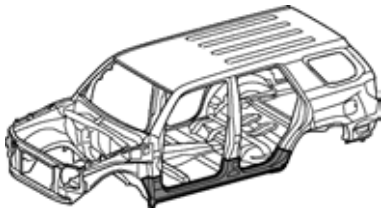
ROCKER OUTER PANEL (ASSY)


F42938A

Weld work for 980 MPa ultra high strength steel

1 Follow the welding conditions below when welding ultra high strength steel to assure sufficient weld strength. (When repairing this model)

*1: When welding 2 panels together including 980 MPa ultra high strength steel.

Spot weld	Pressure	2940 N (300 kgf, 661 lbf)
	Weld current	10000 A
	Weld time	18 Cyc. (0.30 Sec.)
Plug weld	Plug diameter	10 mm (0.39 in.)
	Wire type	AWS A5.18 ER70S-3
	Shield gas	Metal active gas

*2: When welding more than 3 panels together including 980 MPa ultra high strength steel. (When plug welding a panel to the welded panels with the weld condition above.)

Plug weld	Plug diameter	Same as the standard method (See the introduction)
	Wire type	AWS A5.18 ER70S-3
	Shield gas	Metal active gas

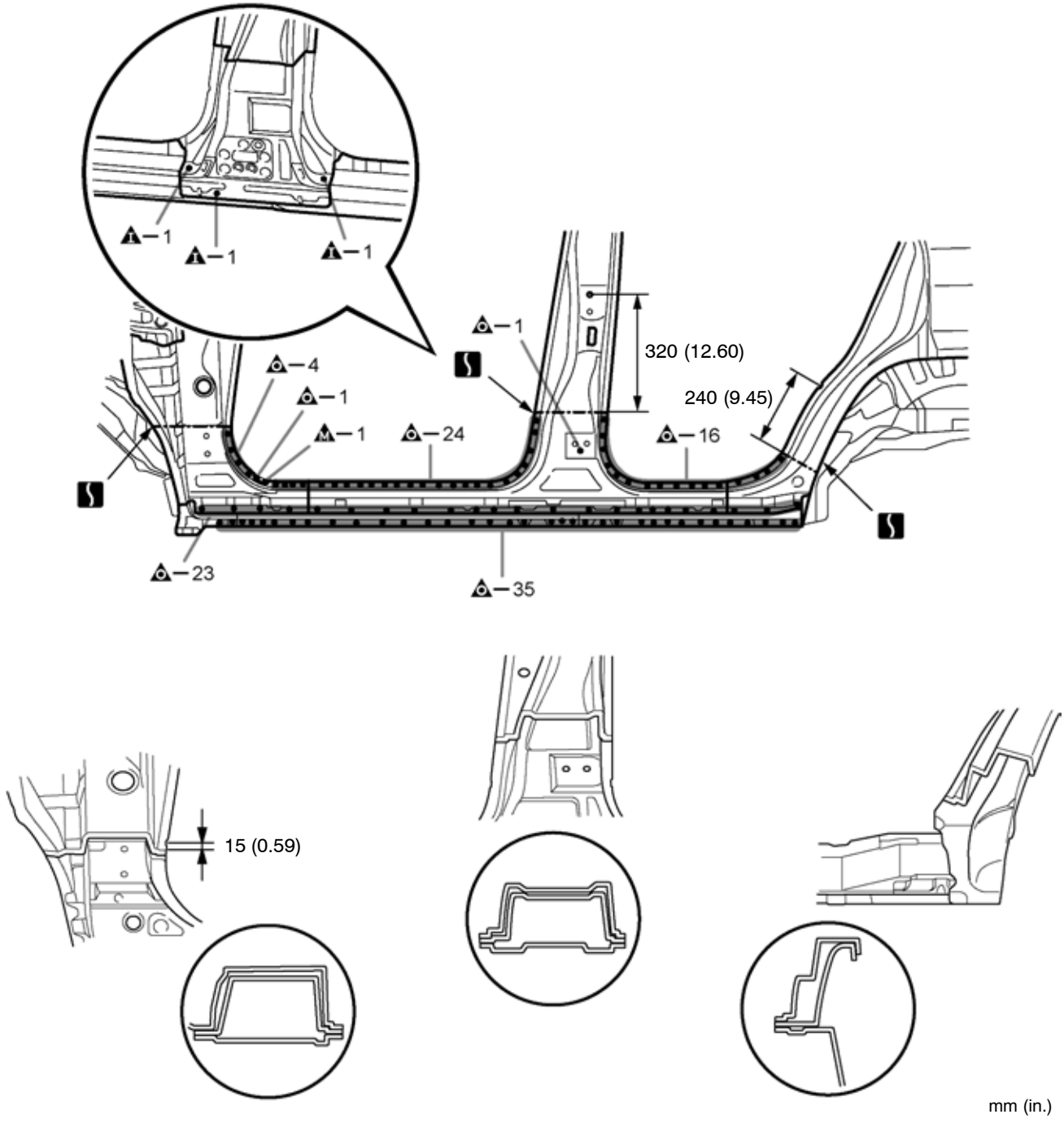
HINT:
Be sure to use Metal active gas (Ar 80% + CO_2 20%) as the shield gas when plug welding.
Sufficient weld strength cannot be assured when using 100% CO_2 shield gas.

Symbol meaning

: Remove Weld Points : Cut with Disc Sander etc. : Cut and Join Location

F42938B

REMOVAL



F42938

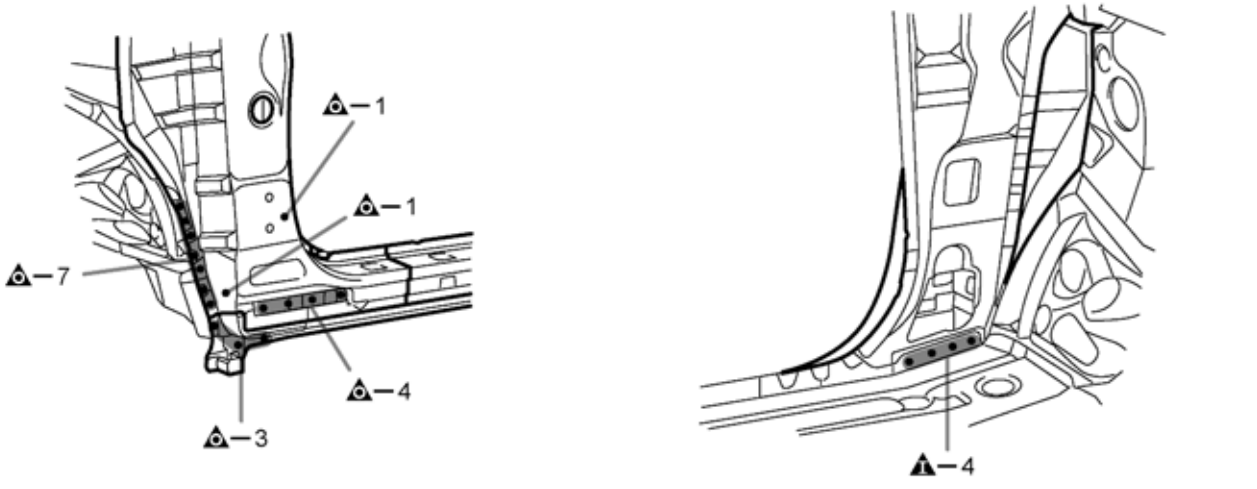
REMOVAL POINT

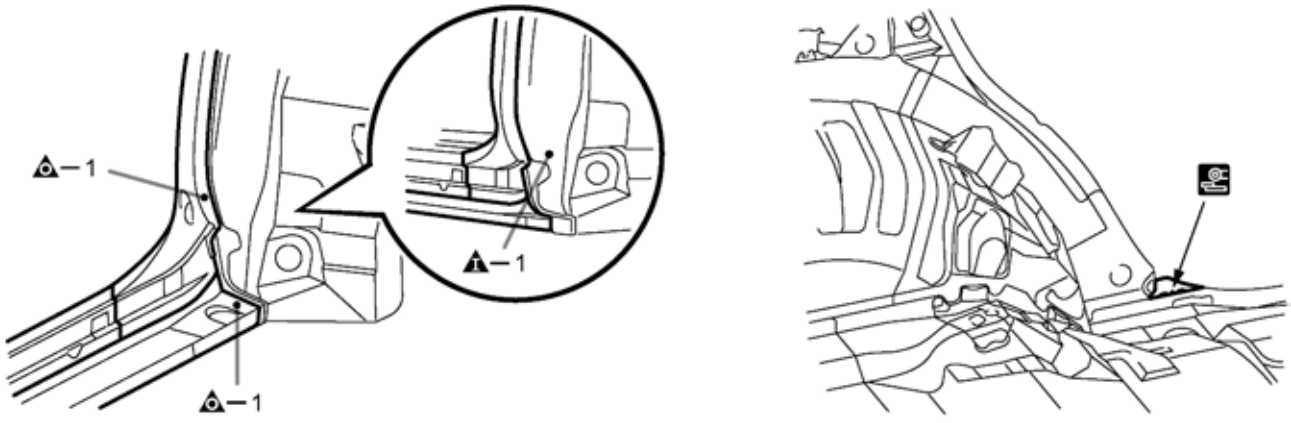
1 Do not butt weld or heat repair because the heat decreases the strength of areas where ultra high strength steel is used. (See the introduction)

Symbol meaning

: Remove Weld Points : Cut with Disc Sander etc. : Cut and Join Location

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F42939

REMOVAL POINT

1 Do not butt weld or heat repair because the heat decreases the strength of areas where ultra high strength steel is used. (See the introduction)

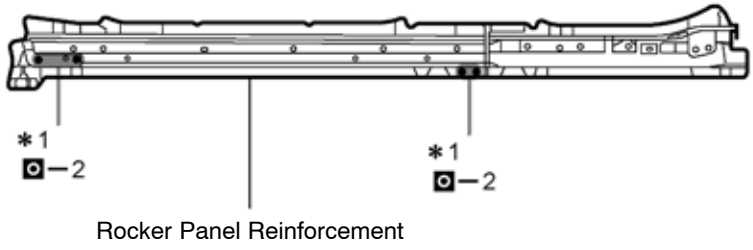
Symbol meaning

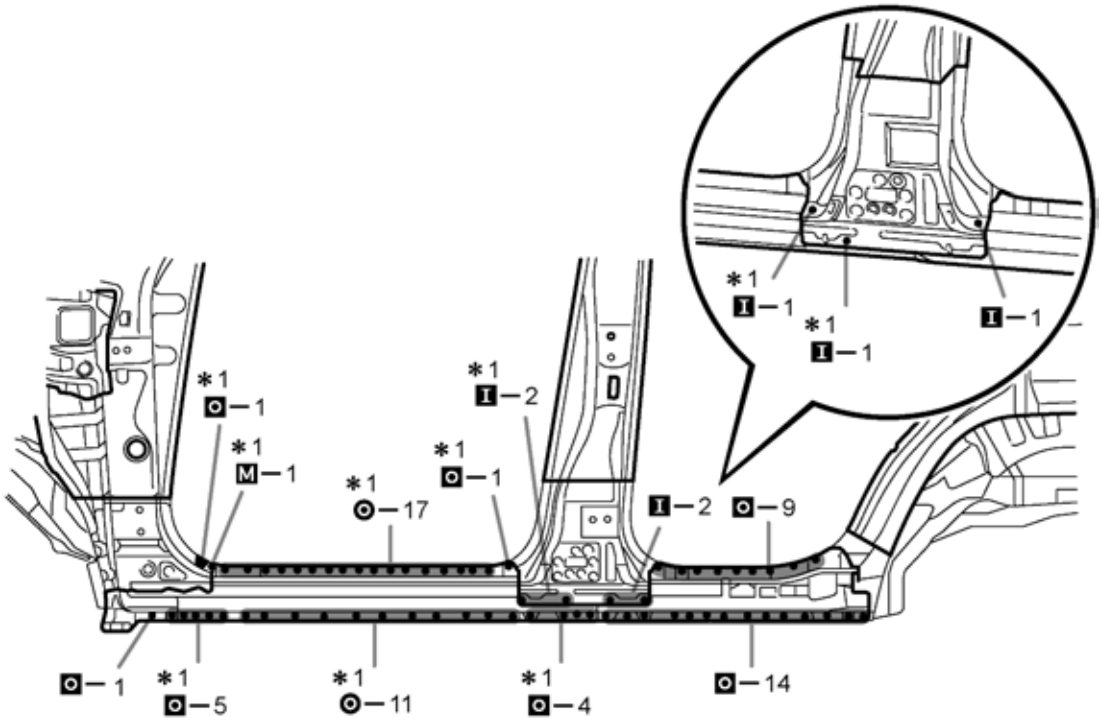
: Spot Weld : Plug Weld : Fillet Weld

: Butt Weld : Body Sealer

F42940B

INSTALLATION





F42940

INSTALLATION POINT

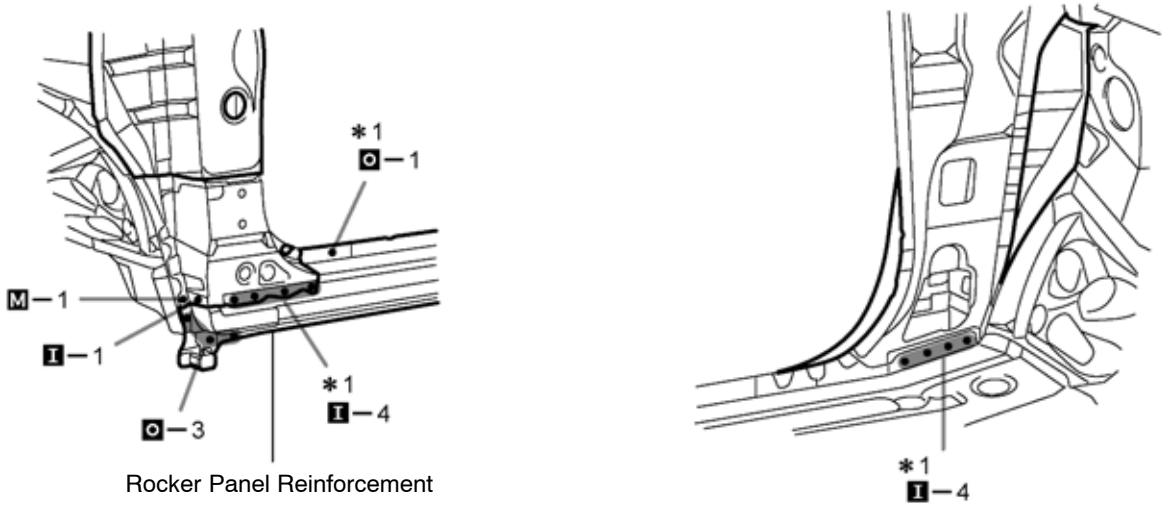
1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
3 Follow the welding conditions when welding point *1 to assure sufficient weld strength. (See the introduction)
4 After welding the rocker panel reinforcement to the vehicle side, install the front body upper outer pillar, center body outer pillar and quarter panel.

Symbol meaning

: Spot Weld : Plug Weld : Fillet Weld

: Butt Weld : Body Sealer

F42940B

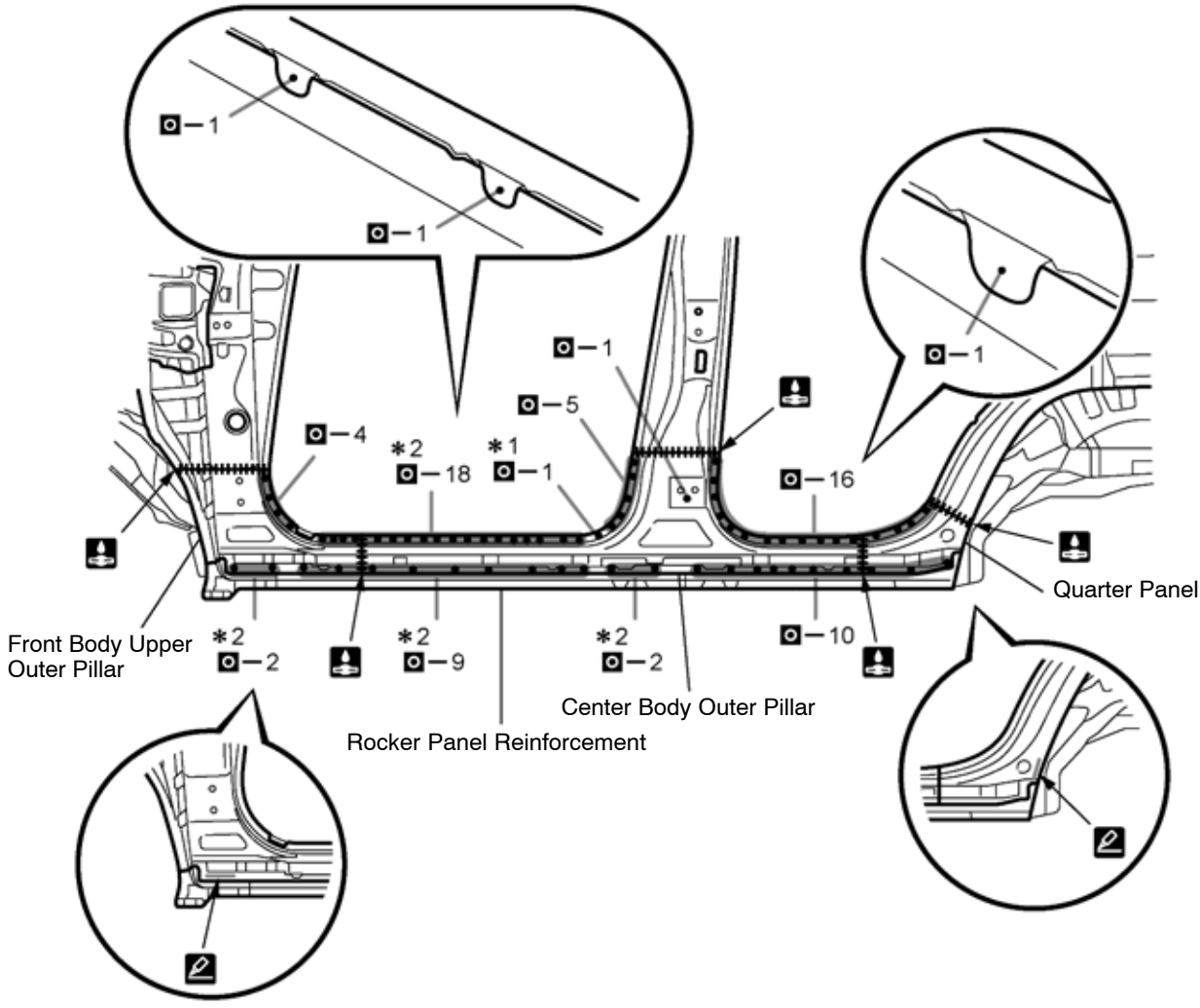


mm (in.)

F42941

INSTALLATION POINT

1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
3 Follow the welding conditions when welding point *1 to assure sufficient weld strength. (See the introduction)
4 After welding the rocker panel reinforcement to the vehicle side, install the front body upper outer pillar, center body outer pillar and quarter panel.



INSTALLATION POINT

1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.

2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)

3 Follow the welding conditions when welding point *2 to assure sufficient weld strength. (See the introduction)

4 After welding the rocker panel reinforcement to the vehicle side, install the front body upper outer pillar, center body outer pillar and quarter panel.

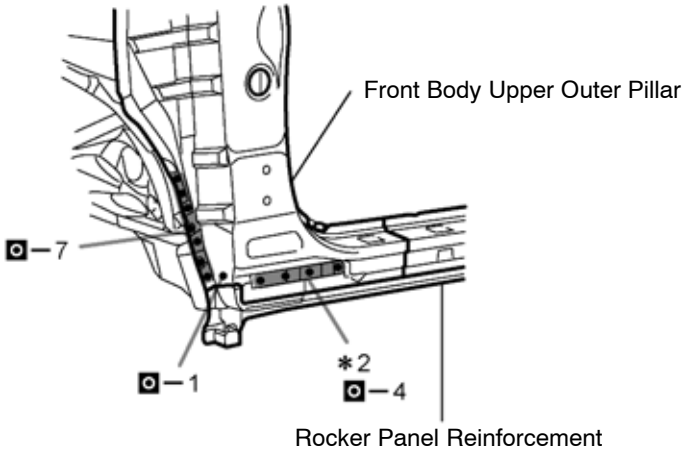
5 Before installing a new part, apply body sealer.
HINT:
Apply body sealer in an even, continuous bead.

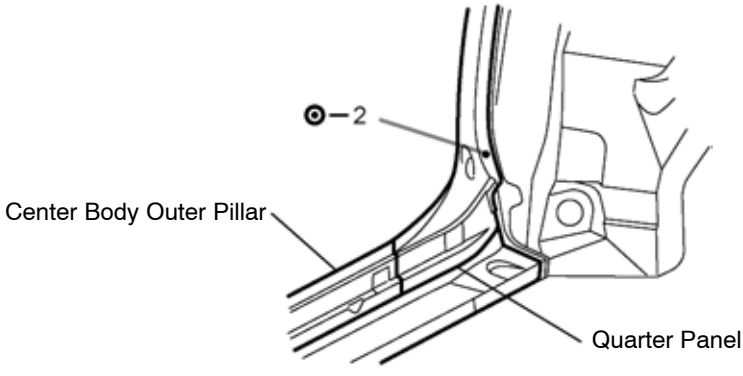
Symbol meaning

: Spot Weld : Plug Weld : Fillet Weld

: Butt Weld : Body Sealer

F42940B





F42943

INSTALLATION POINT

1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
3 Follow the welding conditions when welding point *2 to assure sufficient weld strength. (See the introduction)
4 After welding the rocker panel reinforcement to the vehicle side, install the front body upper outer pillar, center body outer pillar and quarter panel.
5 After welding, apply the foamed sealing material to the corresponding parts. (See the paint·coating)
6 After welding, apply body sealer to the corresponding parts. (See the paint·coating)
7 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.