




FRONT SIDE FRAME (PARTIAL CUTTING) INSTALLATION [PANEL REPLACEMENT]

id098008742200

Symbol Mark

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

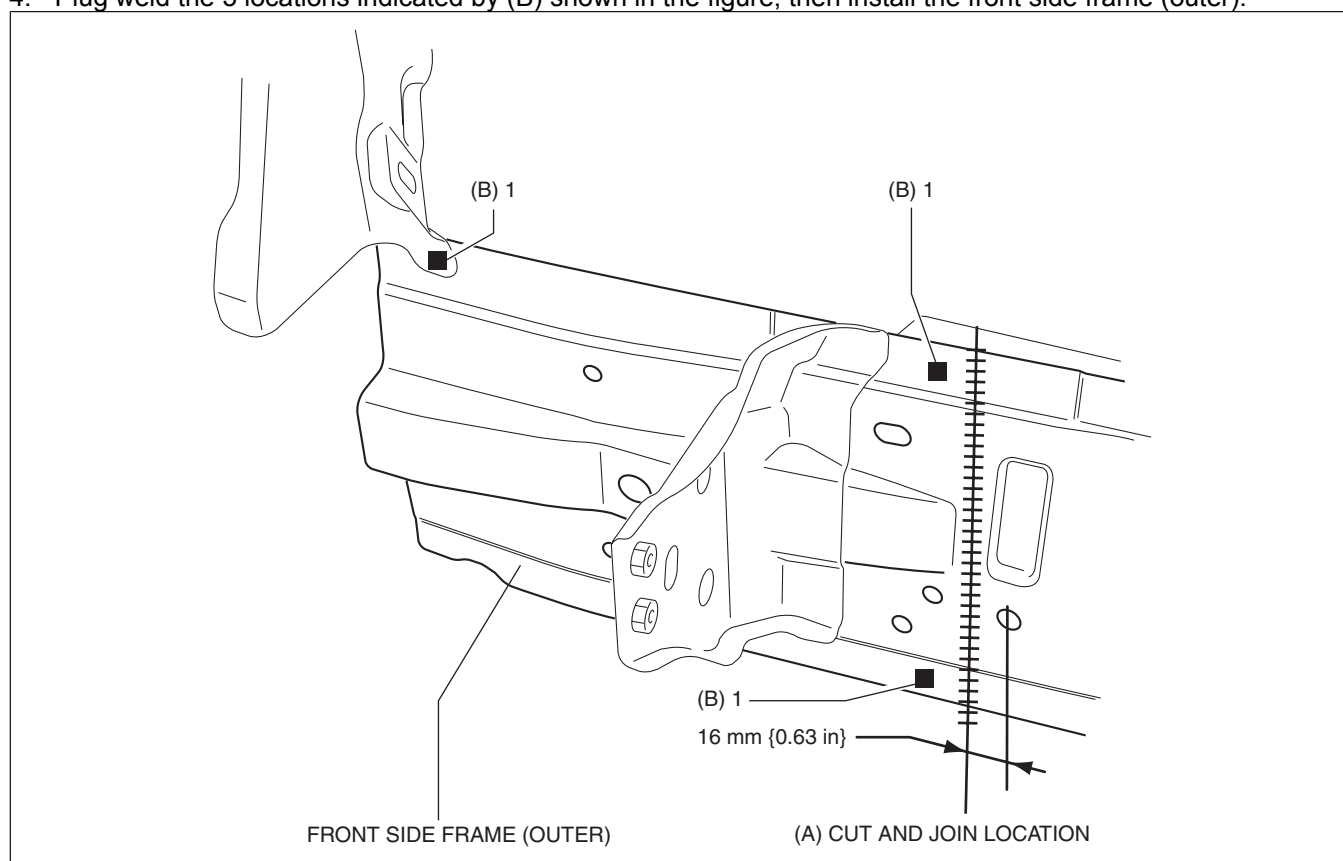
ac5jjb00000066

Installation Procedure

Caution

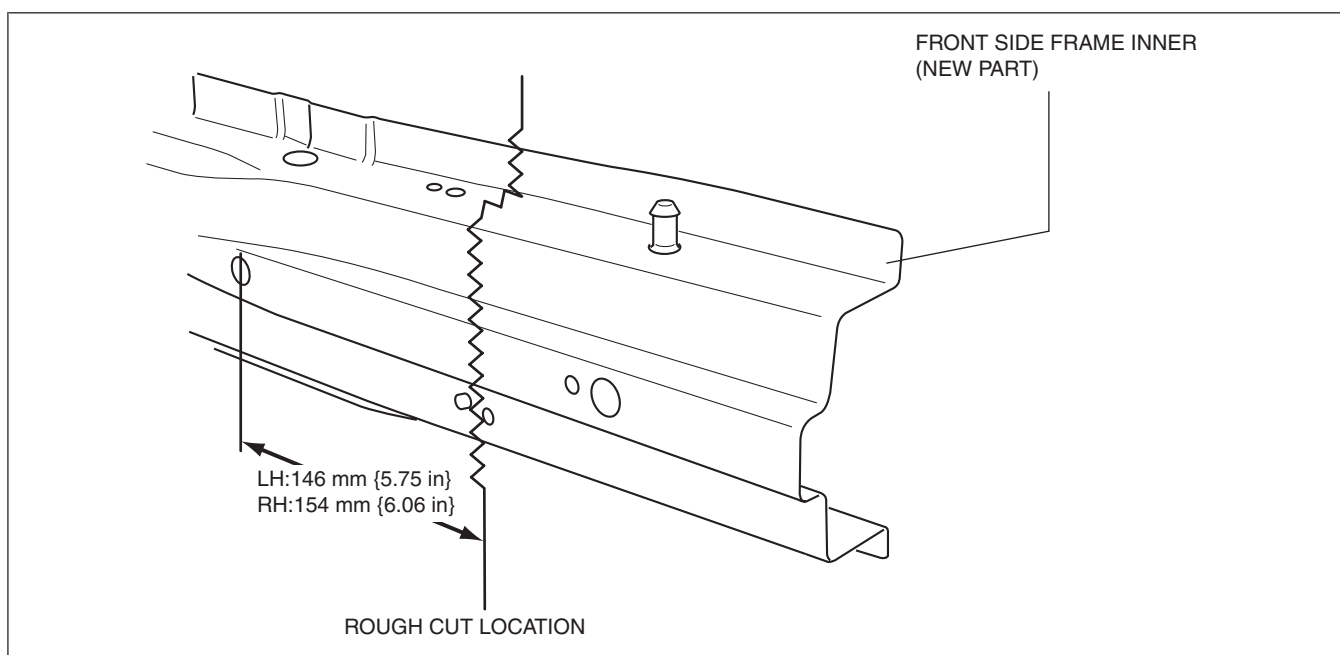
- The cut and joint area indicates the maximum size range of the installation position.

- Drill holes for the plug welding before installing the new parts.
- When installing the new parts, trial-fit new and existing parts, and then measure and adjust the body to conform with standard dimensions.
- Cut and join location indicated by (A) shown in the figure.
- Plug weld the 3 locations indicated by (B) shown in the figure, then install the front side frame (outer).



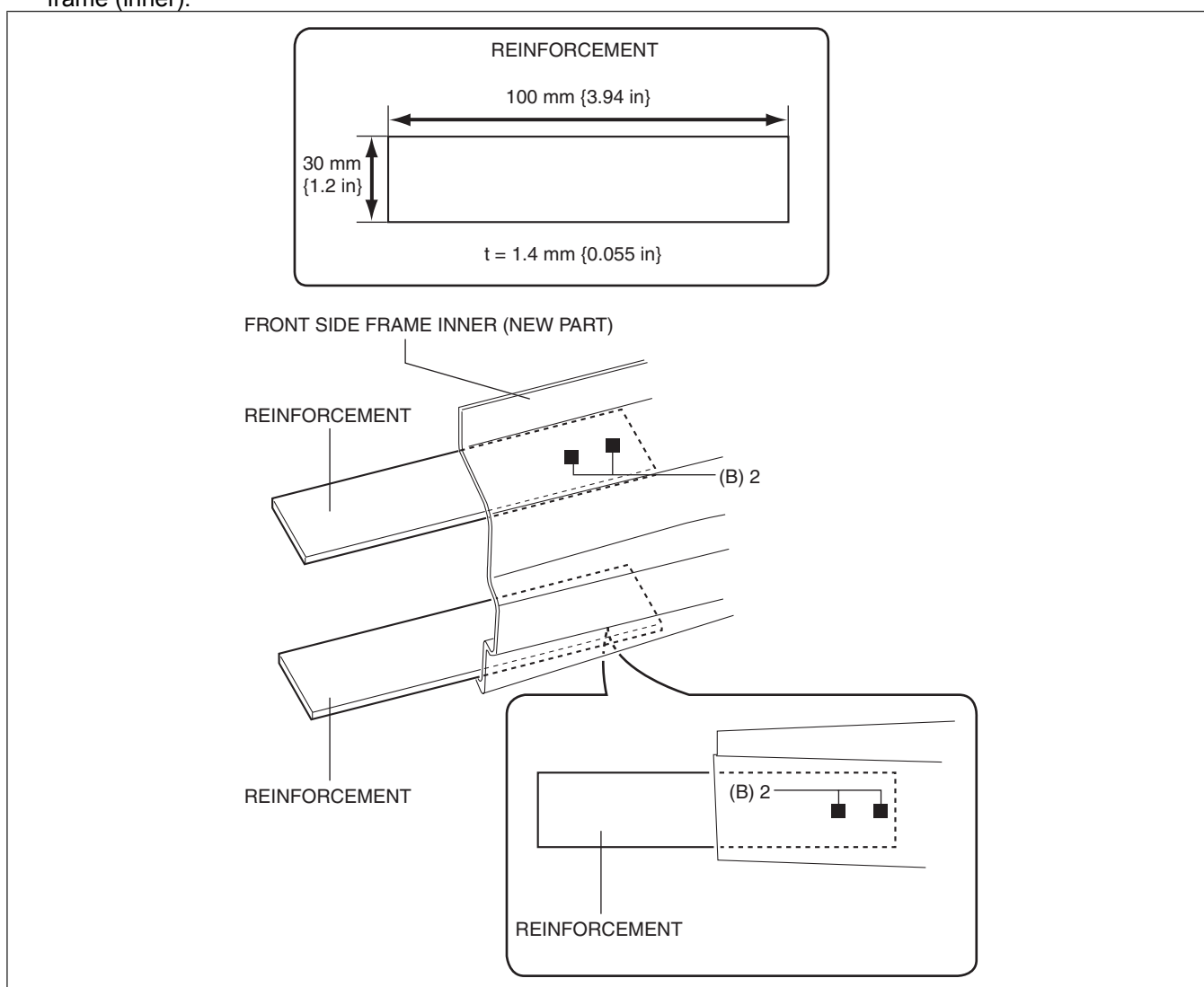
ac5wzb000000274

- To cut and join the new and existing parts, rough cut the new part at the specified location shown in the figure, and chamfer the joint surfaces of the new and existing parts.



ac5wzb00000237

6. Make a reinforcement panel using the material from the front side frame (inner).
7. Plug weld the 4 locations indicated by (B) shown in the figure, then install the reinforcement to the new front side frame (inner).



ac5wzb00000238

8. Plug weld the 3 locations indicated by (C) shown in the figure.

Note

- Press fit the reinforcement panel and the body side material, and then weld them.

9. Cut and location indicated by (D) shown in the figure.
10. Plug weld the 6 locations indicated by (E) shown in the figure, then install the front side frame inner.
11. Plug weld the 5 locations indicated by (F) shown in the figure, then install suspension mounting reinforcement and outer frame reinforcement.

