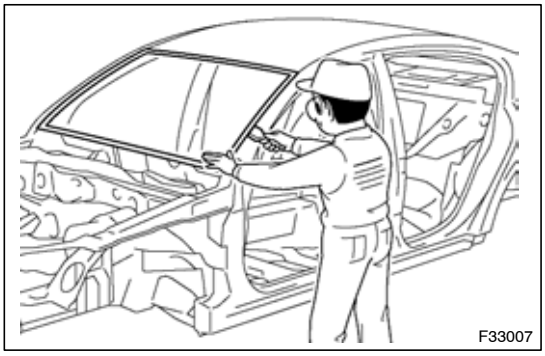
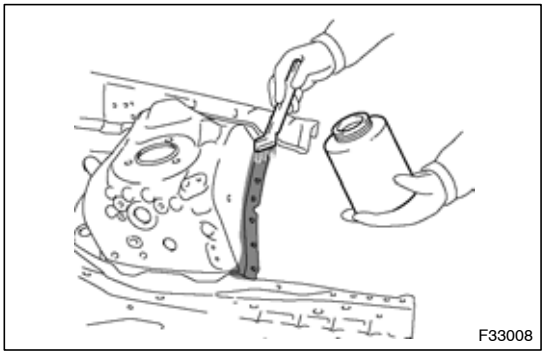
4. PRECAUTIONS FOR CORRECT REPAIRs



(a) REMOVAL OF ADJACENT COMPONENTS

(1) When removing adjacent components, apply protective tape to the surrounding body and your tools to prevent damage.

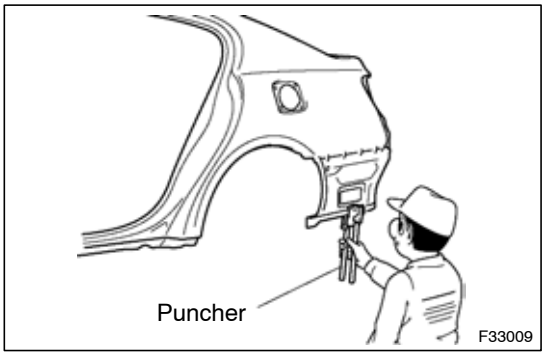
NOTICE:
If the paint film is damaged, make sure to re-finish the paint.



(b) ANTI-RUST TREATMENT BEFORE WELDING

(1) Apply welding primer to the contact surfaces of the welding areas to protect them from rust.

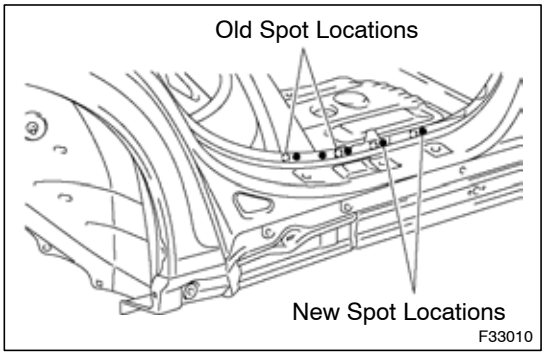
NOTICE:
Do not apply welding primer outside of the contact surfaces.



(c) MAKING HOLES FOR PLUG WELDING

(1) For areas where a spot welder cannot be used, use a puncher or drill to make holes for plug welding.

Thickness of welded portion	Diameter of plug hole
Under 10 mm (0.39 in.)	Over 5 mm (0.20 in.)
1.0 to 1.6 mm (0.04 to 0.06 in.)	Over 6.5 mm (0.26 in.)
1.7 to 2.3 mm (0.07 to 0.09 in.)	Over 8 mm (0.31 in.)
Over 2.4 mm (0.09 in.)	Over 10 mm (0.39 in.)



(d) WELDING PRECAUTIONS

(1) The number of welding spots should be as follows.
Spot weld: 1.3 X No. of manufacturer's spots
Plug weld: More than No. of manufacturer's plugs

(2) Spot weld locations
Avoid welding over previously welded areas.