




## FRONT PILLAR INSTALLATION [PANEL REPLACEMENT]

id098008744800

### Symbol Mark

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

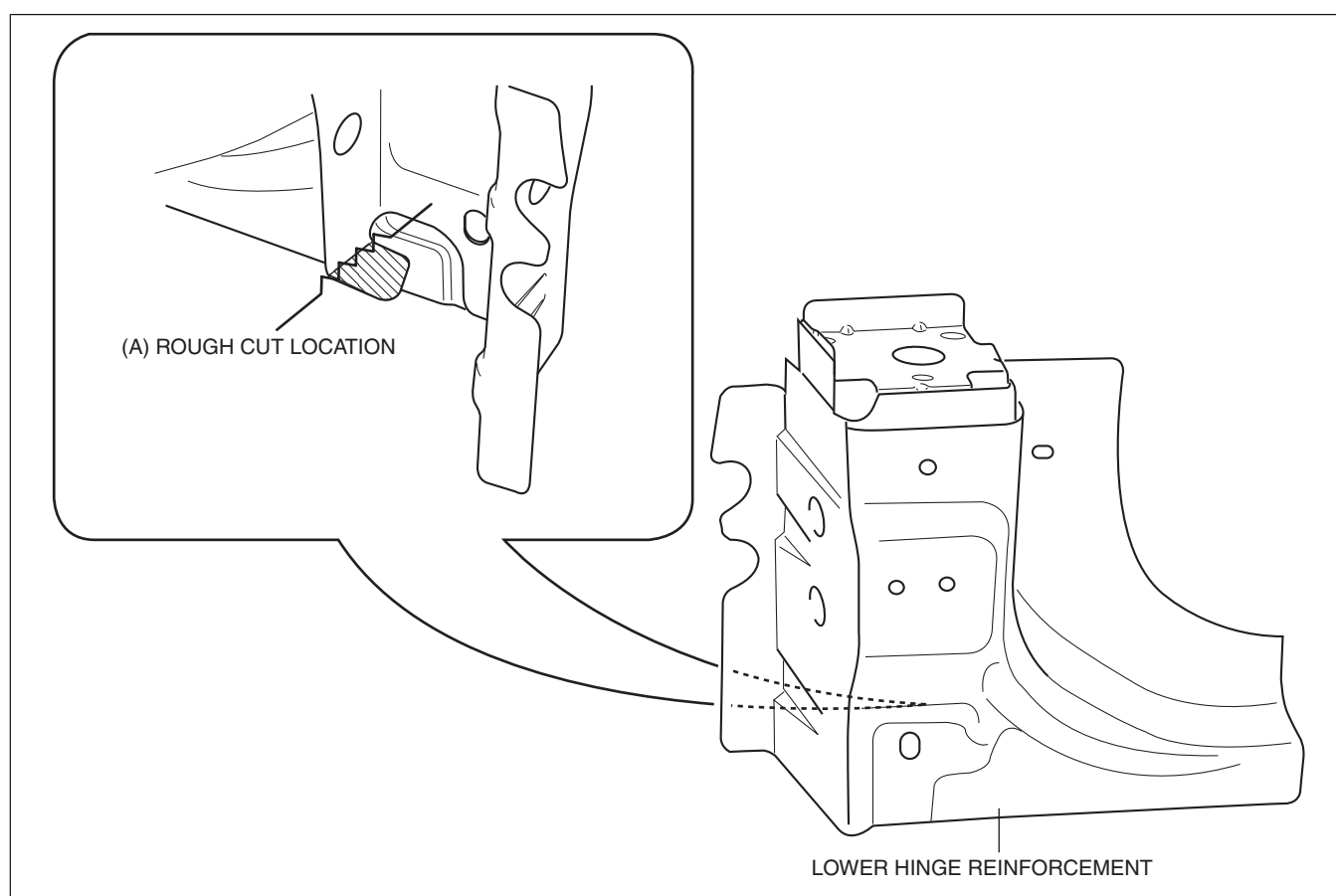
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### Installation Procedure

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. Rough cut the area location indicated by (A) shown in the figure.

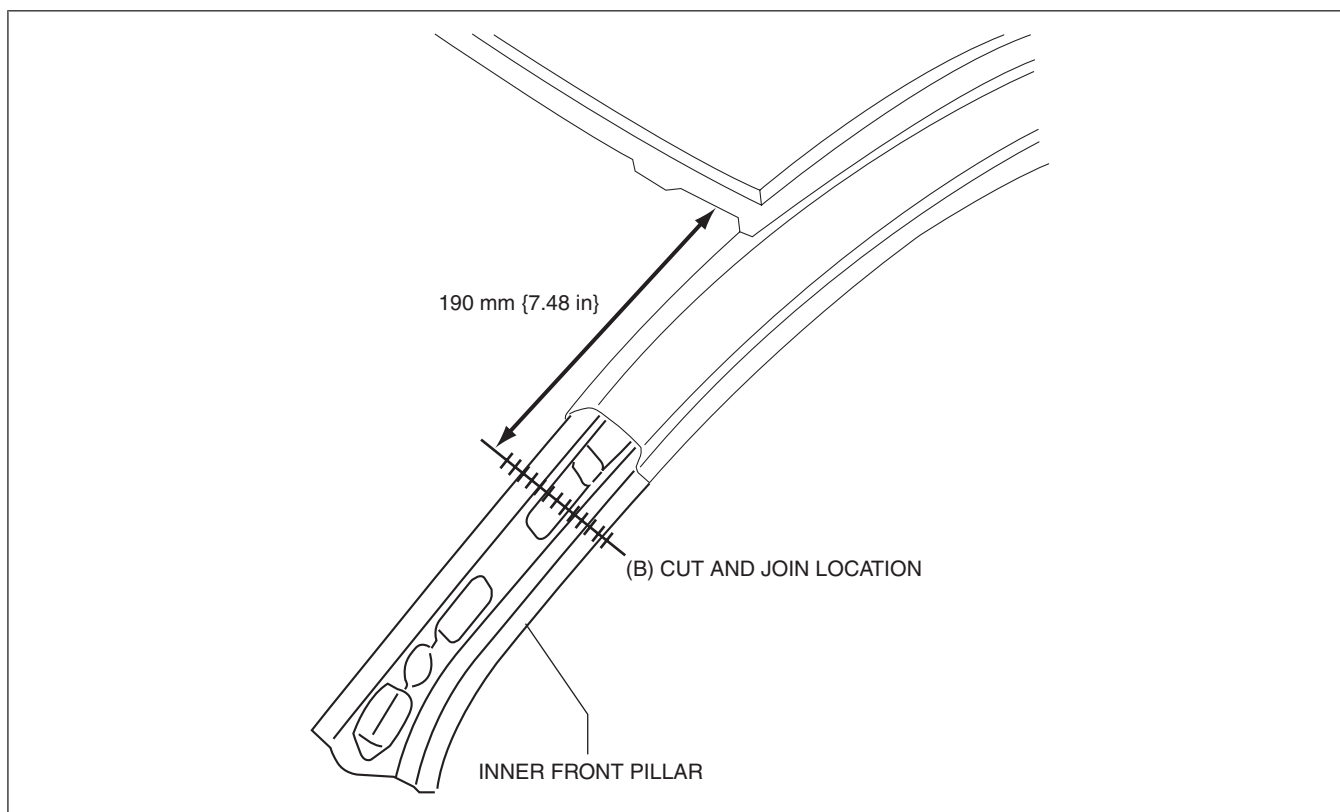
### Caution

- When the part with the rough cut side sill reinforcement, there is a possibility that vibration may occur. After the rough cut, temporarily attach the lower hinge reinforcement and check that the rough cut area does not interfere with the side sill reinforcement.



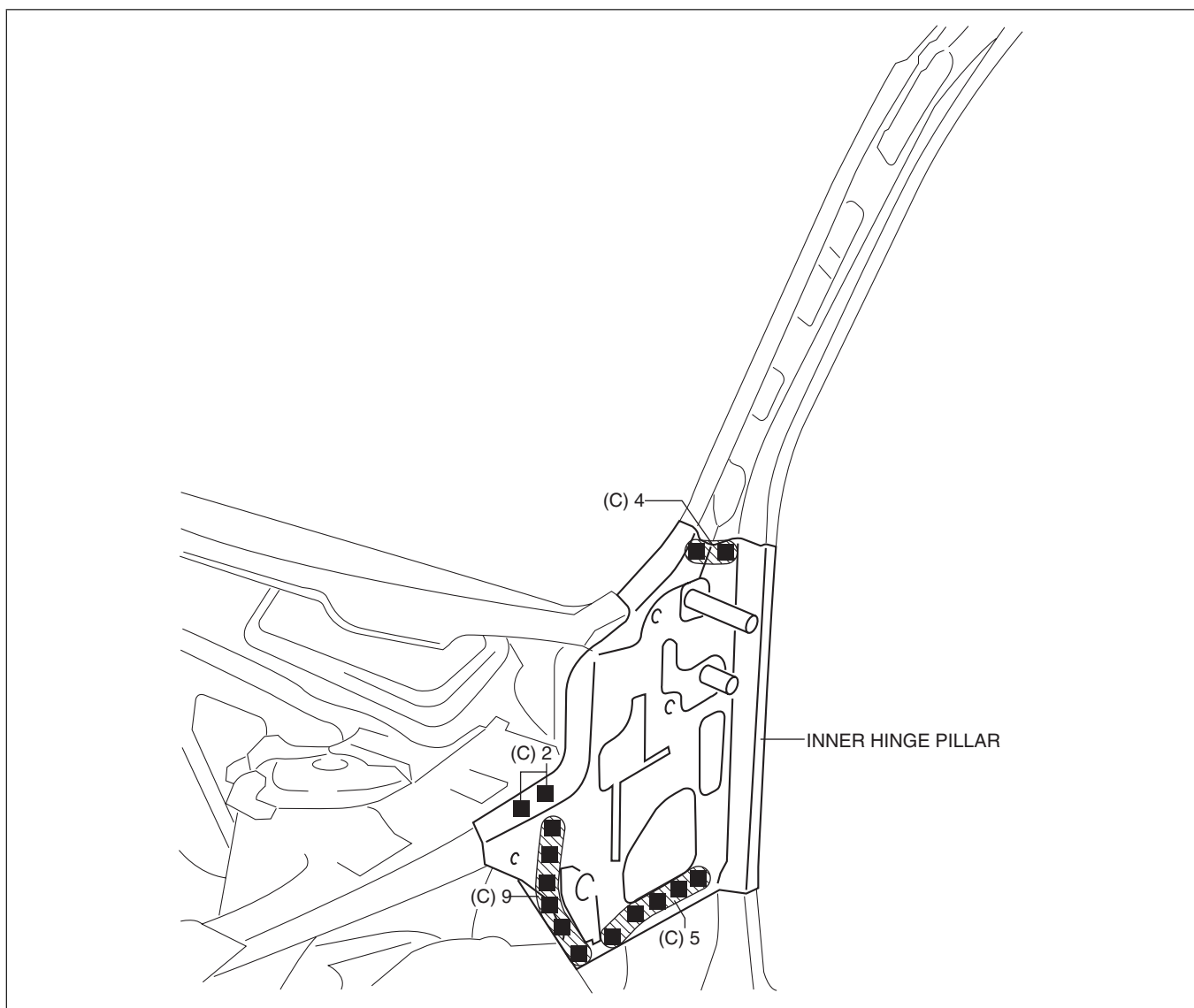
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5. Cut and join the area location indicated by (B) shown in the figure, then install the inner front pillar.



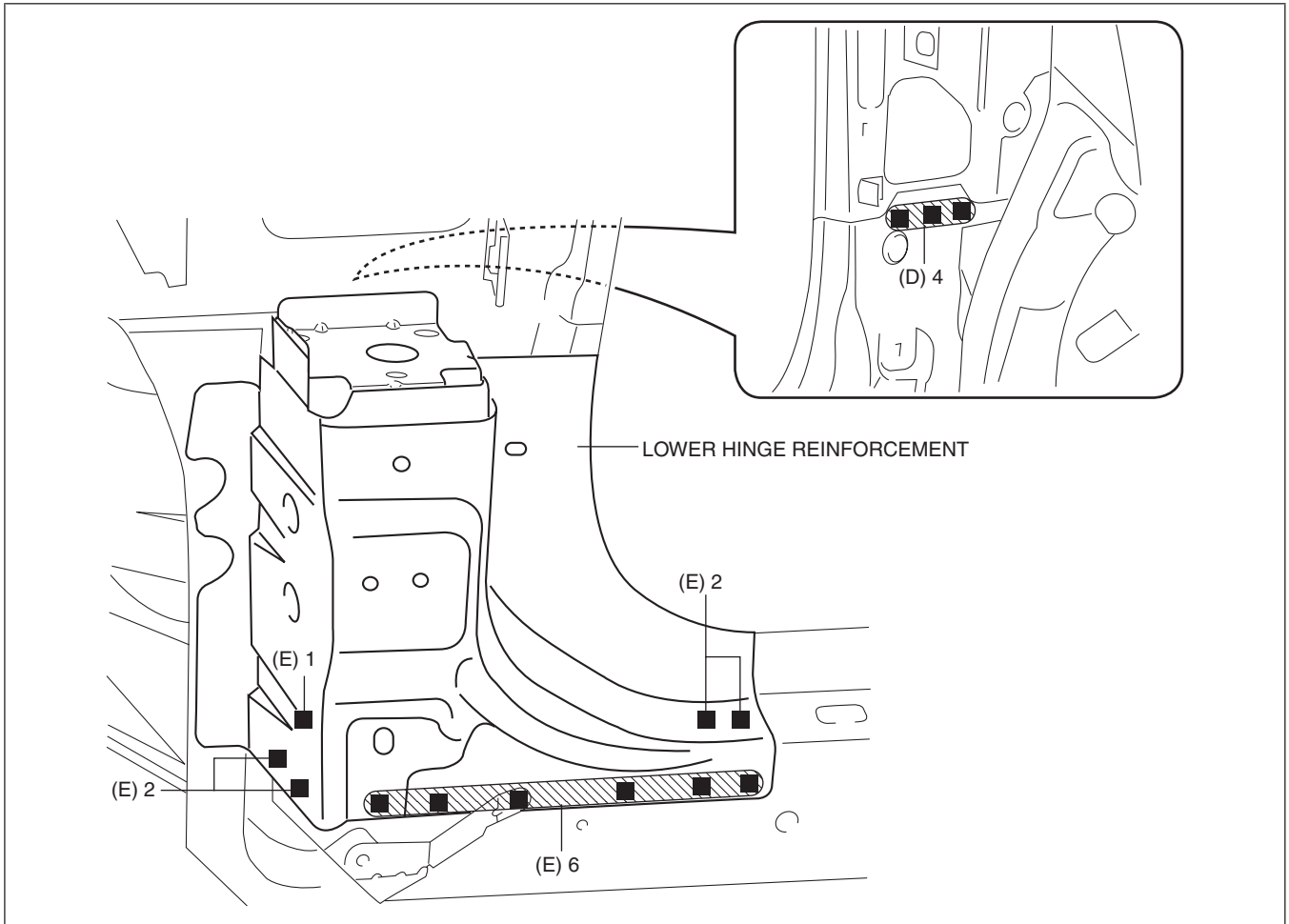
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6. Plug weld the 20 locations indicated by (C) shown in the figure, then install the inner hinge pillar.



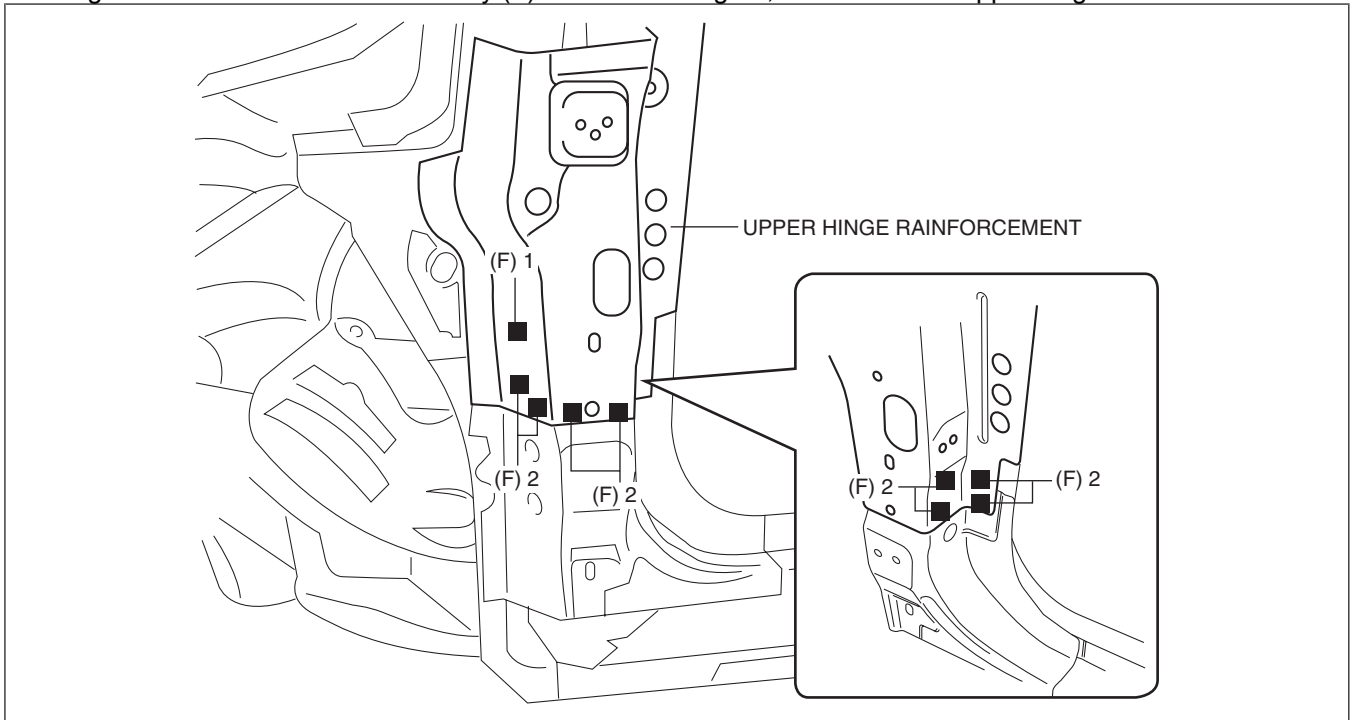
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7. Plug weld the 4 locations indicated by (D) from the inside shown in the figure.
8. Plug weld the 11 locations indicated by (E) shown in the figure, then install the lower hinge reinforcement.



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9. Plug weld the 9 locations indicated by (F) shown in the figure, then install the upper hinge reinforcement.



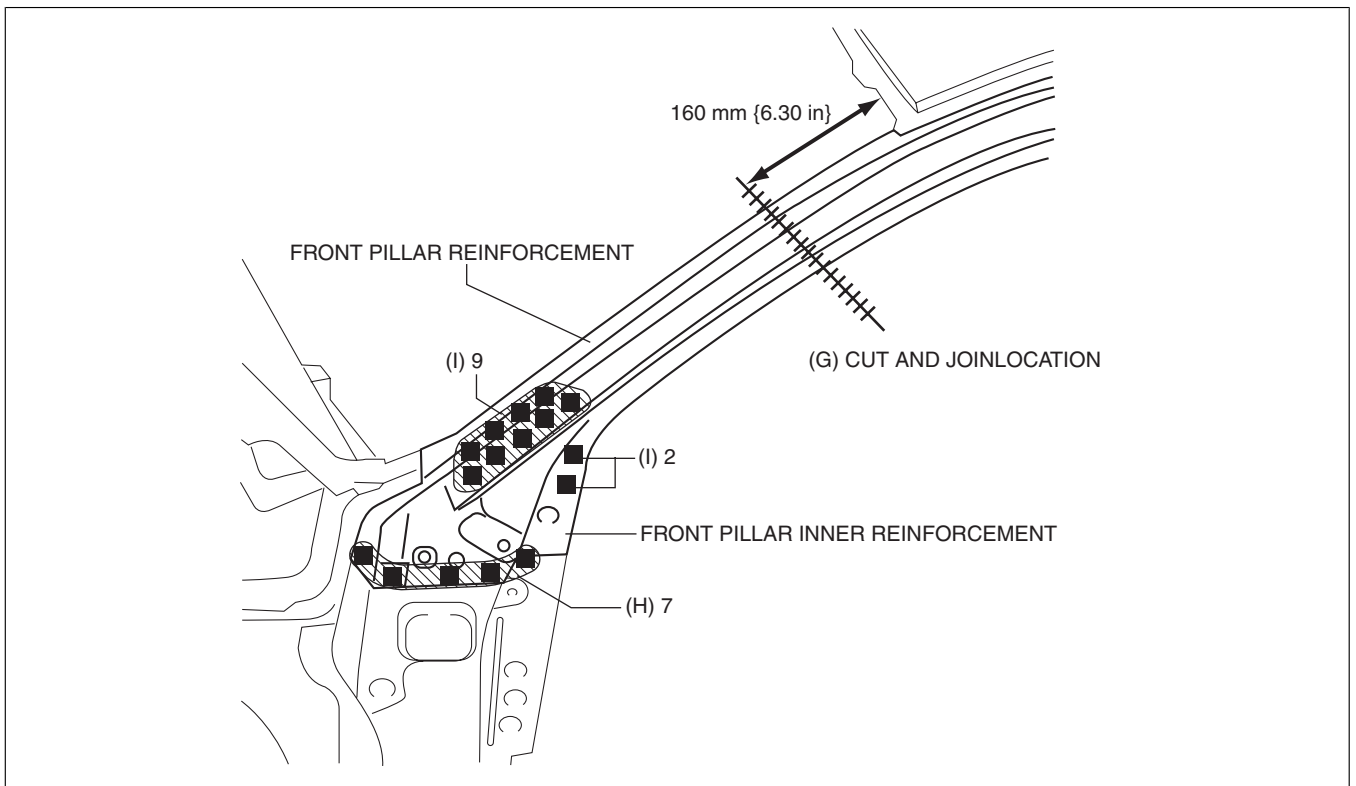
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10. Cut and join the area location indicated by (G) shown in the figure.

11. Plug weld the 7 locations indicated by (H) shown in the figure, then install the front pillar reinforcement and front pillar inner reinforcement as a single unit.

**Note**

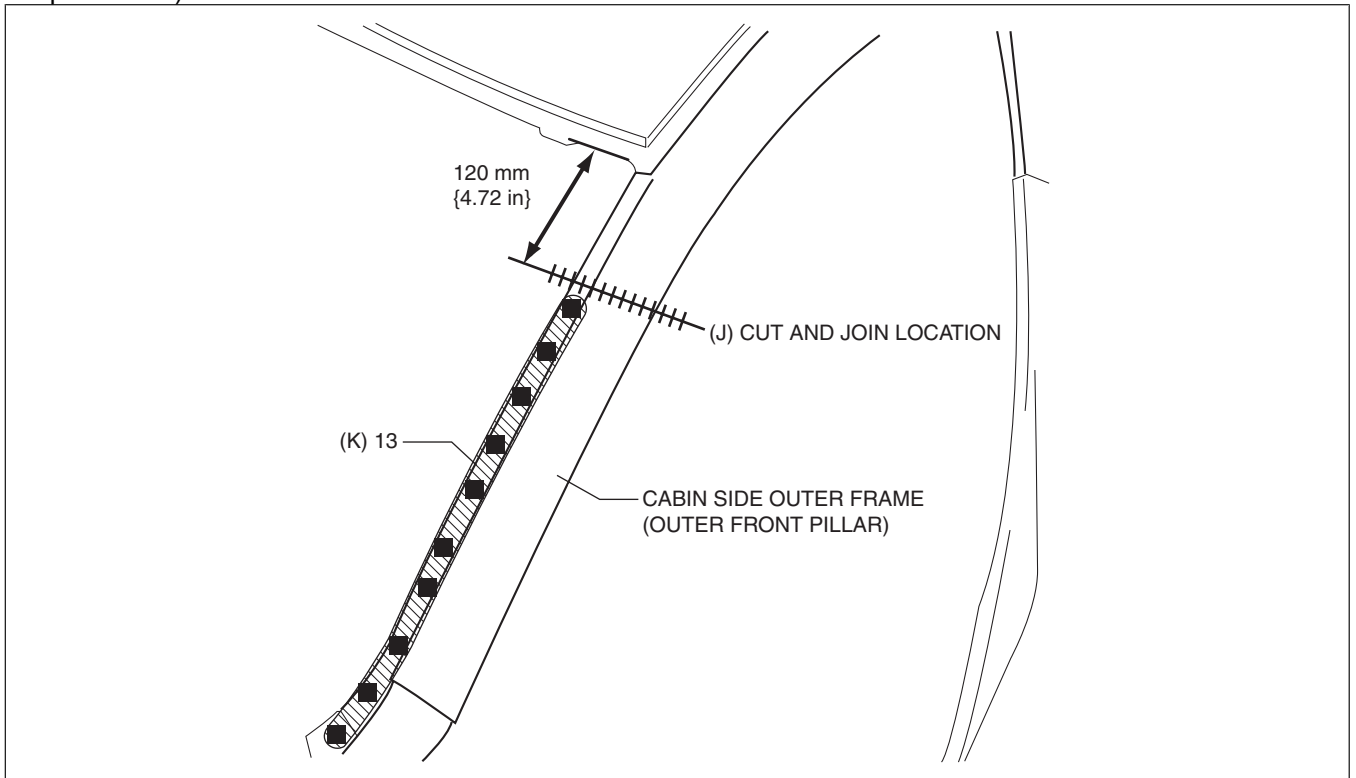
- When installing the front pillar reinforcement and the front pillar inner reinforcement separately, plug weld the 11 locations indicated by (I) shown in the figure.



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12. Cut and join the 2 locations indicated by (J) shown in the figure.

13. Plug weld the 86 locations indicated by (K) shown in the figure, then install the cabin side outer frame (outer front pillar outer).



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