

GROUP 3

WELDED PANEL
REPLACEMENT

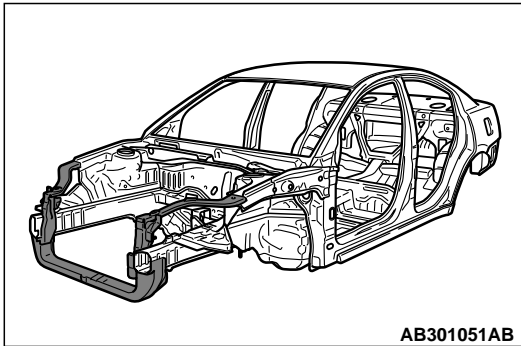
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NOTES

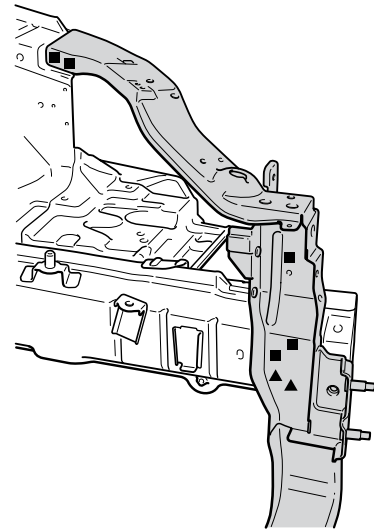
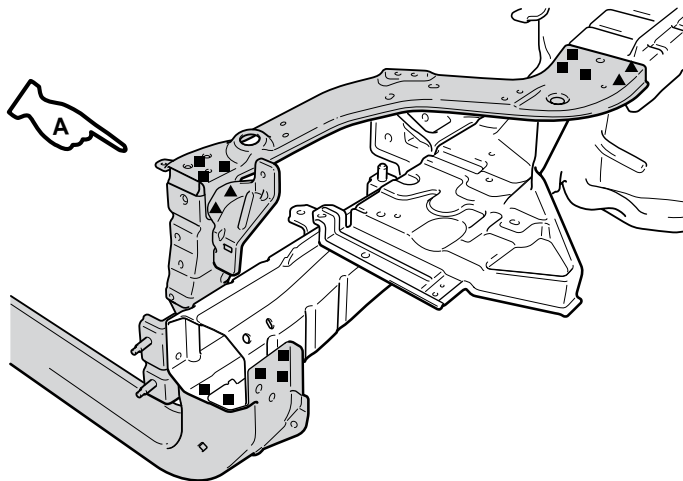
HEADLIGHT SUPPORT

M4030003000177



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.)

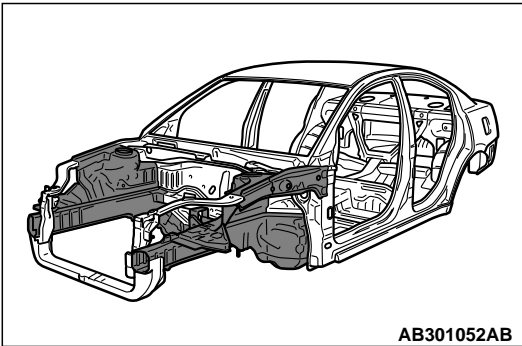
REPAIR WELDS




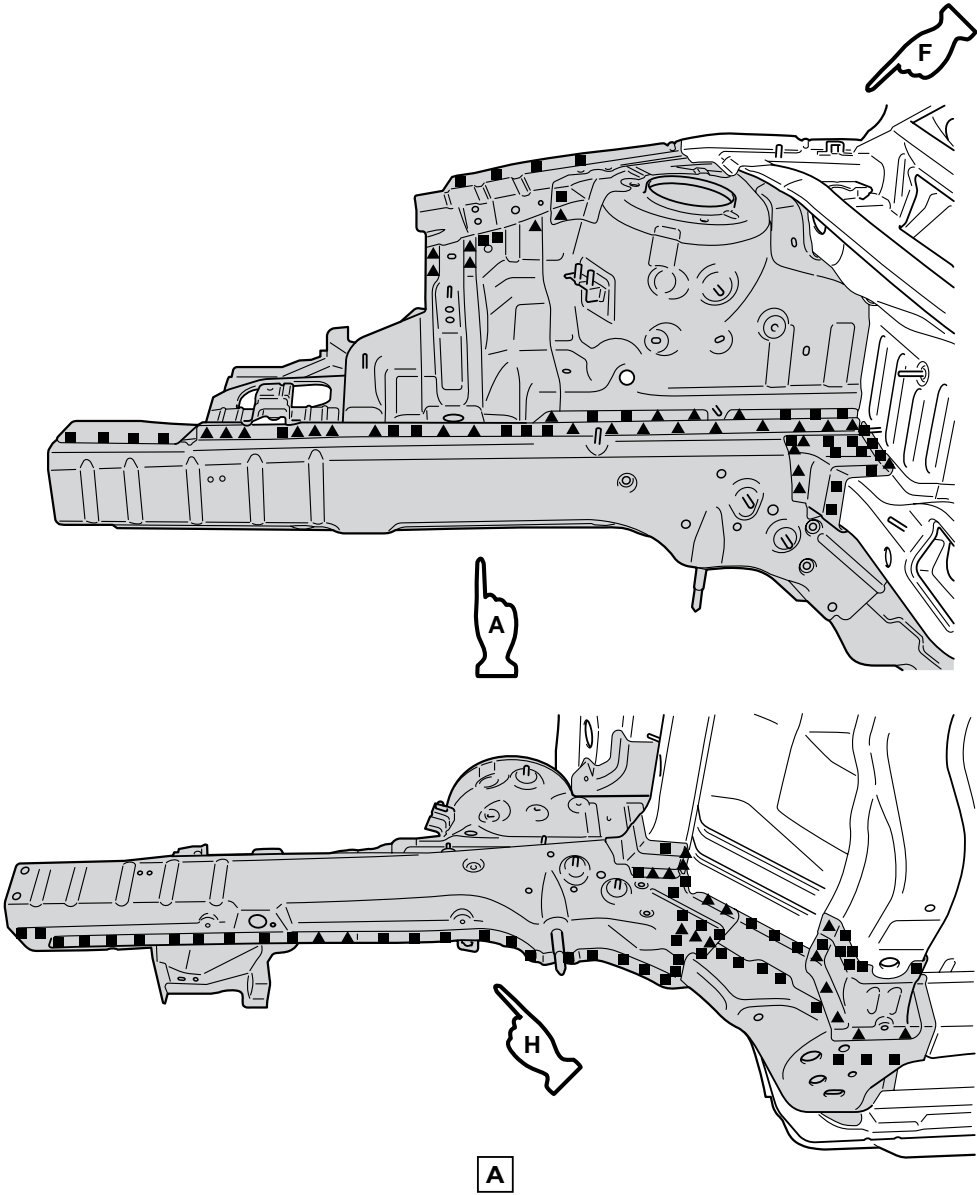
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FENDER SHIELD

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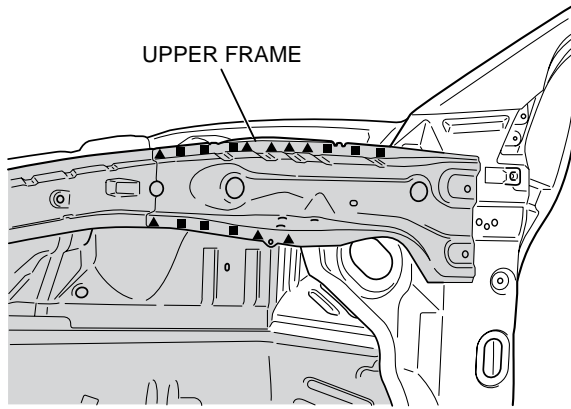


SYMBOL	OPERATION DESCRIPTION
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■ : indicates two panels to be welded ▲ : indicates three panels to be welded)
+ + + +	MIG spot welding
	MIG arc welding (continuous)
○ ○ ○ ○ ○ ○ ○ ○	Braze welding
	Anti-corrosion agent application locations (Use access holes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

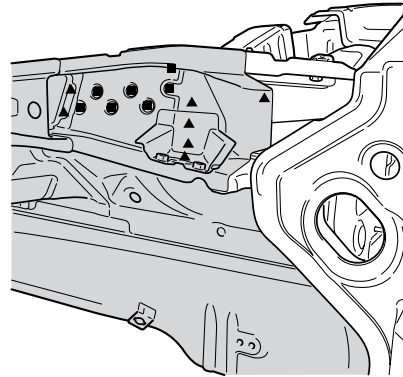


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NOTE: Refer to the Headlight Support Section on [P.3-3](#) for the welding point with headlight support.

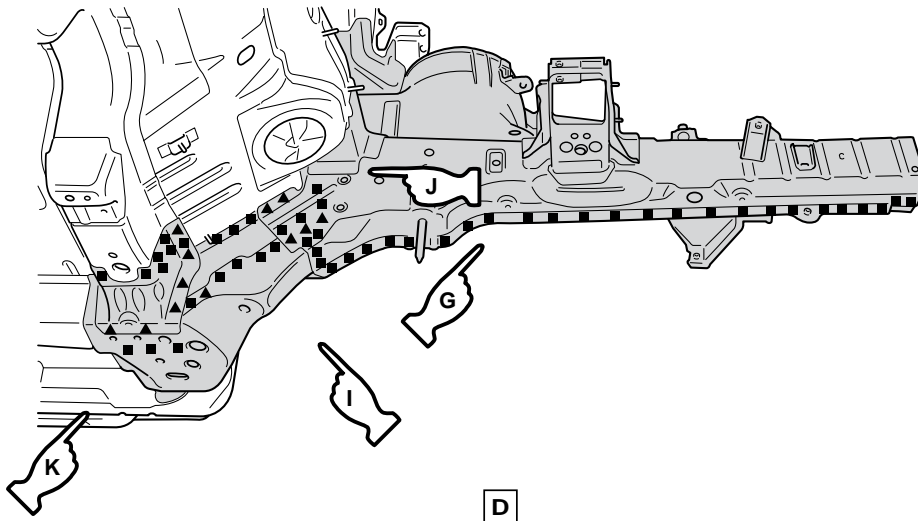
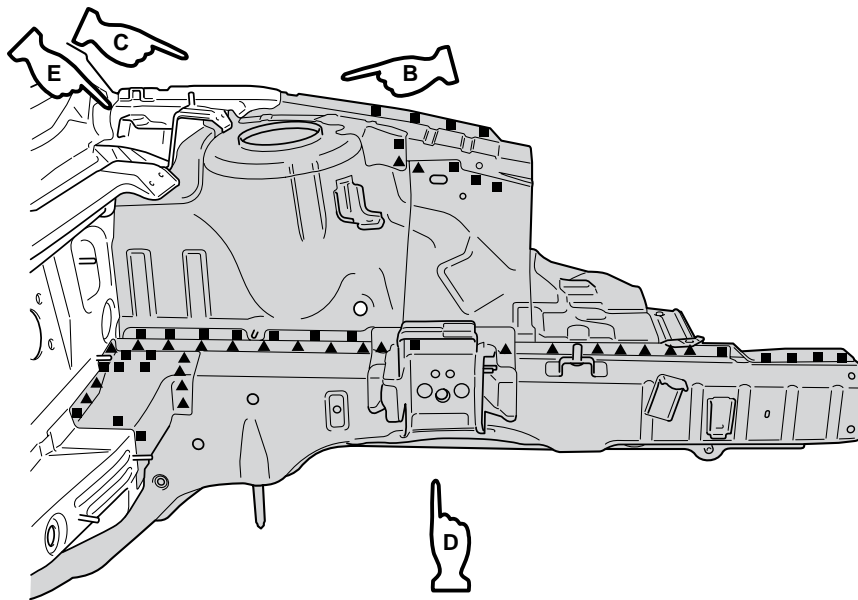


B

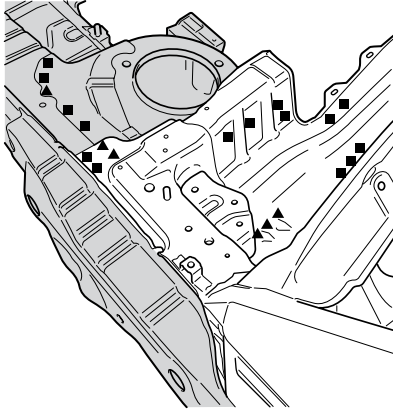
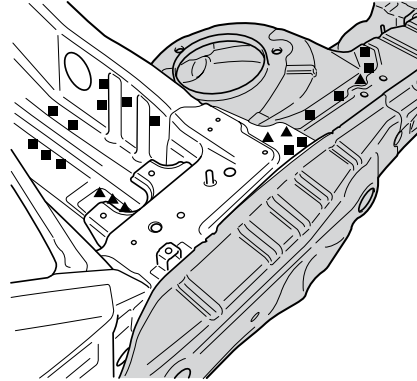
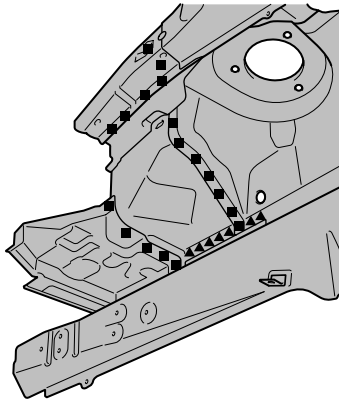
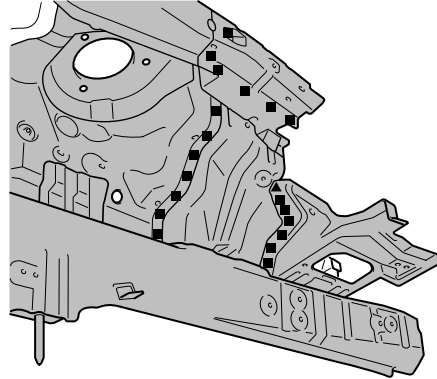
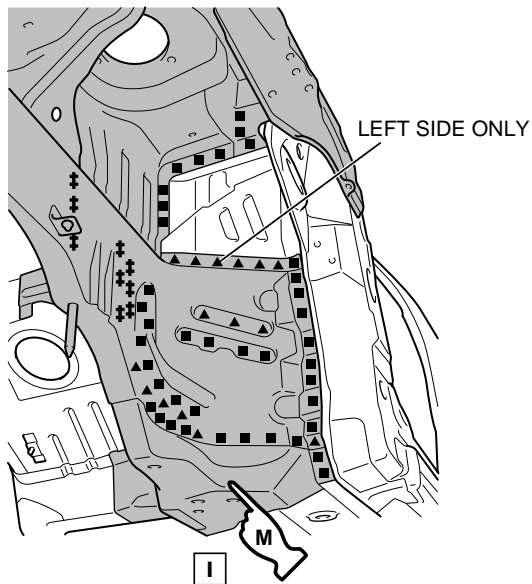
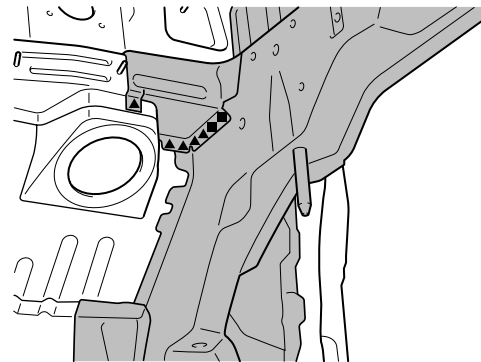


C

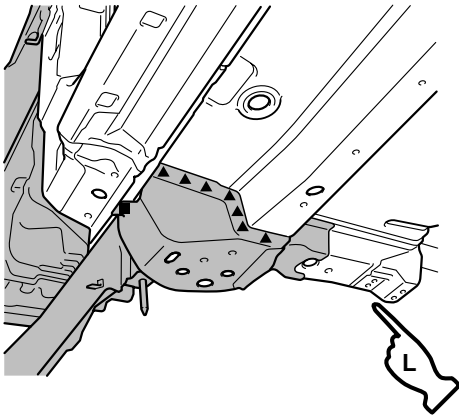
(WITH THE UPPER FRAME REMOVED)



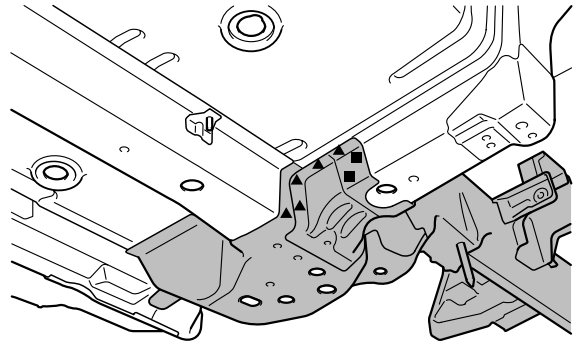
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**E****F****G****H****I****J****(LEFT SIDE ONLY)**

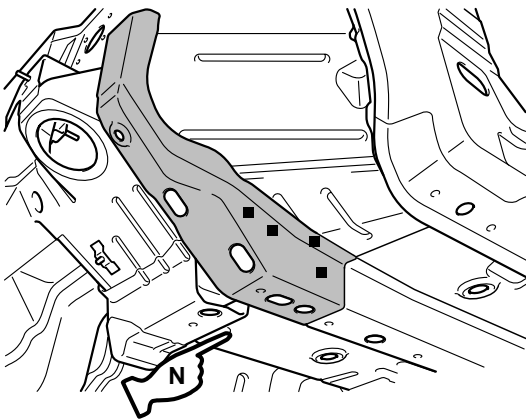
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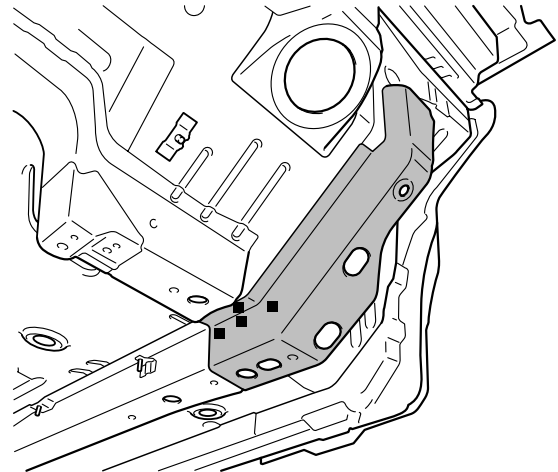
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L



M



N

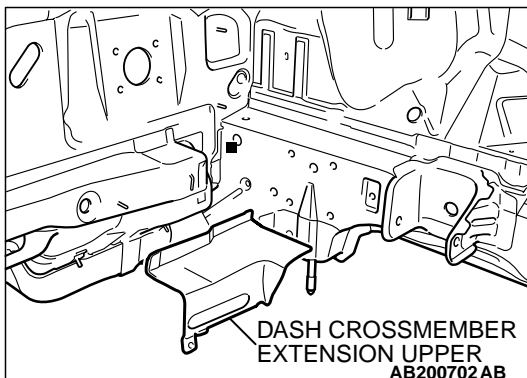
(WITH THE FRONT SIDEMEMBER REMOVED)

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NOTE ON REPAIR WORK

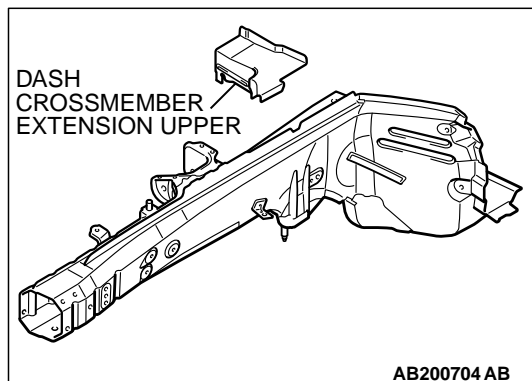
REMOVAL

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



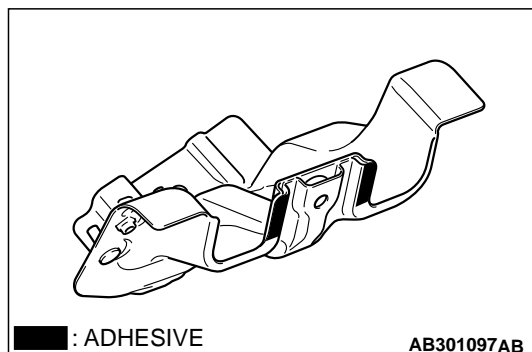
INSTALLATION

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



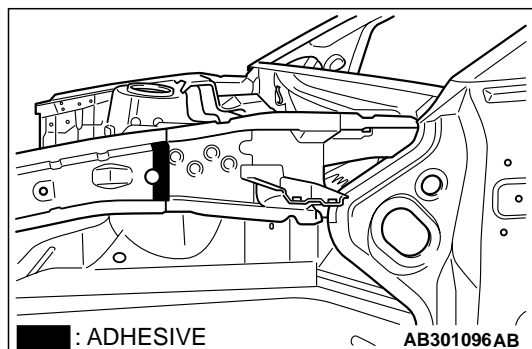
2. Adhere in advance adhesives in the areas shown in the figure of the instructions when assembling the front fender shield.

ADHESIVE	TYPE	BRAND
	Epoxyayresin adhesive	3M™ AAD Part No.8115 or equivalent



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

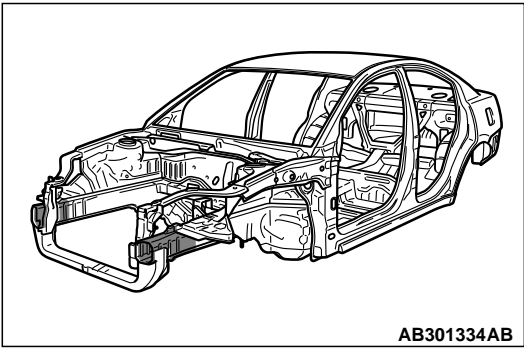
ADHESIVE	TYPE	BRAND
	Epoxyayresin adhesive	3M™ AAD Part No.8115 or equivalent



NOTES

FRONT SIDEMEMBER (PARTIAL REPLACEMENT)

M4030000100108

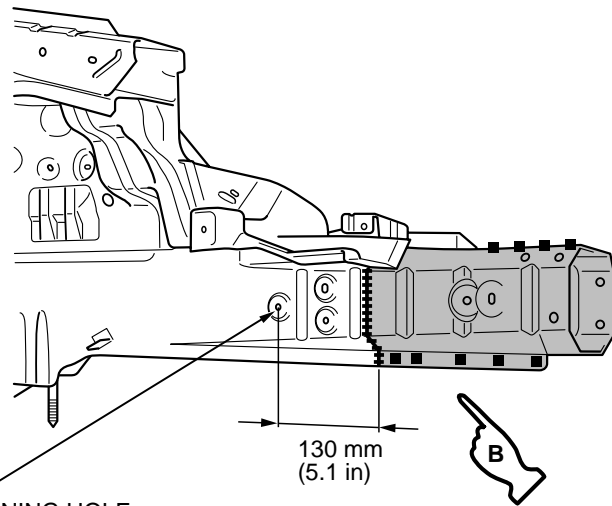
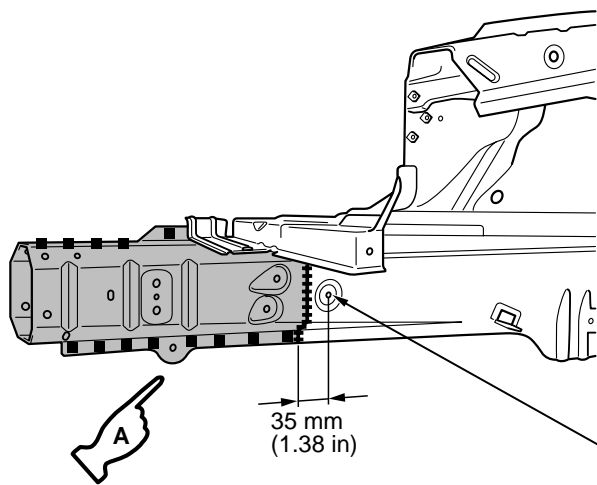


SYMBOL	OPERATION DESCRIPTION
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
++++	MIG spot welding
	MIG arc welding (continuous)
oooo	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally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

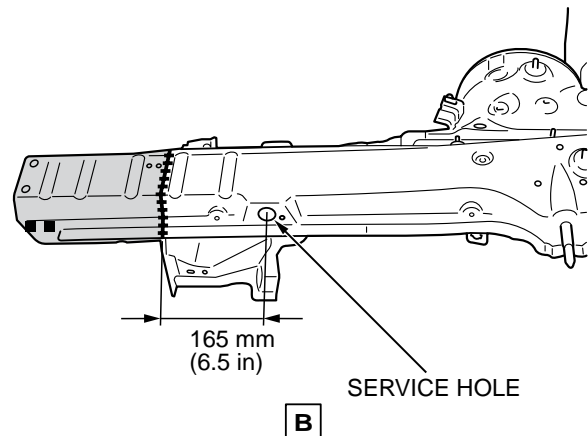
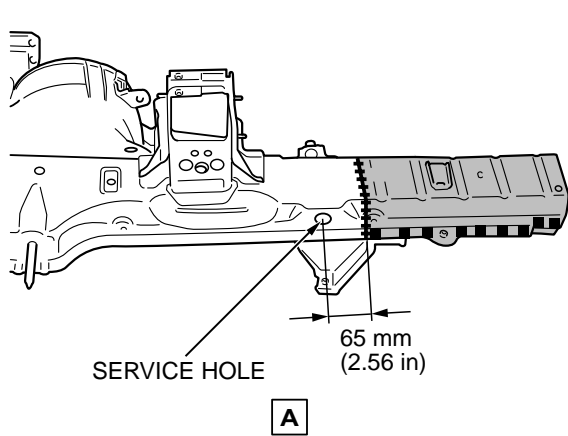
REPAIR WELDS

LEFT SIDE

RIGHT SIDE



WATER DRAINING HOLE



AB301335AB

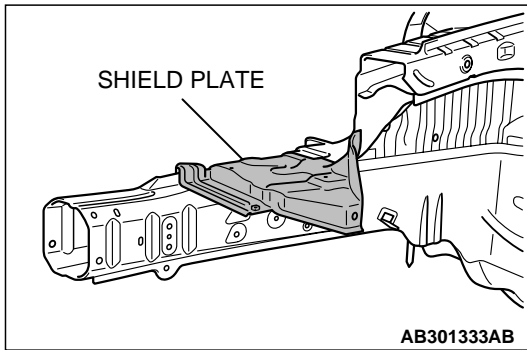
NOTE: Refer to the Headlight Support Section on [P.3-3](#) for the welding point with headlight support.

NOTE ON REPAIR WORK

REMOVAL

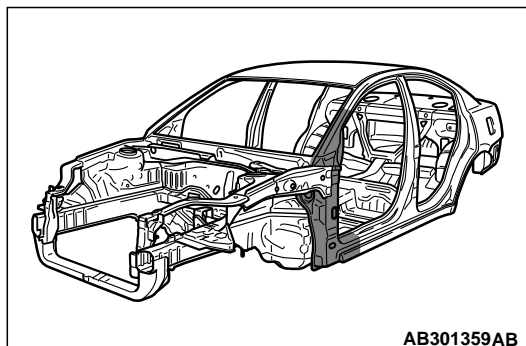
Remove the shield plate on the cut area in advance when cutting the front sidemember.

NOTE: Refer to the Fender Shield Section on [P.3-4](#) for the welding points with the shield plate.



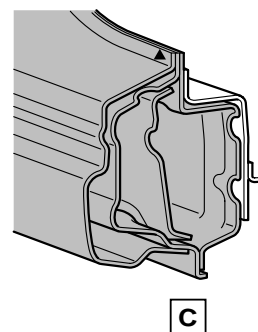
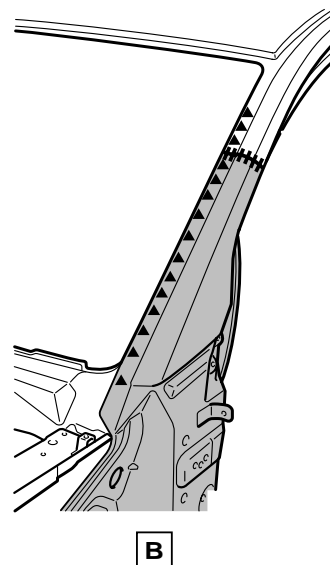
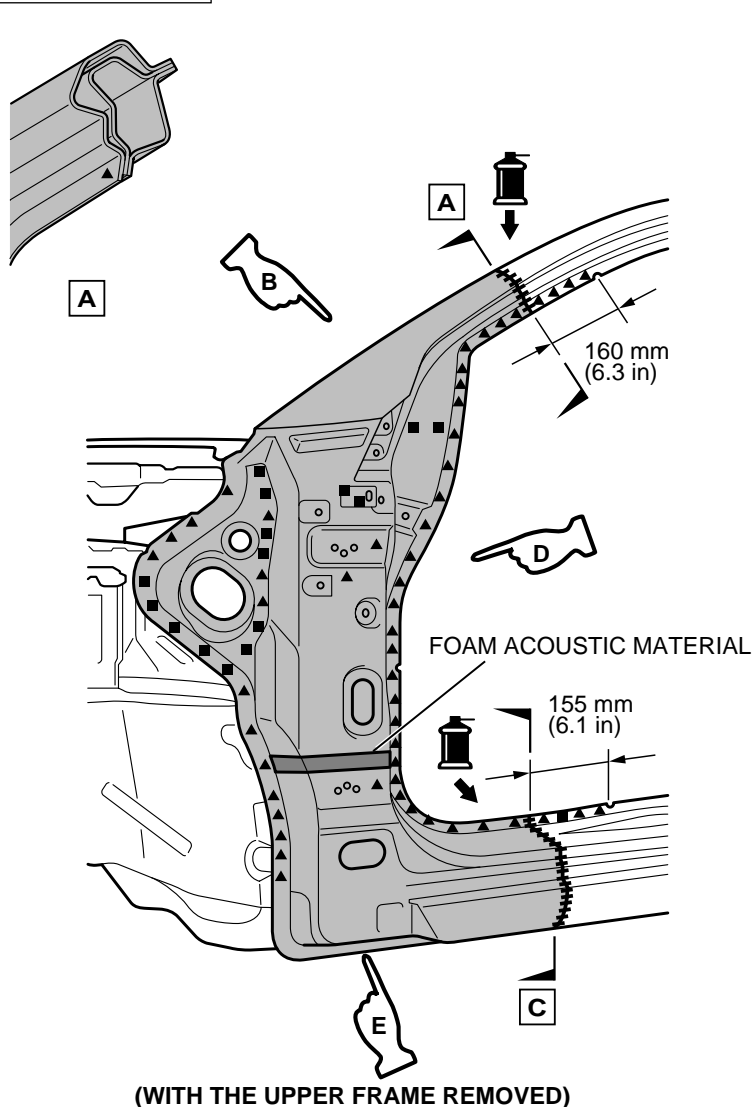
FRONT PILLAR

M4030005000225



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

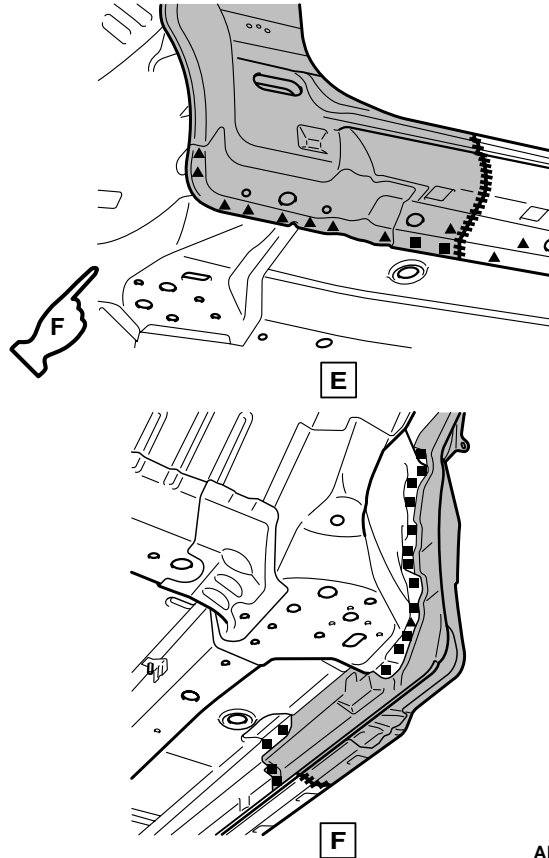
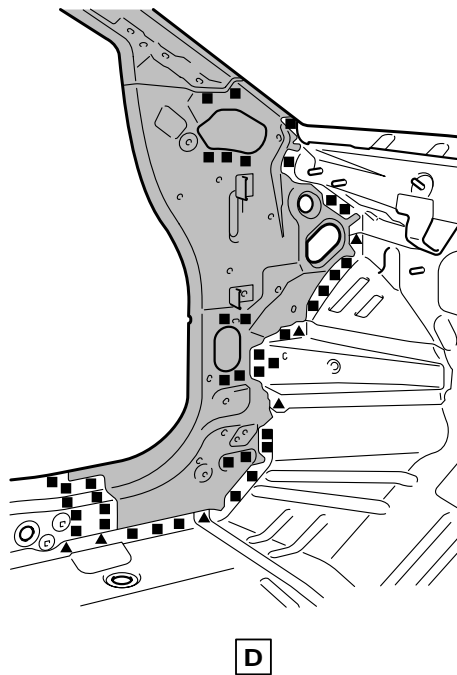


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CAUTION

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.3-4](#) for the welding points with the upper frame.

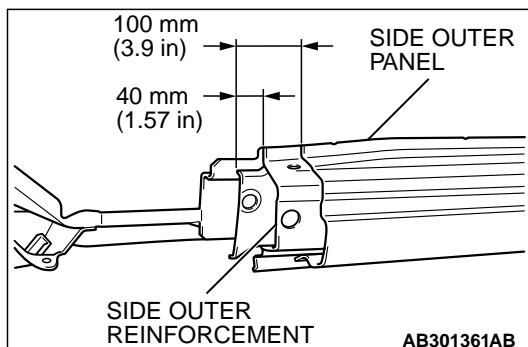
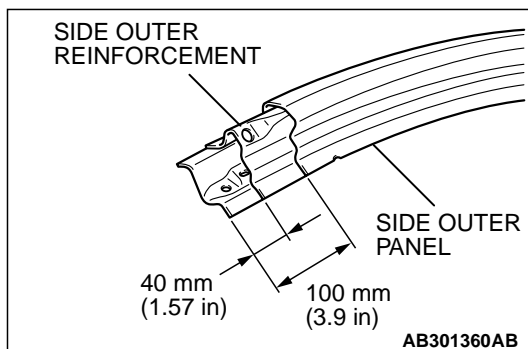


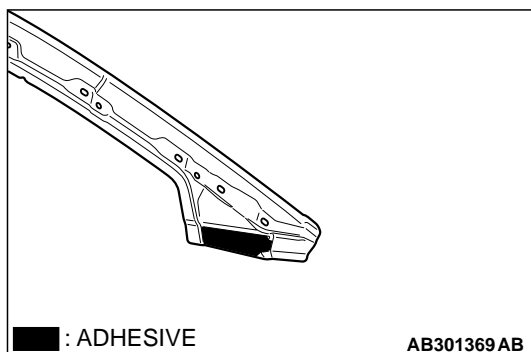
AB301358AB

NOTE ON REPAIR WORK

INSTALLATION

1. To reinforce the strength in the front pillar cut area, cut the side outer panel 100mm (3.9 inches) above the cut area and cut the side outer reinforcement 40mm (1.57 inches) above the cut area.
2. To reinforce the strength in the side sill cut area, cut the side outer panel 100mm (3.9 inches) behind the cut area and cut the side outer reinforcement 40mm (1.57 inches) behind the cut area.
3. Assemble the new front pillar inner lower parts.



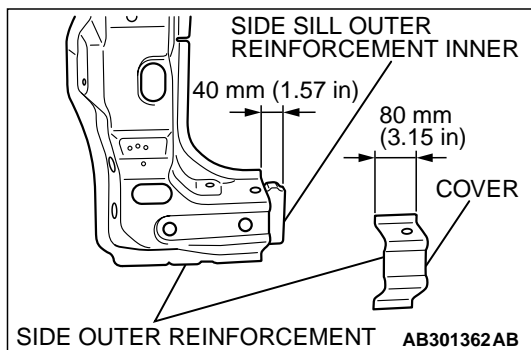


4. Adhere in advance adhesives in the areas shown in the figure of the instructions when assembling the front pillar inner upper.

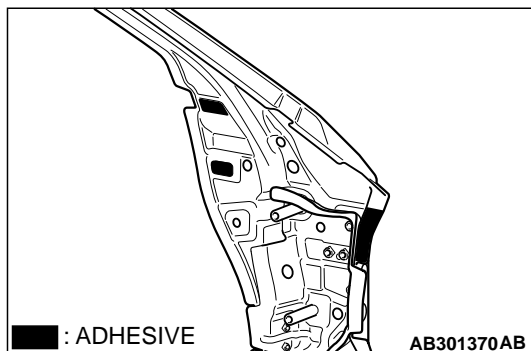
ADHESIVE	TYPE	BRAND
	Epoxyayresin adhesive	3M™ AAD Part No.8115 or equivalent

⚠ CAUTION

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

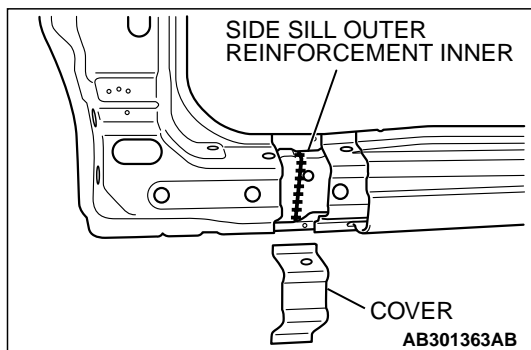


5. Cut the new side outer reinforcement by aligning it with the side outer reinforcement cut area on the body side. Then, cut only the side outer reinforcement 80 mm (3.15 inches) forward the cut area and make a cover. Cut the side sill outer reinforcement inner 40 mm (1.57 inches) behind the cut area of the side outer reinforcement.

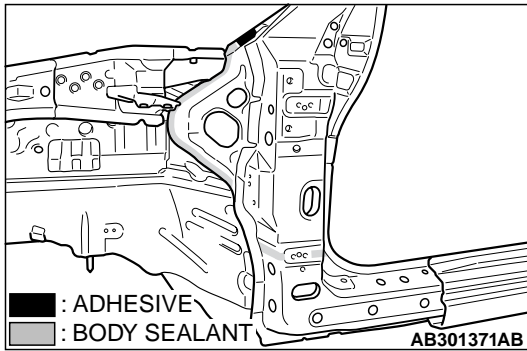


6. When assembling the side outer reinforcement, apply adhesives in the areas shown in the figure of the instructions.

ADHESIVE	TYPE	BRAND
	Epoxyayresin adhesive	3M™ AAD Part No.8115 or equivalent

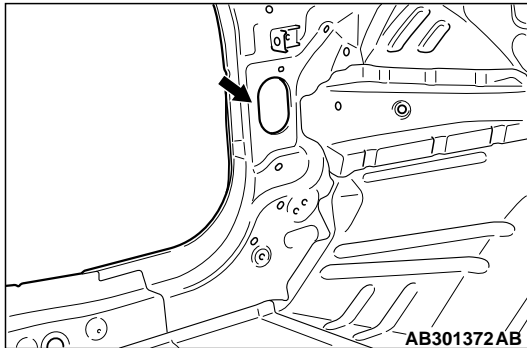


7. Weld the side sill outer reinforcement inner then weld the cover of the side outer reinforcement.



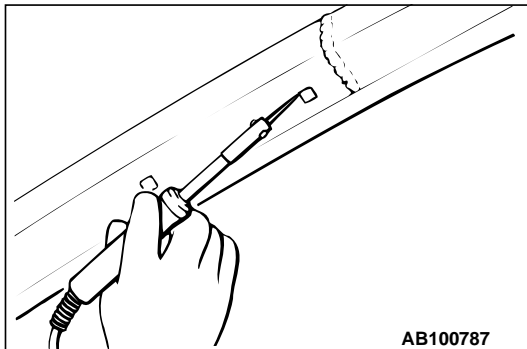
8. Adhere in advance body sealant and adhesives in the areas of the body side shown in the figure when assembling the new front pillar outer parts.

ADHESIVE	TYPE	BRAND
	Epoxyayresin adhesive	3M™ AAD Part No.8115 or equivalent



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

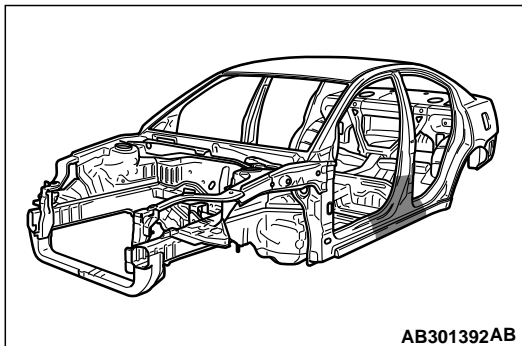
FOAM: 3M™ AAD ULTRAPRO Panel foam-Yellow



- 10.Wait 2 hours after filling the foam materials to remove the bolt and aluminum 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.

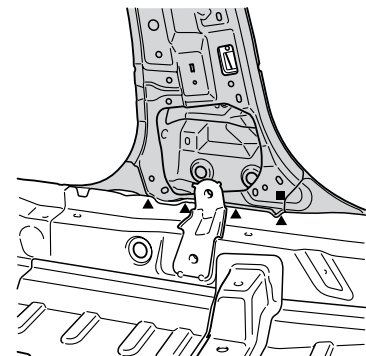
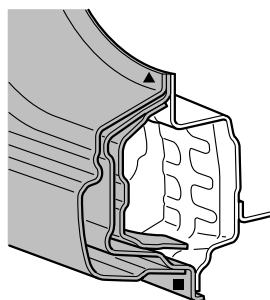
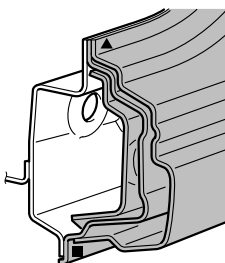
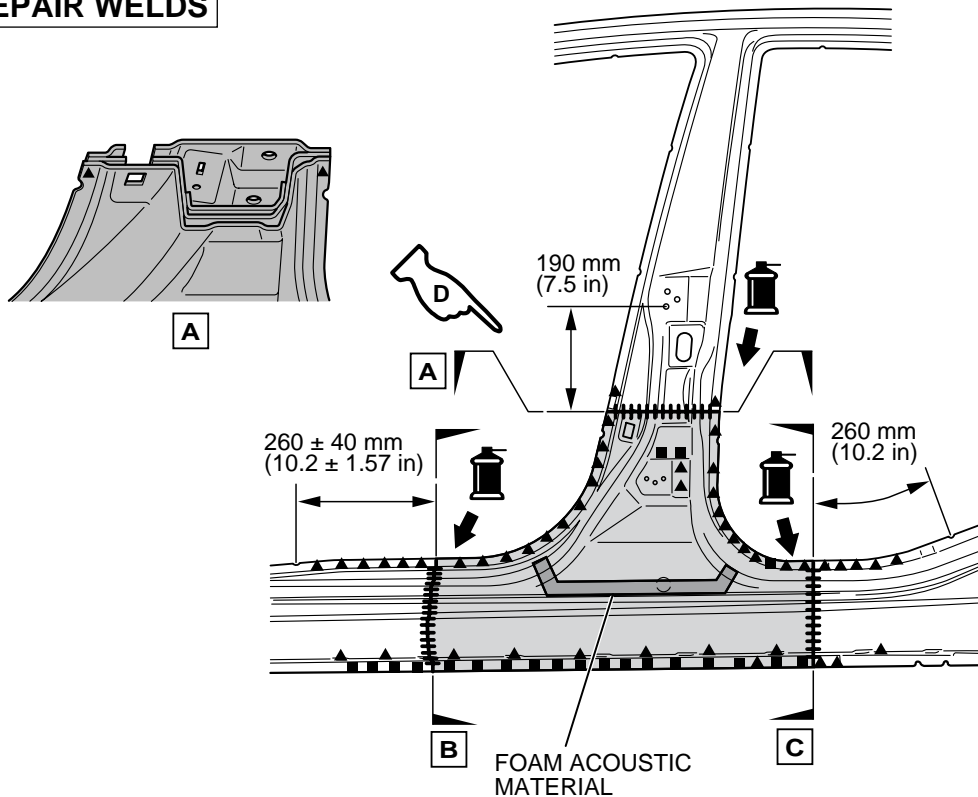
CENTER PILLAR

M4030006000165



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



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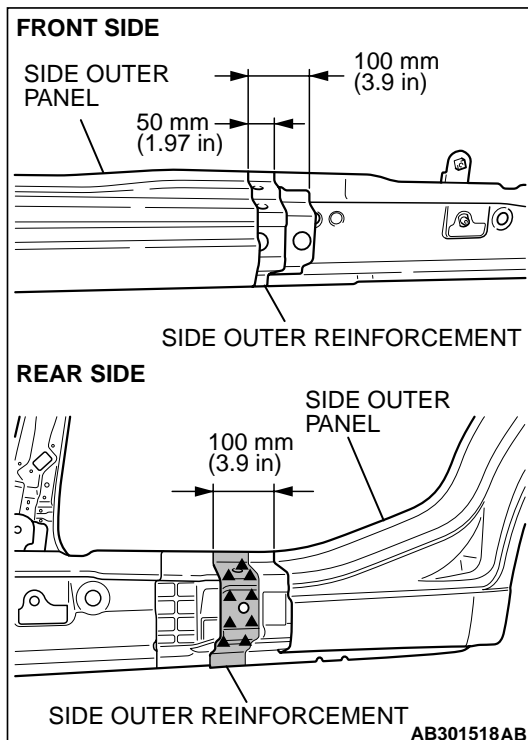
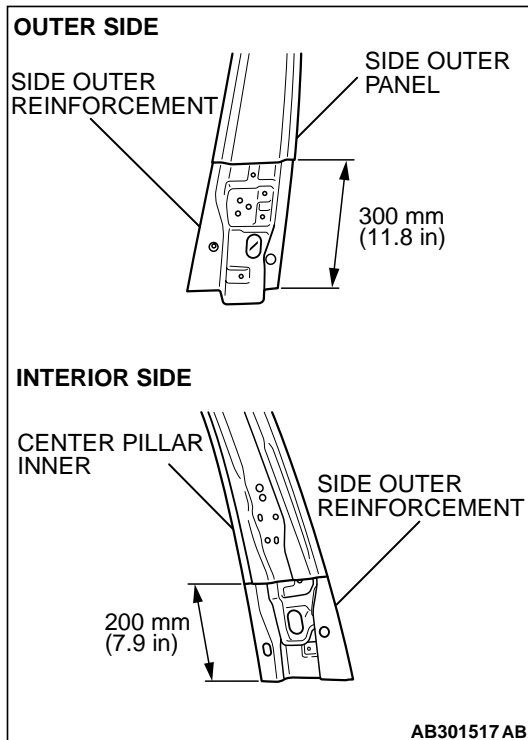
CAUTION

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

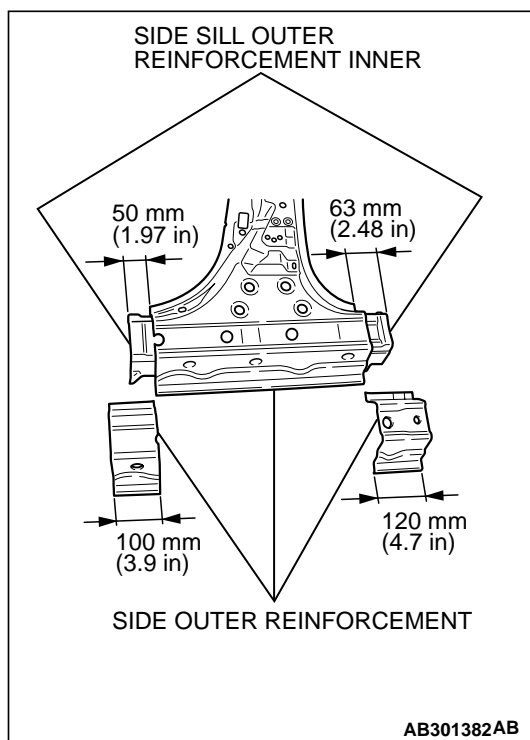
NOTE ON REPAIR WORK

INSTALLATION

1. To reinforce the strength in the center pillar cut area, cut the side outer panel 300 mm (11.8 inches) above the cut area and cut the center pillar inner 200 mm (7.9 inches) above the cut area.



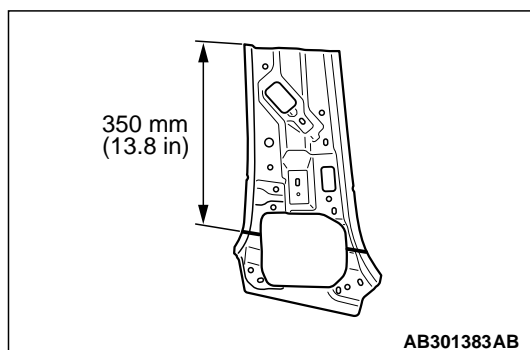
2. To reinforce the strength of the side sill cut area, on the front side, cut only the side outer panel 100 mm (3.9 inches) forward of the cut area, and cut only the side outer panel 50 mm (1.97 inches) behind the cut area. On the rear side, cut only the side outer panel 100 mm (3.9 inches) behind the cut area, and remove the side outer reinforcement.



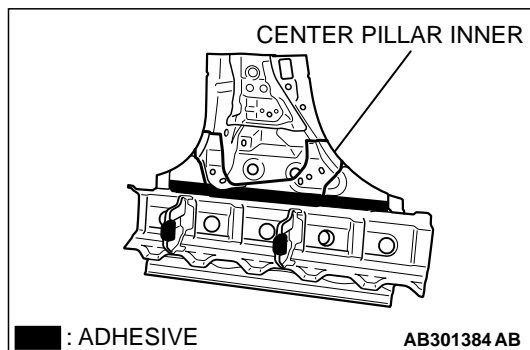
CAUTION

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

- Cut the new side outer reinforcement by aligning its center 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 (3.9 inches) behind the cut area and make a cover. Cut the side sill outer reinforcement inner 50 mm (1.97 inches) 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 (4.7 inches) forward the rear end, and cut the side sill outer reinforcement inner 63 mm (2.48 inches) behind the cut area of the side outer reinforcement.

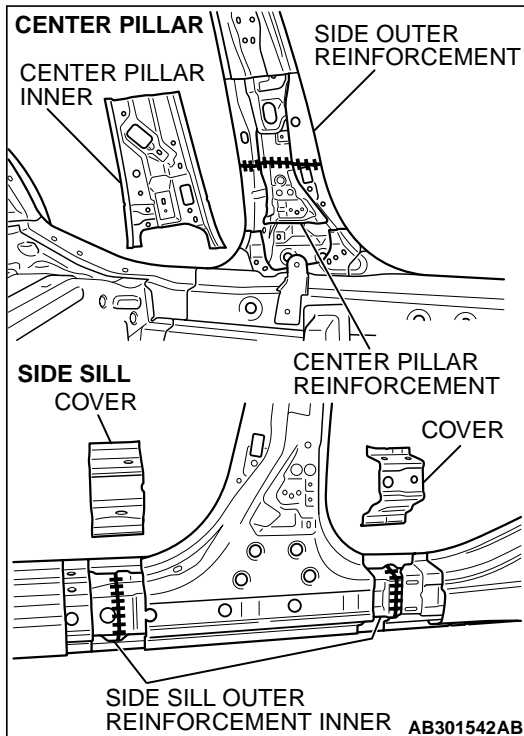


- Cut the new center pillar inner parts by aligning it with the cut area on the body side. Then, cut it 350 mm (13.8 inches) below the cut area.

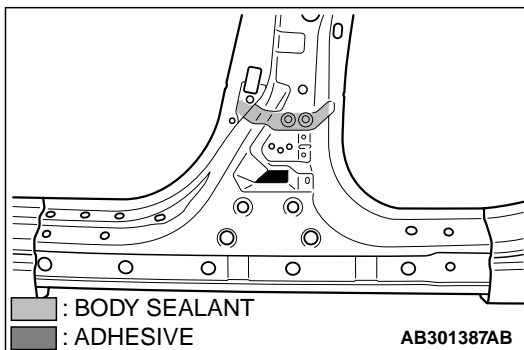


- When assembling the side outer reinforcement, install the lower part of the center pillar inner cut on the procedures above and apply adhesives in the areas shown in the figure of the instructions.

ADHESIVE	TYPE	BRAND
	Epoxyayresin adhesive	3M™ AAD Part No.8115 or equivalent

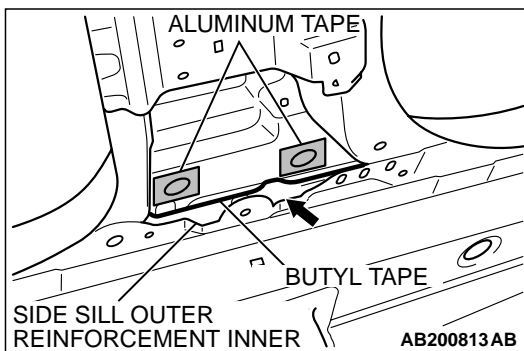


6. When assembling the side reinforcement, on the center pillar area, weld the side outer reinforcement and center pillar reinforcement from the outside and inside, then weld the center pillar inner. On the side sill area, weld the side sill outer reinforcement inner, then weld the side outer reinforcement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

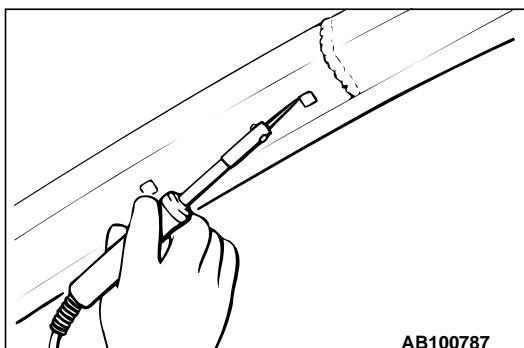


7. Adhere in advance body sealant and adhesives in the areas of the body side shown in the figure when assembling the new center pillar outer parts.

ADHESIVE	TYPE	BRAND
	Epoxyayresin adhesive	3M™ AAD Part No.8115 or equivalent



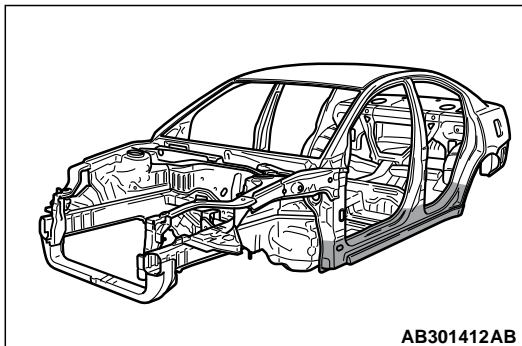
8. After assembling the center pillar outer, fill the upper surface of the side sill outer reinforcement inner with foam materials. At this time, aluminum tape the hole of the side outer reinforcement and the gap on the side sill outer reinforcement inner with butyl-tape, to prevent foam materials from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



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.

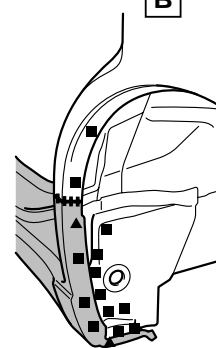
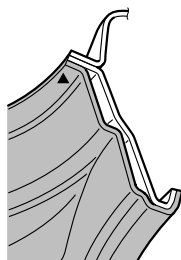
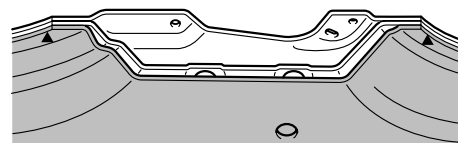
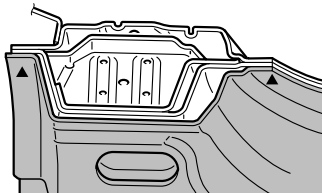
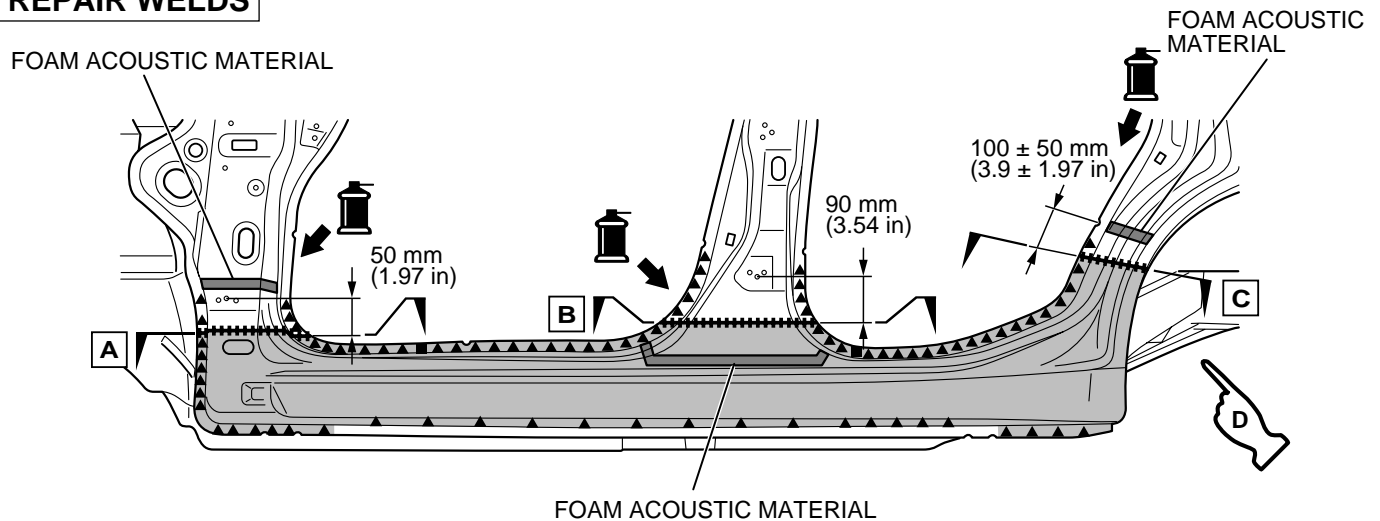
SIDE SILL

M4030007000180



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.)

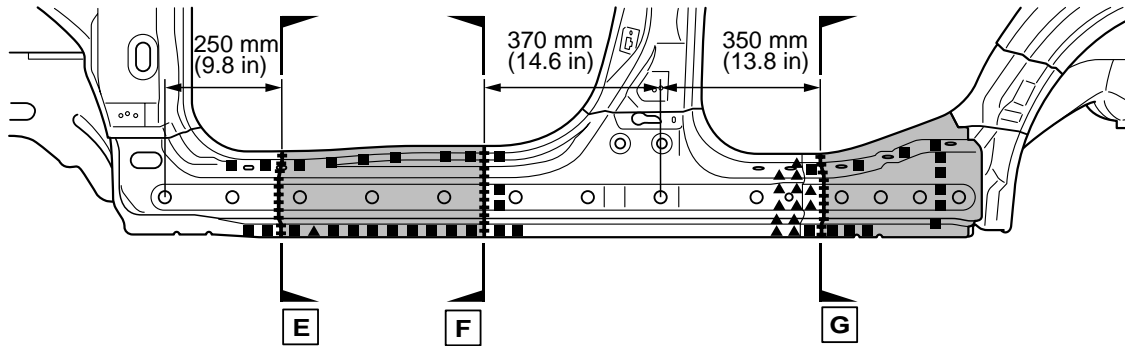
REPAIR WELDS



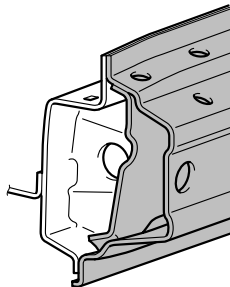
AB301521AB

⚠ CAUTION

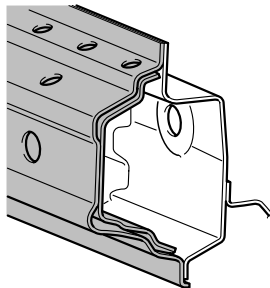
When repairing the area using foam materials do not use firing tools since the foaming materials may burn.



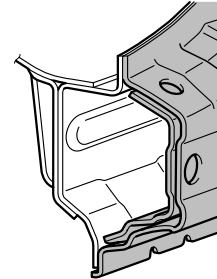
(WITH THE SIDE OUTER PANEL REMOVED)



E



F



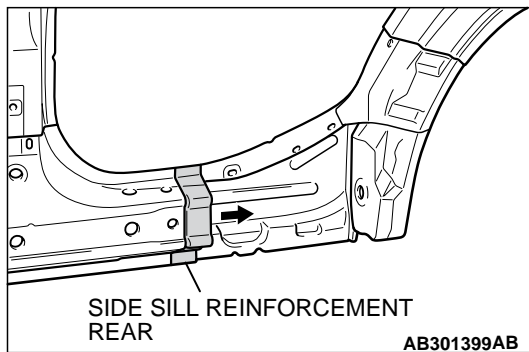
G

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.

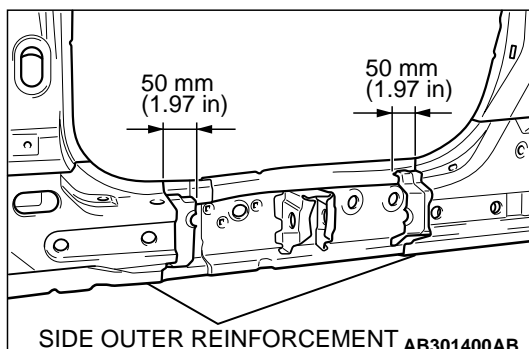


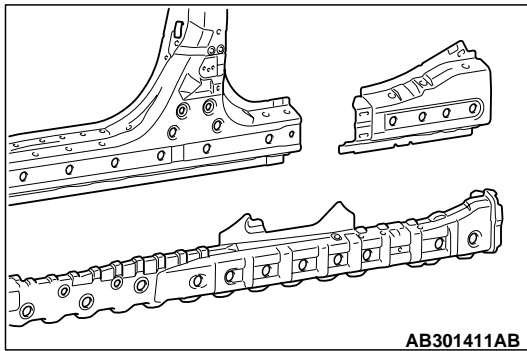
INSTALLATION

⚠ CAUTION

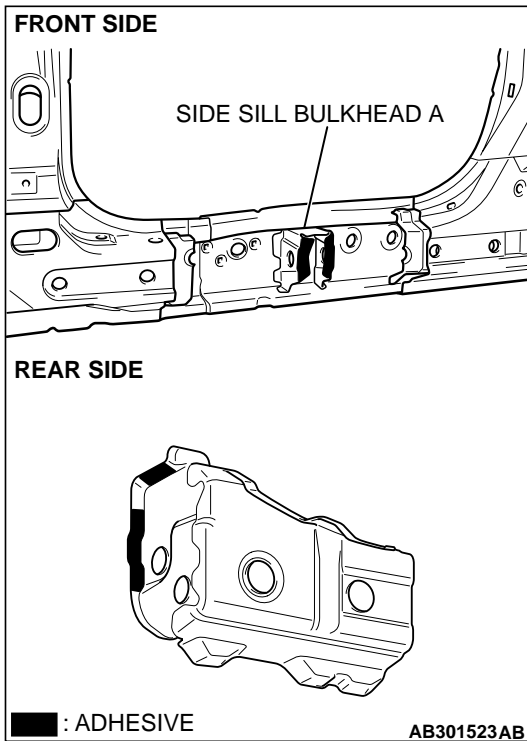
Weld and repair if the side sill outer reinforcement inner is damaged.

1. To reinforce the strength of the side outer reinforcement cut area, cut only the side outer reinforcement 50 mm (1.97 inches) front and behind the cut areas to remove.



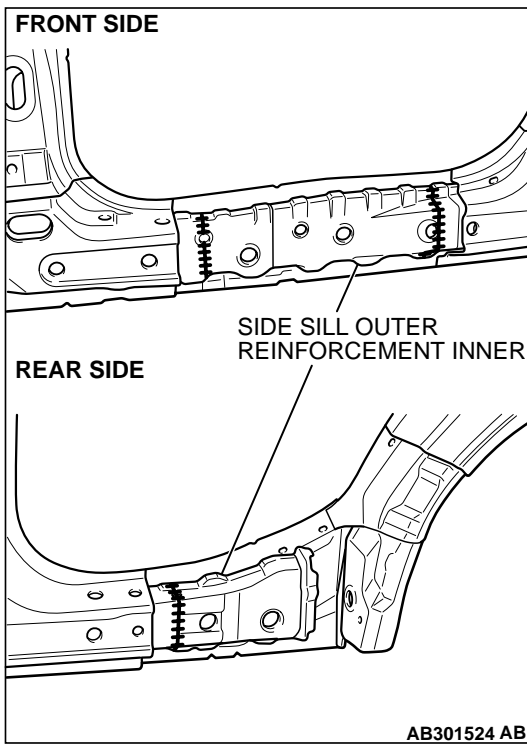


2. Remove the side sill reinforcement rear and the side sill outer reinforcement inner from the side outer reinforcement. Cut the side outer reinforcement and the side sill outer reinforcement inner, aligning them with the body side.

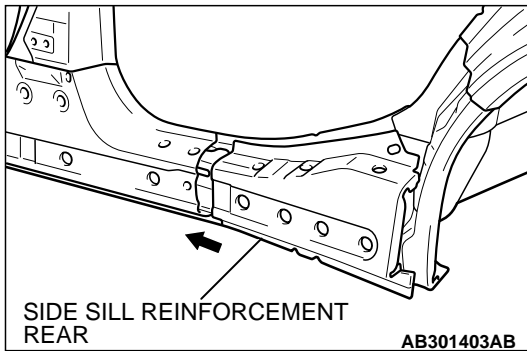


3. When assembling the side sill outer reinforcement inner, on the front side, adhere adhesives to the side sill bulkhead A of the body side. On the rear side, adhere adhesives to the side sill outer reinforcement inner.

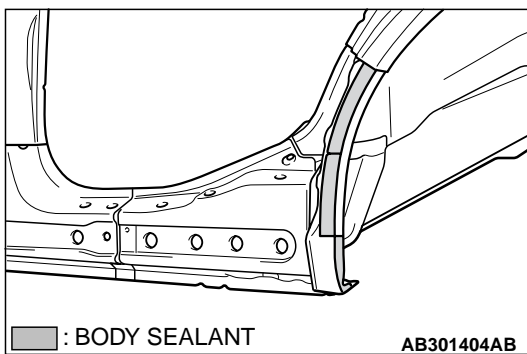
ADHESIVE	TYPE	BRAND
	Epoxyayresin adhesive	3M™ AAD Part No.8115 or equivalent



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



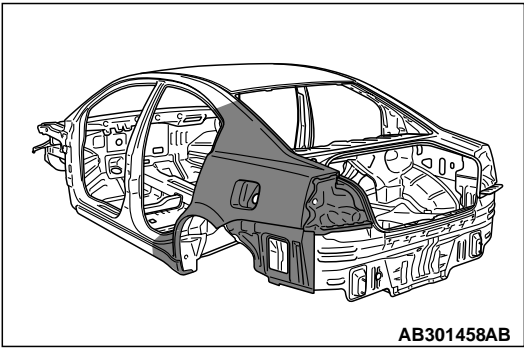
5. Assemble the side sill reinforcement rear by inserting it to the side outer reinforcement from backward.



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.

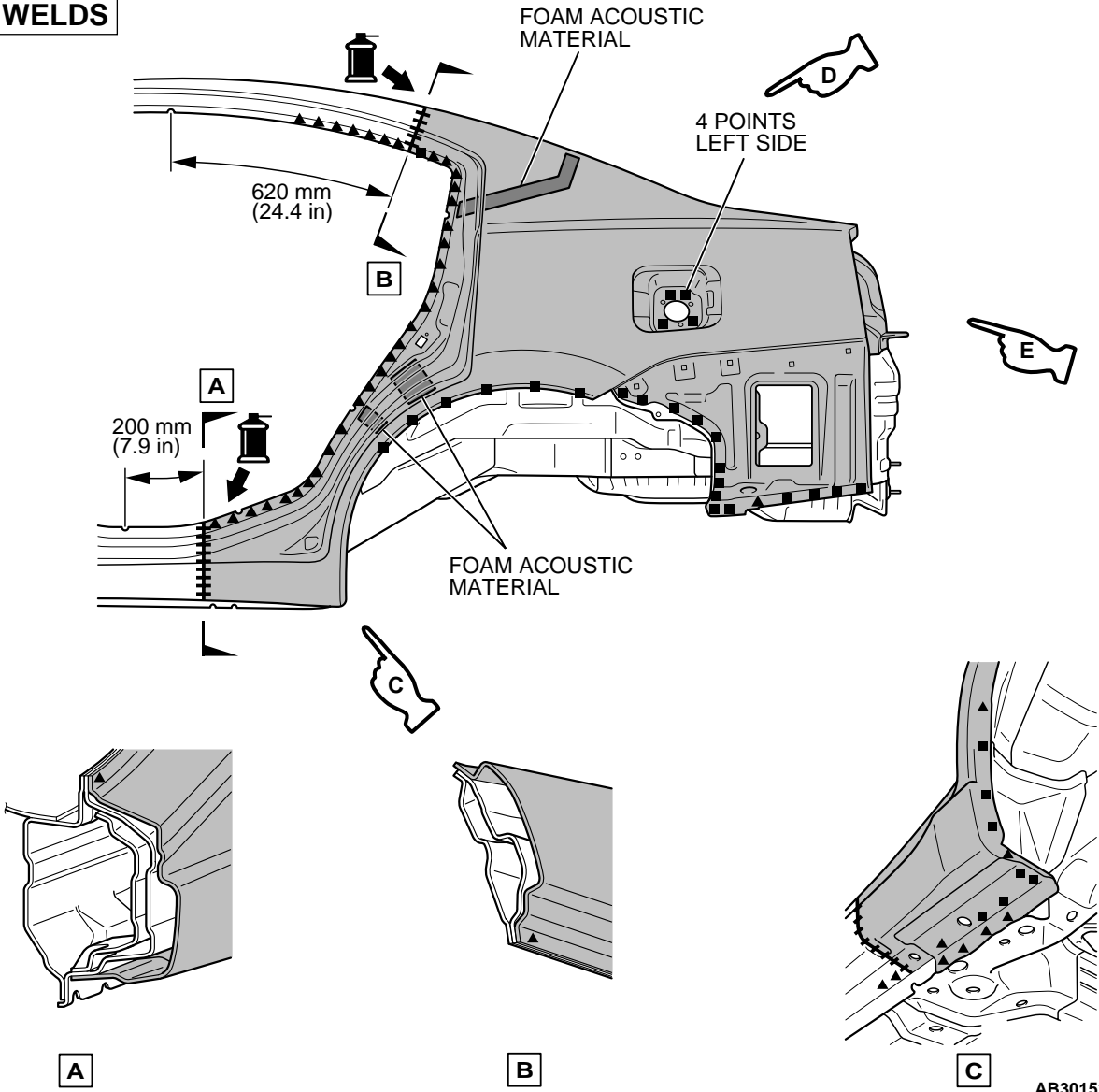
QUARTER OUTER

M4030008000150



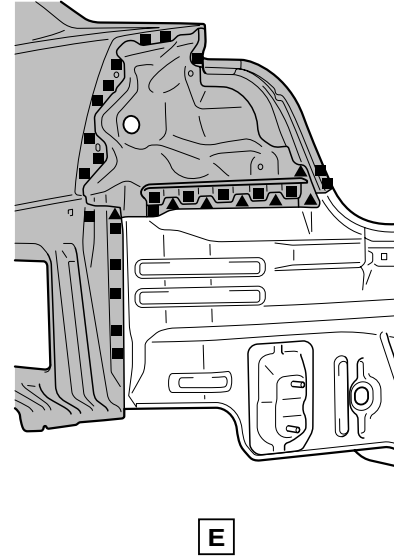
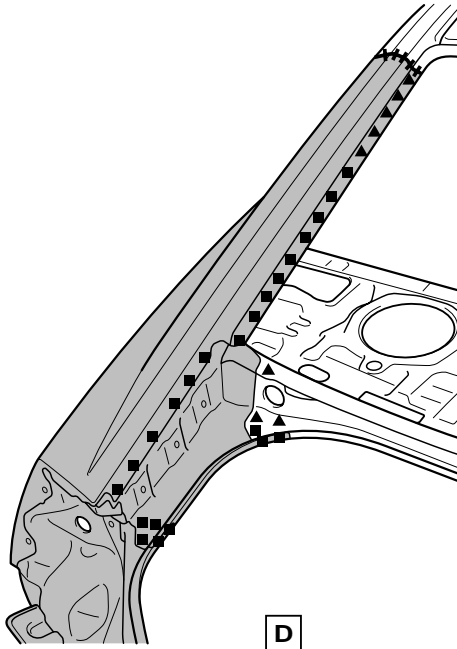
SYMBOL	OPERATION DESCRIPTION
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
++++	MIG spot welding
	MIG arc welding (continuous)
ooooo	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally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

REPAIR WELDS



CAUTION

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



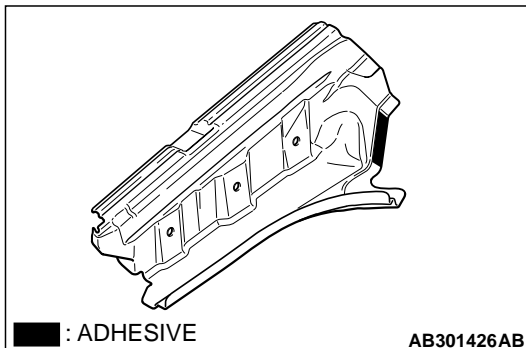
AB301528AB

NOTE ON REPAIR WORK

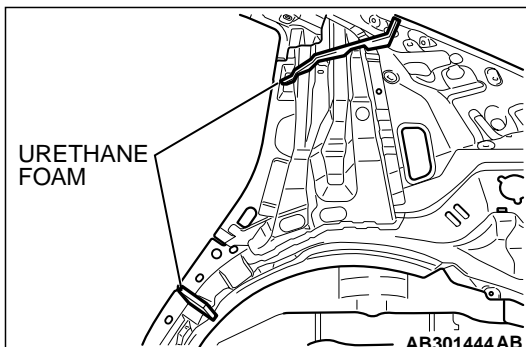
INSTALLATION

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

ADHESIVE	TYPE	BRAND
	Epoxyayresin adhesive	3M™ AAD Part No.8115 or equivalent

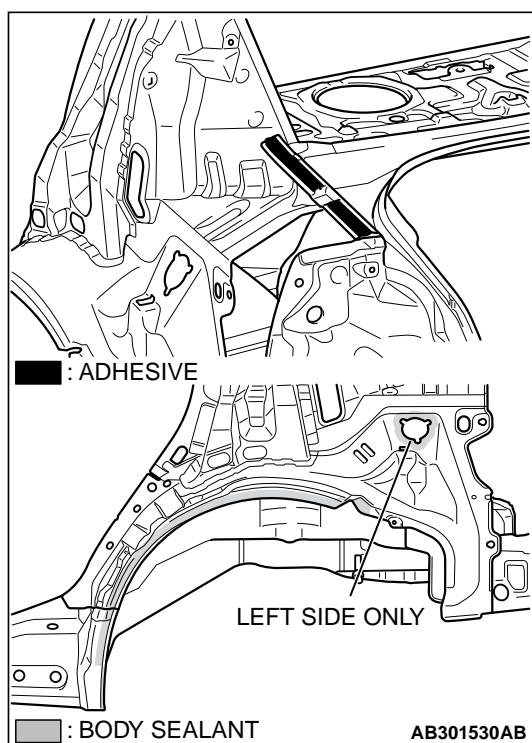


AB301426AB



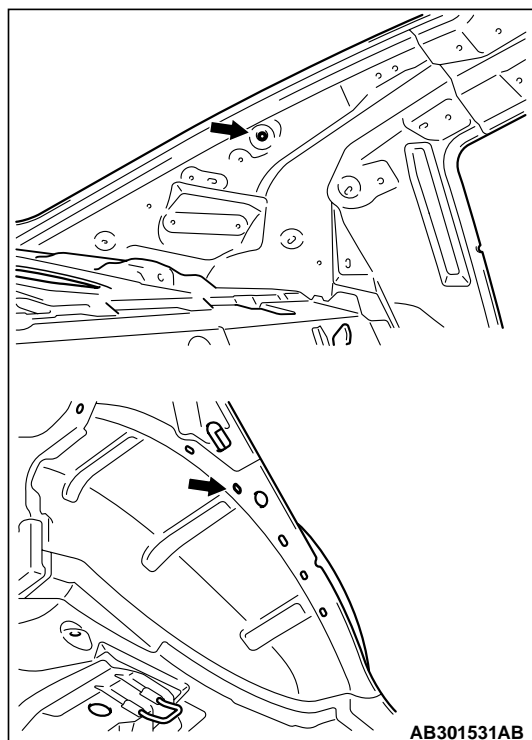
AB301444AB

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.

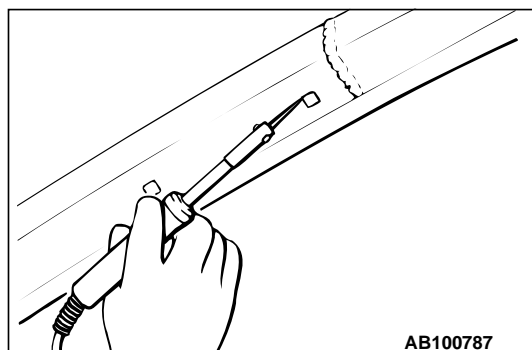


3. When assembling the new rear quarter outer panel parts, apply in advance body sealant and adhesive to the areas shown in the figure of the instructions.

ADHESIVE	TYPE	BRAND
	Epoxyayresin adhesive	3M™ AAD Part No.8115 or equivalent



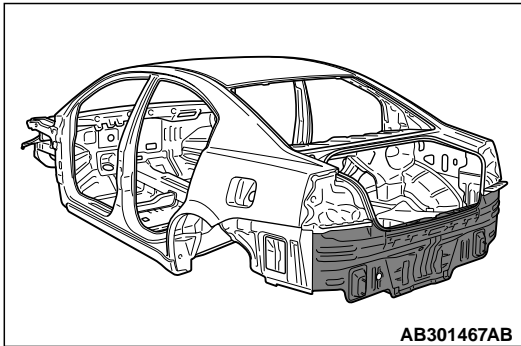
4. Assemble the rear quarter outer panel, bolt and tape the hole and flange with aluminum tape, then fill the hole with foam materials as shown in the figure of the instructions.
FOAM: 3M™ AAD ULTRAPRO Panel foam-Yellow



5. Wait 2 hours after filling the foam materials to remove the bolt and aluminum 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.

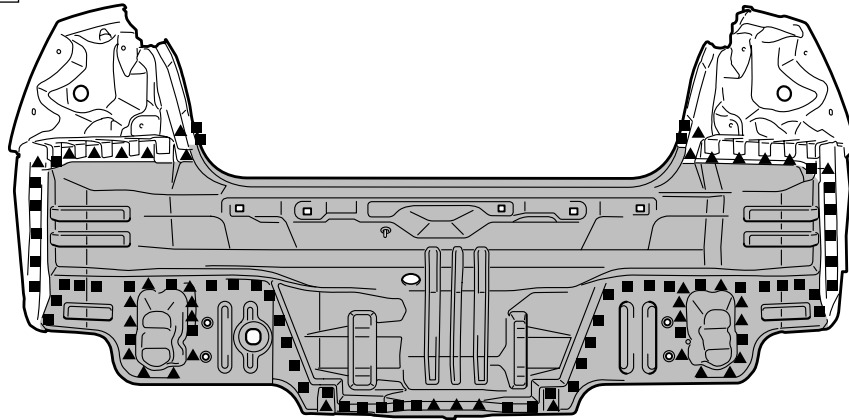
REAR END PANEL

M4030009000090



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

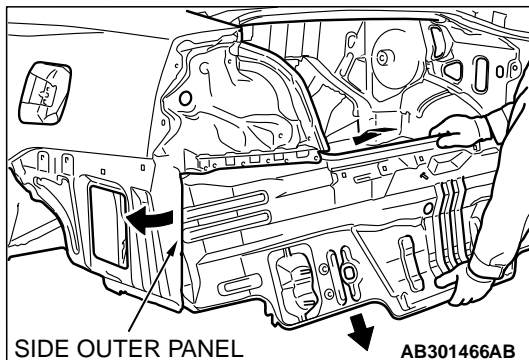


AB301465AB

NOTE ON REPAIR WORK

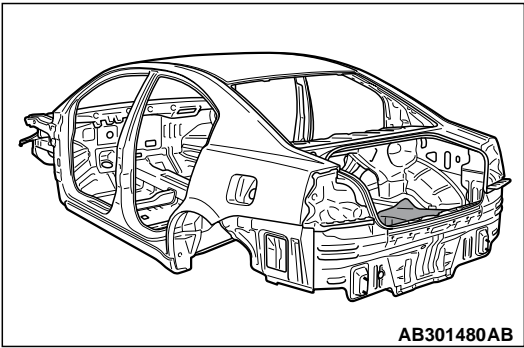
REMOVAL

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.



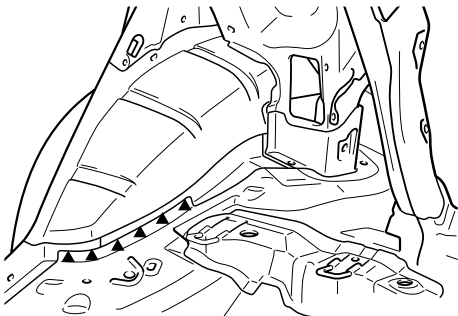
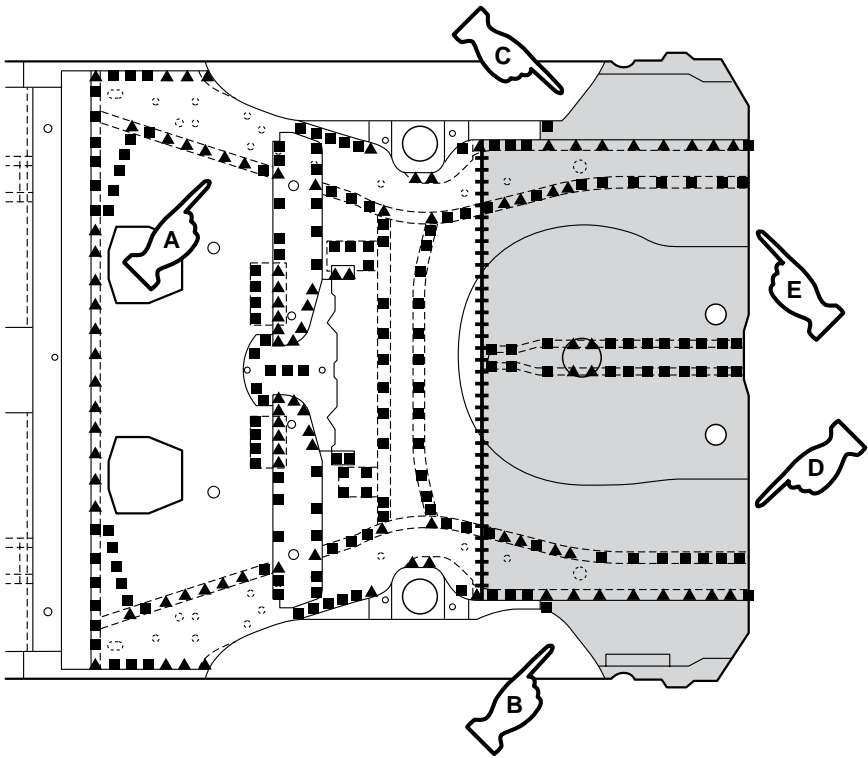
REAR FLOOR

M4030010000157



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.)

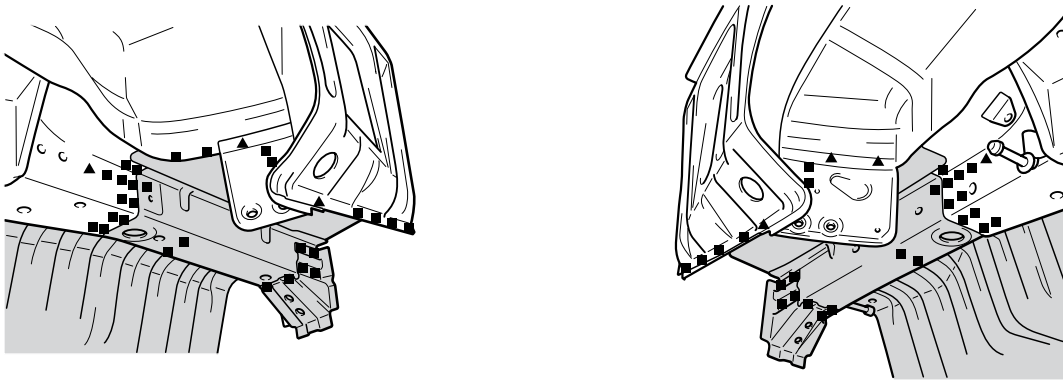
REPAIR WELDS



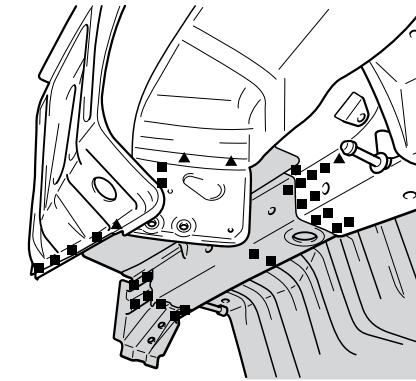
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AB301538AB

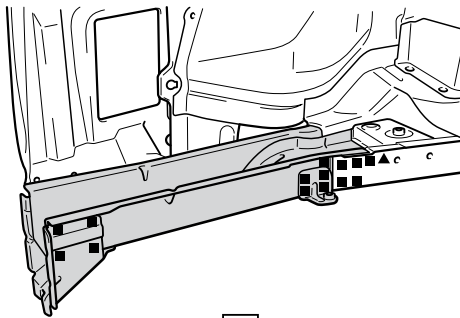
NOTE: Refer to the Rear End Panel Section on [P.3-27](#) for the welding points with the rear end panel.



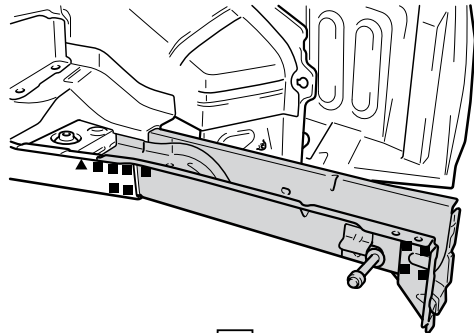
B



C



D



E

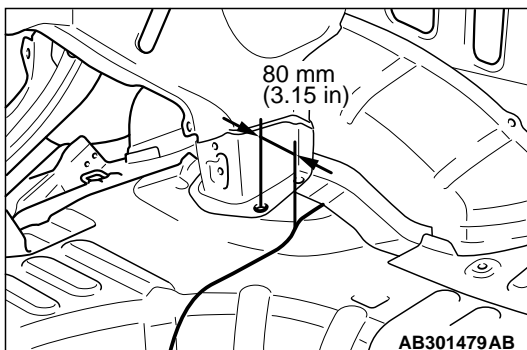
(WITH THE REAR FLOOR PAN REMOVED)

AB301539AB

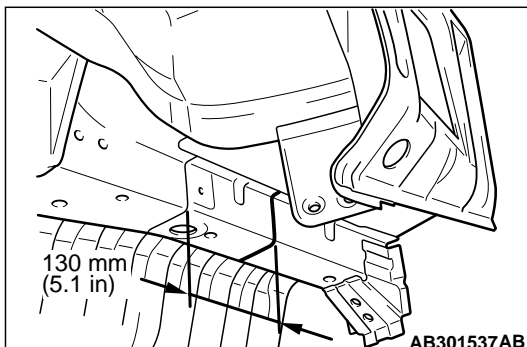
NOTE ON REPAIR WORK

REMOVAL

1. When cutting the rear floor pan, cut it from 80 mm (3.15 inches) behind the rear suspension assembling hole.
2. When removing the rear floor side member extension without removing the rear floor pan, cut it 130 mm (5.1 inches) behind the rear edge of the rear floor side member to remove.



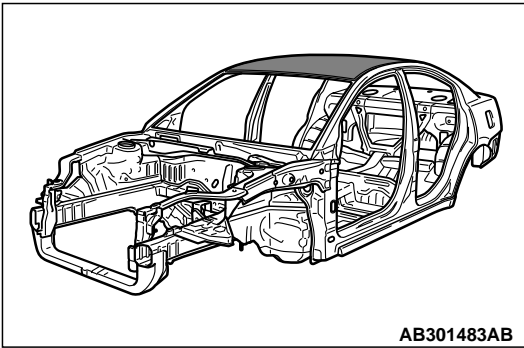
AB301479AB



AB301537AB

ROOF

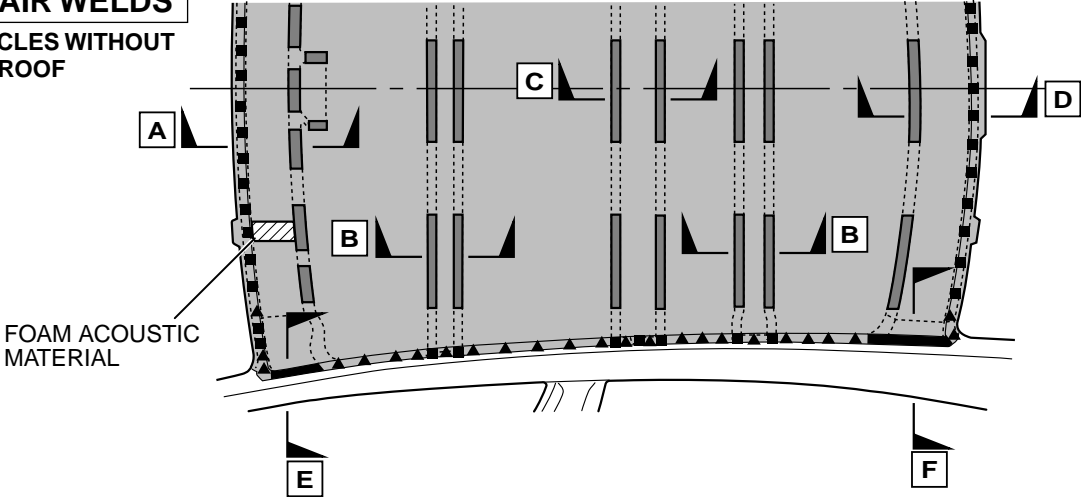
M4030011000150



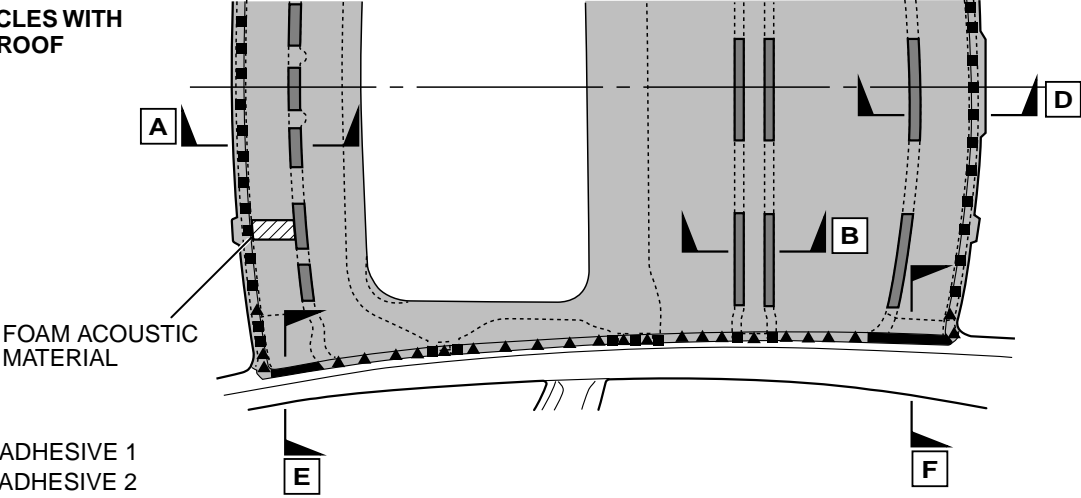
SYMBOL	OPERATION DESCRIPTION
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
++++	MIG spot welding
	MIG arc welding (continuous)
ooooo	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally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

REPAIR WELDS

VEHICLES WITHOUT
SUN ROOF



VEHICLES WITH
SUN ROOF

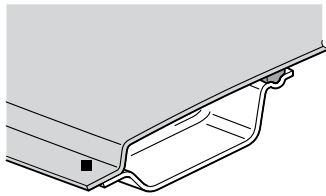


AB301525AB

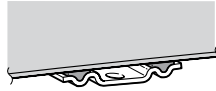
ADHESIVE	TYPE	BRAND
adhesive 1	Urethane body sealer	3M™ AAD Part No. 8542 or equivalent
adhesive 2	Epoxyayresin adhesive	3M™ AAD Part No. 8115 or equivalent

CAUTION

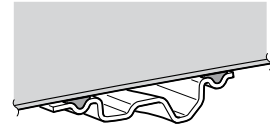
When repairing the area using foam materials do not use firing tools since the foaming materials may burn.



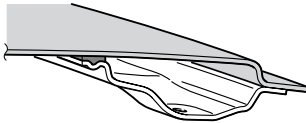
A



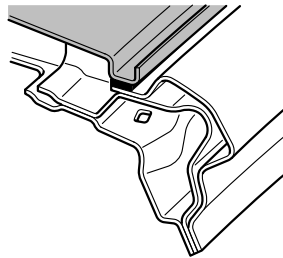
B



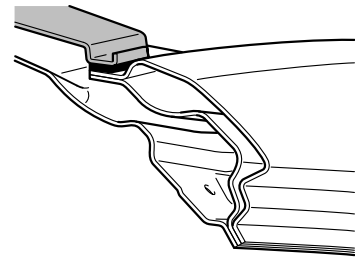
C



D



E



F

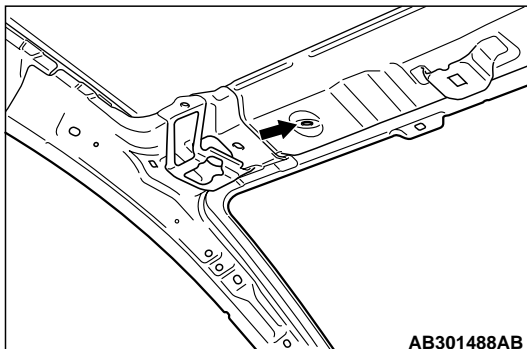
AB301526AB

NOTE ON REPAIR WORK

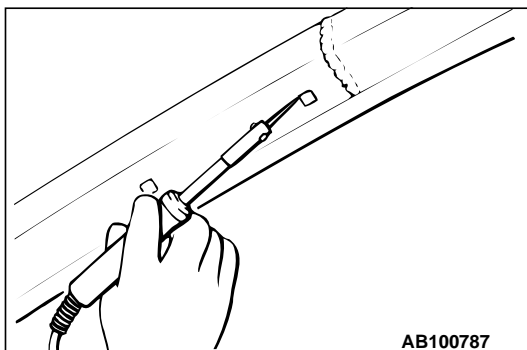
INSTALLATION

1. Assemble the roof panel, bolt and tape the hole and flange with aluminum tape, then fill the hole with foam materials as shown in the figure of the instructions.

FOAM: 3M™ AAD ULTRAPRO Panel foam-Yellow



AB301488AB

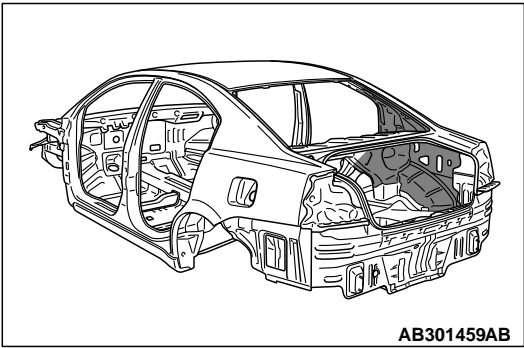


AB100787

2. Wait 2 hours after filling the foam materials to remove the bolt and aluminum 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.

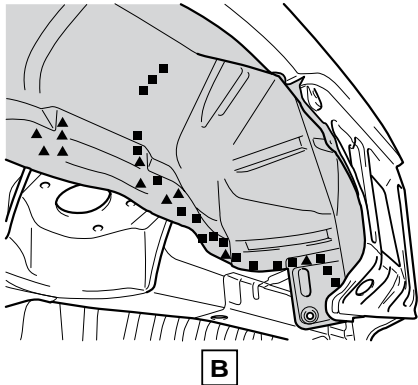
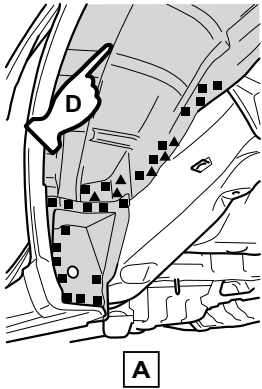
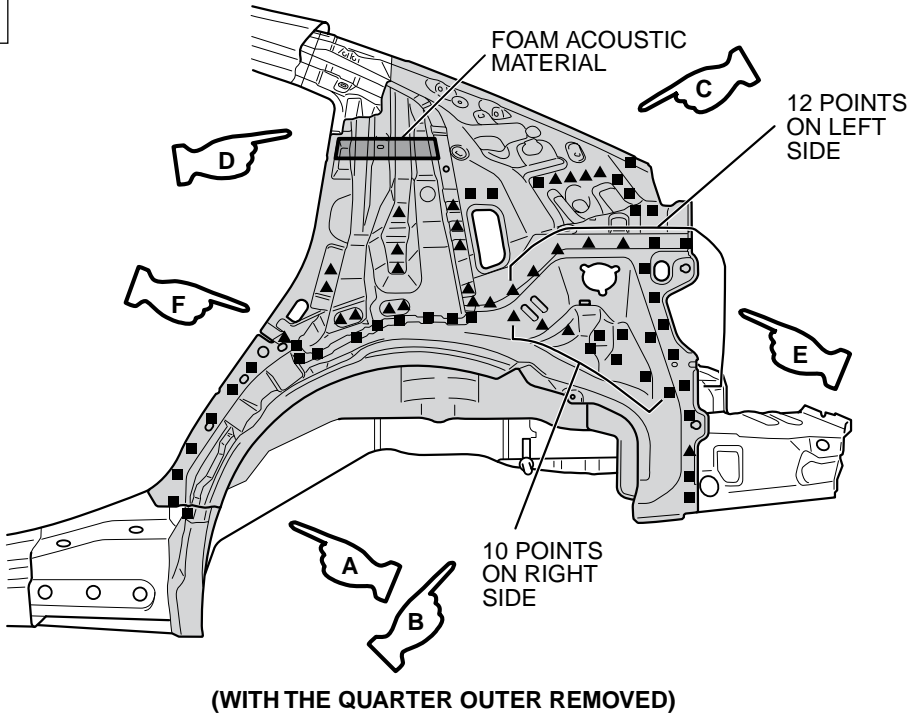
QUARTER INNER

M4030012000153



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

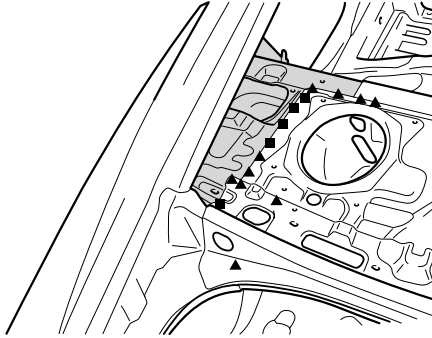


AB301532AB

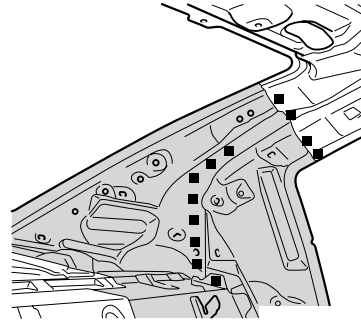
CAUTION

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

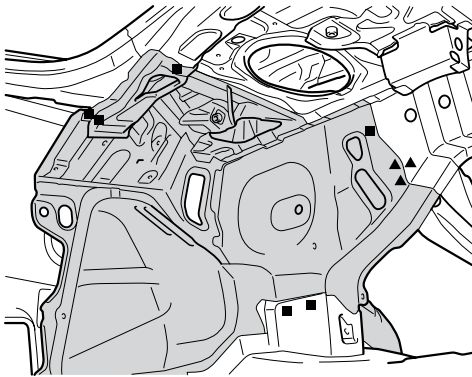
NOTE: Refer to the Quarter Outer Section on [P.3-24](#) for the welding points with the quarter outer.



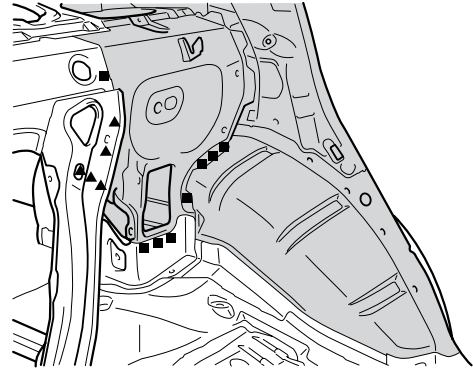
C



D



E



F

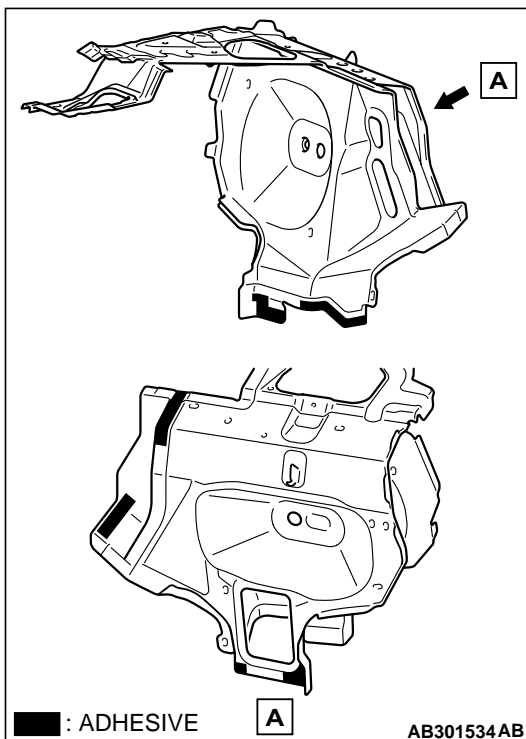
AB301533AB

NOTE ON REPAIR WORK

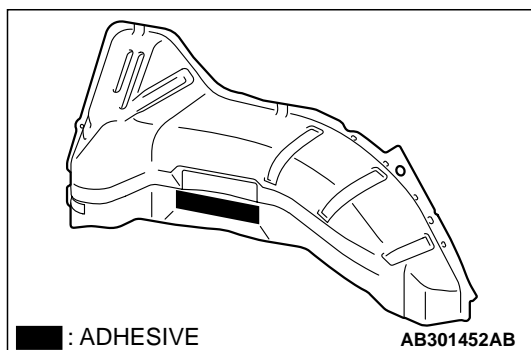
INSTALLATION

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

ADHESIVE	TYPE	BRAND
	Epoxyayresin adhesive	3M™ AAD Part No.8115 or equivalent

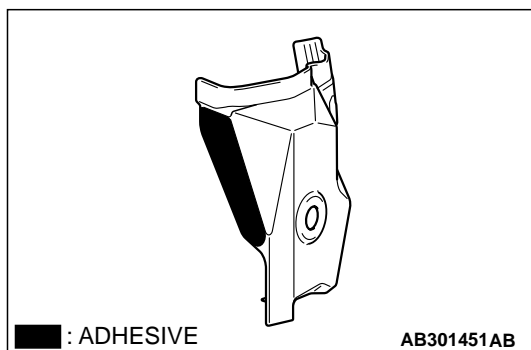


AB301534AB



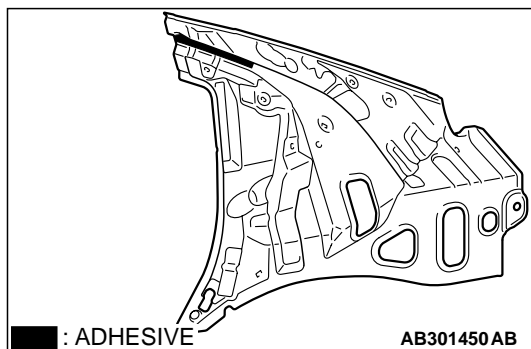
2. Adhere in advance adhesives in the areas shown in the figure of the instructions when assembling the rear wheelhouse panel inner.

ADHESIVE	TYPE	BRAND
	Epoxyayresin adhesive	3M™ AAD Part No.8115 or equivalent



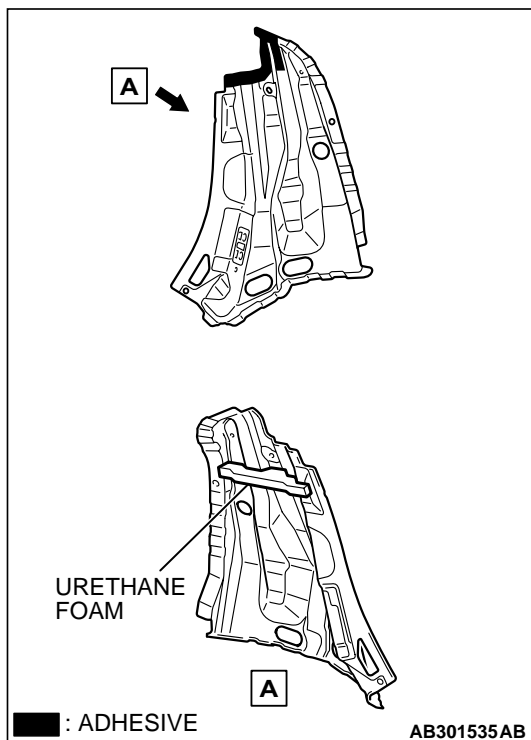
3. Adhere in advance adhesives in the areas shown in the figure of the instructions when assembling the rear wheelhouse shield plate front.

ADHESIVE	TYPE	BRAND
	Epoxyayresin adhesive	3M™ AAD Part No.8115 or equivalent



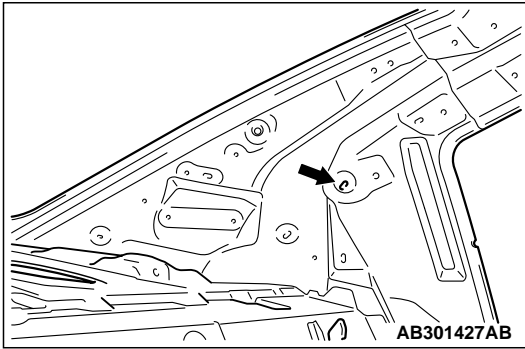
4. Adhere in advance adhesives in the areas shown in the figure of the instructions when assembling the rear quarter inner panel upper.

ADHESIVE	TYPE	BRAND
	Epoxyayresin adhesive	3M™ AAD Part No.8115 or equivalent

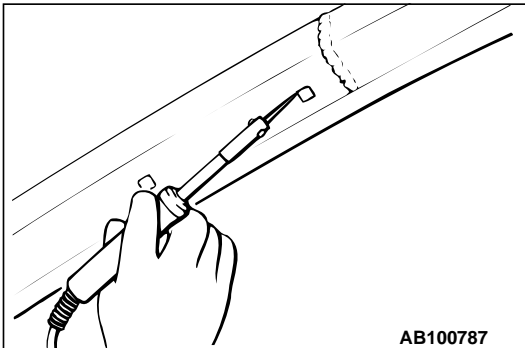


5. Adhere in advance adhesives in the areas shown in the figure of the instructions when assembling the new rear pillar reinforcement parts. To prevent the foam materials from dripping, apply urethane foam to bury the inside of the rear pillar reinforcement.

ADHESIVE	TYPE	BRAND
	Epoxyayresin adhesive	3M™ AAD Part No.8115 or equivalent



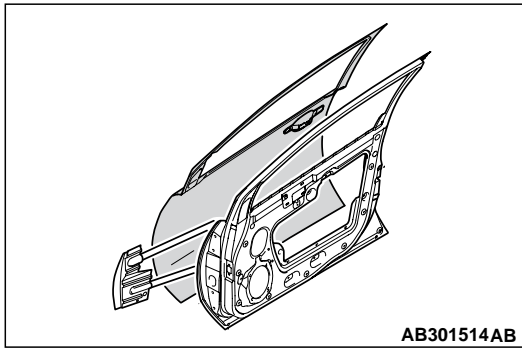
6. Assemble the rear pillar reinforcement, bolt and tape the hole and flange with aluminum tape, then fill the hole with foam materials as shown in the figure of the instructions.
FOAM: 3M™ AAD ULTRAPRO Panel foam-Yellow




7. Wait 2 hours after filling the foam materials to remove the bolt and aluminum 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.

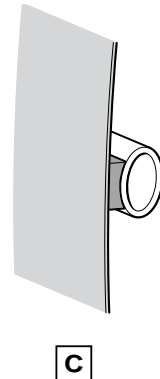
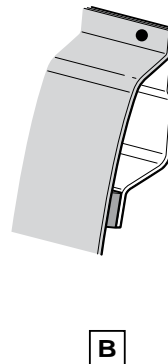
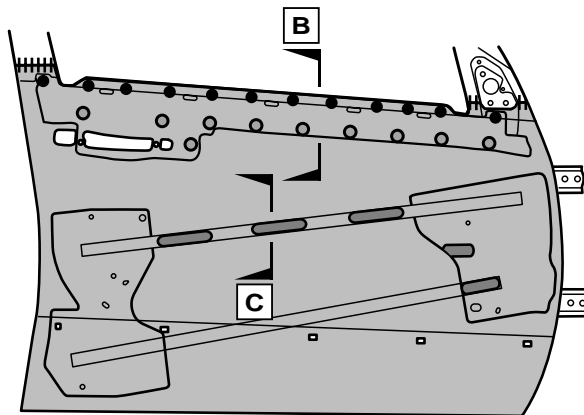
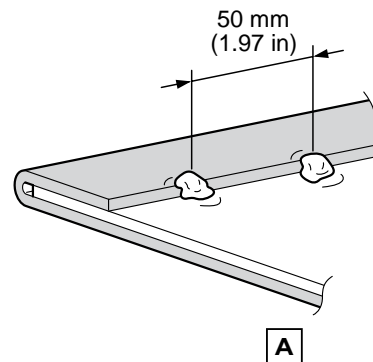
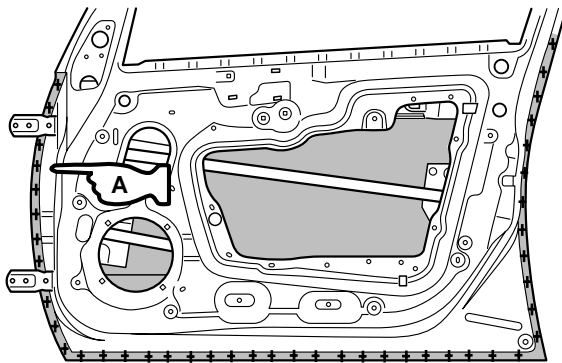
FRONT DOOR OUTER PANEL

M4030013000167



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


 : ADHESIVE

AB301511AB

ADHESIVE	TYPE	BRAND
	Urethane body sealer	3M™ AAD 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 (1.97 inches).

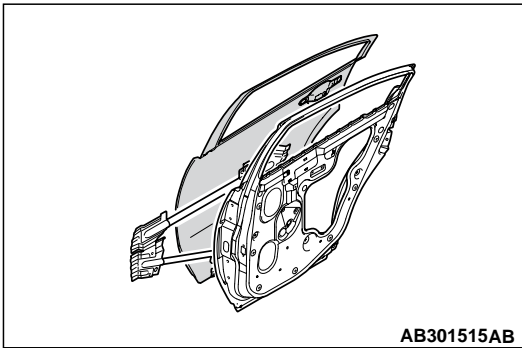
NOTE ON REPAIR WORK

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.

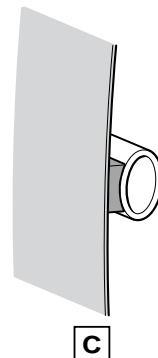
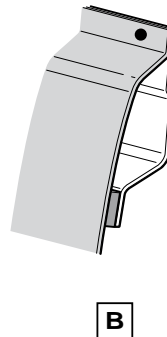
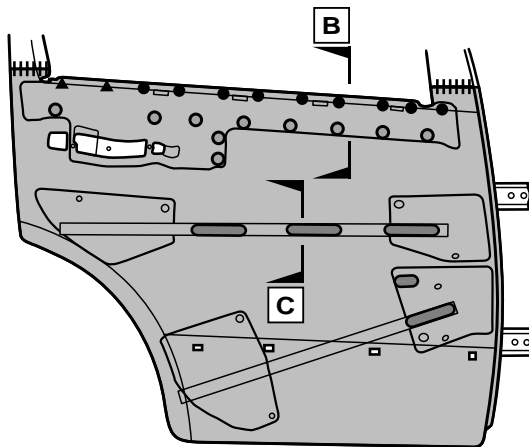
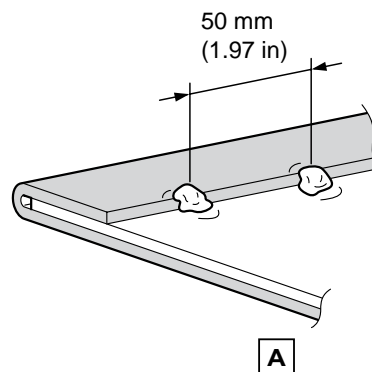
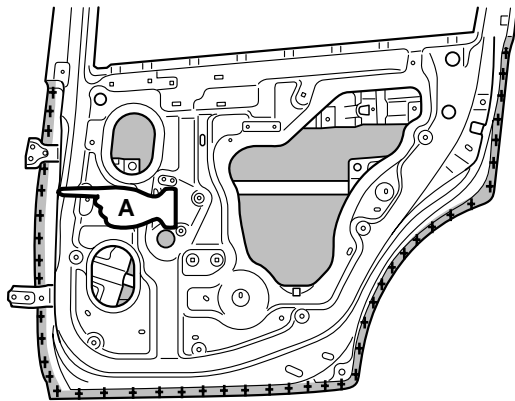
REAR DOOR OUTER PANEL

M4030014000159



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



: ADHESIVE

AB301516 AB

ADHESIVE	TYPE	BRAND
	Urethane body sealer	3M™ AAD 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 (1.97 inches).

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.

NOTES