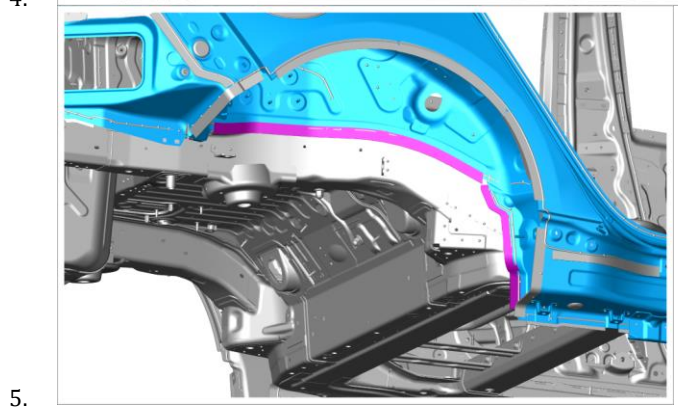
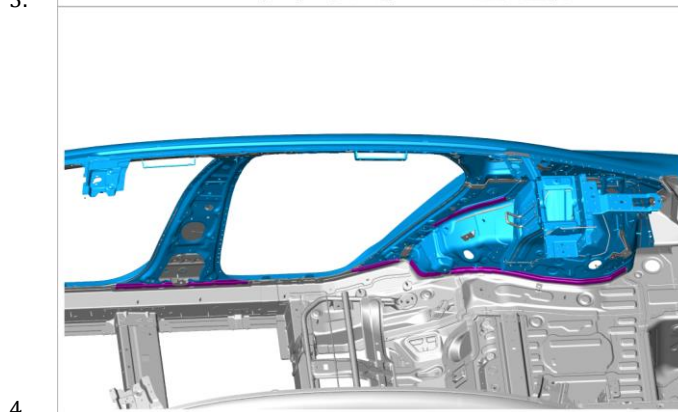
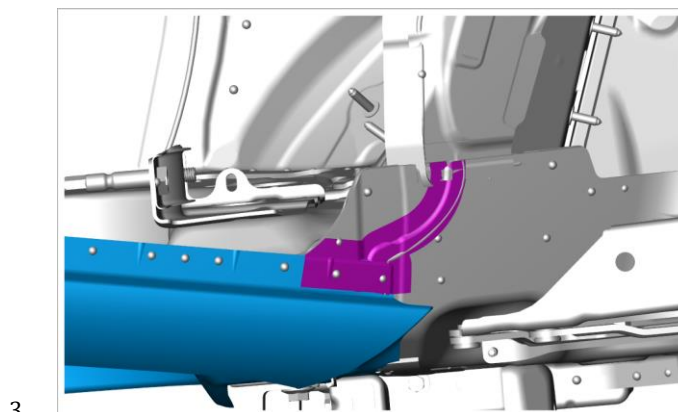


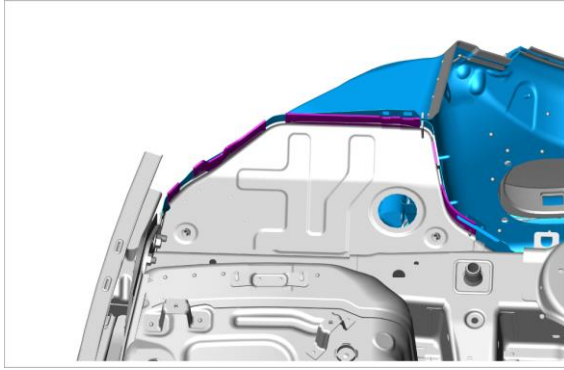
# Replacement of right side wall assembly

## Remove


1. Remove the roof cover assembly. Refer to
2. Use a sander to grind the sealant on the inner side of the right side wall assembly.

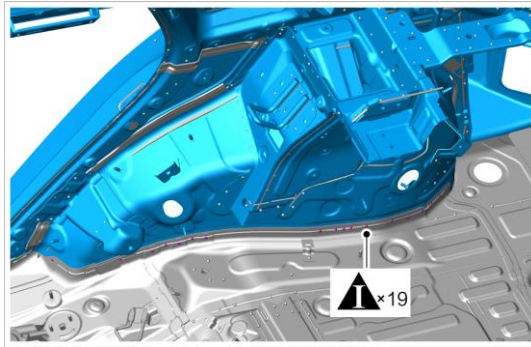
Maintenance method indicator	Descriptions
	Cut with disc sander, etc.






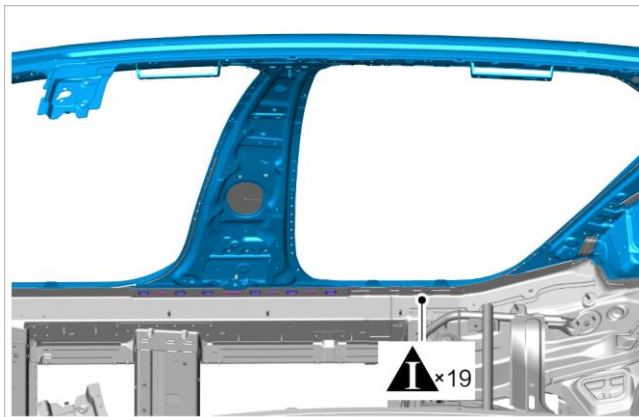
- 6.
7. Remove 19 welding spots of the right side wall assembly.

Maintenance method indicator	Descriptions
	Remove the welding spots (the replaced panel is on the inner side)



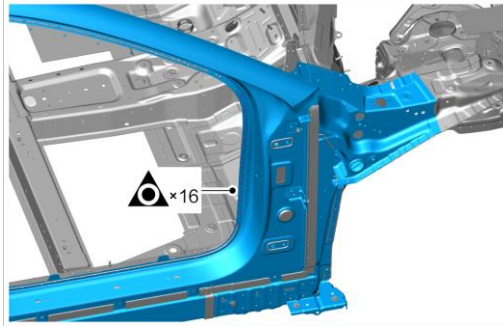
- 8.
9. Remove 19 welding spots of the right side wall assembly.

Maintenance method indicator	Descriptions
	Remove the welding spots (the replaced panel is on the inner side)




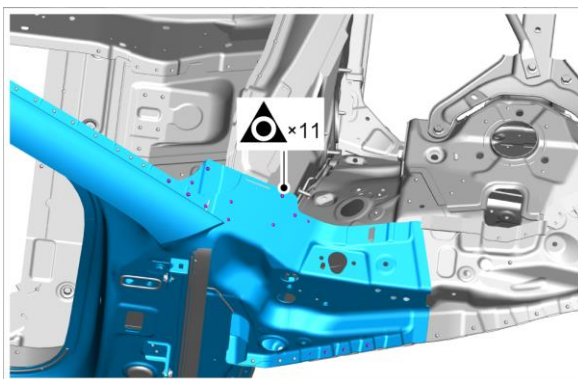
- 10.
11. Remove 16 welding spots of the right side wall assembly.

Maintenance method indicator	Descriptions
	Remove the welding spots (the replaced panel is on the outer side)




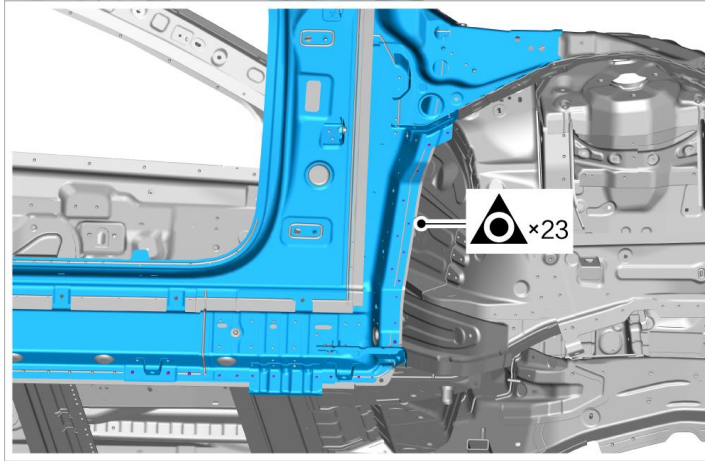
12.  
13. Remove 11 welding spots of the right side wall assembly.

Maintenance method indicator	Descriptions
	Remove the welding spots (the replaced panel is on the outer side)




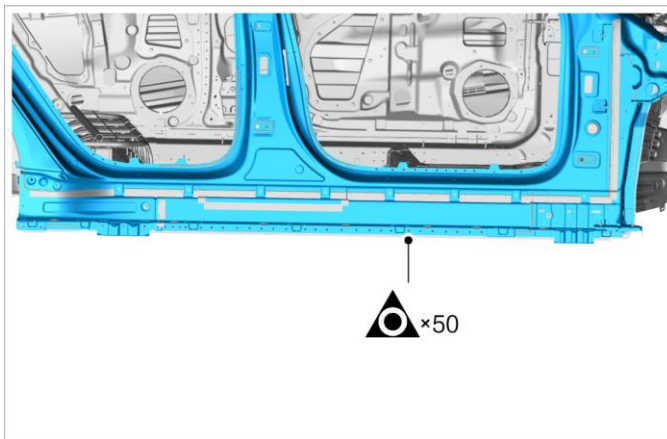
14.  
15. Remove 23 welding spots of the right side wall assembly.

Maintenance method indicator	Descriptions
	Remove the welding spots (the replaced panel is on the outer side)




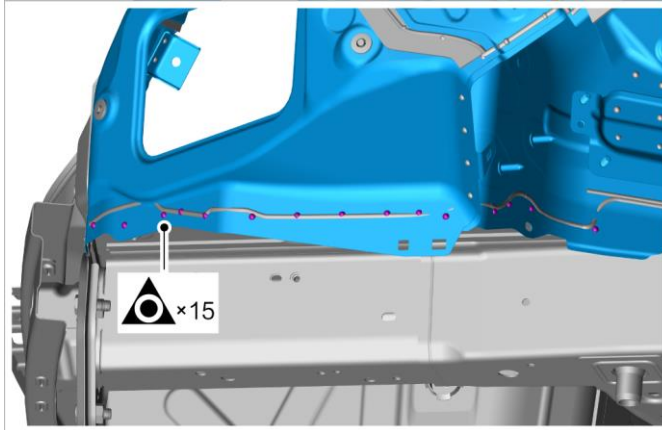
- 16.
- 17. Remove 50 welding spots of the right side wall assembly.

Maintenance method indicator	Descriptions
	Remove the welding spots (the replaced panel is on the outer side)




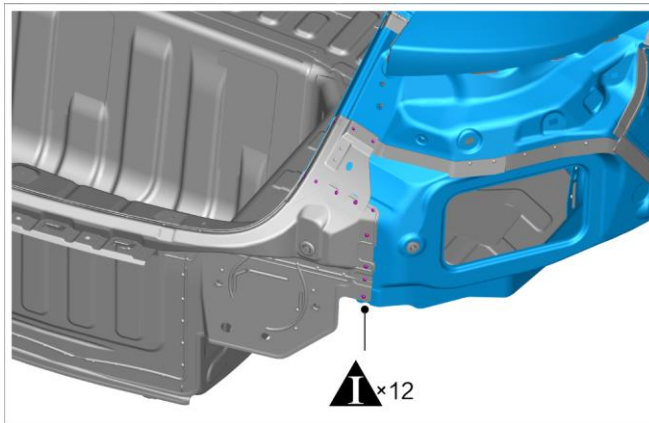
- 18.
- 19. Remove 15 welding spots of the right side wall assembly.

Maintenance method indicator	Descriptions
	Remove the welding spots (the replaced panel is on the outer side)



20.  
 21. Remove 12 welding spots of the right side wall assembly and take out the right side wall assembly.

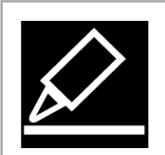
Maintenance method indicator	Descriptions
	Remove the welding spots (the replaced panel is on the inner side)

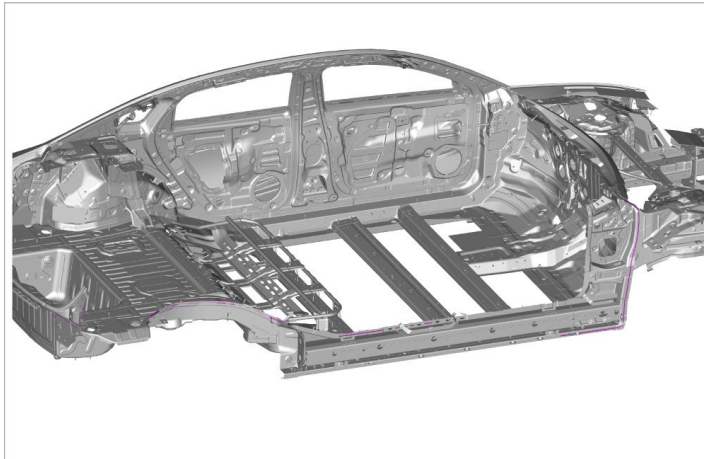


22.

## Install

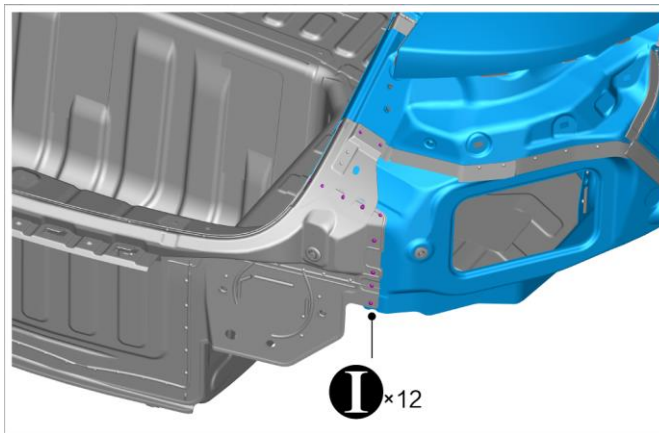
1. Clean the joint of right side wall assembly and apply adhesive.

Maintenance method indicator	Descriptions
	Body sealant




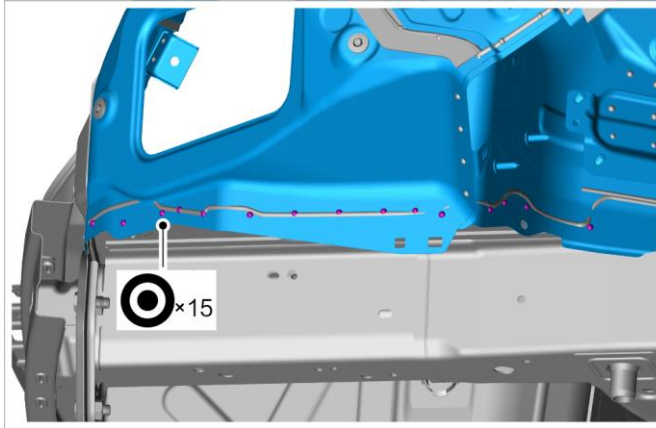
- 2.
3. Fix the right side wall assembly to the installation position.
4. Check and adjust the relative positions and sizes of the right side wall assembly and front compartment parts. Refer to
5. Check and adjust the relative positions and sizes of the right side wall assembly and rear compartment parts. Refer to
6. Check and adjust the relative positions and sizes of the right side wall assembly and underbody parts. Refer to
7. Weld 12 welding spots on the right side wall assembly.

Maintenance method indicator	Descriptions
	Spot welding (the replaced panel is on the inner side)




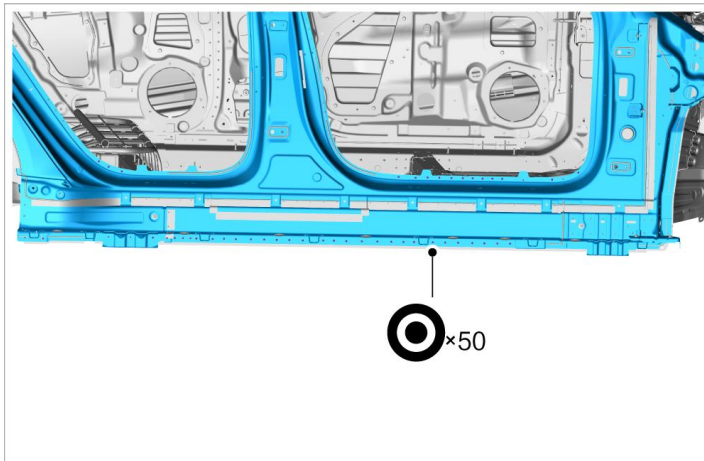
- 8.
9. Weld 15 welding spots on the right side wall assembly.

Maintenance method indicator	Descriptions
	Spot welding (the replaced panel is on the outer side)




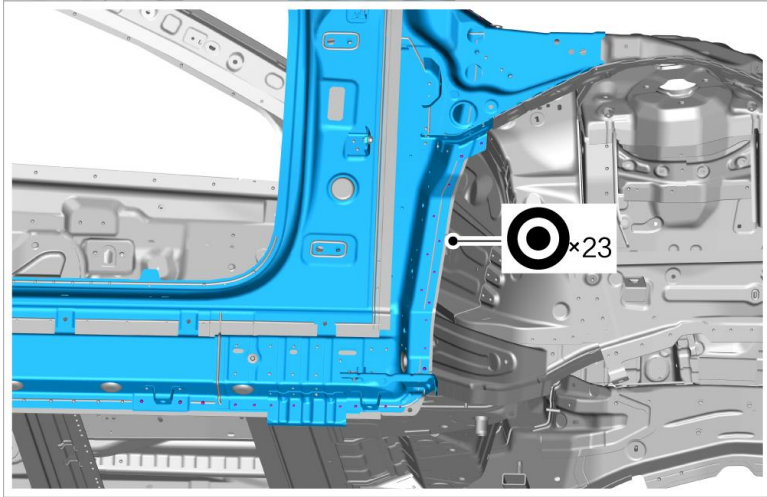
- 10.
- 11. Weld 50 welding spots on the right side wall assembly.

<b>Maintenance method indicator</b>		<b>Descriptions</b>
		Spot welding (the replaced panel is on the outer side)



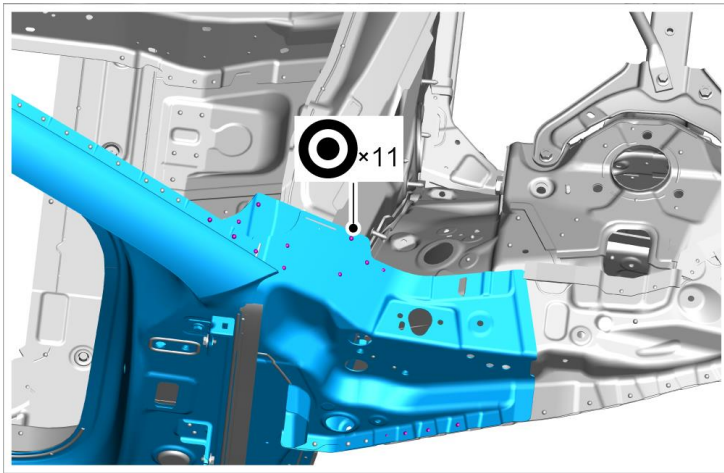
- 12.
- 13. Weld 23 welding spots on the right side wall assembly.

<b>Maintenance method indicator</b>		<b>Descriptions</b>
		Spot welding (the replaced panel is on the outer side)




- 14.
- 15. Weld 11 welding spots on the right side wall assembly.

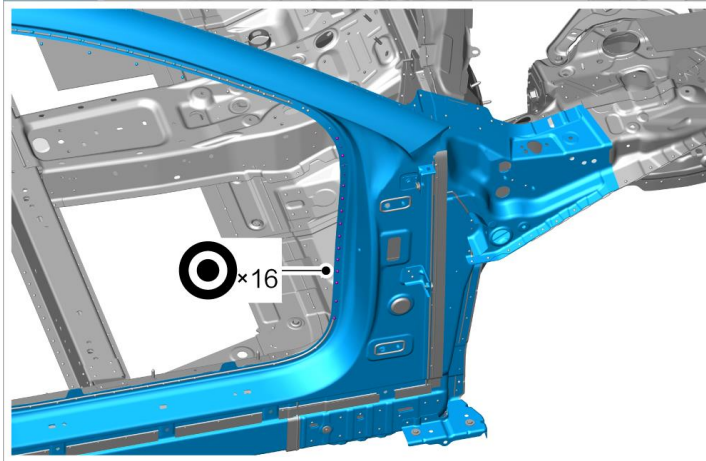
Maintenance method indicator		Descriptions
		Spot welding (the replaced panel is on the outer side)




- 16.
- 17. Weld 16 welding spots on the right side wall assembly.

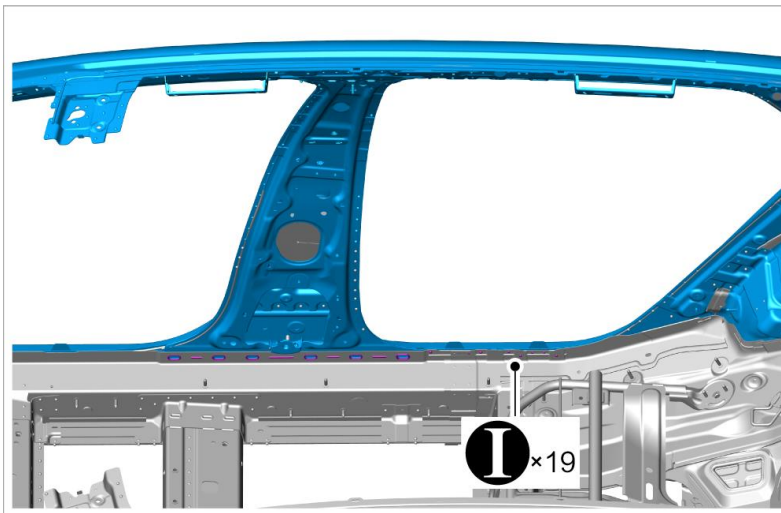
Maintenance method indicator		Descriptions
		Spot welding (the replaced panel is on the outer side)





- 18.
19. Weld 19 welding spots on the right side wall assembly.

Maintenance method indicator		Descriptions
		Spot welding (the replaced panel is on the inner side)



- 20.
21. After applying the external coating, apply rust inhibitor to the inner plate part of the welding spots of the closed section structure.
22. Install it in the reverse order of removal.