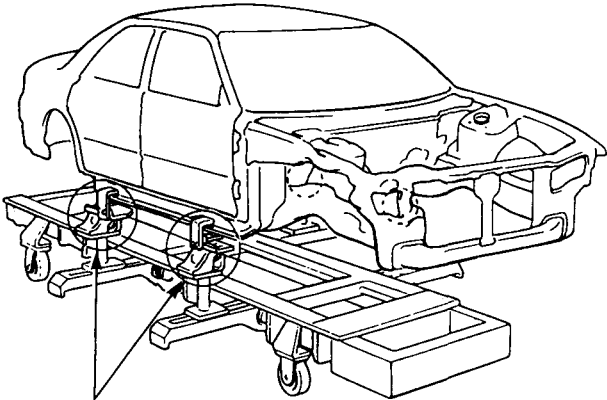


Preparation of Work

Correction of the Damaged Area

Set the frame corrector on the car body.
The side sill is flangeless to allow reshaping by pulling it out.
Use the horizontal pinch welds for anchoring the car.



UNDERBODY CLAMPS

Underbody Clamp Specifications:

UNDERBODY CLAMP (Special tool)	Clamp Number	
<p>③ ② ① ATTACHMENT OFFSET PLATE</p>	<p>AT-63</p> <p>① Clamp body ② Side clamp ③ Under clamp</p> <p>(Without offset plate and attachment)</p>	<p>OFFSET PLATE (No. AT-63-100)</p> <p>NOTE: Use a offset plate, clamp the lower section of the front pillar of the body.</p>
ATTACHMENT	Number	Frame correctors
<p>Standard type:</p> <p>C – type:</p> <p>U – type:</p>	<p>AT-63-AL</p> <p>AT-63-C</p> <p>Inner diameter 65 mm (2.6 in)</p> <p>AT-63-U</p> <p>Inner diameter 20 mm (0.8 in)</p>	<div><ul style="list-style-type: none">● Dataliner● Car-o-liner</div> <div><ul style="list-style-type: none">● Celette● Flex-o-liner● etc.</div> <div><ul style="list-style-type: none">● Korek● Auto pole● etc.</div> <div><ul style="list-style-type: none">● U-Base● Pro-Tec● etc.</div>

1. Apply load to the damaged section and pull it out until the section is almost restored to the original shape.

2. Check that the parts of the body they cover have been more or less restored to their original shapes.

NOTE: Check the original position using the body dimensional drawings (see [section 6](#)) and the positioning jigs (see page [1-7](#)).

3. Remove the parts that require replacement.

4. Decide whether to replace all the affected parts or whether to cut the weld joint parts and replace them.

5. Cut off and separate the damaged parts.

NOTE: When cutting the parts off, take special care that you do not damage adjacent parts on the automobile.

Setting Condition of Replacement Parts Joint Sections:

- Make sure that you can perform straightening work after welding.
- Make sure that the locations are not susceptible to distortion caused by other parts.
- Make sure that there are few removable parts and that the location allows safe welding.
- Make sure that the joints are short, and that paint repair can be performed easily.
- Make sure the locations are such that the joints can be finished in a way that does not affect the outward appearance.
- Make sure that the locations do not hinder the removing and attaching of parts.

NOTE: Bear in mind all of these conditions, and after determining the joint locations, cut the joints for an overlap of 20~30 mm (0.8~1.2 in).

6. Mold the related parts.

7. Set and tack weld the replacement parts.

NOTE: Temporarily mount the related parts and check the clearance and level differences.

8. Weld the replacement parts.

Welding methods (see [section 2](#)).

NOTE: Use of the positioning jig is recommended.

CAUTION: Protect body parts with the heat-resistant protective cover to prevent damage, when welding.

The paint film, which is designed to prevent corrosion caused by moisture, is destroyed around the edges of the locations which have been repaired by welding.

Therefore, in such places and especially in those areas which are not visible, apply another coat of the paint, referring to the anti-corrosion painting manual. This operation is designed to maintain durability and quality (see [section 7](#)).