

Body Repair

INTRODUCTION

BODY PANEL REPLACEMENT

RADIATOR UPPER SUPPORT (ADD)

RADIATOR SIDE SUPPORT (ADD)

FRONT CROSSMEMBER (ADD)

RADIATOR SUPPORT (ADD)

FRONT FENDER ARCH (ADD)

LOWER TOP SIDE RAIL (ADD)

FRONT BODY PILLAR LOWER CORNER (ADD)

FRONT BODY PILLAR (CUT)

CENTER BODY PILLAR (CUT)

FRONT DOOR OUTER PANEL (ADD)

REAR DOOR OUTER PANEL (ADD)

FRONT BODY UPPER OUTER PILLAR (CUT)

CENTER BODY OUTER PILLAR (CUT)

ROCKER OUTER PANEL (ADD)

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BODY LOWER BACK PANEL (CUT)

BODY LOWER BACK PANEL (ADD)

REAR FLOOR CROSSMEMBER NO. 1 (ADD)

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ROOF RAIL (ADD)

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CAB MOUNTING NO. 1 BRACKET (ADD)

FRAME RAIL CROSSMEMBER (ADD)

FRAME RAIL CROSSMEMBER CORNER (ADD)

OUTER PANEL INSTALLATION TORQUE

PT. STAMPING/ASSEMBLY METHOD/TORQUE SPECIFICATION



BP-08

BODY PANEL REPLACEMENT

FRONT BODY UPPER OUTER PILLAR (CUT):

3 Door



Steel used for 90% MPa ultra high strength steel

- Follow the welding conditions below when welding ultra high strength steel to ensure sufficient weld strength. (When repairing this model)

① When welding 2 panels together including 90% MPa ultra high strength steel

Spot weld	Pressure	200N (20 kg) MP-40
	Weld current	1000 A
	Weld time	10 (sec) (10 sec flow)
Plug weld	Plug diameter	16 mm (5/8 in.)
	Wire type	WELD-AE 16 (E7018-1)
	Shield gas	Shield when gas

② When welding more than 2 panels together including 90% MPa ultra high strength steel (When plug welding a panel to the welded panels with the weld condition above.)

Plug weld	Plug diameter	Same as the standard material (see the illustration)
	Wire type	WELD-AE 16 (E7018-1)
	Shield gas	Shield when gas

NOTE

Be sure to use shield when gas for 90% + CO₂ 90% or the shield gas when plug welding. Sufficient weld strength cannot be achieved when using 100% CO₂ shield gas.



HT

Toyota Prado 2015 Service Manual

**Toyota Jidōsha Hanbai Kabushiki
Kaisha. Export-Technical Department**

A red circular graphic with a gradient, appearing as a partial circle or a stylized 'C' shape, located to the right of the text block.

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Toyota Prado Automotive Repair Manual Jeff Killingsworth, John Harold Haynes, 2006-01-01 [Toyota Land Cruiser Automotive Repair Manual](#) Jeff Kibler, Robert Maddox, John Harold Haynes, 2002 FJ60 FJ62 F70 F73 F75 F80 FZJ80 with petrol engines *Toyota Prado 1996-2008 Automobile Repair Manual* Max Ellery, 2004-10-16 This comprehensive manual covers the complete Toyota Prado range of vehicles Detailed engine chapters covering all petrol gasoline and diesel engines It also covers the Hilux 4 Runner and Surf mechanicals Detailed comprehensive chapters cover the complete range of transmissions The manual also covers all other aspects of the vehicle from changing a light globe through to complete vehicle pull down YComprehensive chapters covering diagnostics and troubleshooting and also includes complete electrical wiring diagrams for the entire vehicle This comprehensive manual consists of over 500 pages of step by step instructions which will suite the DIY handyman through to the professional mechanic [Toyota Land Cruiser Petrol and Diesel Automotive Repair Manual](#) ,2015-07 **Toyota Landcruiser Repair Manual** ,2012-01-01 Series 78 79 100 105 6 8 cylinder engines with 4 5L 4 7L petrol and 4 2L diesel **Toyota Land Cruiser Automotive Repair Manual** Jeff Killingsworth, John Harold Haynes, 2005-01-01 *Workshop Manual for Toyota Land Cruiser* Intereurope, 1969 **Toyota Prado Automotive Repair Manual** Jeff Killingsworth, John Harold Haynes, 2011-07-01 Series 95 120 4 6 cylinder engines with 2 7L 3 4L 4 0L petrol 3 0L diesel **Prado 4WD Service & Repair Manual 1996-2009** ,2010 *Toyota Land Cruiser Owners Workshop Manual* John Harold Haynes, Bloomsbury Publishing Plc, Peter Ward, 1982 **Toyota Land Cruiser (heavy Duty) Repair Manual for Chassis & Body** ,1986 *Toyota Land Cruiser Repair Manual, Chassis & Body* Toyota Jidōsha Hanbai Kabushiki Kaisha. Export-Technical Department, 1974 **Toyota Land Cruiser (heavy-duty) Repair Manual for Chassis & Body** ,1988 *Toyota Land Cruiser Repair Manual* Toyota Jidōsha Hanbai Kabushiki Kaisha, 1963 **HM TOYOTA LAND CRUISER D&P 1980-1998** ,2018 **Toyota Land Cruiser Repair Manual** ,1983 *Toyota Land Cruiser: All Models* ,1971

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