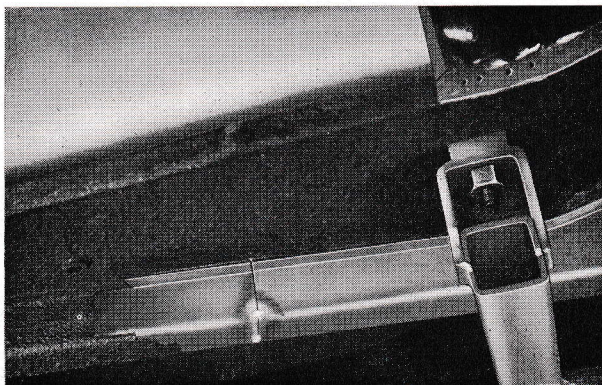


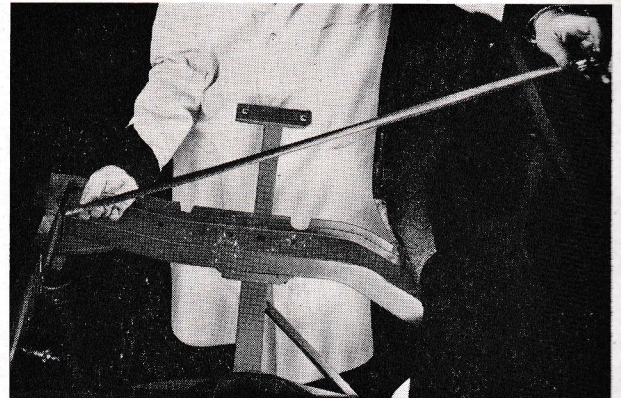
SP 2001
Fig. 104. Checking the lateral alignment of the engine mount side rail

rails and front crossmember can now be assembled on the assembly frame and bolted together. Check that the engine mount side rails are correctly located and that the dimensions from the front of the side rail to a given point on the body (Fig. 104) is the same on both sides. To achieve this, it may be necessary to adjust the assembly frame backwards or forwards in relation to the floor panel. Tack weld the cut edges of the side rails (Fig. 105) at each lower corner and adjust the assembly frame height until the dimension from the centre of the scuttle panel to the forward flange of each engine mount side rail (Fig. 106) is 35.26 in.

Before finally welding the engine mount side rails to the body, bolt the new wheelhouse panels in position on the assembly frame, assemble the other panels and secure with self-tapping screws or by tack welding. As a final check, install the bonnet and align its rear edge with the scuttle panel, then temporarily install the front wings to



SP 2002
Fig. 105. Underside of floor panel showing the cut edges of the engine mount side rail tack welded together



SP 2003
Fig. 106. Checking the front end height of an engine mount side rail

ensure that the general alignment is correct before carrying out the final welding operations. Make sure that all braces, brackets and other supporting members such as the engine mount side rails are properly welded, thus ensuring that the original stability of the body structure is maintained.

Some of these parts however, are secured by means of metal-to-metal adhesive. A typical example of this method of attachment is the body side panel reinforcements incorporated on later models, as shown in Fig. 107. This reinforcement is welded to the rear wheelhouse panel and secured to the body side panel by adhesive. When renewing the rear lower section of a body side panel and a reinforcement assembly, the following points should be observed:

1. Remove all paint and other foreign matter from the mating surfaces of the body side panel and reinforcement. *Paint removing solutions should not be used, otherwise the body sealing materials may be damaged.*
2. Apply a liberal coating of adhesive (air drying epoxy-resin type) to the grooved flanges of the reinforcement and to the surface of the panel to be bonded. Place the reinforcement in position so that its upper edge is parallel with the crease line of the panel, and the curved section of the reinforcement in close contact with the wheelhouse panel. Press the reinforcement firmly onto the panel.
3. Place suitable wedges between the wheelhouse panel and the reinforcement and weld the ends of the curved section of the reinforcement to the panel.
4. An even pressure should be maintained on the reinforcement with the aid of suitable wedges