

GROUP 3

WELDED PANEL REPLACEMENT

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ULTRA HIGH STRENGTH STEEL PLATE

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ADVANTAGES OF ULTRA HIGH STRENGTH STEEL PLATE

The ultra high strength steel plate has the following advantages as compared with conventional high strength steel plate.

- It has tensile strength approximately 1.7 times higher than the conventional high strength steel sheet.
- It has a higher yielding point and yielding ratio (yielding point/tensile strength).

These advantages allow thinner and lighter plates and better fuel efficiency than the high strength steel plate.

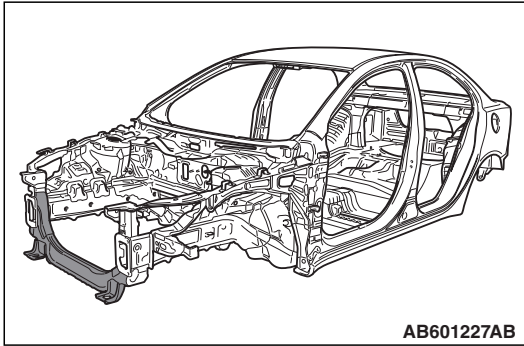
PRECAUTION UPON MAINTENANCE OF ULTRA HIGH STRENGTH STEEL PLATE

- Use a spot cutter for ultra high strength steel plate to ensure that the spot-welded area is cut off.

- For the part in which the ultra high strength steel plate is used, do not repair it by cutting and bonding to avoid the reduction in strength by heat. Instead, replace the whole assembly including the part.
- Be careful with rough extending work, because the ultra high strength steel plate has higher tensile strength and a higher yielding point than high strength steel plate and general steel plate. Careless work will cause symptom such as over-pulling and springback. Do not extend it completely at a time. Do it gradually while removing the distortion by sheet metal processing with a hammer.
- Plug welding of ϕ 8 mm (0.31 inch) diameter plug for repair ensures the strength equivalent to spot welding for 2 steel sheets. For 3 sheets, weld 2 sheets each time instead of welding from one side to give sufficient welding strength.

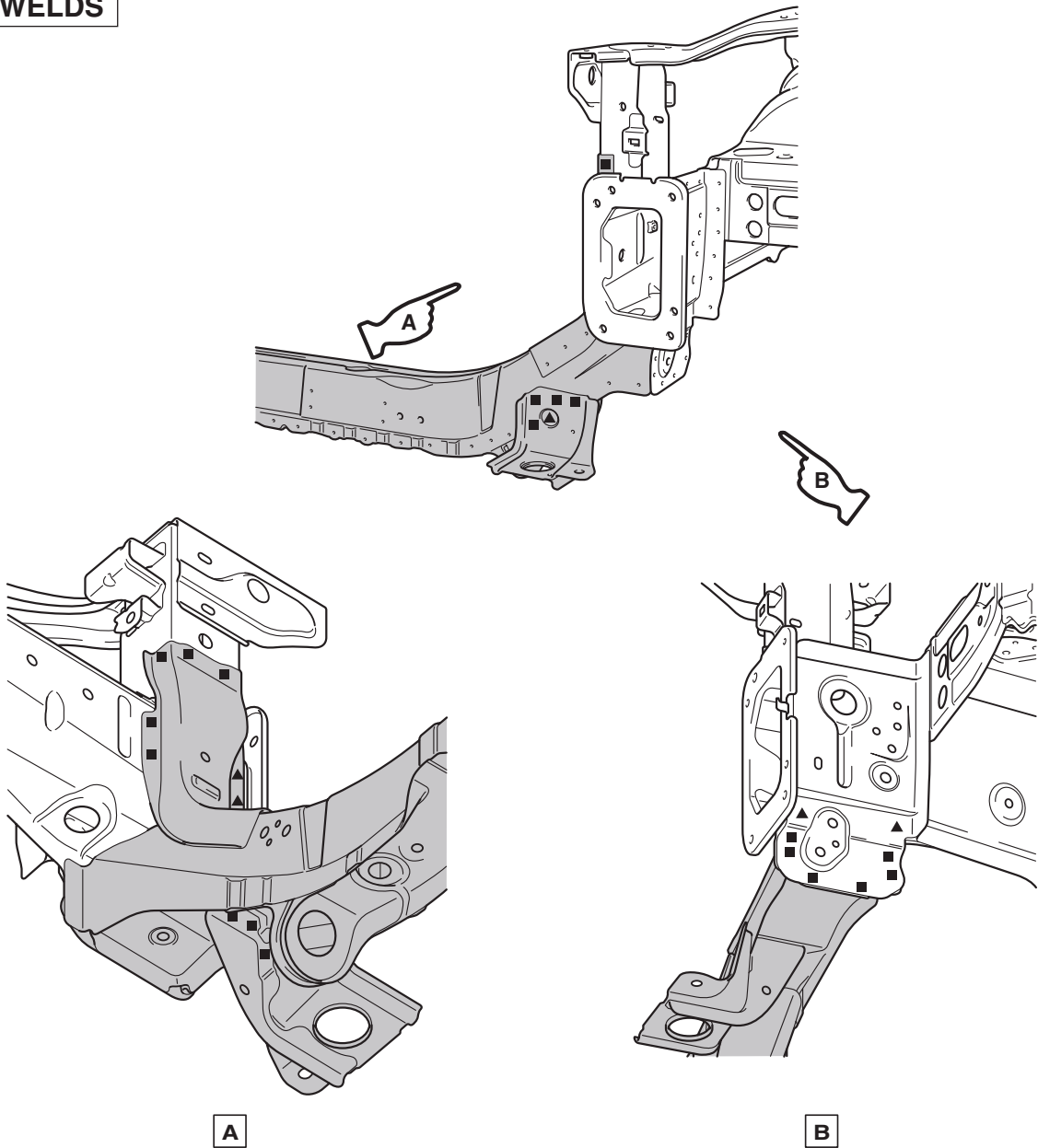
FRONT END CROSSMEMBER

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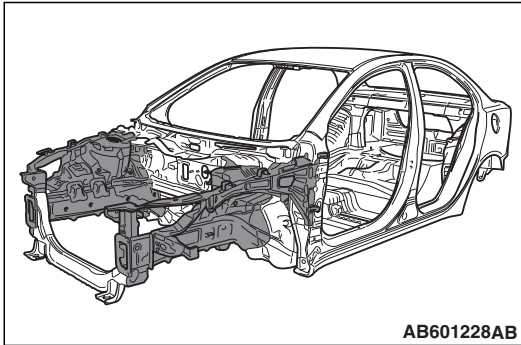
SYMBOL	OPERATION DESCRIPTION
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded) (▲: indicates three panels to be welded)
++++	MIG spot welding
	MIG arc welding (continuous)
○○○○○○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally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


REPAIR WELDS



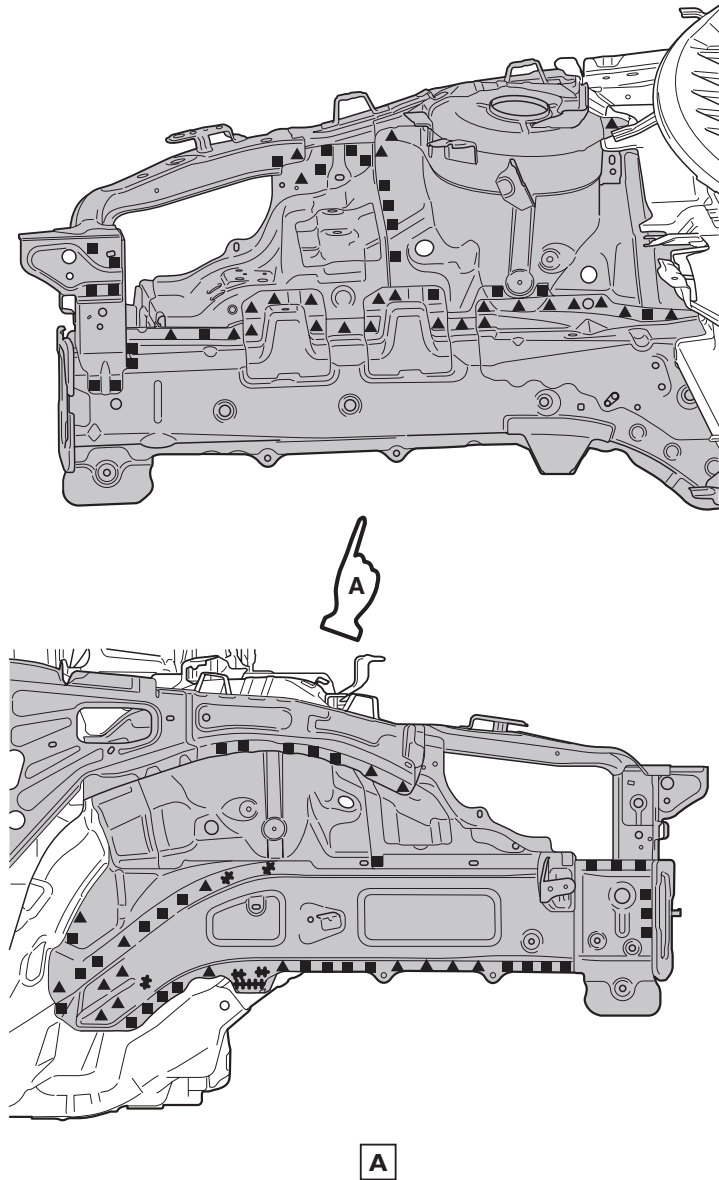
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FENDER SHIELD

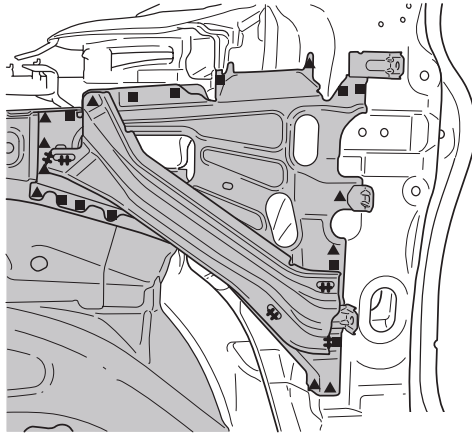


SYMBOL	OPERATION DESCRIPTION
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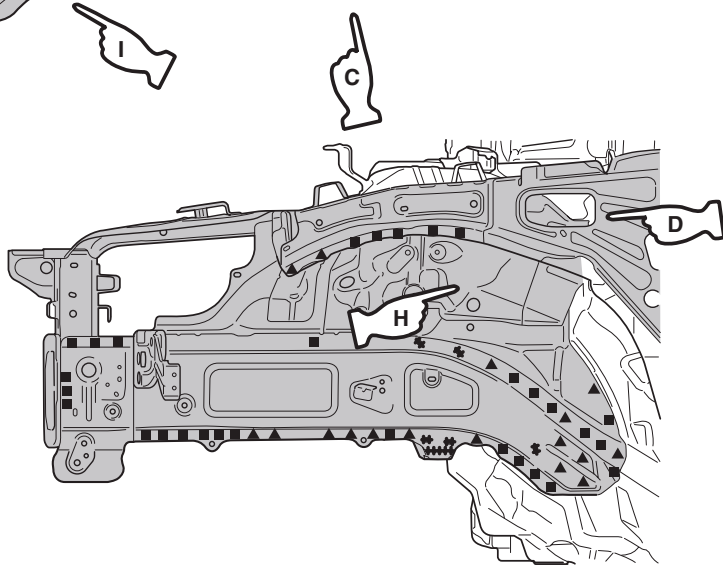
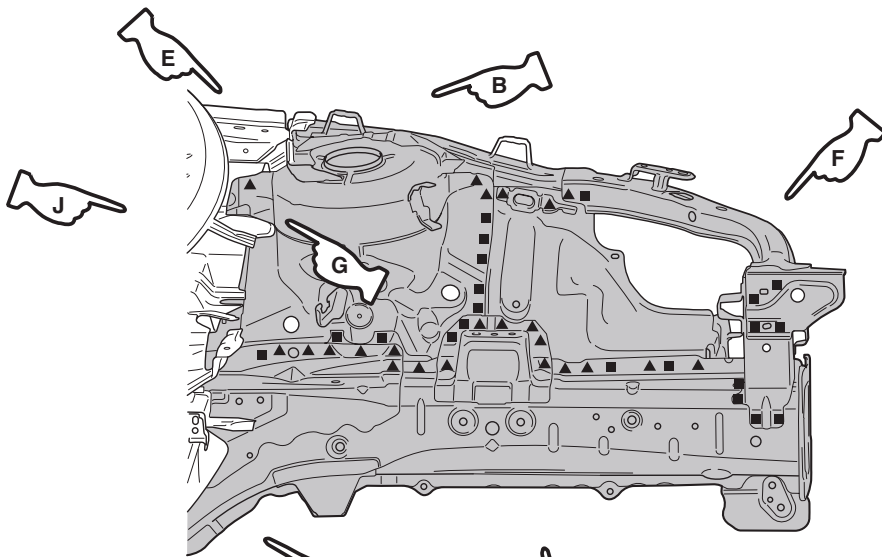
REPAIR WELDS



NOTE: Refer to the Front End Crossmember section on P.3-3 for the welding point with front end crossmember.

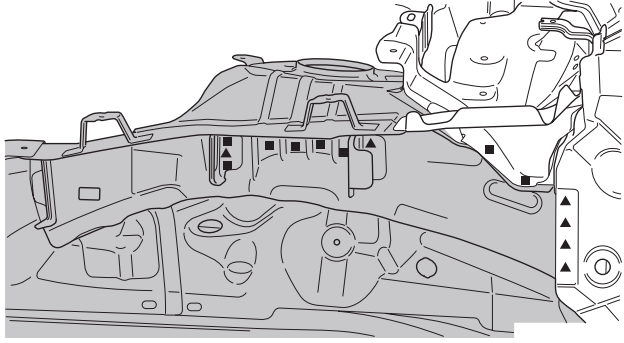


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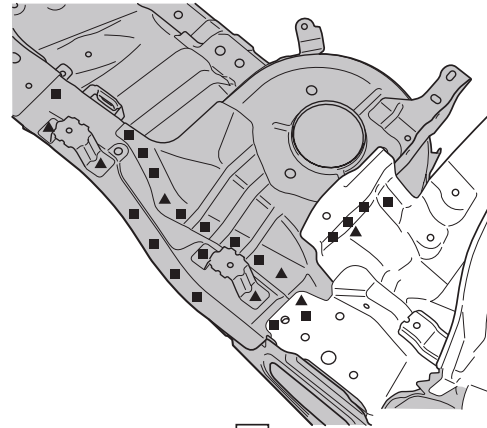


C

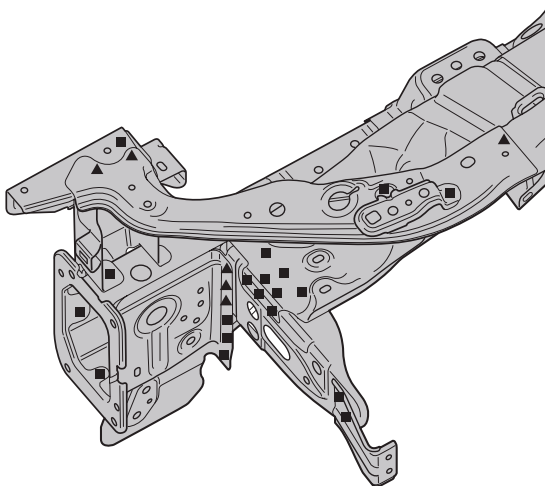
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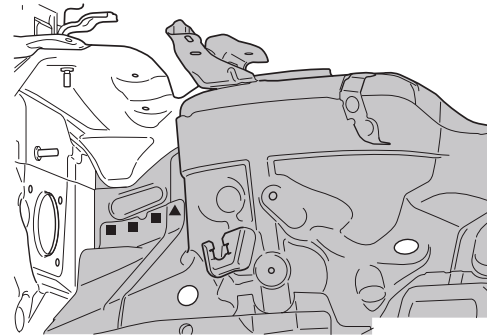
D
(With the front upper frame outer removed)



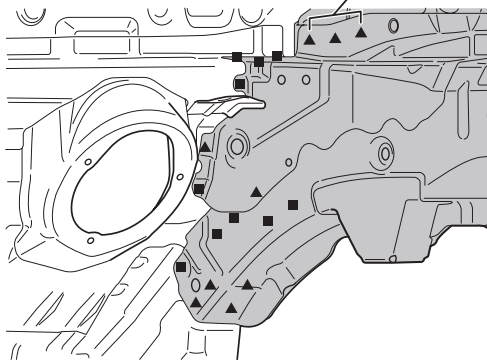
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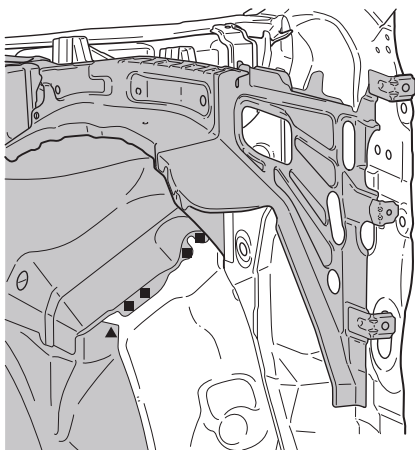
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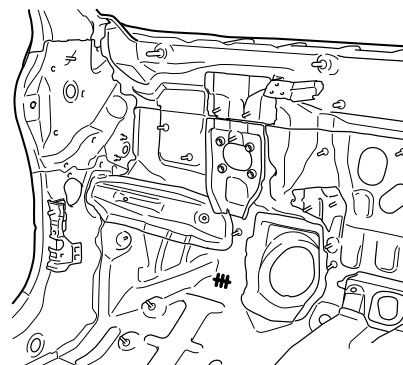
G
3 points
on left
side only



I

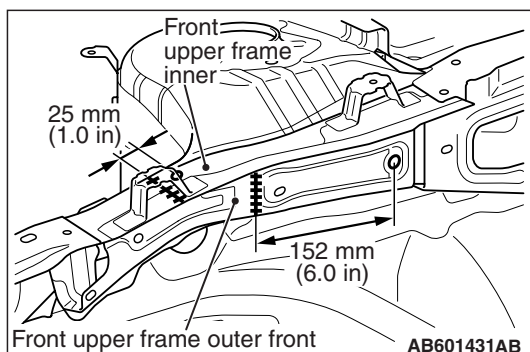


H



J

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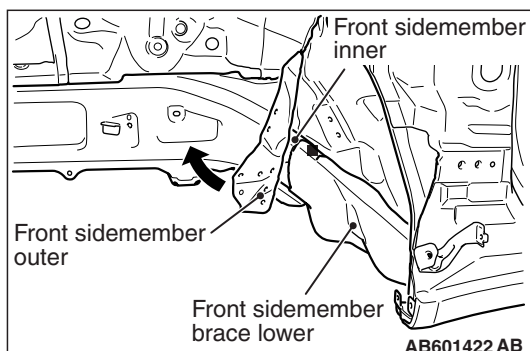


NOTE: Partial replacement of the front upper frame is possible depending on the range of damage. When performing partial replacement, cut the front upper frame outer front 152 mm (6.0 inches) forward of the positioning hole center, and cut the front upper frame inner 25 mm (1.0 inches) forward of the positioning hole center.

NOTE ON REPAIR WORK

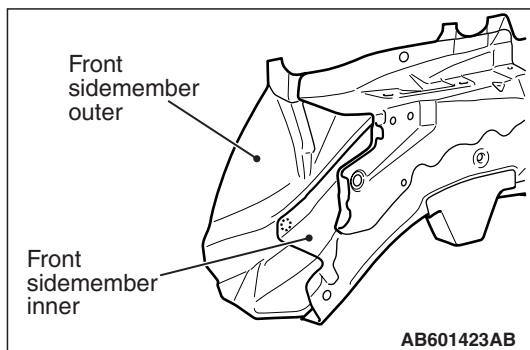
REMOVAL

Turn up the front sidemember outer as shown to cut off the welded point between the front sidemember inner and the front sidemember brace lower.



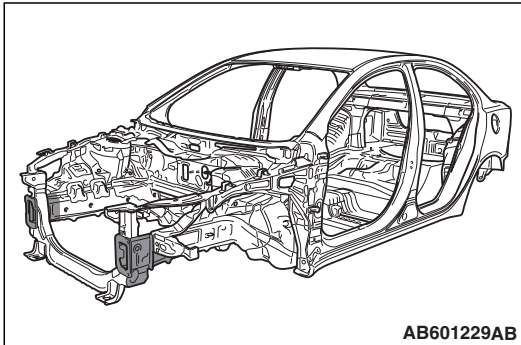
INSTALLATION

1. When installing the new front sidemember, align the hole of the front sidemember brace lower with the front sidemember outer to make a hole because the front sidemember outer prevents the front sidemember inner and front sidemember brace lower from being welded. Then, weld the front sidemember outer, front sidemember inner, and front sidemember brace lower.



FRONT SIDEMEMBER (PARTIAL REPLACEMENT)

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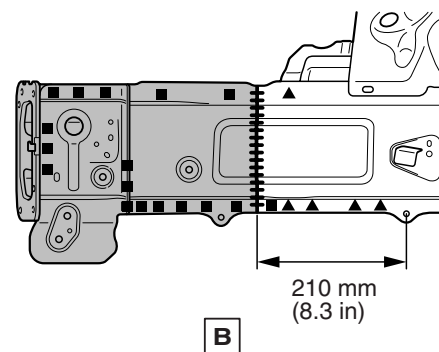
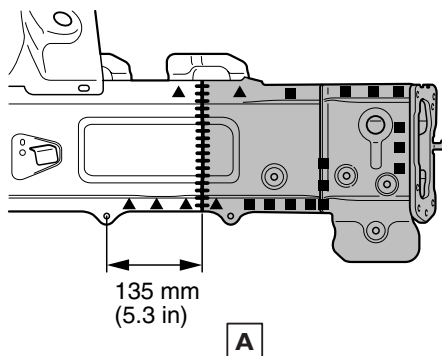
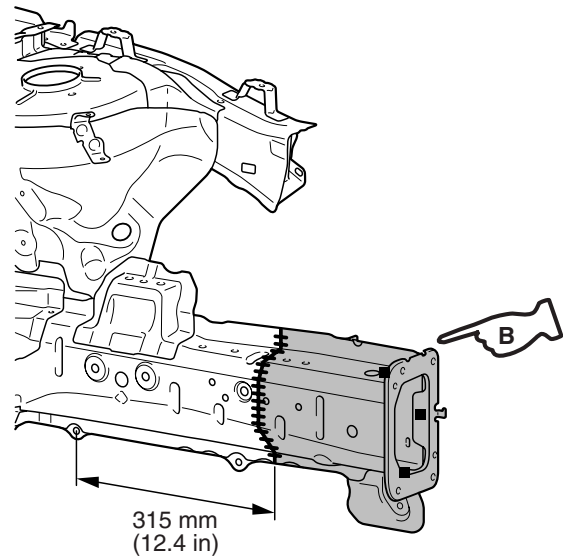
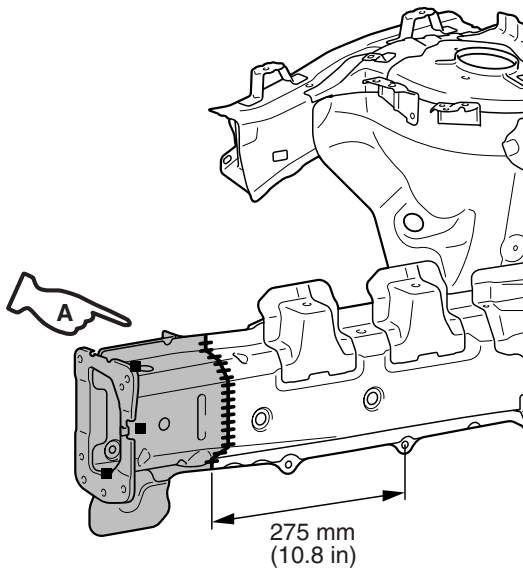


SYMBOL	OPERATION DESCRIPTION
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
++++	MIG spot welding
	MIG arc welding (continuous)
○○○○○○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally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

REPAIR WELDS

Right side

Left side



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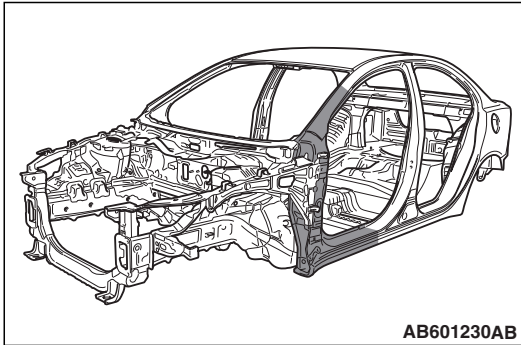
NOTE:

- Refer to the Front End Crossmember section on P.3-3 for the welding point with front end crossmember.
- Refer to the Fender Shield section on P.3-4 for the welding points with the front fender Shield front.

NOTES

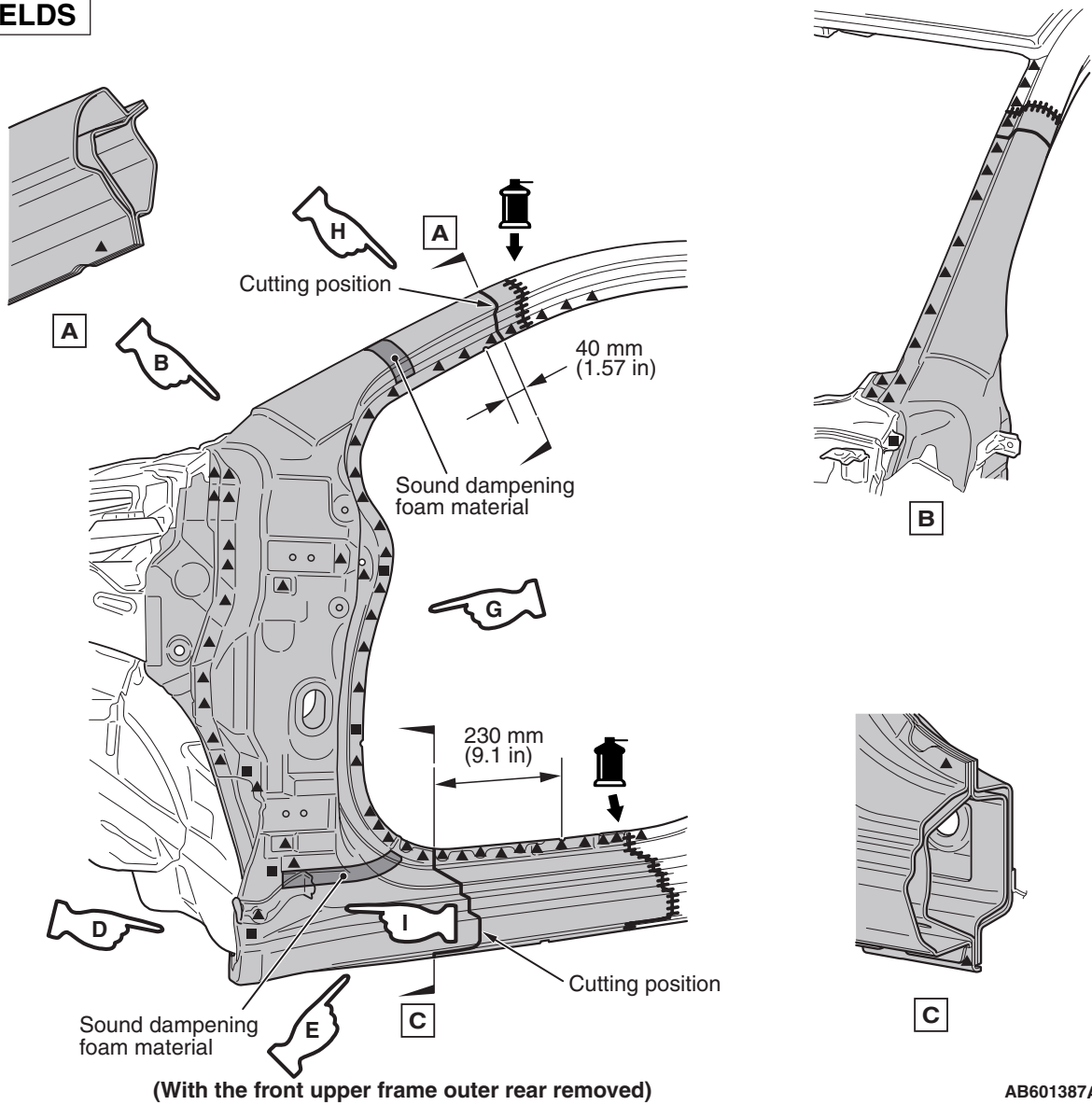
FRONT PILLAR

M4030005001165



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)
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	Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.)

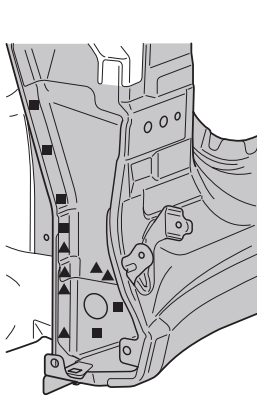
REPAIR WELDS



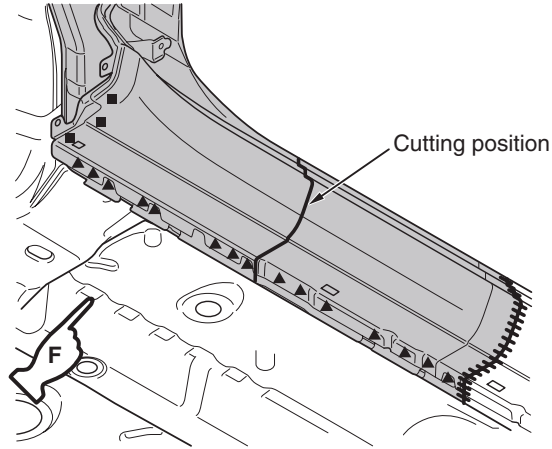
CAUTION

When repairing the area using sound dampening foam material do not use firing tools since the sound dampening foam material may burn.

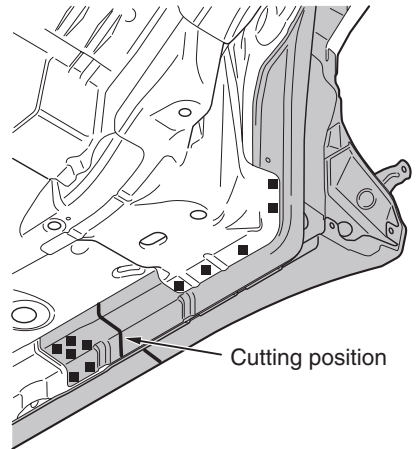
NOTE: Refer to the Fender Shield section on P.3-4 for the welding points with the front upper frame outer rear.



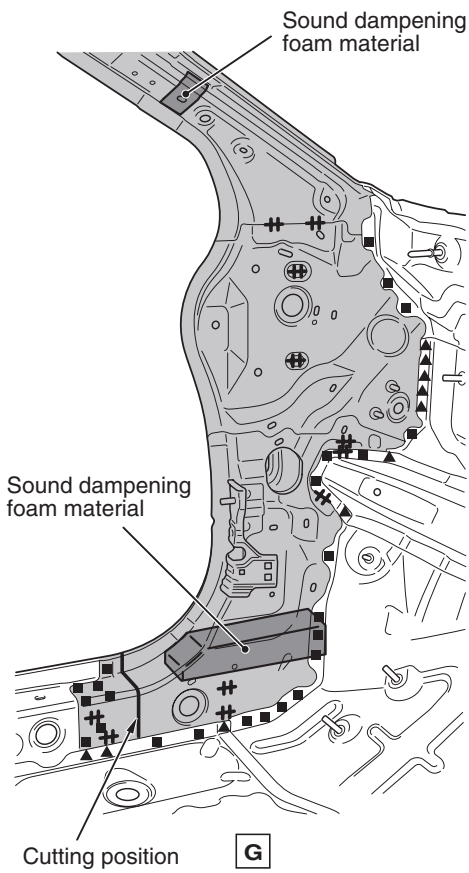
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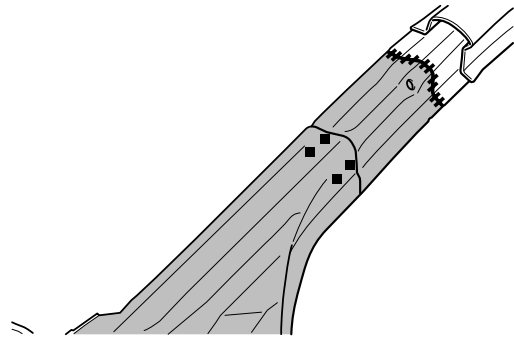
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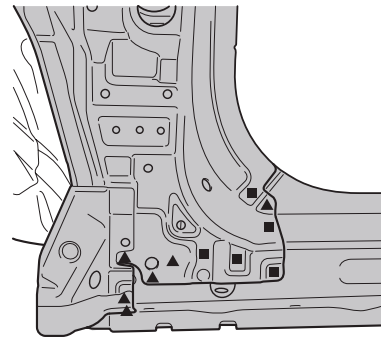


G



H

(With the side outer panel removed)



I

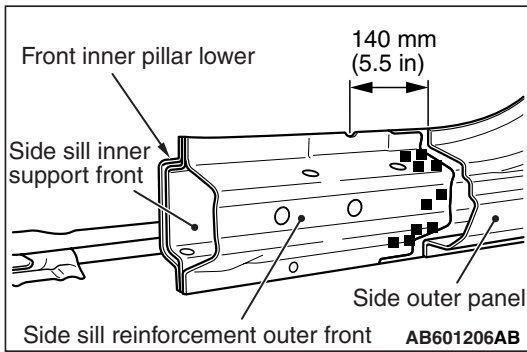
(With the side outer panel removed)

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NOTE ON REPAIR WORK

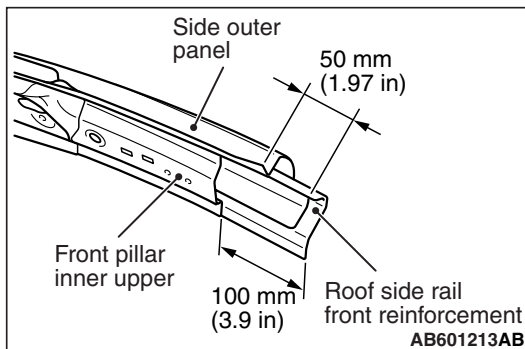
REMOVAL

After removing the front pillar, cut the side outer panel 140 mm (5.5 inches) behind the positioning notch to remove the side sill reinforcement outer front, side sill inner support front, and front inner pillar lower remaining on the body side.

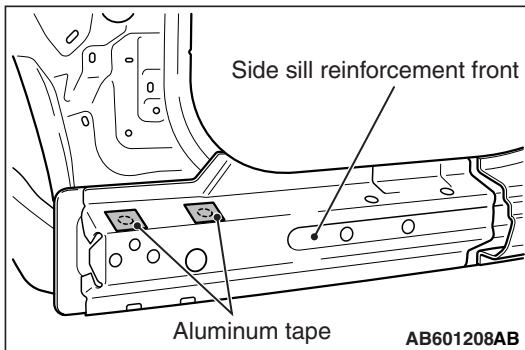


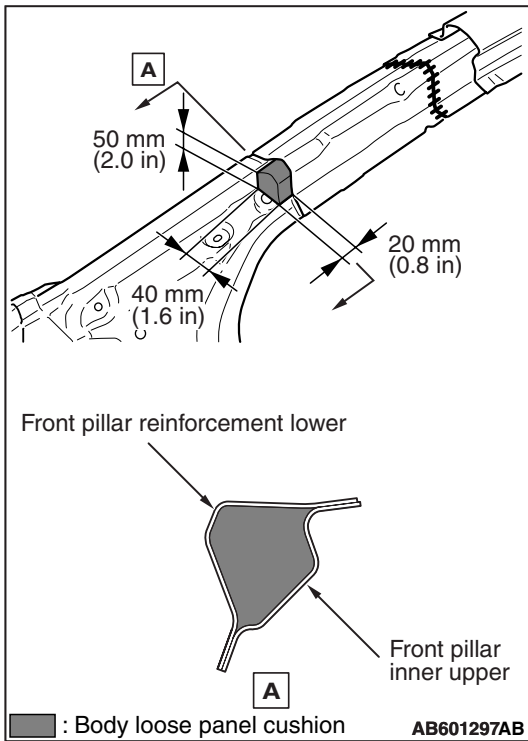
INSTALLATION

1. To reinforce the strength in the front pillar cut area, cut the side outer panel 100 mm (3.9 inches) above the cut area and cut the front inner pillar upper 50 mm (1.97 inches) above the cut area.
2. Assemble the new front pillar inner lower parts.
3. Assemble the new front pillar inner upper part.

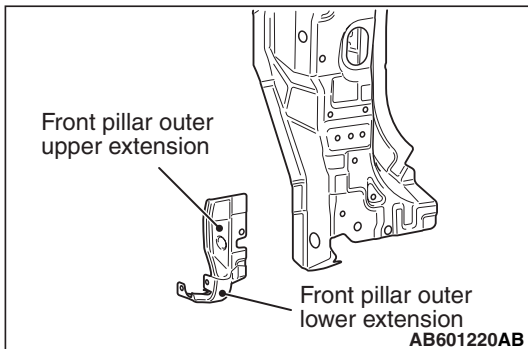


4. Assemble the new side sill reinforcement front parts. After that, cover the hole with aluminum tape to prevent the sound dampening foam material from dropping when the material is filled into the front pillar in the next process.

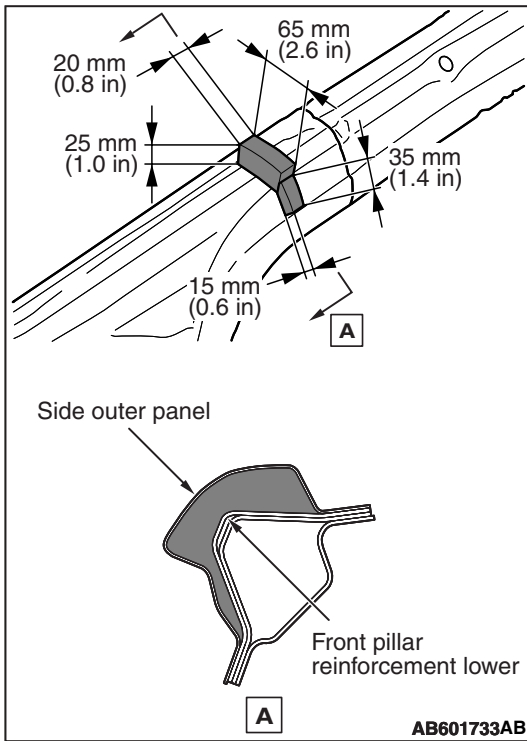




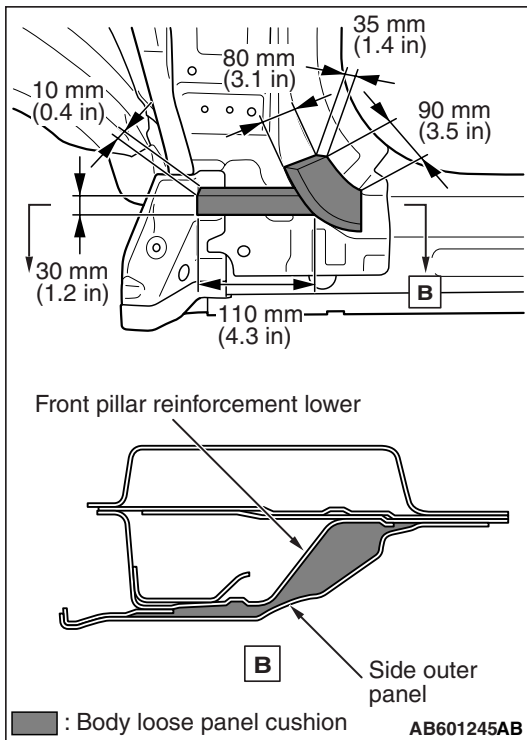
5. Align the new roof side rail reinforcement to the body side to cut and install. After that, machine the body loose panel cushion (MR535301 or MR435765) as shown and apply it to the body side to prevent the sound dampening foam material from dropping when the material is filled into the front pillar in the next process.



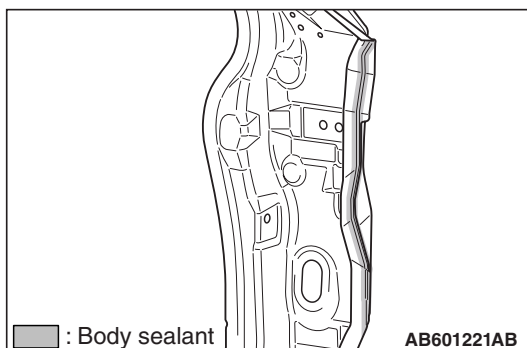
6. When installing the new front pillar lower reinforcement is installed, remove the front pillar outer lower extension and front pillar outer upper extension in advance, and install the front pillar lower reinforcement because there are some points which cannot be welded on the body side. After that, install the front pillar outer lower extension and front pillar outer upper extension.



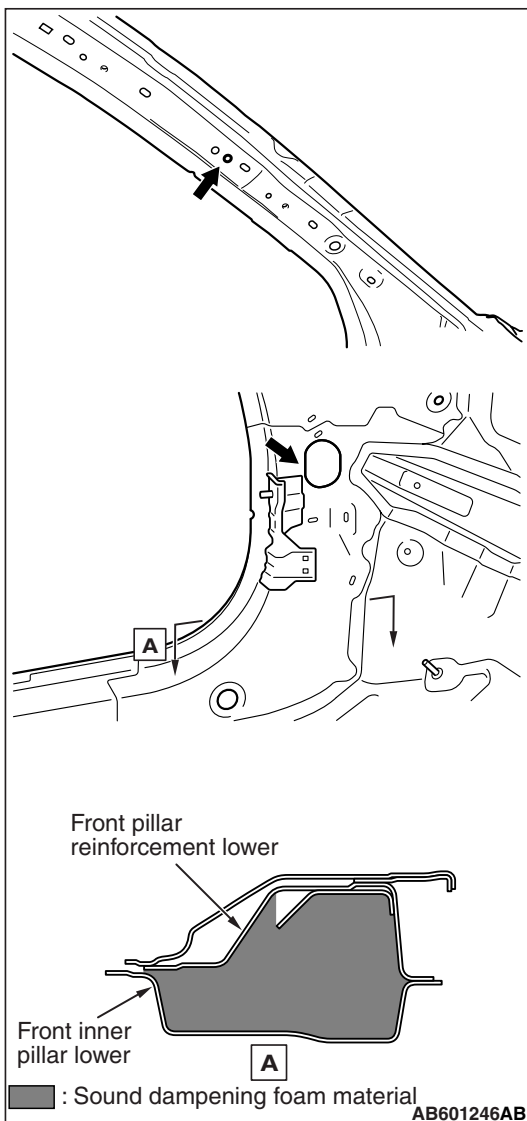
7. When installing the new front pillar outer, machine the body loose panel cushion (MR535301 or MR435765) as shown and apply it to the body side to prevent the sound dampening foam material from dropping when the material is filled into the front pillar upper in the next process (for front pillar upper).



8. When installing the new front pillar outer, machine the body loose panel cushion (MR535301 or MR435765) for replacement as shown and apply it to the body side because the sound dampening foam material is filled into the front pillar (for front pillar lower).

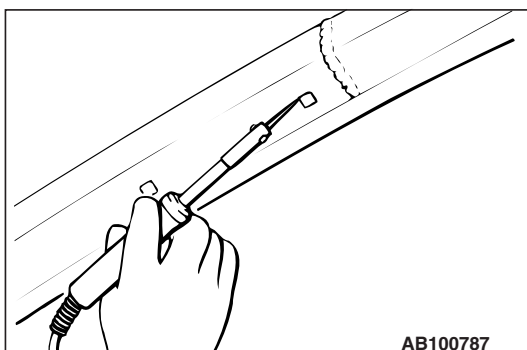


9. When installing the new front pillar outer, apply the body sealant to the areas as shown in advance.



10. Assemble the front pillar outer, bolt and tape the hole and flange with aluminum tape, then fill the hole with sound dampening foam material as shown in the figure of the instructions.

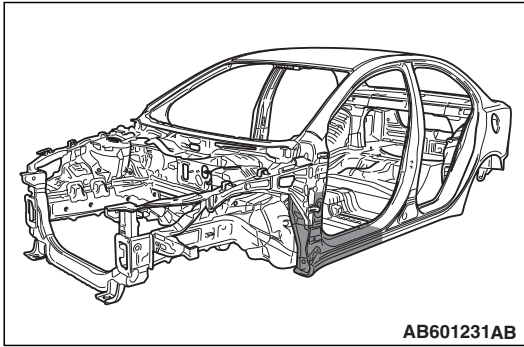
**SOUND DAMPENING FOAM MATERIAL: 3M™ AAD
ULTRAPRO Panel foam-Yellow**



11. Wait 2 hours after filling the sound dampening foam material to remove the bolt and aluminum tape, then melt the sound dampening foam material with a soldering gun so a clip, etc. can thoroughly be inserted in the hole filled with sound dampening foam material.

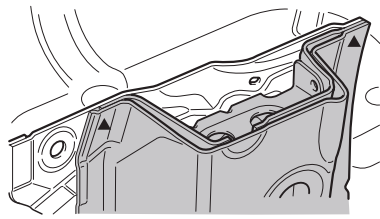
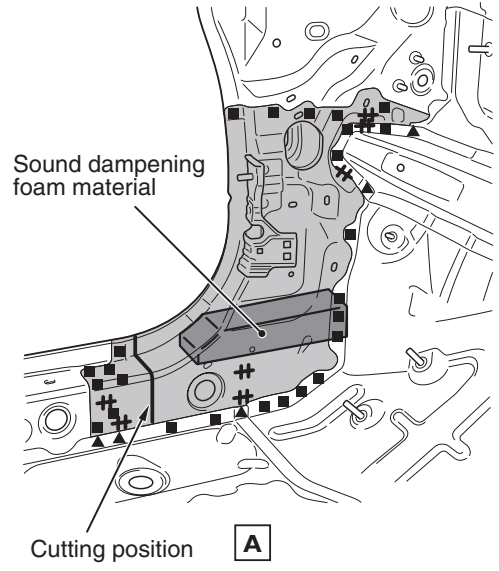
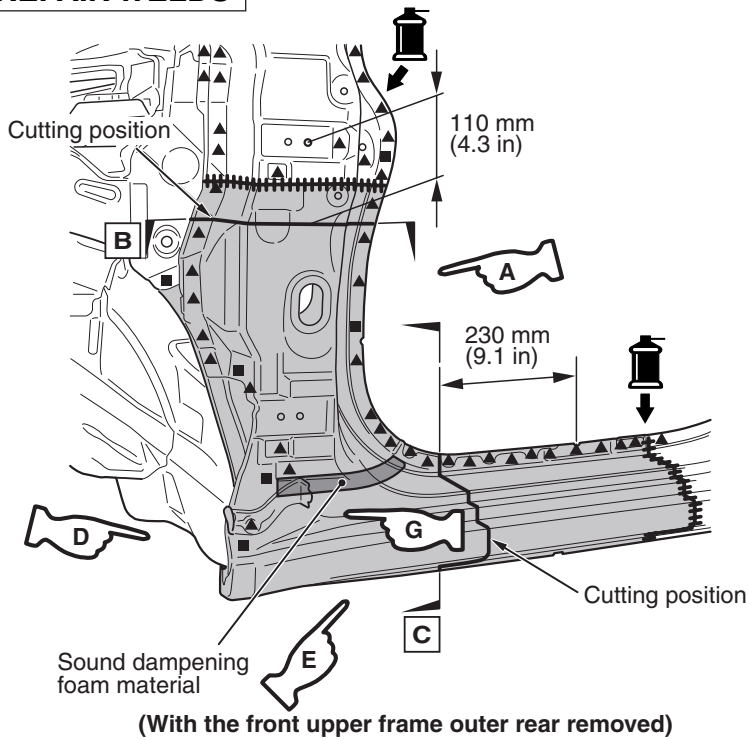
FRONT PILLAR (PARTIAL REPLACEMENT)

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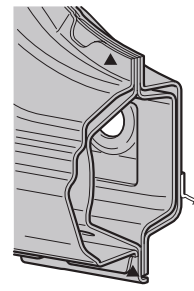


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REPAIR WELDS



B



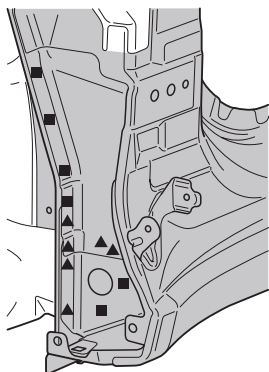
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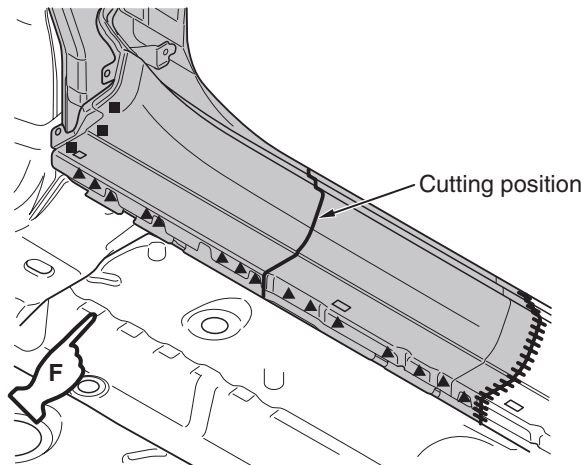
CAUTION

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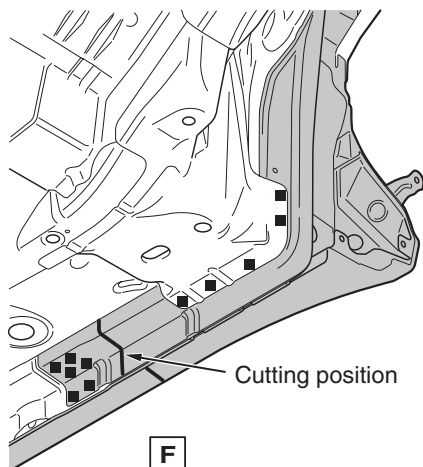
NOTE: Refer to the Fender Shield section on P.3-4 for the welding points with the front upper frame outer rear.



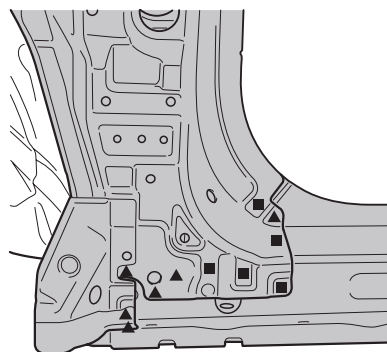
D



E



F



G

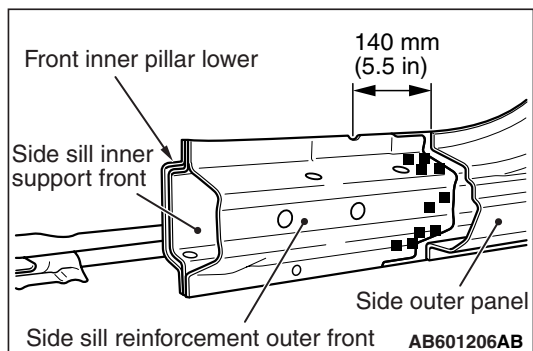
(With the side outer panel removed)

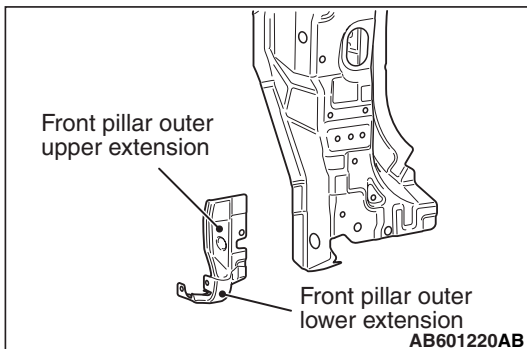
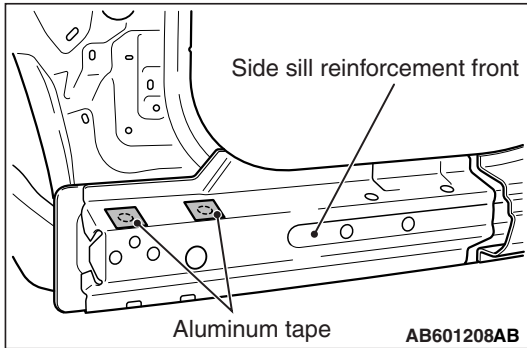
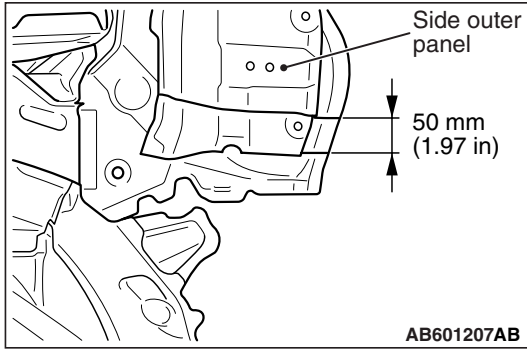
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NOTE ON REPAIR WORK

REMOVAL

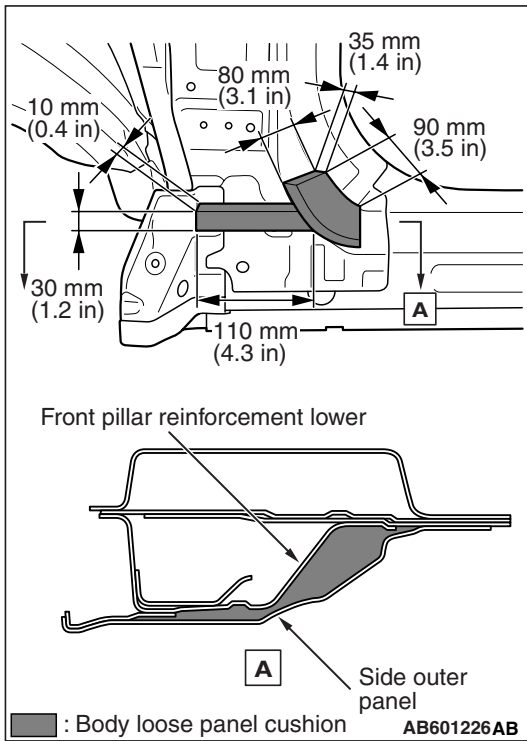
After removing the front pillar, cut the side outer panel 140 mm (5.5 inches) behind the positioning notch to remove the side sill reinforcement outer front, side sill inner support front, and front inner pillar lower remaining on the body side.



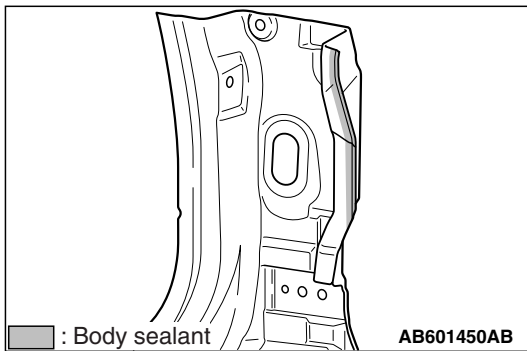


INSTALLATION

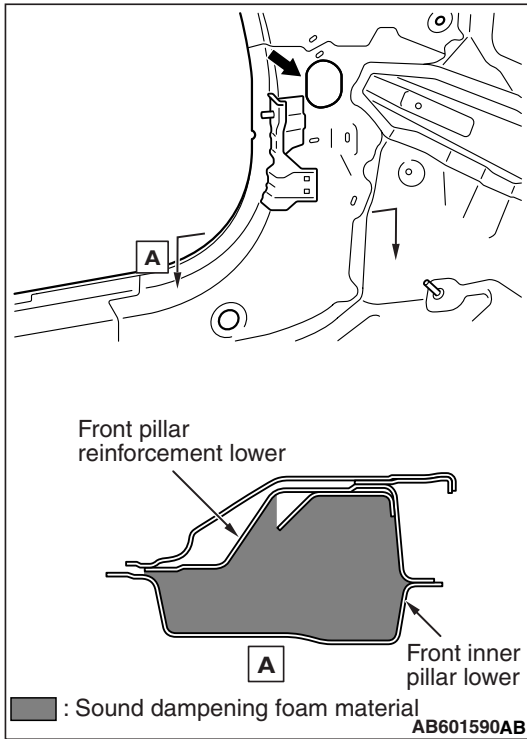
1. To reinforce the strength in the front pillar cut area, cut the side outer panel 50 mm (1.97 inches) above the cut area.
2. Assemble the new front pillar inner lower parts.
3. Assemble the new side sill reinforcement front parts. After that, cover the hole with aluminum tape to prevent the sound dampening foam material from dropping when the material is filled into the front pillar in the next process.
4. When installing the new front pillar lower reinforcement is installed, remove the front pillar outer lower extension and front pillar outer upper extension in advance, and install the front pillar lower reinforcement because there are some points which cannot be welded on the body side. After that, install the front pillar outer lower extension and front pillar outer upper extension.



5. When installing the new front pillar outer, machine the body loose panel cushion (MR535301 or MR435765) for replacement as shown and apply it to the body side because the sound dampening foam material cannot be filled into the front pillar.

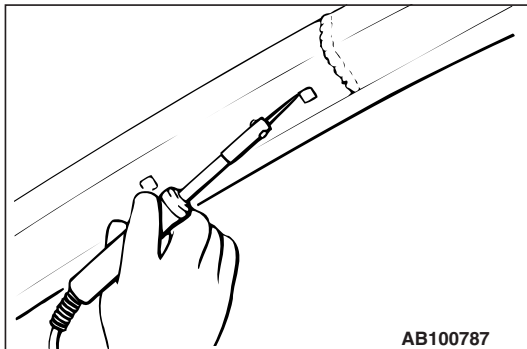


6. When installing the new front pillar outer, apply the body sealant to the areas as shown in advance.



7. Assemble the front pillar outer, bolt and tape the hole and flange with aluminum tape, then fill the hole with sound dampening foam material as shown in the figure of the instructions.

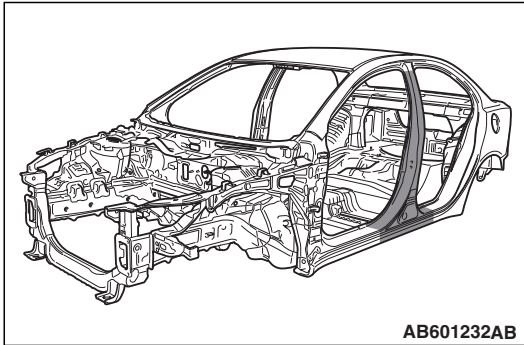
SOUND DAMPENING FOAM MATERIAL: 3M™ AAD ULTRAPRO Panel foam-Yellow



8. Wait 2 hours after filling the sound dampening foam material to remove the bolt and aluminum tape, then melt the sound dampening foam material with a soldering gun so a clip, etc. can thoroughly be inserted in the hole filled with sound dampening foam material.

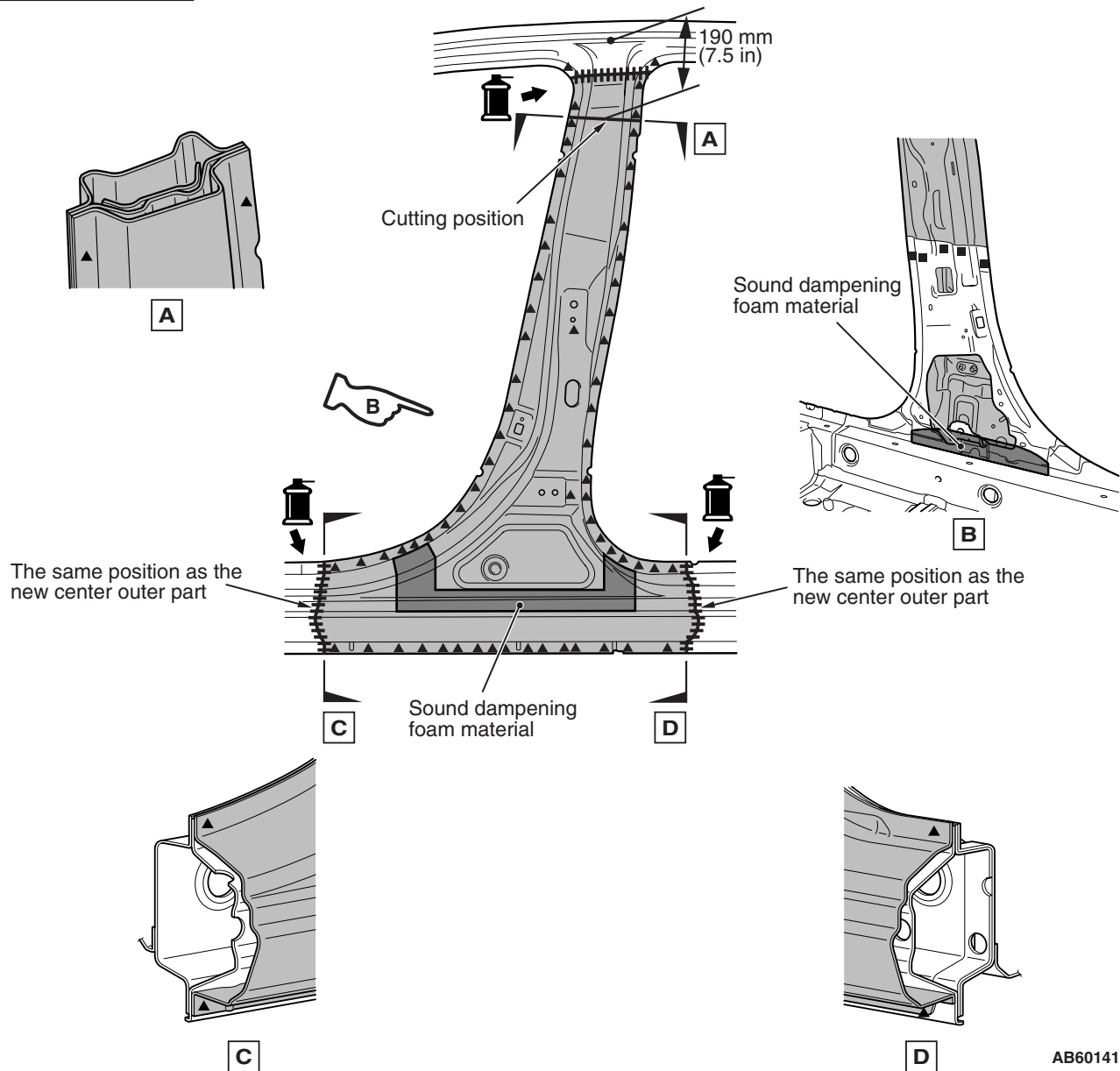
CENTER PILLAR

M4030006000693



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



AB601417AB

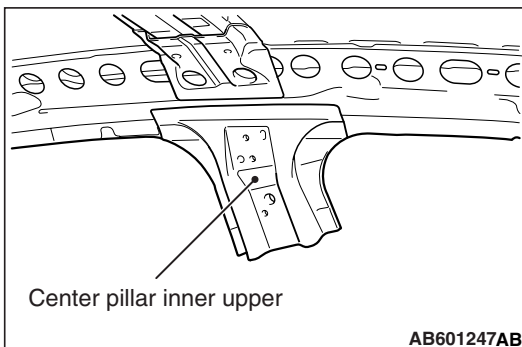
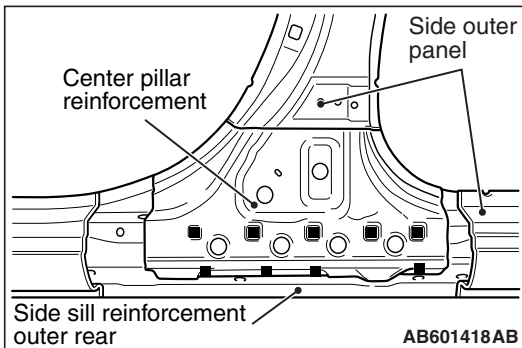
CAUTION

When repairing the area using sound dampening foam material do not use firing tools since the sound dampening foam material may burn.

NOTE ON REPAIR WORK

REMOVAL

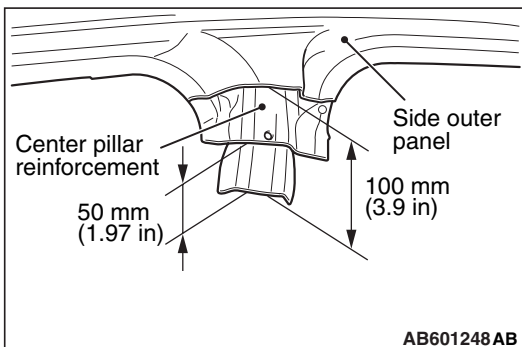
1. To cut the welding points between the side sill center pillar reinforcement and side sill reinforcement outer rear, cut the side outer panel as shown.



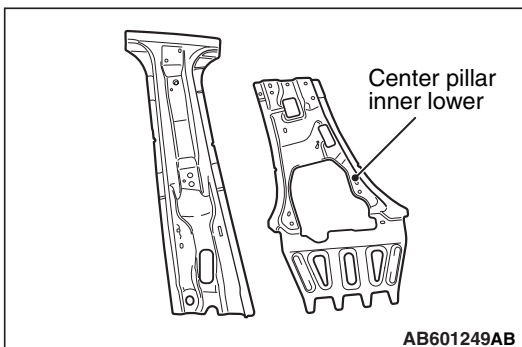
2. After removing the center pillar, remove the center pillar inner upper left on the body side.

INSTALLATION

1. To reinforce the strength in the center pillar cut area, cut the side outer panel 100 mm (3.9 inches) above the cut area and cut the center pillar reinforcement 50 mm (1.97 inches) above the cut area.



2. Remove the center pillar inner lower from the new center inner pillar, and install the center inner pillar to the body.



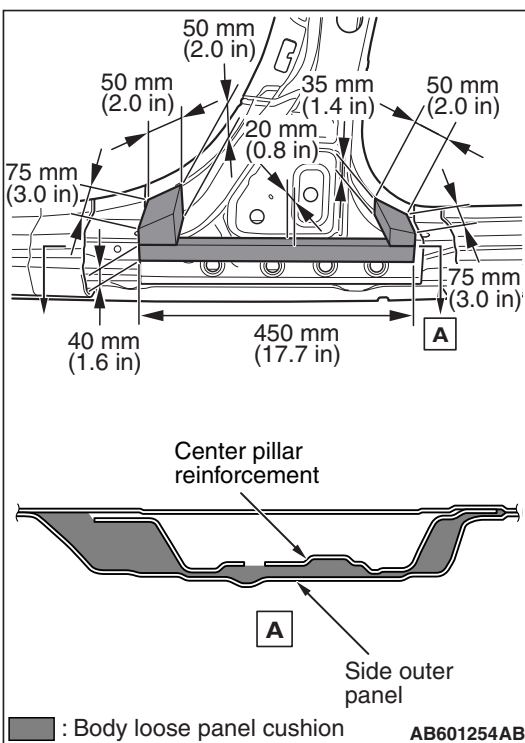
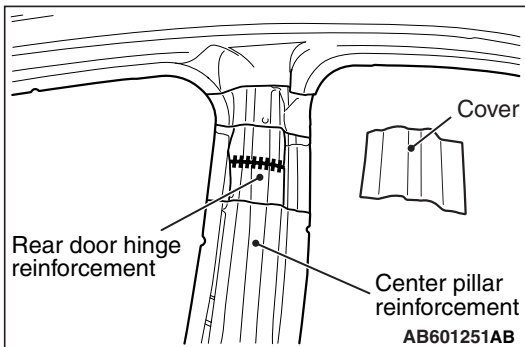
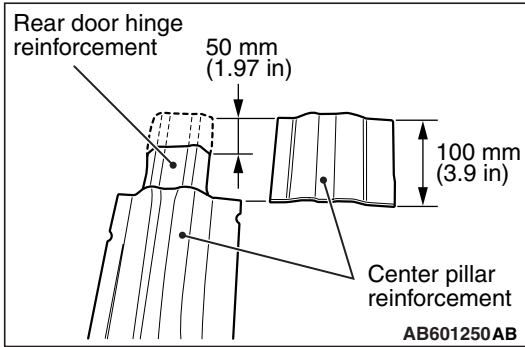
⚠ CAUTION

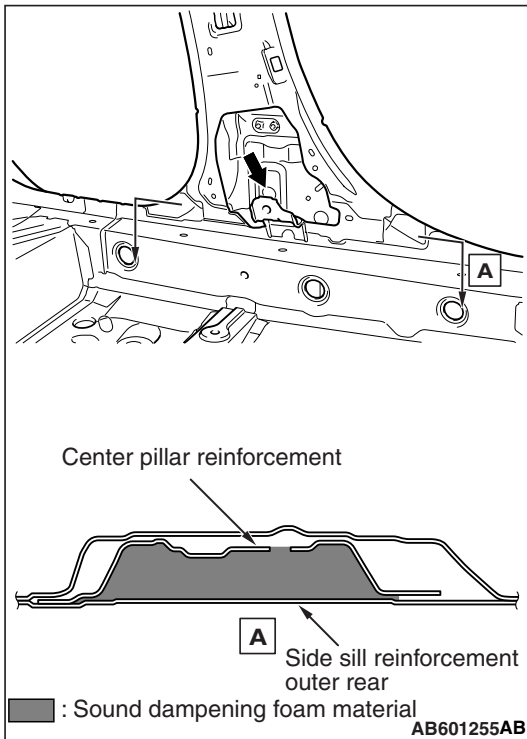
Weld and repair if the rear door hinge reinforcement is damaged.

3. Cut the new center pillar reinforcement parts by aligning them with the cut area of center pillar reinforcement in the body-side. Then, cut only the center pillar reinforcement 100 mm (3.9 inches) below from the cut area to create a cover, and then cut the rear door hinge reinforcement 50 mm (1.97 inches) below from the cut area.

4. Weld the rear door hinge reinforcement then weld the cover of the center pillar reinforcement.

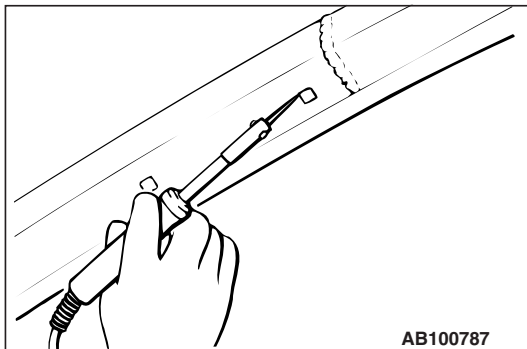
5. When installing the new center pillar outer, machine the body loose panel cushion (MR535301 or MR435765) for replacement as shown and apply it to the body side because the sound dampening foam material cannot be filled into the front pillar.





6. Assemble the center pillar outer, bolt and tape the hole and flange with aluminum tape, then fill the hole with sound dampening foam material as shown in the figure of the instructions.

**SOUND DAMPENING FOAM MATERIAL: 3M™ AAD
ULTRAPRO Panel foam-Yellow**

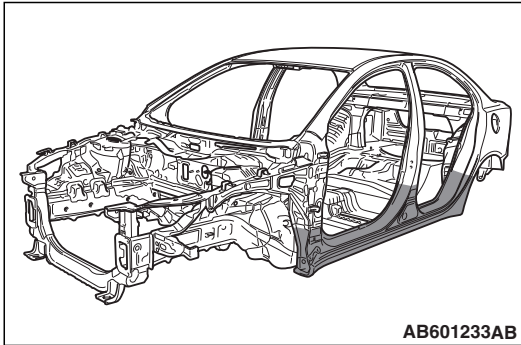


7. Wait 2 hours after filling the sound dampening foam material to remove the bolt and aluminum tape, then melt the sound dampening foam material with a soldering gun so a clip, etc. can thoroughly be inserted in the hole filled with sound dampening foam material.

NOTES

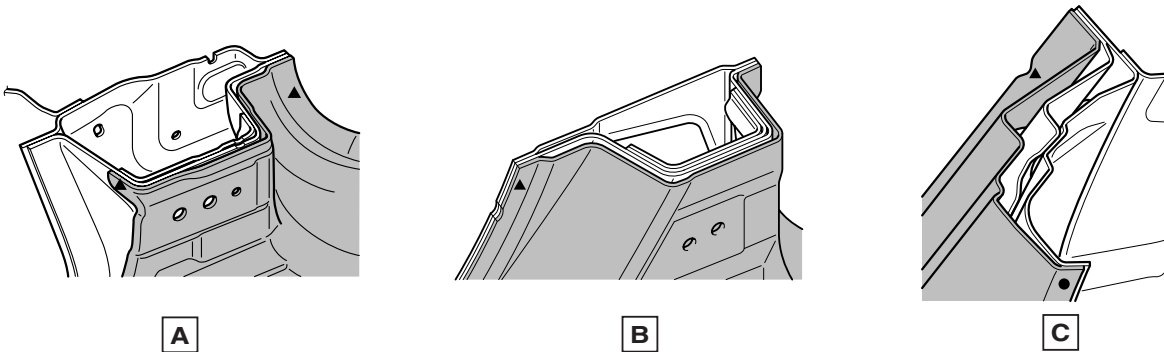
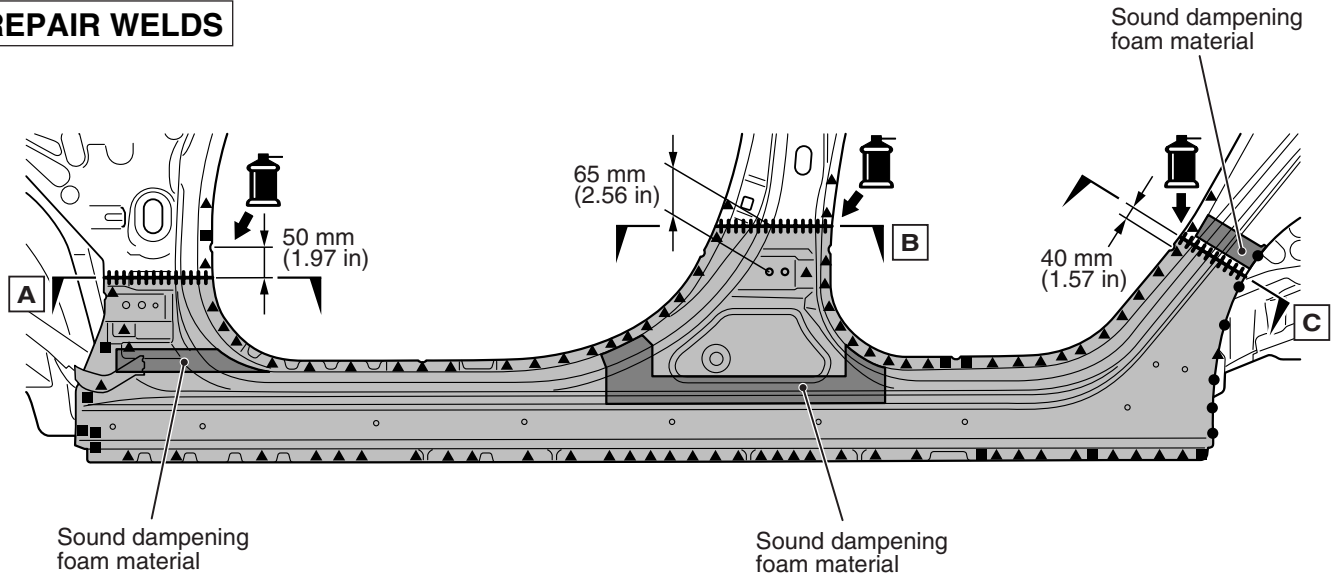
SIDE SILL

M4030007000878



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.)

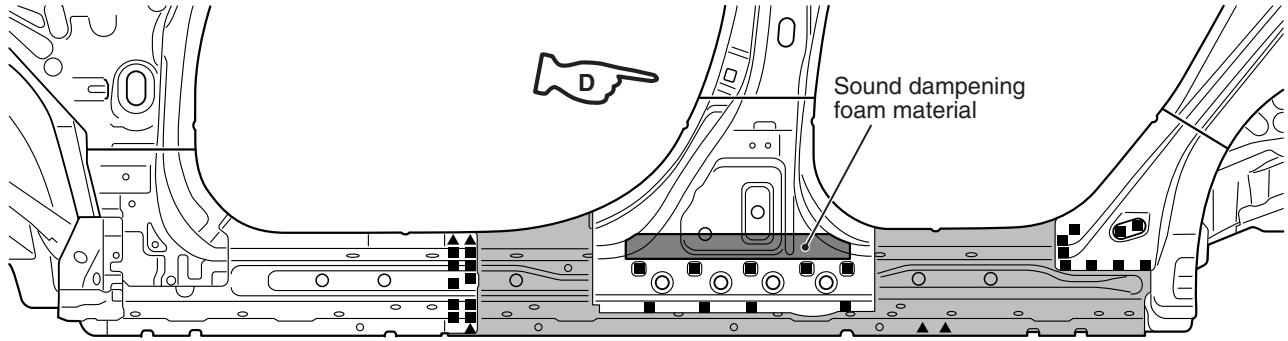
REPAIR WELDS



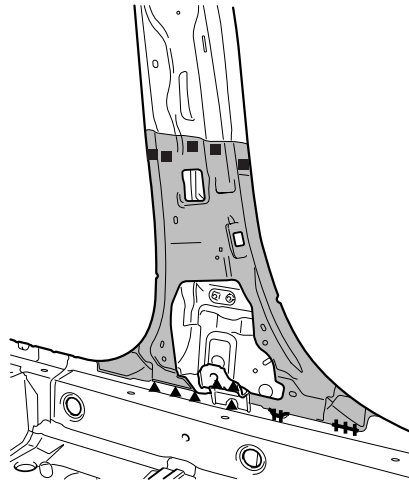
AB601516AB

CAUTION

When repairing the area using sound dampening foam material do not use firing tools since the sound dampening foam material may burn.



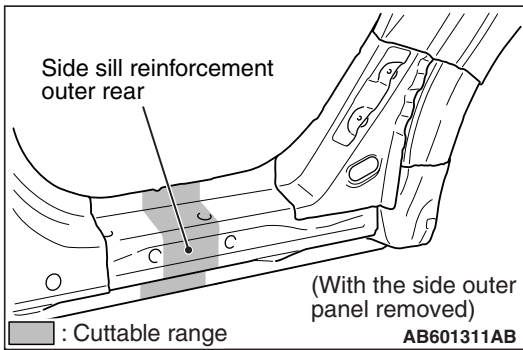
(With the side outer panel removed)



D

AB601517AB

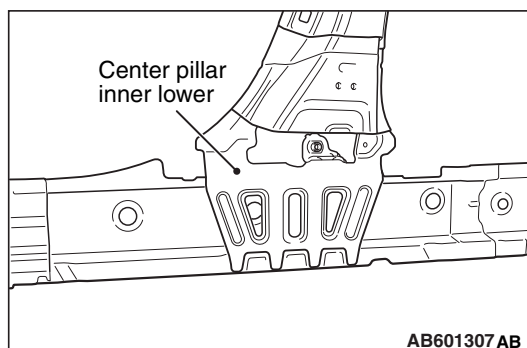
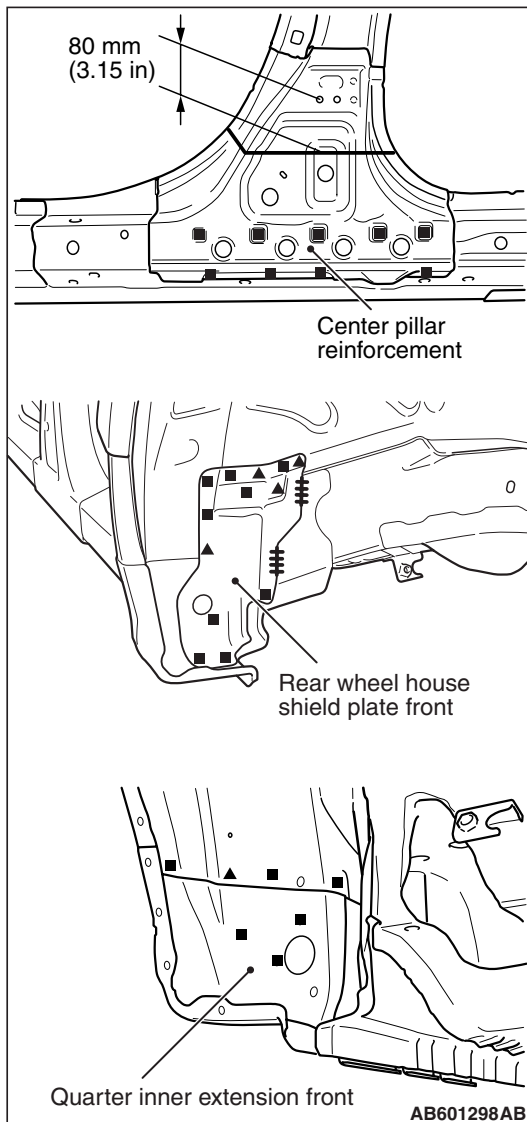
NOTE: Partial replacement is possible depending on the range of damage. Cut the side sill reinforcement outer rear 50 mm (1.97 inches) away from the cut area of the side outer panel.



NOTE ON REPAIR WORK

REMOVAL

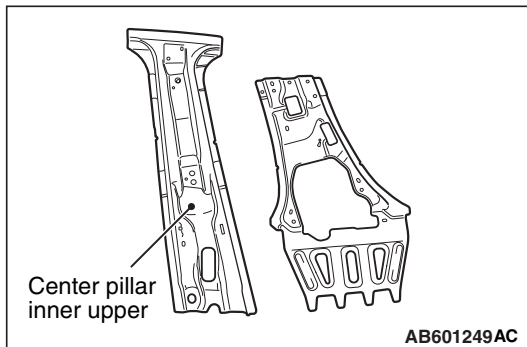
1. When installing the side sill reinforcement outer rear, cut the center pillar reinforcement 80 mm (3.15 inches) downward from the installation hole of the rear door hinge because the center pillar reinforcement interferes with it. For the rear wheel house, remove the rear wheel house shield plate front and quarter inner extension front because the quarter inner extension front interferes with the rear wheel house shield plate front.



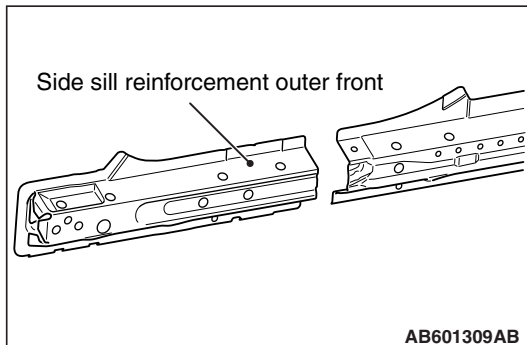
2. After removing the side sill reinforcement outer rear, remove the center pillar inner lower.

INSTALLATION

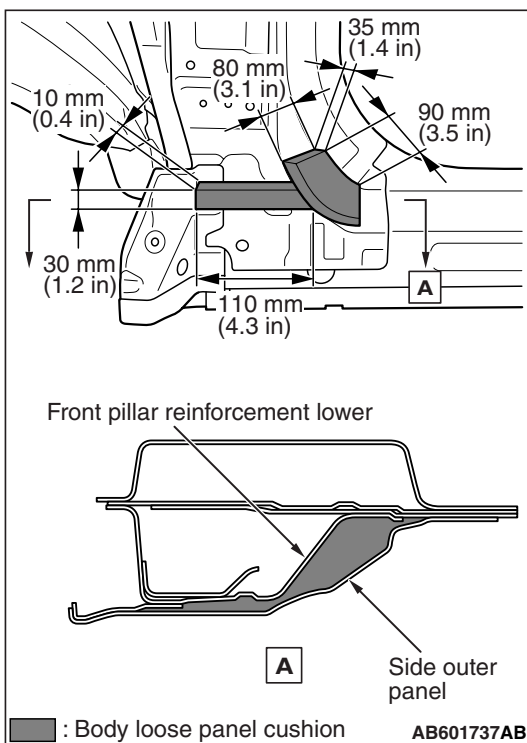
1. Remove the center pillar inner upper from the new center inner pillar, and install the center inner pillar to the body.

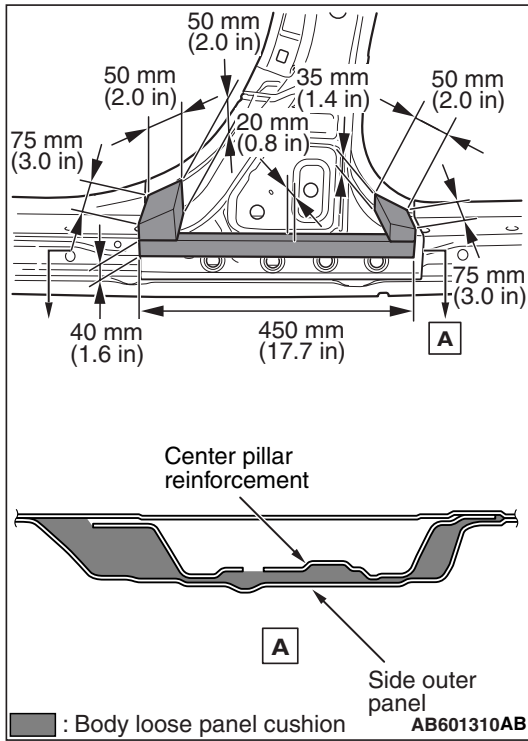


2. Remove the side sill reinforcement outer front from the new side sill reinforcement, and install the side sill reinforcement to the body.

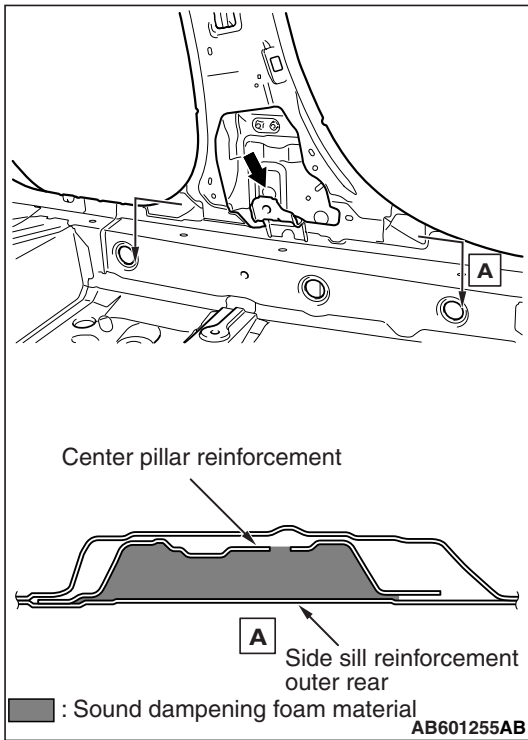


3. When installing the new floor side sill outer, machine the body loose panel cushion (MR535301 or MR435765) for replacement as shown and apply it to the body side because the sound dampening foam material cannot be filled into the front pillar.



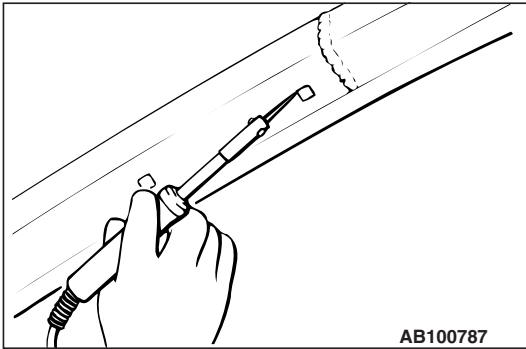


- When installing the new floor side sill outer, machine the body loose panel cushion (MR535301 or MR435765) for replacement as shown and apply it to the body side because the sound dampening foam material cannot be filled into the center pillar.



- Assemble the floor side sill outer, bolt and tape the hole and flange with aluminum tape, then fill the hole with sound dampening foam material as shown in the figure of the instructions.

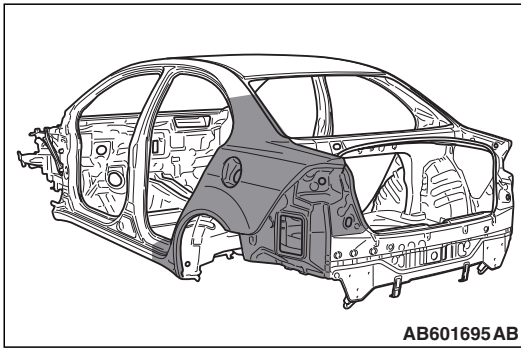
SOUND DAMPENING FOAM MATERIAL: 3M™ AAD ULTRAPRO Panel foam-Yellow



6. Wait 2 hours after filling the sound dampening foam material to remove the bolt and aluminum tape, then melt the sound dampening foam material with a soldering gun so a clip, etc. can thoroughly be inserted in the hole filled with sound dampening foam material.

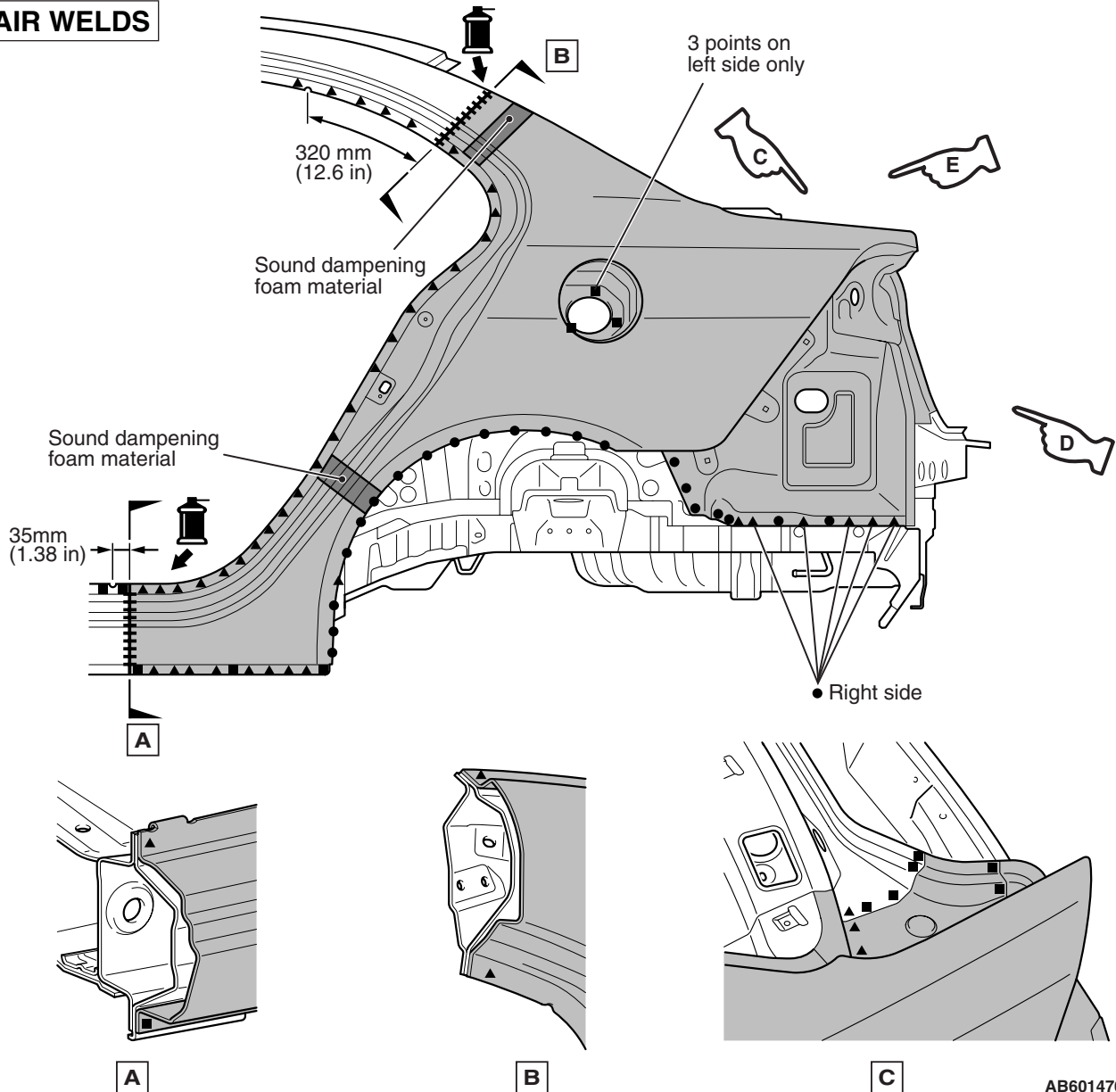
QUARTER OUTER

M4030008000718



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.)

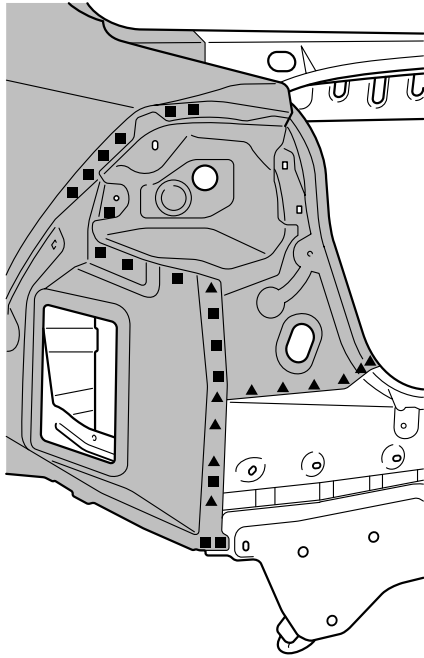
REPAIR WELDS



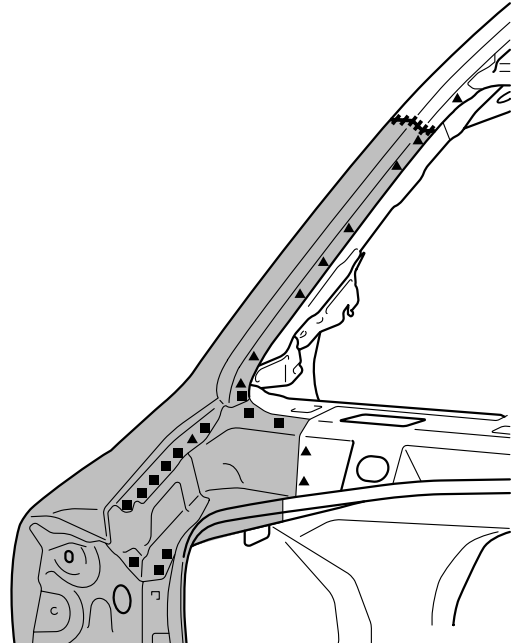
AB601476 AB

CAUTION

When repairing the area using sound dampening foam material do not use firing tools since the sound dampening foam material may burn.



D



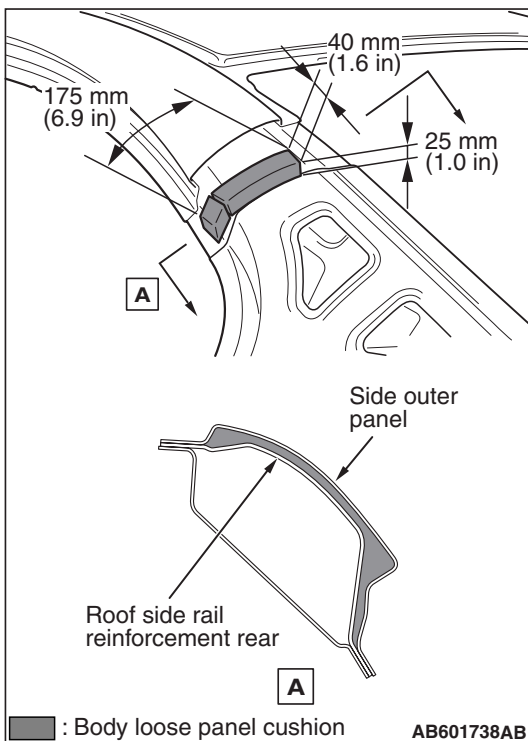
E

AB601477AB

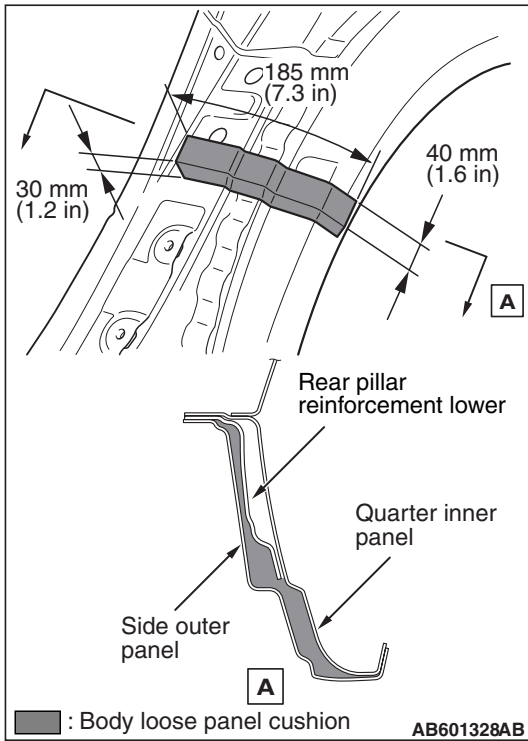
NOTE ON REPAIR WORK

INSTALLATION

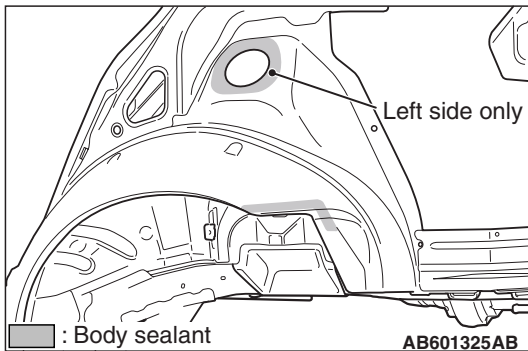
1. When installing the new rear quarter outer panel, machine the body loose panel cushion (MR535301 or MR435765) for replacement as shown and apply it to the body side because the sound dampening foam material cannot be filled into the wheel arch.



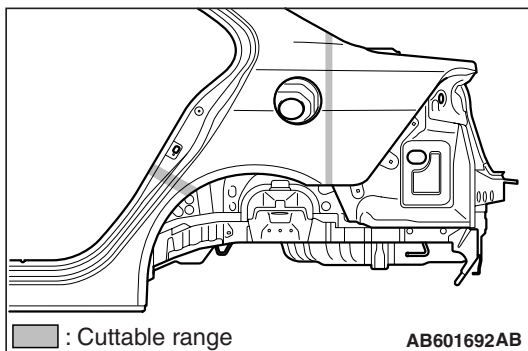
AB601738AB



- When installing the new rear quarter outer panel, machine the body loose panel cushion (MR535301 or MR435765) for replacement as shown and apply it to the body side because the sound dampening foam material cannot be filled into the wheel arch.



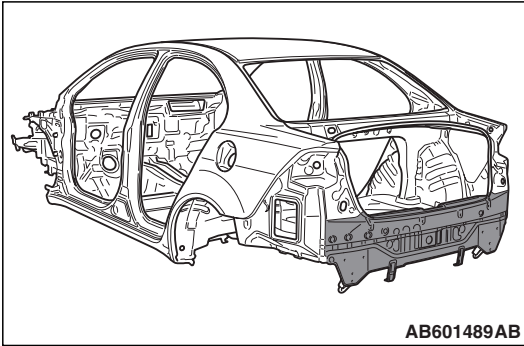
- When installing the new rear quarter outer panel, apply the body sealant in advance to the areas as shown.




NOTE: Partial replacement is possible depending on the range of damage.

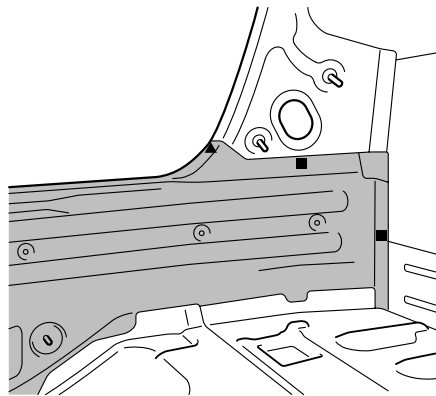
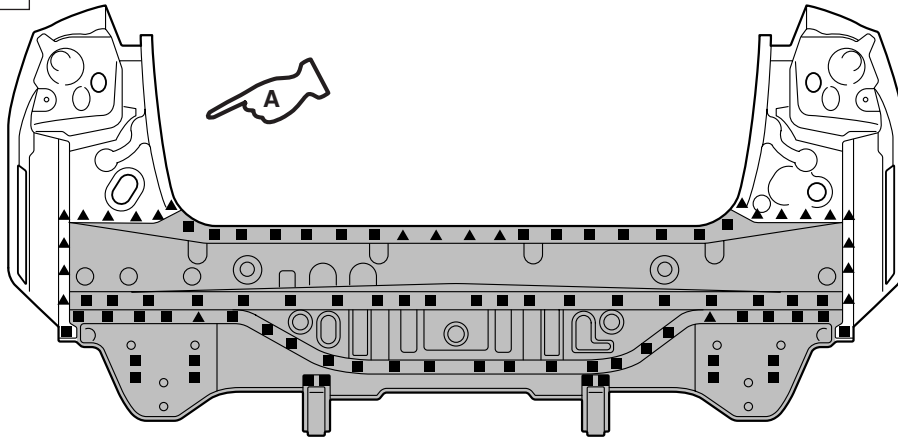
REAR END PANEL

M4030009000302



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.)

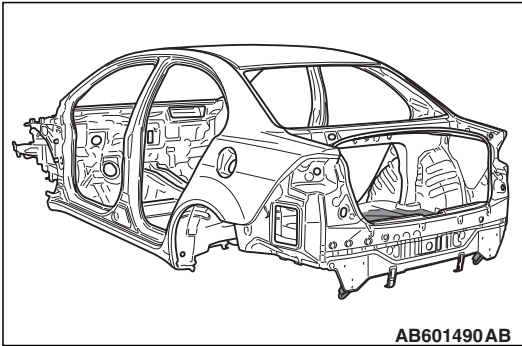
REPAIR WELDS



A

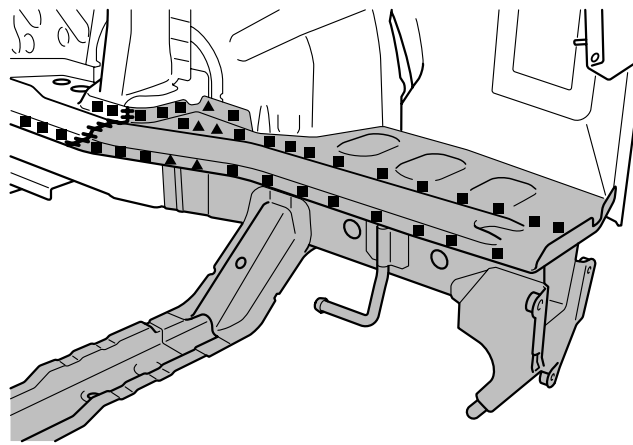
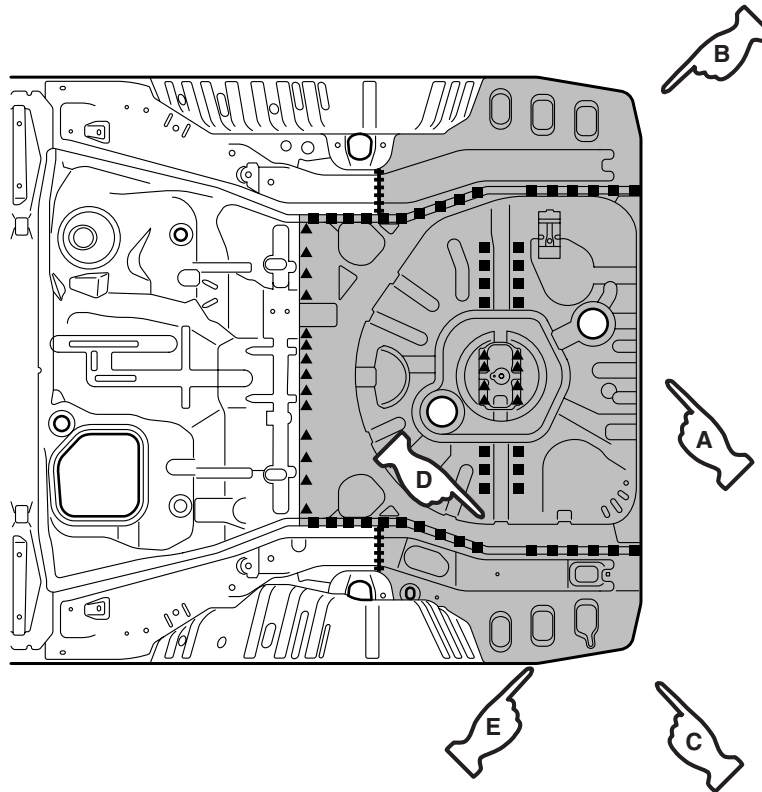
AB601442AB

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



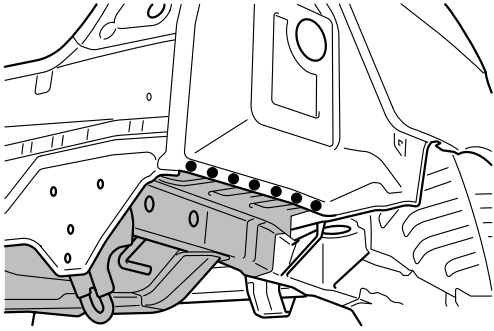
A

(With the rear floor pan rear removed)

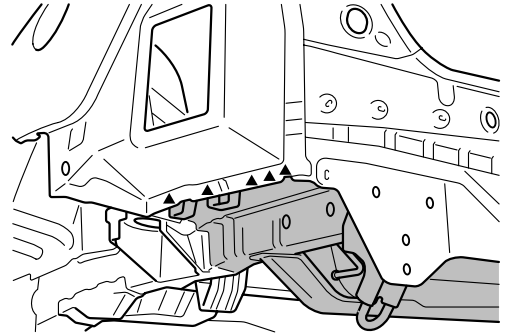
AB601443AB

NOTE: Refer to the Rear End Panel section on P.3-35 for the welding points with the rear end panel.

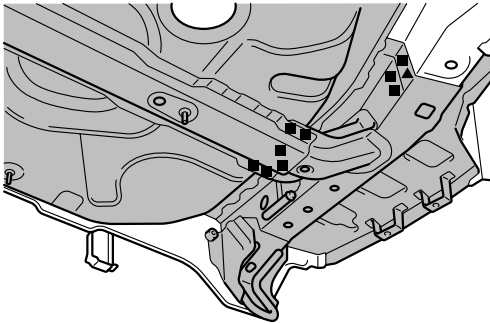
TSB Revision



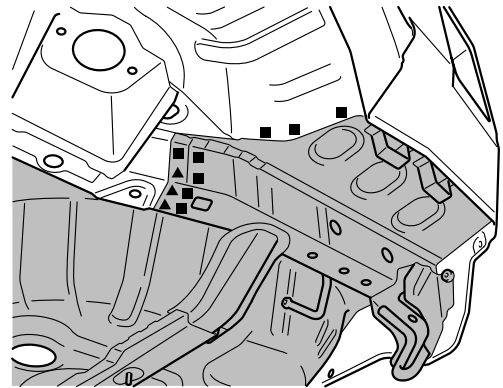
B



C



D



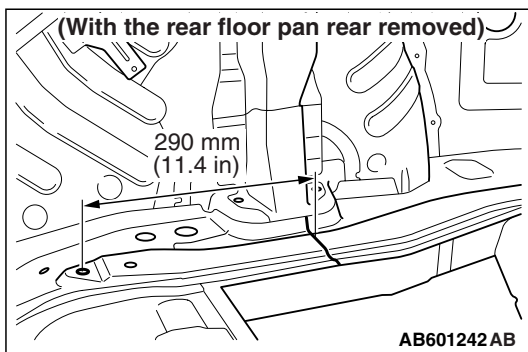
E

AB601444AC

NOTE ON REPAIR WORK

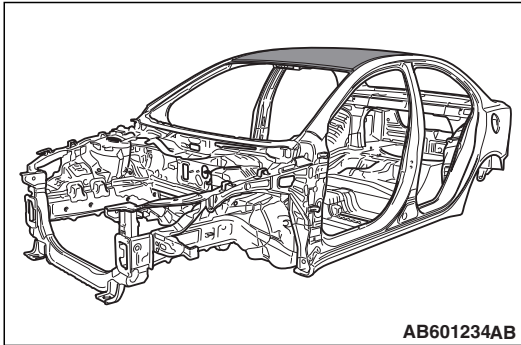
REMOVAL

1. When removing the rear floor sidemember upper, cut it 290 mm (11.4 inches) behind the installation hole of the child restraint bracket.



ROOF

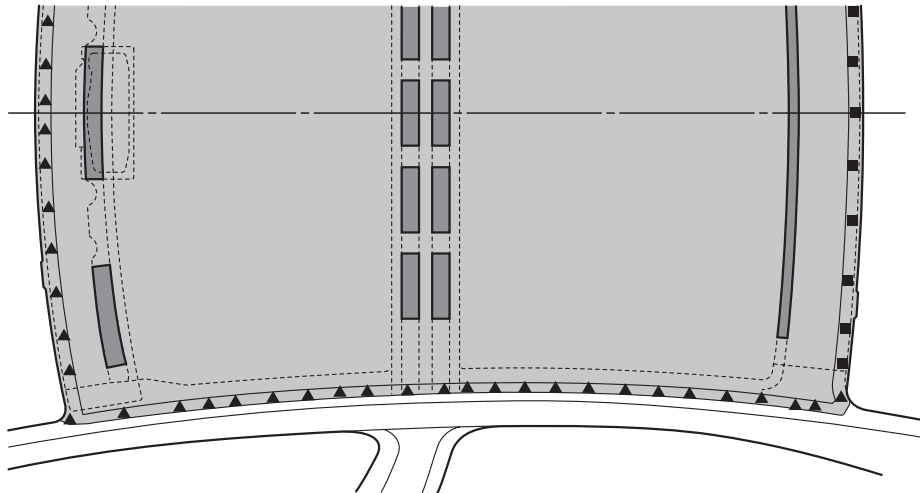
M4030011000871



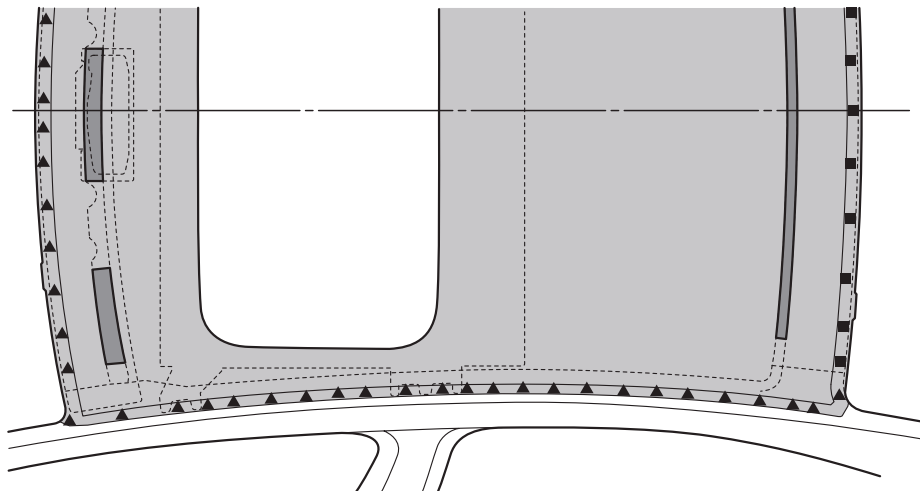
SYMBOL	OPERATION DESCRIPTION
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
++++	MIG spot welding
#####	MIG arc welding (continuous)
○○○○○○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply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

REPAIR WELDS

Vehicles without
sunroof



Vehicles with
sunroof



: Adhesive

AB601308AB

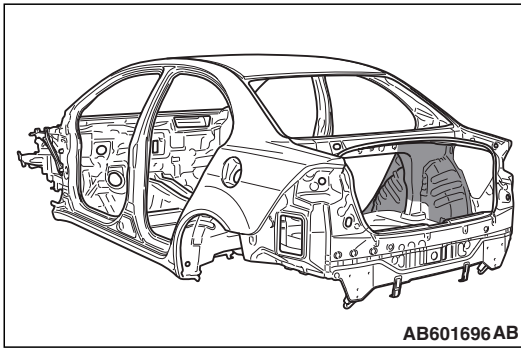
ADHESIVE: Urethane body sealer

BRAND: 3M™ AAD Part No.8542 or equivalent

NOTES

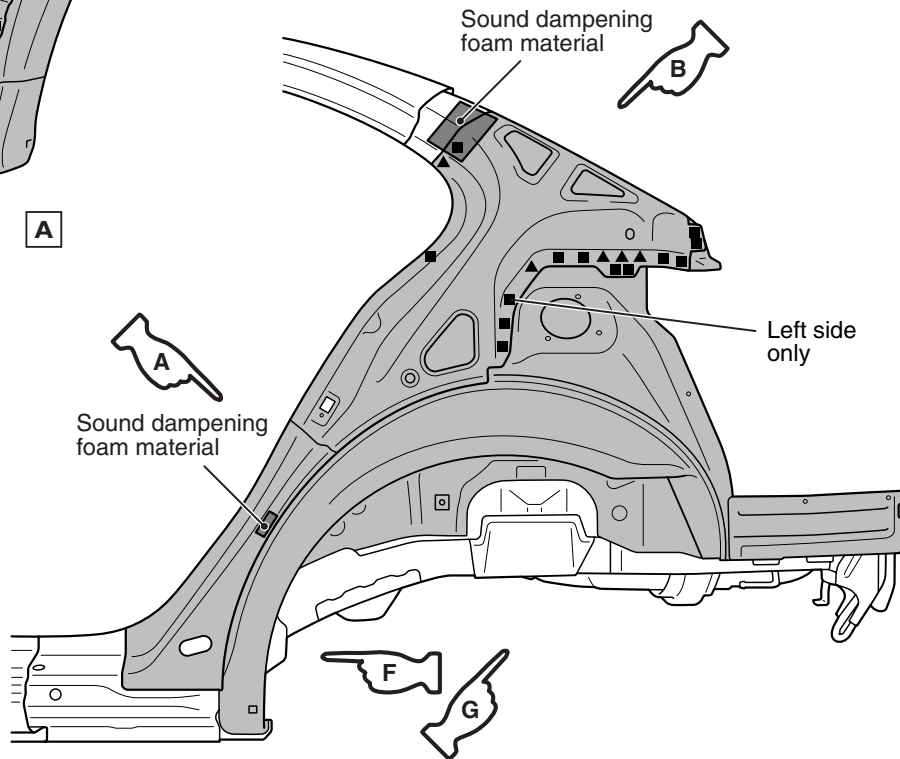
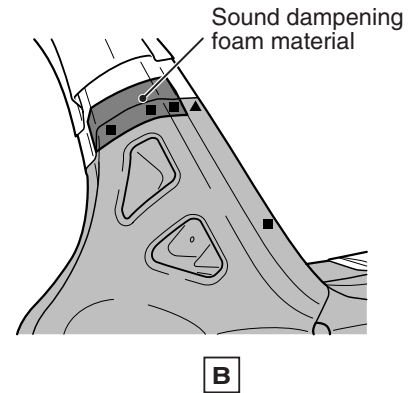
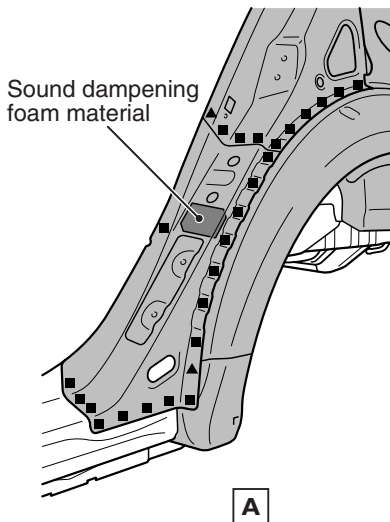
QUARTER INNER

M4030012000733



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



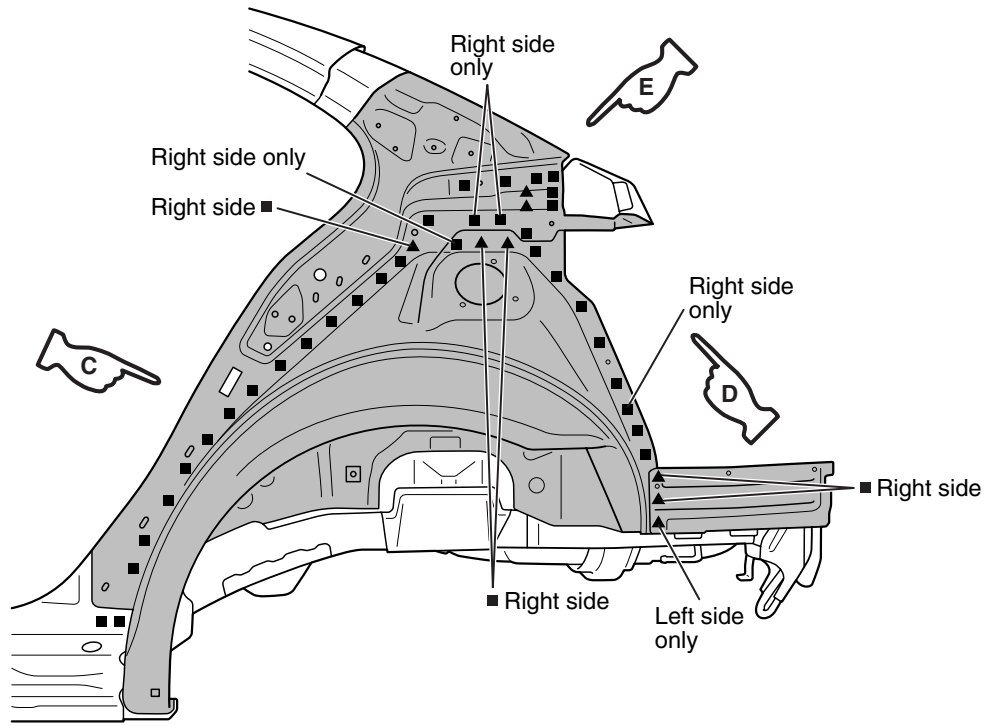
(With the quarter outer removed)

AB601518AB

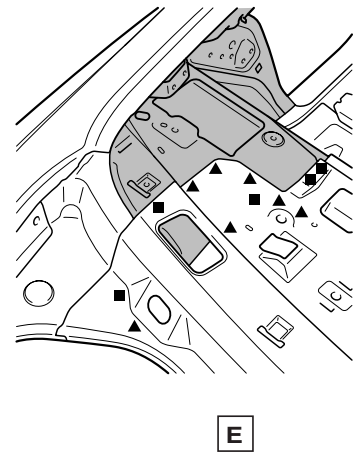
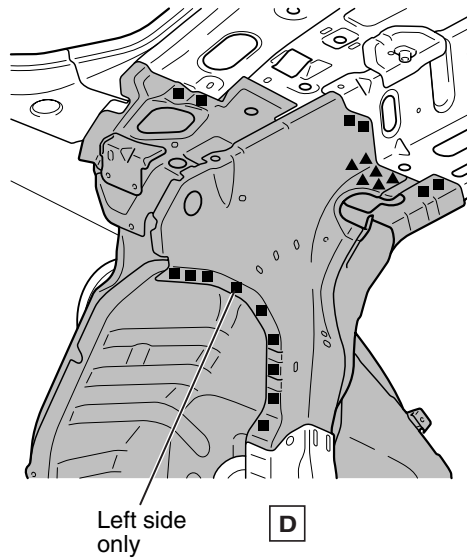
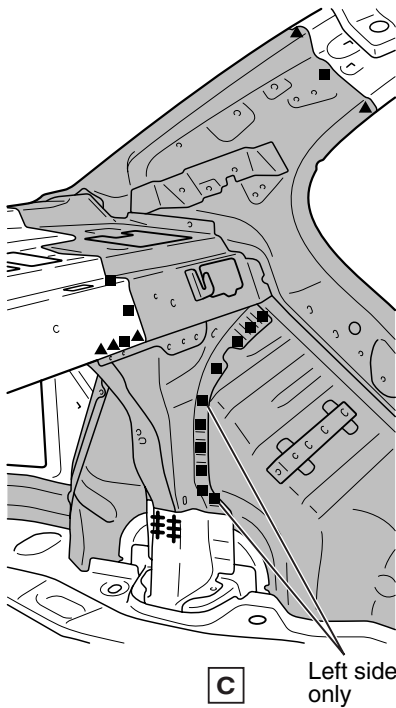
CAUTION

When repairing the area using sound dampening foam material do not use firing tools since the sound dampening foam material may burn.

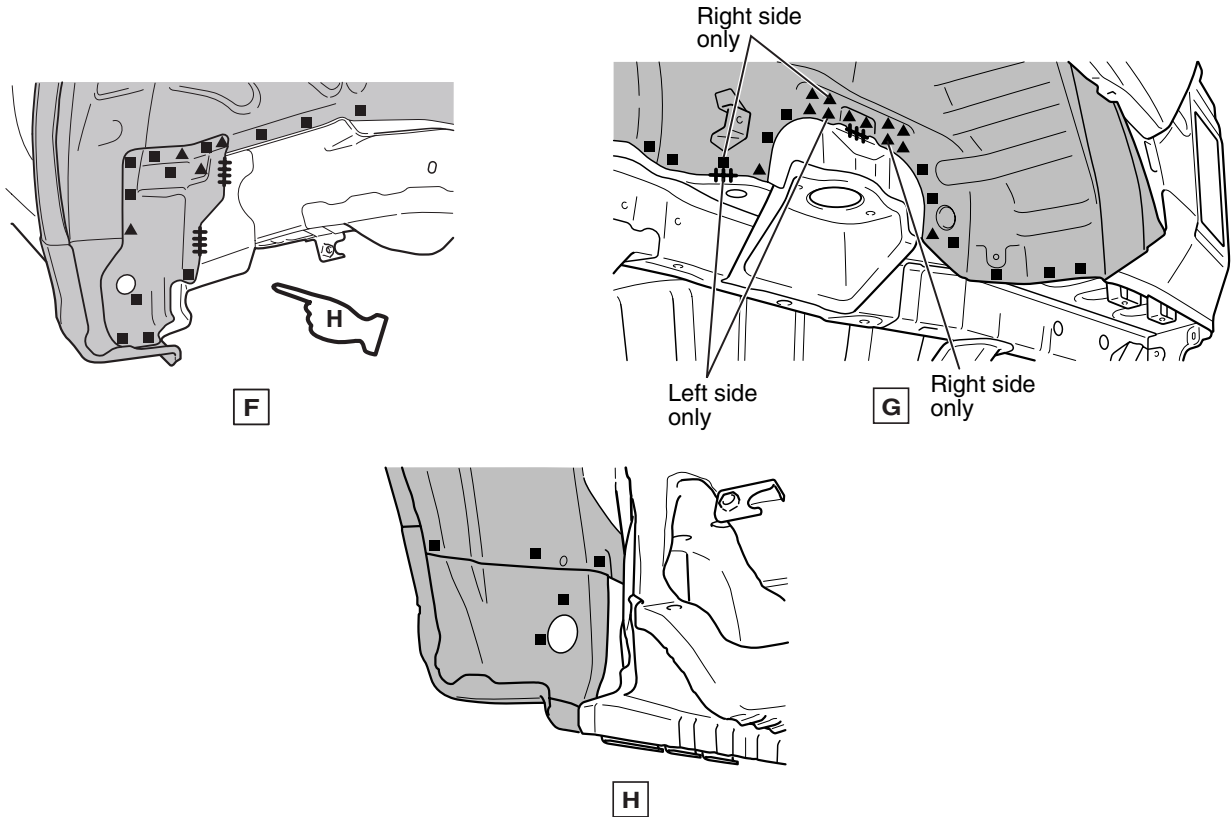
NOTE: Refer to the Quarter Outer section on P.3-32 for the welding points with the quarter outer.



(With the rear pillar reinforcement and the rear pillar reinforcement lower removed)



AB601519AB



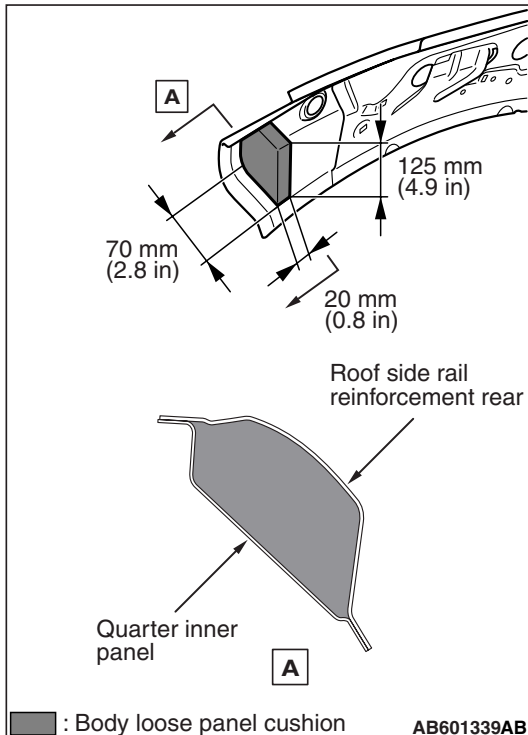
(With the rear wheel house shield plate front removed)

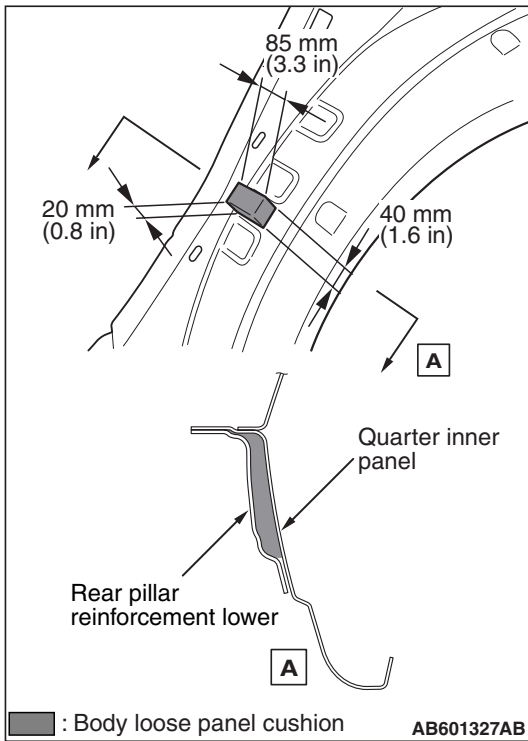
AB601591AB

NOTE ON REPAIR WORK

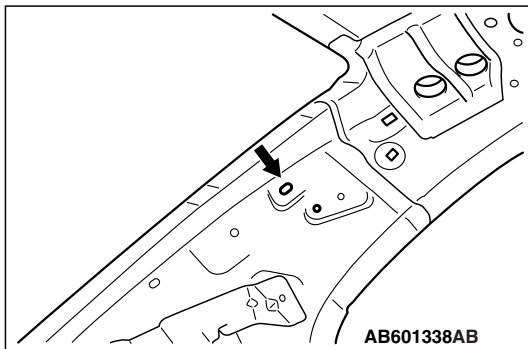
INSTALLATION

1. When installing the new rear quarter inner panel, machine the body loose panel cushion (MR535301 or MR435765) as shown and apply it to the body side to prevent the sound dampening foam material from dropping when the material is filled into the rear pillar in the next process.



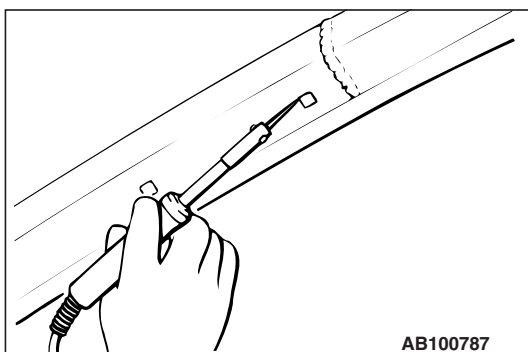


- When installing the new rear pillar reinforcement lower, machine the body loose panel cushion (MR535301 or MR435765) for replacement as shown and apply it to the body side because the sound dampening foam material cannot be filled into the rear pillar reinforcement lower.



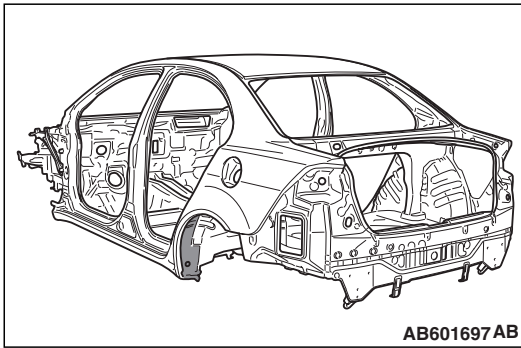
- Assemble the rear quarter inner panel, bolt and tape the hole and flange with aluminum tape, then fill the hole with sound dampening foam material as shown in the figure of the instructions.


SOUND DAMPENING FOAM MATERIAL: 3M™ AAD ULTRAPRO Panel foam-Yellow



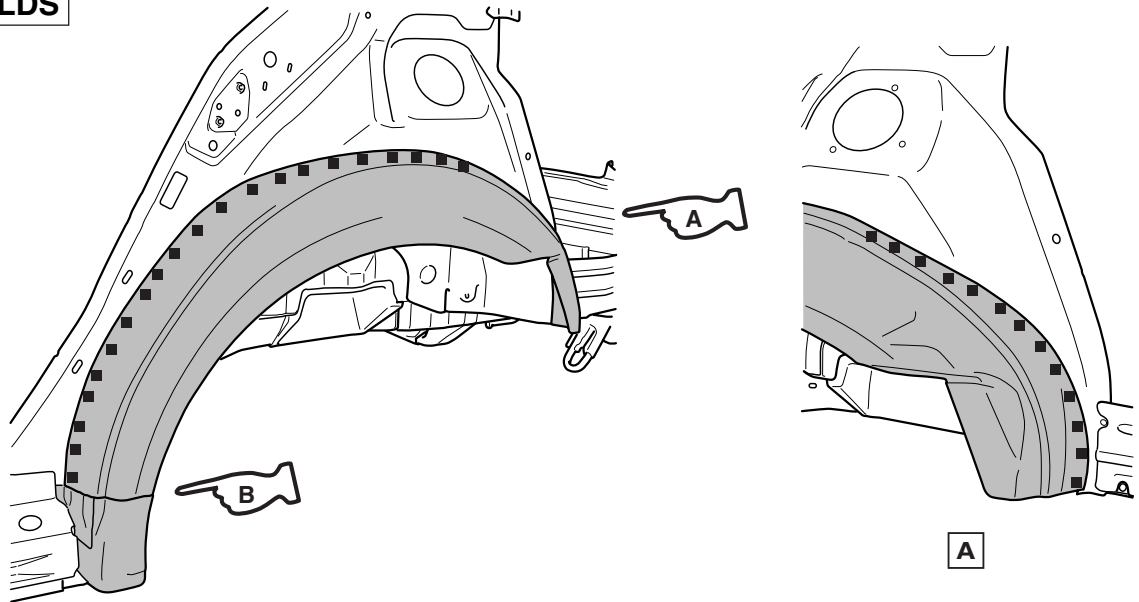
- Wait 2 hours after filling the sound dampening foam material to remove the bolt and aluminum tape, then melt the sound dampening foam material with a soldering gun so a clip, etc. can thoroughly be inserted in the hole filled with sound dampening foam material.

QUARTER INNER (PARTIAL REPLACEMENT)

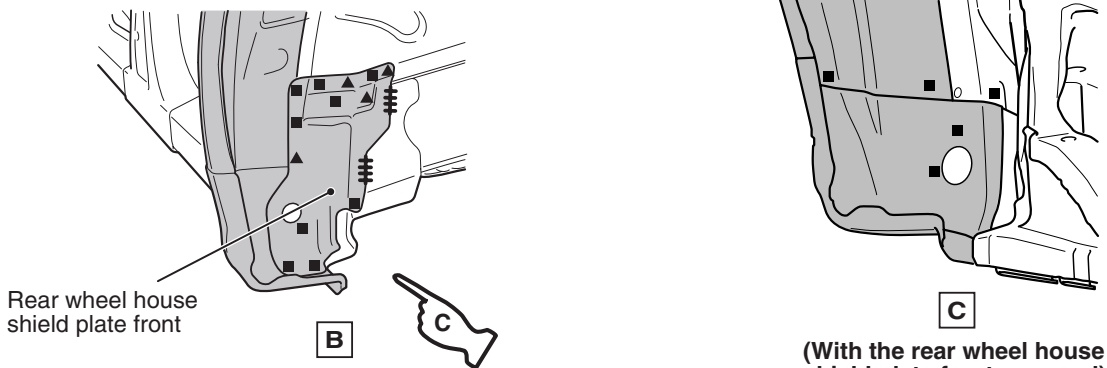


Symbol	Operation description
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
++++	MIG spot welding
#####	MIG arc welding (continuous)
○○○○○○○○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply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

REPAIR WELDS



(With the rear pillar reinforcement and the rear pillar reinforcement lower removed)



(With the rear wheel house shield plate front removed)

AB601487AB

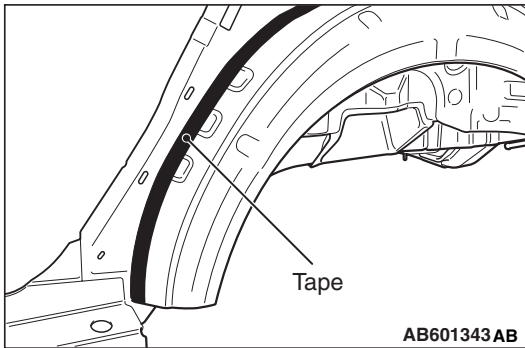
NOTE:

- Refer to the Quarter Outer Section on P.3-32 for the welding points with the quarter outer.
- Refer to the Quarter Inner Section on P.3-40 for the welding points with the rear pillar reinforcement and the rear pillar reinforcement lower.

NOTE ON REPAIR WORK

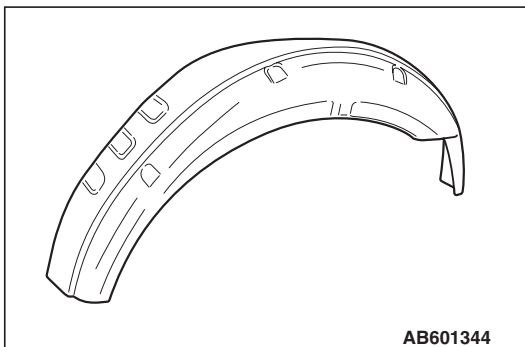
REMOVAL

1. Adhere tape along the wheel arch of the quarter inner panel as shown in the figure of the instructions, use the tape as a guide so about 20 mm (0.79 inch) of the flange remains, then cut and remove.

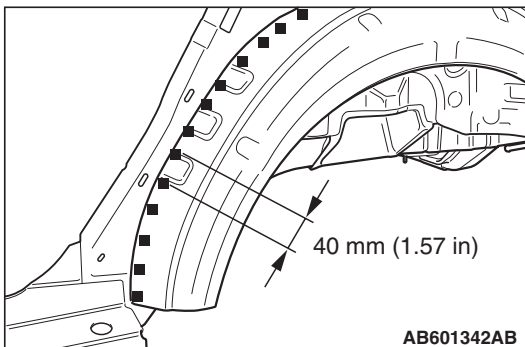


INSTALLATION

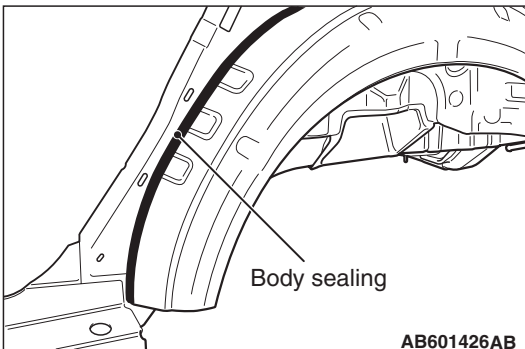
1. For the new rear quarter inner panel parts, cut the wheel arch end are so that it overlaps with the flange on the body-side.



2. Overlap, assemble and weld the rear quarter inner panel with the body-side flange. Weld at a pitch of 40 mm (1.57 inches).

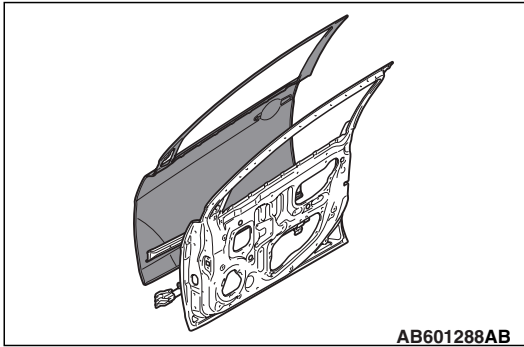



3. Weld the rear quarter inner panel then apply a body sealing in the area shown in the figure of the instructions.



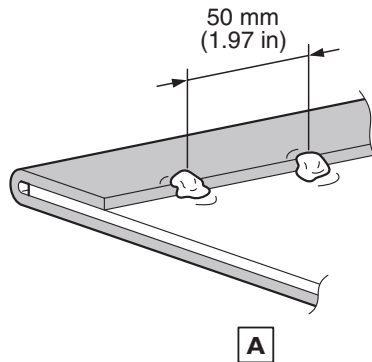
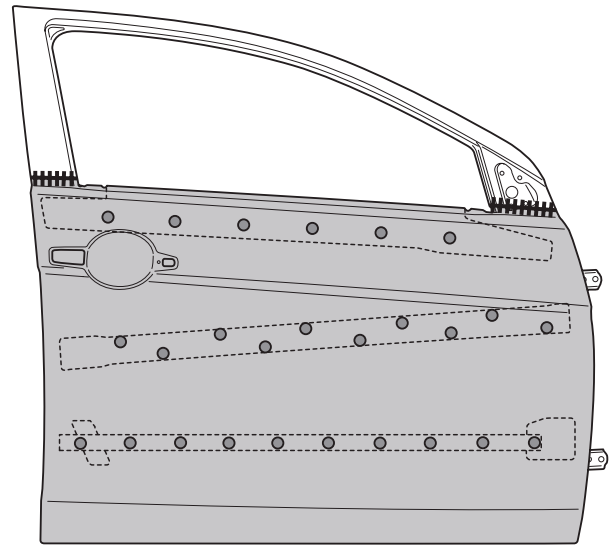
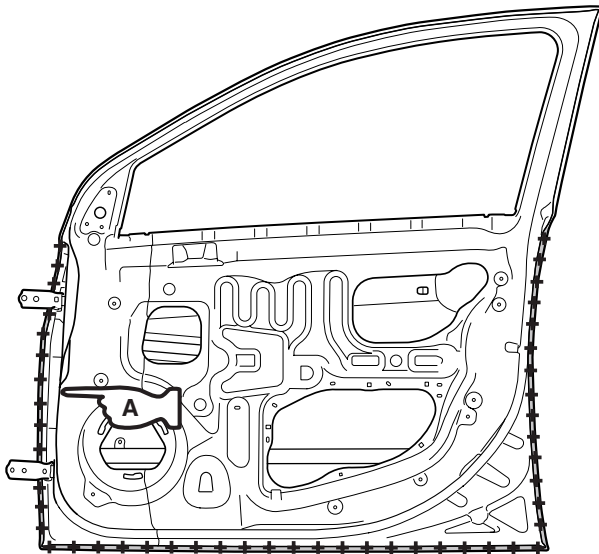
FRONT DOOR OUTER PANEL (WELDED TYPE)


M4030001500239



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

AB601280AB

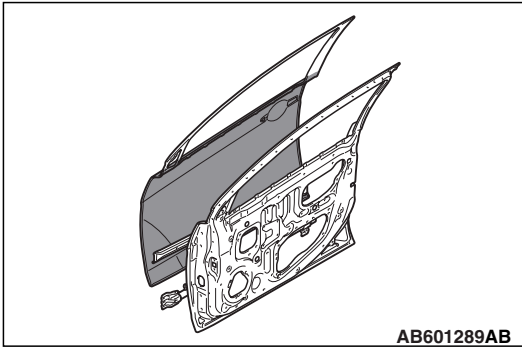
ADHESIVE: Urethane body sealer


BRAND: 3M™ AAD Part No.8542 or equivalent

NOTE: After hemming the front door outer panel, MIG spot weld the flange overlap section at a pitch of 50 mm (1.97 inches).

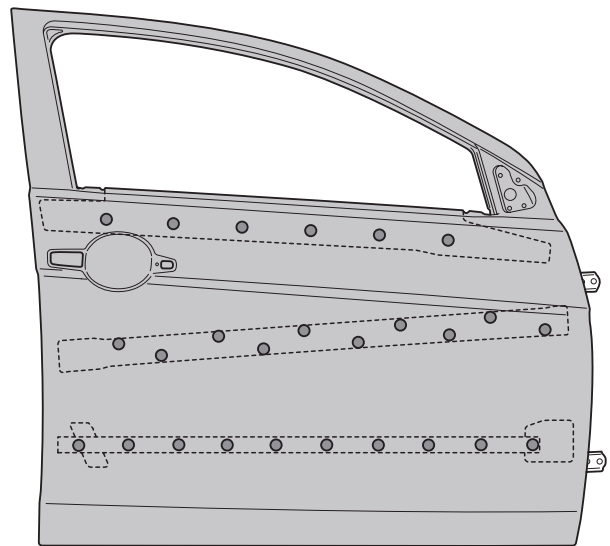
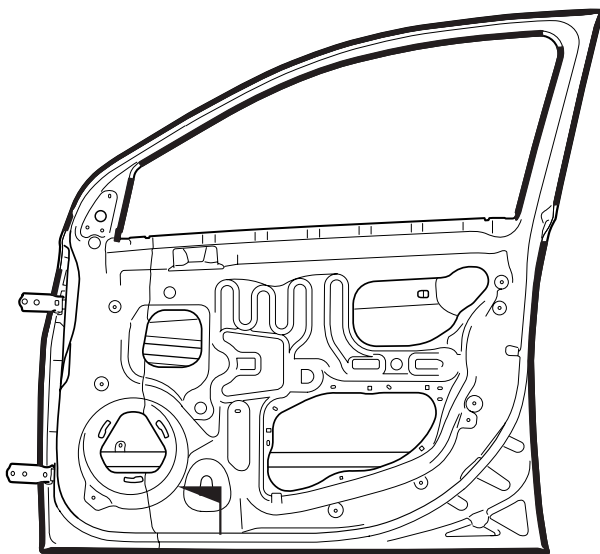
FRONT DOOR OUTER PANEL (ADHESION TYPE)



M4030001700233



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 1
 : Adhesive 2

- **ADHESIVE 1:** Urethane body sealer
BRAND: 3M™ AAD Part No.8542 or equivalent
- **ADHESIVE 2:** Epoxyayresin adhesive
BRAND: 3M™ AAD Part No.8115 or equivalent

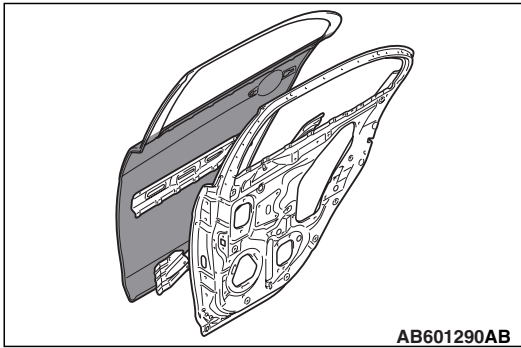
NOTE ON REPAIR WORK

INSTALLATION

1. When installing the front door outer panel, grind the bonding surface and remove the paint to improve adhesion. Then, degrease the front door outer panel.
2. Install the front door outer panel and hem it. Then, wipe off the adhesive that squeezed out.

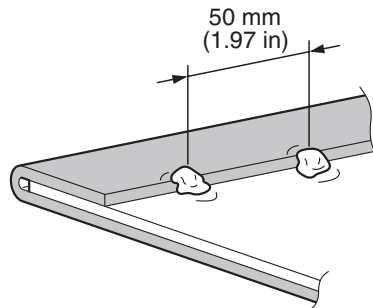
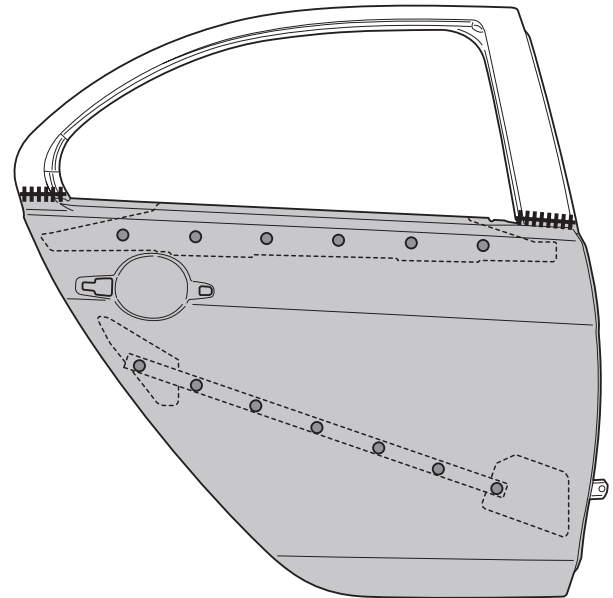
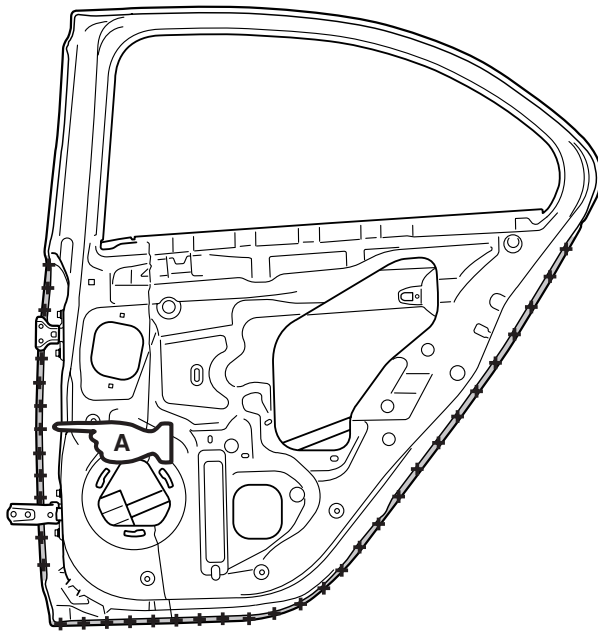
AB601281AB

REAR DOOR OUTER PANEL (WELDED TYPE)



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



A

: Adhesive

AB601282AB

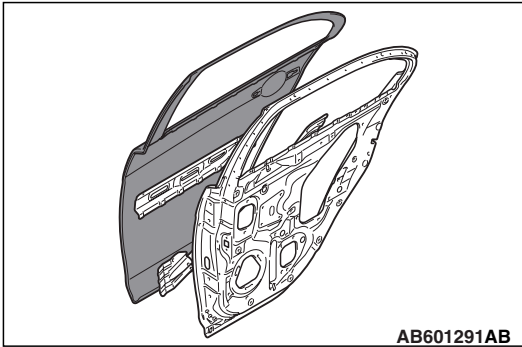
ADHESIVE: Urethane body sealer


BRAND: 3M ATD Part No.8542 or equivalent

NOTE: After hemming the rear door outer panel, MIG spot weld the flange overlap section at a pitch of 50 mm (1.97 inches).

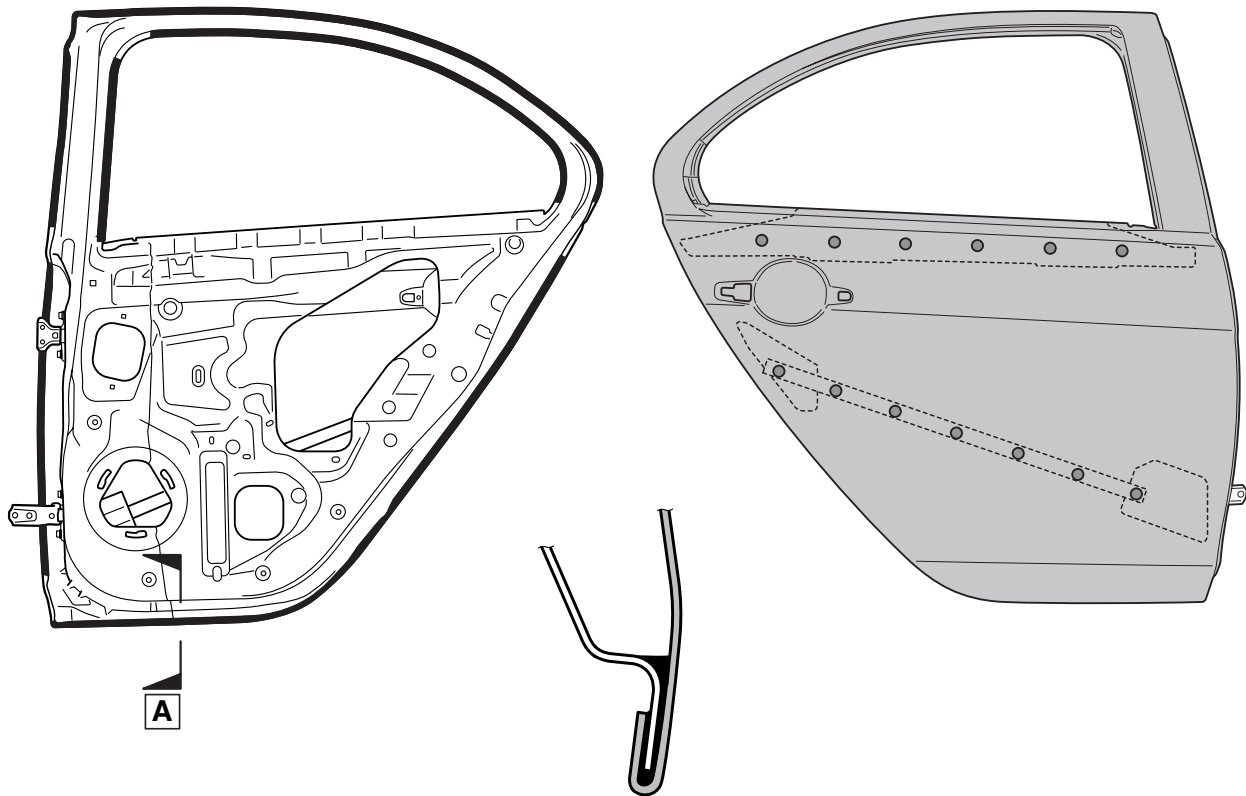
REAR DOOR OUTER PANEL (ADHESION TYPE)



M4030001800188



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 1
 : Adhesive 2

ADHESIVE 1: Urethane body sealer
BRAND: 3M ATD Part No.8542 or equivalent
ADHESIVE 2: Epoxyayresin adhesive
BRAND: 3M ATD Part No.8115 or equivalent

A

AB601283AB

NOTE ON REPAIR WORK

INSTALLATION

1. When installing the rear door outer panel, grind and remove the paint, etc. from the bonded surface of the outer panel to ensure the bonding strength. After the removal, degrease it.
2. Install the outer panel and hem it. Wipe off the excessive adhesive and finish it.

NOTES