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Bumper system

I. Front bumper device

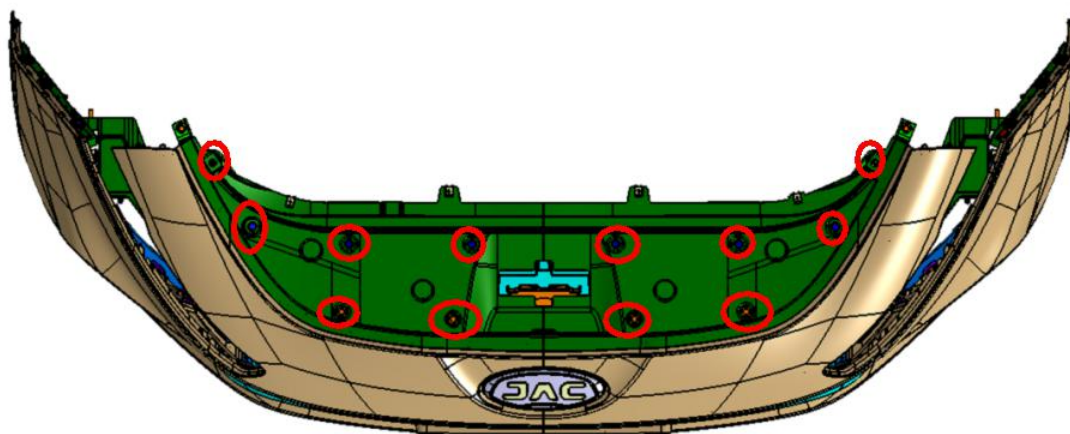
1. Front bumper device composition

No.	Name	Quantity	Remark
1	Front Bumper Assembly	1	
2	Front grille assembly	1	
3	Front Bumper Anti-Collision Beam Assembly	1	
4	Front bumper energy absorbing pad	1	
5	Clutch pedal bracket assembly	1	
6	Front bumper left fixing bracket	1	Bilateral symmetry
7	Front bumper right fixing bracket	1	
8	Front bumper's left-upper stabilizing holder	1	Bilateral symmetry
9	Front bumper right upper stabilizing holder	1	
10	Front bumper left decoration strip	1	Bilateral symmetry
11	Front bumper right decoration strip	1	
12	Thigh guard beam	1	
13	Tibia guard beam	1	
14	Label 210	1	
15	Front bumper energy absorbing pad clamp	2	
16	Hex flange bolt & flat washer assembly	8	
17	Hex flange bolt & flat washer assembly	15	
18	Grommet screw	6	
19	INSERT PLASTIC NUT	10	
20	Expansion clip	6	
21	M-type countersunk screw	16	
22	M-type countersunk screw	4	

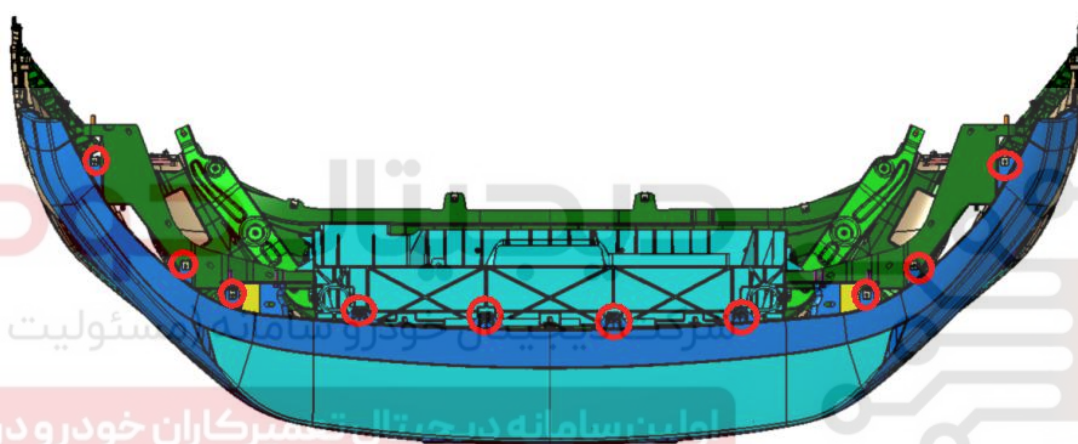
2. Dismantle the front bumper.

- 2.1 First remove the front wheelhouse and front wheel cover, open the engine hood;
- 2.2 Remove the 6 expansion buckles, 4 bolts and 2 screws connecting the front bumper upper trim panel and the front end module;

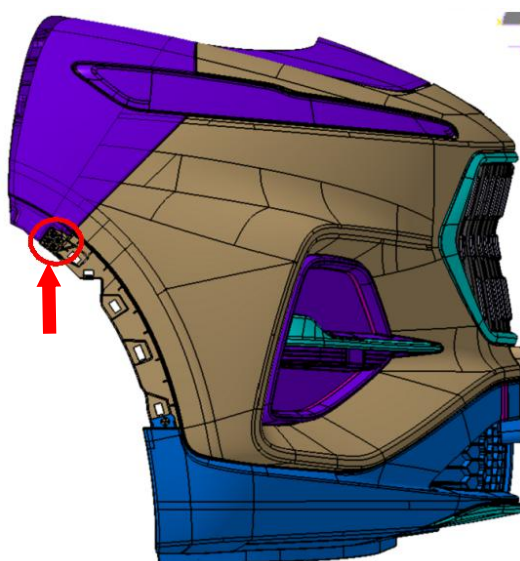
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2.3 Disassemble the 10 buckles connecting with the front bumper deflector.

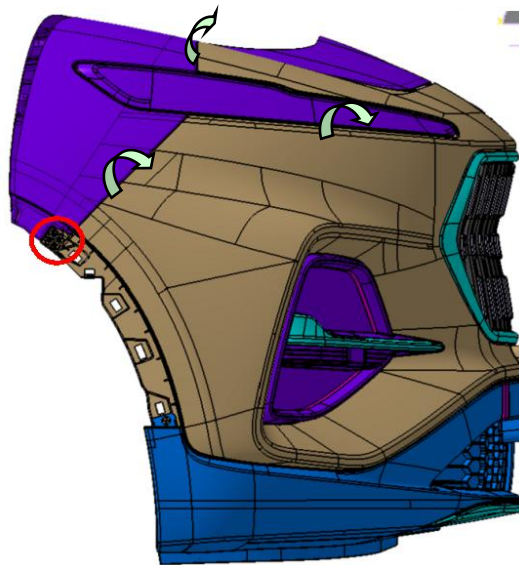


2.4 Remove the self-tapping screws (left and right symmetrical) at the joint between the front bumper and the fender;



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2.5 Gently pull out the front bumper to disengage the front bumper from the front bumper fixing bracket;

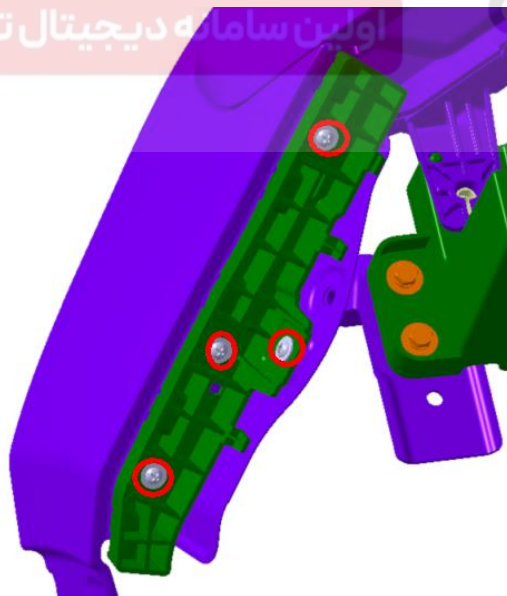


2.6 Disconnect the 360° panorama camera, radar wiring harness connector (models equipped with 360° panorama camera and radar);

2.7 Remove the front bumper.

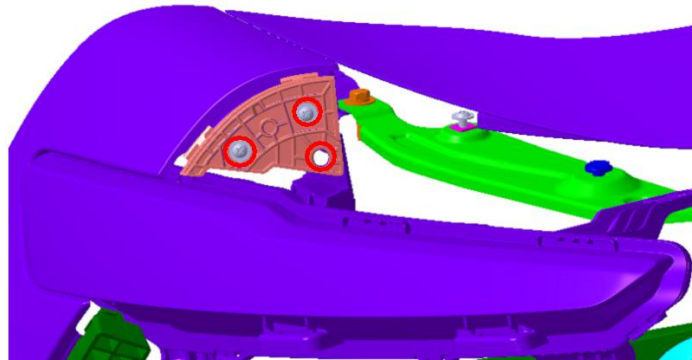
3. Remove the front bumper bracket

3.1 Remove the 4 self-tapping screws (left and right symmetry) of the front bumper fixing bracket and remove the left and right fixing brackets;



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3.2 Remove the 3 self-tapping screws (left and right symmetry) of the front bumper left upper/right upper fixing bracket, and remove the left upper and right upper fixing brackets;

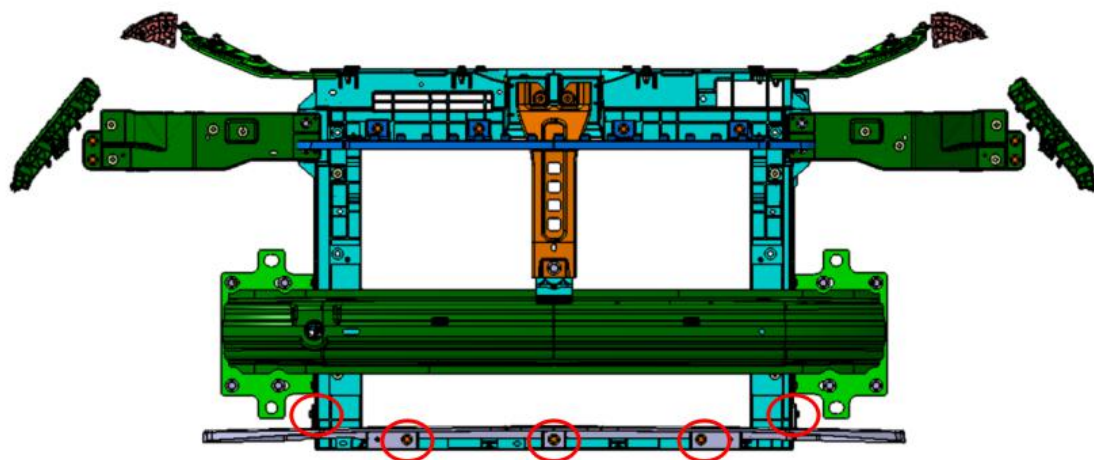


4.Remove the thigh and tibia guard beam

4.1 Disassemble the 4 bolts connecting the thigh guard beam and the front end frame, and remove the thigh guard beam assembly;



4.2 Disassemble the 5 bolts connecting the tibia guard beam and the front end frame, and remove the tibia guard beam assembly;

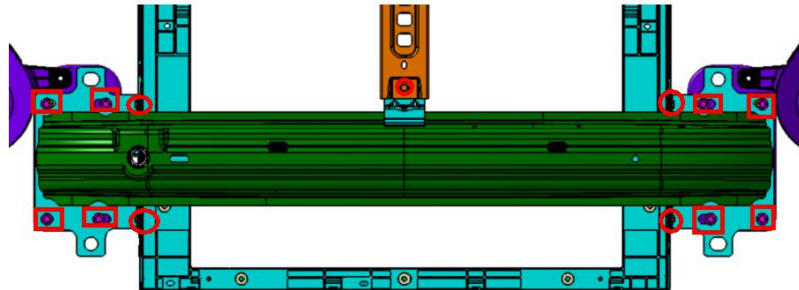


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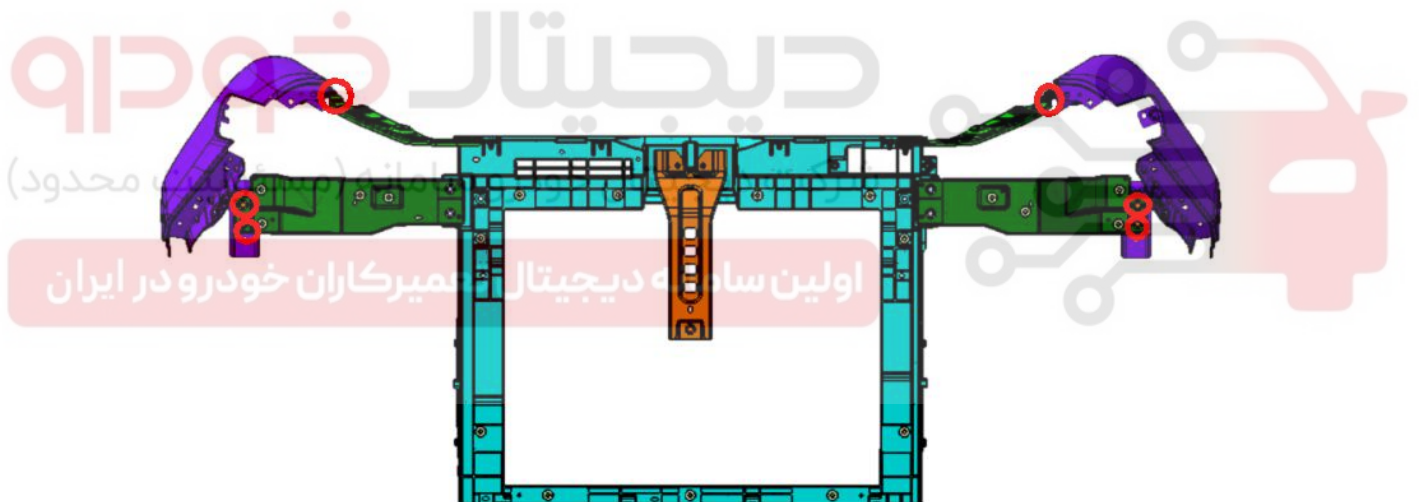
5. Remove the front end module assembly

5.1 Disassemble the headlights;

5.2 Remove the 5 bolts connecting the front impact beam and the front end frame and remove the 8 fixing bolts connected between the front end frame and the vehicle body, and remove the front impact beam. Assembly



5.3 After disassembling the wire harness connector and the heat sink and other related parts, remove the 8 fixing bolts connected between the upper end of the front end frame and the vehicle body, and remove the front end module;



Assembly sequence is opposite to the disassembly sequence.

Precautions:

1. The bumper is made of resin. Please don't touch with corrosive chemicals such as grease. If touch it incautiously, please clean it with water immediately;
2. In order to facilitate the assembly and disassembly of the bumper, the vehicle should be placed in the lift mechanism and ensure the lift is locked.
3. When assemble or disassemble the bumper, there should be two persons to operate to avoid falling and damage the bumper;
4. When assemble or disassemble the bumper, a soft protective film is required to protect the outer surface of the bumper so as not to scratch;

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5. The front anti-collision beam assembly and the vehicle body are fixed by 8 bolts, and the tightening torque is 20~25N.m;

6. When assembling the front bumper, attach it to the bumper fixing bracket.

II. Rear bumper device

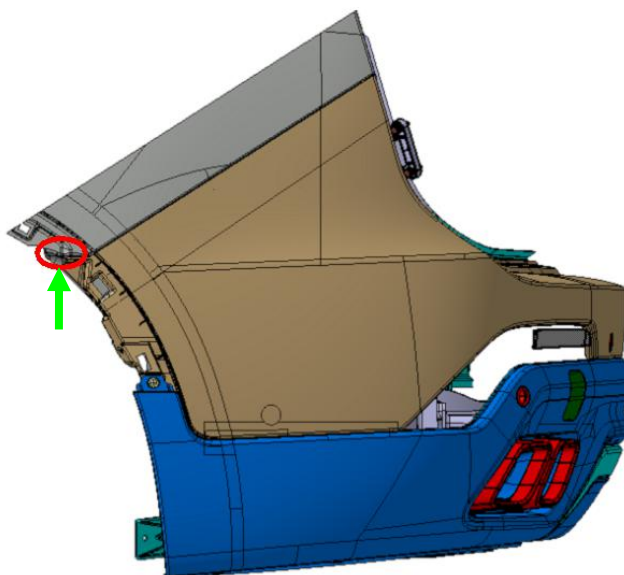
1. Rear bumper device composition

No.	Name	Quantity	Remark
1	Rear bumper trim assembly	1	
2	Rear bumper trim frame (I)	1	Bilateral symmetry
3	Rear bumper trim frame (II)	1	
4	Rear bumper trim frame (III)	1	Bilateral symmetry
5	Rear bumper trim frame (IV)	1	
6	Anti-collision beam of rear bumper	1	
7	Rear bumper left fixing bracket	1	Bilateral symmetry
8	Rear bumper right fixing bracket	1	
9	Left reinforcement plat of rear bumper	1	Bilateral symmetry
10	Right reinforcement plat of rear bumper	1	
11	Hex flange bolt & flat washer assembly	6	
12	Grommet screw	6	
13	Buckle	4	
14	Buckle assembly	8	
15	Expansion clip	7	
16	M-type countersunk screw	8	
17	M-type countersunk screw	6	
18	M-type countersunk screw	4	

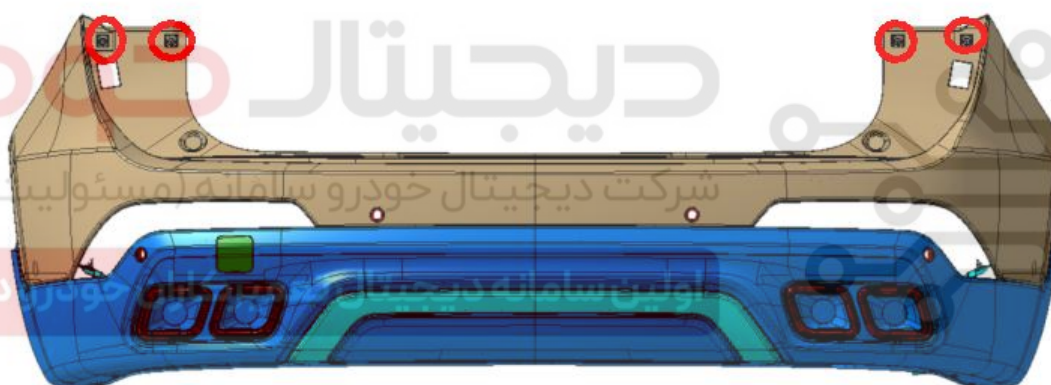
2. Disassemble rear bumper.

2.1 Open the rear door to the maximum position, remove the rear wheel cover and rear wheel eyebrows;

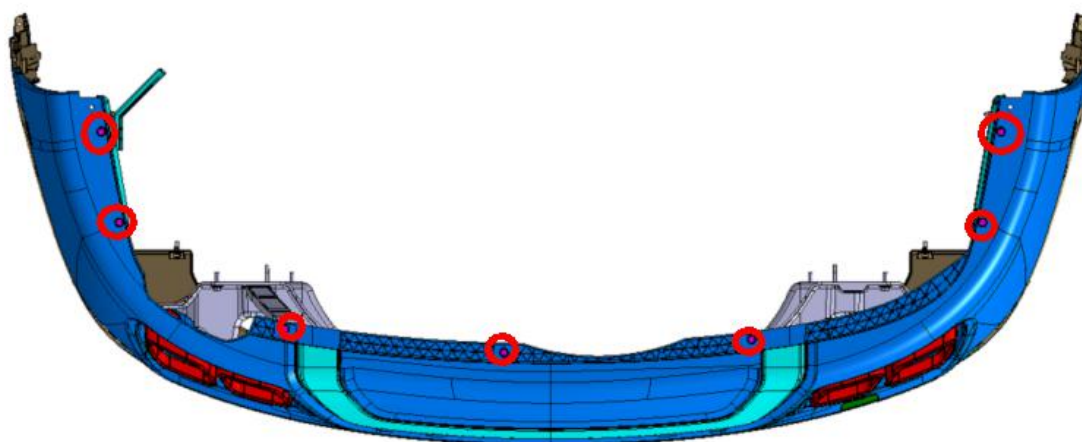
2.2 Remove the self-tapping screws connecting the bumper and the side wall (one on each side);



2.3 Open the 4 screw covers on the rear bumper and remove the 4 screws (one on each side) of the bumper and the body.

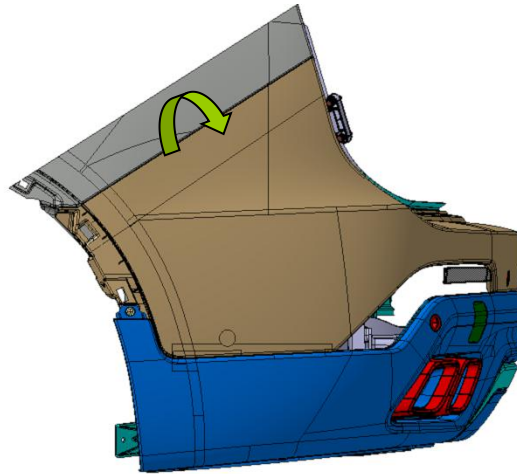


2.4 Remove the 7 expansion buckles in the lower part of the rear bumper;



2.5 Gently pull off the rear bumper to disengage it from the rear bumper fixing bracket;

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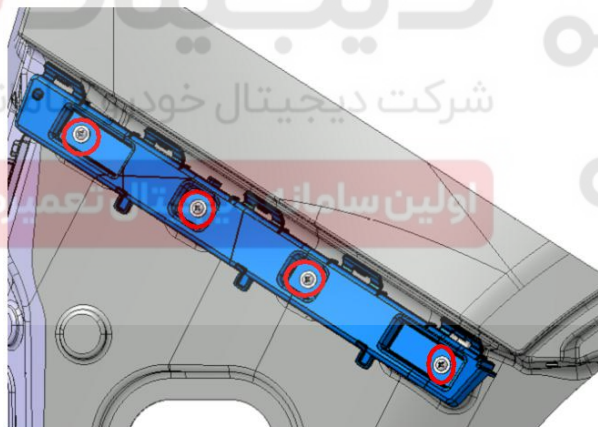


2.6 Disconnect the reversing radar and rear fog lamp connector (with reversing radar and rear fog lamp configuration);

2.7 Remove the rear bumper.

3. Remove the rear bumper left and right fixing bracket

3.1 Self-tapping screws for connecting the rear bumper fixing bracket to the vehicle body (4 on each side)

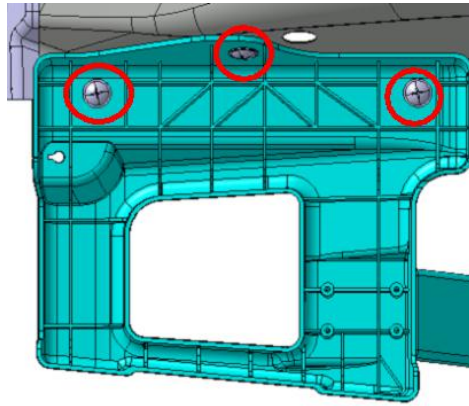


3.2 Remove the rear bumper fixing bracket.

4. Disassemble the right reinforcement plate assembly of rear bumper

4.1 Remove the self-tapping screws (3 screws on each side) connecting the reinforcement plate of rear bumper and the vehicle body

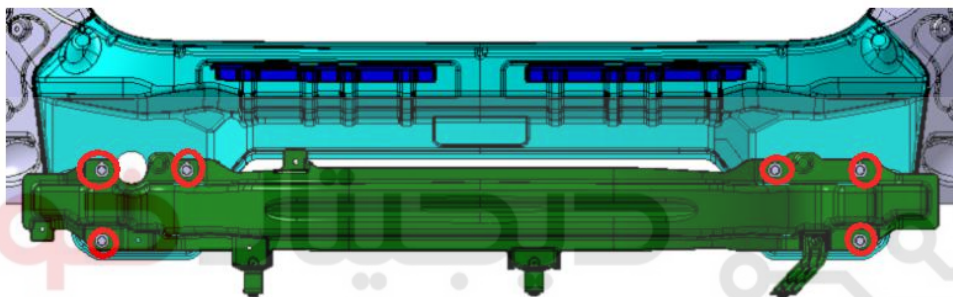
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4.2 Take down the left and right reinforcement of the rear bumper.

5. Disassemble the rear anti-collision beam assembly

5.1 Remove the 6 bolts between the rear anti-collision beam and the vehicle body, and remove the rear anti-collision beam assembly;



شرکت دیجیتال خودرو سامانه (مسئولیت محدود)

اولین سامانه دیجیتال تعمیرکاران خودرو در ایران

Assembly sequence is opposite to the disassembly sequence.

Precautions:

1. The bumper is made of resin. Please don't touch with corrosive chemicals such as grease. If touch it incautiously, please clean it with water immediately;
2. In order to facilitate the assembly and disassembly of the bumper, the vehicle should be placed in the lift and ensure the lift is locked.
3. When assemble or disassemble the bumper, there should be two persons to operate to avoid falling and damage the bumper;
4. When assemble or disassemble the bumper, a soft protective film is required to protect the outer surface of the bumper so as not to scratch;
5. The rear anti-collision beam assembly and the vehicle body are fixed by bolts, and the tightening torque is 20~25N.m;
6. When assembling the rear bumper, snap it into place with the bumper fixing bracket.

III. Car wall trim device

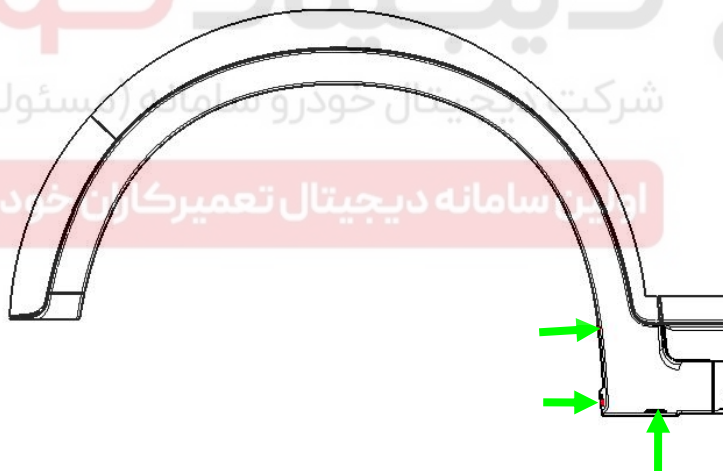
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1. Car wall trim device

No.	Name	Quantity	Remark
1	Left front wheel eyebrow assembly	1	Bilateral symmetry
2	Right front wheel brow	1	
3	Left rear wheel brow	1	Bilateral symmetry
4	Right rear wheel eyebrow assembly	1	
5	Left front door skirt assembly	1	Bilateral symmetry
6	Right front door skirt assembly	1	
7	Left rear door skirt assembly	1	Bilateral symmetry
8	Right rear door skirt assembly	1	
9	Left outer threshold cover plate assembly	1	Bilateral symmetry
10	Right outer threshold cover plate assembly	1	
11	Grommet screw	2	
12	cross recessed pan head self-tapping screw	2	

2. Remove left and right front and rear wheel eyebrow assemblies

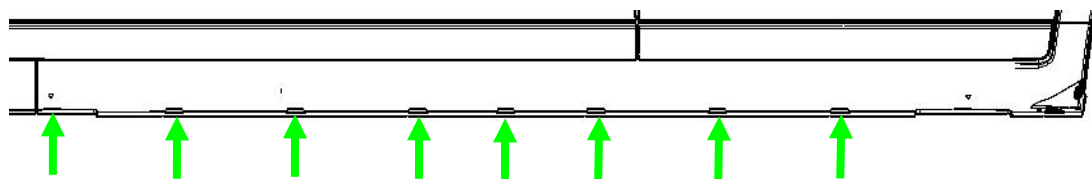
2.1 Disassemble the 3 expansion buckles fixed to the front wheel eyebrow and the body;



2.2 Disassemble the front and rear wheel eyebrows directly, so that the front wheel eyebrows are separated from the fixed buckle of the body, and the wheel eyebrows are removed.

3. Disassemble the left and right sill assembly

3.1 Remove the 8 self-tapping screws fixed to the door sill and the body;



3.2 Disassemble the left and right sills directly to disengage the sill from the buckle that secures

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the body and remove the sill.

4. Remove the left and right skirt assembly

4.1 Directly disassemble the left and right front and rear door skirts, making the skirt to separate from the fixed buckle of the door, and take down the skirt.

Assembly sequence is opposite to the disassembly sequence.

Precautions:

1. The door sill, skirt and wheel eyebrows are made of resin. Do not touch corrosive chemicals such as grease. If you accidentally touch it, please wash it off with water immediately.



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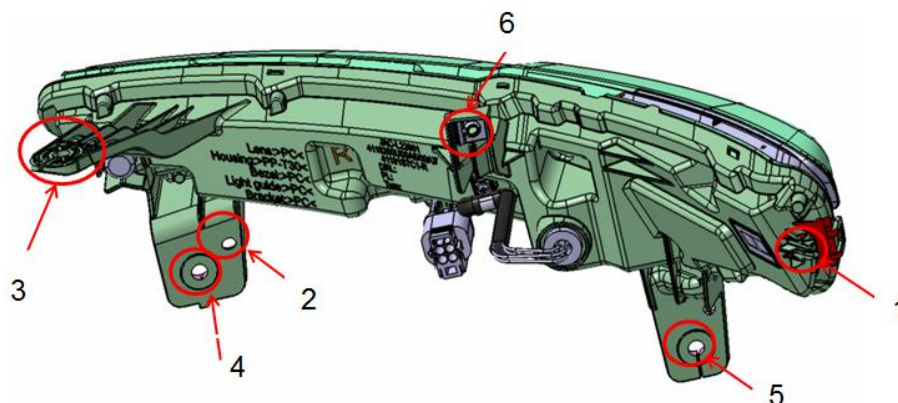
Lighting system

I. Cautions

- Before removing the electrical connector, you must remove the battery negative and wait at least 1 minute, otherwise the vehicle will be damaged.
- When removing and installing components, use a cloth to protect the parts to be removed from damage.
- When removing the metal clip from the trim, wrap the screwdriver blade with a cloth.
- Be careful not to damage the body components.
- When disassembling some components and one person can't finish the work, two people need to operate to avoid falling.
- Do not use excessive force when disassembling some accessories, as it may cause deformation of the parts.

II. Daytime driving combination lamp device

1. Components diagram



2. Daytime driving combination lamp device composition

No.	Name	Quantity	Remark
1	Left daytime driving combination lamp assembly	1	Bilateral symmetry
2	Right daytime driving combination lamp assembly	1	Bilateral symmetry
3	Hex flange bolt & flat washer assembly	6	
4	Cross flange-face large-round head self-tapping screw	2	

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3. Replacement of daytime driving combination lamp

1) Removal Step:

- ① disconnect the negative pole of the accumulator;
- ② Disassemble the front bumper, refer Replacement of the Front Bumper.
- ③ Remove the fixing bolts of installation point 3, installation point 4, installation point 5 and fixing screws of installation point 6 of the daytime driving combination lamp. The bolt tightening torque is 3N.m~5N.m, and the screw tightening torque is 1N.m~3N.m

④ Shake the daytime combination lamp, remove the locating hole at the locating point 2 from the locating pin of the headlamp on the arm of the front-end module, and pull the locating pin at the locating point 1 from the sheet metal installation hole;

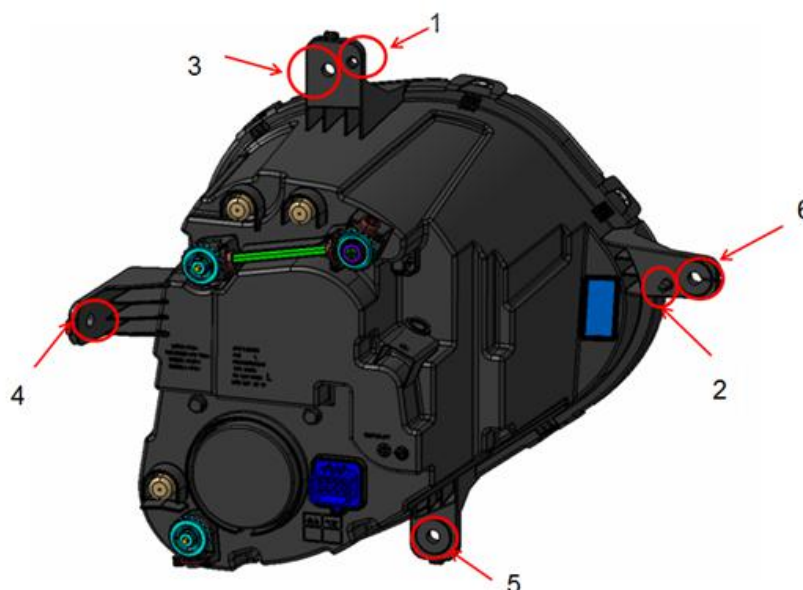
⑤ Carefully move the front combination lamp to remove the electrical connector;

2) Installation Step:

Assembly sequence is opposite to the disassembly sequence.

III. Front combination light device

1. Components diagram



2. Front combination lamp device composition

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No.	Name	Quantity	Remark
1	Left-front combination lamp assy	1	Bilateral symmetry
2	Right-front combination lamp assy	1	Bilateral symmetry
3	Hex flange bolt & flat washer assembly	8	

3, the front combination lamp replacement

1) Removal Step:

- ① disconnect the negative pole of the accumulator;
- ② Disassemble the front bumper, refer Replacement of the Front Bumper.
- ③ Remove the installation point 3, installation point 4, installation point 5 and installation point 6 of the front combination lamp. The tightening torque is 3N.m~5N.m

④ Shake the front combination lamp, remove the locating pin 2 from the front sill mounting plate locating hole, and pull out the locating hole 1 from the front end module locating pin;

⑤ Carefully move the front combination lamp to remove the electrical connector;

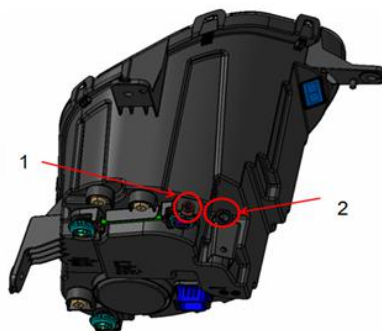
2) Installation Step:

Assembly sequence is opposite to the disassembly sequence.

4. Light adjusting of front combination lamp

Use special M6 hexagonal dimming tool (cross screwdriver is not recommended) to insert into left and right dimming port 1 or upper and lower dimming port 2 respectively. Adjust the dimming mechanism in the direction clockwise or anticlockwise to adjust the focusing position of high and low beam light. The dimming torque is 0.1N.m~0.6N.m.

Light regulating of the left and right front headlamp are the same.



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IV. Rear combination lamp device

1. Components diagram



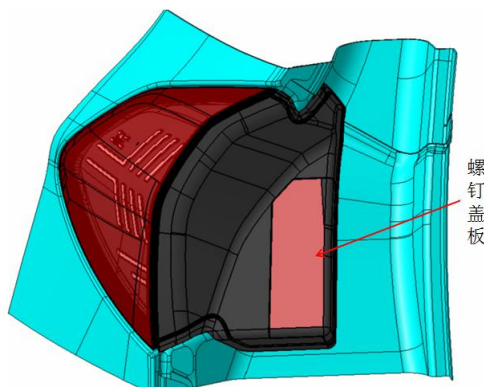
2. Rear combination lamp device composition

No.	Name	Quantity	Remark
1	Left side panel rear combination lamp assembly	1	
2	Right side panel rear combination lamp assembly	1	
3	Left tail door combination lamp assembly	1	
4	Right tail door combination lamp assembly	1	
5	Lower left rear combination lamp assembly	1	
6	Lower right rear combination lamp assembly	1	
7	Locating buckle	2	
8	Locating buckle	2	
9	Buckle	4	
10	M-type countersunk screw	14	
11	Round head cover nut	10	

3, side wall tail light replacement

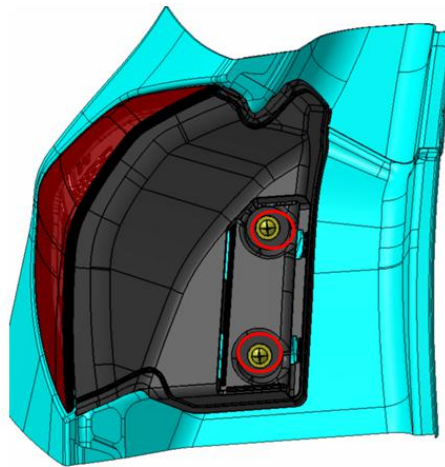
1) Removal Step:

- ① open the tail door.
- ② Use flat screwdriver to pry the screw plug cover;



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③ Use cross screwdriver to remove the fixing screw of side tail lamp, tightening torque is 1N.m~3N.m;



④ Shake the side tail lamp, pull backward to take down the side tail lamp.

2) Installation Step:

Assembly sequence is opposite to the disassembly sequence.

4. Replacement of tail lamp of tail door:

1) Removal Step:

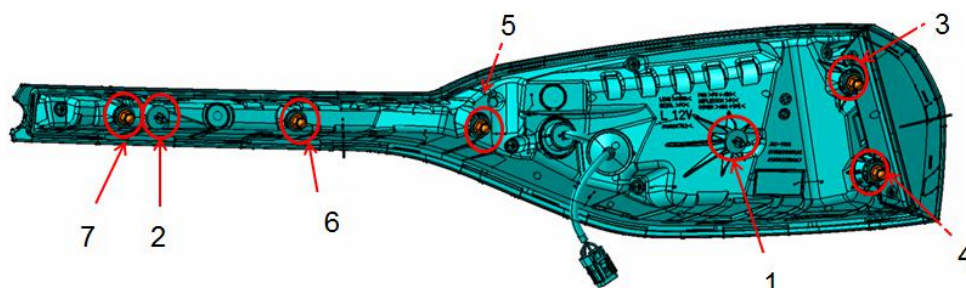
① disconnect the negative pole of the accumulator;

② Open the tail gate;

③ Remove the round head cover nut of the installation point 3, installation point 4, installation point 5, installation point 6 and installation point 7 of the tail lamp. The tightening torque is 7N.m~9N.m

④ Shake the tail lamp, to make the locating pin 1 and locating 2 separate from the tail door sheet metal locating hole;

⑤ Carefully move the tail lamp to remove the electrical connector;



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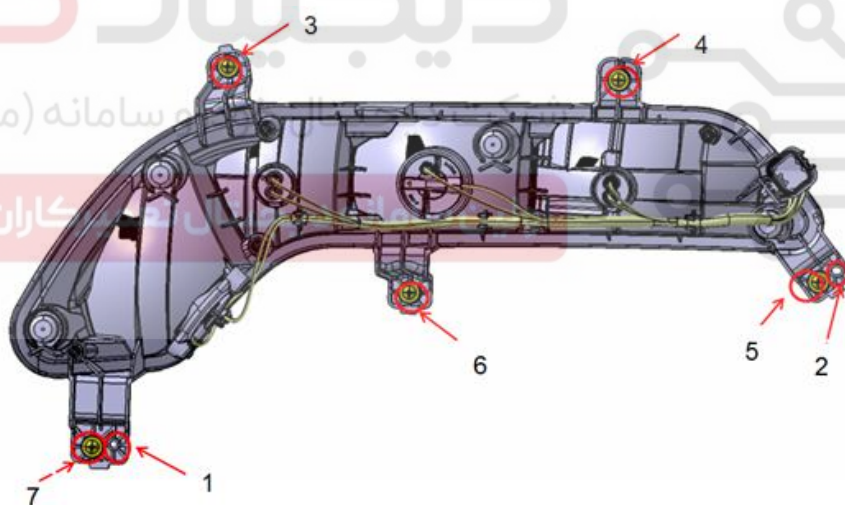
2) Installation Step:

Assembly sequence is opposite to the disassembly sequence.

5. Replacement of rear lower combination light

1) Removal Step:

- ① disconnect the negative pole of the accumulator;
- ② Remove the rear bumper. For the disassembly method, see “Rear Bumper Replacement”.
- ③ Use cross screwdriver to remove the screws of the installation point 3, installation point 4, installation point 5, installation point 6 and installation 7 of the front combination lamp. The tightening torque is 1N.m~3N.m
- ④ Shake the rear lower combination lamp, to make the tail lamp locating hole 1 and locating hole 2 separate from the bumper locating pin, and take down the rear lower combination lamp.



2) Installation Step:

Assembly sequence is opposite to the disassembly sequence.

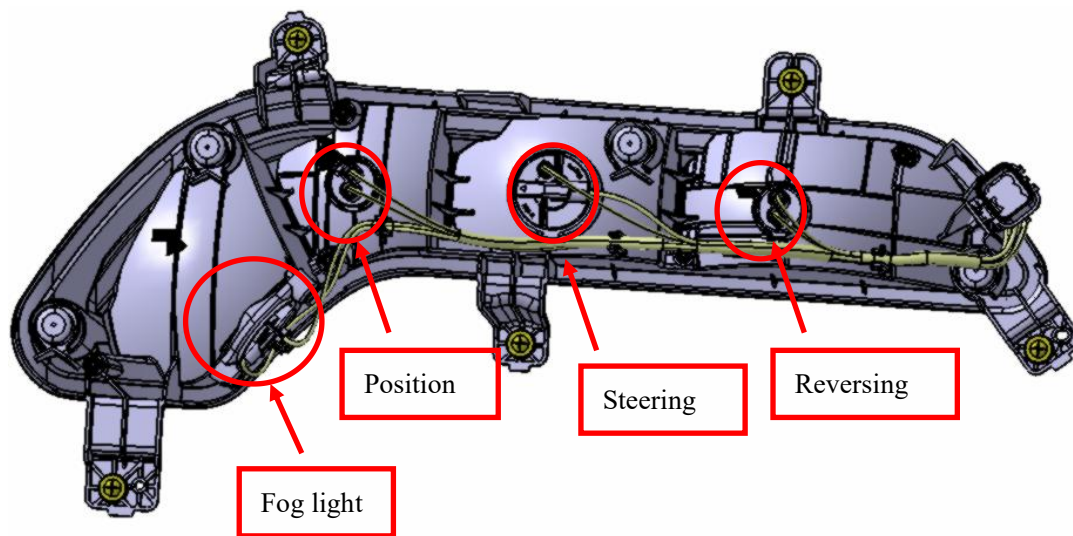
3) Replacement of rear lower combination lamp bulb

1) Removal Step:

- ① disconnect the negative pole of the accumulator;
- ② Rotate the lamp cover counterclockwise to remove the lamp cover.
- ③ Remove the lamp bulb from the lamp holder.

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- ④ Replace the lamp bulb.

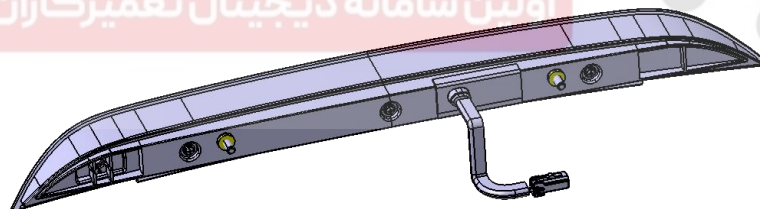


2) Installation Step:

Assembly sequence is opposite to the disassembly sequence.

V. Brake lamp device

1. Components diagram



2. Brake lamp device composition

No.	Name	Quantity	Remark
1	High brake lamp assy.	1	
2	Hex flange bolt & flat washer assembly	2	

3, high brake light replacement

1) Removal Step:

- ① disconnect the negative pole of the accumulator;

② Open the tail door, remove the two fixing points of high position brake lamp, the torque is 3N.m~5N.m.

- ③ Shake the high position brake lamp, to make the high position lamp separate

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from the tail door trim panel;

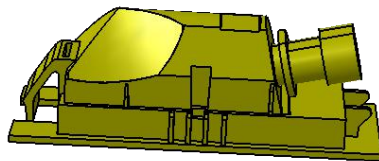
- ④ Carefully move the high position brake lamp and remove electrical connector.

2) Installation Step:

Assembly sequence is opposite to the disassembly sequence.

VI. License Plate Lamp Device

1. Components diagram



2. License plate lamp device composition

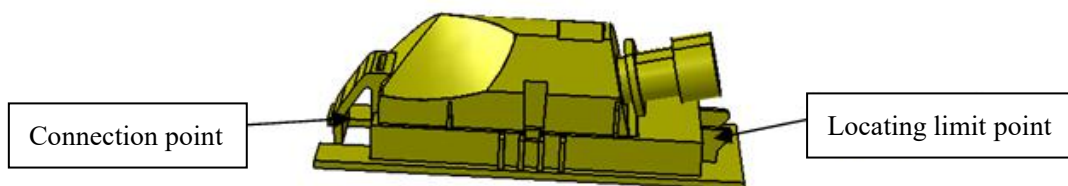
No.	Name	Quantity	Remark
1	License plate lamp assembly	2	

3, license plate replacement

1) Removal Step:

- ① disconnect the negative pole of the accumulator;

② Open the tail door, use flat screwdriver to pry the license plate lamp from the license plate lamp connecting point;



③ Shake the license plate lamp, to make the license plate lamp separate from the tail door outer trim panel;

- ④ Carefully move the license plate lamp and remove electrical connector.

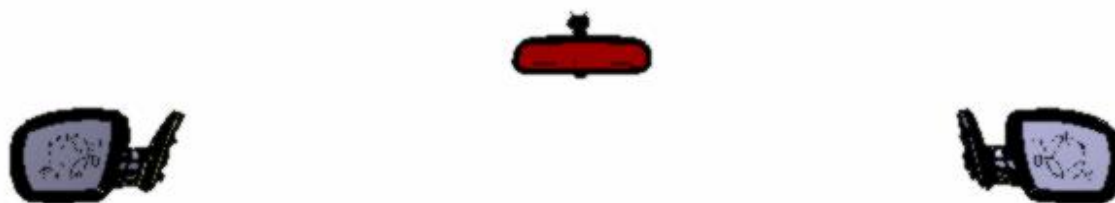
2) Installation Step:

Assembly sequence is opposite to the disassembly sequence.

VII. Rear view mirror device

1. Components diagram

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2. Replacement of rearview mirror device

No.	Name	Quantity	Remark
1	Left external rear-view mirror assy	1	
2	Right external rear-view mirror assy	1	
3	Interior Rearview Mirror Assembly	1	
4	Inner rearview mirror pedestal	1	
5	Hex flange bolt & flat washer assembly	6	
6	Interior rearview mirror upper cover		

3. Replacement of outer rearview mirror

1) Removal Step:

① disconnect the negative pole of the accumulator;

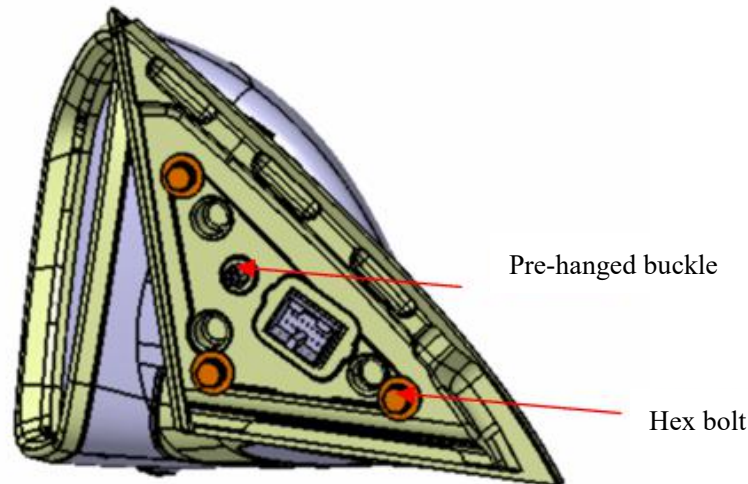
② Disassemble front triangular cover board. Please refer to “front triangular board”

③ Remove the hex bolts on the outer rearview three installation point, the torque is 3N•m-5N•m.

④ Shake the outer rearview mirror, to make the outer rearview mirror buckles separate from the vehicle door;

⑤ Carefully move the rearview mirror, and remove the electrical connector;

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2) Installation Step:

Assembly sequence is opposite to the disassembly sequence.

4. Replacement of inner rearview mirror

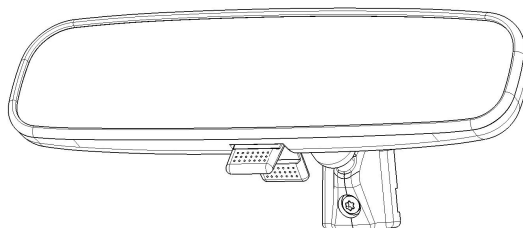
1) Removal Step:

① Rotate the rearview mirror, and uncover the rearview mirror upper cover from the rearview mirror base;

② Disassemble rear view mirror from the base with small flat screwdriver, the torque is 1.1N-1.9N;

③ Slightly shake the inner rearview mirror, to make the inner rearview mirror separate from the rearview mirror base slide track.

④ Carefully move the rearview mirror, and remove the electrical connector;



2) Installation Step:

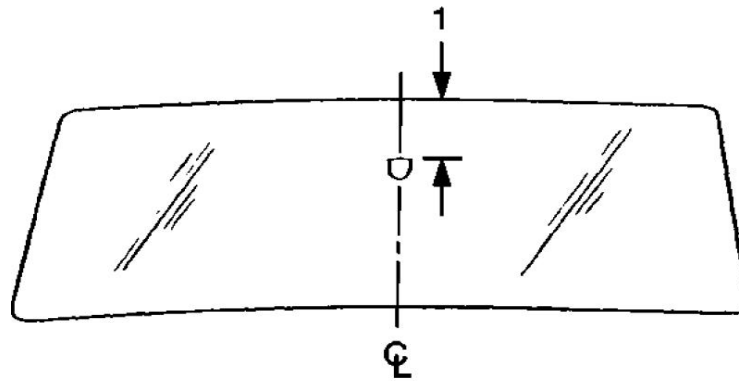
Assembly sequence is opposite to the disassembly sequence.

5. Replacement of inner rearview mirror base

1) Installation Step:

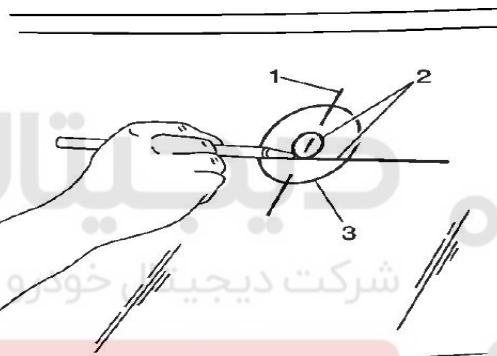
① Measure the top dimensions from the top of windshield (1) to the inner rear view mirror pedestal(2). The size is 105 mm.

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The sketch map after install the inner rear view mirror

② Mark the outside of the windshield with a wax pen or crayon. Draw a large circle along the inner rear view mirror pedestal outside edge on the windshield outer surface (3).



The sketch map of installation of the inner rear view mirror

③ Clean the circle on the inner side of windshield with glass detergent of common type, common part number or polished tissue. Scrub the area until it is completely clean and dry. After drying, clean the area with the tissue what stained with isopropyl alcohol to remove the traces of washing powder or detergent.

Attention:

■ If the original inner rear mirror pedestal is used again, all adhesive traces must be removed before reinstalling.

④ Use a thin (320 or 360) steel gauze or sandpaper to polish the bonding surface of the new inner rear view mirror or factory mounted original inner rear view mirror pedestal.

⑤ Wipe the polished inner rear mirror pedestal with a clean tissue stained with isopropyl alcohol. open-air dry it.

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⑥ Before install it onto the windshield, prepare the inner rear mirror pedestal according to the manufacturer's instructions.

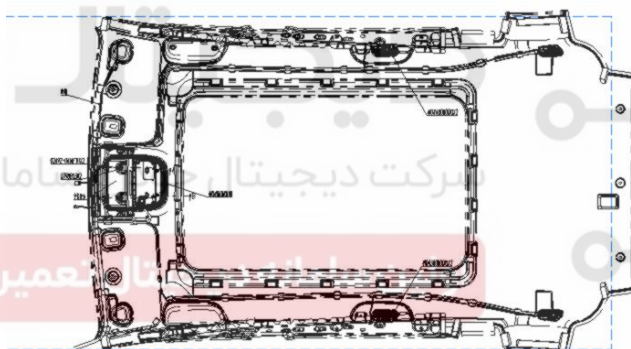
⑦ Place the inner rear view mirror correctly at the pre-marked position. The half rounded end pointing upward is unallowed. Press the inner rear view mirror pedestal against the windshield for 30 to 60 seconds, applying constant pressure on the windshield.

⑧ After 5 minutes, remove all excess adhesive with tissue stained with isopropyl alcohol or window cleaner.

⑨ Re-install the inner rear view mirror.

VIII. Inner lamp device

1. Components diagram



2. Inner lamp device composition

No.	Name	Quantity	Remark
1	Front roof light assembly	1	
2	Left wall lamp assembly	2	
3	Right wall lamp assembly	2	
4	Door lamp end cap	8	
5	Screw spring washer assembly	2	
6	Type A through-hole insert plastic nut	2	

3, the front ceiling lamp replacement

1) Removal Step:

- ① disconnect the negative pole of the accumulator;
- ② Open the front roof lamp glass box;
- ③ Remove the 2 fixing screws of front roof lamp by sequence, the torque is

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1N•m-3N•m;

④ Remove the front roof lamp from the roof, disconnect the connector carefully.

2) Installation Step:

Assembly sequence is opposite to the disassembly sequence.

4. Replacement of side wall lamp

1) Removal Step:

① disconnect the negative pole of the accumulator;

② Use flat screwdriver to carefully remove the side wall lamp from the roof inner trim;

② Disconnect connectors, take down the side wall lamp

9. maintenance data and specifications

Bulb power and light color

Lamps and lanterns specification

Name		Bulb type	Bulb rate	Lighting color
Daytime driving combination lamp	Front headlight/Daytime running light	LED		White
	Turning lamp	LED		amber
	Far/low light	LED		White
Tailgate taillight	Brake lamp	LED		Red
	Turning lamp	LED		amber
	Position Lamp	LED		Red
Rear lower combination lamp	Rear fog lamp	Bulb (P21W)	2×21W	Red
	Reversing lamp	Bulb (W21W)	2×21W	White
	Rear turn lamp	Bulb (PY21W)	2×21W	amber
	Rear position light	Bulb (W5W)	2×5W	Red
License plate lamp		Bulb (W5W)	2×5W	White
High brake lamp		LED		Red
Front roof lamp	Reading lamp	LED		White
Side wall lamp	Door light	LED		White

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Accessory System

I. Engine mudguard

1. Engine mudguard device composition:

No.	Name	Quantity	Remark
1	Engine left guard plate assembly	1	
2	Engine right guard plate assembly	1	
3	Left deflector assembly	1	
4	Engine lower guard plate assembly	1	
5	Left installing bracket of lower backplate	1	
6	Right installing bracket of lower backplate	1	
7	Hex flange bolt & flat washer assembly	10	
8	Hex flange bolt & flat washer assembly	10	
9	M-type countersunk screw	4	
10	Hex flange bolt & flat washer assembly	4	
11	Hex plastic nut	6	
12	Hex flange bolt & flat washer assembly	4	
13	hexagon flange bolt	4	
14	Engine cover assembly	1	
15	Engine cover mounting bracket assembly	1	

2. Replacement of engine mudguard

2.1 Removal of engine left guard plate assembly (2802100U0010)

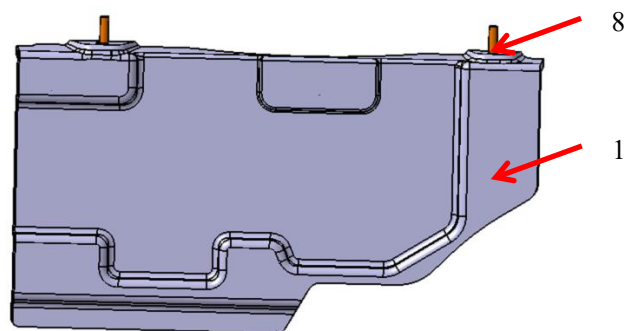
2.1.1 Unscrew the two hexagon bolt & flat spring washer assembly (11254-0620F61)

connecting the engine left guard plate assembly and the sheet metal;

2.1.2 Take down the engine left guard plate assembly;

- a) Engine left guard plate assembly affiliated components and assembling relations

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2.2 Removal of engine right guard plate assembly (2802200U0010)

2.2.1 The removal method of engine right guard plate assembly is the same with the left

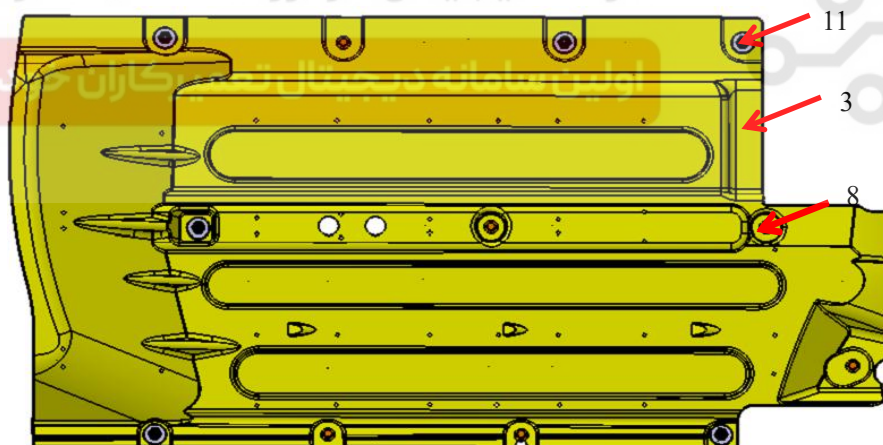
2.3 Removal of left deflector assembly (2802300U0010)

2.3.1 Unscrew the two hexagon bolt & flat spring washer assembly (11254-0620F61) connecting the engine left guard plate assembly and the sheet metal;

2.3.2 Remove the 6 hex plastic nuts;

2.3.3 Take down the left deflector assembly.

a) Left deflector assembly affiliated components and assembling relations



2.4 Removal of engine lower guard plate assembly (2802500U0010)

2.4.1 First remove the 4 M type sunk screws (12492-0516F71) and the 4 hex bolt and flat spring washer assembly (11254-0825F61) fixing on the FEM, and then remove the 4 hex bolt & flat spring washer assembly (11254-0825F61), and finally remove the 6 hex bolt & flat spring washer assembly (11254-0820F61);

2.4.2 Take down the engine lower guard plate assembly;

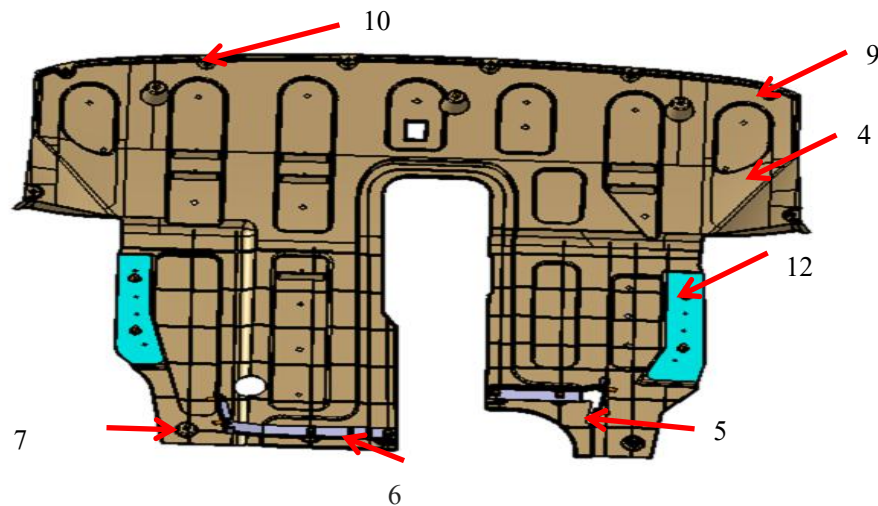
2.4.3 Remove the 2 hex bolt and flat spring washer assembly (11254-0820F61) connecting the lower guard plate left side installation bracket and sheet metal, and remove the 2 hex bolt and flat spring washer assembly (11254-0820F61) connecting

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the lower guard plate right side installation bracket and sheet metal

2.4.2 Take down the left/right installing bracket of lower backplate

a) Engine lower guard plate assembly affiliated components and assembling relations



2.5 Removal of engine guard assembly (2802600U0030)

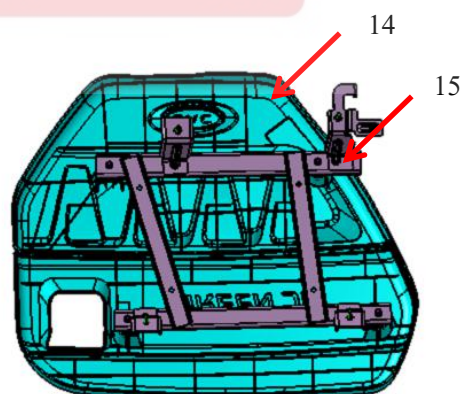
2.5.1 Pry the dipstick cover plate opening handle, you can directly remove the part

2.5.2 pull up and remove the engine guard;

2.5.3 unscrew the 4 flange hexagon bolts (Q1840612F62) connecting engine guard mounting bracket and engine;

2.5.4 remove engine guard mounting bracket assy

a) Engine guard device's affiliated components and assembling relations



3. Installation of engine mudguard

Assembly sequence is opposite to the disassembly sequence.

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II. Nameplate device

1. Nameplate device composition

No.	Name	Quantity	Remark
1	Nameplate	1	
2	VIN label	7	
3	Label 150	1	
4	Model name label	1	Optional

2. Removal of nameplate device

2.1 Directly tear off the model name logo. Attention: These logo parts are damaged after removal and can not be restored, new logo parts must be installed.

2.2 After removing the logo installation base, unscrew the label 150 mounting screw from back; back of the label is bonded with double sides adhesive tape, use flat screwdriver to pry it when removing.

2.3 The VIN sign and nameplate contain vehicle identification information, which are non-removable parts and are not allowed to be damaged, smeared or disassembled.

3. Installation of nameplate device

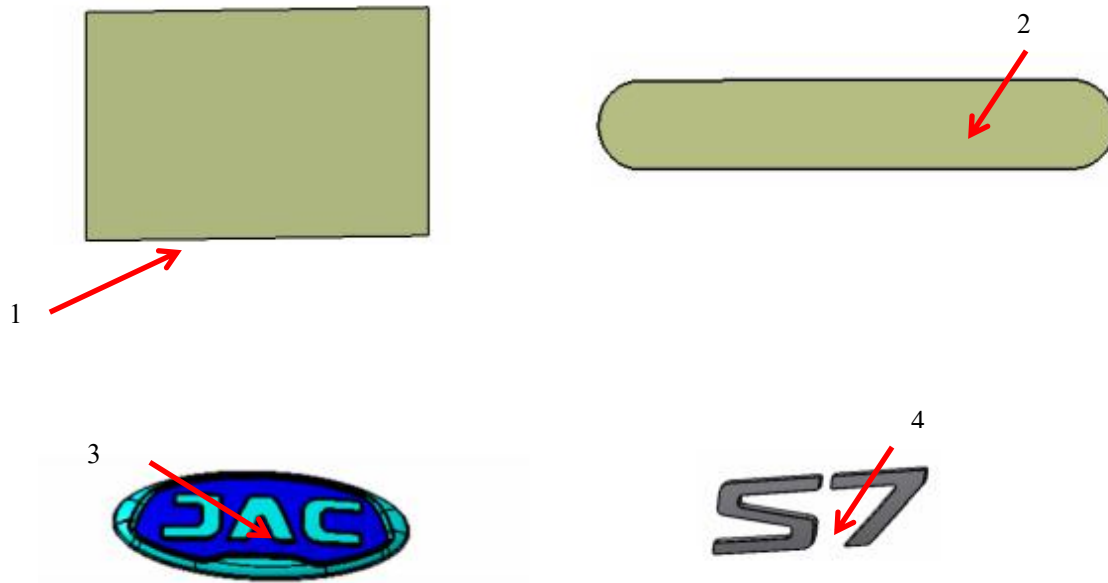
3.1 Paste the vehicle nameplate to the vehicle bodywork right side panel outer plate, ensure it is pasted well, and it is flat and there is no bubbles;

3.2 Paste the VIN label to the vehicle body VIN label mounting bracket, upper part of the engine compartment left front shock absorber metal plate, lower part of the right B-pillar outer panel, upper part of the left middle door lower hinge, lower part of driver's seat rear part, right upper part of glove box, right upper part of luggage compartment metal plate, totally 7 positions; use locating tools to ensure it is pasted correctly, and it is flat and there is no bubbles;

3.3 Label 150 is fixed on the logo mounting base by M4 self-tapping screw, and it is supplied by assembly, the torque is 3-5Nm.

3.4 Use positioning tooling to locate the vehicle name label, tear off the double-sided adhesive paper on the back, and paste it on the body's sheet metal surface; pay attention to the cleaning and pasting position before pasting; press the word surface after pasting, so that The double-sided tape is in full contact with the bonding surface.

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III. Front windshield glass and sealing strip device

1. Composition of front windshield and sealing strip device

No.	Name	Quantity	Remark
1	Front windshield glass	1	
2	Ventilation cover assembly	1	
3	Left part of ventilation cover	1	
4	Right part of ventilation cover	1	
5	Left fender	1	
6	Right fender	1	
7	Fender left block	1	
8	Fender right block	1	
9	Expansion clip	9	

2. Removal of front windshield glass and sealing strip device

2.1 dismantle the 2 expansion buckles (5522101U2152) connecting the left/right cover plate of the ventilation cover plate and the ventilation cover plate assembly, and take down the left/right cover plate of the ventilation cover plate and left/right fender;

2.2 Remove the 7 expansion buckle (5522101U2152), remove the water pipe, and take down the ventilation cover assembly; note that before removing ventilation cover, please remove the engine compartment left/right ventilation cover;

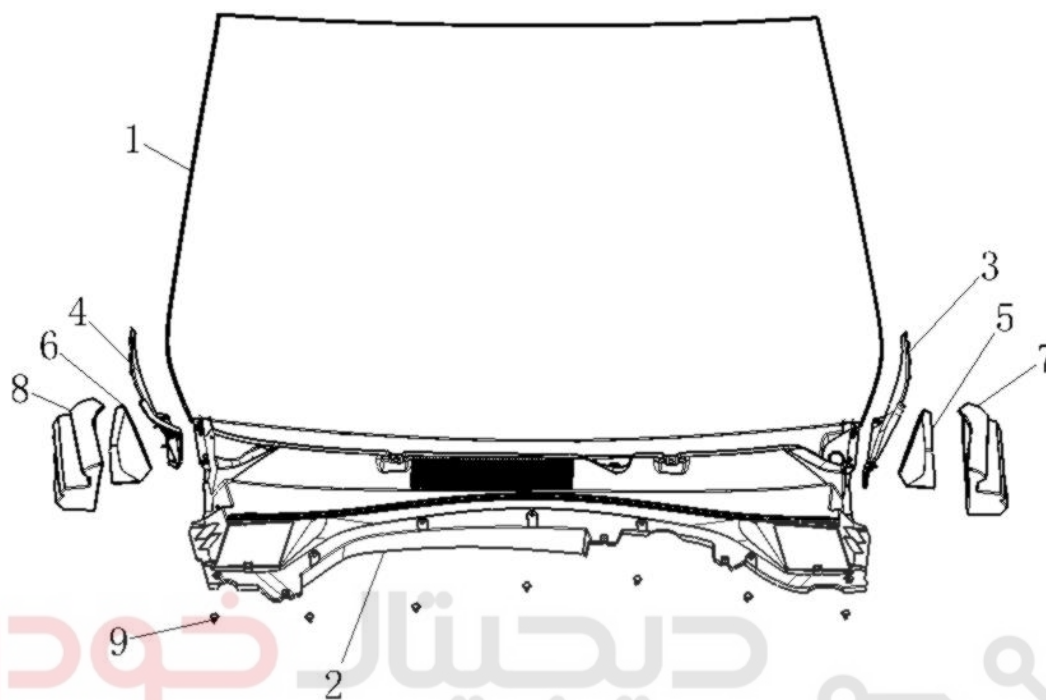
2.3 Fender left/right block can directly be removed;

2.4 Get rid of the sealant between windshield glass and the frame, remove the

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windshield glass assembly; attention: windshield glass and decorative strip is not reusable, and must be replaced for a new one.

a) Front windshield device affiliation parts and its assembly relations



Note: dismantle the screen wiper components before dismantling the front windshield.

3. Installation of front windshield glass and sealing strip device

3.1 Installation of the front windshield assembly

3.1.1 Inspection before installing

Check the appearance for scratches and other defects, amount,

3.1.2 installation procedure:

1) Wipe the surface of the body sheet metal flange used to install the front windshield with a clean cloth with a glass cleaner, and let it cool for 1-2 minutes;

2) uniformly coating the glass primer on the body sheet metal flanged surface for installing the front windshield;

3) Place the front windshield on the glass coating station, use the glass cleaner to clean the front windshield rubber coating area and dry it;

4) coat the base coat evenly on the area to be coated, and then dry it in the air;

5) Use a glue gun to apply the glue track along the front wind window to apply the glass glue to the glass coating area; the glue specification: the bottom edge of the glue is 8mm wide and 12mm high;

6) after gelatinizing, carry the windshield glass to the position over the

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frame, press it against the body sheet metal revers, clip the positioning pin into the positioning hole in the sheet metal, let it stand for 12 hours.

c) After assembly, check whether the windshield rubber strip and the body sheet metal are well fitted, whether the limit column is stuck in the sheet metal limit hole, and whether there is overflow glue. If there is any problem, it must be adjusted immediately.

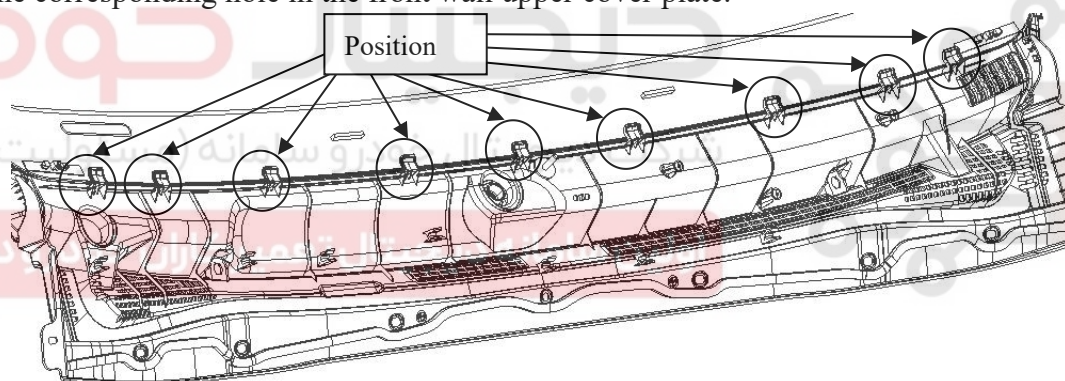
3.2 Assembly of the ventilation cover assembly

3.2.1 Inspection before installing

Before installing, check if the assembly appearance has any defect, such as scratch, breakdown; if the installation of the pre-installation part is firmly, if there is misinstallation; check the front windshield and left/right fender is installed and adjusted in place, the front engine hood is in open state.

3.2.2 installation procedure:

1) turn the cover plate body to the proper position, insert two windscreen wiper spindle, insert the clip foot into the back of the front windshield, insert the limit rib into the corresponding hole in the front wall upper cover plate.



Picture 6.16.2

2) Fit the expansion buckle (5522101U2152) into the corresponding hole position, first assemble the intermediate main positioning hole, then assemble the auxiliary positioning holes at both ends, and finally assemble the remaining holes.

3) Pre-install the ventilation cover left/right fender and left/right cover plate, install the fender installation hole into the side cover plate installation pillar, and then install the overall; install the left/right cover plate locating pillar into the main locating hole of the ventilation cover body, and then install the clip feet installed on the fender flange into the fender flange; adjust the left/right fender position, paste the fender double sides adhesive tape and the metal plate installation surface firmly, and install the expansion buckle (5522101U2152) into the front fitting fixing hole of the side

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cover plate and ventilation plate.

4) Insert the fender left/right block into the hole of the fender and the hinge. Check if the cover plate is firmly assembled, seal strip and the front windshield glass fit well, and other parts fit well. Check if the fender left/right block has looseness, if it is installed in place.

IV. Side panel window device

1. Composition of side panel window device:

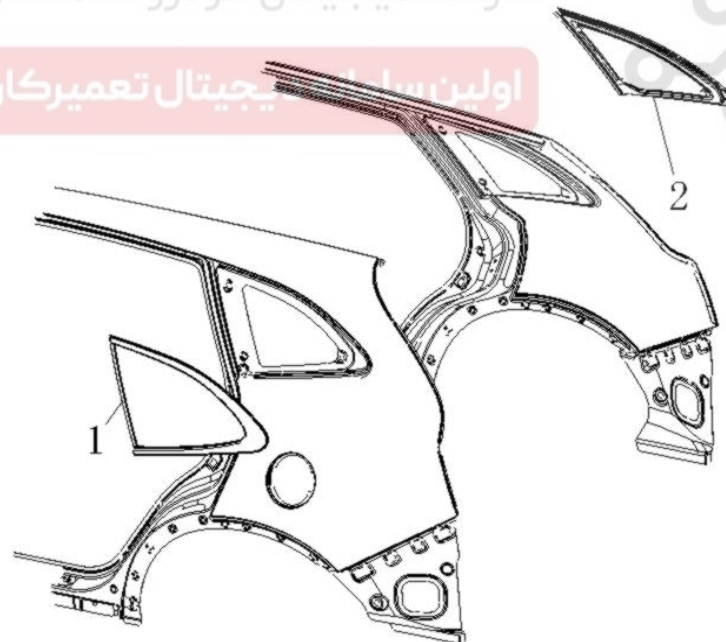
No.	Name	Quantity	Remark
1	Left rear triangular window	1	Bilateral symmetry
2	Right rear triangle window	1	Bilateral symmetry

2. Removal of side panel window device

2.1 Firstly cut the sealant between the left/right side window assembly and the body sheet metal mounting frame;

Take down the left/right side panel window device; Note: The side panel window always become unrecoverable parts after disassembly, and new parts must be used for re-installation.

a) Side panel window device affiliation parts and its assembly relations



3. Removal of side panel window device

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- 1) Wipe the surface of the body sheet metal flange used to install the left/right rear triangle window with a clean cloth with a glass cleaner, and let it cool for 1-2 minutes;
- 2) uniformly coating the glass primer on the body sheet metal flanged surface for installing the left/right rear triangle window;
- 3) Place the left/right rear triangle window assembly on the glass coating station, use the glass cleaner to clean the left/right rear triangular window coating area and dry it;
- 4) Evenly paint the gluing area of the left/right rear triangle window assembly and dry it;
- 5) Use a glue gun to apply the glue track along the left/right rear triangle window to apply the glass glue to the glass coating area; the glue specification: the bottom edge of the glue is 8mm wide and 12mm high;
- 6) After applying the glue, use the suction cup to transport the left/right rear triangle window assembly to the body sheet metal mounting frame, align the fixing buckle with the body sheet metal mounting hole, snap into the sheet metal limit hole and press to ensure the glass. The glue is in full contact with the gilt surface and is allowed to stand still for more than 12 hours.

V. Wheel cover decoration part device

1. Composition of wheel cover decoration part device:

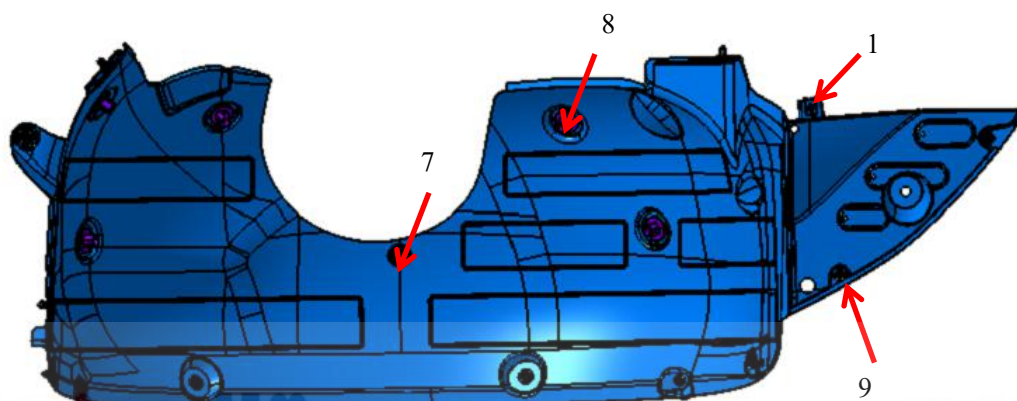
No.	Name	Quantity	Remark
1	Left front wheel cover	1	
2	Right front wheel cover	1	
3	Left rear wheel cover assembly	1	
4	Right rear wheel cover assembly	1	
5	Left rear mudguard assembly	1	Bilateral symmetry
6	Right rear mudguard assembly	1	Bilateral symmetry
7	Bumper outer housing expansion buckle	34	
8	Hex plastic nut	18	
9	M-type countersunk screw	12	
10	INSERT PLASTIC NUT	2	

2. Removal of wheel cover decoration part device

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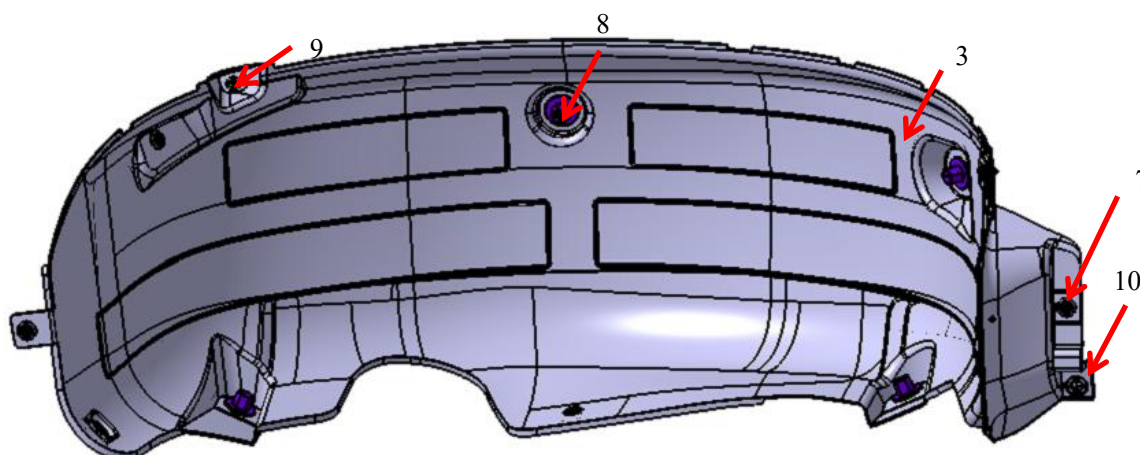
2.1 Remove the 9 bumper outer housing expansion buckles (86590-28000), 4 M-type countersunk screws (12492-0516F71) and 5 hex plastic nut (5512150U1510) of the left/right front wheel cover installed on the metal plate; take down the left/right front wheel cover assembly; Note before removing the front wheel cover, remove the engine lower guard panel assembly and tire assembly.

a) Wheel cover device affiliation parts and its assembly relations



2.2 Remove the 2 M-type screw (12492-0516F71), the 5 bumper outer housing expansion buckles (86590-28000) and the 4 hex plastic nuts (5512150U1510) of the left/right rear wheel cover assembly, and take down the left/right rear wheel cover assembly;

2.3 Remove the 3 bumper outer housing expansion buckles (86590-28000) of the left/right rear mudguard assembly, and take down the left/right rear mudguard assembly.



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3. Removal of wheel cover decoration part device

Assembly sequence is opposite to the disassembly sequence.

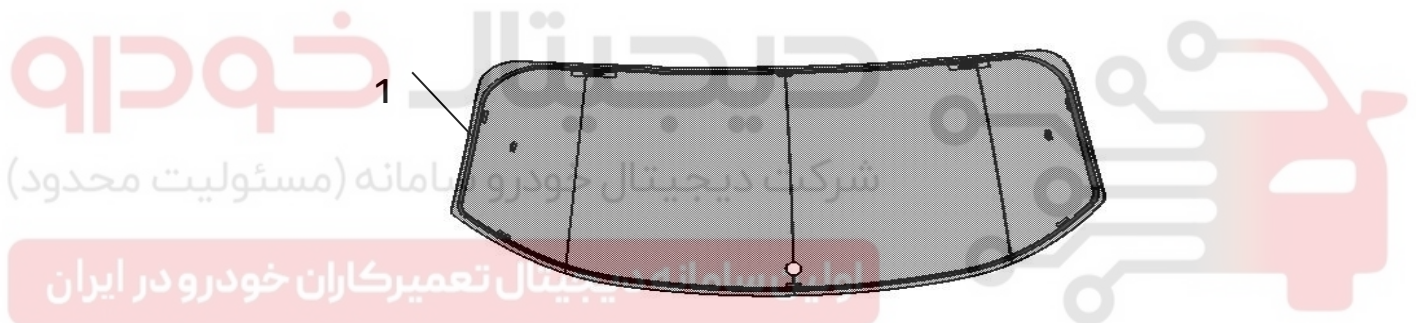
VI. Rear windshield device

1. Rear windshield device composition

No.	Name	Quantity	Remark
1	Rear windshield glass	1	

2. Removal of rear windshield device

2.1 Remove the sealant between the front windshield and the body sheet metal mounting frame and remove the rear windshield glass assembly; note that the rear windshield glass is always an unrecoverable part after disassembly, and new parts must be used for re-installation. Be careful to remove the rear windshield assembly, the left/right tailgate trim assembly, and the tailgate wiper before removing the rear windshield, and pull out the wiring harness connected to the rear windshield.



3. Installation of rear windshield device

3.1 Inspection before installing

Check for any scratches and other defects, the amount, the labels and enforced inspection mark clarity, make sure the tail door outer trim panel assembly is correctly mounted.

3.2 Assembly step

1) Wipe the surface of the body sheet metal flange used to install the rear windshield with a clean cloth with a glass cleaner, and let it cool for 1-2 minutes;

2) uniformly apply the glass primer to the body sheet metal flanged surface for installing the rear windshield;

3) Place the rear windshield on the glass coating station, use the glass cleaner to clean the windshield rubber coating area and dry it;

4) smear the first coat onto the coating area evenly, and let it dry in the air

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5) Use the glue gun to evenly apply the glass glue along the glue track to the glue application area; the glue specification: the bottom edge of the glue is 8mm wide and 12mm high;

6) after coating , carry the rear windscreen with suction disc, place it behind the mounting frame, and press it against the sheet metal revers for mounting the windscreen, location pin is aimed at the location hole in the body, place it there ,let it stay in the air for 12 hours or more.

c) After installing, check if the rear windshield is installed correctly, if there is sealant leaking.

VII. Roof cover outer guard surface device

1、Roof cover outer guard surface device composition:

No.	Name	Quantity	Remark
1	left roof rack	1	Bilateral symmetry
2	Right roof rack	1	Bilateral symmetry
3	Left-top trim panel	1	Bilateral symmetry
4	Right side roof cover trim panel assembly	1	Bilateral symmetry
5	Hex nut & conical spring washer assembly	8	

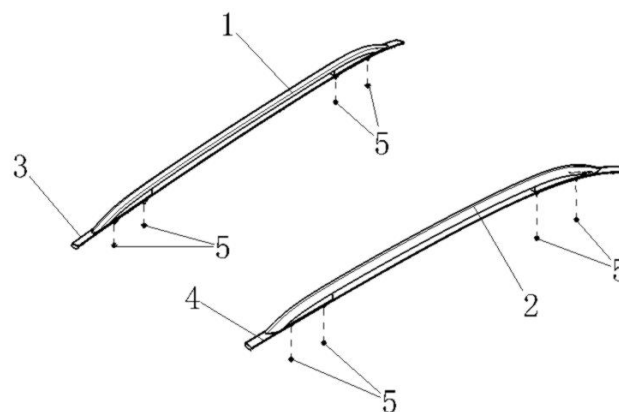
2、Removal of roof cover outer guard surface device

2.1 Unscrew the 4 nuts (Q32206F62L) connecting left/right roof rack and metal plate.

Note: When removing the outer cover of the top cover, the interior ceiling and its accessories should be removed first;

2.2 From the front end, pry open the left/right top strip to the side panel and the top cover, and remove the left/right top strip.

a) Roof cover outer guard surface device and its assembly relations



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3. Installation of roof guard surface device

3.1 Inspection before installing

Before assembly, check the appearance of components for scratches, blistering and other defects affecting the appearance, and check whether the buckles are broken or loose.

3.2 Assembly step

1) Insert the left/right top cover trim assembly snap into the body mounting clip, and use 8 snaps to position the front end of the top cover, and then snap in from the front to the back to ensure that the card is securely fastened.

2) The left/right roof rack assembly mounting bolts are inserted into the roof mounting hole of the car body and fixed by 4 hex nuts and tapered elastic washer assemblies (Q32206F62L). First install the main positioning holes, then install the auxiliary positioning holes and other holes. Position, tightening torque $7\text{N}\cdot\text{m} \sim 9\text{N}\cdot\text{m}$.

c) After installation, check if the fitting of left/right top cover decorative strip assembly flange and vehicle body metal plate is well, if the fitting of the left/right roof rack assembly and left/right top cover decorative strip assembly.

VIII. Roof cover outer guard surface device

1. Composition of tail door outer guard surface device

No.	Name	Quantity	Remark
1	Tail fin assembly	1	
2	Tail door outer trim panel assembly	1	
3	Left rear door decorative strip assembly	1	Bilateral symmetry
4	Right rear door decorative strip assembly	1	Bilateral symmetry
5	logo installation base	1	
6	Round head cover nut	4	
7	Hex nut & conical spring washer assembly	16	
8	M-type countersunk screw	2	

2. Removal of tail door outer guard surface device

2.1 Remove the 2 hex nut & conical spring washer assembly (Q3206F62L)

connecting with metal plate, and pull down the logo mounting base;

2.2 Pull down the left/right tail door decorative strip assembly;

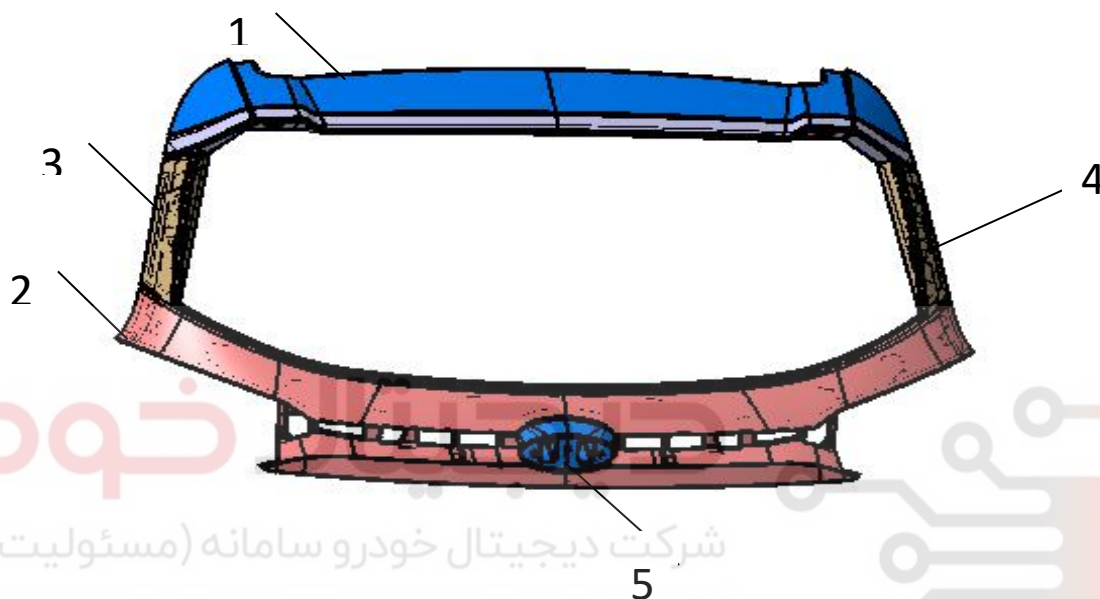
2.3 Remove the 7 nuts (Q3206F62L) connecting spoiler assembly and metal plate,

take down the spoiler assembly. Note: When removing the rear wing assembly, first remove the tailgate trim panel and pull out the harness and water pipe connected

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with the high brake light;

2.4 Remove the 4 hex with conical nuts connecting with the metal plate and 7 hex nut & conical spring washer assembly, and pull down the tail door outer decorative plate assembly; NOTE: Before removing tail door outer decorative plate assembly, first remove the rear windshield assembly, tail door wiper, tail door run through lamp, and pull out the wiring harness connecting to the license plate lamp, camera and tail door switch.



3. Installation of tail door outer guard surface device

3.1 Inspection before installing

Before assembly, check if the part amount is correct, if there is scratch, blistering and other defects affecting the appearance.

3.2 Assembly step

1) Tail door outer trim panel assembly: Firstly, the tailgate outer panel assembly positioning post is snapped into the corresponding body of the body sheet metal, and the outer panel is pressed to snap the card into the corresponding mounting hole; then use the 4 hexagonal flange nuts (5705500U0010) to screw the fixing bolts on the two sides of outer trim panel, and the tightening torque is $3\text{N}\cdot\text{m} \sim 5\text{N}\cdot\text{m}$. Finally, use 7 hex nut and conical spring washer assembly (Q3206F62L) to fasten other fixing bolts, and the tightening torque is $4\text{N}\cdot\text{m} \sim 6\text{N}\cdot\text{m}$.

2. Spoiler assembly: Check to confirm that the installation of the rear windshield assembly is correct; insert the tail assembly fixing bolt into the corresponding hole of the

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body sheet metal and tighten with 7 hex nut & conical spring washer assembly hex nut & conical spring washer assembly (Q3206F62L), firstly fix the main and auxiliary positioning holes, and then tighten the other holes, tightening torque $4\text{N}\cdot\text{m}\sim 6\text{N}\cdot\text{m}$.

3. Left/right tail door trim panel assembly: Before installing, check to confirm the spoiler assembly is installed correctly; clean the windshield and body sheet metal double-sided adhesive bonding area with the cleaner, after dry, spread bottom coating, the window pasting area uses G-200 type bottom coating, and the metal plate area uses K-520 type bottom coating; snap the left/right tail door trim panel assembly into the mounting hole corresponding to the tail door metal plate, and press the side trim panel to make its buckles be installed into the vehicle body installation hole, and press the side trim panel to make the double-sided tape on both sides fully fit the mounting surface.

4) logo mounting base: before installing, check to confirm the installation of tail door outer trim panel assembly and tail door run through lamp is installed correctly; install the logo mounting base locating pillar into the corresponding locating hole of tail door outer trim panel, and finally use the 3 hex nut and conical spring washer assembly (Q3206F62L) to fasten other bolts, the tightening torque is $4\text{N}\cdot\text{m}\sim 6\text{N}\cdot\text{m}$.



شرکت دیجیتال خودرو (مسئولیت محدود)

اولین سامانه دیجیتال تعمیرکاران خودرو در ایران