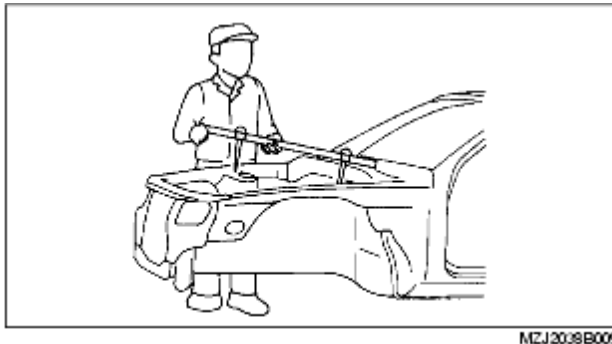


EFFICIENT INSTALLATION OF BODY PANELS

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Checking Preweld Measurements And Watching

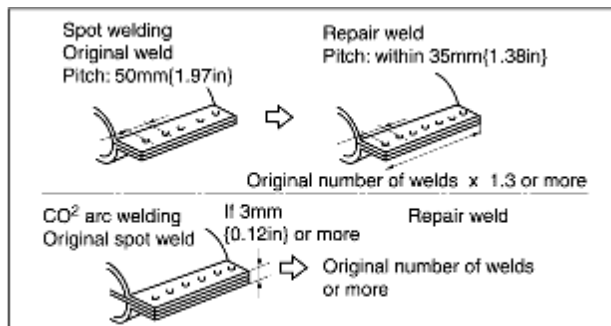
- Align to the standard reference dimensions, based upon the body dimensions illustration, so that new parts are installed in the correct position.



MZJ30:9B009

Welding Notes

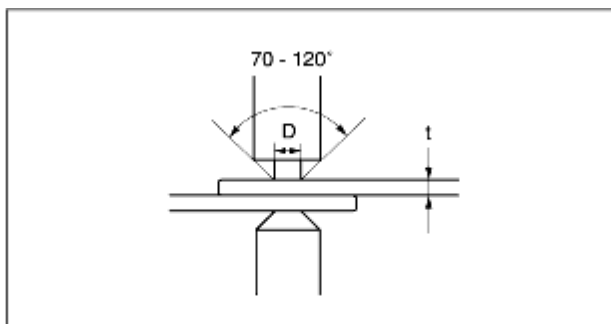
- For the number of weld points, welding should be performed in accordance with the following reference standards.



MZZ20:9B005

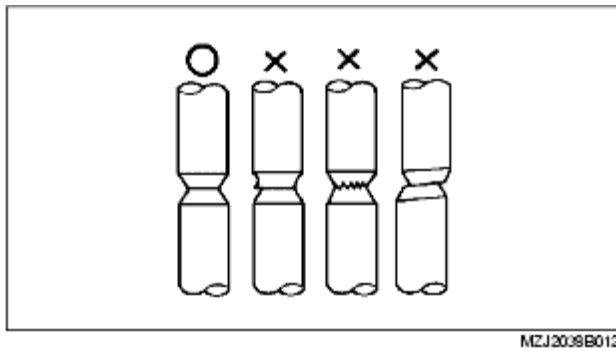
Spot Welding Notes

- The shape of the spot welder tip is $D=(2 \times t)+3$. If the upper panel thickness is different from that of the under panel, adjust to the thinner one.

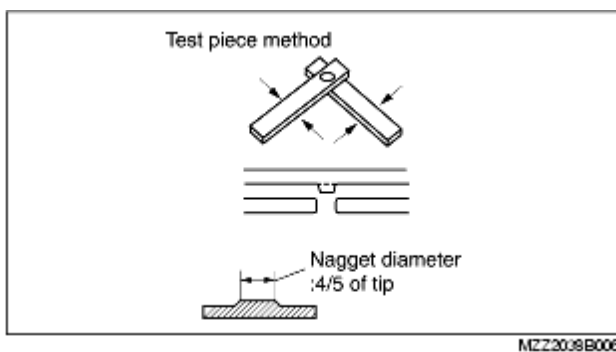


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- Because the weld strength is affected by the shape of the spot welder tip, the optimum condition of the tip should always be maintained.

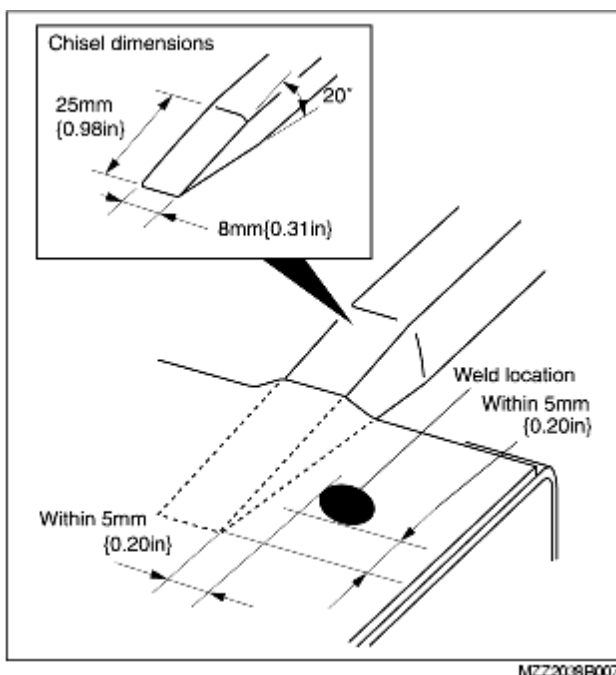


- Spot welds should be made at points other than the originally welded points.
- Before spot welding, make a trial weld using the same material as the body panel to check the weld strength.

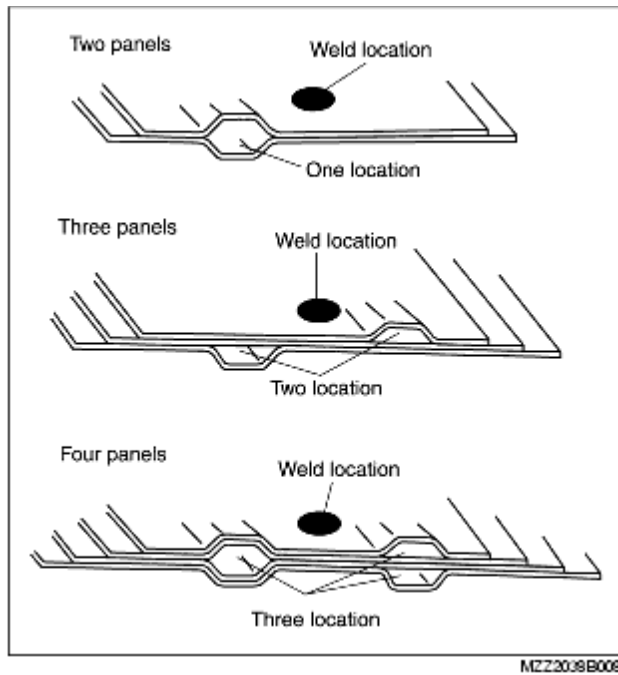


Checking Weld Strength

- Installation locations of the engine, chassis, and seat belts are designated as important safety locations for weld strength. Check weld strength by driving a chisel between the panels at every fourth or fifth weld spot, and every tenth regular weld location.



- Drive the chisel between the panels according to the number of panels as shown below.



- To determine weld strength, drive the chisel between the panel and check whether the panels come apart. If the panels come apart, make another weld near the original weld.
- Restore the shape of the checked area.