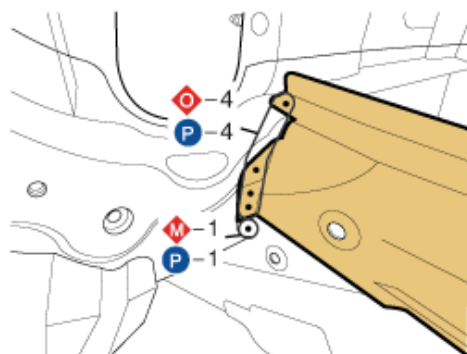
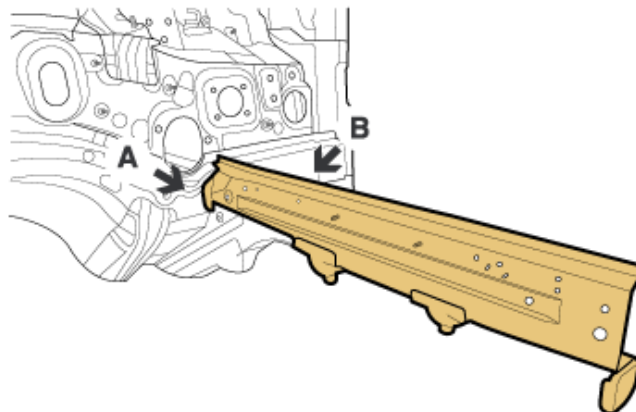


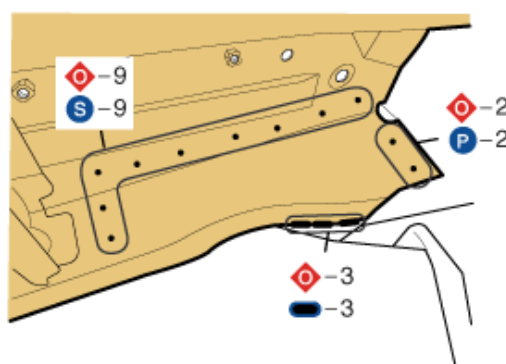


Symbol Meaning

| | | | | | |
|--------------|--|--|---|--|---|
| REMOVAL |  : Outside |  : Middle |  : Inside |  : Cut |  : Hidden weld point |
| INSTALLATION |  : Spot welding |  : Plug welding |  : Lap welding |  : Epoxy adhesive |  : Butt welding |



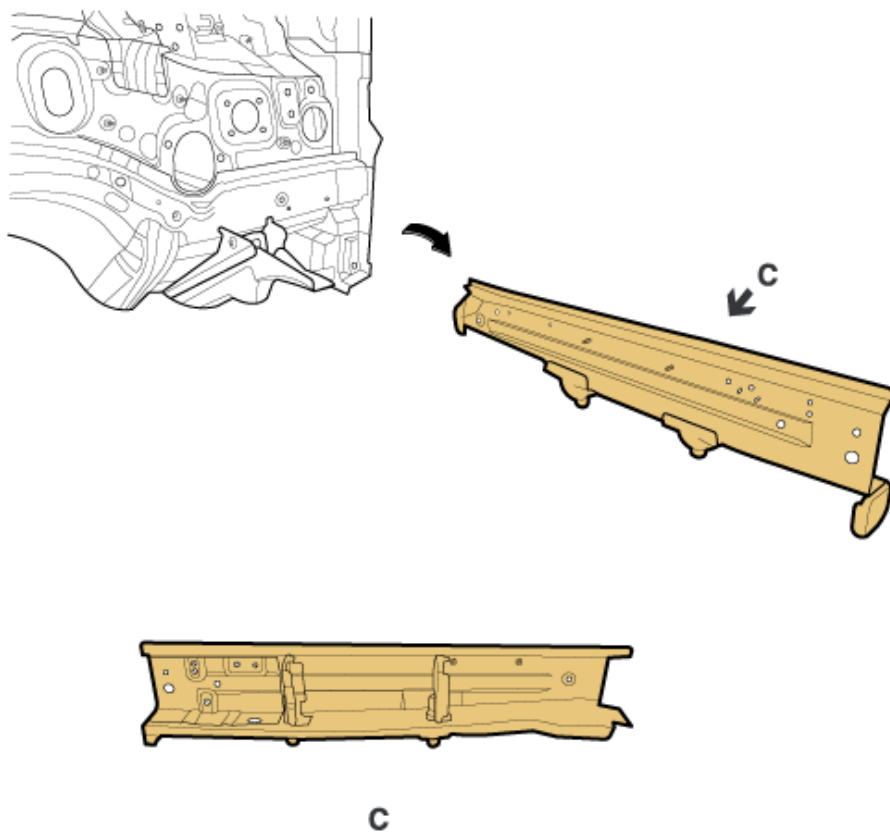
A



B

Symbol Meaning

| | | | | | |
|--------------|--|--|---|--|---|
| REMOVAL |  : Outside |  : Middle |  : Inside |  : Cut |  : Hidden weld point |
| INSTALLATION |  : Spot welding |  : Plug welding |  : Lap welding |  : Epoxy adhesive |  : Butt welding |





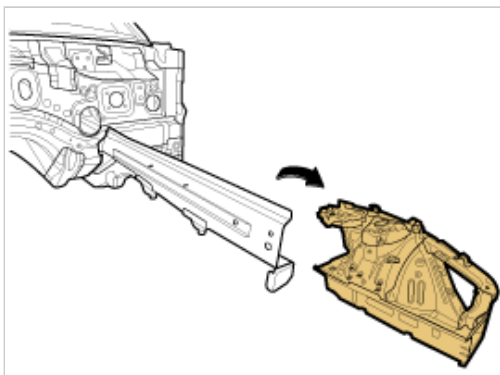
Removal

NOTICE

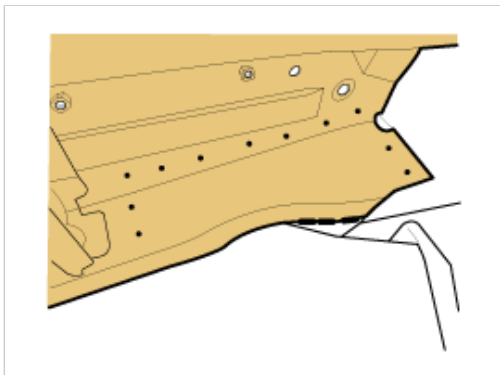
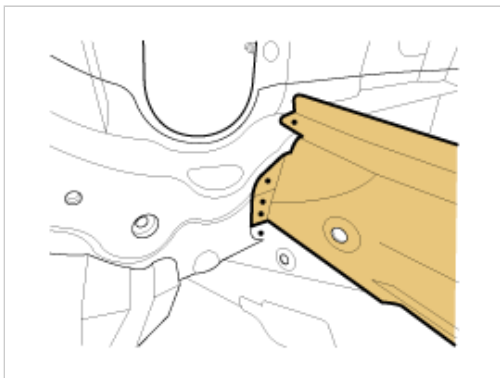
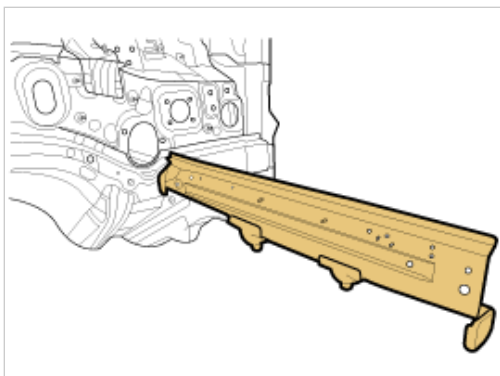
Before repairing, remove Engine and Suspension Components.

Refer to the body dimension charts and measure the vehicle to determine straightening and alignment requirements. The body must return to its original dimension after the repair procedure.

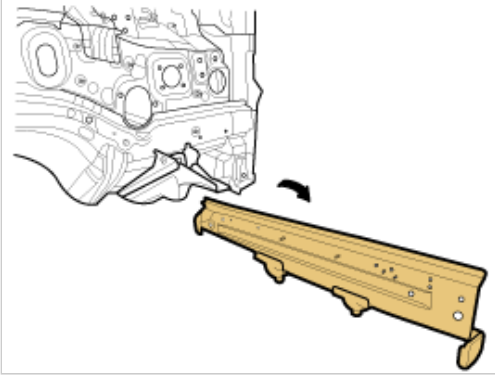
1. To remove the front side member assembly, remove the fender apron panel assembly. (Refer to the fender apron panel assembly repair procedures)



2. Drill out all welding points of the front side member assembly.



3. Remove the front side member assembly.



4. After removal. Remove broken panel parts from welding area.
5. Apply zinc corrosion inhibitor for welding.

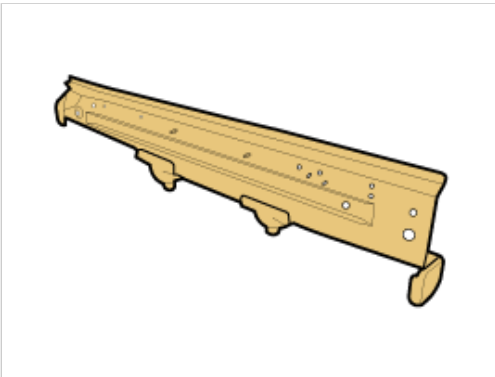
Installation

NOTICE

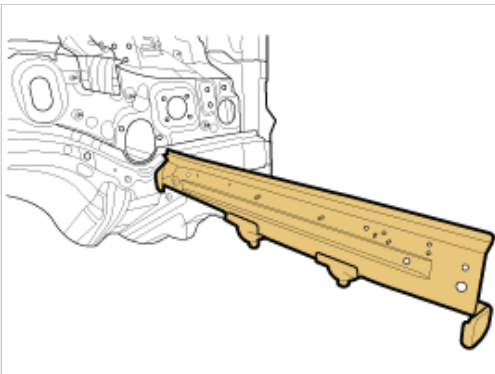
In case of welding during panel installation, perform spot welding on all parts except instructed otherwise in this manual.

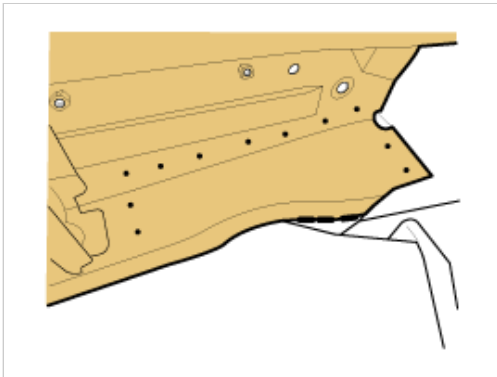
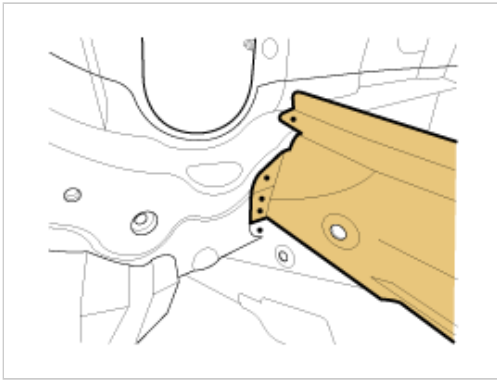
For panels that cannot be spot welded (e.g. parts with holes, parts blocked by panel, parts inaccessible by spot welding arm, etc.), perform MIG PLUG welding.

1. Cut and process new panel before installing on body.
2. Apply zinc corrosion inhibitor for welding.



3. Using a clamp, fix the new panel on body.
 - The application point of epoxy adhesive differs according to panel installation area. The panel must be installed to the body before epoxy adhesive dries.
4. Check the dimensions of the new panel that has been fixed. If the dimensions differ, adjust again.
5. After confirming all dimensions, perform welding on the panel.
 - After performing temporary welding (tack welding), double check the dimensions, and then perform welding.
 - Spot welding after epoxy adhesive has dried may cause weld defects; at all times, complete all spot welding operations before epoxy adhesive dries.
 - If epoxy adhesive is applied on the MIG PLUG welding point, perform MIG PLUG welding after removing epoxy adhesive.





6. For plug welding, remove welding bead with a grinder and clean the welding area.
7. Apply urethane sealer on contacting surface of each panel. (Refer to the Body Sealing Location)
8. After painting, apply cavity wax inside the repaired panel.
9. Install the fender apron panel assembly. (Refer to the fender apron panel assembly repair procedures)

