

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 CLIPSET (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)

QUARTER PANEL (ADD)

QUARTER PANEL, HOODING OUTER PANEL (ADD)

BACK DOOR (INNER), SIDE REINFORCE (CUT)

ROOF SIDE PANEL INNER PANEL (ADD)

BODY LOWER BACK PANEL (CUT)

BODY (LOWER BACK PANEL (ADD)

REAR FLOOR CROSSMEMBER NO. 1 (ADD)

REAR FLOOR PAN (CUT)

REAR FLOOR PAN (ADD)

REAR FLOOR SIDE PANEL (ADD)

REAR FLOOR SIDE PANEL REAR EXTENSION (ADD)

REAR FLOOR SIDE MEMBER (CUT)

REAR FLOOR CROSSMEMBER NO. 2 (ADD)

REAR FLOOR SIDE CENTER MEMBER (CUT)

ROOF RAIL (ADD)

FRAME SIDE RAIL, PLATE (ADD)

FRAME AUXILIARY CROSSMEMBER (ADD)

CAB MOUNTING NO. 1 BRACKET (ADD)

FRAME RAIL CROSSMEMBER (ADD)

FRAME RAIL CROSSMEMBER (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) (sec)
Plug weld	Plug diameter	16 mm (5/8 in)
	Wire type	WELD-AE 16 (GTW16-2)
	Shield gas	Shield active 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 instructions)
	Wire type	WELD-AE 16 (GTW16-2)
	Shield gas	Shield active gas

NOTE

Be sure to use Shield active 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**

A red circular graphic with a gradient, appearing as a partial circle or a thick arc, located to the right of the Toyota Jidōsha Hanbai Kabushiki Kaisha text.

Toyota Prado 2015 Service Manual:

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 Prado Automotive Repair Manual Jeff Killingsworth, John Harold Haynes, 2006-01-01 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 *Workshop Manual for Toyota Land Cruiser* Intereurope, 1969 *Toyota Land Cruiser Petrol and Diesel Automotive Repair Manual* , 2015-07 **Toyota Land Cruiser Australian Automotive Repair Manual** Jeff Kibler, Robert Phillip Maddox, John Harold Haynes, 2000 Series HJ60 61 70 75 HZJ80 HDJ80 Only covers 4 4 2L models Does NOT cover BK or Colorado models *Toyota Land Cruiser Automotive Repair Manual* Jeff Killingsworth, John Harold Haynes, 2005-01-01 **Haines San Mateo County Criss-cross Directory** , 2005 *Toyota Land Cruiser Owners Workshop Manual* John Harold Haynes, Bloomsbury Publishing Plc, Peter Ward, 1982 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 **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 , 1986 *Toyota Land Cruiser (heavy-duty) Repair Manual for Chassis & Body* , 1988 Toyota Land Cruiser Repair Manual Toyota Jidōsha Hanbai Kabushiki Kaisha, 1963 *Toyota Land Cruiser Repair Manual* Toyota Jidōsha Kabushiki Kaisha, 1982 *Toyota Land Cruiser Repair Manual* Toyota Jidōsha Hanbai Kabushiki Kaisha. Overseas Service Division, Toyota Jidōsha Hanbai Kabushiki Kaisha, 1990 **Toyota Land Cruiser: All Models** , 1971 *HM TOYOTA LAND CRUISER D&P 1980-1998* , 2018 Toyota Land Cruiser Repair Manual Toyota Jidōsha Hanbai Kabushiki Kaisha. Export-Technical Department, 1969 *Detailed Instructions for Repair Toyota Prado 120 in Pictures*. Nigel Oneal, 2016-10-23 Car Land Cruiser Prado manufactured by Toyota since 1987 The cost of the car was not small but comfortable ride excellent off road performance and build quality have made the car very popular The second generation of the family Toyota began to produce in 1996 The car was named the Toyota Prado 90 Repair and maintenance of cars were also held in firm service centers throughout Japan as well as beyond its borders Toyota Prado 90 gained increasing popularity in other countries The third generation of the family of Prado was released in 2002 today it is the most common brands of cars Toyota Prado This generation has been called the Toyota Prado 120 Repair and maintenance of these cars a very common practice in technical

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