
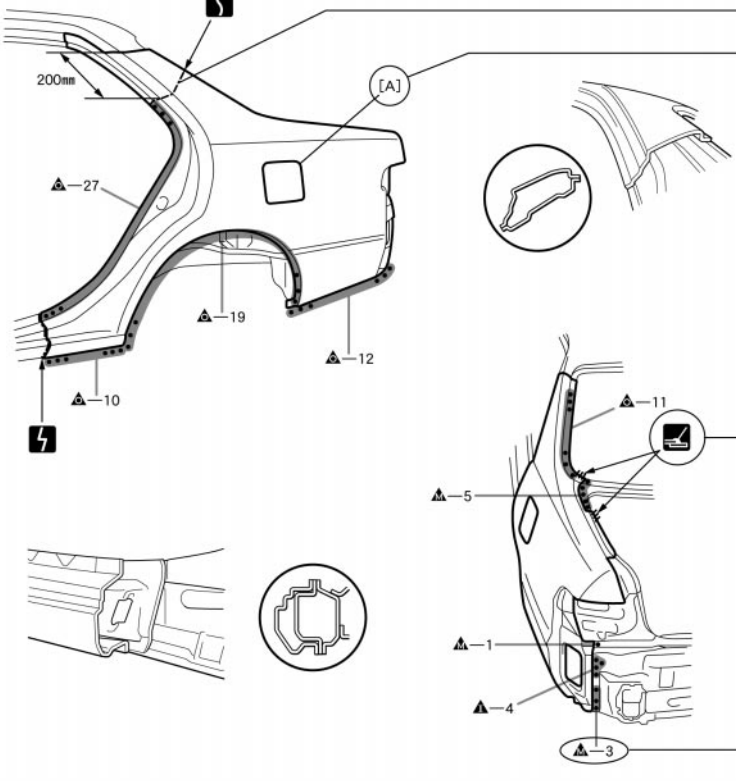

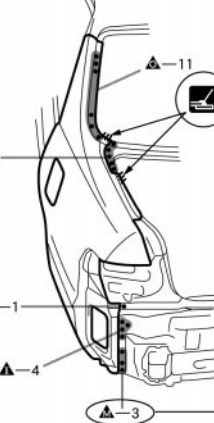


# HOW TO USE THIS MANUAL

## 1. BODY PANEL REPLACEMENT THIS MANUAL

BP-34		BODY PANEL REPLACEMENT	
(A)	QUARTER PANEL (CUT) REPLACEMENT		(C)
(B)	REMOVAL		
(D)			(I)
(E)	<p>POINT</p> <p>1 Remove the [A] at the same time.</p> <p>PART NAME</p> <p>[A] Fuel Filler Opening Lid</p>		(J)

(A) : REPLACEMENT PART AND METHOD  
QUARTER PANEL (CUT)

Replacement method  
 (ASSY) ... Assembly replacement  
 (CUT) ... Major cutting (less than 1/2 of part used)  
 (CUT-H) ... Half cutting (about 1/2 of part used)  
 (CUT-P) ... Partial cutting (most of part used)

Replacement part

(B) : REMOVAL CONDCTIONS

(C) : PART LOCATION

(D) : REMOVAL DIAGRAM  
 Describes in detail removal of the damaged part involving repair by cutting.

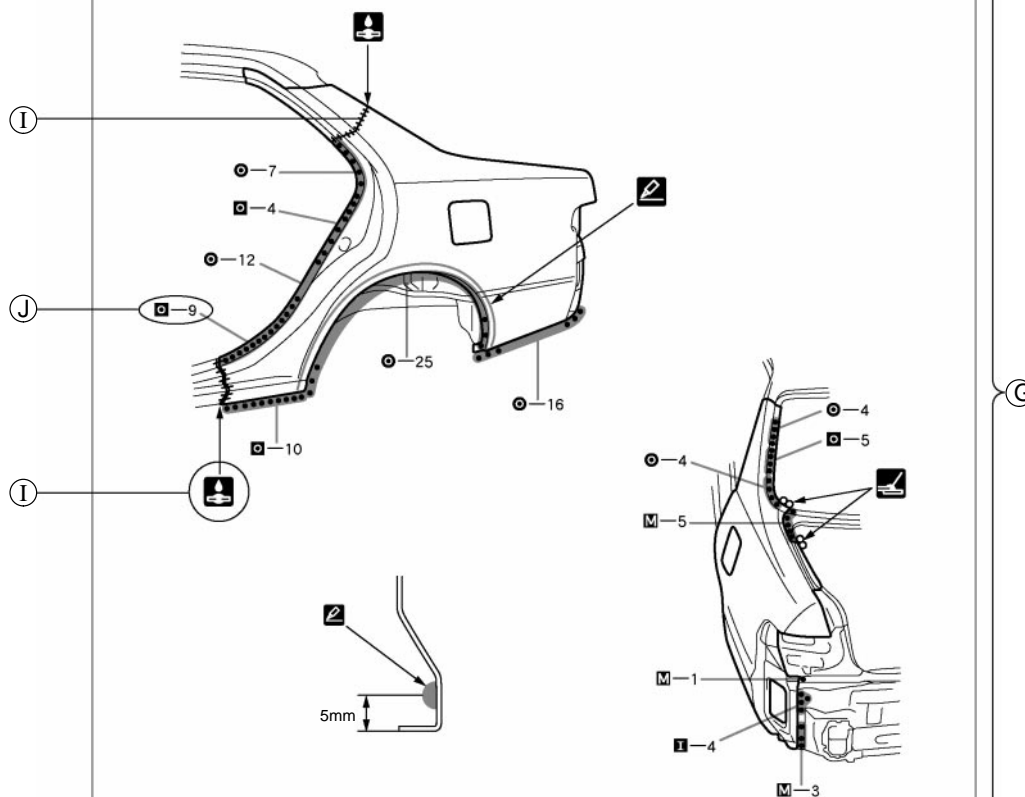
(E) : REMOVAL GUIDE  
 Provides additional information to more efficiently help you perform the removal.

## BODY PANEL REPLACEMENT

BP-35

## INSTALLATION

- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



## POINT

- 1 Before temporarily installing the new parts, apply body sealer to the wheel arch.

## HINT:

- 1) Apply body sealer about 5mm (0.20in.) front the flange, avoiding any oozing.
- 2) Apply sealer evenly, about 3 – 4mm (0.12 – 0.16in.) in diameter.
- 3) For other sealing points, refer to section PC.

## PART NAME

[A] Fuel Filler Opening Lid

[B] Waterproof Rivet

(F) : INSTALLATION CONDITIONS

(G) : INSTALLATION DIAGRAM

Describes in detail installation to the new part involving repair by welding and/or cutting, but excluding painting.

(H) : INSTALLATION GUIDE

Provides additional information to more efficiently help you perform the installation.

(I) : SYMBOLS

(See page IN-7)


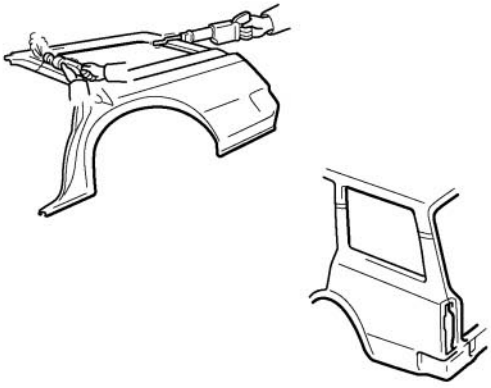




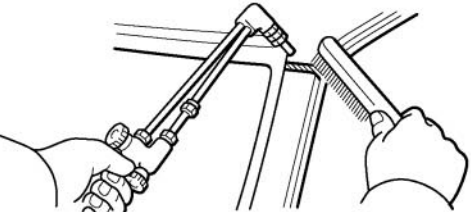

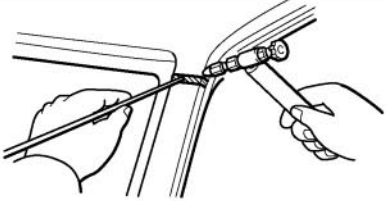
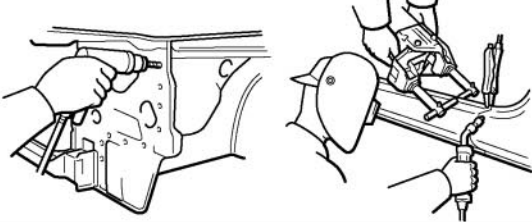










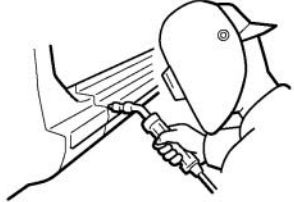



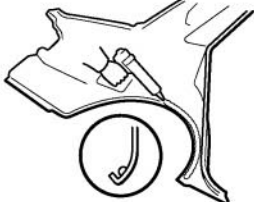
(J) : ILLUSTRATION OF WELD POINTS


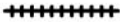


Weld method and panel position symbols (See page IN-9)

(K) : PART NAME

## 2. SYMBOLS

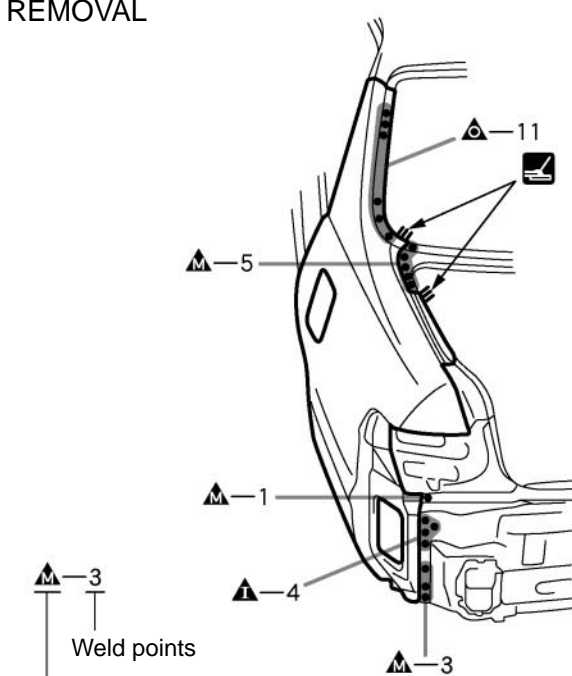
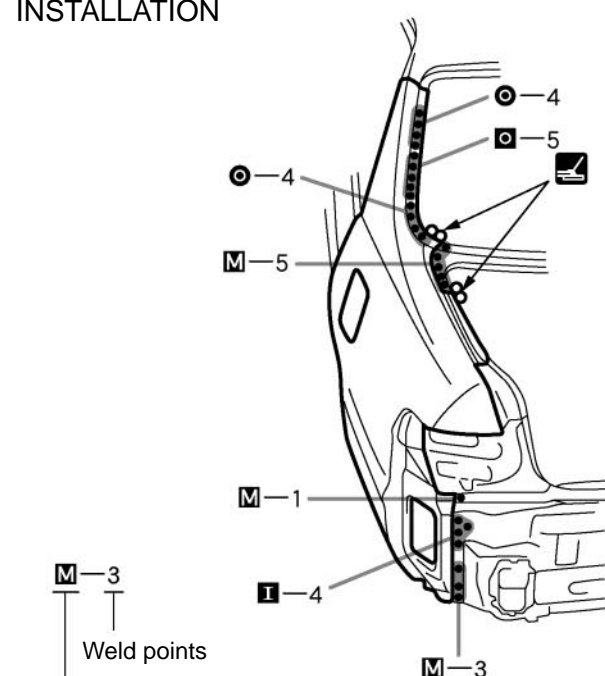



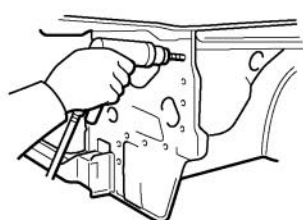



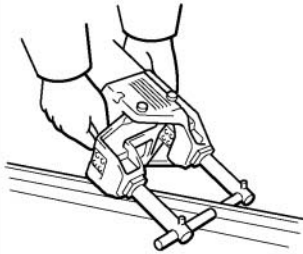

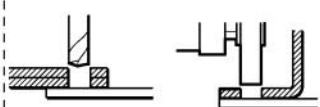



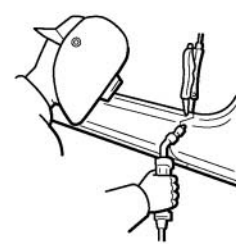

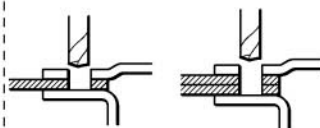

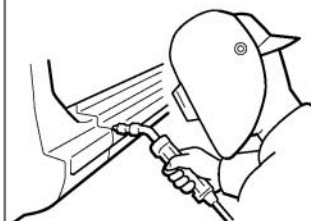


The following symbols are used in the welding diagrams in section BP of this manual to indicate cutting areas and the types of weld required.

SYMBOLS		MEANING	ILLUSTRATION
-----		CUT AND JOIN LOCATION (SAW CUT)	
		CUT AND JOIN LOCATION (Cut Location for Supply Parts)	
		CUT LOCATION	
		CUT WITH DISC SANDER, ETC.	
////		BRAZE (Removal)	
oooo		BRAZE (Installation)	
●●●●●	—	WELD POINTS	
        	—	SPOT WELD OR MIG PLUG WELD (See Page IN-9)	
++++		CONTINUOUS MIG WELD (BUTT WELD)	
		CONTINUOUS MIG WELD (TACK WELD)	
		BODY SEALER	

SYMBOLS		MEANING	ILLUSTRATION
—		Assembly Mark	
	—	BODY SEALER (Flat Finishing)	
—	—	BODY SEALER (No flat Finishing)	

### 3. ILLUSTRATION OF WELD POINT SYMBOLS

#### EXAMPLE:

REMOVAL			INSTALLATION		
 <p>Remove weld point and panel position</p>			 <p>Weld method and panel position</p>		
SYMBOLS	MEANING	ILLUSTRATION	SYMBOLS	MEANING	ILLUSTRATION
  	Remove Weld Points		  	Spot Weld	
	(Outside)		  	MIG Plug Weld	
	(Middle)			Spot MIG Weld	
	(Inside)				
<p><i>HINT: Panel position symbols are as seen from the working posture.</i></p>					