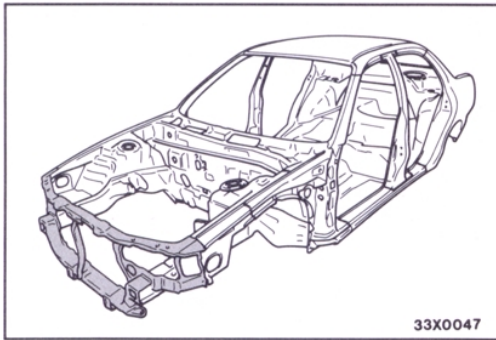


3 WELDED PANEL REPLACEMENT

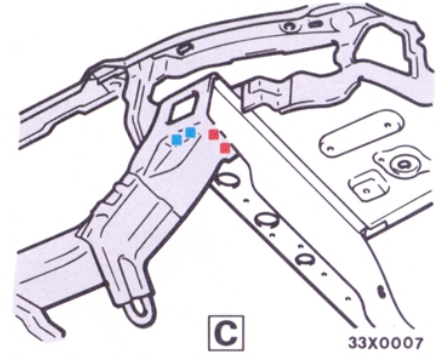
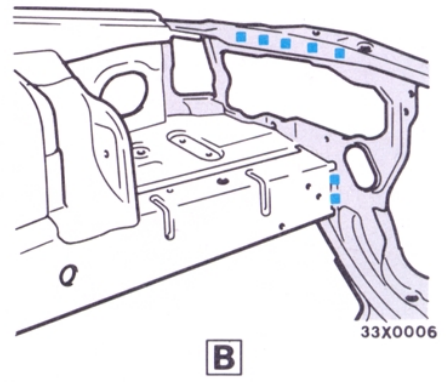
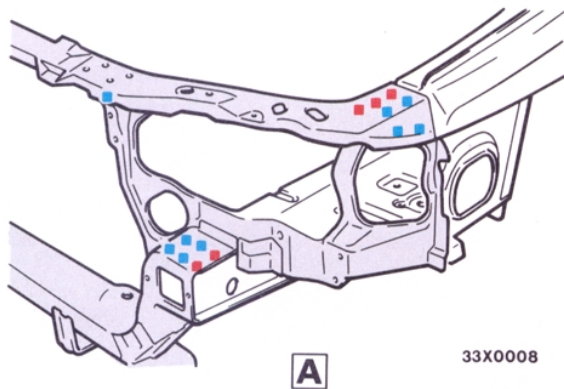
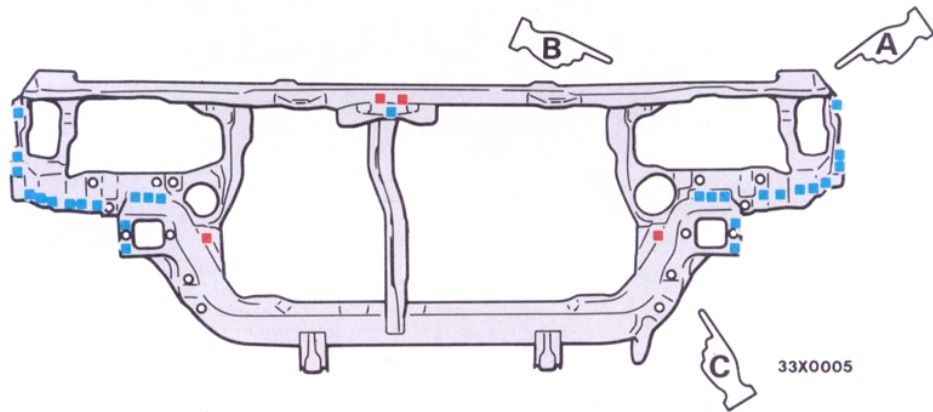
HEADLAMP SUPPORT	3-2
FENDER SHIELD	3-3
FRONT PILLAR	3-5
SIDE SILL	3-7
CENTER PILLAR	3-9
QUARTER, OUTER	3-10
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REAR FLOOR	3-16
ROOF	3-20
QUARTER, INNER	3-24
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HEADLAMP SUPPORT

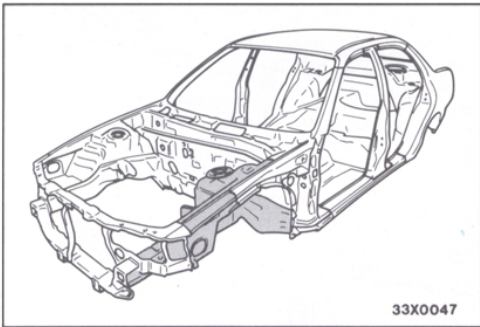


Symbol	Operation description
•••••	Spot welding
■ ■ ■ ■ ■	MIG plug welding ■ indicates two panels to be welded ■ indicates three panels to be welded
+ + + + +	MIG spot welding
	MIG arc welding (Continuous)
○ ○ ○ ○ ○	Braze welding

REPAIR WELDS

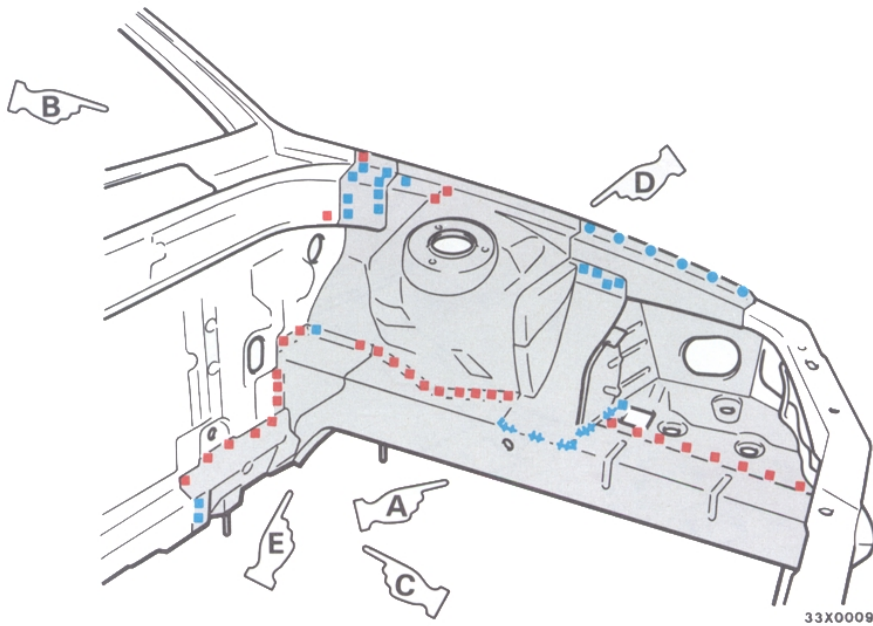


FENDER SHIELD

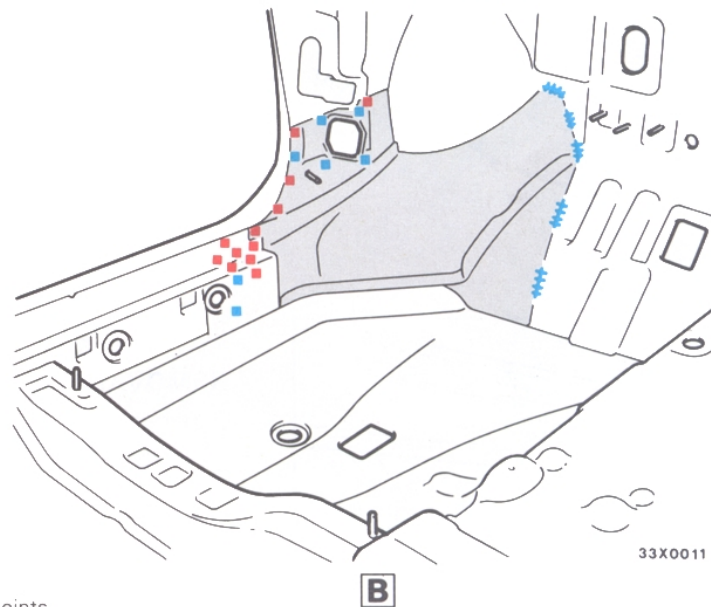
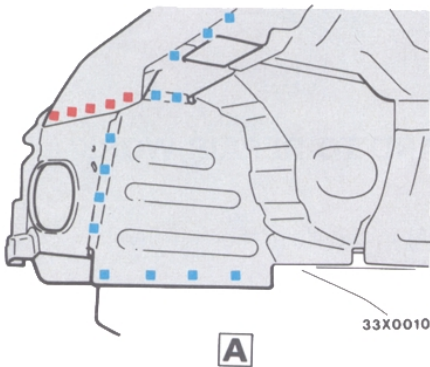


Symbol	Operation description
••••	Spot welding
■ ■ ■ ■	MIG plug welding ■ indicates two panels to be welded ■ indicates three panels to be welded
++++	MIG spot welding
	MIG arc welding (Continuous)
○○○○	Braze welding

REPAIR WELDS

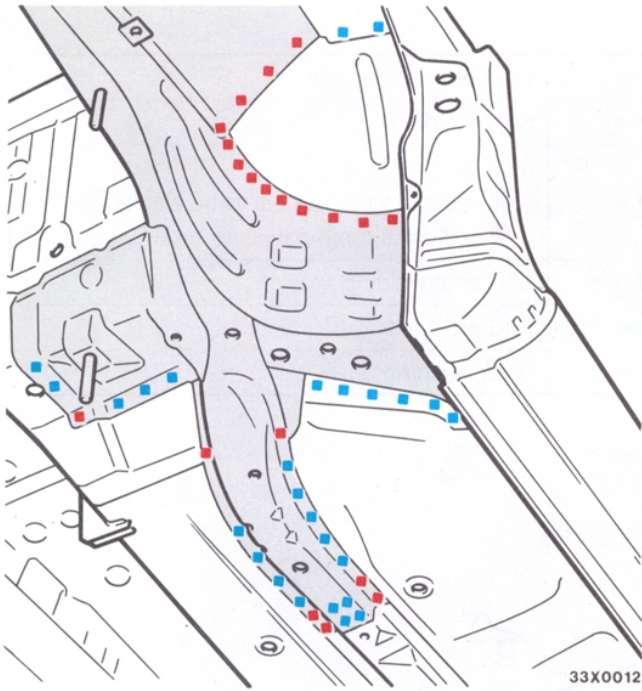


3

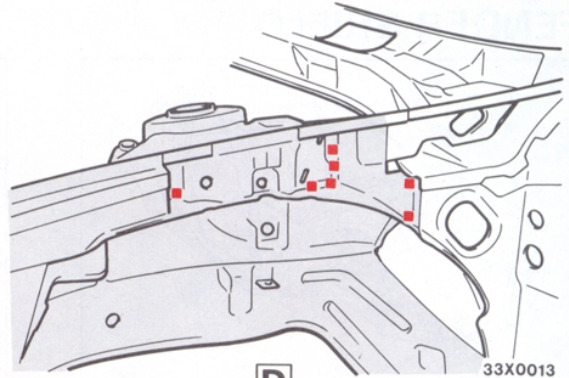


NOTE

- (1) Refer to P.3-2 for the headlamp support weld points.
- (2) Refer to P.3-5 for the front upper frame outer extension weld points.

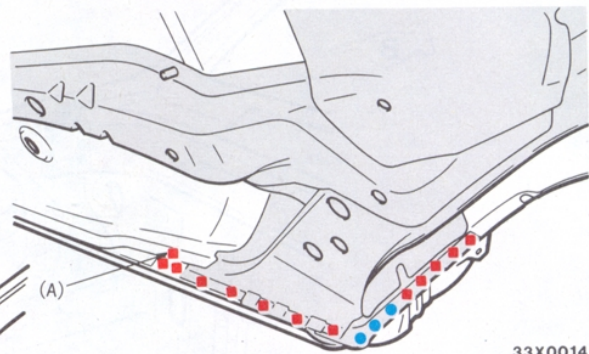


C

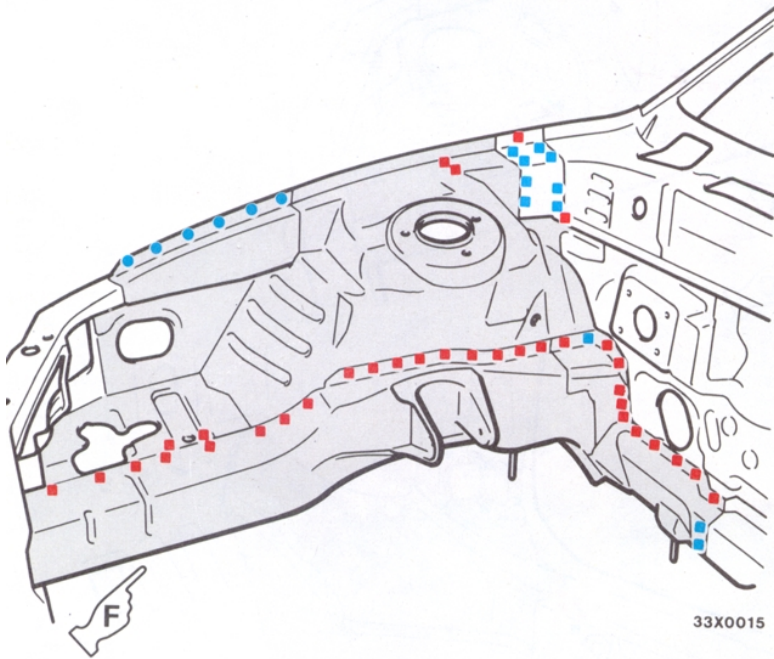


D

(Condition with the front upper frame outer extension removed)

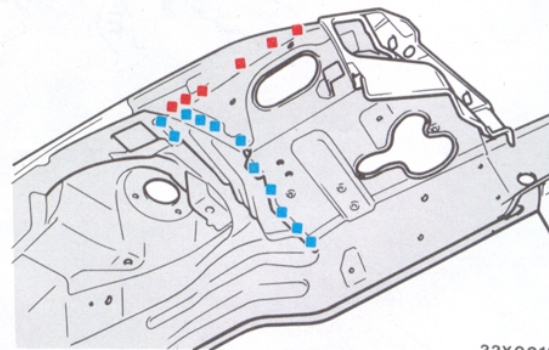


E



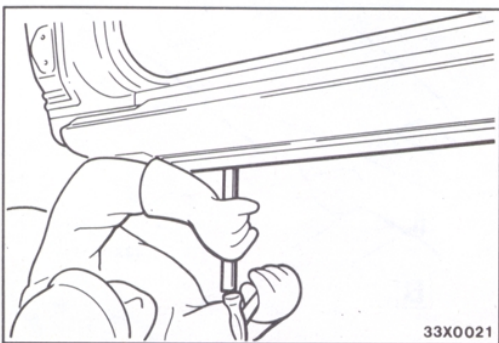
F

33X0015



F

33X0016



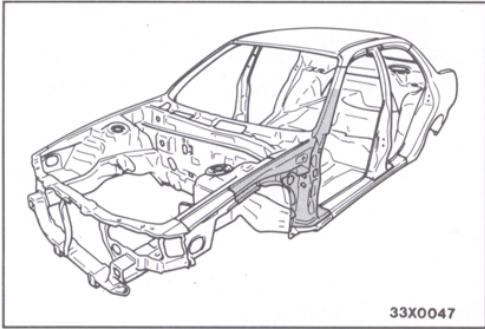
33X0021

NOTES WITH REGARD TO REPAIR WORK

REMOVAL

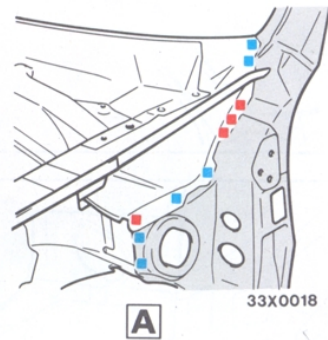
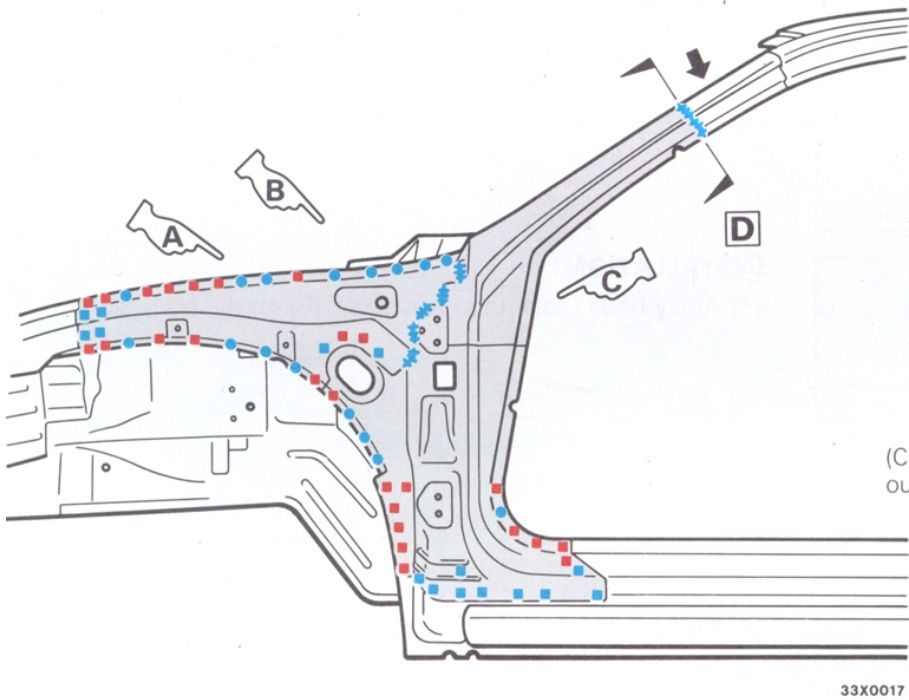
Separate the weld point (A) in the illustration E with a chisel.

FRONT PILLAR



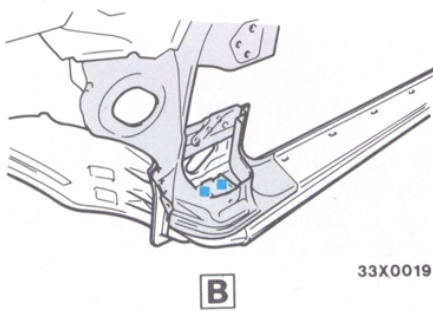
Symbol	Operation description
••••	Spot welding
■ ■ ■ ■	MIG plug welding ■ indicates two panels to be welded ■ indicates three panels to be welded
+ + + +	MIG spot welding
	MIG arc welding (Continuous)
○ ○ ○ ○ ○	Braze welding

REPAIR WELDS

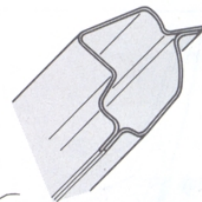
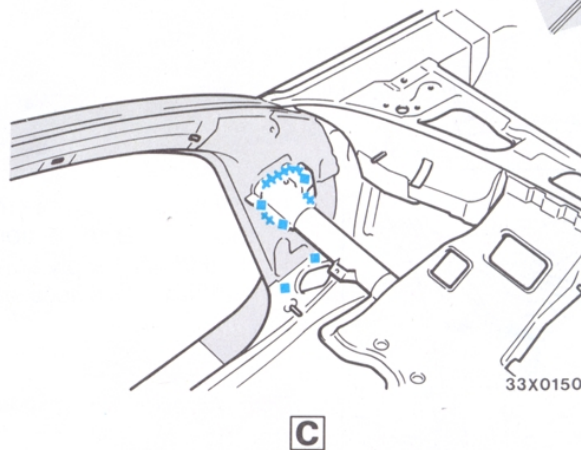


3

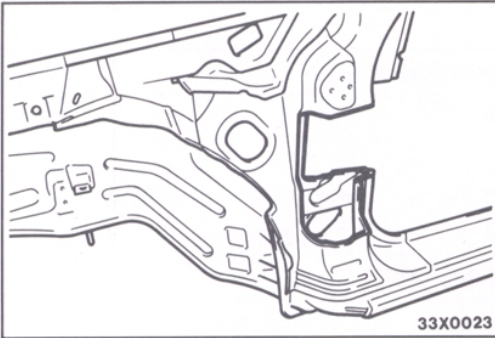
(Condition with the front upper frame outer extension removed)



(The illustration shows the front pillar partially cut and separated)



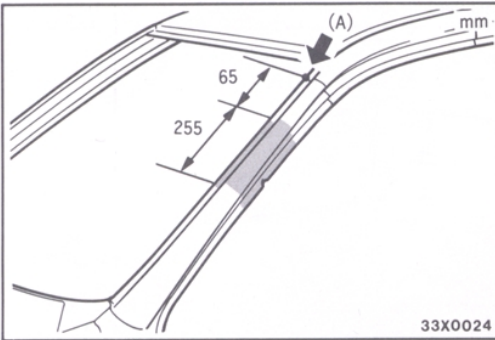
NOTE
 Use the front pillar trim access holes (←) to spray an ample amount of anti-corrosion agent onto the butt welded joints.



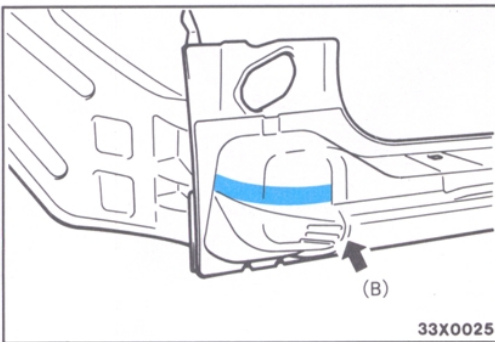
NOTES WITH REGARD TO REPAIR WORK

REMOVAL

(1) In order to separate weld point [B], make a rough cutting of the front pillar outer and inner as shown in the illustration.

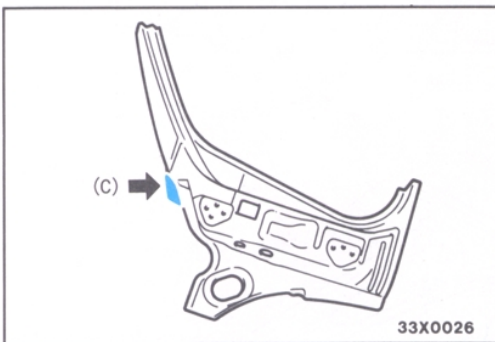


(2) Cut the front pillar 65 mm – 320 mm below the joint (A) between the side roof rail outer and front pillar.

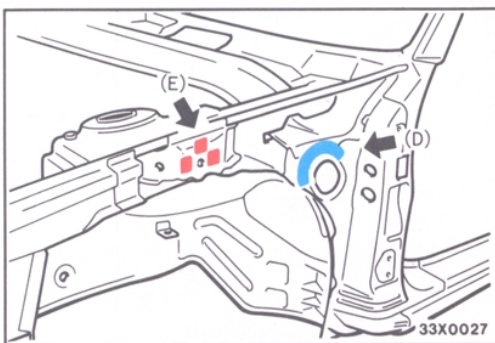


INSTALLATION

(1) Apply body sealant to the side sill (B) on the body side.



(2) Apply body sealant to the new front pillar (C)

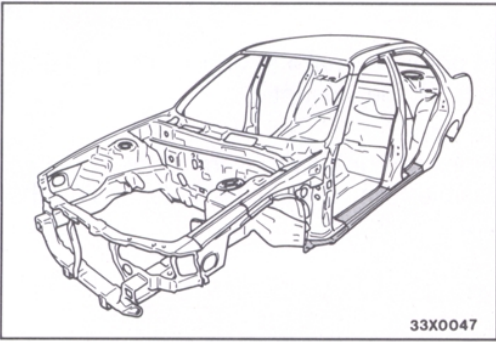


(3) When installing the front upper frame outer extension, apply body sealer to section (D) in the illustration. In addition, apply adhesive to section (E) or make plug welds in the three places shown in the illustration.

 :Adhesive

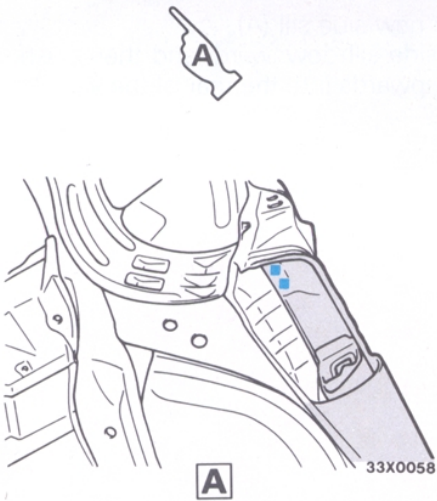
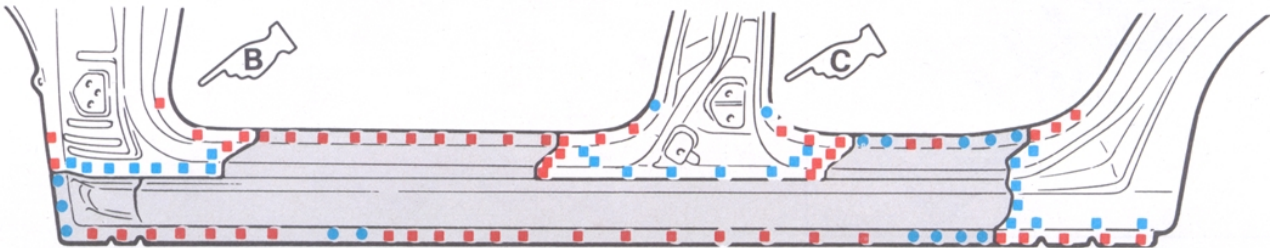
Adhesive	Type
	Acrylic adhesive

SIDE SILL

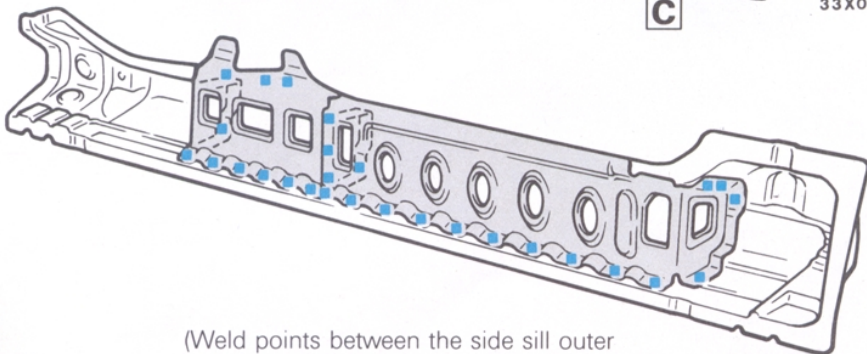
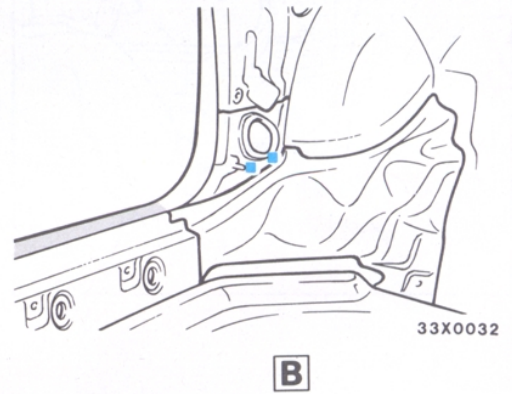
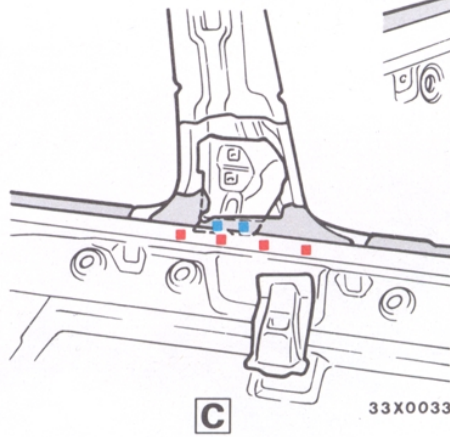


Symbol	Operation description
•••••	Spot welding
■ ■ ■ ■ ■	MIG plug welding ■ indicates two panels to be welded ■ indicates three panels to be welded
+ + + + +	MIG spot welding
	MIG arc welding (Continuous)
○ ○ ○ ○ ○	Braze welding

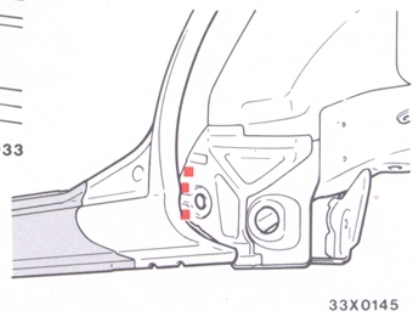
REPAIR WELDS

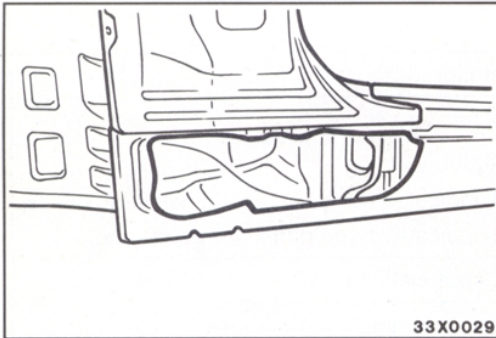


(The illustration shows the side sill outer partially cut and separated)



(Weld points between the side sill outer and reinforcement)





33X0029

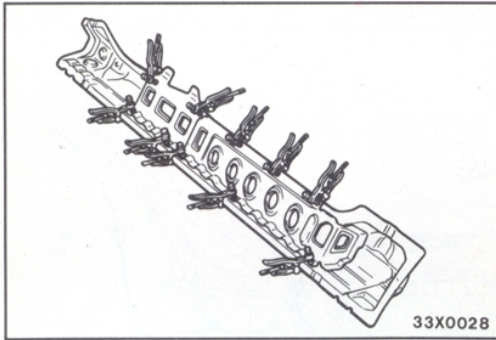
NOTES WITH REGARD TO REPAIR WORK

REMOVAL

In order to separate weld point **A**, make a rough cutting of only the side sill outer as shown in the illustration.

NOTE

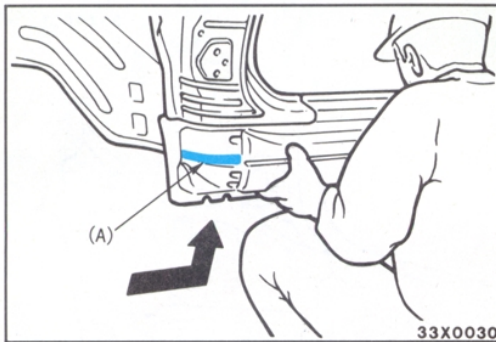
When installing, make holes through two layers of the panel so that plug welding is possible from the access holes inside the passenger compartment.



33X0028

INSTALLATION

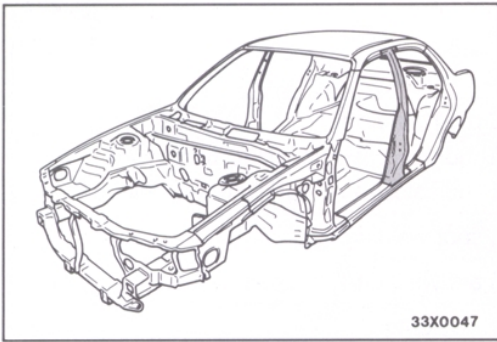
- (1) Make a sub-assembly from the new side sill outer and the side sill reinforcement front and center.



33X0030

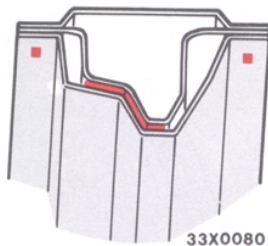
- (2) Apply body sealant to the new side sill (A).
- (3) Tilt the front of the new side sill downward, and then push the whole of the side sill upwards into the rear of the vehicle to install it.

CENTER PILLAR

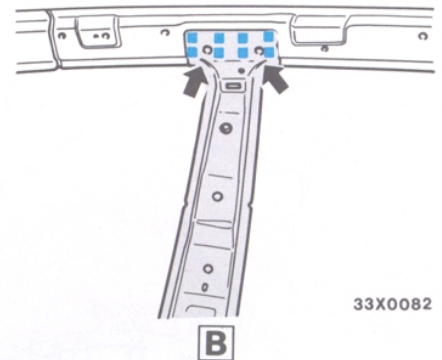
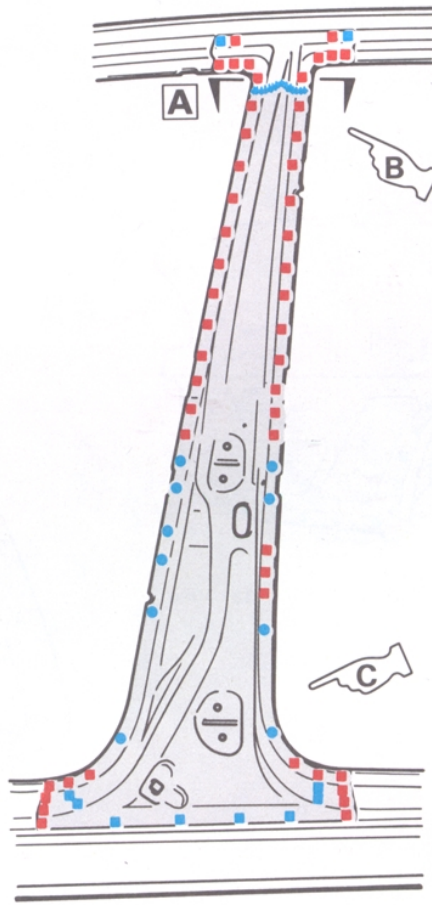


Symbol	Operation description
••••	Spot welding
■ ■ ■ ■	MIG plug welding ■ indicates two panels to be welded ■ indicates three panels to be welded
++++	MIG spot welding
	MIG arc welding (Continuous)
○○○○	Brze welding

REPAIR WELDS

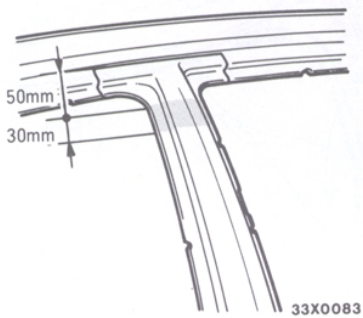


A

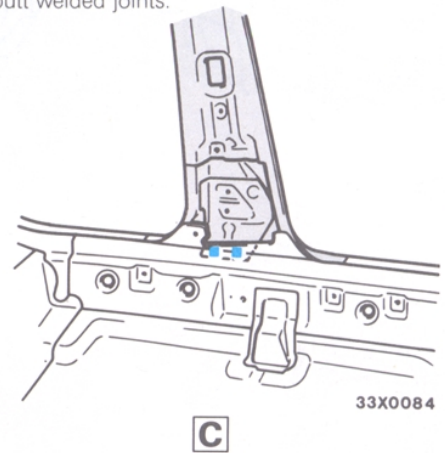


B

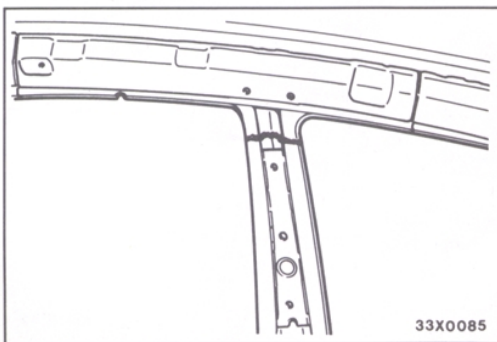
NOTE
Use the access holes (◀) to spray an ample amount of anti-corrosion agent onto the butt welded joints.



(Possible cutting range of center pillar outer)



C



NOTES WITH REGARD TO REPAIR WORK

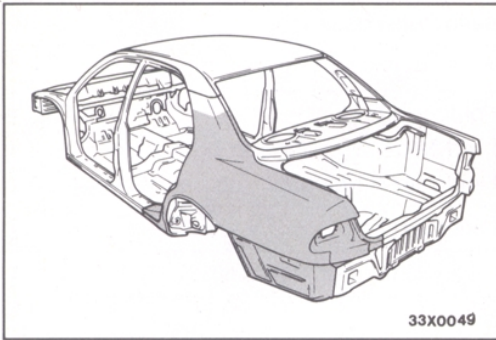
INSTALLATION

Before installing the center pillar inner extension to the vehicle body, securely butt-weld the center pillar outer reinforcement from the passenger compartment side.

Caution

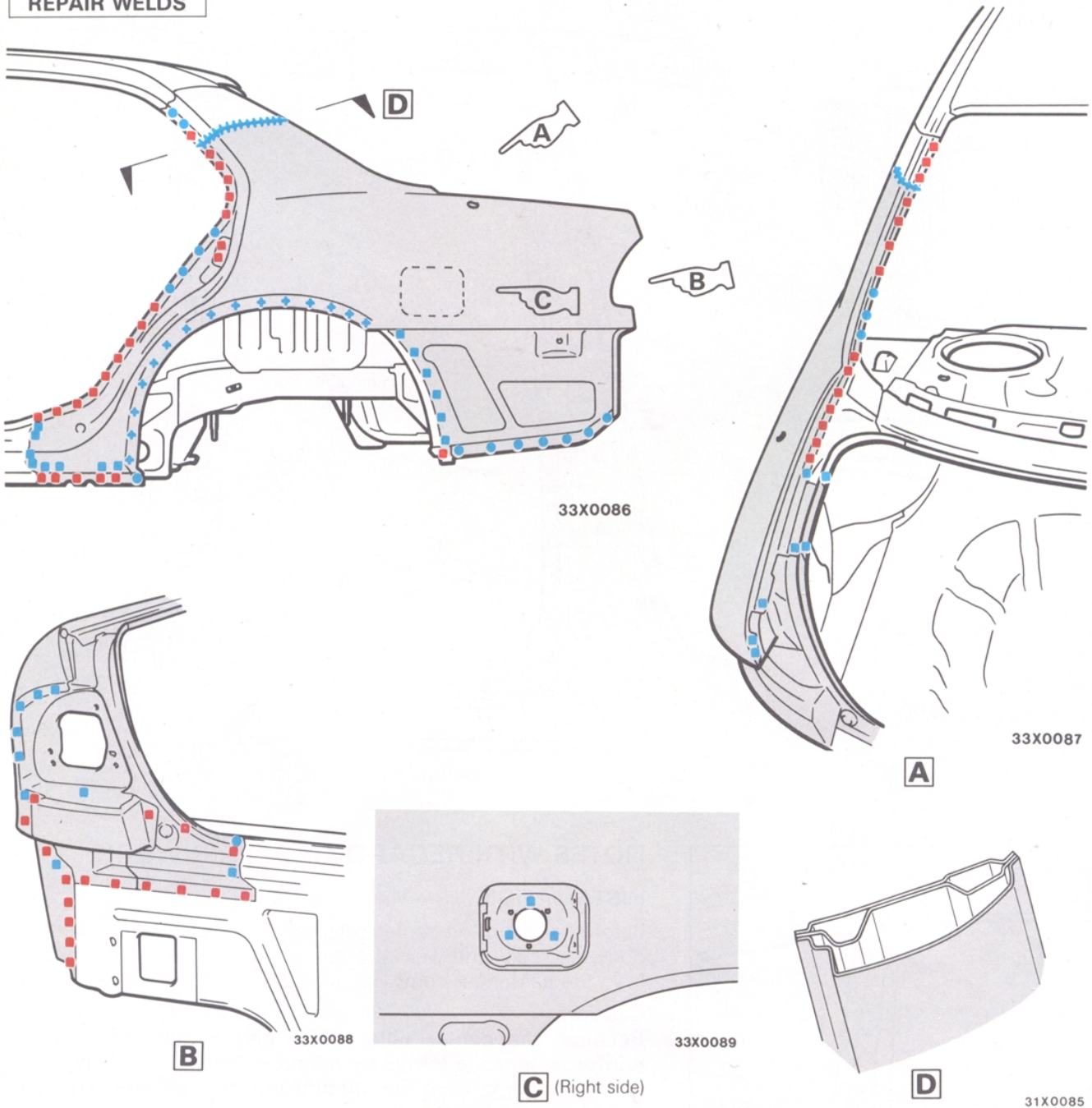
Because the center pillar outer and center pillar outer reinforcement are joined by adhesive, make every effort to keep the joint cool by minimizing the effects of heat resulting from butt-welding.

QUARTER, OUTER [SEDAN]



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

REPAIR WELDS



33X0086

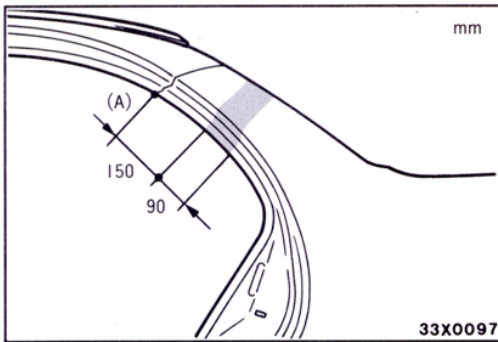
33X0087

33X0088

33X0089

31X0085

C (Right side)



NOTES WITH REGARD TO REPAIR WORK

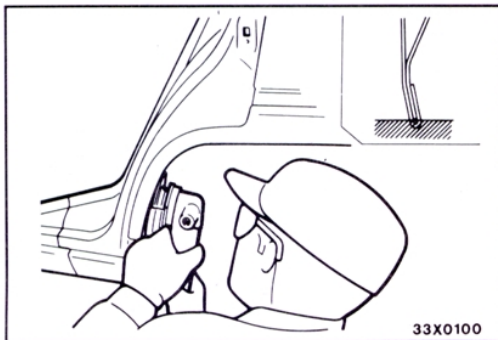
REMOVAL

- (1) Cut only the quarter panel outer 150–240 mm below the joint (A) between the side roof rail outer and the quarter panel outer, while being careful not to damage the rear pillar seat belt reinforcement.

Caution

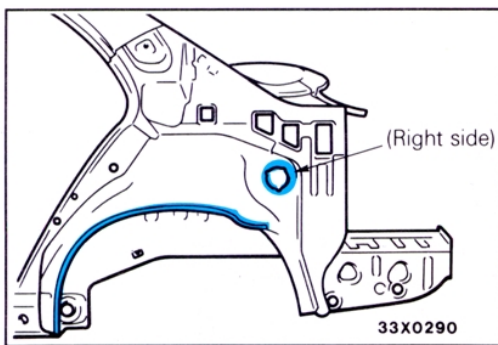
If the rear pillar seat belt reinforcement should become damaged, repair it by welding.

- (2) Cut the hemming on the wheel arch with a grinder or belt sander.



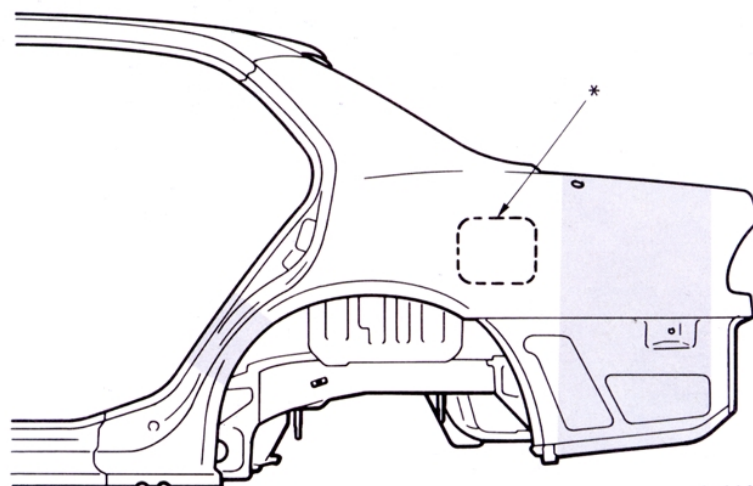
INSTALLATION

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



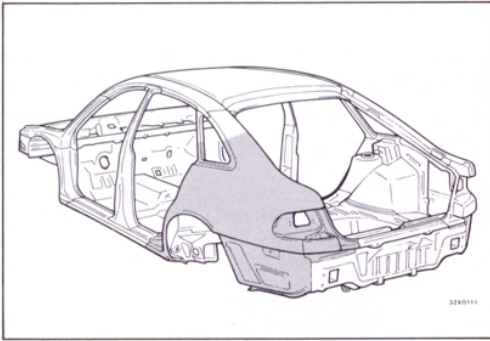
NOTE

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



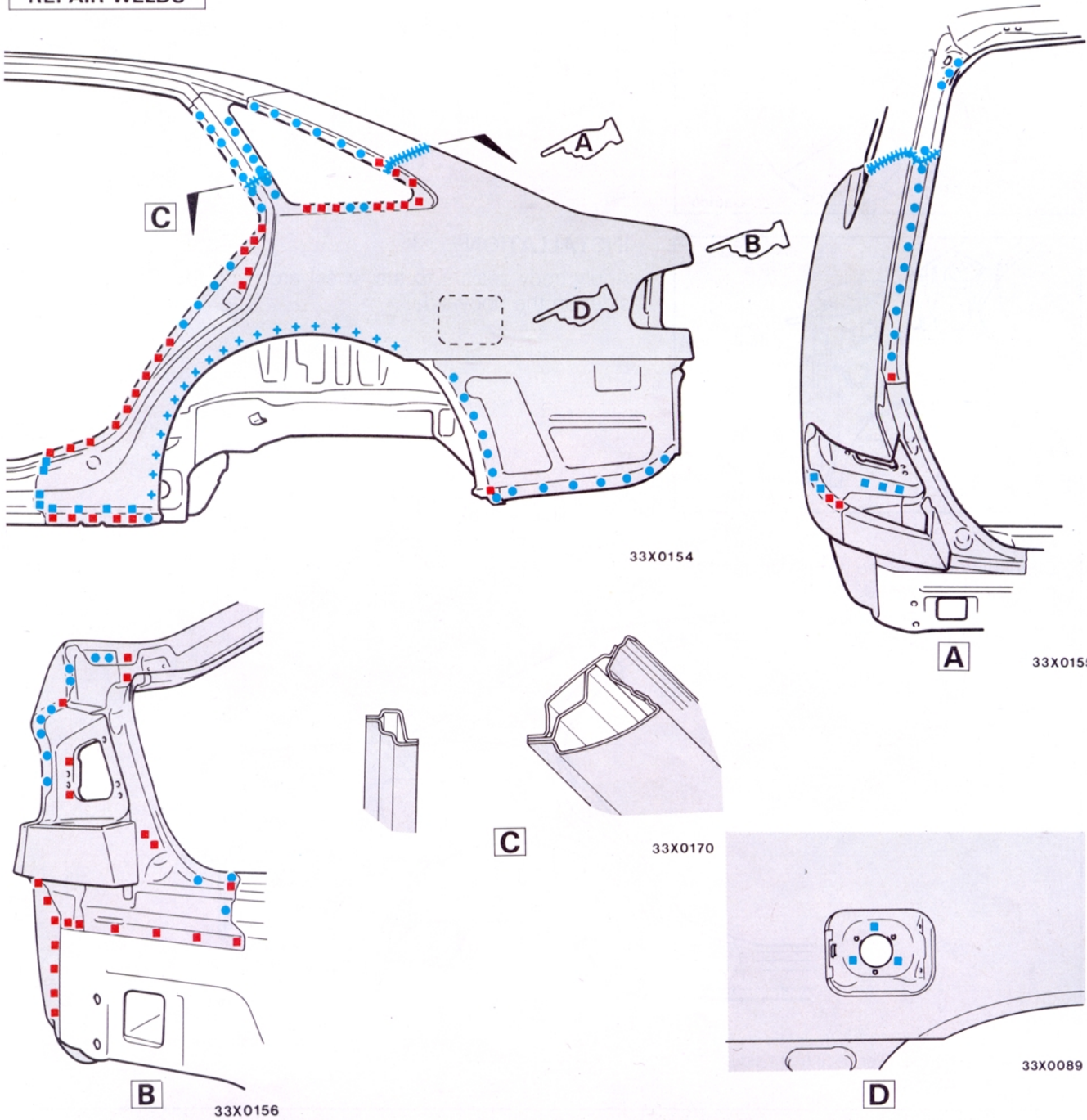
- * : Avoid the fuel filler neck (right side)
- : Area that can be cut

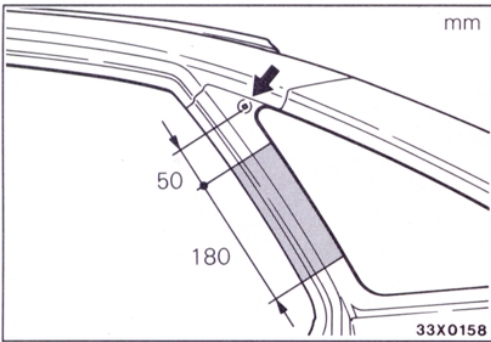
QUARTER, OUTER [HATCHBACK]



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

REPAIR WELDS

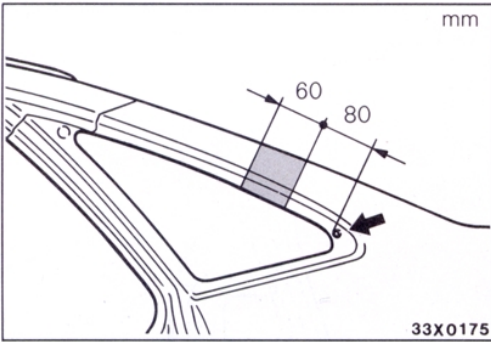




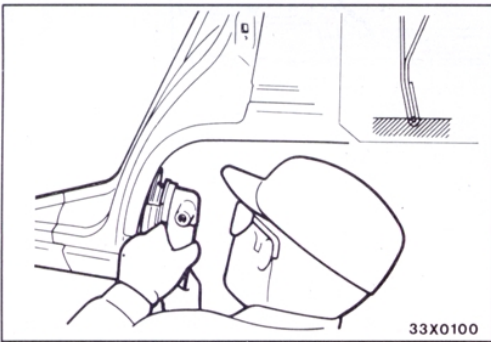
NOTES WITH REGARD TO REPAIR WORK

REMOVAL

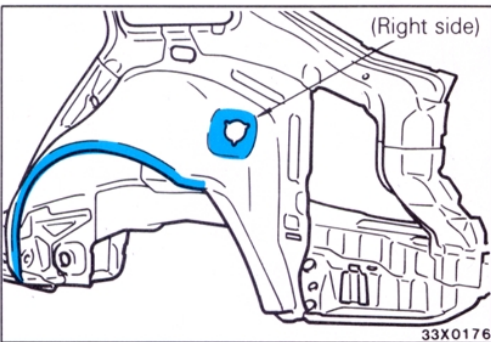
(1) Cut only the quarter panel outer of the rear pillar 50–230 mm below the quarter glass mounting hole indicated by (←) in the illustration.



(2) Cut the quarter panel outer and quarter panel outer extension of the gate pillar 80–140 mm below the positioning hole indicated by (←) in the illustration.

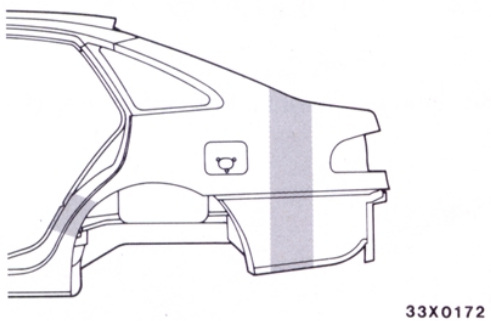


(3) Cut the hemming on the wheel arch with a grinder or belt sander.



INSTALLATION

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



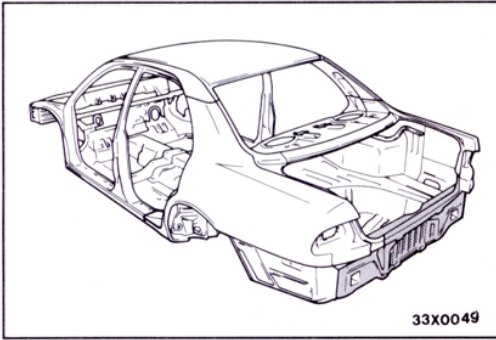
NOTE

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

* : Avoid the fuel filler neck (right side).

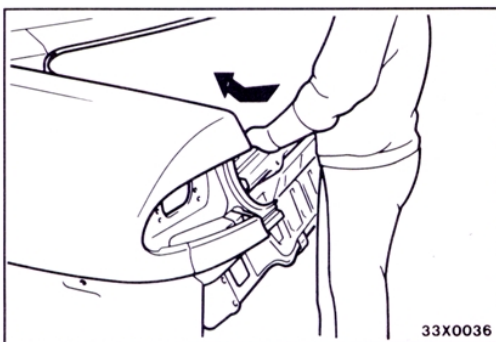
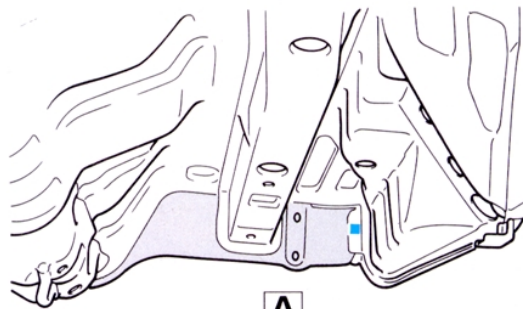
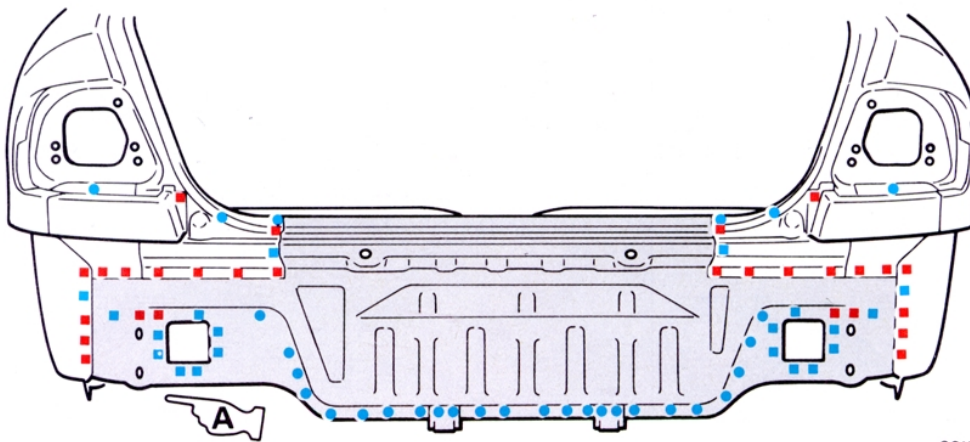
■ : Area that can be cut

REAR END PANEL [SEDAN]



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

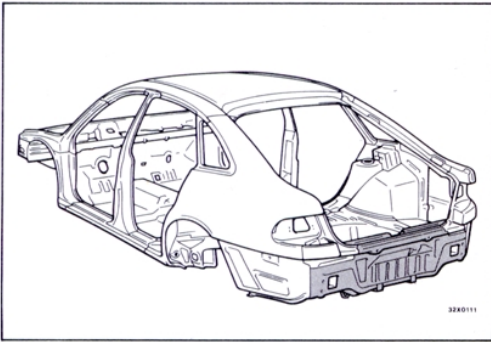
REPAIR WELDS



NOTES WITH REGARD TO REPAIR WORK
REMOVAL

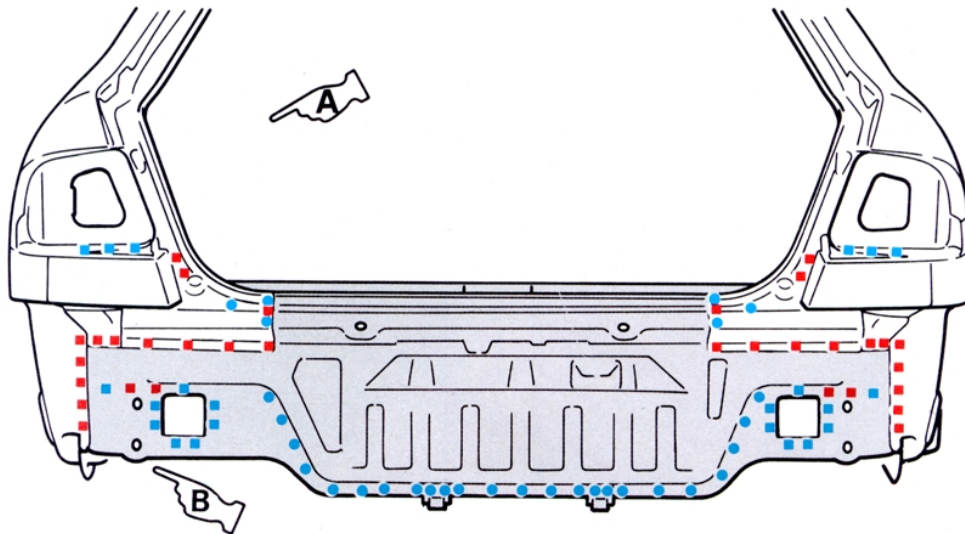
Push and tilt the rear end panel to prevent it from interfering other parts, and pull it out.

REAR END PANEL [HATCHBACK]

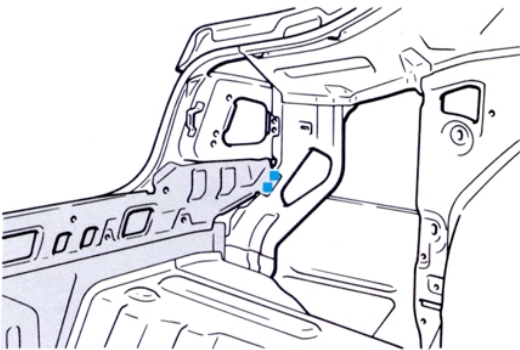


Symbol	Operation description
••••	Spot welding
■ ■ ■ ■	MIG plug welding ■ indicates two panels to be welded ■ indicates three panels to be welded
++++	MIG spot welding
	MIG arc welding (Continuous)
○○○○	Braze welding

REPAIR WELDS

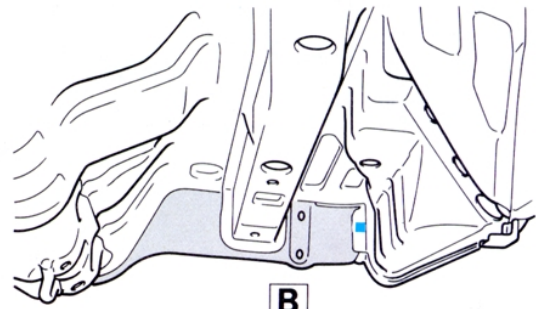


33X0157



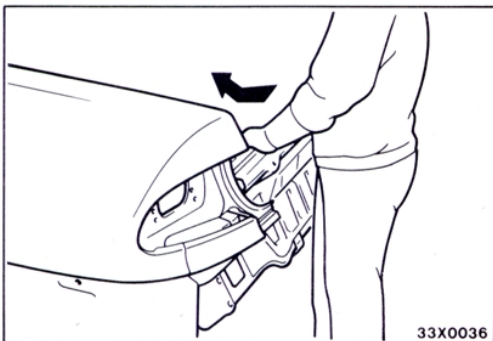
A

33X0160



B

33X0174



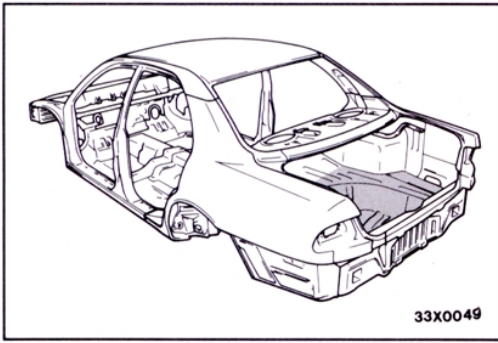
33X0036

NOTES WITH REGARD TO REPAIR WORK

REMOVAL

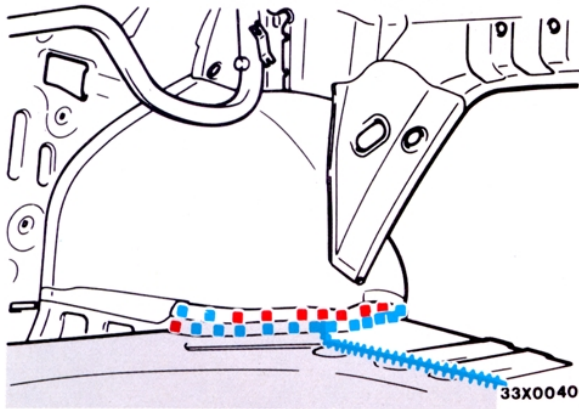
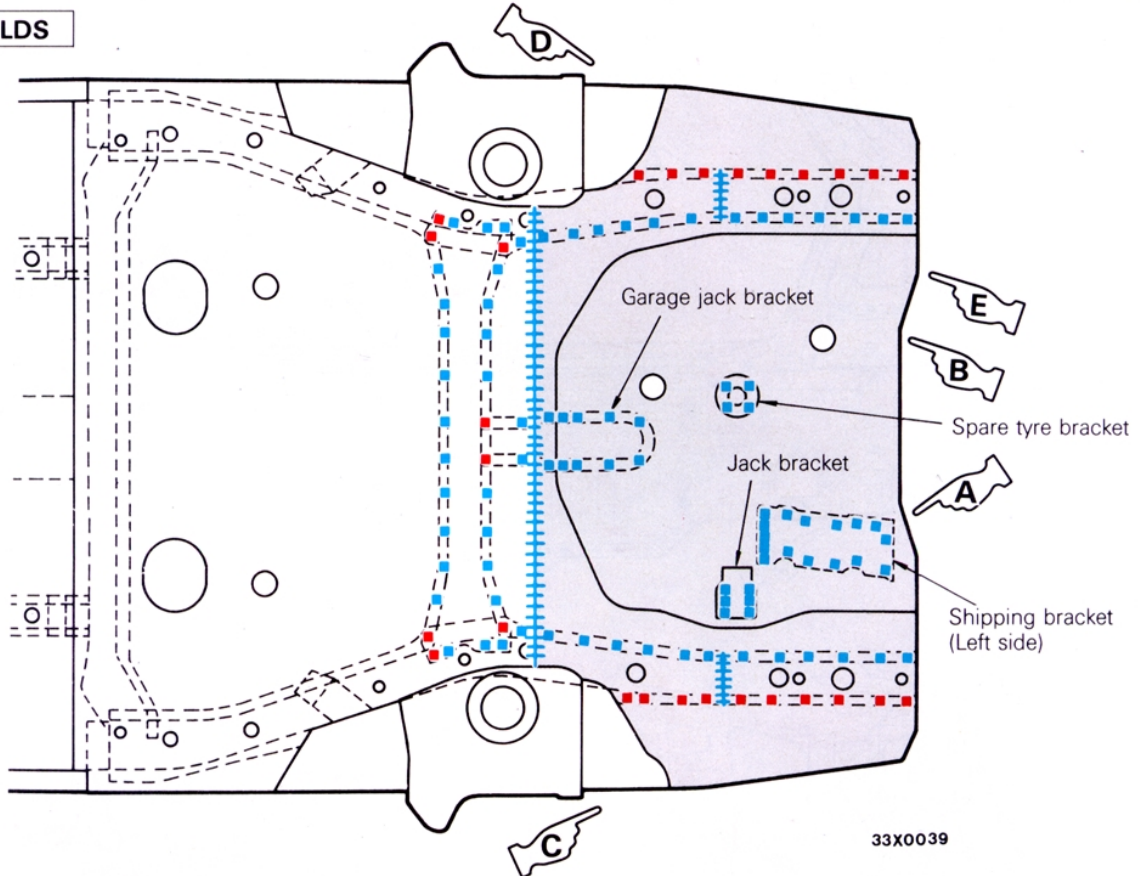
Pull and tilt the rear end panel to prevent it from interfering other parts, and pull it out.

REAR FLOOR

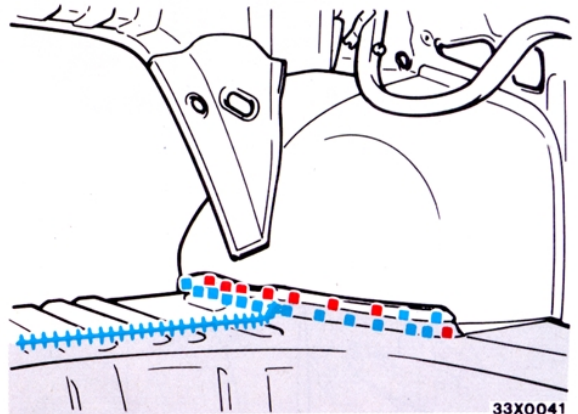


Symbol	Operation description
•••••	Spot welding
■ ■ ■ ■ ■	MIG plug welding ■ indicates two panels to be welded ■ indicates three panels to be welded
+ + + + +	MIG spot welding
	MIG arc welding (Continuous)
○○○○○○○	Braze welding

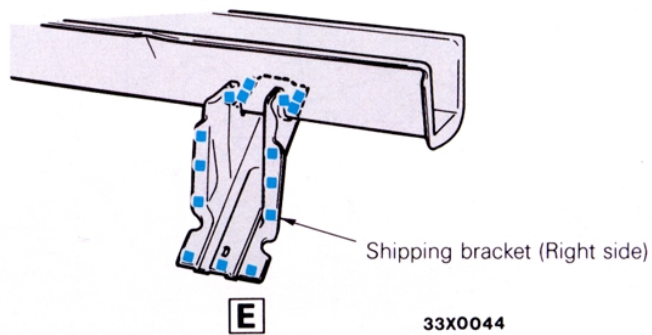
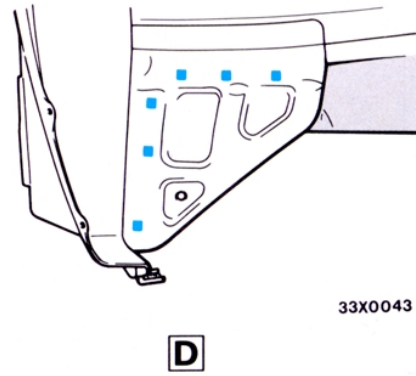
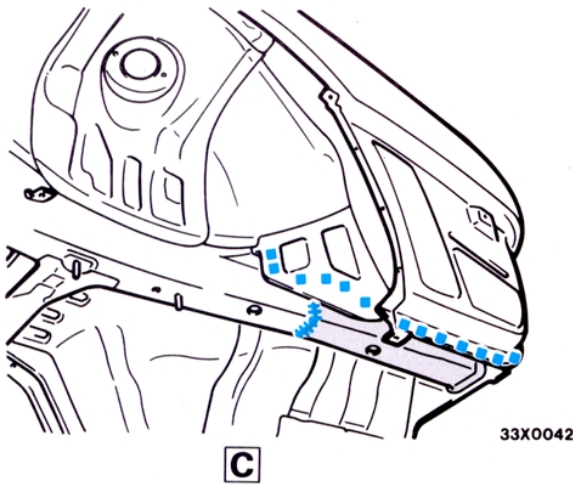
REPAIR WELDS



A

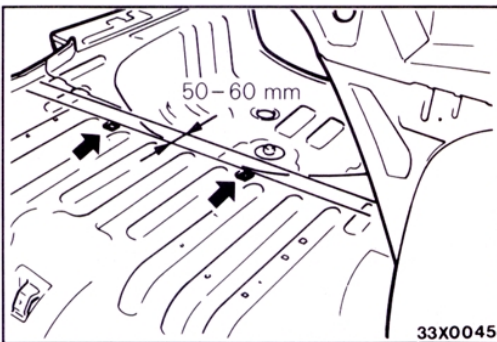


B



(Condition with the rear floor pan removed)

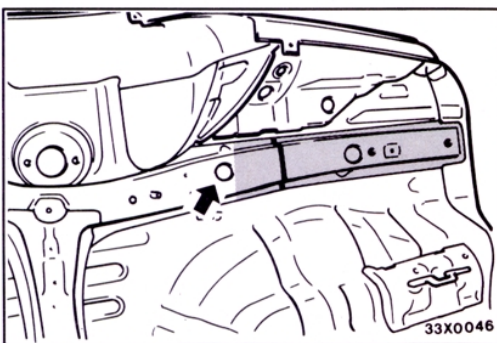
NOTE
Refer to P.3-14 for the rear end panel weld points.



NOTES WITH REGARD TO REPAIR WORK

REMOVAL

- (1) In order to make cutting of the rear floor panel easier, separate the weld points on the garage jack bracket before cutting.
- (2) Cut the rear floor pan 50-60 mm behind the trunk board mounting hole indicated by (←) in the illustration.

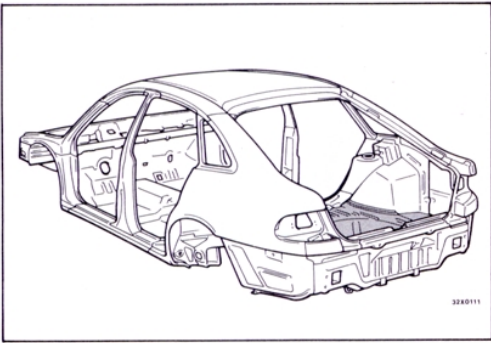


- (3) Cut the rear floor sidemember behind the drain hole indicated by (←) in the illustration.

INSTALLATION (Vehicles for GCC)

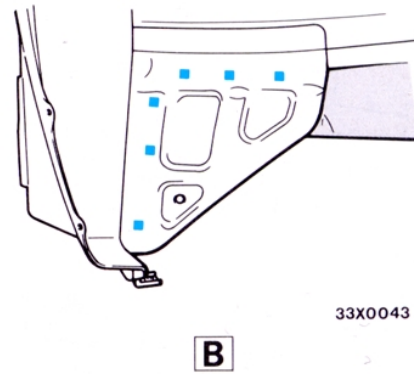
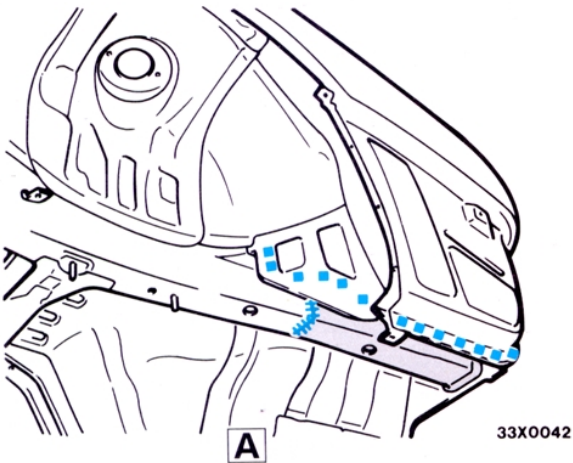
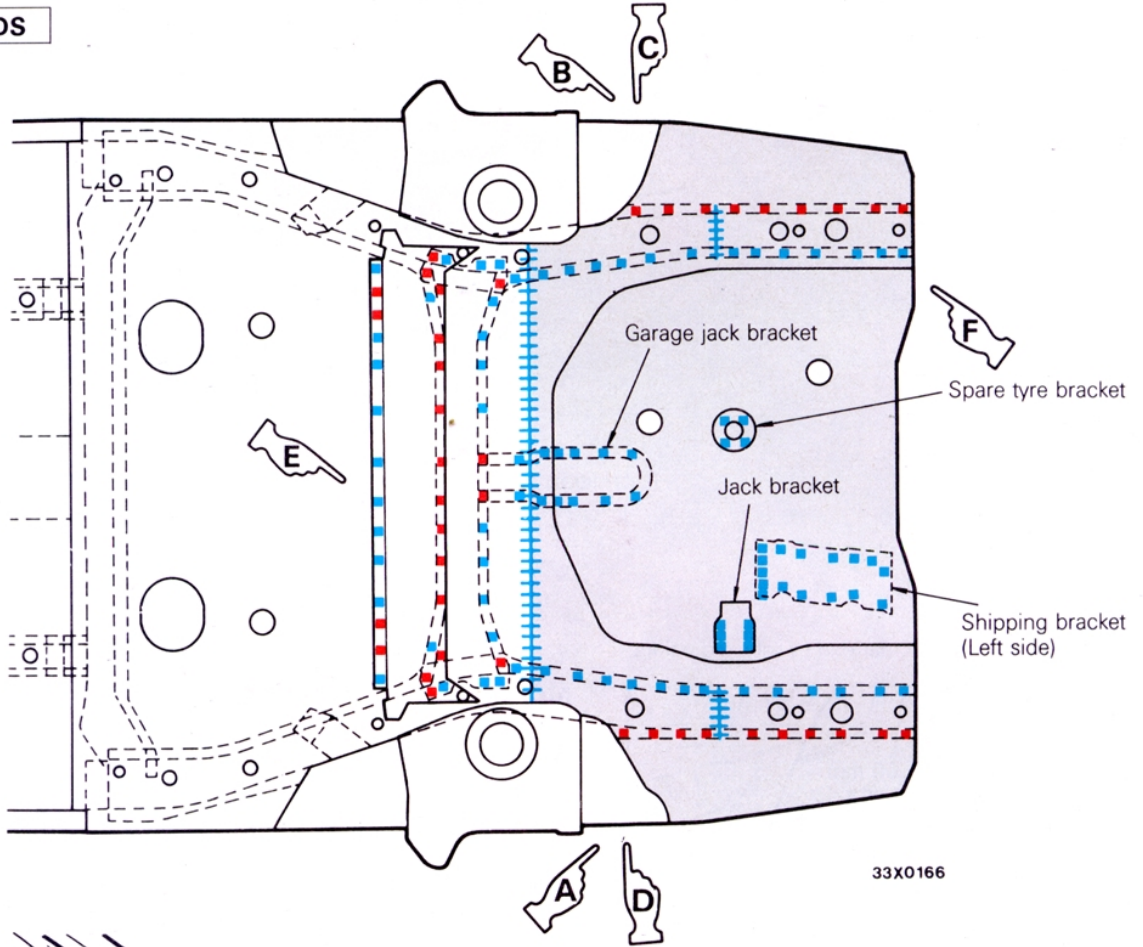
Securely butt-weld the rear floor sidemember reinforcement from the passenger compartment side.

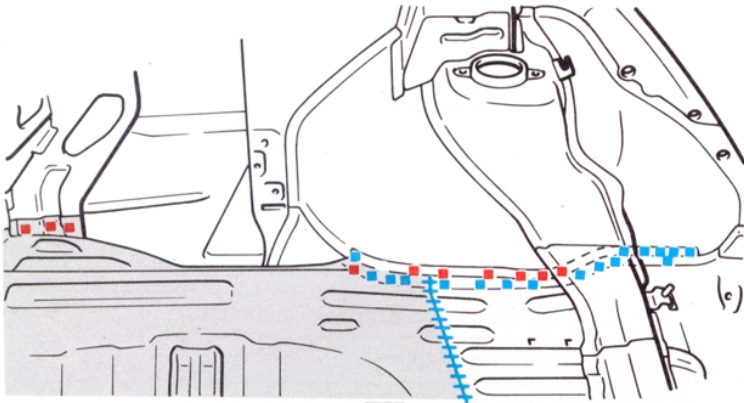
REAR FLOOR [HATCHBACK]



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

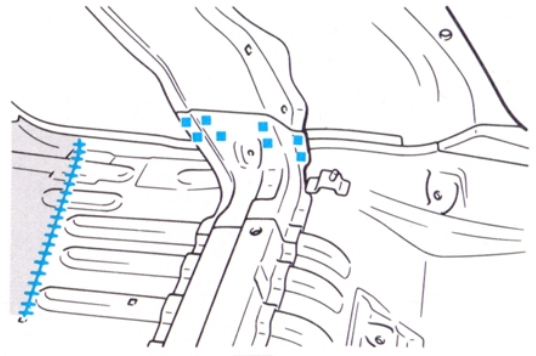
REPAIR WELDS





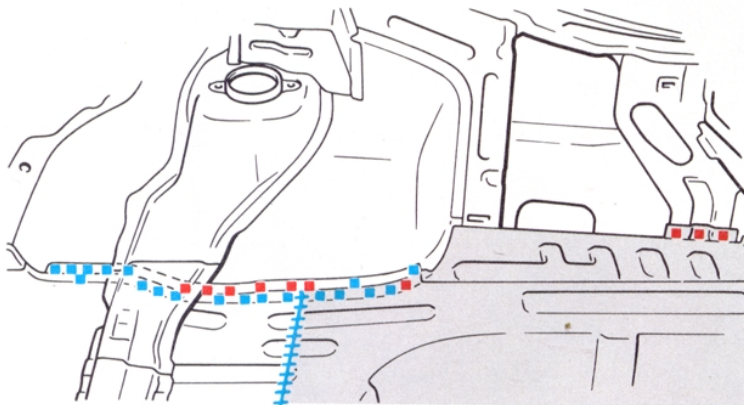
C

33X0161



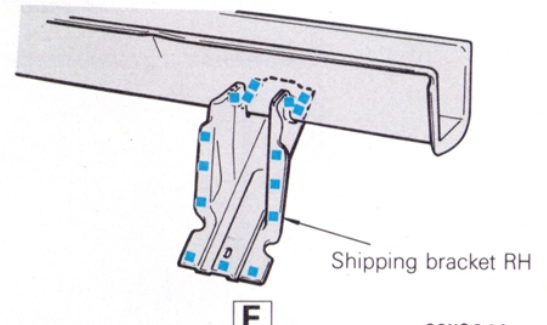
E

33X0163



D

33X0162

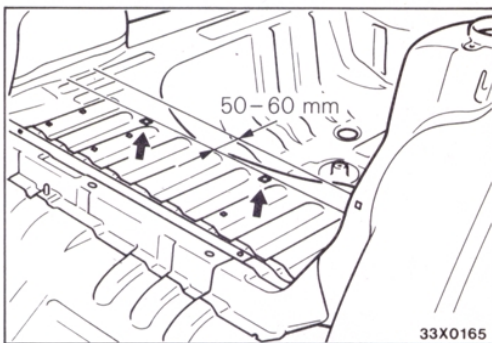


F

33X0044

(Condition with rear floor pan removed)

NOTE
Refer to P. 3-15 for the rear end panel weld points.

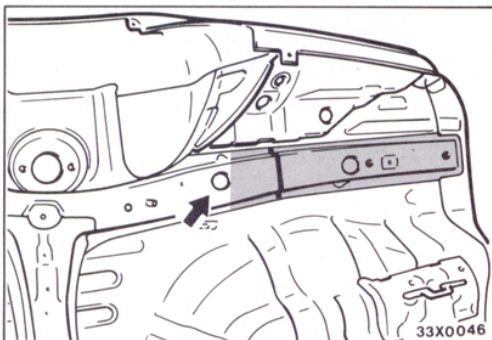


33X0165

NOTES WITH REGARD TO REPAIR WORK

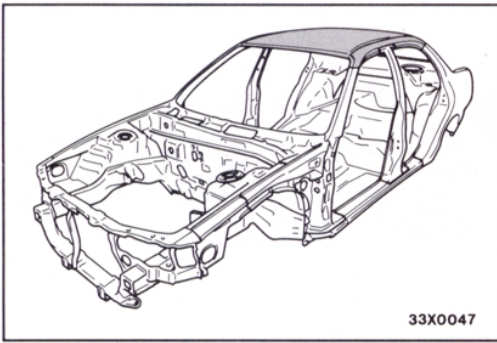
REMOVAL

- (1) In order to make cutting of the rear floor panel easier, separate the weld points on the garage jack bracket before cutting.
- (2) Cut the rear floor pan 50-60 mm behind the trunk board mounting hole indicated by (←) in the illustration.
- (3) Cut the rear floor sidemember behind the drain hole indicated by (←) in the illustration.



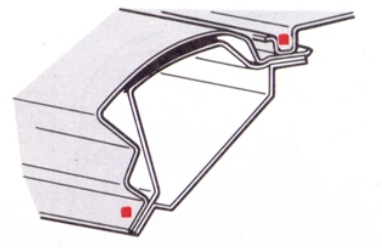
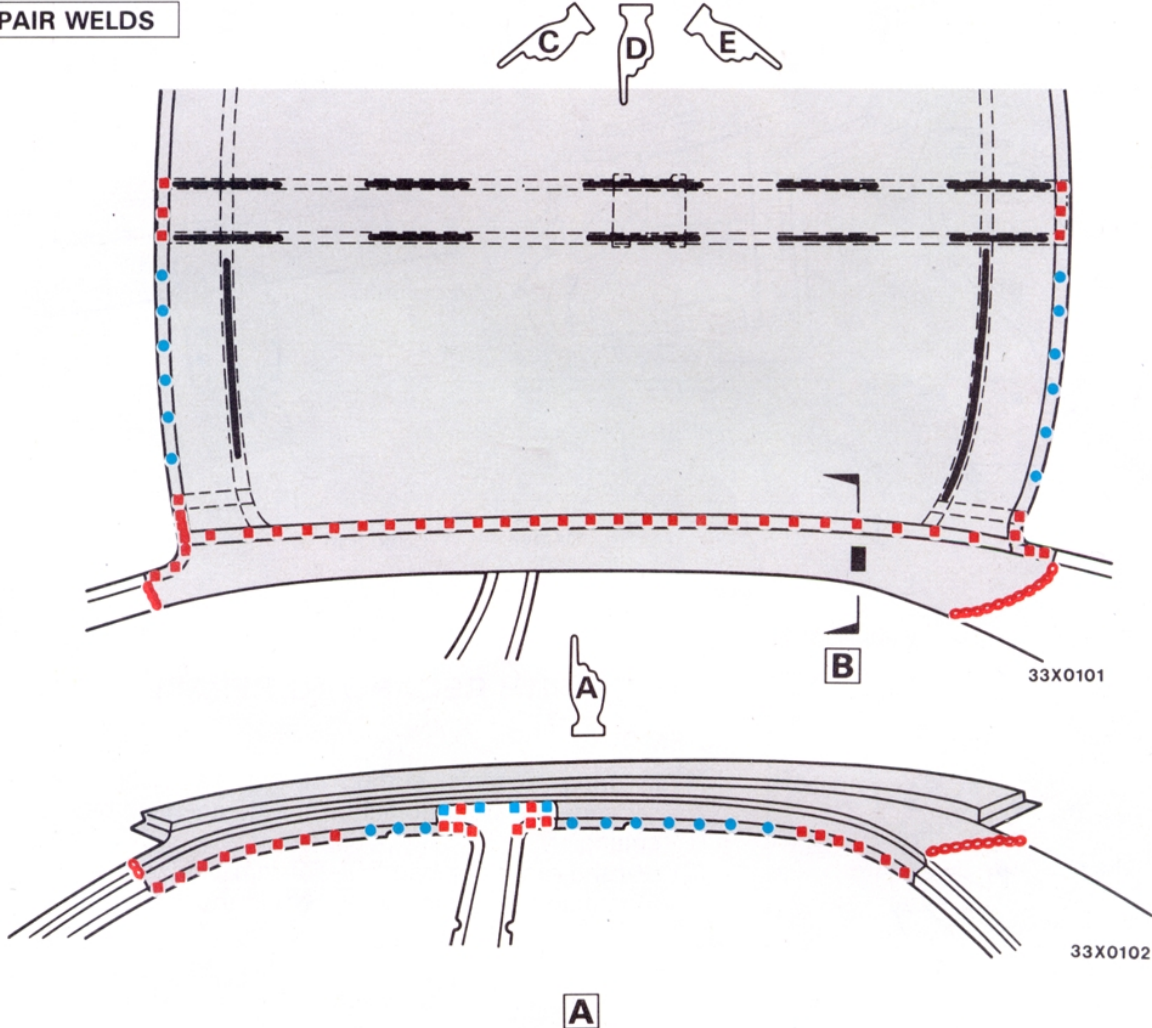
33X0046

ROOF [SEDAN]



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

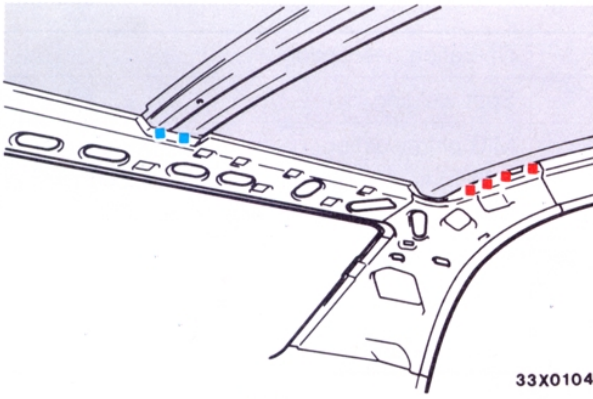
REPAIR WELDS



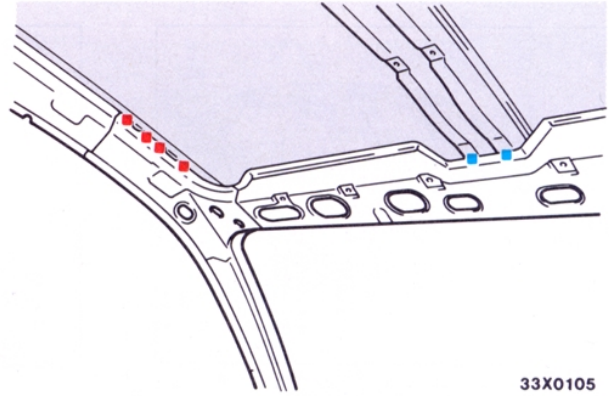
■ : Adhesive

Adhesive	Type
	Chloroprene-base drying sealant

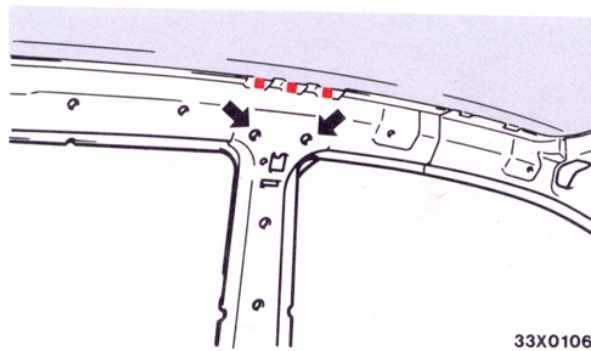
B 33X0103



E



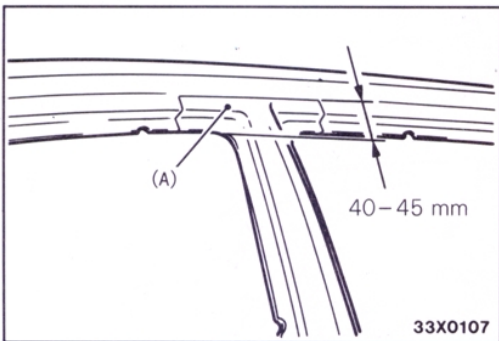
C



D

NOTE

Use the access holes (↖) to spray an ample amount of anti-corrosion agent onto the butt welded joints.



NOTES WITH REGARD TO REPAIR WORK

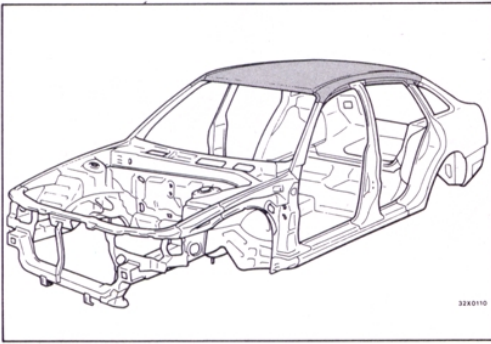
REMOVAL

In order to remove the side roof rail outer, cut the outer panel only of the center pillar outer 40–45 mm below the joint between the center pillar outer and the side roof rail outer.

NOTE

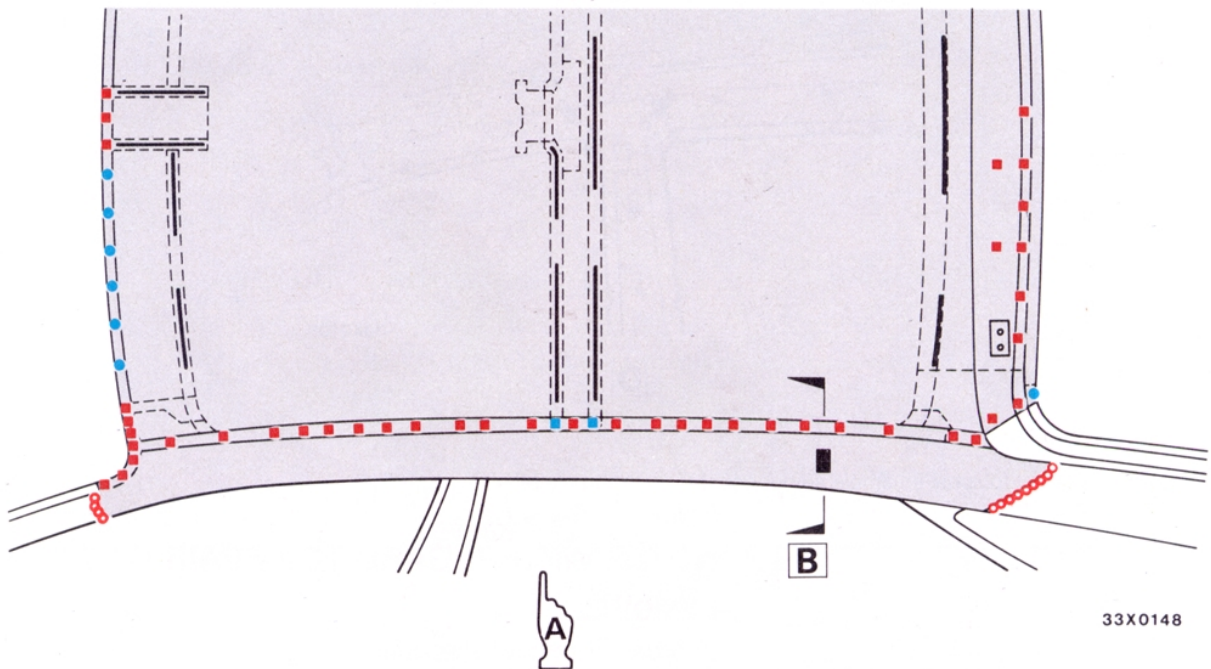
The cut outer panel (A) will be reused, so it should be kept.

ROOF [HATCHBACK]

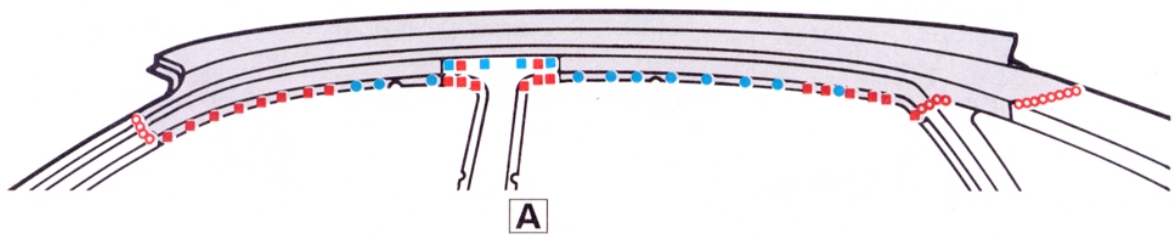


Symbol	Operation description
•••••	Spot welding
■ ■ ■ ■ ■	MIG plug welding ■ indicates two panels to be welded ■ indicates three panels to be welded
+ + + + +	MIG spot welding
	MIG arc welding (Continuous)
○ ○ ○ ○ ○	Braze welding

REPAIR WELDS



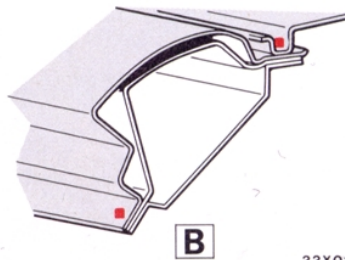
33X0148



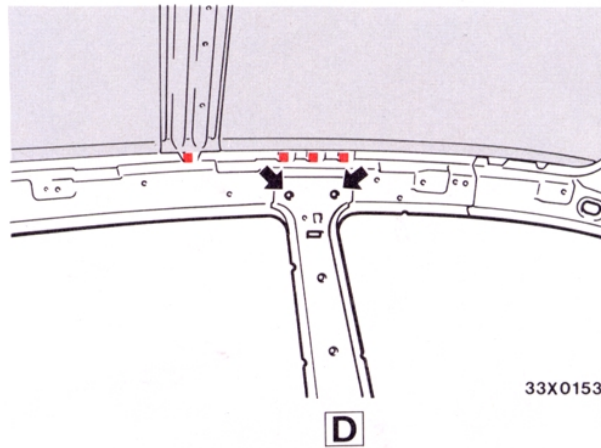
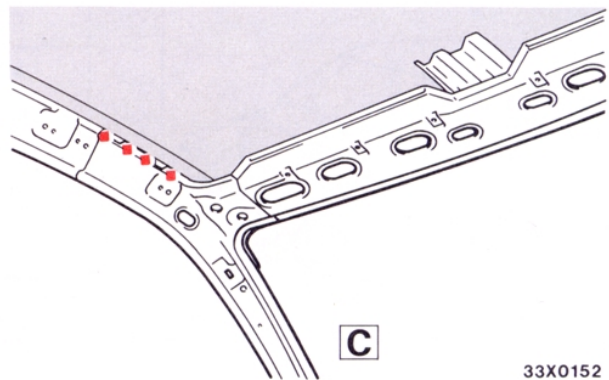
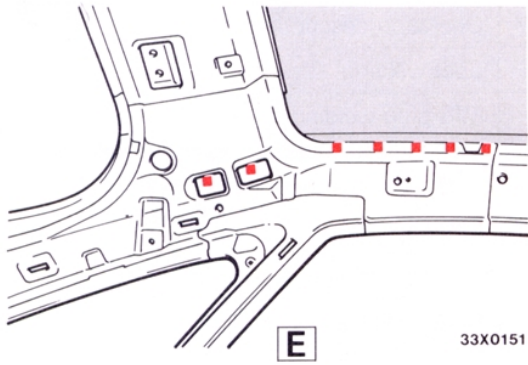
33X0149

■ : Adhesive

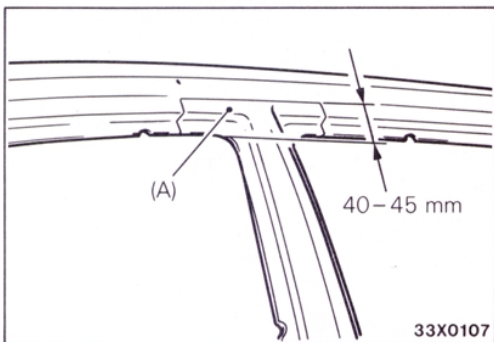
Adhesive	Type
	Chloroprene-base drying sealant



33X0103



NOTE
Use the access holes (↔) to spray an ample amount of anti-corrosion agent onto the butt welded joints



NOTES WITH REGARD TO REPAIR WORK

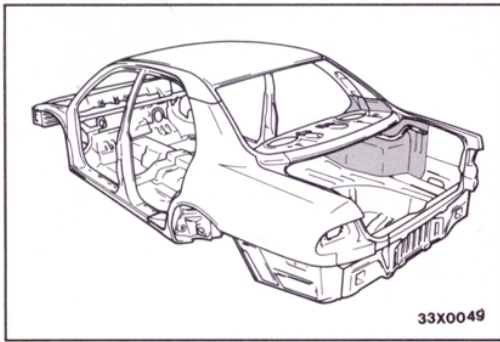
REMOVAL

In order to remove the side roof rail outer, cut the outer panel only of the center pillar outer 40-45 mm below the joint between the center pillar outer and the side roof rail outer.

NOTE

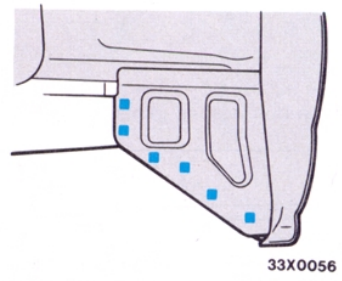
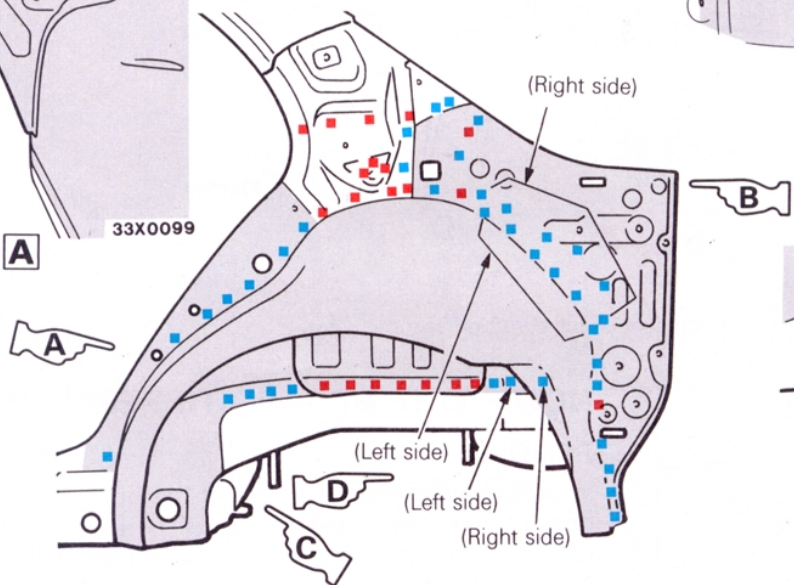
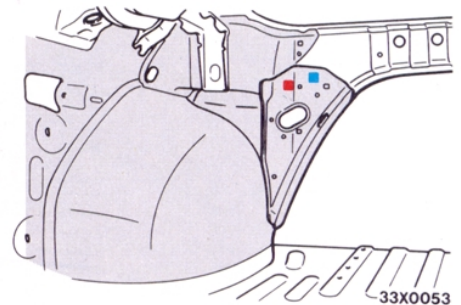
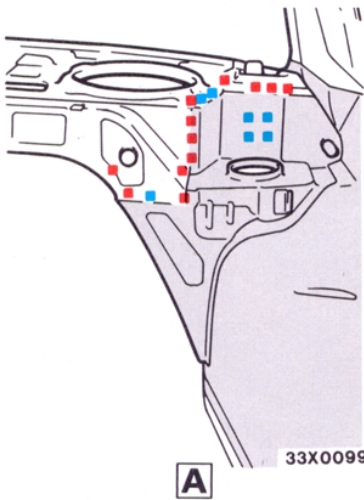
The cut outer panel (A) will be reused, so it should be kept.

QUARTER, INNER [SEDAN]

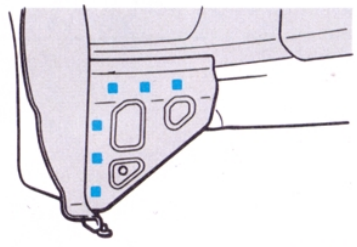
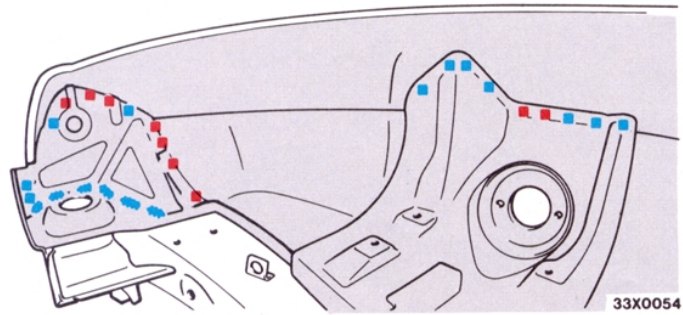


Symbol	Operation description
••••	Spot welding
■ ■ ■ ■	MIG plug welding ■ indicates two panels to be welded ■ indicates three panels to be welded
+ + + +	MIG spot welding
	MIG arc welding (Continuous)
○ ○ ○ ○ ○ ○	Braze welding

REPAIR WELDS

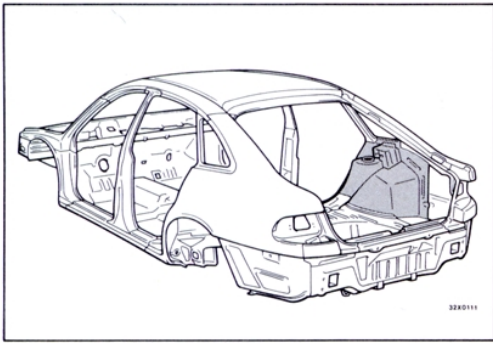


33X0171



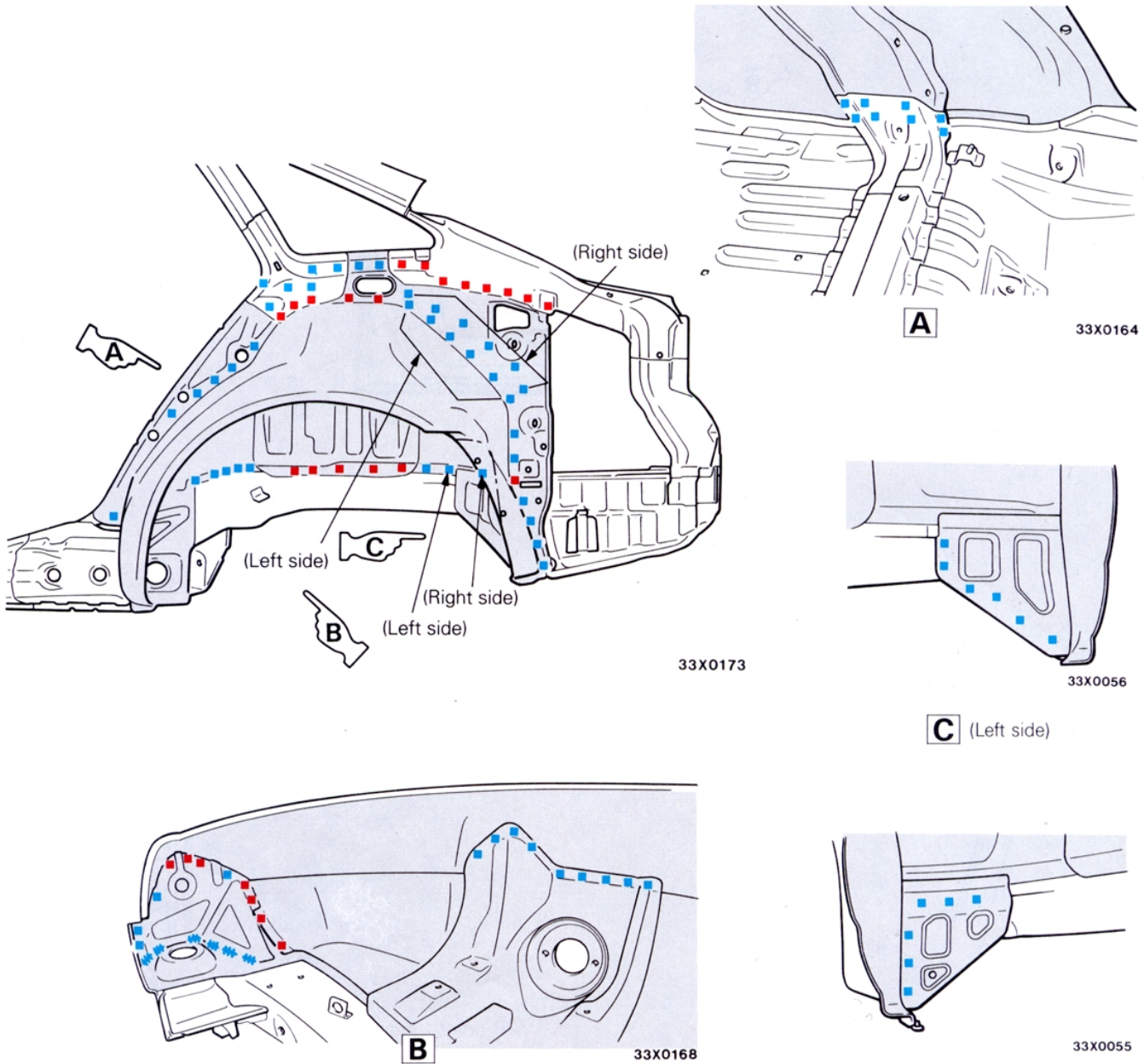
NOTE
 Refer to P.3-10 for the quarter outer weld points.

QUARTER, INNER [HATCHBACK]



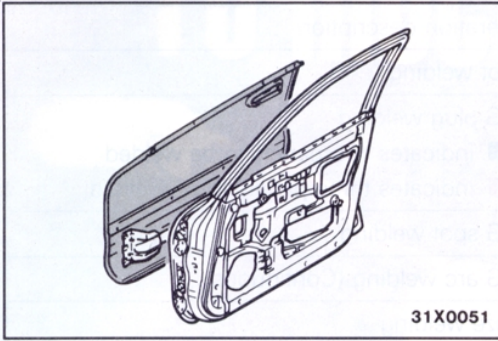
Symbol	Operation description
•••••	Spot welding
■ ■ ■ ■ ■	MIG plug welding ■ indicates two panels to be welded ■ indicates three panels to be welded
+ + + + +	MIG spot welding
	MIG arc welding (Continuous)
○ ○ ○ ○ ○	Braze welding

REPAIR WELDS



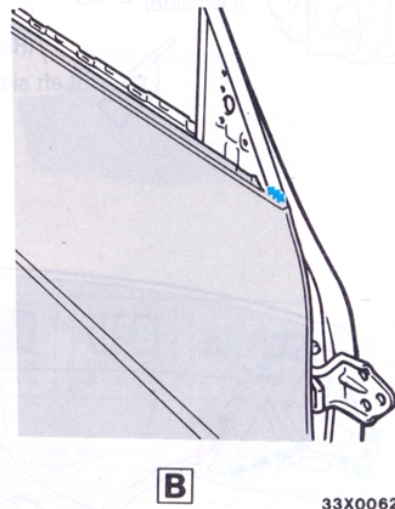
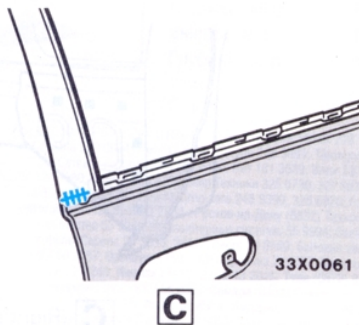
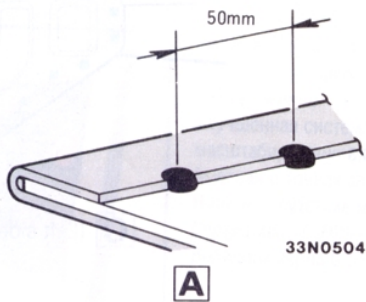
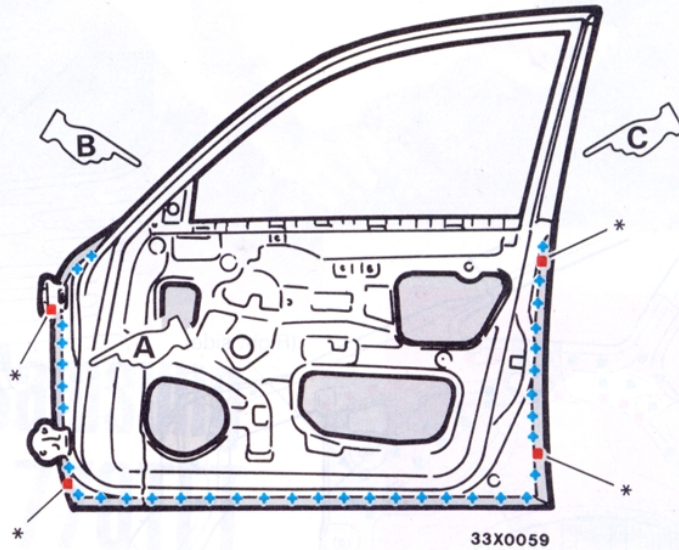
NOTE
 Refer to P.3-12 for the quarter outer weld points.

FRONT DOOR OUTER PANEL



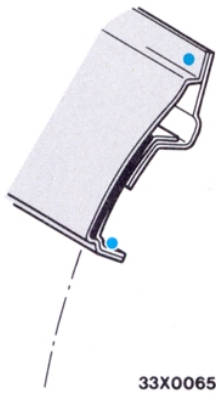
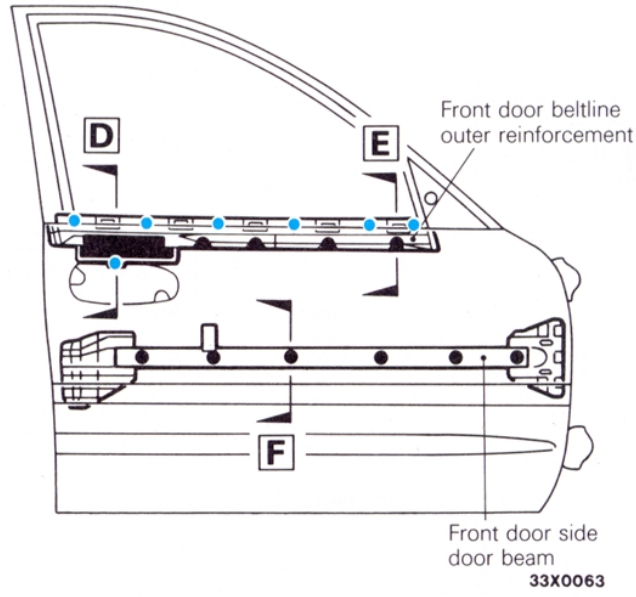
Symbol	Operation description
•••••	Spot welding
■ ■ ■ ■ ■	MIG plug welding ■ indicates two panels to be welded ■ indicates three panels to be welded
+ + + + +	MIG spot welding
	MIG arc welding (Continuous)
○ ○ ○ ○ ○	Braze welding

REPAIR WELDS

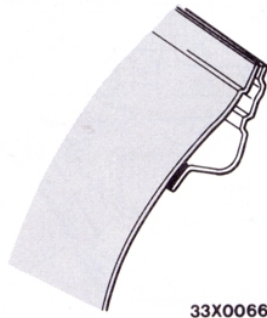


NOTES

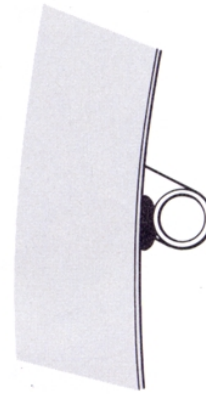
- (1) Weld point * indicates manufacturer's welding joint. (Unnecessary at repair work)
- (2) After hemming the door outer panel, MIG spot weld the flange overlap section at a pitch of approx. 50 mm.



D



E

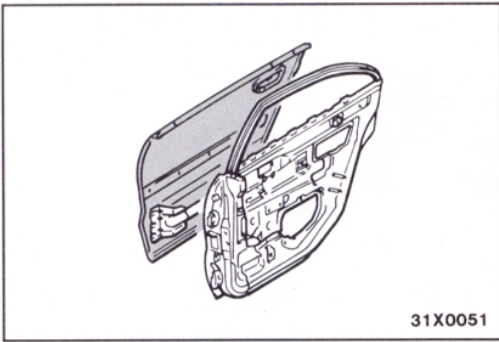


F

■ : Adhesive

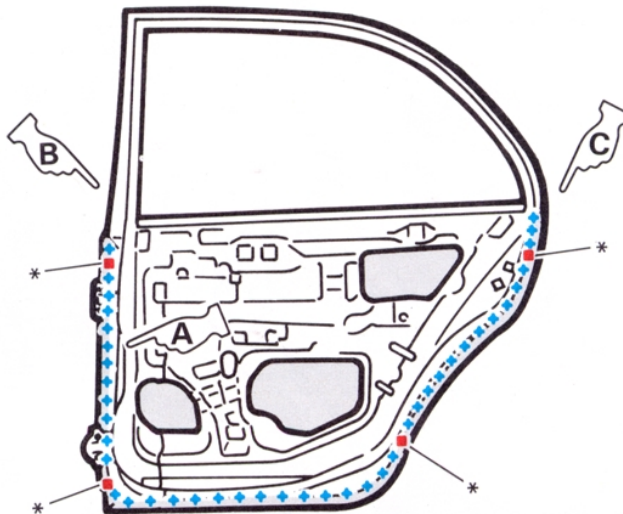
Adhesive	Type
	Chloroprene-base drying sealant

REAR DOOR OUTER PANEL

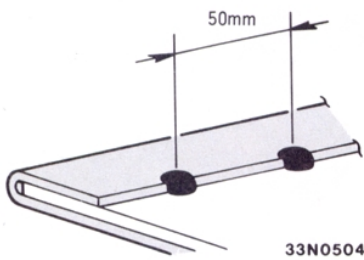


Symbol	Operation description
•••••	Spot welding
■ ■ ■ ■ ■	MIG plug welding ■ indicates two panels to be welded ■ indicates three panels to be welded
+ + + + +	MIG spot welding
	MIG arc welding (Continuous)
○ ○ ○ ○ ○	Braze welding

REPAIR WELDS

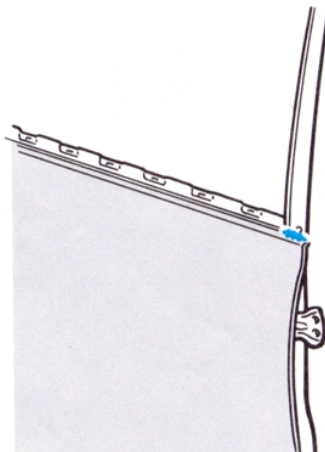


33X0070



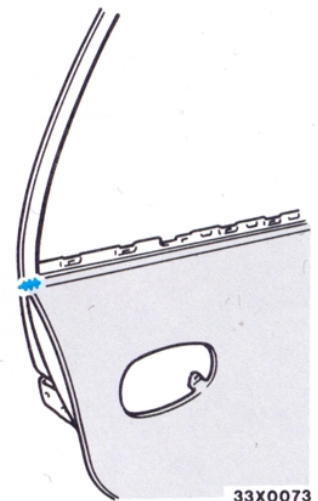
33N0504

A



33X0072

B

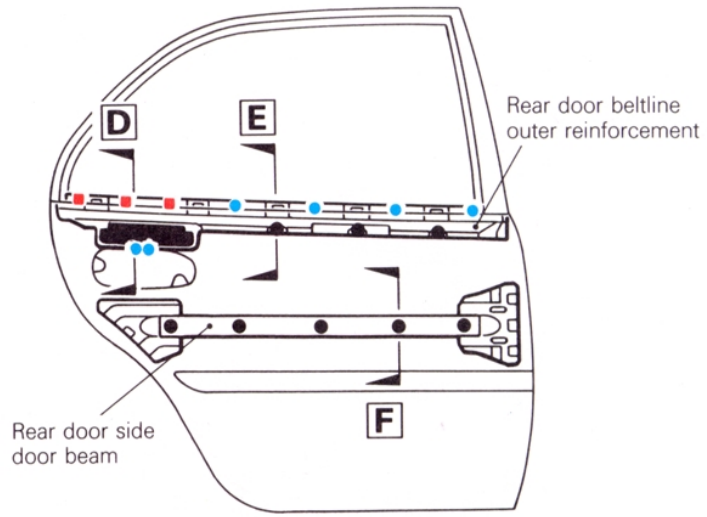


33X0073

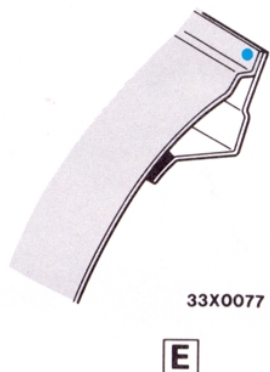
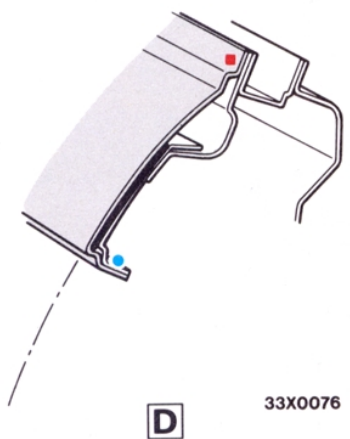
C

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.



33X0074



■ : Adhesive

Adhesive	Type
	Chloroprene-base drying sealant