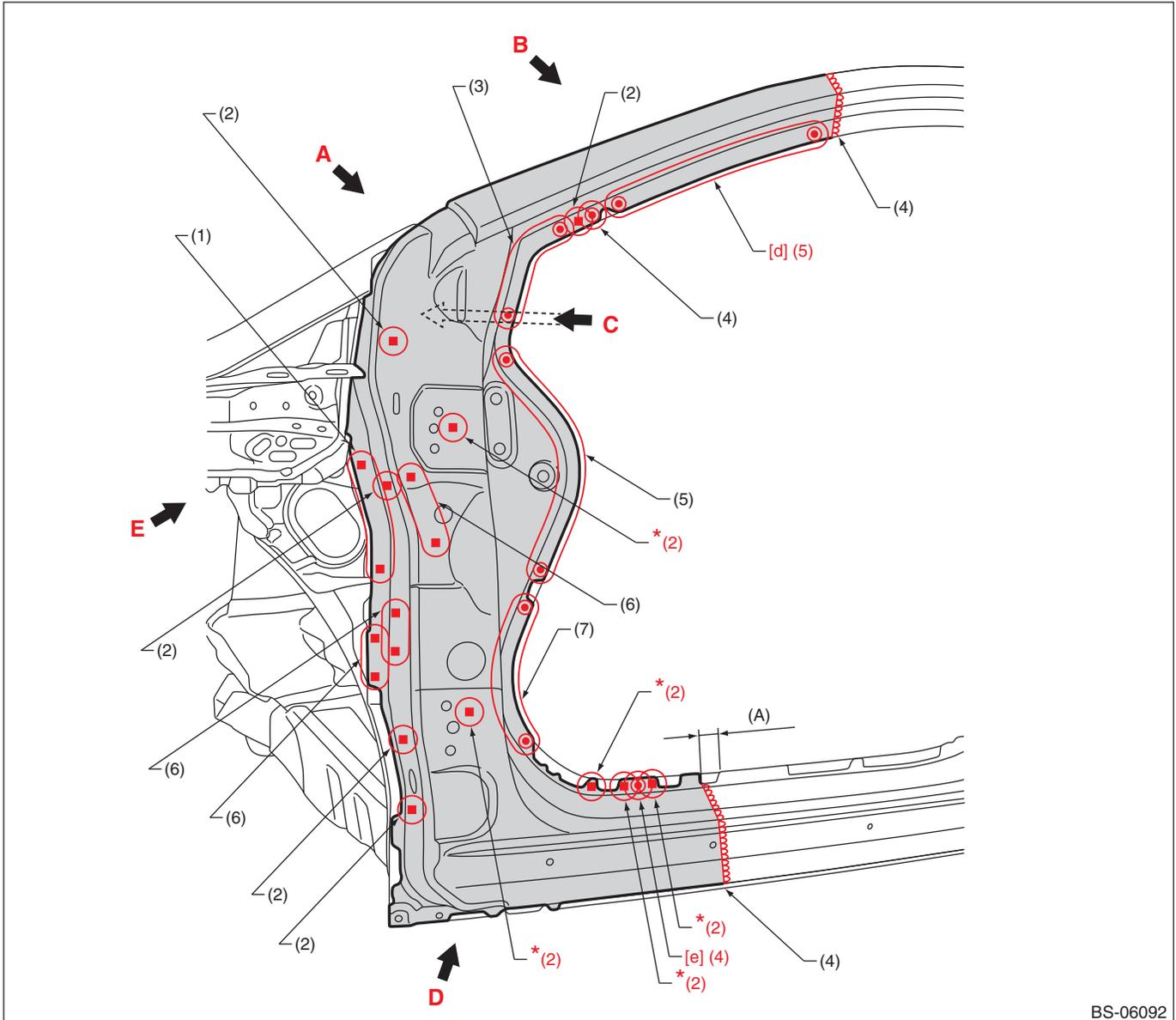


# Panel Replacement

## B: INSTALLATION

### • Overall view



BS-06092

(A) 25 mm (0.98 in)

(1) 4 points (service)

(4) 1 point

(7) 7 points (only LH)  
4 points (only RH)

(2) 1 point (service)

(5) 8 points

(3) 4 points

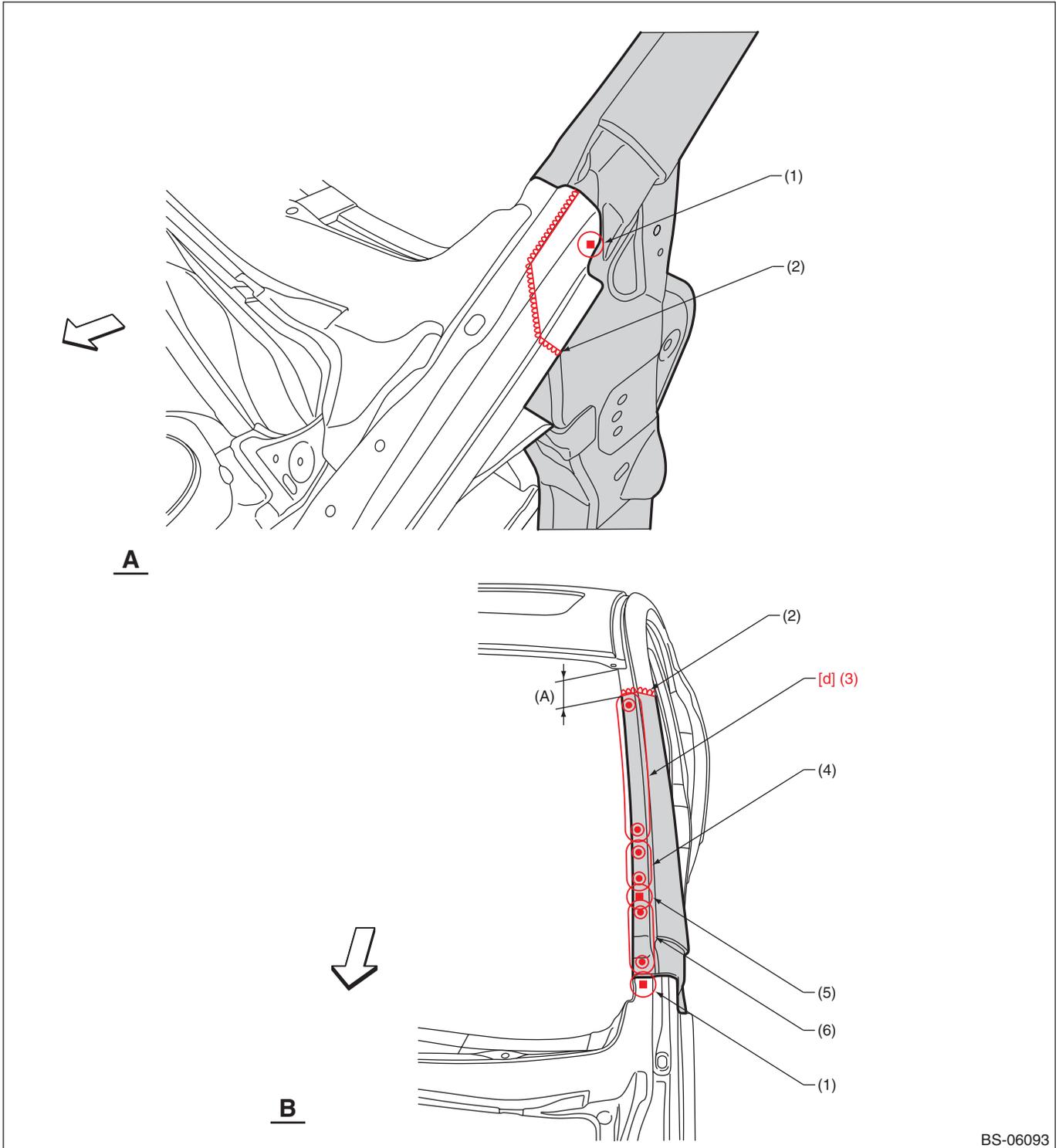
(6) 2 points (service)

[d] Spot welding conditions	Compression: 3.5 kN, Current: 7.0 kA, Welding time: 25 cyc
[e] Spot welding conditions	Compression: 3.5 kN, Current: 7.5 kA, Welding time: 16 cyc

\*: When plug welding a high-tensile steel sheet of 980 MPa Class or more, refer to "NOTE, Foreword" on page 7.

# Panel Replacement

## • Views 1



BS-06093

(A) 60 mm (2.36 in)

(1) 1 point (service - matching)

(3) 9 points

(5) 1 point (service)

(2) 1 point

(4) 2 points

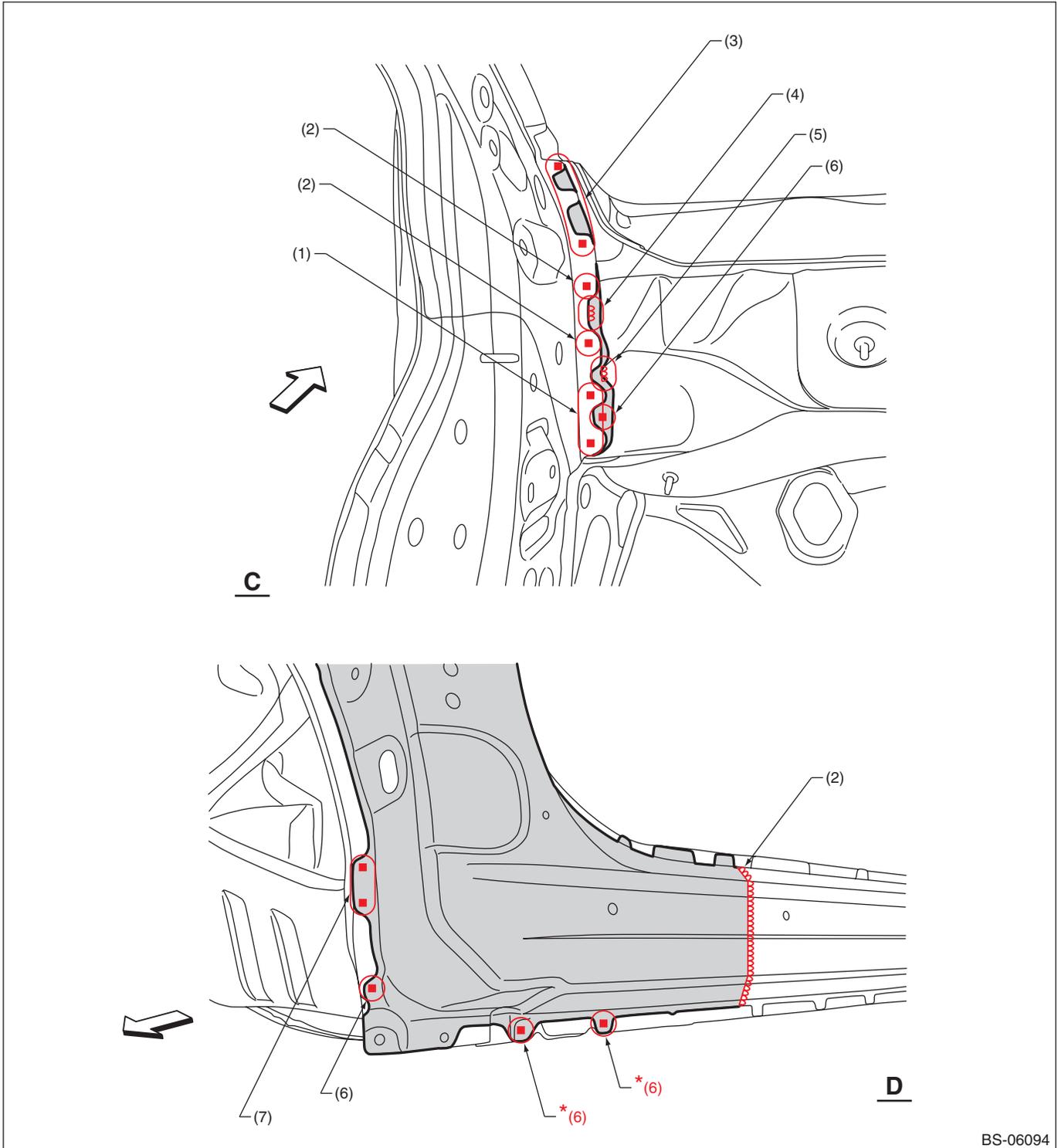
(6) 3 points

[d] Spot welding conditions

Compression: 3.5 kN, Current: 7.0 kA, Welding time: 25 cyc

# Panel Replacement

## • Views 2



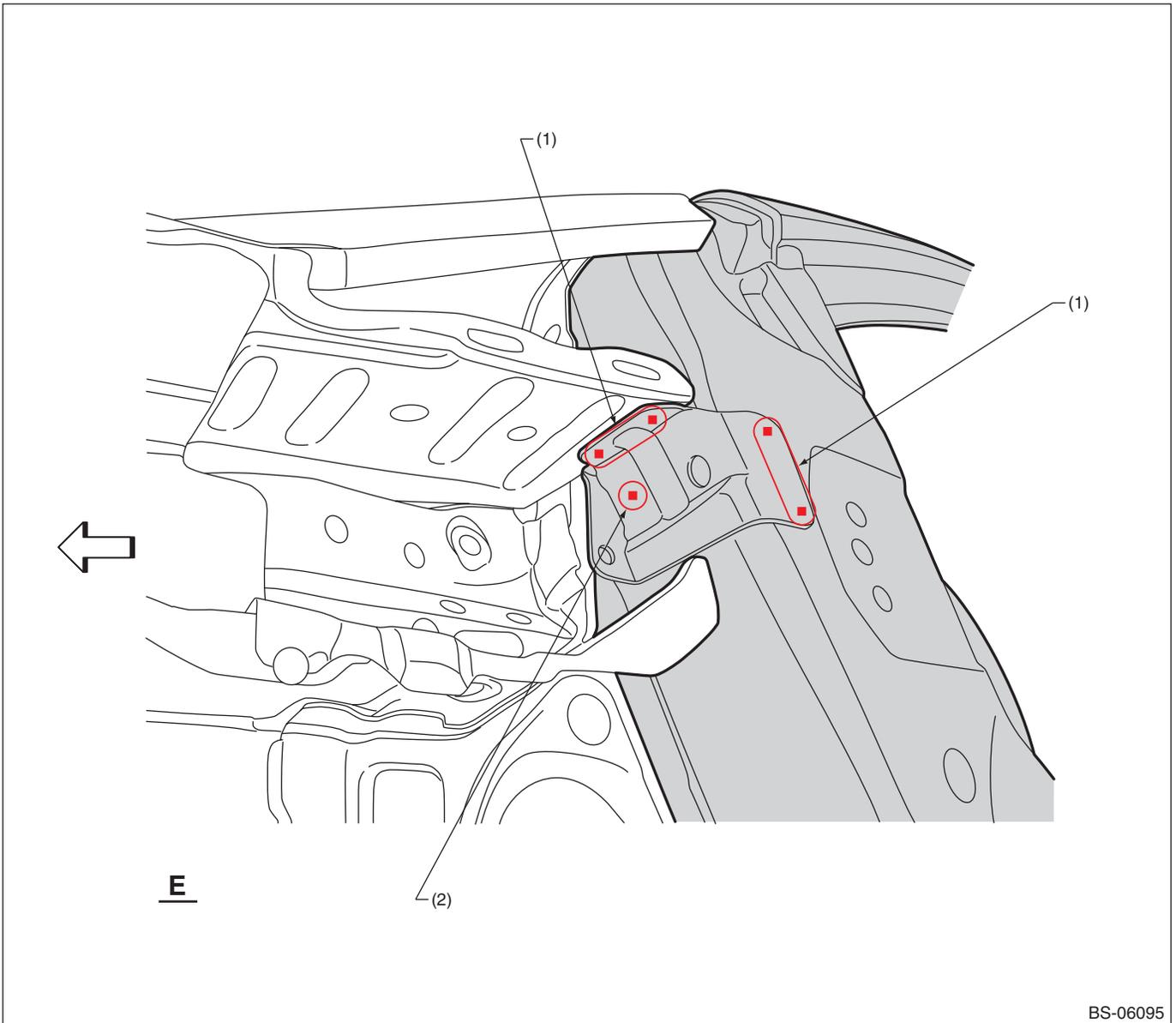
BS-06094

- |              |                               |                        |
|--------------|-------------------------------|------------------------|
| (1) 2 points | (4) 1 point [15 mm (0.59 in)] | (7) 2 points (service) |
| (2) 1 point  | (5) 1 point [10 mm (0.39 in)] |                        |
| (3) 3 points | (6) 1 point (service)         |                        |

\*: When plug welding a high-tensile steel sheet of 980 MPa Class or more, refer to "NOTE, Foreword" on page 7.

# Panel Replacement

## • Views 3



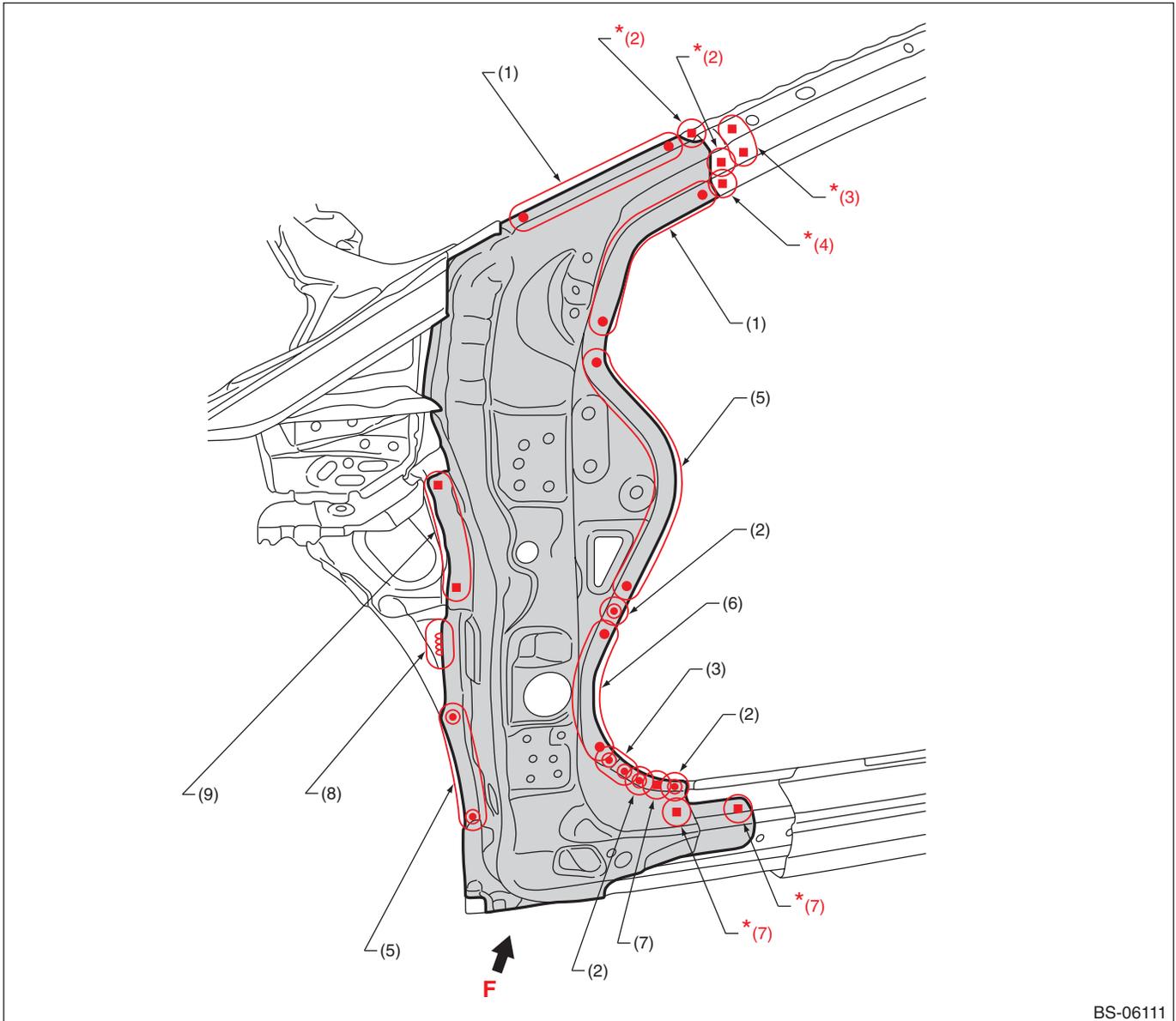
BS-06095

(1) 2 points (service)

(2) 1 point (service)

# Panel Replacement

## • Overall view (LH)



BS-06111

- (1) 5 points
- (2) 1 point
- (3) 2 points

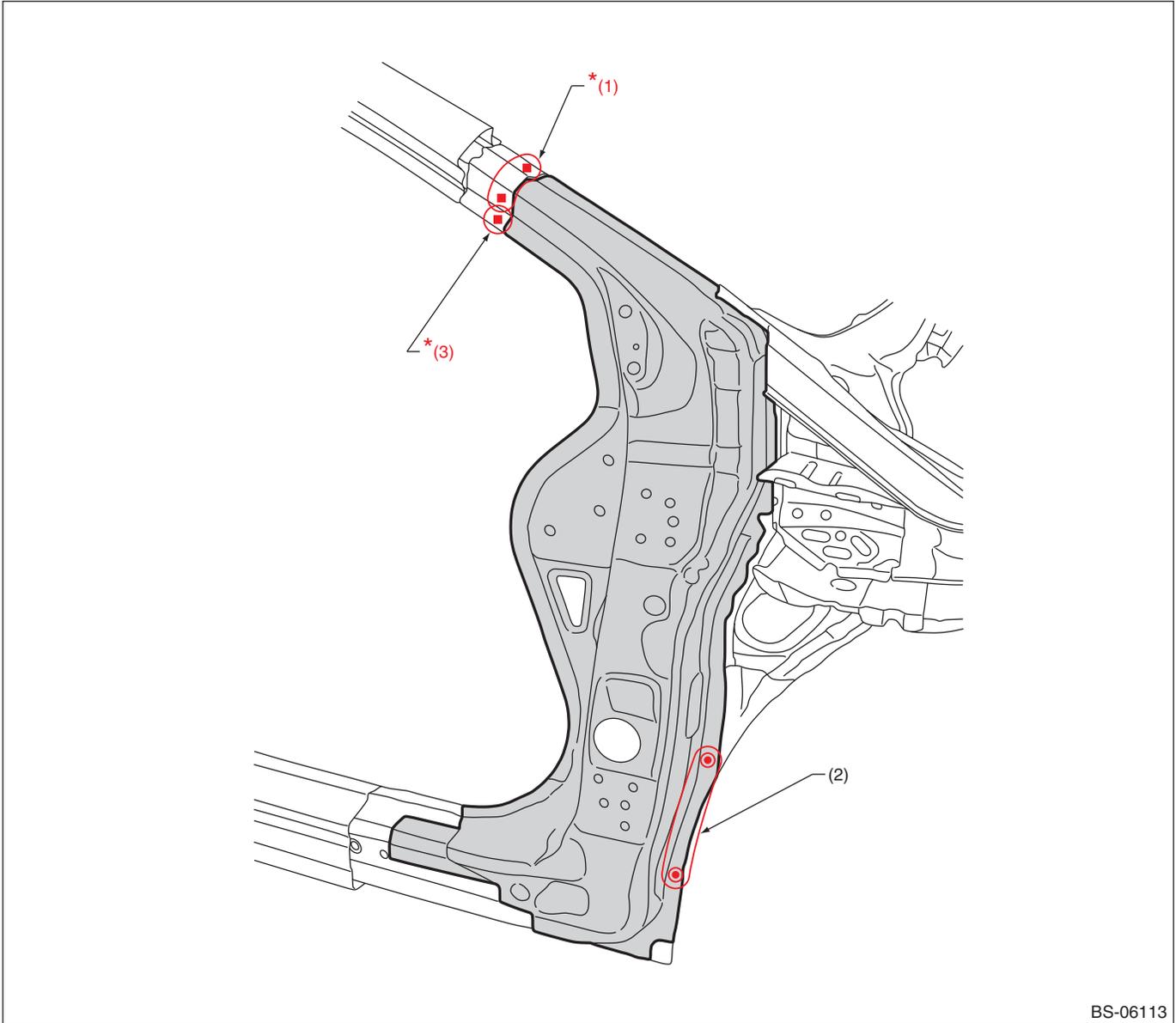
- (4) 1 point (service · matching)
- (5) 8 points
- (6) 7 points (only LH)  
4 points (only RH)

- (7) 1 point (service)
- (8) 1 point [25 mm (0.98 in)]
- (9) 4 points (service)

\*: When plug welding a high-tensile steel sheet of 980 MPa Class or more, refer to "NOTE, Foreword" on page 7.

# Panel Replacement

- (RH)



(1) 3 points

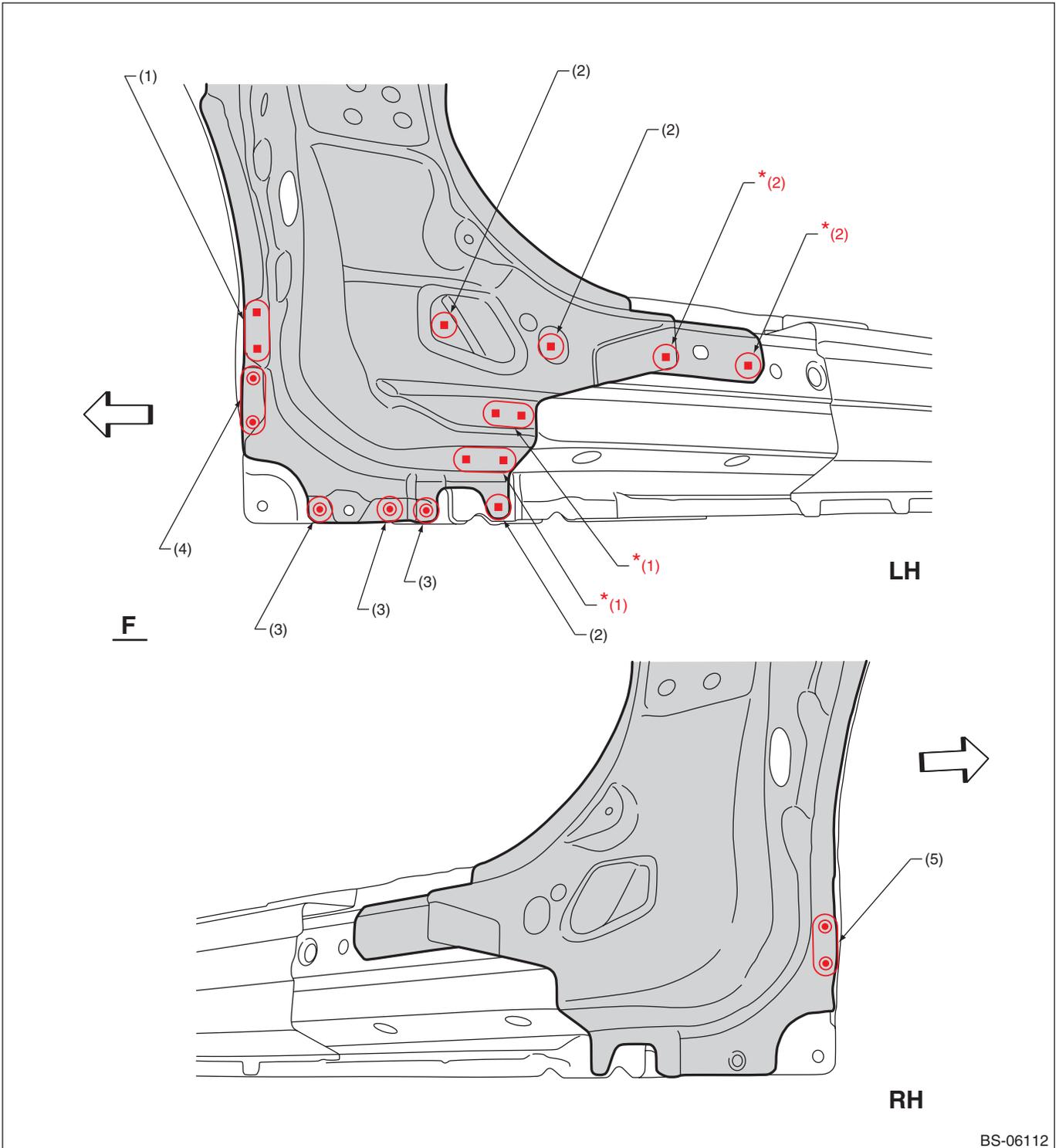
(2) 5 points

(3) 1 point (service · matching)

Note: Designations in the RH diagram are the same as in the LH diagram, except for the indicated points.  
\*: When plug welding a high-tensile steel sheet of 980 MPa Class or more, refer to "NOTE, Foreword" on page 7.

# Panel Replacement

## • Views



BS-06112

(1) 2 points (service)

(3) 1 point

(5) 2 points

(2) 1 point (service)

(4) 3 points

Note: Designations in the RH diagram are the same as in the LH diagram, except for the indicated points.

\*: When plug welding a high-tensile steel sheet of 980 MPa Class or more, refer to "NOTE, Foreword" on page 7.