

REPAIRING HIGH STRENGTH STEEL

< REMOVAL AND INSTALLATION >

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High Strength Steel (HSS)

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High strength steel is used for body panels in order to reduce vehicle weight.

Accordingly, precautions in repairing automotive bodies made of high strength steel are described below:

Tensile strength	Nissan/Infiniti designation	Major applicable parts
373 N/mm ² (38 kg/mm ² , 54 klb/sq in)	SP130	<ul style="list-style-type: none">• Side dash• Front floor• Rear side member assembly• Other reinforcements• Inner center front bumper reinforcement
785 - 1350 N/mm ² (80 - 138 kg/mm ² , 114 - 196 klb/sq in)	SP150	<ul style="list-style-type: none">• Front side member assembly• Front side member closing plate assembly• Lower dash crossmember reinforcement• Lower dash crossmember assembly• Front side member rear extension (Front floor component part)• Inner sill• Inner center rear bumper reinforcement

SP130 is the most commonly used HSS.

SP150 HSS is used only on parts that require much more strength.

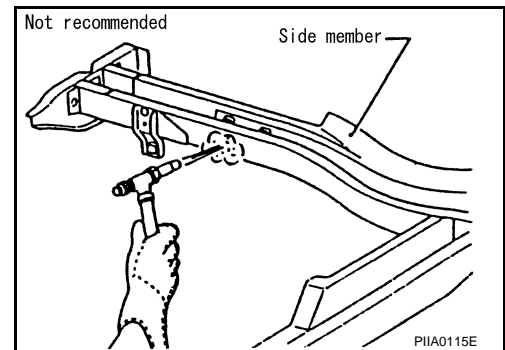
Read the following precautions when repairing HSS:

1. Additional points to consider

- The repair of reinforcements (such as side members) by heating is not recommended since it may weaken the component. When heating is unavoidable, do not heat HSS parts above 550°C (1,022°F).

Verify heating temperature with a thermometer.

(Crayon-type and other similar type thermometer are appropriate.)



- When straightening body panels, use caution in pulling any HSS panel. Because HSS is very strong, pulling may cause deformation in adjacent portions of the body. In this case, increase the number of measuring points, and carefully pull the HSS panel.

