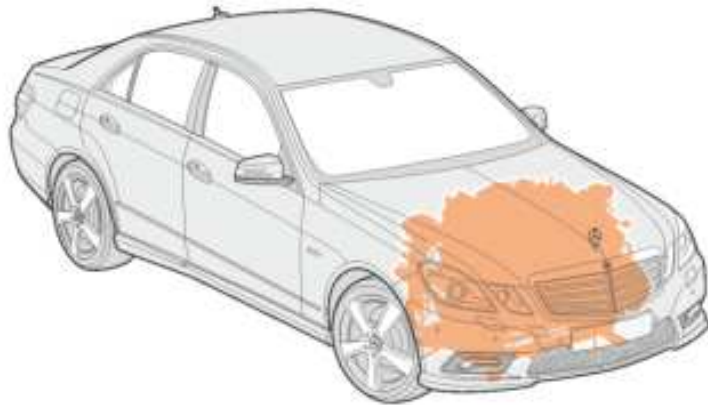


• Engine & Suspension R&R



Additional Information

- Refer to **Vehicle Safety Features** for SRS information
- Requires correct SRS storage in line with health and safety regulations
- A/C Evac/Charge:-
 - Refrigerant Capacities (grams) - **590**
 - Oil Grade - **Pag 46**
- Evac. & Bleed Clutch System - Bleed nipple is located behind rubber cover on lower bell housing left hand side
- Disconnect Battery - Negative terminal only

Torque Settings

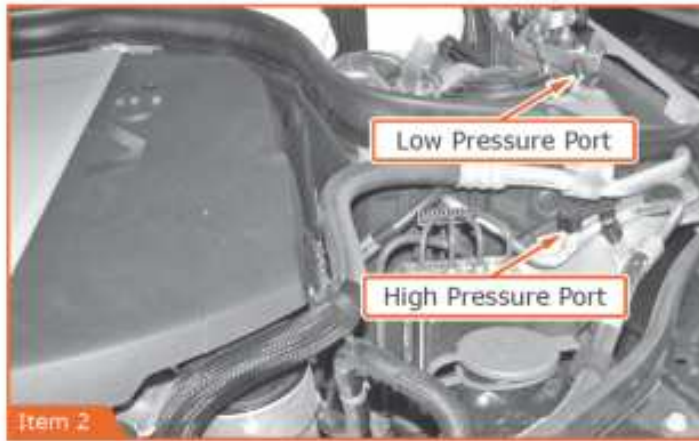
- Wheel Road Front LH/RH - **130Nm**

Strip Route	
Engine & Suspension R&R	
Mechanical, Electrical, Trim (MET)	
1. Load-Unload Vehicle to Ramp	
2. A/C Evac/Charge	①
3. Drain- Refill Cooling System	
4. Evac. & Bleed Clutch System	①
5. Evacuate - Bleed Brake System	
6. Drain & Refill PAS System	
7. Remove Wheel Road Front LH	Ⓣ
8. Remove Wheel Road Front RH	Ⓣ
9. Disconnect Battery	①

table continued on next page



Engine & Suspension Overview

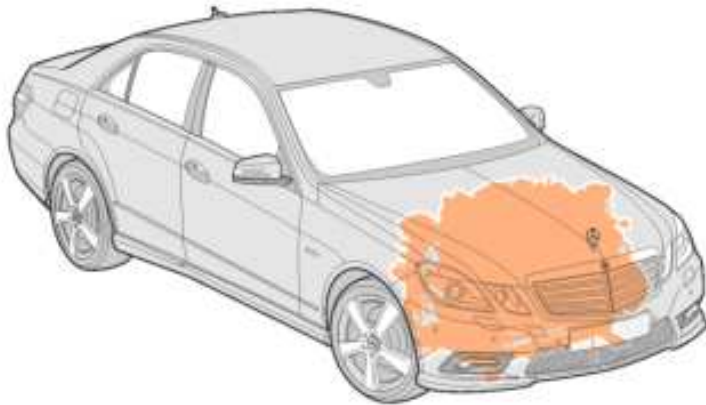


Item 2

Air Conditioning Port Location



Engine & Suspension R&R - Cont.



Additional Information

- Heater/Blower Intake Duct:-
 - Located on the lefthand front inner wing
 - Covers battery
- Washer Tubing Headlamp - Piping which runs heated coolant to the washer bottle to prevent freezing

Torque Settings

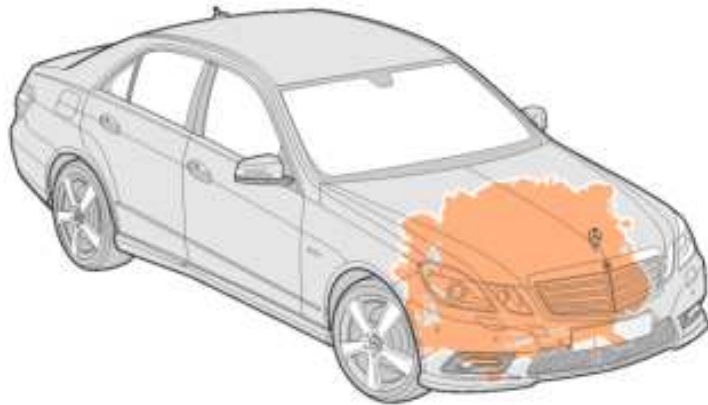
- Centre Brace Fixings - **10Nm**
- Bumper Front Reinforcement Fixings:-
 - Mount fixings - **28Nm +135°**
 - 6mm Bracket fixings - **No torques found**

Strip Route - Cont.	
Engine & Suspension R&R	
Mechanical, Electrical, Trim (MET)	
10. Remove Heater/Blower Intake Duct	①
11. Remove Air Filter Duct	
12. Remove Grille Front Fixings	Ⓢ
13. Remove Wing Front Liner LH	
14. Remove Wing Front Liner RH	
15. Remove Bumper Fixing Front	Ⓢ
16. Remove Headlamp LH	Ⓢ
17. Remove Headlamp RH	Ⓢ
18. Remove Engine Splash Shield Front	
19. Remove Washer Tubing Headlamp	①
20. Remove / Lay Aside Wiring Harness Front Bumper Rein.	
21. Remove Centre Brace Fixings	Ⓢ
22. Remove Bumper Front Reinforcement Fixings	Ⓢ

table continued on next page



Engine & Suspension R&R - Cont.



Additional Information

- Scuttle Panel Grille - Includes disconnection of washer pipe
- Propshaft Joint Rear/Front/Centre Mounting - Care should be taken when handling propshaft to ensure the two sections do not part as they are marked for alignment purposes
- Radiator - Refers to cooling pack which includes top & bottom hoses
- Steering Wheel:-
 - Apply thread lock to bolt
 - Fit new securing bolt

Torque Settings

- Wiper Front Arm & Blade LH/RH - **22Nm**
- Propshaft Joint Rear/Front - **58Nm**
- Propshaft Centre Mounting - **20Nm**
- Radiator:-
 - Air conditioning Condenser bolts - **9Nm**
- Airbag Drivers Side - **7Nm**
- Steering Wheel - **80Nm**
- Steering Column Lower Joint - **24Nm**



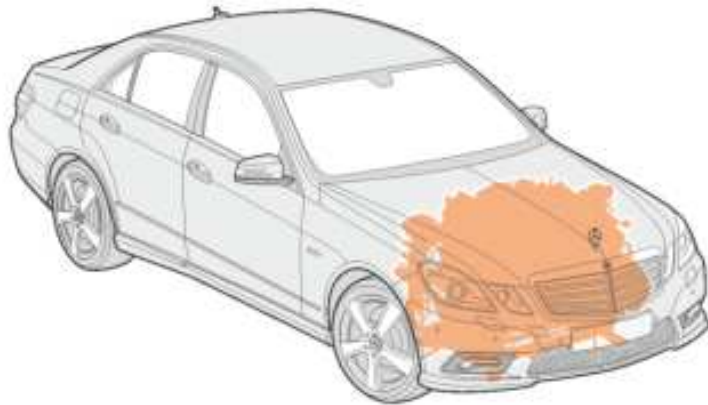
Airbag drivers side

Strip Route - Cont.	
Engine & Suspension R&R	
Mechanical, Electrical, Trim (MET)	
23. Remove Engine Splash Shield	
24. Remove Transmission Splash Shield	
25. Remove Floor Pan Splash Shield RH	
26. Remove Floor Pan Splash Shield LH	
27. Remove Wiper Front Arm & Blade LH	Ⓢ
28. Remove Wiper Front Arm & Blade RH	Ⓢ
29. Remove Scuttle Panel Grille	Ⓢ
30. Remove Air Filter Duct LH	
31. Remove Air Filter Duct RH	
32. Remove Extension Sill Painted LH Fixings	
33. Remove Extension Sill Painted RH Fixings	
34. Remove Propshaft Joint Rear	Ⓢ Ⓢ
35. Remove Propshaft Centre Mounting	Ⓢ Ⓢ
36. Remove Propshaft Joint Front	Ⓢ Ⓢ
37. Remove Exhaust Heat Shield Tunnel	
38. Remove Radiator	Ⓢ Ⓢ
39. Remove Airbag Drivers Side	Ⓢ
40. Remove Steering Wheel	Ⓢ Ⓢ
41. Disconnect Steering Column Lower Joint	Ⓢ

table continued on next page



Engine & Suspension R&R - Cont.



Additional Information

- Engine Bay Brace LH/RH - Refers to the engine stabiliser bar which locates from the rear of the subframe to the sill panel reinforcement
- Brake Flexible Hose Front LH - Includes ABS wiring

Torque Settings

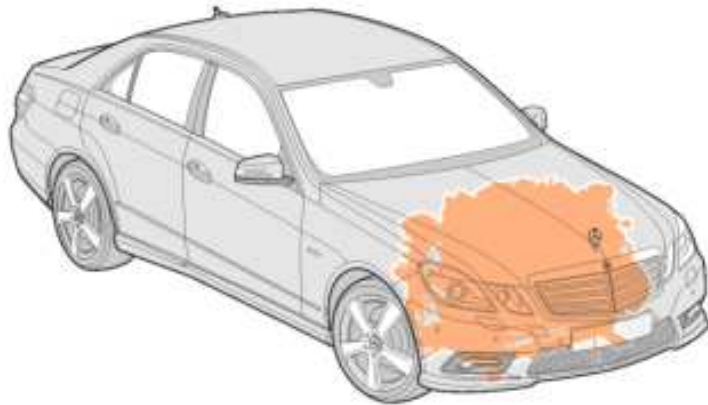
- Engine Bay Brace LH/RH - **60Nm**
- Brake Flexible Hose Front LH - **16Nm**

Strip Route - Cont.	
Engine & Suspension R&R	
Mechanical, Electrical, Trim (MET)	
42. Remove Engine Bay Brace LH	① ②
43. Remove Engine Bay Brace RH	① ②
44. Disconnect / Lay Aside Brake Flexible Hose Front LH	① ②
table continued on next page	



Engine Bay Brace location (LH shown)

Engine & Suspension R&R - Cont.



Additional Information

- Brake Flexible Hose Front RH - Includes ABS wiring
- Remove Engine ECU - Located on right hand inner wing
- Disconnect Wiring (R&R Engine) - Refers to the main starter cable at fuse box
- ECU Fault Code Check:-
 - Memory has to be deleted after airbag deployment
 - Airbag ECU replacement is required only if damaged fault codes indicate replacement or after 3 airbag deployments

Torque Settings

- Brake Flexible Hose Front RH - **16Nm**
- Engine Fixing Bolts:-
 - Gearbox support bolts - **50Nm**
 - Subframe to chassis leg bolts - **180Nm**
 - Strut top bolts - **33Nm**



Engine ECU

Item 48

Engine ECU Location

Strip Route - Cont.

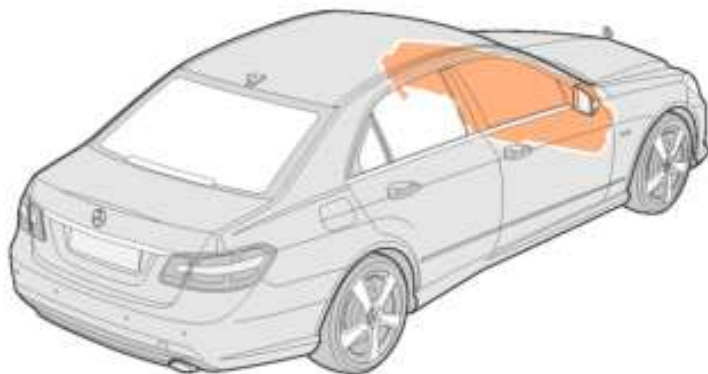
Engine & Suspension R&R

Mechanical, Electrical, Trim (MET)

45. Disconnect / Lay Aside Brake Flexible Hose Front RH	① ⑦
46. Remove Engine Compartment Cover	
47. Remove Heater Hose	
48. Remove Engine ECU	Ⓢ
49. Disconnect / Lay Aside Wiring (R&R Engine)	① ⑦
50. Disconnect / Lay Aside Hoses - Cables (Engine)	Ⓢ
51. Disconnect / Lay Aside Fuel Pipes R & R Eng	
52. Remove Engine Fixing Bolts	⑦
53. Focus Headlamps	
54. Geometry Check	
55. R&R Power Unit	
56. Focus Front Foglamps	
57. Start & Run up Engine	
58. ECU Fault Code	①



• Facia Panel R&R



Additional Information

- Refer to **Vehicle Safety Features** for SRS information
- Requires correct SRS storage in line with health and safety regulations
- Heater/Blower Intake Duct - Removed to allow disconnection of the battery
- Disconnect Battery - Negative terminal only
- Steering Wheel: -
 - Renew fixing and apply thread lock

Torque Settings

- Seat Belt Front Lower Fixing LH/RH - **35Nm**
- Seat Front LH/RH - **50Nm**
- Airbag Drivers Side - **7Nm**
- Steering Wheel - **80Nm**

Strip Route	
Facia Panel R&R	
Mechanical, Electrical, Trim (MET)	
1. Remove Heater/Blower Intake Duct	①
2. Disconnect Battery	① ⚡
3. Remove Seat Belt Front Lower Fixing LH	Ⓣ
4. Remove Seat Belt Front Lower Fixing RH	Ⓣ
5. Remove Seat Front LH	Ⓣ
6. Remove Seat Front RH	Ⓣ
7. Remove Ashtray/Cigar Lighter Assembly	
8. Remove Heater Control Assembly	
9. Remove Centre Console Fixings	⚡
10. Remove Sill Panel Inner Trim Front LH	
11. Remove Sill Panel Inner Trim Front RH	
12. Remove Door Front Aperture Weatherseal LH	
13. Remove Door Front Aperture Weatherseal RH	
14. Remove A Post Upper Trim LH	⚡
15. Remove A Post Upper Trim RH	⚡
16. Remove Airbag Drivers Side	Ⓣ
17. Remove Steering Wheel	Ⓣ ①
18. Remove Facia Panel Lower Dash Panel RH	
19. Remove Facia Panel Lower Dash Panel LH	

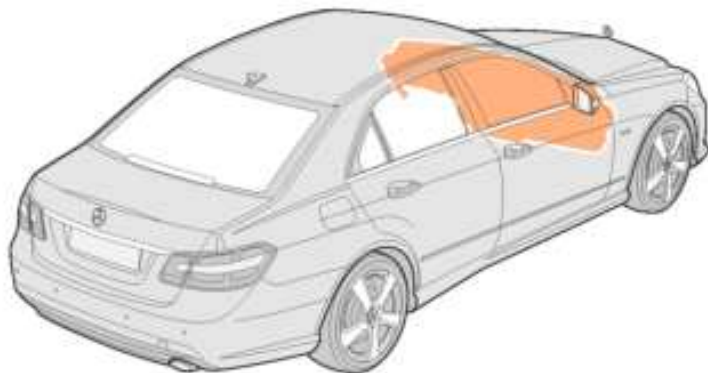
Table continued on next page



• Facia Panel R&R

① Additional Information

- Switches Steering Column - Includes rotary coupling



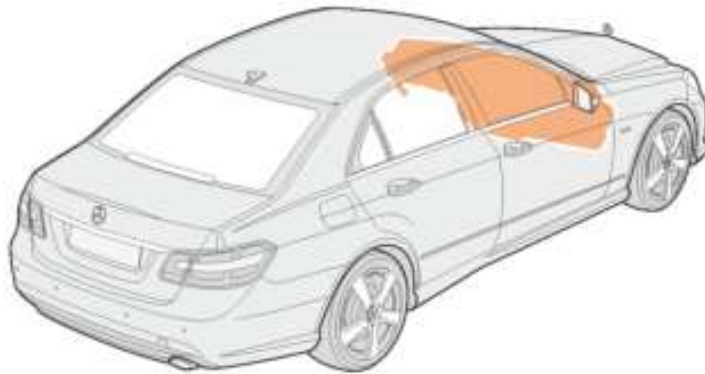
Strip Route - cont.
Facia Panel R&R
Mechanical, Electrical, Trim (MET)
20. Remove Switches Steering Column ①
21. Remove Facia Panel End Cover LH
22. Remove Facia Panel End Cover RH
<small>table continued on next page</small>



Item 20

Switches Steering Column

• Facia Panel R&R - Cont.



Additional Information

- Facia Panel Vent RH - Includes sensor
- A/C Solar Sensor - Located in grille on top centre facia
- Ignition Lock Cover:-
 - Use special tool to remove
 - Part number - **639589010700**
- ECU Fault Code Check:-
 - Memory has to be deleted after airbag deployment
 - Airbag ECU replacement is required only if damaged fault codes indicate replacement or after 3 airbag deployments

Torque Settings

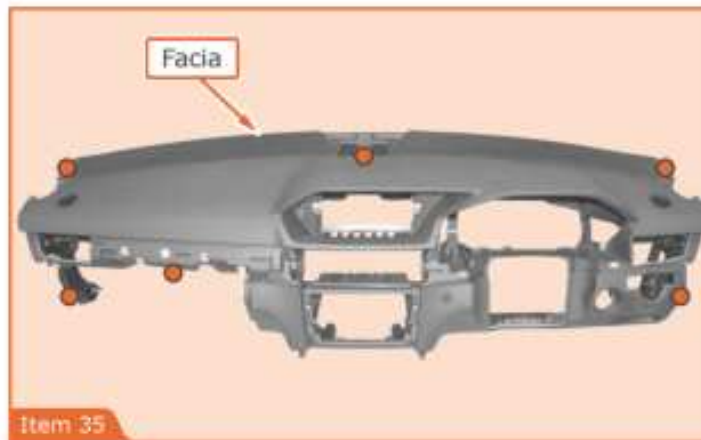
- Facia Panel Fixings:-
 - Support for knee airbag - **6Nm**

Strip Route - Cont.	
Facia Panel R&R	
Mechanical, Electrical, Trim (MET)	
23. Remove Facia Panel Vent RH	📌
24. Remove Facia Panel Vent Centre	
25. Remove Instrument Cluster Surround	
26. Remove Instrument Cluster	
27. Remove Steering Column Shroud Upper	
28. Disconnect Handbrake Release Handle	
29. Remove Multi Function Display Unit	
30. Remove CD Player	🔌
31. Remove A/C Solar Sensor	📌
32. Remove Glove Compartment Assembly	
33. Remove Ignition Lock Cover	📌
34. Disconnect Facia Wiring	
35. Remove Facia Panel Fixings	🔧
36. ECU Fault Code Check	📌



Item 33

Ignition lock cover tool being used



Item 35

Facia Panel Fixing Location



Screen Front



Additional Information

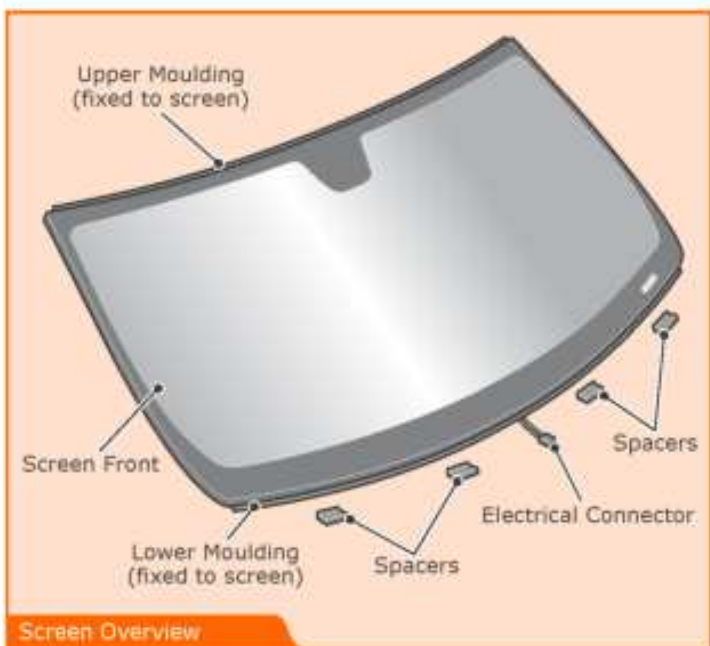
- Bead height & width - 12mm x 8mm
- Bead length - 3870mm
- Screen weight - 13.8Kg
- Screen Front - Upper/Lower moulding is supplied on screen
- Scuttle Panel Grille - Includes removal of washer pipe and wiring from scuttle panel grille
- Moulding Roof LH/RH - Re-use with care

Torque Settings

- Wiper Front Arm & Blade LH/RH - **22Nm**

Strip Route	
Screen Front	①
Mechanical, Electrical, Trim (MET)	
1. Remove Heater/Blower Intake Duct	
2. Remove Wiper Front Arm & Blade LH	⚠
3. Remove Wiper Front Arm & Blade RH	⚠
4. Remove Scuttle Panel Grille	①
5. Remove Moulding Roof LH	①
6. Remove Moulding Roof RH	①
7. Remove A Post Upper Trim RH	⚠
8. Remove A Post Upper Trim LH	⚠

table continued on next page



Screen Overview

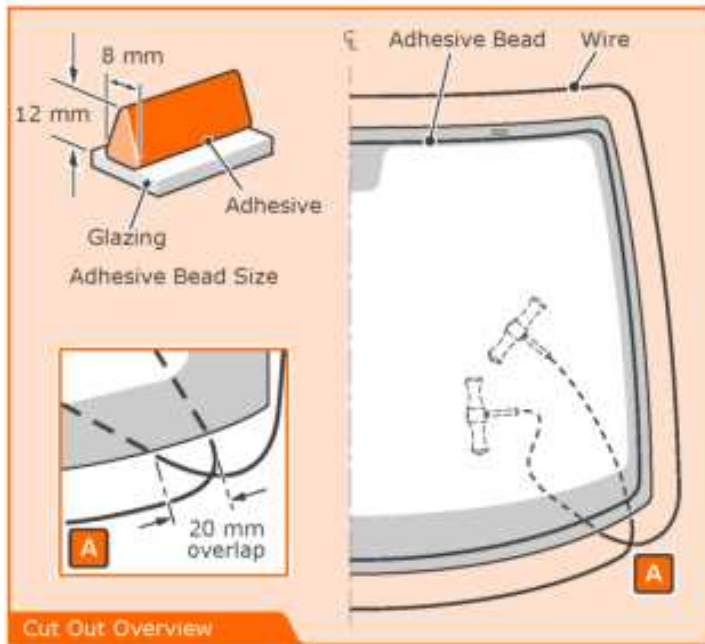


Item 4

Scuttle panel with washer pipe location



Screen Front - cont.



Strip Route
Screen Front
Mechanical, Electrical, Trim (MET)
9. Remove Mirror Rear View
10. Remove Sun Visor Supports
11. Remove Screen Front
12. Screen Front Water Test

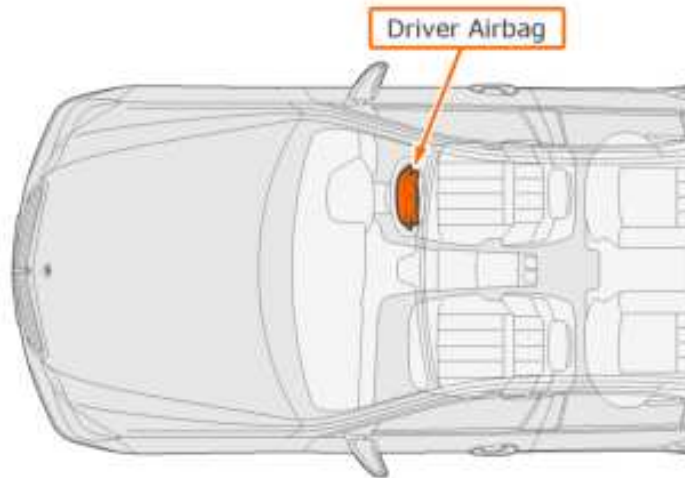
Preparation:

- Protect paintwork around screen aperture.
- Remove trim, see Strip Route.

Cutting Wire Method:

- Push a probe through PU adhesive.
- Hook cutting wire through probe and pull into the passenger compartment, tie ends off to a 'T' handle.
- Feed approximately **5 metres** of cutting wire around the circumference of the screen, making sure the wire is securely situated under the encapsulated moulding, back to original insertion point with a 20mm overlap.
- With assistance cut through PU adhesive, some sawing action may be required at corners.
- Remove screen and stow.

• SRS Drivers Airbag



Driver Airbag

Additional Information

- Refer to **Vehicle Safety Features** for SRS information
- Requires correct SRS storage in line with health and safety regulations
- Heater/Blower Intake Duct - Removed to allow disconnection of the battery
- Disconnect Battery - Negative terminal only
- Seat Belt Front Lower Fixing RH/LH - Includes removal of small plastic cover to access fixing
- Steering Wheel:-
 - Renew fixing and apply thread lock

Torque Settings

- Seat Belt Front Lower Fixing RH/LH - **35Nm**
- Seat Front LH/RH:-
 - Fixing to floor - **50Nm**
- Airbag Drivers Side - **7Nm**
- Steering Wheel - **80Nm**



Driver Airbag

Item 16

Airbag drivers side



Item 20

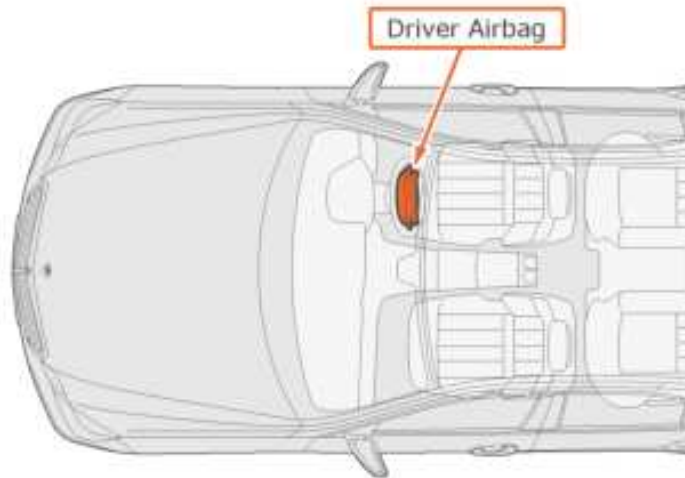
Switches Steering Column

Strip Route	
SRS Drivers Airbag	
Mechanical, Electrical, Trim (MET)	
1. Remove Heater/Blower Intake Duct	ⓘ
2. Disconnect Battery	ⓘ ⚠
3. Remove Seat Belt Front Lower Fixing RH	ⓘ ⚠
4. Remove Seat Belt Front Lower Fixing LH	ⓘ ⚠
5. Remove Seat Front LH	⚠
6. Remove Seat Front RH	⚠
7. Remove Ashtray/Cigar Lighter Assembly	
8. Remove Heater Control Assembly	
9. Remove Centre Console Fixings	⚠
10. Remove Sill Panel Inner Trim Front LH	
11. Remove Sill Panel Inner Trim Front RH	
12. Remove Door Front Aperture Weatherseal LH	
13. Remove Door Front Aperture Weatherseal RH	
14. Remove A Post Upper Trim LH	⚠
15. Remove A Post Upper Trim RH	⚠
16. Remove Airbag Drivers Side	⚠
17. Remove Steering Wheel	ⓘ ⚠
18. Remove Facia Panel Lower Dash Panel RH	
19. Remove Facia Panel Lower Dash Panel LH	
20. Remove Switches Steering Column	
21. Remove Facia Panel End Cover LH	
22. Remove Facia Panel End Cover RH	

table continued on next page



SRS Drivers Airbag - Cont.



Additional Information

- Facia Panel Vent RH - Includes internal temperature sensor
- Steering Column Shroud Upper - Refers to the cloth shroud at the top of the column
- A/C Solar Sensor - Located in grille on top centre of facia
- Ignition Lock Cover:-
 - Use special tool to remove
 - Part number - **639589010700**
- Steering Column - Removed to allow removal of facia carrier

Torque Settings

- Facia Panel Fixings:-
 - Support for knee airbag - **6Nm**
- Steering Column Lower Joint - **24Nm**
- Steering Column - **26Nm**
- Airbag Passenger Side - **6Nm**
- Airbag Drivers Knee - **2.5Nm**



Item 33

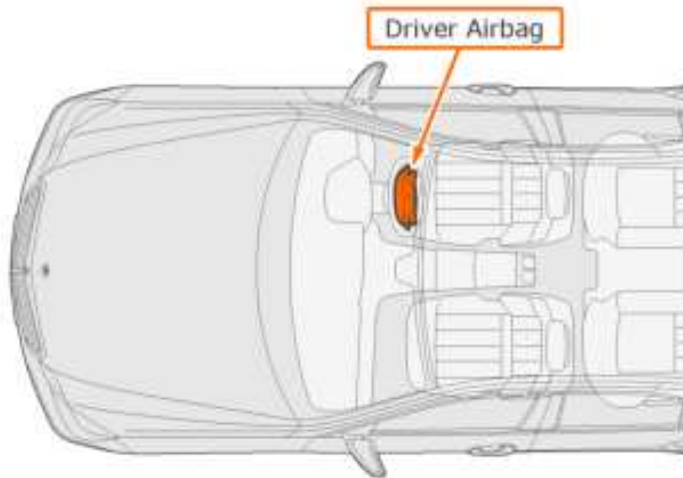
Ignition lock cover tool being used

Strip Route - Cont.	
SRS Drivers Airbag	
Mechanical, Electrical, Trim (MET)	
23. Remove Facia Panel Vent RH	①
24. Remove Facia Panel Vent Centre	
25. Remove Instrument Cluster Surround	
26. Remove Instrument Cluster	
27. Remove Steering Column Shroud Upper	①
28. Disconnect Handbrake Release Handle	
29. Remove Multi Function Display Unit	
30. Remove Stereo Head unit	⊗
31. Remove A/C Solar Sensor	①
32. Remove Glove Compartment Assembly	
33. Remove Ignition Lock Cover	①
34. Disconnect Facia Wiring	
35. Disconnect Facia Panel Fixings	⊗
36. Disconnect / Lay Aside Steering Column Lower Joint	⊗
37. Remove Steering Column	① ⊗
38. Remove Airbag Passenger Side	⊗
39. Remove Airbag Drivers Knee	⊗
40. Remove Switch Headlamp	
41. Remove Interior Temperature Sensor	
42. Remove Handbrake Lever Surround	
43. Remove Heater Duct/Ducts Rear	
44. Remove Miscellaneous Items From Facia Panel	

table continued on next page



SRS Drivers Airbag - Cont.



Driver Airbag

Additional Information

- Seat Belt Front Upper Fixing RH - Includes guide
- B Post Upper Trim RH - Clips may break upon removal
- Fuse/Relay Box 2:-
 - Refers to battery isolation unit
 - Houses the main power cables
 - Located on the lefthand strut tower
 - SRS sensor incorporated into unit
 - Activated for airbags only
- ECU Fault Code Check:-
 - Memory has to be deleted after airbag deployment
 - Airbag ECU replacement is required only if damaged fault codes indicate replacement or after 3 airbag deployments

Torque Settings

- Seat Belt Front Upper Fixing RH:-
 - Upper fixing - **32Nm**
 - Guide fixing - **32Nm**
- Seat Belt Front Reel RH - **32Nm**



Battery Isolator

Item 51

Fuse/Relay Box 2 - Incorporates battery isolator

Strip Route - Cont.

SRS Drivers Airbag	
Mechanical, Electrical, Trim (MET)	
45. Remove Seat Belt Front Upper Fixing RH	① ②
46. Remove Seat Belt Front Reel RH	②
47. Remove Sill Panel Inner Trim Rear RH	
48. Remove Door Rear Aperture Weatherseal RH	
49. Remove B Post Lower Trim RH	
50. Remove B Post Upper Trim RH	①
51. Remove Fuse/Relay Box 2	① ②
52. Carry out ECU Fault Code Check	①



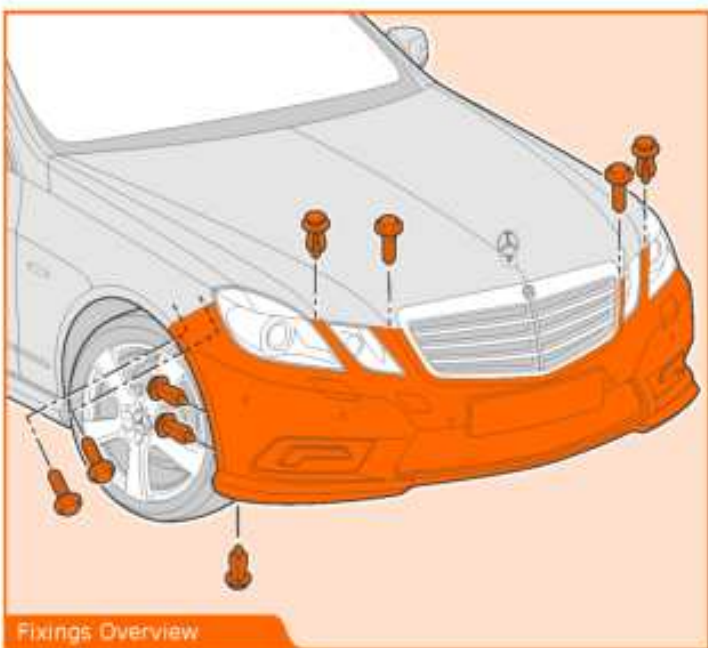
Bumper Front R&R



Additional Information

- Heater/Blower Intake Duct - Removed to allow disconnection of the battery
- Disconnect Battery - Negative terminal only

Strip Route	
Bumper Front R&R	
Mechanical, Electrical, Trim (MET)	
1. Load-Unload Vehicle to Ramp	
2. Remove Heater/Blower Intake Duct	①
3. Disconnect Battery	① Ⓝ
4. Remove Air Filter Ducts	
5. Remove Grille Front Fixings	Ⓝ
6. Remove Wing Front Liner LH	
7. Remove Wing Front Liner RH	
8. Remove Bumper Fixing Front	Ⓝ
9. Focus Front Foglamps	



Fixings Overview



Bumper Front Reinforcement Panel



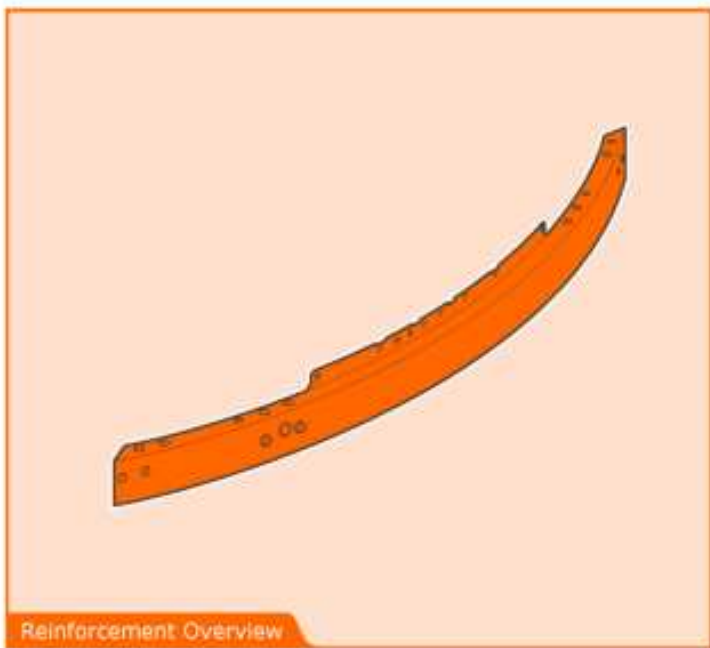
Additional Information

- Refer to **Vehicle Safety Features** for SRS information
- Washer Tubing Headlamp - Refers to piping that runs coolant to the washer bottle to prevent freezing
- Centre Brace Fixings - Refers to metal brace that connects landing panel to front bumper front reinforcement

Torque Settings

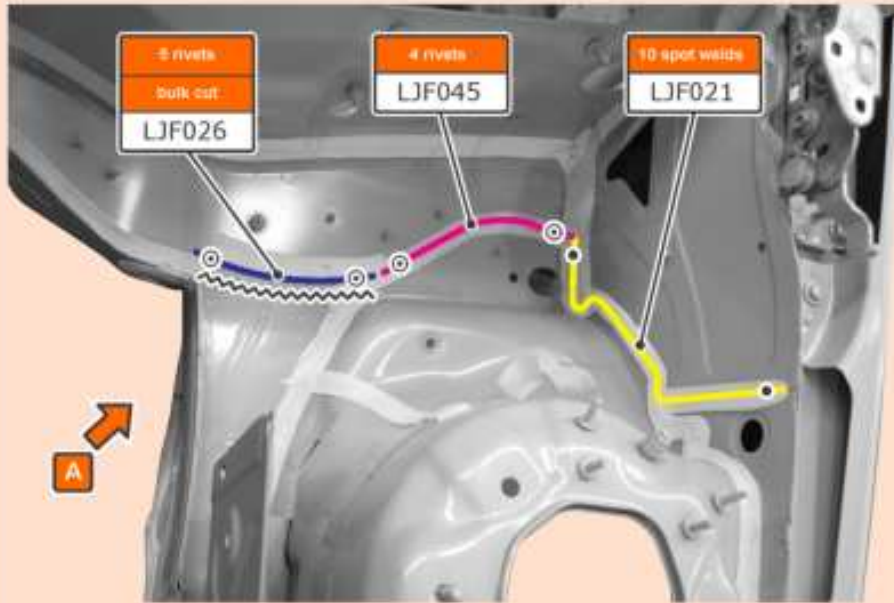
- Centre Brace Fixings - **10Nm**
- Bumper Front Reinforcement Fixings: -
 - Mount fixings - **28Nm +135°**
 - 6mm Bracket fixings - **No torques found**
- Airbag Impact Sensor LH/RH - **8Nm**
- Airbag Impact Sensor (centre) - **8Nm**
- Horn LH/RH - **8Nm**

Strip Route	
Bumper Front Reinforcement Panel	
Mechanical, Electrical, Trim (MET)	
1. Remove Headlamp LH	ⓘ
2. Remove Headlamp RH	ⓘ
3. Remove Engine Splash Shield Front	
4. Drain- Refill Cooling System	
5. Remove Washer Tubing Headlamp	ⓘ
6. Remove / Lay Aside Wiring Harness Front Bumper Rein	
7. Remove Centre Brace Fixings	ⓘ Ⓞ
8. Remove Bumper Front Reinforcement Fixings	Ⓞ
9. Remove Airbag Impact Sensor LH	Ⓞ
10. Remove Airbag Impact Sensor RH	Ⓞ
11. Remove Airbag Impact Sensor (centre)	Ⓞ
12. Remove Horn LH	Ⓞ
13. Remove Horn RH	Ⓞ
14. Focus Headlamps	



Centre Brace Fixing location





Note: Joints LJF026/LJF027/LJF028/LJF029 & LJF045 use Polygrip flat/round head rivets, dia 6.4X14



Service Condition Information

Chassis Leg Front & Inner Wing LH: Combination Panel
Served as a separate panel

TTS Reference
LM1000

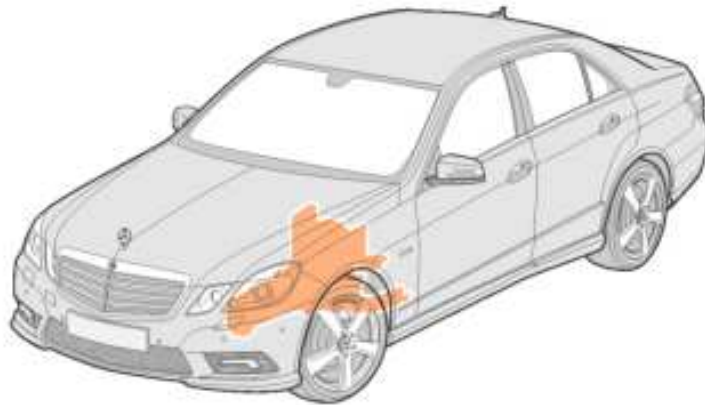
Replacement Information

Corrosion Protection	cavity wax		
Material	HSS	Yield Strength (Mpa)	<550
Panel Fixing	welded	riveted	

Fitted With

headlamp panel support bracket, chassis leg front side extension, wing front inner side reinforcement, wing front inner side reinforcement lower, wing front inner side reinforcement extension, wing front mounting bracket upper rear

Chassis Leg Front & Inner Wing LH



Additional Information

- Refer to **Vehicle Safety Features** for SRS information
- Requires correct SRS storage in line with health and safety regulations
- Door Trim Board Front LH:-
 - Partially remove then disconnect bowden cable
 - Includes a lower cover trim
- Fuse/Relay Box 2:-
 - Refers to battery isolation unit
 - Houses the main power cables
 - Located on the lefthand strut tower
 - SRS sensor incorporated into unit
 - Activated for airbags only

Torque Settings

- ABS Pump Modulator:-
 - Brake pipe to master cylinder - **16Nm**
 - Brake pipes to modulator - **16Nm**

Strip Route
Chassis Leg Front & Inner Wing LH
Mechanical, Electrical, Trim (MET)
1. Remove Bonnet Support Strut RH
2. Remove Bonnet Support Strut LH
3. Remove Speaker Grille Door Tweeter Front LH
4. Remove Door Window Frame Trim Front LH
5. Remove Door Trim Board Front LH ①
6. Disconnect Door LHF
7. Disconnect Airbag ECU
8. Remove A Post Lower Trim LH
9. Remove A Post Lower Trim RH
10. Remove ABS Pump Modulator ②
11. Remove Insulation Gearbox Tunnel
12. Remove Washer Bottle Screen Front
13. Remove A/C Pipes Inner Wing LH
14. Remove A/C Pipe Front Bulkhead
15. Remove Fuse/Relay Box 2 ①
16. Remove Fuel Pipes at Chassis Leg
<small>Table continued on next page</small>



Item 7

Airbag ECU location



Item 15

Fuse/Relay Box 2 - Incorporates battery isolator



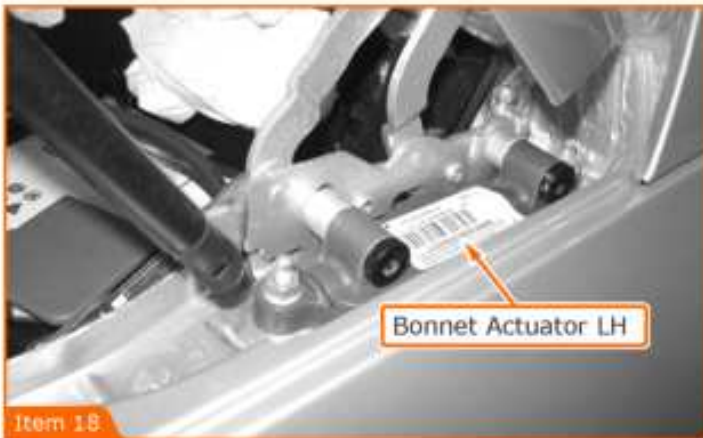
Chassis Leg Front & Inner Wing LH

Torque Settings

- Wiper Front Motor & Mechanism Assembly:-
 - Black Brace - **35Nm**
 - Wiper mechanism bolts - **22Nm**
- Steering Column - **26Nm**



Strip Route - Cont.	
Chassis Leg Front & Inner Wing LH	
Mechanical, Electrical, Trim (MET)	
17. Remove Wiper Front Motor & Mechanism Assembly	ⓘ
18. Remove Pedestrian Protection Bonnet Actuator LH	⚠
19. Remove Steering Column	ⓘ
20. Remove Pedal Throttle	
21. Remove Insulation Outer Bulkhead	
22. Remove Carpet Section Front LH	
table continued on next page	

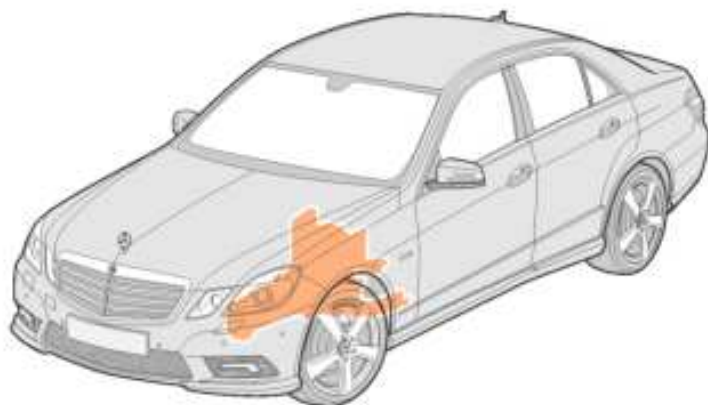


Bonnet Actuator LH

Item 18

Pedestrian Bonnet Actuator Location

Chassis Leg Front & Inner Wing LH

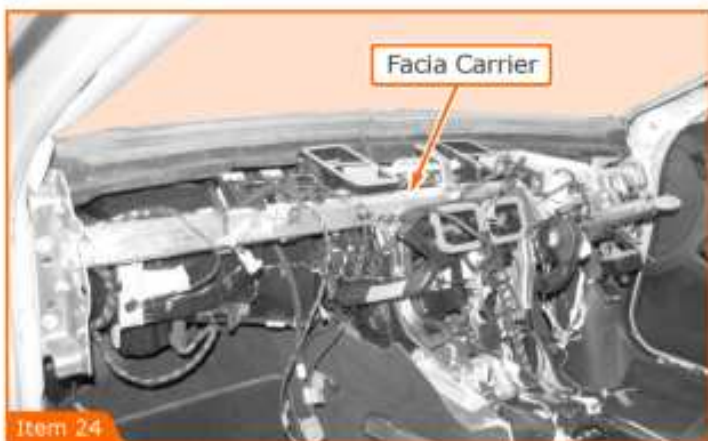


Additional Information

- Insulation Floor Panel Front - Refers to an insulation plate and metal spacer which carries an ecu where the front passenger feet rest
- Alarm Horn - Located under LH front wing

Torque Settings

- Facia Panel Support Carrier: -
 - Centre support strut - **50Nm**
 - Steering Column Support Bracket - **25Nm**
 - Support to A Pillar - **25Nm**
- Battery:-
 - Retaining Nut - **21Nm**



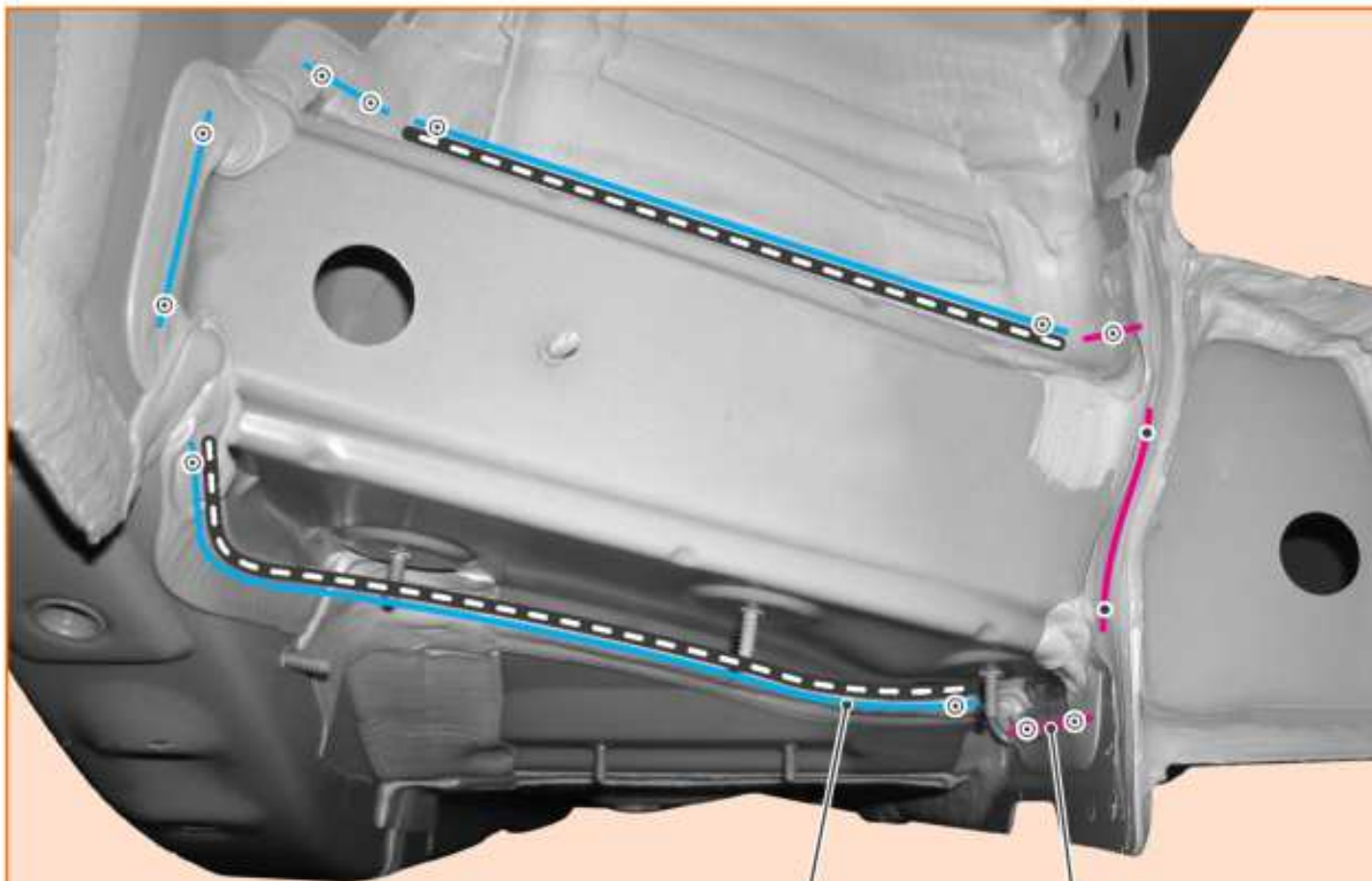
Item 24

Facia Panel Support Carrier

Strip Route - Cont.

- Chassis Leg Front & Inner Wing LH
- Mechanical, Electrical, Trim (MET)**
- Remove Carpet Section Front RH
 - Remove Facia Panel Support Carrier **T**
 - Remove Heater Casing
 - Lay Aside Wiring Harness Front Inner Wing LH
 - Lay Aside Wiring Harness Front A Post Inner LH
 - Disconnect / Lay Aside Wiring Harness Front A Post LH
 - Remove / Lay Aside Wiring Harn. Chassis Leg Front LH Sect.
 - Lay Aside Insulation Floor Panel LH
 - Remove Insulation Floor Panel Front **I**
 - Lay Aside Insulation Inner Bulkhead LH
 - Remove Plenum Chamber Drain Tube Front LH
 - Lay Aside Brake Pipes Front To Rear
 - Remove Alarm Horn **I** **S**
 - Remove Battery **T**
 - Remove Misc Items From Wing Inner Frt Side Reinf LH
 - Remove Misc Items From Chassis Leg Section Front LH
 - Remove Misc Items From Chassis Leg Section Front RH
 - Remove Misc Items From Chassis Leg & I Wing LHF





• Note: Joints LJF035/LJF046 use Polygrip flat/round head rivets, dia 6.4X14

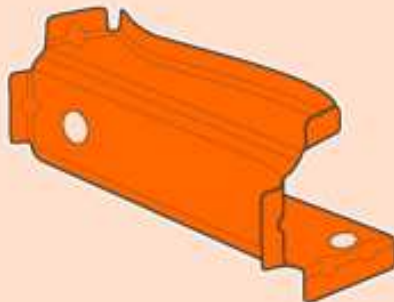
16 rivets
2k adhesive
LJF032

2 spot welds
3 rivets
LJF046

Service Condition Information

Chassis Leg Front Side Extension LH Combination Panel

Serviced as a separate panel



TTS Reference
LFM030

Replacement Information

Corrosion Protection	cavity wax		
Material	HSS	Yield Strength (Mpa)	<550
Panel Fixing	welded	bonded	riveted

Fitted With

Not Applicable



Chassis Leg Front Side Extension LH



Additional Information

- Refer to **Vehicle Safety Features** for SRS information
- Requires correct SRS storage in line with health and safety regulations
- Steering Column - Removed to allow removal of the facia carrier
- Insulation Floor Panel Front - Refers to insulation plate and metal spacer which carries an ecu where the front passenger feet rest
- Insulation Floor Panel LH - Refers to the lower section of the inner bulkhead insulation

Torque Settings

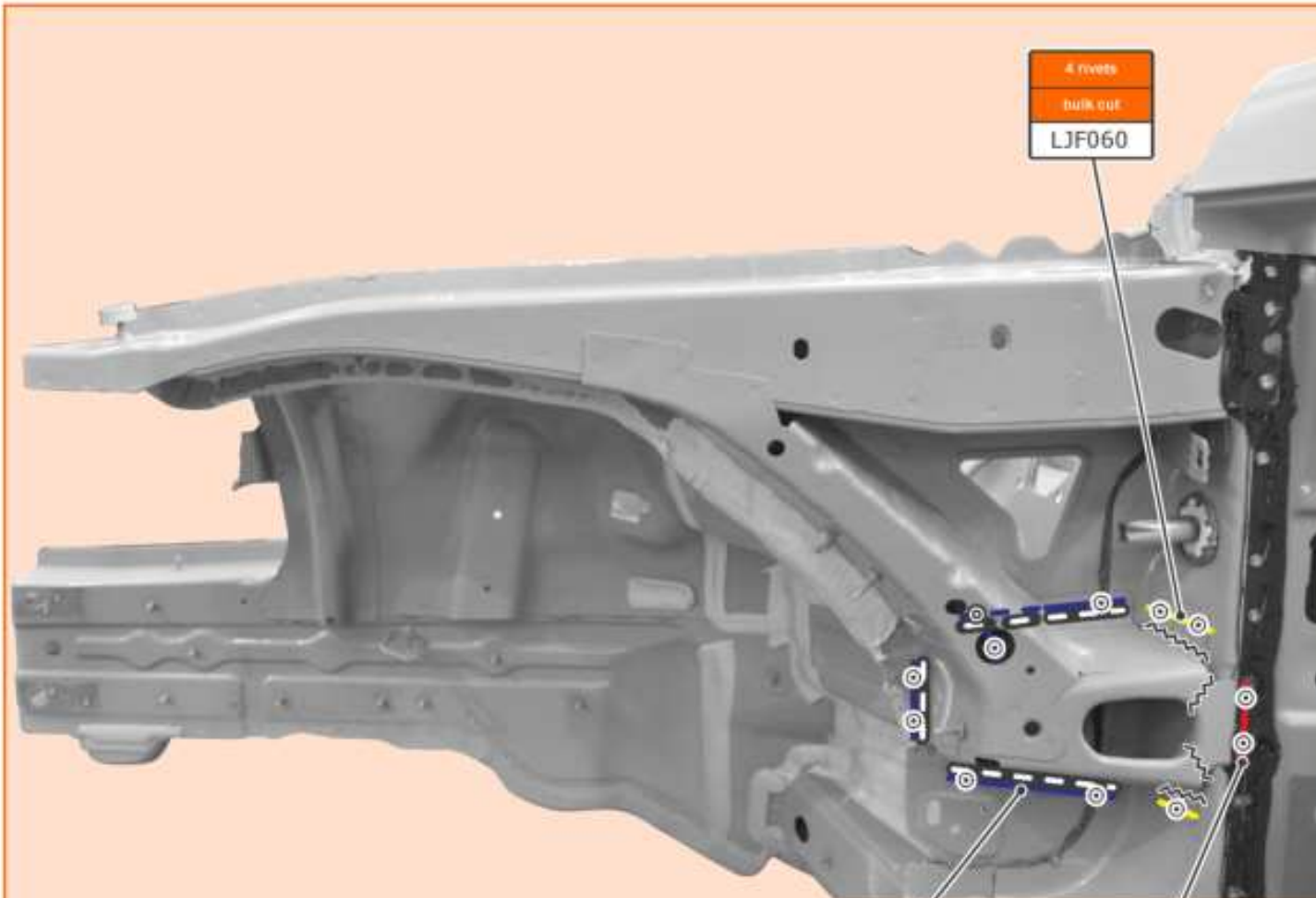
- Wheel Road Front LH - **130Nm**
- Steering Column Lower Joint - **24Nm**
- Steering Column - **26Nm**



Airbag ECU location

Strip Route	
Chassis Leg Front Side Extension LH	
Mechanical, Electrical, Trim (MET)	
1. Remove A Post Lower Trim LH	
2. Remove A Post Lower Trim RH	
3. Disconnect Airbag ECU	Ⓢ
4. Remove Wheel Road Front LH	Ⓢ
5. Remove Engine Splash Shield	
6. Remove Pedal Throttle	
7. Disconnect / Lay Aside Steering Column Lower Joint	Ⓢ
8. Remove Steering Column	Ⓢ Ⓢ
9. Lay Aside Wiring Harness Front A Post Inner LH	
10. Remove Carpet Section Front LH	
11. Remove Carpet Section Front RH	
12. Remove Insulation Floor Panel Front	Ⓢ
13. Lay Aside Insulation Floor Panel LH	Ⓢ





4 rivets
bulk cut
LJF060

7 rivets
2% adhesive
LJF057

2 rivets
bulk cut
LJF059

Note: Joints LJF057/LJF059 and LJF060 use Polygrip flat/round head rivets, dia 6.4X14

Note: Wing front inner side reinforcement lower and wing front inner side reinforcement extension are offered up together, aligned and tac welded, then remove panels and spot welded (joint LJF050) together before welding to car.



Service Condition Information

Wing Front Inner Side Reinforcement Extension LH Combination Panel

Serviced as a separate panel

TTS Reference
LPF556

Replacement Information

Corrosion Protection	cavity wax		
Material	HSS	Yield Strength (Mpa)	<550
Panel Fixing	welded	bonded	riveted

Fitted With

wing front inner side reinforcement lower

Wing Front Inner Side Rein. Ext. LH



Additional Information

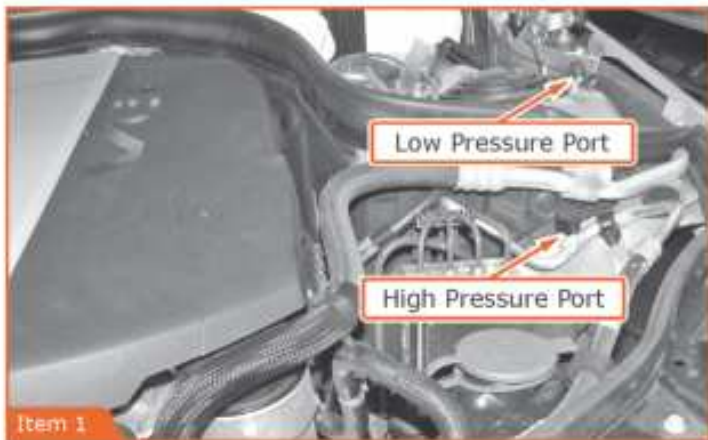
- A/C Evac/Charge:-
 - Refrigerant capacity - **590Grms**
 - Oil Grade - **Pag 46**
- Scuttle Panel Grille - Includes disconnection of washer pipe
- Alarm Horn - Located under LH front wing

Torque Settings

- Wiper Front Arm & Blade LH/RH - **22Nm**
- Wiper Front Motor & Mechanism Assembly:-
 - Black Brace - **35Nm**
 - Mechanism Bolts - **22Nm**
- Battery:-
 - Retaining nut - **21Nm**
- Wheel Road Front LH - **130Nm**

Strip Route	
Wing Front Inner Side Reinforcement Extension LH	
Mechanical, Electrical, Trim (MET)	
1. A/C Evac/Charge	①
2. Drain- Refill Cooling System	
3. Disconnect Airbag ECU	⚠
4. Disconnect Door LHF	
5. Remove Heater Hose	
6. Remove A Post Lower Trim RH	
7. Remove A Post Lower Trim LH	
8. Remove Wiper Front Arm & Blade LH	Ⓡ
9. Remove Wiper Front Arm & Blade RH	Ⓡ
10. Remove Scuttle Panel Grille	①
11. Remove Carpet Section Front LH	
12. Remove Carpet Section Front RH	
13. Remove Wiper Front Motor & Mechanism Assembly	Ⓡ
14. Remove Battery	Ⓡ
15. Remove Plenum Chamber Drain Tube-Front LH	
16. Remove Pedal Throttle	
17. Remove Wheel Road Front LH	Ⓡ
18. Remove Engine Splash Shield	
19. Remove Alarm Horn	① ⚠

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Item 1

Air Conditioning Port Location



Item 3

Airbag ECU location



Wing Front Inner Side Rein. Ext. LH



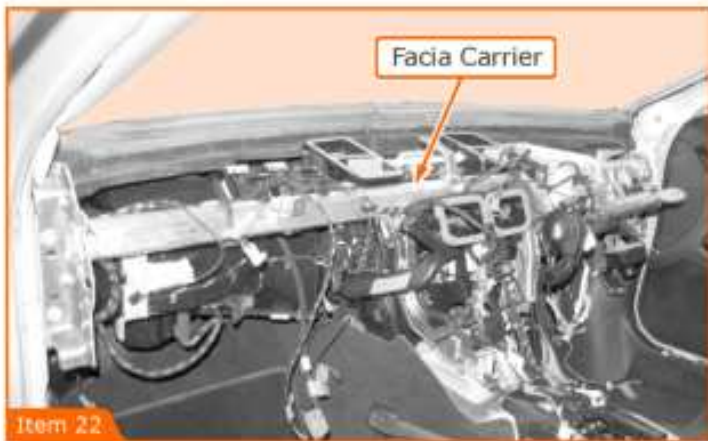
Additional Information

- Facia Panel Support Carrier - Includes removing and laying aside the handbrake pedal mechanism

Torque Settings

- Steering Column Lower Joint - **24Nm**
- Steering column - **26Nm**
- Facia Panel Support Carrier:-
 - Centre Support Strut - **50Nm**
 - Steering Column Support Bracket - **25Nm**
 - Support to A Pillar - **25Nm**

Strip Route - Cont.	
Wing Front Inner Side Reinforcement Extension LH	
Mechanical, Electrical, Trim (MET)	
20. Disconnect / Lay Aside Steering Column Lower Joint	ⓘ
21. Remove Steering Column	ⓘ
22. Remove Facia Panel Support Carrier	ⓘ ⓘ
table continued on next page	



Item 22

Facia Panel Support Carrier location

Wing Front Inner Side Rein. Ext. LH



Additional Information

- Insulation Floor Panel Front - Refers to an insulation plate and metal spacer which carries an ecu where the front passenger feet rest

Strip Route - Cont.

Wing Front Inner Side Reinforcement Extension LH

Mechanical, Electrical, Trim (MET)

23. Remove Heater Casing

24. Lay Aside Insulation Inner Bulkhead LH

25. Remove A/C Pipe Front Bulkhead

26. Remove Insulation Outer Bulkhead

27. Remove Insulation Floor Panel Front ⓘ

28. Lay Aside Insulation Floor Panel LH

29. Remove / Lay Aside Wiring Harn. Chassis Leg Front LH Sect.

30. Lay Aside Wiring Harness Front A Post Inner LH

31. Disconnect / Lay Aside Wiring Harness Front A Post LH

32. Lay Aside Wiring Harness Front Inner Wing LH

33. Remove Misc Items From Wing Inner Frt Side Reinf LH

10 spot welds
2k adhesive
LJF030

23 spot welds
2k adhesive
LJF031

2 rivets
LJF049

2 rivets
LJF055

2 rivets
LJF053

View A

Note: Joint LJF049 - The tab on Wing Front Side Reinforcement needs to be turned 180 deg before fitting to allow riveting.

Note: Joints LJF049/LJF053 and LJF055 use Polygrip flat/round head rivets, dia 6.4X14

Note: Joint LJF053 - If fitting Wing Front Side Reinforcement with A Post Outer then replace rivets with mig plugs.

WARNING SRS

CAUTION HSB

Service Condition Information

Wing Front Inner Side Reinforcement LH Combination Panel

Serviced as a separate panel

TTS Reference
LPF052

Replacement Information

Corrosion Protection	cavity wax		
Material	HSS	Yield Strength (Mpa)	<550
Panel Fixing	welded	bonded	riveted

Fitted With

wing front inner side reinforcement lower,
wing front inner side reinforcement extension,
wing front mounting bracket upper rear

Wing Front Inner Side Rein. LH

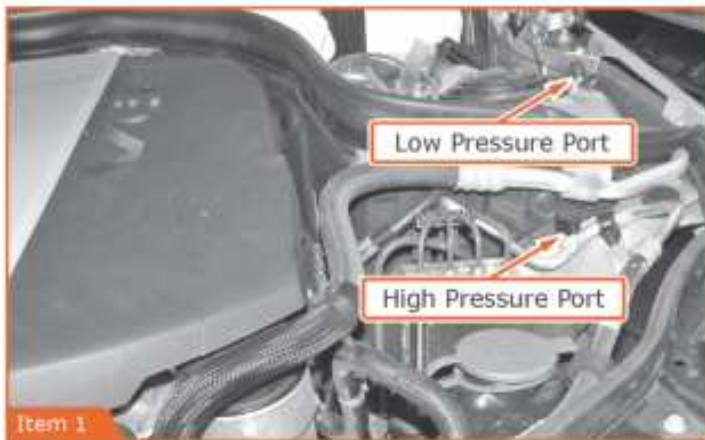


Additional Information

- Refer to **Vehicle Safety Features** for SRS information
- Requires correct SRS storage in line with health and safety regulations
- A/C Evac/Charge:-
 - Refrigerant capacity - **590Grms**
 - Oil Grade - **Pag 46**
- Scuttle Panel Grille - Includes disconnection of washer pipe

Torque Settings

- Wiper Front Arm & Blade LH/RH - **22Nm**
- Wiper Front Motor & Mechanism Assembly:-
 - Black Brace - **35Nm**
 - Mechanism Bolts - **22Nm**
- Battery:-
 - Retaining nut - **21Nm**
- Wheel Road Front LH - **130Nm**



Item 1

Air Conditioning Port Location



Item 3

Airbag ECU location

Strip Route	
Wing Front Inner Side Reinforcement LH	
Mechanical, Electrical, Trim (MET)	
1. A/C Evac/Charge	①
2. Drain- Refill Cooling System	
3. Disconnect Airbag ECU	⚠
4. Disconnect Door LHF	
5. Remove Heater Hose	
6. Remove A Post Lower Trim RH	
7. Remove A Post Lower Trim LH	
8. Remove Carpet Section Front RH	
9. Remove Carpet Section Front LH	
10. Remove Wiper Front Arm & Blade LH	⚠
11. Remove Wiper Front Arm & Blade RH	⚠
12. Remove Scuttle Panel Grille	①
13. Remove Wiper Front Motor & Mechanism Assembly	⚠
14. Remove Pedestrian Protection Bonnet Actuator LH	⚠
15. Remove Battery	⚠
16. Remove Plenum Chamber Drain Tube Front LH	
17. Remove Pedal Throttle	
18. Remove Wheel Road Front LH	⚠
19. Remove Engine Splash Shield	

table continued on next page



Wing Front Inner Side Rein. LH



Additional Information

- Alarm Horn - Located under the LH front wing

Torque Settings

- Steering Column Lower Joint - **24Nm**
- Steering Column - **26Nm**

Strip Route - cont.	
Wing Front Inner Side Reinforcement LH	
Mechanical, Electrical, Trim (MET)	
20. Remove Alarm Horn	① ⚠
21. Disconnect / Lay Aside Steering Column Lower Joint	⚠
22. Remove Steering Column	⚠
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Wing Front Inner Side Rein. LH - Cont.

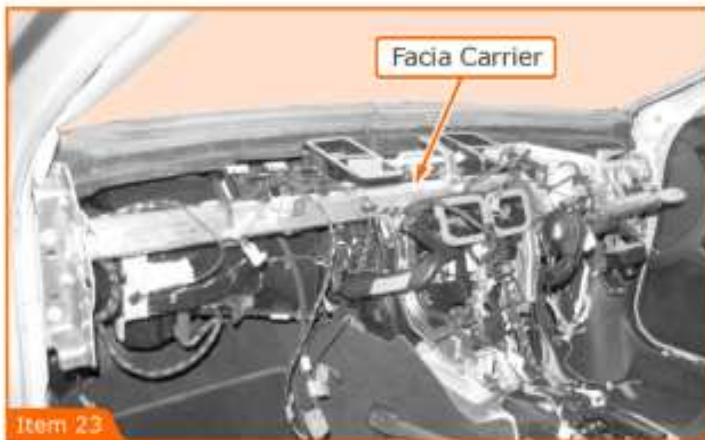


Additional Information

- Facia Panel Support Carrier - Includes removing and laying aside the handbrake mechanism
- Insulation Floor Panel Front - Refers to an insulation plate and metal spacer which carries an ECU where the front passenger feet rest

Torque Settings

- Facia Panel Support Carrier: -
 - Centre Support Strut - **50Nm**
 - Steering Column Support Bracket - **25Nm**
 - Support to A Pillar - **25Nm**



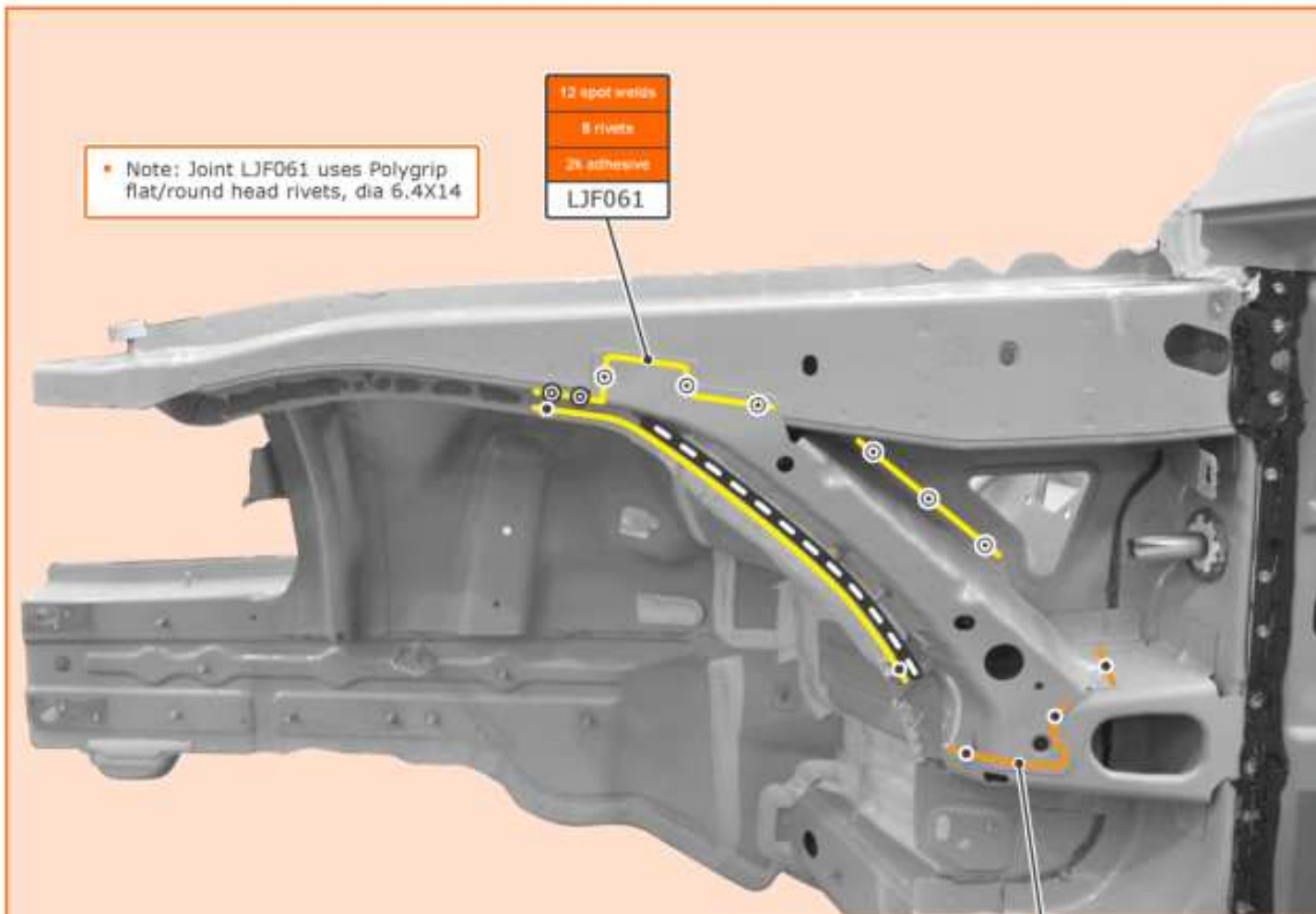
Facia Panel Support Carrier location

Strip Route - Cont.

Wing Front Inner Side Reinforcement LH

Mechanical, Electrical, Trim (MET)

23. Remove Facia Panel Support Carrier: ⓘ ⓘ
24. Remove Heater Casing
25. Lay Aside Insulation Inner Bulkhead LH
26. Remove A/C Pipe Front Bulkhead
27. Remove Insulation Outer Bulkhead
28. Remove Insulation Floor Panel Front ⓘ
29. Lay Aside Insulation Floor Panel LH
30. Remove / Lay Aside Wiring Harn. Chassis Leg Front LH Sect.
31. Lay Aside Wiring Harness Front A Post Inner LH
32. Disconnect / Lay Aside Wiring Harness Front A Post LH
33. Lay Aside Wiring Harness Front Inner Wing LH
34. Remove Misc Items From Wing Inner Frt Side Reinf LH



• Note: Joint LJF061 uses Polygrip flat/round head rivets, dia 6.4X14

12 spot welds
8 rivets
2% adhesive
LJF061

8 spot welds
LJF050

• Note: Wing front inner side reinforcement lower and wing front inner side reinforcement extension are offered up together, aligned and tac welded, then remove panels and spot welded (joint LJF050) together before welding to car.

Service Condition Information

Wing Front Inner Side Reinforcement Lower LH Combination Panel

Serviced as a separate panel

TTS Reference
LPF555

Replacement Information

Corrosion Protection	cavity wax		
Material	HSS	Yield Strength (Mpa)	<550
Panel Fixing	welded	bonded	riveted

Fitted With

wing front inner side reinforcement extension



Wing Front Inner Side Rein. Lower LH



Additional Information

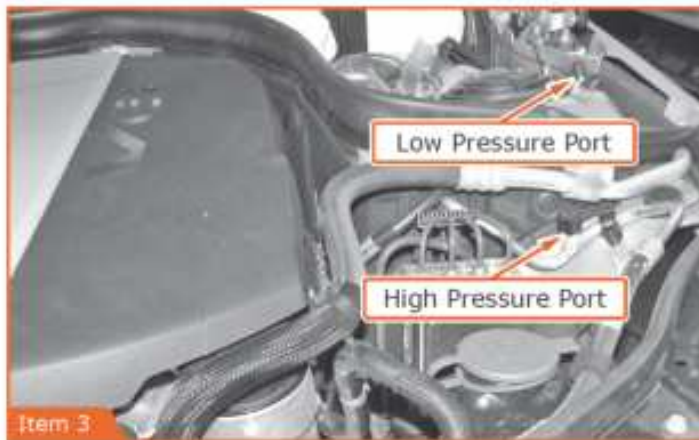
- Refer to **Vehicle Safety Features** for SRS information
- Requires correct SRS storage in line with health and safety regulations
- A/C Evac/Charge:-
 - Refrigerant capacity - **590Grms**
 - Oil Grade - **Pag 46**
- Scuttle Panel Grille - Includes disconnection of washer pipe

Torque Settings

- Wiper Front Arm & Blade LH/RH - **22Nm**
- Wiper Front Motor & Mechanism Assembly:-
 - Black Brace - **35Nm**
 - Mechanism Bolts - **22Nm**
- Battery:-
 - Retaining nut - **21Nm**
- Wheel Road Front LH - **130Nm**



Airbag ECU location



Air Conditioning Port Location

Strip Route	
Wing Front Inner Side Reinforcement Lower LH	
Mechanical, Electrical, Trim (MET)	
1. A/C Evac/Charge	①
2. Drain- Refill Cooling System	
3. Disconnect Airbag ECU	⚠
4. Disconnect Door LHF	
5. Remove Heater Hose	
6. Remove A Post Lower Trim RH	
7. Remove A Post Lower Trim LH	
8. Remove Carpet Section Front RH	
9. Remove Carpet Section Front LH	
10. Remove Wiper Front Arm & Blade LH	⚠
11. Remove Wiper Front Arm & Blade RH	⚠
12. Remove Scuttle Panel Grille	①
13. Remove Wiper Front Motor & Mechanism Assembly	⚠
14. Remove Battery	⚠
15. Remove Plenum Chamber Drain Tube-Front LH	
16. Remove Pedal Throttle	
17. Remove Wheel Road Front LH	⚠
18. Remove Engine Splash Shield	
19. Remove Alarm Horn	⚠

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Wing Front Inner Side Rein. Lower LH



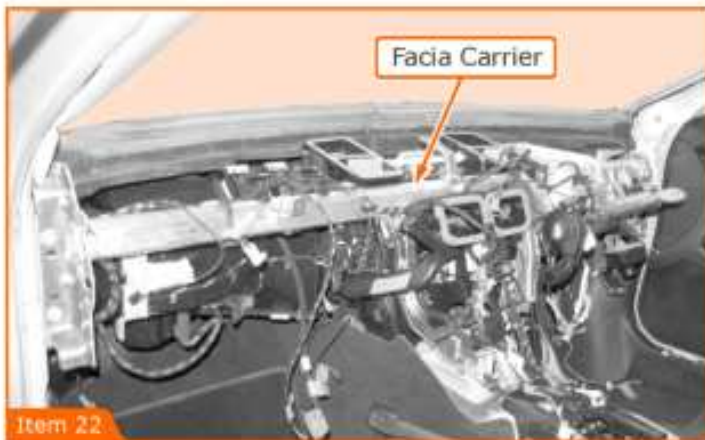
Additional Information

- Steering Column - Removed to allow removal of facia carrier
- Facia Panel Support Carrier - Includes removing and laying aside the handbrake mechanism

Torque Settings

- Steering Column Lower Joint - **24Nm**
- Steering Column - **26Nm**
- Facia Panel Support Carrier: -
 - Centre Support Strut - **50Nm**
 - Steering Column Support Bracket - **25Nm**
 - Support to A Pillar - **25Nm**

Strip Route - Cont.	
Wing Front Inner Side Reinforcement Lower LH	
Mechanical, Electrical, Trim (MET)	
20. Disconnect / Lay Aside Steering Column Lower Joint	🔧
21. Remove Steering Column	🔧 ⚙️
22. Remove Facia Panel Support Carrier	🔧 ⚙️
table continued on next page	



Facia Carrier

Item 22

Facia Panel Support Carrier location

Wing Front Inner Side Rein. Lower LH



Additional Information

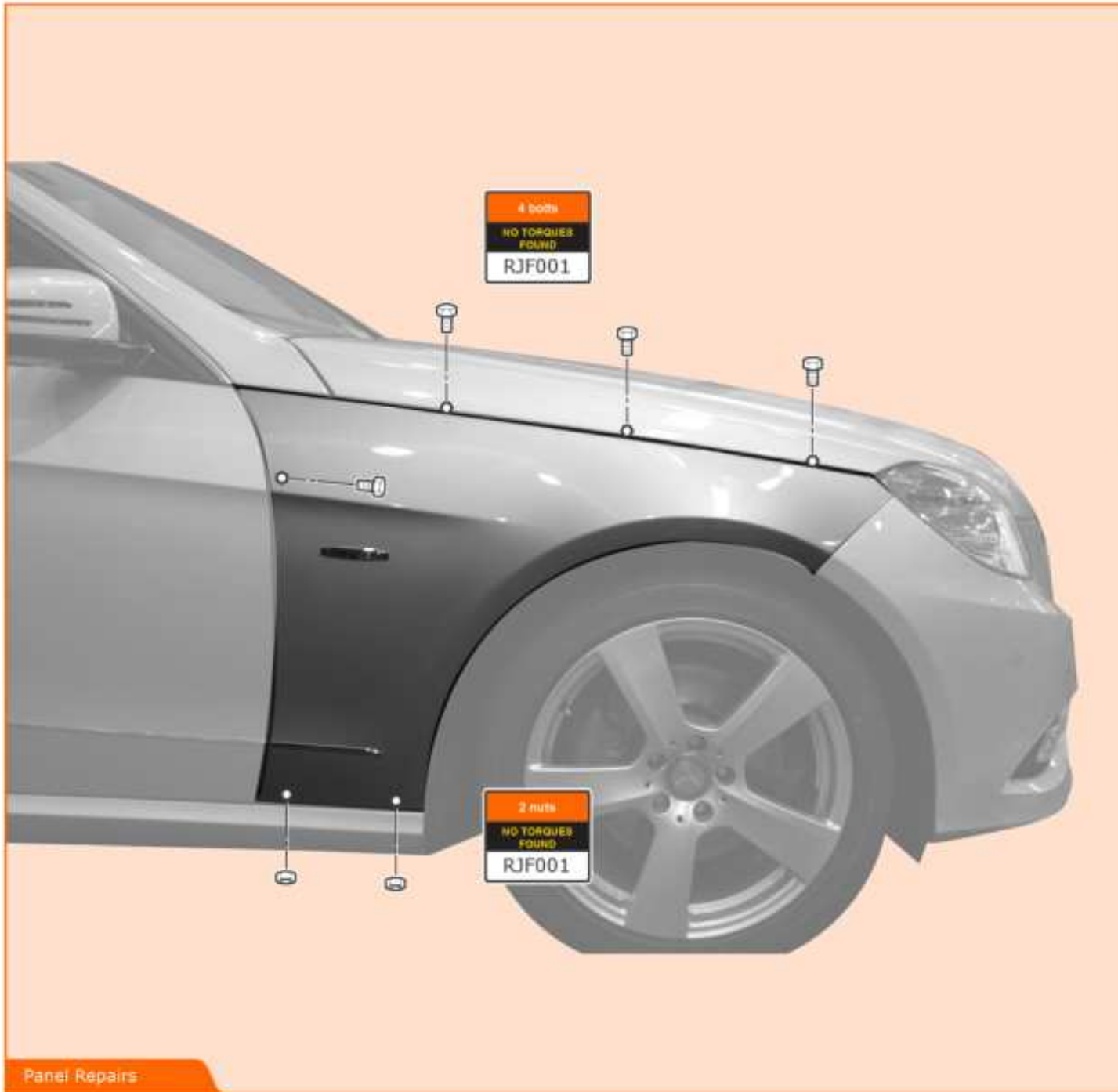
- Insulation Floor Panel Front - Refers to an insulation plate and metal spacer which carries an ecu where the front passenger feet rest

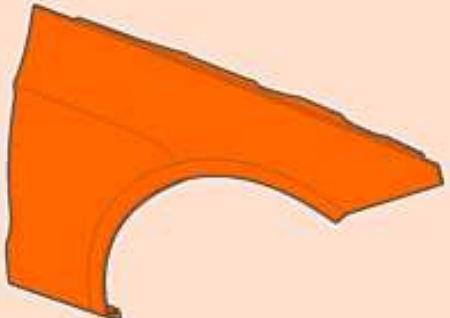
Strip Route - Cont.

Wing Front Inner Side Reinforcement Lower LH

Mechanical, Electrical, Trim (MET)

23. Remove Heater Casing
24. Lay Aside Insulation Inner Bulkhead LH
25. Remove A/C Pipe Front Bulkhead
26. Remove Insulation Outer Bulkhead
27. Remove Insulation Floor Panel Front **①**
28. Lay Aside Insulation Floor Panel LH
29. Remove / Lay Aside Wiring Harn. Chassis Leg Front LH Sect.
30. Lay Aside Wiring Harness Front A Post Inner LH
31. Disconnect / Lay Aside Wiring Harness Front A Post LH
32. Lay Aside Wiring Harness Front Inner Wing LH



Service Condition Information			
Wing Front		Single Panel	
Serviced as a seperate panel			
			
TTS Reference RFW000			
Replacement Information			
Corrosion Protection	n/a		
Material	aluminium	Yield Strength (Mpa)	n/a
Panel Fixing	bolted		
Fitted With			
Not Applicable			

Wing Front



Additional Information

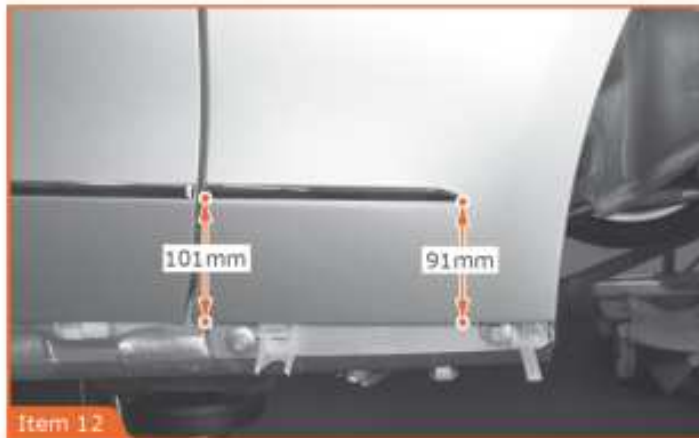
- Heater/Blower Intake Duct - Removed to allow disconnection of the battery
- Disconnect Battery - Negative terminal only
- Badge Wing Front - Will need replacing
- Moulding Wing Front RH:-
 - Refers to chrome trim
 - Will need replacing

Strip Route	
Wing Front RH	
Mechanical, Electrical, Trim (MET)	
1. Load-Unload Vehicle to Ramp	
2. Remove Heater/Blower Intake Duct	ⓘ
3. Disconnect Battery	ⓘ ⚠
4. Remove Air Filter Ducts	
5. Remove Grille Front Fixings	⚠
6. Remove Wing Front Liner LH	
7. Remove Wing Front Liner RH	
8. Remove Bumper Fixing Front	⚠
9. Remove Extension Sill Painted RH Fixings	
10. Remove Floor Pan Splash Shield RH	
11. Remove Badge Wing Front RH	ⓘ
12. Remove Moulding Wing Front RH	ⓘ
13. Remove Miscellaneous Items From Wing Front RH	
14. Focus Front Foglamps	



Item 11

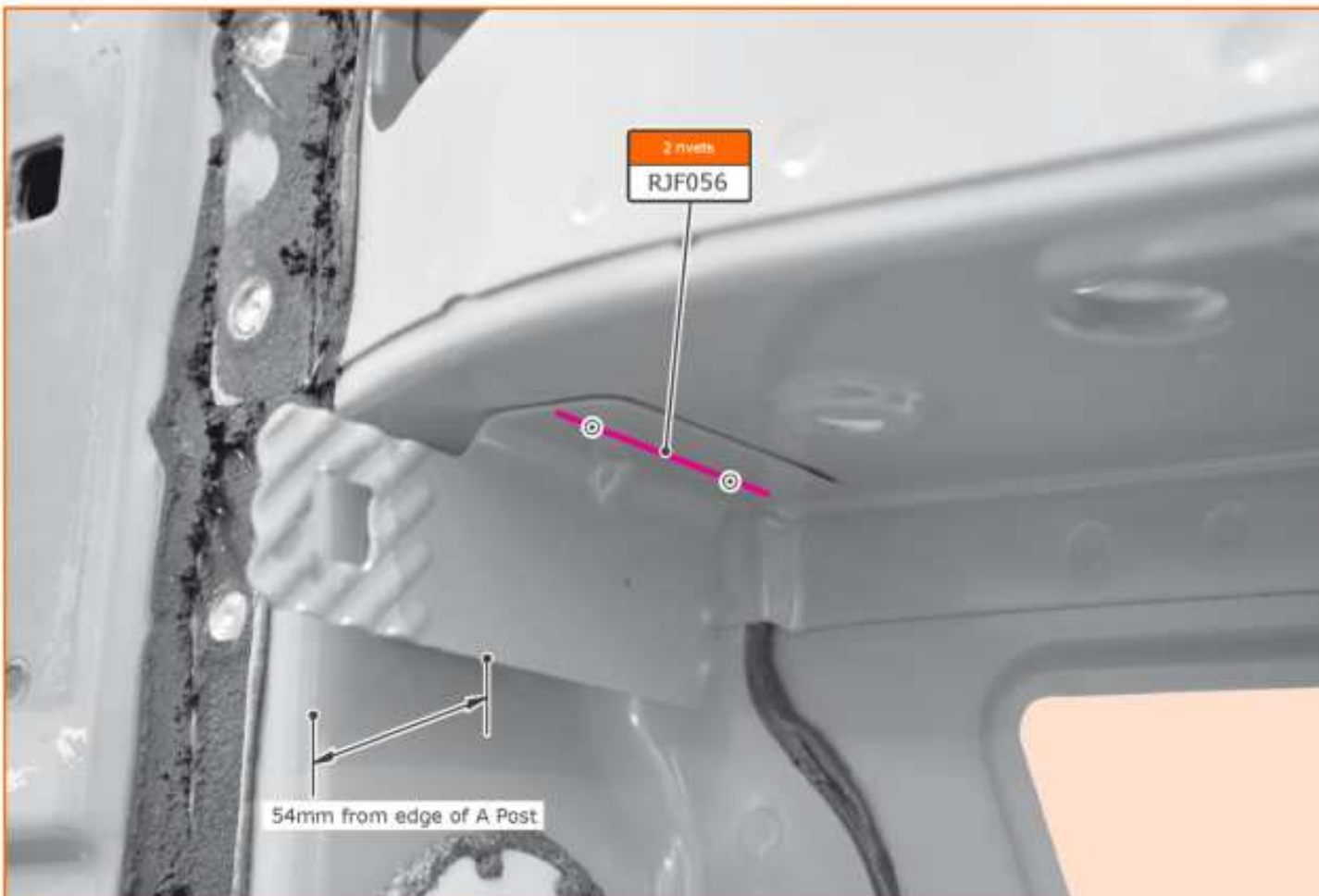
Badge Location




Item 12

Moulding Location





Service Condition Information			
Wing Front Mounting Bracket Upper Rear RH		Combination Panel	
Serviced as a separate panel			
			
TTS Reference			
RWF008			
Replacement Information			
Corrosion Protection	cavity wax		
Material	HSS	Yield Strength (Mpa)	<550
Panel Fixing	riveted		
Fitted With			
Not Applicable			

Headlamp Assembly



Additional Information

- Heater/Blower Intake Duct - Removed to allow disconnection of the battery
- Disconnect Battery - Negative terminal only
- Headlamp Strip RH & Transfer To New - Refers to the changeover of bulbs and gas discharge unit



Headlamp Assembly Overview

Strip Route	
Headlamp Assembly RH	
Mechanical, Electrical, Trim (MET)	
1. Load-Unload Vehicle to Ramp	
2. Remove Heater/Blower Intake Duct	① ⓧ
3. Disconnect Battery	①
4. Remove Air Filter Duct	
5. Remove Grille Front Fixings	ⓧ
6. Remove Wing Front Liner LH	
7. Remove Wing Front Liner RH	
8. Remove Bumper Fixing Front	ⓧ
9. Remove Headlamp RH	ⓧ
10. Headlamp Strip RH & Transfer To New	①
11. Focus Front Foglamps	
12. Focus Headlamps	



• Headlining R&R



Additional Information

- Seat Belt Rear Lower Fixing LH/RH - Includes pretensioner
- B Post Upper Trim LH - Clips may break

Torque Settings

- Seat Belt Rear Lower Fixing LH/RH - **35Nm**
- Seat Belt Front Lower Fixing LH - **35Nm**



Headlining Overview



Item 15

Headlining Rear Finsher location

Strip Route	
Headlining R&R	
Mechanical, Electrical, Trim (MET)	
1. Remove A Post Upper Trim RH	⊗
2. Remove A Post Upper Trim LH	⊗
3. Remove Mirror Rear View	
4. Remove Sun Visor Support	
5. Remove Seat Cushion Rear	
6. Remove Seat Back Rest Rear	⊗
7. Remove Seat Belt Rear Lower Fixing LH	ⓘ ⊗
8. Remove Seat Belt Rear Lower Fixing RH	ⓘ ⊗
9. Remove Sill Panel Inner Trim Rear LH	
10. Remove Sill Panel Inner Trim Rear RH	
11. Remove Door Rear Aperture Weatherseal LH	
12. Remove Door Rear Aperture Weatherseal RH	
13. Remove C Post Upper Trim LH	
14. Remove C Post Upper Trim RH	
15. Remove Headlining Rear Finisher	
16. Remove Sill Panel Inner Trim Front LH	
17. Remove Sill Panel Inner Trim Front RH	
18. Remove Door Front Aperture Weatherseal LH	
19. Remove Door Front Aperture Weatherseal RH	
20. Remove Seat Belt Front Lower Fixing LH	
21. Remove Seat Belt Front Lower Fixing RH	
22. Remove B Post Upper Trim LH	ⓘ

table continued on next page



• Headlining R&R - Cont.



① **Additional Information**

- B Post Upper Trim RH - Clips may break

Strip Route - Cont.

Headlining R&R

Mechanical, Electrical, Trim (MET)

23. Remove B Post Upper Trim RH ①

24. Remove B Post Lower Trim LH

25. Remove B Post Lower Trim RH

26. Remove Dog Leg Trim Panel LH

27. Remove Dog Leg Trim Panel RH

28. Remove Grab Handle Roof Front LH

29. Remove Grab Handle Roof Front RH

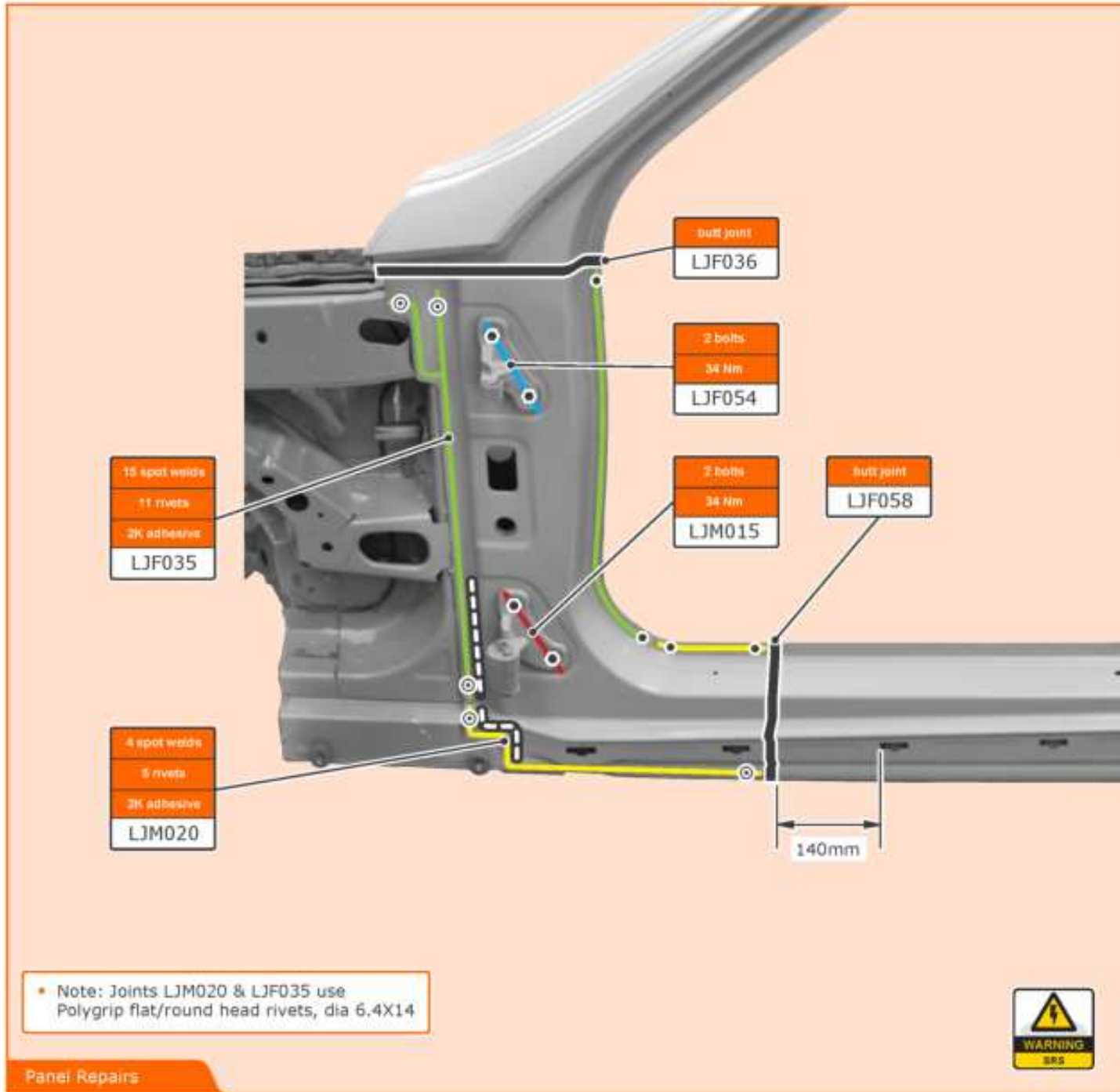
30. Remove Grab Handle Roof Rear LH

31. Remove Grab Handle Roof Rear RH

32. Remove Sun Visor LH

33. Remove Sun Visor RH

34. Remove Headlining



Service Condition Information			
A Post Lower LH		Combination Panel	
Cut from full bodyside front section			
TTS Reference			
LAP010			
Replacement Information			
Corrosion Protection		cavity wax	
Material	mild steel	Yield Strength (Mpa)	n/a
Panel Fixing	welded	bonded	riveted
Fitted With			
Not Applicable			

• Note: Joints LJM020 & LJF035 use Polygrip flat/round head rivets, dia 6.4X14



▪ A Post Outer Lower LH



① Additional Information

- A/C Evac/Charge:-
 - Refrigerant capacity - **590Grms**
 - Oil Grade - **Pag 46**
- Moulding Bodyside LH - Chrome moulding that runs front to rear

Ⓣ Torque Settings

- Steering Column Lower Joint - **24Nm**
- Steering Column - **26Nm**
- Facia Panel Support Carrier:-
 - Centre Support Strut - **50Nm**
 - Steering Column Support Bracket - **25Nm**
 - Support to A Pillar - **25Nm**
- Wheel Road Front LH - **130Nm**

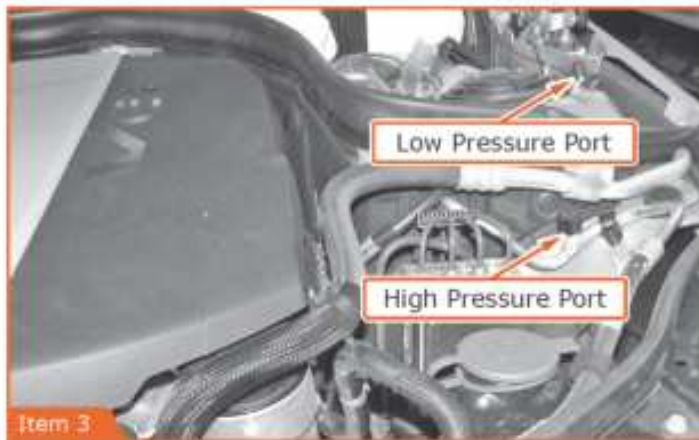
Strip Route	
A Post Outer Lower LH	
Mechanical, Electrical, Trim (MET)	
1. Disconnect Airbag ECU	Ⓣ
2. Drain- Refill Cooling System	
3. Carry out A/C Evac/Charge	①
4. Remove Floor Pan Splash Shield LH	
5. Remove Extension Sill Painted LH Fixings	
6. Remove Moulding Bodyside LH	①
7. Remove Pedal Throttle	①
8. Remove A Post Lower Trim RH	
9. Remove A Post Lower Trim LH	
10. Remove Pedestrian Protection Bonnet Actuator LH	Ⓣ
11. Disconnect / Lay Aside Steering Column Lower Joint	Ⓣ
12. Remove Steering Column	Ⓣ
13. Remove Carpet Section Front LH	
14. Remove Carpet Section Front RH	
15. Remove Facia-Panel Support Carrier	Ⓣ
16. Lay Aside Insulation Inner Bulkhead LH	
17. Remove Sill Tread Plate Finisher Front LH	
18. Remove Wheel Road Front LH	Ⓣ

table continued on next page



Item 1

Airbag ECU location



Item 3

Air Conditioning Port Location

• A Post Lower LH - Cont.



① Additional Information

- Scuttle Panel Grille - Includes disconnection of washer pipe

⚠ Torque Settings

- Wiper Front Motor & Mechanism Assembly:-
 - Black Brace - **35Nm**
 - Wiper mechanism Bolts - **22Nm**

Strip Route - Cont.

A Post Outer Lower LH

Mechanical, Electrical, Trim (MET)

19. Remove Scuttle Panel Grille **①**

20. Remove Wiper Front Motor & Mechanism Assembly **⚠**

21. Remove Heater Hose

22. Lay Aside Wiring Harness Sill Section Front LH

table continued on next page

• A Post Lower LH - Cont.



Additional Information

- Insulation Floor Panel Front - Refers to an insulation plate and metal spacer which carries an ecu where the front passenger feet rest

Strip Route - Cont.

A Post Outer Lower LH

Mechanical, Electrical, Trim (MET)

23. Remove Insulation Floor Panel Front ⓘ
24. Remove Insulation Outer Bulkhead
25. Remove A/C Pipe Front Bulkhead
26. Remove Heater Casing
27. Remove / Lay Aside Wiring Harness Chassis Leg Front LH Sect
28. Lay Aside Wiring Harness Front Inner Wing LH
29. Disconnect / Lay Aside Wiring Harness Front A Post LH
30. Remove / Lay Aside Wiring Harness Front A Post Upper LH
31. Lay Aside Wiring Harness Front A Post Inner LH
32. Lay Aside Insulation Floor Panel LH

butt joint
LJF038

15mm

11 spot welds
2 rivets
2K adhesive
LJF037

16 spot welds
LJF040

3 plug welds
13 rivets
2K adhesive
LJF041

Note: Joints LJF037 & LJF041 use Polygrip flat/round head rivets, dia 6.4X14

CAUTION
HSS

Service Condition Information

A Post Reinforcement LH	Combination Panel
-------------------------	-------------------

Cut and unpicked from bodyside front reinforcement

TTS Reference
LAP002

Replacement Information

Corrosion Protection	cavity wax		
Material	HSS	Yield Strength (Mpa)	<550
Panel Fixing	welded	bonded	riveted

Fitted With

wing front inner side reinforcement, headlamp panel, bonnet hinge, wing front inner side reinforcement lower, wing front inner side reinforcement extension

▪ A Post Reinforcement LH

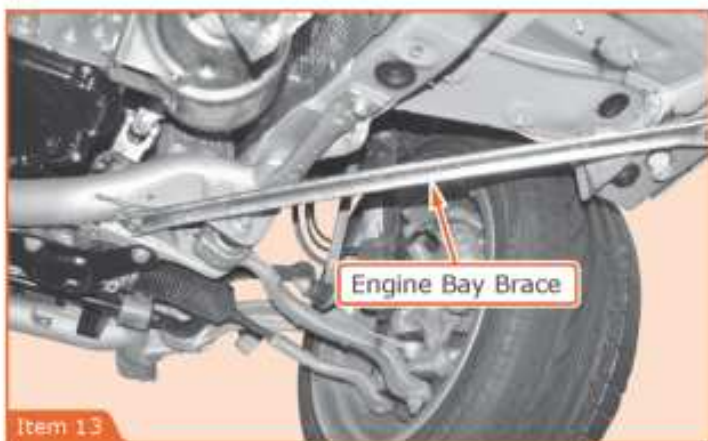


Additional Information

- Alarm Horn - Located under LH front wing
- Engine Bay Brace LH - Refers to the engine stabiliser bar which locates from the rear of the subframe to the sill panel reinforcement

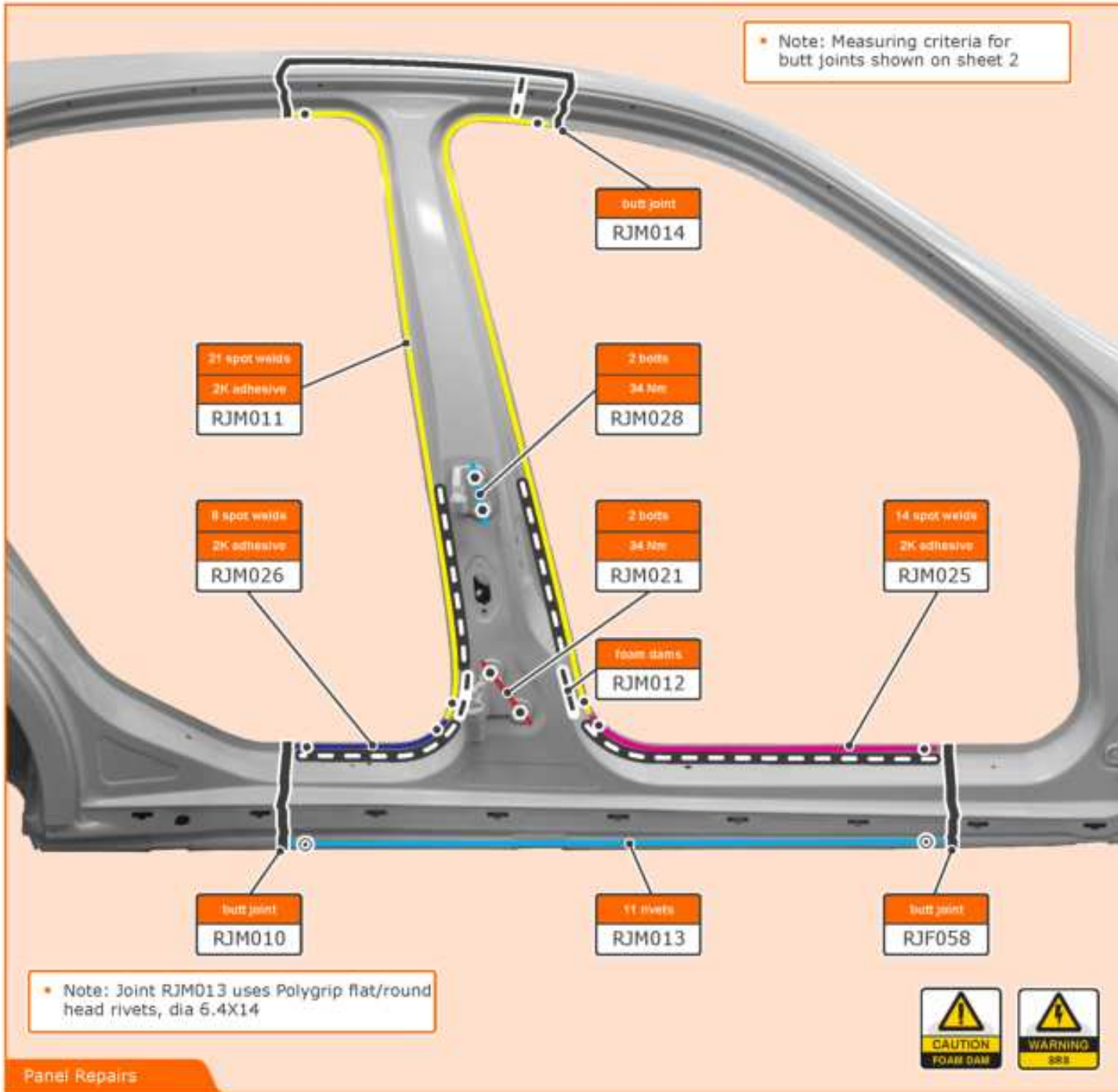
Torque Settings

- Battery:-
 - Retaining Nut - **21Nm**
- Wiper Front Arm & Blade LH/RH - **22Nm**
- Engine Bay Brace LH - **60Nm**

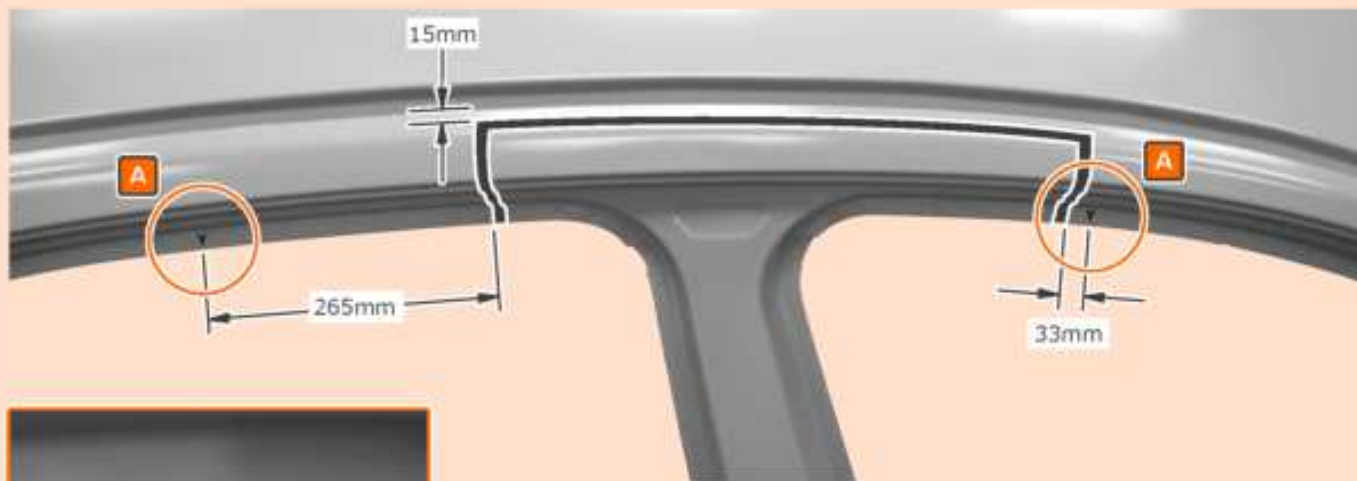


Engine Bay Brace location

Strip Route	
A Post Reinforcement LH	
Mechanical, Electrical, Trim (MET)	
1. Remove Battery	ⓘ
2. Remove Wiper Front Arm & Blade LH	ⓘ
3. Remove Wiper Front Arm & Blade RH	ⓘ
4. Remove Plenum Chamber Drain Tube Front LH	
5. Remove Engine Splash Shield	
6. Remove Alarm Horn	ⓘ ⓘ
7. Remove Headlamp LH	ⓘ
8. Disconnect / Lay Aside Wiring Harness Headlamp Panel LH	
9. Remove Washer Bottle Screen Front	
10. Remove Bonnet Catch LH	
11. Remove Bonnet Support Strut RH	
12. Remove Bonnet Support Strut LH	
13. Remove Engine Bay Brace LH	ⓘ ⓘ
14. Remove Misc Items From Wing Inner Frt Side Reinf LH	
15. Focus Headlamps	



Service Condition Information			
B Post & Sill RH		Combination Panel	
Cut from full bodyside front section			
TTS Reference			
RSB000			
Replacement Information			
Corrosion Protection		cavity wax	
Material	mild steel	Yield Strength (Mpa)	n/a
Panel Fixing	welded	bonded	riveted
Fitted With			
Not Applicable			



Front →



Service Condition Information			
B Post & Sill RH		Combination Panel	
Cut from full bodyside front section			
TTS Reference			
RSB000			
Replacement Information			
Corrosion Protection	cavity wax		
Material	mild steel	Yield Strength (Mpa)	n/a
Panel Fixing	welded	bonded	riveted
Fitted With			
Not Applicable			

• B Post & Sill RH



Additional Information

- Refer to **Vehicle Safety Features** for SRS information
- Requires correct SRS storage in line with health and safety regulations
- Heater/Blower Intake Duct - Removed to allow disconnection of the battery
- Disconnect Battery - Negative terminal only
- Moulding Bodyside RH - Chrome moulding that runs front to rear
- Wiring Harness Rear Dogleg RH - Includes ABS plug
- Seat Belt Front Upper Fixing RH - Includes guide

Torque Settings

- Seat Front RH - **50Nm**
- Seat Belt Front Upper Fixing RH:-
 - Seat Belt Upper Fixing - **32Nm**
 - Guide fixing - **32Nm**
- Seat Belt Front Reel RH - **32Nm**
- Airbag Side Sensor RH - **8Nm**



Airbag ECU

Item 8

Airbag ECU location

Strip Route	
B Post & Sill RH	
Mechanical, Electrical, Trim (MET)	
1. Load-Unload Vehicle to Ramp	
2. Remove Heater/Blower Intake Duct	①
3. Disconnect Battery	①
4. Remove Seat Front RH	⚠
5. Remove Heater Control Assembly	
6. Remove Ashtray/Cigar Lighter Assembly	
7. Remove Centre Console Fixings	⚠
8. Disconnect Airbag ECU	⚠
9. Remove Floor Pan Splash Shield RH	
10. Remove Moulding Bodyside RH	①
11. Remove Extension Sill Painted RH Fixings	
12. Remove Insulation Rear Seat	
13. Lay Aside Carpet Section Rear RH	
14. Lay Aside Wiring Harness Rear Dogleg RH	①
15. Remove Sill Tread Plate Finisher Rear RH	
16. Remove Sill Tread Plate Finisher Front RH	
17. Remove A Post Lower Trim RH	
18. Remove Carpet Section Front RH	
19. Lay Aside Wiring Harness Sill Section Front RH	
20. Remove Seat Belt Front Upper Fixing RH	① ⚠
21. Remove Seat Belt Front Reel RH	⚠
22. Remove Airbag Side Sensor RH	⚠

table continued on next page



• B Post & Sill RH



Strip Route - Cont.

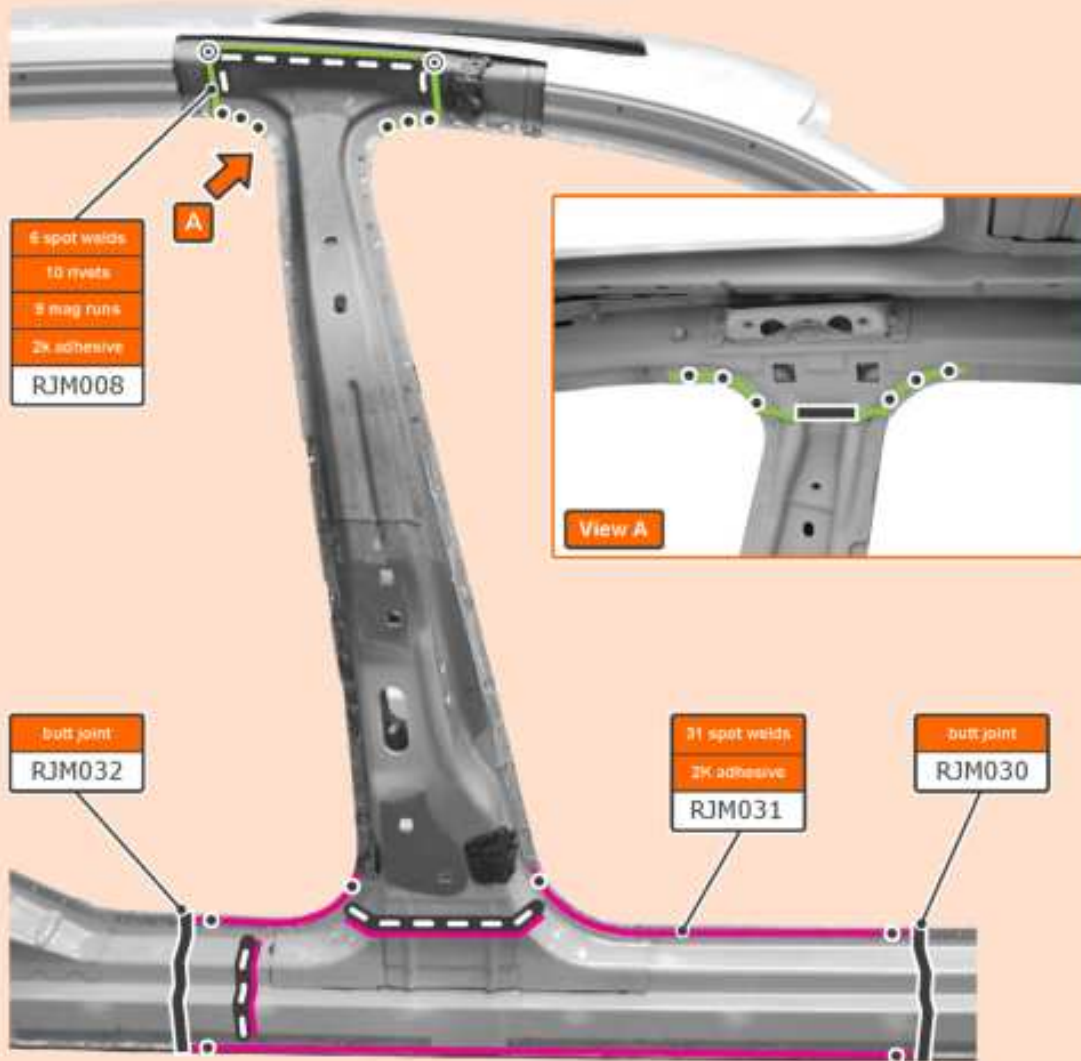
B Post & Sill RH

Mechanical, Electrical, Trim (MET)

23. Lay Aside Wiring Harness B Post RH

24. Remove Miscellaneous Items From Sill Panel RH

25. Remove Miscellaneous Items From Dog Leg Panel RH



• Note: Joint RJM008 uses Polygrip flat/round head rivets, dia 6.4X14



Service Condition Information			
B Post Reinforcement RH		Combination Panel	
Cut from bodyside front reinforcement			
TTS Reference			
RBP002			
Replacement Information			
Corrosion Protection		cavity wax	
Material	HSS	Yield Strength (Mpa)	<1500
Panel Fixing	welded	bonded	riveted
Fitted With			
Not Applicable			



▪ Note: Use loctite thread locking agent.



Service Condition Information			
Door Front	Single Panel		
Serviced as a separate bolt on panel, less hinges - sealed			
TTS Reference			
RFD000			
Replacement Information			
Corrosion Protection	cavity wax		
Material	HSS	Yield Strength (Mpa)	<550
Panel Fixing	bolted		
Fitted With			
Not Applicable			

• Door Front

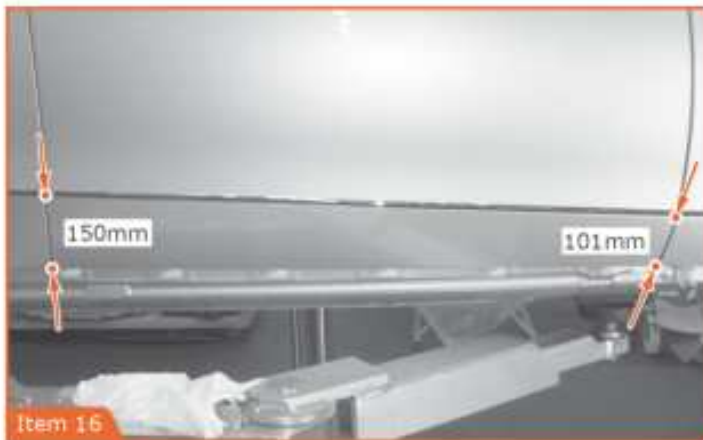


① Additional Information

- Refer to **Vehicle Safety Features** for SRS information
- Door Trim Board Front RH:-
 - Partially remove then disconnect bowden cable
 - Includes a lower cover trim
- Door Glass Front RH - Remove from outside at 45°
- Heater/Blower Intake Duct - Removed to allow disconnection of the battery
- Disconnect Battery - Negative terminal only
- Door Handle Outer Release Front RH - Includes lock barrel assembly
- Disconnect Door RHF - Includes wiring connector
- Door Front Component Carrier RH:-
 - Impact sensor on carrier
 - Carrier is riveted
- Door Glass Run Felt Front RH - Use caution when removing, may bend easily
- Door Front Weatherseal RH:-
 - Fixing is double sided tape
 - Renew seal every time
- Moulding Door Front RH - Re-use with care

⑦ Torque Settings

- Door Front Component Carrier RH:-
 - Door catch bolts - **7Nm**



Moulding Location

Strip Route	
Door Front RH	
Mechanical, Electrical, Trim (MET)	
1. Remove Speaker Grille Door Tweeter Front RH	
2. Remove Door Window Frame Trim Front RH	
3. Remove Door Trim Board Front RH	①
4. Remove Door Glass Weatherseal Inner Front RH	
5. Remove Door Glass Front RH	① ☠
6. Remove Heater/Blower Intake Duct	①
7. Disconnect Battery	① ☠
8. Remove Door Mirror RH	☠
9. Remove Door Handle Outer Release Front RH	① ☠
10. Disconnect Door RHF	①
11. Remove Door Front Component Carrier RH	① ⚠
12. Remove Door Glass Weatherseal Outer Front RH	
13. Remove Moulding Door Frame Outer Front RH	
14. Remove Door Glass Run Felt Front RH	①
15. Remove Door Front Weatherseal RH	①
16. Remove Moulding Door Front RH	①
17. Remove Door Front Lower Seal RH	
18. Remove Miscellaneous Items From Door Front RH	



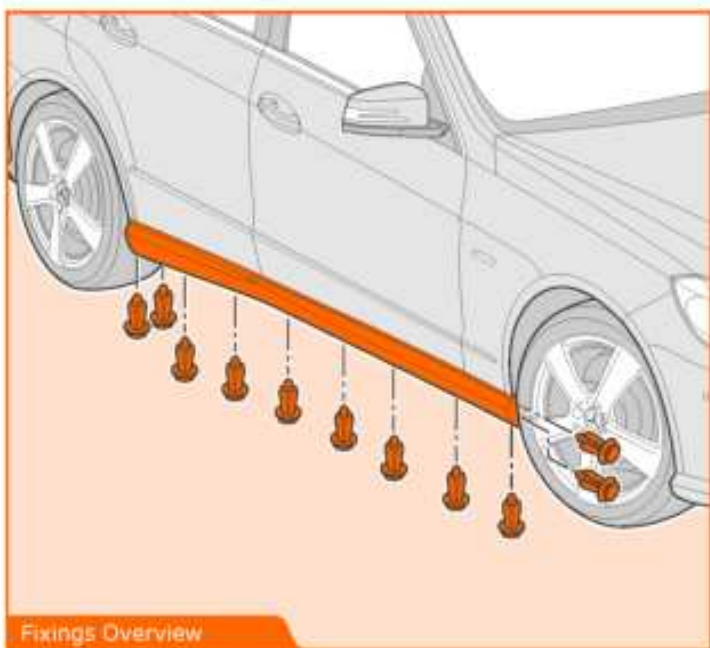
• Spoiler Sill Extension RH Painted



① **Additional Information**

- Floor Pan Splash Shield RH - Refers to fibrous covers that run the length of the sill

Strip Route
Spoiler Sill Extension RH Painted
Mechanical, Electrical, Trim (MET)
1. Load-Unload Vehicle to Ramp
2. Remove Floor Pan Splash Shield RH ①
3. Remove Extension Sill Painted RH Fixings



Fixings Overview

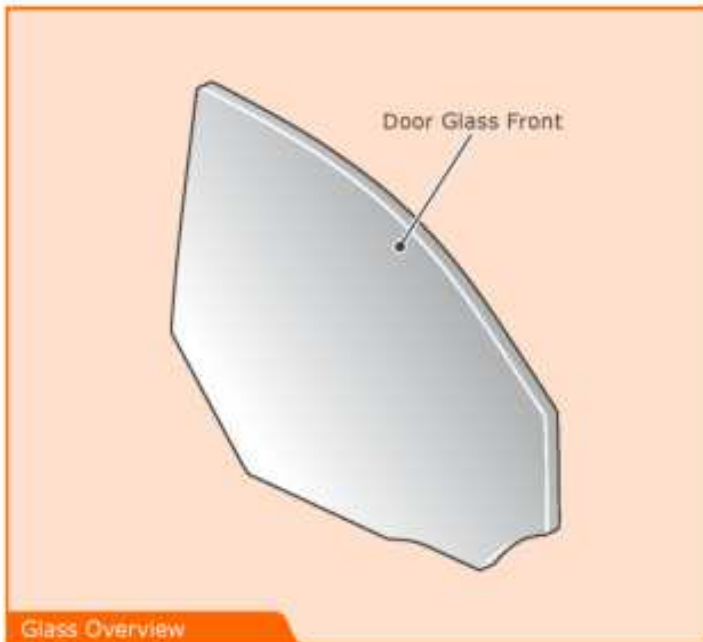
• Door Glass Front



① Additional Information

- Door Trim Board Front RH: -
 - Partially remove then disconnect bowden cable
 - Includes a lower cover trim
- Door Glass Front RH - Remove from outside at 45°

Strip Route	
Door Glass Front RH (lts)	
Mechanical, Electrical, Trim (MET)	
1. Remove Speaker Grille Door Tweeter Front RH	
2. Remove Door Window Frame Trim Front RH	
3. Remove Door Trim Board Front RH ①	
4. Remove Door Glass Weatherseal Inner Front RH	
5. Remove Door Glass Front RH	① ⚠



Glass Overview



• Door Glass Front - Trimboard



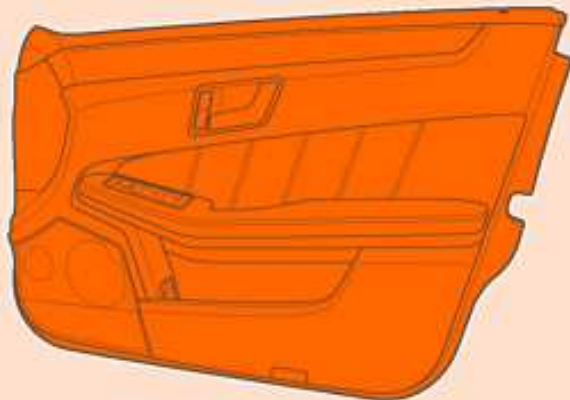
Stage 1

Remove lower cover trim



Stage 2

Remove door window frame trim front to access retaining clip for trimboard



Trimboard Overview



Stage 3

Trimboard fixing locations



Stage 4

Trimboard fixing clip location