

RENAULT

4 Panelwork

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X79

NOVEMBER 2009

EDITION ANGLAISE

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

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

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DUSTER - Chapitre 4

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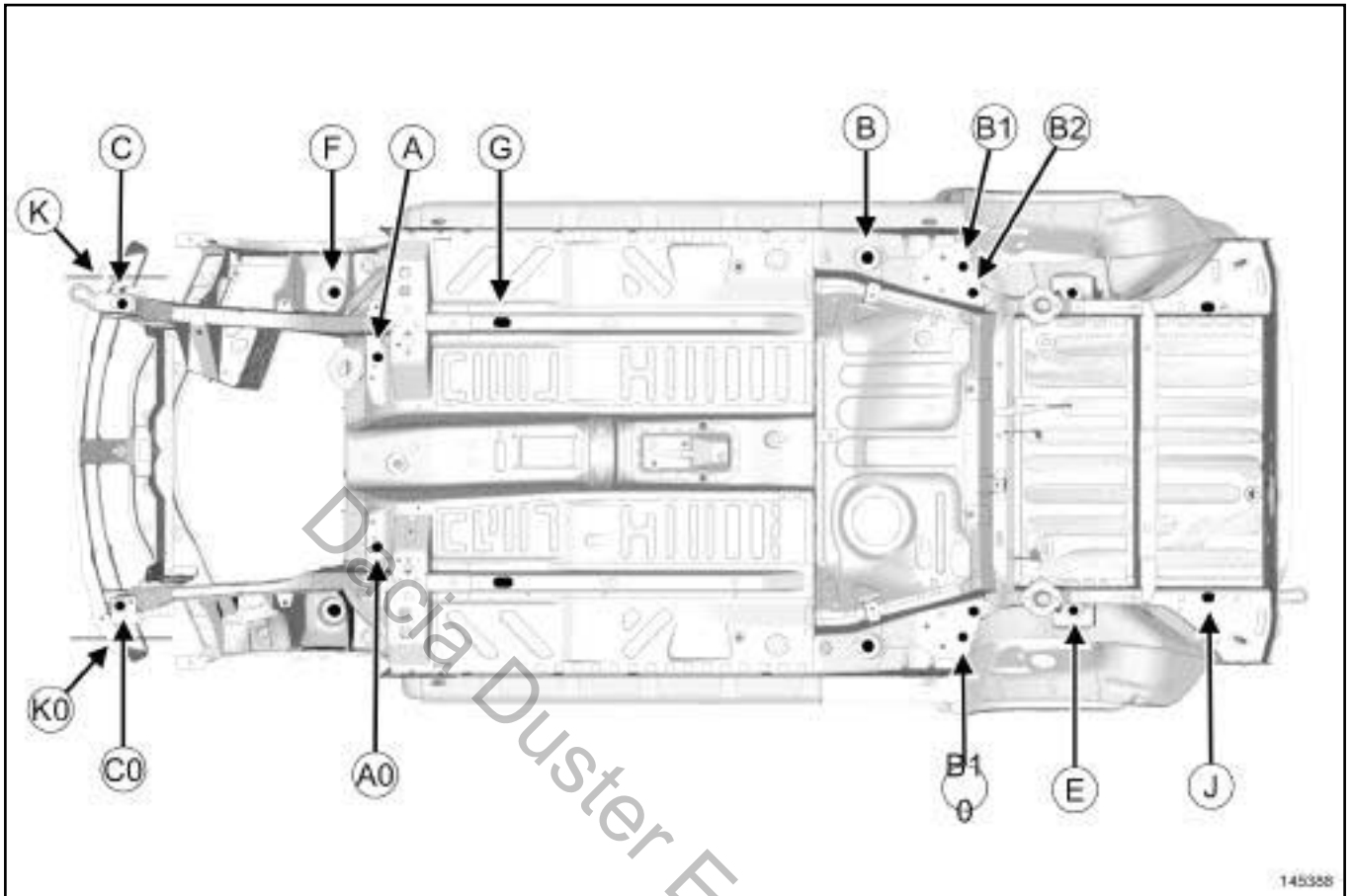
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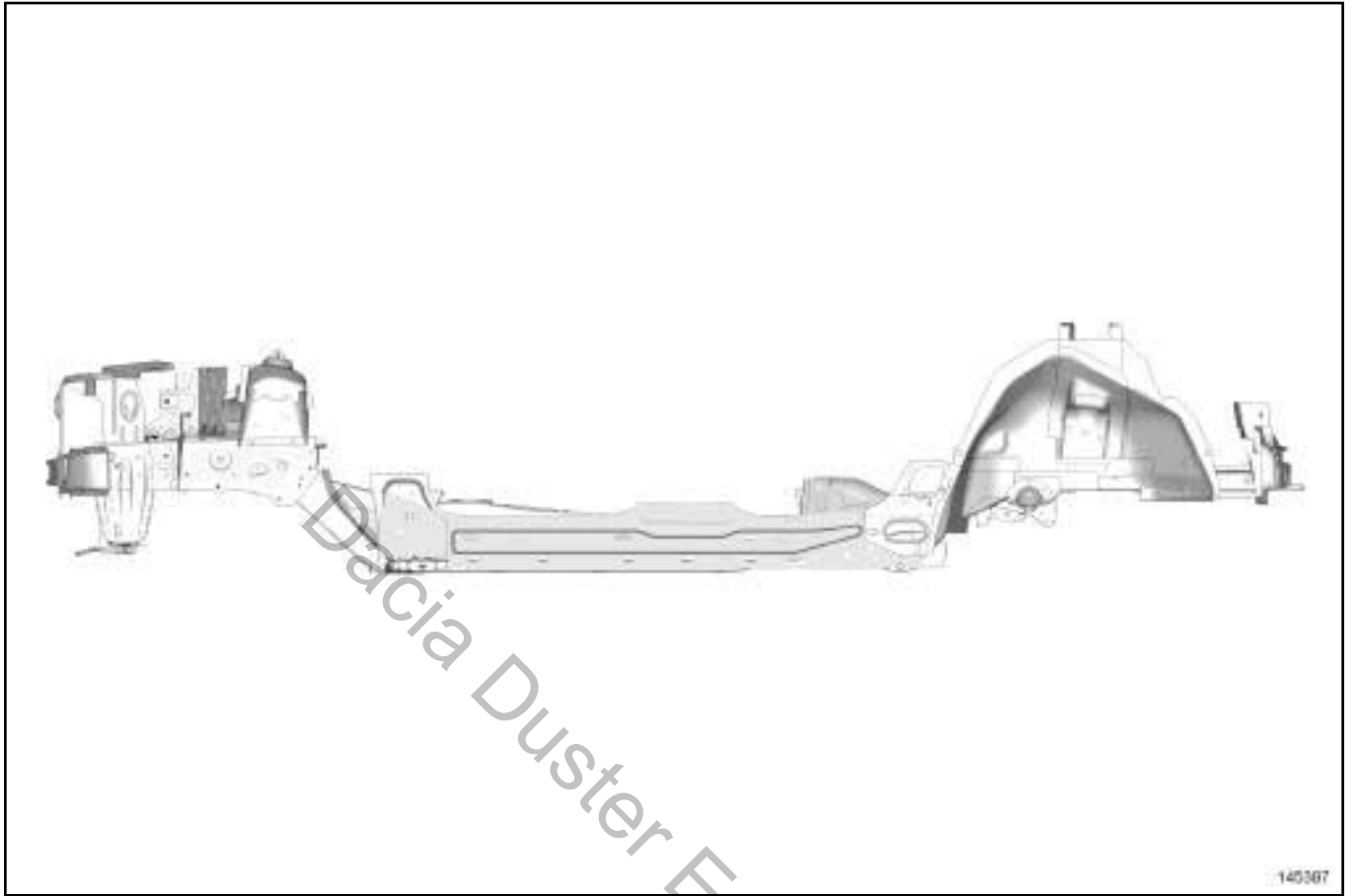
GENERAL INFORMATION
Subframe: Specifications

40A



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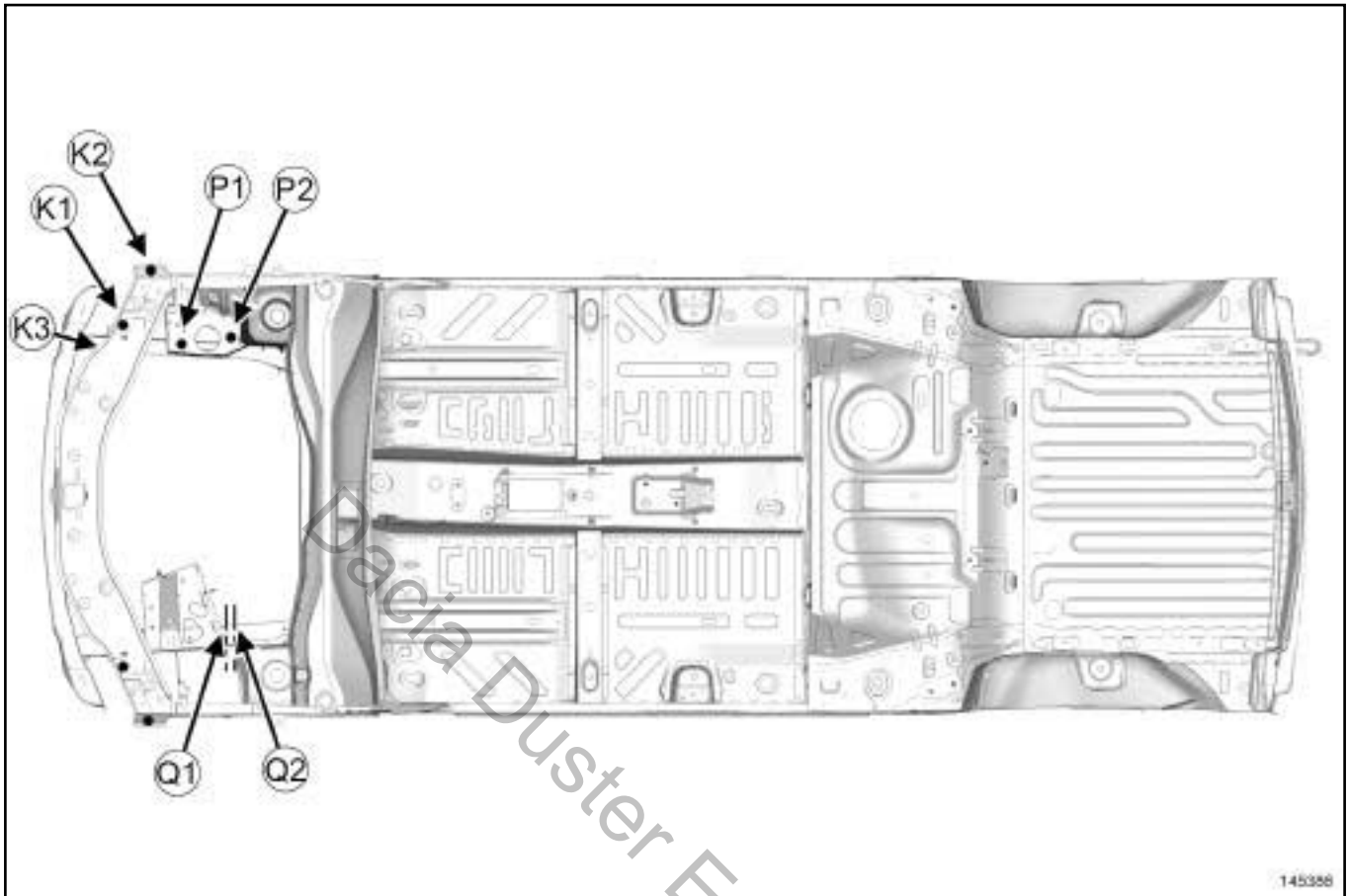


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GENERAL INFORMATION

Subframe: Specifications

40A



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4x2 version

No.	Description	Dimension X (mm)	Dimension Y (mm)	Dimension Z (mm)	Diameter (mm)	Angle
A	Left front subframe rear mounting without mechanical components	301	305	78	24.7-M12	0°
Ao	Right front subframe rear mounting without mechanical components	301	305	78	24.7x29.6-M12	0°
A	Left front subframe rear mounting with mechanical components	301	305	-28	Bolt head	0°
Ao	Right front subframe rear mounting with mechanical components	301	305	-28	Bolt head	0°
B	Rear side member front leader pin	1838	622	74	30x30	0°
B1	Left-hand rear axle fixing leader pin without mechanical components	2200	600	118.5	16.2	0°
B1o	Right-hand rear axle fixing leader pin without mechanical components	2200	600	118.5	16.2x24.2	0°
B2	Rear axle rear mounting without mechanical components	2230	516	114.5	Bolt head	0°

GENERAL INFORMATION

Subframe: Specifications

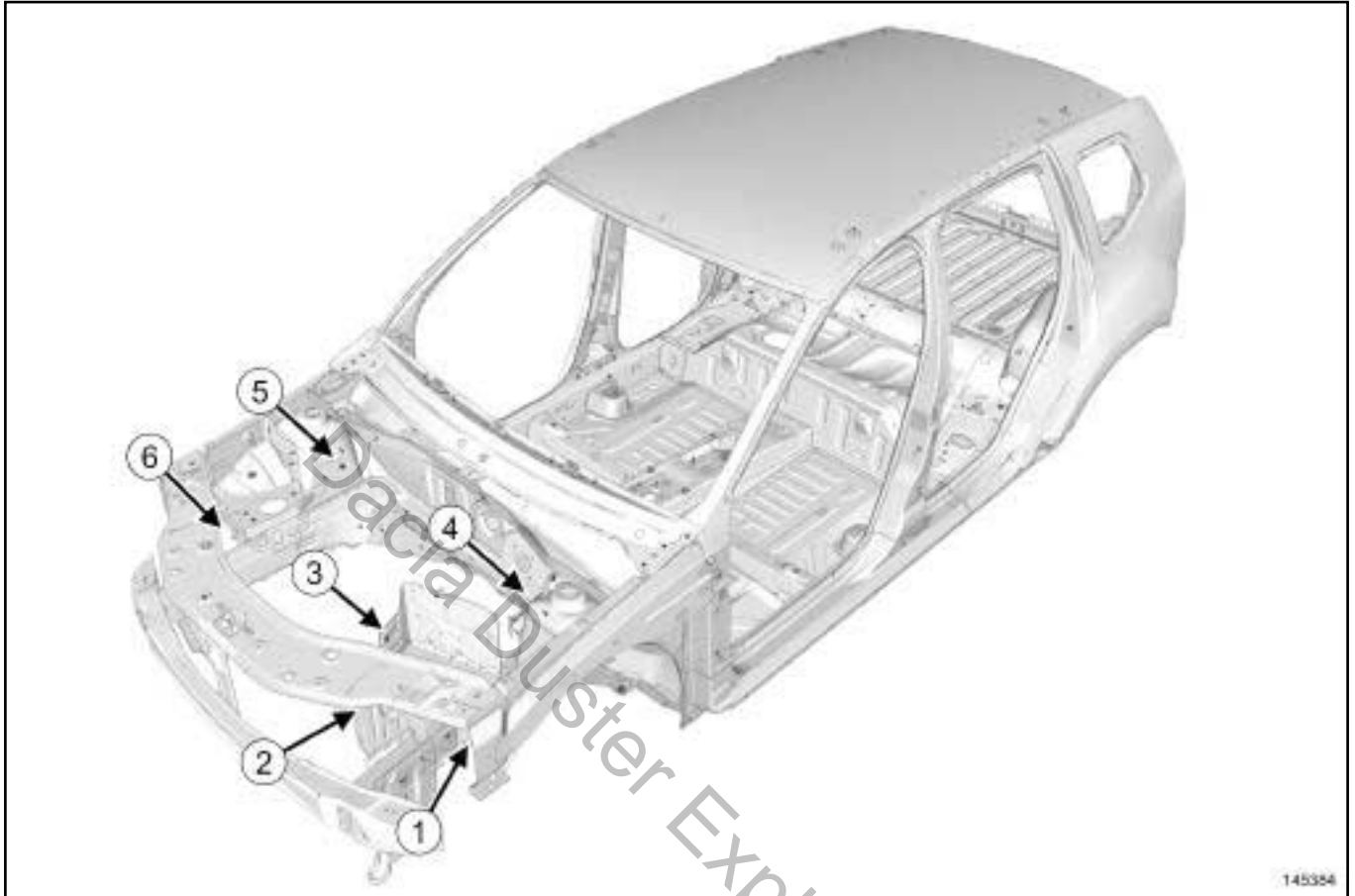
40A

No.	Description	Dimension X (mm)	Dimension Y (mm)	Dimension Z (mm)	Diameter (mm)	Angle
C	Left front subframe front mounting without mechanical components	-502	476	82	M12	0°
Co	Right front subframe front mounting without mechanical components	-525	492	82	M12	0°
C	Left front subframe front mounting with mechanical components	-502	476	-5.5	Bolt head	0°
Co	Right front subframe front mounting with mechanical components	-525	492	-5.5	Bolt head	0°
E	Rear shock absorber upper mounting	2672.25	562.5	532.5	18.2	X: 8° Y: 0°
F	Front shock absorber upper mounting	-3	583.5	683	48	x: 0°35' y: 3°40'
G	Front side member rear leader pin, centre section	721	409	-8.5	20x50	0°
J	Rear side member rear leader pin	2809	485.5	259.5	16.2x32.2	0°
K	Front left end lower cross member	-698	565.5	314.75	14.5	90°
Ko	Front right lower end cross member	-698	566.5	314.75	12.2x16.2	90°
K1	Front upper cross member	-504	555	656	10.2x12.2	0°
K2	Bumper mountings	-421	732	403	12x12	0°
K3	Headlight mounting	581.5	420.5	458.3	8.2x16.2	90°
L	Rear left rear end cross member	3300	580	325	20.5	90°
LO	Rear right rear end cross member	3300	580	325	20x50	90°
P1	Engine mountings 1	-310	492.5	491.5	M10	180°
P2	Engine mountings 2	-150	514.5	491.5	M10	180°
Q1	Gearbox mountings 1	-283	429.5	368	M10	X: 0° y: 90° Z: 4°
Q2	Gearbox mountings 2	-254	427.3	320.5	M10	X: 0° y: 90° Z: 4°

A and B = vehicle trim height reference

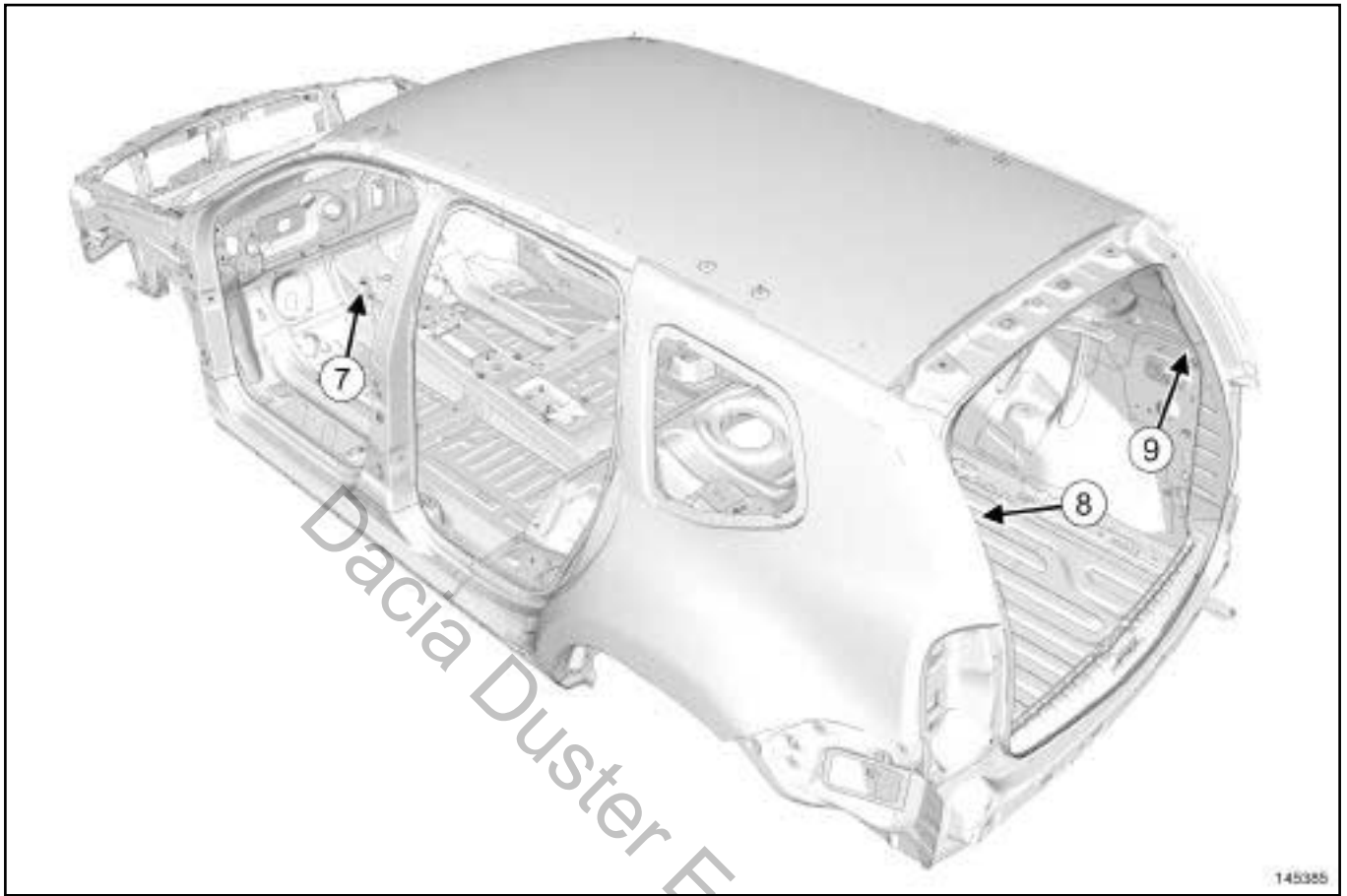
Earths on body: List and location of components

For the earth stud fitting procedure (see) (MR400, 40H, Bolted connections).



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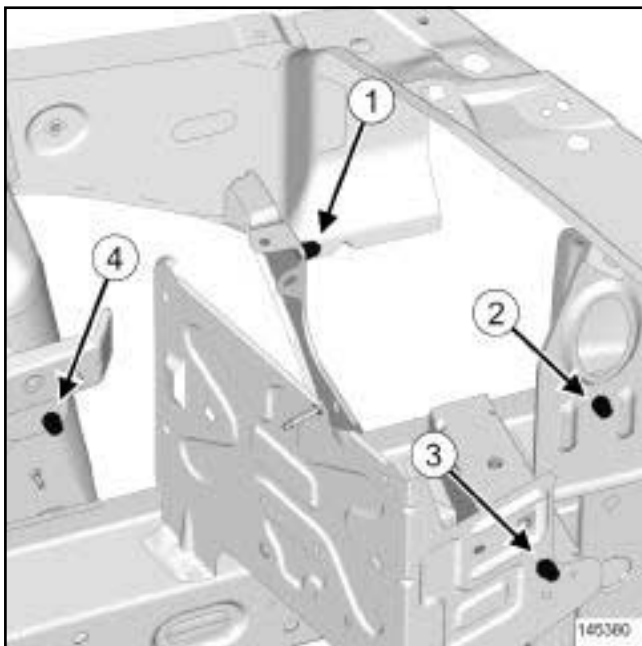
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DETAILED VIEW OF THE EARTH POSITIONS ON THE VEHICLE

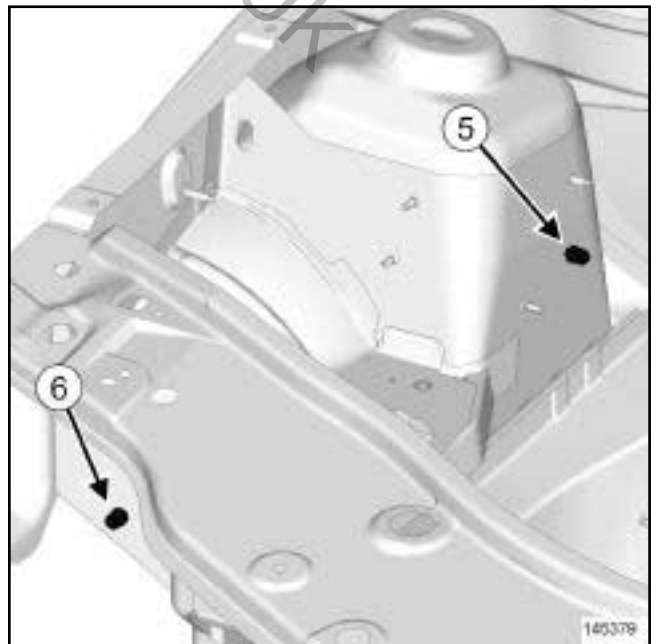


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Earth studs on:

- the front left-hand end side cross member (1) ,

- the front end panel upper cross member mounting (2) ,
- the battery tray bracket (3) ,
- the left-hand shock absorber cup height adjuster (4) .



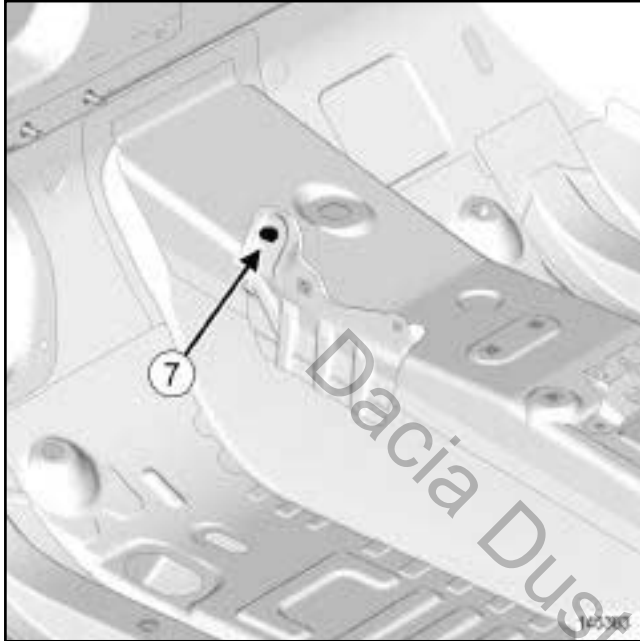
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Earths on body: List and location of components

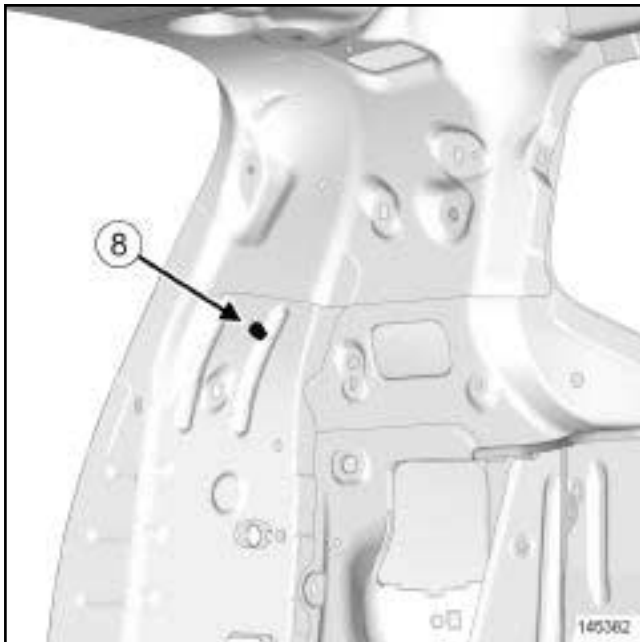
Earth studs on:

- the right-hand shock absorber cup height adjuster (5)
- the front right-hand end side cross member (6)



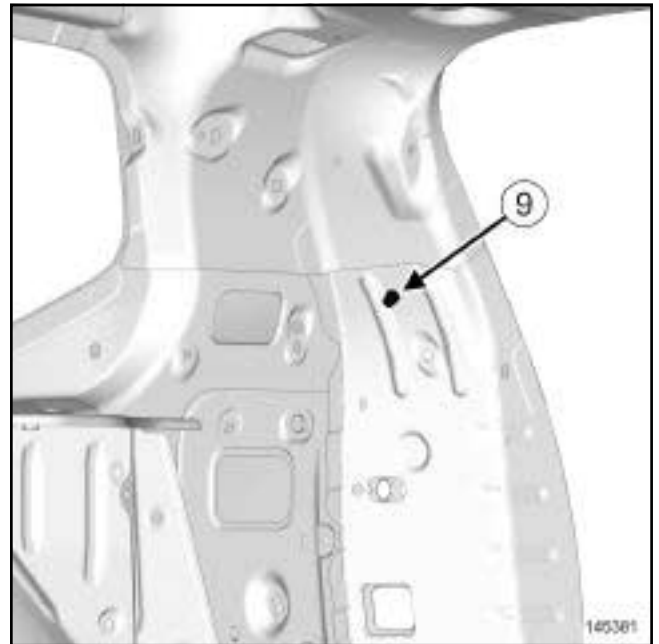
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Earth stud on the tunnel (7) .



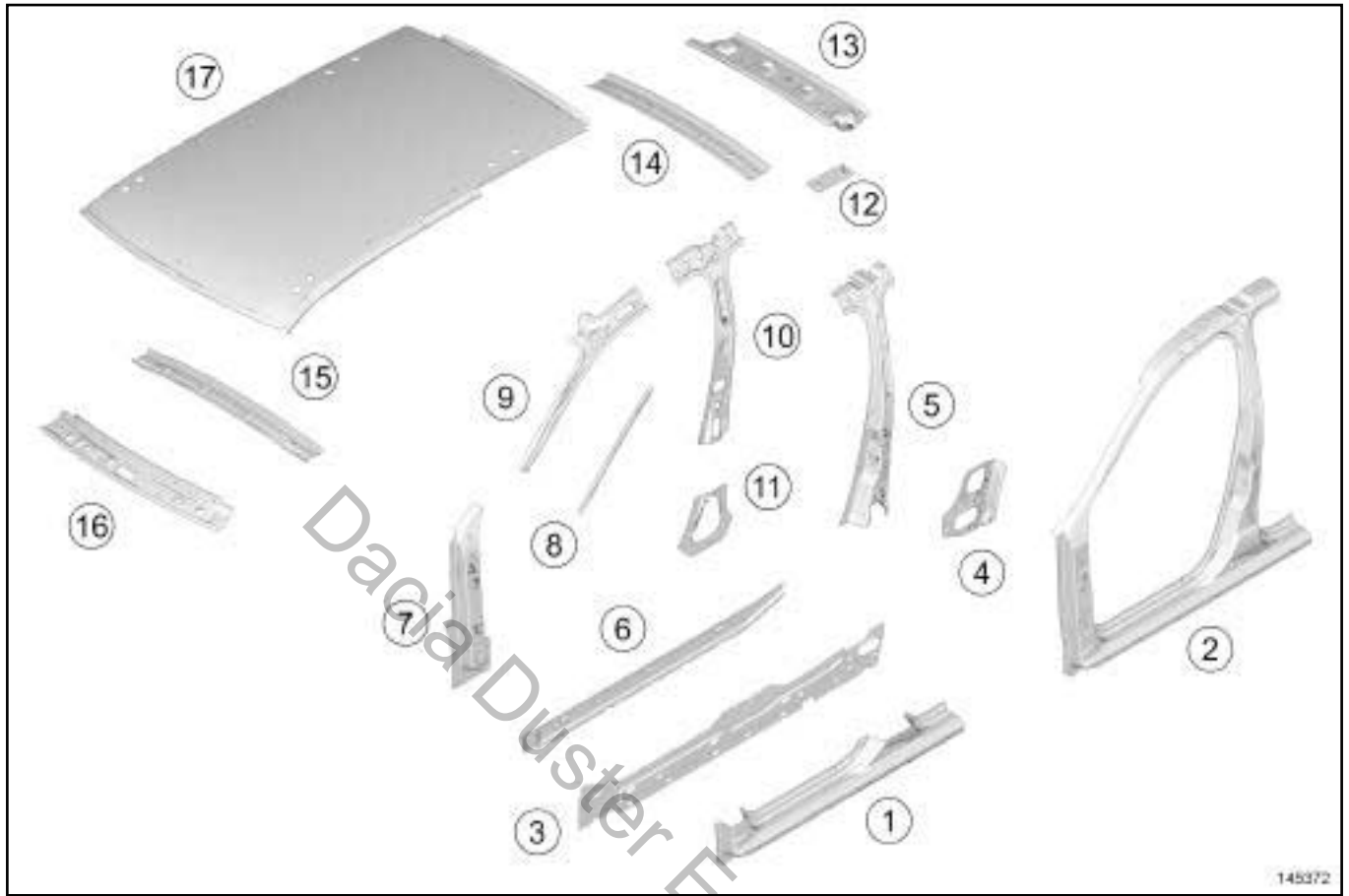
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Earth stud on left-hand light mounting lining (8) .



145381

Earth stud on right-hand light mounting lining (9) .



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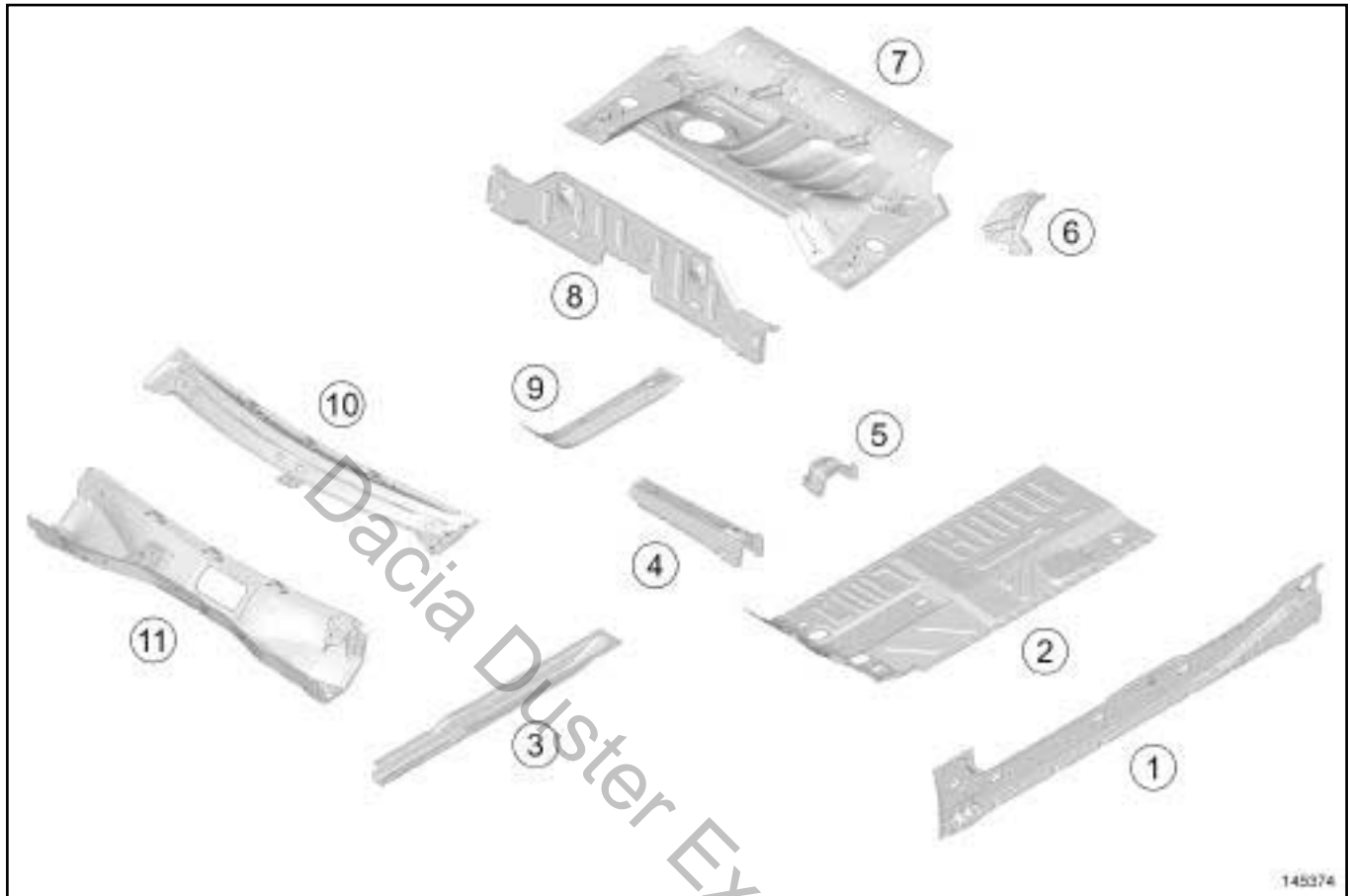
No.	Description	Reference
(1)	Sill panel	(see 41C, Side lower structure, Sill panel: Replacement, page 41C-1)
(2)	Body side, front section	(see 43A, Side upper structure, Body side, front section: Replacement, page 43A-7)
(3)	Sill panel reinforcement	(see 41C, Side lower structure, Sill panel reinforcement: Replacement, page 41C-10)
(4)	Sill panel rear reinforcement	(see 41C, Side lower structure, Sill panel rear reinforcement: Replacement, page 41C-18)
(5)	B-pillar reinforcement	(see 43A, Side upper structure, B-pillar reinforcement: Replacement, page 43A-4)
(6)	Sill pane stiffener	(see 41C, Side lower structure, Sill panel stiffener: Replacement, page 41C-14)
(7)	A-pillar reinforcement	(see 43A, Side upper structure, A-pillar reinforcement: Replacement, page 43A-1)
(8)	Double seal mounting	(see 43A, Side upper structure, Body side, front section: Replacement, page 43A-7)

GENERAL INFORMATION

Vehicle structure, side section: Description

40A

No.	Description	Reference
(9)	Windscreen pillar lining	(see 43A, Side upper structure, Windscreen pillar lining: Replacement, page 43A-3)
(10)	B-pillar lining	(see 43A, Side upper structure, B-pillar lining: Replacement, page 43A-5)
(11)	B-pillar lower lining	(see 43A, Side upper structure, B-pillar lower lining: Replacement, page 43A-6)
(12)	Roof bar mounting	(see 43A, Side upper structure, Roof bar mounting: Replacement, page 43A-12)
(13)	Roof rear cross member	(see)
(14)	Roof panel arch	(see 45A, Top of body, Roof panel arch: Replacement, page 45A-5)
(15)	Roof centre cross member	(see 45A, Top of body, Roof centre cross member: Replacement, page 45A-4)
(16)	Roof front cross member	(see 45A, Top of body, Roof front cross member: Replacement, page 45A-3)
(17)	Roof	(see 45A, Top of body, Roof: Replacement, page 45A-1)



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No.	Description	Reference
(1)	Sill panel closure panel	(see 41C, Side lower structure, Sill panel closure panel: Replacement, page 41C-6)
(2)	Centre floor, side section	(see 41B, Centre lower structure, Centre floor, side section: Replacement, page 41B-1)
(3)	Centre side member	(see 41B, Centre lower structure, Centre side member: Replacement, page 41B-5)
(4)	Front cross member under front seat	(see)
(5)	Front seat rear mounting support	(see)
(6)	Front section of rear floor side reinforcement	(see 41D, Rear lower structure, Rear floor, front section: Replacement, page 41D-2)
(7)	Rear floor, front section	(see 41D, Rear lower structure, Rear floor, front section: Replacement, page 41D-2)
(8)	Rear floor front cross member	(see 41D, Rear lower structure, Rear floor front cross member: Replacement, page 41D-8)

GENERAL INFORMATION

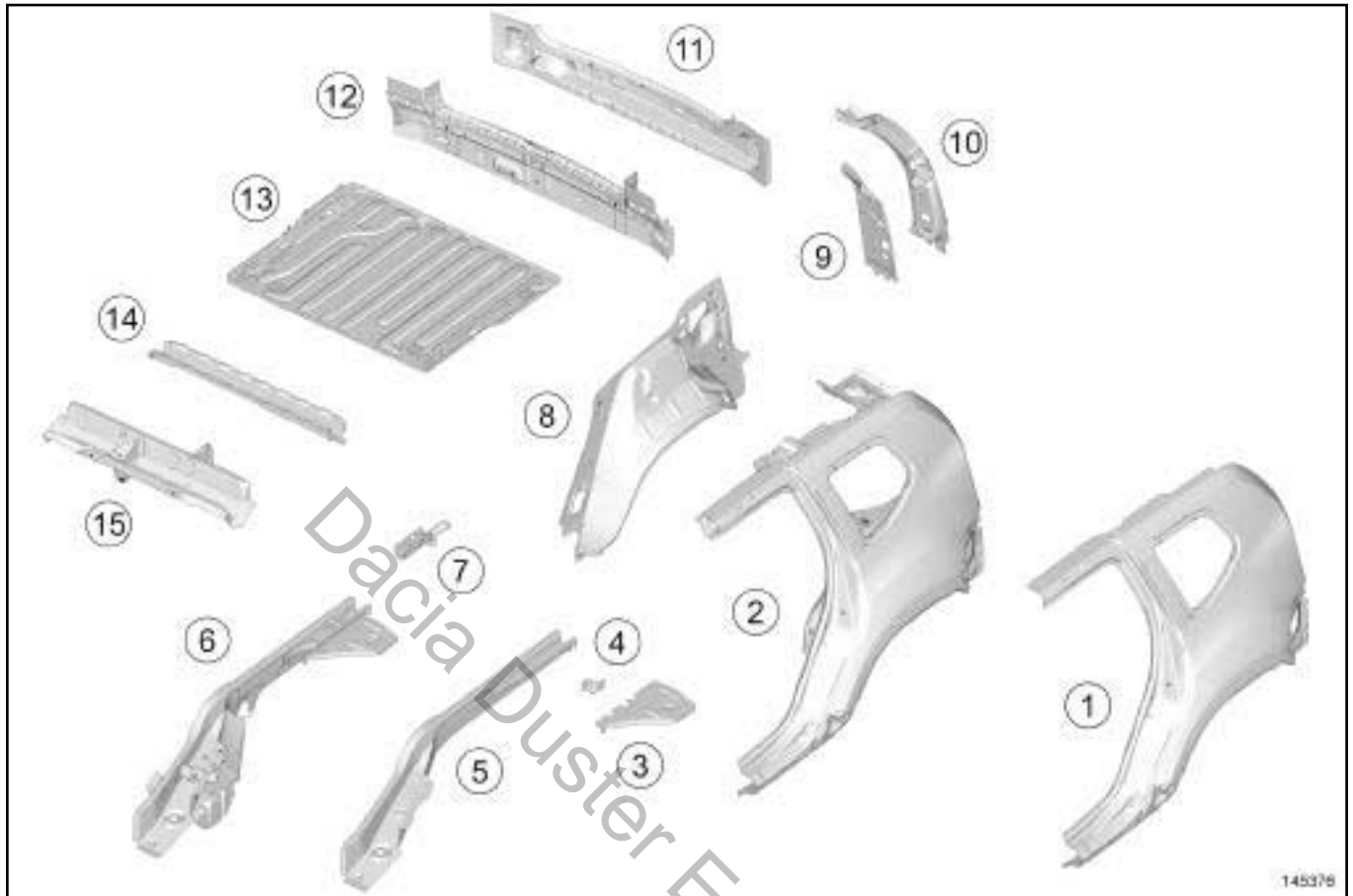
40A

Vehicle structure, centre section: Description

No.	Description	Reference
(9)	Centre floor reinforcement	(see)
(10)	Windscreen aperture lower cross member	(see 42A, Front upper structure, Windscreen aperture lower cross member: Replacement, page 42A-10)
(11)	Heater bulkhead	(see 42A, Front upper structure, Heater bulkhead: Replacement, page 42A-8)

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4x2 version



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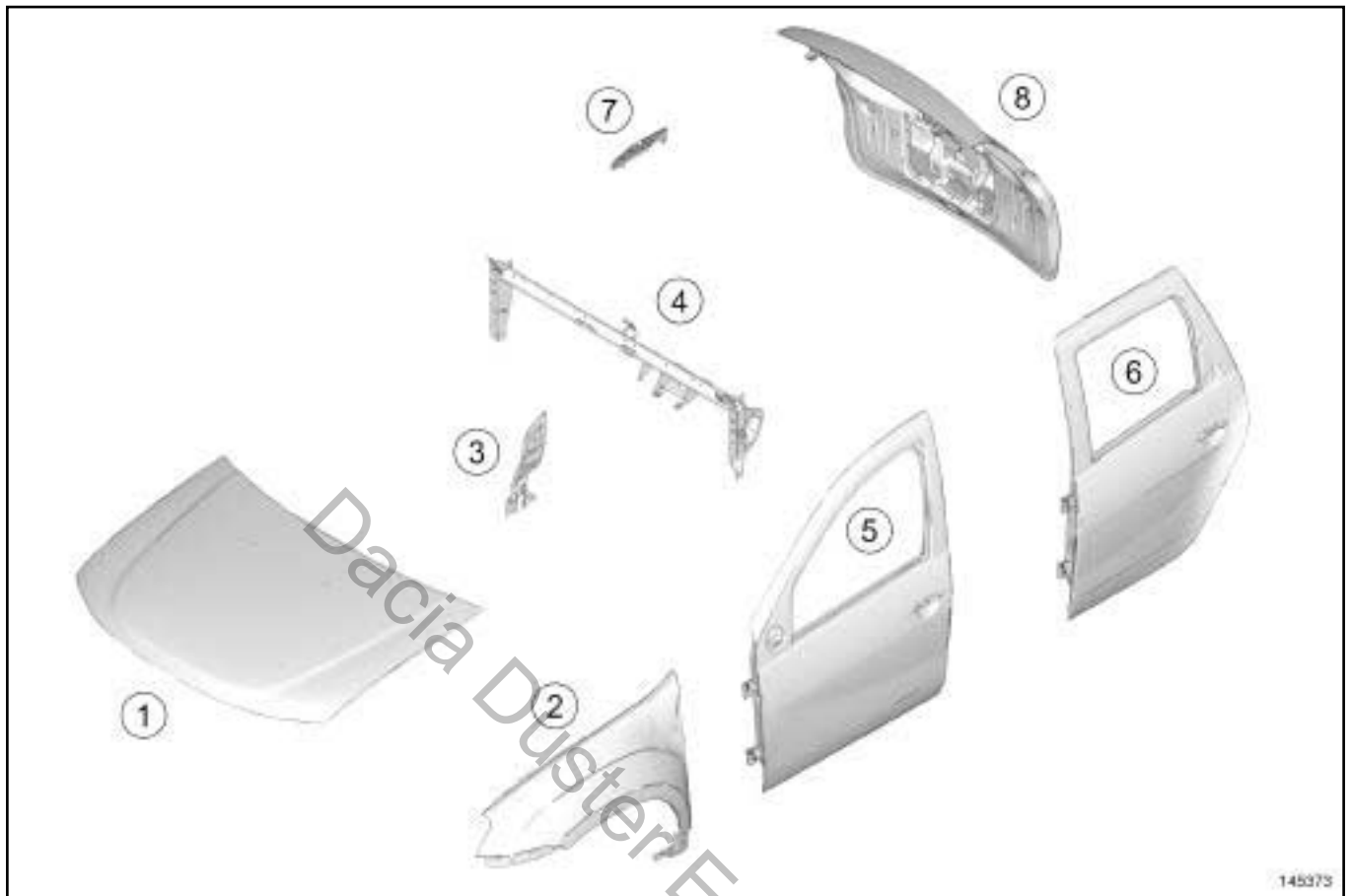
No.	Description	Reference
(1)	Rear wing panel	(see 44A, Rear upper structure, Rear wing panel: Replacement, page 44A-1)
(2)	Rear half unit	(see 44A, Rear upper structure, Rear half-unit: Replacement, page 44A-9)
(3)	Rear floor, side section	(see 41D, Rear lower structure, Rear floor, rear side section: Replacement, page 41D-14)
(4)	Exhaust mounting support	(see 41D, Rear lower structure, Exhaust mounting support: Replacement, page 41D-16)
(5)	Rear side member	(see 41D, Rear lower structure, Rear side member: Replacement, page 41D-6)
(6)	Rear side member assembly	(see 41D, Rear lower structure, Rear side member assembly: Replacement, page 41D-4)
(7)	Rear towing eye	(see 41D, Rear lower structure, Rear towing eye: Replacement, page 41D-15)
(8)	Quarter panel lining	(see 44A, Rear upper structure, Quarter panel lining: Replacement, page 44A-8)

GENERAL INFORMATION

Vehicle structure, rear section: Description

40A

No.	Description	Reference
(9)	Light mounting lining	(see 44A, Rear upper structure, Light mounting lining: Replacement, page 44A-7)
(10)	Rear light mounting	(see 44A, Rear upper structure, Rear light mounting: Replacement, page 44A-6)
(11)	Rear end panel	(see 44A, Rear upper structure, Rear end panel: Replacement, page 44A-11)
(12)	Rear end panel lining	(see 44A, Rear upper structure, Rear end panel lining: Replacement, page 44A-12)
(13)	Rear floor, rear section	(see 41D, Rear lower structure, Rear floor, rear section: Replacement, page 41D-11)
(14)	Rear floor reinforcement	(see 41D, Rear lower structure, Rear floor reinforcement: Replacement, page 41D-1)
(15)	Rear floor centre cross member	(see 41D, Rear lower structure, Rear floor centre cross member: Replacement, page 41D-10)



145373

145373

No.	Description	Reference
(1)	Bonnet	(see 48A, Non-side opening elements, Bonnet: Removal - Refitting, page 48A-1)
(2)	Front wing	(see 42A, Front upper structure, Front wing: Removal - Refitting, page 42A-2)
(3)	Dashboard cross member centre plate	(see 42A, Front upper structure, Dashboard cross member: Removal - Refitting, page 42A-11)
(4)	Dashboard cross member	(see 42A, Front upper structure, Dashboard cross member: Removal - Refitting, page 42A-11)
(5)	Front side door	(see 47A, Side opening elements, Front side door: Removal - Refitting, page 47A-1)
(6)	Rear side door	(see 47A, Side opening elements, Rear side door: Removal - Refitting, page 47A-6)
(7)	Fuel filler flap cover	(see 47A, Side opening elements, Fuel filler flap cover: Removal - Refitting, page 47A-11)
(8)	Tailgate	(see 48A, Non-side opening elements, Tailgate: Removal - Refitting, page 48A-5)

FRONT LOWER STRUCTURE

Front end lower cross member: Replacement

41A

I - COMPOSITION OF THE SPARE PART

No.	Description	Thickness (mm)
(1)	Front end lower cross member	1.45

II - IN THE EVENT OF REPLACEMENT

There is only one way of replacing this part:

- complete replacement.

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

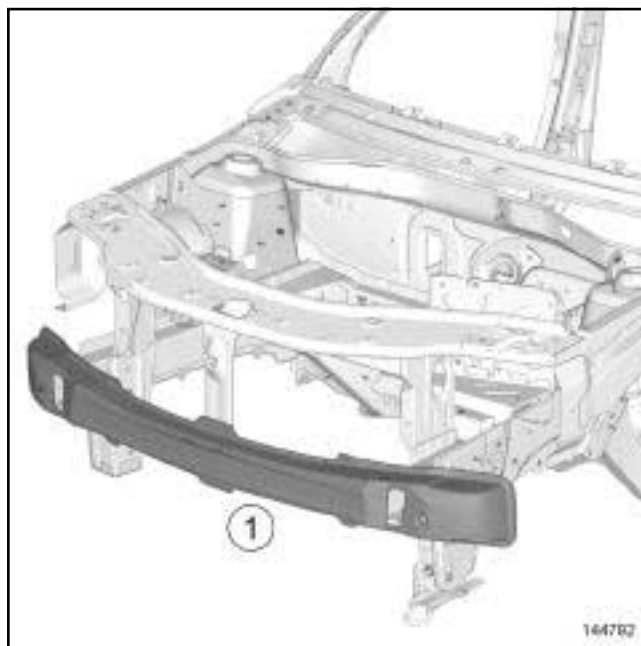
To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see **40A, General information, Earths on body: List and location of components**, page 40A-5) .

Complete replacement

Part in position



144792

FRONT LOWER STRUCTURE

Front end side cross member: Replacement

41A

I - COMPOSITION OF THE SPARE PART

No.	Description	Thickness (mm)
(1)	Front end side cross member	1.20

II - IN THE EVENT OF REPLACEMENT

There is only one way of replacing this part:

- complete replacement.

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

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

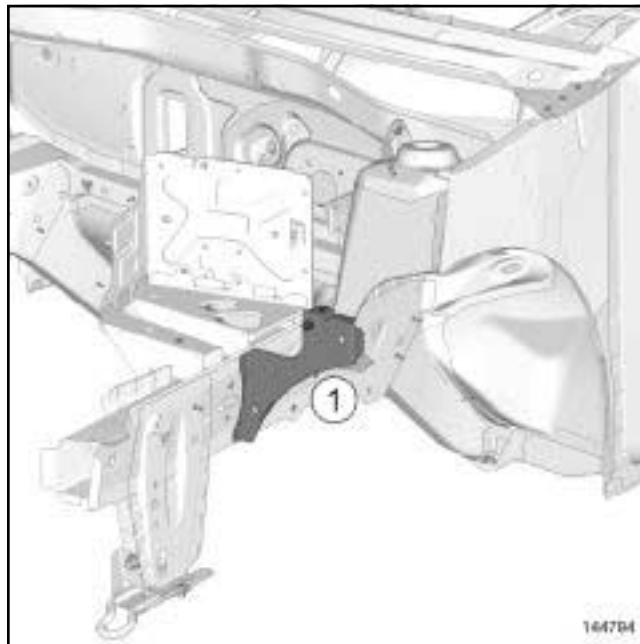
Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see **40A, General information, Earths on body: List and location of components, page 40A-5**) .

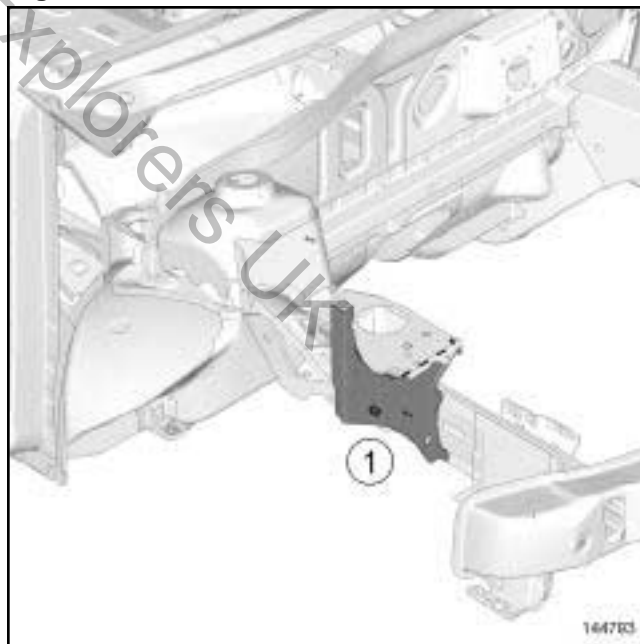
Complete replacement

Part in position

Left-hand side

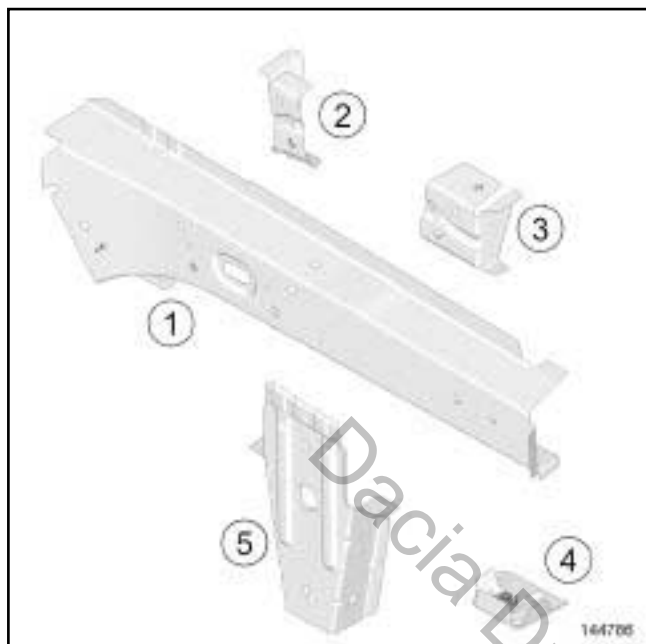


Right-hand side



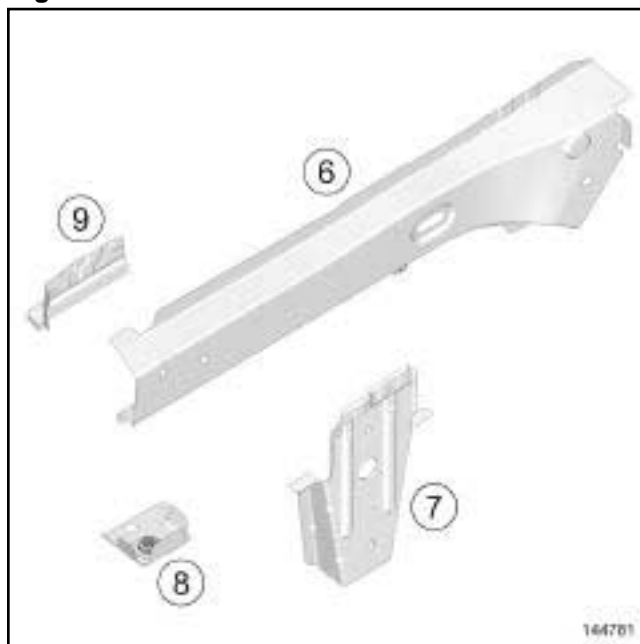
I - COMPOSITION OF THE SPARE PART

Left-hand side



No.	Description	Thickness (mm)
(1)	Front side member front section	1.25
(2)	Engine - gearbox assembly suspension rear reinforcement on body	2.5
(3)	Engine - gearbox assembly suspension front reinforcement on body	2.5
(4)	Front subframe mounting support plate	3
(5)	Front sub-frame front mounting unit	1.2

Right-hand side



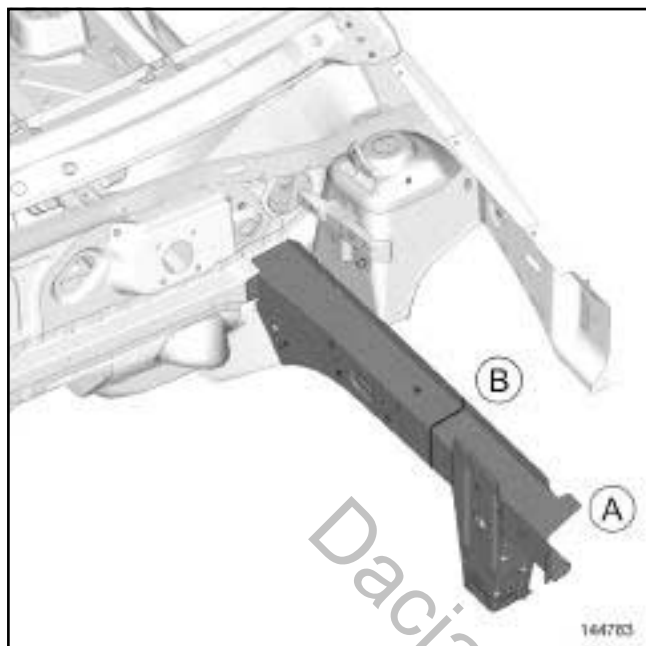
No.	Description	Thickness (mm)
(6)	Front side member front section	1.25
(7)	Front sub-frame front mounting unit	1.2
(8)	Front subframe mounting support plate	3
(9)	Front tow hitch support	2.5

II - IN THE EVENT OF REPLACEMENT

The options for replacing this part are as follows:

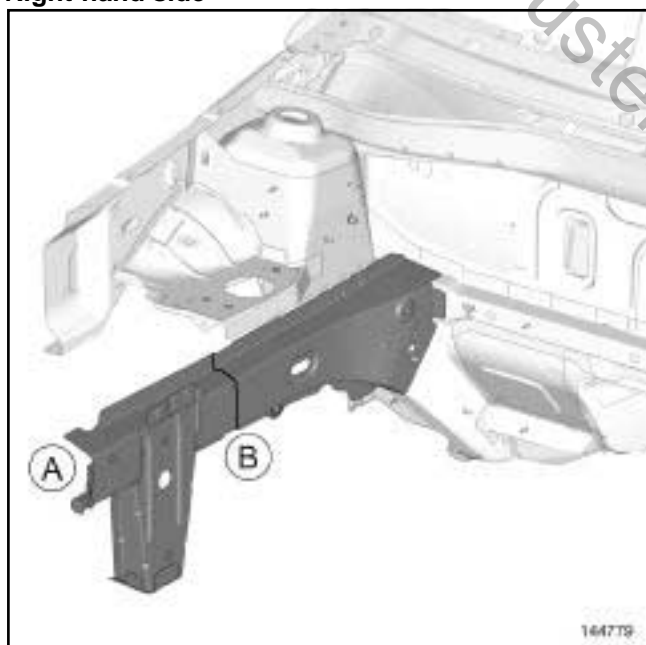
- Complete replacement
- partial replacement section A-B.

Left-hand side



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Right-hand side



144779

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

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

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see 40A, General information, Earths on body: List and location of components, page 40A-5) .

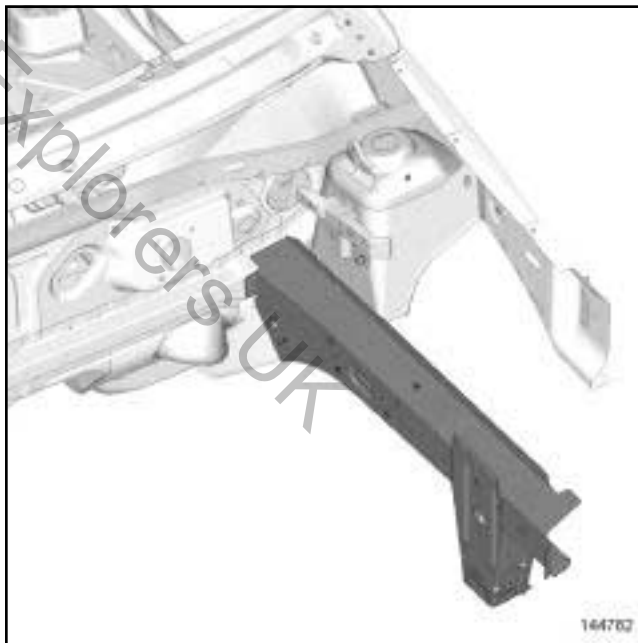
1 - Complete replacement

IMPORTANT

Use a repair bench to ensure the positioning of the points and the geometry of the axle assemblies.

Part in position

Left-hand side



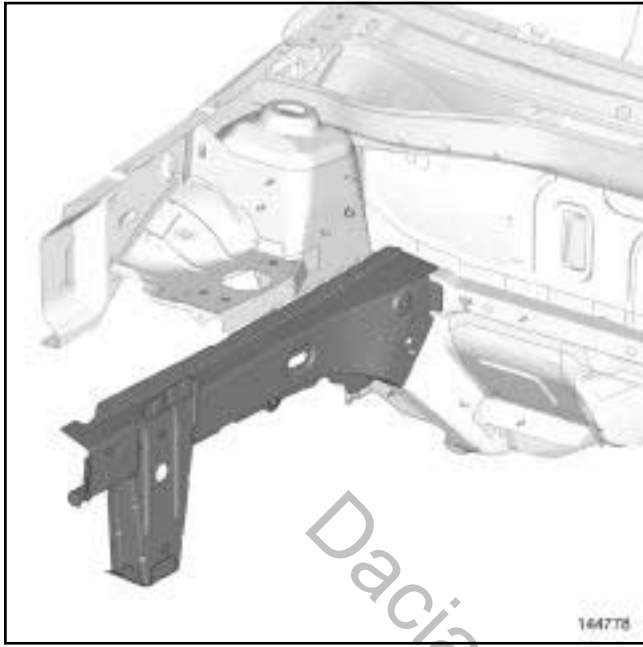
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FRONT LOWER STRUCTURE

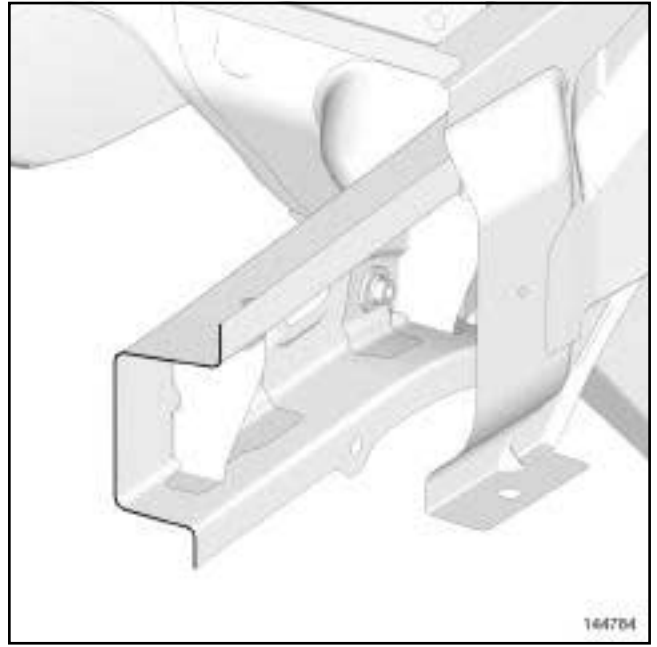
Front side member, front section: Replacement

41A

Right-hand side



Detailed view of cut B



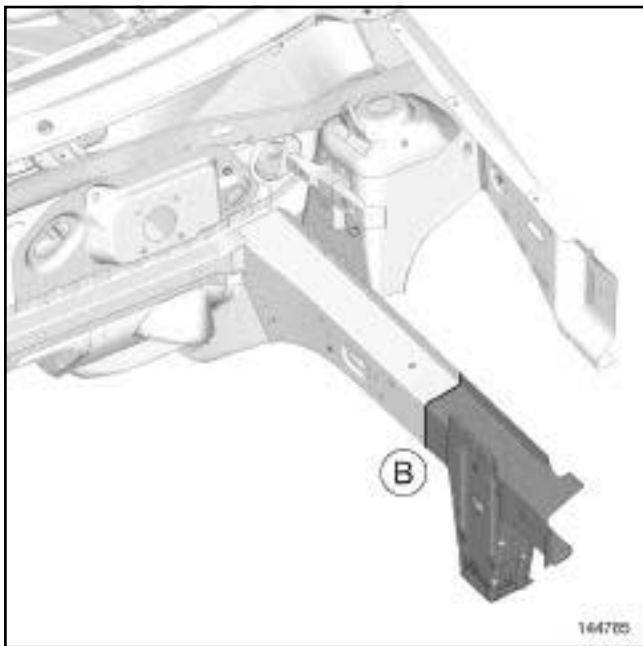
2 - Partial replacement section A-B

IMPORTANT

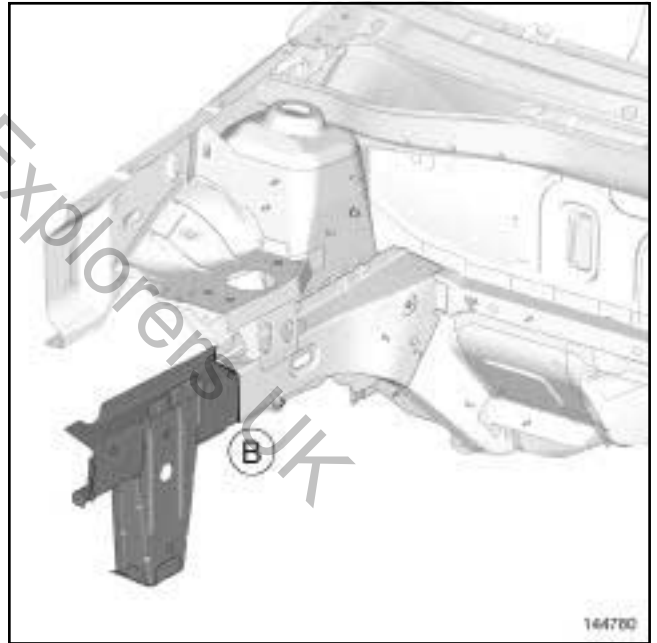
Use a repair bench to ensure the positioning of the points and the geometry of the axle assemblies.

Part in position

Left-hand side



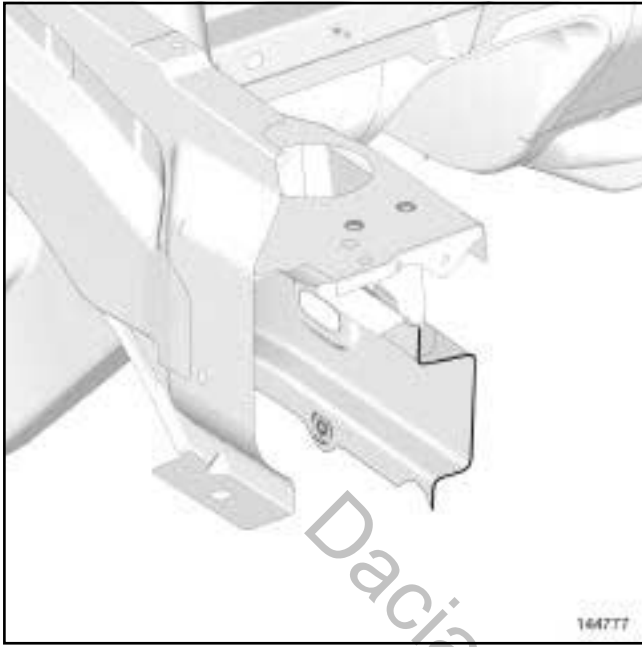
Right-hand side



FRONT LOWER STRUCTURE
Front side member, front section: Replacement

41A

Detailed view of cut B



144777

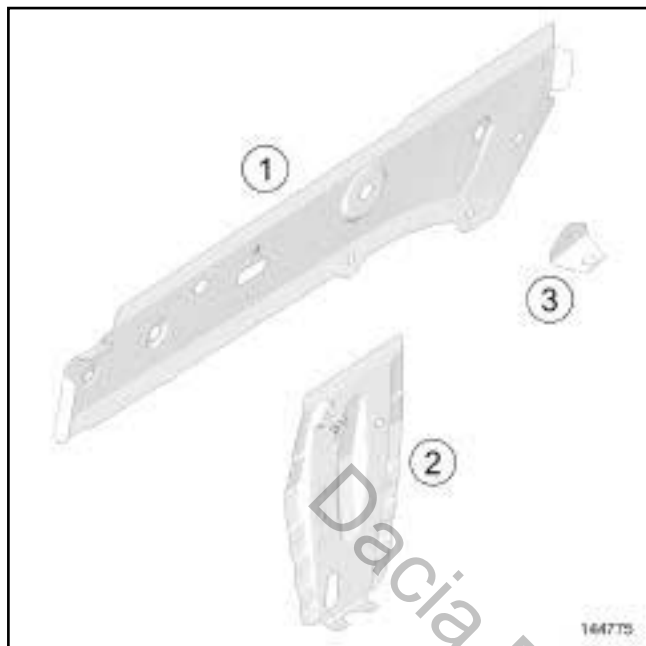
Dacia Duster Explorers UK

FRONT LOWER STRUCTURE

Front section of front side member closure panel: Replacement

41A

I - COMPOSITION OF THE SPARE PART

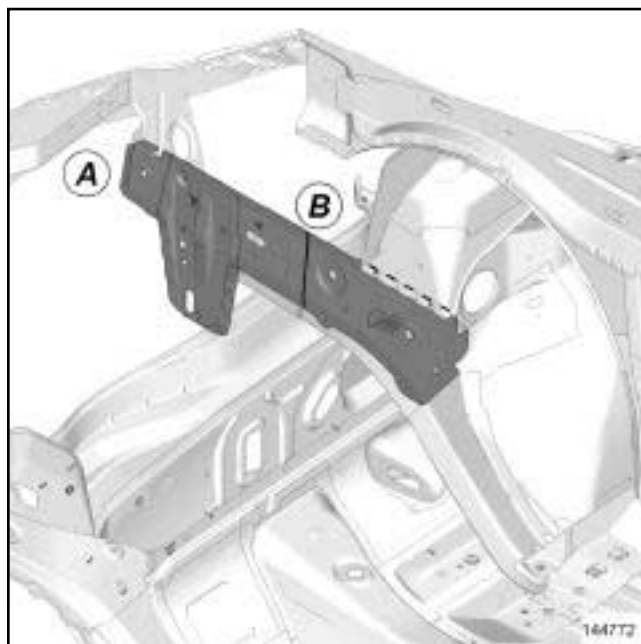


No.	Description	Thickness (mm)
(1)	Front closure panel component of front section front side member	1.25
(2)	Front subframe mounting front unit component	1.2
(3)	Brake hose stop bracket	2

II - IN THE EVENT OF REPLACEMENT

The options for replacing this part are as follows:

- Complete replacement
- partial replacement section A-B.



WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

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

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see **40A, General information, Earths on body: List and location of components, page 40A-5**) .

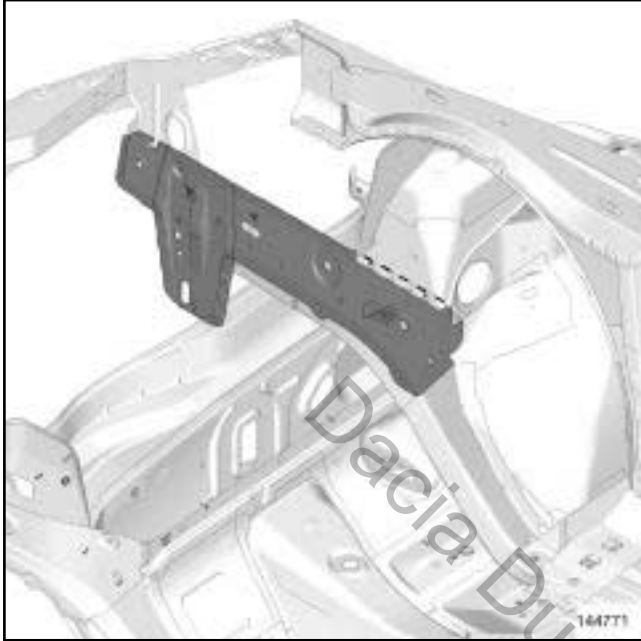
FRONT LOWER STRUCTURE

Front section of front side member closure panel: Replacement

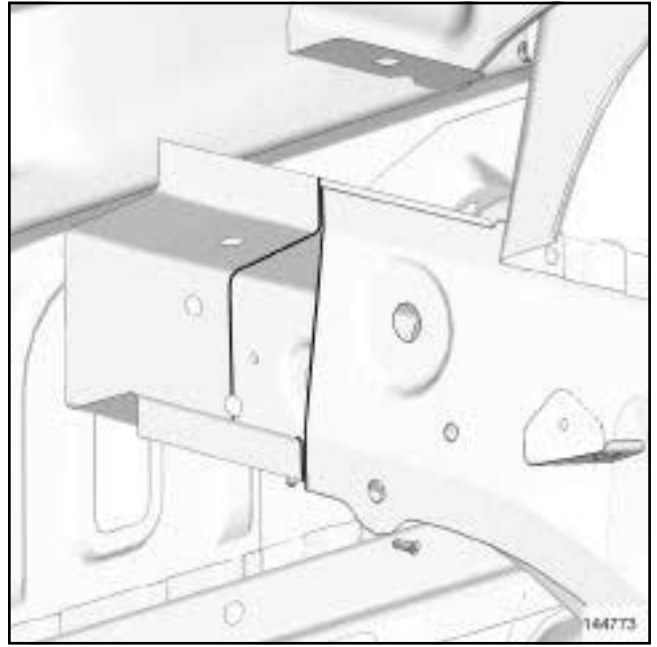
41A

1 - Complete replacement

Part in position

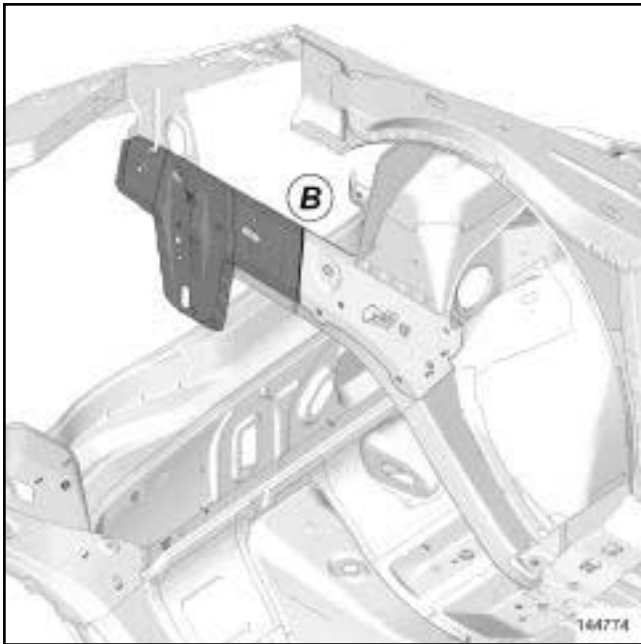


Detailed view of cut B



2 - Partial replacement section A-B

Part in position

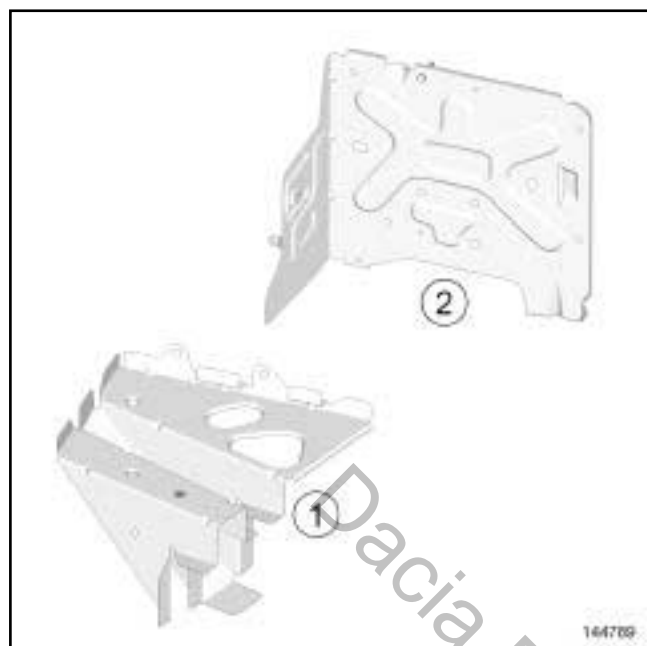


FRONT LOWER STRUCTURE

Battery tray mounting: Replacement

41A

I - COMPOSITION OF THE SPARE PART



144789

No.	Description	Thickness (mm)
(1)	Battery tray bracket	1.45
(2)	Computer mounting	0.95

II - IN THE EVENT OF REPLACEMENT

There is only one way of replacing this part:

- complete replacement.

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

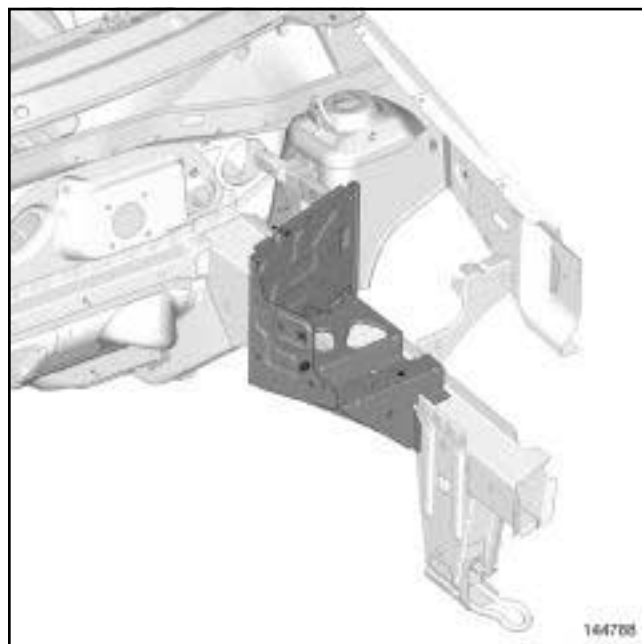
To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see **40A, General information, Earths on body: List and location of components**, page **40A-5**).

Complete replacement

Part in position



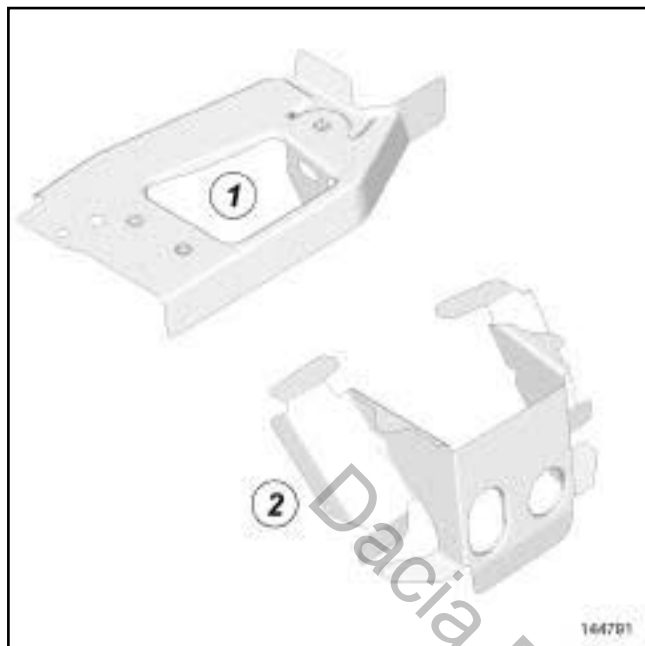
144788

FRONT LOWER STRUCTURE

Engine mounting: Replacement

41A

I - COMPOSITION OF THE SPARE PART



No.	Description	Thickness (mm)
(1)	Right-hand mounting plate for engine - gearbox assembly support on body	2.5
(2)	Right-hand engine - gearbox assembly suspension support on body	2.5

II - IN THE EVENT OF REPLACEMENT

There is only one way of replacing this part:

- complete replacement.

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

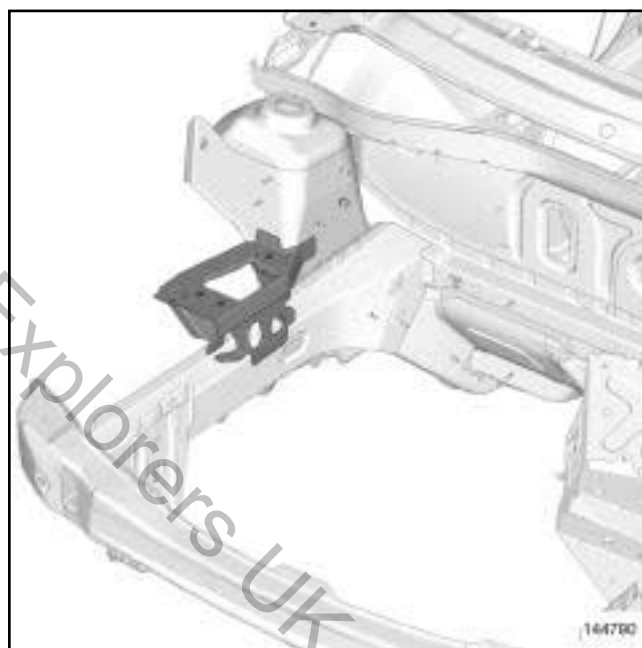
To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see 40A, General information, Earths on body: List and location of components, page 40A-5) .

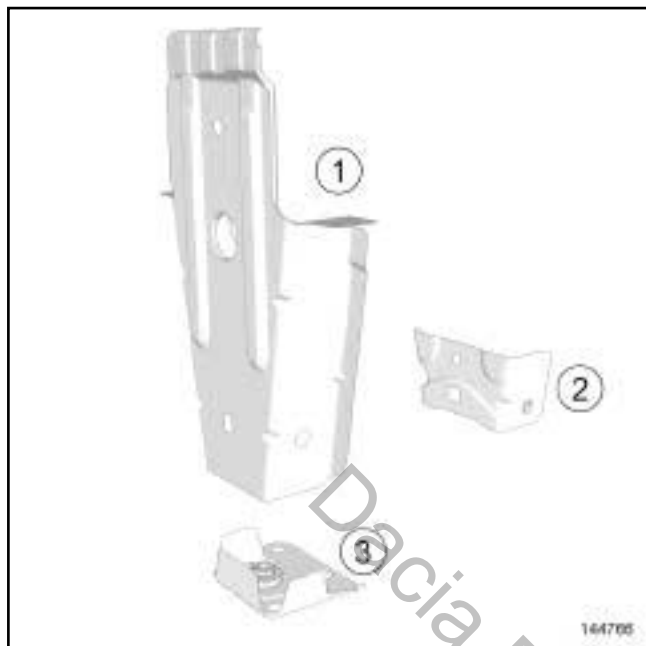
Complete replacement

Part in position



144790

I - COMPOSITION OF THE SPARE PART



144766

No.	Description	Thickness (mm)
(1)	Front subframe front mounting unit	1.2
(2)	Front towing eye mounting reinforcement	2.5
(3)	Front subframe mounting support plate	3

II - IN THE EVENT OF REPLACEMENT

There is only one way of replacing this part:

- complete replacement.

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

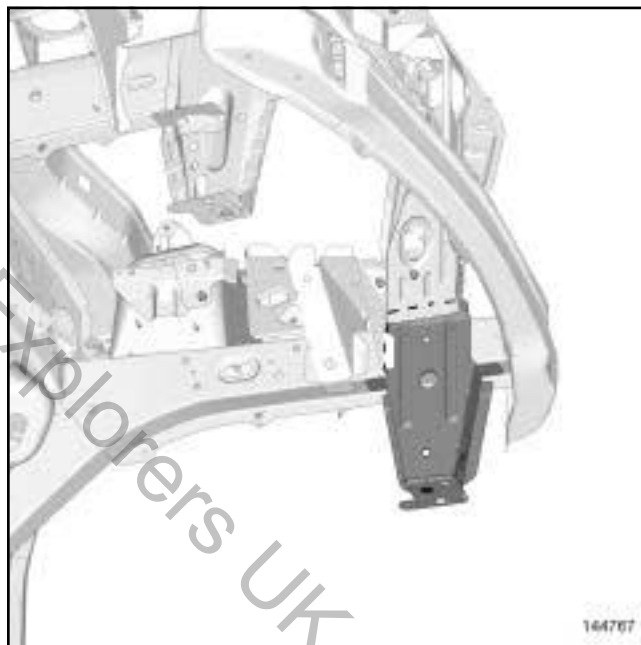
To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see 40A, General information, Earths on body: List and location of components, page 40A-5) .

Complete replacement

Part in position



144767

144767

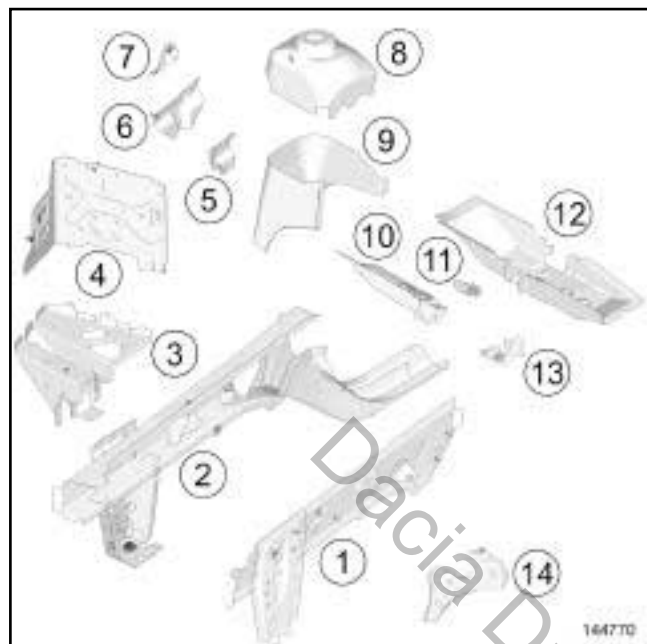
FRONT LOWER STRUCTURE

Front half-unit: Replacement

41A

I - COMPOSITION OF THE SPARE PART

Left-hand side



144770

No.	Description	Thickness (mm)
(1)	Front section of front side member closure panel	1.2/1.25
(2)	Front left-hand side member	1.2/3
(3)	Battery tray bracket on body	1.8
(4)	Computer mounting	0.95
(5)	Gas tank mounting impact reinforcement	1.5
(6)	Gas tank mounting on subframe	1.4
(7)	Bonnet left-hand strut mounting reinforcement	1.5
(8)	Front left-hand shock absorber cup	2.5
(9)	Front left-hand shock absorber cup height adjuster	1.2
(10)	Rear left-hand unit of front subframe mounting	1.95

No.	Description	Thickness (mm)
(11)	Centre floor front left-hand rear mounting reinforcement	0.95
(12)	Centre floor front left-hand side cross member	0.95
(13)	Rear exterior unit of front axle subframe mounting	1.7
(14)	Front end side cross member	1.2

Right-hand side



144769

No.	Description	Thickness (mm)
(15)	Engine stand	2.5
(16)	Front right-hand side member	1.2/3
(17)	Front section of front side member closure panel	1.2/1.25
(18)	Front end side cross member	1.2
(19)	Front wheel arch	1.2
(20)	Front shock absorber cup height adjuster	2.5

FRONT LOWER STRUCTURE

Front half-unit: Replacement

41A

No.	Description	Thickness (mm)
(21)	Front shock absorber cup	2.5
(22)	Centre floor front right-hand side cross member	0.95
(23)	Rear exterior unit of front axle subframe mounting	1.7
(24)	Front subframe rear right-hand mounting reinforcement	0.95
(25)	Rear right-hand unit of front subframe mounting	1.95

II - IN THE EVENT OF REPLACEMENT

There is only one way of replacing this part:

- complete replacement.

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

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

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see **40A, General information, Earths on body: List and location of components**, page 40A-5) .

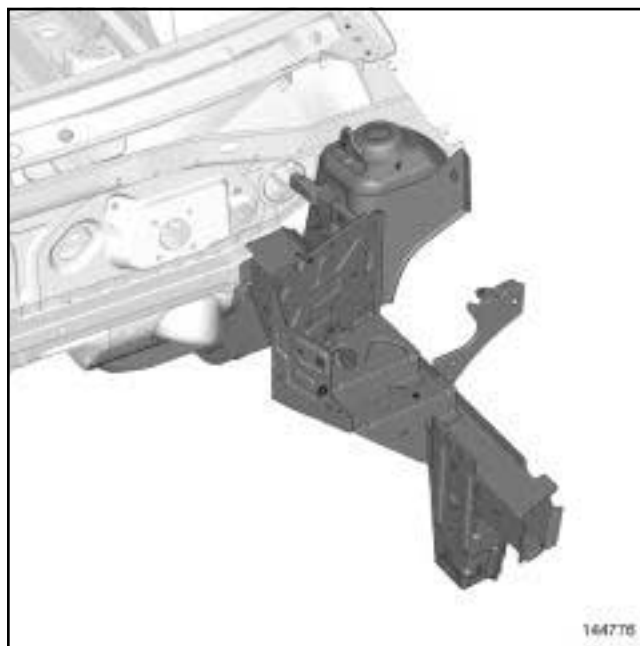
Complete replacement

IMPORTANT

Use a repair bench to ensure the positioning of the points and the geometry of the axle assemblies.

Part in position

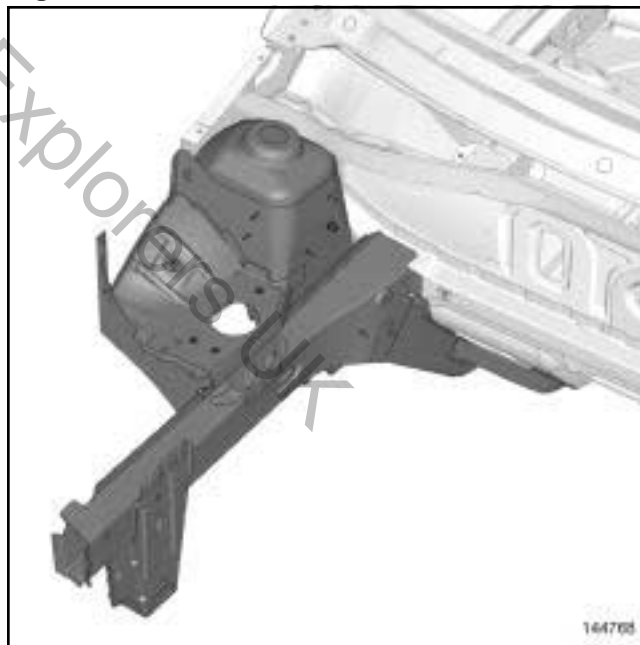
Left-hand side



144776

144776

Right-hand side



144768

144768

CENTRE LOWER STRUCTURE

Centre floor, side section: Replacement

41B

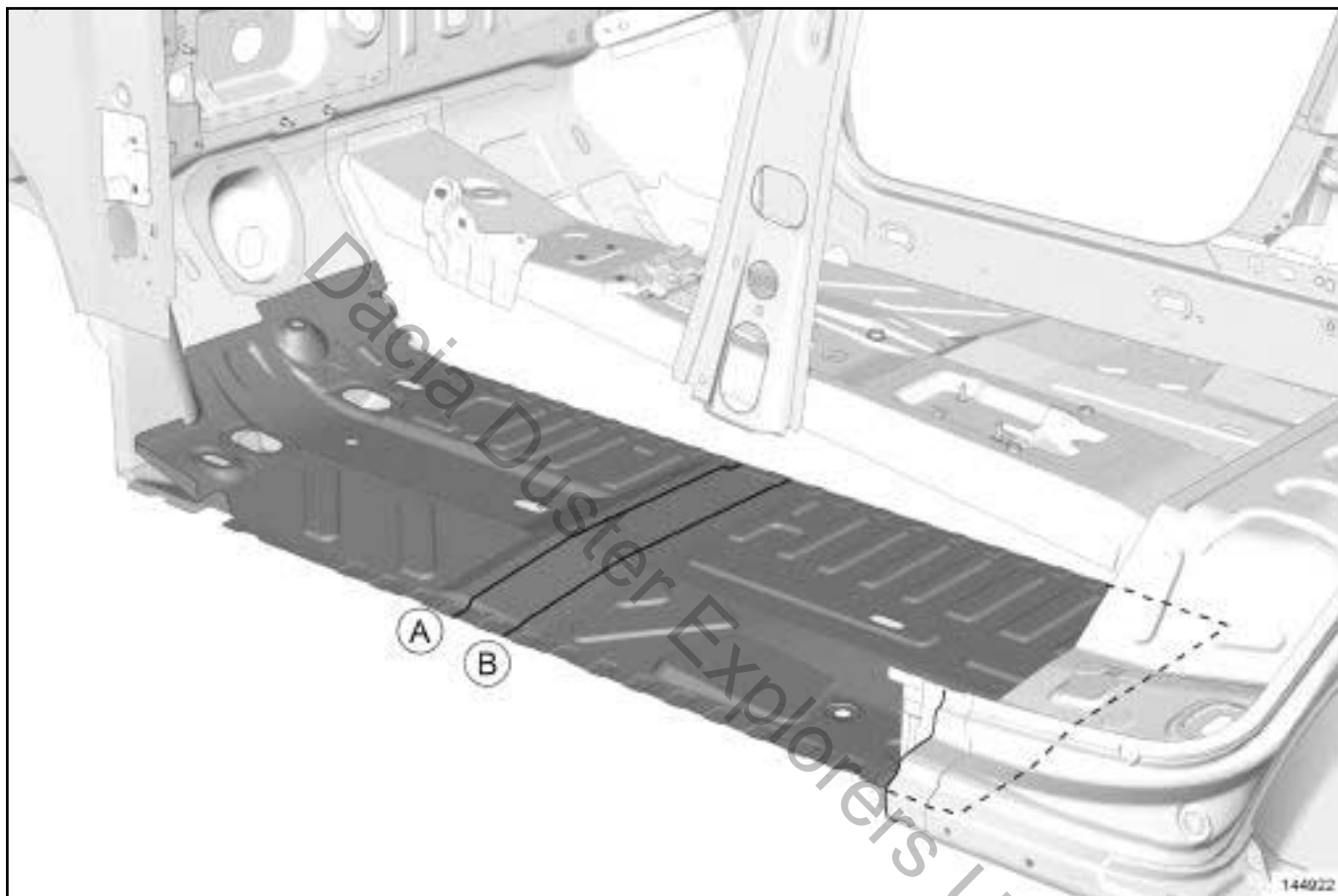
I - COMPOSITION OF THE SPARE PART

No.	Description	Thickness (mm)
(1)	Centre floor, side section	0.6

II - IN THE EVENT OF REPLACEMENT

The options for replacing this part are as follows:

- Complete replacement
- partial replacement along cut A,
- partial replacement along cut B.



WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

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

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

144922
Locate the earths located near to the weld area (see **40A, General information, Earths on body: List and location of components**, page 40A-5) .

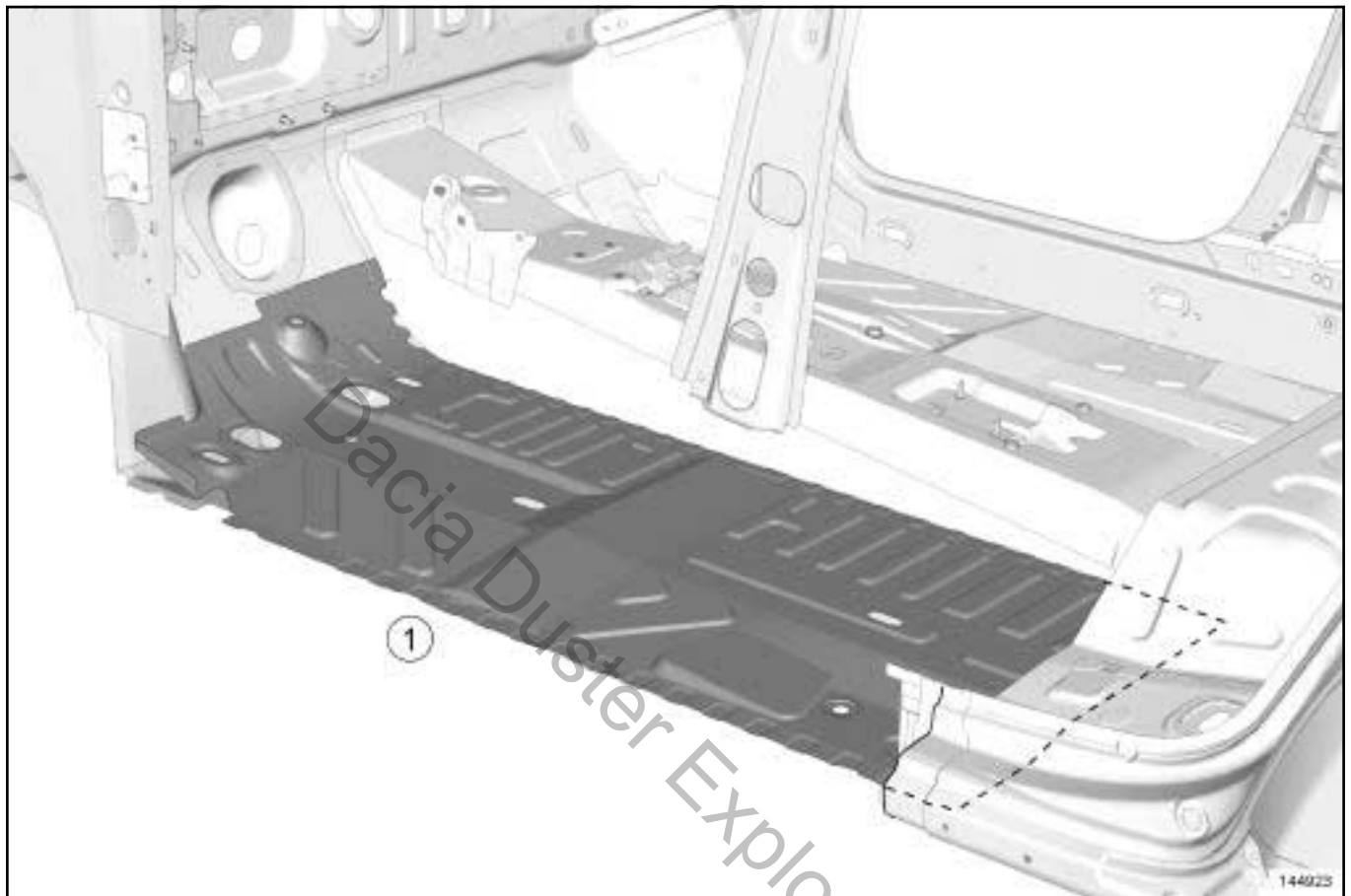
CENTRE LOWER STRUCTURE

Centre floor, side section: Replacement

41B

1 - Complete replacement

Part in position



144923

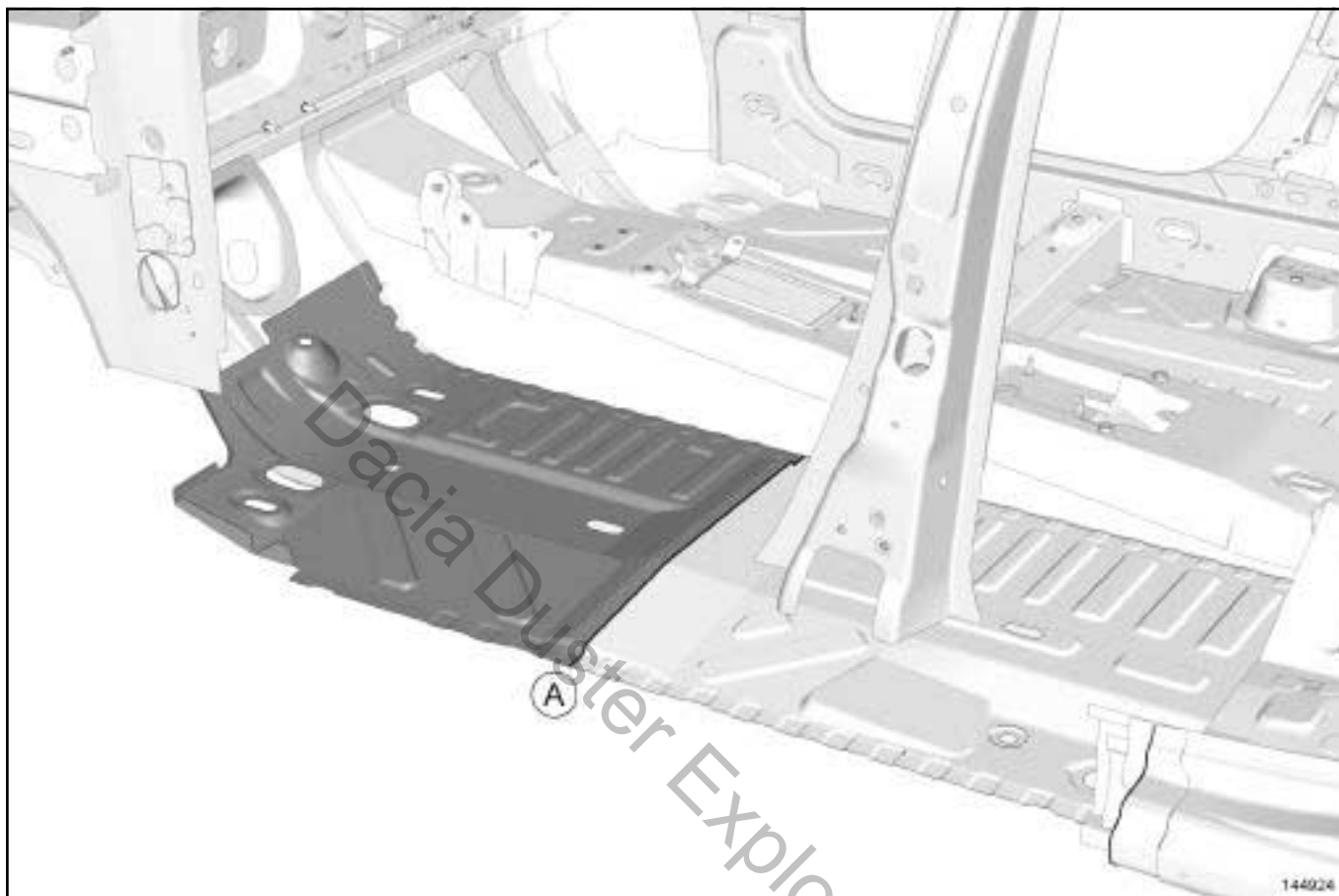
CENTRE LOWER STRUCTURE

Centre floor, side section: Replacement

41B

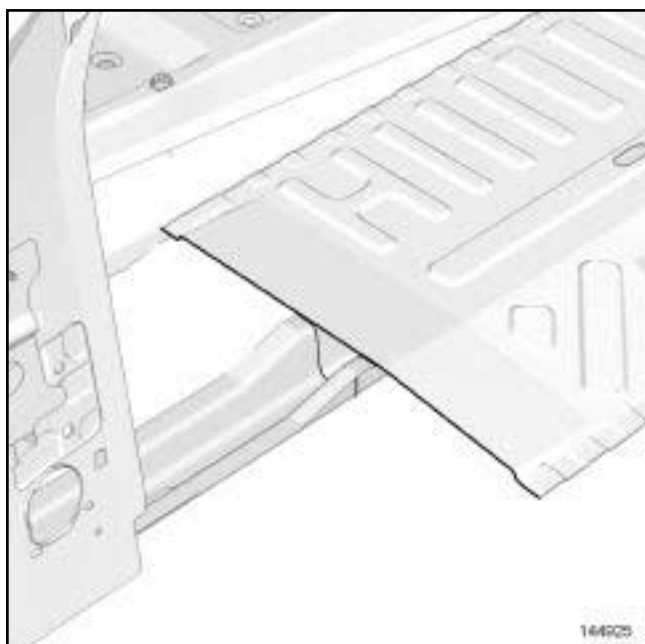
2 - Partial replacement along cut A

Part in position



144924

Detailed view A



144925

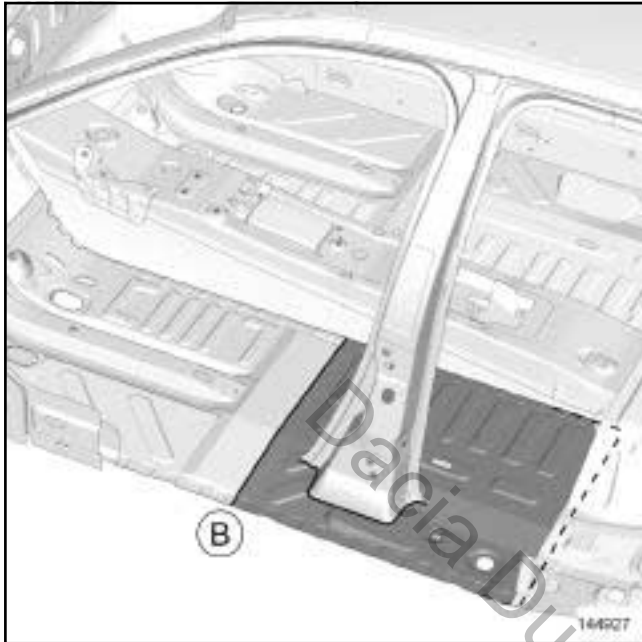
CENTRE LOWER STRUCTURE

Centre floor, side section: Replacement

41B

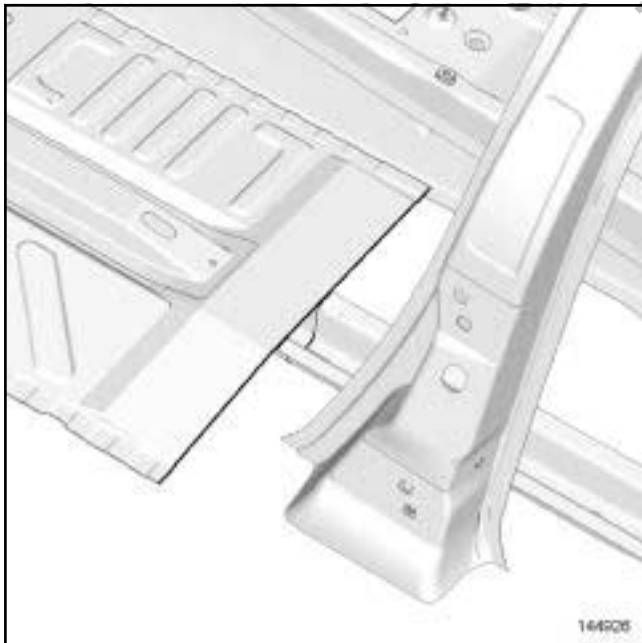
3 - Partial replacement along cut B

Part in position



144927

Detailed view B



144926

CENTRE LOWER STRUCTURE

Centre side member: Replacement

41B

I - COMPOSITION OF THE SPARE PART

No.	Description	Thickness (mm)
(1)	Centre side member	1.95

II - IN THE EVENT OF REPLACEMENT

There is only one way of replacing this part:

- complete replacement.

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

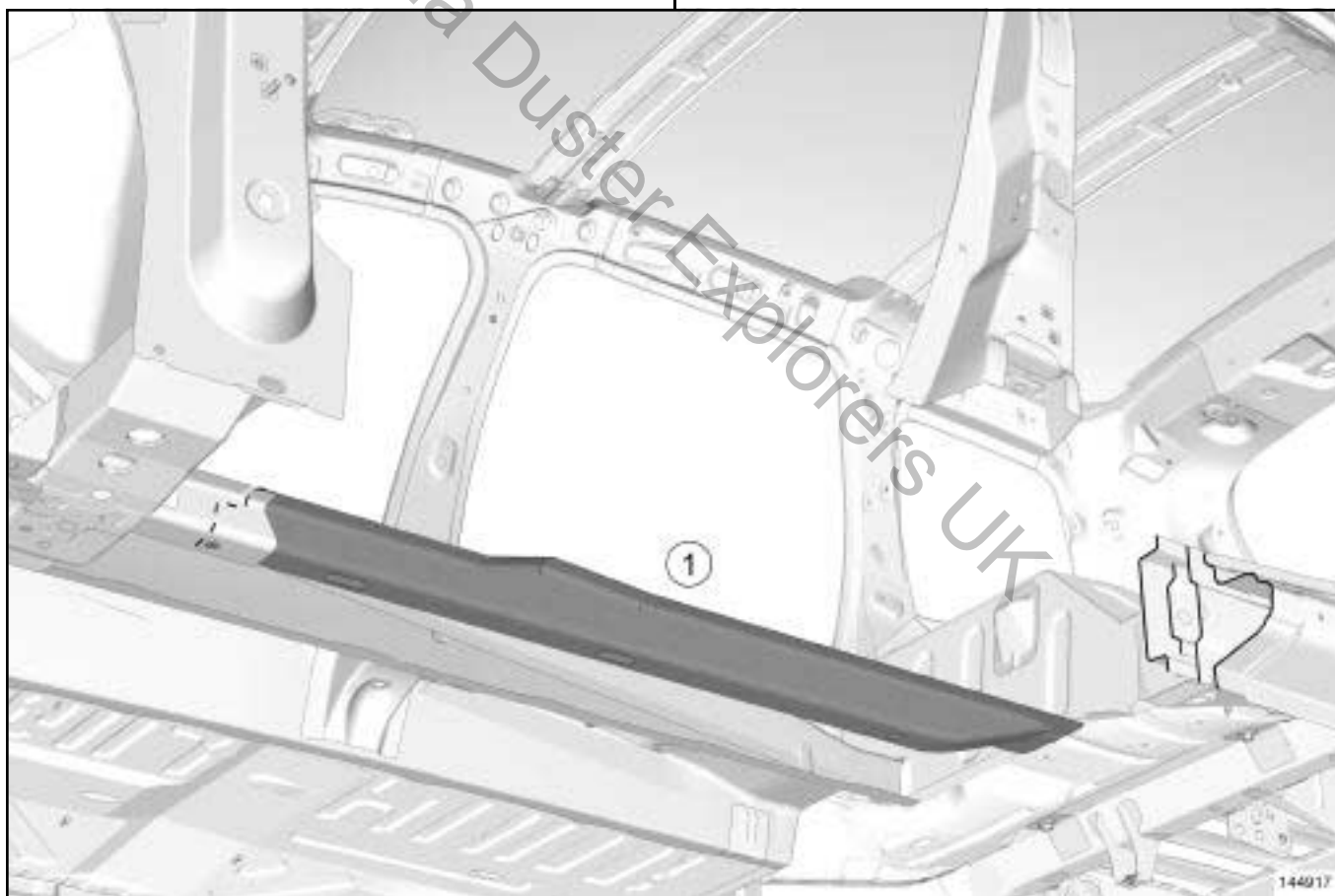
To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see **40A, General information, Earths on body: List and location of components**, page 40A-5) .

Complete replacement

Part in position



144917

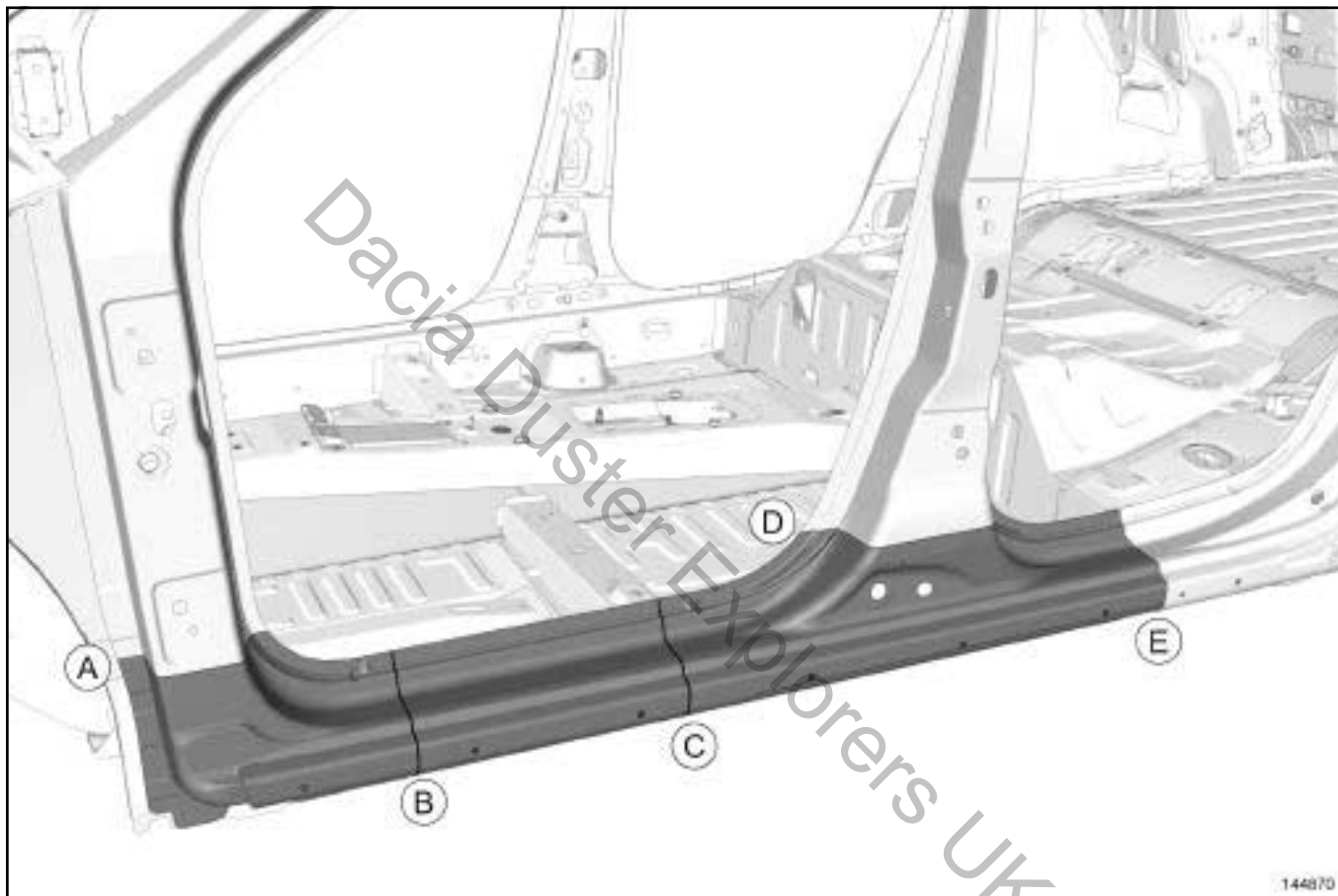
I - COMPOSITION OF THE SPARE PART

No.	Description	Thickness (mm)
(1)	Sill panel	0.95

II - IN THE EVENT OF REPLACEMENT

The options for replacing this part are as follows:

- complete replacement A-D-E,
- partial replacement of front end section A-C,
- partial replacement under door B-C,
- partial replacement B-D-E.



144870

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

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

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see **40A, General information, Earths on body: List and location of components, page 40A-5**) .

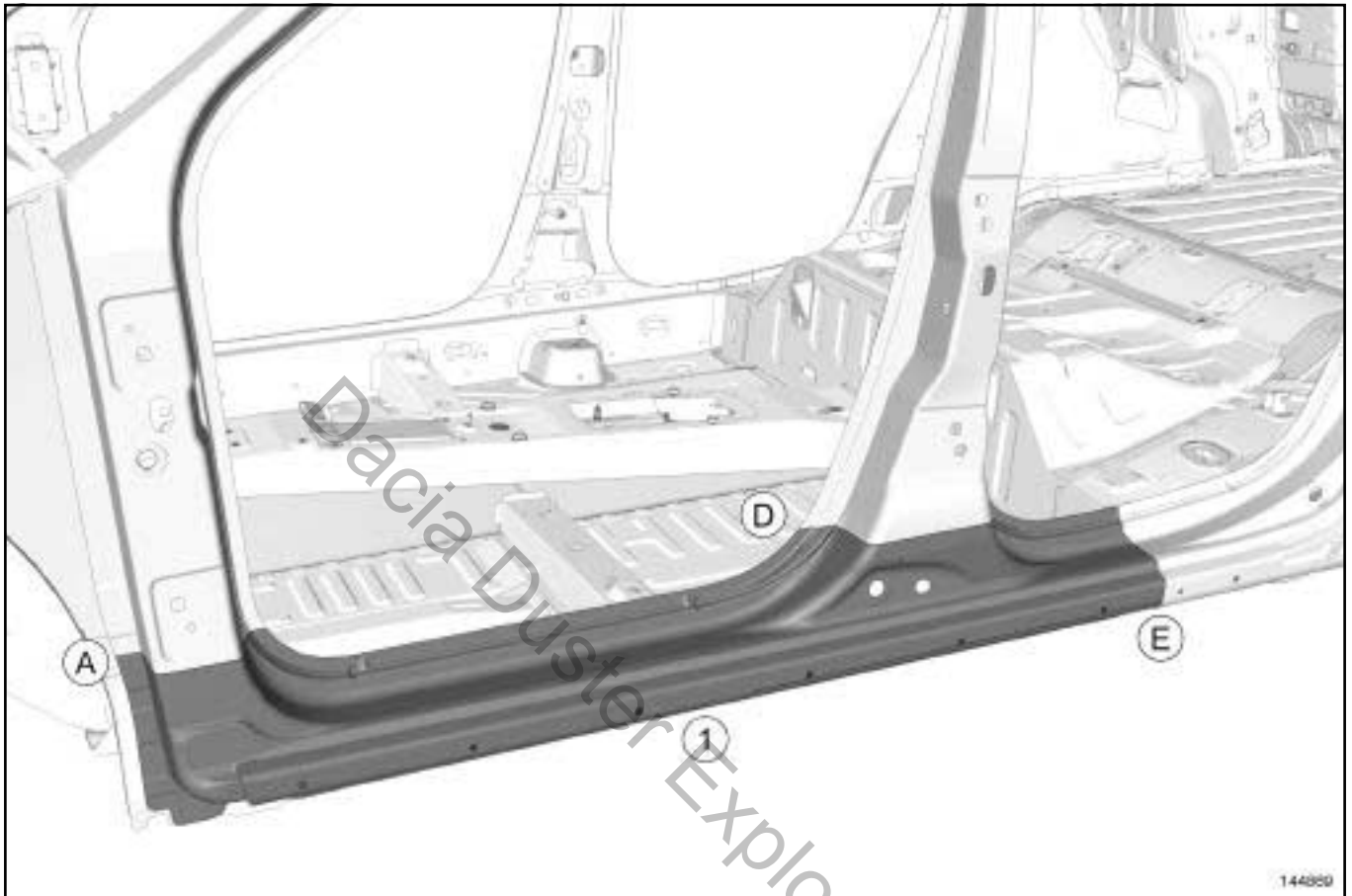
SIDE LOWER STRUCTURE

Sill panel: Replacement

41C

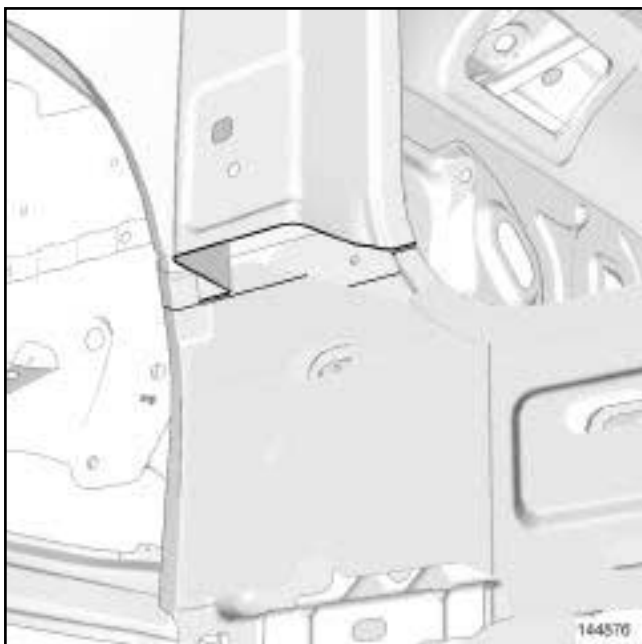
1 - Complete replacement A-D-E

Part in position



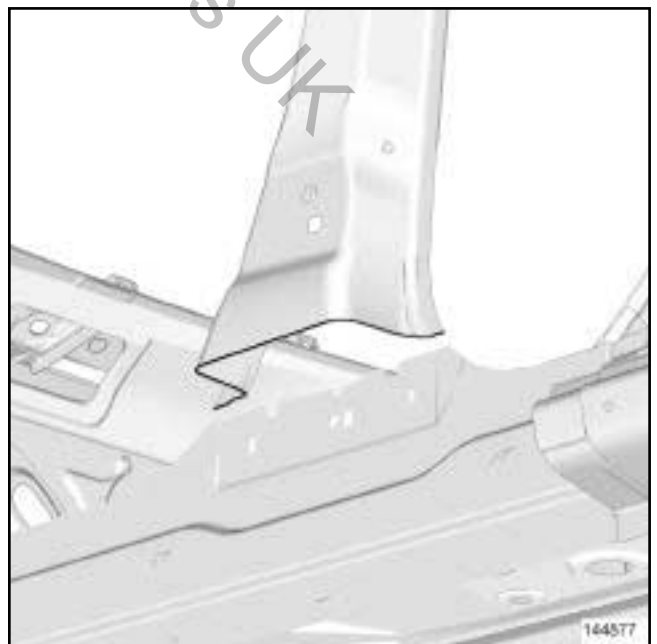
144869

Detailed view A



144876

Detailed view D



144877

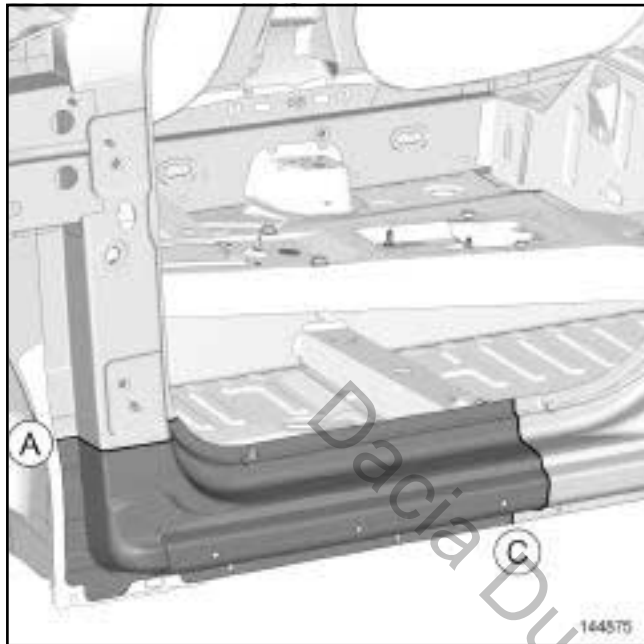
SIDE LOWER STRUCTURE

Sill panel: Replacement

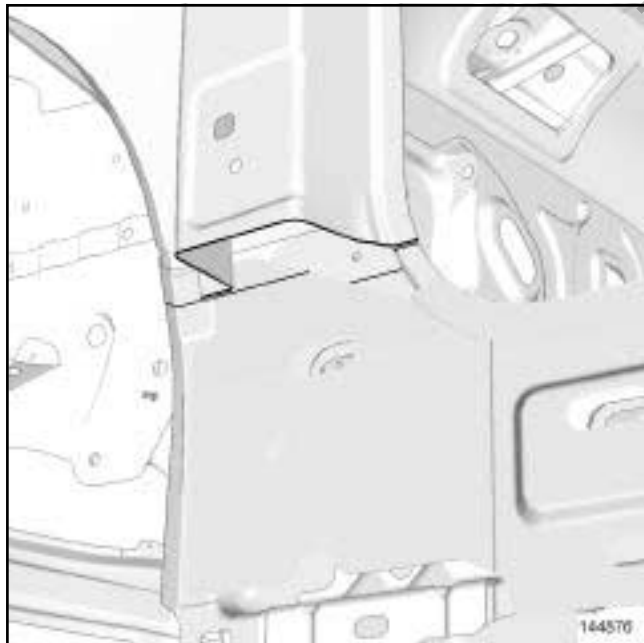
41C

2 - Partial replacement of front end section A-C

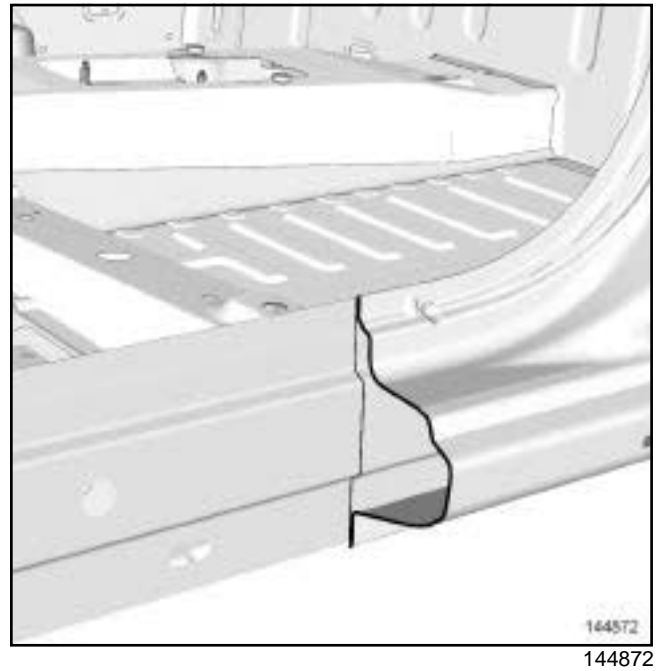
Part in position



Detailed view A

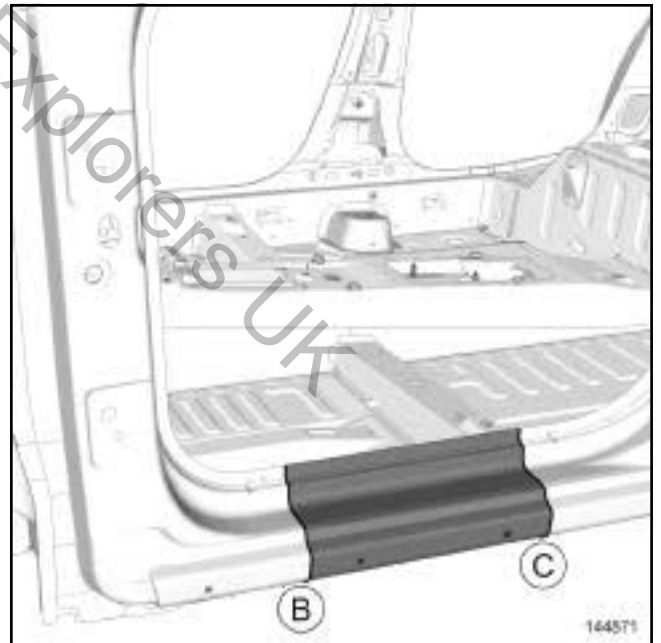


Detailed view C



3 - Partial replacement section under door B-C

Part in position

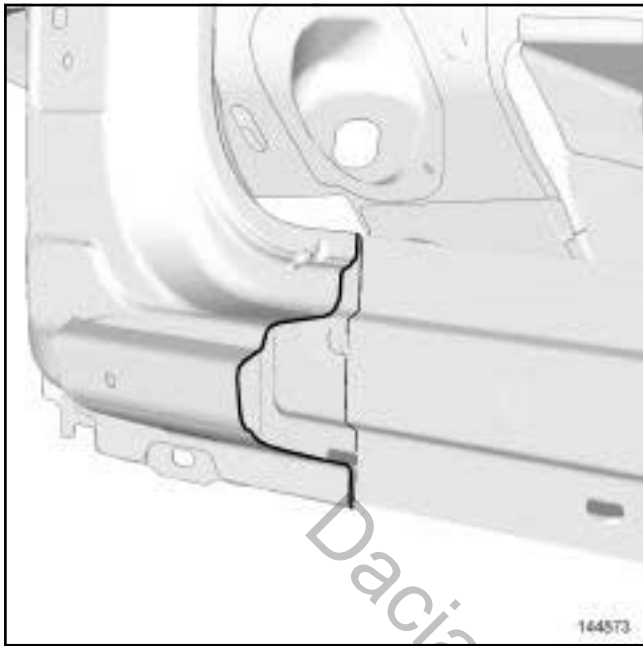


SIDE LOWER STRUCTURE

Sill panel: Replacement

41C

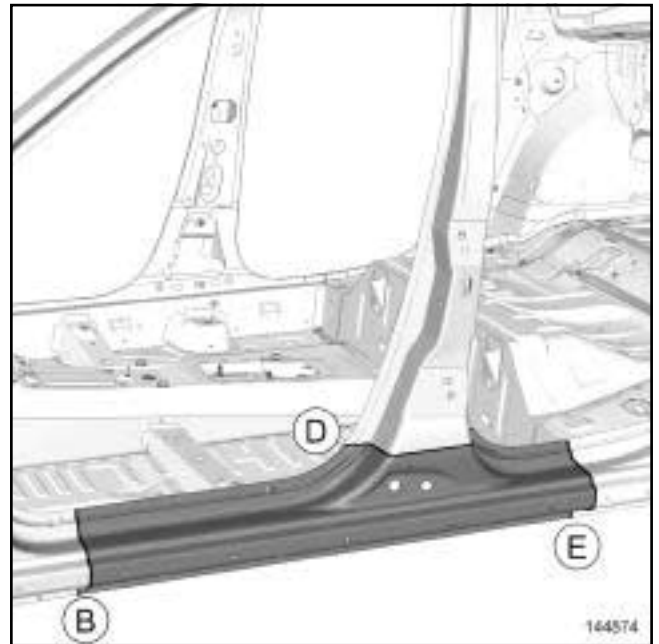
Detailed view B



144873

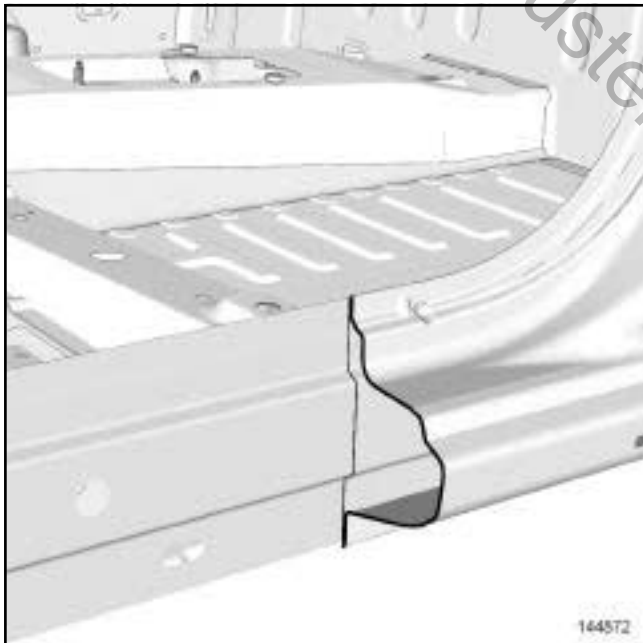
4 - Partial replacement B-D-E

Part in position



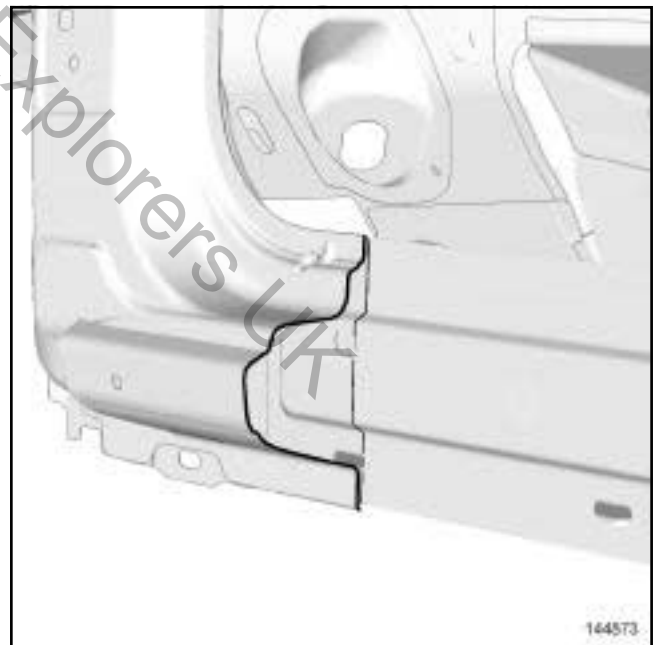
144874

Detailed view C



144872

Detailed view B



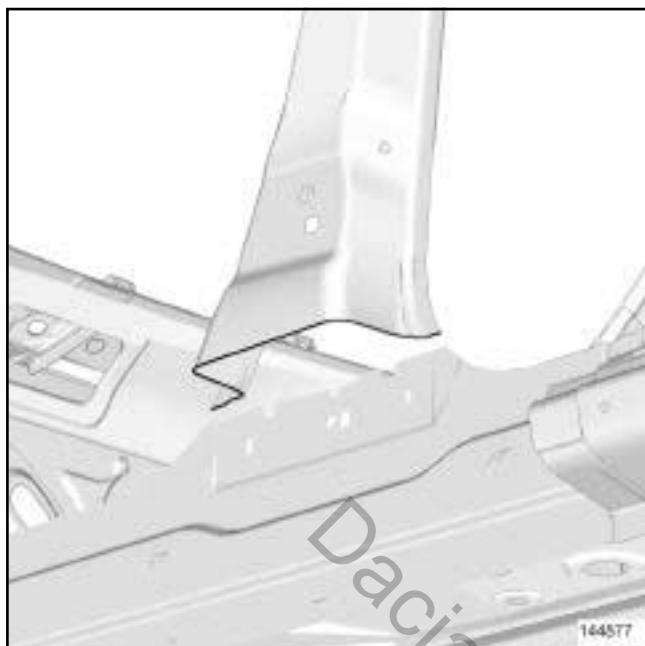
144873

SIDE LOWER STRUCTURE

Sill panel: Replacement

41C

Detailed view D



144877

Dacia Duster Explorers UK

SIDE LOWER STRUCTURE

Sill panel closure panel: Replacement

41C

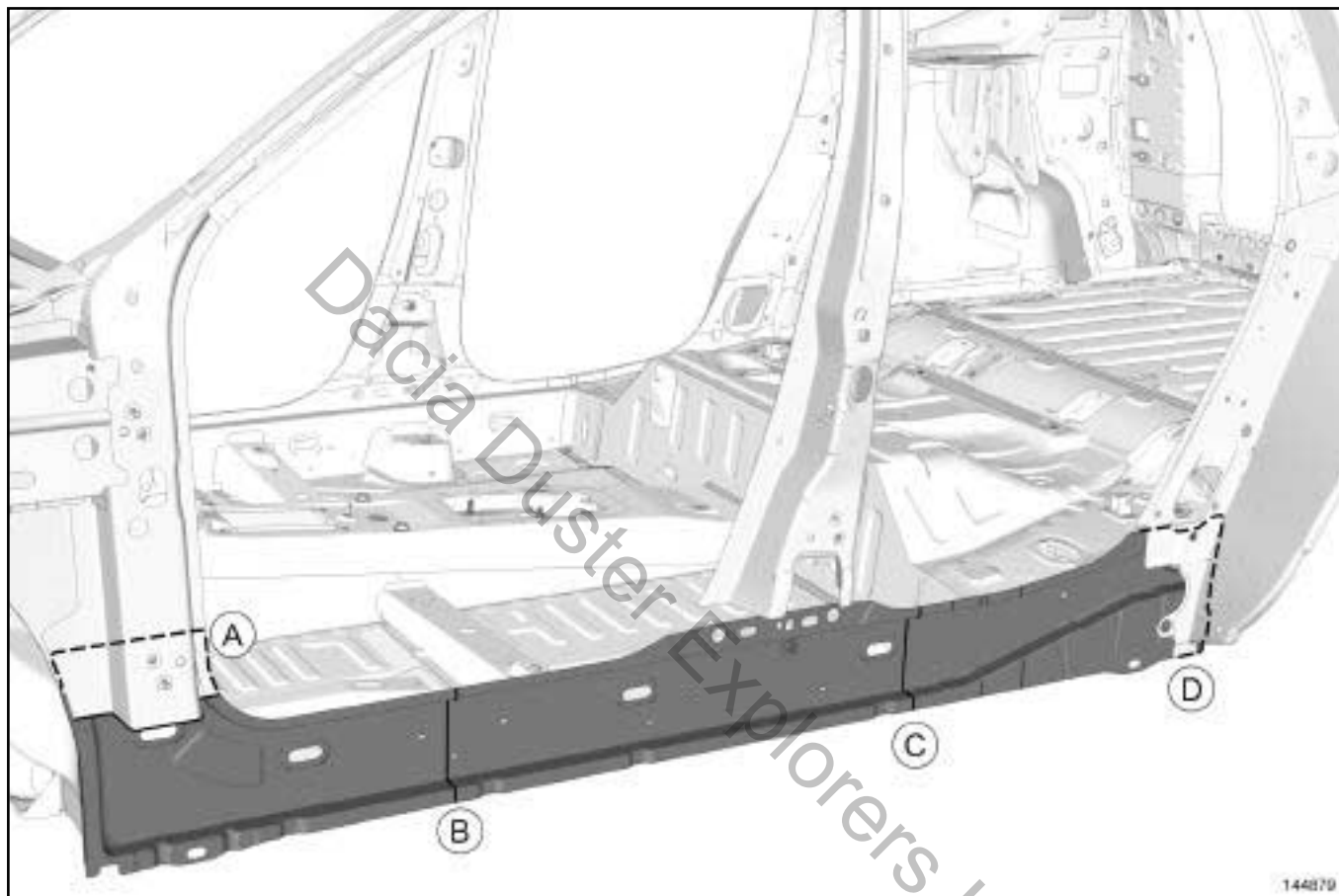
I - COMPOSITION OF THE SPARE PART

No.	Description	Thickness (mm)
(1)	Sill panel closure panel	1.3

II - IN THE EVENT OF REPLACEMENT

The options for replacing this part are as follows:

- complete replacement A-D,
- front section partial replacement A-C,
- rear section partial replacement B-D.



144879

144879

Locate the earths located near to the weld area (see **40A, General information, Earths on body: List and location of components**, page 40A-5) .

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

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

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

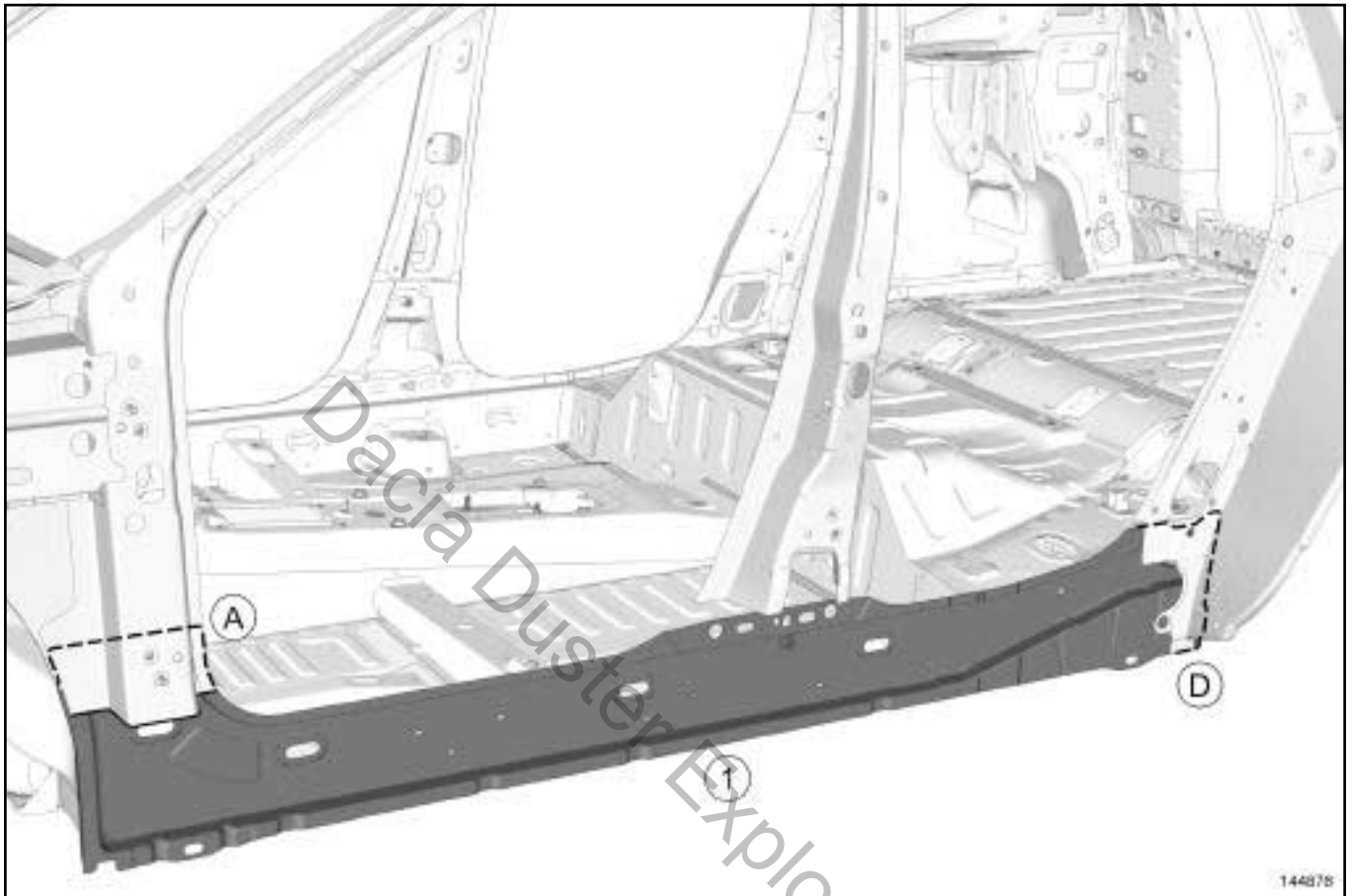
SIDE LOWER STRUCTURE

Sill panel closure panel: Replacement

41C

1 - Complete replacement A-D

Part in position



144878

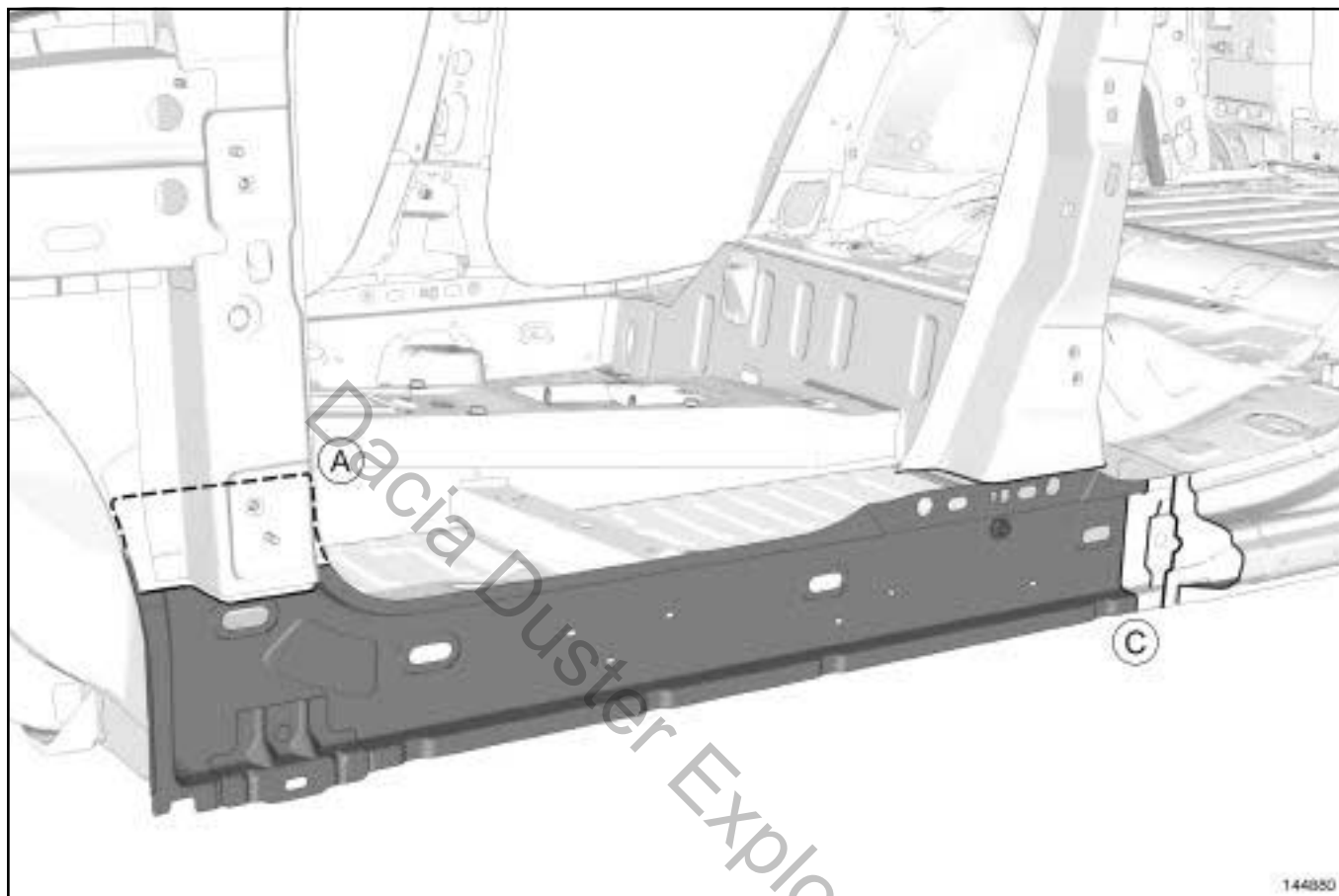
SIDE LOWER STRUCTURE

Sill panel closure panel: Replacement

41C

2 - Front section partial replacement A-C

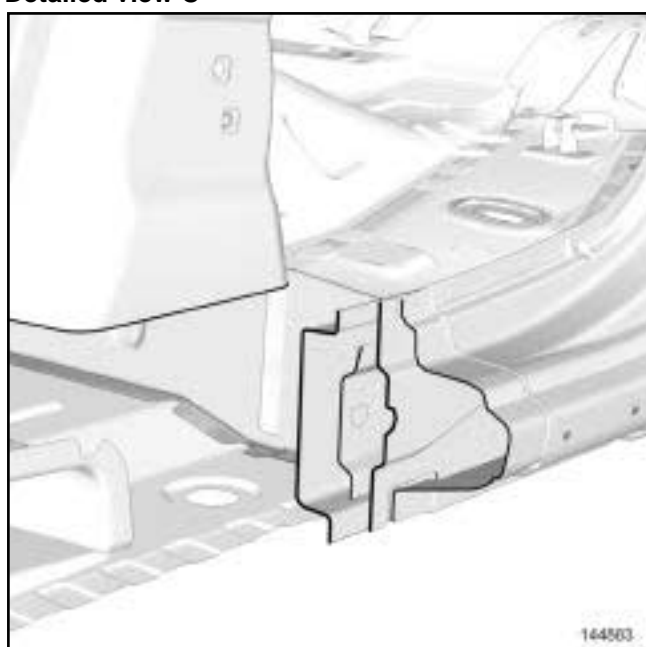
Part in position



144880

144880

Detailed view C



144883

144883

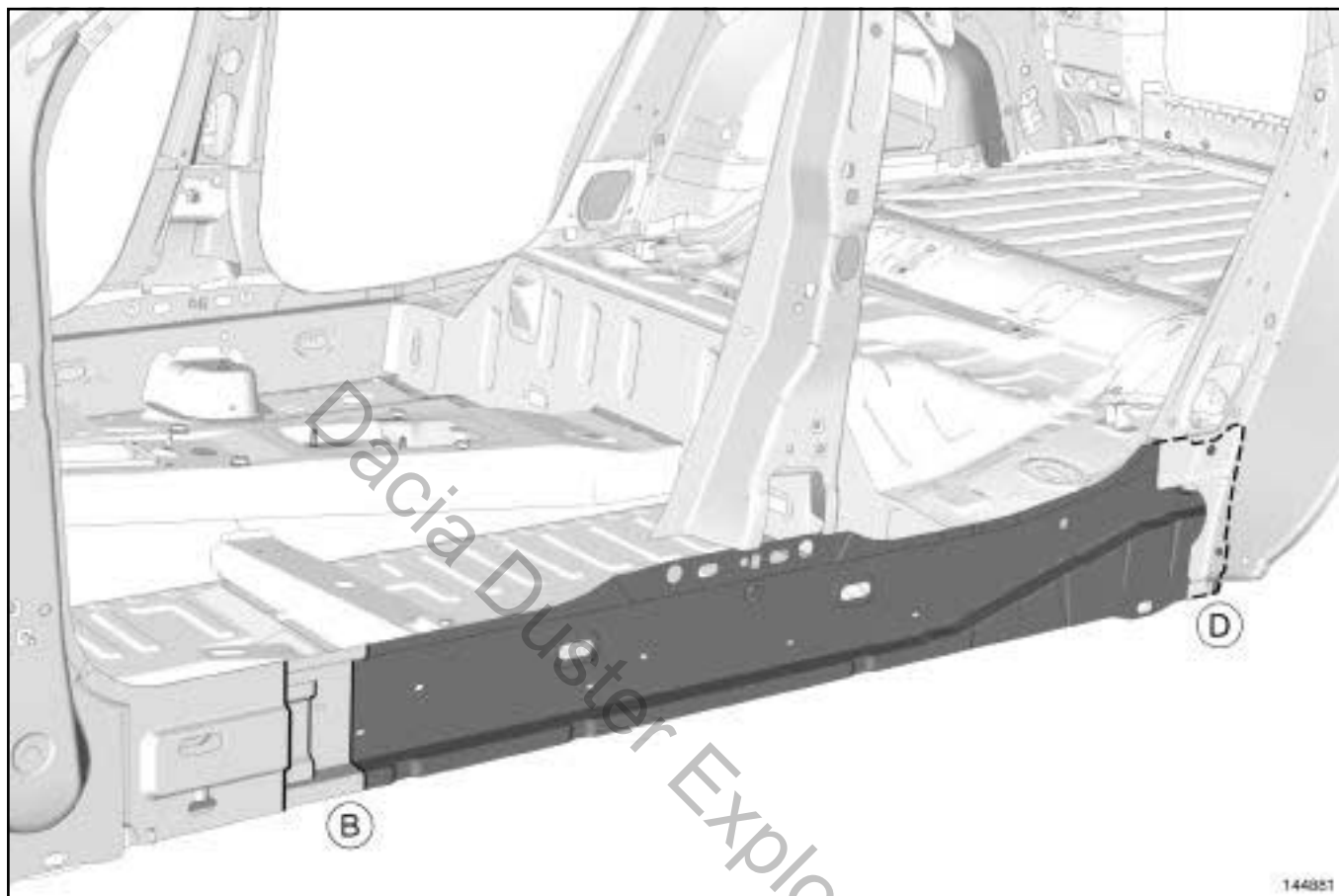
SIDE LOWER STRUCTURE

Sill panel closure panel: Replacement

41C

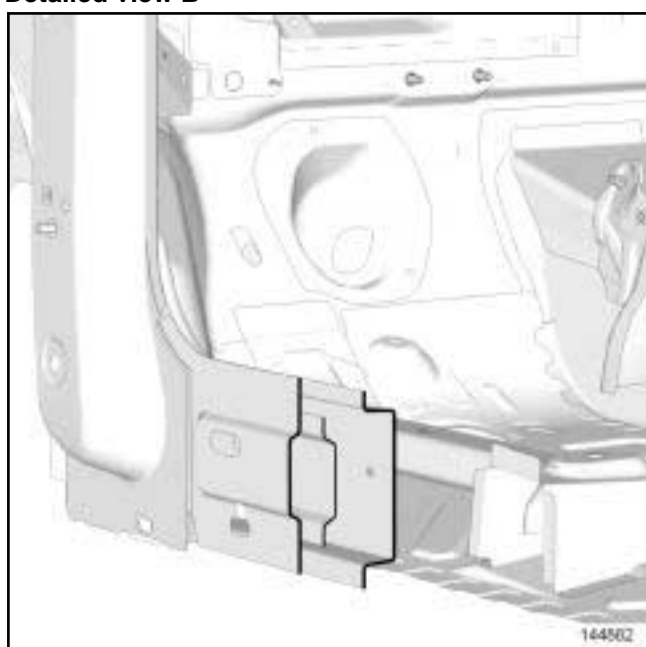
3 - Rear section partial replacement B-D

Part in position



144881

Detailed view B



144882

SIDE LOWER STRUCTURE

Sill panel reinforcement: Replacement

41C

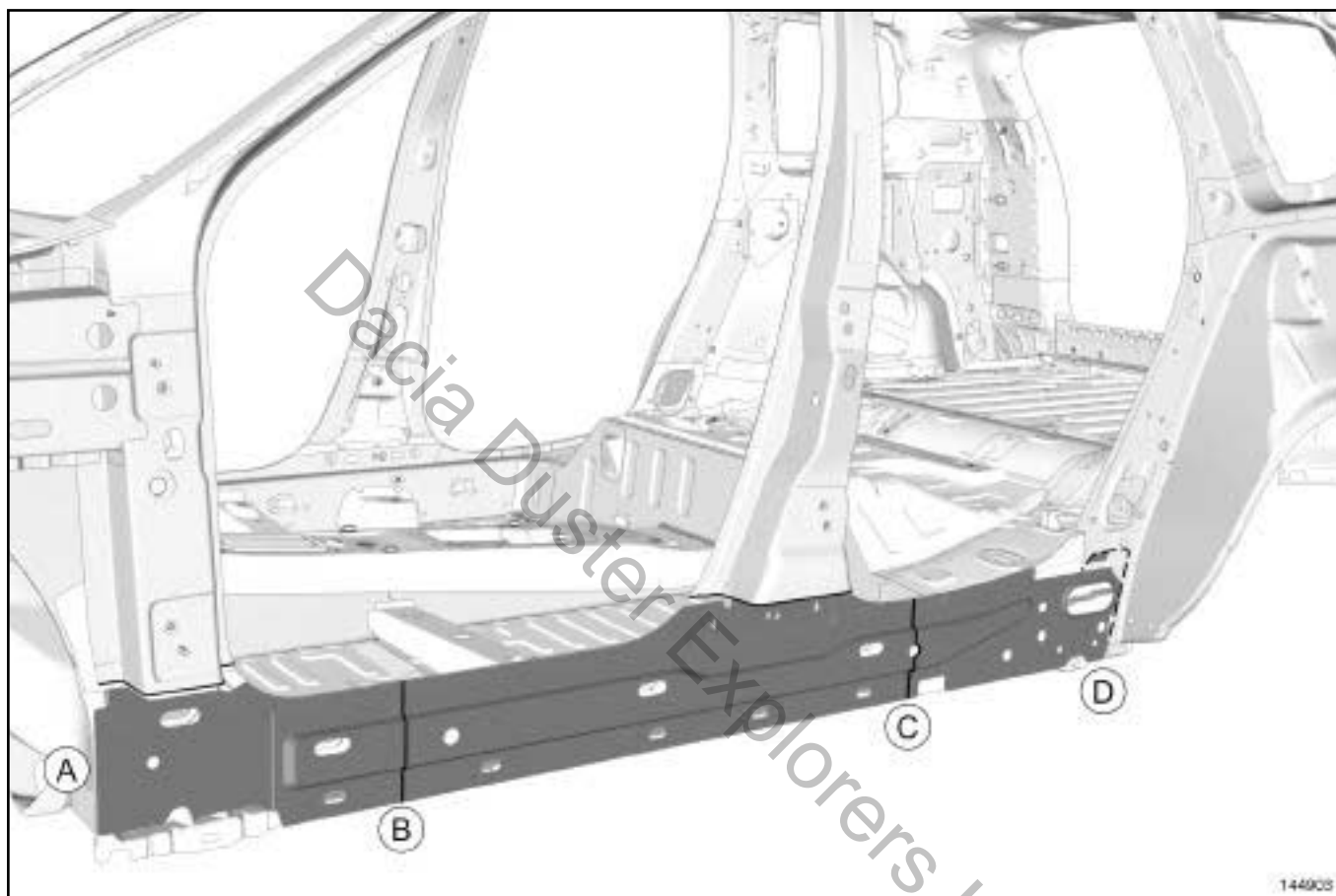
I - COMPOSITION OF THE SPARE PART

No.	Description	Thickness (mm)
(1)	Sill panel reinforcement	1.2

II - IN THE EVENT OF REPLACEMENT

The options for replacing this part are as follows:

- complete replacement A-D,
- front section partial replacement A-C,
- rear section partial replacement B-D.



WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

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

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

144903
Locate the earths located near to the weld area (see **40A, General information, Earths on body: List and location of components**, page 40A-5) .

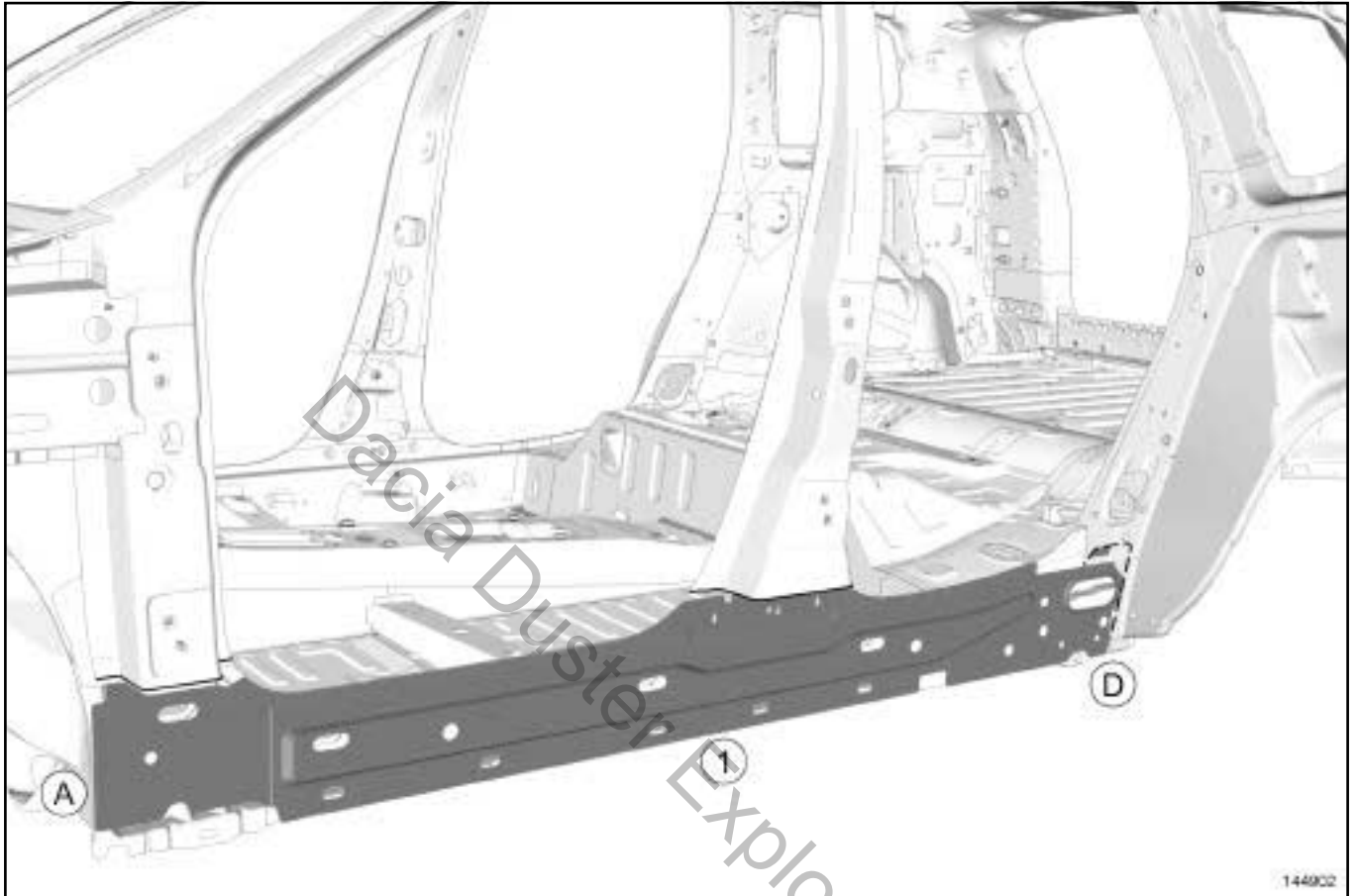
SIDE LOWER STRUCTURE

Sill panel reinforcement: Replacement

41C

1 - Complete replacement A-D

Part in position



144902

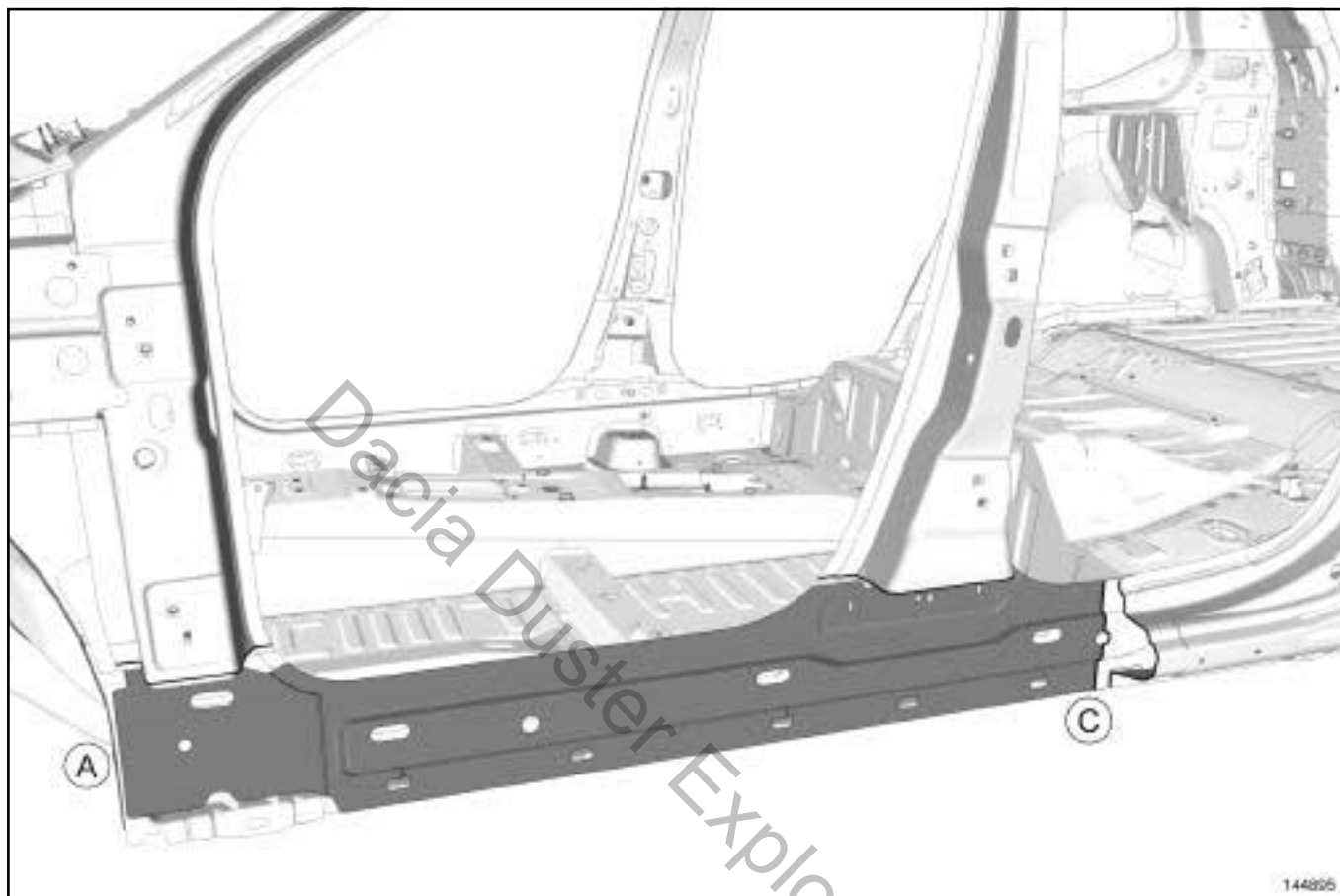
SIDE LOWER STRUCTURE

Sill panel reinforcement: Replacement

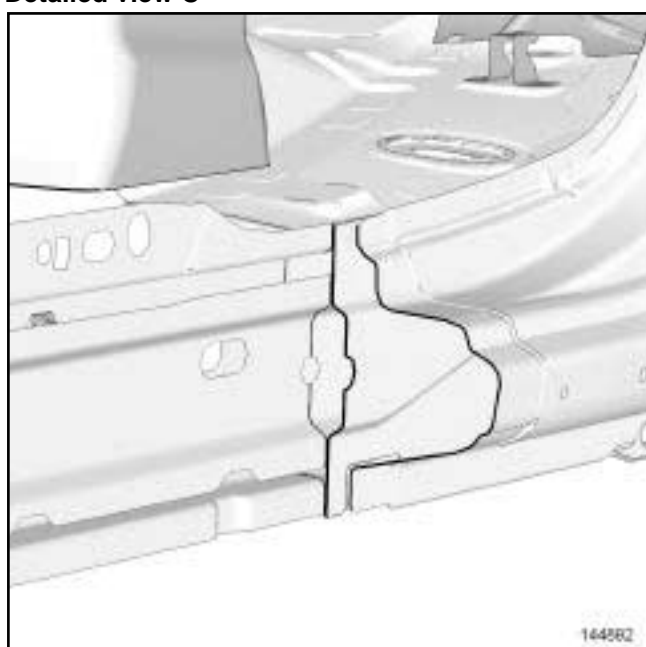
41C

2 - Front section partial replacement A-C

Part in position



Detailed view C



144892

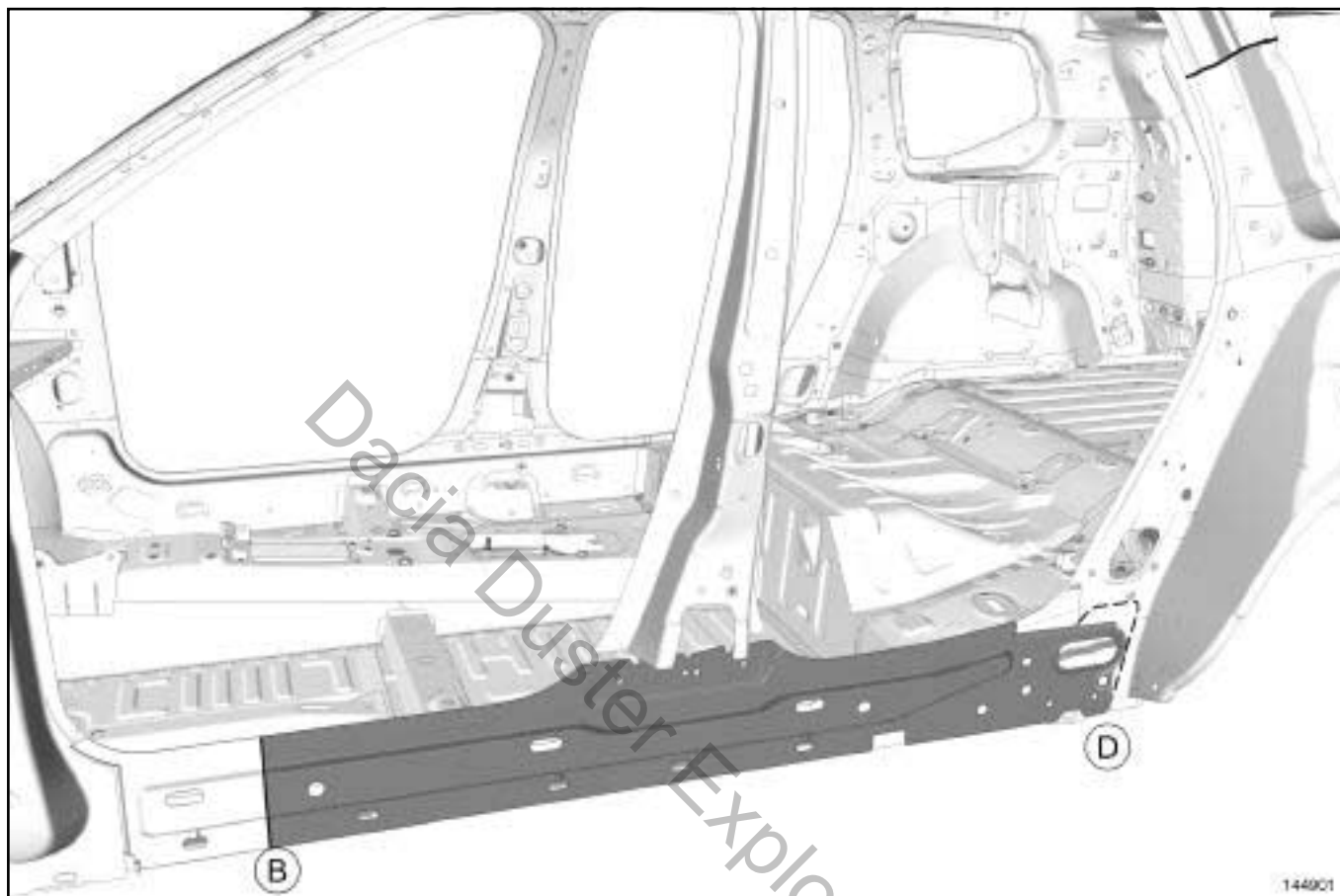
SIDE LOWER STRUCTURE

Sill panel reinforcement: Replacement

41C

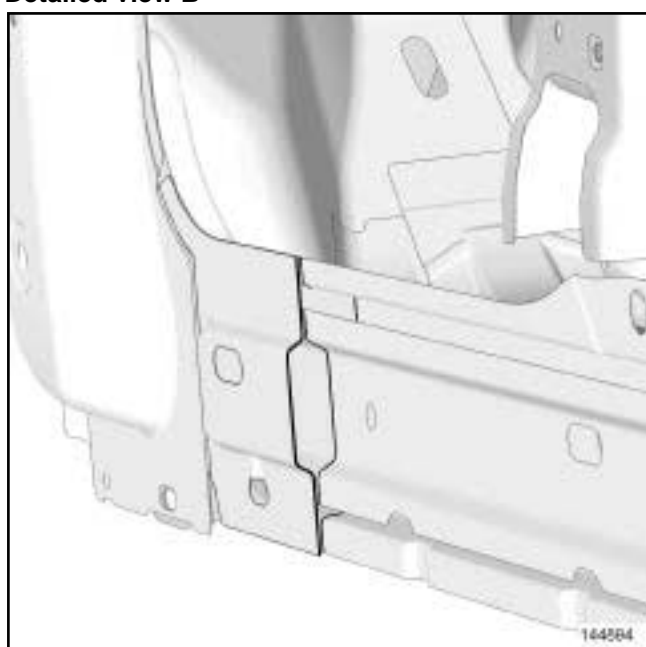
3 - Rear section partial replacement B-D

Part in position



144901

Detailed view B



144894

SIDE LOWER STRUCTURE

Sill panel stiffener: Replacement

41C

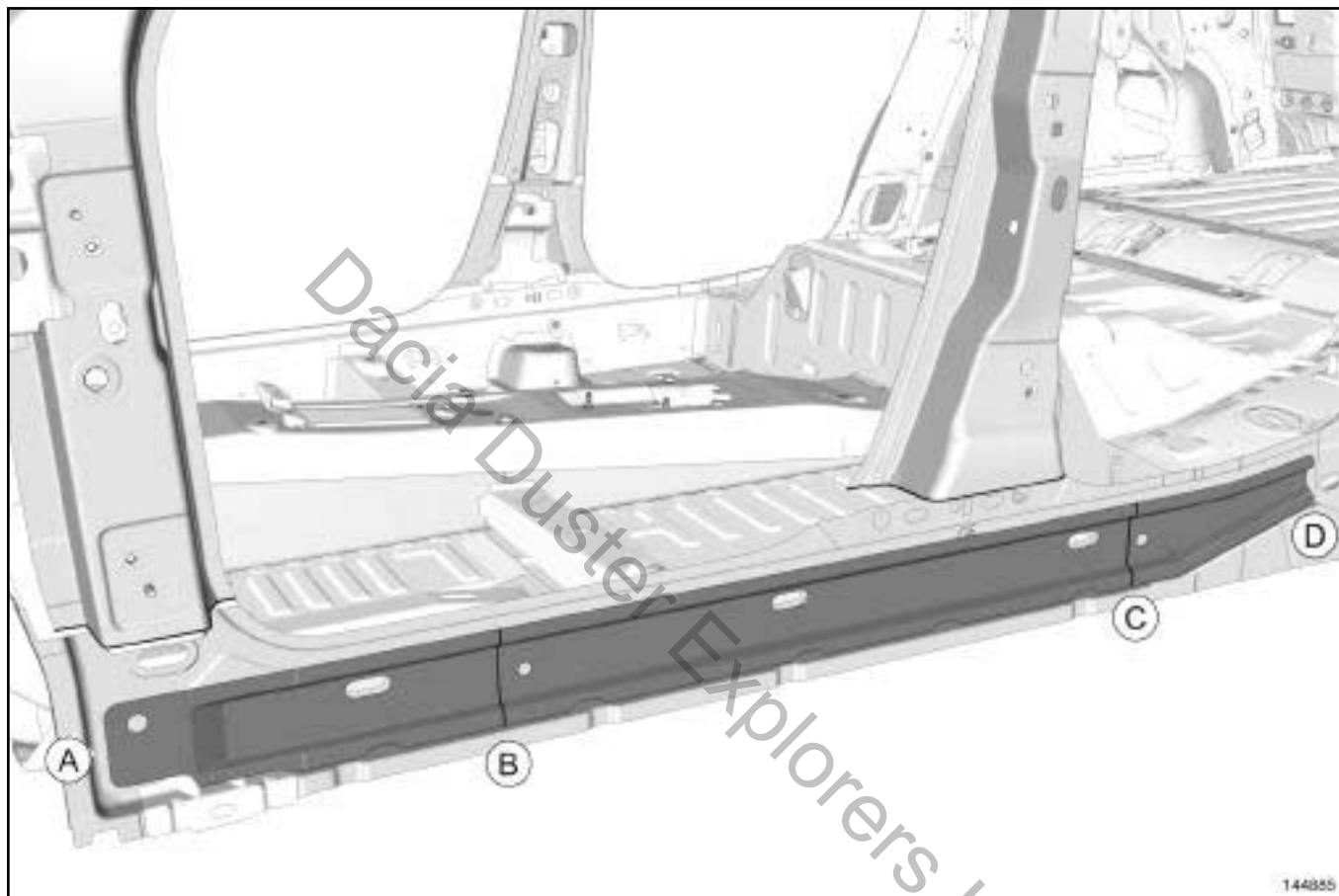
I - COMPOSITION OF THE SPARE PART

No.	Description	Thickness (mm)
(1)	Sill pane stiffener	2

II - IN THE EVENT OF REPLACEMENT

The options for replacing this part are as follows:

- complete replacement A-D,
- front section partial replacement A-C,
- rear section partial replacement B-D.



WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

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

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

144885
Locate the earths located near to the weld area (see **40A, General information, Earths on body: List and location of components**, page 40A-5) .

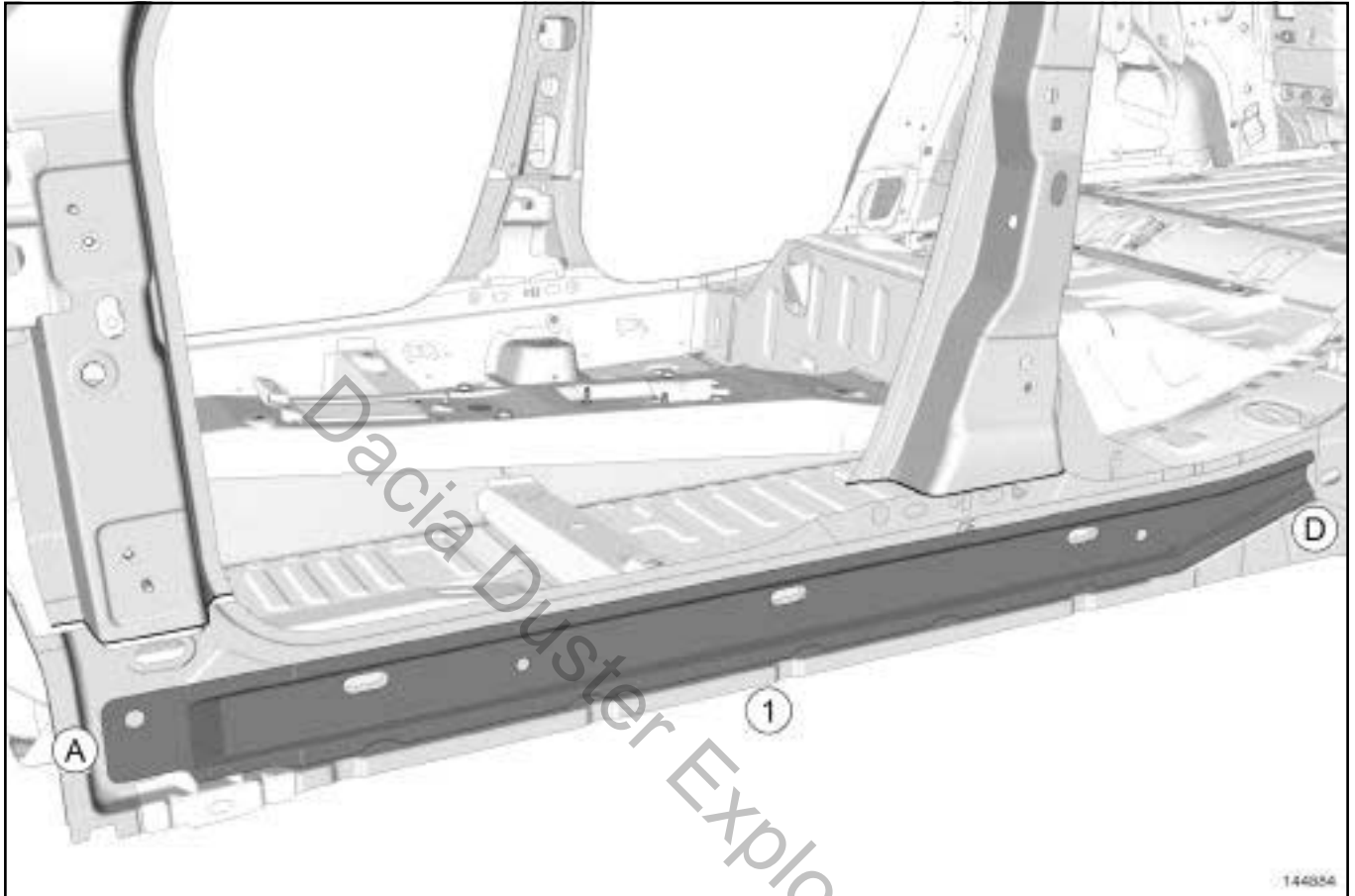
SIDE LOWER STRUCTURE

Sill panel stiffener: Replacement

41C

1 - Complete replacement A-D

Part in position



144884

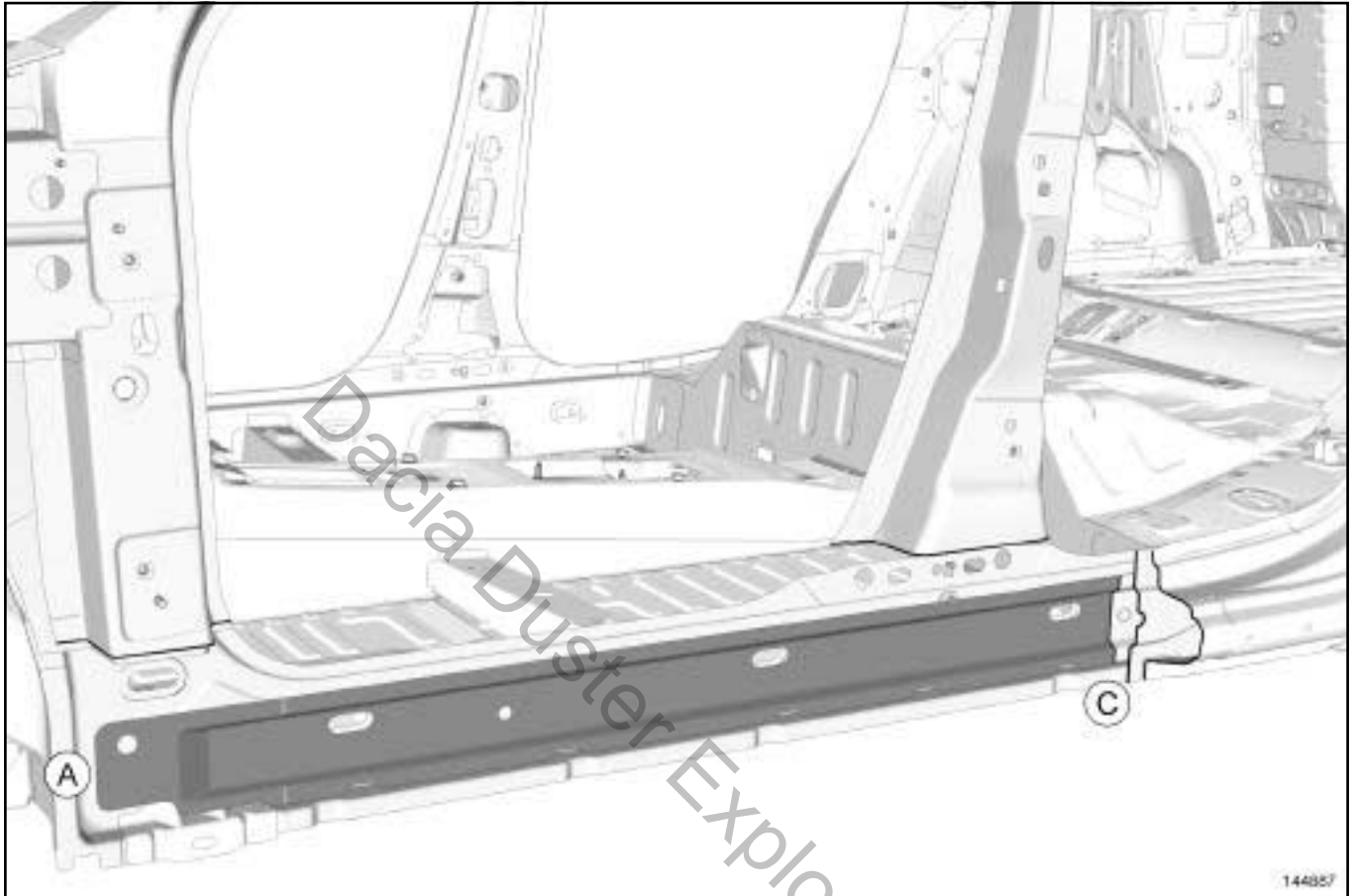
SIDE LOWER STRUCTURE

Sill panel stiffener: Replacement

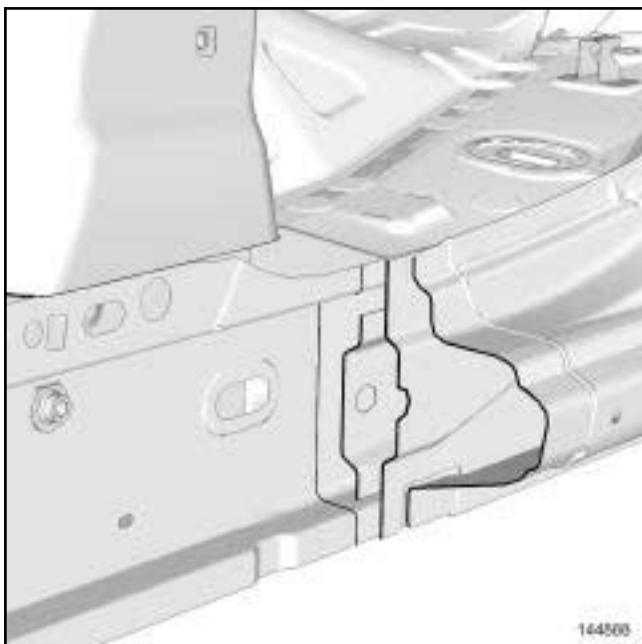
41C

2 - Front section partial replacement A-C

Part in position



Detailed view C



144888

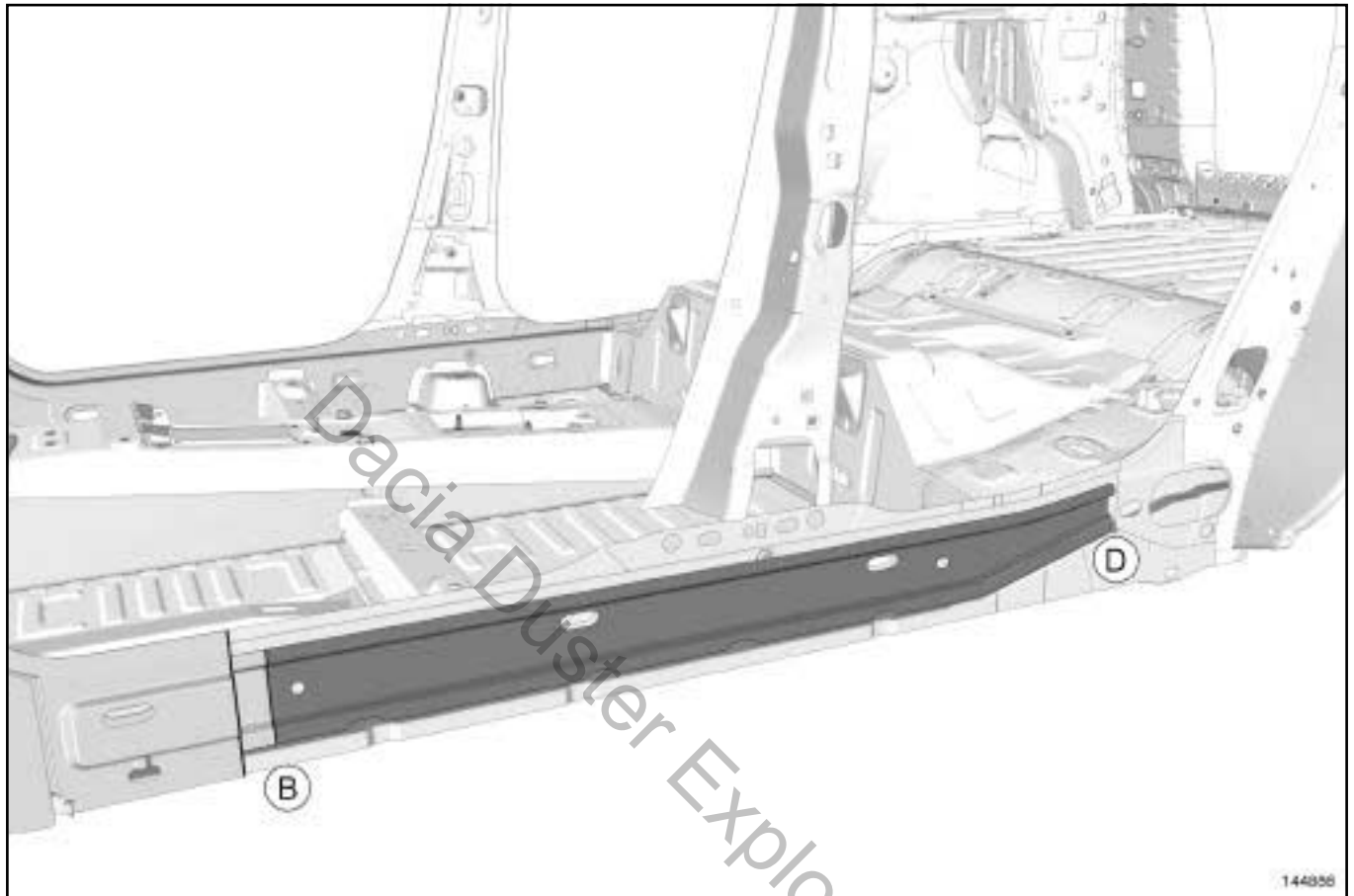
SIDE LOWER STRUCTURE

Sill panel stiffener: Replacement

41C

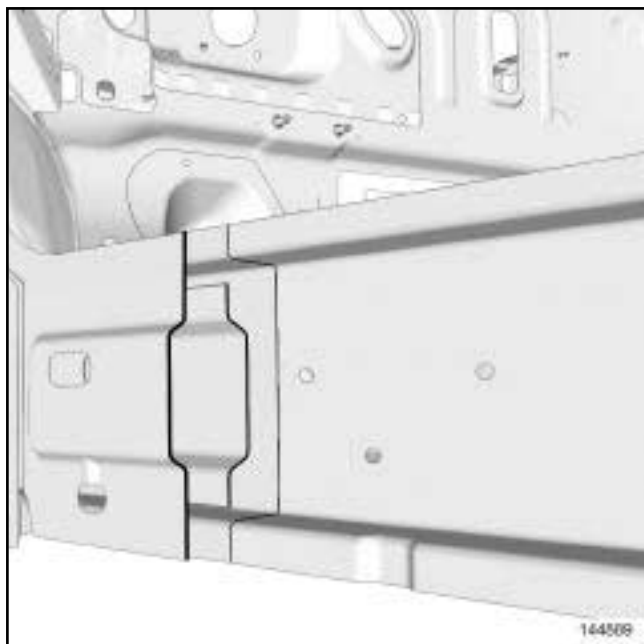
3 - Rear section partial replacement B-D

Part in position



144886

Detailed view B



144889

I - COMPOSITION OF THE SPARE PART



144890

No.	Description	Thickness (mm)
(1)	Lower connection component for front section inner rear wheel arch	0.95
(2)	Lower connection component for rear section inner rear wheel arch	0.95

II - IN THE EVENT OF REPLACEMENT

There is only one way of replacing this part:

- complete replacement.

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

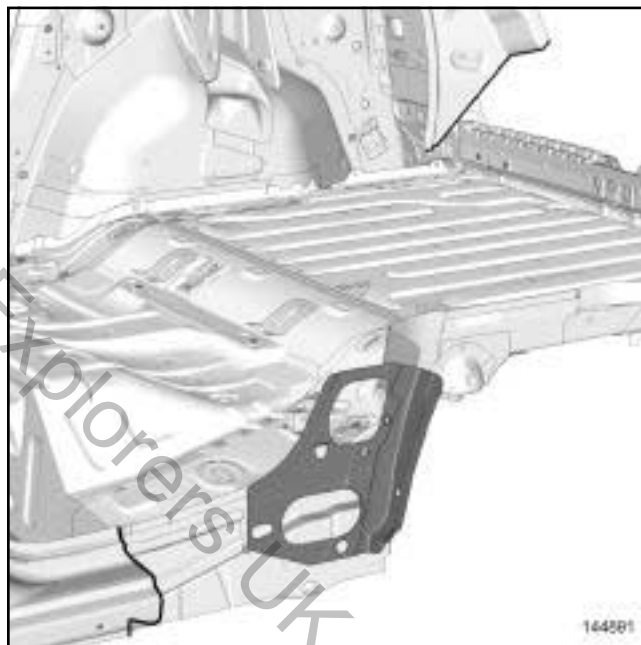
To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see 40A, General information, Earths on body: List and location of components, page 40A-5) .

Complete replacement

Part in position



144891

REAR LOWER STRUCTURE

Rear floor reinforcement: Replacement

41D

I - COMPOSITION OF THE SPARE PART

No.	Description	Thickness (mm)
(1)	Rear floor reinforcement	0.8

II - IN THE EVENT OF REPLACEMENT

There is only one way of replacing this part:

- complete replacement.

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

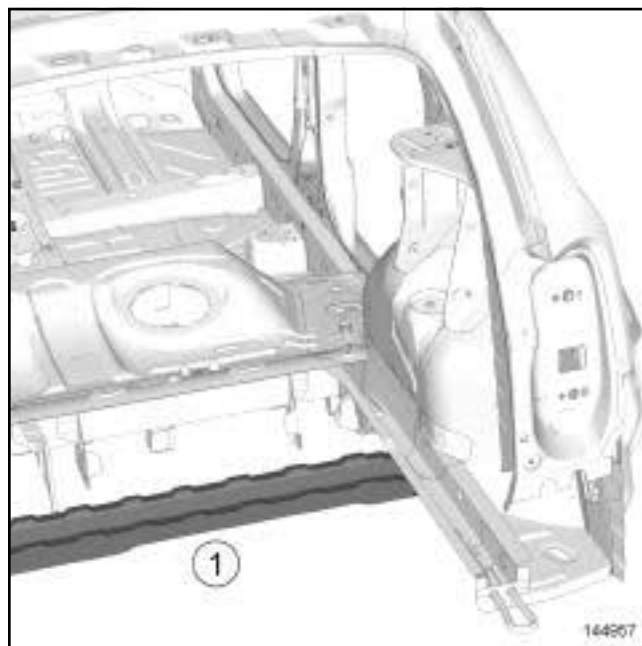
To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see **40A, General information, Earths on body: List and location of components**, page 40A-5) .

Complete replacement

Part in position



144957

REAR LOWER STRUCTURE

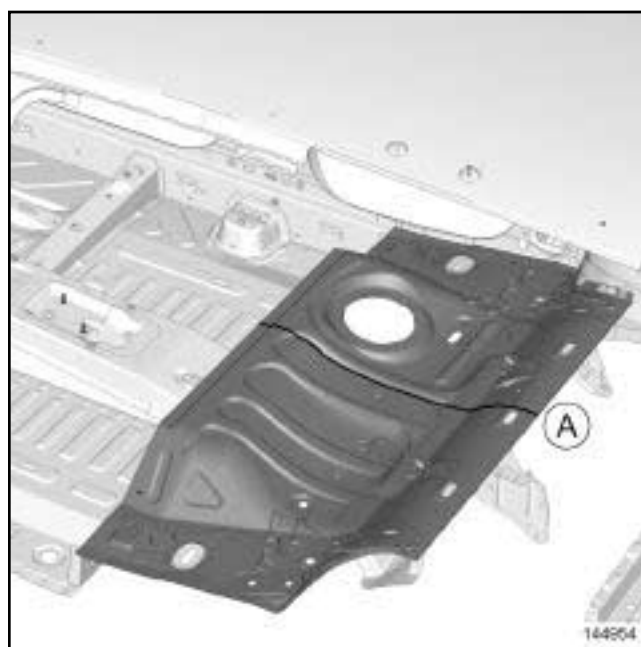
Rear floor, front section: Replacement

41D

I - COMPOSITION OF THE SPARE PART



144953



144954

No.	Description	Thickness (mm)
(1)	Rear floor, front section	0.65
(2)	Impact retaining component under second row front seat	1.95
(3)	Front section of rear floor reinforcement	1.8
(4)	Centre attachment reinforcement for child seat on second row	1.8

II - IN THE EVENT OF REPLACEMENT

The options for replacing this part are as follows:

- Complete replacement
- partial replacement along cut A.

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

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

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see **40A, General information, Earths on body: List and location of components**, page 40A-5) .

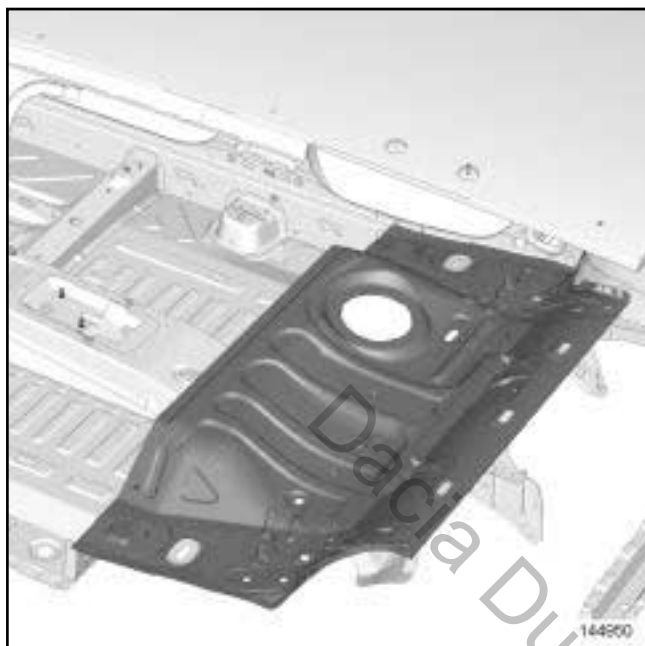
REAR LOWER STRUCTURE

Rear floor, front section: Replacement

41D

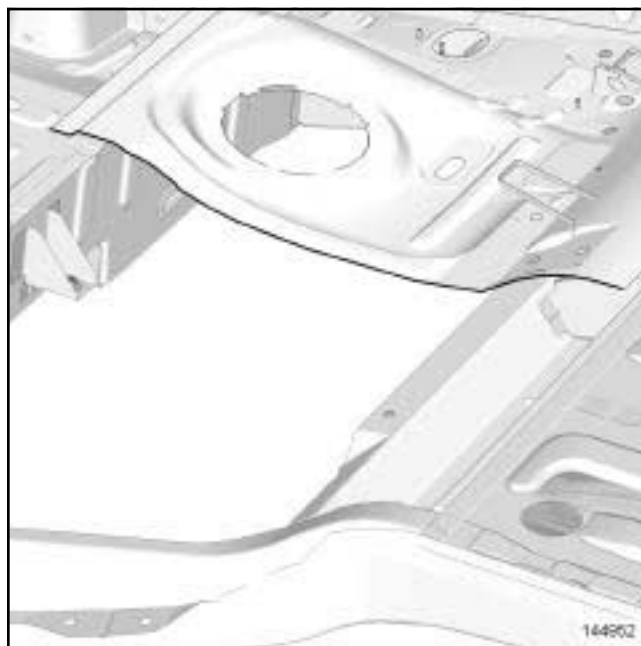
1 - Complete replacement

Part in position



144950

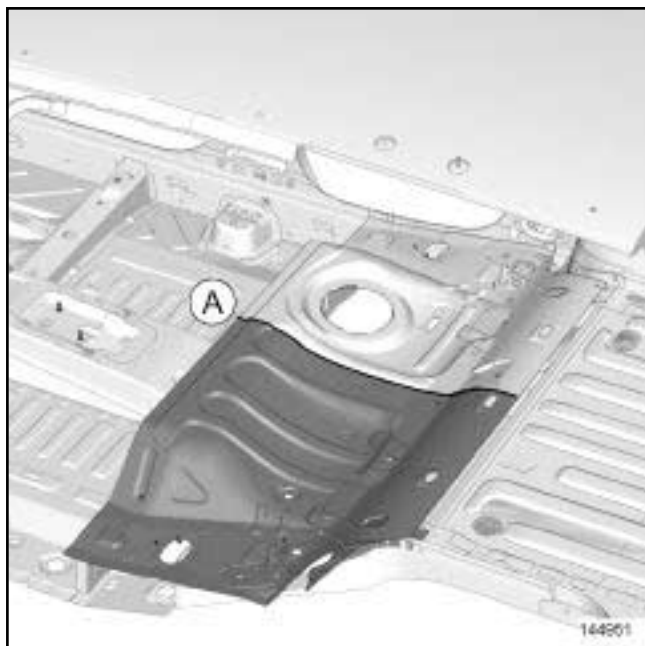
Detailed view A



144952

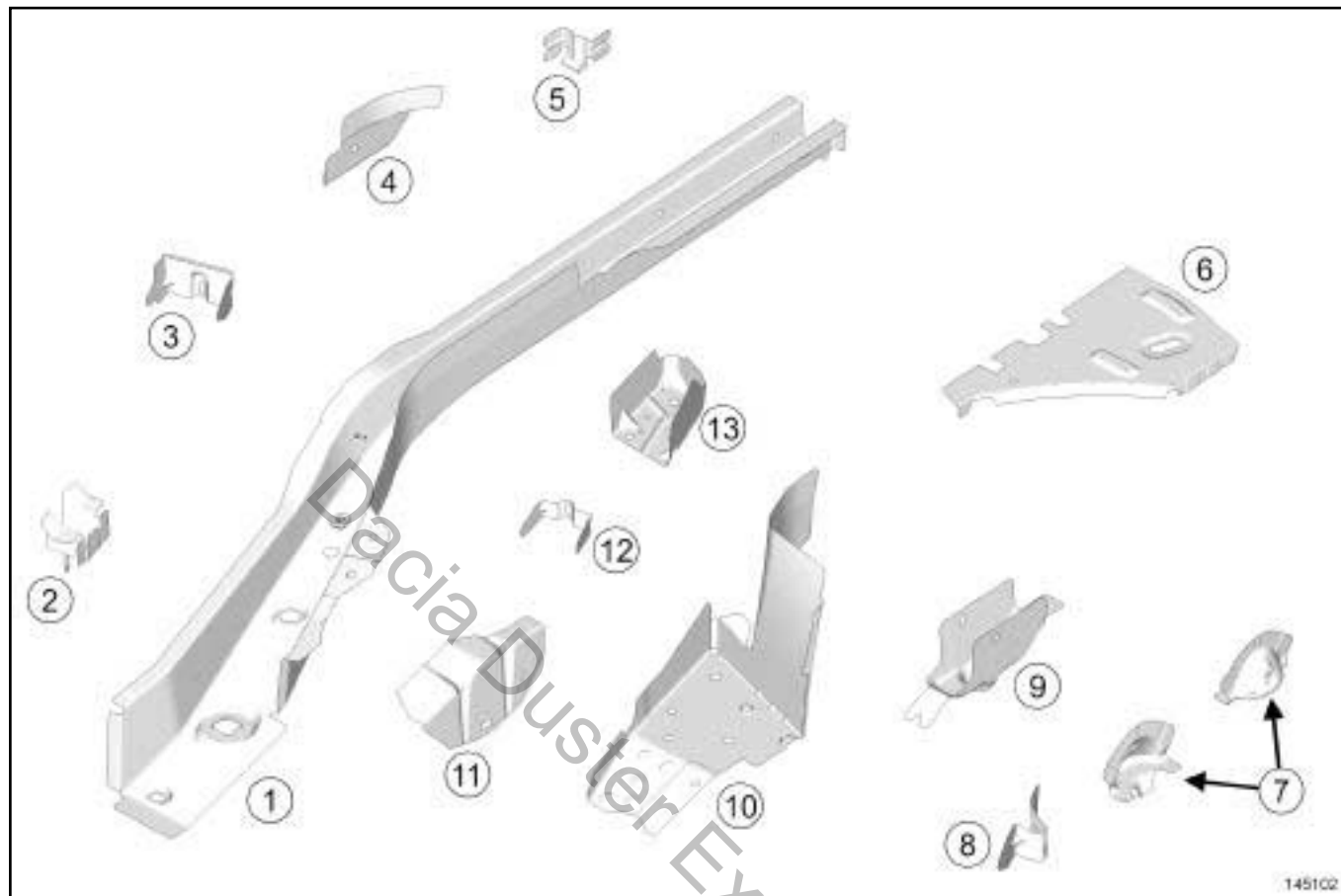
2 - Partial replacement along cut A

Part in position



144951

I - COMPOSITION OF THE SPARE PART



145102

145102

No.	Description	Thickness (mm)
(1)	Rear side member	1.45
(2)	Rear support for retaining the fuel tank on the body	1.5
(3)	Interior reinforcement of rear axle mounting side member	2
(4)	Connection component between rear side member and inner rear wheel arch	1.45
(5)	Exhaust rear support on subframe	2.5
(6)	Subframe side closure panel component	0.65

No.	Description	Thickness (mm)
(7)	Rear suspension spring support reinforcement	2
(8)	Rear axle rear mounting reinforcement	3.5
(9)	Rear upper spring support	2
(10)	Side rear cross member	1.9
(11)	Rear support reinforcement for jack	3
(12)	Rear axle mounting bracket on body	2
(13)	Rear axle assembly mounting unit	1.9

II - IN THE EVENT OF REPLACEMENT

There is only one way of replacing this part:

- complete replacement.

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

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

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

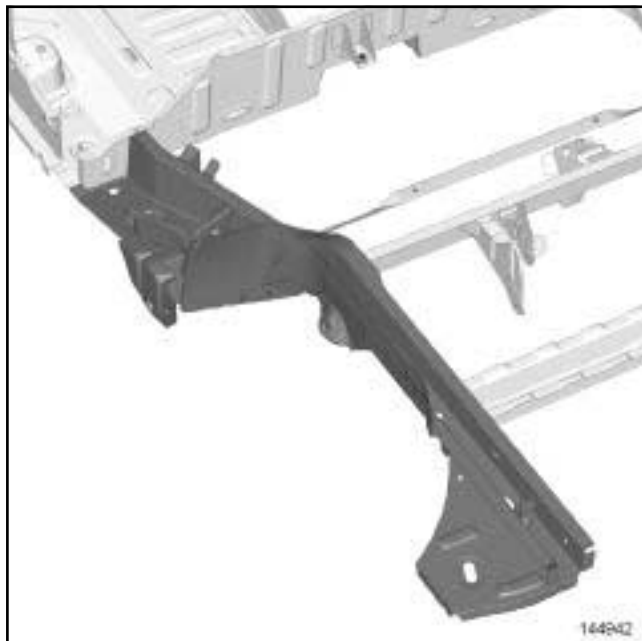
Locate the earths located near to the weld area (see **40A, General information, Earths on body: List and location of components**, page 40A-5) .

Complete replacement

IMPORTANT

Use a repair bench to ensure the positioning of the points and the geometry of the axle assemblies.

Part in position



144942

REAR LOWER STRUCTURE

Rear side member: Replacement

41D

I - COMPOSITION OF THE SPARE PART

No.	Description	Thickness (mm)
(1)	Rear side member	1.45

II - IN THE EVENT OF REPLACEMENT

There is only one way of replacing this part:

- partial replacement along cut A.

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

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

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

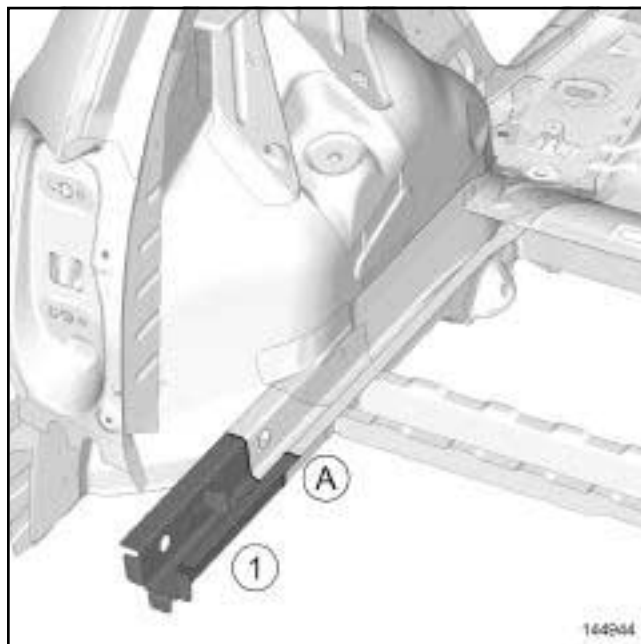
Locate the earths located near to the weld area (see **40A, General information, Earths on body: List and location of components**, page 40A-5) .

Partial replacement along cut A

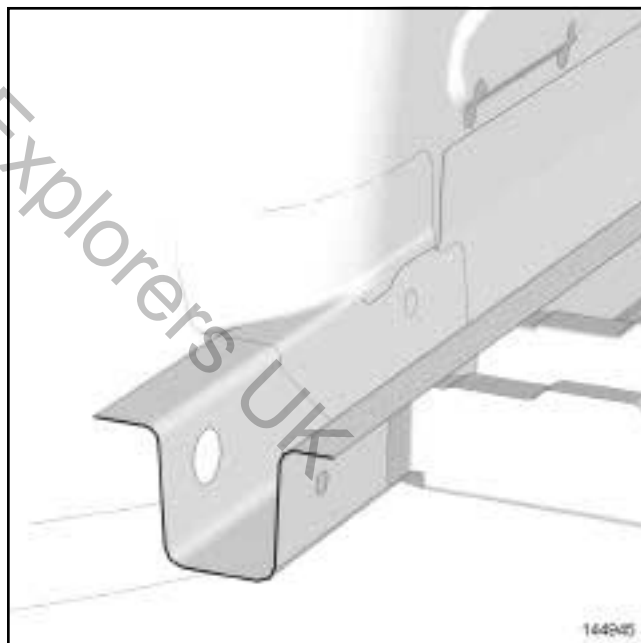
IMPORTANT

Use a repair bench to ensure the positioning of the points and the geometry of the axle assemblies.

Part in position



Detailed view A



REAR LOWER STRUCTURE

Front upper cross member: Replacement

41D

I - COMPOSITION OF THE SPARE PART

No.	Description	Thickness (mm)
(1)	Front upper cross member	0.95

II - IN THE EVENT OF REPLACEMENT

There is only one way of replacing this part:

- complete replacement.

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

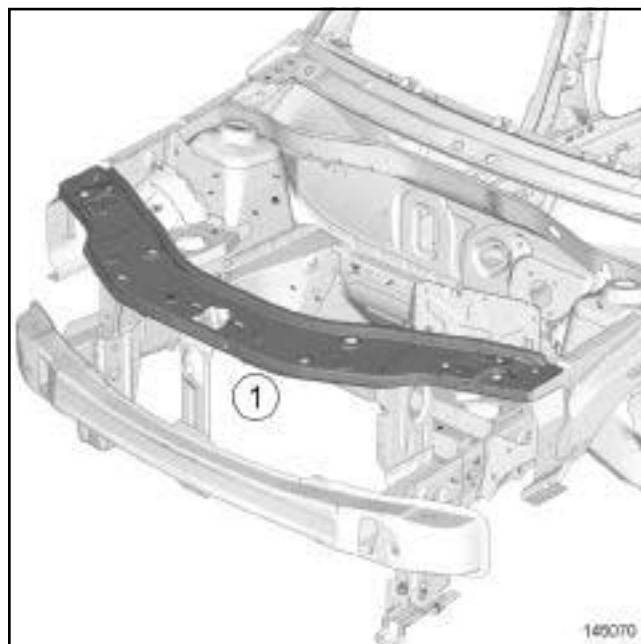
To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see **40A, General information, Earths on body: List and location of components**, page 40A-5) .

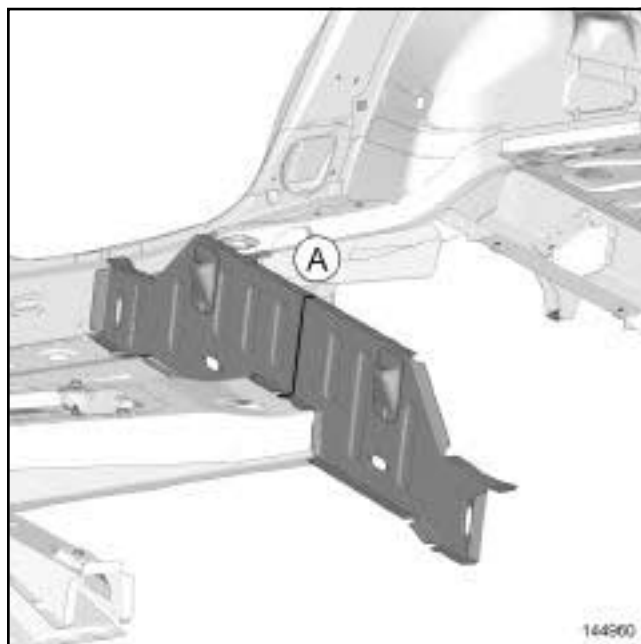
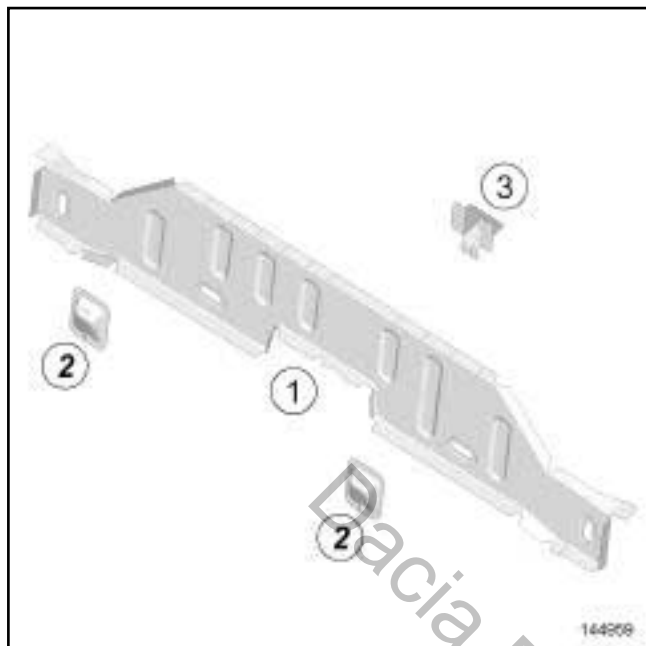
Complete replacement

Part in position



145070

I - COMPOSITION OF THE SPARE PART



No.	Description	Thickness (mm)
(1)	Rear floor front cross member	1.2
(2)	Attachment support for second row seat	0.95
(3)	Front support reinforcement for retaining the fuel tank on the body	1.5

II - IN THE EVENT OF REPLACEMENT

The options for replacing this part are as follows:

- Complete replacement
- partial replacement along cut A.

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

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

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see **40A, General information, Earths on body: List and location of components**, page 40A-5) .

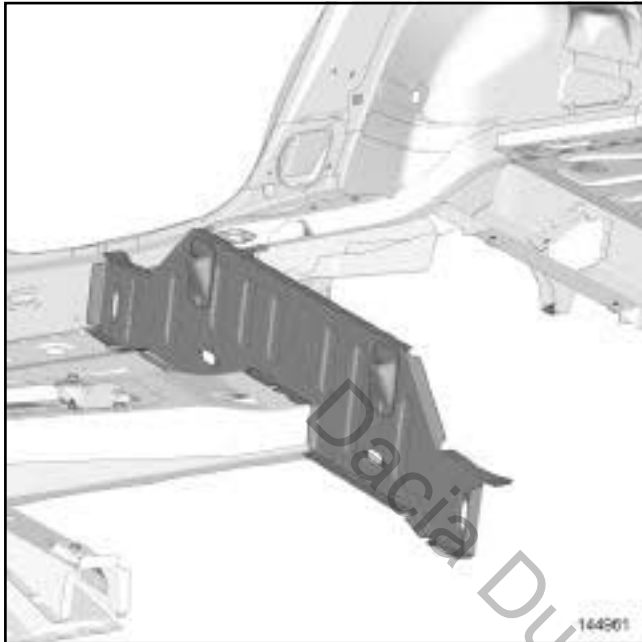
REAR LOWER STRUCTURE

Rear floor front cross member: Replacement

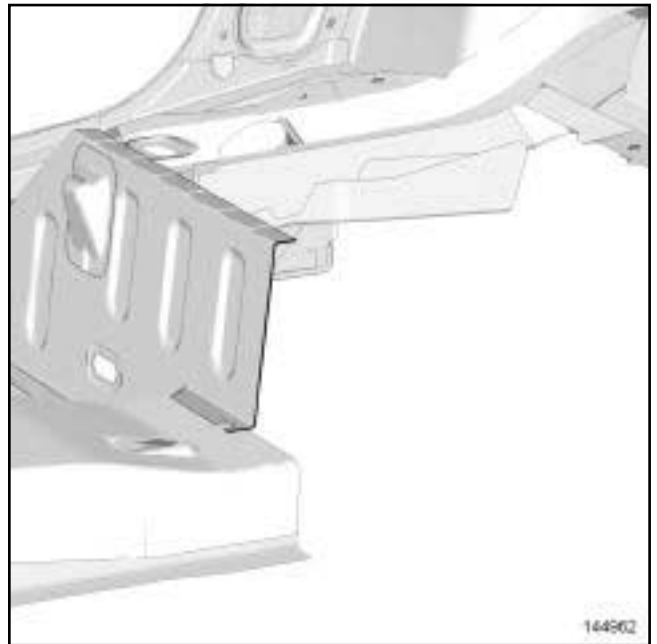
41D

1 - Complete replacement

Part in position



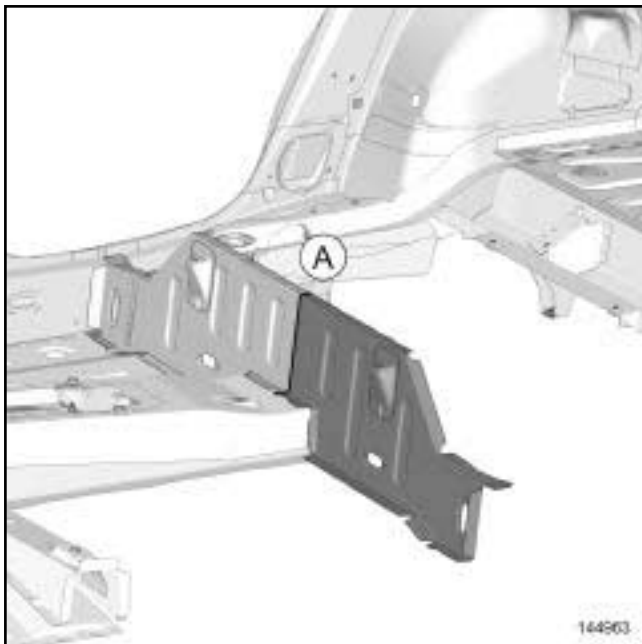
Detailed view A



144962

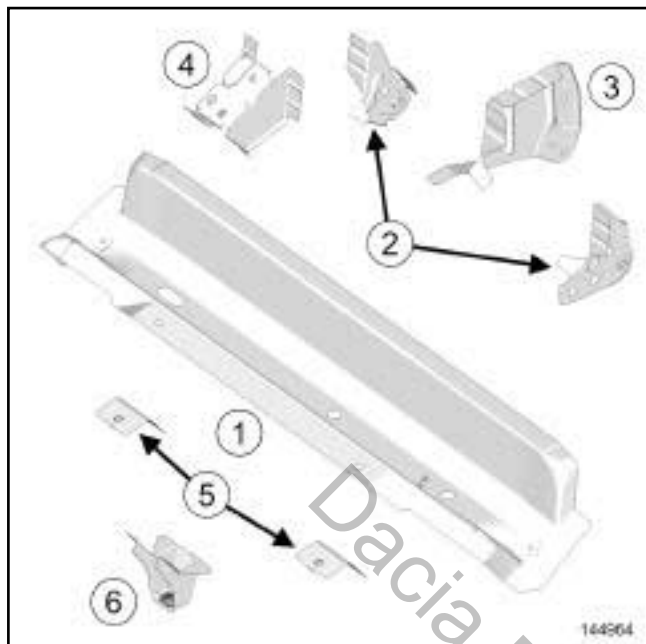
2 - Partial replacement along cut A

Part in position



144963

I - COMPOSITION OF THE SPARE PART



No.	Description	Thickness (mm)
(1)	Rear floor rear centre cross member	1.2
(2)	Brake limiter mounting support	1.95
(3)	Emergency spare wheel subframe joint support	2
(4)	Mounting bracket of second row seat	2
(5)	Second row anchorage centre reinforcement	1.95
(6)	Fuel tank rear mounting reinforcement	1.5

II - IN THE EVENT OF REPLACEMENT

There is only one way of replacing this part:

- complete replacement.

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

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

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

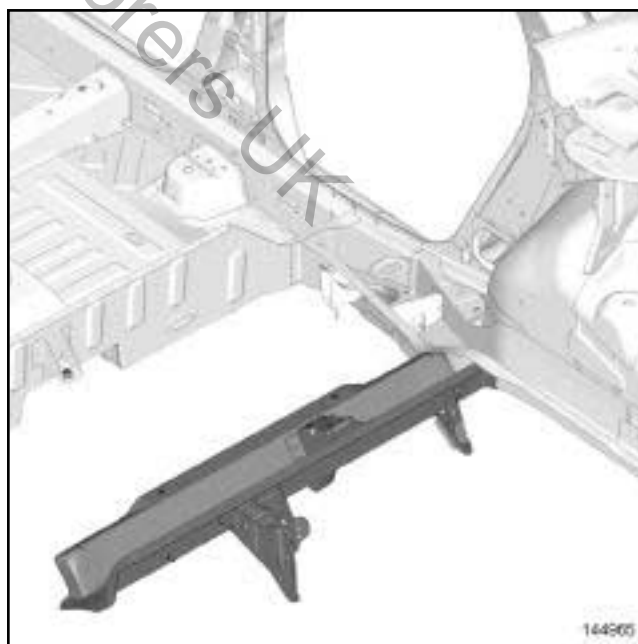
Locate the earths located near to the weld area (see **40A, General information, Earths on body: List and location of components**, page 40A-5) .

Complete replacement

IMPORTANT

Use a repair bench to ensure the positioning of the points and the geometry of the axle assemblies.

Part in position



144965

REAR LOWER STRUCTURE

Rear floor, rear section: Replacement

41D

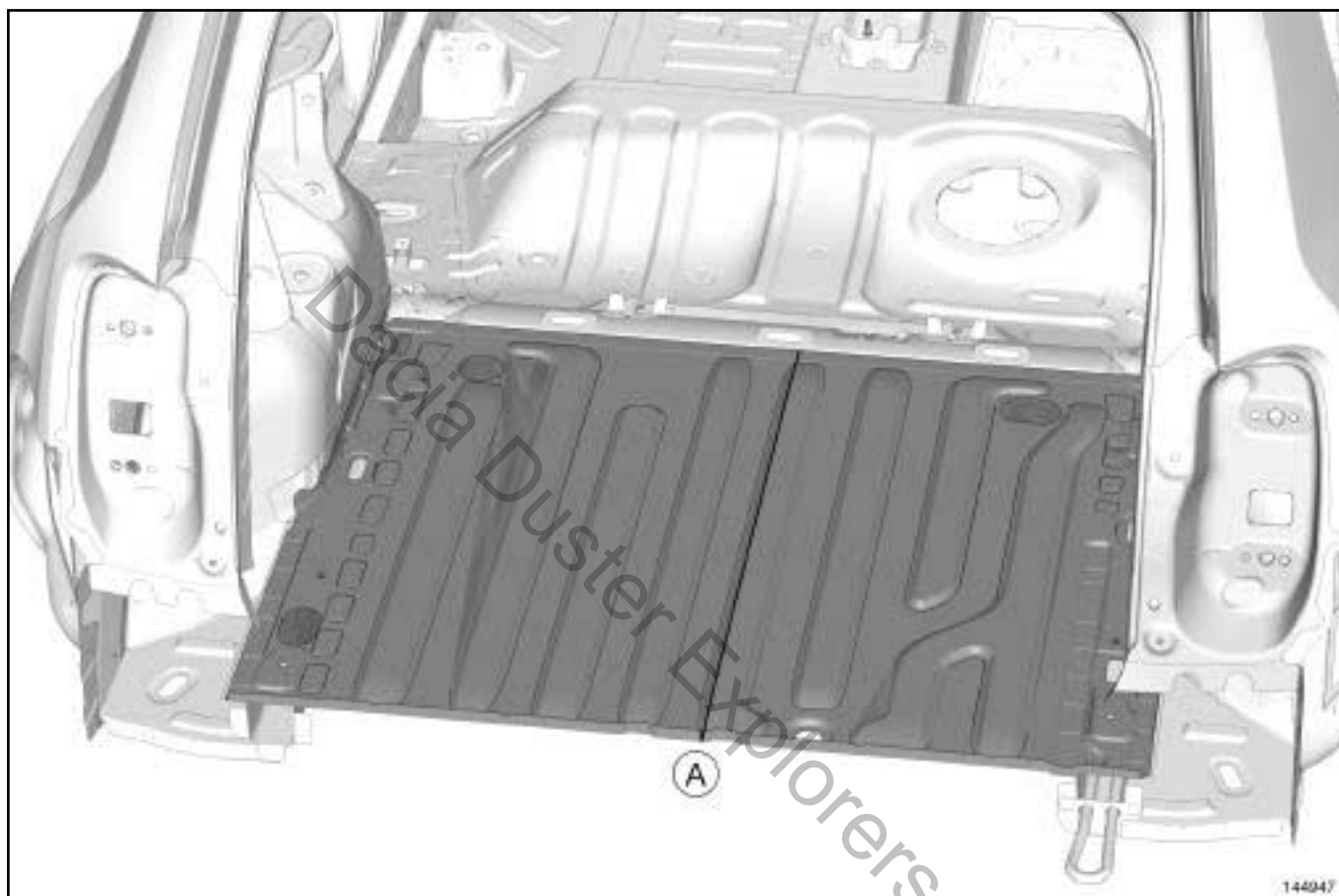
I - COMPOSITION OF THE SPARE PART

No.	Description	Thickness (mm)
(1)	Rear floor, rear section	0.7

II - IN THE EVENT OF REPLACEMENT

The options for replacing this part are as follows:

- Complete replacement
- partial replacement along cut A.



WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

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

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

144947
Locate the earths located near to the weld area (see **40A, General information, Earths on body: List and location of components**, page 40A-5) .

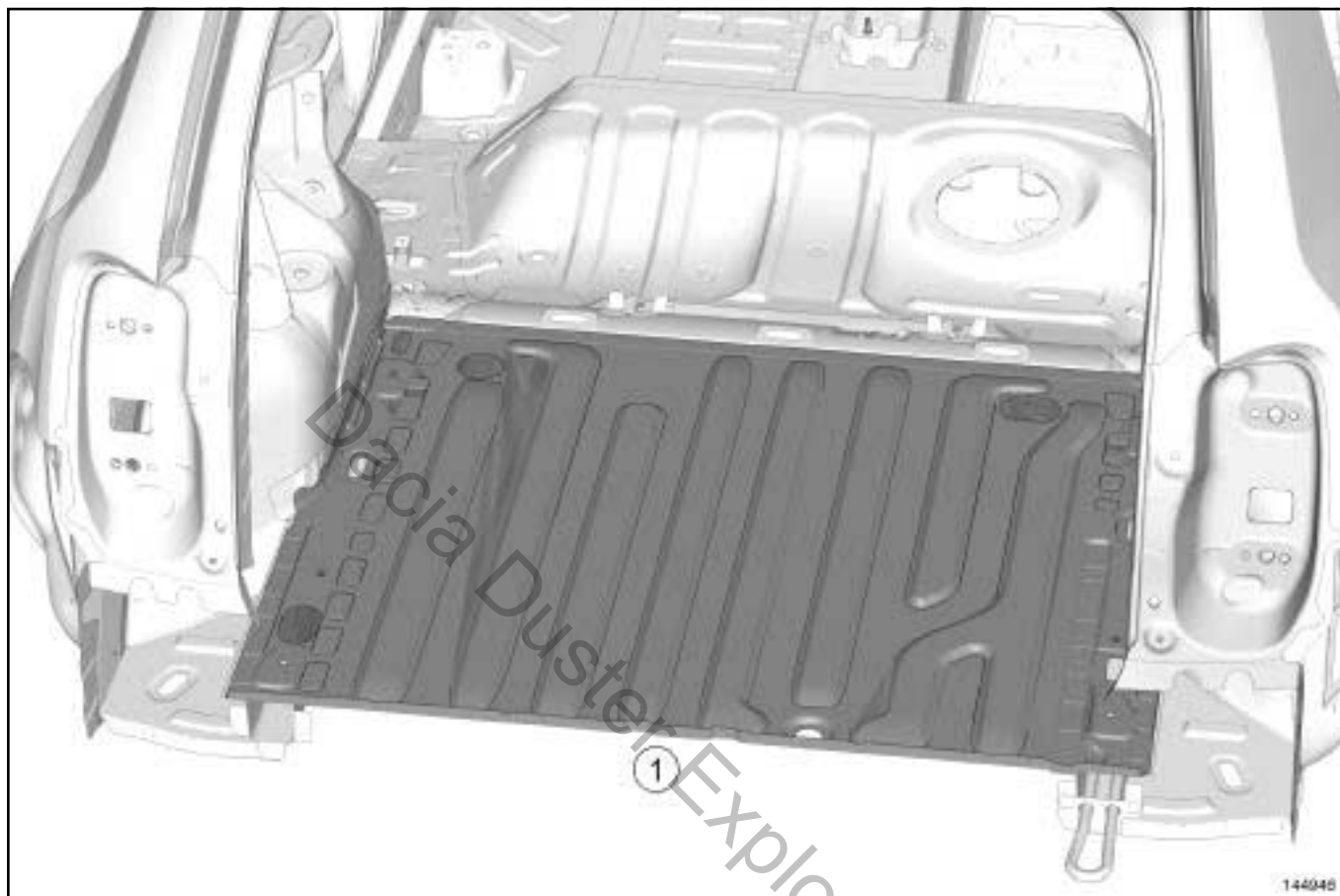
REAR LOWER STRUCTURE

Rear floor, rear section: Replacement

41D

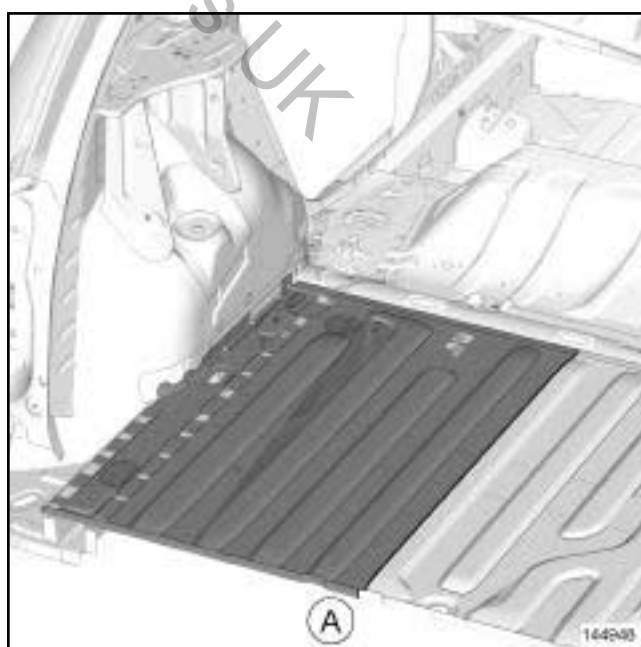
1 - Complete replacement

Part in position



2 - Partial replacement along cut A

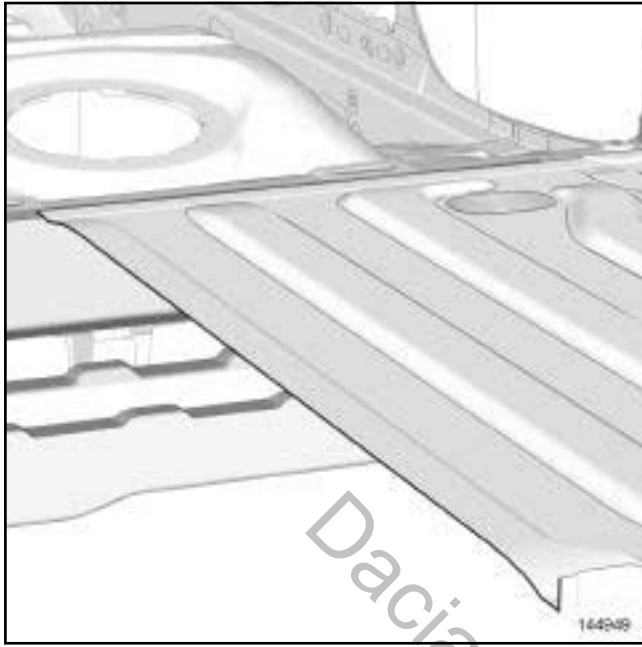
Part in position



REAR LOWER STRUCTURE
Rear floor, rear section: Replacement

41D

Detailed view A



144949

Dacia Duster Explorers UK

I - COMPOSITION OF THE SPARE PART

No.	Description	Thickness (mm)
(1)	Rear floor, rear side section	0.65

II - IN THE EVENT OF REPLACEMENT

There is only one way of replacing this part:

- complete replacement.

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

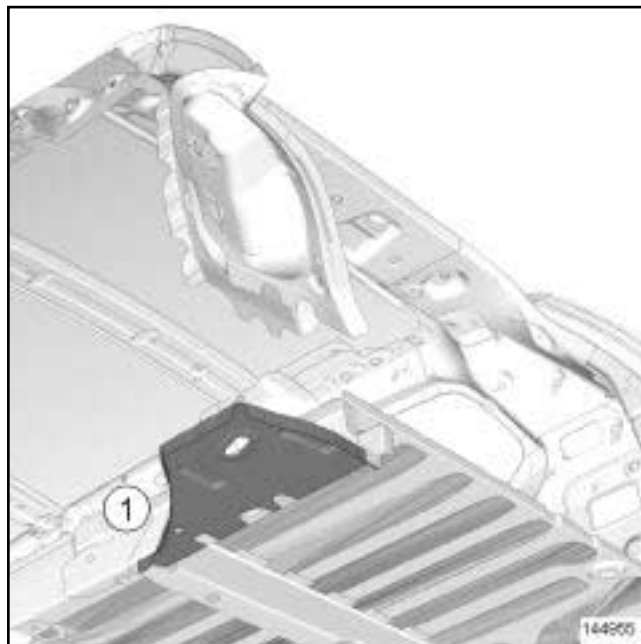
To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see **40A, General information, Earths on body: List and location of components**, page 40A-5) .

Complete replacement

Part in position



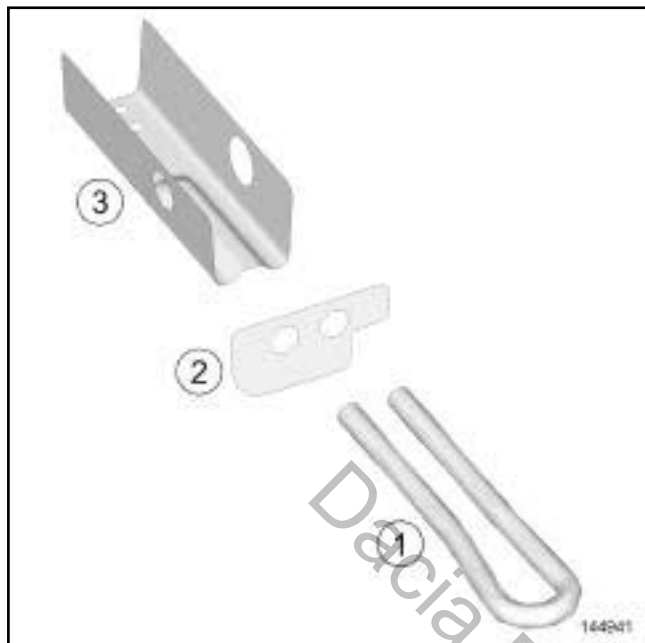
144955

REAR LOWER STRUCTURE

Rear towing eye: Replacement

41D

I - COMPOSITION OF THE SPARE PART



144941

No.	Description	Thickness (mm)
(1)	Rear towing eye	14
(2)	Rear side member closure panel component	0.95
(3)	Rear towing eye mounting	3

II - IN THE EVENT OF REPLACEMENT

There is only one way of replacing this part:

- complete replacement.

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

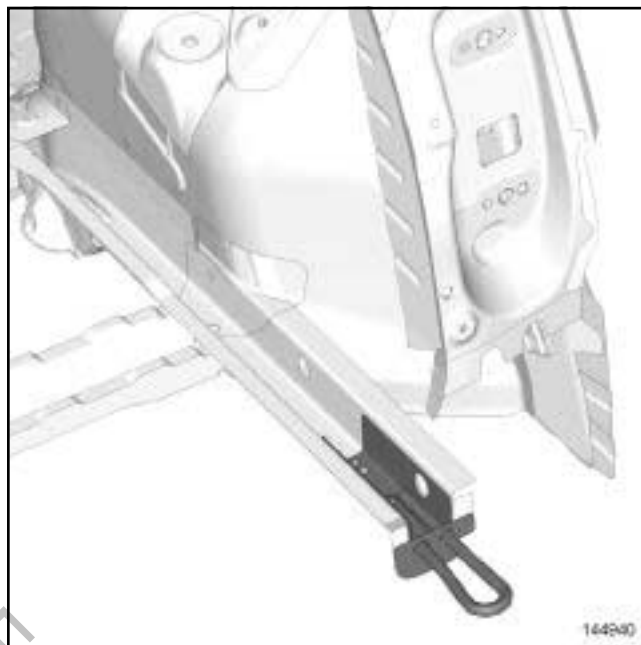
To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see 40A, General information, Earths on body: List and location of components, page 40A-5) .

Complete replacement

Part in position



144940

REAR LOWER STRUCTURE

Exhaust mounting support: Replacement

41D

I - COMPOSITION OF THE SPARE PART

No.	Description	Thickness (mm)
(1)	Exhaust mounting support	2.5

II - IN THE EVENT OF REPLACEMENT

There is only one way of replacing this part:

- complete replacement.

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

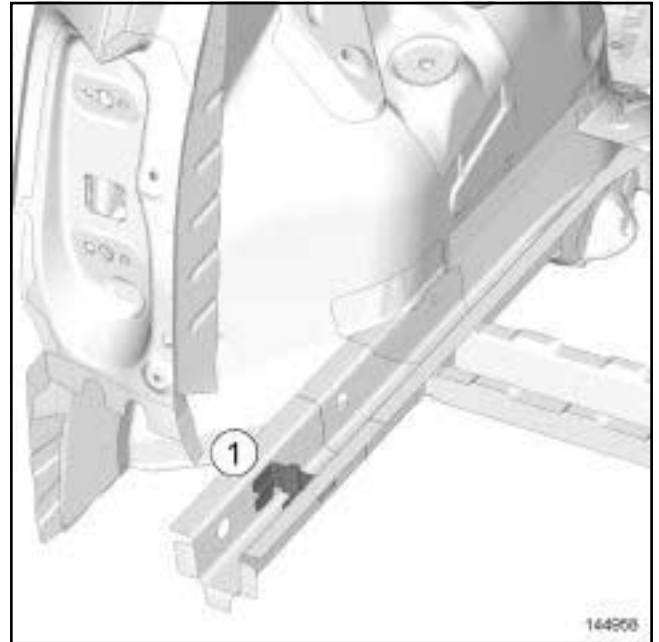
To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see **40A, General information, Earths on body: List and location of components**, page 40A-5) .

Complete replacement

Part in position



144958

144958

I - COMPOSITION OF THE SPARE PART



145060

No.	Description	Thickness (mm)
(1)	Front end panel upper cross member centre mounting	1.4
(2)	Lock mounting cross member reinforcement	1.2
(3)	Right-hand headlight carrier panel	1
(4)	Front end panel upper cross member	0.95
(5)	Left-hand headlight carrier panel	1

II - IN THE EVENT OF REPLACEMENT

There is only one way of replacing this part:

- complete replacement.

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

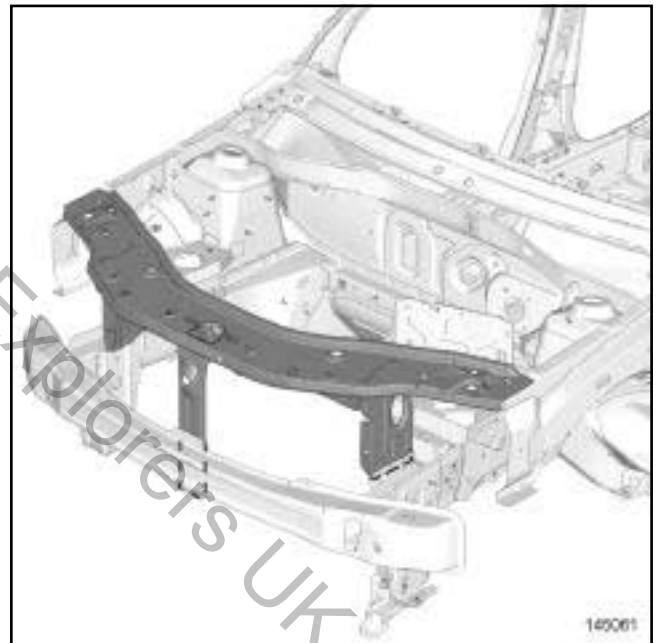
To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see 40A, General information, Earths on body: List and location of components, page 40A-5) .

Complete replacement

Part in position



145061

FRONT UPPER STRUCTURE

Front wing: Removal - Refitting

42A

Location and specifications (tightening torques, parts always to be replaced, etc.) (see **Exterior body front trim assembly: Exploded view**) .

REMOVAL

I - REMOVAL PREPARATION OPERATION

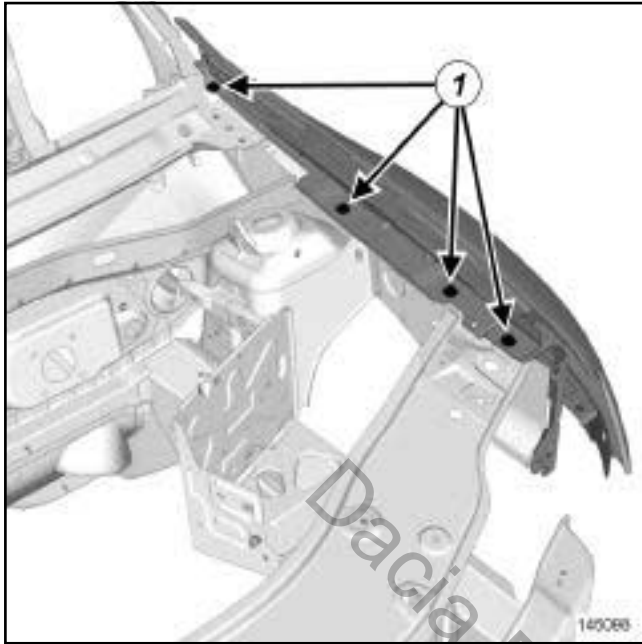
- Position the vehicle on a two-post lift (see **Vehicle: Towing and lifting**) (02A, Lifting equipment).
- Remove (see **Exterior body front trim assembly: Exploded view**) (55A, Exterior protection):
 - the scuttle panel grille side blanking cover,
 - the front wheel arch liner,
 - the front section of the sill panel extender,
 - the front bumper (see **Front bumper assembly: Exploded view**) .
- Remove:
 - the side indicator (see **Side indicator: Removal - Refitting**) ,
 - the headlight (see **Headlight assembly: Exploded view**) (80B, Headlight).

FRONT UPPER STRUCTURE

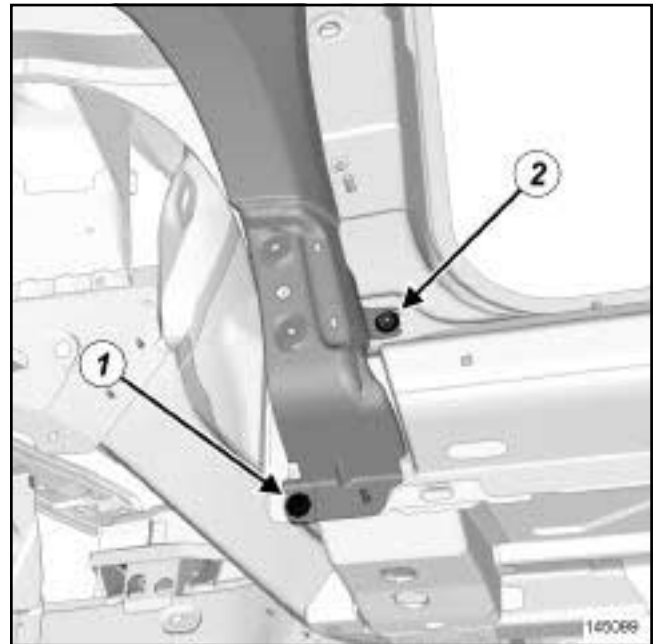
Front wing: Removal - Refitting

42A

II - REMOVAL OPERATION



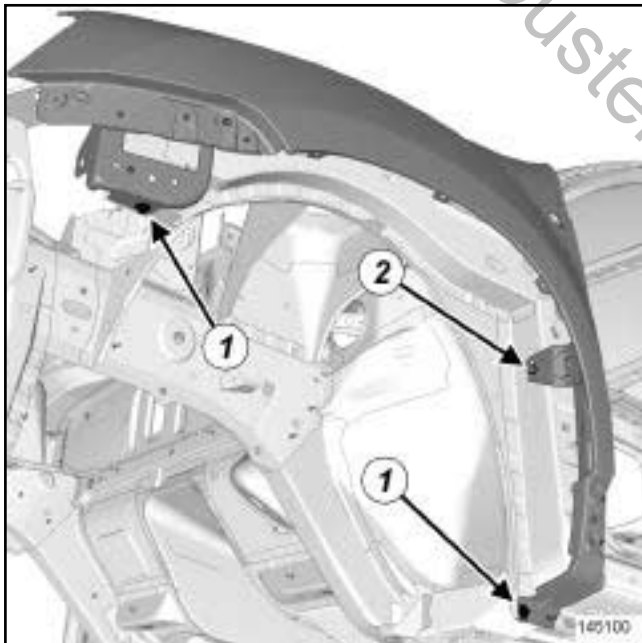
145098



145099

Remove:

- the bolts (1) ,
- the nuts (2) ,
- the front wing.



145100

REFITTING

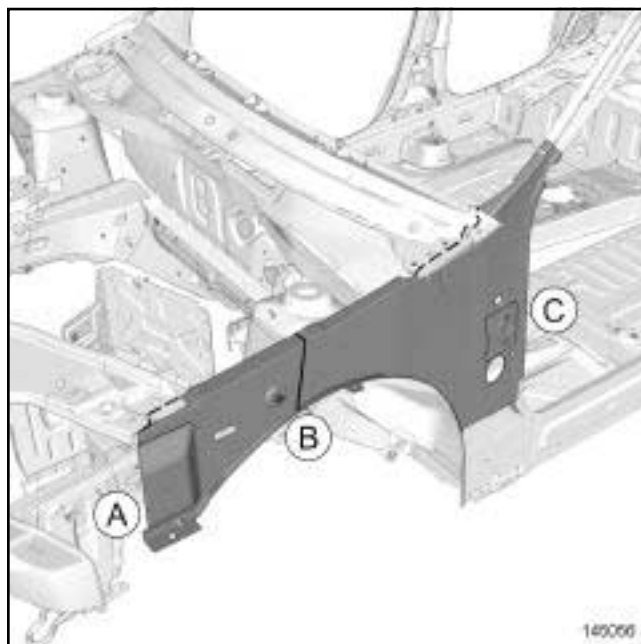
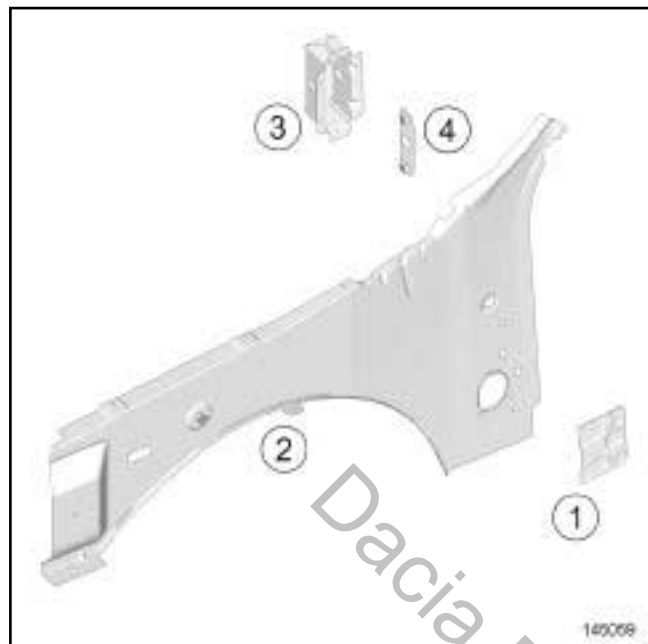
- Proceed in the reverse order to removal.
- Adjust the clearances and flush fitting (see **Vehicle panel gaps: Adjustment value**) (01C, Vehicle bodywork specifications).

FRONT UPPER STRUCTURE

Scuttle side panel: Replacement

42A

I - COMPOSITION OF THE SPARE PART



No.	Description	Thickness (mm)
(1)	A-pillar lining impact reinforcement	1.95
(2)	A-pillar lining	0.9
(3)	Mounting plate nut	0.9
(4)	Mounting support for upper section of driver's seat cross member	1.95

II - IN THE EVENT OF REPLACEMENT

The options for replacing this part are as follows:

- complete replacement A-C,
- front section partial replacement A-B.

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

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

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see **40A, General information, Earths on body: List and location of components, page 40A-5**) .

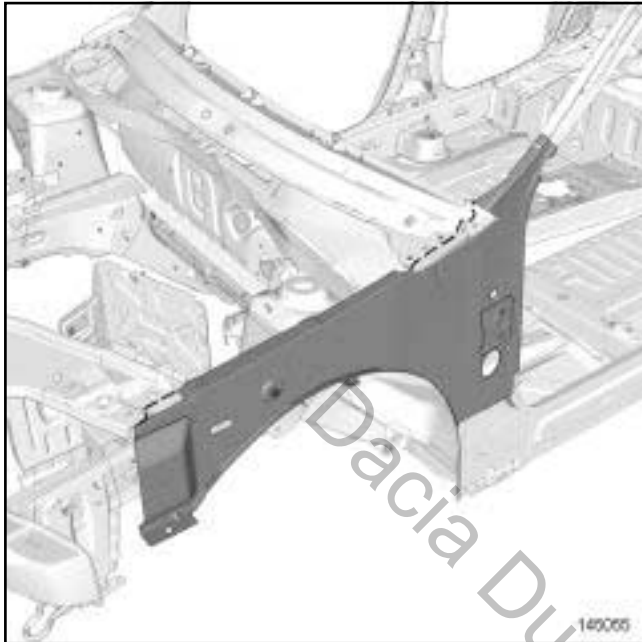
FRONT UPPER STRUCTURE

Scuttle side panel: Replacement

42A

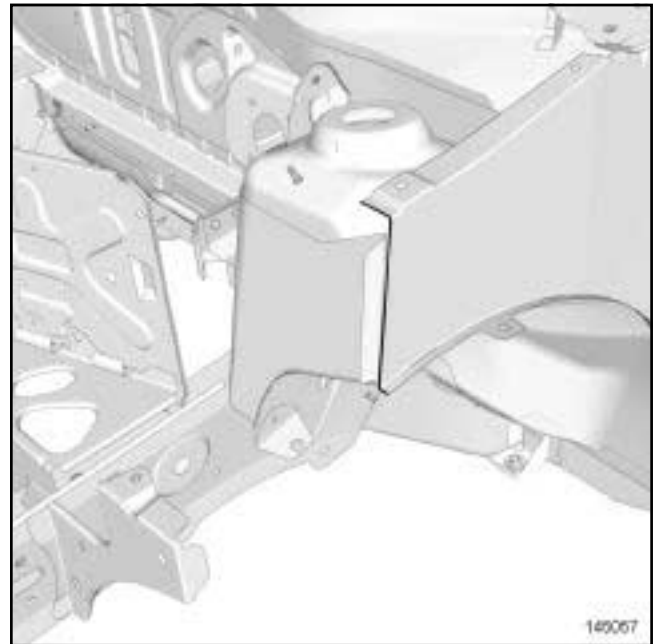
1 - Complete replacement A-C

Part in position



145055

Detailed view B

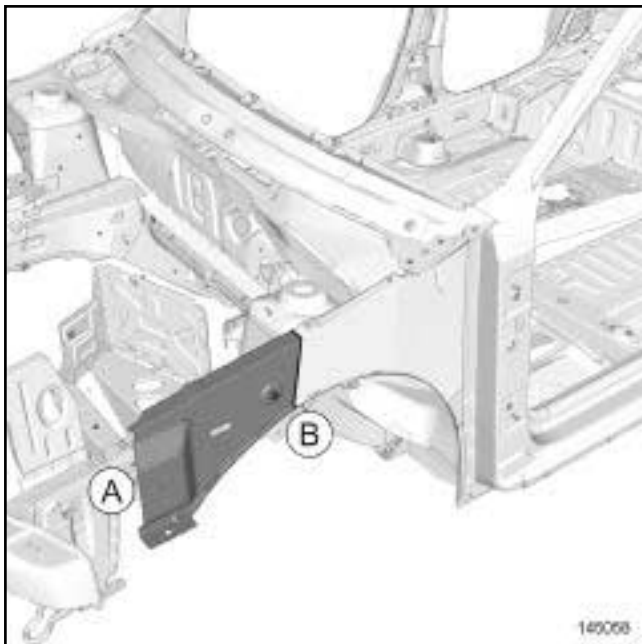


145057

145057

2 - Front section partial replacement A-B

Part in position



145058

145058

FRONT UPPER STRUCTURE

Scuttle side panel upper reinforcement: Replacement

42A

I - COMPOSITION OF THE SPARE PART

No.	Description	Thickness (mm)
(1)	Scuttle side panel upper reinforcement	0.95

II - IN THE EVENT OF REPLACEMENT

There is only one way of replacing this part:

- complete replacement.

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

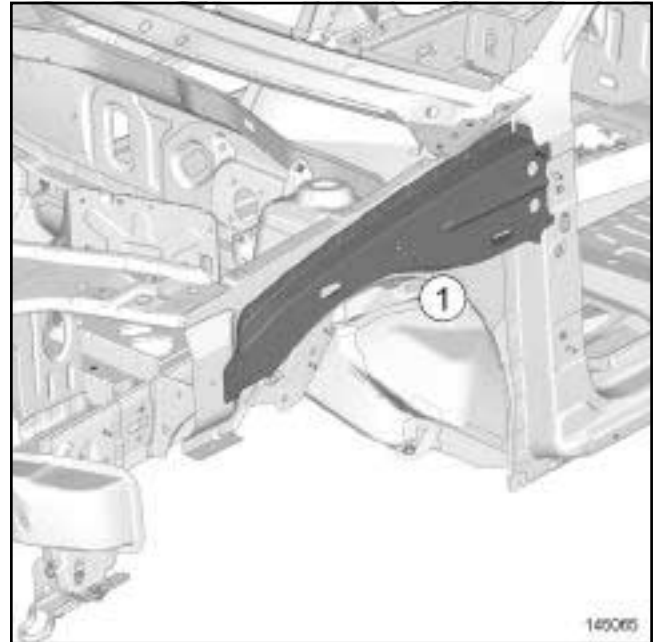
To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see **40A, General information, Earths on body: List and location of components**, page 40A-5) .

Complete replacement

Part in position



145065

145065

FRONT UPPER STRUCTURE

Front wheel arch, front section: Replacement

42A

I - COMPOSITION OF THE SPARE PART

No.	Description	Thickness (mm)
(1)	Front wheel arch, front section	1.2

II - IN THE EVENT OF REPLACEMENT

There is only one way of replacing this part:

- complete replacement.

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

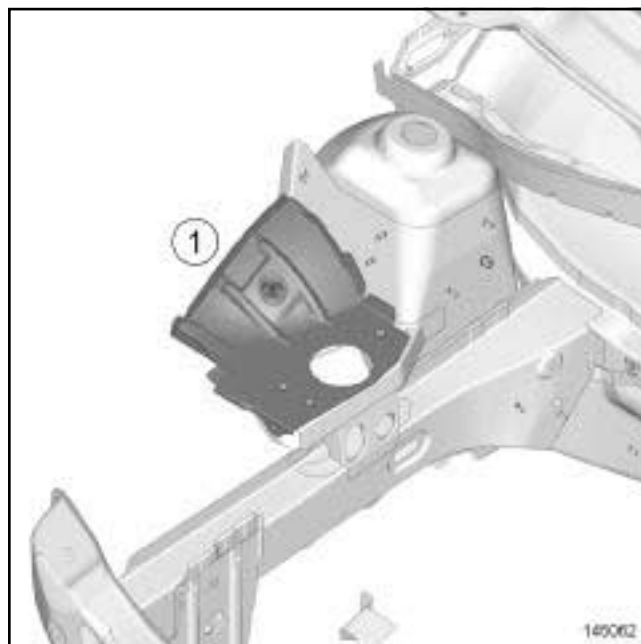
To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see **40A, General information, Earths on body: List and location of components**, page 40A-5) .

Complete replacement

Part in position



145062

145062

FRONT UPPER STRUCTURE

Heater bulkhead: Replacement

42A

I - COMPOSITION OF THE SPARE PART

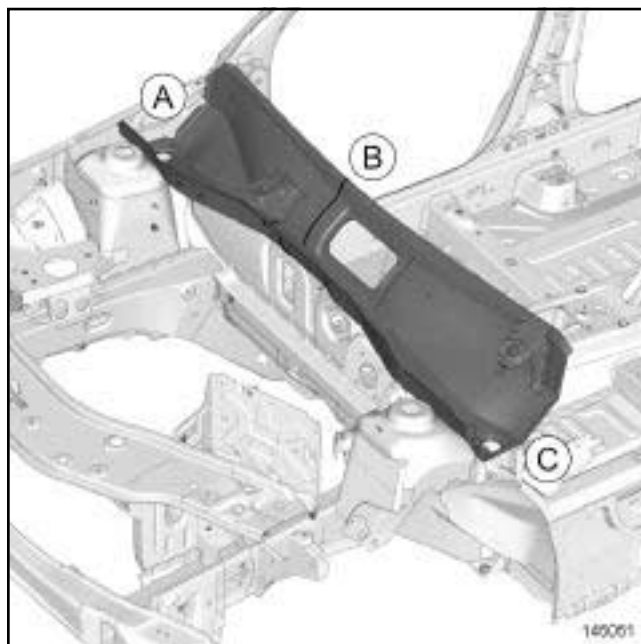


No.	Description	Thickness (mm)
(1)	Lower section of windscreen aperture lower cross member	0.95
(2)	Windscreen aperture lower cross member centre reinforcement	0.95
(3)	Reinforcement of windscreen wiper shaft left-hand mounting	1.45
(4)	Windscreen wiper plate mounting bridge	1.5

II - IN THE EVENT OF REPLACEMENT

The options for replacing this part are as follows:

- complete replacement A-C,
- partial replacement B-C.



WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

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

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see **40A, General information, Earths on body: List and location of components, page 40A-5**).

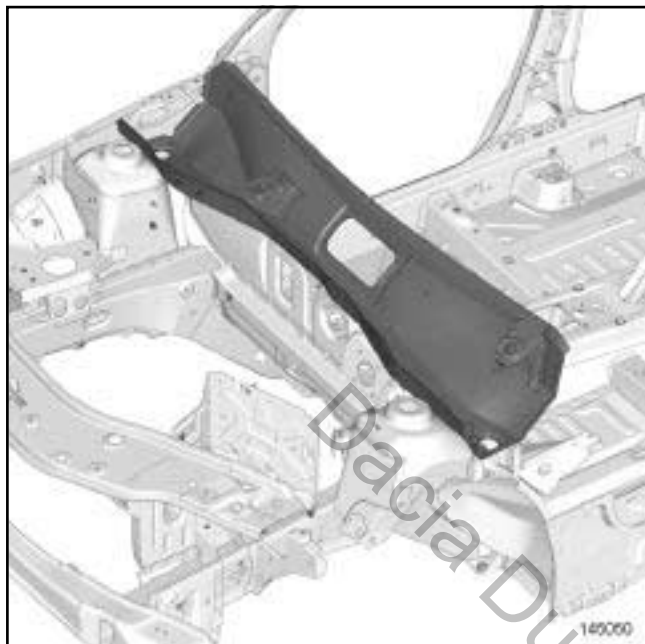
FRONT UPPER STRUCTURE

Heater bulkhead: Replacement

42A

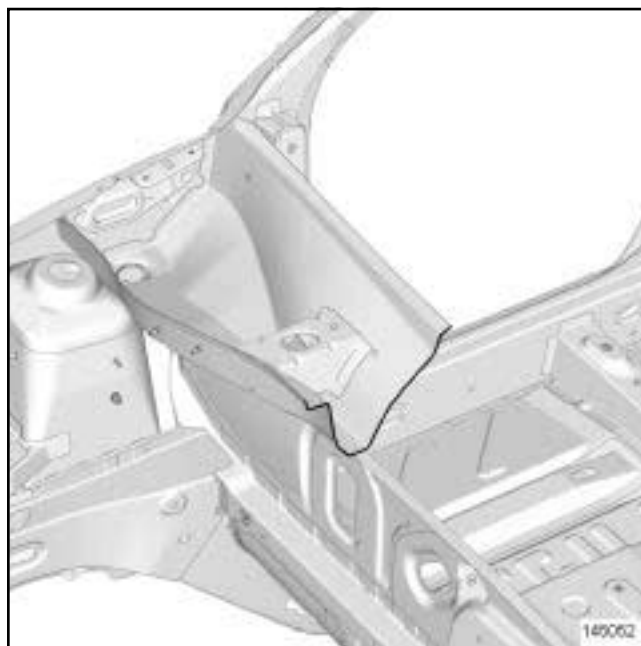
1 - Complete replacement A-C

Part in position



145050

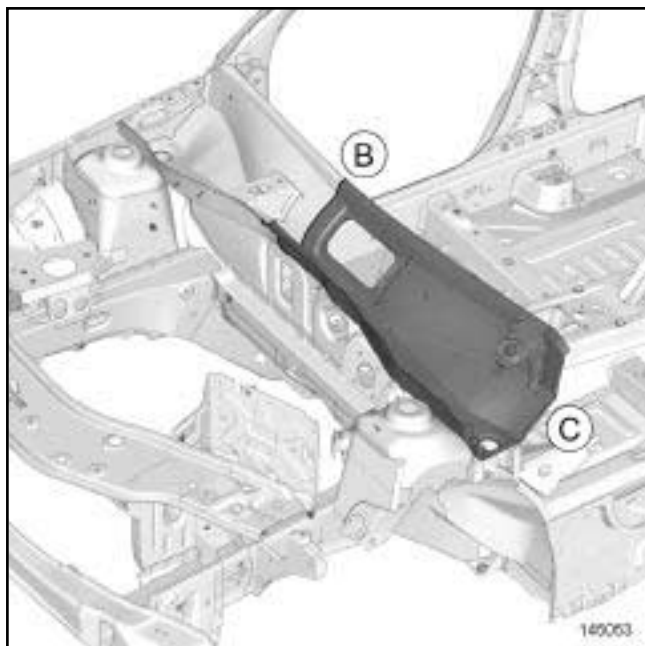
Detailed view B



145052

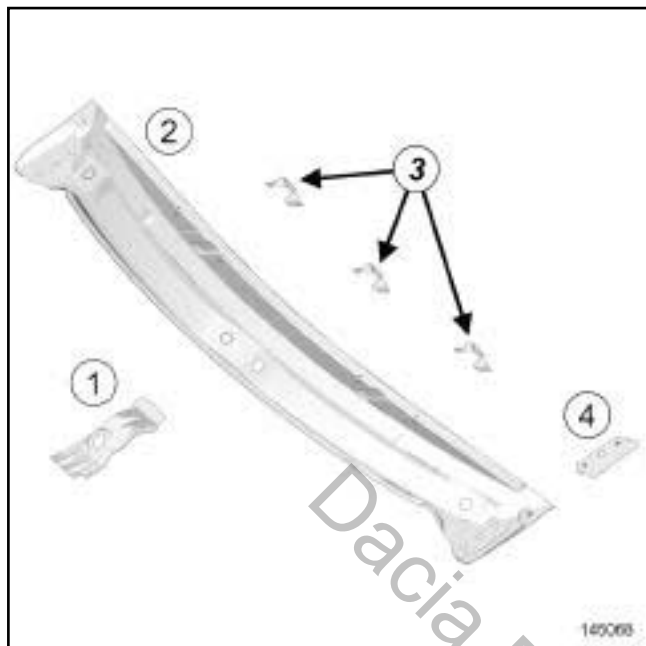
2 - Partial replacement B-C

Part in position



145053

I - COMPOSITION OF THE SPARE PART



145068

No.	Description	Thickness (mm)
(1)	Central mounting reinforcement of windscreen wiper output shaft	1.45
(2)	Upper section of windscreen aperture lower cross member	0.65
(3)	Dashboard retaining bridge piece on subframe	0.95
(4)	Reinforcement on bonnet left-hand hinge sub-frame	1.9

II - IN THE EVENT OF REPLACEMENT

There is only one way of replacing this part:

- complete replacement.

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

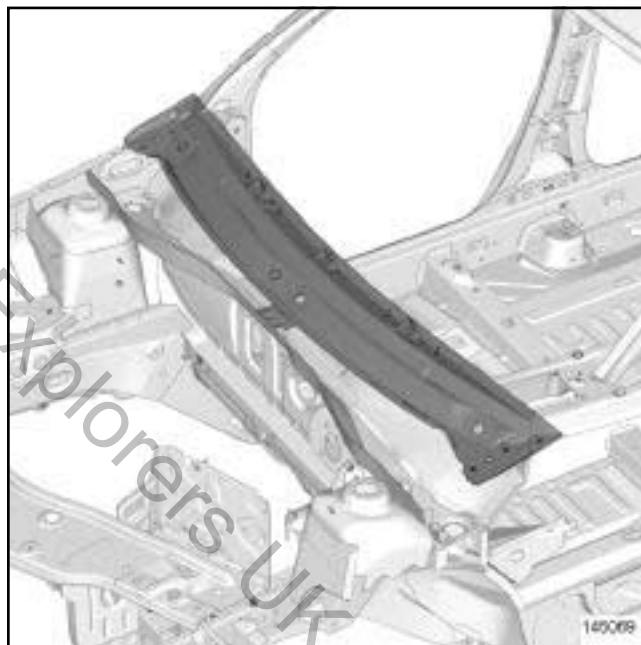
To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see 40A, General information, Earths on body: List and location of components, page 40A-5) .

Complete replacement

Part in position



145069

Equipment required

Diagnostic tool

Tightening torques

dashboard cross member bolts **21 N.m**

dashboard cross member strut mountings **21 N.m**

IMPORTANT

To avoid any risk of triggering when working on or near a pyrotechnic component (airbags or pretensioners), lock the airbag computer using the diagnostic tool.

When this function is activated, all the trigger lines are inhibited and the airbag warning light on the instrument panel lights up continuously (ignition on).

IMPORTANT

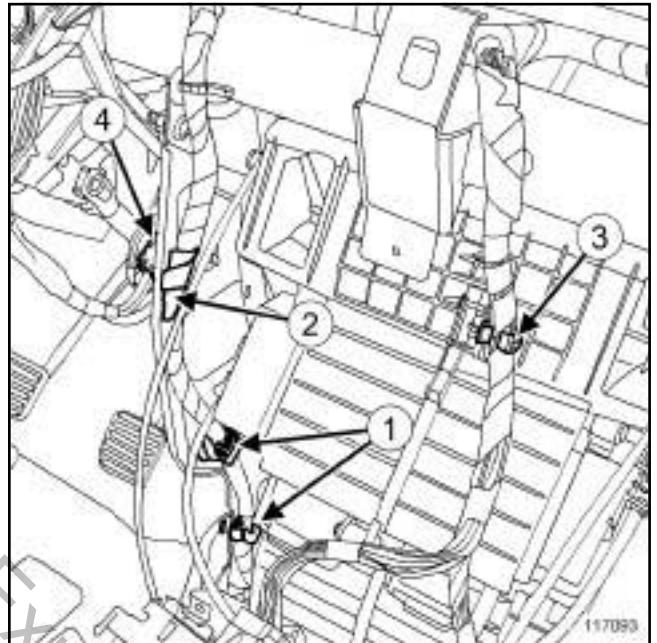
Never handle the pyrotechnic systems (pretensioners or airbags) near to a source of heat or naked flame - they may be triggered.

REMOVAL

I - REMOVAL PREPARATION OPERATION

- Lock the airbag computer using the **Diagnostic tool** (see **Fault finding - Replacement of components**) (88C, Airbag and pretensioners).
- Disconnect the battery (see **Battery: Removal - Refitting**) (80A, Battery).
- Remove:
 - the driver's front airbag (see **Driver's frontal airbag: Removal - Refitting**) (88C, Airbags and pretensioners),
 - the steering wheel (see **Steering wheel: Removal - Refitting**) (36A, Steering assembly),
 - the steering column switch assembly (see **Steering column switch assembly: Removal - Refitting**) (84A, Control - Signals),
 - the instrument panel (see **Instrument panel: Removal - Refitting**) (83A, Instrument panel),

- the radio (see **Radio: Removal - Refitting**) (86A, Radio),
- the dashboard (see **Dashboard: Removal - Refitting**) (57A, Interior equipment),
- the front air distribution ducts (see **Front air distribution duct: Removal - Refitting**) ,
- the steering column (see **Steering column: Removal - Refitting**) (36A, Steering assembly).

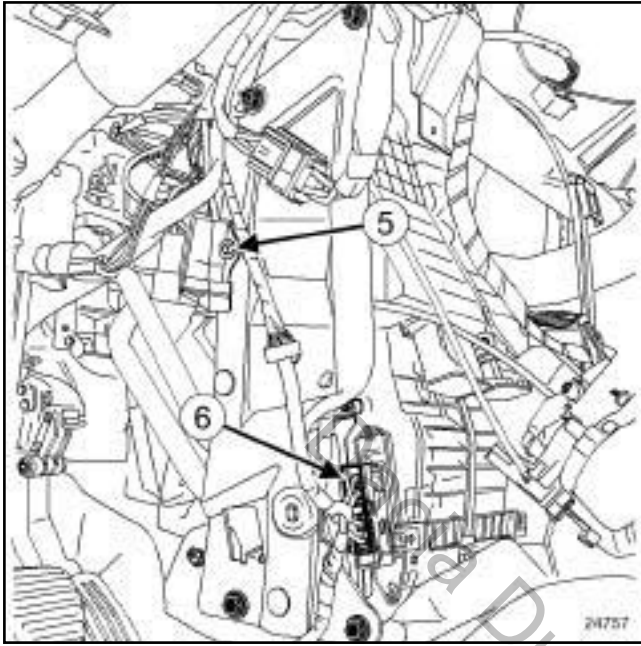


- Unclip:
 - the wiring harness at (1) ,
 - the electrical harness at (2) .
- Unclip the wiring harness on the distribution unit at (3) .

LEFT-HAND DRIVE

- Unclip the ignition switch connector (4) from its mounting.

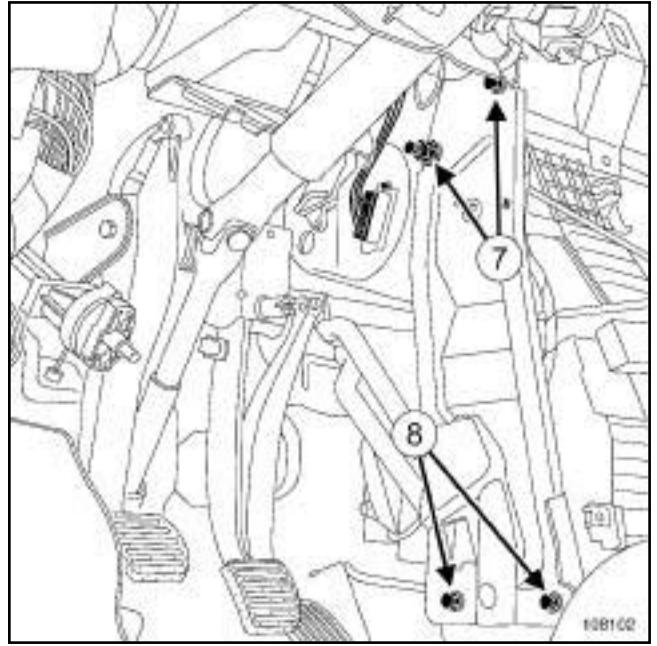
K9K



- Remove:
 - the heating resistor relay mounting bolt (5) ,
 - the heating resistor relay mounting.
- Disconnect the connector (6) from the heating resistor unit.

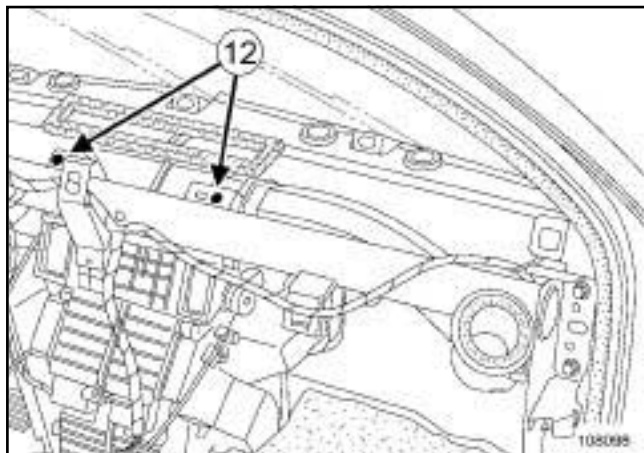
- Partially lift the floor carpet to access the strut mounting bolt.
- Mark the position of the strut on the body before removing it.

LEFT-HAND DRIVE



- Remove:
 - the two upper nuts (7) from the strut,
 - the two lower bolts (8) from the strut,
 - stay.

- Disconnect:
 - the air conditioning control panel connector,
 - the passenger compartment fan assembly connector,
 - the passenger compartment fan assembly resistor unit connector.

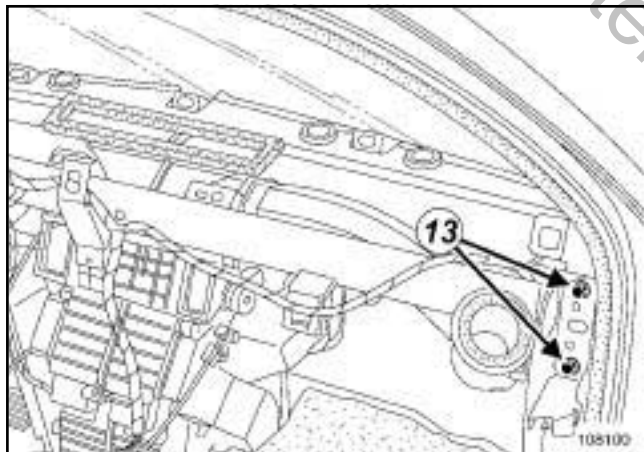


108098

Remove:

- the bolts (12) from the air distribution unit,
- the wiring harness on the dashboard cross member.

II - OPERATION FOR REMOVAL OF PART CONCERNED



108100

- Mark the position of the dashboard cross member on the body before removing it.
- Remove the dashboard cross member bolts (13) from both sides of the vehicle.

REFITTING

I - REFITTING OPERATION FOR PART CONCERNED

- Refit the dashboard cross member bolts on both sides of the vehicle, respecting the marking made before the removal operation.
- Torque tighten the **dashboard cross member bolts (21 N.m)**.

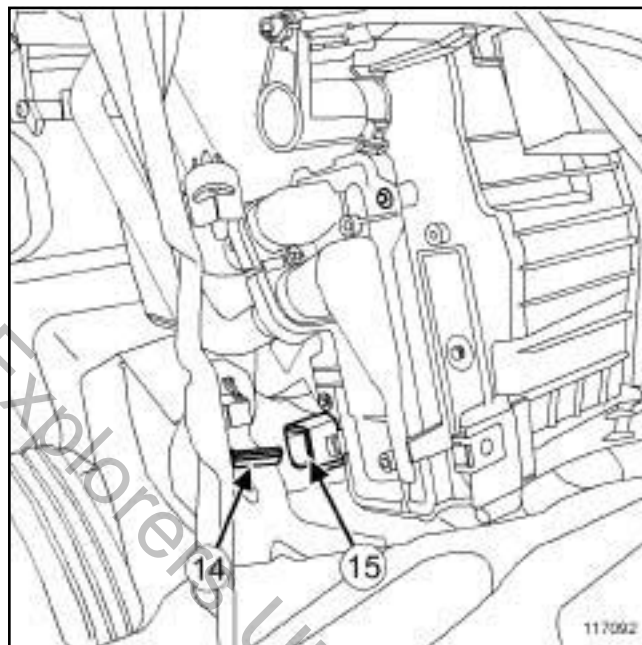
II - FINAL OPERATION

Refit:

- the wiring harness on the dashboard cross member,
- the bolts on the air distribution unit,
- the bolts on the steering column.

Reconnect:

- the passenger compartment fan assembly resistor unit connector,
- the passenger compartment fan assembly connector,
- the air conditioning control panel connector.



117092

Refit:

- the strut, by positioning the strut bracket (14) in the distribution unit hole (15) ,
- the two lower bolts on the strut, respecting the marking made during the removal operation,
- the two upper nuts to the strut.

Torque tighten the **dashboard cross member strut mountings (21 N.m)**.

Refit the floor carpet.

K9K

Reconnect heating resistor unit connector.

Refit:

- the heating resistor relay mounting.

Dashboard cross member: Removal - Refitting

- the heating resistor relay mounting bolt.

Clip on:

- the starter switch connector on its mounting.
- the wiring harness on the strut.

Clip:

- the wiring harness on the distribution unit,
- the wiring harness on the strut.

Refit:

- the steering column (see **Steering column: Removal - Refitting**) (36A, Steering assembly).
 - the front air distribution ducts (see **Front air distribution duct: Removal - Refitting**),
 - the dashboard (see **Dashboard: Removal - Refitting**) (57A, Interior equipment),
 - the radio (see **Radio: Removal - Refitting**) (86A, Radio),
 - the instrument panel (see **Instrument panel: Removal - Refitting**) (83A, Instrument panel),
 - the steering column switch assembly (see **Steering column switch assembly: Removal - Refitting**) (84A, Control - Signals),
 - the steering wheel (see **Steering wheel: Removal - Refitting**) (36A, Steering assembly),
 - the driver's front airbag (see **Driver's frontal airbag: Removal - Refitting**) (88C, Airbags and seat belt pretensioners).
- Connect the battery (see **Battery: Removal - Refitting**) (80A, Battery).
- Unlock the airbag computer using the **Diagnostic tool** (see **Fault finding - Replacement of components**) (88C, Airbags and pretensioners).

FRONT UPPER STRUCTURE

Headlight carrier panel: Replacement

42A

I - COMPOSITION OF THE SPARE PART

No.	Description	Thickness (mm)
(1)	Headlight carrier panel	1

II - IN THE EVENT OF REPLACEMENT

There is only one way of replacing this part:

- complete replacement.

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

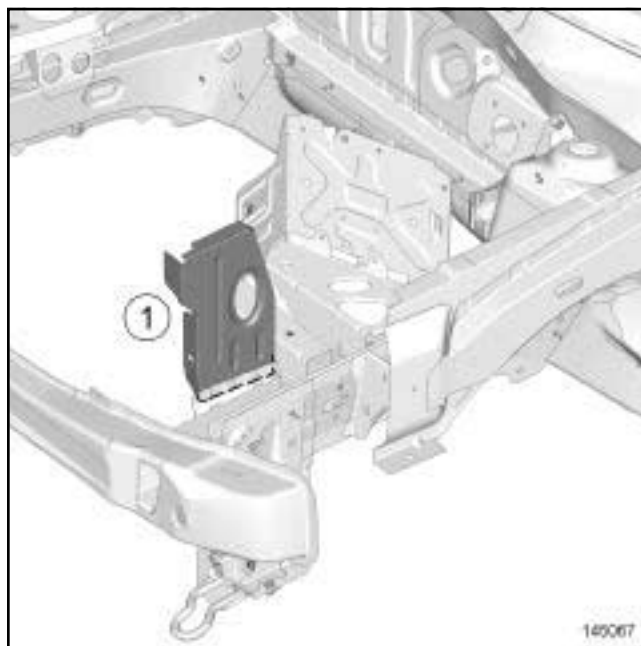
To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see **40A, General information, Earths on body: List and location of components**, page **40A-5**) .

Complete replacement

Part in position



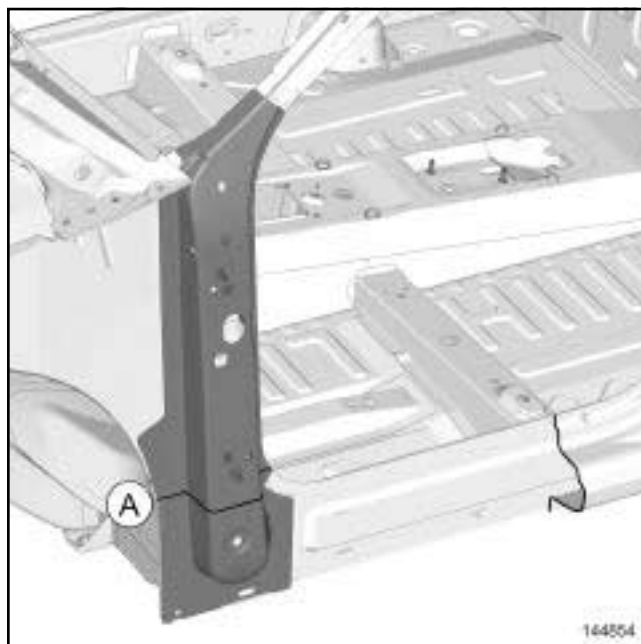
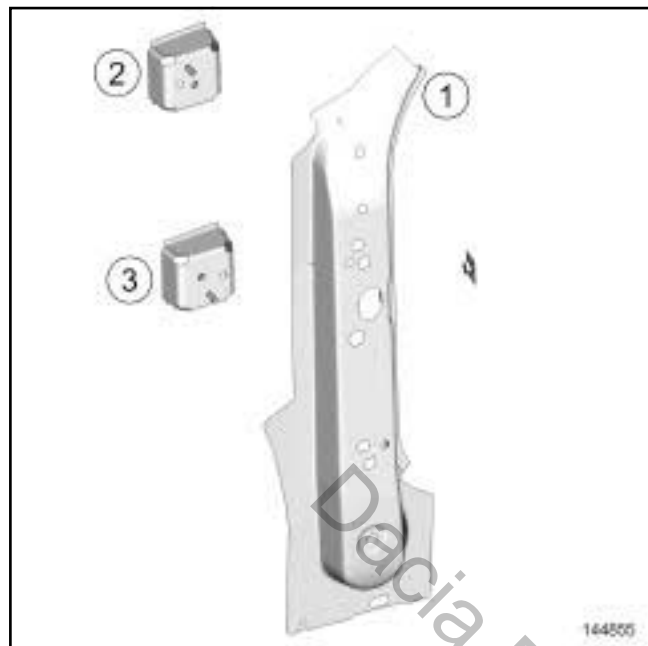
145067

SIDE UPPER STRUCTURE

A-pillar reinforcement: Replacement

43A

I - COMPOSITION OF THE SPARE PART



No.	Description	Thickness (mm)
(1)	A-pillar reinforcement	1.2
(2)	Upper hinge reinforcement of front side door on body	2
(3)	Lower hinge reinforcement of front side door on body	2

II - IN THE EVENT OF REPLACEMENT

The options for replacing this part are as follows:

- Complete replacement
- partial replacement along cut A.

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

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

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see **40A, General information, Earths on body: List and location of components**, page 40A-5) .

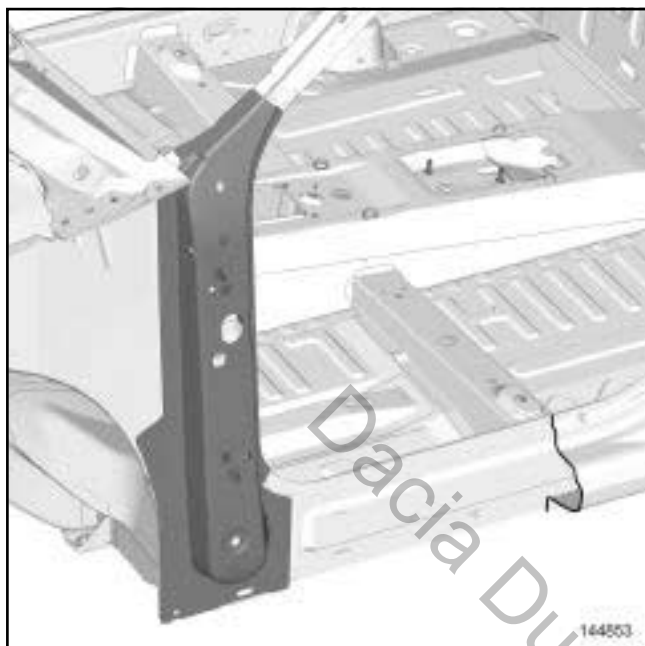
SIDE UPPER STRUCTURE

A-pillar reinforcement: Replacement

43A

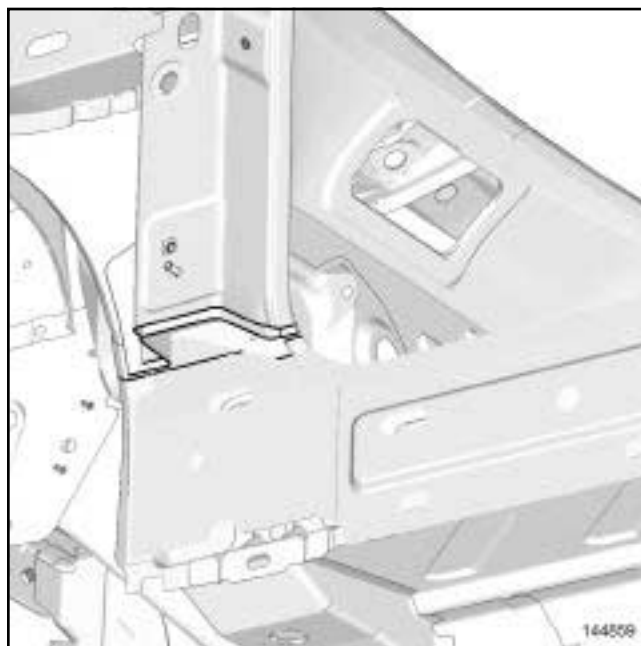
1 - Complete replacement

Part in position



144853

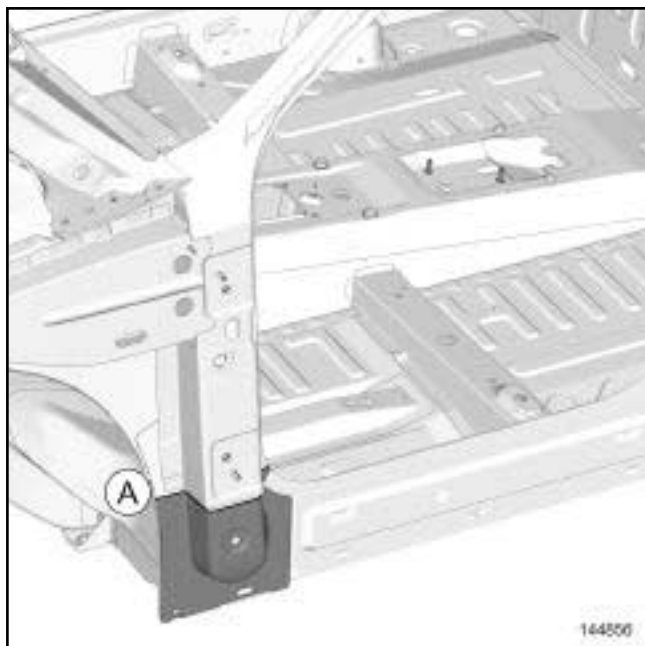
Detailed view A



144859

2 - Partial replacement A

Part in position



144856

SIDE UPPER STRUCTURE

Windscreen pillar lining: Replacement

43A

I - COMPOSITION OF THE SPARE PART

No.	Description	Thickness (mm)
(1)	Windscreen pillar lining	1.15

II - IN THE EVENT OF REPLACEMENT

There is only one way of replacing this part:

- complete replacement.

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

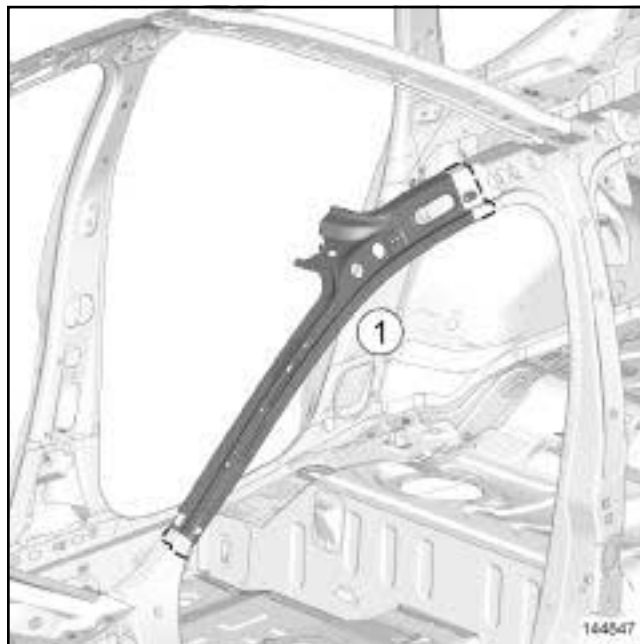
To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see **40A, General information, Earths on body: List and location of components**, page 40A-5) .

Complete replacement

Part in position



144847

SIDE UPPER STRUCTURE

B-pillar reinforcement: Replacement

43A

I - COMPOSITION OF THE SPARE PART



144858

No.	Description	Thickness (mm)
(1)	B-pillar impact reinforcement	1.5
(2)	B-pillar impact reinforcement component	1.8
(3)	Upper hinge reinforcement of rear side door on body	1.2
(4)	Sensor mounting bridge for side airbag	1.5
(5)	Lower hinge reinforcement of rear side door on body	1.2

II - IN THE EVENT OF REPLACEMENT

There is only one way of replacing this part:

- complete replacement.

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

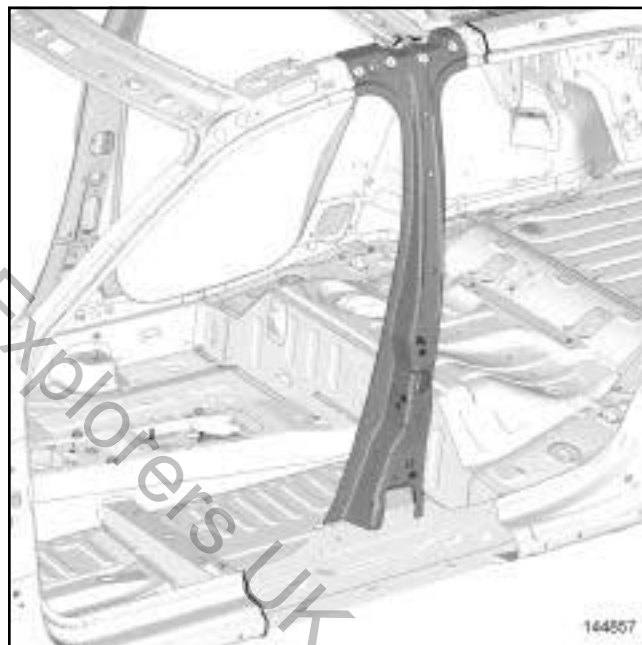
To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see 40A, General information, Earths on body: List and location of components, page 40A-5) .

Complete replacement

Part in position



144857

SIDE UPPER STRUCTURE

B-pillar lining: Replacement

43A

I - COMPOSITION OF THE SPARE PART



144849

No.	Description	Thickness (mm)
(1)	B-pillar lining	1.15
(2)	Anchorage reinforcement for first row seat belt	1.5

II - IN THE EVENT OF REPLACEMENT

There is only one way of replacing this part:

- complete replacement.

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

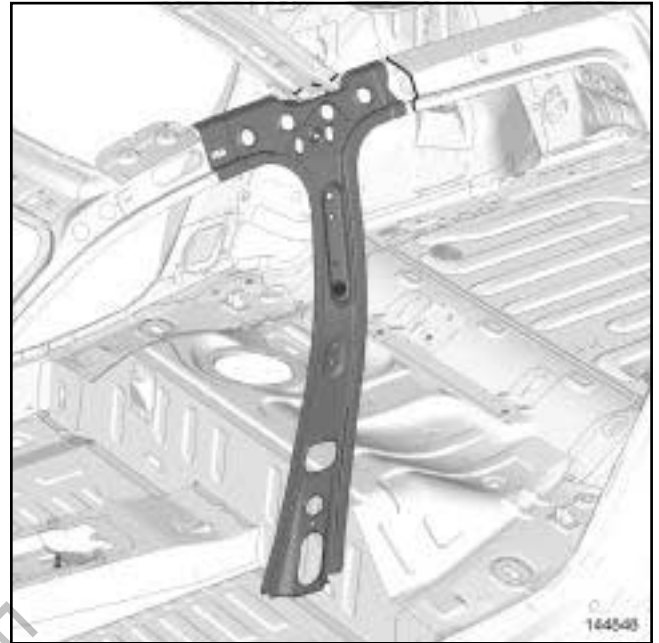
To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see 40A, General information, Earths on body: List and location of components, page 40A-5) .

Complete replacement

Part in position



144848

SIDE UPPER STRUCTURE

B-pillar lower lining: Replacement

43A

I - COMPOSITION OF THE SPARE PART

No.	Description	Thickness (mm)
(1)	B-pillar lower lining	0.95

II - IN THE EVENT OF REPLACEMENT

There is only one way of replacing this part:

- complete replacement.

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

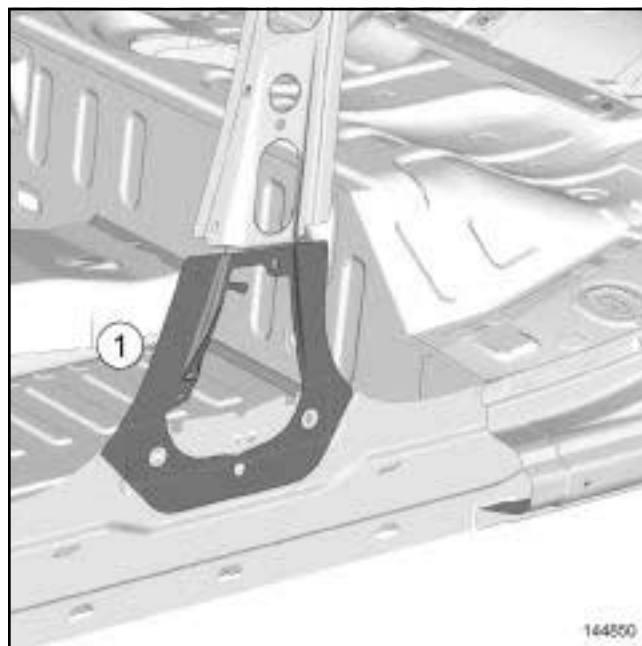
To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see **40A, General information, Earths on body: List and location of components**, page 40A-5) .

Complete replacement

Part in position



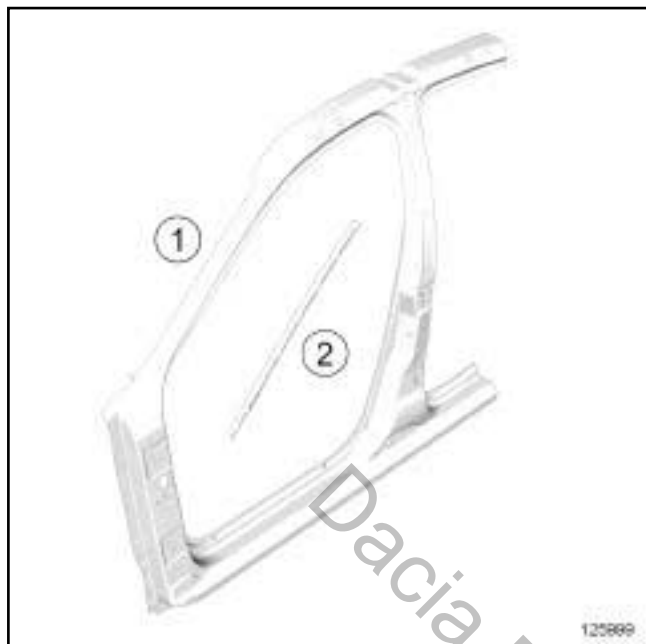
144850

SIDE UPPER STRUCTURE

Body side, front section: Replacement

43A

I - COMPOSITION OF THE SPARE PART

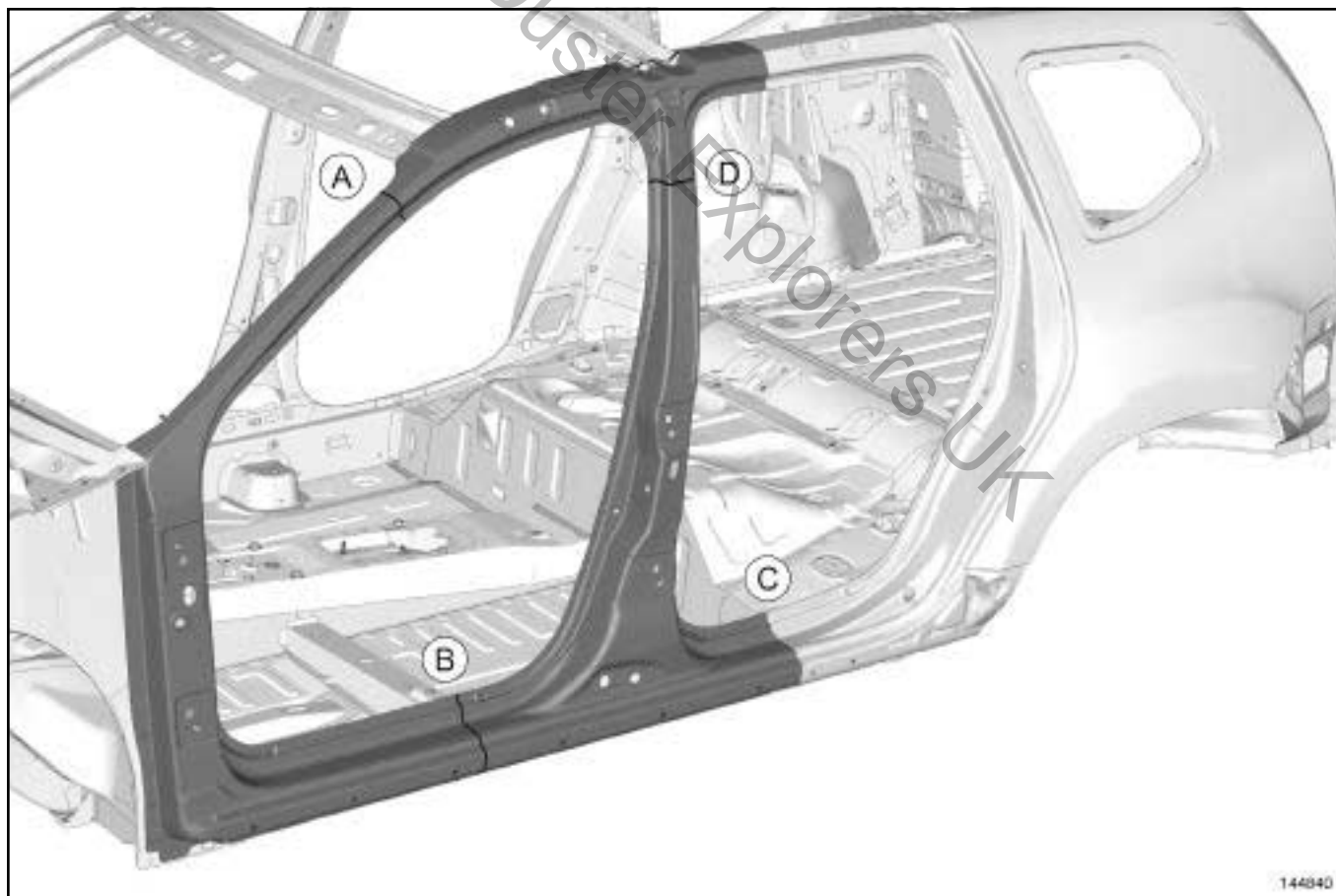


No.	Description	Thickness (mm)
(1)	Body side, front section	0.95
(2)	Double seal support	0.65

II - IN THE EVENT OF REPLACEMENT

The options for replacing this part are as follows:

- Complete replacement
- partial replacement A-B,
- partial replacement B-D-C,
- partial replacement low section A-D.



144840

SIDE UPPER STRUCTURE

Body side, front section: Replacement

43A

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

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

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

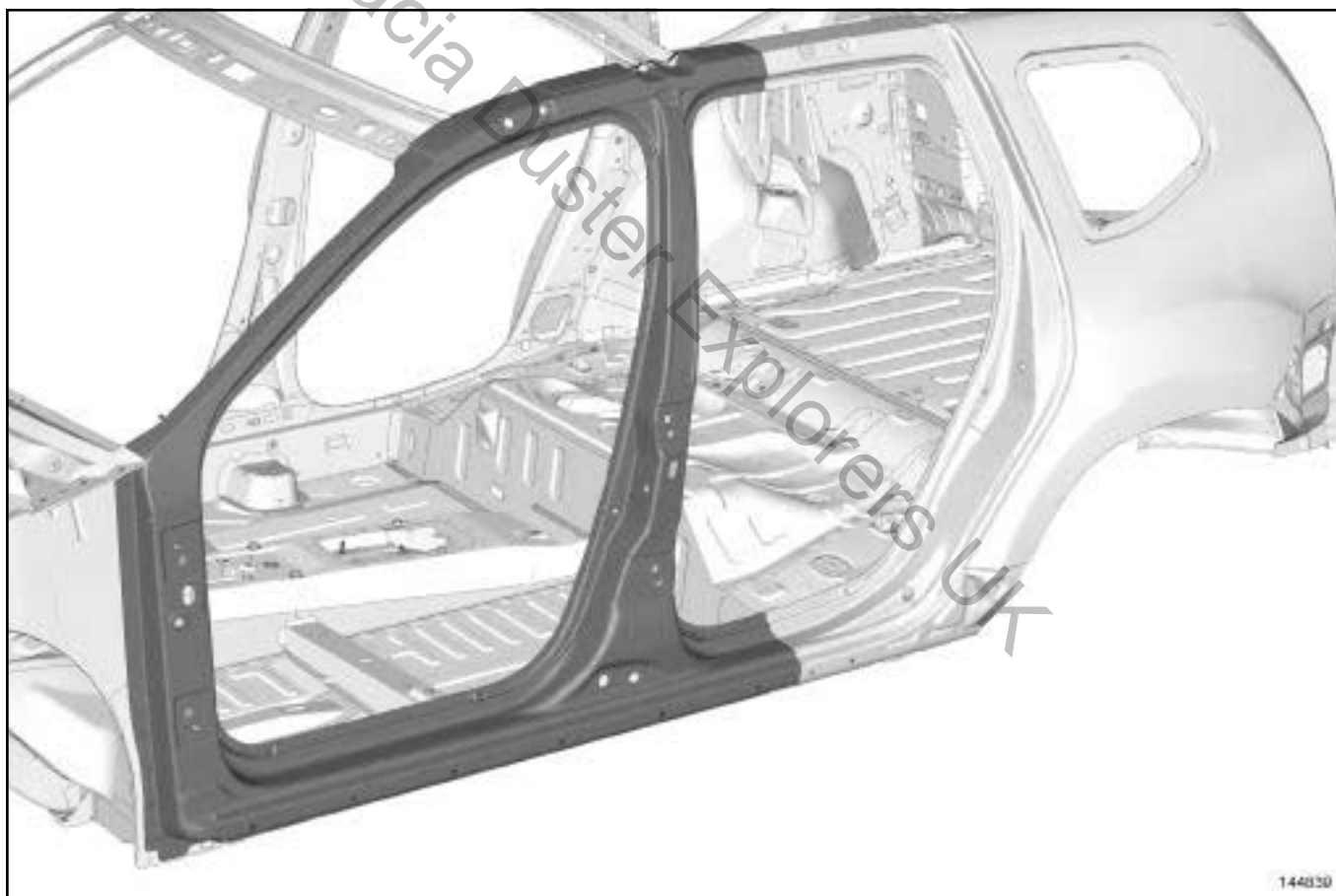
Locate the earths located near to the weld area (see 40A, General information, Earths on body: List and location of components, page 40A-5) .

1 - Complete replacement

Part in position

Note:

To replace the body side front section, also order the double seal mounting (2) .



144839

2 - Partial replacement A-B

Part in position

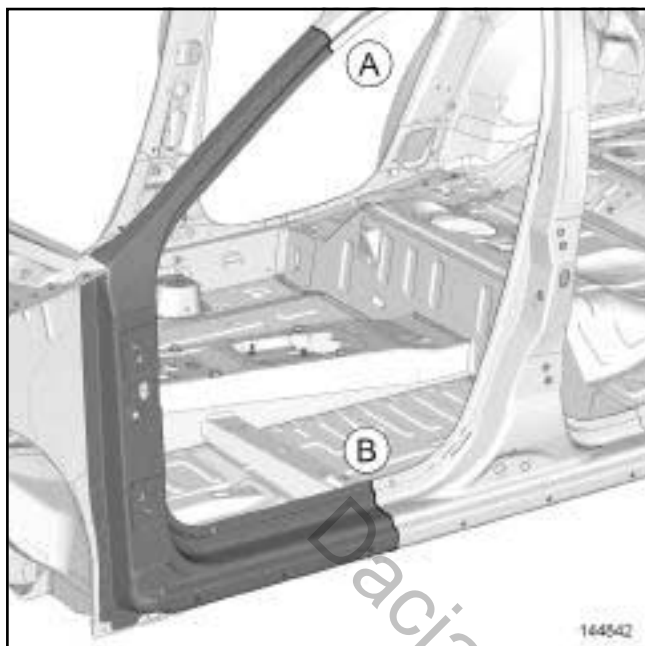
Note:

To partially replace the body side front section along cut A-B, also order the double seal mounting (2) .

SIDE UPPER STRUCTURE

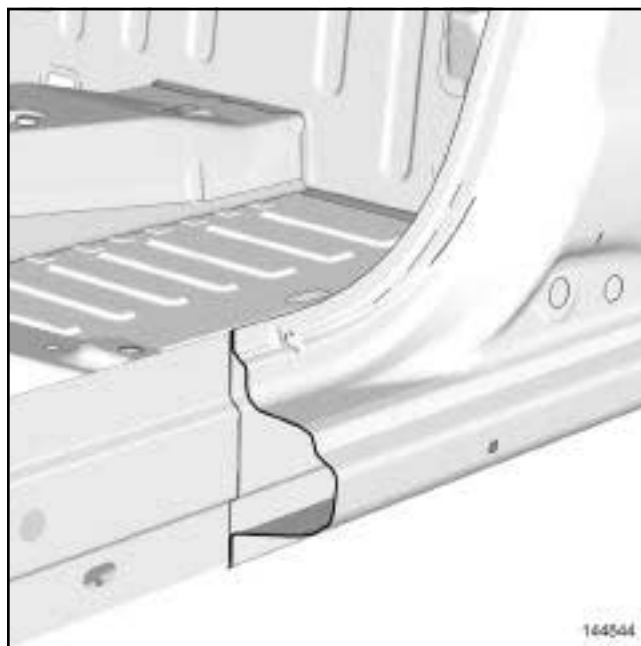
Body side, front section: Replacement

43A



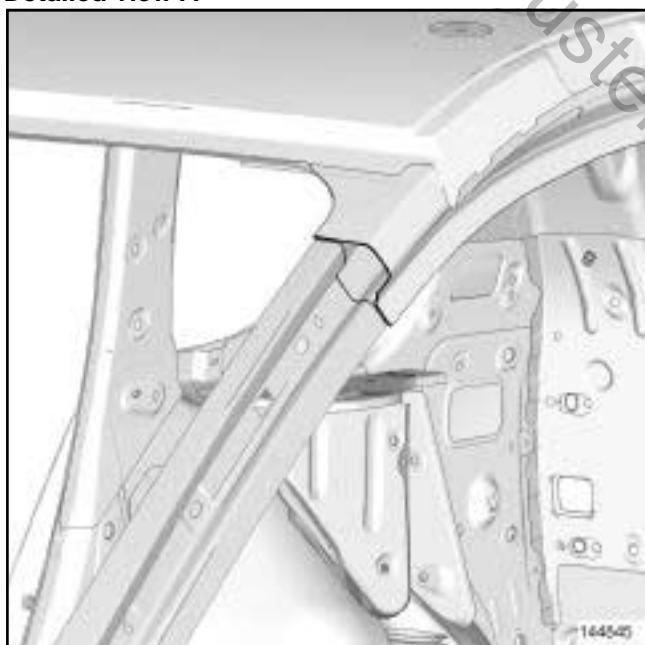
144842

Detailed view B



144844

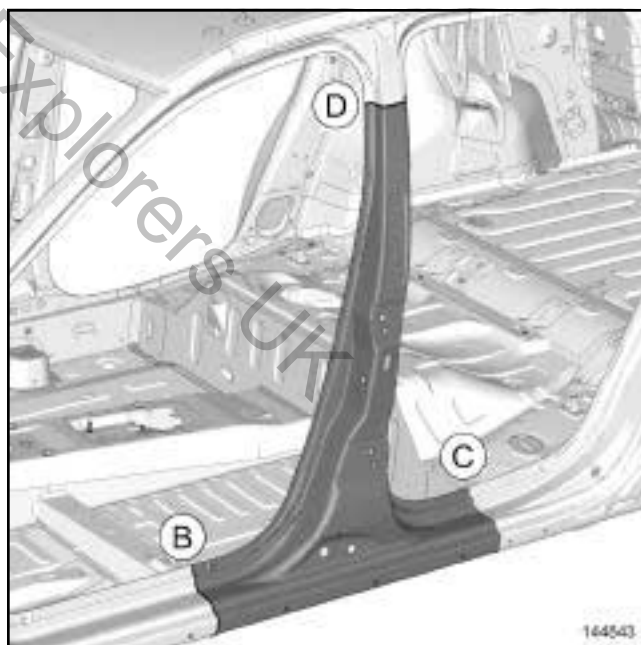
Detailed view A



144845

3 - Partial replacement B-D-C

Part in position



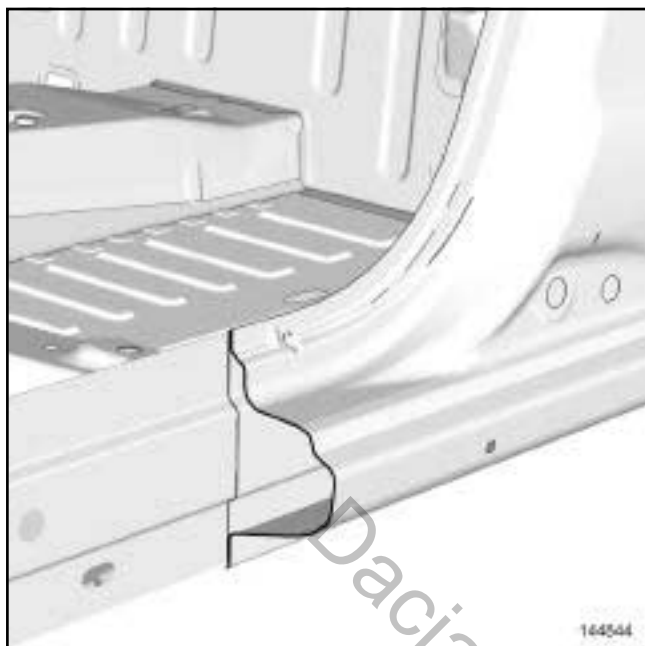
144843

SIDE UPPER STRUCTURE

Body side, front section: Replacement

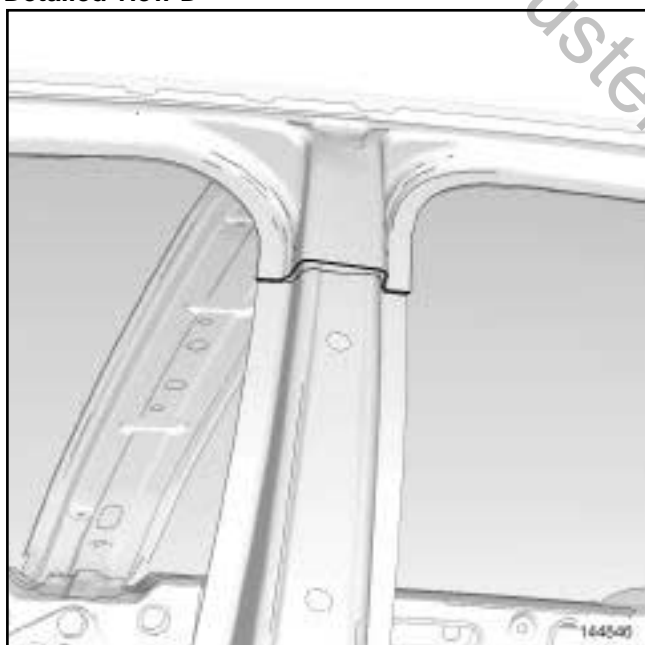
43A

Detailed view B



144844

Detailed view D



144846

4 - Partial replacement A-D

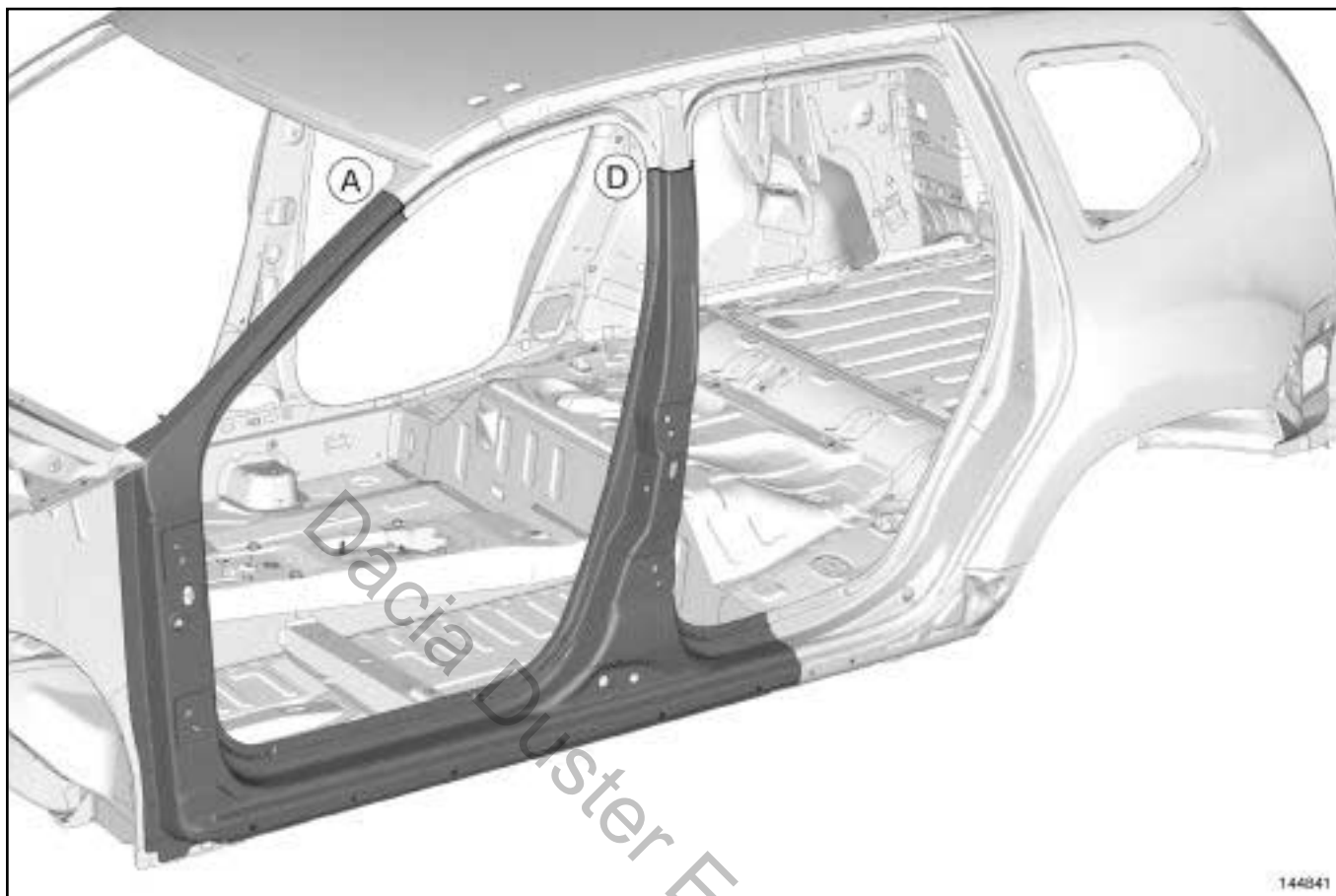
Part in position

Note:

To replace the body side front section along cut A-D, also order the double seal mounting **(2)**.

SIDE UPPER STRUCTURE
Body side, front section: Replacement

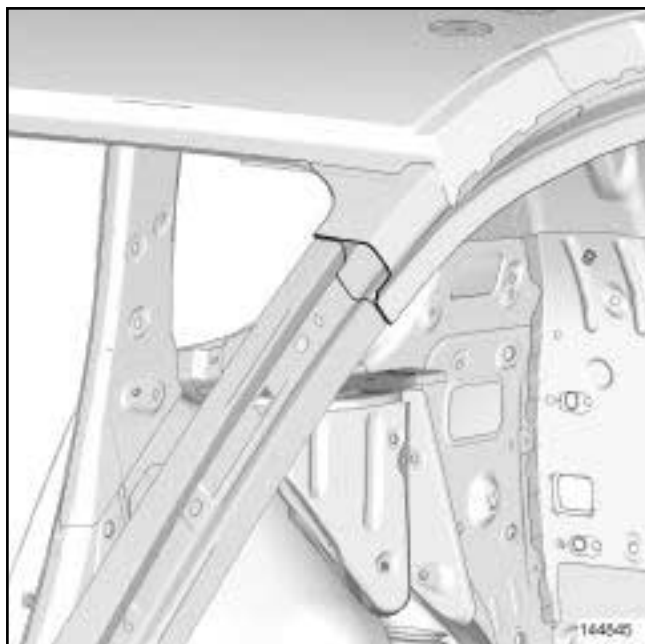
43A



144841

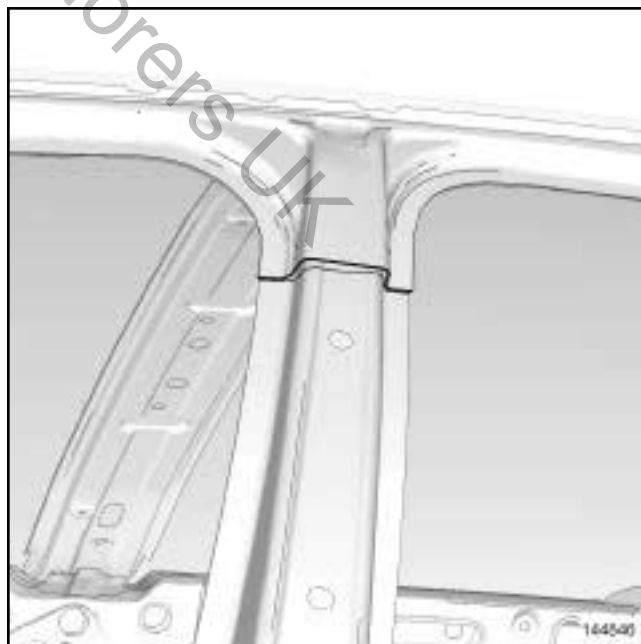
144841

Detailed view A



144845

Detailed view D



144846

SIDE UPPER STRUCTURE

Roof bar mounting: Replacement

43A

I - COMPOSITION OF THE SPARE PART

No.	Description	Thickness (mm)
(1)	Front roof bar mounting	2
(2)	Rear roof bar mounting	2

II - IN THE EVENT OF REPLACEMENT

There is only one way of replacing this part:

- complete replacement.

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

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

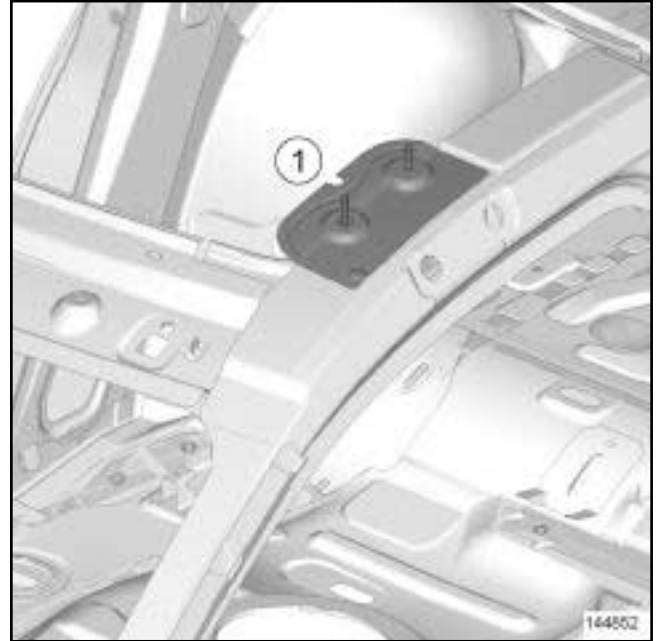
Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see **40A, General information, Earths on body: List and location of components**, page **40A-5**) .

Complete replacement

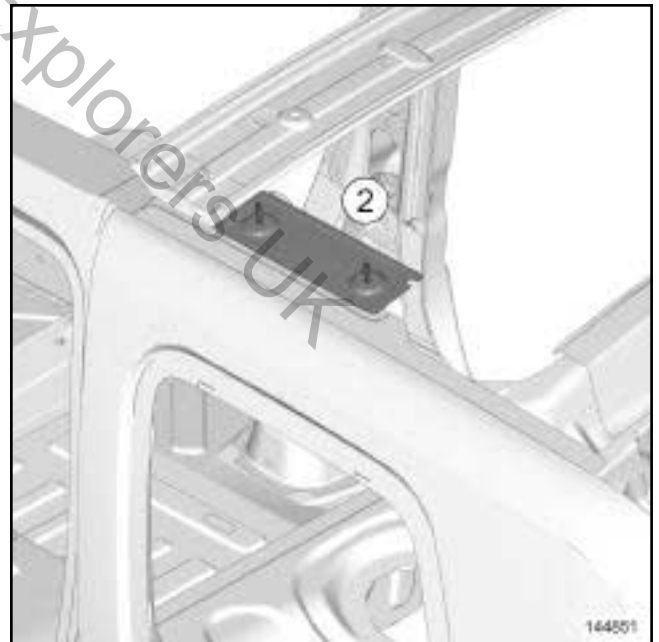
Part in position

Front roof bar mounting



144852

Rear roof bar mounting



144851

REAR UPPER STRUCTURE

Rear wing panel: Replacement

44A

I - COMPOSITION OF THE SPARE PART

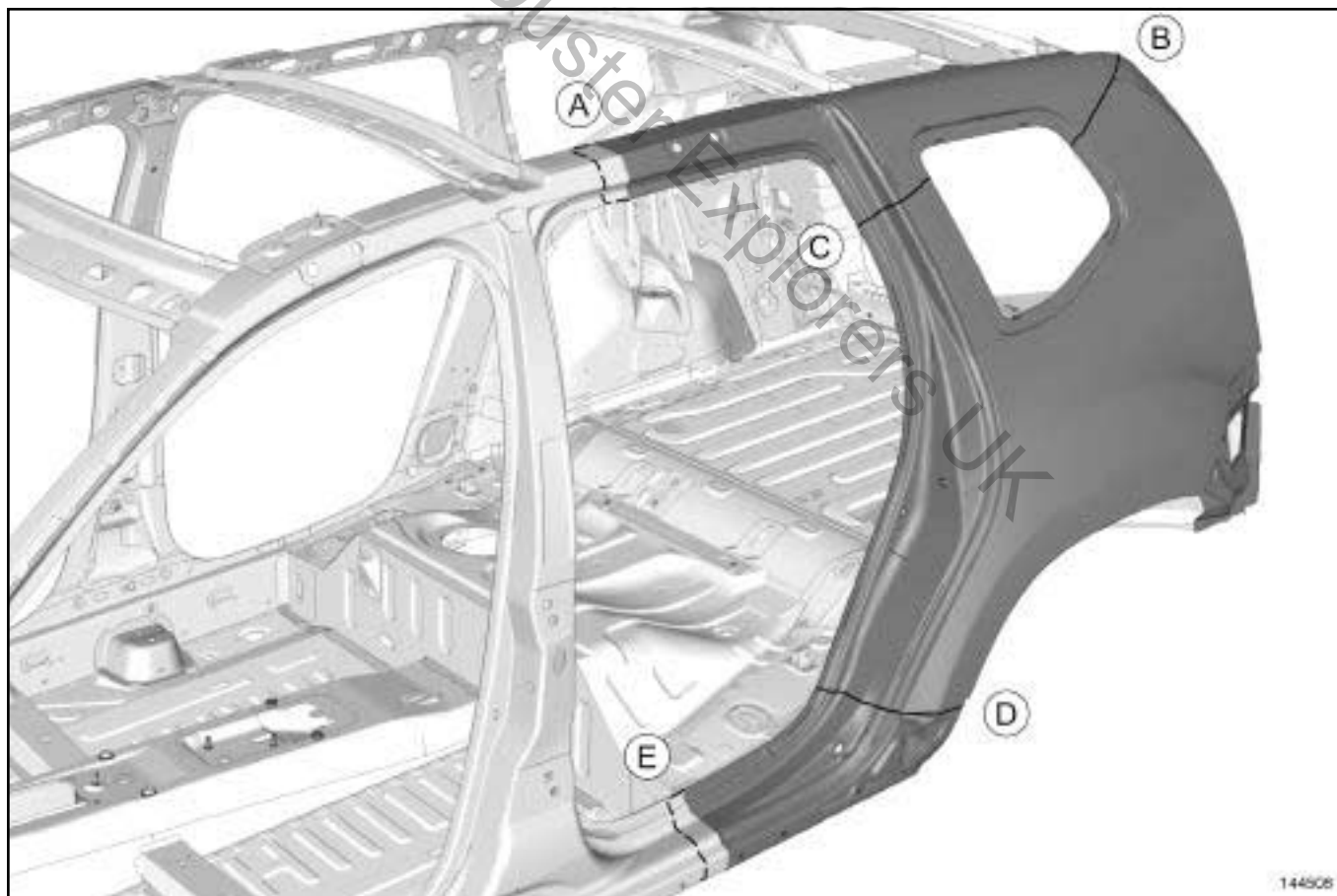


No.	Description	Thickness (mm)
(1)	Rear wing panel	0.65
(2)	Rear door striker plate reinforcement,	1.2

II - IN THE EVENT OF REPLACEMENT

The options for replacing this part are as follows:

- complete replacement A-E,
- partial replacement B-C-E,
- partial replacement B-C-D.



145008

REAR UPPER STRUCTURE

Rear wing panel: Replacement

44A

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

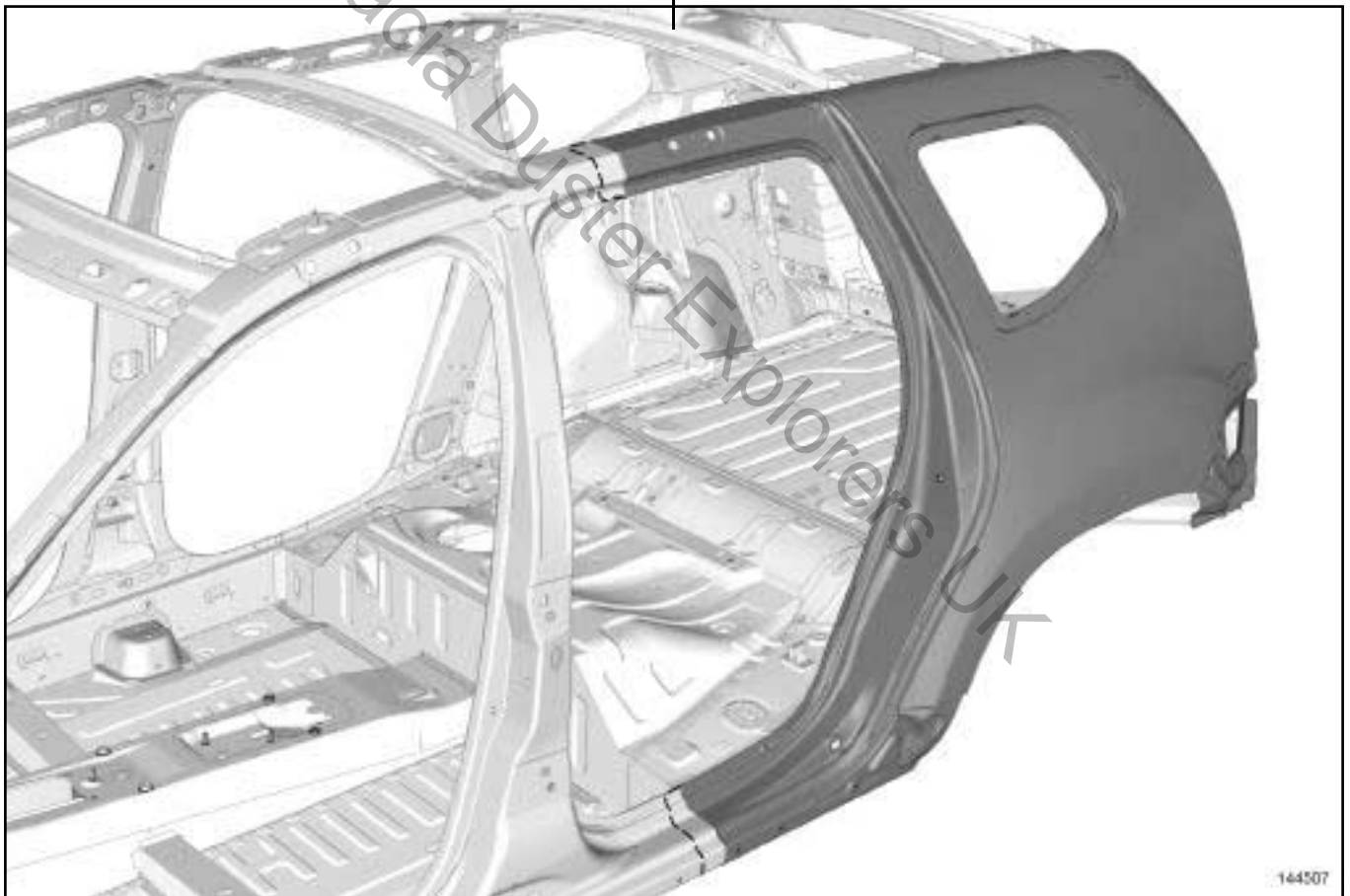
To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see 40A, General information, Earths on body: List and location of components, page 40A-5) .

1 - Complete replacement A-E

a - Part in position



144507

145007

b - Irremovable bodywork components - structures to be removed in order to carry out the replacement operation

Remove the roof (see 45A, Top of body, Roof: Replacement, page 45A-1) .

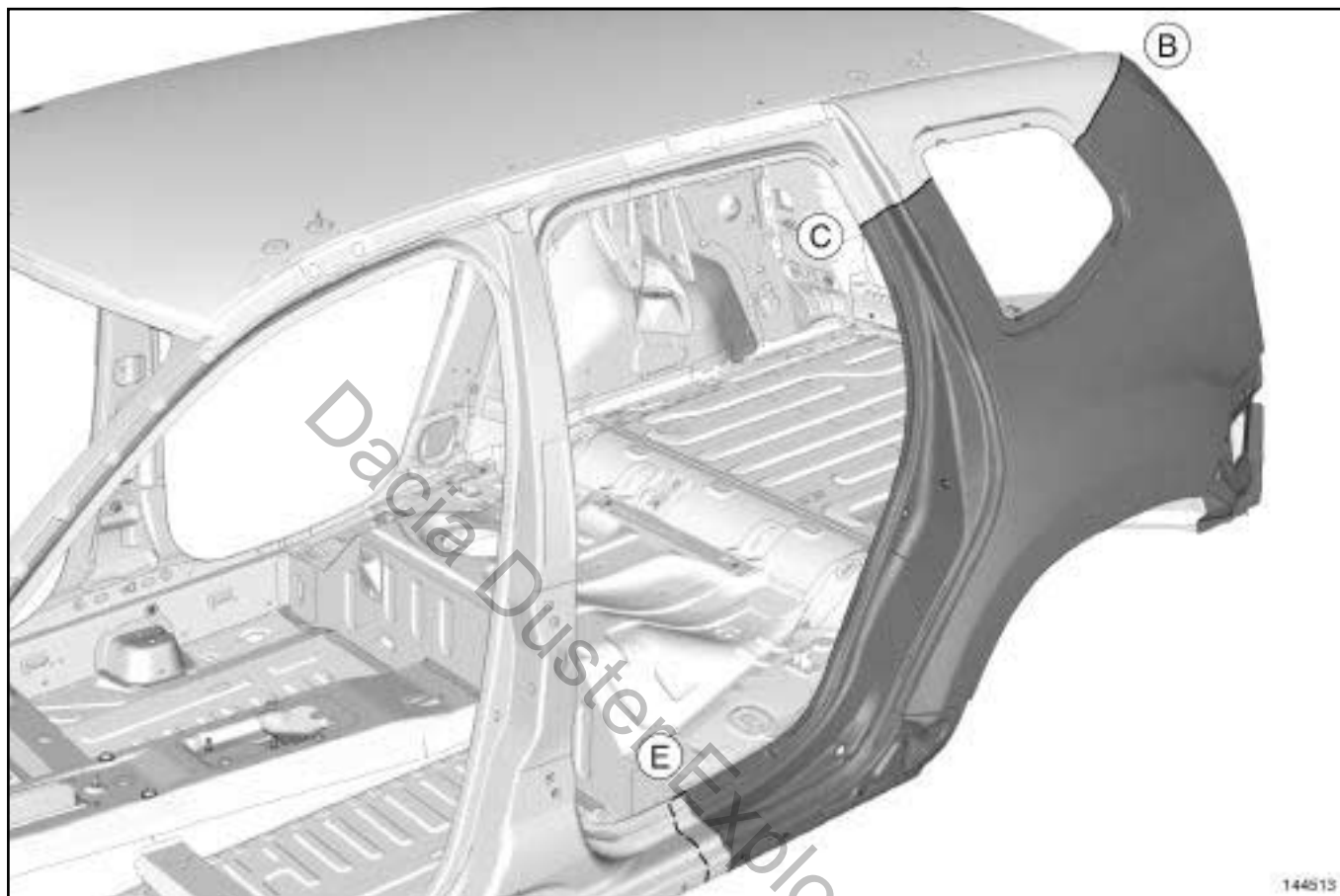
REAR UPPER STRUCTURE

Rear wing panel: Replacement

44A

2 - Partial replacement B-C-E

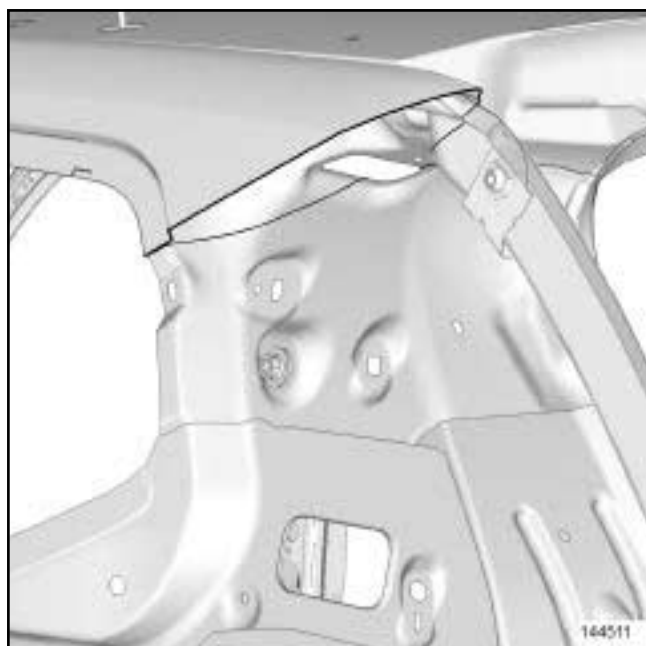
Part in position



144513

145013

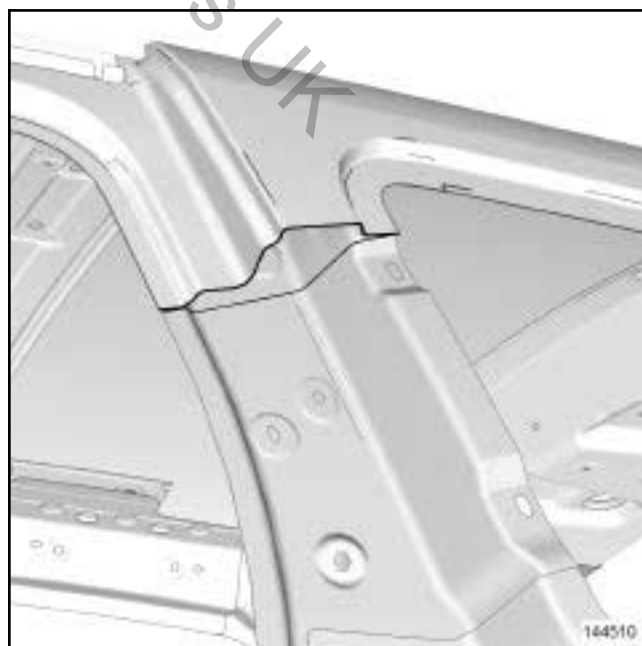
Detailed view B



144511

145011

Detailed view C



144510

145010

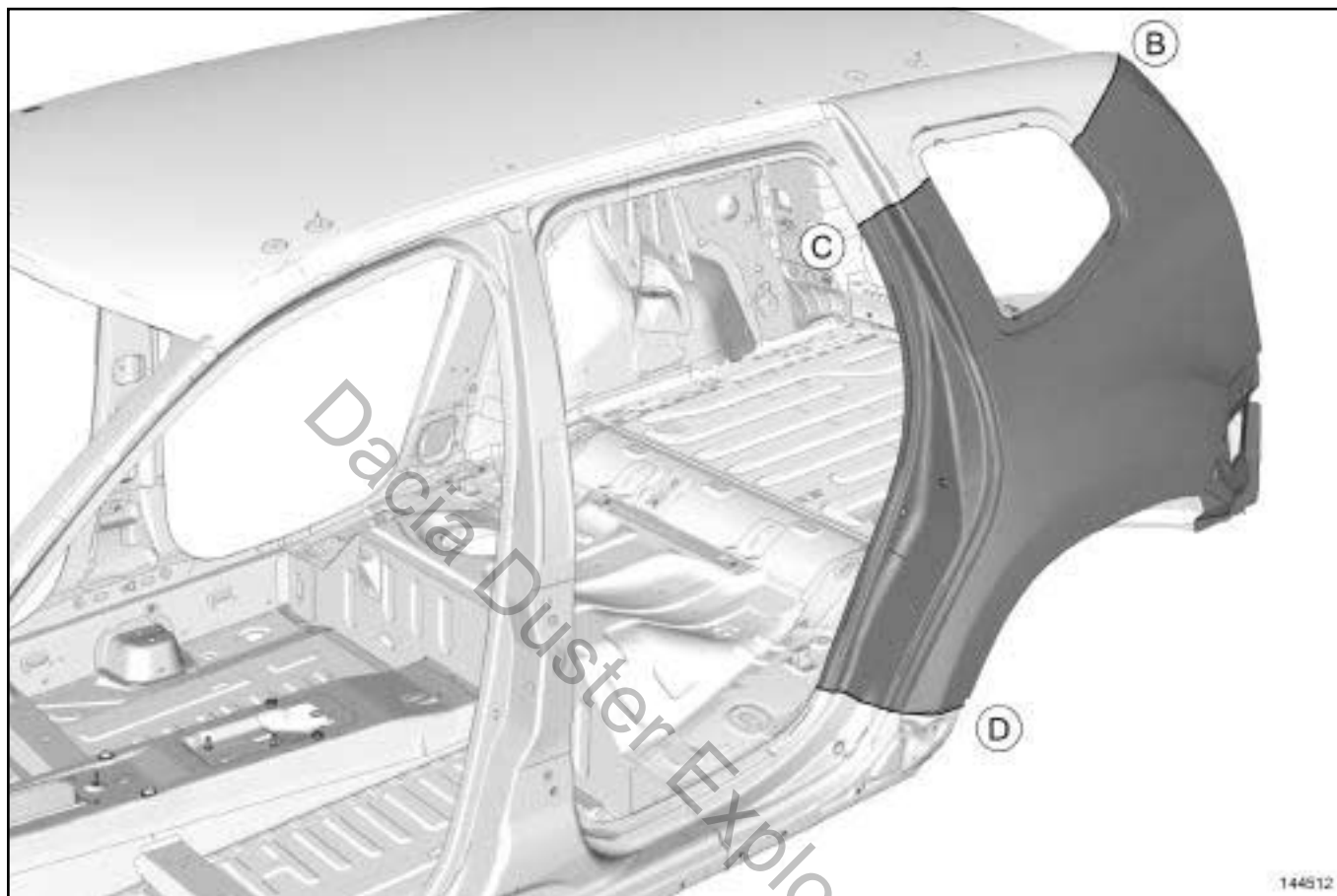
REAR UPPER STRUCTURE

Rear wing panel: Replacement

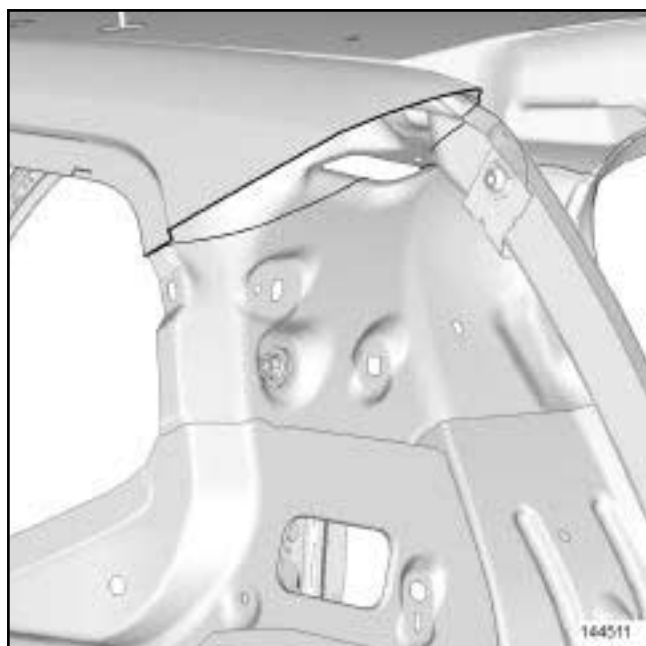
44A

3 - Partial replacement B-C-D

Part in position

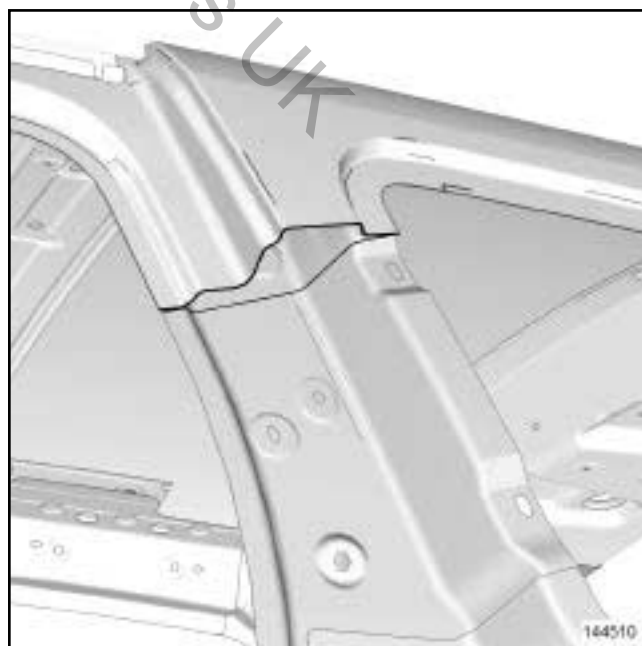


Detailed view B



145011

Detailed view C



145010

REAR UPPER STRUCTURE

Rear wing panel: Replacement

44A

Detailed view D



145009

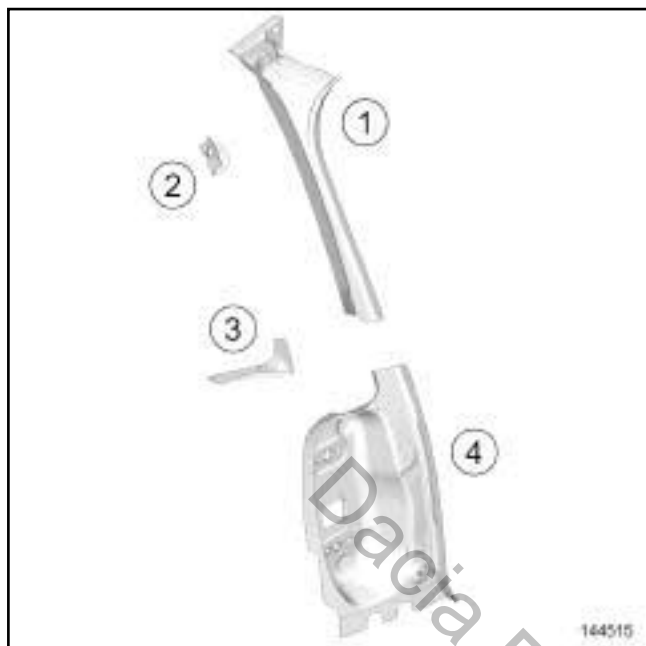
Dacia Duster Explorers UK

REAR UPPER STRUCTURE

Rear light mounting: Replacement

44A

I - COMPOSITION OF THE SPARE PART



145015

No.	Description	Thickness (mm)
(1)	Rear side rain channel	0.85
(2)	Strut mounting reinforcement	2
(3)	Closure panel component of rear light mounting	0.95
(4)	Rear light mounting	0.95

II - IN THE EVENT OF REPLACEMENT

There is only one way of replacing this part:

- complete replacement.

Note:

It is preferable to unclip the rear side rain channel if it has not been affected by the impact.

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

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

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see 40A, General information, Earths on body: List and location of components, page 40A-5) .

Complete replacement

Part in position



145016

REAR UPPER STRUCTURE

Light mounting lining: Replacement

44A

I - COMPOSITION OF THE SPARE PART

No.	Description	Thickness (mm)
(1)	Rear light mounting lining	0.65

II - IN THE EVENT OF REPLACEMENT

There is only one way of replacing this part:

- complete replacement.

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

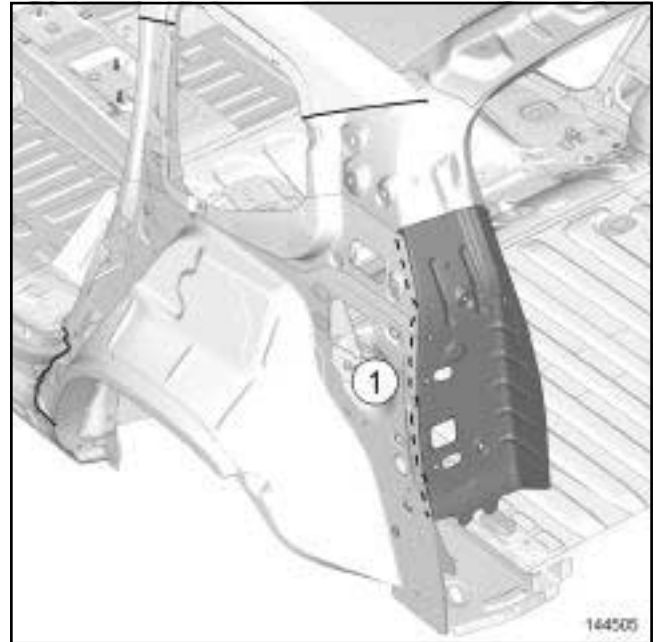
To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see **40A, General information, Earths on body: List and location of components**, page 40A-5) .

Complete replacement

Part in position



145005

REAR UPPER STRUCTURE

Quarter panel lining: Replacement

44A

I - COMPOSITION OF THE SPARE PART

No.	Description	Thickness (mm)
(1)	Quarter panel lining	0.65

II - IN THE EVENT OF REPLACEMENT

There is only one way of replacing this part:

- complete replacement.

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

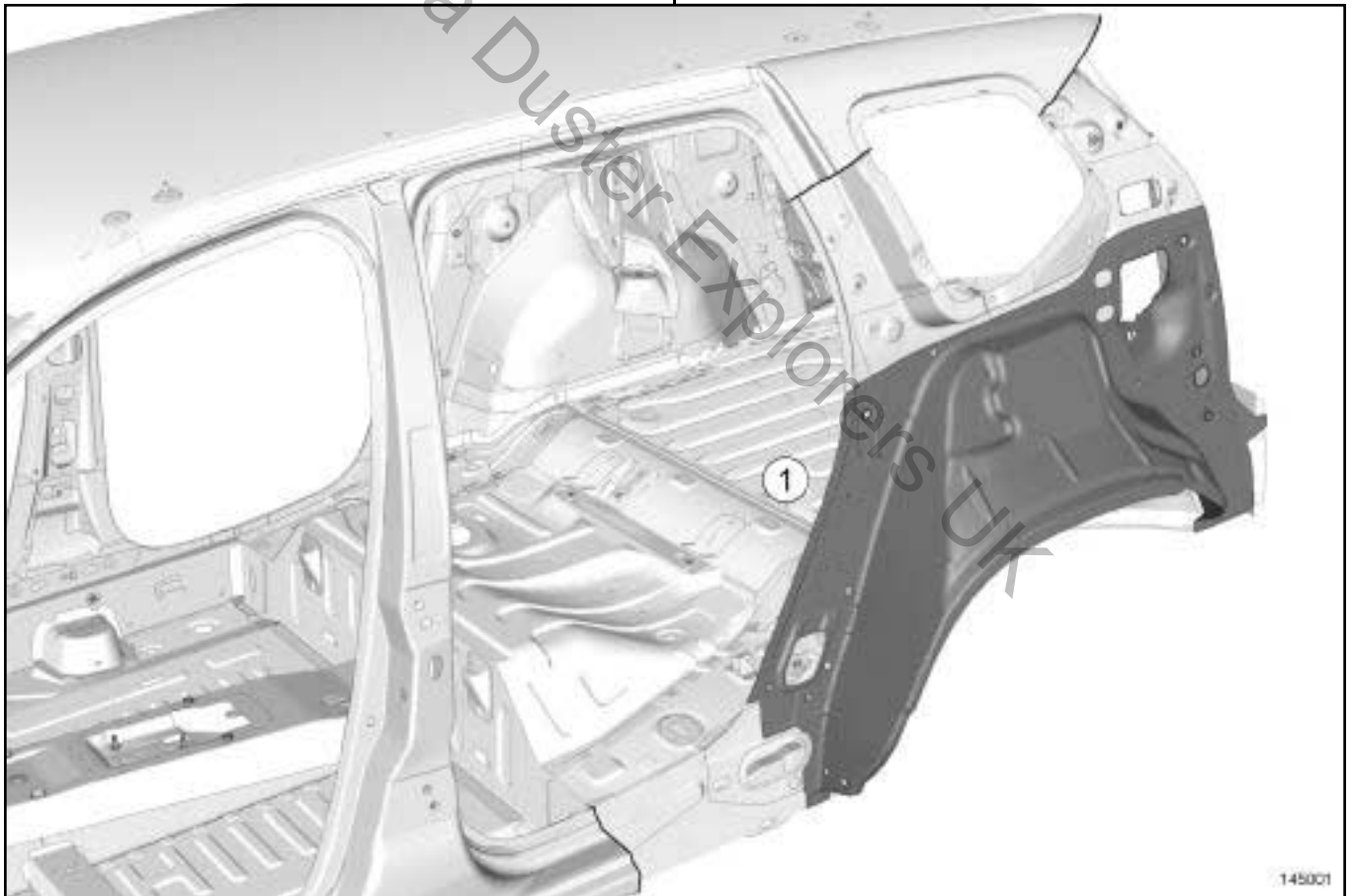
To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see **40A, General information, Earths on body: List and location of components**, page 40A-5) .

Complete replacement

Part in position



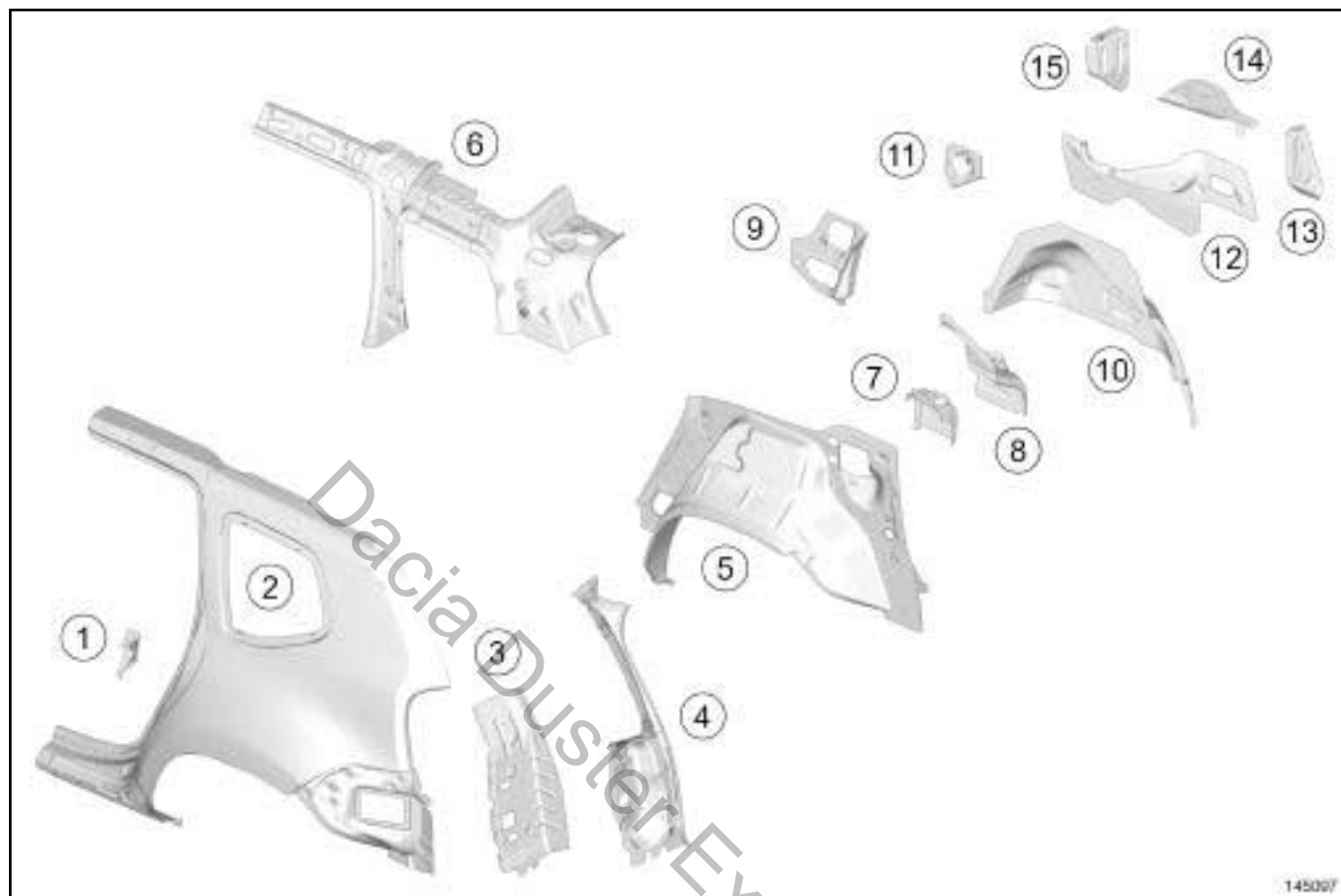
145001

REAR UPPER STRUCTURE

Rear half-unit: Replacement

44A

I - COMPOSITION OF THE SPARE PART



145097

145097

No.	Description	Thickness (mm)
(1)	Rear door striker plate reinforcement,	1.2
(2)	Rear wing panel	0.65
(3)	Rear light mounting lining	0.65
(4)	Rear light mounting	0.85/2
(5)	Quarter panel lining	0.65
(6)	Quarter panel lining, upper section	0.65/1.4
(7)	Rear shock absorber cup reinforcement	2.5
(8)	Rear shock absorber mounting reinforcement	2

No.	Description	Thickness (mm)
(9)	Lower connection component of rear inner wheel arch	0.95
(10)	Rear inner wheel arch	0.8
(11)	Support reinforcement for locking second row seat	1.2
(12)	Rear reinforcement of quarter panel lower section	1.2
(13)	Rear reinforcement of rear inner wheel arch	1.7
(14)	Side rear parcel shelf structure	1.2
(15)	Front reinforcement of rear inner wheel arch	1.7

REAR UPPER STRUCTURE

Rear half-unit: Replacement

44A

II - IN THE EVENT OF REPLACEMENT

There is only one way of replacing this part:

- complete replacement.

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

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

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

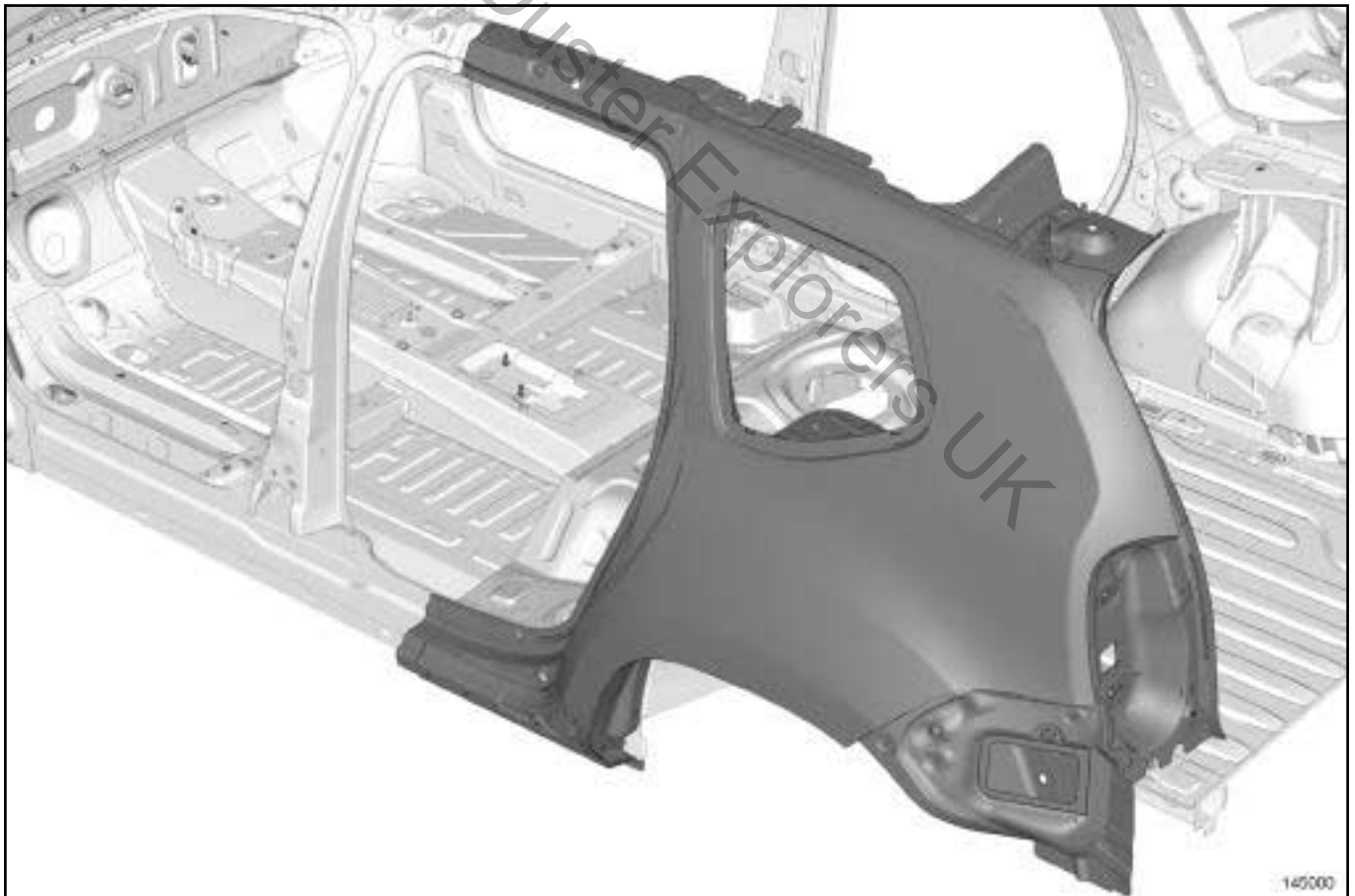
Locate the earths located near to the weld area (see 40A, General information, Earths on body: List and location of components, page 40A-5) .

Complete replacement

IMPORTANT

Use a repair bench to ensure the positioning of the points and the geometry of the axle assemblies.

a - Part in position



145000

b - Irremovable bodywork components - structures to be removed in order to carry out the replacement operation

Remove the roof (see 45A, Top of body, Roof: Re-

placement, page 45A-1) .

REAR UPPER STRUCTURE

Rear end panel: Replacement

44A

I - COMPOSITION OF THE SPARE PART

No.	Description	Thickness (mm)
(1)	Rear end panel	0.95

II - IN THE EVENT OF REPLACEMENT

There is only one way of replacing this part:

- complete replacement.

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

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

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see **40A, General information, Earths on body: List and location of components**, page 40A-5) .

Complete replacement

Part in position



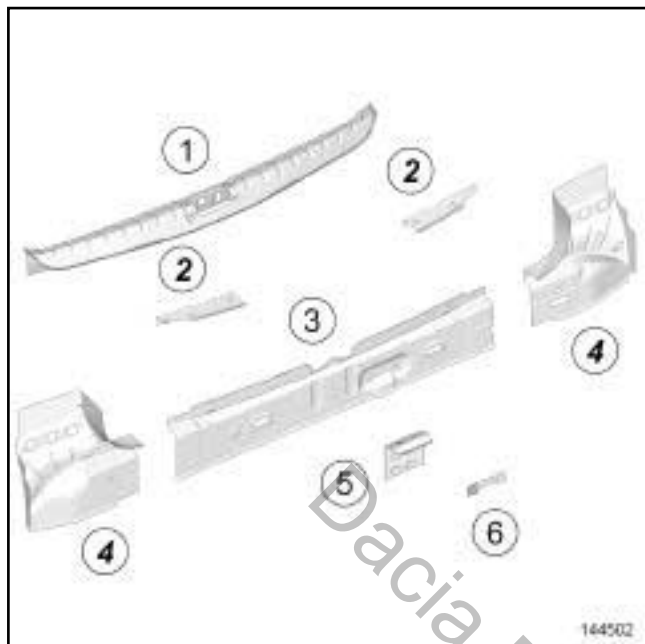
145006

REAR UPPER STRUCTURE

Rear end panel lining: Replacement

44A

I - COMPOSITION OF THE SPARE PART



145002

No.	Description	Thickness (mm)
(1)	Rear end panel lining, upper section	0.8
(2)	Rear end panel lining reinforcement, side section	0.8
(3)	Rear end panel lining, lower section	0.8
(4)	Rear end panel lining, side section	0.8
(5)	Tailgate door striker plate reinforcement	1.5
(6)	Emergency spare wheel carrier mounting reinforcement	1.2

II - IN THE EVENT OF REPLACEMENT

There is only one way of replacing this part:

- complete replacement.

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

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

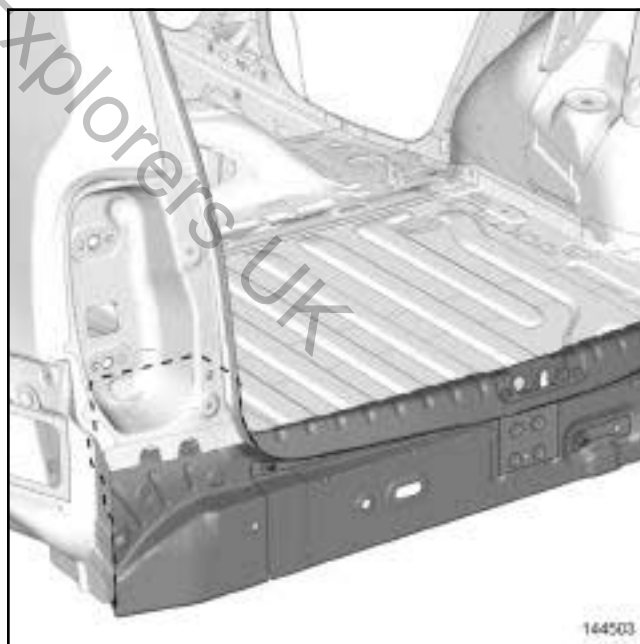
Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see **40A, General information, Earths on body: List and location of components, page 40A-5**).

Complete replacement

Part in position

External view



144503

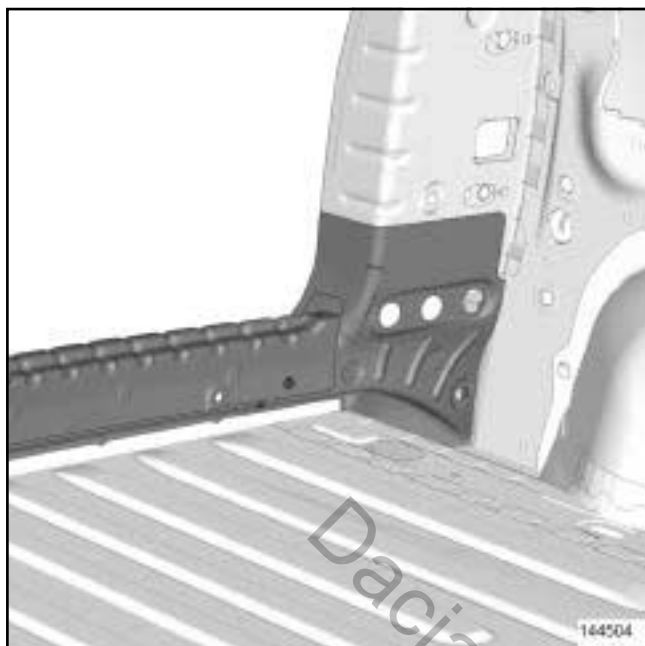
145003

REAR UPPER STRUCTURE

Rear end panel lining: Replacement

44A

Internal view



145004

Dacia Duster Explorers UK

TOP OF BODY

Roof: Replacement

45A

I - COMPOSITION OF THE SPARE PART

No.	Description	Thickness (mm)
(1)	Roof	0.7

II - IN THE EVENT OF REPLACEMENT

There is only one way of replacing this part:

- complete replacement

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

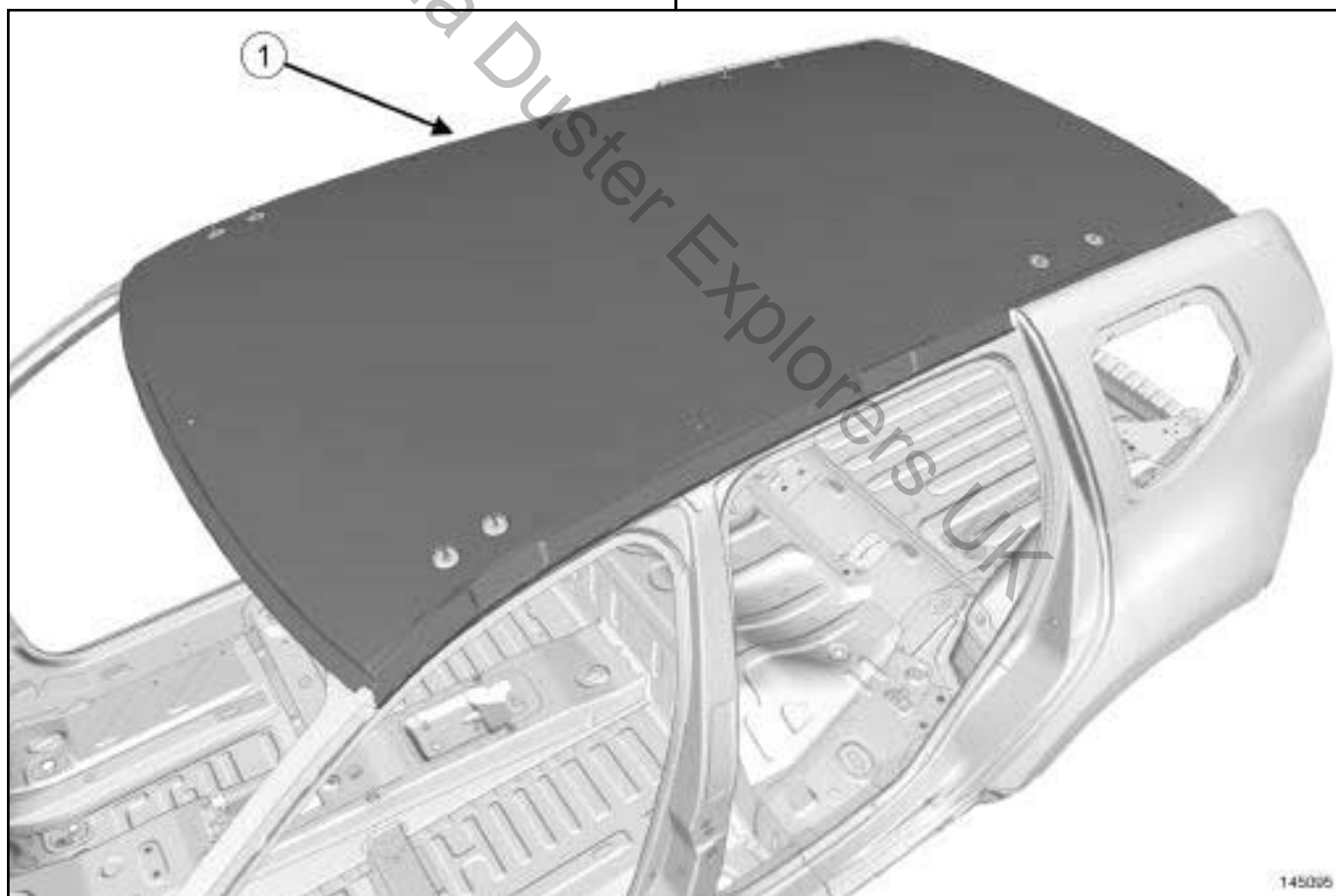
To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see **40A, General information, Earths on body: List and location of components**, page 40A-5) .

Complete replacement

a - Part in position



145095

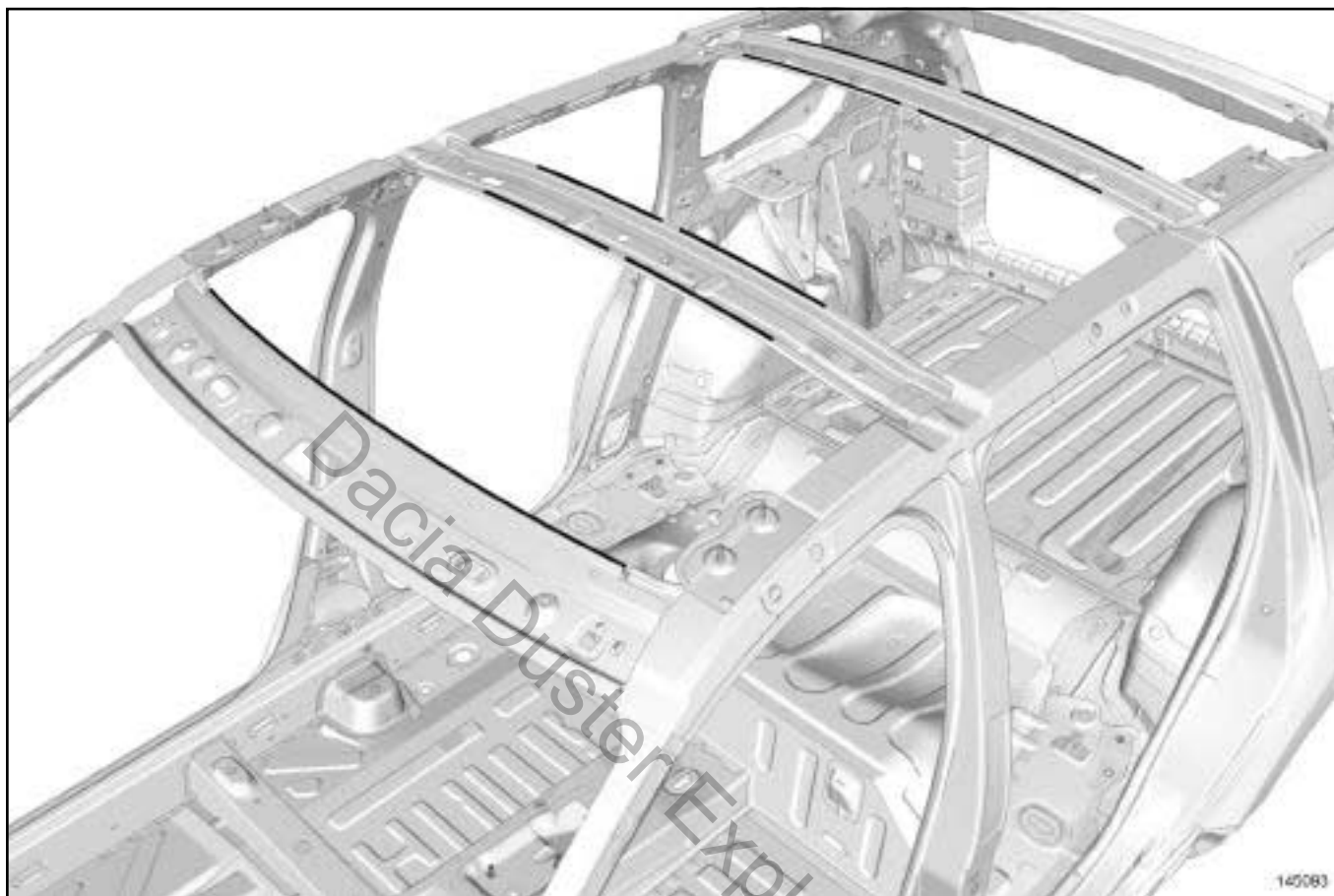
TOP OF BODY

Roof: Replacement

45A

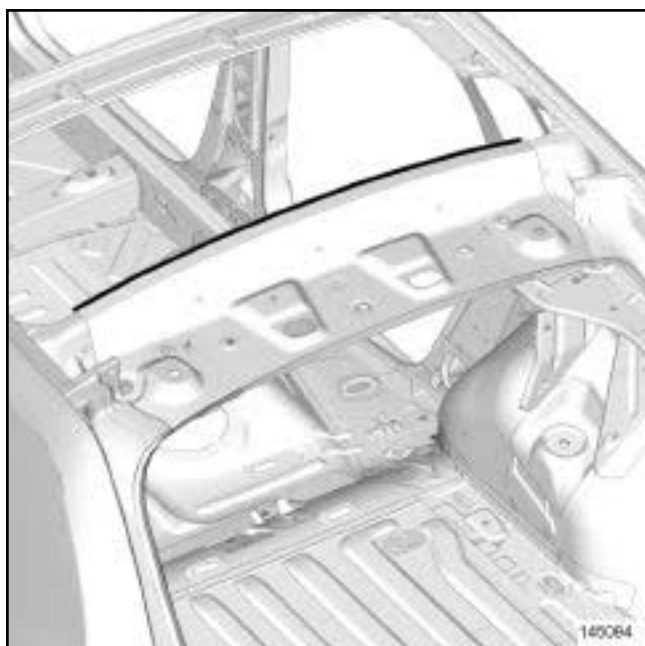
b - Bonding area

Front zone



145093

Rear zone



145094

TOP OF BODY

Roof front cross member: Replacement

45A

I - COMPOSITION OF THE SPARE PART

No.	Description	Thickness (mm)
(1)	Roof front cross member	0.95

II - IN THE EVENT OF REPLACEMENT

There is only one way of replacing this part:

- complete replacement

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

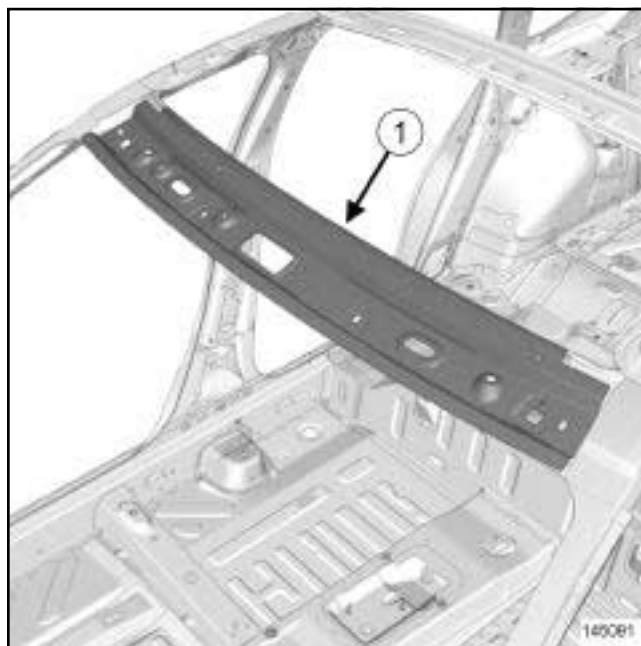
To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see **40A, General information, Earths on body: List and location of components**, page 40A-5) .

Complete replacement

Part in position



145091

TOP OF BODY

Roof centre cross member: Replacement

45A

I - COMPOSITION OF THE SPARE PART

No.	Description	Thickness (mm)
(1)	Roof centre cross member	1.2

II - IN THE EVENT OF REPLACEMENT

There is only one way of replacing this part:

- complete replacement

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

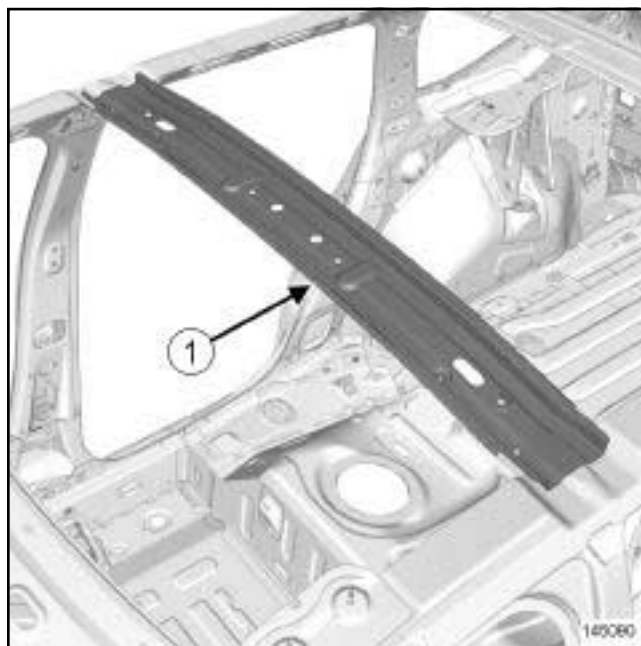
To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see **40A, General information, Earths on body: List and location of components**, page 40A-5) .

Complete replacement

Part in position



145090

TOP OF BODY

Roof panel arch: Replacement

45A

I - COMPOSITION OF THE SPARE PART

No.	Description	Thickness (mm)
(1)	Roof panel arch	0.8

II - IN THE EVENT OF REPLACEMENT

There is only one way of replacing this part:

- complete replacement

WARNING

If the mating faces of the parts to be welded are not accessible, use a GMAW plug weld in place of the original electrical resistance weld (see) (MR 400, 40C, Gas metal arc welded connections (GMAW)).

WARNING

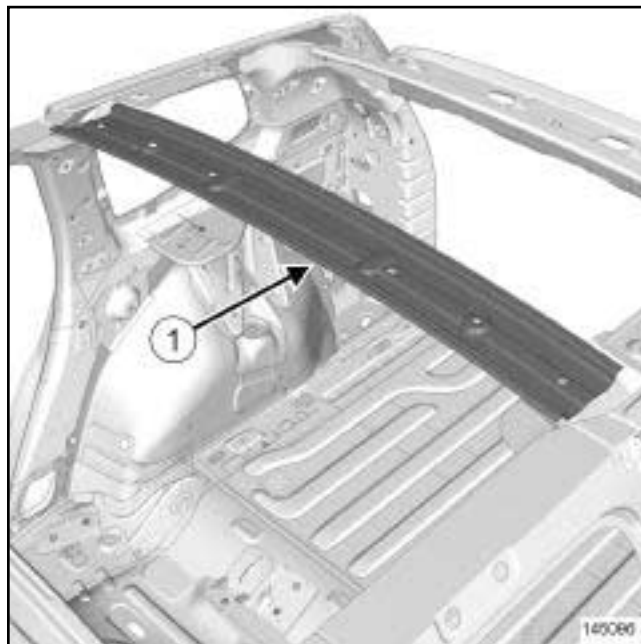
To avoid damaging the vehicles electric and electronic components, the earths of any wiring harness near the weld area must be disconnected.

Position the earth of the welding machine as close as possible to the weld area (see) (MR 400, 40H, Bolted connections).

Locate the earths located near to the weld area (see **40A, General information, Earths on body: List and location of components**, page 40A-5) .

Complete replacement

Part in position



145096

Tightening torques

hinge nuts on the front side door	28 N.m
hinge bolts and nuts on the A-pillar	28 N.m

There are two options for removing the front side door:

- without the hinges,
- with the hinges.

Note:

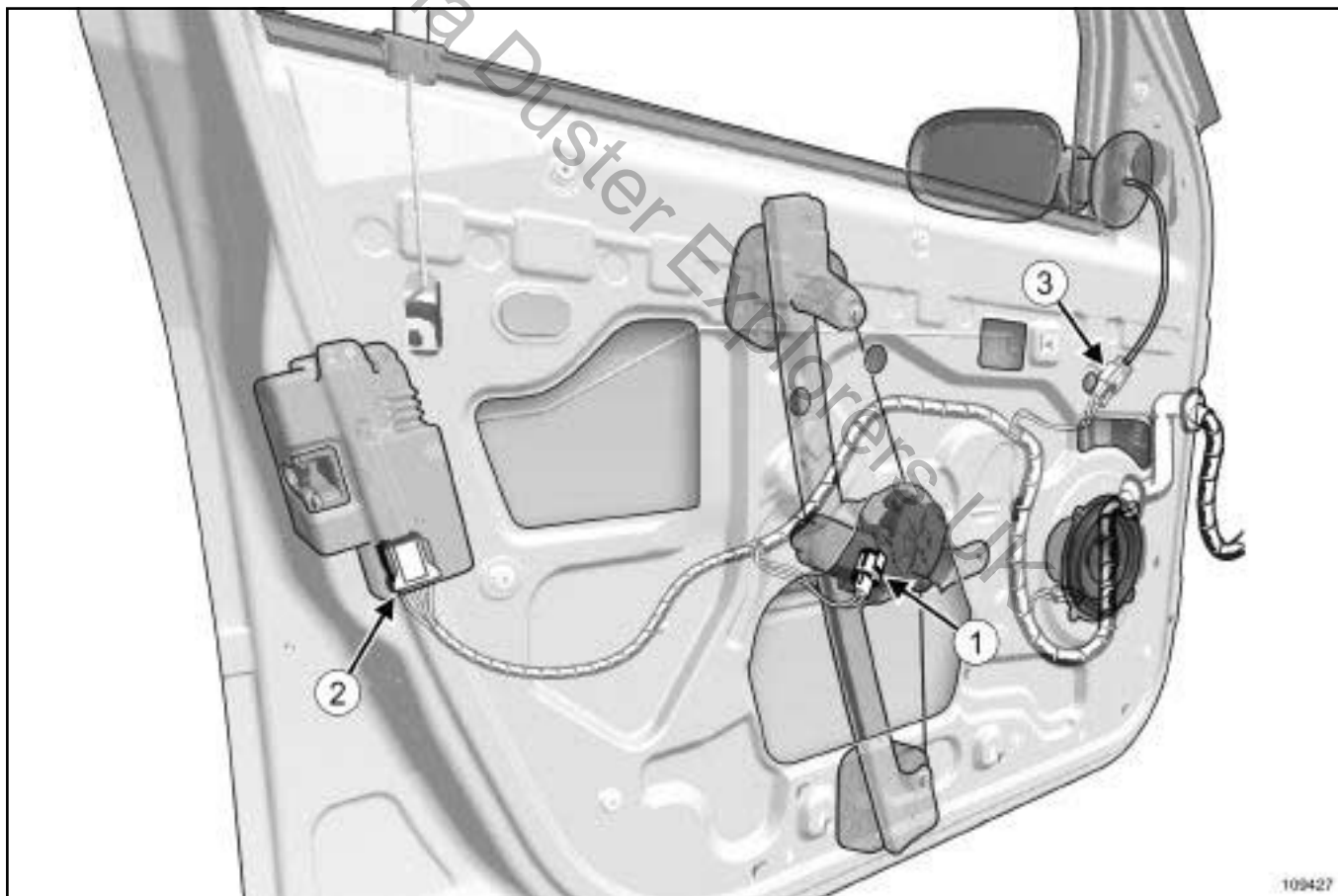
The front side door can be removed without removing the front wing.

REMOVAL

I - REMOVAL PREPARATION OPERATION

Remove:

- the front speaker (see **Front speakers: Removal - Refitting**) (86A, Radio),
- the front side door handle (see **Front side door interior opening control: Removal - Refitting**) (51A, Non-side opening element mechanisms),
- the front side door trim (see **Front side door trim: Removal - Refitting**) (72A, Side opening element trim).



109427

109427

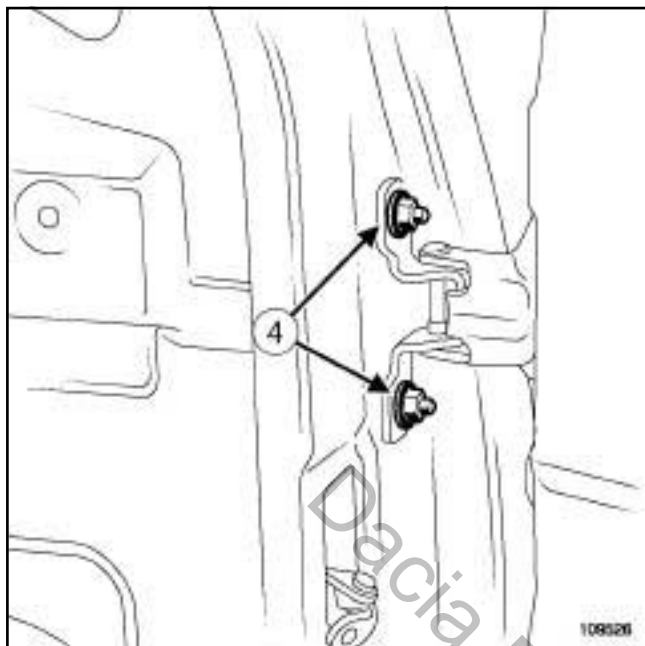
Disconnect:

- the connector of the front side door electric window motor (1) ,
- the connector of the front side door lock actuator (2) ,
- the door mirror switch connector (3) .

Remove the wiring from the front side door (depending on the equipment level).

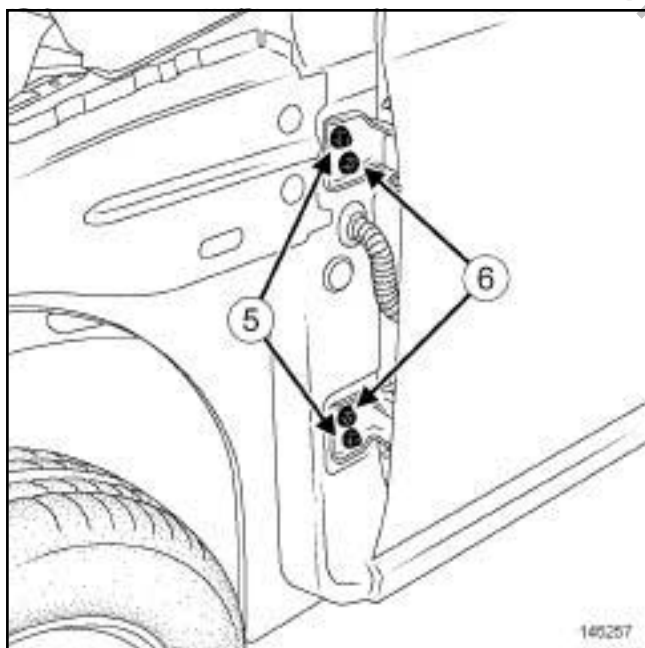
- Remove the front side door check strap (see **Front side door check strap: Removal - Refitting**) (51A, Side opening element mechanisms).

II - REMOVAL WITHOUT THE HINGES



- Remove nuts (4) .

III - REMOVAL WITH THE HINGES



- Remove:
 - the nuts (5) ,
 - the bolts (6) .

REFITTING

REFITTING OPERATION

- Proceed in the reverse order to removal.

WARNING

For any adjustment or removal/refitting procedure where it is necessary to separate a bolted connection, reapply the mating and sealing anti-corrosion protection to the bolts using filling mastic in a pre-formed bead.

- Adjust the gaps and flush fittings of the front side door (see **47A, Side opening elements, Front side door: Adjustment**, page **47A-4**) (48A, Non-side opening elements).
- Torque tighten:
 - the **hinge nuts on the front side door (28 N.m)**,
 - the **hinge bolts and nuts on the A-pillar (28 N.m)**.

Front side door: Stripping - rebuilding

The order of the operations described below is specific to the front side door replacement.

Note:

It is possible to carry out the stripping operations on the vehicle before removing the front side door.

STRIPPING Remove:

- the front side door interior weatherstrip (see) (66A, Window sealing),
- the front side door exterior weatherstrip (see **Front side door exterior weatherstrip: Removal - Refitting**) (66A, Window sealing),
- the front side door sliding window (see **Front side door sliding window: Removal - Refitting**) (54A, Windows),
- the front side door glass run channel (see **Front side door window run channel: Removal - Refitting**) (66A, Window sealing),
- the front side door electric window mechanism (see **Front side door electric window mechanism: Removal - Refitting**) (51A, Side opening element mechanisms),
- the front side door electric window motor (see) (51A, Side opening element mechanisms),
- the front side exterior door handle (see **Exterior door handle: Removal - Refitting**) (51A, Side opening element mechanisms),
- the front side door lock (see **Front side door lock: Removal - Refitting**) (51A, Side opening element mechanisms),
- the front side door check strap (see **Front side door check strap: Removal - Refitting**) (51A, Side opening element mechanisms),
- the front side door lock barrel (see **Front side door lock barrel: Removal - Refitting**) (51A, Side opening element mechanisms),
- the door mirror (see **Door mirror: Removal - Refitting**) (56A, Exterior equipment).


REBUILDING

-
- Proceed in the reverse order to removal

SIDE OPENING ELEMENTS

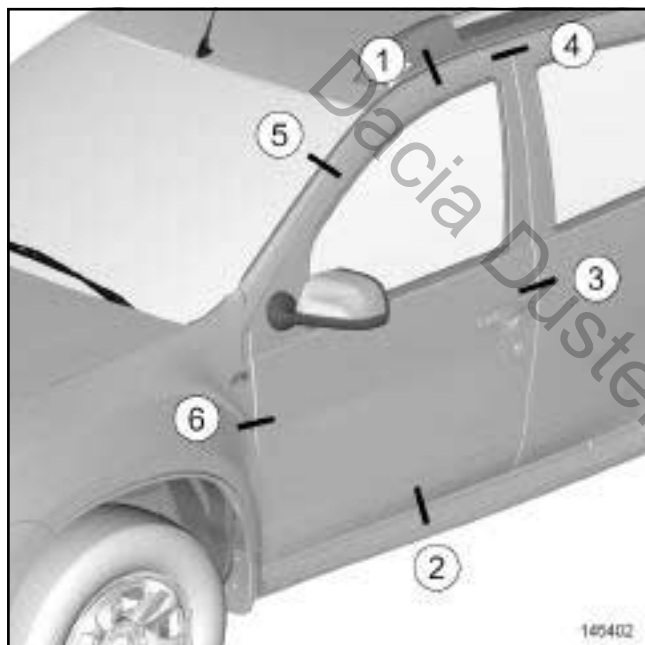
Front side door: Adjustment

47A

Tightening torques 	
front side door nuts	28 N.m
nuts and the bolts on the A-pillar	28 N.m

ADJUSTMENT VALUES

- ❑ For information on the front side door adjustment values (see **Vehicle panel gaps: Adjustment value**) (01C, Vehicle bodywork specifications).



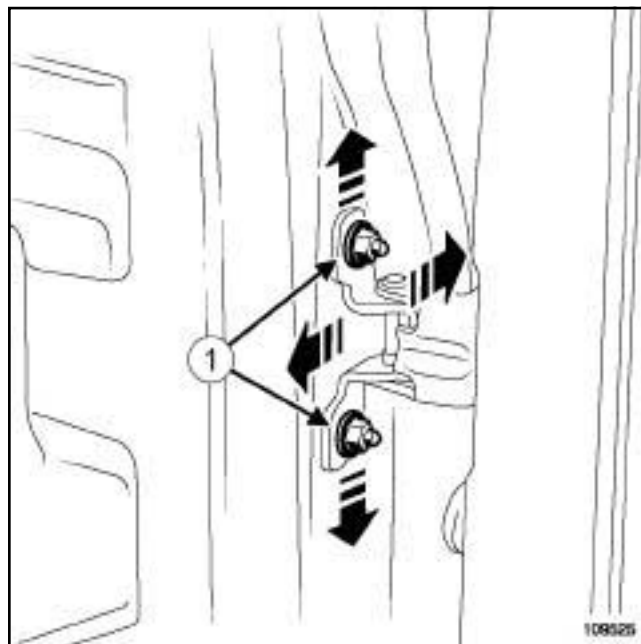
145402

- ❑ Observe the adjustment sequence (1) , (2) , (3) , (4) , (5) ,and (6) .

ADJUSTMENT

- ❑ There are three options for adjusting the front side door:
 - using the front side door nuts,
 - using the A-pillar nuts and bolts,
 - using the front side door striker plate.

I - ADJUSTMENT USING THE FRONT SIDE DOOR NUTS



109525

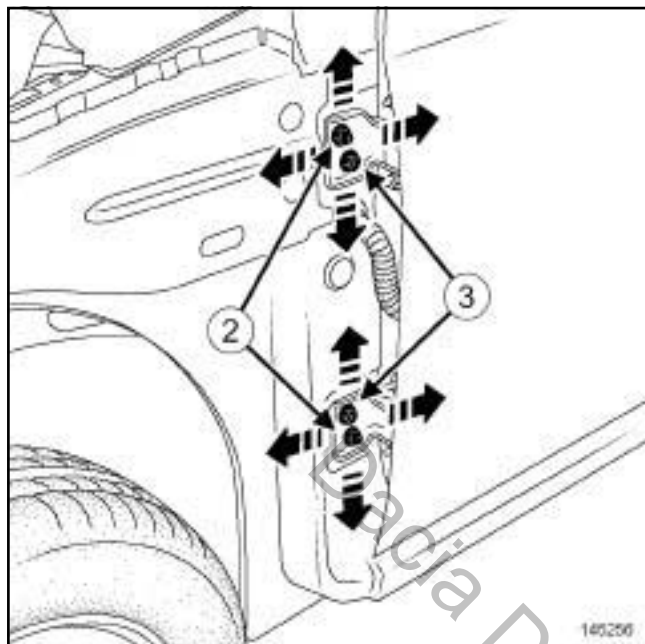
- ❑ Loosen the bolts (1) on the front side door.
- ❑ Adjust the panel gaps of the front side door.
- ❑ Torque tighten the **front side door nuts (28 N.m)**.

SIDE OPENING ELEMENTS

Front side door: Adjustment

47A

II - ADJUSTMENT USING THE A-PILLAR NUTS AND BOLTS

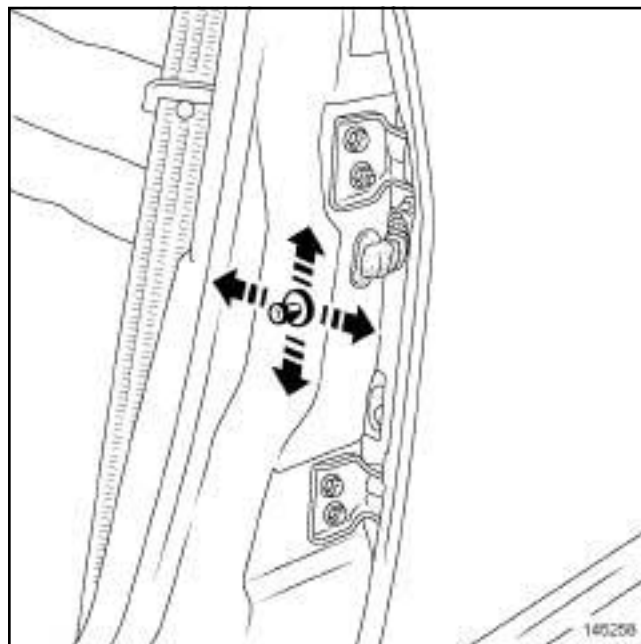


- Loosen the nuts (2) and the bolts (3) on the A-pillar.
- Adjust the panel gaps of the front side door.
- Torque tighten the **nuts and the bolts on the A-pillar (28 N.m)**.

Note:

The front wing does not have to be removed to adjust the front door.

III - ADJUSTMENT USING THE FRONT SIDE DOOR STRIKER PLATE




- Adjust the panel gaps of the front side door.

SIDE OPENING ELEMENTS

Rear side door: Removal - Refitting

47A

Tightening torques 	
hinge nuts on the rear side door	28 N.m
hinge nut and bolts on the B-pillar	28 N.m

There are two options for removing the rear side door:

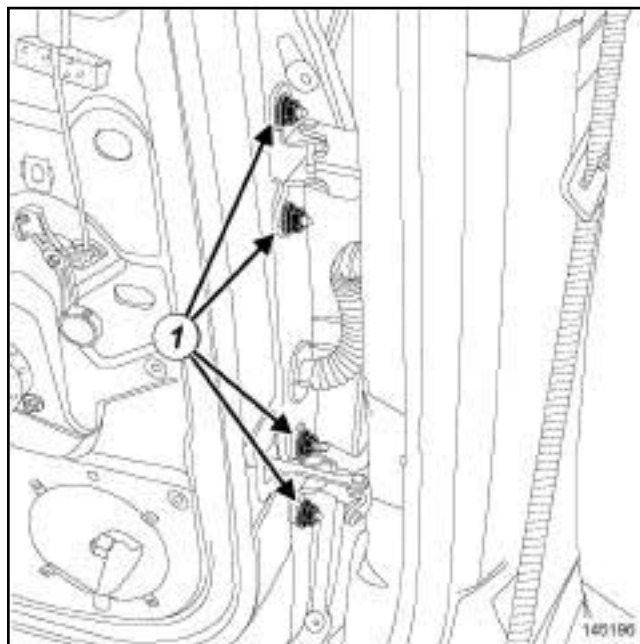
- without the hinges,
- with the hinges.

REMOVAL

I - REMOVAL PREPARATION OPERATION

- Remove:
 - the rear speaker (see **Rear speakers: Removal - Refitting**) (86A, Radio),
 - the rear side door interior handle (see **Rear side door interior opening control: Removal - Refitting**) (51A, Non-side opening element mechanisms),
 - the rear side door trim (see **Rear side door trim: Removal - Refitting**) (72A, Side opening element trim).
- Disconnect:
 - the connector of the rear side door electric window motor (depending on the equipment level),
 - the connector of the rear side door lock actuator.
- Remove the wiring from the rear side door (depending on the equipment level).
- Remove the rear side door check strap (see **Rear side door check strap: Removal - Refitting**) (51A, Side opening element mechanisms).

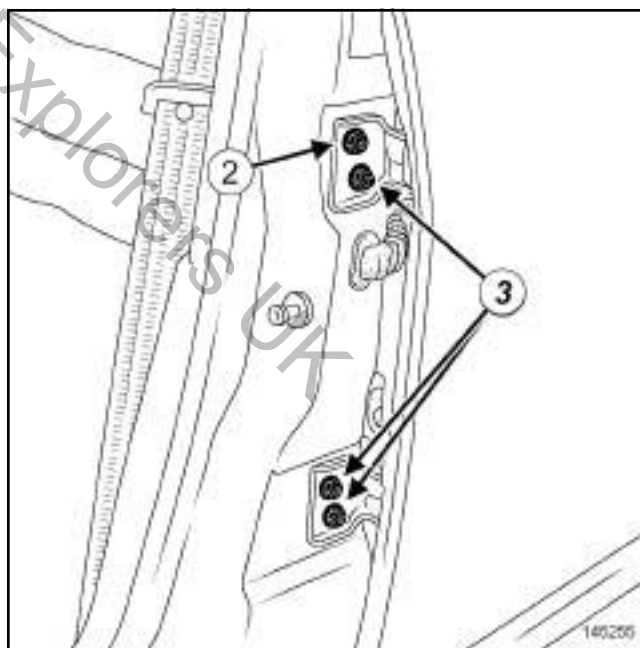
II - REMOVAL WITHOUT THE HINGES



145196

- Remove nuts (1) .

III - REMOVAL WITH THE HINGES



145255

- Remove:
 - the nut (2) ,
 - the bolts (3) .

REFITTING

REFITTING OPERATION

WARNING

For any adjustment or removal/refitting procedure where it is necessary to separate a bolted connection, reapply the mating and sealing anti-corrosion protection to the bolts using filling mastic in a pre-formed bead.

- Proceed in the reverse order to removal.
- Adjust the rear side door clearances and flush fittings (see **47A, Side opening elements, Rear side door: Adjustment**, page **47A-9**).
- Torque tighten:
 - the **hinge nuts on the rear side door (28 N.m)**,
 - the **hinge nut and bolts on the B-pillar (28 N.m)**.

Rear side door: Stripping - rebuilding

The order of the operations described below applies specifically to replacing the rear side door.

Note:


It is possible to carry out the stripping operations on the vehicle before removing the rear side door.

STRIPPING Remove:

- the rear side door interior weatherstrip (see) (66A, Window sealing),
- the rear side door exterior weatherstrip (see **Rear side door exterior weatherstrip: Removal - Refitting**) (66A, Window sealing),
- the rear side door sliding window (see **Rear side door sliding window: Removal - Refitting**) (54A, Windows),
- the rear side door glass run channel (see **Rear side door window run channel: Removal - Refitting**) (66A, Window sealing),
- the rear side door window winder mechanism (see **Rear side door manual window winder mechanism: Removal - Refitting**) (51A, Side opening element mechanisms),
- the rear side door exterior handle (see **Exterior door handle: Removal - Refitting**) (51A, Side opening element mechanisms),
- the rear side door lock (see **Rear side door lock: Removal - Refitting**) (51A, Side opening element mechanisms),
- the rear side door check strap (see **Rear side door check strap: Removal - Refitting**) (51A, Side opening element mechanisms),
- the rear side door lock barrel (see) (51A, Side opening element mechanisms).

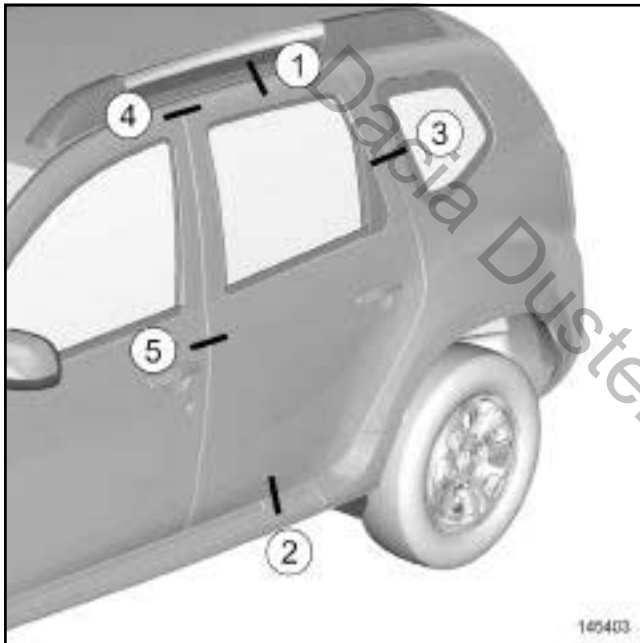
REBUILDING

-
- Proceed in the reverse order to removal.

Tightening torques 	
rear side door nuts	28 N.m
nut and the bolts on the B-pillar	28 N.m

ADJUSTMENT VALUES

- For information on the front side door adjustment values (see **Vehicle panel gaps: Adjustment value**) (01C, Vehicle bodywork specifications).



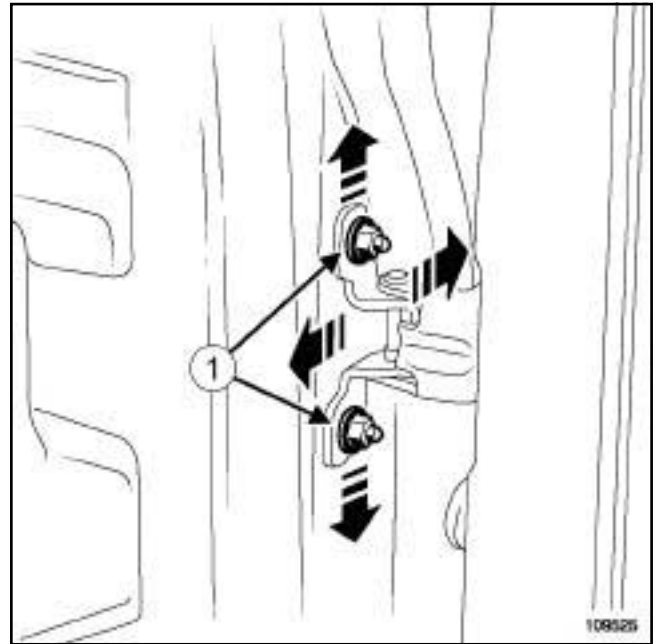
145403

- Observe the adjustment sequence (1) , (2) , (3) , (4) ,and (5) .

ADJUSTMENT

- There are three options for adjusting the rear side door:
 - using the rear side door nuts,
 - using the B-pillar nuts and bolts,
 - using the rear side door striker plate.

I - ADJUSTMENT USING THE REAR SIDE DOOR NUTS



109525

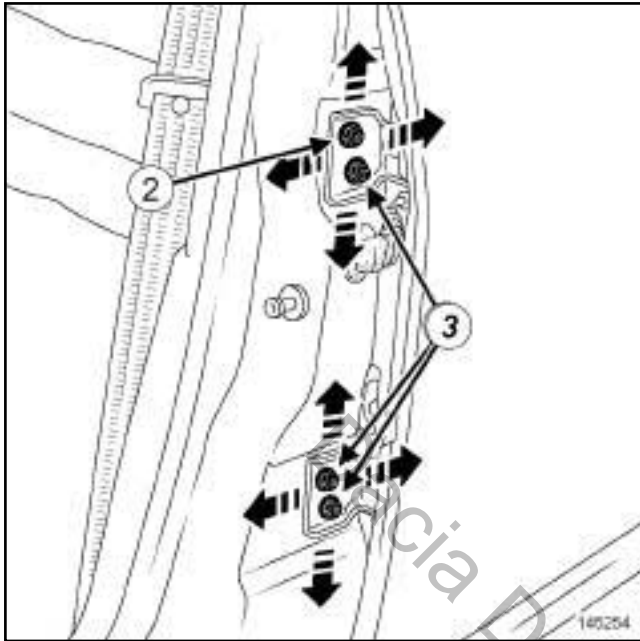
- Loosen the bolts (1) on the rear side door.
- Adjust the panel gaps and flush fittings of the rear side door.
- Torque tighten the **rear side door nuts (28 N.m)**.

SIDE OPENING ELEMENTS

Rear side door: Adjustment

47A

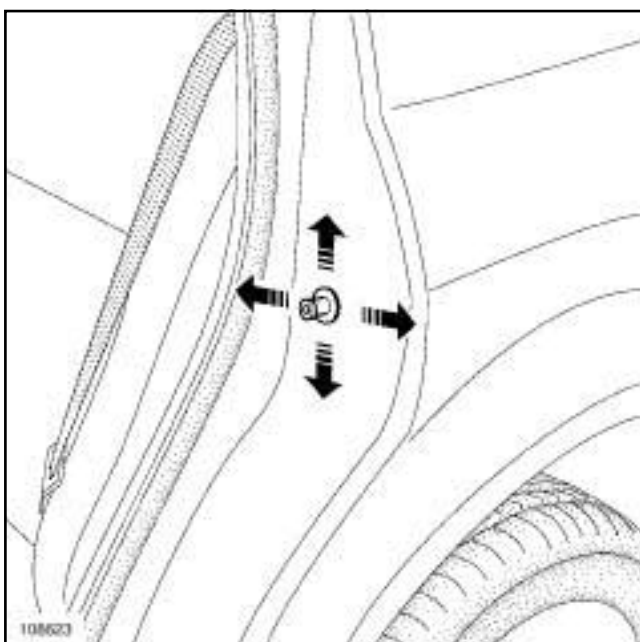
II - ADJUSTMENT USING THE B-PILLAR NUTS AND BOLTS



145254

- Loosen the nut (2) and the bolts (3) on the B-pillar.
- Adjust the panel gaps of the rear side door.
- Torque tighten the **nut and the bolts on the B-pillar (28 N.m)**.

III - ADJUSTMENT USING THE REAR SIDE DOOR STRIKER PLATE



108623

- Adjust the panel gaps of the rear side door.

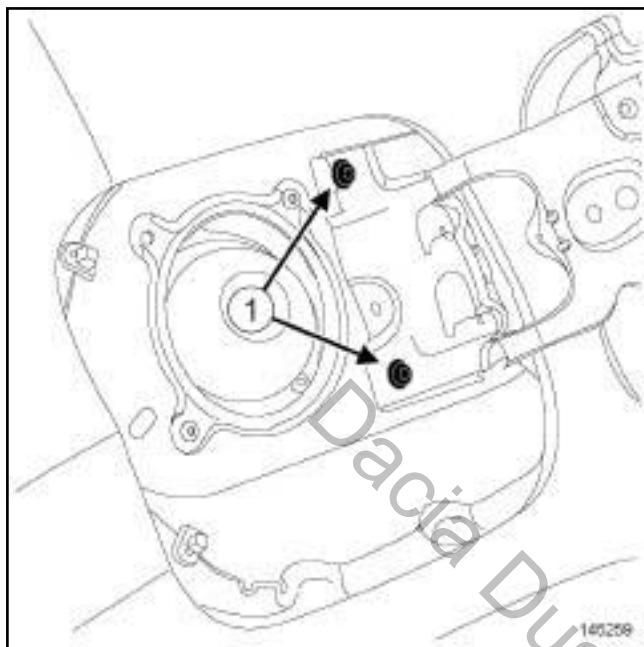
SIDE OPENING ELEMENTS

Fuel filler flap cover: Removal - Refitting

47A

REMOVAL

REMOVAL OPERATION



Remove:

- the bolts (1) ,
- the fuel tank flap cover.

REFITTING

I - REFITTING PREPARATION OPERATION

- Lubricate the joint shafts of the fuel tank flap cover with **MULTIPURPOSE GREASE** (see **Vehicle: Parts and consumables for the repair**) (04B, Consumables - Products).

II - REFITTING OPERATION

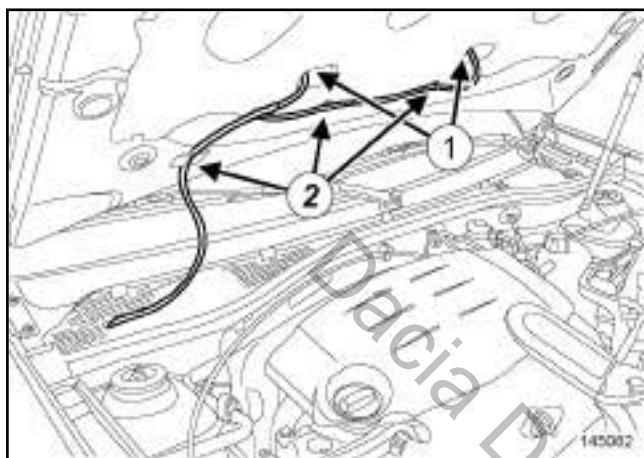
- Proceed in the reverse order to removal.

Location and specifications (tightening torques, parts always to be replaced etc.) (see **Exterior body front trim assembly: Exploded view**) .

- Adjust the opening clearances and flush fitting (see **48A, Non-side opening elements, Bonnet: Adjustment, page 48A-3**) .

REMOVAL

I - REMOVAL PREPARATION OPERATION



- Disconnect the windscreen washer jet pipes at (1) .
- Unclip the windscreen washer jet pipe at (2) .

II - REMOVAL OPERATION

1 - REMOVAL BY MEANS OF THE BONNET BOLTS

- Remove the bonnet strut (see **Bonnet strut: Removal - Refitting**) (52A, Non-side opening element mechanisms).
- Remove (see **Exterior body front trim assembly: Exploded view**) (55A, Exterior protection):
 - the bonnet bolts,
 - the bonnet.

2 - REMOVAL BY MEANS OF THE BONNET HINGE BOLTS

- Remove the bonnet strut (see **Bonnet strut: Removal - Refitting**) (52A, Non-side opening element mechanisms).
- Remove (see **Exterior body front trim assembly: Exploded view**) (55A, Exterior protection):
 - the bonnet hinge bolts,
 - the bonnet.

REFITTING

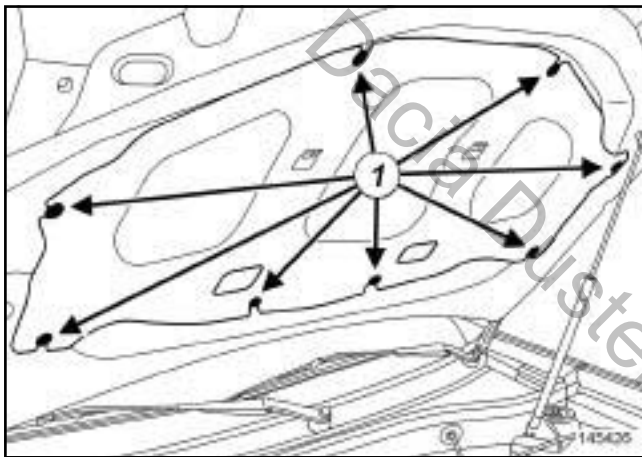
- Proceed in the reverse order to removal.

Special tooling required**Car. 1363**

Set of trim removal levers.

Note:

Described below is a special sequence of operations for bonnet replacement.

STRIPPING**STRIPPING OPERATION**

145426

 Remove:

- the clips (1) of the bonnet soundproofing using the **(Car. 1363)**,
- the bonnet soundproofing (depending on the equipment level),
- the windscreen washer jets from the bonnet (see **Front screen washer jet: Removal - Refitting**) (85A, Wiping - Washing).

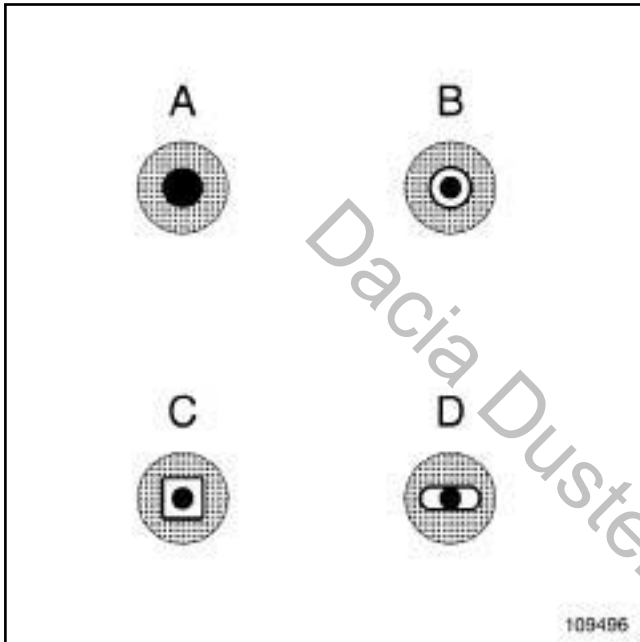
REBUILDING

-
- Proceed in the reverse order to removal.

Bonnet: Adjustment

ADJUSTMENT

- ❑ For information on the adjustment values for the bonnet (see **Vehicle panel gaps: Adjustment value**) (01C, Vehicle bodywork specifications).
- ❑ There are two options for adjusting the bonnet:
 - by means of the bonnet bolts,
 - by means of the bonnet hinge bolts.



- ❑ Symbols A, B, C and D show the adjustment options.

The black dot in the centre represents the body of the bolt.

The grey section represents the component to be adjusted.

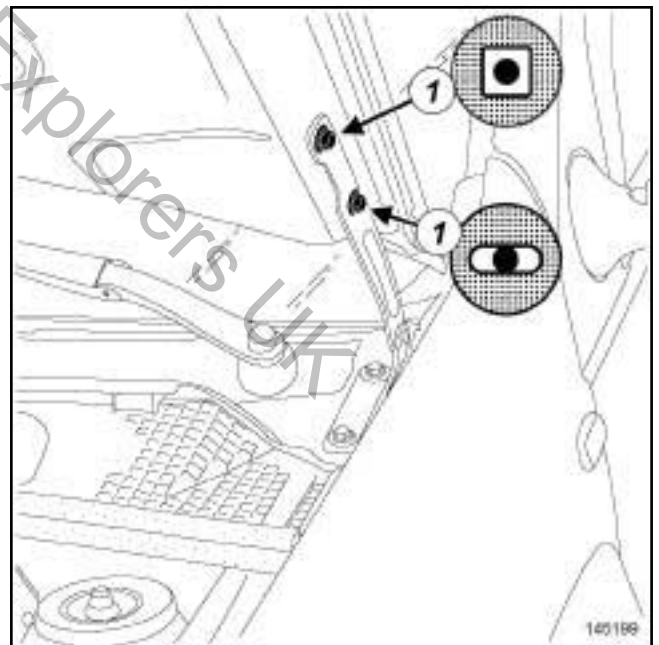
The white section represents the adjustment area.



145404

- ❑ Observe the adjustment sequence (1), (2) and (3).

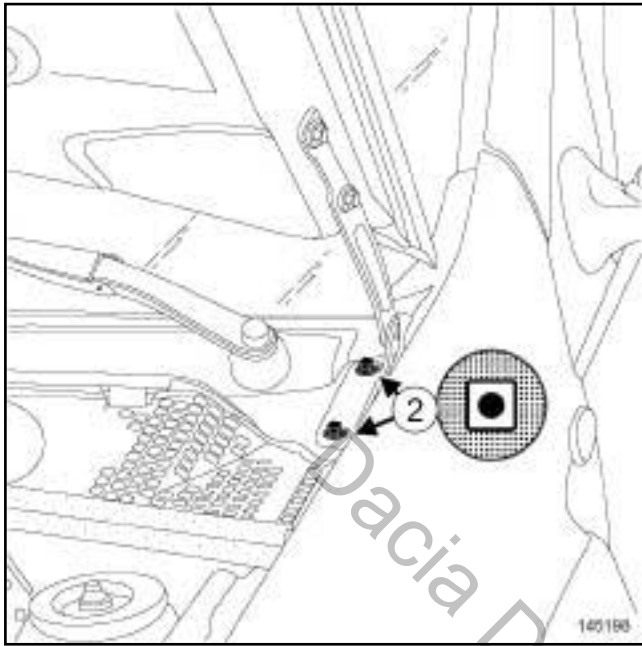
I - ADJUSTMENT BY MEANS OF THE BONNET BOLTS




145199

- ❑ Loosen the bonnet bolts (1).
- ❑ Adjust the gaps and flush fittings of the bonnet.
- ❑ Tighten the bonnet bolts.

II - ADJUSTMENT BY MEANS OF THE BONNET HINGE BOLTS



- Loosen the bonnet hinge bolts (2) .
- Adjust the bonnet panel gaps.
- Tighten the bonnet hinge bolts.

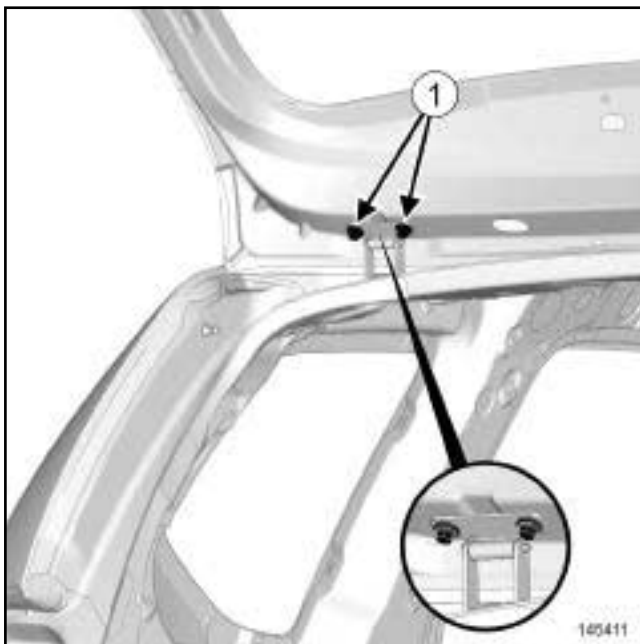
Tightening torques 	
tailgate bolts	21 N.m
tailgate hinge nuts	21 N.m

I - REMOVAL WITHOUT THE HINGES

1 - REMOVAL PREPARATION OPERATION

- Remove the tailgate trim (see) (73A, Non-side opening elements trim).
- Disconnect the following connectors :
 - the rear screen wiper motor,
 - the high level brake light,
 - the tailgate lock,
 - the heated rear screen,
 - the number plate lights.
- Remove:
 - the tailgate wiring,
 - the tailgate washer jet tube,
 - the tailgate gas struts (see **Tailgate strut: Removal - Refitting**) (52A, Non-side opening element mechanisms).

2 - REMOVAL OPERATION



145411

- Remove:
 - the tailgate bolts on each side of the vehicle (1) ,

- the tailgate (this operation requires two people).

II - REFITTING WITHOUT HINGES

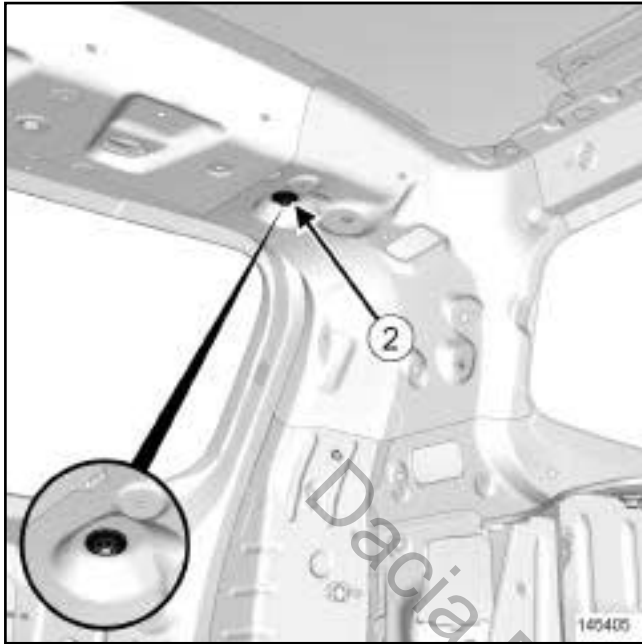
- Proceed in the reverse order to removal.
- Adjust the gaps and flush fittings of the tailgate (see **48A, Non-side opening elements, Tailgate: Adjustment**, page 48A-8) .
- Torque tighten the **tailgate bolts (21 N.m)**.

III - REMOVAL WITH HINGES

1 - REMOVAL PREPARATION OPERATION

- Remove:
 - the headlining partially (see) (71A, Body internal trim),
 - the tailgate trim (see) (73A, Non-side opening elements trim).
- Disconnect the following connectors :
 - the rear screen wiper motor,
 - the high level brake light,
 - the tailgate lock,
 - the heated rear screen,
 - the number plate lights.
- Remove:
 - the tailgate wiring,
 - the tailgate washer jet tube,
 - the tailgate gas struts (see **Tailgate strut: Removal - Refitting**) (52A, Non-side opening element mechanisms).

2 - REMOVAL OPERATION



145405

 Remove:

- the tailgate hinge nut (2) on each side of the vehicle,
- the tailgate (this operation requires two people).

IV - REFITTING WITH HINGES

- Proceed in the reverse order to removal.
- Adjust the tailgate panel gaps (see **48A, Non-side opening elements, Tailgate: Adjustment**, page **48A-8**).
- Torque tighten the **tailgate hinge nuts (21 N.m)**.

Location and specifications (tightening torques, parts always to be replaced, etc.) (see **Exterior rear opening element assembly: Exploded view**) .

Described below is a special sequence of operations for tailgate replacement.

Note:

It is possible to carry out the trim removal operations on the vehicle before removing the tailgate.

STRIPPING


STRIPPING OPERATION

- Remove (see **Exterior rear opening element assembly: Exploded view**) (52A, Non-side opening element mechanisms):
 - the manufacturer's badge,
 - the badge,
 - the tailgate strip,
 - the number plate lights,
 - the rear screen wiper arm,
 - the rear screen wiper blade,
 - the rear screen washer jet.
- Remove:
 - the rear screen wiper motor (see **Rear screen wiper motor: Removal - Refitting**) (85A, Washing - Wiping),
 - the tailgate lock (see **Tailgate lock: Removal - Refitting**) (52A, Non-side opening element mechanisms),
 - the tailgate lock barrel (see) (52A, Non-side opening element mechanisms),
 - the high level brake light (see **3rd brake light: Removal - Refitting**) (81A, Rear lighting),
 - the rear screen (see **Rear screen: Removal - Refitting**) (54A, Windows),
 - the closing end stops.

REBUILDING

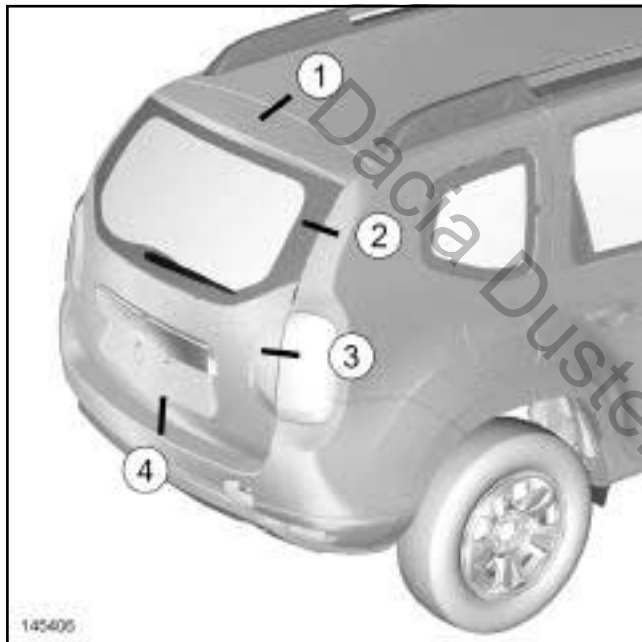
REBUILDING OPERATION

- Proceed in the reverse order to removal.

Tightening torques 	
tailgate bolts	21 N.m
hinge nuts	21 N.m

ADJUSTMENT VALUES

- For information on the adjustment values for the tailgate (see **Vehicle panel gaps: Adjustment value**) (01C, Vehicle bodywork specifications).

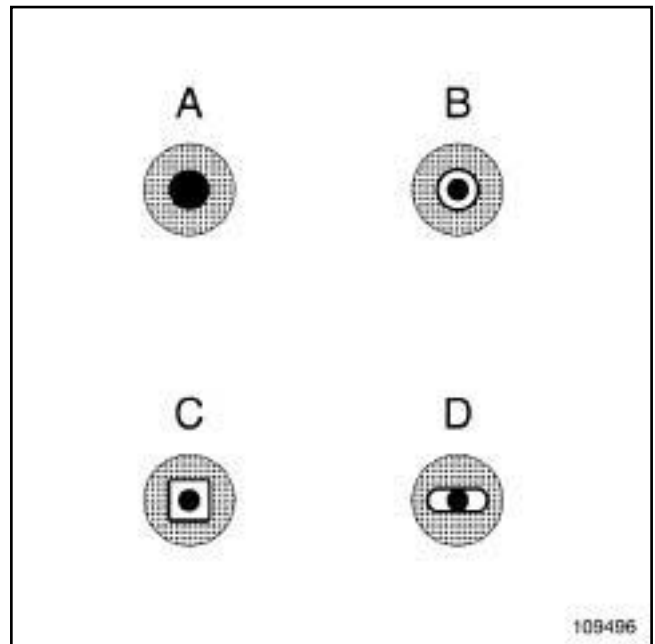


145406

- Observe the adjustment sequence (1), (2), (3) and (4).

ADJUSTMENT

- There are three options for adjusting the tailgate:
 - using the tailgate bolts,
 - using the tailgate hinge nuts,
 - using the rear end panel striker plate.



109496

109496

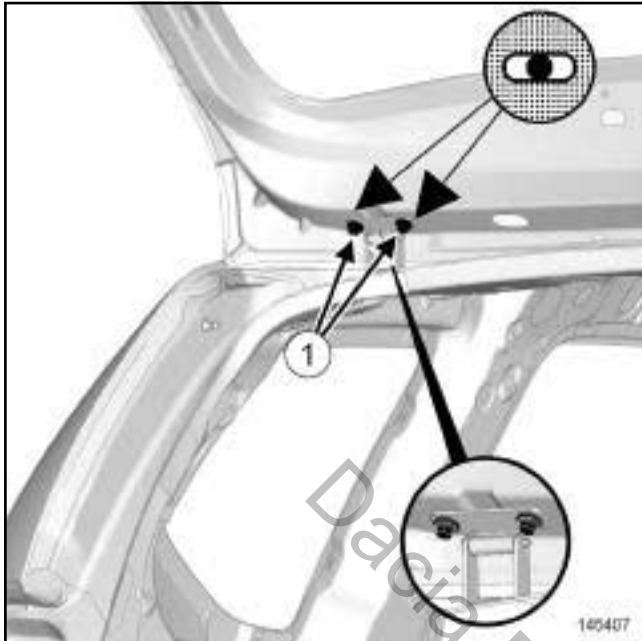
- Symbols A, B, C and D show the adjustment options.

The black dot in the centre represents the body of the bolt.

The grey section represents the component to be adjusted.

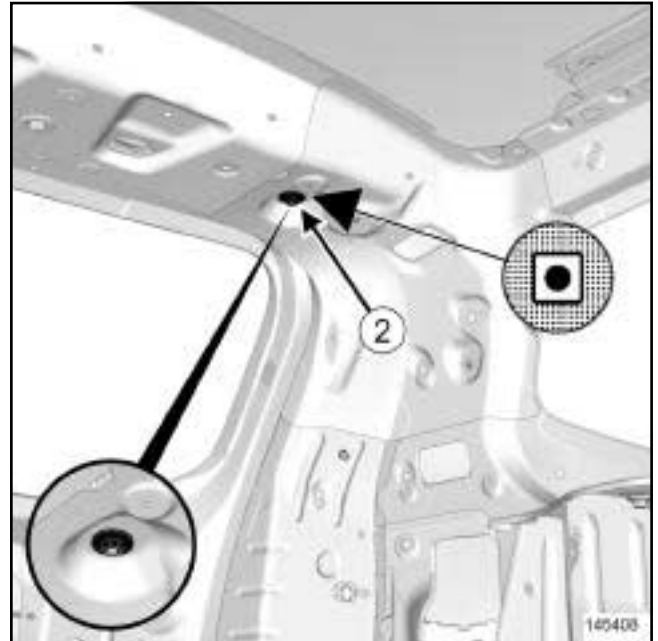
The white section represents the adjustment area.

I - ADJUSTMENT USING THE TAILGATE BOLTS



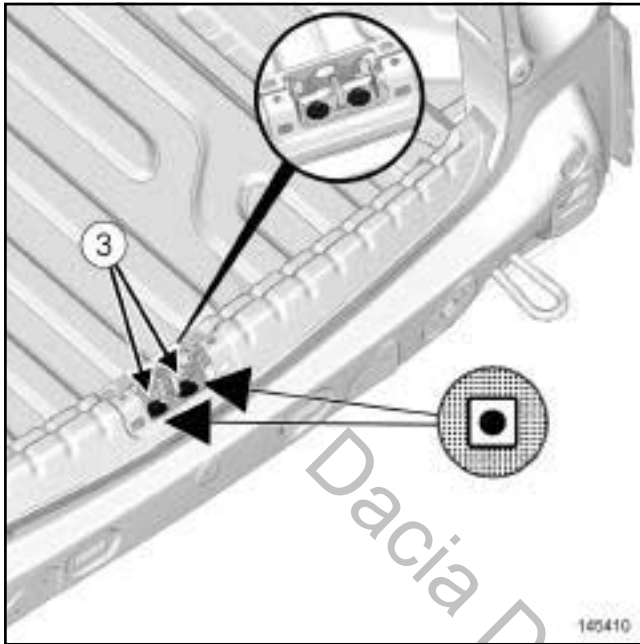
- Undo the tailgate bolts (1) on each side of the vehicle.
- Adjust the tailgate panel gaps.
- Torque tighten the **tailgate bolts (21 N.m)**.

II - ADJUSTMENT USING THE HINGE NUTS



- Partially remove the headlining (see) (71A, Body internal trim).
- Undo the hinge nut (2) on each side of the vehicle.
- Adjust the tailgate panel gaps.
- Torque tighten the **hinge nuts (21 N.m)**.
- Refit the headlining (see) (71A, Body internal trim).

III - ADJUSTMENT USING THE REAR END PANEL STRIKER PLATE



- Remove the striker plate trim from the rear end panel.
- Loosen the striker plate bolts (3) on the rear end panel.
- Adjust the tailgate panel gaps.
- Refit the striker plate trim on the rear end panel.