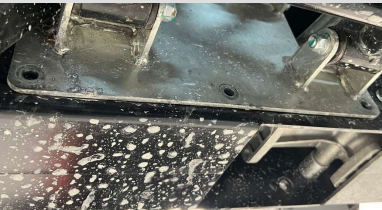


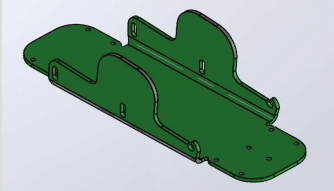
REPAIR SHEET - Control arm and beam reinforcement plate installation

REASON:

OPERATOR	WORKSHOP	DATE
REGISTRATION	TIME 12min	COST

REQUIRED TOOLS				SAFETY	
☐ Drill	☐ 6 mm drill bit	☐ Hydraulic jack	☐ Safety shoes		
☐ 13mm open-end wrench	☐ Rivet gun	☐	☐ Safety gloves		
☐	☐	☐	☐		
☐	☐	☐	☐		

	TOOLS	PROCESS	ASSEMBLY DRAWING	ESTIMATED TIME
1	Hydraulic jack	Vehicle lifting: 1- Using a hydraulic jack, raise the front of the vehicle.		1
	REMARKS			REAL TIME
2	13mm open-end wrench	Removal of the lower mounting bolts: 1- Using a 13 mm open-end wrench, loosen and remove the three lower bolts securing the front control arm. 2- Repeat the procedure on the control arm on the opposite side.	 	2
	REMARKS			REAL TIME

	TOOLS	PROCESS	ASSEMBLY DRAWING	ESTIMATED TIME
3	13mm open-end wrench	Installation of the reinforcement: Note: The new reinforcement is lower and attaches only to the three lower mounting holes of the control arm. 1- Position the reinforcement correctly and thread in the three new bolts M8×30 DIN 6921 (ref. FX1-8-30-6921). 2- Thread in the other three new bolts on the opposite side. Once the reinforcement is properly positioned and all mounting bolts are threaded, tighten the bolts using a 13 mm open-end wrench.	  	3
4	Drill, 6mm drill bit	Reinforcement installation: 1- Using a drill with a 6 mm bit, drill the 10 mounting holes for the reinforcement into the beam.		3
5	Rivet gun	Reinforcement installation: 1- Using a rivet gun, install M6×25 DIN 7337 (ref. FX4-00-11) rivets in the 10 mounting holes of the reinforcement.		2
6	Hydraulic jack	Lowering the vehicle: 1- Lower the vehicle from the hydraulic jack.		1