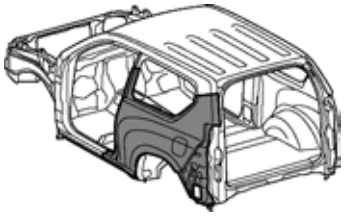
QUARTER PANEL (ASSY):

3 Door



F43267A

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

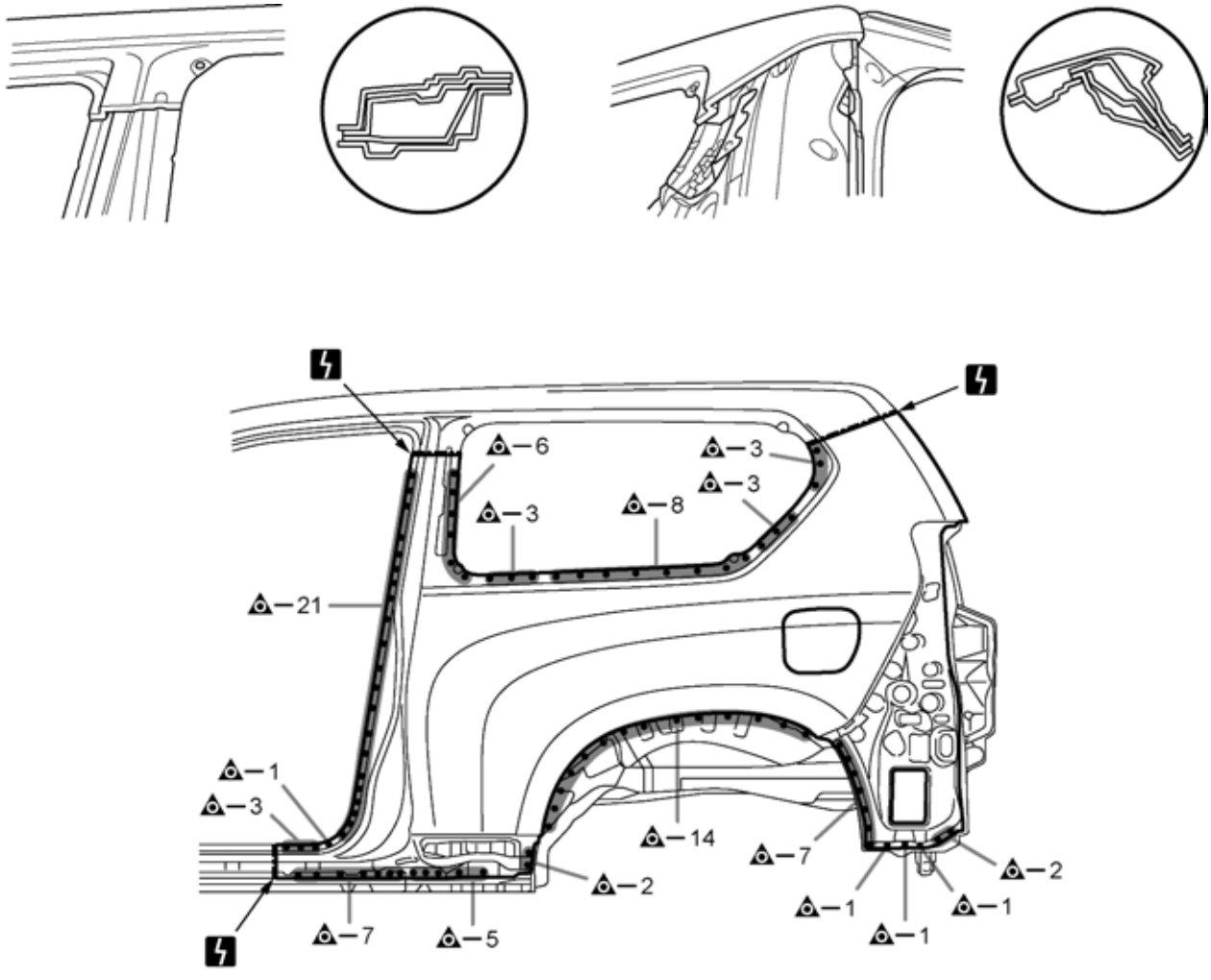
HINT:
Be sure to use Metal active gas (Ar 80% + CO_2 20%) as the shield gas when plug welding.
Sufficient weld strength cannot be assured when using 100% CO_2 shield gas.

Symbol meaning

: Remove Weld Points : Cut with Disc Sander etc. : Cut Location for Supply Parts

F43267B

REMOVAL



F43267

REMOVAL POINT

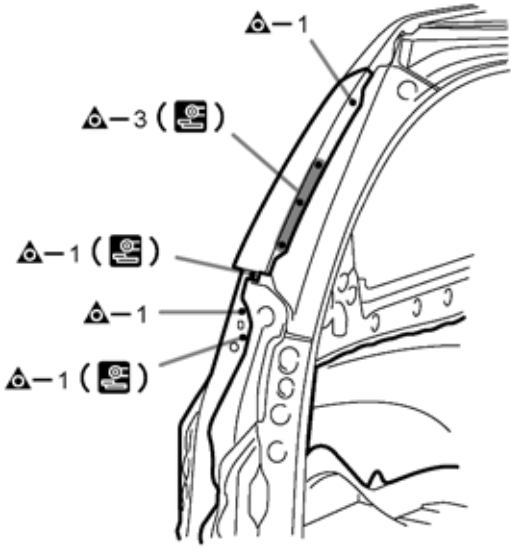
1 Do not butt weld or heat repair because the heat decreases the strength of areas where ultra high strength steel is used. (See the introduction)

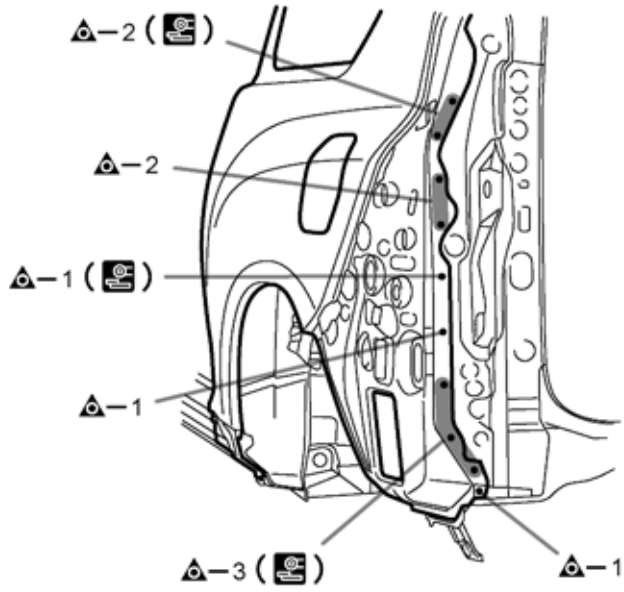
Symbol meaning

: Remove Weld Points : Cut with Disc Sander etc. : Cut Location for Supply Parts

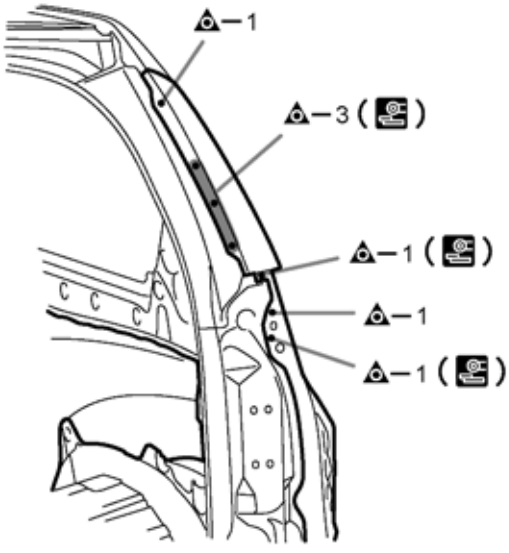
F43267B

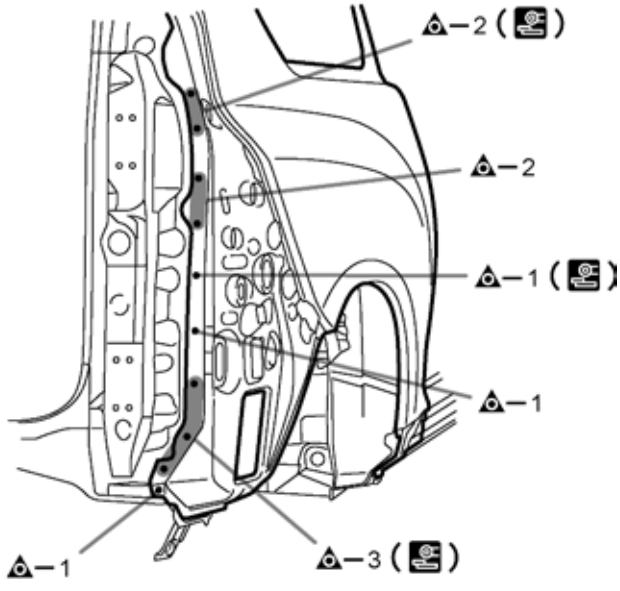
[LH]





[RH]





F43268

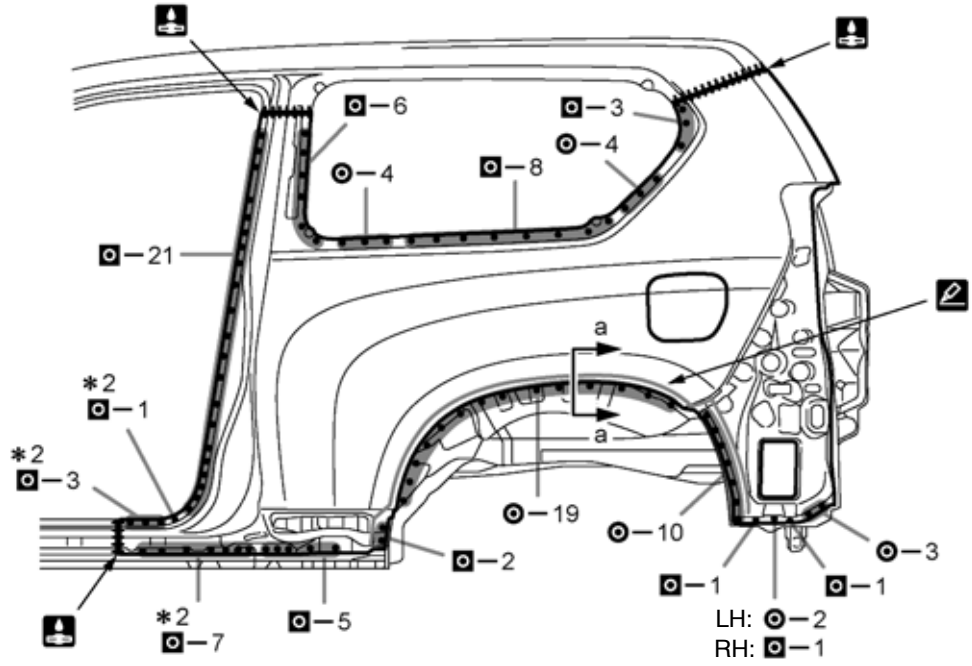
Symbol meaning

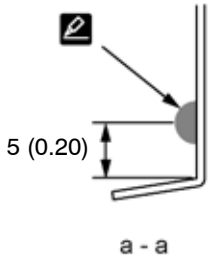
: Spot Weld : Plug Weld : Butt Weld

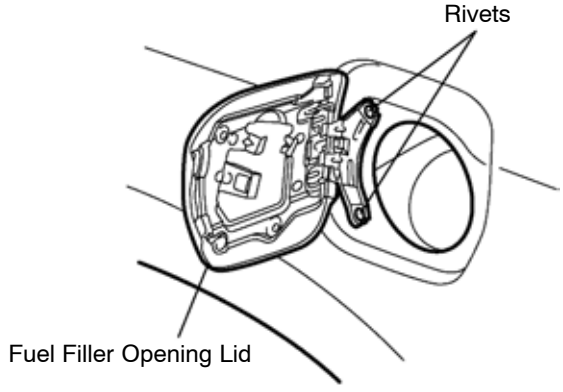
: Body Sealer

F43269B

INSTALLATION







mm (in.)

F43269

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 Before installing a new part, apply body sealer.
HINT:
Apply body sealer evenly about 5 mm (0.20 in.) from the flange, avoiding any oozing.
Apply body sealer evenly, about 3 – 4 mm (0.12 – 0.16 in.) in diameter.

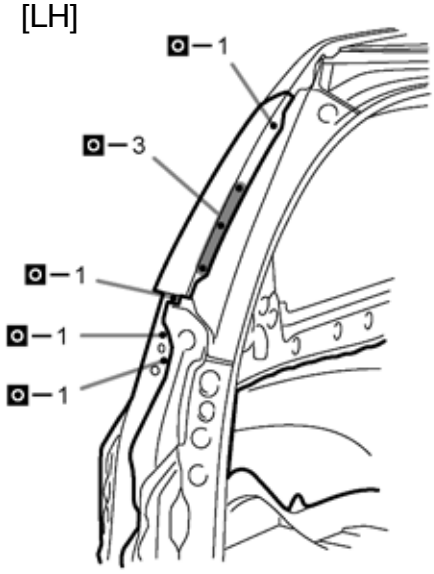
Symbol meaning

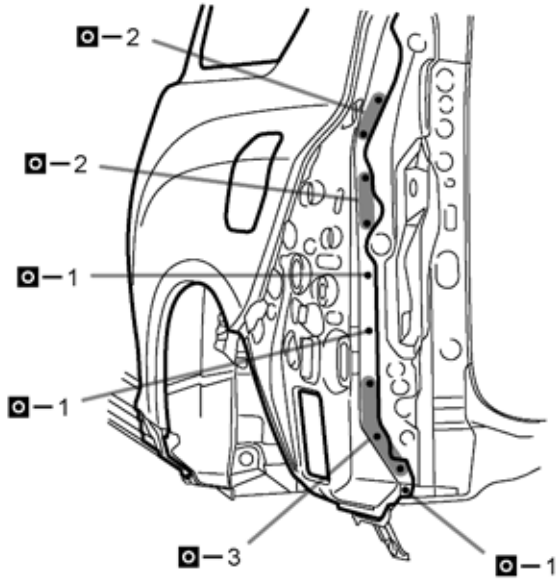
: Spot Weld : Plug Weld : Butt Weld

: Body Sealer

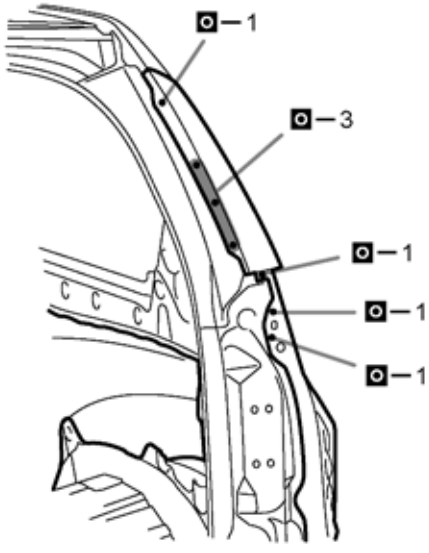
F43269B

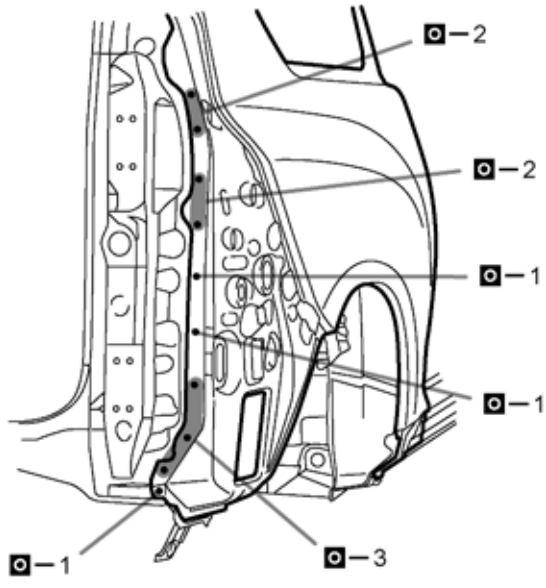
[LH]





[RH]





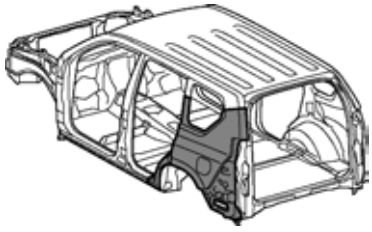
F43270

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 After welding, apply the foamed sealing material to the corresponding parts. (See the paint·coating)
4 After welding, apply body sealer to the corresponding parts. (See the paint·coating)
5 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

QUARTER PANEL (ASSY):

5 Door



F43271A

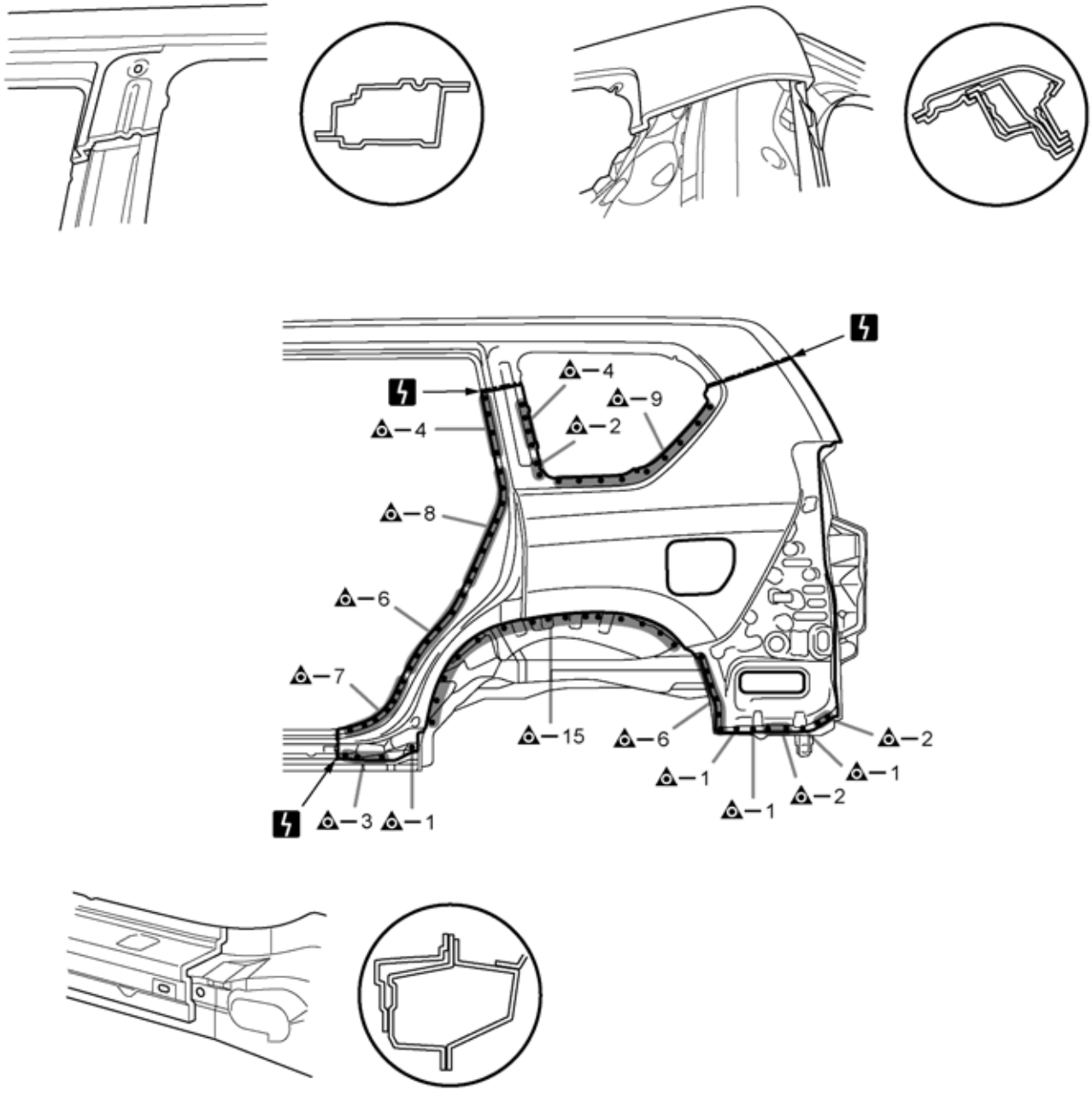
Symbol meaning

: Remove Weld Points : Cut with Disc Sander etc.

: Cut Location for Supply Parts

F43271B

REMOVAL



F43271

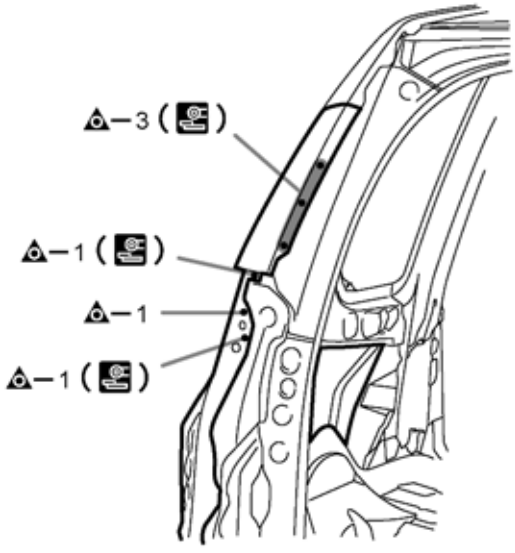
Symbol meaning

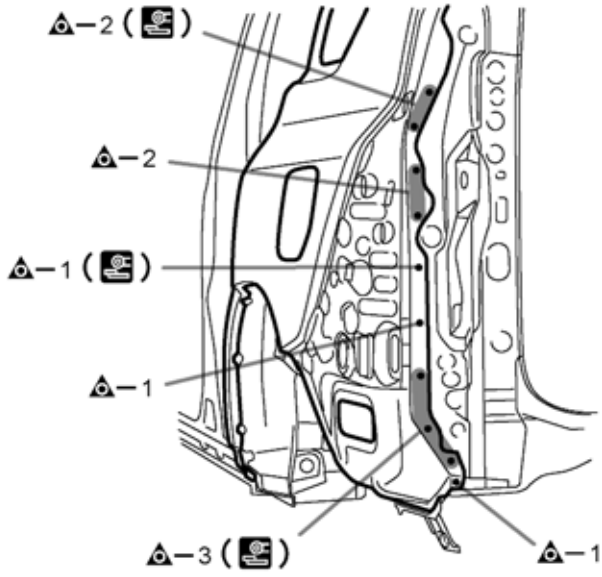
: Remove Weld Points : Cut with Disc Sander etc.

: Cut Location for Supply Parts

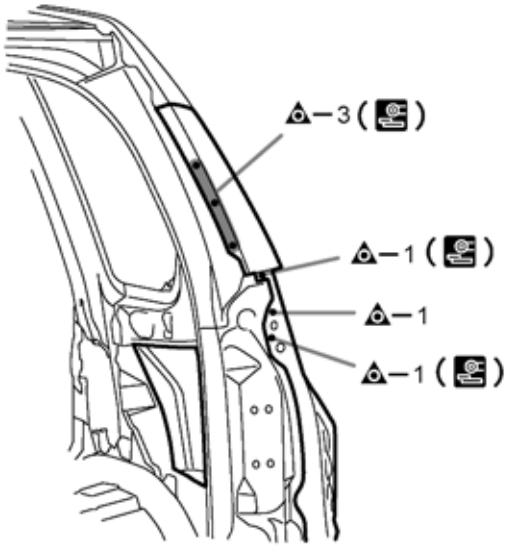
F43271B

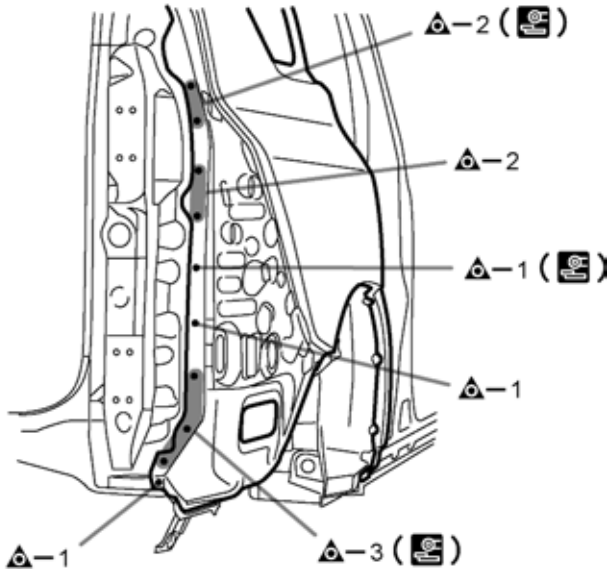
[LH]





[RH]





F43272

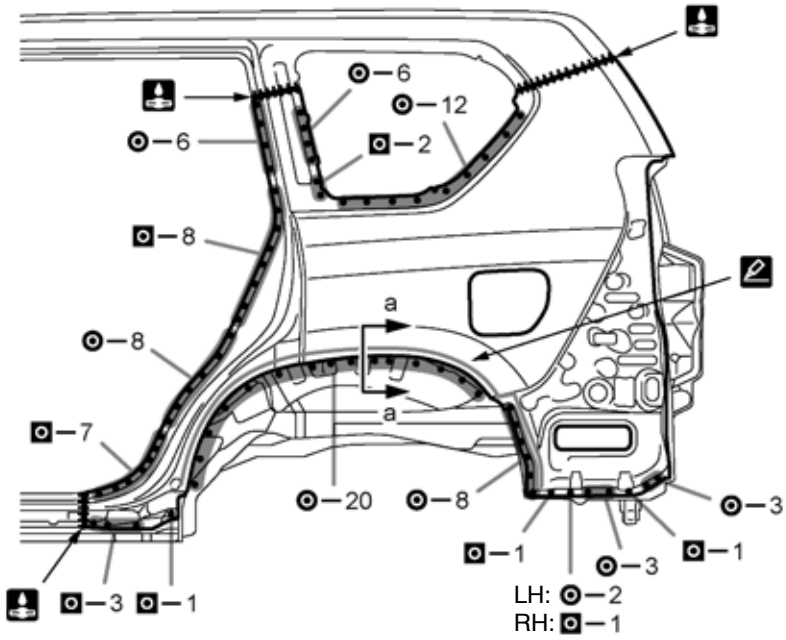
Symbol meaning

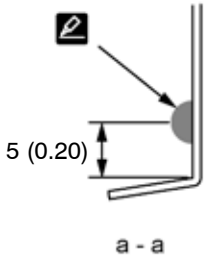
: Spot Weld : Plug Weld : Butt Weld

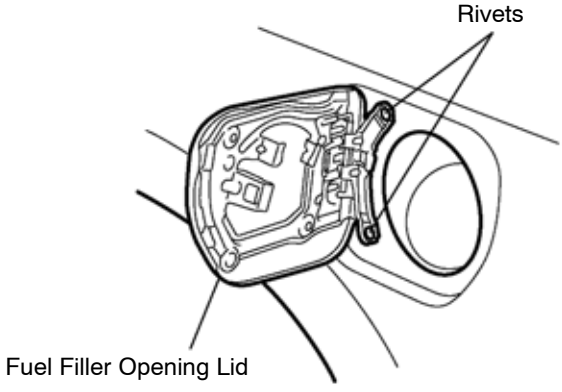
: Body Sealer

F43273B

INSTALLATION







mm (in.)

F43273

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 Before installing a new part, apply body sealer.
HINT:
Apply body sealer evenly about 5 mm (0.20 in.) from the flange, avoiding any oozing.
Apply body sealer evenly, about 3 – 4 mm (0.12 – 0.16 in.) in diameter.

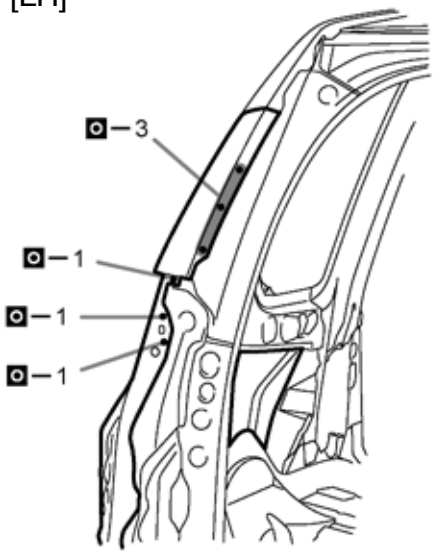
Symbol meaning

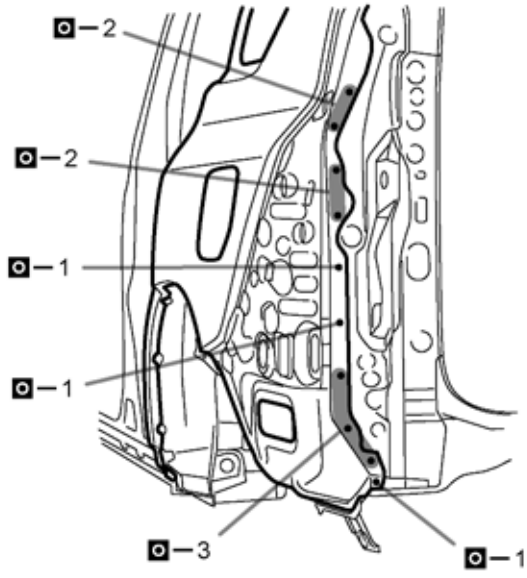
: Spot Weld : Plug Weld : Butt Weld

: Body Sealer

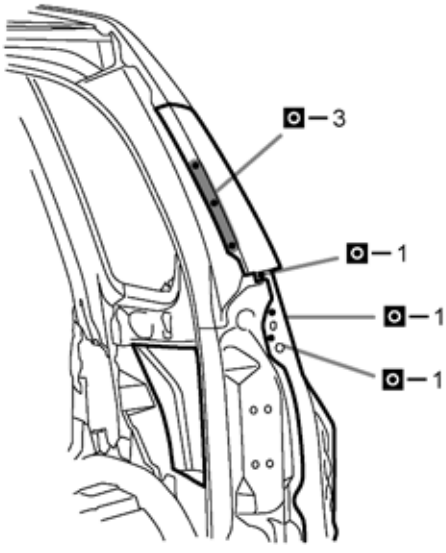
F43273B

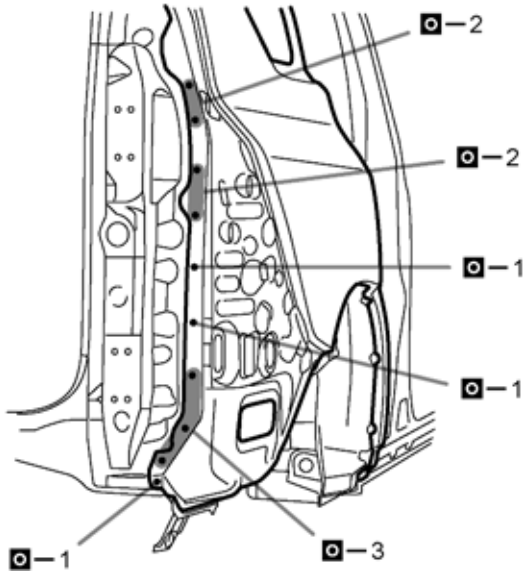
[LH]





[RH]





F43274

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 After welding, apply the foamed sealing material to the corresponding parts. (See the paint·coating)
4 After welding, apply body sealer to the corresponding parts. (See the paint·coating)
5 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.