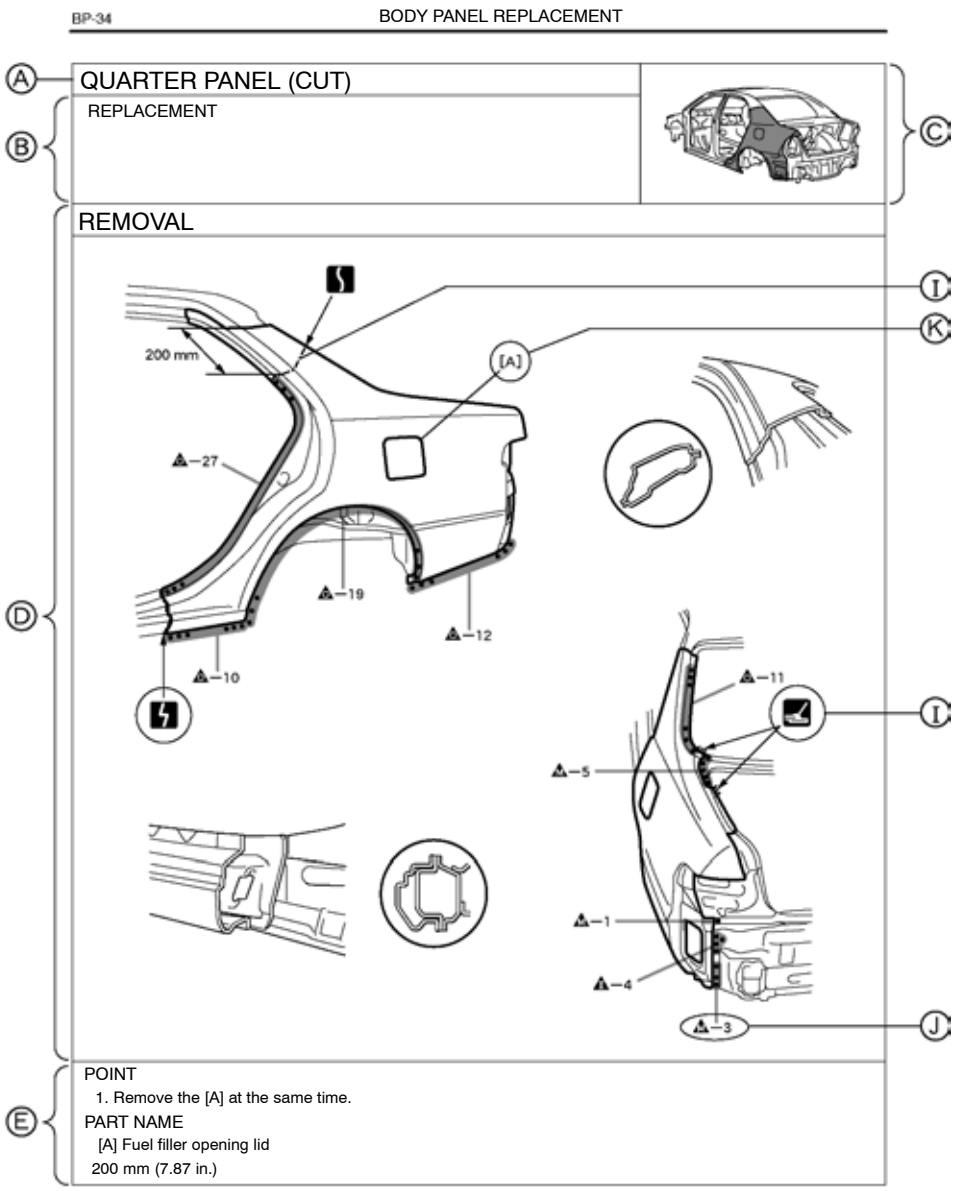
HOW TO USE THIS MANUAL

1. BODY PANEL REPLACEMENT THIS MANUAL



Ⓐ : 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

Ⓑ : REMOVAL CONDITIONS

Ⓒ : PART LOCATION

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

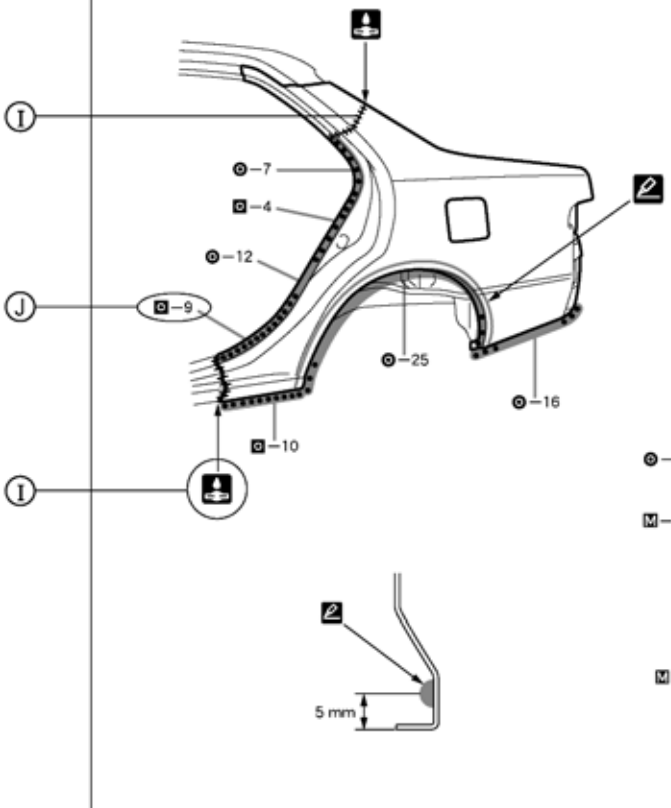
Ⓔ : REMOVAL GUIDE
Provides additional information to more efficiently help you perform the removal.

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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.

(F)



(G)

POINT
1. Before temporarily installing the new parts, apply 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.

(H)

(F) : INSTALLATION CONDITIONS

(G) : INSTALLATION DIAGRAM
Describes in detail installation of 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)

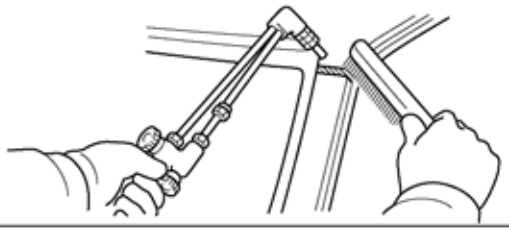
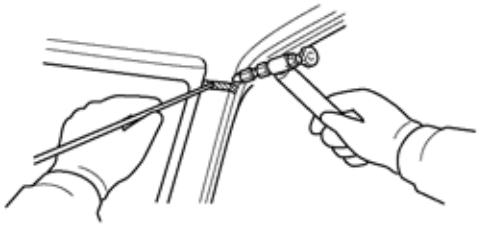
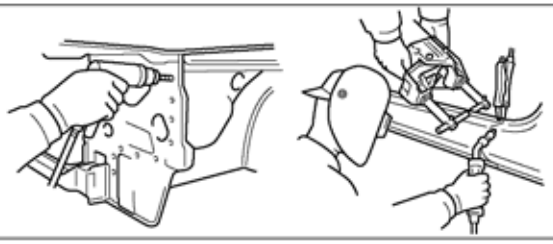
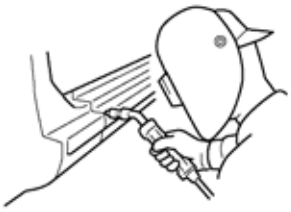
(J) : INSTALLATION OF WELD POINTS
Weld method and panel position symbols (See page IN-9)

(K) : PART NAME

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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	 F13893A

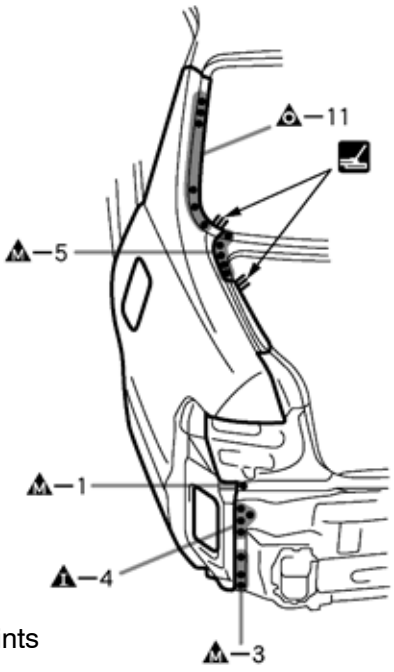
SYMBOLS		MEANING	ILLUSTRATION
—		Assembly Mark	—
	—	BODY SEALER (Flat Finishing)	
	—	BODY SEALER (No flat Finishing)	

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3. ILLUSTRATION OF WELD POINT SYMBOLS

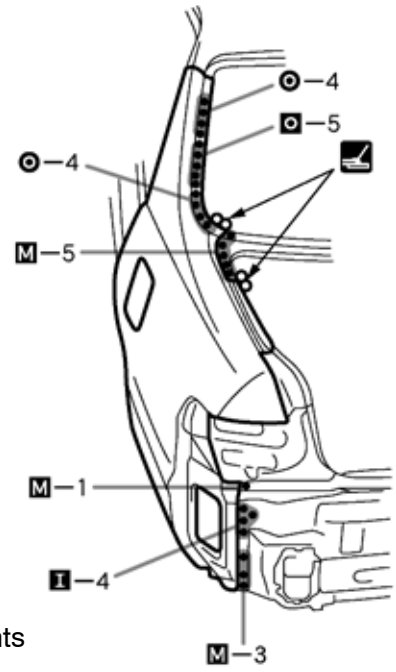
EXAMPLE:

REMOVAL

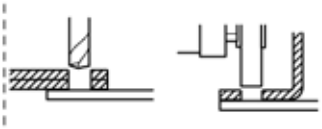
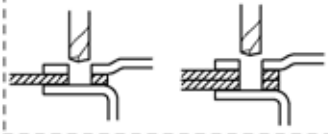


Remove weld point and panel position

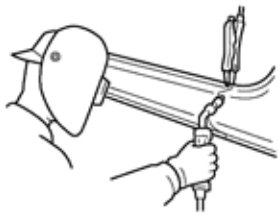
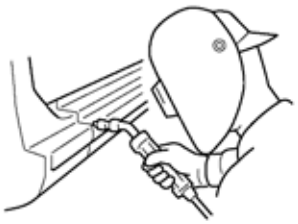
INSTALLATION



Weld method and panel position

SYMBOLS	MEANING	ILLUSTRATION
O M I	Remove Weld Points	
O	(Outside)	
M	(Middle)	
I	(Inside)	

HINT: Panel position symbols are as seen from the working posture.

SYMBOLS	MEANING	ILLUSTRATION
O M I	Spot Weld	
O M I	MIG Plug Weld	
+	Spot MIG Weld	

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