INSTALLATION PREPARATIONS

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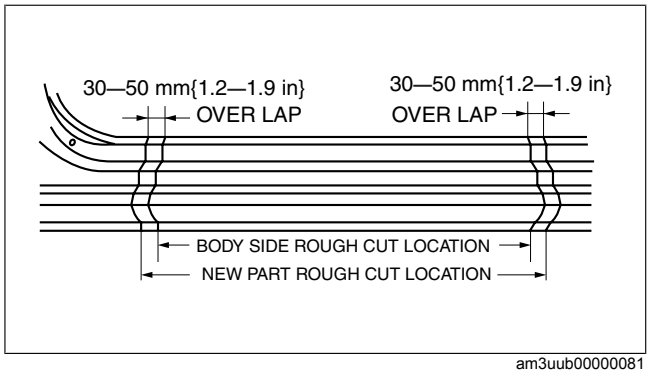
Rough Cutting of New Parts

- For cut-and-join areas, allow for an overlap of 30—50 mm {1.2—1.9 in} with the remaining area on the body side and then rough-cut the new parts.



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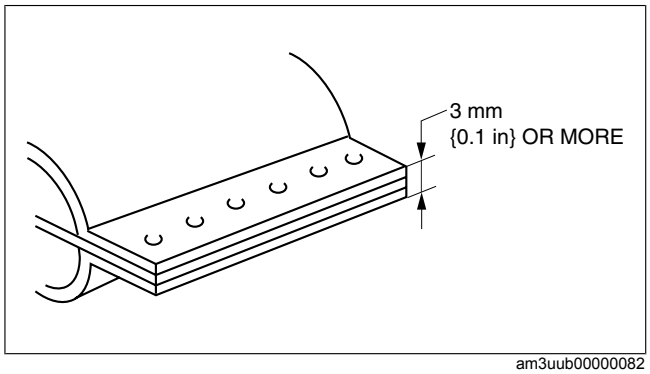
Determination of Welding Method

- If the total thickness at the area to be welded is 3 mm {0.12 in} or more, use a gas shielded-arc welder to make the plug welds.



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Making Holes for Arc Welding

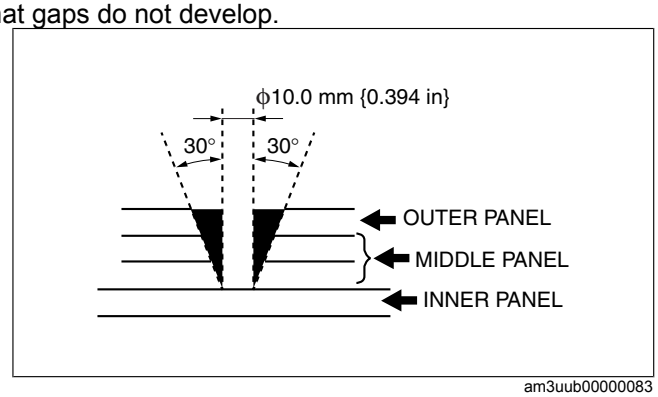
- For places that cannot be spot welded, make a hole for arc welding using a punch or drill as follows.

(mm {in})

Panel thickness (φ)	Hole diameter (φ)
0.60—0.90 {0.024—0.035}	5.0 {0.20}
0.91—1.20 {0.036—0.047}	6.0 {0.24}
1.21—1.80 {0.0477—0.0708}	8.0 {0.31}

Panel thickness (φ)	Hole diameter (φ)
1.81—4.50 {0.072—0.177}	10.0 {0.394}

- Grind the shaded section indicated in the diagram below and create a hole in the part where the 3—4 plates are put together. Also, weld the plates together tightly so that gaps do not develop.



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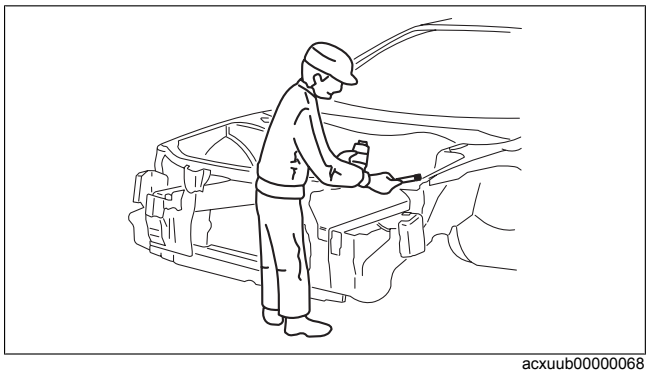
Application of Weld-through Primer

- For treatment against corrosion, remove the paint grease, and other material from the portion of new part and body to be welded, and apply weld-through primer.



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