



# 2023 KX11 PHEV Body Manual

The manual provides specifications, diagnostics, and repair service information on KX11 PHEV

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## 1.1 Warning

### 1.1.1 Warning

#### 1.1.1.1 Warnings

Servicing a vehicle is a specialized and dangerous work. Failure to receive specialized training related to servicing can increase the risk of injury, property loss, and the inability to properly perform servicing operations. The vehicle servicing procedures recommended in this manual have been carefully developed by professional Geely technicians. This manual is very helpful to technicians who have not been trained by Geely; For technicians who have received our repair training and experience in performing repair operations, this manual is very helpful to reduce the risk. However, all users of this manual should be aware of the minimum safety precautions.

The "WARNINGS" and "CAUTIONS" contained in this manual will alert technicians of average experience to hazards that are not frequently encountered. These "WARNINGS" and "CAUTIONS" must be strictly observed during the servicing of the vehicle to minimize injury or death, and to prevent damage to the vehicle caused by irregularities in servicing and repair, or unsafe conditions remaining in the repaired vehicle. These "WARNINGS" and "CAUTIONS" are not redundant, but are very important reminders. Due to the dangerous consequences of failing to follow the servicing procedures, it is not possible to give all the "WARNINGS, CAUTIONS" in this manual.

The recommended procedures described in this manual are very effective for servicing and repair work. Some of the servicing tools have been specially designed for specific servicing procedures. Service personnel must ensure their own safety and the complete safety of the vehicle when using non-Geely recommended service procedures and special service tools during the servicing procedures.

Replaced parts must be original Geely replacement parts or parts that match the quality of original Geely replacement parts used.

Geely is not responsible for any problems that may arise from failure to use this manual. Causes of these problems include lack of training related to the servicing, use of incorrect tools, use of parts of inferior quality to original Geely replacement parts, and other causes.



## 2.1 Contents

### 2.1.1 Contents

#### 2.1.1.1 Contents

The contents of this manual provide assistance to the body service personnel of the KX11 PHEV, guiding them in the proper performance of body servicing.

In order to properly repair and maintain your vehicle, it is important to have a complete grasp of the contents of this manual. This manual should always be kept within easy reach for quick and easy reference.

Since changes in the contents of the manual affect body repair and maintenance, information to supplement this edition is available from your Geely dealer. This manual should be kept up-to-date.

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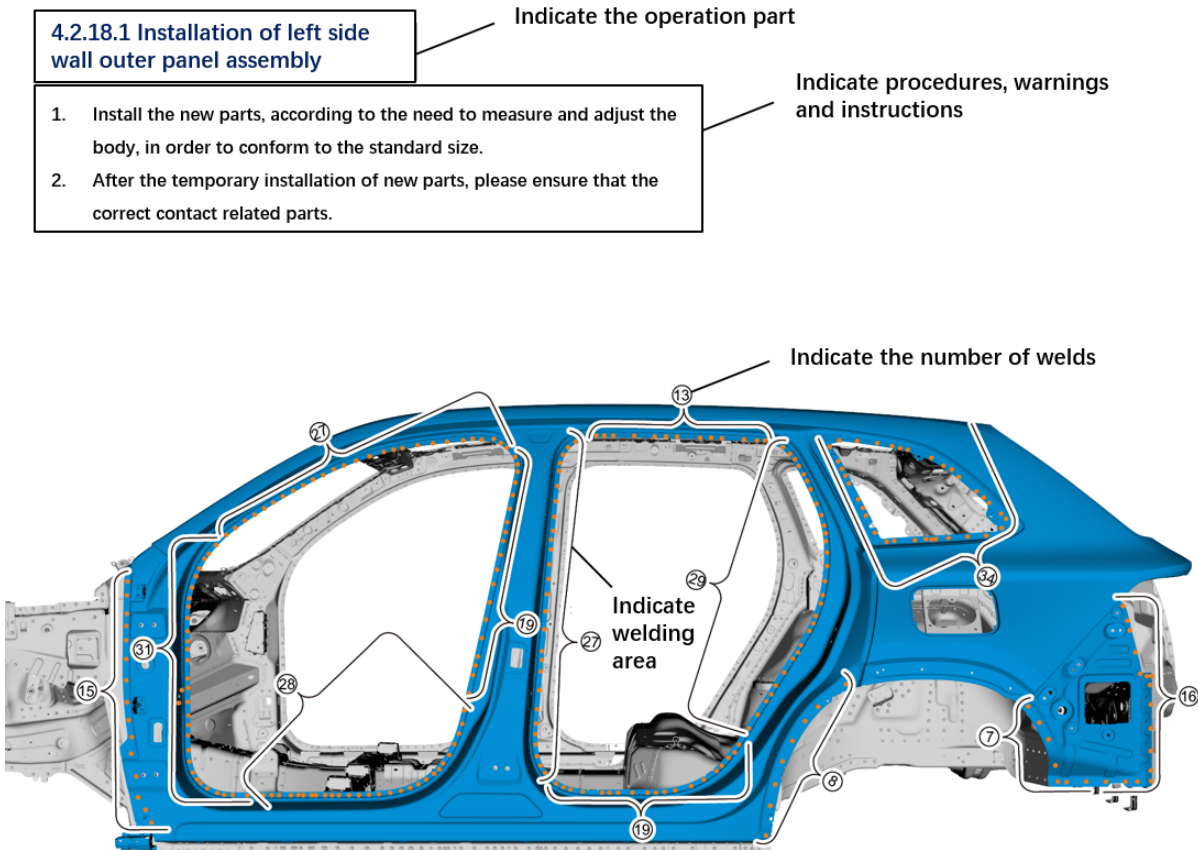
### 3.1 General

#### 3.1.1 How to use this manual

##### 3.1.1.1 Quick Replacement of Body Plates

- This section contains information on body plates that includes the type of welding, number of welding points, and the location of the joints required for sheet metal removal and installation.
- Weld types and locations are indicated by symbols.
- Some sections are accompanied by instructions related to performing this procedure. Read and understand these instructions in detail before performing any procedure.

EXAMPLE





##### 3.1.1.2 Symbols for Board Replacement

Symbols	Meaning
●	Spot welding (two-layer welding)
⬡	Spot welding (three-layer welding)



---

Symbols	Meaning
	Spot welding (four-layer welding)
	CO <sub>2</sub> Shielded Welding

## 3.1.2 Maintenance precautions

### 3.1.2.1 Workshop Organization

- Proper organization of the workshop helps to improve the production safety and increase the work efficiency.

### 3.1.2.2 Safety Precautions

1. Safety helmets and safety shoes must be worn.

Depending on the nature of the work, gloves, protective glasses, ear protectors, face masks, etc. are required.



Welding goggles



Ear protection device



Welding gloves



Safety helmet



Dust cover



Goggles



Mask



Safety shoes



Cotton gloves



Insulation gloves



Insulation shoes



Insulation cap

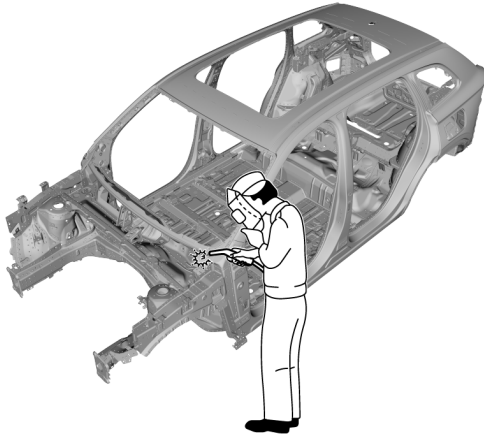
2. Service personnel must wear insulating protective

equipment before operating on energized parts: wear insulating rubber shoes, insulating gloves and insulating caps.

3. Insulating protective equipment must be checked before use to ensure that it is free of damage, hole and crack, is clean and with dry internal and external surfaces, and cannot be operated with water to ensure safety.

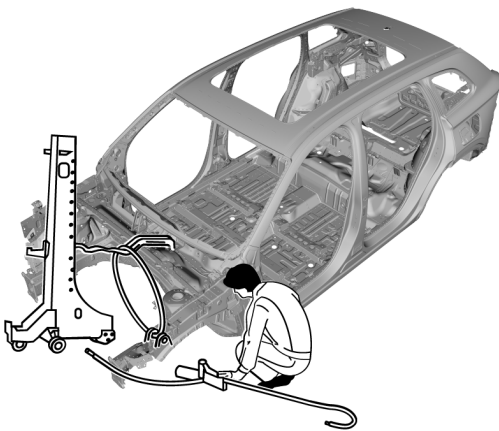
### 3.1.2.3 Vehicle Protection

1. Use seat covers and floor mats.
2. Use insulated covers to protect glass and seats from heat and sparks generated during welding.
3. Protect inserts, decorations and upholstery during welding.
4. Before welding, clean the paint on the part to be welded and use compressed air to clean the surface impurities and expose the sheet metal.



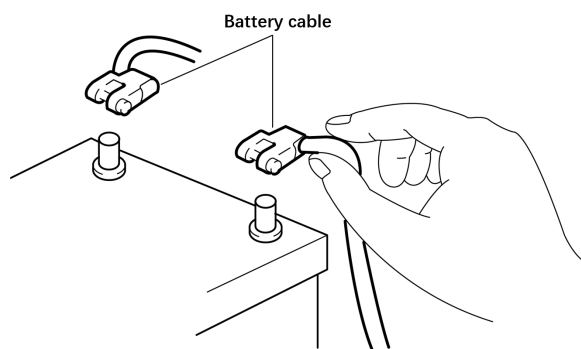
### 3.1.2.4 Using Traction Equipment

- When using traction equipment, stay away from the traction area and use safety wires to prevent accidents.

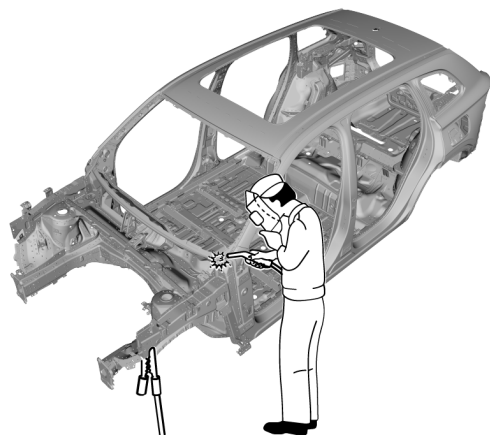


### 3.1.2.5 Preventing Short Circuit

1. Operate the start switch, so that the power supply mode is OFF.
2. Disconnect the positive and negative battery cables.



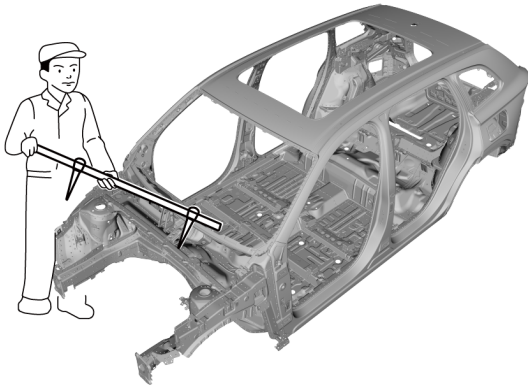
3. Connect the ground wire of the welder securely near the welding part.
4. Connect the ground wire to the body nut of the welding component, which must be free of paint and larger than M6 or above.



### 3.1.3 Quick removal of body panel

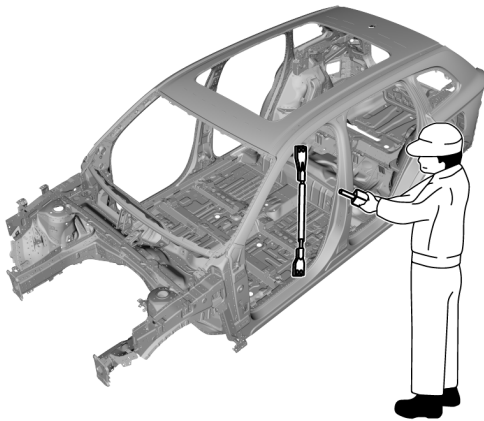
#### 3.1.3.1 Body Measurement

- Prior to carrying out the appropriate body plate servicing, measurements are first taken in and around the damaged area in accordance with standard reference dimensional specifications. If deformation exists, then initial correction is needed to be carried out using frame servicing equipment.



#### 3.1.3.2 Preventing Body Deformation

- Use clamps or jacks for removal and support in and around the location of the part to be replaced to prevent body deformation.



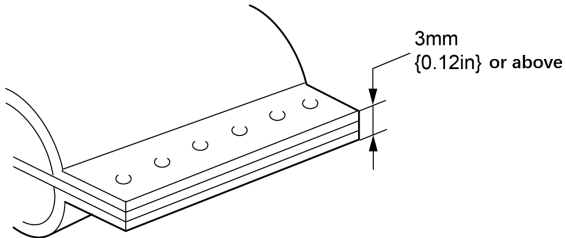
#### 3.1.3.3 Removal of Related Parts

- When removing the related parts, protect the inserts, decorations, and upholstery with straps.

### 3.1.4 Installation preparations

#### 3.1.4.1 Determination of Welding Methods

- If the total thickness of the weld area is 3mm (0.12in) or above, use a CO<sub>2</sub> gas shielded arc welder to perform plug welding.

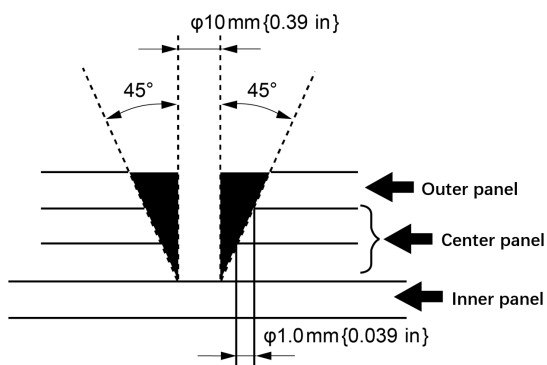


#### 3.1.4.2 Drilling Holes for Plug Welding

1. For areas where the plug welding process is used, use a punch or drill to make holes for CO<sub>2</sub> arc welding.
2. Sand the shaded area shown at left and punch a hole where 3-4 plates are joined together. Also, weld the plates tightly together to avoid gap.

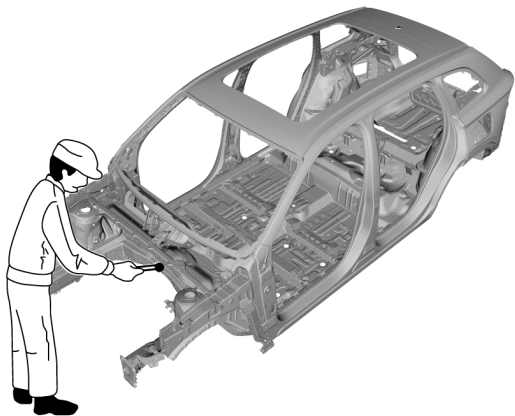
##### Caution

Before plug welding the holes, sand to remove the paint on body surface. After plug welding is complete, sand the plug weld area.



### 3.1.4.3 Spraying of Weld penetration Primer

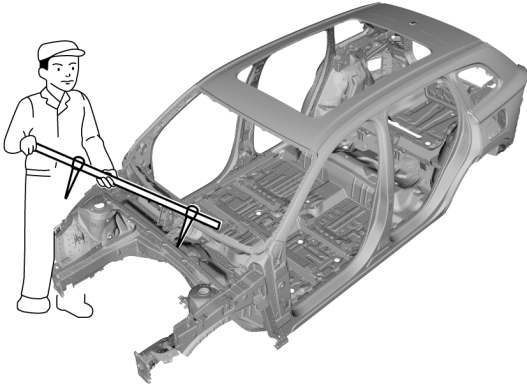
- For corrosion protection, paint, grease and other substances are removed from the new parts to be welded and from the body of the vehicle, and then sprayed with weld penetration primer.



### 3.1.5 Quick installation of body panel

#### 3.1.5.1 Check Pre-welded Dimensions and Observe

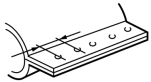
- Align the standard reference dimensions according to the body dimensions schematic so that the new part is installed in the correct position.



#### 3.1.5.2 Welding Precautions

- Regarding the number of welding points, they must be selected according to the following reference standards.

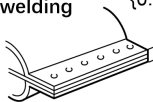
Spot welding  
Initial welding



Repair welding

⇒ The initial number of weld number x1.3 or more

CO2 arc welding  
Initial spot welding



If it's 3mm  
{0.12in} or more

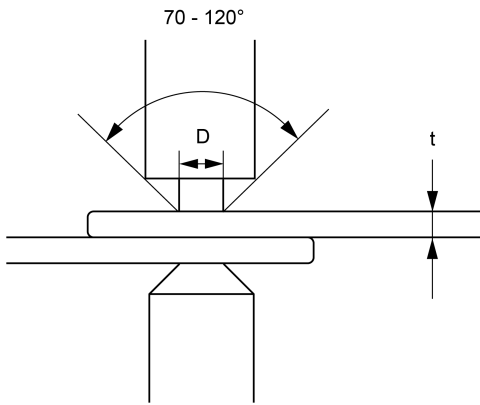
Repair welding

⇒ The initial number of weld number or more



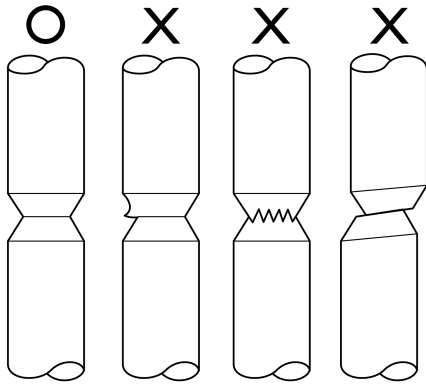
### 3.1.5.3 Spot Welding Precautions

1. The size of the diameter of the welding point is  $D = (2 \times t) + 3$ ; if the thickness of the upper plate is different from the thickness of the lower plate, adjust it according to the thin plate.



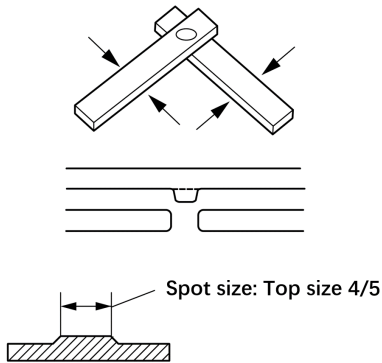
2. Since the welding strength is affected by the shape of the tip of the spot welding, it is necessary to maintain the optimum conditions of the tip.

3. Spot welding should be performed at a location other than the original welding point.



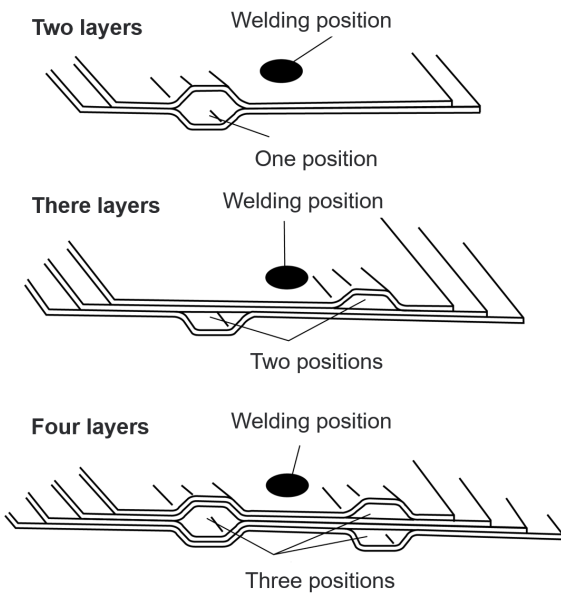
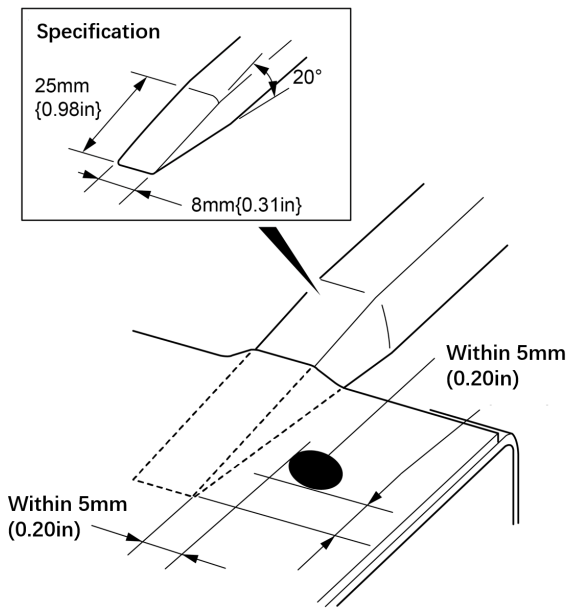
4. Prior to spot welding, test weldings are made using a weldment of the same material and thickness as the body plate to check the strength of the weld.

Method of test artifacts



### 3.1.5.4 Checking Welding Strength

1. Engine, chassis and seat belt mounting locations are important safety locations to ensure welding strength. Check weld strength by wedging a chisel between the plates at every fourth or fifth welding point and at the tenth regular welding position.

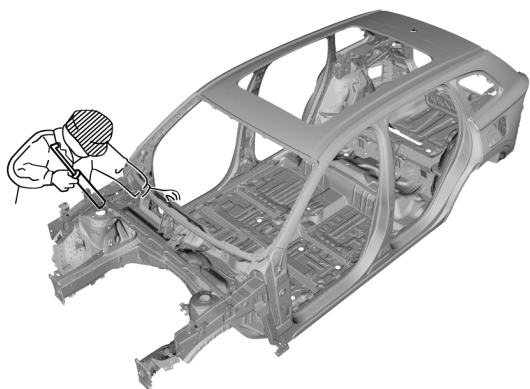


2. Depending on the number of plates, wedge the chisel between the plates.  
 3. Restore the shape of the inspected area.  
 4. To determine the strength of the welding, wedge the chisel between the plates and check if the plates will separate. If the plates separate, then re-weld near the original weld.

### 3.1.6 Corrosion prevention, sound insulation and shock resistance

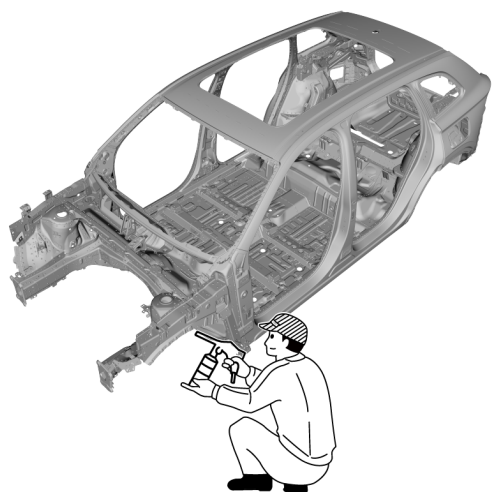
#### 3.1.6.1 Body Sealing

1. Apply body sealant where necessary.
2. Apply body sealant to locations where it is difficult to apply body sealant after installation, and paint it on before installation.



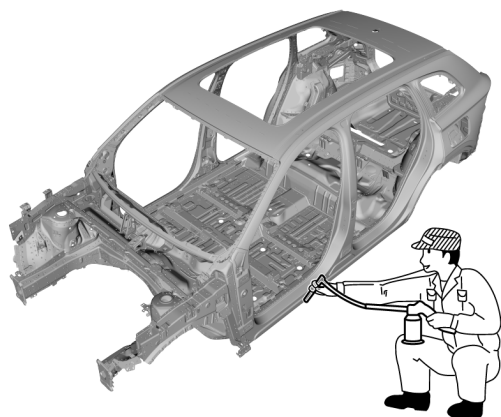
#### 3.1.6.2 Paint of Primer

- Apply primer where needed on the body.



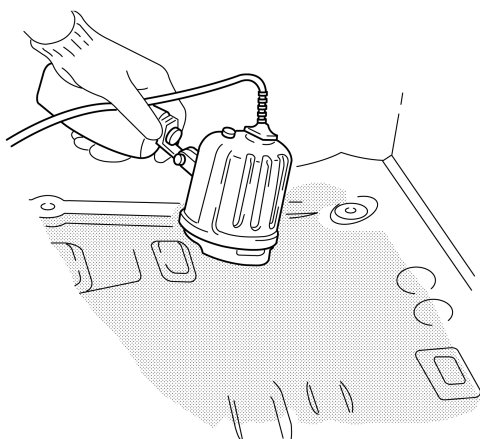
### 3.1.6.3 Apply Rust Inhibitor

- Apply the rust inhibitor (wax, oil, etc.) to the back of the weld area.



### 3.1.6.4 Laying of Soundproofing for Floor

- The soundproofing is applied by heating with infrared lamps.

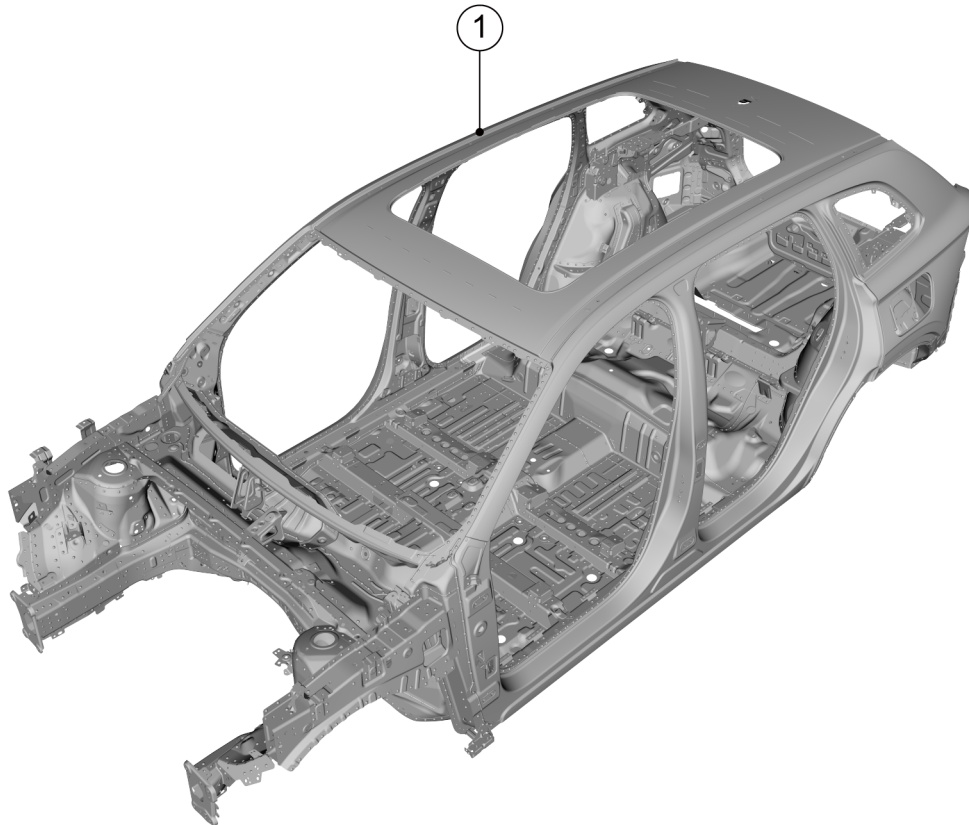




## 4.1 Body structure (structure)

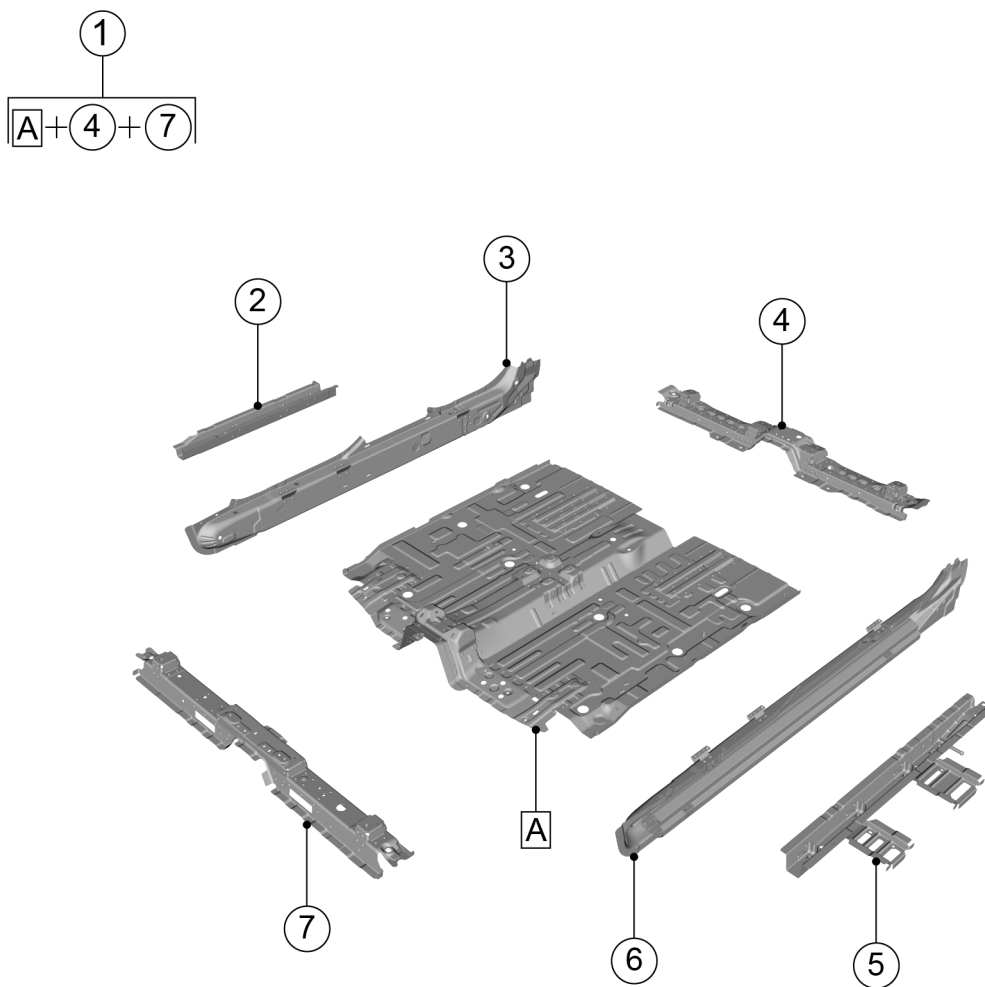
### 4.1.1 Construction of body parts

#### 4.1.1.1 Body-in-white Assembly



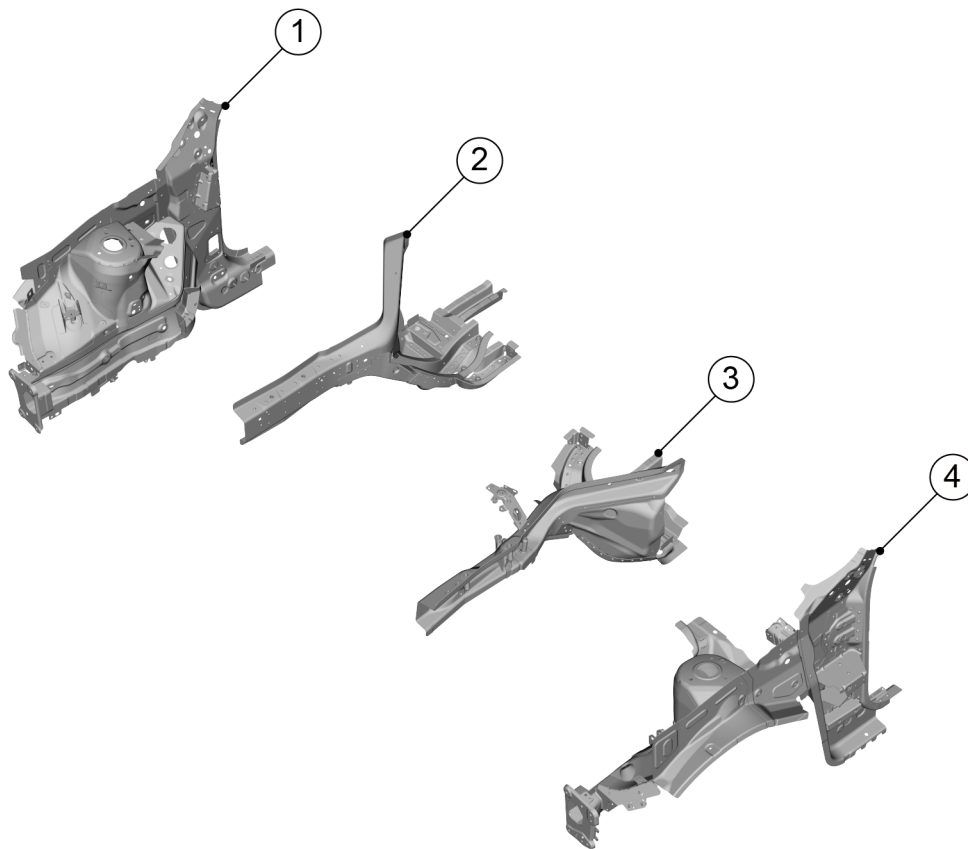
1. Vehicle body assembly

4.1.1.2 Body Front Floor



- |   |  |
|---|--|
| 1. Front floor assembly                               | 5. Front floor left lower longitudinal beam assembly |
| 2. Front floor right lower longitudinal beam assembly | 6. Left door sill inner plate assembly               |
| 3. Right door sill inner plate assembly               | 7. Front seat front beam assembly                    |
| 4. Front seat rear beam assembly                      |  |

### 4.1.1.3 Engine Compartment

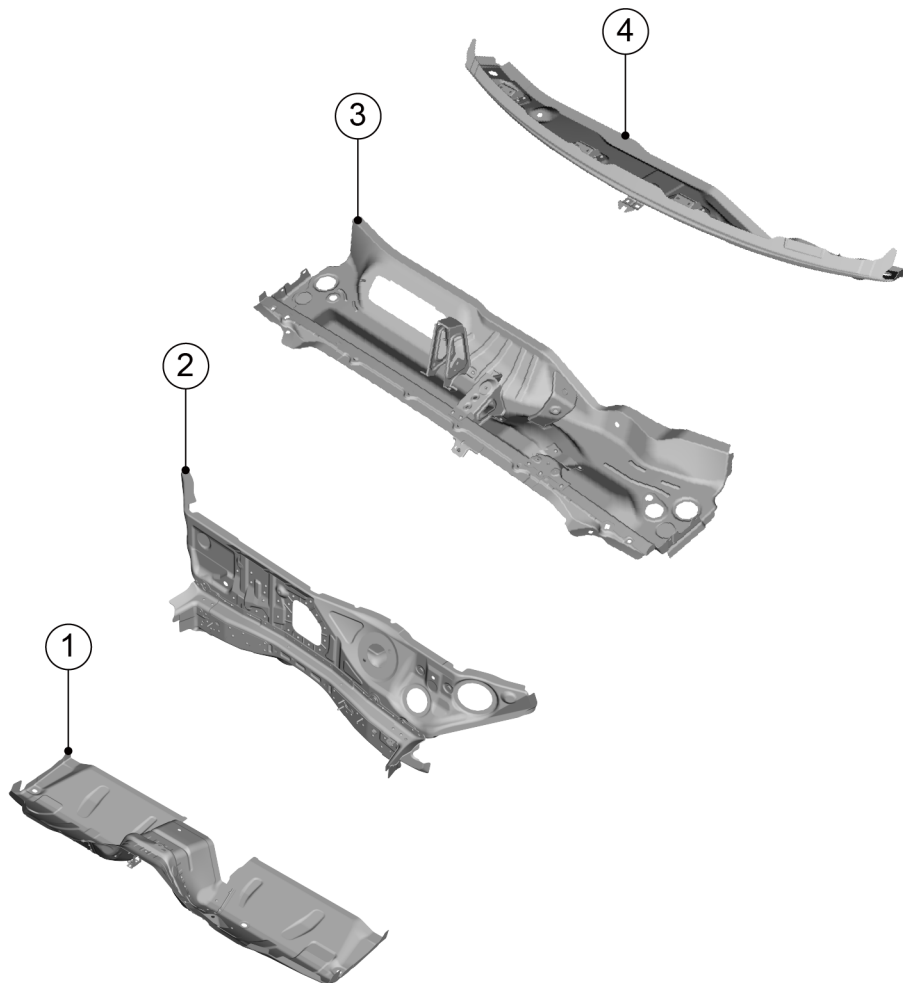


1. Right front wheel cover assembly
2. Right front longitudinal beam assembly

3. Left front longitudinal beam assembly
4. Left front wheel cover assembly



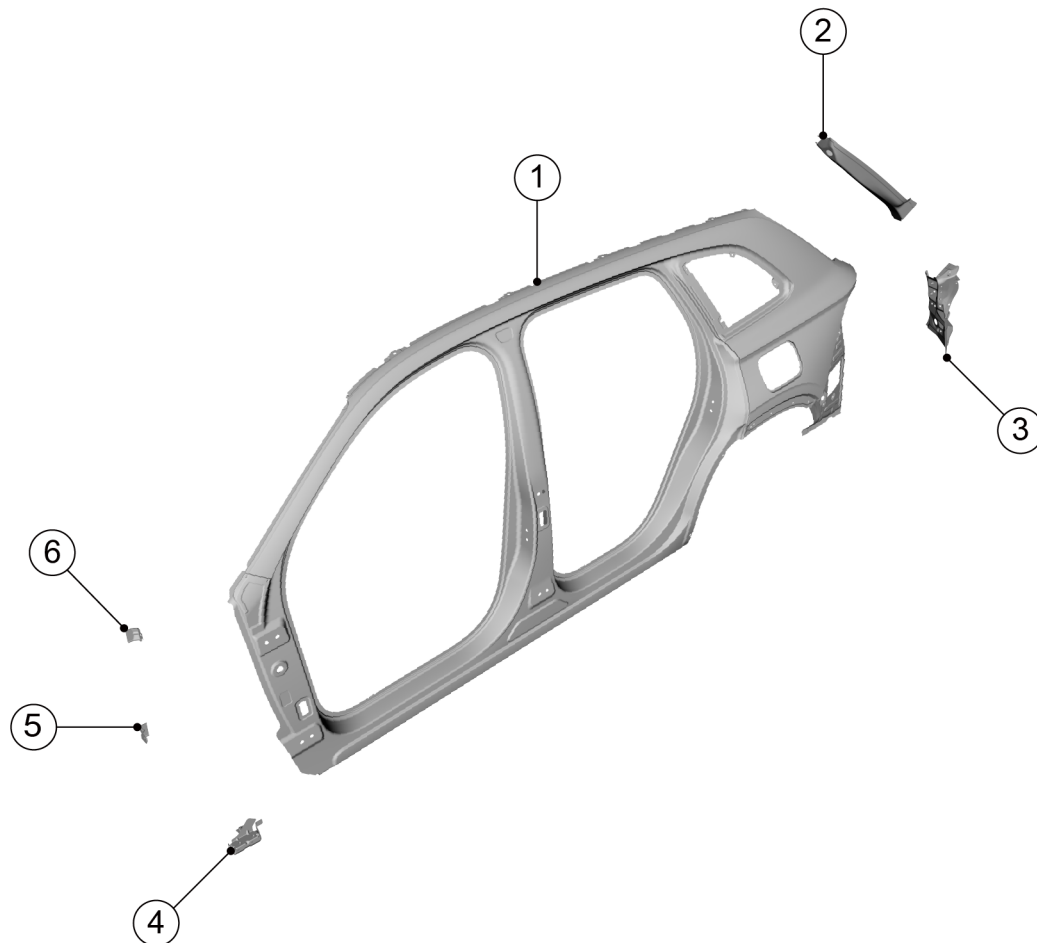
#### 4.1.1.4 Front Enclosure Fence



1. Front enclosure pedal assembly
2. Front enclosure lower plate assembly

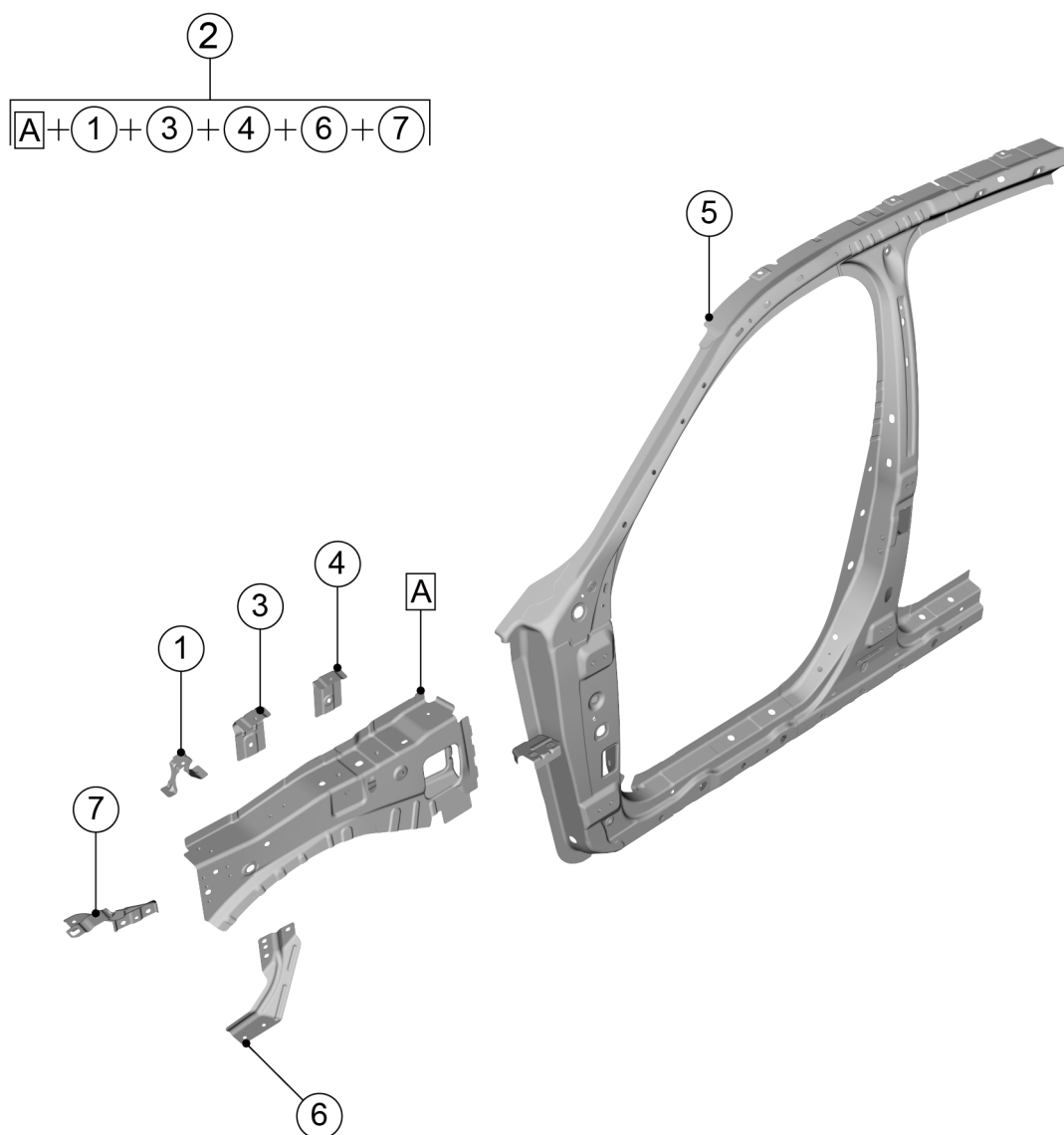
3. Front cabin water channel assembly
4. Front cabin water channel cover assembly

### 4.1.1.5 Side wall



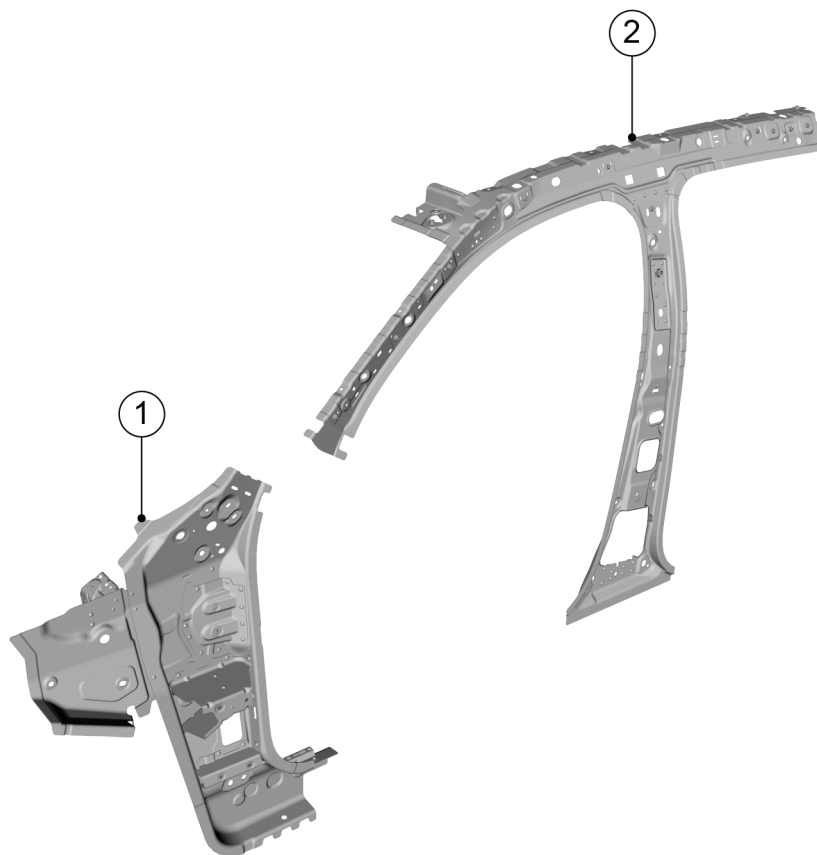
- |    |   |    |  |
|----|---|----|--|
| 1. | Left sidewall outer plate                 | 4. | Wing large bracket assembly (rear lower) |
| 2. | Left sidewall rear water channel assembly | 5. | Wing bracket (rear center)               |
| 3. | Left tail light mounting plate assembly   | 6. | Wing bracket (rear upper)                |

## 4.1.1.6 Body Front Pillar



- |    |   |    |  |
|----|---|----|--|
| 1. | Hood buffer block bracket                     | 5. | Left sidewall front reinforcement plate assembly |
| 2. | Left sidewall front connecting plate assembly | 6. | Wing bracket (front lower)                       |
| 3. | Wing bracket (upper center)                   | 7. | Wing large bracket (upper front)                 |
| 4. | Wing bracket (upper rear)                     |    |  |

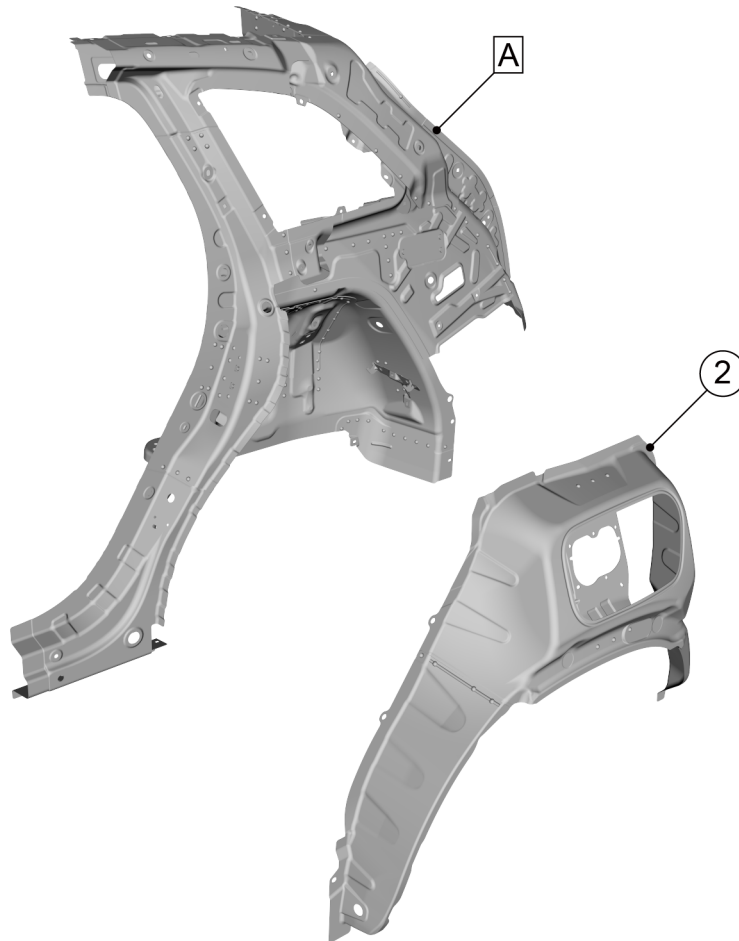
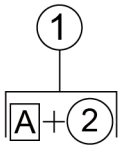
### 4.1.1.7 Body Center Pillar



1. Left A-pillar inner plate assembly

2. Left sidewall front inner plate assembly

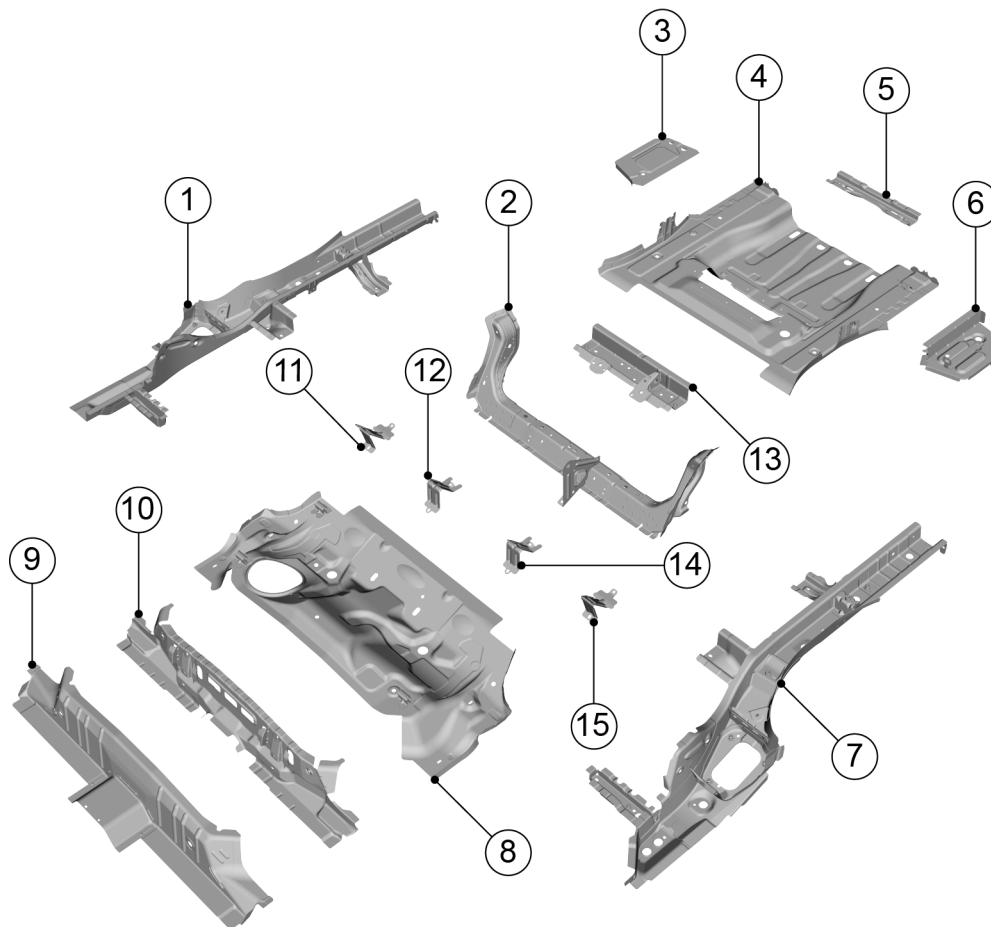
### 4.1.1.8 Body Rear Pillar



1. Left C-pillar assembly

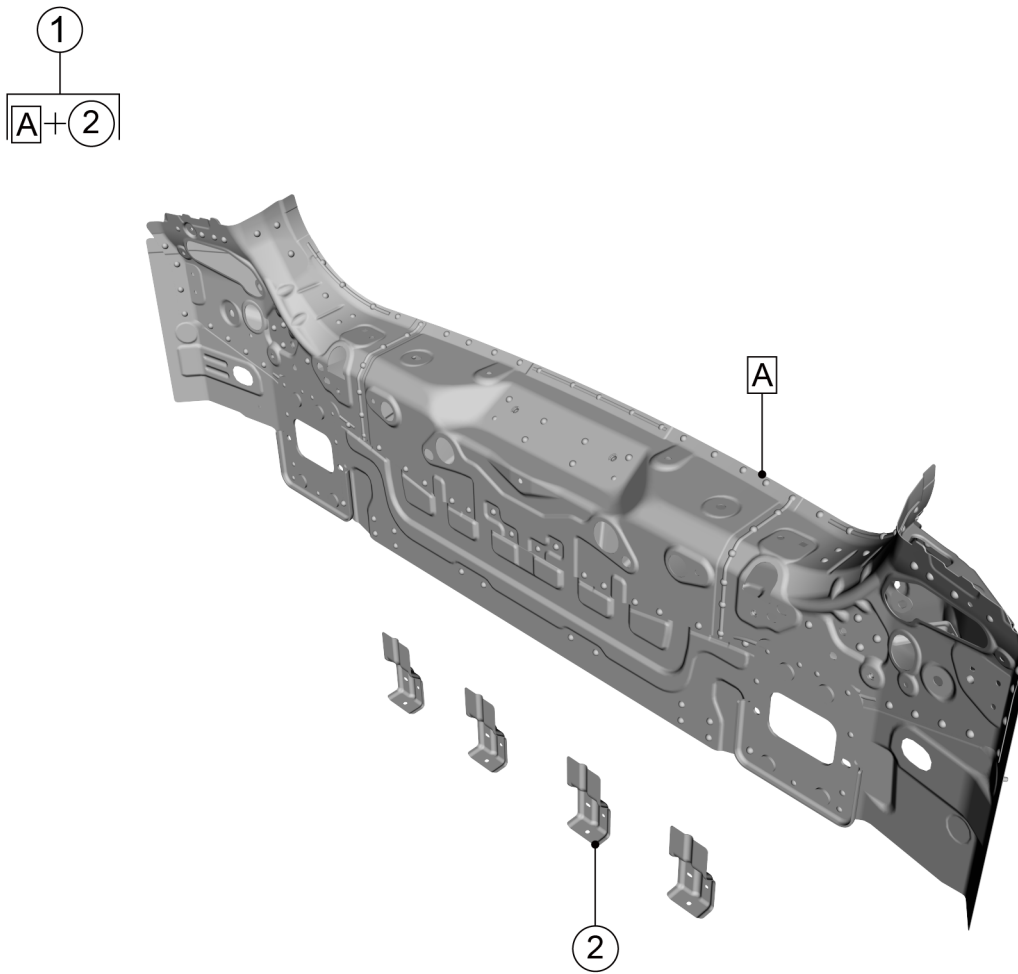
2. Left rear wheel cover plate assembly

## 4.1.1.9 Rear Floor



- |  |   |
|--|---|
| 1. Rear floor right longitudinal beam assembly       | 9. Center floor front connecting plate assembly |
| 2. Rear floor upper beam assembly                    | 10. Center floor lower beam assembly            |
| 3. Rear floor right rear connecting plate            | 11. Child seat outer right bracket assembly     |
| 4. Rear floor body assembly                          | 12. Child seat inner right bracket assembly     |
| 5. Spare tire pool lower reinforcement beam assembly | 13. Center floor lower beam assembly            |
| 6. Rear floor left rear connecting plate assembly    | 14. Child seat inner left bracket assembly      |
| 7. Rear floor left longitudinal beam assembly        | 15. Child seat outer left bracket assembly      |
| 8. Center floor body                                 |   |

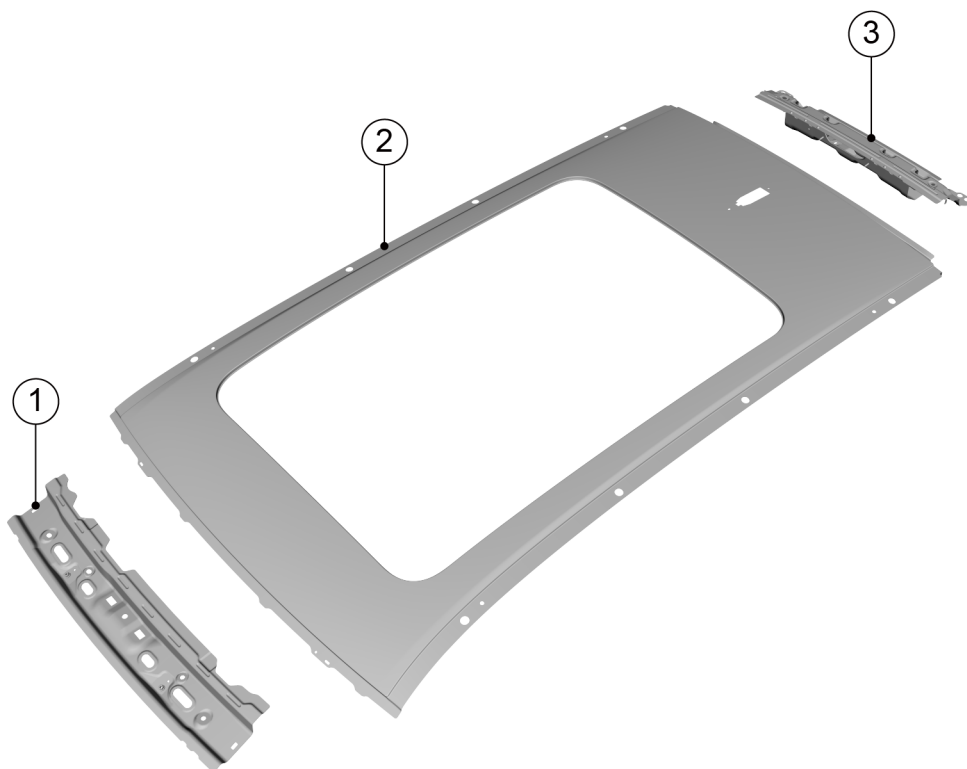
### 4.1.1.10 Rear Enclosure



1. Rear enclosure assembly

2. Rear bumper bracket

### 4.1.1.11 Roof



1. Cover front beam assembly
2. Big sunroof roof cover assembly

3. Cover rear beam assembly



## 4.2 Body structure (replacement of body panel)

### 4.2.1 Removal of the Left Front Wheel Cover Assembly

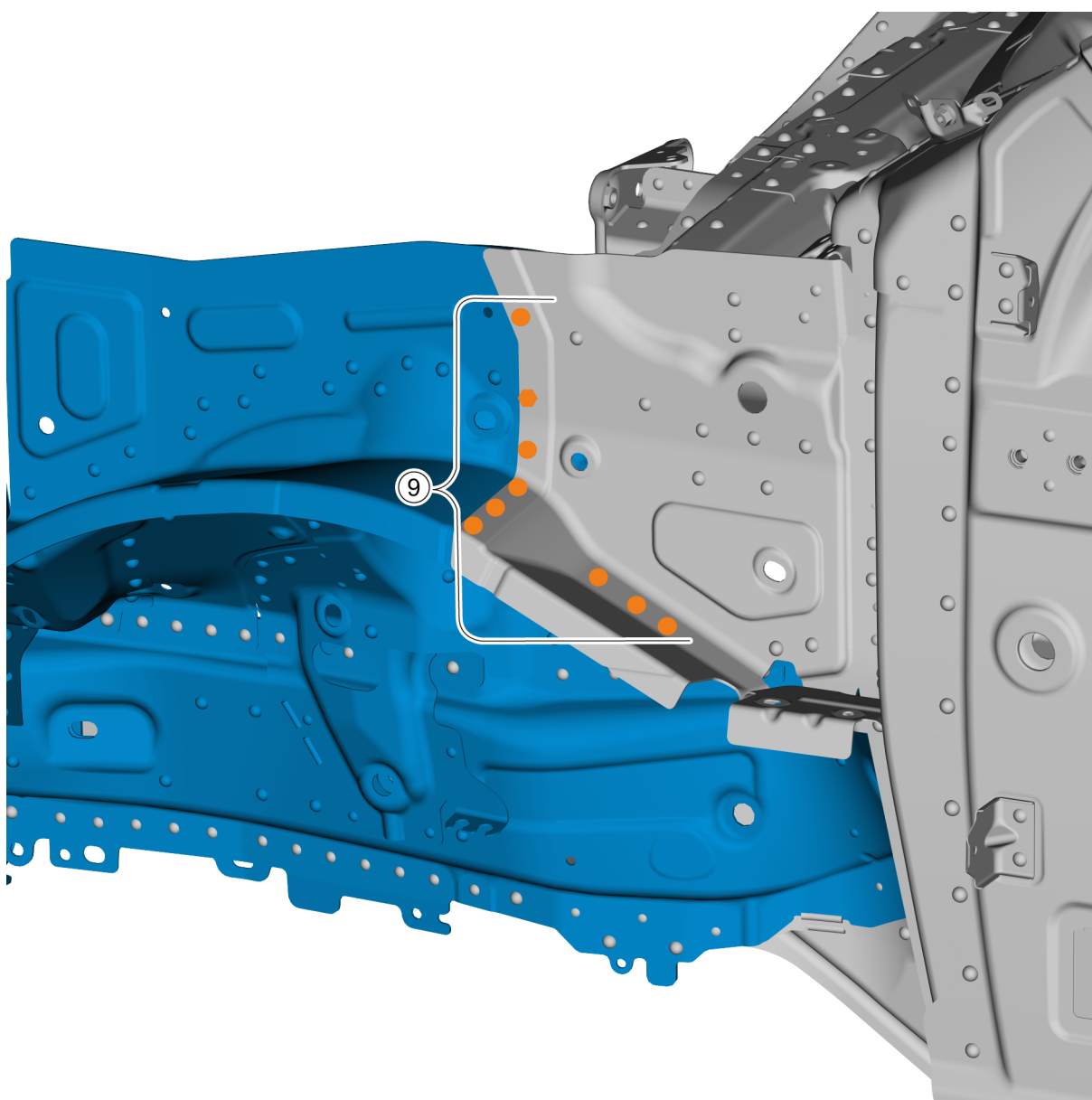
#### 4.2.1.1 Removal of the Left Front Wheel Cover Assembly

Removal of Parts

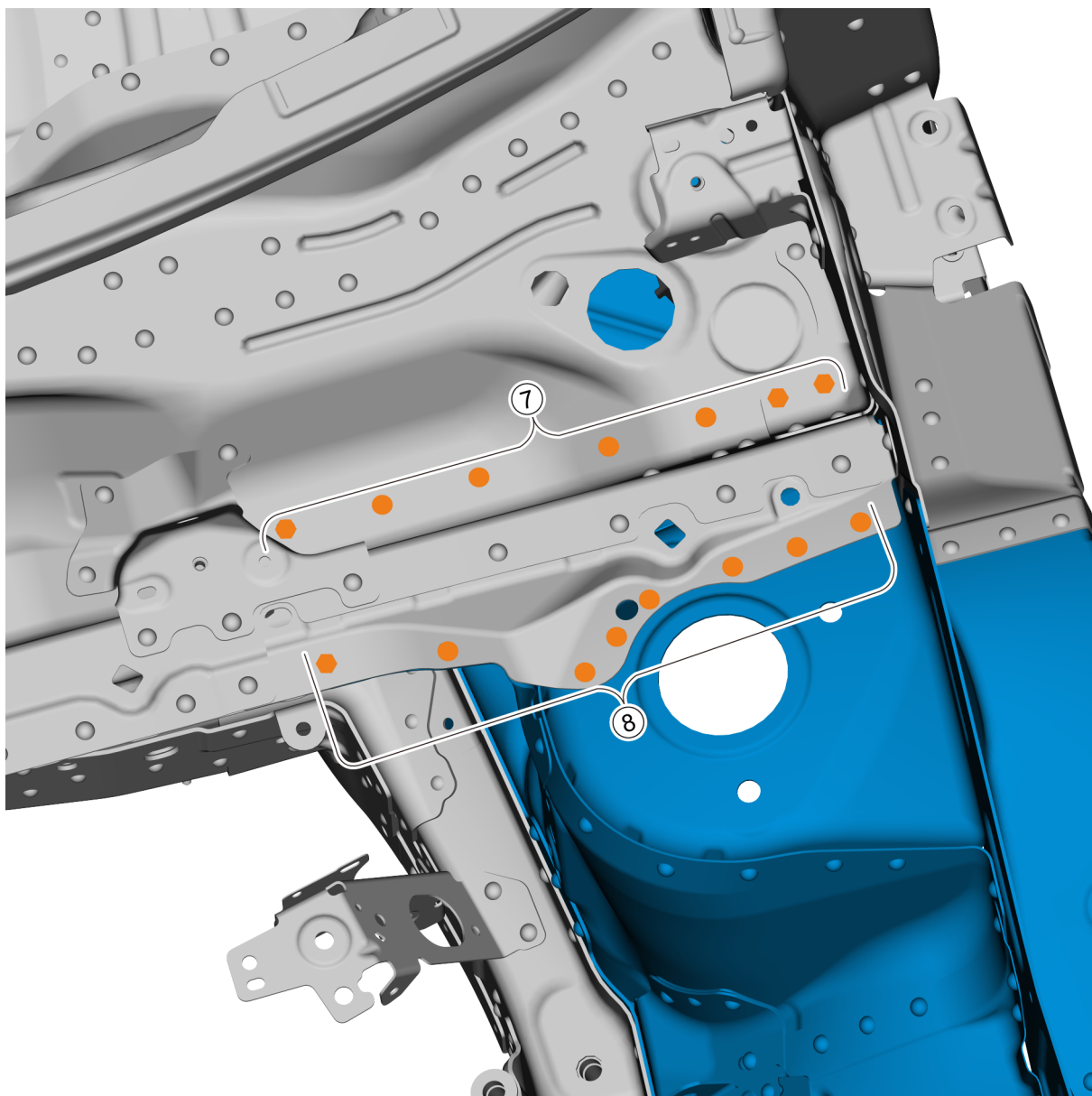
#### Caution

Remove the left and right sides in the same way.

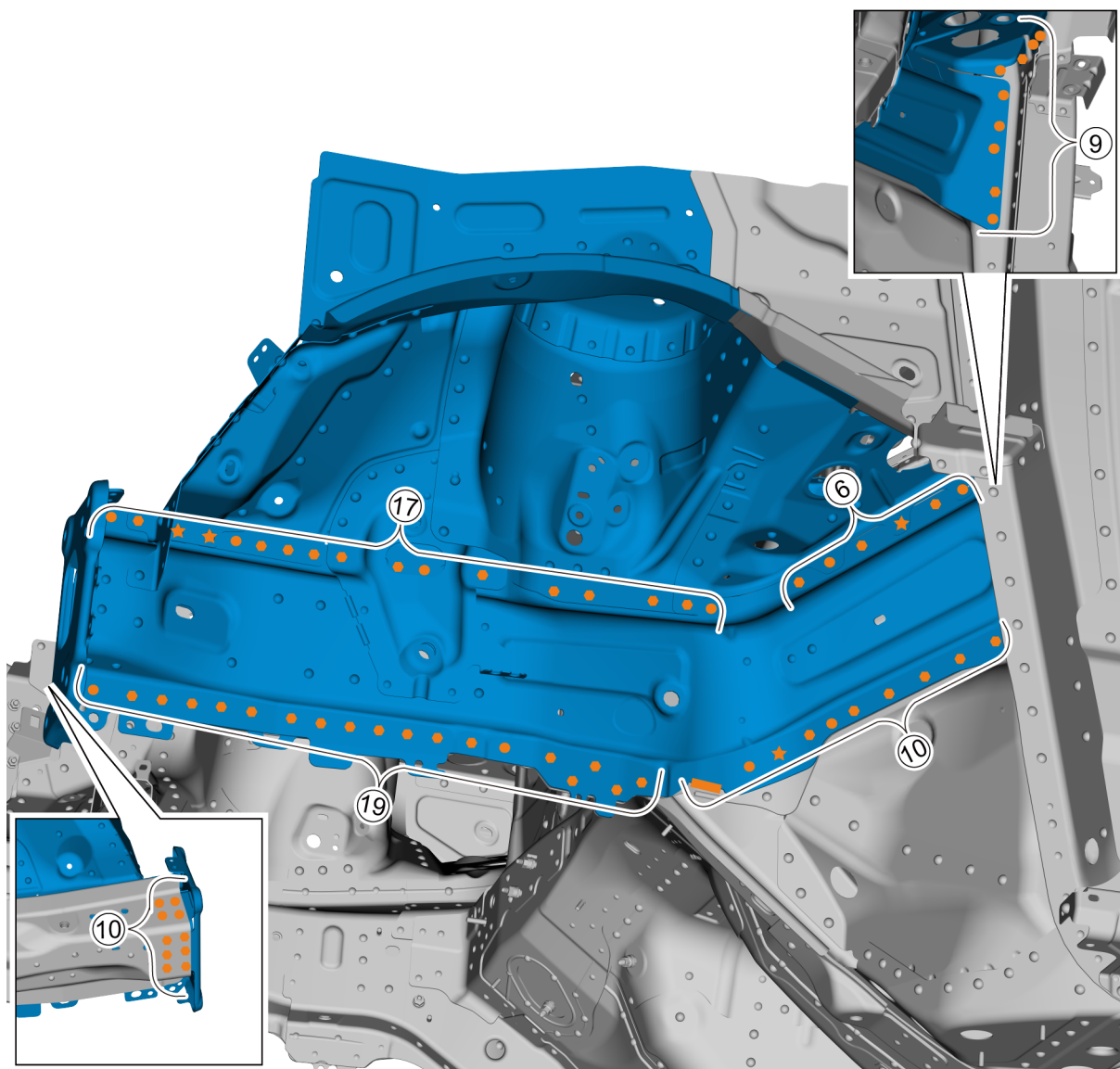
1. Remove the left sidewall front connecting plate assembly, refer to [Removal of the Left Sidewall Front Connecting Plate Assembly](#).
2. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the left front wheel cover assembly to the front cabin water channel assembly.



3. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the left front wheel cover assembly to the left A-pillar inner plate assembly.



4. At the welding positions shown in the figure below, drill out or grind away the welding points and remove the fixing points of the left front wheel cover assembly to the left front longitudinal beam assembly and the left A-pillar inner plate assembly.

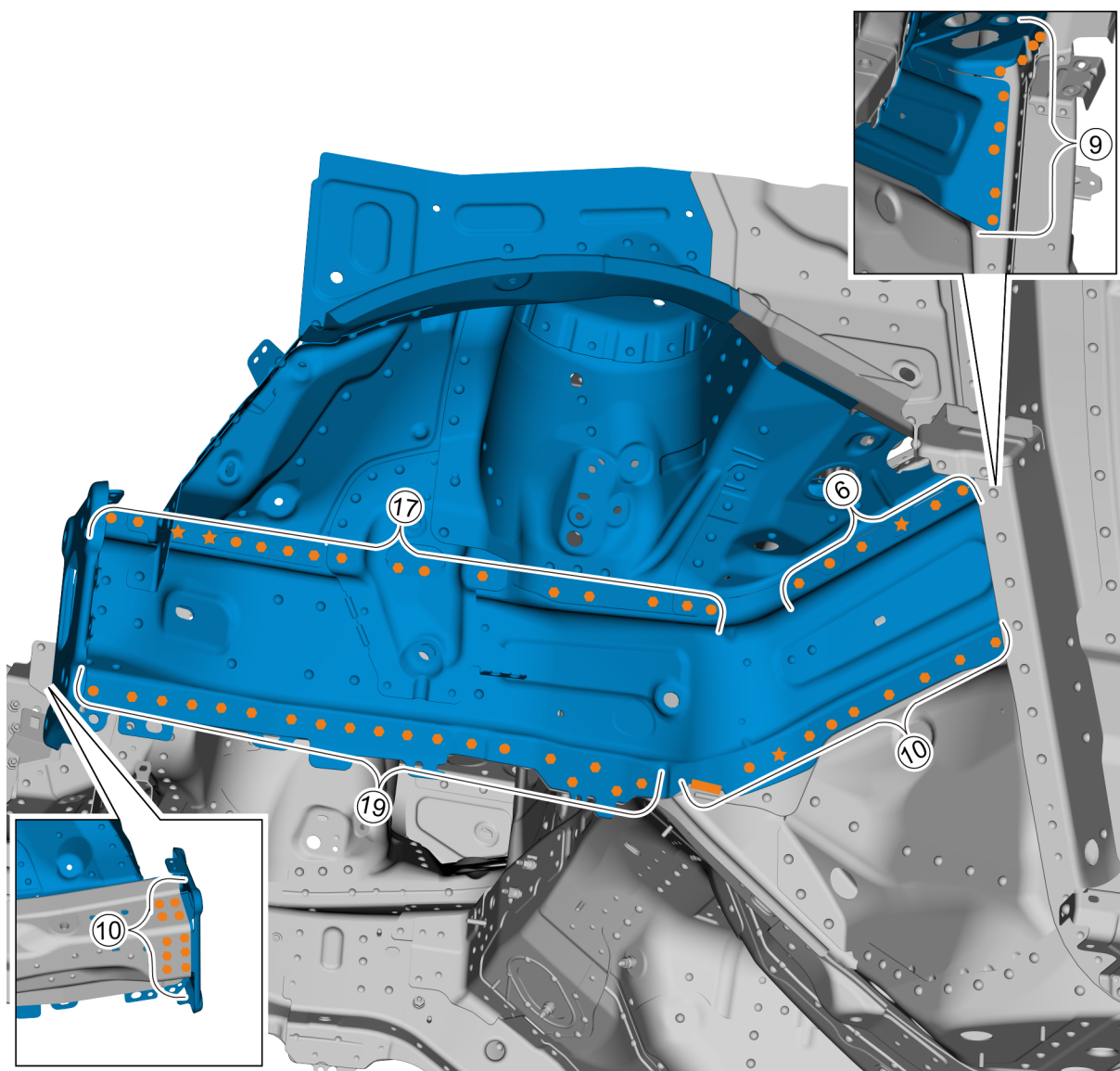


5. Grind away any welding marks that may remain on the body surface, and sand the welded surfaces to bare metal (remove surface foreign matter, paint and rust).

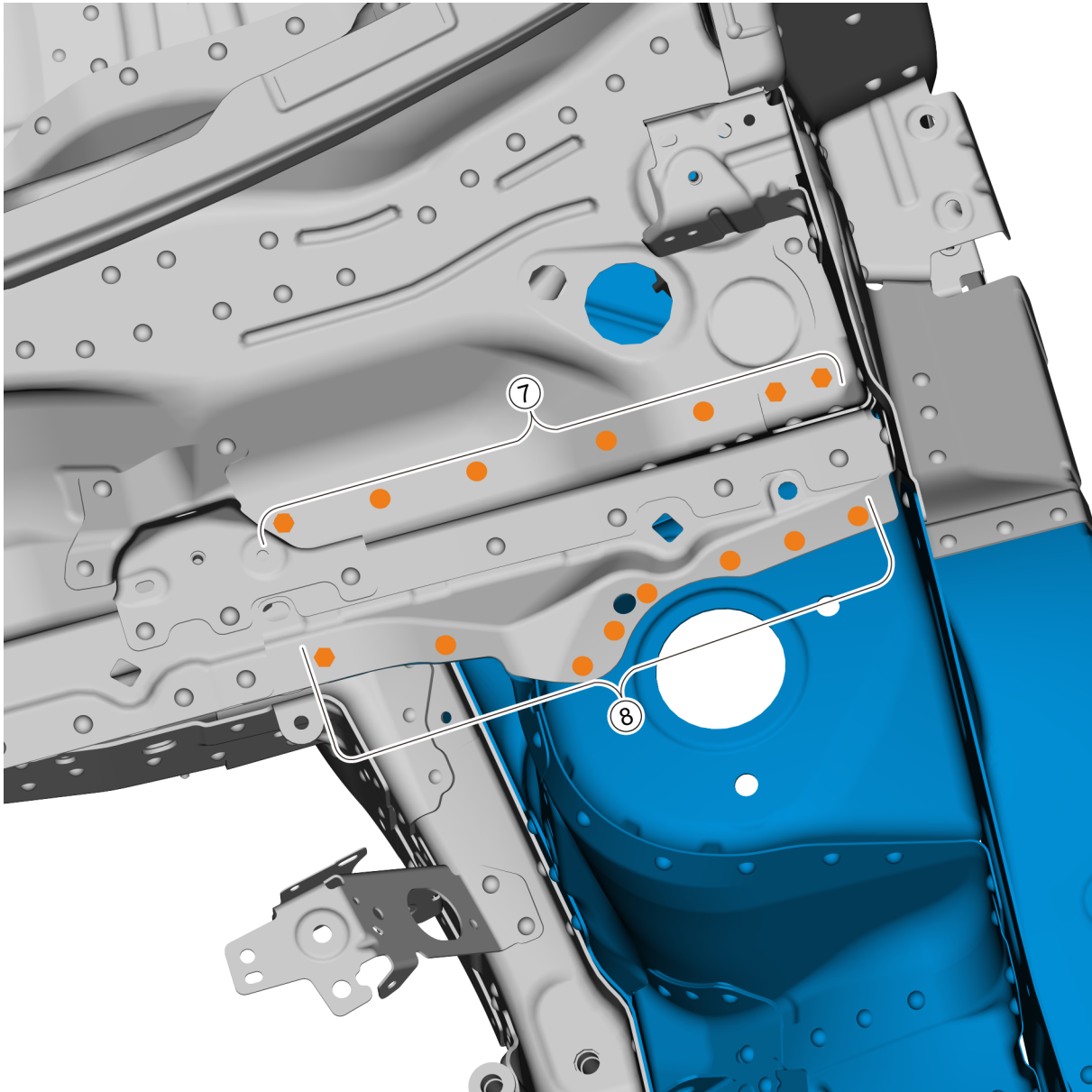
## 4.2.2 Installation of the Left Front Wheel Cover Assembly

### 4.2.2.1 Installation of the Left Front Wheel Cover Assembly

1. When installing a new part, match the mounting position of the new part on the body.
2. Temporarily install the new part for initial positioning.
3. Check and measure the positional dimensions of the left front wheel cover assembly and the body for compliance with the standard, and adjust if necessary.
4. Weld the fixing points of the left front wheel cover assembly to the left front longitudinal beam assembly and the left A-pillar inner plate assembly.

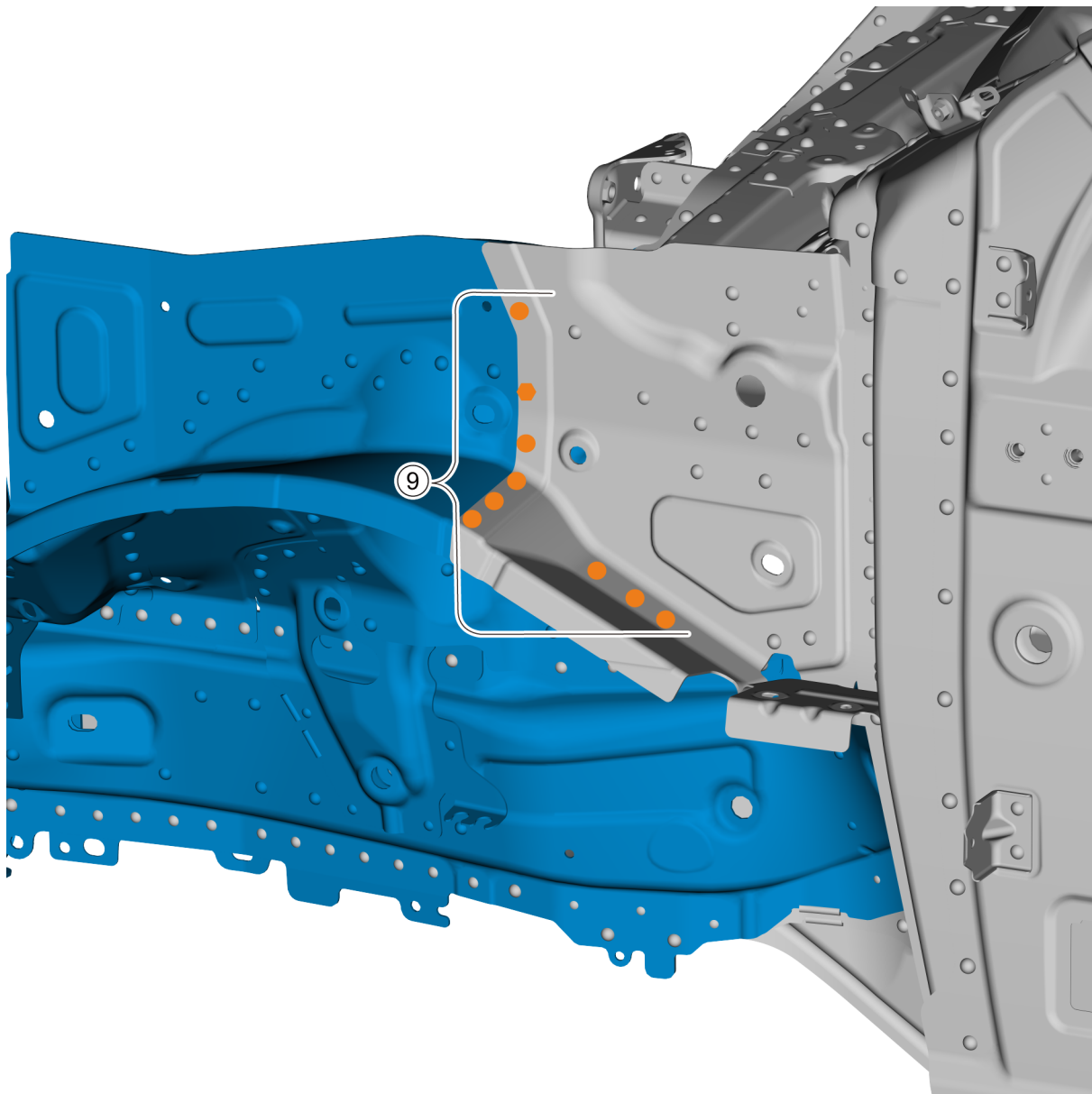


5. Weld the fixing points of the left front wheel cover assembly to the left A-pillar inner plate assembly.





6. Weld the fixing points of the left front wheel cover assembly to the front cabin water channel assembly.



7. Install the left sidewall front connecting plate assembly.

## 4.2.3 Removal of the Left Front Longitudinal Beam Assembly

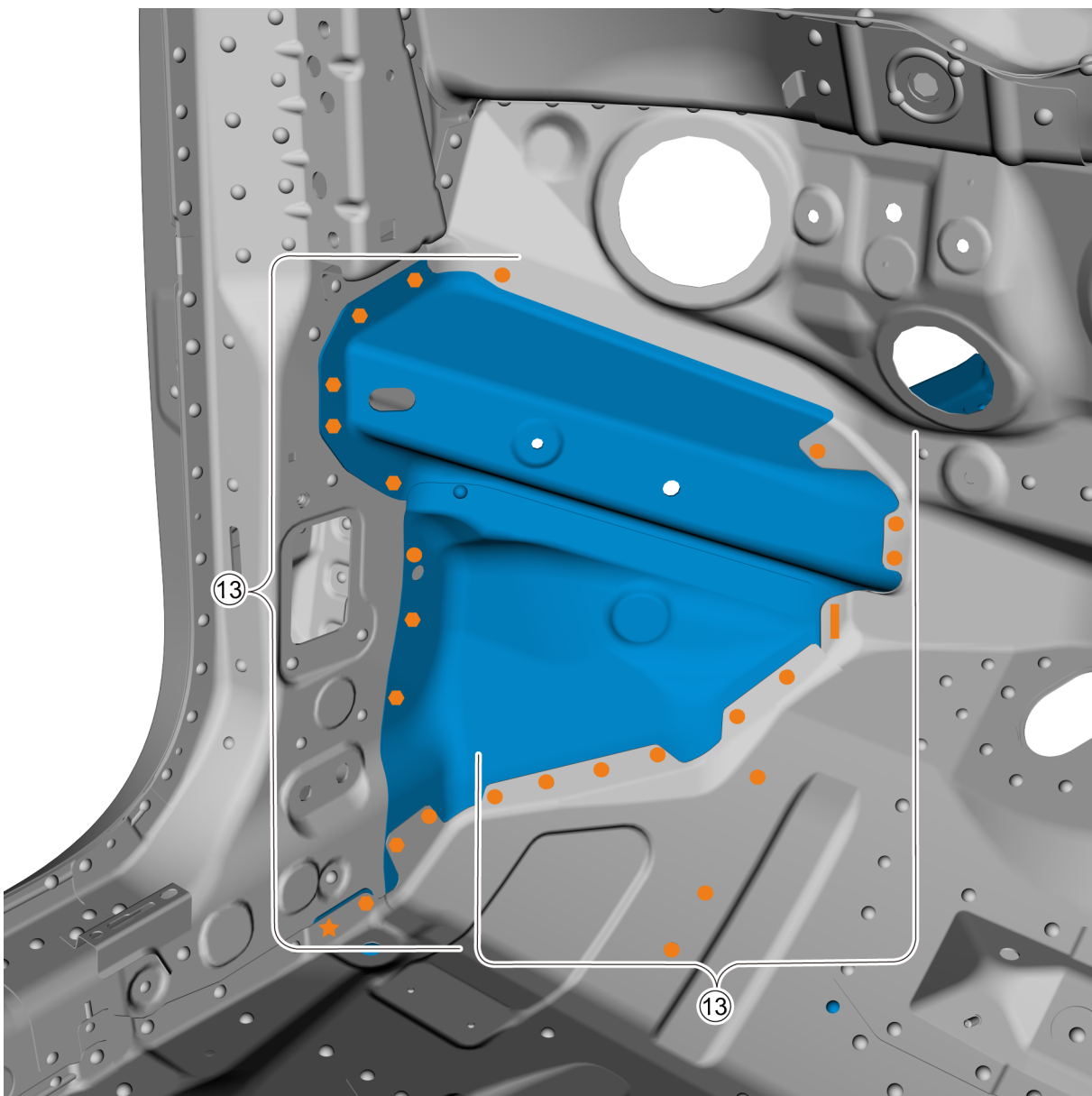
### 4.2.3.1 Removal of the Left Front Longitudinal Beam Assembly

Removal of Parts

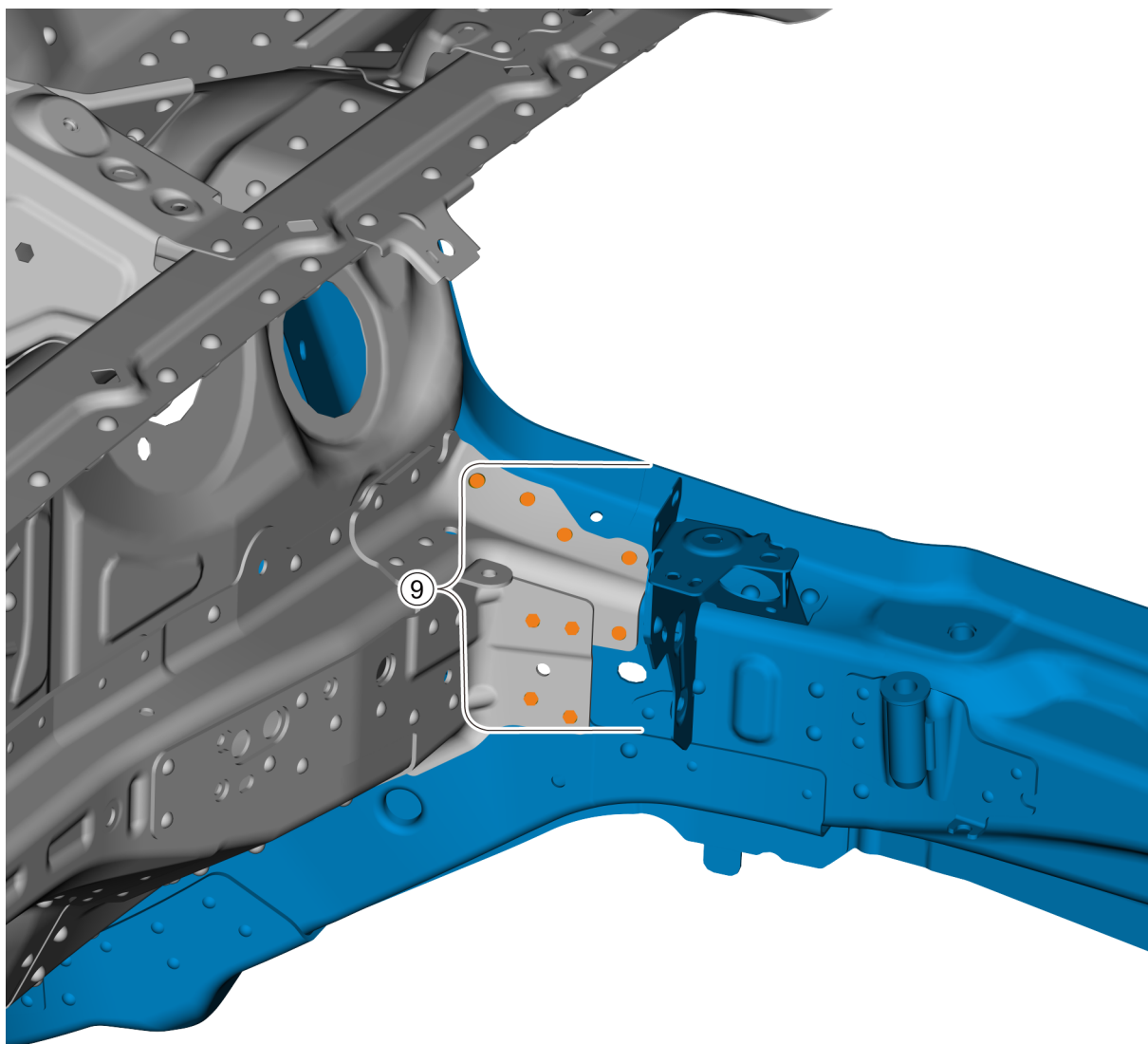
#### Caution

Remove the left and right sides in the same way.

1. Remove the left sidewall front connecting plate assembly, refer to [Removal of the Left Sidewall Front Connecting Plate Assembly](#).
2. Remove the left front wheel cover assembly, refer to [Removal of the Left Front Wheel Cover Assembly](#).
3. At the welding positions shown in the figure below, drill out or grind away the welding points and remove the fixing points of the left front longitudinal beam assembly to the front enclosure lower plate assembly and front enclosure pedal assembly and the left A-pillar inner plate assembly.

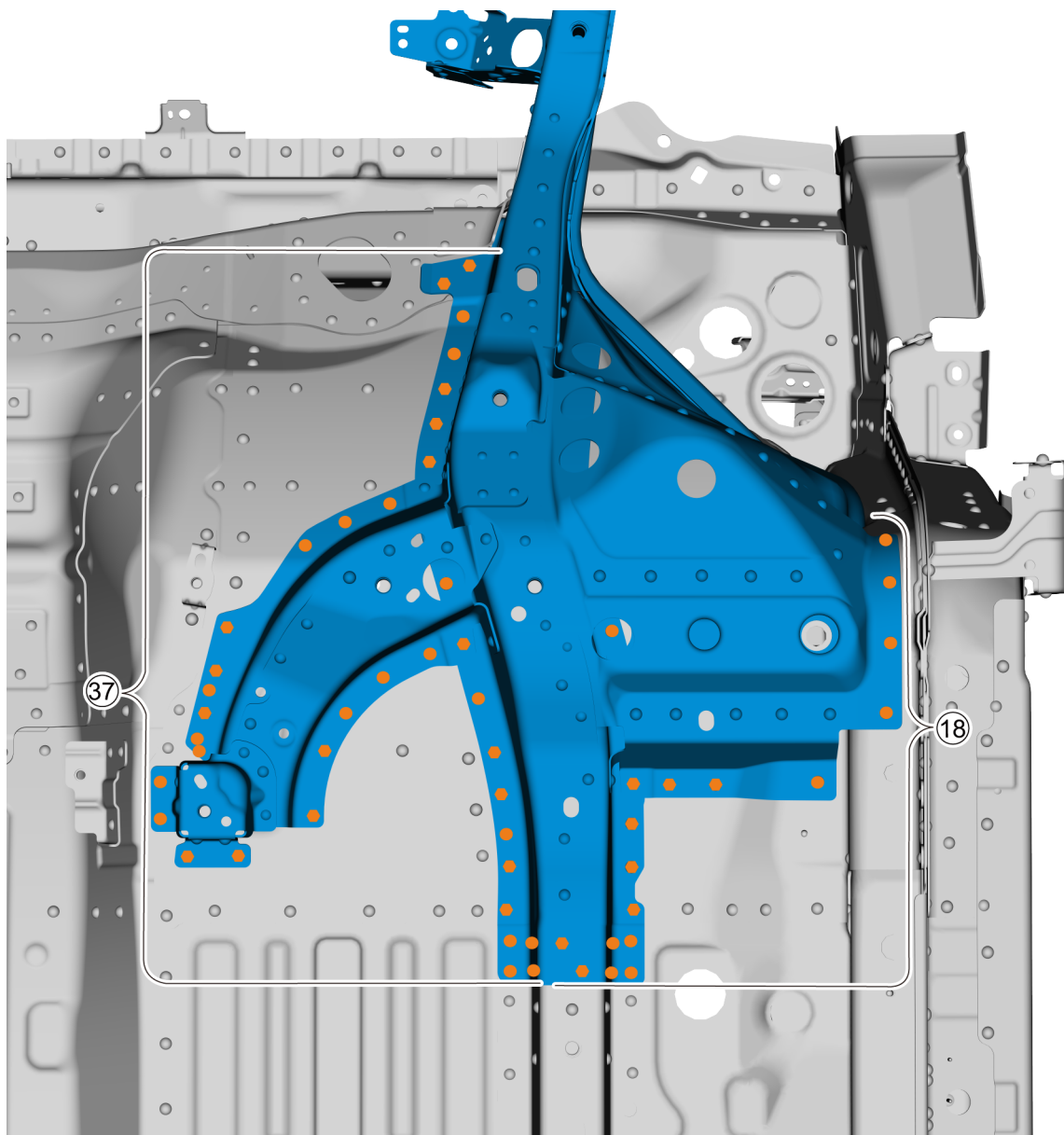


4. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the left front longitudinal beam assembly to the front enclosure lower plate assembly.





5. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the left front longitudinal beam assembly to the front enclosure pedal assembly and the front floor left lower longitudinal beam assembly and front enclosure lower plate assembly.

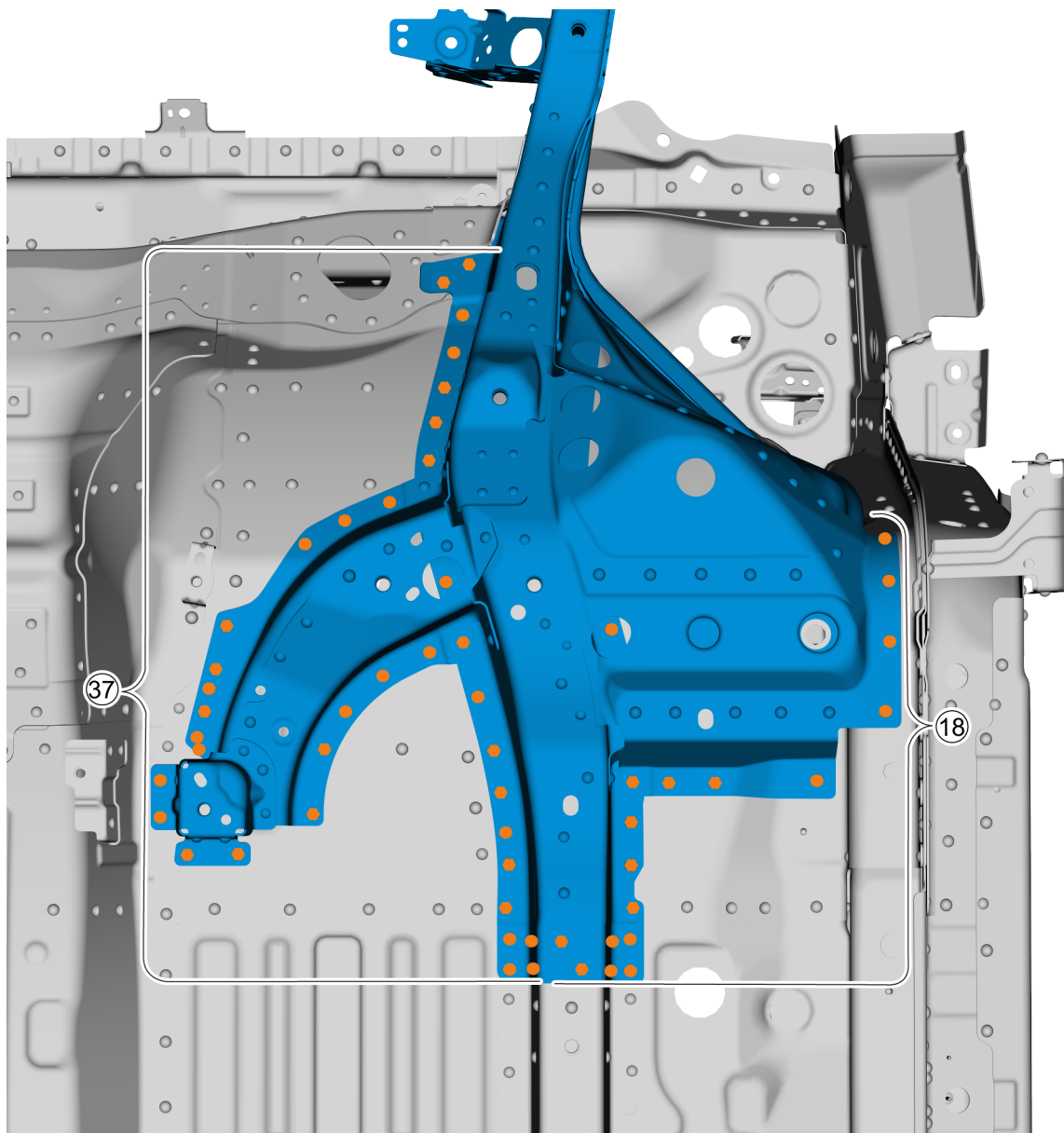


6. Grind away any welding marks that may remain on the body surface, and sand the welded surfaces to bare metal (remove surface foreign matter, paint and rust).

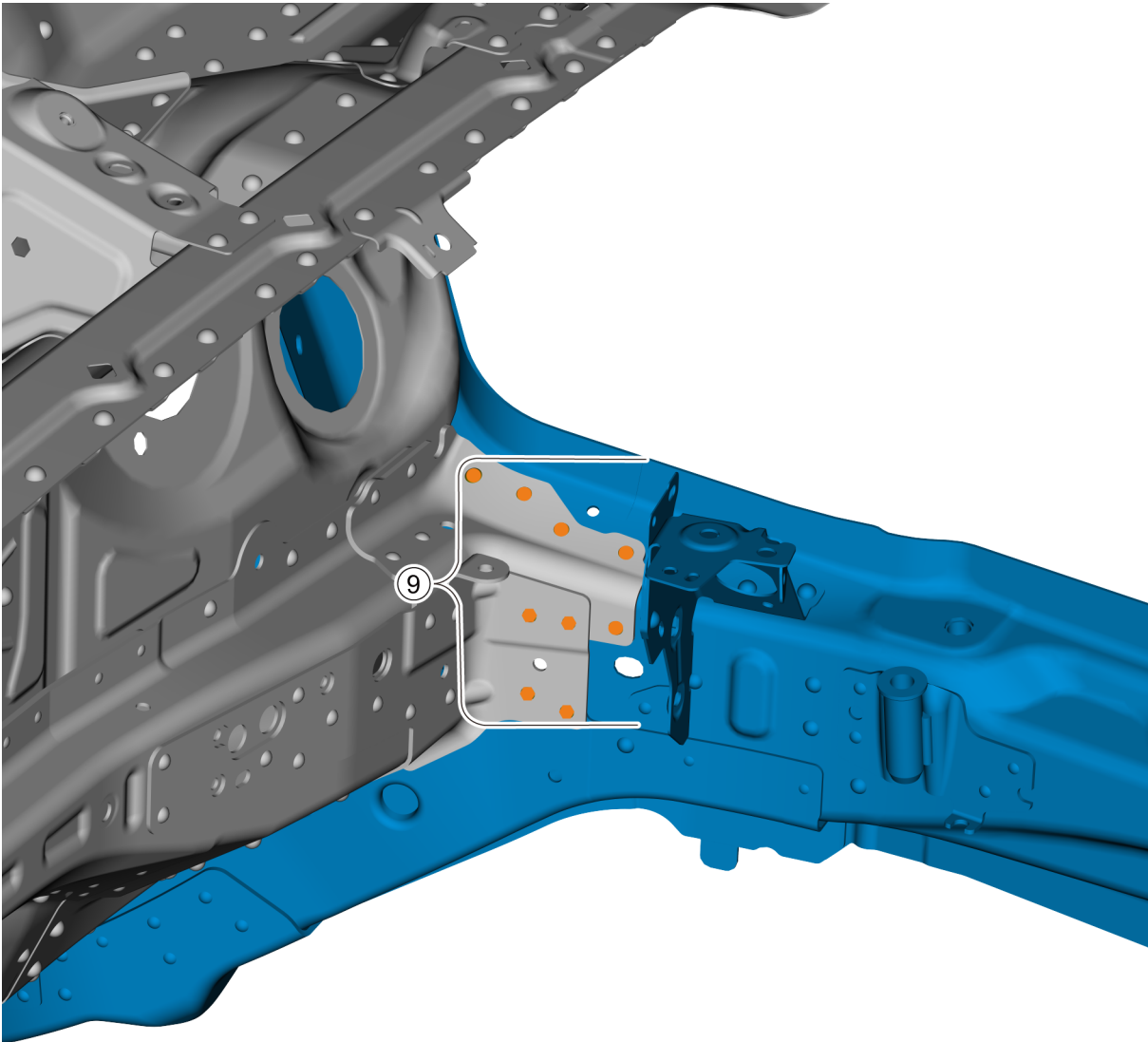
## 4.2.4 Installation of the Left Front Longitudinal Beam Assembly

### 4.2.4.1 Installation of the Left Front Longitudinal Beam Assembly

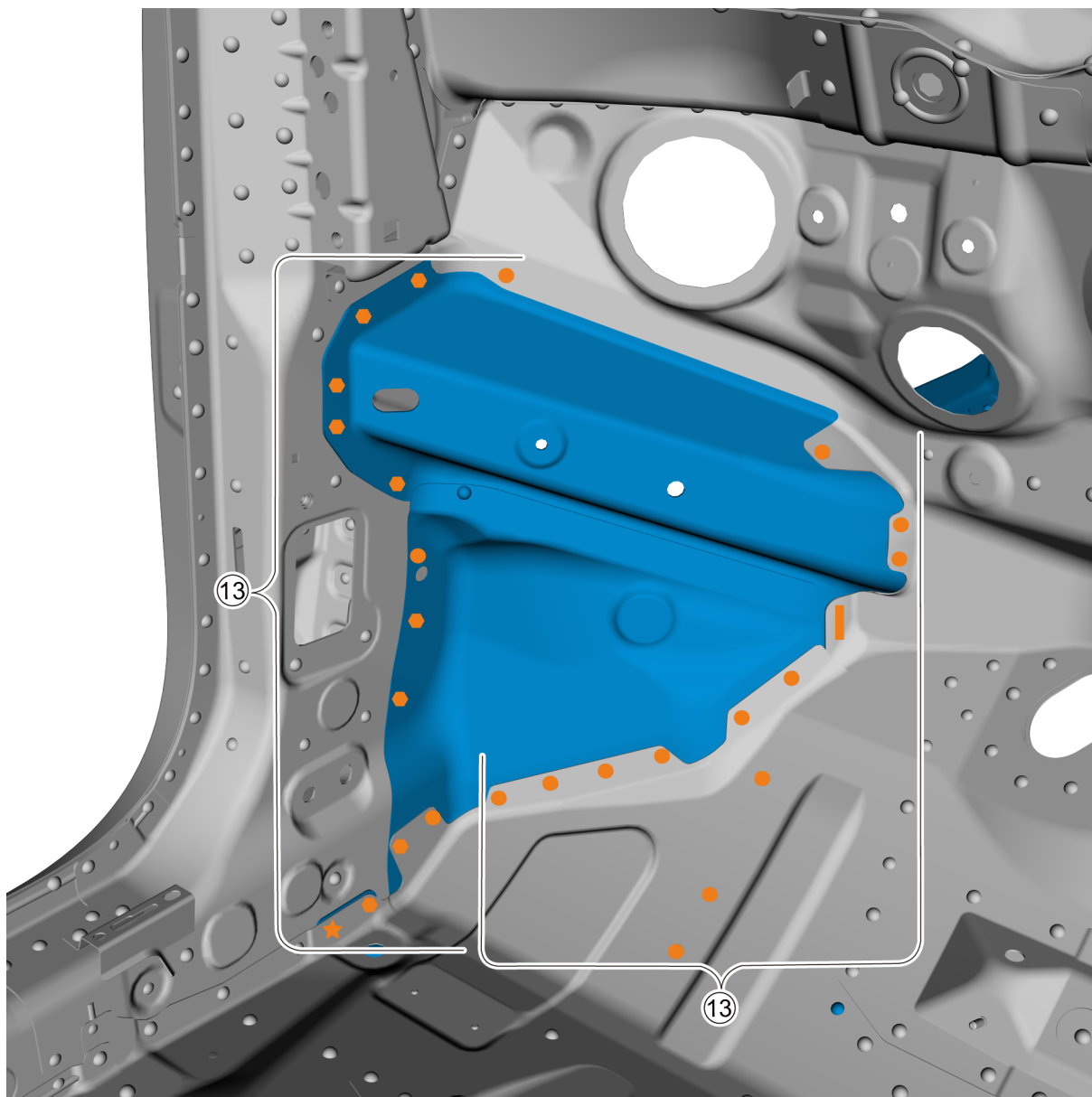
1. When installing a new part, match the mounting position of the new part on the body.
2. Temporarily install the new part for initial positioning.
3. Check and measure the positional dimensions of the left front longitudinal beam assembly and the body for compliance with the standard, and adjust if necessary.
4. Weld the fixing points of the left front longitudinal beam assembly to the front enclosure pedal assembly and the front floor left lower longitudinal beam assembly and the front enclosure pedal lower plate assembly.



5. Weld the fixing points of the left front longitudinal beam assembly with the front enclosure lower plate assembly.



6. Weld the fixing points of the left front longitudinal beam assembly with the front enclosure lower plate assembly and the front enclosure pedal assembly and the left A-pillar inner plate assembly.



7. Install the left front wheel cover assembly.
8. Install the left sidewall front connecting plate assembly.

## 4.2.5 Removal of the Left Sidewall Front Connecting Plate Assembly

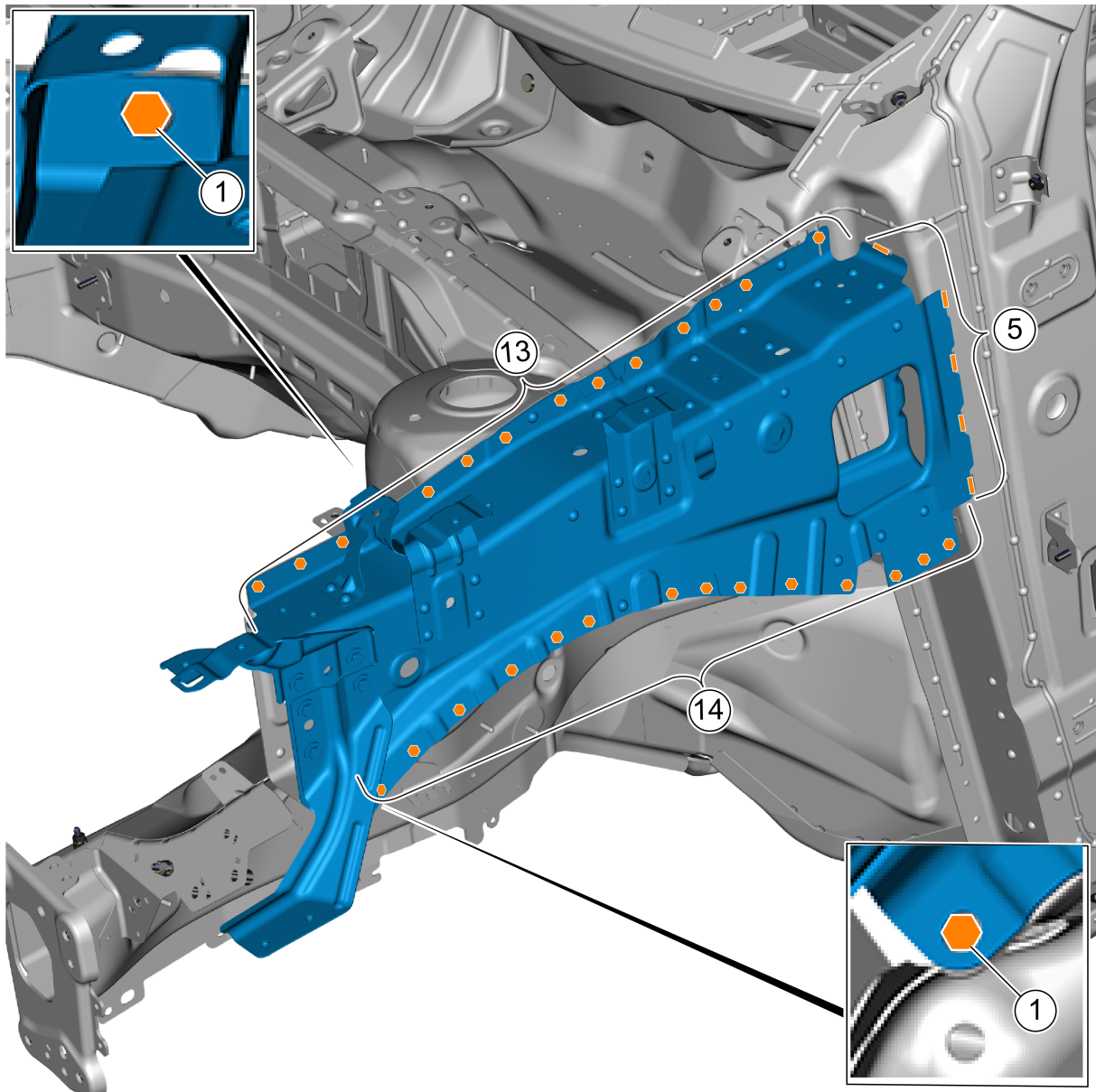
### 4.2.5.1 Removal of the Left Sidewall Front Connecting Plate Assembly

Removal of Parts

#### Caution

Remove the left and right sides in the same way.

1. At the welding positions shown in the figure below, drill out or grind away the welding points and remove the fixing points of the left sidewall front connecting plate assembly to the left front wheel cover assembly and the left sidewall front reinforcement plate assembly.



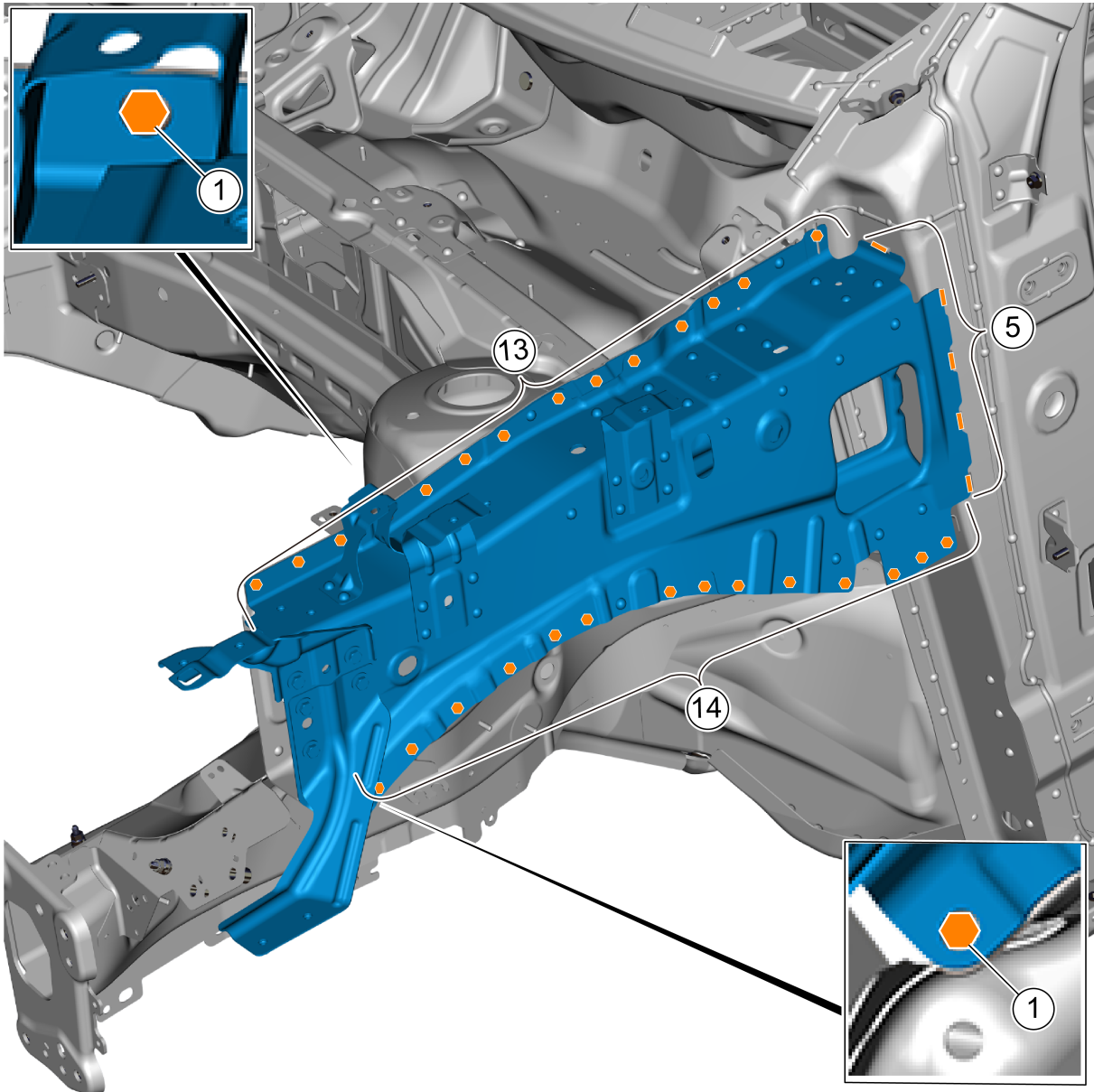
2. Grind away any welding marks that may remain on the body surface, and sand the welded surfaces to bare metal (remove surface foreign matter, paint and rust).



## 4.2.6 Installation of the Left Sidewall Front Connecting Plate Assembly

### 4.2.6.1 Installation of the Left Sidewall Front Connecting Plate Assembly

1. When installing a new part, match the mounting position of the new part on the body.
2. Temporarily install the new part for initial positioning.
3. Check and measure the positional dimensions of the left sidewall front connecting plate assembly and the body for compliance with the standard, and adjust if necessary.
4. Weld the fixing points of the left sidewall front connecting plate assembly to the left front wheel cover assembly and the left sidewall front reinforcement plate assembly.

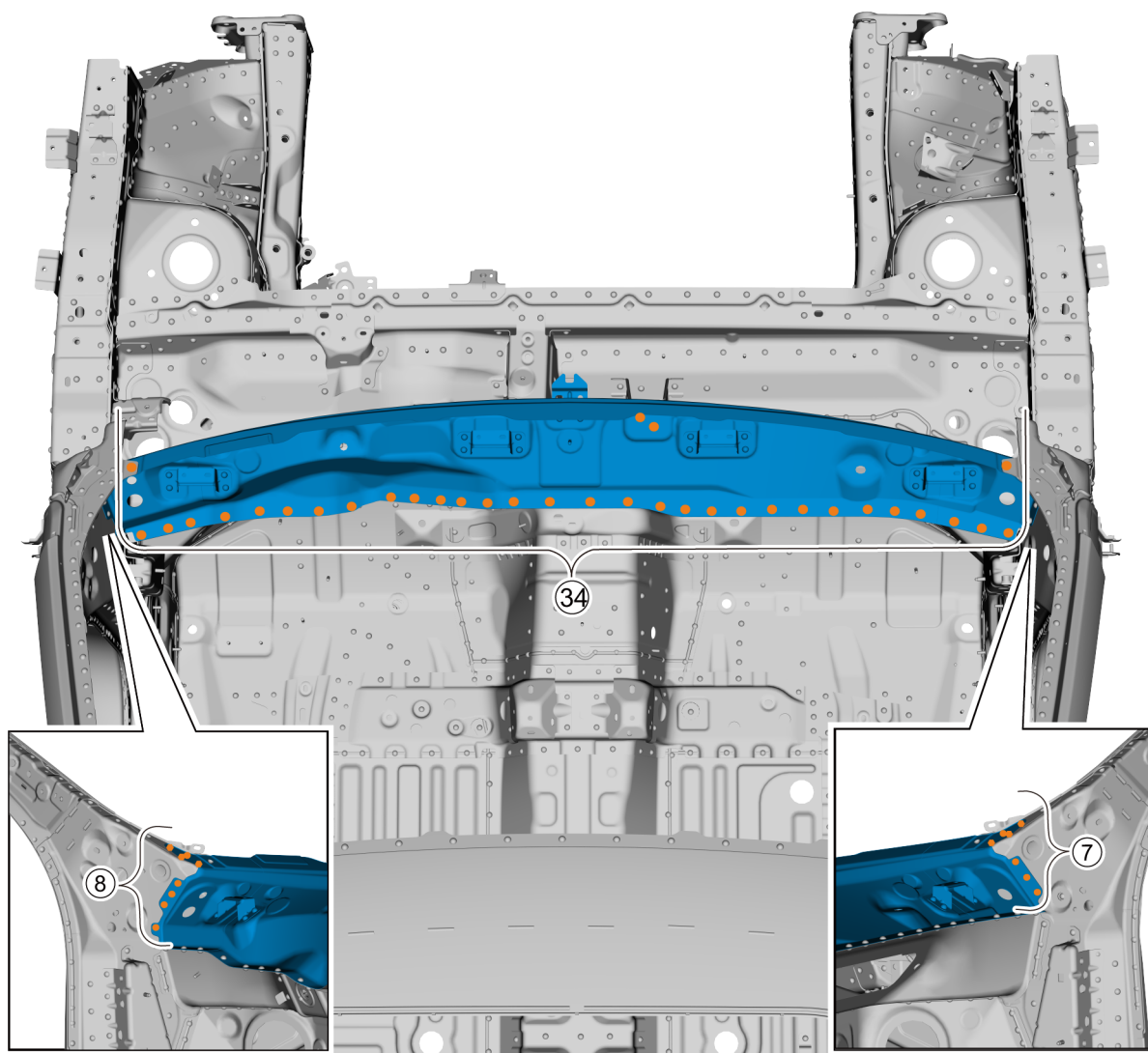


## 4.2.7 Removal of the Front Cabin Water Channel Cover Assembly

### 4.2.7.1 Removal of the Front Cabin Water Channel Cover Assembly

#### Removal of Parts

1. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the front cabin water channel cover assembly to the front cabin water channel assembly.

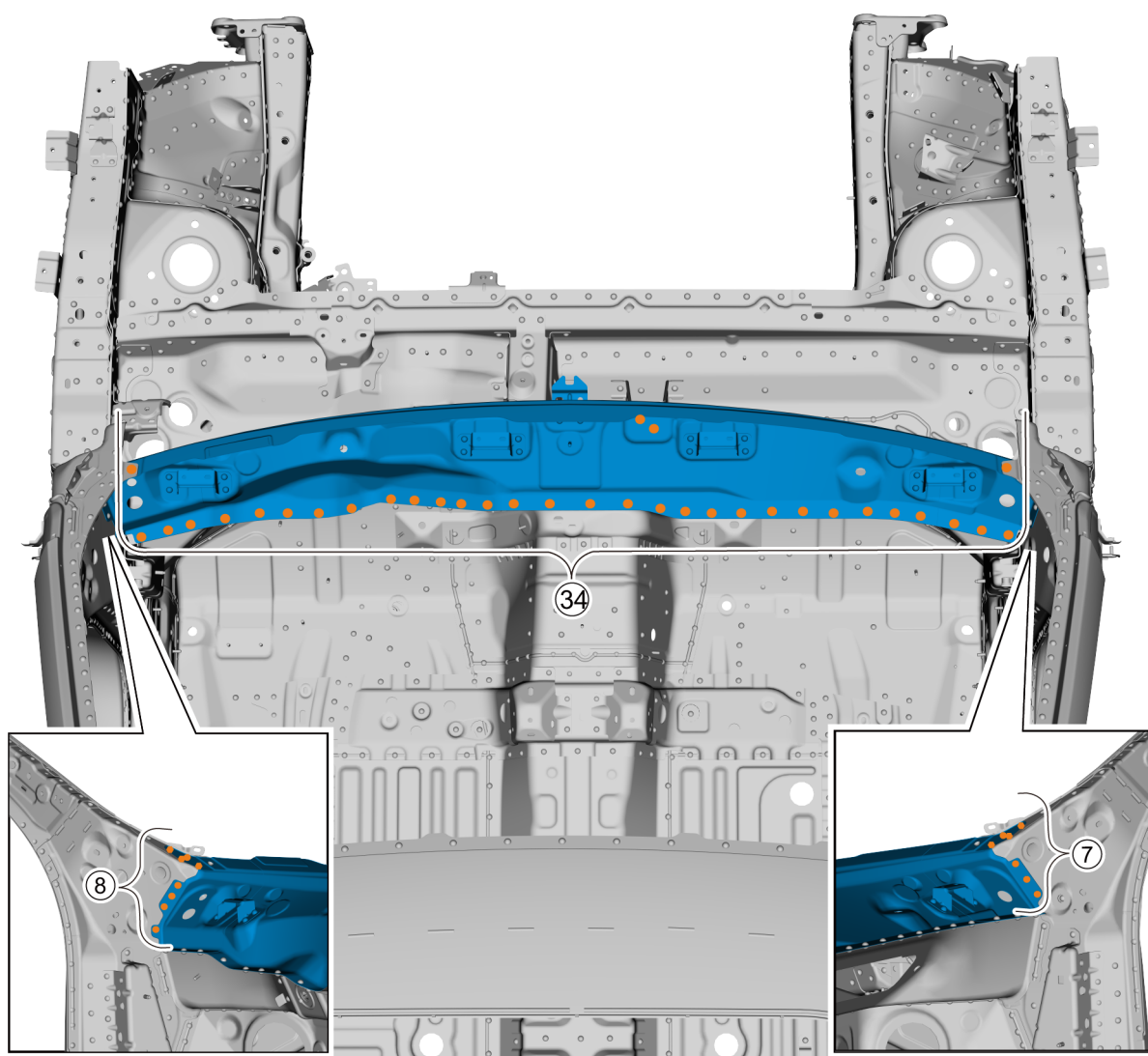


2. Grind away any welding marks that may remain on the body surface, and sand the welded surfaces to bare metal (remove surface foreign matter, paint and rust).

## 4.2.8 Installation of the Front Cabin Water Channel Cover Assembly

### 4.2.8.1 Installation of the Front Cabin Water Channel Cover Assembly

1. When installing a new part, match the mounting position of the new part on the body.
2. Temporarily install the new part for initial positioning.
3. Check and measure the positional dimensions of the front cabin water channel cover assembly and the body for compliance with the standard, and adjust if necessary.
4. Weld the fixing points of the front cabin water channel cover assembly and the front cabin water channel assembly.



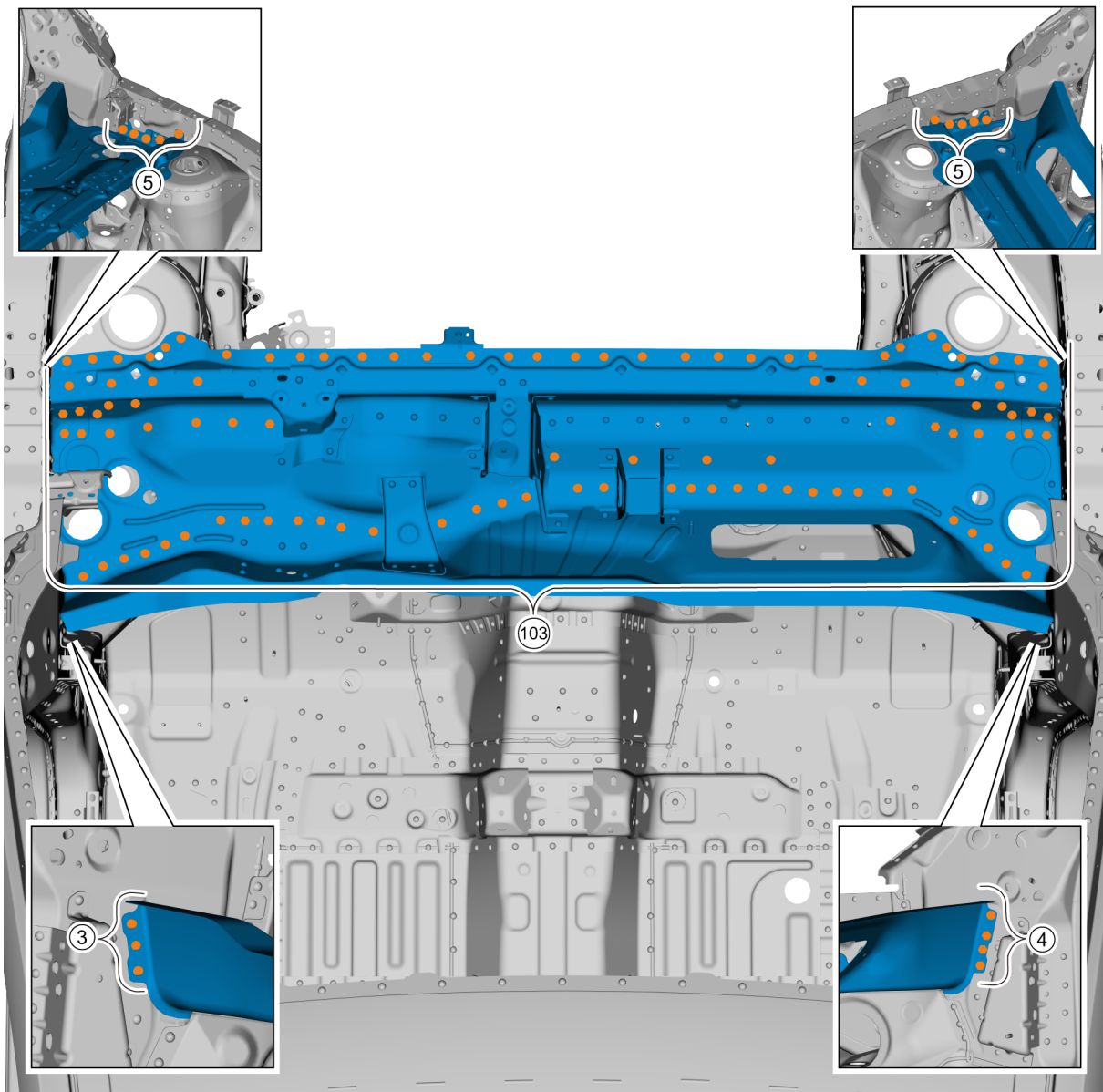


## 4.2.9 Removal of the Front Cabin Water Channel Assembly

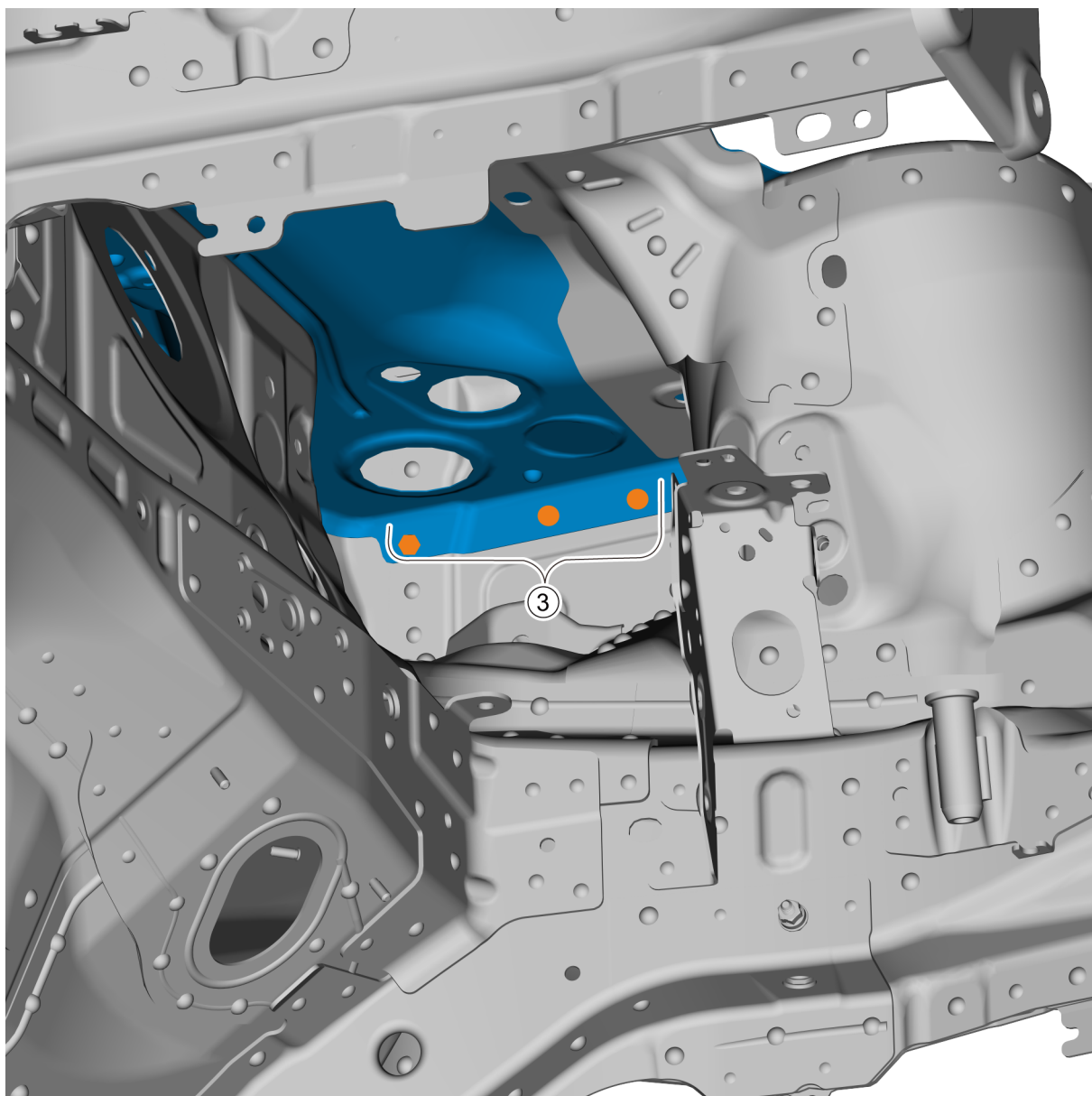
### 4.2.9.1 Removal of the Front Cabin Water Channel Assembly

#### Removal of Parts

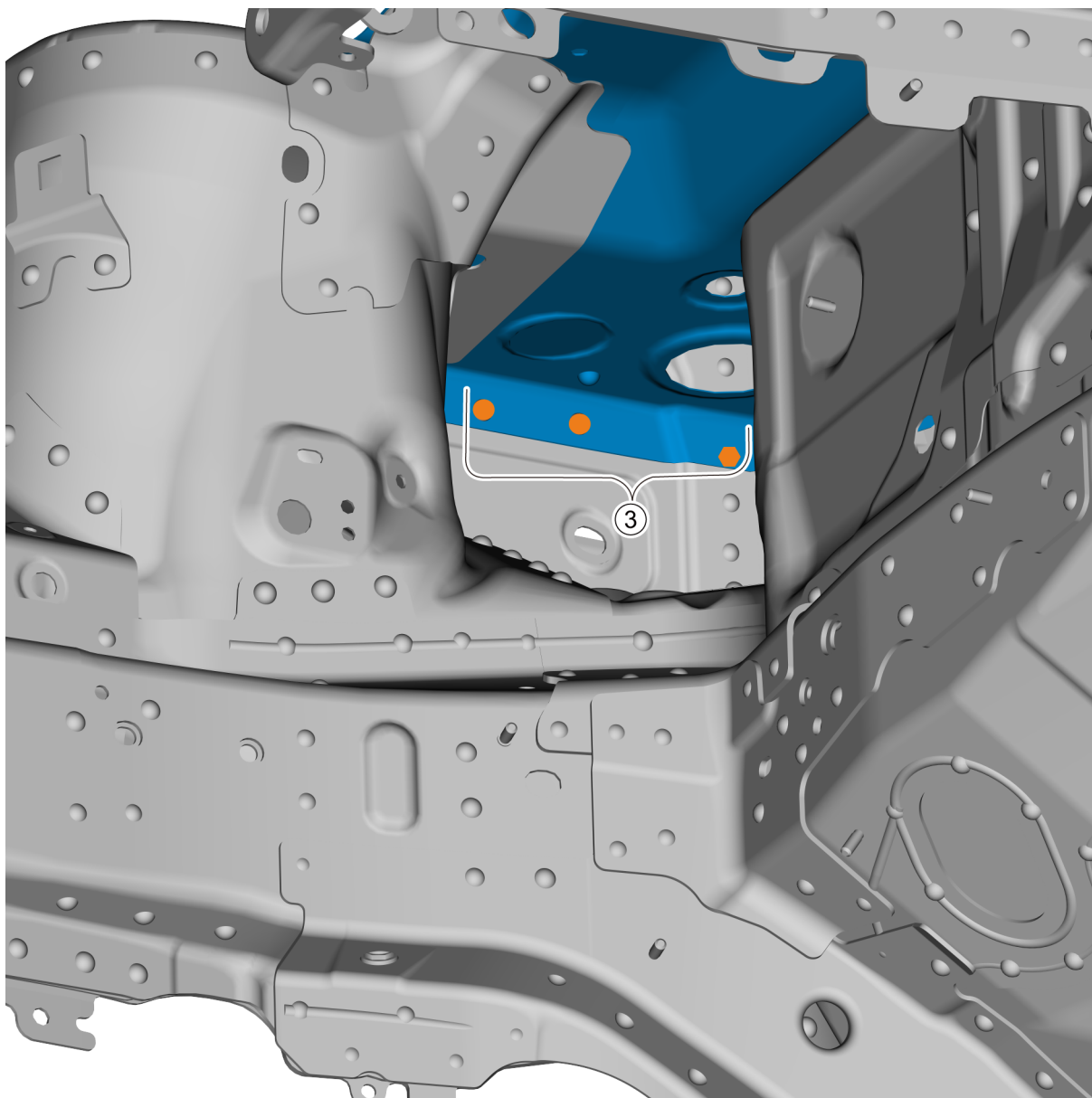
1. Remove the front cabin water channel cover assembly, refer to [Removal of the Front Cabin Water Channel Cover Assembly](#).
2. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the front cabin water channel assembly to the left and right front wheel cover assemblies and the front enclosure lower plate assembly.



3. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the front cabin water channel assembly to the left front wheel cover assembly.



4. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the front cabin water channel assembly to the right front wheel cover assembly.

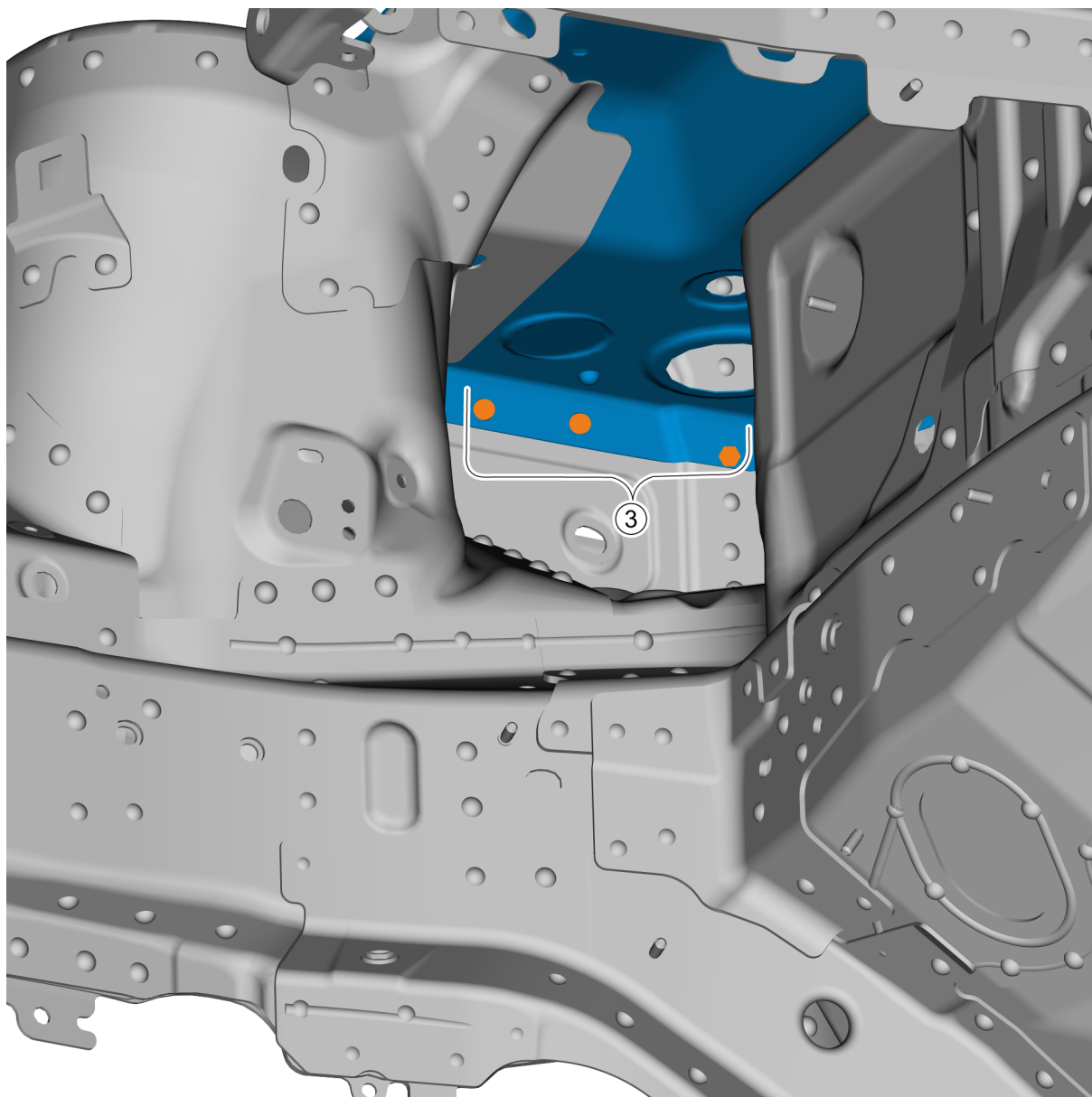


5. Grind away any welding marks that may remain on the body surface, and sand the welded surfaces to bare metal (remove surface foreign matter, paint and rust).

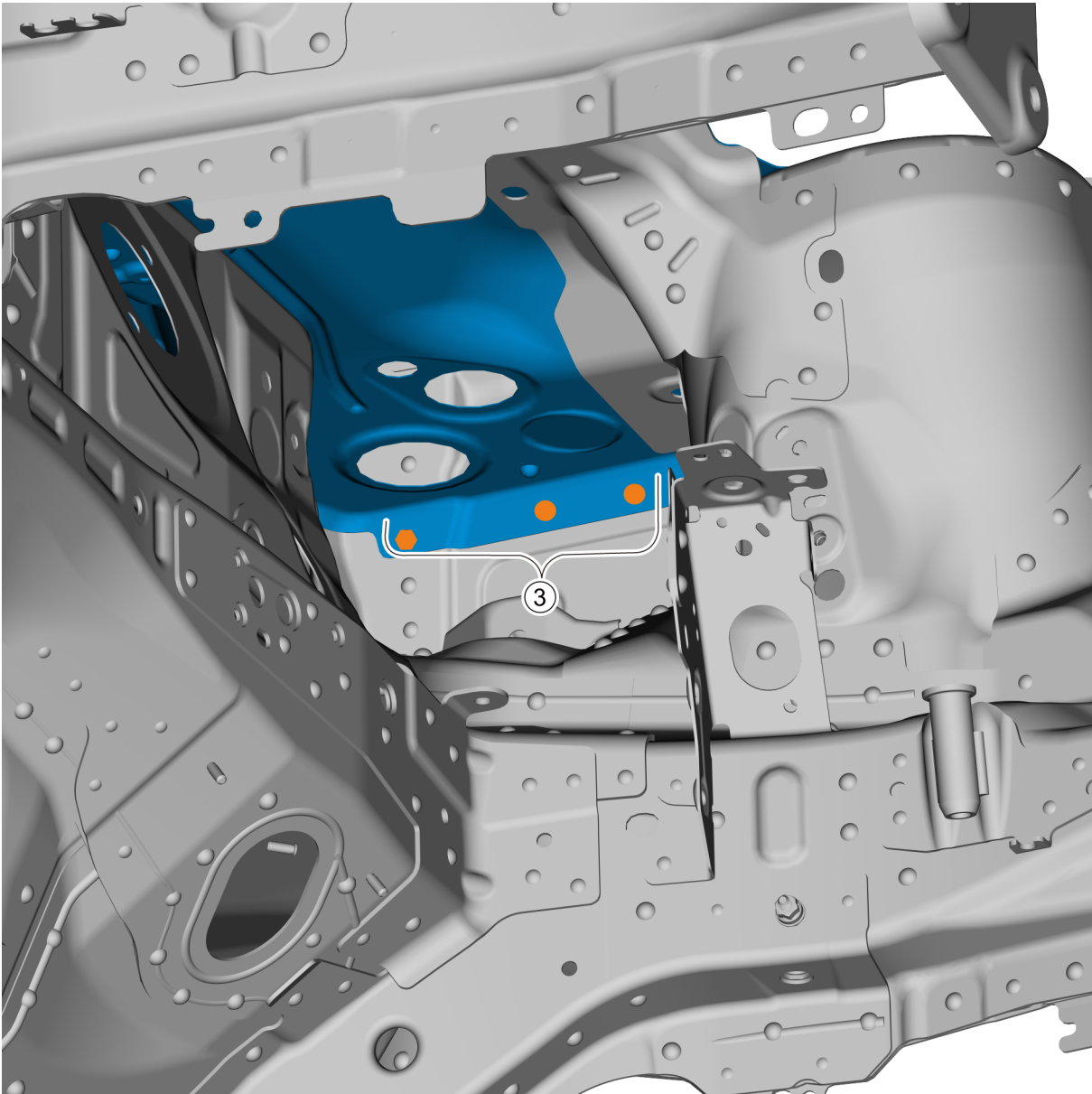
## 4.2.10 Installation of the Front Cabin Water Channel Assembly

### 4.2.10.1 Installation of the Front Cabin Water Channel Assembly

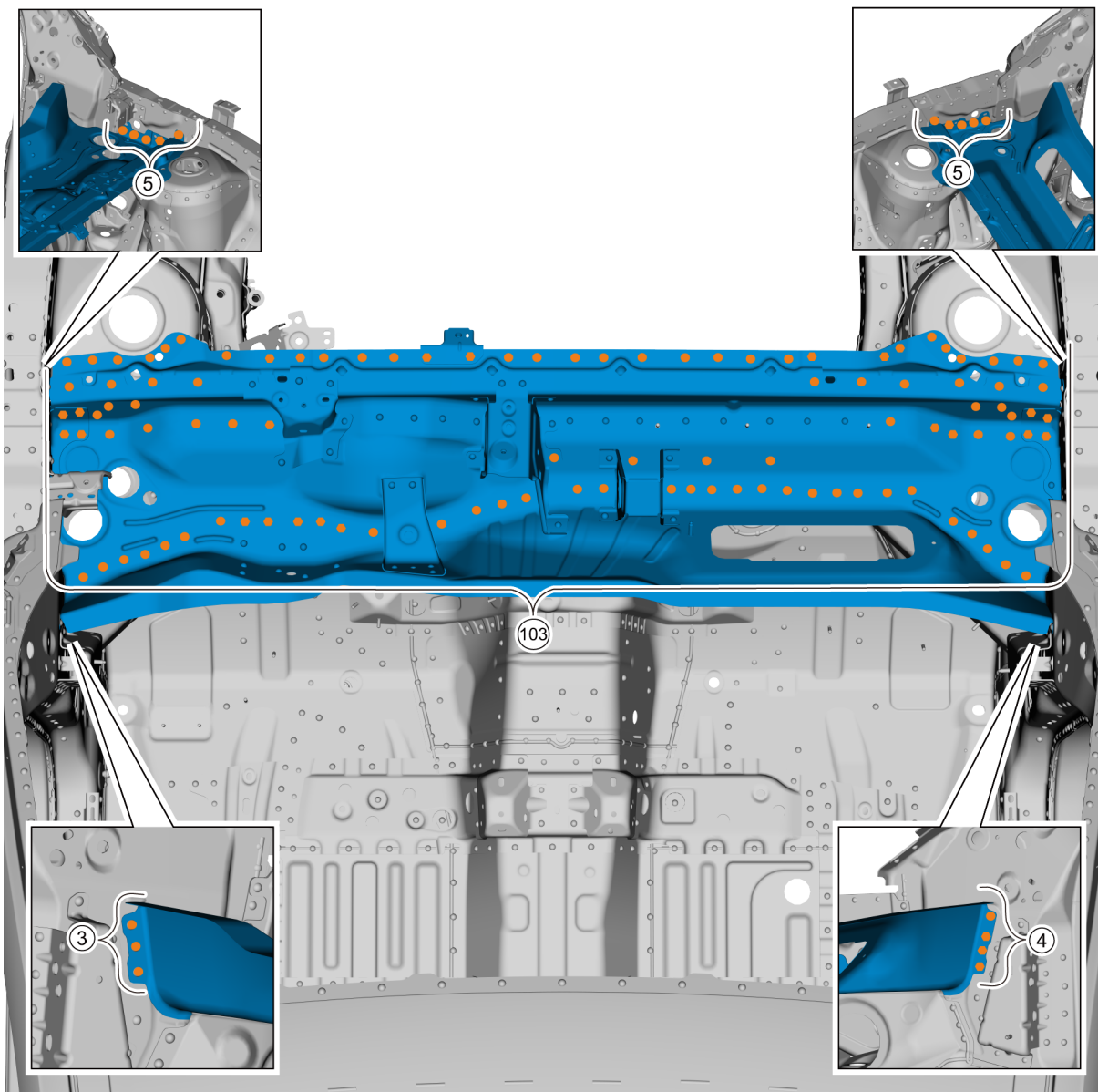
1. When installing a new part, match the mounting position of the new part on the body.
2. Temporarily install the new part for initial positioning.
3. Check and measure the positional dimensions of the front cabin water channel assembly and the body for compliance with the standard, and adjust if necessary.
4. Weld the fixing point of the front cabin water channel assembly to the right front wheel cover assembly.



5. Weld the fixing point between the front cabin water channel assembly to the left front wheel cover assembly.



6. Weld the fixing point of the front cabin water channel assembly to the left and right front wheel cover assemblies and the front enclosure lower plate assembly.



7. Install the front cabin water channel cover assembly.

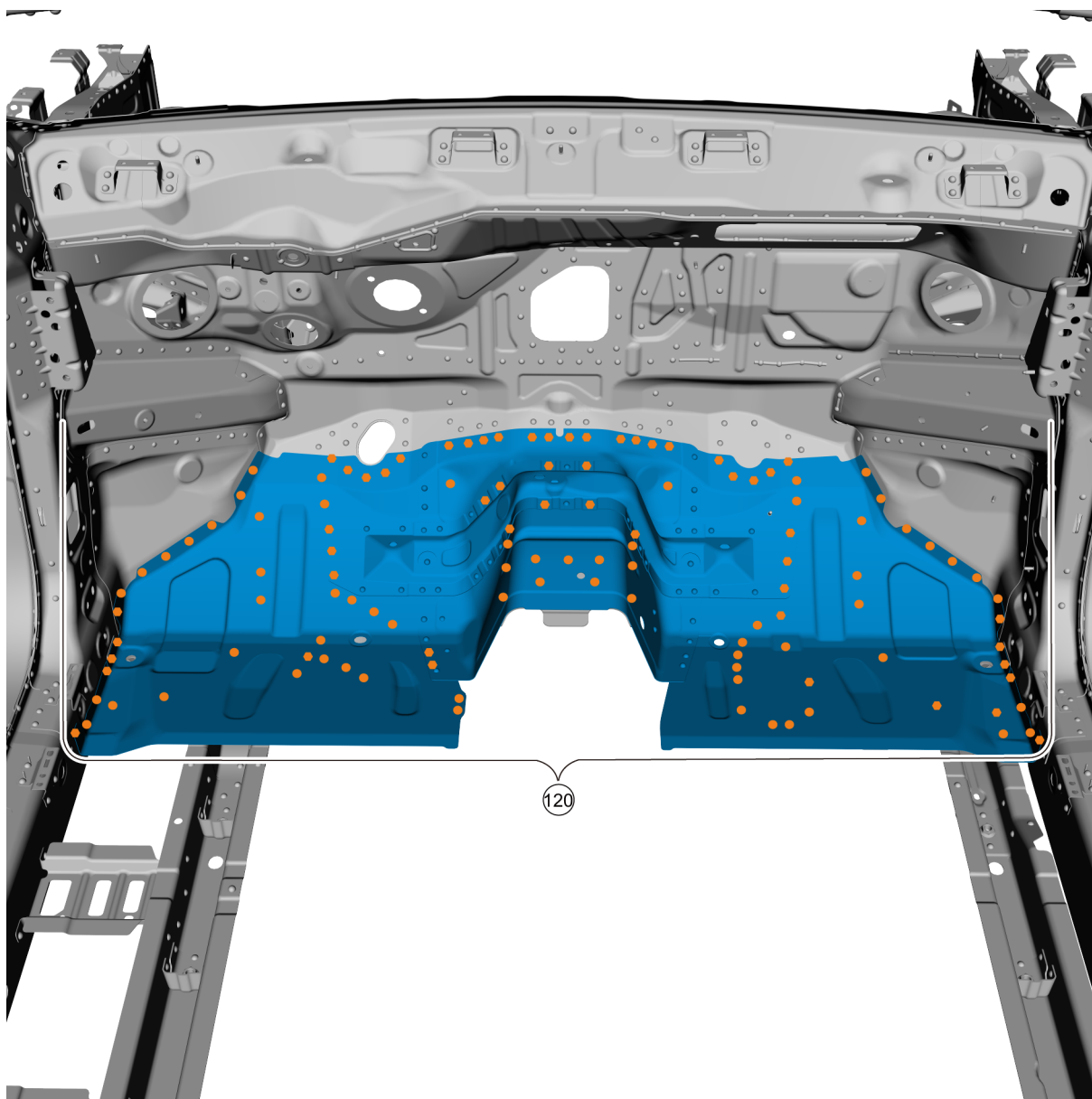


## 4.2.11 Removal of the Front Enclosure Pedal Assembly

### 4.2.11.1 Removal of the Front Enclosure Pedal Assembly

#### Removal of Parts

1. Remove the front floor assembly, refer to [Removal of the Front Floor Assembly](#).
2. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the front enclosure pedal assembly to the left and right door sill inner plate assemblies and the front enclosure lower plate assembly to the left and right front longitudinal beam assemblies.

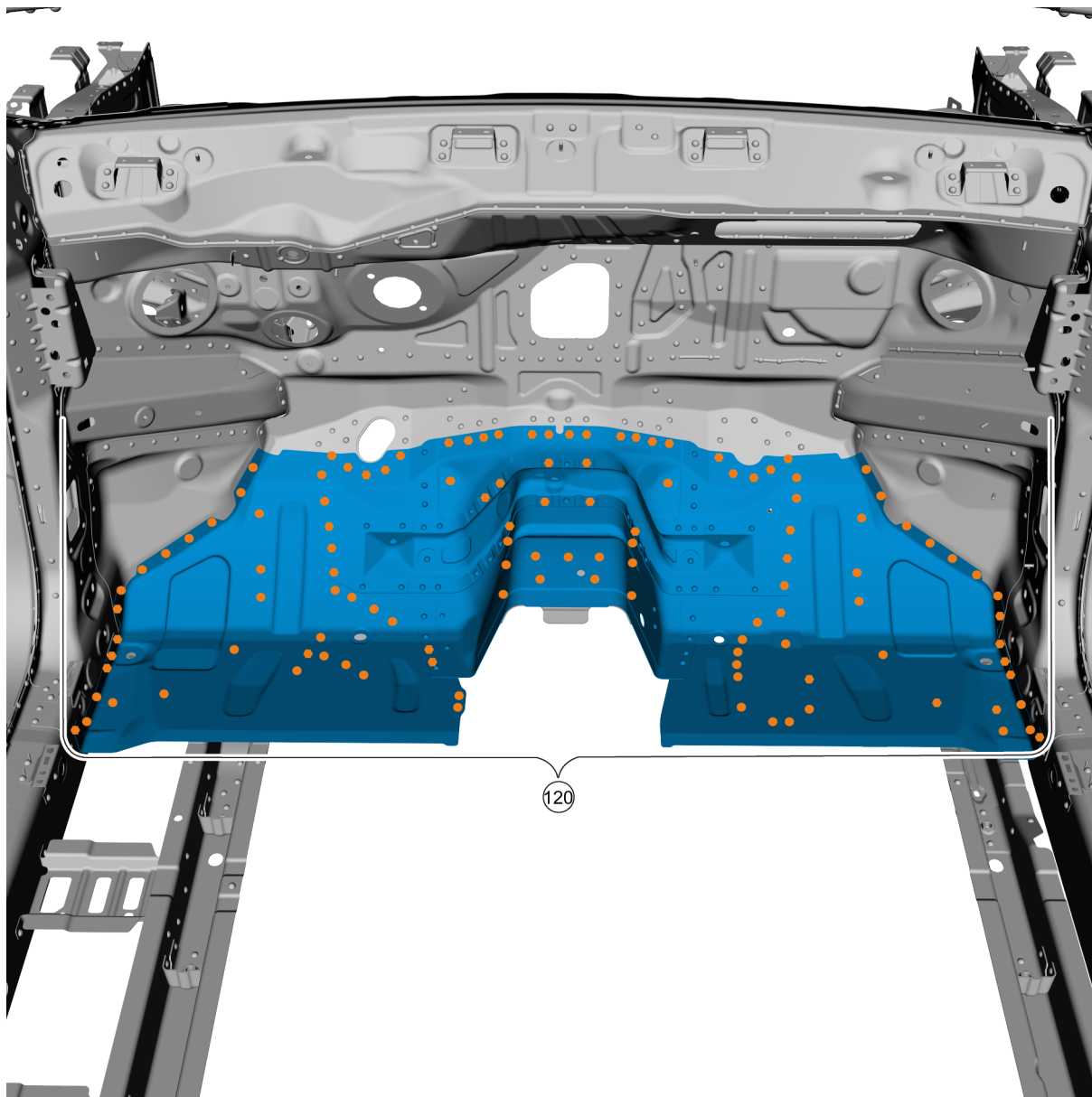


3. Grind away any welding marks that may remain on the body surface and sand the welded surfaces to bare metal (remove surface foreign matter, paint and rust).

## 4.2.12 Installation of the Front Enclosure Pedal Assembly

### 4.2.12.1 Installation of the Front Enclosure Pedal Assembly

1. When installing a new part, match the mounting position of the new part on the body.
2. Temporarily install the new part for initial positioning.
3. Check and measure the positional dimensions of the front enclosure pedal assembly and the body for compliance with the standard, and adjust if necessary.
4. Weld the fixing points of the front enclosure pedal assembly to the left and right door sill inner plate assemblies and the front enclosure lower plate assembly and the left and right front longitudinal beam assemblies.



5. Install the front floor assembly.

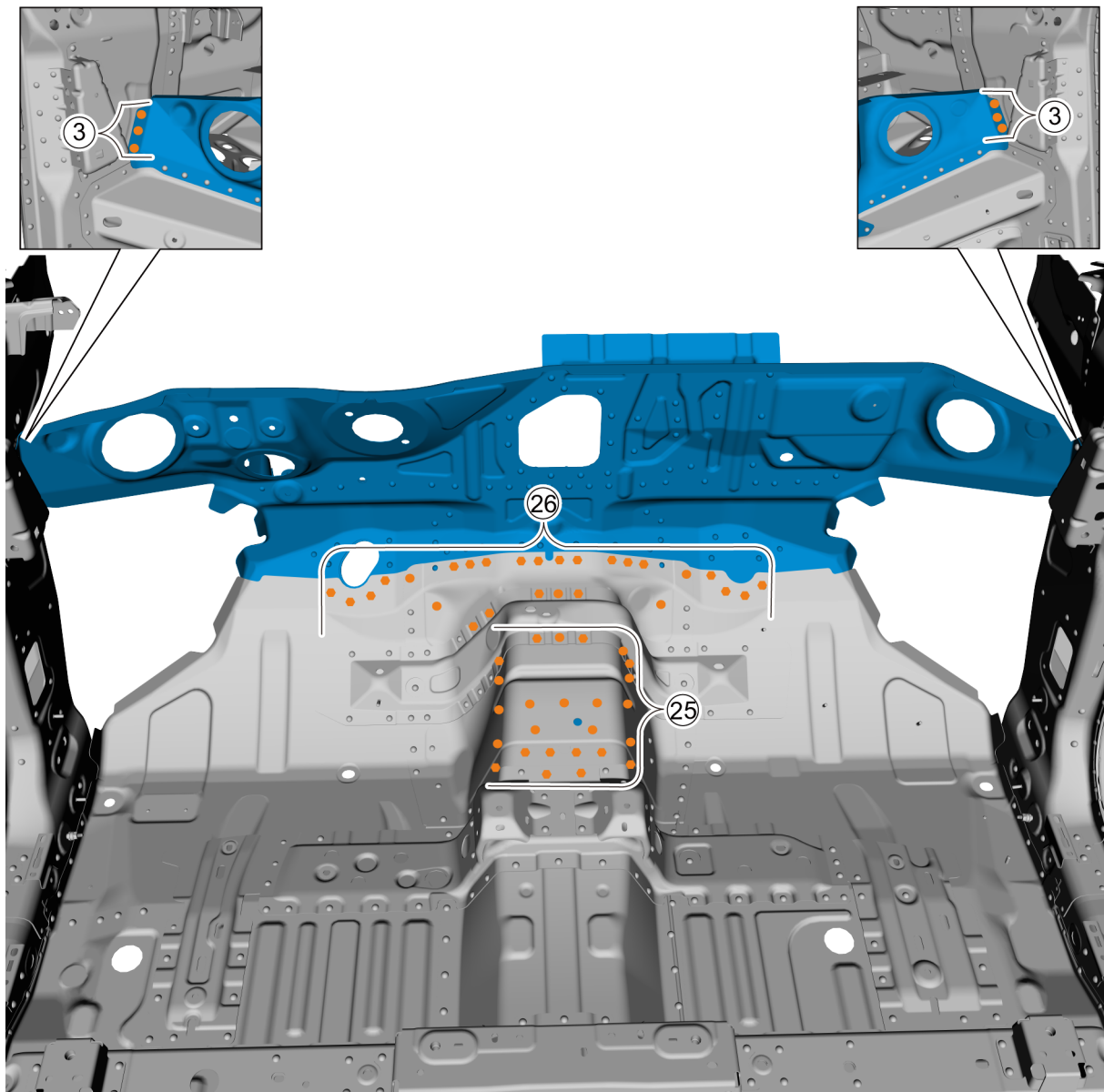


## 4.2.13 Removal of the Front Enclosure Lower Plate Assembly

### 4.2.13.1 Removal of the Front Enclosure Lower Plate Assembly

#### Removal of Parts

1. Remove the left sidewall front connecting plate assembly, refer to [Removal of the Left Sidewall Front Connecting Plate Assembly](#).
2. Remove the front cabin water channel cover assembly, refer to [Removal of the Front Cabin Water Channel Cover Assembly](#).
3. Remove the front cabin water channel assembly, refer to [Removal of the Front Cabin Water Channel Assembly](#).
4. Remove the left and right front wheel cover assemblies, refer to [Removal of the Left Front Wheel Cover Assembly](#).
5. Remove the left and right front longitudinal beam assemblies, refer to [Removal of the Left Front Longitudinal Beam Assembly](#).
6. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the front enclosure lower plate assembly to the left and right A-pillar inner plate assemblies and the front enclosure pedal assembly to the front floor assembly.

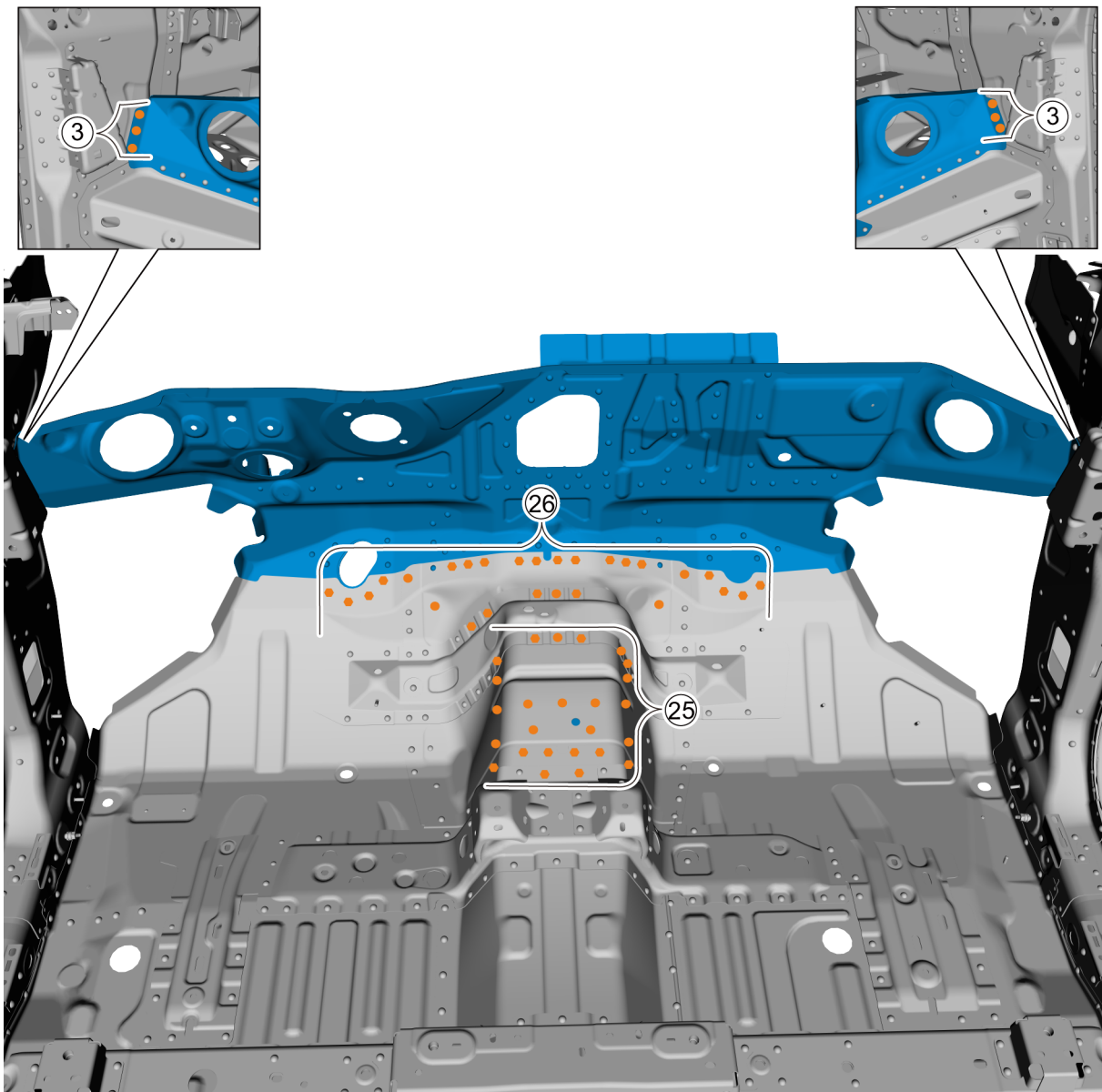


7. Grind away any welding marks that may remain on the body surface and sand the welded surfaces to bare metal (remove surface foreign matter, paint and rust).

## 4.2.14 Installation of the Front Enclosure Lower Plate Assembly

### 4.2.14.1 Installation of the Front Enclosure Lower Plate Assembly

1. When installing a new part, match the mounting position of the new part on the body.
2. Temporarily install the new part for initial positioning.
3. Check and measure the positional dimensions of the front enclosure lower plate assembly and the body for compliance with the standard, and adjust if necessary.
4. Weld the fixing points of the front enclosure lower plate assembly to the left and right A-pillar inner plate assemblies and the front enclosure pedal assembly and front floor assembly.



5. Install the left and right front longitudinal beam assemblies.
6. Install the left and right front wheel cover assemblies.
7. Install the front cabin water channel assembly.
8. Install the front cabin water channel cover assembly.

9. Install the left sidewall front connecting plate assembly.

## 4.2.15 Removal of the Left Sidewall Outer Plate

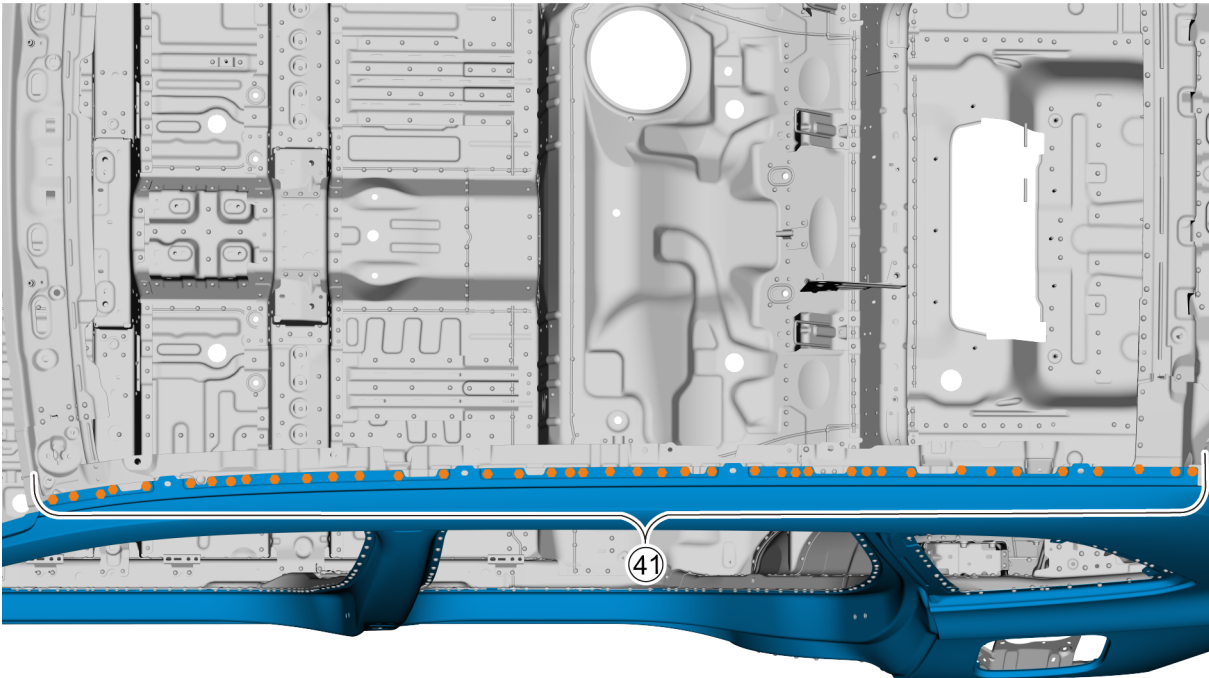
### 4.2.15.1 Removal of the Left Sidewall Outer Plate

Removal of Parts

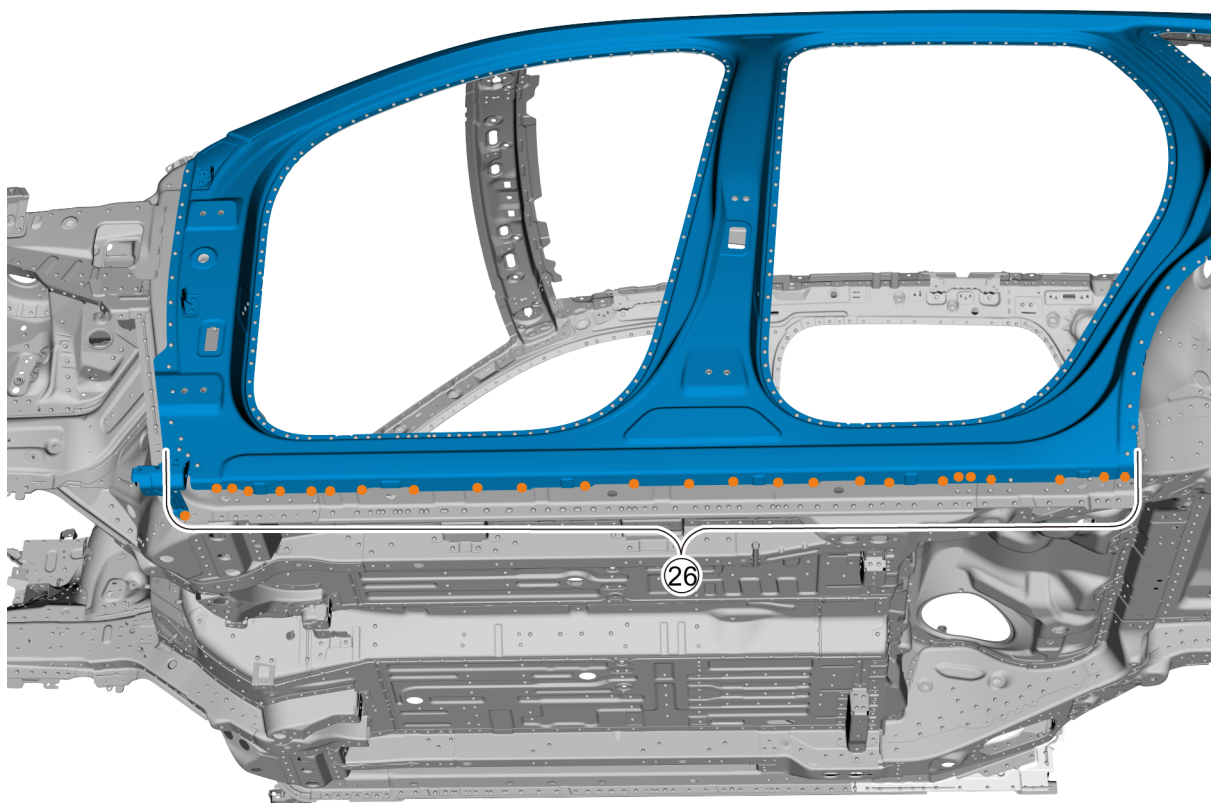
#### Caution

Remove the left and right sides in the same way.

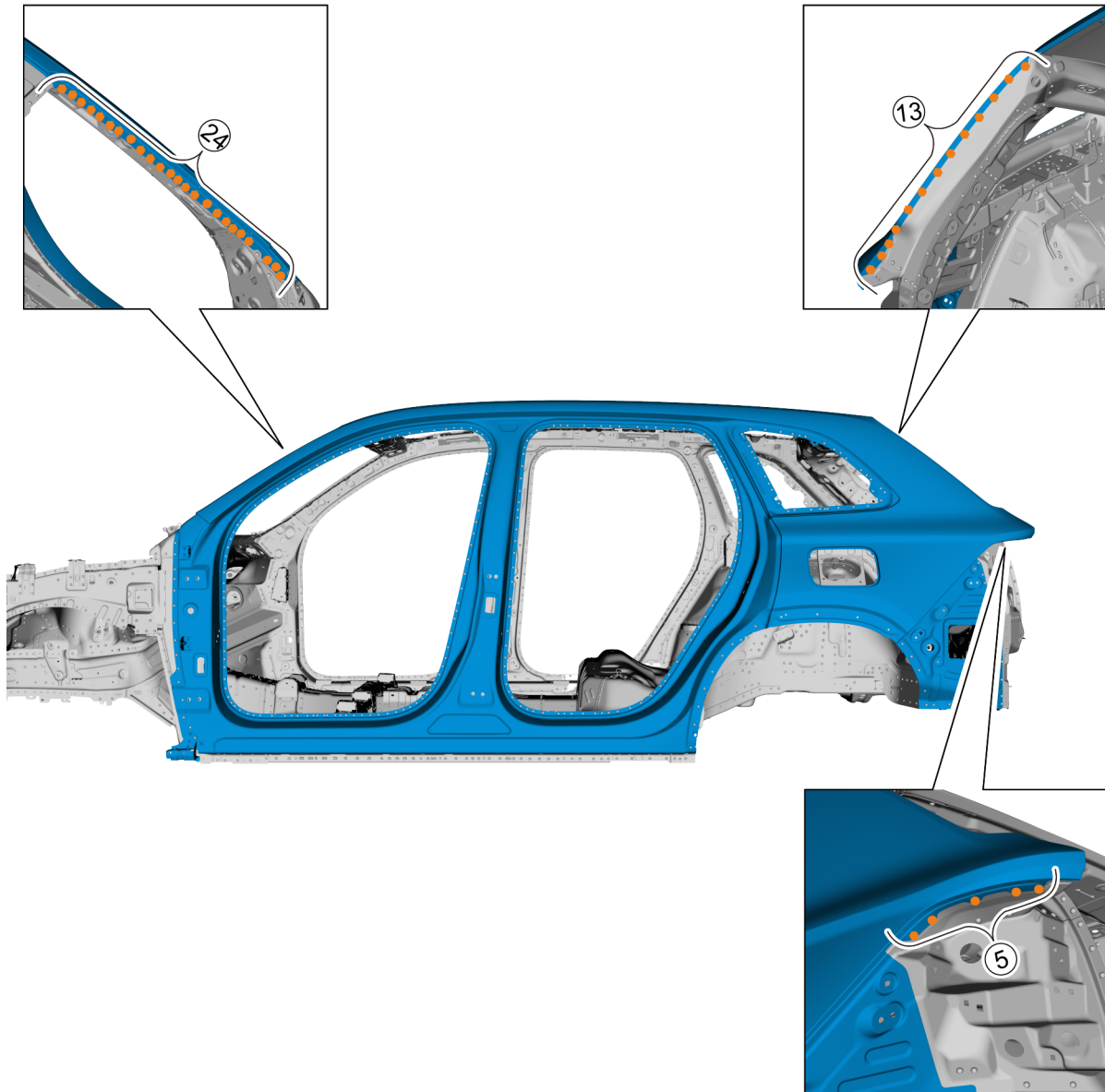
1. Remove the large sunroof top cover assembly, refer to [Removal of the Large Sunroof Top Cover Assembly](#).
2. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the left sidewall outer plate to the left sidewall front reinforcement plate assembly and the left C-pillar assembly.



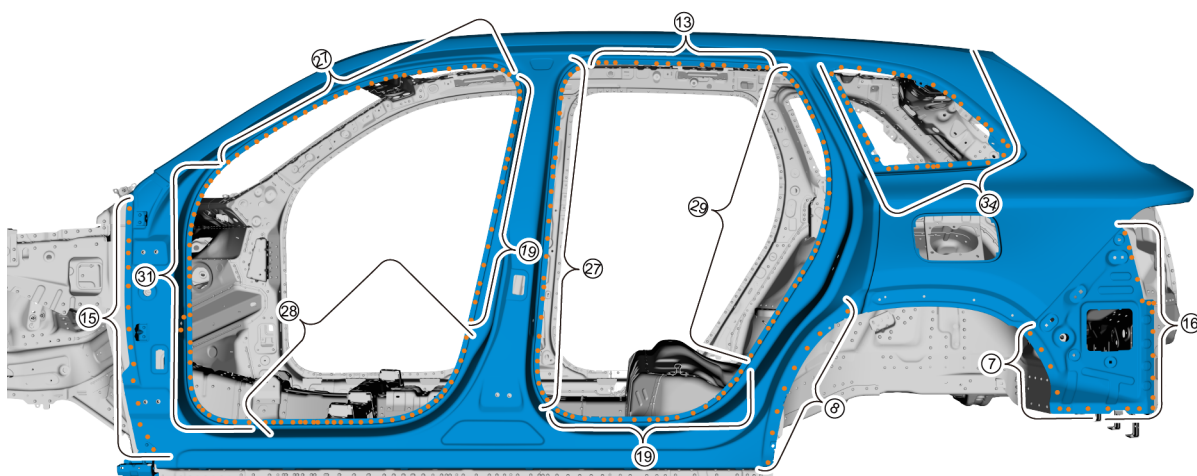
3. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the left sidewall outer plate to the left sidewall front reinforcement plate assembly and the left C-pillar assembly.



4. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the left sidewall outer plate to the left sidewall front reinforcement plate assembly and the left sidewall rear water channel assembly and the left tail light mounting plate assembly.



5. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the left sidewall outer plate to the left sidewall front reinforcement plate assembly and the left C-pillar assembly and the left sidewall rear water channel assembly and the left tail light mounting plate assembly.



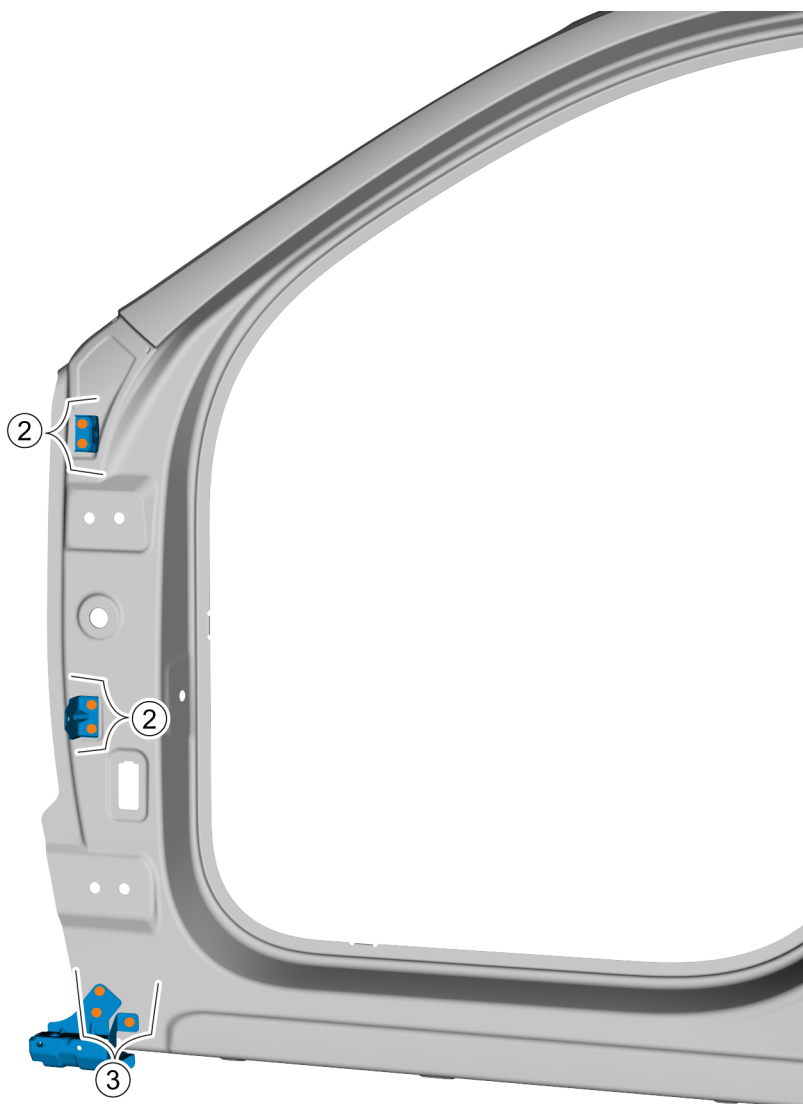
6. Grind away any welding marks that may remain on the body surface, and sand the welded surfaces to bare metal (remove surface foreign matter, paint and rust).



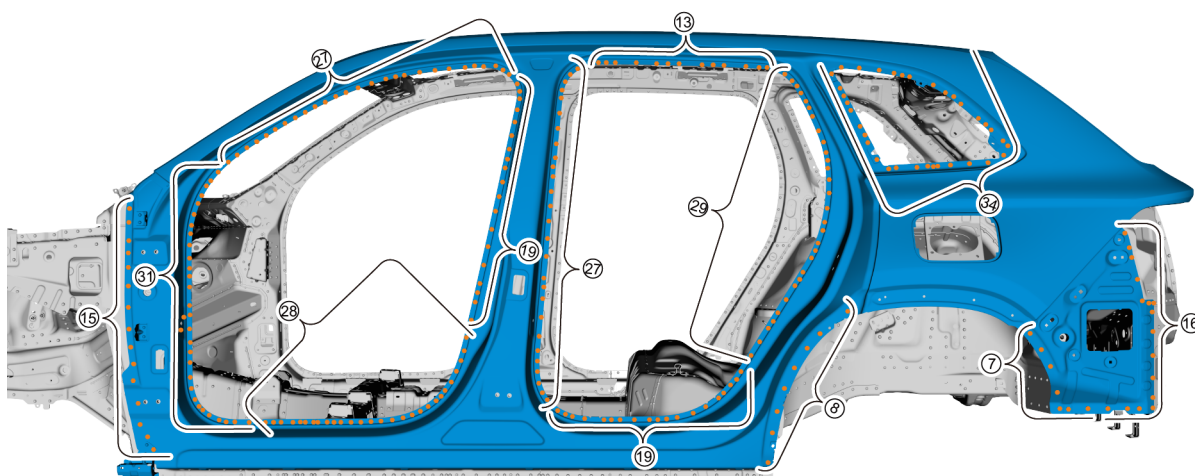
## 4.2.16 Installation of the Left Sidewall Outer Plate

### 4.2.16.1 Installation of the Left Sidewall Outer Plate

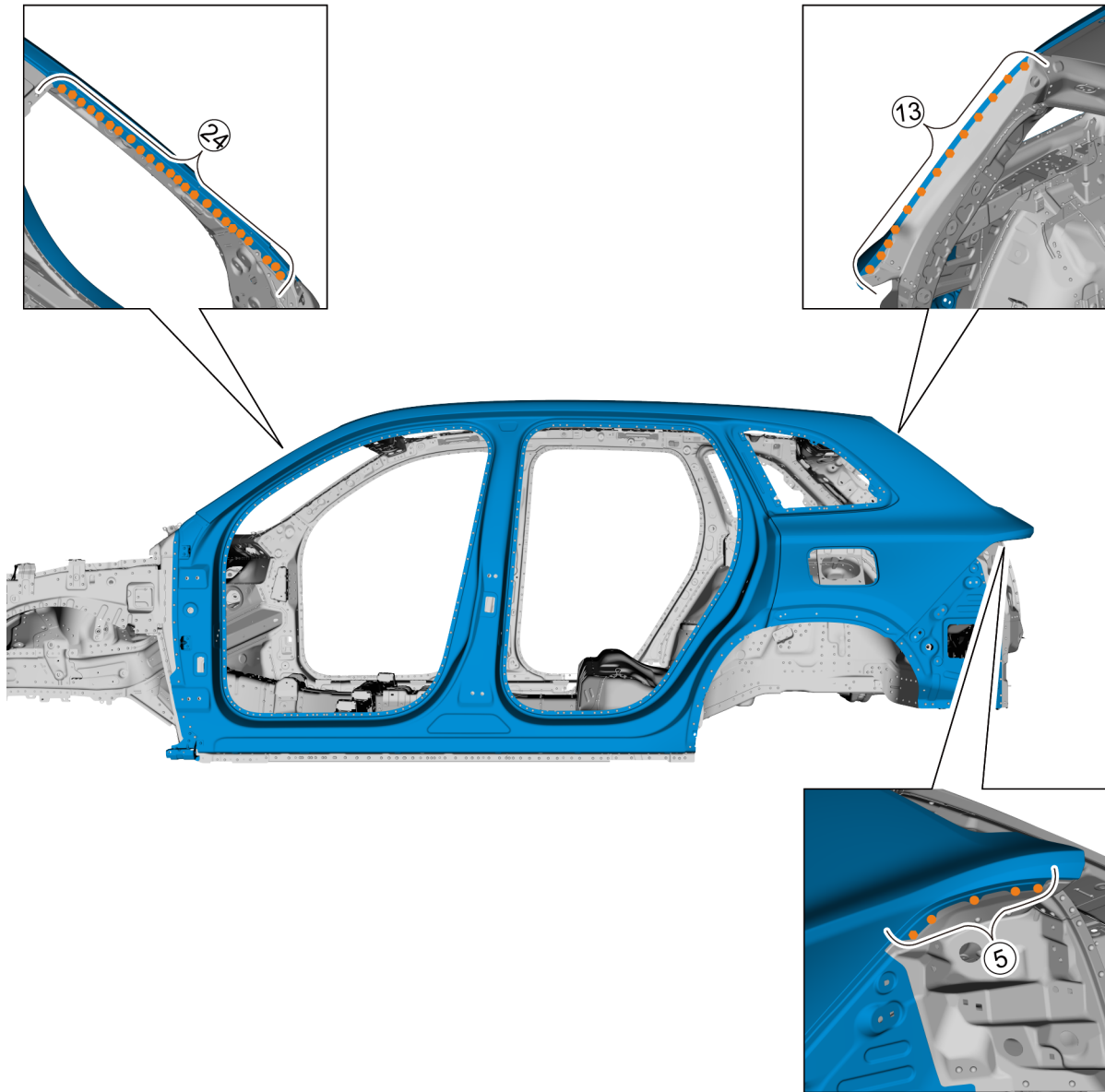
1. When installing a new part, match the mounting position of the new part on the body.
2. Temporarily install the new part for initial positioning.
3. Check and measure the positional dimensions of the left sidewall outer plate and body for compliance with the standard, and adjust if necessary.
4. Weld the fixing points of the left sidewall outer plate to the wing large bracket assembly and wing bracket.



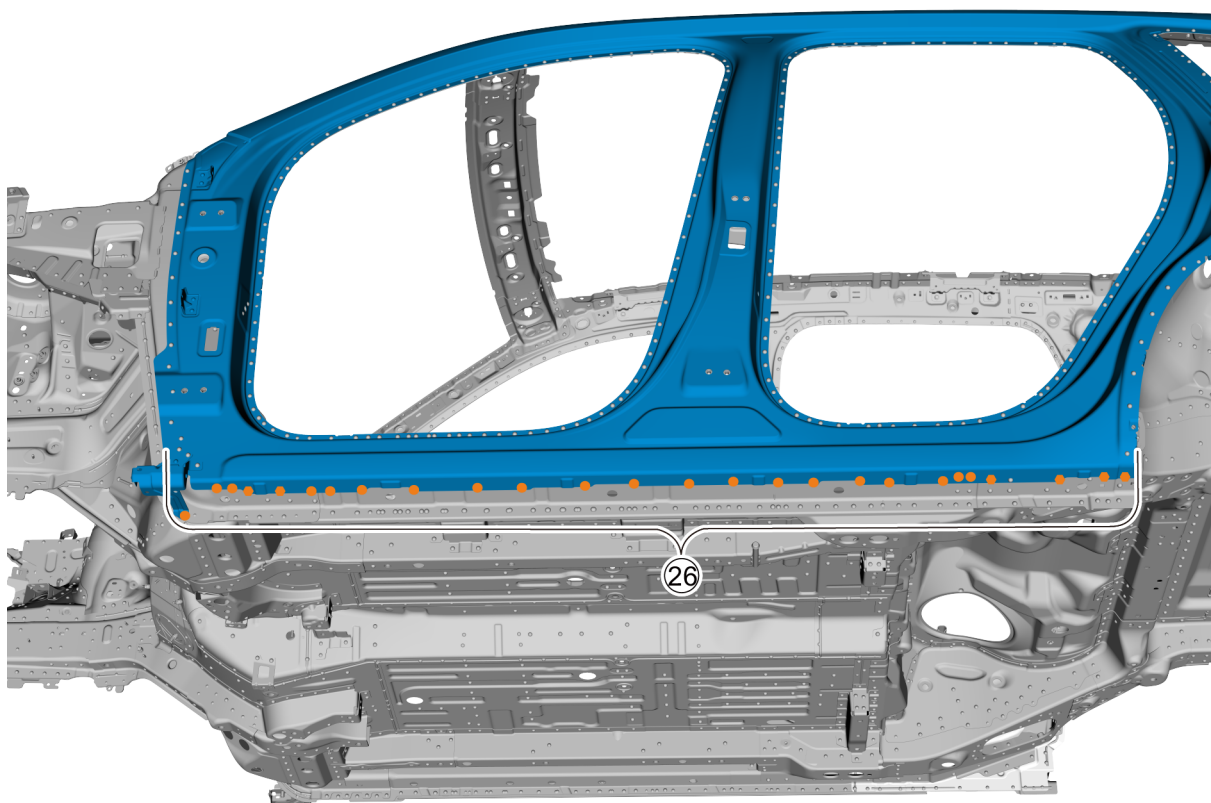
- Weld the fixing points of the left sidewall outer plate to the left side enclosure front reinforcement plate assembly and the left C-pillar assembly and the left side enclosure rear running channel assembly and the left tail light mounting plate assembly.



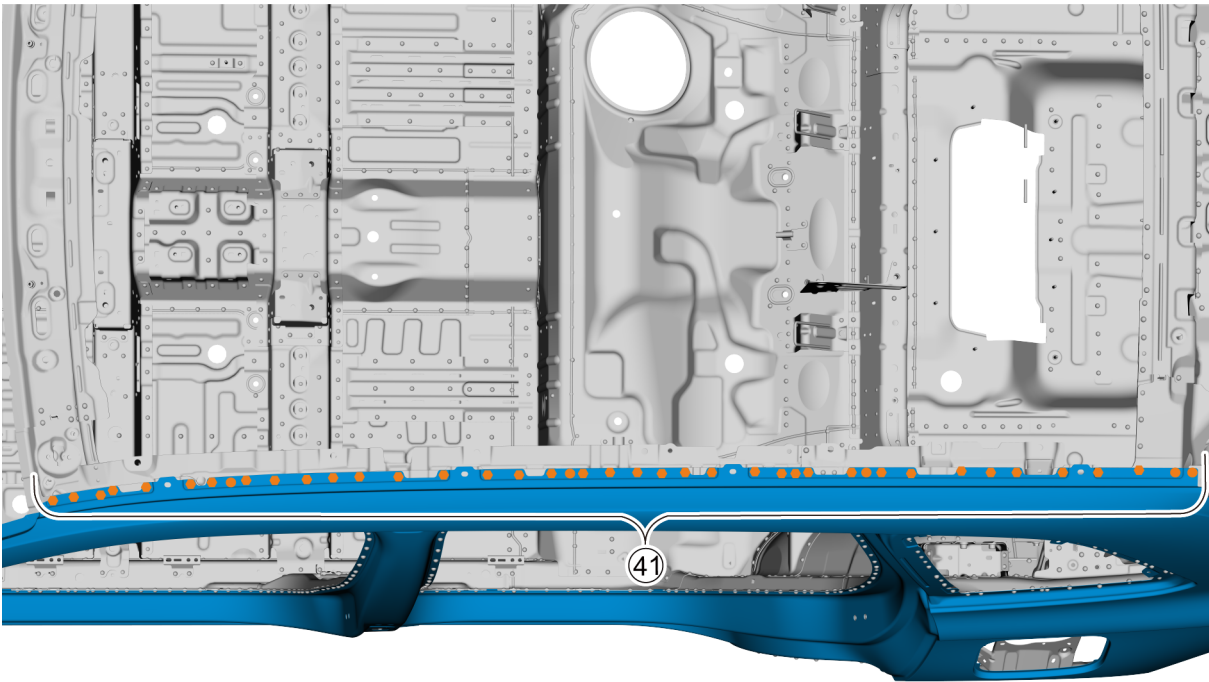
6. Weld the fixing points of the left sidewall outer plate to the left sidewall front reinforcement plate assembly and the left sidewall rear water channel assembly and the left tail light mounting plate assembly.



7. Weld the fixing points of the left sidewall outer plate to the left sidewall front reinforcement plate assembly and the left C-pillar assembly.



8. Weld the fixing points of the left sidewall outer plate to the left sidewall front reinforcement plate assembly and the left C-pillar assembly.



9. Install the large sunroof top cover assembly.

## 4.2.17 Removal of the Left Sidewall Front Reinforcement Plate Assembly

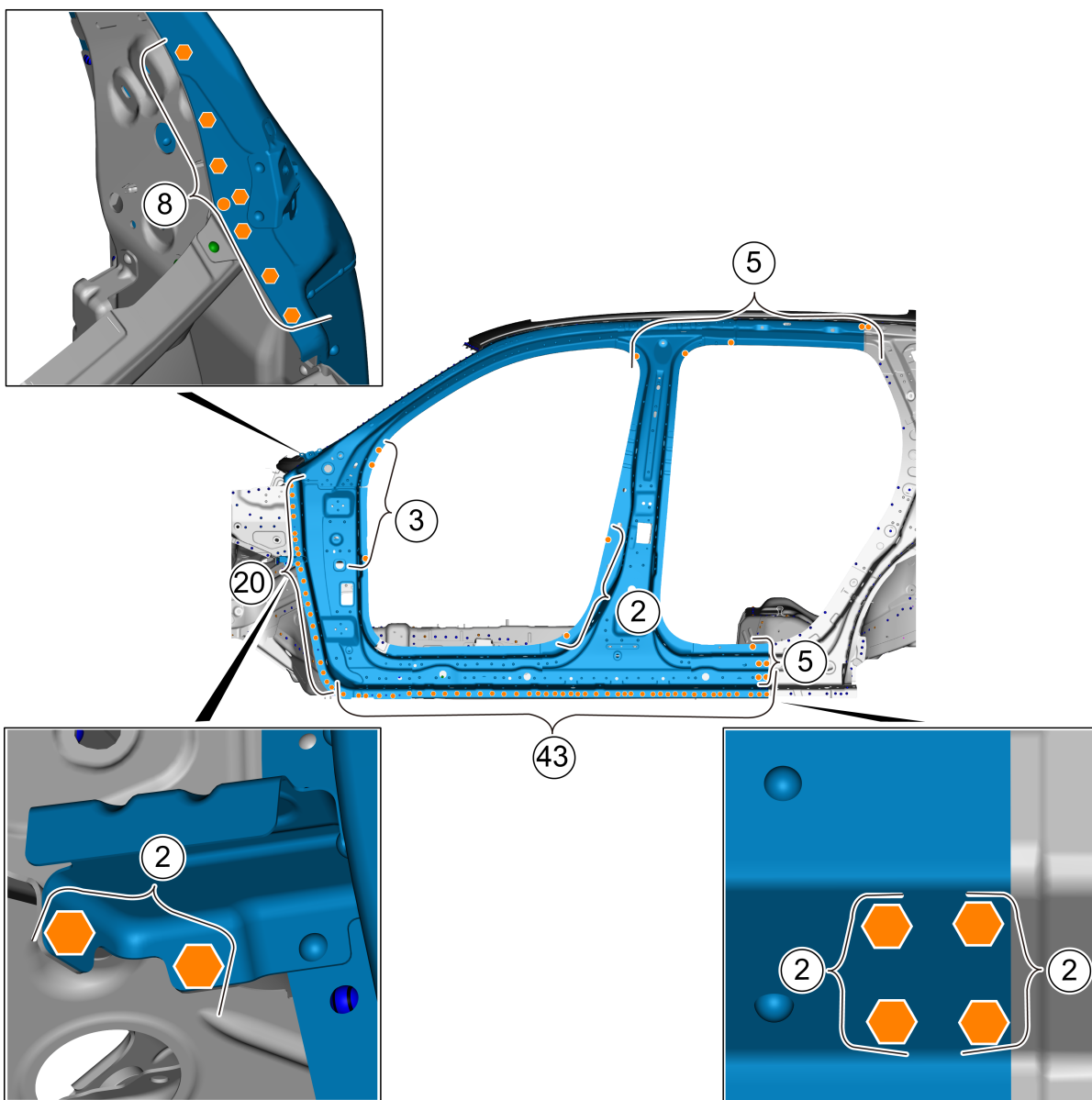
### 4.2.17.1 Removal of the Left Sidewall Front Reinforcement Plate Assembly

#### Removal of Parts

#### Caution

Remove the left and right sides in the same way.

1. Remove the left sidewall front connecting plate assembly, refer to [Removal of the Left Sidewall Front Connecting Plate Assembly](#).
2. Remove the left sidewall outer plate, refer to [Removal of the Left Sidewall Outer Plate](#).
3. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the left sidewall front reinforcement plate assembly to the left A-pillar inner plate assembly and the left door sill inner plate assembly.

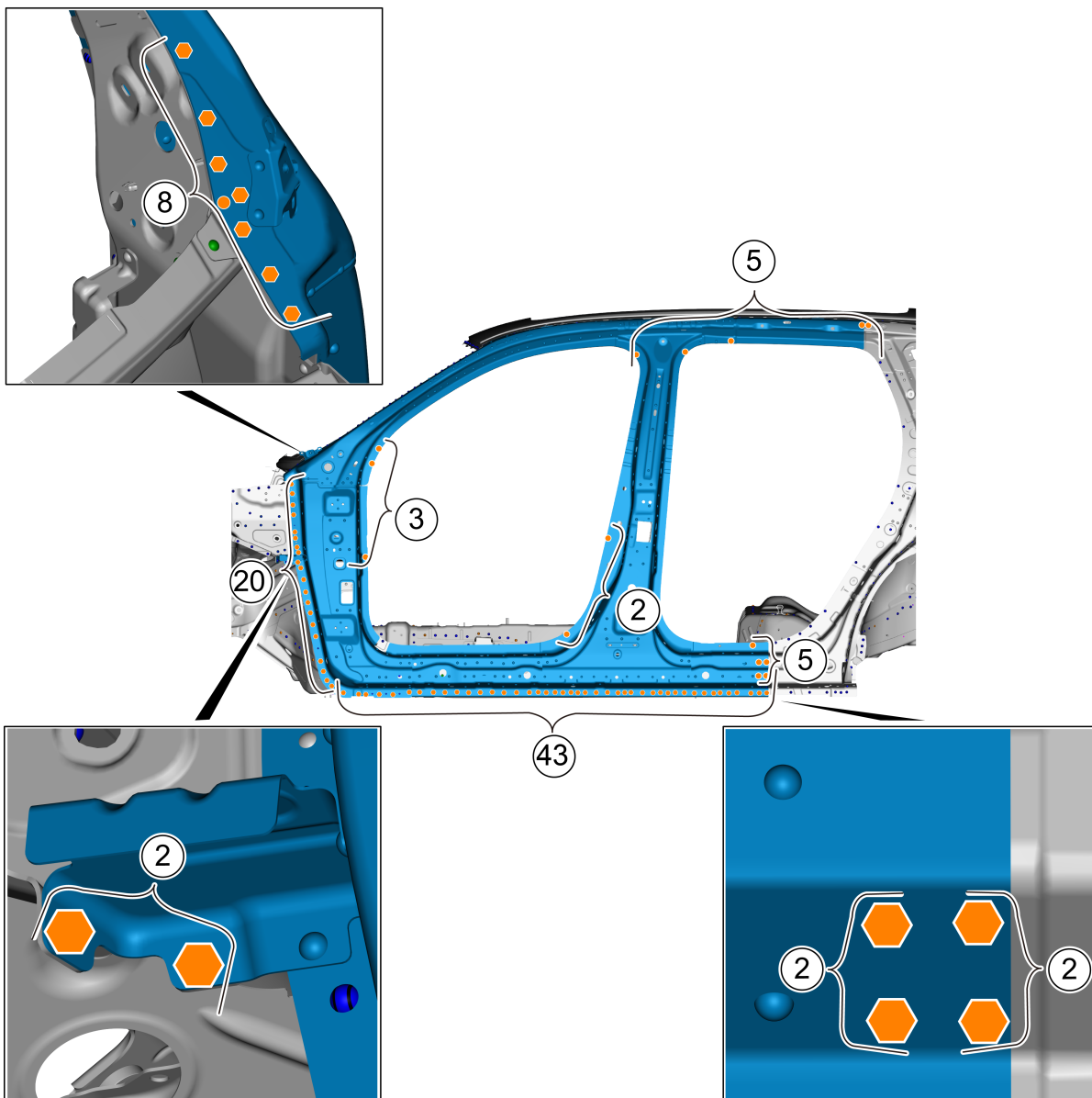


4. Grind away any welding marks that may remain on the body surface and sand the welded surfaces to bare metal (remove surface foreign matter, paint and rust).

## 4.2.18 Installation of the Left Sidewall Front Reinforcement Plate Assembly

### 4.2.18.1 Installation of the Left Sidewall Front Reinforcement Plate Assembly

1. When installing a new part, match the mounting position of the new part on the body.
2. Temporarily install the new part for initial positioning.
3. Check and measure the positional dimensions of the left sidewall front reinforcement plate assembly and the body for compliance with the standard, and adjust if necessary.
4. Weld the fixing points of the left sidewall front reinforcement plate assembly to the left A-pillar inner plate assembly and the left door sill inner plate assembly.



5. Install the left sidewall outer plate.
6. Install the left sidewall front connecting plate assembly.

## 4.2.19 Removal of the Left A-pillar Inner Plate Assembly

### 4.2.19.1 Removal of the Left A-pillar Inner Plate Assembly

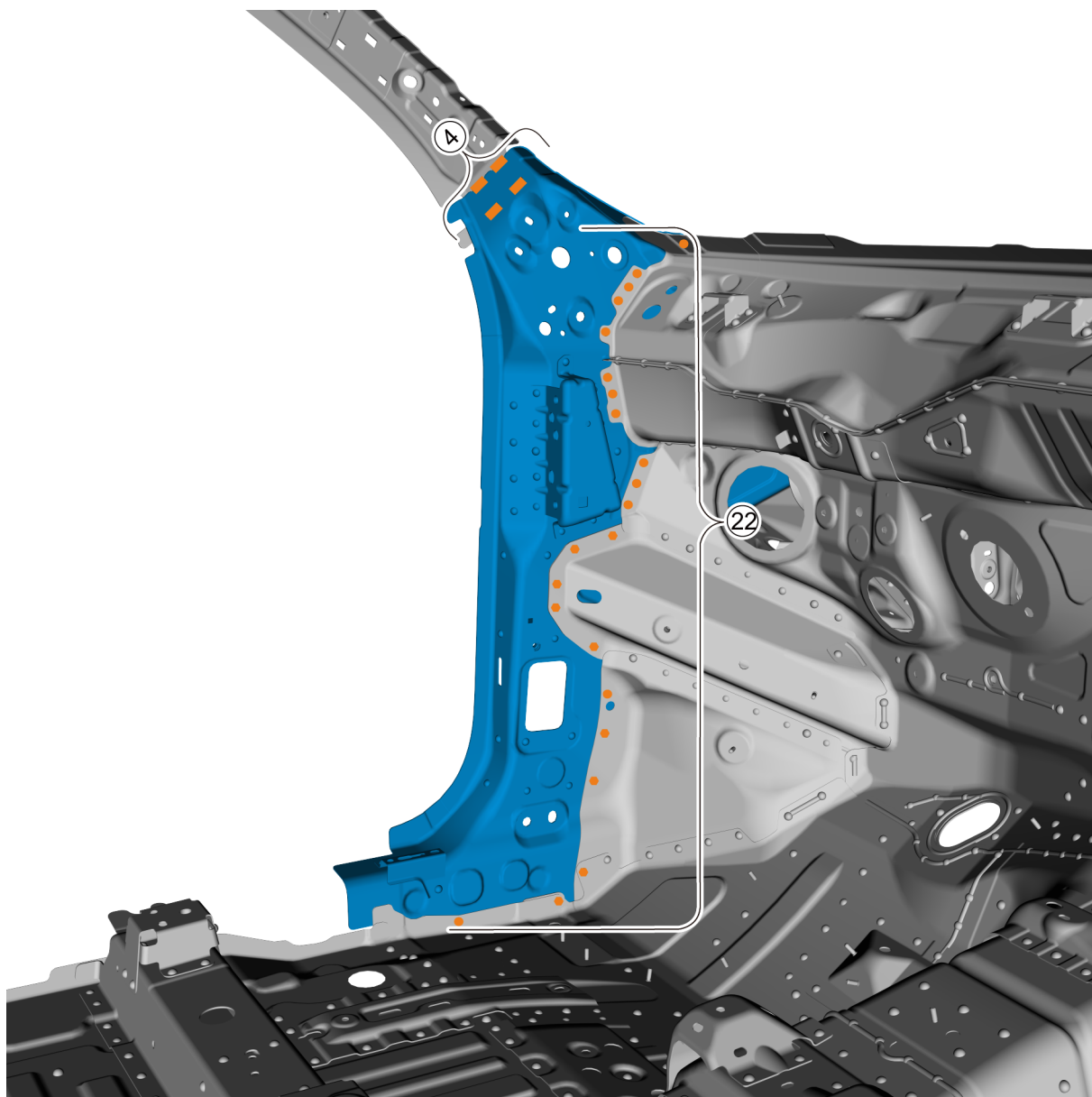
Removal of Parts

#### Caution

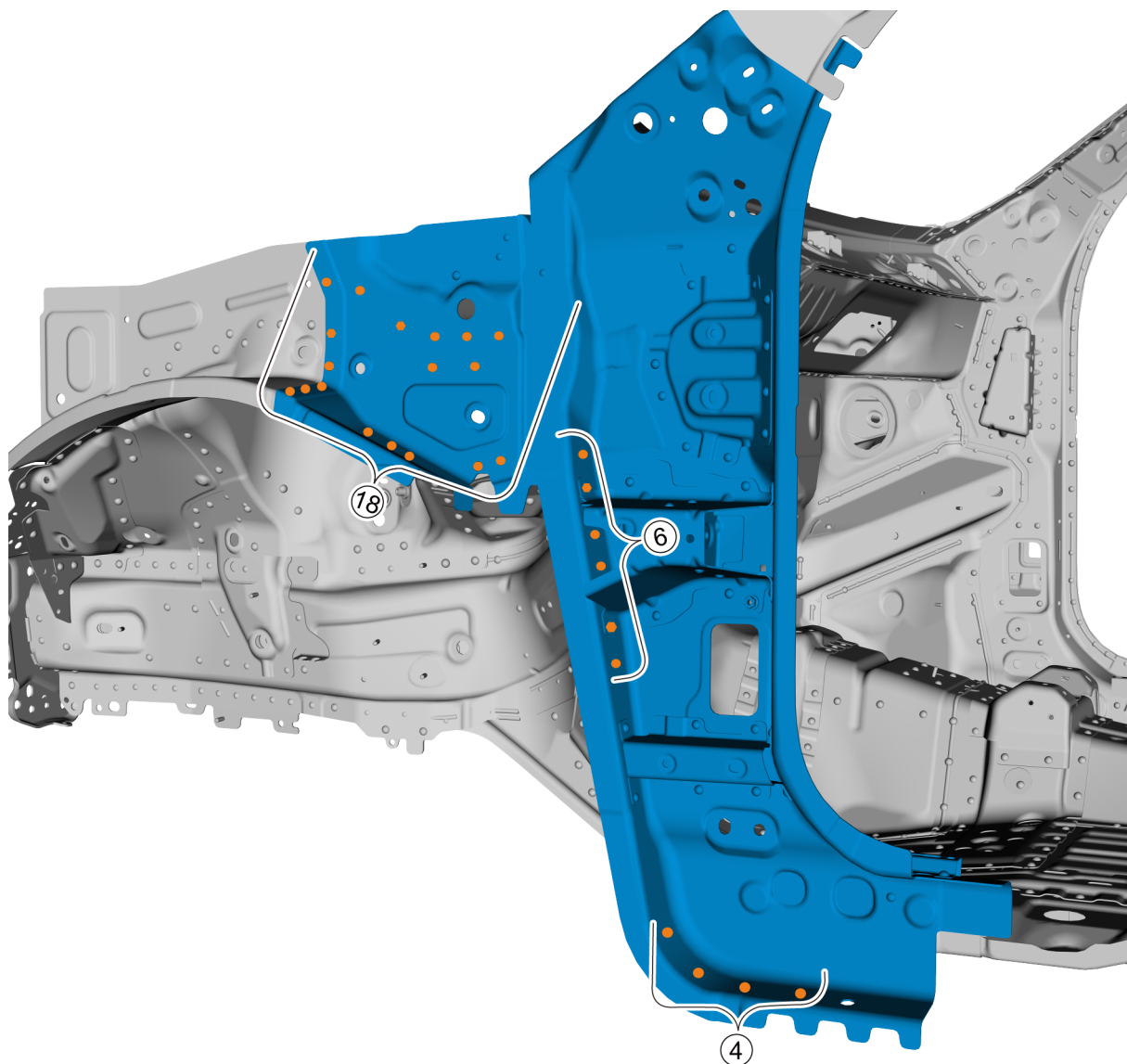
Remove the left and right sides in the same way.

1. Remove the large sunroof top cover assembly, refer to [Removal of the Large Sunroof Top Cover Assembly](#).
2. Remove the left sidewall outer plate, refer to [Removal of the Left Sidewall Outer Plate](#).
3. Remove the left sidewall front connecting plate assembly, refer to [Removal of the Left Sidewall Front Connecting Plate Assembly](#).
4. Remove the left sidewall front reinforcement plate assembly, refer to [Removal of the Left Sidewall Front Reinforcement Plate Assembly](#).
5. Remove the left door sill inner plate assembly, refer to [Removal of the Left Door Sill Inner Plate Assembly](#).
6. At the welding positions shown in the figure below, drill out or grind away the welding points and remove the fixing points of the left A-pillar inner plate assembly to the front enclosure assembly and the left front longitudinal beam assembly and the left sidewall front inner plate assembly.





7. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the left A-pillar inner plate assembly to the left front longitudinal beam assembly and the left front wheel cover assembly.

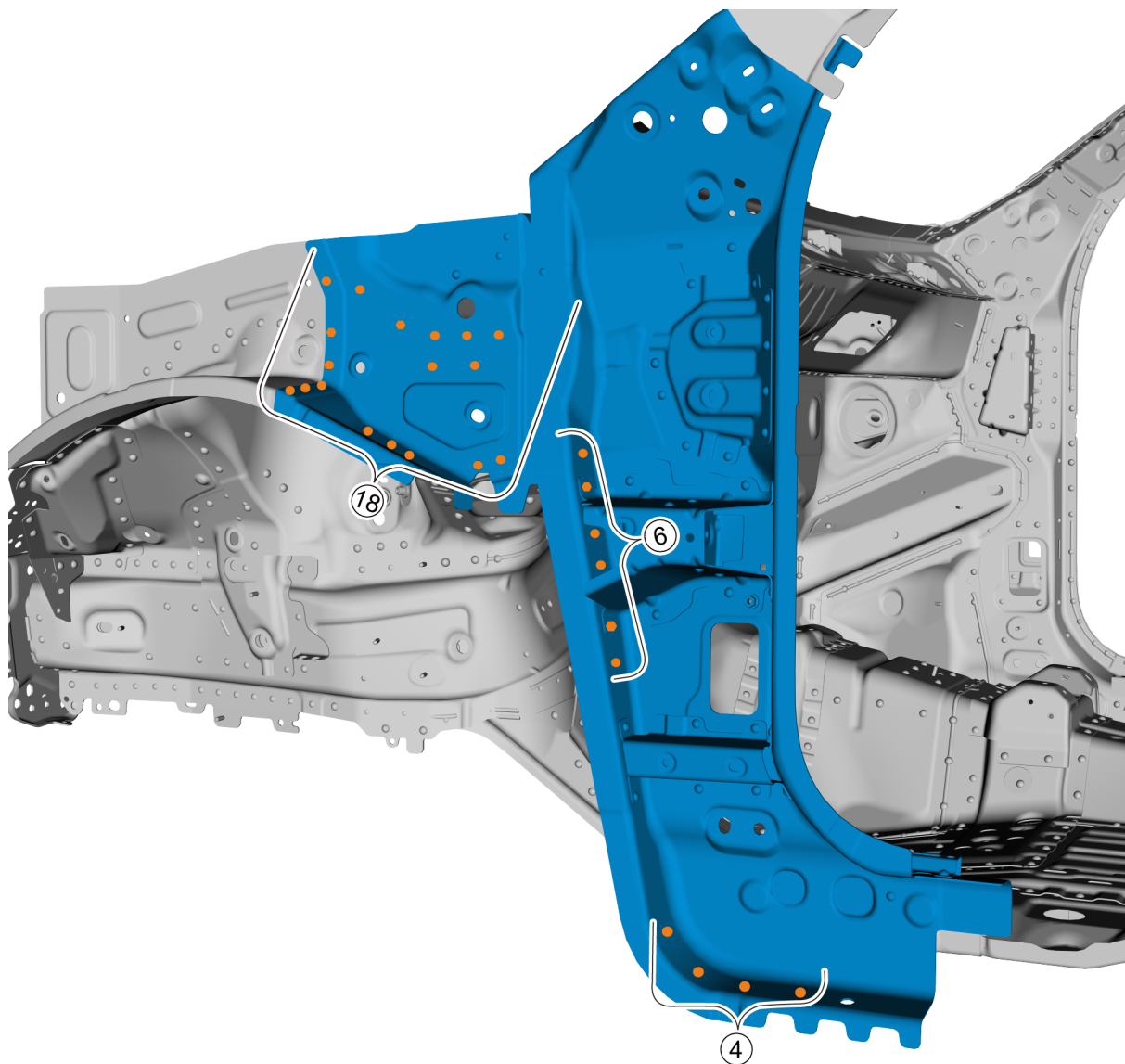


8. Grind away any welding marks that may remain on the body surface and sand the welded surfaces to bare metal (remove surface foreign matter, paint and rust).

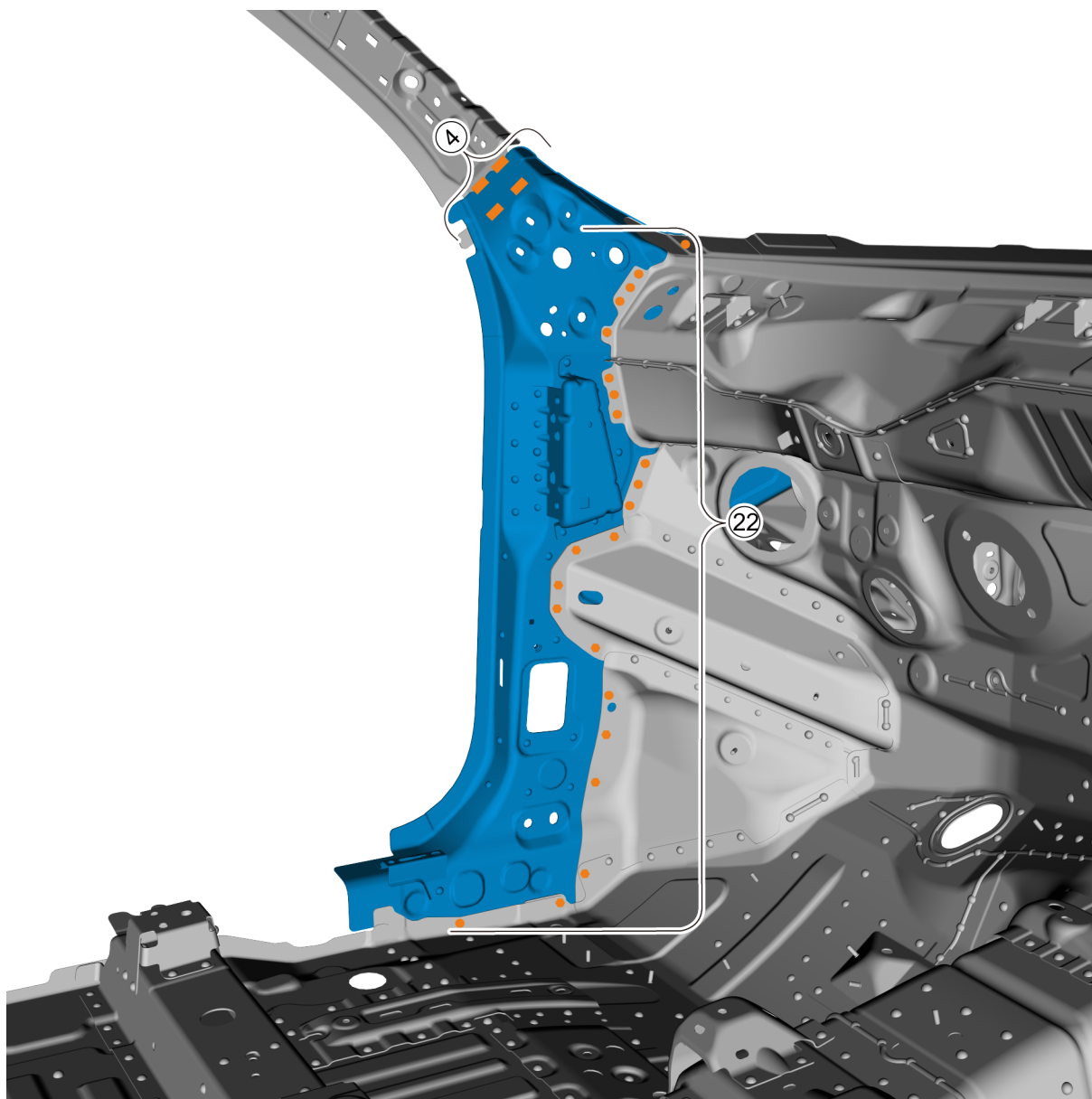
## 4.2.20 Installation of the Left A-pillar Inner Plate Assembly

### 4.2.20.1 Installation of the Left A-pillar Inner Plate Assembly

1. When installing a new part, match the mounting position of the new part on the body.
2. Temporarily install the new part for initial positioning.
3. Check and measure the positional dimensions of the left A-pillar inner plate assembly and the body for compliance with the standard, and adjust if necessary.
4. Weld the fixing points of the left A-pillar inner plate assembly to the left front longitudinal beam assembly and the left front wheel cover assembly.



5. Weld the fixing points of the left A-pillar inner plate assembly to the front enclosure assembly and the left front longitudinal beam assembly and the left sidewall front inner plate assembly.



6. Install the left door sill inner plate assembly
7. Install the left sidewall front reinforcement plate assembly.
8. Install the left sidewall front connecting plate assembly.
9. Install the left sidewall outer plate.
10. Install the large sunroof top cover assembly.

## 4.2.21 Removal of the Left Sidewall Front Inner Plate Assembly

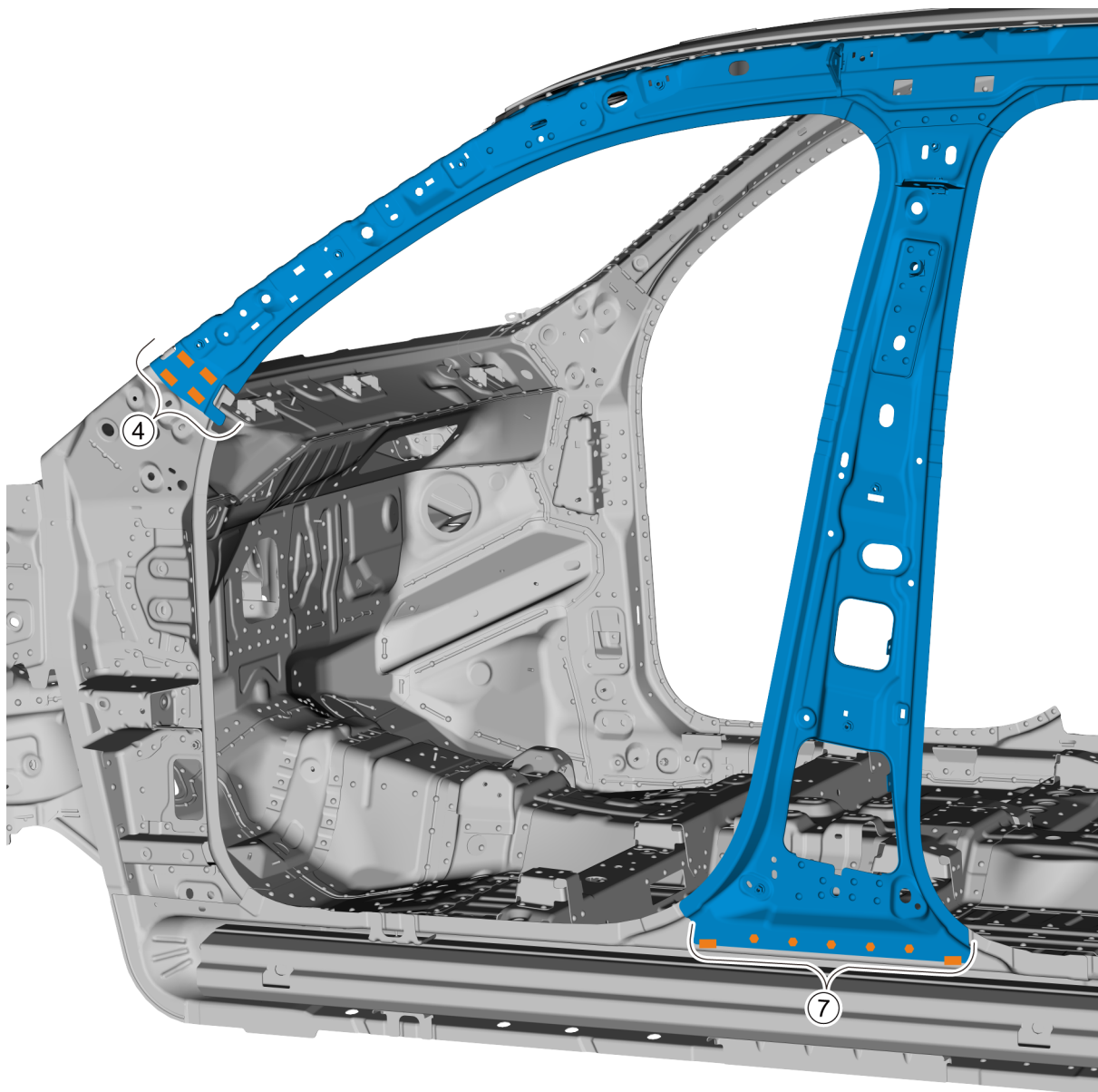
### 4.2.21.1 Removal of the Left Sidewall Front Inner Plate Assembly

#### Removal of Parts

#### Caution

Remove the left and right sides in the same way.

1. Remove the left sidewall front connecting plate assembly, refer to [Removal of the Left Sidewall Front Connecting Plate Assembly](#).
2. Remove the left sidewall outer plate, refer to [Removal of the Left Sidewall Outer Plate](#).
3. Remove the left sidewall front reinforcement plate assembly, refer to [Removal of the Left Sidewall Front Reinforcement Plate Assembly](#).
4. At the welding positions shown in the figure below, drill out or grind away the welding points and remove the fixing points of the left sidewall front inner plate assembly to the left door sill inner plate assembly and the left A-pillar inner plate assembly.



5. At the welding positions shown in the figure below, drill out or grind away the welding points and remove the fixing points of the left sidewall front inner plate assembly to the roof front beam assembly and the left C-pillar assembly.



6. Grind away any welding marks that may remain on the body surface and sand the welded surfaces to bare metal (remove surface foreign matter, paint and rust).



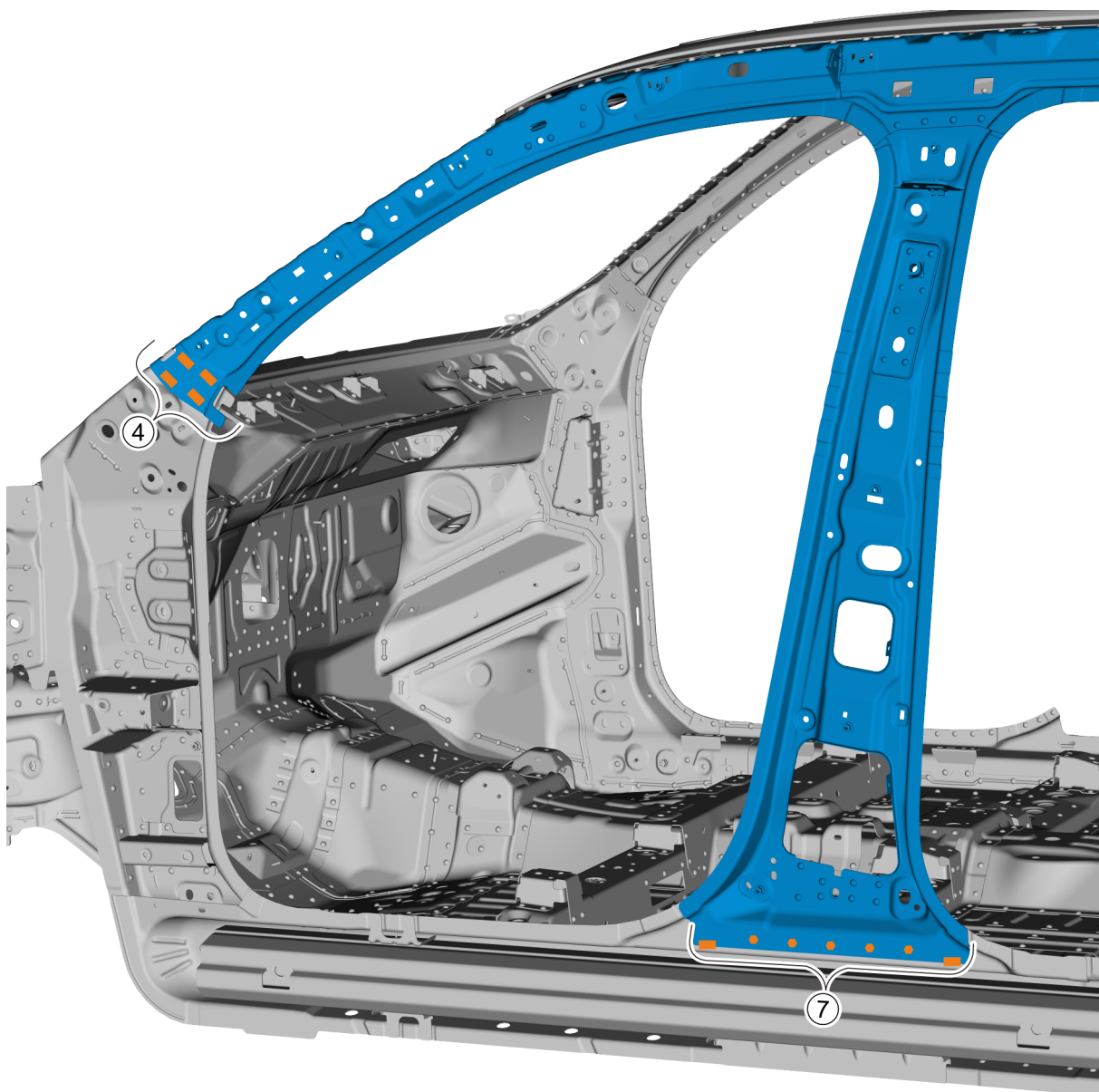
## 4.2.22 Installation of the Left Sidewall Front Inner Plate Assembly

### 4.2.22.1 Installation of the Left Sidewall Front Inner Plate Assembly

1. When installing a new part, match the mounting position of the new part on the body.
2. Temporarily install the new part for initial positioning.
3. Check and measure the positional dimensions of the left sidewall front inner plate assembly and the body for compliance with the standard, and adjust if necessary.
4. Weld the fixing points of the left sidewall front inner plate assembly to the roof front beam assembly and the left C-pillar assembly.



5. Weld the fixing points of the left sidewall front inner plate assembly to the left door sill inner plate assembly and the left A-pillar inner plate assembly.



6. Install the left sidewall front reinforcement plate assembly.
7. Install the left sidewall outer plate.
8. Install the left sidewall front connecting plate assembly.



## 4.2.23 Removal of the Left C-pillar Assembly

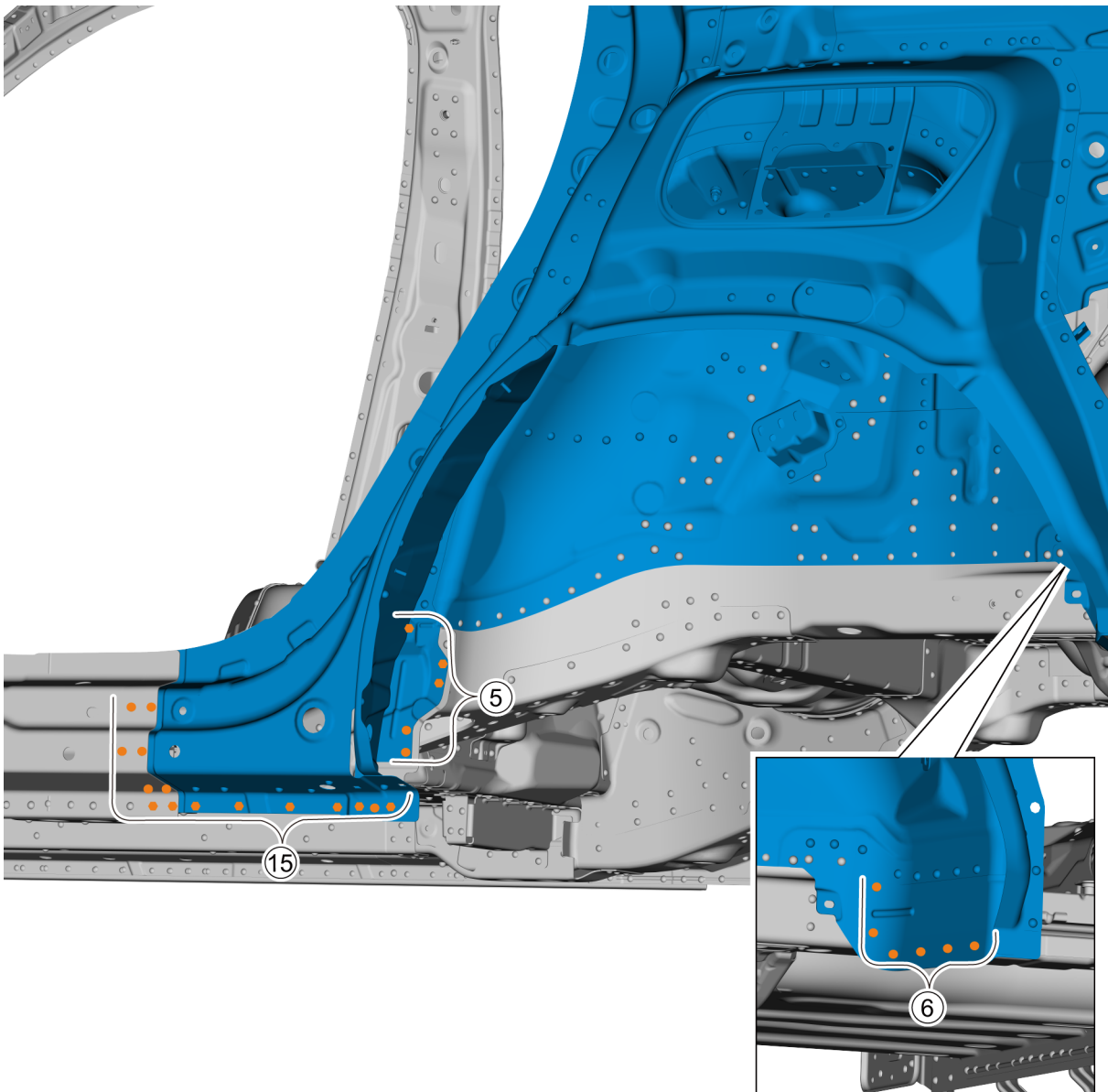
### 4.2.23.1 Removal of the Left C-pillar Assembly

Removal of Parts

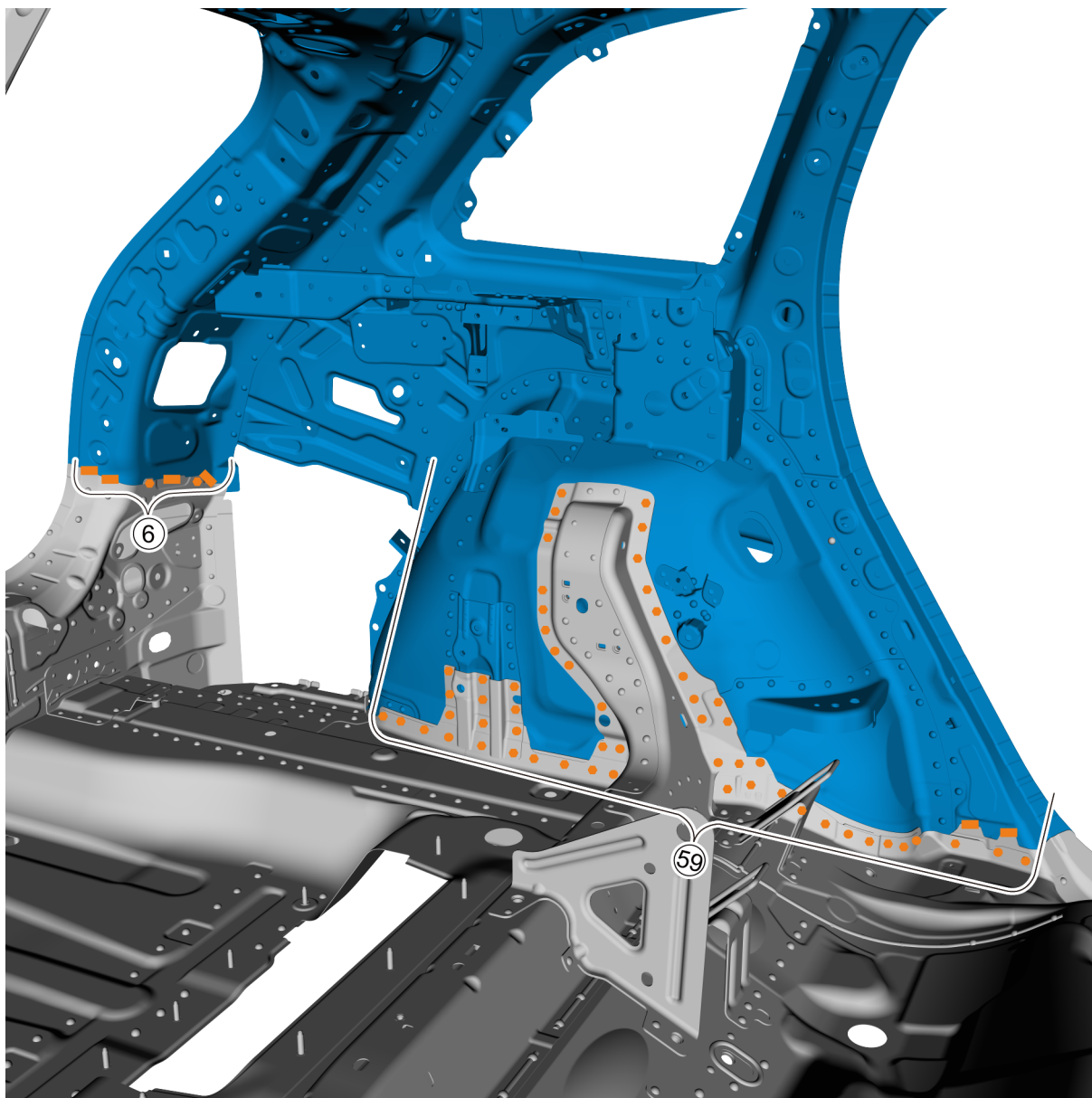
#### Caution

Remove the left and right sides in the same way.

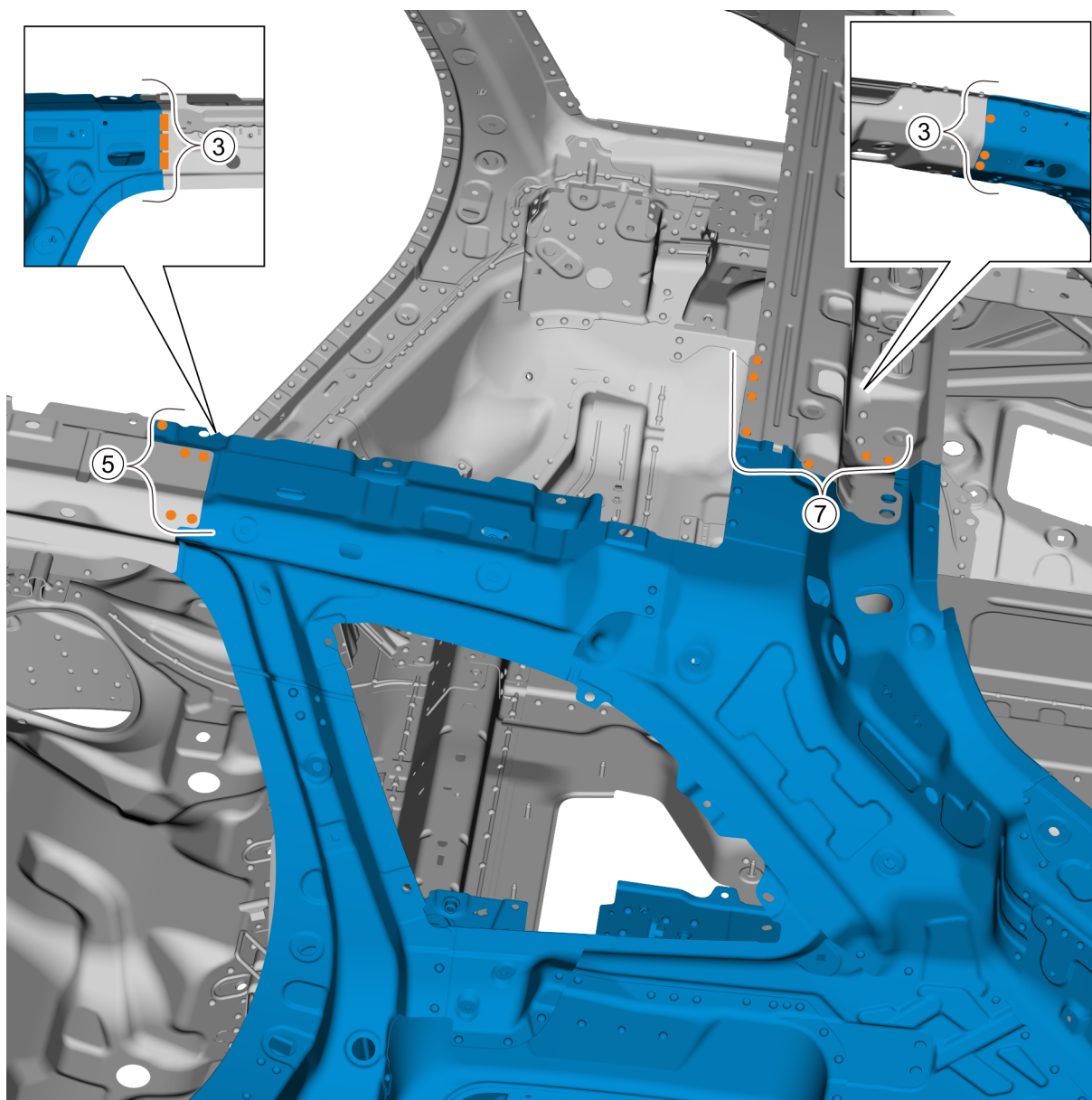
1. Remove the large sunroof top cover assembly, refer to [Removal of the Large Sunroof Top Cover Assembly](#).
2. Remove the left sidewall outer plate, refer to [Removal of the Left Sidewall Outer Plate](#).
3. Remove the left sidewall rear water channel assembly, refer to [Removal of the Left Side Rear Water Channel Assembly](#).
4. Remove the left tail light mounting plate assembly, refer to [Removal of the Left Tail Light Mounting Plate Assembly](#).
5. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the left C-pillar assembly to the rear floor left longitudinal beam assembly and the rear floor left rear connecting plate assembly and the left sidewall front reinforcement plate assembly.



6. At the welding positions shown in the figure below, drill out or grind away the welding points and remove the fixing points of the left C-pillar assembly to the rear floor body assembly and the rear floor upper beam assembly and the center floor body.



7. At the welding positions shown in the figure below, drill out or grind away the welding points and remove the fixing points of the left C-pillar assembly to the left sidewall front inner plate assembly and the left sidewall front reinforcement plate assembly and the roof rear beam assembly.

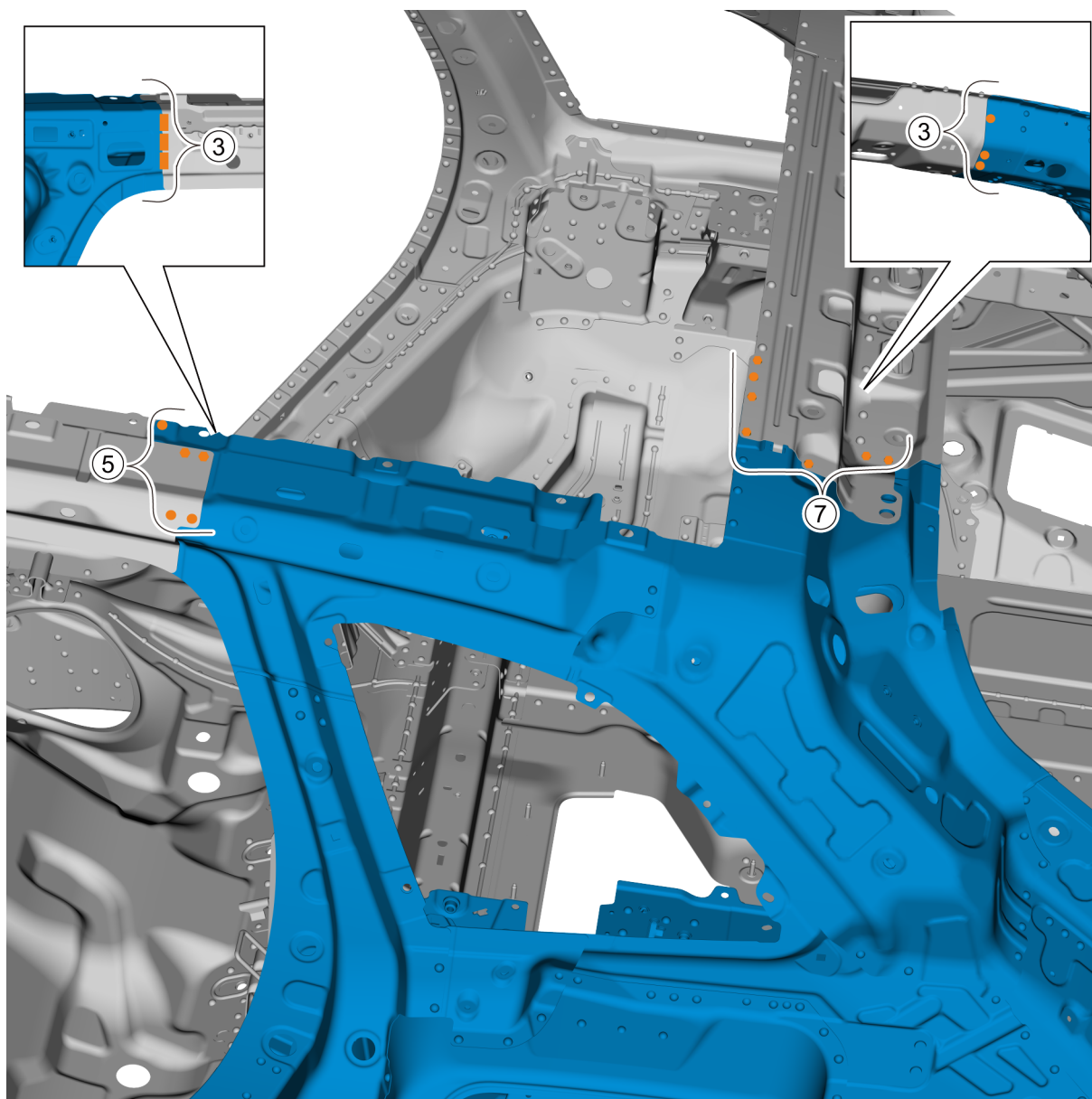


8. Grind away any welding marks that may remain on the body surface, and sand the welded surfaces to bare metal (remove surface foreign matter, paint and rust).

## 4.2.24 Installation of the Left C-pillar Assembly

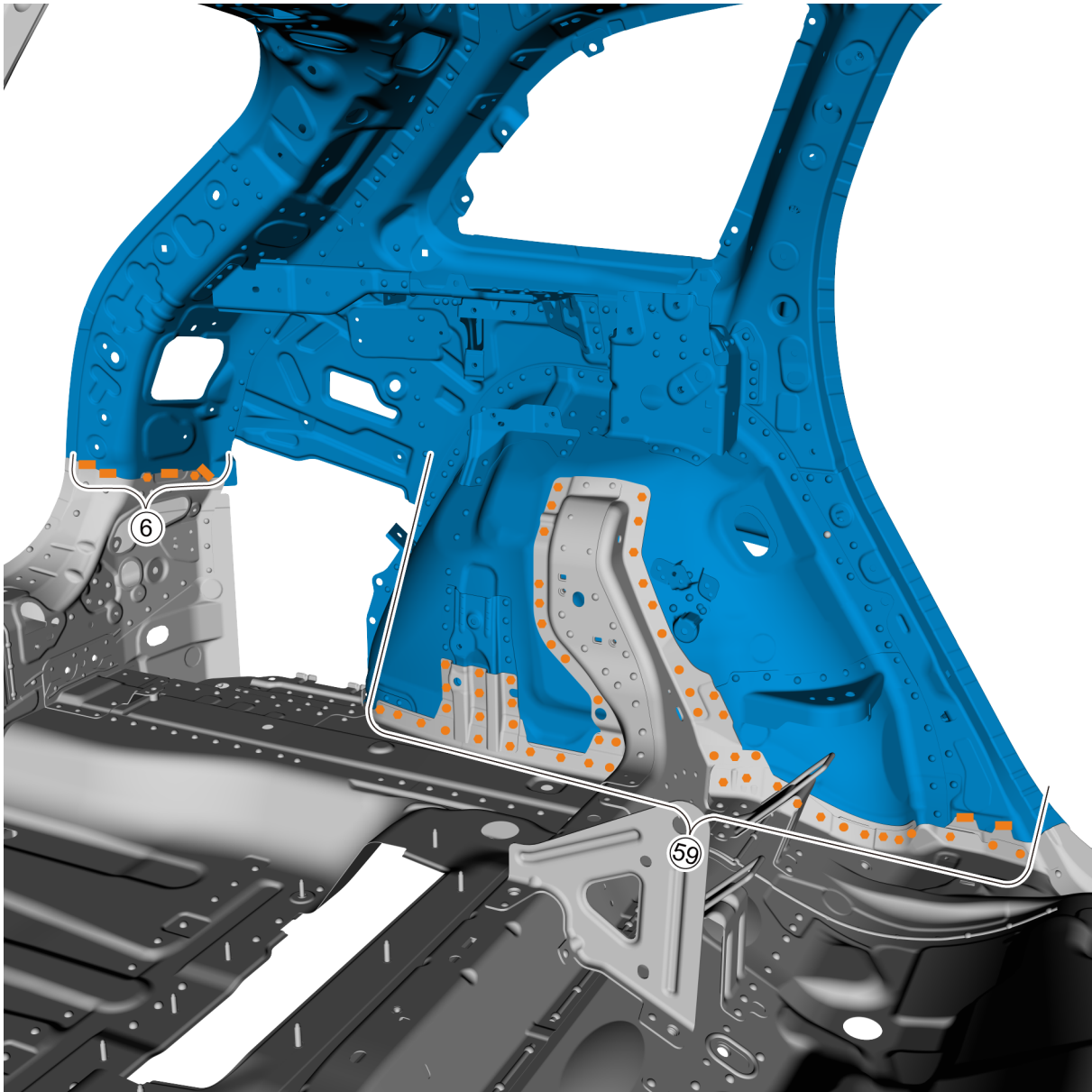
### 4.2.24.1 Installation of the Left C-pillar Assembly

1. When installing a new part, match the mounting position of the new part on the body.
2. Temporarily install the new part for initial positioning.
3. Check and measure the positional dimensions of the left C-pillar assembly and the body for compliance with the standard, and adjust if necessary.
4. Weld the fixing points of the left C-pillar assembly to the left sidewall front inner plate assembly and the left sidewall front reinforcement plate assembly and the roof rear beam assembly.

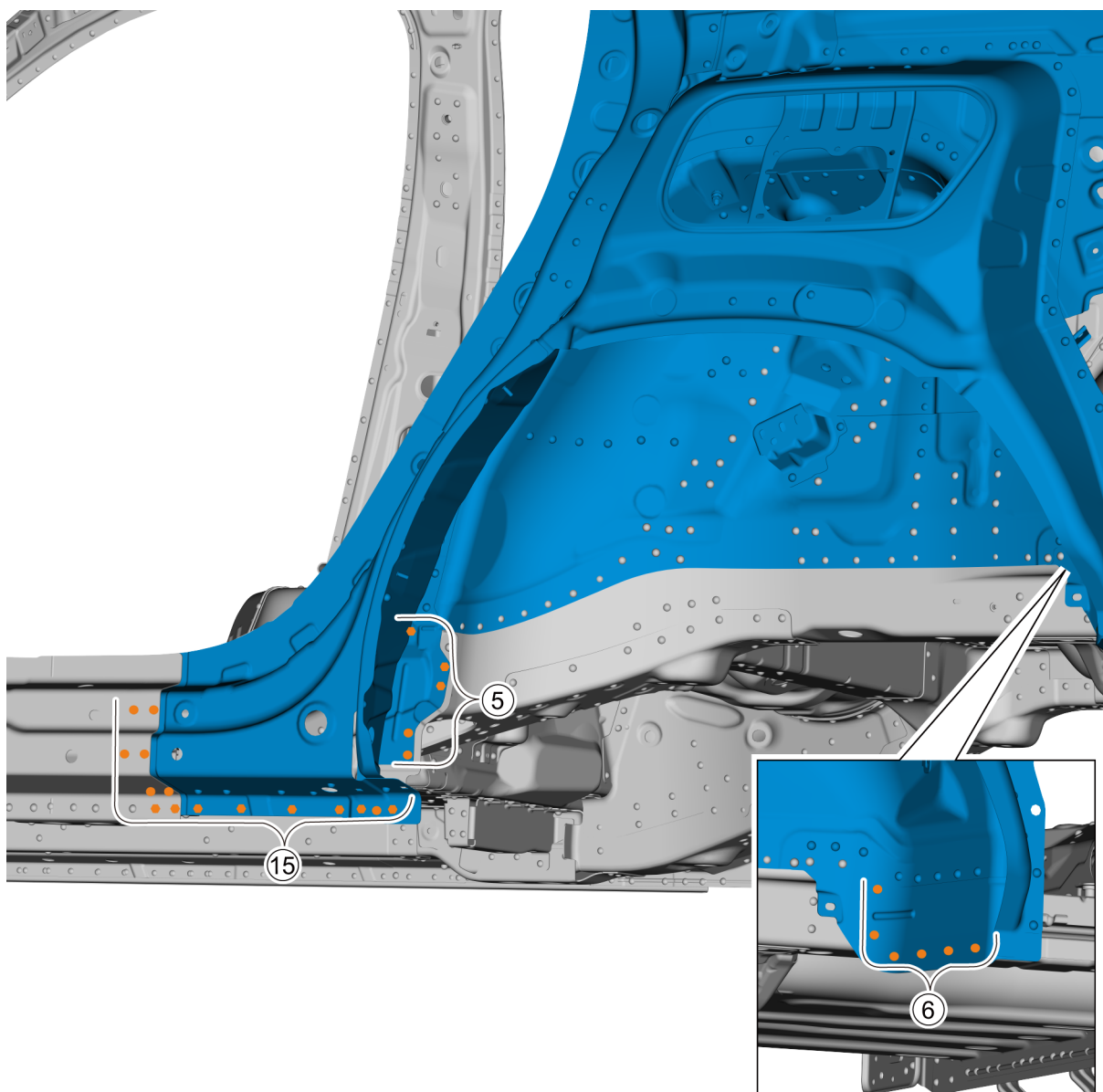




5. Weld the fixing points of the left C-pillar assembly to the rear floor body assembly and the rear floor upper beam assembly and the center floor body.



6. Weld the fixing points of the left C-pillar assembly to the rear floor left longitudinal beam assembly and the rear floor left rear connecting plate assembly and the left sidewall front reinforcement plate assembly.



7. Install the left tail light mounting plate assembly.
8. Install the left sidewall rear water channel assembly.
9. Install the left sidewall outer plate.
10. Install the large sunroof top cover assembly.

## 4.2.25 Removal of the Left Rear Wheel Cover Outer Plate Assembly

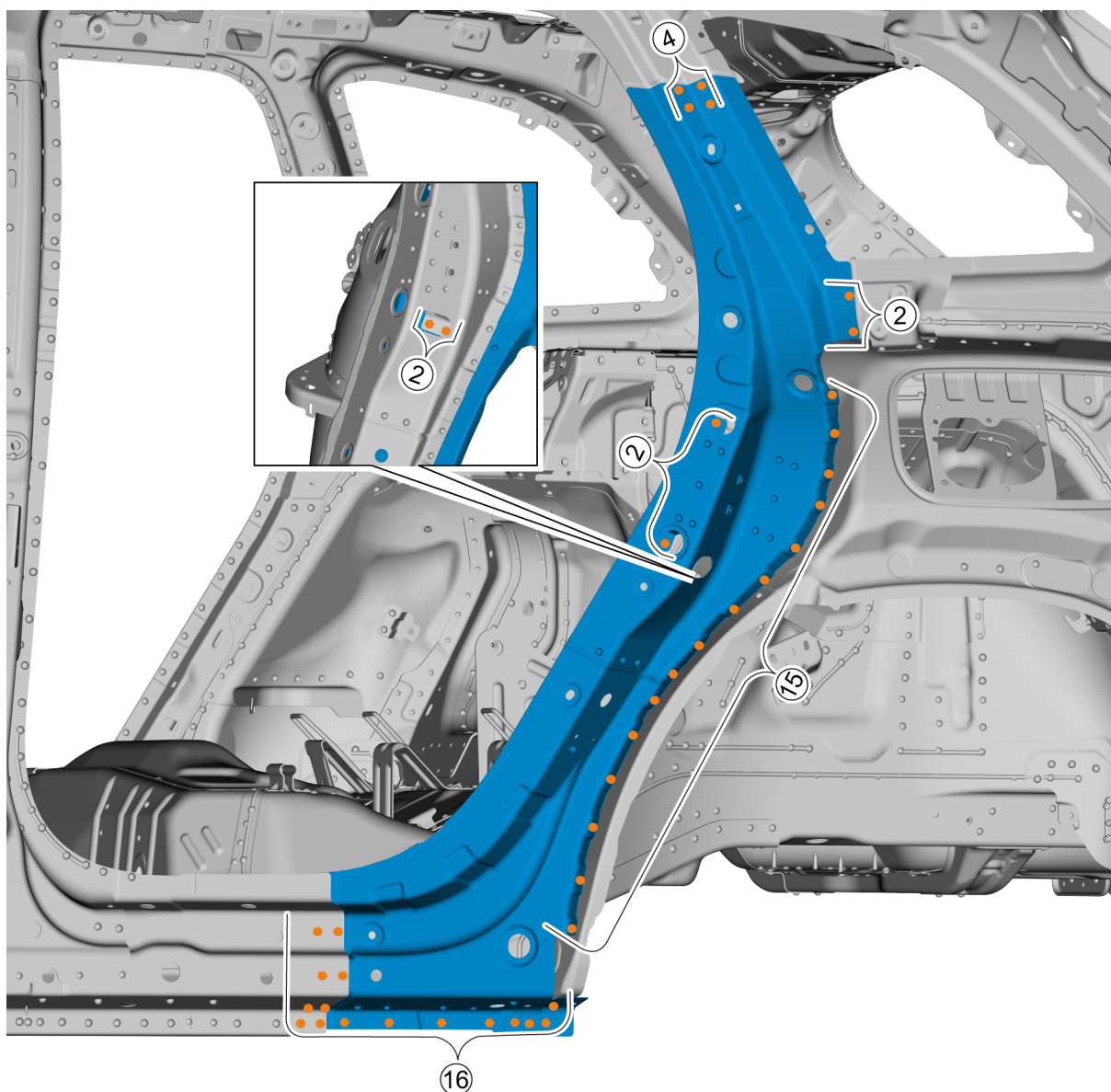
### 4.2.25.1 Removal of the Left Rear Wheel Cover Outer Plate Assembly

Removal of Parts

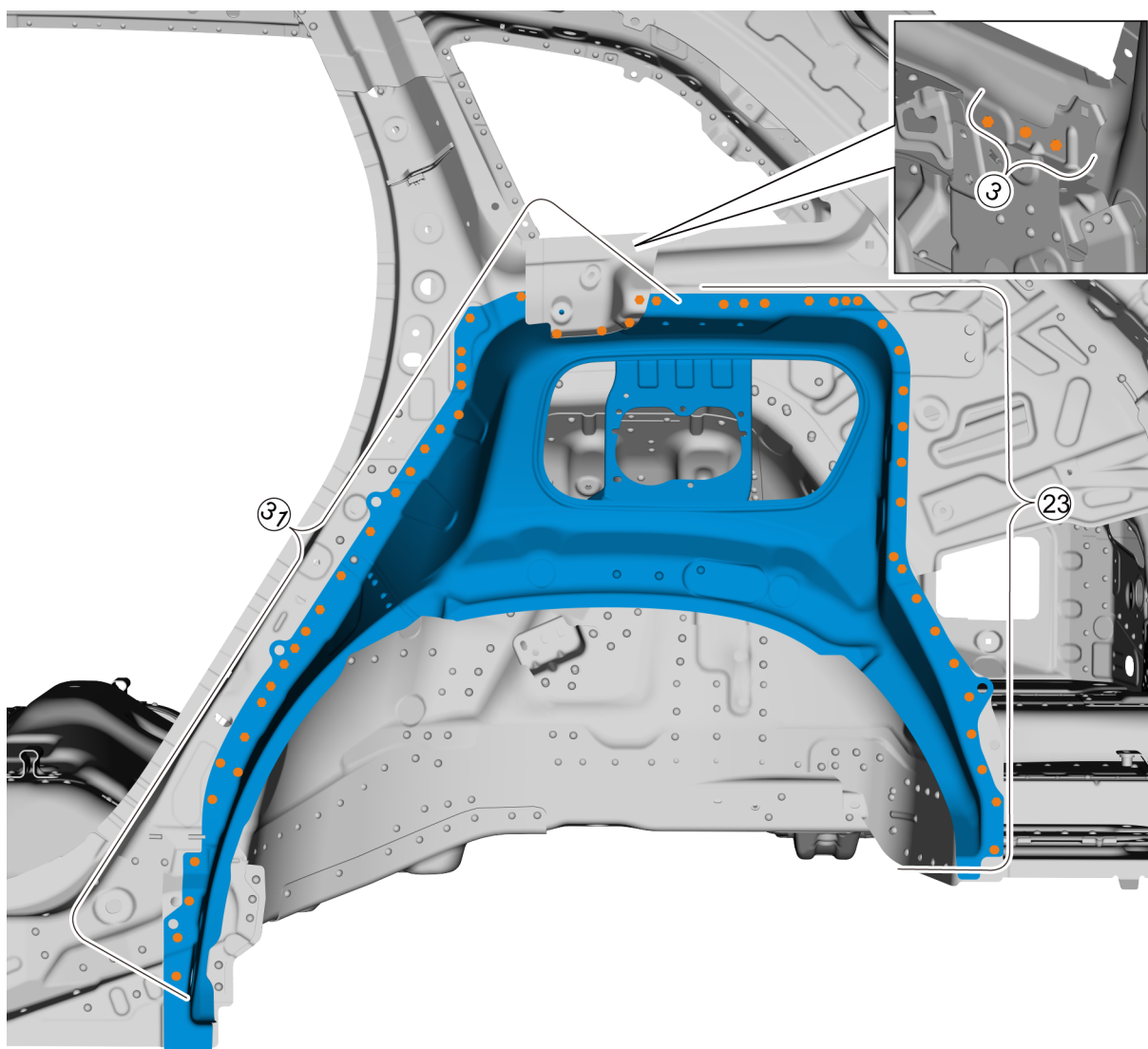
#### Caution

Remove the left and right sides in the same way.

1. Remove the large sunroof top cover assembly, refer to [Removal of the Large Sunroof Top Cover Assembly](#).
2. Remove the left sidewall outer plate, refer to [Removal of the Left Sidewall Outer Plate](#).
3. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the left C-pillar assembly to the left C-pillar reinforcement plate and the left C-pillar lower reinforcement plate.



4. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the left rear wheel cover outer plate assembly to the left C-pillar assembly.



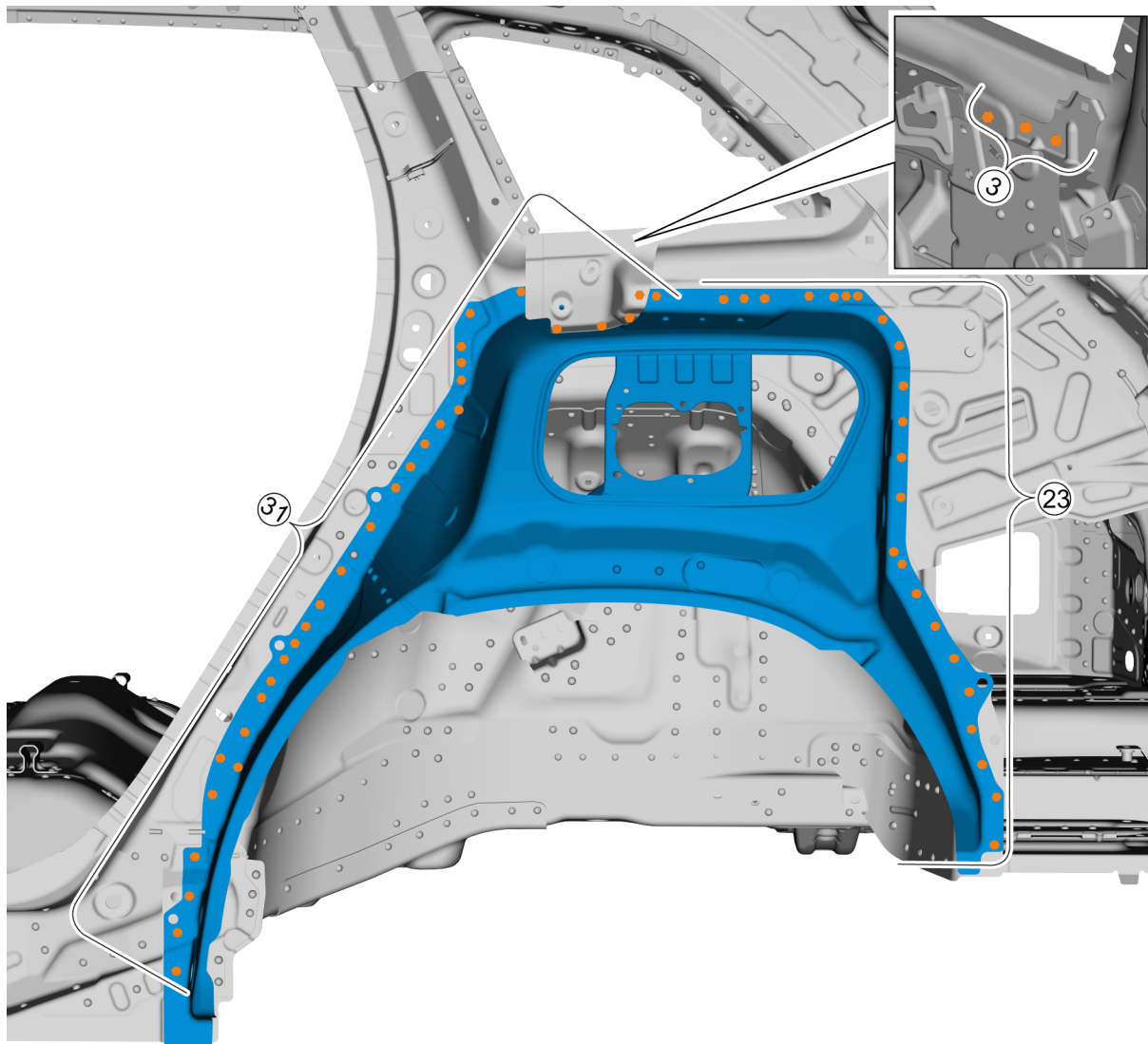
5. Grind away any welding marks that may remain on the body surface, and sand the welded surfaces to bare metal (remove surface foreign matter, paint and rust).



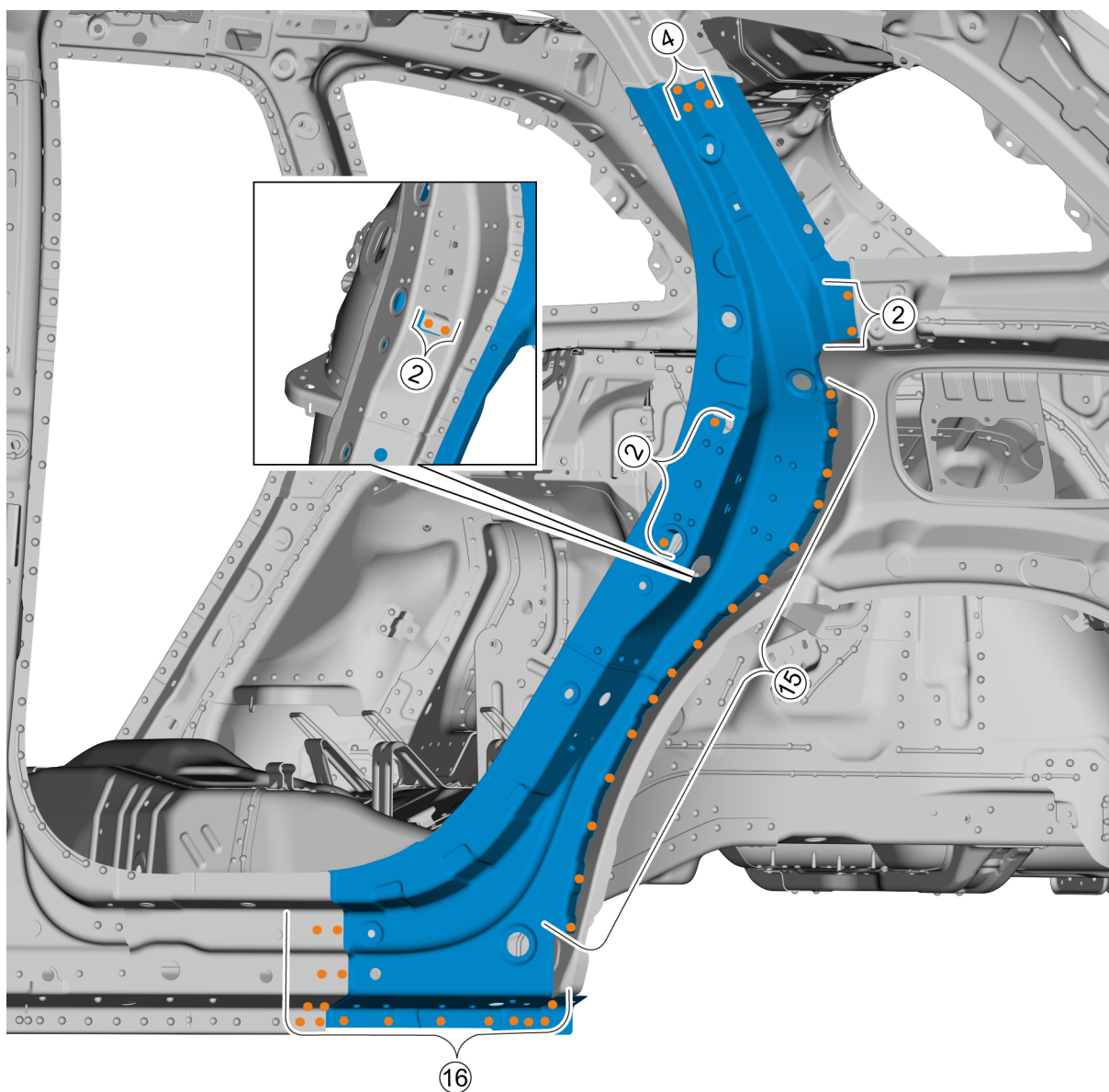
## 4.2.26 Installation of the Left Rear Wheel Cover Outer Plate Assembly

### 4.2.26.1 Installation of the Left Rear Wheel Cover Outer Plate Assembly

1. When installing a new part, match the mounting position of the new part on the body.
2. Temporarily install the new part for initial positioning.
3. Check and measure the positional dimensions of the left rear wheel cover outer plate assembly and the left C-pillar assembly for compliance with the standard, and adjust if necessary.
4. Weld the fixing points of the left rear wheel cover outer plate assembly to the left C-pillar assembly.



5. Weld the fixing points of the left C-pillar assembly to the left C-pillar reinforcement plate and the left C-pillar lower reinforcement plate.



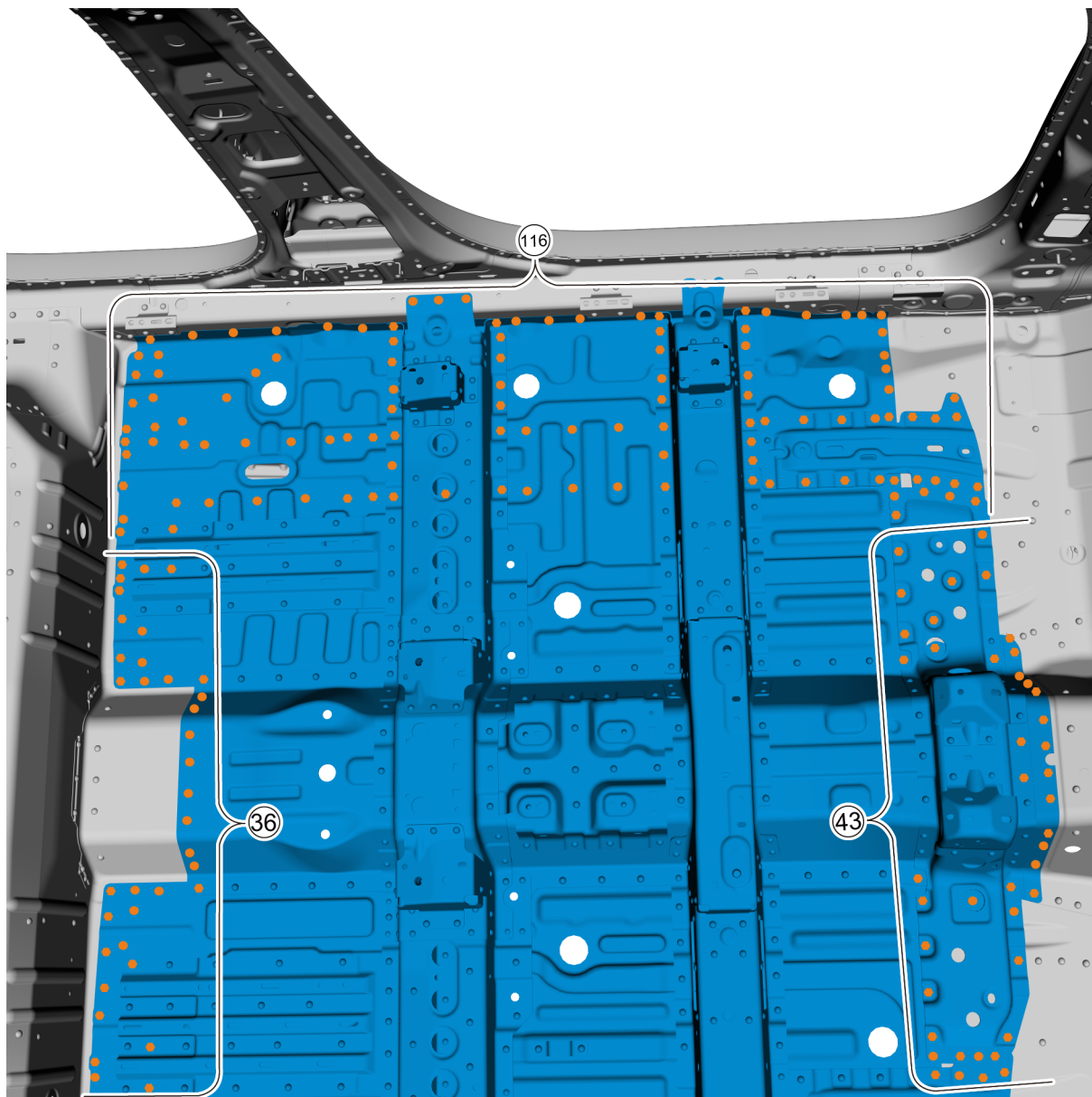
6. Install the left sidewall outer plate.
7. Install the large sunroof top cover assembly.

## 4.2.27 Removal of the Front Floor Assembly

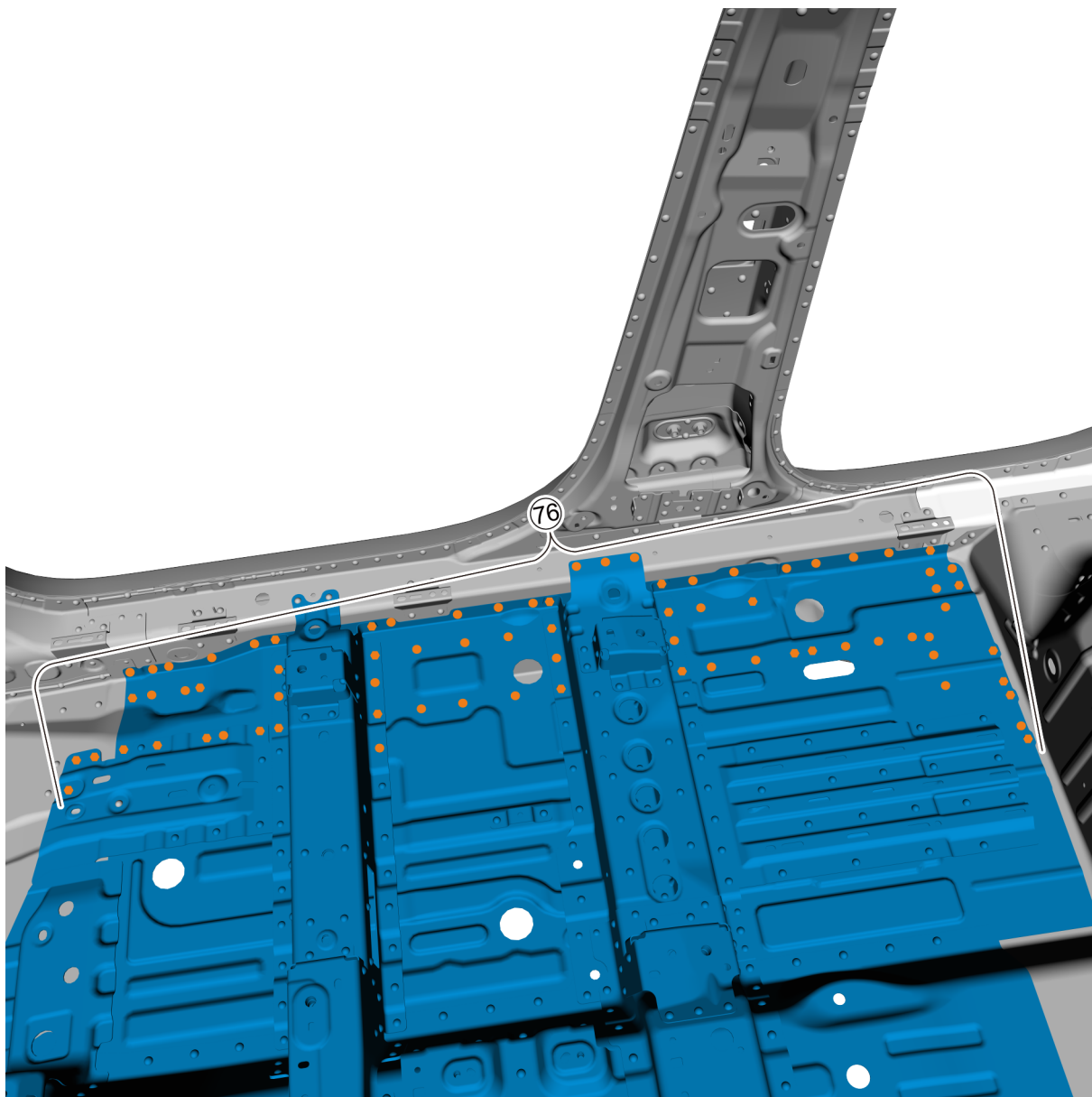
### 4.2.27.1 Removal of the Front Floor Assembly

#### Removal of Parts

1. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the front floor assembly to the left door sill inner plate assembly and the center floor front connecting plate assembly and the front enclosure lower plate assembly.



2. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the front floor assembly to the right door sill inner plate assembly and the center floor front connecting plate assembly and the front enclosure lower plate assembly.

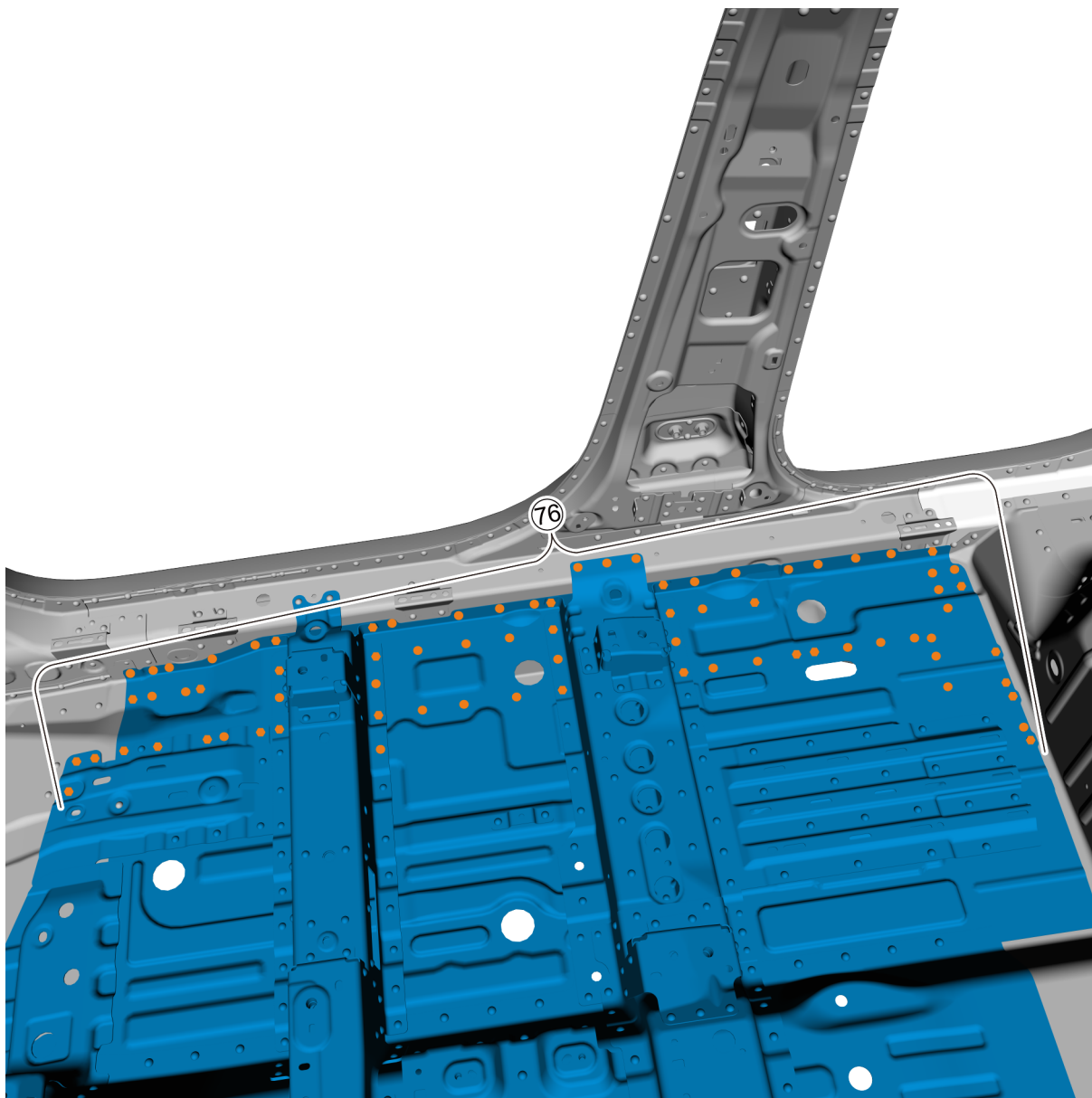


3. Grind away any welding marks that may remain on the body surface and sand the welded surfaces to bare metal (remove surface foreign matter, paint and rust).

## 4.2.28 Installation of the Front Floor Assembly

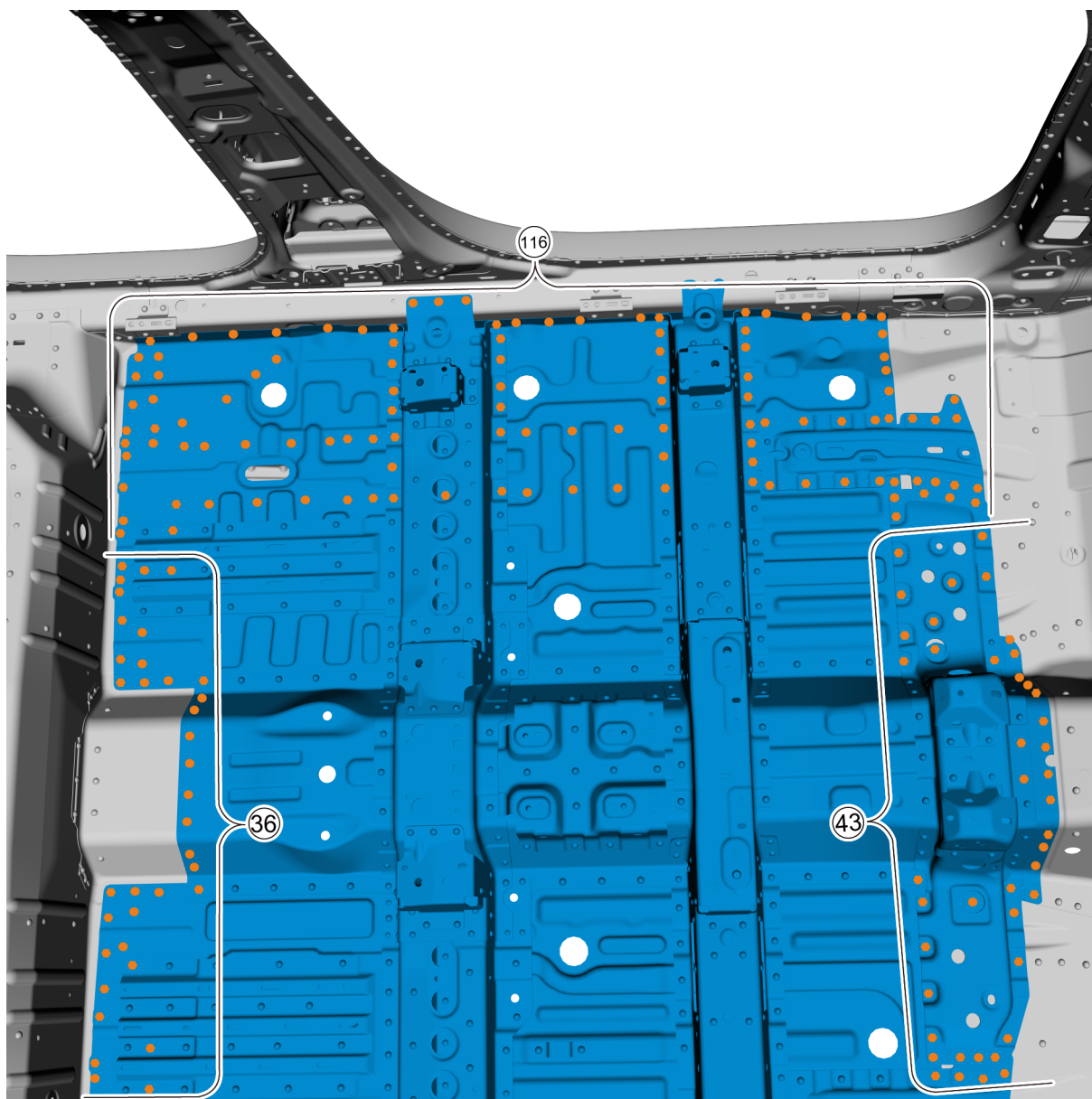
### 4.2.28.1 Installation of the Front Floor Assembly

1. When installing a new part, match the mounting position of the new part on the body.
2. Temporarily install the new part for initial positioning.
3. Check and measure the positional dimensions of the front floor assembly and the body for compliance with the standard, and adjust if necessary.
4. Weld the fixing points of the front floor assembly to the right door sill inner plate assembly and the center floor front connecting plate assembly and front enclosure lower plate assembly.





5. Weld the fixing points of the front floor assembly to the left door sill inner plate assembly and the center floor front connecting plate assembly and the front enclosure lower plate assembly.



## 4.2.29 Removal of the Left Door Sill Inner Plate Assembly

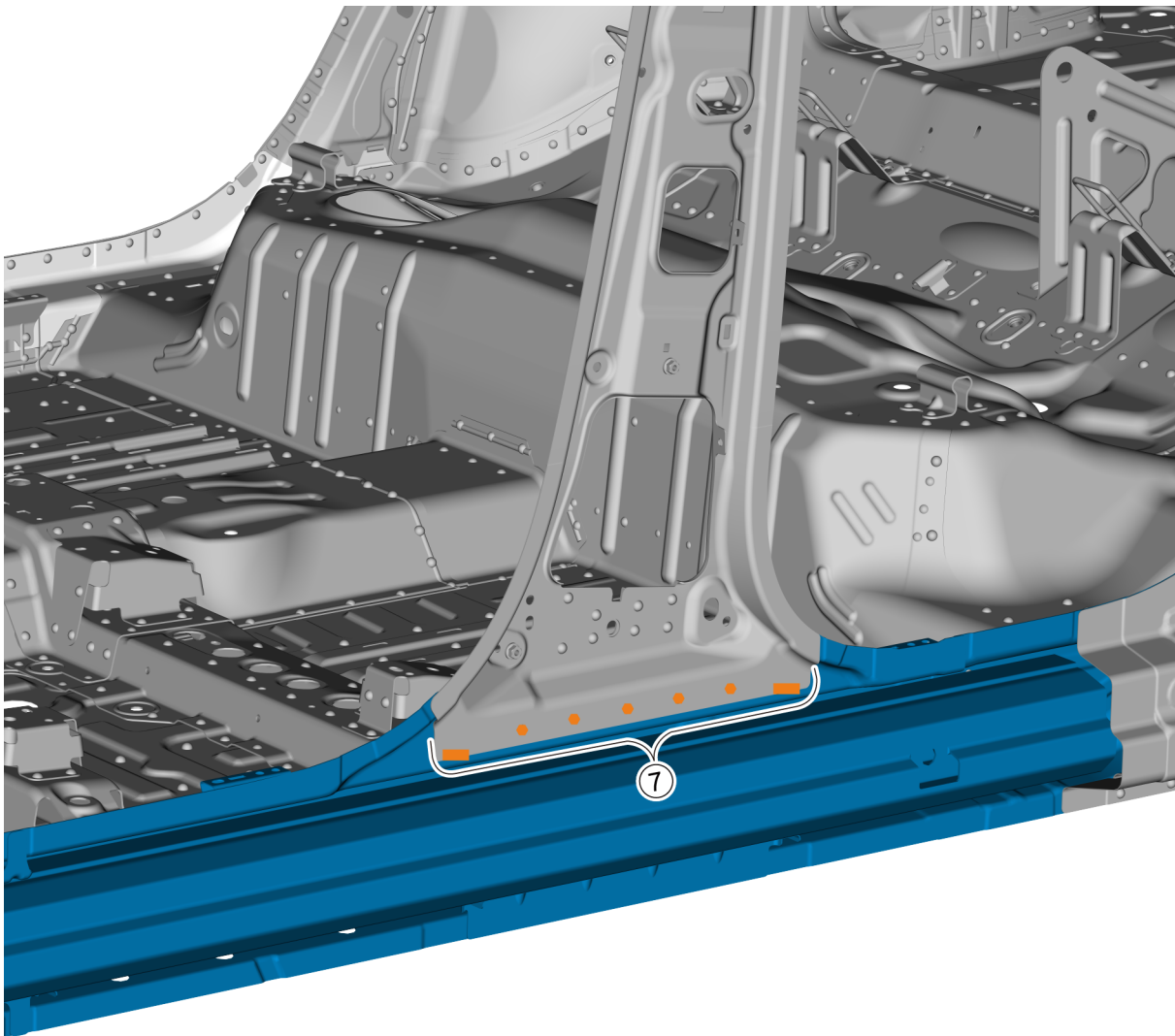
### 4.2.29.1 Removal of the Left Door Sill Inner Plate Assembly

Removal of Parts

#### Caution

Remove the left and right sides in the same way.

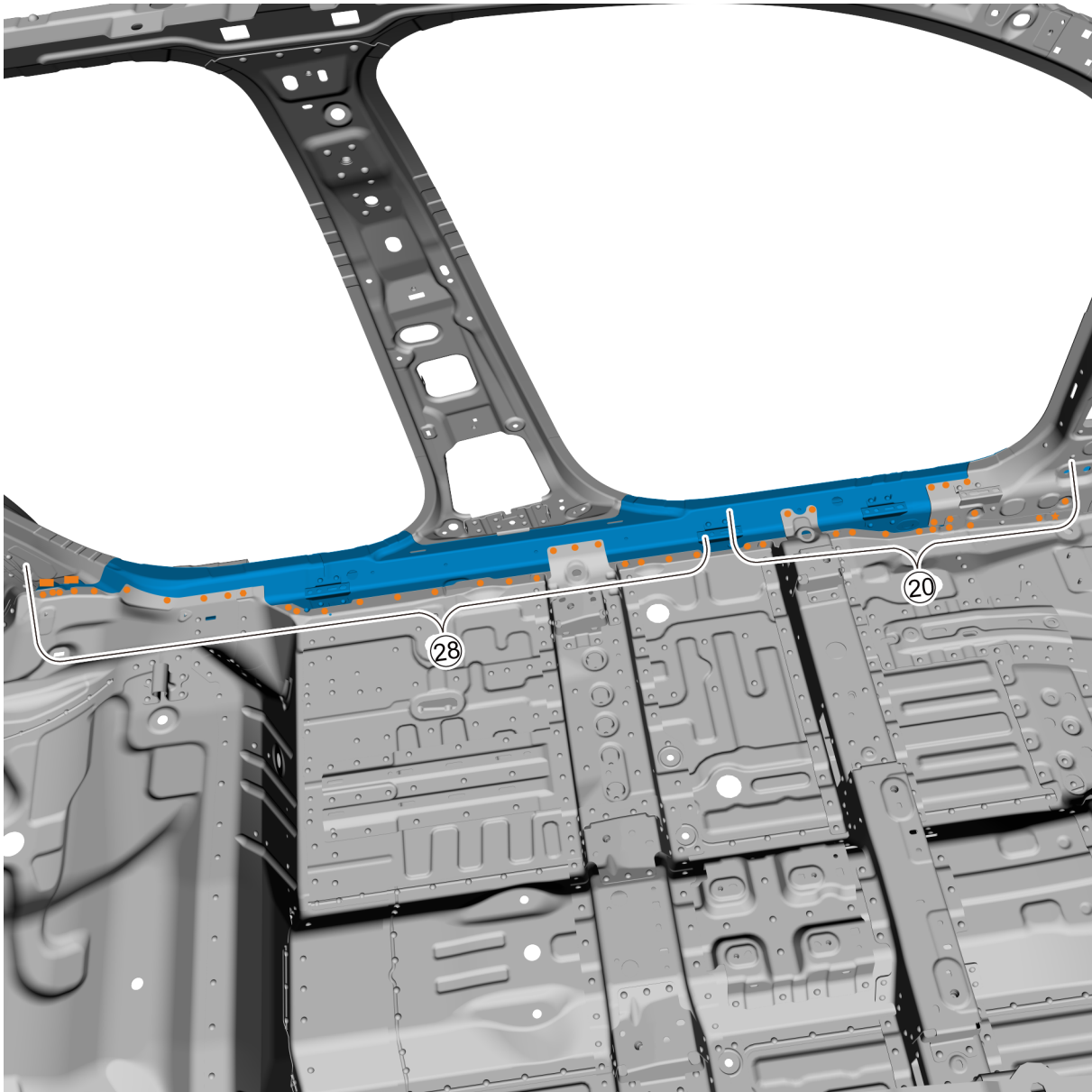
1. Remove the large sunroof top cover assembly, refer to [Removal of the Large Sunroof Top Cover Assembly](#).
2. Remove the left sidewall outer plate, refer to [Removal of the Left Sidewall Outer Plate](#).
3. Remove the left sidewall front connecting plate assembly, refer to [Removal of the Left Sidewall Front Connecting Plate Assembly](#).
4. Remove the left sidewall front reinforcement plate assembly, refer to [Removal of the Left Sidewall Front Reinforcement Plate Assembly](#).
5. At the welding positions shown in the figure below, drill out or grind away the welding points and remove the fixing points of the left door sill inner plate assembly to the left sidewall front inner plate assembly.



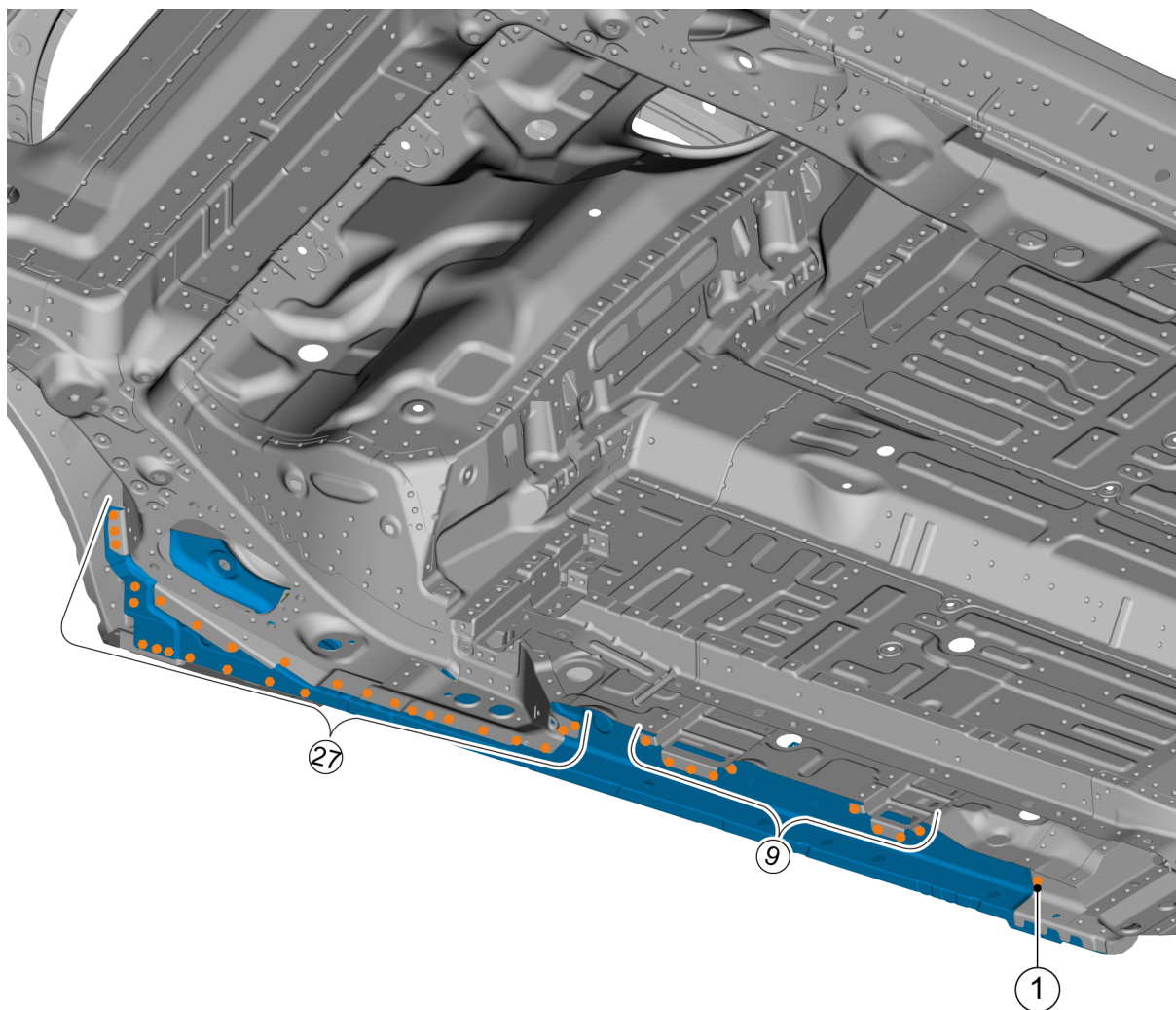




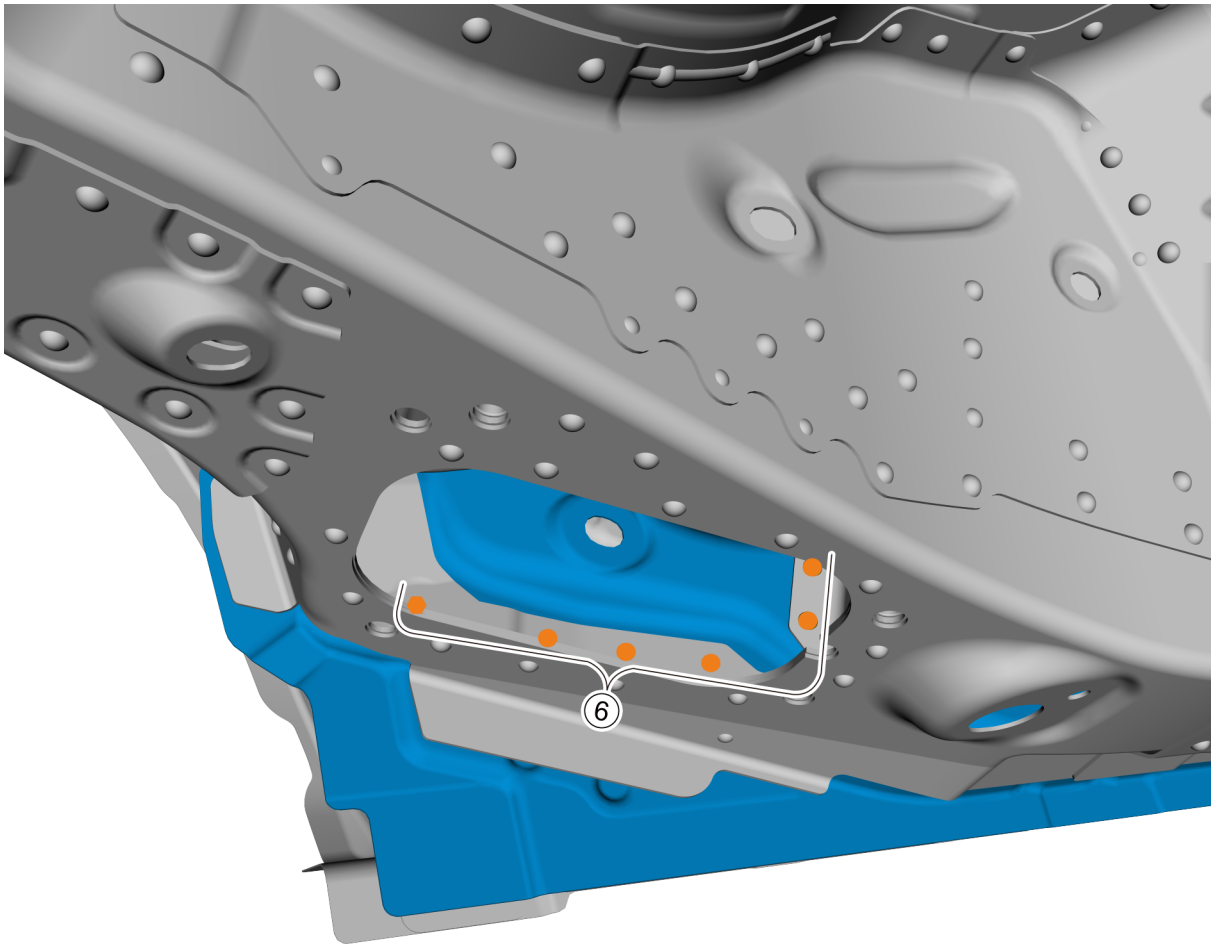
6. At the welding positions shown in the figure below, drill out or grind away the welding points and remove the fixing points of the left door sill inner plate assembly to the front floor assembly and the left A-pillar inner plate assembly and center floor body.



7. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the left door sill inner plate assembly to the rear floor left longitudinal beam assembly and the front floor left lower longitudinal beam assembly and the left front longitudinal beam assembly.



8. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the left door sill inner plate assembly to the rear floor left longitudinal beam assembly.

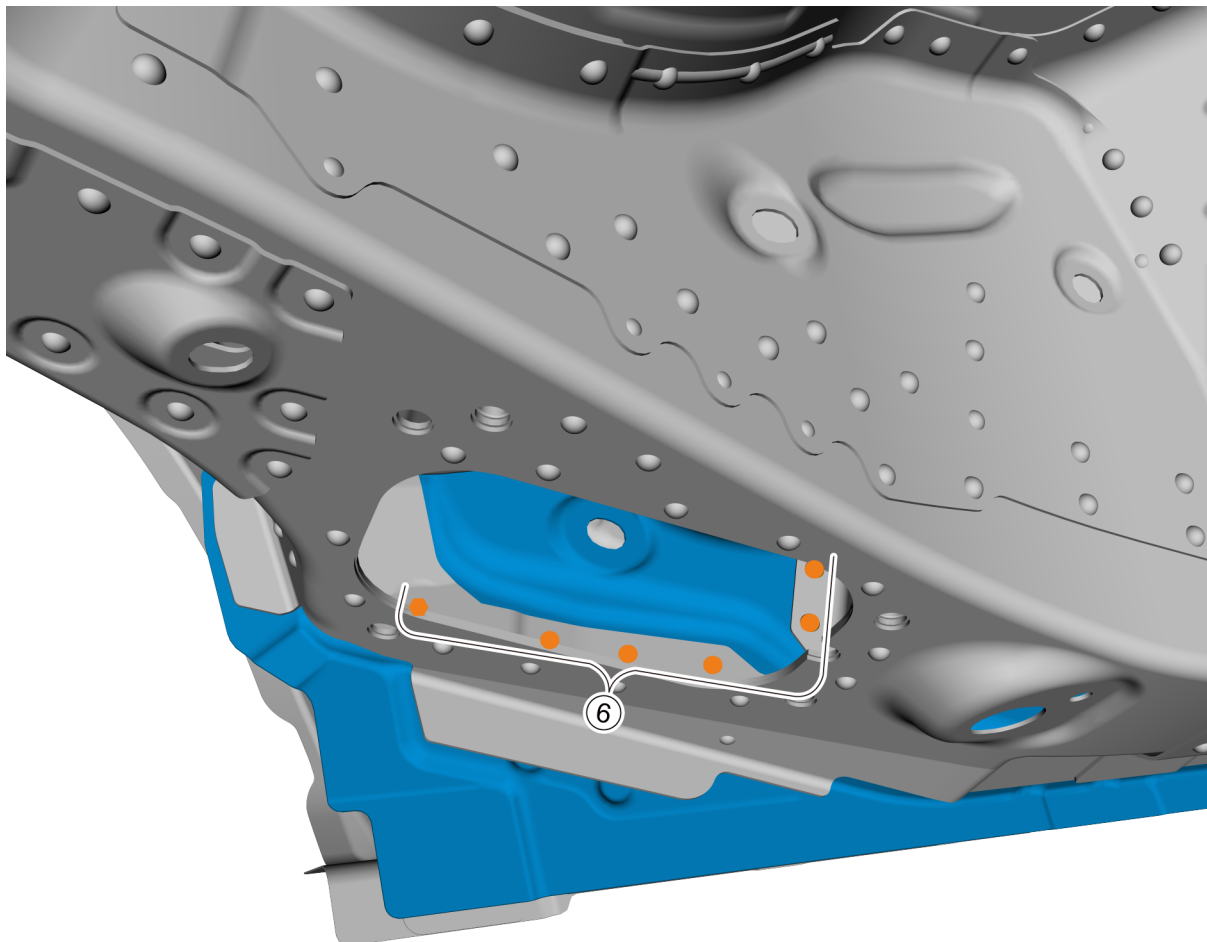


9. Grind away any welding marks that may remain on the body surface and sand the welded surfaces to bare metal (remove surface foreign matter, paint and rust).

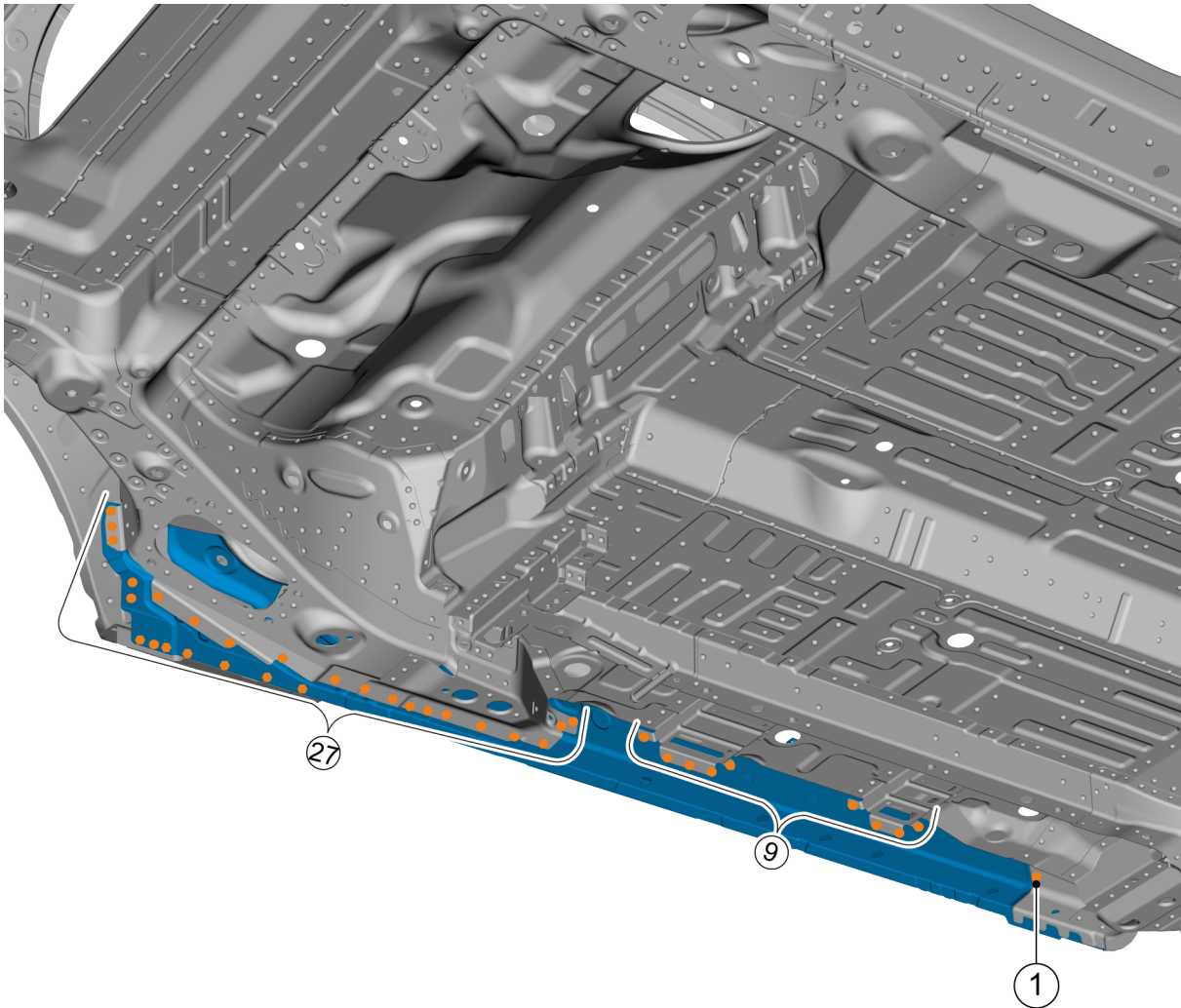
## 4.2.30 Installation of the Left Door Sill Inner Plate Assembly

### 4.2.30.1 Installation of the Left Door Sill Inner Plate Assembly

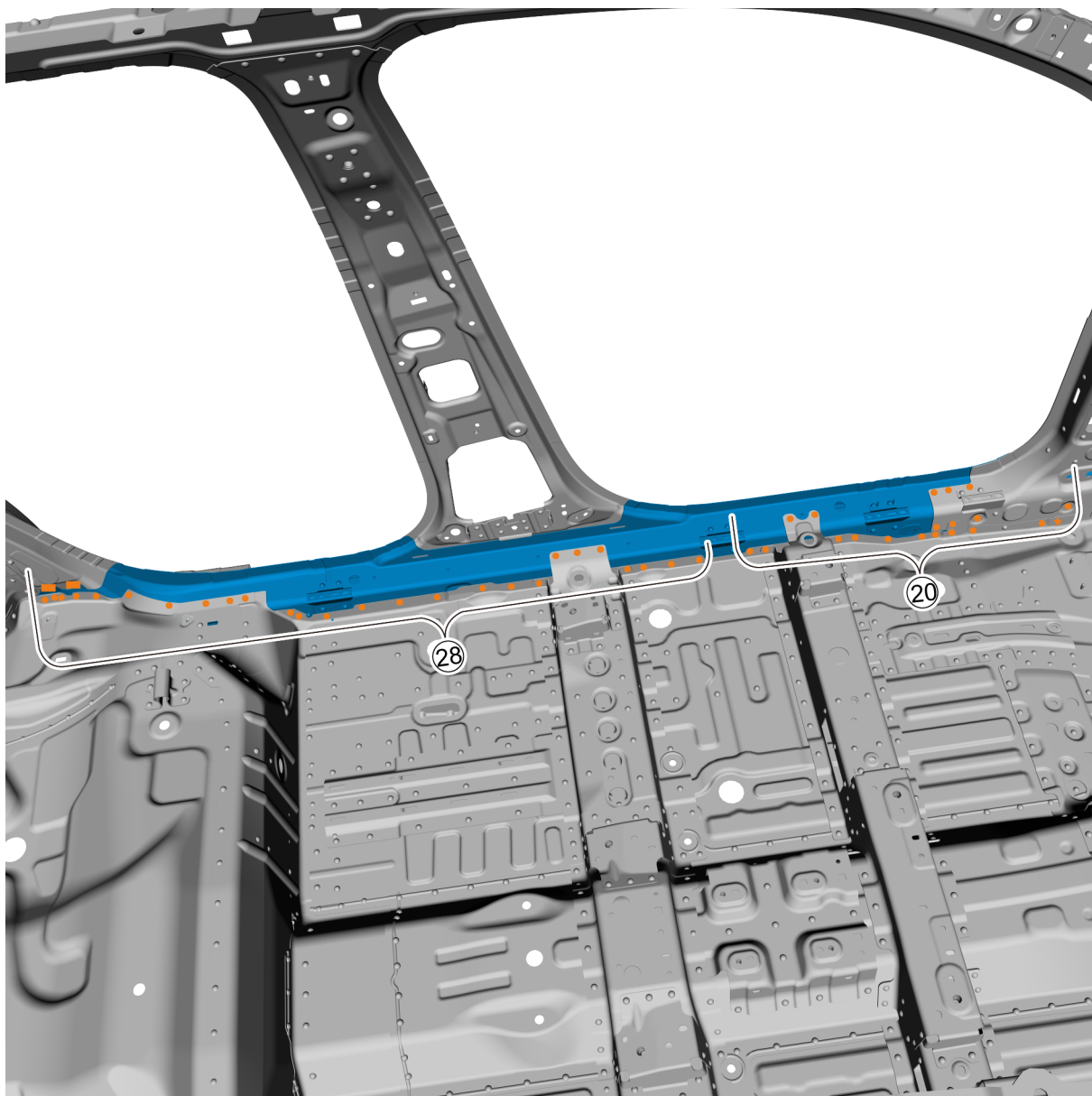
1. When installing a new part, match the mounting position of the new part on the body.
2. Temporarily install the new part for initial positioning.
3. Check and measure the positional dimensions of the left door sill inner plate assembly and the body for compliance with the standard, and adjust if necessary.
4. Weld the fixing points of the left door sill inner plate assembly to the rear floor left longitudinal beam assembly.



5. Weld the fixing points of the left door sill inner plate assembly to the rear floor left longitudinal beam assembly and the front floor left lower longitudinal beam assembly and the left front longitudinal beam assembly.

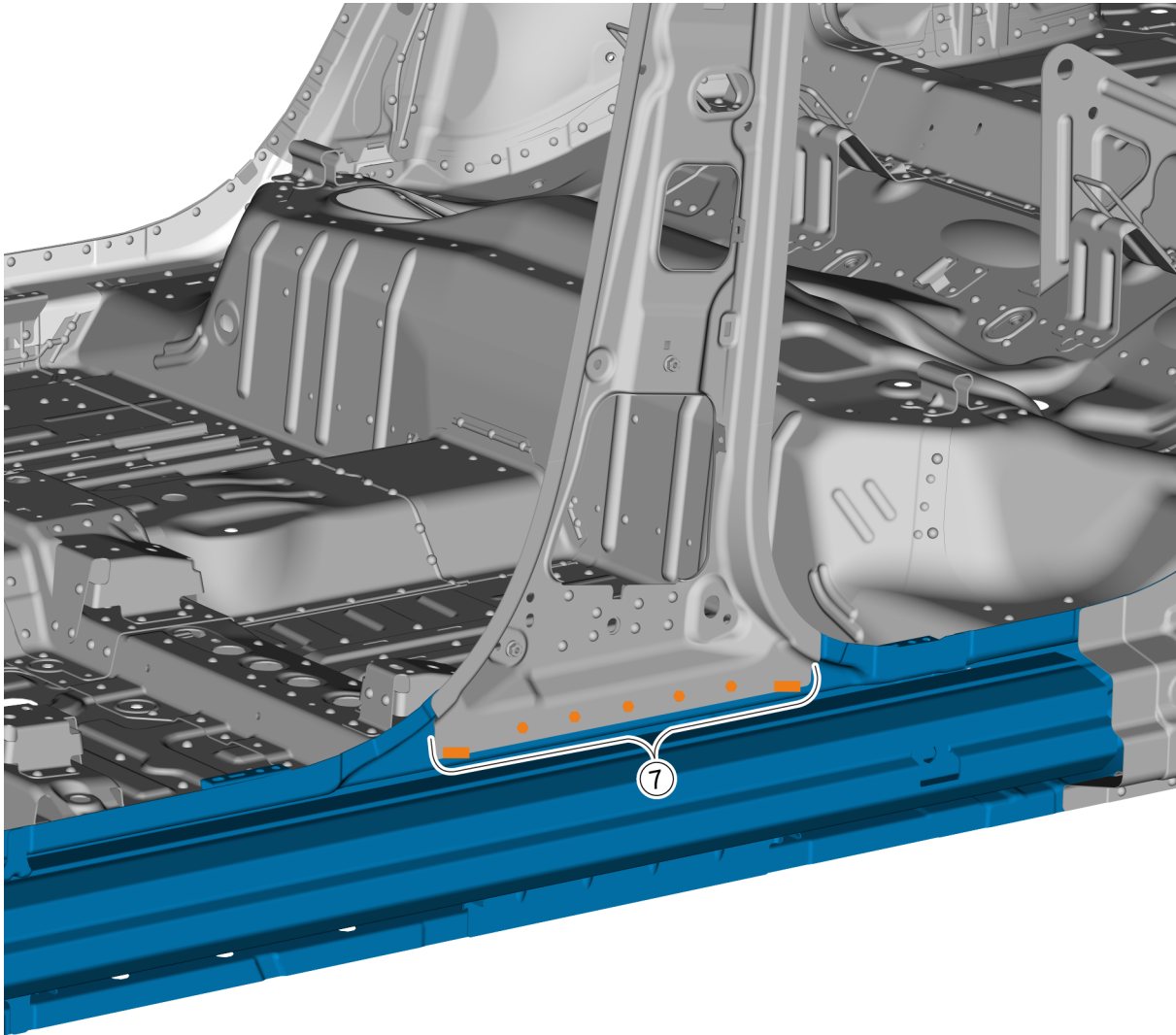


6. Weld the fixing points of the door sill inner plate assembly to the front floor assembly and the left A-pillar inner plate assembly and the center floor body.





7. Weld the fixing points of the left door sill inner plate assembly to the left sidewall front inner plate assembly.



8. Install the left sidewall front reinforcement plate assembly.

9. Install the left sidewall front connecting plate assembly.

10. Install the left sidewall outer plate.

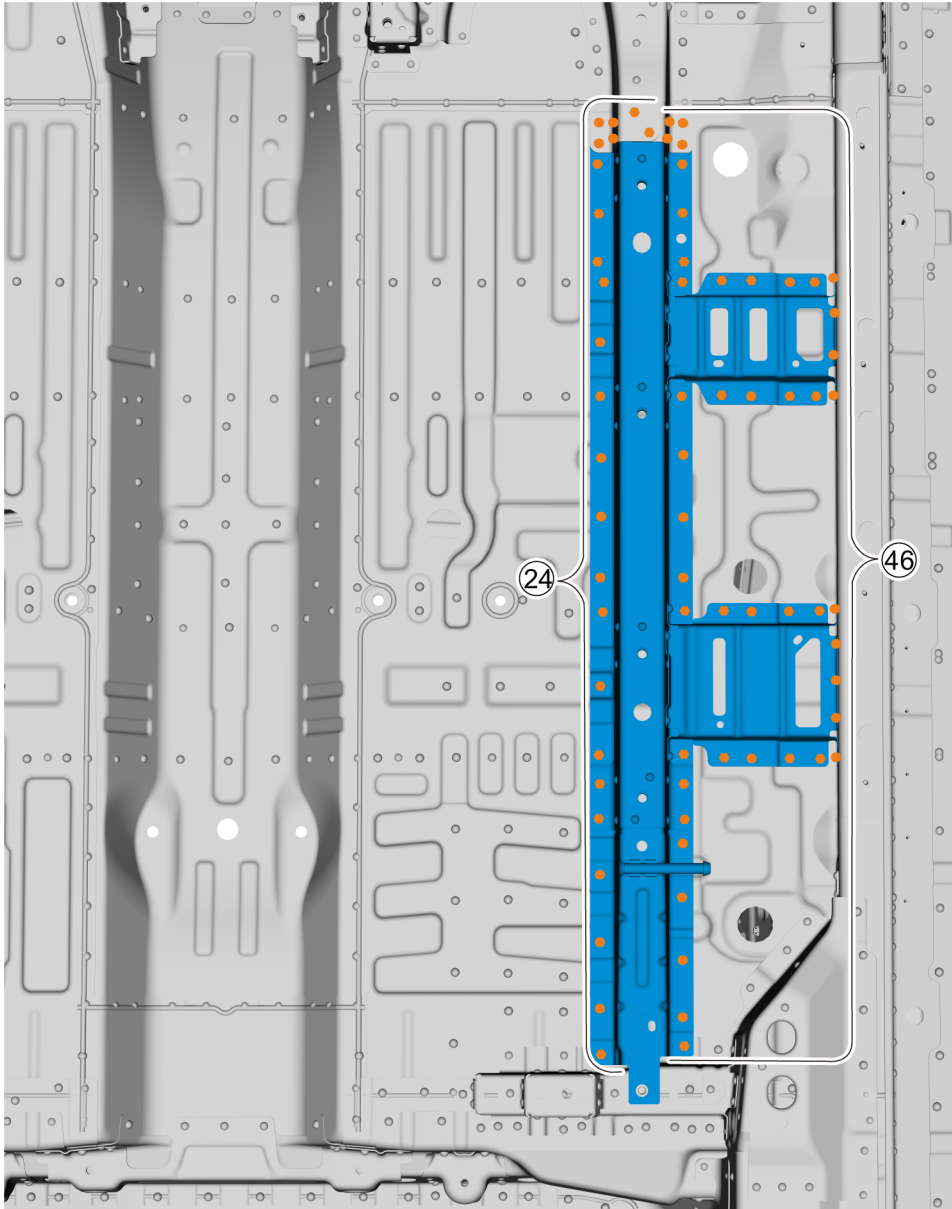
11. Install the large sunroof top cover assembly.

## 4.2.31 Removal of the Front Floor Left Lower Longitudinal Beam Assembly

### 4.2.31.1 Removal of the Front Floor Left Lower Longitudinal Beam Assembly

#### Removal of Parts

1. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the front floor left lower longitudinal beam assembly to the left door sill inner plate assembly and the left front longitudinal beam assembly and front floor assembly.



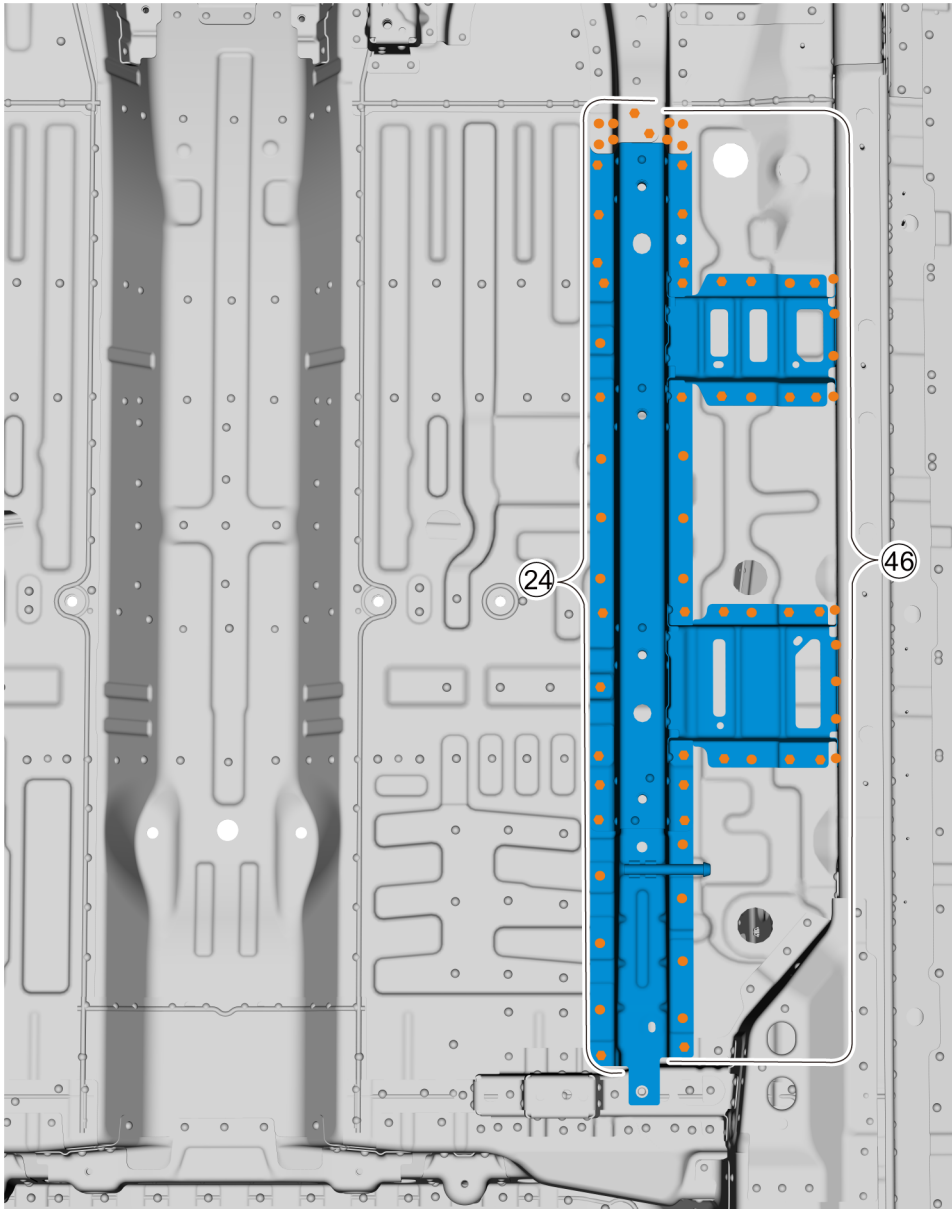
2. Grind away any welding marks that may remain on the body surface and sand the welded surfaces to bare metal (remove surface foreign matter, paint and rust).



## 4.2.32 Installation of the Front Floor Left Lower Longitudinal Beam Assembly

### 4.2.32.1 Installation of the Front Floor Left Lower Longitudinal Beam Assembly

1. When installing a new part, match the mounting position of the new part on the body.
2. Temporarily install the new part for initial positioning.
3. Check and measure the positional dimensions of the front floor left lower longitudinal beam assembly and the body for compliance with the standard, and adjust if necessary.
4. Weld the fixing points of the front floor left lower longitudinal beam assembly to the left door sill inner plate assembly and the left front longitudinal beam assembly and front floor assembly.

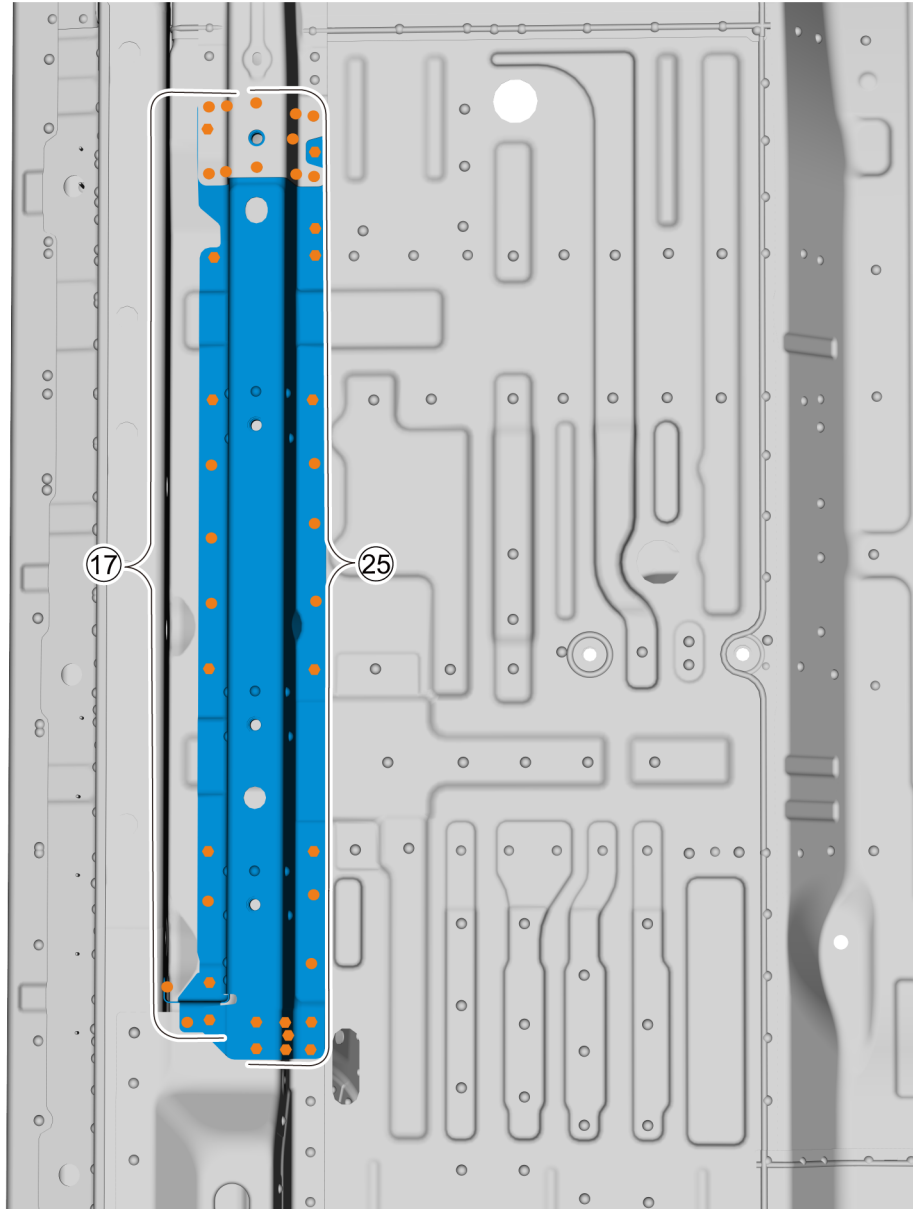


## 4.2.33 Removal of the Front Floor Right Lower Longitudinal Beam Assembly

### 4.2.33.1 Removal of the Front Floor Right Lower Longitudinal Beam Assembly

#### Removal of Parts

1. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the front floor right lower longitudinal beam assembly to the rear floor right longitudinal beam assembly and the right front longitudinal beam assembly and the front floor assembly.

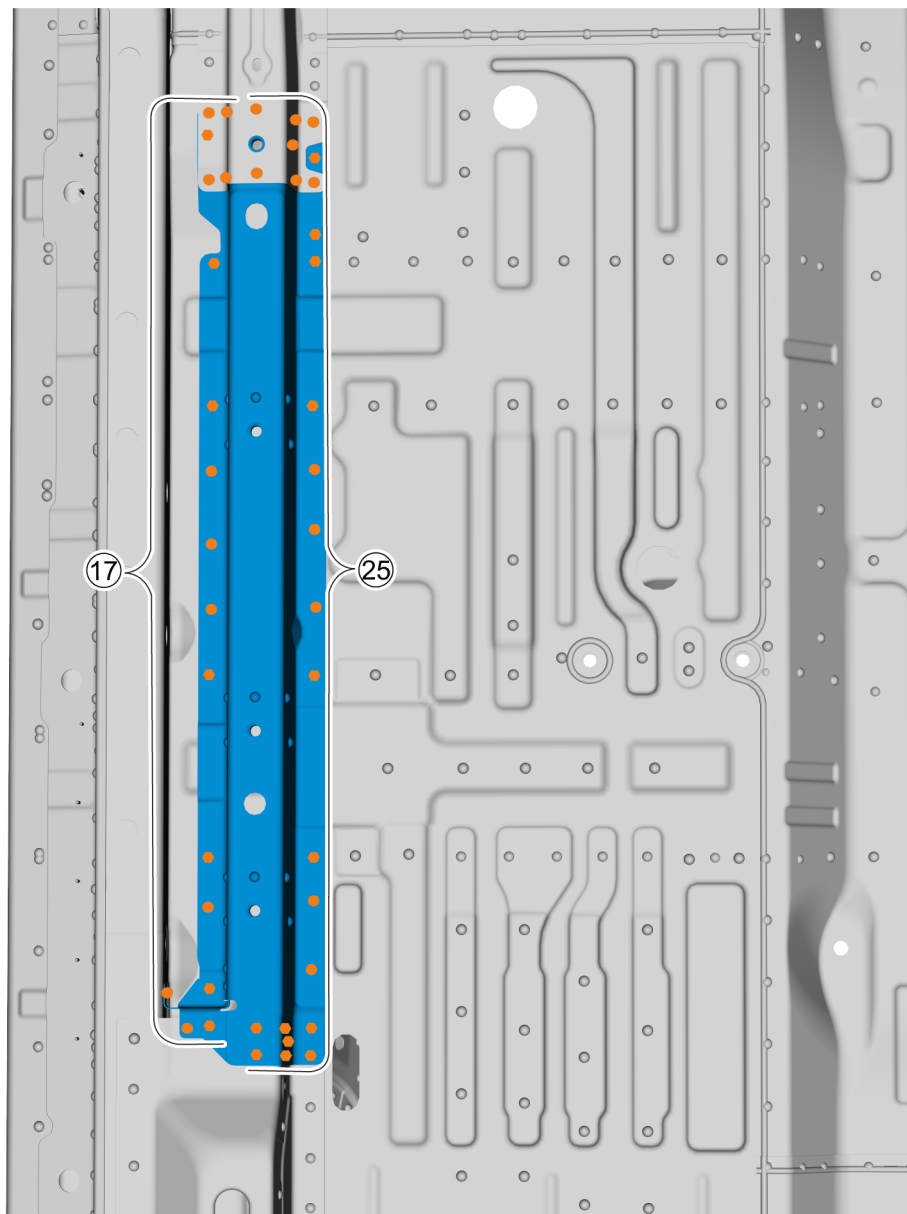


2. Grind away any welding marks that may remain on the body surface and sand the welded surfaces to bare metal (remove surface foreign matter, paint and rust).

## 4.2.34 Installation of the Front Floor Right Lower Longitudinal Beam Assembly

### 4.2.34.1 Installation of the Front Floor Right Lower Longitudinal Beam Assembly

1. When installing a new part, match the mounting position of the new part on the body.
2. Temporarily install the new part for initial positioning.
3. Check and measure the positional dimensions of the front floor right lower longitudinal beam assembly and the body for compliance with the standard, and adjust if necessary.
4. Weld the fixing points of the front floor right lower longitudinal beam assembly to the rear floor right longitudinal beam assembly and the right front longitudinal beam assembly and front floor assembly.

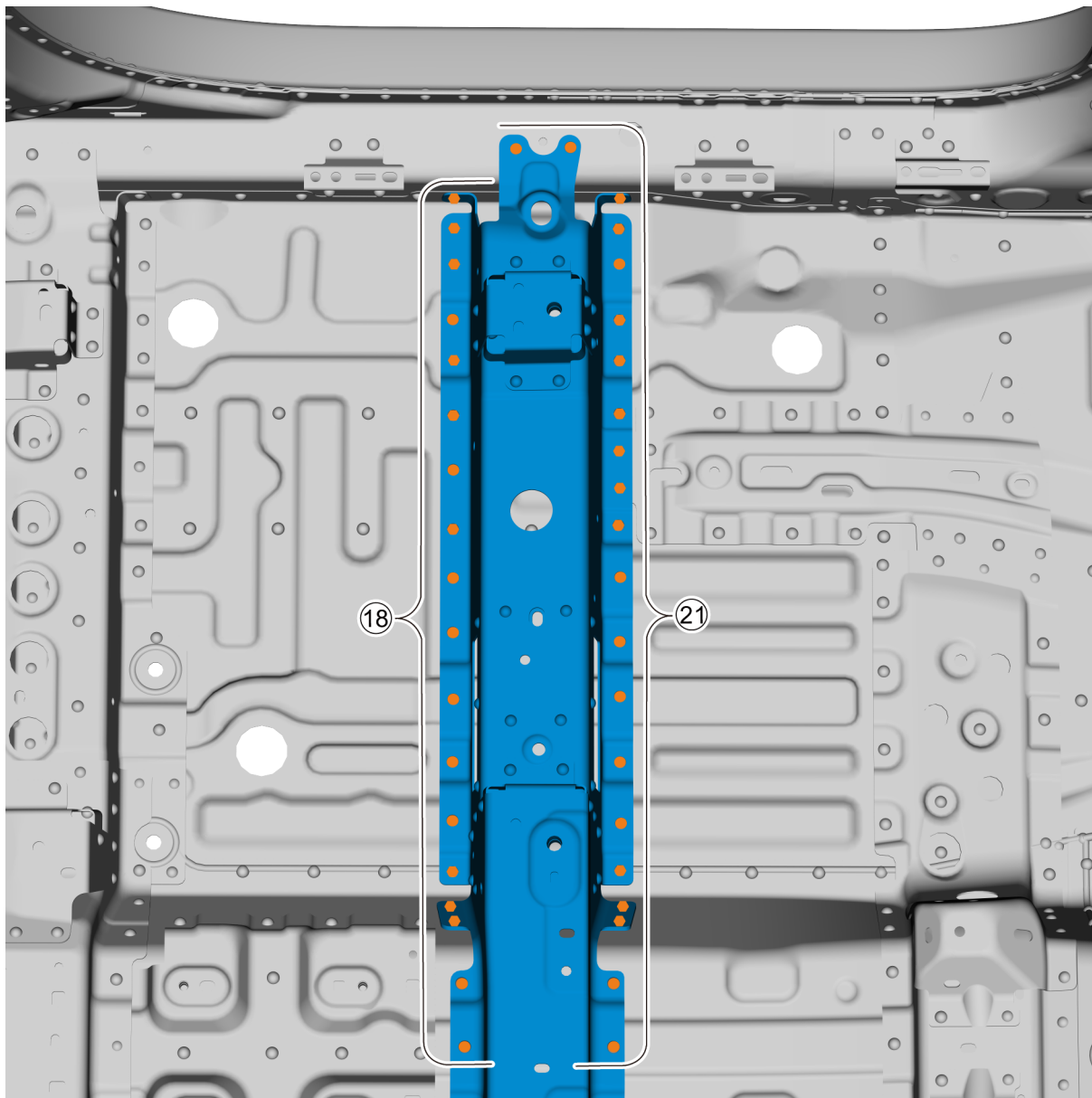


## 4.2.35 Removal of the Front Seat Front Beam Assembly

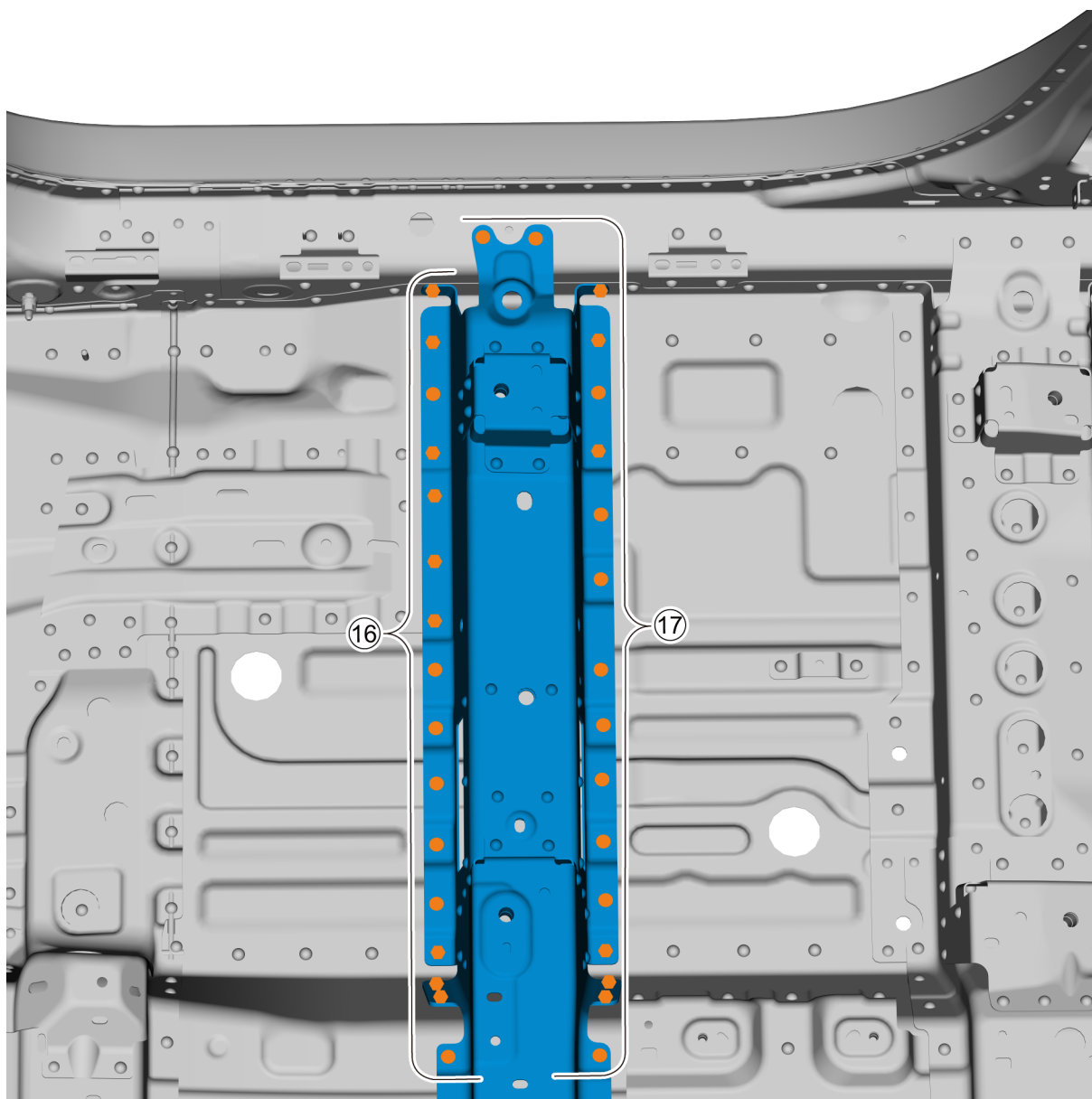
### 4.2.35.1 Removal of the Front Seat Front Beam Assembly

#### Removal of Parts

1. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the front seat front beam assembly to the front floor assembly and the left door sill inner plate assembly.



2. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the front seat front beam assembly with the front floor assembly and the right door sill inner plate assembly.

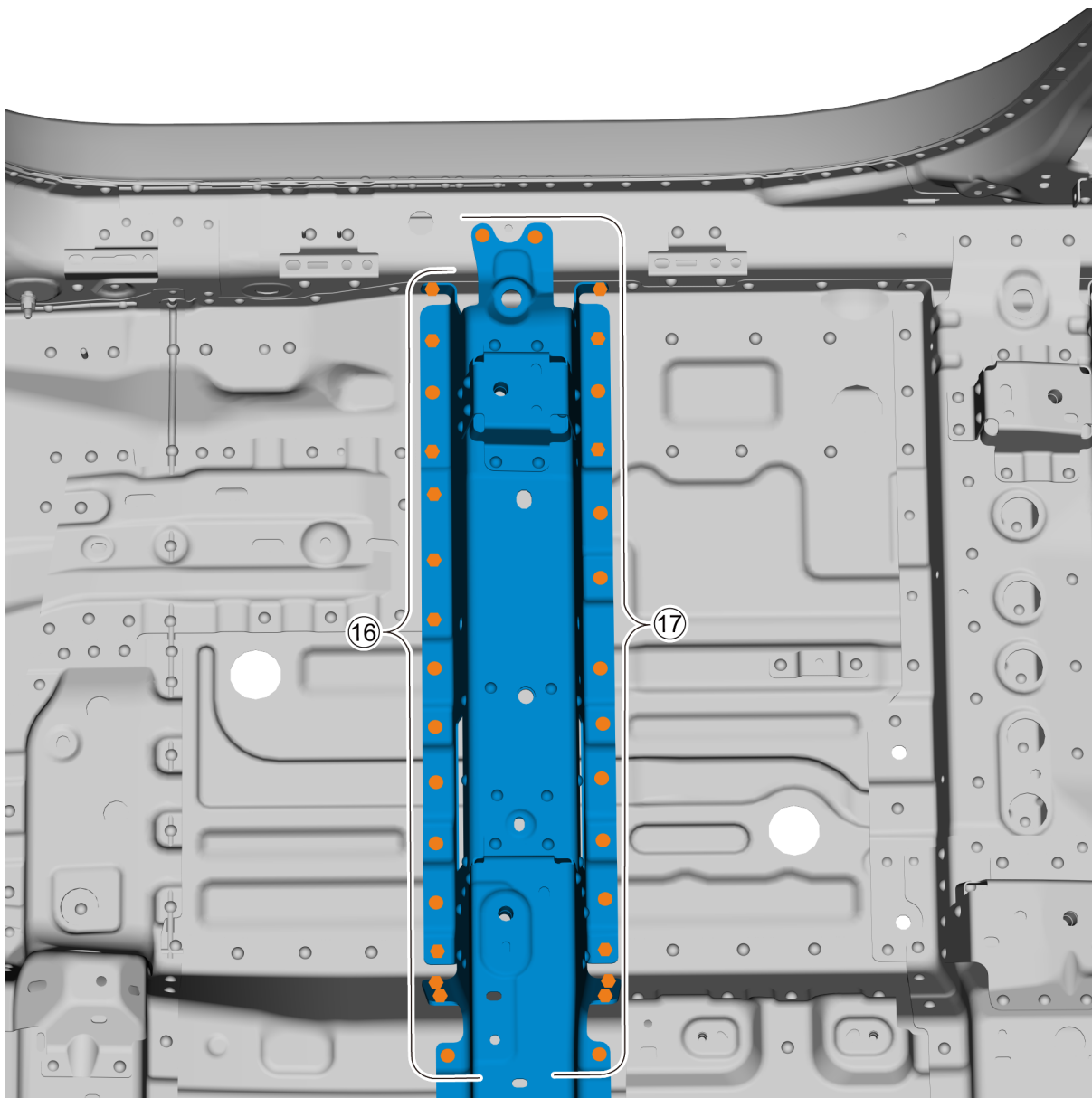


3. Grind away any welding marks that may remain on the body surface, and sand the welded surfaces to bare metal (remove surface foreign matter, paint and rust).

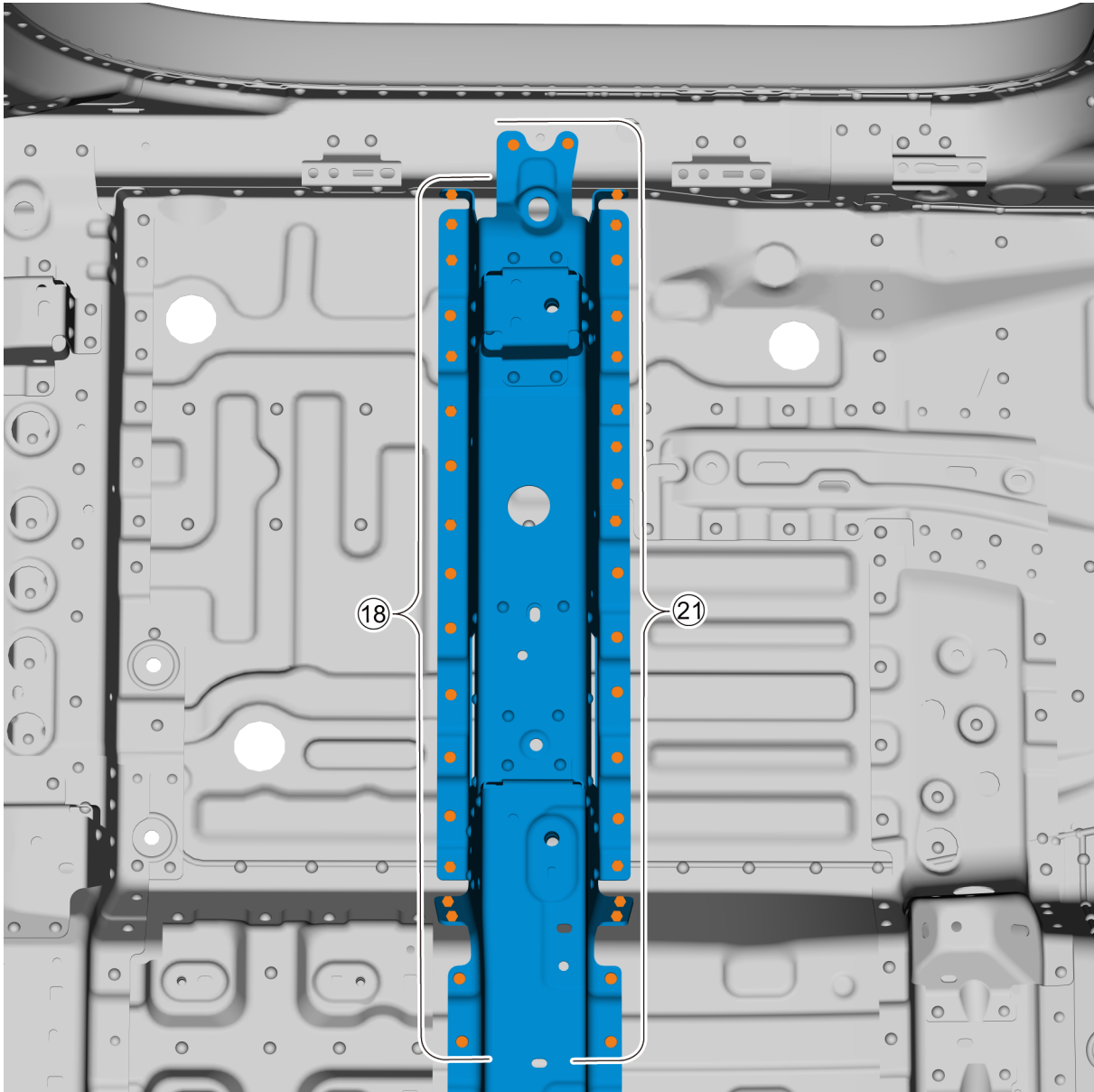
## 4.2.36 Installation of the Front Seat Front Beam Assembly

### 4.2.36.1 Installation of the Front Seat Front Beam Assembly

1. When installing a new part, match the mounting position of the new part on the body.
2. Temporarily install the new part for initial positioning.
3. Check and measure the positional dimensions of the front seat front beam assembly and the body for compliance with the standard, and adjust if necessary.
4. Weld the fixing points of the front seat front beam assembly to the front floor assembly.



5. Weld the fixing points of the front seat front beam assembly to the front floor assembly.

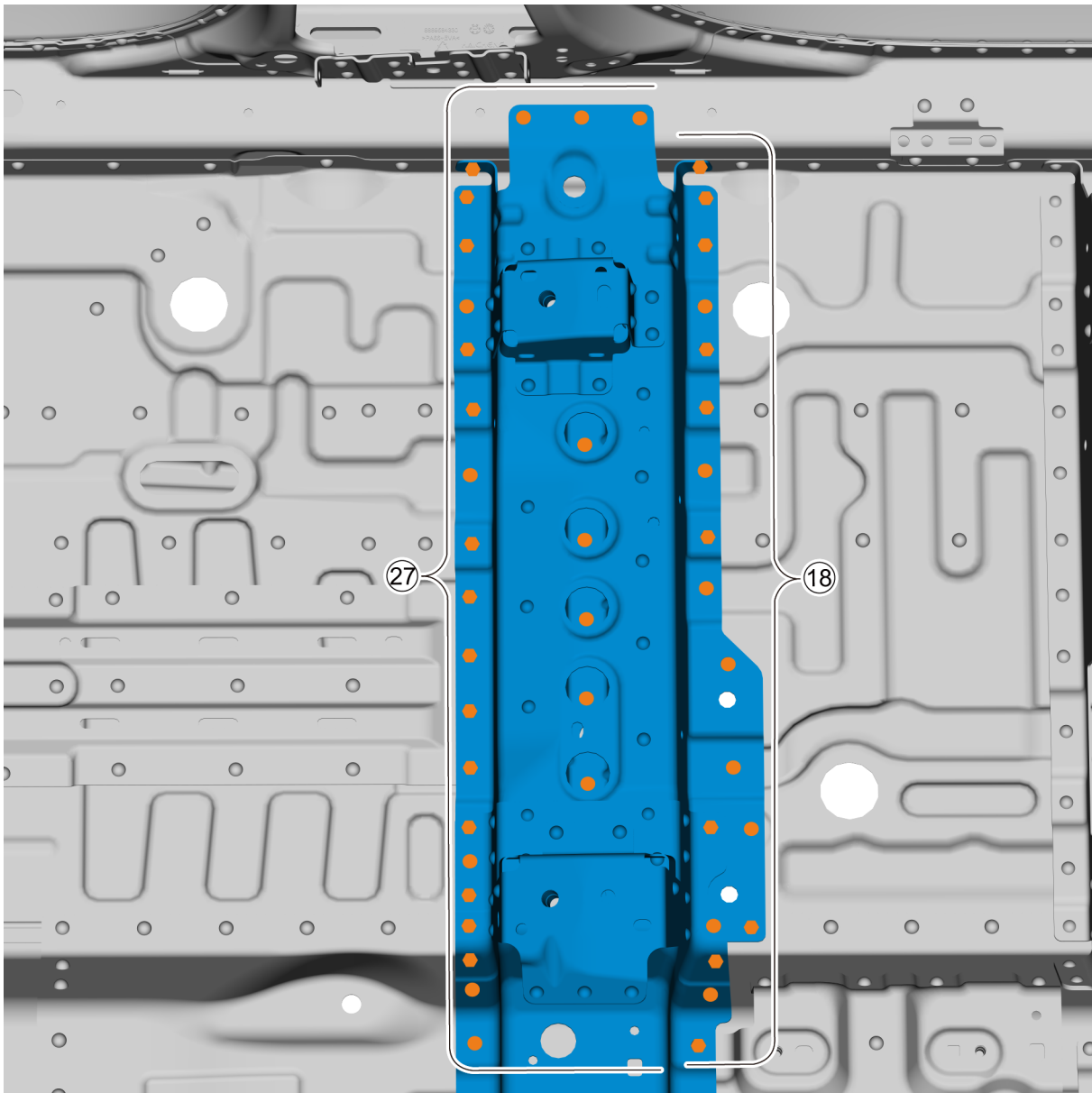


## 4.2.37 Removal of the Front Seat Rear Beam Assembly

### 4.2.37.1 Removal of the Front Seat Rear Beam Assembly

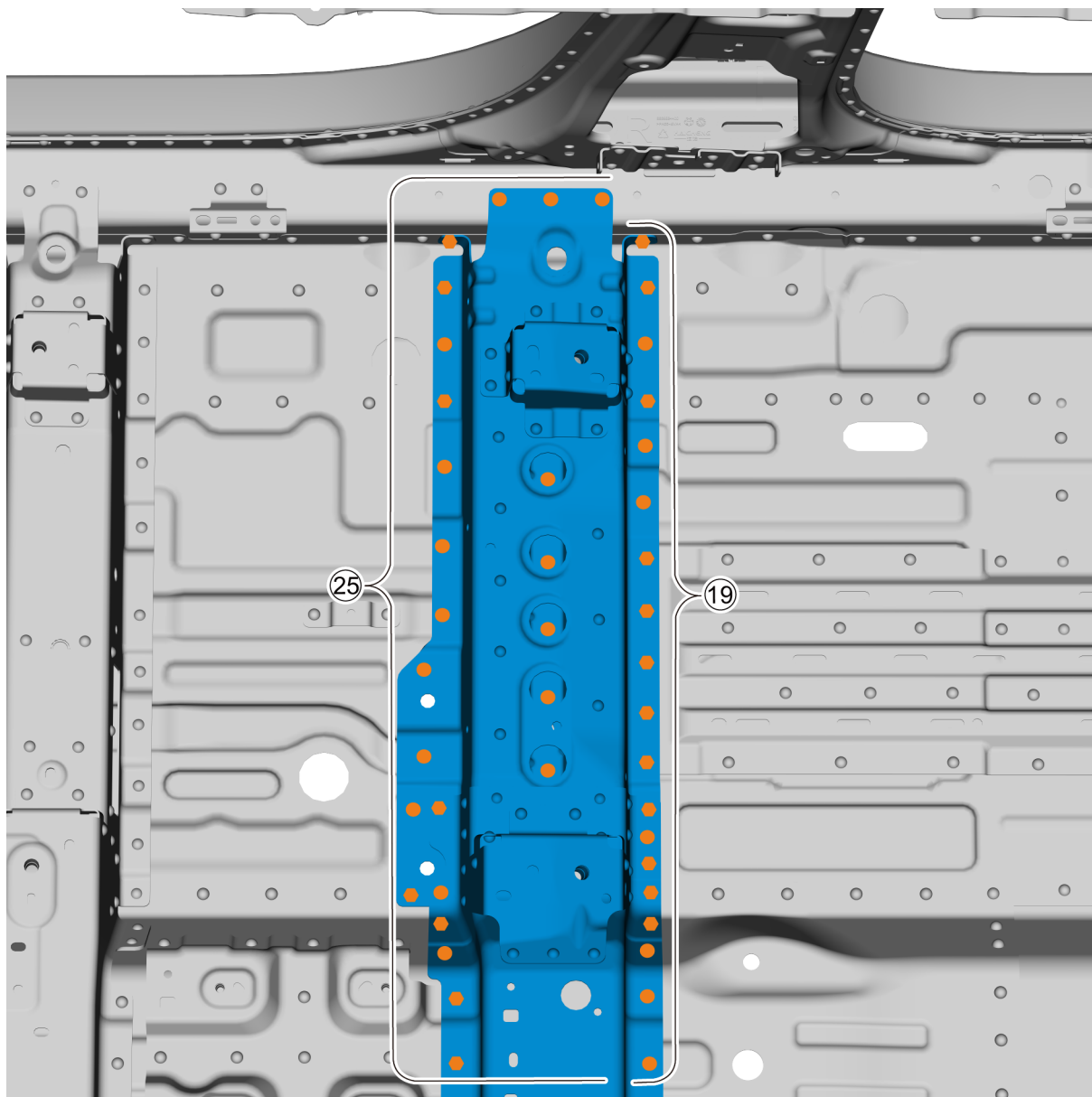
#### Removal of Parts

1. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the front seat rear beam assembly to the front floor assembly and the left door sill inner plate assembly.





2. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the front seat rear beam assembly to the front floor assembly and the right door sill inner plate assembly.

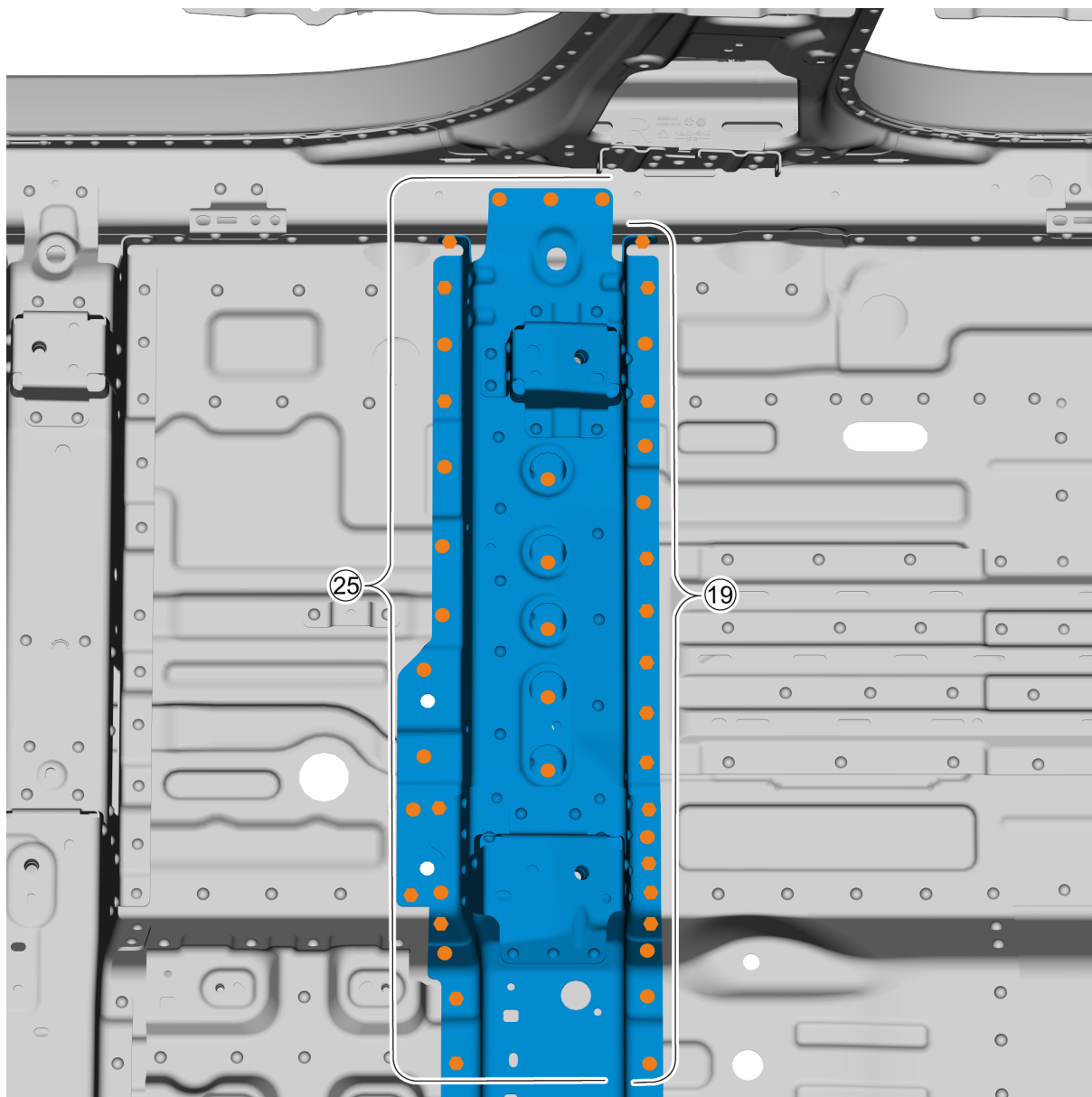


3. Grind away any welding marks that may remain on the body surface and sand the welded surfaces to bare metal (remove surface foreign matter, paint and rust).

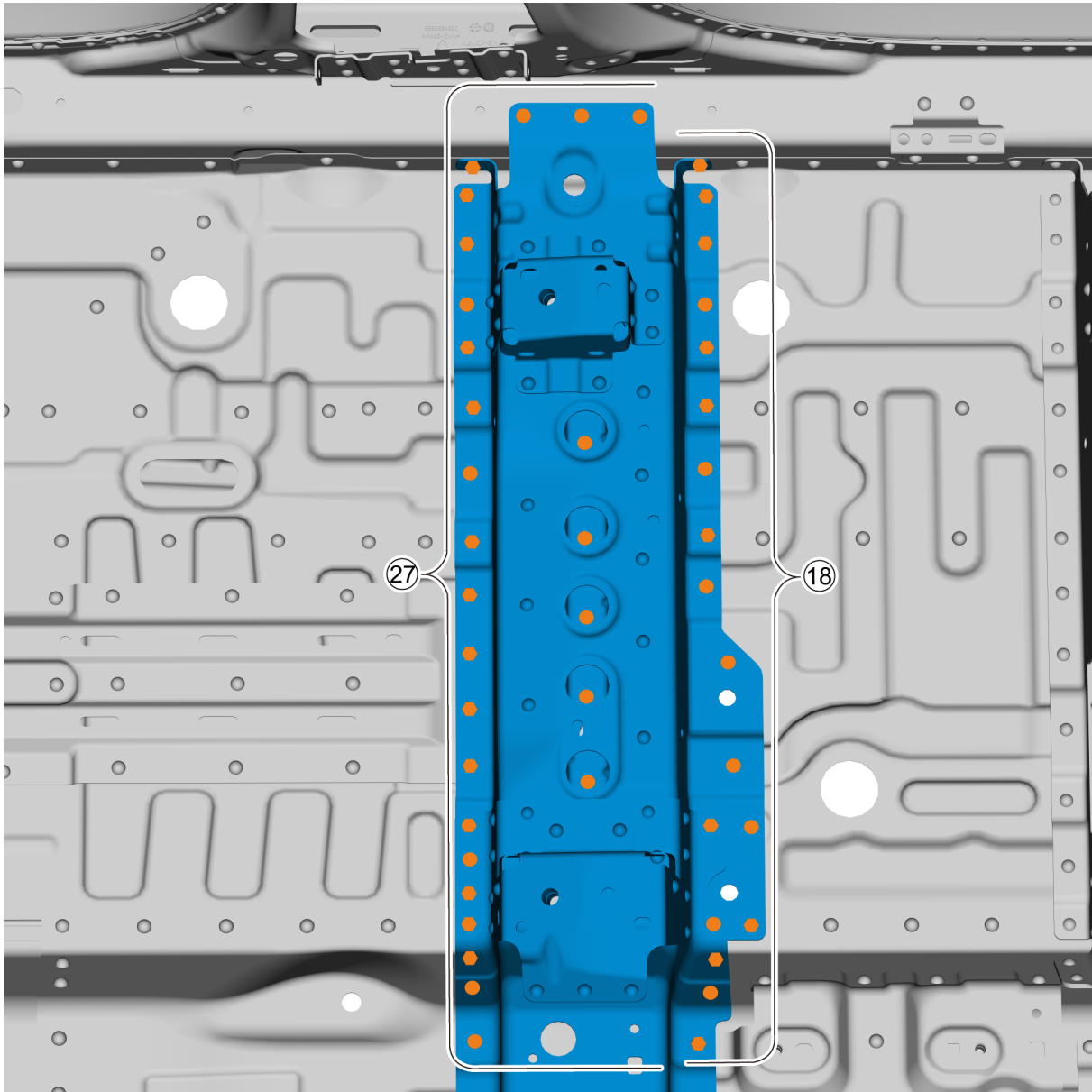
## 4.2.38 Installation of the Front Seat Rear Beam Assembly

### 4.2.38.1 Installation of the Front Seat Rear Beam Assembly

1. When installing a new part, match the mounting position of the new part on the body.
2. Temporarily install the new part for initial positioning.
3. Check and measure the positional dimensions of the front seat rear beam assembly and the body for compliance with the standard, and adjust if necessary.
4. Weld the fixing points of the front seat rear beam assembly to the front floor assembly.



5. Weld the fixing points of the front seat rear beam assembly to the front floor assembly.

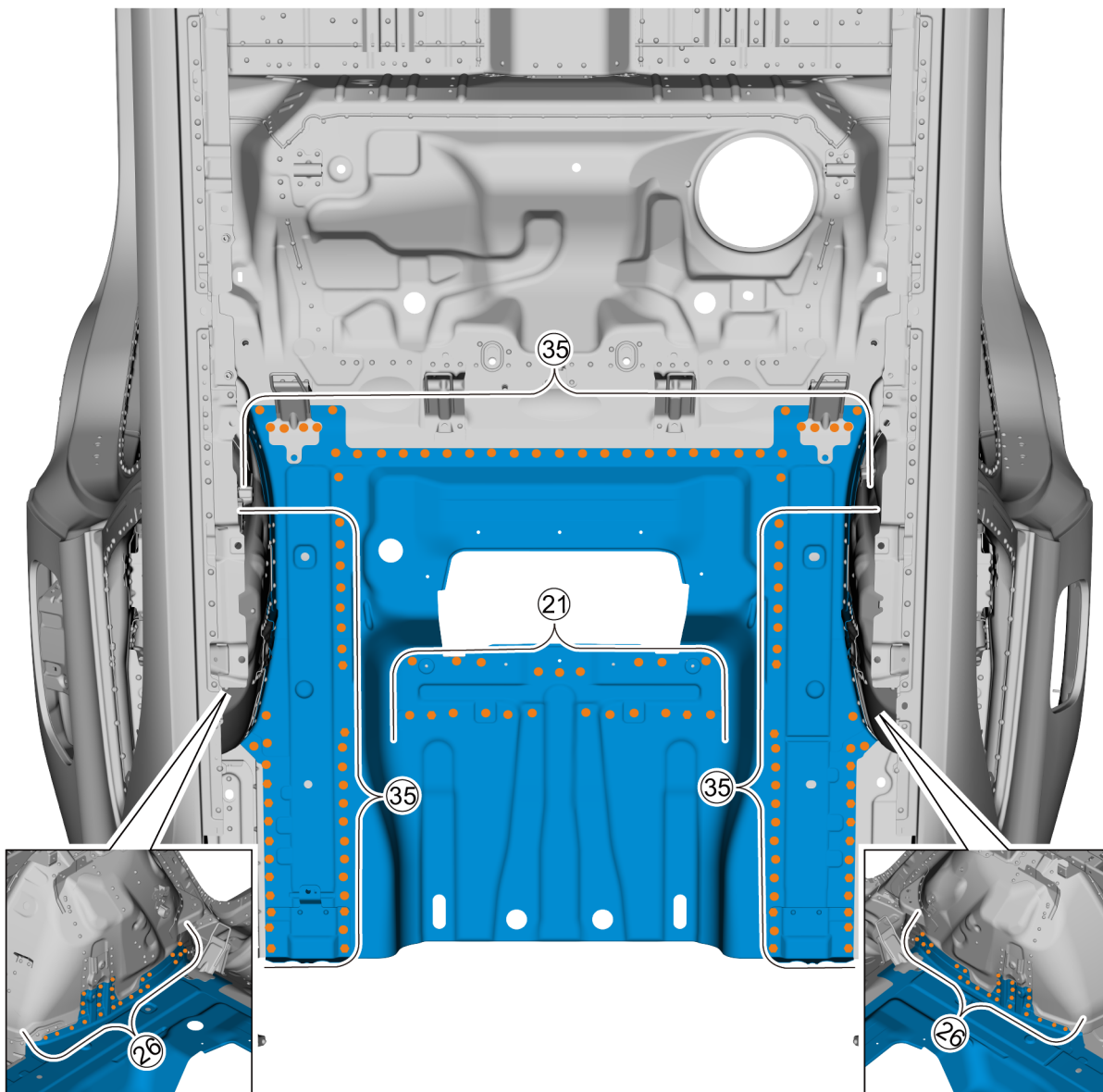


## 4.2.39 Removal of the Rear Floor Body Assembly

### 4.2.39.1 Removal of the Rear Floor Body Assembly

#### Removal of Parts

1. Remove the rear panel assembly, refer to [Removal of the Rear Panel Assembly Removal](#).
2. Remove the rear floor upper beam assembly, refer to [Removal of the Rear Floor Upper Beam Assembly](#).
3. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the rear floor body assembly to the left and right longitudinal beam assemblies of the rear floor and the reinforcement beam assemblies under the spare tire pool and the left and right C-pillar assemblies.

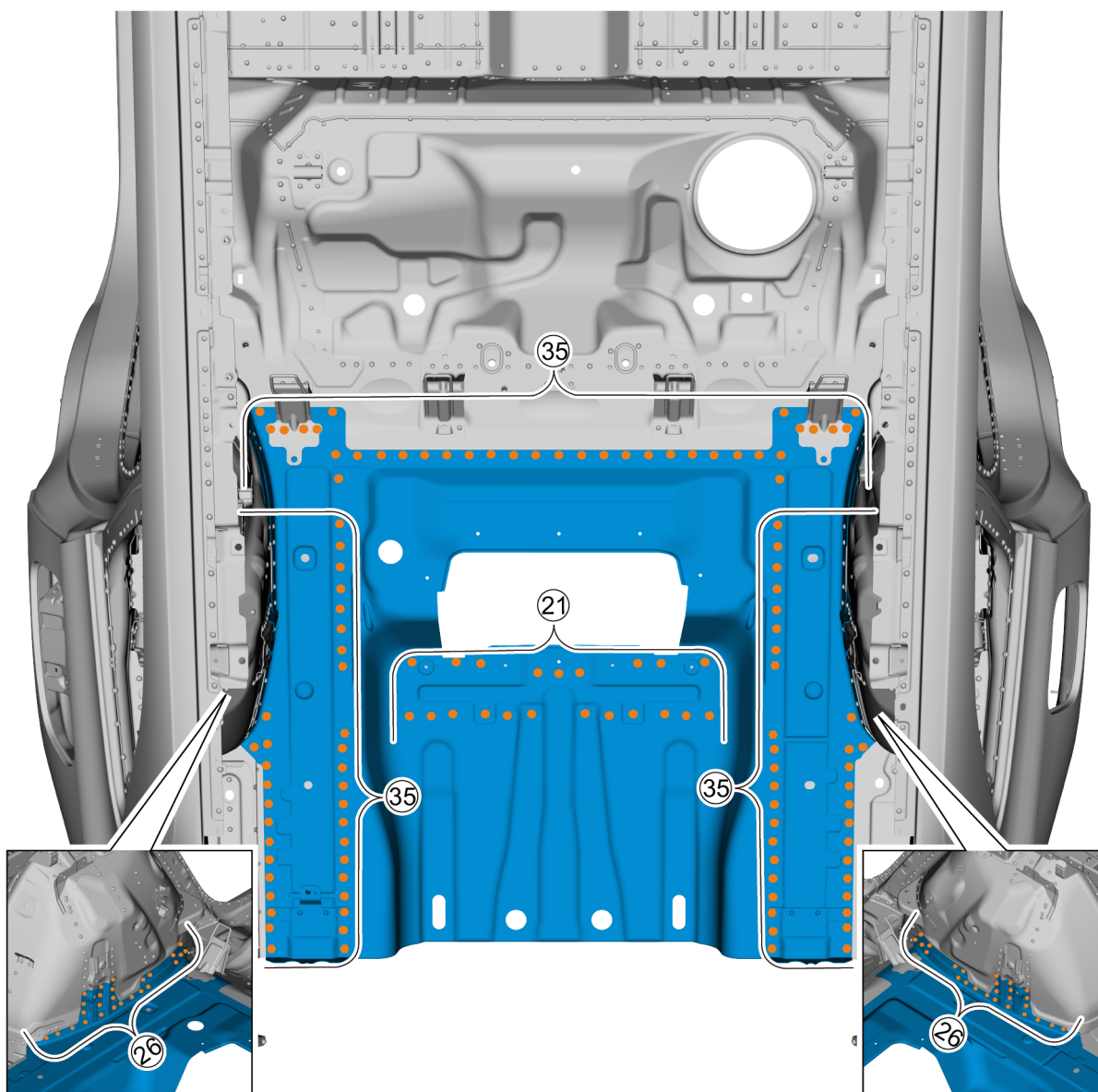


4. Grind away any welding marks that may remain on the body surface and sand the welded surfaces to bare metal (remove surface foreign matter, paint and rust).

## 4.2.40 Installation of the Rear Floor Body Assembly

### 4.2.40.1 Installation of the Rear Floor Body Assembly

1. When installing a new part, match the mounting position of the new part on the body.
2. Temporarily install the new part for initial positioning.
3. Check and measure the positional dimensions of the rear floor body assembly and the body for compliance with the standard, and adjust if necessary.
4. Weld the fixing points of the rear floor body assembly to the rear floor left and right longitudinal beam assemblies and the reinforcement beam assembly under the spare tire pool and the left and right C-pillar assemblies.



5. Install the rear floor upper beam assembly.
6. Install the rear panel assembly.

## 4.2.41 Removal of the Rear Floor Left Rear Connecting Plate Assembly

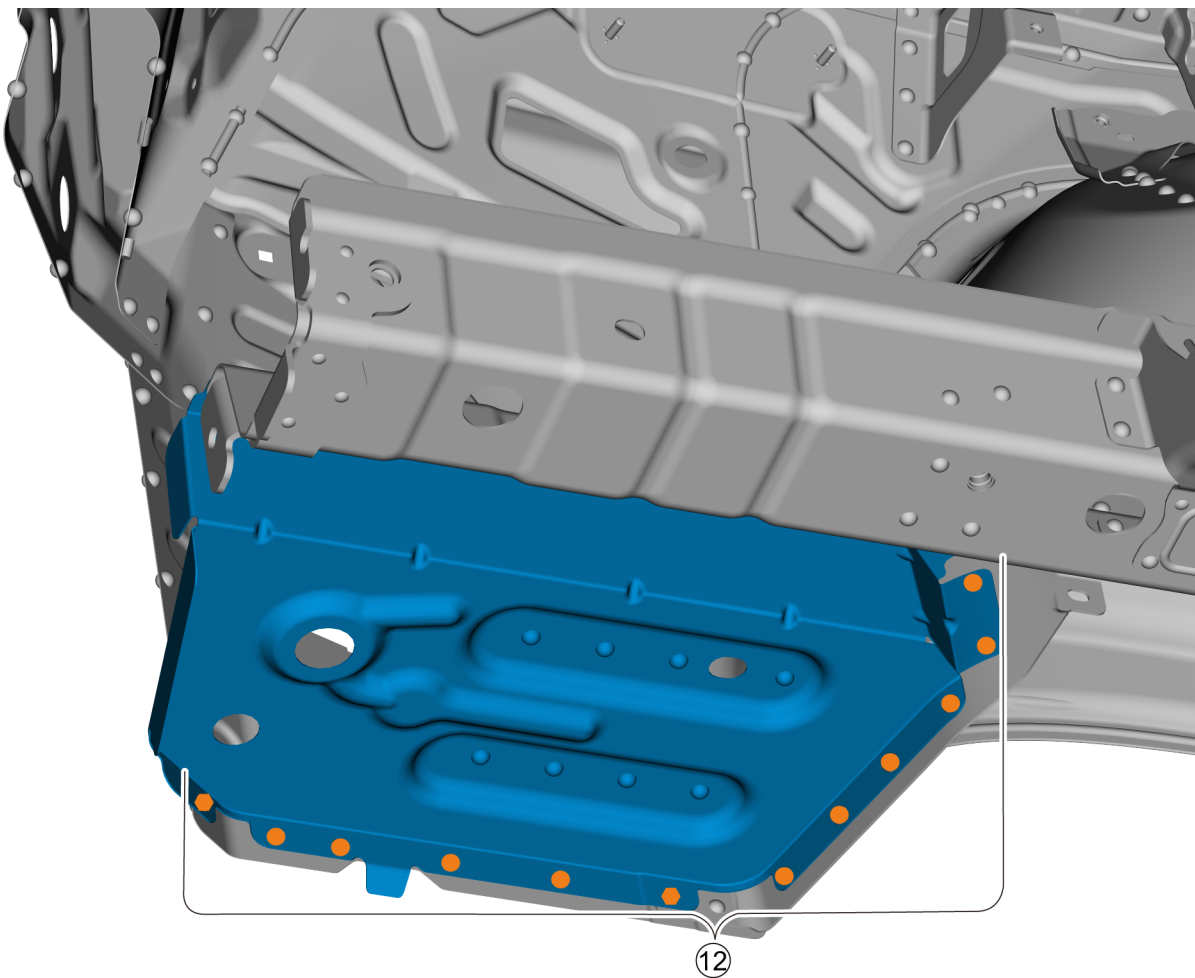
### 4.2.41.1 Removal of the Rear Floor Left Rear Connecting Plate Assembly

Removal of Parts

#### Caution

Remove the left and right sides in the same way.

1. Remove the rear panel assembly, refer to [Removal of the Rear Panel Assembly Removal](#).
2. Remove the rear floor upper beam assembly, refer to [Removal of the Rear Floor Upper Beam Assembly](#).
3. Remove the rear floor body assembly, refer to [Removal of the Rear Floor Body Assembly](#).
4. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the rear floor left rear connecting plate assembly to the left sidewall plate and left C-pillar assembly.



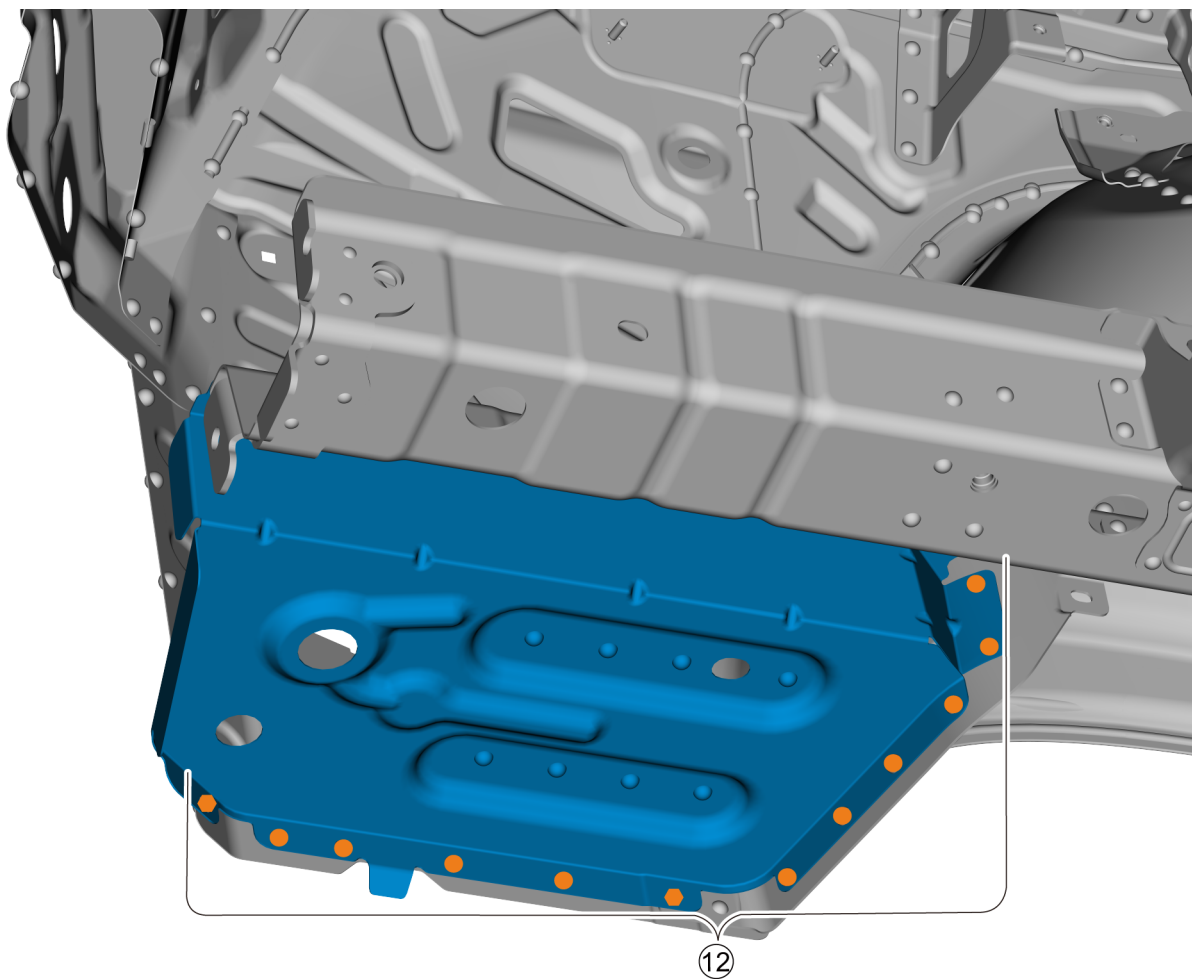
5. Grind away any welding marks that may remain on the body surface and sand the welded surfaces to bare metal (remove surface foreign matter, paint and rust).



## 4.2.42 Installation of the Rear Floor Left Rear Connecting Plate Assembly

### 4.2.42.1 Installation of the Rear Floor Left Rear Connecting Plate Assembly

1. When installing a new part, match the mounting position of the new part on the body.
2. Temporarily install the new part for initial positioning.
3. Check and measure the positional dimensions of the rear floor left rear connecting plate assembly and the body for compliance with the standard, and adjust if necessary.
4. Weld the fixing points of the rear floor left rear connecting plate assembly to the left sidewall plate and left C-pillar assembly.



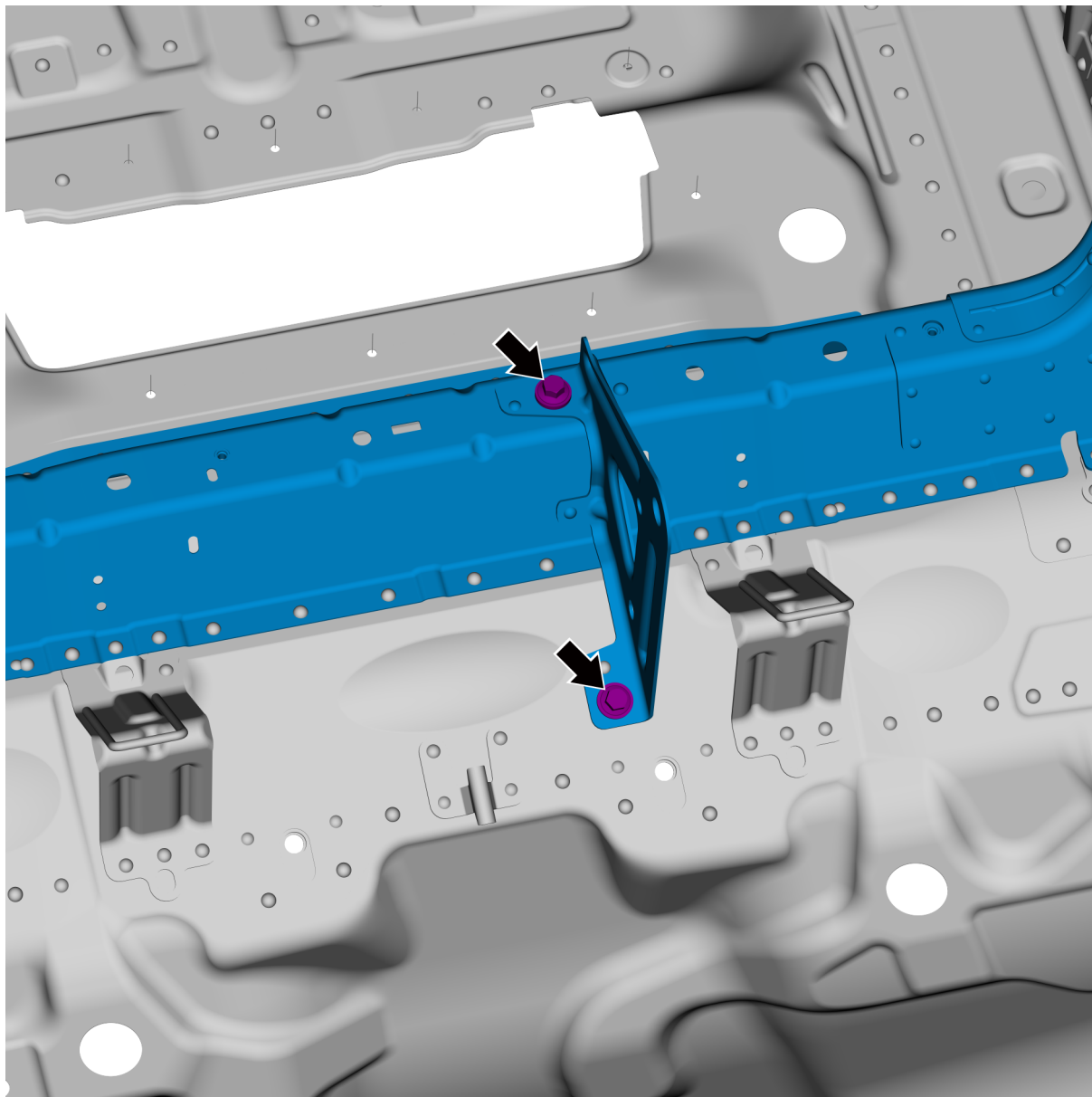
5. Install the rear floor body assembly.
6. Install the rear floor upper beam assembly.
7. Install the rear panel assembly.

## 4.2.43 Removal of the Rear Floor Upper Beam Assembly

### 4.2.43.1 Removal of the Rear Floor Upper Beam Assembly

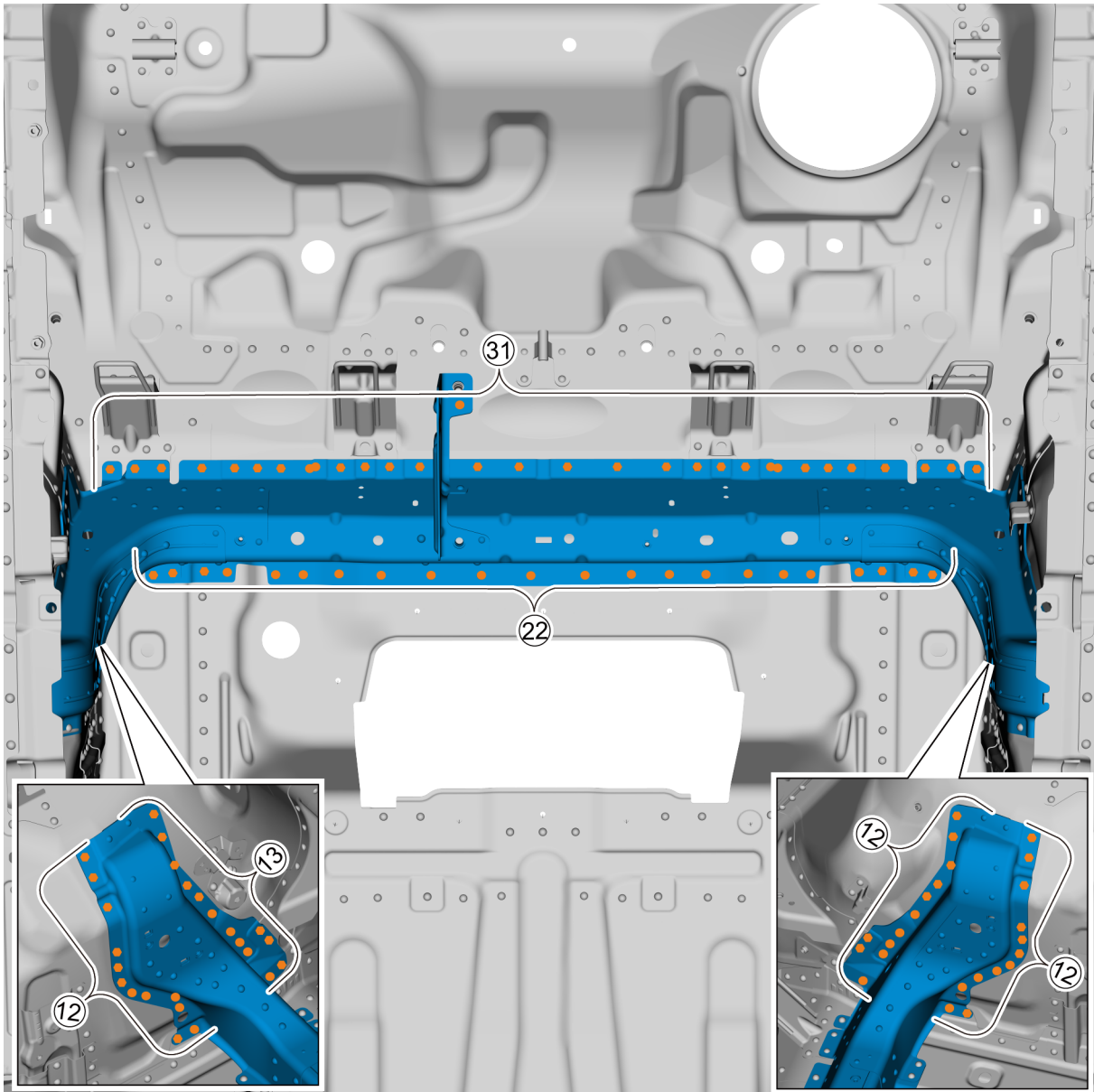
#### Removal of Parts

1. Remove the 2 fixing bolts of the rear floor upper beam assembly.





2. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the rear floor upper beam assembly to the rear floor body assembly and the center floor body and the left and right C-pillar assemblies.

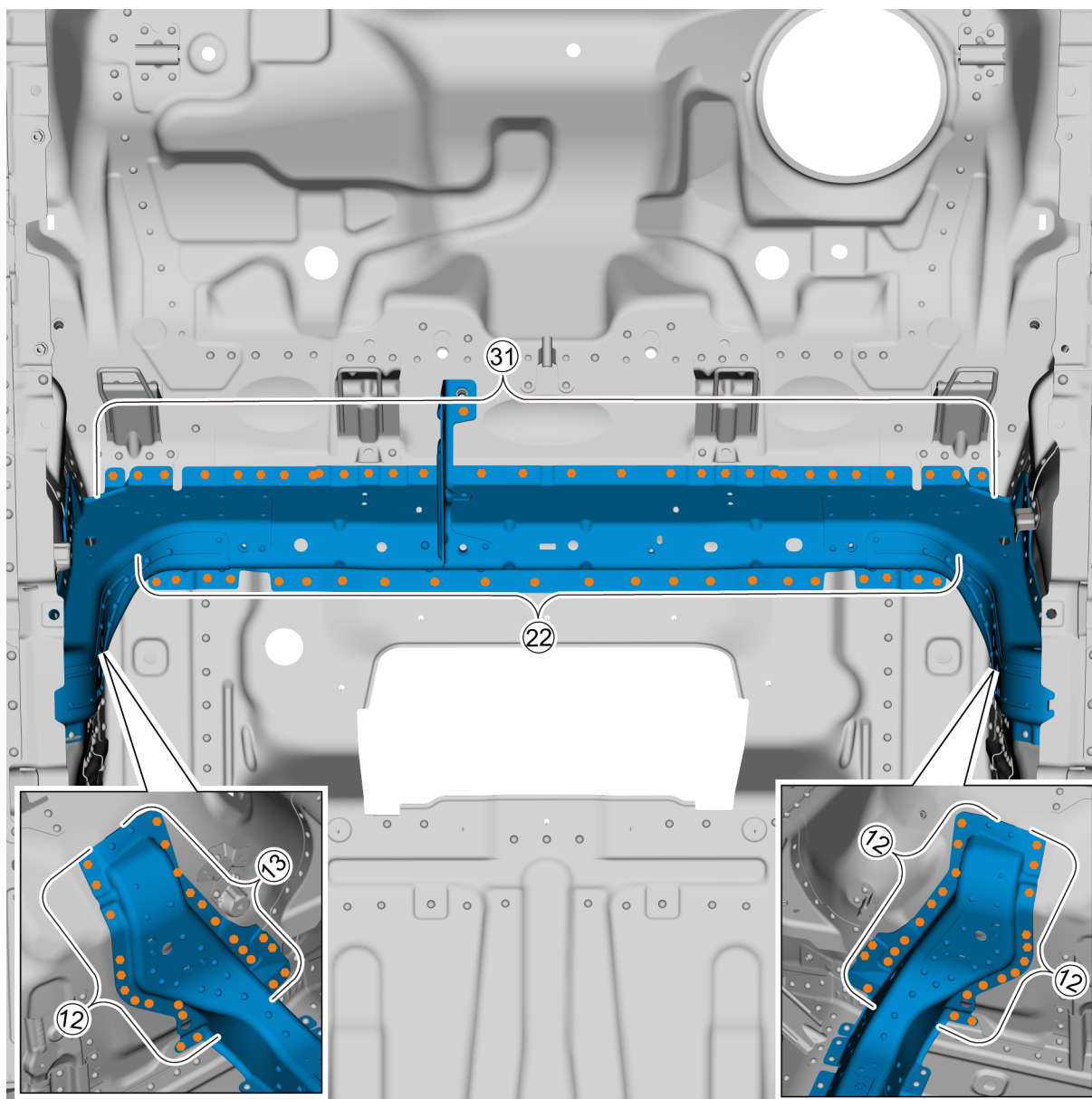


3. Grind away any welding marks that may remain on the body surface and sand the welded surfaces to bare metal (remove surface foreign matter, paint and rust).

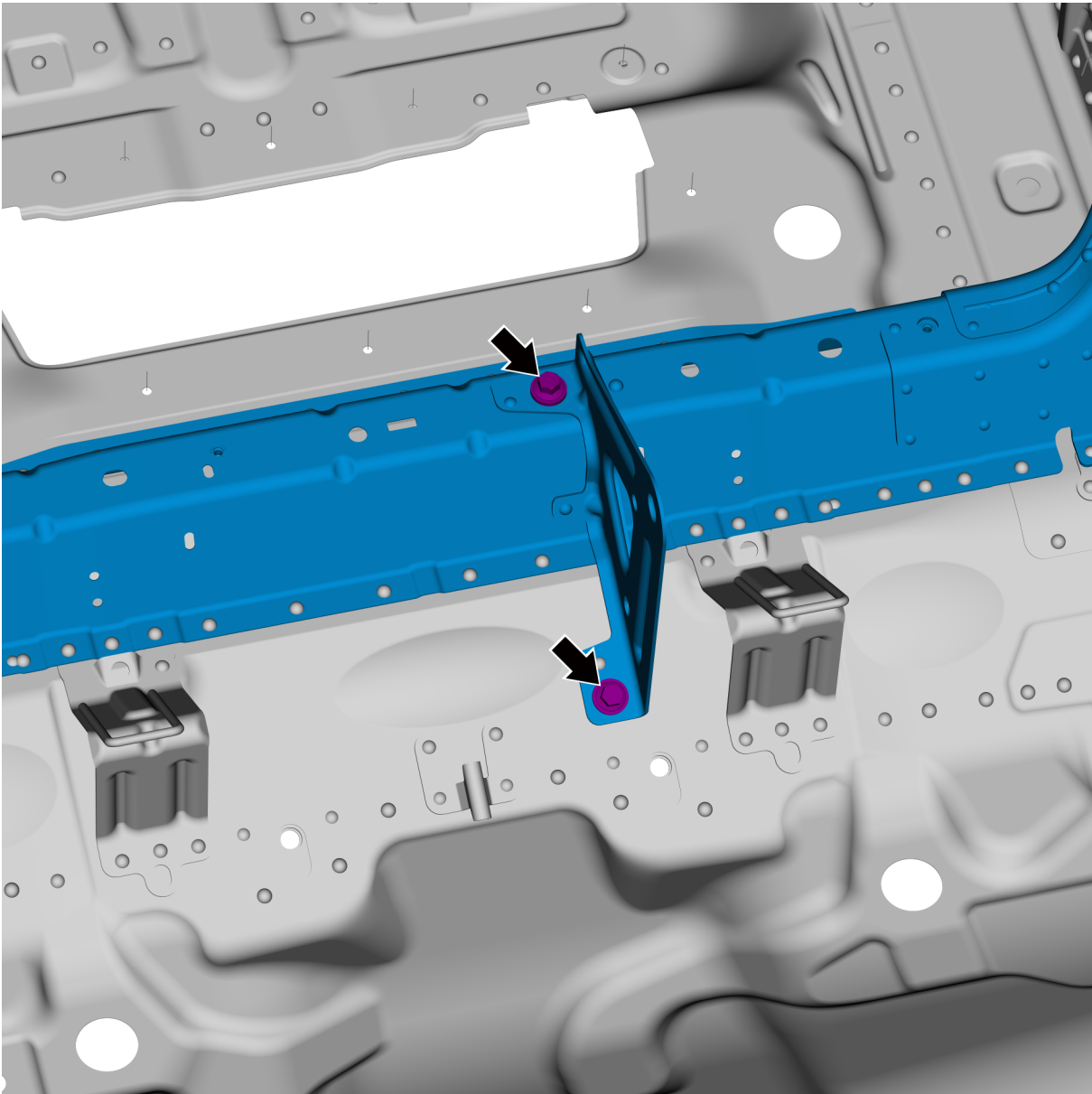
## 4.2.44 Installation of the Rear Floor Upper Beam Assembly

### 4.2.44.1 Installation of the Rear Floor Upper Beam Assembly

1. When installing a new part, match the mounting position of the new part on the body.
2. Temporarily install the new part for initial positioning.
3. Check and measure the positional dimensions of the rear floor upper beam assembly and the body for compliance with the standard, and adjust if necessary.
4. Weld the fixing points of the rear floor upper beam assembly to the rear floor body assembly and the center floor body and left and right C-pillar assemblies.



5. Install the 2 fixing bolts of the rear floor upper beam assembly.

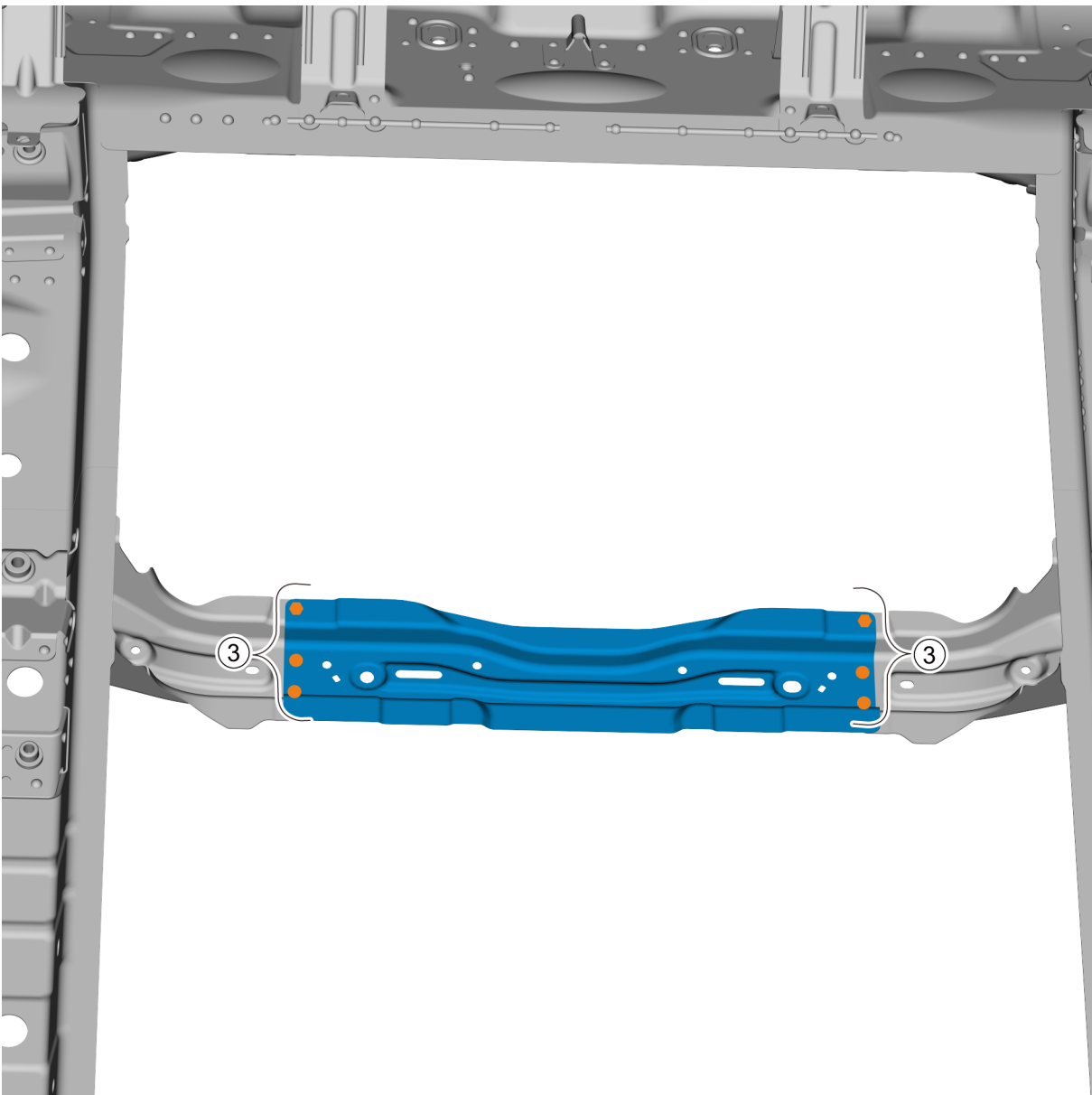


## 4.2.45 Removal of the Spare Tire Pool Lower Reinforcement Beam Assembly

### 4.2.45.1 Removal of the Spare Tire Pool Lower Reinforcement Beam Assembly

#### Removal of Parts

1. Remove the rear panel assembly, refer to [Removal of the Rear Panel Assembly Removal](#).
2. Remove the rear floor upper beam assembly, refer to [Removal of the Rear Floor Upper Beam Assembly](#).
3. Remove the rear floor body assembly, refer to [Removal of the Rear Floor Body Assembly](#).
4. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the reinforcement beam assembly under the spare tire pool to the rear floor left and right longitudinal beam assemblies.

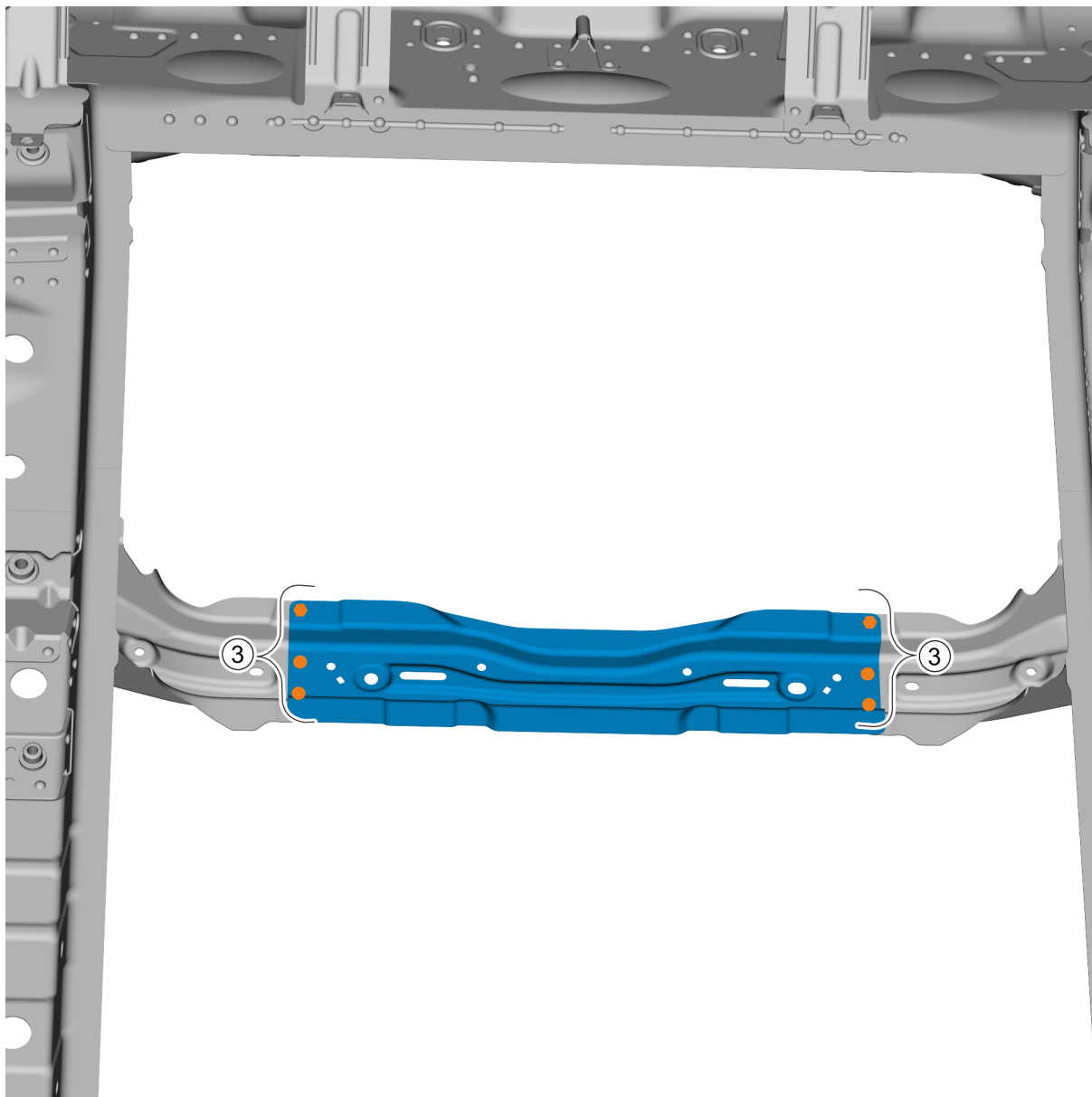


5. Grind away any welding marks that may remain on the body surface and sand the welded surfaces to bare metal (remove surface foreign matter, paint and rust).

## 4.2.46 Installation of the Spare Tire Pool Lower Reinforcement Beam Assembly

### 4.2.46.1 Installation of the Spare Tire Pool Lower Reinforcement Beam Assembly

1. When installing a new part, match the mounting position of the new part on the body.
2. Temporarily install the new part for initial positioning.
3. Check and measure the positional dimensions of the reinforcement beam assembly under the spare tire pool and the body for compliance with the standard, and adjust if necessary.
4. Weld the fixing points of the reinforcement beam assembly under the spare tire pool and the rear floor left and right longitudinal beam assemblies.



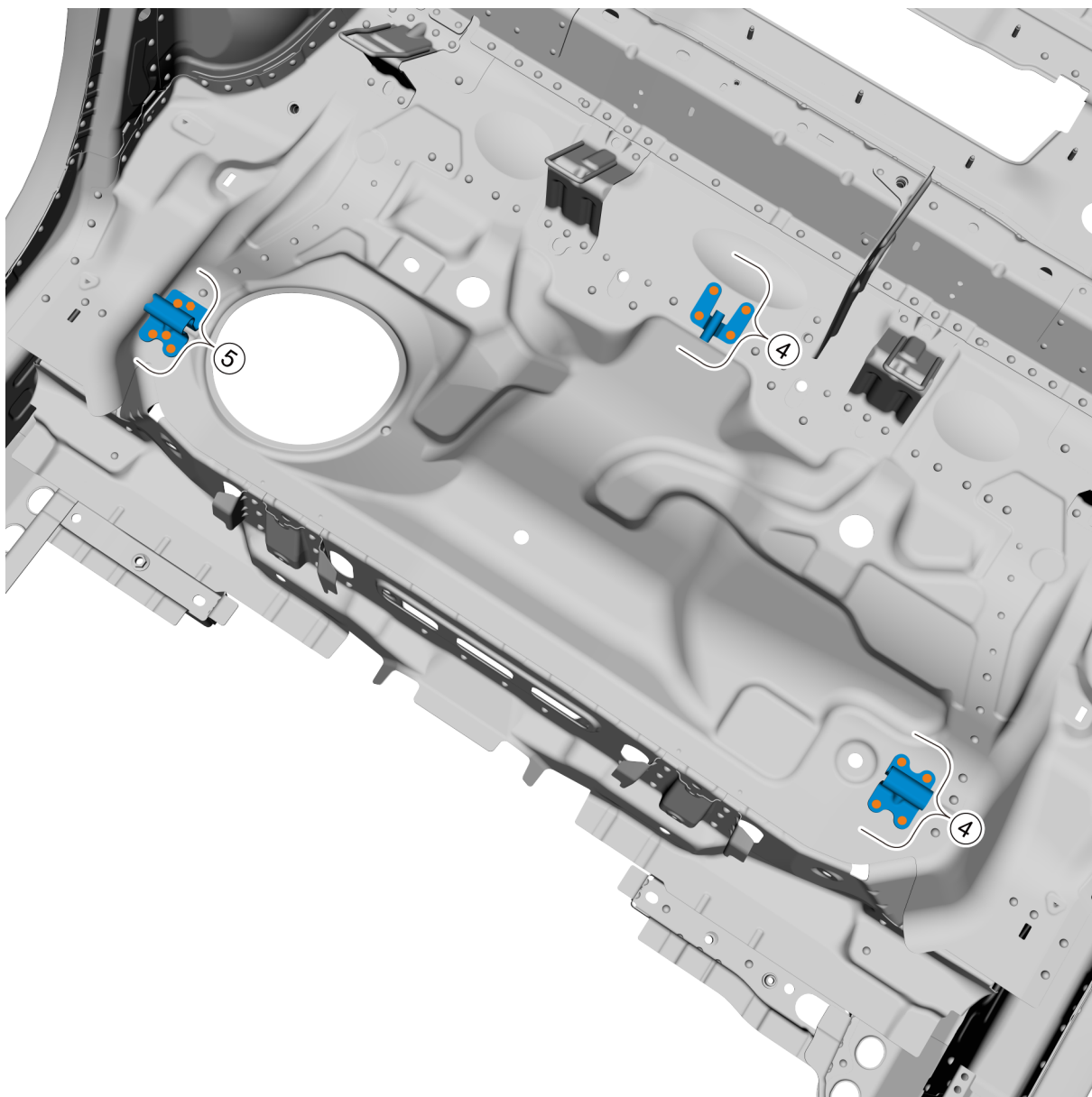
5. Install the rear floor body assembly.
6. Install the rear floor upper beam assembly.
7. Install the rear panel assembly.

## 4.2.47 Removal of the Center Floor Body

### 4.2.47.1 Removal of the Center Floor Body

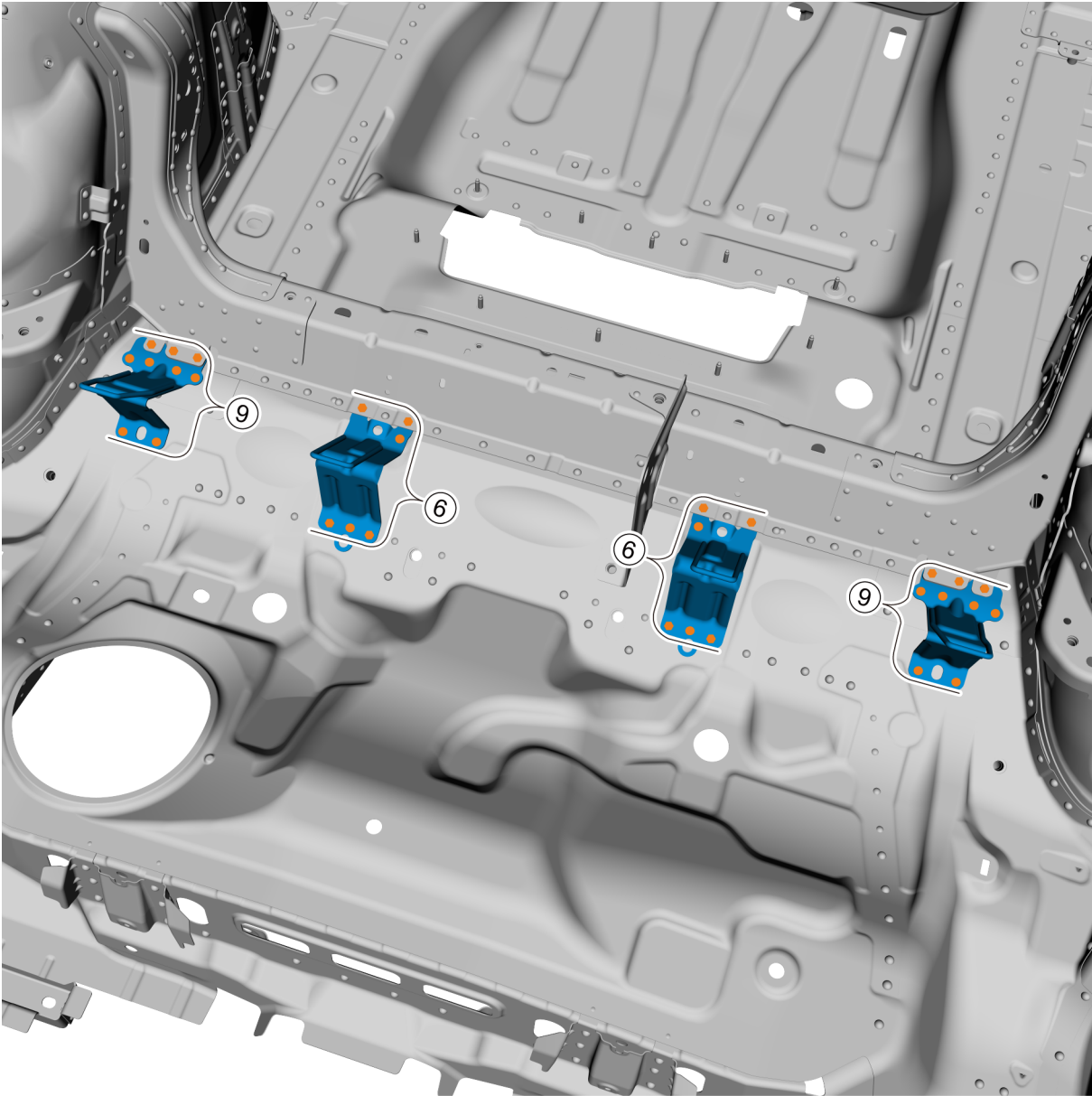
#### Removal of Parts

1. Remove the front floor assembly, refer to [Removal of the Front Floor Assembly](#).
2. Remove the center floor front connecting plate assembly, refer to [Removal of the Center Floor Front Connecting Plate Assembly](#).
3. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the 3 rear seat brackets, and remove the 3 rear seat brackets.

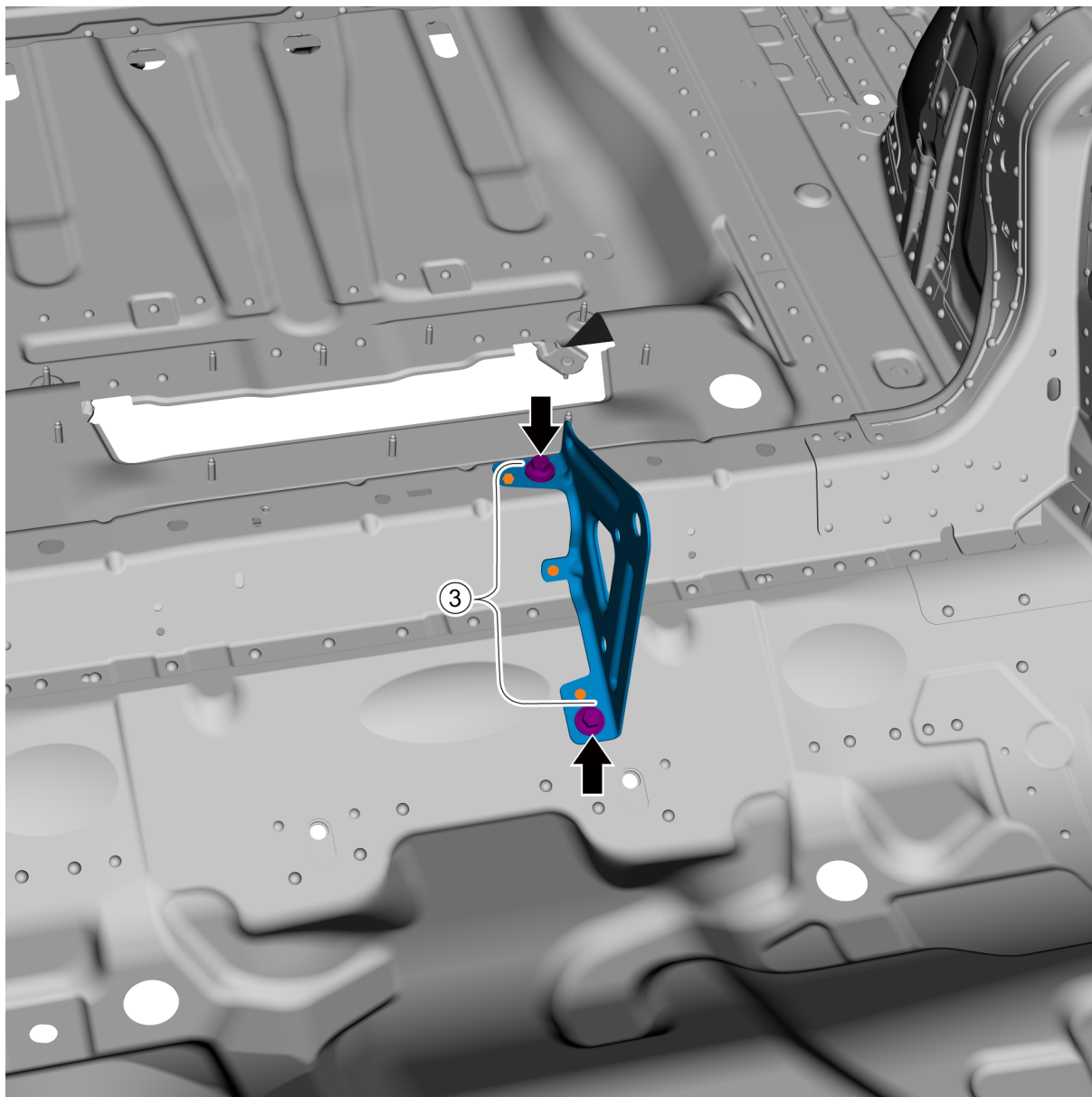




4. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the child seat inner and outer right bracket assemblies and the child seat inner and outer left bracket assemblies, and remove the child seat inner and outer right bracket assemblies and the child seat inner and outer left bracket assemblies.

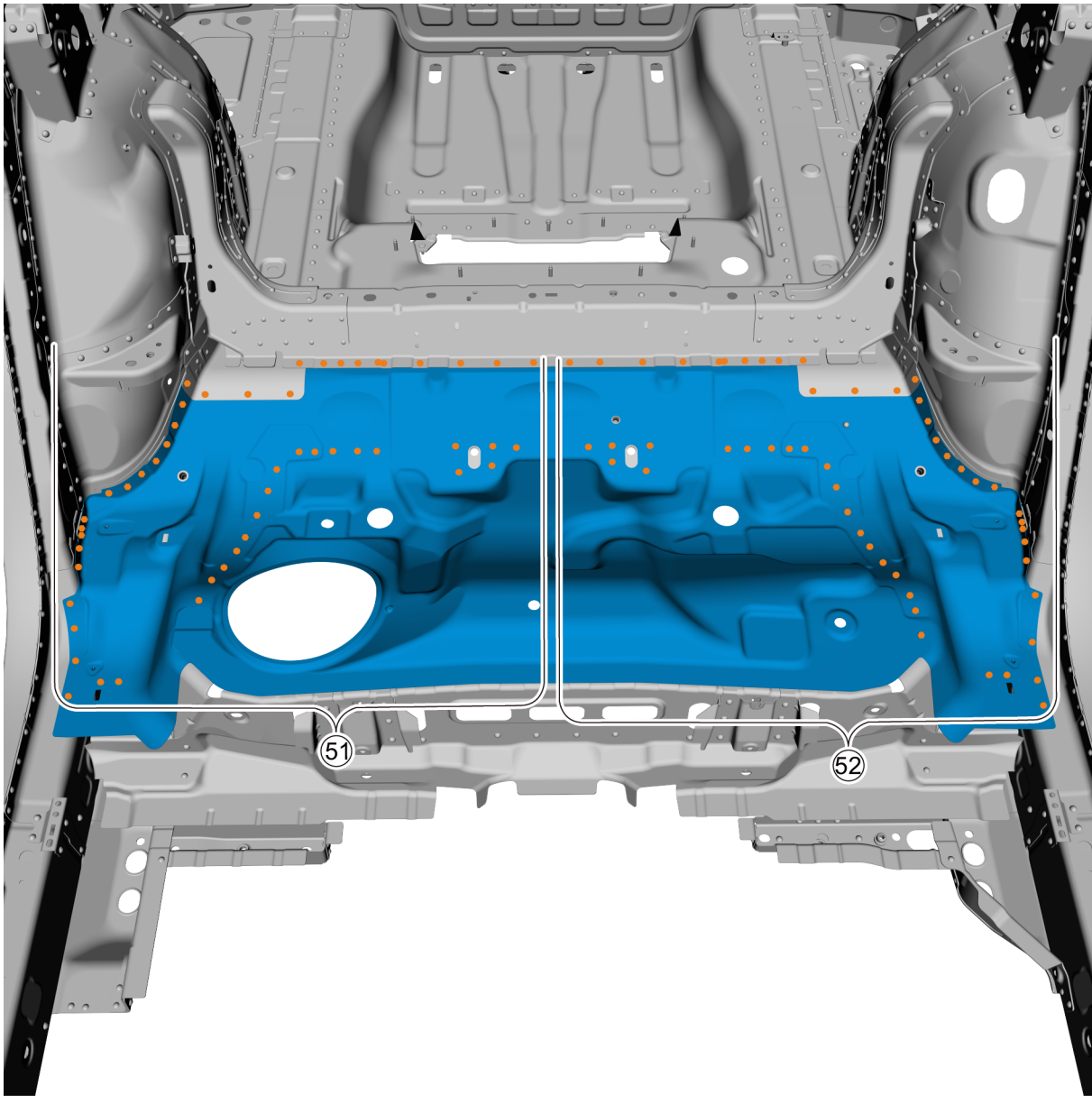


5. Remove the 2 fixing bolts for the mounting brackets in the rear seat.
6. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the mounting brackets in the rear seat, and remove the mounting brackets in the rear seat.





7. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the center floor body to the rear floor body assembly and the rear floor left and right longitudinal beam assembly and the center floor lower beam assembly (front).

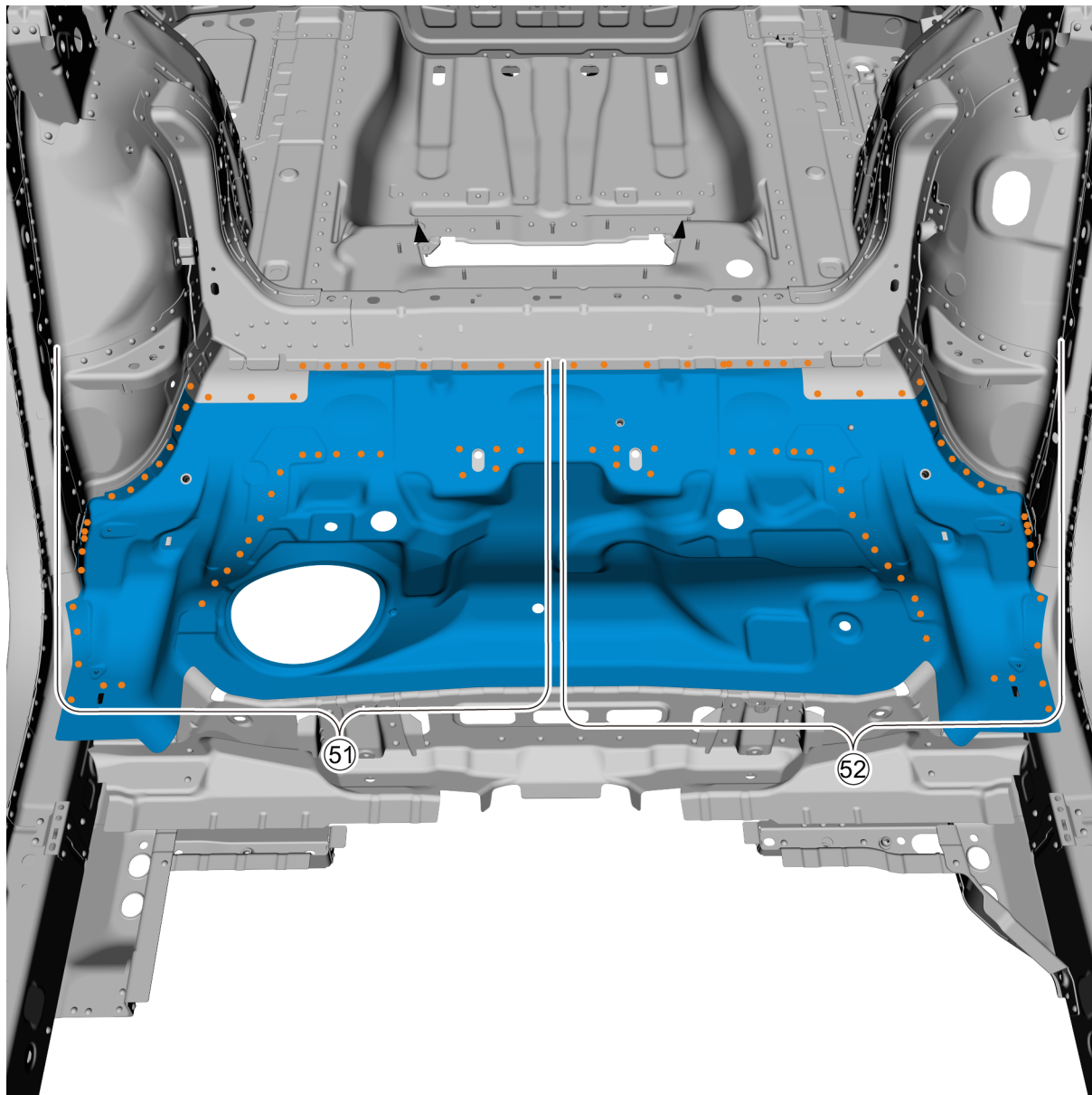


8. Grind away any welding marks that may remain on the body surface and sand the welded surfaces to bare metal (remove surface foreign matter, paint and rust).

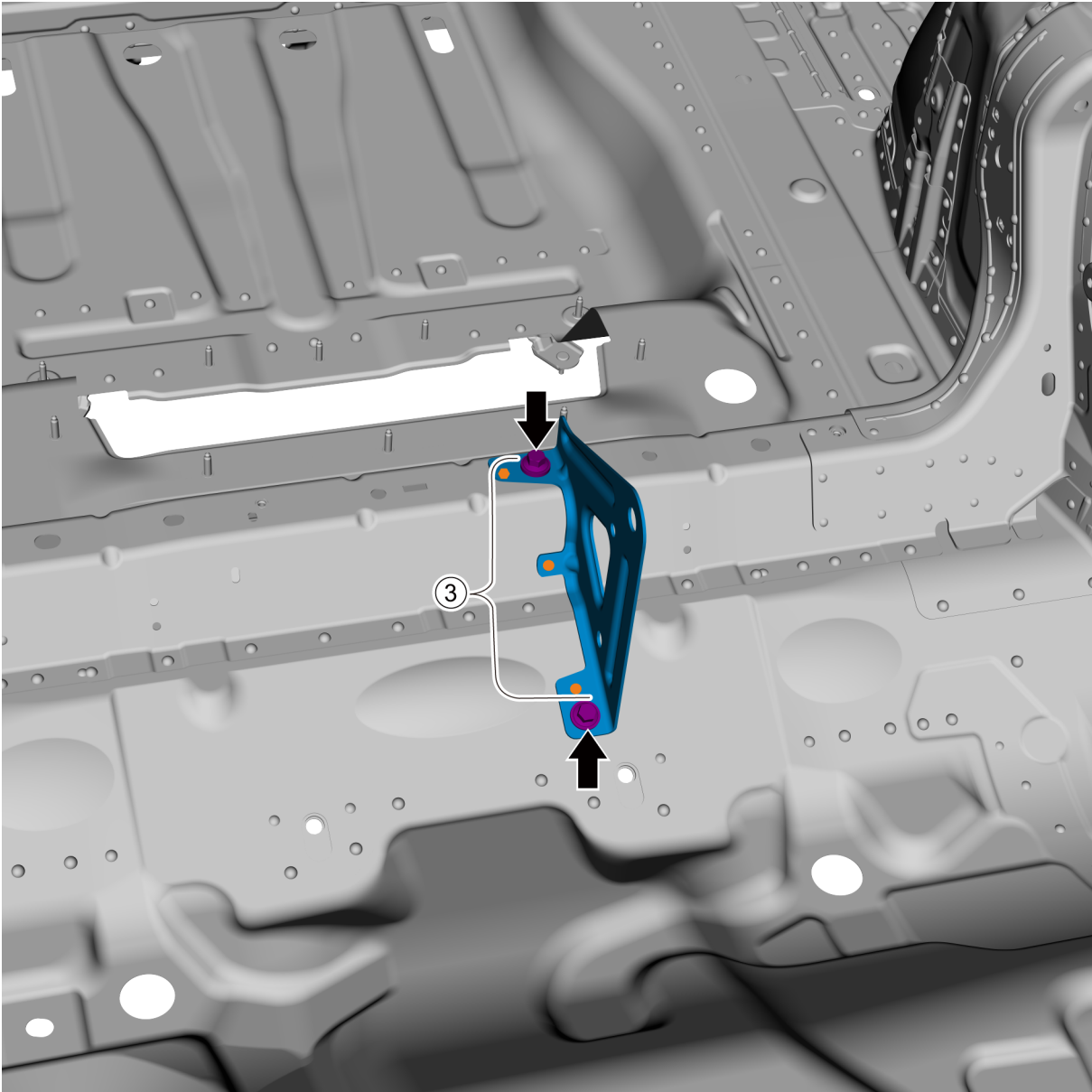
## 4.2.48 Installation of the Center Floor Body

### 4.2.48.1 Installation of the Center Floor Body

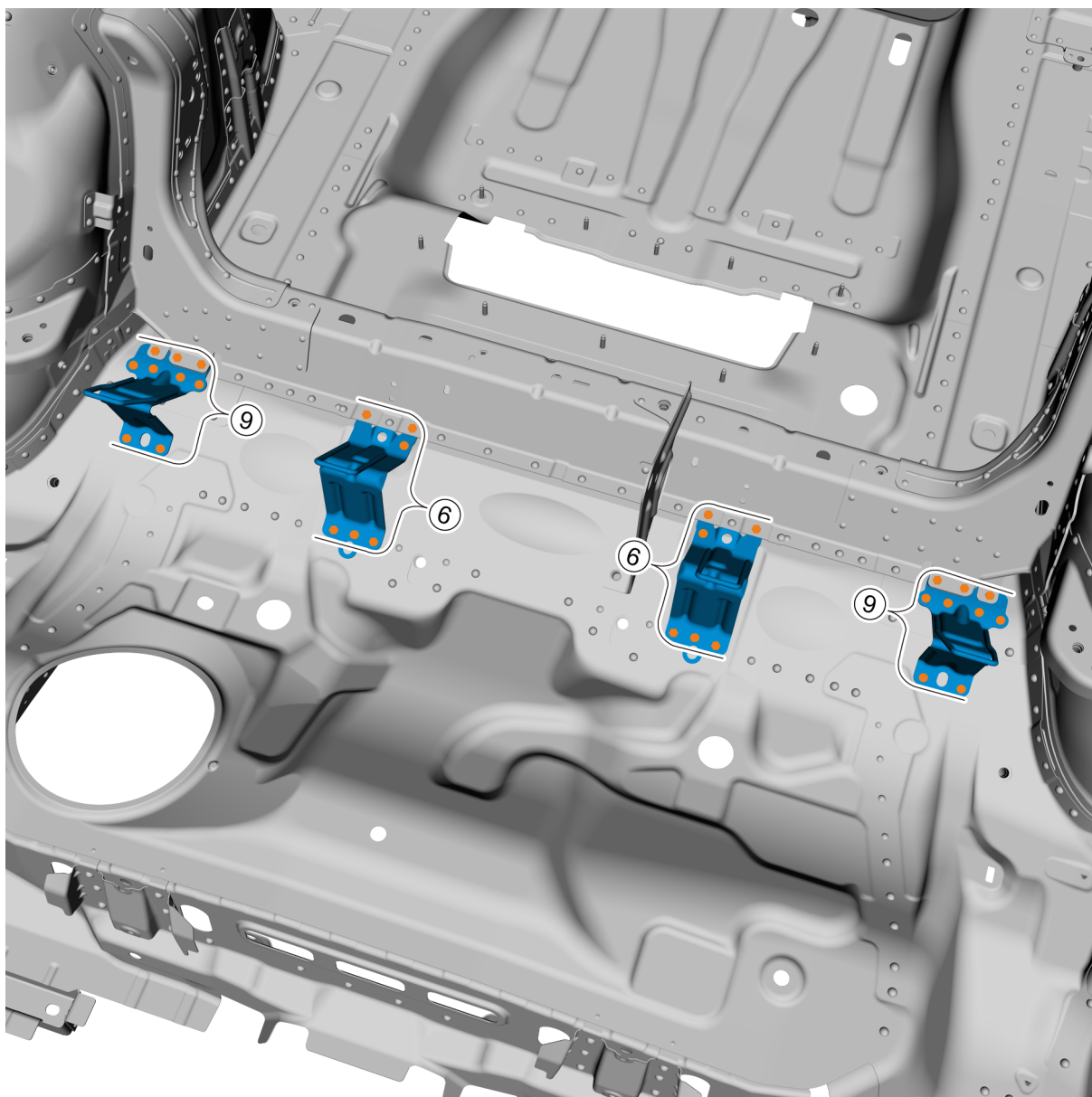
1. When installing a new part, match the mounting position of the new part on the body.
2. Temporarily install the new part for initial positioning.
3. Check and measure the positional dimensions of the center floor body and the body for compliance with the standard, and adjust if necessary.
4. Weld and remove the fixing points of center floor body to the rear floor body assembly and the rear floor left and right longitudinal beam assemblies and the center floor lower beam assembly (front).



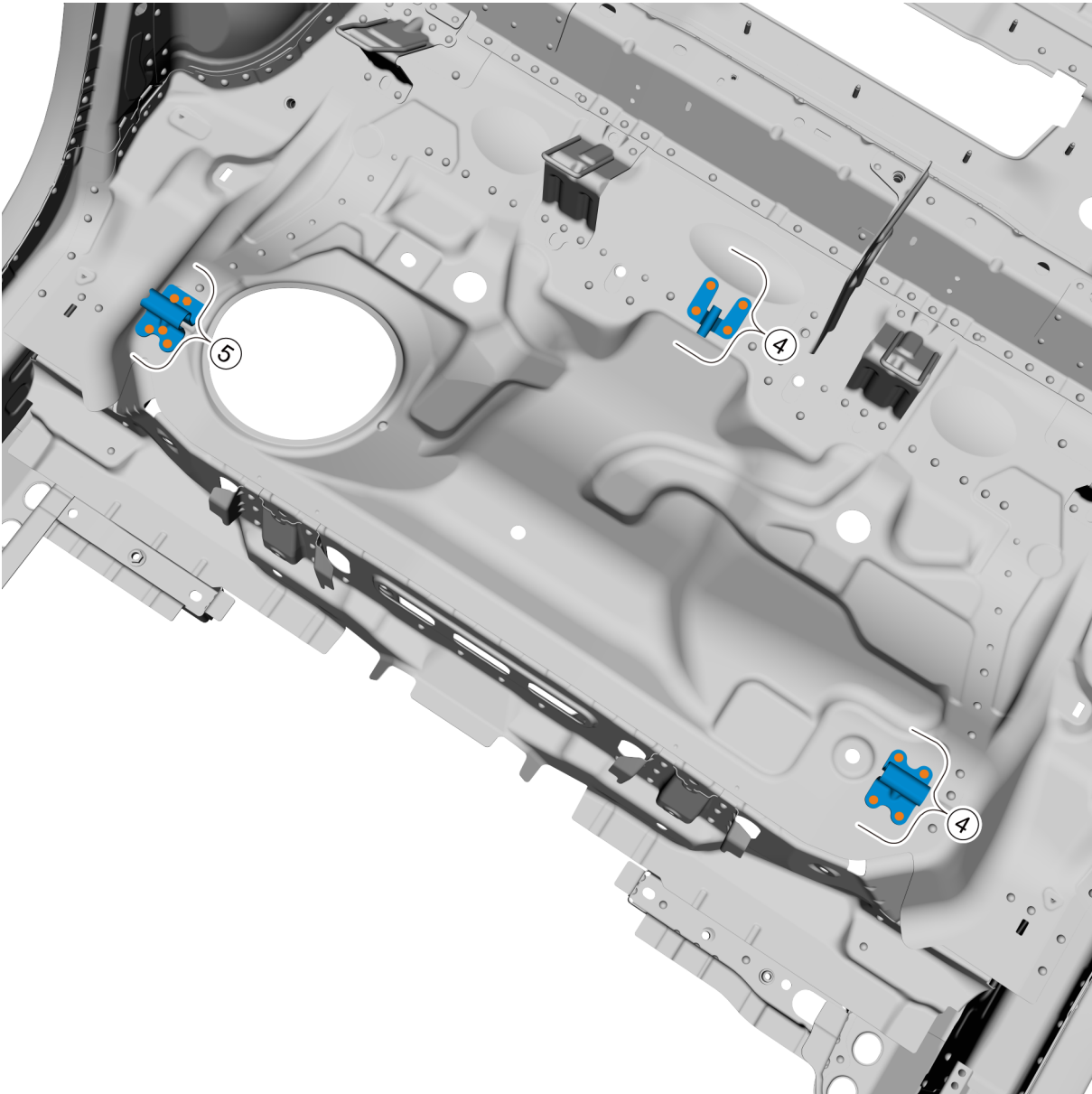
5. Weld the fixing points of the mounting brackets in the rear seat.
6. Install the 2 fixing bolts of the mounting brackets in the rear seat.



7. Weld the fixing points of the child seat inner and outer right bracket assemblies and the child seat inner and outer left bracket assemblies.



8. Weld the 3 fixing points of the rear seat brackets.



9. Install the center floor front connecting plate assembly.

10. Install the front floor assembly.

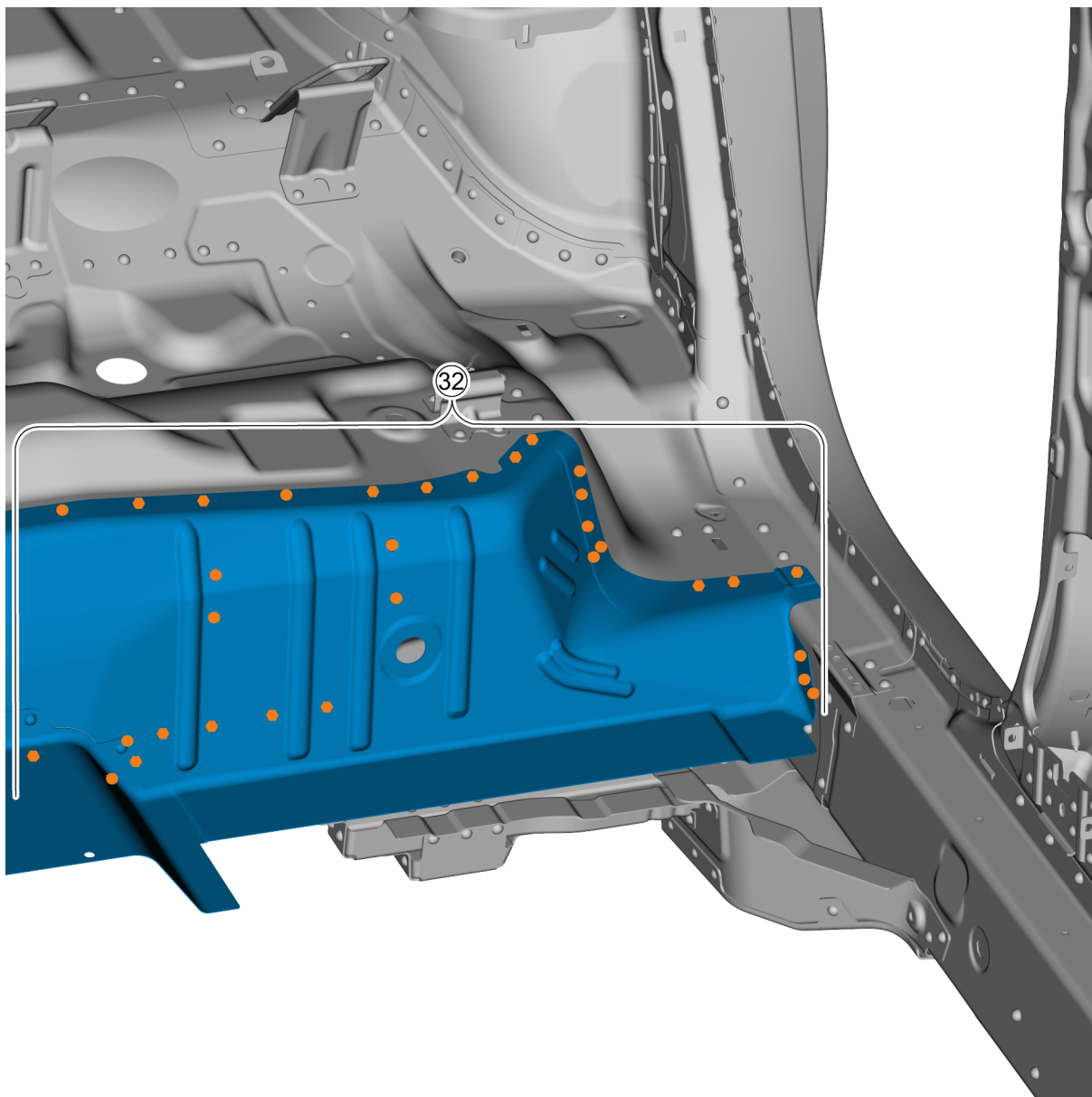


## 4.2.49 Removal of the Center Floor Front Connecting Plate Assembly

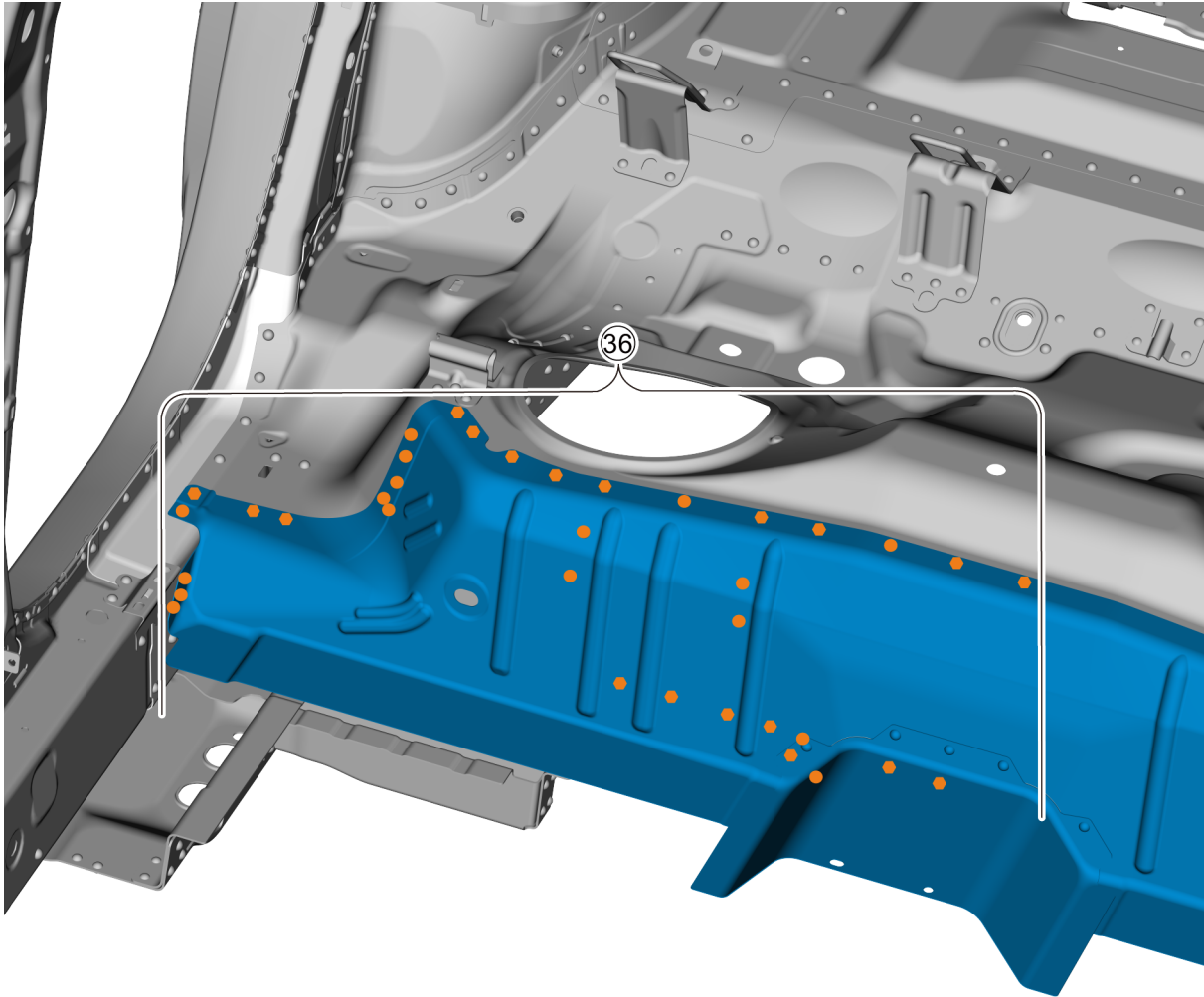
### 4.2.49.1 Removal of the Center Floor Front Connecting Plate Assembly

#### Removal of Parts

1. Remove the front floor assembly, refer to [Removal of the Front Floor Assembly](#).
2. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the center floor front connecting plate assembly to the rear floor left longitudinal beam assembly and the center floor body and the center floor lower beam assembly (front).



3. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the center floor front connecting plate assembly to the rear floor right longitudinal beam assembly and the center floor body and center floor lower beam assembly (front).



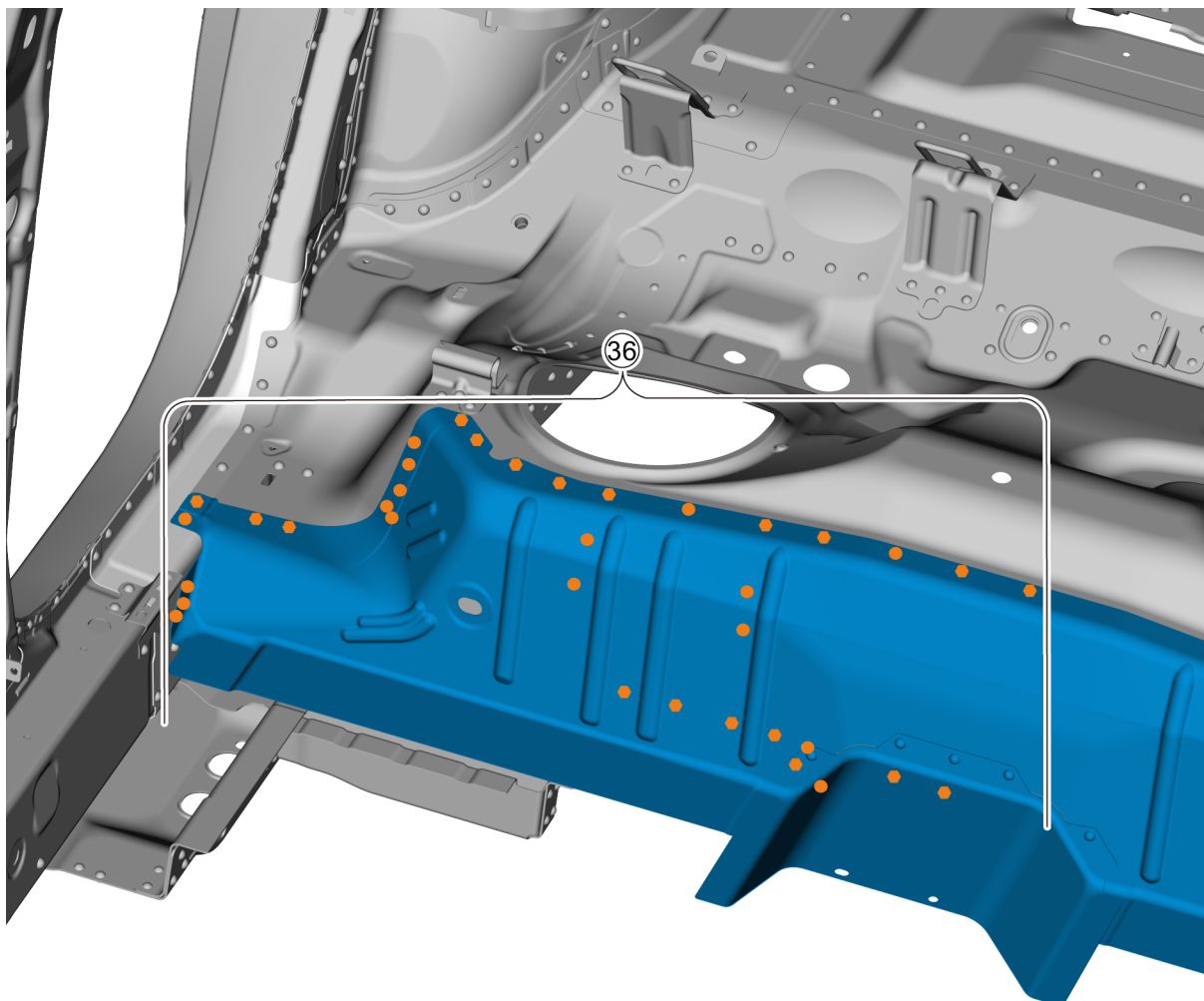
4. Grind away any welding marks that may remain on the body surface and sand the welded surfaces to bare metal (remove surface foreign matter, paint and rust).



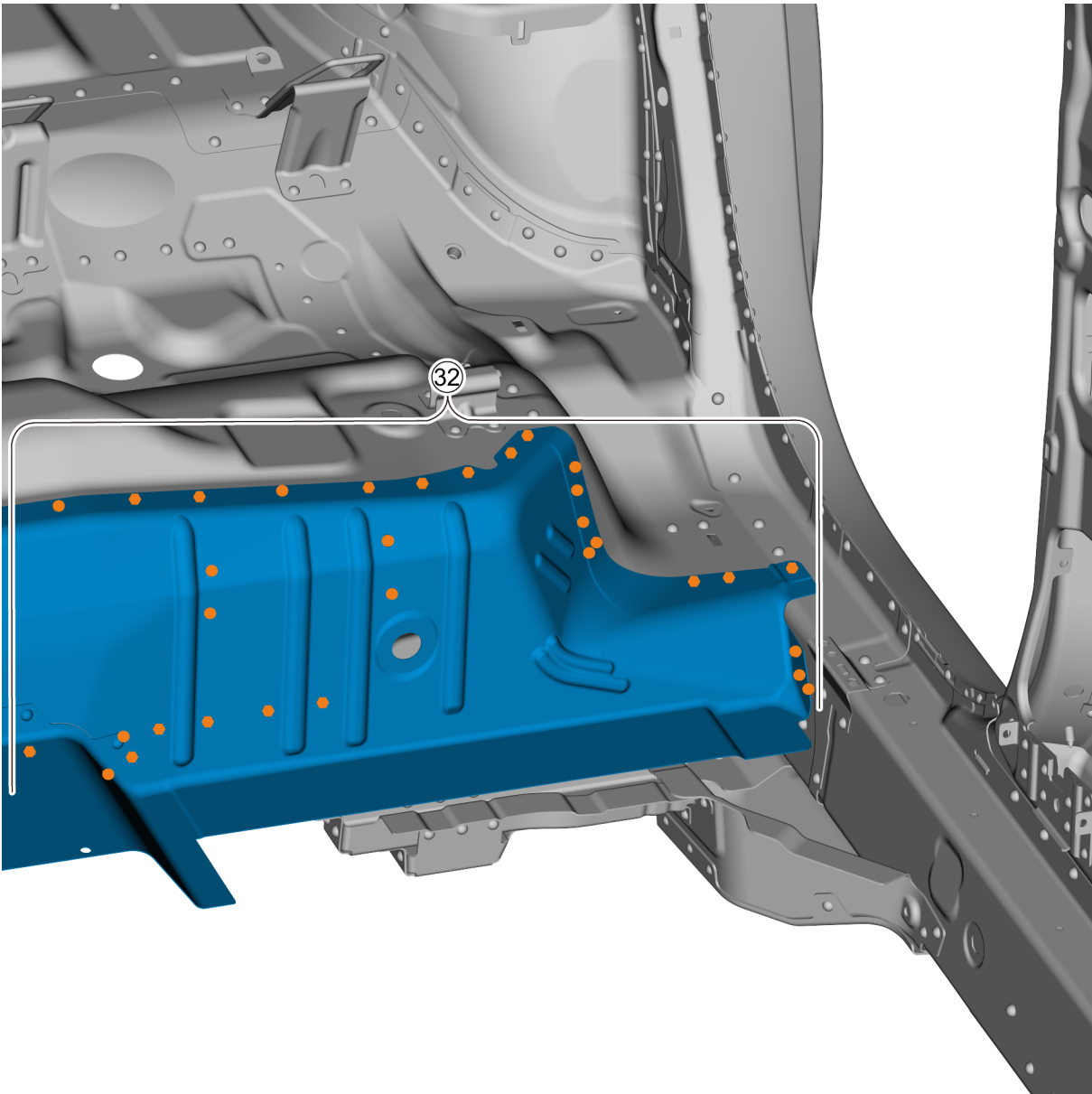
## 4.2.50 Installation of the Center Floor Front Connecting Plate Assembly

### 4.2.50.1 Installation of the Center Floor Front Connecting Plate Assembly

1. When installing a new part, match the mounting position of the new part on the body.
2. Temporarily install the new part for initial positioning.
3. Check and measure the positional dimensions of the center floor front connecting plate assembly and the body for compliance with the standard, and adjust if necessary.
4. Weld the fixing points of the center floor front connecting plate assembly to the rear floor right longitudinal beam assembly and the center floor body and the center floor lower beam assembly (front).



5. Weld the fixing points of the center floor front connecting plate assembly to the rear floor left longitudinal beam assembly and the center floor body and center floor lower beam assembly (front).



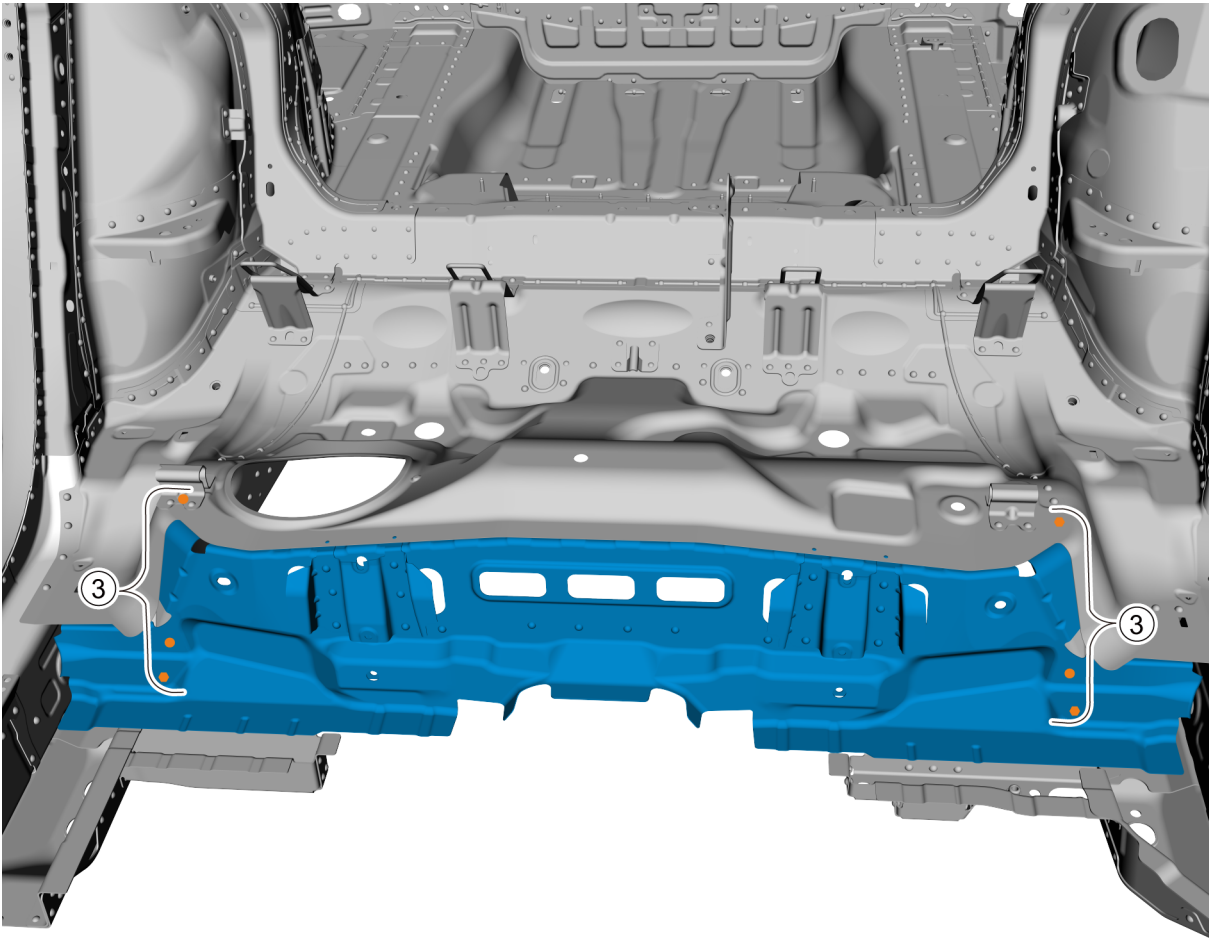
6. Install the front floor assembly.

## 4.2.51 Removal of the Center Floor Lower Beam Assembly (front)

### 4.2.51.1 Removal of the Center Floor Lower Beam Assembly (front)

#### Removal of Parts

1. Remove the front floor assembly, refer to [Removal of the Front Floor Assembly](#).
2. Remove the center floor front connecting plate assembly, refer to [Removal of the Center Floor Front Connecting Plate Assembly](#).
3. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the center floor lower beam assembly (front) to the center floor body and the rear floor left and right longitudinal beam assemblies.

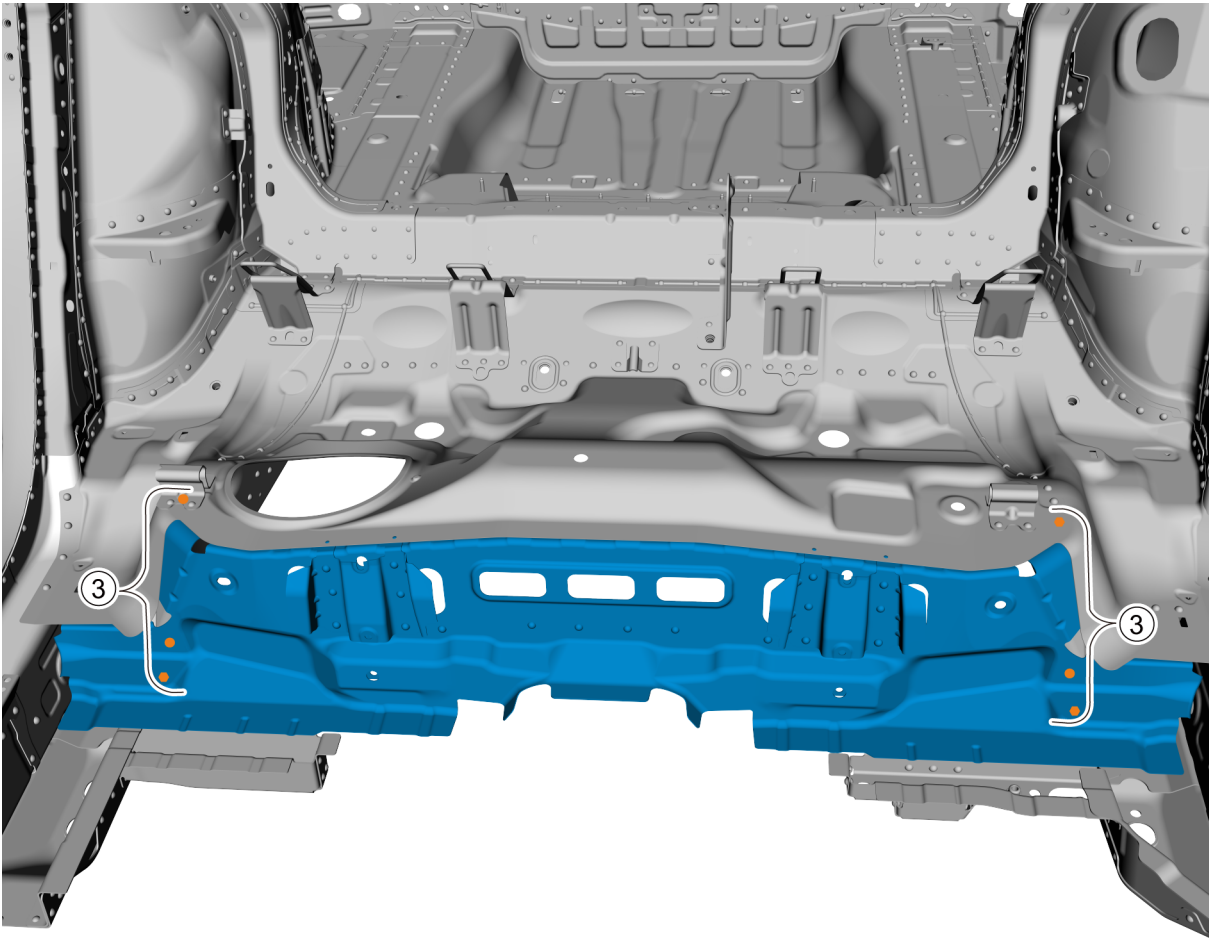


4. Grind away any welding marks that may remain on the body surface and sand the welded surfaces to bare metal (remove surface foreign matter, paint and rust).

## 4.2.52 Installation of the Center Floor Lower Beam Assembly (front)

### 4.2.52.1 Installation of the Center Floor Lower Beam Assembly (front)

1. When installing a new part, match the mounting position of the new part on the body.
2. Temporarily install the new part for initial positioning.
3. Check and measure the positional dimensions of the center floor lower beam assembly (front) and the body for compliance with the standard, and adjust if necessary.
4. Weld the fixing points of the center floor lower beam assembly (front) to the center floor body and the rear floor left and right longitudinal beam assemblies.



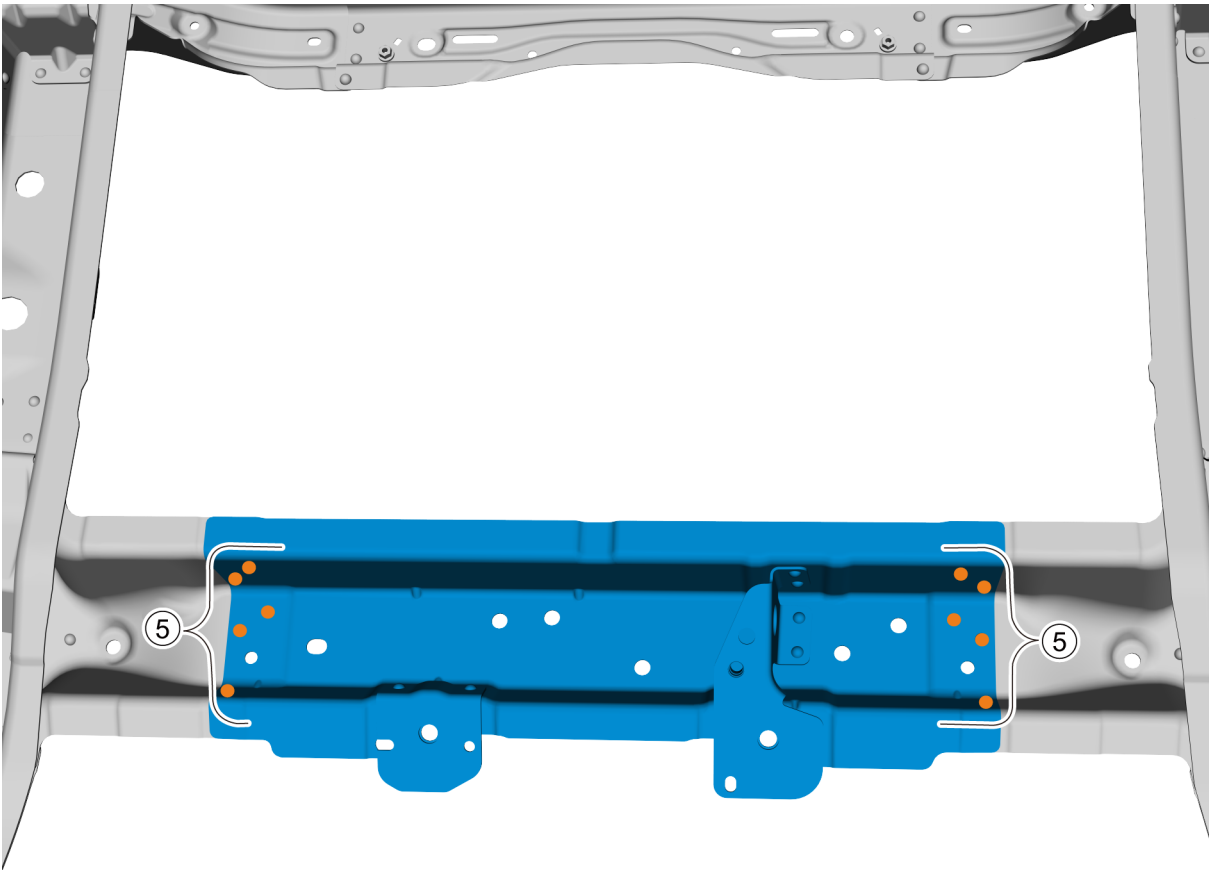
5. Install the center floor front connecting plate assembly.
6. Install the front floor assembly.

## 4.2.53 Removal of the Center Floor Lower Beam Assembly (rear)

### 4.2.53.1 Removal of the Center Floor Lower Beam Assembly (rear)

#### Removal of Parts

1. Remove the rear floor upper beam assembly, refer to [Removal of the Rear Floor Upper Beam Assembly](#)..
2. Remove the rear floor body assembly, refer to [Removal of the Rear Floor Body Assembly](#).
3. Remove the front floor assembly, refer to [Removal of the Front Floor Assembly](#).
4. Remove the center floor front connecting plate assembly, refer to [Removal of the Center Floor Front Connecting Plate Assembly](#).
5. Remove the center floor body, refer to [Removal of the Center Floor Body](#).
6. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the center floor lower beam assembly (rear) and the rear floor left and right longitudinal beam assemblies.

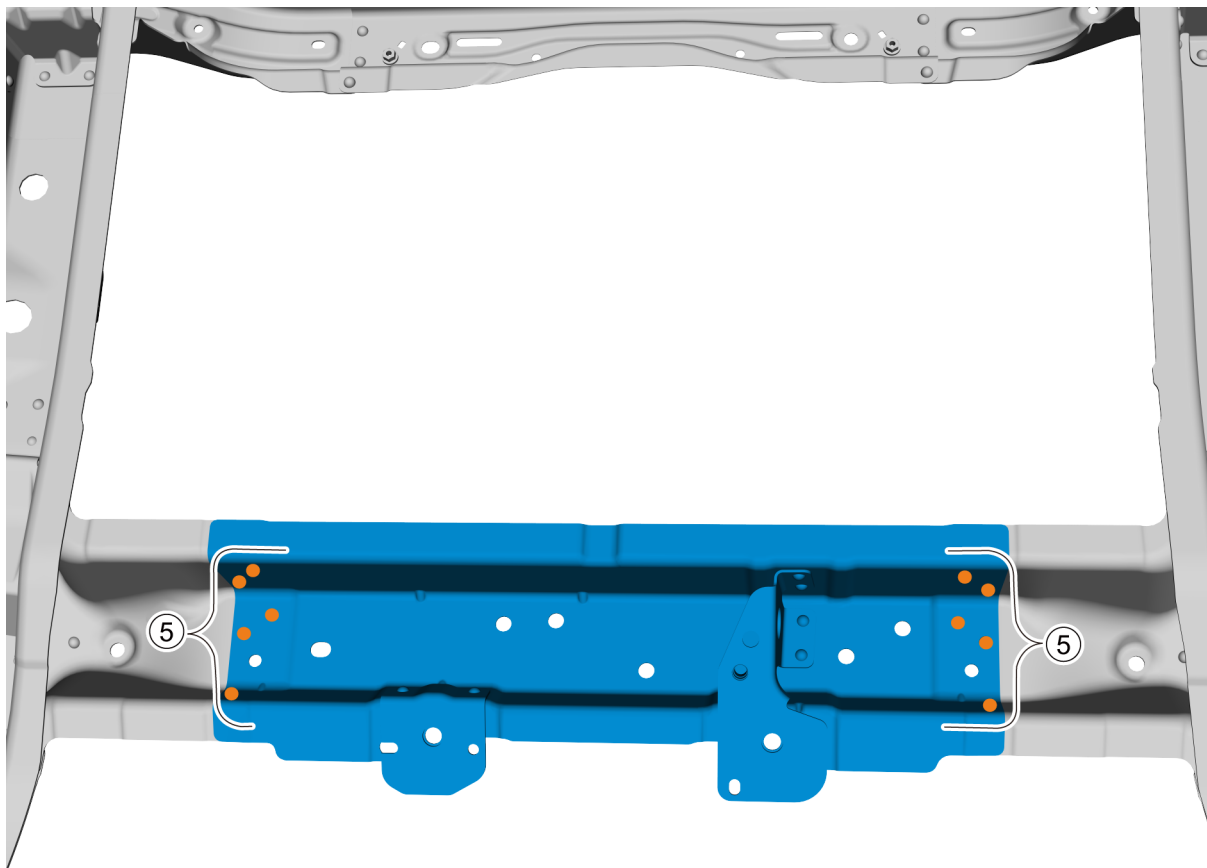


7. Grind away any welding marks that may remain on the body surface and sand the welded surfaces to bare metal (remove surface foreign matter, paint and rust).

## 4.2.54 Installation of the Center Floor Lower Beam Assembly (rear)

### 4.2.54.1 Installation of the Center Floor Lower Beam Assembly (rear)

1. When installing a new part, match the mounting position of the new part on the body.
2. Temporarily install the new part for initial positioning.
3. Check and measure the positional dimensions of the center floor lower beam assembly (rear) and the body for compliance with the standard, and adjust if necessary.
4. Weld the fixing points of the center floor lower beam assembly (rear) to the rear floor left and right longitudinal beam assemblies.



5. Install the center floor body.
6. Install the center floor front connecting plate assembly.
7. Install the front floor assembly.
8. Install the rear floor body assembly.



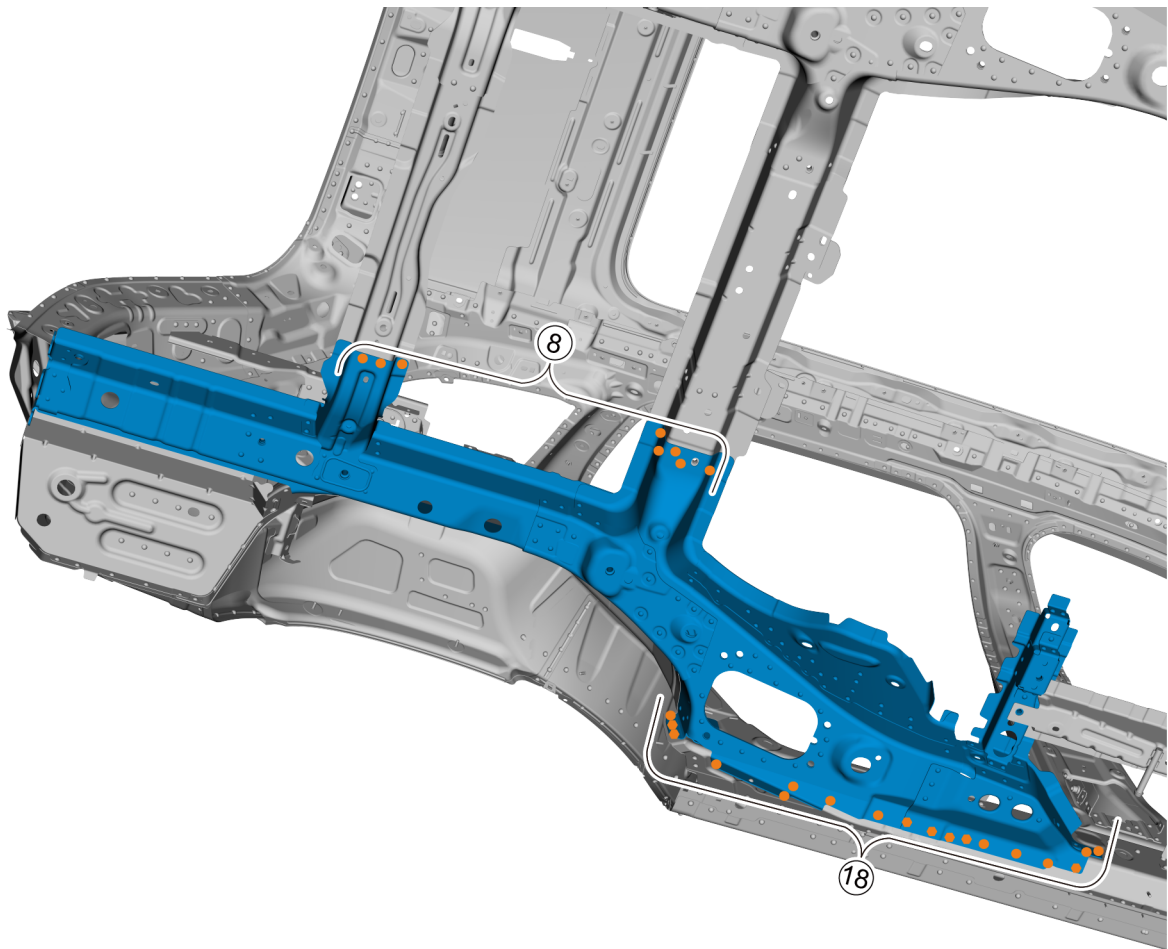
9. Install the rear floor upper beam assembly.

## 4.2.55 Removal of the Rear Floor Left Longitudinal Beam Assembly

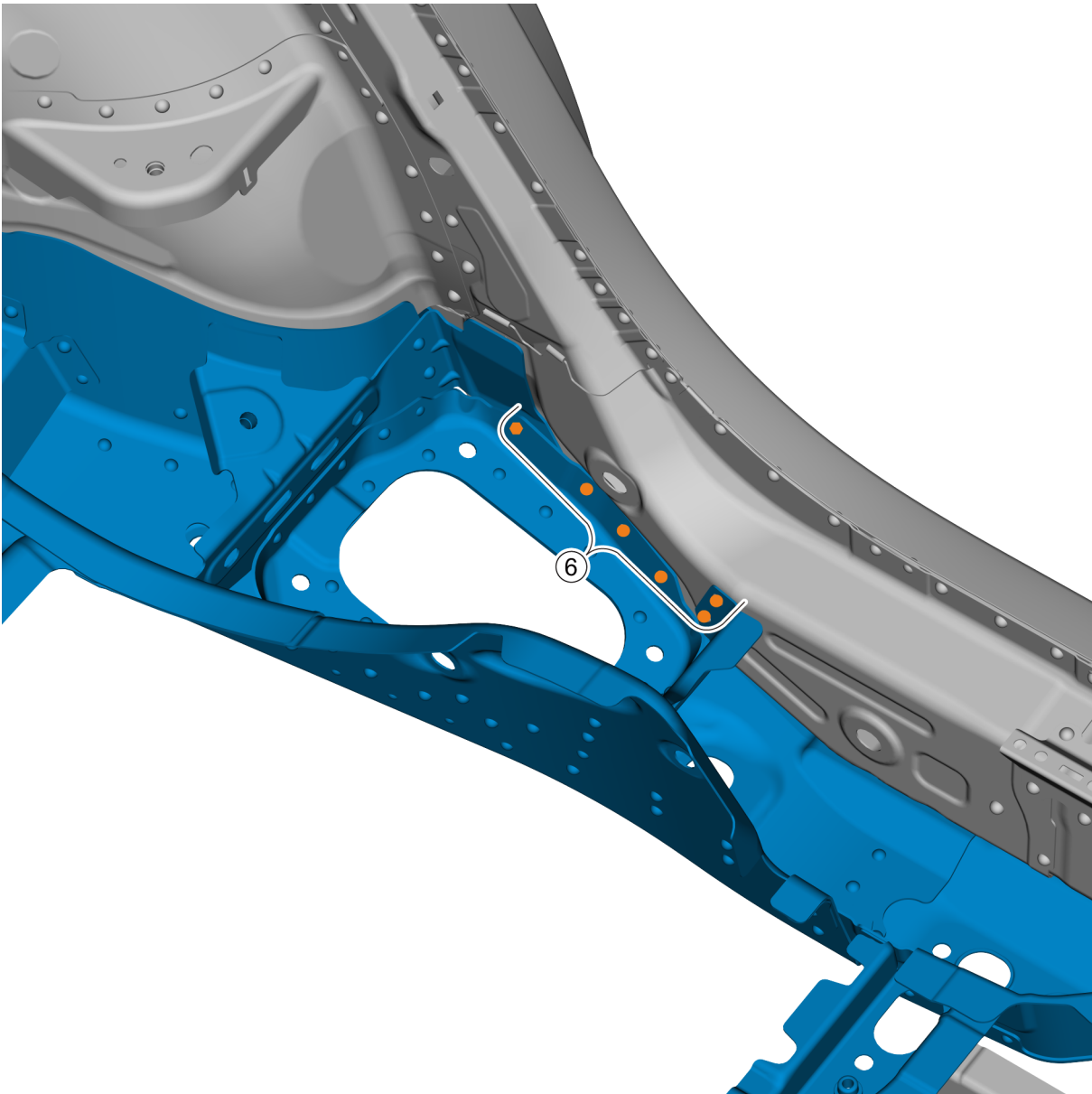
### 4.2.55.1 Removal of the Rear Floor Left Longitudinal Beam Assembly

#### Removal of Parts

1. Remove the rear panel assembly, refer to [Removal of the Rear Panel Assembly Removal](#).
2. Remove the rear floor upper beam assembly, refer to [Removal of the Rear Floor Upper Beam Assembly](#).
3. Remove the rear floor body assembly, refer to [Removal of the Rear Floor Body Assembly](#).
4. Remove the front floor assembly, refer to [Removal of the Front Floor Assembly](#).
5. Remove the center floor front connecting plate assembly, refer to [Removal of the Center Floor Front Connecting Plate Assembly](#).
6. Remove the center floor lower beam assembly (front), refer to [Removal of the Center Floor Lower Beam Assembly \(front\)](#).
7. Remove the center floor body, refer to [Removal of the Center Floor Body](#).
8. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the rear floor left longitudinal beam assembly to the reinforcement beam assembly under the spare tire pool and the center floor lower beam assembly (rear) and the left door sill inner plate assembly and the left C-pillar assembly.



9. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the rear floor left longitudinal beam assembly to the left C-pillar assembly.

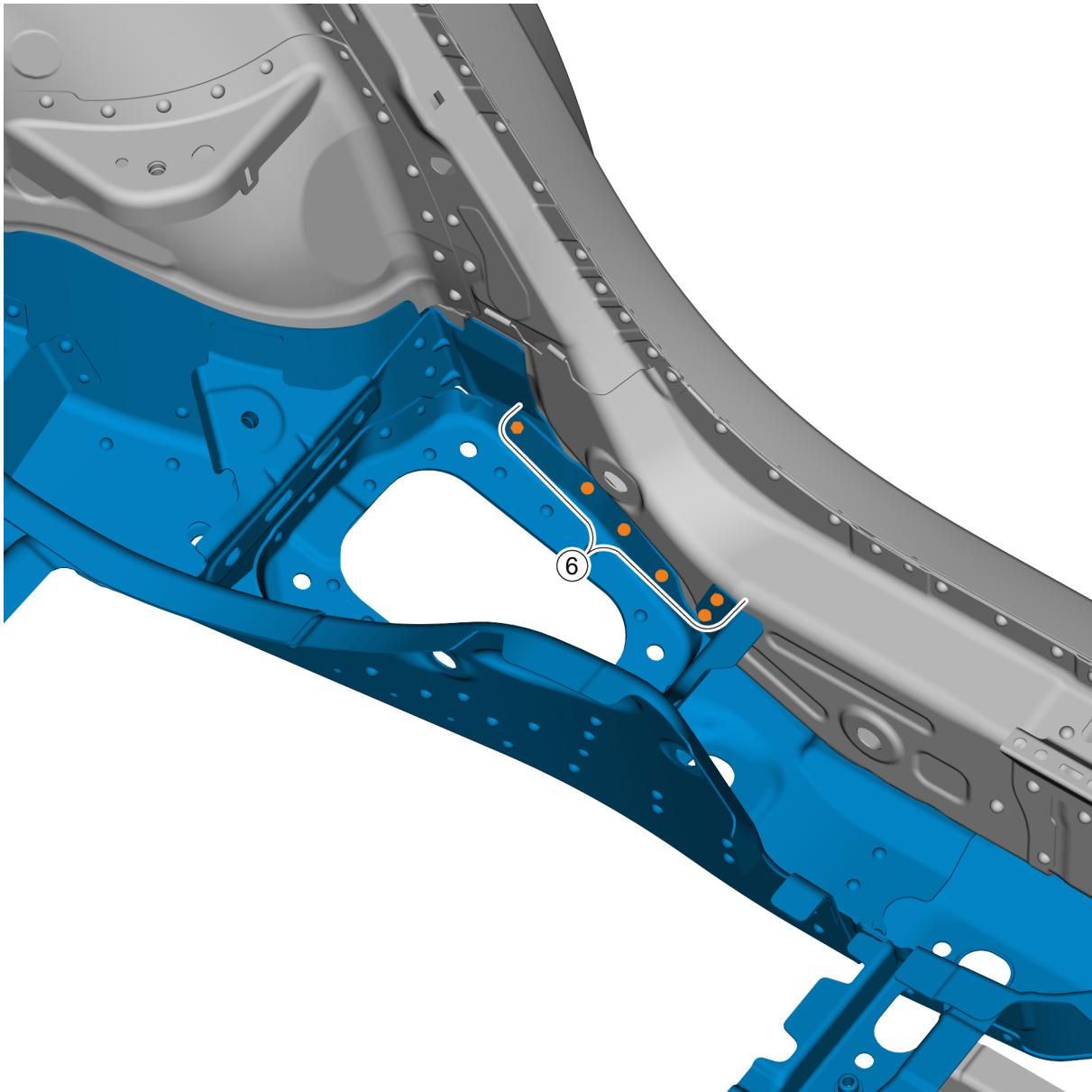


10. Grind away any welding marks that may remain on the body surface and sand the welded surfaces to bare metal (remove surface foreign matter, paint and rust).

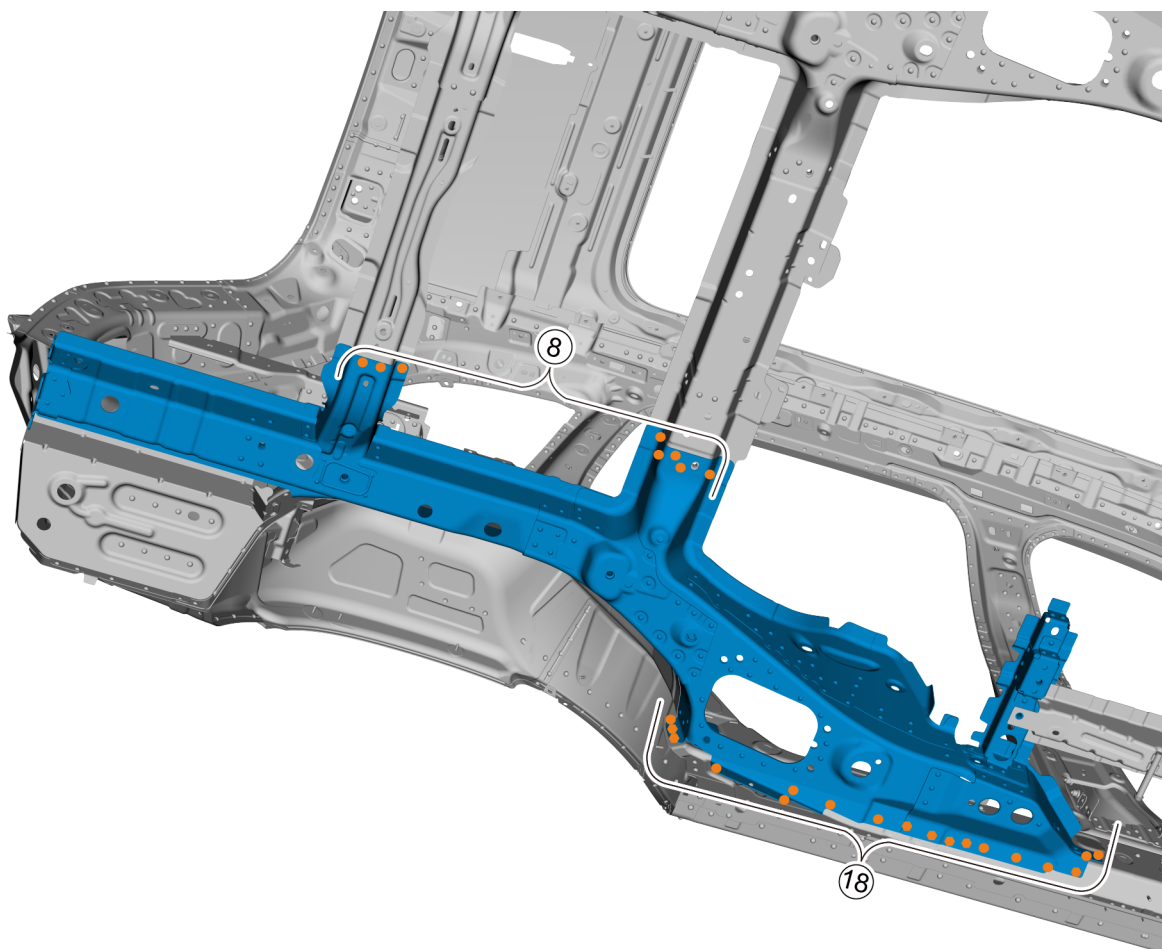
## 4.2.56 Installation of the Rear Floor Left Longitudinal Beam Assembly

### 4.2.56.1 Installation of the Rear Floor Left Longitudinal Beam Assembly

1. When installing a new part, match the mounting position of the new part on the body.
2. Temporarily install the new part for initial positioning.
3. Check and measure the positional dimensions of the rear floor left longitudinal beam assembly and the body for compliance with the standard, and adjust if necessary.
4. Weld the fixing points of the rear floor left longitudinal beam assembly to the left C-pillar assembly.



5. Weld the fixing points of the rear floor left longitudinal beam assembly to the reinforcement beam assembly under the spare tire pool and the center floor lower beam assembly (rear) and the left door sill inner plate assembly and the left C-pillar assembly.



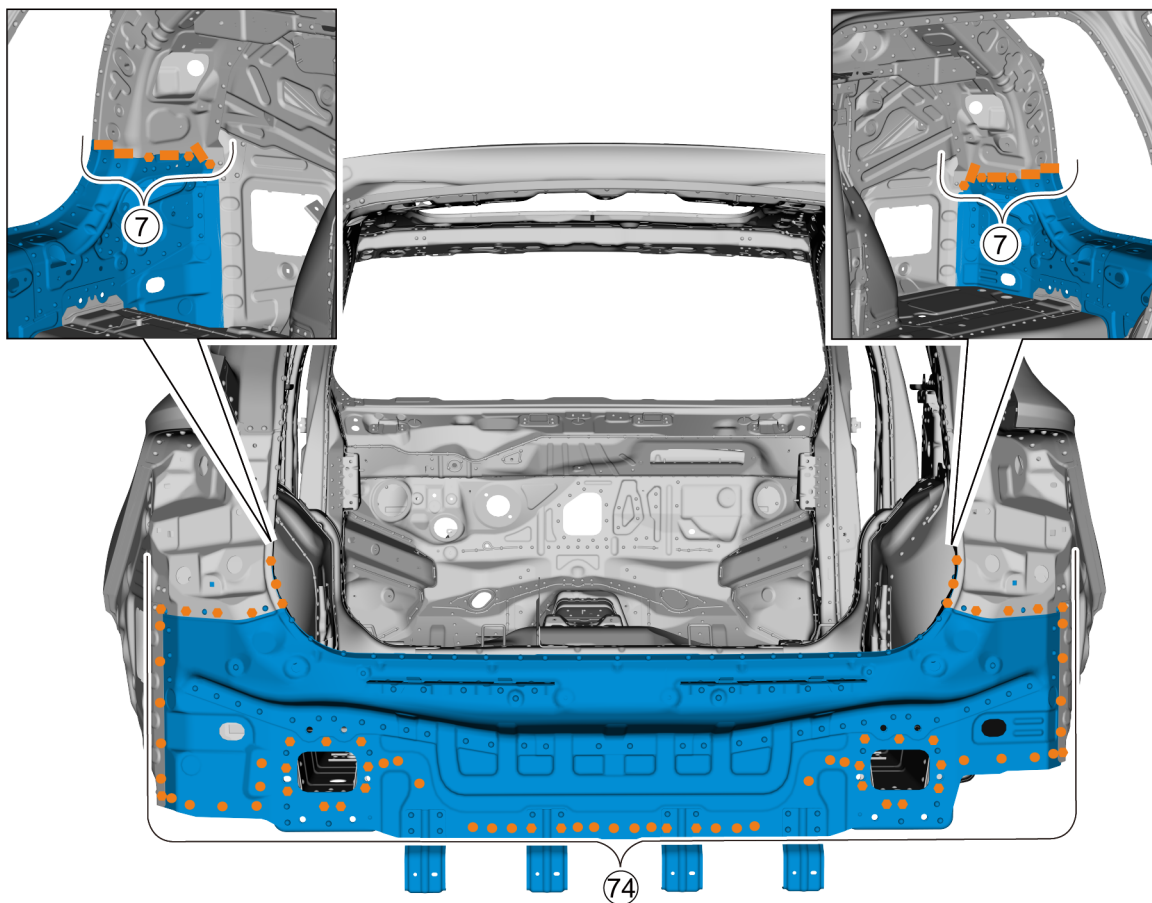
6. Install the center floor body.
7. Install the center floor lower beam assembly (front).
8. Install the center floor front connecting plate assembly.
9. Install the front floor assembly.
10. Install the rear floor body assembly.
11. Install the rear floor upper beam assembly.
12. Install the rear panel assembly.

## 4.2.57 Removal of the Rear Panel Assembly

### 4.2.57.1 Removal of the Rear Panel Assembly

#### Removal of Parts

1. At the welding positions shown in the figure below, drill out or grind away the welding points and remove the fixing points of the rear panel assembly to the left and right sidewall rear water assemblies and the left and right sidewall outer plates and rear floor body assembly, and the rear floor left and right longitudinal beam assemblies.



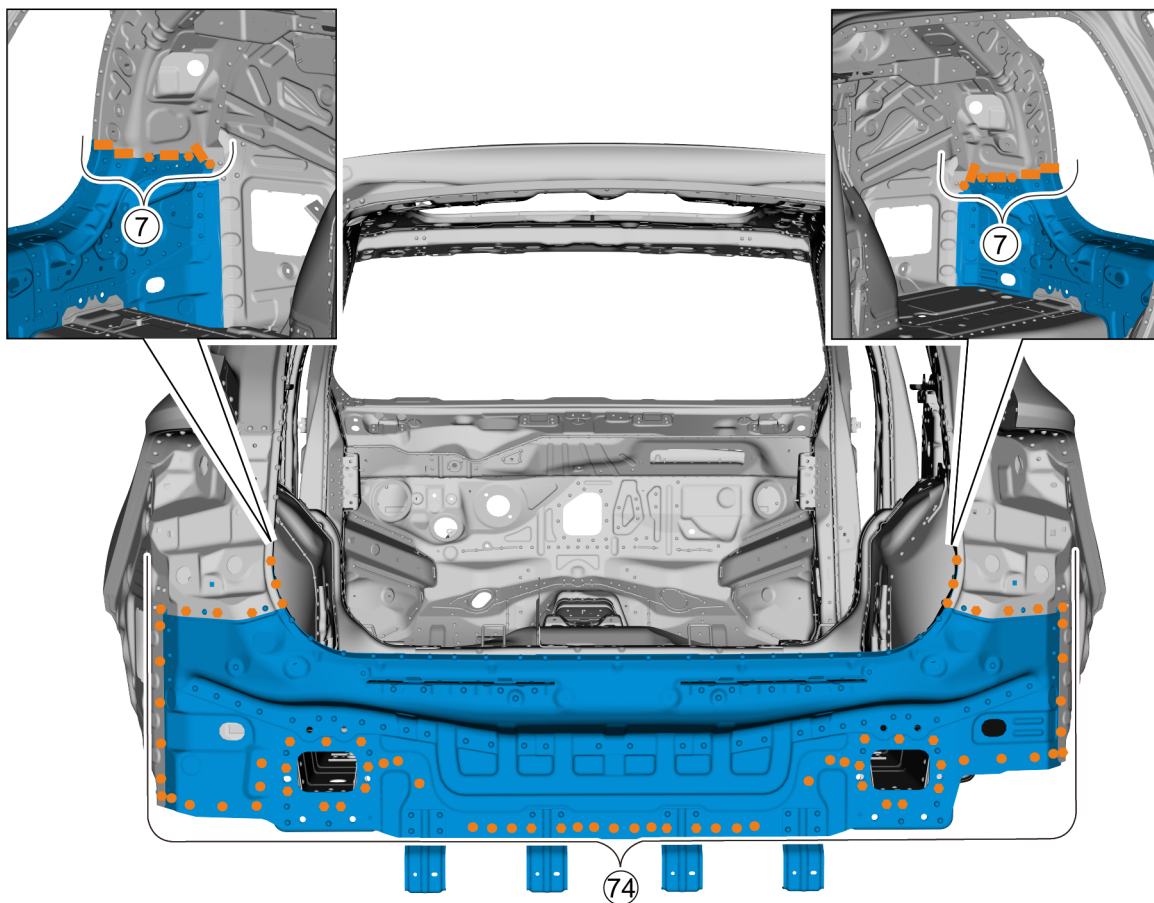
2. Grind away any welding marks that may remain on the body surface and sand the welded surfaces to bare metal (remove surface foreign matter, paint and rust).



## 4.2.58 Installation of the Rear Panel Assembly

### 4.2.58.1 Installation of the Rear Panel Assembly

1. When installing a new part, match the mounting position of the new part on the body.
2. Temporarily install the new part for initial positioning.
3. Check and measure the positional dimensions of the rear panel assembly and the body for compliance with the standard, and adjust if necessary.
4. Weld the fixing points of the rear panel assembly with the left and right sidewall rear water channel assemblies and the left and right sidewall outer plates and rear floor body assemblies, and the rear floor left and right longitudinal beam assemblies.

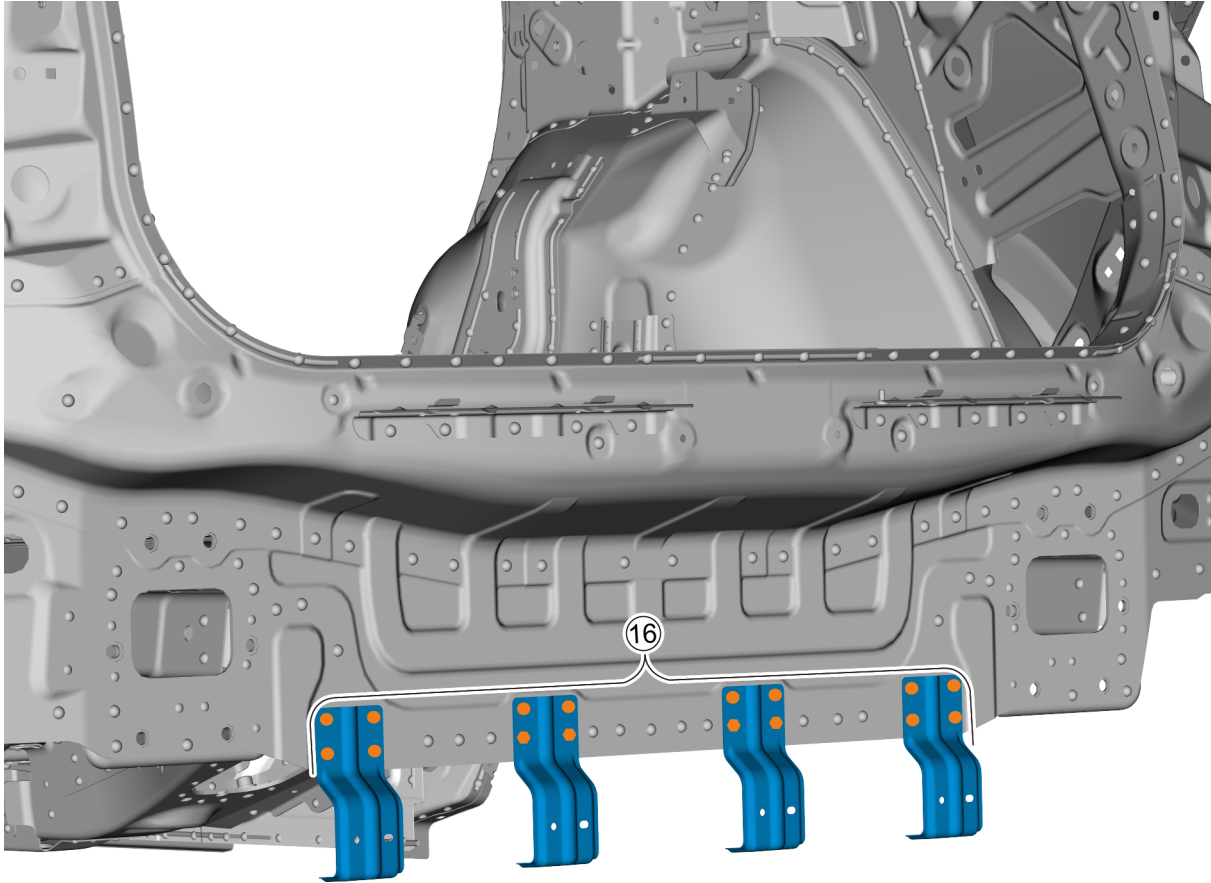


## 4.2.59 Removal of the Rear Bumper Bracket

### 4.2.59.1 Removal of the Rear Bumper Bracket

#### Removal of Parts

1. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the rear bumper bracket to the rear panel assembly.

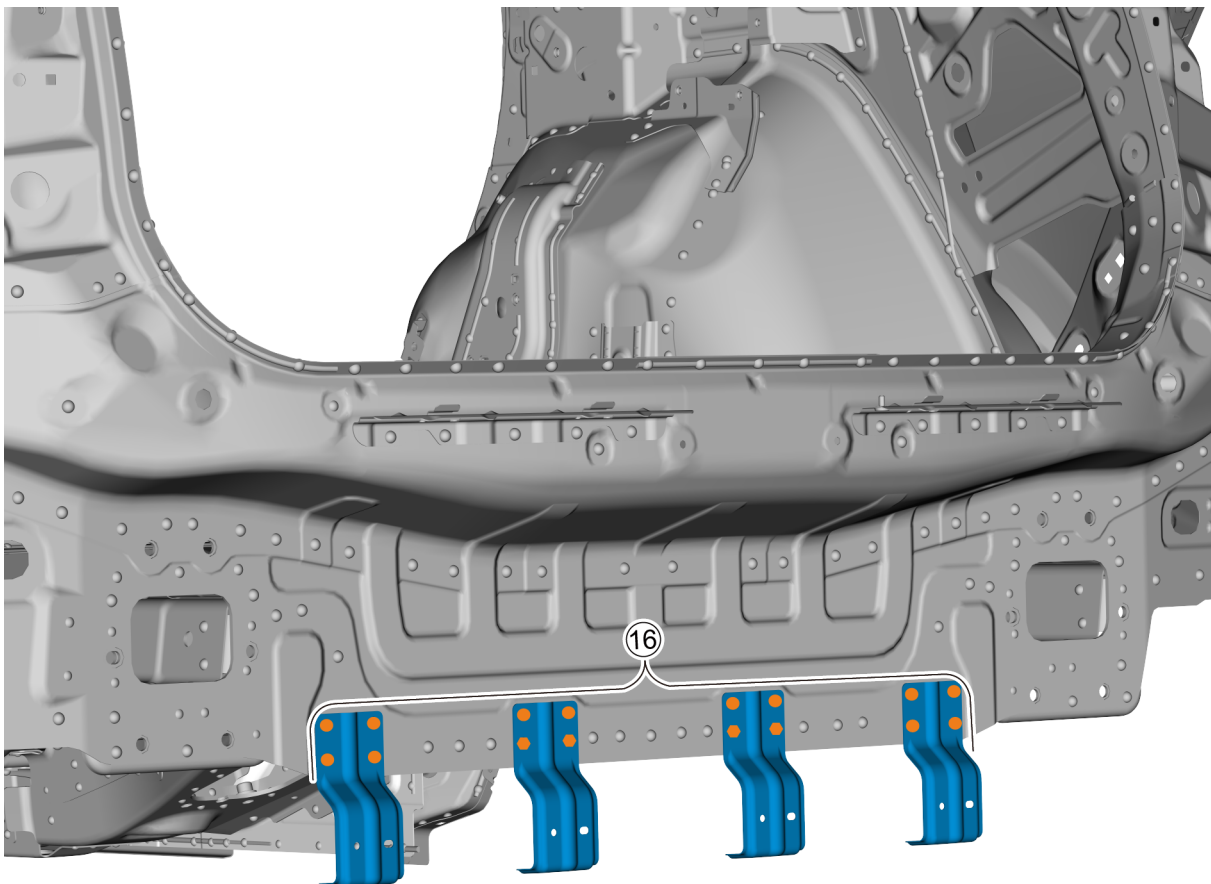


2. Grind away any welding marks that may remain on the body surface and sand the welded surfaces to bare metal (remove surface foreign matter, paint and rust).

## 4.2.60 Installation of the Rear Bumper Bracket

### 4.2.60.1 Installation of the Rear Bumper Bracket

1. When installing a new part, match the mounting position of the new part on the body.
2. Temporarily install the new part for initial positioning.
3. Check and measure the positional dimensions of the rear bumper bracket and the body for compliance with the standard, and adjust if necessary.
4. Weld the fixing points of the rear bumper bracket to the rear panel assembly.



## 4.2.61 Removal of the Left Sidewall Rear Water Assembly

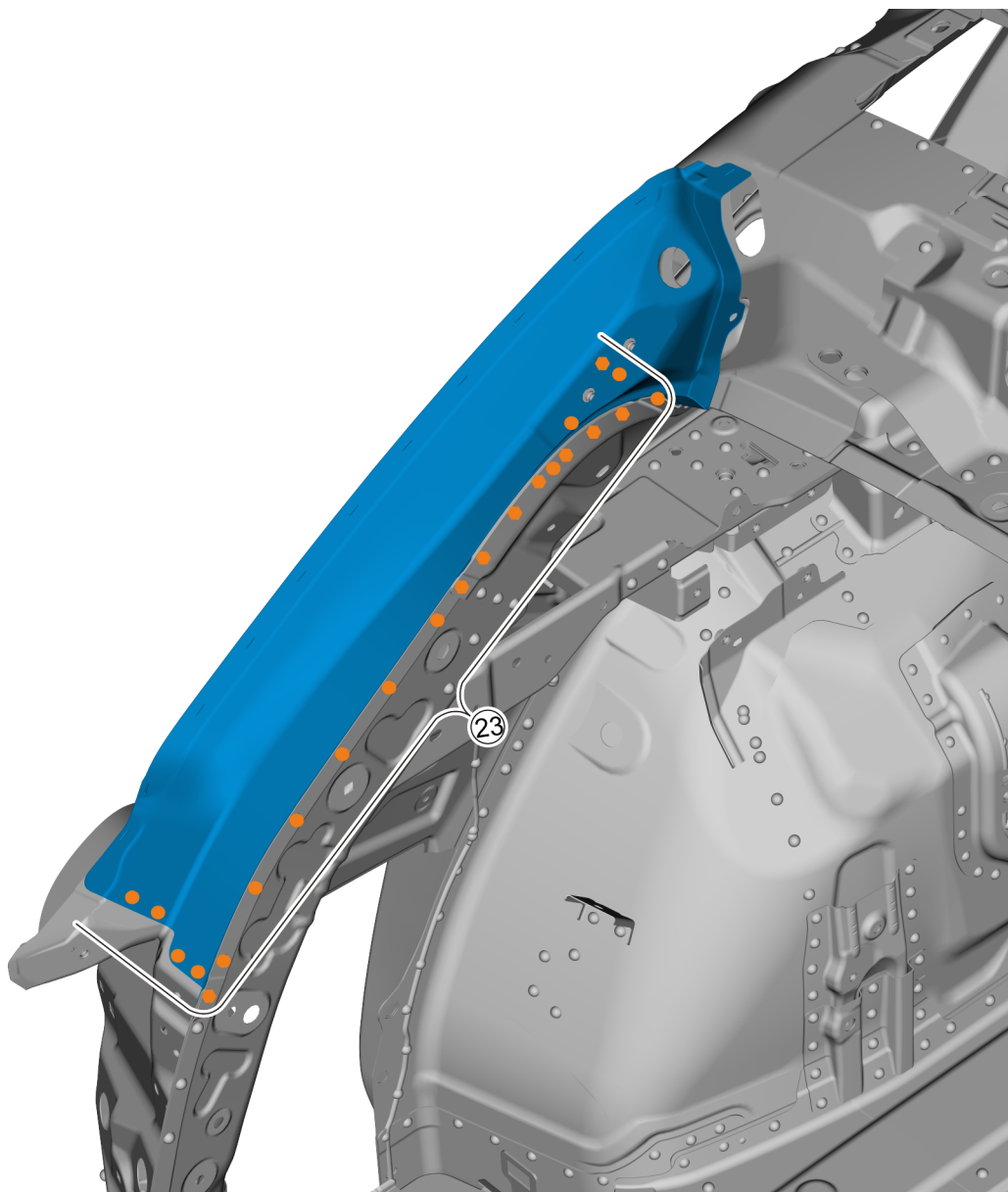
### 4.2.61.1 Removal of the Left Sidewall Rear Water Assembly

Removal of Parts

#### Caution

Remove the left and right sides in the same way.

1. Remove the large sunroof top cover assembly, refer to [Removal of the Large Sunroof Top Cover Assembly](#).
2. Remove the left sidewall outer plate, refer to [Removal of the Left Sidewall Outer Plate](#).
3. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the left sidewall rear water channel assembly to the left C-pillar assembly.

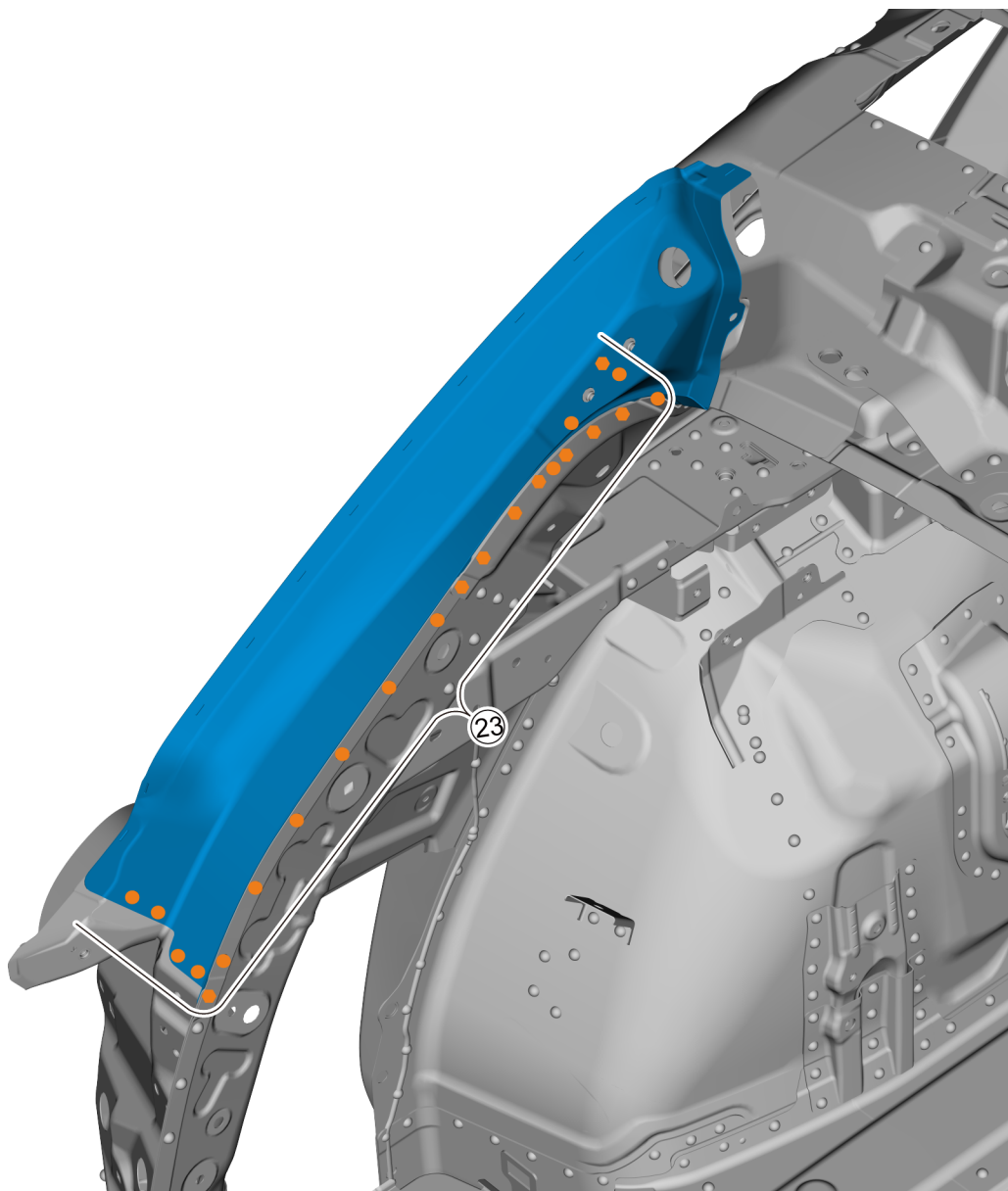


4. Grind away any welding marks that may remain on the body surface and sand the welded surfaces to bare metal (remove surface foreign matter, paint and rust).

## 4.2.62 Installation of the Left Sidewall Rear Water Channel Assembly

### 4.2.62.1 Installation of the Left Sidewall Rear Water Channel Assembly

1. When installing a new part, match the mounting position of the new part on the body.
2. Temporarily install the new part for initial positioning.
3. Check and measure the positional dimensions of the left sidewall rear water channel assembly and the body for compliance with the standard, and adjust if necessary.
4. Weld the fixing points of the left sidewall rear water assembly to the left C-pillar assembly.



5. Install the left sidewall rear water channel assembly.
6. Install the left sidewall outer plate.
7. Install the large sunroof top cover assembly.

## 4.2.63 Removal of the Left Tail Light Mounting Plate Assembly

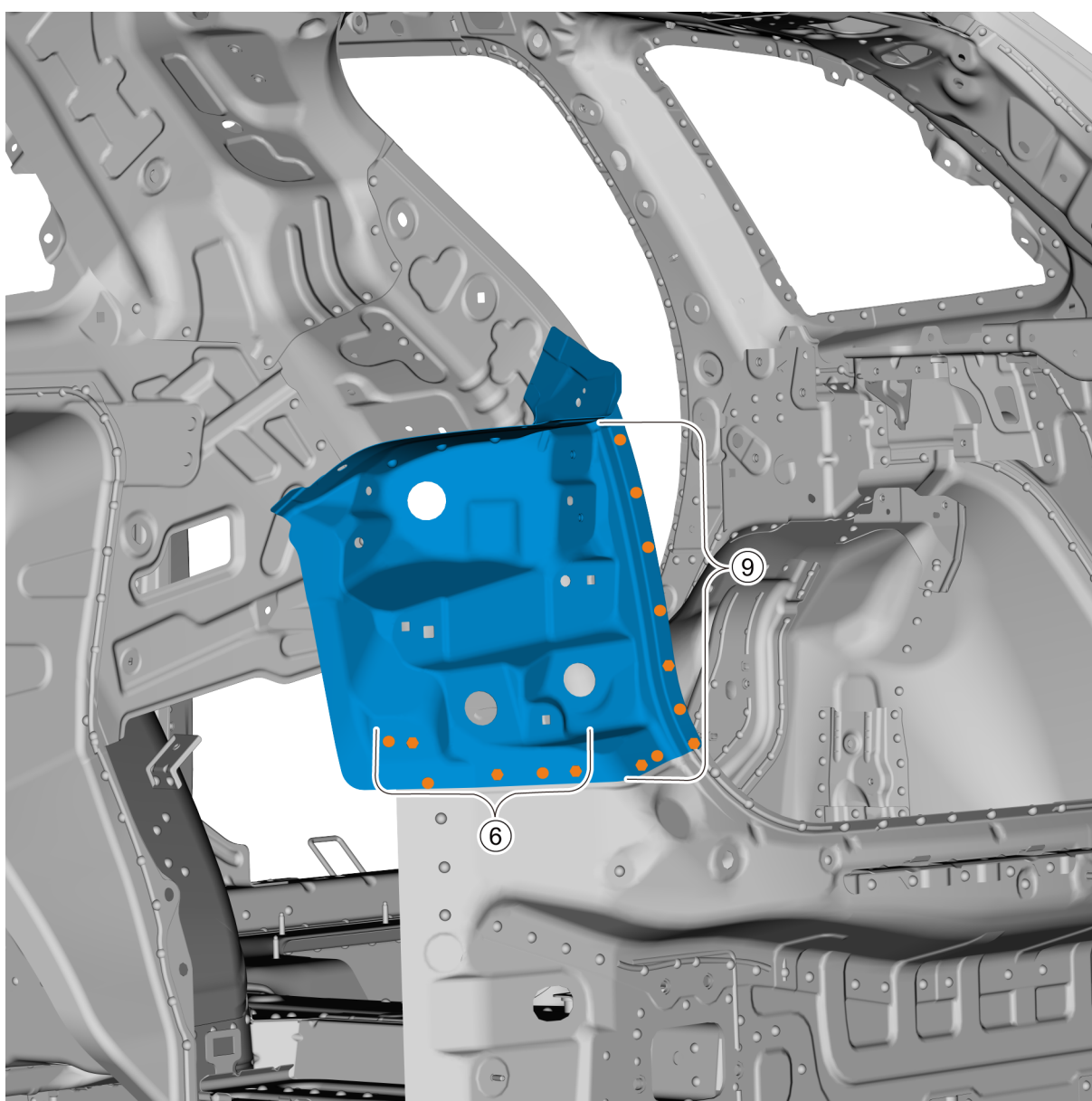
### 4.2.63.1 Removal of the Left Tail Light Mounting Plate Assembly

Removal of Parts

#### Caution

Remove the left and right sides in the same way.

1. Remove the large sunroof top cover assembly, refer to [Removal of the Large Sunroof Top Cover Assembly](#).
2. Remove the left sidewall outer plate, refer to [Removal of the Left Sidewall Outer Plate](#).
3. Remove the left sidewall rear water channel assembly, refer to [Removal of the Left Side Rear Water Channel Assembly](#).
4. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the left tail light mounting plate assembly to the left C-pillar assembly and the rear panel assembly.



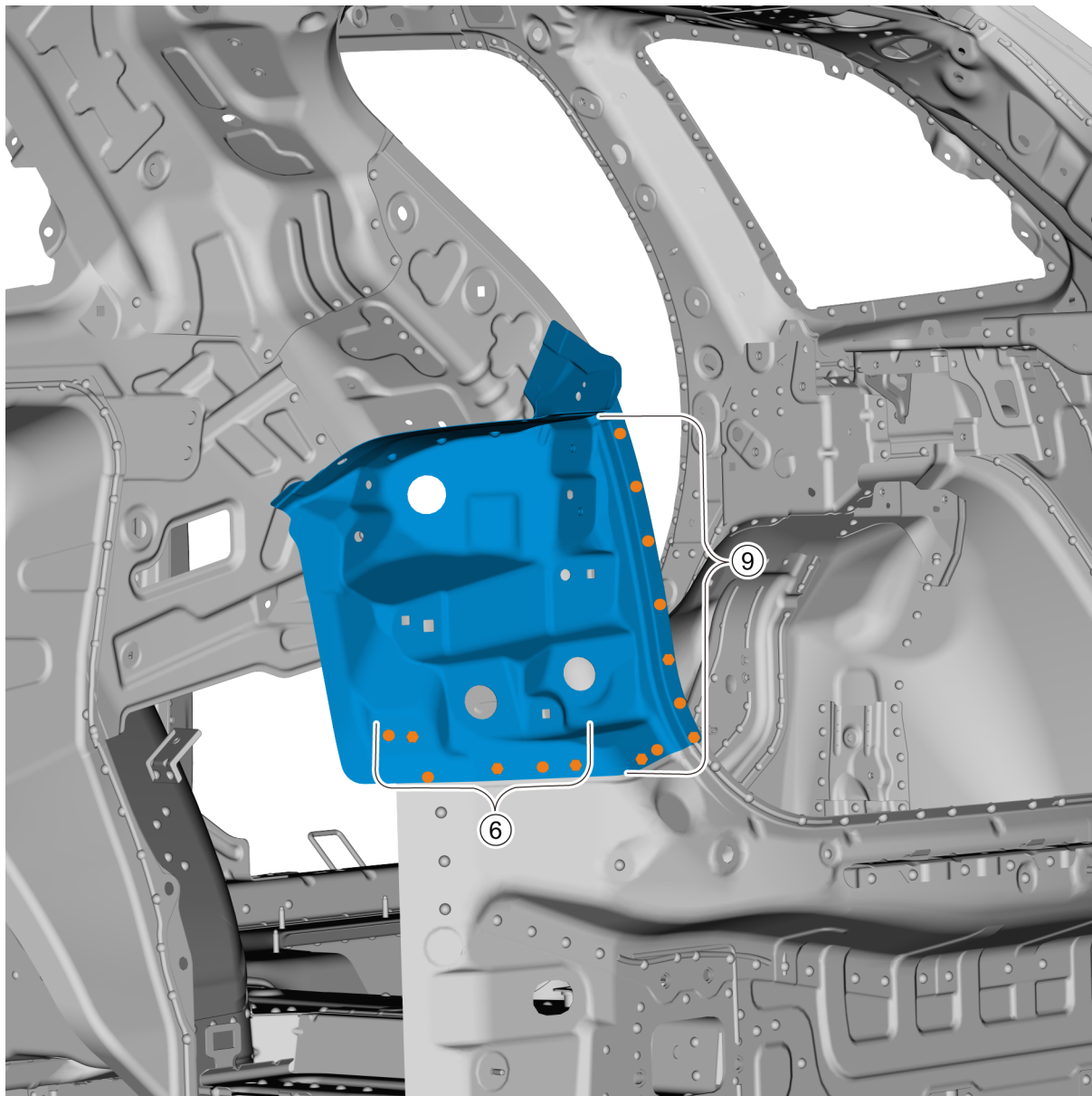
5. Grind away any welding marks that may remain on the body surface and sand the welded surfaces to bare metal (remove surface foreign matter, paint and rust).



## 4.2.64 Installation of Left Tail Light Mounting Plate Assembly

### 4.2.64.1 Installation of Left Tail Light Mounting Plate Assembly

1. When installing new parts, measure and adjust the body as necessary to conform to standard dimensions.
2. After temporarily installing new parts, make sure that the related parts are properly seated.
3. Check and measure the positional dimensions of the left tail light mounting plate assembly and the body for compliance with the standard, and adjust if necessary.
4. Install the fixing points of the left tail light mounting plate assembly to the left C-pillar assembly and the rear panel assembly.



5. Install the left sidewall rear water channel assembly.
6. Install the left sidewall outer plate.
7. Install the large sunroof top cover assembly.

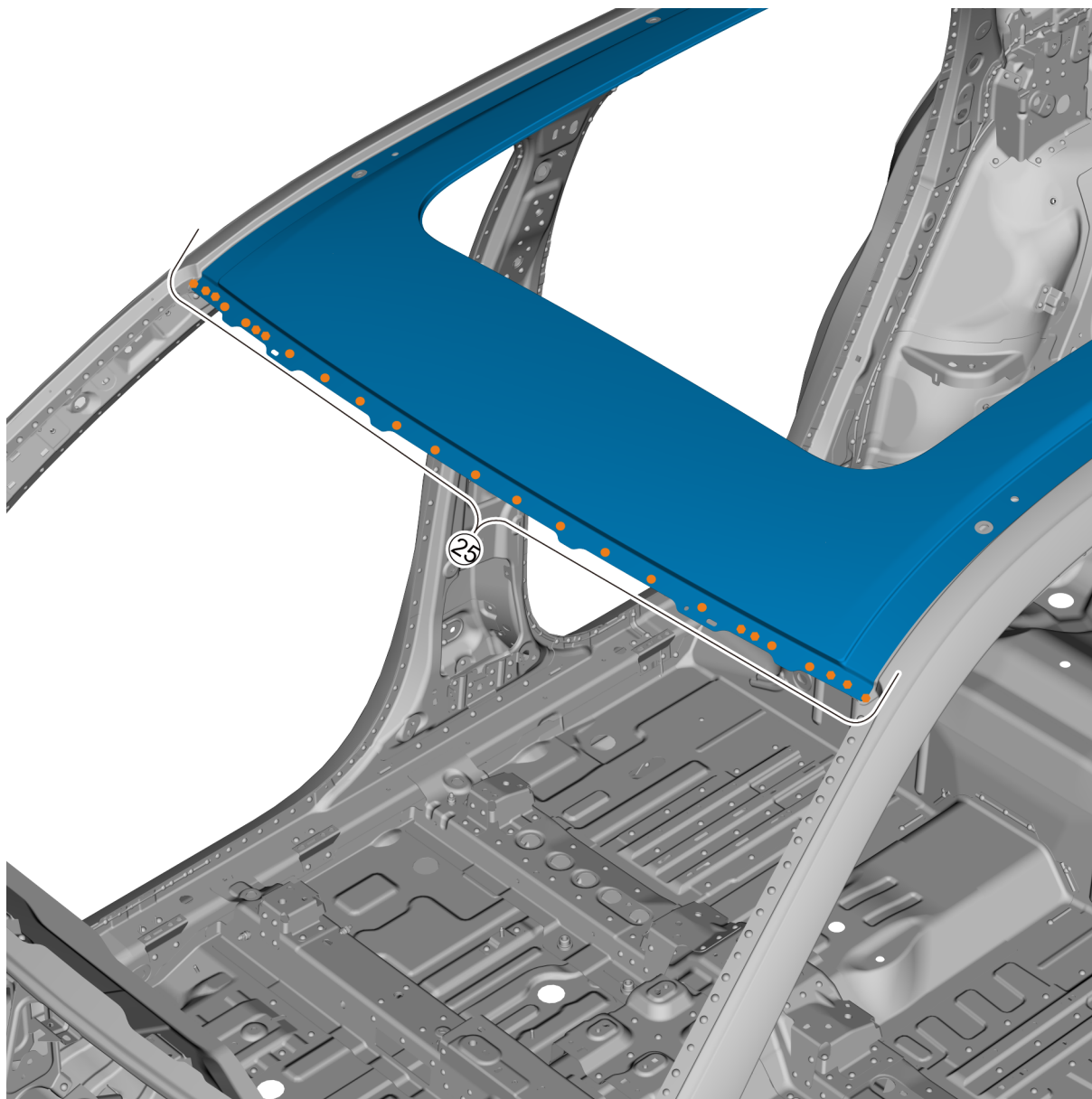


## 4.2.65 Removal of the Large Sunroof Roof Cover Assembly

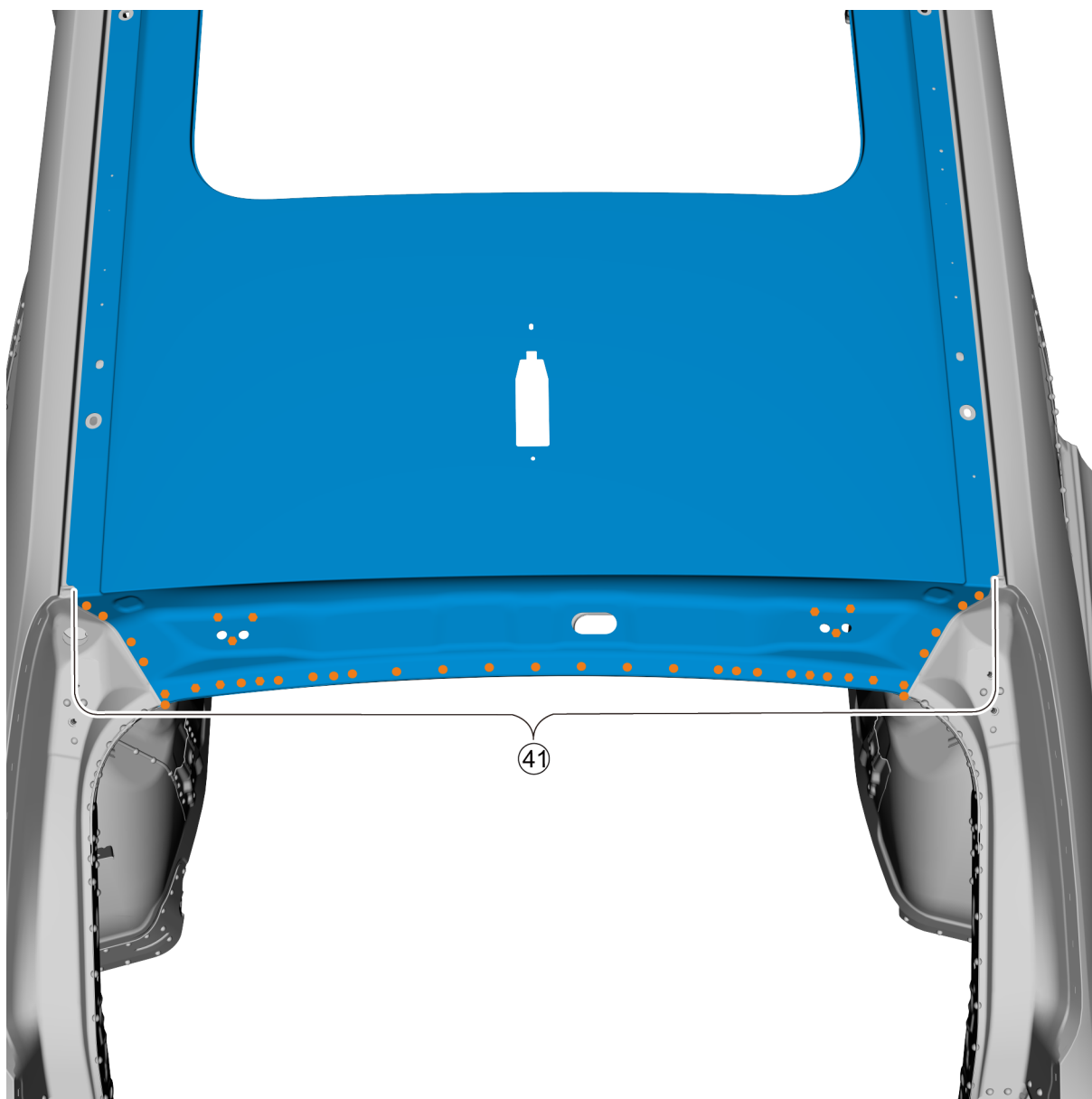
### 4.2.65.1 Removal of the Large Sunroof Roof Cover Assembly

#### Removal of Parts

1. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the large sunroof top cover assembly to the roof cover front beam assembly and the left and right sidewall outer plates.



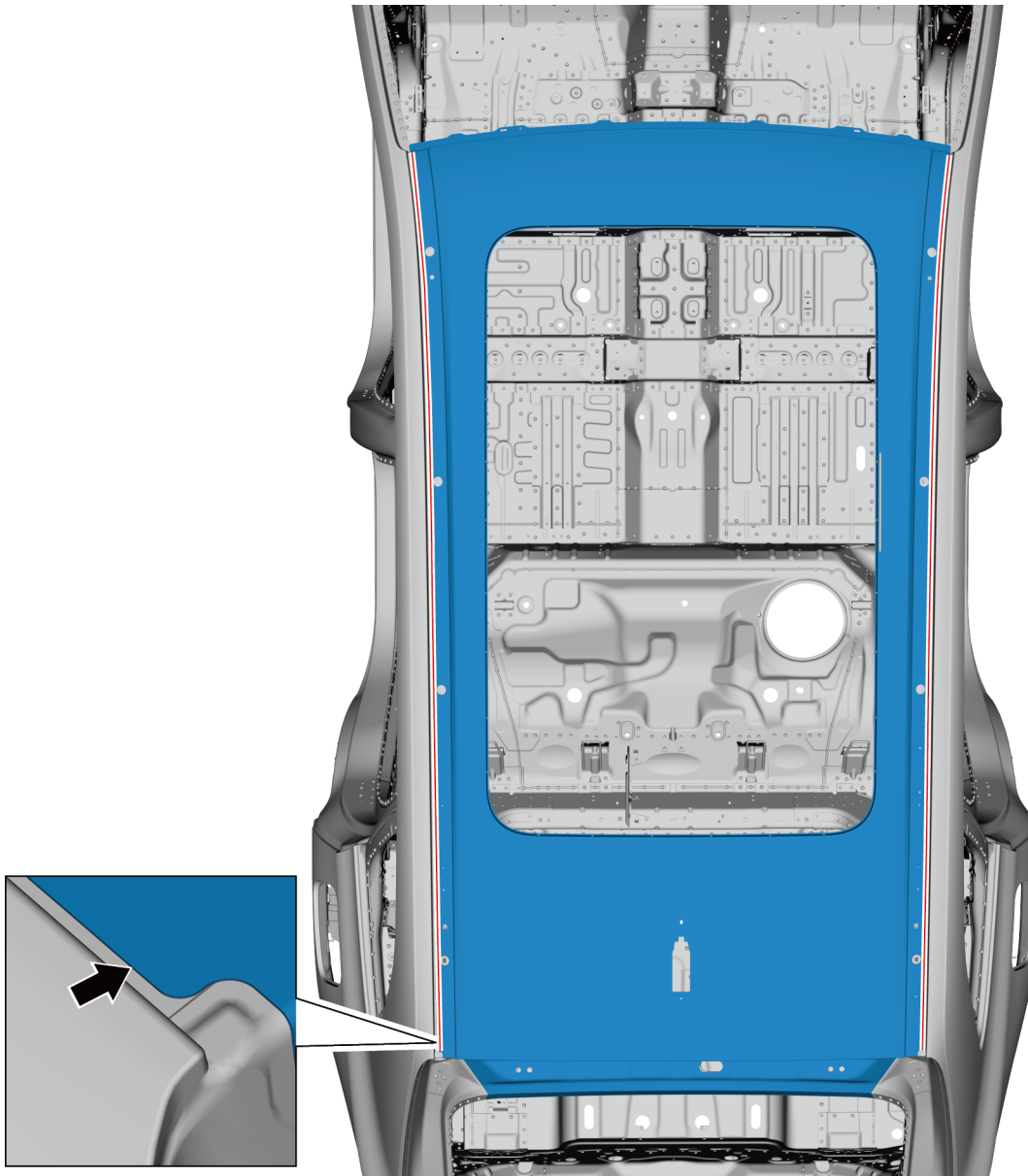
2. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the large sunroof roof cover assembly with the roof cover rear beam assembly and the left and right sidewall rear water channel assemblies.



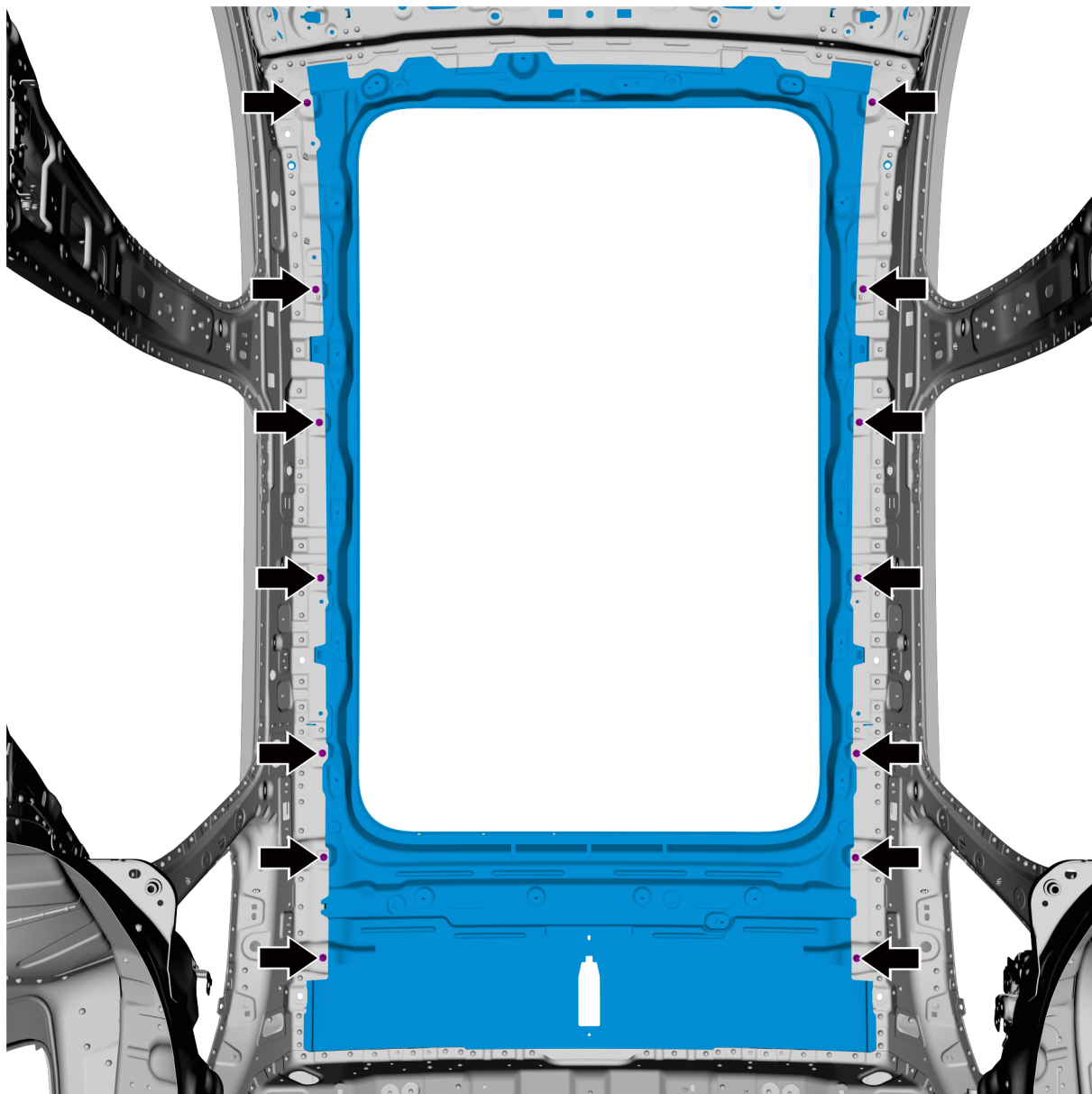
3. At the welding positions shown in the figure below, grind away the laser welds and remove the welding position of the large sunroof roof cover assembly to the left and right sidewall outer plates.

**Caution**

Do not allow damage to the lower sidewall components.



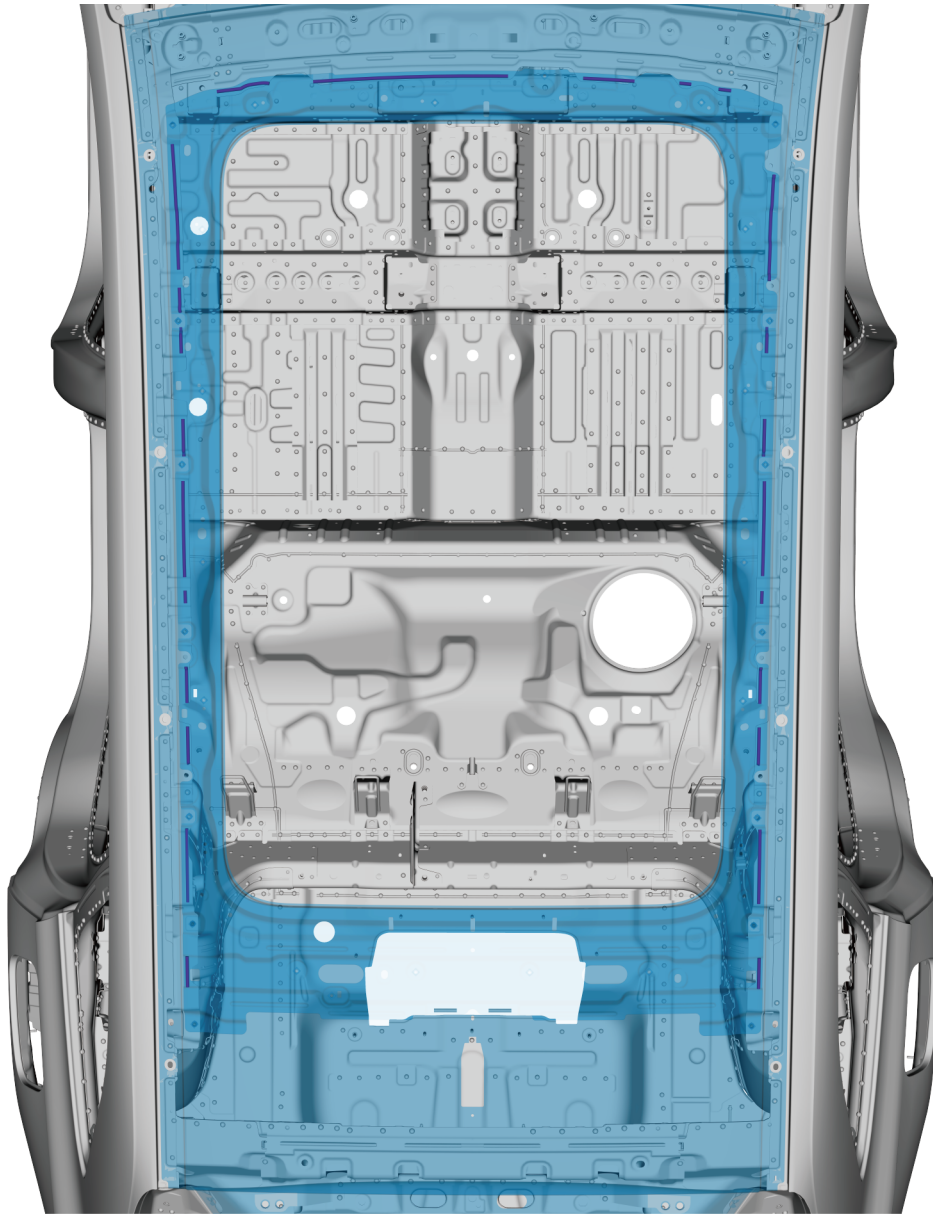
4. Remove the fixing bolts on both sides of the large sunroof roof cover assembly.



5. Heat the structural adhesive to a temperature not exceeding 120° and remove the large sunroof roof assembly.

**Caution**

Excessive heating temperature may cause deformation damage to other parts.



6. Grind away any welding marks that may remain on the body surface, and sand the welded surfaces to bare metal (remove surface foreign matter, paint and rust).

## 4.2.66 Installation of the Large Sunroof Roof Cover Assembly

### 4.2.66.1 Installation of the Large Sunroof Roof Cover Assembly

1. When installing a new part, match the mounting position of the new part on the body.
2. Temporarily install the new part for initial positioning.
3. Check and measure the positional dimensions of the large sunroof roof assembly and the body for compliance with the standard, and adjust if necessary.
4. Apply anti-vibration adhesive to the roof front beam assembly and roof rear beam assembly.

#### Caution

- Gluing type: room temperature curing adhesive
- Glueing position: as shown in the figure
- Glueing specifications: length is 824mm, pressing width is 10mm
- Glueing requirement: glue to the glue groove



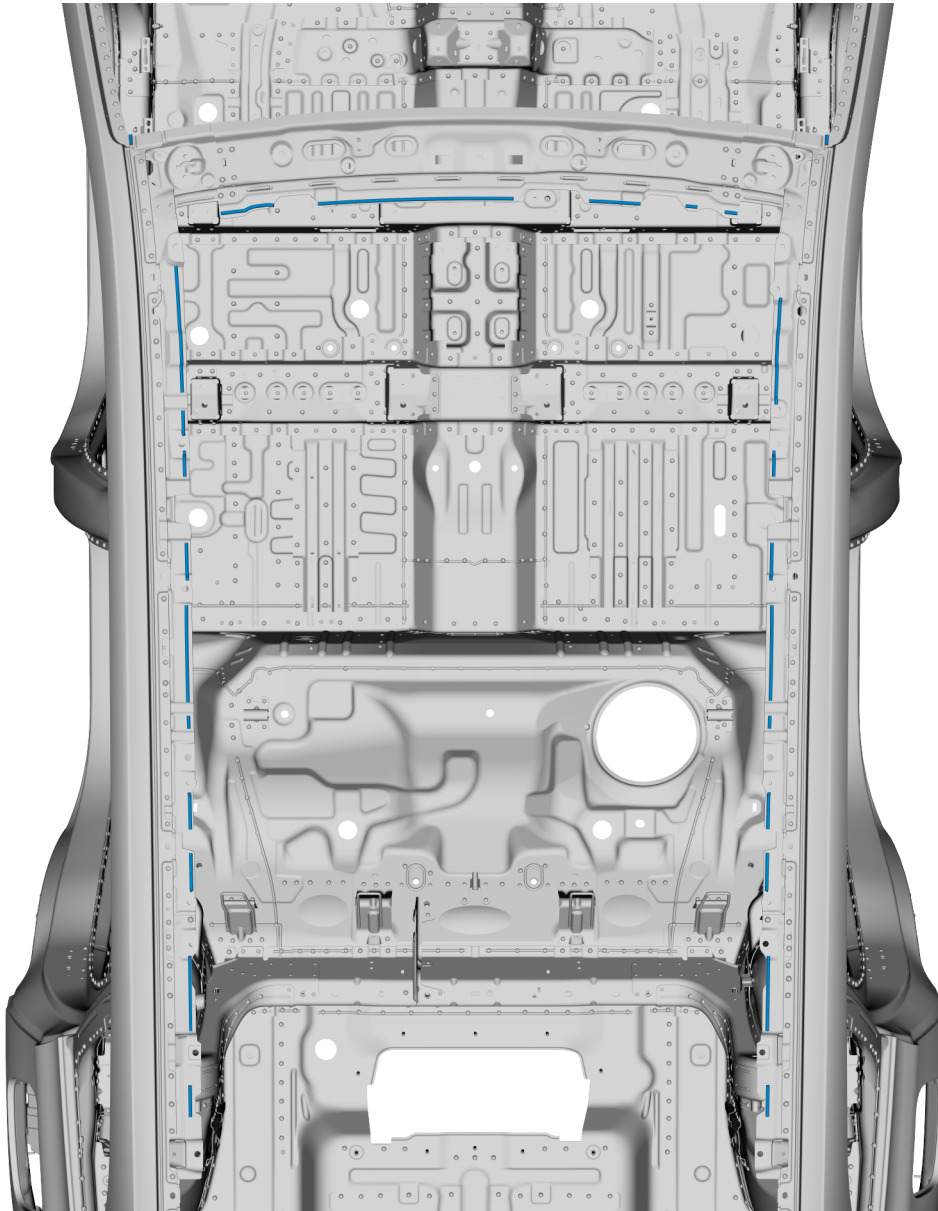




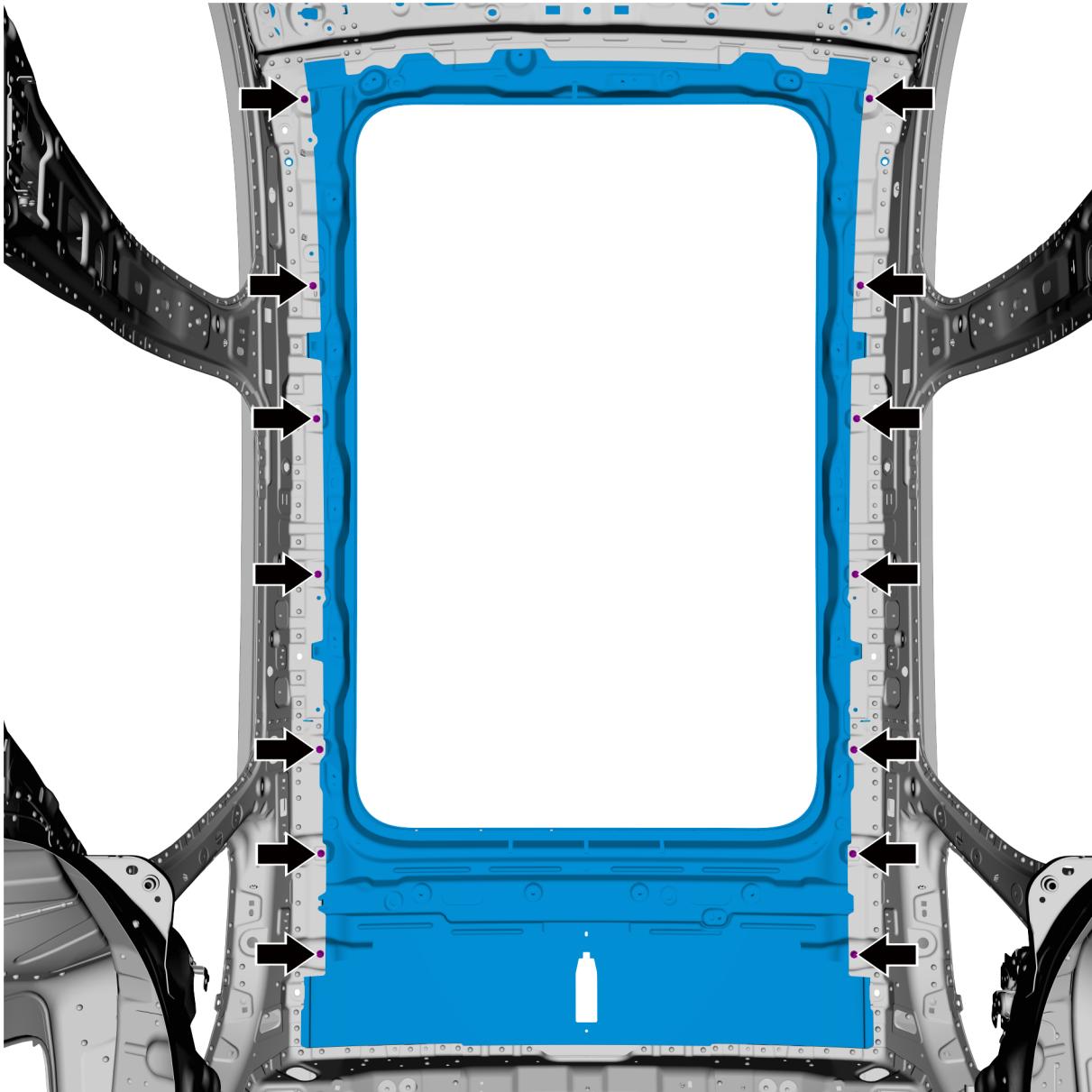
5. Apply structural sealant on the sidewall assembly and the roof front beam.

**Caution**

- Gluing type: room temperature curing adhesive
- Glueing position: as shown in the figure
- Glueing specifications: length is 2610mm, pressing width is 10mm
- Glueing requirements: continuous, complete and without leakage



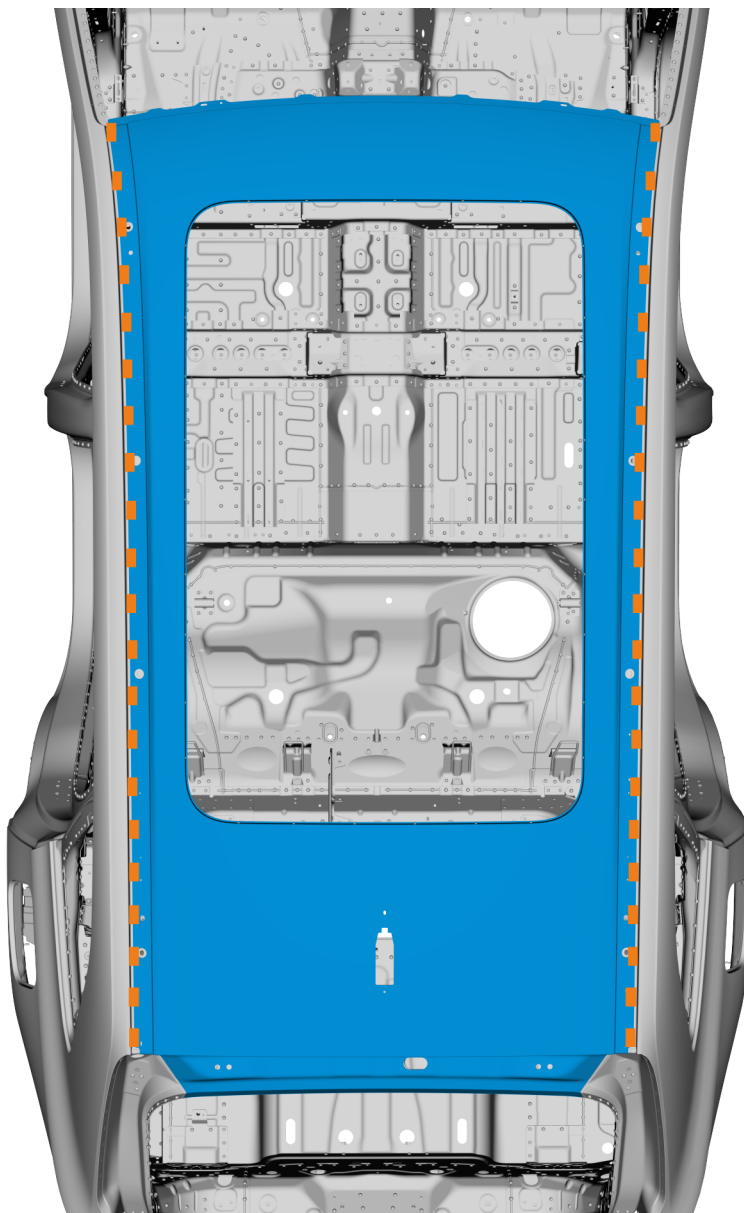
6. Install the fixing bolts on both sides of the large sunroof roof cover assembly.



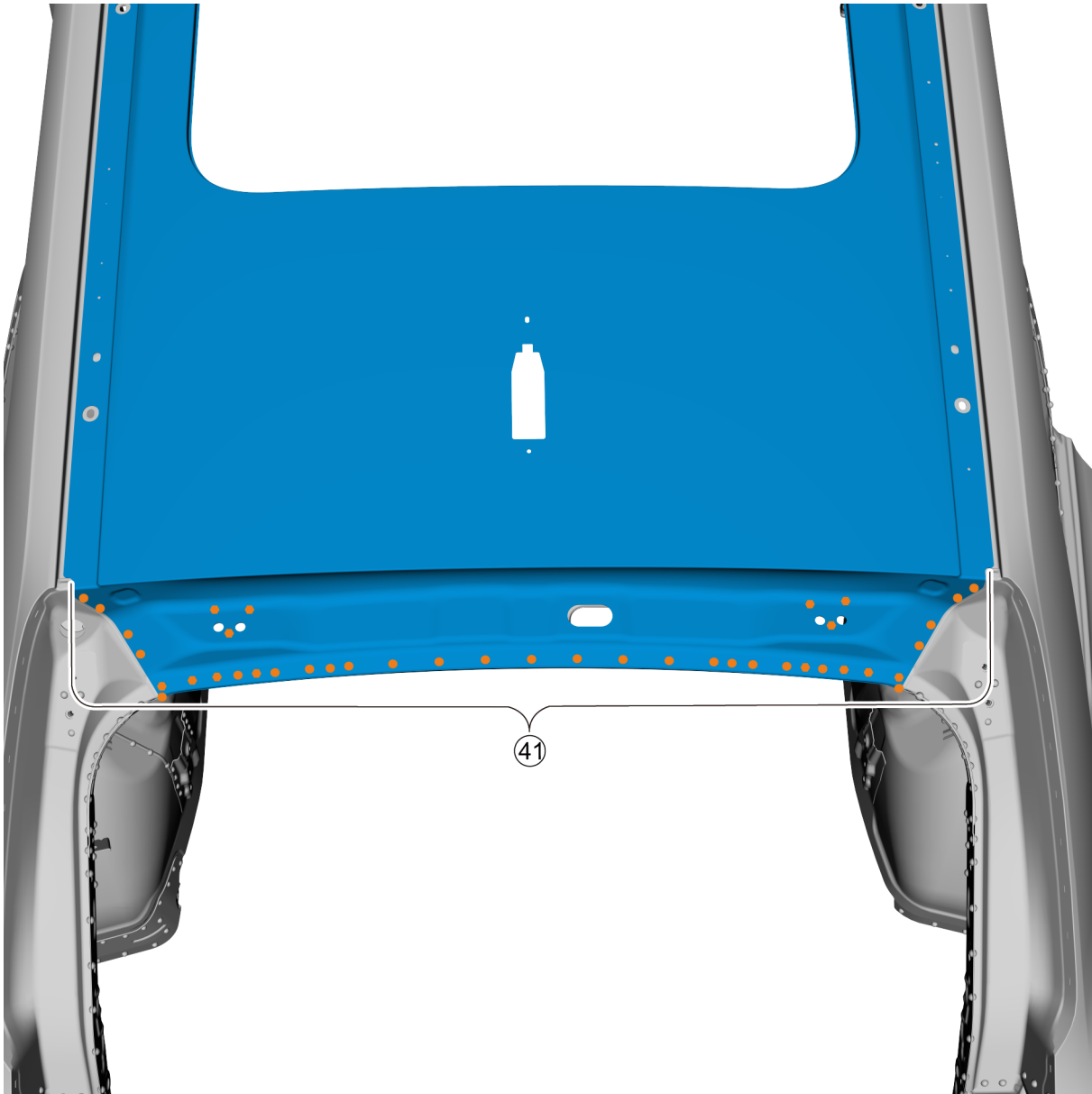
7. Weld the large sunroof roof assembly to the left and right side plates.

**Caution**

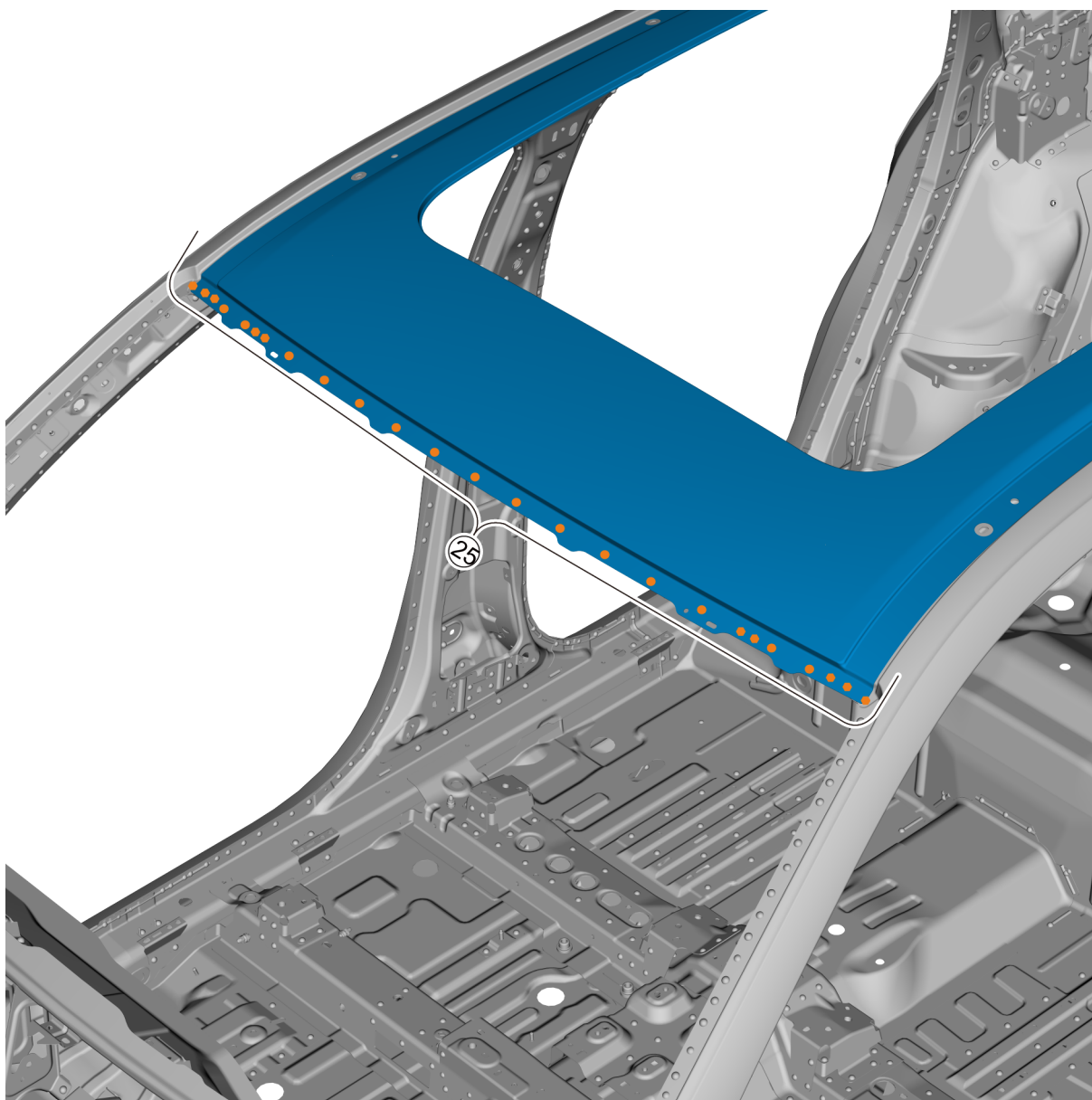
Use carbon dioxide shielded welding instead of laser welding, carbon dioxide shielded welding seam spacing is  $50\pm 5\text{mm}$ , when welding, carbon dioxide shielded welding single seam length should be less than 20mm.



8. Weld the fixing points of the large sunroof roof cover assembly with the left and right sidewall water channel assemblies and the roof rear beam assembly.



9. Weld the fixing points of the large sunroof roof cover assembly to the left and right sidewall plates and the roof front beam assembly.



10. Apply welding sealant on both sides of the large sunroof roof cover assembly.

**Caution**

- Glueing positions: as shown in the figure, symmetrical left and right
- Glueing specifications: width is 10mm, height is 2mm
- Glueing requirements: continuous, complete and without leakage



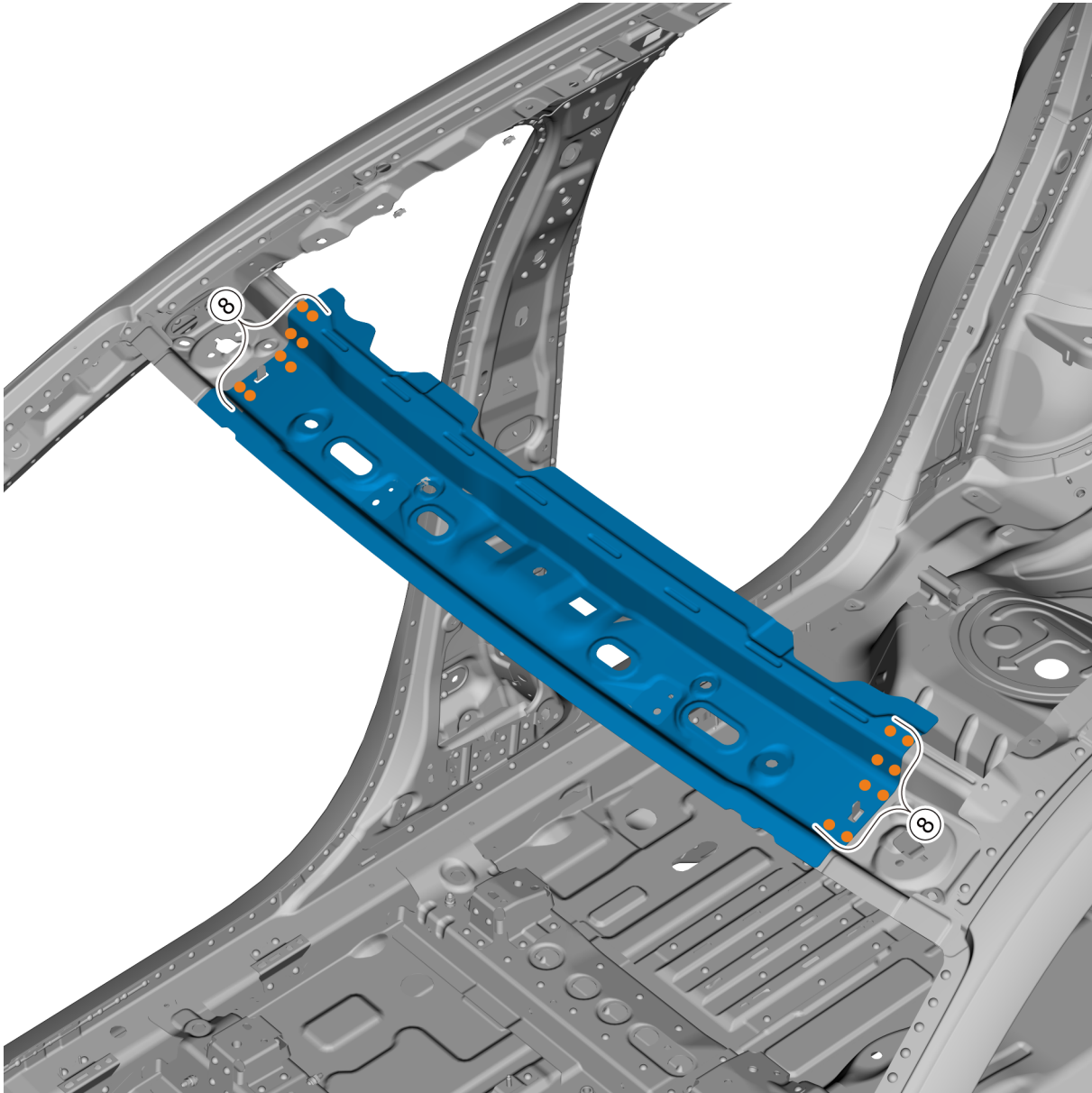


## 4.2.67 Removal of the Roof Cover Front Beam Assembly

### 4.2.67.1 Removal of the Roof Cover Front Beam Assembly

#### Removal of Parts

1. Remove the large sunroof top cover assembly, refer to [Removal of the Large Sunroof Top Cover Assembly](#).
2. At the welding positions shown in the figure below, drill out the welding points and remove the fixing points of the roof front beam assembly and the left and right sidewall front inner plate assemblies.



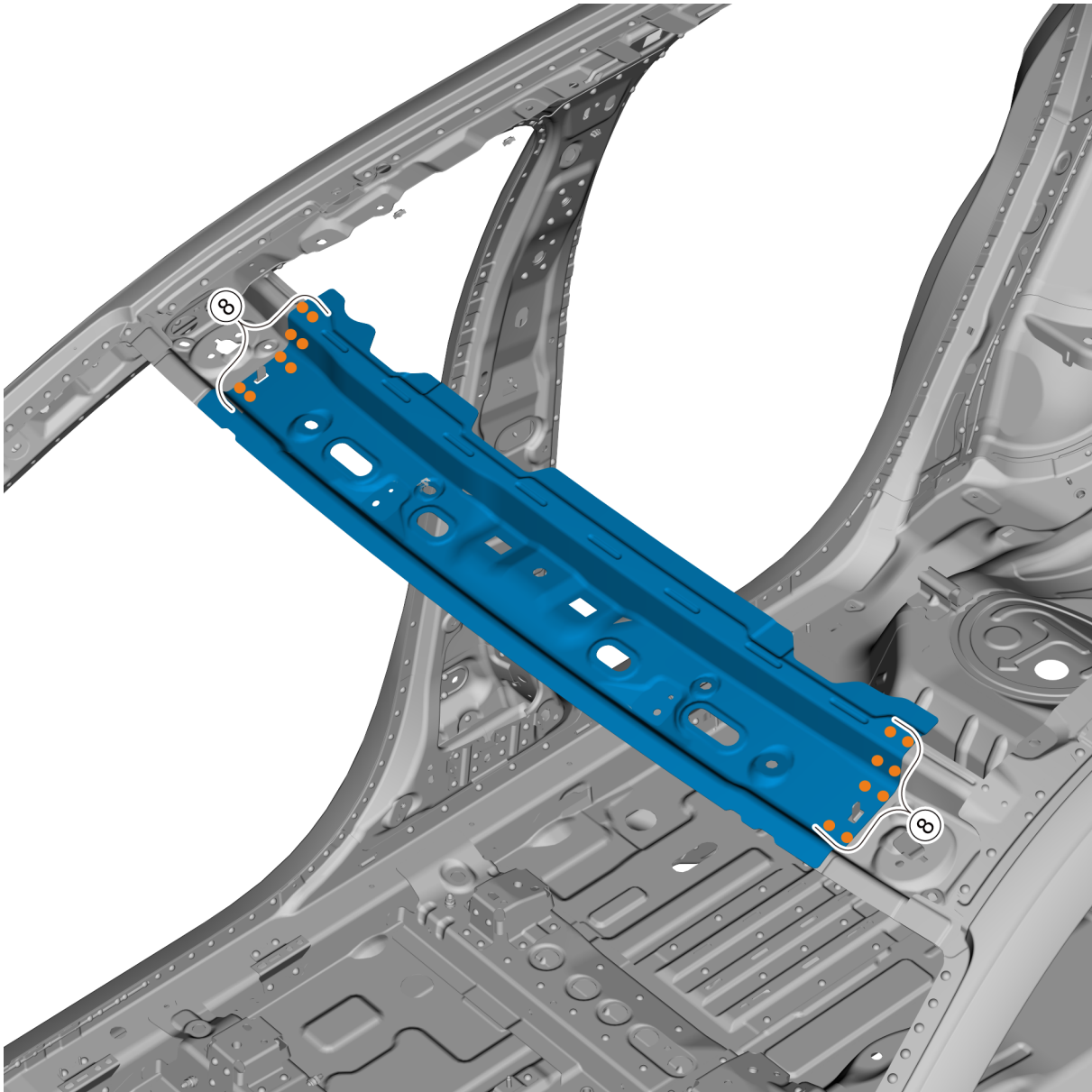
3. Grind away any welding marks that may remain on the body surface and sand the welded surfaces to bare metal (remove surface foreign matter, paint and rust).



## 4.2.68 Installation of the Roof Cover Front Beam Assembly

### 4.2.68.1 Installation of the Roof Cover Front Beam Assembly

1. When installing a new part, match the mounting position of the new part on the body.
2. Temporarily install the new part for initial positioning.
3. Check and measure the positional dimensions of the roof cover front beam assembly and the body for compliance with the standard, and adjust if necessary.
4. Weld the fixing points of the roof front beam assembly to the left and right sidewall front inner plate assemblies.



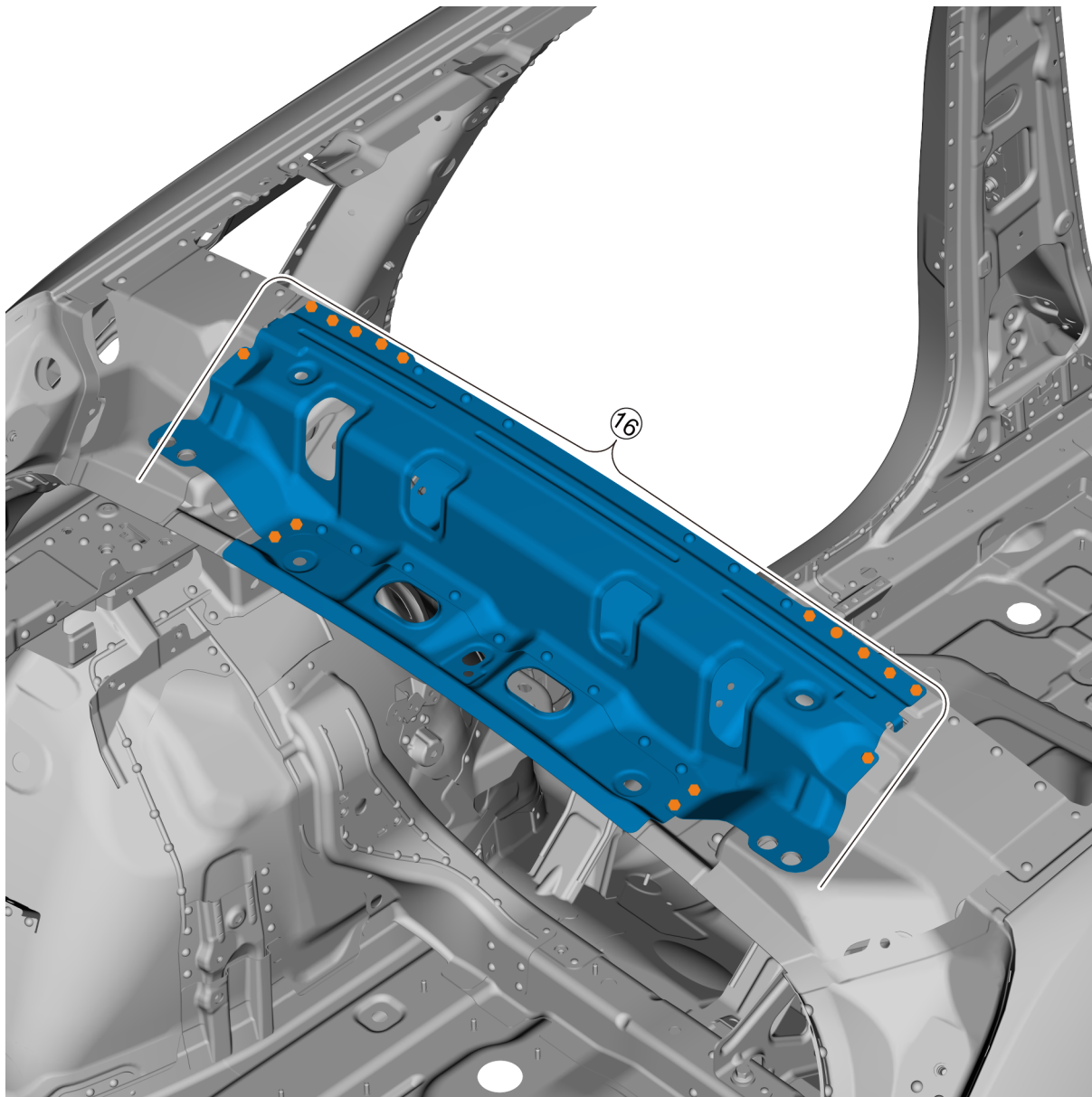
5. Install the large sunroof top cover assembly.

## 4.2.69 Removal of the Roof Cover Rear Beam Assembly

### 4.2.69.1 Removal of the Roof Cover Rear Beam Assembly

#### Removal of Parts

1. Remove the large sunroof top cover assembly, refer to [Removal of the Large Sunroof Top Cover Assembly](#).
2. At the welding positions shown in the figure below, drill out or grind away the welding points and remove the fixing points of the roof cover rear beam assembly to the left and right C-pillar assemblies.



3. At the welding positions shown in the figure below, drill out or grind away the welding points and remove the fixing points of the roof cover rear beam assembly to the left and right C-pillar assemblies.

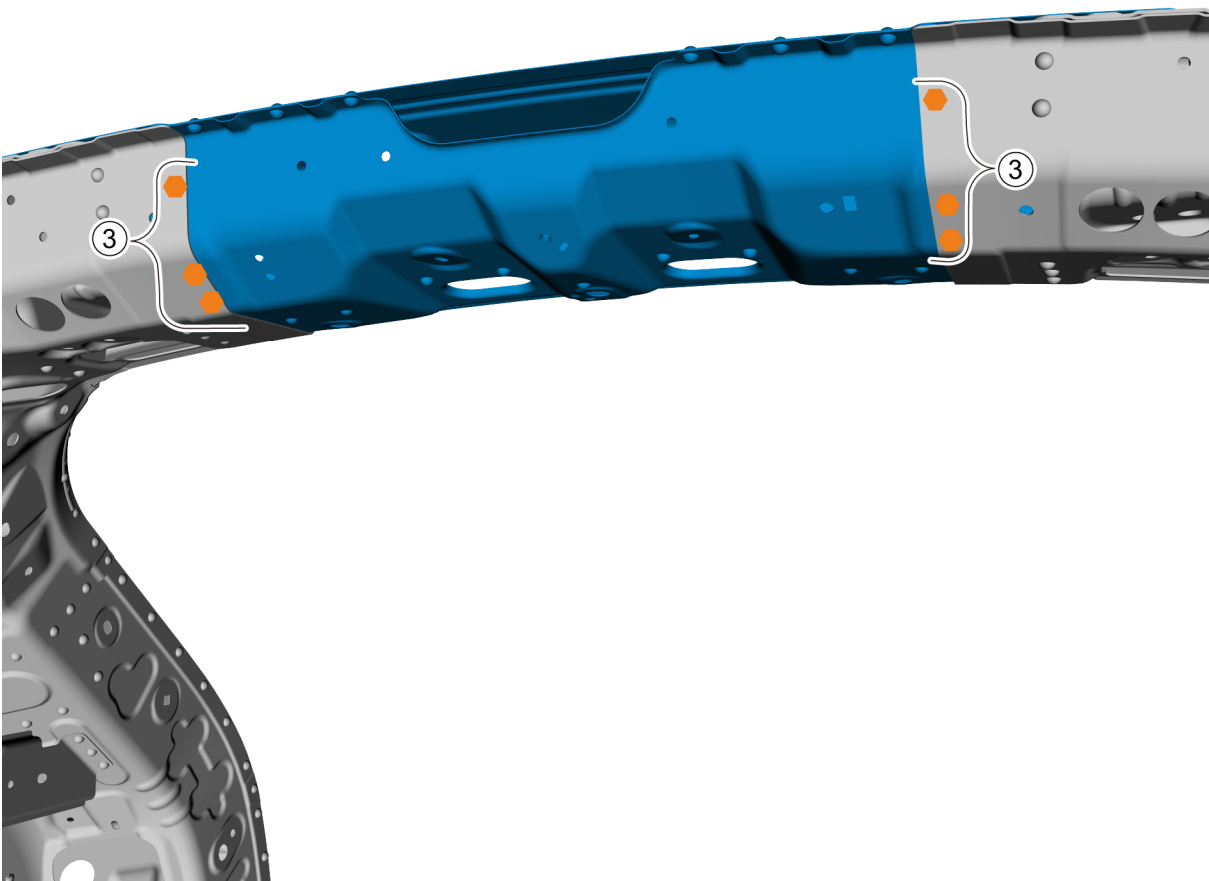


4. Grind away any welding marks that may remain on the body surface and sand the welded surfaces to bare metal (remove surface foreign matter, paint and rust).

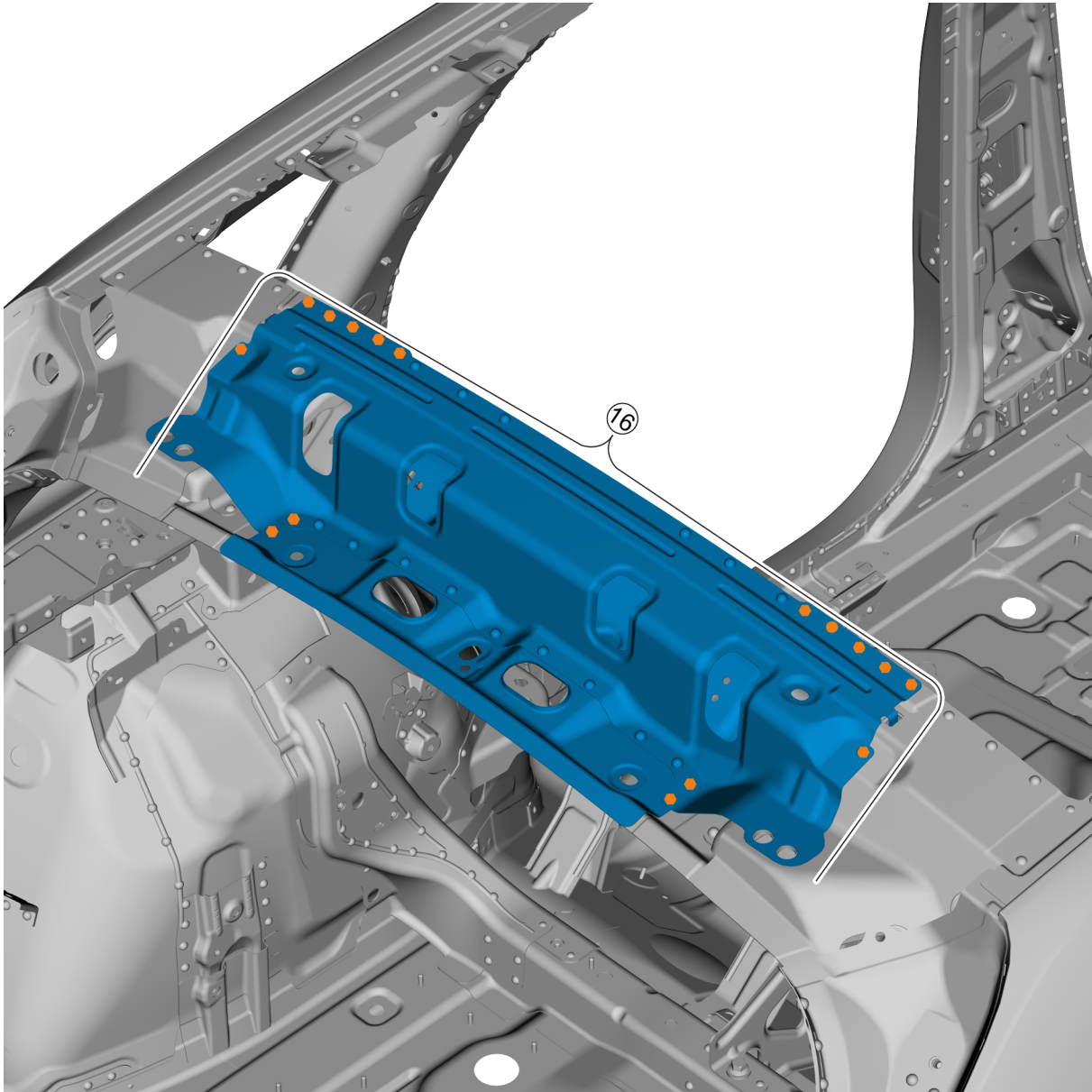
## 4.2.70 Installation of the Roof Cover Rear Beam Assembly

### 4.2.70.1 Installation of the Roof Cover Rear Beam Assembly

1. When installing a new part, match the mounting position of the new part on the body.
2. Temporarily install the new part for initial positioning.
3. Check and measure the positional dimensions of the roof cover front beam assembly and the body for compliance with the standard, and adjust if necessary.
4. Weld the fixing points of the roof cover rear beam assembly to the left and right C-pillar assemblies.



5. Weld the fixing points of the roof cover rear beam assembly to the left and right C-pillar assemblies.



6. Install the large sunroof top cover assembly.

## 4.3 Vehicle body structure (waterproofing and rust prevention treatment)

### 4.3.1 Body Seal Material

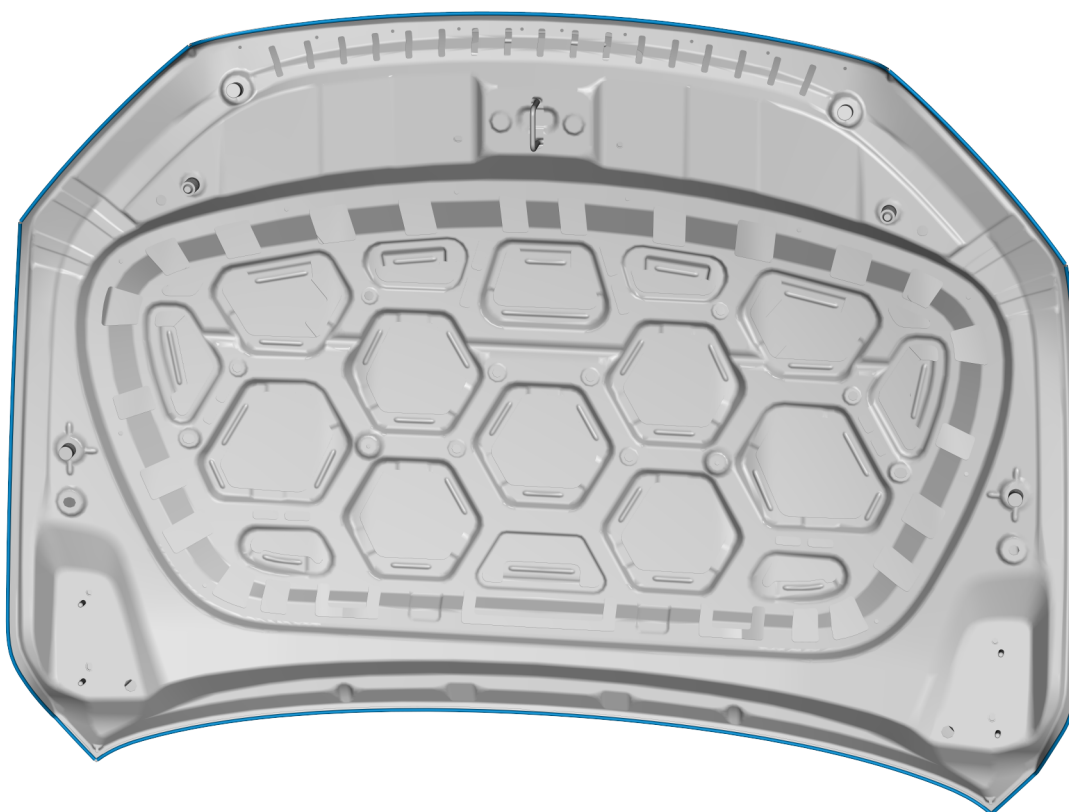
#### 4.3.1.1 Body Seal Material

Apply sealant to the joints of the plates to prevent water and rust.

Hood gluing position

#### Caution

- Glueing position: as shown in the figure
- Glueing specifications: width is 10mm, height is 2mm
- Glueing requirements: continuous, complete and without leakage

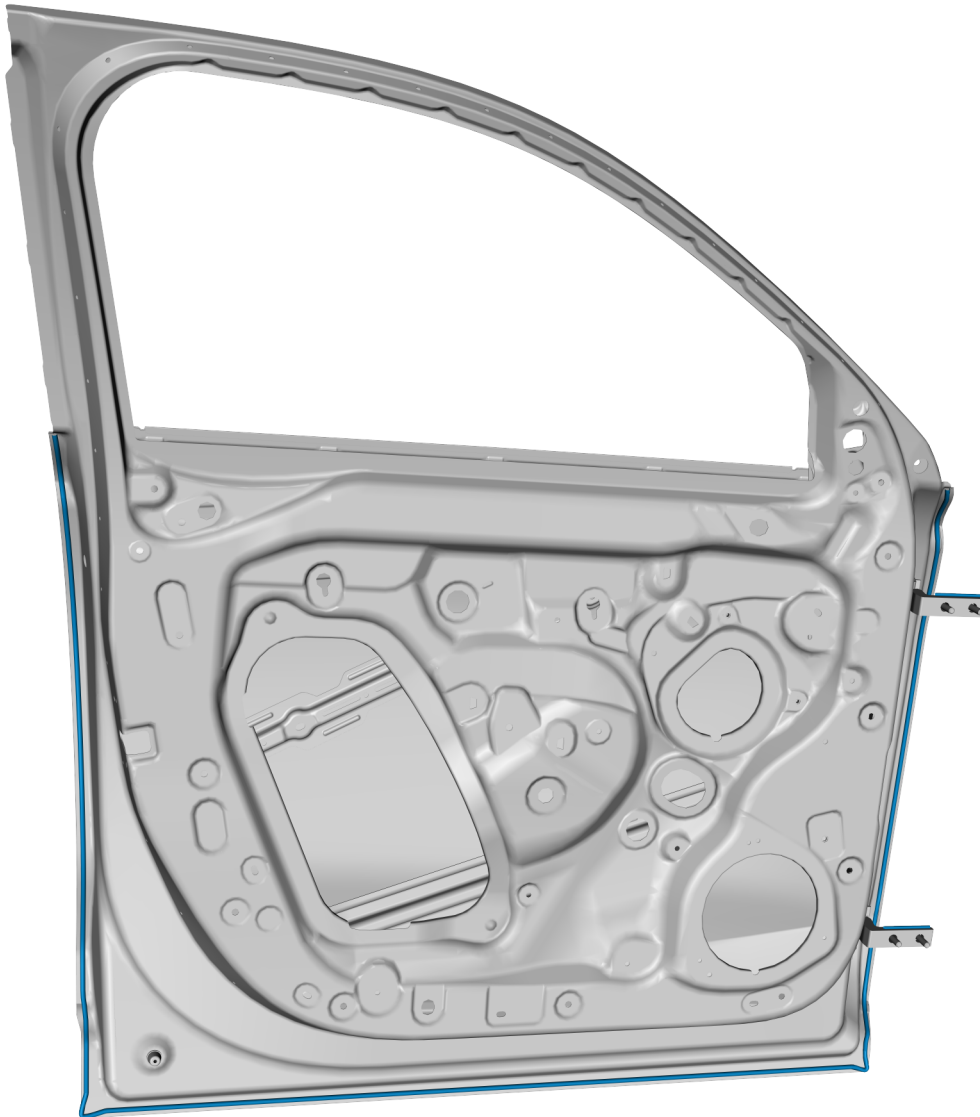




Front door gluing position

Caution

- Glueing position: as shown in the figure
- Glueing specifications: width is 10mm, height is 2mm
- Glueing requirements: continuous, complete and without leakage

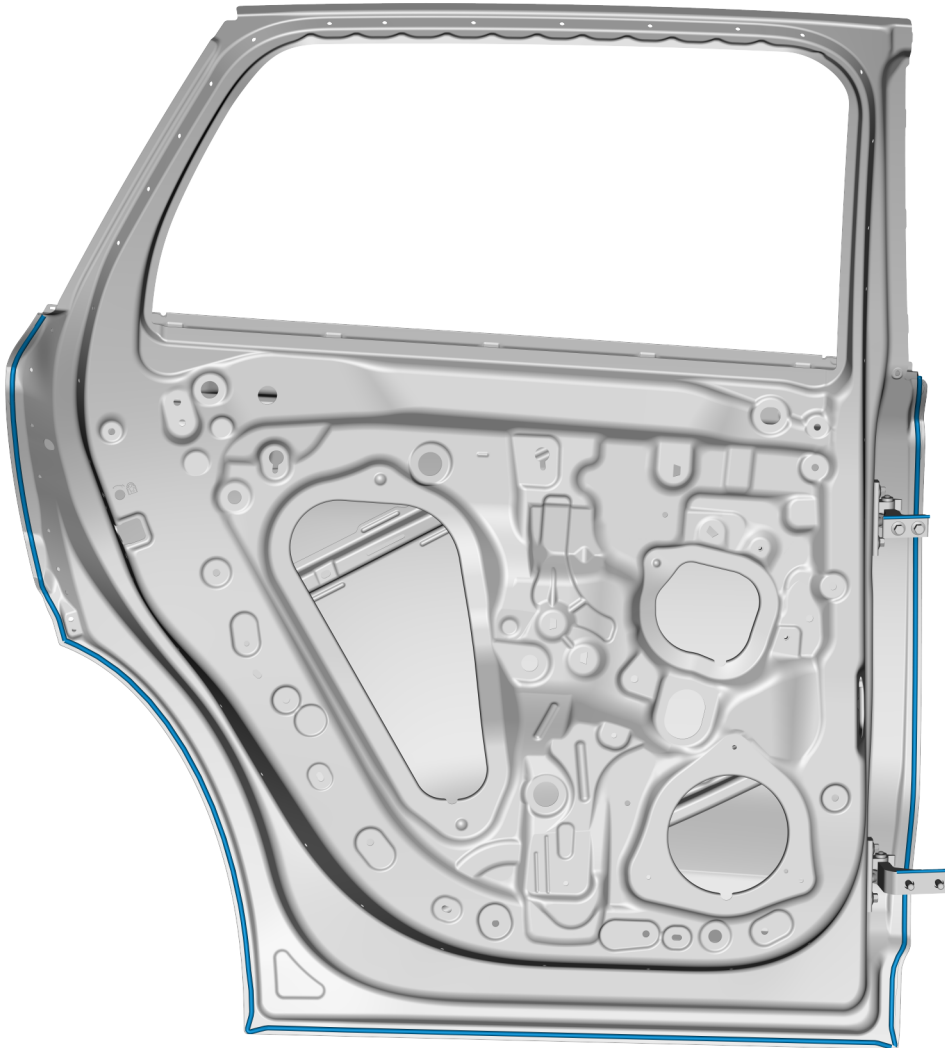




## Rear door gluing position

## Caution

- Glueing position: as shown in the figure
- Glueing specifications: width is 10mm, height is 2mm
- Glueing requirements: continuous, complete and without leakage



Back door gluing position

Caution

- Glueing position: as shown in the figure
- Glueing specifications: width is 10mm, height is 2mm
- Glueing requirements: continuous, complete and without leakage

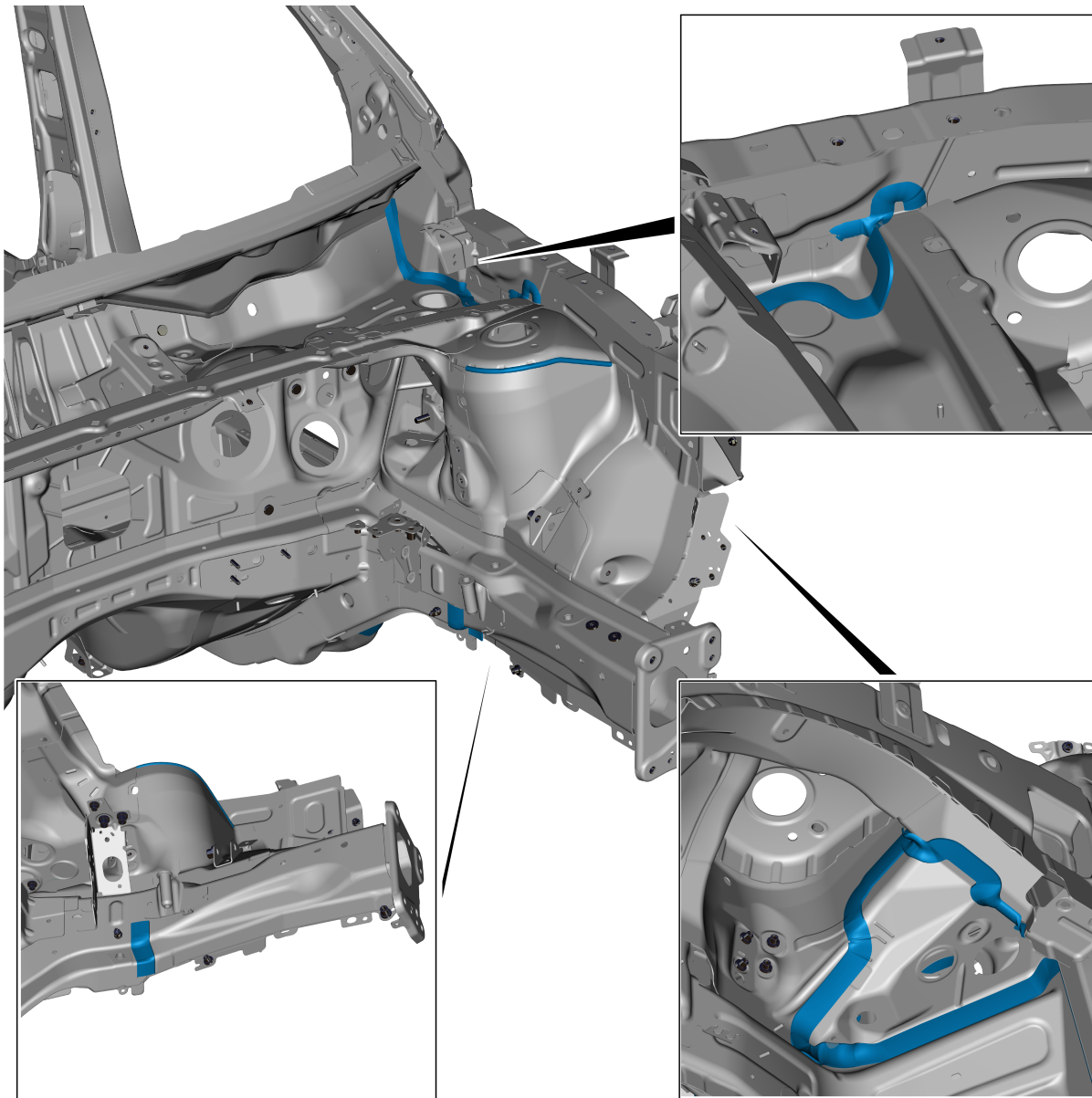




Left longitudinal beam gluing position

**Caution**

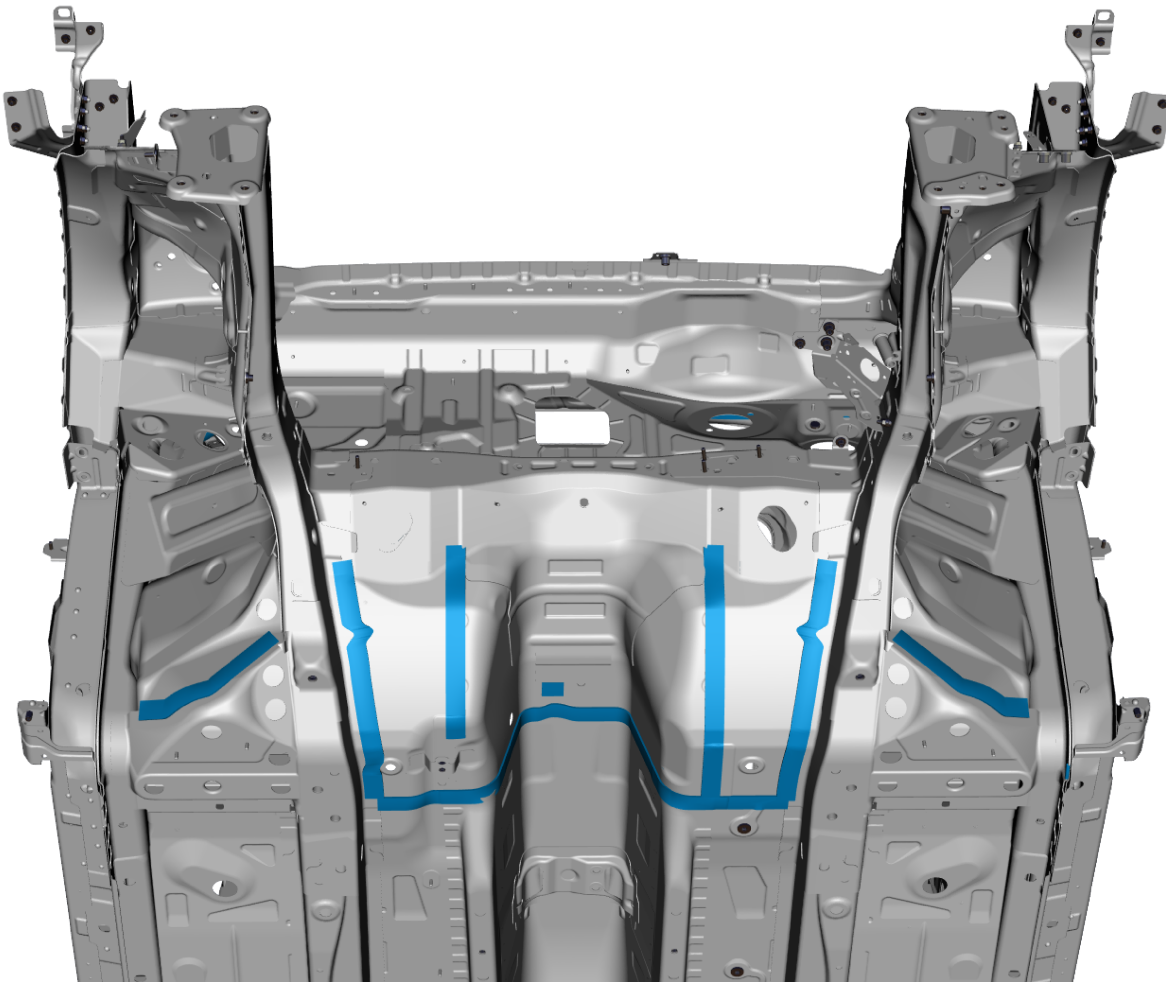
Left and right gluing positions are symmetrical.



## Front cabin lower gluing position

## Caution

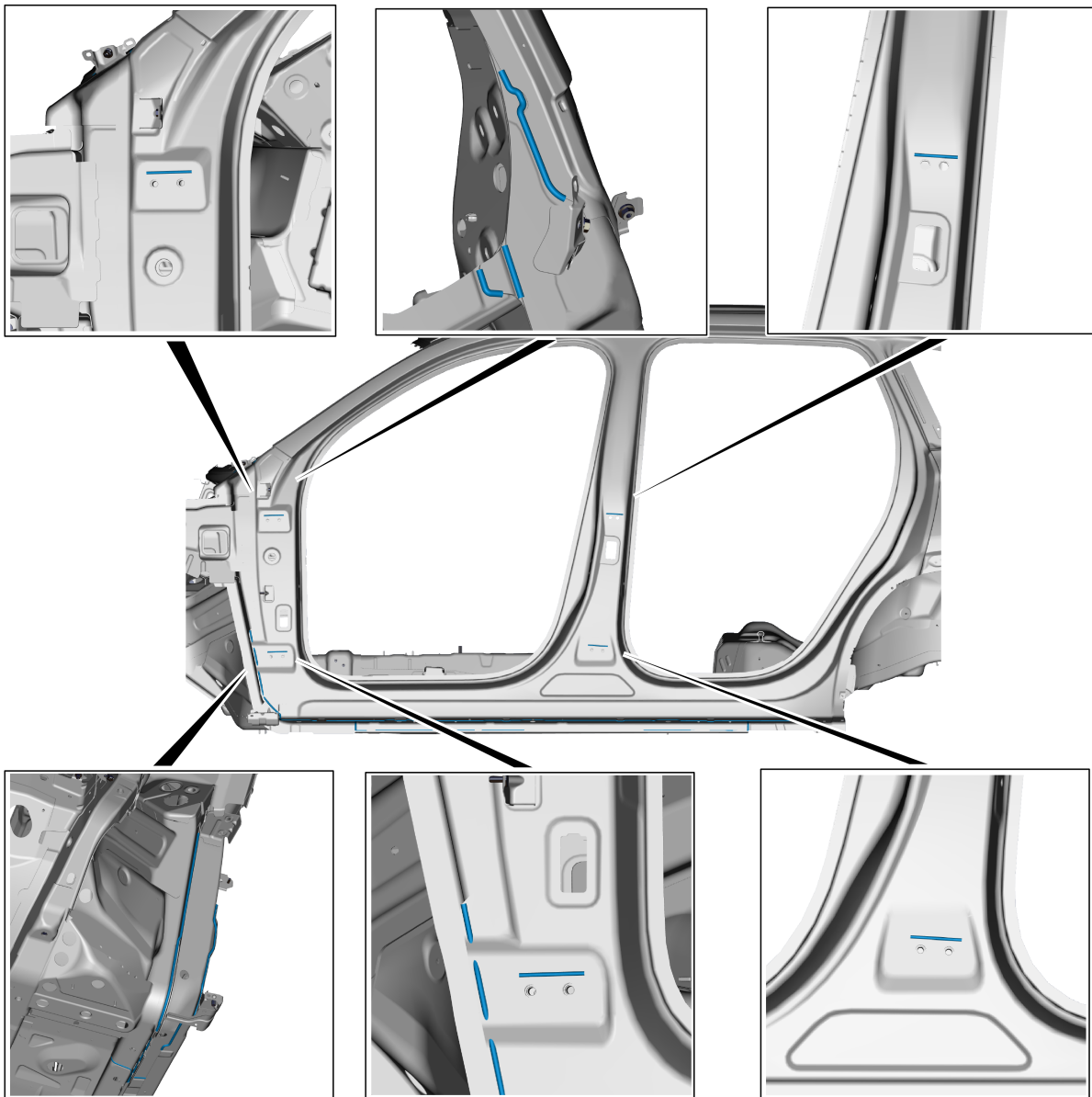
- Glueing positions: as shown in the figure, symmetrical left and right
- Glueing specifications: width is 30mm, height is 3mm
- Glueing requirements: continuous, complete and without leakage



Sidewall mounting bracket gluing position

Caution

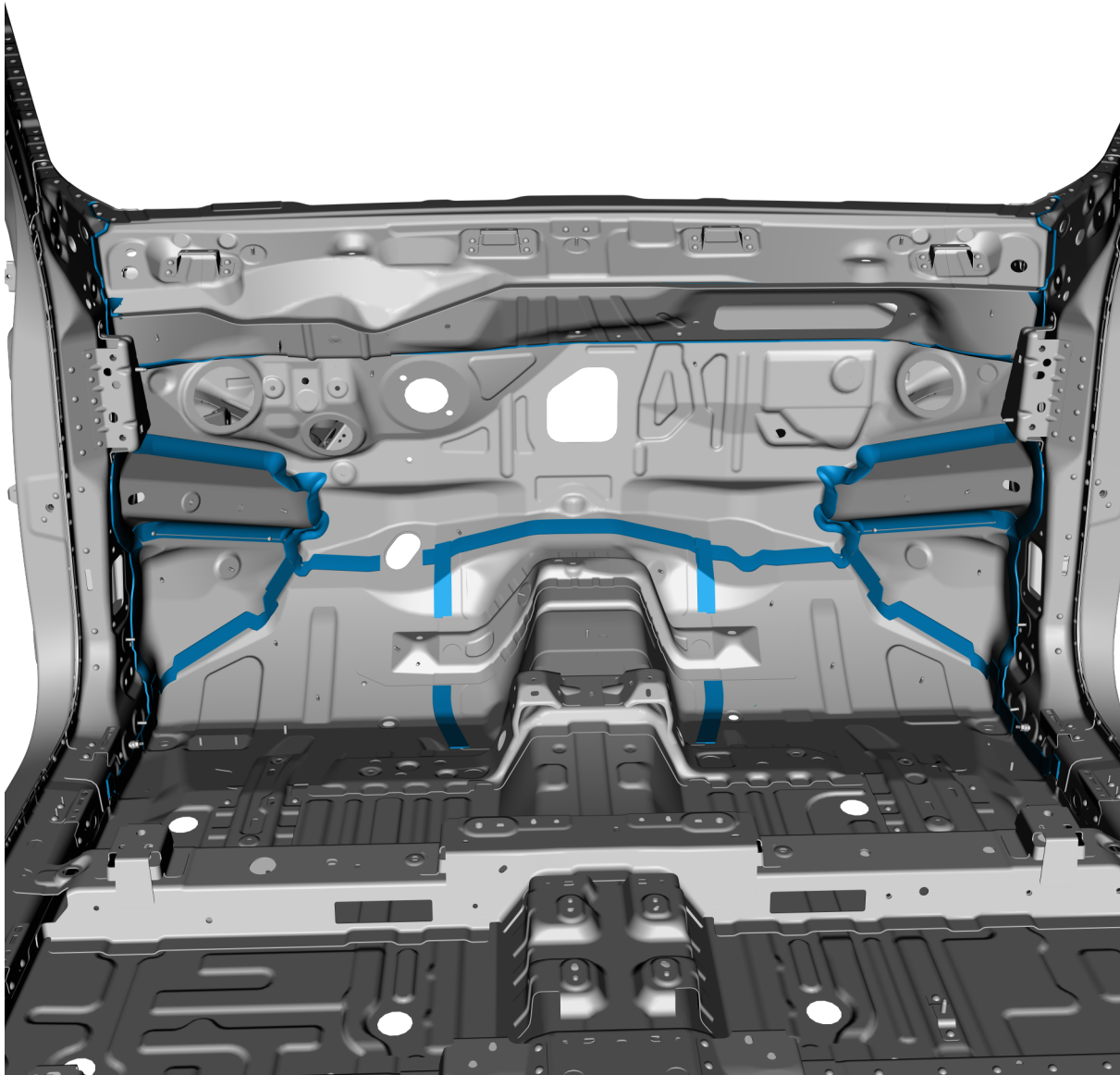
Left and right gluing positions are symmetrical.



Gluing position of the front enclosure and sidewall and the front floor

**Caution**

- Glueing positions: as shown in the figure, symmetrical left and right
- Glueing specifications: width is 30mm, height is 3mm
- Glueing requirements: continuous, complete and without leakage

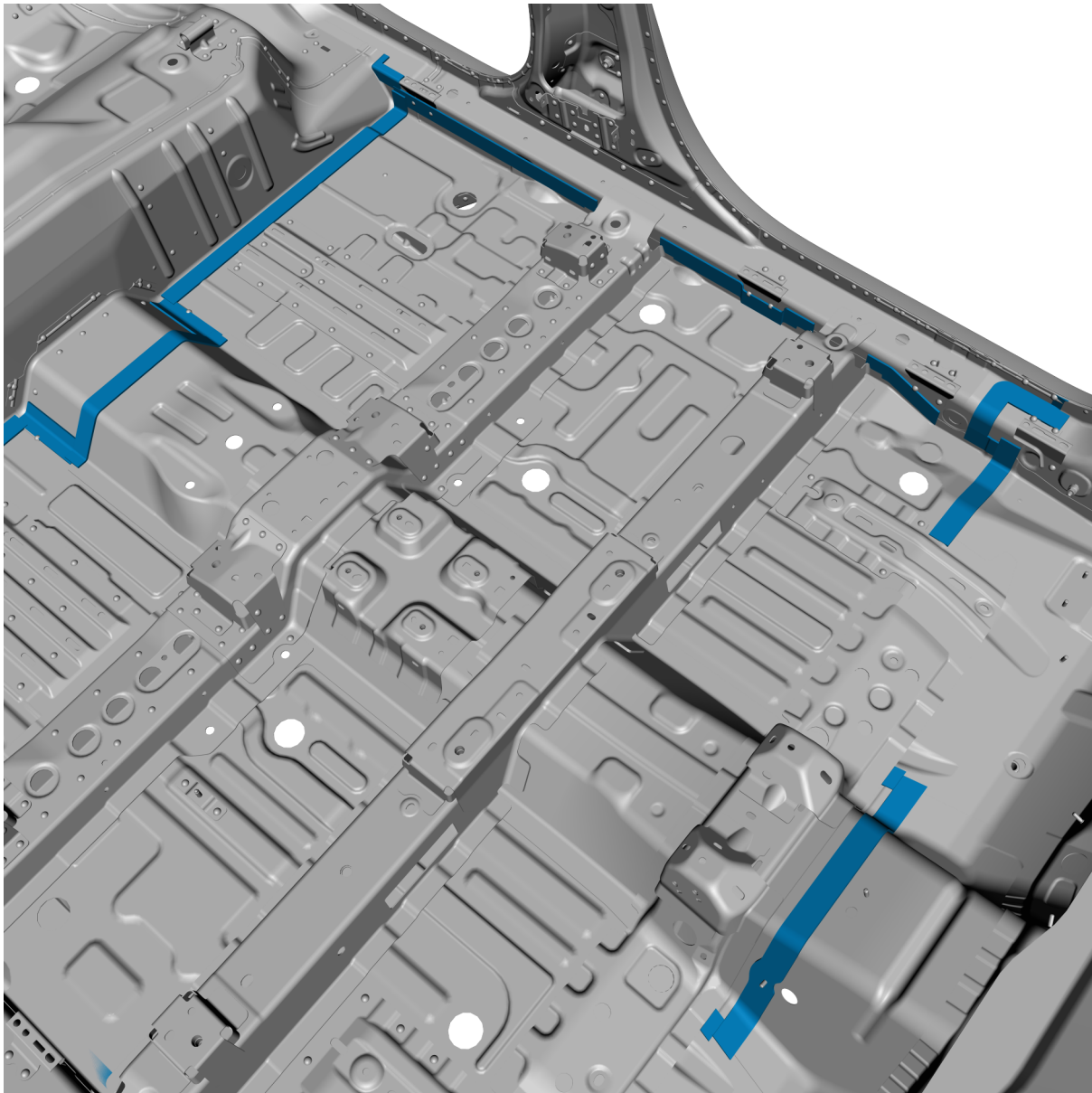




Front floor gluing position

**Caution**

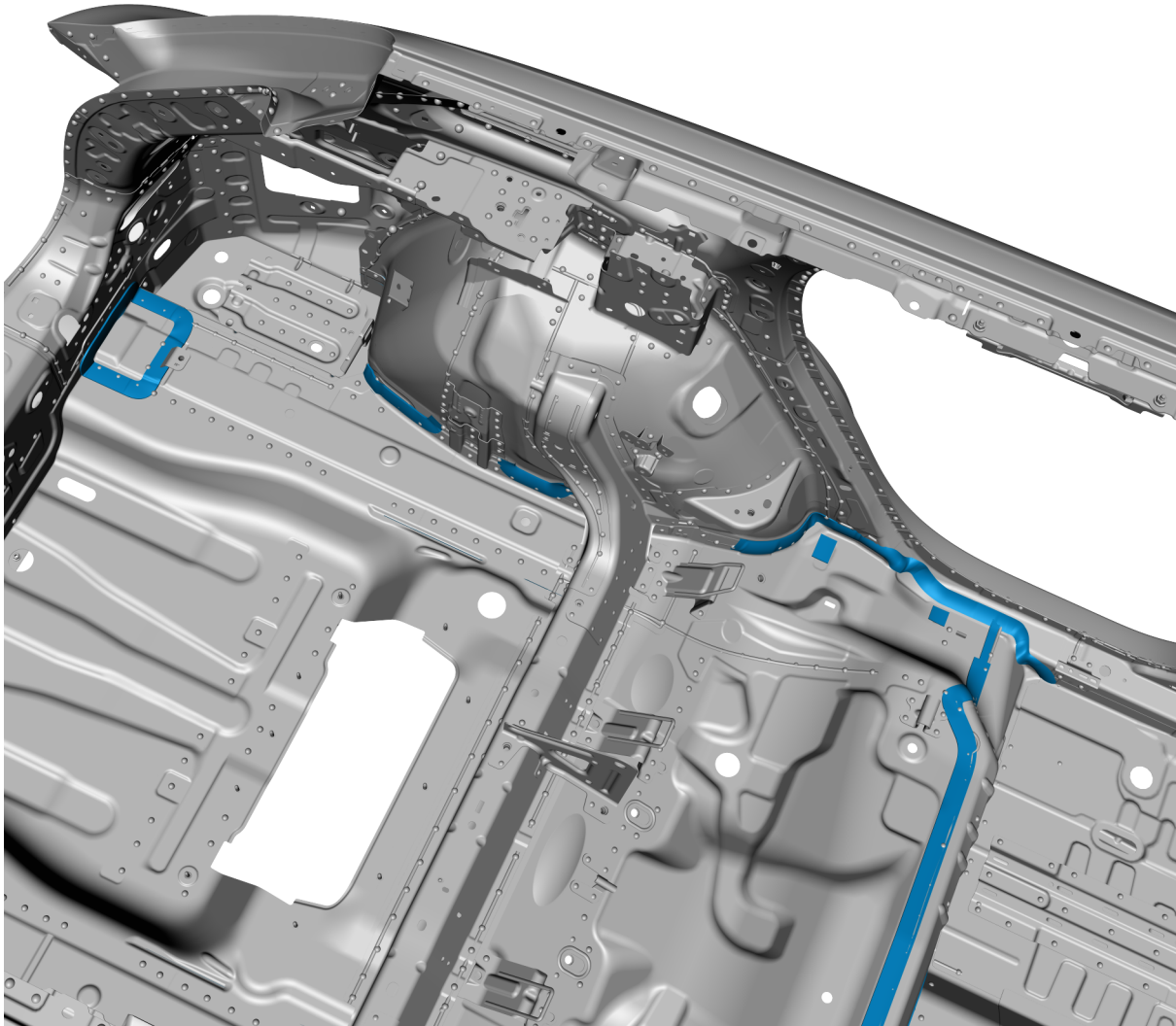
- Glueing positions: as shown in the figure, symmetrical left and right
- Glueing specifications: width is 30mm, height is 3mm
- Glueing requirements: continuous, complete and without leakage



Rear floor gluing position

**Caution**

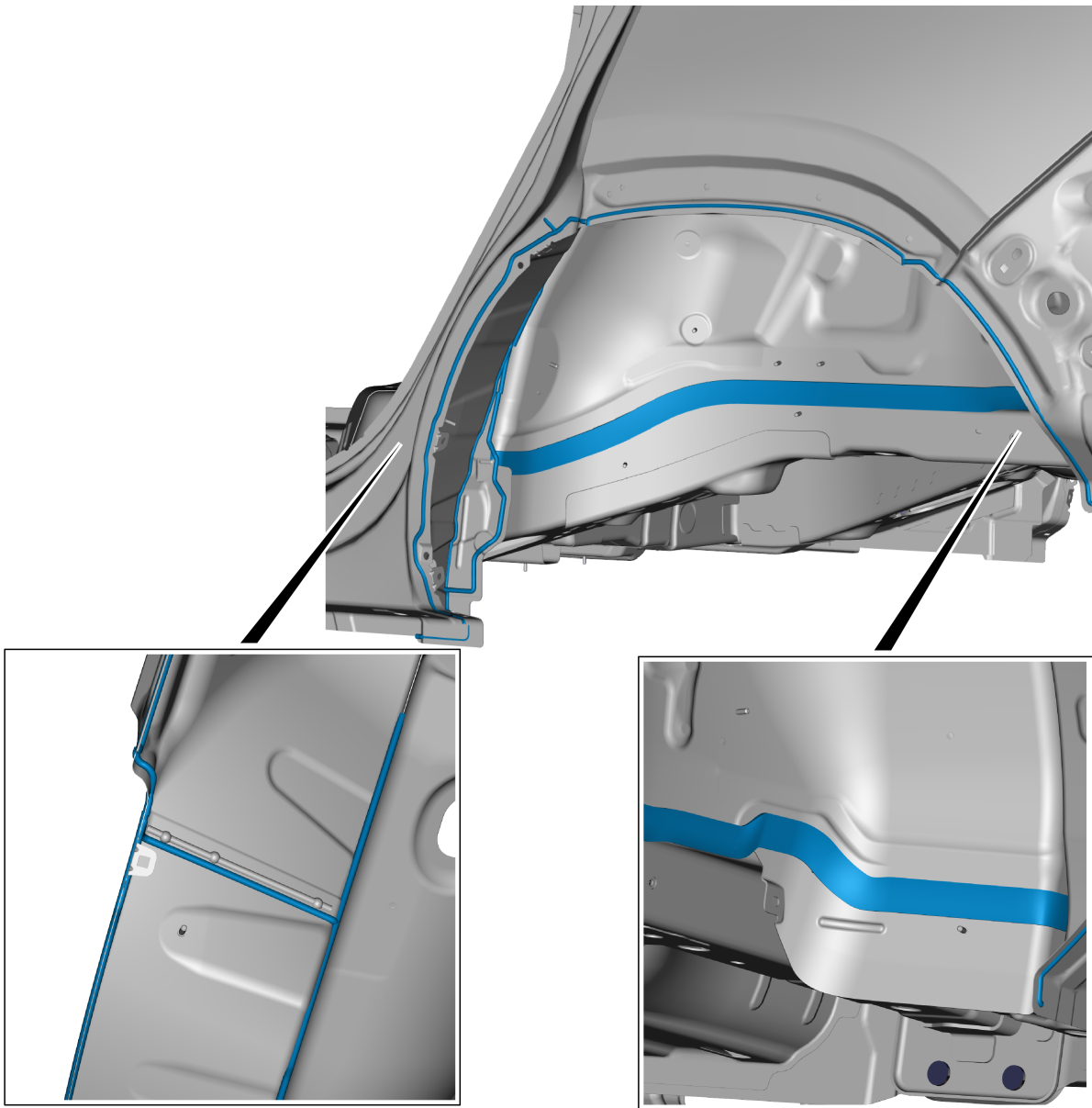
- Glueing positions: as shown in the figure, symmetrical left and right
- Glueing specifications: width is 30mm, height is 3mm
- Glueing requirements: continuous, complete and without leakage



Rear wheel cover gluing position

Caution

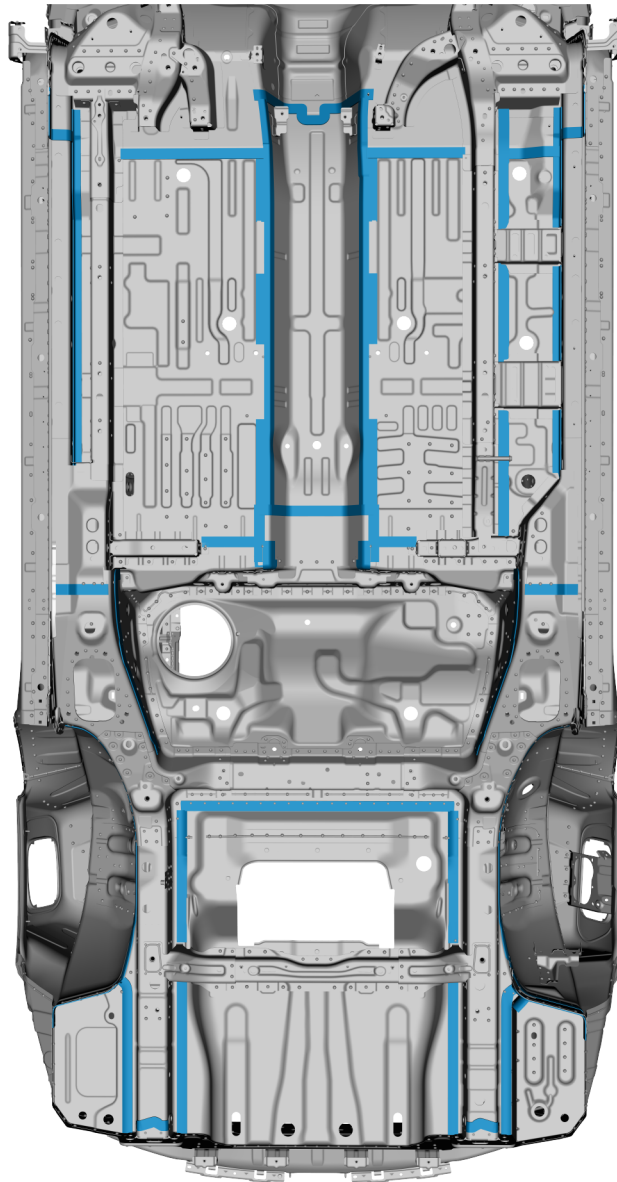
Left and right gluing positions are symmetrical.



## Underbody gluing position

## Caution

- Glueing positions: as shown in the figure, symmetrical left and right
- Glueing specifications: width is 30, height is 3mm
- Glueing requirements: continuous, complete and without leakage



Rear enclosure gluing position



## 4.3.2 Stone-chip resistant materials

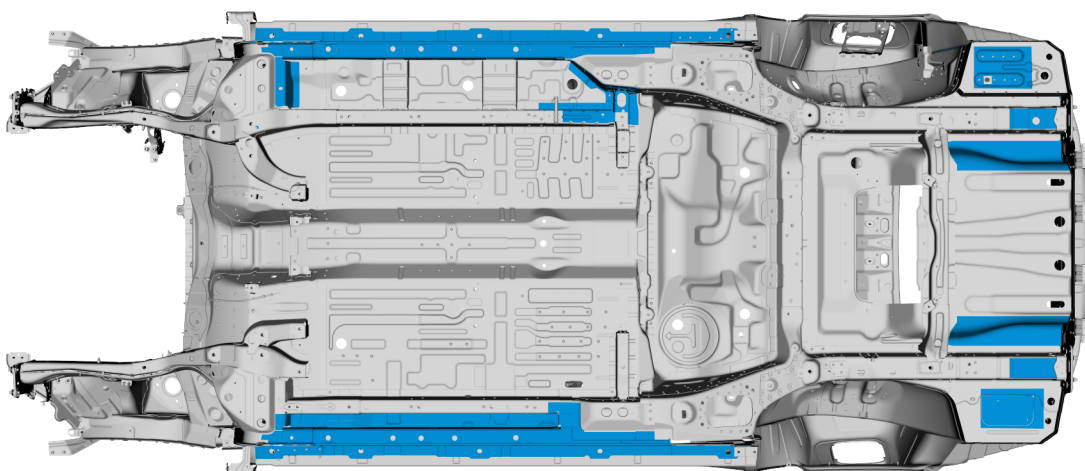
### 4.3.2.1 Location of the anti-rock impact material

#### Anti-rock Impact Material

Anti-rock impact material is a coating used to protect the lower part of the body and reduce the damage caused by the impact of flying rocks on the body. It is sprayed on the underfloor surfaces and front and rear wheel covers to cushion the chassis from the impact of sand and rocks brought up by high-speed driving, to reduce interior noise and to improve the comfort of the driver.

The shaded area in the figure below is the protective coating applied by the anti-rock impact paint.

Position of anti-rock impact material on the bottom of the body

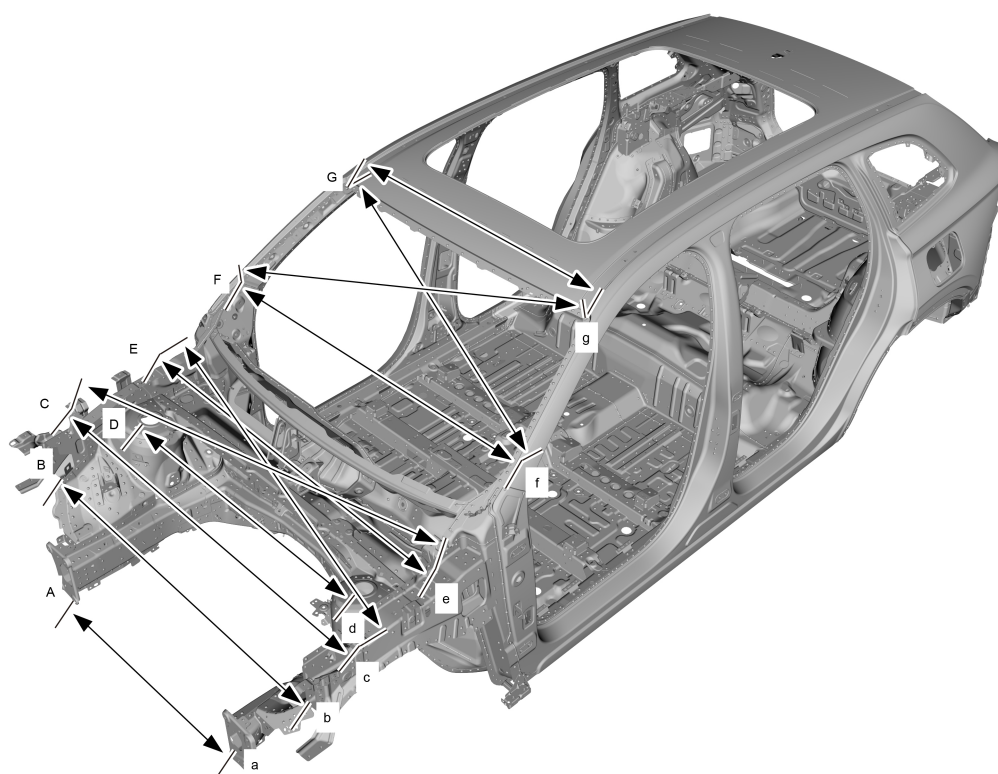




## 4.4 Body structure (dimensions)

### 4.4.1 Front body dimensions

#### 4.4.1.1 Front body dimensions



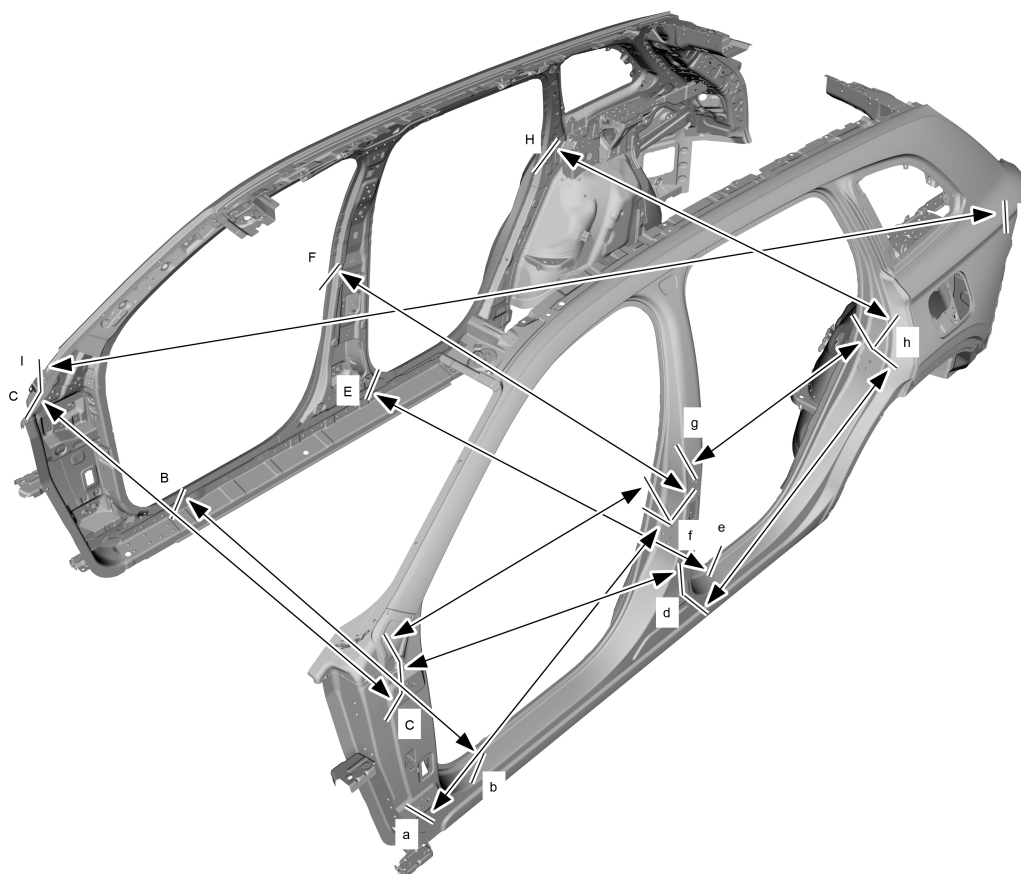
Location	Dimensions	Nominal dimensions (mm)	Difference
Front beam mounting hole	A-a	950	±1.5
Tank mounting hole	B-b	757.6	±1.5
Wing front bracket mounting hole	C-c	1584	±1.5
Right wing front bracket mounting hole - hood left hinge rear mounting hole	C-e	1639	±1.5
Front shock absorber mounting hole	D-d	1187.9	±1.5



Location	Dimensions	Nominal dimensions (mm)	Difference
Hood hinge mounting hole	E-e	1532	±1.5
Hood right hinge rear mounting hole - Left wing front bracket mounting hole	E-c	1639	±1.5
Sidewall outer plate/front enclosure upper combination part	F-f	1494.6	±1.5
Sidewall outer plate/front enclosure upper combination part (right) - Sidewall outer plate/roof cover combination part (left)	F-g	1466.6	±1.5
Sidewall outer plate/roof cover combination part	G-g	1466.6	±1.5
Sidewall outer plate/roof cover combination part (right) - Sidewall outer plate/front enclosure upper combination part (left)	G-f	1466.6	±0.5

### 4.4.2 Mid-body dimensions

#### 4.4.2.1 Mid-body dimensions

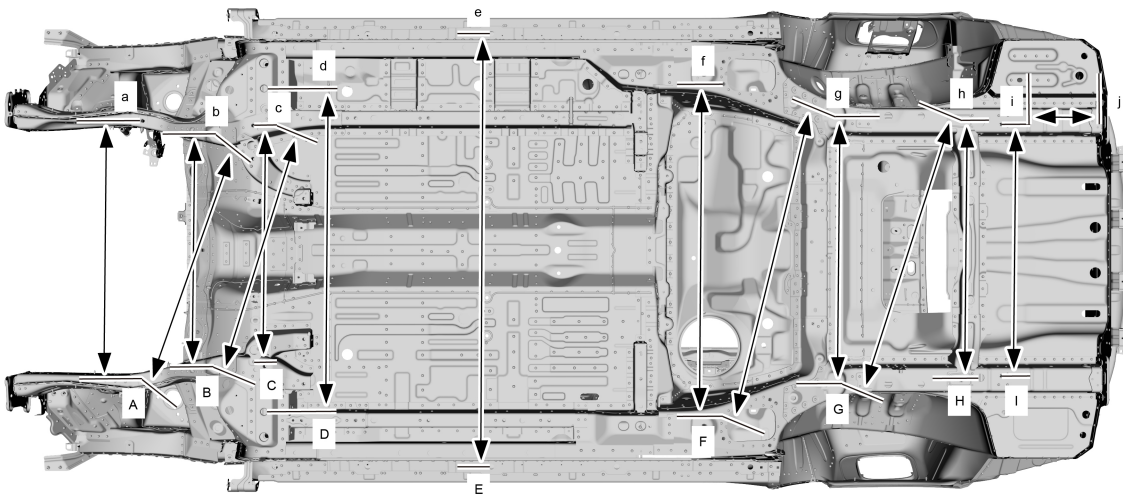


Location	Dimensions	Nominal dimensions (mm)	Difference ( $\pm$ )
Front door lower hinge mounting hole (left) - Front door latch mounting hole (left)	a-f	1082	$\pm 1.5$
Measurement marks at the bottom of the front door opening	b-B	1510	$\pm 1.5$
Front door upper hinge mounting hole (left) - Front door upper hinge mounting hole (right)	c-C	1629.7	$\pm 1.5$

Location	Dimensions	Nominal dimensions (mm)	Difference ( $\pm$ )
Front door upper hinge mounting hole (left) - Rear door lower hinge mounting hole (left)	c-d	1182.3	$\pm 1.5$
Front door upper hinge mounting hole (left) - Front door latch mounting hole (left)	c-f	1072.8	$\pm 1.5$
Rear door lower hinge mounting hole (left) - Rear door latch mounting hole (left)	d-h	1076.8	$\pm 1.5$
Measurement marks at the bottom of the rear door opening	e-E	1510	$\pm 1.5$
Front door latch mounting hole (left) - Front door latch mounting hole (right)	f-F	1606.2	$\pm 1.5$
Rear door upper hinge mounting hole (left) - Rear door latch mounting hole (left)	g-h	939.5	$\pm 1.5$
Rear door latch mounting hole (left) - Rear door latch mounting hole (right)	h-H	1606.5	$\pm 1.5$
Front door upper hinge mounting hole (right) - Rear combination light mounting hole (left)	i-C	3364.3	$\pm 1.5$

4.4.3 Under body Dimensions

4.4.3.1 Underbody Dimensions

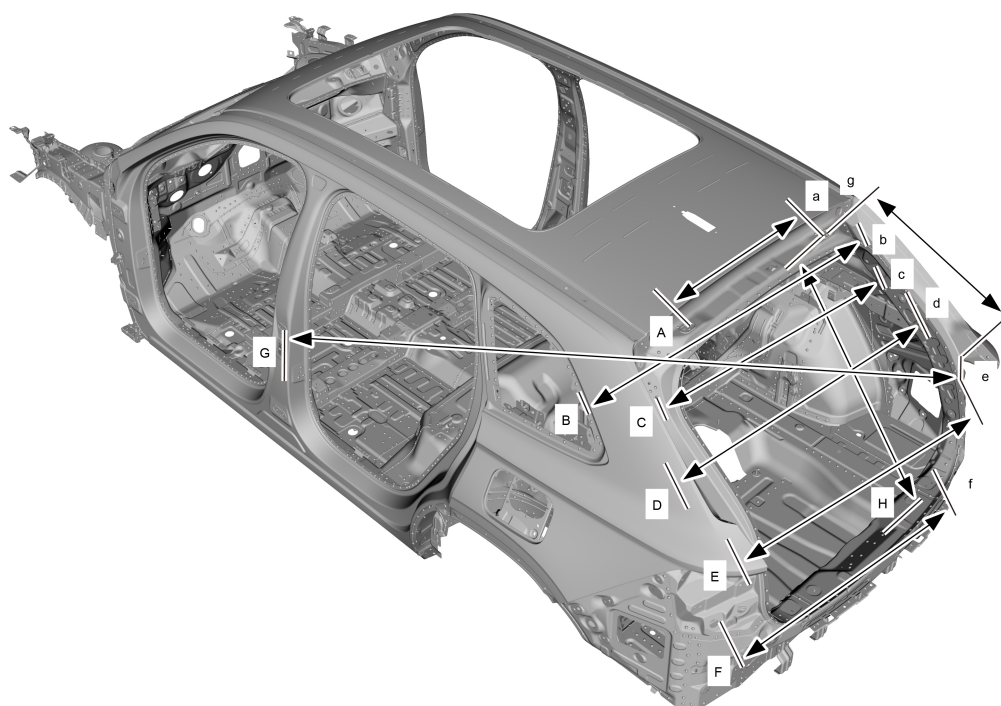


Location	Dimensions	Nominal dimensions (mm)	Difference (±)
Front sub-frame front mounting hole	A-a	946	±1.5
Front sub-frame right front mounting hole - Front sub-frame left center mounting hole	A-b	957.9	±1.5
Front sub-frame center mounting hole	B-b	814.5	±1.5

Location	Dimensions	Nominal dimensions (mm)	Difference (±)
Front suspension right center mounting hole - Front suspension left rear mounting hole	B-c	871.2/753.1	±1.5
Front sub-frame rear mounting hole	C-c	838.3/648	±1.5
Left front floor positioning hole - Right front floor positioning hole	D-d	1142	±1.5
Right door sill outer plate positioning hole - Left door sill outer plate positioning hole	E-e	1536.2	±1.5
Rear sub-frame trailing arm mounting hole	F-f	1182.8	±1.5
Rear sub-frame right trailing arm mounting hole - Rear sub-frame left front mounting hole	F-g	1162.3	±1.5
Rear sub-frame front mounting hole	G-g	968	±1.5
Rear sub-frame right front mounting hole - Rear sub-frame left rear mounting hole	G-h	1072.5	±1.5
Rear sub-frame rear mounting hole	H-h	946	±1.5
Rear longitudinal beam positioning hole	I-i	924	±1.5
Rear longitudinal beam positioning hole - Rear panel	i-j	368.3	±1.5

### 4.4.4 Rear Body Dimensions

#### 4.4.4.1 Rear Body Dimensions



Location	Dimensions	Nominal dimensions (mm)	Difference (±)
Back door (right) hinge left mounting hole	A-a	694	±1.5
Rear side triangular window center D-pillar trim mounting hole	B-b	1364.7	±1.5
Back door strut mounting hole	C-c	1132.5	±1.5
Rear seat belt retractor bracket supporting plate mounting hole	D-d	1311	±1.5

Location	Dimensions	Nominal dimensions (mm)	Difference ( $\pm$ )
Rear combination lamp mounting hole	E-e	1185.5	$\pm 1.5$
Rear beam assembly mounting hole	F-f	1086	$\pm 1.5$
Back door (right) hinge left mounting hole - Luggage compartment latch mounting hole (right)	a-h	1024	$\pm 1.5$
Rear combination lamp mounting hole (right) - Rear door upper hinge mounting hole (left)	e-G	2416.5	$\pm 1.5$
Rear combination light mounting hole (right) - Back door (right) hinge right mounting hole	e-g	734	$\pm 1.5$



