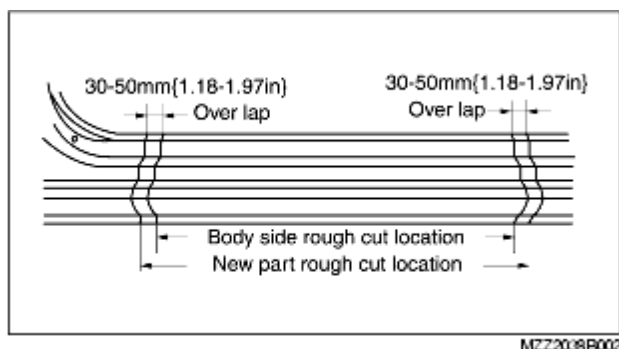


INSTALLATION PREPARATIONS

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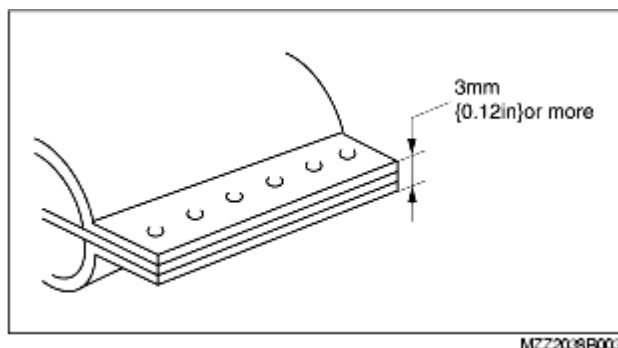
Rough Cutting of New Parts

- For cut-and-join areas, allow for an overlap of 30-50 mm {1.18-1.97 in} with the remaining area on the body side and then rough-cut the new parts.



Determination of Welding Method

- If the total thickness at the area to be welded is 3 mm {0.12 in} or more, use a CO₂ gas shielded-arc welder to make the plug welds.



Making Holes for CO2 Arc Welding

- For places that cannot be spot welded, make a hole for CO₂ arc welding using a punch or drill as follows.

(mm {in})

Panel thickness (ø)	Hole diameter (ø)
0.60-0.90 {0.02-0.03}	5 {0.19}
0.91-1.20 {0.04-0.05}	6 {0.23}
1.21-1.80 {0.051-0.07}	8 {0.31}
1.81-4.50 {0.071-0.17}	10 {0.39}

- 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.

- 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.

