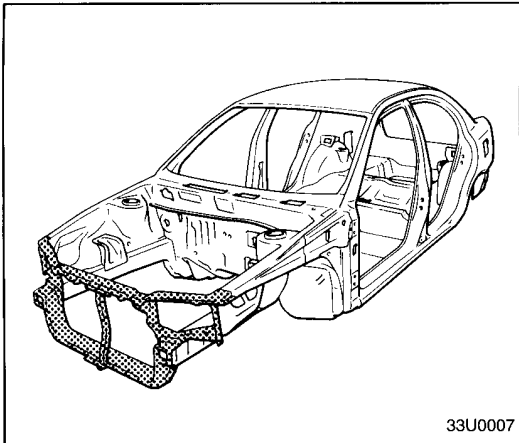



3 WELDED PANEL REPLACEMENT

HEADLAMP SUPPORT	3- 3
FENDER SHIELD	3- 4
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CENTER PILLAR	3-10
SIDE SILL	3-12
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REAR END PANEL	3-18
QUARTER, INNER	3-19
ROOF PANEL	3-20
FRONT DOOR OUTER PANEL	3-21
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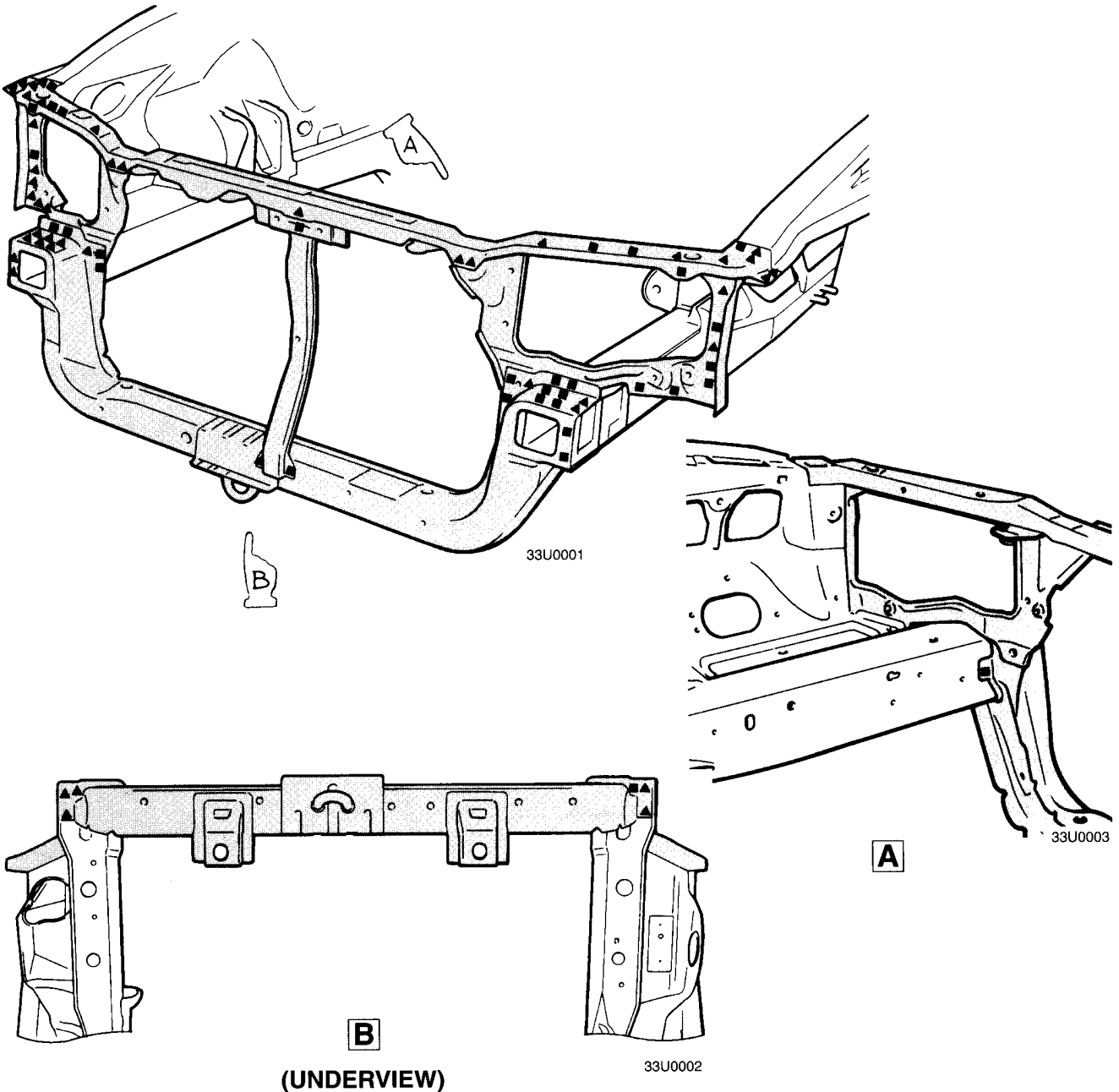
NOTES

HEADLAMP SUPPORT

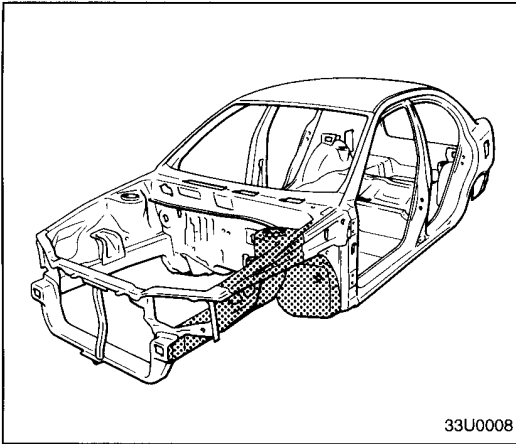



Symbol	Operation description
• • • •	Spot welding
■ ■ ▲ ▲	MIG plug welding ■ indicates two panels to be welded ▲ indicates three panels to be welded
+ + + +	MIG spot welding
#####	MIG arc welding (continuous)
oooooooo	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.)

REPAIR WELDS

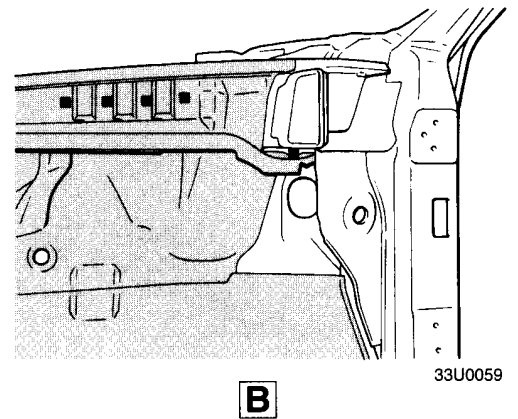
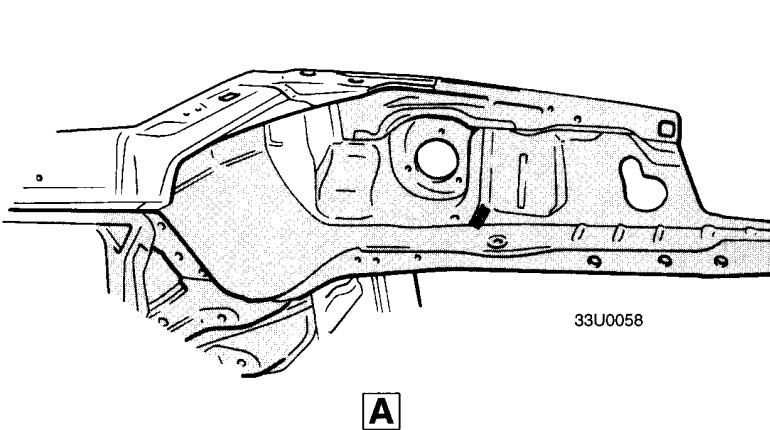
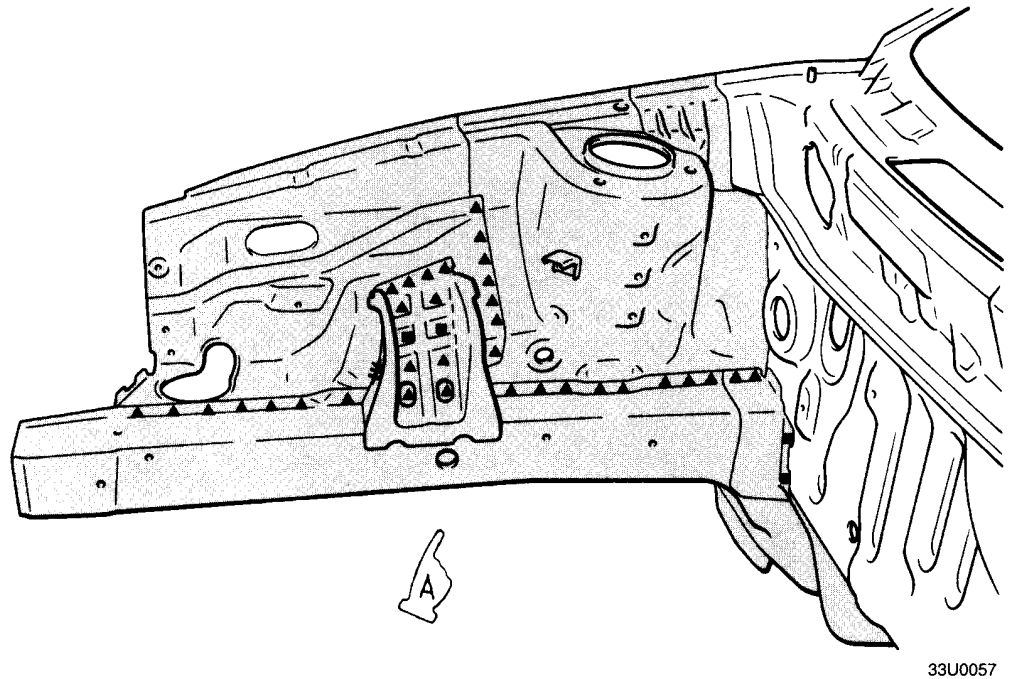


FENDER SHIELD



Symbol	Operation description
• • • •	Spot welding
■ ■ ▲ ▲	MIG plug welding ■ indicates two panels to be welded ▲ indicates three panels to be welded
+ + + +	MIG spot welding
	MIG arc welding (continuous)
○○○○○○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.)

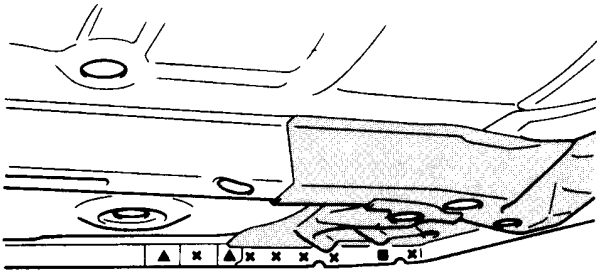
REPAIR WELDS



(With the front upper frame extension outer and the front upper frame outer removed.)

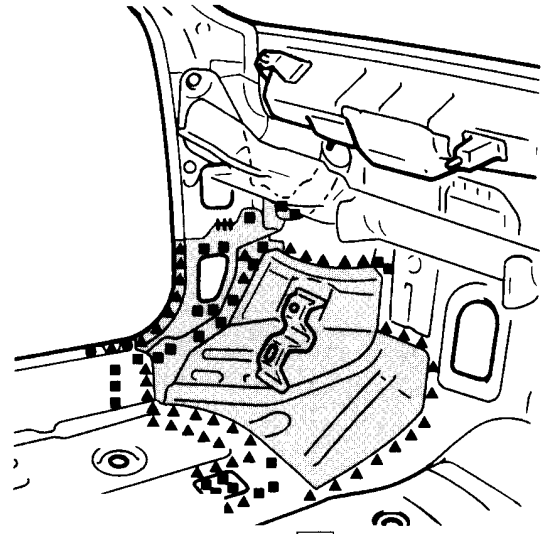
NOTE

- (1) For the right side, only weld points that are different from those on the left side are shown.
- (2) Refer to page 3-3 for the headlamp support weld points.



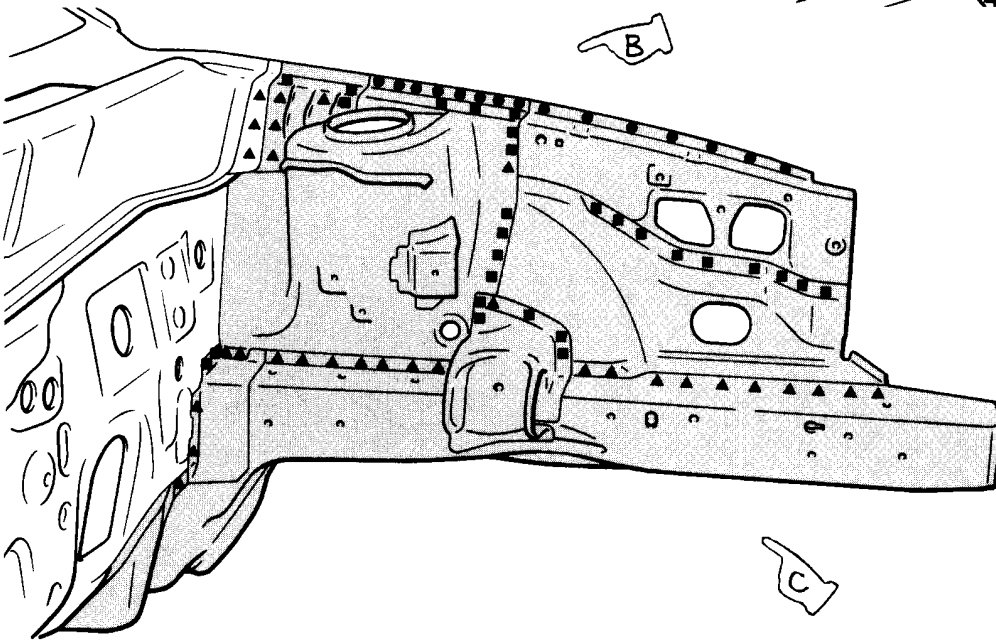
D

33U0062



E

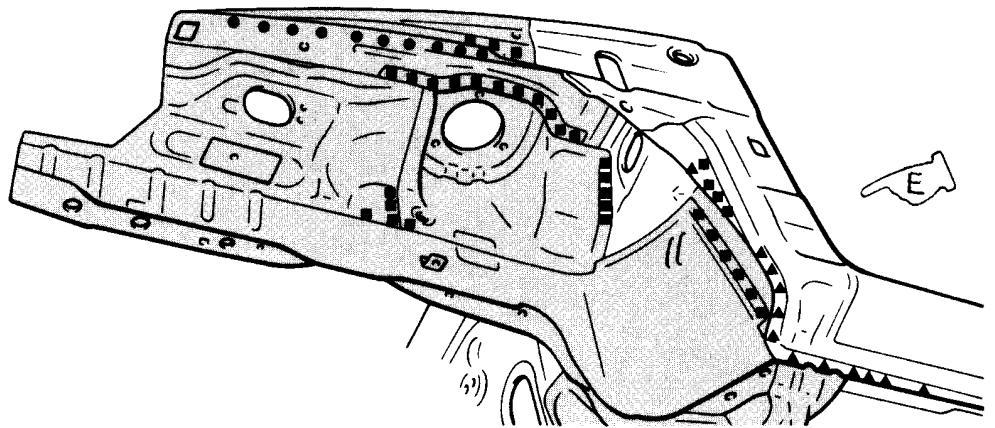
33U0063



B

33U0061

C

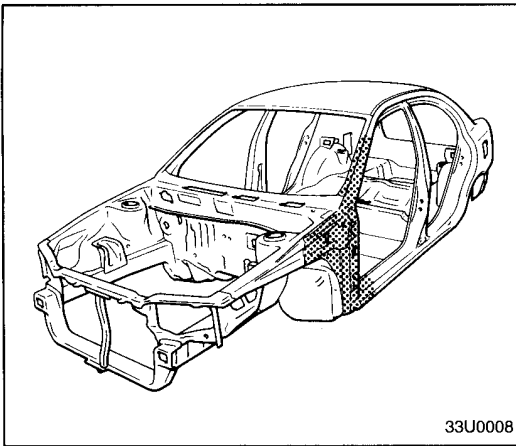


C

E

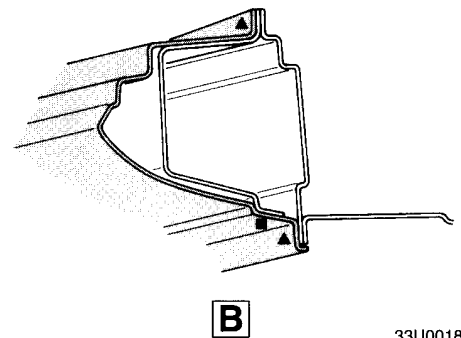
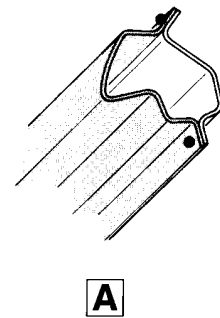
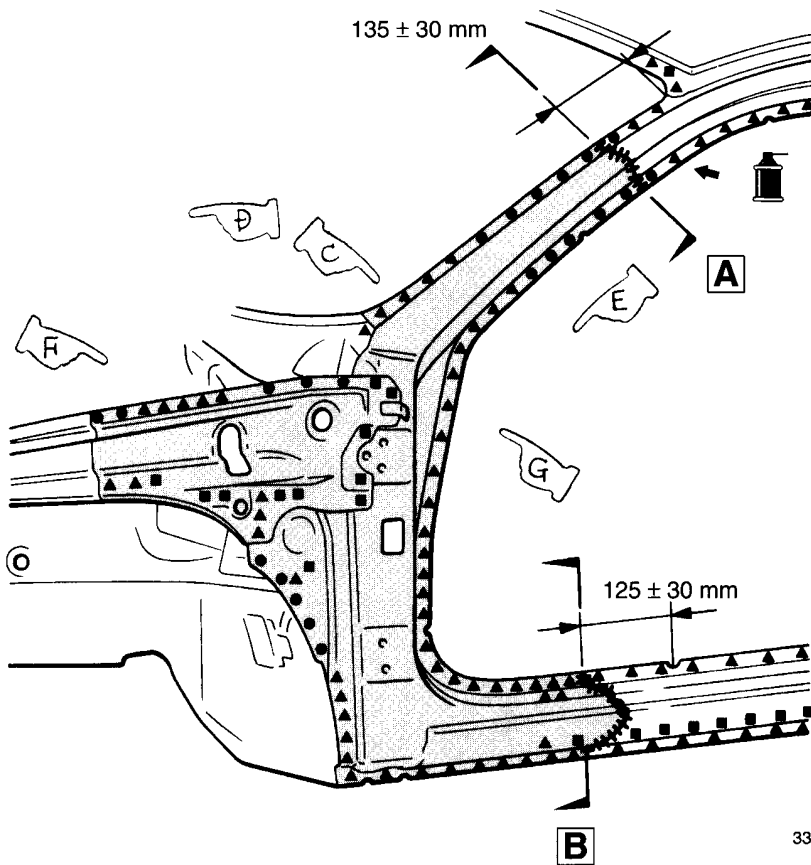
33U0060

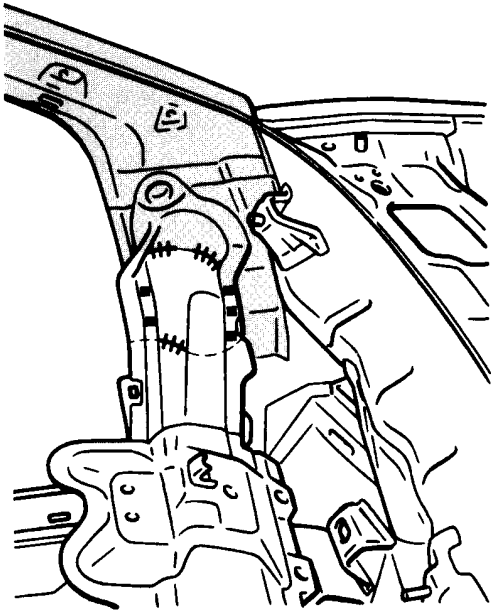
FRONT PILLAR



Symbol	Operation description
••••	Spot welding
■ ■ ▲ ▲	MIG plug welding ■ indicates two panels to be welded ▲ indicates three panels to be welded
+ + + +	MIG spot welding
	MIG arc welding (continuous)
○○○○○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.)

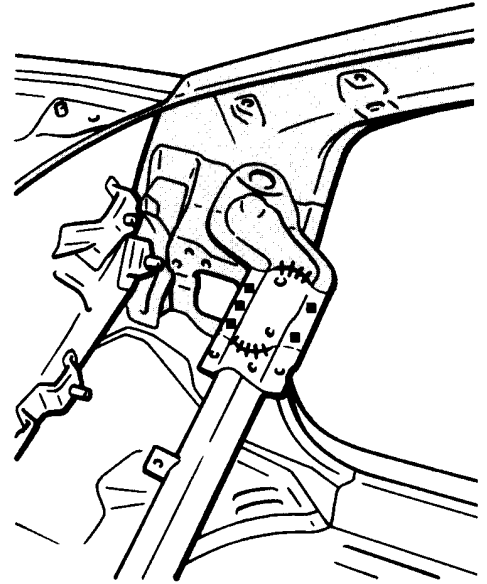
REPAIR WELDS





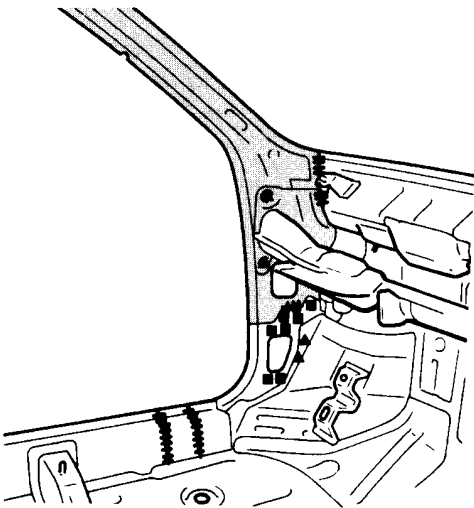
C

33U0065



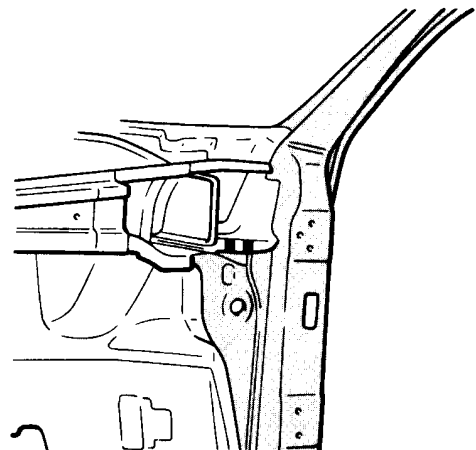
D

33U0066



E

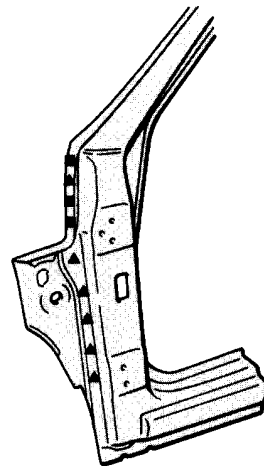
33U0067



F

33U0068

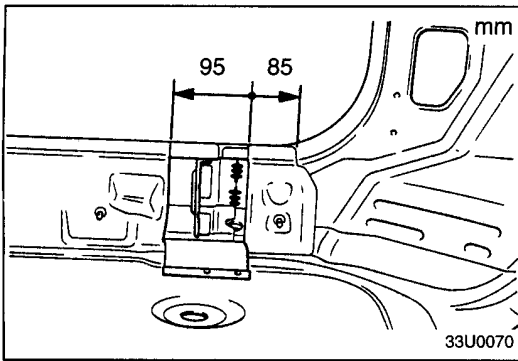
(With the front upper frame extension outer removed.)



G

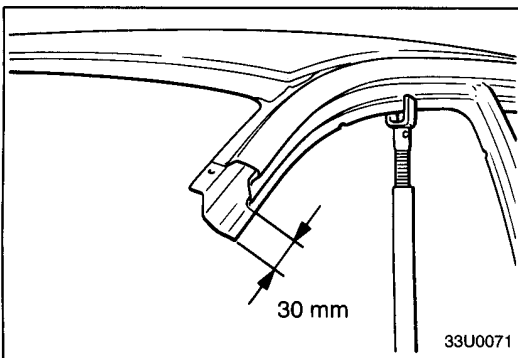
33U0069

(Front pillar outer and inner assembled)



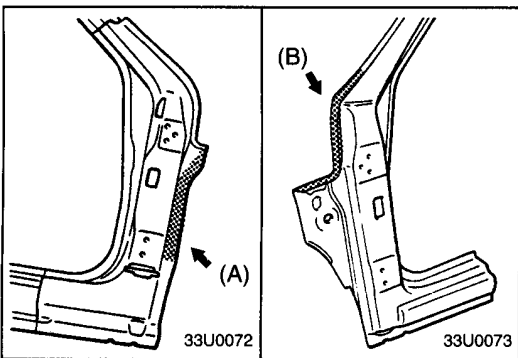
NOTES WITH REGARD TO REPAIR WORK
REMOVAL

In order to cut the MIG arc welding between the front pillar reinforcement lower and side sill outer reinforcement front, cut the front floor side sill inner as shown in the illustration.



INSTALLATION

- (1) Cut the front pillar outer panel 30 mm above the cut line of the inner panel to butt weld a new front pillar to the body.
Then cut the new front pillar to correspond to it.



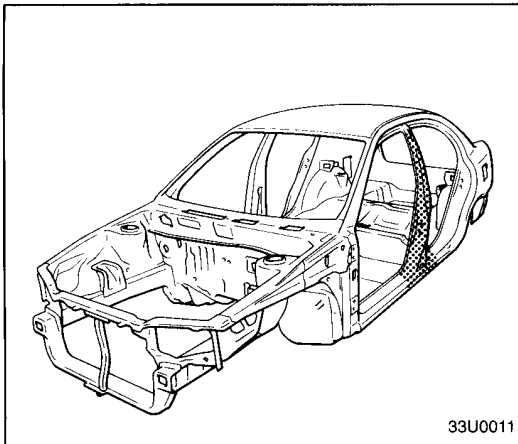
- (2) When installing the front pillar outer to the front pillar inner, apply adhesive to section (A) in the illustration.

Adhesive	Type
	Chloroprene-base drying sealant

- (3) When installing the front pillar outer and front pillar inner sub-assembly to the body, apply body sealant to section (B) in the illustration.

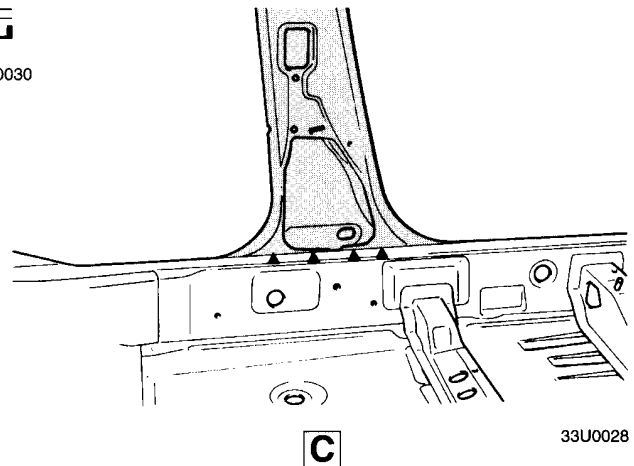
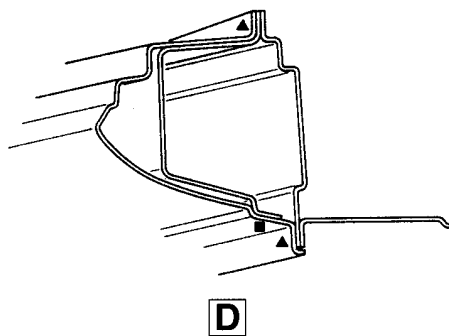
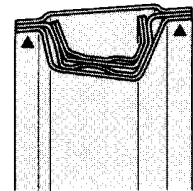
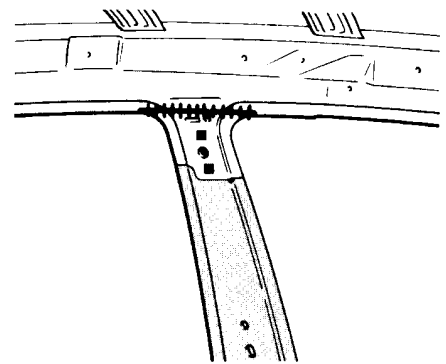
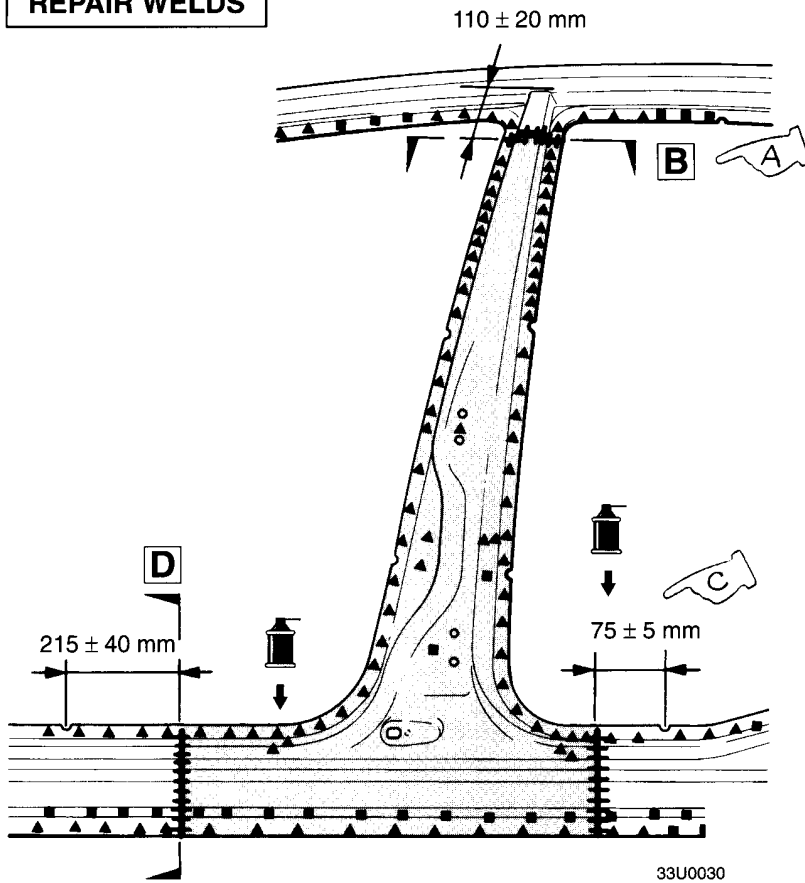
NOTES

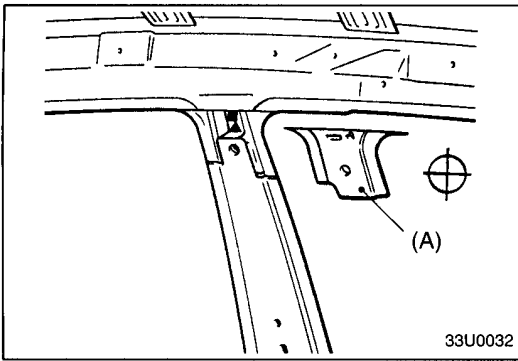
CENTER PILLAR



Symbol	Operation description
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding ■ indicates two panels to be welded ▲ indicates three panels to be welded
+ + + +	MIG spot welding
	MIG arc welding (continuous)
○○○○○○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.)

REPAIR WELDS



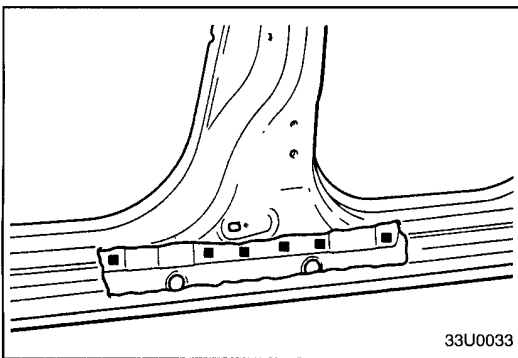


**NOTES WITH REGARD TO REPAIR WORK
REMOVAL**

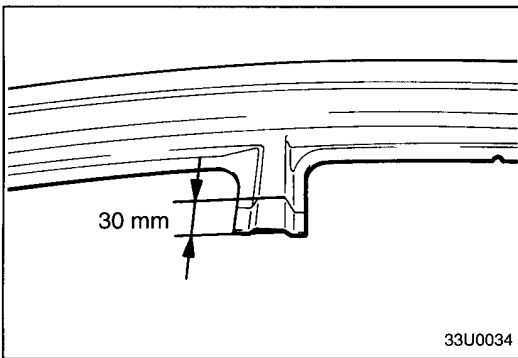
- (1) In order to cut the welding points between the center pillar seatbelt reinforcement and center pillar reinforcement, cut the lower part of the side roof rail inner as shown in the illustration.

NOTE

The cut side roof rail inner (A) will be reused, so it should be kept.

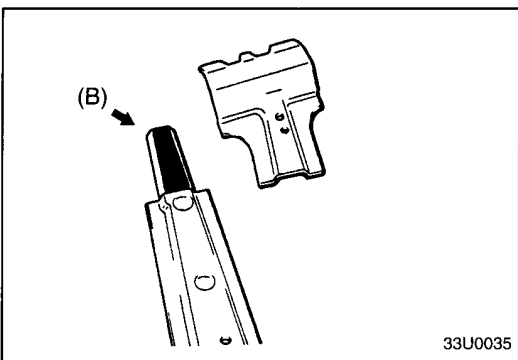


- (2) Make a rough cutting of the side sill as shown in the illustration in order to cut the welding points between the center pillar reinforcement and the side sill outer reinforcement.



INSTALLATION

- (1) When installing the center pillar outer and center pillar reinforcement to the body, cut the outer panel 30 mm above the cutting line of the center pillar.



- (2) Cut only the center pillar reinforcement from the new center pillar to correspond to the body.

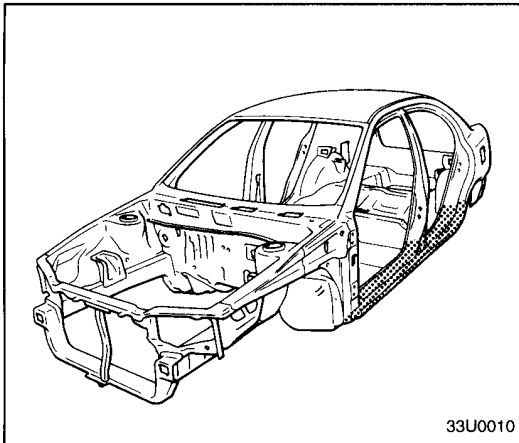
NOTE

Be careful not to damage the center pillar reinforcement upper and seatbelt reinforcement.

- (3) When installing the center pillar reinforcement to the body, apply adhesive to section (B) in the illustration.

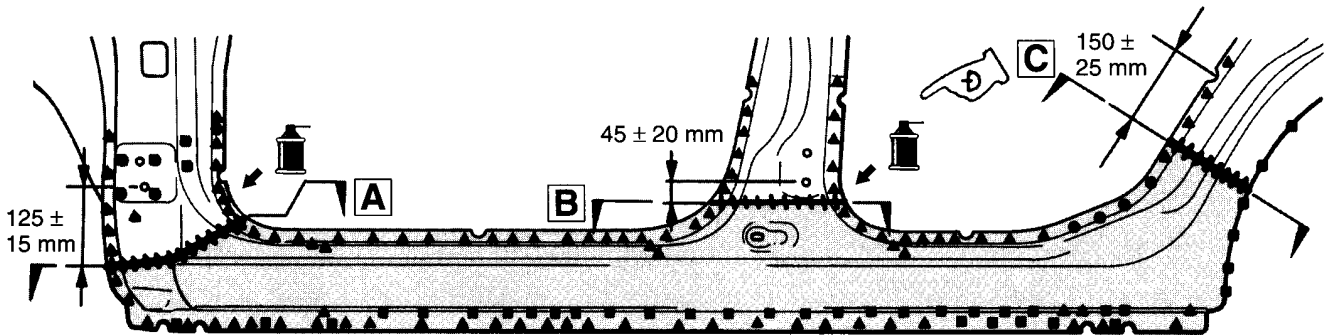
Adhesive	Type	Brand
		Epoxyresin adhesive

SIDE SILL

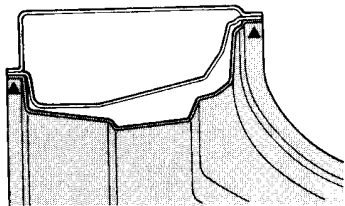


Symbol	Operation description
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding ■ indicates two panels to be welded ▲ indicates three panels to be welded
+ + + +	MIG spot welding
	MIG arc welding (continuous)
○ ○ ○ ○ ○ ○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.)

REPAIR WELDS

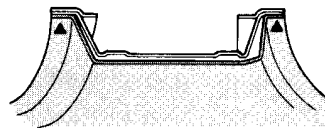


33U0025



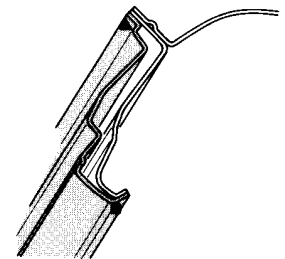
A

33U0026



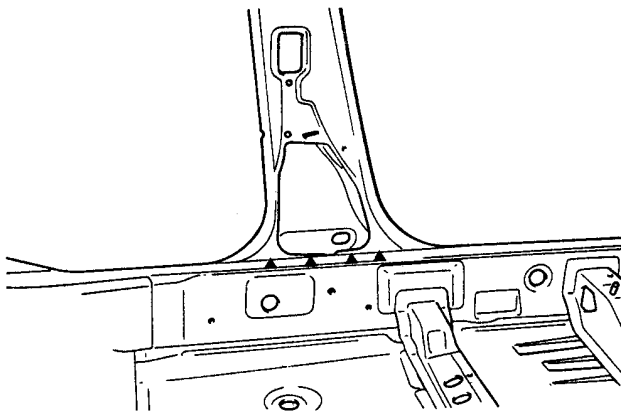
B

33U0027



C

33U0019



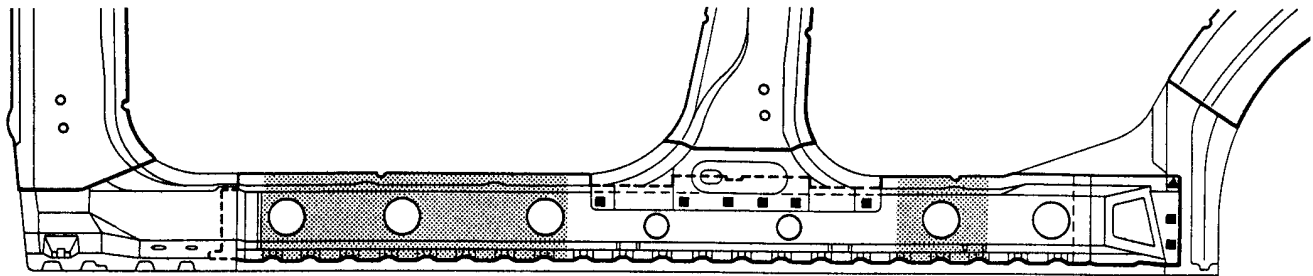
D

33U0028


NOTES WITH REGARD TO REPAIR WORK

<Side sill outer reinforcement>

Cut the side sill outer reinforcement 30 mm away from the butt-welding of the side sill outer.



(With the side sill outer removed)

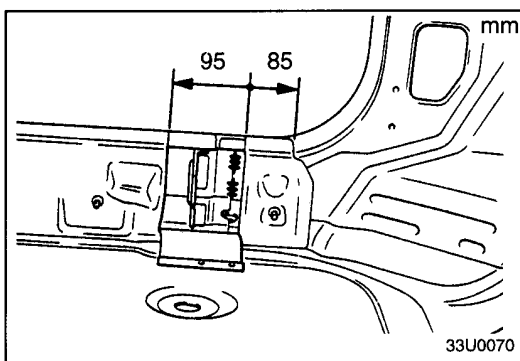
 : Area that can be cut

33U0029

REMOVAL

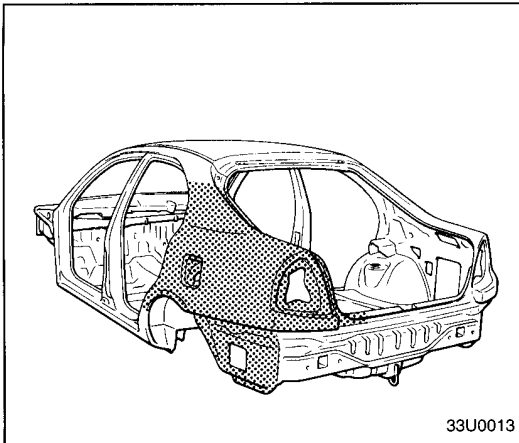
Caution


Take care not to damage the front pillar reinforcement lower and center pillar reinforcement when cutting the side sill outer.



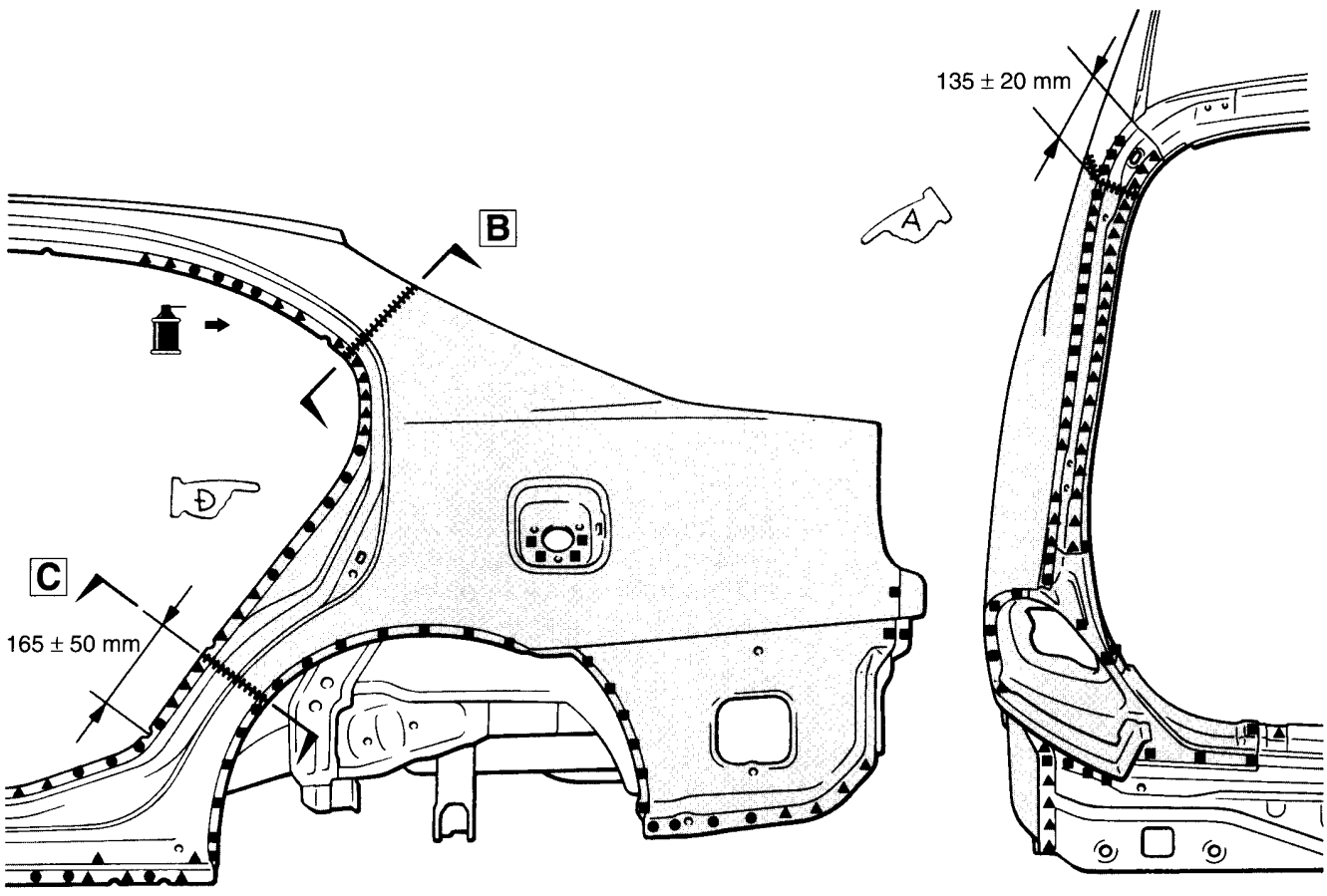
In order to cut the MIG arc welding between the side sill outer reinforcement lower and front pillar reinforcement lower, cut the front floor side sill inner as shown in the illustration.

QUARTER, OUTER



Symbol	Operation description
• • • •	Spot welding
■ ■ ▲ ▲	MIG plug welding ■ indicates two panels to be welded ▲ indicates three panels to be welded
+ + + +	MIG spot welding
	MIG arc welding (continuous)
○○○○○○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.)

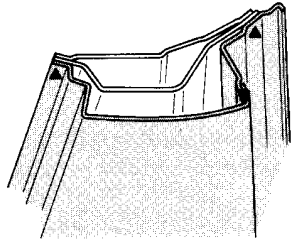
REPAIR WELDS



33U0050

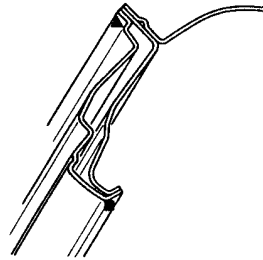
A

33U0052



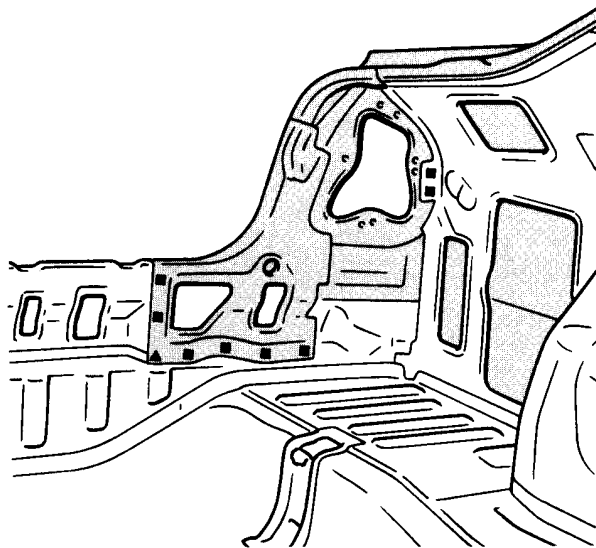
B

33U0021



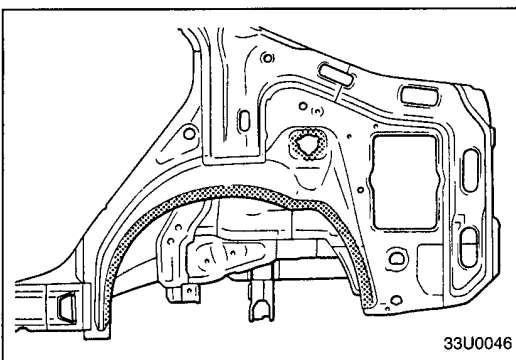
C

33U0019



D

33U0051



33U0046

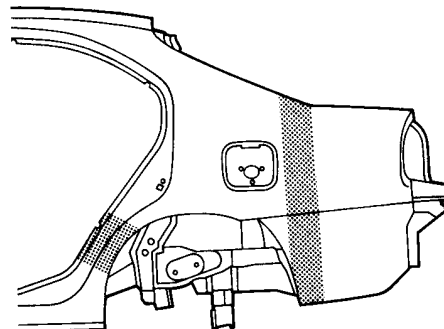
NOTES WITH REGARD TO REPAIR WORK


INSTALLATION

Apply body sealant to the wheel arch and fuel filler neck on the body side.

NOTE

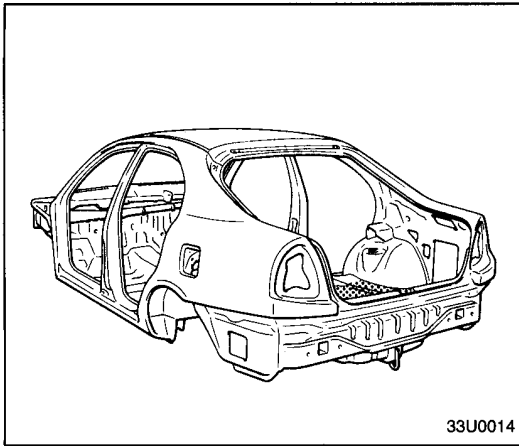
Depending on the size of the damaged area, parts can be replaced.




 : Area that can be cut

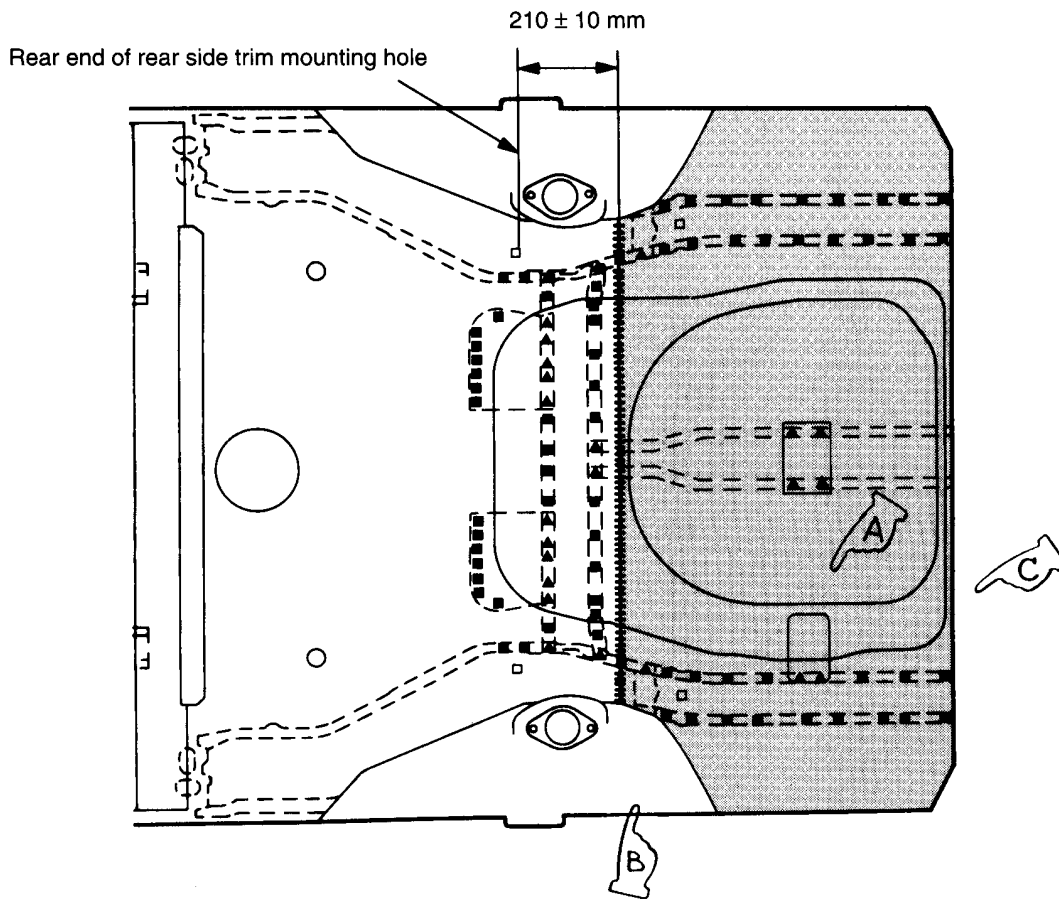
33U0053

REAR FLOOR



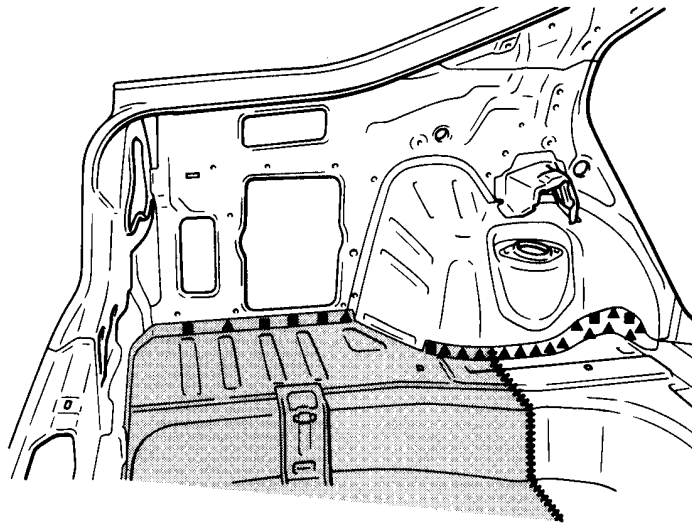
Symbol	Operation description
• • • •	Spot welding
■ ■ ▲ ▲	MIG plug welding ■ indicates two panels to be welded ▲ indicates three panels to be welded
+ + + +	MIG spot welding
	MIG arc welding (continuous)
○ ○ ○ ○ ○ ○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.)

REPAIR WELDS



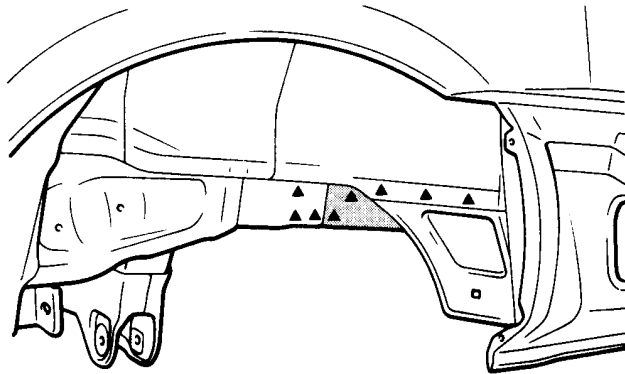
33U0054

NOTE
 Refer to P.3-18 for the rear end panel weld points.



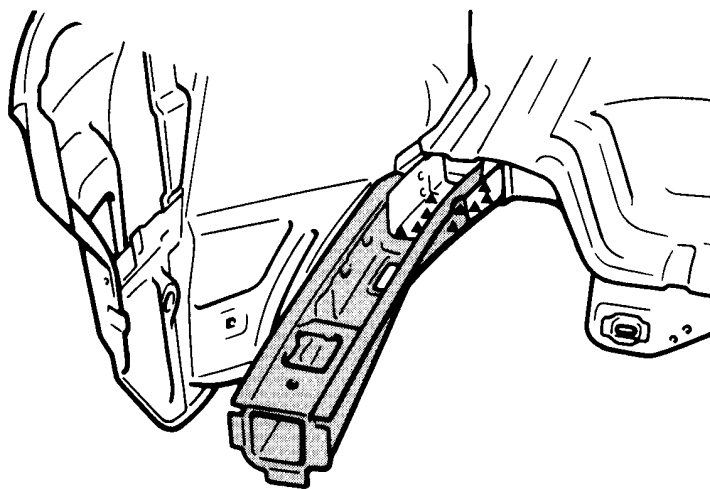
A

33U0049



B

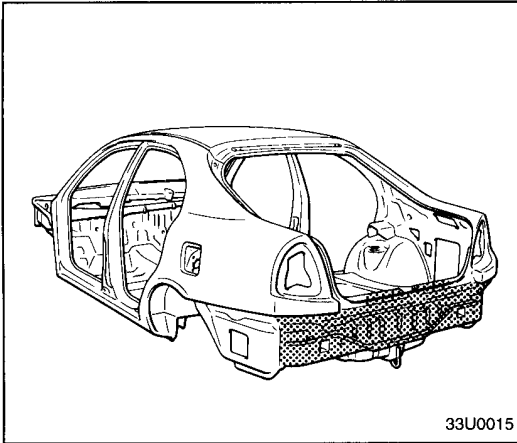
33U0055




C

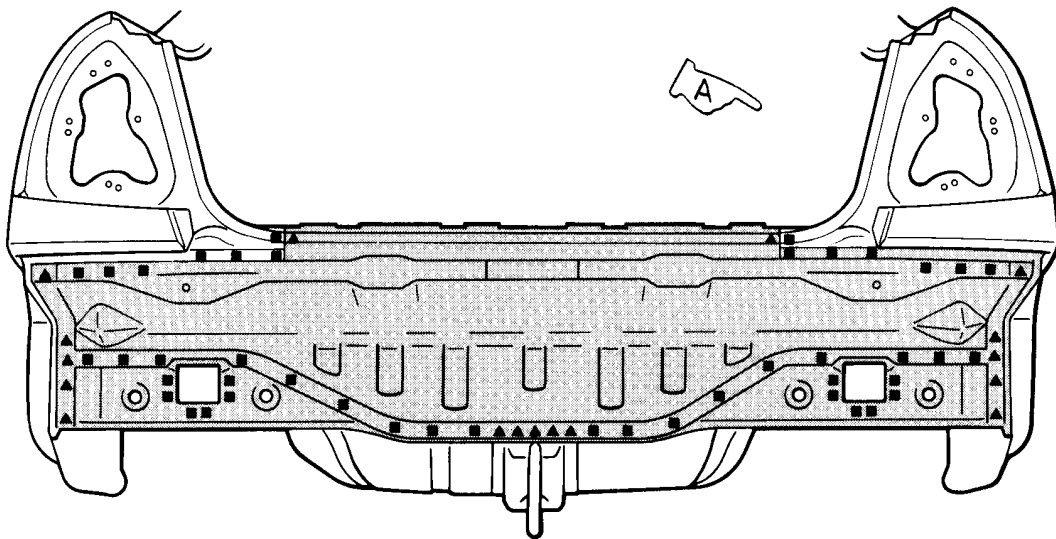
33U0056

REAR END PANEL

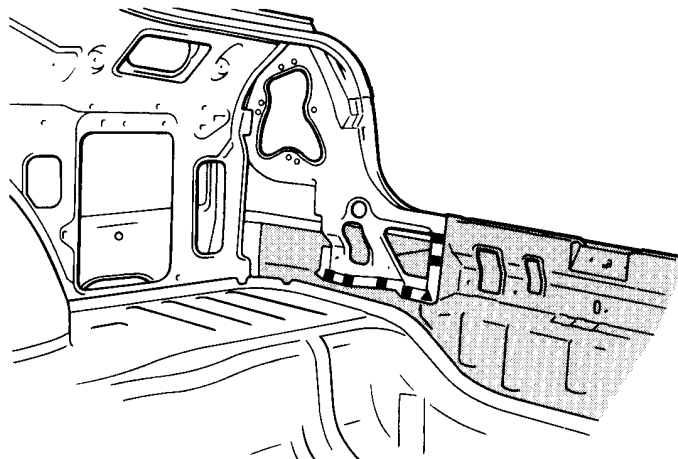


Symbol	Operation description
• • • •	Spot welding
■ ■ ▲ ▲	MIG plug welding ■ indicates two panels to be welded ▲ indicates three panels to be welded
+ + + +	MIG spot welding
	MIG arc welding (continuous)
○○○○○○○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.)

REPAIR WELDS



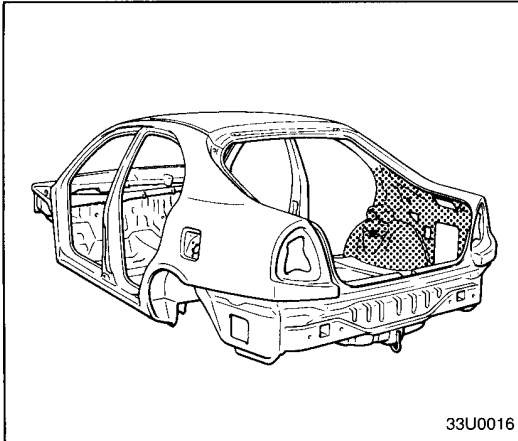
33U0004




33U0005

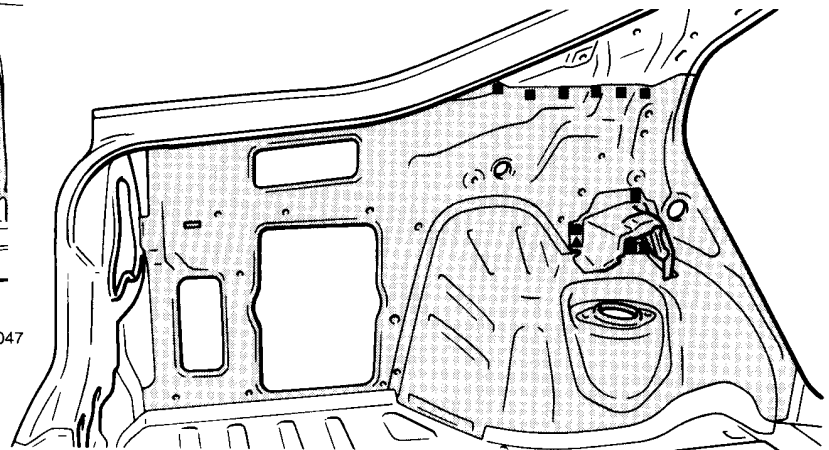
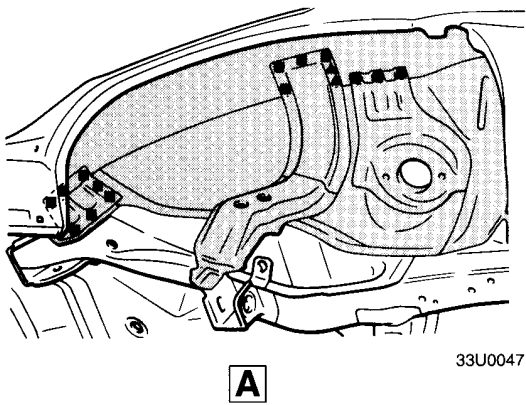
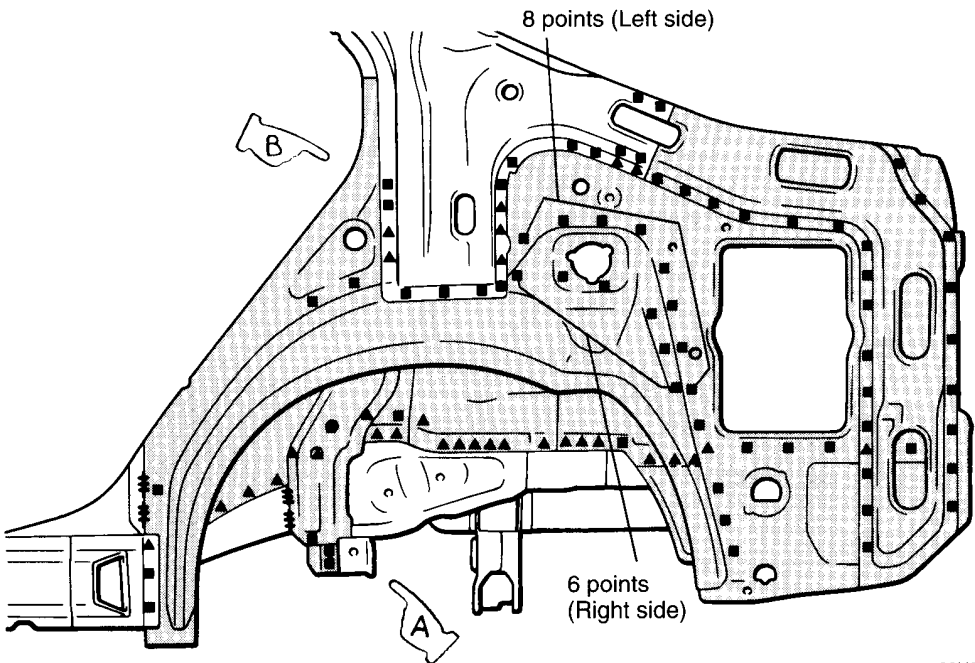
A

QUARTER, INNER



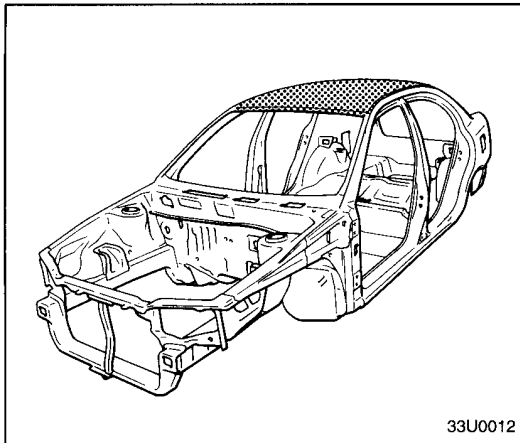
Symbol	Operation description
••••	Spot welding
■ ■ ▲ ▲	MIG plug welding ■ indicates two panels to be welded ▲ indicates three panels to be welded
+ + + +	MIG spot welding
	MIG arc welding (continuous)
○○○○○○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.)

REPAIR WELDS




NOTE
 Refer to P.3-14 for the quarter outer weld points.

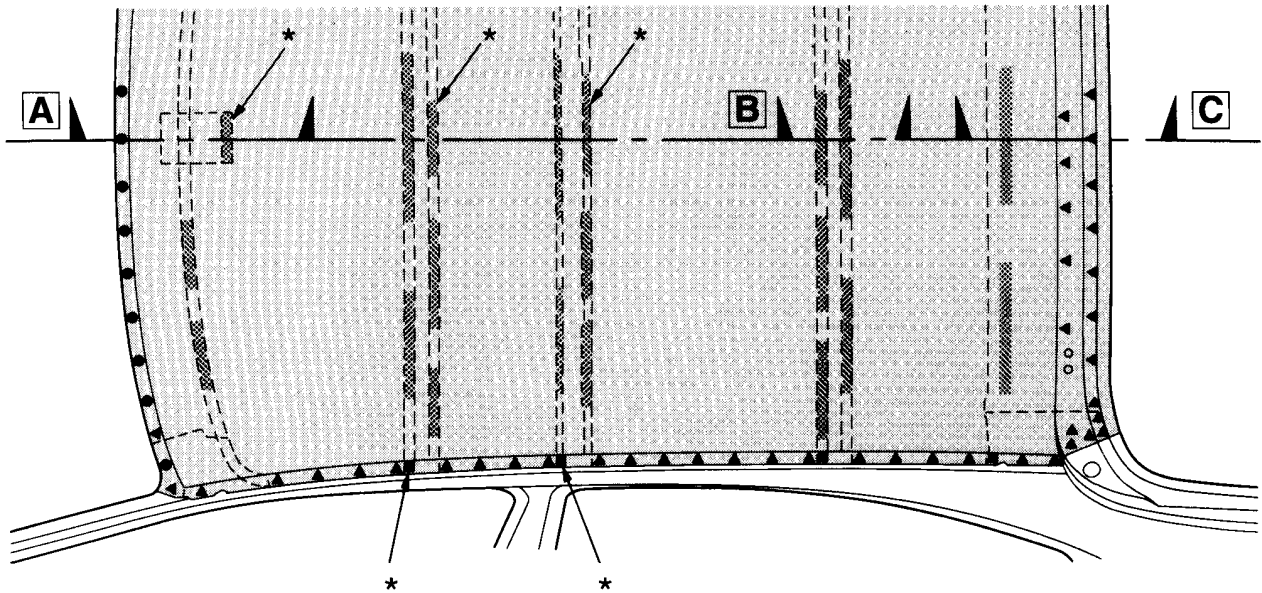
ROOF PANEL



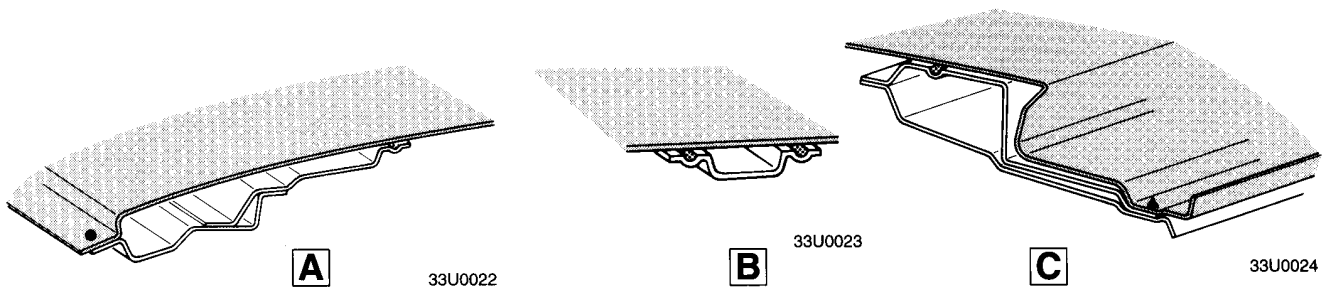
33U0012

Symbol	Operation description
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding ■ indicates two panels to be welded ▲ indicates three panels to be welded
+ + + +	MIG spot welding
	MIG arc welding (continuous)
○○○○○○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.)

REPAIR WELDS



33U0006



A

33U0022

B


33U0023

C

33U0024

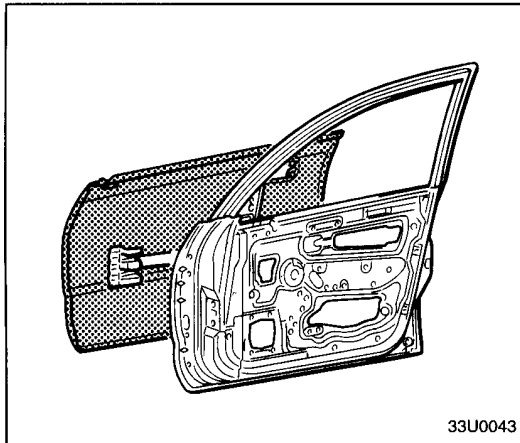
NOTE

* : Vehicles without sunroof

 : Adhesive

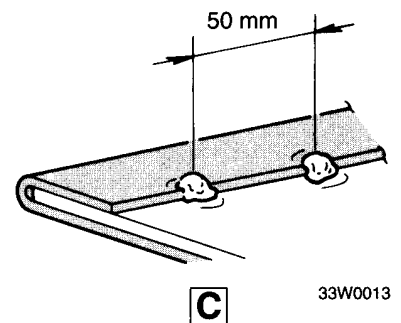
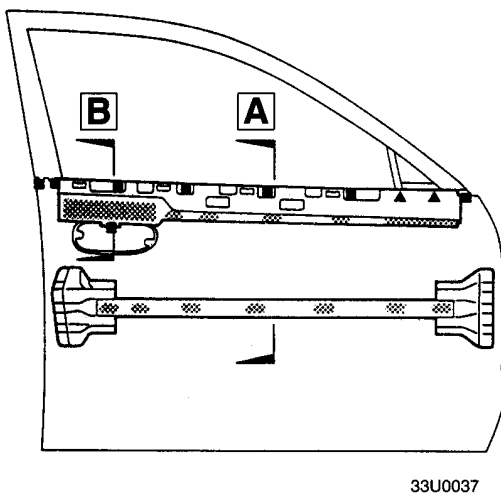
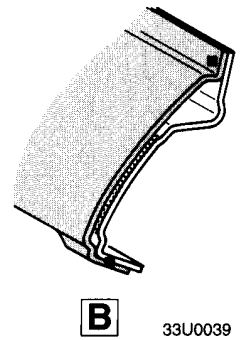
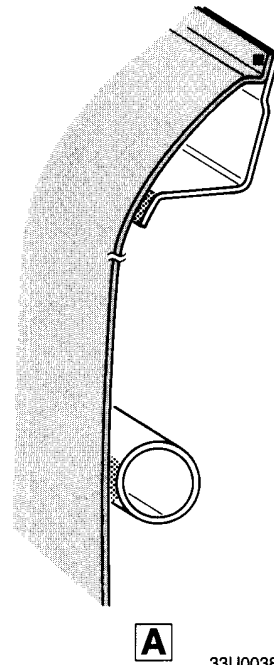
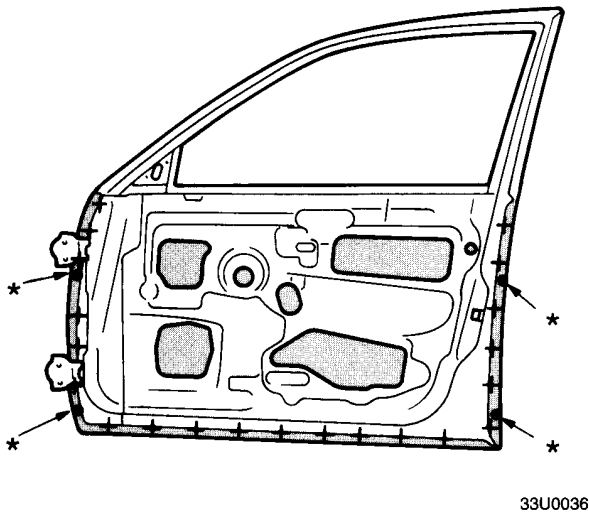
Adhesive	Type
	Chloroprene-base drying sealant

FRONT DOOR OUTER PANEL



Symbol	Operation description
• • • •	Spot welding
■ ■ ▲ ▲	MIG plug welding ■ indicates two panels to be welded ▲ indicates three panels to be welded
+ + + +	MIG spot welding
	MIG arc welding (continuous)
○○○○○○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.)

REPAIR WELDS



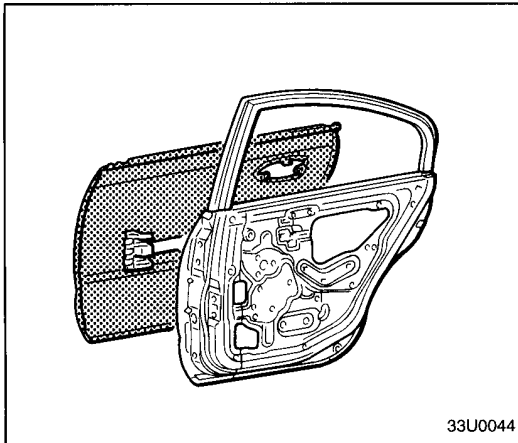
: Adhesive

Adhesive	Type
	Chloroprene-base drying sealant


NOTES

- (1) Weld point * indicates manufacturer's welding joint.
(Unnecessary at repair work)
- (2) After hemming the door outer panel, MIG spot weld the flange overlap section at a pitch of approx. 50 mm.

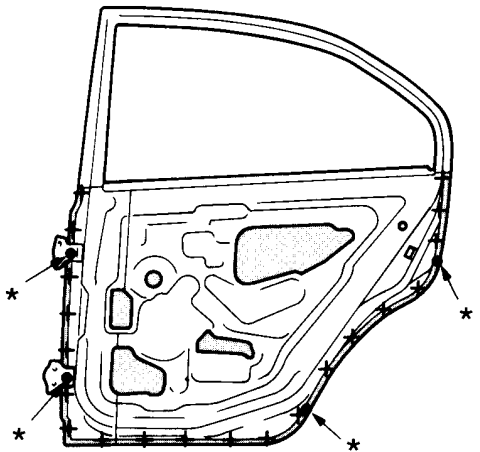
REAR DOOR OUTER PANEL



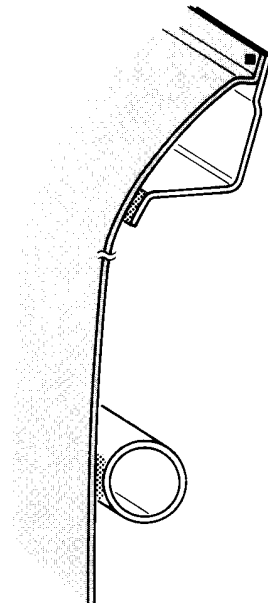
33U0044

Symbol	Operation description
• • • •	Spot welding
■ ■ ▲ ▲	MIG plug welding ■ indicates two panels to be welded ▲ indicates three panels to be welded
+ + + +	MIG spot welding
	MIG arc welding (continuous)
○ ○ ○ ○ ○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.)

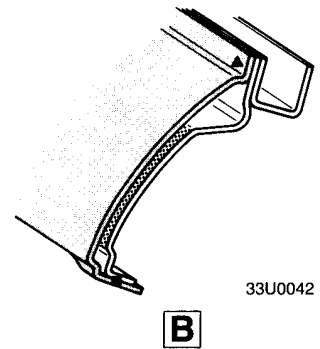
REPAIR WELDS



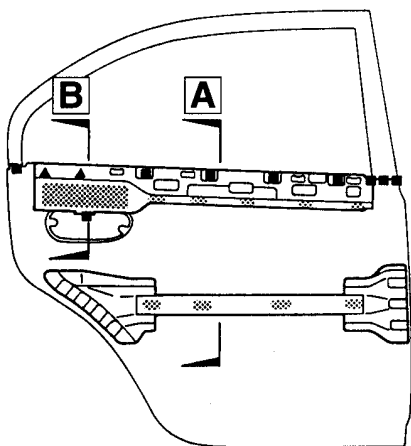
33U0040



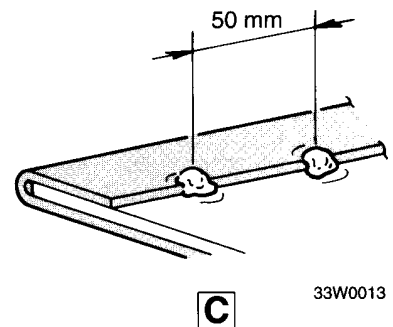
A 33U0038



33U0042



33U0041



33W0013

 : Adhesive

Adhesive	Type
	Chloroprene-base drying sealant

NOTES

- (1) Weld point * indicates manufacturer's welding joint. (Unnecessary at repair work)
- (2) After hemming the door outer panel, MIG spot weld the flange overlap section at a pitch of approx. 50 mm.