



SHANGHAI GM

SGM 710 (H-car)

LEGEND OF SYMBOL

2007.8.22



Seal P.N.= 9984272



Seal P.N.= 9985865



Seal P.N.= 9984273

***Notes : Actual sealer position pls refer to mathdata :**

AHE09522_001.0002_GEO_FIN001

AHE14633_001_GEO_FIN001

AHE15653_001_GEO_FIN001



SHANGHAI GM

SGM 710 (H-car)

U/B Engine Room

2007.8.22

P.N.9984272

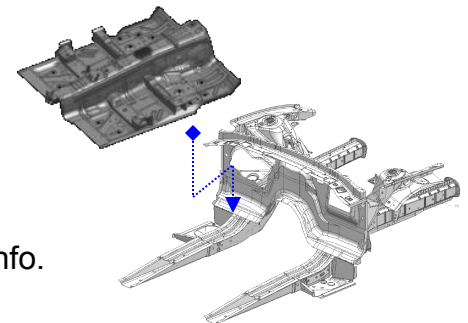
Length:1698mm+/-10mm

Diameter : 7mm+/-1mm

SEALER-DA PNL (TO FLR PNL) 1C 2K
0215B

Along the length
edge to edge 6+/-2mm

Both RH and LH



Process info.



SHANGHAI GM

SGM 710 (H-car)

U/B Rear Compartment

2007.8.22

P.N.9984272

Length:1695mm+/-10mm

Diameter : 7mm+/-1mm

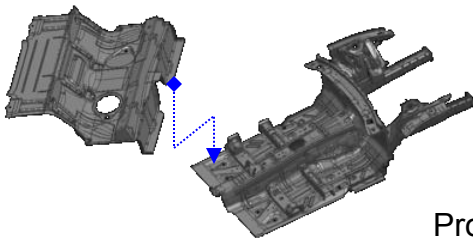
1C 1K 1480A SEALER-F/FLR PNL (TO R/FLR PNL)

edge to edge 3+/-2mm

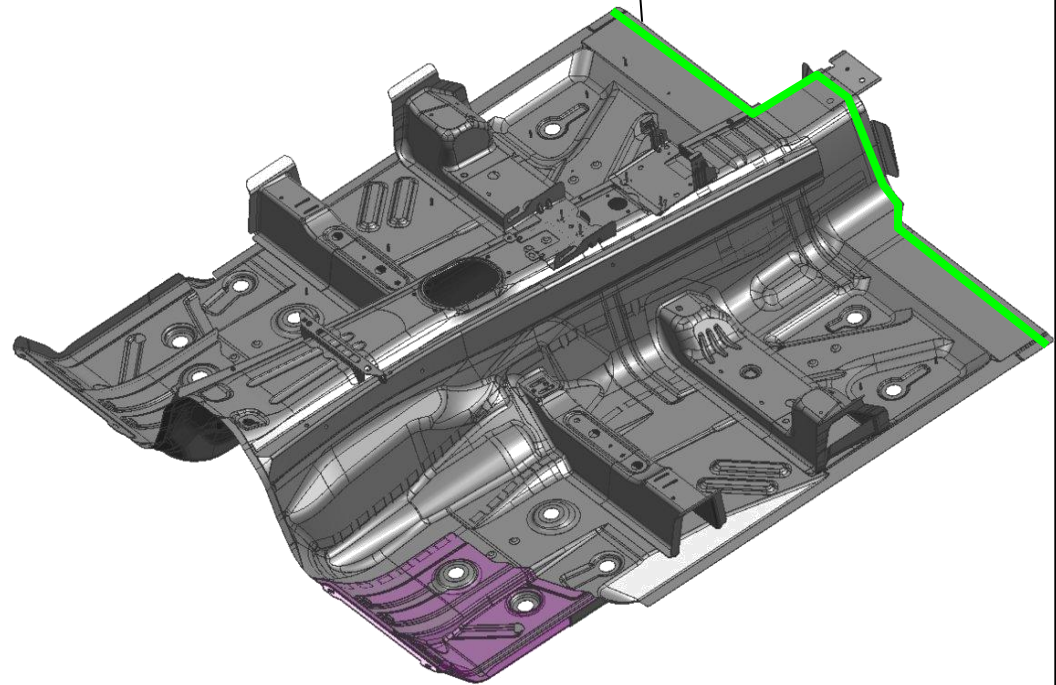
In this corner,
edge to edge 1+/-1mm
Other place 3+/-2mm

edge to edge 3+/-2mm

Both RH and LH



Process info.



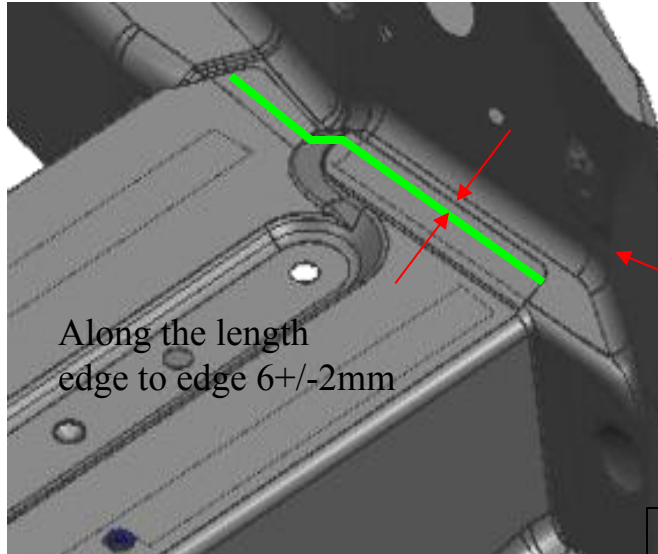


SHANGHAI GM

SGM 710 (H-car)

U/B Rear Compartment

2007.8.22



P.N.9984272

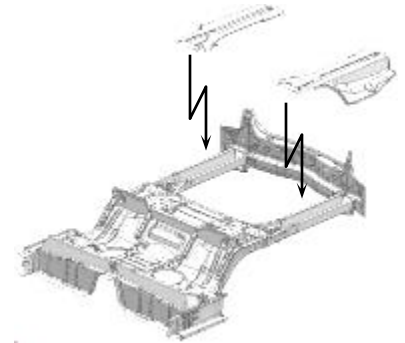
Length : 338mm+/-5mm

Diameter : 5mm+/-1mm

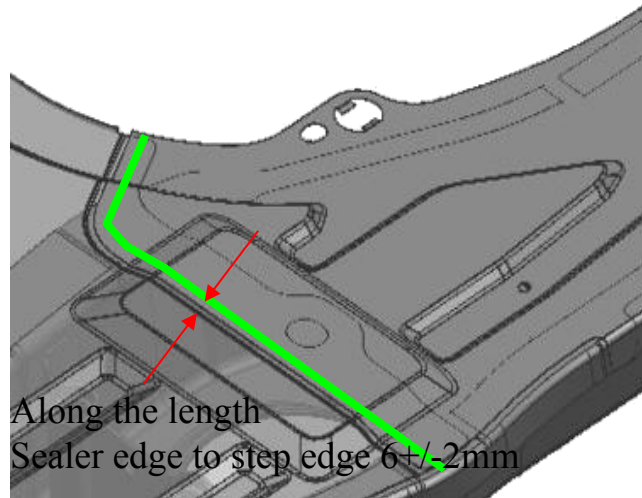
Both LH & RH

1C1K 2320B SEALER-R/CMPT FLR PNL EXTN
(TO R/END PNL)

Along the length
edge to edge 6+/-2mm



Process info.



P.N.9984272

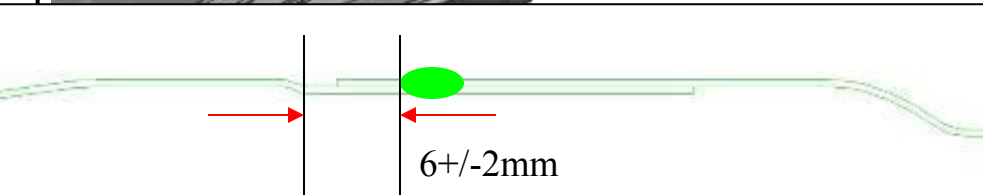
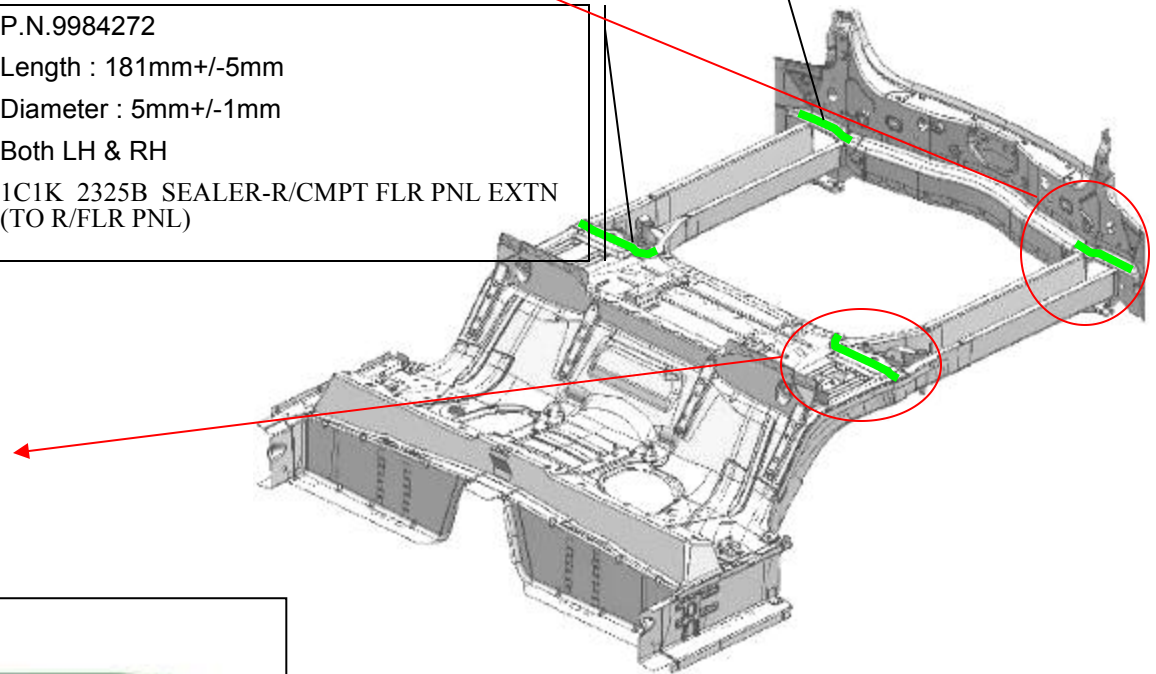
Length : 181mm+/-5mm

Diameter : 5mm+/-1mm

Both LH & RH

1C1K 2325B SEALER-R/CMPT FLR PNL EXTN
(TO R/FLR PNL)

Along the length
Sealer edge to step edge 6+/-2mm





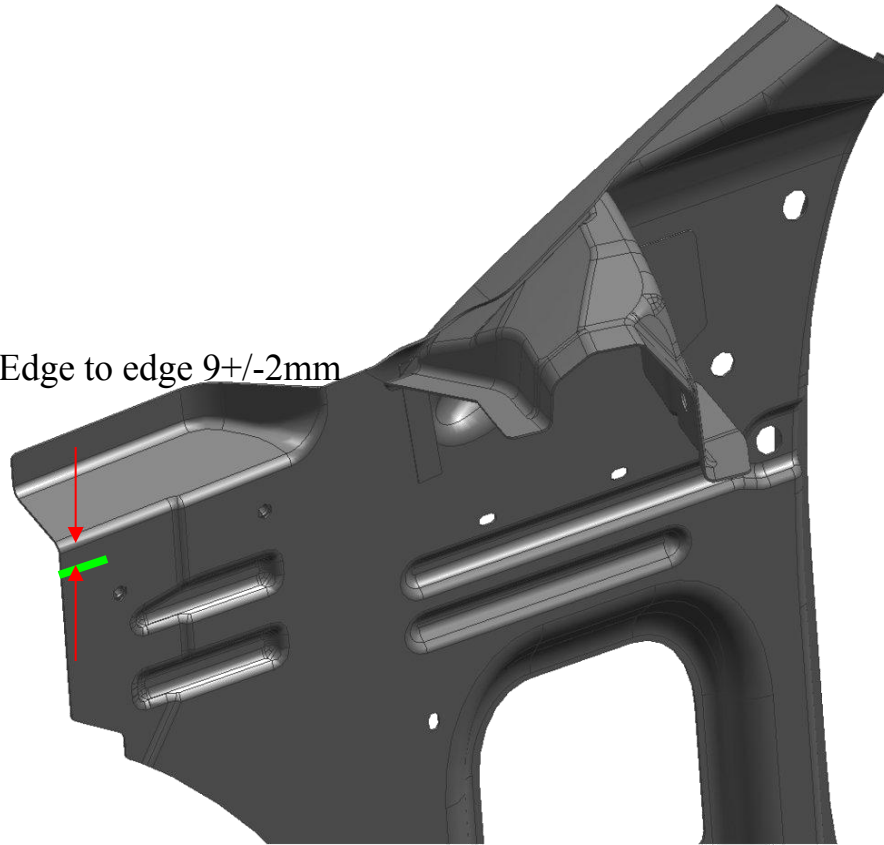
SHANGHAI GM

SGM 710 (H-car)

U/B Rocker INR

2007.8.22

Edge to edge 9+/-2mm



P.N.9984272

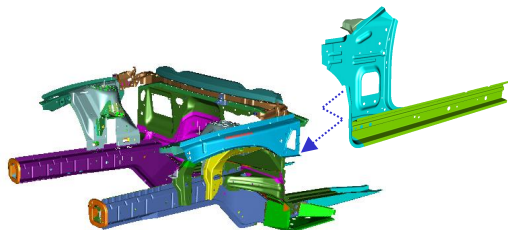
Length : 10+/-2mm

Diameter : 5+/-1mm

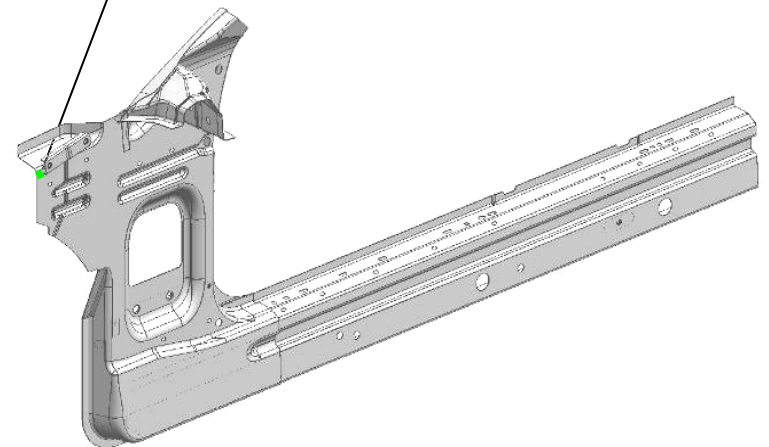
Both LH & RH

1C 2K 2565B SEALER-
BODY H/PLR (TO FRT W/H
PNL UPR INR S/RL)

Rkr inr to f/cmpt



Process info.



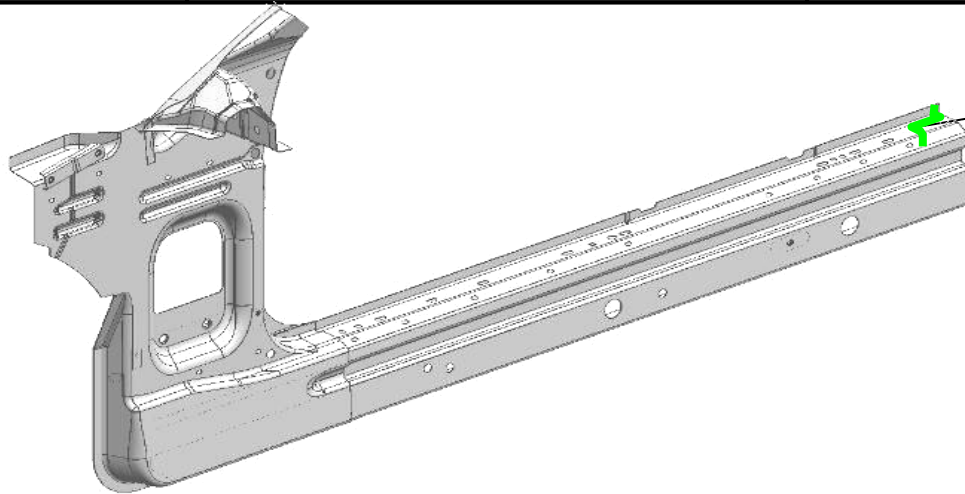


SHANGHAI GM

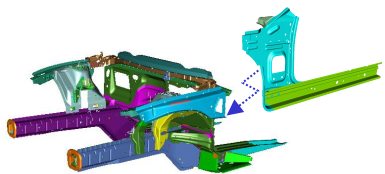
SGM 710 (H-car)

U/B Rocker INR

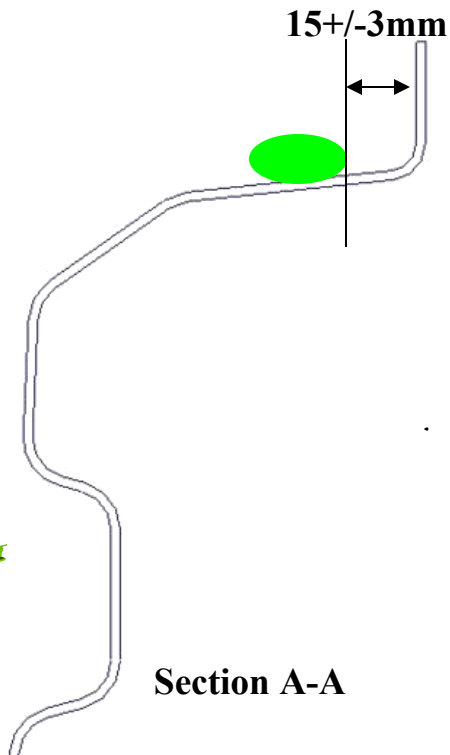
2007.8.22



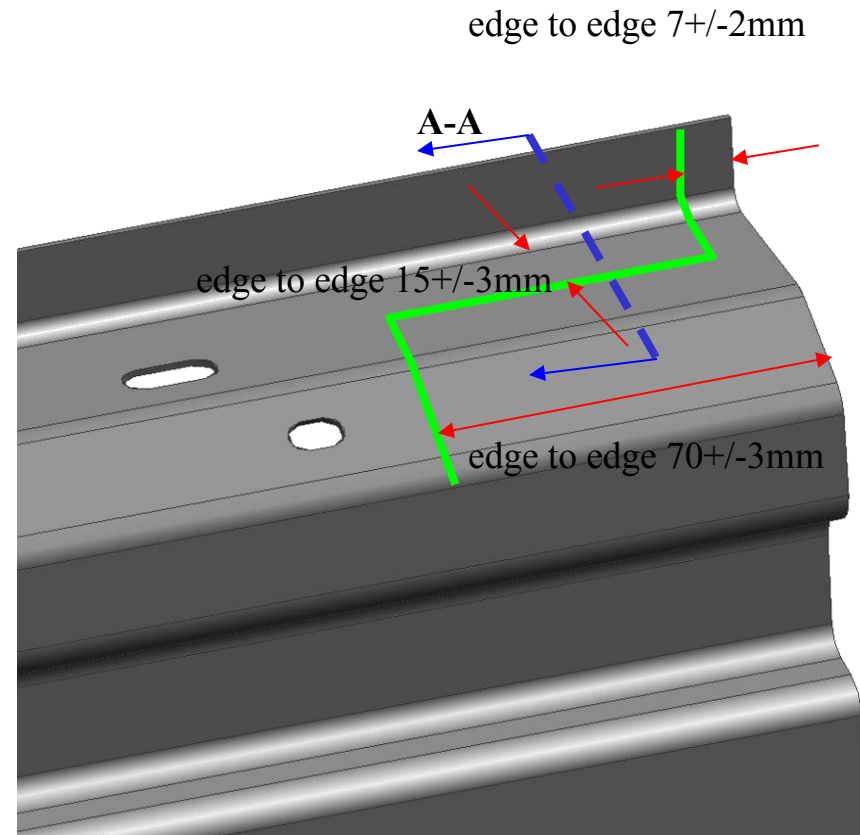
P.N.9984272
Length : 200+/-5mm
Diameter : 5+/-1mm
Both LH & RH
1C 1K 2700C
SEALER-RKR INR PNL (TO R/FLR PNL)



Process info.



Section A-A



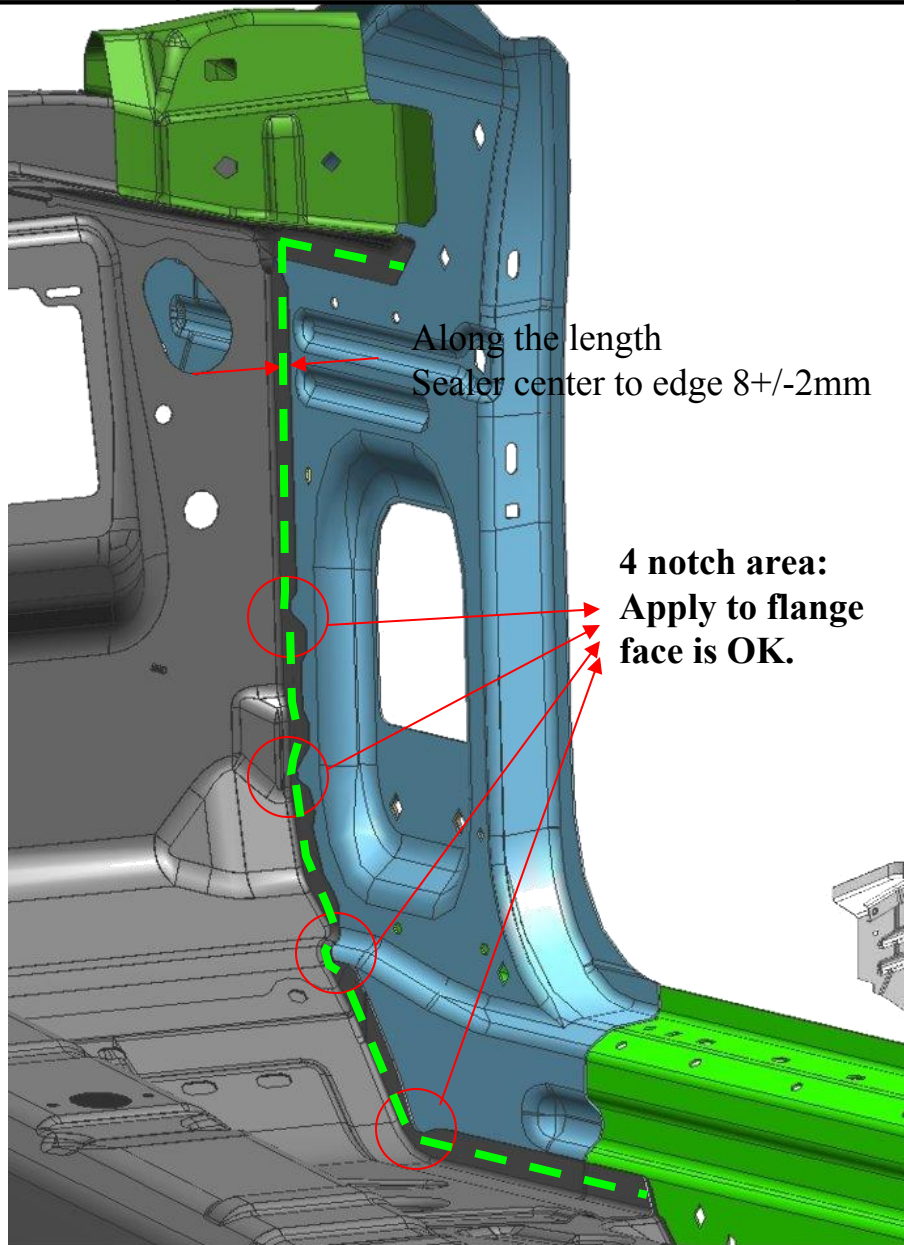


SHANGHAI GM

SGM 710 (H-car)

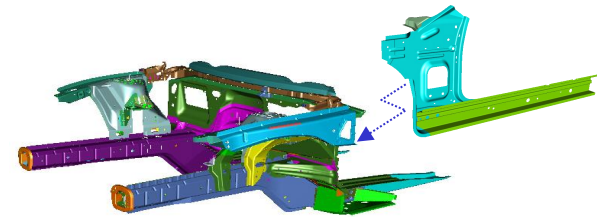
U/B Rocker INR

2007.8.22



Along the length
Sealer center to edge 8+/-2mm

4 notch area:
Apply to flange
face is OK.



Process info.

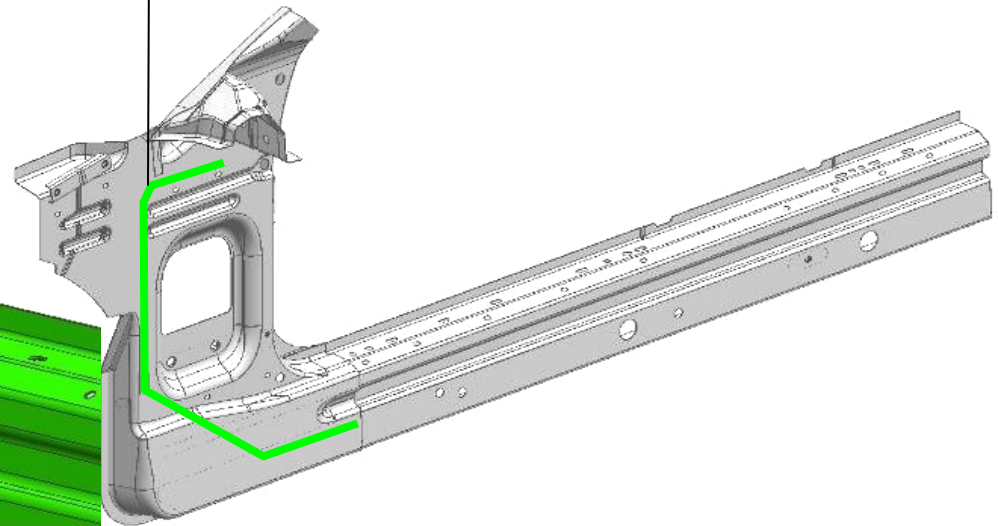
P.N.9984272

Length : 585mm+/-10mm

Diameter : 5+/-1mm

Both LH & RH

1C 2K 2600B SEALER-BODY H/PLR (TO DA PNL)



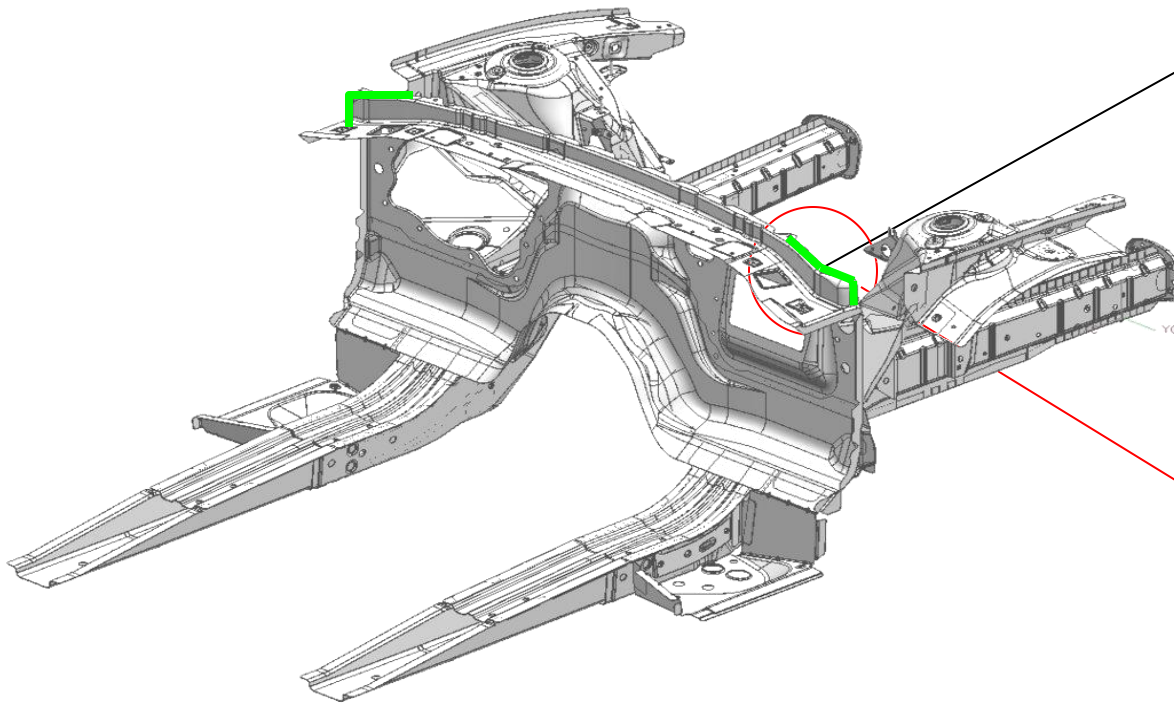


SHANGHAI GM

SGM 710 (H-car)

U/B Rocker INR

2007.8.22



P.N.9984272

Length : 220+/-5mm

Diameter : 7+/-1mm

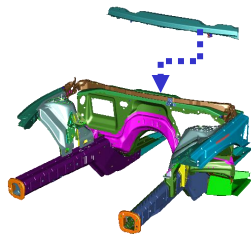
Both LH & RH

(In lower surf.)

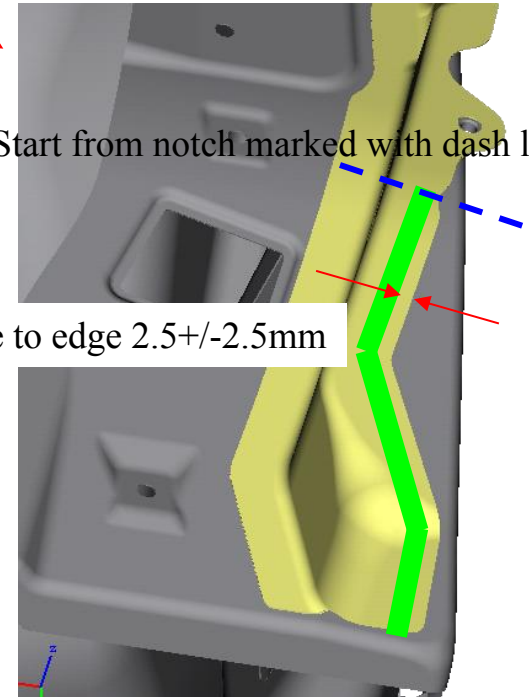
1C 2K 2630B SEALER-BODY
H/PLR (TO PLNM UPR PNL)

Start from notch marked with dash line

Edge to edge 2.5+/-2.5mm



Process info.





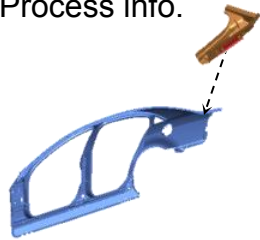
SHANGHAI GM

SGM 710 (H-car)

Side Gutter

2007.8.22

Process info.



Gutter to body si otr

25+/-3mm

Notch area:
Edge to edge 0~3mm

P.N.9984272

Length : 420+/-5mm

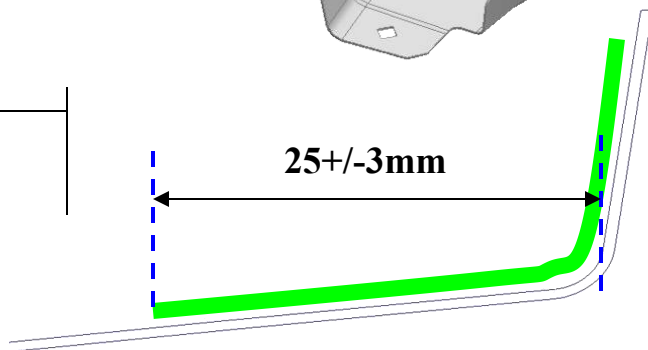
Diameter : 5+/-1mm

Both LH & RH

1C 4K 1915B SEALER-BODY SI OTR PNL (TO
BODY SI OTR PNL EXTN)

Edge to edge 4+/-2mm

25+/-3mm





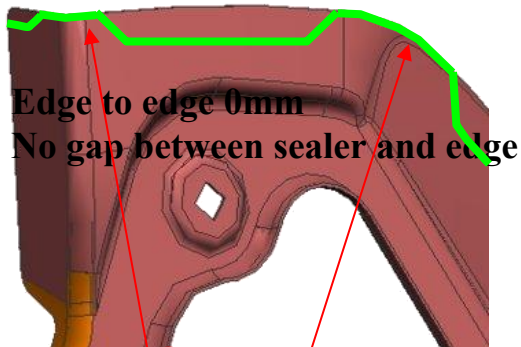
SHANGHAI GM

SGM 710 (H-car)

Side Tail Lamp Sub

2007.8.22

With body si otr



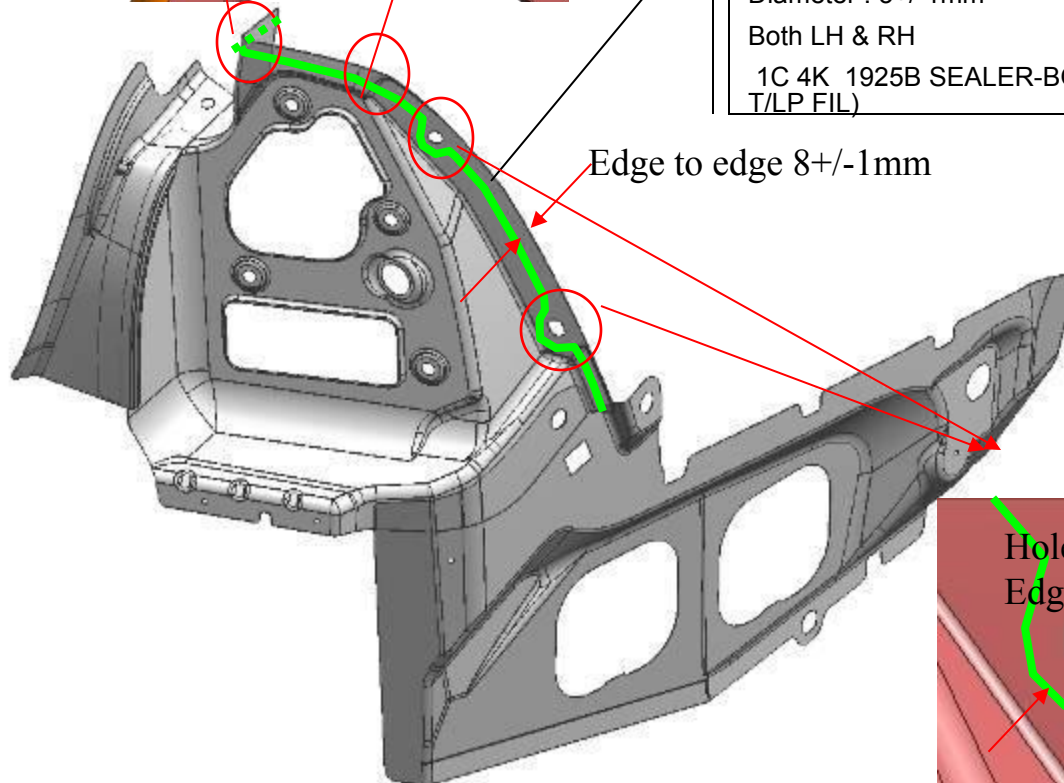
P.N.9984272

Length : 512+/-10mm

Diameter : 5+/-1mm

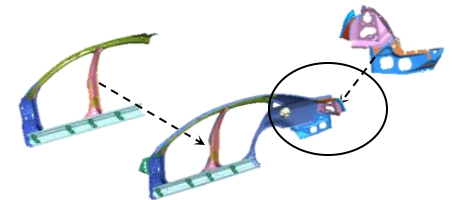
Both LH & RH

1C 4K 1925B SEALER-BODY SI OTR PNL (TO T/LP FIL)

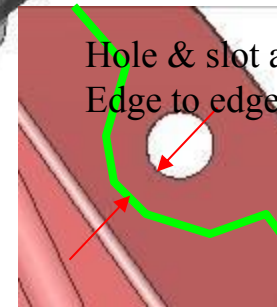


Edge to edge 8+/-1mm

Process info.



Hole & slot area:
Edge to edge 2+/-1mm



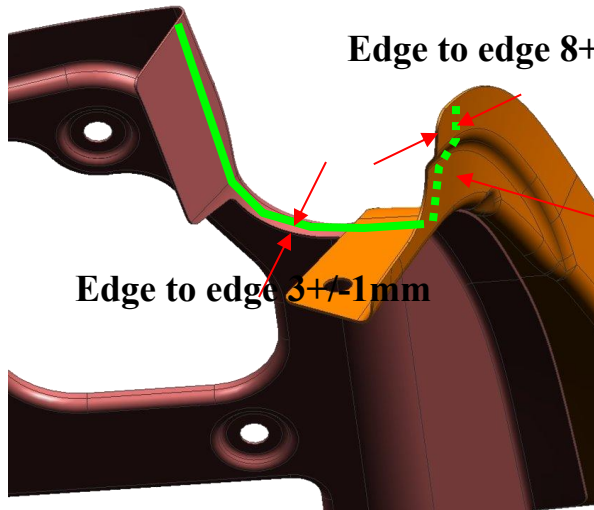


SHANGHAI GM

SGM 710 (H-car)

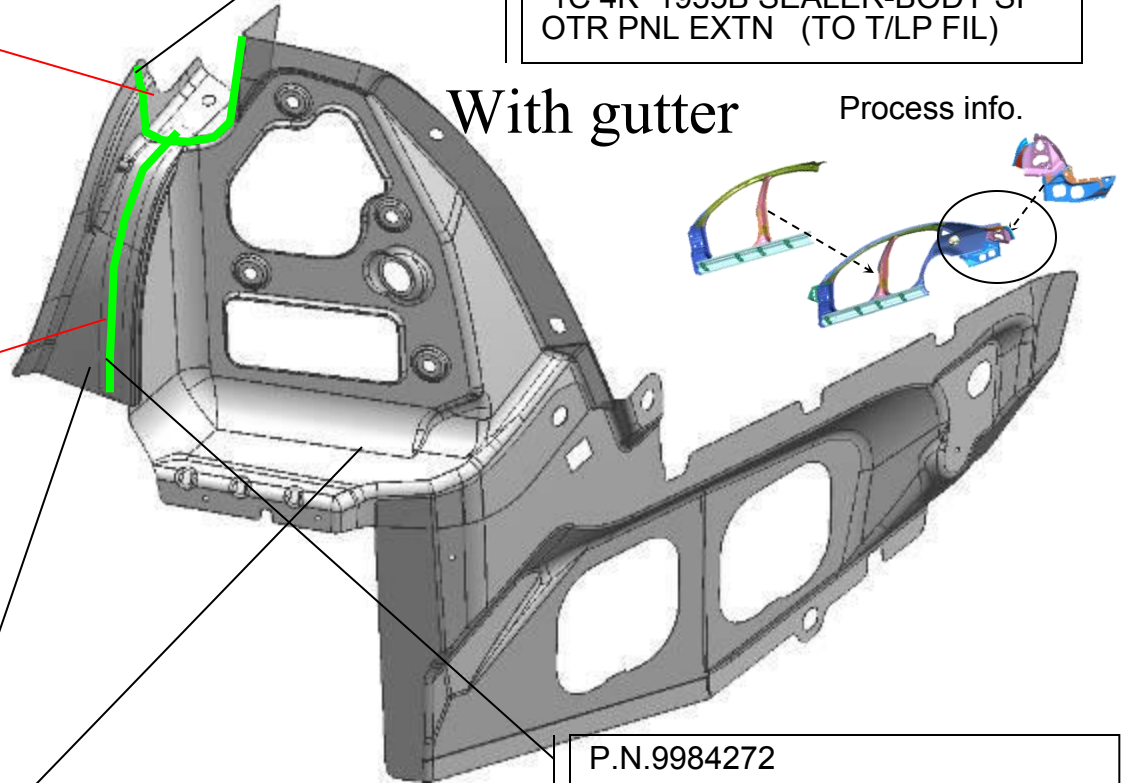
Side Tail Lamp Sub

2007.8.22



Edge to edge 8+/-1mm

Edge to edge 3+/-1mm



P.N.9984272

Length : 193+/-5mm

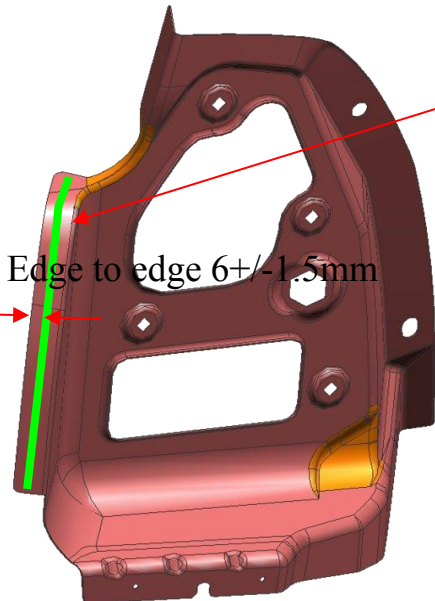
Diameter : 5+/-1mm

Both LH & RH

1C 4K 1955B SEALER-BODY SI
OTR PNL EXTN (TO T/LP FIL)

With gutter

Process info.



Edge to edge 6+/-1.5mm

This sealer should be between these 2 PNL

P.N.9984272

Length : 206+/-5mm

Diameter : 5+/-1mm

Both LH & RH

1C 4K 1955B SEALER-BODY SI
OTR PNL EXTN (TO T/LP FIL)



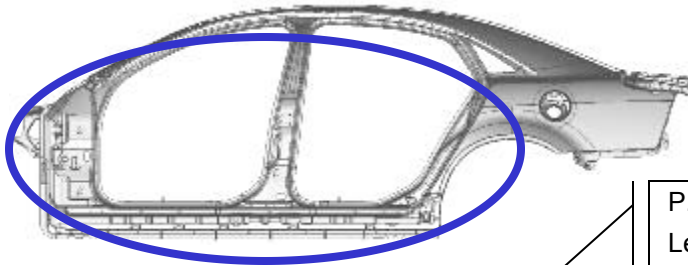
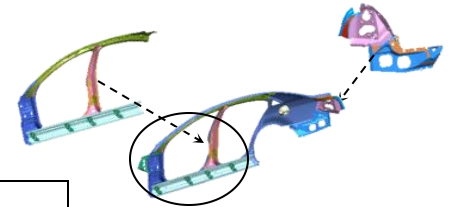
SHANGHAI GM

SGM 710 (H-car)

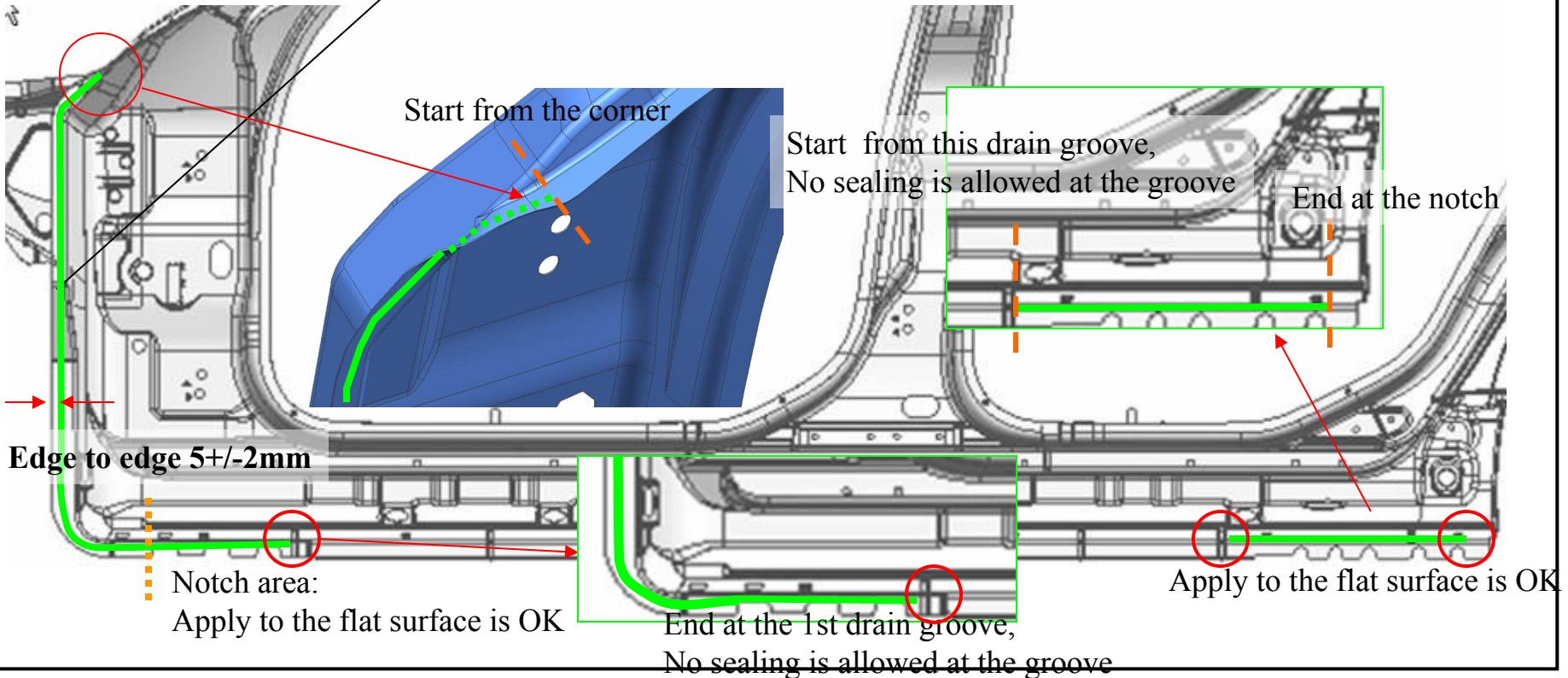
Side Otr Sub (GEO1)

2007.8.22

Process info.



P.N.9984272
Length : 1310+/-10mm
Diameter : 5+/-1mm
Both LH & RH
1C 4K 0001P SEALER-BODY SI (PUMPABLE)



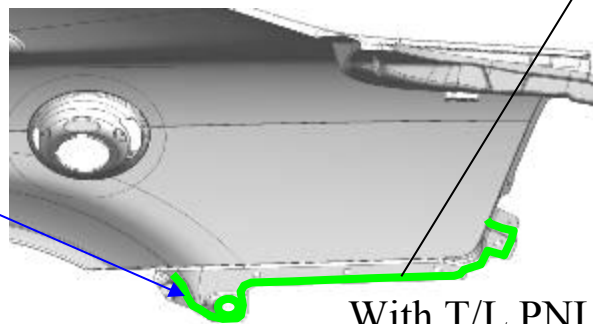
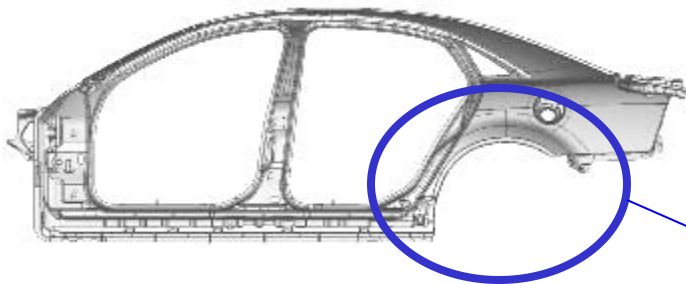


SHANGHAI GM

SGM 710 (H-car)

Side Otr Sub (GEO1)

2007.8.22



P.N.9984272

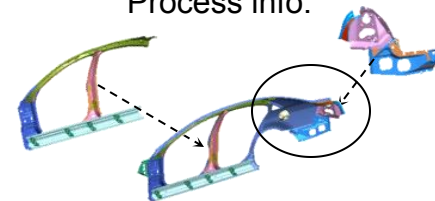
Length : 861+/-10mm

Diameter : 5+/-1mm

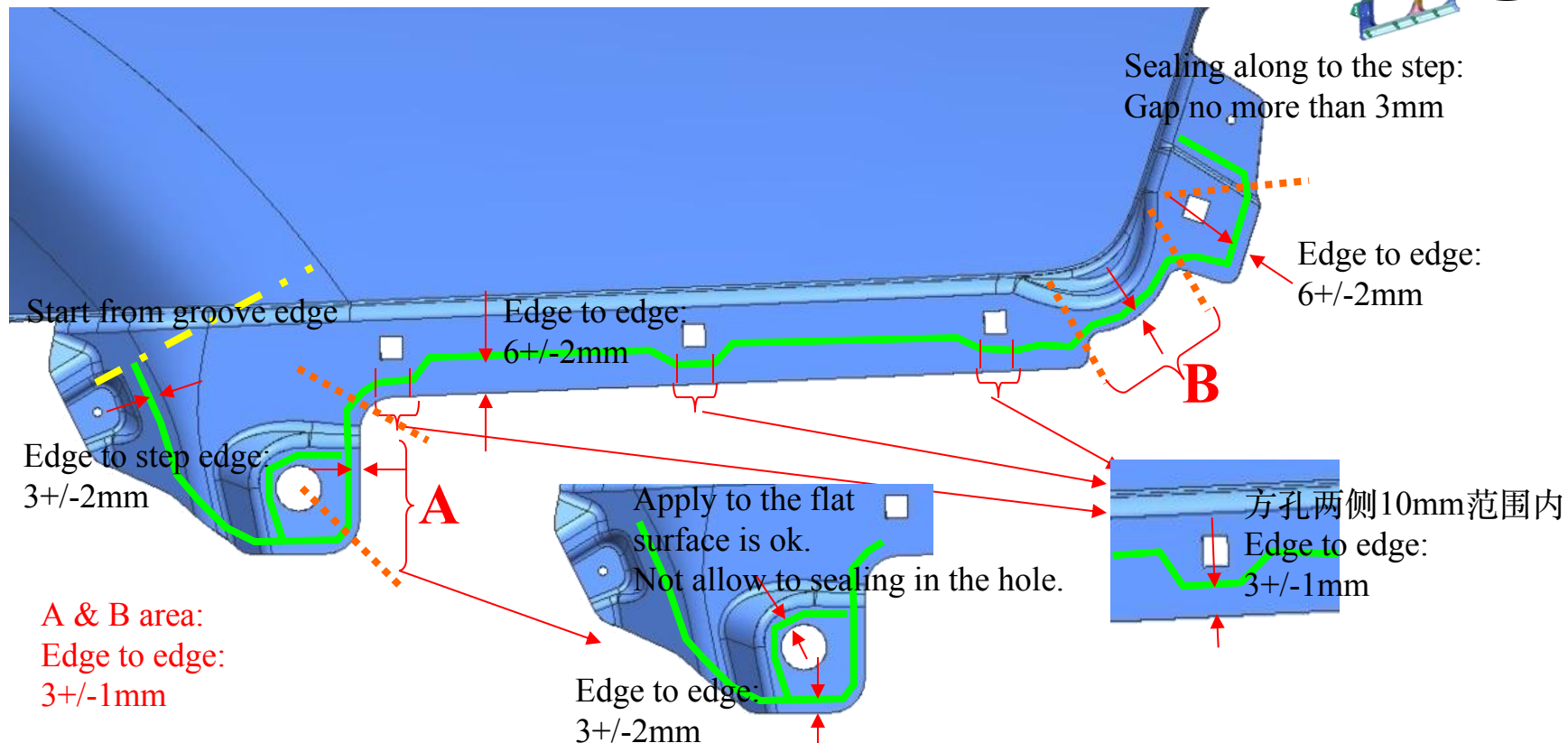
Both LH & RH

1C 4K 1925B SEALER-BODY SI
OTR PNL (TO T/LP FIL)

Process info.



With T/L PNL



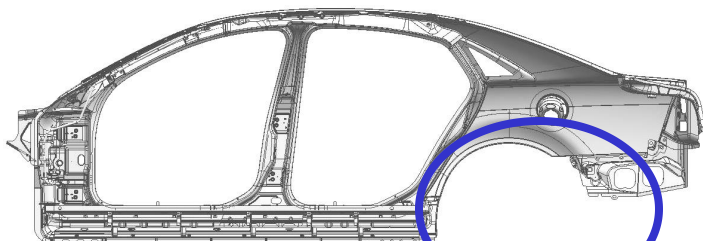


SHANGHAI GM

SGM 710 (H-car)

Side Otr Sub (GEO2)

2007.8.22



P.N.9984272

Length : 1568+/-10mm

Diameter : 6+/-1mm

Both LH & RH

1C 4K 0065B SEALER-BODY SI
FRM (TO RR W/H OTR PNL)

P.N.9984272

Length : 125+/-5mm

Diameter : 5+/-1mm

Both LH & RH

1C 4K 0065B SEALER-BODY SI
FRM (TO RR W/H OTR PNL)

Process info.

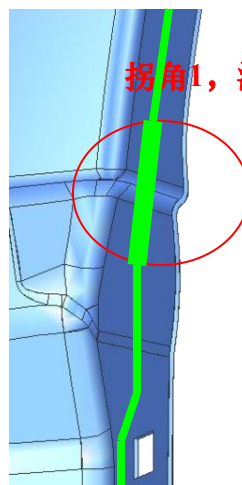


Area I:

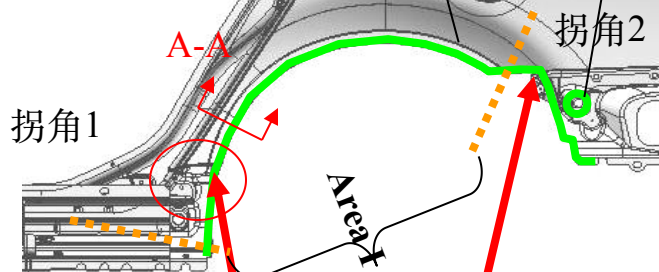
Along the length apply
Sealer To the flange surface

1+/-1 mm

Section A-A



拐角1, 涂胶直径加粗



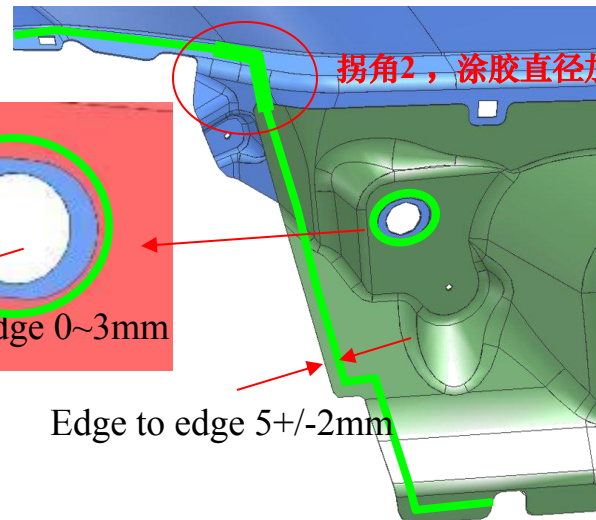
A-A

拐角1

拐角2

Area I

这2处拐角处涂胶直径加粗到10+/-1mm



拐角2, 涂胶直径加粗

Edge to edge 0~3mm

Edge to edge 5+/-2mm

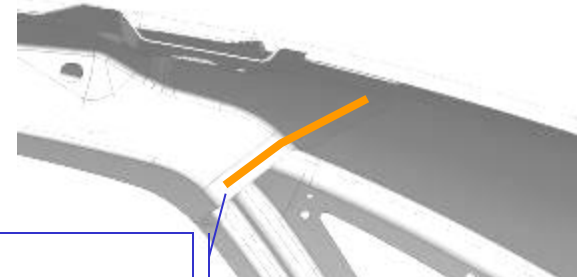
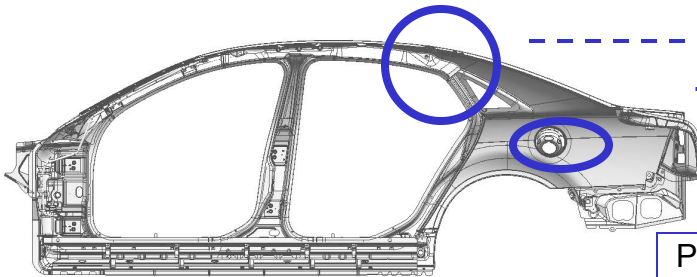


SHANGHAI GM

SGM 710 (H-car)

Side Otr Sub (GEO2)

2007.8.22



P.N. 9985865

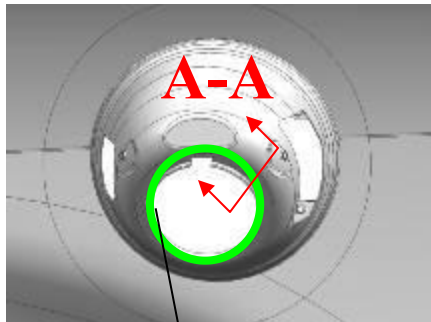
Length : 167+/-5mm

Diameter : 5+/-1mm

Both LH & RH

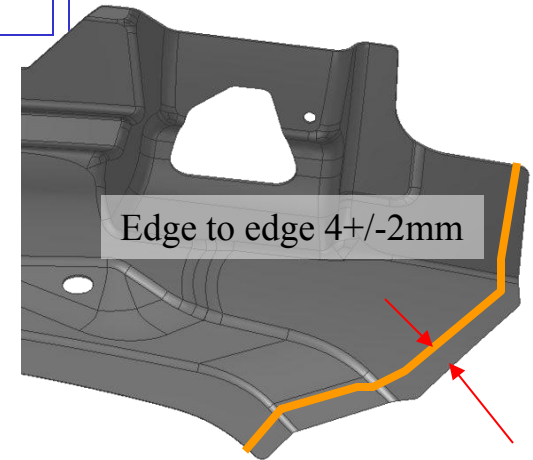
1C 4J 1955G ADHESIVE-BODY SI
OTR PNL REINF

This one should be
between reinforcement
with intr asm



Fuel Tank

9+/-1.5mm



Edge to edge 4+/-2mm

P.N.9984272

Length : 318+/-5mm

Diameter : 7+/-1mm

RH Only

8A 2279A SEALER-F/TNK FIL
PIPE HSG (TO QTR OTR PNL)

Section A-A

Process info.





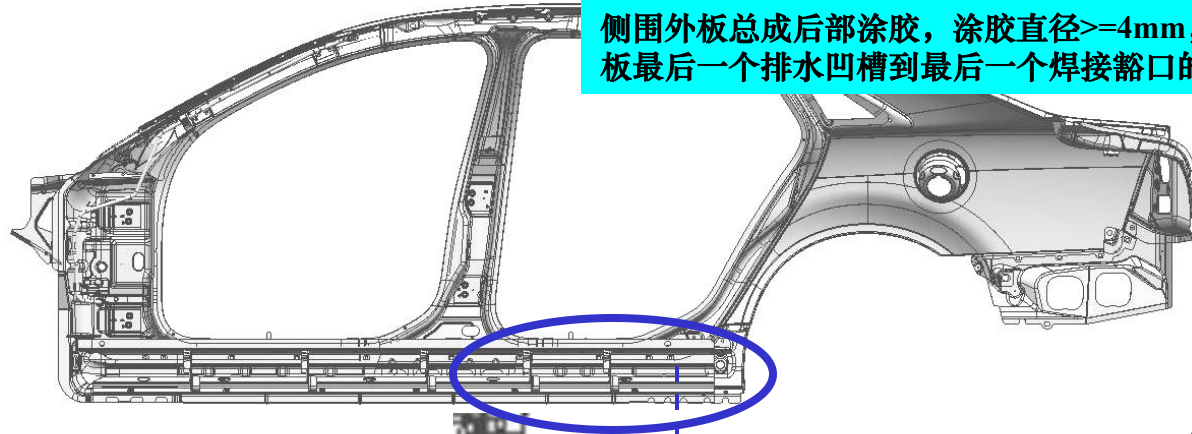
SHANGHAI GM

SGM 710 (H-car)

Side Otr Sub (GEO2)

2007.8.22

侧围外板总成后部涂胶，涂胶直径 $\geq 4\text{mm}$ ，高低位置在翻边中间，前后位置从侧围外板最后一个排水凹槽到最后一个焊接豁口的后边。



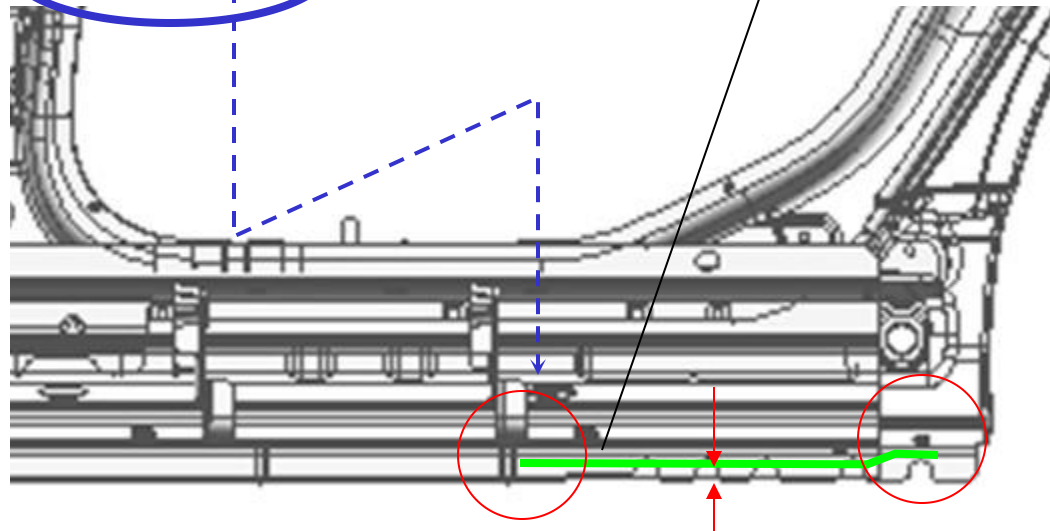
P.N.9984272

Length : $355 \pm 5\text{mm}$

Diameter : $5 \pm 1\text{mm}$

Both LH & RH

1C 4K 0001P SEALER-BODY SI (PUMPABLE)

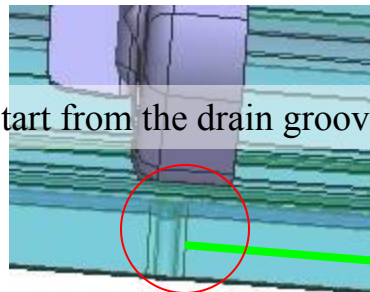


Edge to edge $6 \pm 2\text{mm}$

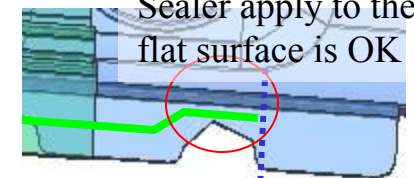
Process info.



Start from the drain groove



Notch area:
Sealer apply to the
flat surface is OK



End point



SHANGHAI GM

SGM 710 (H-car)

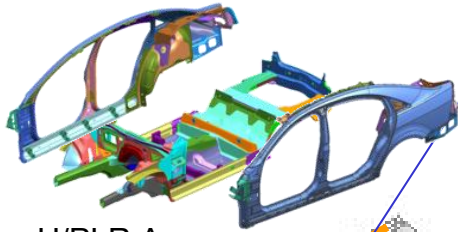
Fram Sealing (Side)

2007.8.22

Body si (with rkr inr)

Process info.

H/PLR Area



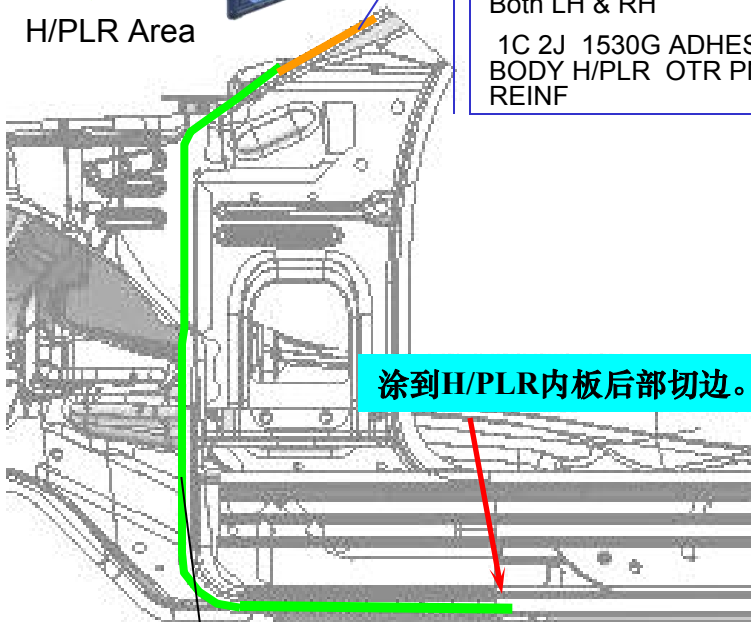
H/PLR Area

P.N. 9985865

Length : 230+/-5mm

Diameter : 5+/-1mm

Both LH & RH

1C 2J 1530G ADHESIVE-
BODY H/PLR OTR PNL LWR
REINF

涂到H/PLR内板后部切边。

P.N.9984272

Length : 885+/-10mm

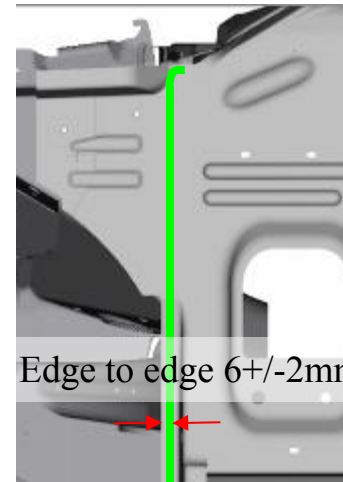
Diameter : 5+/-1mm

Both LH & RH

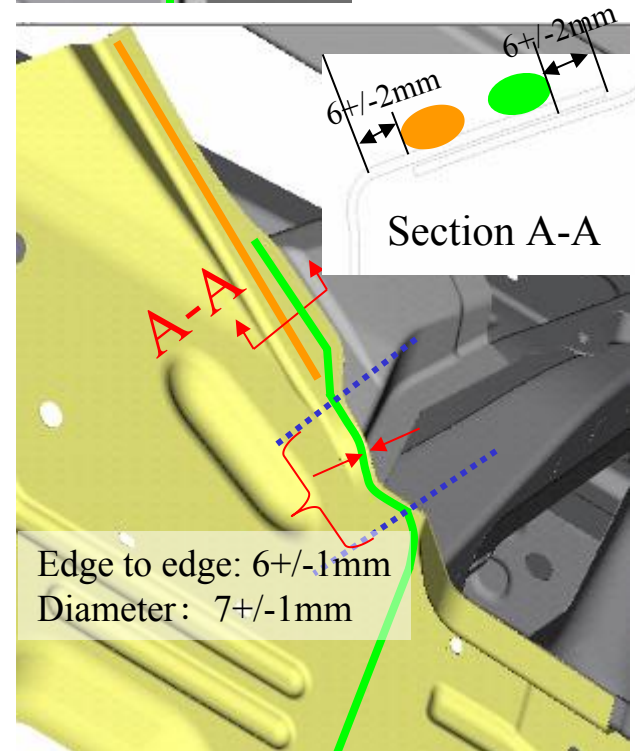
1C 2K 2552B SEALER-BODY H/PLR (TO BODY SI FRM)

The flange of the rocker extension also be pumped.

View A



Edge to edge 6+/-2mm



Section A-A

Edge to edge: 6+/-1mm

Diameter: 7+/-1mm



SHANGHAI GM

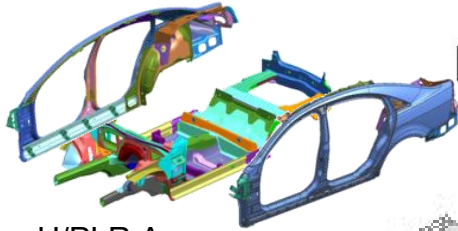
SGM 710 (H-car)

Fram Sealing (Side)

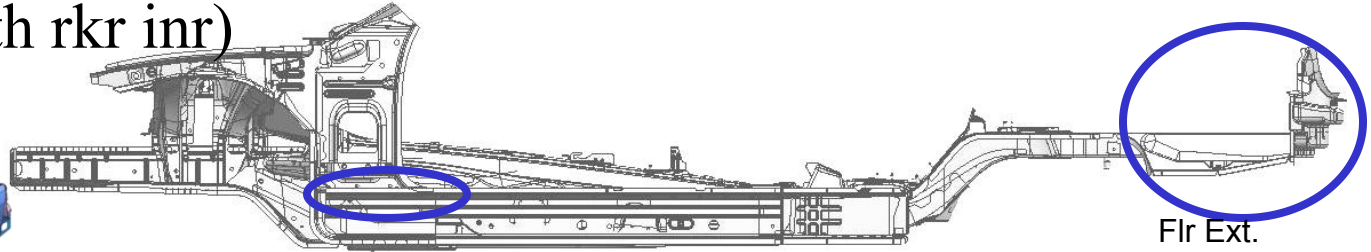
2007.8.22

Body si (with rkr inr)

Process info.



H/PLR Area



Flr Ext.

H/PLR Area

P.N. 9985865

Length : 383+/-5mm

Diameter : 5+/-1mm

Both LH & RH

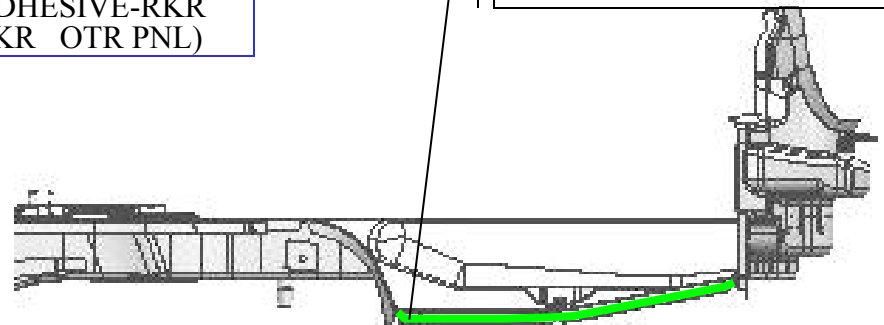
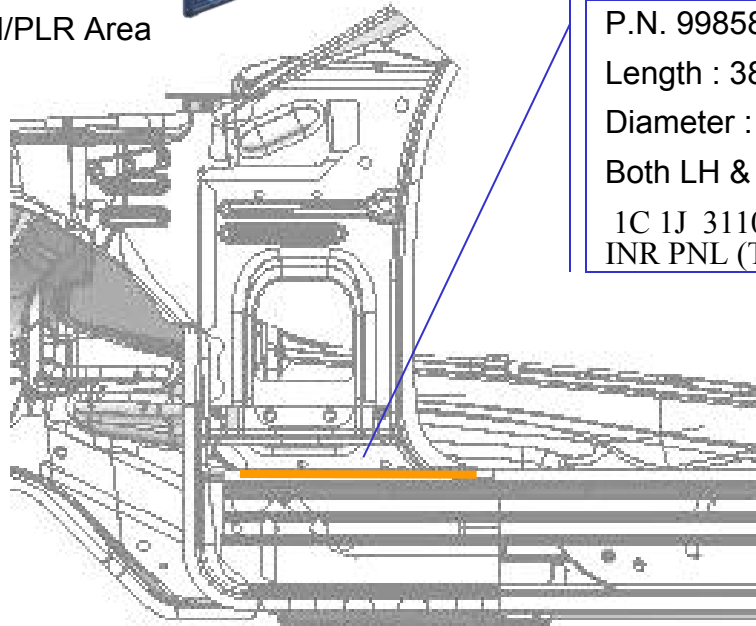
1C 1J 3110G ADHESIVE-RKR
INR PNL (TO RKR OTR PNL)

P.N.9984272

Length : 540+/-10mm

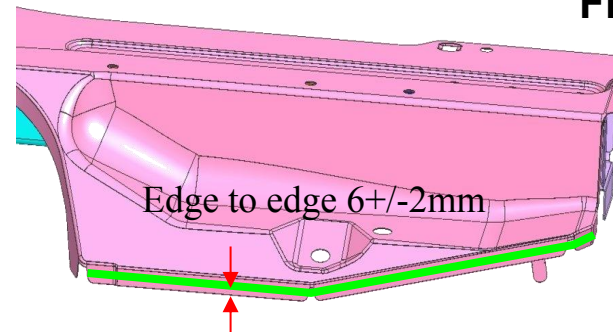
Diameter : 5+/-1mm

Both LH & RH

1C 1K 1700J SEALER-R/FLR
PNL (TO BODY RR LWR PNL)

Flr Ext.

Adhesive applied at flat surface is OK



Edge to edge 6+/-2mm

View A



SHANGHAI GM

SGM 710 (H-car)

Fram Sealing (Roof Area)

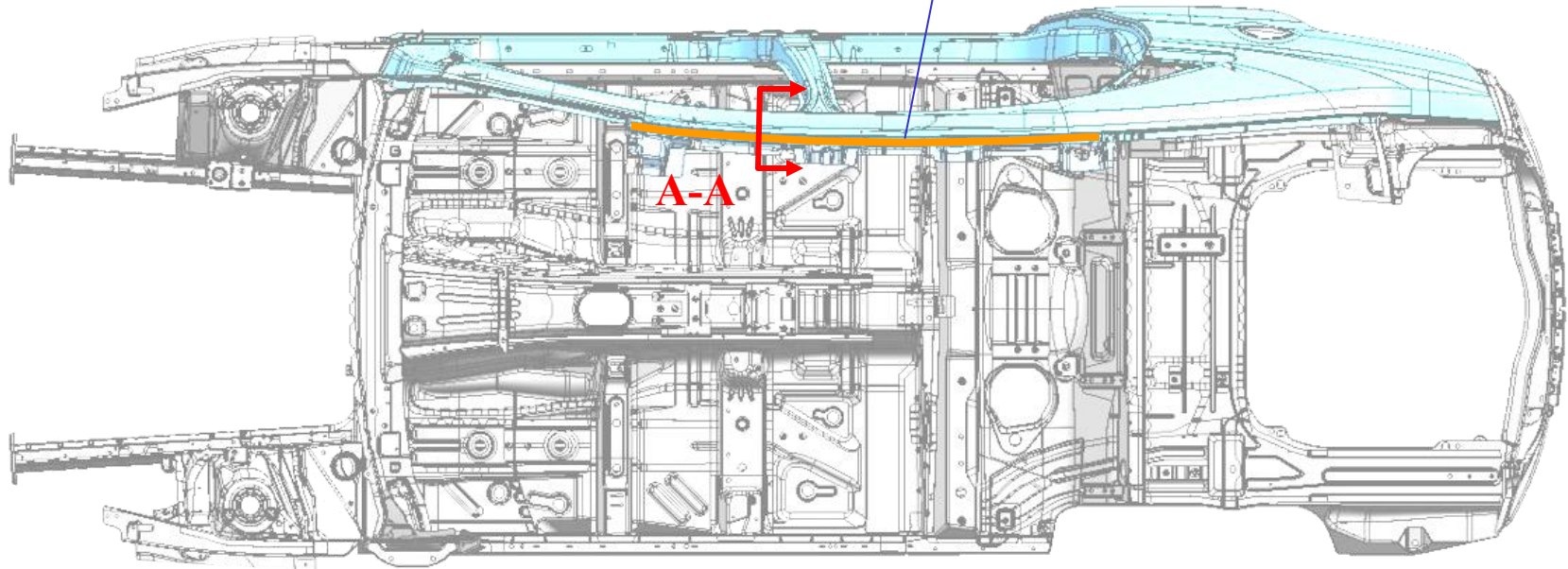
2007.8.22

P.N. 9985865

Length : 1370+/-10mm

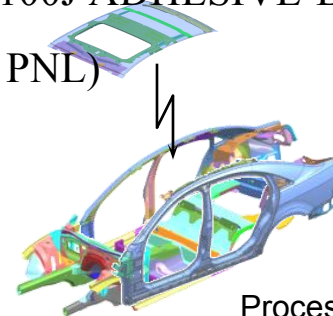
Diameter : 5+/-1mm

Both LH & RH



A-A

1C 4J 0100J ADHESIVE-BODY SI FRM
(TO RF PNL)



Process info.

1.5+/-1.5mm

Section A-A



SHANGHAI GM

SGM 710 (H-car)

Fram Sealing (Roof Area)

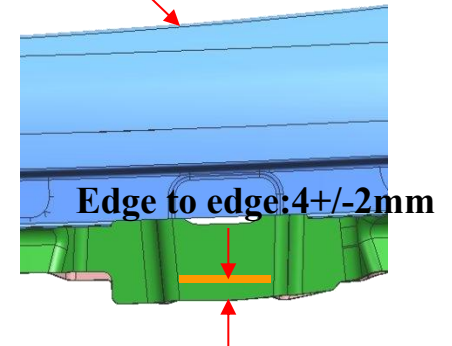
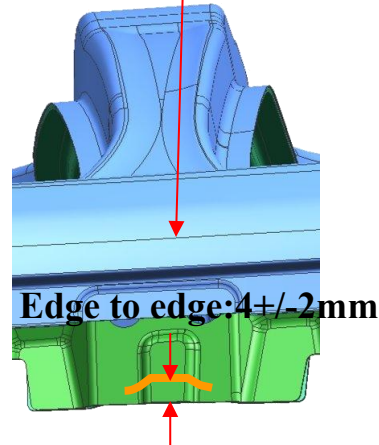
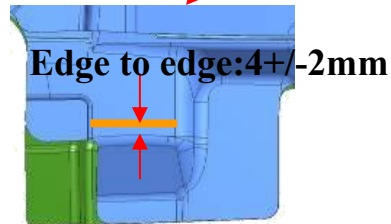
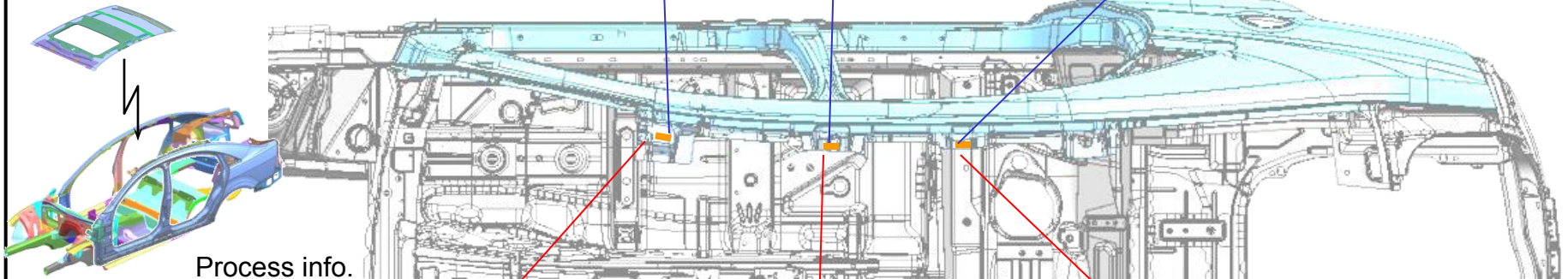
2007.8.22

1C 4J 0100J
ADHESIVE-BODY SI
FRM (TO RF PNL)

P.N. 9985865
Length : 58+/-5mm
Diameter : 5+/-1mm
Both LH & RH

P.N. 9985865
Length : 30+/-5mm
Diameter : 5+/-1mm
Both LH & RH

P.N. 9985865
Length : 25+/-5mm
Diameter : 5+/-1mm
Both LH & RH



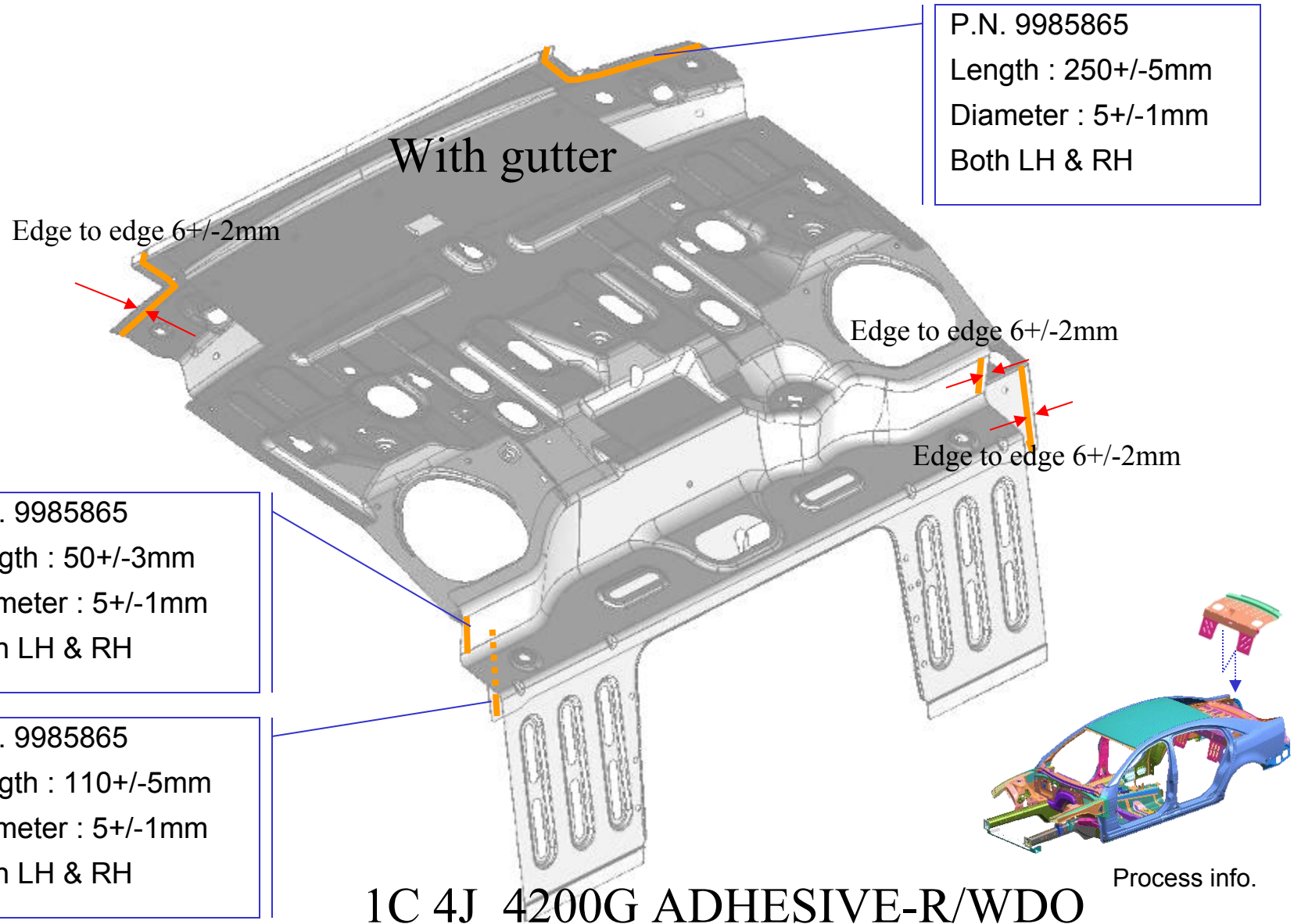


SHANGHAI GM

SGM 710 (H-car)

Fram Shelf

2007.8.22





SHANGHAI GM

SGM 710 (H-car)

Fram Resp STN.

2007.8.22

P.N.9984272

Length : 1383+/-10mm

Diameter : 7+/-1mm

1C 2K 4802B

SEALER-W/S FRM & PLNM PNL (TO PNL
PLNM FRT)

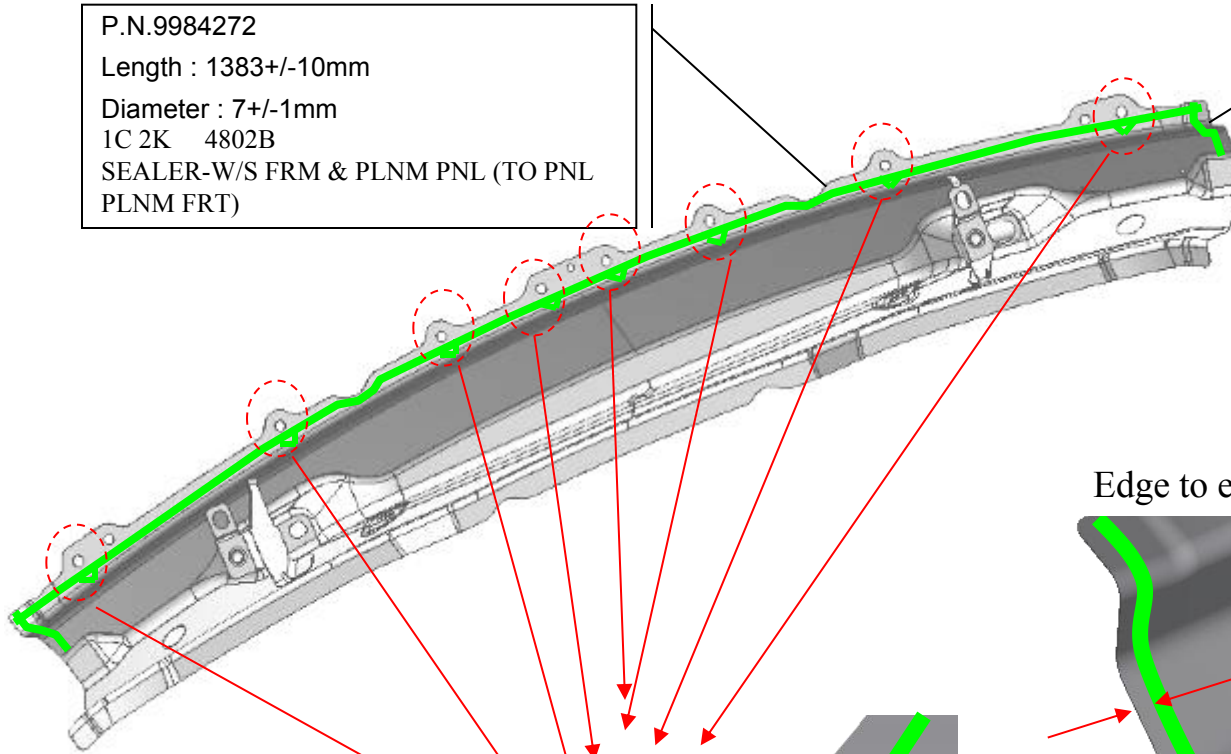
P.N.9984272

Length : 70+/-3mm

Diameter : 5+/-1mm

Both LH & RH 1C 2K 4803B

SEALER-W/S FRM & PLNM PNL
(TO PNL PLNM SI)
To RKR INR



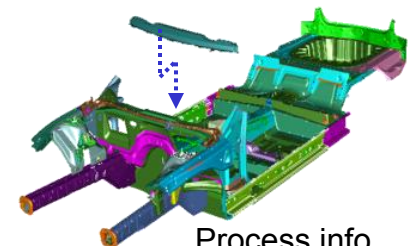
Edge to edge 2.5+/-2.5mm

Hole edge to sealer edge 7+/-1mm

Edge to edge 5+/-2mm

5498157

PANEL ASM-W/S FRM & PLNM
Q'TY=1



Process info.



SHANGHAI GM

SGM 710 (H-car)

Sun Roof

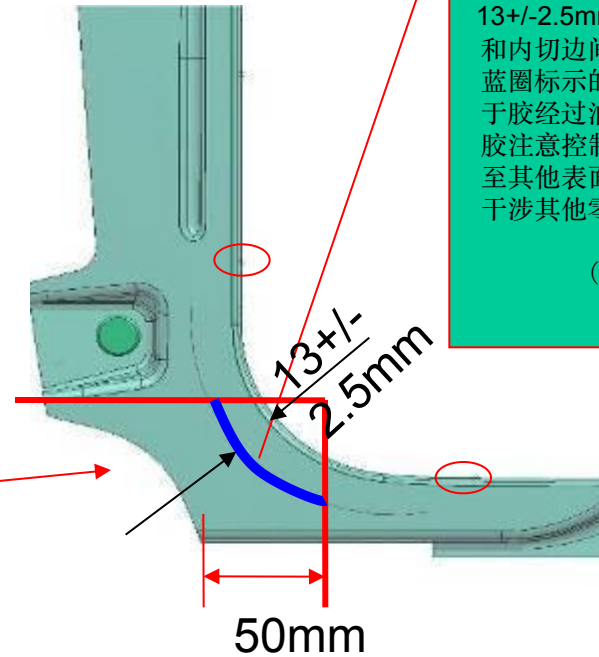
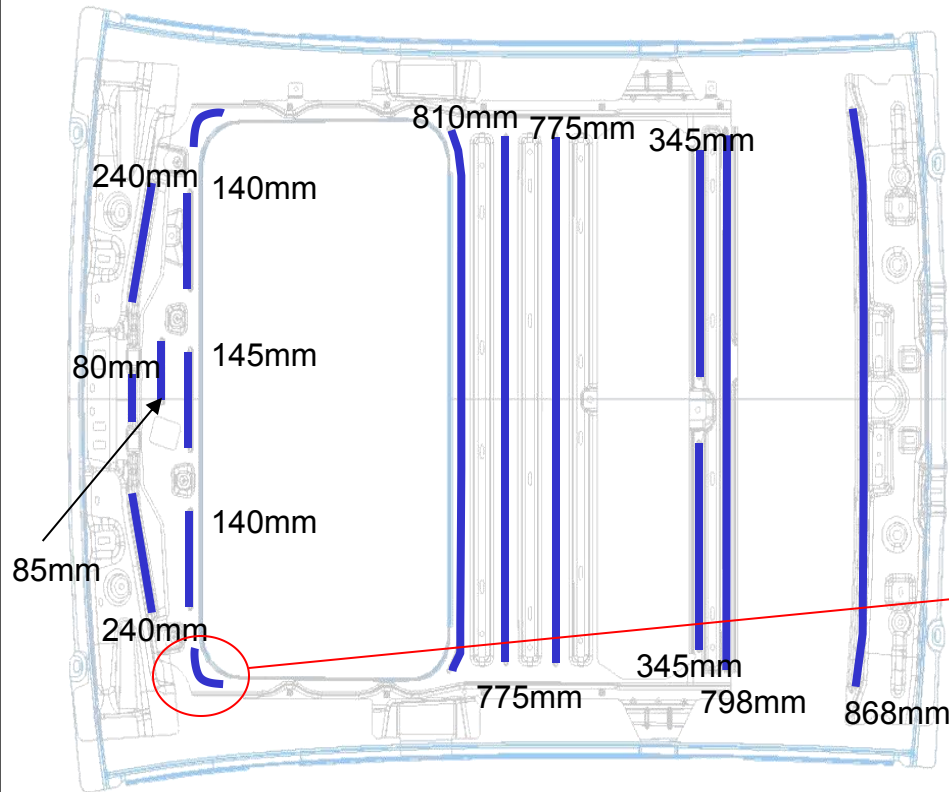
2007.8.22

P.N. 9984273

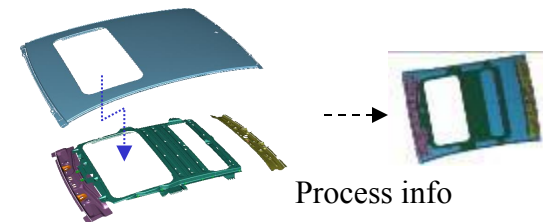
1C 3K 0110B SEALER-RF PNL

Diameter : 5+/-1mm

Sealer applied in guide tunnel is OK



涂胶长度50+/-5mm、涂胶直径5.0+/-1mm。涂胶距离内切边13+/-2.5mm（保持和原有涂胶和内切边间距不变），控制在蓝圈标示的两个焊点之间。由于胶经过油漆烘烤有膨胀，涂胶注意控制胶量，不要溢出流至其他表面，以免影响外观或干涉其他零件或膨胀造成钣金变形。（左右相同）





SHANGHAI GM

SGM 710 (H-car)

Roof

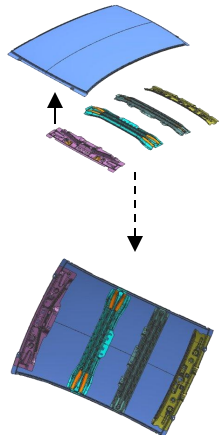
2007.8.22

P.N. 9984273

Diameter : 5+/-1mm

Sealer applied in guide tunnel is OK

1C 3K 0110B SEALER-RF PNL



Process info

