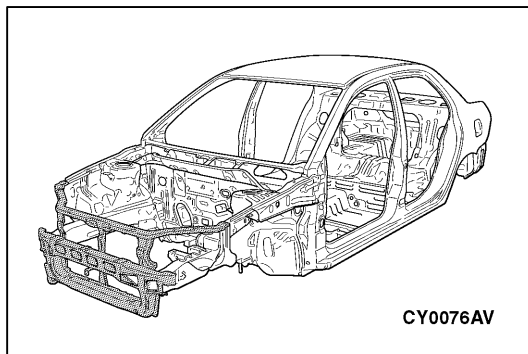
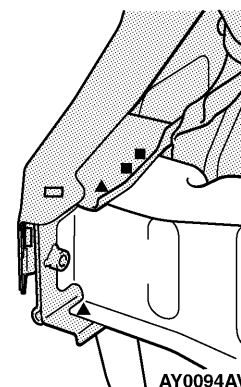
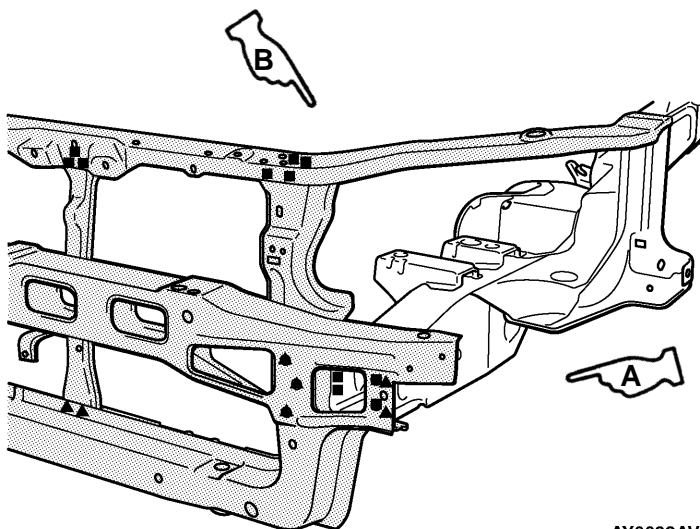


## HEADLAMP SUPPORT

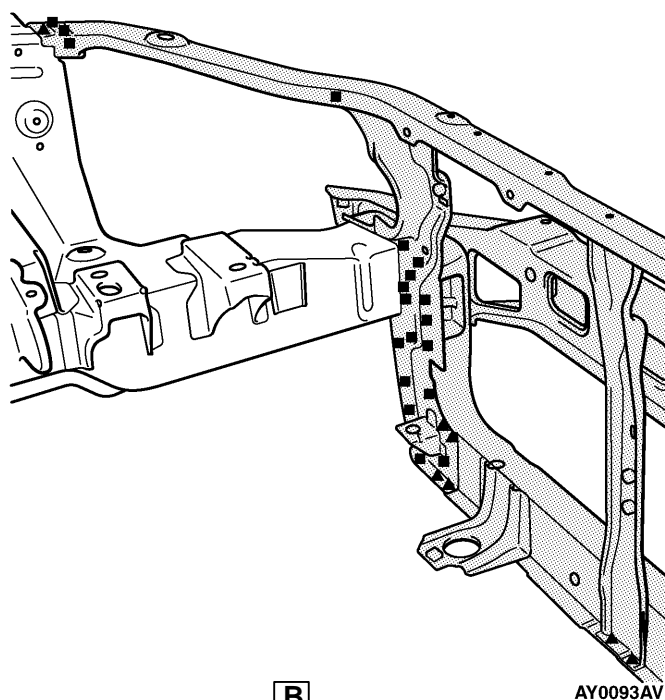


Symbol	Operation description
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
+ + + +	MIG spot welding
	MIG arc welding (continuous)
○ ○ ○ ○ ○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply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

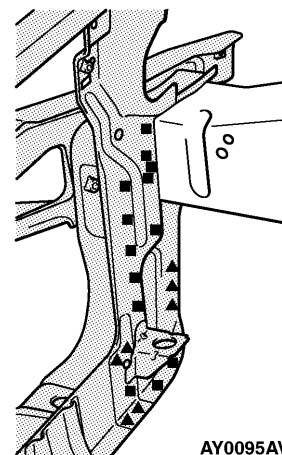
### REPAIR WELDS



A



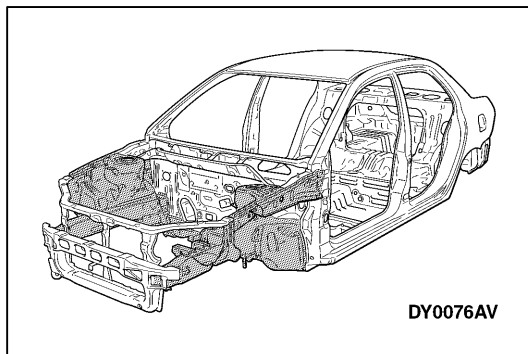
B




B

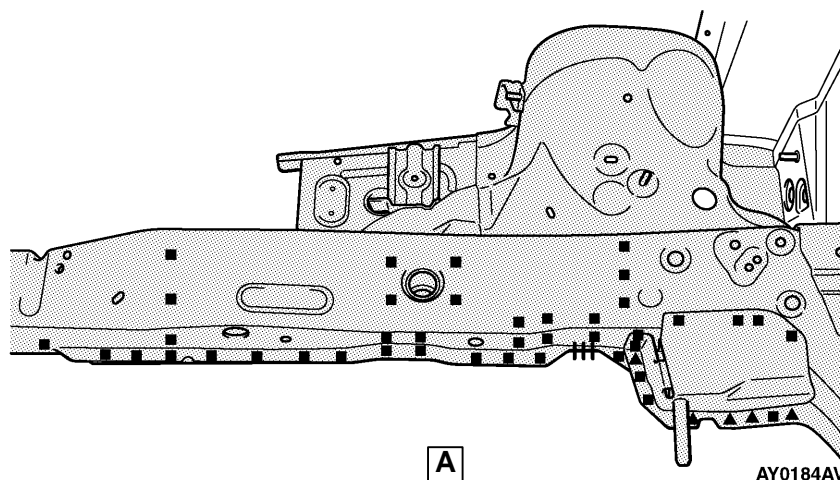
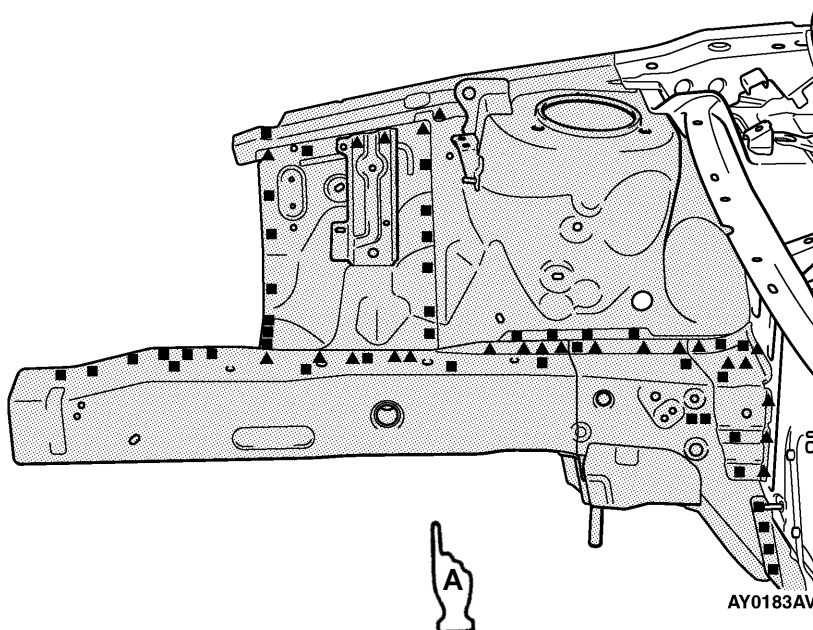
(Right side)

## FENDER SHIELD



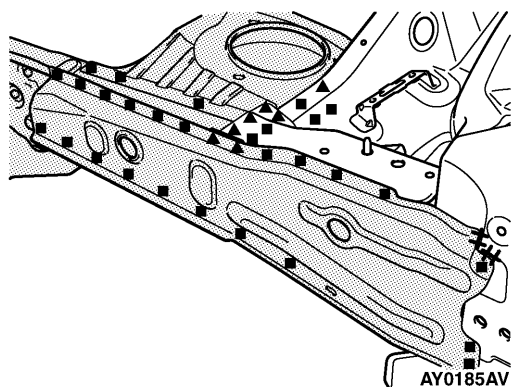
Symbol	Operation description
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
+ + + +	MIG spot welding
	MIG arc welding (continuous)
○○○○○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally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

## REPAIR WELDS

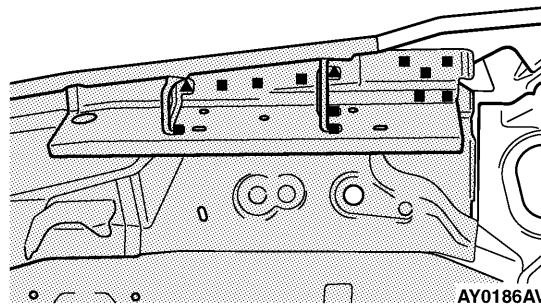


### NOTE

For the weld points for the headlamp support, refer to [Headlamp Support](#).

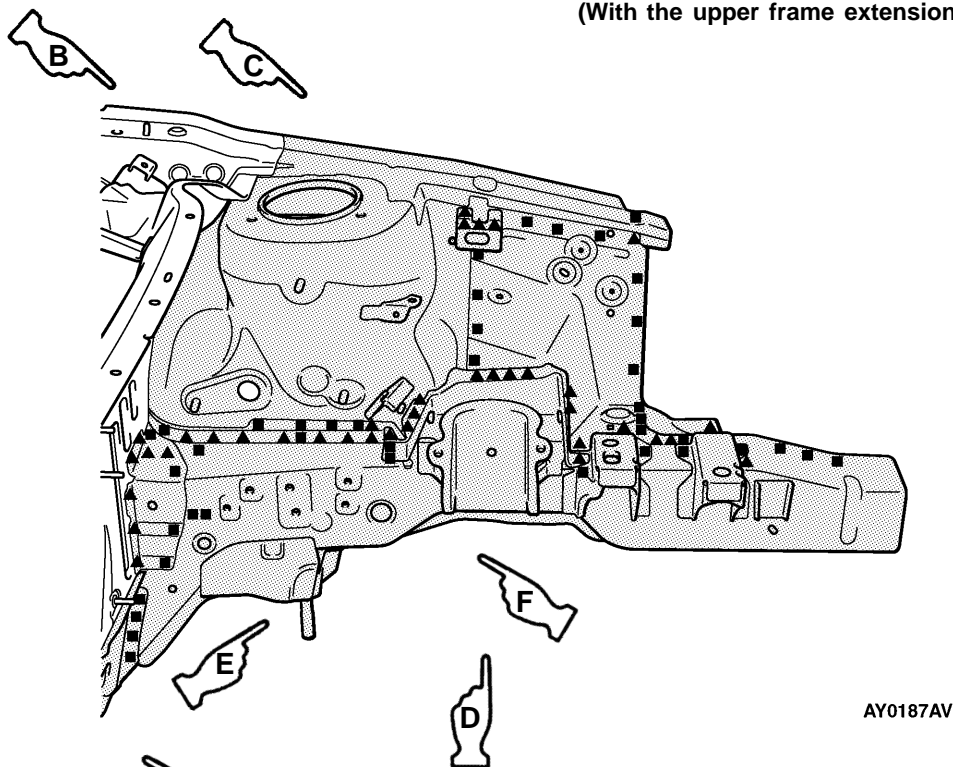


**B**

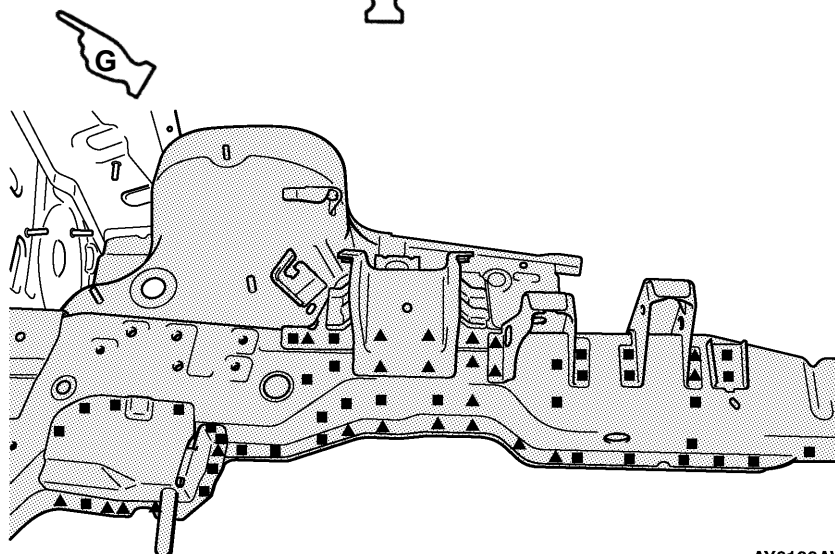


**C**

(With the upper frame extension outer removed)



AY0187AV



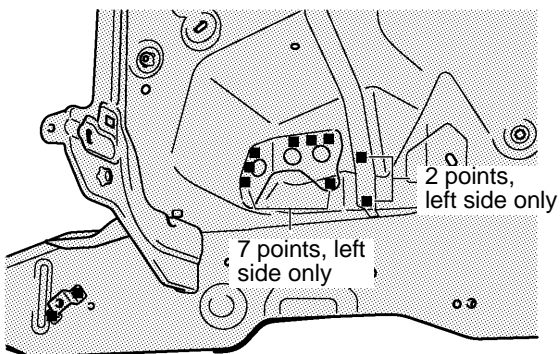
AY0188AV

**D**

## WELDED PANEL REPLACEMENT – Fender Shield

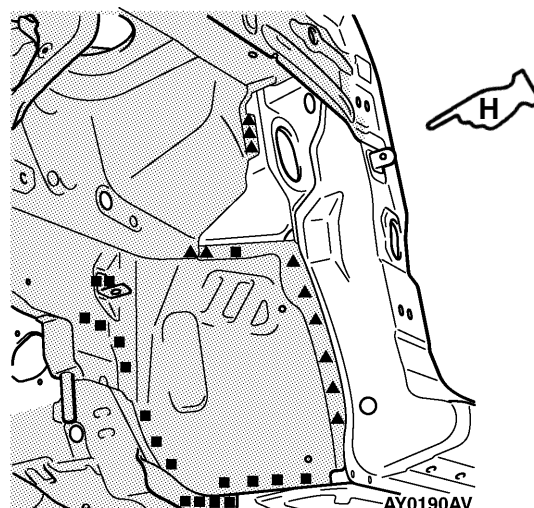
[Main  
Index](#)

[Group  
TOC](#)

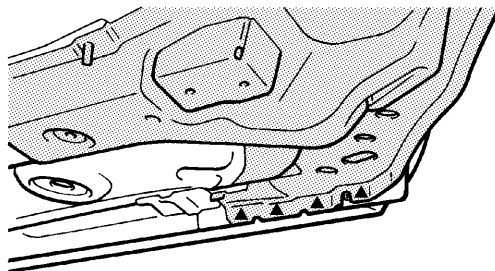


**E**

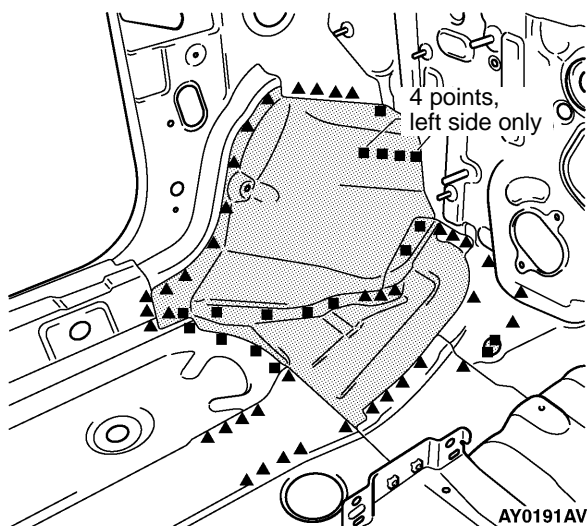
AY0189AV



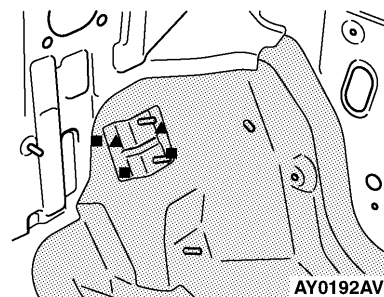
**F**



**G**



**H**

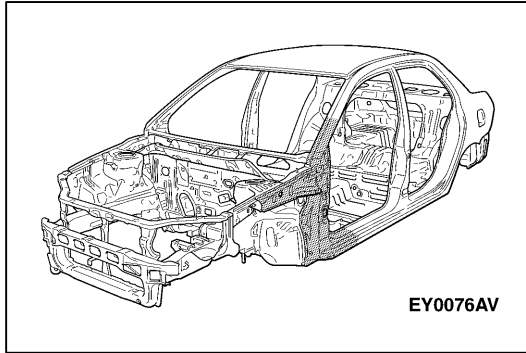


**H**

(Right side)

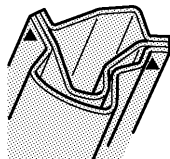


## FRONT PILLAR

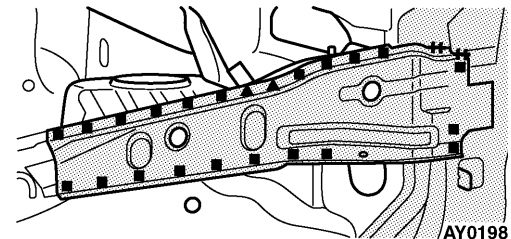


Symbol	Operation description
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
+ + + +	MIG spot welding
	MIG arc welding (continuous)
○○○○○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally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

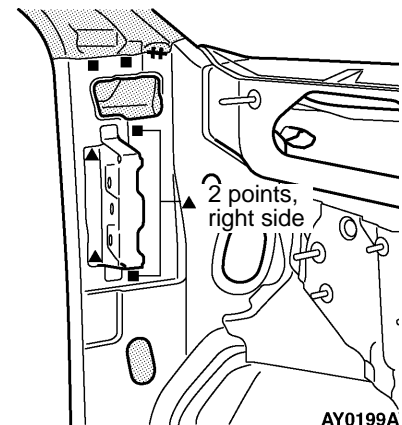
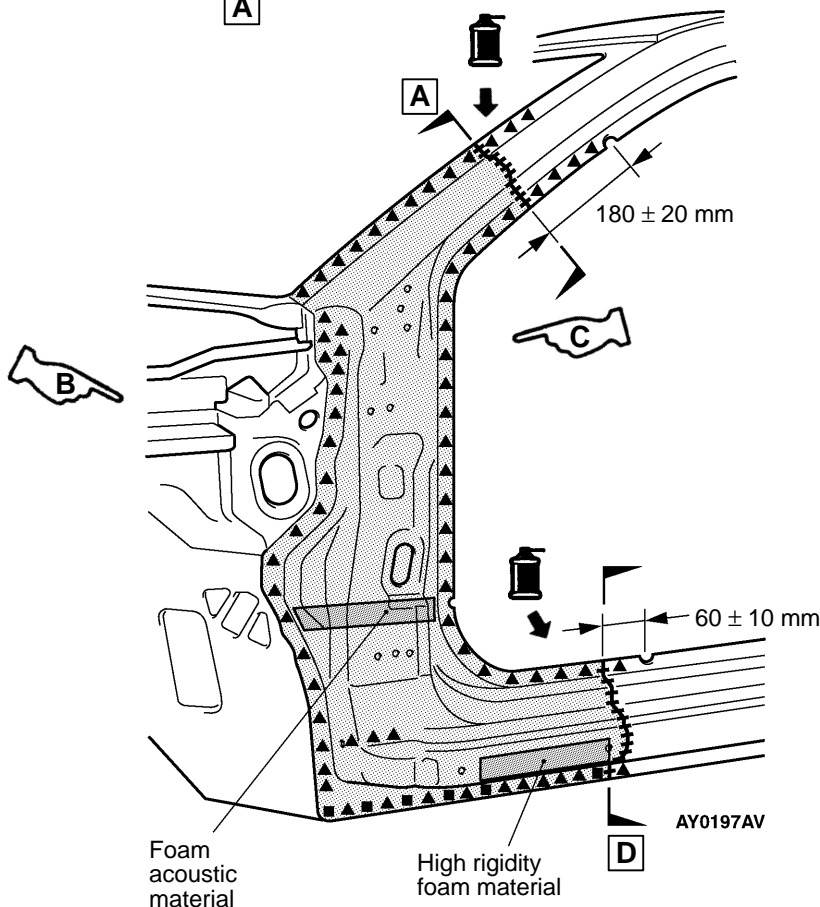
## REPAIR WELDS



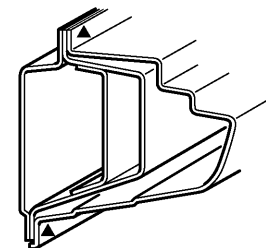
A



B



C



D

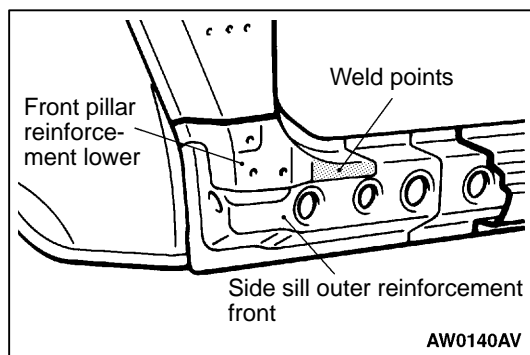
### Caution

Do not use heat at areas using foam material as the foam material may burn.

## WELDED PANEL REPLACEMENT – Front Pillar

Main  
Index

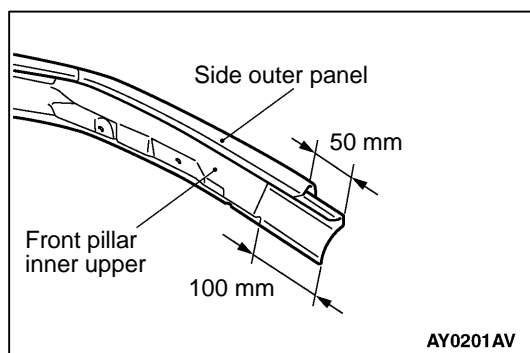
Group  
TOC



### NOTE ON REPAIR WORK

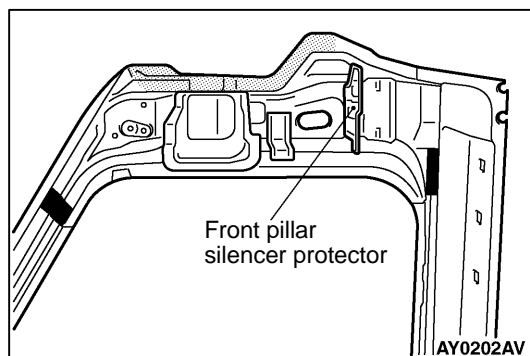
#### REMOVAL

As the front pillar reinforcement lower and side sill outer reinforcement front are welded at the side sill, cut the side outer panel at the position shown in the illustration where the weld points of the reinforcement can be seen, remove, and then remove the weld points of the front pillar reinforcement lower.



#### INSTALLATION

1. To ensure the strength of the cut area of the front pillar, cut the front pillar inner 100 mm above the cut area, and the side outer panel 50 mm above the cut area as shown in the illustration. Cut the new center pillar at the same positions.
2. Attach the front pillar inner upper assembly of the new front pillar to the body.

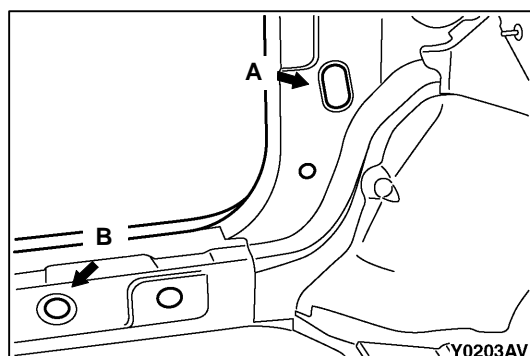


3. When attaching the front pillar outer of the new front pillar, attach the front pillar silencer protector, fill the gaps with butyl tape, and apply body sealant and adhesive at the locations indicated in the illustration.

■: Body sealant

■: Adhesive

ADHESIVE	TYPE	BRAND
	Epoxyayresin adhesive	3M-DP-460, 3M DP-420 or equivalent

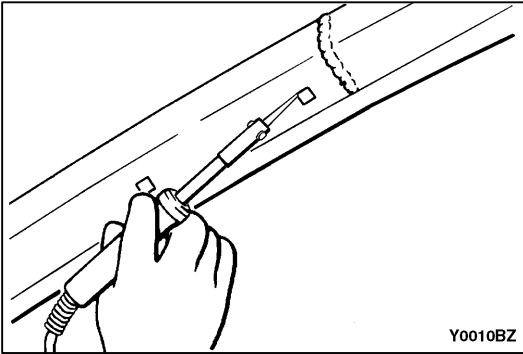


### <Vehicles for Hong Kong – 1800>

4. After attaching the front pillar outer, seal the holes and flanges with bolts and plate tape, and fill with foam material from the A, B holes as shown in the illustration.

Foam material	Type	Brand Used
A: Foam acoustic material	Foam hard polyurethane foam	Semedain hi-span foam
B: High rigidity foam material	Two fluid mix type foaming urethane	3M Super panel filler

## WELDED PANEL REPLACEMENT – Front Pillar

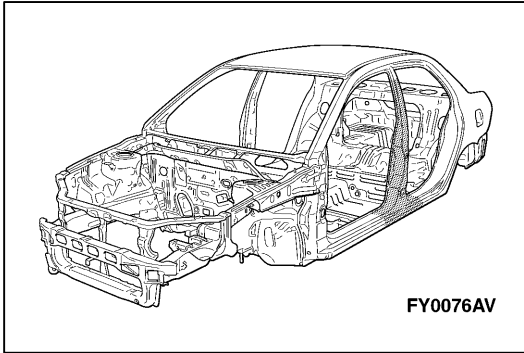


5. About two hours after filling the foam material, remove the bolts and plate tape, and solder the sealed holes until a clip, etc. can be inserted completely.

[Main  
Index](#)

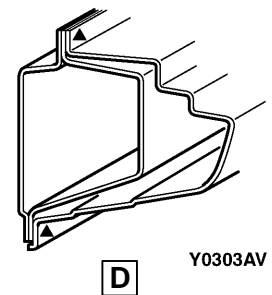
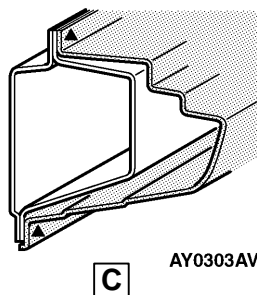
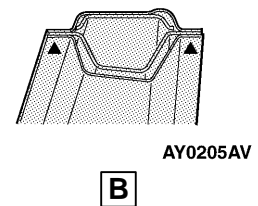
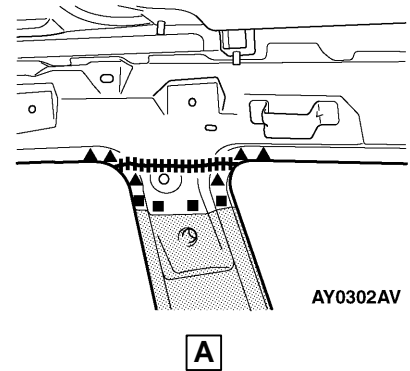
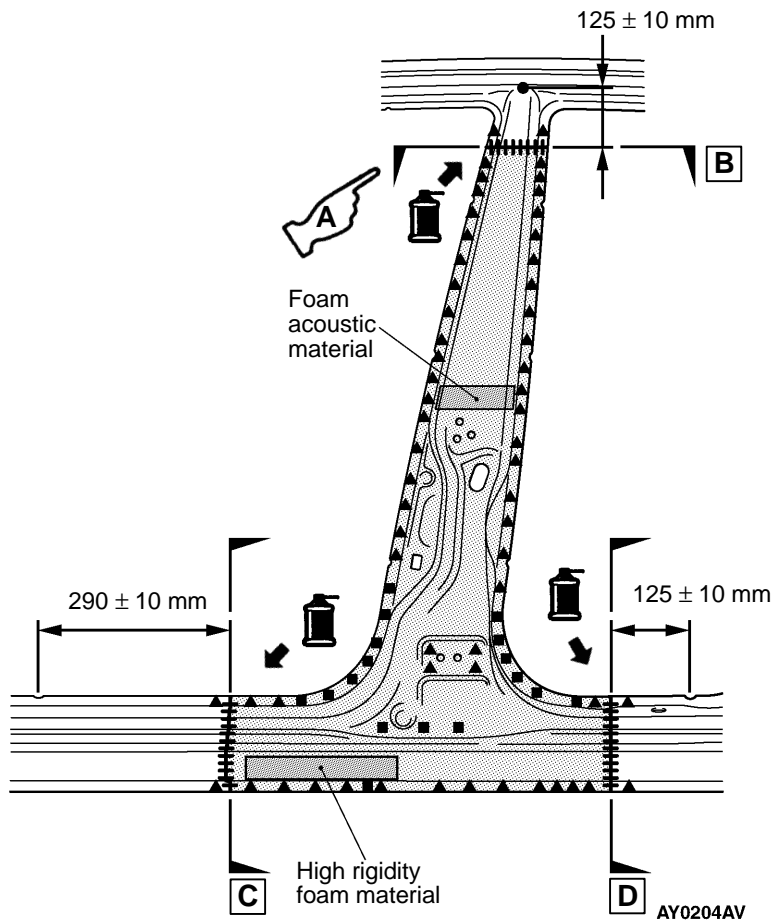
[Group  
TOC](#)

## CENTER 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)
○○○○○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally to butt-welded joints.)

### REPAIR WELDS



### Caution

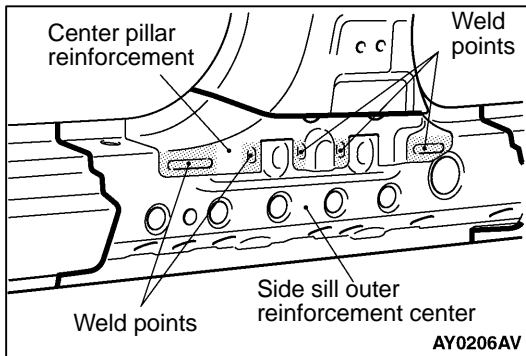
Do not use heat at areas using foam material as the foam material may burn.



## WELDED PANEL REPLACEMENT – Center Pillar

Main  
Index

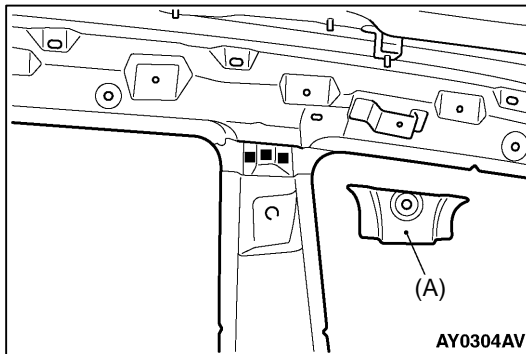
Group  
TOC



### NOTE ON REPAIR WORK

#### REMOVAL

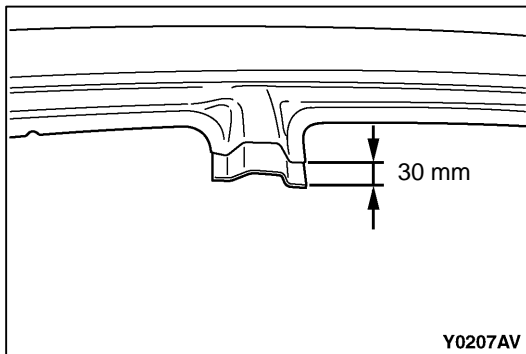
1. As the center pillar reinforcement and side sill outer reinforcement center are joined at the side sill, cut the side outer panel at the position shown in the illustration where the weld points can be seen, remove, and then remove the weld points.



2. To cut the weld points of the center pillar seatbelt reinforcement and center pillar reinforcement, cut at the bottom of the roof side rail inner as shown in the illustration.

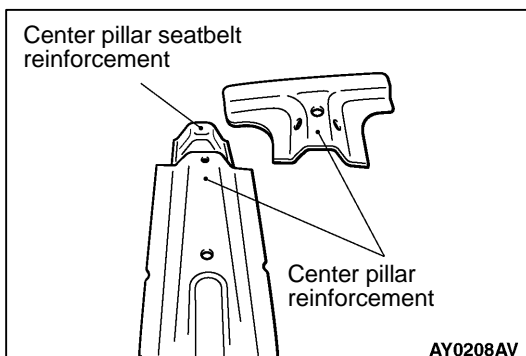
#### NOTE

Keep the roof side rail inner (A) cut for use later.



#### INSTALLATION

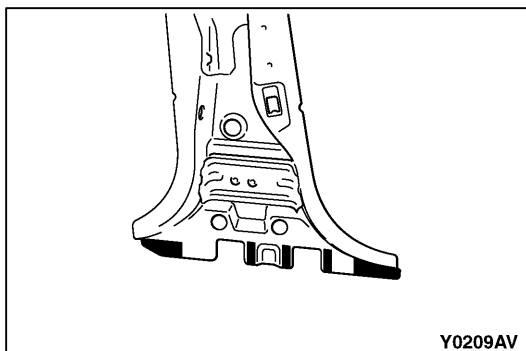
1. Remove the side outer panel, side sill outer reinforcement center, side sill bulkhead, and side sill reinforcement support from the new center pillar.
2. To ensure the strength of the cut area at the top of the center pillar, cut the side outer panel 30 mm above the cut area.  
Cut the new center pillar at the same positions.



3. To prevent damage of the center pillar seatbelt reinforcement, align the new center pillar reinforcement only to the body side and cut.

#### Caution

If the center pillar seatbelt reinforcement has been damaged, repair by welding.



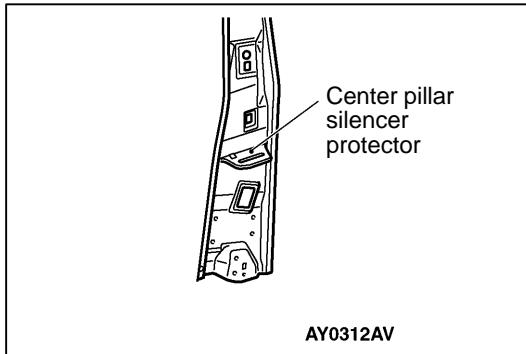
4. When attaching the center pillar reinforcement, apply adhesive to the locations indicated in the illustration.  
■: Adhesive

ADHESIVE	TYPE	BRAND
	Epoxyayresin adhesive	3M-DP-460, 3M DP-420 or equivalent

## WELDED PANEL REPLACEMENT – Center Pillar

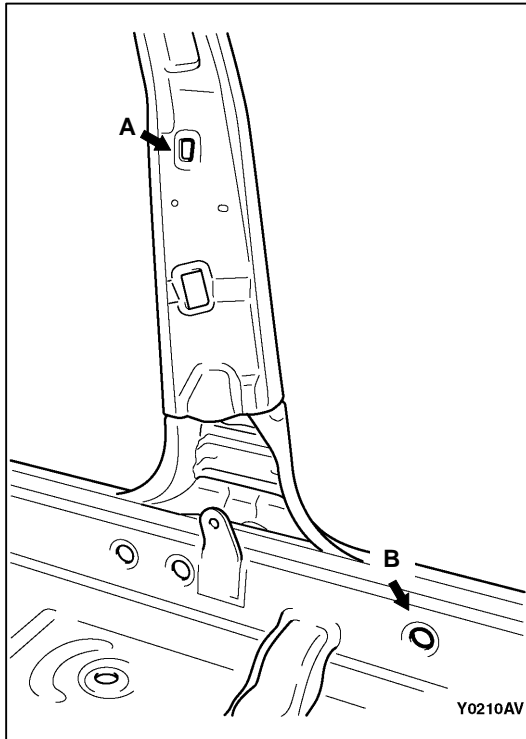
Main  
Index

Group  
TOC



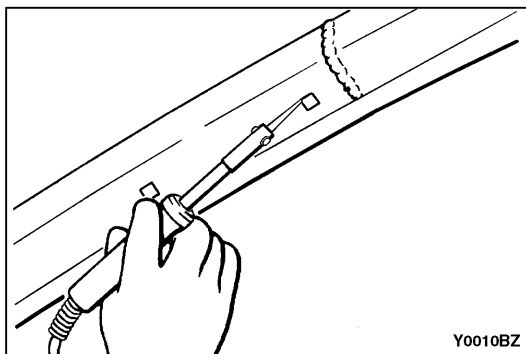
### <Vehicles for Hong Kong – 1800>

- When attaching the center pillar inner, attach the center pillar silencer protector to the center pillar inner, and seal the holes of the center pillar silencer protector with butyl tape.



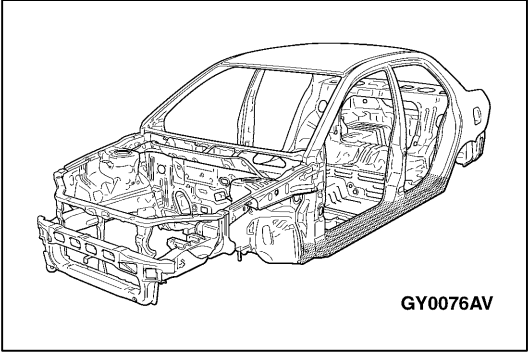
- After attaching the center pillar outer, seal the holes and flanges with bolts and plate tape, and fill with foam material from the A and B holes.

Foam material	Type	Brand Used
A: Foam acoustic material	Foam hard polyurethane foam	Semedain hi-span foam
B: High rigidity foam material	Two fluid mix type foaming urethane	3M Super panel filler



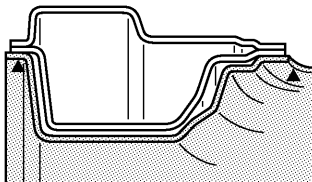
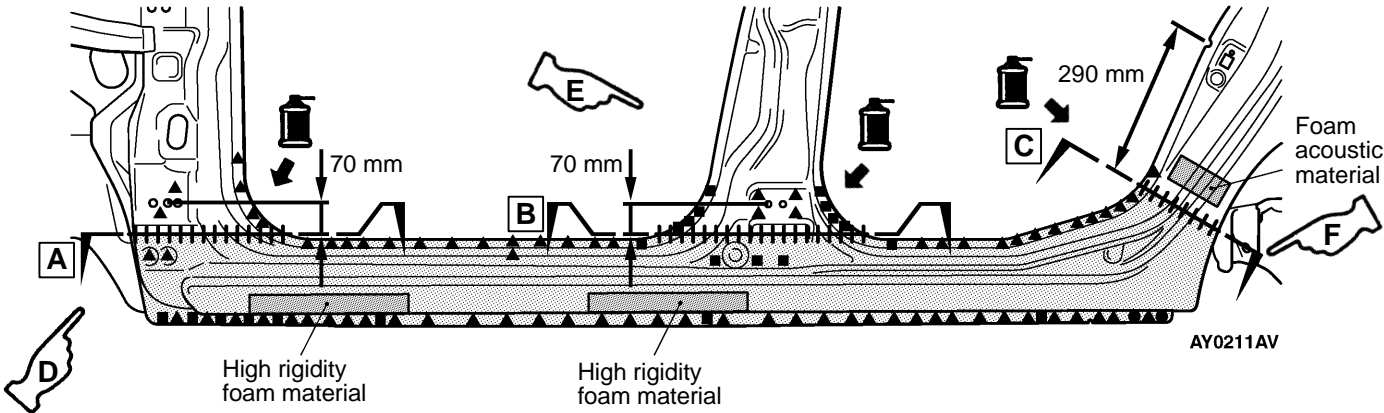
- About two hours after filling the foam material, remove the bolts and plate tape, and solder the sealed holes until a clip, etc. can be inserted completely.

SIDE SILL

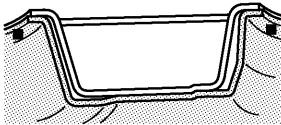


Symbol	Operation description
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
+ + + +	MIG spot welding
	MIG arc welding (continuous)
○ ○ ○ ○ ○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply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

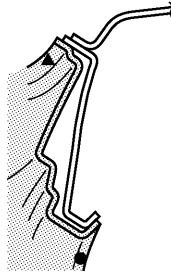
REPAIR WELDS



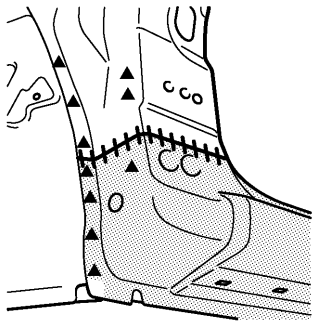
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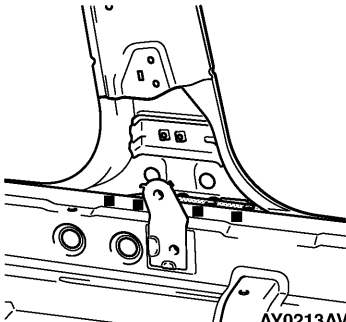
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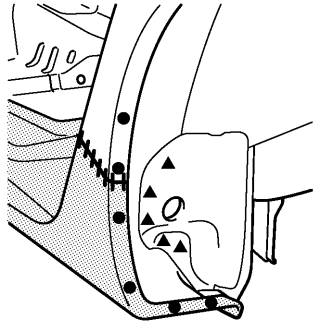
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AY0212AV

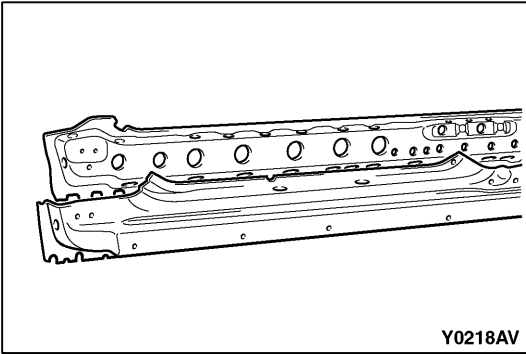


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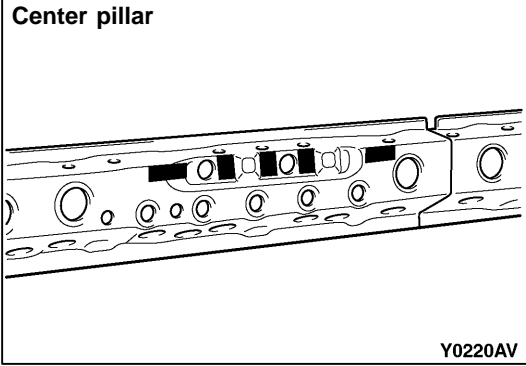
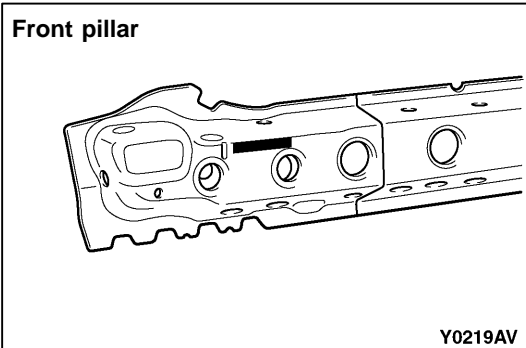
AY0214AV

**Caution**  
Do not use heat at areas using foam material as the foam material may burn.



**NOTE ON REPAIR WORK  
INSTALLATION**

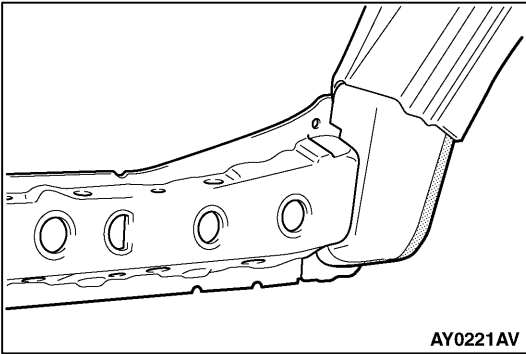
1. Remove the side outer panel of the side sill as shown in the illustration, and remove the front pillar lower reinforcement, center pillar reinforcement from the side sill outer reinforcement.



2. When attaching the side sill outer reinforcement, apply adhesive to the areas indicated in the illustration.

■: Adhesive

ADHESIVE	TYPE	BRAND
	Epoxyayresin adhesive	3M-DP-460, 3M DP-420 or equivalent



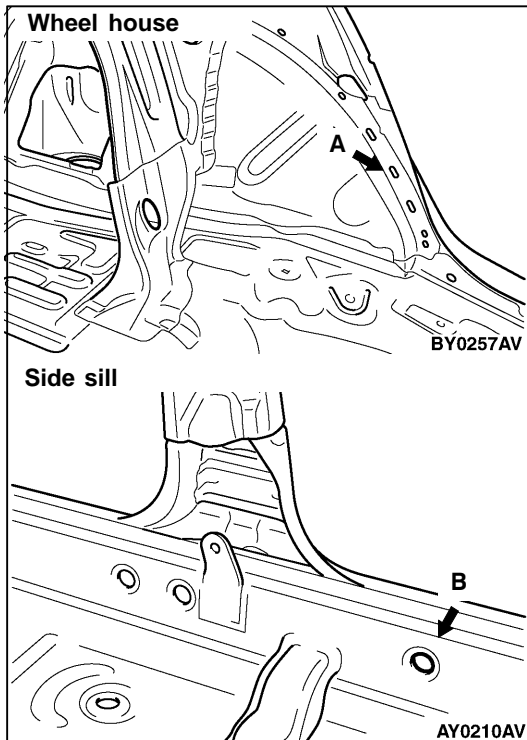
3. When attaching the side outer panel, apply body sealant to the areas indicated in the illustration.

▨: Body sealant

## WELDED PANEL REPLACEMENT – Side Sill

Main  
Index

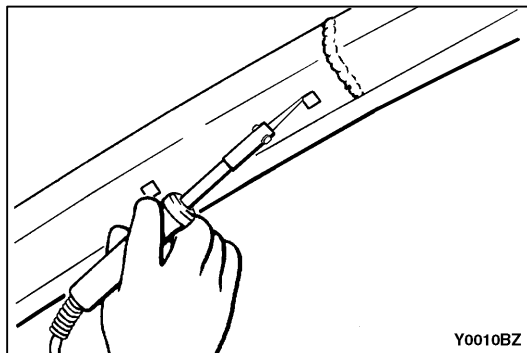
Group  
TOC



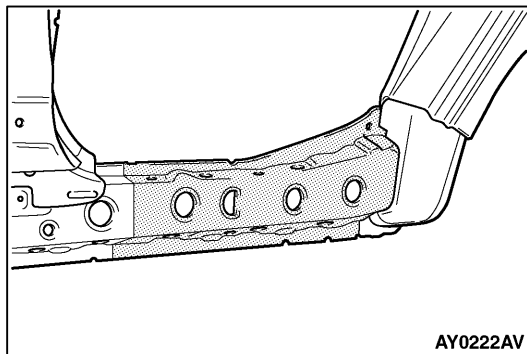
### <Vehicles for Hong Kong – 1800>

- After attaching the side outer panel, seal the holes and flanges with bolts and plate tape, and fill foam material from holes A and B shown in the illustration.

Foam material	Type	Brand Used
A: Foam acoustic material	Foam hard polyurethane foam	Semedain hi-span foam
B: High rigidity foam material	Two fluid mix type foaming urethane	3M super panel filler



- About two hours after filling the foam material, remove the bolts and plate tape, and solder the sealed holes until a clip, etc. can be inserted completely.



### Reference

Depending on the damaged range, it is advisable to replace the side outer panel and side sill outer reinforcement parts.

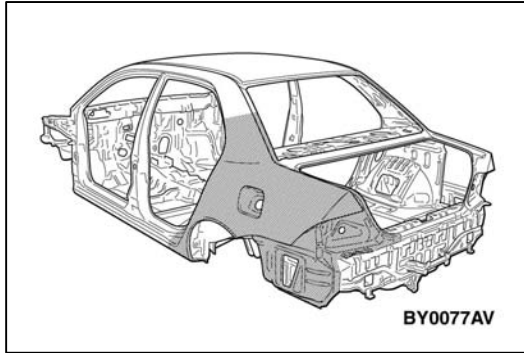
■ :Cuttable range

### Caution

Cut the side sill outer reinforcement 50 mm away from the cut area of the side outer panel.

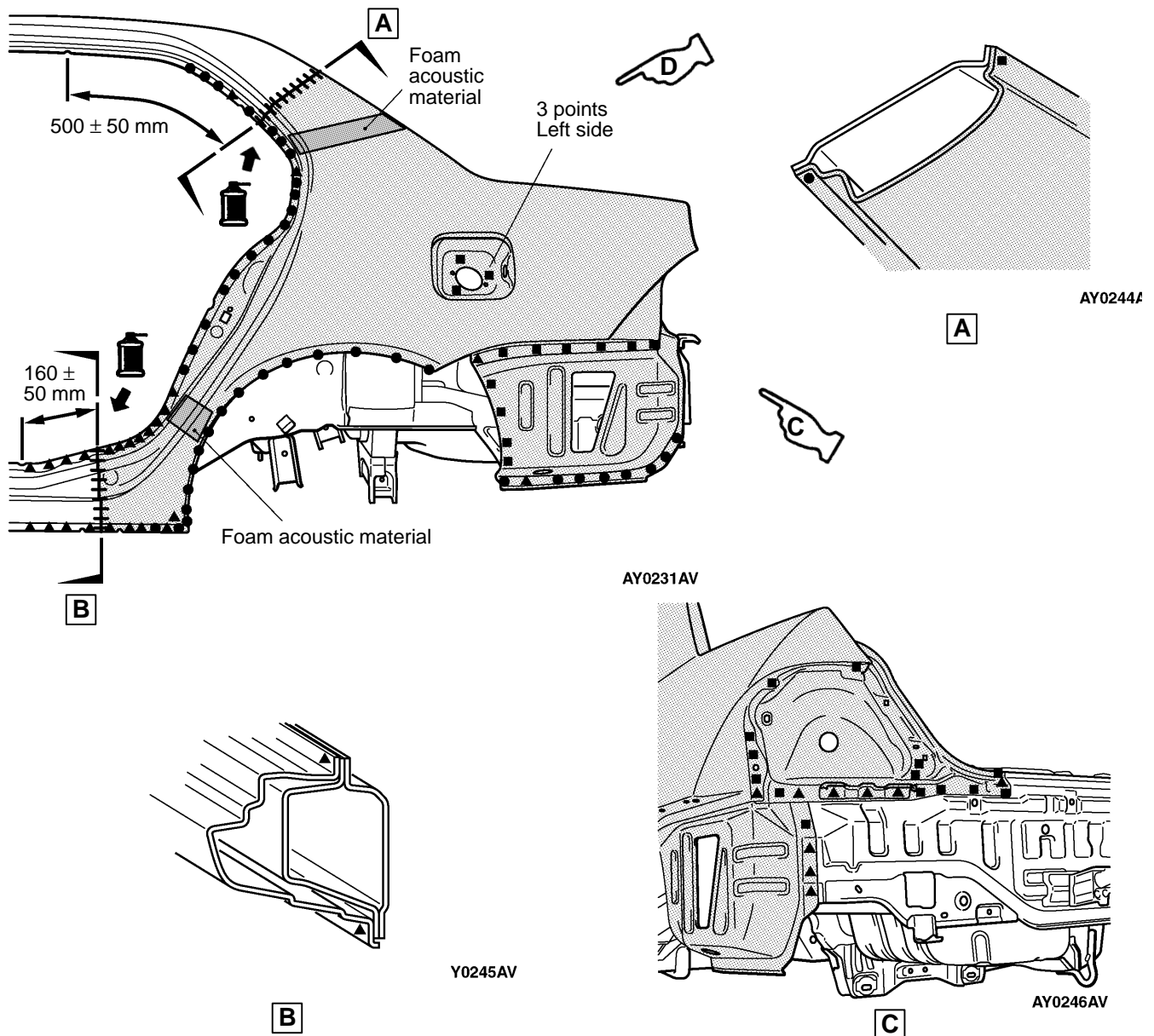


## QUARTER, OUTER



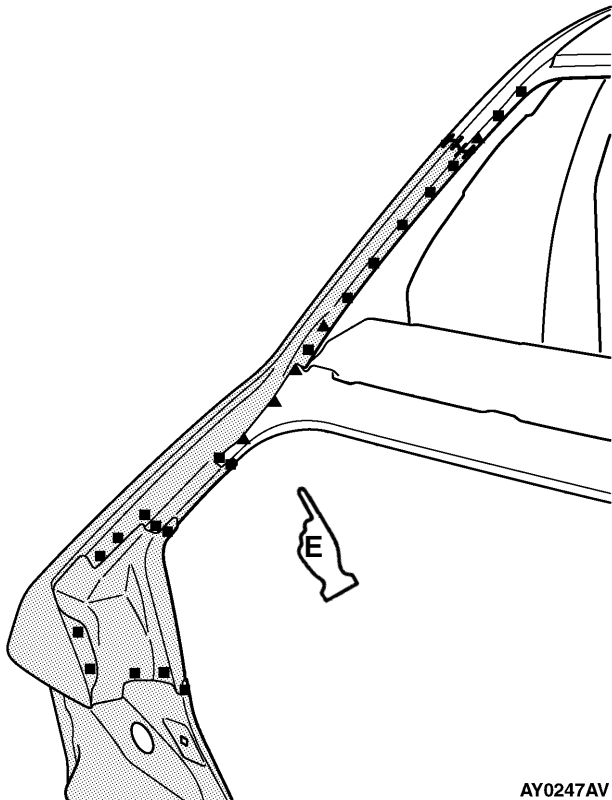
Symbol	Operation description
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
+ + + +	MIG spot welding
	MIG arc welding (continuous)
○○○○○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally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

### REPAIR WELDS



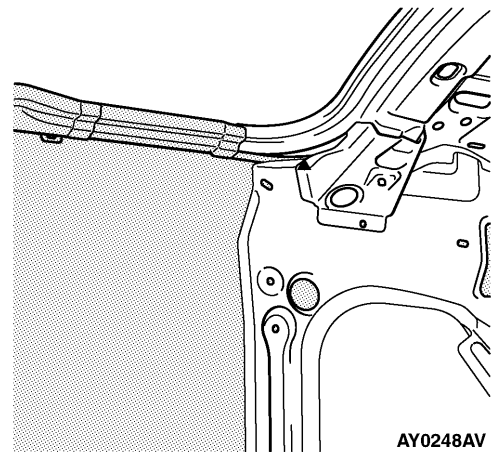
### Caution

Do not use heat at areas using foam material as the foam material may burn.



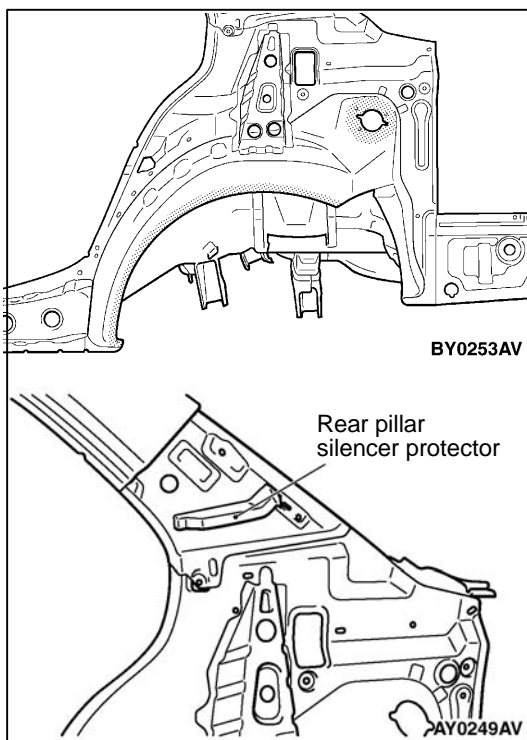
**D**

AY0247AV



AY0248AV

**E**



BY0253AV

Rear pillar  
silencer protector

AY0249AV

## NOTE ON REPAIR WORK INSTALLATION

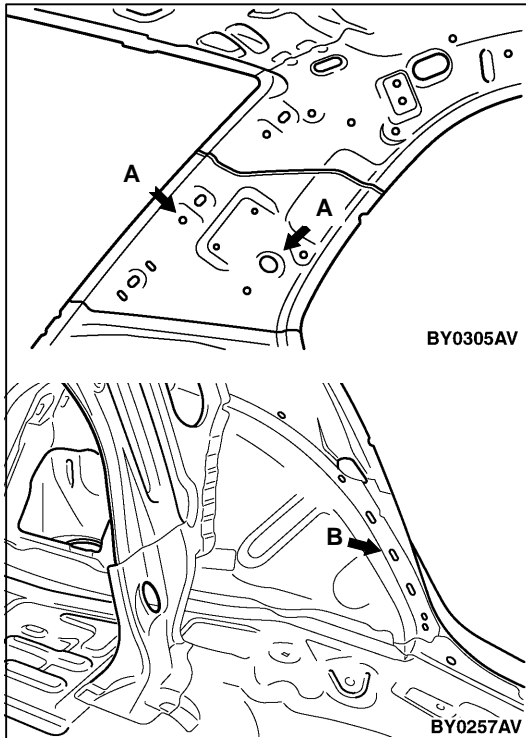
1. When attaching the quarter outer, apply sealant to the areas indicated in the illustration. For standard roof vehicles, attach the rear pillar silencer protector, and fill the gaps with butly tape.

■ : Body sealant

## WELDED PANEL REPLACEMENT – Quarter, Outer

Main  
Index

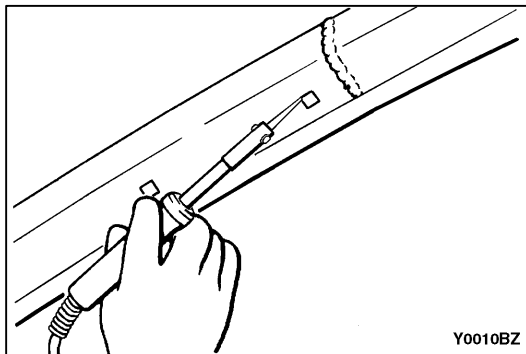
Group  
TOC



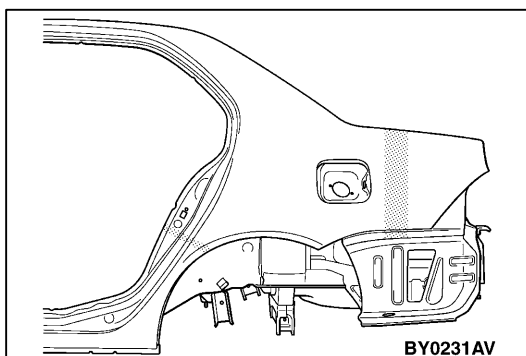
- After attaching the quarter outer, seal the holes and flanges with bolts and plate tape, and fill foam material from hole shown in the illustration.

A: Standard roof vehicle  
B: Vehicles for Hong Kong – 1800

Foam material	Type	Brand Used
Foam acoustic material	Foam hard polyurethane foam	Semedain hi-span foam



- After two hours after filling the foam material, remove the bolts and plate tape, and solder the sealed holes until a clip, etc. can be inserted completely.



### Reference

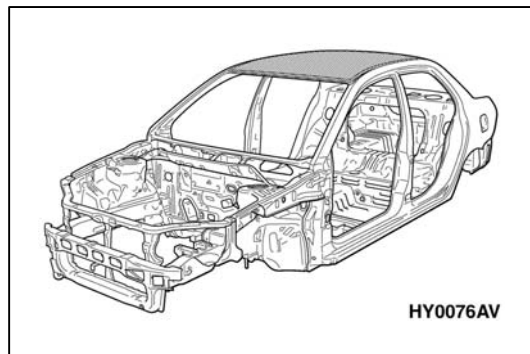
Parts replacement is advised. depending on the damaged range.


▨ : Cuttable range

### Caution

Avoid the fuel filler bracket (left side).

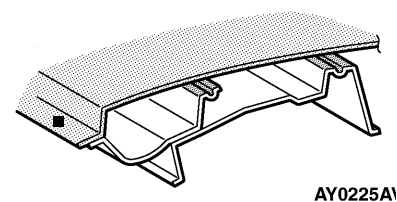
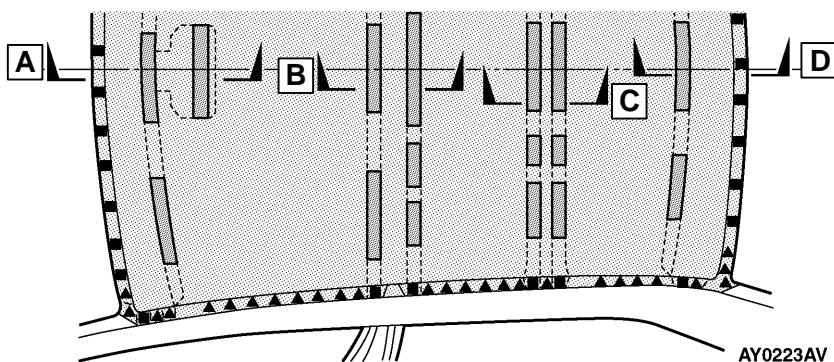
## ROOF

[Main Index](#)
[Group TOC](#)


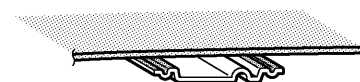
Symbol	Operation description
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
+ + + +	MIG spot welding
	MIG arc welding (continuous)
○○○○○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally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

## REPAIR WELDS

### Standard roof



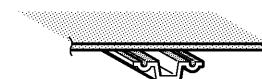
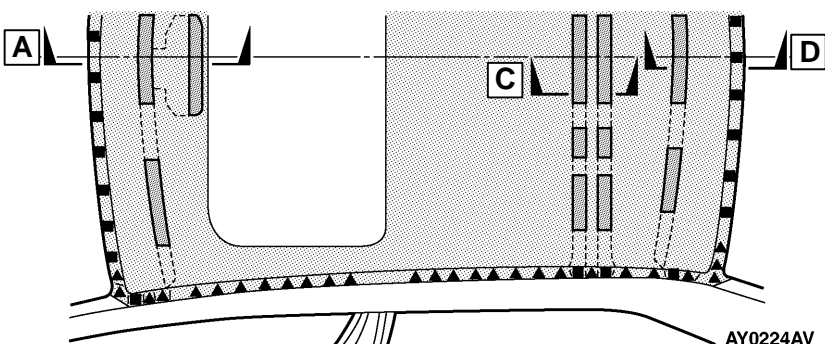
A



B

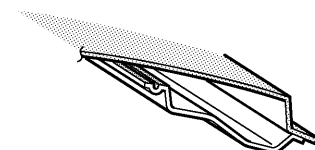
AY0226A

### Sunroof



C

AY0227AV



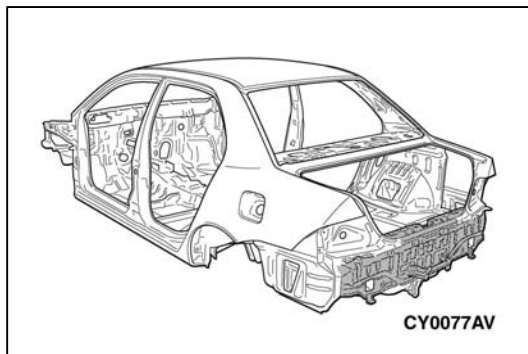
D


AY0228A

 : Adhesive

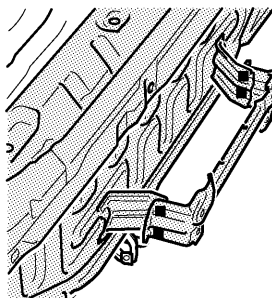
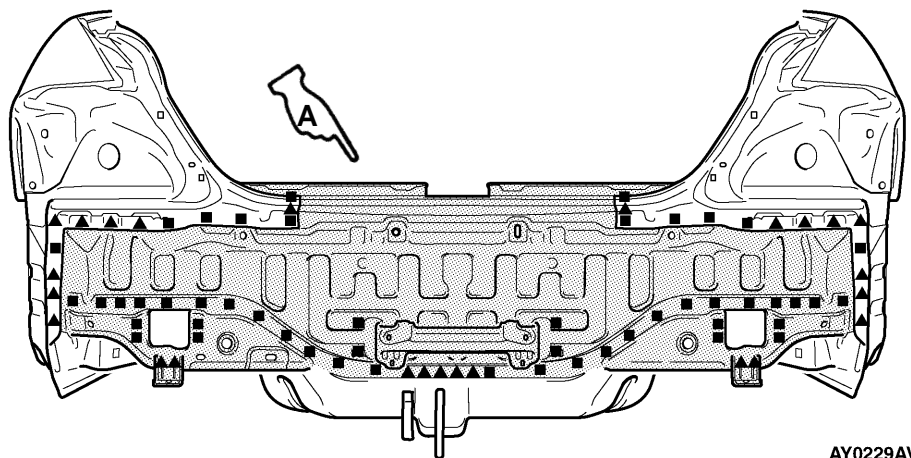
ADHESIVE	TYPE
	Chloroprene-base drying sealant

## REAR END PANEL



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

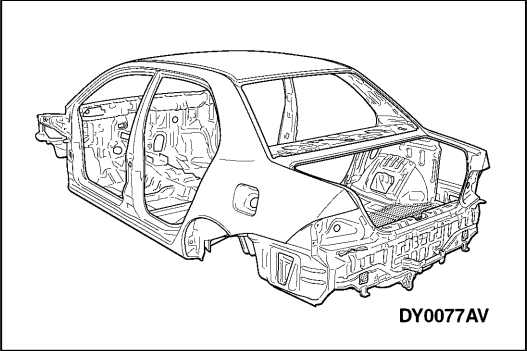



**A**

(Large bumper mounted vehicle)

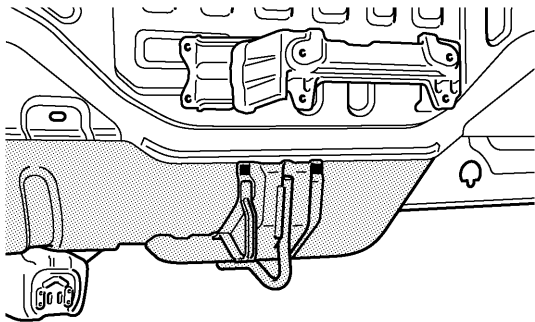
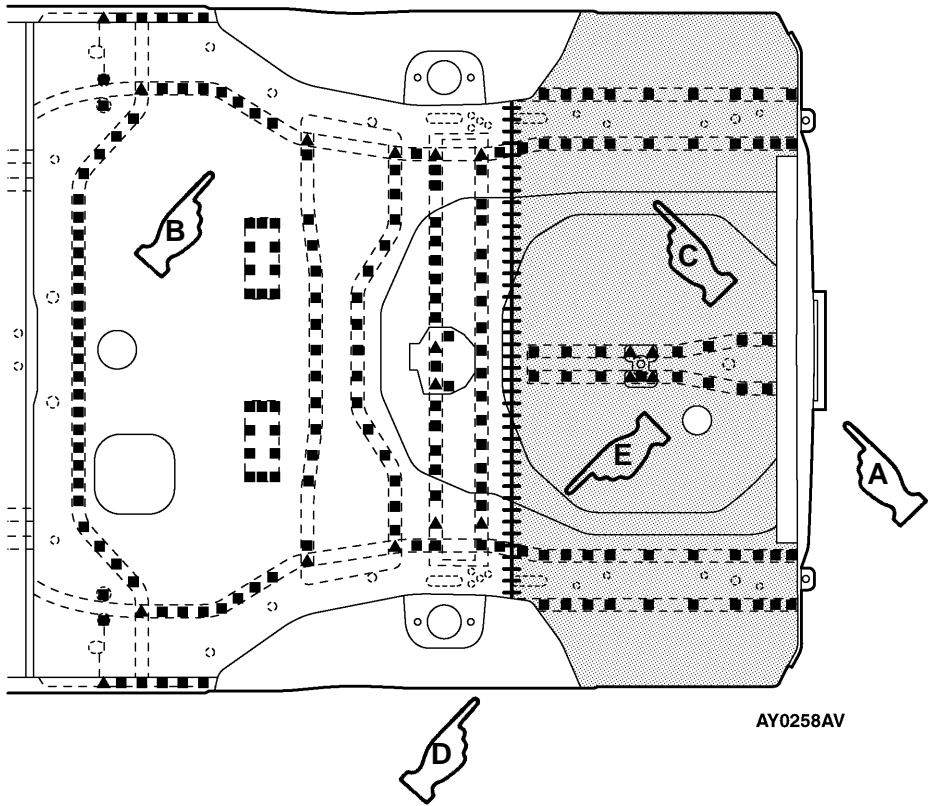


# REAR FLOOR



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

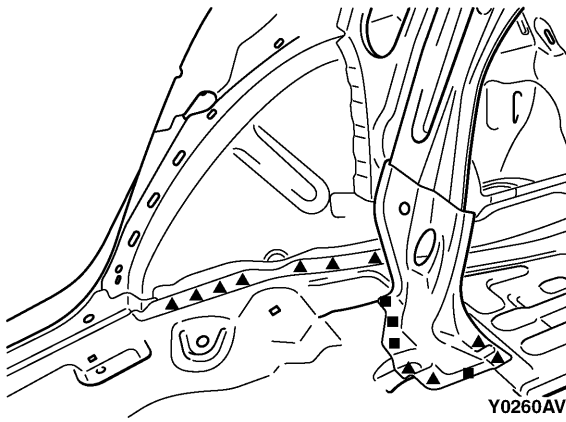


A

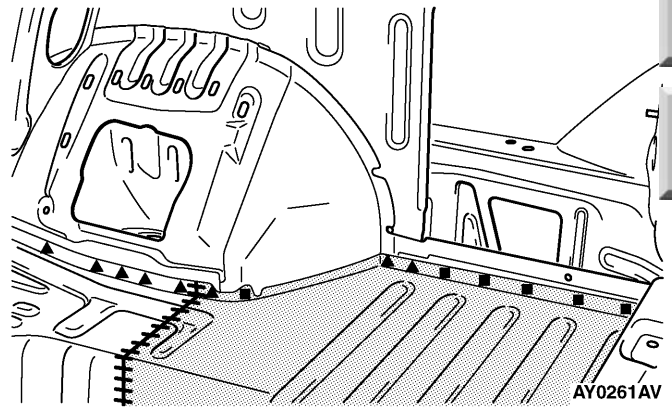
## WELDED PANEL REPLACEMENT – Rear Floor

Main  
Index

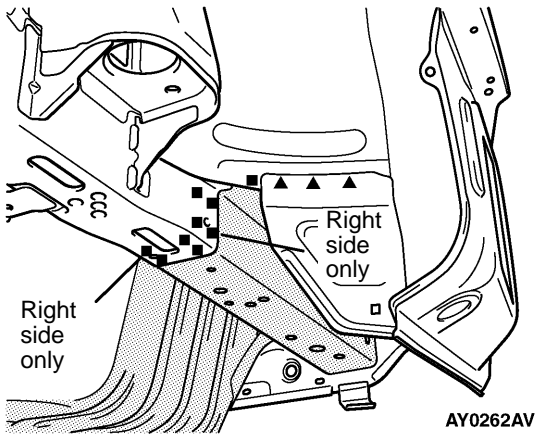
Group  
TOC



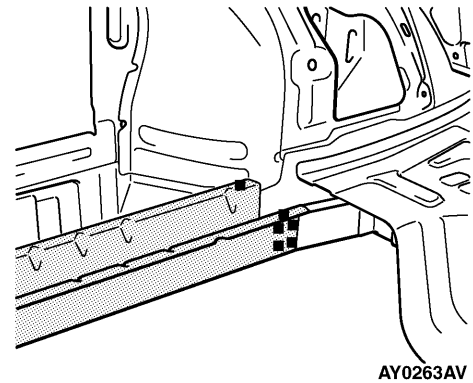
B



C



D

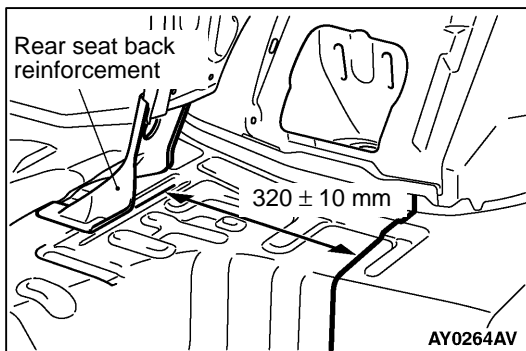


E

(With the rear floor pan.)

### NOTE

For details on the weld points with the rear end panel refer to [Rear End Panel](#).

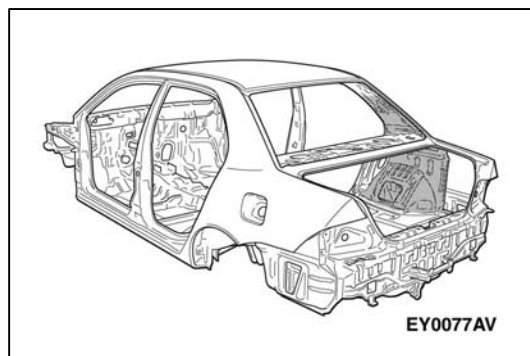



### NOTE ON REPAIR WORK

#### REMOVAL

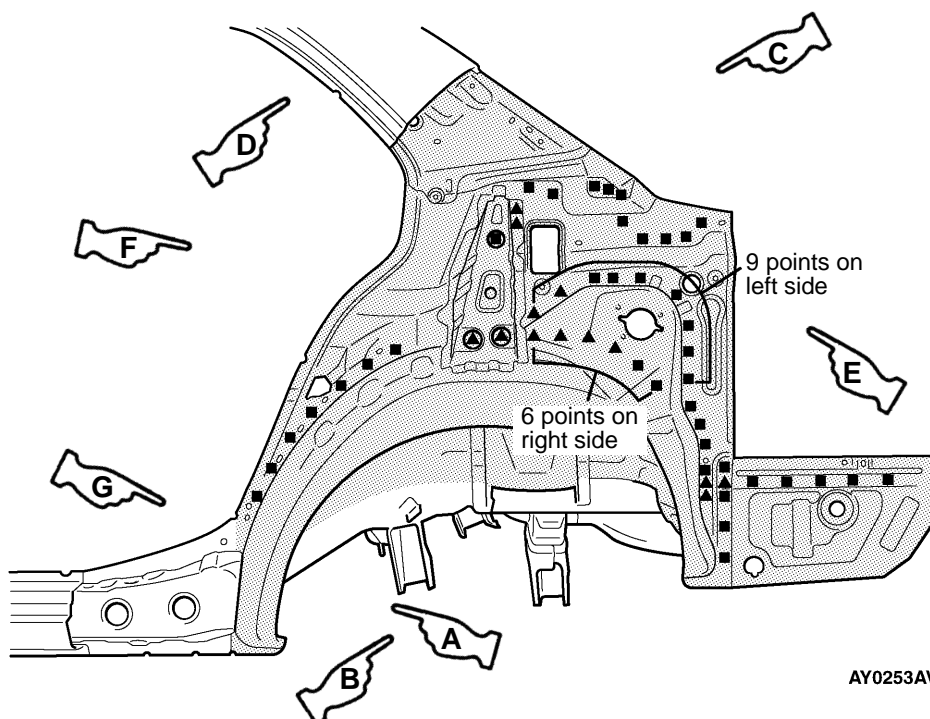
1. Cut the rear floor panel  $320 \pm 10$  mm from the back of the rear seat back reinforcement.

## QUARTER, INNER

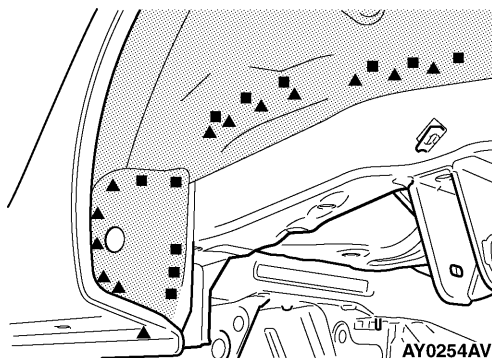


Symbol	Operation description
• • • •	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
+ + + +	MIG spot welding
	MIG arc welding (continuous)
○○○○○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally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

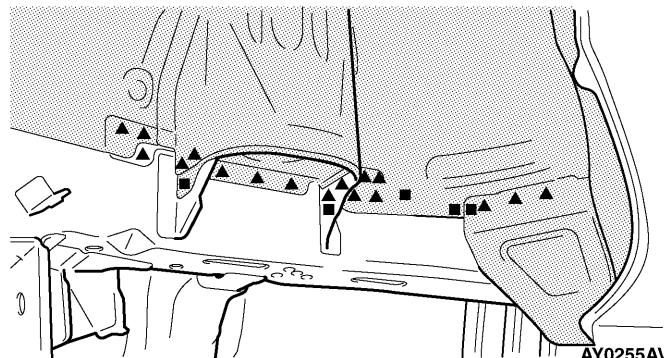
### REPAIR WELDS



(With the quarter outer removed)



**A**



**B**

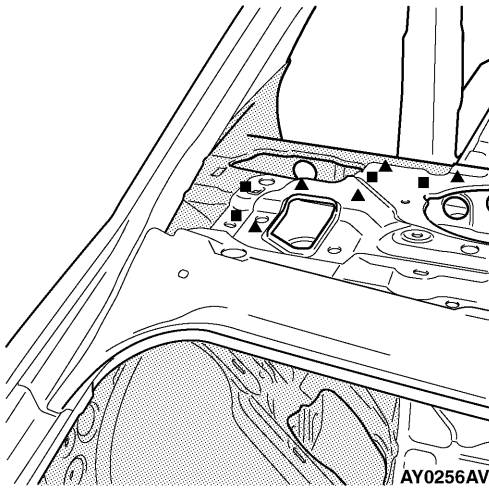
#### NOTE

Refer to the weld points to the [quarter outer](#).

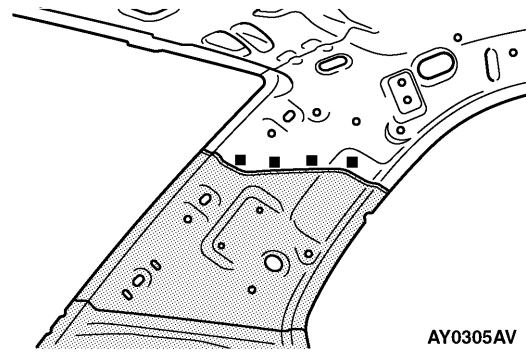
## WELDED PANEL REPLACEMENT – Quarter, Inner

[Main  
Index](#)

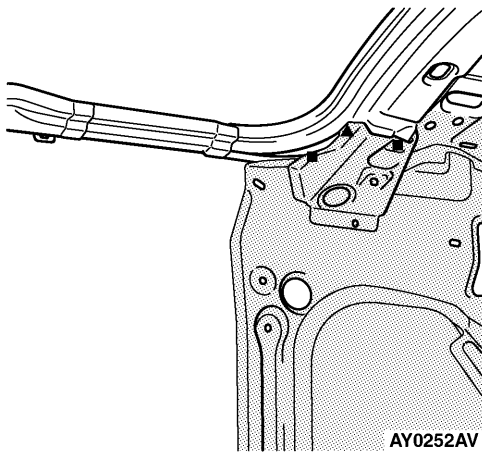
[Group  
TOC](#)



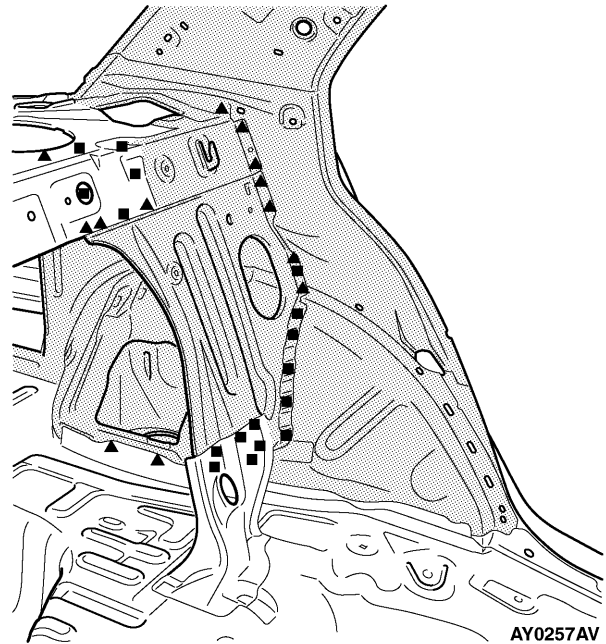
**C**



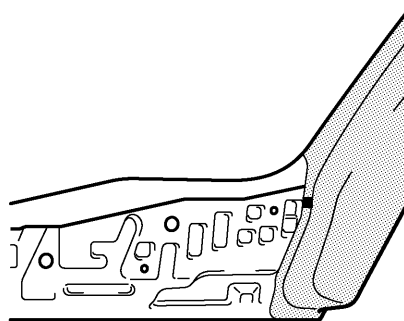
**D**



**E**



**F**

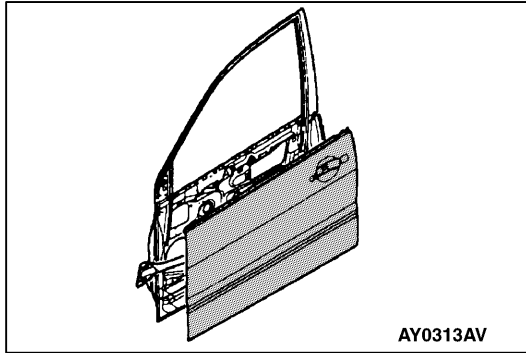



AX0125AV

**G**

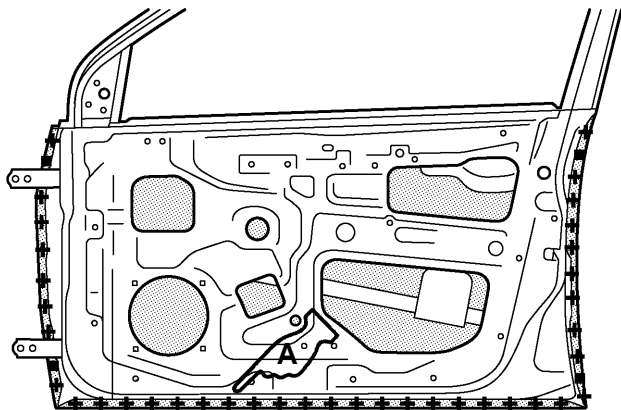
(With the side sill outer reinforcement rear removed.)

## FRONT DOOR

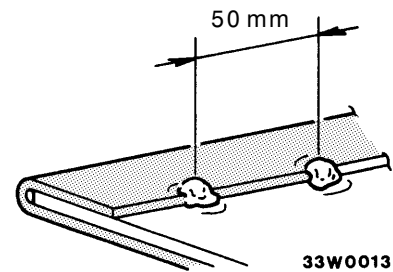


Symbol	Operation description
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
+ + + +	MIG spot welding
	MIG arc welding (continuous)
○○○○○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally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

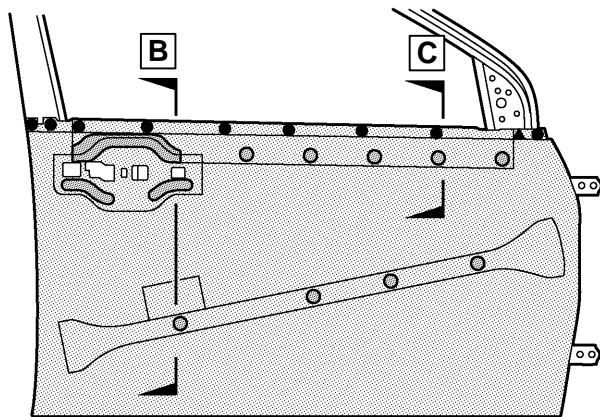
### REPAIR WELDS



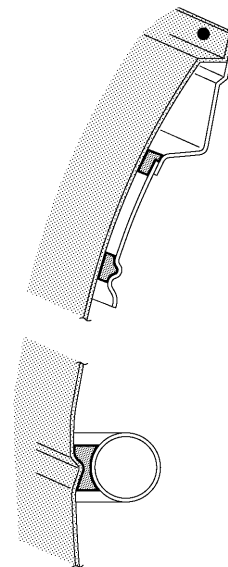
AY0265AV



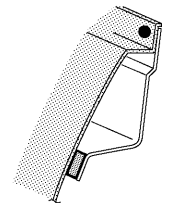
A



AY0266AV



B



AY0268AV

C

 : Adhesive

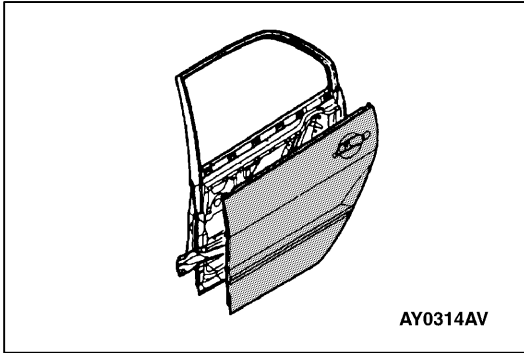
ADHESIVE	TYPE
	Chloroprene-base drying sealant

### NOTE

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

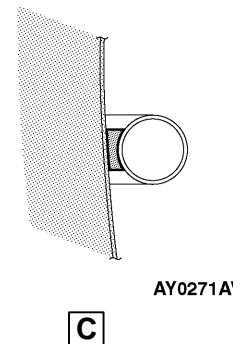
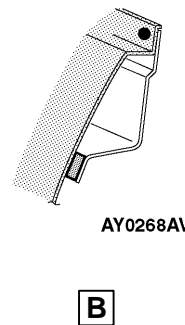
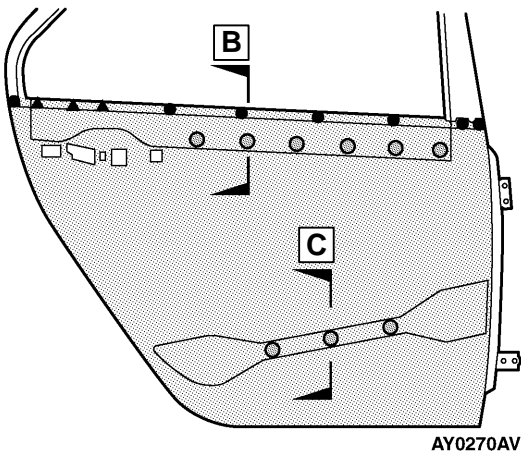
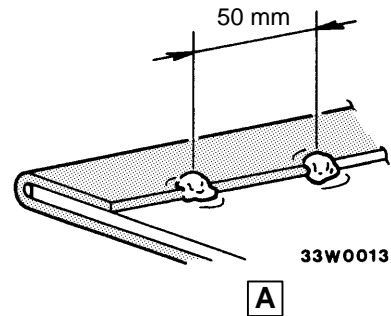
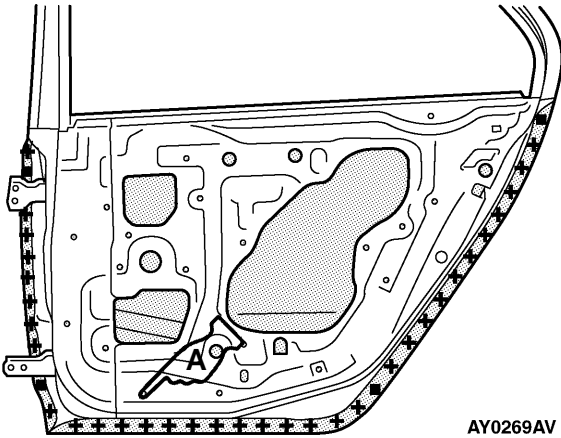


## REAR DOOR



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

ADHESIVE	TYPE
	Chloroprene-base drying sealant

### NOTE

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