

### Precautions

#### Maintenance precautions of body structure

1. Precautions for working

Warning :

- Wear clothes and protective items suitable for repair work.
- Disconnect the cable from the battery negative terminal before proceeding with work.
- Always remove the fuel tank from the vehicle and prevent fuel leakage by plugging the hose and pipe when repairing body panels using flames or sparks near the fuel tank.
- Never stand in the path of the chain of the body frame puller when pulling out the frame. In addition, use a safety cable or equivalent in case of an unexpected accident.

Caution :

- When removing and installing body panels, remove or protect resin parts as necessary, otherwise these parts may deform when exposed to heat.

2. Precautions for repairing high-strength steel panels

Caution :

- High-strength steel panels with the tensile strength more than 590 MPa will remarkably reduce its original strength if they are cut, heated and welded. Always replace these panels with individual supply parts.

3. Precautions for repairing body panels

- Use a spot welder suitable for the panel thickness of welding areas and type of the steel panel when performing spot welding.
- Increase the number of spot welded points by 20 to 30% compared with that of originally welded points. In addition, avoid welding over originally welded areas as much as possible.
- For details about the panel thickness and type of each steel panel, refer to “Sheet metal description”.
- Adopt plug welding to weld areas where spot welding cannot be used. Select hole diameters for plug welding by referring to the following table according to the panel thickness and type of steel panel.

Thickness of panel to be welded	Hole diameter for plug welding
Less than 1.0 mm (0.04 in.)*	ø 6.0 (ø 0.24 in.) or more
1.0 to 1.5 mm (0.04 to 0.06 in.)*	ø 8.0 (ø 0.31 in.) or more
1.5 mm (0.06 in.) or more	ø 10.0 (ø 0.39 in.) or more

- ø 10.0 (ø 0.39 in.) or more for parts using high-strength steel panels
- Always remove coating from new parts and paint from vehicle bodies at every welding point and apply spot sealer for anti-rust treatment, before proceeding with welding.
- Apply anti-rust wax on back side of the continuous welding and fillet welding.
- Refer to body dimensions to properly install new parts.

4. Precautions for handling vehicles equipped with the supplemental restraint system

Caution :

- Remove any parts related to the supplemental restraint system, when performing work involving the application of heat higher than 85°C.
- Remove the SRS control unit and each airbag sensor before proceeding with work, if a strong impact may be applied to these parts.
- Refer to “Vehicles with supplemental restraint system safety information” to avoid unexpected operation of the supplemental restraint system.