

CITROEN

REPAIR MANUAL FOR BODYWORK

FRONT WHEEL DRIVE MODELS

ENGLISH MODELS

FRENCH DESIGNATION

Light Fifteen _____ II Legere. BL

Big Fifteen _____ II Normale. B

Fifteen Seven-seater _____ II Familiale. BF

Six _____ 15 Six

ILLUSTRATIONS

LIST OF ILLUSTRATIONS IN MANUAL

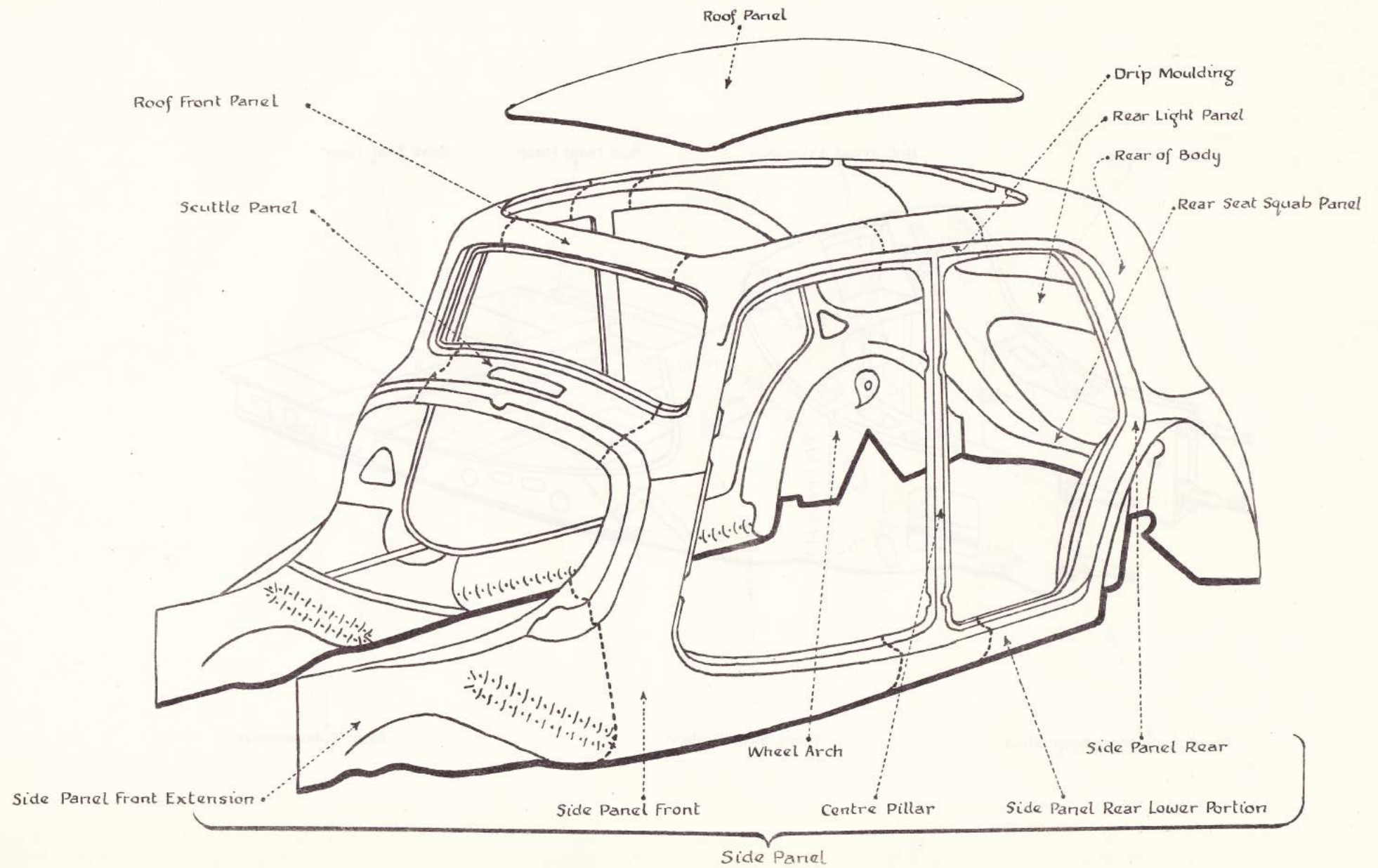
Unit	No.	Description
BODY	1	Body assembly.
	2	Hull assembly.
	3	Dimensions of mounting points for main mechanical units (4 cylinder models).
	3A	Dimensions of mounting points for main mechanical units (6 cylinder models).
FIXTURE	4	Lifting body.
	5	Installation of fixture base.
	6	Drilling of fixture base.
	7	Use of fixture (tubular crossmember not removed).
	8	Use of fixture (tubular crossmember removed).
	9	Location of fixture brackets (tubular crossmember removed).
	10	Location of fixture brackets (tubular crossmember not removed).
BODY PANELS	11	Checking hull front end.
	12	Removing and fitting side panel front lower portion (cut under scuttle panel moulding).
	13	Removing and fitting side panel front lower portion (cut through windscreen pillar).
	14	Removing and fitting front extension and side panel front portion.
	15	Removing and fitting assembly of front extension, side panel front portion and centre pillar.
	16	Removing and fitting front sidemember.
	17	Removing and fitting hull front end.
	18	Removing and fitting a front axle mounting stud.
	19	Removing and fitting hull front assembly (cut along scuttle line).
	20	Removing and fitting body front assembly.
	21	Removing and fitting body front assembly (cut across roof rails).
	22	Removing and fitting front end of side panel extension.
	23	Reinforcing scuttle panel corners.
	24	Removing and fitting instrument panel.
	25	Removing and fitting scuttle panel.
	26	Removing and fitting front roof panel.
	27	Removing and fitting roof panel.
	28	Removing and fitting rear light panel.
	29	Removing and fitting rear panel lower portion.
	30	Removing and fitting rear panel.
	31	Removing and fitting wheel arch.
	32	Removing and fitting petrol tank housing panel.
	33	Reinforcement of wheel arch.
	34	Removing and fitting side panel rear portion.

LIST OF ILLUSTRATIONS IN MANUAL

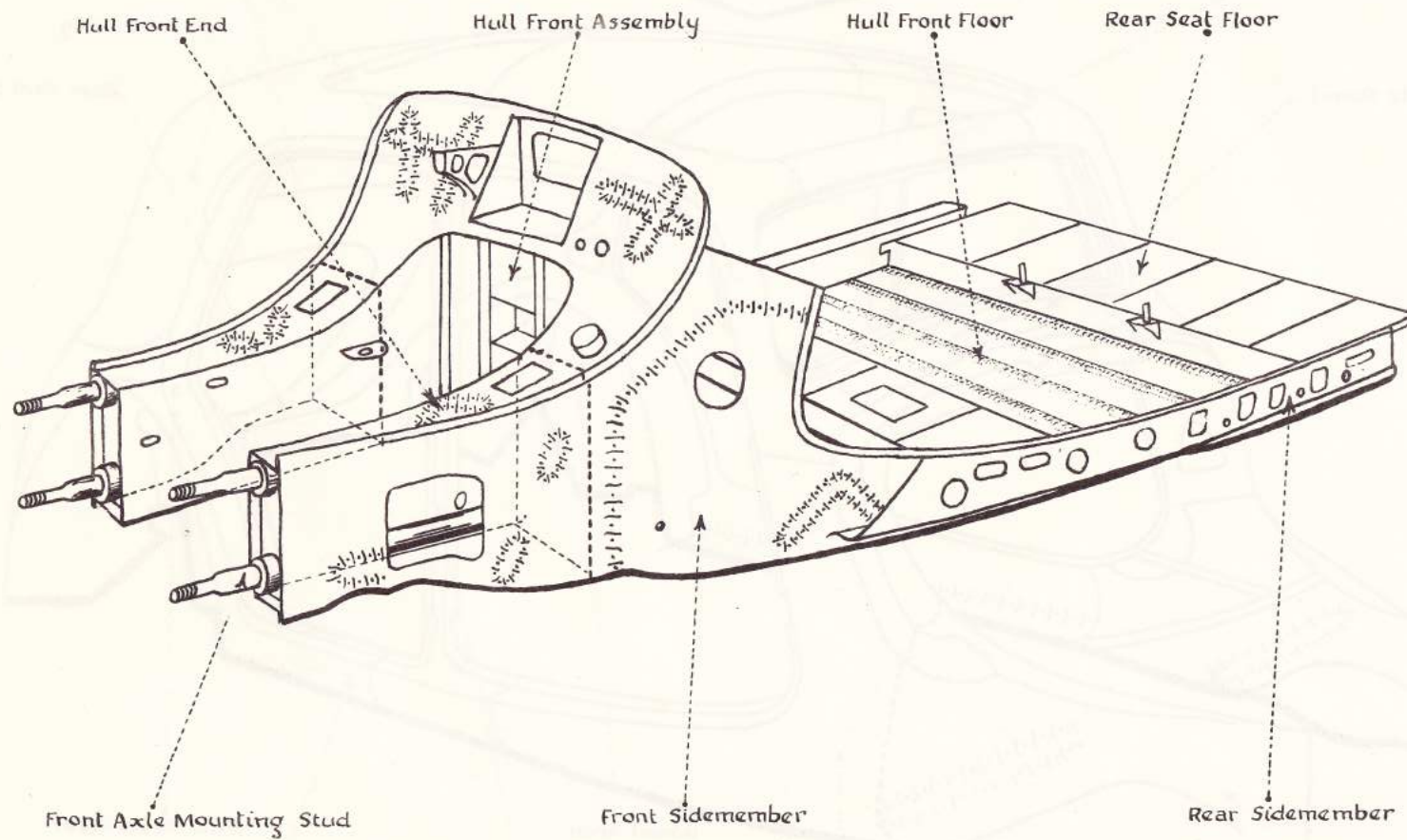
Unit	No.	Description
	35	Removing and fitting side panel rear portion and centre pillar.
	36	Removing and fitting side panel.
	37	Removing and fitting centre pillar.
	38	Removing and fitting side panel lower portion.
	39	Removing and fitting rear sidemember.
	40	Components of body maker's jack.
	41	Various tools for panel-work.
	42	Use of wedges with body maker's jack.
TRIMMING	43	Section through "softened" type seat cushion.
PAINT	44	Sound deadening.

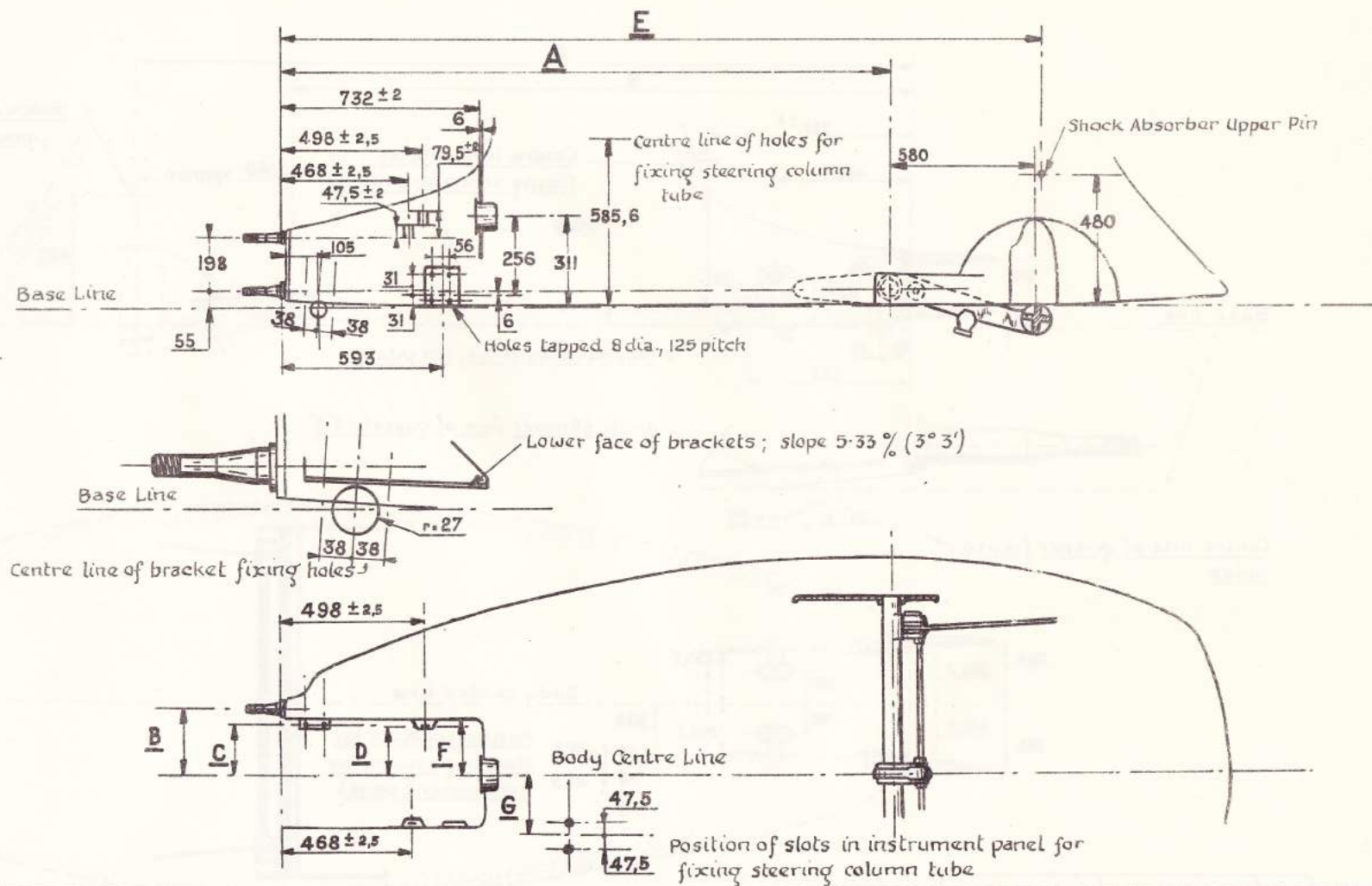
BODY ASSEMBLY

1



— HULL ASSEMBLY —



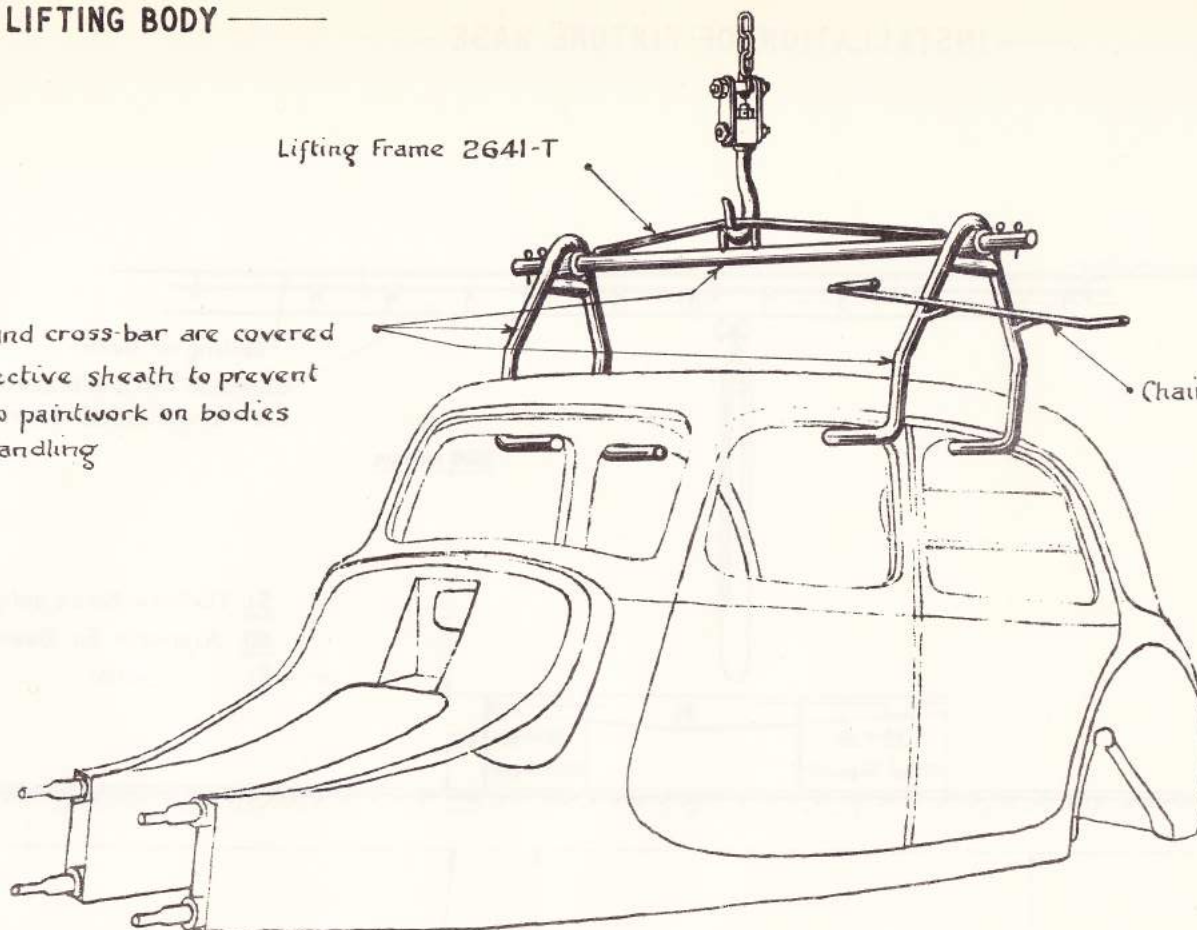


	"Twelve" and "Light Fifteen"	"Big Fifteen"	"Fifteen" (Seven-seater)		"Twelve" and "Light Fifteen"	"Big Fifteen"	"Fifteen" (Seven-seater)
A	2259	2439	2624	E	2850	3030	3215
B	225	285	285	F	195,7	255,7	255,7
C	185,2	245,2	245,2	G	260	320	320
D	163 ± 1	223 ± 1	223 ± 1				

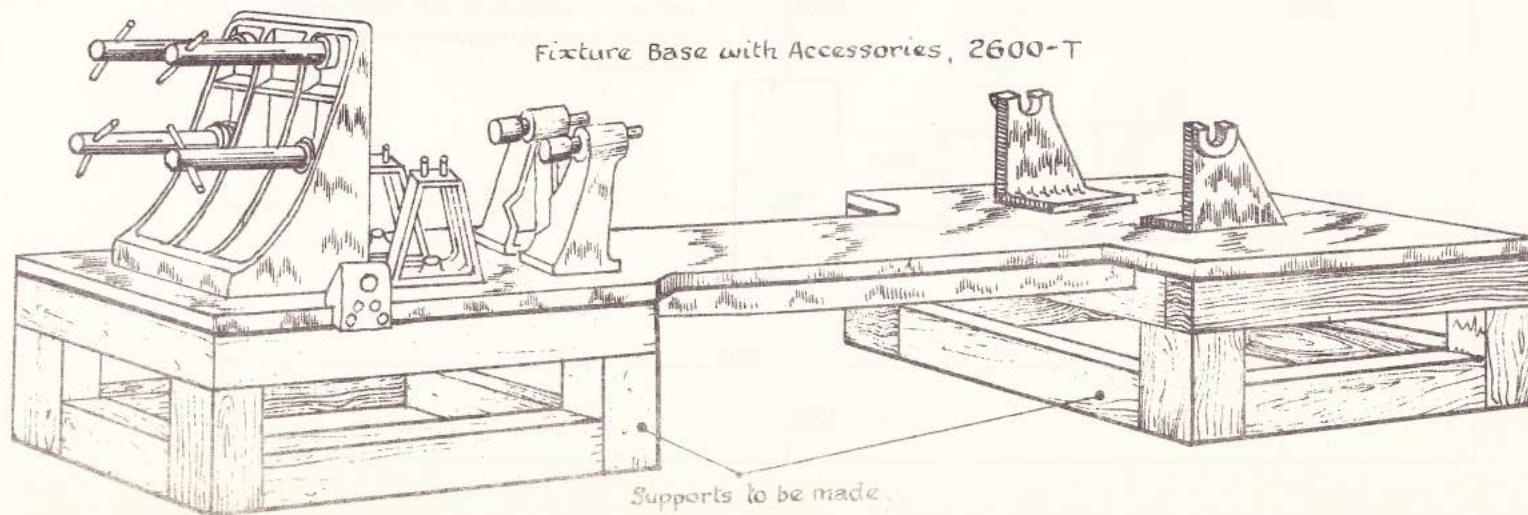
Lifting Frame 2641-T

The legs and cross-bar are covered with protective sheath to prevent damage to paintwork on bodies during handling

Chain guide

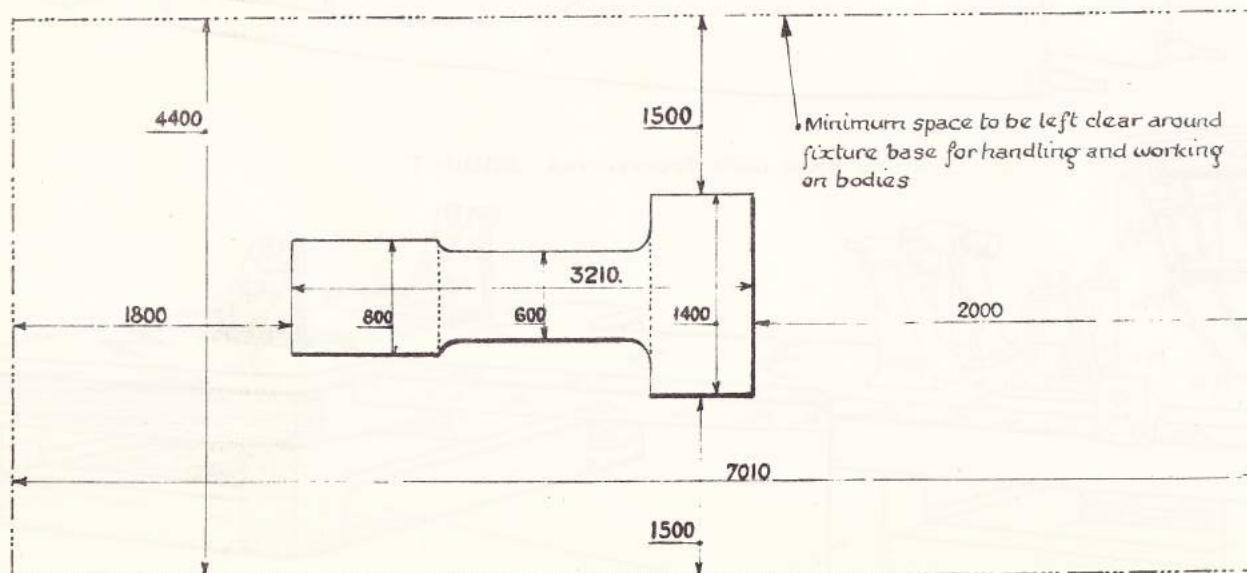
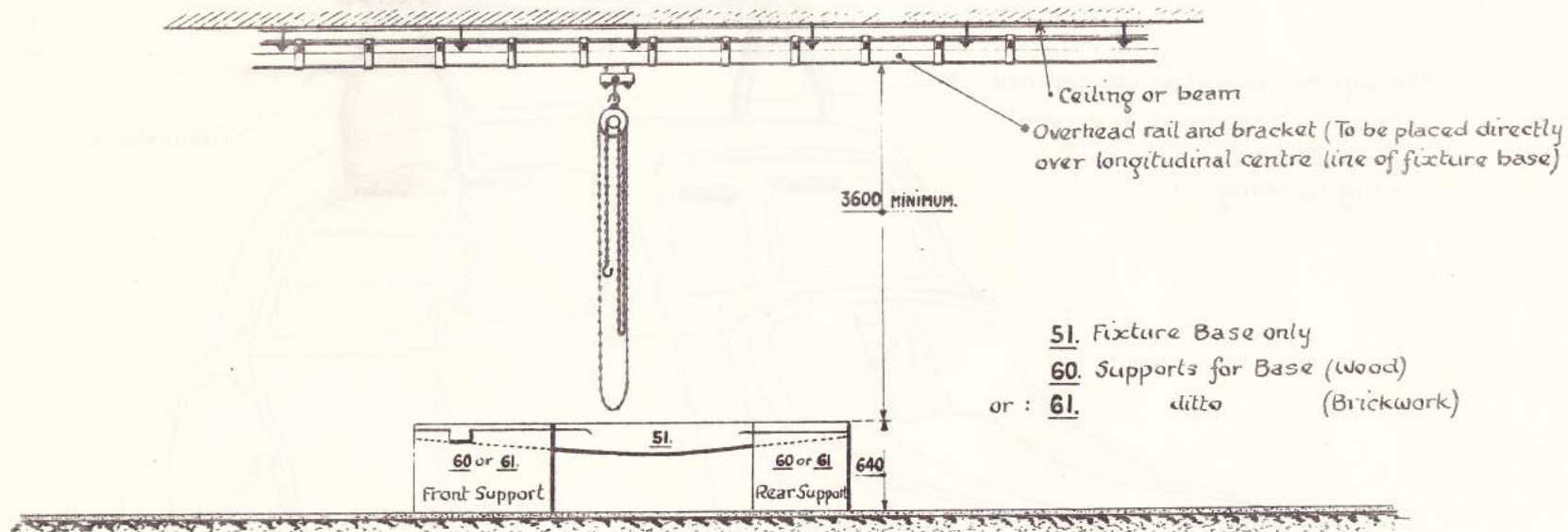


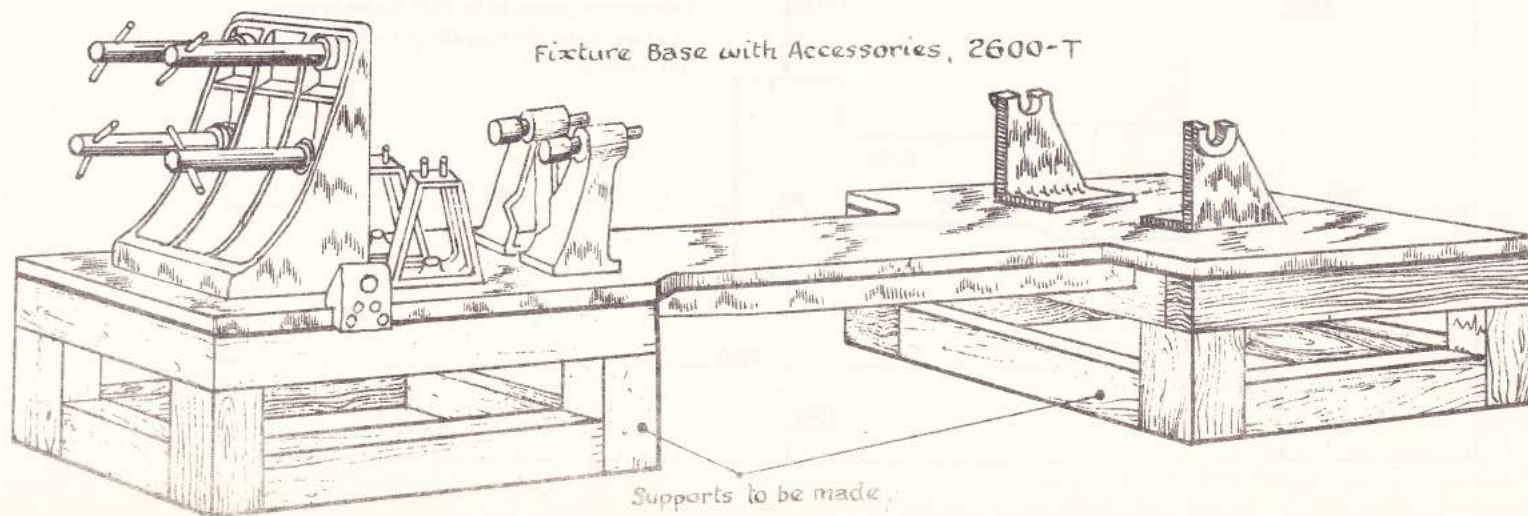
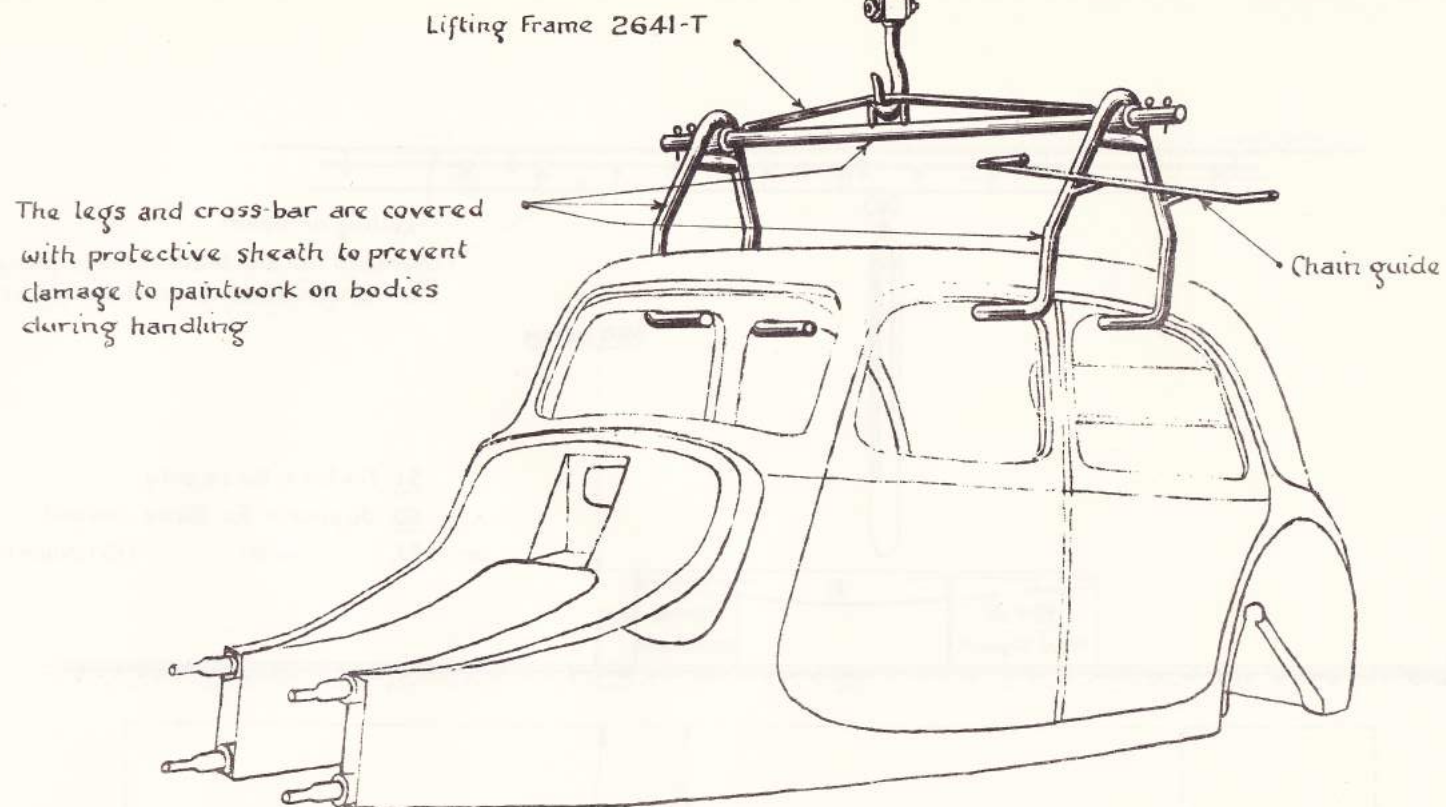
Fixture Base with Accessories, 2600-T

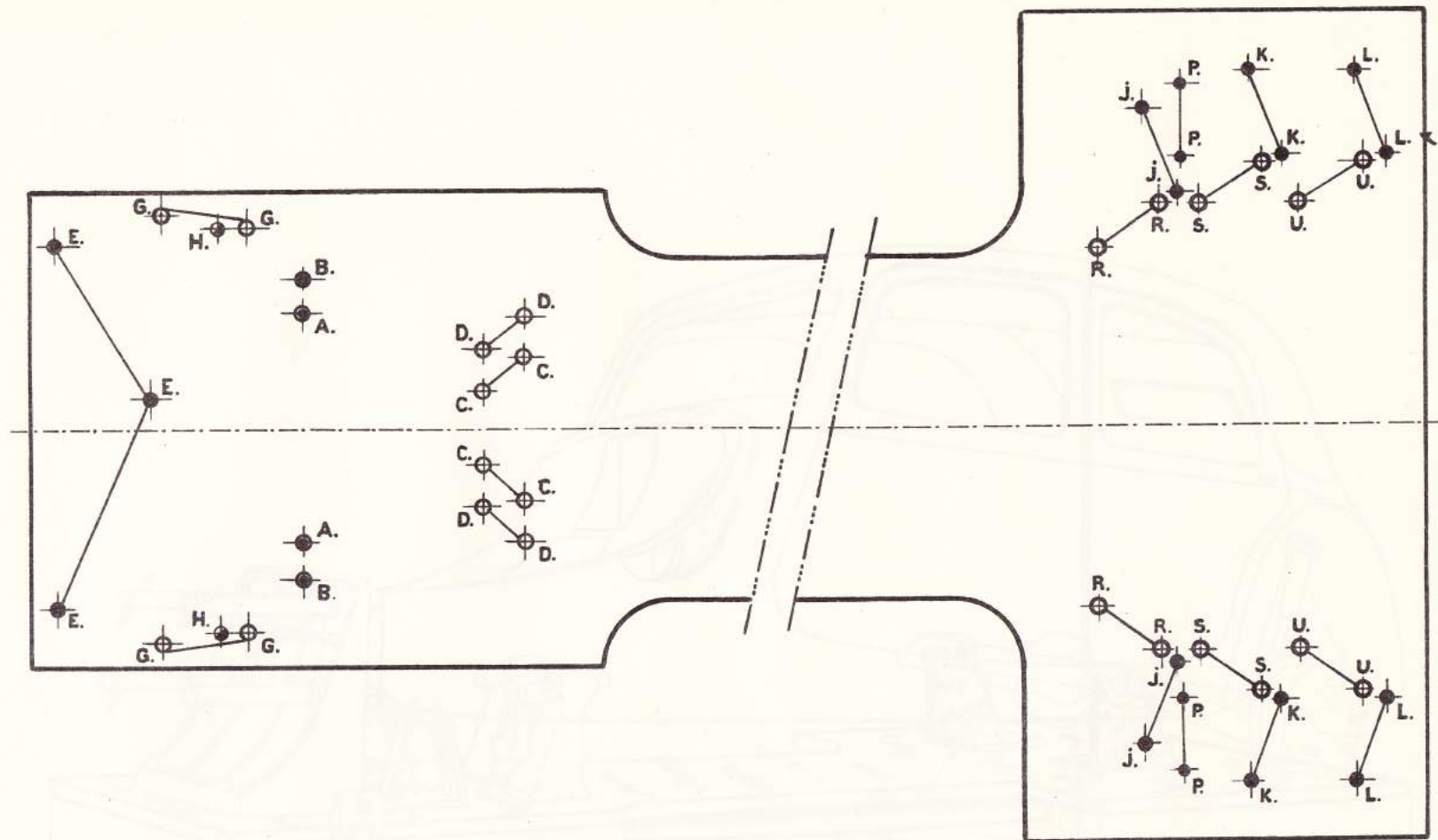


Supports to be made

— INSTALLATION OF FIXTURE BASE —







Holes A : For supports : 6 for "Twelve" and "Light Fifteen"
 Holes B : For supports : 6 for "Big Fifteen" and "Fifteen seven-seater"
 Holes C : For supports : 54 for "Twelve" and "Light Fifteen"
 Holes D : For supports : 54 for "Big Fifteen" and "Fifteen seven-seater"
 Holes E : For front bracket : 45 in 'work' position only
 Holes G : For slides : 20 and 21 for front bracket 45 in 'check' position
 Holes H : For blocks : 56 for front bracket 45 in 'work' position

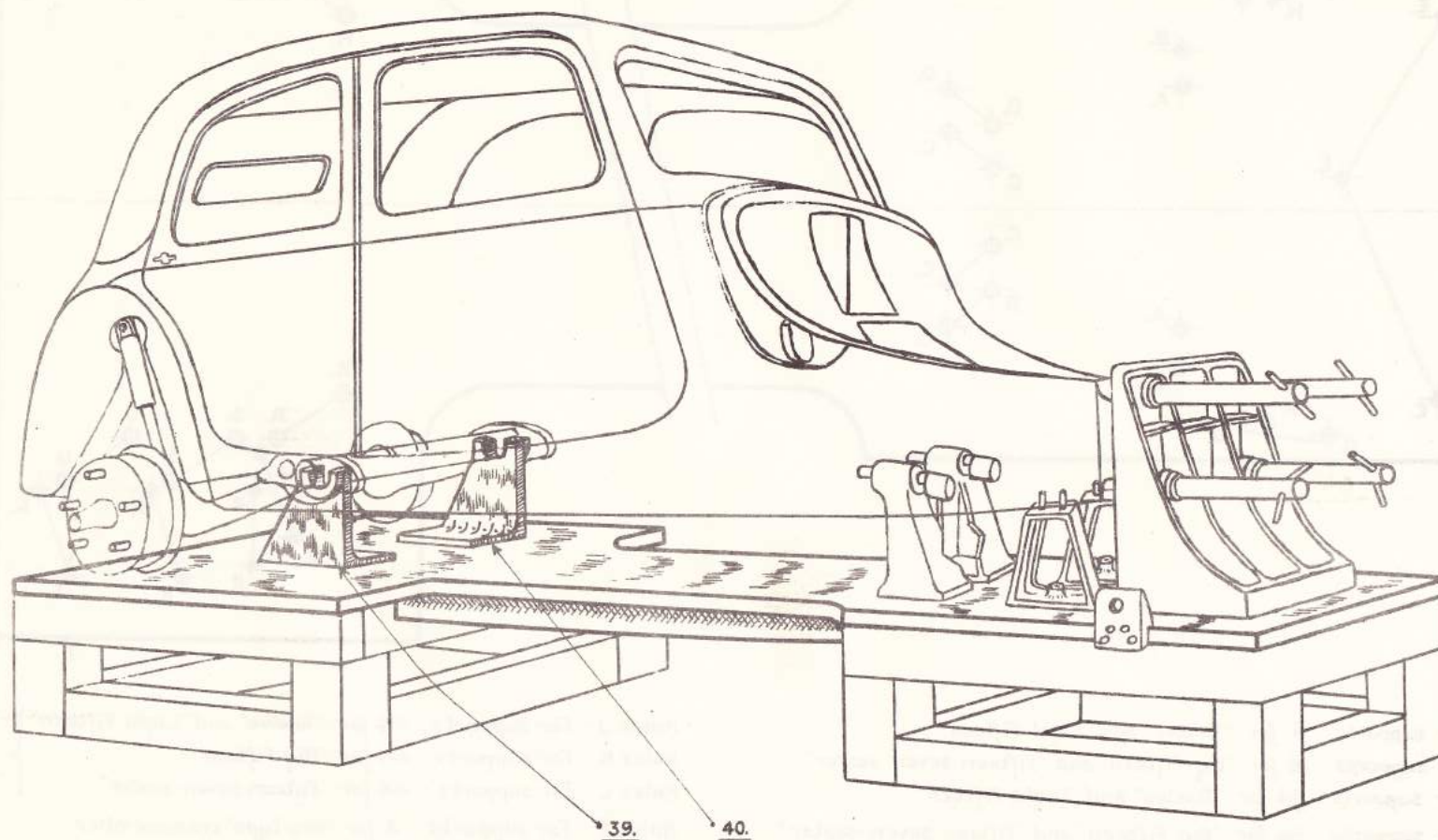
Holes J : For supports : 44 for "Twelve" and "Light Fifteen"
 Holes K : For supports : 44 for "Big Fifteen"
 Holes L : For supports : 44 for "Fifteen seven-seater"
 Holes P : For supports : 4 for 'box-type' crossmember
 Holes R : For supports : 39 and 40 for "Twelve" and "Light Fifteen"
 Holes S : For supports : 39 and 40 for "Big Fifteen"
 Holes U : For supports : 39 and 40 for "Fifteen seven-seater"

Tubular cross-member removed

Tubular cross-member fitted

— USE OF FIXTURE —

— TUBULAR CROSSMEMBER NOT REMOVED —

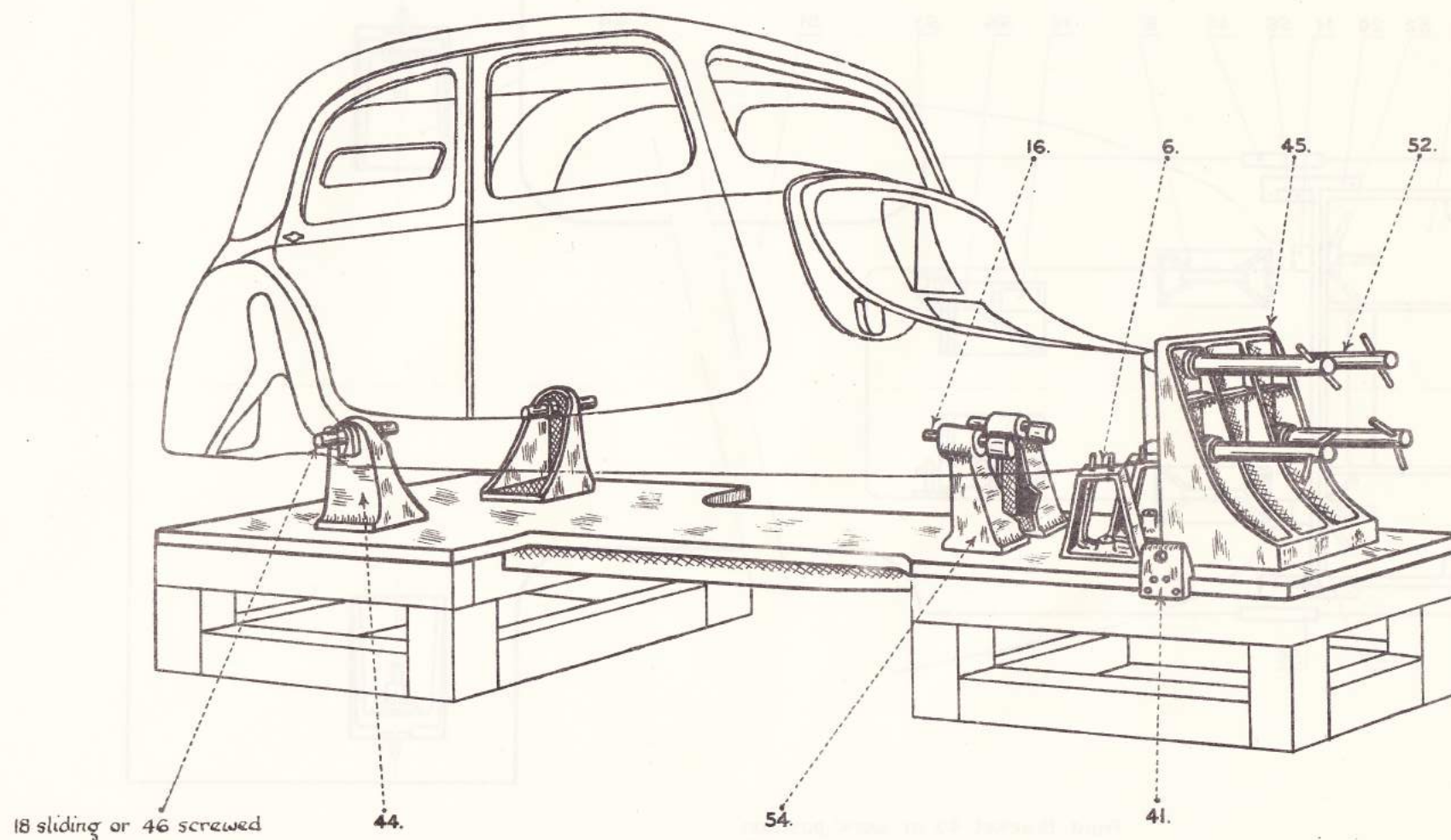


Fixture Base with Accessories 2600-T

— USE OF FIXTURE —

8

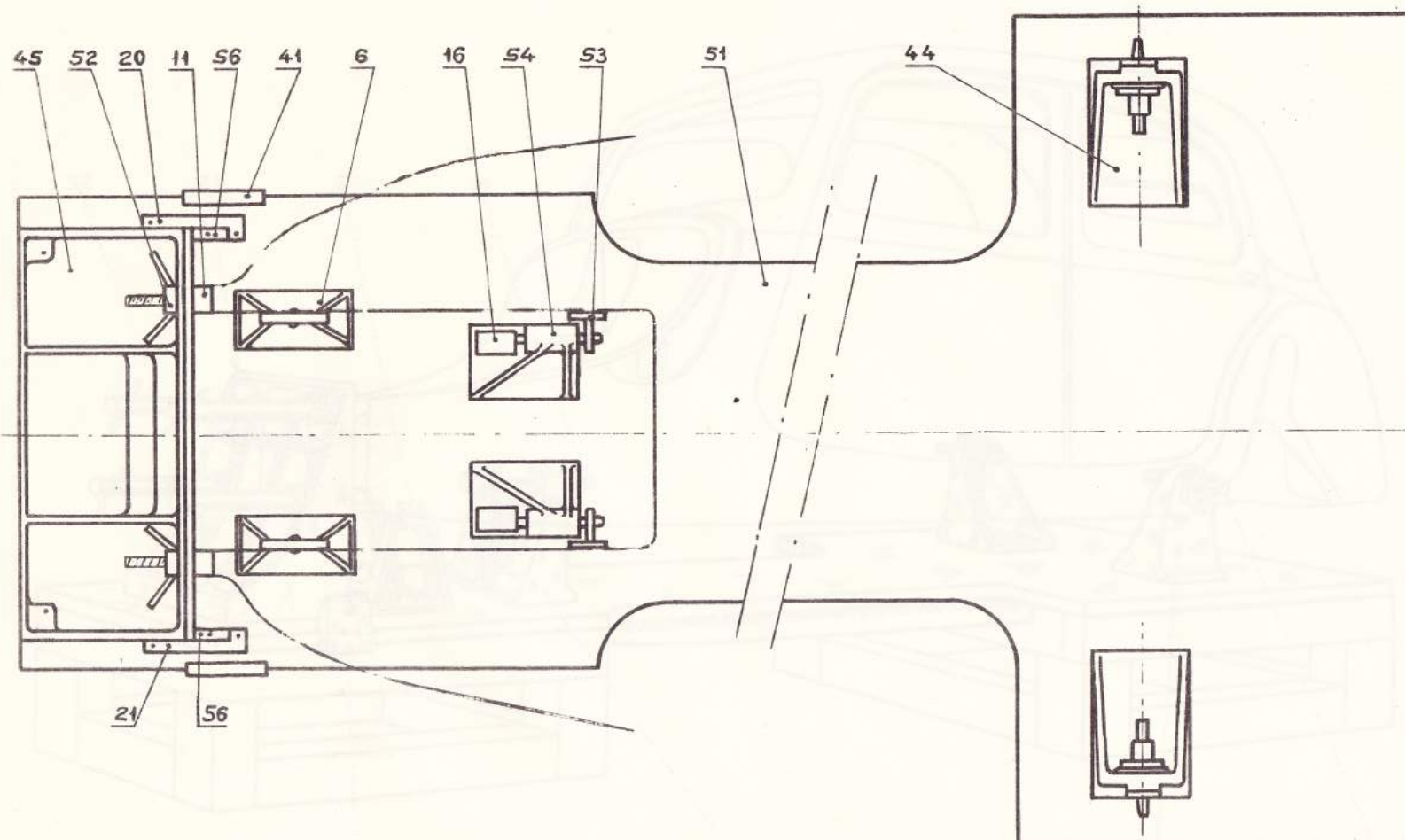
— TUBULAR CROSSMEMBER REMOVED —



Fixture Base with Accessories 2600-T

— LOCATION OF FIXTURE BRACKETS —

— TUBULAR CROSSMEMBER REMOVED —

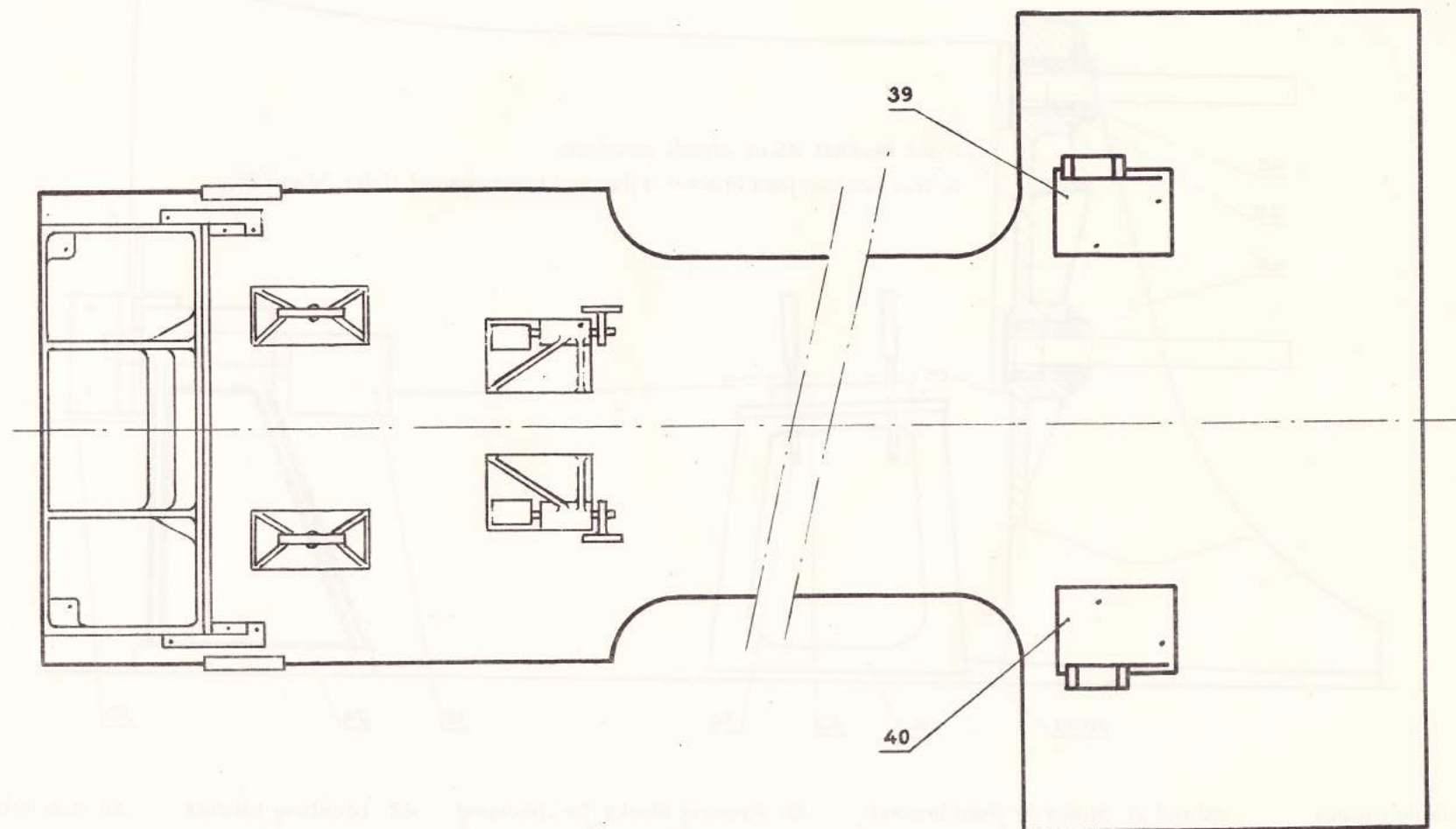


Front Bracket 45 in 'work' position

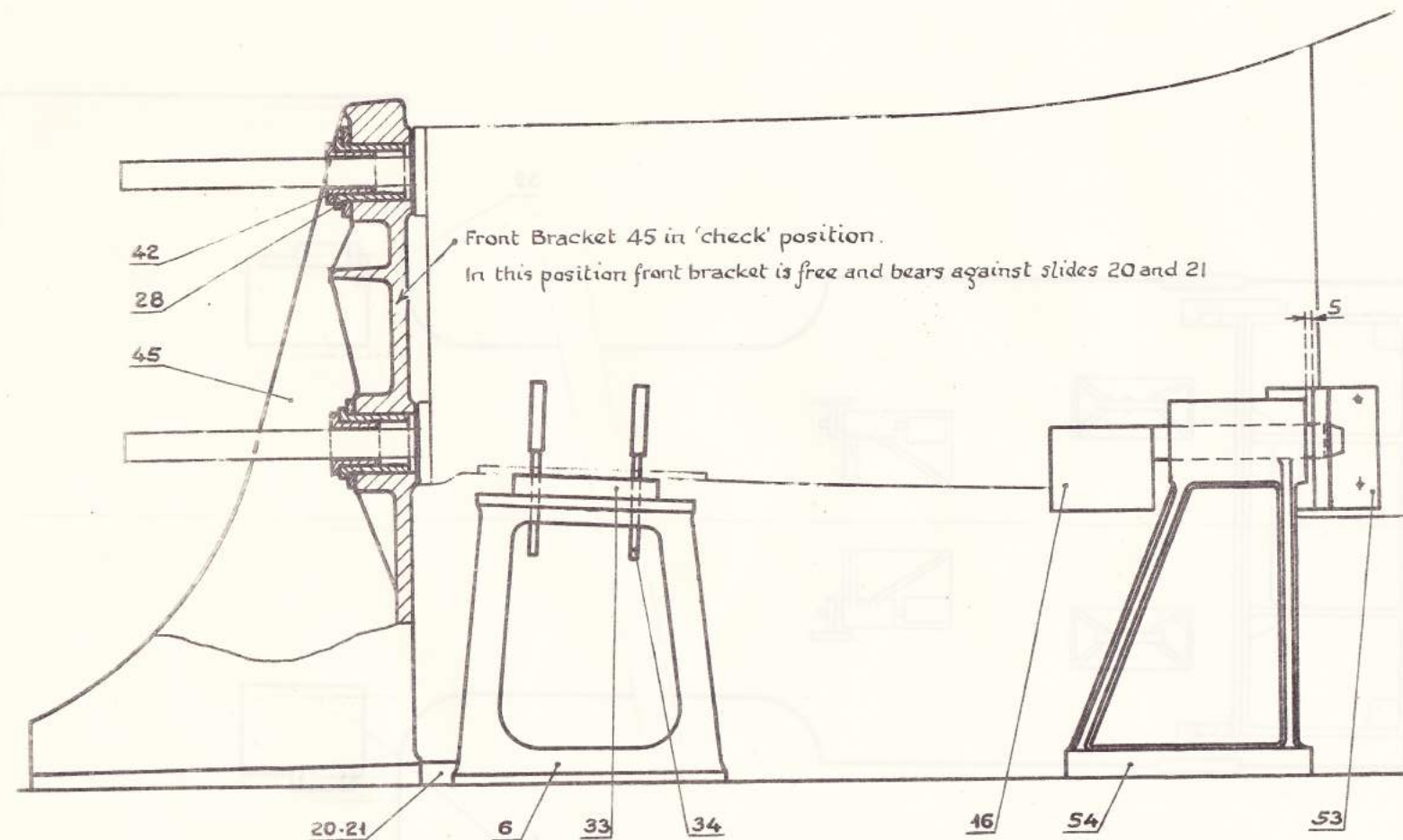
In this position the front bracket is fixed by three bolts, its position being determined by two blocks 56. The two 'open-type' distance pieces 11 act as spacers between front bracket and hull in the 'work' position.

—— LOCATION OF FIXTURE BRACKETS ——

—— TUBULAR CROSSMEMBER NOT REMOVED ——



CHECKING HULL FRONT END



6. Checking gauges

20 and 21. Slides for front bracket

33. Packing blocks for checking

42. Locating bushes

53. Brackets on hull

16. Pins

28. Checking bushes

34. Checking pins

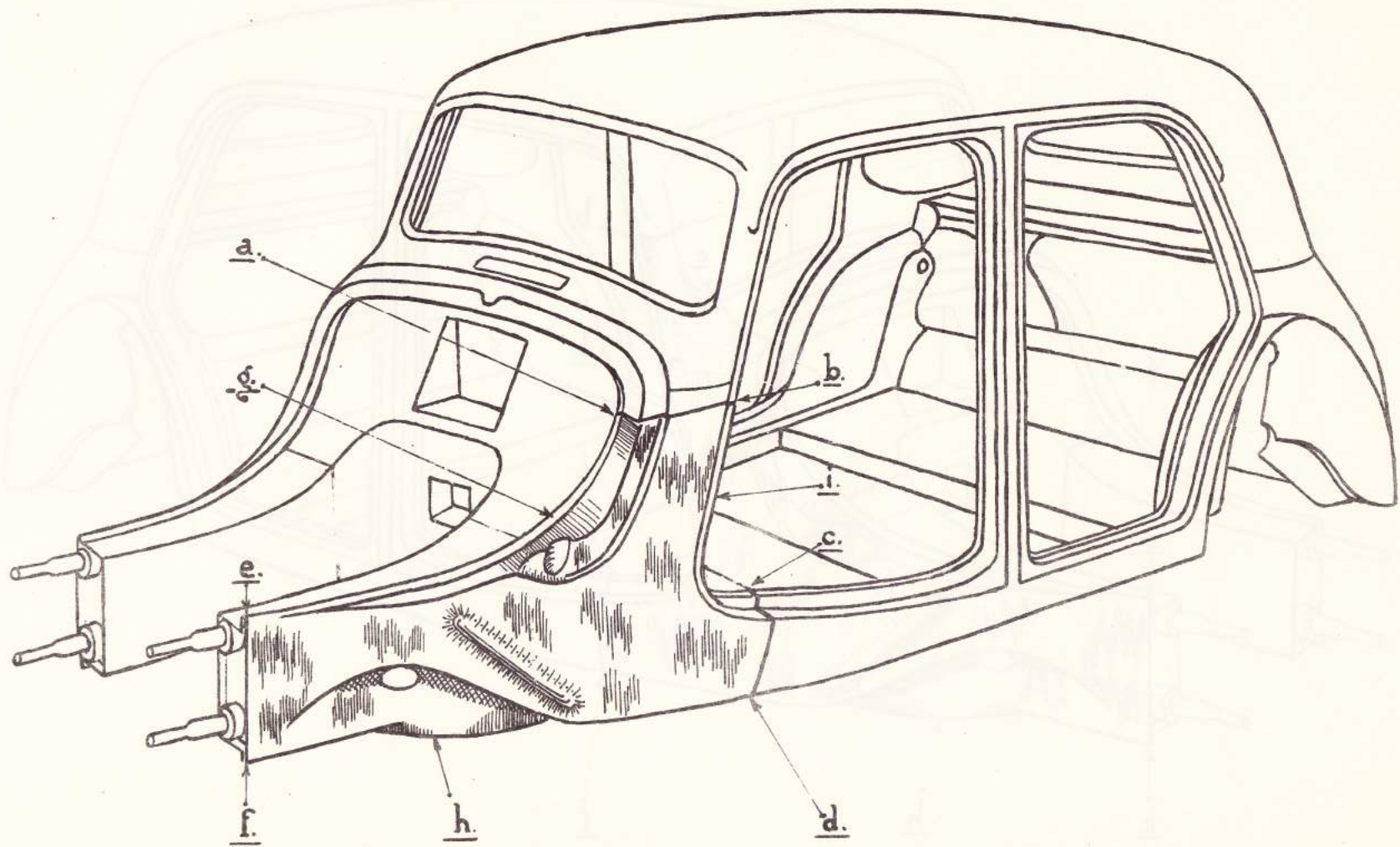
45. Front bracket

54. Brackets on fixture base

— REMOVING AND FITTING SIDE PANEL FRONT LOWER PORTION —

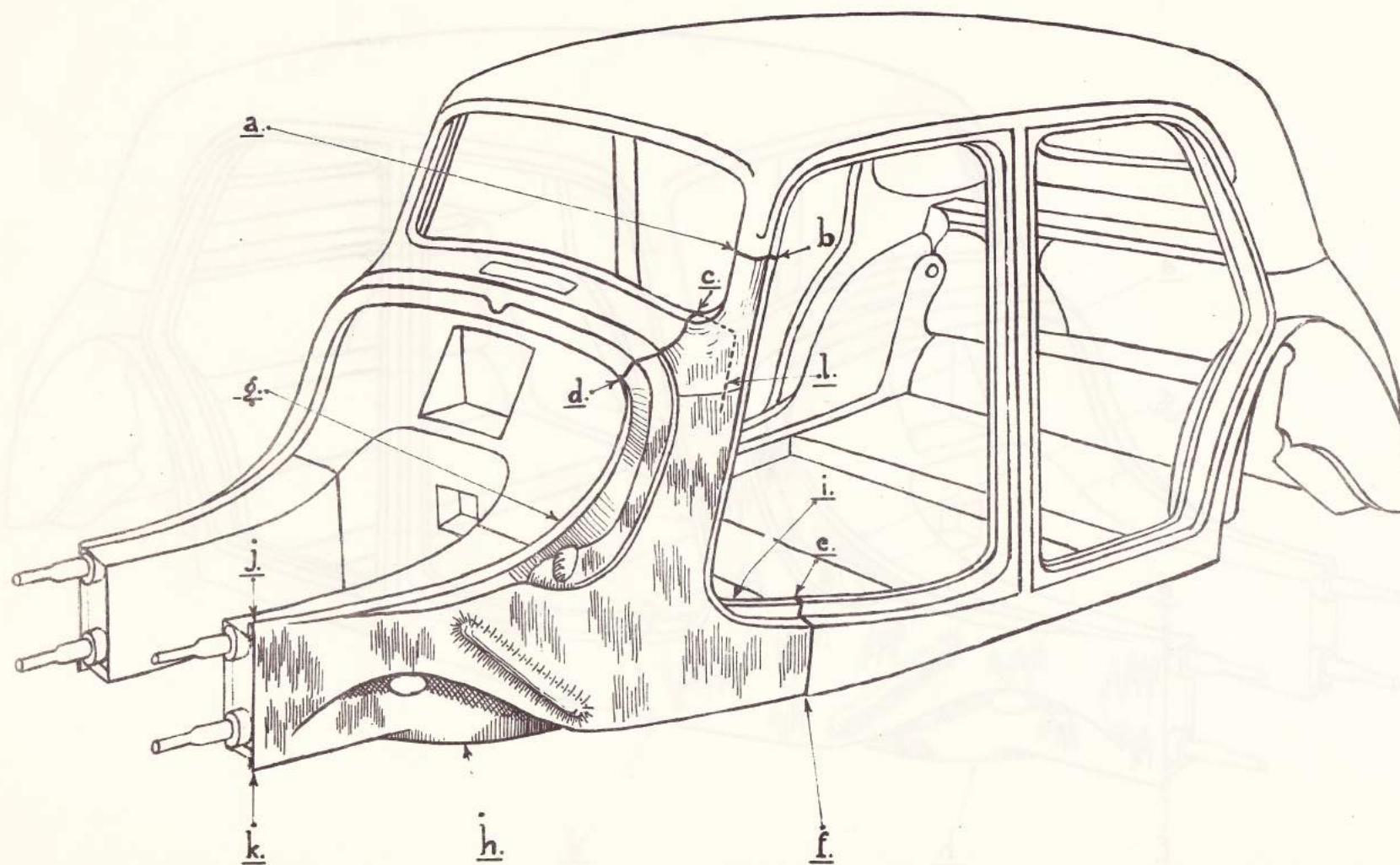
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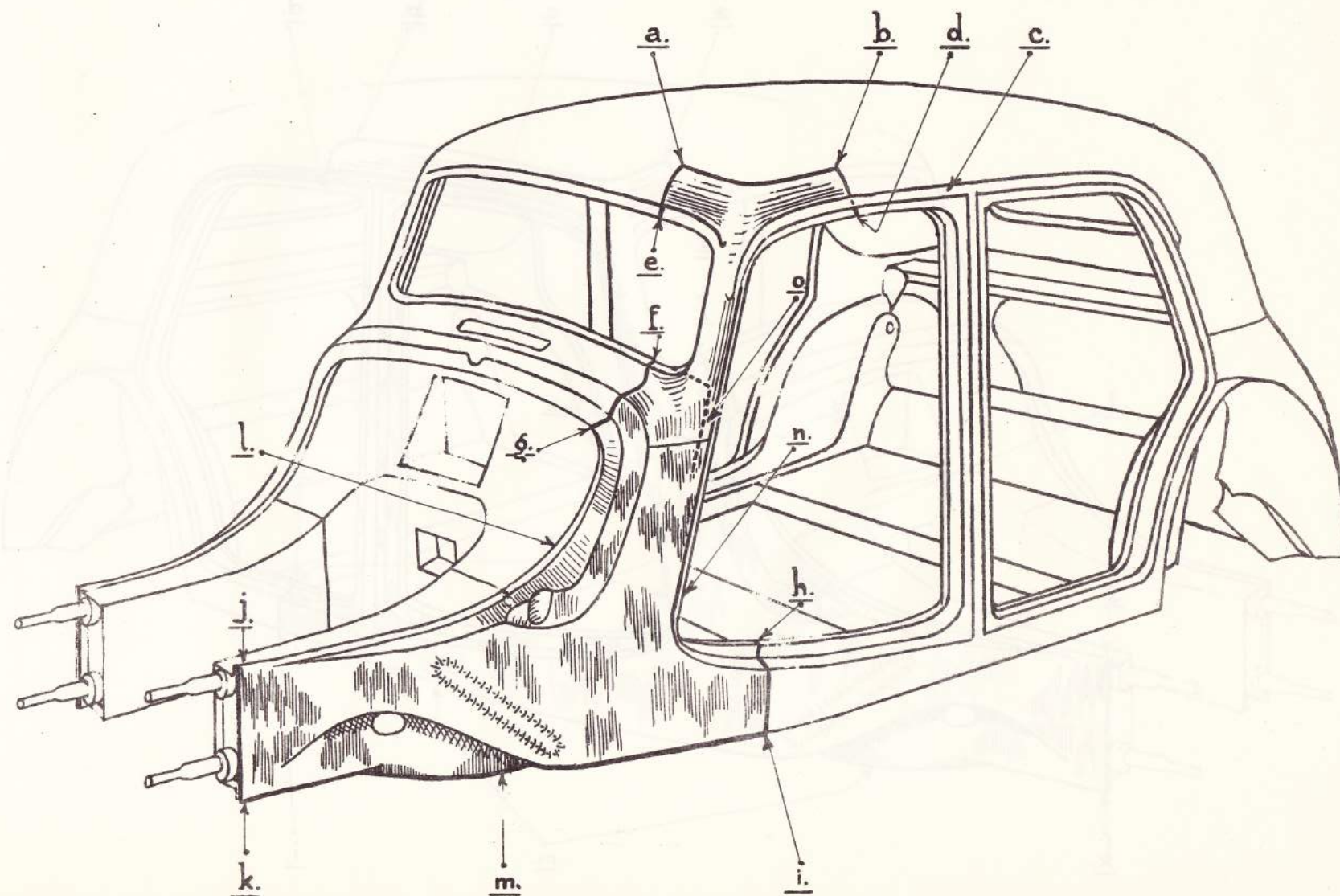
— CUT UNDER SCUTTLE PANEL MOULDING —

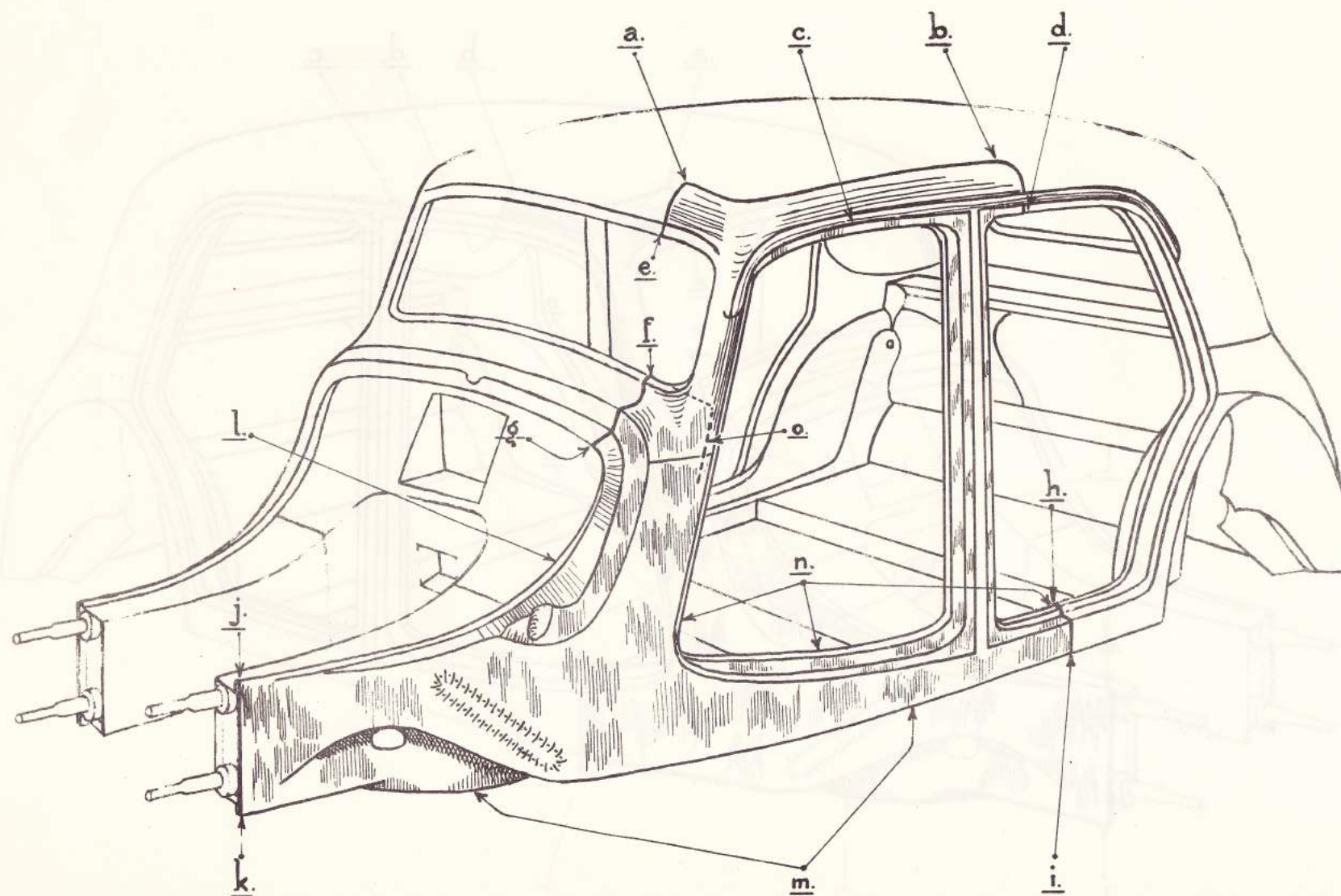


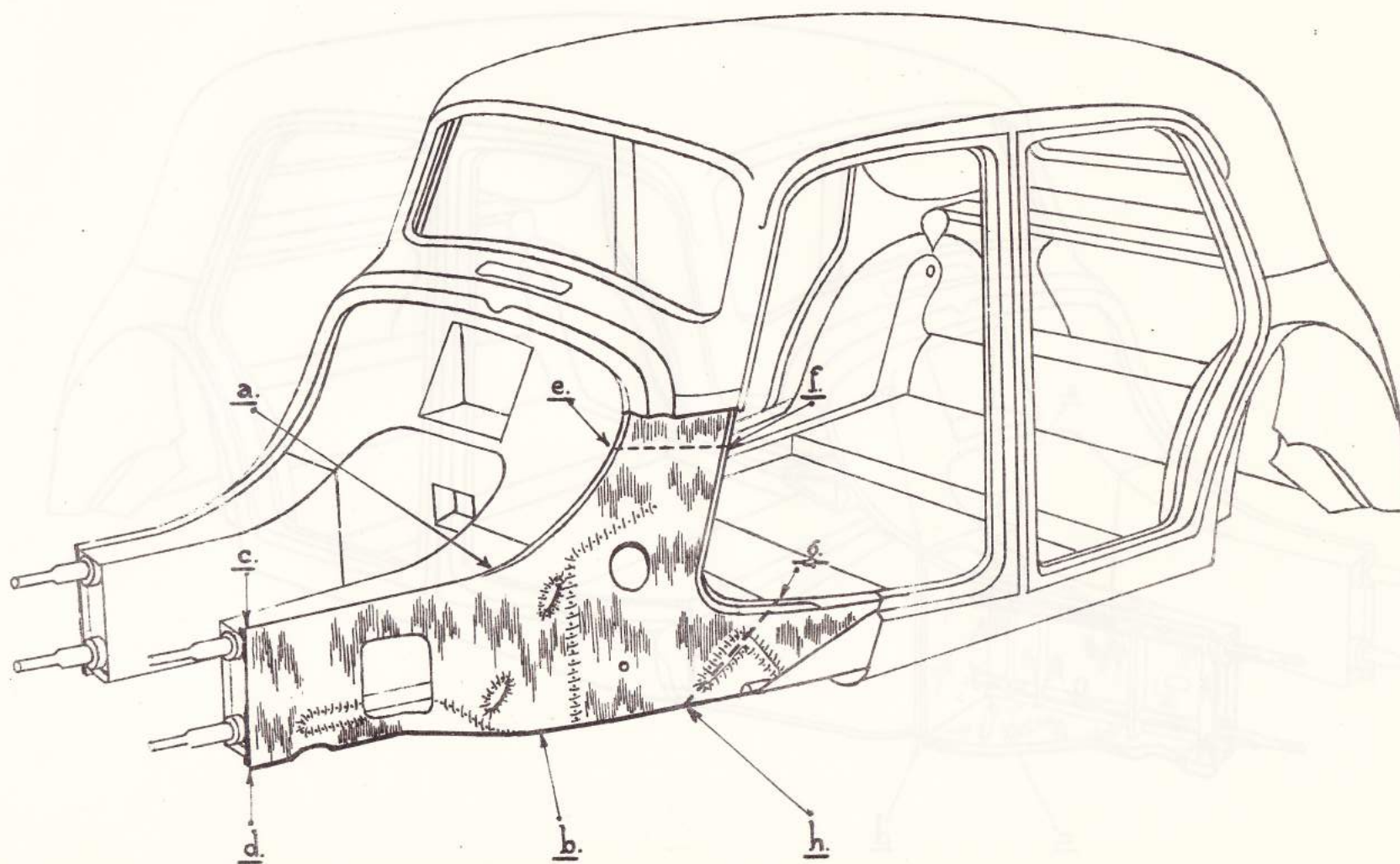
REMOVING AND FITTING SIDE PANEL FRONT LOWER PORTION

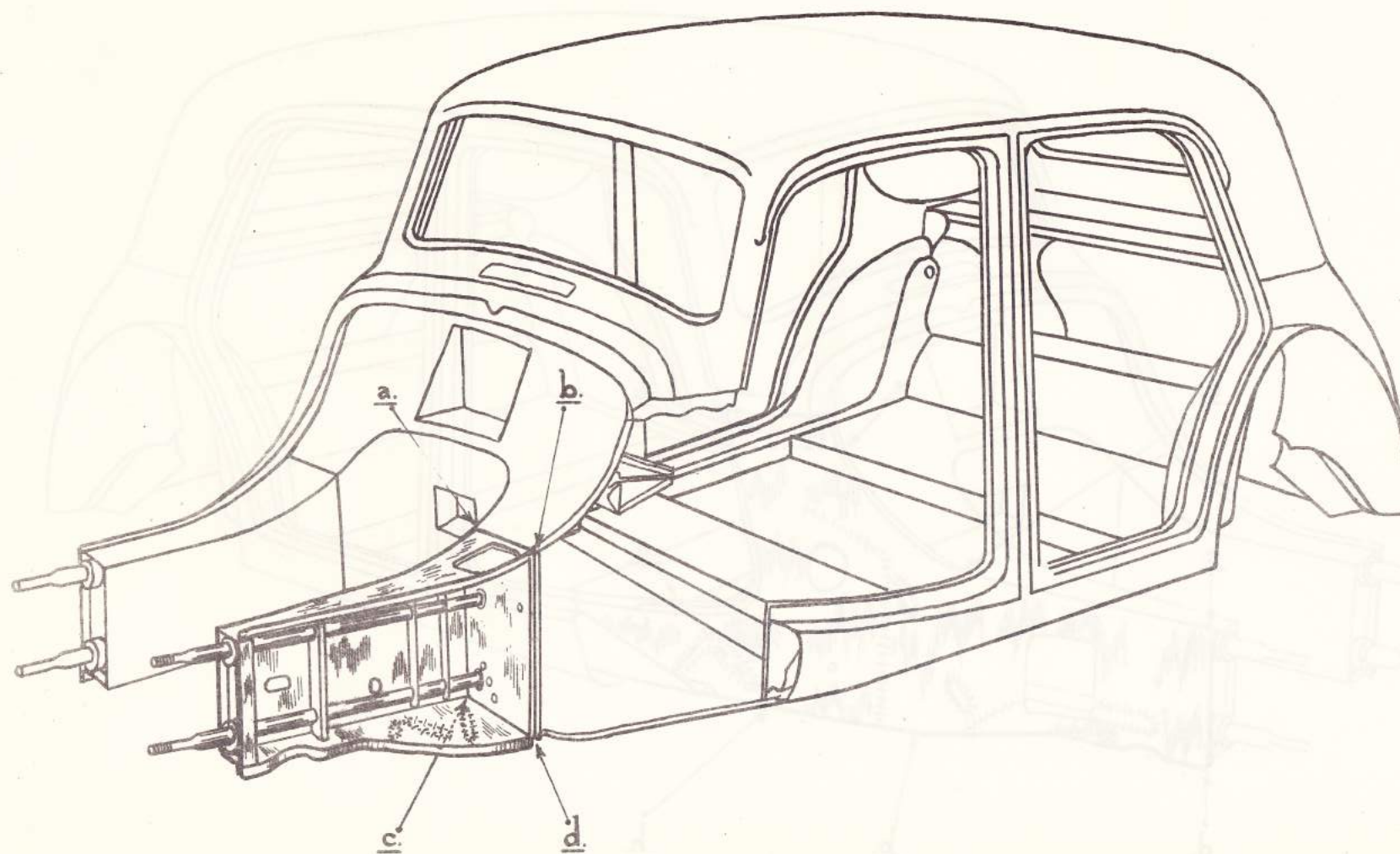
CUT THROUGH WINDSCREEN PILLAR

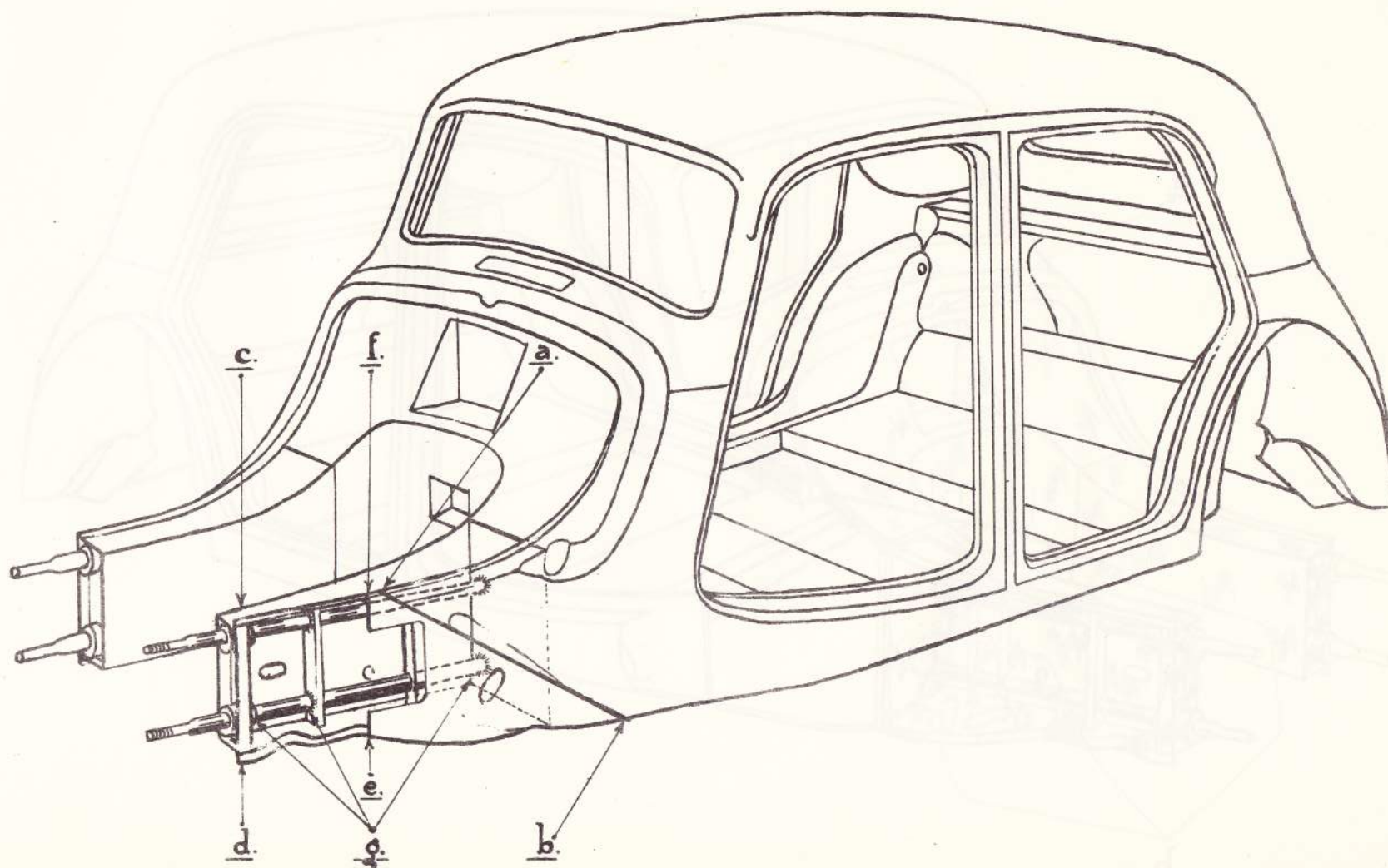






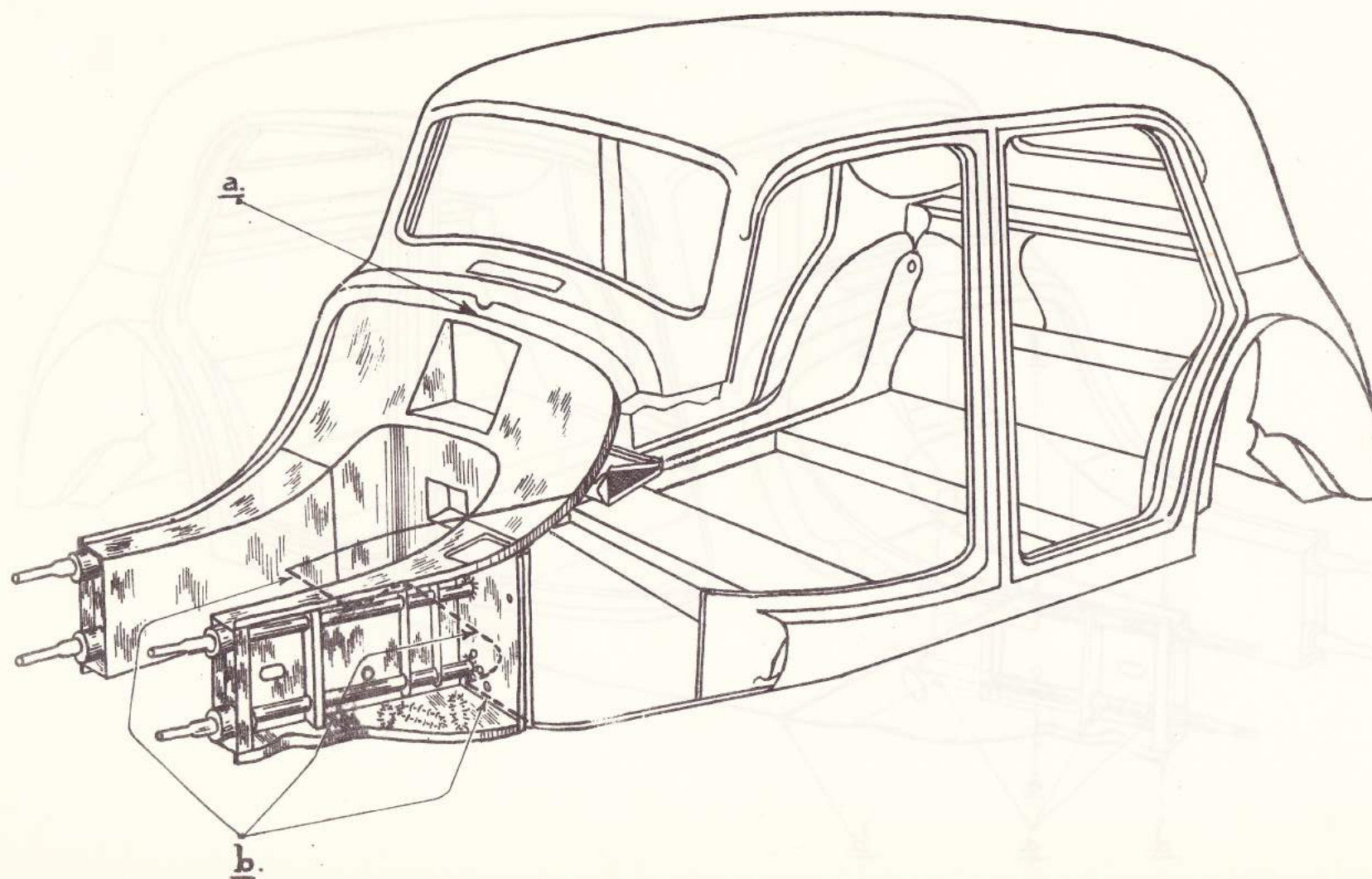




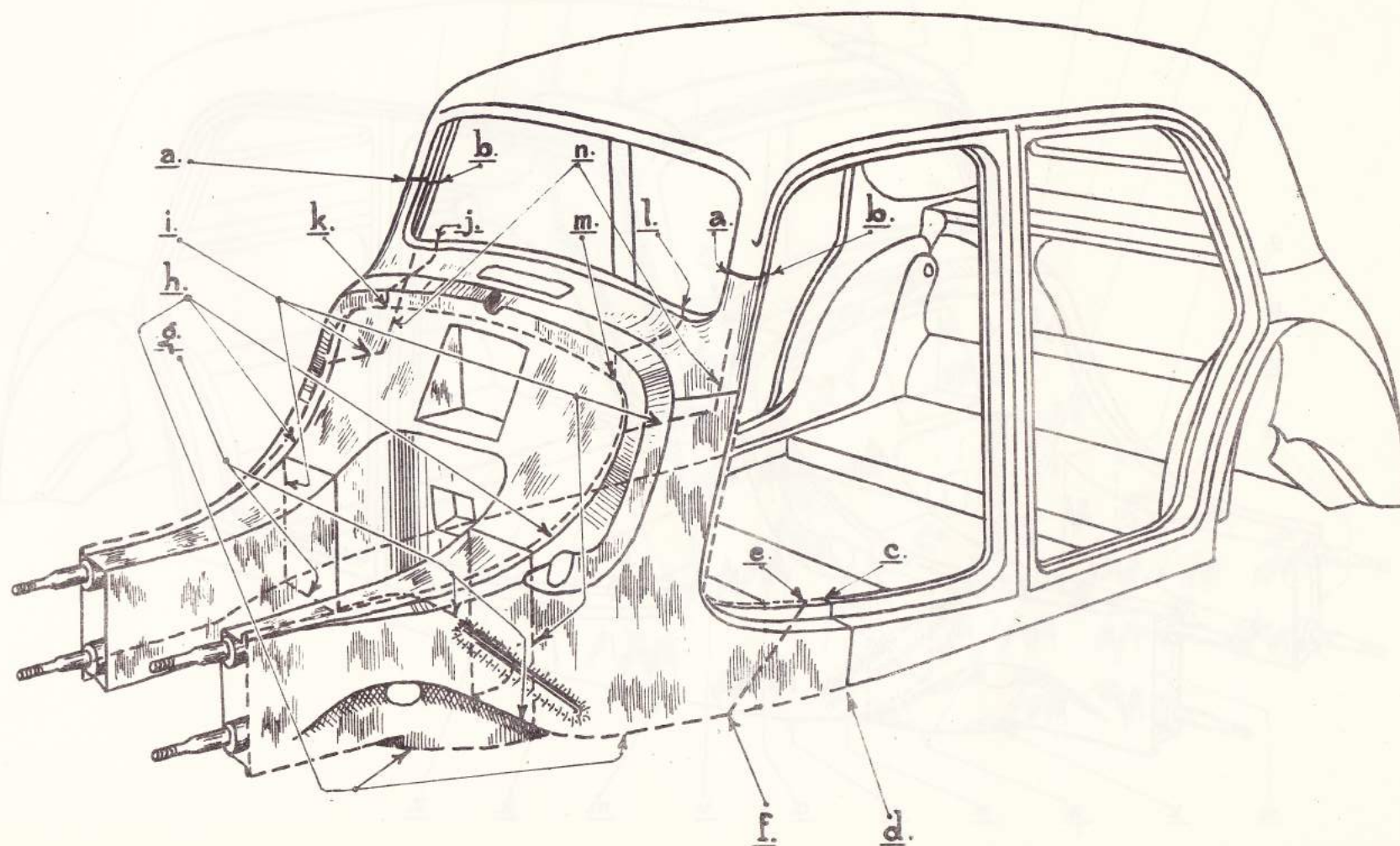


REMOVING AND FITTING HULL FRONT ASSEMBLY

CUT ALONG SCUTTLE LINE

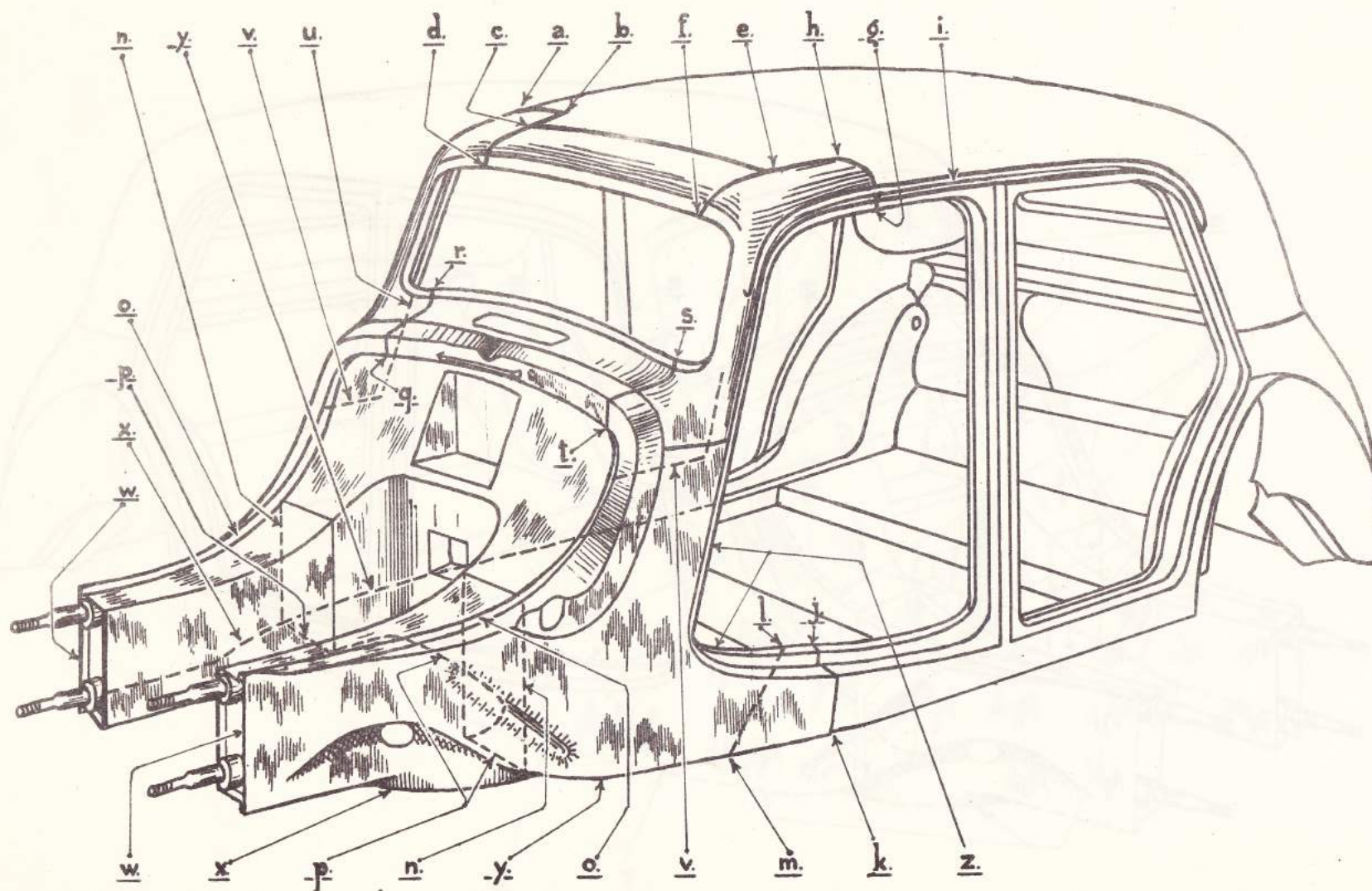


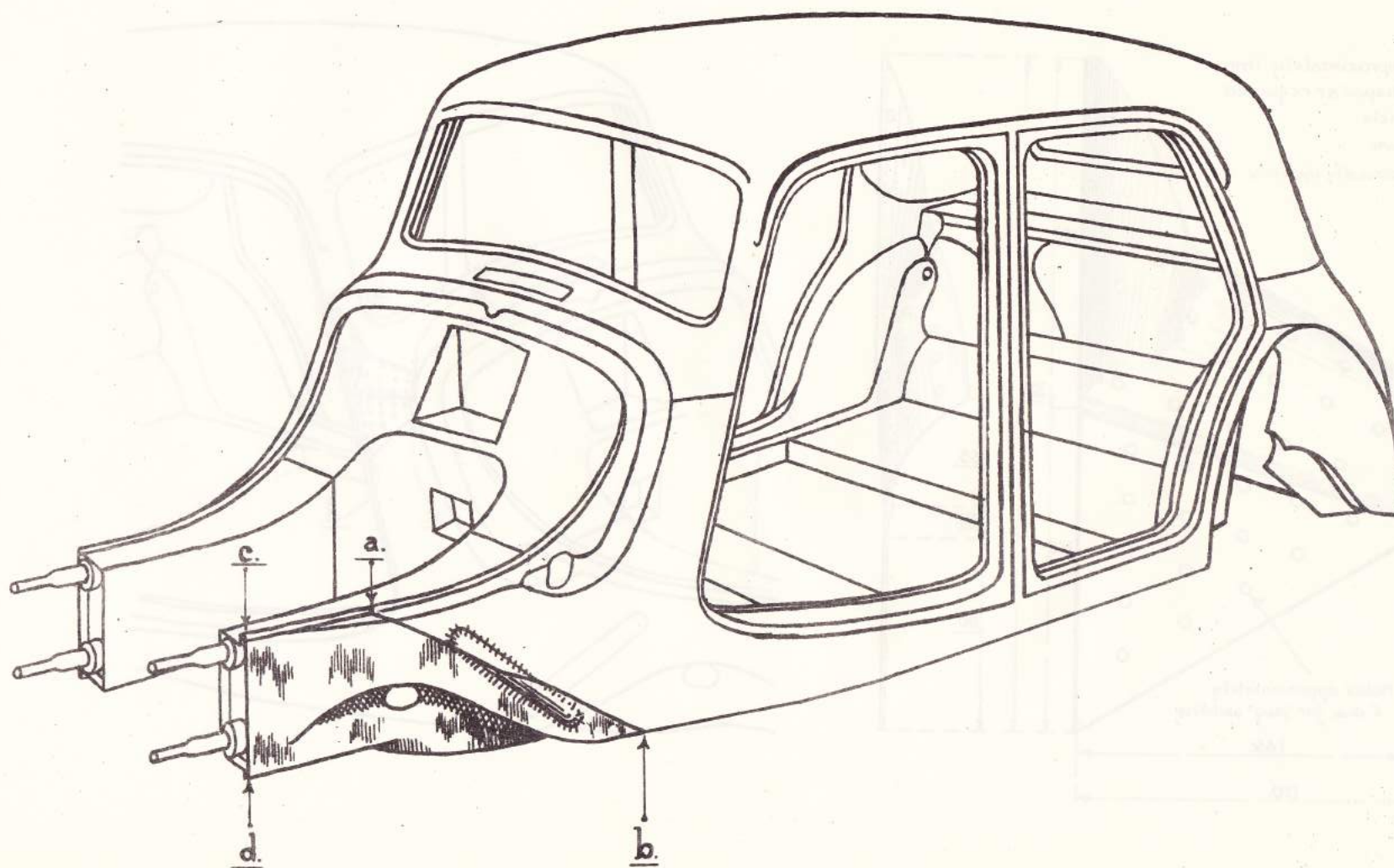
CUT THROUGH WINDSCREEN PILLARS



REMOVING AND FITTING BODY FRONT ASSEMBLY

CUT ACROSS ROOF SIDE RAILS





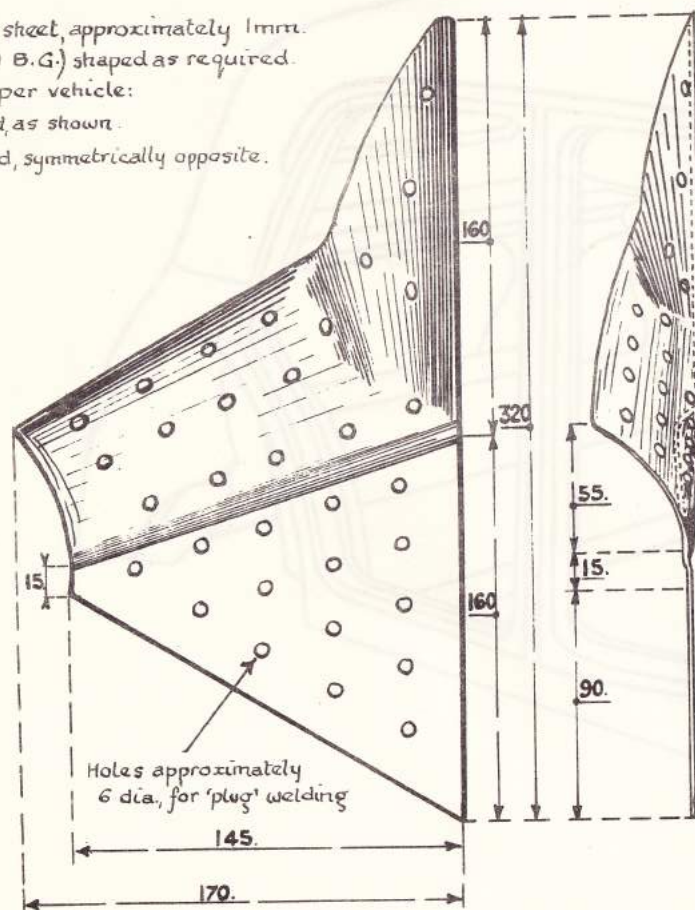
— Fig. 1. —

Mild steel sheet, approximately 1mm.
thick (*20 B.G.) shaped as required.

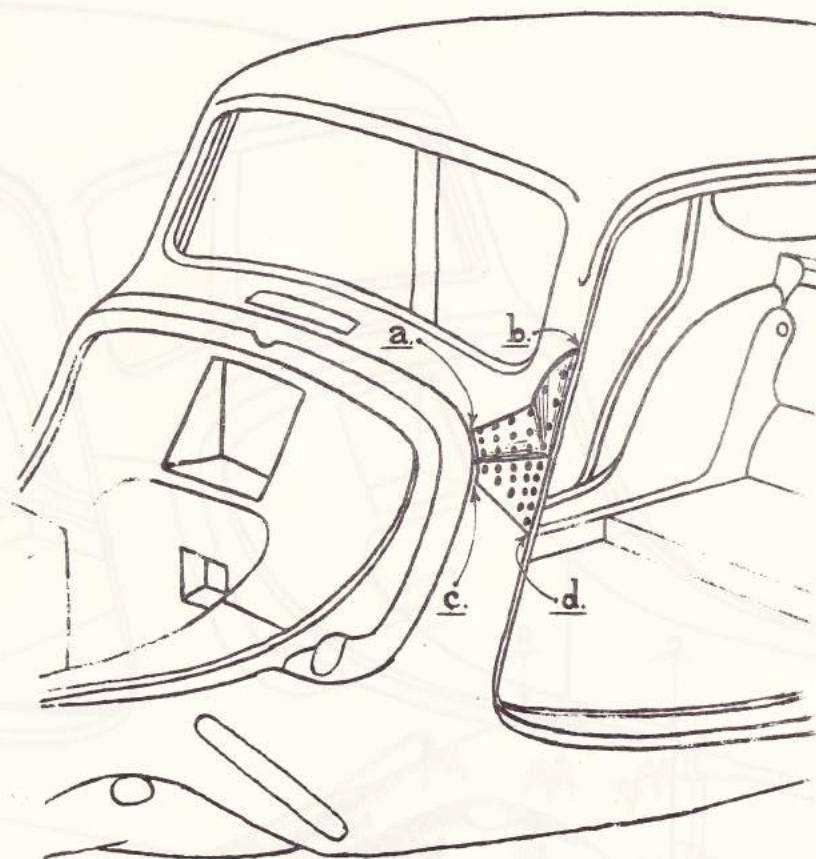
2 per vehicle:

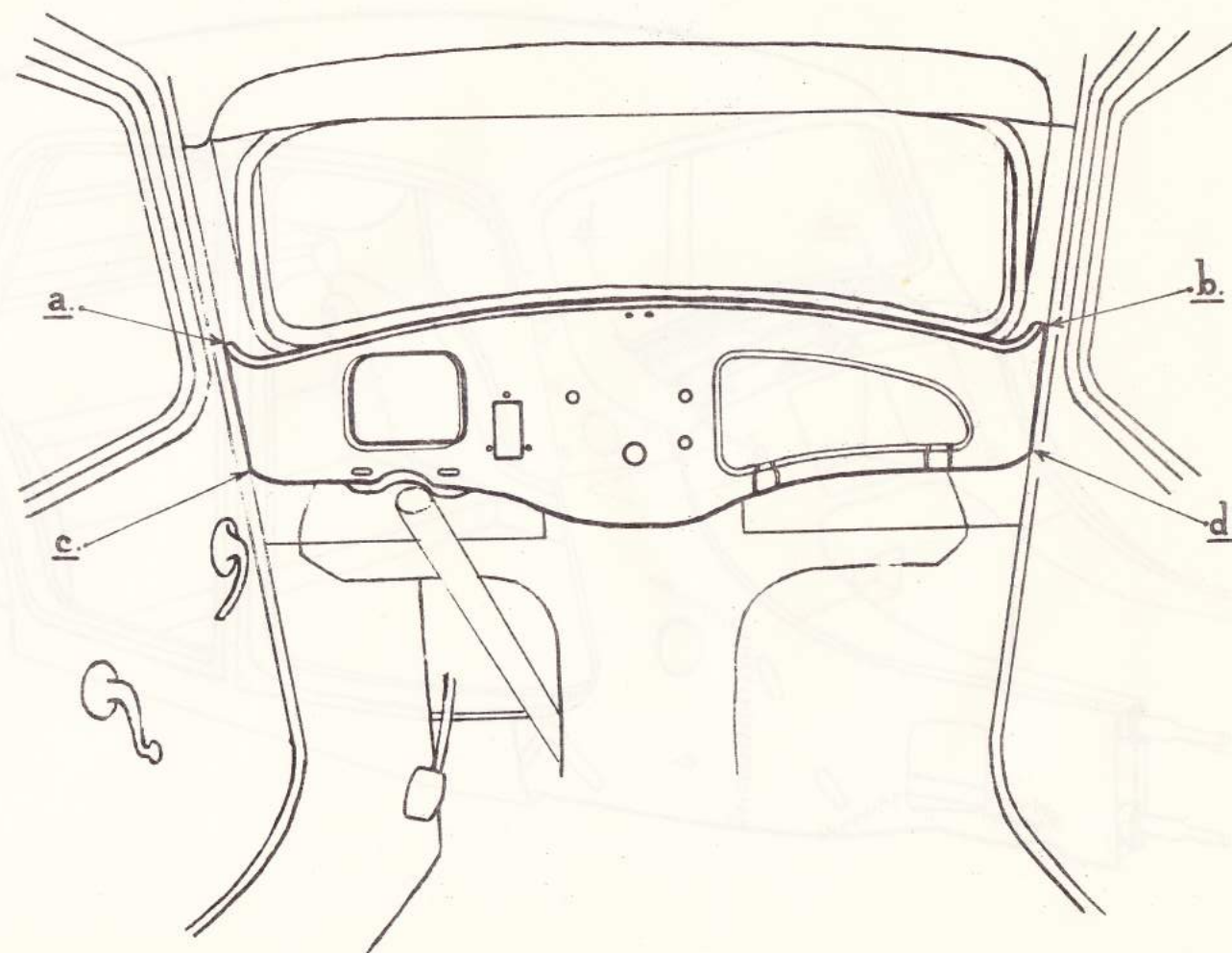
1, Left hand, as shown.

1, Right hand, symmetrically opposite.



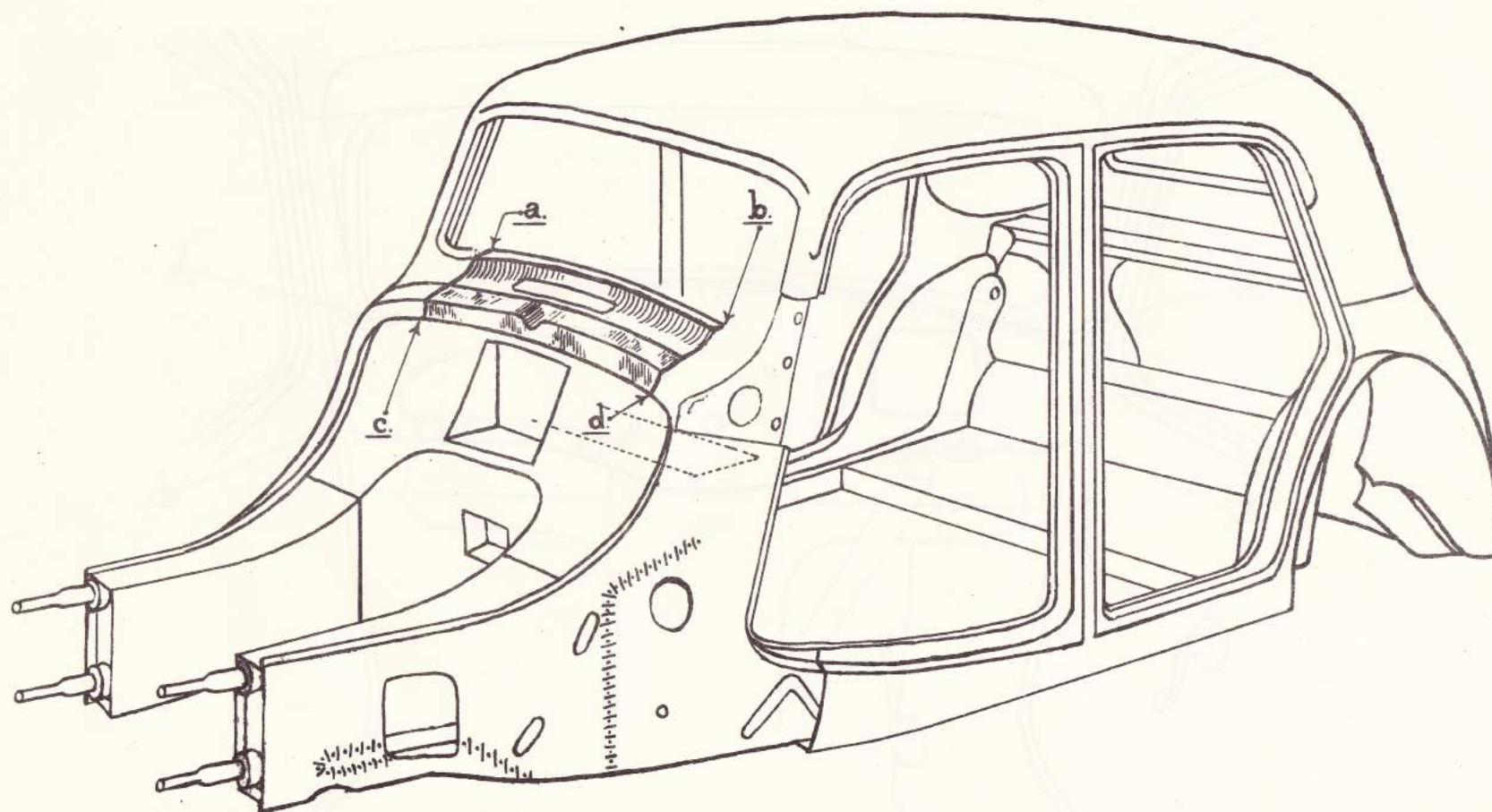
— Fig. 2. —

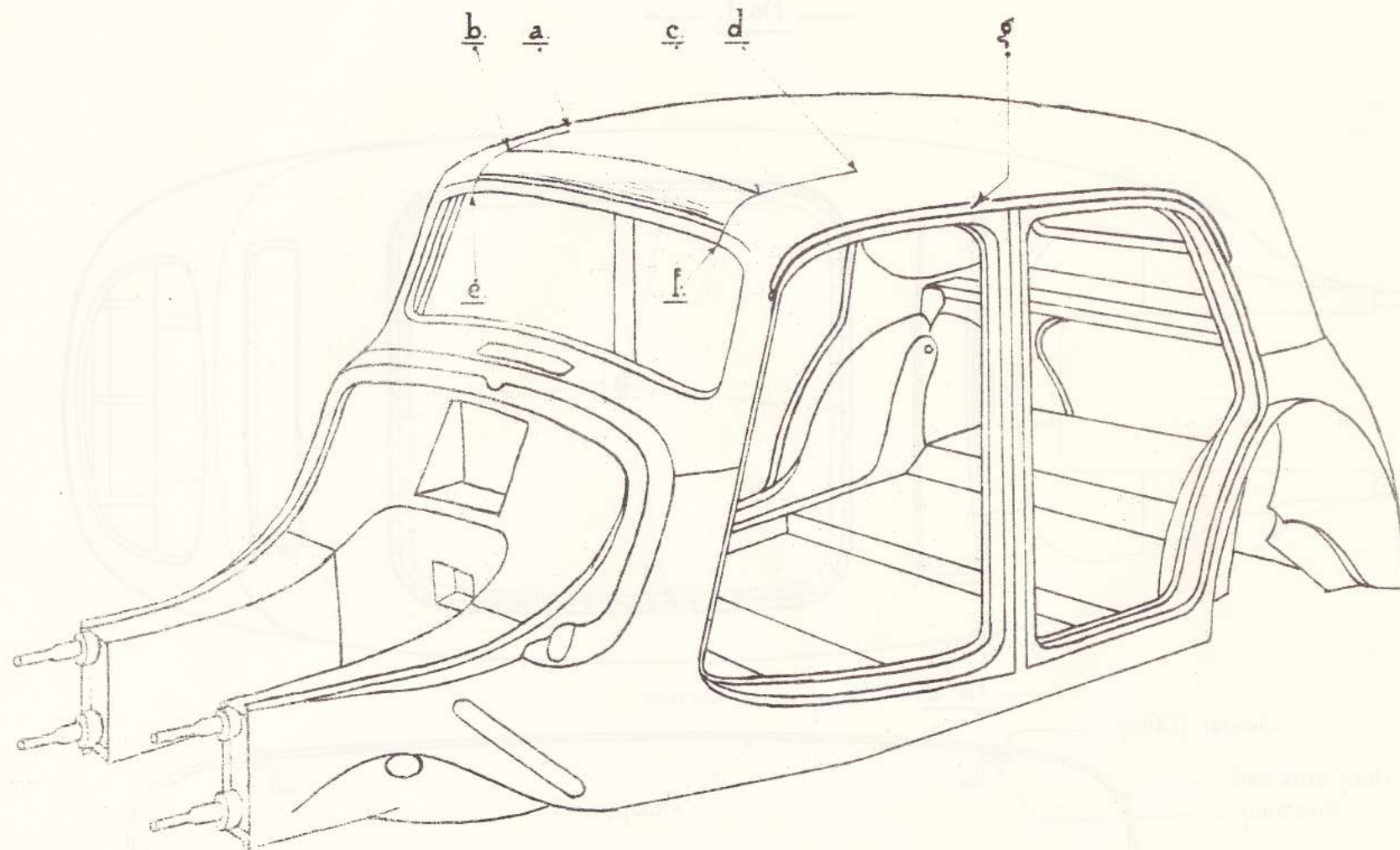


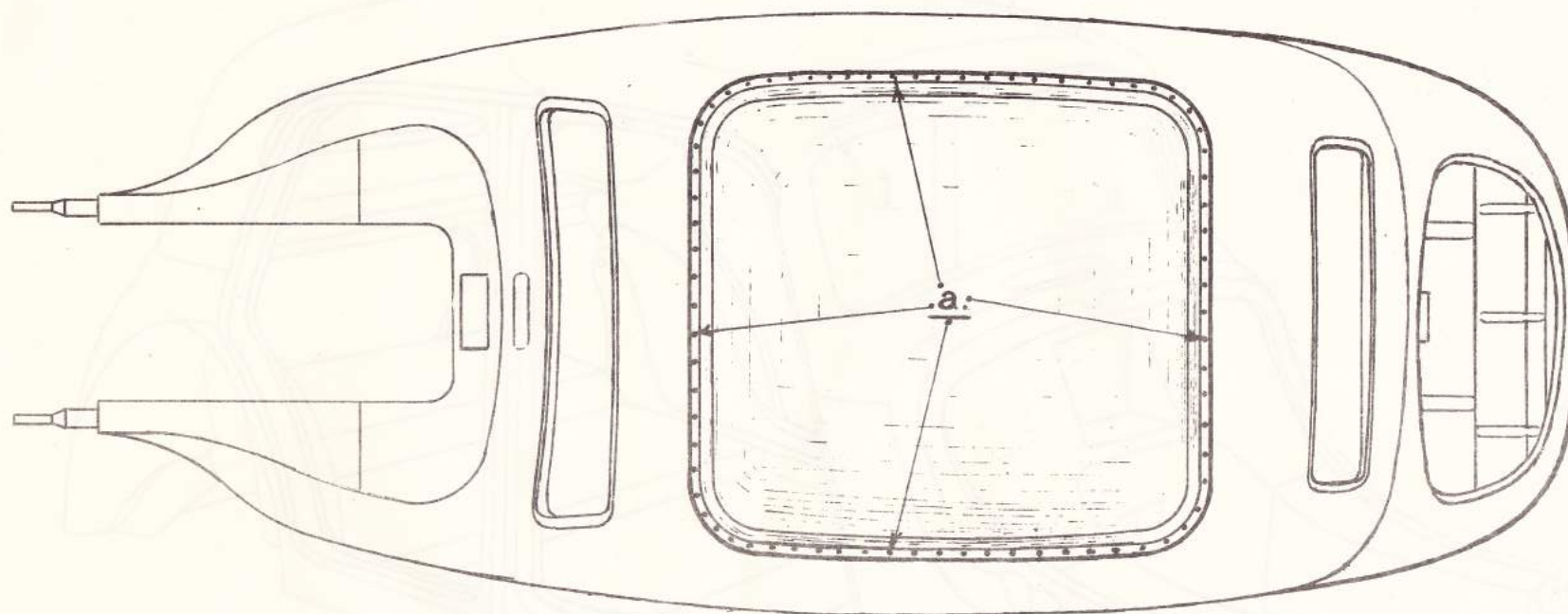
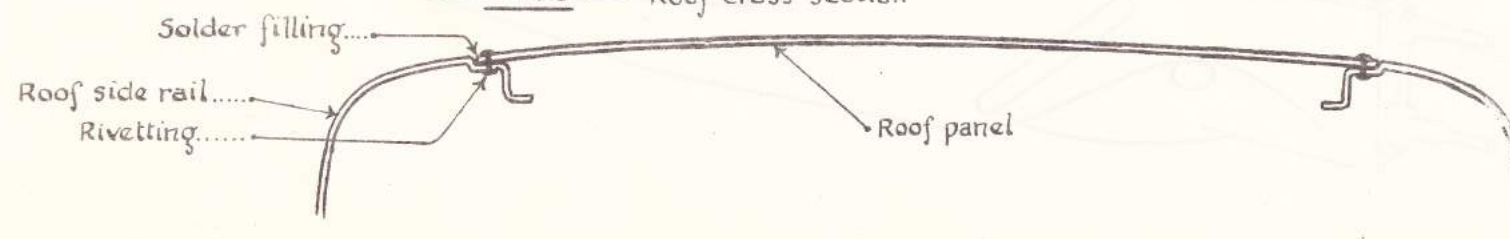


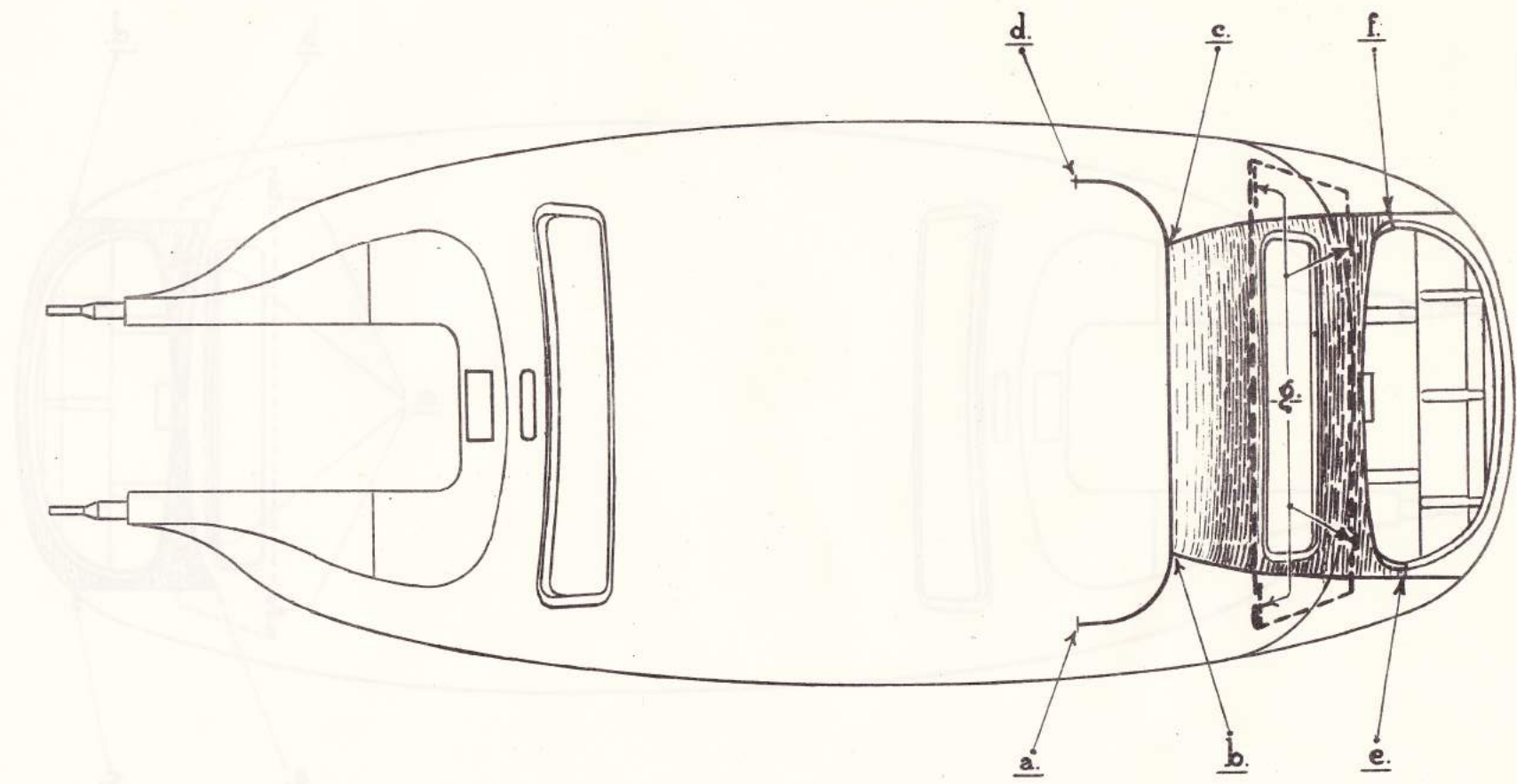
— REMOVING AND FITTING SCUTTLE PANEL —

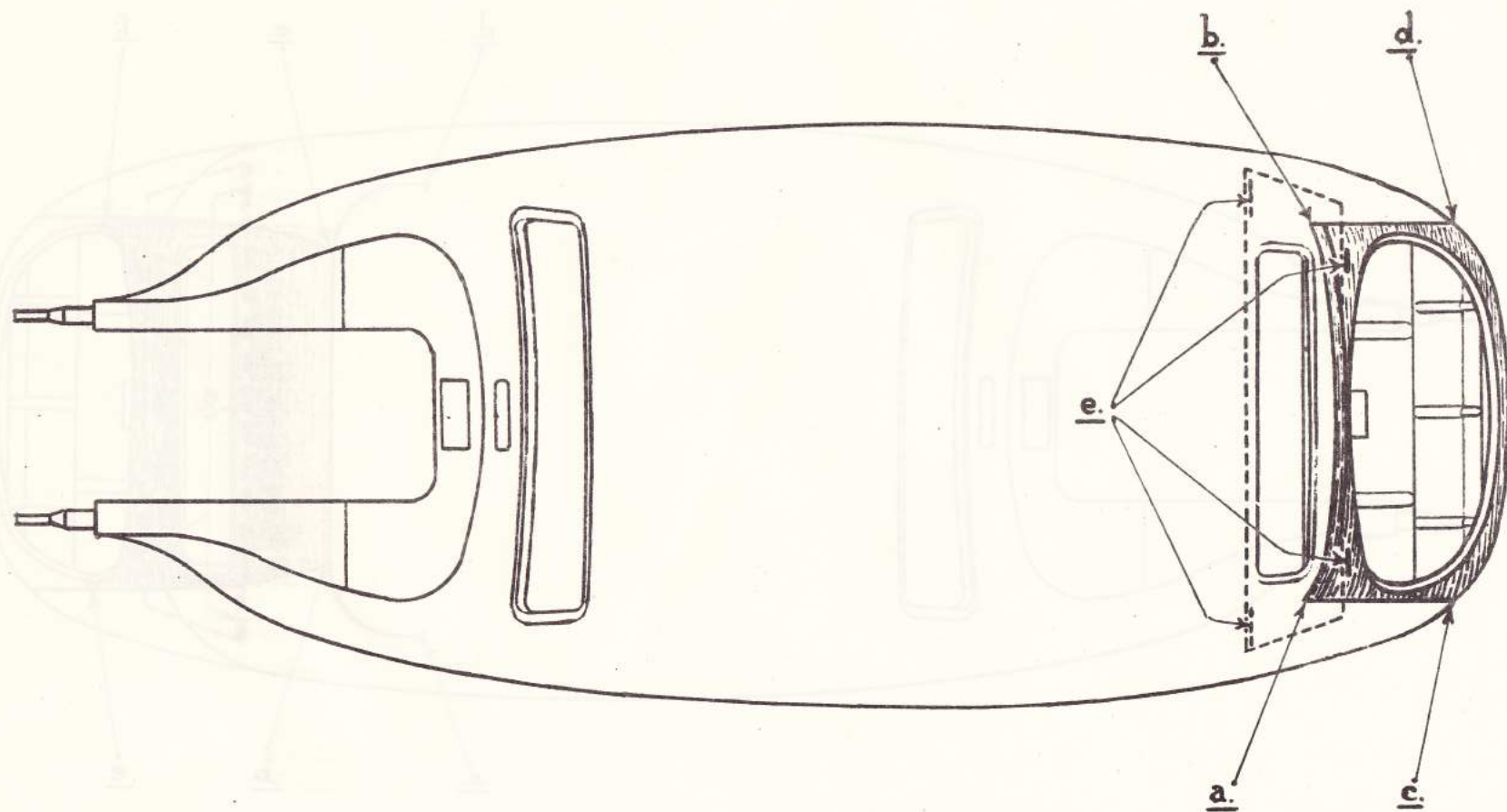
— SIDE PANEL AND EXTENSIONS REMOVED —

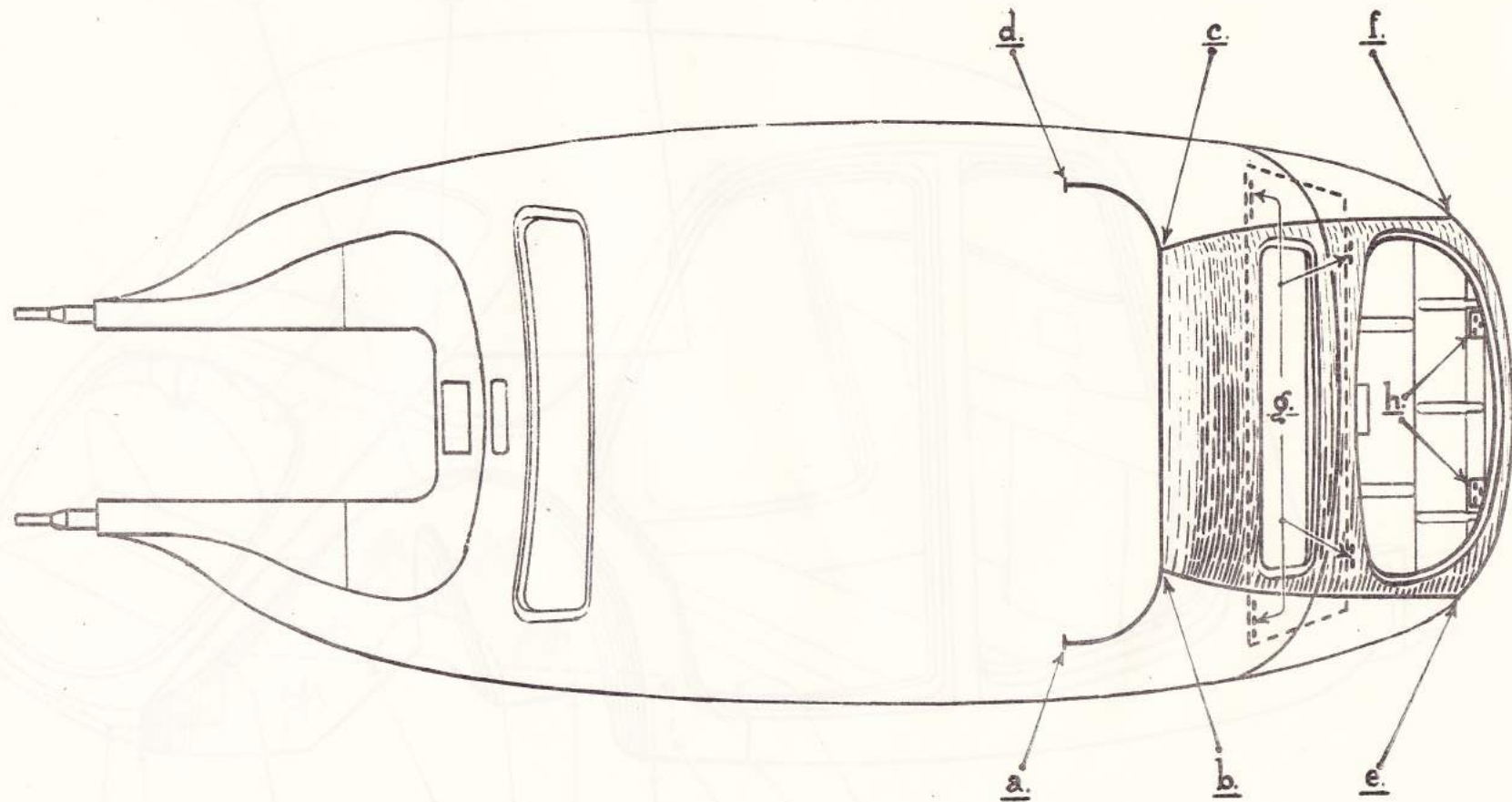


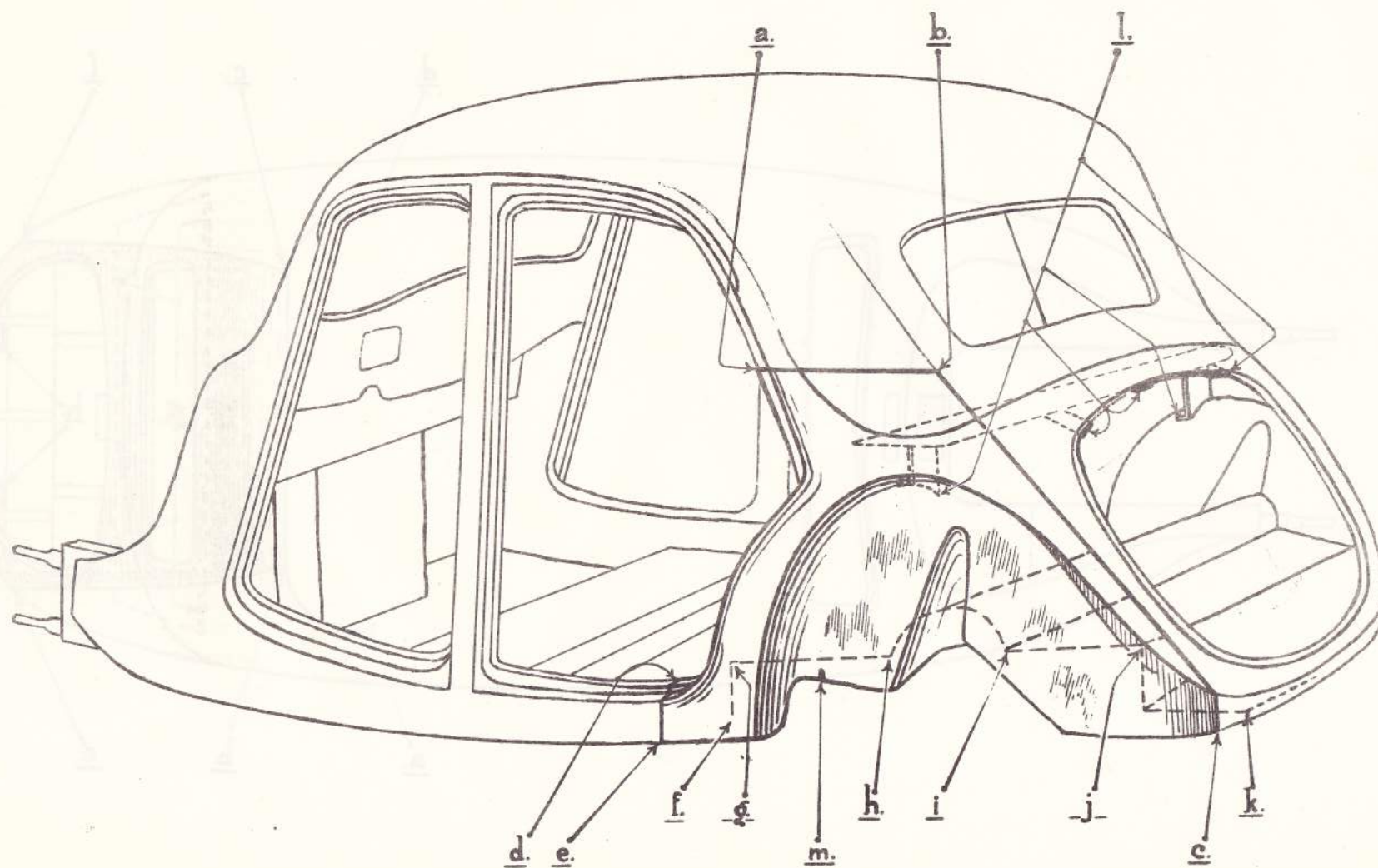


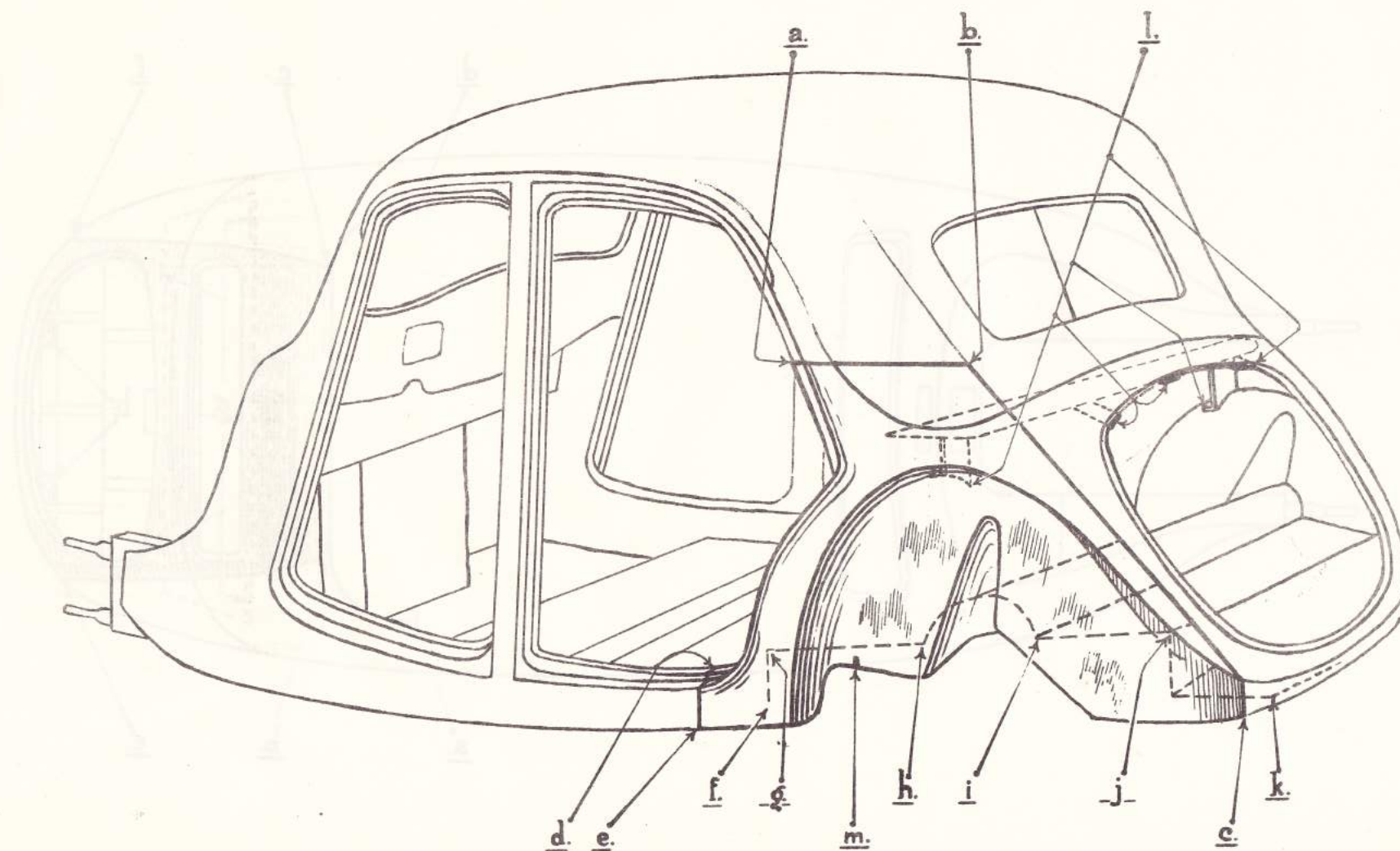
— Fig. 1. —— Fig. 2. — Roof cross section











VIEW FROM UNDERSIDE OF BODY

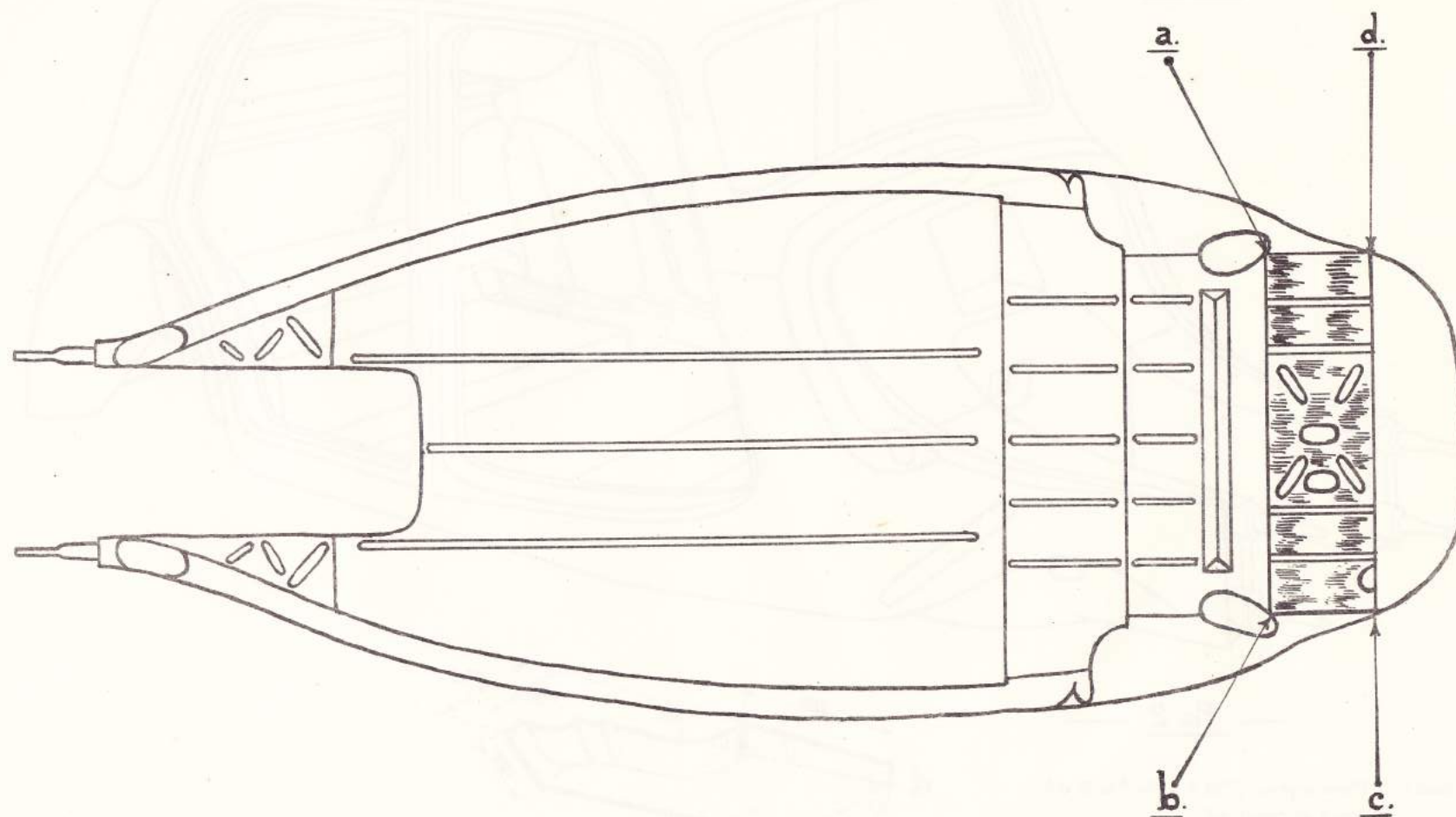


FIG. 1.

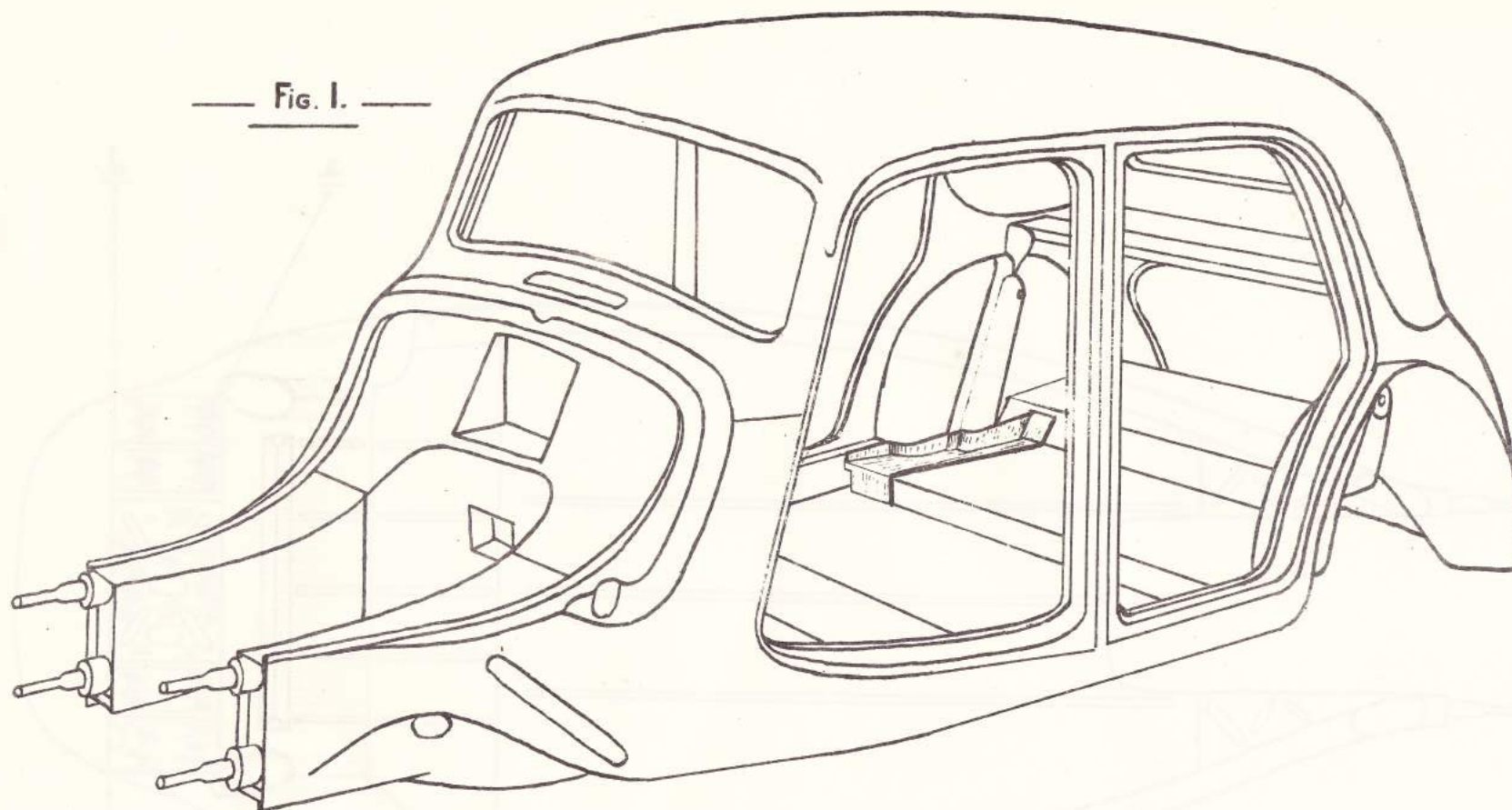
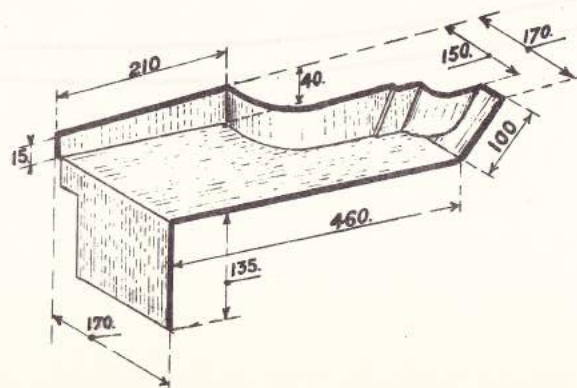


FIG. 2.

Mild steel 1² to 1⁵mm approx. (#18 B.G. to #16 B.G.),
shaped as required.

Part illustrated is for right hand side.

Part for left hand side is symmetrically opposite



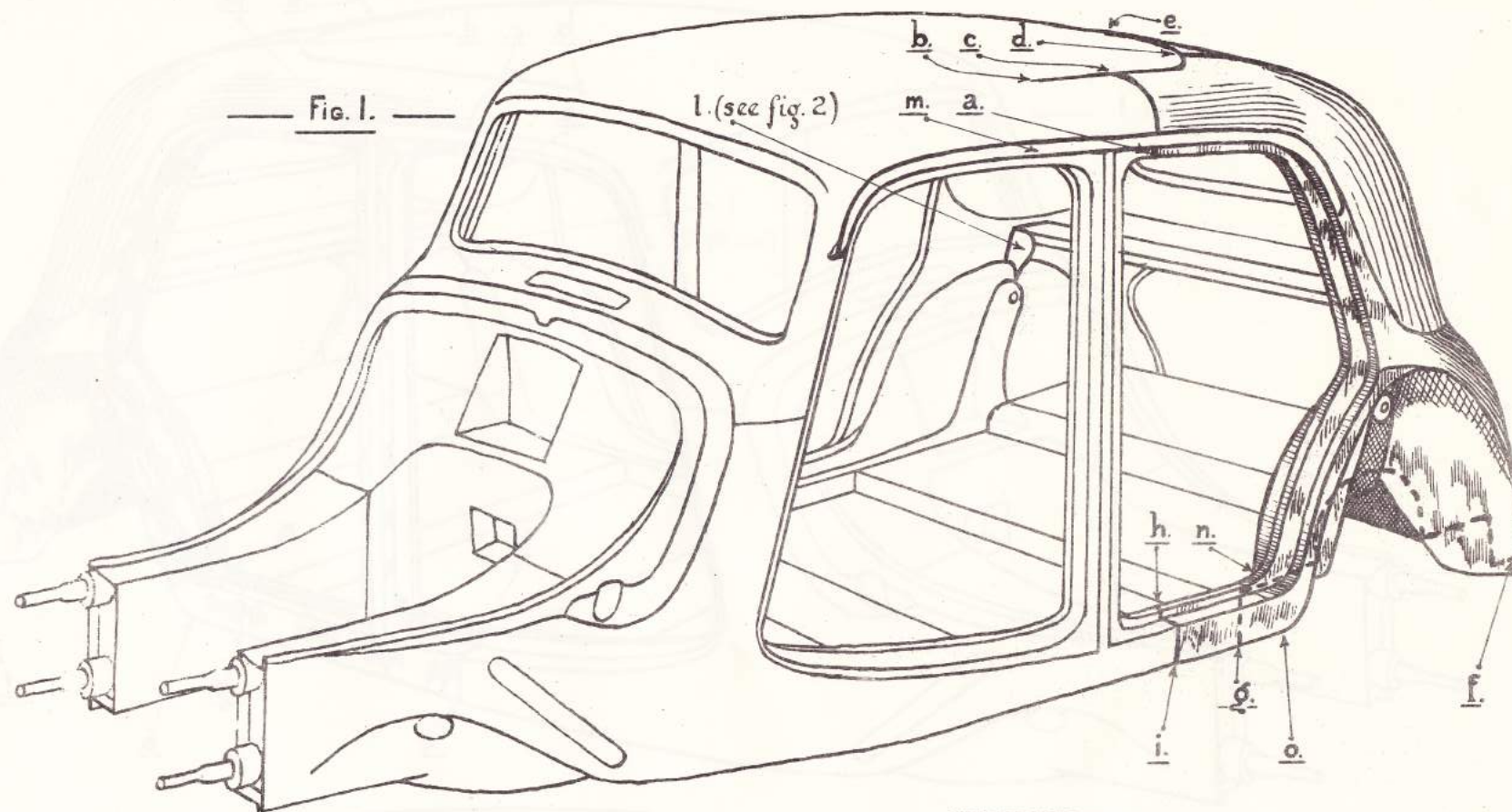
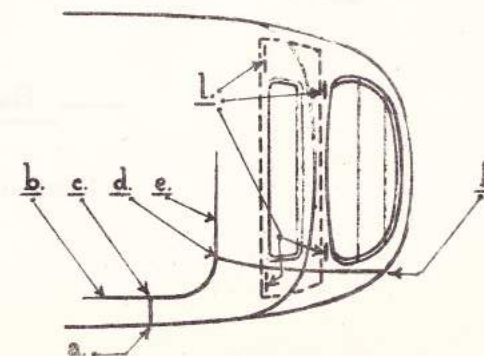


Fig. 2.

Plan view



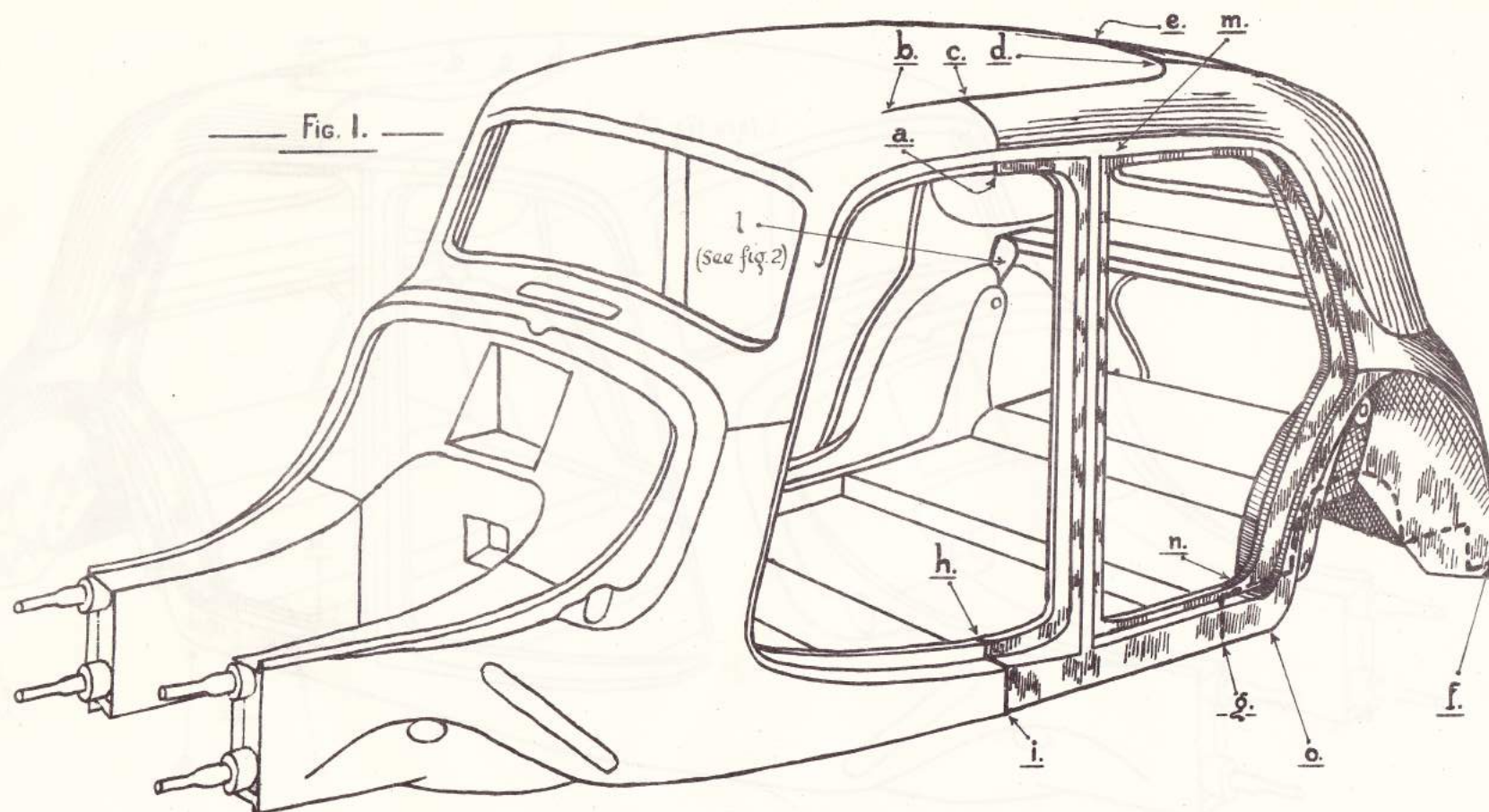
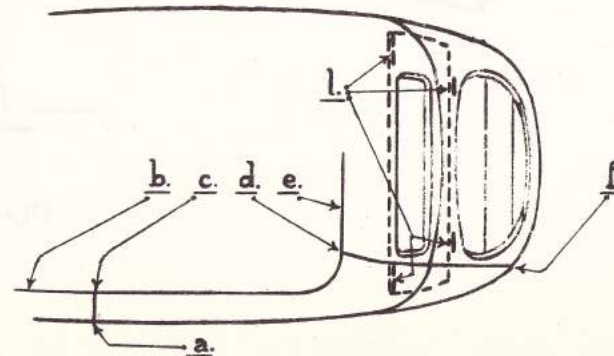
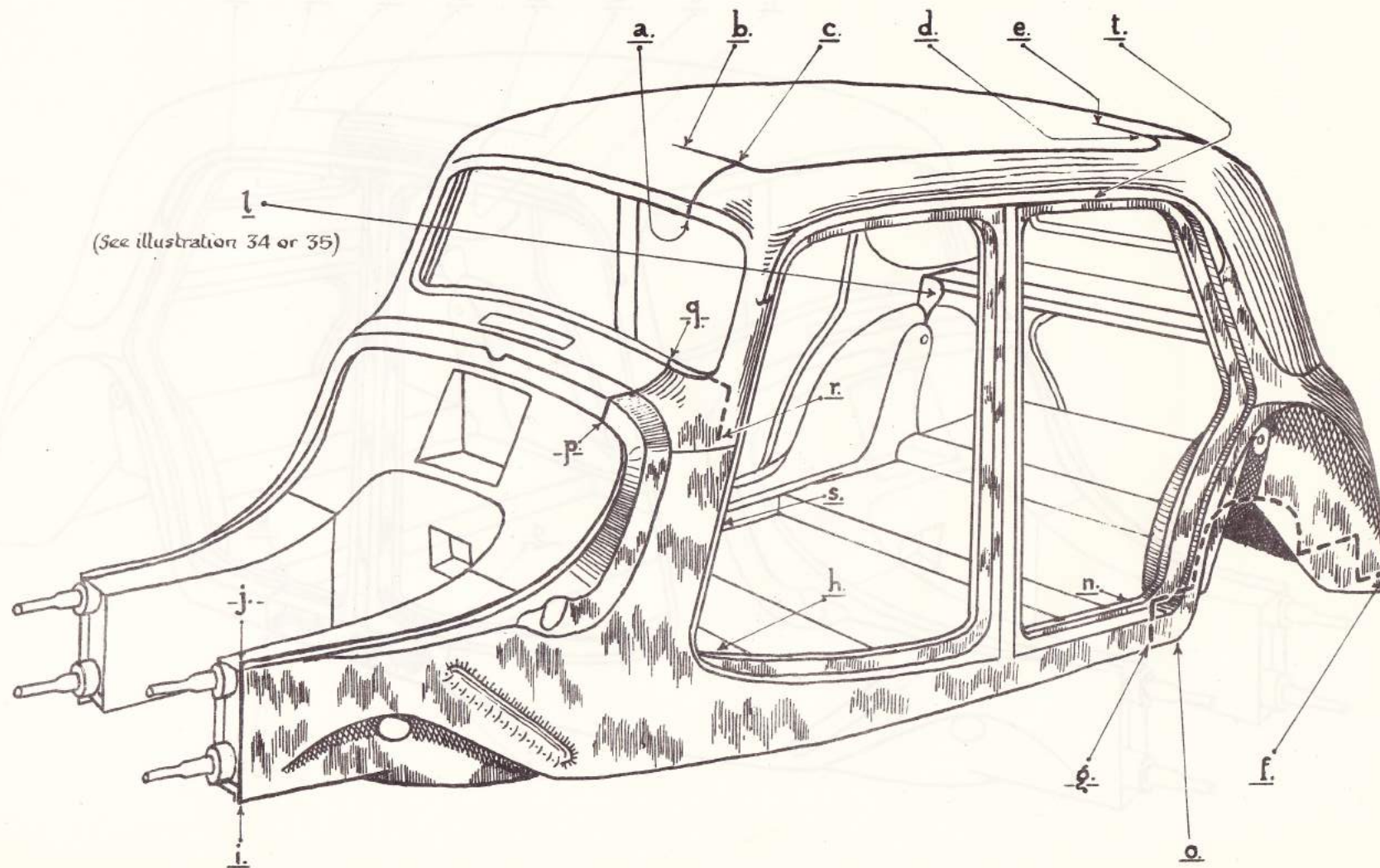
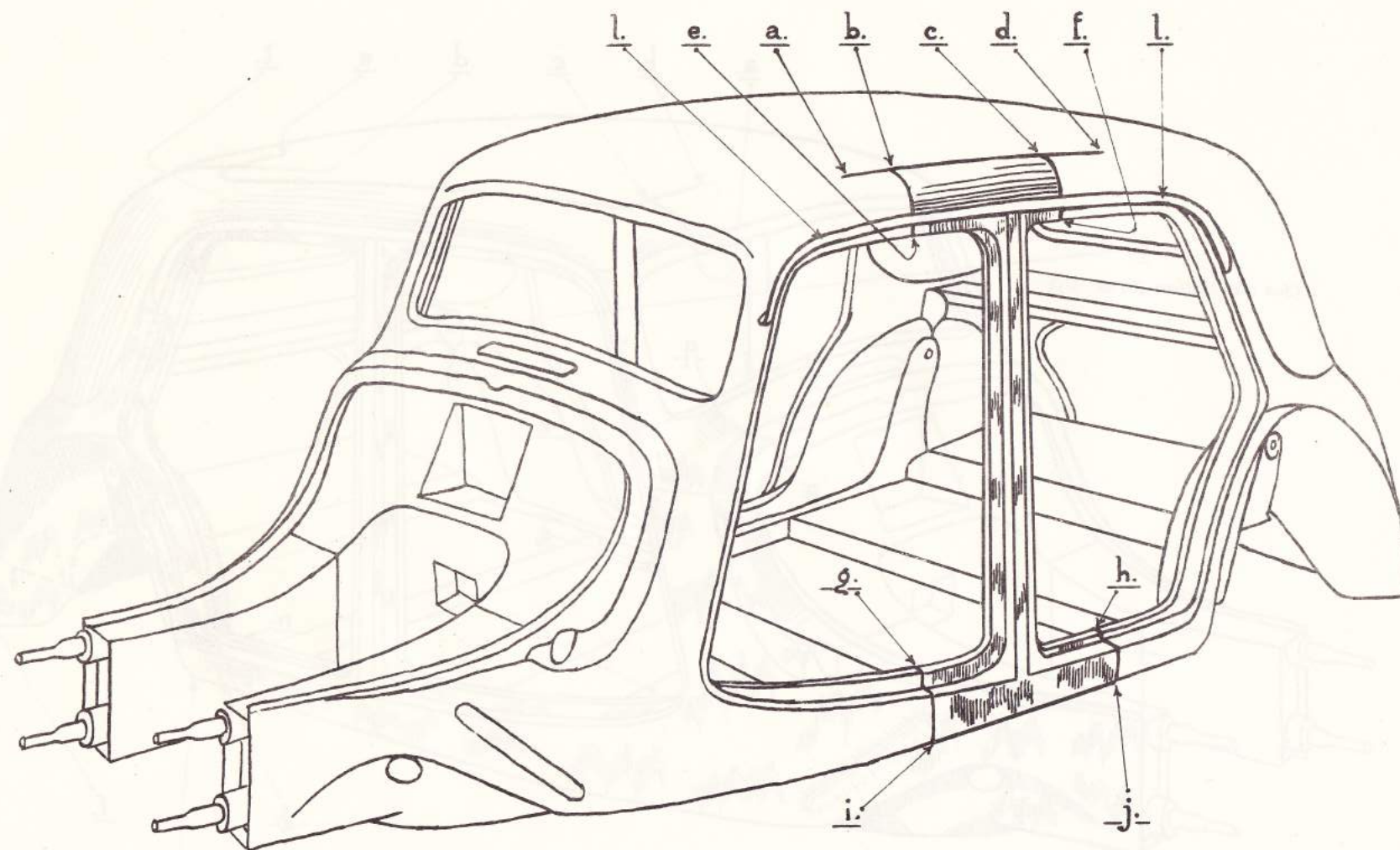


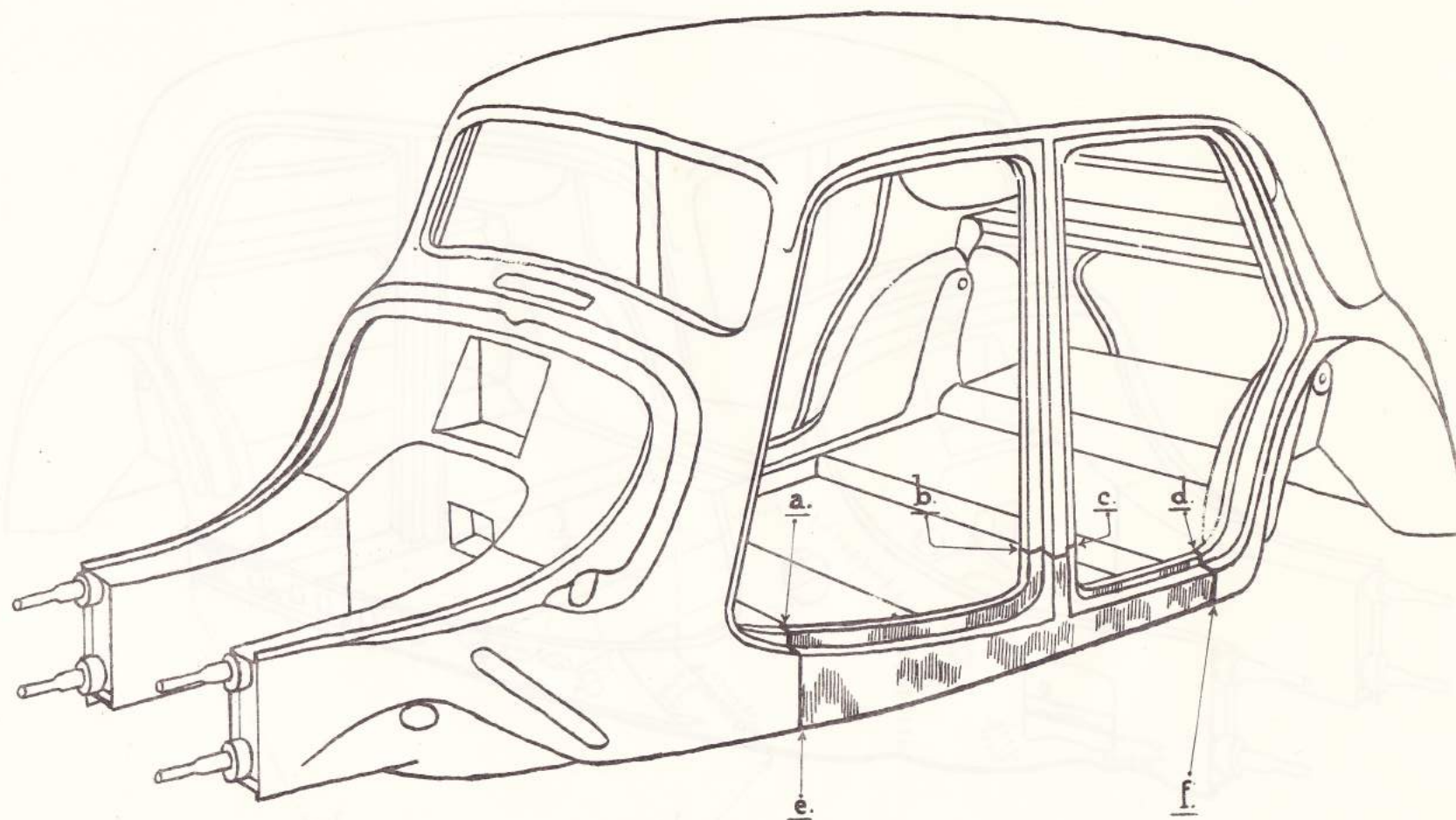
Fig. 2.

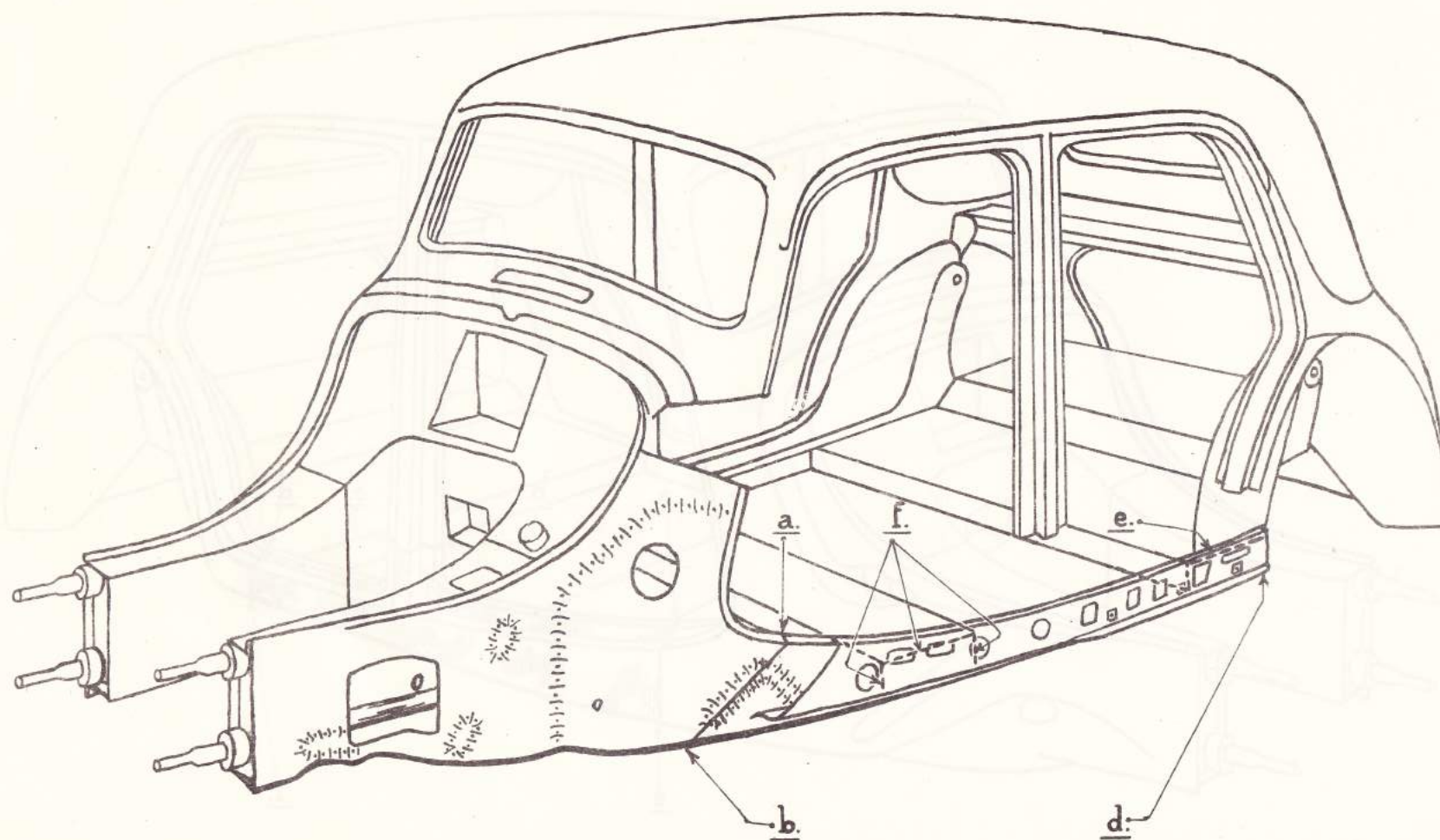
Plan view





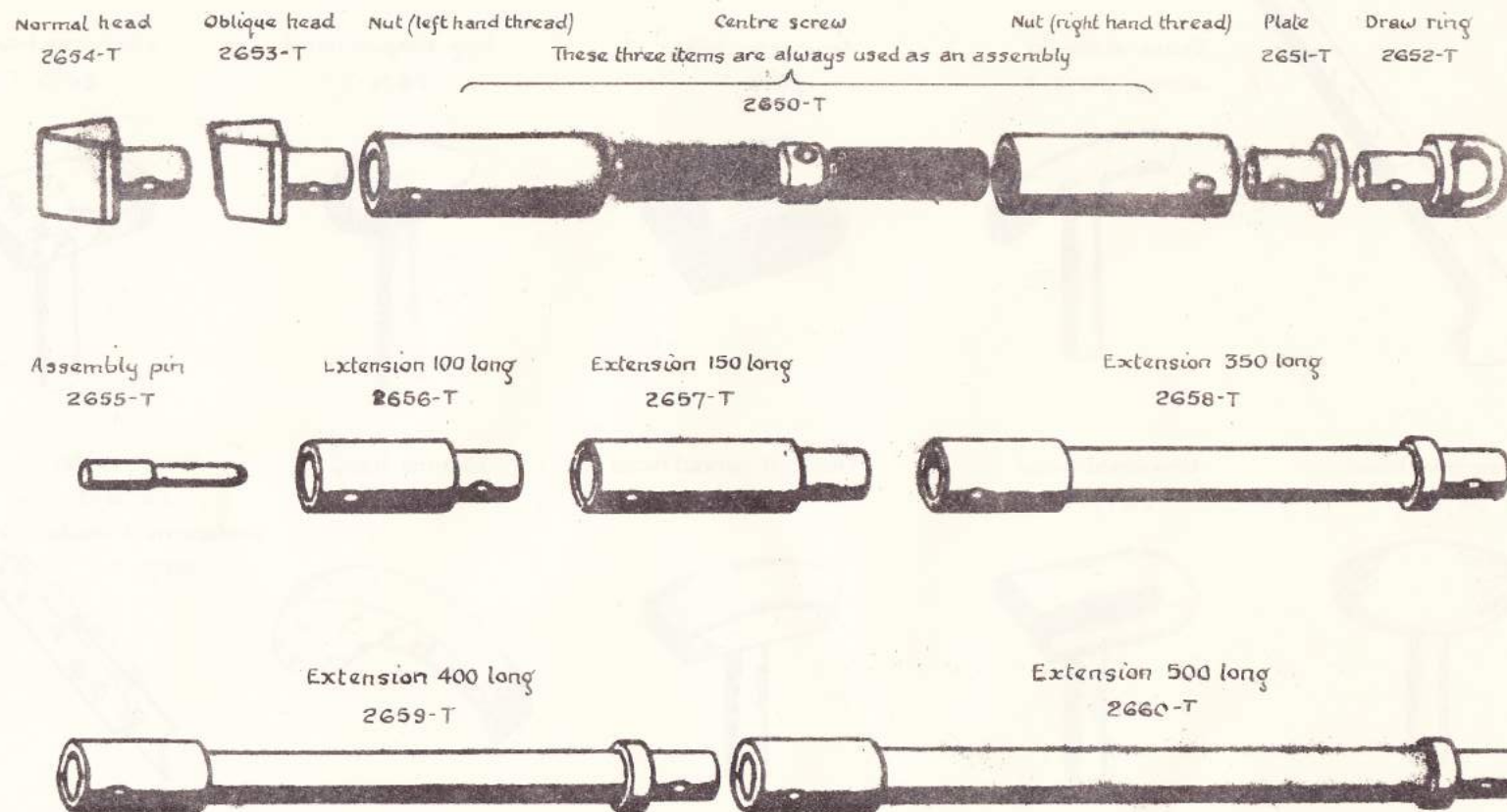






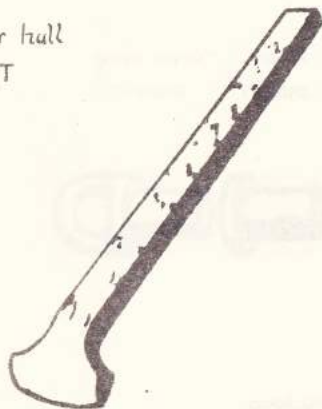
COMPONENTS OF BODYMAKER'S JACK

40



Seven assembly pins 2655-T are required to fully equip one jack

Crowbar for hull
2680-T



Cross-stake for
wings 2672-T



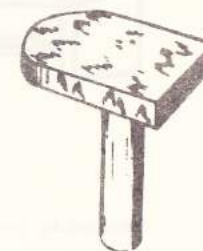
American dolly
2673-T



Egg-shaped head
2674-T



Flat horse head
2675-T



Mushroom head
2676-T



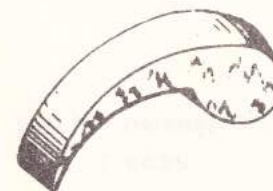
Universal head
2677-T



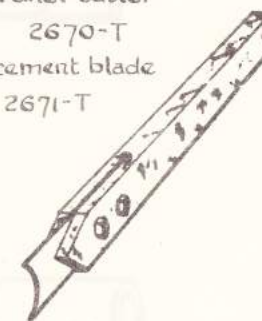
General curved head
2678-T



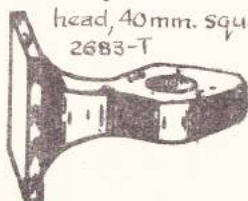
Comma head
2679-T



Panel cutter
2670-T
Replacement blade
2671-T



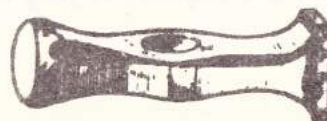
Planishing hammer, flat
head, 40mm. square
2683-T



Trimming hammer
2684-T



Round and square face
hammer 2685-T



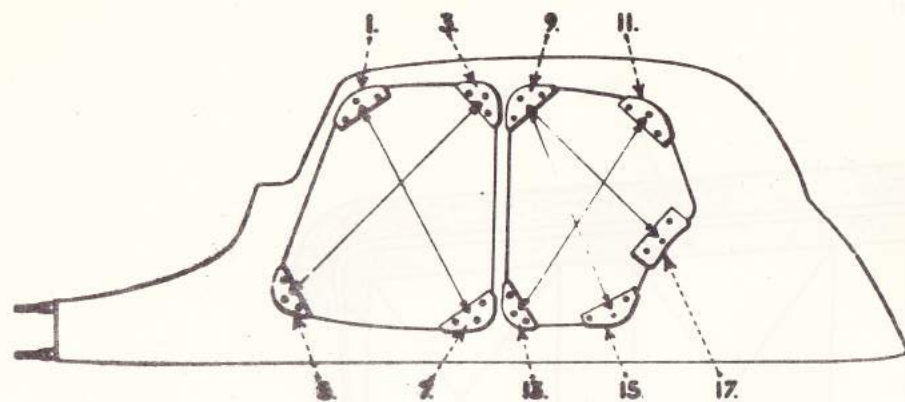
Large peine hammer
2686-T



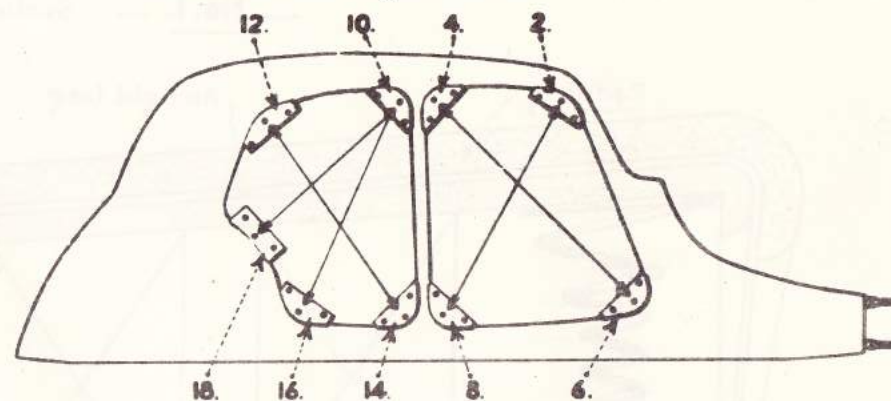
Twin head ball-nose hammer
2687-T



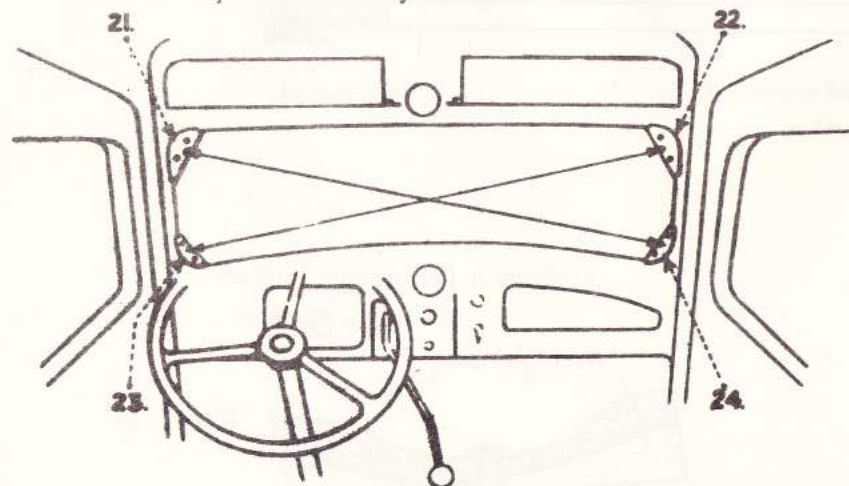
External view - left hand side



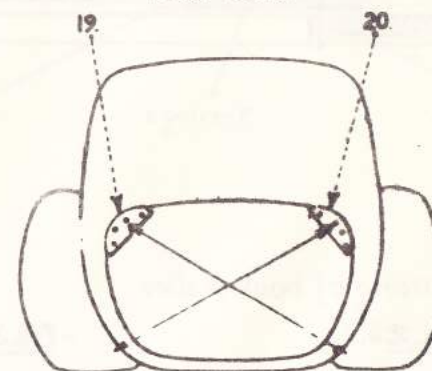
External view - right hand side



View of windscreen from interior



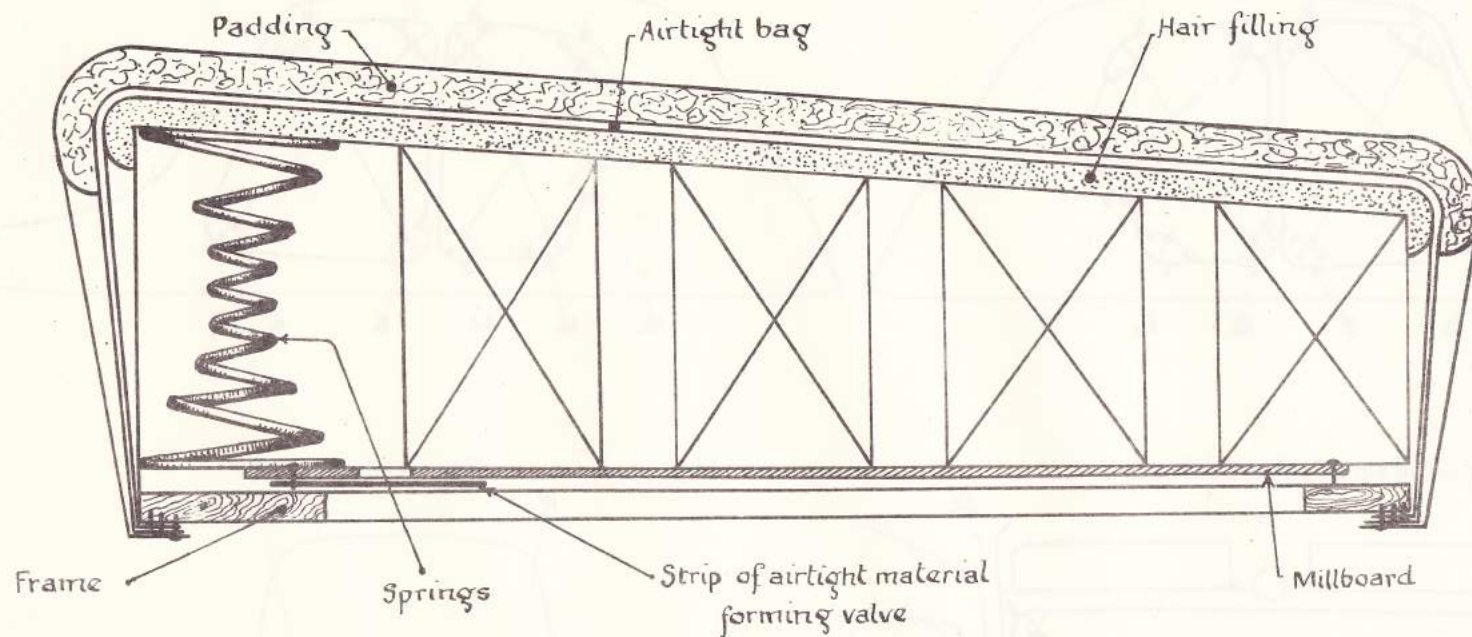
Rear view



Set of 24 wedges 2662-T

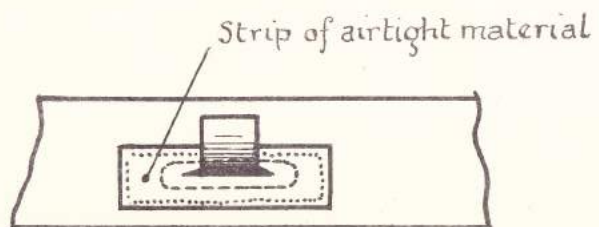
SECTION THROUGH "SOFTENED" TYPE SEAT CUSHION

— Fig. 1. — Section

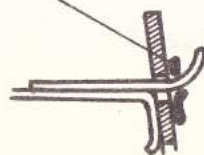


Fitting of hook plates

- Fig. 2 -



- Fig. 3 -



Fitting a trimming button

- Fig. 4 -

