

GROUP 3

WELDED PANEL REPLACEMENT

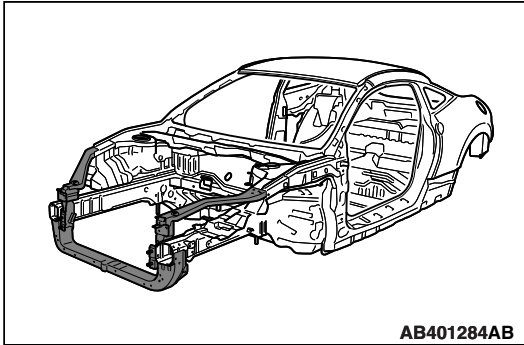
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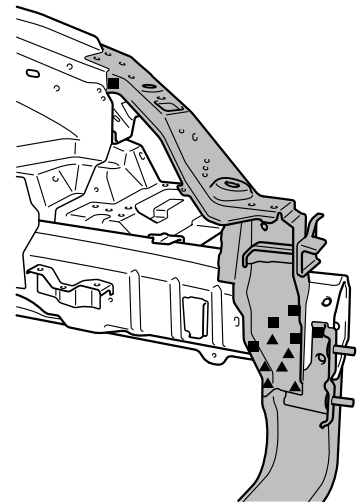
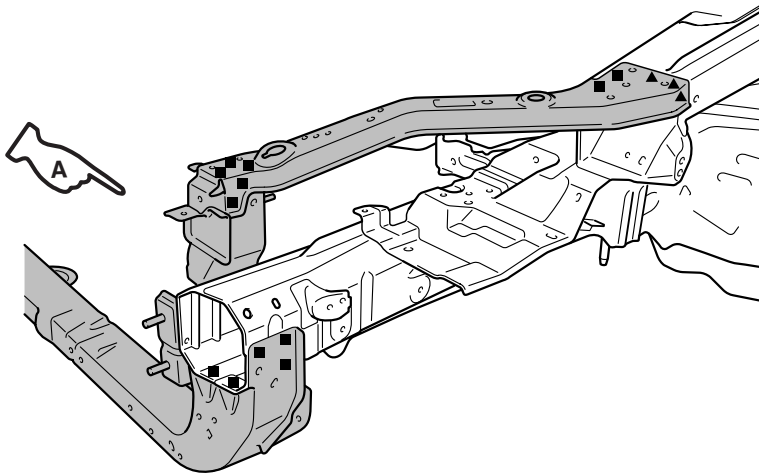
HEADLIGHT SUPPORT

M4030003000382



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

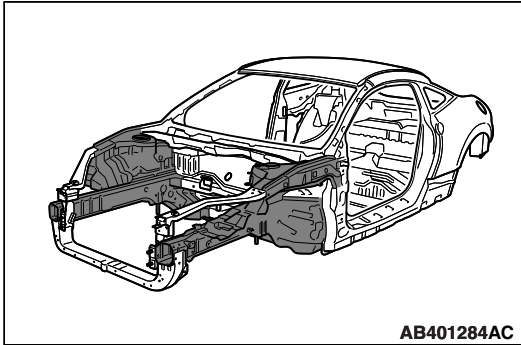


A

AB400981AB

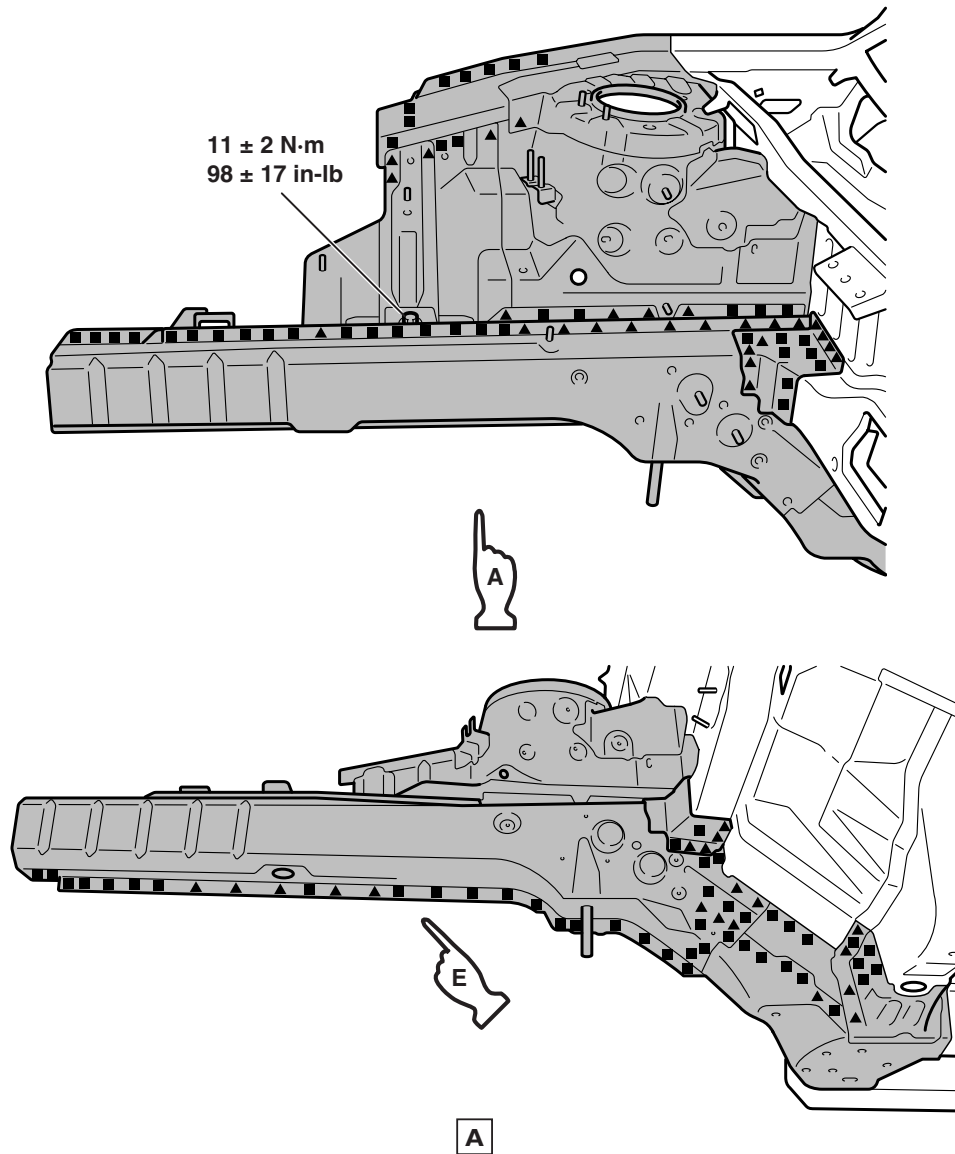
FENDER SHIELD

M4030004000482



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.)

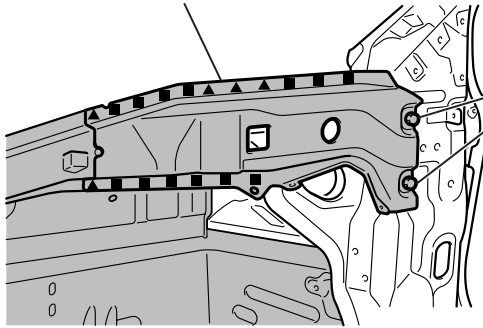
REPAIR WELDS



AB401076AB

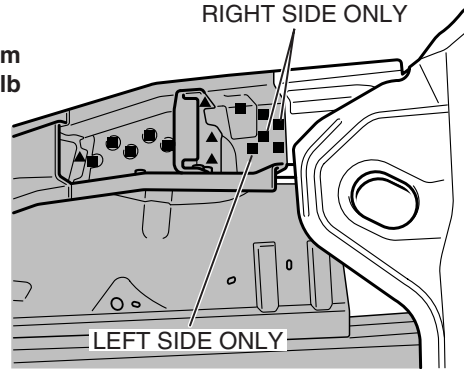
NOTE: Refer to the Headlight Support section on P.3-3 for the welding point with headlight support.

UPPER FRAME OUTER EXTENSION



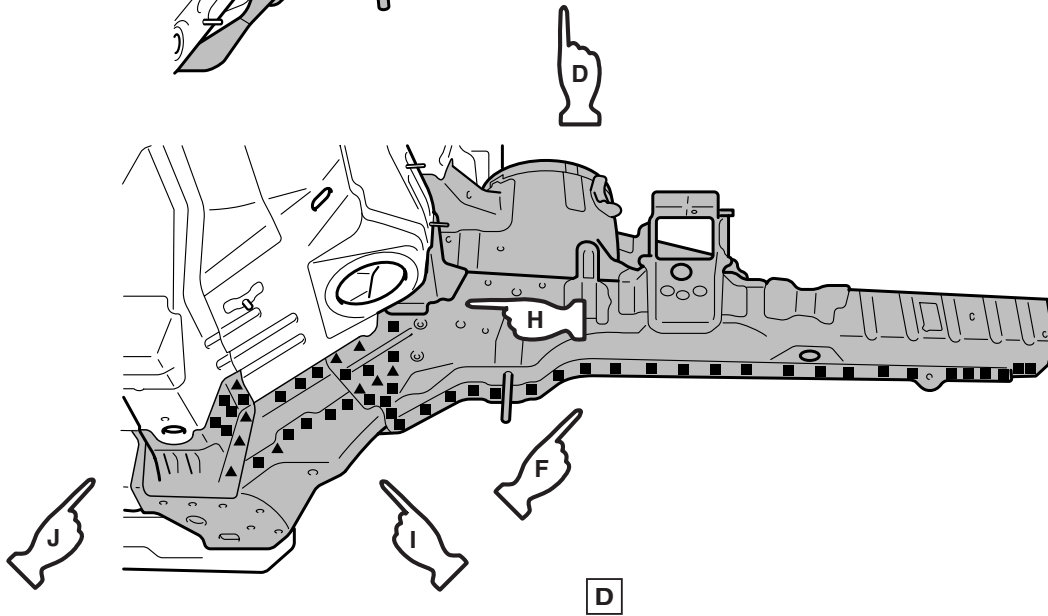
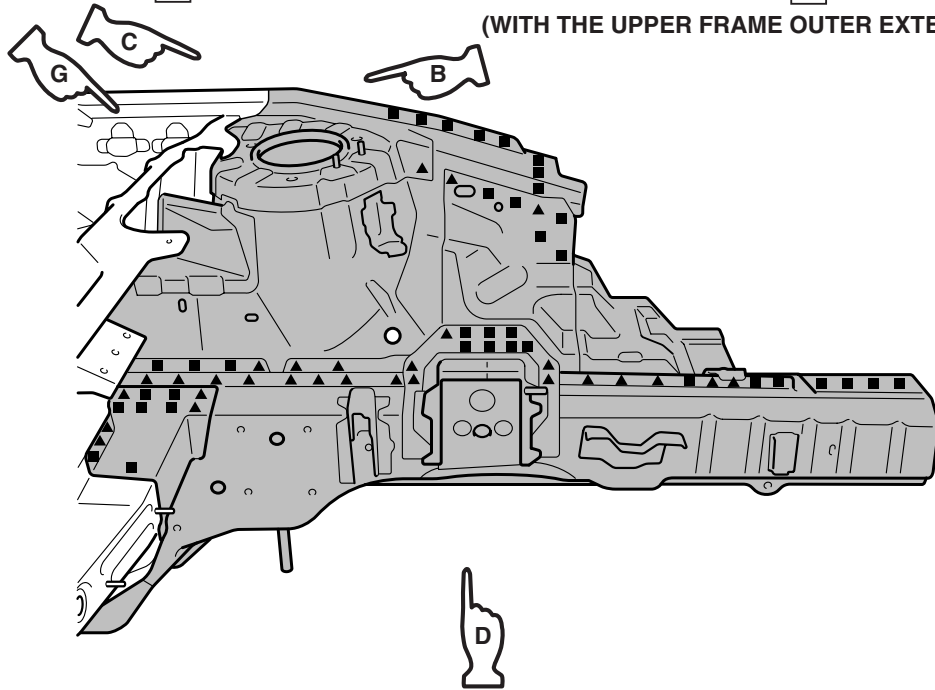
23 ± 4 N·m
 17 ± 3 ft·lb

RIGHT SIDE ONLY

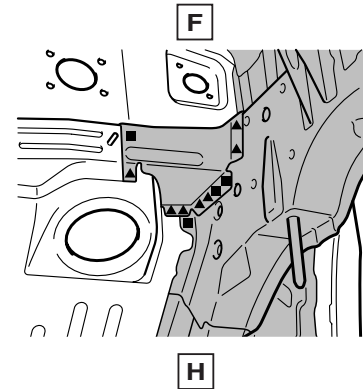
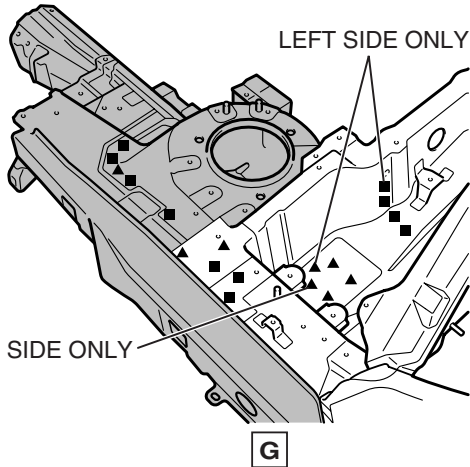
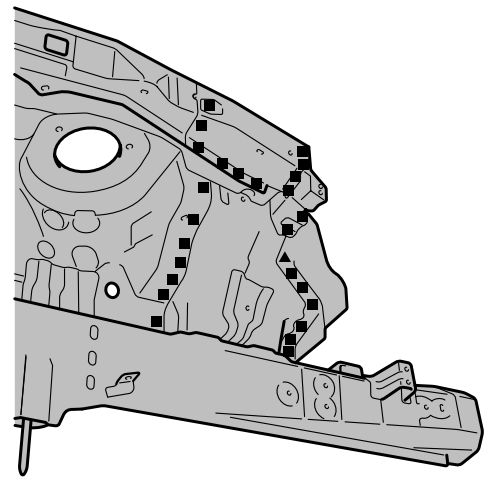
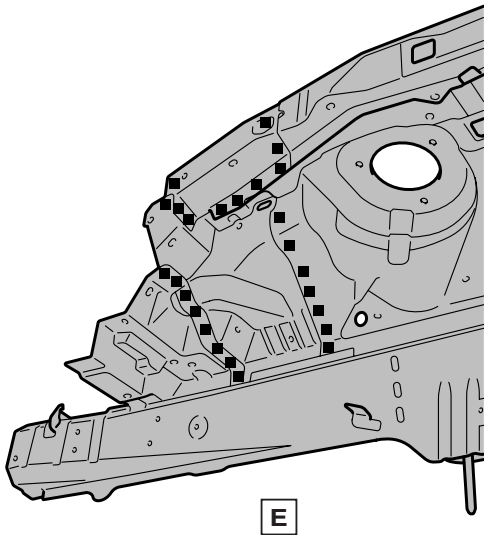


LEFT SIDE ONLY

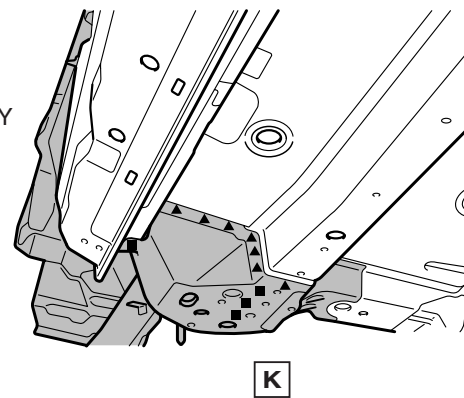
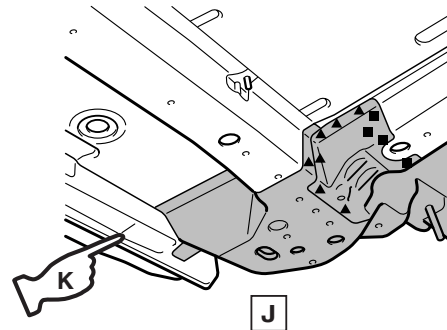
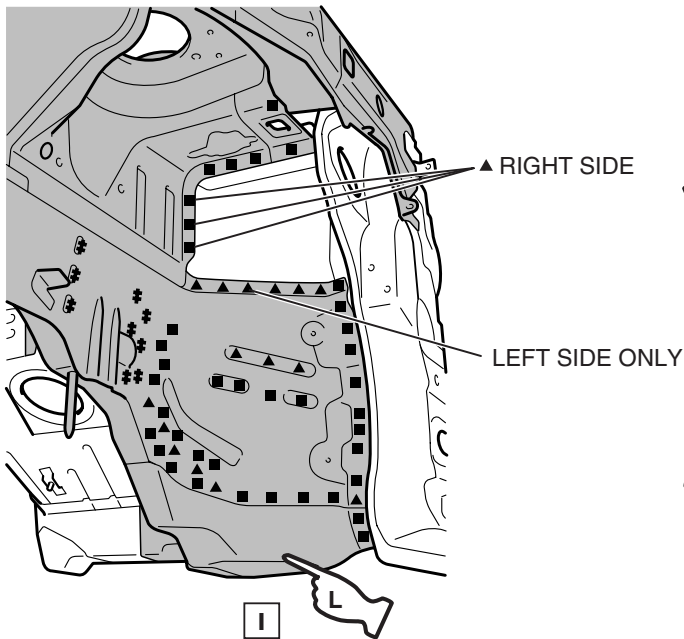
B **C**
(WITH THE UPPER FRAME OUTER EXTENSION REMOVED)



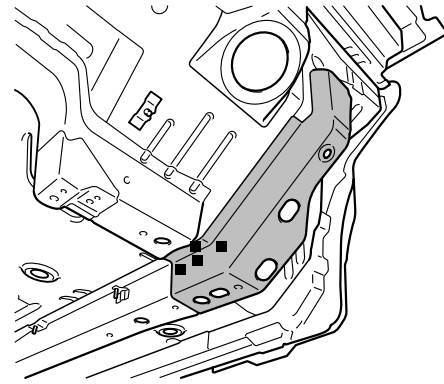
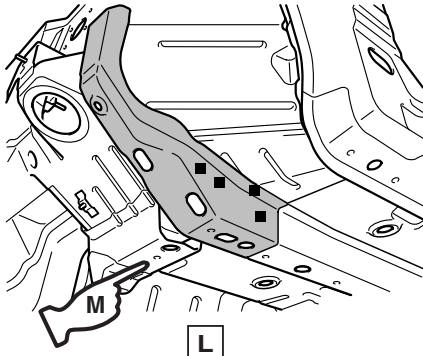
AB401077AB



(LEFT SIDE ONLY)

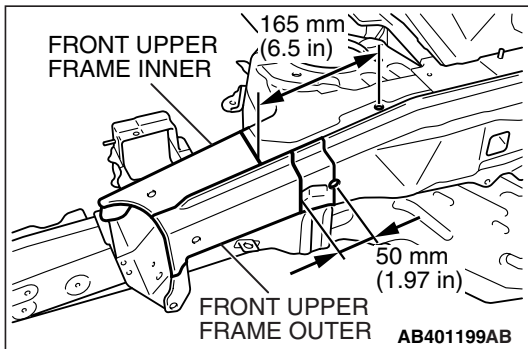


AB401078AB



(WITH THE FRONT SIDEMEMBER REMOVED)

AB401079AB

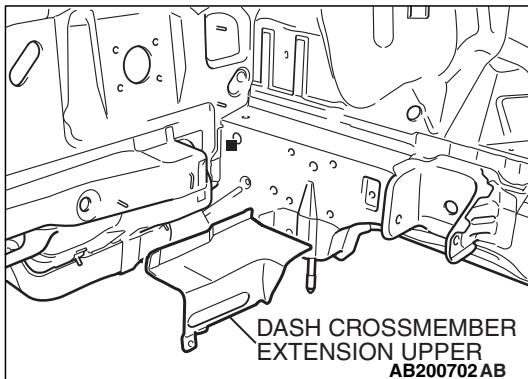


NOTE: Partial replacement of the front upper frame is possible depending on the range of damage. When performing partial replacement, cut the front upper frame outer 50 mm (1.97 inches) forward of the positioning hole center, and cut the front upper frame inner 165 mm (6.5 inches) forward of the front fender mounting hole center.

NOTE ON REPAIR WORK

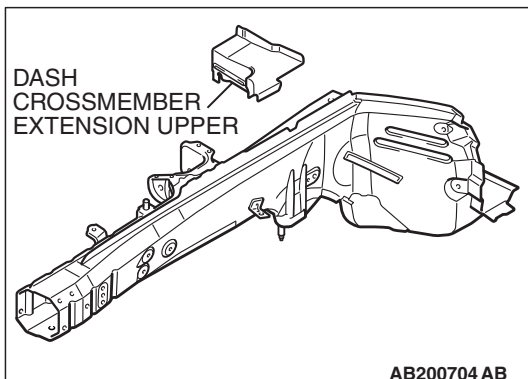
REMOVAL

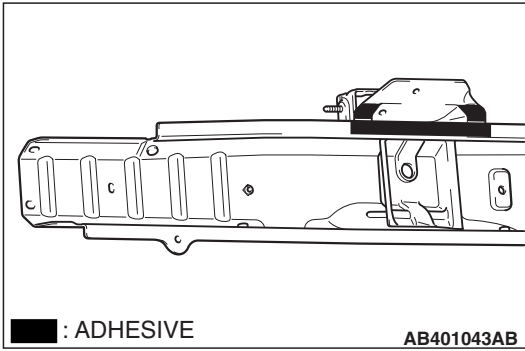
The welding point between front sidemember inner and rear A sidemember is hidden by the dash crossmember extension upper. Therefore, when removing the front sidemember, remove the dash crossmember extension upper in advance.



INSTALLATION

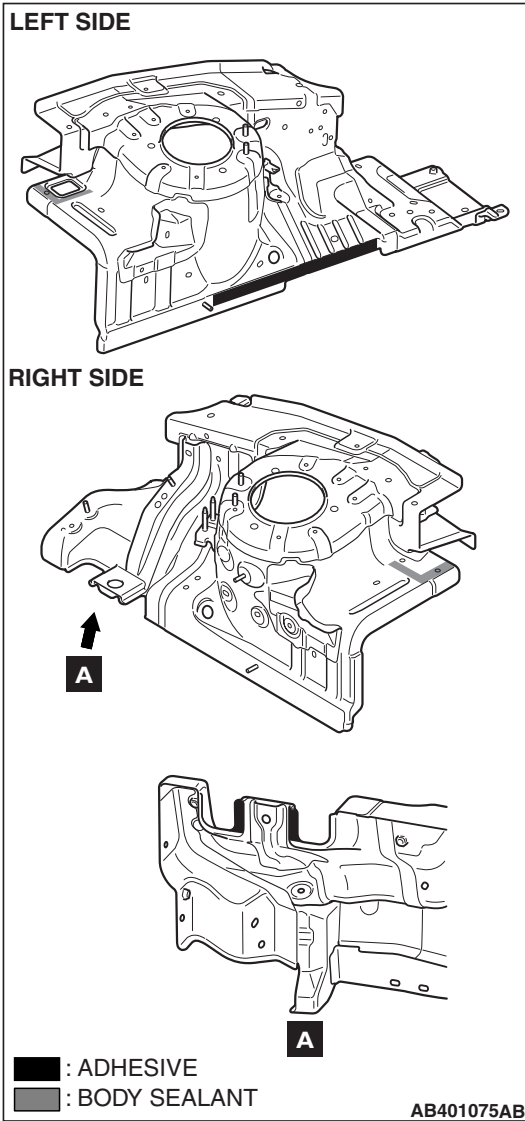
1. Remove the dash crossmember extension upper from the new front sidemember parts.





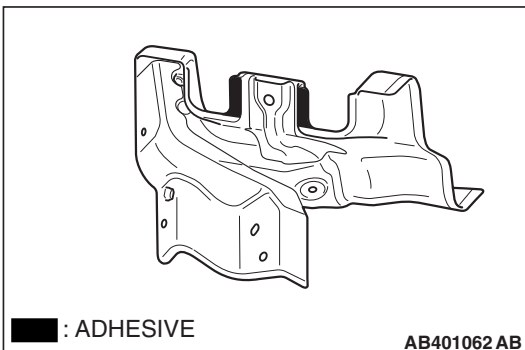
- When assembling the new front sidemember outer (LH) parts, apply in advance adhesives to the areas shown in the figure of the instructions of body side.

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



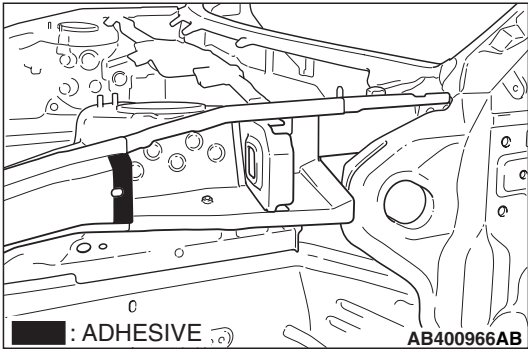
- When assembling the new front fender shield parts, apply in advance body sealant and adhesives to the areas shown in the figure of the instructions.

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



- When assembling the new front fender shield front (RH) parts, apply in advance adhesives to the areas shown in the figure of the instructions.

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



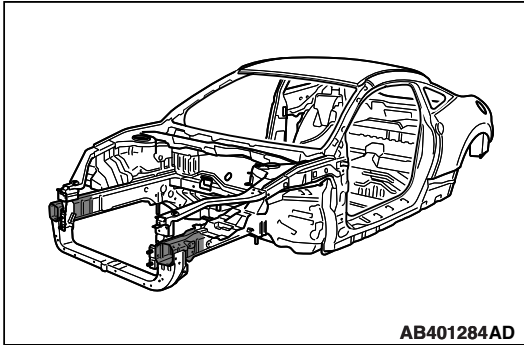
5. When assembling the new upper frame outer extension parts, apply in advance adhesives to the areas shown in the figure of the instructions.

ADHESIVE: Epoxyayresin adhesive

BRAND: 3M™ AAD Part No.8115 or equivalent

FRONT SIDEMEMBER (PARTIAL REPLACEMENT)

M4030000100368

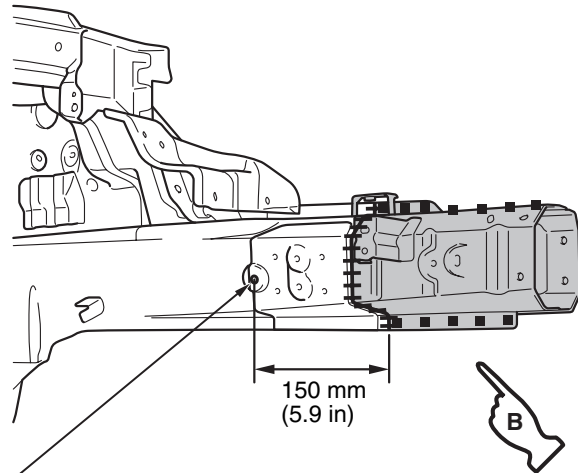
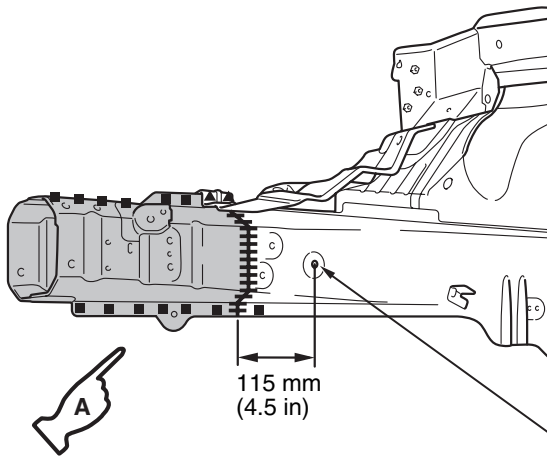


SYMBOL	OPERATION DESCRIPTION
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
++++	MIG spot welding
#####	MIG arc welding (continuous)
oooooo	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply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

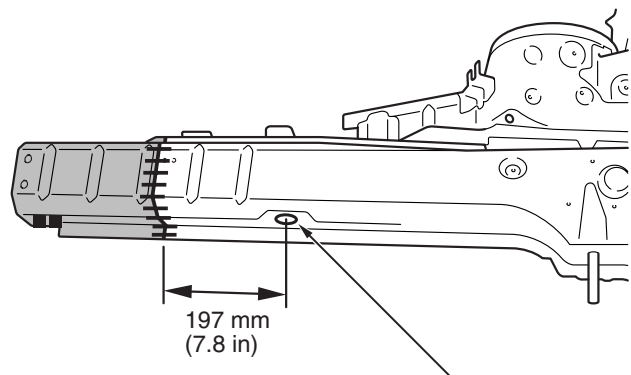
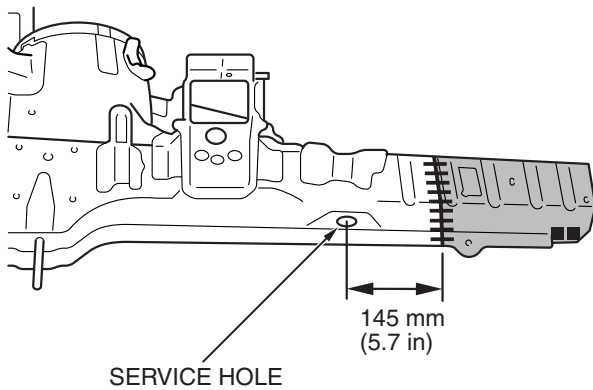
REPAIR WELDS

LEFT SIDE

RIGHT SIDE



WATER DRAINING HOLE



AB401198AB

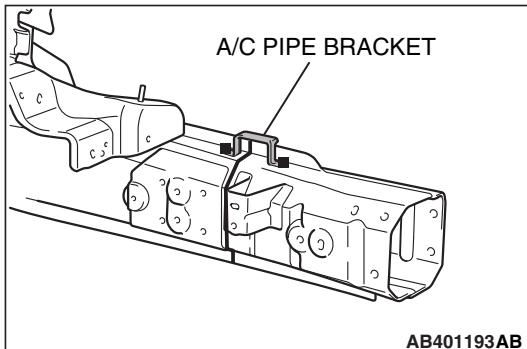
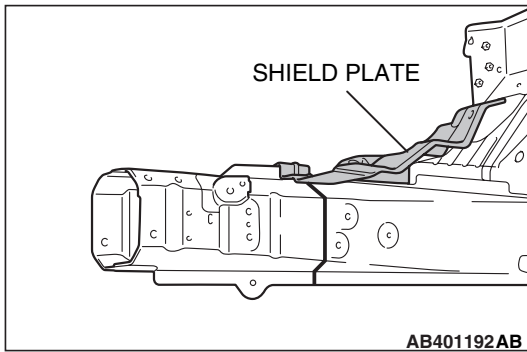
NOTE: Refer to the Headlight Support section on P.3-3 for the welding point with headlight support.

NOTE ON REPAIR WORK

REMOVAL

1. Remove the shield plate on the cut area in advance when cutting the front sidemember (LH).

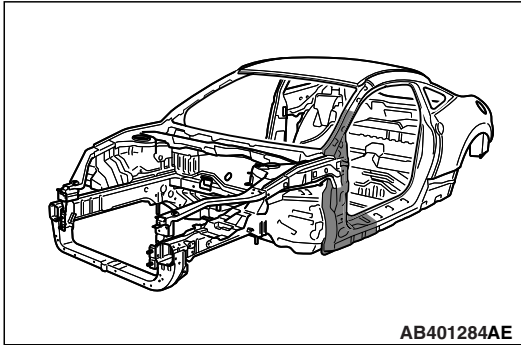
NOTE: Refer to the Fender Shield section on P.3-4 for the welding points with the shield plate.



2. Remove the A/C pipe bracket on the cut area in advance when cutting the front sidemember (RH).

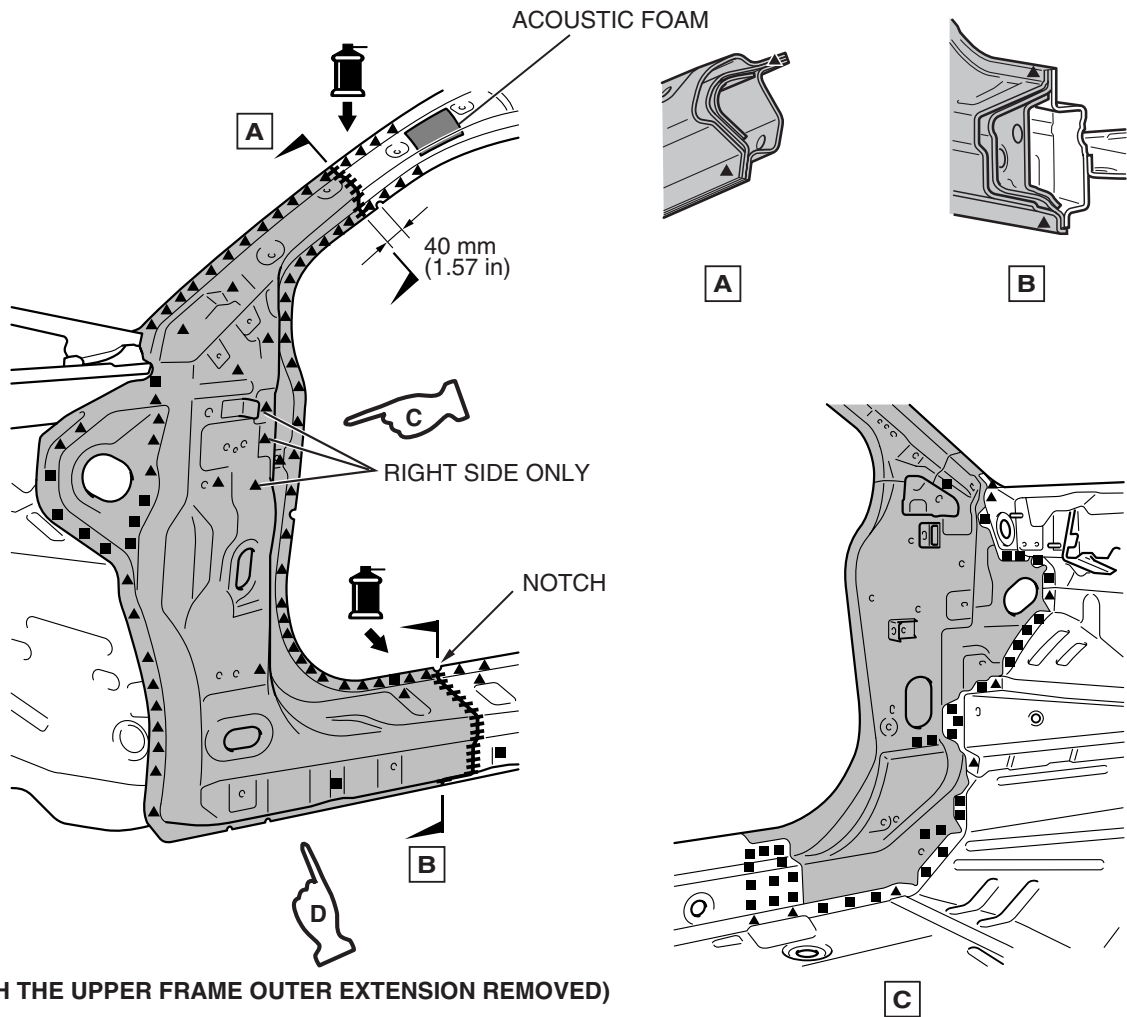
FRONT PILLAR

M4030005000678



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

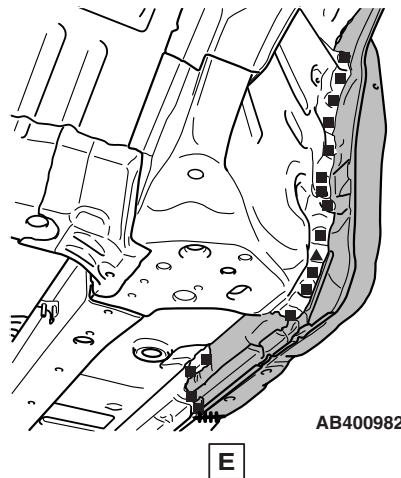
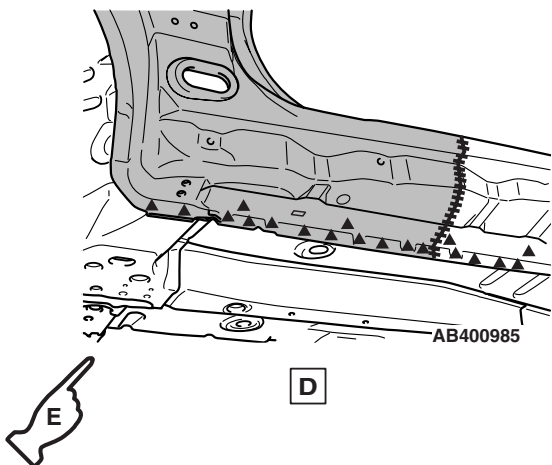


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CAUTION

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 outer extension.

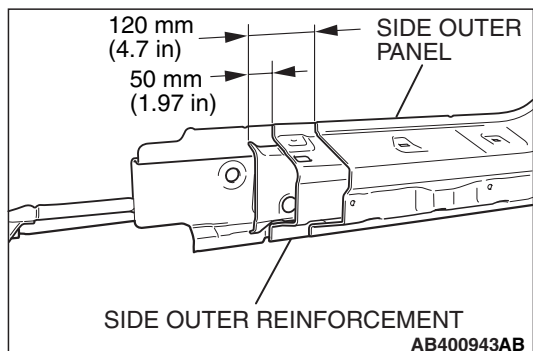
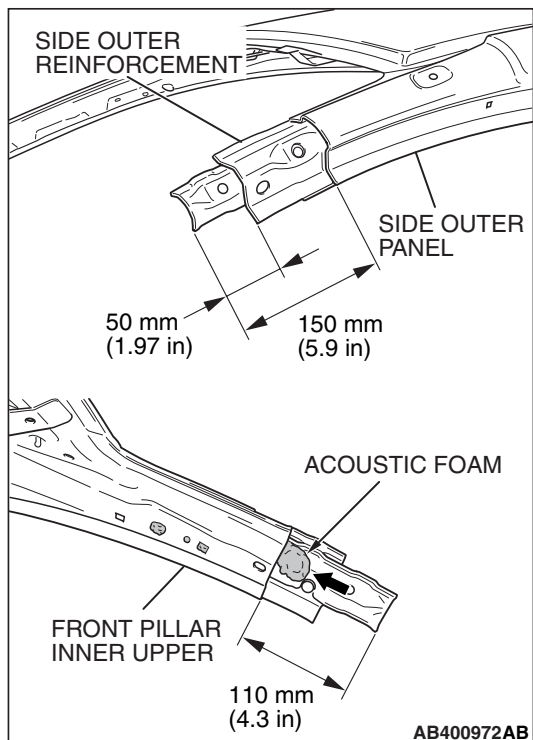


AB400976AB

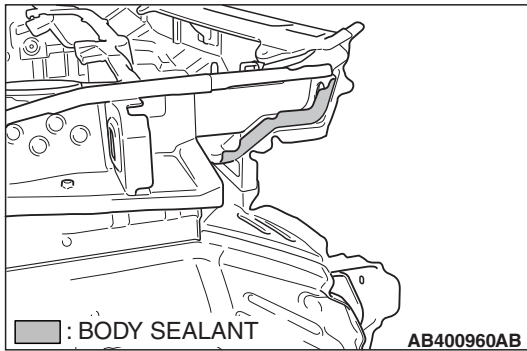
NOTE ON REPAIR WORK

INSTALLATION

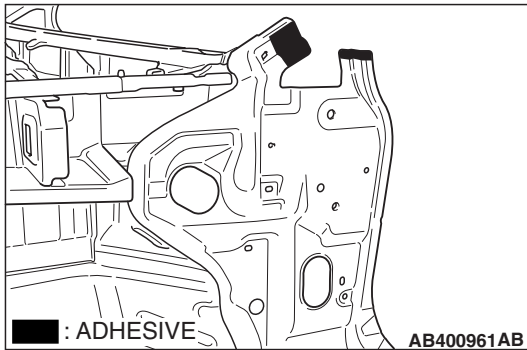
1. To reinforce the strength in the front pillar cut area, cut the side outer panel 150 mm (5.9 inches) above the cut area and cut the side outer reinforcement 50 mm (1.97 inches) above the cut area and cut the front pillar inner upper 110 mm (4.3 inches) above the cut area. The acoustic foam may sag to the cut area of the front pillar inner upper. Because the acoustic foam may burn during welding of the following operation, push it upward.



2. To reinforce the strength in the side sill cut area, cut the side outer panel 120 mm (4.7 inches) behind the cut area and cut the side outer reinforcement 50 mm (1.97 inches) behind the cut area.

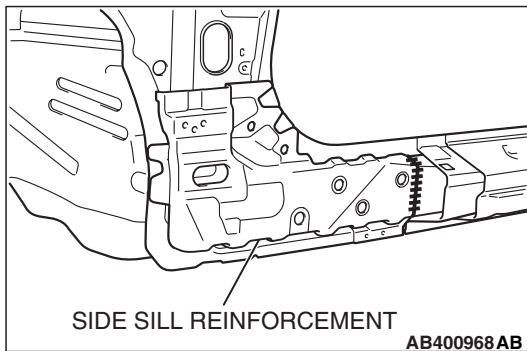


3. When assembling the new front pillar inner lower parts, apply in advance body sealant to the areas shown in the figure of the instructions.

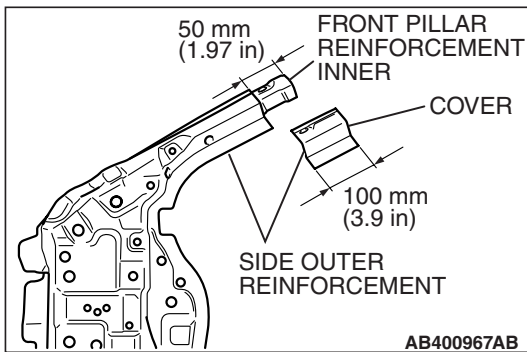


4. When assembling the new front pillar inner upper parts, apply in advance adhesives to the areas shown in the figure of the instructions.

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



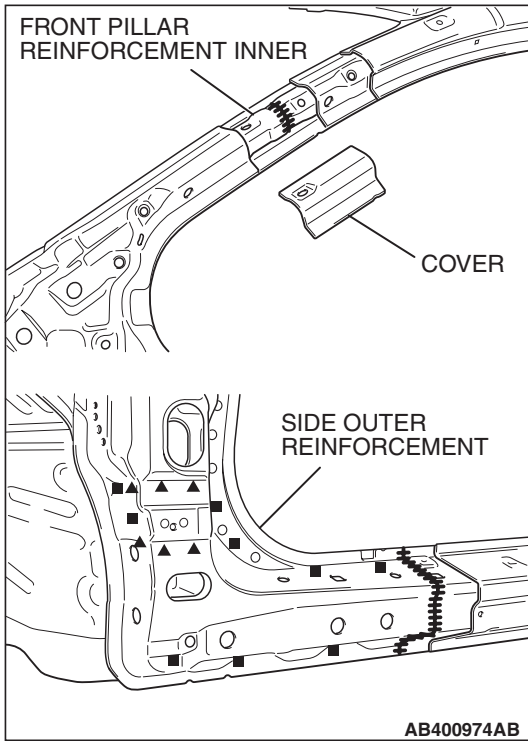
5. Assemble the new side sill reinforcement parts.



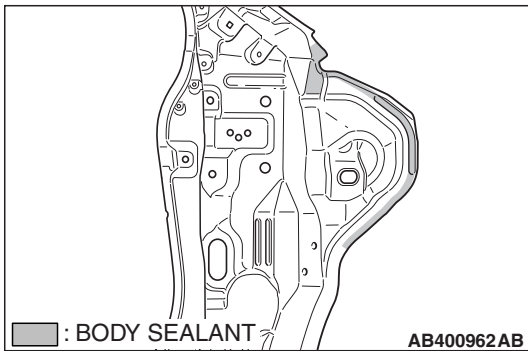
CAUTION

Weld and repair if the front pillar reinforcement inner is damaged.

6. Cut the new side outer reinforcement parts by aligning it with the side outer reinforcement cut area on the body side. Then, cut only the side outer reinforcement 100 mm (3.9 inches) below the cut area and make a cover. Cut the front pillar reinforcement inner 50 mm (1.97 inches) above the cut area of the side outer reinforcement.



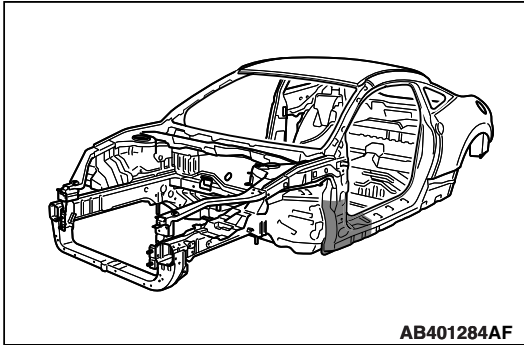
7. Weld the front pillar reinforcement inner then weld the cover and the side outer reinforcement.



8. When assembling the new front outer pillar parts, apply in advance body sealant to the areas shown in the figure of the instructions.

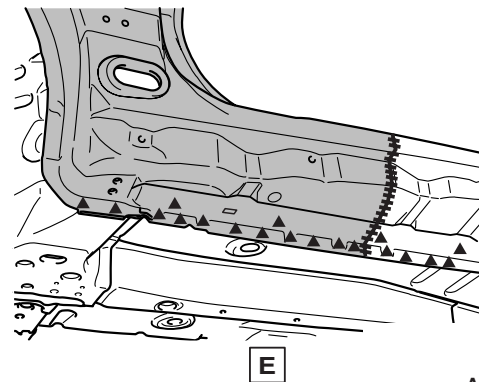
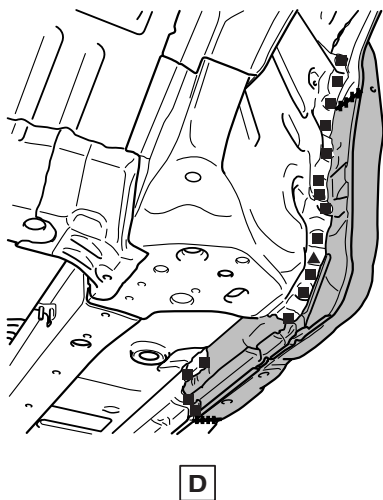
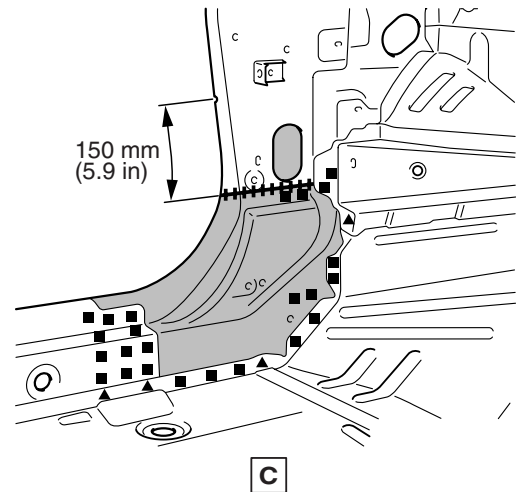
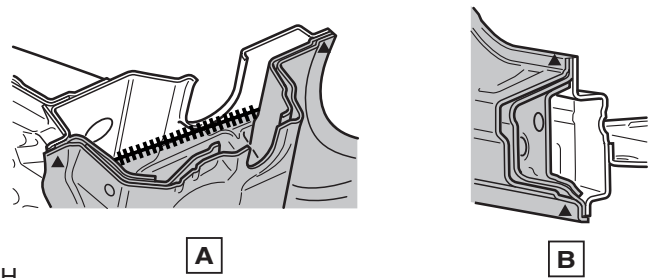
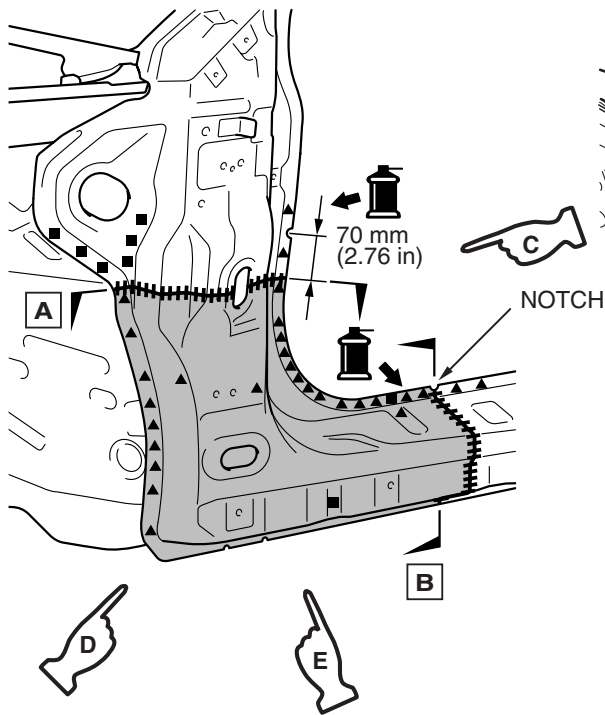
FRONT PILLAR (PARTIAL REPLACEMENT)

M4030001200012



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

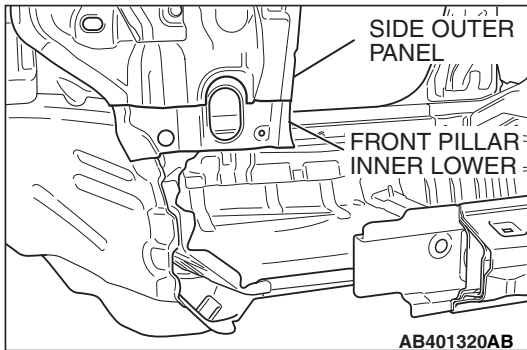


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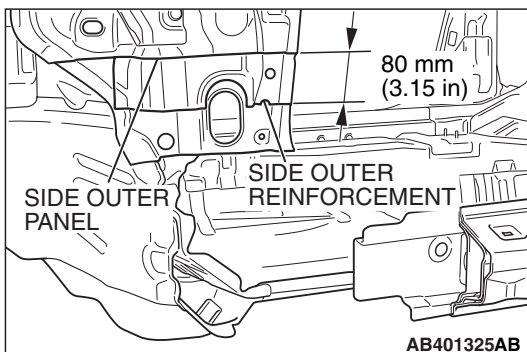
NOTE ON REPAIR WORK

INSTALLATION

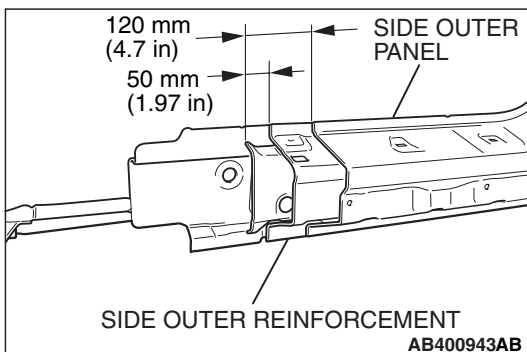
1. When cutting the front pillar, cut the side outer panel and side outer reinforcement in the same area. Then cut the front pillar inner lower.



2. To reinforce the strength in the front pillar cut area, cut the side outer panel 80 mm (3.15 inches) above the cut area.

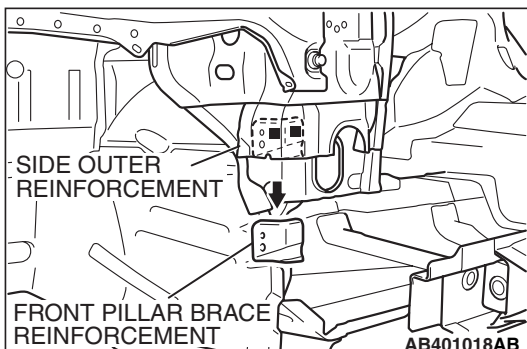


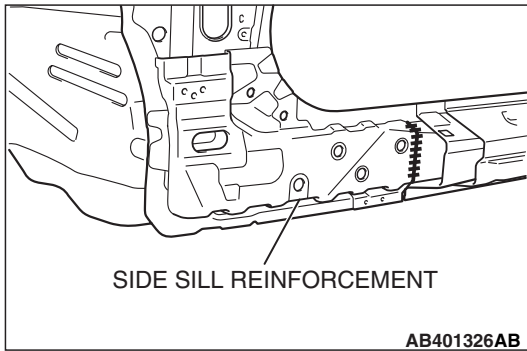
3. To reinforce the strength in the side sill cut area, cut the side outer panel 120 mm (4.7 inches) behind the cut area and cut the side outer reinforcement 50 mm (1.97 inches) behind the cut area.



4. Remove the front pillar brace reinforcement remaining on the body.

5. Assemble the new front pillar inner lower parts.

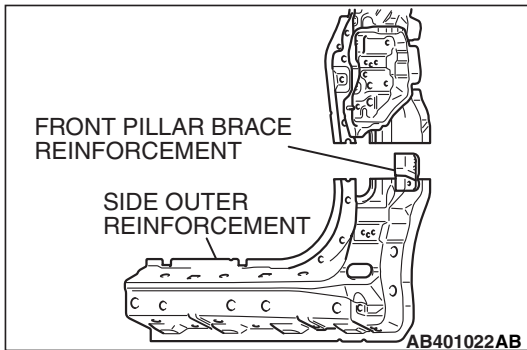




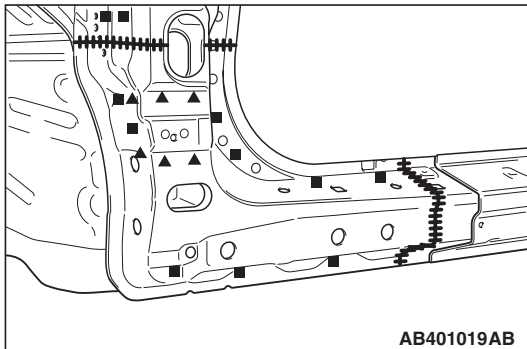
6. Assemble the new side sill reinforcement parts.

CAUTION

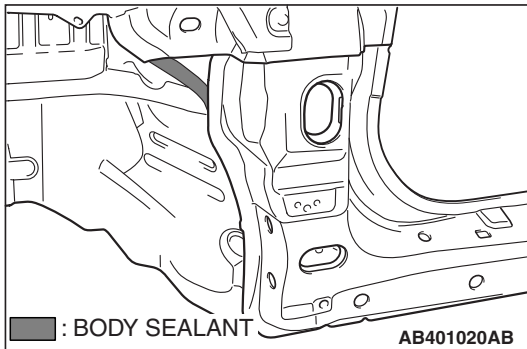
Weld and repair if the front pillar brace reinforcement is damaged.



7. Cut the new side outer reinforcement by aligning it with the side outer reinforcement cut area on the body side.



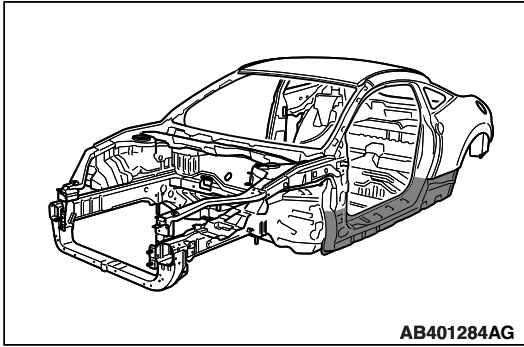
8. Assemble the new side outer reinforcement parts.



9. When assembling the new front outer pillar parts, apply in advance body sealant to the areas shown in the figure of the instructions.

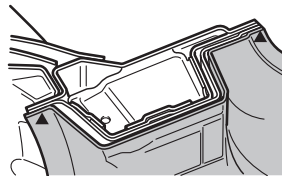
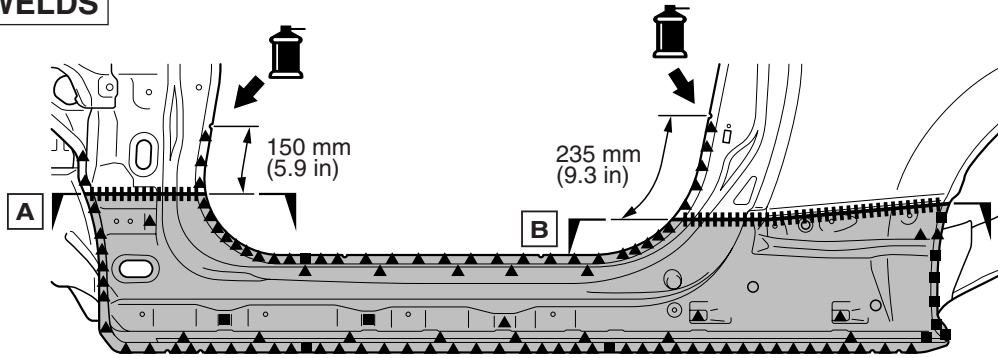
NOTES

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.)

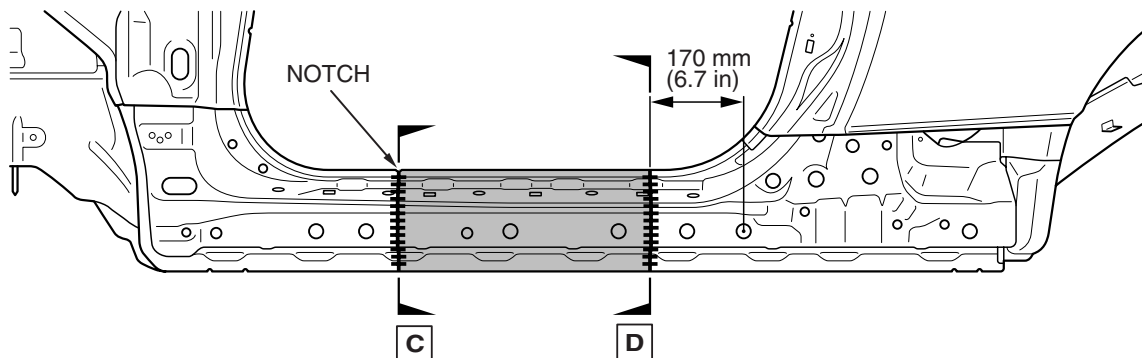
REPAIR WELDS



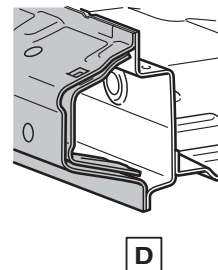
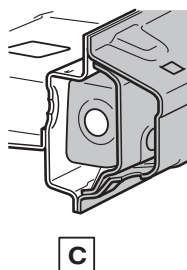
A



B



(WITH THE SIDE OUTER PANEL REMOVED)



AB401175AB

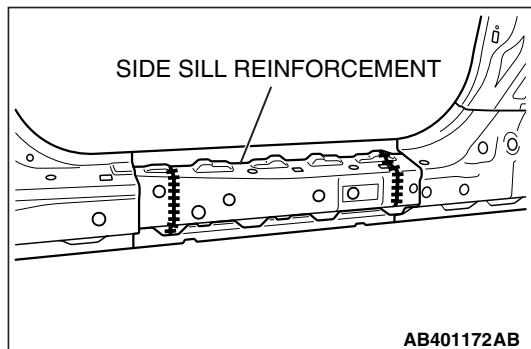
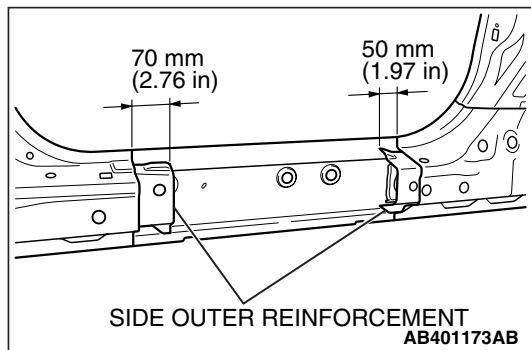
NOTE ON REPAIR WORK

INSTALLATION

⚠ CAUTION

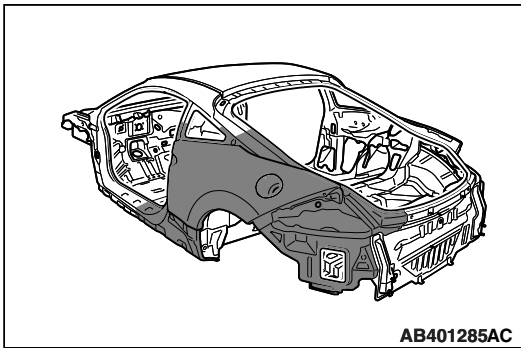
Weld and repair if the side sill reinforcement is damaged.

1. To reinforce the strength of the side outer reinforcement cut area, cut the side outer reinforcement 70 mm (2.76 inches) forward of the cut area at the front side. Cut the side outer reinforcement 50 mm (1.97 inches) backward of the cut area at the rear side.
2. Weld the side sill reinforcement, then weld the side outer reinforcement.



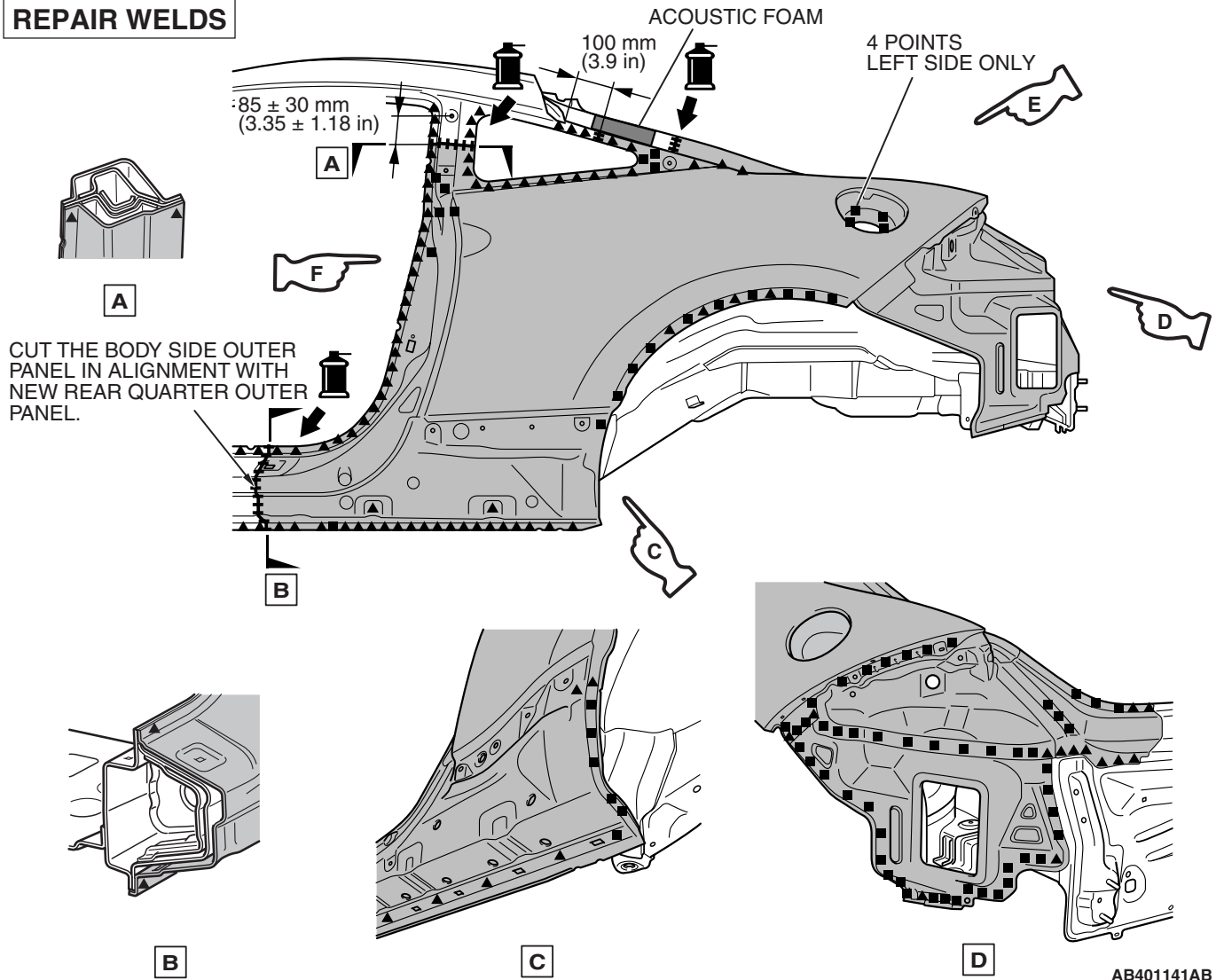
QUARTER OUTER

M4030008000440



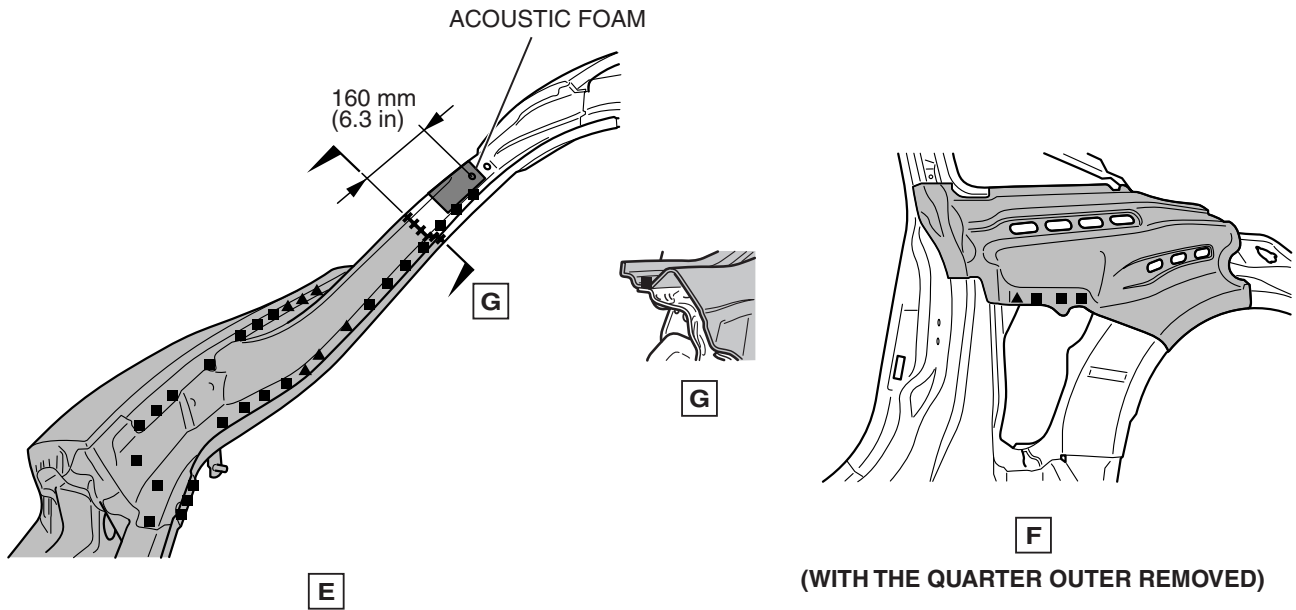
SYMBOL	OPERATION DESCRIPTION
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
++++	MIG spot welding
#####	MIG arc welding (continuous)
○○○○○○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply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

REPAIR WELDS



CAUTION

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

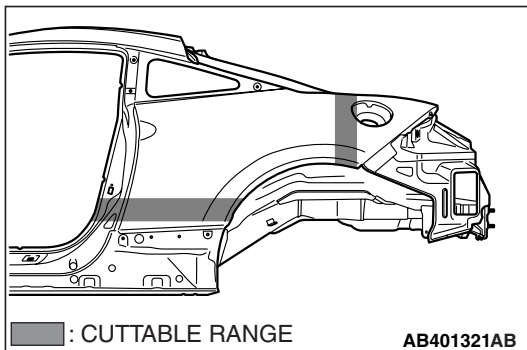


AB401142AB

CAUTION

Avoid the fuel filler bracket (left side).

NOTE: Parts replacement is advised, depending on the damaged range.

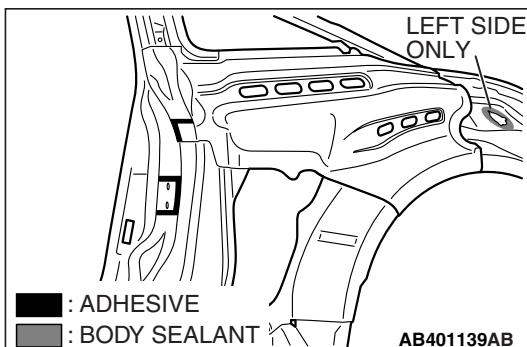


NOTE ON REPAIR WORK

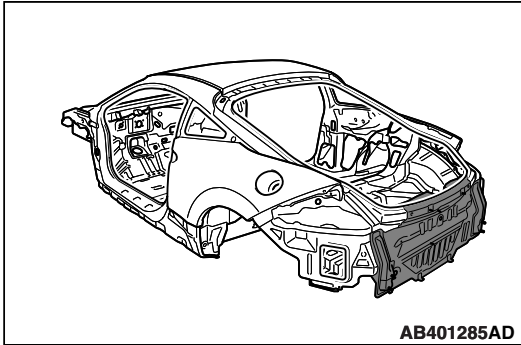
INSTALLATION


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

ADHESIVE: Epoxy resin adhesive
BRAND: 3M™ AAD Part No.8115 or equivalent

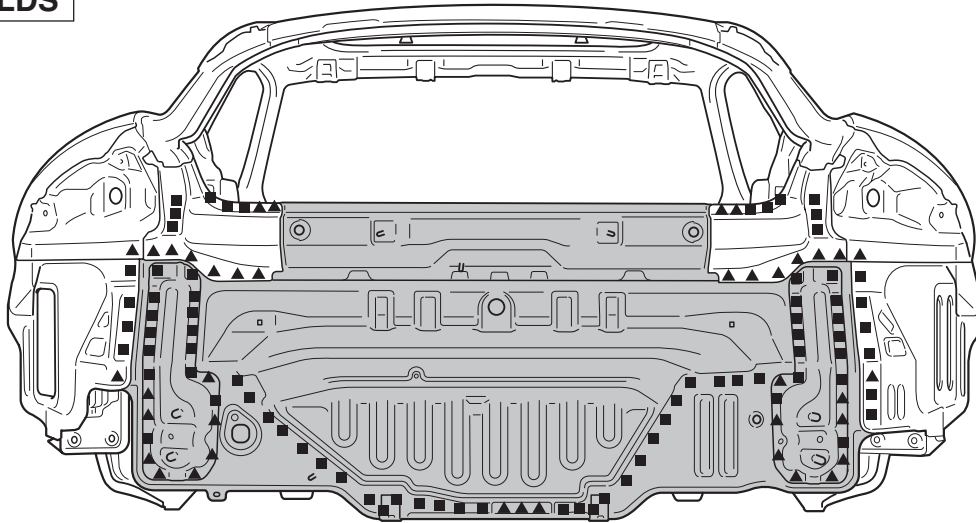


REAR END PANEL



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

REPAIR WELDS

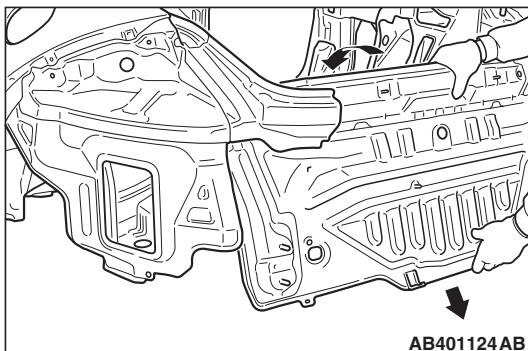


AB401123AB

NOTE ON REPAIR WORK

REMOVAL

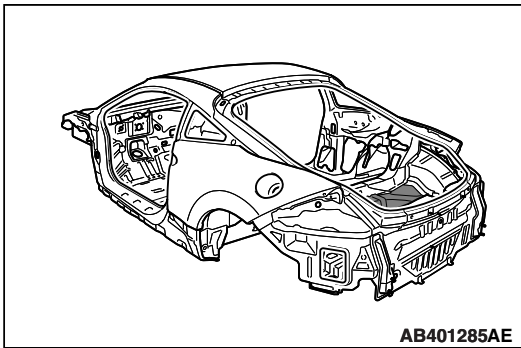
When removing the rear end panel, slant the top of rear end panel toward the cabin side and pull out the rear end panel in the bottom direction.




NOTES

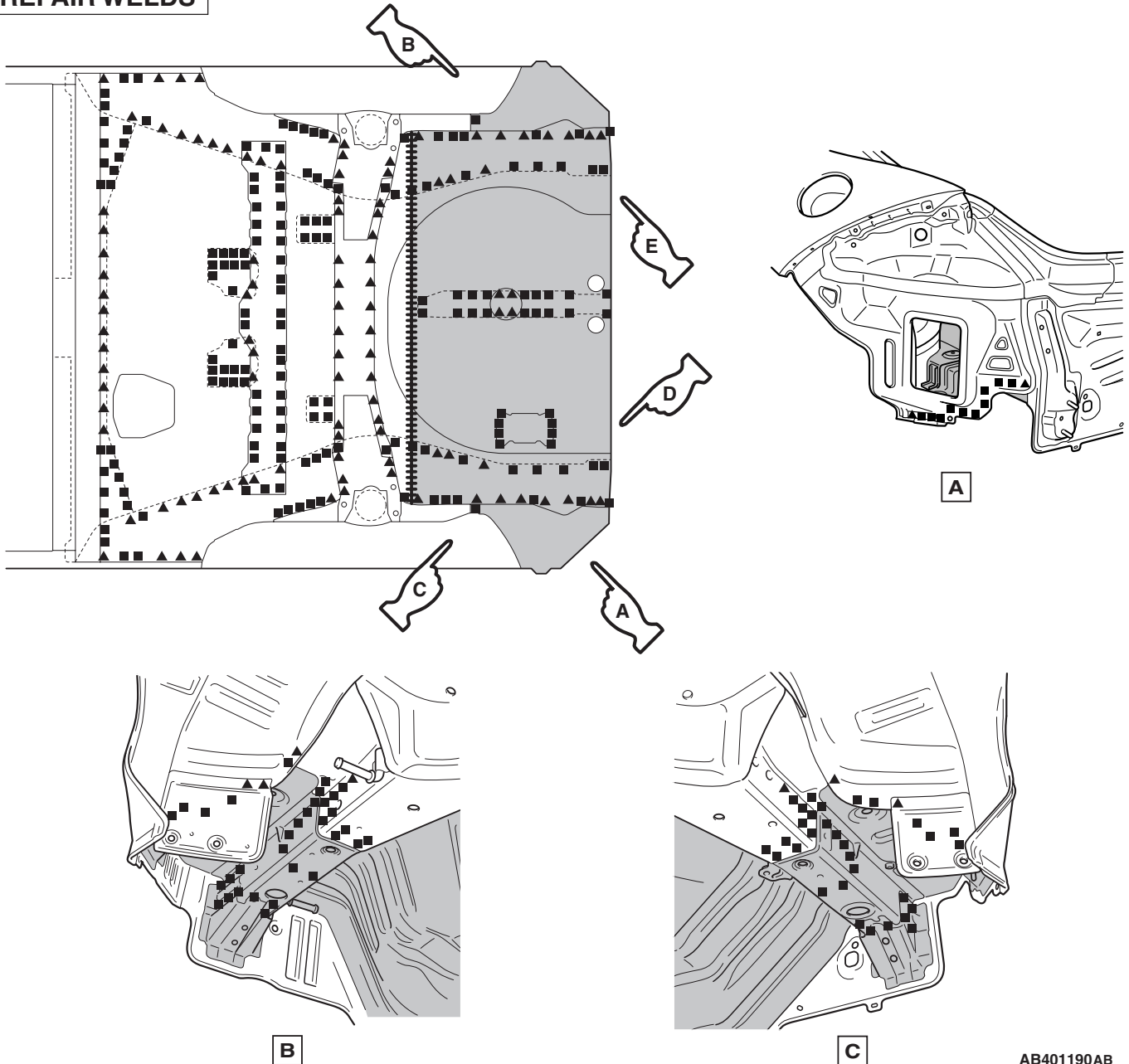
REAR FLOOR

M4030010000469



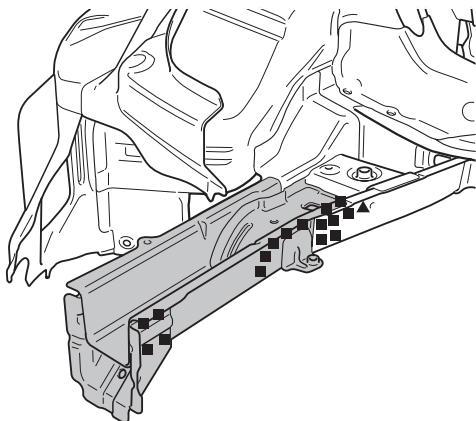
SYMBOL	OPERATION DESCRIPTION
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
++++	MIG spot welding
#####	MIG arc welding (continuous)
oooooo	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply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

REPAIR WELDS

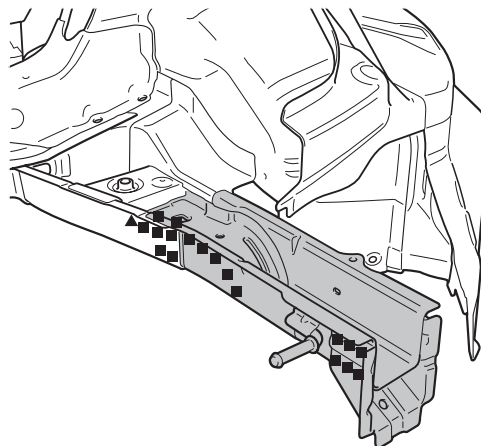


NOTE: Refer to the Rear End Panel section on P.3-24 for the welding points with the rear end panel.

AB401190AB



D



E

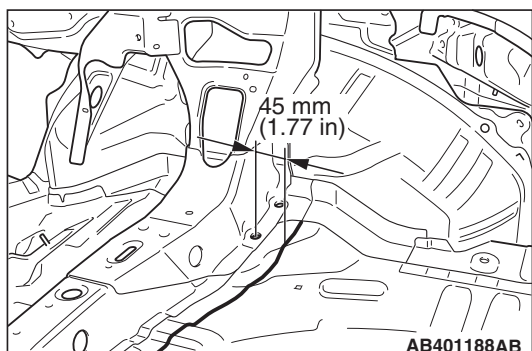
(WITH THE REAR FLOOR PAN REMOVED)

AB401191AB

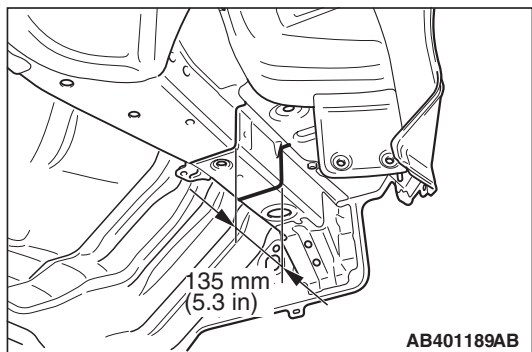
NOTE ON REPAIR WORK

REMOVAL

1. When cutting the rear floor pan, cut it from 45 mm (1.77 inches) behind the rear suspension assembling hole.
2. When removing the rear floor side member extension without removing the rear floor pan, cut it 135 mm (5.3 inches) behind the rear edge of the rear floor side member to remove.



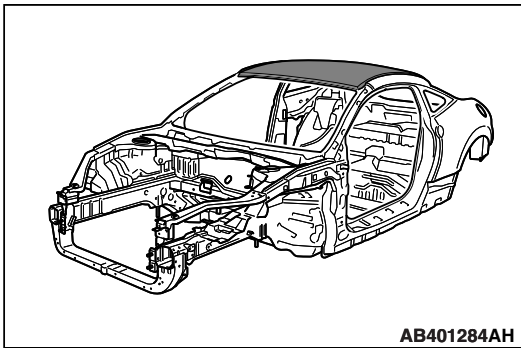
AB401188AB



AB401189AB

ROOF

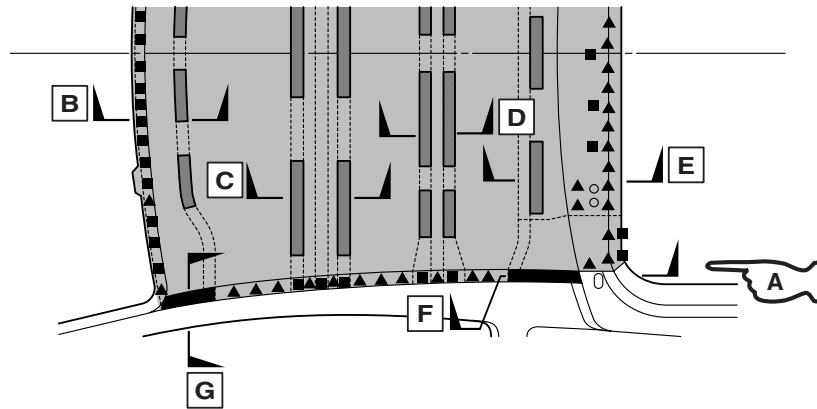
M4030011000503



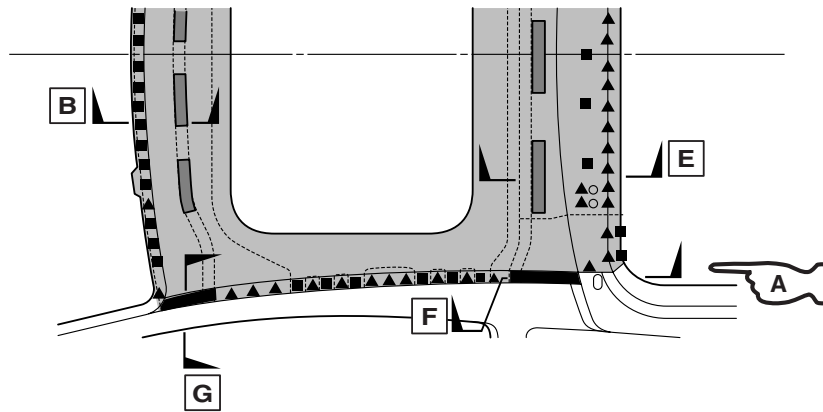
SYMBOL	OPERATION DESCRIPTION
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded) (▲: indicates three panels to be welded)
++++	MIG spot welding
#####	MIG arc welding (continuous)
ooooooo	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply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

REPAIR WELDS

VEHICLES WITHOUT
SUNROOF



VEHICLES WITH
SUNROOF



: ADHESIVE 1
 : ADHESIVE 2

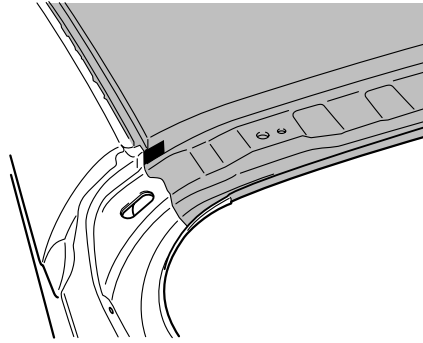
AB401208AB

- **ADHESIVE 1:** Urethane body sealer
BRAND: 3M™ AAD Part No.8542 or equivalent

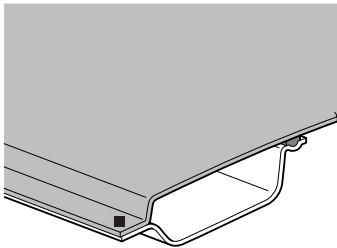
- **ADHESIVE 2:** Epoxyayresin adhesive
BRAND: 3M™ AAD Part No.8115 or equivalent

CAUTION

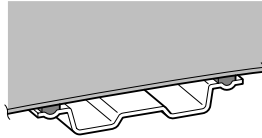
When repairing the area using foam materials do not use firing tools since the foaming materials may burn.



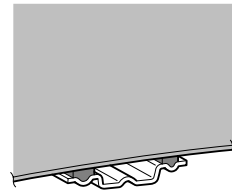
A



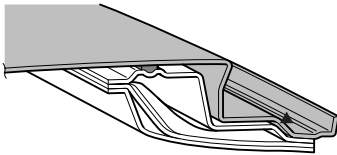
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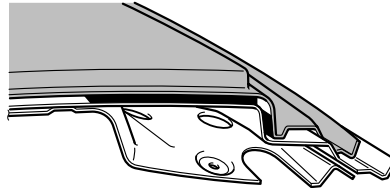
C



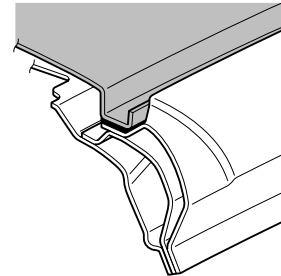
D



E



F

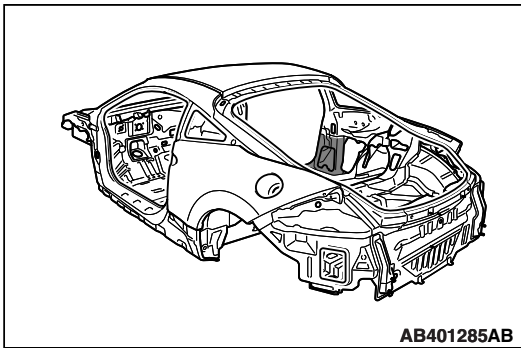


G

AB401281AB

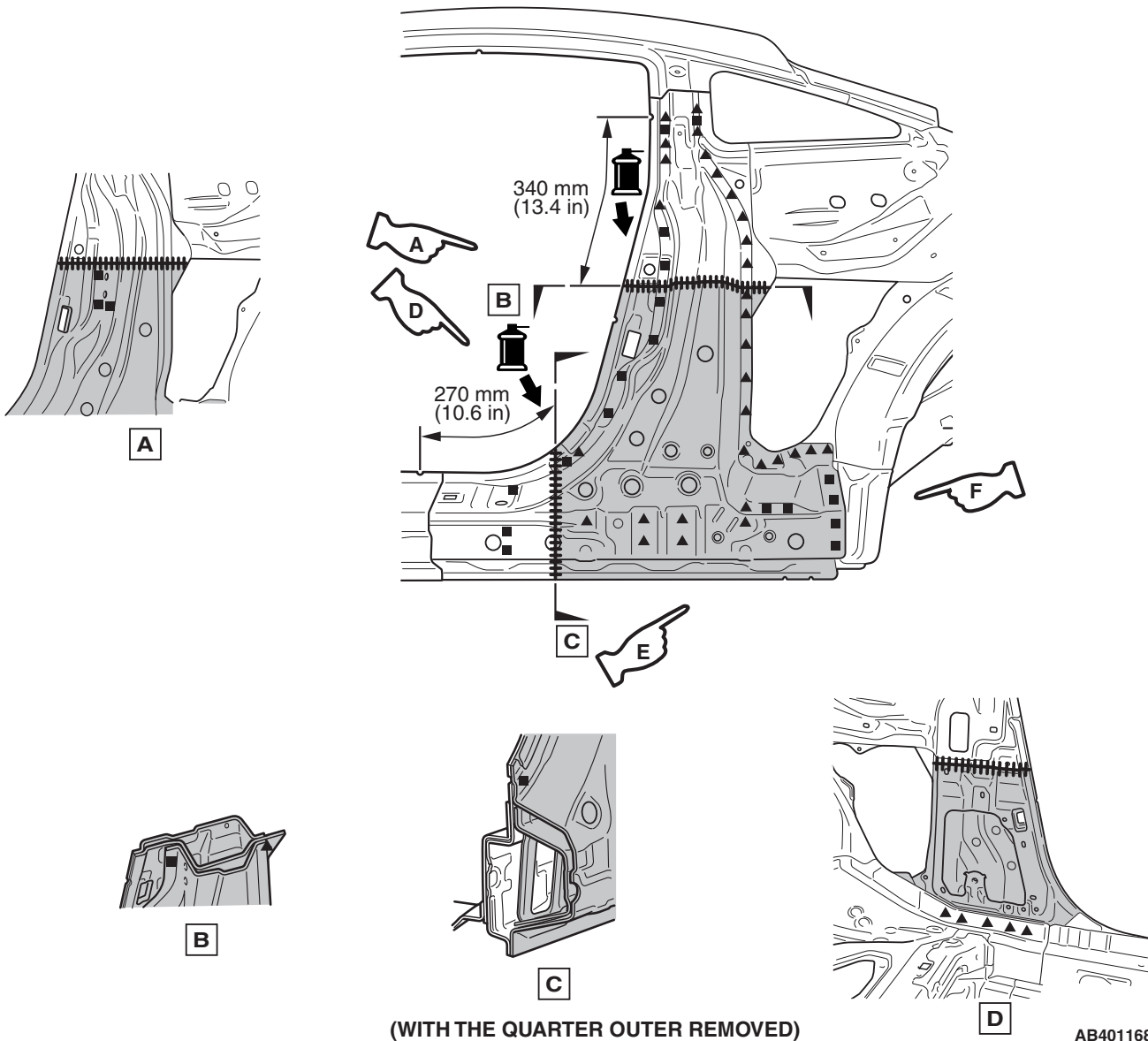
CENTER PILLAR REINFORCEMENT

M4030001300019

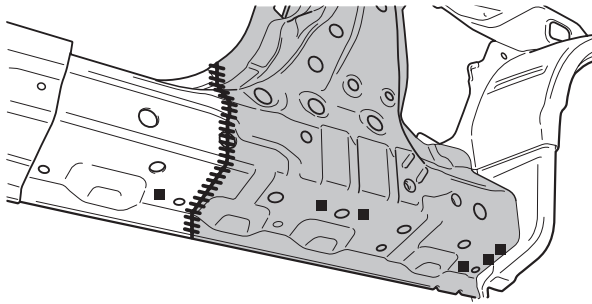


SYMBOL	OPERATION DESCRIPTION
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded) (▲: indicates three panels to be welded)
++++	MIG spot welding
#####	MIG arc welding (continuous)
○○○○○○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply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

REPAIR WELDS

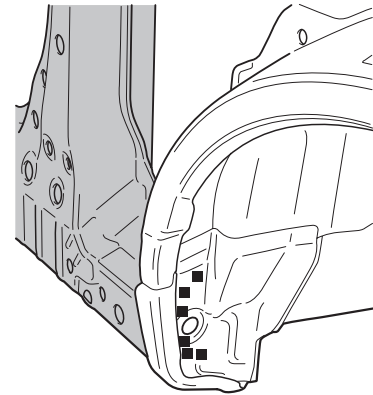


NOTE: Refer to the Quarter Outer section on P.3-22 for the welding points with the quarter outer.



E

(WITH THE QUARTER OUTER REMOVED)



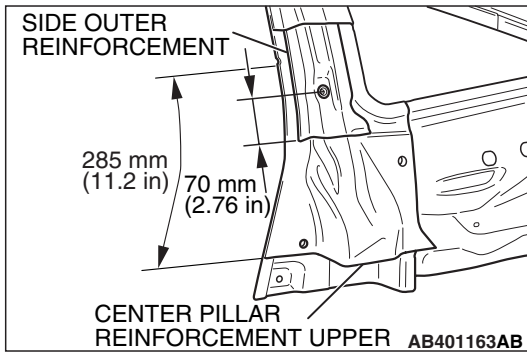
F

AB401169AB

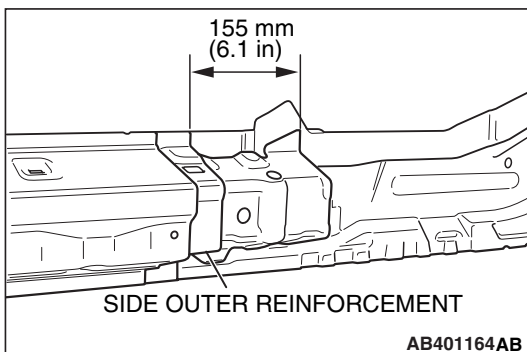
NOTE ON REPAIR WORK

INSTALLATION

1. To reinforce the strength of the center pillar cut area, cut the side outer reinforcement 70 mm (2.76 inches) downward of the quarter glass clip mounting hole, and cut the center pillar reinforcement upper 285 mm (11.2 inches) downward of the notch.

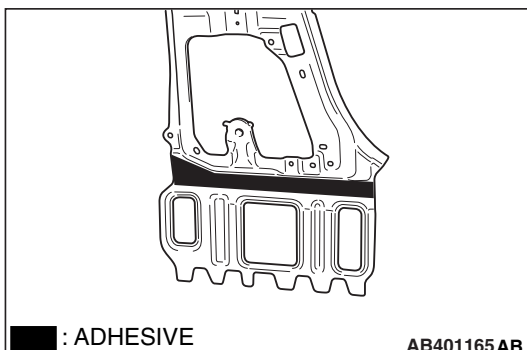


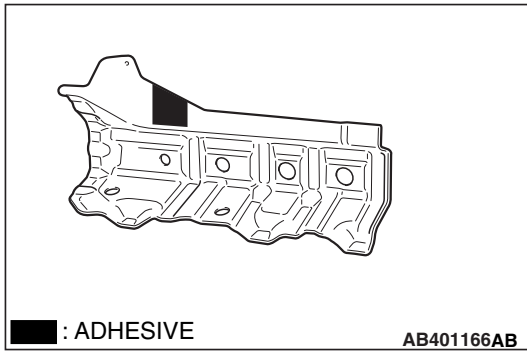
2. To reinforce the strength of the side sill cut area, cut only the side outer reinforcement 155 mm (6.1 inches) forward of the cut area.



3. When assembling the new center pillar seat belt reinforcement parts, apply in advance adhesives to the areas shown in the figure of the instructions.

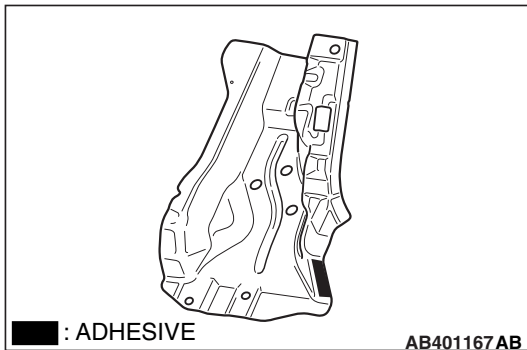
ADHESIVE: Epoxyayresin adhesive
BRAND: 3M™ AAD Part No.8115 or equivalent





4. When assembling the new side sill reinforcement parts, apply in advance adhesives to the areas shown in the figure of the instructions.

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

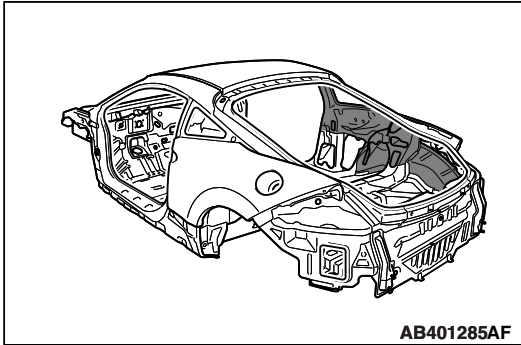


5. When assembling the new center pillar reinforcement upper parts, apply in advance adhesives to the areas shown in the figure of the instructions.

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

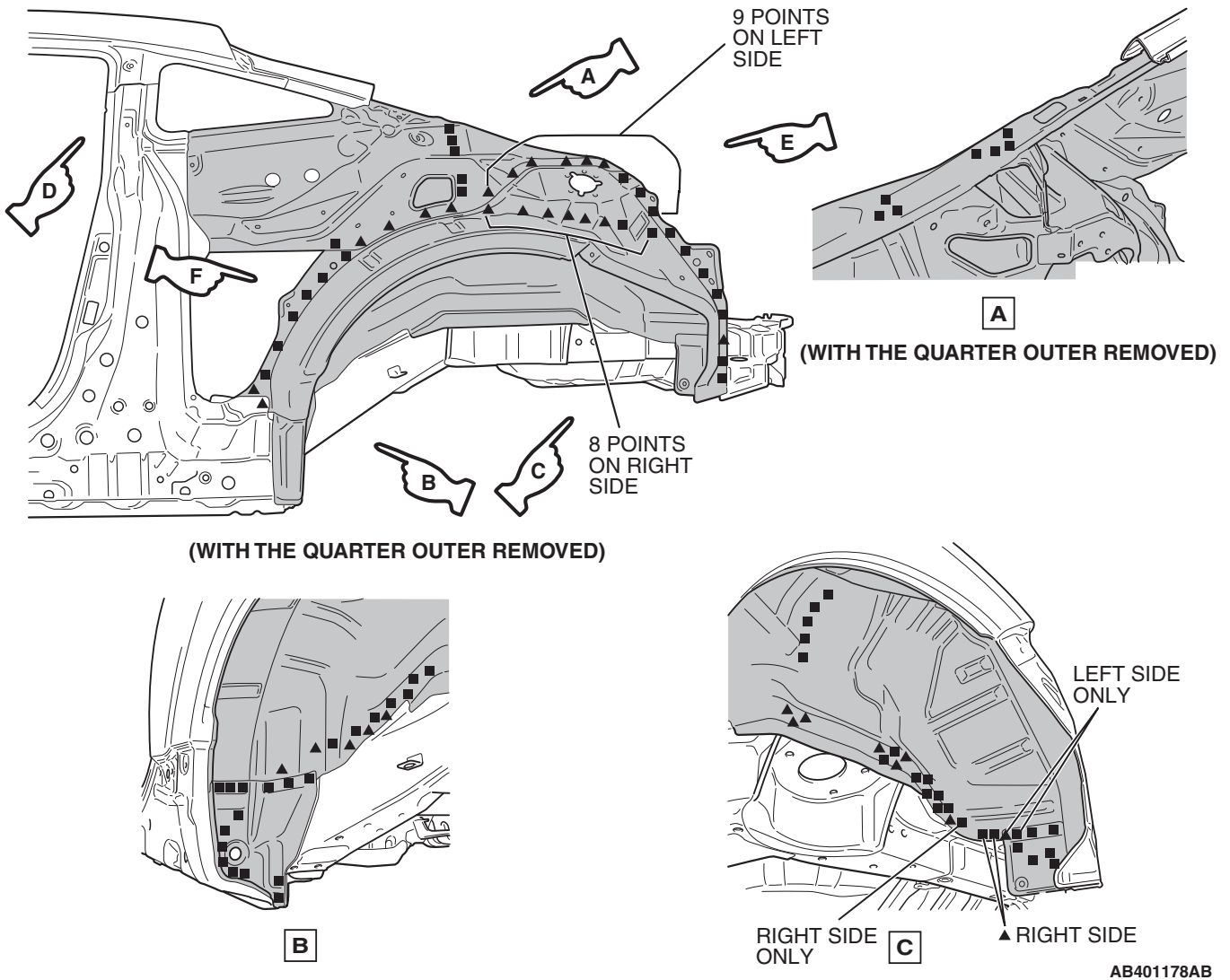
NOTES

QUARTER INNER

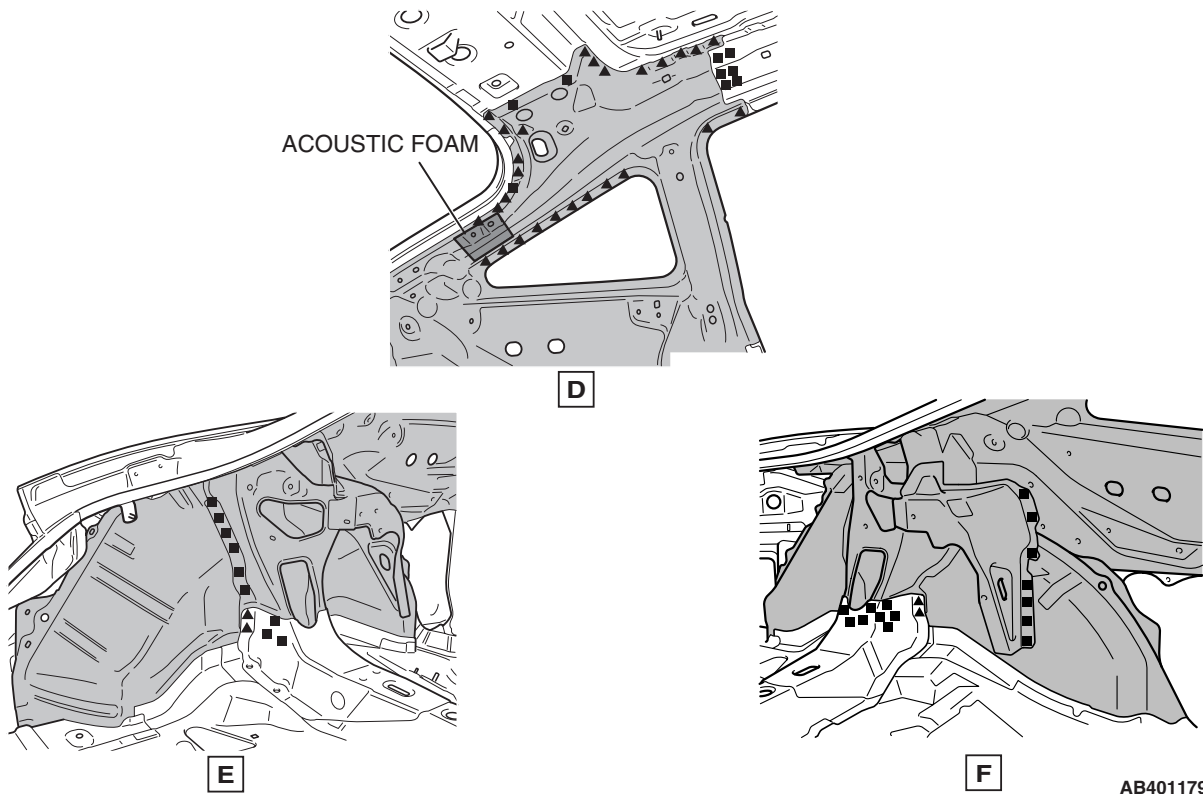


SYMBOL	OPERATION DESCRIPTION
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
+++++	MIG spot welding
#####	MIG arc welding (continuous)
○○○○○○○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply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

REPAIR WELDS



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



CAUTION

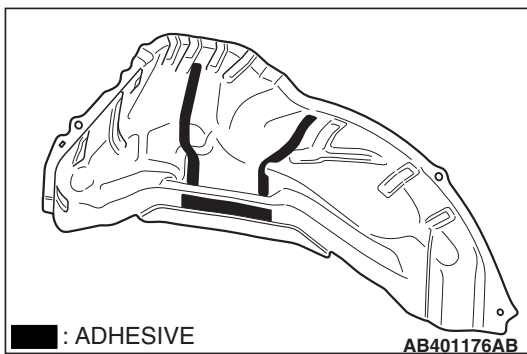
When repairing the area using foam materials do not use firing tools since the foaming materials may burn.

NOTE ON REPAIR WORK

INSTALLATION

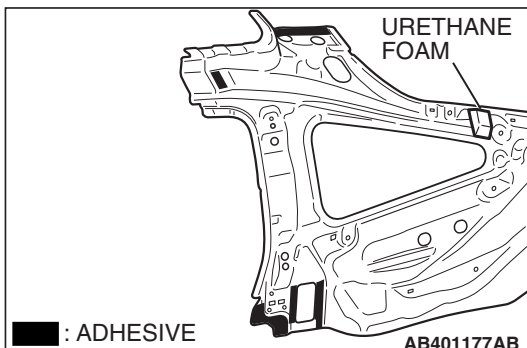
1. When installing the new rear wheelhouse inner panel, apply adhesives to the mating areas of the rear shelf brace and spring house bracket.

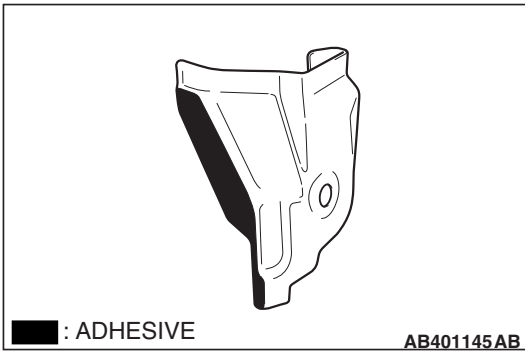
ADHESIVE: Epoxyayresin adhesive
BRAND: 3M™ AAD Part No.8115 or equivalent



2. When installing the new rear quarter inner panel upper, apply in advance adhesives to the areas shown in the figure at the instructions. Also, in order to prevent the foam materials from dropping, stick the urethane foam to fill the inside of the pillar.

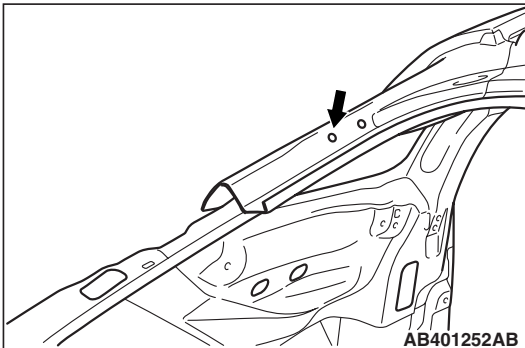
ADHESIVE: Epoxyayresin adhesive
BRAND: 3M™ AAD Part No.8115 or equivalent





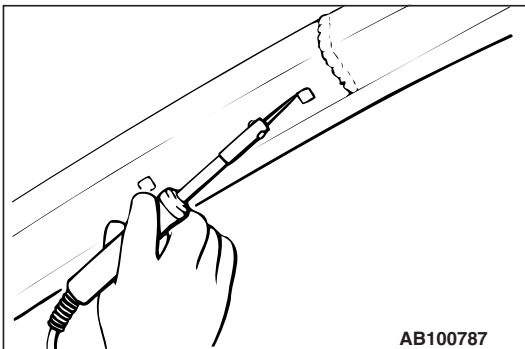
3. When assembling the new rear wheel house shield plate front parts, apply in advance adhesives to the areas shown in the figure of the instructions.

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



4. Assemble the rear quarter inner panel upper, 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.

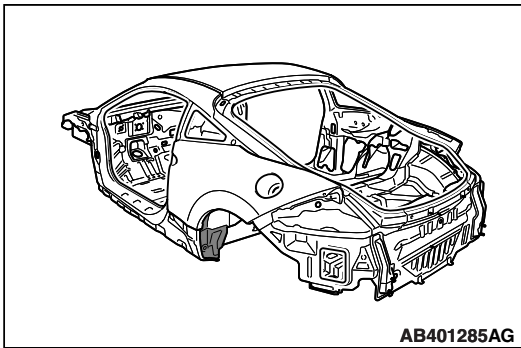
FOAM: 3M™ AAD ULTRAPRO Panel foam-Yellow



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.

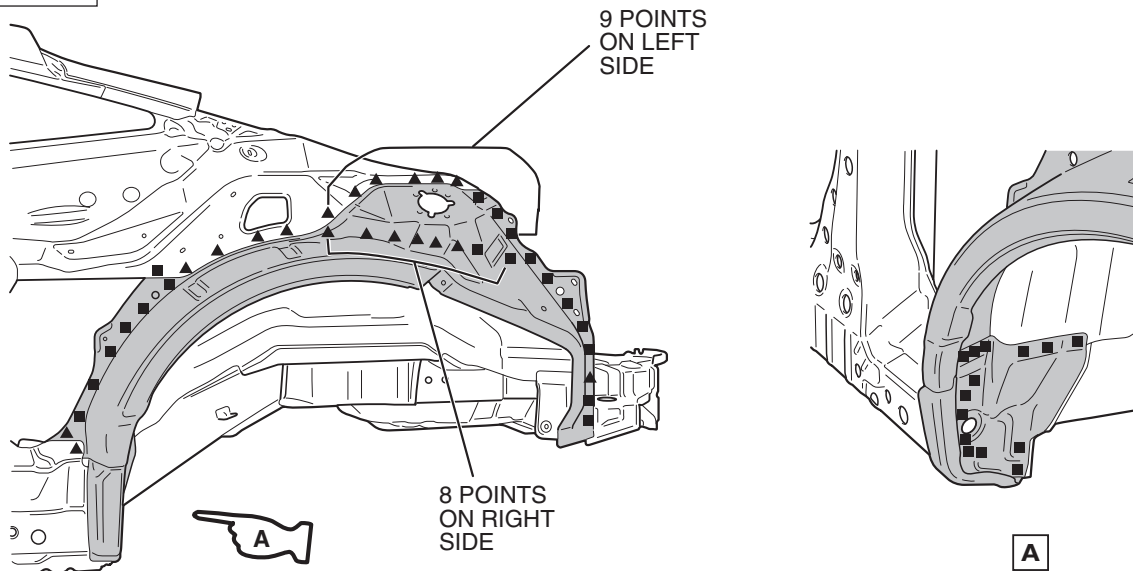
QUARTER INNER LOWER

M4030001100082



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)

AB401146AB

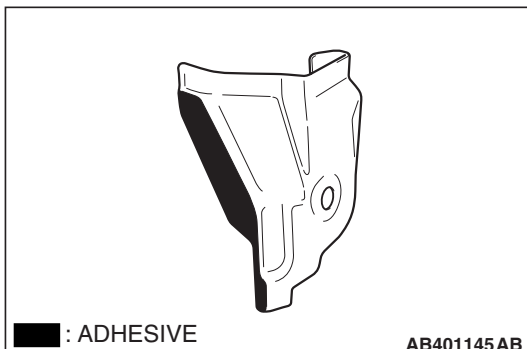
NOTE: Refer to the Quarter Outer section on P.3-22 for the welding points with the quarter outer.

NOTE ON REPAIR WORK

INSTALLATION

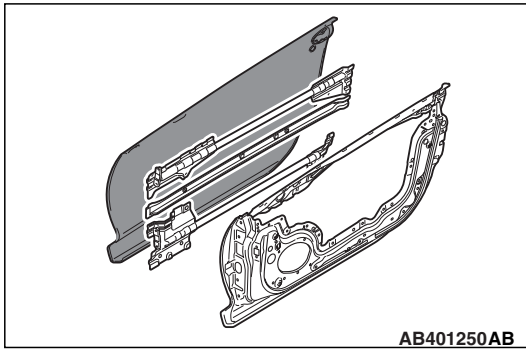
When assembling the new rear wheelhouse shield plate front parts, apply in advance adhesives to the areas shown in the figure of the instructions.


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



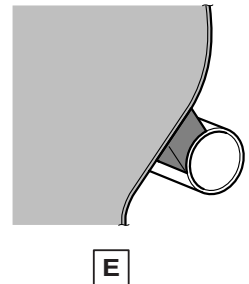
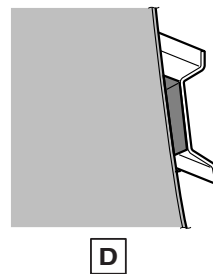
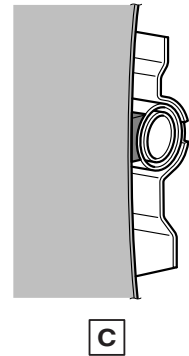
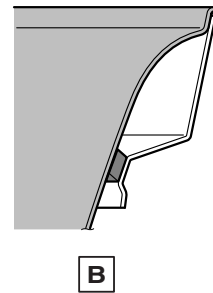
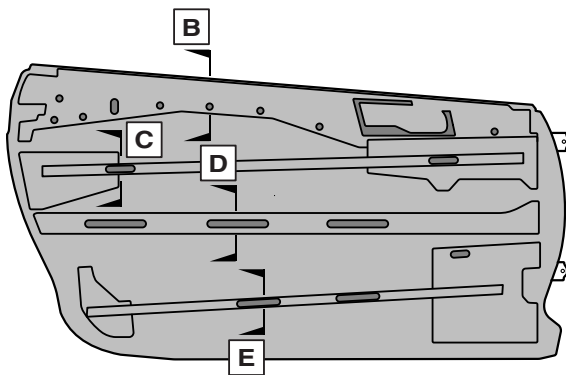
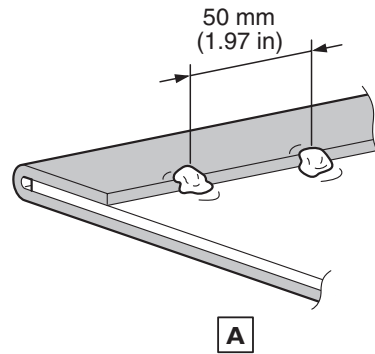
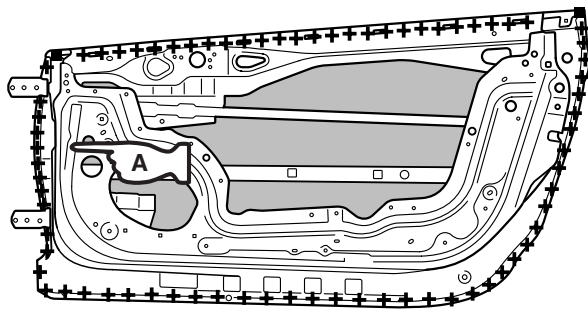
FRONT DOOR OUTER PANEL (WELDED TYPE)

M4030001500013



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: Urethane body sealer

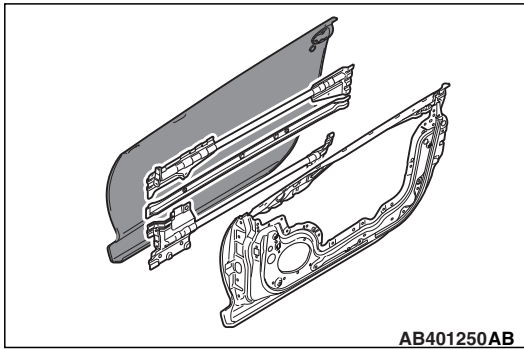
BRAND: 3M™ AAD Part No.8542 or equivalent


AB401278AB

NOTE: After hemming the front door outer panel, MIG spot weld the flange overlap section at a pitch of 50 mm (1.97 inches).

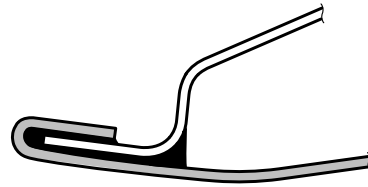
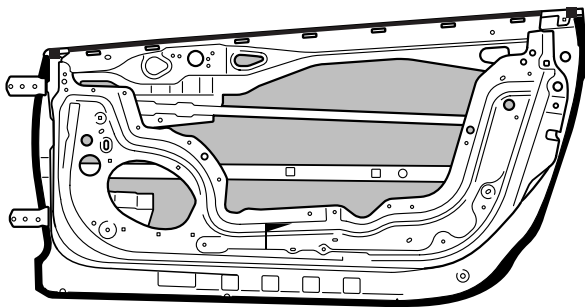
FRONT DOOR OUTER PANEL (ADHESION TYPE)

M4030001700017



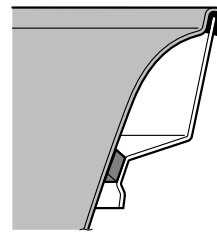
SYMBOL	OPERATION DESCRIPTION
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■ : indicates two panels to be welded) (▲ : indicates three panels to be welded)
++++	MIG spot welding
	MIG arc welding (continuous)
○○○○○○○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply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

REPAIR WELDS

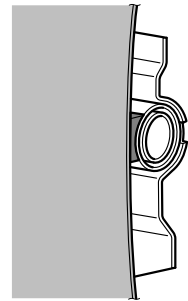


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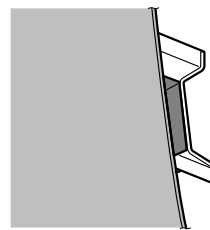
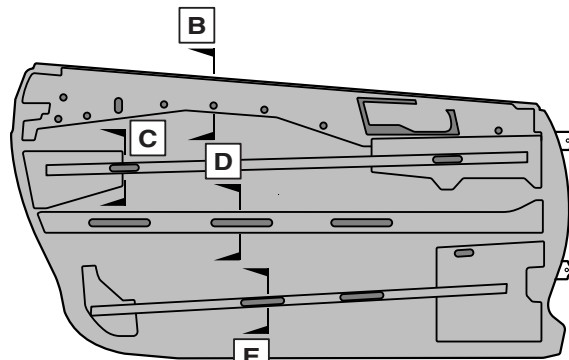
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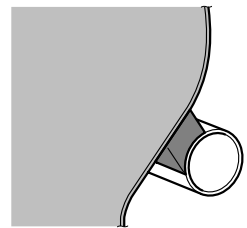
B



C



D



E

AB401304AB

■ : ADHESIVE 1
■ : ADHESIVE 2

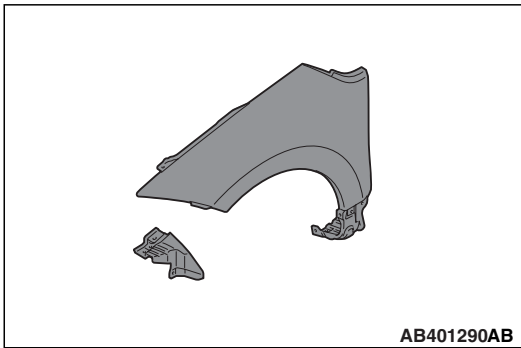
- **ADHESIVE 1:** Urethane body sealer
BRAND: 3M™ AAD Part No.8542 or equivalent
- **ADHESIVE 2:** Epoxyayresin adhesive
BRAND: 3M™ AAD Part No.8115 or equivalent


NOTE ON REPAIR WORK

INSTALLATION

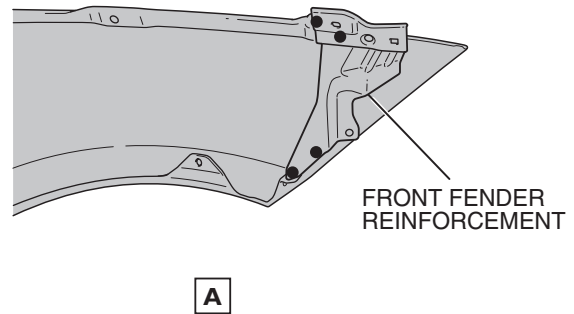
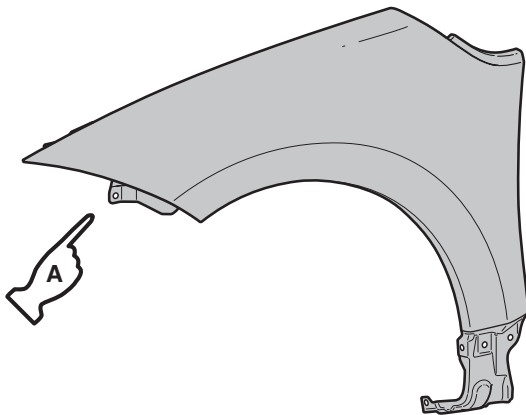
1. When installing the front door outer panel, grind the bonding surface and remove the paint to improve adhesion. Then, degrease the front door outer panel.
2. Install the front door outer panel and hem it. Then, wipe off the adhesive that squeezed out.

FRONT FENDER



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



AB401277AB

NOTE ON REPAIR WORK

REMOVAL

When assembling the new front fender reinforcement parts, apply in advance adhesives to the areas shown in the figure of the instructions.

ADHESIVE: Urethane body sealer
BRAND: 3M™ AAD Part No.8542 or equivalent

