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## 16-03-003BUG

### RPS Plate

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#### Applicability:

Bugatti Veyron

Bugatti Grand Sport

Bugatti Super Sport

#### VIN range :

As per E573

#### Market Region:

All

#### Introduction:

RPS plates on the Monocoque chassis have to be secured with rivets

#### Description:

If the RPS plates of the Monocoque chassis are not riveted, check their position prior to securing them.

If the RPS plate of the Monocoque chassis is not present, a new RPS plate has to be installed

#### Warning:

If any doubt regarding this procedure, contact your Bugatti contact.



**Do NOT drive/move or lift the car within 24h of the repair.**

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#### Procedure:

1. Check that the RPS plate is not dislocated from the monocoque. The RPS plate must not move during the hand verification (Do Not use tools). If the RPS plate is not in place or is loose, see the RPS installation procedure below
2. Mechanically clean the RPS plate and surrounding area as shown on Fig. 1

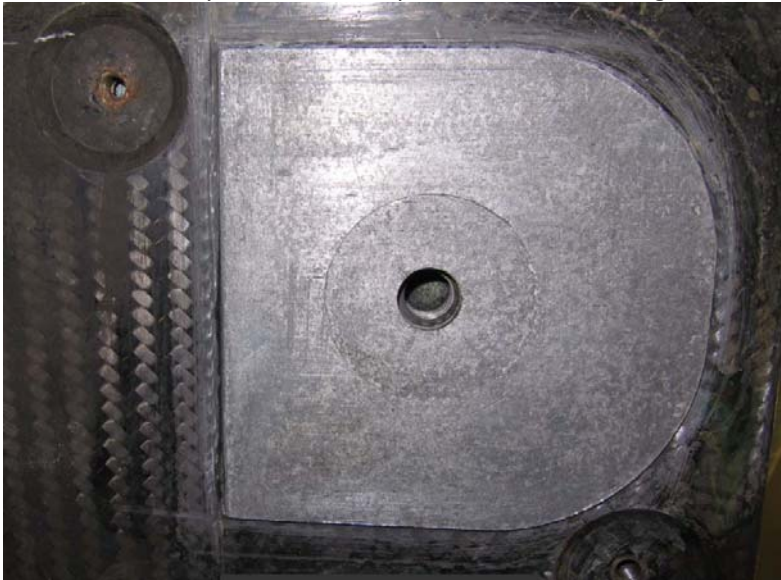


Fig 1: Mechanically cleaned RPS- Plate (Surrounding and bottom surface)

3. Install the drilling gauge as shown on RPS installation drawing (Fig. 2), check the gauge position (Fig. 3-5) prior to securing.

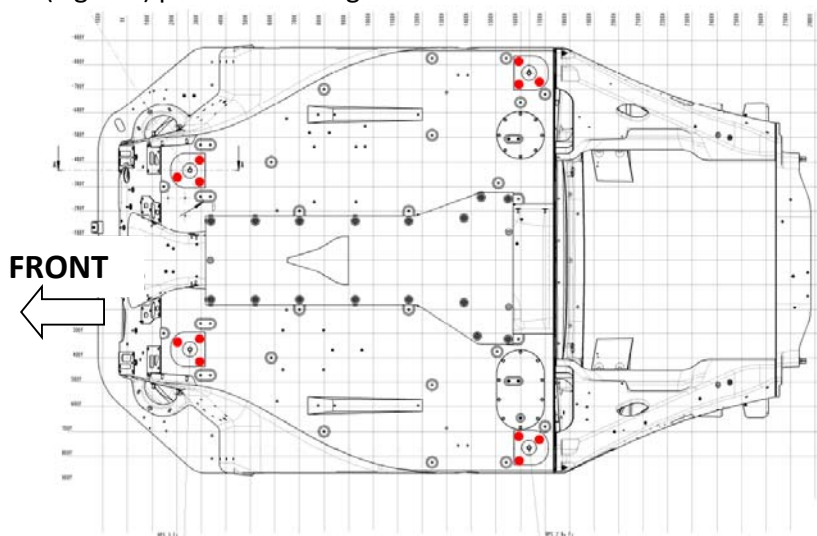


Fig 2: View from the bottom of the car, Schematic position of the fastening holes on all RPS

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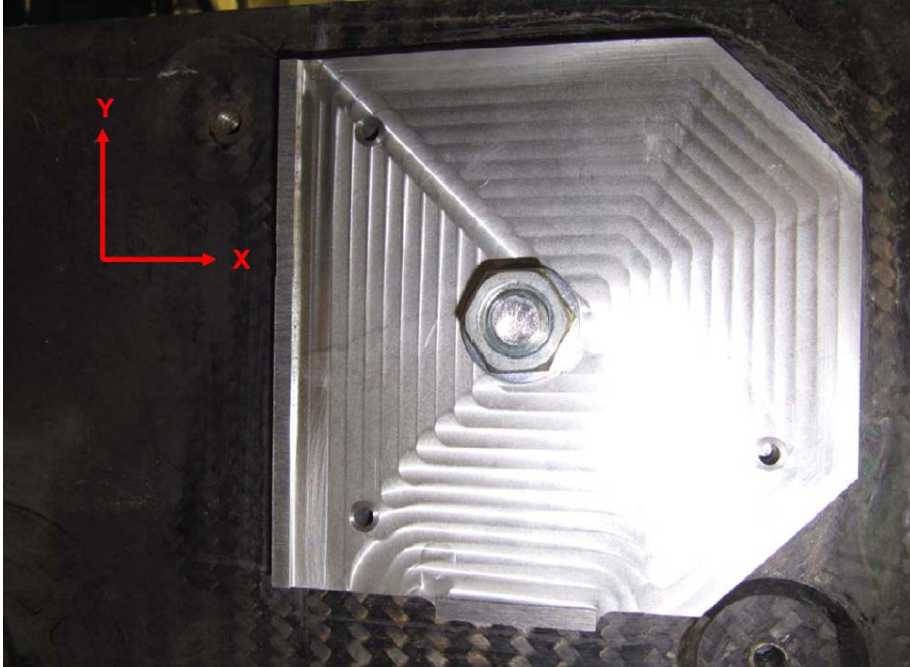


Fig 3: Installation position of the drilling gauge on the Monocoque

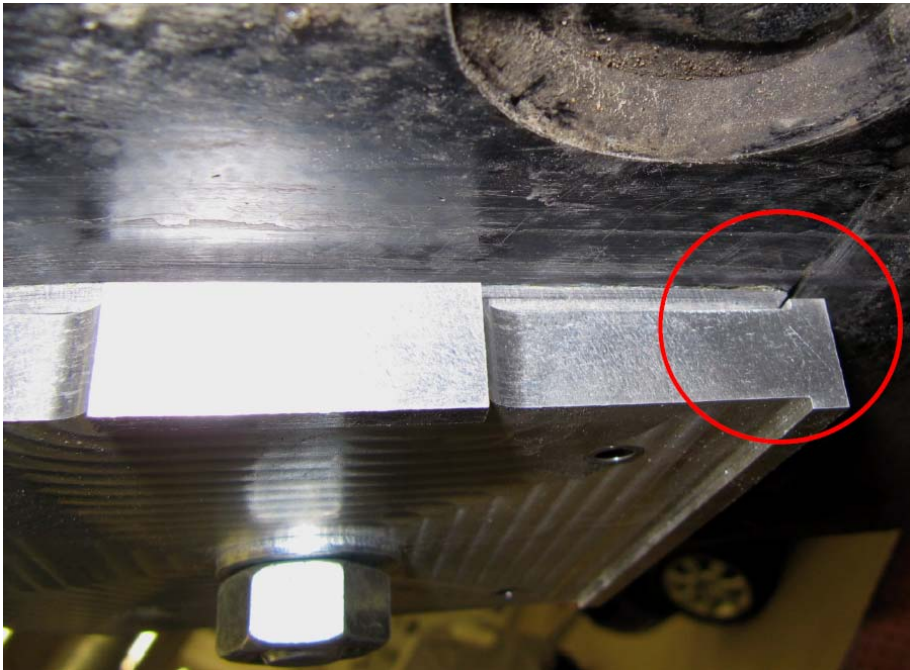


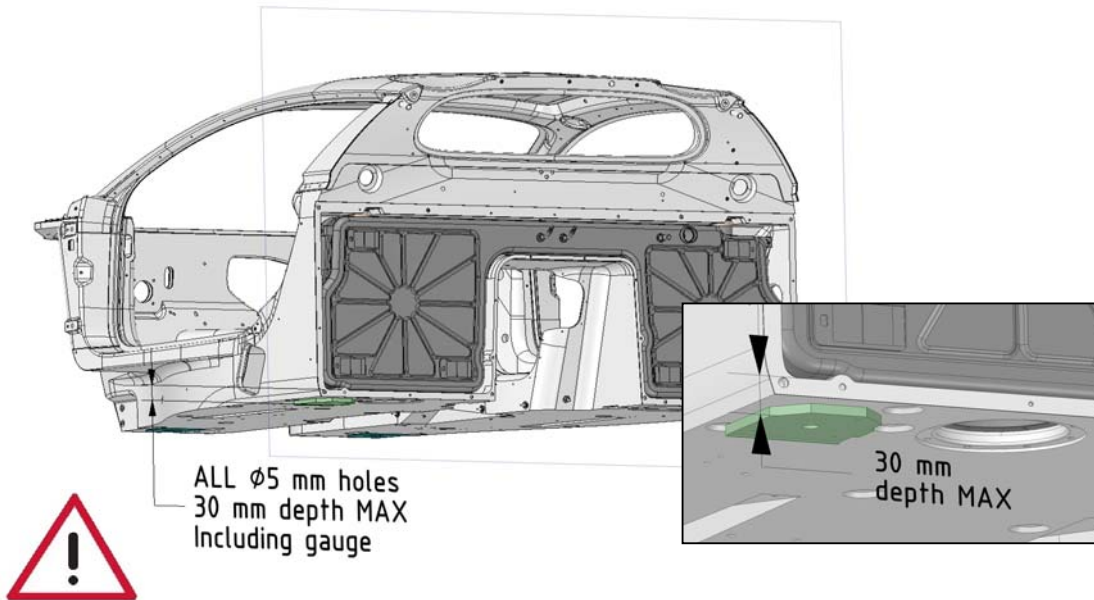
Fig 4: Installation position of the drilling gauge on the Monocoque with Detail X stop

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Fig 5: Installation position of the drilling gauge on the Monocoque with Detail Y stop



4. Drill 3 holes dia. 5mm with max depth 30mm (including drilling gauge height)  
**N.B.** Monocoque or Fuel Tank could be damaged if not respected



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5. Remove drilling gauge and deburr holes (Fig.6)



Fig 6: RPS-Plate with the 3 drilled and deburred holes (Ø5,0mm)

6. Install and expand the 3 blind rivets Typ: Monobolt 2774 Ø 4,8 mm (aluminum) with EPDM seal (Fig. 7-9)

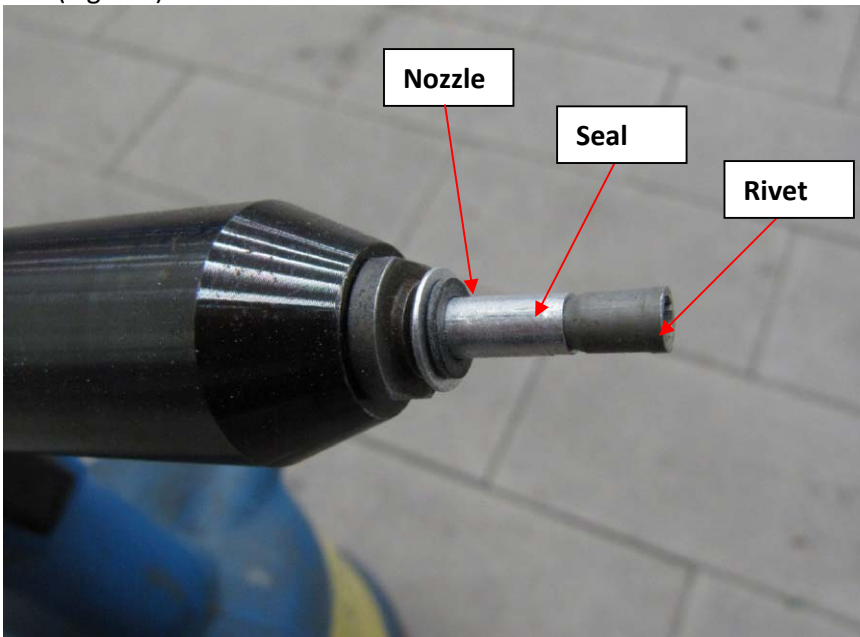


Fig 7: Avdel installation device Genesis nG3 with Monobolt Rivet 2774 with installed seal

**Remark :** Alternative installation device: Pop Rivet Pliers V.A.G.- System Nr. VAS 1753 A with 72005-02007 nozzle

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Fig 8: Installation of the blind rivet with the Avdel installation device Genesis nG3

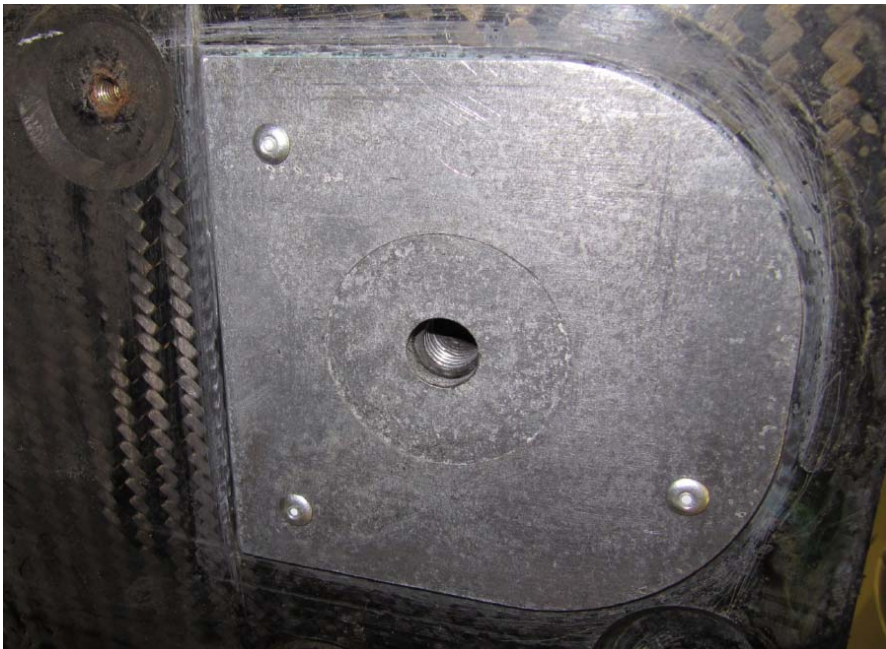


Fig 9: Riveted RPS Plate without surrounding seal

7. Degrease the RPS plate surrounding with Brake Cleaner and let it dry for about 10 min
8. Seal the RPS Plate surrounding with 3M Scotch-Weld DP 490 (DA 001 730 A2) (Fig. 10-11) with seal bead.



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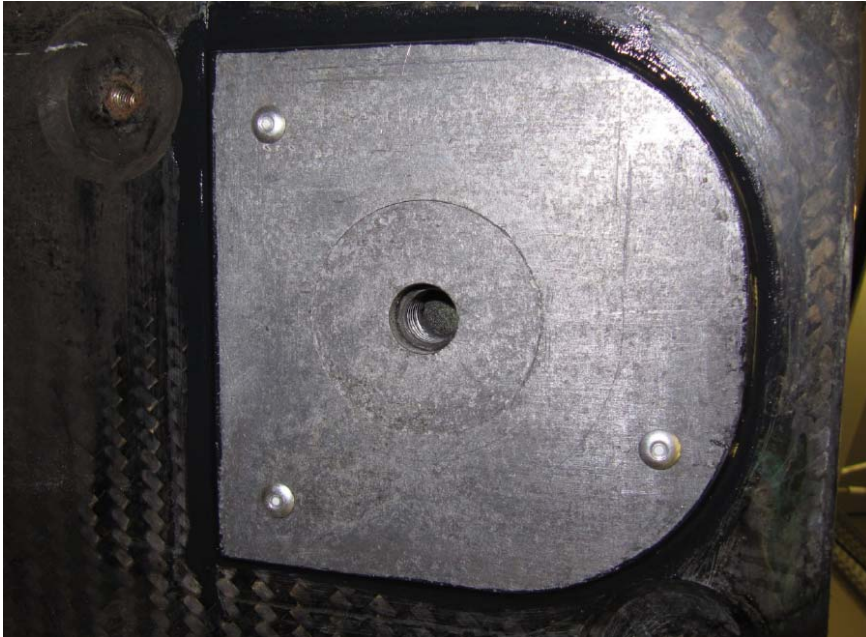


Fig 10: RPS Plate surrounding seal with Scotch-Weld DP 490 (DA 001 730 A2)



Fig 11: Detail view of the RPS Plate surrounding sealed with Scotch-Weld DP 490

9. Repeat sequence 1 to 8 for each RPS plates
10. End of procedure



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#### **RPS Plate Re-installation procedure:**

1. If the RPS Plate is loose, perform steps 2 to 5 of previous procedure
2. Carefully remove the RPS plate, and mechanically clean contact surfaces between Monocoque and RPS plate with sandpaper grit 80 – 100
3. Degrease the RPS plate and Monocoque RPS area with Brake Cleaner and let it dry for about 10 min
4. Apply a thin film of the structural adhesive 3M Scotch-Weld DP 490 (DA 001 730 A2) on the RPS Plate
5. Install the RPS Plate on the Monocoque using drilling gauge installation bolt
6. Install and expand the 3 blind rivets Typ: Monobolt 2774  $\varnothing$  4,8 mm (aluminium) with EPDM seal (Fig. 7-9)
7. Remove drilling gauge installation bolt
8. Seal the RPS Plate surrounding with 3M Scotch-Weld DP 490 (DA 001 730 A2) (Fig. 10-11) with seal bead.
9. End of procedure



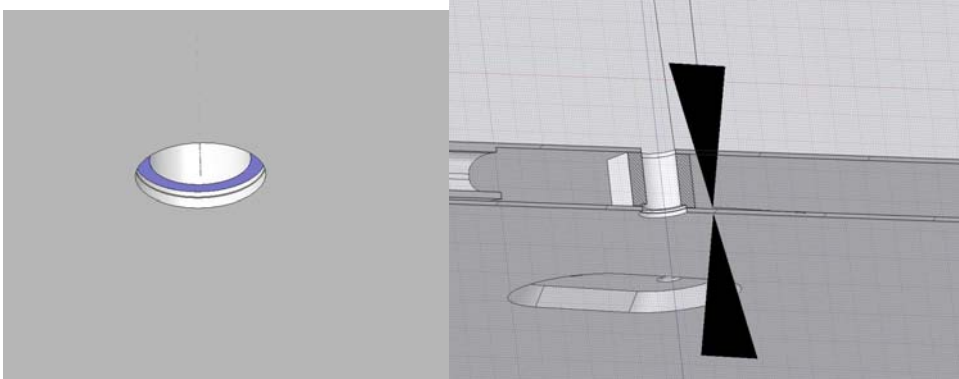
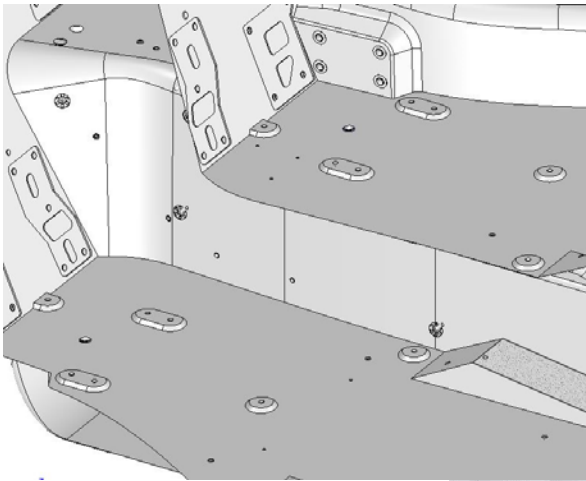
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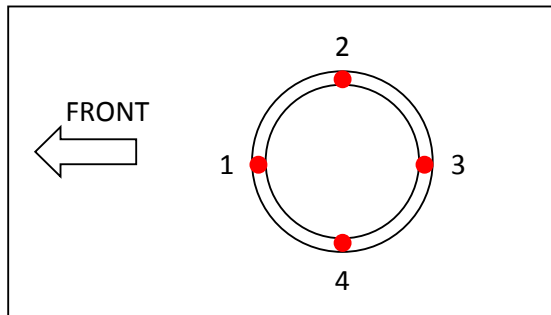
#### New RPS Plate installation procedure:

If the RPS Plate is not present on the vehicle, a measurement of the RPS insert has to be performed to select appropriate RPS Plate.

1. Make sure the RPS tap is removed and clean the RPS insert with Brake Cleaner
2. Use the depth probe of a Vernier calliper to measure the distance between the insert and the Monocoque Chassis



3. Repeat the measurement for the four measurement points of each missing RPS plate.  
Record the measurement values



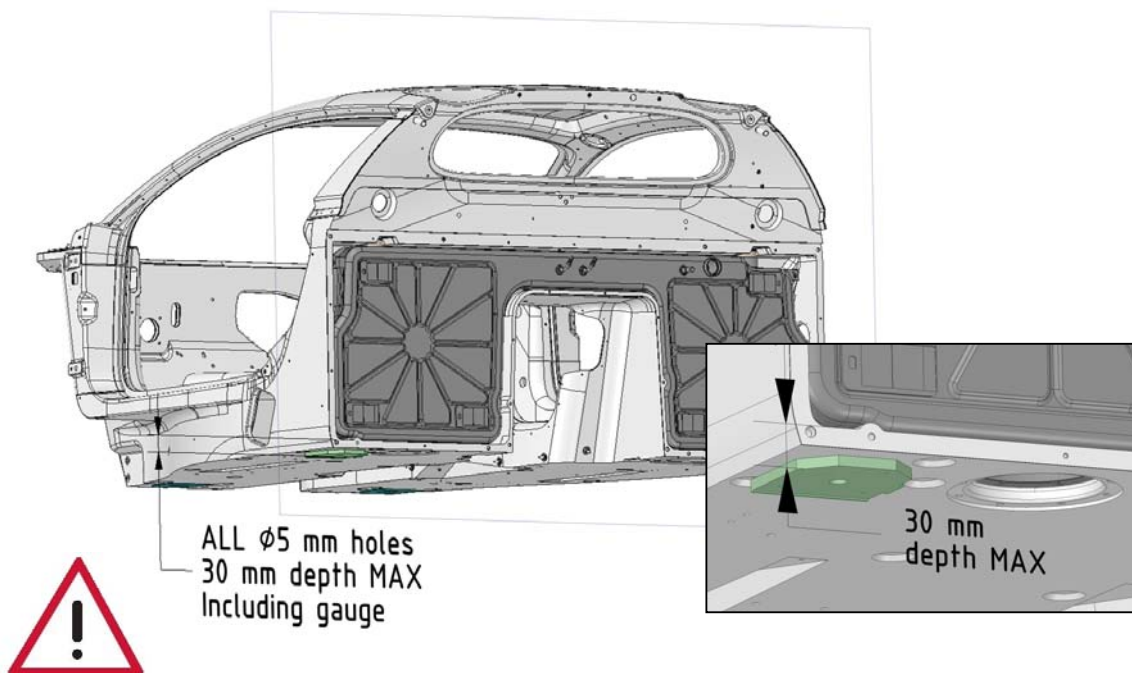
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- Calculate the average of the 4 measurements , and define appropriate RPS plate according following table (to be confirmed according RPS plate)

Average distance from Insert to Monocoque	RPS plate thickness to be used
1,00 to 1,50	3,00 tbc
1,51 to 2,00	2,50 tbc
2,01 to 2,50	2,00 tbc
2,51 to 3,00	1,50 tbc

- Mechanically clean contact surfaces between Monocoque and RPS plate with sandpaper grit 80 – 100
- Install the selected RPS Plate on the Monocoque and the drilling gauge  
Drill 3 holes dia. 5mm with max depth 30mm (including drilling gauge height)



- Remove drilling gauge and deburr RPS Plate holes
- Degrease the RPS plate and Monocoque RPS area with Brake Cleaner and let it dry for about 10 min
- Apply a thin film of the structural adhesive 3M Scotch-Weld DP 490 (DA 001 730 A2) on the selected RPS Plate
- Install the selected RPS Plate on the Monocoque using drilling gauge installation bolt
- Install and expand the 3 blind rivets Typ: Monobolt 2774  $\phi$  4,8 mm (aluminium) with EPDM seal (Fig. 7-9)



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- 12. Remove drilling gauge installation bolt
- 13. Seal the RPS Plate surrounding with 3M Scotch-Weld DP 490 (DA 001 730 A2) (Fig. 10-11) with seal bead
- 14. End of procedure

**Warranty information:**

Operation	Defect Code	Repair Code	Time
Repair if needed			2 hrs

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