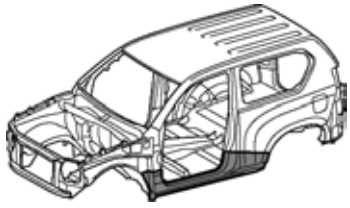
ROCKER OUTER PANEL (ASSY):

3 Door



F43255A

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

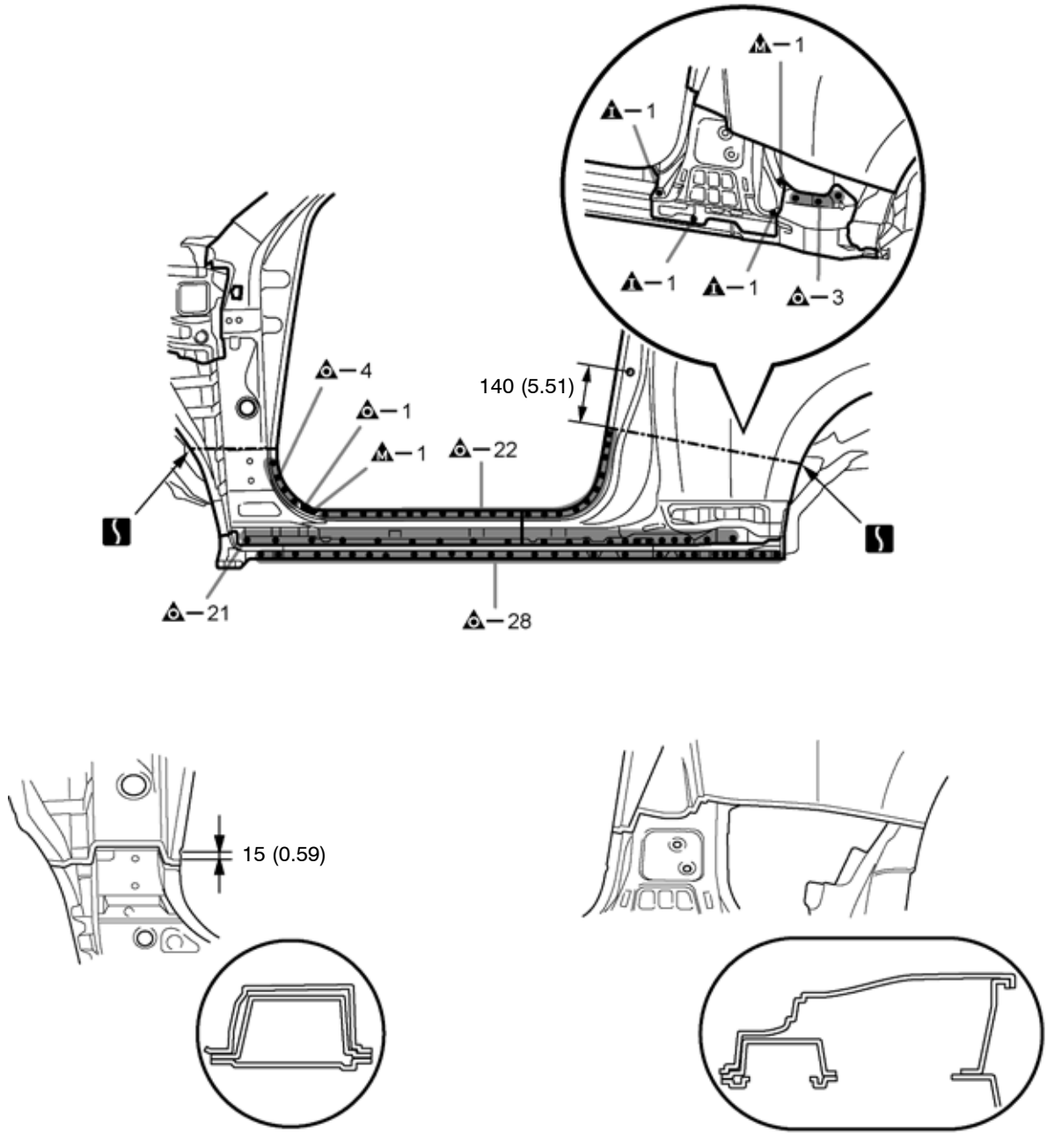
HINT:
Be sure to use Metal active gas (Ar 80% + CO_2 20%) as the shield gas when plug welding.
Sufficient weld strength cannot be assured when using 100% CO_2 shield gas.

Symbol meaning

: Remove Weld Points : Cut and Join Location

F43255B

REMOVAL



mm (in.)

F43255

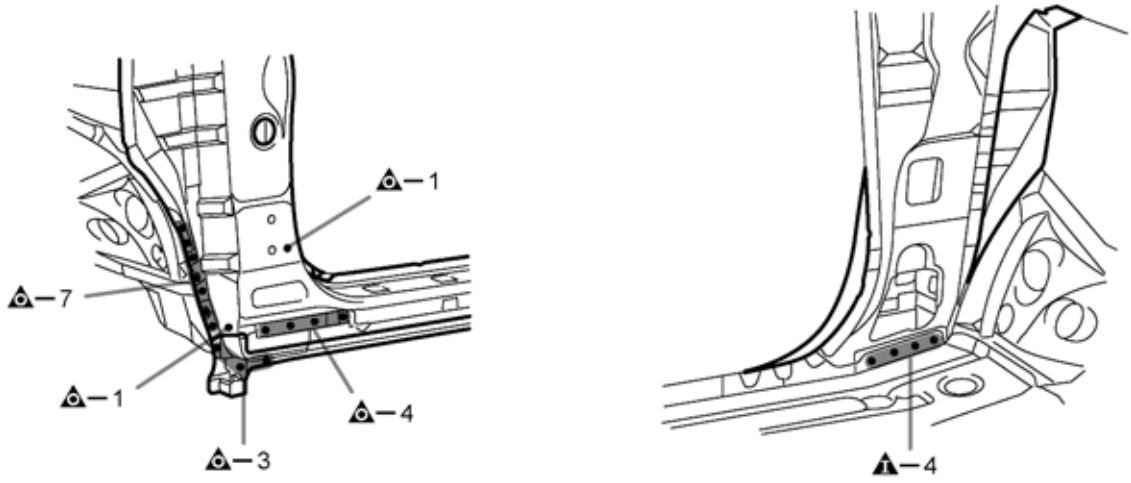
REMOVAL POINT

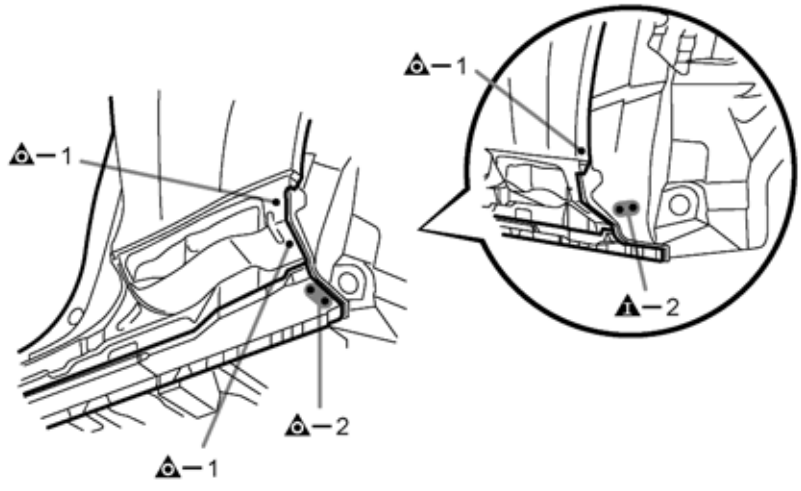
1 Do not butt weld or heat repair because the heat decreases the strength of areas where ultra high strength steel is used. (See the introduction)

Symbol meaning

: Remove Weld Points : Cut and Join Location

F43255B





F43256

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)

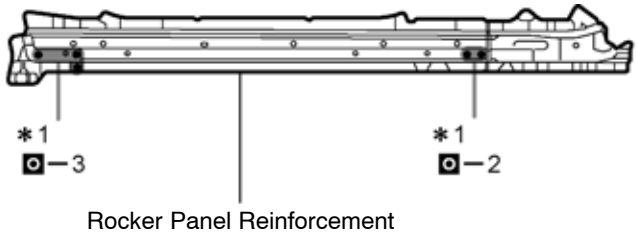
Symbol meaning

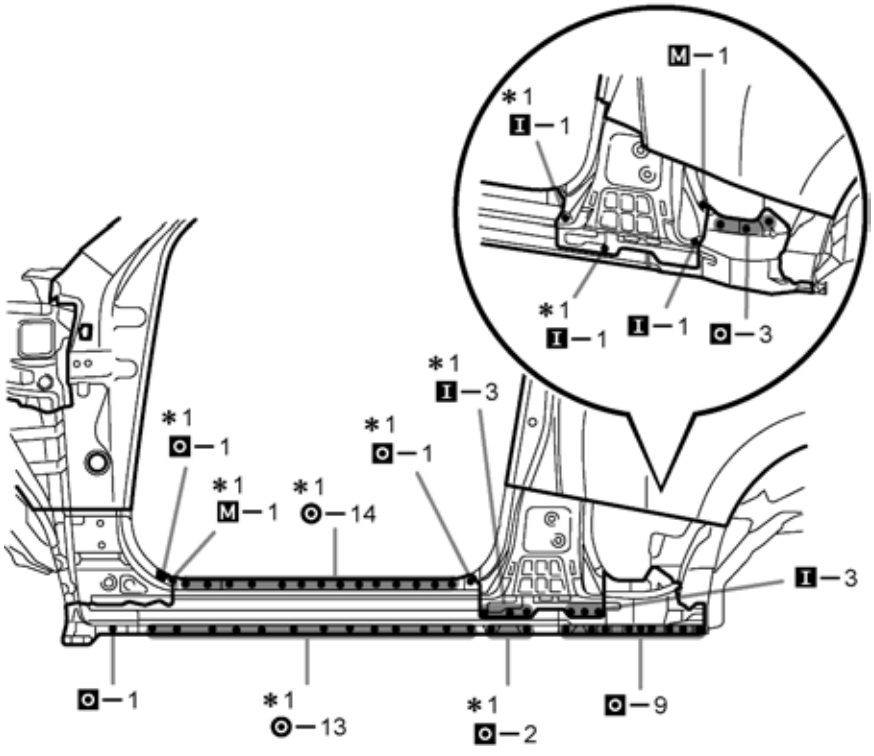
: Spot Weld : Plug Weld : Butt Weld

: Body Sealer

F43257B

INSTALLATION





F43257

INSTALLATION POINT

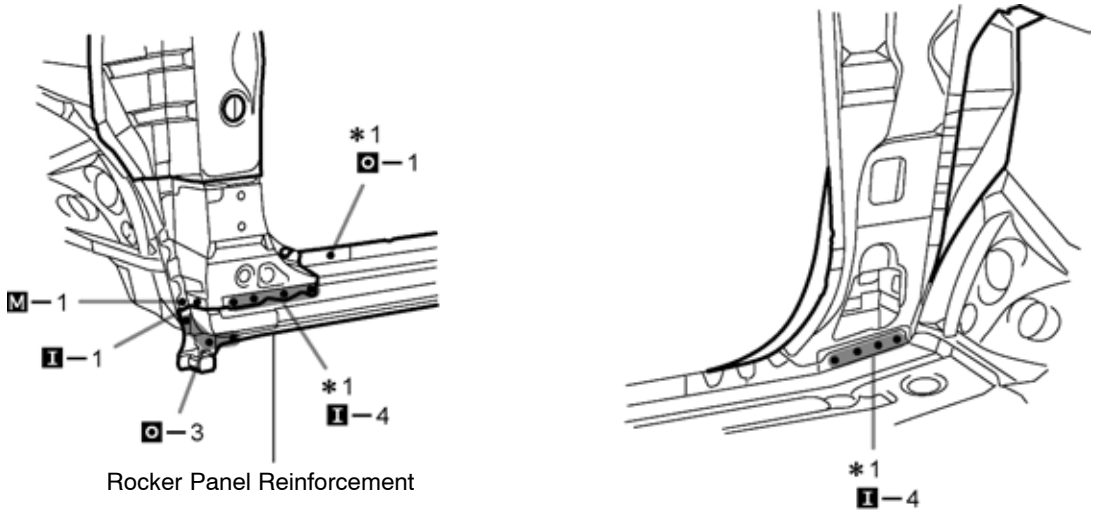
1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
3 Follow the welding conditions 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 and quarter panel.

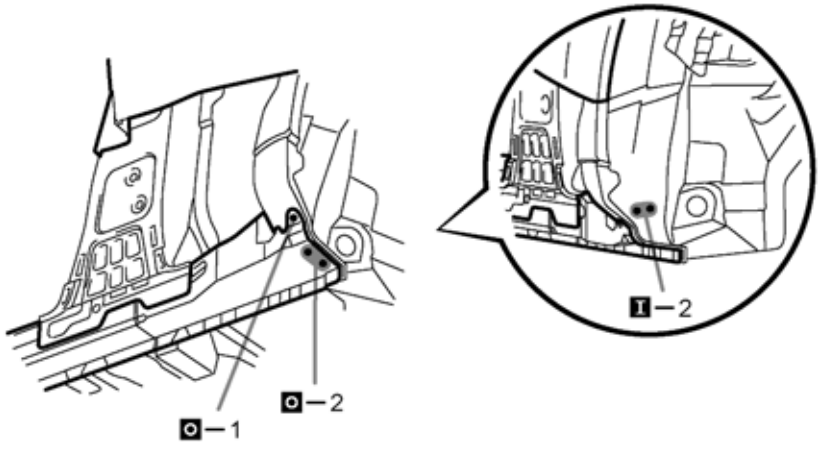
Symbol meaning

: Spot Weld : Plug Weld : Butt Weld

: Body Sealer

F43257B

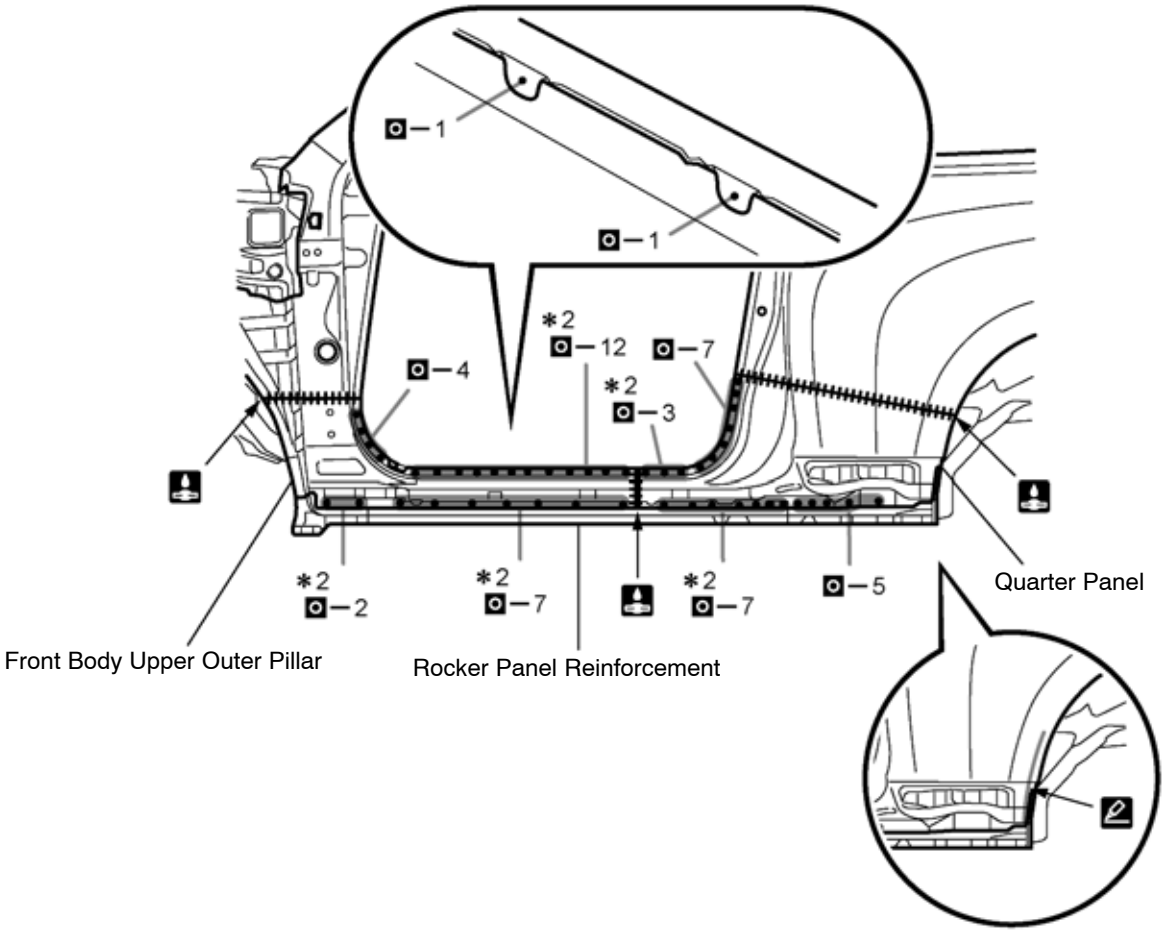




F43258

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 and quarter panel.



INSTALLATION POINT

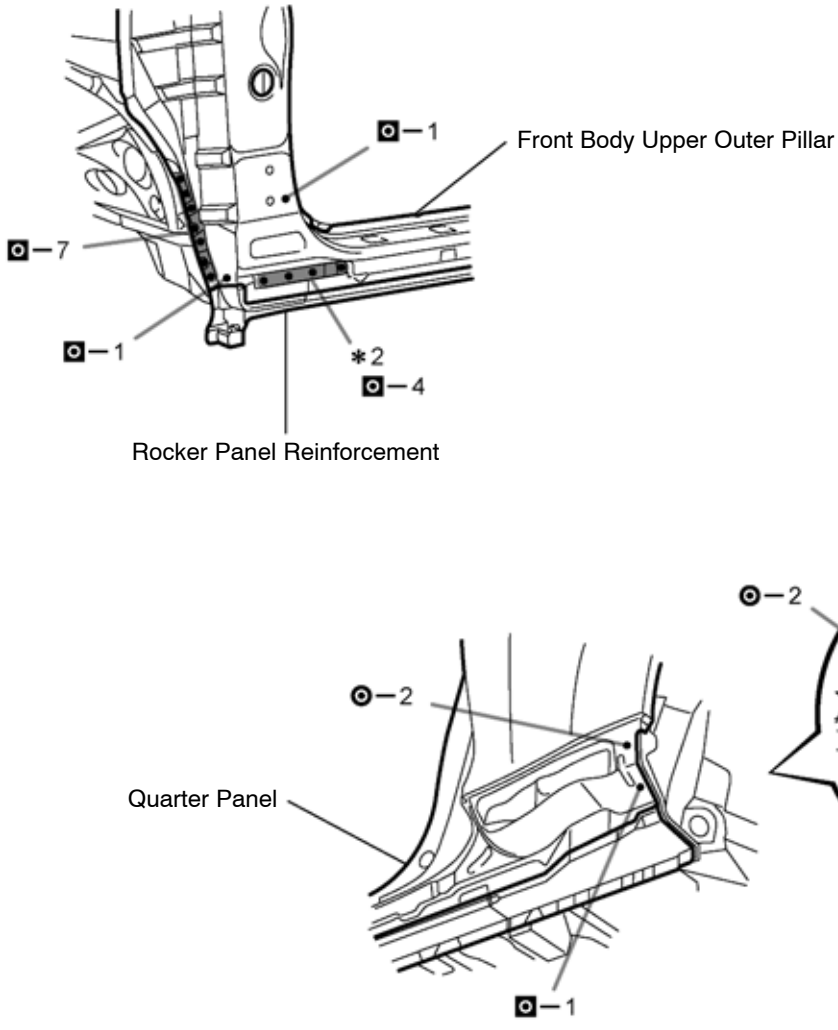
1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
3 Follow the welding conditions 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 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 : Butt Weld

: Body Sealer

F43257B



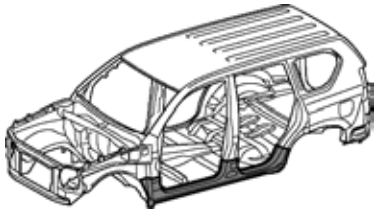
F43260

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 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.

ROCKER OUTER PANEL (ASSY):

5 Door


F43261A

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

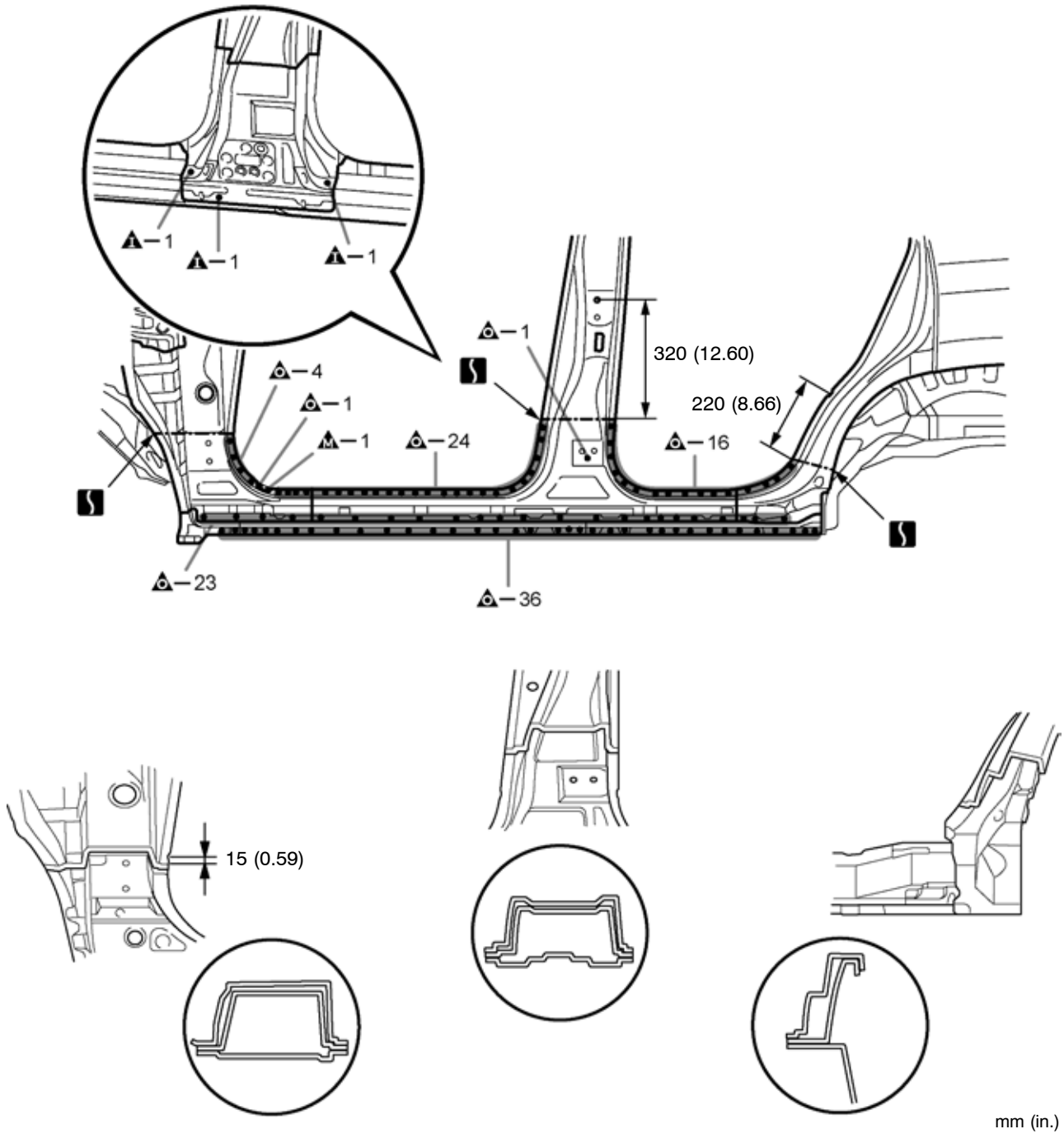
HINT:
Be sure to use Metal active gas (Ar 80% + CO_2 20%) as the shield gas when plug welding.
Sufficient weld strength cannot be assured when using 100% CO_2 shield gas.

Symbol meaning

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

F43261B

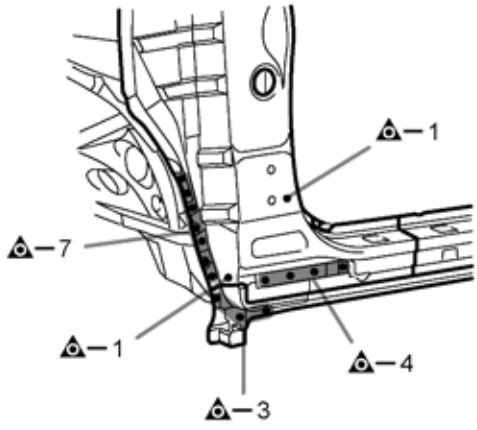
REMOVAL

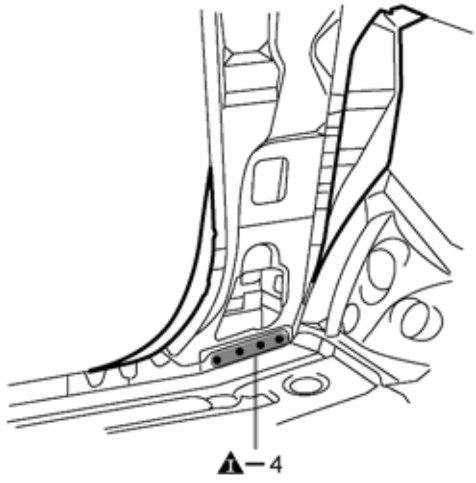


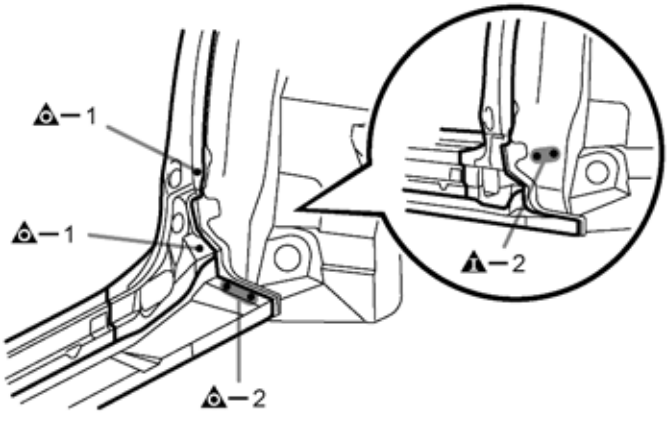
F43261

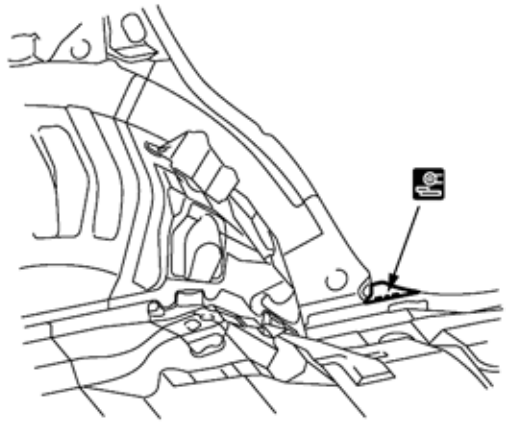
REMOVAL POINT

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)









F43262

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)

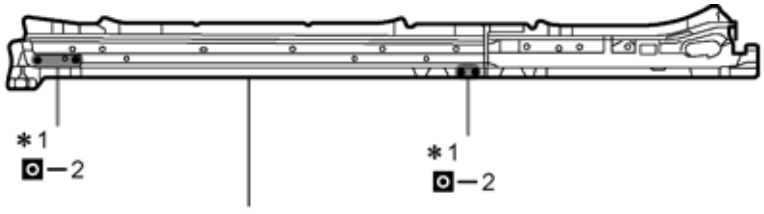
Symbol meaning

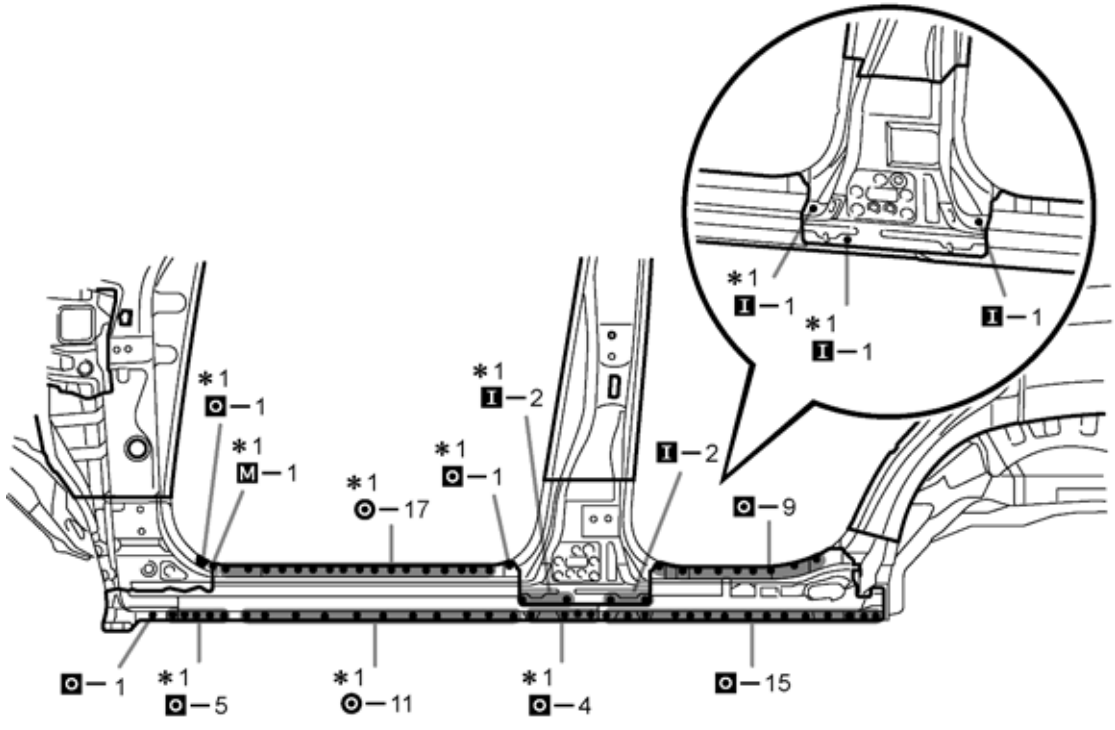
: Spot Weld : Plug Weld : Fillet Weld

: Butt Weld : Body Sealer

F43263B

INSTALLATION





F43263

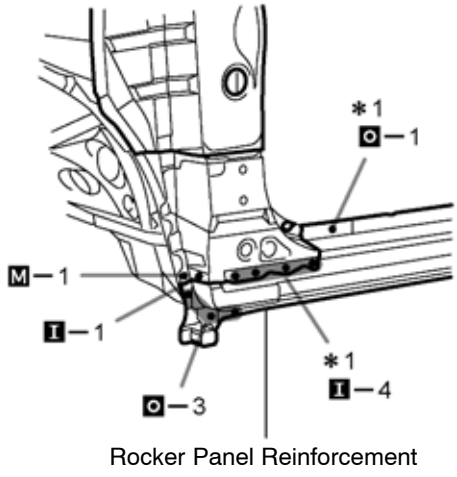
INSTALLATION POINT

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

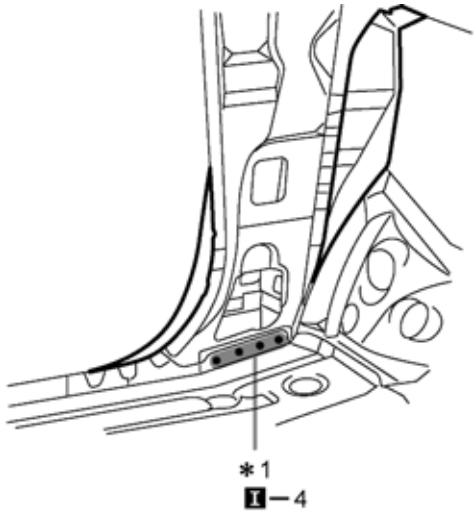
2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)

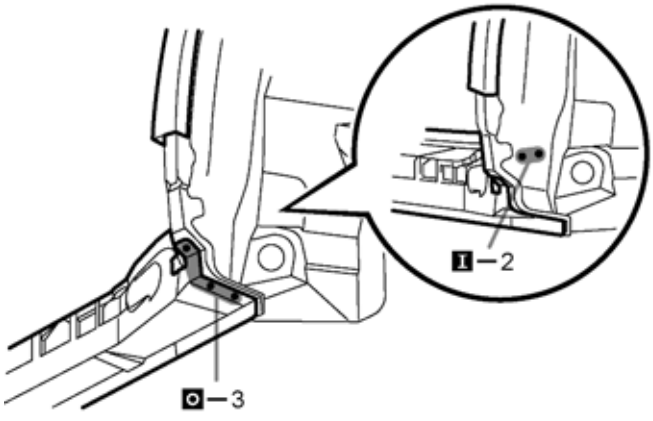
3 Follow the welding conditions when welding point *1 to assure sufficient weld strength. (See the introduction)

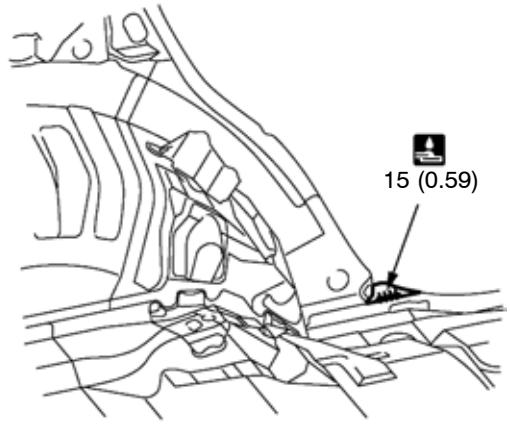
4 After welding the rocker panel reinforcement to the vehicle side, install the front body upper outer pillar, center body outer pillar and quarter panel.



Rocker Panel Reinforcement







mm (in.)

F43264

INSTALLATION POINT

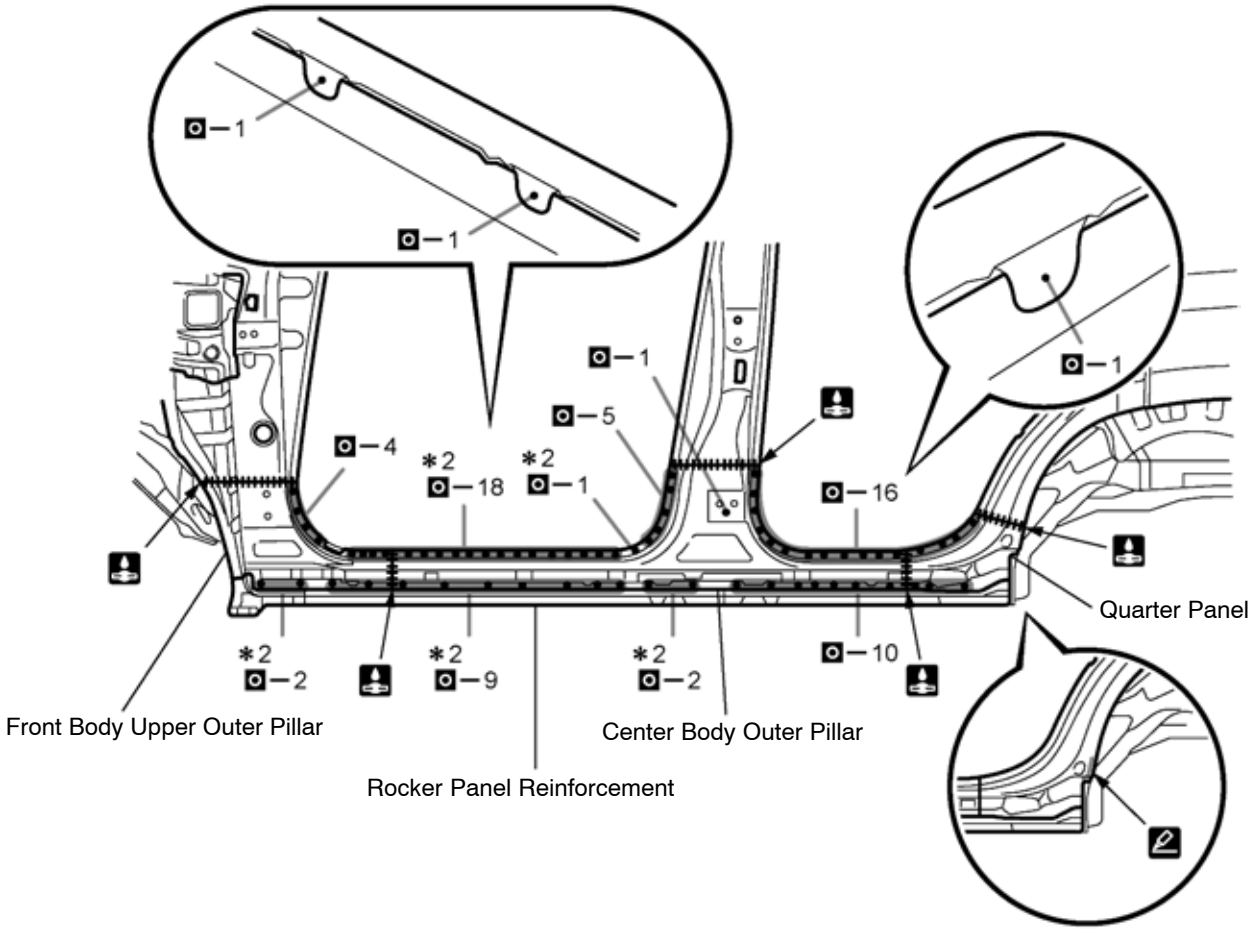
1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
3 Follow the welding conditions 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

F43263B



F43265

INSTALLATION POINT

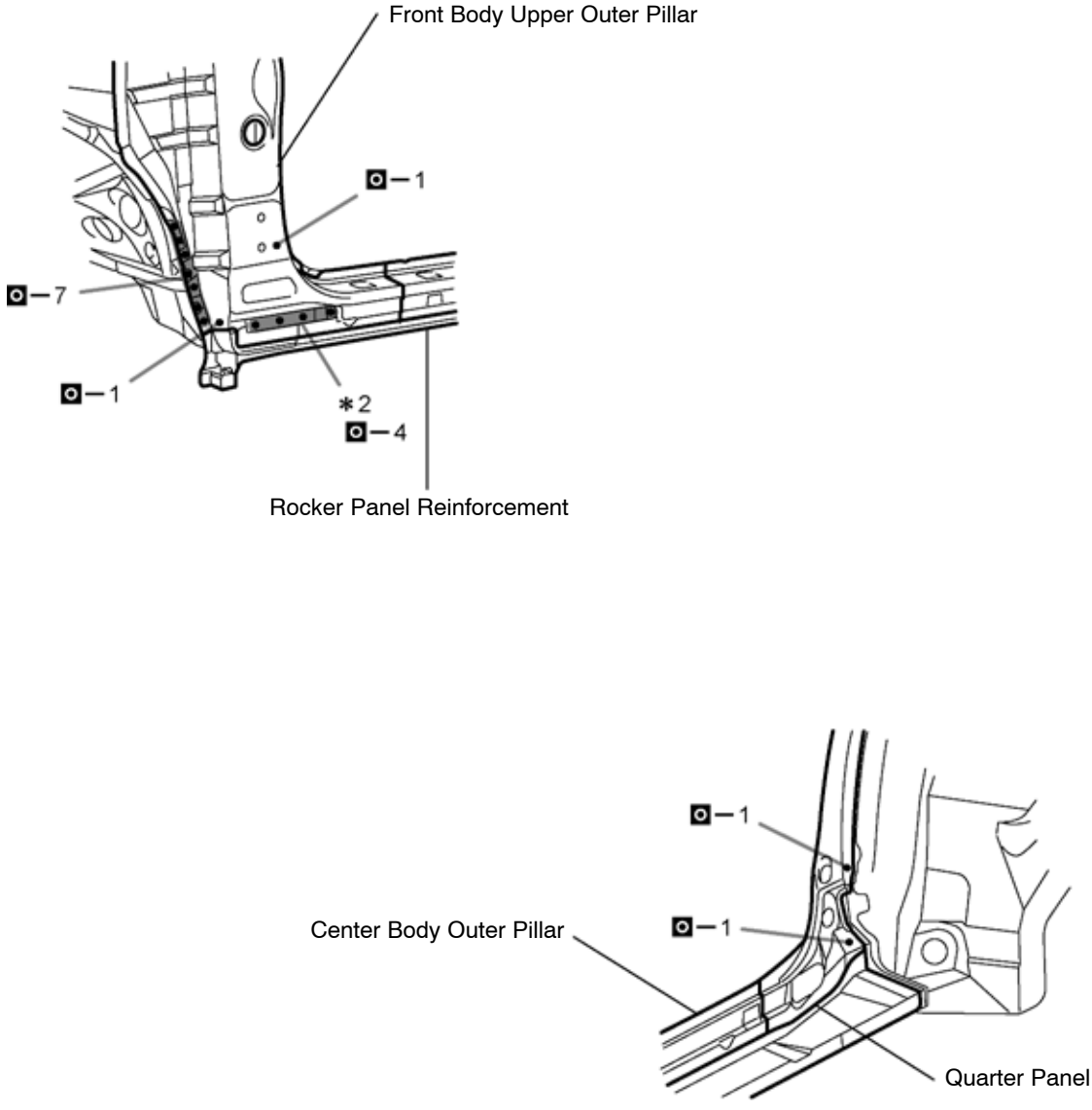
1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.

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.



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.