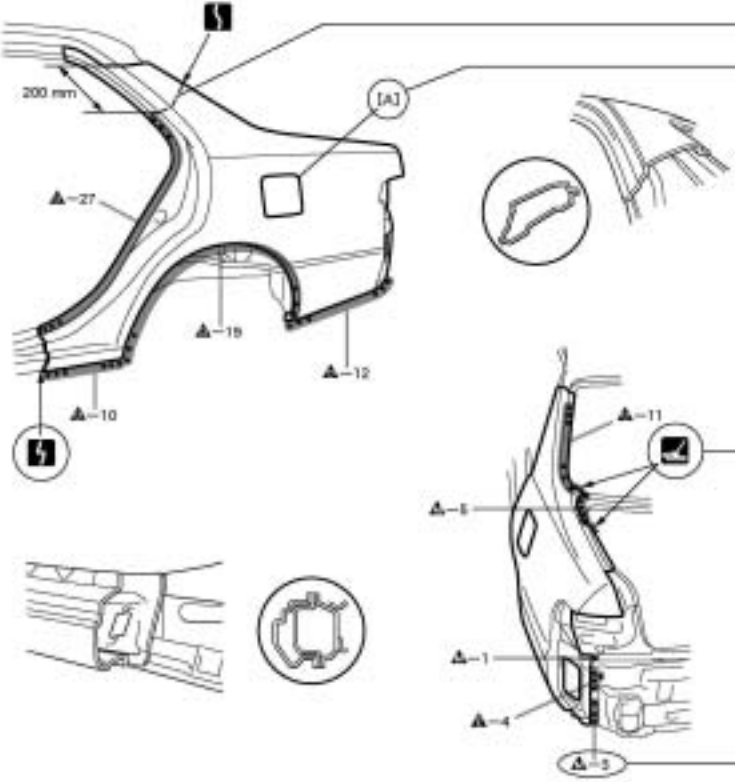


HOW TO USE THIS MANUAL

1. BODY PANEL REPLACEMENT THIS MANUAL

BP-34		BODY PANEL REPLACEMENT	
(A)	QUARTER PANEL (CUT) REPLACEMENT		(C)
(B)	REMOVAL		
(D)		(I)	(K)
(E)	POINT 1. Remove the [A] at the same time. PART NAME [A] Fuel filler opening lid 200 mm (7.87 in.)	(J)	

(A) : REPLACEMENT PART AND METHOD
QUARTER PANEL (CUT)

Replacement method
 (ASSY)...Assembly replacement
 (CUT)...Major cutting (less than 1/2 of part used)
 (CUT-H)...Half cutting (about 1/2 of part used)
 (CUT-P)...Partial cutting (most of part used)

Replacement part

(B) : REMOVAL CONDITIONS

(C) : PART LOCATION

(D) : REMOVAL DIAGRAM
 Describes in detail removal of the damaged part involving repair by cutting.

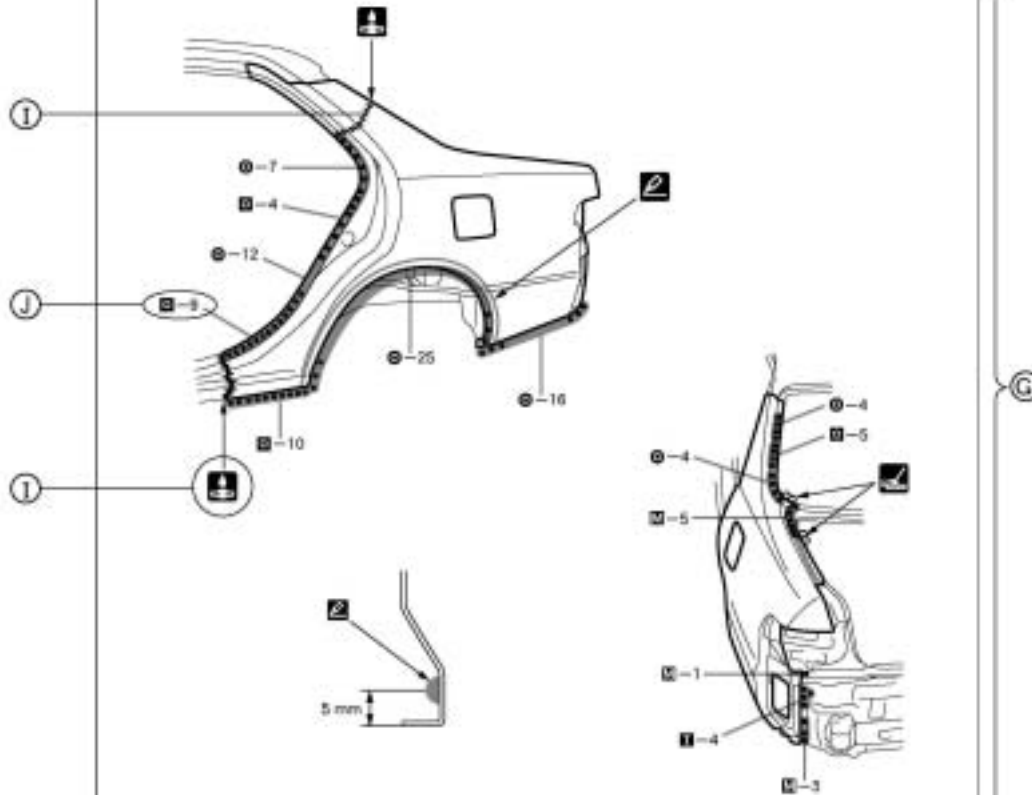
(E) : REMOVAL GUIDE
 Provides additional information to more efficiently help you perform the removal.

BODY PANEL REPLACEMENT

BP-35

INSTALLATION

- 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)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



POINT

1. Before temporarily installing the new parts, apply body sealer to the wheel arch.

HINT

- 1) Apply body sealer about 5 mm (0.20 in.) front the flange, avoiding any oozing.
- 2) Apply sealer evenly, about 3 – 4 mm (0.12 – 0.16 in.) in diameter.
- 3) For other sealing points, refer to section PC.

(F) : INSTALLATION CONDITIONS

(G) : INSTALLATION DIAGRAM

Describes in detail installation to the new parts involving repair by welding and/or cutting, but excluding painting.

(H) : INSTALLATION GUIDE

Provides additional information to more efficiently help you perform the installation.

(I) : SYMBOLS

(See page IN-7)

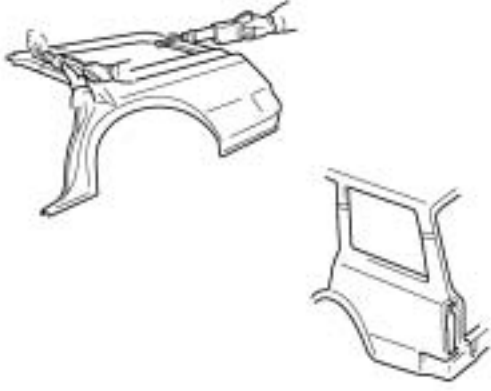
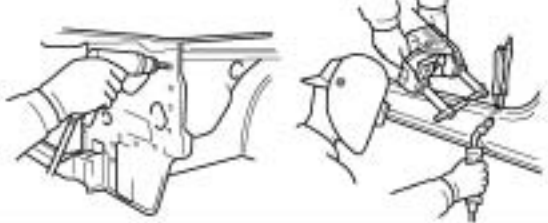
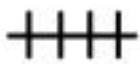
(J) : INSTALLATION OF WELD POINTS

Weld method and panel position symbols (See page IN-9)

(K) : PART NAME

2. SYMBOLS

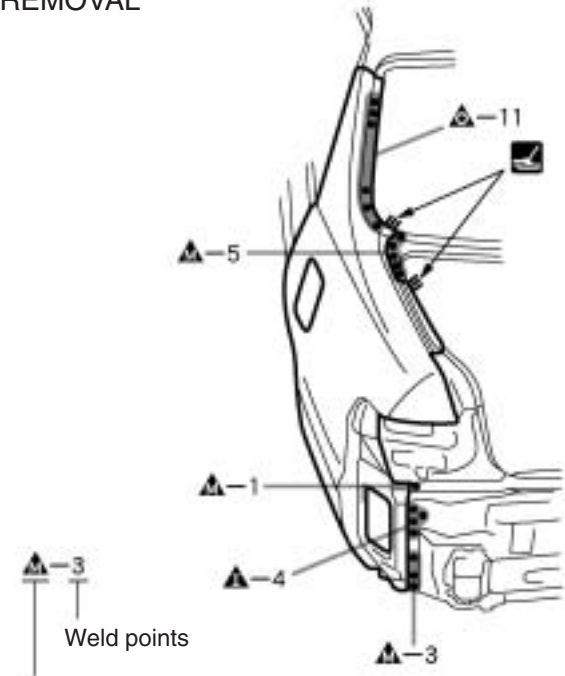
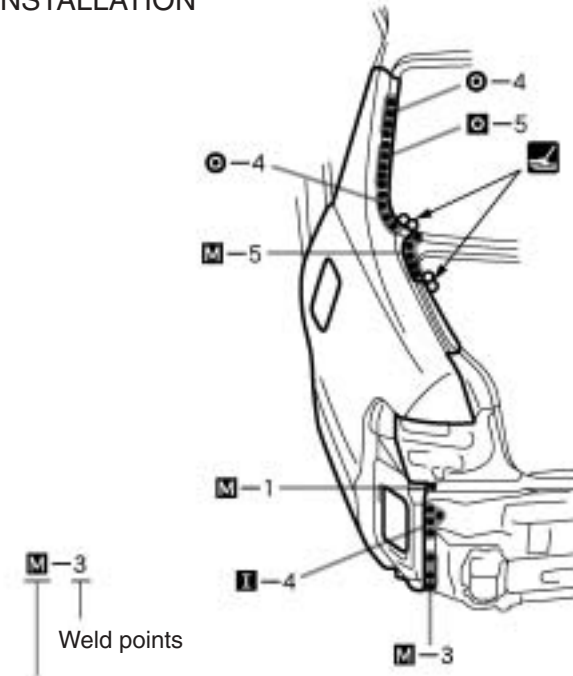
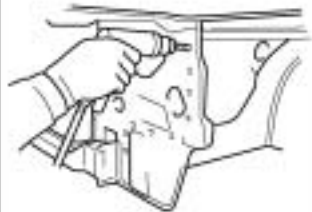
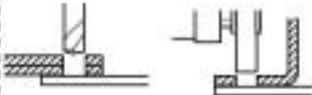
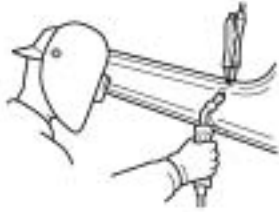
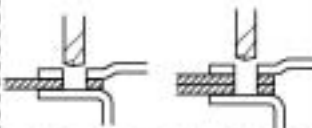
The following symbols are used in the welding diagrams in section BP of this manual to indicate cutting areas and the types of weld required.

SYMBOLS		MEANING	ILLUSTRATION
		CUT AND JOIN LOCATION (SAW CUT)	
		CUT AND JOIN LOCATION (Cut Location for Supply Parts)	
		CUT LOCATION	
		CUT WITH DISC SANDER, ETC.	
		BRAZE (Removal)	
		BRAZE (Installation)	
	—	WELD POINTS	
	—	SPOT WELD OR MIG PLUG WELD (See Page IN-9)	
		CONTINUOUS MIG WELD (BUTT WELD)	
		CONTINUOUS MIG WELD (TACK WELD)	
		BODY SEALER	

SYMBOLS		MEANING	ILLUSTRATION
—		Assembly Mark	—
	—	BODY SEALER (Flat Finishing)	
	—	BODY SEALER (No flat Finishing)	

3. ILLUSTRATION OF WELD POINT SYMBOLS

EXAMPLE:

REMOVAL			INSTALLATION		
 Weld points Remove weld point and panel position			 Weld points Weld method and panel position		
SYMBOLS	MEANING	ILLUSTRATION	SYMBOLS	MEANING	ILLUSTRATION
  	Remove Weld Points		  	Spot Weld	
	(Outside)		  	MIG Plug Weld	
	(Middle)				
	(Inside)				
<i>HINT: Panel position symbols are as seen from the working posture.</i>			+	Spot MIG Weld	