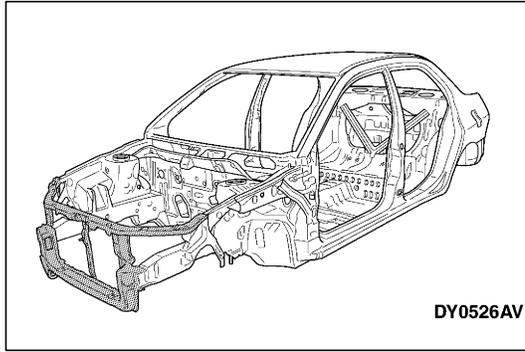

WELDED PANEL REPLACEMENT

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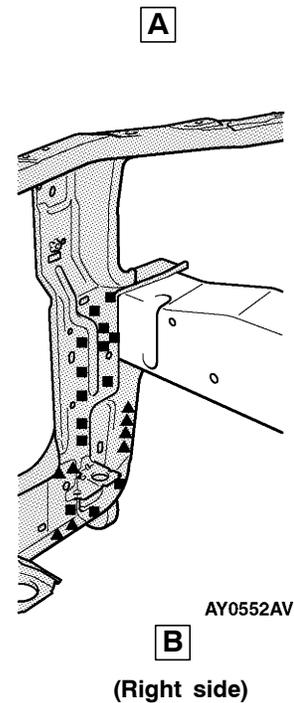
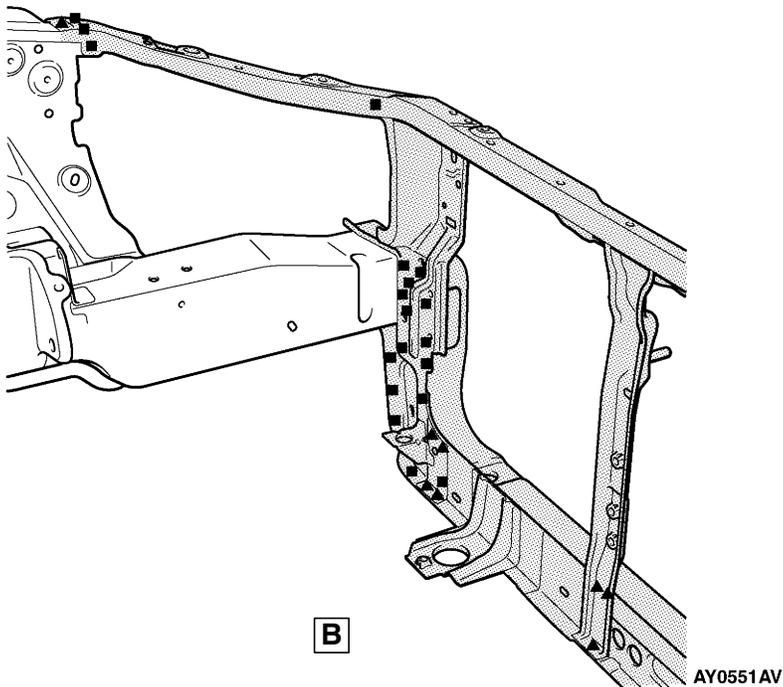
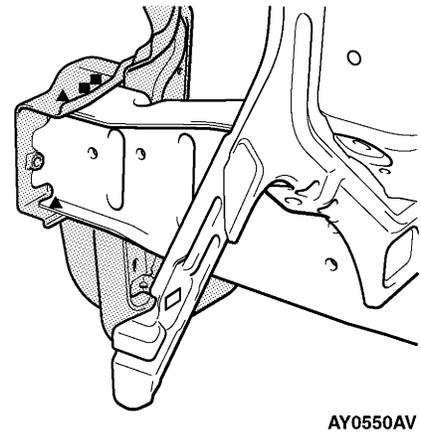
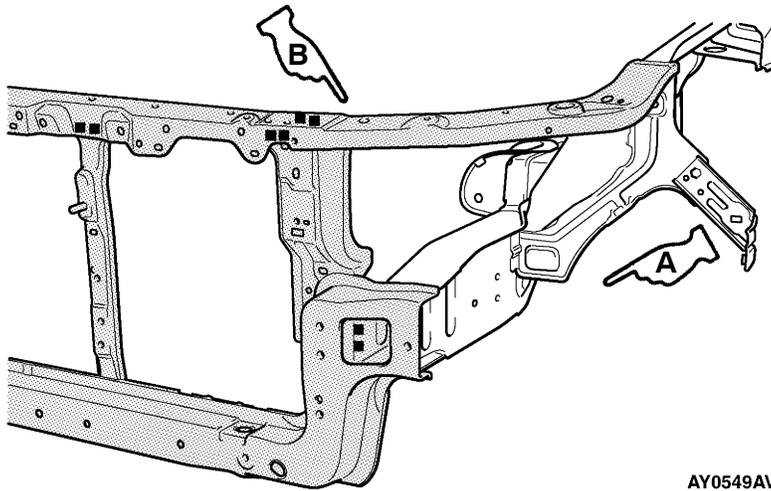


HEADLAMP SUPPORT

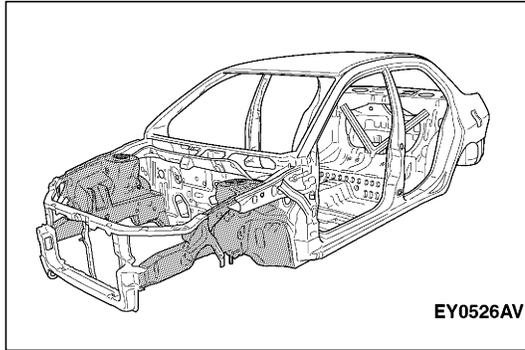


Symbol	Operation description
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
+ + + +	MIG spot welding
	MIG arc welding (continuous)
○ ○ ○ ○ ○ ○ ○ ○	Braze welding
	Anti-corrosion agent application locations (Use access holes to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

REPAIR WELDS

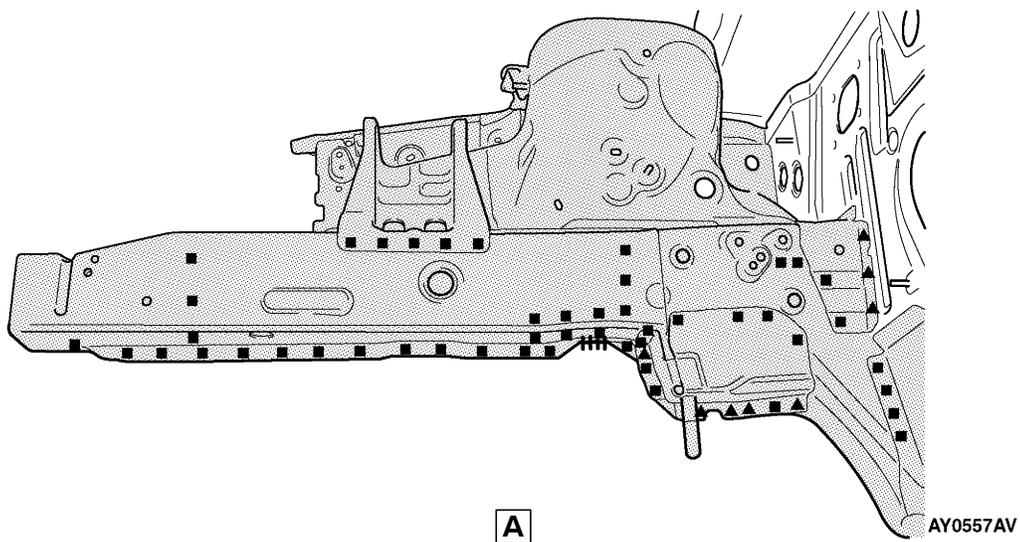
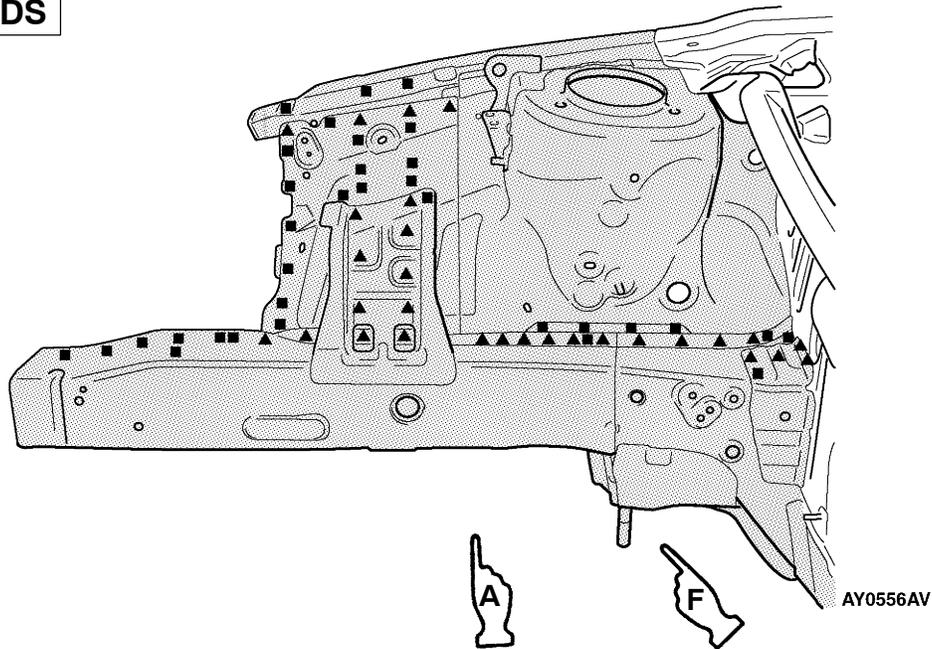


FENDER SHIELD



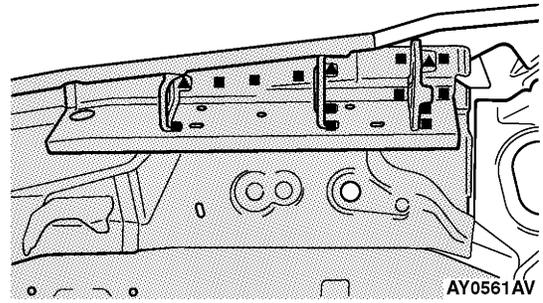
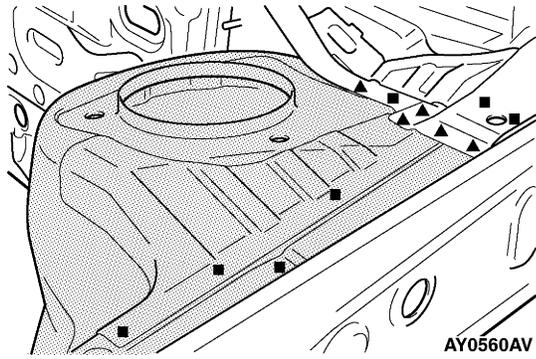
Symbol	Operation description
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
+ + + +	MIG spot welding
	MIG arc welding (continuous)
○ ○ ○ ○ ○ ○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply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

REPAIR WELDS



NOTE

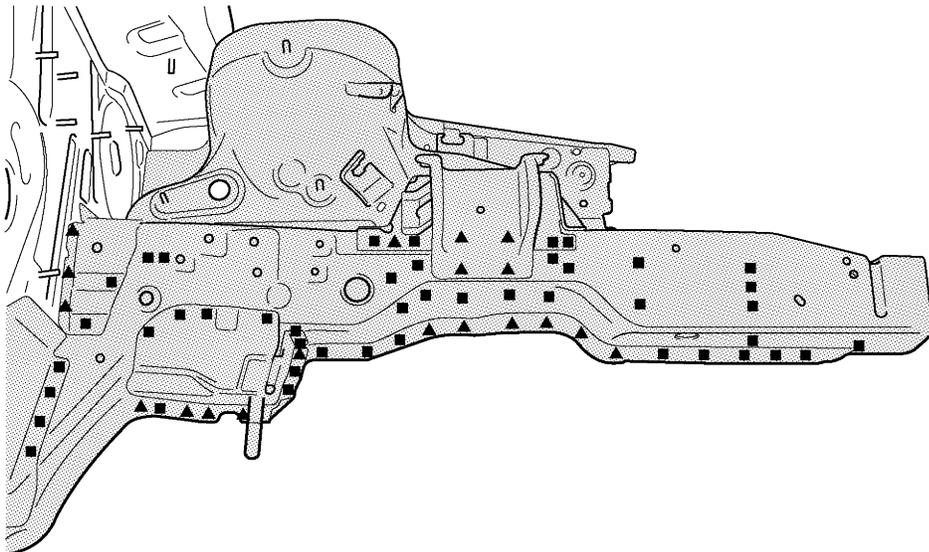
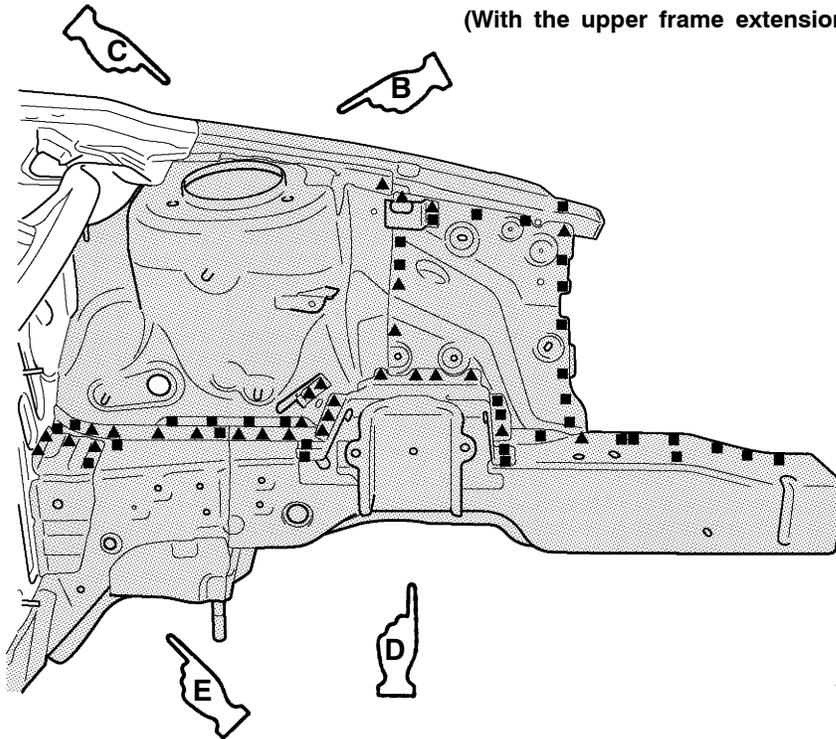
For the weld points for the headlamp support, refer to P.C-3 Headlamp Support.



B

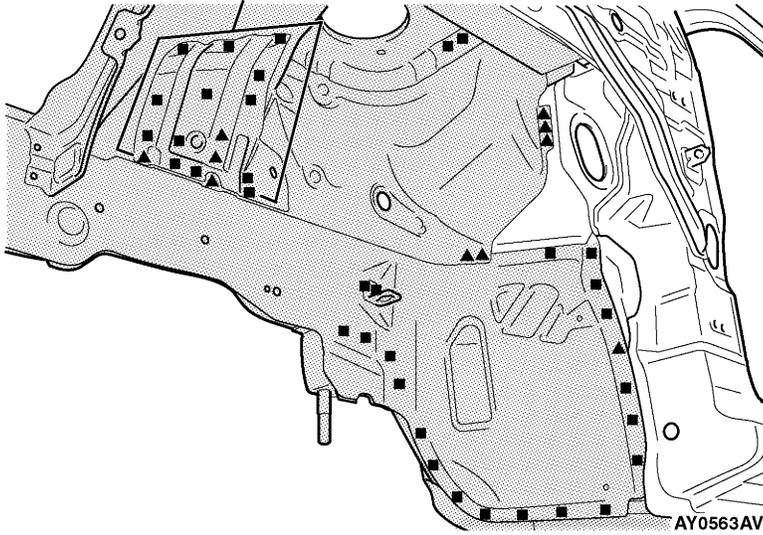
C

(With the upper frame extension outer removed)



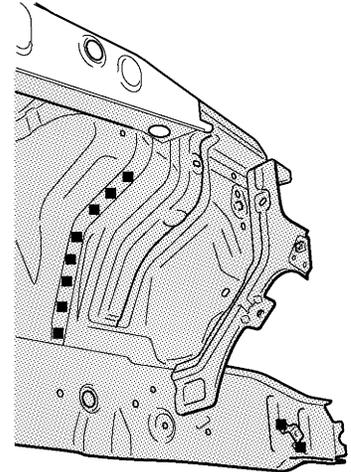
D

17 points, left side only



E

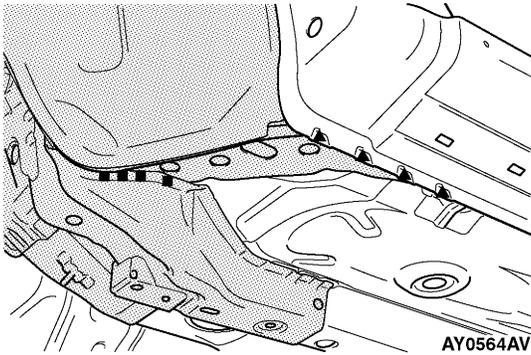
H



F

AY0562AV

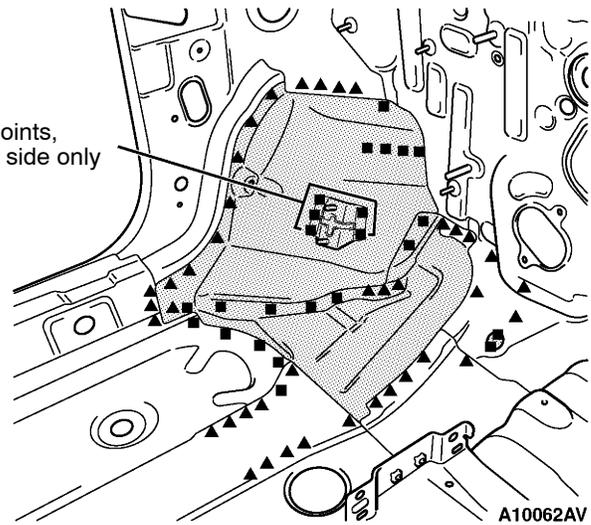
G



G

AY0564AV

5 points,
left side only

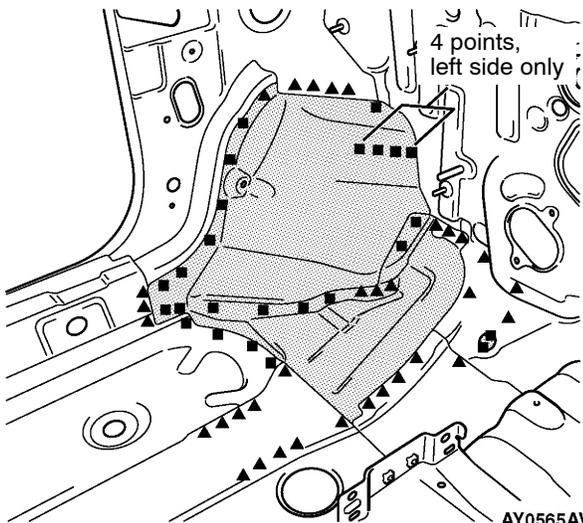


H

<LHD>

A10062AV

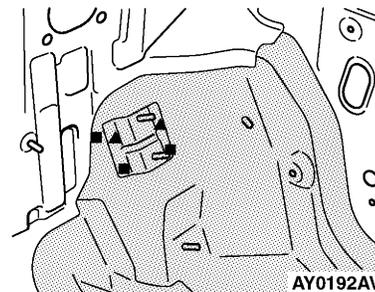
4 points,
left side only



H

<RHD>

AY0565AV

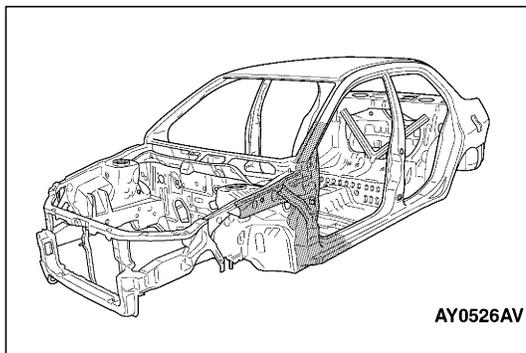


I

<RHD(Right side)>

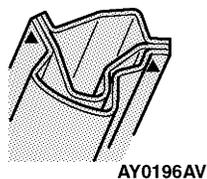
AY0192AV

FRONT PILLAR

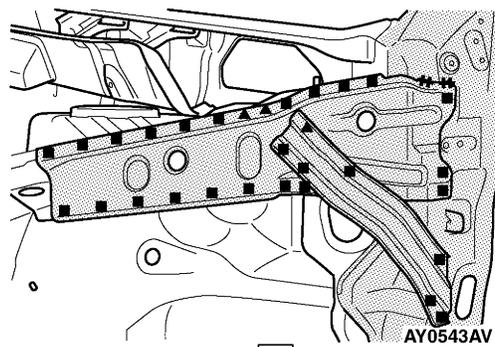


Symbol	Operation description
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
+ + + +	MIG spot welding
	MIG arc welding (continuous)
○ ○ ○ ○ ○ ○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply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

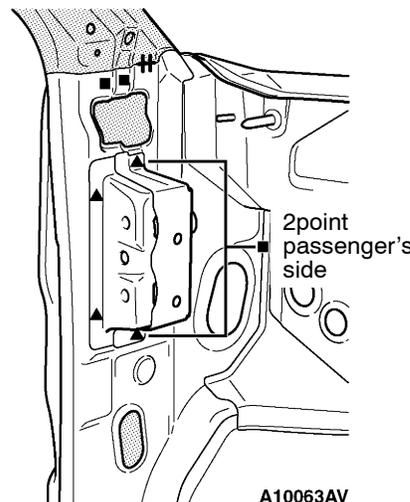
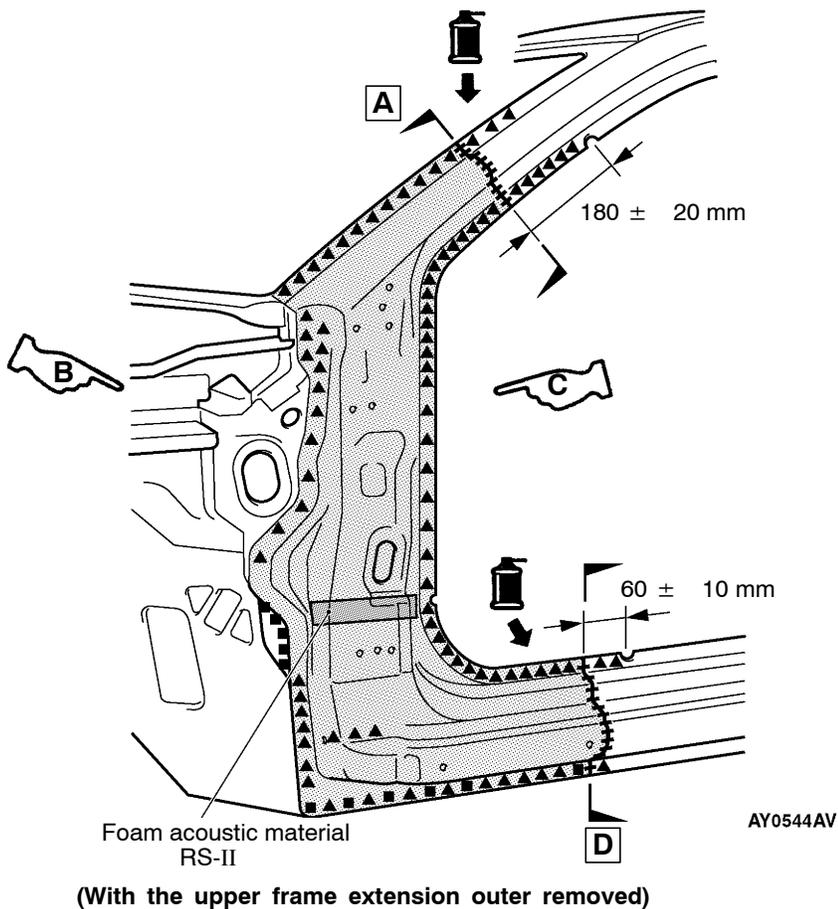
REPAIR WELDS



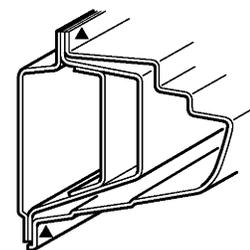
A



B



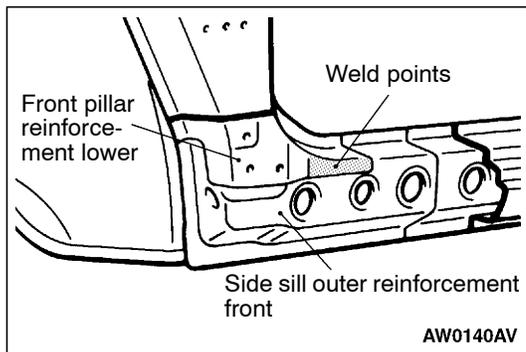
C



D

Y0200AV

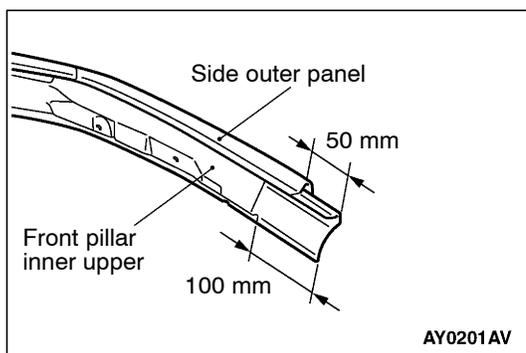
Caution
Do not use heat at areas using foam material as the foam material may burn.



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.

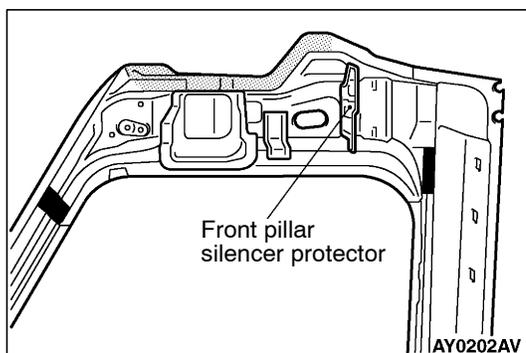


INSTALLATION

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.

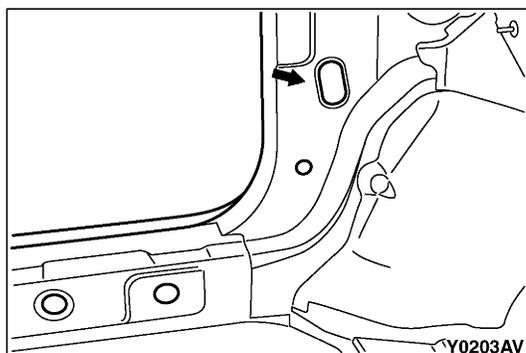


3. When installing a new front pillar outer, install a front pillar silencer protector filling up the gap with butyl tape<RS-II> and then apply body sealant and structural adhesive on the area shown in the illustration.

▨ : Body sealant

■ : Adhesive

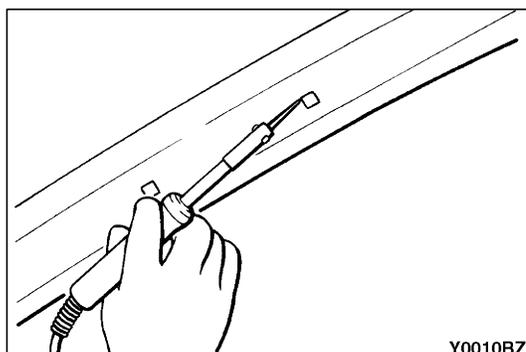
Adhesive	Type	BRAND
	Epoxyayresin adhesive	3M DP-460, 3M DP-420 or equivalent



<The following service procedures are only applied to RS-II.>

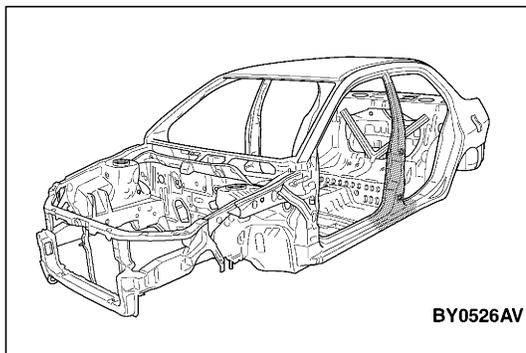
4. After attaching the front pillar outer, seal the holes and flanges with bolts and plate tape, fill the foam material through the holes as shown in the illustration.

Foam material	Type	Brand Used
Foam acoustic material	Two - part expanded urethane	3M ULTRAPRO Panel foam - Yellow



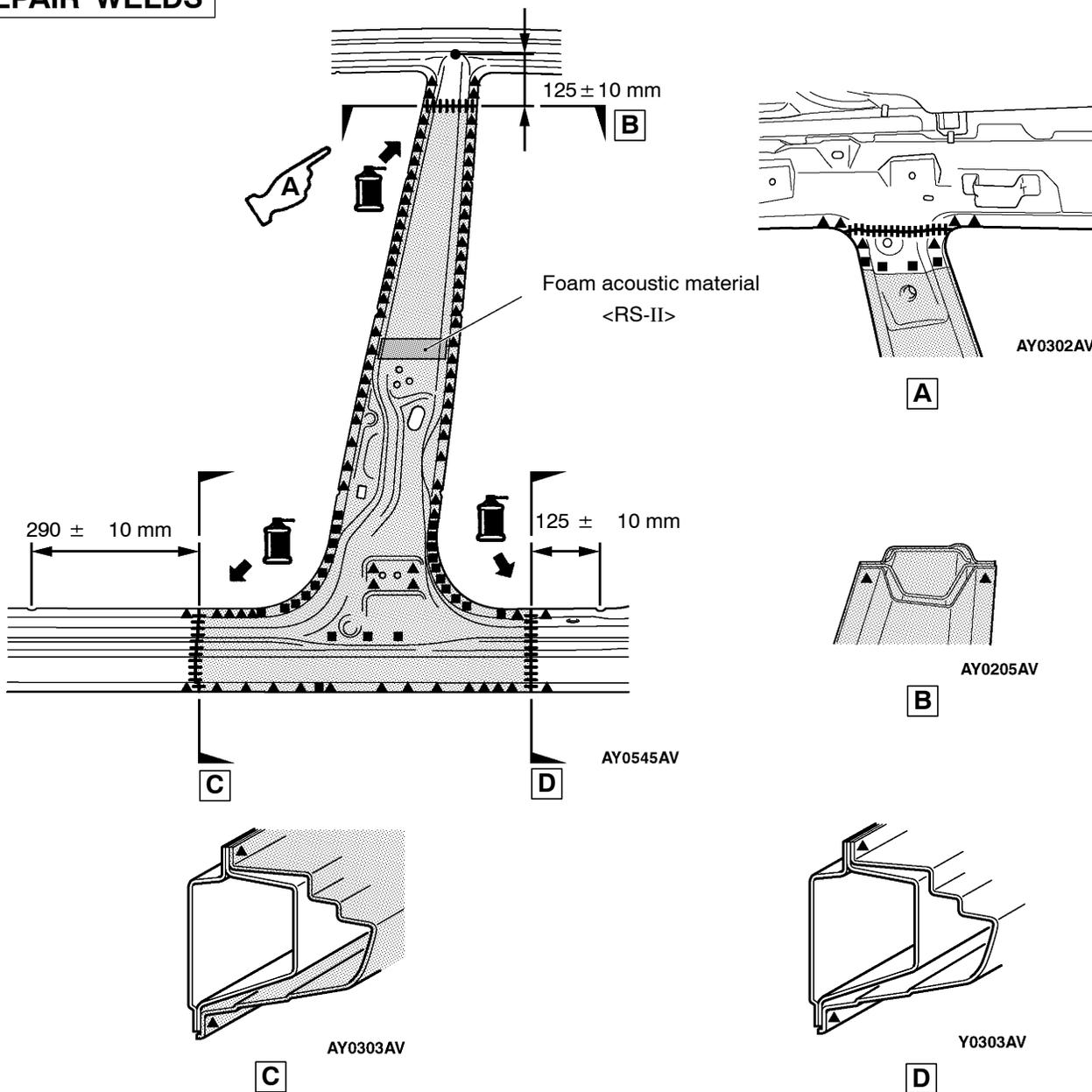
5. About two hours after filling the foam material, remove the bolts and plate tape, and solder the sealed holes until a clip, etc. can be inserted completely.

CENTER PILLAR

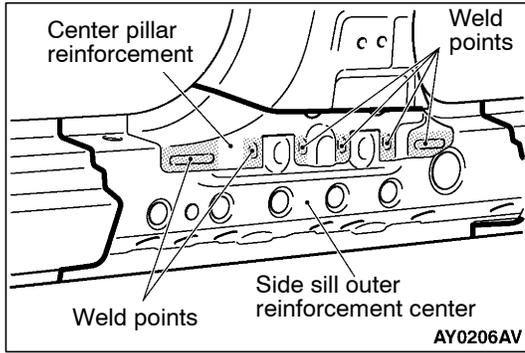


Symbol	Operation description
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
+ + + +	MIG spot welding
	MIG arc welding (continuous)
○ ○ ○ ○ ○ ○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply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

REPAIR WELDS



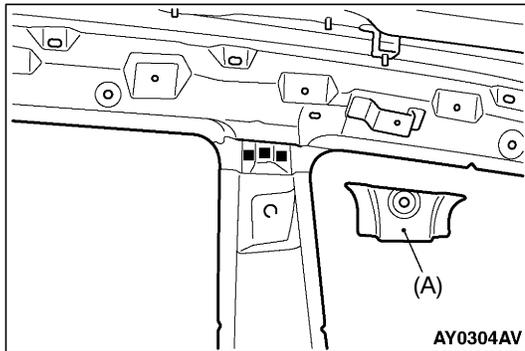
Caution
Do not use heat at areas using foam material as the foam material may burn.



NOTE ON REPAIR WORK

REMOVAL

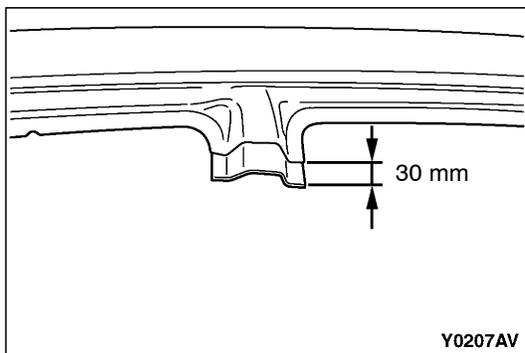
1. As the center pillar reinforcement and side sill outer reinforcement center are welded at the side sill, cut the side outer panel at the position shown in the illustration where the weld points of the reinforcement can be seen, remove, and then remove the weld points of the center pillar reinforcement.



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

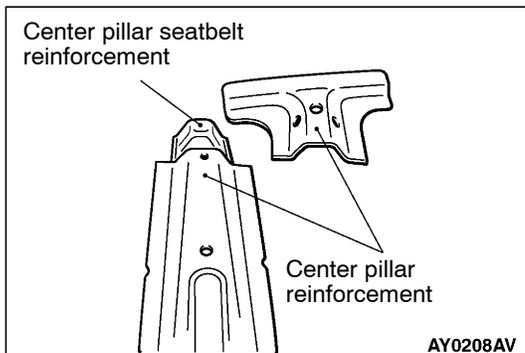
Keep the separated side roof rail inner (A) for the future use.



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 of the front pillar, cut the side outer panel 30 mm above the cut area.

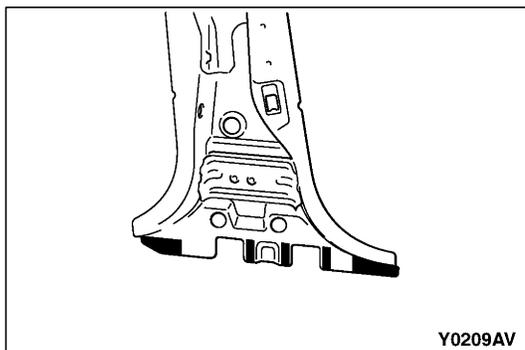
Cut the new center pillar at the same positions.



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

Caution

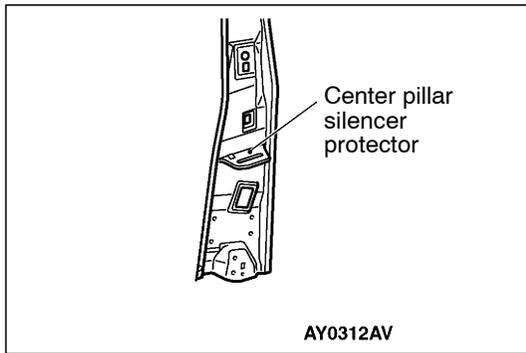
If the center pillar seatbelt reinforcement has been damaged, repair by welding.



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

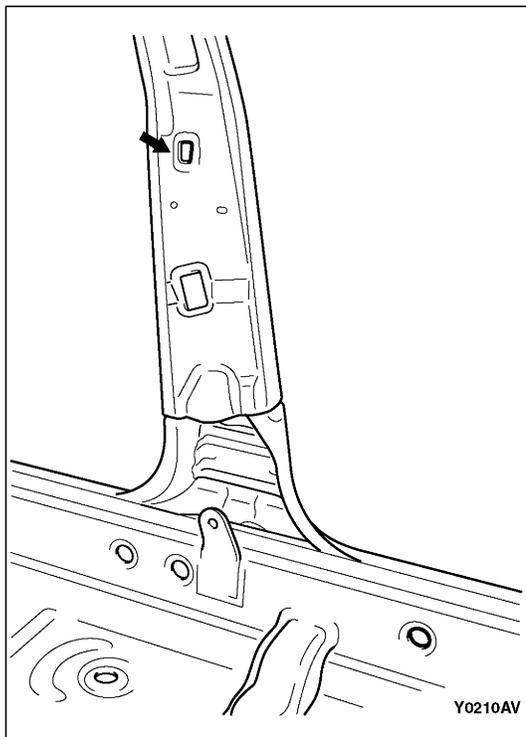
■ : Adhesive

Adhesive	Type	BRAND
	Epoxyayresin adhesive	3M DP-460, 3M DP-420 or equivalent



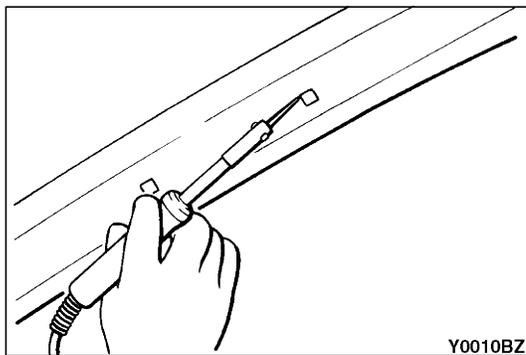
<The following service procedures are only applied to RS-II.>

- 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.



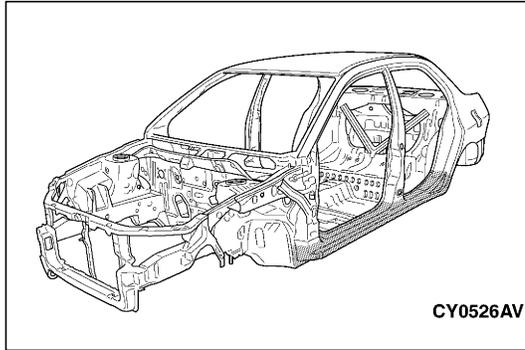
- After attaching the center pillar outer, seal the holes and flanges with bolts and plate tape, fill the foam material through the holes as shown in the illustration.

Foam material	Type	Brand Used
Foam acoustic material	Two - part expanded urethane	3M ULTRAPRO Panel foam - Yellow



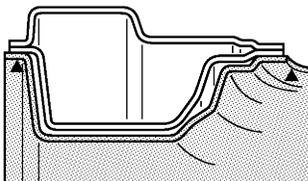
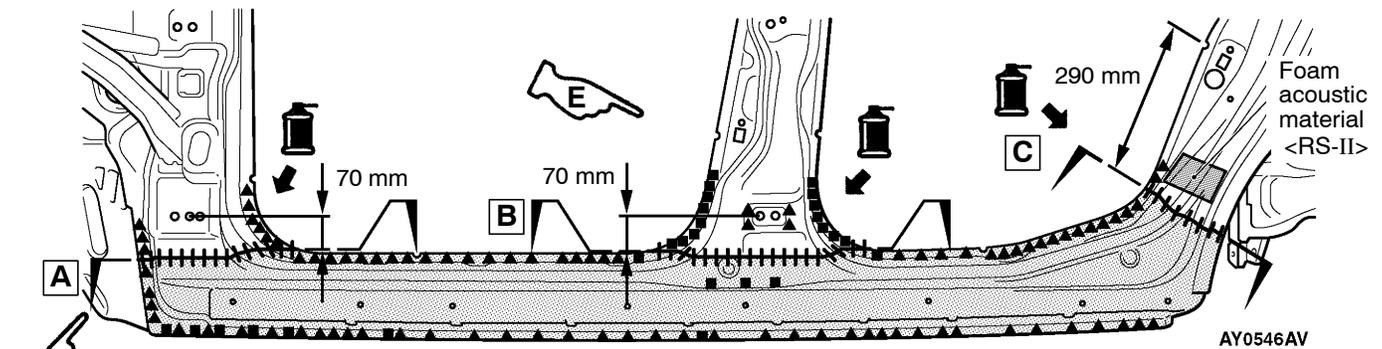
- About two hours after filling the foam material, remove the bolts and plate tape, and solder the sealed holes until a clip, etc. can be inserted completely.

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.)

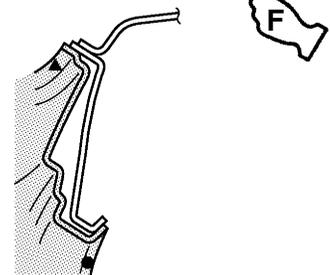
REPAIR WELDS



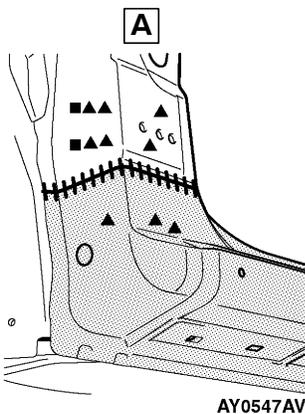
AY0215AV



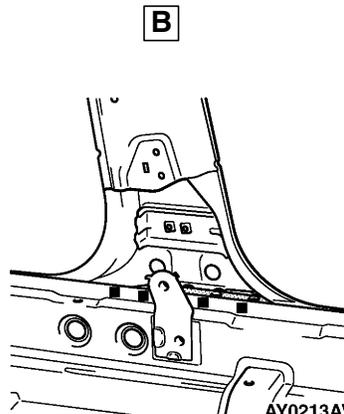
AY0216AV



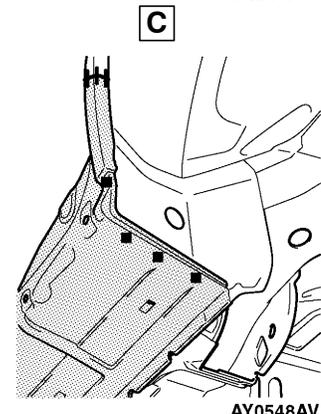
AY0217AV



AY0547AV



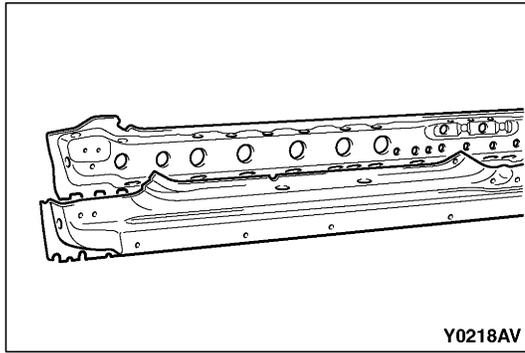
AY0213AV



AY0548AV

Caution

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

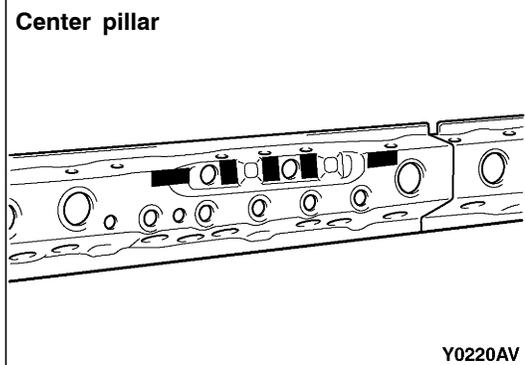
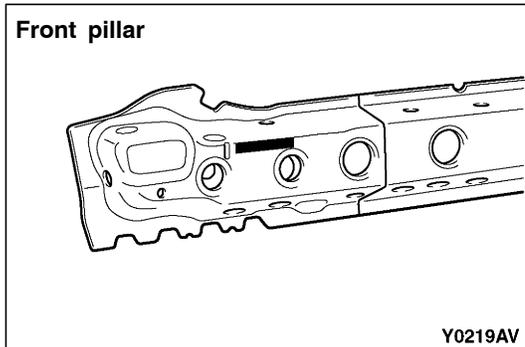


**NOTE ON REPAIR WORK
INSTALLATION**

1. Release the side outer panel from the new parts and remove unnecessary front pillar reinforcement lower, front pillar reinforcement lower extension, and 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.

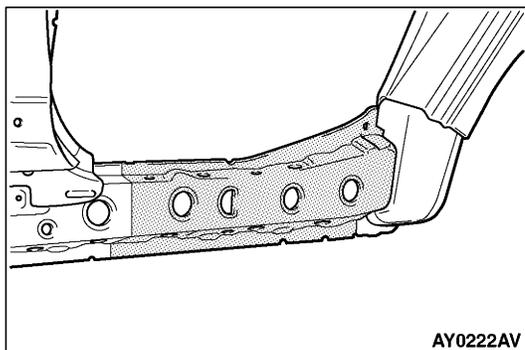
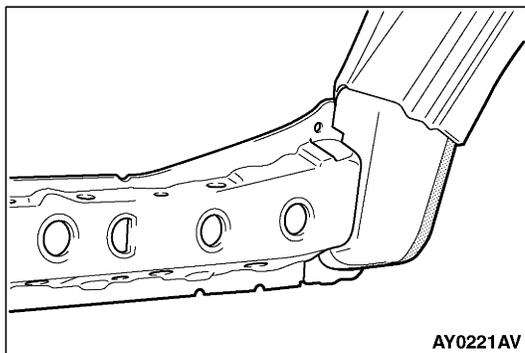
■: Adhesive

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



Reference

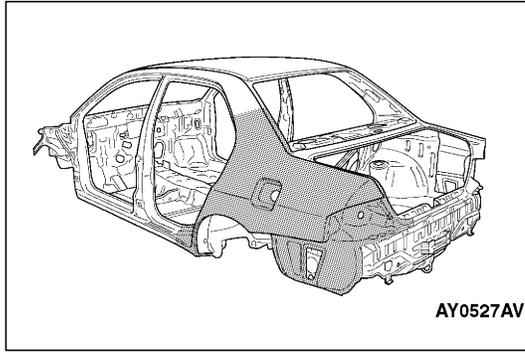
Depending on the damaged range, it is advisable to replace the side outer panel and side sill outer reinforcement parts.

▨: Cuttable range

Caution

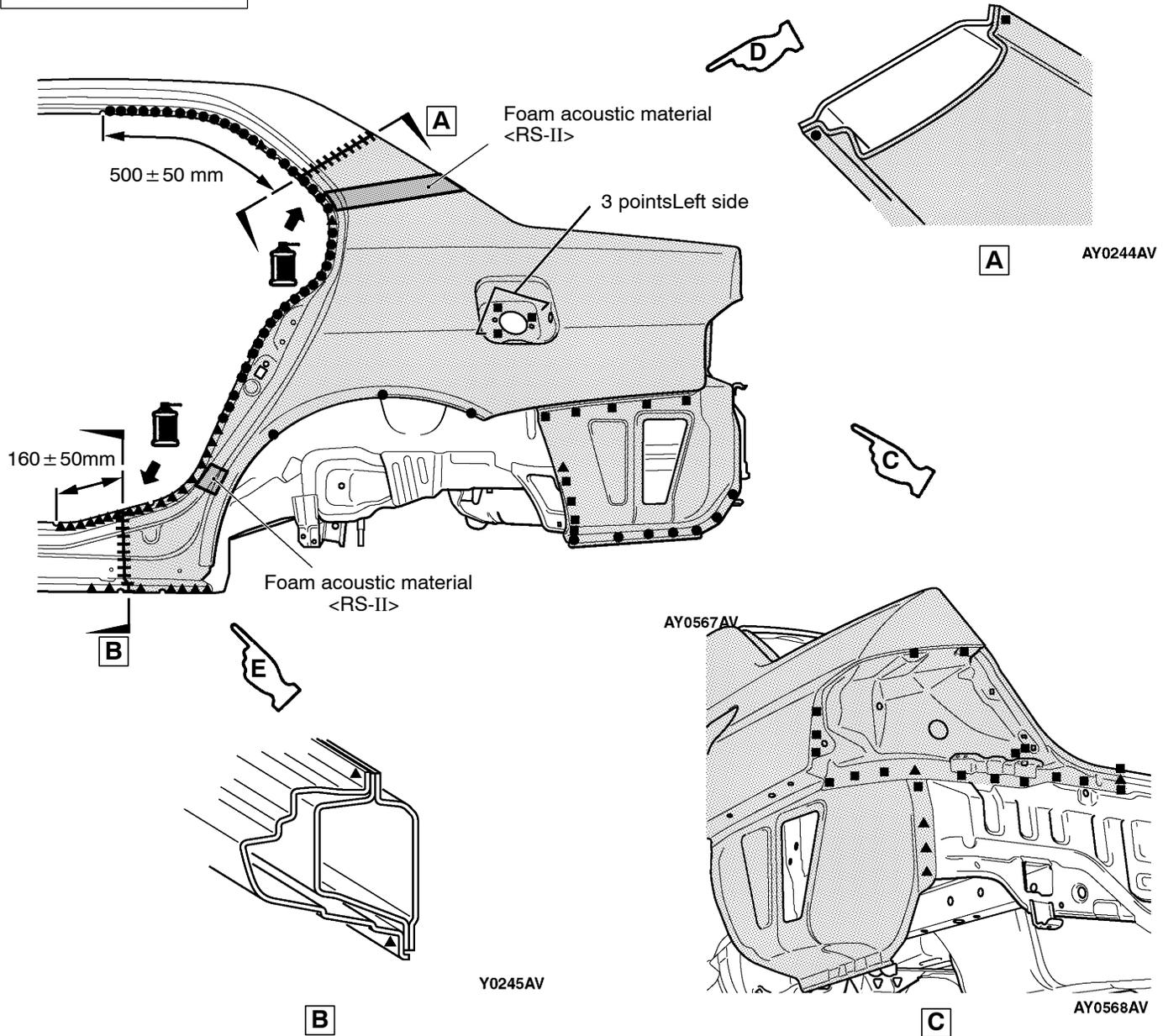
Cut the side sill outer reinforcement 50 mm away from the cut area of the side outer panel.

QUARTER, OUTER



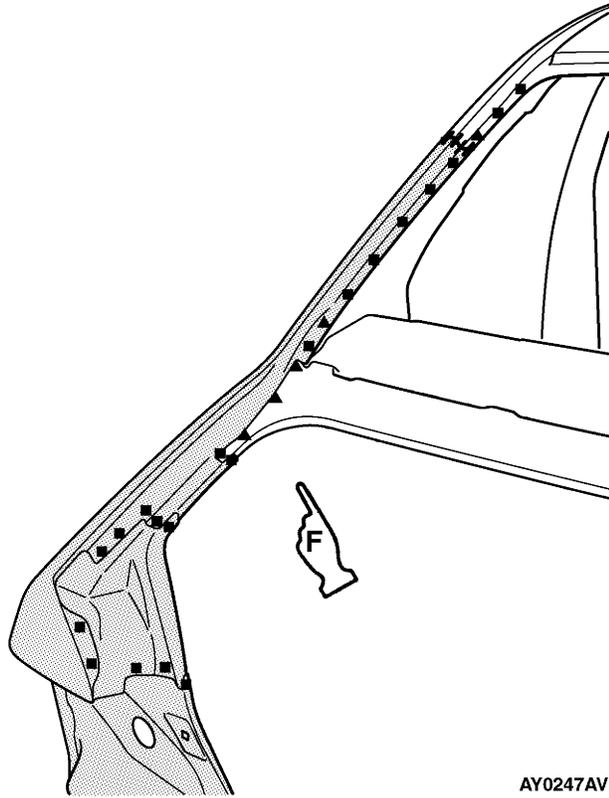
Symbol	Operation description
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
+ + + +	MIG spot welding
	MIG arc welding (continuous)
○ ○ ○ ○ ○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply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

REPAIR WELDS

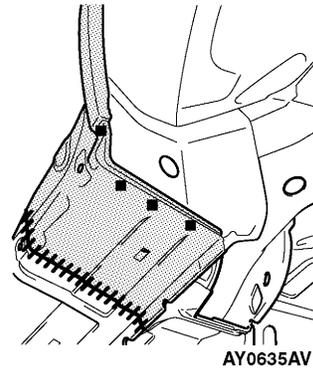


Caution

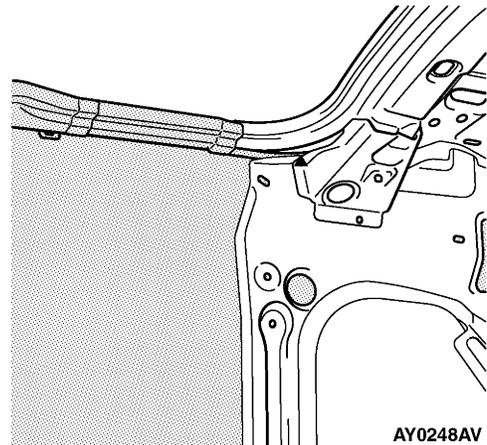
Do not use heat at areas using foam material as the foam material may burn.



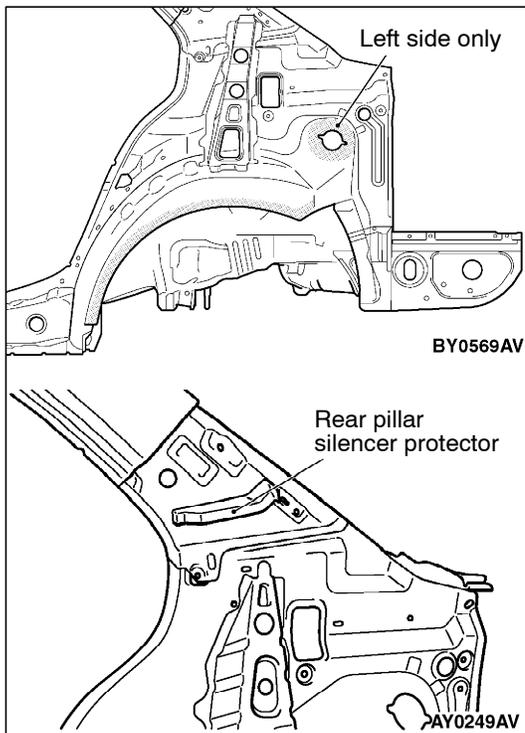
D



E



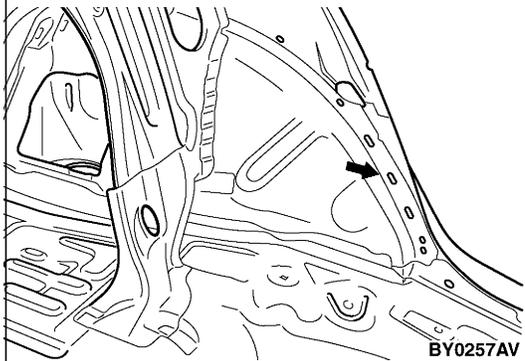
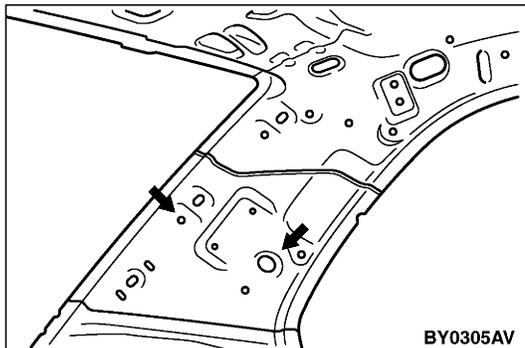
F



**NOTE ON REPAIR WORK
INSTALLATION**

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

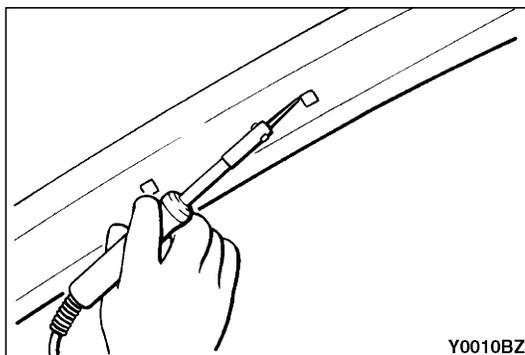
 : Body sealant



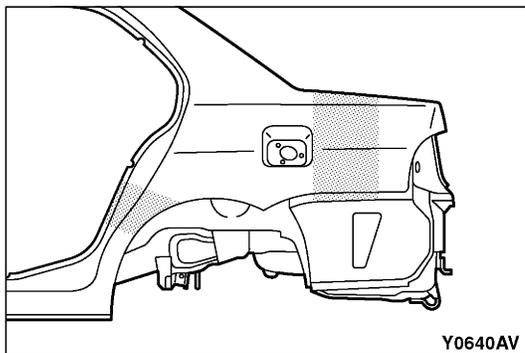
<The following service procedures are only applied to RS-II.>

2. 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.

Foam material	Type	Brand Used
Foam acoustic material	Two-part expanded urethane	3M ULTRAPRO Panel foam - Yellow



3. 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.

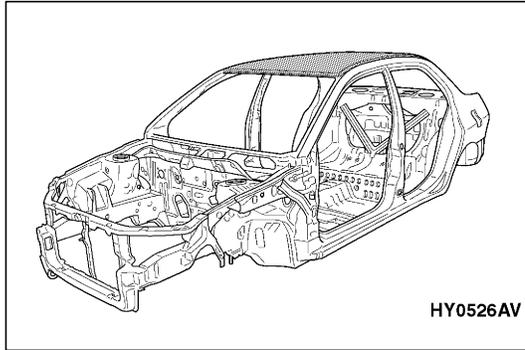


Reference
Parts replacement is advised. depending on the damaged range.

▨ : Cuttable range

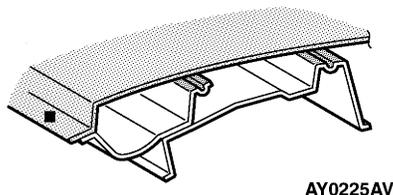
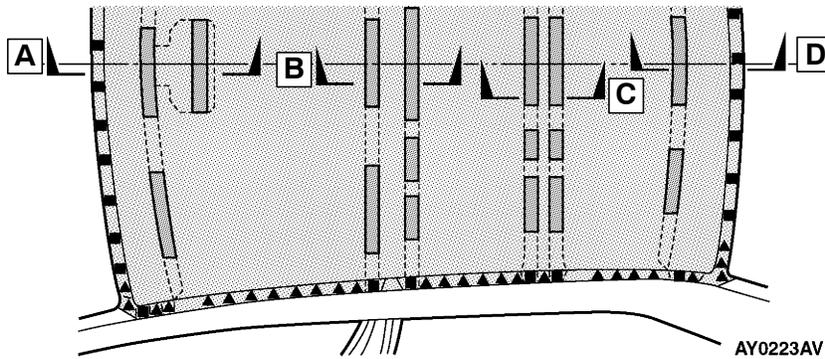
Caution
Avoid the fuel filler bracket (left side).

ROOF



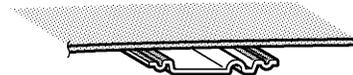
Symbol	Operation description
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
+ + + +	MIG spot welding
	MIG arc welding (continuous)
○○○○○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally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

REPAIR WELDS



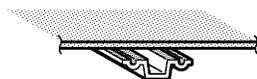
AY0225AV

A



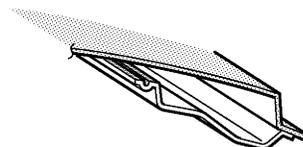
AY0226AV

B



AY0227AV

C



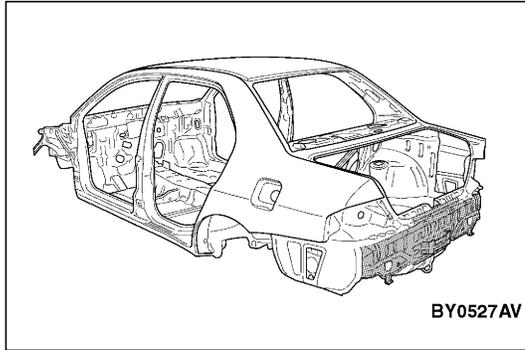
AY0228AV

D

 : Adhesive

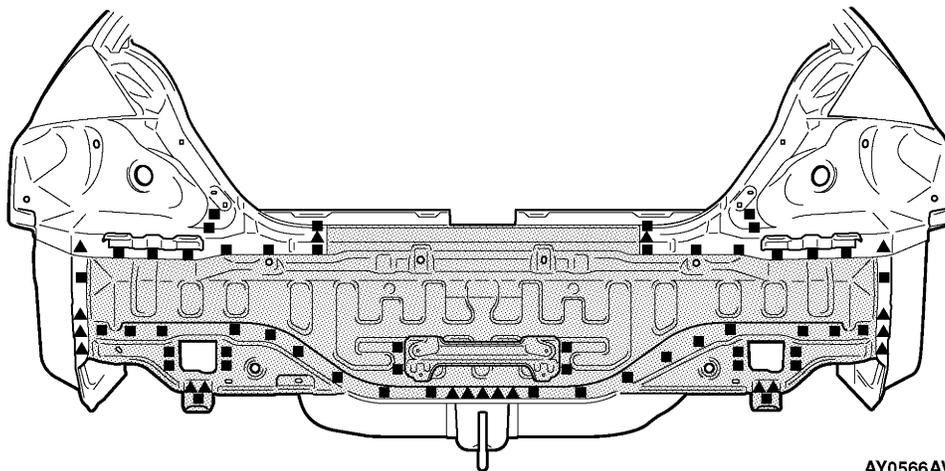
Adhesive	Type
	Chloroprene-base drying sealant

REAR END PANEL

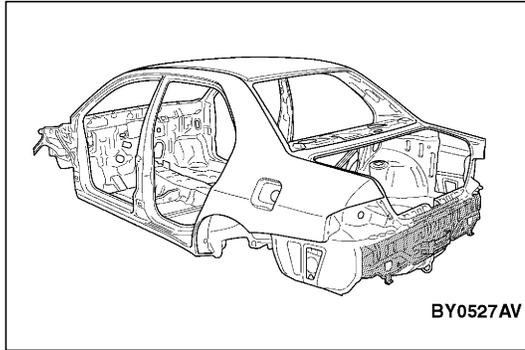


Symbol	Operation description
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
+ + + +	MIG spot welding
	MIG arc welding (continuous)
○○○○○○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply liberally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

REPAIR WELDS

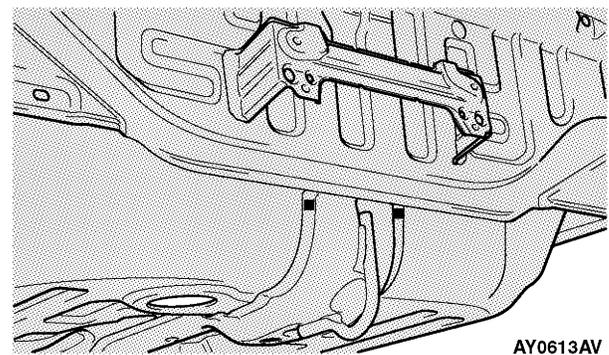
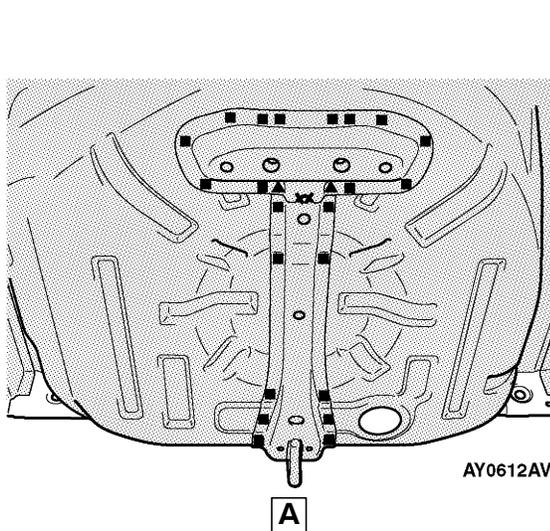
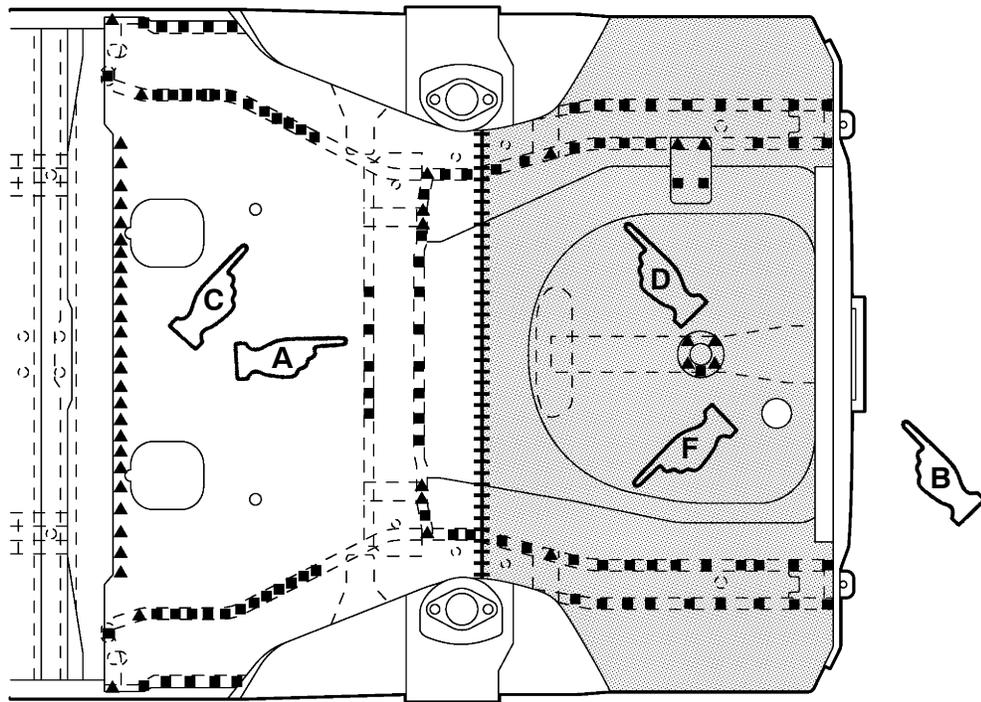


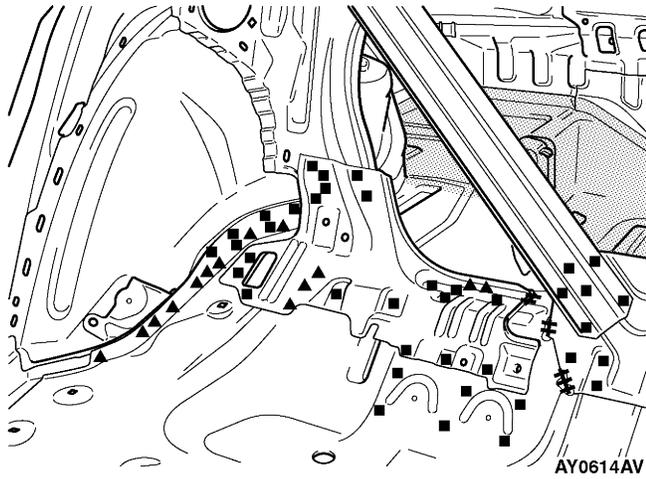
REAR FLOOR



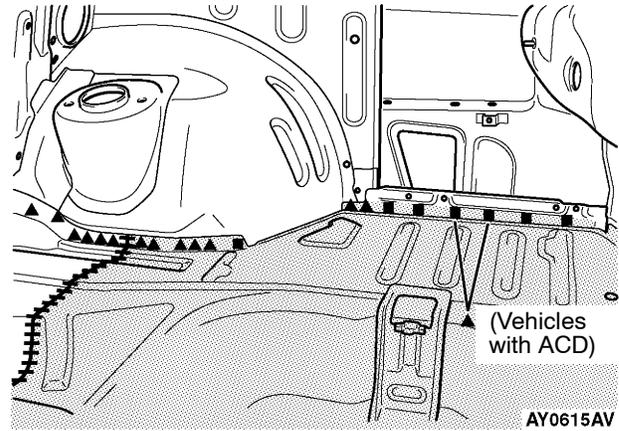
Symbol	Operation description
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
+ + + +	MIG spot welding
	MIG arc welding (continuous)
○ ○ ○ ○ ○ ○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply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

REPAIR WELDS

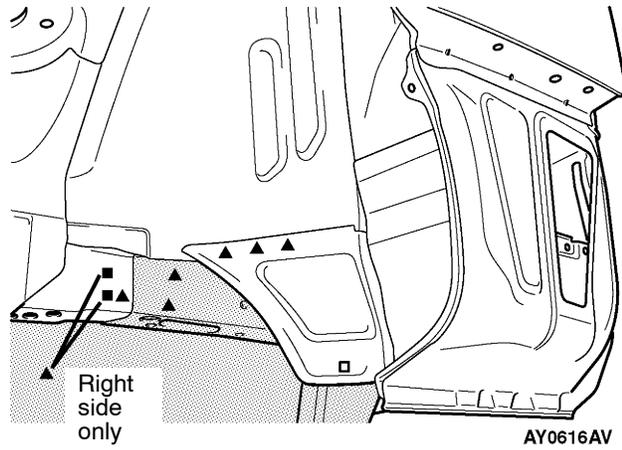




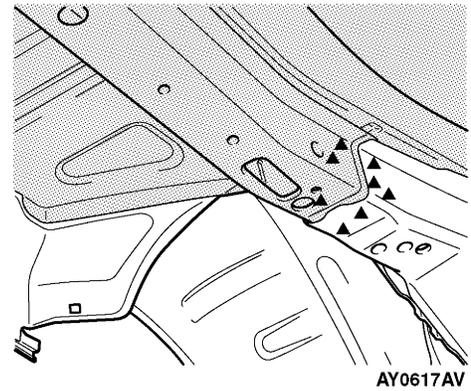
C



D



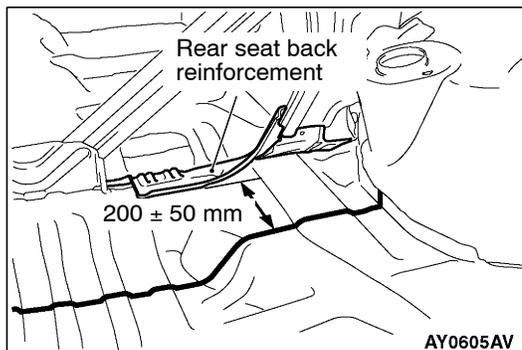
E



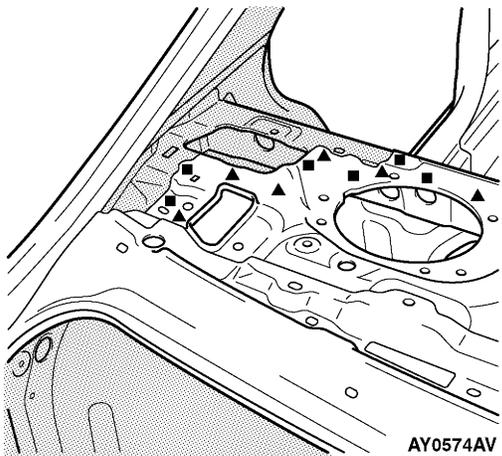
F

NOTE

For details on the weld points with the rear end panel refer to REAR END PANEL on P.C-18.

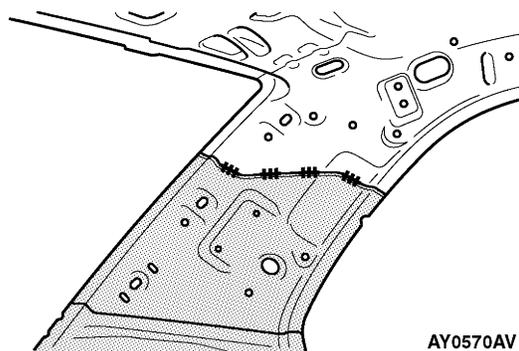
**NOTE ON REPAIR WORK
REMOVAL**

1. Cut the rear floor panel 320 ± 10 mm from the back of the rear seat back reinforcement.
Cut the rear floor pan 200 ± 50 mm from the back of the rear seat back reinforcement as shown in the illustration.



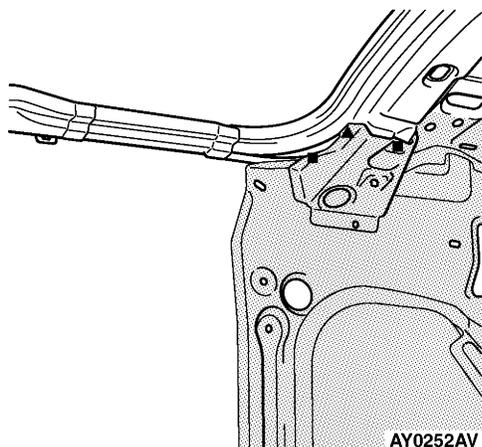
C

AY0574AV



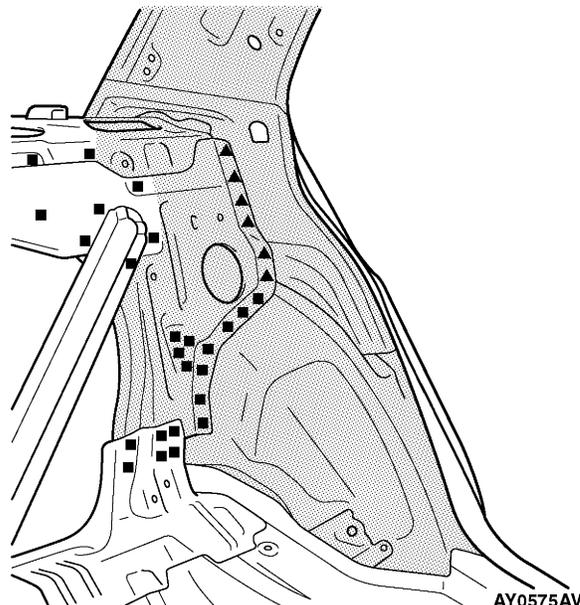
AY0570AV

D



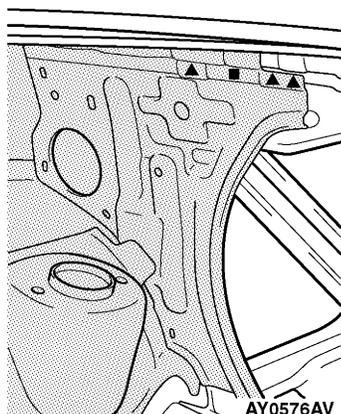
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E



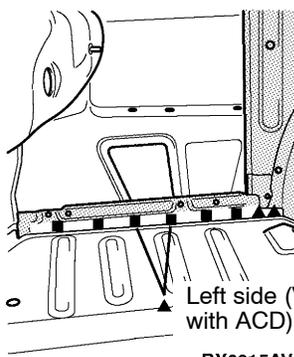
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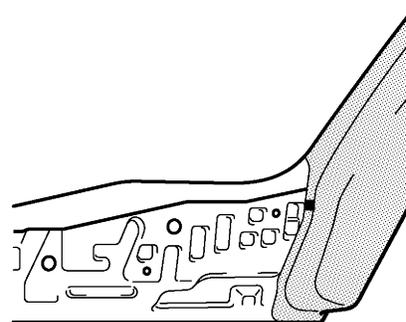
AY0576AV

G



Left side (Vehicles with ACD)
BY0615AV

H

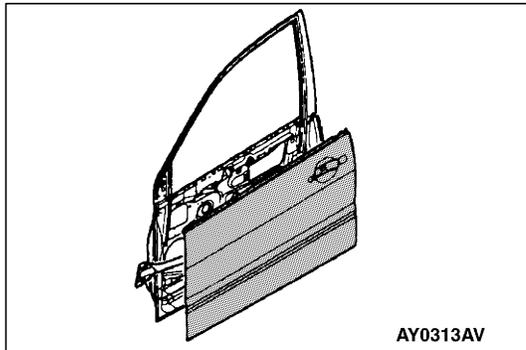


AX0125AV

I

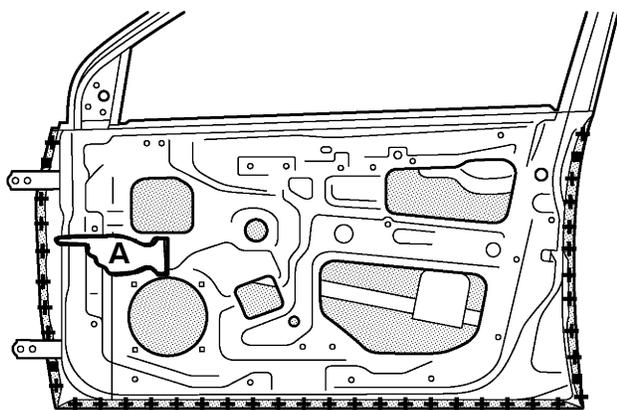
(With the side sill outer reinforcement rear removed.)

FRONT DOOR OUTER PANEL

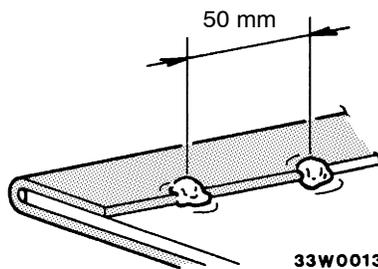


Symbol	Operation description
● ● ● ●	Spot welding
■ ■ ▲ ▲	MIG plug welding (■: indicates two panels to be welded ▲: indicates three panels to be welded)
+ + + +	MIG spot welding
	MIG arc welding (continuous)
○ ○ ○ ○ ○	Braze welding
	Anti-corrosion agent application locations (Use access holes to apply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

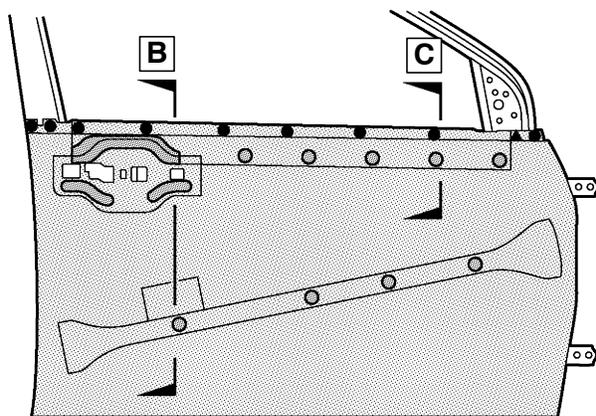
REPAIR WELDS



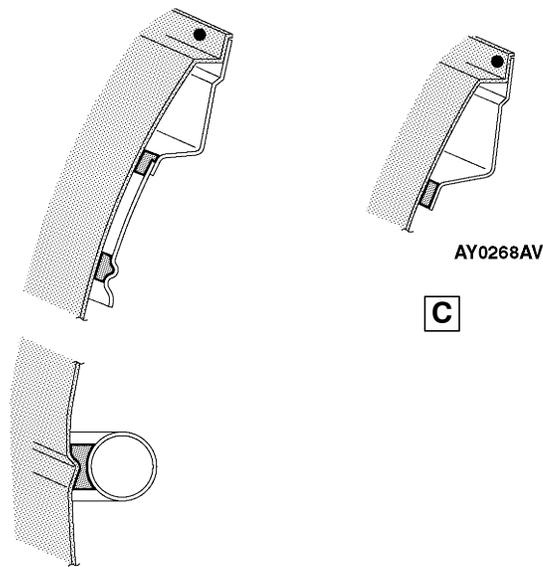
AY0265AV



A



AY0266AV



AY0267AV

B

AY0268AV

C

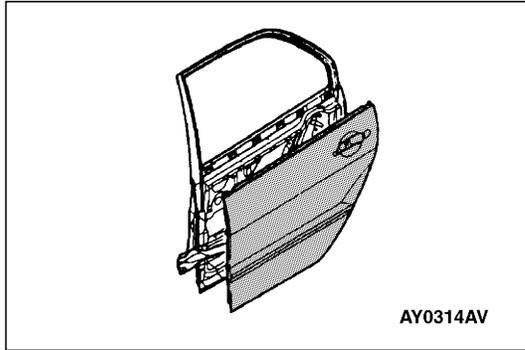
 : Adhesive

Adhesive	Type
	Chloroprene-base drying sealant

NOTE

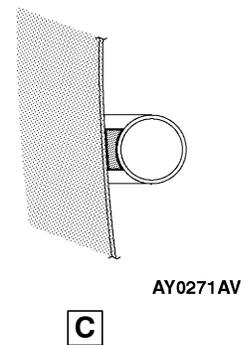
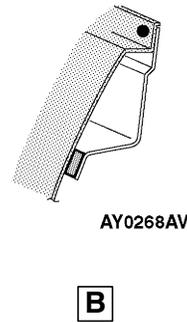
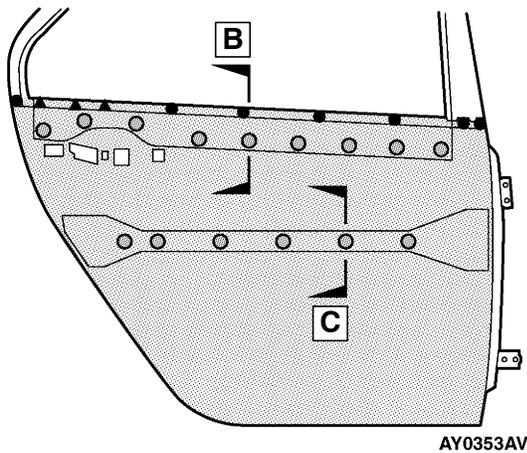
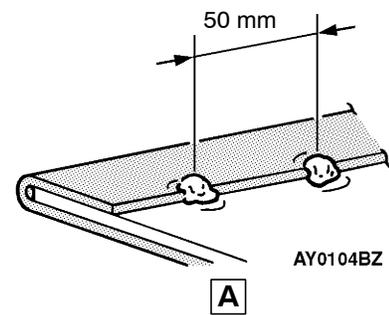
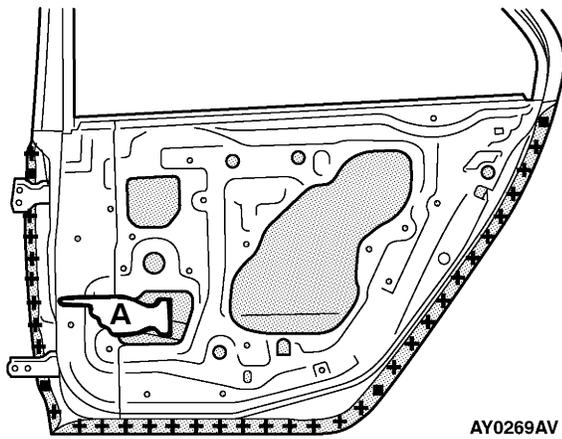
After hemming the door outer panel, MIG spot weld the flange overlap section at a pitch of approx. 50 mm.

REAR DOOR OUTER 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



 : 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.