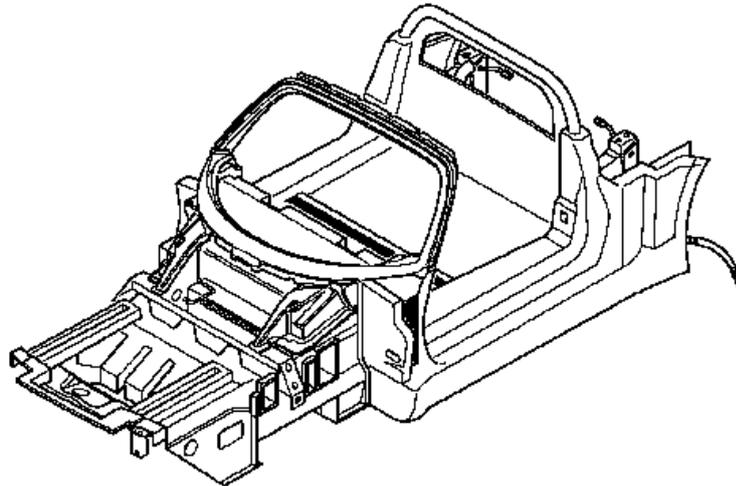


## Partial Body Assembly, Replace

The partial body assembly as supplied will consist of a partial body with the addition of various components necessary for the production sequence. The nomination of these extra components may change due to requirements of the production sequence. The instruction below should therefore be taken as a guide to the major components that must be transferred from the original vehicle to the new partial body



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**Important:** Observe relevant safety measures and national legislation.

The following major components will always be included in the partial body

1. Aluminium body tub
2. Roll over bar
3. Rear bulkhead
4. Side sills
5. Windscreen frame
6. Front crash structure
7. Main wiring harness
8. Pedal support box
9. Pipes and hoses concealed by side sills



### Disassemble

**Important:** A four-post hoist must be used to raise the vehicle when removing the engine undertray. The vehicle can be moved to a two-post hoist for other operations if required.

1. The following components should be removed from the original vehicle, inspected for damage where applicable and stored for installation to the new partial body in a logical sequence. Refer to individual component instructions for more information (additional technicians may be required)
  1. Battery (plus CDL backup battery if applicable)
  2. Hard top and Soft top
  3. Engine undertray
  4. Exhaust undertray

5. Front closure panel
6. Front clamshell assembly
7. Rear clamshell assembly
8. Exhaust system
9. Seats
10. Doors complete with door hinge
11. Interior trim and instrument panel
12. Steering column
13. Hand brake and gear shift components
14. Engine and transmission assembly
15. Rear suspension components
16. Rear subframe
17. Radiator
18. Heater assembly
19. Front suspension components
20. Steering rack
21. Coolant hoses and pipes
22. Fuel tank and hoses



## **Assemble**

2. The following list outlines only the major components that need to be installed to the new partial body. All required components should be transferred as necessary. Components should be installed to the new partial body assembly in a logical sequence. Refer to individual component instructions for more information
  1. Fuel tank and hoses
  2. Rear subframe
  3. Front suspension components
  4. Steering rack
  5. Steering column
  6. Rear suspension components
  7. Fuel lines and filter
  8. Engine and transmission assembly
  9. Radiator
  10. Heater assembly
  11. Coolant hoses and pipes
  12. Exhaust system
  13. Air cleaner
  14. Hand brake and gear shift components
  15. Rear suspension components
  16. Brake pipes
  17. Interior trim
  18. Door assemblies
  19. Front and rear clamshell assemblies
  20. Lamps
  21. Seats
  22. New windscreen complete with surround
  23. Battery (plus CDL backup battery if applicable)

**Adjust**

3. Front and rear suspension - see relevant operations

**Inspect**

4. Fill and bleed coolant system - see operation "Cooling System, Drain, Fill and Bleed" in group J
5. Bleed brake system - see operation "Brake System, Bleed" in group H
6. Bleed clutch - see operation "Hydraulic Clutch, Bleed" in group K
7. Add fuel and check for leaks
8. Program all volatile memories

**Adjust**

9. Where body components such as front or rear clamshell have been repaired due to accident damage, then minor adjustment or alignment of the new panels by elongating the mounting holes will be required. Align body parts to specification, see operation "Body Panel Alignment Values" in group A. Only the areas detailed in this section are adjustable. All further gaps align as a consequence of these adjustments as the body panels are formed from common moulds