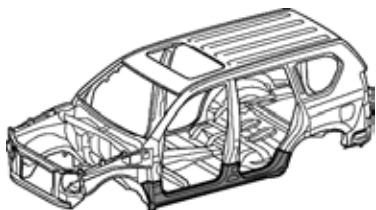


## ROCKER OUTER PANEL (ASSY)



F43878A

Weld work for 980 MPa ultra high strength steel

### 1 Follow the welding conditions below when welding ultra high strength steel to assure sufficient weld strength. (When repairing this model)

\*1: When welding 2 panels together including 980 MPa ultra high strength steel.

Spot weld	Pressure	2940 N (300 kgf, 661 lbf)
	Weld current	10000 A
	Weld time	18 Cyc. (0.30 Sec.)
Plug weld	Plug diameter	10 mm (0.39 in.)
	Wire type	AWS A5.18 ER70S-3
	Shield gas	Metal active gas

\*2: When welding more than 3 panels together including 980 MPa ultra high strength steel. (When plug welding a panel to the welded panels with the weld condition above.)

Plug weld	Plug diameter	Same as the standard method (See the introduction)
	Wire type	AWS A5.18 ER70S-3
	Shield gas	Metal active gas

#### HINT:

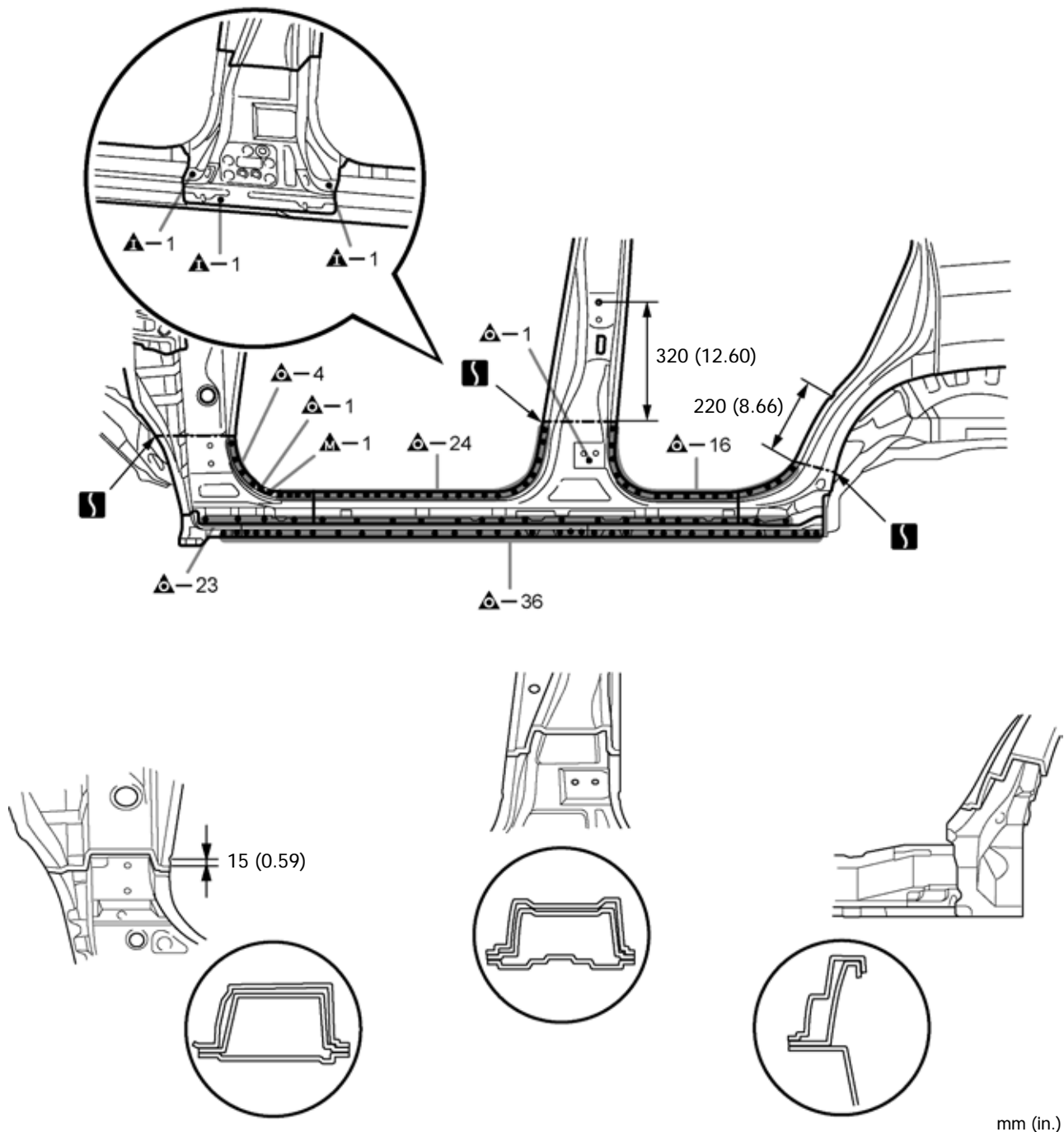
Be sure to use Metal active gas (Ar 80% + CO<sub>2</sub> 20%) as the shield gas when plug welding. Sufficient weld strength cannot be assured when using 100% CO<sub>2</sub> shield gas.

Symbol meaning

△ △ △ : Remove Weld Points     : Cut with Disc Sander etc.     : Cut and Join Location

F43261B

REMOVAL





mm (in.)

F43261

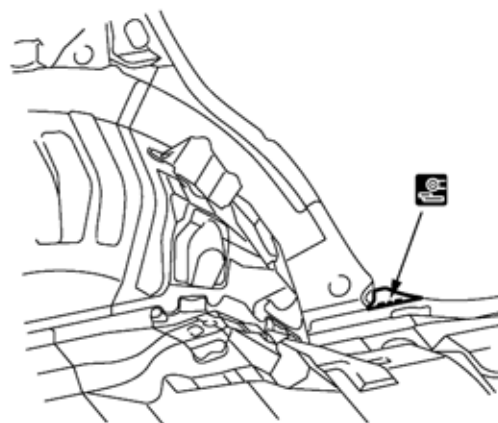
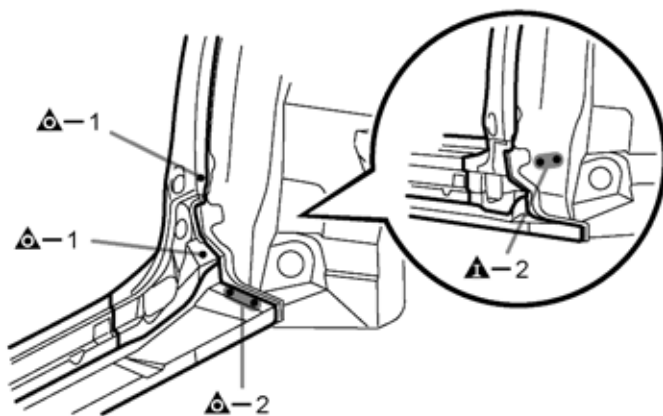
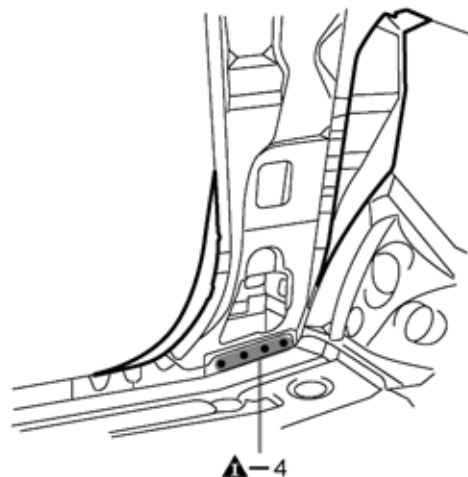
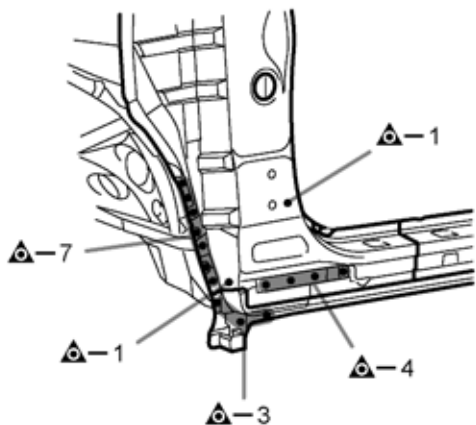
REMOVAL POINT

- 1 Do not butt weld or heat repair because the heat decreases the strength of areas where ultra high strength steel is used. (See the introduction)

## Symbol meaning

△ △ △ : Remove Weld Points     : Cut with Disc Sander etc.     : Cut and Join Location

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F43262

## REMOVAL POINT

- 1 Do not butt weld or heat repair because the heat decreases the strength of areas where ultra high strength steel is used. (See the introduction)

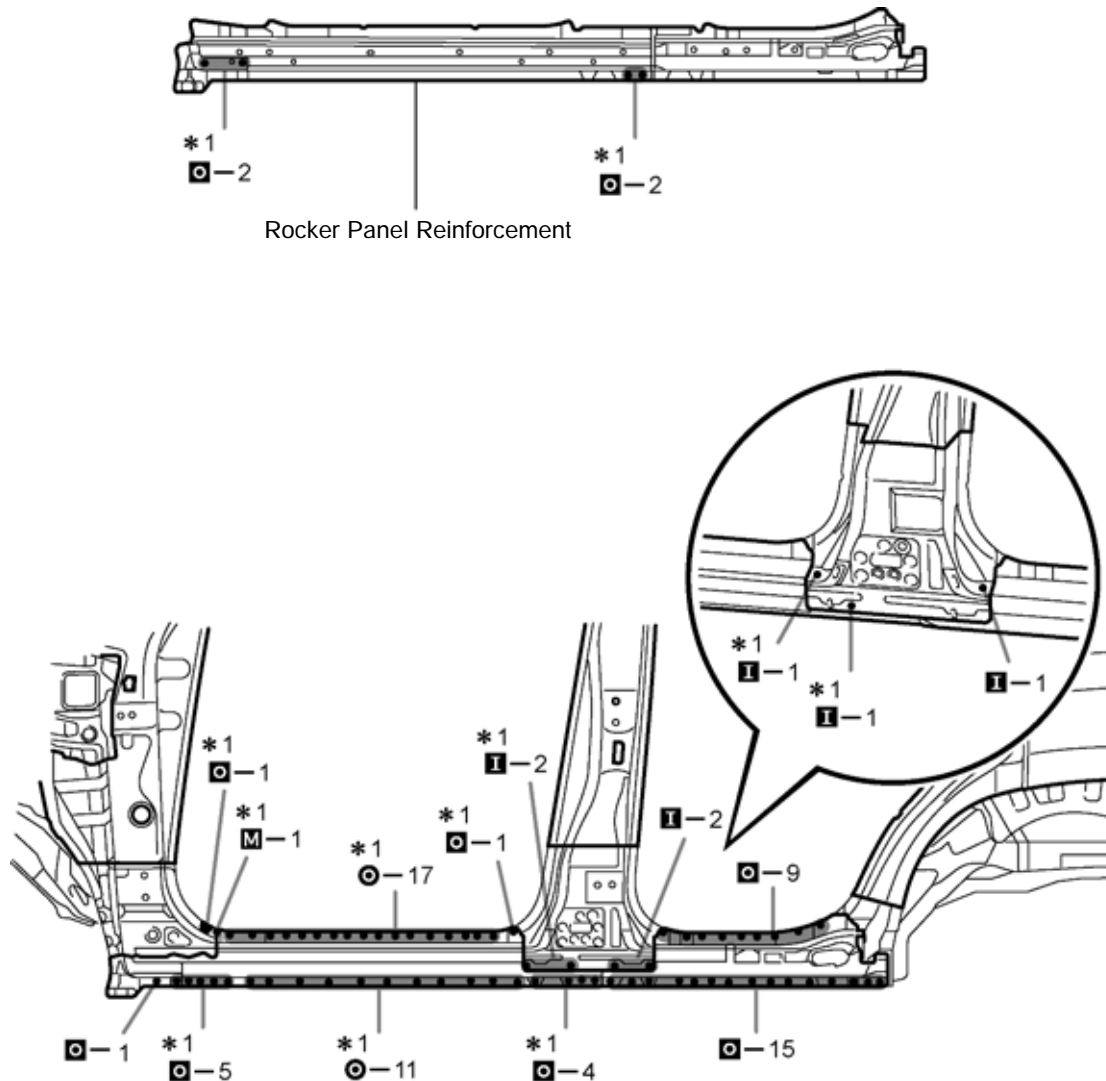
## Symbol meaning

○ : Spot Weld    ◻ M I : Plug Weld     : Fillet Weld

 : Butt Weld     : Body Sealer

F43263B

## INSTALLATION




F43263

## INSTALLATION POINT

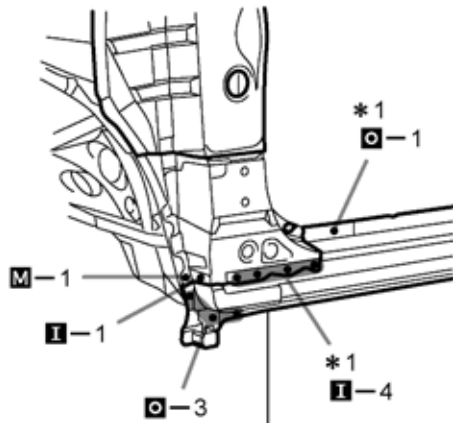
- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 Follow the welding conditions when welding point \*1 to assure sufficient weld strength. (See the introduction)
- 4 After welding the rocker panel reinforcement to the vehicle side, install the front body upper outer pillar, center body outer pillar and quarter panel.

## Symbol meaning

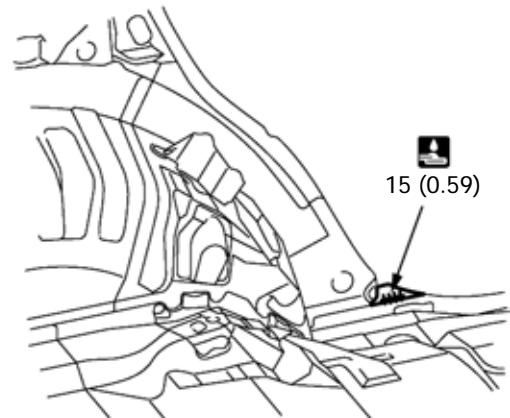
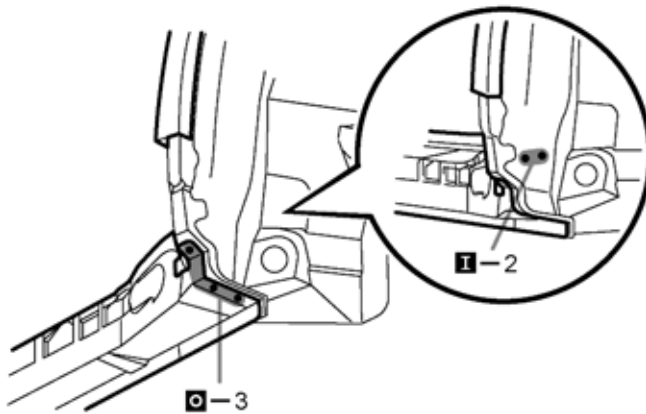
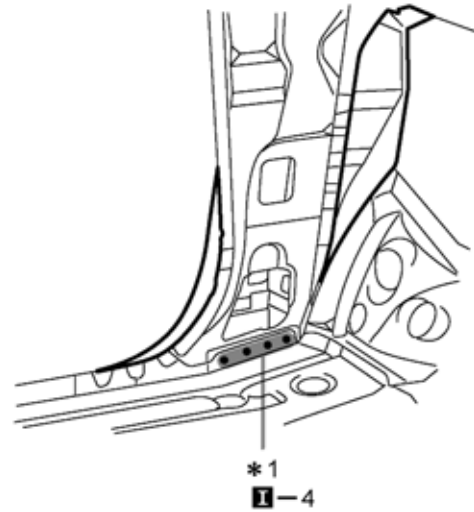
⊙ : Spot Weld    ⊙ M I : Plug Weld     : Fillet Weld

 : Butt Weld     : Body Sealer

F43263B



Rocker Panel Reinforcement

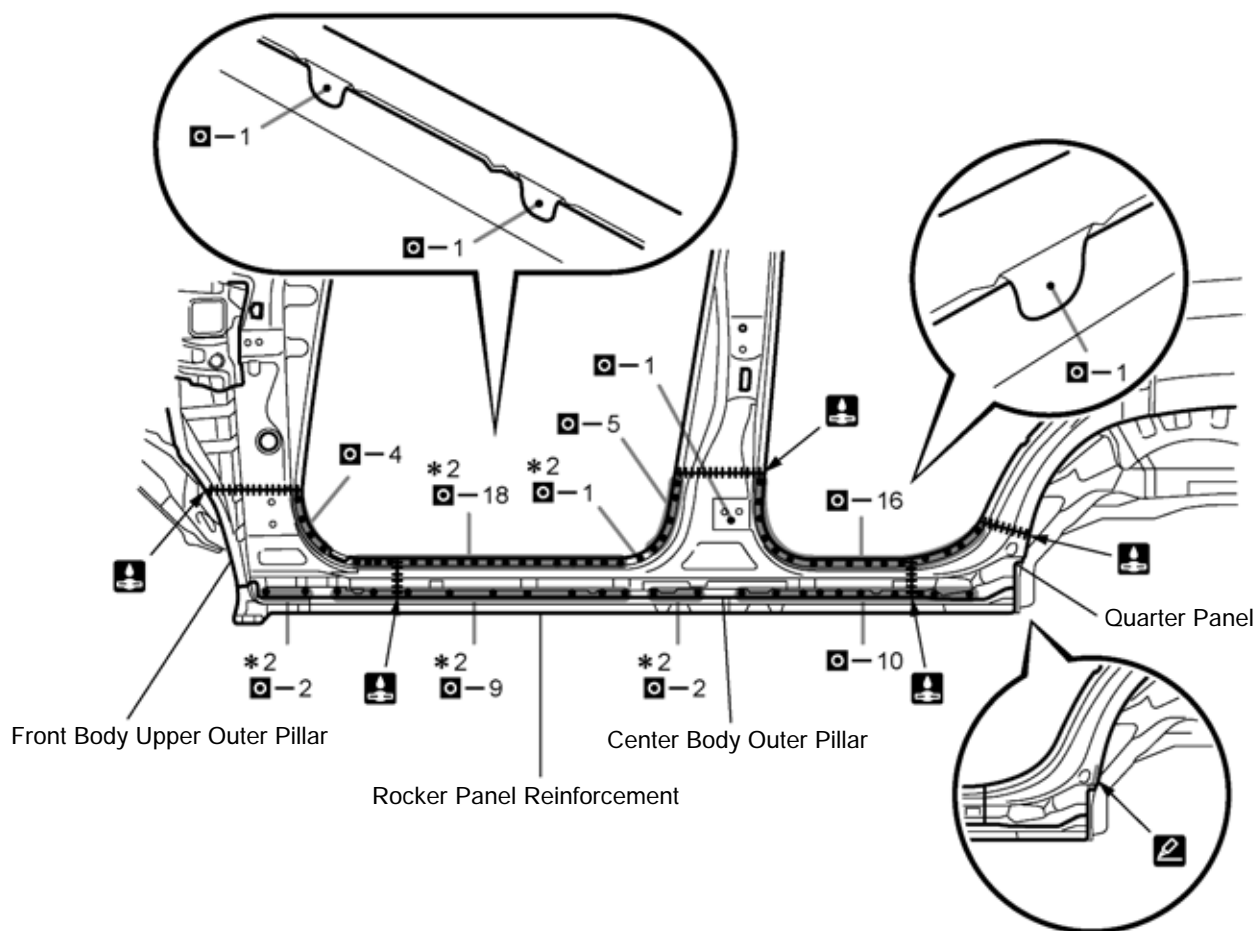


mm (in.)

F43264

## INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 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)
- 3 Follow the welding conditions when welding point \*1 to assure sufficient weld strength. (See the introduction)
- 4 After welding the rocker panel reinforcement to the vehicle side, install the front body upper outer pillar, center body outer pillar and quarter panel.



F43265


**INSTALLATION POINT**

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 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)
- 3 Follow the welding conditions when welding point \*2 to assure sufficient weld strength. (See the introduction)
- 4 After welding the rocker panel reinforcement to the vehicle side, install the front body upper outer pillar, center body outer pillar and quarter panel.
- 5 Before installing a new part, apply body sealer.

**HINT:**

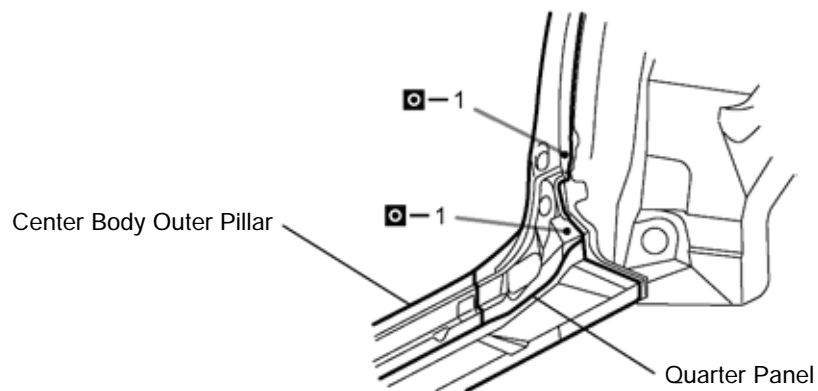
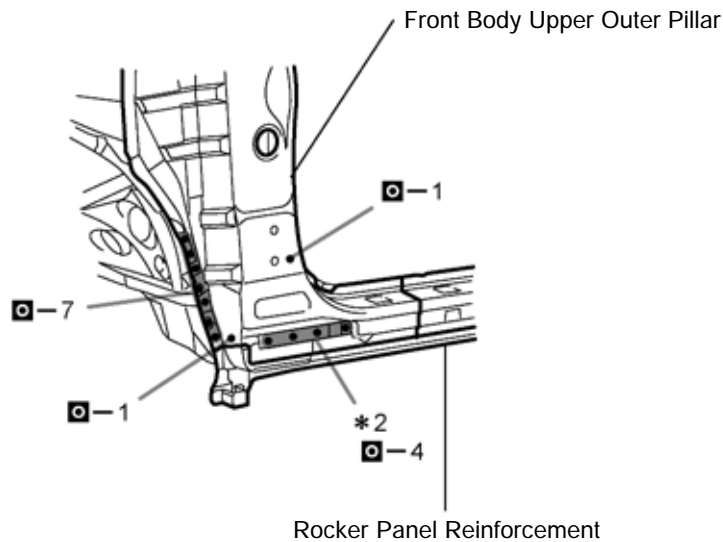
Apply body sealer in an even, continuous bead.

## Symbol meaning

⊙ : Spot Weld    ⊙ M I : Plug Weld     : Fillet Weld

 : Butt Weld     : Body Sealer

F43263B



F43266

**INSTALLATION POINT**

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 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)
- 3 Follow the welding conditions when welding point \*2 to assure sufficient weld strength. (See the introduction)
- 4 After welding the rocker panel reinforcement to the vehicle side, install the front body upper outer pillar, center body outer pillar and quarter panel.
- 5 After welding, apply the foamed sealing material to the corresponding parts. (See the paint coating)
- 6 After welding, apply body sealer to the corresponding parts. (See the paint coating)
- 7 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.