

CENTER PILLAR INSTALLATION [PANEL REPLACEMENT]

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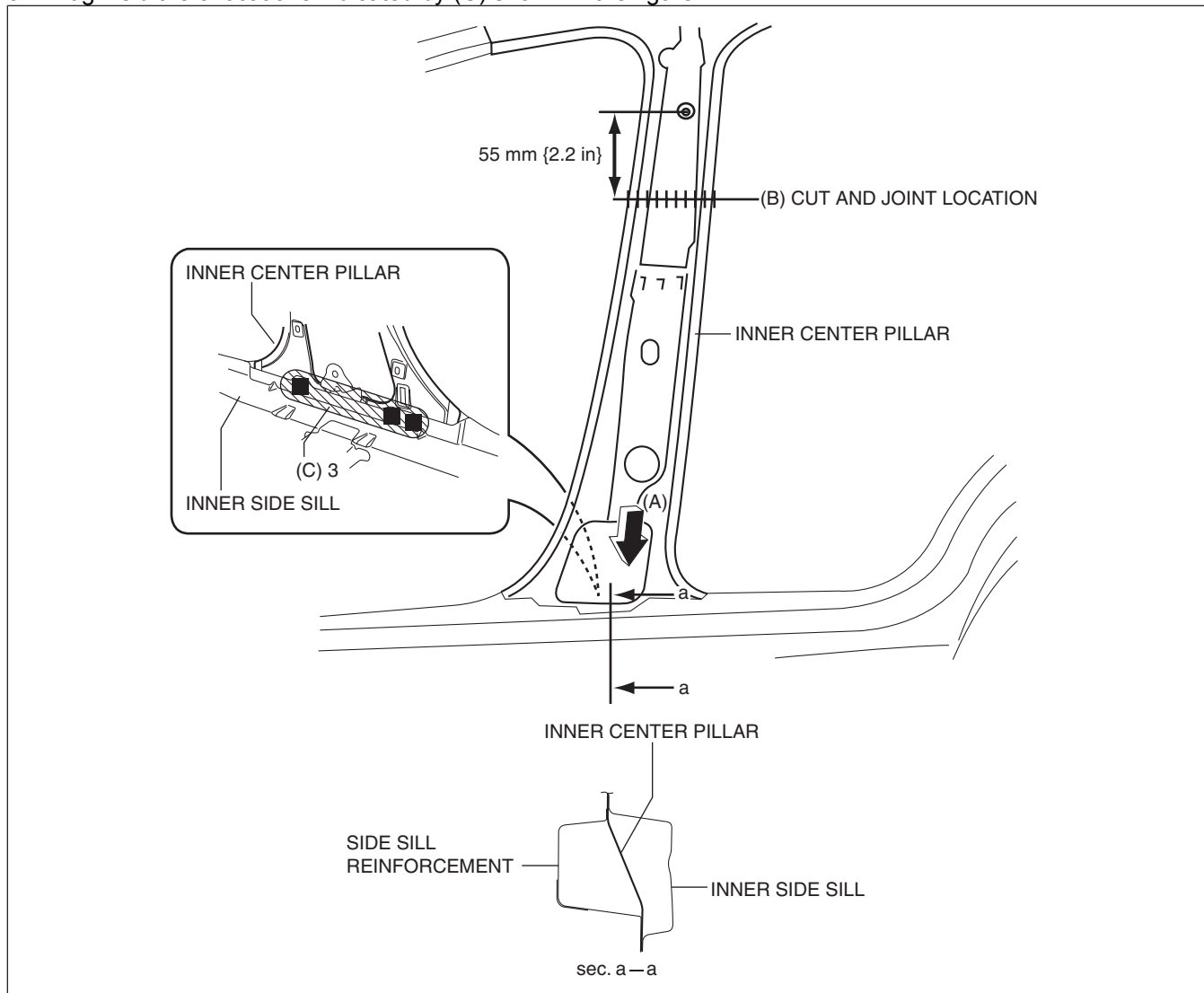
Symbol Mark

SYMBOL MARK	MEANING
■	PLUG WELDING (ARC WELDING)
	CONTINUOUS ARC WELDING (CUT-AND-JOIN LOCATION)

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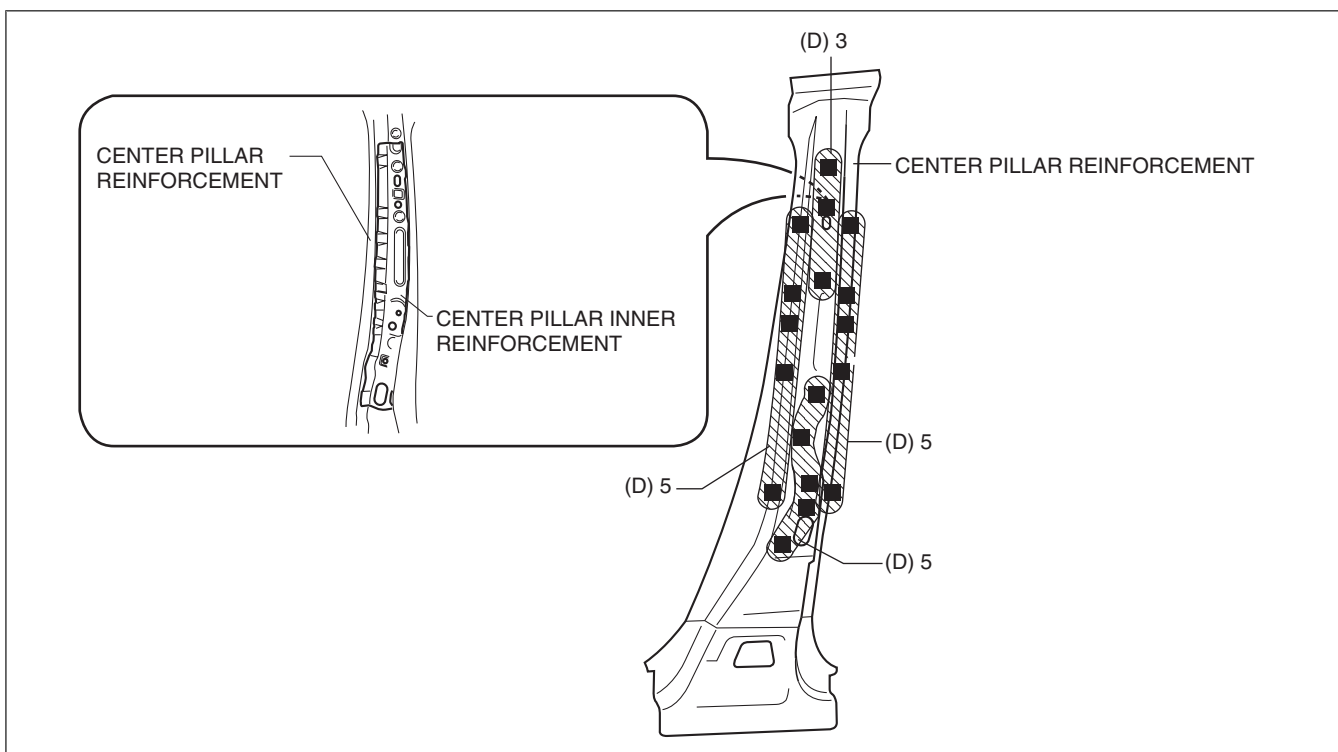
Installation Procedure

1. When installing new parts, measure and adjust the body as necessary to conform with standard dimensions.
2. Drill holes for the plug welding before installing the new parts.
3. After temporarily installing new parts, make sure the related parts fit properly.
4. Insert the end of the inner center pillar locations indicated by (A) shown in the figure, between the inner side sill and side sill reinforcement.
5. Cut and join the area locations indicated by (B) shown in the figure.
6. Plug weld the 3 locations indicated by (C) shown in the figure.



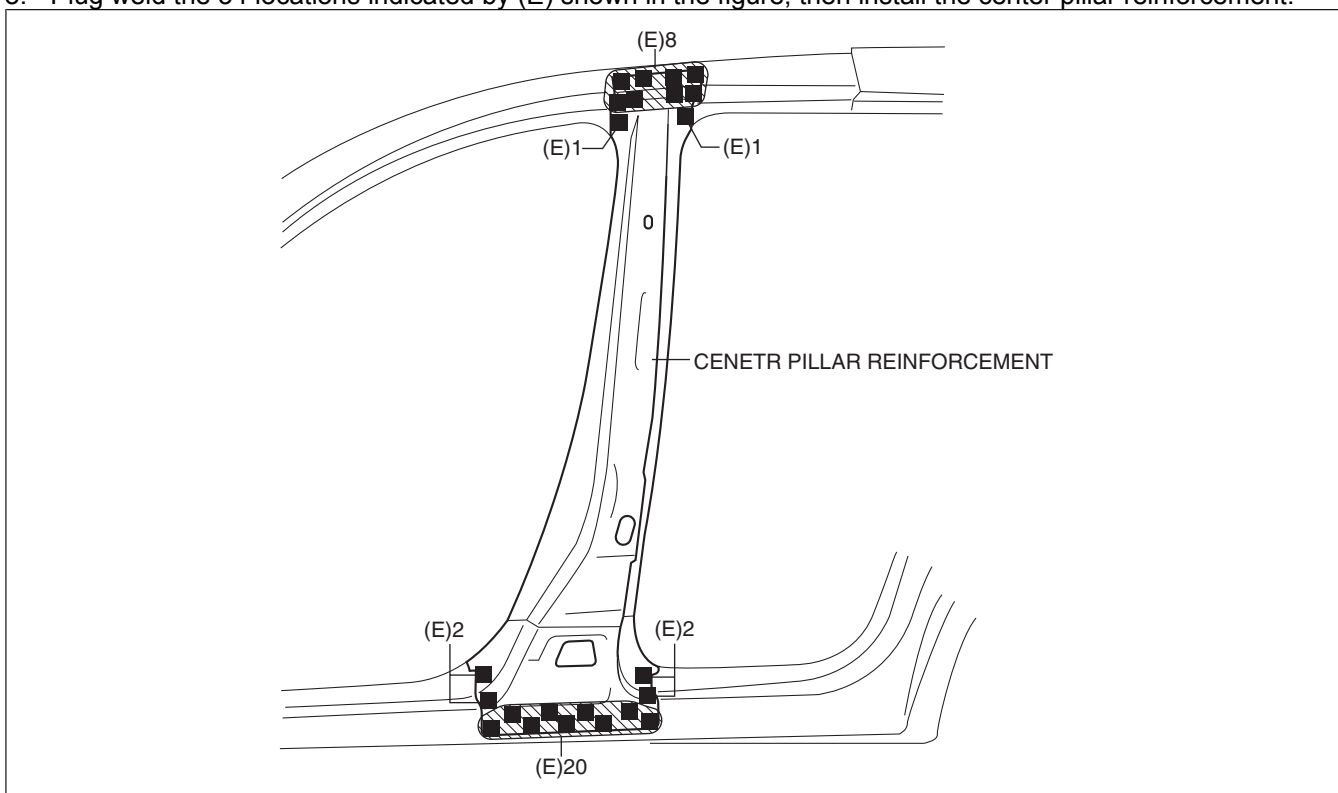
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7. Plug weld the 18 locations indicated by (D) shown in the figure, then install the center pillar inner reinforcement to the center pillar reinforcement.



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8. Plug weld the 34 locations indicated by (E) shown in the figure, then install the center pillar reinforcement.



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9. Cut and join the area locations indicated by (F) shown in the figure.

10. Plug weld the 92 locations indicated by (G) shown in the figure, then install the cabin side outer frame (outer center pillar).

