

DAIHATSU MATERIA REPAIR MANUAL FOR COLLISION DAMAGE

INTRODUCTION **IN**

BODY PANEL REPLACEMENT **BP**

BODY DIMENSIONS **DI**

PAINT • COATING **PC**



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5. HANDLING PRECAUTIONS OF PLASTIC BODY PARTS

- (a) The repair procedure for plastic body parts must conform with the type of plastic material.
 (b) Plastic body parts are identified by the codes in the following table.
 (c) When repairing metal body parts adjoining plastic body parts (by brazing, frame cutting, welding, painting etc.), consideration must be given to the properties of the plastic.



Code	Material name	Heat* resistant temperature limit (°C)	Resistance to alcohol gasoline	Note
AAS	Acrylonitrile Acrylic Styrene	80	Alcohol is harmless if applied only for short time in small amounts (e.g., quick wiping to remove grease).	Avoid gasoline and organic or aromatic solvents.
ABS	Acrylonitrile Butadiene Styrene	80	Alcohol is harmless if applied only for short time in small amounts (e.g., quick wiping to remove grease).	Avoid gasoline and organic or aromatic solvents.
ASA	Acrylonitrile Styrene Acrylate	80	Alcohol is harmless if applied only for short time in small amounts (e.g., quick wiping to remove grease).	Avoid gasoline and organic or aromatic solvents.
E/VAC	Ethylene Vinyl Acetate Copolymer Resin	70	Alcohol is harmless if applied only for short time in small amounts (e.g., quick wiping to remove grease).	Avoid gasoline and organic or aromatic solvents.
PA	Polyamide (Nylon)	80	Alcohol and gasoline are harmless.	Avoid battery acid.
PBT	Polybutylene Terephthalate	160	Alcohol and gasoline are harmless.	Most solvents are harmless.
PC	Polycarbonate	120	Alcohol is harmless.	Avoid gasoline, brake fluid, wax, wax removers and organic solvents. Avoid alkali.
PMMA	Polymethyl Methacrylate	80	Alcohol is harmless if applied only for short time in small amounts.	Avoid dipping or immersing in alcohol, gasoline, solvents, etc.
PP	Polypropylene	80	Alcohol and gasoline are harmless.	Most solvents are harmless.
PVC	Polyvinyl chloride (Vinyl)	80	Alcohol and gasoline are harmless if applied only for short time in small amounts (e.g., quick wiping to remove grease).	Avoid dipping or immersing in alcohol, gasoline, solvents, etc.
TPO	Thermoplastic Olefine	80	Alcohol is harmless. Gasoline is harmless if applied only for short time in small amounts.	Most solvents are harmless but avoid dipping in gasoline, solvents, etc.

* Temperatures higher than those listed here may result in material deformation during repair.

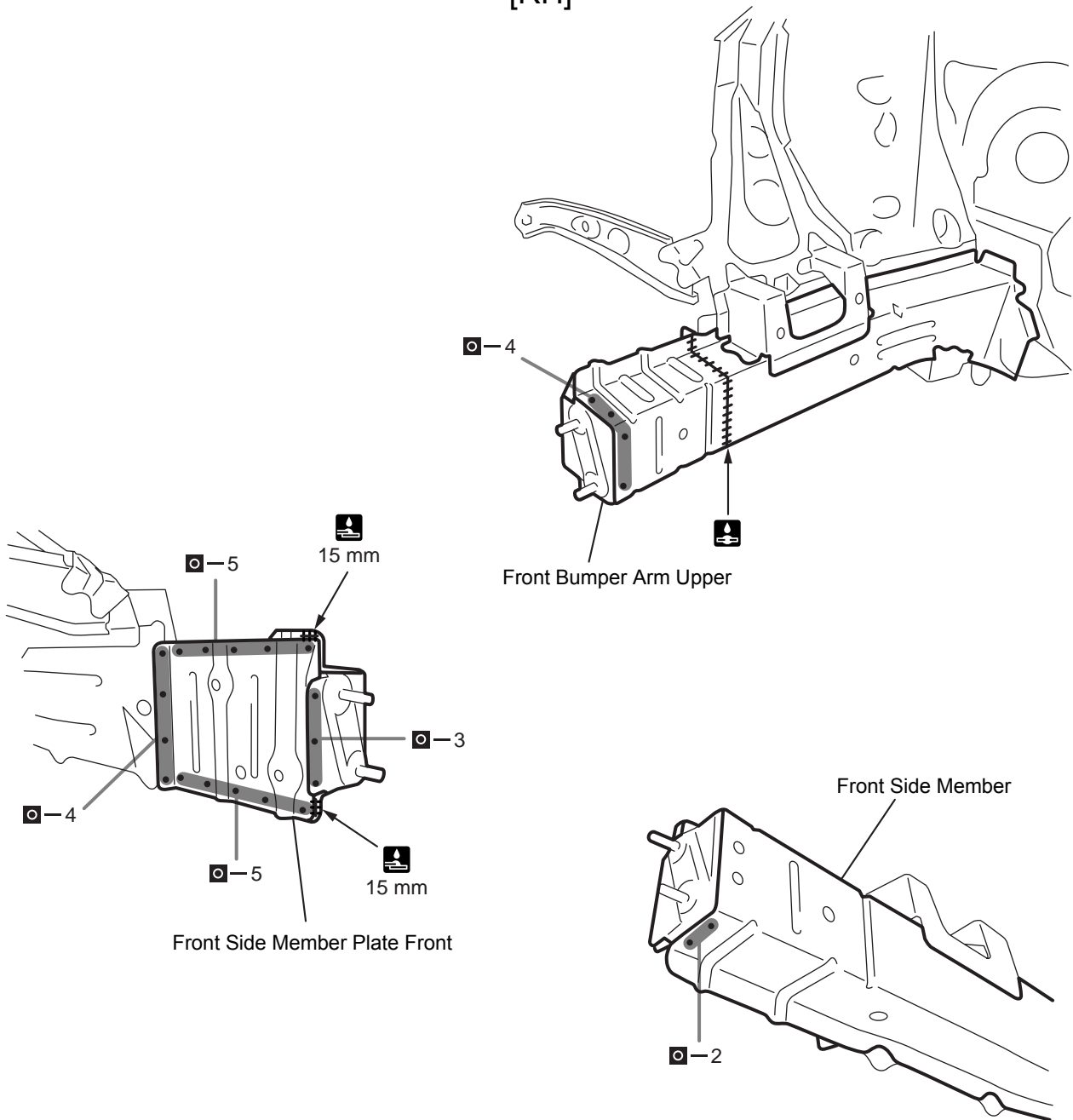
MEMO

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Symbol meaning

 : MIG Plug Weld
  : Tack Weld
  : Butt Weld

[RH]

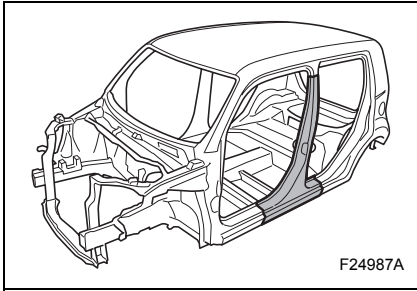


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INSTALLATION POINT

- 1 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 2 After welding, apply body sealer and undercoating to the corresponding parts. (See the paint • coating)
- 3 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

CENTER BODY PILLAR (CUT)

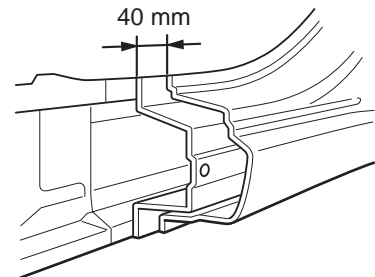
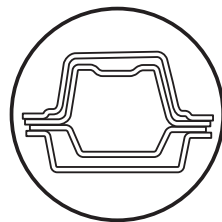
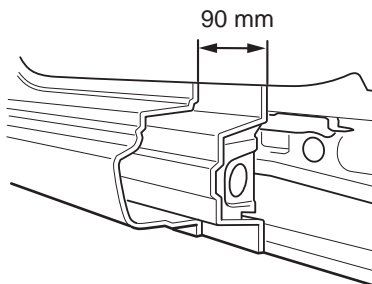
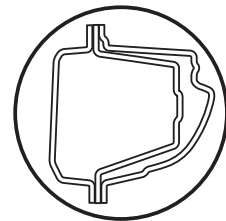
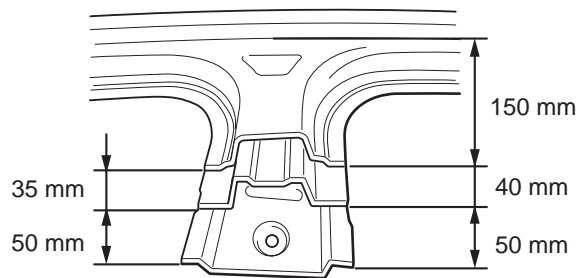
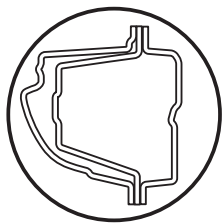
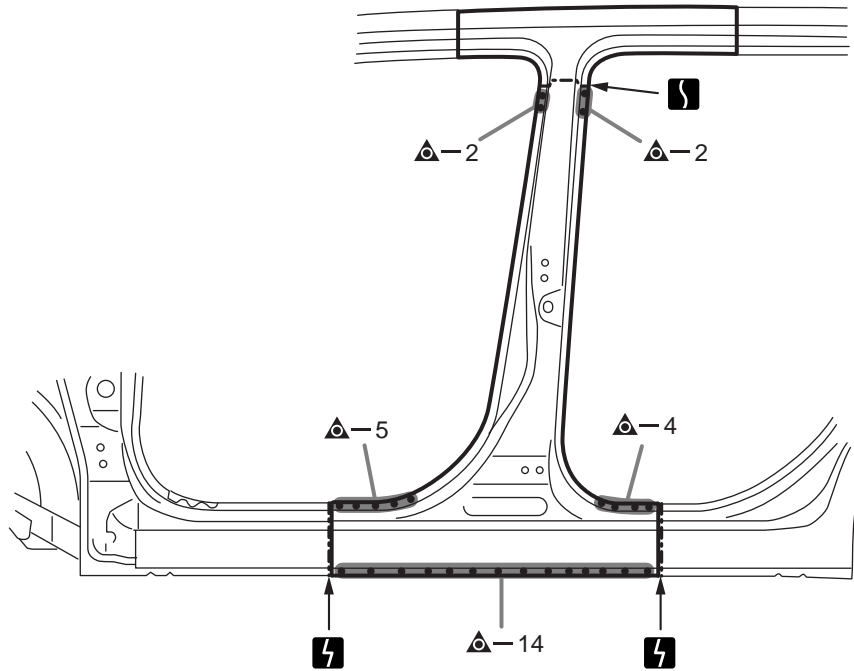


Symbol meaning

- : Remove Weld Points : Cut with disc sander, etc.
- : Cut and Join Location : Cut Location for Supply Parts

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REMOVAL

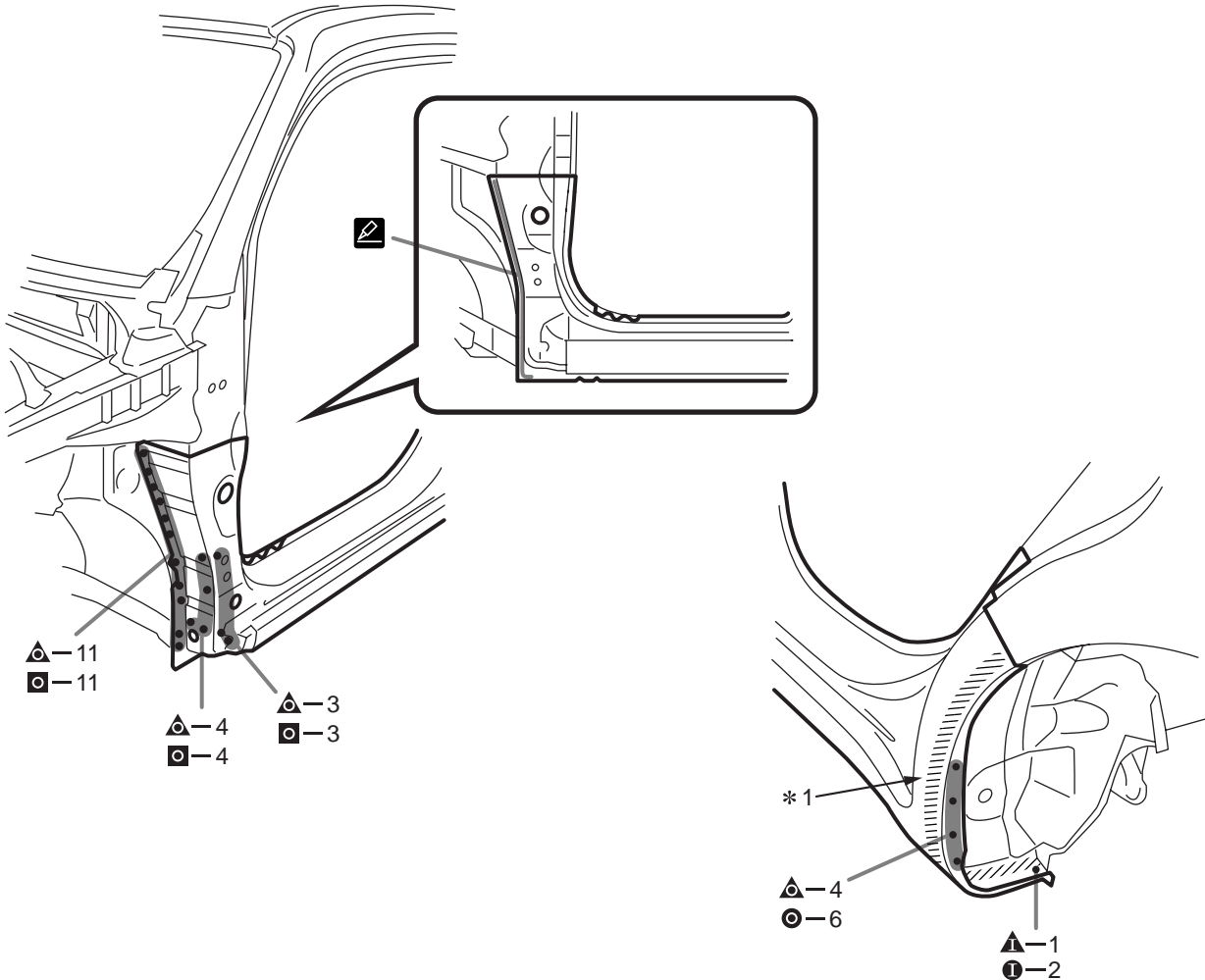


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Symbol meaning

- REMOVAL ⚠ ⚠ : Remove Weld Points ✂ : Cut Location for Supply Parts
- INSTALLATION Ⓞ ⓘ : Spot Weld ◻ : MIG Plug Weld 🔥 : Butt Weld
- ✍ : Body Sealer

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REMOVAL POINT

- 1 *1: In illustration above indicates where the adhesive is located.
- 2 Roughly cut open the wheel arch of the panel so that the adhesive can be reached. Cut through the adhesive with a cut chisel to remove the panel.

HINT:

- 1) If the cut chisel cannot reach the adhesive, heat the adhesive with an industrial heater gun, gas burner. When heating, do not deform the quarter housing outer panel.

INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 Before installing a new part, apply body sealer.

HINT:

- 1) Apply sealer in an even, continuous bead.
- 4 Apply adhesive (3M™ Automix™ Panel Bonding Adhesive #8115) to the area indicated by *1 in illustration.

HINT:

 - 1) Apply enough adhesive for the panels to stick to each other.
- 5 After welding, apply undercoating to the corresponding parts. (See the paint • coating)
- 6 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

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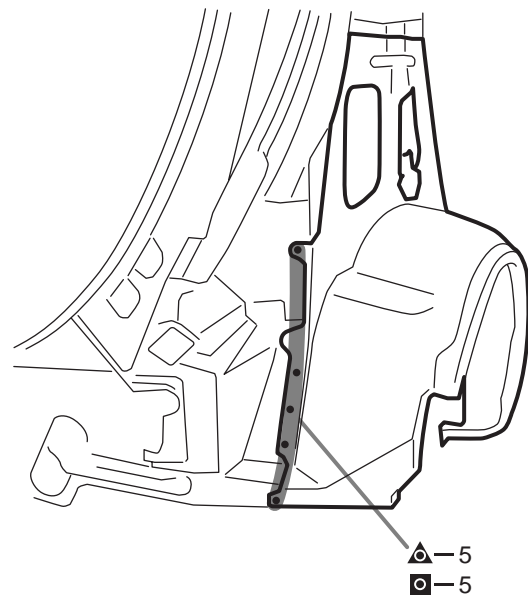
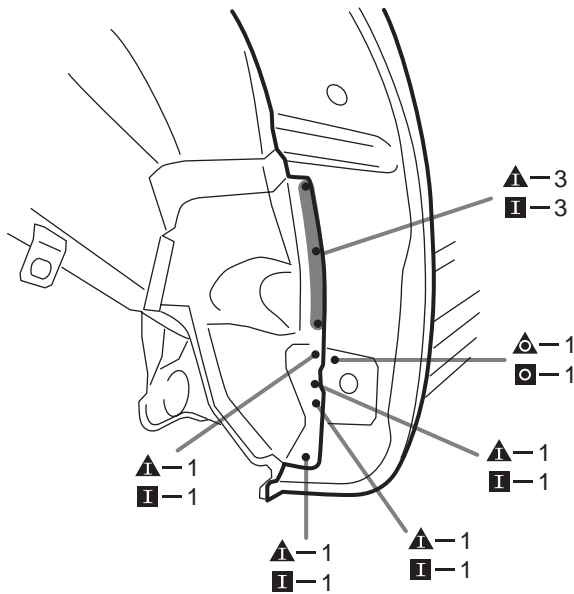
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Symbol meaning

REMOVAL ▲ ▲ ▲ : Remove Weld Points
 INSTALLATION ● : Spot Weld ◻ M I : MIG Plug Weld

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[RH]

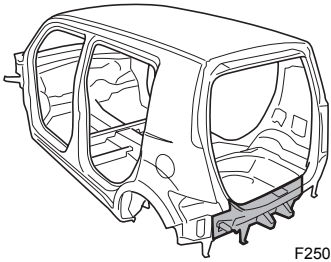


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INSTALLATION POINT

- 1 After welding, apply body sealer and undercoating to the corresponding parts. (See the paint • coating)
- 2 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

BODY LOWER BACK PANEL (ASSY)



F25012A

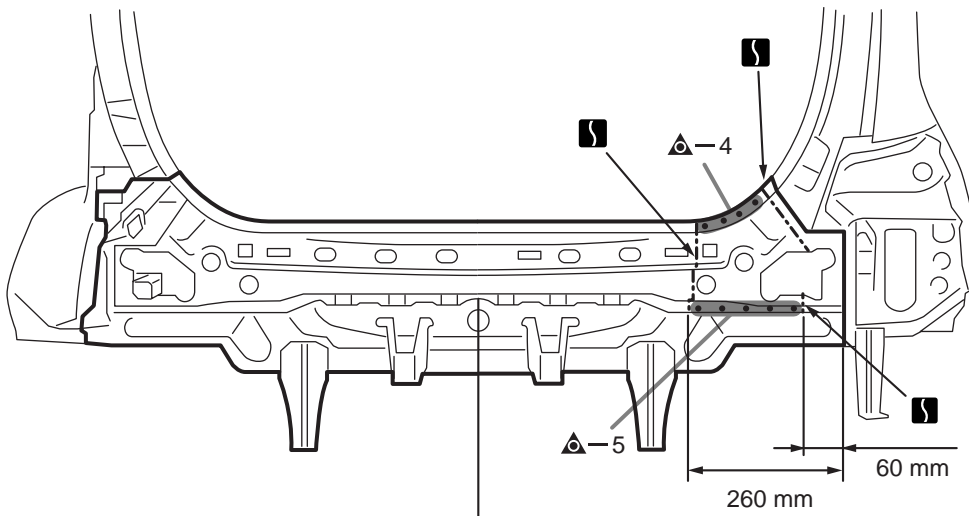
With the quarter panel extension outer removed.

Symbol meaning

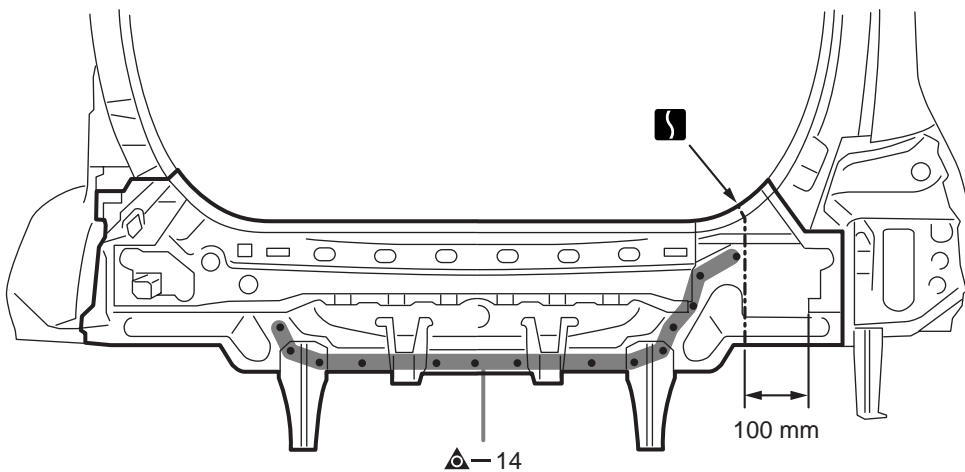
▲ ▲ ▲ : Remove Weld Points S : Cut and Join Location

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REMOVAL



Body Lower Back Reinforcement

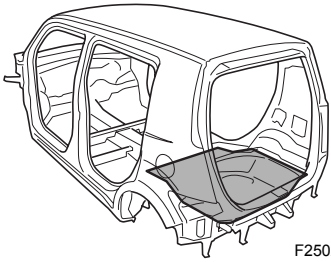


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REMOVAL POINT

- 1 After removing the body lower back reinforcement, remove the body lower back panel.

REAR FLOOR PAN (ASSY)



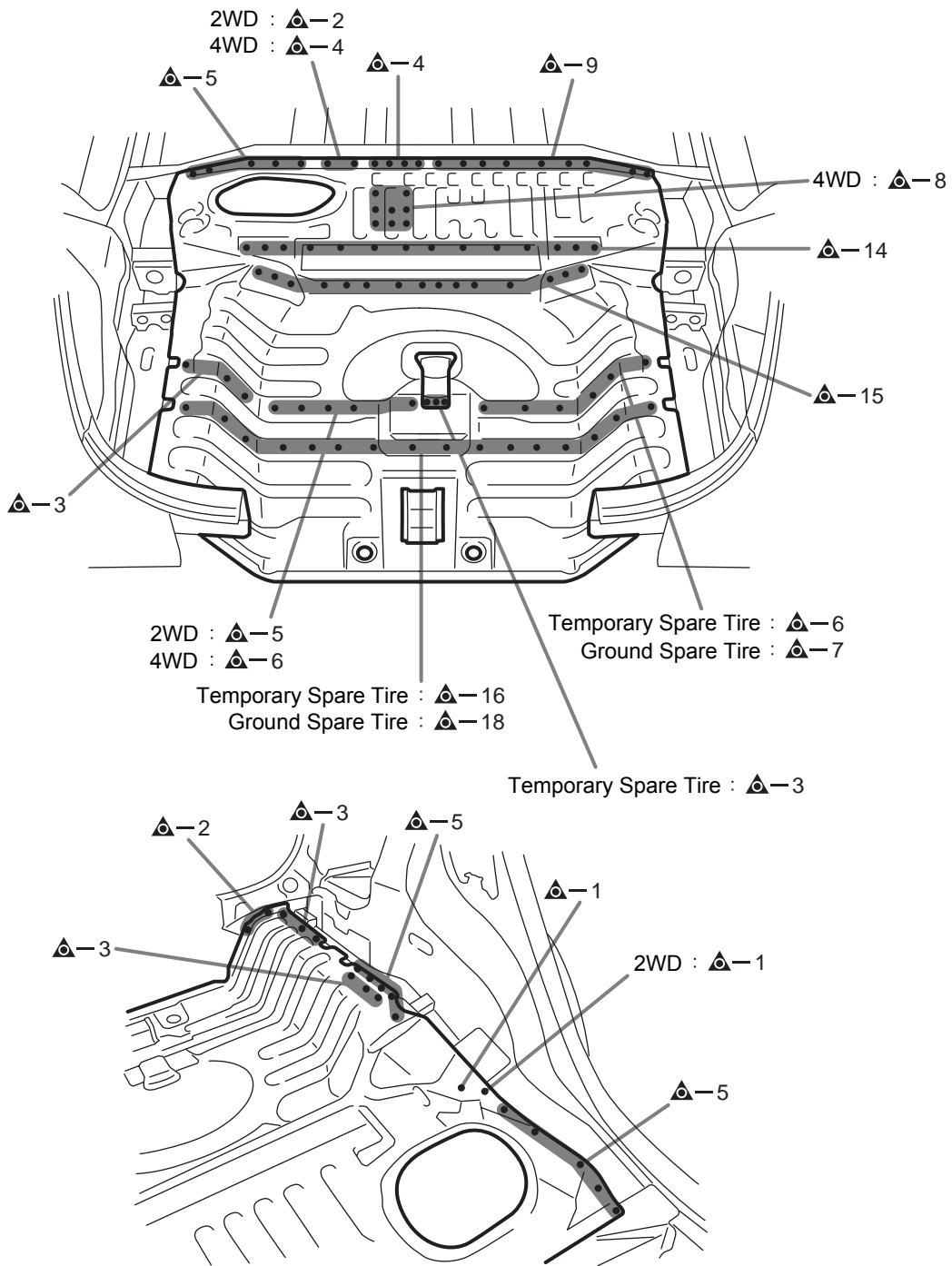
With the body lower back panel and rear floor side panel and rear floor crossmember reinforcement No. 2 removed.

Symbol meaning

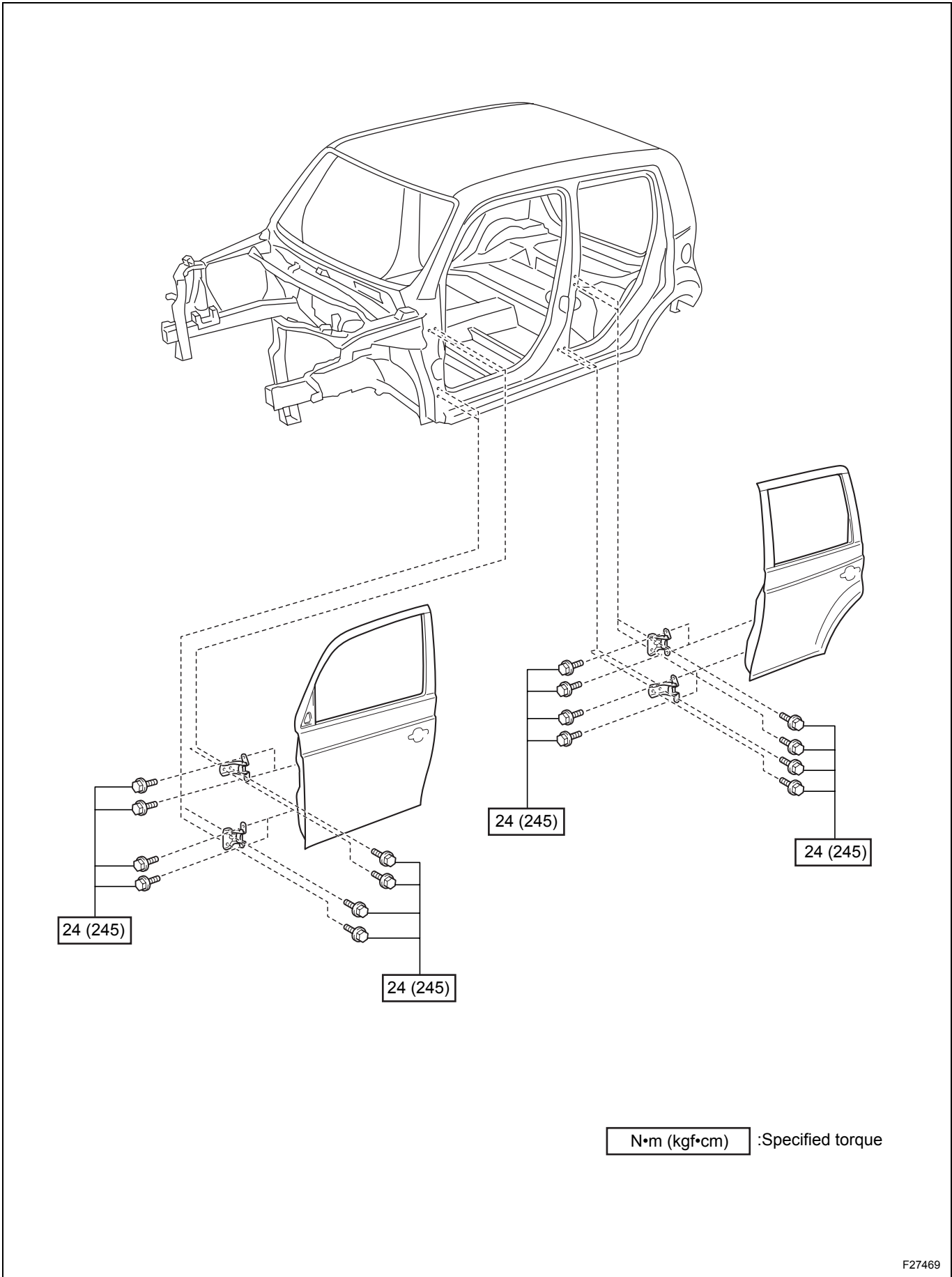
▲ : Remove Weld Points

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REMOVAL



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24 (245)

24 (245)

24 (245)

24 (245)

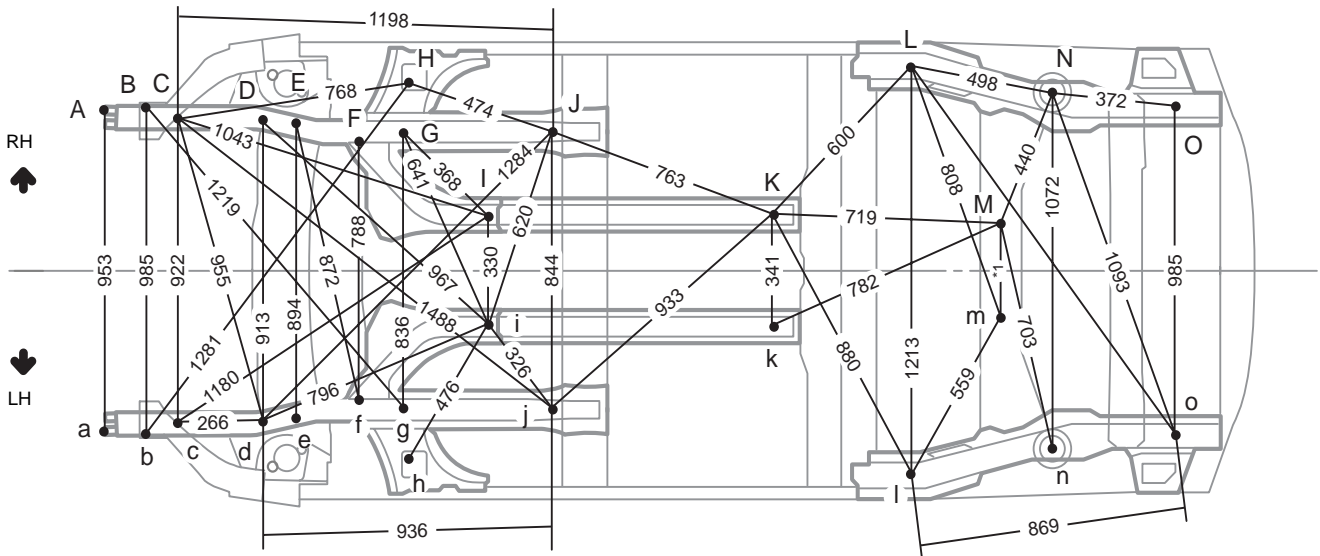
N•m (kgf•cm) :Specified torque

4. UNDER BODY

MODEL NAME	MATERIA	Date made	oct.,2006
Applicable models	M401LS,M402LS,M402RS		

[Three-Dimensional Distance]

B-G,b-g	E-F,e-f	D-E,d-e	D-e,d-E	F-G,f-g	F-g,f-G	H-i,h-l	H-j,h-J	H-h	L-n,l-N
813	237	116	911	150	825	776	1090	1140	1244

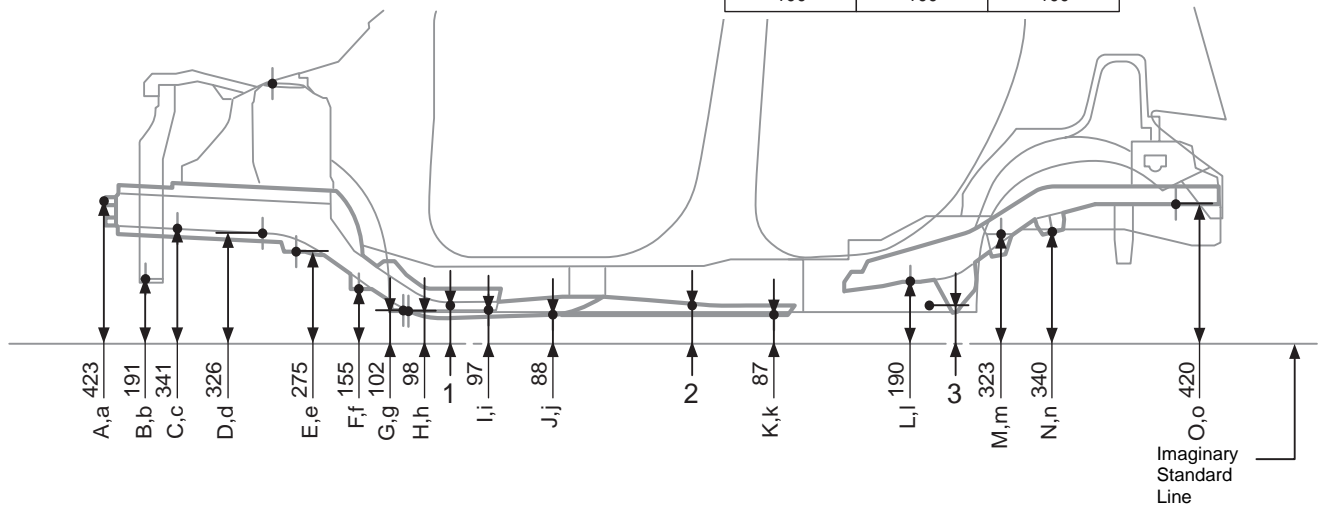


*1
280

Wheel base	2540
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1	2	3
100	100	100

Front

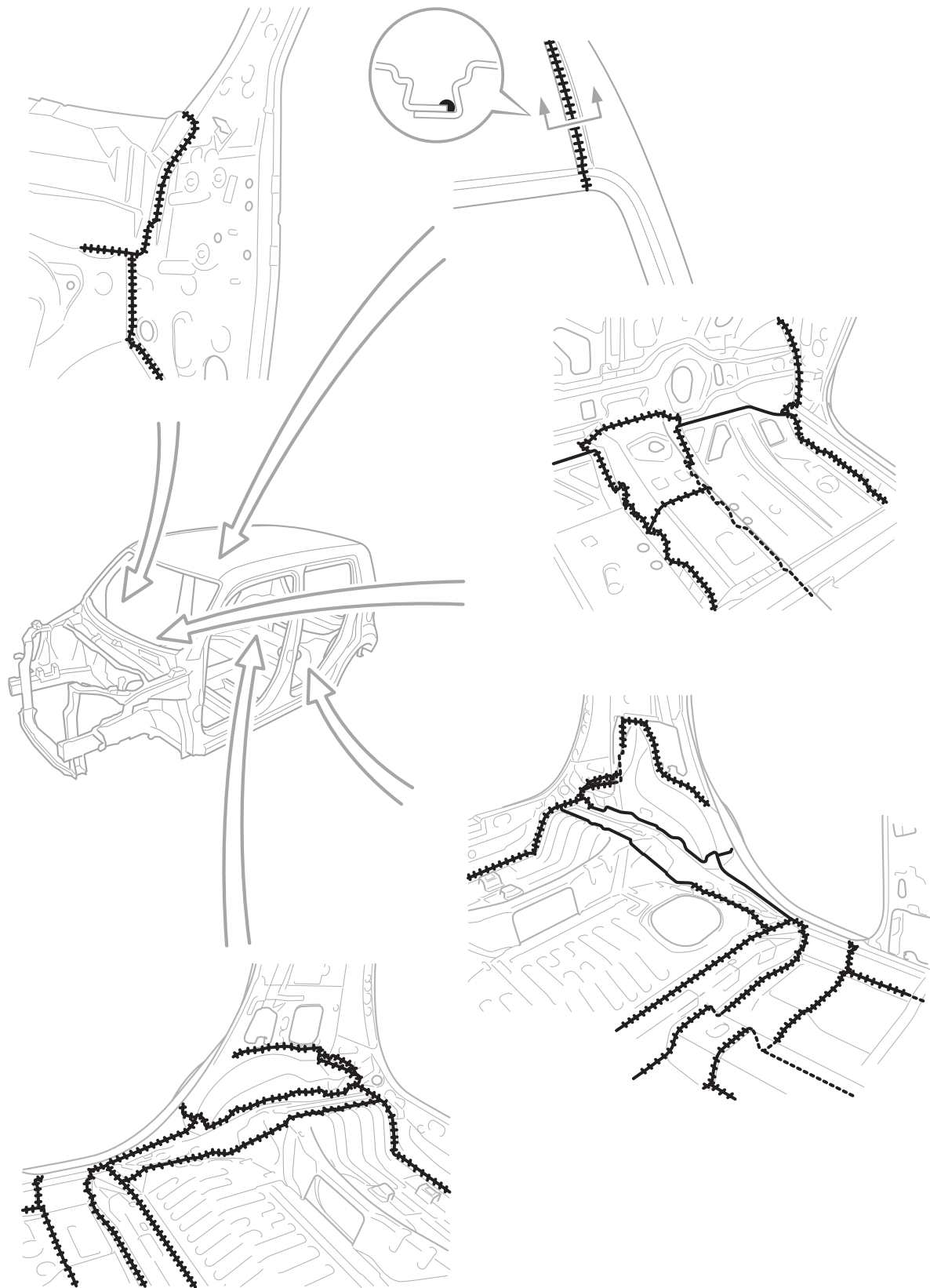


(Note) Symmetrical if dimensions are shown on either side only.

Unit: mm

Symbol	Name	Hole dia.	H, h	Torque box front standard hole	ø10
A, a	Front bumper reinforcement installation bolt	M8bolt	I, i	Front side member standard hole	ø10
B, b	Radiator lower support installation nut	M6nut	J, j	Front side member standard hole	ø18
C, c	Front side member standard hole	ø15	K, k	Front floor under reinforcement standard hole	ø10
D, d	Front side member standard hole	ø15	L, l	Rear floor side member standard hole	ø15
E, e	Front suspension crossmember installation nut	M12nut	M, m	Rear floor crossmember standard hole	ø15
F, f	Front suspension crossmember installation nut	M12nut	N, n	Bumnd stopper installation nut	M8nut
G, g	Front suspension crossmember brace installation nut	M10nut	O, o	Rear floor side member standard hole	ø20

2. INSIDE



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