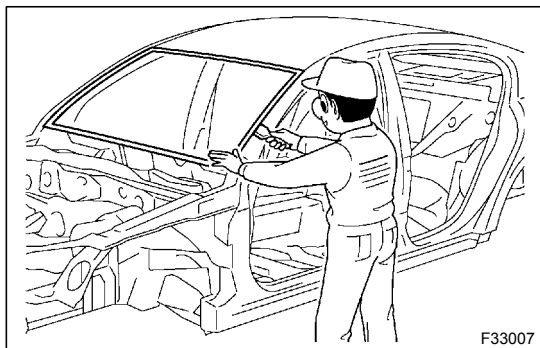


### 3. PRECAUTIONS FOR CORRECT REPAIR

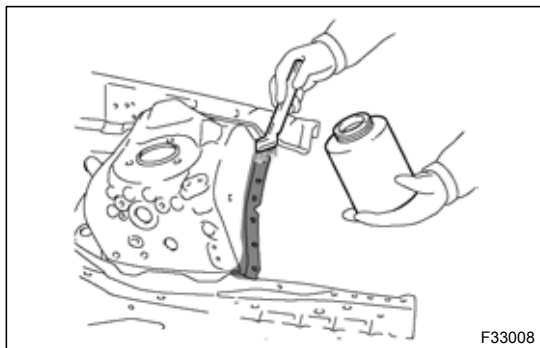


#### (a) REMOVAL OF ADJACENT COMPONENTS

- (1) When removing adjacent components, apply protective tape to the surrounding body and your tools to prevent damage.

**NOTICE:**

**If the paint film is damaged, make sure to re-finish the paint.**

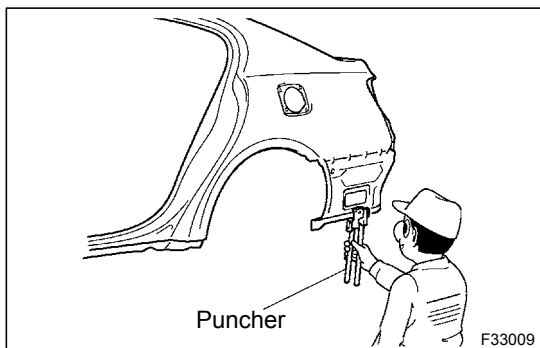


#### (b) ANTI-RUST TREATMENT BEFORE WELDING

- (1) Apply welding primer to the contact surfaces of the welding areas to protect them from rust.

**NOTICE:**

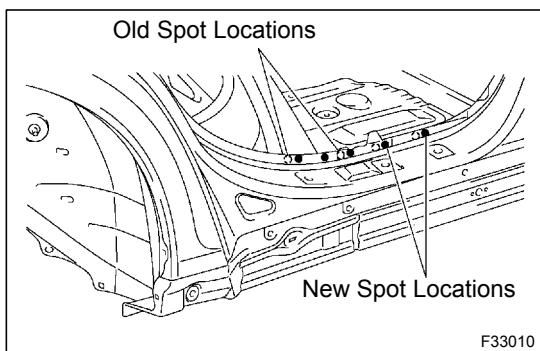
**Do not apply welding primer outside of the contact surfaces.**



#### (c) MAKING HOLES FOR PLUG WELDING

- (1) For areas where a spot welder cannot be used, use a puncher or drill to make holes for plug welding.

Thickness of welded portion	Diameter of plug hole
Under 1.0 mm (0.04 in.)	Over 5 mm (0.20 in.)
1.0 to 1.6 mm (0.04 to 0.06 in.)	Over 6.5 mm (0.26 in.)
1.7 to 2.3 mm (0.07 to 0.09 in.)	Over 8 mm (0.31 in.)
Over 2.4 mm (0.09 in.)	Over 10 mm (0.39 in.)



#### (d) WELDING PRECAUTIONS

- (1) The number of welding spots should be as follows.

**Spot weld: 1.3 X No. of manufacturer's spots**

**Plug weld: More than No. of manufacturer's plugs**

- (2) Spot weld locations  
Avoid welding over previously welded areas.