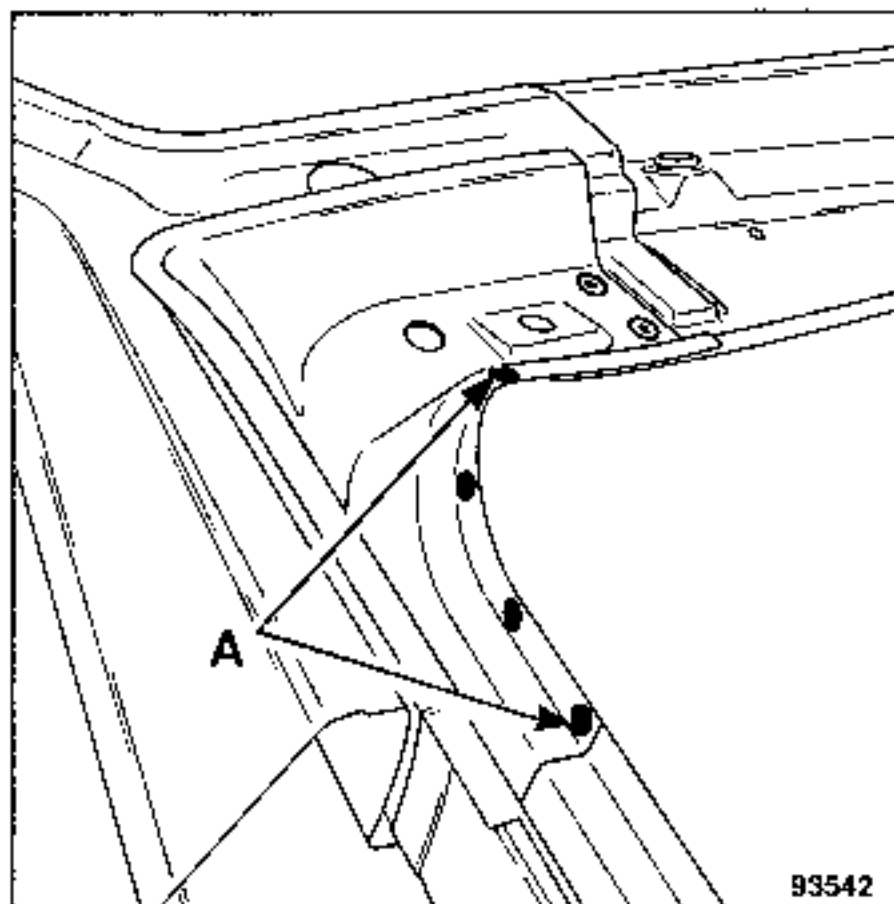
Rain channel upper gusset	1.50
Upper far rear pillar lining	0.77
Upper strengthener	0.97
Side rain channel	0.67

Unpicking

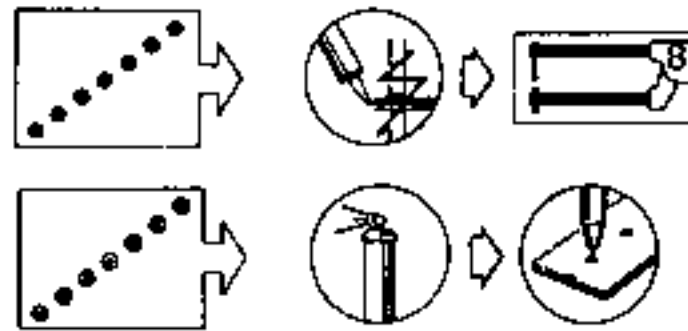


6 electric spot welds

Welding



93542



(A) 2 welds through 3 thicknesses

## 2 CONNECTION WITH SIDE RAIN CHANNEL

Panel thickness (mm)

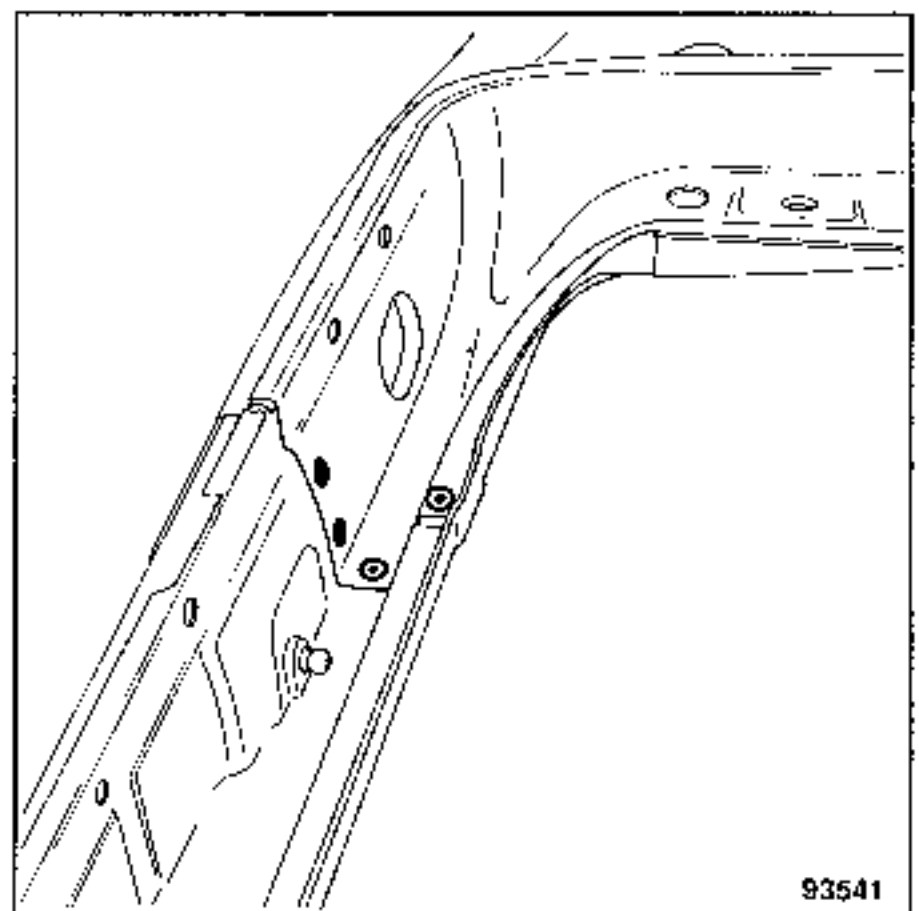
Rain channel upper gusset	1.50
Side rain channel	0.67

Unpicking

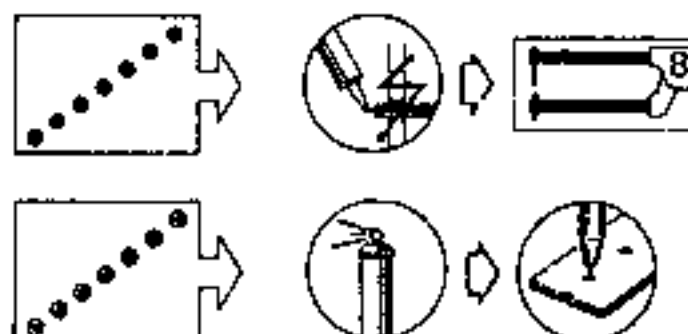


4 electric spot welds

Welding

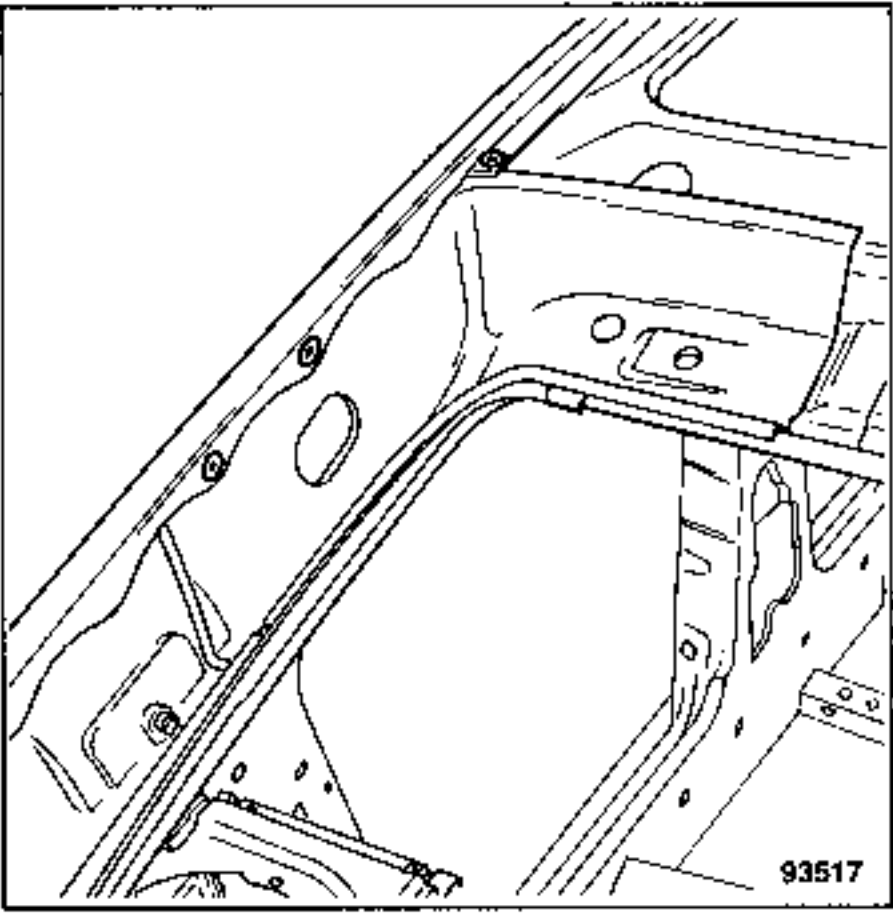


93541



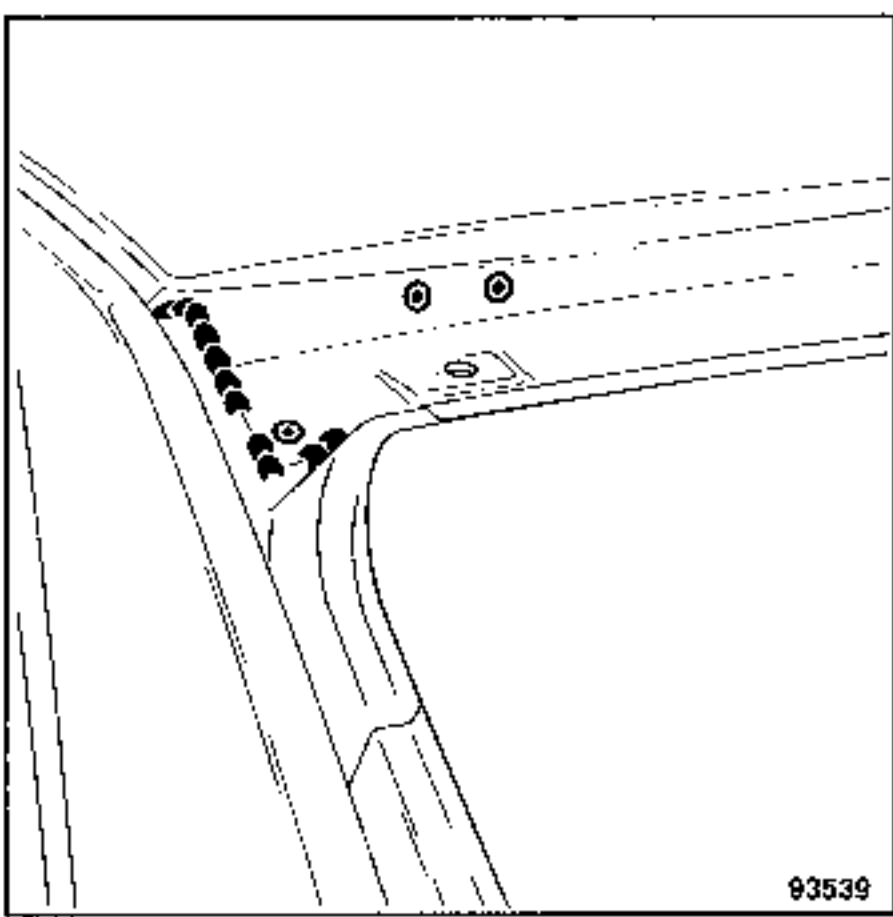
**3** CONNECTION WITH WING PANEL.

Remember: See 44-A-2



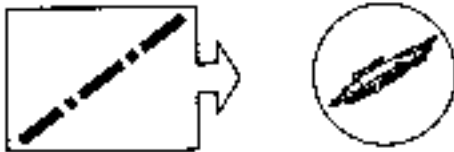
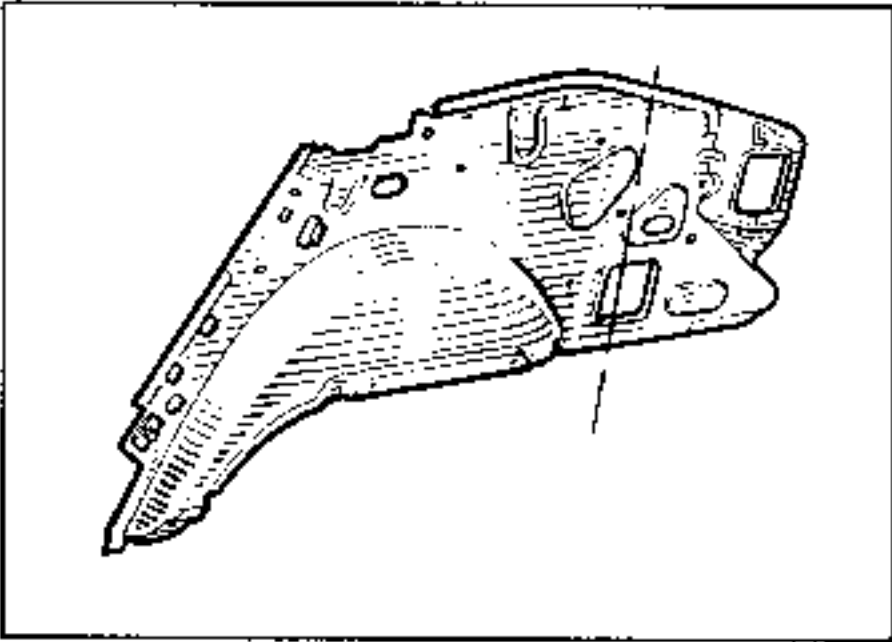
**4** CONNECTION WITH ROOF

Remember: See 45-A-2

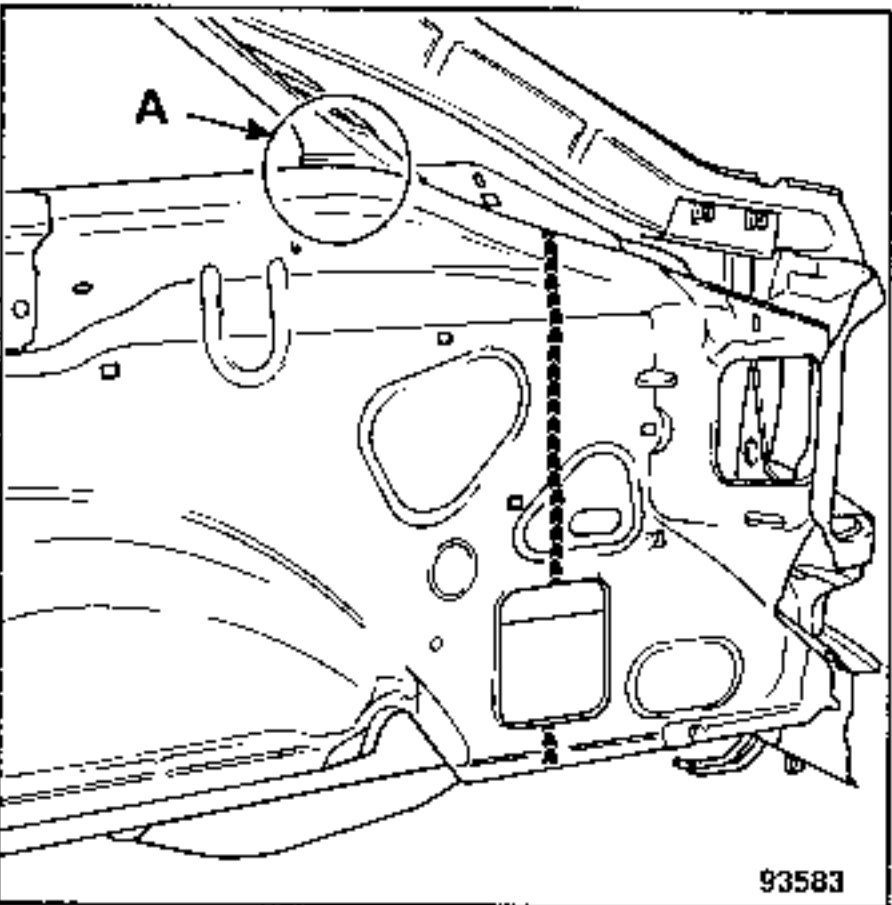


COMPOSITION OF PARTS AS SUPPLIED  
BY THE PARTS DEPARTMENT.

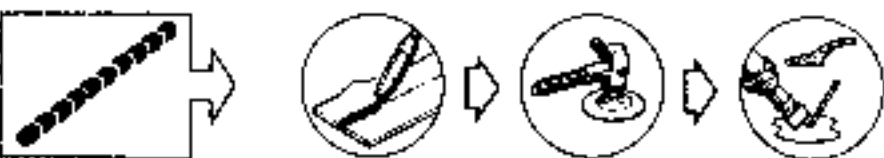
Single part.



**1** CUTTING



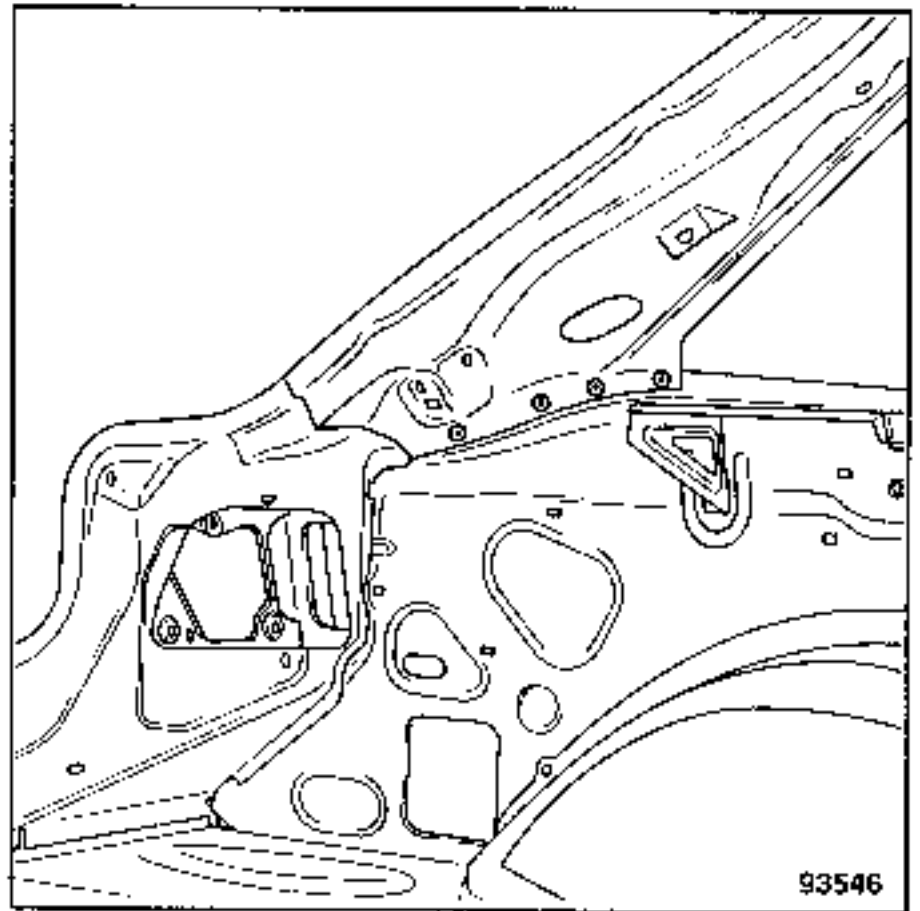
93583



This cut is an example. The exact location is to be determined according to the impact. The important factor is to retain a connection (A) between the outer wheel arch and the upper far rear pillar lining, after the part to be replaced has been cut out.

**2** CONNECTION WITH REAR QUARTER PANEL LINING

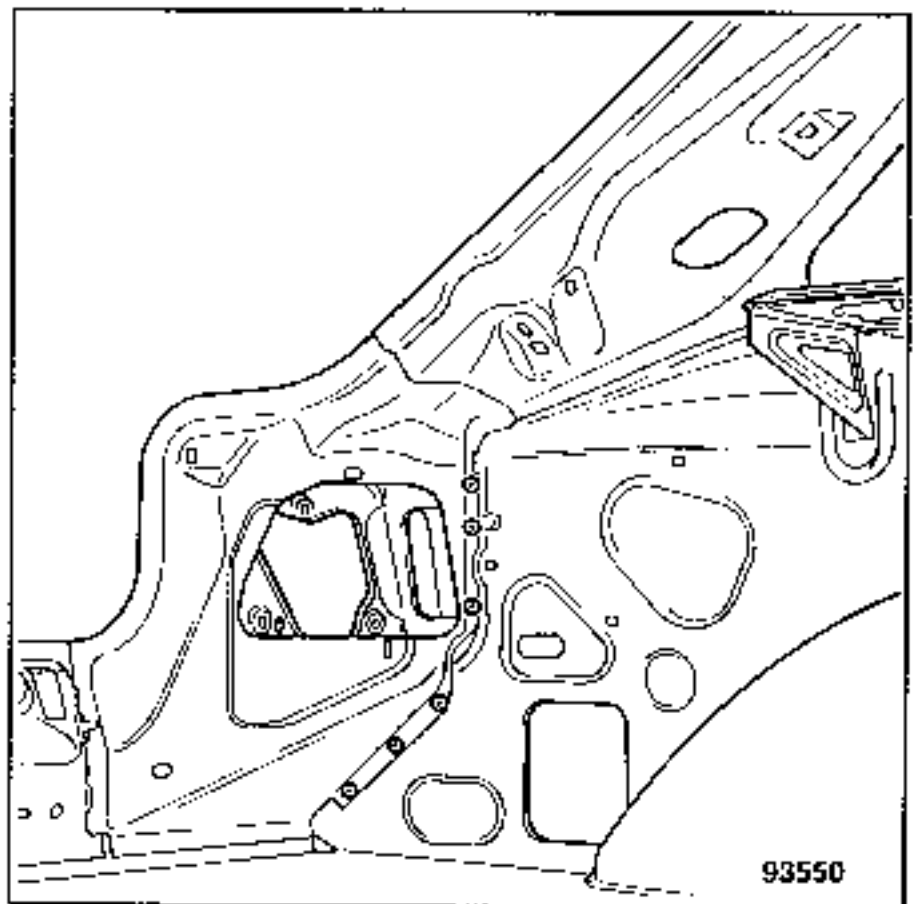
Remember: See 44-F-3



93546

**3** CONNECTION WITH LOWER FAR REAR PILLAR LINING

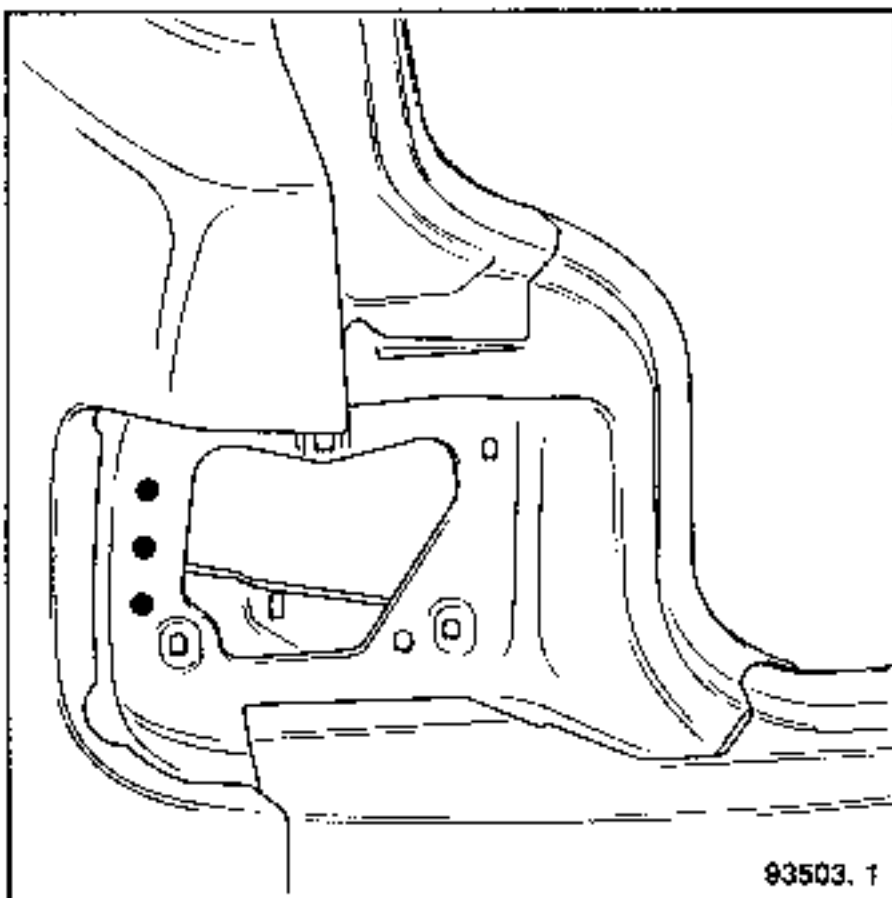
Remember: See 44-E-2



93550

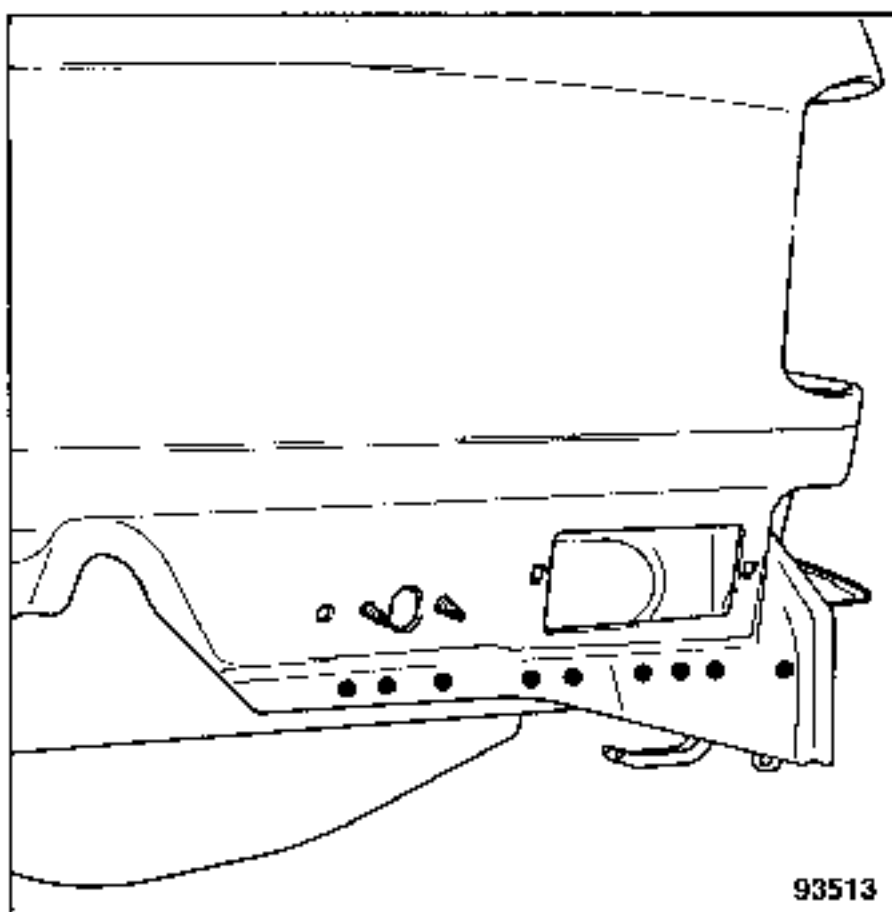
**4** CONNECTION WITH LIGHT UNIT  
CARRIER PANEL

Remember: See 44-D-2



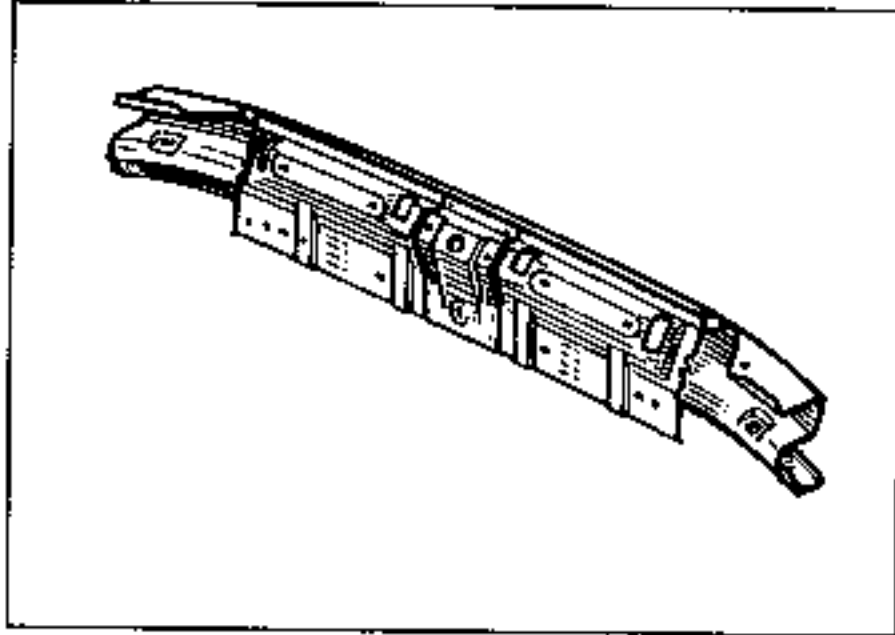
**5** CONNECTION WITH REAR SECTION  
OF REAR FLOOR PANEL

Remember: See 44-A-8



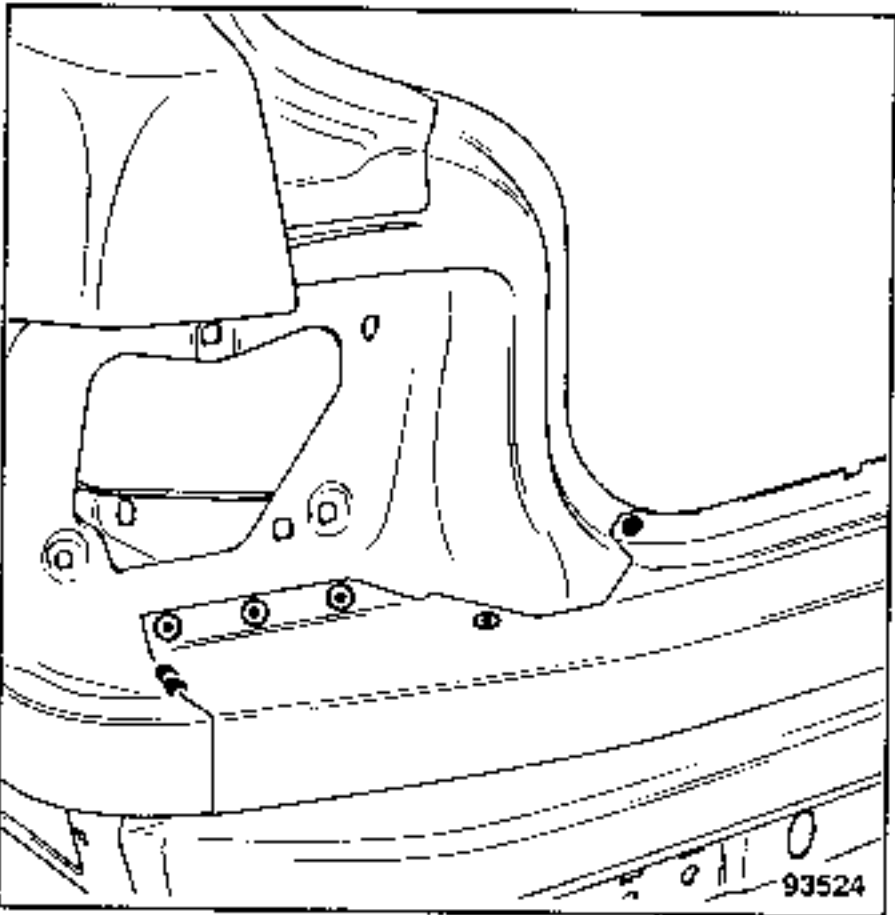
COMPOSITION OF PARTS AS SUPPLIED BY THE  
PARTS DEPARTMENT.

Rear end panel  
Rear end panel lining  
Striker plate strengthener



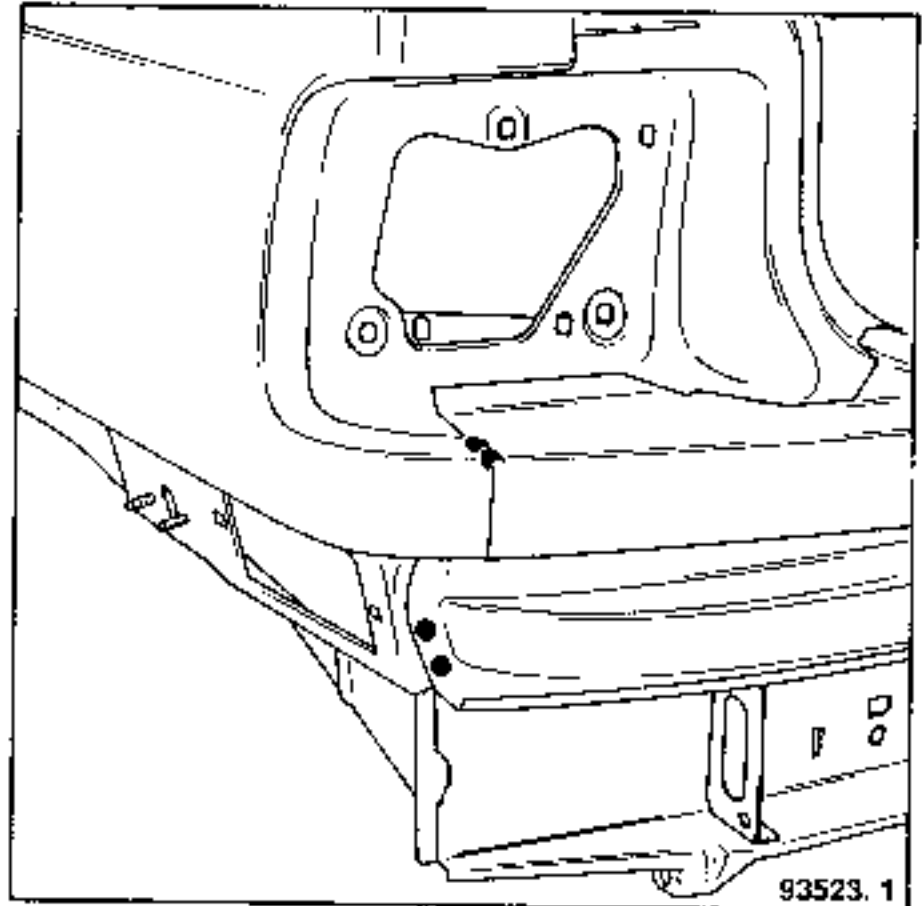
**1** CONNECTION WITH LIGHT UNIT CARRIER  
PANEL

Remember: See 41-A-1



**2** CONNECTION WITH WING PANEL

Remember: See 44-A-6

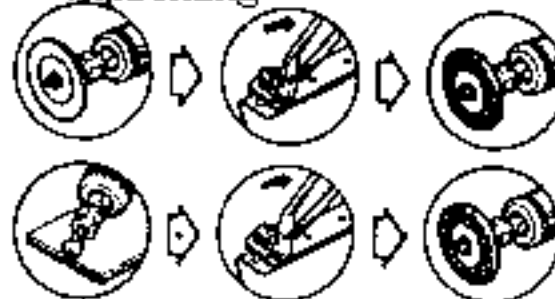


**3** CONNECTION WITH LOWER FAR REAR PILLAR  
LINING

Panel thickness (mm)

Rear end panel	0.67
Rear end panel lining	0.67
Lower far rear pillar lining	0.77

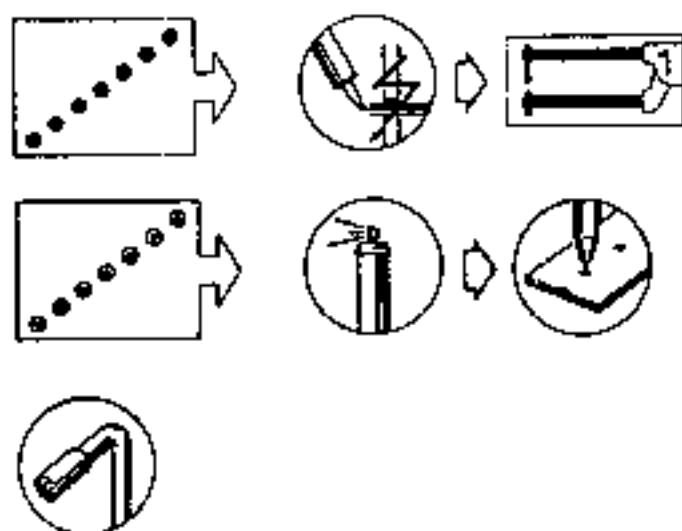
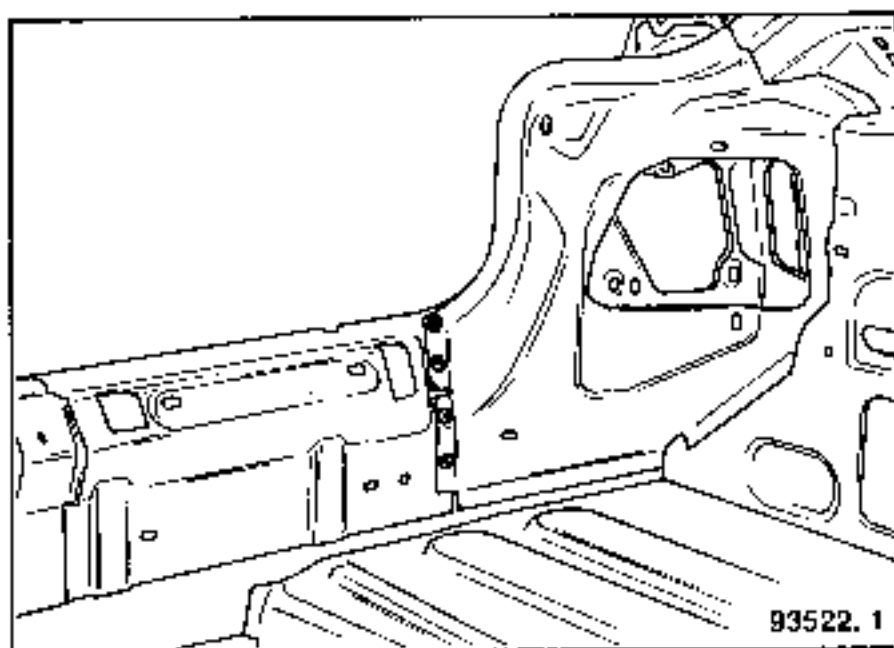
Unpicking



(A) See "welding"

4 + 4 electric spot welds

# Welding



(B) 1 weld through 3 thicknesses

## 4 CONNECTION WITH LOWER CROSS-MEMBER

Panel thickness(mm)

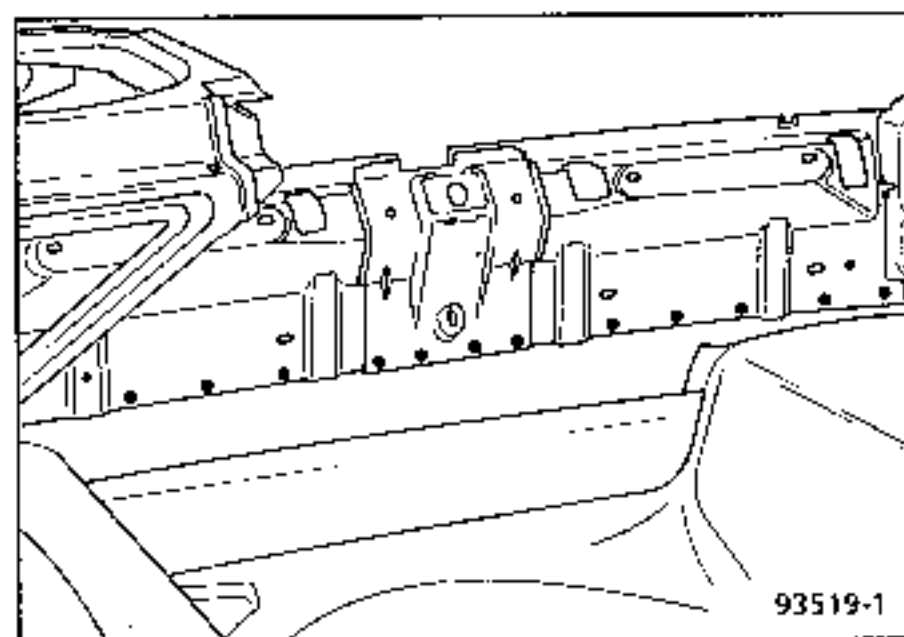
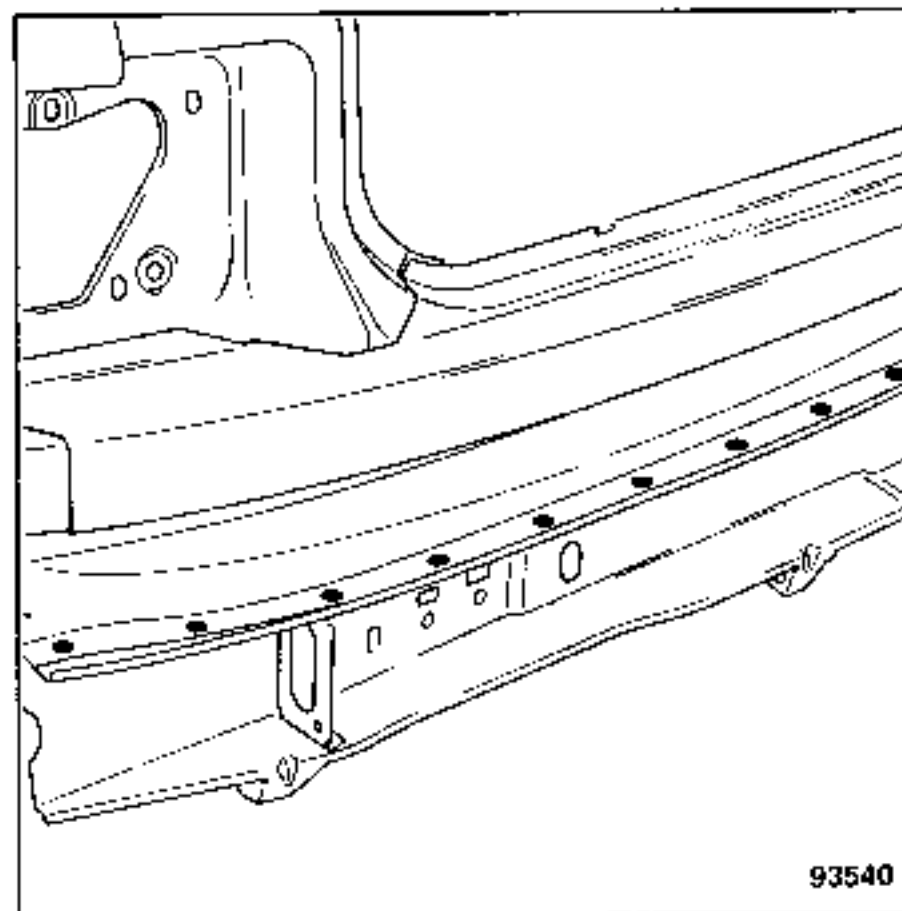
Rear end panel	0.67
Rear end panel lining	0.67
Striker plate strengthener	1.20
Rear lower cross-member	1.20

Unpicking



34 electric spot welds

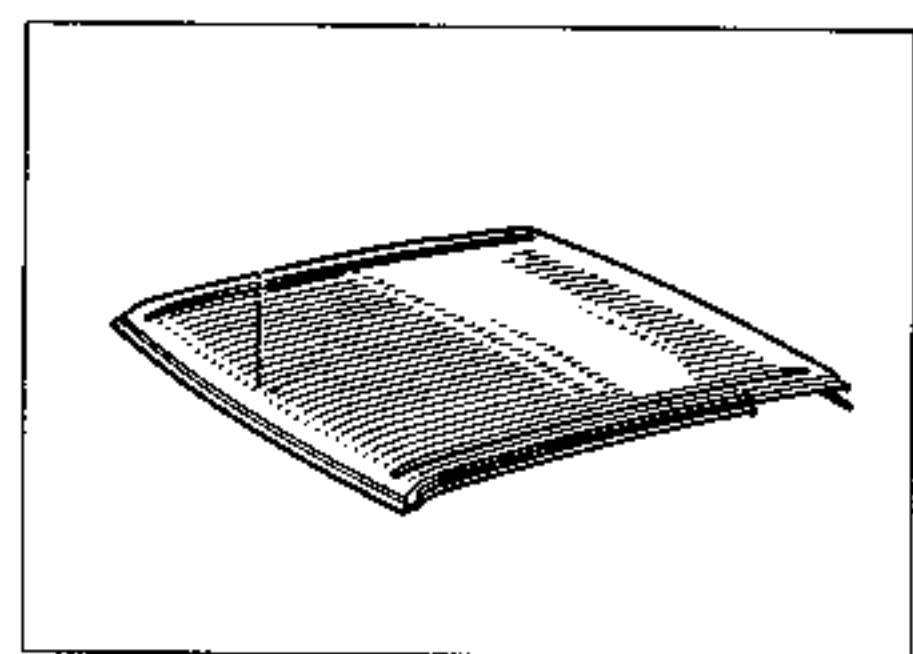
# Welding



This operation only deals with the special points for the B48. Please consult MR292 for the other connections.

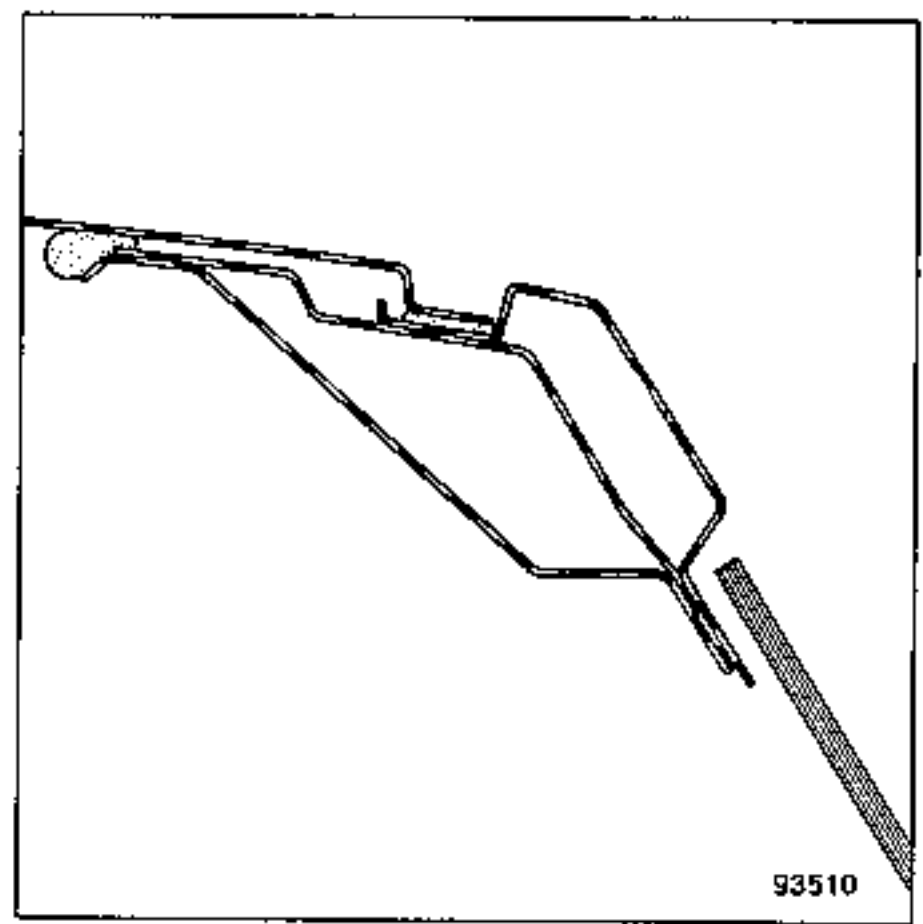
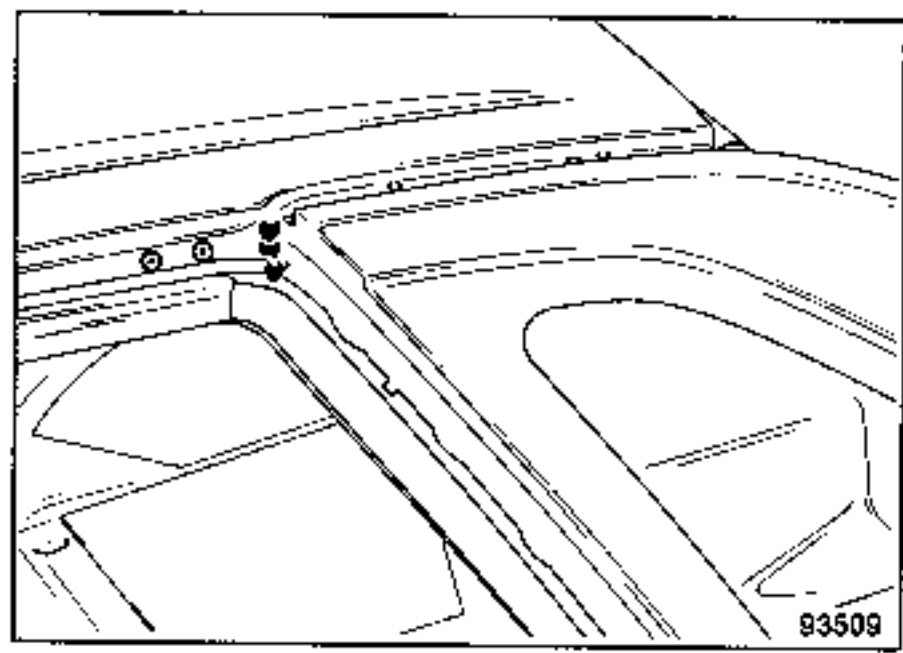
COMPOSITION OF THE PARTS AS SUPPLIED BY THE PARTS DEPARTMENT.

Single part.



# 1 CONNECTION WITH WING PANEL

Remember: See 44-A-12



# 2 CONNECTION WITH RAIN CHANNEL, UPPER GUSSET

Panel thickness (mm)

Roof panel	0.77
Rain channel upper gusset	1.50

Unpicking



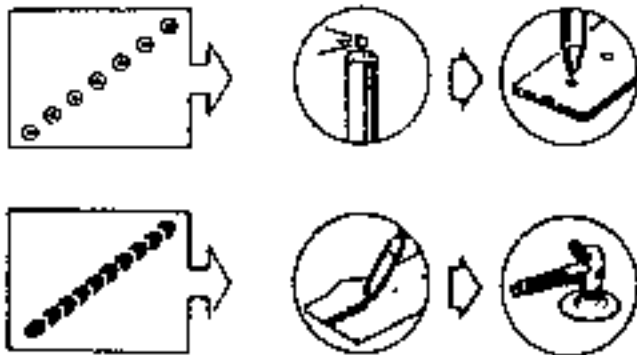
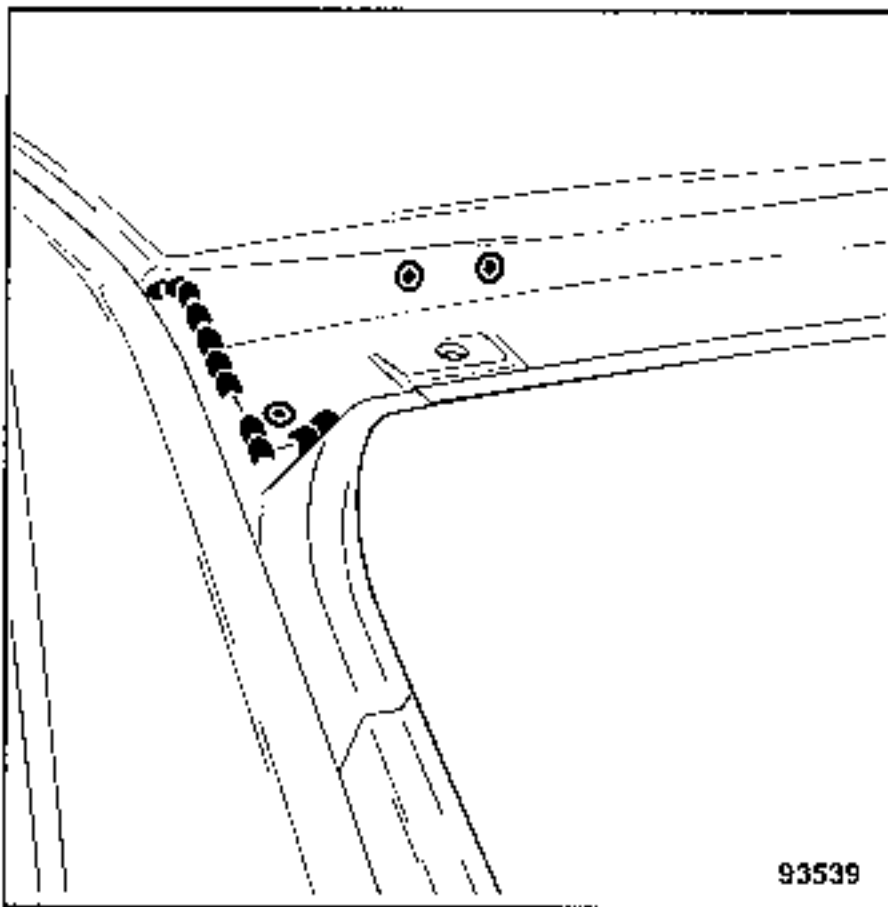
3 electric spot welds



- 1 90 mm soldering joint bead
- 2 15 mm soldering joint beads



Welding

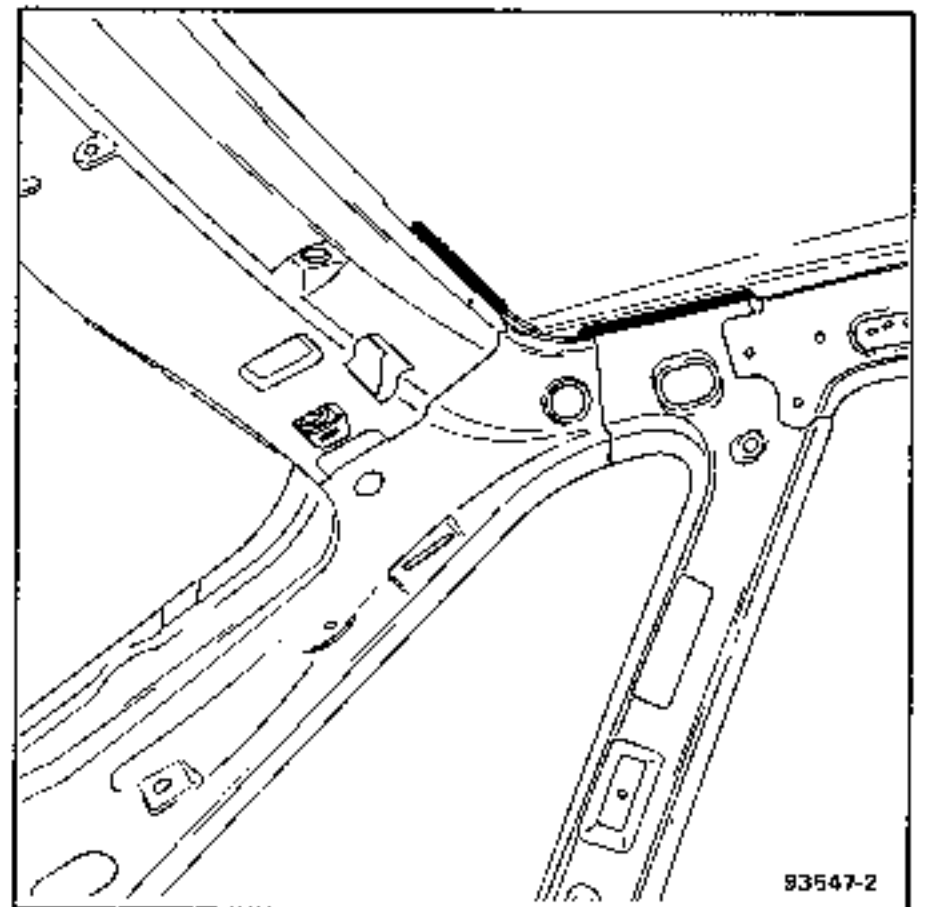
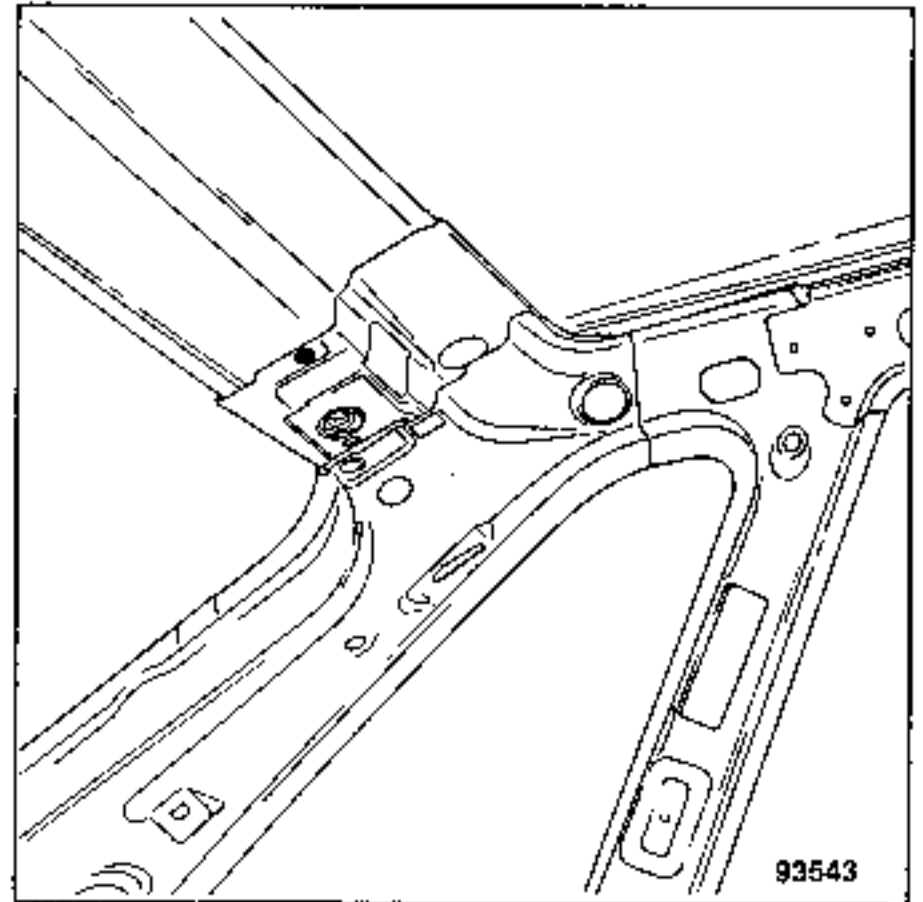


- 1 90 mm M.I.G. bead
- 2 15 mm M.I.G. beads

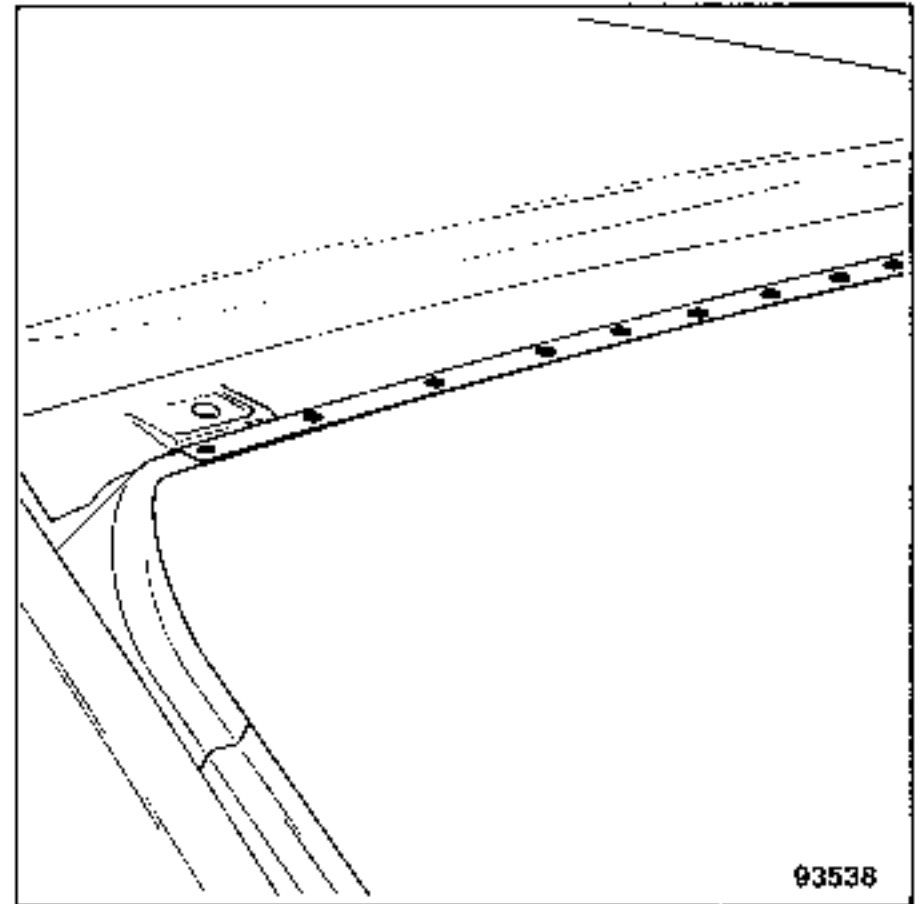
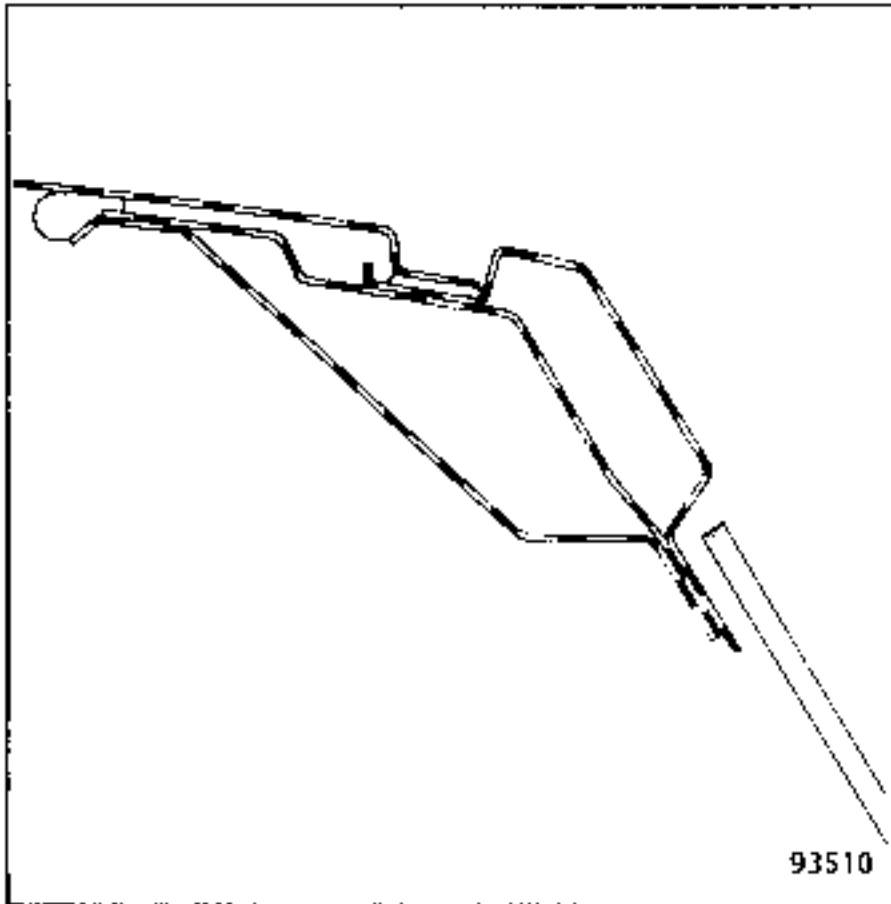


**3** CONNECTION WITH REAR QUARTER PANEL  
LINING ASSEMBLY

Remember: See 44-F-8



# Welding



## 4 CONNECTION WITH REAR CROSS-MEMBER

Panel thickness (mm)

Roof panel	0.77
Rain channel	
upper gusset	1.50
Roof cross-member	0.67

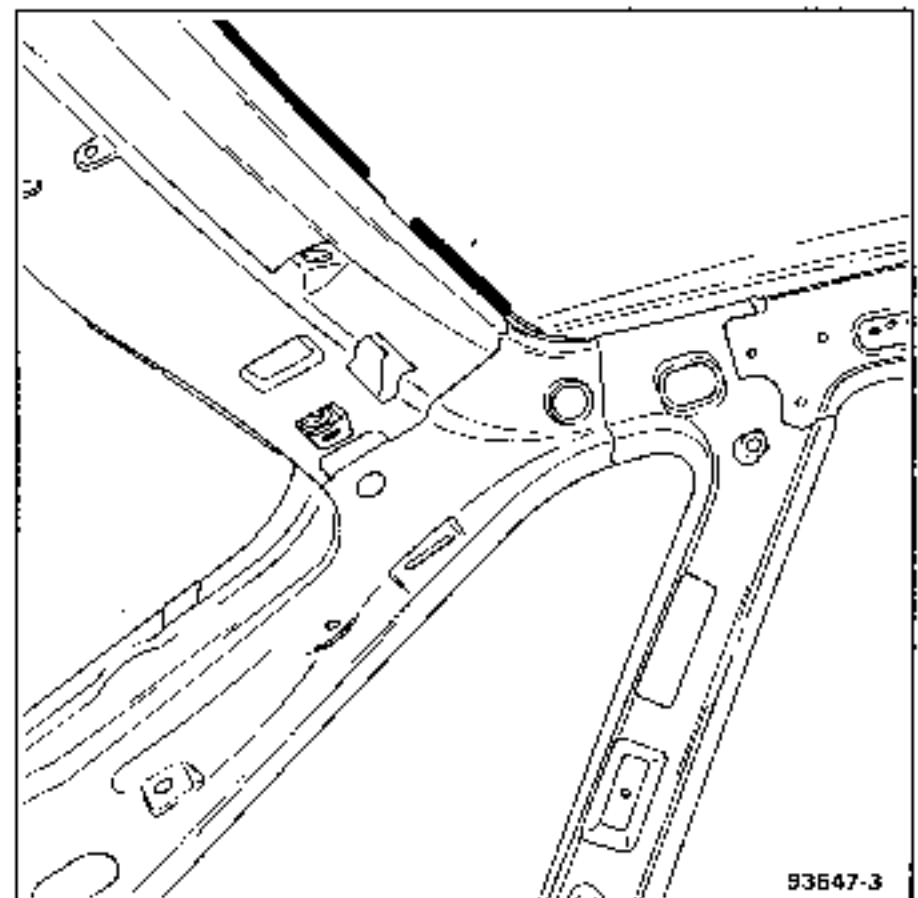
Unpicking



12 electric spot welds

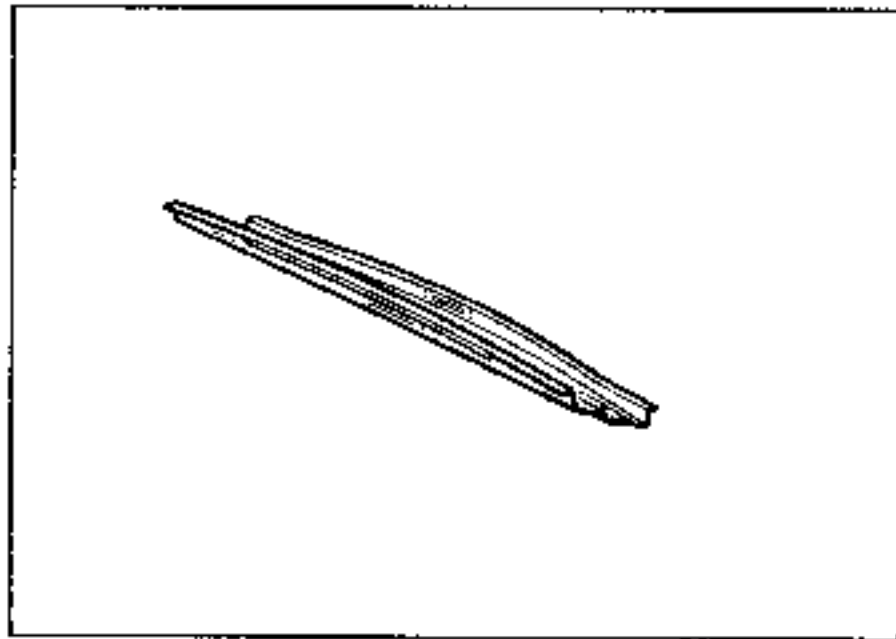


# Bonding



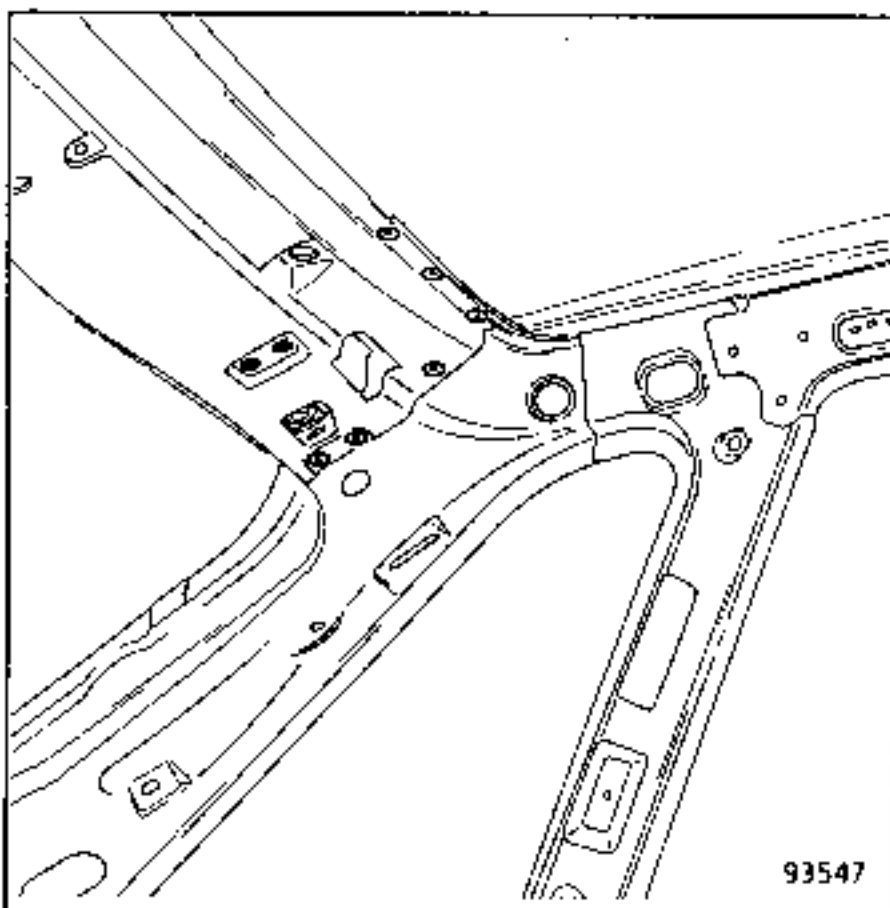
COMPOSITION OF PARTS AS SUPPLIED BY  
THE PARTS DEPARTMENT.

Single part.



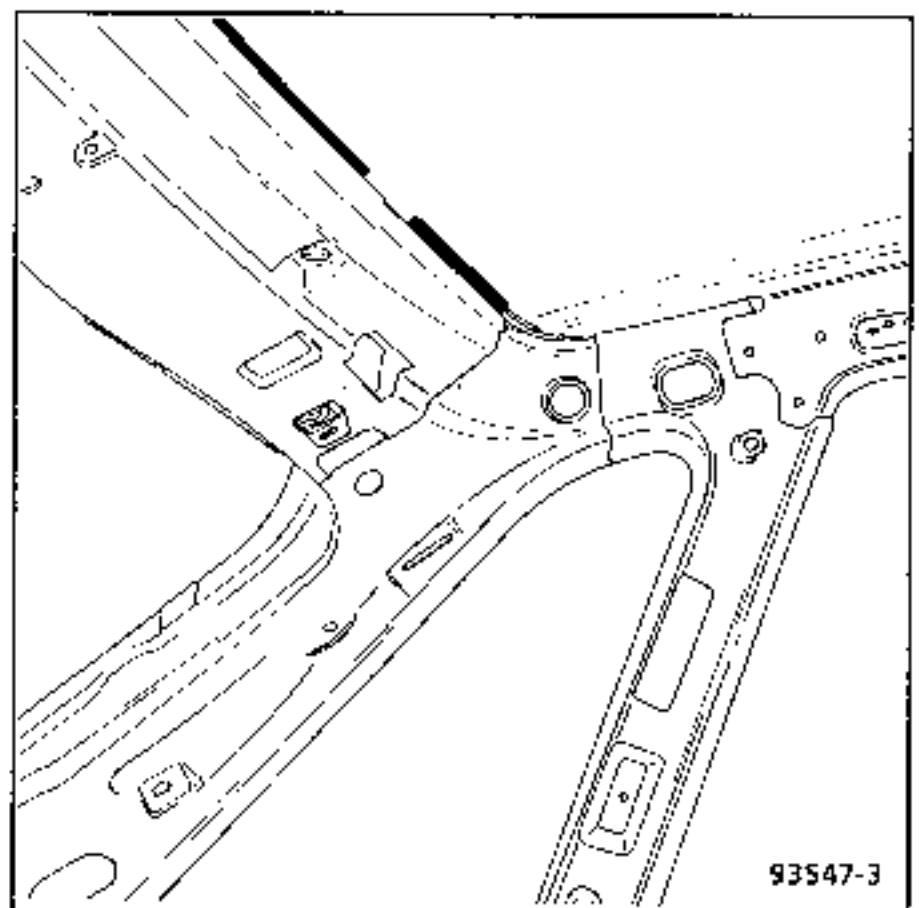
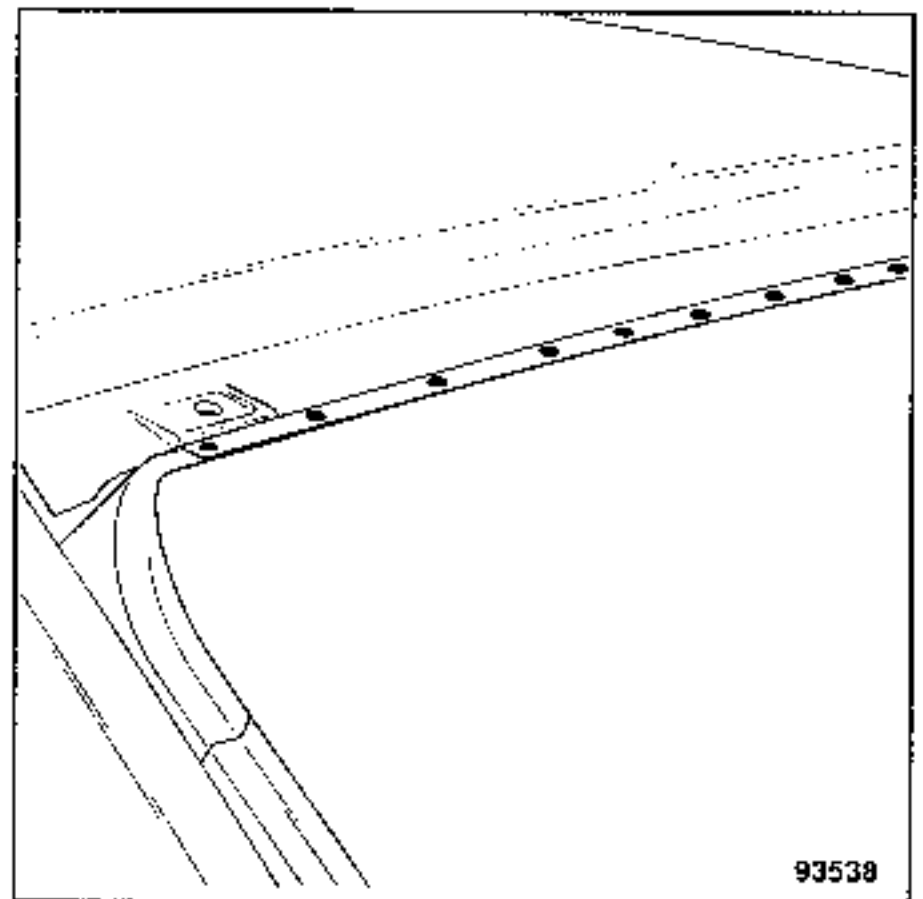
**1** CONNECTION WITH REAR QUARTER PANEL  
LINING

Remember: See 44-F-2

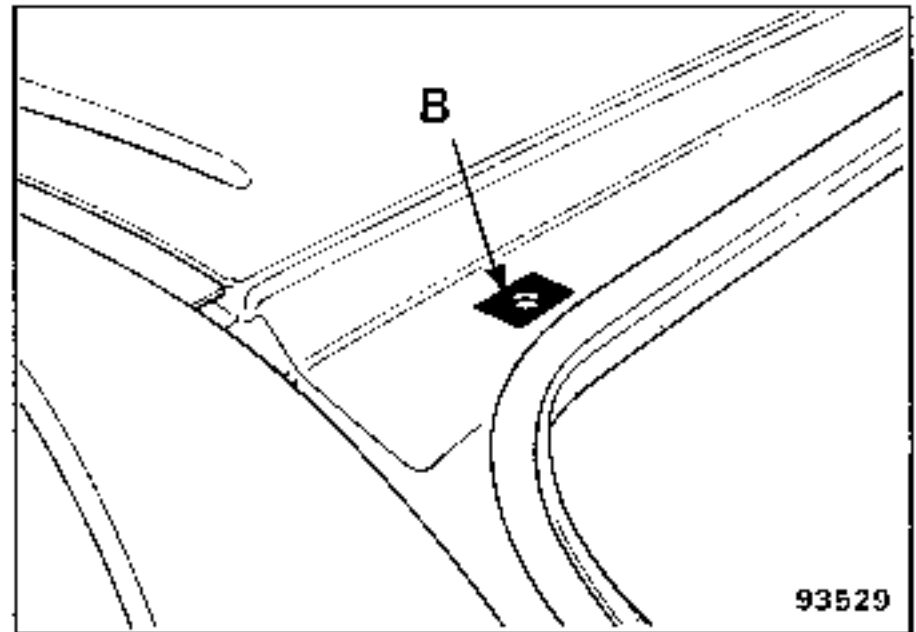


**2** CONNECTION WITH ROOF

Remember: See 45-A-4



## REFITTING

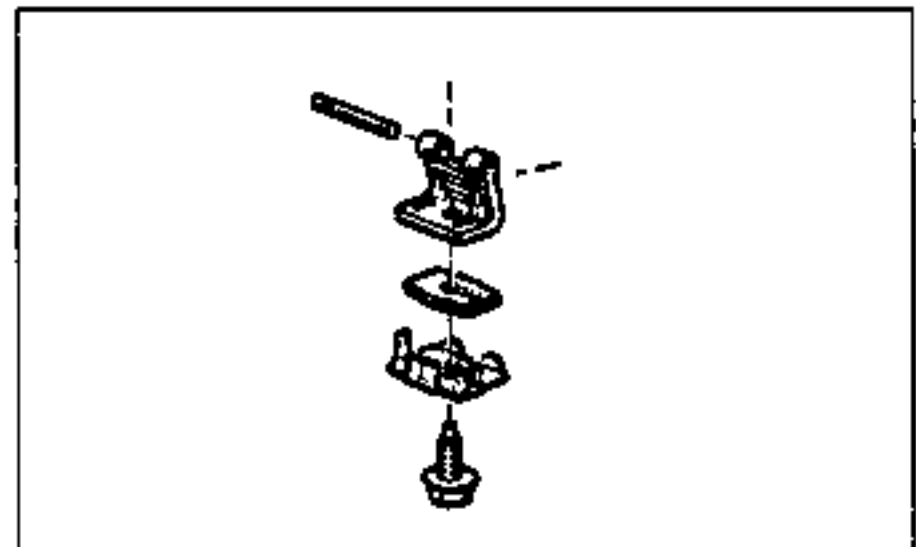


Before refitting the tailgate, apply sealing mastic over part (B) located under the hinge.

After refitting, spray on 2-part anti-gravel mastic around the hinge.

For refitting the trim, it is advisable to re-assemble the harness first.

## REPLACING

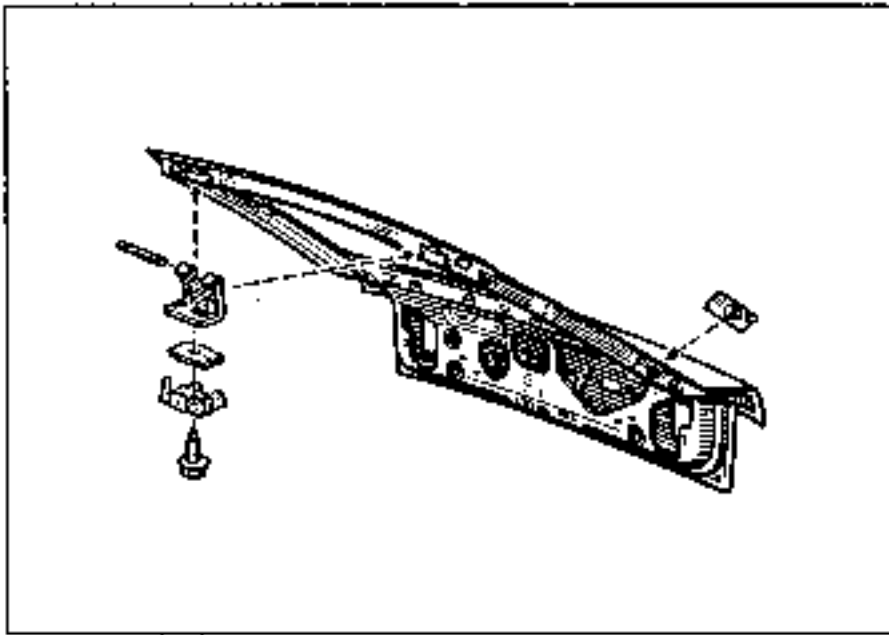


If the tailgate is replaced, the female hinges will have to be recovered or re-ordered since they are not supplied with the tailgate.

NOTE: In order to facilitate adjustment, it is advisable to dismantle the hinges when the tailgate has been removed.

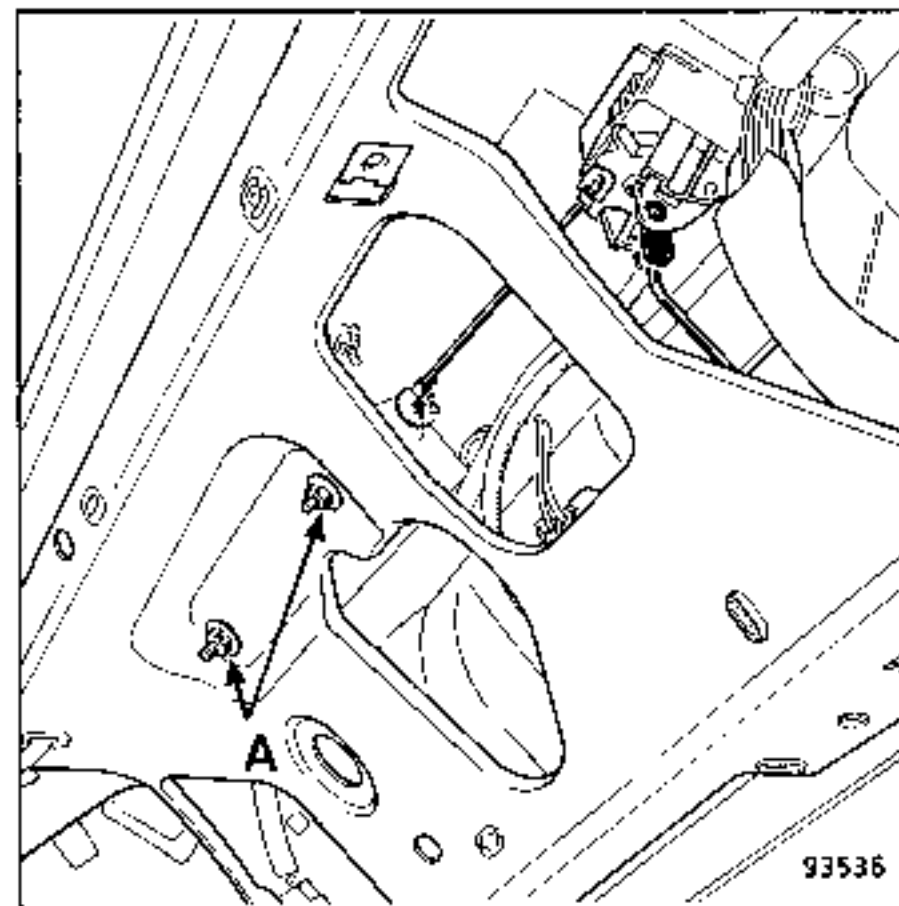
## COMMENT:

Before removing the hinge pins, mark the side with the splines in order that they can be dismantled in the correct direction.



## REMOVAL

When stripping the tailgate, proceed in the following order:



Remove the tailgate trim;  
Remove the rear screen wiper;  
Remove the tailgate lock motor (A) so that the harness and rear spoiler can be dismantled.  
Remove the harness.