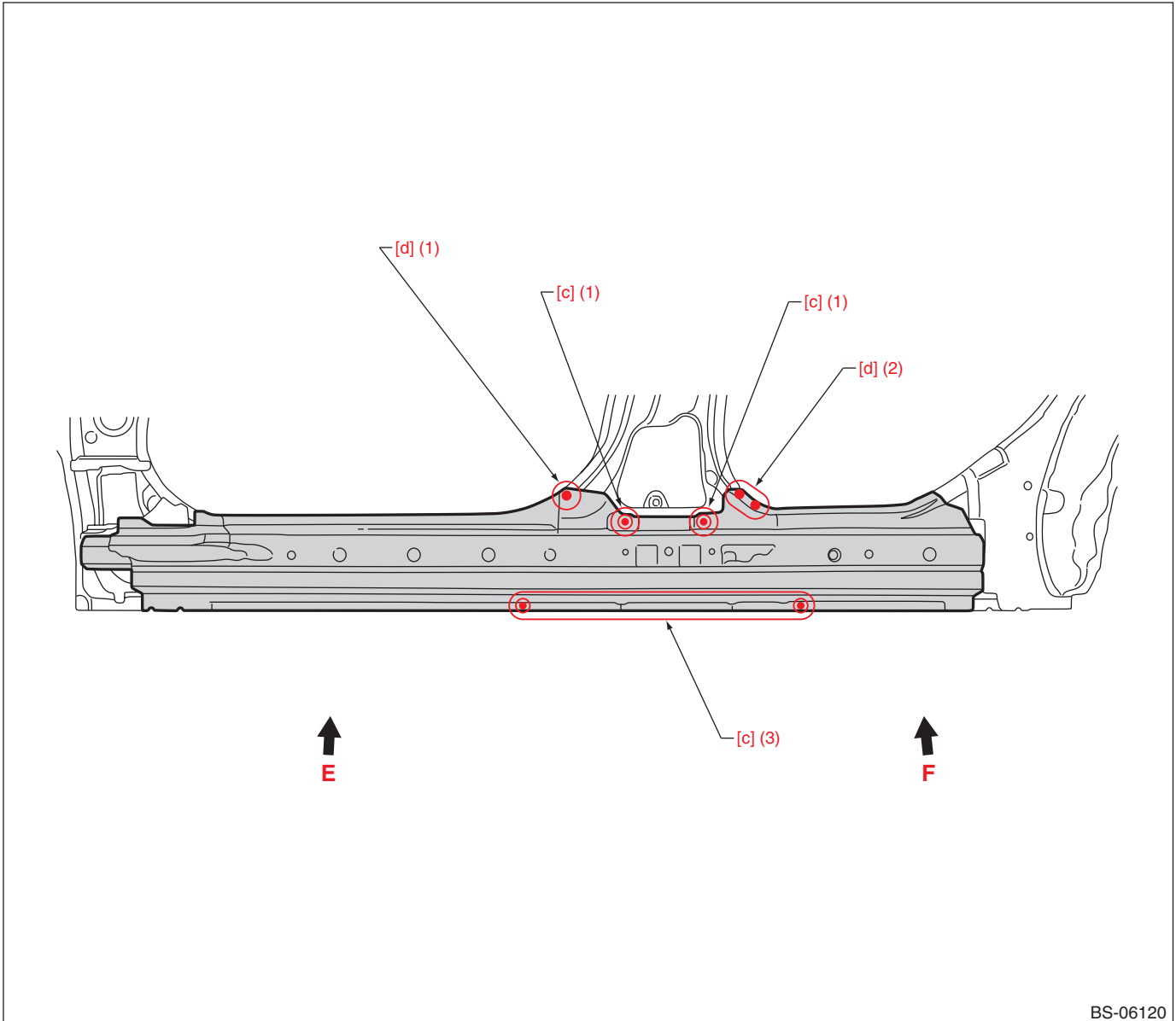


Panel Replacement

B: INSTALLATION

• Overall view



BS-06120

(1) 1 point

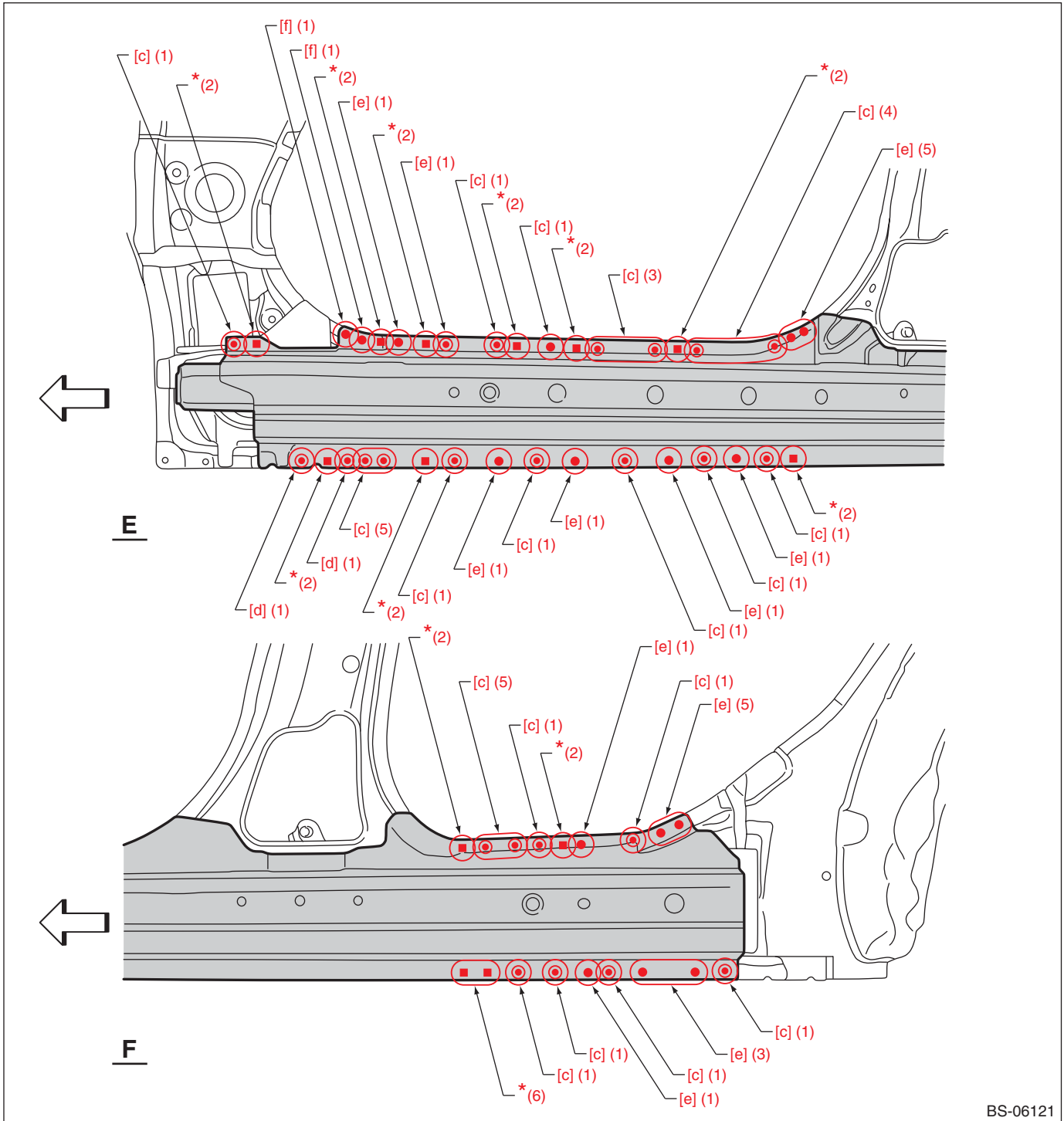
(2) 2 points

(3) 10 points

[c] Spot welding conditions	Compression: 3.0 kN, Current: 6.5 kA, Welding time: 25 cyc
[d] Spot welding conditions	Compression: 3.5 kN, Current: 7.0 kA, Welding time: 25 cyc

Panel Replacement

• Views



BS-06121

(1) 1 point

(2) 1 point (service)

(3) 3 points

(4) 6 points

(5) 2 points

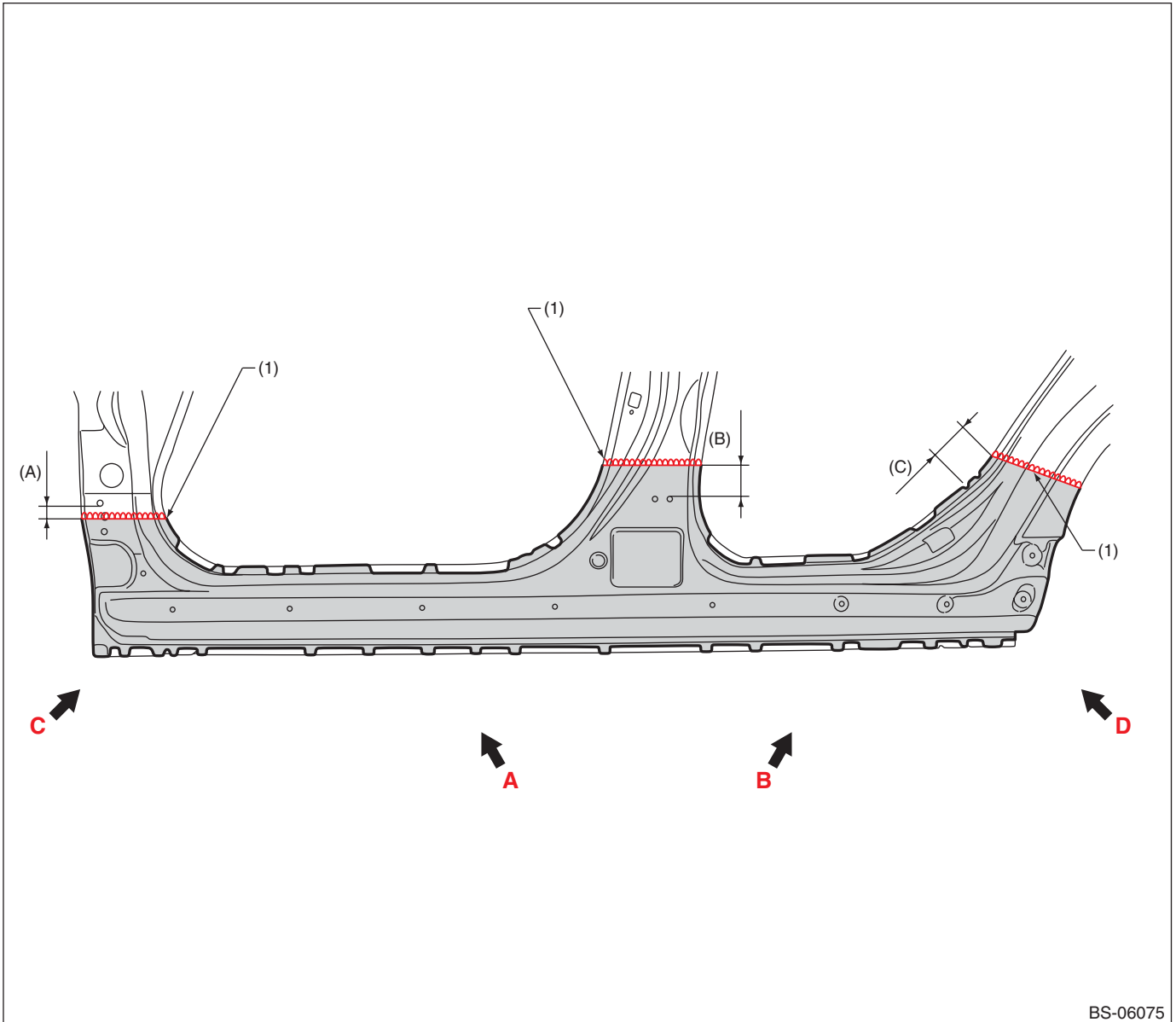
(6) 2 points (service)

[c] Spot welding conditions	Compression: 3.0 kN, Current: 6.5 kA, Welding time: 25 cyc
[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
[f] Spot welding conditions	Compression: 4.4 kN, Current: 8.0 kA, Welding time: 20 cyc

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

Panel Replacement

• Overall view



BS-06075

(A) 30 mm (1.18 in)

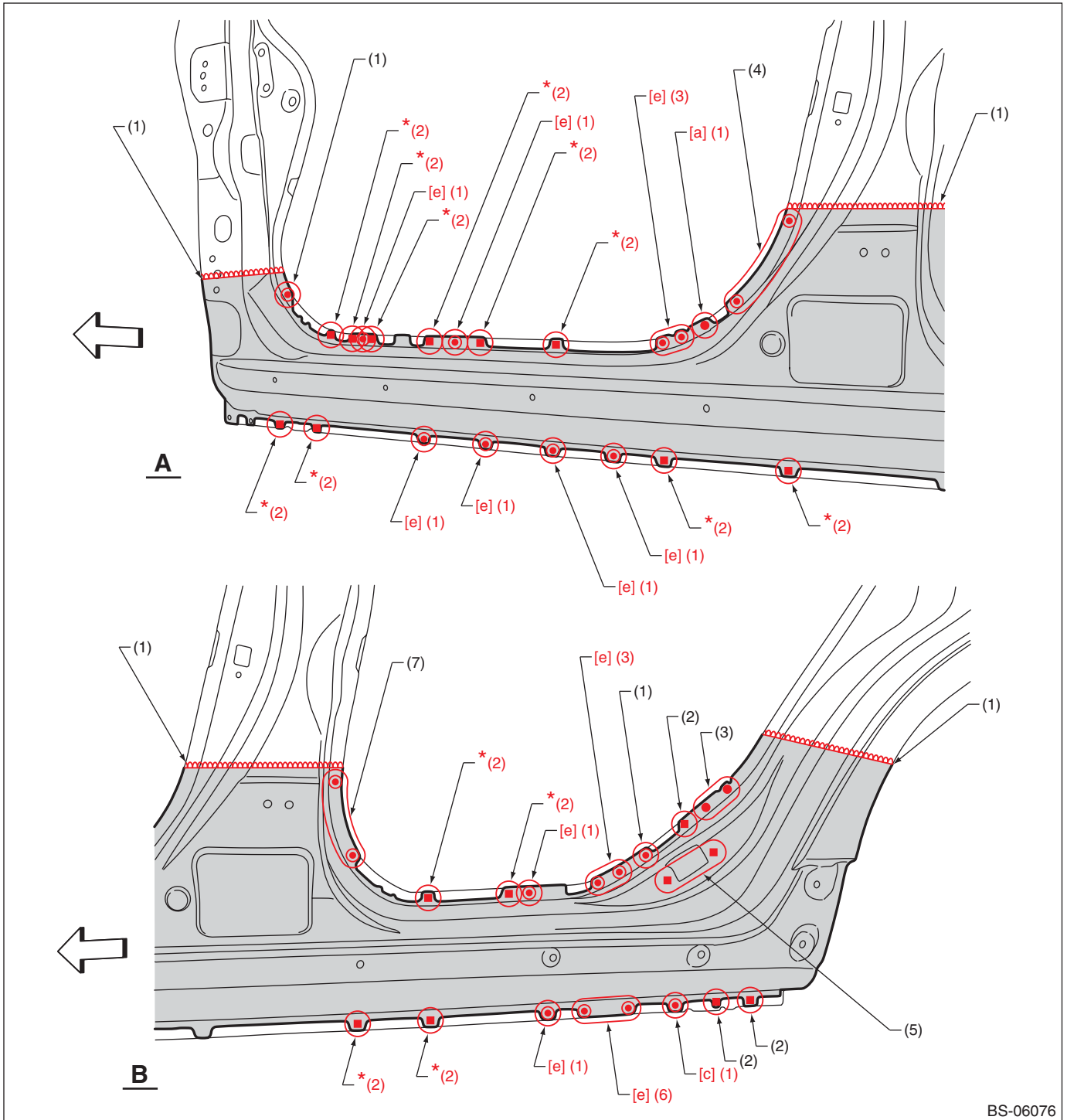
(B) 35 mm (1.38 in)

(C) 50 mm (1.97 in)

(1) 1 point

Panel Replacement

• Views 1



BS-06076

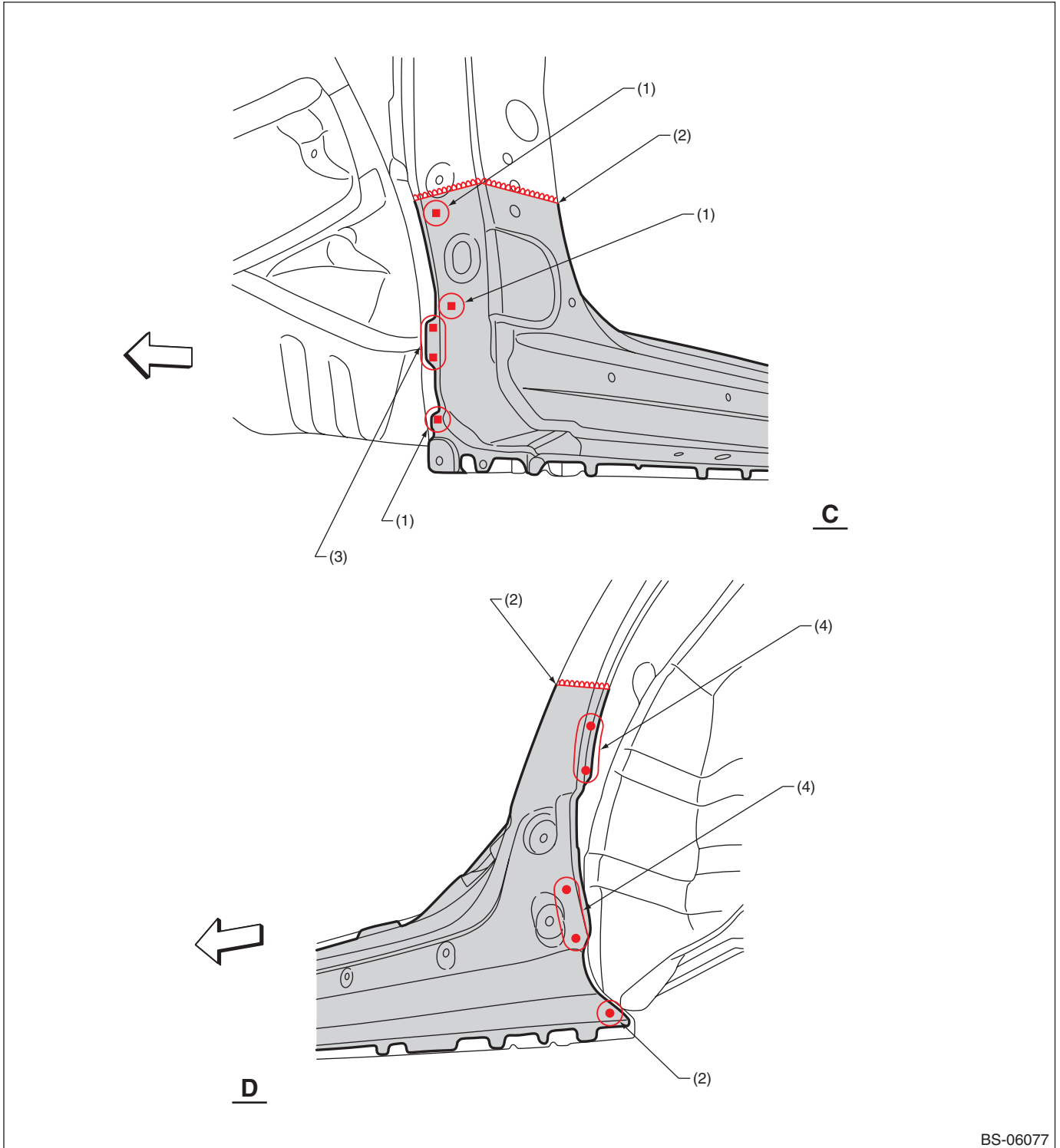
- | | | |
|-----------------------|------------------------|--------------|
| (1) 1 point | (4) 6 points | (7) 4 points |
| (2) 1 point (service) | (5) 2 points (service) | |
| (3) 2 points | (6) 3 points | |

[a] Spot welding conditions	Compression: 3.0 kN, Current: 6.0 kA, Welding time: 15 cyc
[c] Spot welding conditions	Compression: 3.0 kN, Current: 6.5 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 2



BS-06077

(1) 1 point (service)

(3) 2 points (service)

(4) 2 points

(2) 1 point