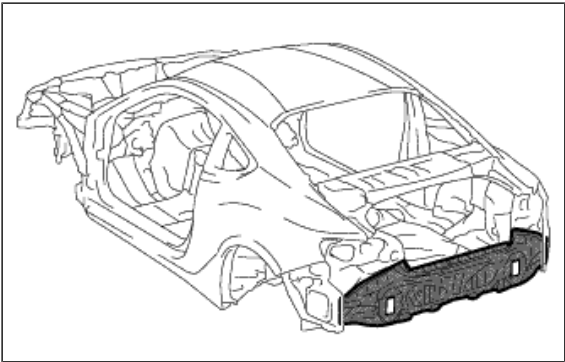


BODY LOWER BACK
PANEL > ASSEMBLY
REPLACEMENT

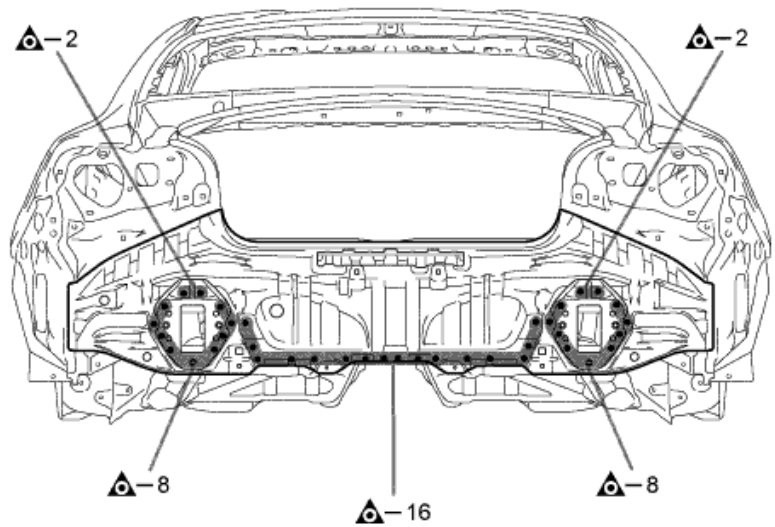
- REMOVAL
- INSTALLATION

BODY LOWER BACK PANEL > ASSEMBLY REPLACEMENT

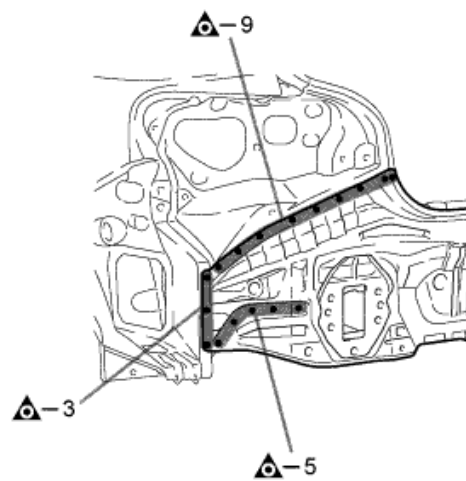


REMOVAL

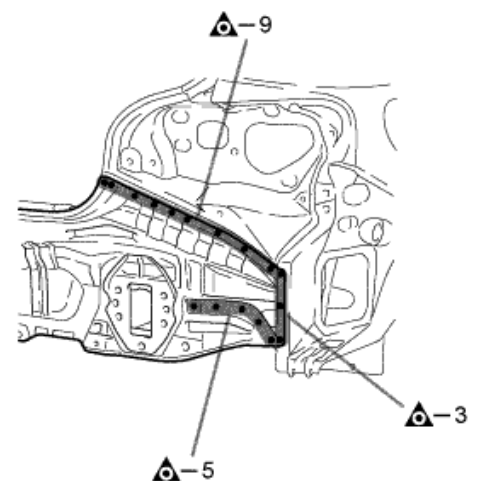
Symbol meaning	
	Remove Weld Points




LH Side:



RH Side:

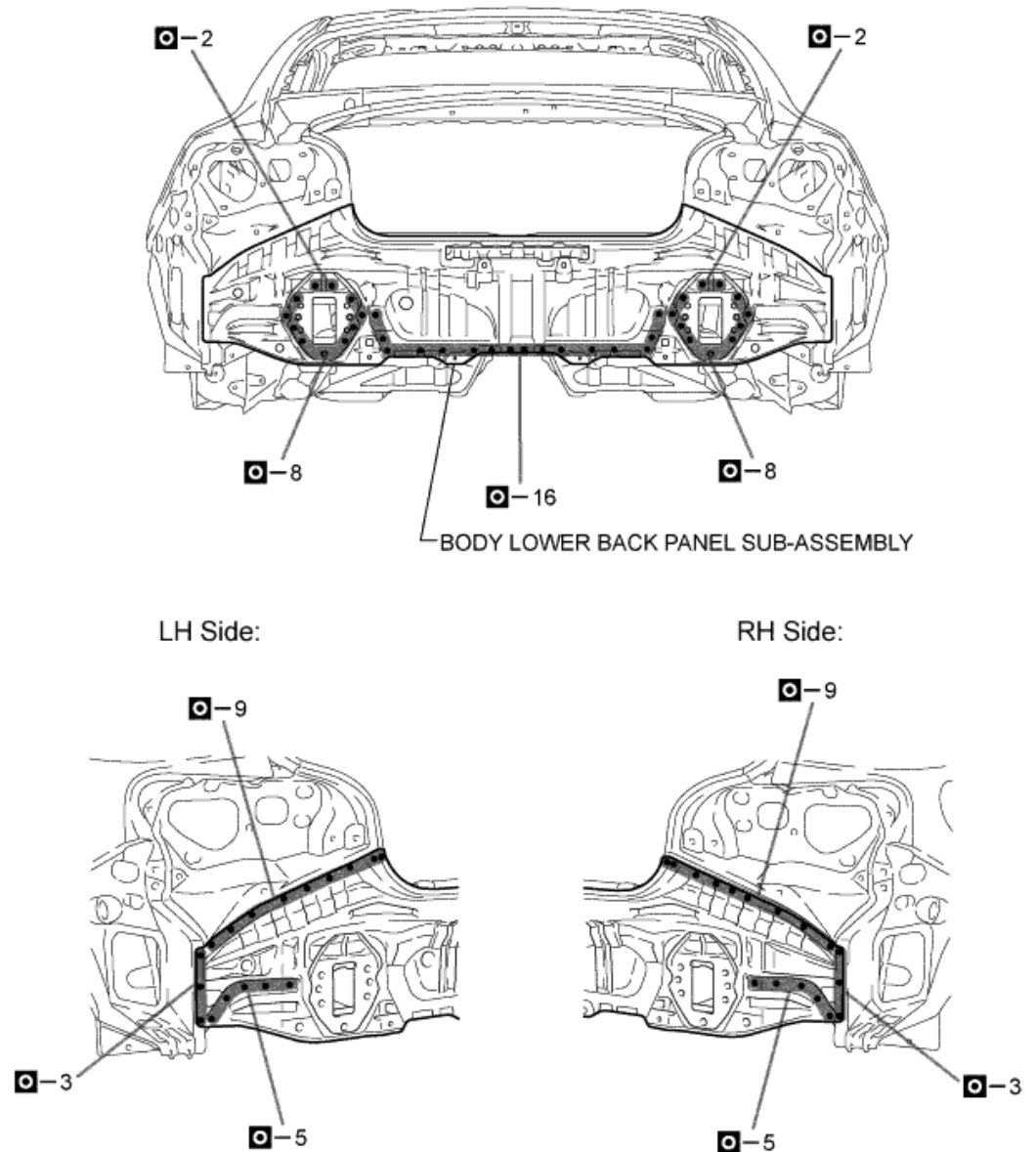


INSTALLATION

Symbol meaning	
	Plug Weld

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 dimensions)
3. After welding, apply body sealer to the corresponding parts. (See the painting / coating)
4. After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.



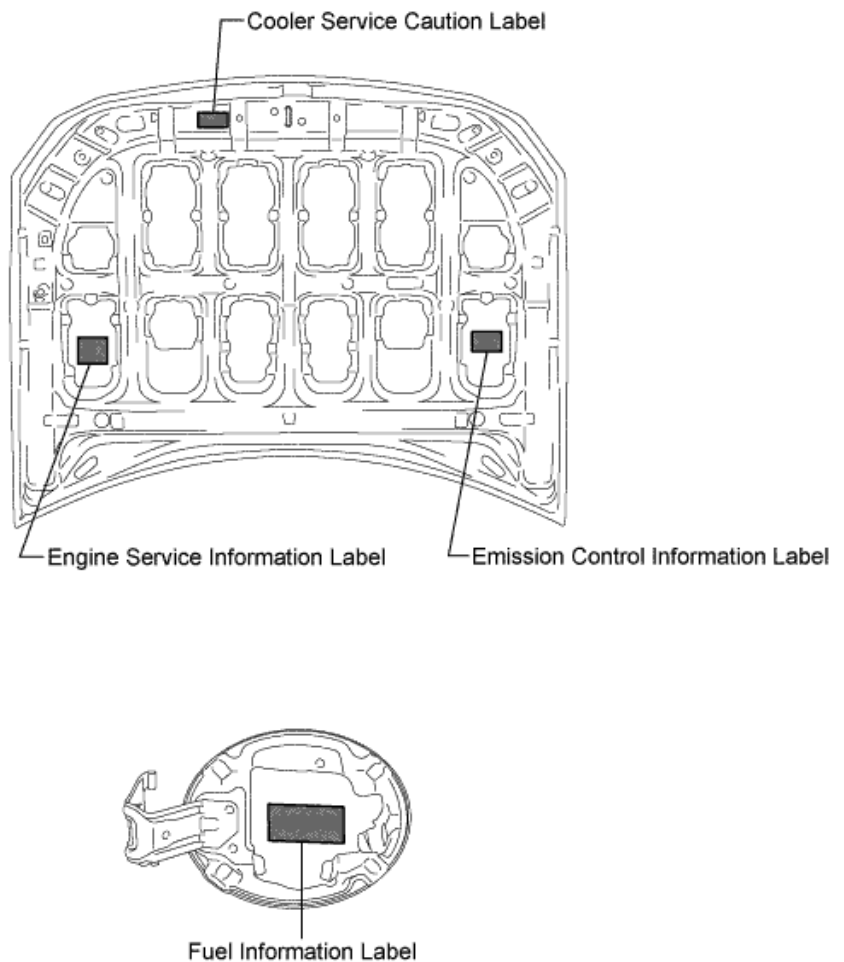
CAUTION LABEL > ATTACHMENT POSITION

CAUTION LABEL > ATTACHMENT POSITION

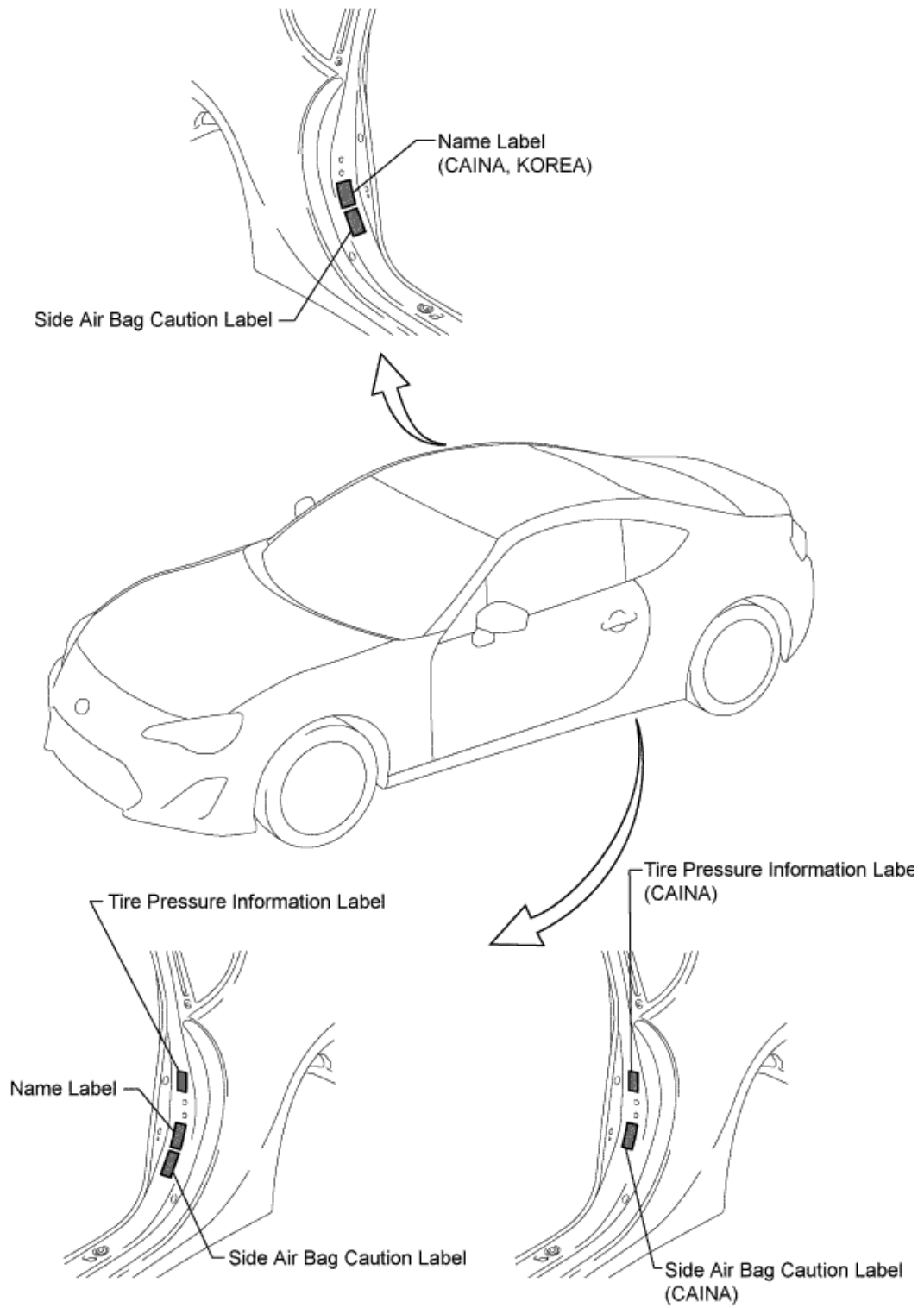
1. After using a degreasing agent to clean the surfaces of the body where the caution labels will be attached, attach the caution labels to the positions shown in the illustration.

HINT:

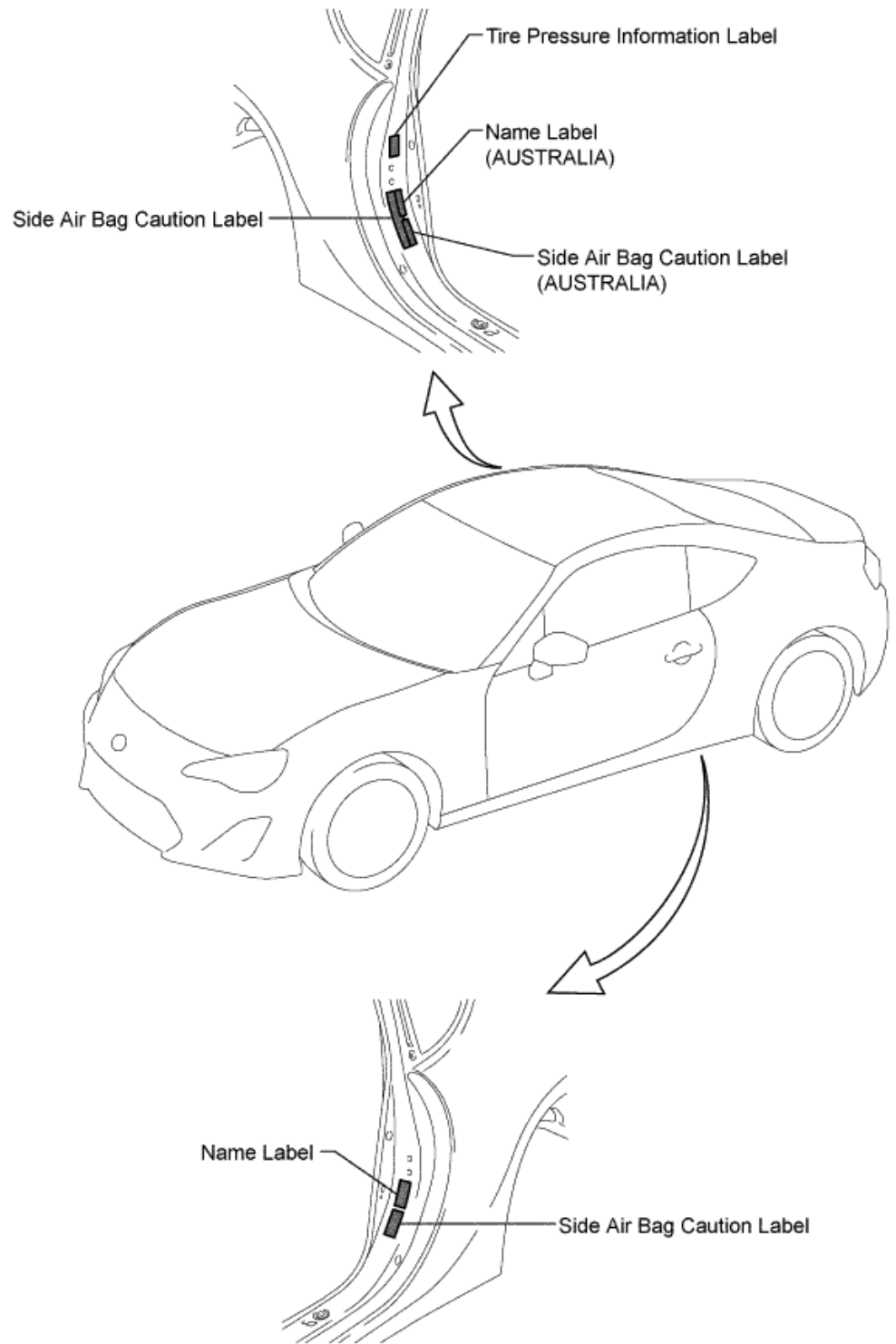
- Make sure the caution label is not attached over a spot weld.
- When attaching the caution label, make sure not to touch the label's adhesive surface.
- To prevent the edges of the caution label from peeling, apply extra pressure to the label's periphery.
- If the work area's temperature is 5°C or less, the caution label's adhesive will deteriorate. It is recommended that you heat the label to 20 to 40°C.



for LHD:



for RHD:



CENTER BODY PILLAR > CUT AND JOIN REPLACEMENT SECTIONS

- REMOVAL
- INSTALLATION

CENTER BODY PILLAR > CUT AND JOIN REPLACEMENT SECTIONS

With the quarter panel removed.

Weld work for 980 MPa ultra high strength steel

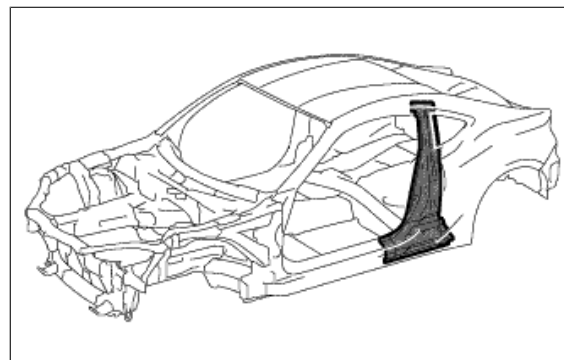
Follow the welding conditions below when welding ultra high strength steel to assure sufficient weld strength. (When repairing this model)

*1: When welding 2 panels together including 980 MPa ultra high strength steel.

Plug weld	Plug diameter	10 mm (0.39 in.)
	Wire type	AWS A5.18 ER70S-3
	Shield gas	Metal active gas

*2: When welding more than 3 panels together including 980 MPa ultra high strength steel. (When plug welding a third panel to 2 panels which are welded under the conditions described above.)

Plug weld	Plug diameter	Same as the standard method (See the introduction)
	Wire type	AWS A5.18 ER70S-3
	Shield gas	Metal active gas

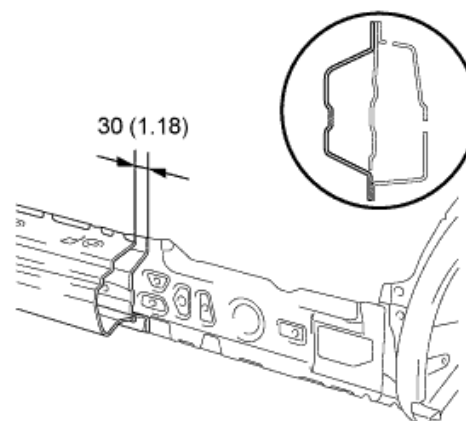
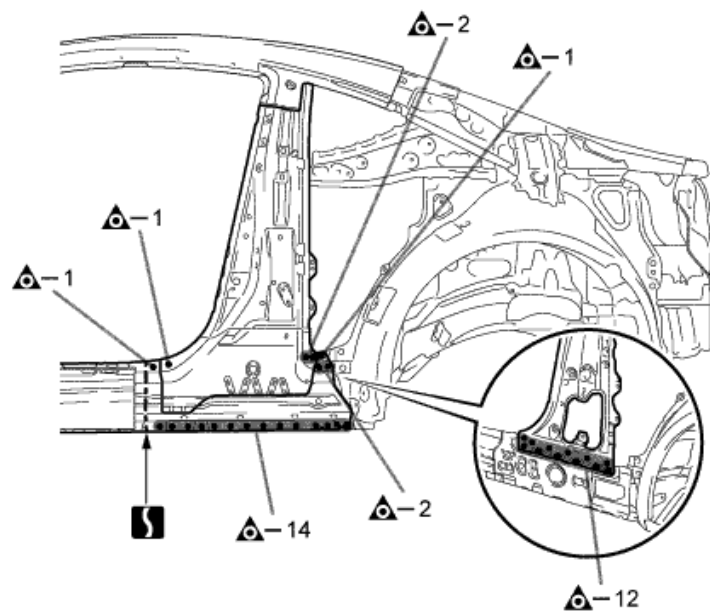


REMOVAL

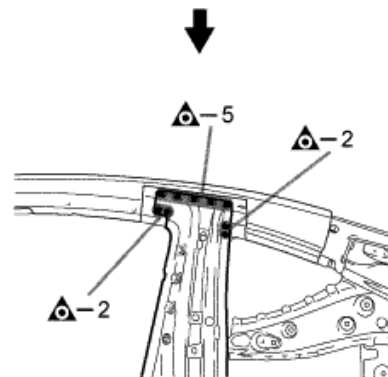
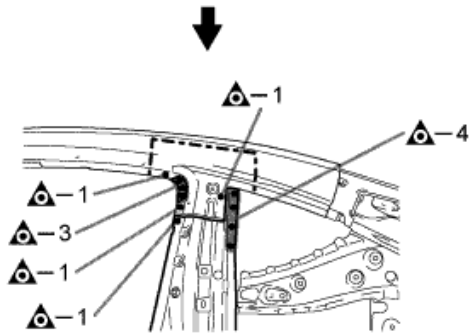
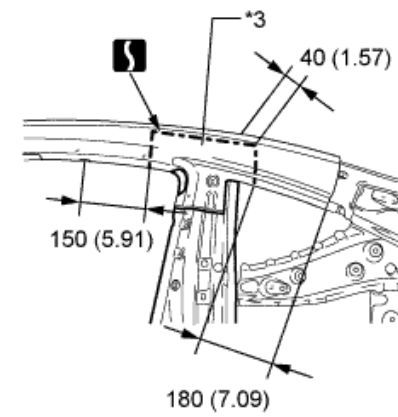
Symbol meaning	
	Remove Weld Points
	Remove Weld Points
	Cut with Disc Sander etc.
	Cut and Join Location

REMOVAL POINT

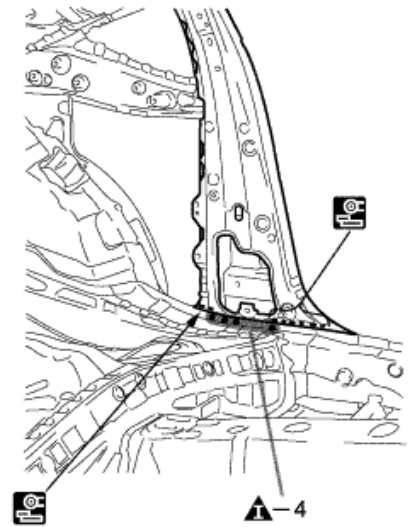
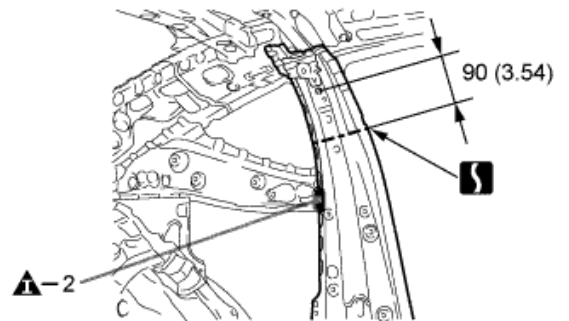
1. Do not butt weld or heat repair because the heat decreases the strength of areas where ultra high strength steel is used. (See the introduction)
2. *3 is reused.



mm (in.)







mm (in.)



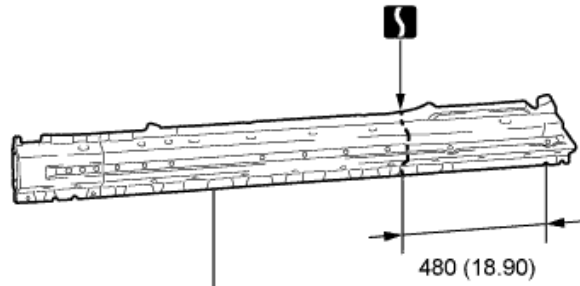
INSTALLATION

Symbol meaning	
	Plug Weld
	Plug Weld

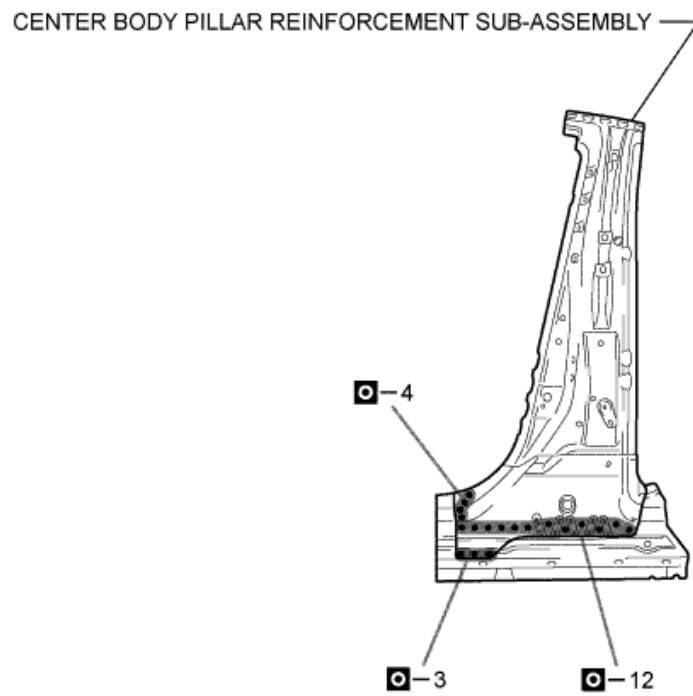
	
	Cut and Join Location
	Fillet Weld
	Butt Weld

INSTALLATION POINT

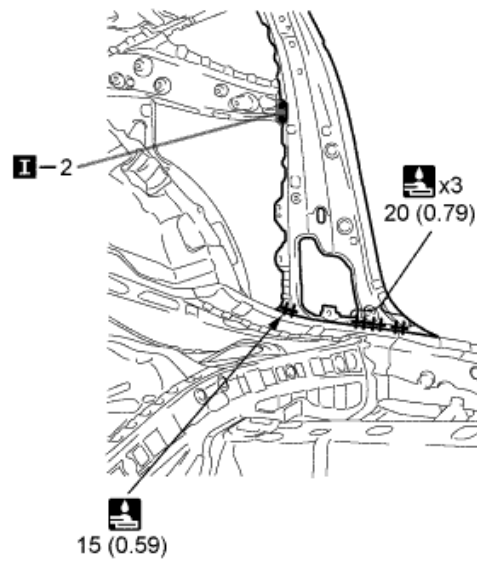
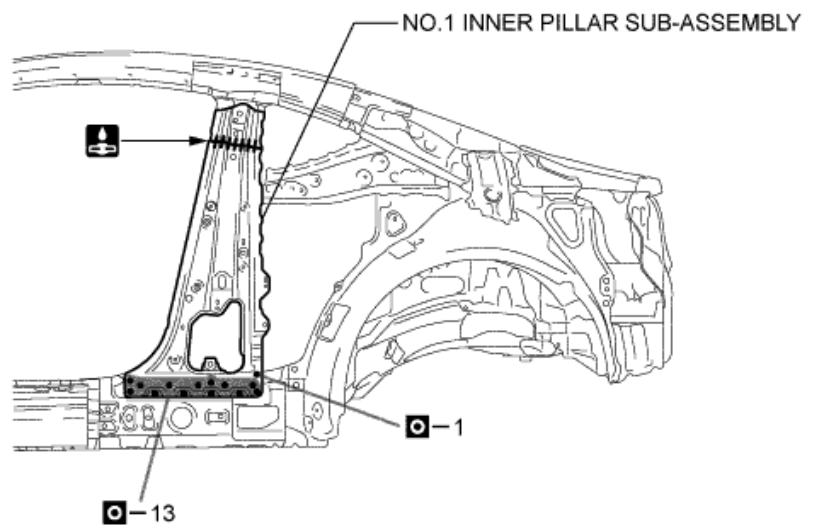
1. Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
2. Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimensions)
3. If the entire supply part is not needed, remove the part of the supply part that is needed.
4. Follow the welding conditions when welding *1 and *2 to assure sufficient weld strength. (See the introduction)
5. Before temporarily installing the new parts, weld the center body pillar reinforcement sub-assembly and rocker reinforce sub-assembly outer with the standard number of welding points.
6. After welding the No.1 inner pillar sub-assembly the vehicle side, install the center body pillar reinforcement sub-assembly and rocker reinforce sub-assembly outer.
7. After welding the No.1 inner pillar sub-assembly, center body pillar reinforcement sub-assembly and rocker reinforce sub-assembly outer the vehicle side, install the *3.
8. After welding, apply body sealer to the corresponding parts. (See the painting / coating)
9. After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.



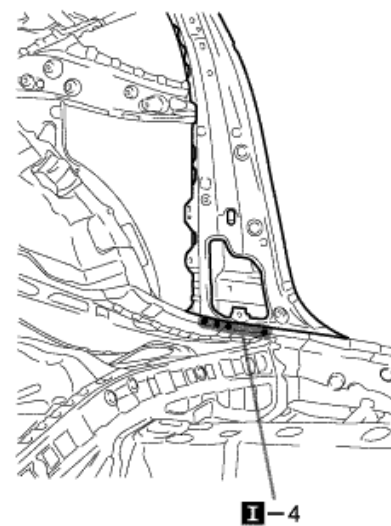
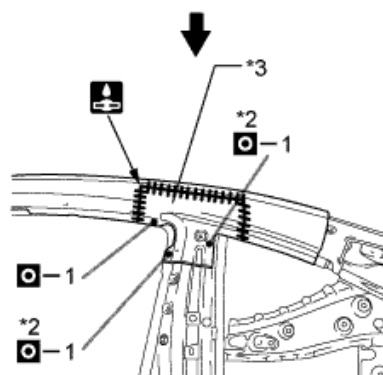
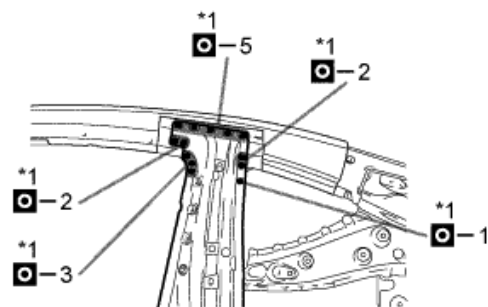
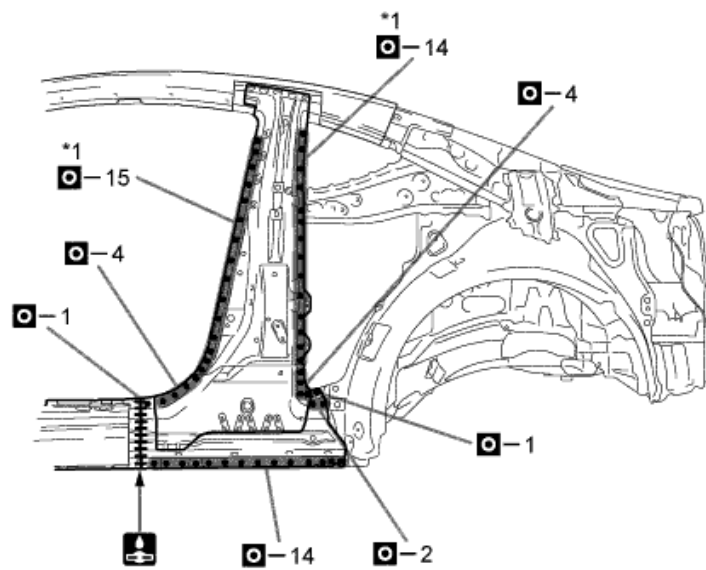
ROCKER REINFORCE SUB-ASSEMBLY OUTER



mm (in.)

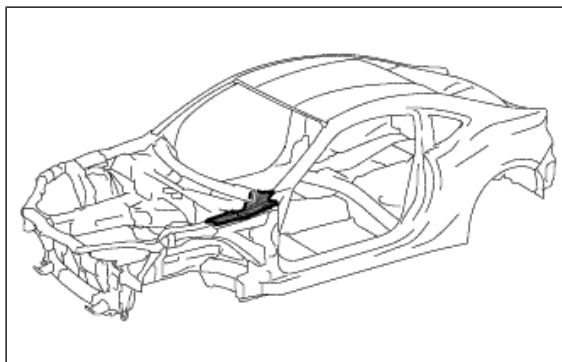


mm (in.)






COWL TOP TO APRON BRACE > ASSEMBLY REPLACEMENT

- REMOVAL
- INSTALLATION



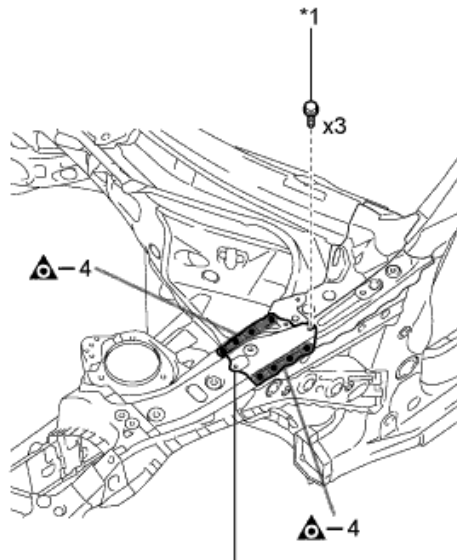
COWL TOP TO APRON BRACE > ASSEMBLY REPLACEMENT

REMOVAL

Symbol meaning	
	Remove Weld Points
	Remove Weld Points
	Cut with Disk Sander etc.

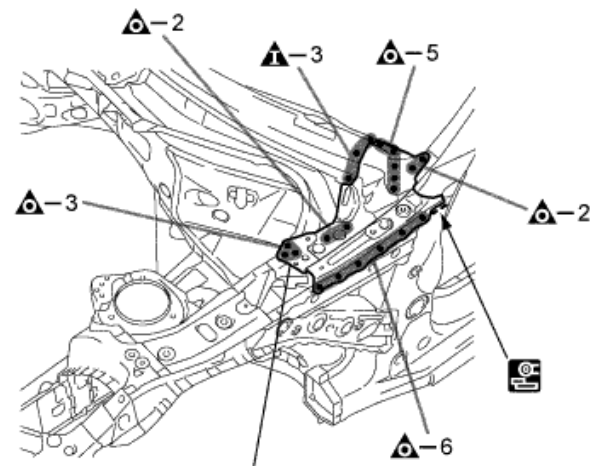
REMOVAL POINT

1. *1: Bolts.
2. After removing the front fender apron patch No.4 and front fender apron patch, remove the cowl top side panel sub-assembly.




LH:FRONT FENDER APRON PATCH NO.4

RH:FRONT FENDER APRON PATCH



COWL TOP SIDE PANEL SUB-ASSEMBLY

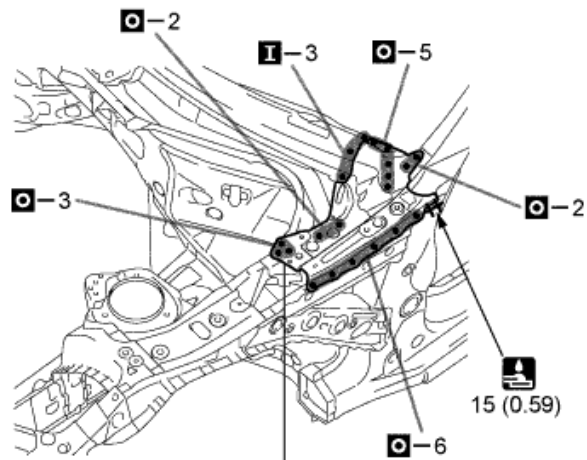
INSTALLATION

Symbol meaning	
	Plug Weld
	Plug Weld

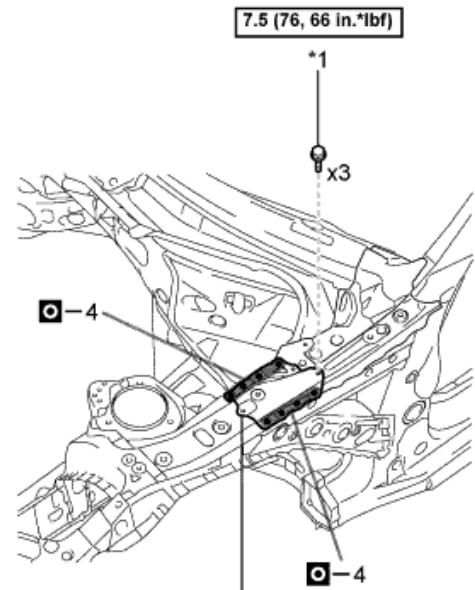
	
	Fillet Weld

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. *1: Bolts.
4. After welding the cowl top side panel sub-assembly to the vehicle side, install the front fender apron patch No.4 and front fender apron patch.
5. After welding, apply body sealer to the corresponding parts. (See the painting / coating)
6. After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.



COWL TOP SIDE PANEL SUB-ASSEMBLY



N*m (kgf*cm, ft.*lbf): Specified torque

mm (in.)

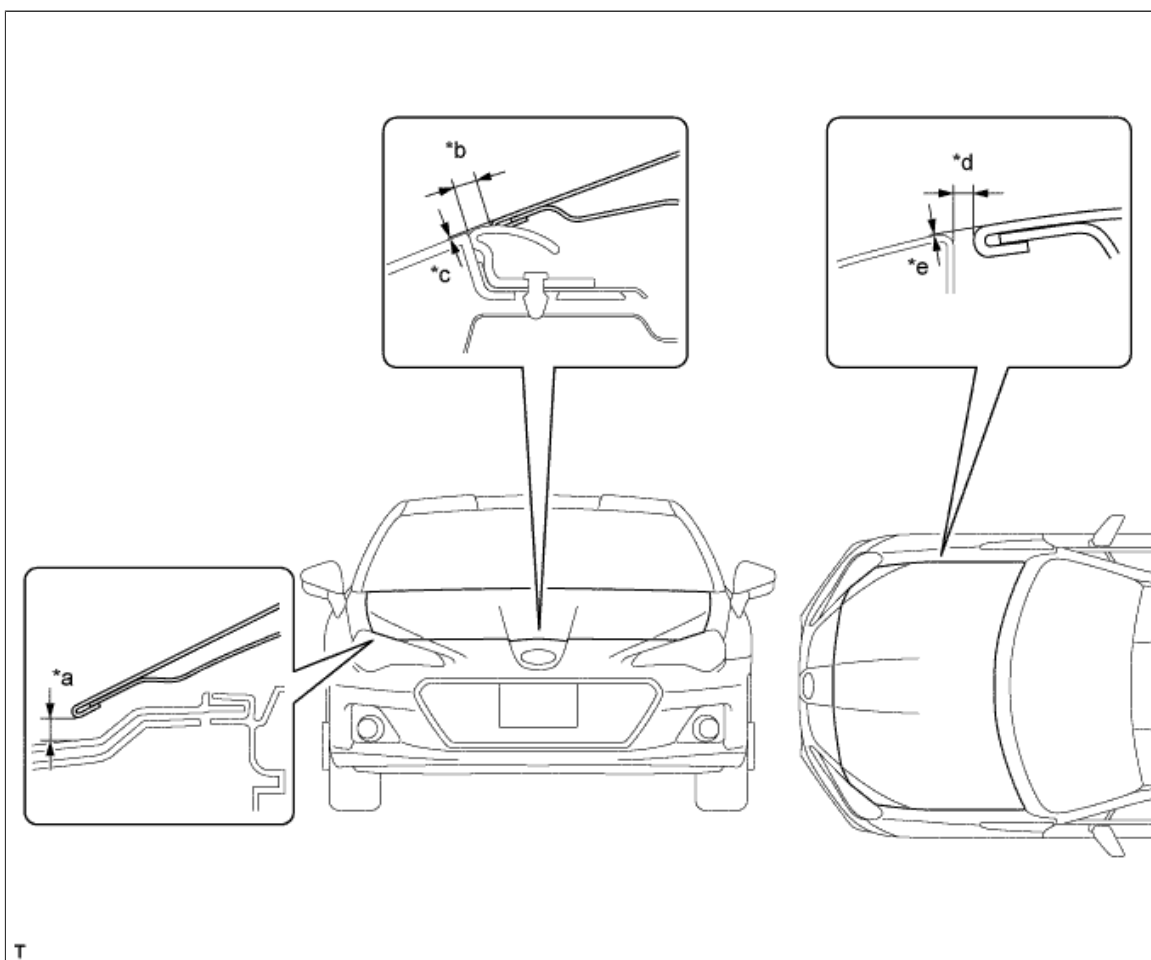
LH:FRONT FENDER APRON PATCH NO.4

RH:FRONT FENDER APRON PATCH

FIT STANDARD / ADJUSTMENT METHOD > ADJUSTMENT

- INSPECT HOOD SUB-ASSEMBLY
- ADJUST HOOD SUB-ASSEMBLY
- INSPECT FRONT DOOR
- ADJUST FRONT DOOR GLASS
- ADJUST FRONT DOOR
- INSPECT LUGGAGE COMPARTMENT DOOR PANEL SUB-ASSEMBLY
- ADJUST LUGGAGE COMPARTMENT DOOR PANEL SUB-ASSEMBLY

INSPECT HOOD SUB-ASSEMBLY



- a.** Check that the clearance measurements of areas *a through *e are within each standard range.

Reference Value

Area	Measurement	Area	Measurement
*a	5.8 to 9.8 mm (0.2283 to 0.3858 in.)	*b	3.0 to 7.0 mm (0.1181 to 0.2756 in.)
*c	-2.0 to 2.0 mm (-0.0787 to 0.0787 in.)	*d	2.0 to 5.0 mm (0.0787 to 0.1969 in.)
*e	-2.0 to 1.0 mm (-0.0787 to 0.0394 in.)	-	-

HINT:

- Use the same procedure for the LHD and RHD vehicles.
- The procedure listed below is for the LHD vehicles.
- Centering bolts are used to mount the hood hinge and hood lock. The hood and hood lock cannot be adjusted with the centering bolts installed. Substitute the centering bolts with standard bolts when making adjustments.

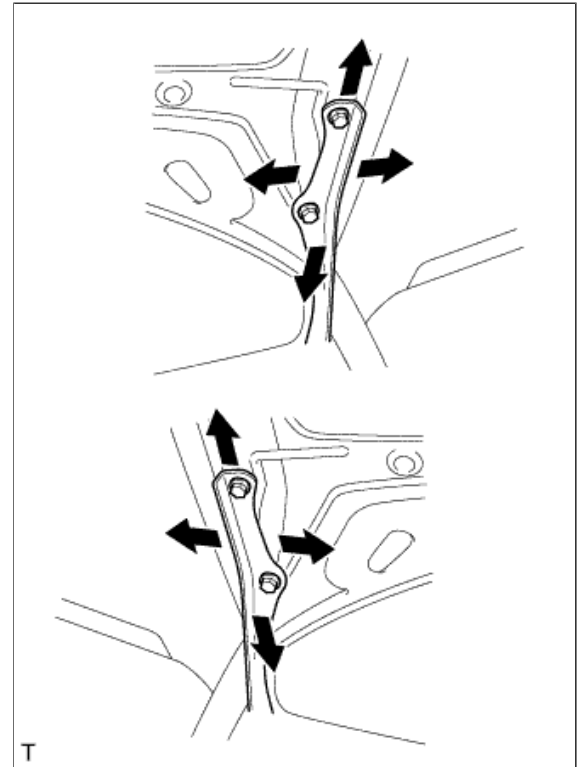
ADJUST HOOD SUB-ASSEMBLY

- a.** Horizontally and vertically adjust the hood.

- i. Loosen the 4 hinge bolts of the hood.
- ii. Adjust the clearance between the hood and front fender by moving the hood.
- iii. Tighten the 4 hinge bolts after the adjustment.

Torque:

**25 N*m { 255 kgf*cm ,
18 ft.*lbf }**

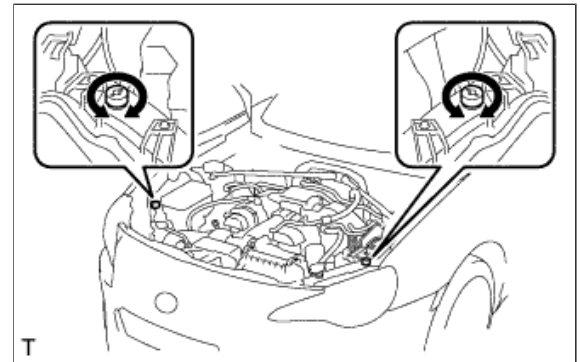


- b. Adjust the height of the front end of the hood using the cushion rubbers.

- i. Adjust the 2 cushion rubbers so that the heights of the hood and fender are aligned.

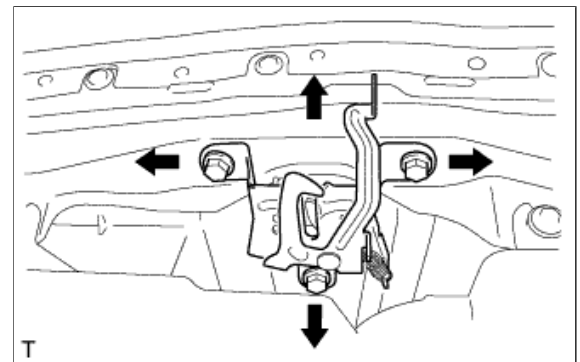
HINT:

Raise or lower the front end of the hood by turning the 2 cushion rubbers.



- c. Adjust the hood lock.

- i. Loosen the 3 bolts.
- ii. Adjust the hood lock position so that the striker can enter it smoothly.



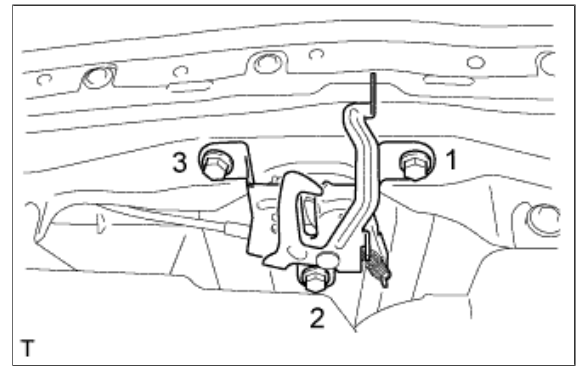
- iii. Tighten the 3 bolts after the adjustment in the order shown in the illustration.

Torque:

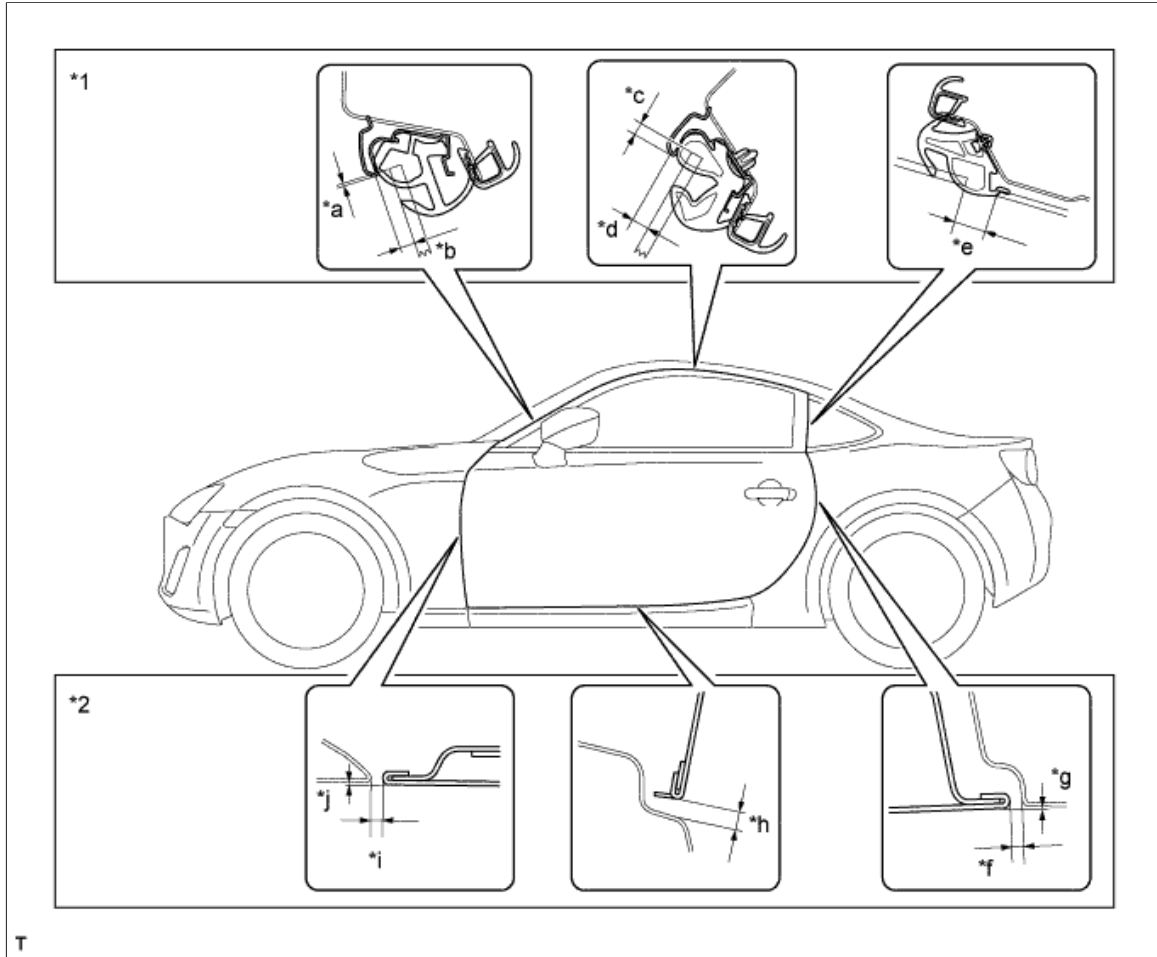
**33 N*m { 337 kgf*cm ,
24 ft.*lbf }**

- iv. Check that the striker can

engage smoothly with the hood lock.



INSPECT FRONT DOOR



- a. Check that the clearance measurements of areas *a through *j are within each standard range.

Reference Value

Area	Measurement	Area	Measurement
*a	0.5 mm (0.0197 in.)	*b	7.0 mm (0.2756 in.)
*c	5.0 mm (0.1969 in.)	*d	6.7 mm (0.2638 in.)
*e	13.5 to 16.5 mm (0.5315 to 0.6496 in.)	*f	2.5 to 5.5 mm (0.0984 to 0.2165 in.)
*g	0.0 to 1.5 mm (0.0 to 0.0591 in.)	*h	4.8 to 7.8 mm (0.1890 to 0.3071 in.)
*i	3.1 to 5.6 mm (0.122 to 0.220 in.)	*j	-1.0 to 1.5 mm (-0.0394 to 0.0591 in.)

Text in Illustration

*1	Front Glass	*2	Front Door
----	-------------	----	------------

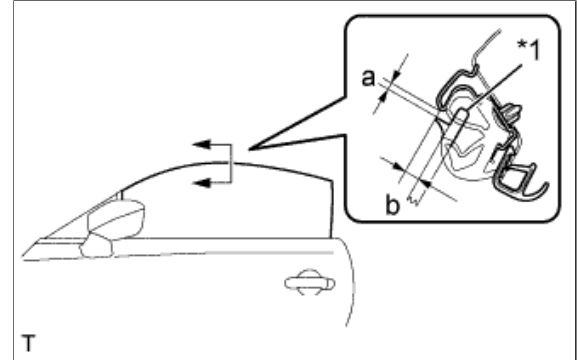
HINT:

- Use the same procedure for both the RH and LH sides.
- The following procedure is for the LH side.
- Centering bolts are used to mount the door hinge to the vehicle body and door.
The door cannot be adjusted with the centering bolts installed on it. Substitute the centering bolts with standard bolts when making adjustments.

ADJUST FRONT DOOR GLASS

- a. Using a SST, check that the clearance measurements of areas "a" to "b" are within each standard range

SST
09812-18010



Text in Illustration

*1	SST
----	-----

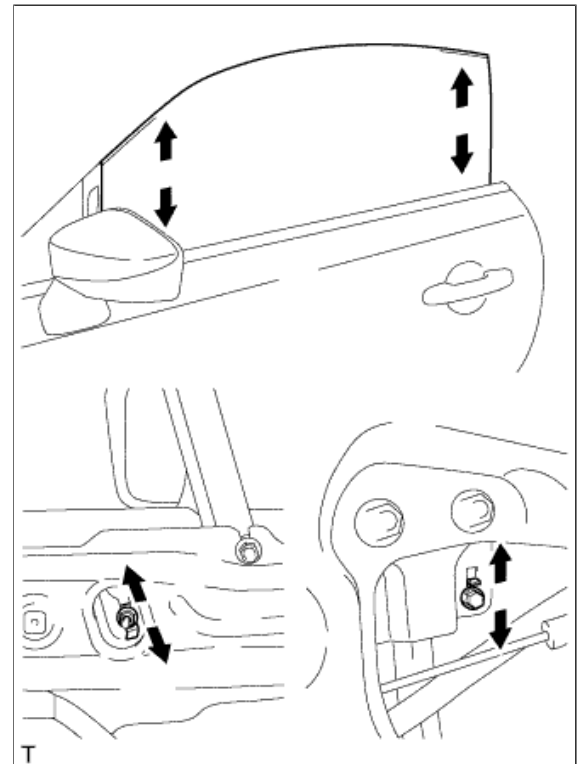
Reference Value

Area	Measurement
*a	5.0 mm (0.1969 in.)
*b	6.7 mm (0.2638 in.)

- b. Adjust the front door glass so that the fitting dimensions come within the reference values.
- c. Loosen the nut on the front door sush stopper and front door rear sush stopper, and adjust the glass position.
- d. After the adjustment, tighten the nut on the front door sush stopper and front door rear sush stopper.

Torque:

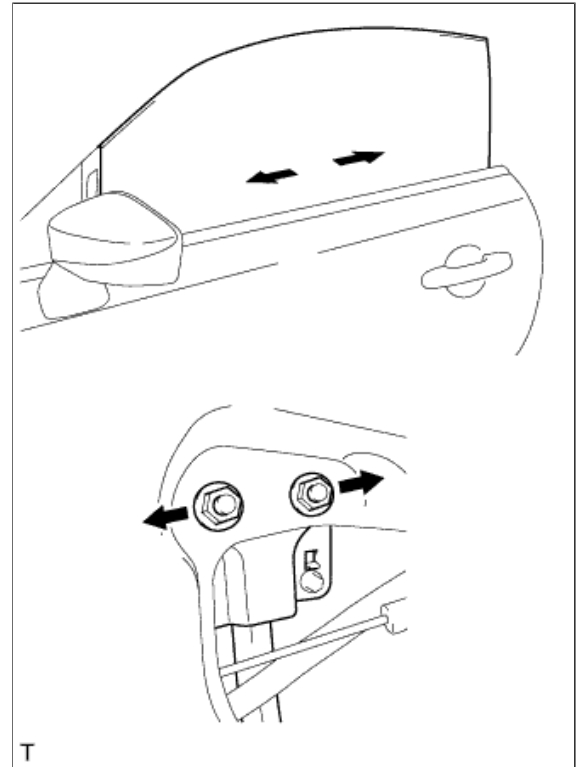
7.5 N*m{ 76 kgf*cm , 66 in.*lbf }



- e. Loosen the 2 nuts on the front door rear lower frame sub-assembly, and adjust the glass position.
- f. After the adjustment, tighten the 2 nuts on the front door rear lower frame sub-assembly.

Torque:

14 N*m{ 143 kgf*cm , 10 ft.*lbf }



- g. Loosen the bolt on the door glass inner stabilizer and adjust the glass position.
- h. After the adjustment, tighten the bolt on the door glass inner stabilizer.

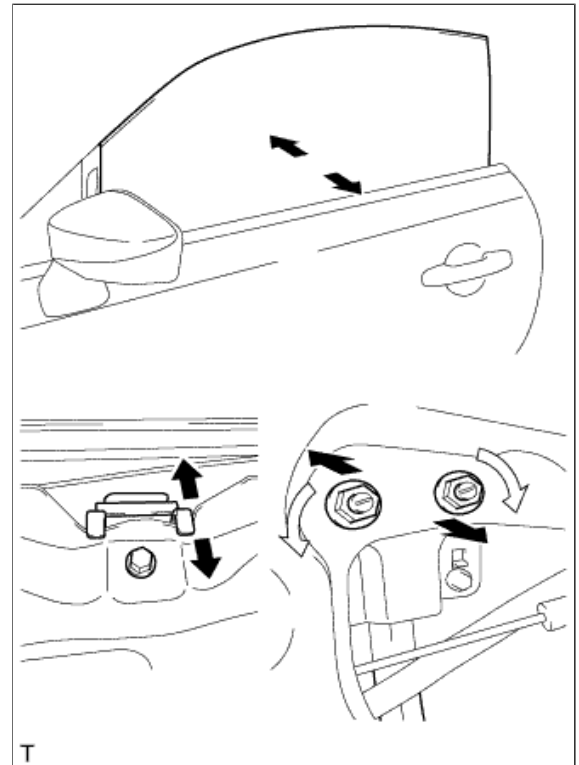
Torque:

7.5 N*m{ 76 kgf*cm , 66 in.*lbf }

- i. Loosen the 2 nuts on the front door rear lower frame sub-assembly.
- j. Using a screwdriver, rotate the bolts and then adjust the position of the front door glass in lateral direction.
- k. After the adjustment, tighten the 2 nuts on the front door rear lower frame sub-assembly.

Torque:

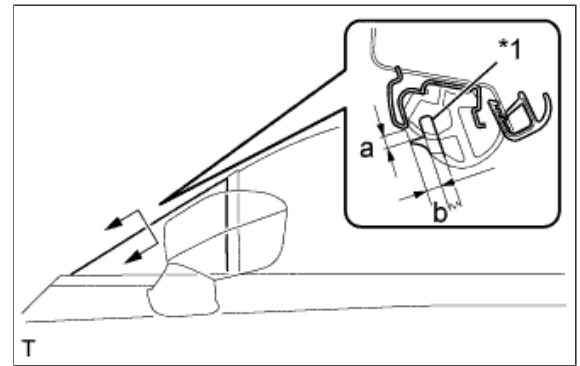
14 N*m{ 143 kgf*cm , 10 ft.*lbf }



- l. Using a SST, check that the clearance measurements of areas "a" to "b" are within each standard range .

SST

09812-18020



Text in Illustration

*1	SST
----	-----

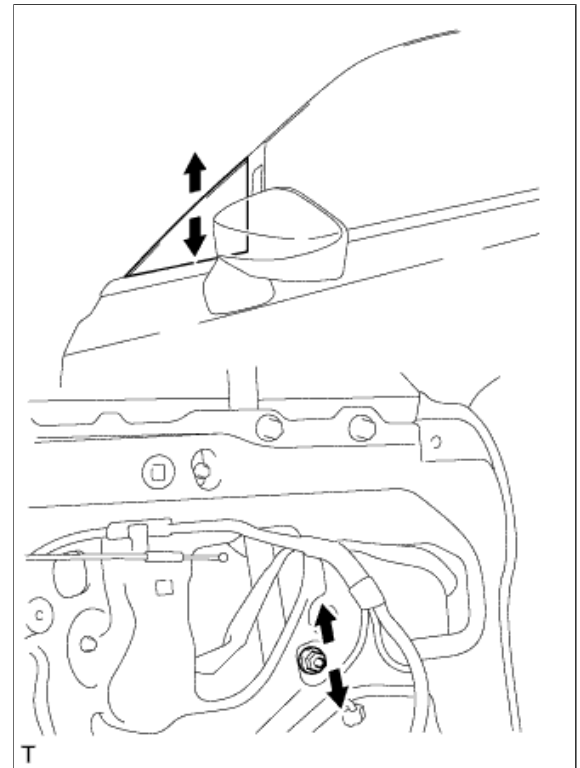
Reference Value

Area	Measurement
*a	2.5 to 5.5 mm (0.0984 to 0.2165 in.)
*b	5.2 to 8.2 mm (0.2047 to 0.3228 in.)

- m. Adjust the front door sush so that the fitting dimensions come within the reference values.
- n. Loosen the nut on the front door sush and adjust the front door sush position.
- o. After the adjustment, tighten the nut on the front door sush.

Torque:

14 N*m{ 143 kgf*cm , 10 ft.*lbf }



ADJUST FRONT DOOR

- a. Loosen the hinge bolts on the vehicle body and adjust the door position.
- b. After the adjustment, tighten the hinge bolts on the vehicle body.

Torque:

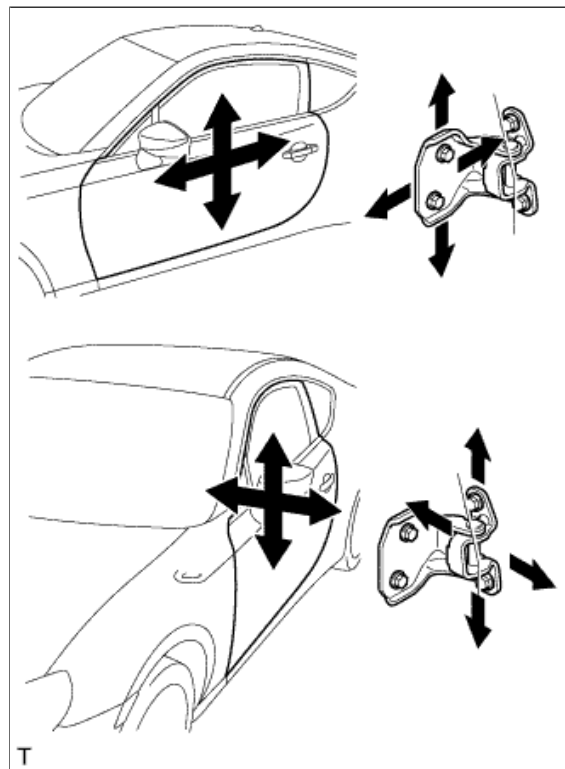
30 N*m{ 306 kgf*cm , 22 ft.*lbf }

- c. Loosen the hinge bolts on the door and adjust the door position.

- d. After the adjustment, tighten the hinge bolts on the door.

Torque:

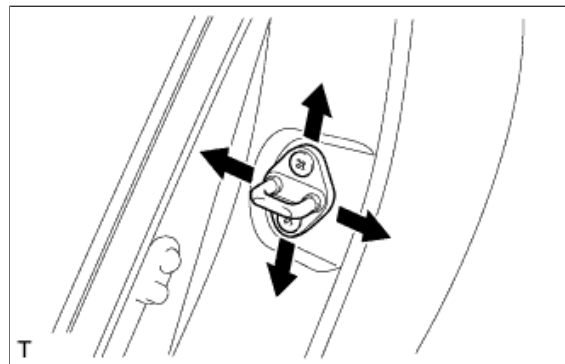
**25 N*m{ 255 kgf*cm , 18
ft.*lbf }**



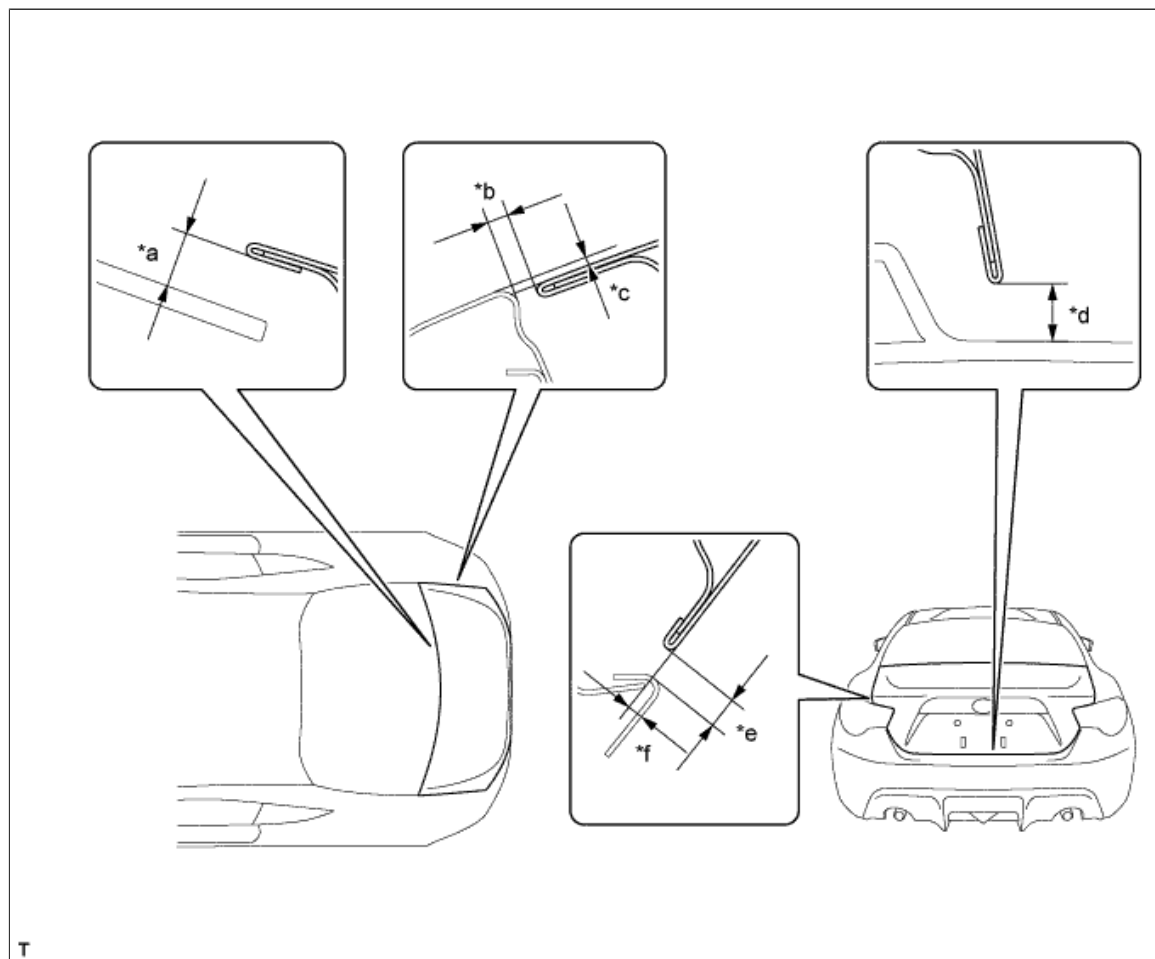
- e. Adjust the striker position by slightly loosening the striker mounting screws and hitting the striker with a plastic-faced hammer.
- f. After the adjustment, tighten the striker mounting screws.

Torque:

**18 N*m{ 184 kgf*cm , 13
ft.*lbf }**



INSPECT LUGGAGE COMPARTMENT DOOR PANEL SUB-ASSEMBLY



T

- a. Check that the clearance measurements of areas *a to *f are within each standard range.

Reference Value

Area	Measurement	Area	Measurement
*a	8.2 mm (0.3228 in.)	*b	2.0 to 5.0 mm (0.0787 to 0.1969 in.)
*c	-2.0 to 1.0 mm (-0.0787 to 0.0394 in.)	*d	5.8 to 10.2 mm (0.2283 to 0.4016 in.)
*e	4.3 to 7.3 mm (0.1693 to 0.2874 in.)	*f	-2.0 to 1.0 mm (-0.0787 to 0.0394 in.)

HINT:

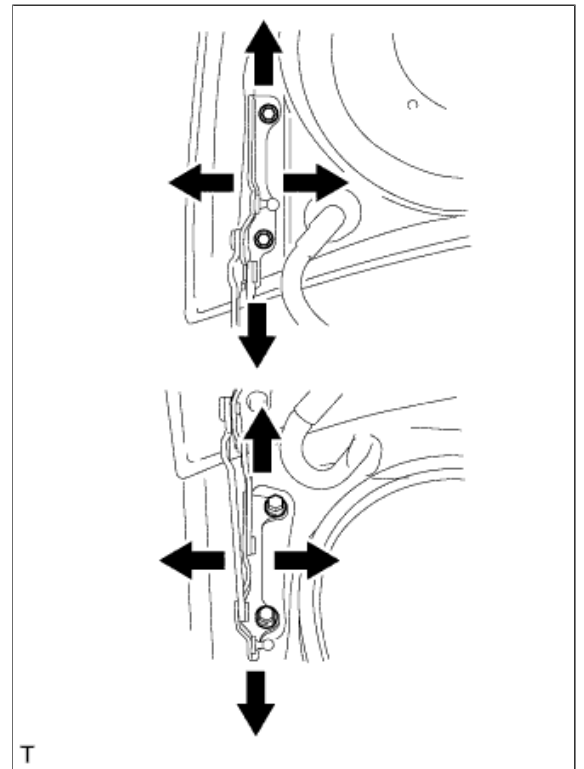
Centering bolts are used to mount the door hinge to the vehicle body and door. The door cannot be adjusted with the centering bolts on. Substitute the centering bolts with standard bolts when making adjustments.

ADJUST LUGGAGE COMPARTMENT DOOR PANEL SUB-ASSEMBLY

- a. Horizontally and vertically adjust the door by loosening the door side hinge bolts.

Torque:

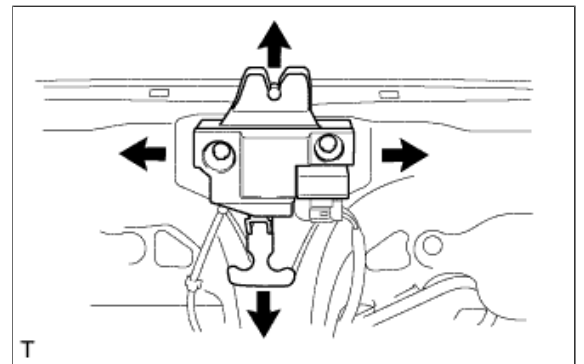
18 N*m{ 184 kgf*cm , 13 ft.*lbf }



- b.** When adjusting the rear edge of the doors left or right, or adjusting the luggage door closer assembly, loosen the bolts before making adjustments.
- c.** Using a brass bar and a hammer, hit the striker to adjust its position.
- d.** After the adjustment, tighten the 2 bolts on the luggage door closer assembly.

Torque:

7.5 N*m{ 76 kgf*cm , 66 in.*lbf }

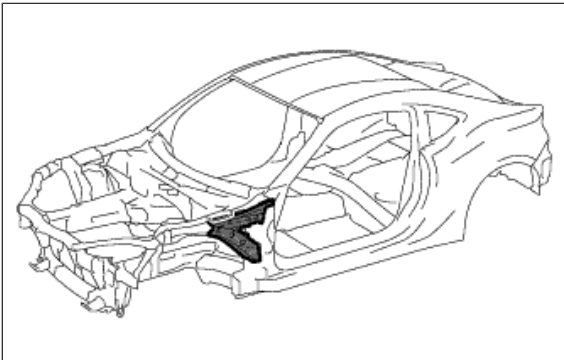


FRONT BODY PILLAR LOWER GUSSET > ASSEMBLY REPLACEMENT

- REMOVAL
- INSTALLATION

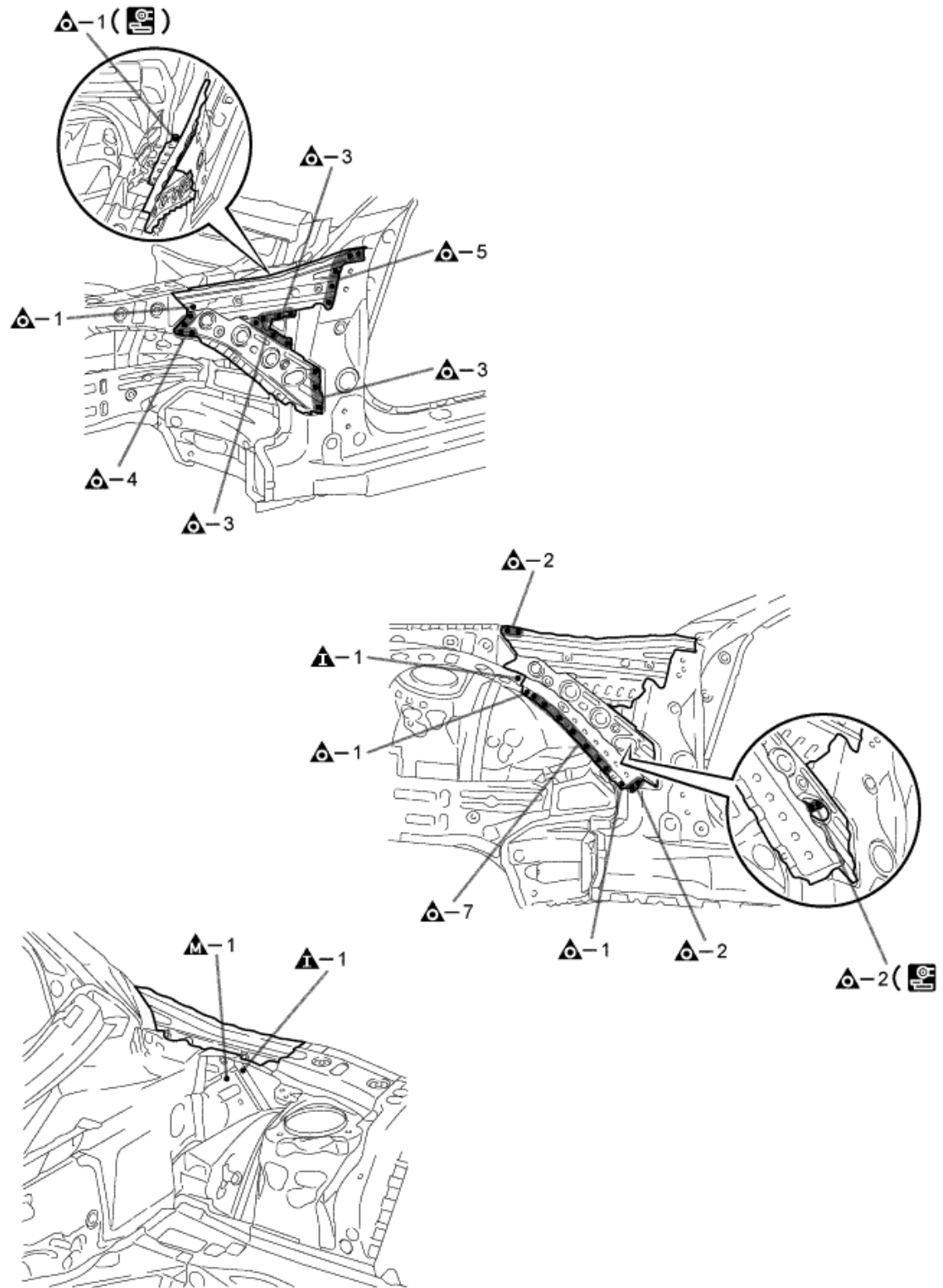
FRONT BODY PILLAR LOWER GUSSET > ASSEMBLY REPLACEMENT

With the cowl top to apron brace removed.




REMOVAL

Symbol meaning	
	Remove Weld Points
	Remove Weld Points
	Remove Weld Points
	Cut with Disk Sander etc.



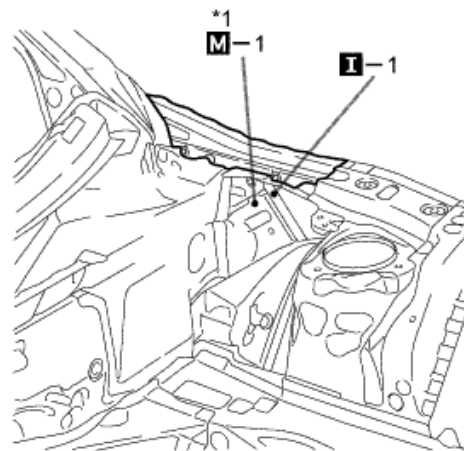
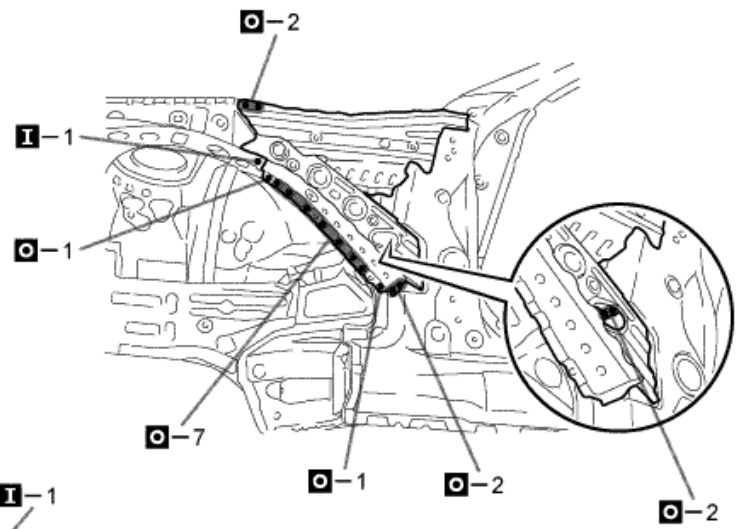
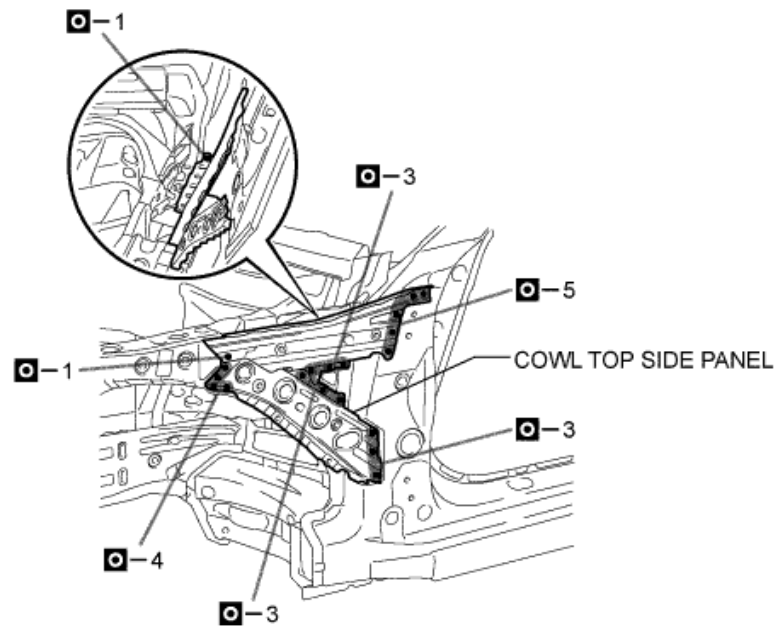
INSTALLATION

Symbol meaning	
	Plug Weld
	Plug Weld

M	
I	Plug Weld

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 dimensions)
3. When welding *1, make a hole on a new part for plug welding and weld the panel with the panel behind completely.
4. After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.



FRONT BODY PILLAR > CUT AND JOIN REPLACEMENT SECTIONS

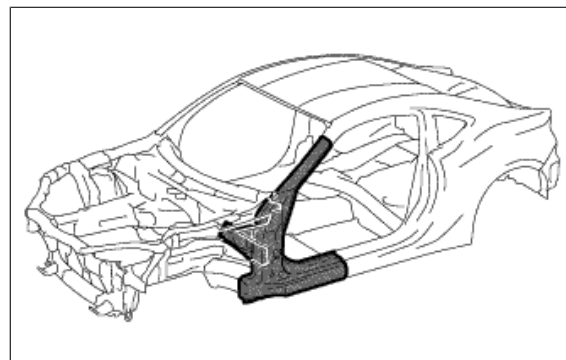
- REMOVAL
- INSTALLATION

FRONT BODY PILLAR > CUT AND JOIN REPLACEMENT SECTIONS

With the front body pillar lower gusset removed.

Weld work for 980 MPa ultra high strength steel

Follow the welding conditions below when welding ultra high strength steel to assure sufficient weld strength. (When repairing this model)



*1: When welding 2 panels together including 980 MPa ultra high strength steel.

Spot weld	Pressure	2940 N (300 kgf, 661 lbf)
	Weld current	10000 A
	Weld time	18 Cyc. (0.30 Sec.)
Plug weld	Plug diameter	10 mm (0.39 in.)
	Wire type	AWS A5.18 ER70S-3
	Shield gas	Metal active gas

*2: When welding more than 3 panels together including 980 MPa ultra high strength steel. (When plug welding a third panel to 2 panels which are welded under the conditions described above.)

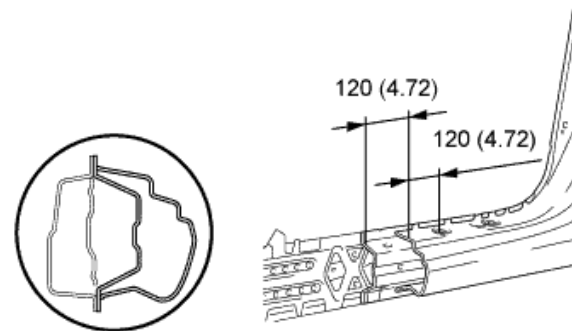
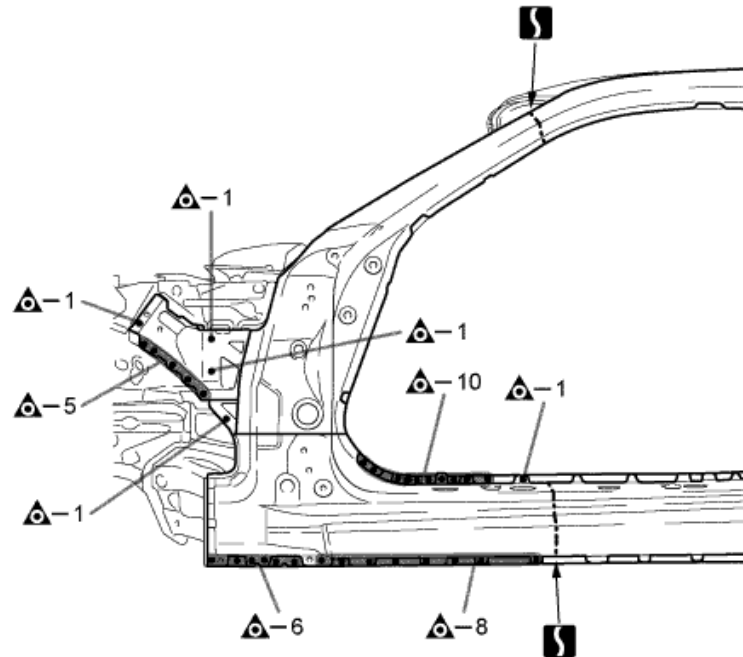
Plug weld	Plug diameter	Same as the standard method (See the introduction)
	Wire type	AWS A5.18 ER70S-3
	Shield gas	Metal active gas

REMOVAL

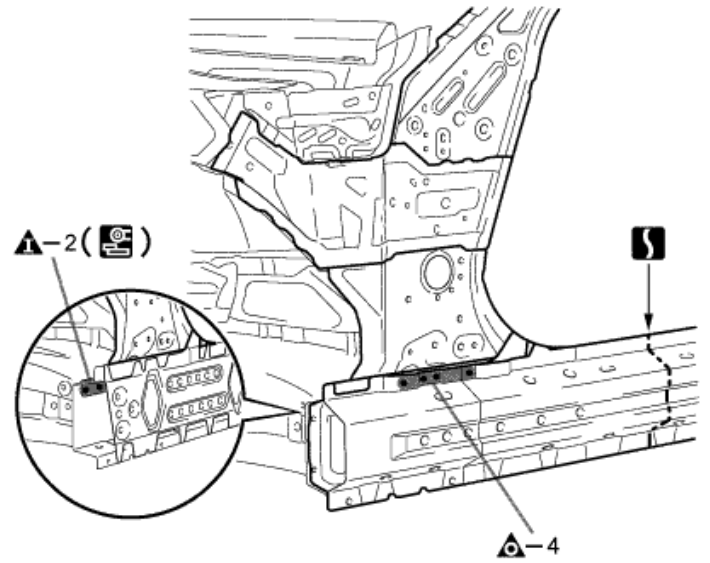
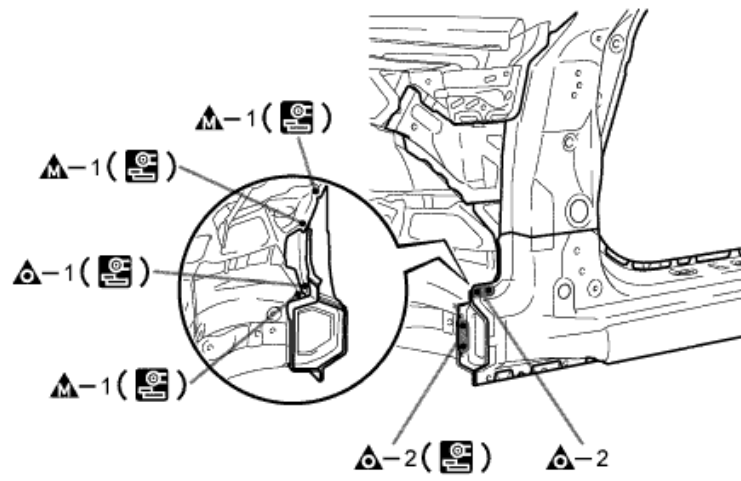
Symbol meaning	
	Remove Weld Points
	Remove Weld Points
	Remove Weld Points
	Cut with Disc Sander etc.
	Cut and Join Location

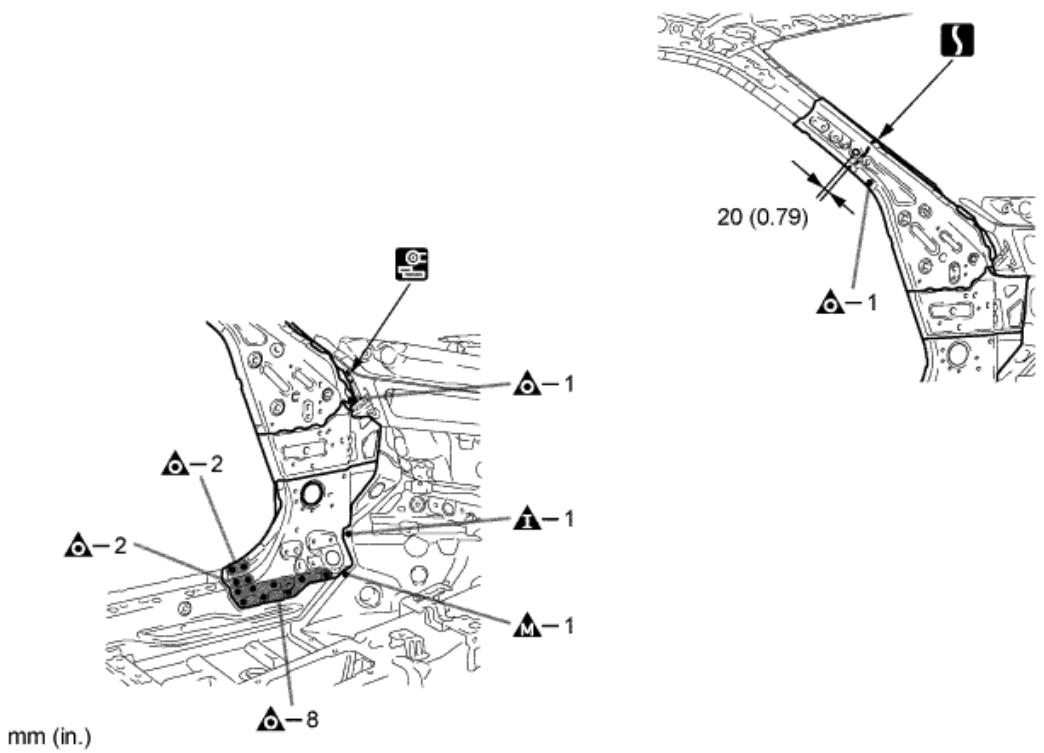
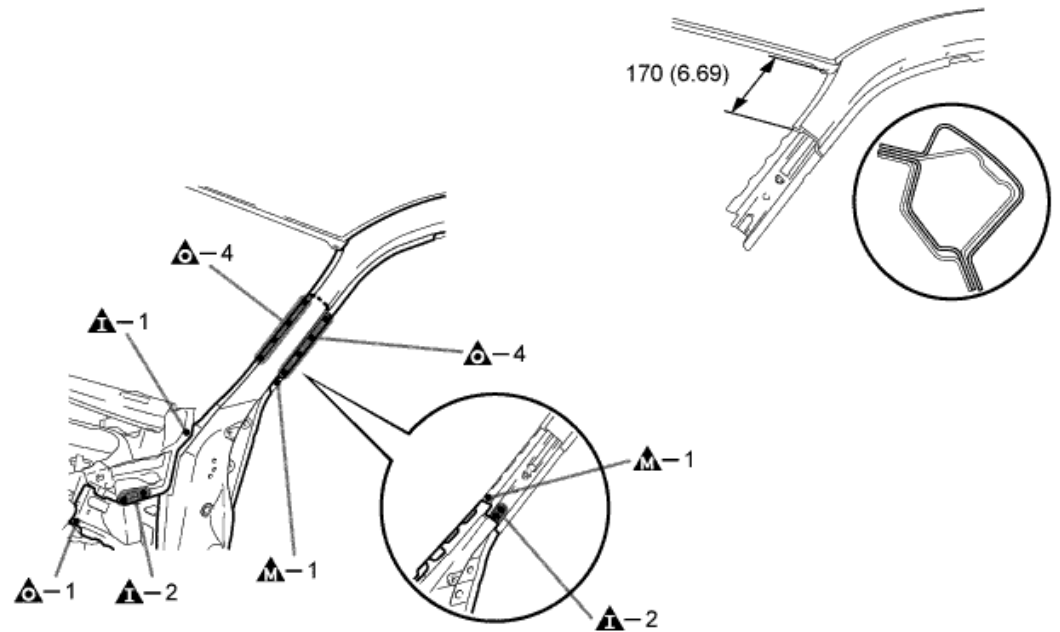
REMOVAL POINT

1. Do not butt weld or heat repair because the heat decreases the strength of areas where ultra high strength steel is used. (See the introduction)










mm (in.)





INSTALLATION

Symbol meaning	
	Spot Weld
	Plug Weld

	
	Plug Weld
	Plug Weld
	Cut and Join Location
	Fillet Weld
	Butt Weld
	Body Sealer

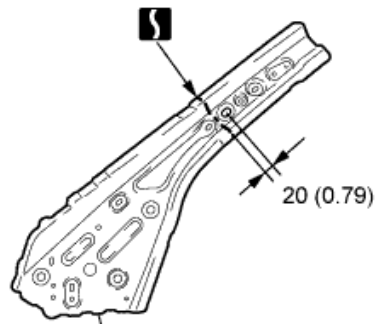
INSTALLATION POINT

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 dimensions)
3. If the entire supply part is not needed, remove the part of the supply part that is needed.
4. Before installing a new part, apply body sealer.

HINT:

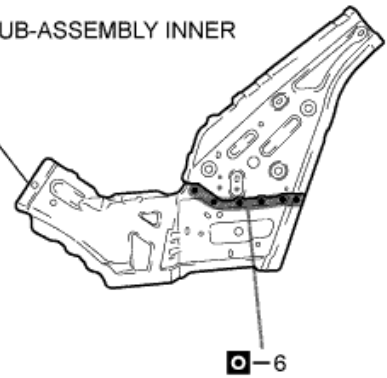
Apply body sealer in an even, continuous bead.

5. Follow the welding conditions when welding *1 and *2 to assure sufficient weld strength. (See the introduction)
6. Before temporarily installing the new parts, weld the front body pillar sub-assembly inner and front pillar extension lower with the standard number of welding points.
7. When welding *3, make a hole on a new part for plug welding and weld the panel with the panel.
8. After welding the front body lower inner pillar the vehicle side, install the front body pillar sub-assembly inner and front pillar extension lower.
9. After welding the front body lower inner pillar, front body pillar sub-assembly inner and front pillar extension lower the vehicle side, install the rocker reinforce sub-assembly outer.
10. After welding the front body lower inner pillar, front body pillar sub-assembly inner, front pillar extension lower and rocker reinforce sub-assembly outer the vehicle side, install the front body pillar reinforce sub-assembly lower.
11. After welding the front body lower inner pillar, front body pillar sub-assembly inner, front pillar extension lower, rocker reinforce sub-assembly outer and front body pillar reinforce sub-assembly lower the vehicle side, install the front body pillar upper outer and rocker panel outer rear.
12. After welding, apply body sealer to the corresponding parts. (See the painting / coating)
13. After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.



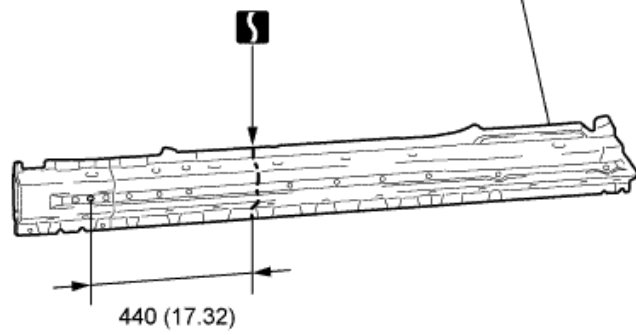
FRONT BODY PILLAR SUB-ASSEMBLY INNER

FRONT PILLAR EXTENSION LOWER

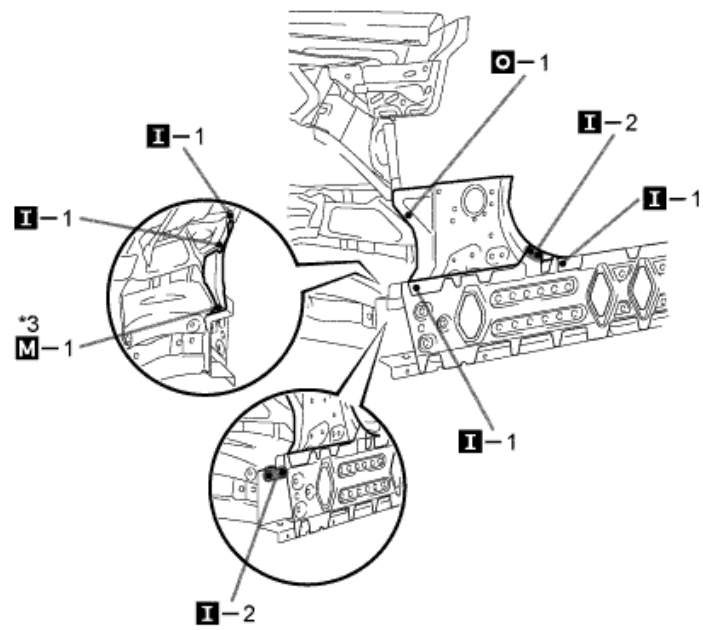


6

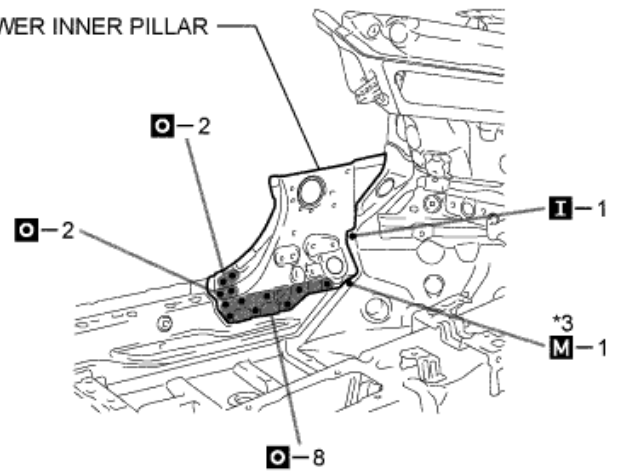
ROCKER REINFORCE SUB-ASSEMBLY OUTER

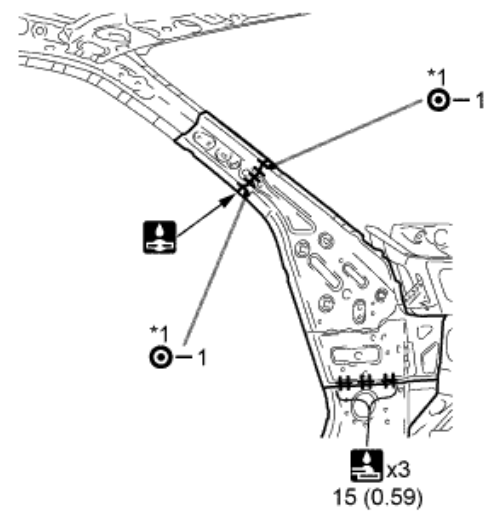
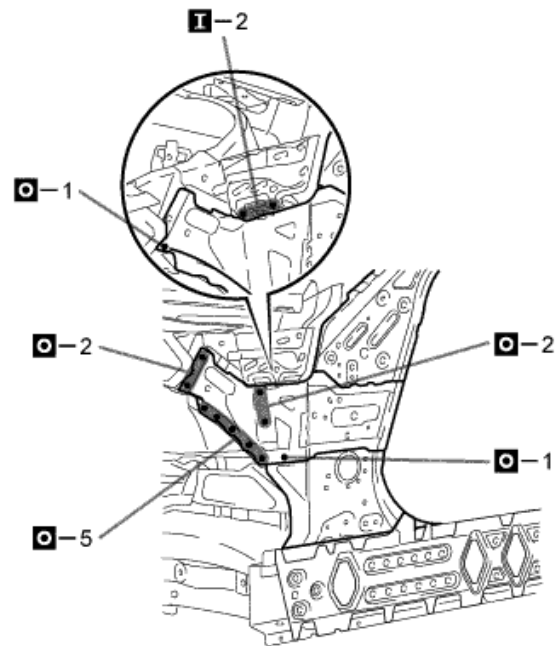


mm (in.)

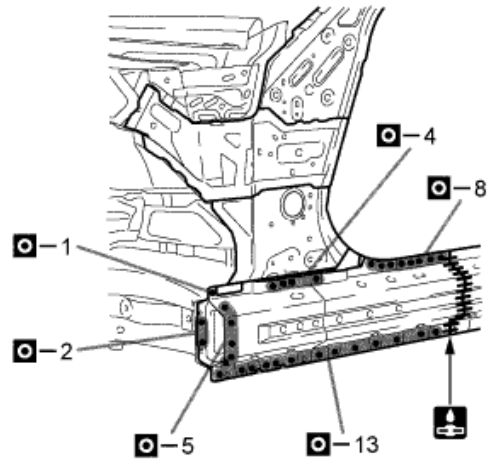


FRONT BODY LOWER INNER PILLAR

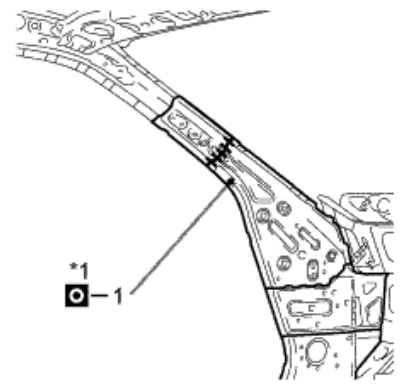
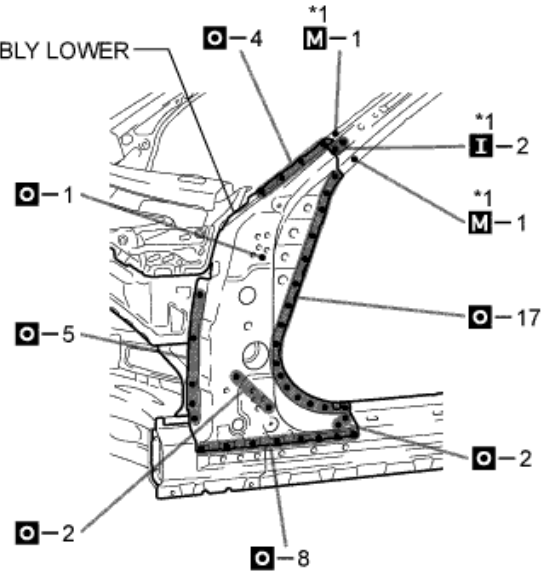


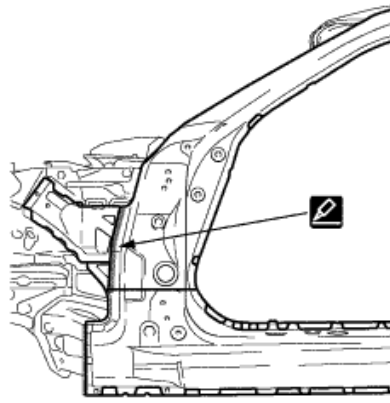


mm (in.)

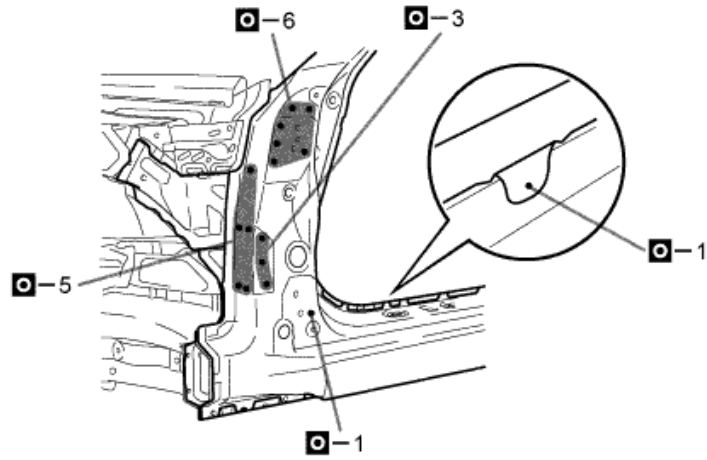
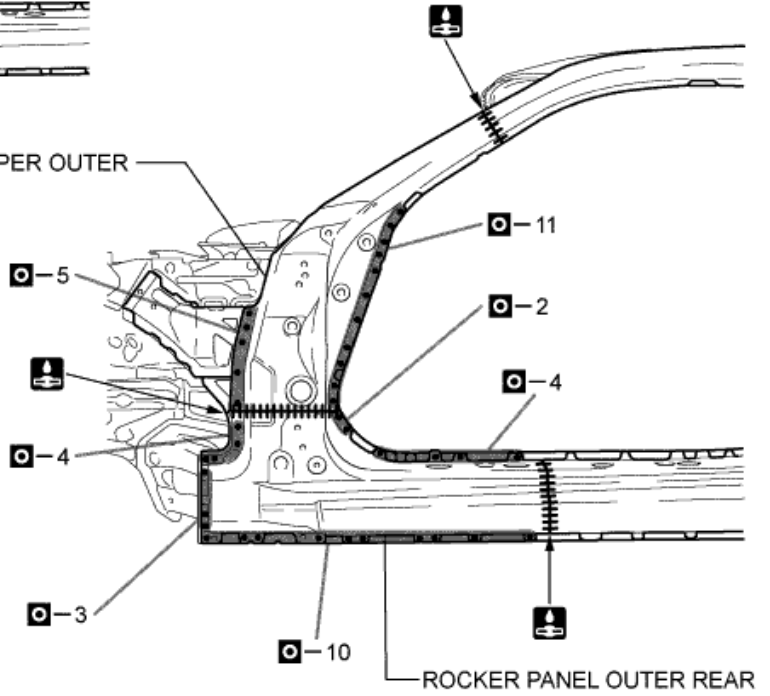


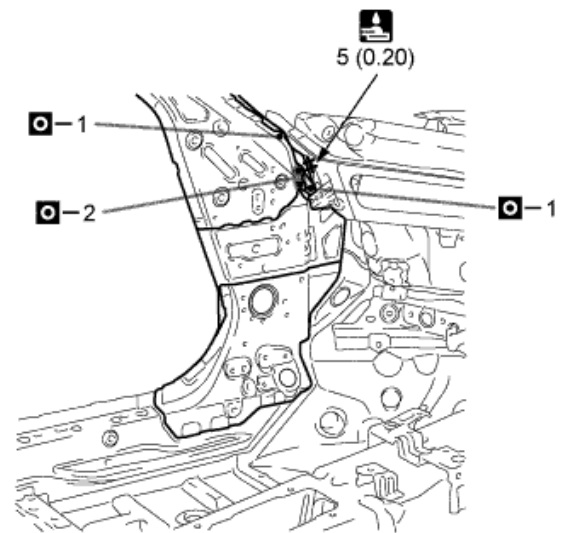
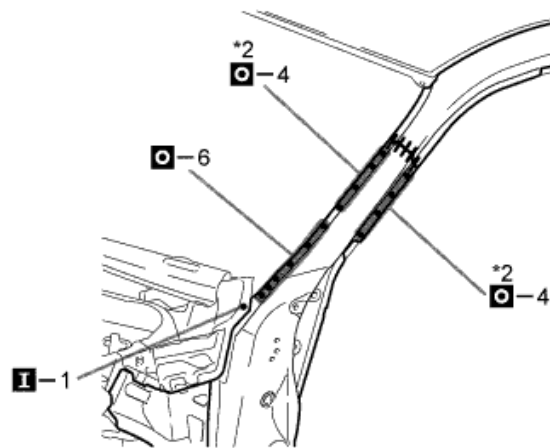
FRONT BODY PILLAR REINFORCE SUB-ASSEMBLY LOWER





FRONT BODY PILLAR UPPER OUTER



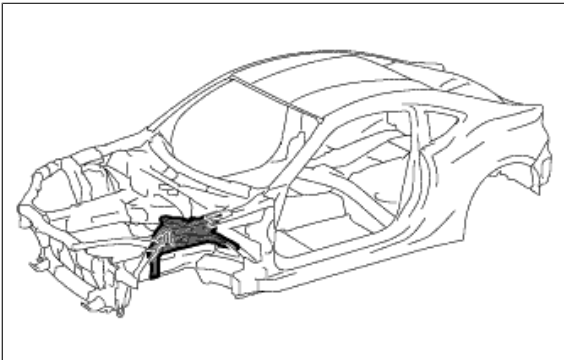


mm (in.)




FRONT FENDER APRON
> ASSEMBLY
REPLACEMENT

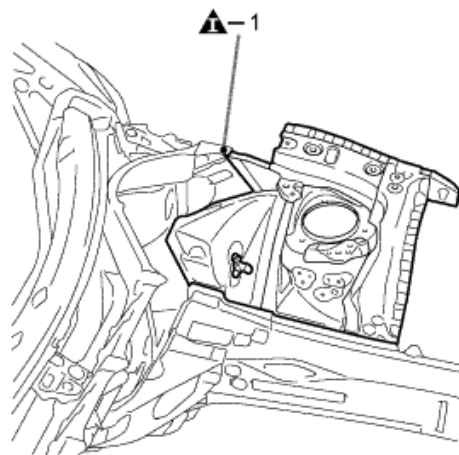
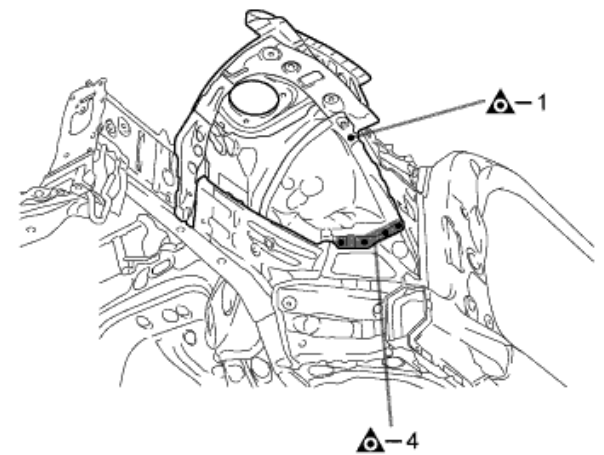
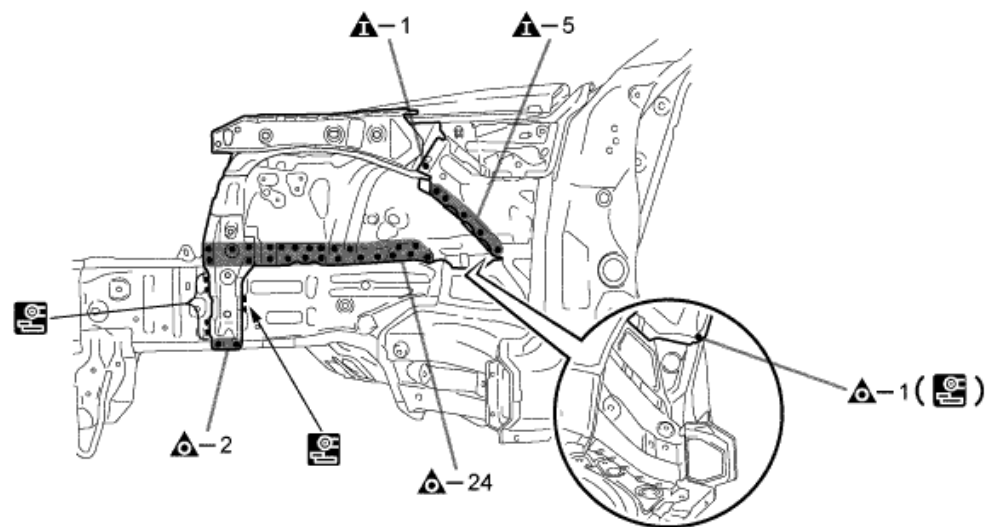
- REMOVAL
- INSTALLATION

With the front fender mounting bracket and front body pillar lower gusset removed.




REMOVAL

Symbol meaning	
	Remove Weld Points
	Remove Weld Points
	Cut with Disk Sander etc.



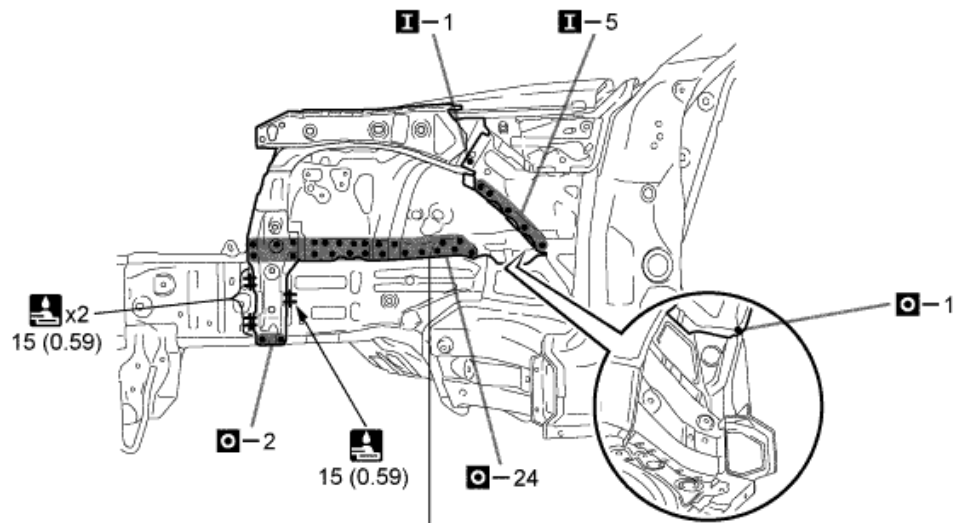
INSTALLATION

Symbol meaning	
	Plug Weld
	Plug Weld

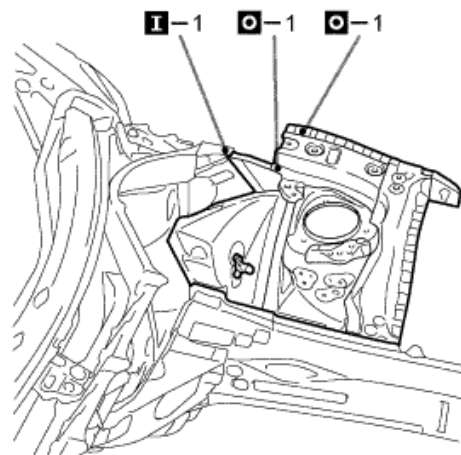
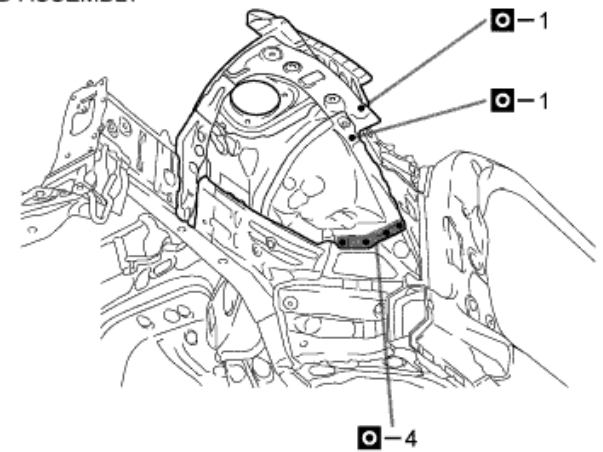
	
	Fillet Weld

INSTALLATION POINT

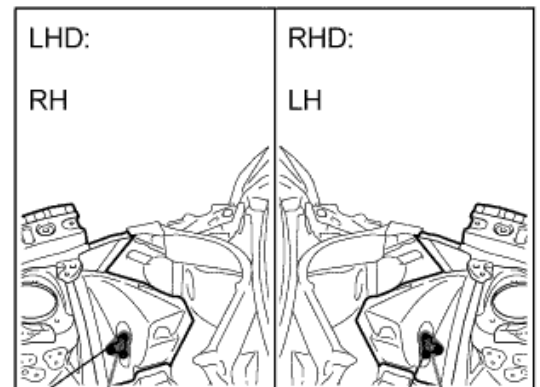
1. Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
2. Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
3. Make sure to attach correctly in accordance with the body dimension diagram as this part affects the front wheel alignment.
4. After welding, apply body sealer and undercoating to the corresponding parts. (See the painting / coating)
5. After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.



FRONT FENDER APRON SUB-ASSEMBLY



BATTERY CLAMP MOUNTING BRACKET



BATTERY CLAMP MOUNTING BRACKET

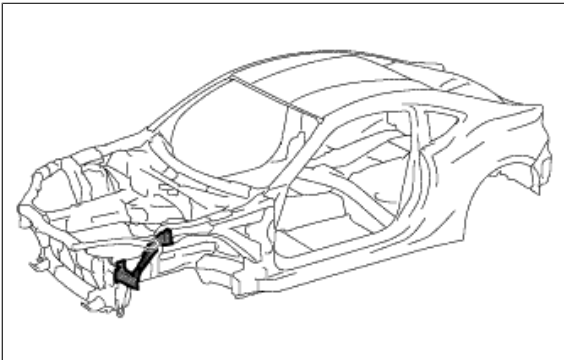
mm (in.)

FRONT FENDER MOUNTING BRACKET > ASSEMBLY REPLACEMENT

- REMOVAL
- INSTALLATION

FRONT FENDER MOUNTING BRACKET > ASSEMBLY REPLACEMENT

With the radiator side support removed.

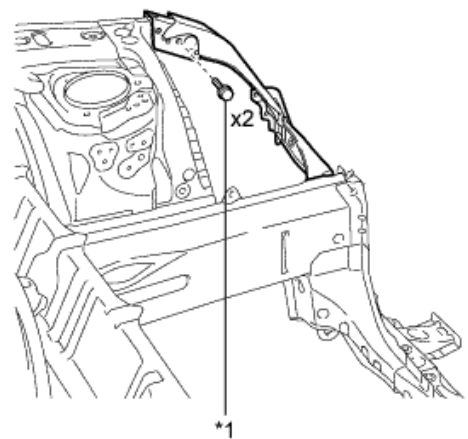
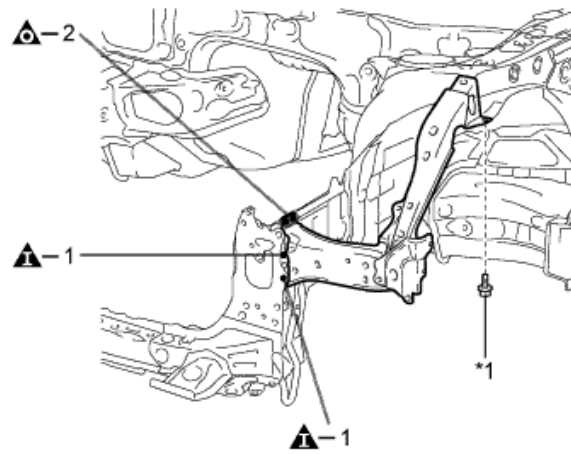


REMOVAL


Symbol meaning	
	Remove Weld Points
	Remove Weld Points

REMOVAL POINT

1. *1: Bolts.

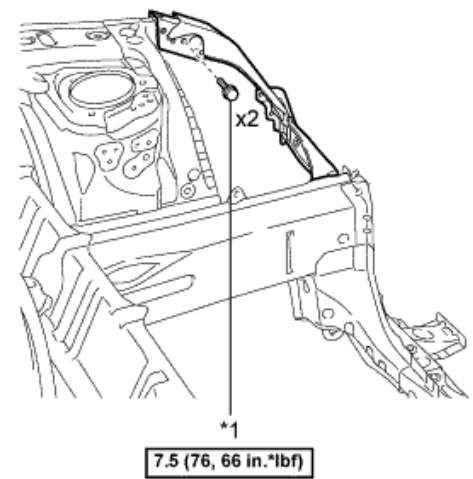
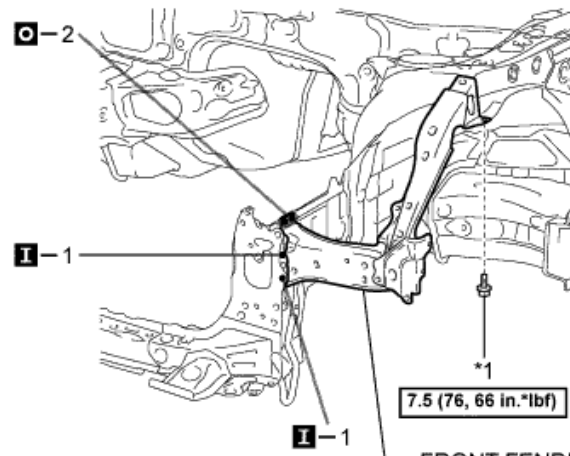


INSTALLATION

Symbol meaning	
	Plug Weld
	Plug Weld

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. *1: Bolts.
4. After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.



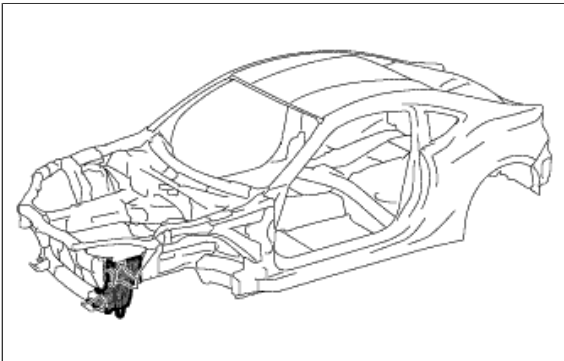
N*m (kgf*cm, ft.*lbf): Specified torque

FRONT SIDE MEMBER
> CUT AND JOIN
REPLACEMENT
SECTIONS (SMALL
AREAS)

- REMOVAL
- INSTALLATION

FRONT SIDE MEMBER > CUT AND JOIN REPLACEMENT SECTIONS (SMALL AREAS)

With the radiator support and front fender mounting bracket removed.



REMOVAL

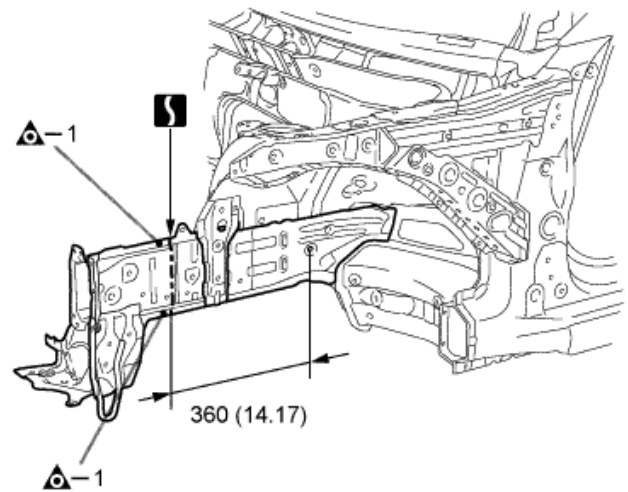
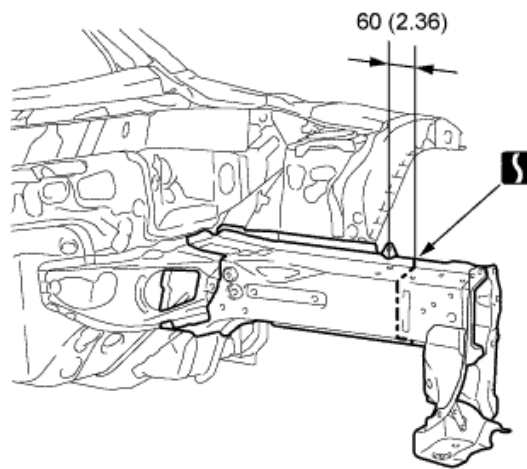
Symbol meaning	
	Remove Weld Points
	Cut and Join Location

REMOVAL POINT

1. Carefully cut the member so not to damage *1.

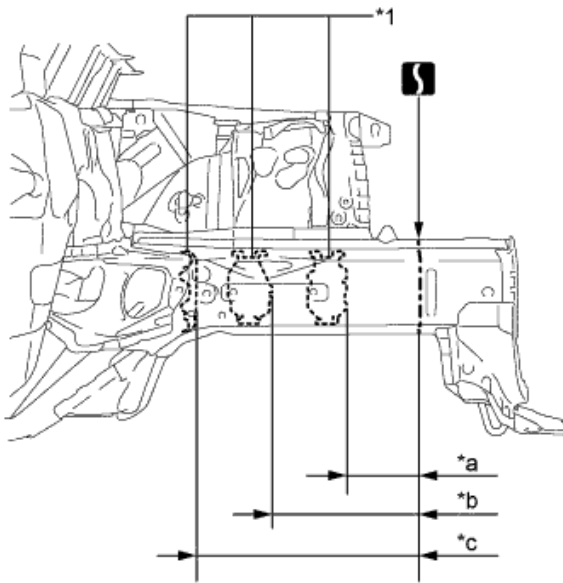
Reference Value

Area	Measurement	Area	Measurement
*a	135 mm (5.31 in.)	*b	271 mm (10.67 in.)
*c	410 mm (16.14 in.)	*d	135 mm (5.31 in.)
*e	271 mm (10.67 in.)	*f	410 mm (16.14 in.)

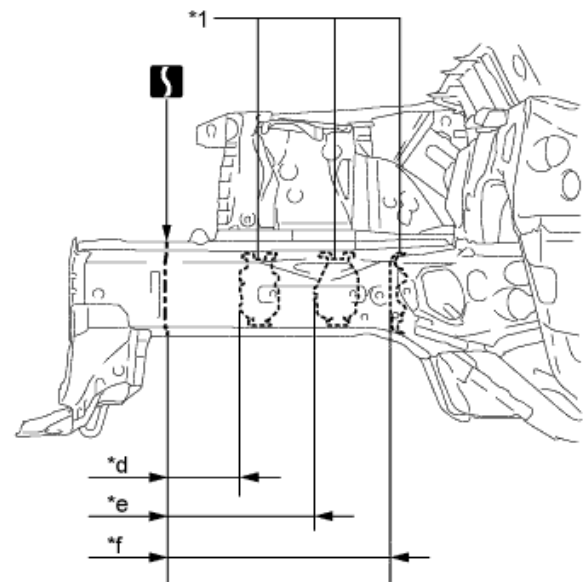


mm (in.)


LH:



RH:



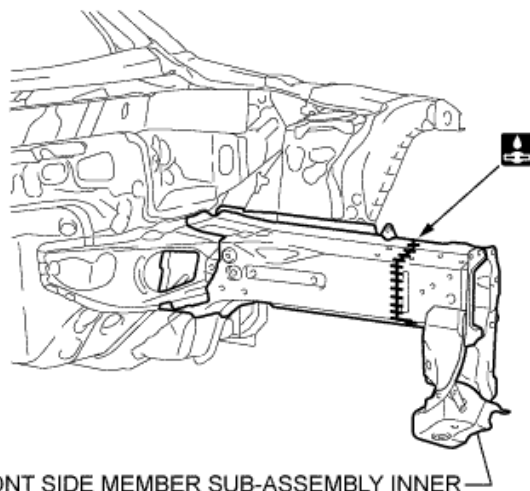
INSTALLATION

Symbol meaning	
	Plug Weld
	Butt Weld

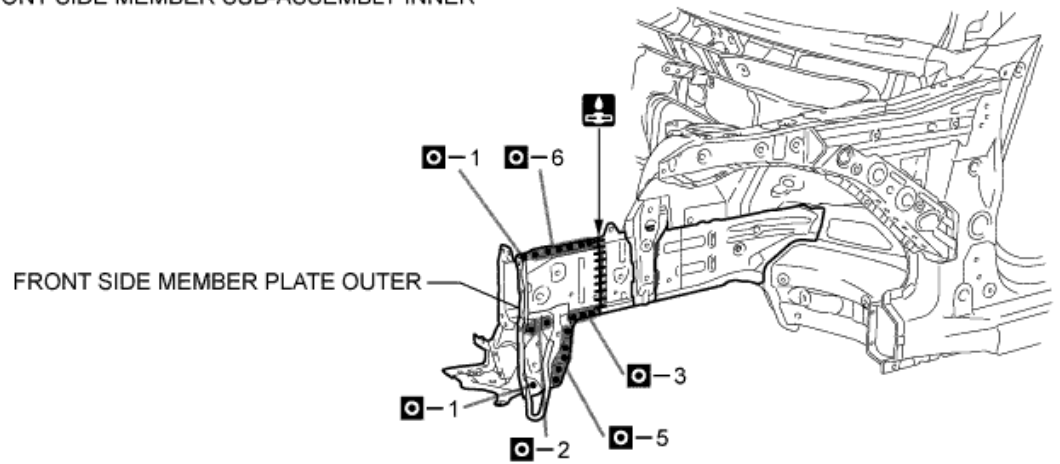


INSTALLATION POINT

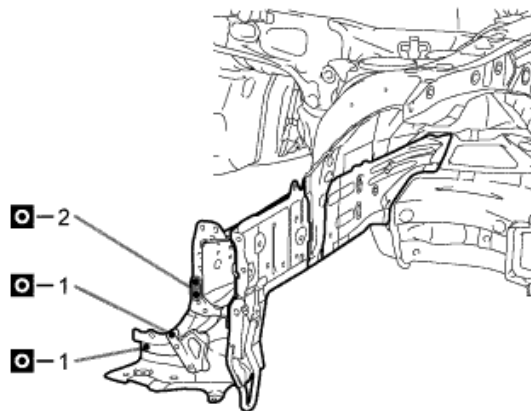
1. Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimensions)
2. After welding, apply body sealer and undercoating to the corresponding parts. (See the painting / coating)
3. After applying the top coat, apply anti-rust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



FRONT SIDE MEMBER SUB-ASSEMBLY INNER



FRONT SIDE MEMBER PLATE OUTER

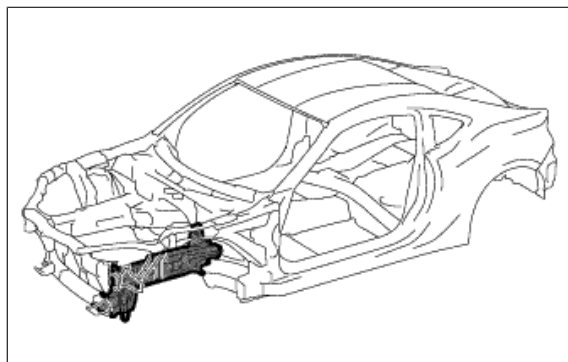


FRONT SIDE MEMBER > ASSEMBLY REPLACEMENT (PATTERN 1)

- REMOVAL
- INSTALLATION

FRONT SIDE MEMBER > ASSEMBLY REPLACEMENT (PATTERN 1)

With the radiator support and front fender mounting bracket removed.

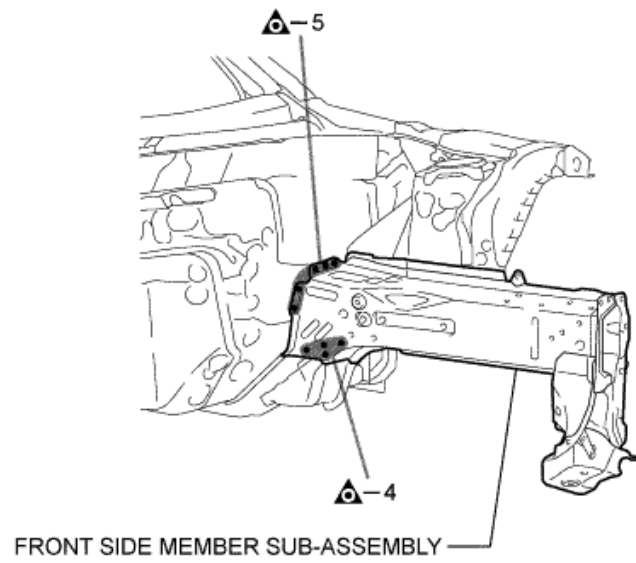
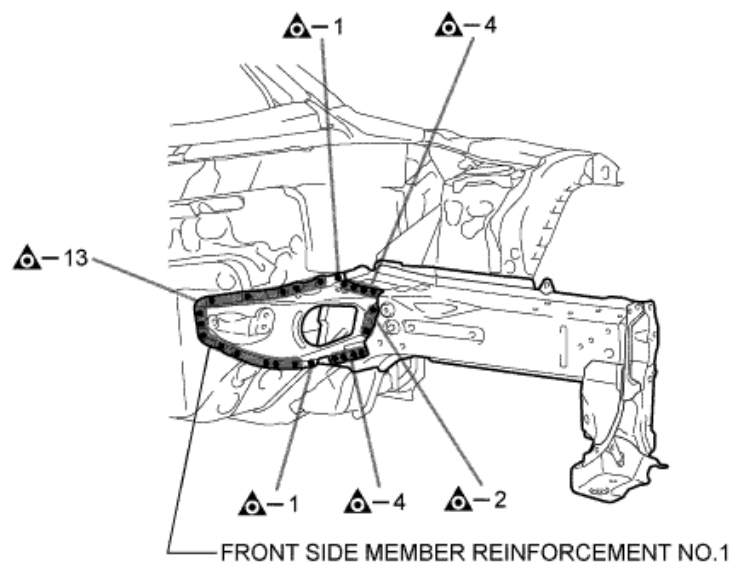


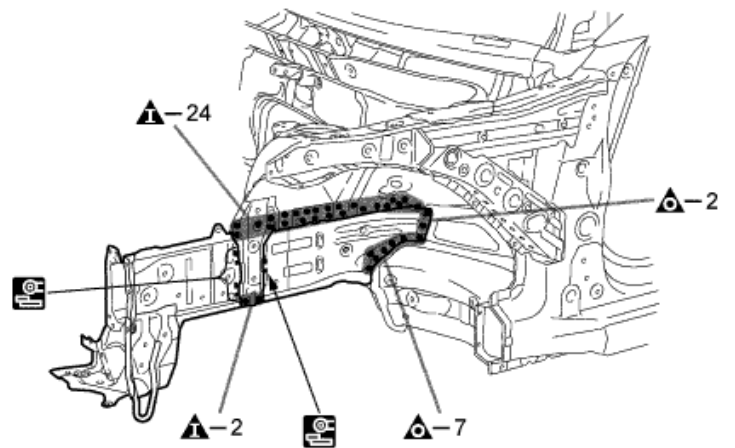
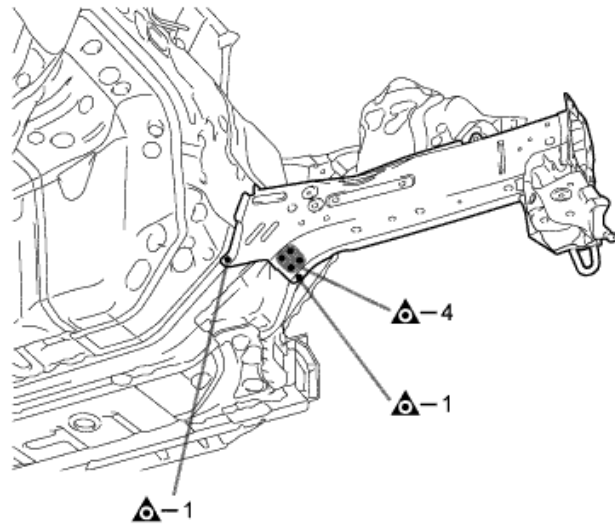
REMOVAL

Symbol meaning	
	Remove Weld Points
	Remove Weld Points
	Cut with Disk Sander etc.

REMOVAL POINT

1. After removing the front side member reinforcement No.1, remove the front side member sub-assembly.





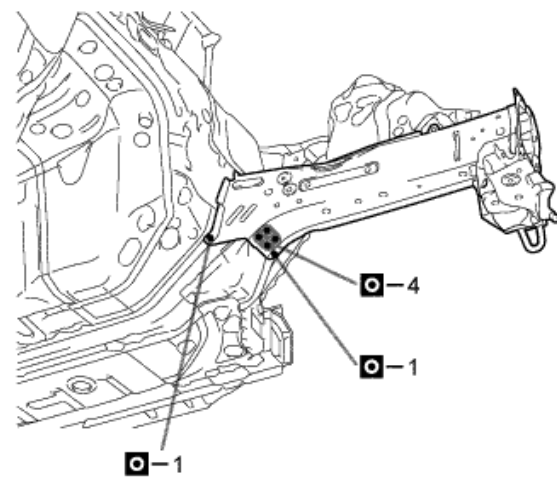
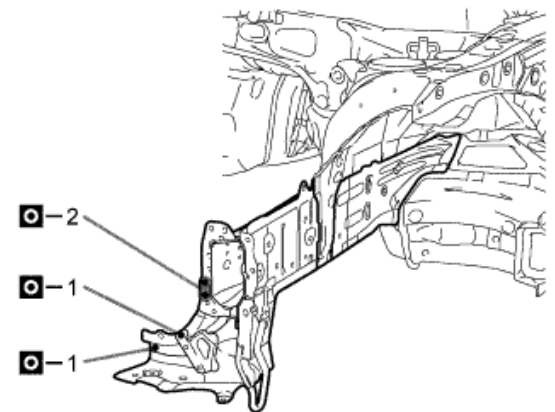
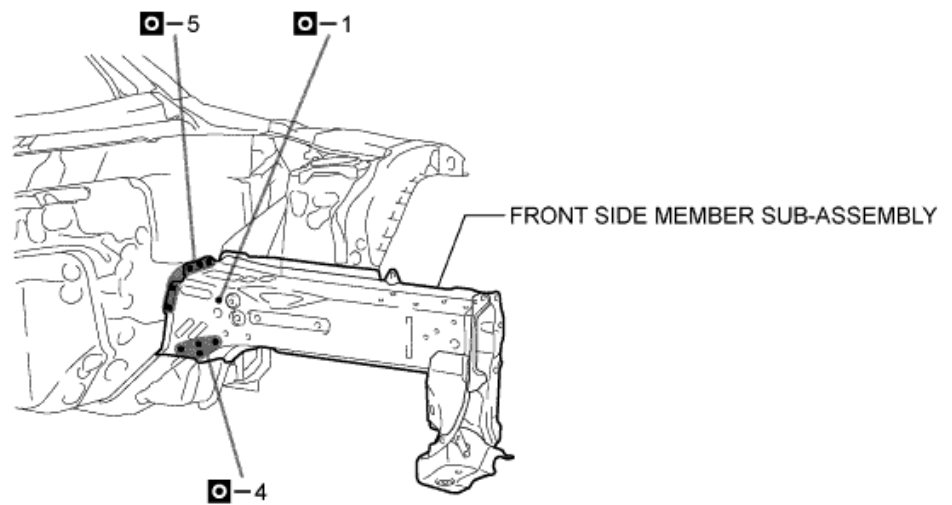
INSTALLATION

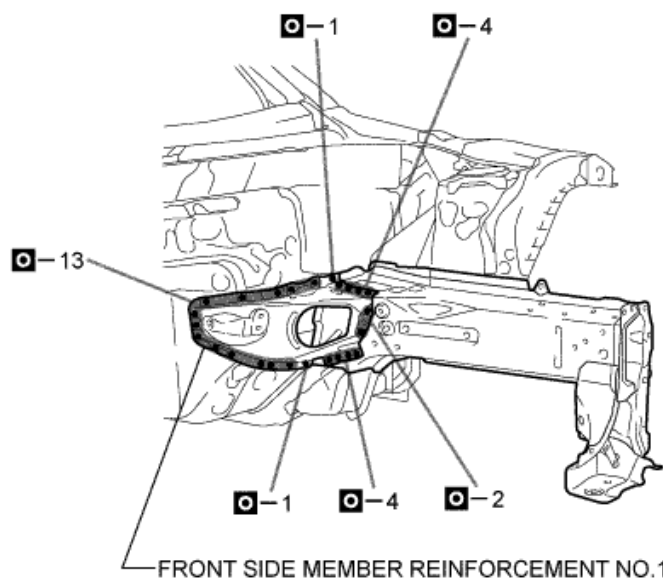
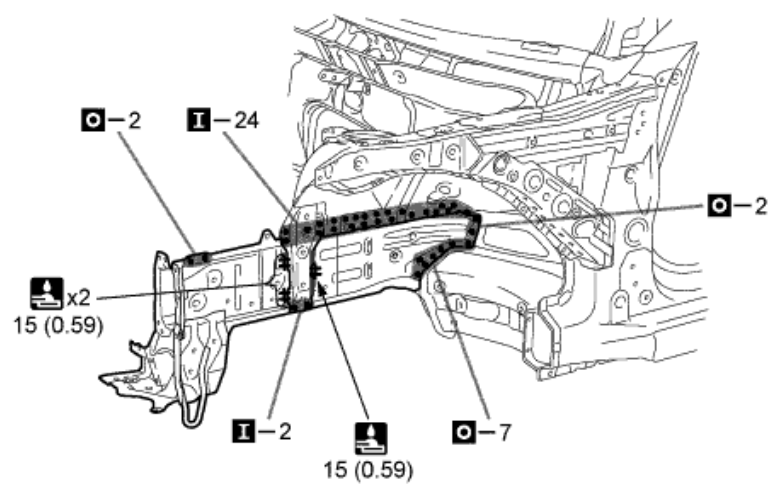
Symbol meaning	
	Plug Weld
	Plug Weld

	
	Fillet Weld

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 dimensions)
2. After welding the front side member sub-assembly to the vehicle side, install the front side member reinforcement No.1.
3. Make sure to attach correctly in accordance with the body dimension diagram as this part affects the front wheel alignment.
4. After welding, apply body sealer and undercoating to the corresponding parts. (See the painting / coating)
5. After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.





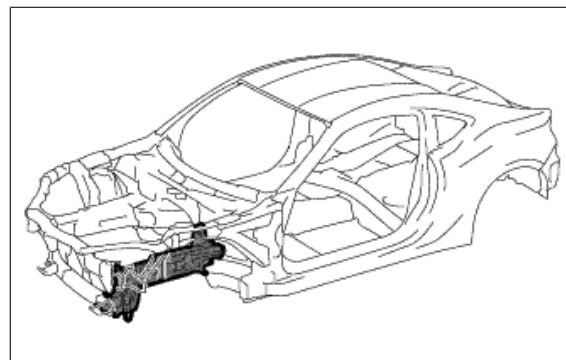
mm (in.)

FRONT SIDE MEMBER > ASSEMBLY REPLACEMENT (PATTERN 2)

- REMOVAL
- INSTALLATION

FRONT SIDE MEMBER > ASSEMBLY REPLACEMENT (PATTERN 2)

With the radiator support and front fender apron removed.

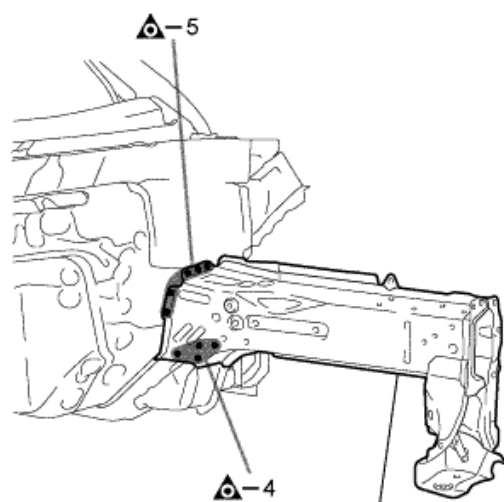
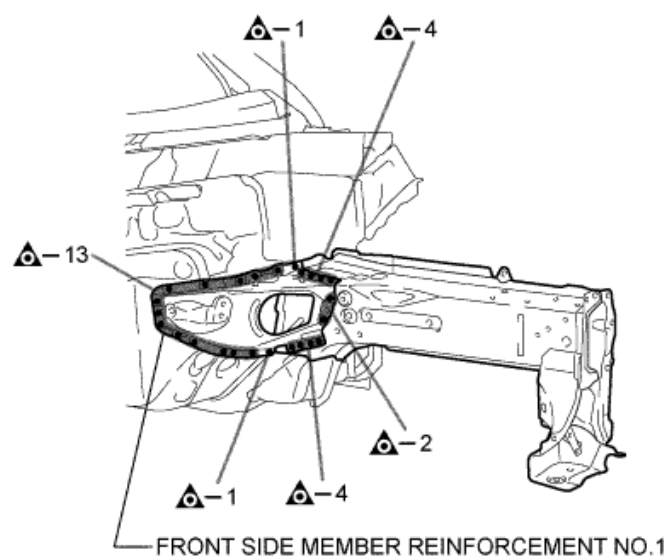


REMOVAL

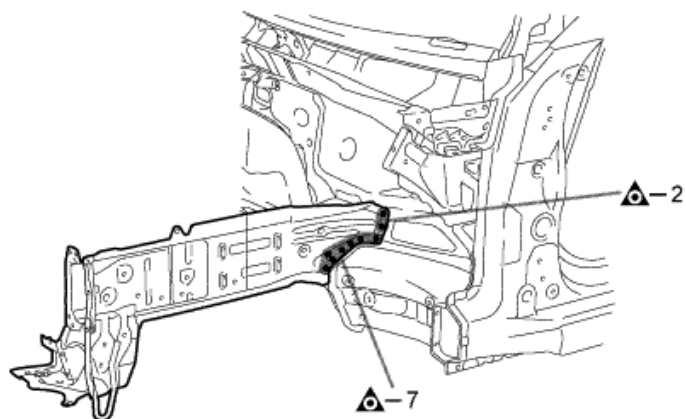
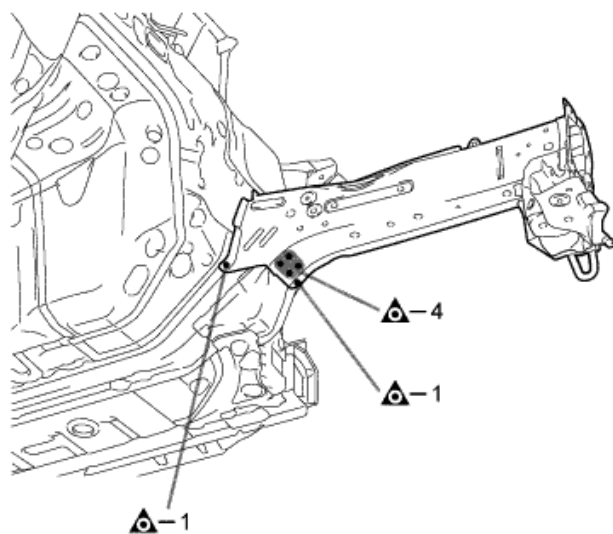
Symbol meaning	
	Remove Weld Points

REMOVAL POINT


1. After removing the front side member reinforcement No.1, remove the front side member sub-assembly.



FRONT SIDE MEMBER SUB-ASSEMBLY

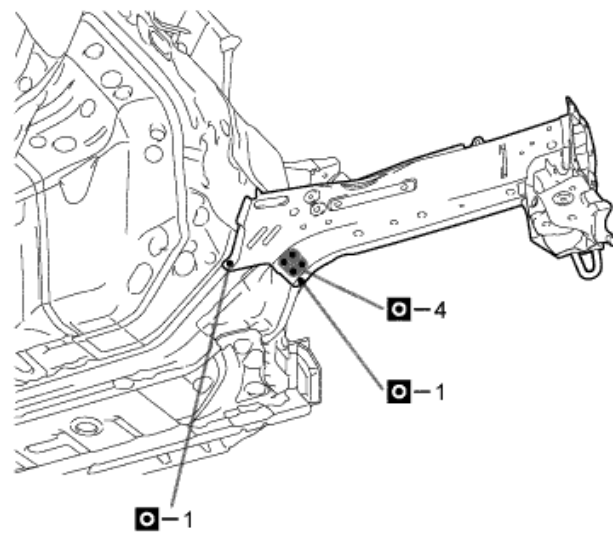
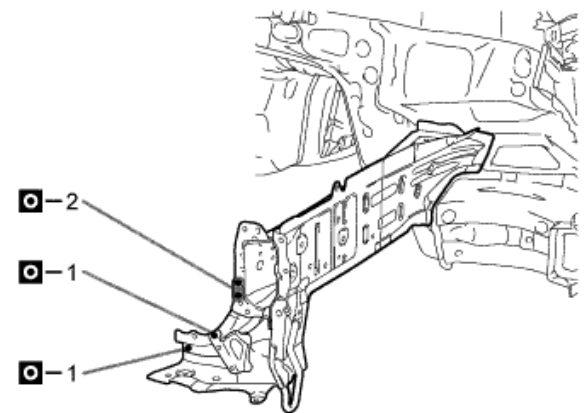
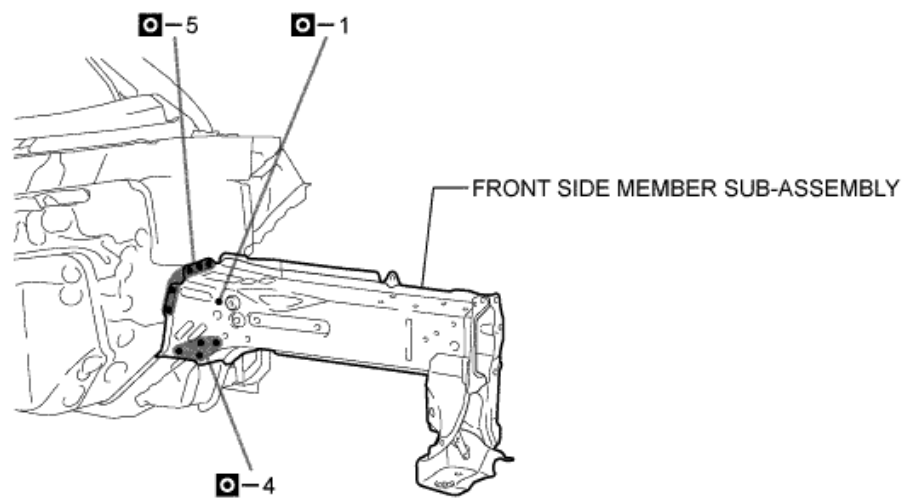


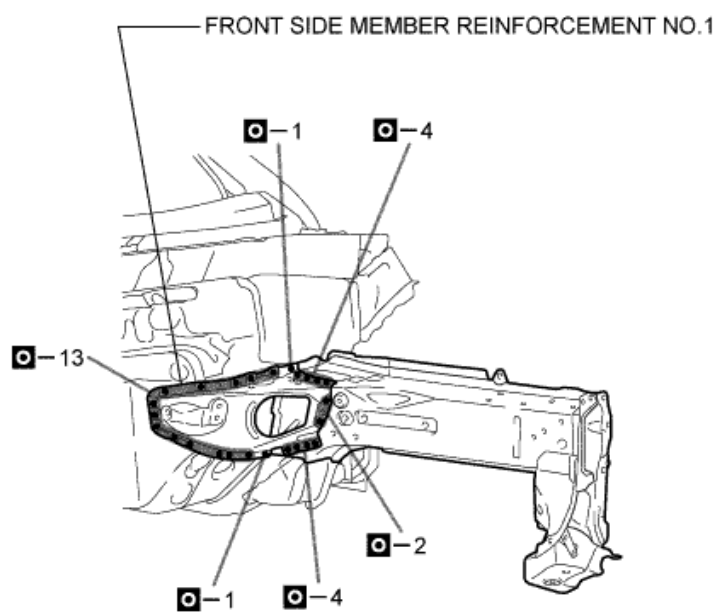
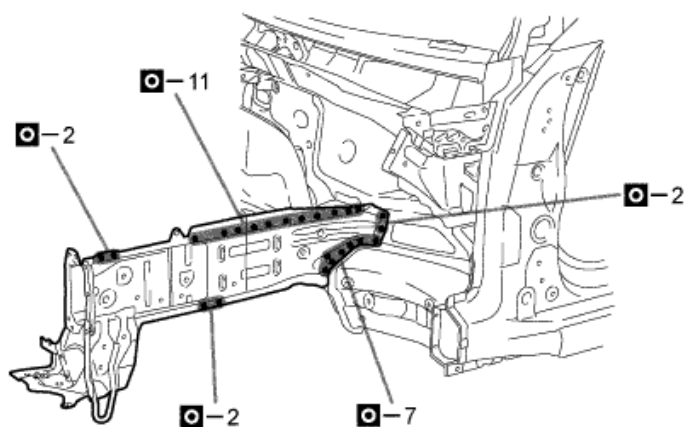
INSTALLATION

Symbol meaning	
	Plug Weld

INSTALLATION POINT

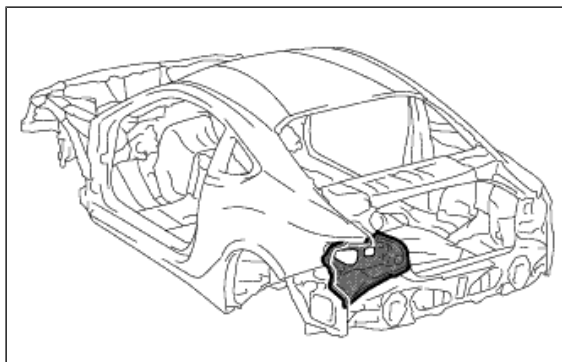
1. Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimensions)
2. After welding the front side member sub-assembly to the vehicle side, install the front side member reinforcement No.1.
3. Make sure to attach correctly in accordance with the body dimension diagram as this part affects the front wheel alignment.
4. After welding, apply body sealer and undercoating to the corresponding parts. (See the painting / coating)
5. After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.








QUARTER PANEL END HOUSING > ASSEMBLY REPLACEMENT

- REMOVAL
- INSTALLATION



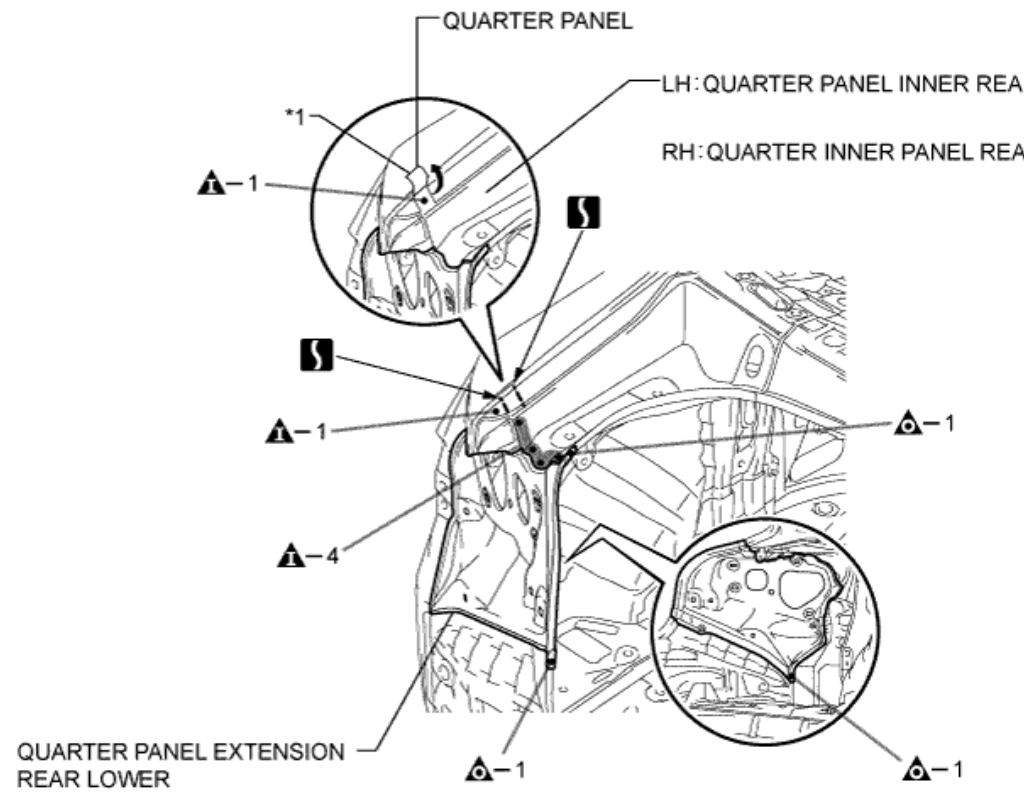
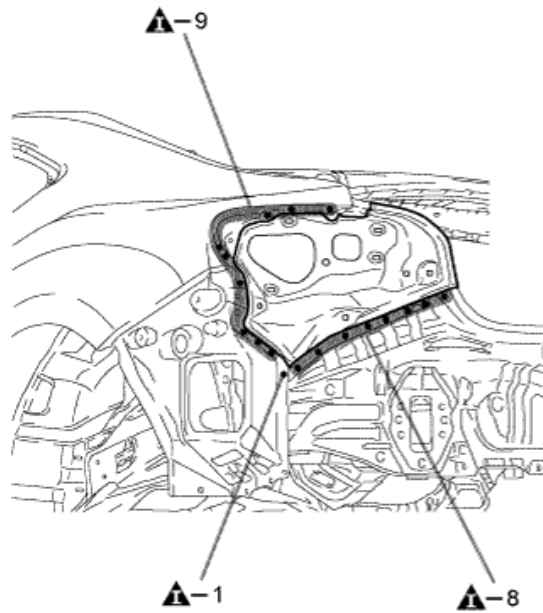
QUARTER PANEL END HOUSING > ASSEMBLY REPLACEMENT

REMOVAL


Symbol meaning	
	Remove Weld Points
	Remove Weld Points
	Cut with Disc Sander etc.

REMOVAL POINT

1. Cut the quarter panel and fold it upward as shown in *1. Then cut through the welded area of the quarter panel inner rear and quarter inner panel rear, and remove the quarter panel extension rear lower.



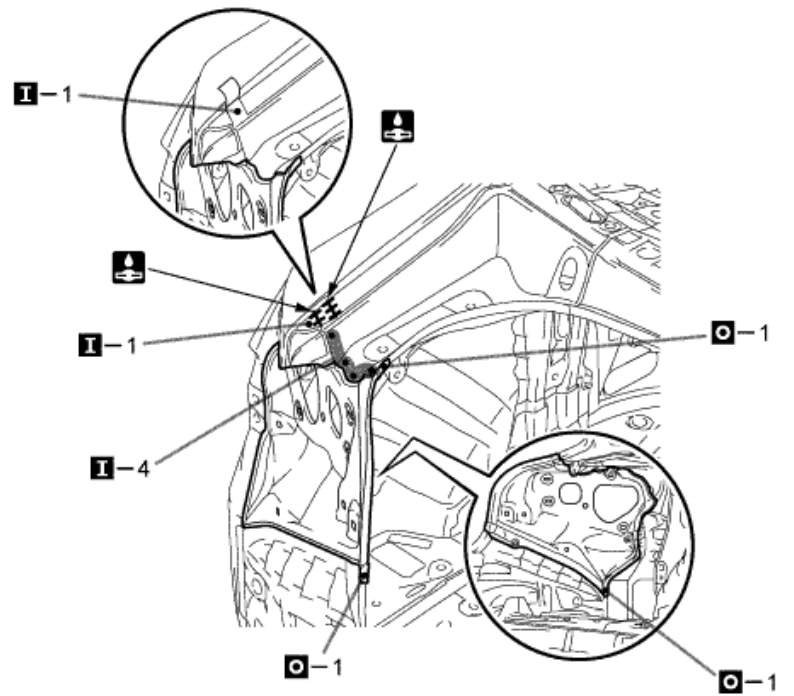
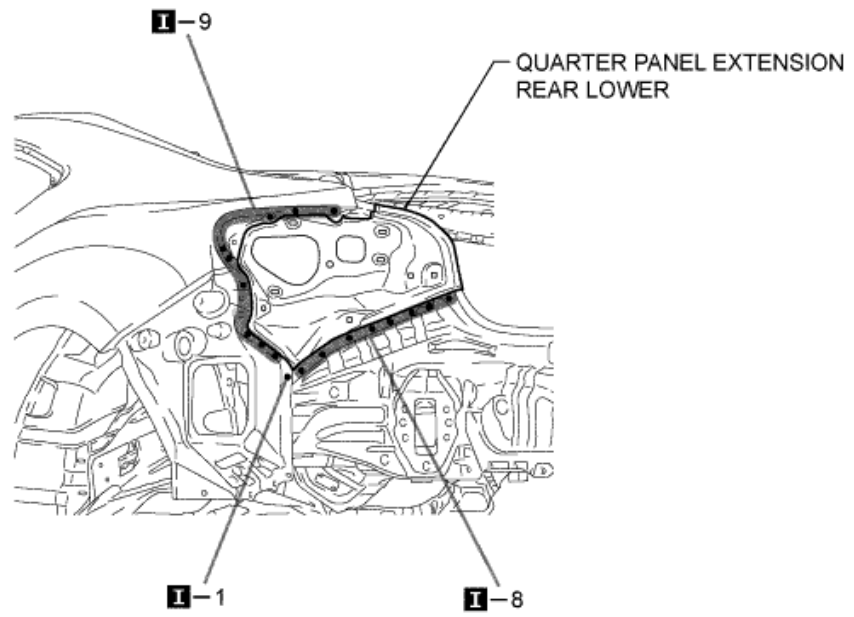
INSTALLATION

Symbol meaning	
	Plug Weld
	Plug Weld

	
	Butt Weld

INSTALLATION POINT

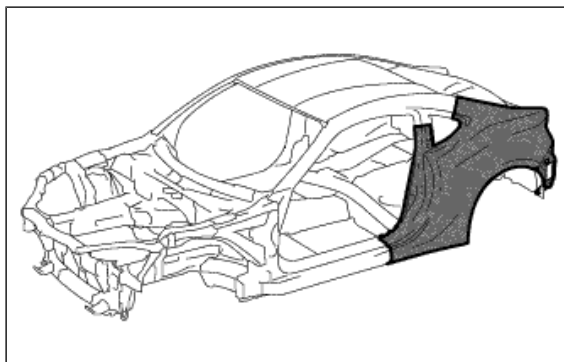
1. Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
2. Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimensions)
3. After welding, apply body sealer to the corresponding parts. (See the painting / coating)
4. After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.



QUARTER PANEL > CUT AND JOIN REPLACEMENT SECTIONS

- REMOVAL
- INSTALLATION

QUARTER PANEL > CUT AND JOIN REPLACEMENT SECTIONS



Quarter Panel Replacement Using Adhesive

Work Procedure

1. Cut the wheel arch portion.
2. Heat the quarter panel adhesive area and remove the quarter panel.

HINT:

Using an industrial heater gun or gas burner, heat the quarter panel to 110 to 140°C. Make sure the quarter panel does not warp.

3. Clean off any adhesive that remains on the vehicle.

HINT:

- Using an industrial heater gun or gas burner, heat the adhesive to 110 to 140°C.
- Using a scraper, scrape away the adhesive.
- If adhesive remains, the strength of any subsequently applied adhesive will be weak.

4. Using a disc grinder or belt sander, scuff and sand any adhesive that remains on the vehicle.

HINT:

Scuff at a width of approximately 10 mm (0.39 in.) over the previous adhesive coating.




5. Apply adhesive to the exposed metal areas on the vehicle. Using a spatula, spread the adhesive evenly.
6. Apply adhesive to the vehicle again.
7. Using #60-120 grit sandpaper, scuff the adhesive application area on the new quarter panel.
8. Apply adhesive to the new quarter panel. Using a spatula, spread the adhesive evenly.
9. Using a vise grip or the palms of your hands, press the quarter panel so that the thickness of the adhesive is even.
10. Complete installation the new quarter panel.
11. Dry the adhesive areas of the new quarter panel.

HINT:

- With dryer or equivalent (60°C): 60 minutes (complete hardening: 90 minutes)
- Ambient temperature (25°C): 12 hours (complete hardening: 24 hours)

REMOVAL

Symbol meaning

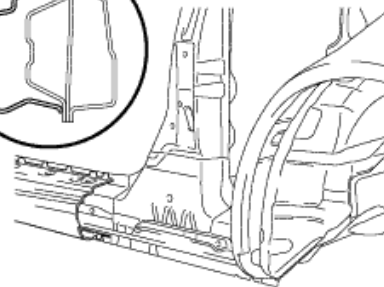
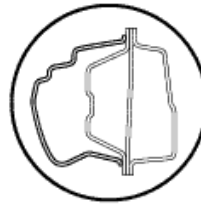
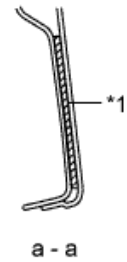
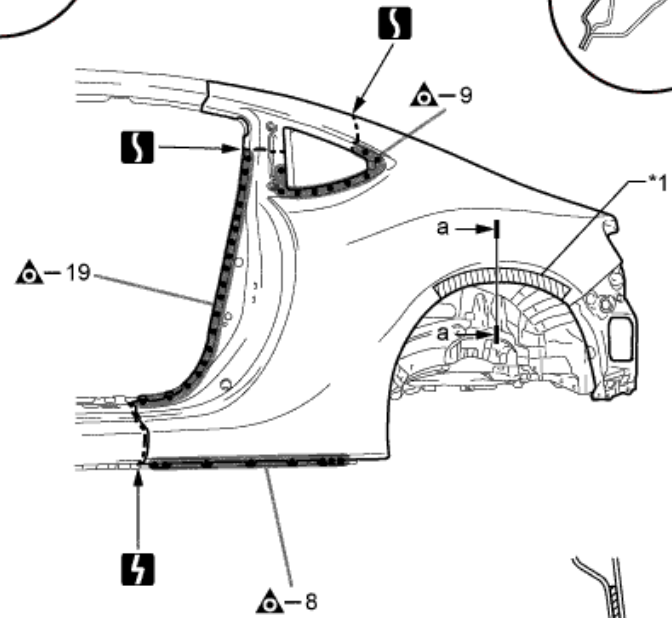
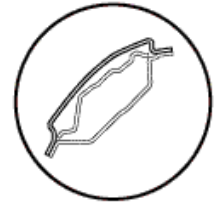
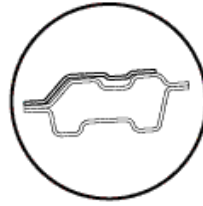
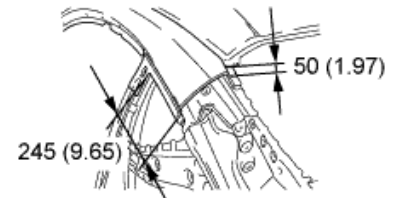
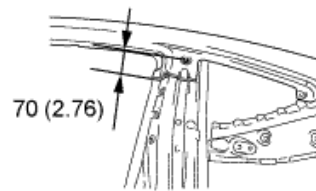
	Remove Weld Points
	Remove Weld Points
	Remove Weld Points
	Cut and Join Location
	Cut Location for Supply Parts

REMOVAL POINT

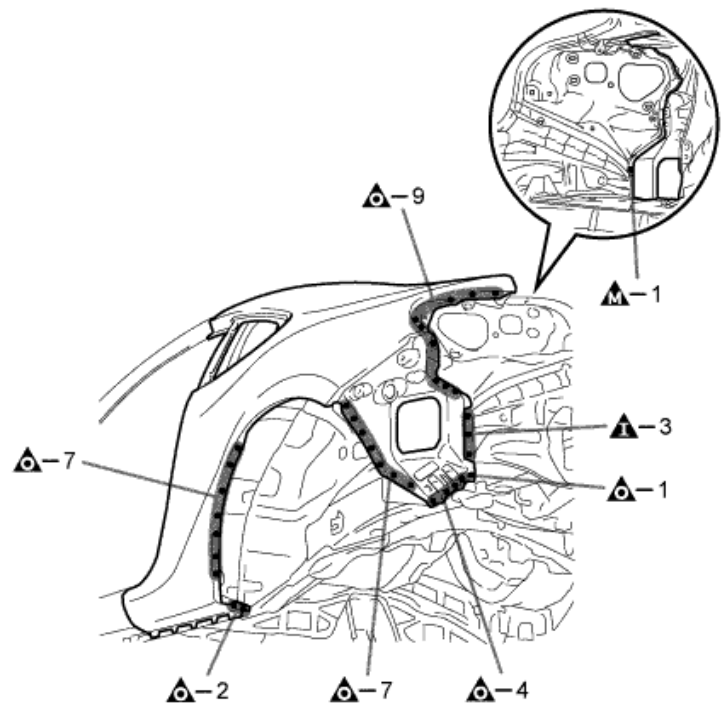
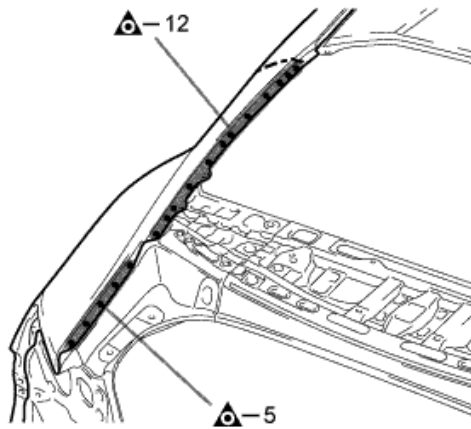
1. *1 in illustration above indicates where the adhesive is located.
2. Roughly cut open the panel so that the adhesive can be reached. Cut through the adhesive with a cut chisel to remove the panel.

HINT:

In cases where the adhesive cannot be removed with a cut chisel, heat the adhesive with an industrial heater gun or gas burner taking care not to cause panel deformation by overheating.







mm (in.)



INSTALLATION

Symbol meaning	
⊙	Spot Weld
	Plug Weld

	
	Plug Weld
	Plug Weld
	Butt Weld

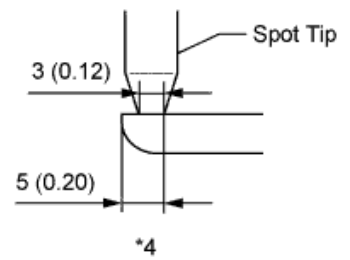
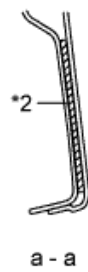
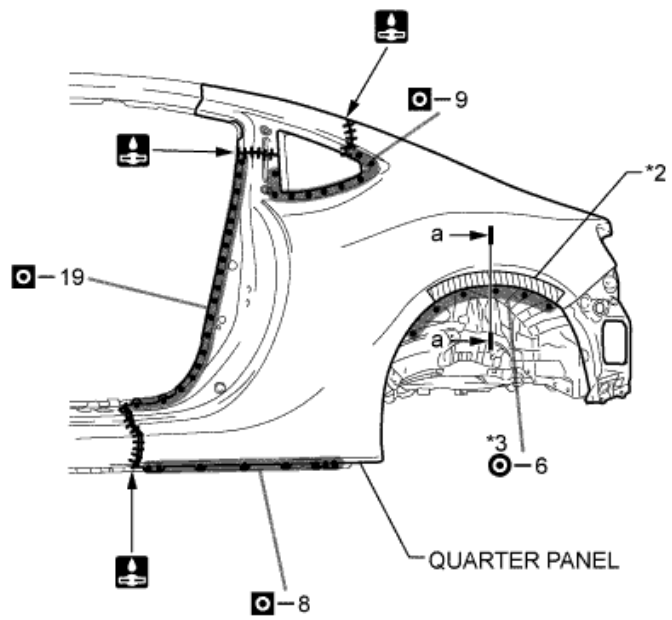
INSTALLATION POINT

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 dimensions)
3. When welding *1, make a hole on a new part for plug welding and weld the panel with the panel behind completely.
4. Apply adhesive (3M™ Automix™ Panel Bonding Adhesive #8115) to the area indicated by *2 in the illustration.

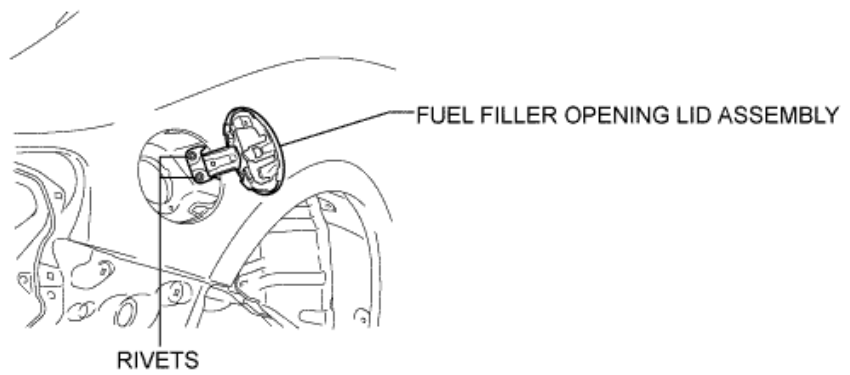
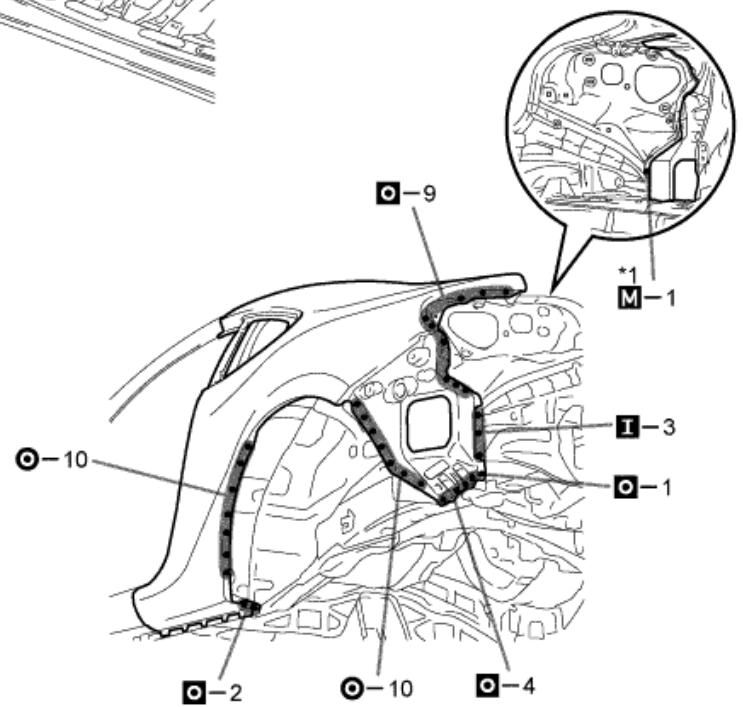
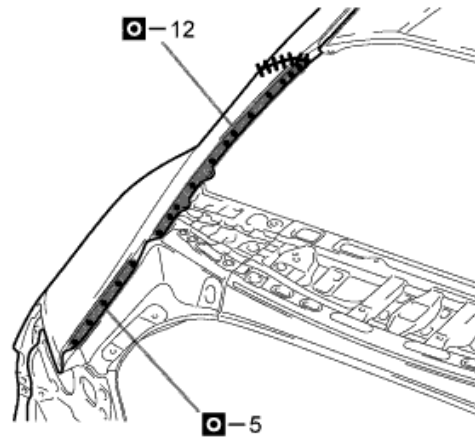
HINT:

Apply enough adhesive for the panels to stick to each other.

5. Perform spot-welding on the flange indicated by *3 in the illustration. Modify/cut the spot tip as shown in the illustration*4 so that it can fit in to the narrow flange.
6. After welding, apply body sealer to the corresponding parts. (See the painting / coating)
7. After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.



mm (in.)

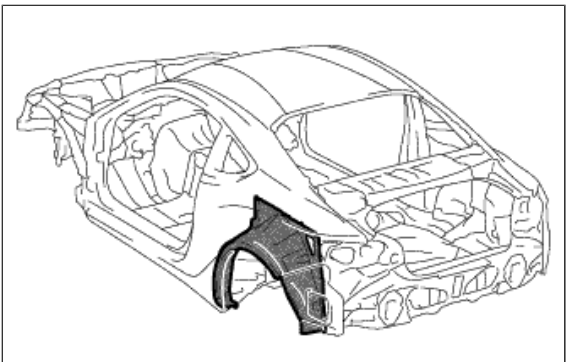


QUARTER WHEEL HOUSING OUTER PANEL > ASSEMBLY REPLACEMENT

- REMOVAL
- INSTALLATION

QUARTER WHEEL HOUSING OUTER PANEL > ASSEMBLY REPLACEMENT

With the quarter panel removed.



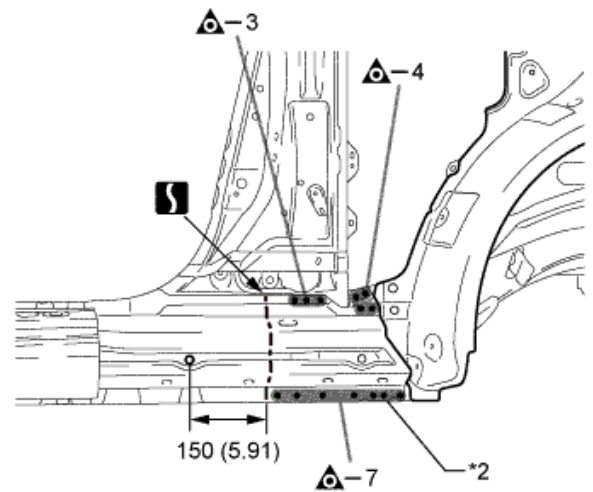
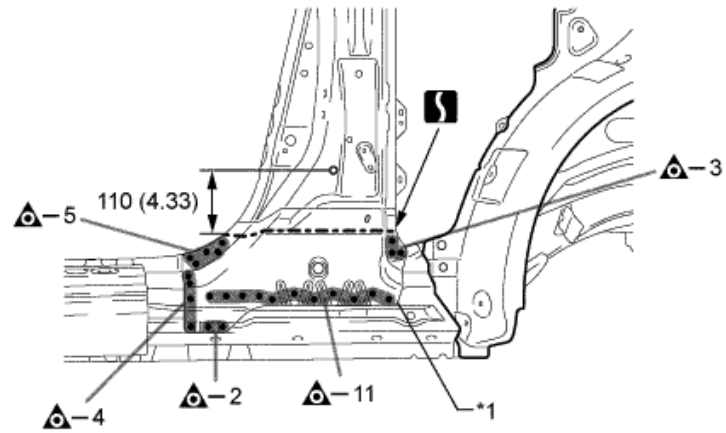
REMOVAL

Symbol meaning	
	Remove Weld Points
	Remove Weld Points
	Remove Weld Points
	Cut and Join Location

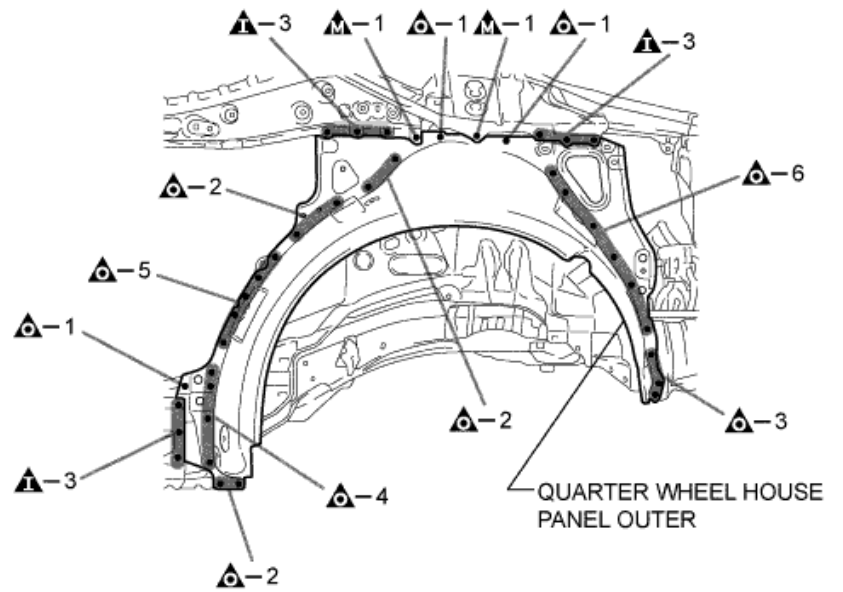
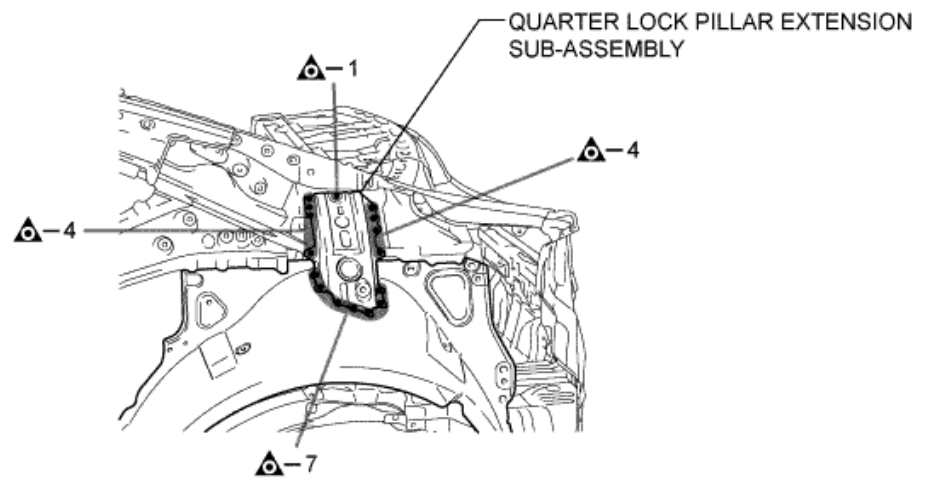
REMOVAL POINT

1. *1 and *2 is reused.
2. After removing the *1, *2 and quarter lock pillar extension sub-assembly, remove the quarter wheel house panel outer.

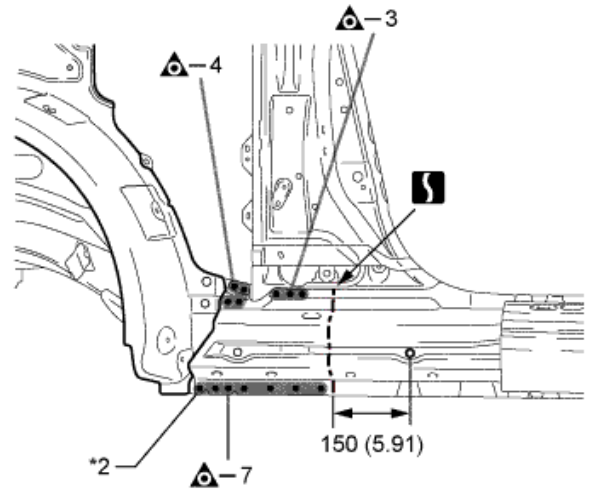
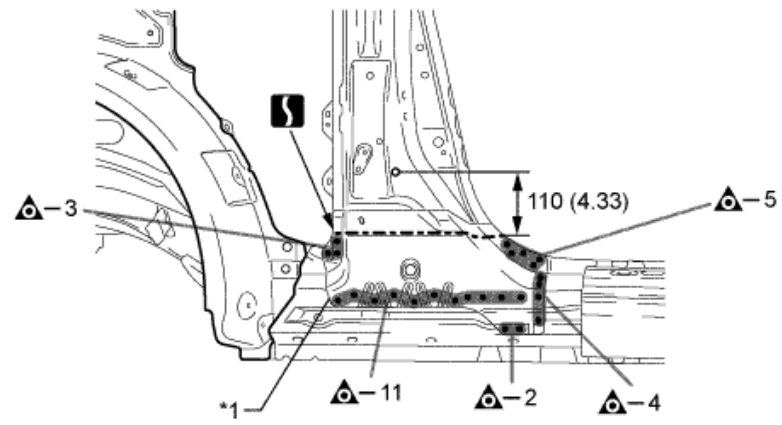
LH:



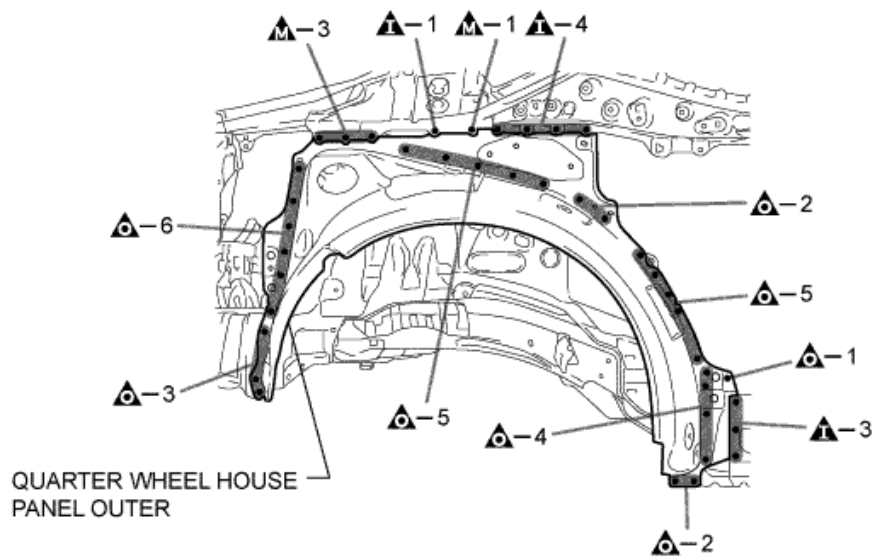
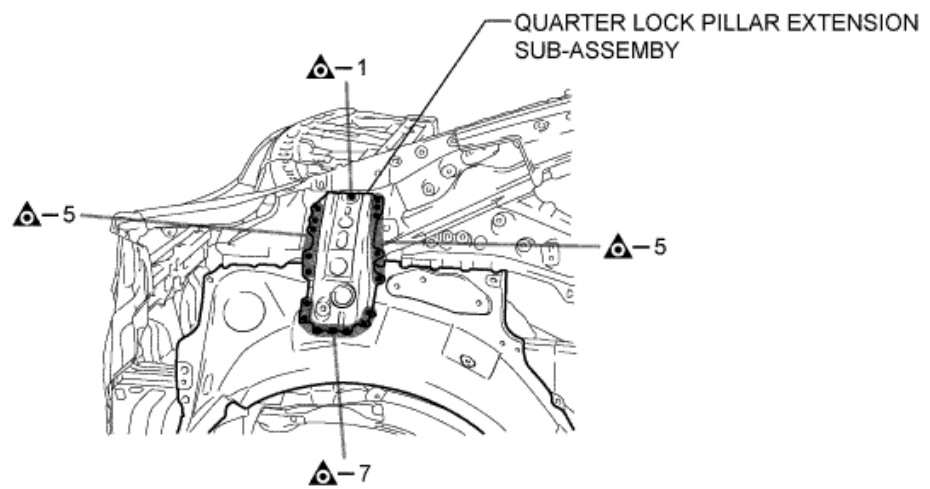
mm (in.)



RH:








mm (in.)



INSTALLATION

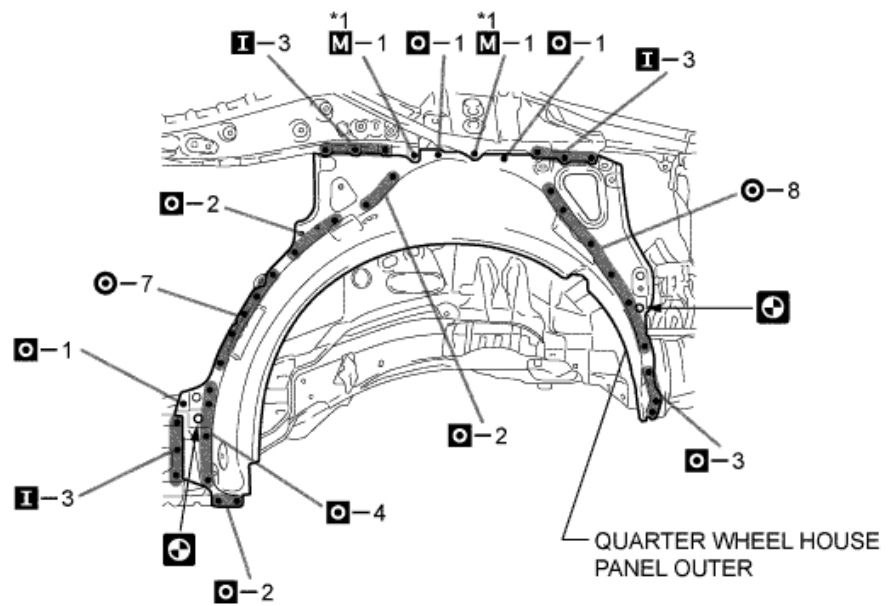
Symbol meaning	
⊙	Spot Weld
	Plug Weld

	
	Plug Weld
	Plug Weld
	Butt Weld
	Assembly Mark

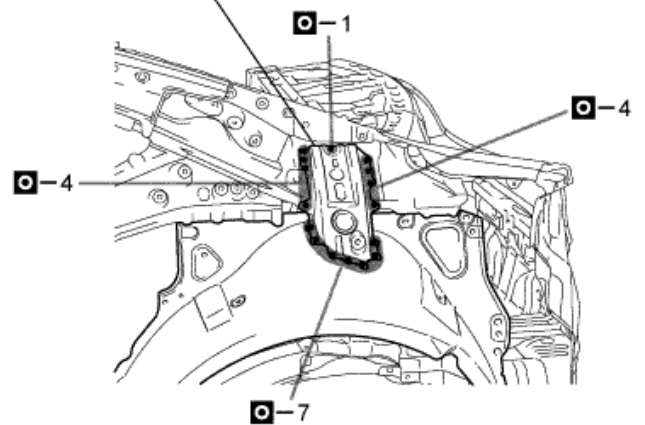
INSTALLATION POINT

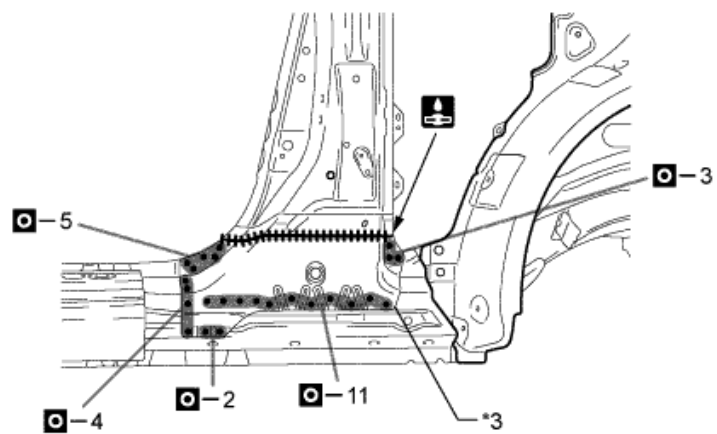
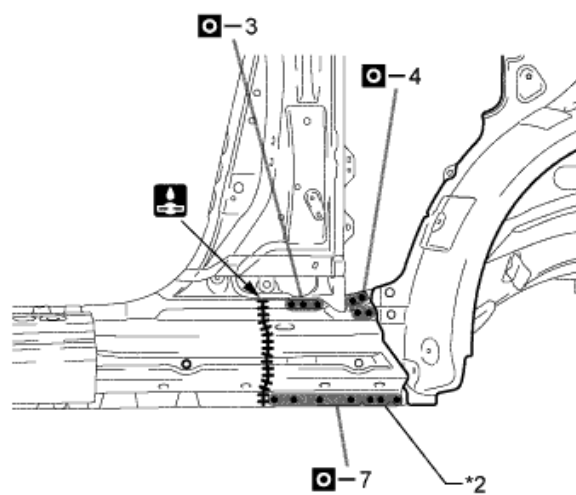
1. When welding *1, make a hole on a new part for plug welding and weld the panel with the panel behind completely.
2. For positioning of the new parts, align the installation standard holes of the outer panel and the inner panel.
3. After welding the quarter wheel house panel outer to the vehicle side, install the quarter lock pillar extension sub-assembly, *1 and *2.
4. After welding, apply body sealer and undercoating to the corresponding parts. (See the painting / coating)
5. After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

LH:

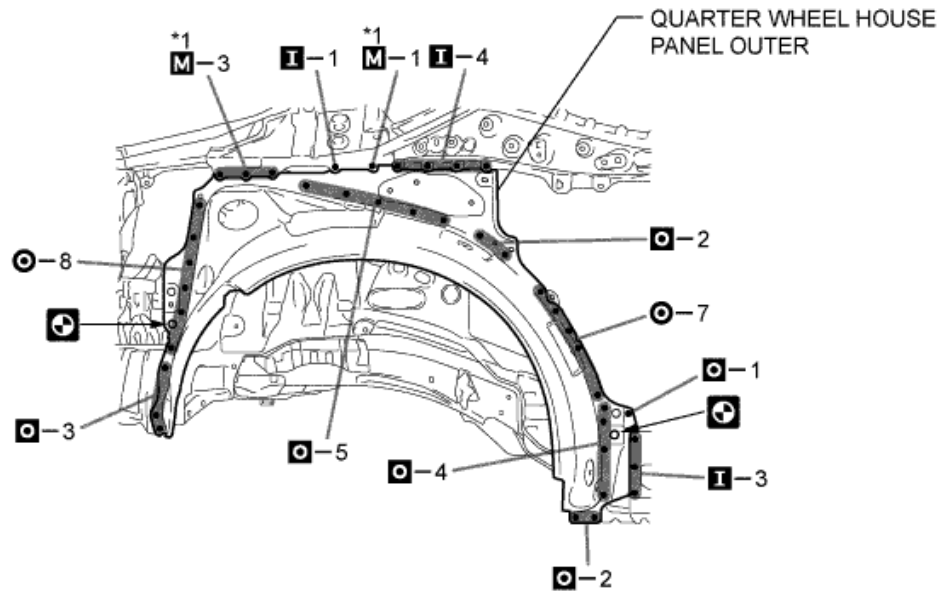


QUARTER LOCK PILLAR EXTENSION
SUB-ASSEMBLY

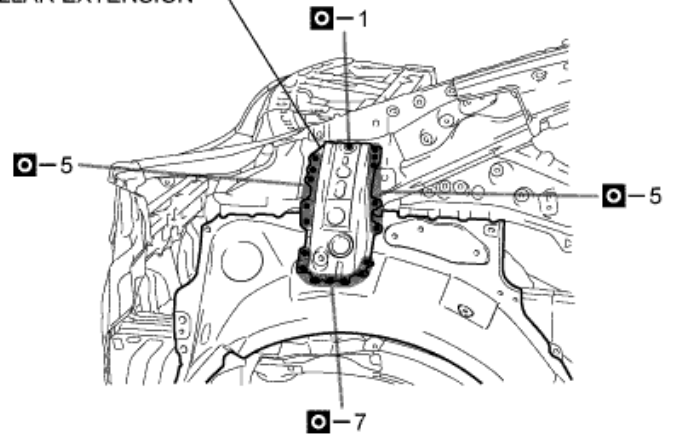


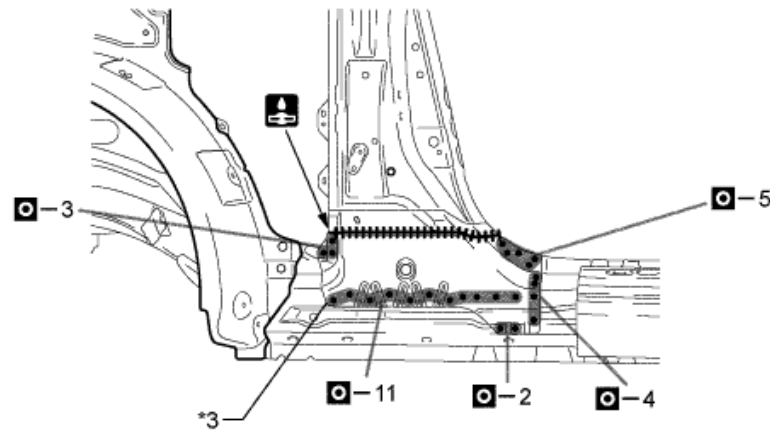
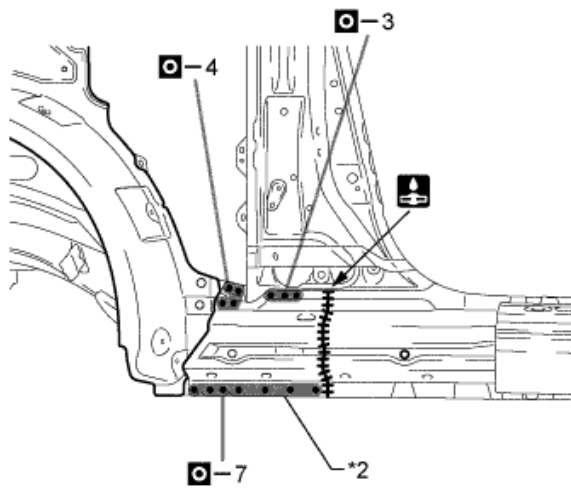


RH:



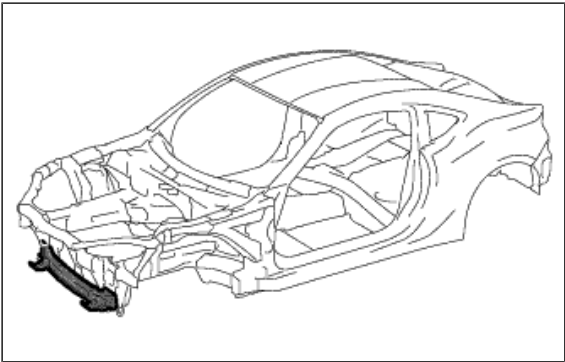
QUARTER LOCK PILLAR EXTENSION
SUB-ASSEMBLY





RADIATOR LOWER SUPPORT > ASSEMBLY REPLACEMENT

- REMOVAL
- INSTALLATION



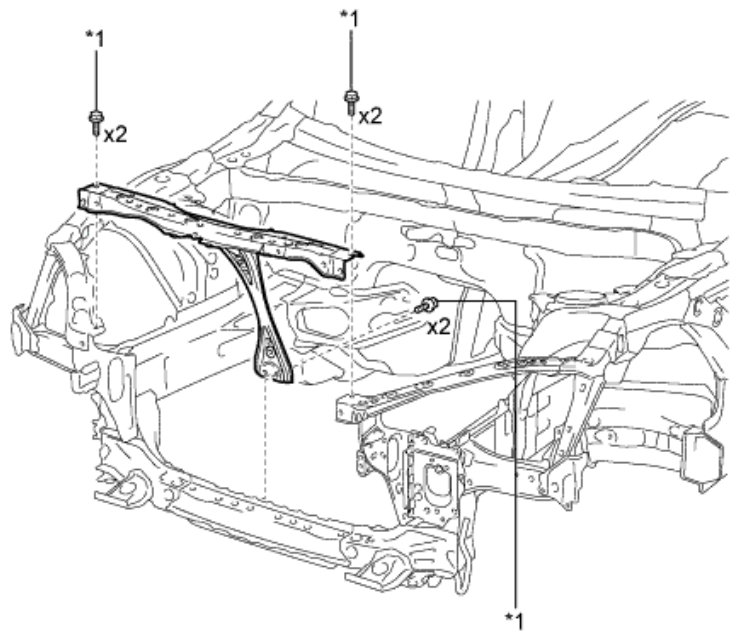
RADIATOR LOWER SUPPORT > ASSEMBLY REPLACEMENT

REMOVAL

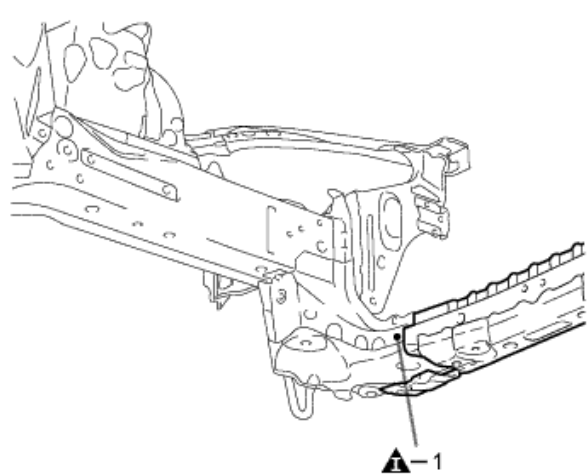
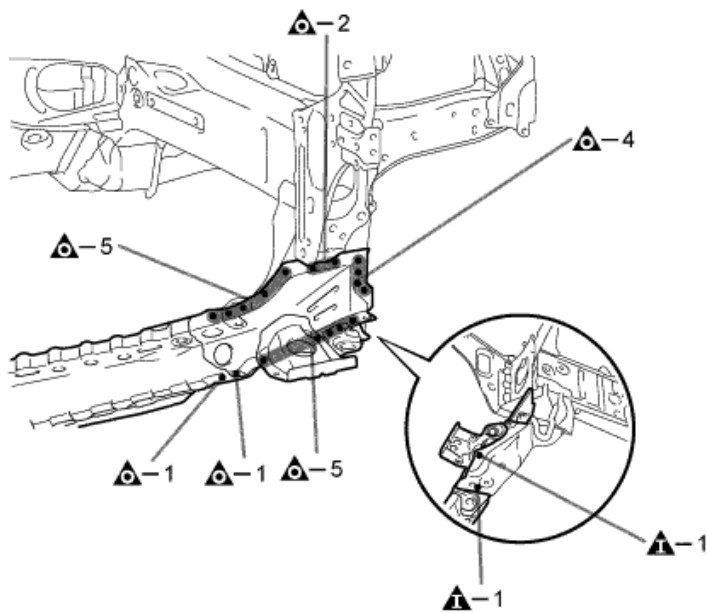
Symbol meaning	
	Remove Weld Points
	Remove Weld Points

REMOVAL POINT

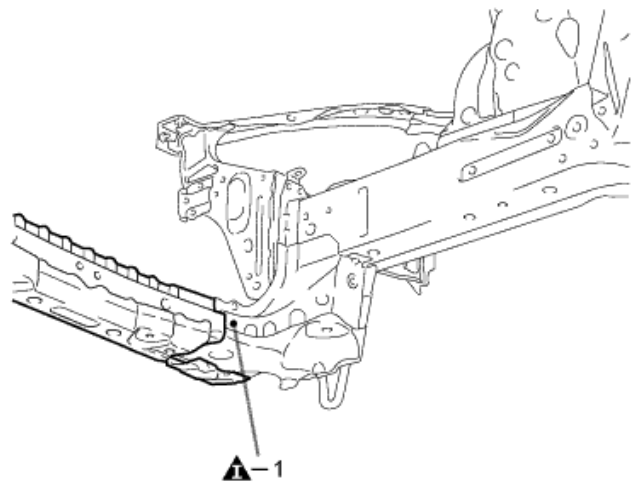
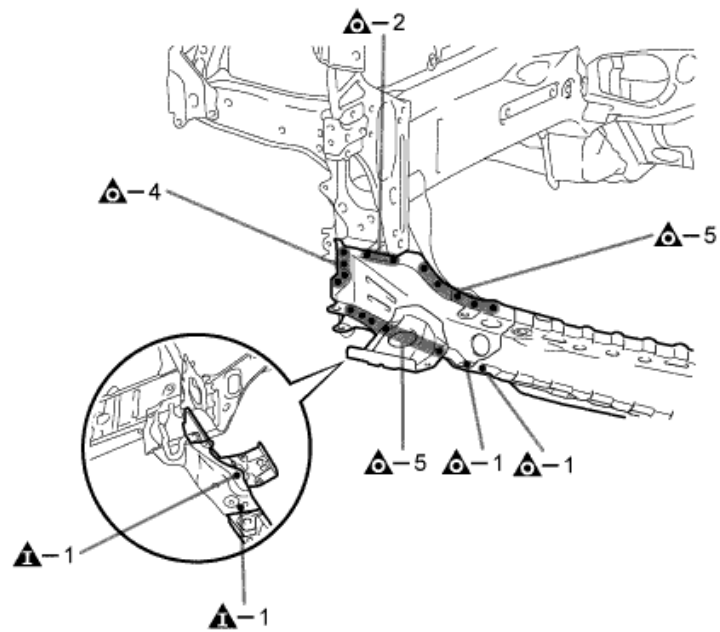
1. *1: Bolts.




LH Side:



RH Side:



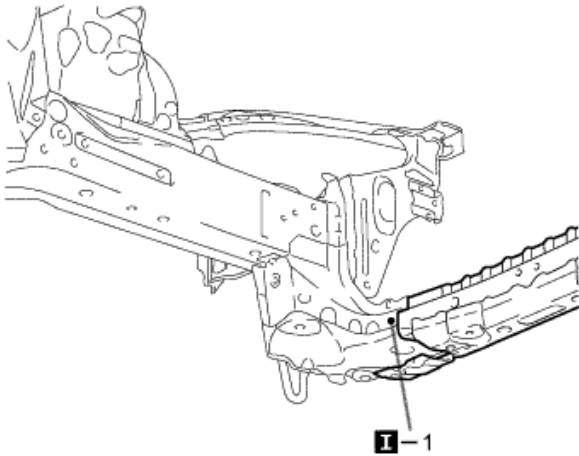
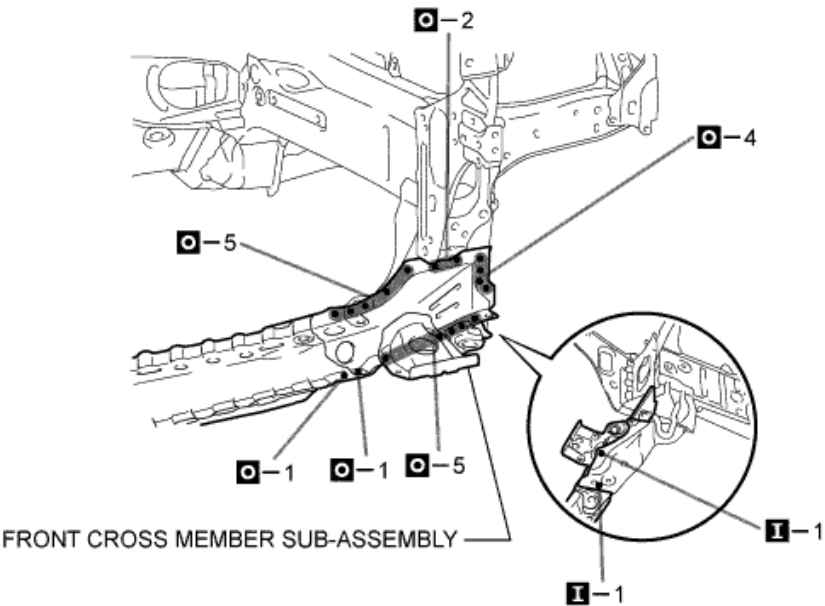
INSTALLATION

Symbol meaning	
	Plug Weld
	Plug Weld

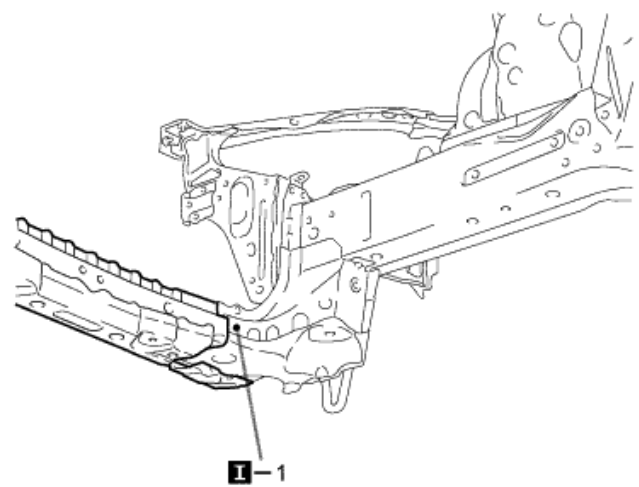
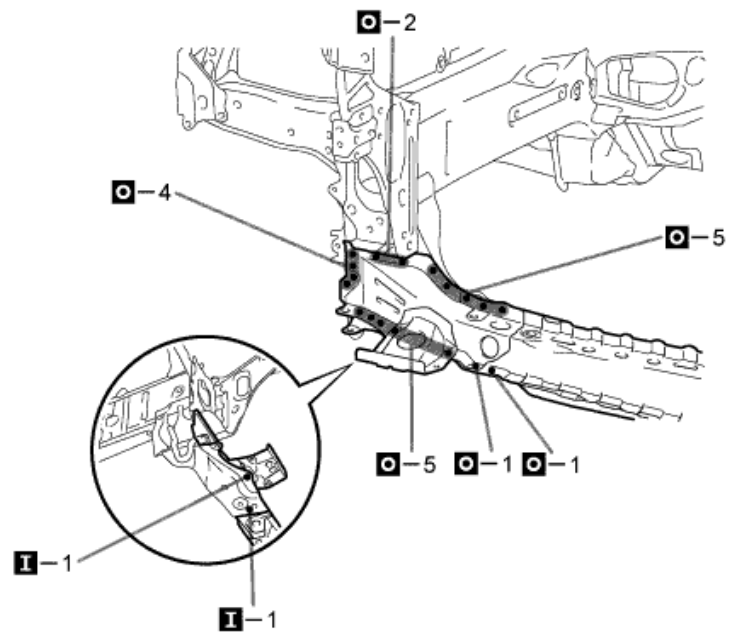
INSTALLATION POINT

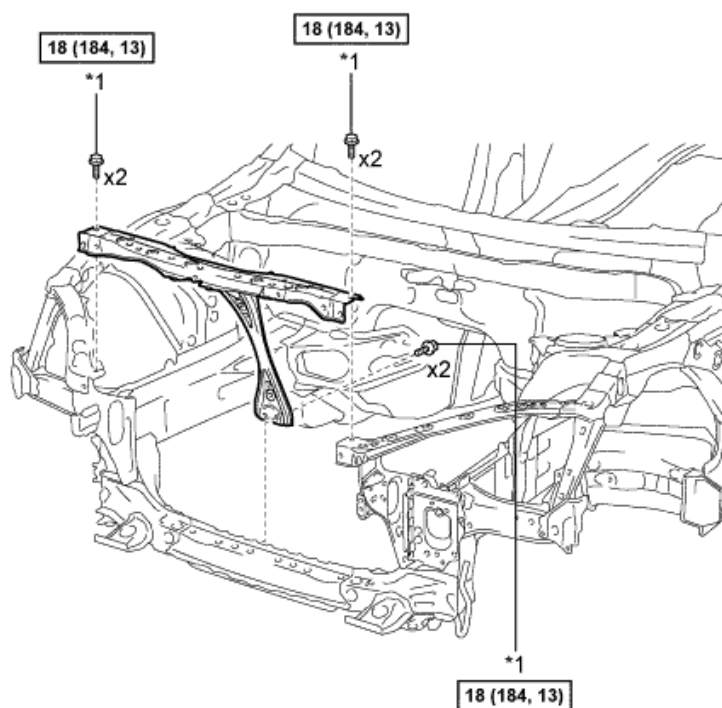
1. Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
2. Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimensions)
3. *1: Bolts.
4. After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

LH Side:



RH Side:

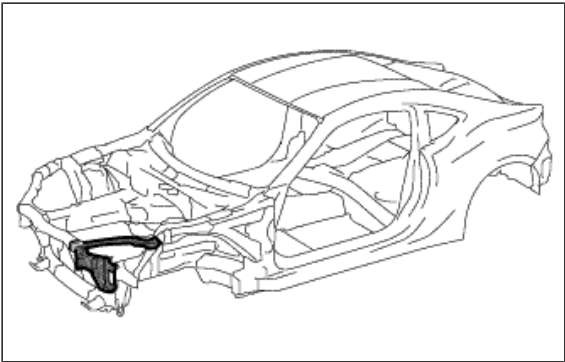





N*m (kgf*cm, ft.*lbf): Specified torque

RADIATOR SIDE SUPPORT > ASSEMBLY REPLACEMENT

- REMOVAL
- INSTALLATION

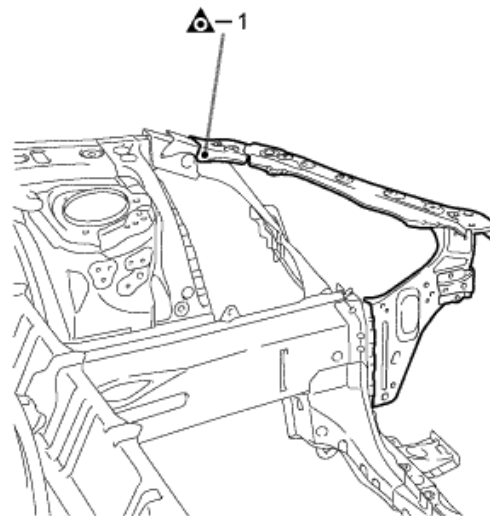
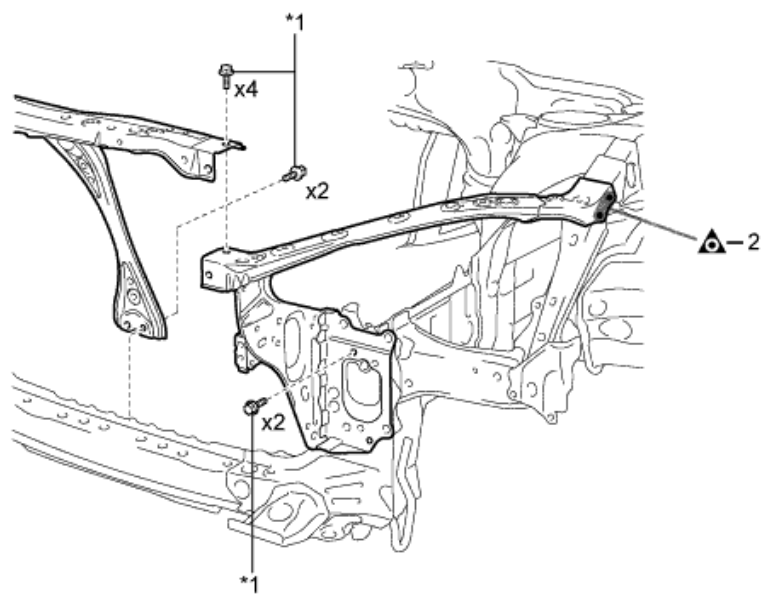


REMOVAL


Symbol meaning	
	Remove Weld Points

REMOVAL POINT

1. *1: Bolts.

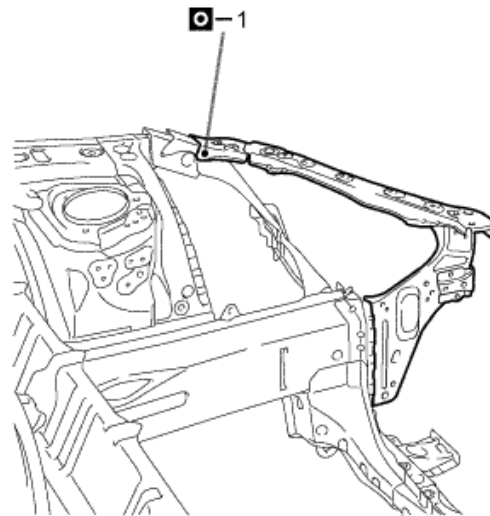
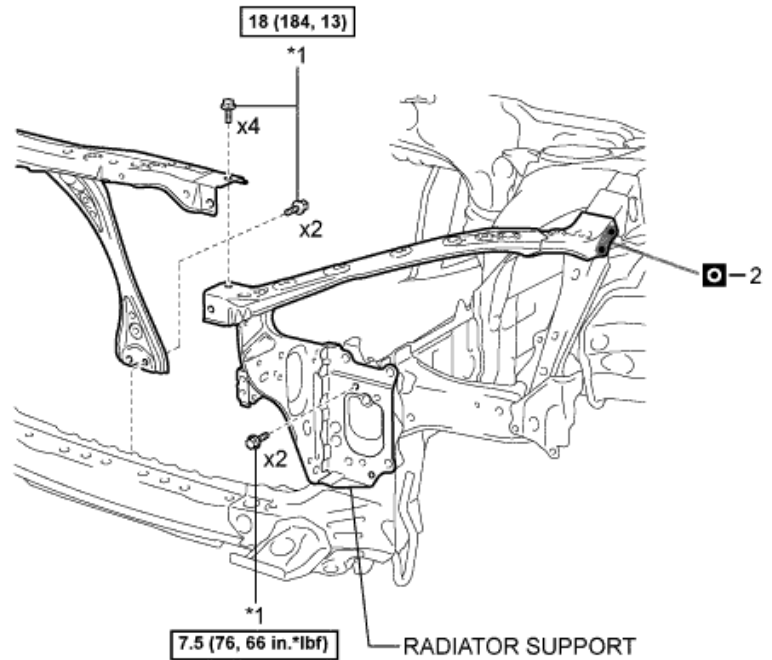


INSTALLATION

Symbol meaning	
	Plug Weld

INSTALLATION POINT

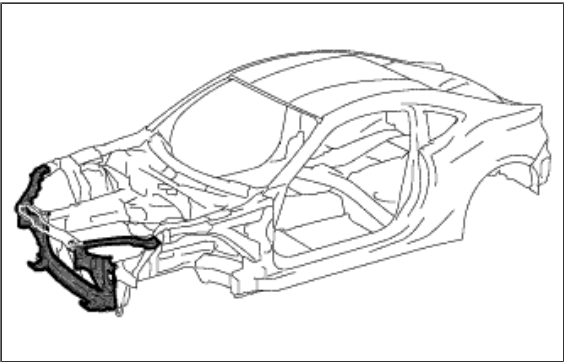
1. Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
2. Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimensions)
3. *1: Bolts.
4. After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.



[N*m (kgf*cm, ft.*lbf)]: Specified torque

RADIATOR SUPPORT > ASSEMBLY REPLACEMENT

- REMOVAL
- INSTALLATION

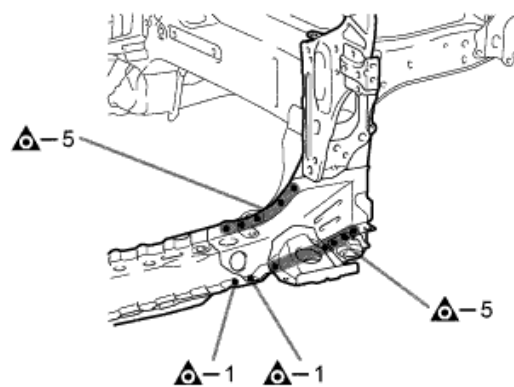
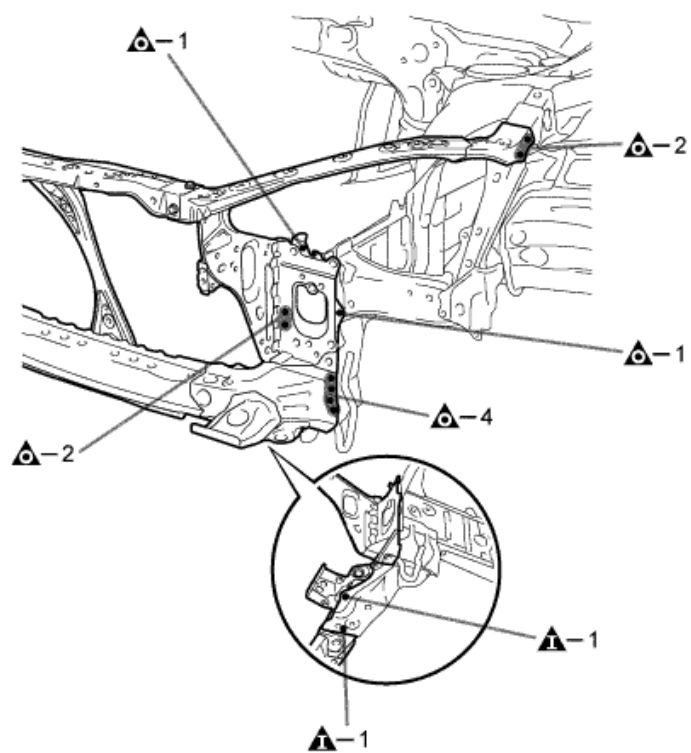


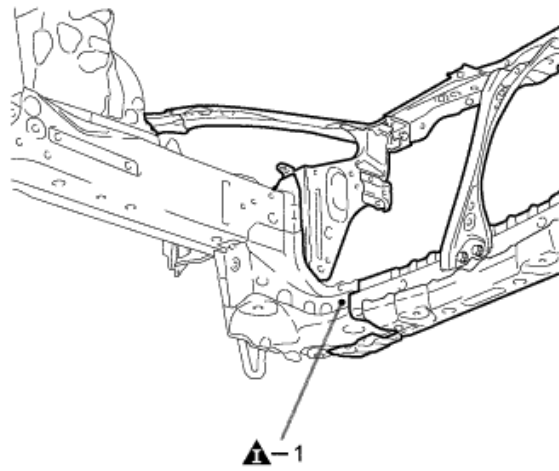
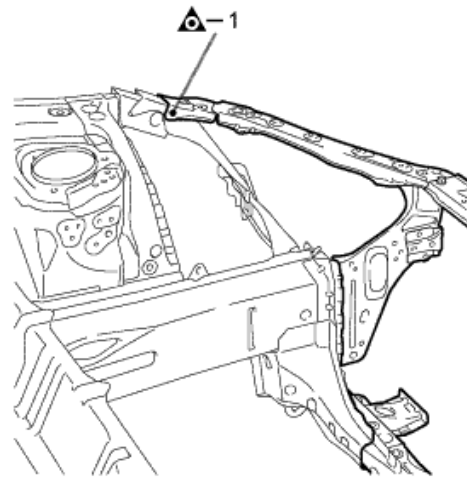
RADIATOR SUPPORT > ASSEMBLY REPLACEMENT

REMOVAL

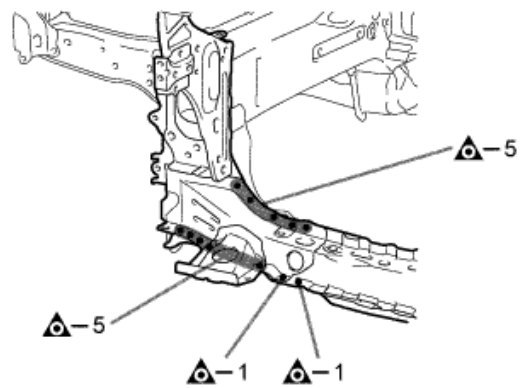
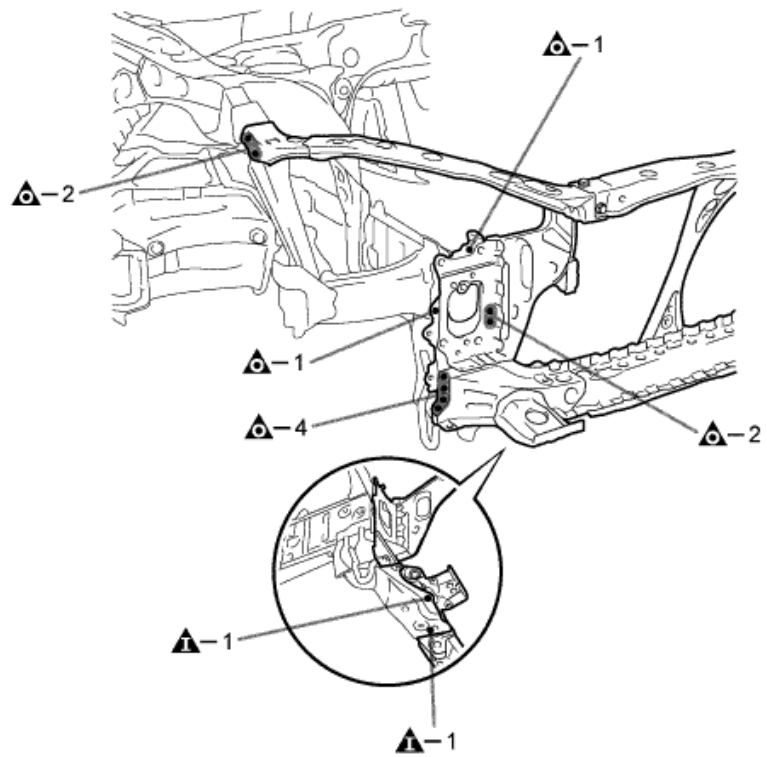
Symbol meaning	
	Remove Weld Points
	Remove Weld Points

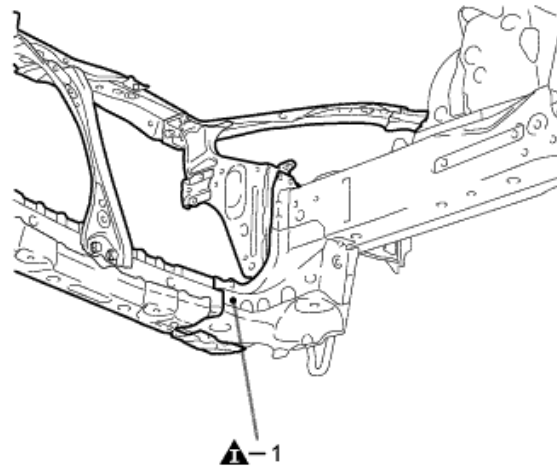
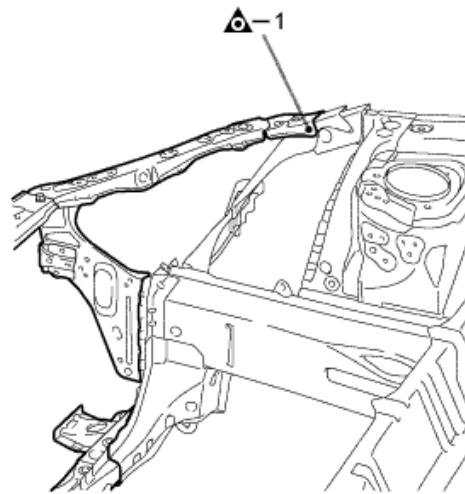
LH Side:






RH Side:





INSTALLATION

Symbol meaning	
	Plug Weld
	Plug Weld

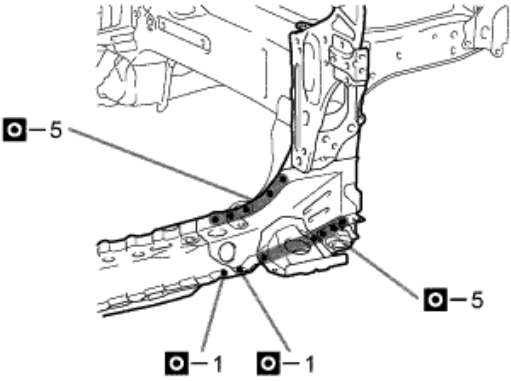
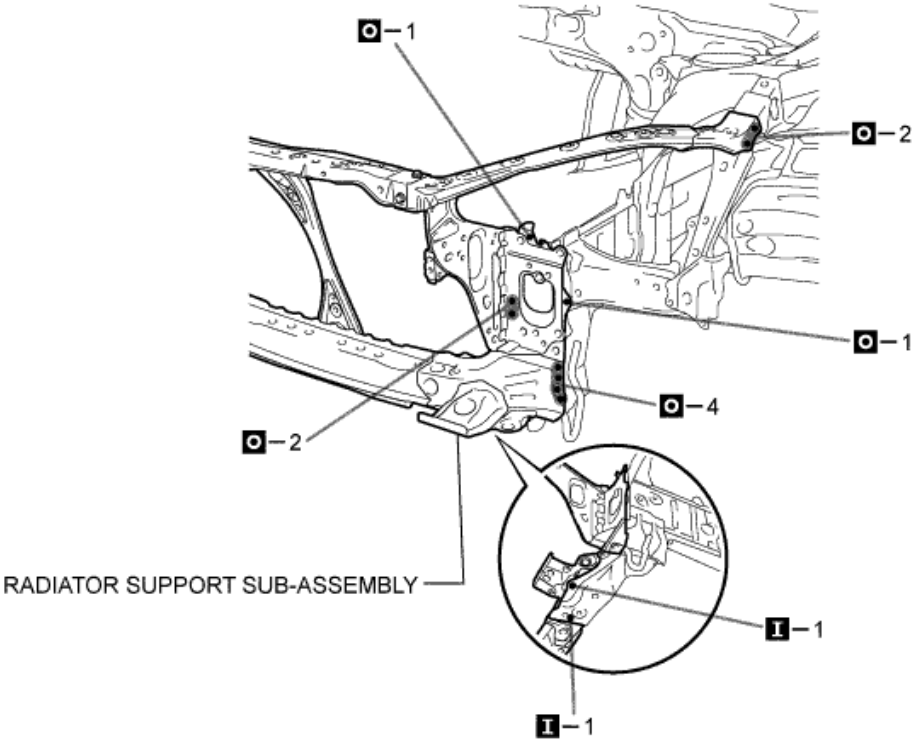
INSTALLATION POINT

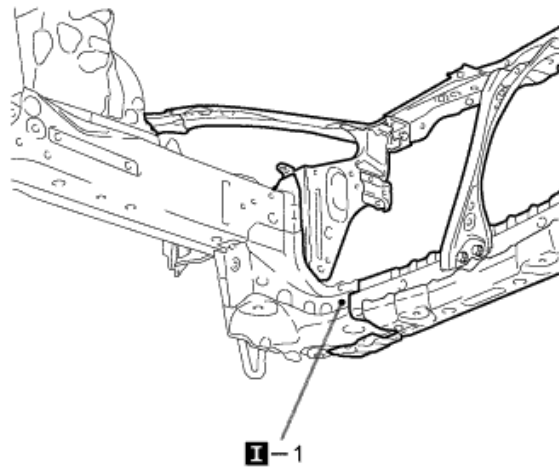
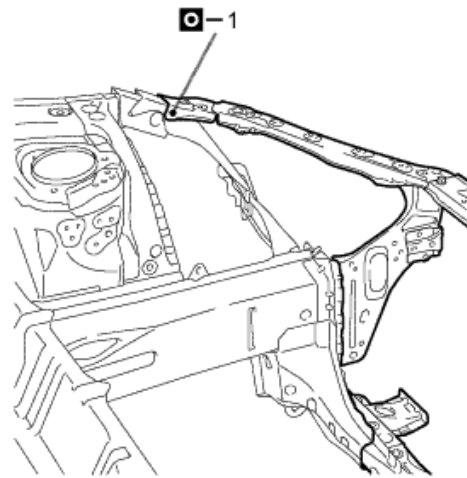
- 1. Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2. Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimensions)
- 3. After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.
- 4. Measure the dimensions before installing the headlights.

Reference Value

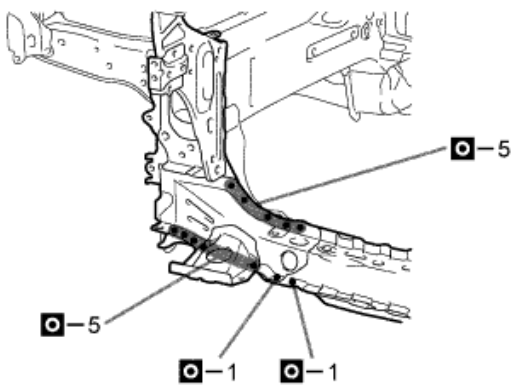
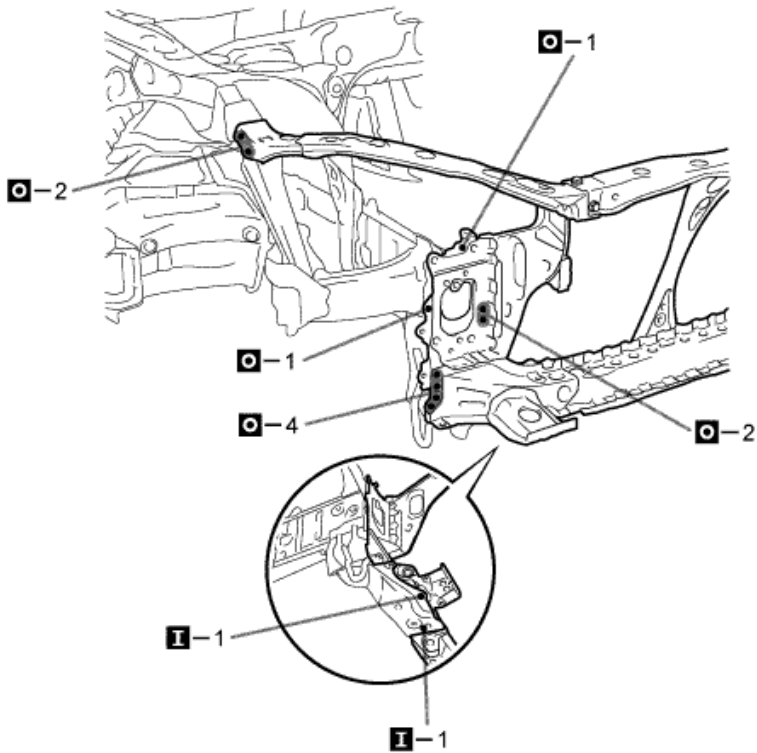
Area	Measurement	Area	Measurement
*a	1360 mm (53.54 in.)	*b	1278 mm (50.31 in.)
*c	1097 mm (43.19 in.)	*d	888 mm (34.96 in.)
*e	881 mm (34.68 in.)	*f	889 mm (35.00 in.)
*g	805 mm (31.69 in.)	-	-

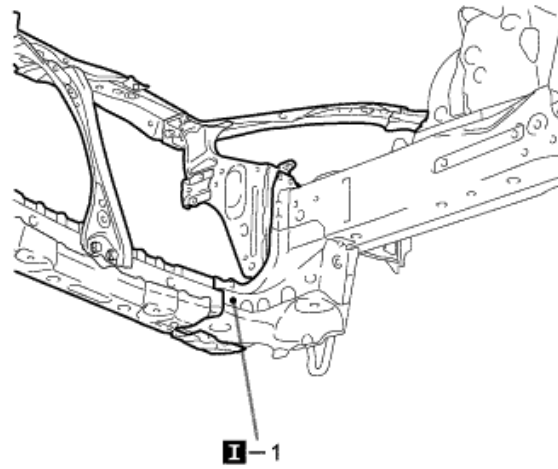
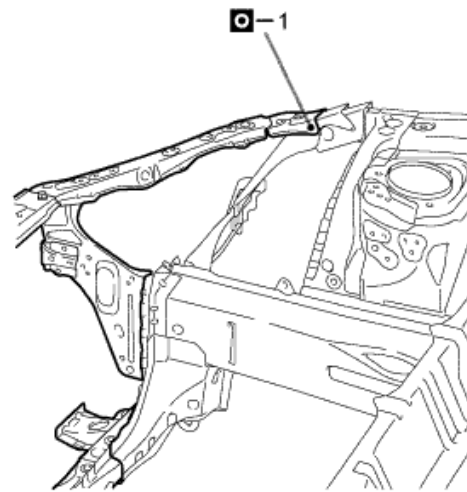
LH Side:

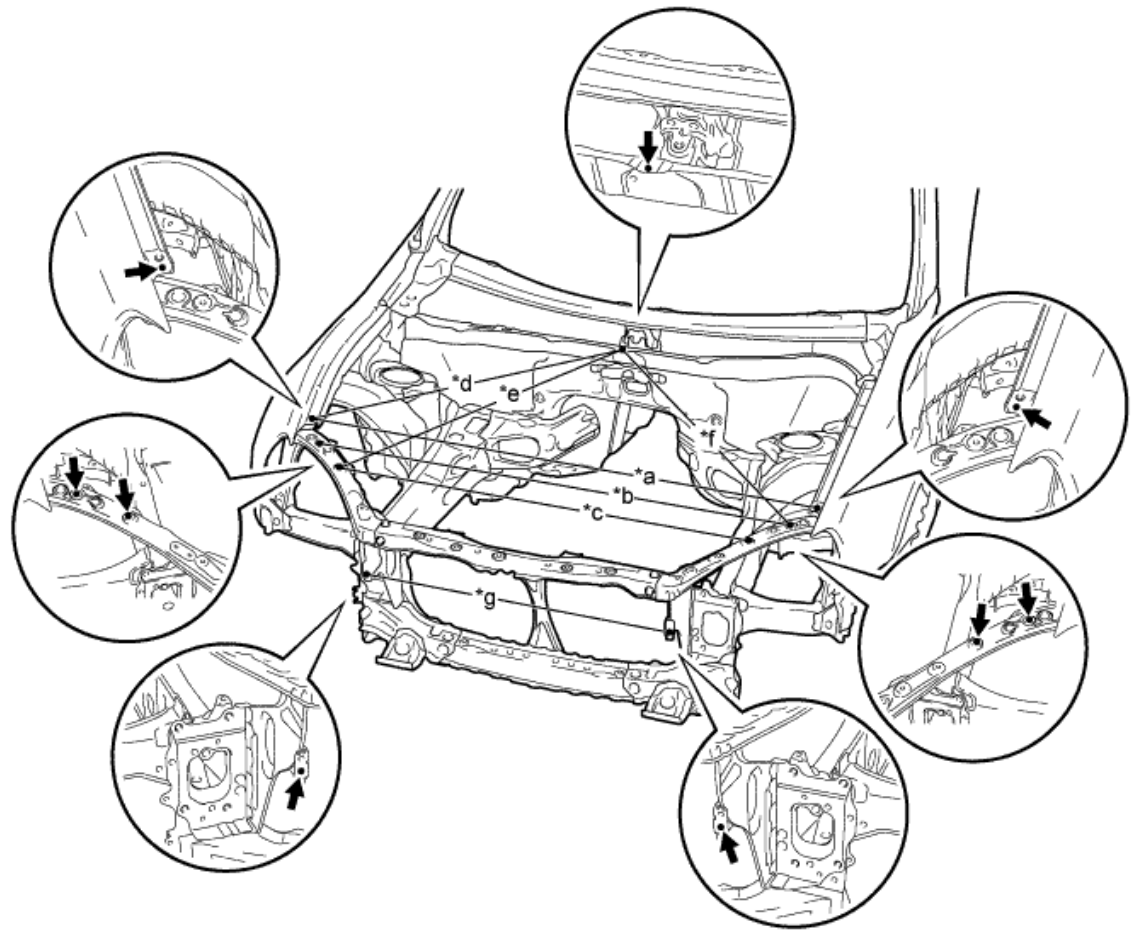




RH Side:





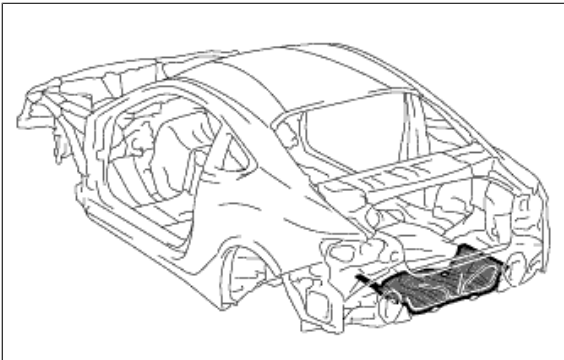


REAR FLOOR PAN >
CUT AND JOIN
REPLACEMENT
SECTIONS

- REMOVAL
- INSTALLATION

REAR FLOOR PAN > CUT AND JOIN REPLACEMENT SECTIONS

With the body lower back panel removed.



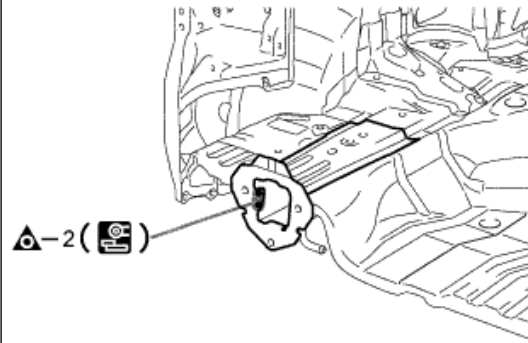
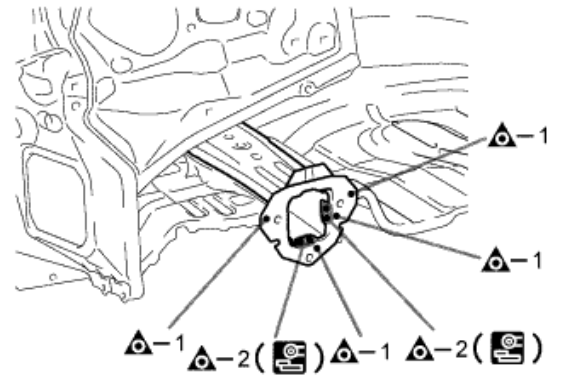
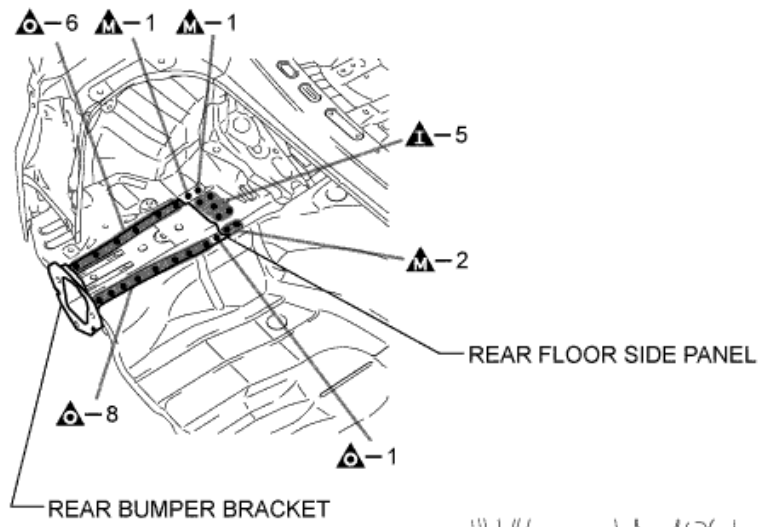
REMOVAL

Symbol meaning	
	Remove Weld Points
	Remove Weld Points
	Remove Weld Points
	Cut with Disc Sander etc.
	Cut Location

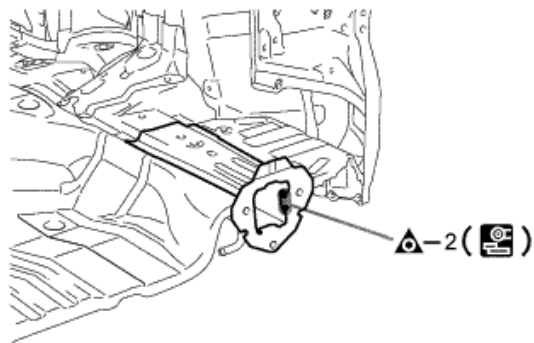
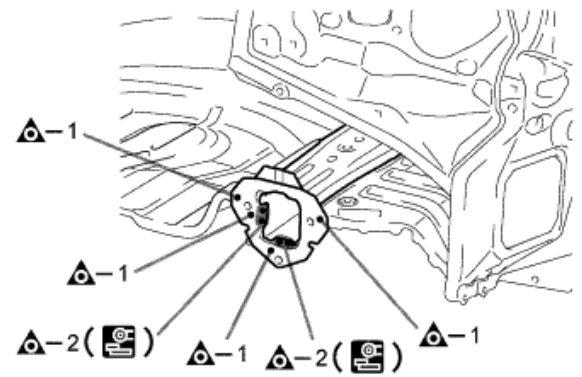
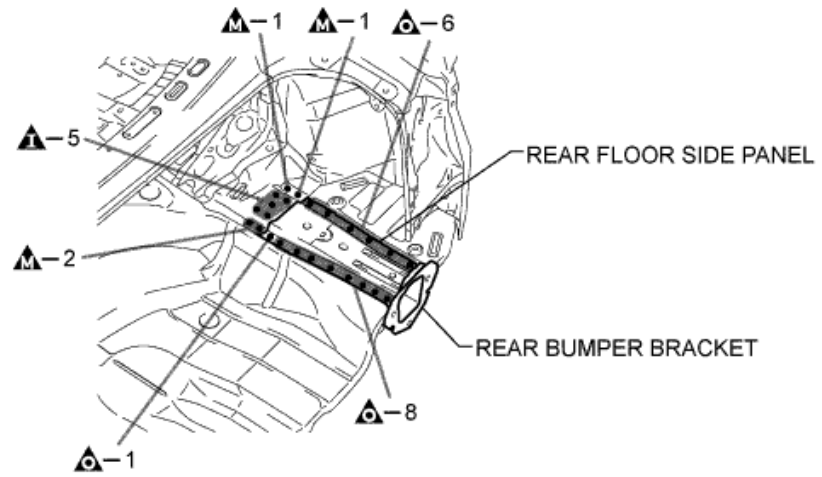
REMOVAL POINT

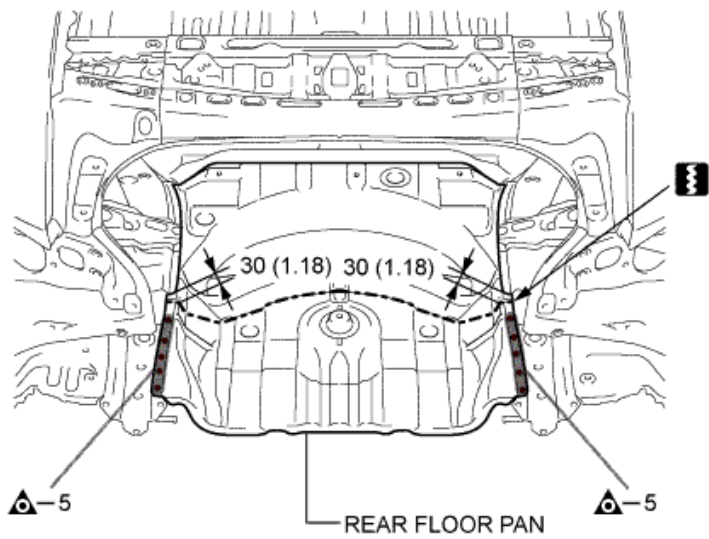
1. After removing the rear floor side panel and rear bumper bracket, remove the rear floor pan.

LH:




RH:








mm (in.)

INSTALLATION

Symbol meaning	
	Plug Weld
	Plug Weld

	
	Plug Weld
	Cut Location
	Fillet Weld
	Body Sealer

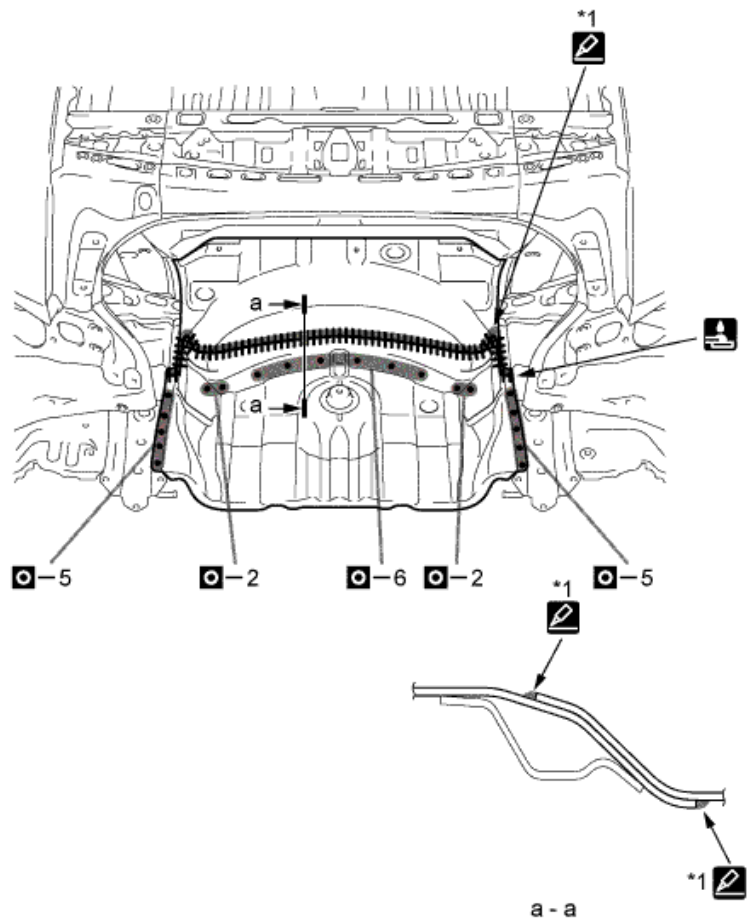
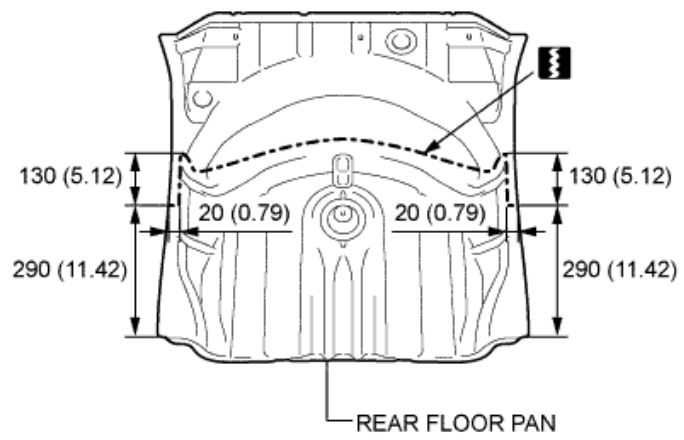
INSTALLATION POINT

1. Cut the new part so that it overlaps the previous cut location.
2. When welding *2, make a hole on a new part for plug welding and weld the panel with the panel behind completely.
3. *1: Perform plug-welding in the area where the panel are overlapped. Apply body sealer to both sides of each panel.

HINT:

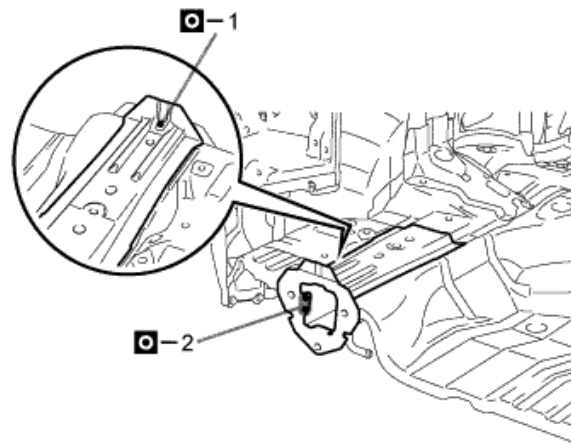
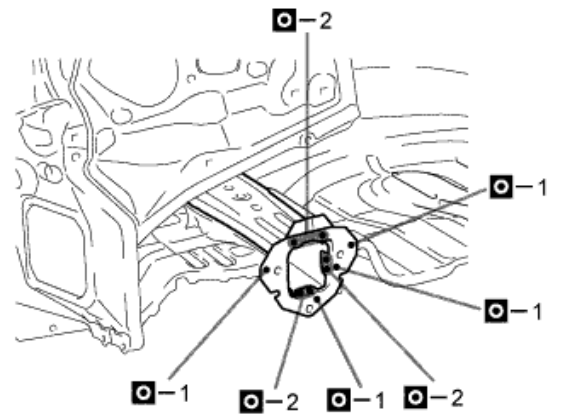
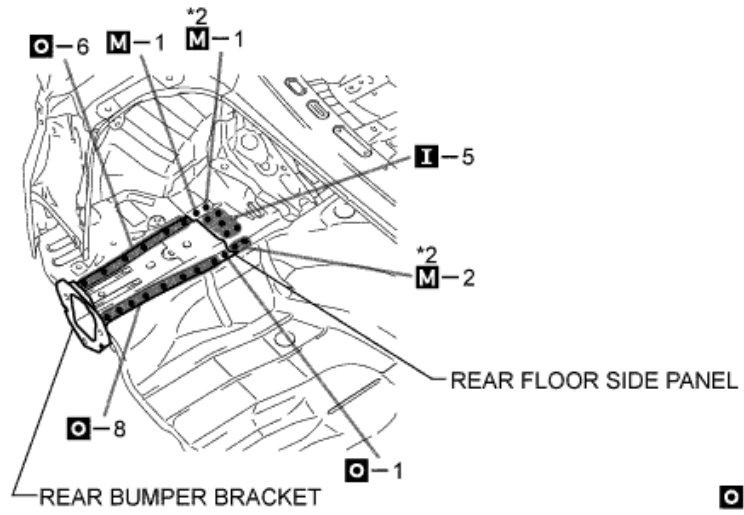
- Confirm that the panels are securely welded together.
- Apply body sealer in an even, continuous bead.

4. After welding the rear floor pan to the vehicle side, install the rear floor side panel and rear bumper bracket.
5. After welding, apply body sealer and undercoating to the corresponding parts. (See the painting / coating)
6. After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

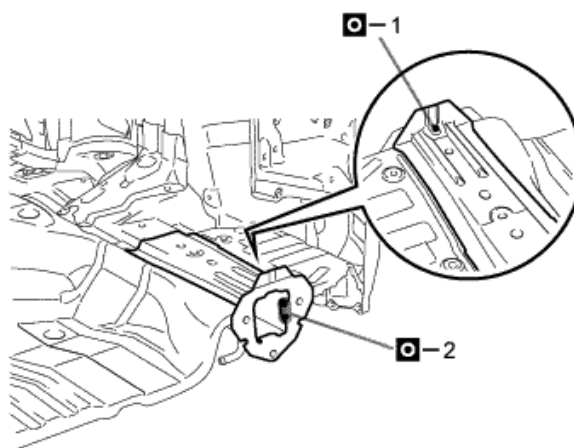
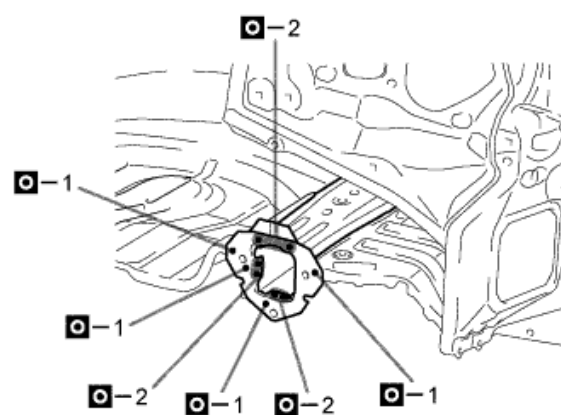
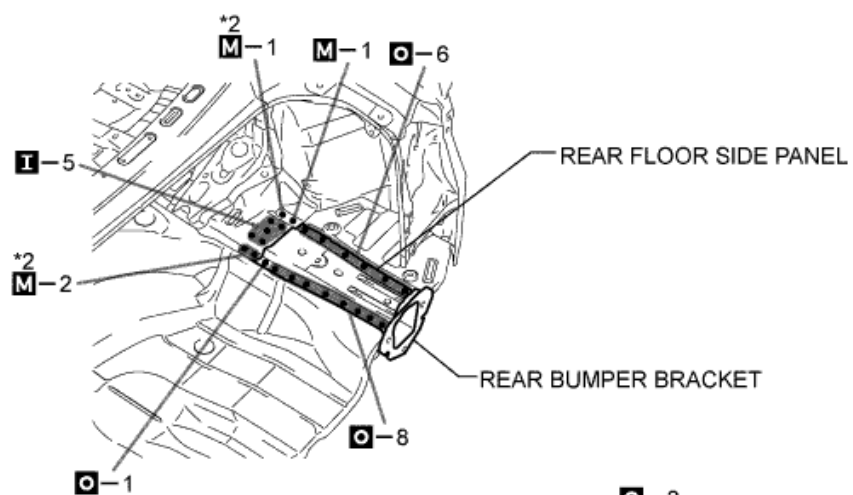


mm (in.)

LH:



RH:

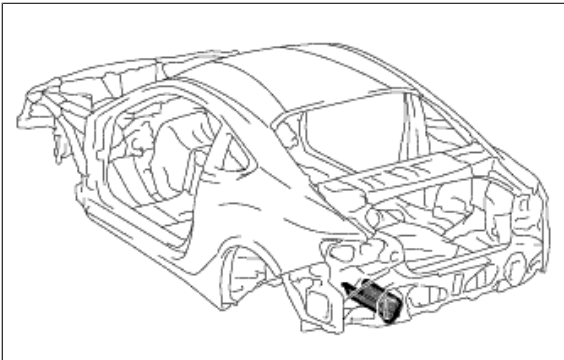


REAR FLOOR SIDE MEMBER > ASSEMBLY REPLACEMENT





- REMOVAL
- INSTALLATION

REAR FLOOR SIDE MEMBER > ASSEMBLY REPLACEMENT

With the body lower back panel removed.

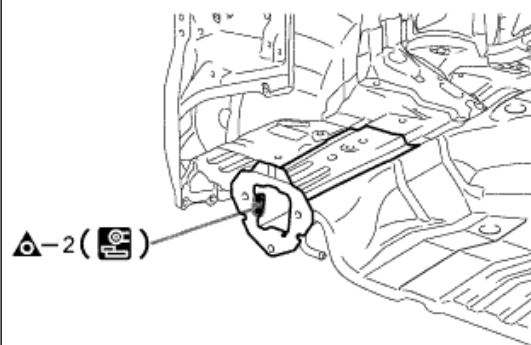
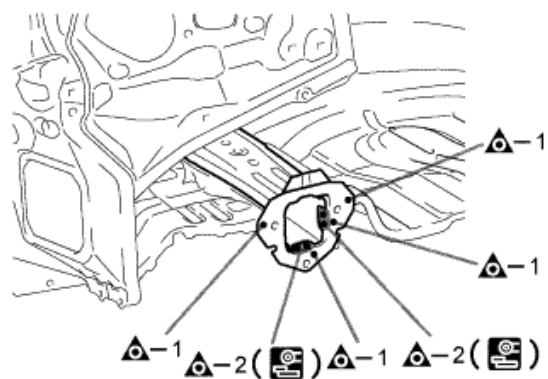
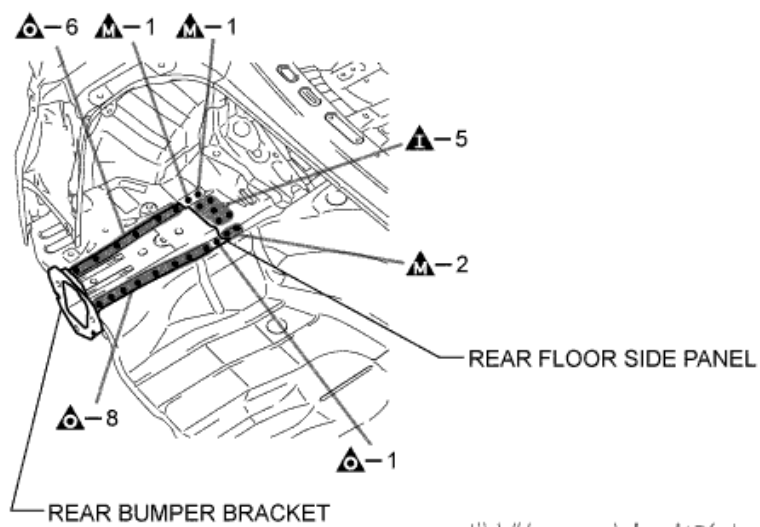


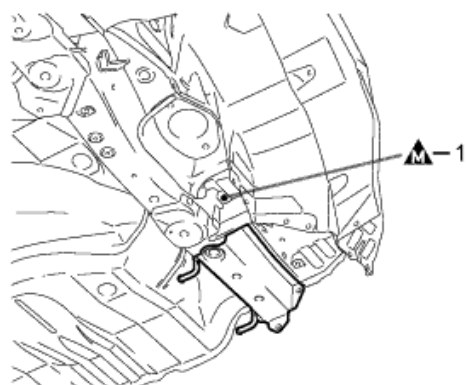
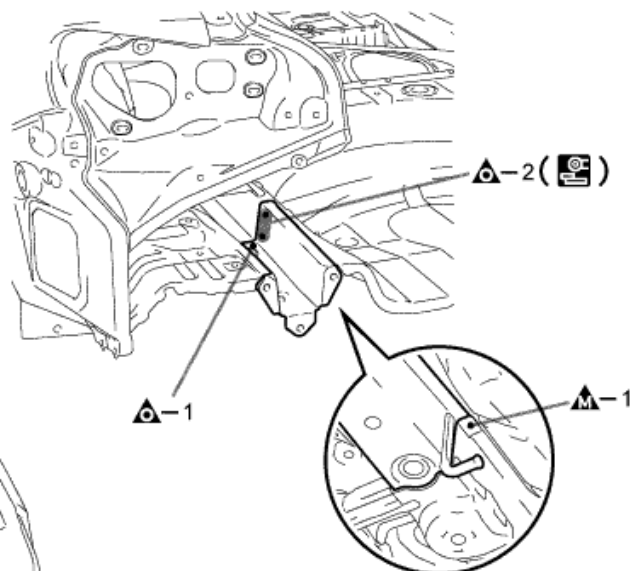
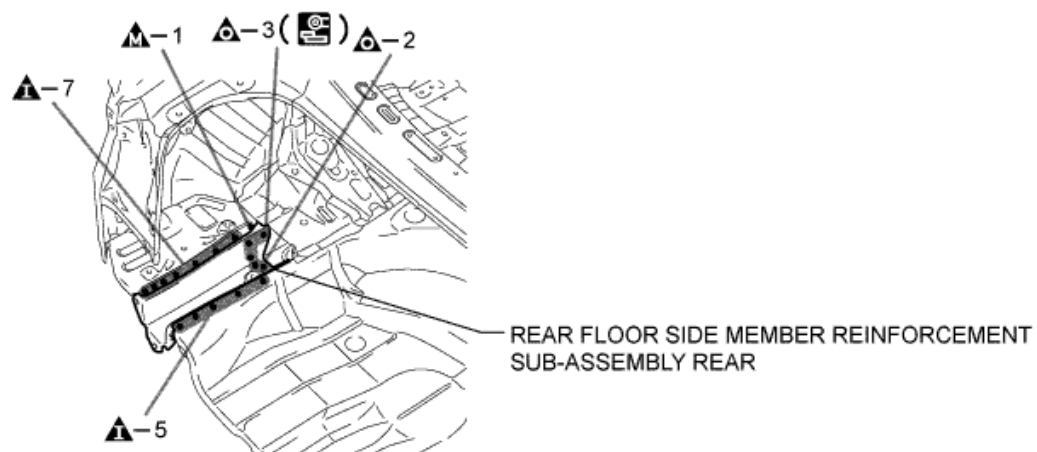
REMOVAL

Symbol meaning	
	Remove Weld Points
	Remove Weld Points
	Remove Weld Points
	Cut with Disc Sander etc.

REMOVAL POINT

1. After removing the rear floor side panel and rear bumper bracket, remove the rear floor side member reinforcement sub-assembly rear.





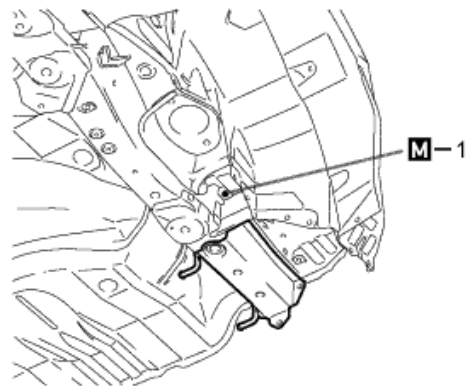
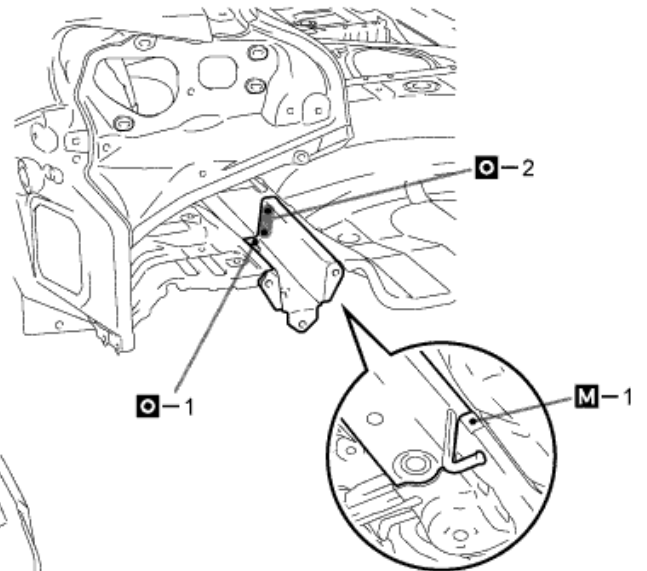
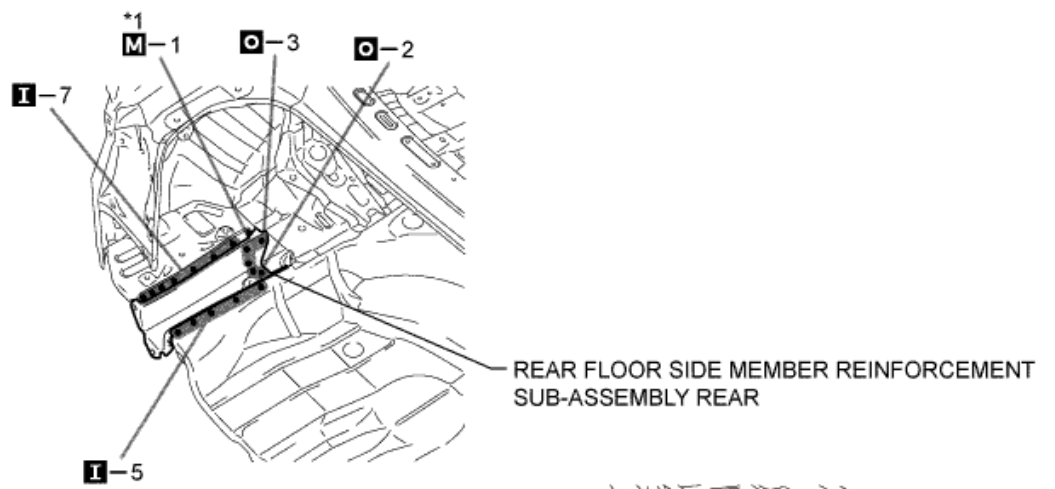
INSTALLATION

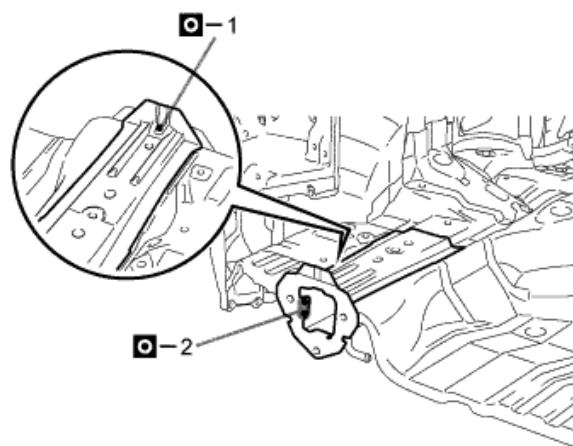
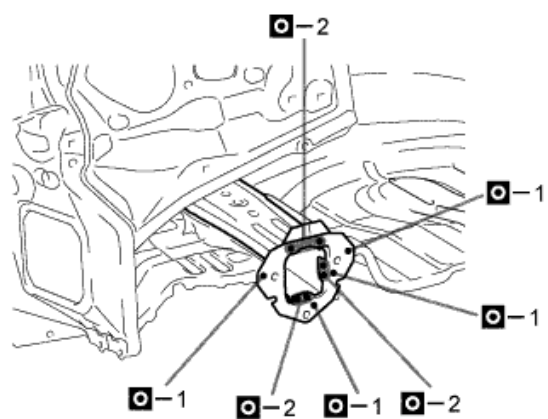
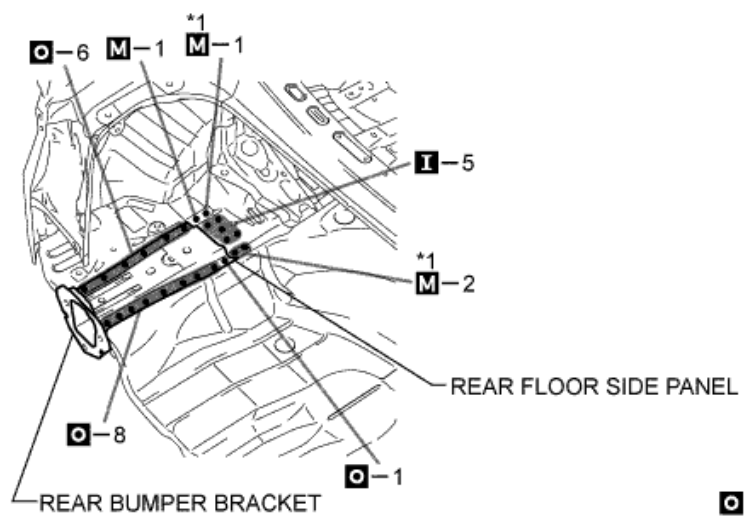
Symbol meaning	
	Plug Weld
	Plug Weld

M	
I	Plug Weld

INSTALLATION POINT

1. When welding *1, make a hole on a new part for plug welding and weld the panel with the panel behind completely.
2. After welding the rear floor side member reinforcement sub-assembly rear to the vehicle side, install the rear floor side panel and rear bumper bracket.
3. After welding, apply body sealer and undercoating to the corresponding parts. (See the painting / coating)
4. After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

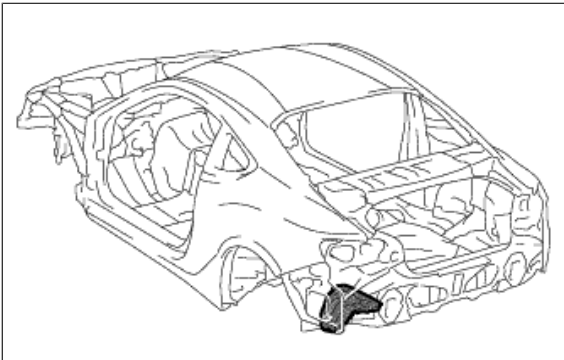




REAR FLOOR SIDE PANEL > ASSEMBLY REPLACEMENT

- REMOVAL
- INSTALLATION

With the body lower back panel removed.



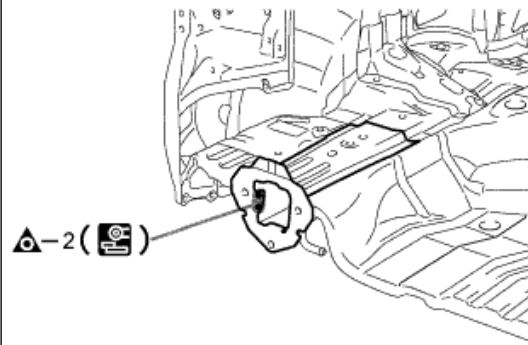
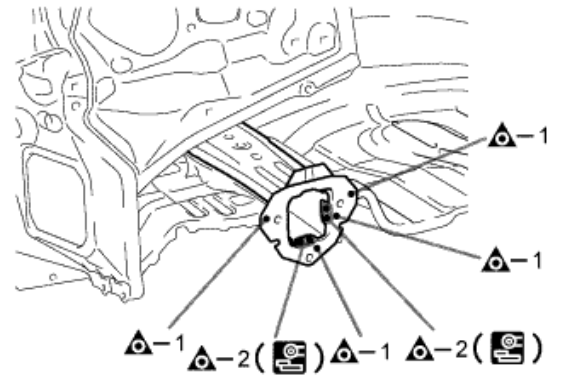
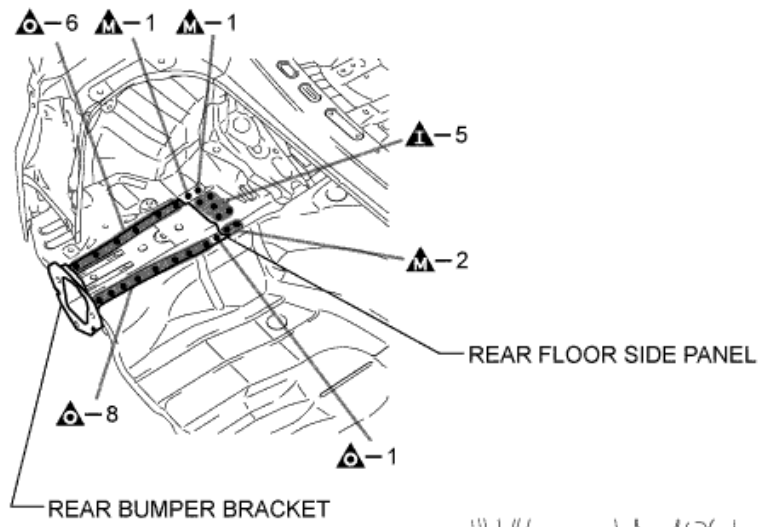
REMOVAL

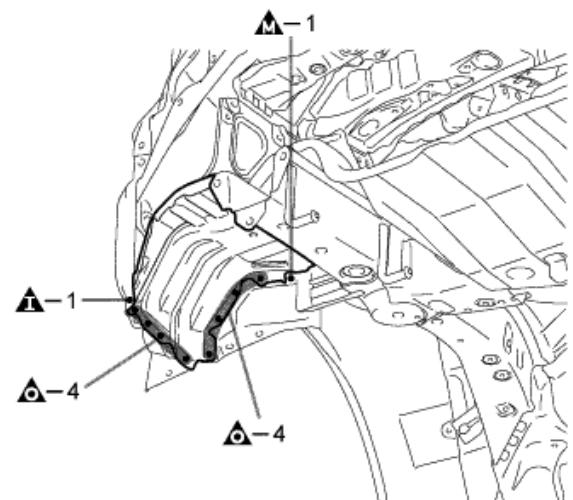
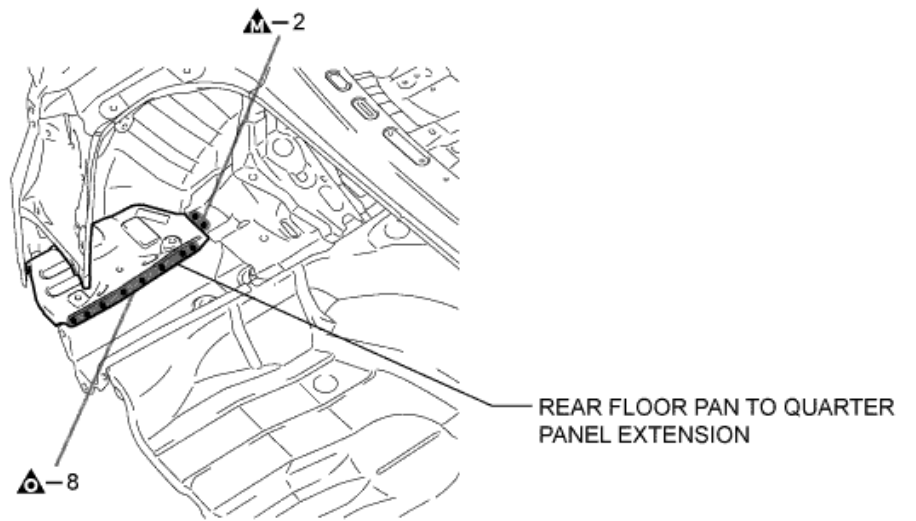
Symbol meaning	
	Remove Weld Points
	Remove Weld Points
	Remove Weld Points
	Cut with Disc Sander etc.

REMOVAL POINT

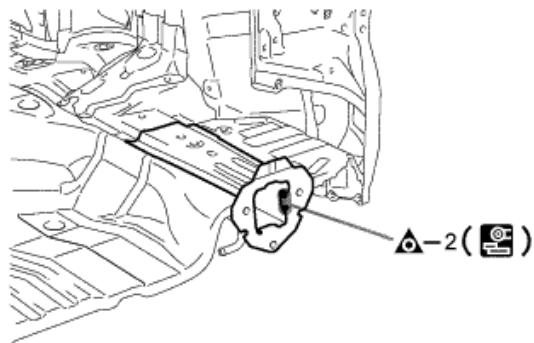
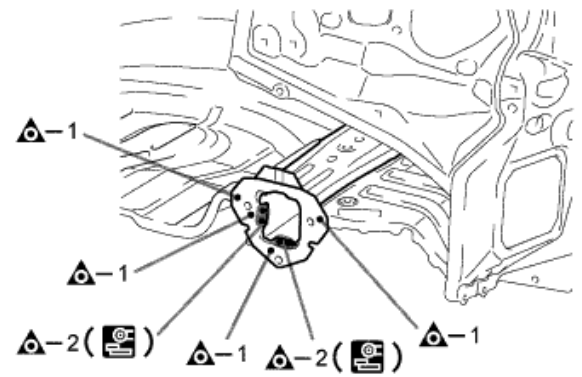
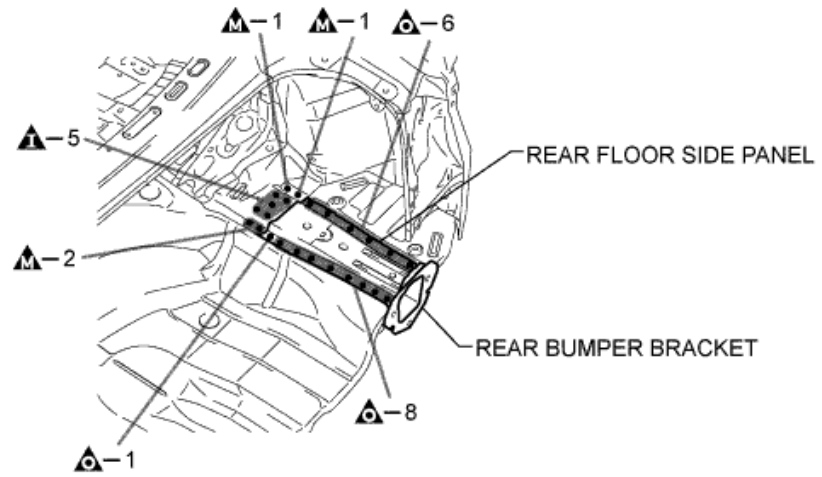
1. After removing the rear floor side panel and rear bumper bracket, remove the rear floor pan to quarter panel extension.

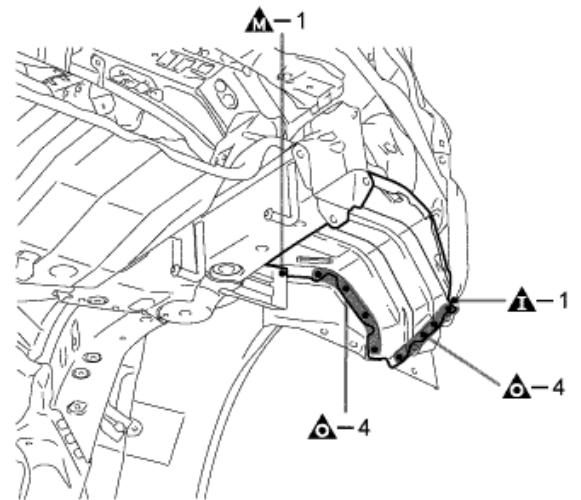
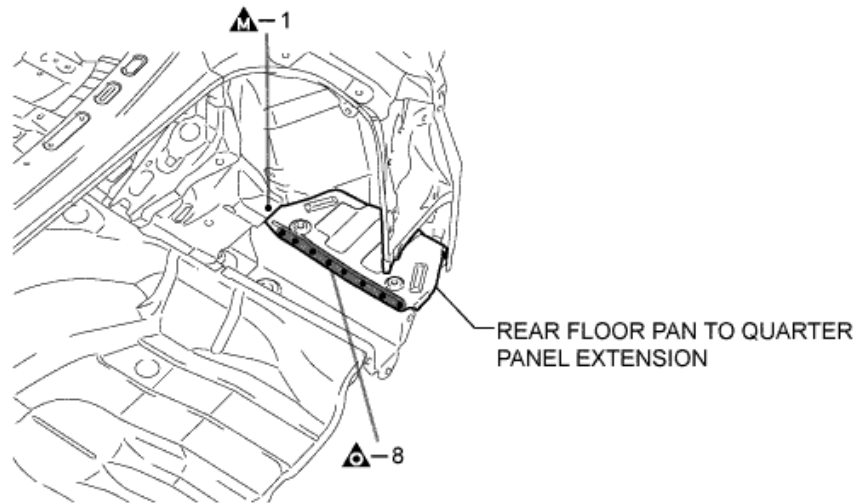
LH:






RH:





INSTALLATION

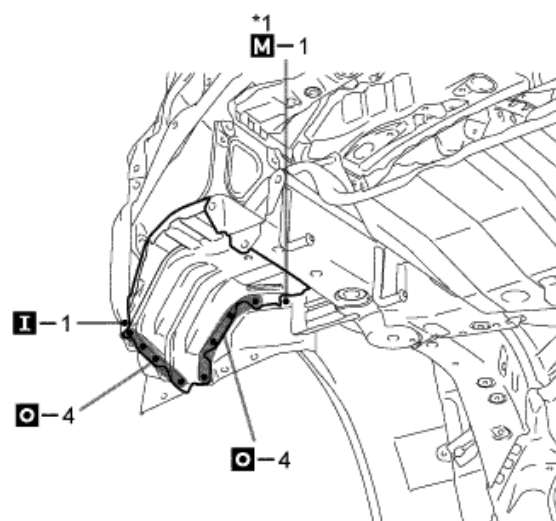
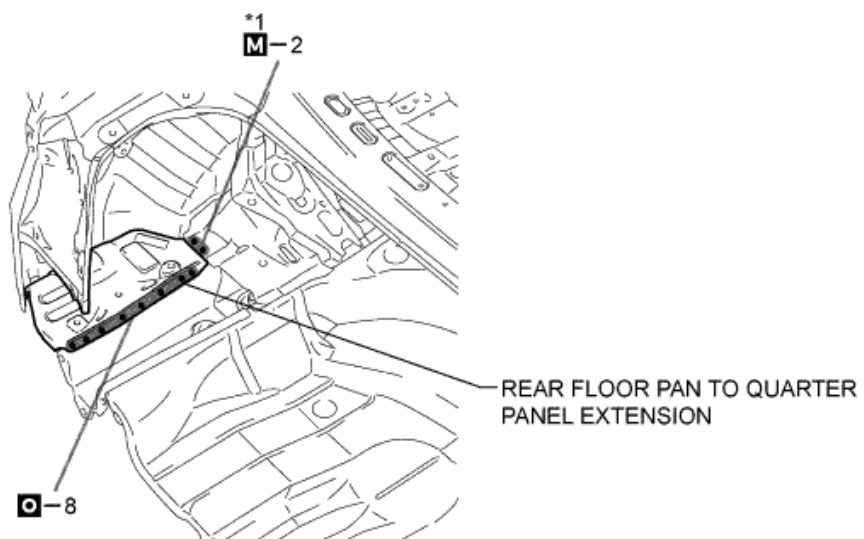
Symbol meaning	
	Plug Weld
	Plug Weld

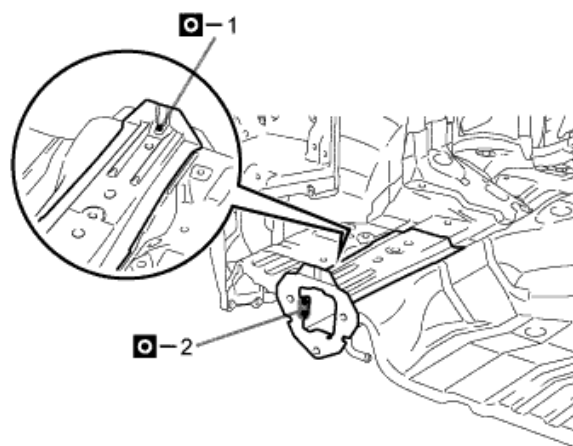
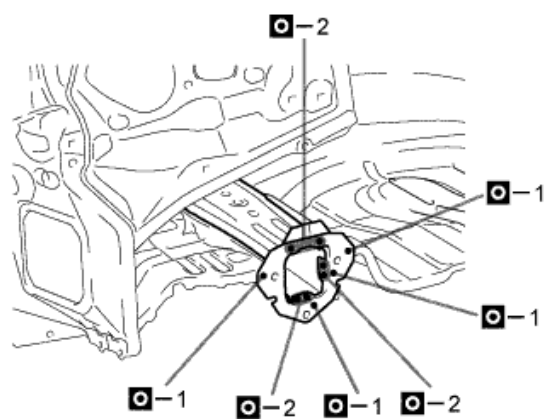
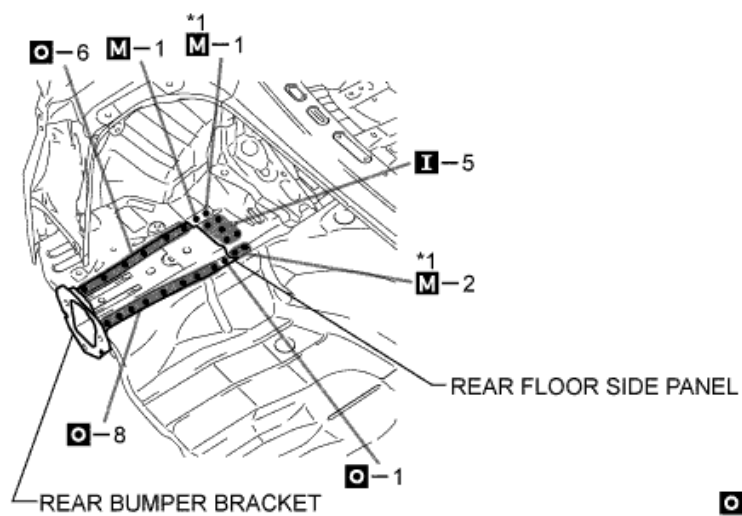
M	
I	Plug Weld

INSTALLATION POINT

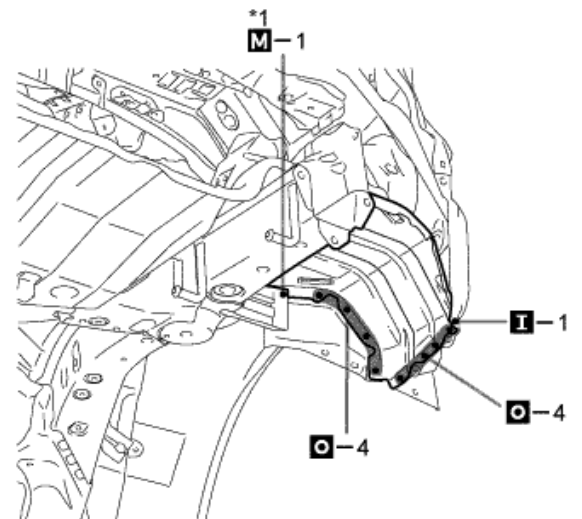
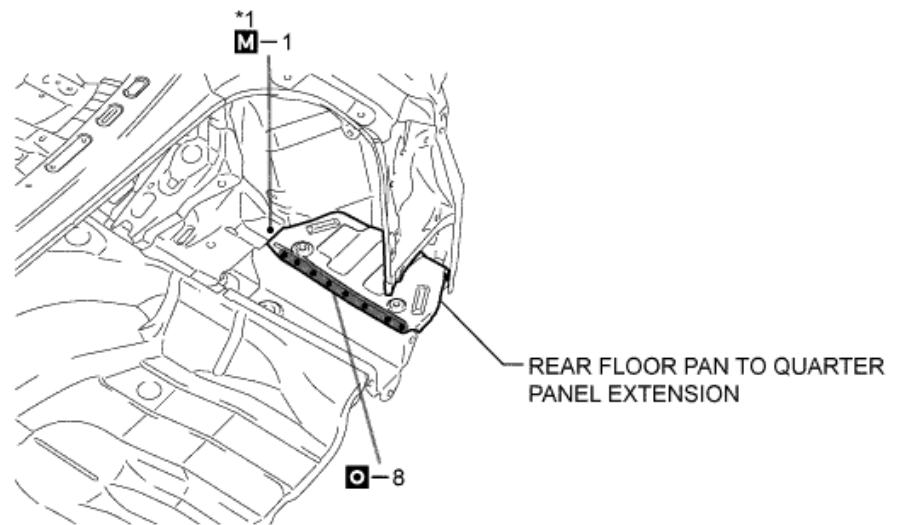
1. When welding *1, make a hole on a new part for plug welding and weld the panel with the panel behind completely.
2. After welding the rear floor pan to quarter panel extension to the vehicle side, install the rear floor side panel and rear bumper bracket.
3. After welding, apply body sealer to the corresponding parts. (See the painting / coating)
4. After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

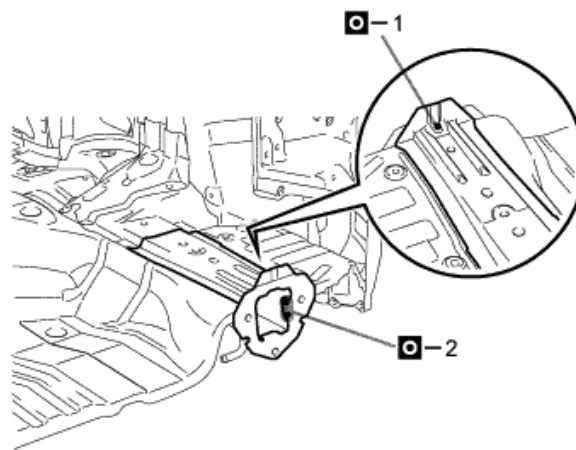
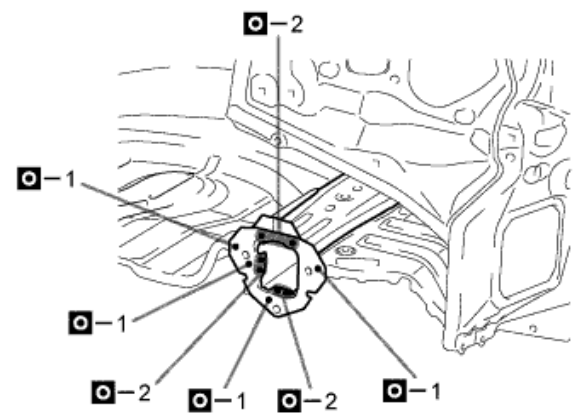
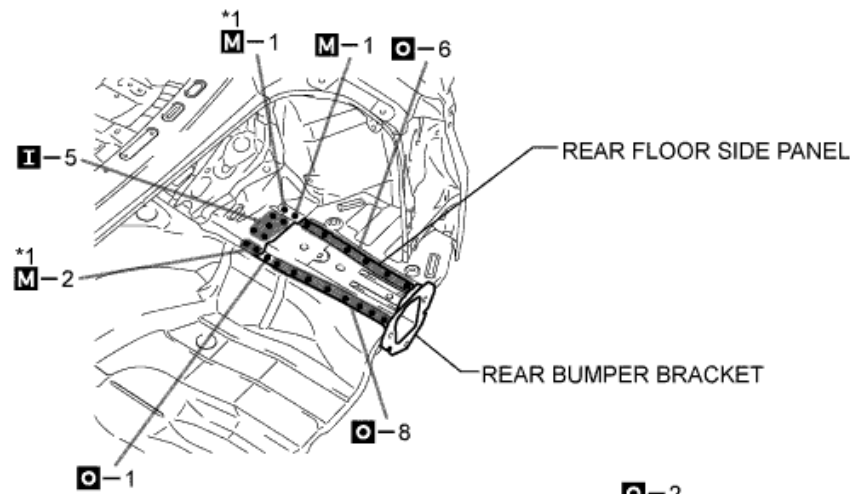
LH:





RH:

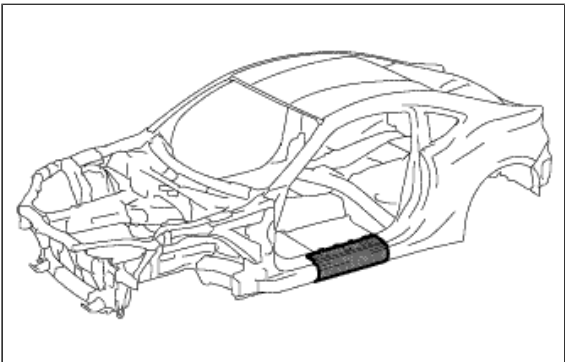




ROCKER OUTER PANEL
> CUT AND JOIN
REPLACEMENT
SECTIONS (SMALL
AREAS)

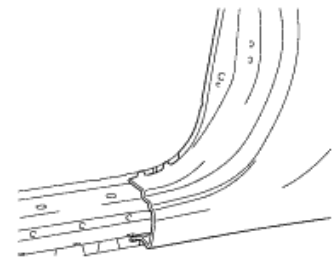
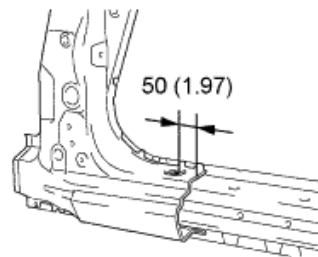
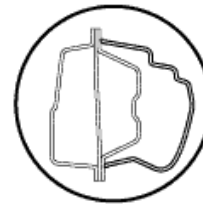
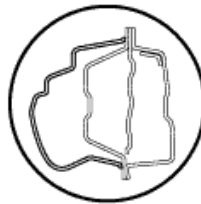
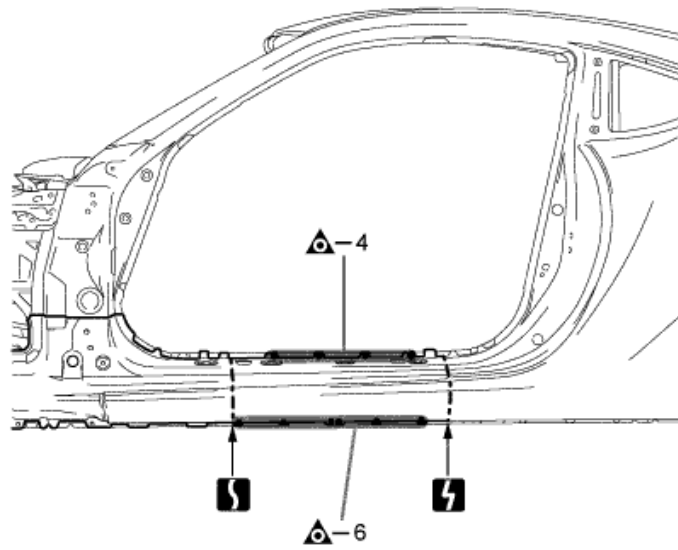
- REMOVAL
- INSTALLATION

ROCKER OUTER PANEL > CUT AND JOIN REPLACEMENT SECTIONS (SMALL AREAS)




REMOVAL

Symbol meaning	
	Remove Weld Points
	Cut and Join Location
	Cut Location for Supply Parts



mm (in.)

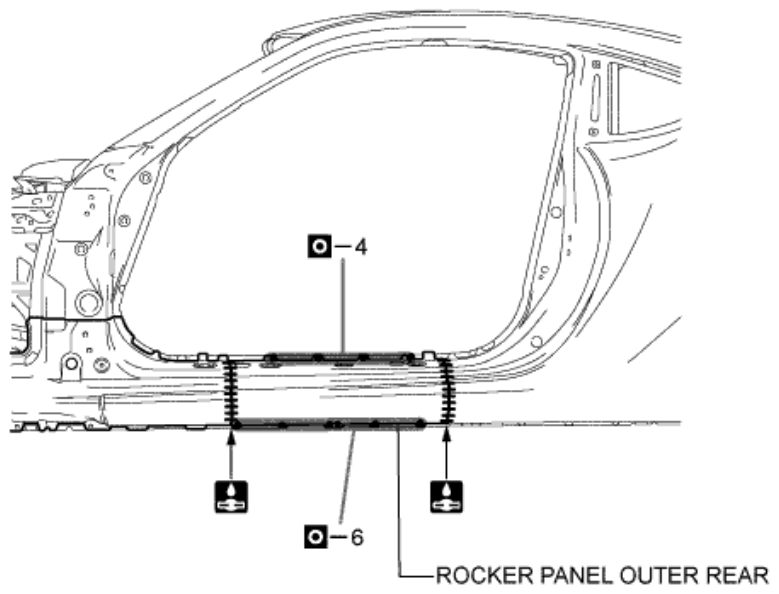
INSTALLATION

Symbol meaning	
	Plug Weld
	Butt Weld



INSTALLATION POINT

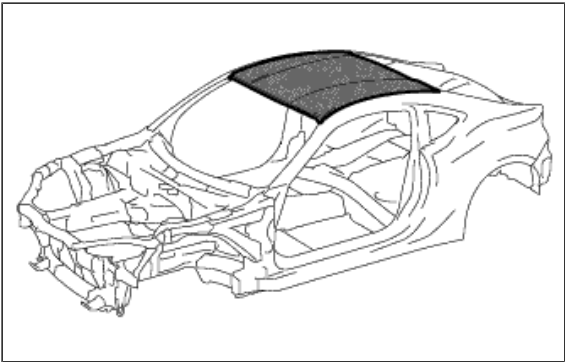
1. Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
2. Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimensions)
3. After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.




ROOF PANEL >
ASSEMBLY
REPLACEMENT

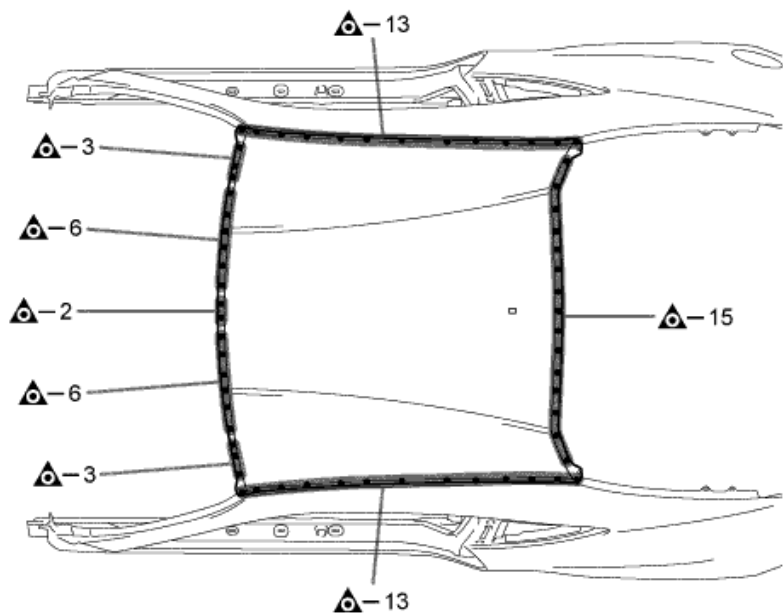
- REMOVAL
- INSTALLATION

ROOF PANEL > ASSEMBLY REPLACEMENT



REMOVAL

Symbol meaning	
	Remove Weld Points



INSTALLATION

Symbol meaning	
⊙	Spot Weld
	Plug Weld

	
	Body Sealer

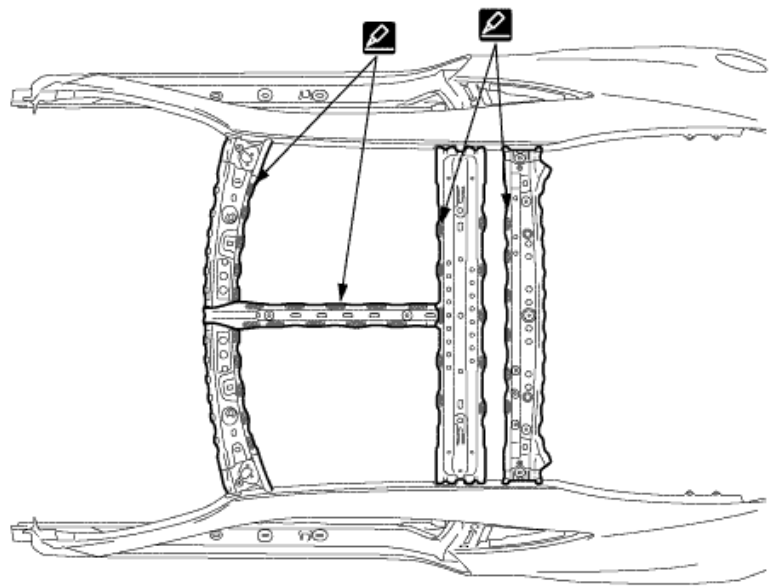
INSTALLATION POINT

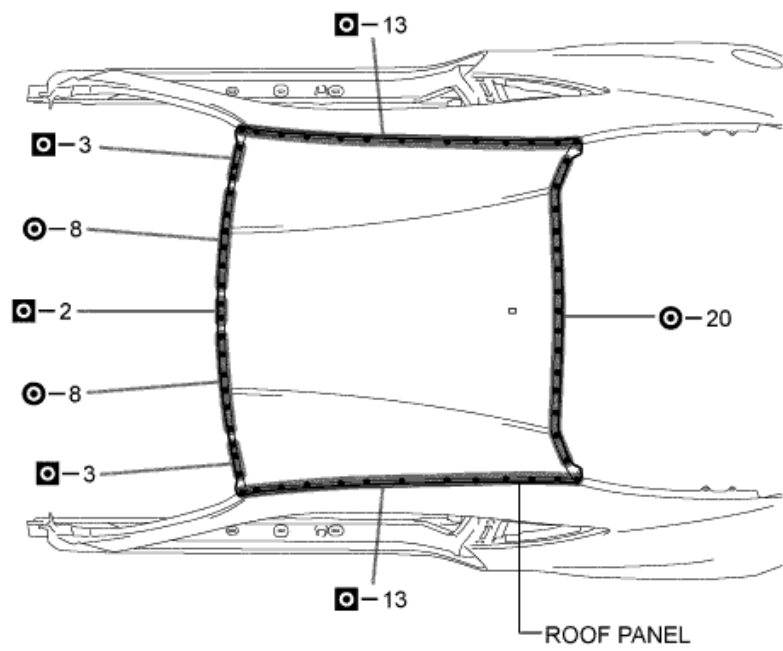
1. Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
2. Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimensions)
3. Before temporarily installing the new parts, apply body sealer to the windshield header panel and roof panel reinforcement.

HINT:

Apply just enough body sealer for the new parts to make contact.

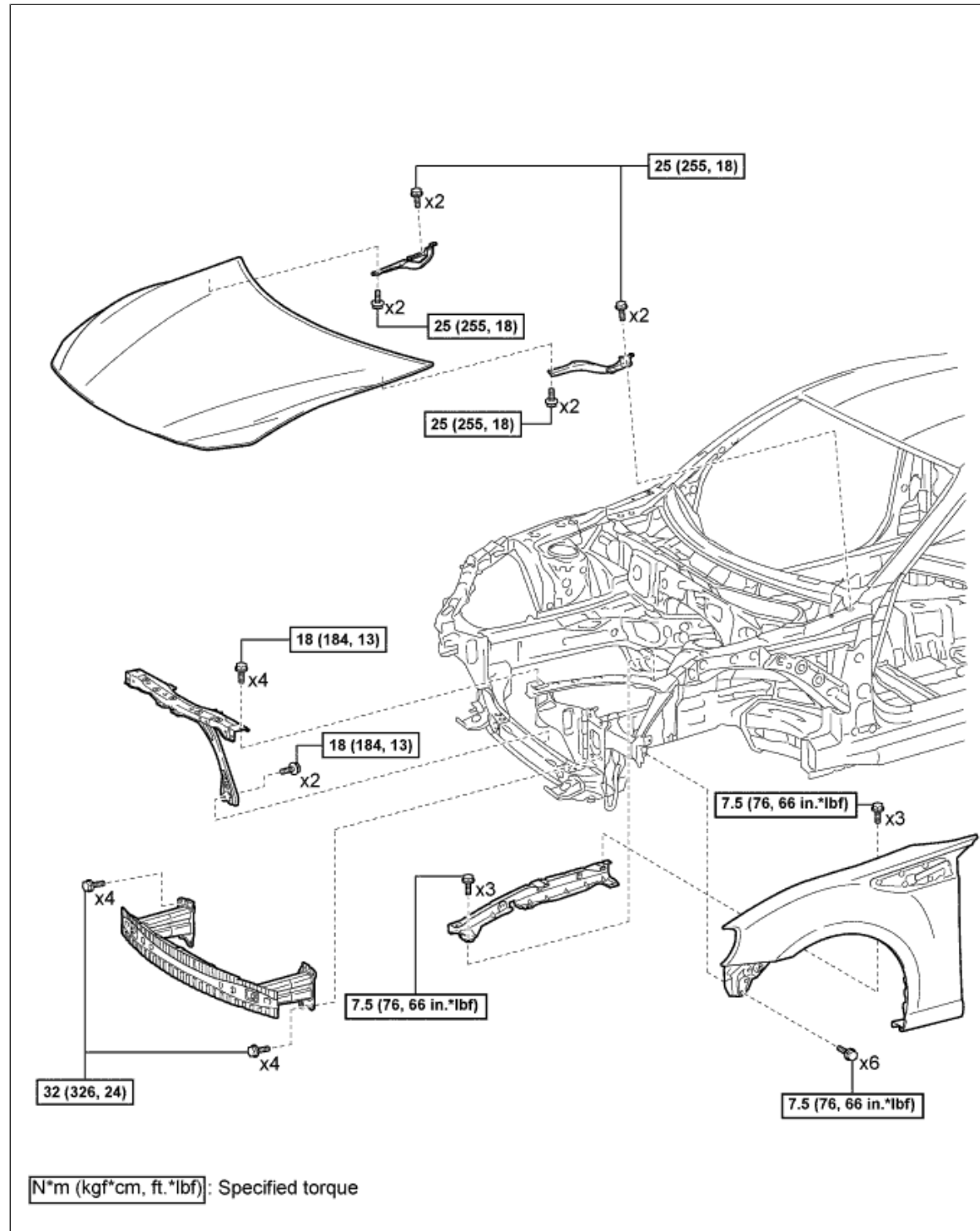
4. After welding, apply body sealer to the corresponding parts. (See the painting / coating)
5. After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

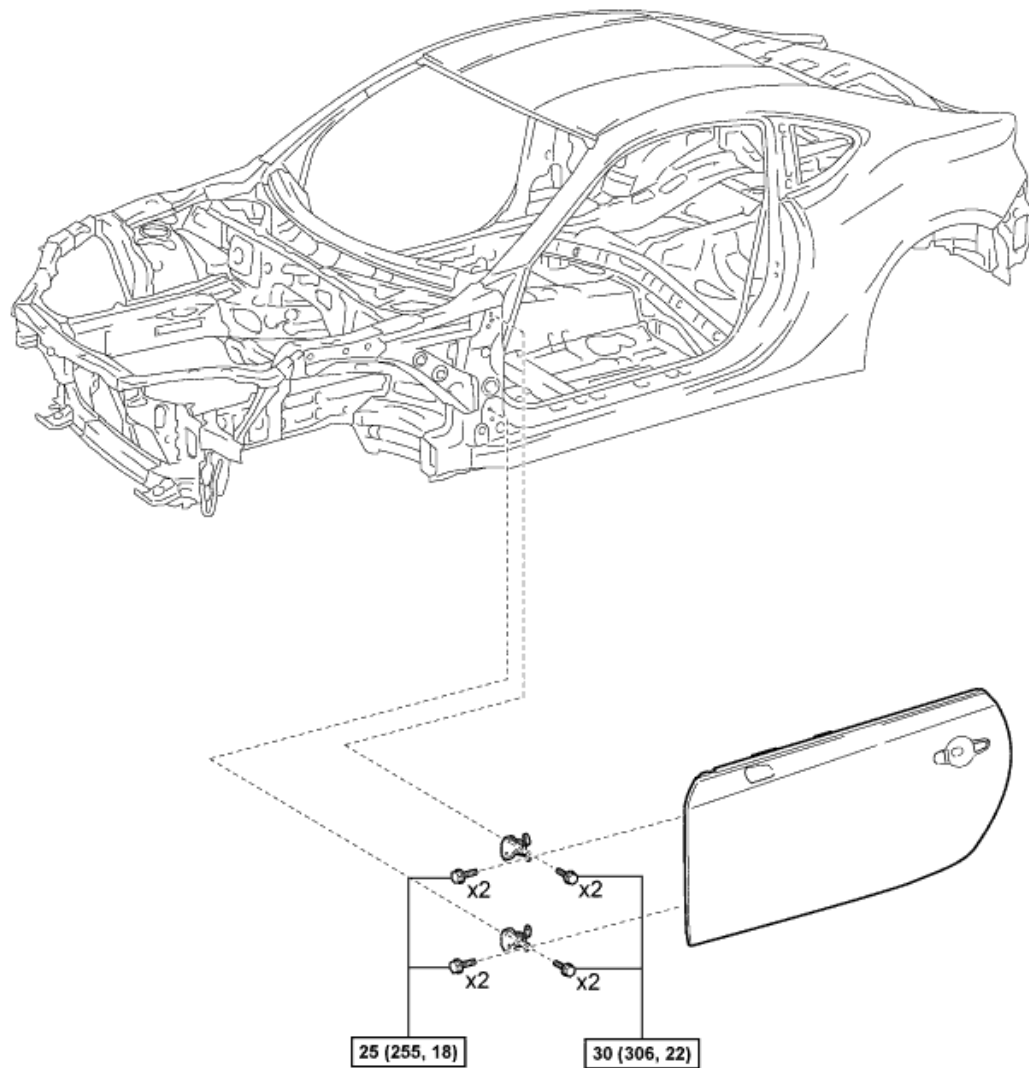




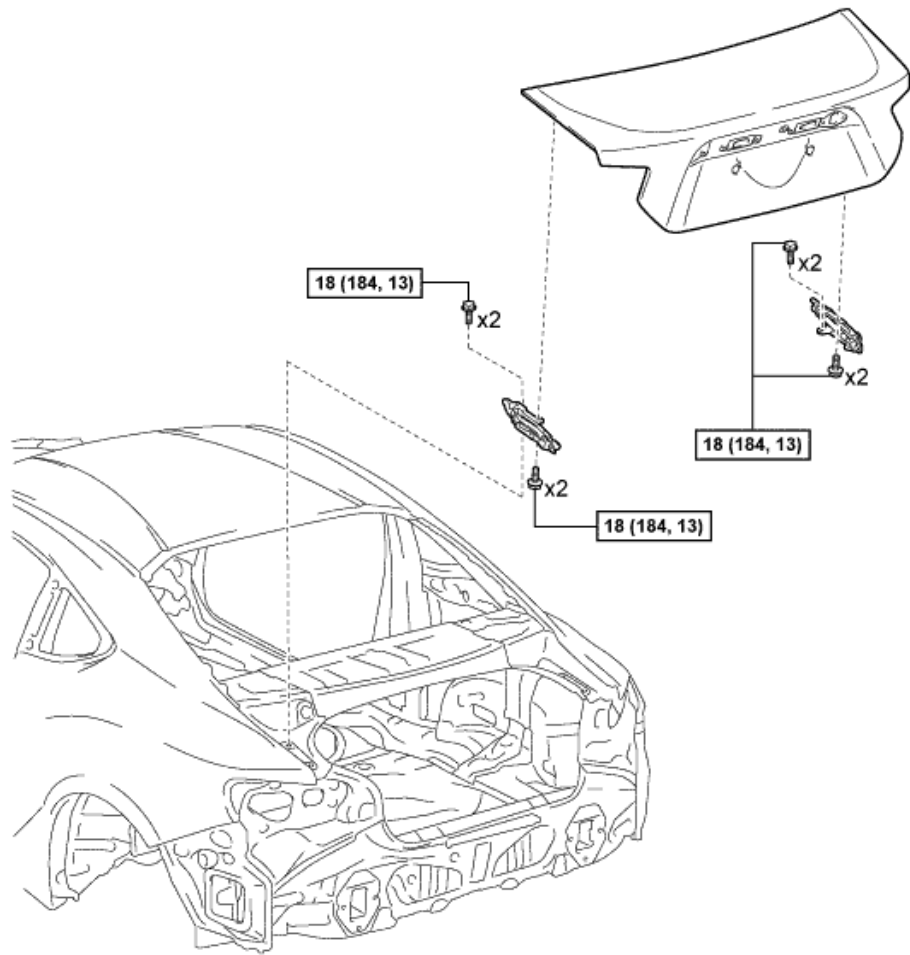
SPECIFIED TORQUE >
COMPONENTS

SPECIFIED TORQUE > COMPONENTS

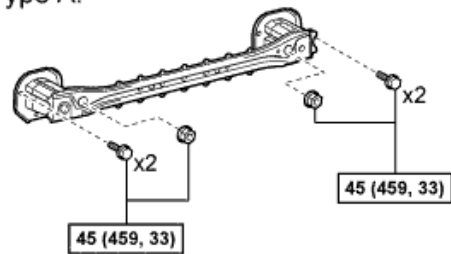




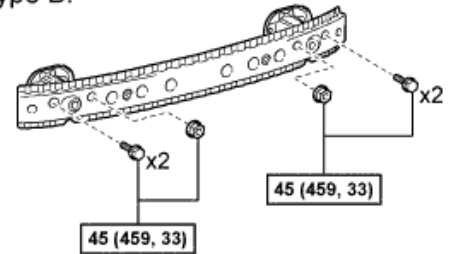
N*m (kgf*cm, ft.*lbf): Specified torque



for Type A:



for Type B:



N*m (kgf*cm, ft.*lbf): Specified torque

