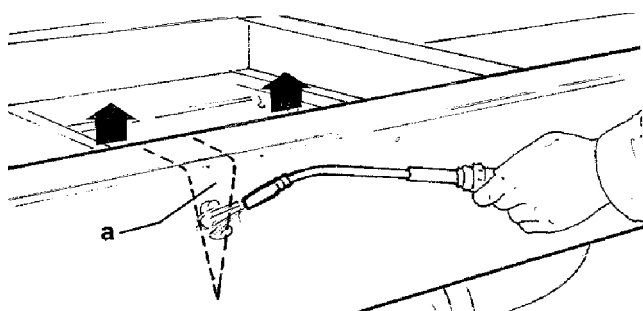


Figure 31



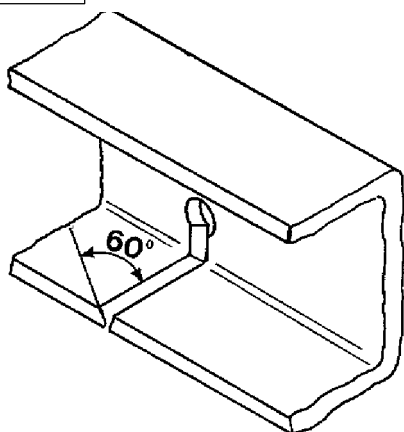
17361

Straighten the chassis up or down bending by wedge heating the upper edge plate of the side member. When bending down, the base of the wedge (a) is down, for up bending the base is up.

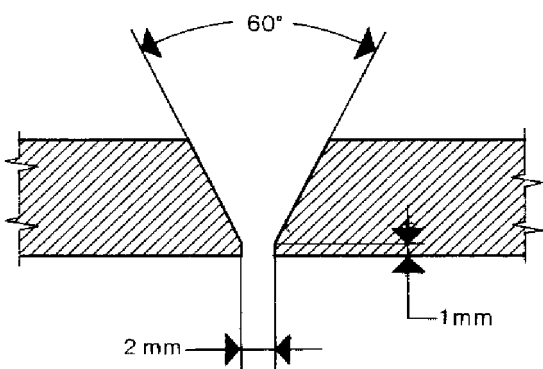
The relevant lower or upper edge plate of the side member is to be heated last in the area where the wedge base lays.

### Welds on the chassis

Figure 32



17362



17363

Before starting to weld, remove the negative battery terminal and connect the welding machine earth directly on the part to be welded. Plastic hoses must be protected or removed. Excellent workmanship is essential and welding shall only be carried out by skilled and trained operators using suitable

equipment.

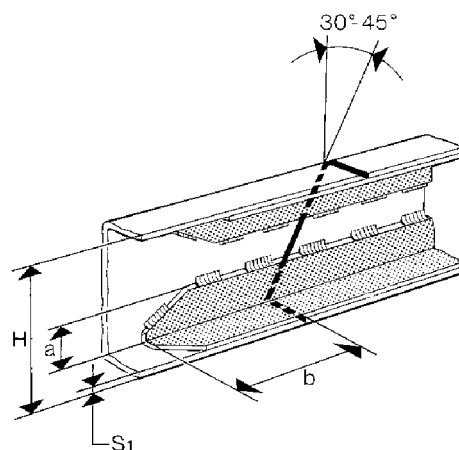
Strip off the paint and remove rust from the parts to be welded.

Make a V chamfer of 60° on the broken point in the inner part of the side member along the entire length concerned.

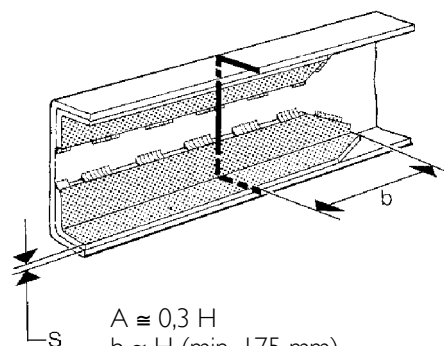


No cuts are admitted on the side members in areas where the profile changes or in the points subject to heavy stress, moreover, the parting line is not to involve any holes on the side member.

Figure 33



17364



$$A \approx 0,3 H$$

$$b \approx H \text{ (min. 175 mm)}$$

$$S \approx (0,8 \div 1) S1$$

17365

$$A \approx 0,3 H$$

$$b \approx H \text{ (min. 175 mm)}$$

$$S \approx (0,8 \div 1) S1$$

The operating instructions for correct welding are given here below:

- heat the areas to be welded (except material QST E 420); arc weld with several passes using basic electrodes suitably dried, or MIG-MAG weld with proper welding material. Avoid current overloads; welding must have no marginal indentation or slags;
- re-weld on the back, as specified in point (a, Figure 33);

- c) allow to cool slowly and evenly. Cooling with air jets or other means is not allowed;
- d) grind surface to remove excess material;
- e) apply steel stiffening angle irons having the same characteristics as the chassis; minimum suggested dimensions are indicated in the figures above. They are only to be fixed to the vertical length of the side member; and welding seams, false spots, nails or screws may be used. Welding seam section and length, number and distribution of false spots, screws or nails must be suitable to transmit moments of flexure and shearing stress of the section. When the job has been completed the welded part must be protected with rust preventer paint.