

GROUP 3

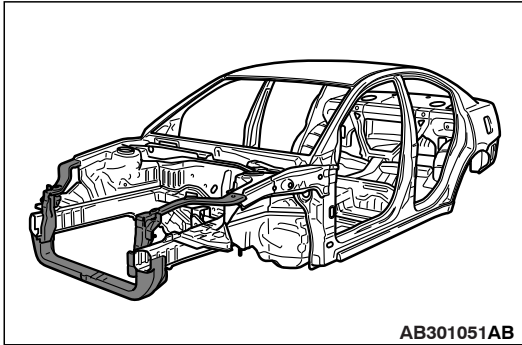
WELDED PANEL REPLACEMENT

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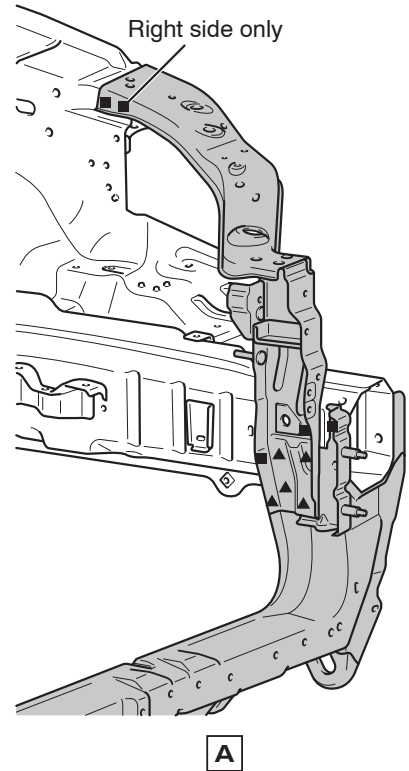
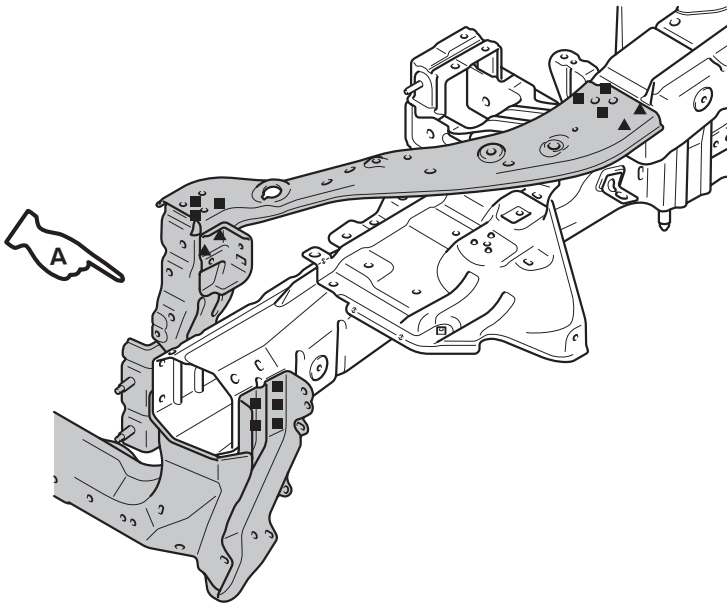
HEADLAMP SUPPORT

M4030003000445



SYMBOL	OPERATION DESCRIPTION
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
++++	MIG spot welding
	MIG arc welding (continuous)
ooooo	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.)

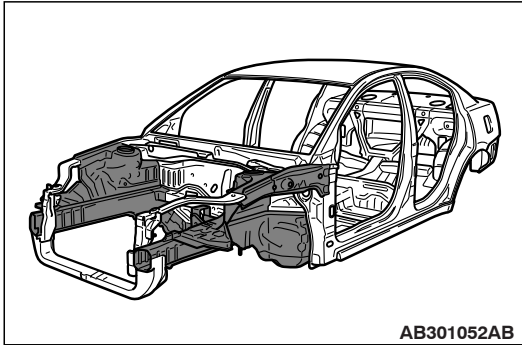
REPAIR WELDS



AB501173AB

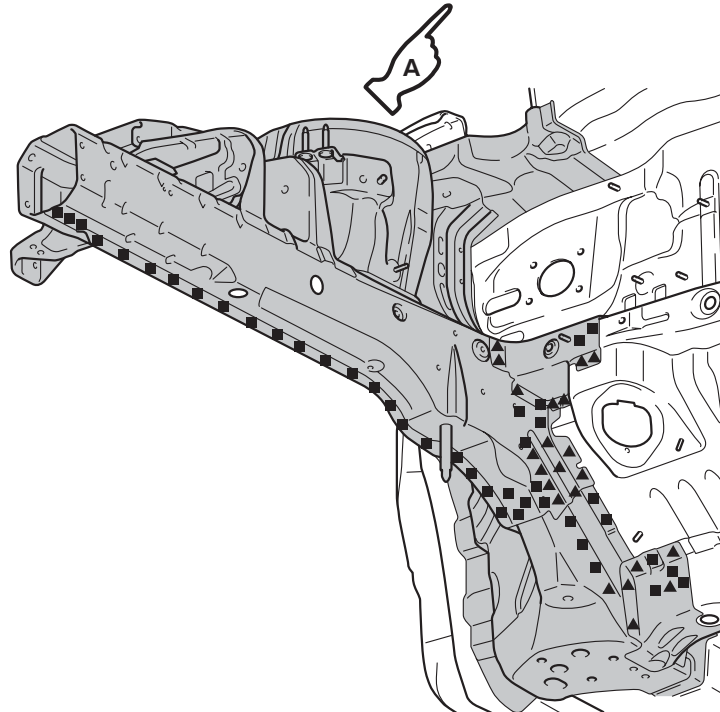
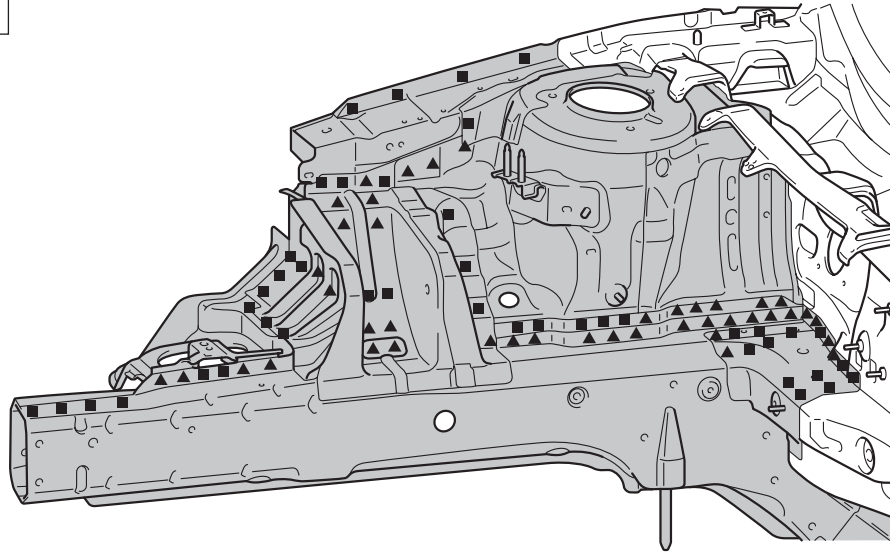
FENDER SHIELD

M4030004000556



SYMBOL	OPERATION DESCRIPTION
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
++++	MIG spot welding
	MIG arc welding (continuous)
oooooo	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.)

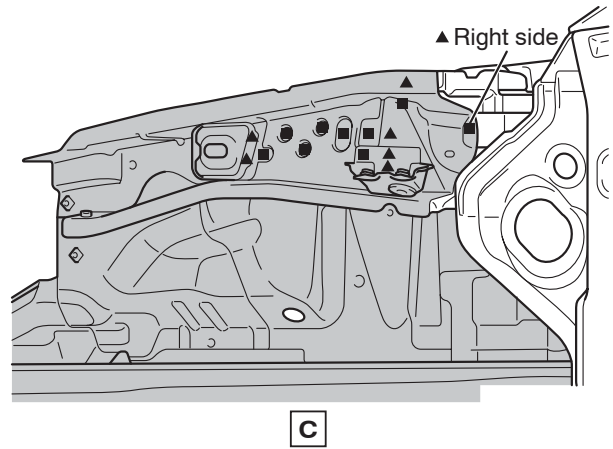
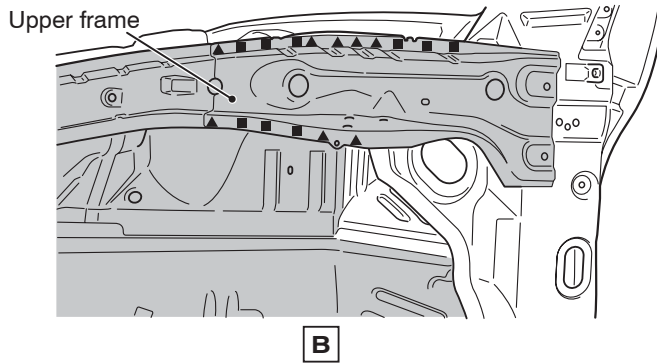
REPAIR WELDS



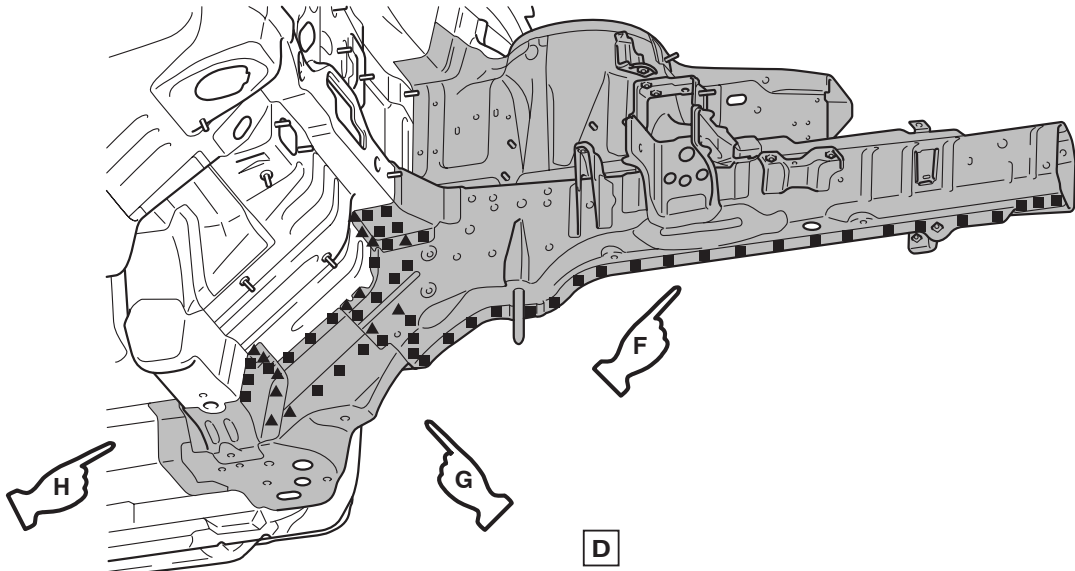
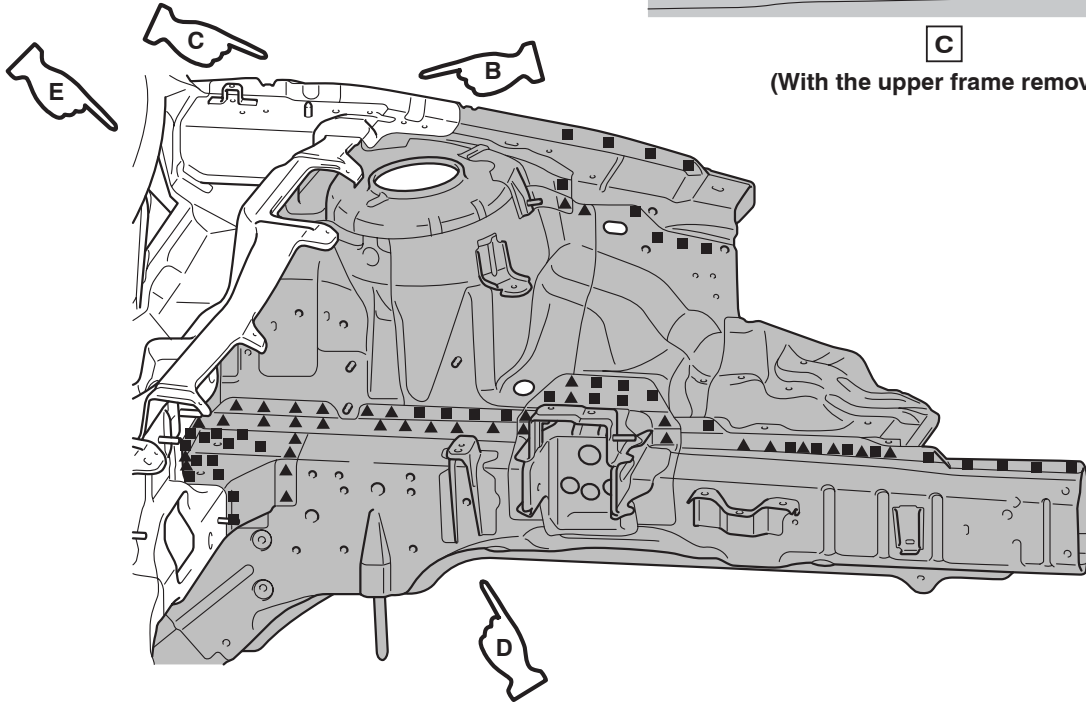
A

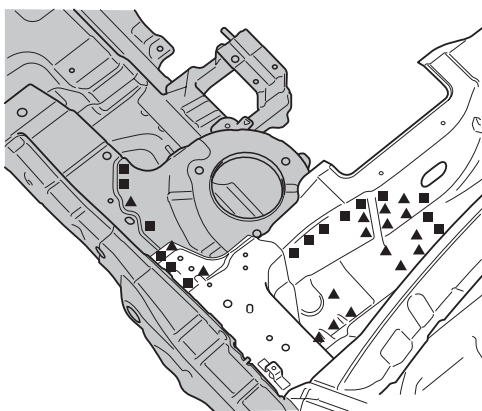
AB501461AB

NOTE: Refer to the Headlamp Support section on [P.3-2](#) for the welding point with headlamp support.

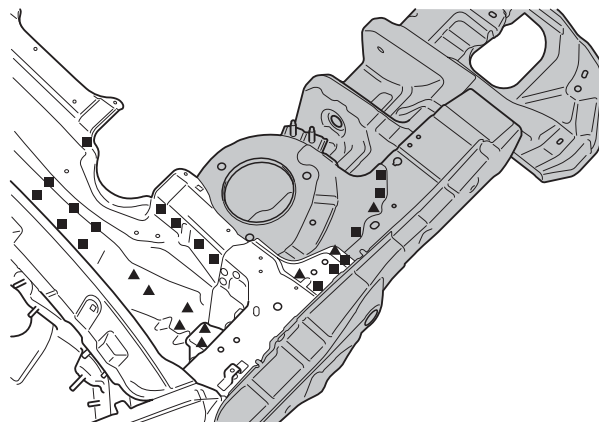


(With the upper frame removed)

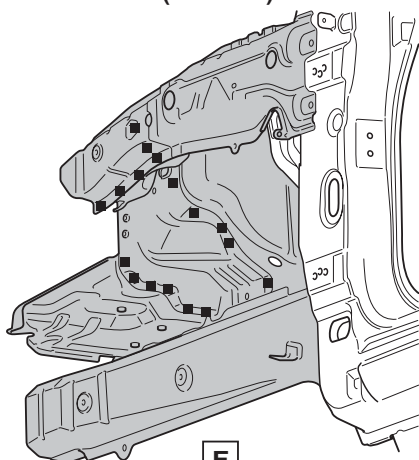




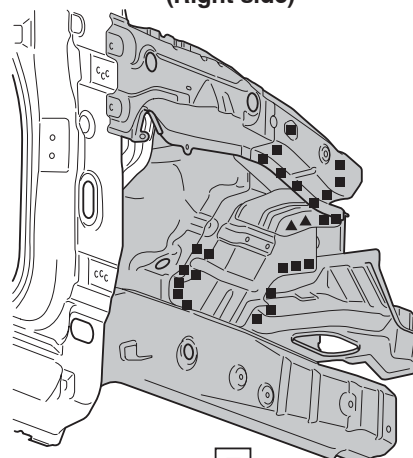
E
(Left side)



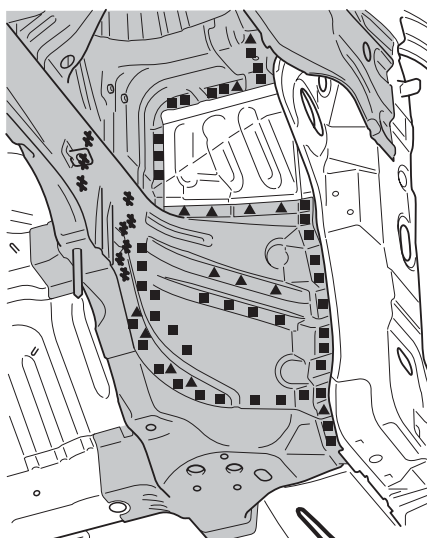
E
(Right side)



F
(Left side)



F
(Right side)

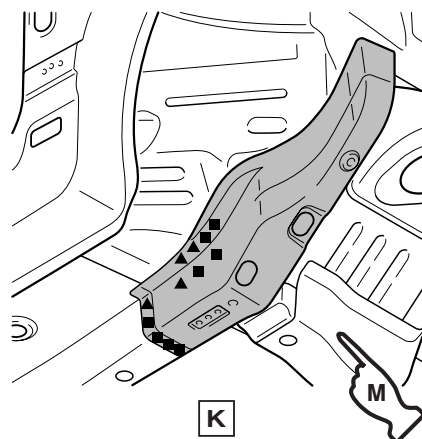
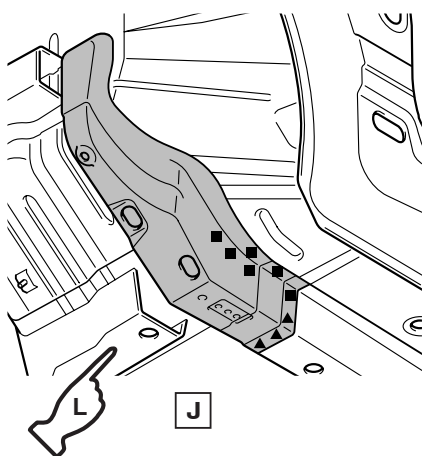
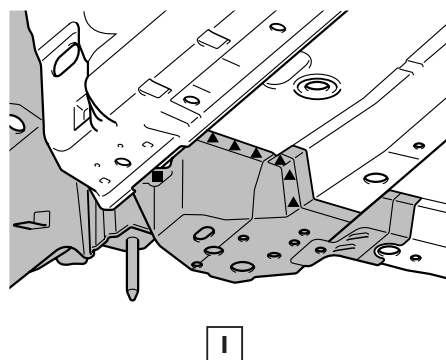
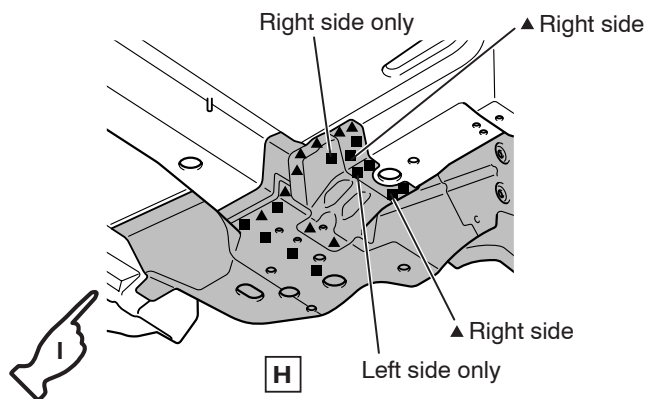


G
(Left side)

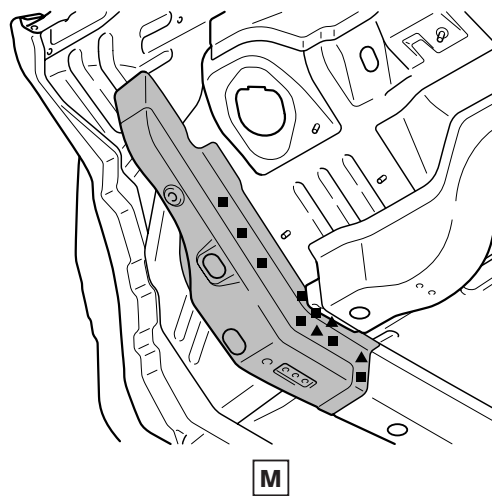
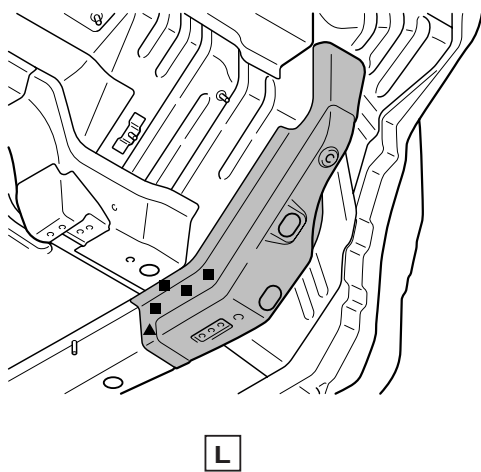


G
(Right side)

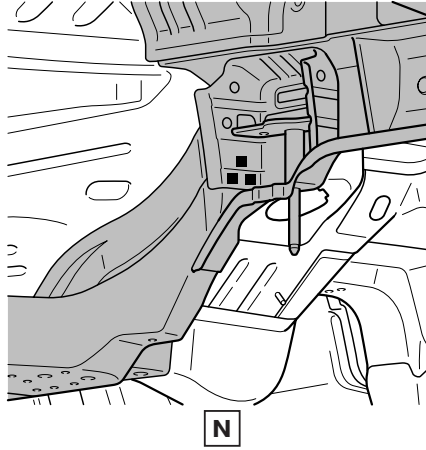
AB501517AB



(With the front sidemember removed)



(With the front sidemember removed)

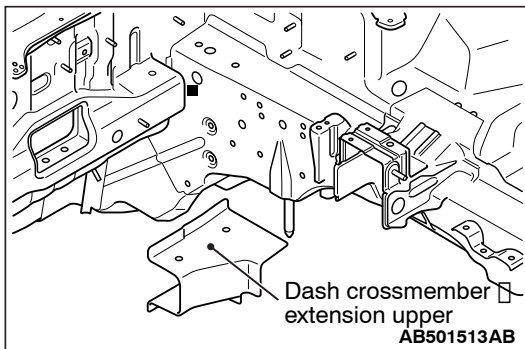


(Right side only)

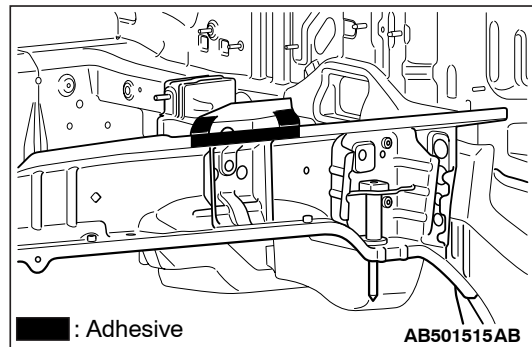
(With the front sidemember outer removed)

AB501506AB

NOTE ON REPAIR WORK REMOVAL



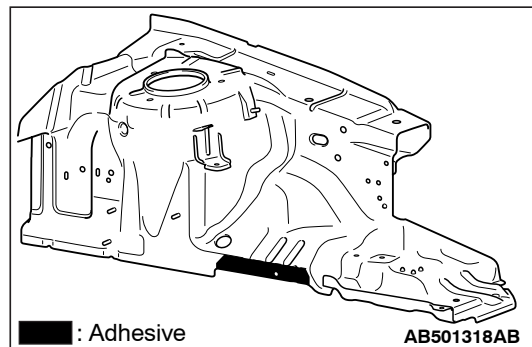
The welding point between front sidemember inner (LH) and front sidemember rear A (LH) is hidden by the dash crossmember extension upper. Therefore, when removing the front sidemember, remove the dash crossmember extension upper in advance.



2. Adhere in advance adhesives in the areas shown in the figure of the instructions when assembling the front sidemember outer (LH).

Adhesive: Epoxyayresin adhesive

Brand: 3M ATD Part No.8115 or equivalent

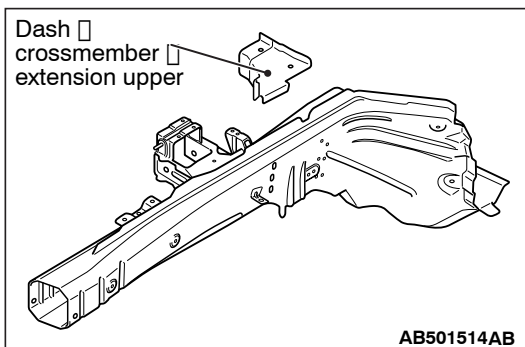


3. Adhere in advance adhesives in the areas shown in the figure of the instructions when assembling the front wheel house panel (LH).

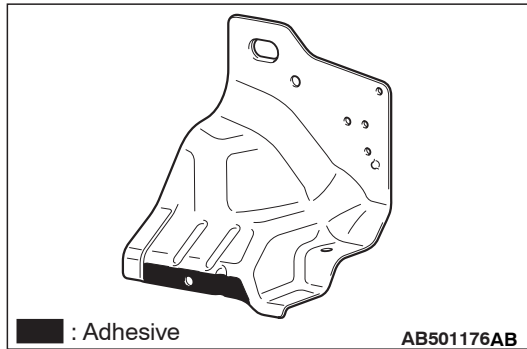
Adhesive: Epoxyayresin adhesive

Brand: 3M ATD Part No.8115 or equivalent

INSTALLATION

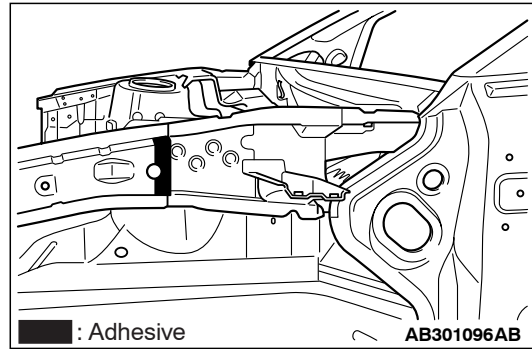


1. Remove the dash crossmember extension upper from the new front sidemember (LH).



4. Adhere in advance adhesives in the areas shown in the figure of the instructions when assembling the front fender shield (LH).

Adhesive: Epoxyayresin adhesive
Brand: 3M ATD Part No.8115 or equivalent

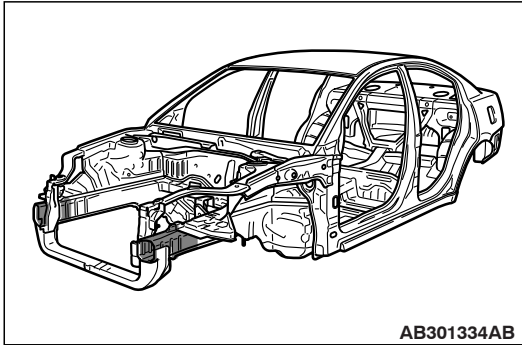


5. Adhere in advance adhesives in the areas shown in the figure of the instructions when assembling the upper frame.

Adhesive: Epoxyayresin adhesive
Brand: 3M ATD Part No.8115 or equivalent

FRONT SIDEMEMBER (PARTIAL REPLACEMENT)

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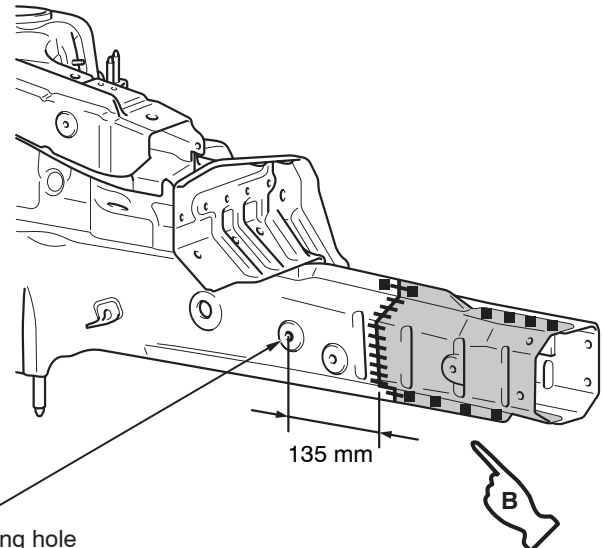
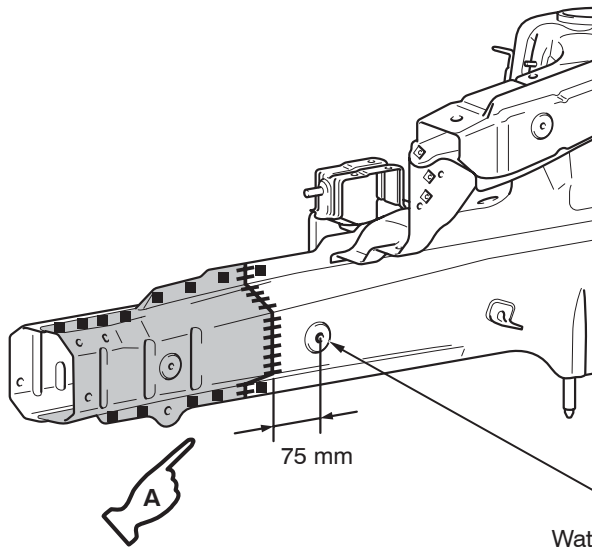


SYMBOL	OPERATION DESCRIPTION
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
++++	MIG spot welding
	MIG arc welding (continuous)
oooo	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.)

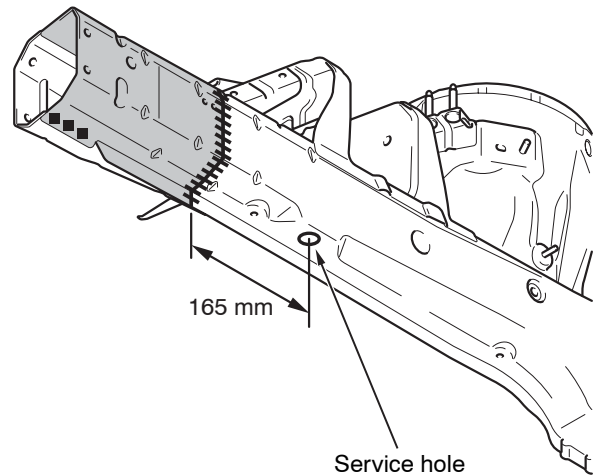
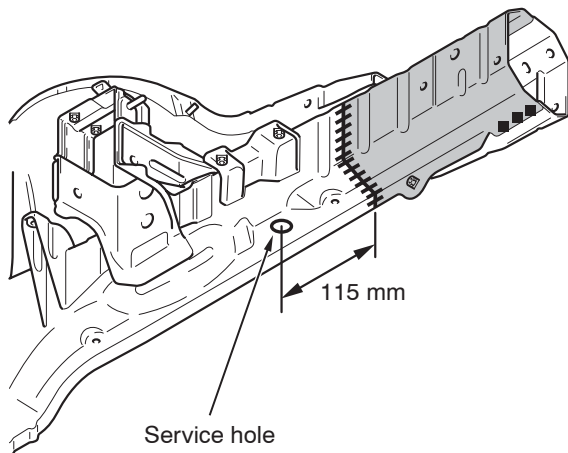
REPAIR WELDS

Left side

Right side



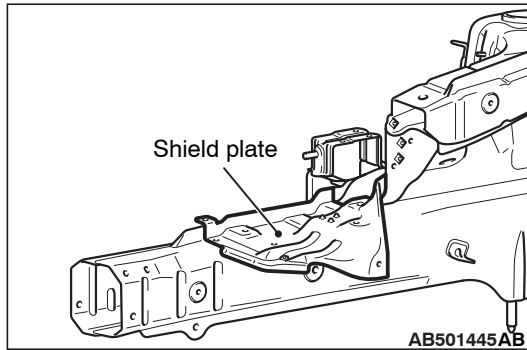
Water draining hole



AB501458AB

NOTE: Refer to the Headlamp Support section on [P.3-2](#) for the welding point with headlamp support.

**NOTE ON REPAIR WORK
REMOVAL**

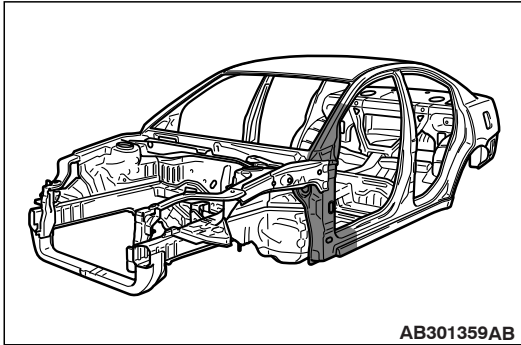


Remove the shield plate on the cut area in advance when cutting the front sidemember.

NOTE: Refer to the Fender Shield section on [P.3-3](#) for the welding points with the shield plate.

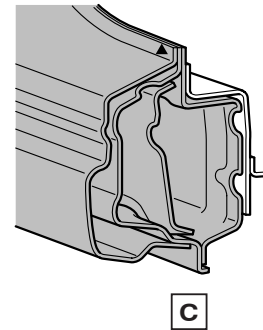
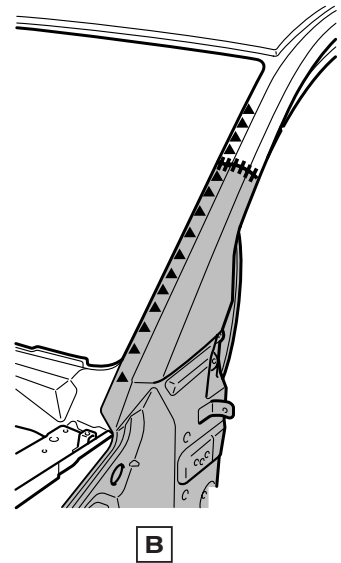
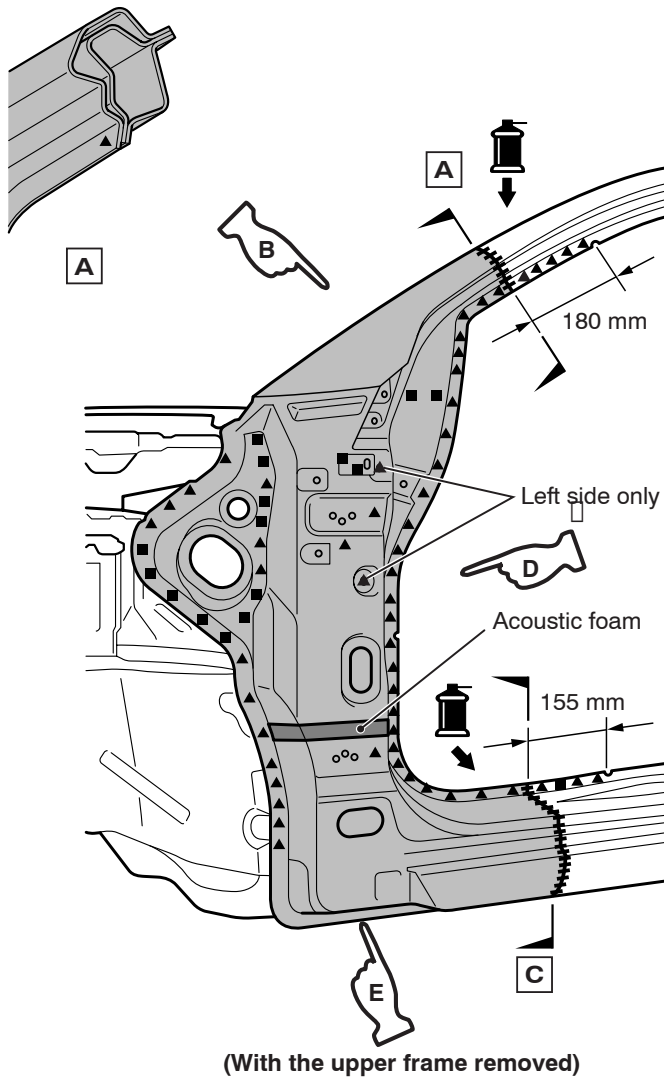
M4030005000816

FRONT PILLAR



SYMBOL	OPERATION DESCRIPTION
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
++++	MIG spot welding
	MIG arc welding (continuous)
oooo	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.)

REPAIR WELDS

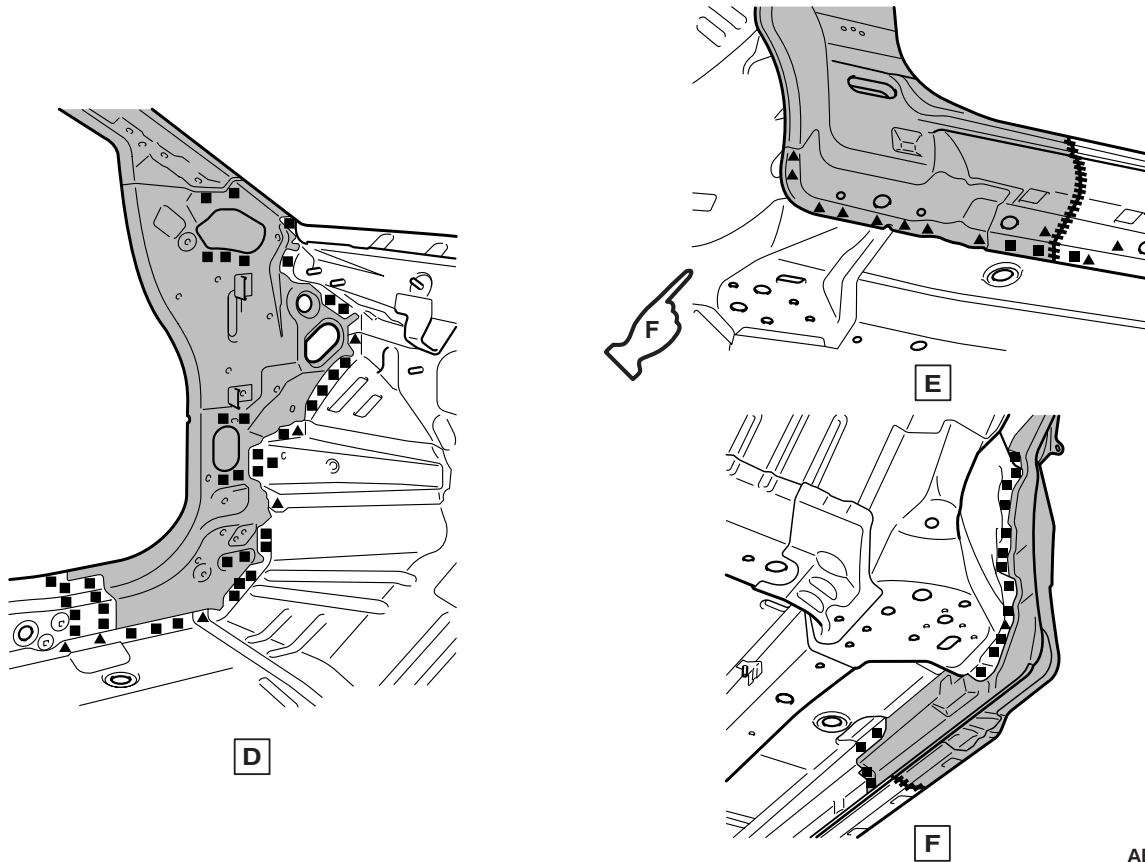


AB501132AB

CAUTION

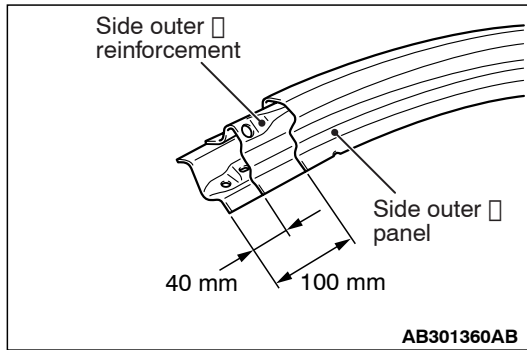
When repairing the area using foam materials do not use firing tools since the foaming materials may burn.

NOTE: Refer to the Fender Shield section on [P.3-3](#) for the welding points with the upper frame.

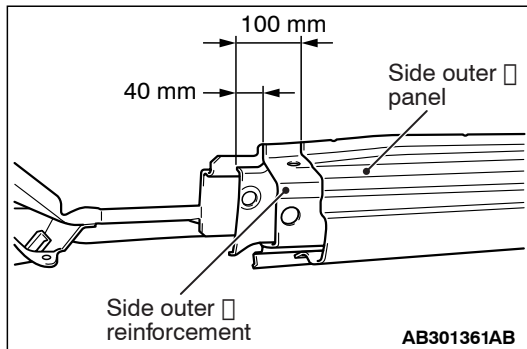


AB301358AC

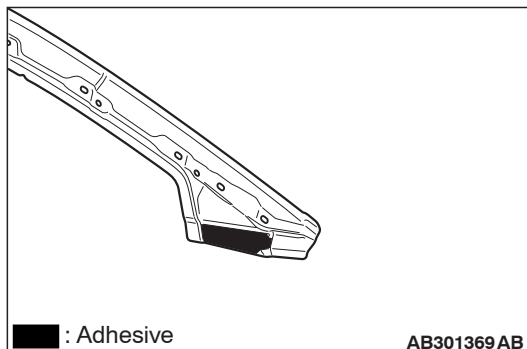
NOTE ON REPAIR WORK INSTALLATION



1. To reinforce the strength in the front pillar cut area, cut the side outer panel 100 mm above the cut area and cut the side outer reinforcement 40 mm above the cut area.



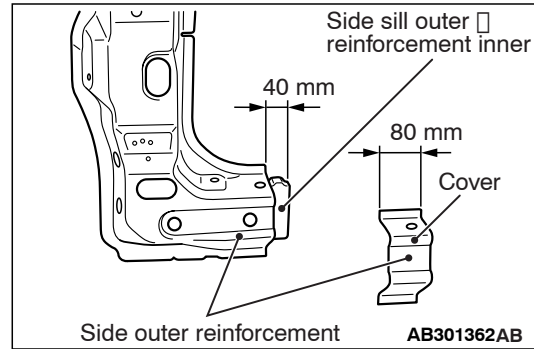
2. To reinforce the strength in the side sill cut area, cut the side outer panel 100 mm behind the cut area and cut the side outer reinforcement 40 mm behind the cut area.
3. Assemble the new front pillar inner lower parts.



4. Adhere in advance adhesives in the areas shown in the figure of the instructions when assembling the front pillar inner upper.

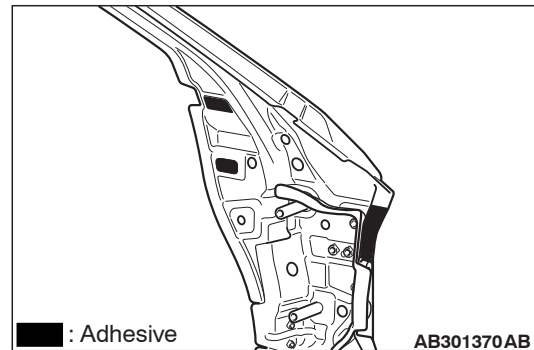
Adhesive: Epoxyayresin adhesive
Brand: 3M ATD Part No.8115 or equivalent

CAUTION



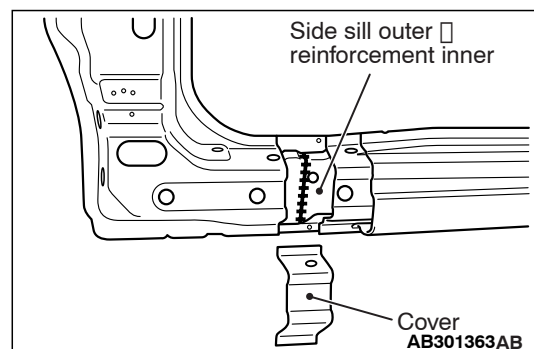
Weld and repair if the side sill outer reinforcement inner is damaged.

5. Cut the new side outer reinforcement by aligning it with the side outer reinforcement cut area on the body side. Then, cut only the side outer reinforcement 80 mm forward the cut area and make a cover. Cut the side sill outer reinforcement inner 40 mm behind the cut area of the side outer reinforcement.

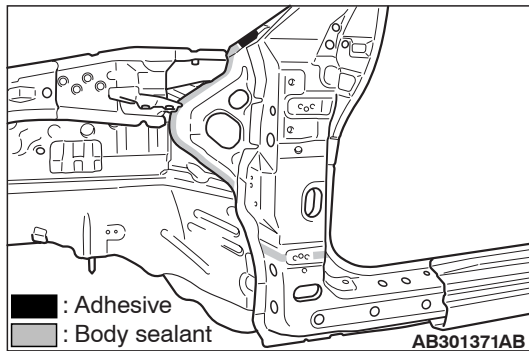


6. When assembling the side outer reinforcement, apply adhesives in the areas shown in the figure of the instructions.

Adhesive: Epoxyayresin adhesive
Brand: 3M ATD Part No.8115 or equivalent

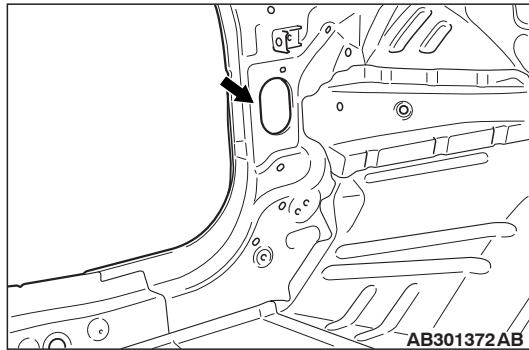


7. Weld the side sill outer reinforcement inner then weld the cover of the side outer reinforcement.



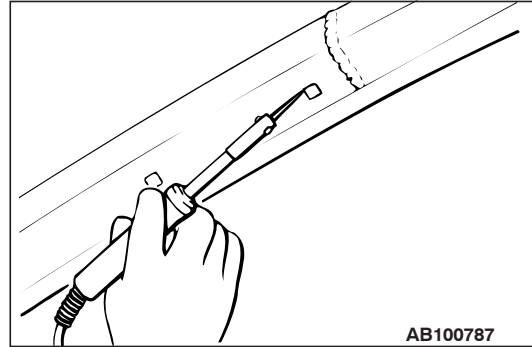
8. Adhere in advance body sealant and adhesives in the areas of the body side shown in the figure when assembling the new front pillar outer parts.

Adhesive: Epoxyayresin adhesive
Brand: 3M ATD Part No.8115 or equivalent



9. Assemble the front pillar outer, bolt and tape the hole and flange with aluminium tape, then fill the hole with foam materials as shown in the figure of the instructions.

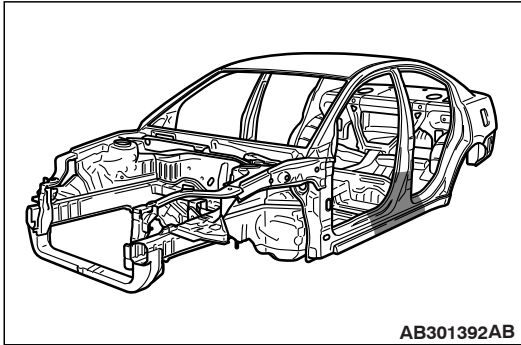
FOAM: 3M ATD ULTRAPRO Panel foam-Yellow



10. Wait 2 hours after filling the foam materials to remove the bolt and aluminium tape, then melt the foam materials with a soldering gun so a clip, etc. can thoroughly be inserted in the hole filled with foam materials.

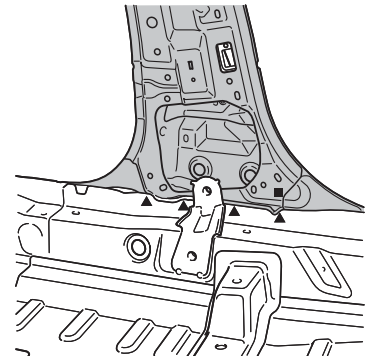
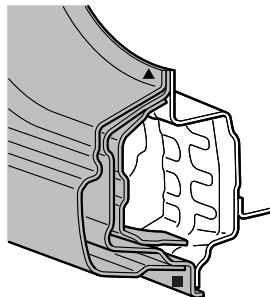
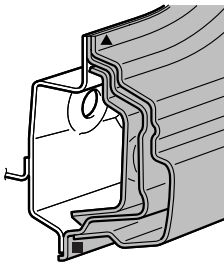
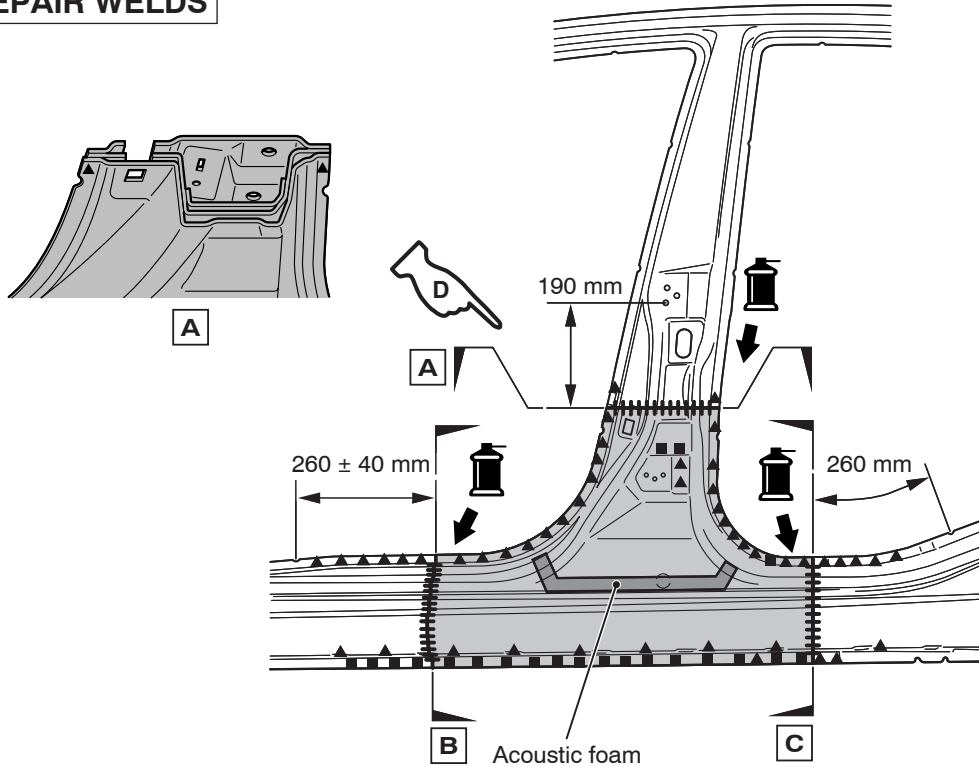
CENTRE PILLAR

M4030006000499



SYMBOL	OPERATION DESCRIPTION
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
++++	MIG spot welding
	MIG arc welding (continuous)
oooooo	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.)

REPAIR WELDS

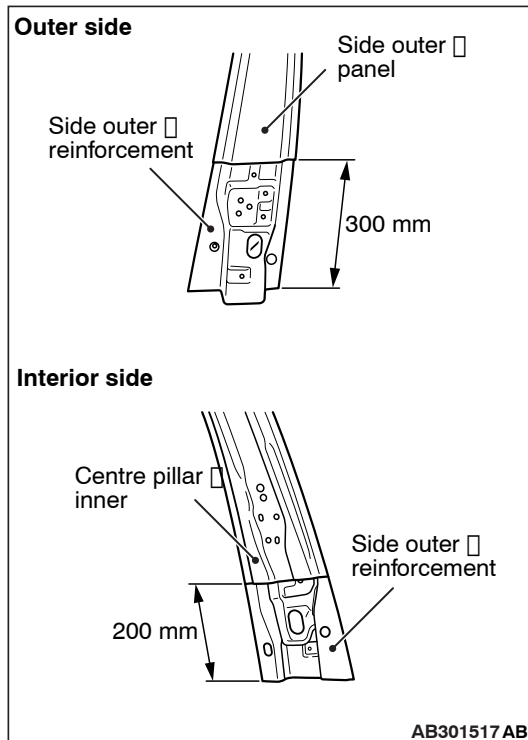


AB301520AB

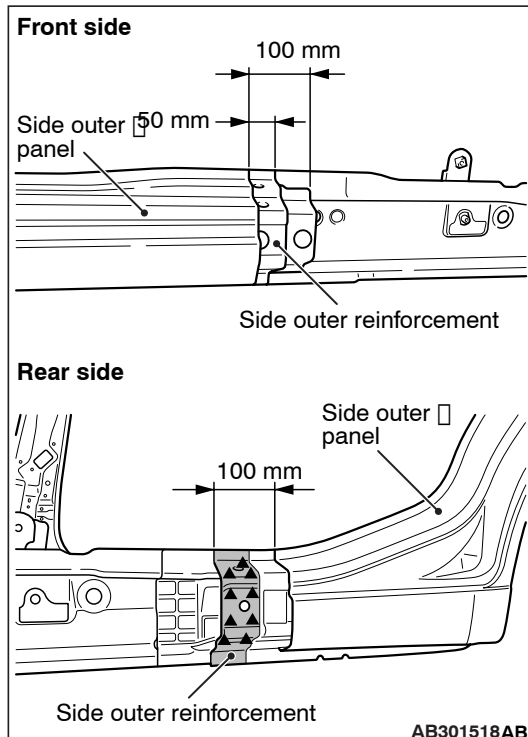
CAUTION

When repairing the area using foam materials do not use firing tools since the foaming materials may burn.

NOTE ON REPAIR WORK INSTALLATION

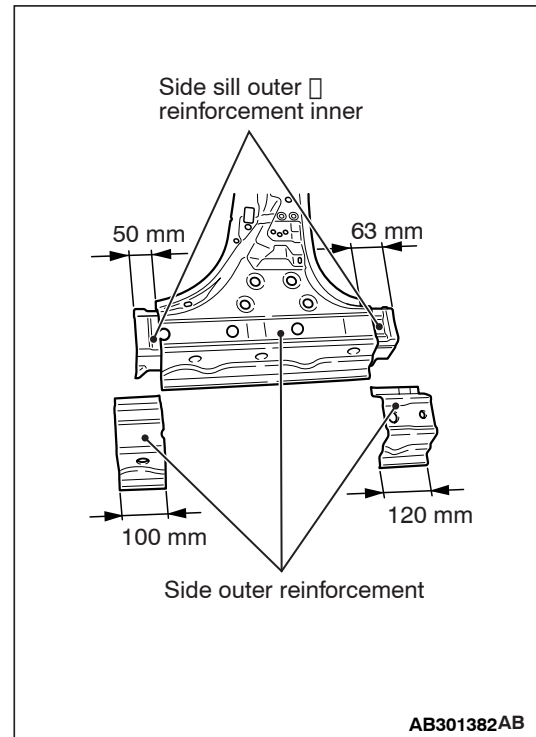


1. To reinforce the strength in the centre pillar cut area, cut the side outer panel 300 mm above the cut area and cut the centre pillar inner 200 mm above the cut area.



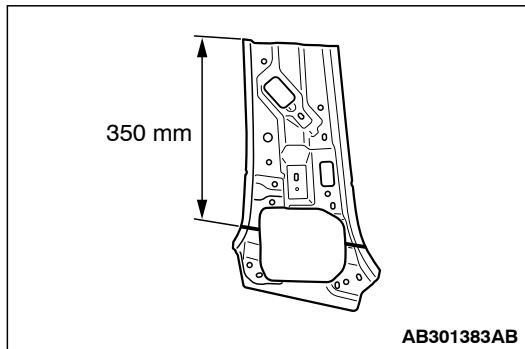
2. To reinforce the strength of the side sill cut area, on the front side, cut only the side outer panel 100 mm forward of the cut area, and cut only the side outer panel 50 mm behind the cut area. On the rear side, cut only the side outer panel 100 mm behind the cut area, and remove the side outer reinforcement.

CAUTION

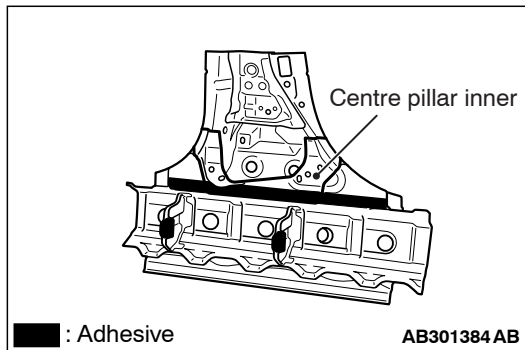


Weld and repair if the side sill outer reinforcement inner is damaged.

3. Cut the new side outer reinforcement by aligning its centre pillar area and its front side of the side sill area with the side outer reinforcement cut area on the body side. Then, on the front side of the side sill area, cut only the side outer reinforcement 100 mm behind the cut area and make a cover. Cut the side sill outer reinforcement inner 50 mm forward the cut area of the side outer reinforcement. On the rear side of the side sill area, cut only the side outer reinforcement 120 mm forward the rear end, and cut the side sill outer reinforcement inner 63 mm behind the cut area of the side outer reinforcement.

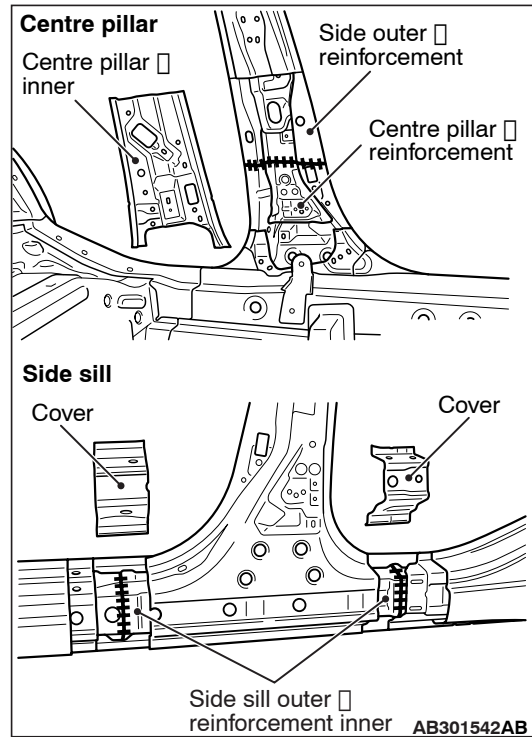


4. Cut the new centre pillar inner part by aligning it with the cut area on the body side. Then, cut it 350 mm below the cut area.

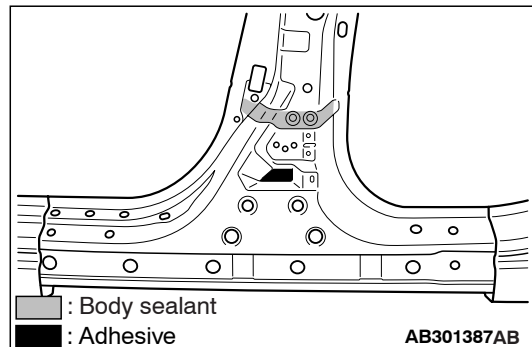


5. When assembling the side outer reinforcement, install the lower part of the centre pillar inner cut on the procedures above and apply adhesives in the areas shown in the figure of the instructions.

Adhesive: Epoxyayresin adhesive
Brand: 3M ATD Part No.8115 or equivalent

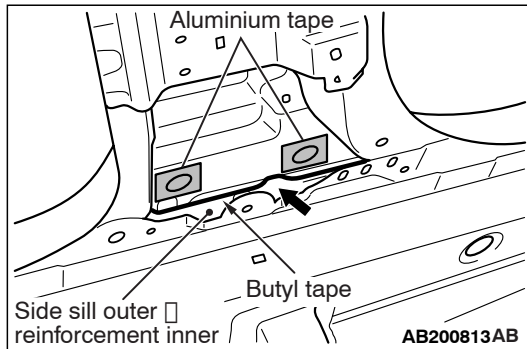


6. When assembling the side reinforcement, on the centre pillar area, weld the side outer reinforcement and centre pillar reinforcement from the outside and inside, then weld the centre pillar inner. On the side sill area, weld the side sill outer reinforcement inner, then weld the side outer reinforcement cover.



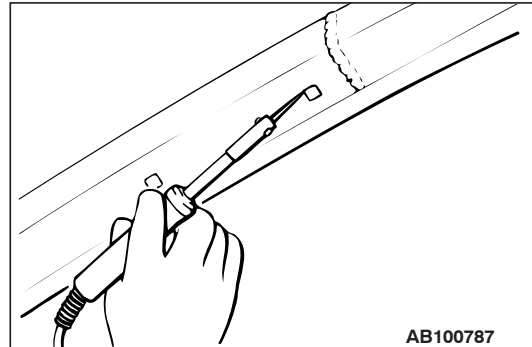
7. Adhere in advance body sealant and adhesives in the areas of the body side shown in the figure when assembling the new centre pillar outer part.

Adhesive: Epoxyayresin adhesive
Brand: 3M ATD Part No.8115 or equivalent



8. After assembling the centre pillar outer, fill the upper surface of the side sill outer reinforcement inner with foam materials. At this time, aluminium tape the hole of the side outer reinforcement and the gap on the side sill outer reinforcement inner with butyl-tape, to prevent foam materials from dropping.

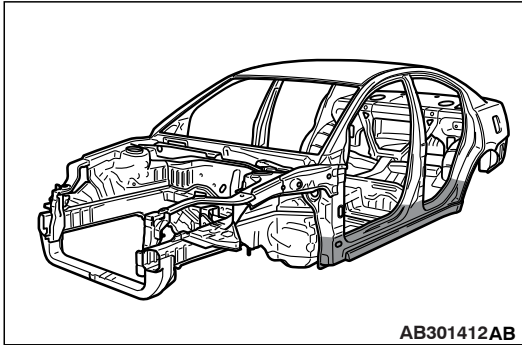
Foam: 3M ATD ULTRAPRO Panel foam-Yellow



9. Wait approximately 2 hours after filling the foam materials, and melt the foam materials with a soldering gun so that a clip and other fixing items can thoroughly be inserted in the hole filled with foam materials, to secure the hole.

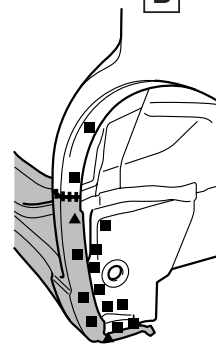
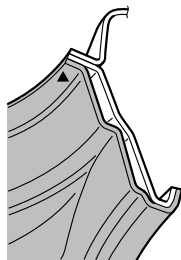
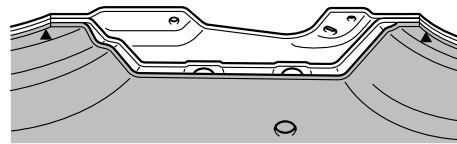
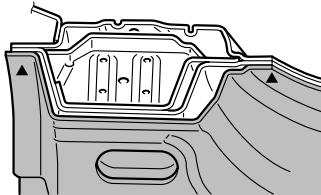
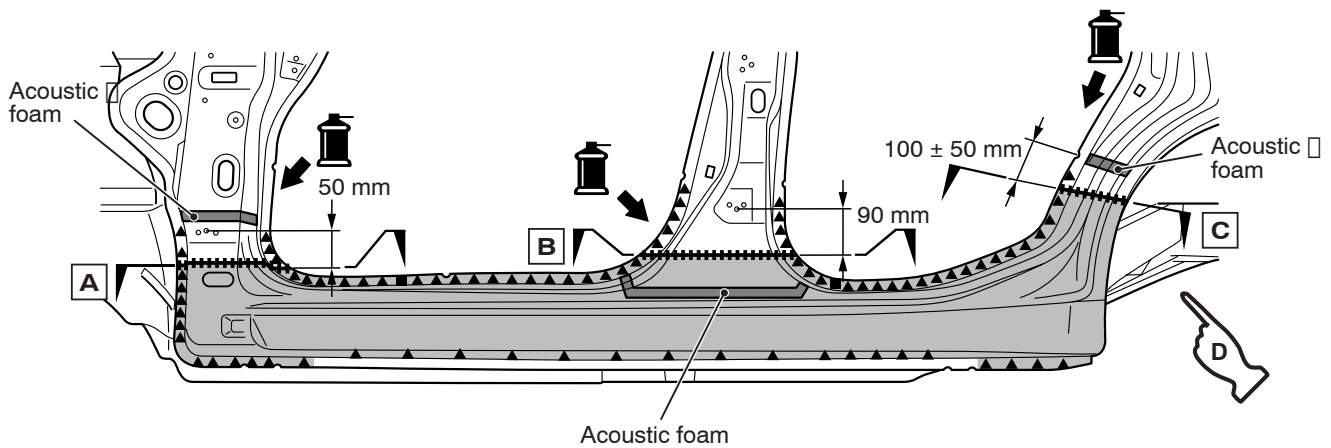
SIDE SILL

M4030007000618



SYMBOL	OPERATION DESCRIPTION
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
++++	MIG spot welding
	MIG arc welding (continuous)
○○○○○○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.)

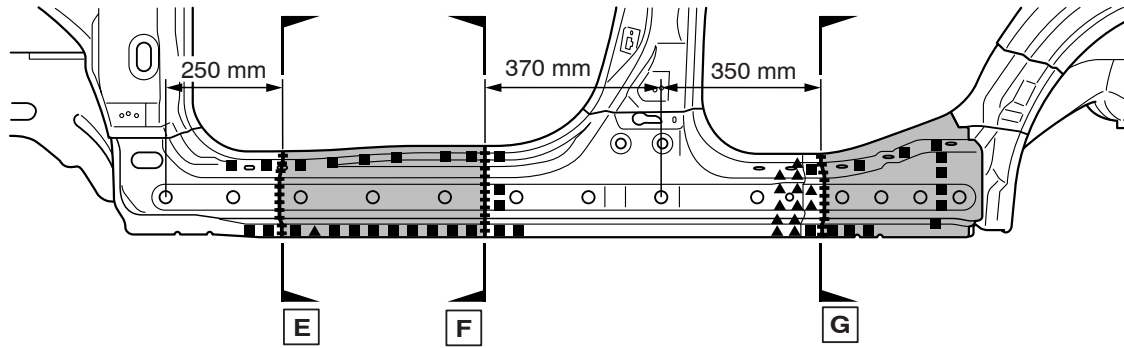
REPAIR WELDS



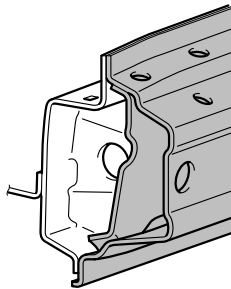
AB301521AB

CAUTION

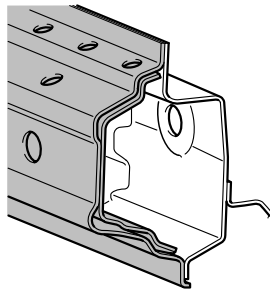
When repairing the area using foam materials do not use firing tools since the foaming materials may burn.



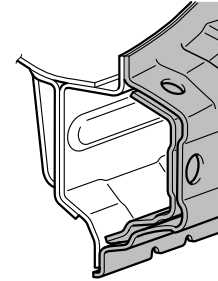
(With the side outer panel removed)



E



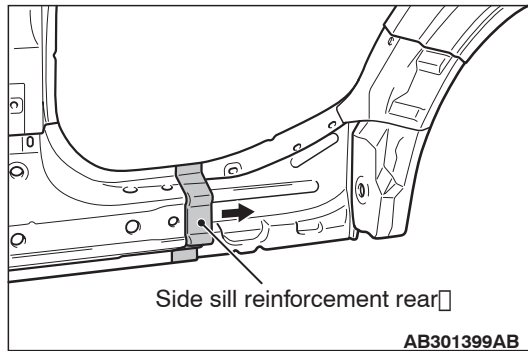
F



G

AB301522AB

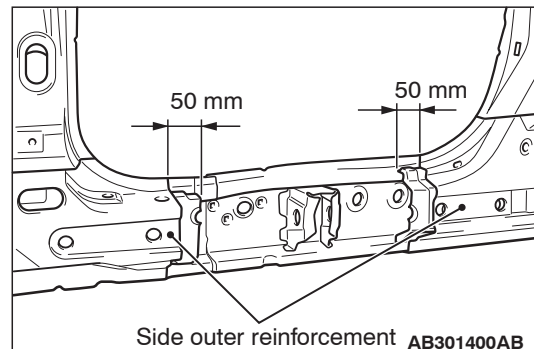
NOTE ON REPAIR WORK REMOVAL



After cutting and removing the side sill reinforcement rear, pull backward the side sill reinforcement rear remaining on the body side.

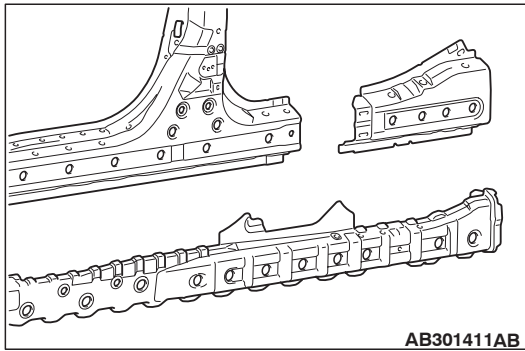
INSTALLATION

CAUTION

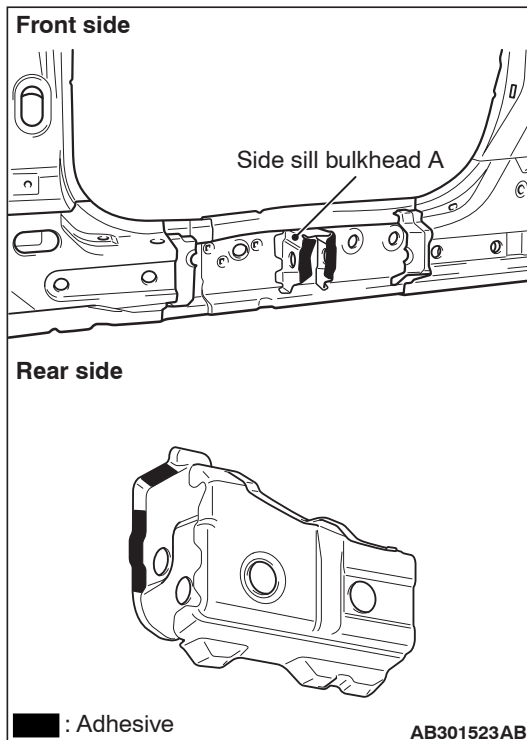


Weld and repair if the side sill outer reinforcement inner is damaged.

1. To reinforce the strength of the side outer reinforcement cut area, cut only the side outer reinforcement 50 mm front and behind the cut areas to remove.

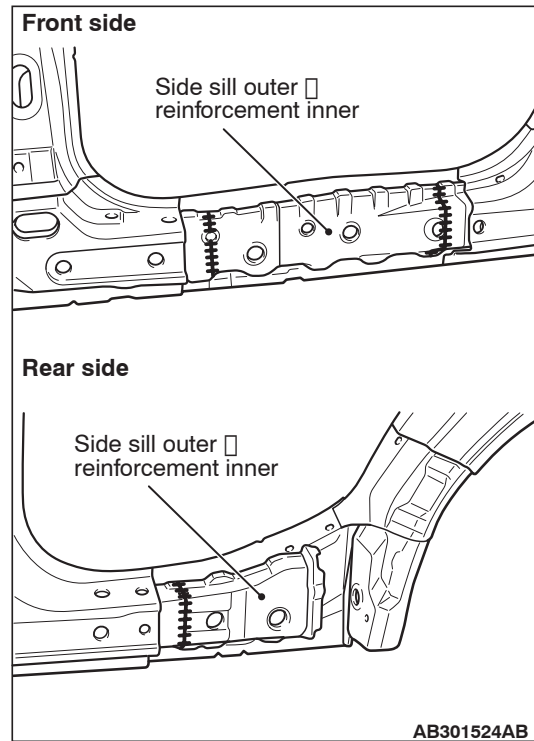


2. Remove the side sill reinforcement rear and the side sill outer reinforcement inner from the side outer reinforcement. Cut the side outer reinforcement and the side sill outer reinforcement inner, aligning them with the body side.

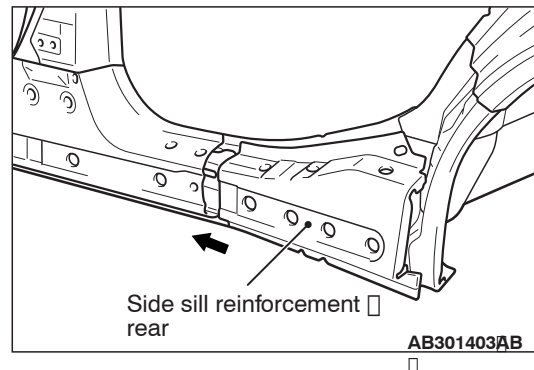


3. When assembling the side sill outer reinforcement inner, on the front side, adhere adhesives to the side sill bulkhead A of the body side. On the rear side, adhere adhesives to the side sill outer reinforcement inner.

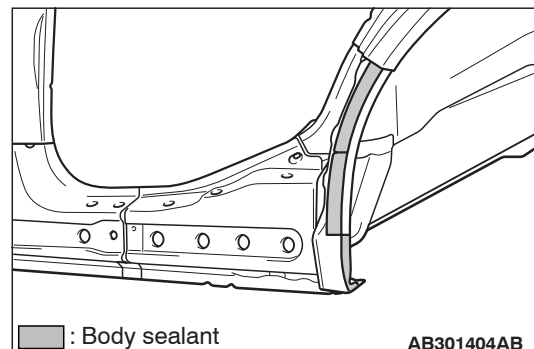
Adhesive: Epoxyayresin adhesive
Brand: 3M ATD Part No.8115 or equivalent



4. Weld the side sill outer reinforcement inner, then weld the side outer reinforcement.



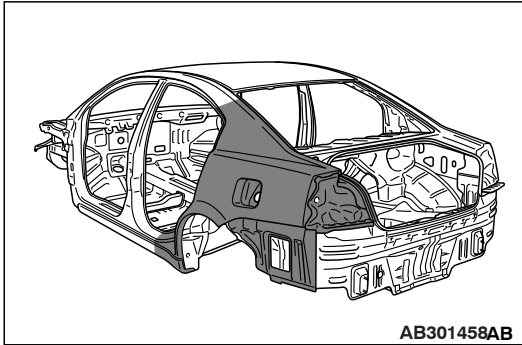
5. Assemble the side sill reinforcement rear by inserting it to the side outer reinforcement from backward.



6. Adhere in advance body sealant in the areas of the body side shown in the figure when assembling the front floor side sill outer.

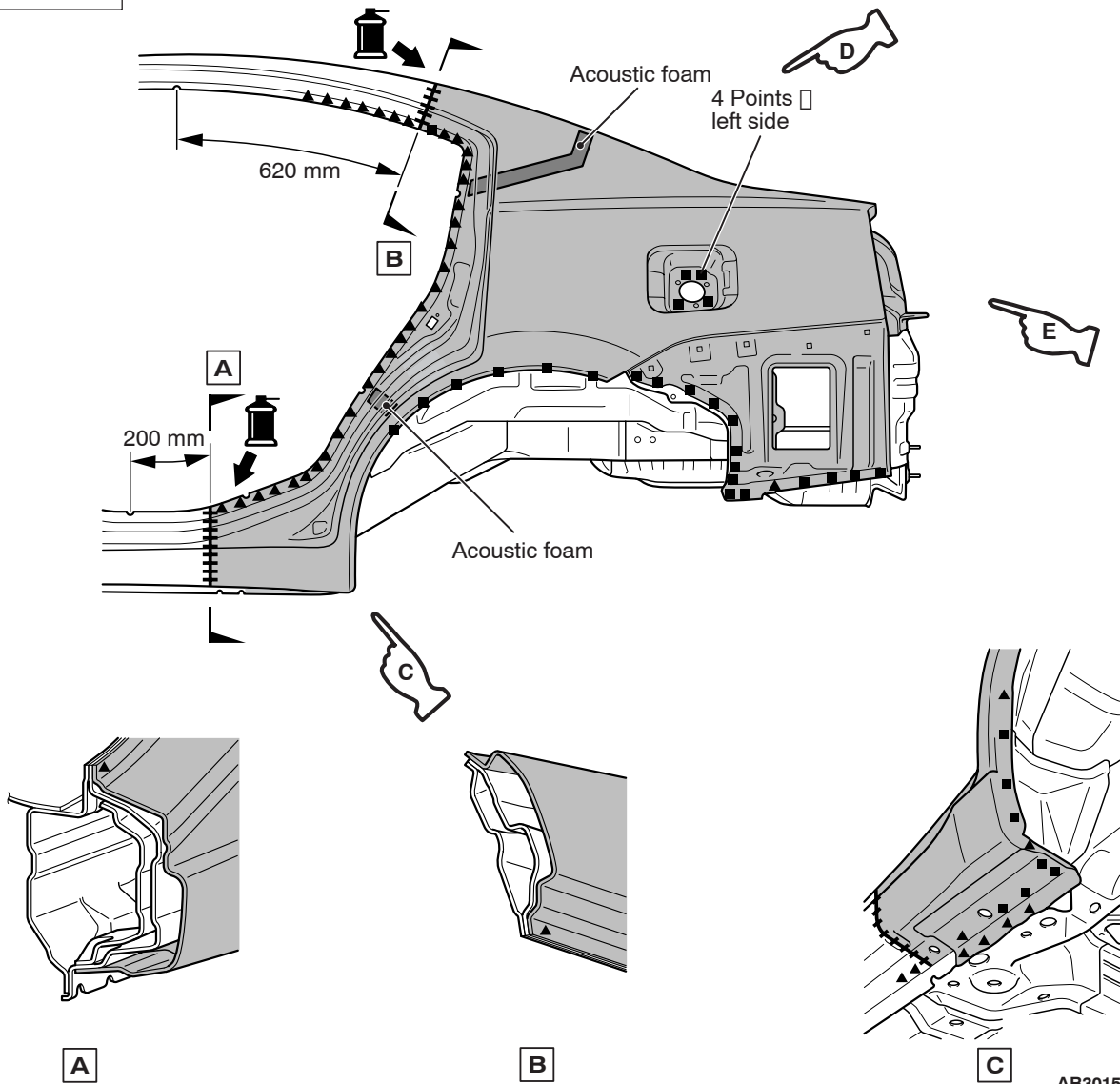
QUARTER OUTER

M4030008000495



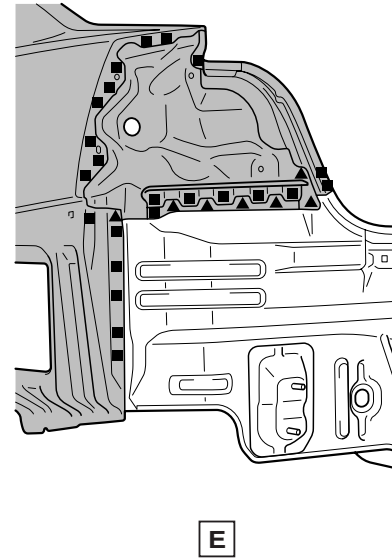
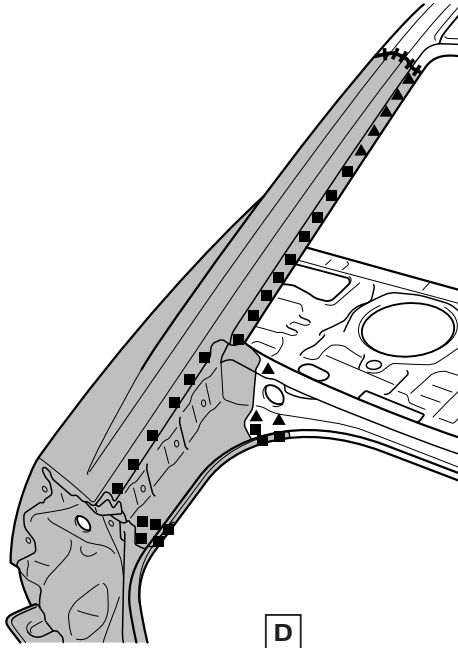
SYMBOL	OPERATION DESCRIPTION
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
++++	MIG spot welding
	MIG arc welding (continuous)
oooooo	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.)

REPAIR WELDS



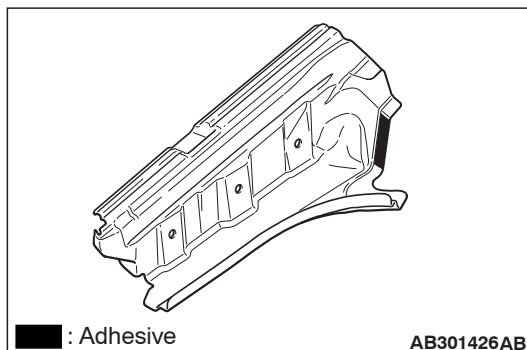
CAUTION

When repairing the area using foam materials do not use firing tools since the foaming materials may burn.



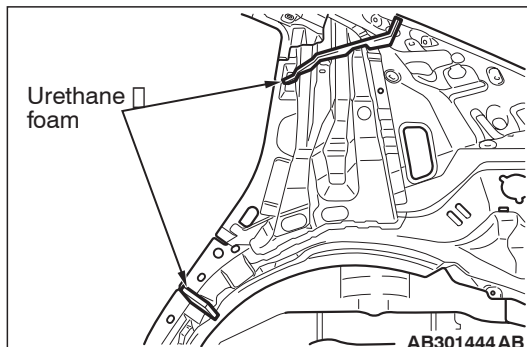
AB301528AB

NOTE ON REPAIR WORK INSTALLATION

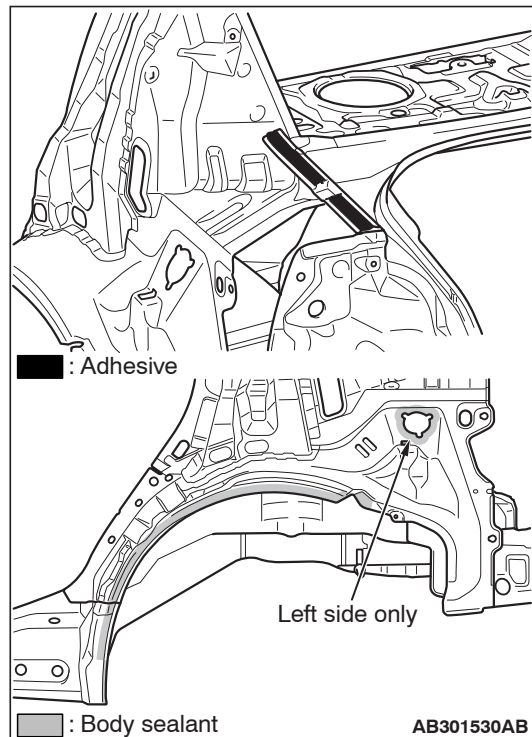


1. Adhere in advance adhesives in the areas shown in the figure of the instructions when assembling the rear quarter outer panel extension.

Adhesive: Epoxyayresin adhesive
Brand: 3M ATD Part No.8115 or equivalent

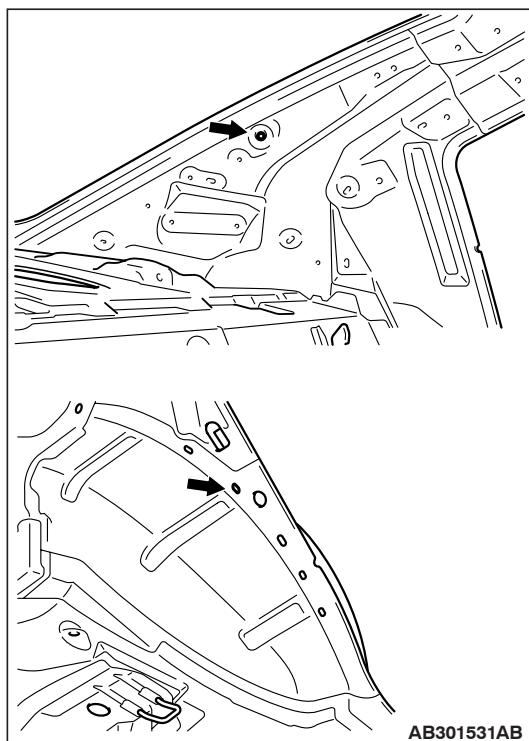


2. When filling the foam materials, to prevent the foam materials from dripping, apply urethane foam to bury the inside of the rear pillar and the wheel arch.



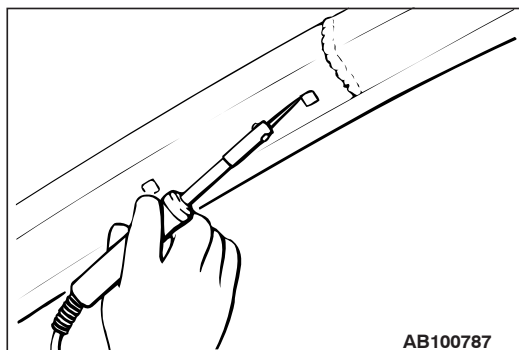
3. When assembling the new rear quarter outer panel parts, apply in advance body sealant and adhesive to the areas shown in the figure of the instructions.

Adhesive: Epoxyayresin adhesive
Brand: 3M ATD Part No.8115 or equivalent



4. Assemble the rear quarter outer panel, bolt and tape the hole and flange with aluminium tape, then fill the hole with foam materials as shown in the figure of the instructions.

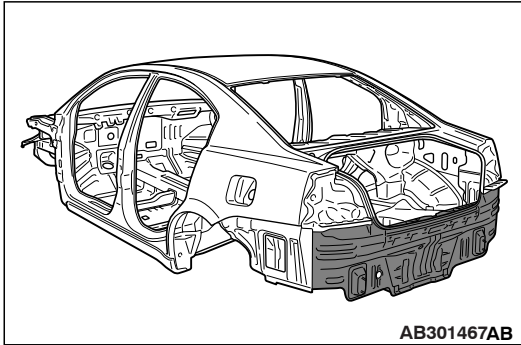
Foam: 3M ATD ULTRAPRO Panel foam-Yellow



5. Wait 2 hours after filling the foam materials to remove the bolt and aluminium tape. Then melt the foam materials with a soldering gun so a clip, etc. can thoroughly be inserted in the hole that was clogged with foam materials, to bore open the hole.

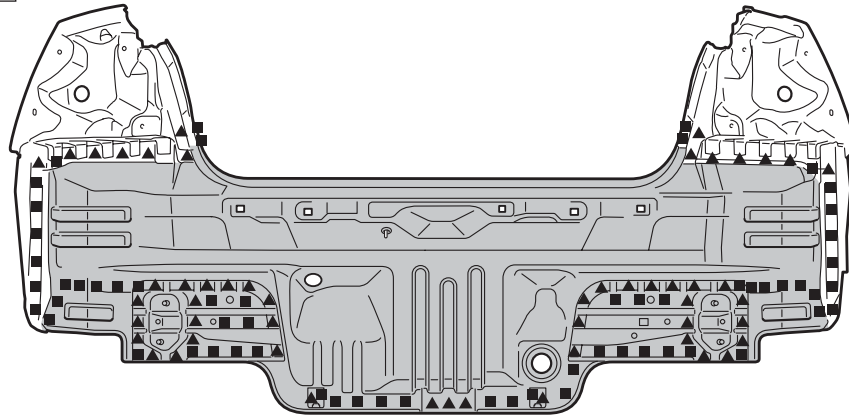
REAR END PANEL

M4030009000227



SYMBOL	OPERATION DESCRIPTION
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
++++	MIG spot welding
	MIG arc welding (continuous)
ooooo	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.)

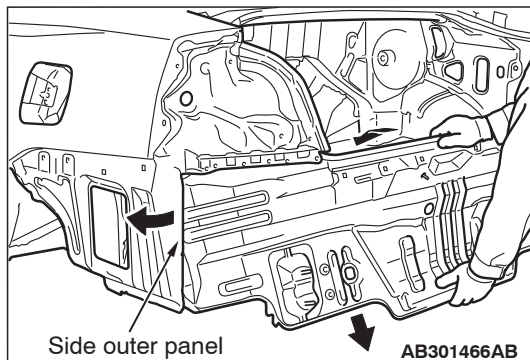
REPAIR WELDS



AB501144AB

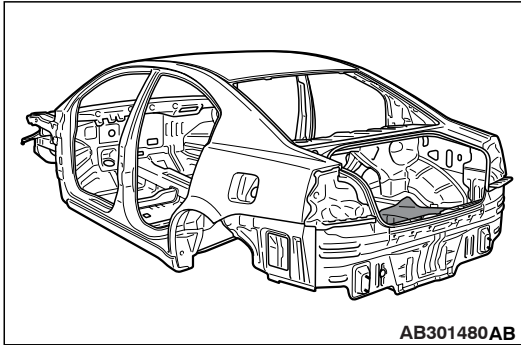
NOTE ON REPAIR WORK REMOVAL

When removing the rear end panel, slant the top of rear end panel toward the cabin side and pull out the rear end panel in the bottom direction. If it is difficult to remove the rear end panel, spread the side outer panel slightly.



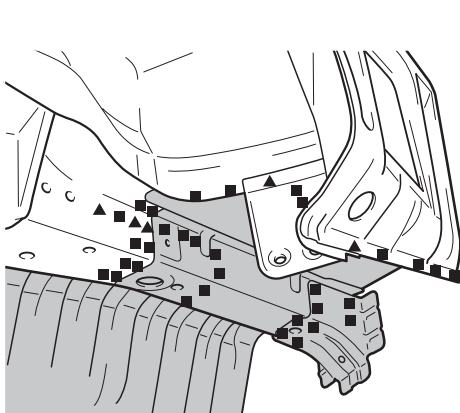
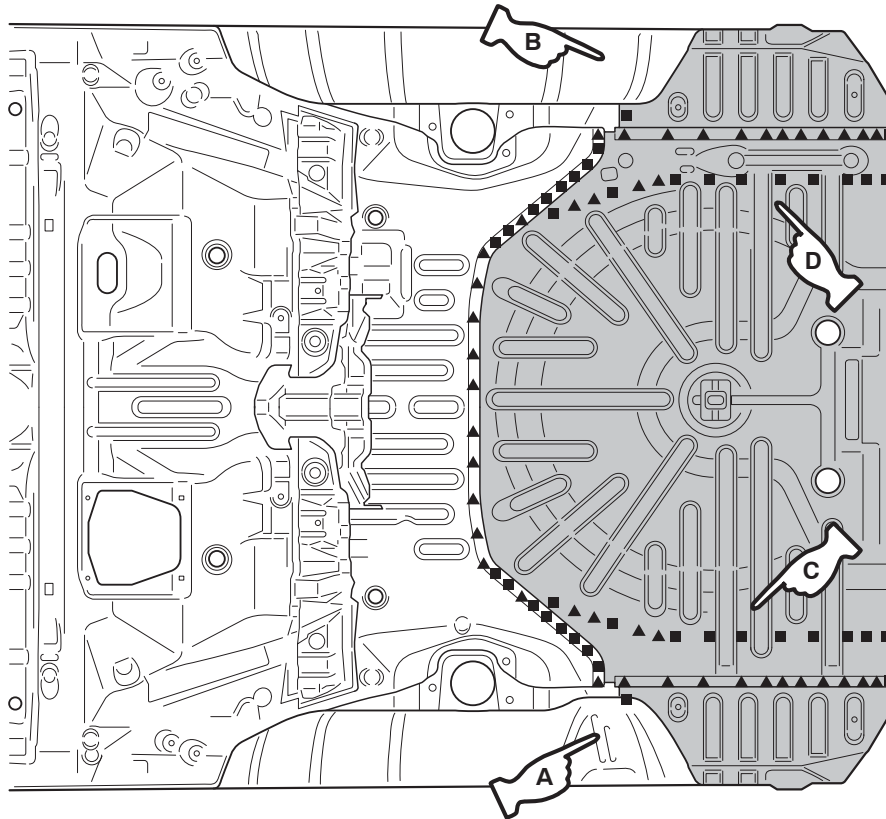
REAR FLOOR

M4030010000544

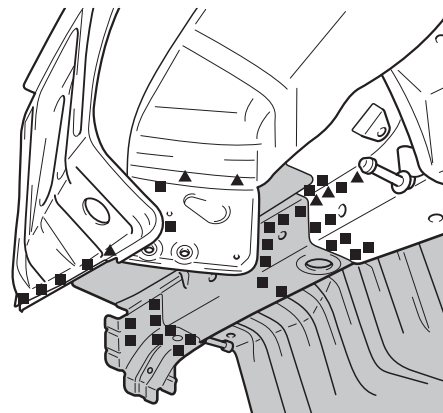


SYMBOL	OPERATION DESCRIPTION
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
++++	MIG spot welding
	MIG arc welding (continuous)
ooooooo	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.)

REPAIR WELDS



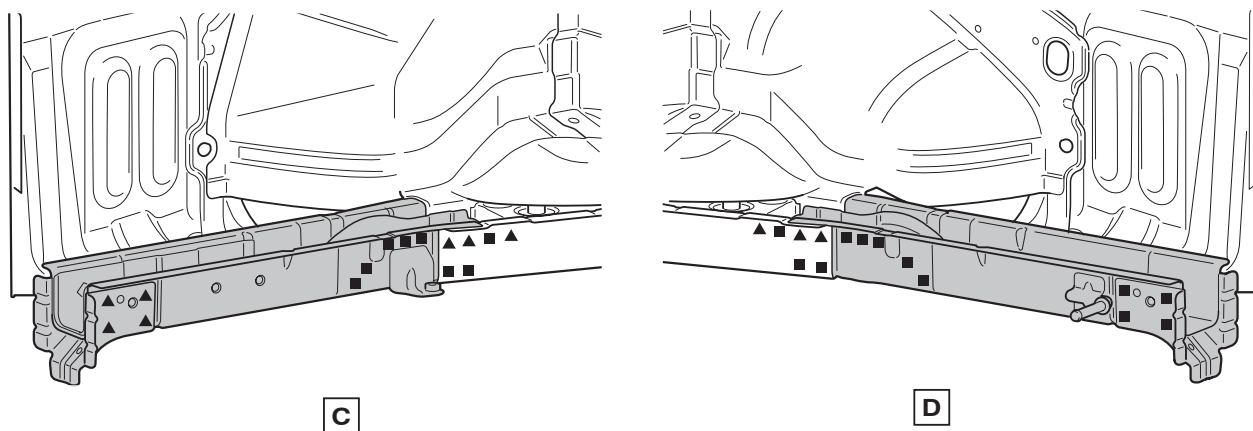
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B

AB501592AB

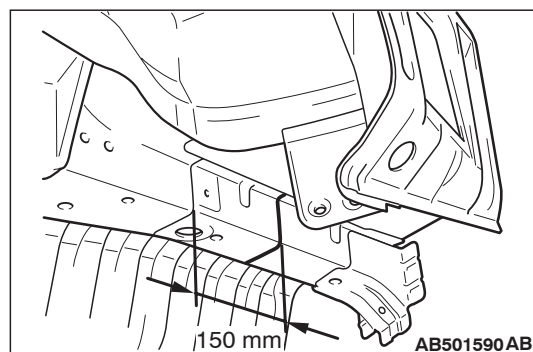
NOTE: Refer to the Rear End Panel section on [P.3-25](#) for the welding points with the rear end panel.



(With the rear floor panel rear removed)

AB501593AB

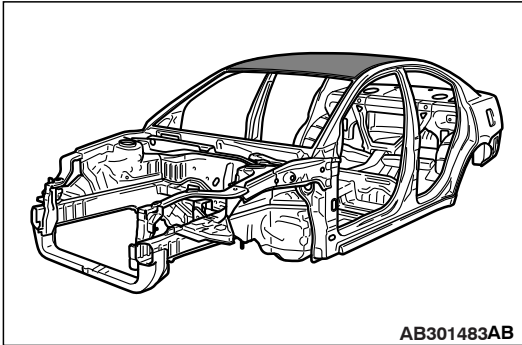
NOTE ON REPAIR WORK REMOVAL



When removing the rear floor side member extension without removing the rear floor panel rear, cut it 150 mm behind the rear edge of the rear floor side member to remove.

ROOF

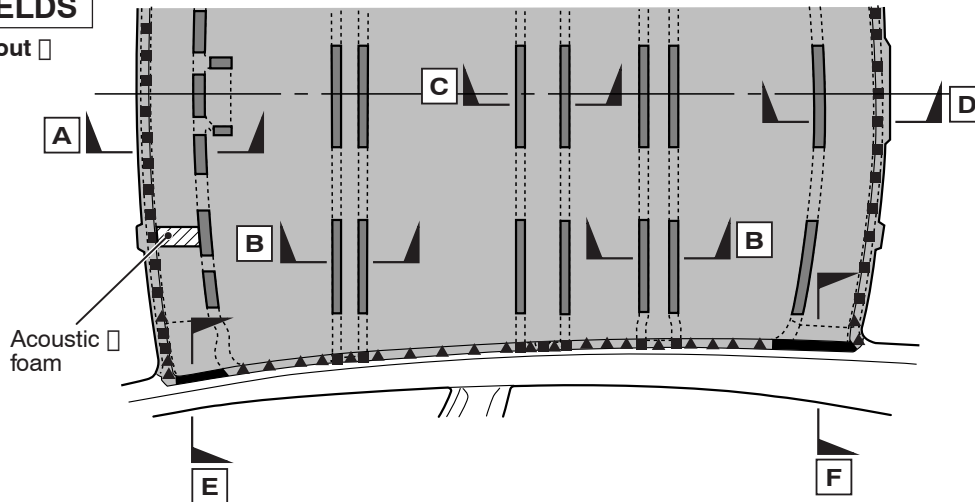
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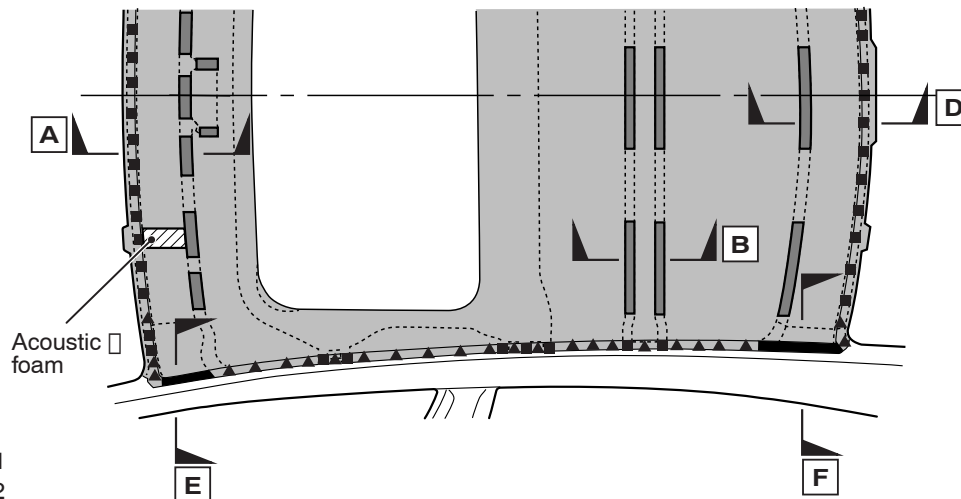
SYMBOL	OPERATION DESCRIPTION
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
++++	MIG spot welding
	MIG arc welding (continuous)
oooooo	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.)

REPAIR WELDS

Vehicles without
sunroof



Vehicles with
sunroof



■ : Adhesive 1
■ : Adhesive 2

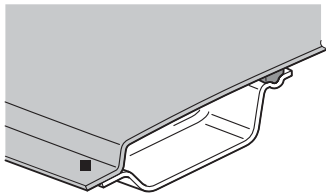
AB301525AB

• Adhesive 1: Urethane body sealer
Brand: 3M ATD Part No.8542 or equivalent

• Adhesive 2: Epoxyayresin adhesive
Brand: 3M ATD Part No.8115 or equivalent

CAUTION

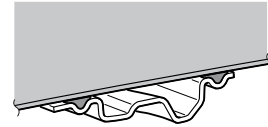
When repairing the area using foam materials do not use firing tools since the foaming materials may burn.



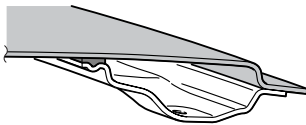
A



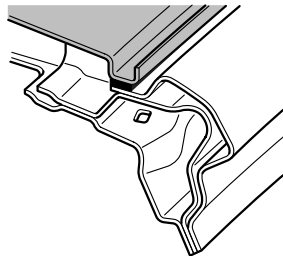
B



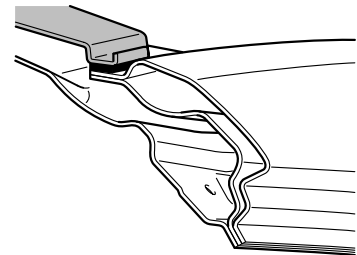
C



D



E

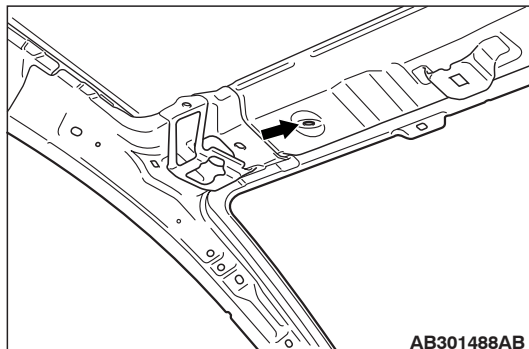


F

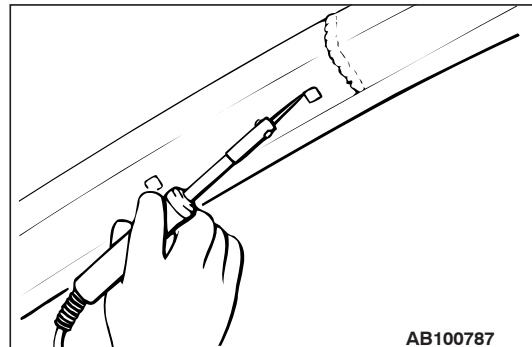
AB301526AB

**NOTE ON REPAIR WORK
INSTALLATION**

FOAM: 3M ATD ULTRAPRO Panel foam-Yel-low



AB301488AB

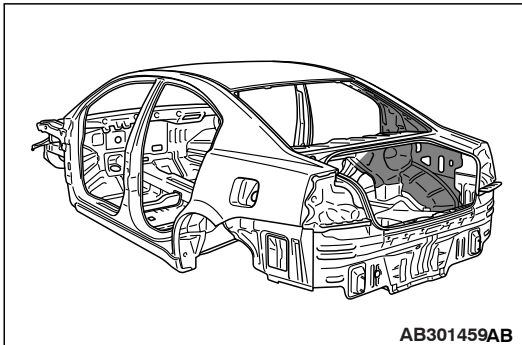


AB100787

1. Assemble the roof panel, bolt and tape the hole and flange with aluminium tape, then fill the hole with foam materials as shown in the figure of the instructions.
2. Wait 2 hours after filling the foam materials to remove the bolt and aluminium tape, then melt the foam materials with a soldering gun so a clip, etc. can thoroughly be inserted in the hole filled with foam materials.

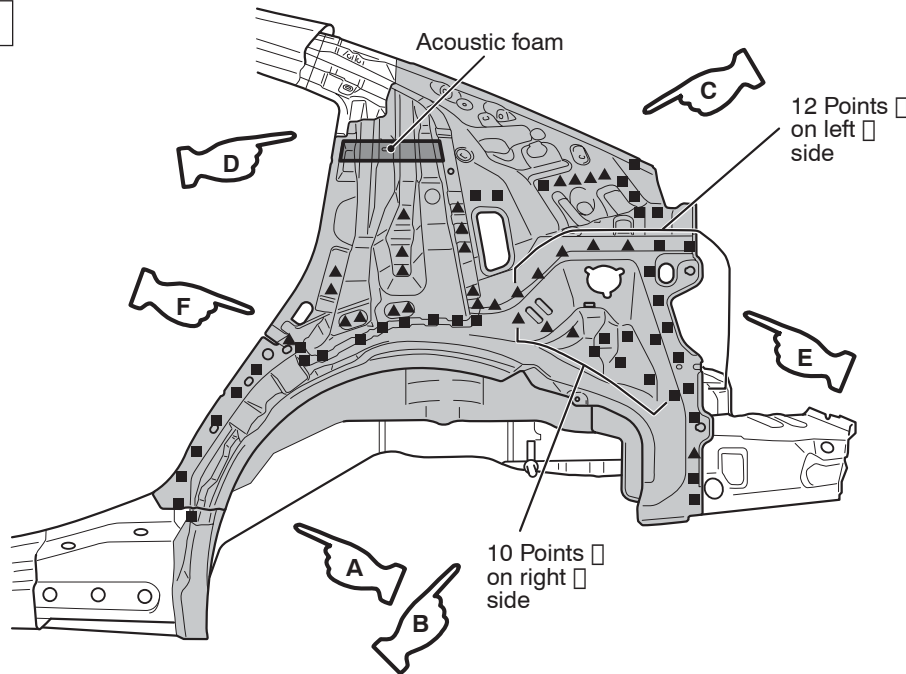
M4030012000498

QUARTER INNER

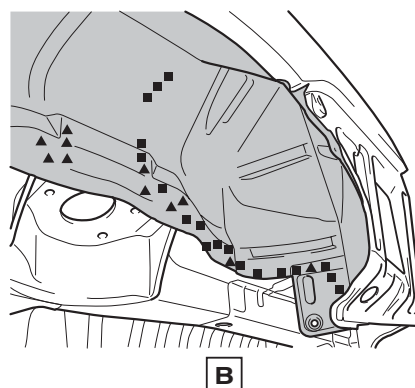
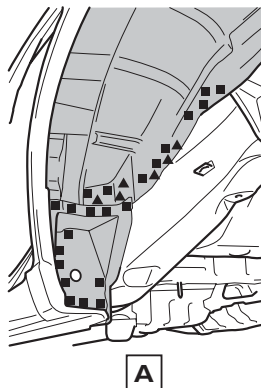


SYMBOL	OPERATION DESCRIPTION
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
++++	MIG spot welding
	MIG arc welding (continuous)
○○○○○○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.)

REPAIR WELDS



(With the quarter outer removed)

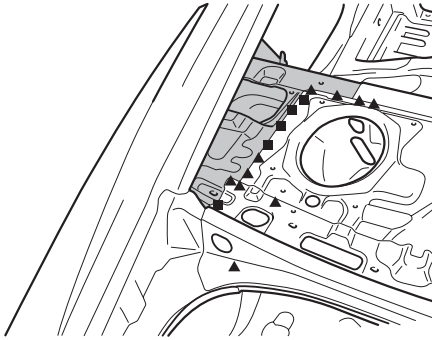


AB301532AB

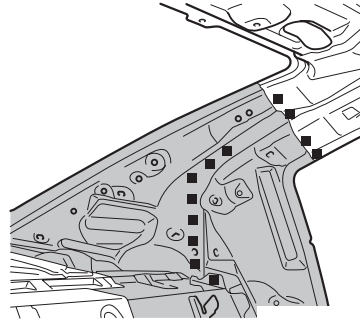
CAUTION

When repairing the area using foam materials do not use firing tools since the foaming materials may burn.

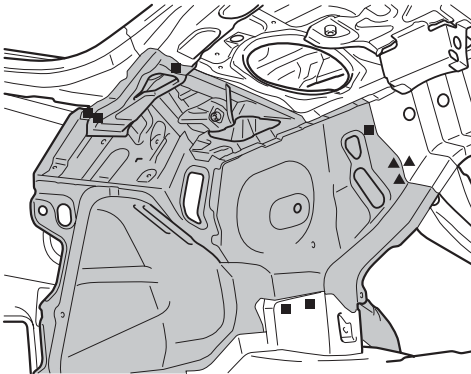
NOTE: Refer to the Quarter Outer section on [P.3-22](#) for the welding points with the quarter outer.



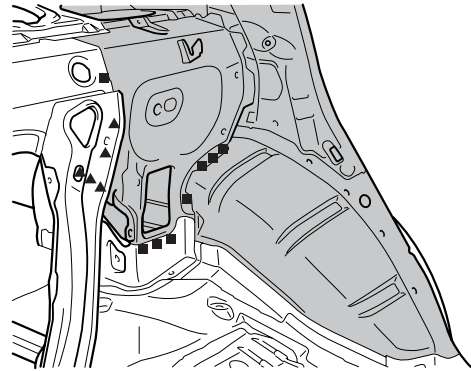
C



D



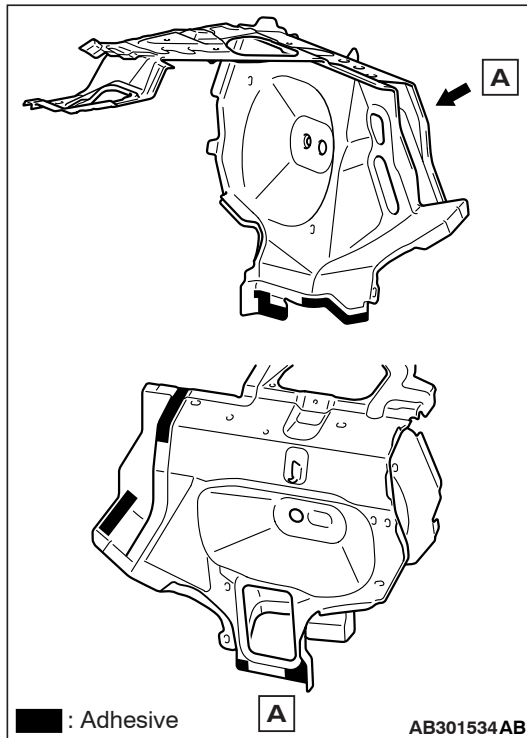
E



F

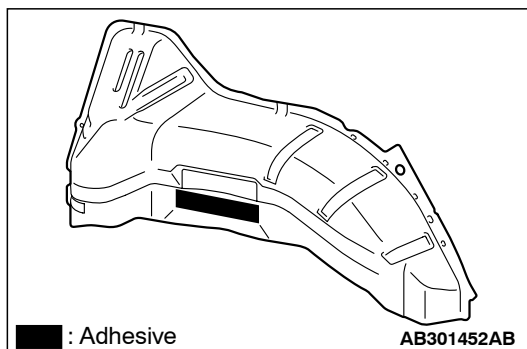
AB301533AB

NOTE ON REPAIR WORK INSTALLATION



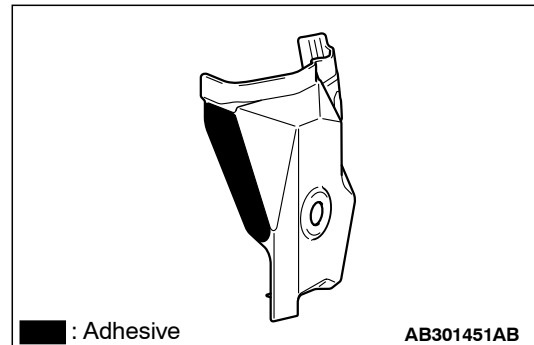
1. Adhere in advance adhesives in the areas shown in the figure of the instructions when assembling the rear seat back brace.

Adhesive: Epoxyayresin adhesive
Brand: 3M ATD Part No.8115 or equivalent



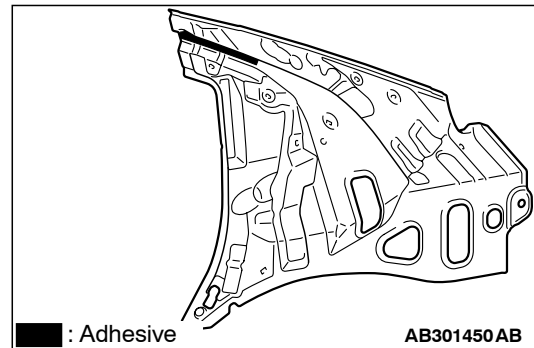
2. Adhere in advance adhesives in the areas shown in the figure of the instructions when assembling the rear wheelhouse panel inner.

Adhesive: Epoxyayresin adhesive
Brand: 3M ATD Part No.8115 or equivalent



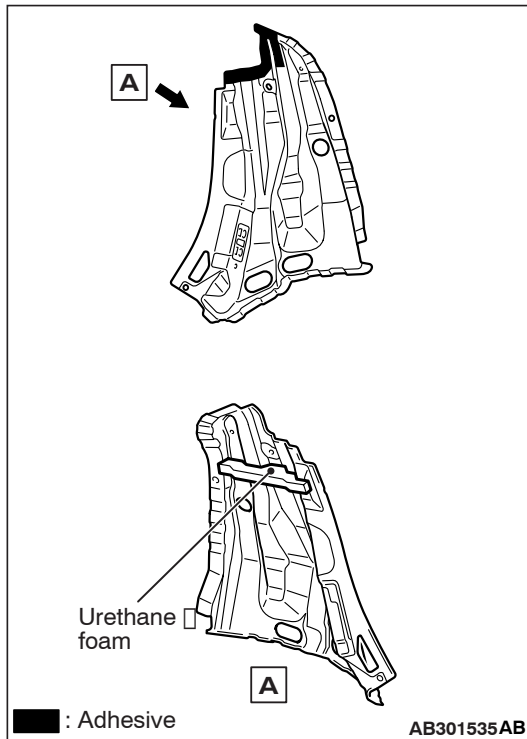
3. Adhere in advance adhesives in the areas shown in the figure of the instructions when assembling the rear wheelhouse shield plate front.

Adhesive: Epoxyayresin adhesive
Brand: 3M ATD Part No.8115 or equivalent



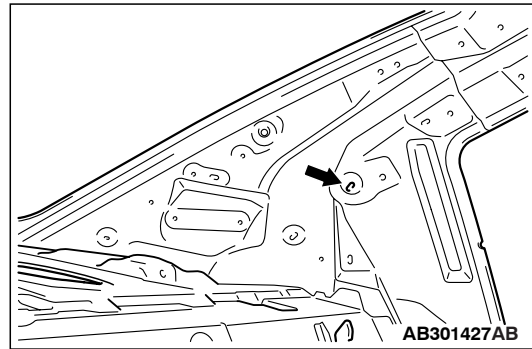
4. Adhere in advance adhesives in the areas shown in the figure of the instructions when assembling the rear quarter inner panel upper.

Adhesive: Epoxyayresin adhesive
Brand: 3M ATD Part No.8115 or equivalent



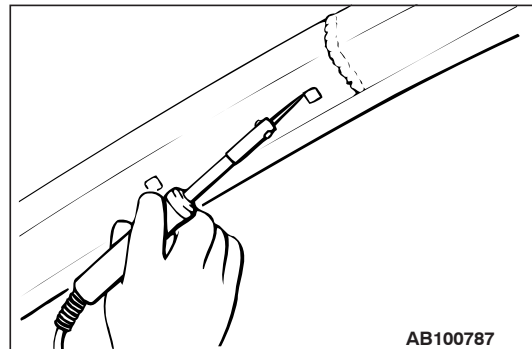
5. Adhere in advance adhesives in the areas shown in the figure of the instructions when assembling the new rear pillar reinforcement parts. To prevent the foam materials from dripping, apply urethane foam to bury the inside of the rear pillar reinforcement.

Adhesive: Epoxyayresin adhesive
Brand: 3M ATD Part No.8115 or equivalent



6. Assemble the rear pillar reinforcement, bolt and tape the hole and flange with aluminium tape, then fill the hole with foam materials as shown in the figure of the instructions.

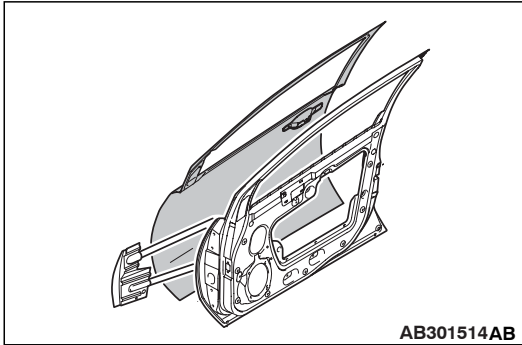
Foam: 3M ATD ULTRAPRO Panel foam-Yellow



7. Wait 2 hours after filling the foam materials to remove the bolt and aluminium tape. Then melt the foam materials with a soldering gun so a clip, etc. can thoroughly be inserted in the hole that was clogged with foam materials, to bore open the hole.

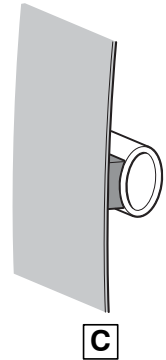
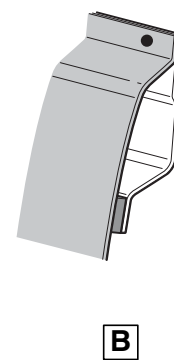
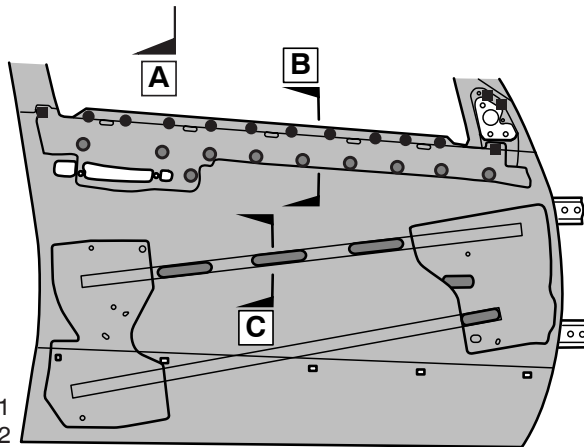
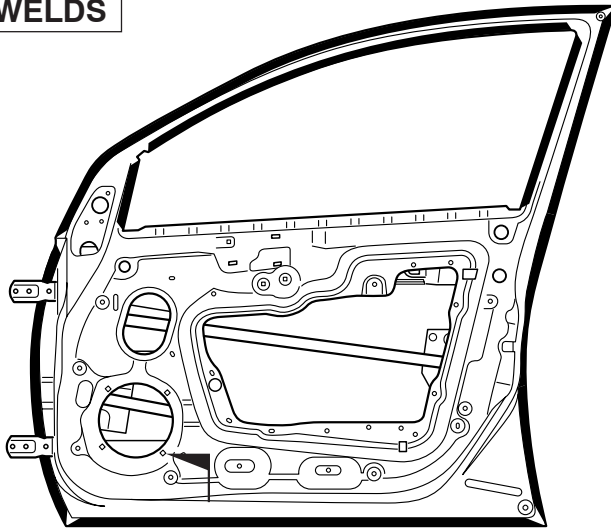
FRONT DOOR OUTER PANEL (ADHESION TYPE)

M4030001700114



SYMBOL	OPERATION DESCRIPTION
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
++++	MIG spot welding
	MIG arc welding (continuous)
○○○○○○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.)

REPAIR WELDS



AB501594AB

■ : Adhesive 1
■ : Adhesive 2

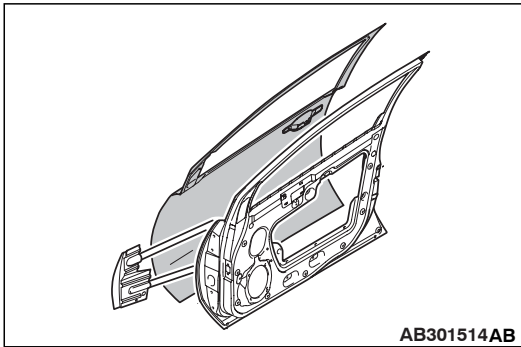
- **Adhesive 1: Epoxyayresin adhesive**
Brand: 3M ATD Part No.8115 or equivalent
- **Adhesive 2: Urethane body sealer**
Brand: 3M ATD Part No.8542 or equivalent

NOTE ON REPAIR WORK INSTALLATION

1. When installing the front door outer panel, grind the bonding surface and remove the paint to improve adhesion. Then, degrease the front door outer panel.
2. Install the front door outer panel and hem it. Then, wipe off the adhesive that squeezed out.

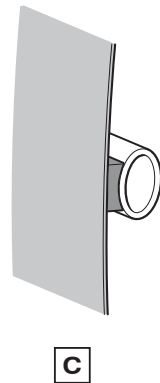
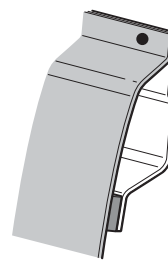
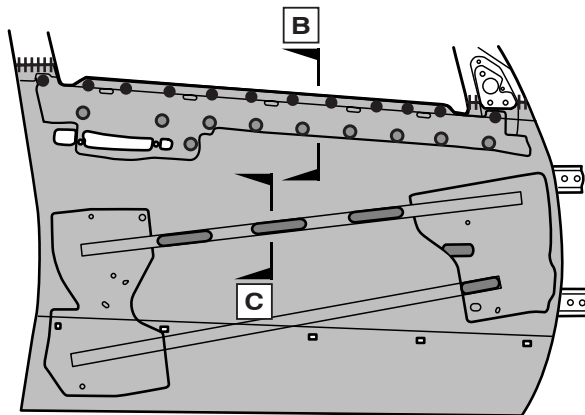
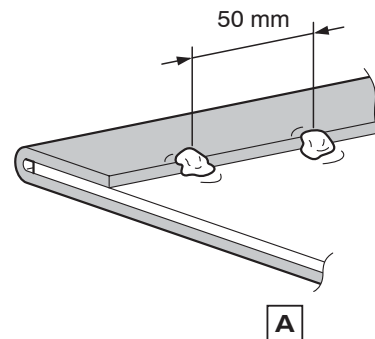
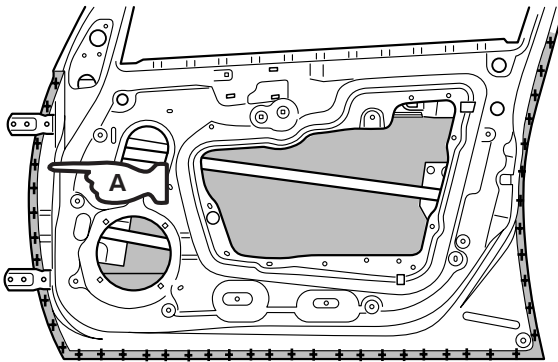
FRONT DOOR OUTER PANEL (WELDED TYPE)

M4030001500110



SYMBOL	OPERATION DESCRIPTION
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
++++	MIG spot welding
	MIG arc welding (continuous)
○○○○○○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.)

REPAIR WELDS



: Adhesive

AB301511AB

Adhesive: Urethane body sealer

Brand: 3M ATD Part No.8542 or equivalent

NOTE: After hemming the front door outer panel, MIG spot weld the flange overlap section at a pitch of 50 mm.

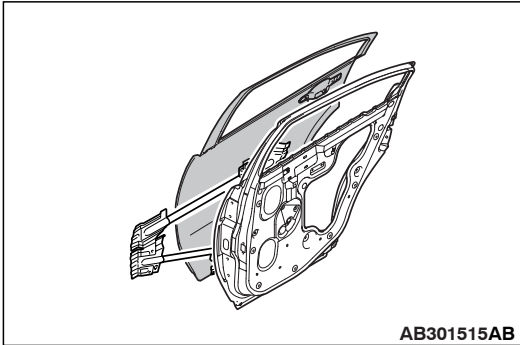
NOTE ON REPAIR WORK

REMOVAL

Since it is difficult to replace the sash due to a pressed door structure, cut the outer panel from the bottom of the sash.

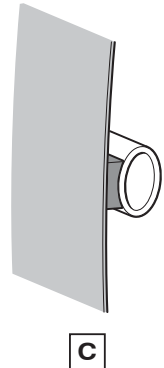
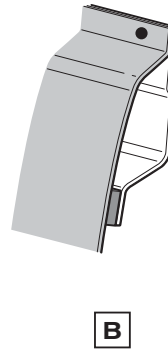
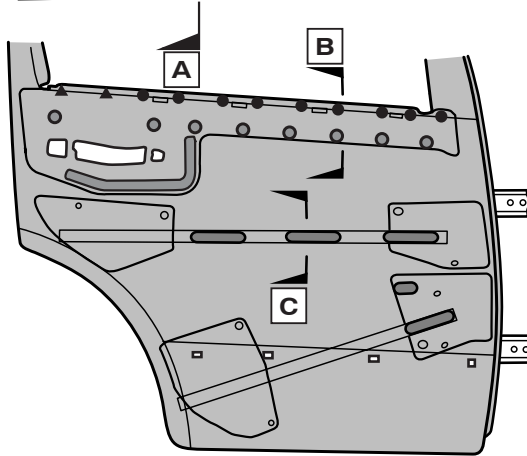
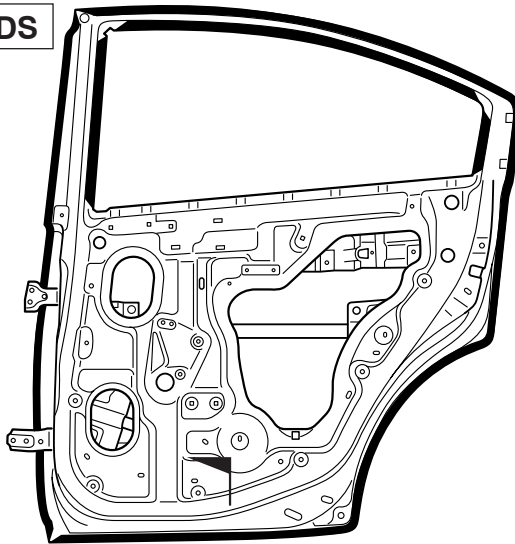
REAR DOOR OUTER PANEL (ADHESION TYPE)

M4030001800081



SYMBOL	OPERATION DESCRIPTION
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
++++	MIG spot welding
	MIG arc welding (continuous)
○○○○○○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.)

REPAIR WELDS



AB501595AB

■ : Adhesive 1
■ : Adhesive 2

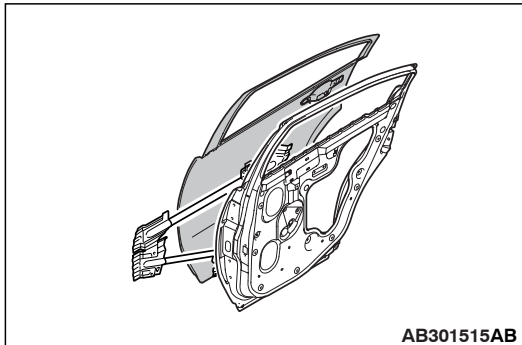
- Adhesive 1: Epoxyayresin adhesive
Brand: 3M ATD Part No.8115 or equivalent
- Adhesive 2: Urethane body sealer
Brand: 3M ATD Part No.8542 or equivalent

NOTE ON REPAIR WORK INSTALLATION

1. When installing the rear door outer panel, grind the bonding surface and remove the paint to improve adhesion. Then, degrease the rear door outer panel.
2. Install the rear door outer panel and hem it. Then, wipe off the adhesive that squeezed out.

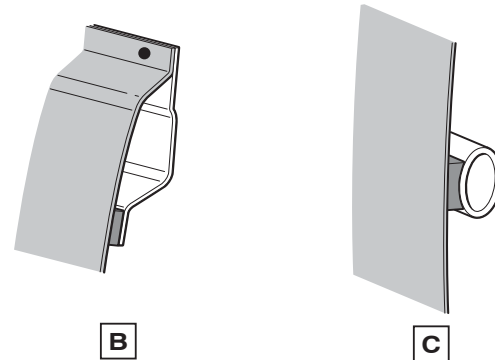
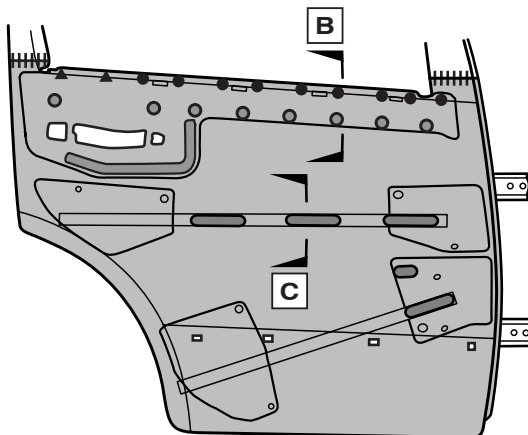
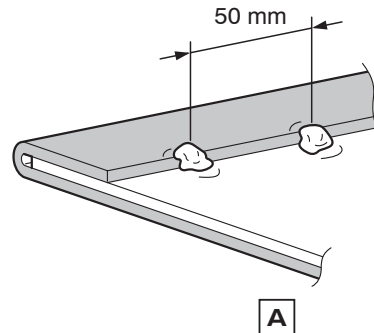
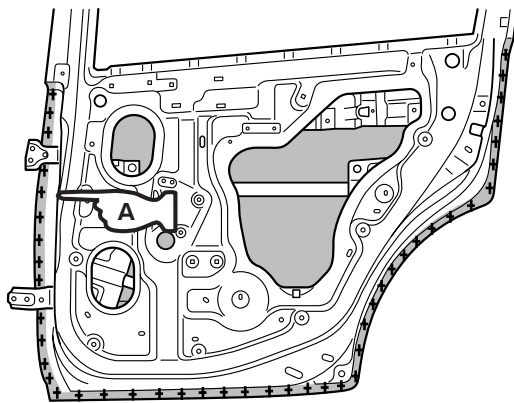
REAR DOOR OUTER PANEL (WELDED TYPE)

M4030001600076



SYMBOL	OPERATION DESCRIPTION
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
++++	MIG spot welding
	MIG arc welding (continuous)
○○○○○○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.)

REPAIR WELDS



■ : Adhesive

AB501693AB

Adhesive: Urethane body sealer

Brand: 3M ATD Part No.8542 or equivalent

NOTE: After hemming the rear door outer panel, MIG spot weld the flange overlap section at a pitch of 50 mm.

NOTE ON REPAIR WORK

REMOVAL

Since it is difficult to replace the sash due to a pressed door structure, cut the outer panel from the bottom of the sash.