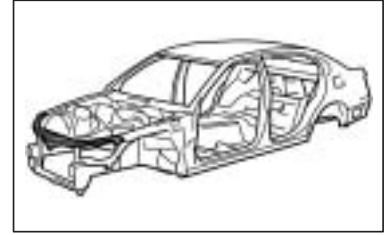
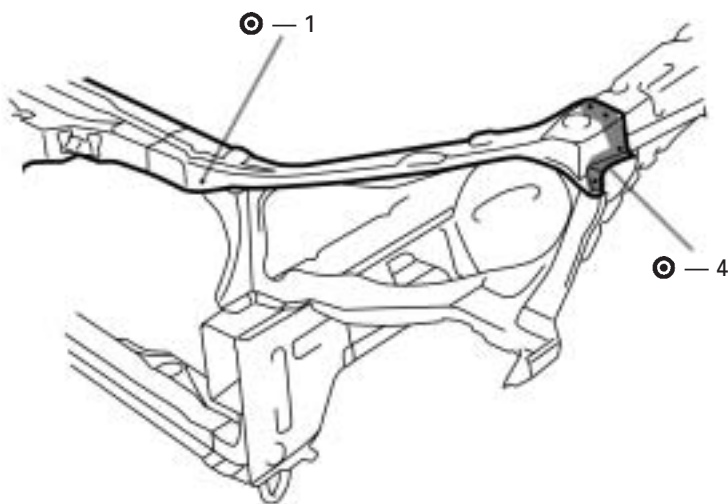
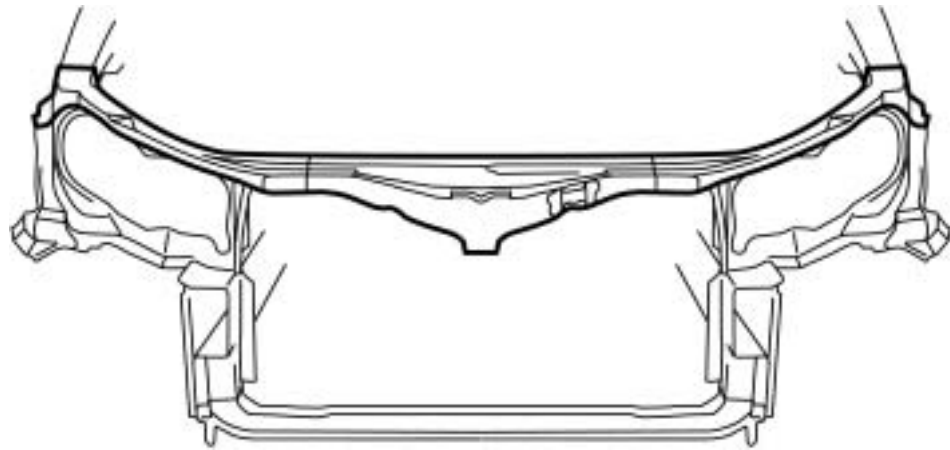
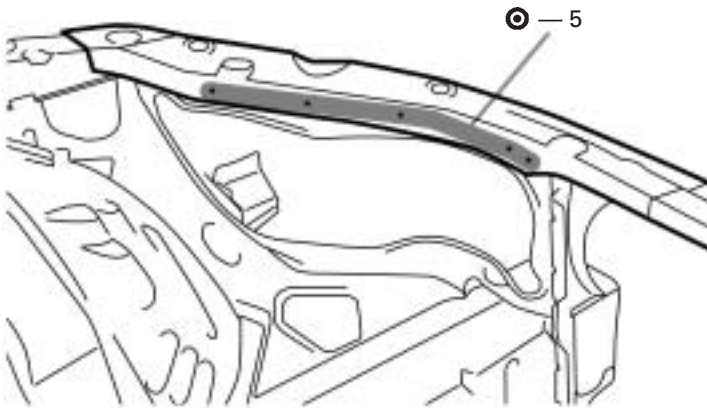


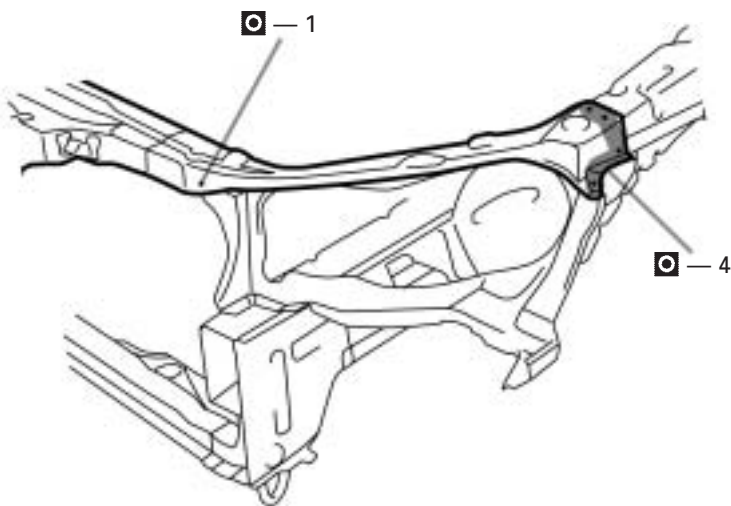
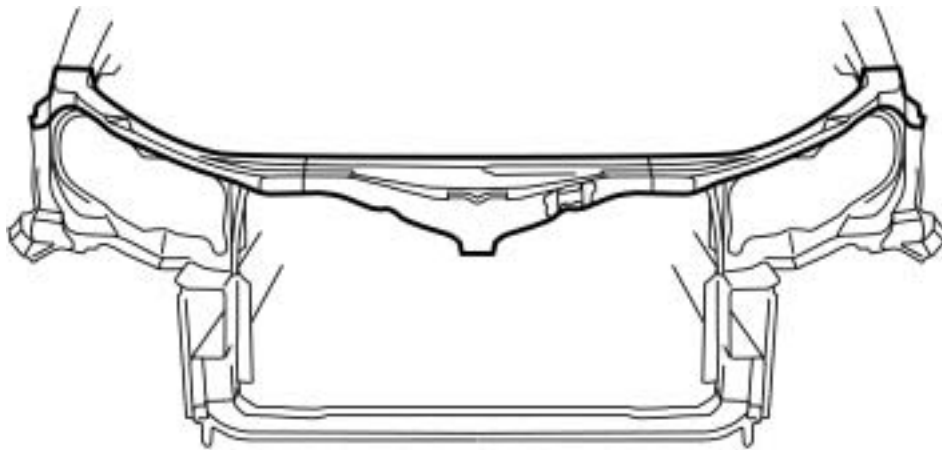
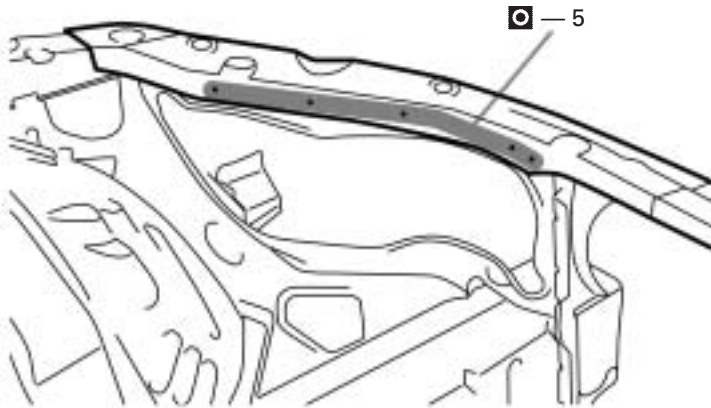
RADIATOR UPPER SUPPORT (ASSY)



REMOVAL



INSTALLATION

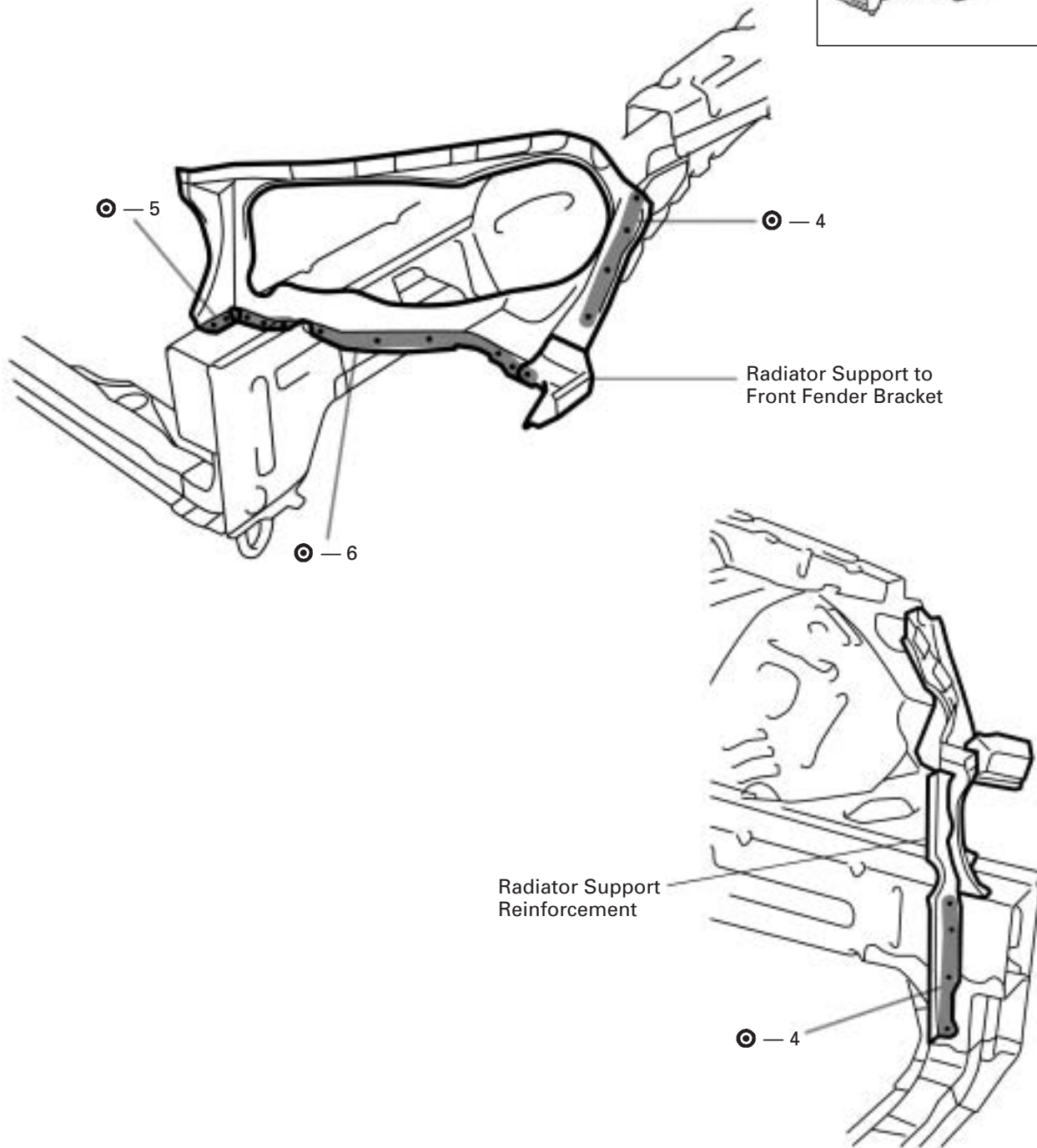
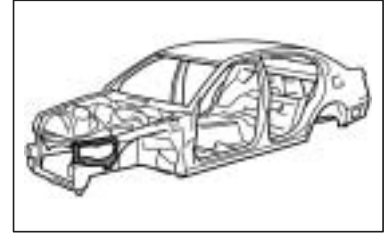


1. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.

HINT: First install the hood lock support.

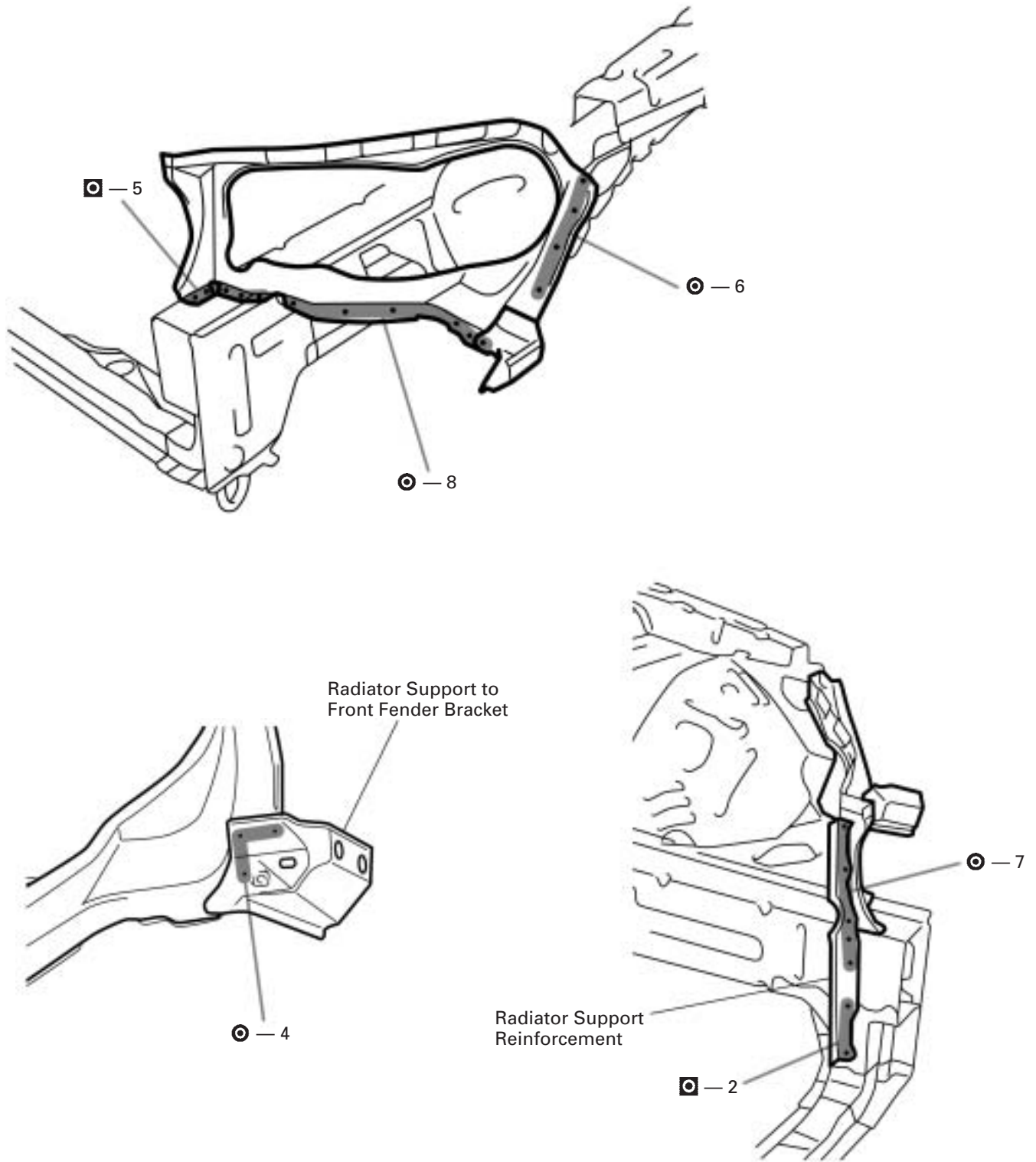
RADIATOR SIDE SUPPORT (ASSY)

REMOVAL (With the radiator upper support removed.)



1. Replace the radiator support to front fender bracket and radiator support reinforcement at the same time.

INSTALLATION

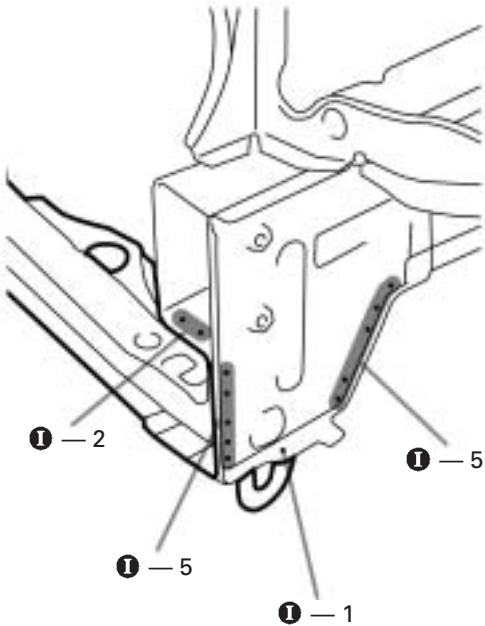
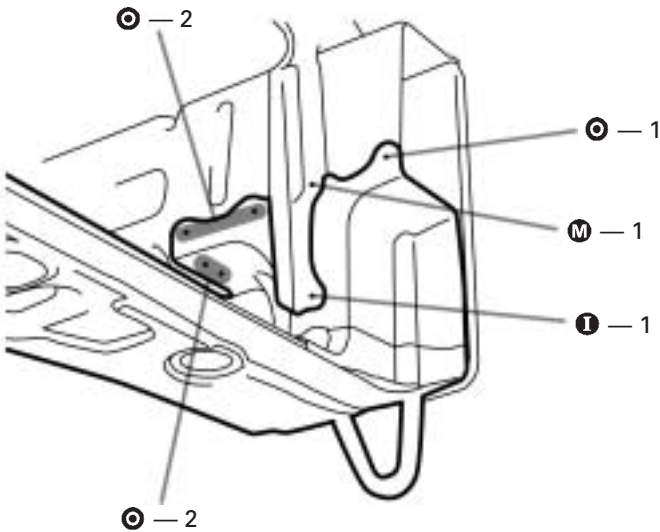
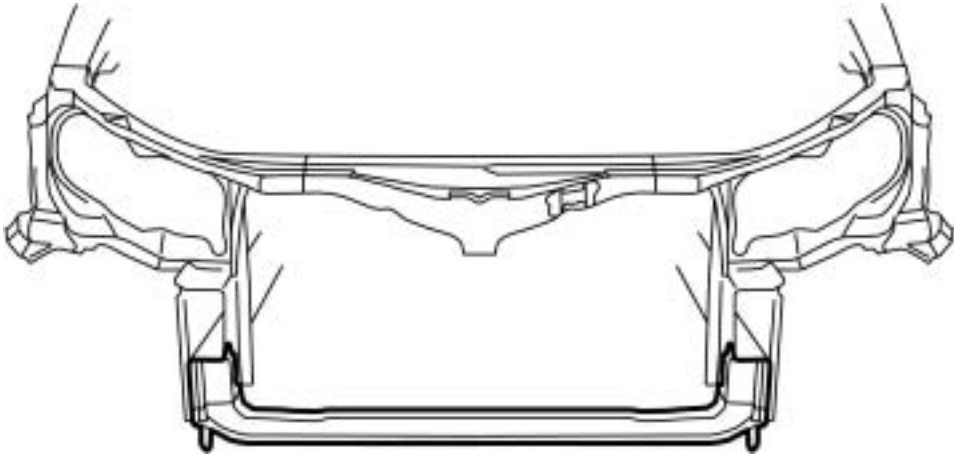
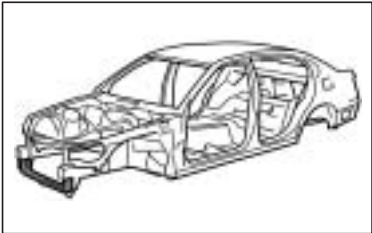


1. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.

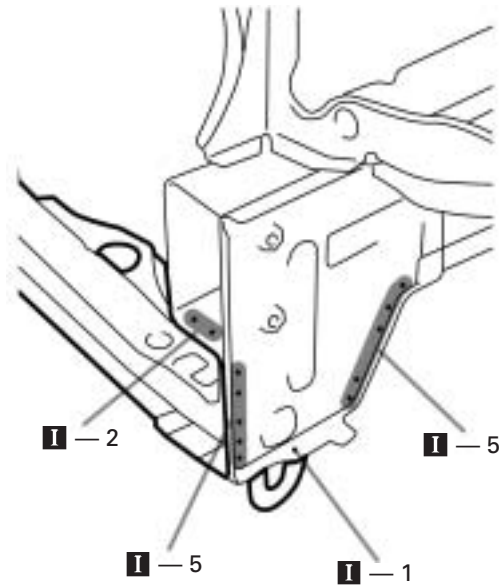
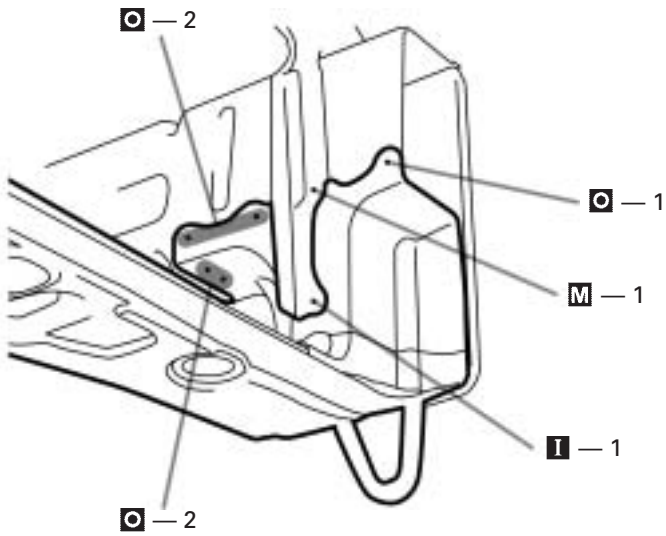
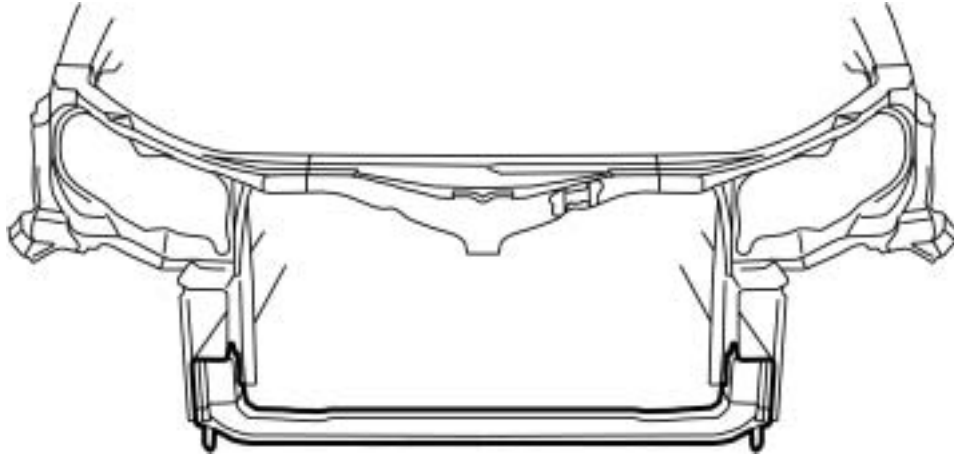
HINT: First install the radiator upper support.

FRONT CROSSMEMBER (ASSY)

REMOVAL



INSTALLATION

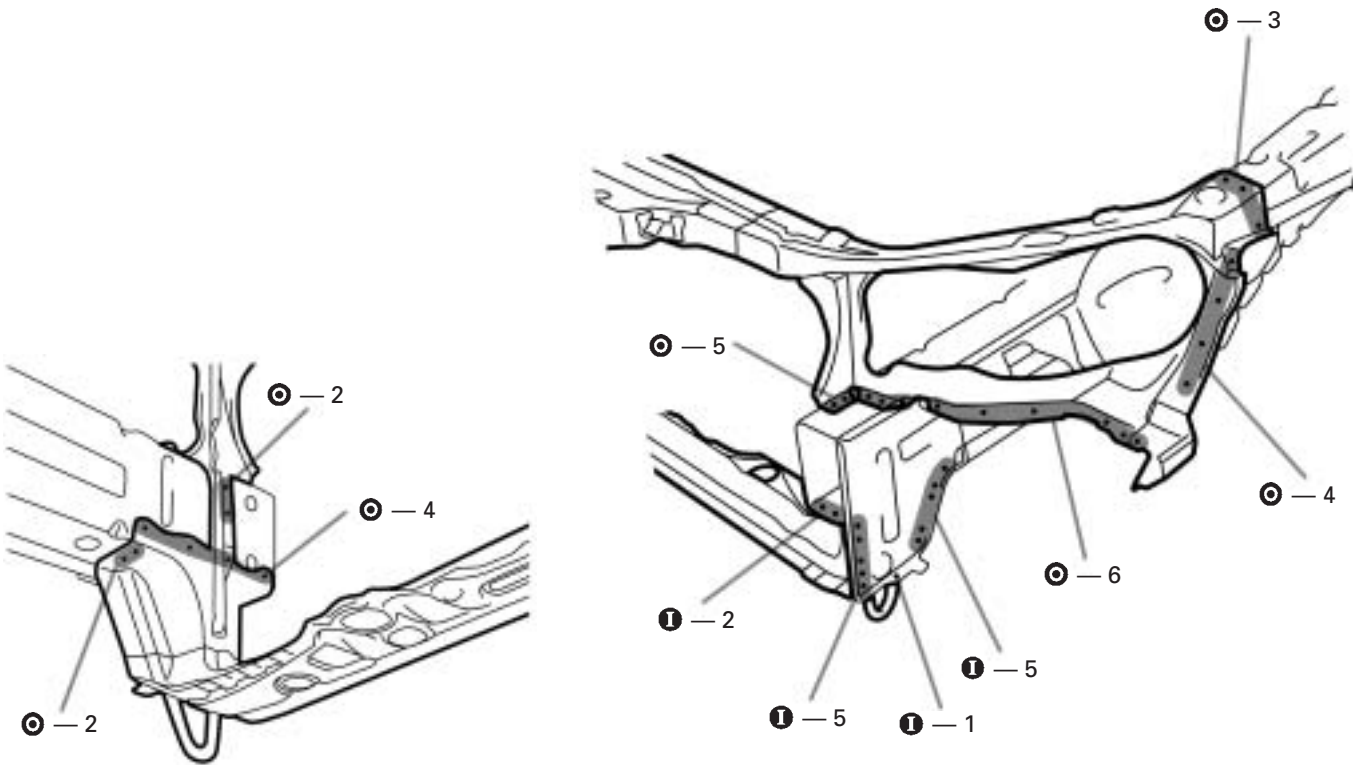
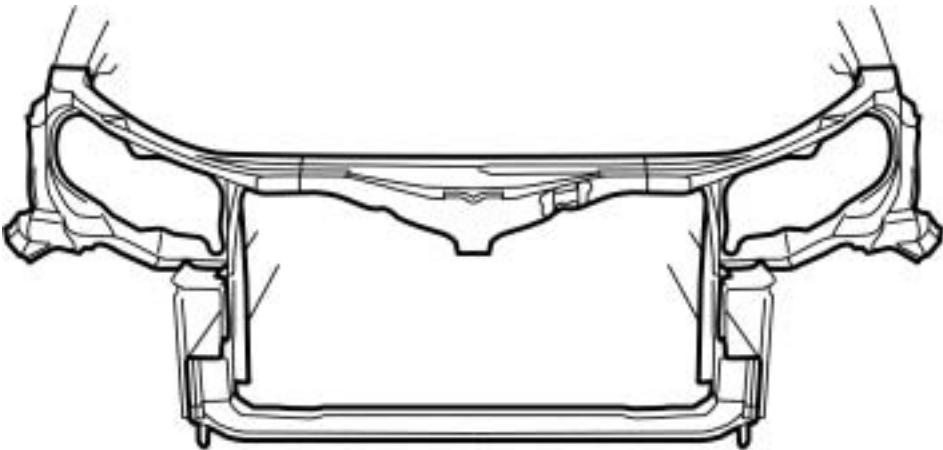
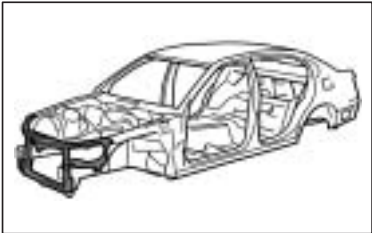


1. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.

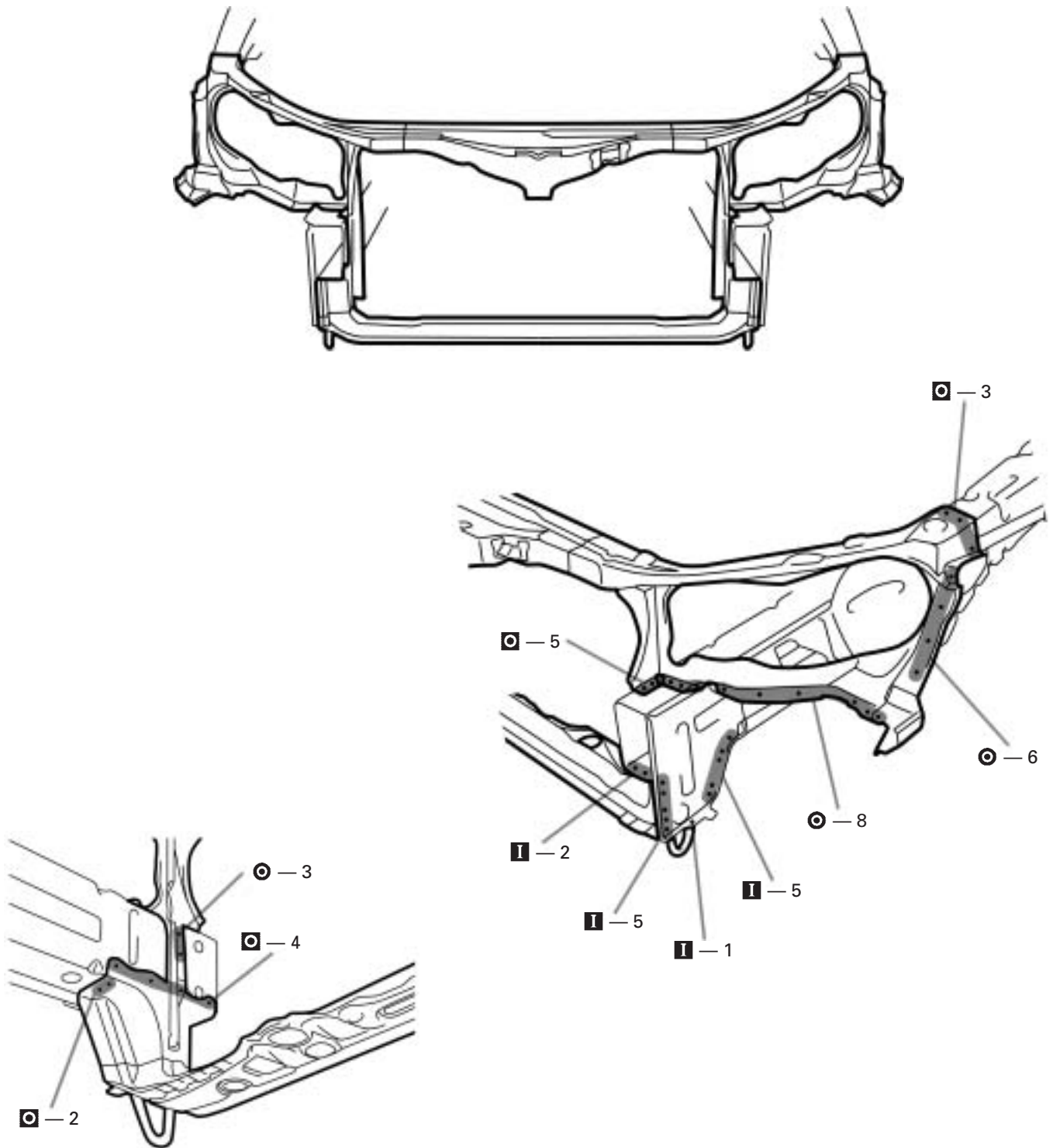
HINT: First install the hood lock support.

RADIATOR SUPPORT (ASSY)

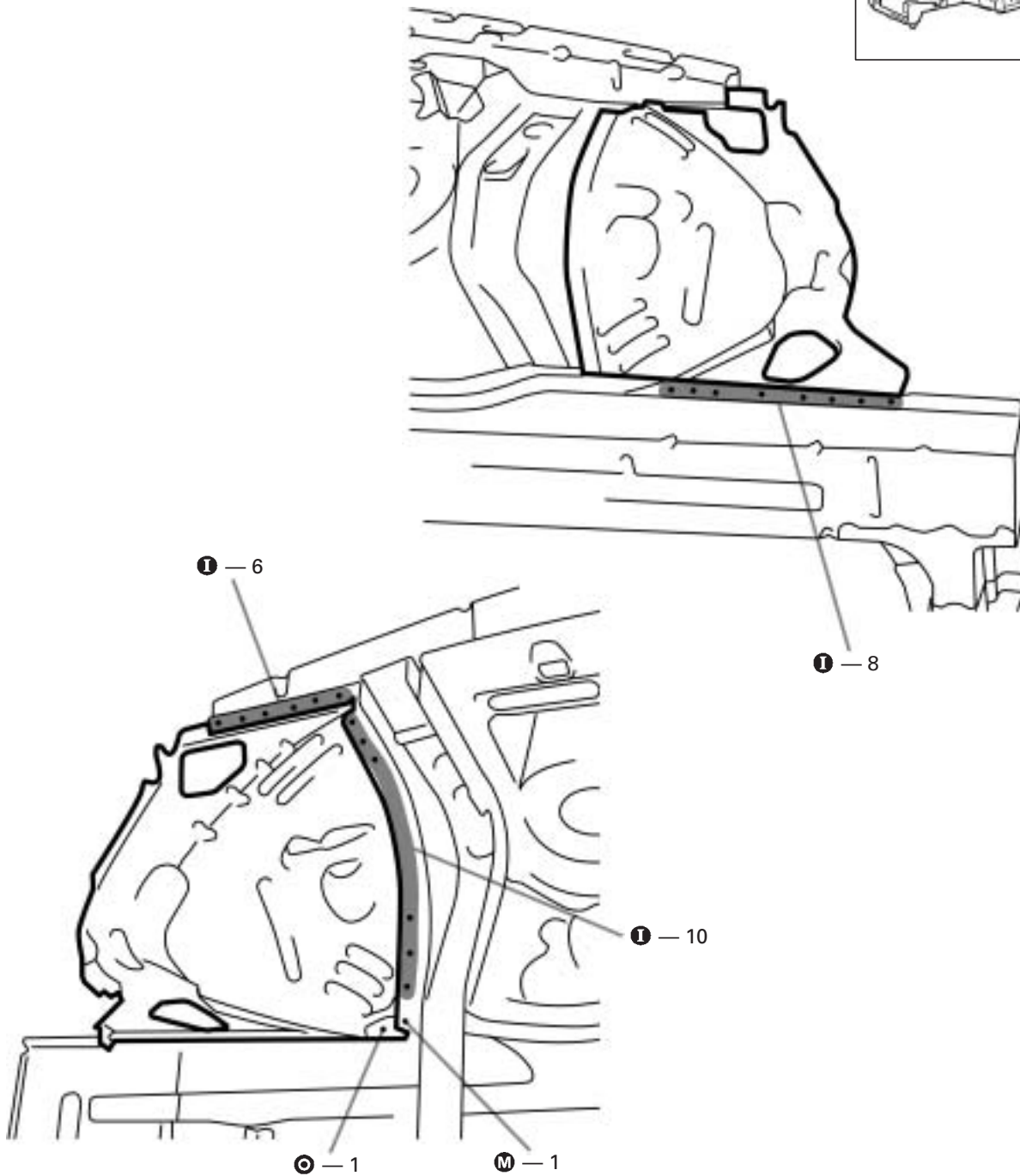
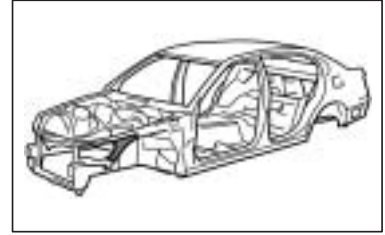
REMOVAL



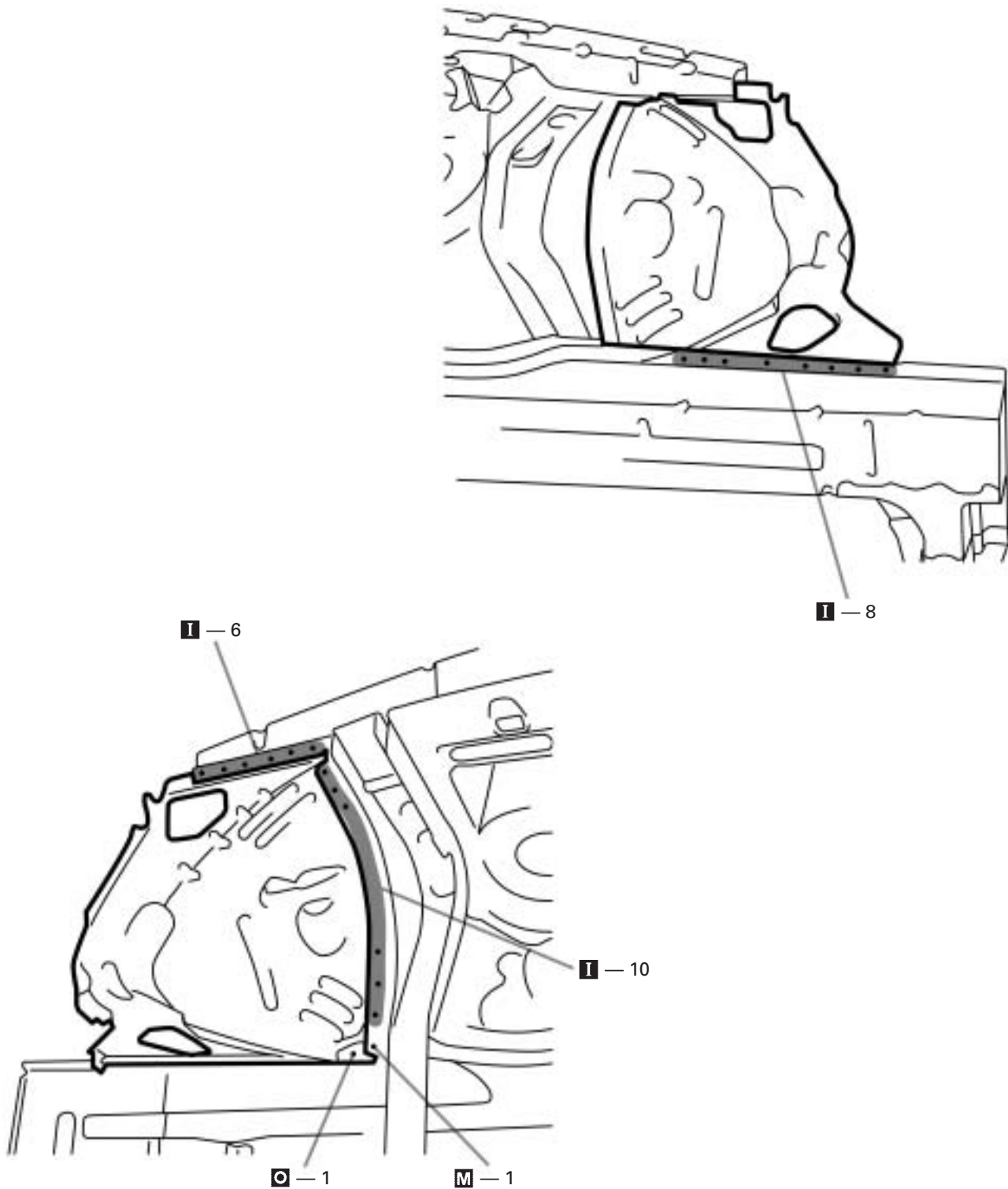
INSTALLATION



1. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.

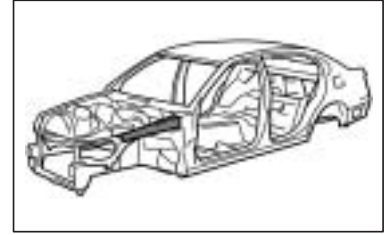
FRONT FENDER FRONT APRON (ASSY)**REMOVAL (With the radiator side support removed.)**

INSTALLATION

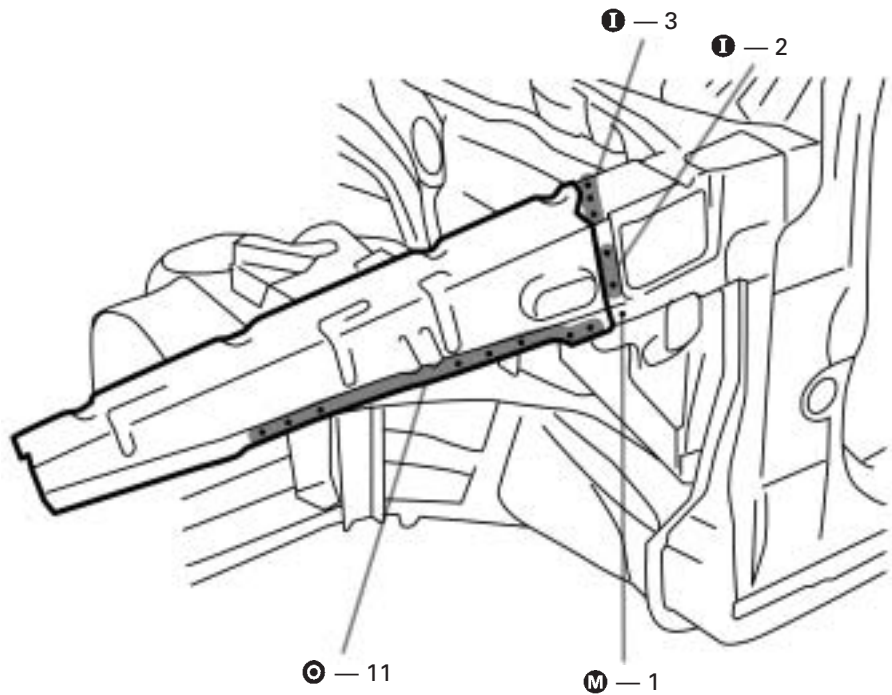
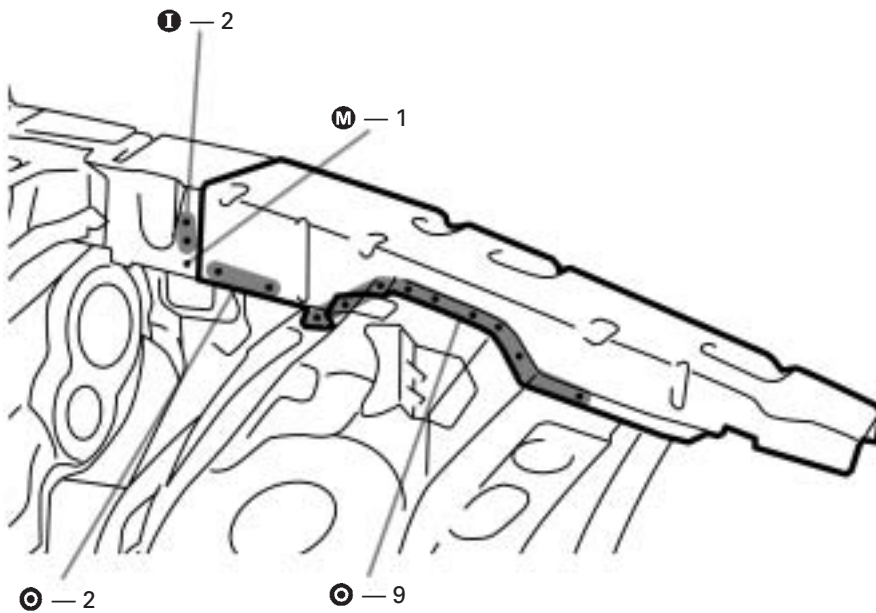


1. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.

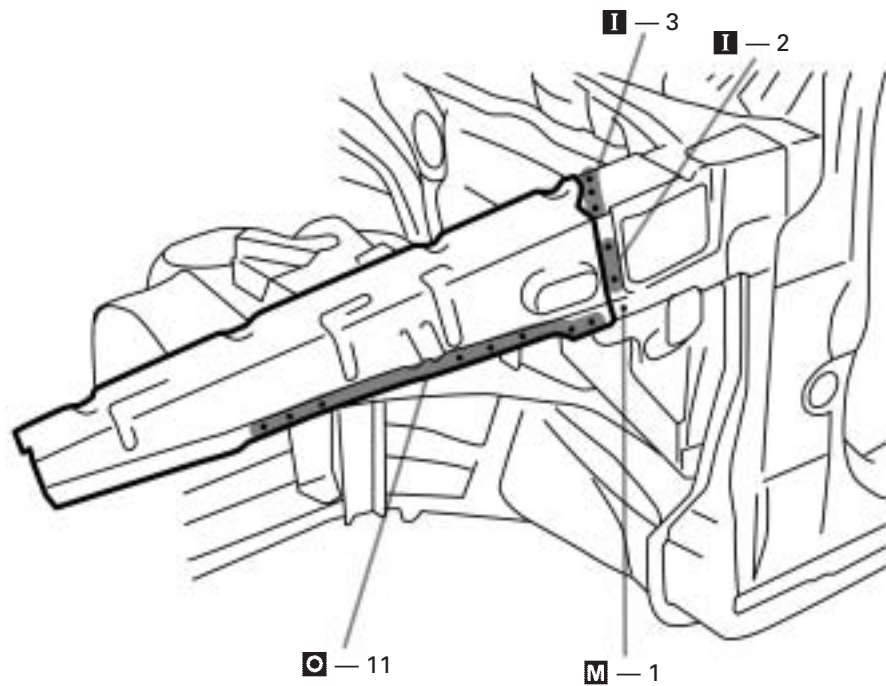
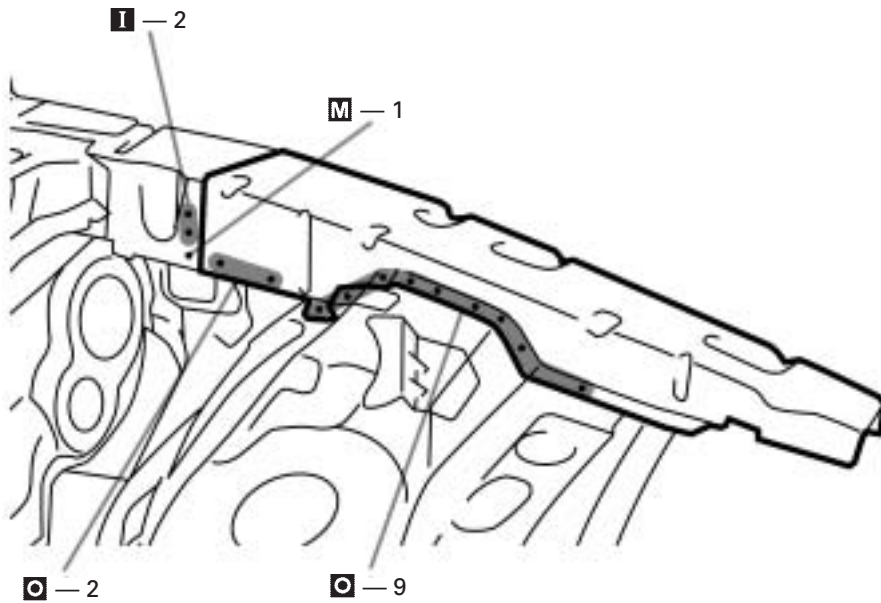
FRONT APRON TO COWL SIDE MEMBER (ASSY)



REMOVAL (With the front fender front apron removed.)



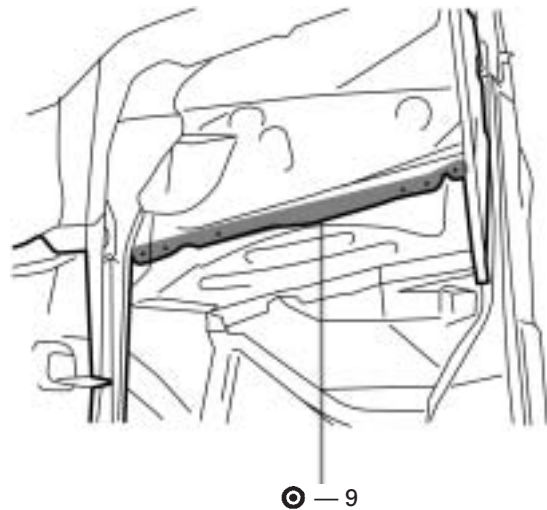
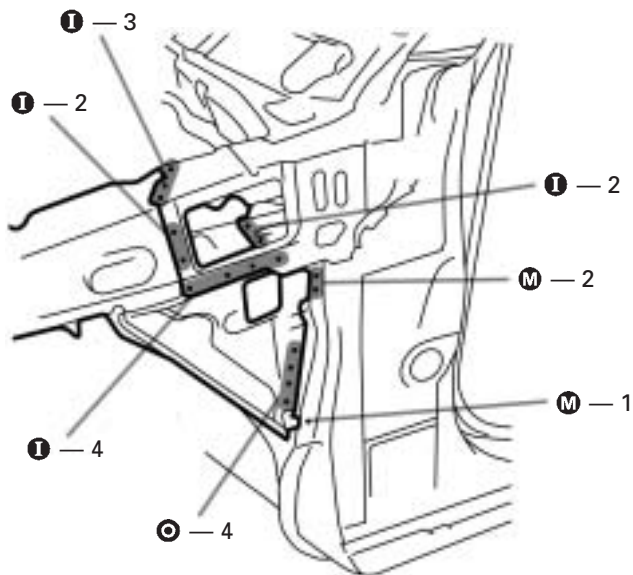
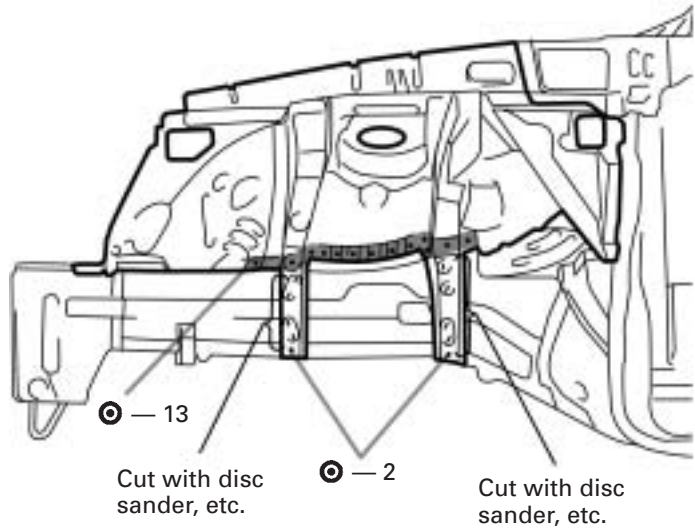
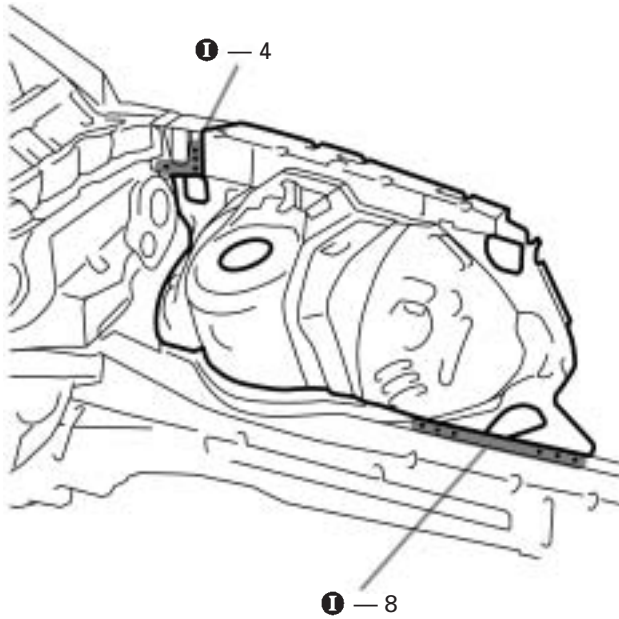
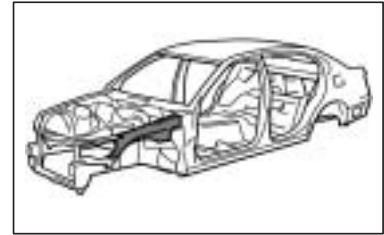
INSTALLATION



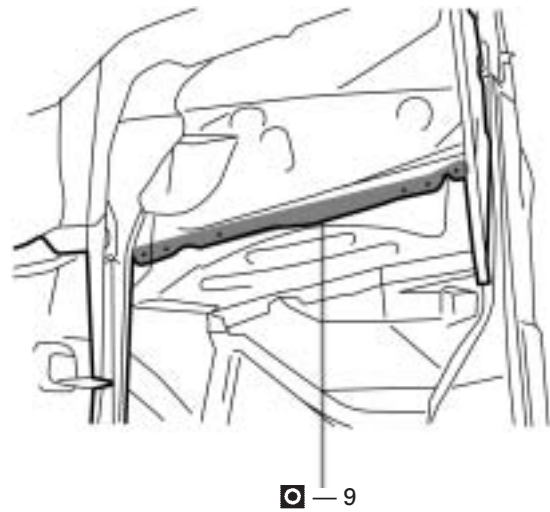
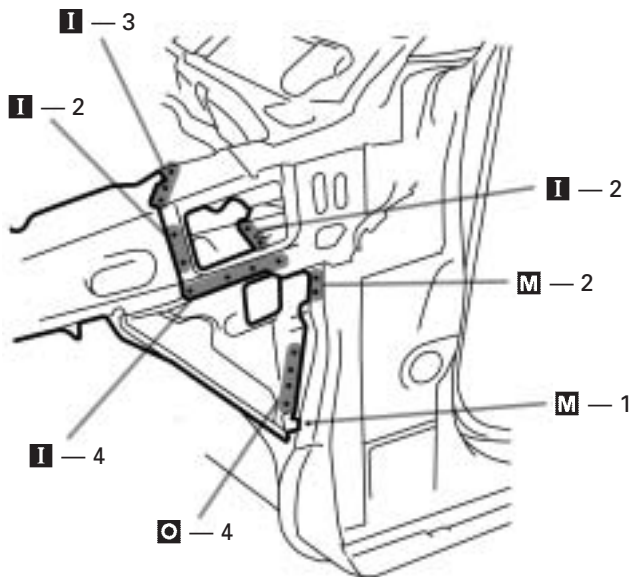
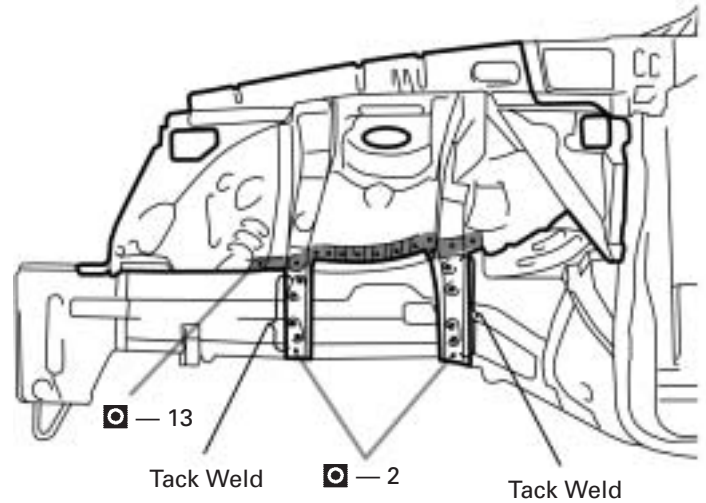
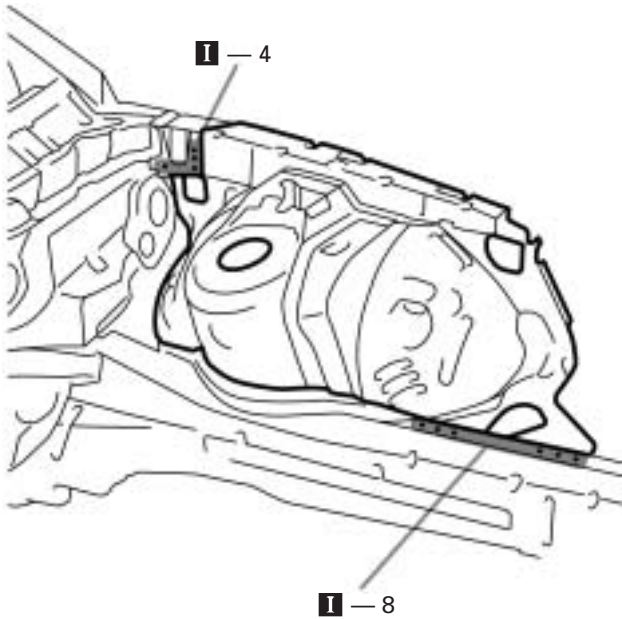
1. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.
2. Temporarily install the front fender and hood, and check the fit.

FRONT FENDER APRON (ASSY)

REMOVAL (With the radiator side support removed.)



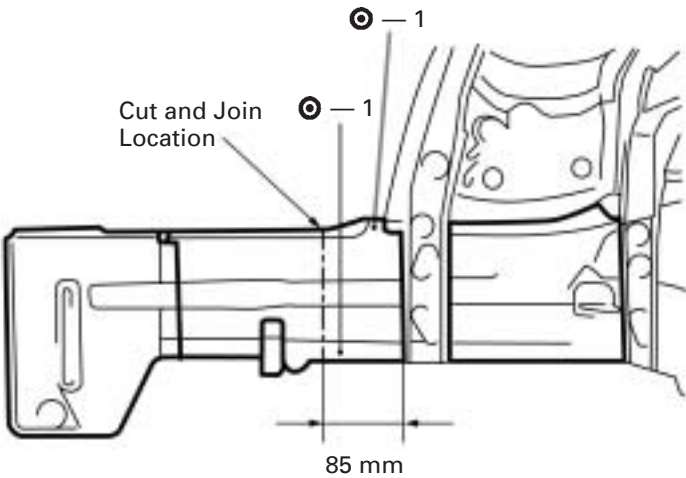
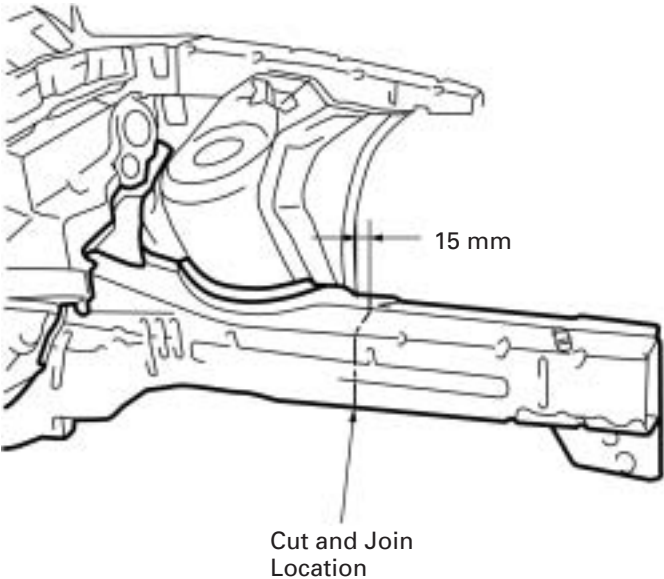
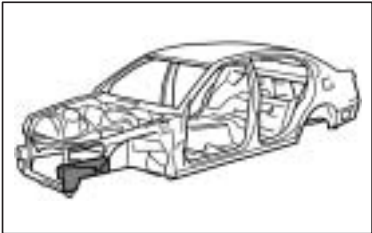
INSTALLATION



1. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.
2. Measurements must be accurate with the body dimension diagram, as this affects the front wheel alignment.
3. Temporarily install the front fender and hood, and check the fit.

FRONT SIDE MEMBER (CUT-P)

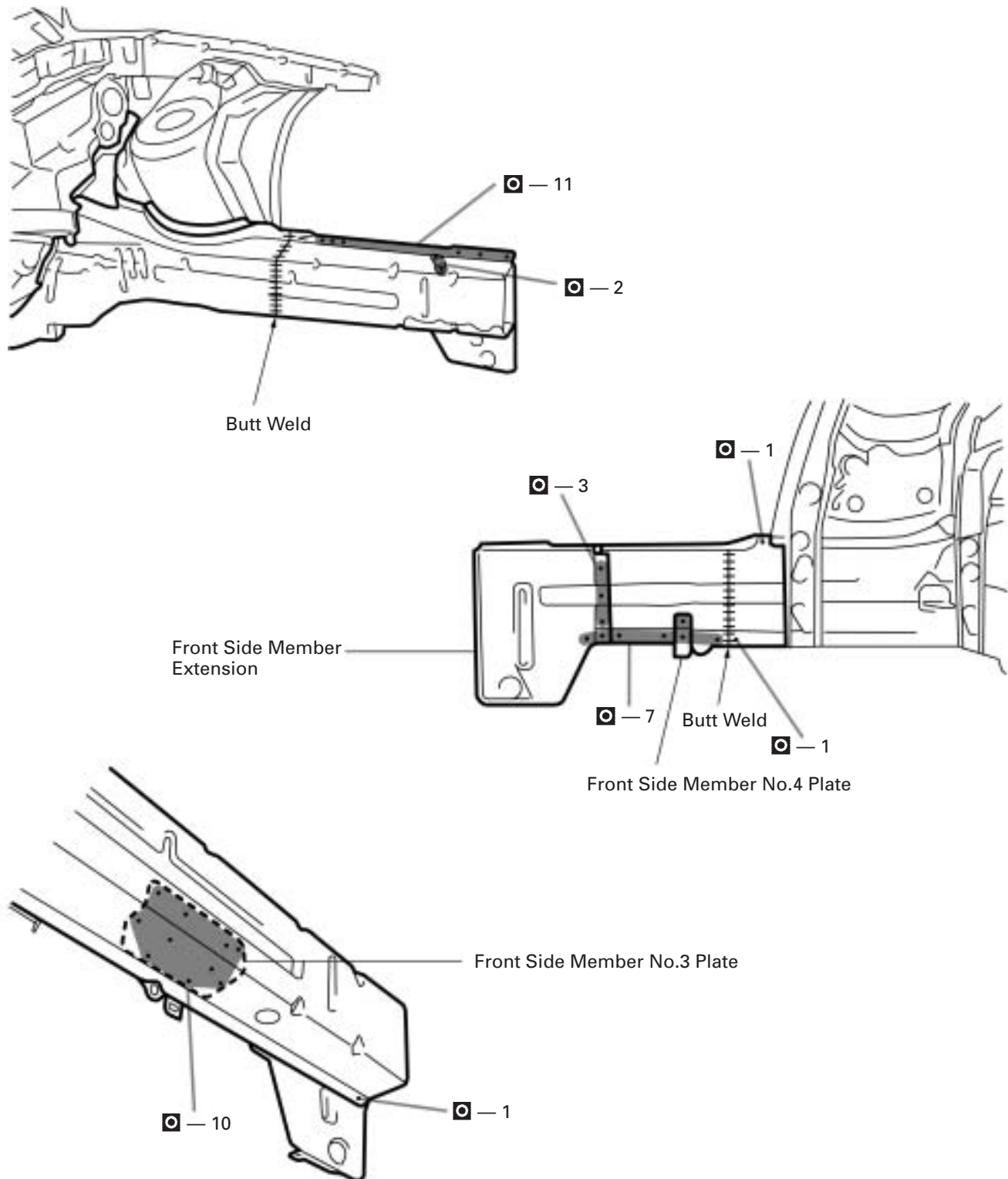
REMOVAL (With the front crossmember, front fender front apron removed.)



1. Cut and join the parts at the locations as shown above.

mm	in.
15	0.59
85	3.35

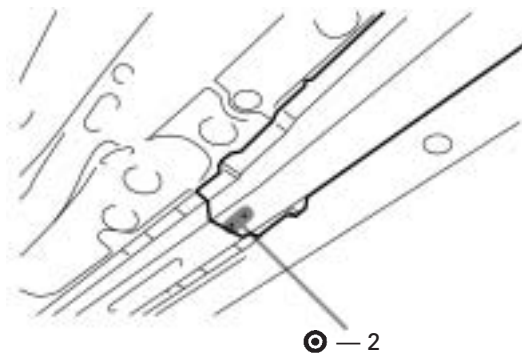
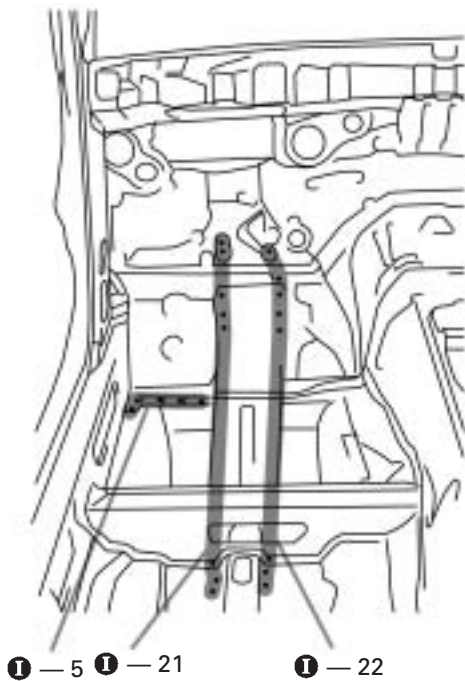
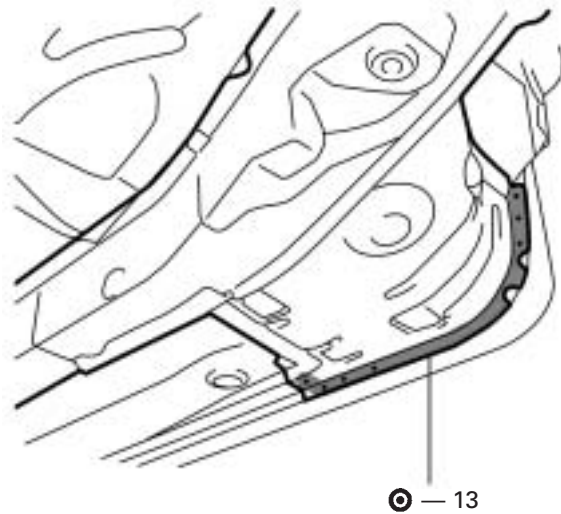
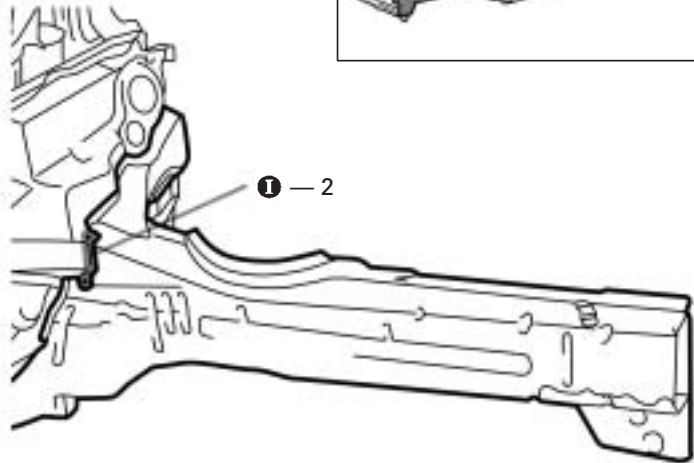
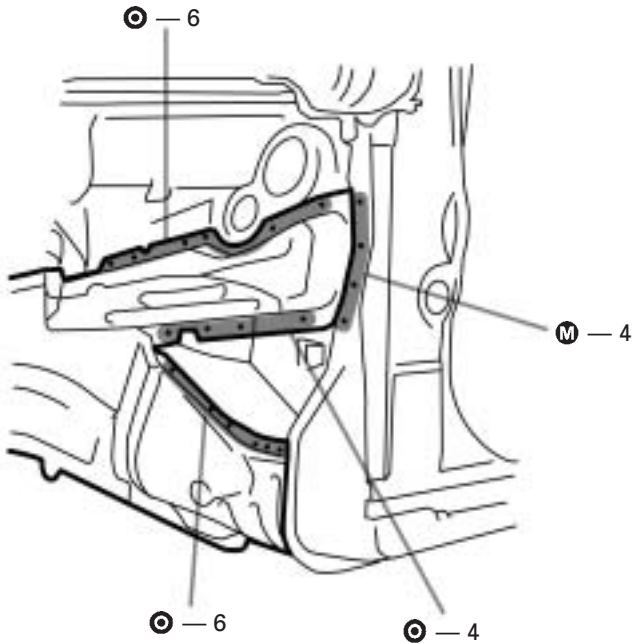
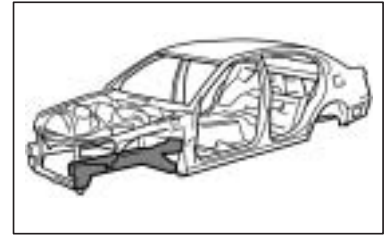
INSTALLATION



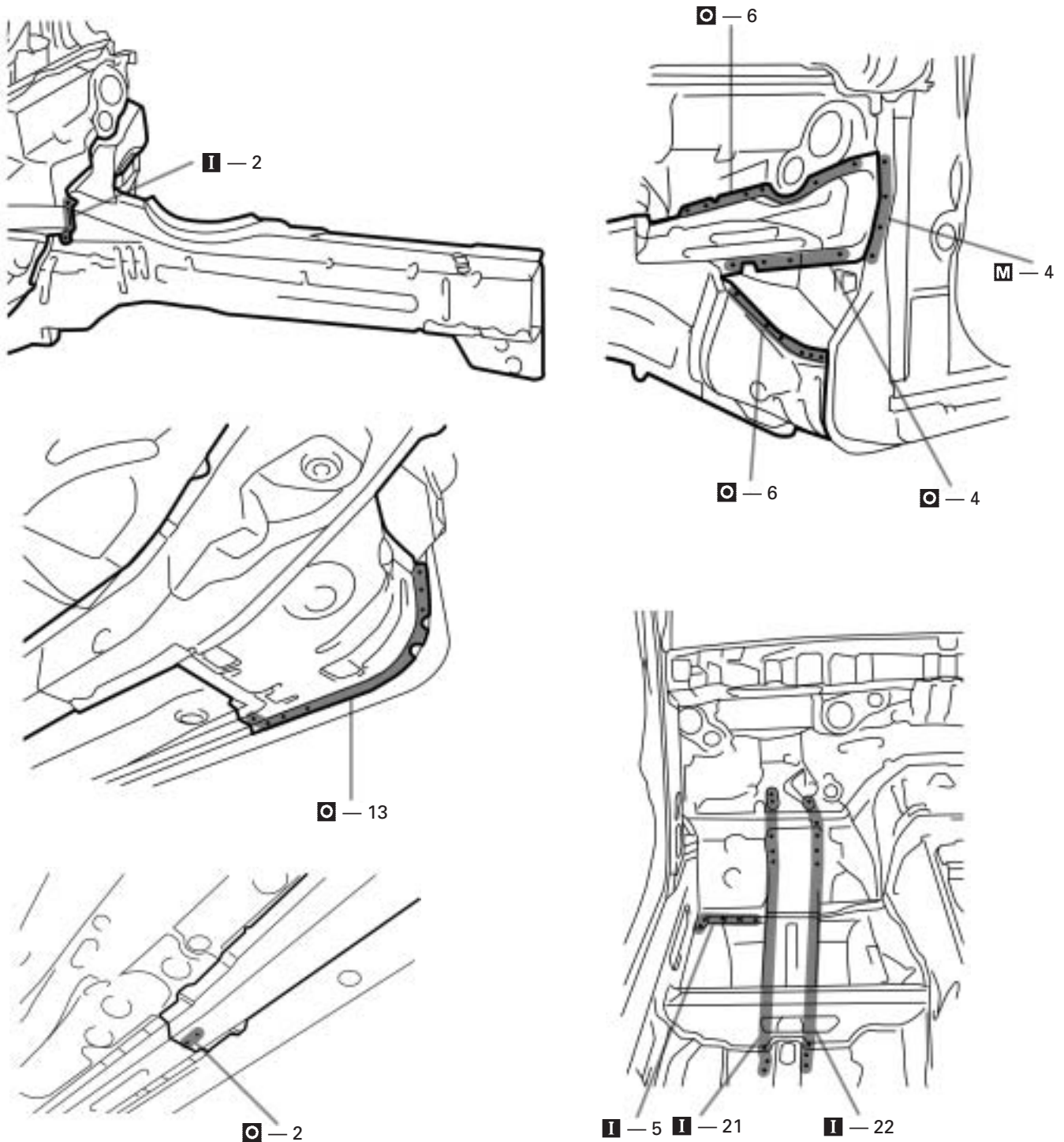
1. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.

FRONT SIDE MEMBER (ASSY)

REMOVAL (With the front crossmember, front fender apron removed.)



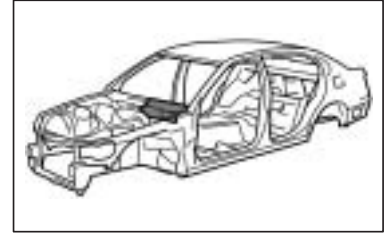
INSTALLATION



1. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.

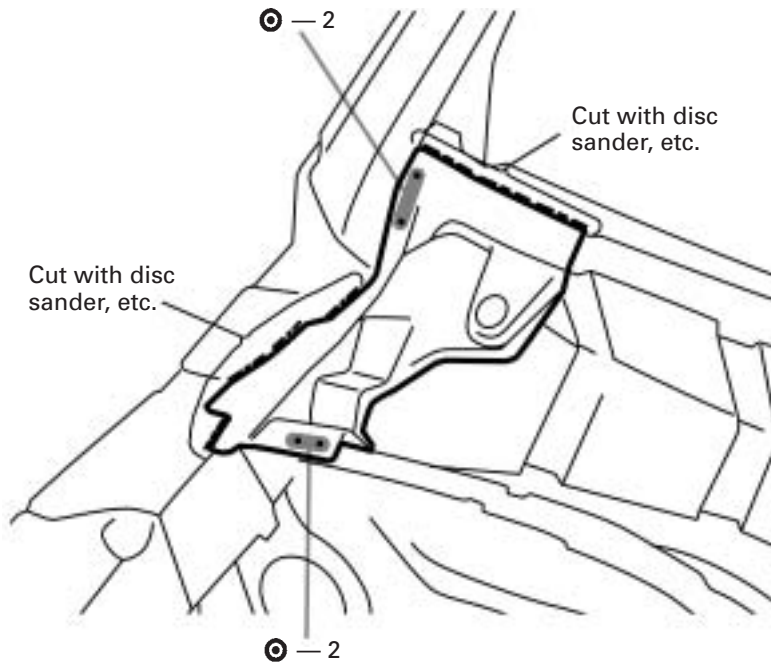
HINT: Make sure each measurement is correct, as this parts affects the front wheel alignment.

COWL TOP TO APRON BRACE (ASSY)

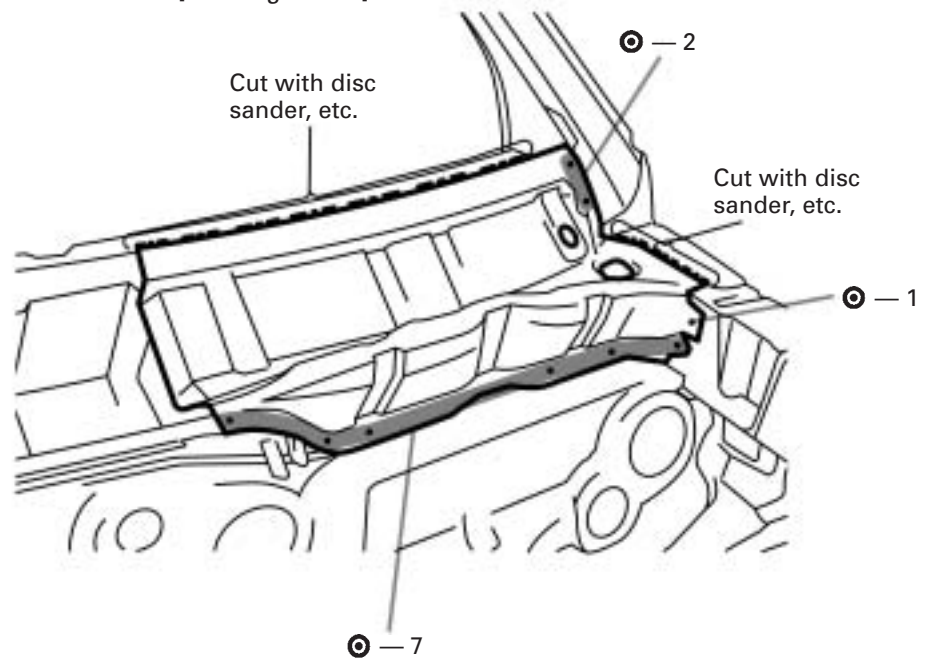


REMOVAL

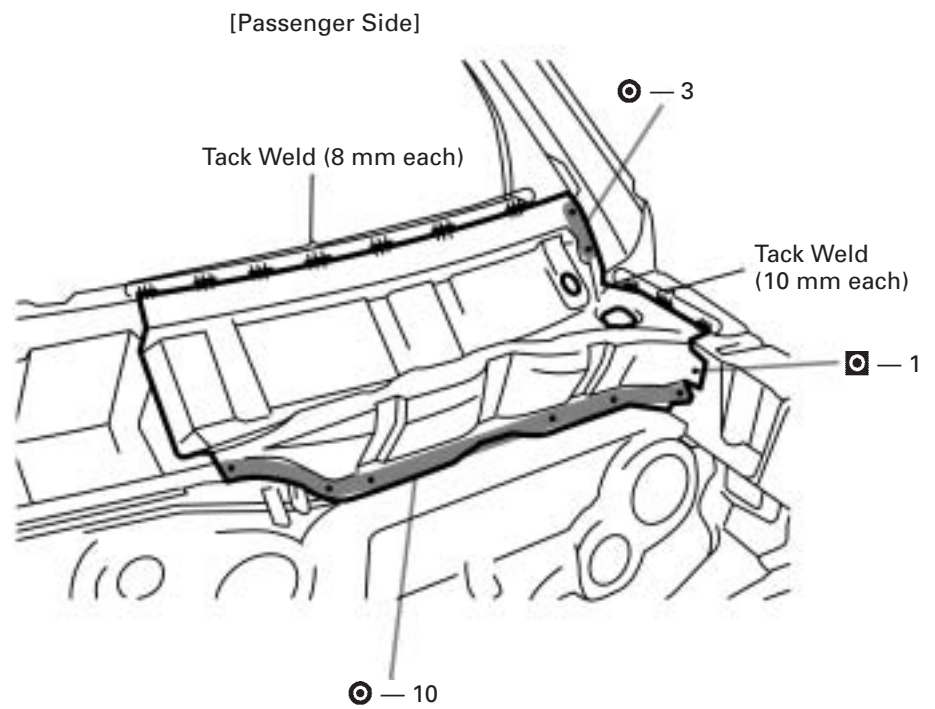
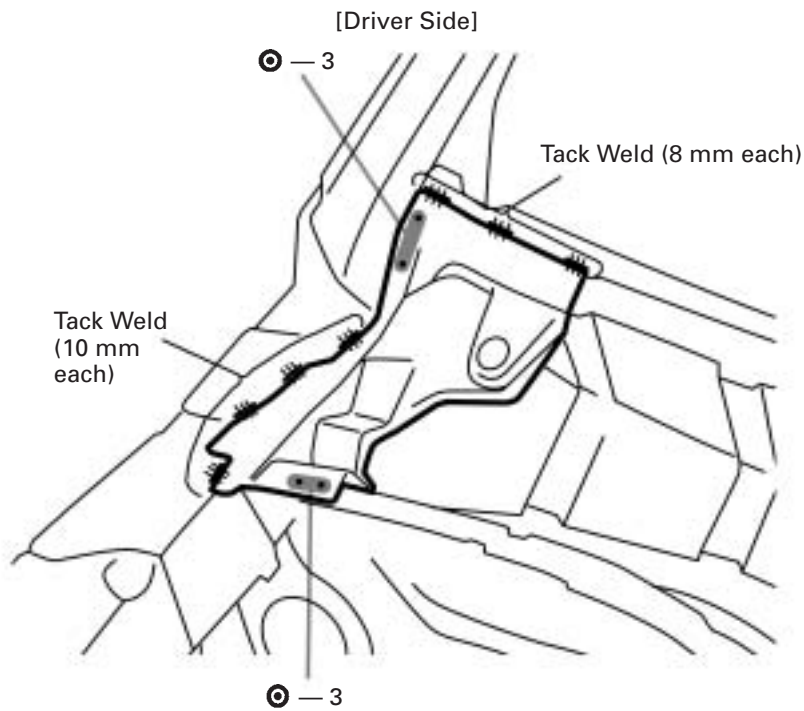
[Driver Side]



[Passenger Side]



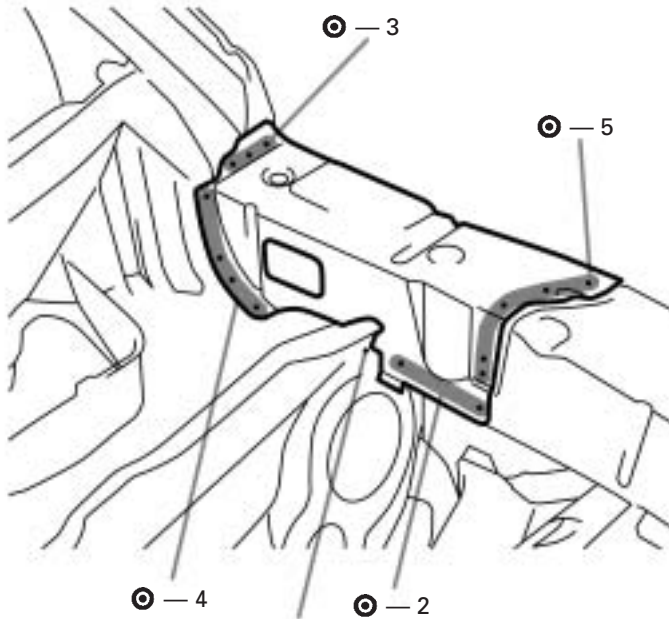
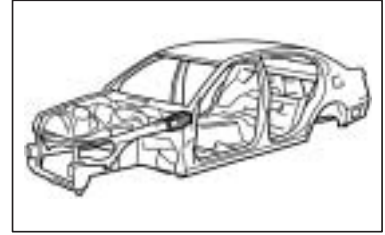
INSTALLATION



mm	in.
8	0.31
10	0.39

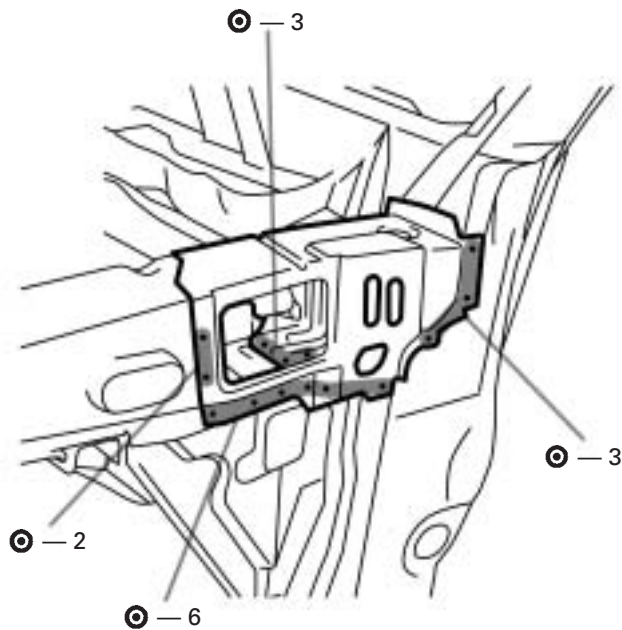
COWL TOP SIDE PANEL (ASSY)

REMOVAL (With the cowl top to apron brace removed.)

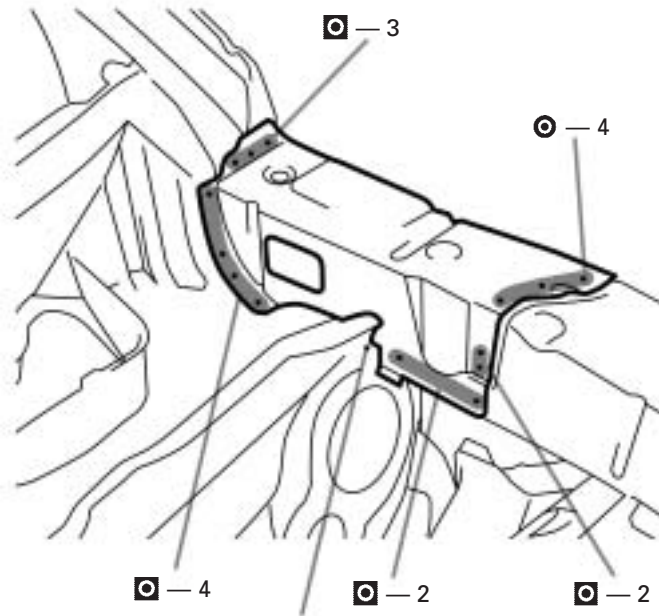


[RHD] RH: ❶ — 2
LH: ❶ — 1

[LHD] RH: ❶ — 1
LH: ❶ — 2

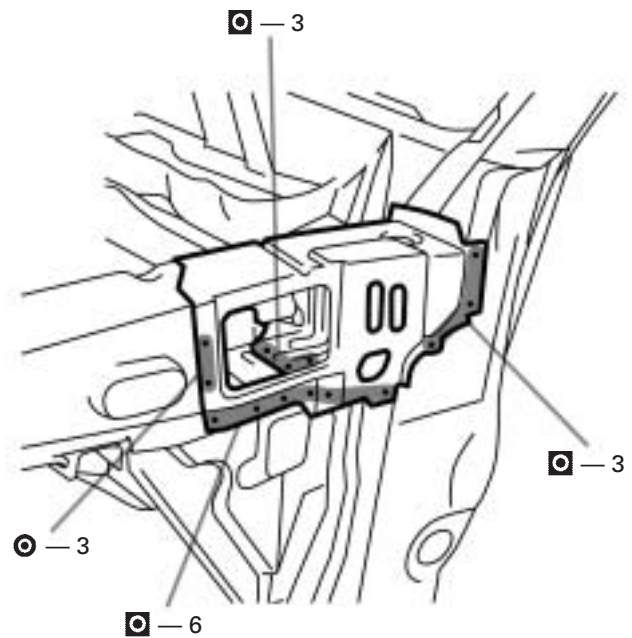


INSTALLATION



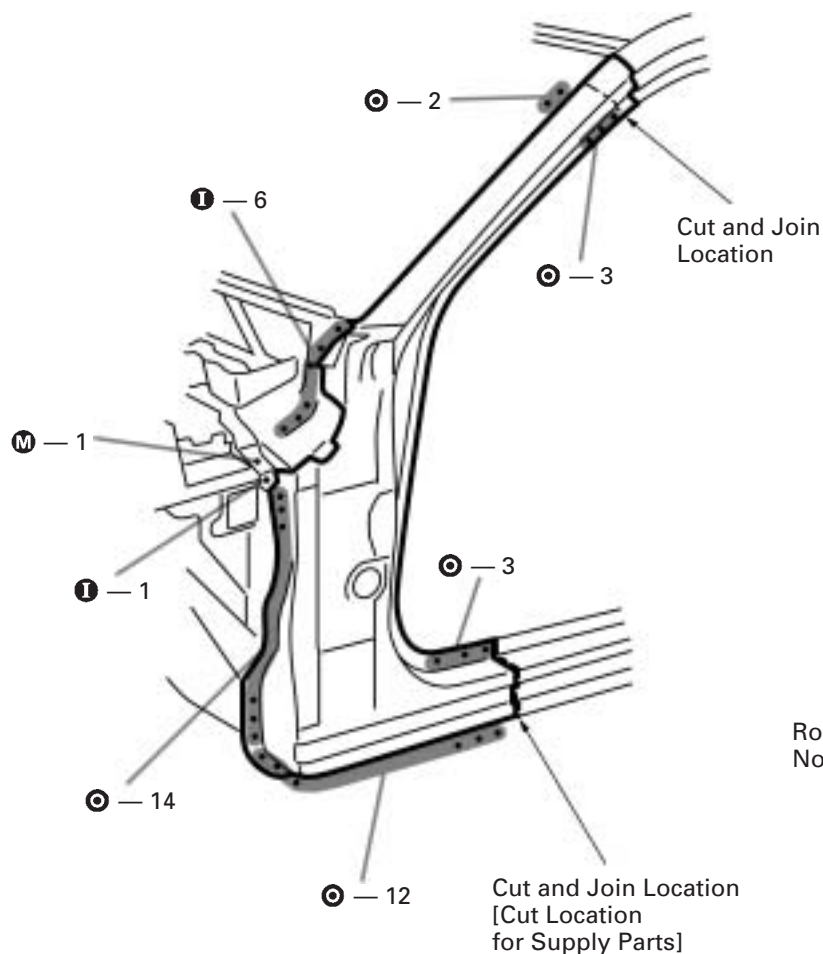
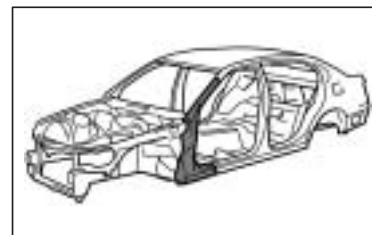
[RHD] RH: **1** — 2
LH: **1** — 1

[LHD] RH: **1** — 1
LH: **1** — 2

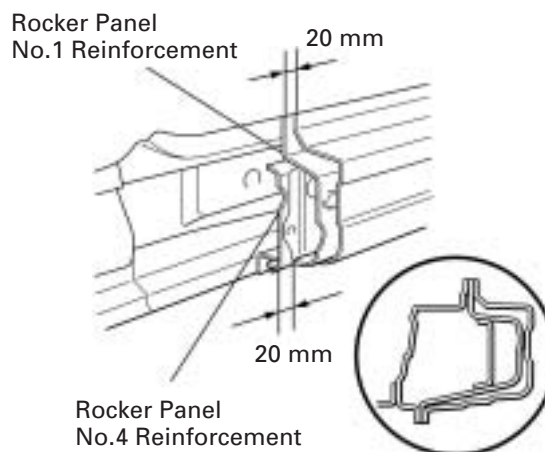
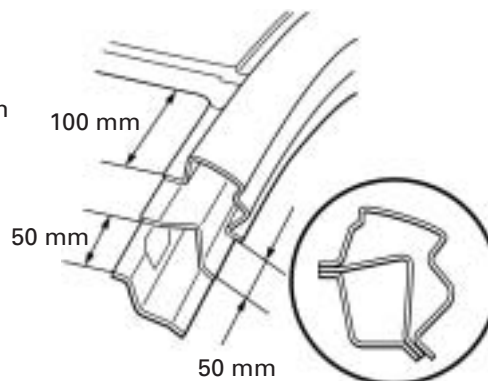


FRONT BODY PILLAR (CUT)

REMOVAL (With the cowl top side panel removed.)

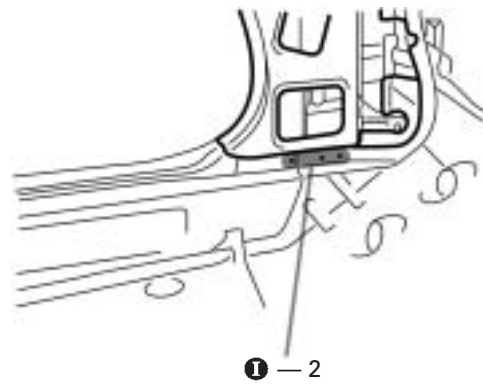
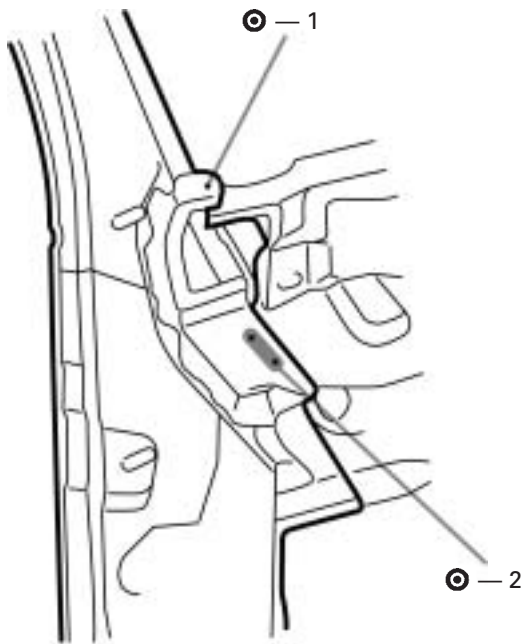


[Cut and Join Location]

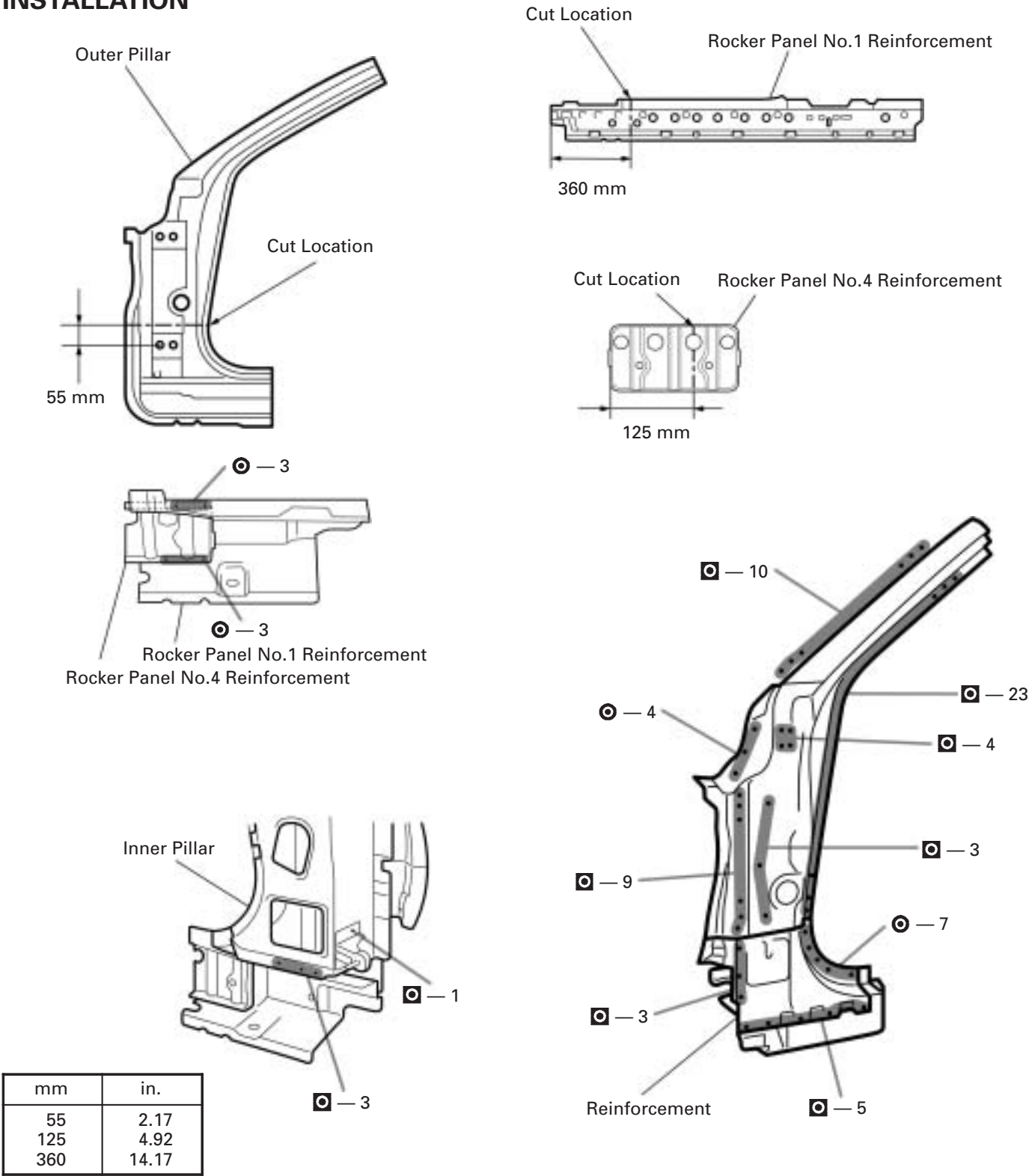


mm	in.
20	0.79
50	1.97
100	3.94

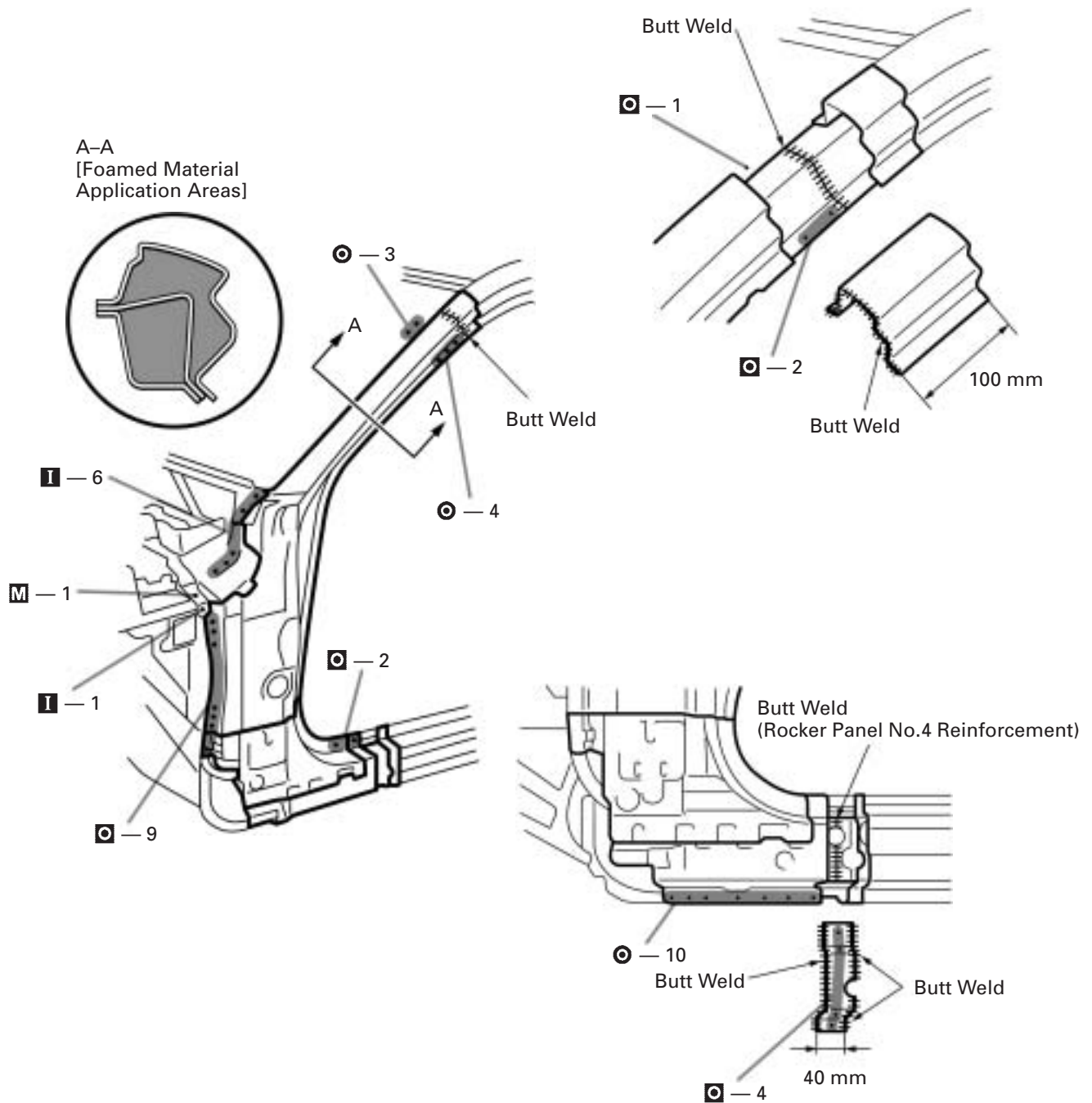
1. Cut and join the parts at the locations as shown above.
2. Shift the each cut and join locations of the outer pillar, reinforcement and inner pillar.
3. Shift the each cut and join locations of the outer pillar, rocker panel No.1 reinforcement and rocker panel No.4 reinforcement.



INSTALLATION

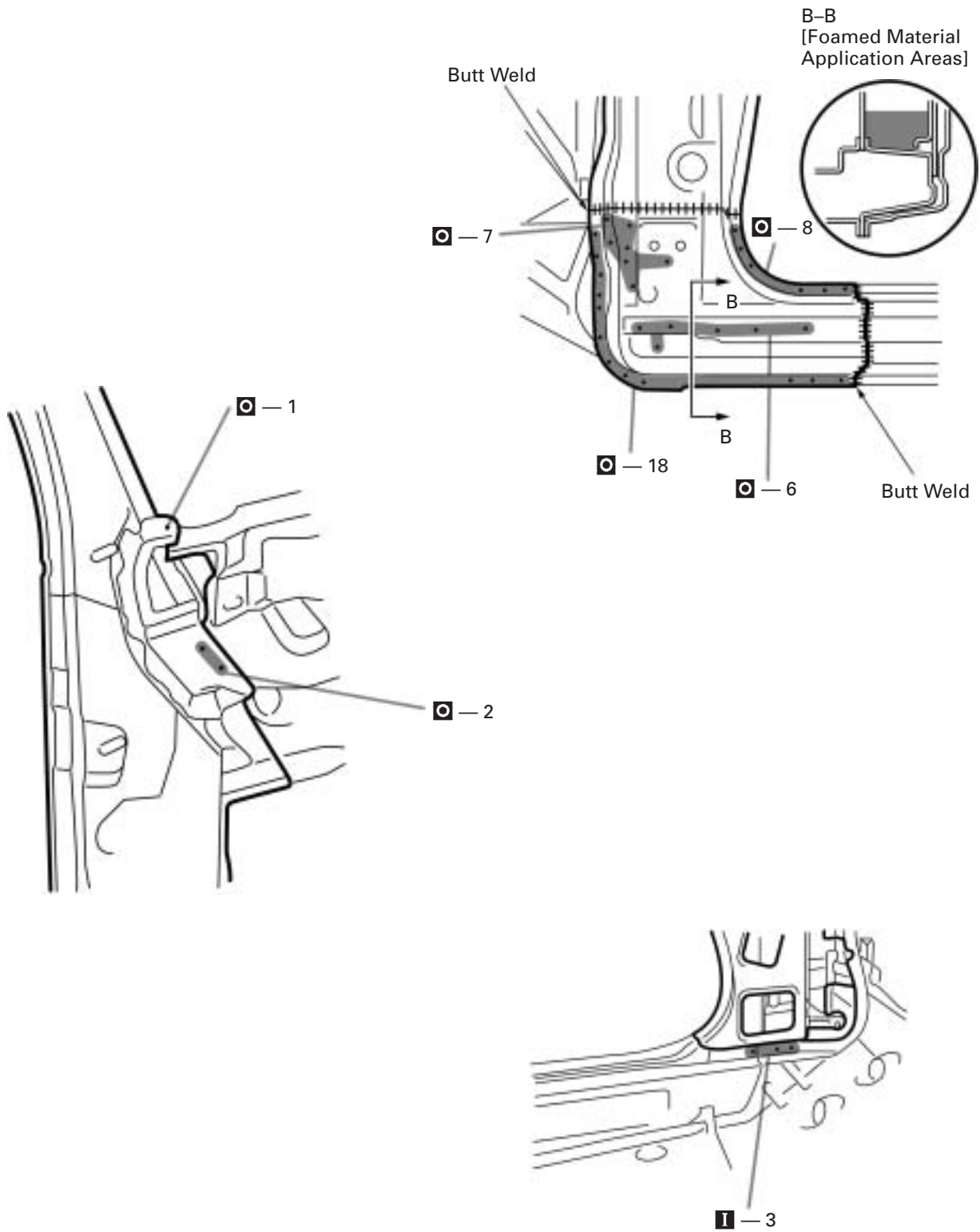


1. Cut the new parts for the outer pillar, rocker panel No.1 reinforcement and rocker panel No.4 reinforcement at the locations shown above.
HINT: After butt welding the rocker panel No. 1 reinforcement attach it to the lower area of the outer pillar.
2. Before temporarily installing the new parts weld the outer pillar, reinforcement, inner pillar, rocker panel No.1 reinforcement and rocker panel No.4 reinforcement with standard points.
3. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.



mm	in.
40	1.57
100	3.94

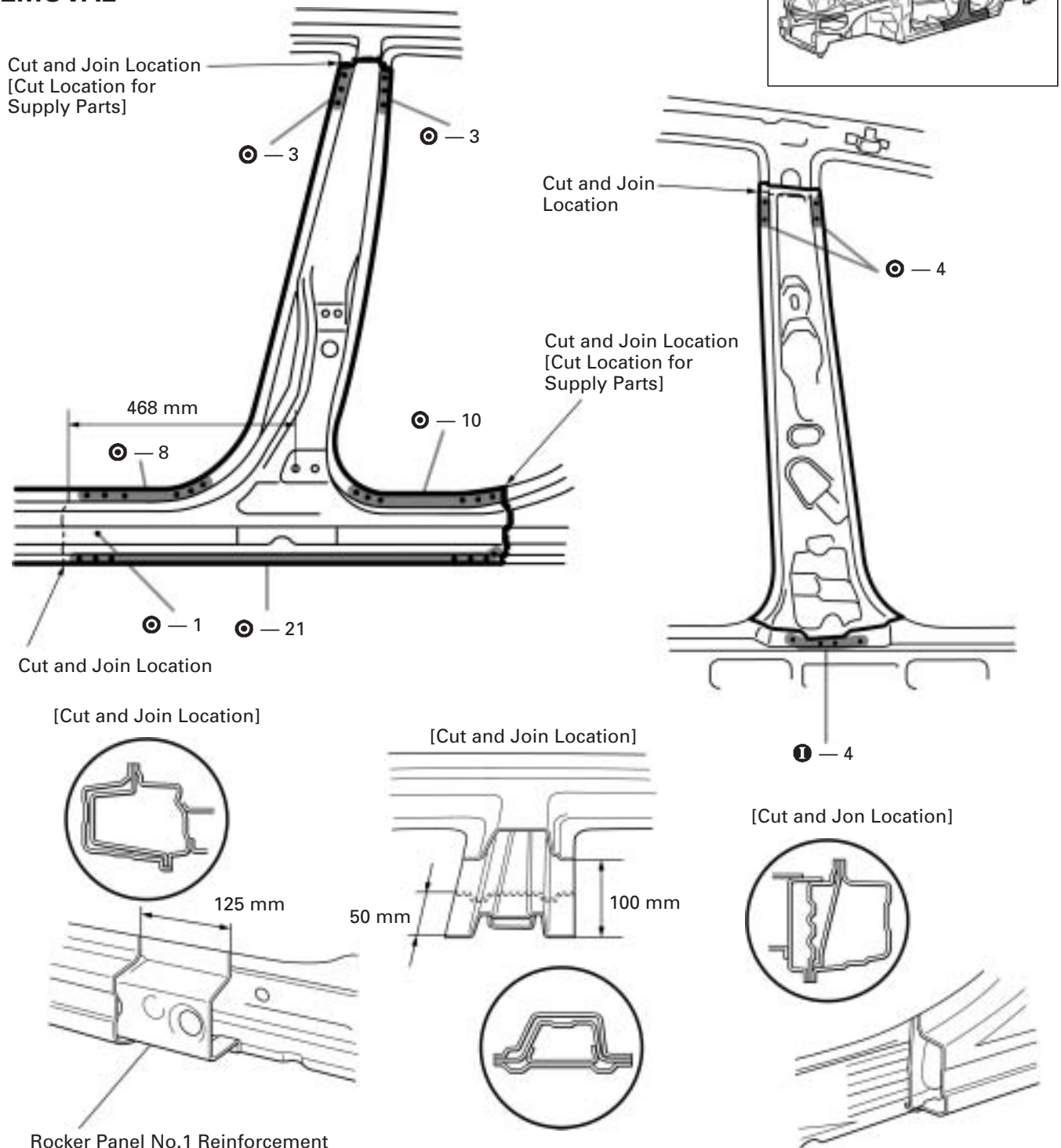
- Before welding the new parts, check the fit of the front door, front fender and windshield glass.
- Cut the upper part of the outer pillar 100 mm (3.94 in.) from its cut and join location and after butt welding the reinforcement, attach the outer pillar.
- Cut the rocker panel No.1 reinforcement 40 mm (1.57 in.) from its previous cut and joining location. Butt weld the rocker panel No.4 reinforcement and butt weld the rocker panel No.1 reinforcement.



7. Apply foamed material to the pillar section.

CENTER BODY PILLAR (CUT)

REMOVAL



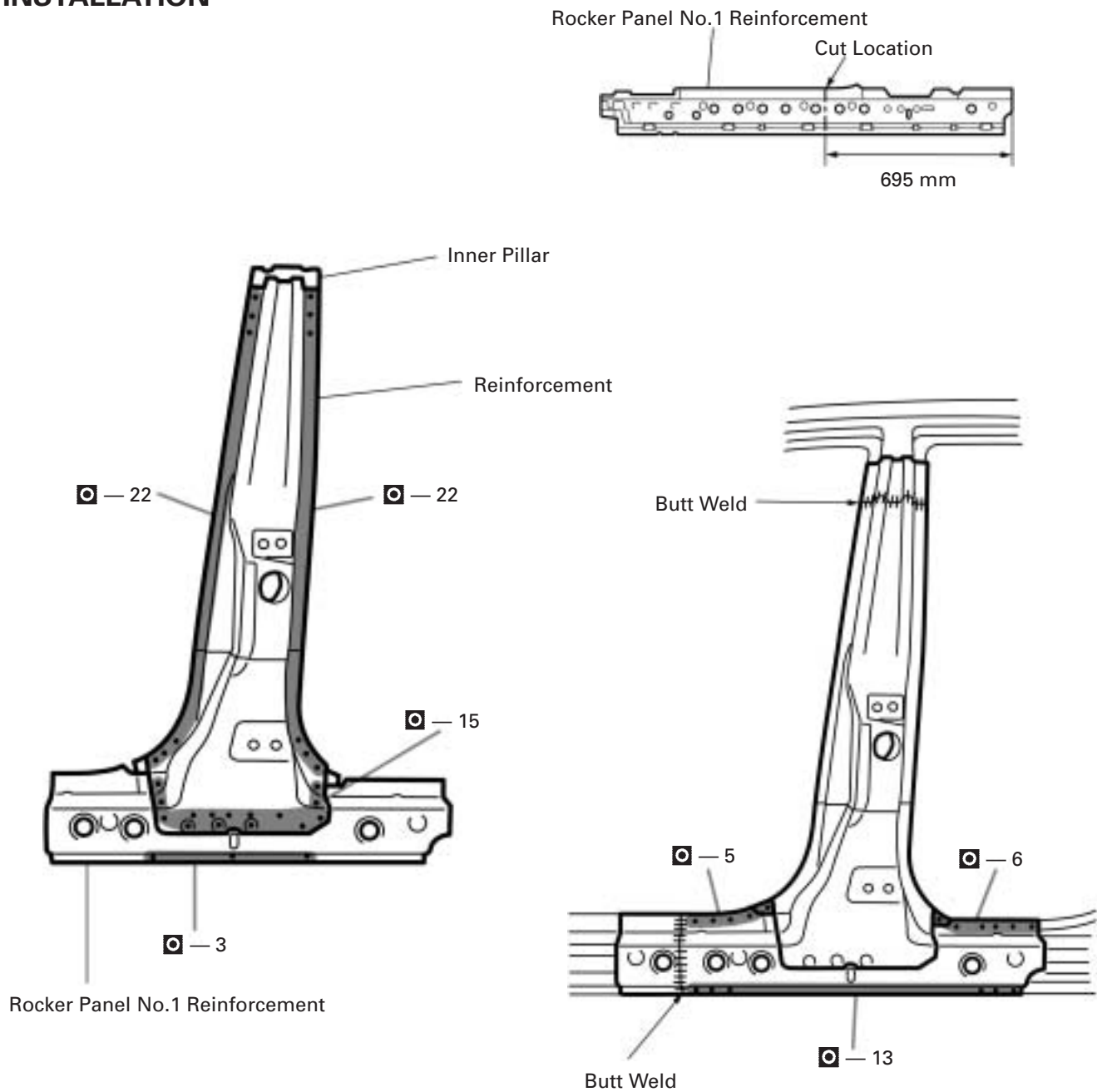
1. Cut and join the parts at the locations as shown above.

HINT:

- 1) Shift the each cut and join locations of the outer pillar, reinforcement and inner pillar.
- 2) Shift the each cut and join locations of the outer pillar and rocker panel No.1 reinforcement.

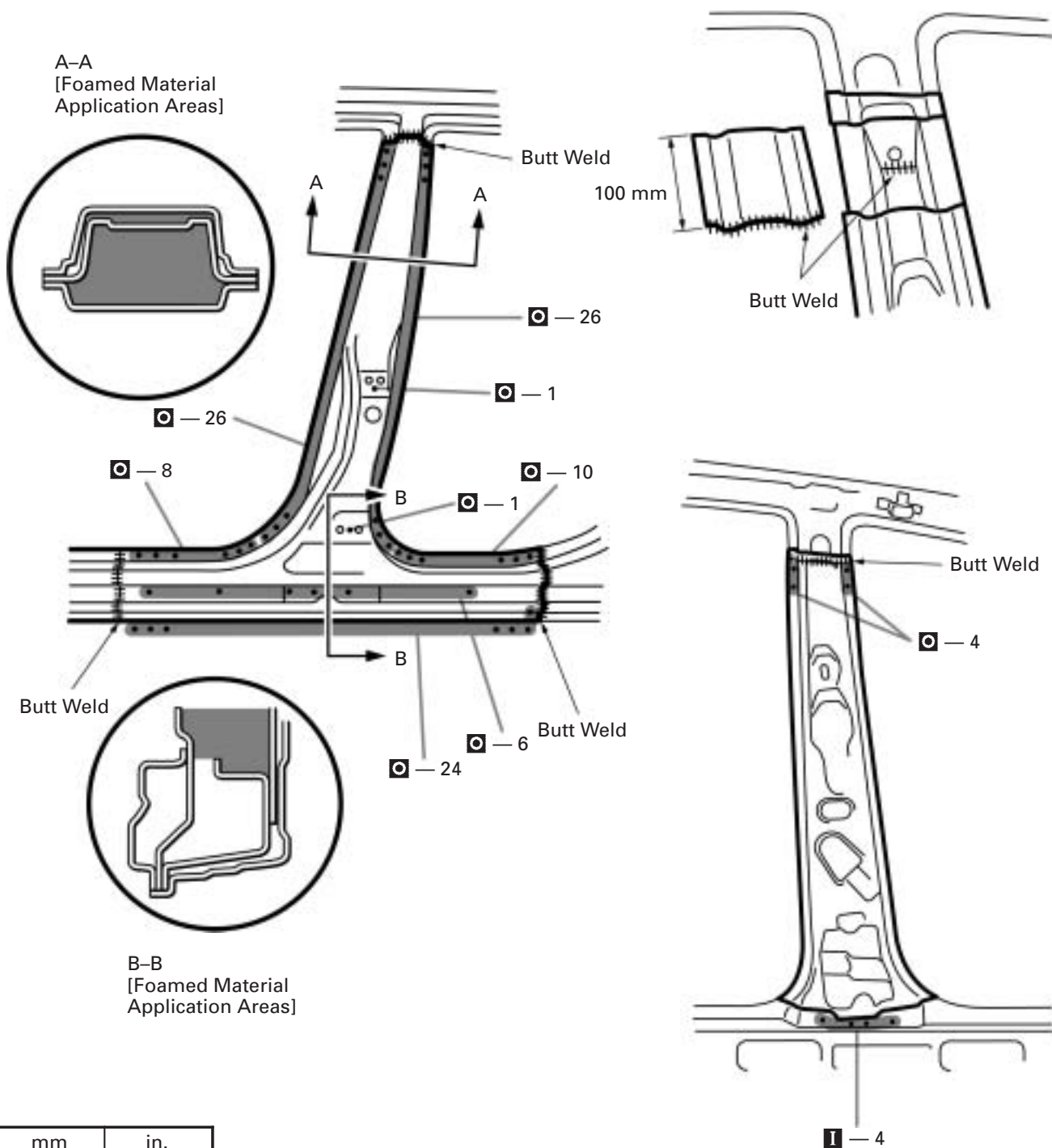
mm	in.
50	1.97
100	3.94
125	4.92
468	18.43

INSTALLATION

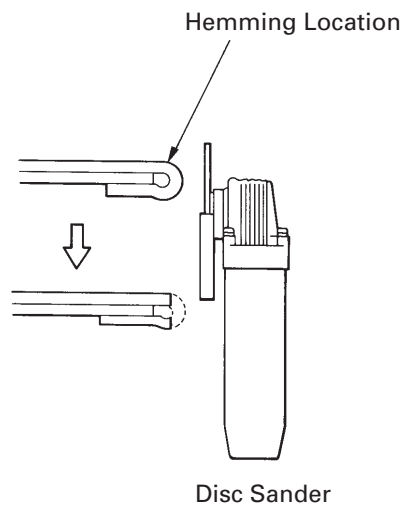
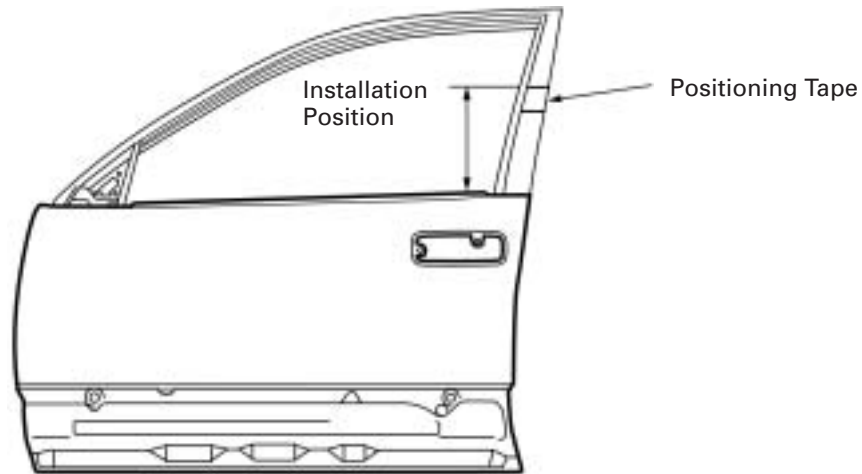
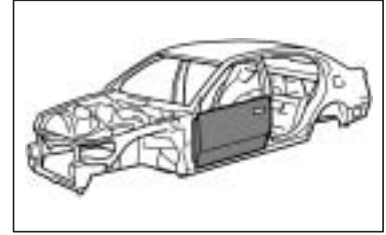


mm	in.
695	27.36

1. Cut the new parts for the rocker panel No.1 reinforcement at the locations shown above.
2. Before temporarily installing the new parts, weld the inner pillar, reinforcement and rocker panel No.1 reinforcement with standard points.
3. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.
4. Before welding the new parts, check the fit of the front door and rear door.

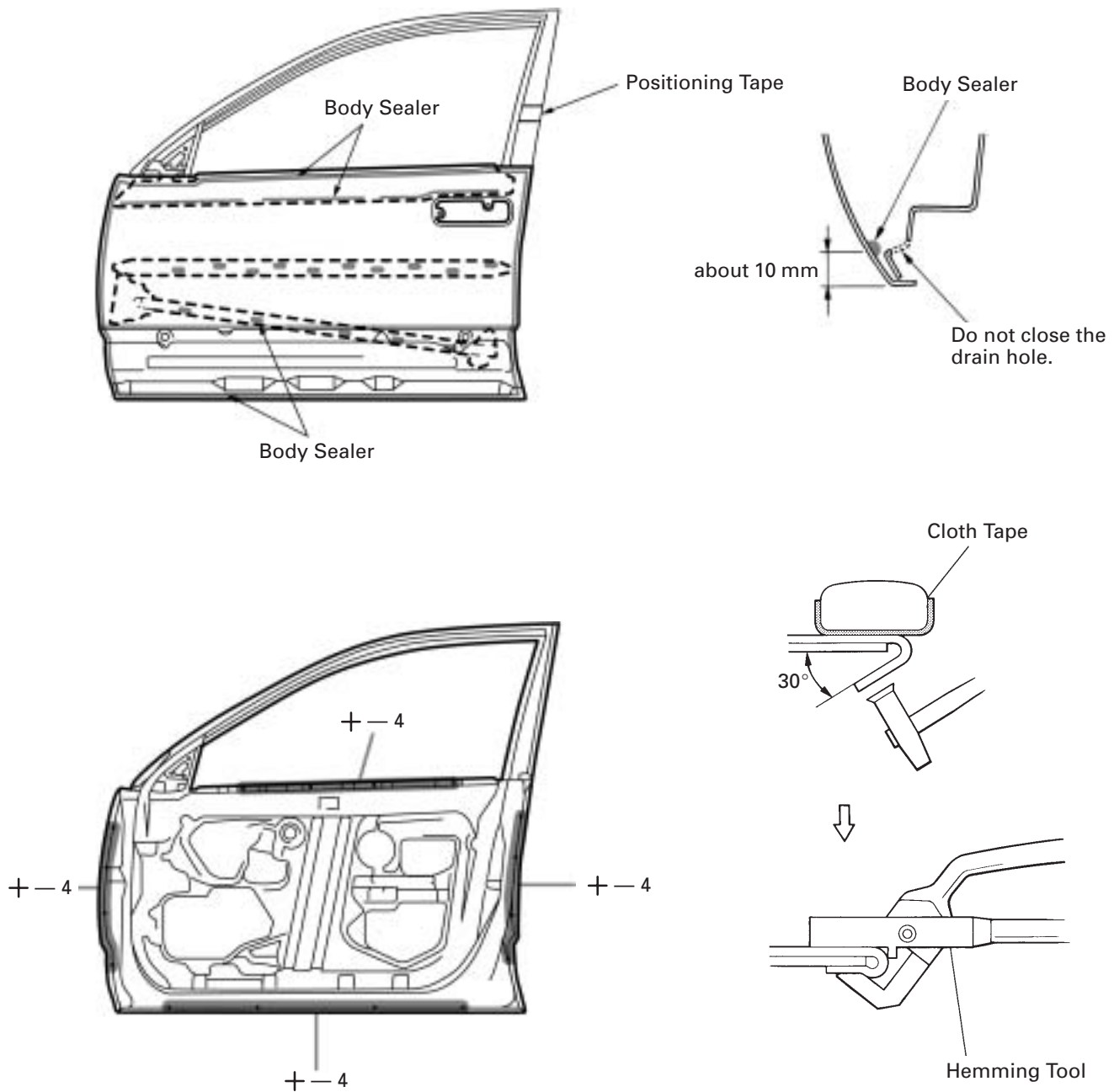


5. After welding the inner pillar, reinforcement and rocker panel No.1 reinforcement to the vehicle install the outer pillar.
6. Cut the upper part of the outer pillar 100 mm (3.94 in.) from its cut and join location and after butt welding the reinforcement, attach the outer pillar.
7. Apply foamed material to the pillar section.

FRONT DOOR OUTER PANEL (ASSY)**REMOVAL**

1. Before removing the outer panel, make the installation position with a tape.
2. After grinding off the hemming location, remove the outer panel.

INSTALLATION



mm	in.
10	0.39

1. Before temporarily installing the new parts, apply body sealer to the reinforcement, side impact protection beam and back side of the new parts.

HINT:

- 1) Apply just enough sealer for the reinforcement and side impact beam to touch the new panel. Apply sealer evenly around the flange area, about 10 mm (0.39 in.) from the edge, as shown.
- 2) For other sealing points, refer to section AR.

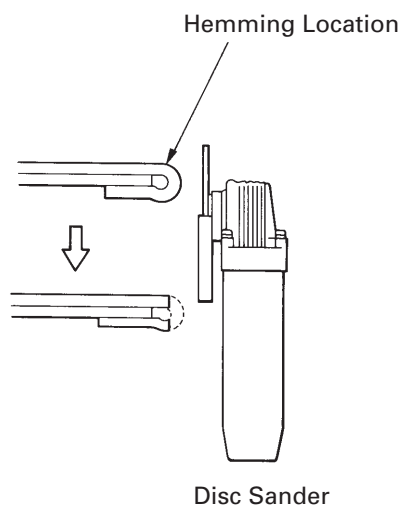
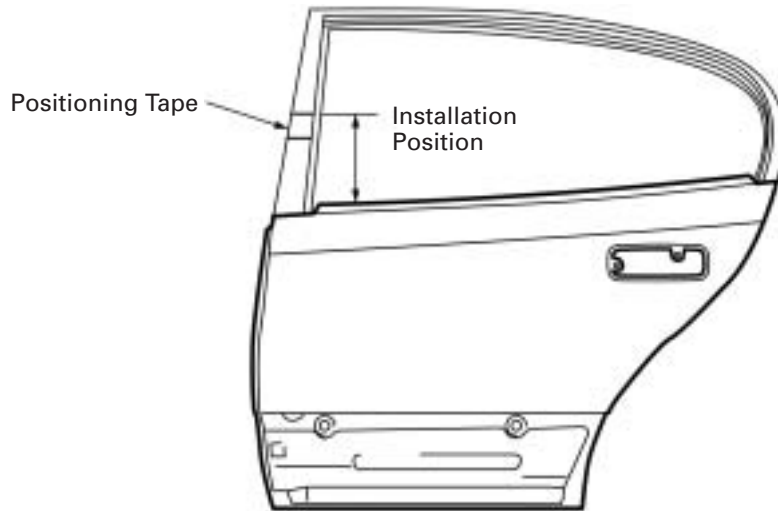
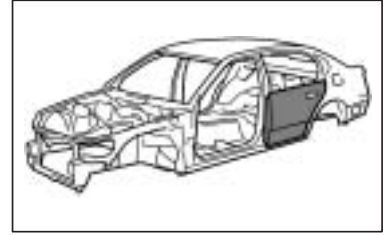
2. Bend the flange hem about 30° with a hammer and dolly, then fasten tightly with a hemming tool.

HINT:

- 1) Perform hemming in three steps, being careful not to warp the panel.
- 2) If a hemming tool cannot be used, hem with a hammer and dolly.

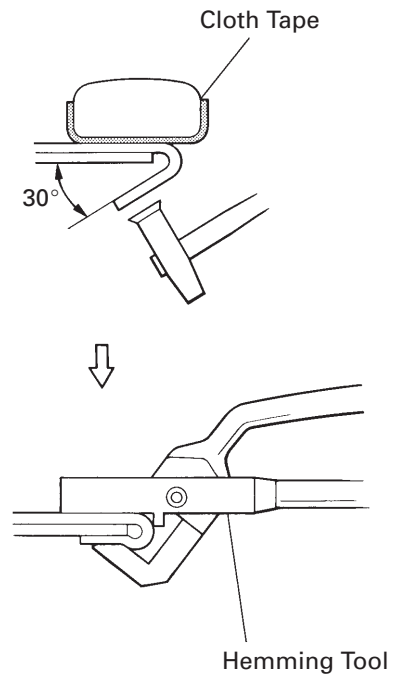
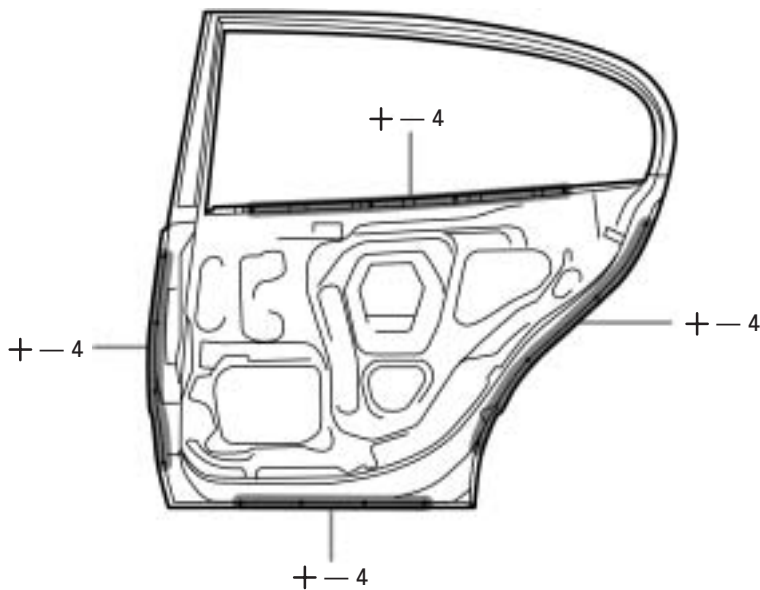
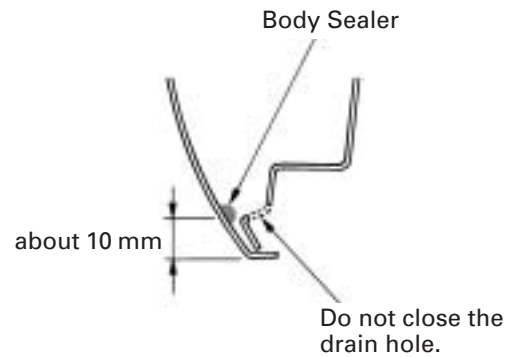
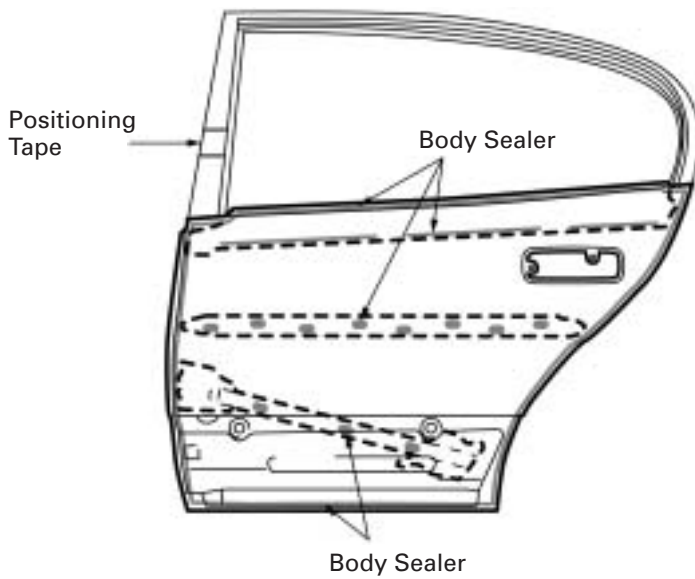
REAR DOOR OUTER PANEL (ASSY)

REMOVAL



1. Before removing the outer panel, make the installation position with a tape.
2. After grinding off the hemming location, remove the outer panel.

INSTALLATION



mm	in.
10	0.39

1. Before temporarily installing the new parts, apply body sealer to the reinforcement, side impact protection beam and back side of the new parts.

HINT:

- 1) Apply just enough sealer for the reinforcement and side impact beam to touch the new panel. Apply sealer evenly around the flange area, about 10 mm (0.39 in.) from the edge, as shown.
- 2) For other sealing points, refer to section AR.

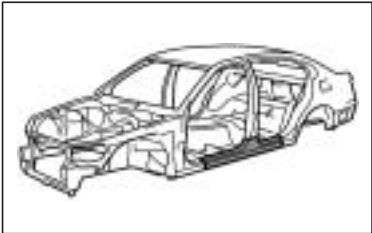
2. Bend the flange hem about 30° with a hammer and dolly, then fasten tightly with a hemming tool.

HINT:

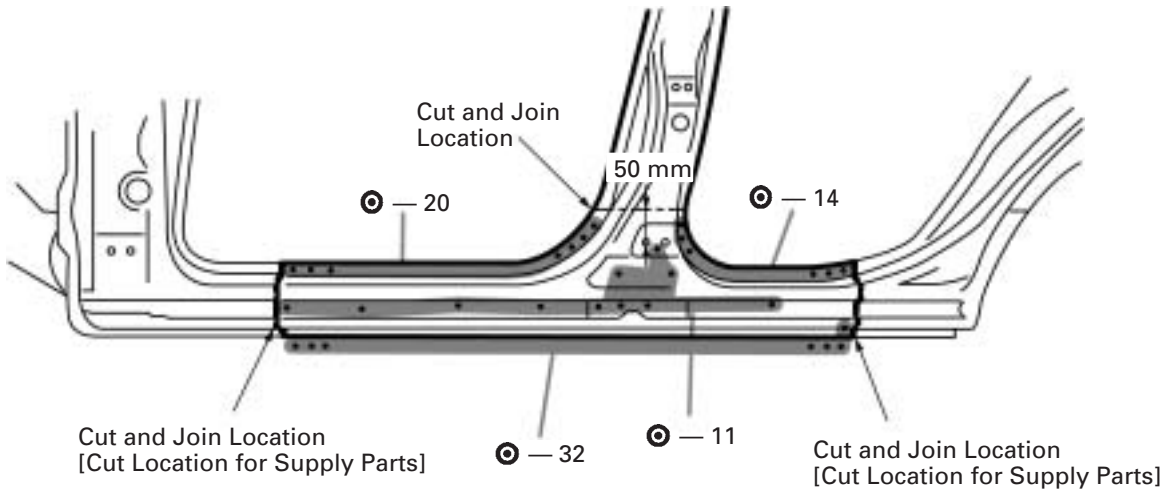
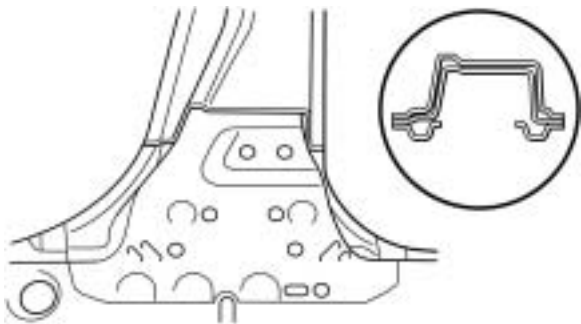
- 1) Perform hemming in three steps, being careful not to warp the panel.
- 2) If a hemming tool cannot be used, hem with a hammer and dolly.

ROCKER OUTER PANEL (CUT)

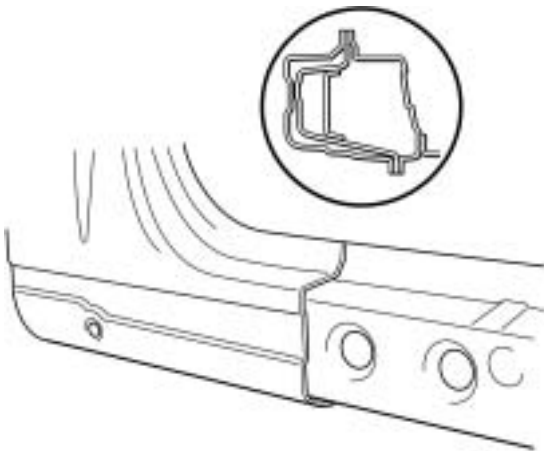
REMOVAL



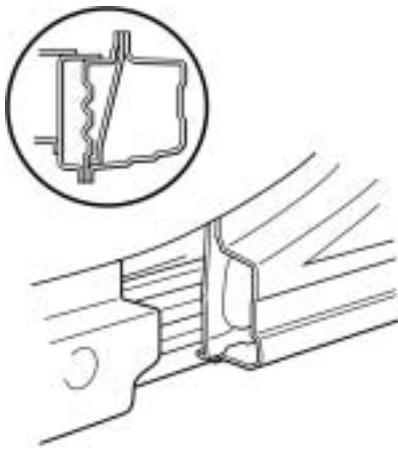
[Cut and Join Location]



[Cut and Join Location]



[Cut and Join Location]

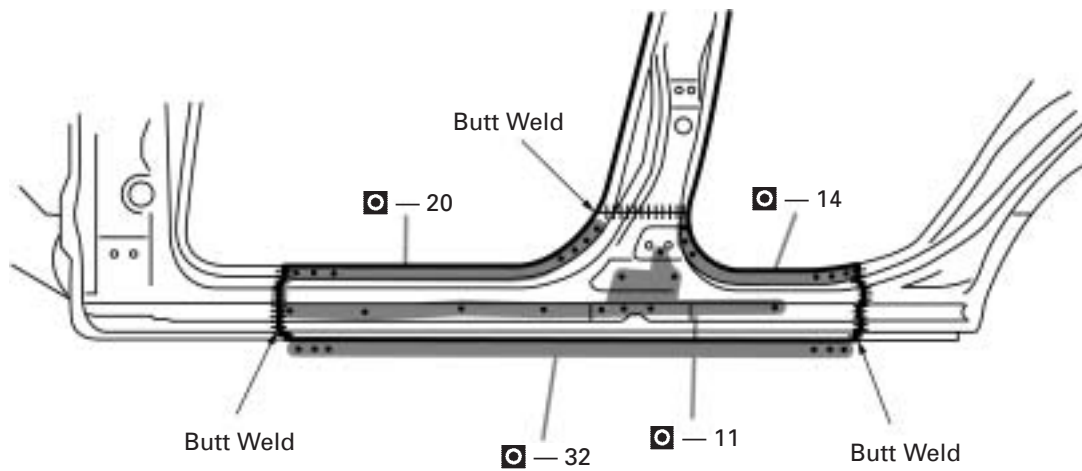


1. Cut and join the parts at the locations as shown above.

HINT: Take care not to damage the internal reinforcement of the center body pillar and rocker panel.

mm	in.
50	1.97

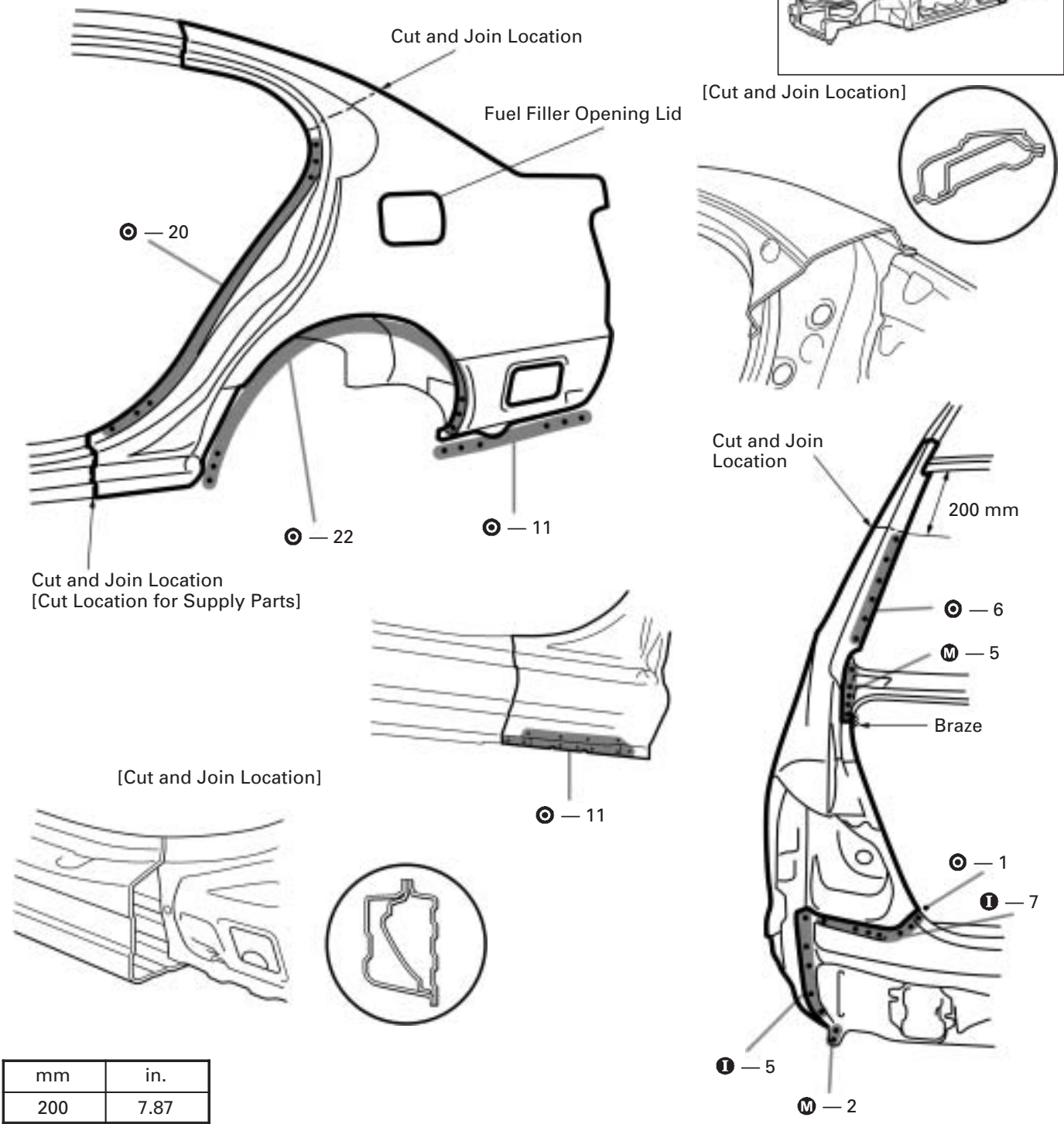
INSTALLATION



1. Temporarily install the new parts and check the fit of the front door and rear door.

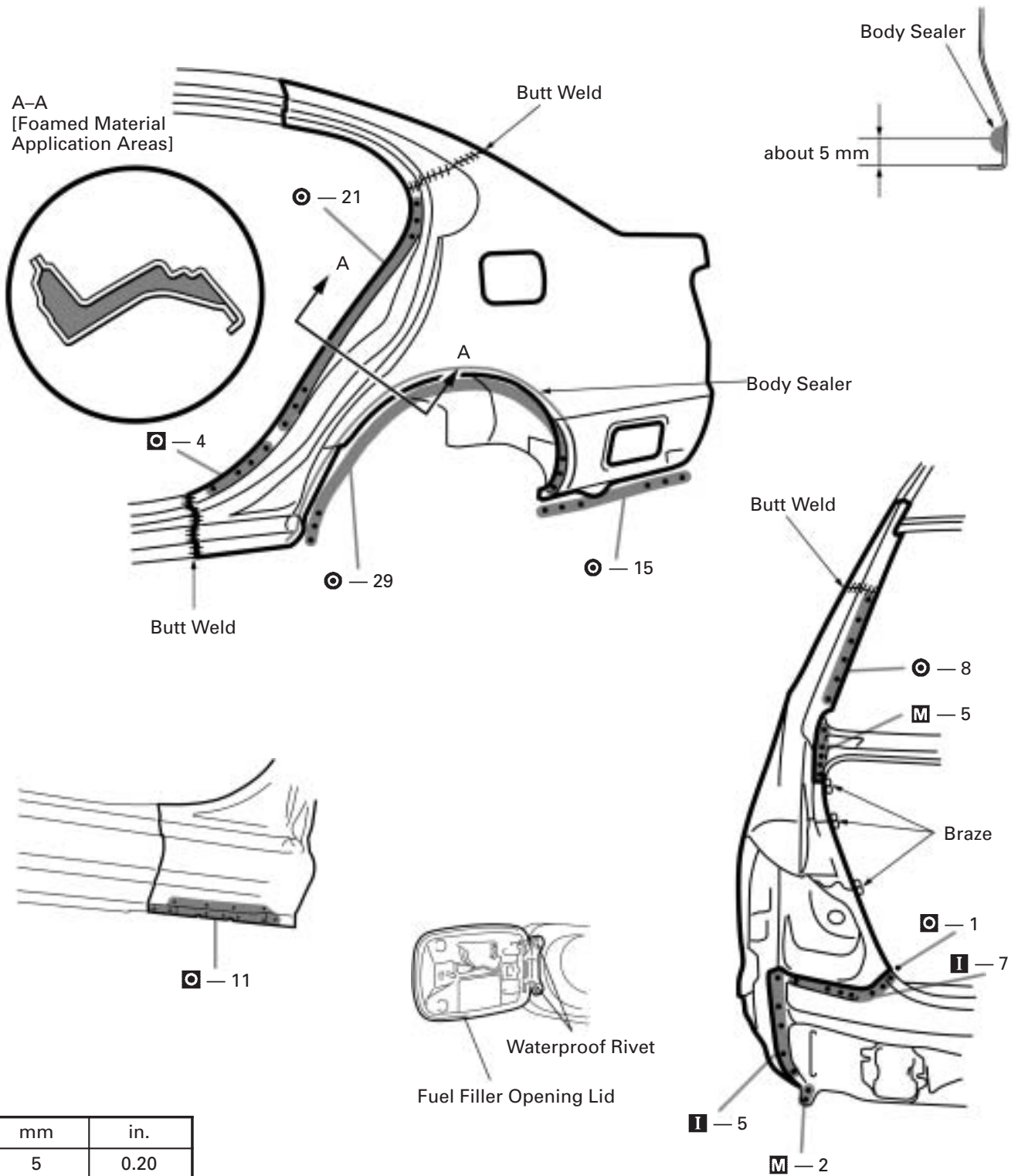
QUARTER PANEL (CUT)

REMOVAL



1. Cut and join the parts at the locations as shown above.
2. Replace the fuel filler opening lid at the same time as the quarter panel.

INSTALLATION



mm	in.
5	0.20

- Before temporarily installing the new parts, apply body sealer to the wheel arch.

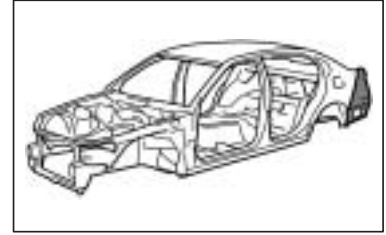
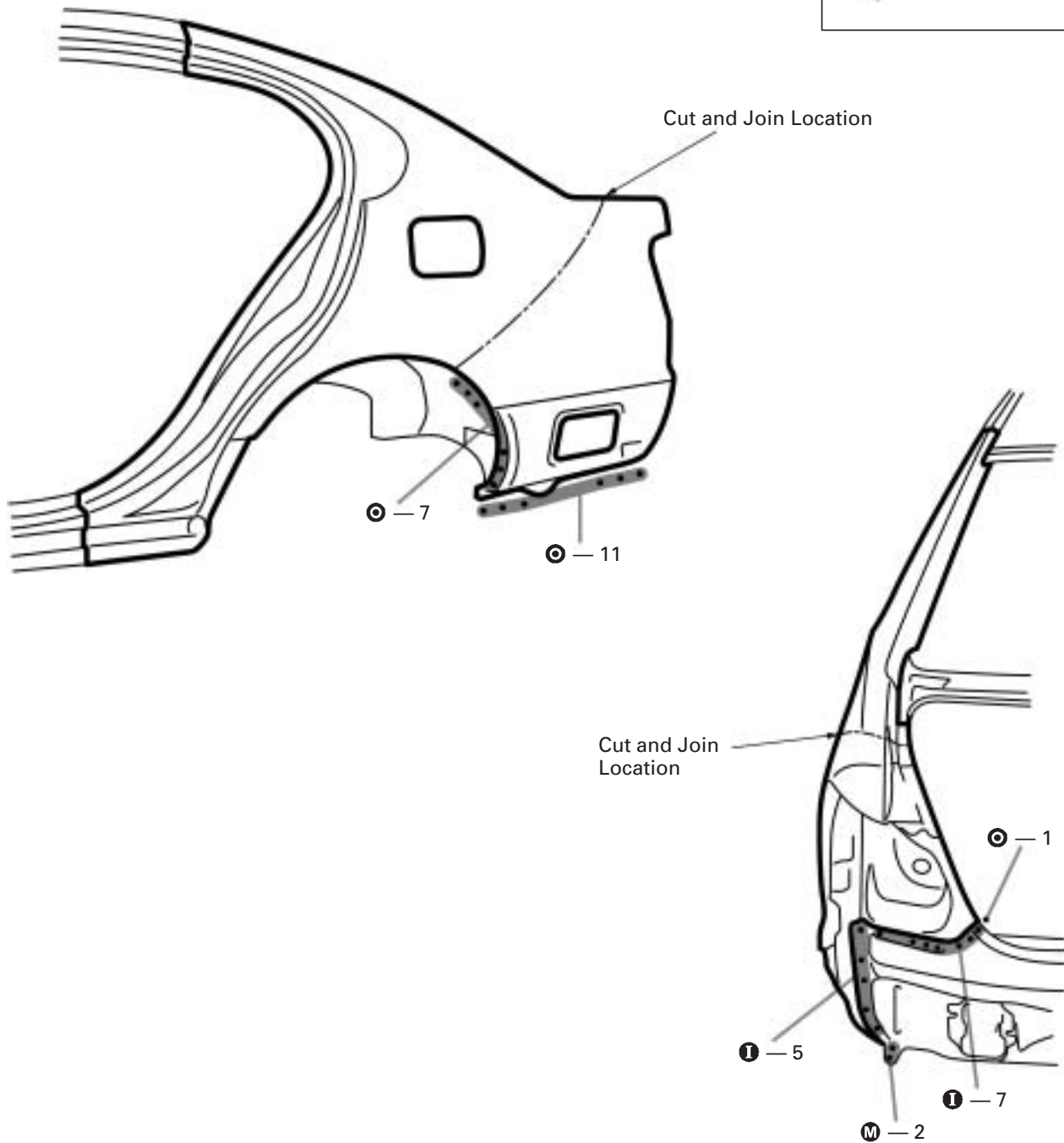
HINT:

- 1) Apply body sealer about 5 mm (0.20 in.) from the flange, avoiding any oozing.
 - 2) Apply sealer evenly, about 3 – 4 mm (0.12 – 0.16 in.) in diameter.
 - 3) For other sealing points, refer to section AR.
2. Temporarily install the new parts and check the fit of the rear door, luggage compartment door and rear combination light.

3. Apply foamed material to the pillar section.
4. Attach the fuel filler opening lid by rivets to the quarter panel.

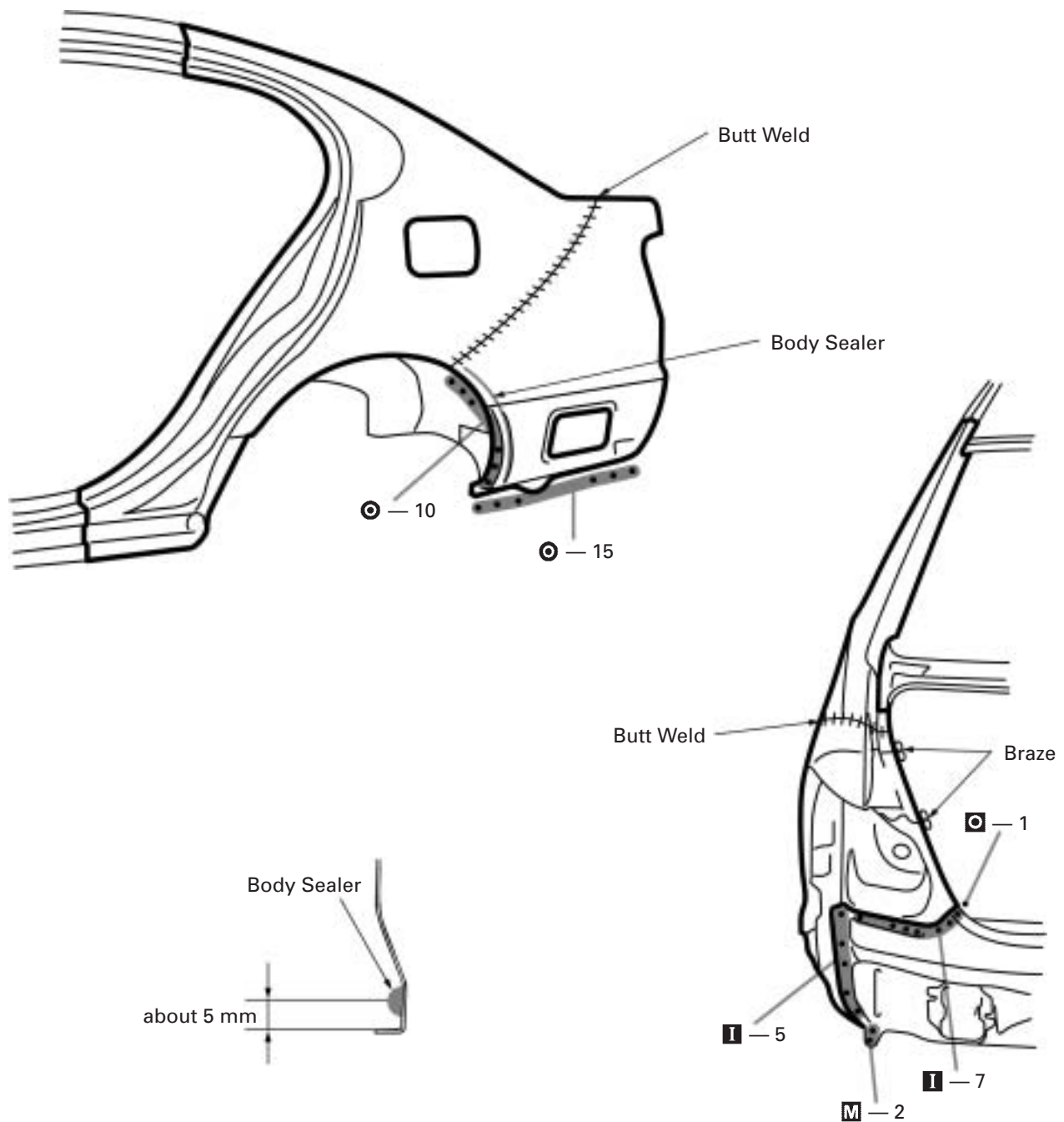
HINT:

- 1) Use waterproof rivets.
- 2) Refer to the introduction when installation rivets.

QUARTER PANEL (CUT-P)**REMOVAL**

1. Cut and join the part at the location as shown above.

INSTALLATION



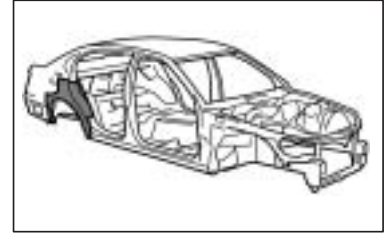
mm	in.
5	0.20

1. Before temporarily installing the new parts, apply body sealer to the wheel arch.
2. Temporarily install the new parts and check the fit of the luggage compartment door and rear combination light.

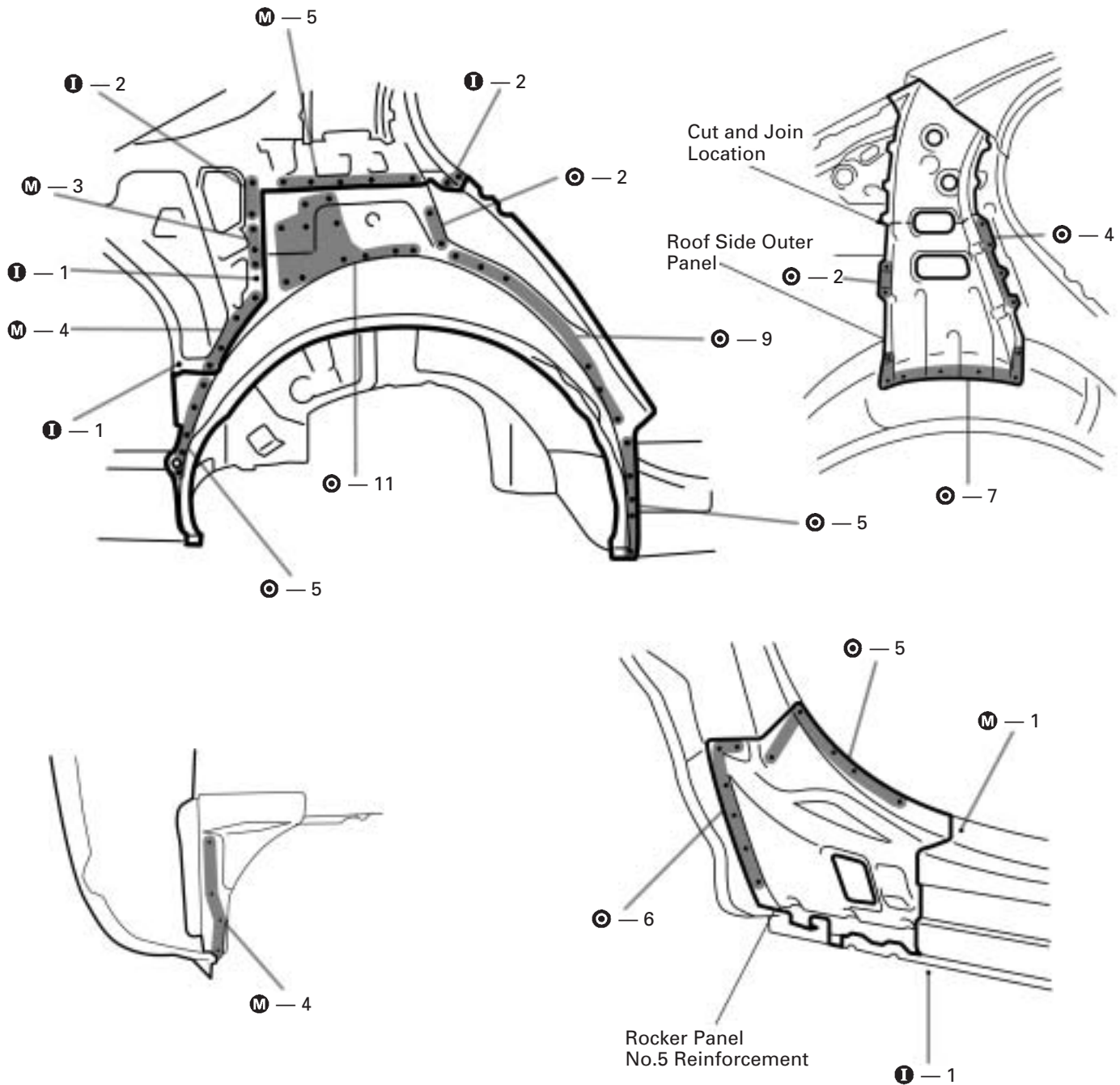
HINT:

- 1) Apply body sealer about 5 mm (0.20 in.) from the flange, avoiding any oozing.
- 2) Apply sealer evenly, about 3 – 4 mm (0.12 – 0.16 in.) in diameter.
- 3) For other sealing points, refer to section AR.

QUARTER WHEEL HOUSING OUTER PANEL (ASSY): Right Side

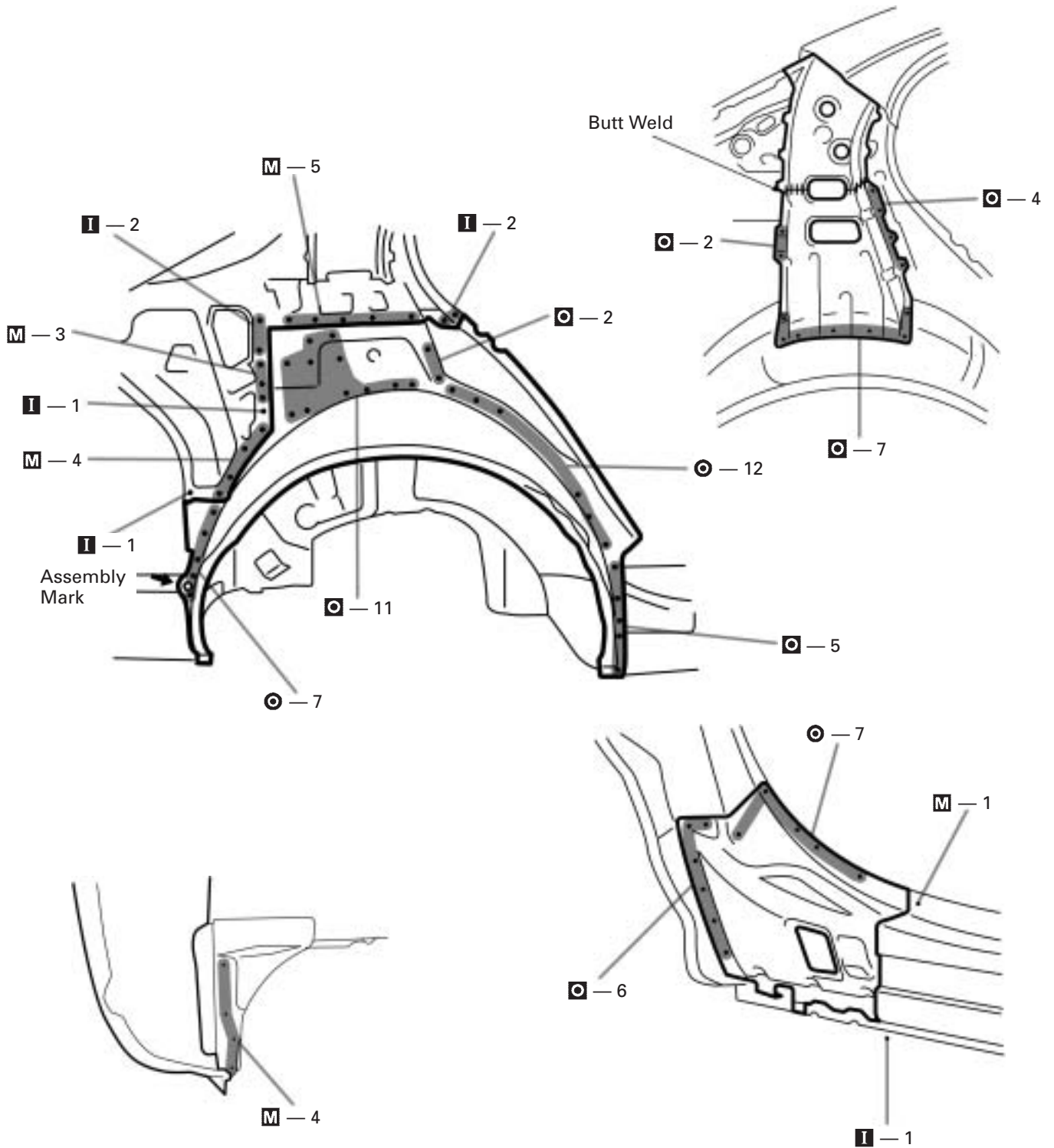


REMOVAL (With the quarter panel removed.)



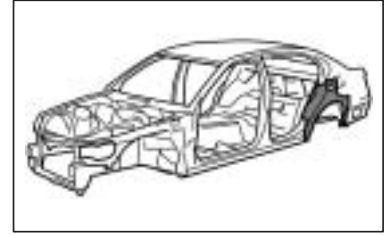
1. Cut the roof side outer panel at the location shown above.
2. After removing the rocker panel No.5 reinforcement remove the quarter wheel housing outer panel.

INSTALLATION

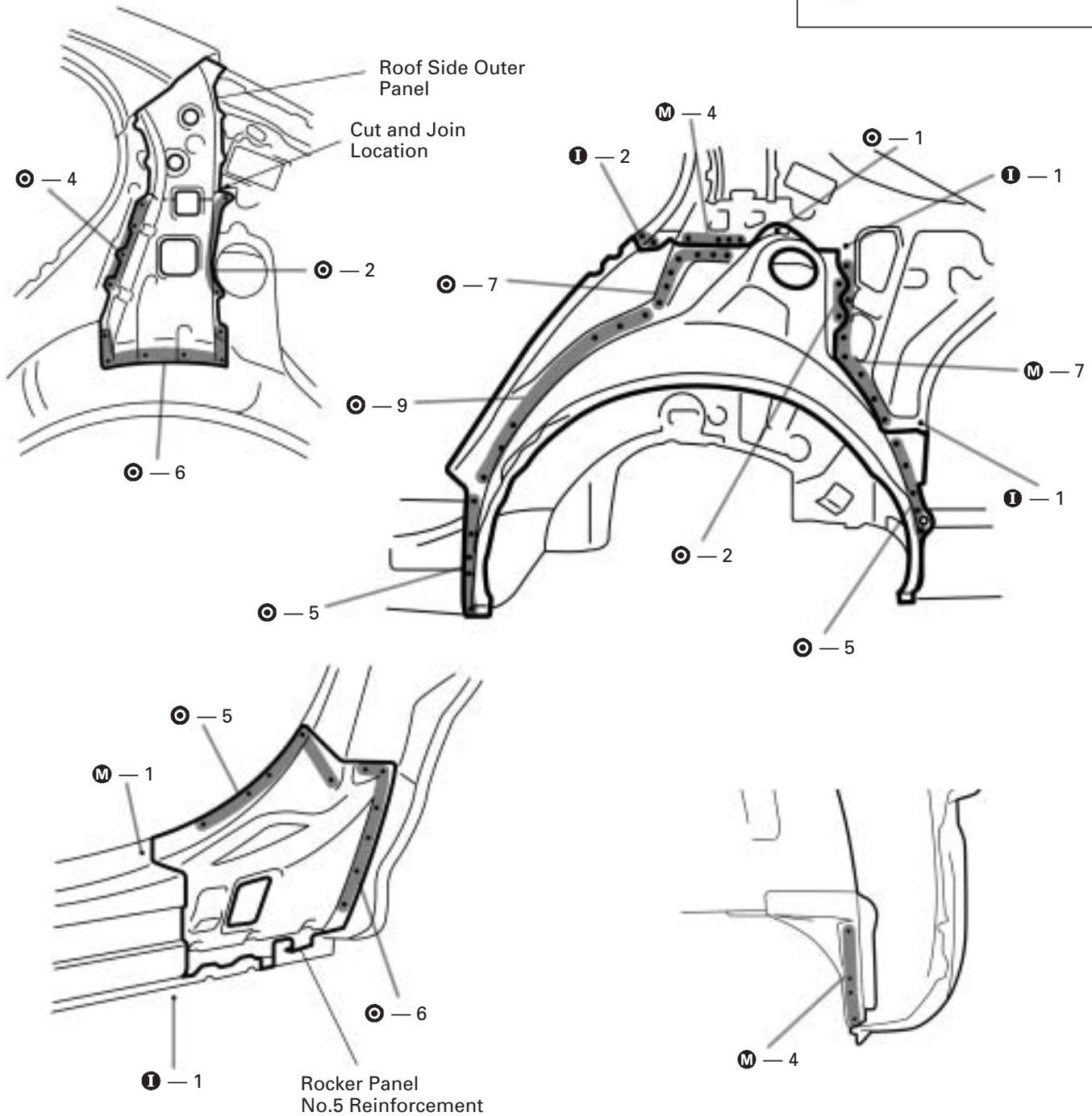


1. Determine the position of the new parts by the assembly marks of the inner and outer panels.
2. Before welding the new parts, temporarily install the quarter panel and check the fit.

QUARTER WHEEL HOUSING OUTER PANEL (ASSY): Left Side

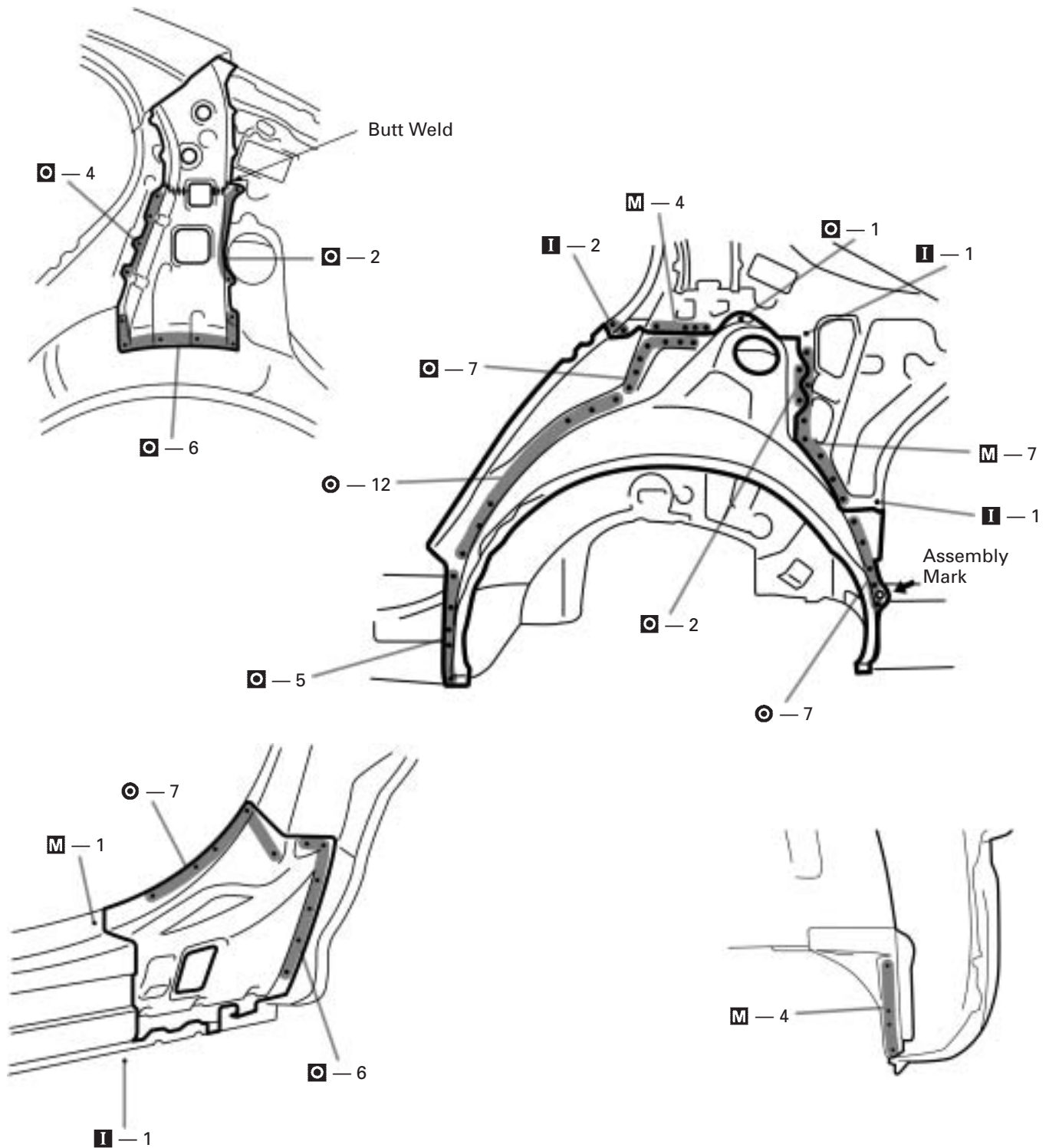


REMOVAL (With the quarter panel removed.)

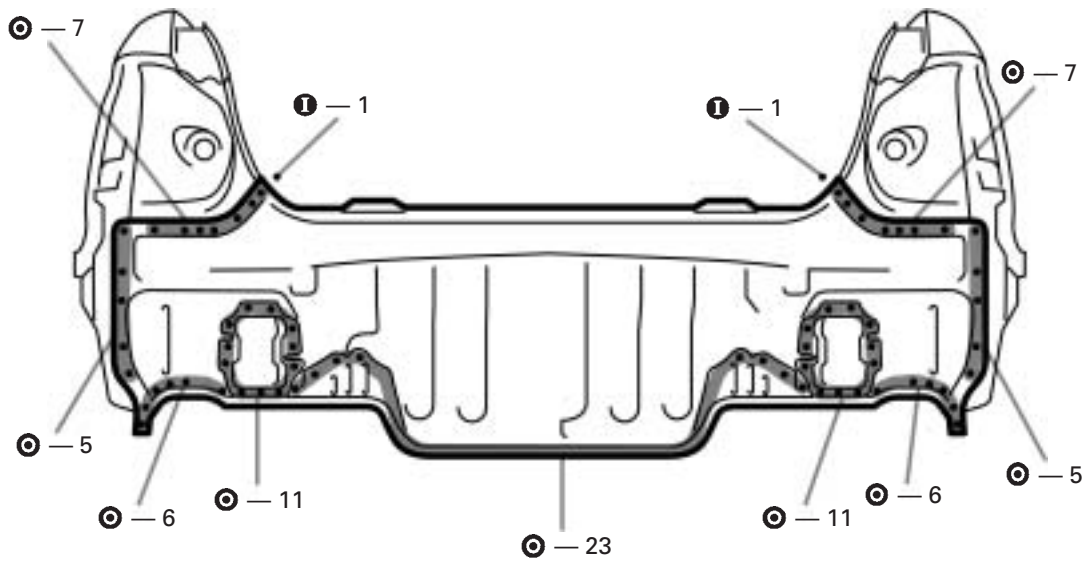
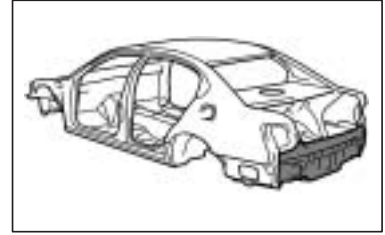


1. Cut the roof side outer panel at the location shown above.
2. After removing the rocker panel No.5 reinforcement, remove the quarter wheel housing outer panel.

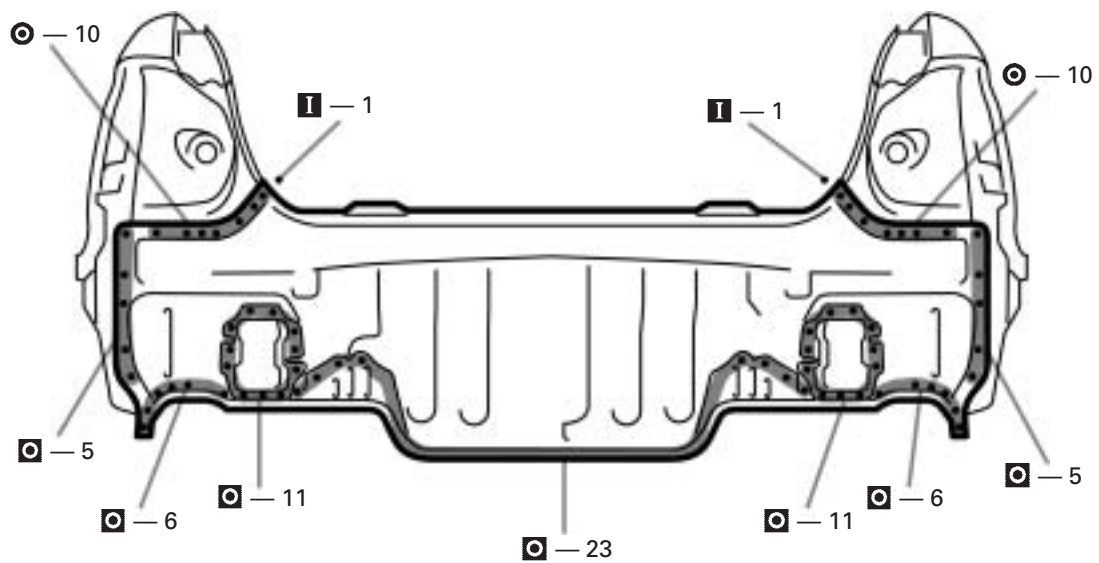
INSTALLATION



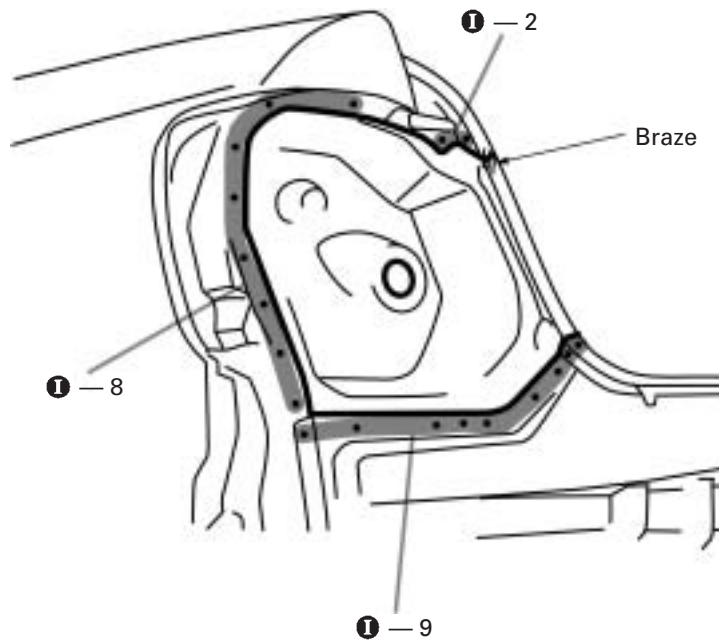
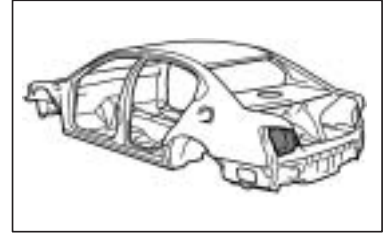
1. Determine the position of the new parts by the assembly marks of the inner and outer panels.
2. Before welding the new parts, temporarily install the quarter panel and check the fit.

BODY LOWER BACK PANEL (ASSY)**REMOVAL**

INSTALLATION

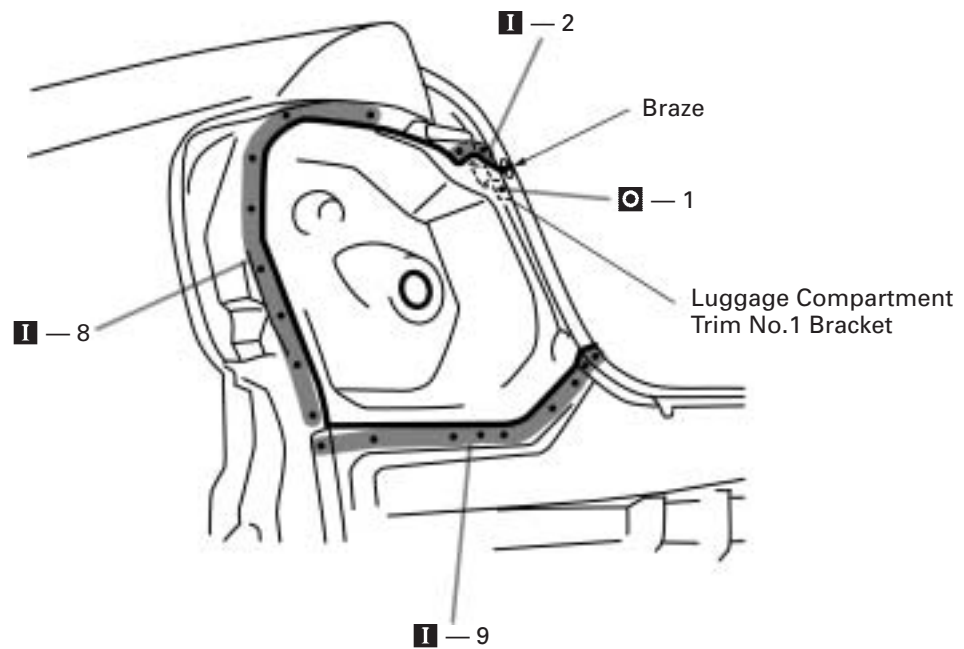


1. Temporarily install the new parts, and check the fit of the luggage compartment door and rear combination light.

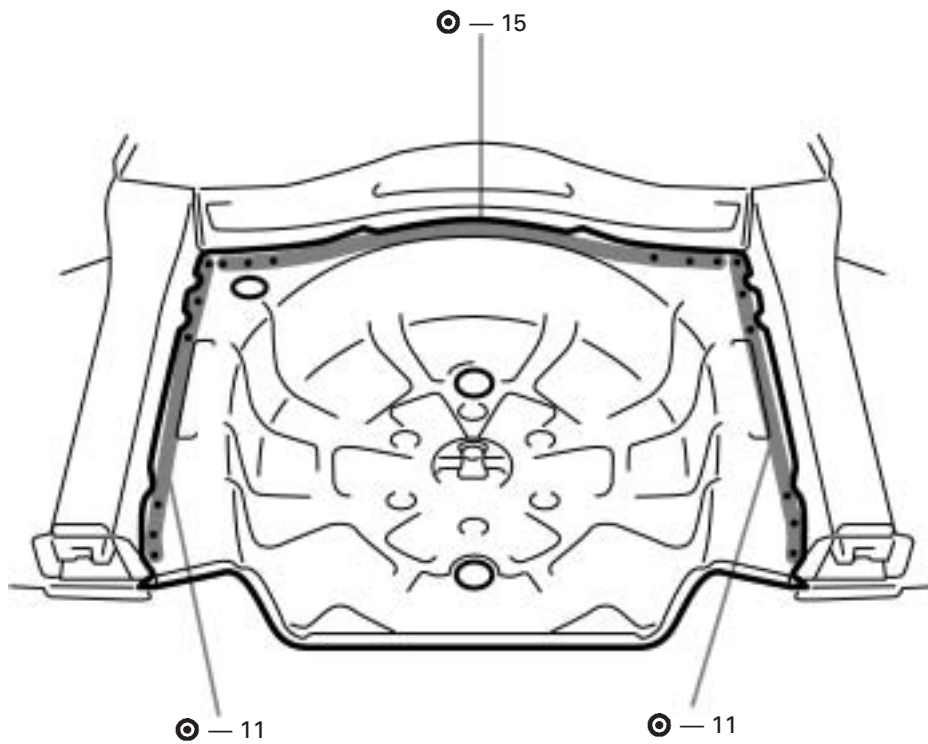
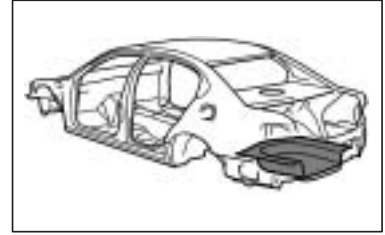
QUARTER PANEL OUTER EXTENSION (ASSY)**REMOVAL**

1. Replace the luggage compartment trim No.1 bracket at same time.

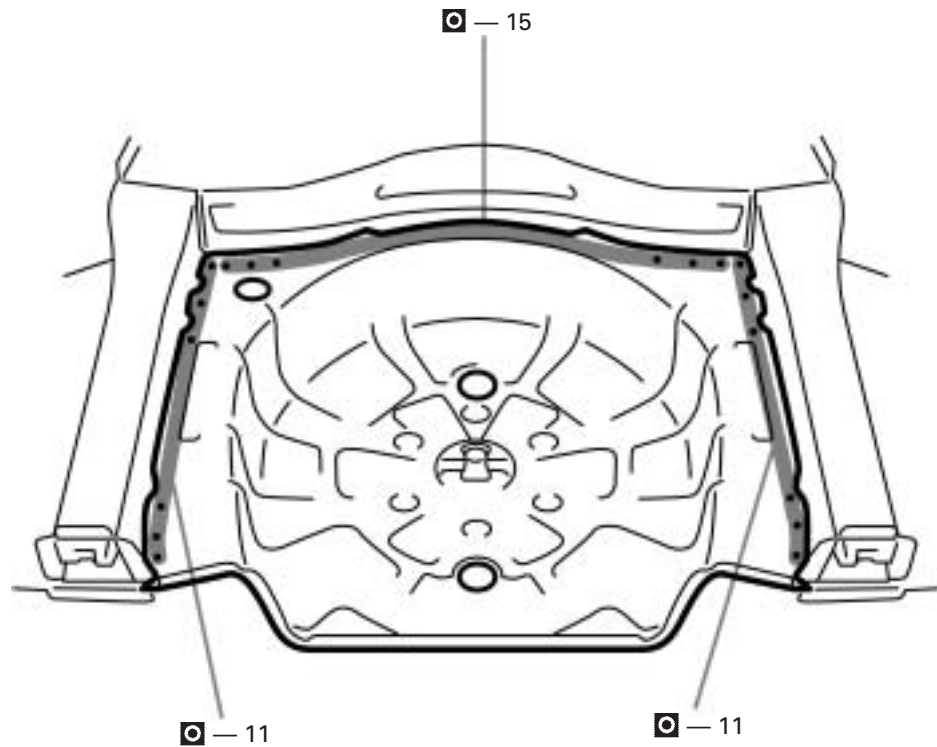
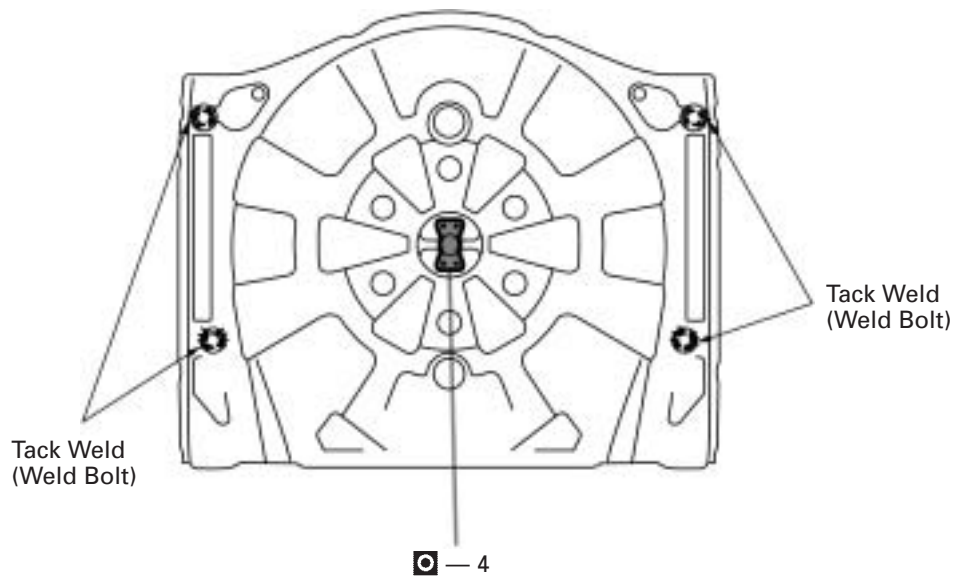
INSTALLATION



1. Temporarily install the new parts and check the fit of the rear combination light.

REAR FLOOR PAN (ASSY)**REMOVAL (With the body lower back panel removed.)**

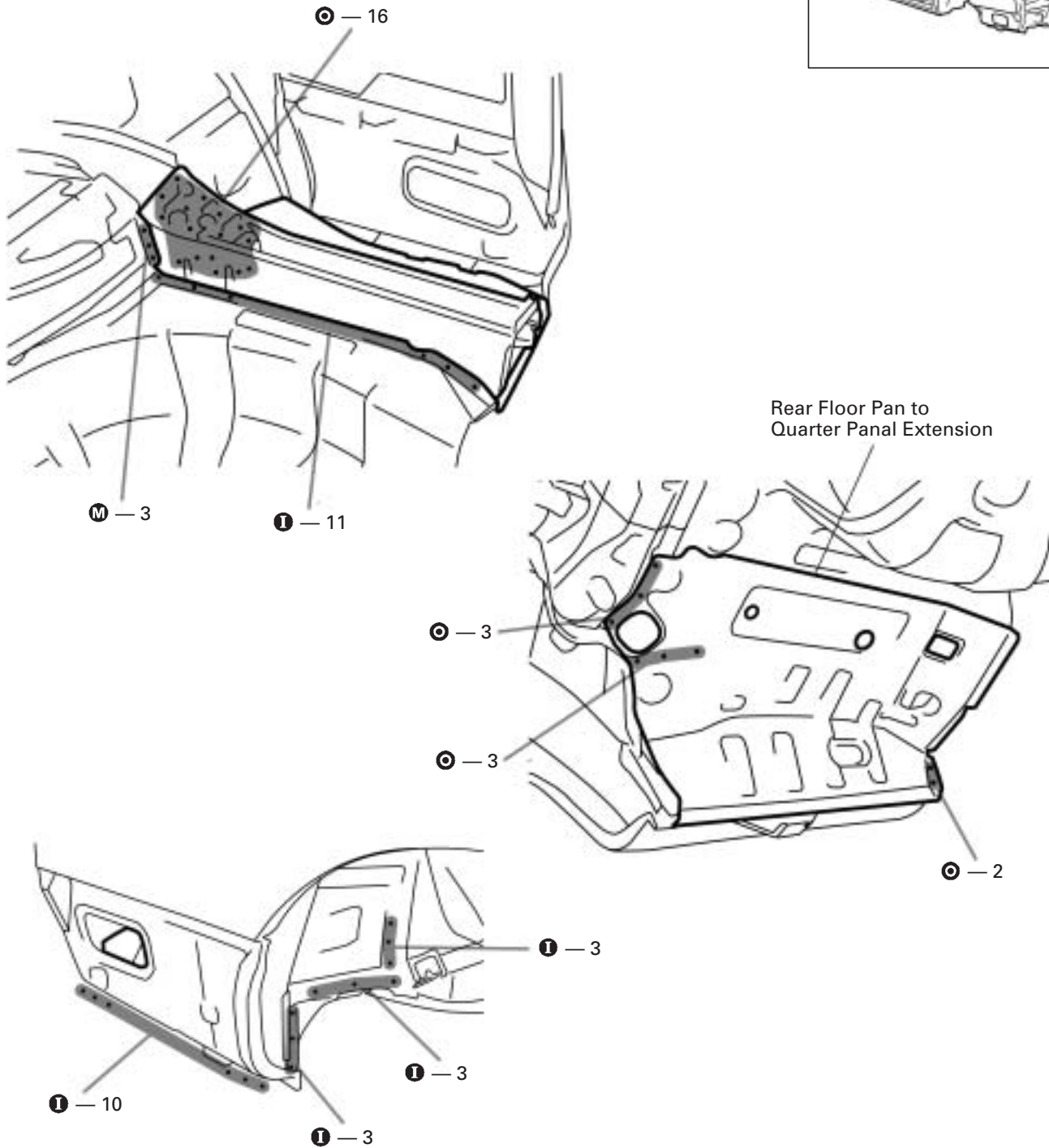
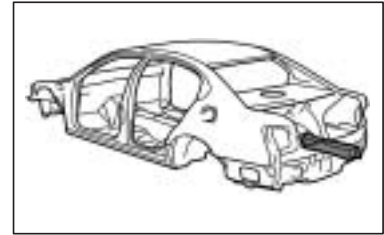
INSTALLATION



1. Attach the weld bolt to the center of the bearing surface.

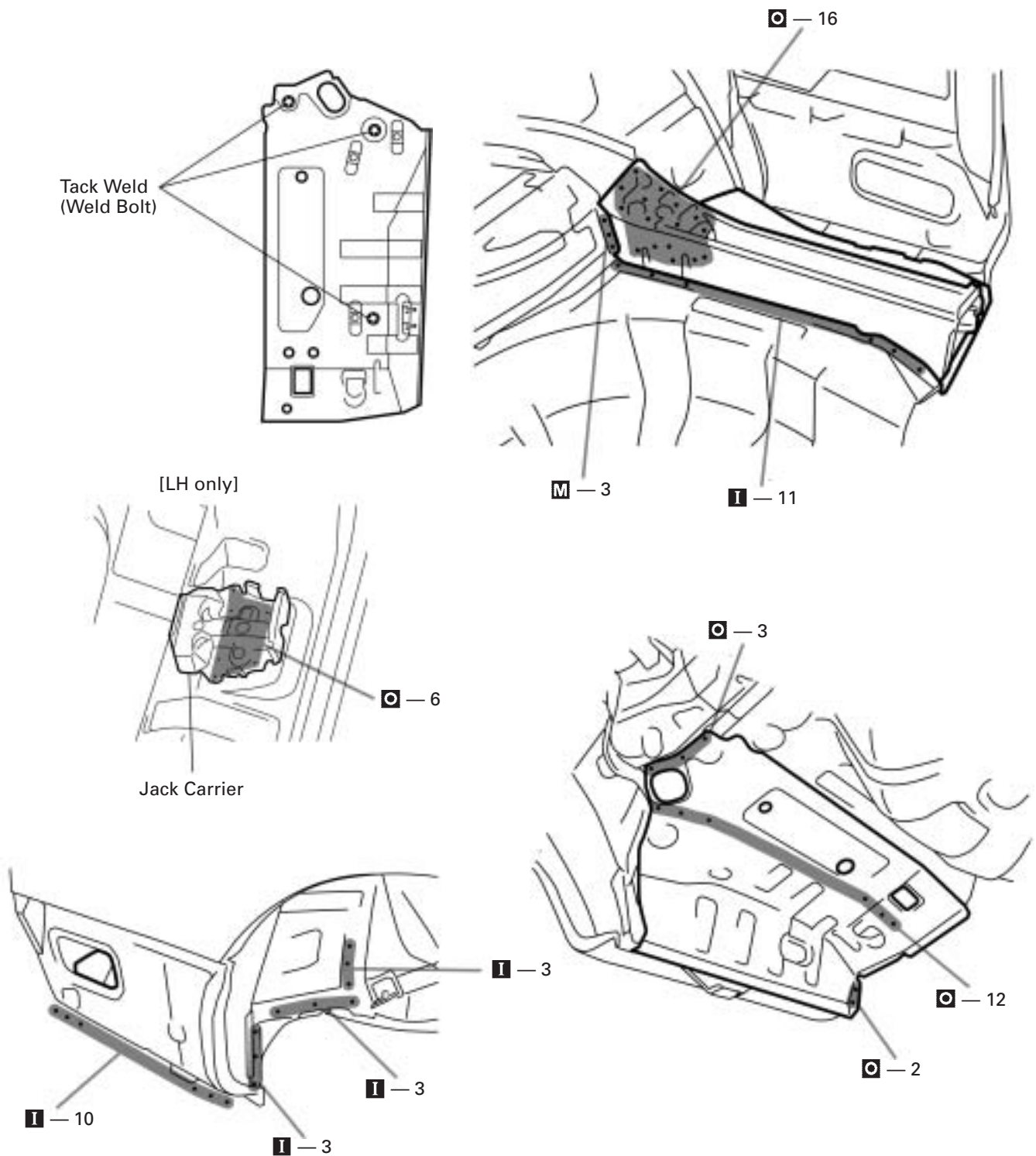
REAR FLOOR SIDE REAR MEMBER (ASSY)

REMOVAL (With the body lower back panel removed.)



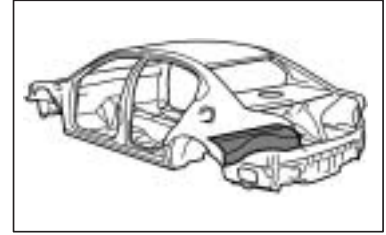
1. Replace the rear floor pan to quarter panel extension at the same time.

INSTALLATION

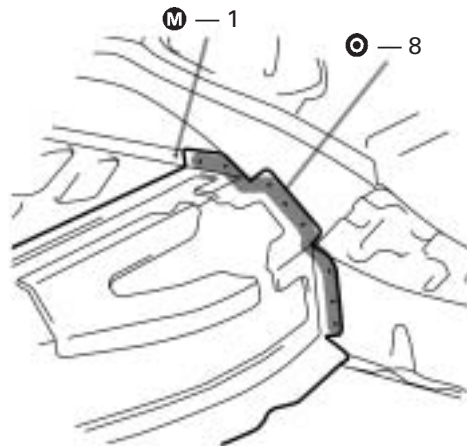
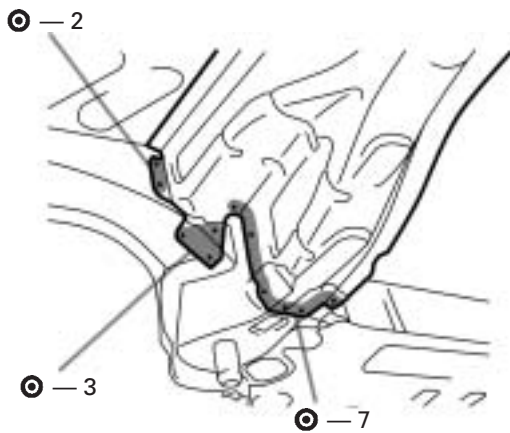
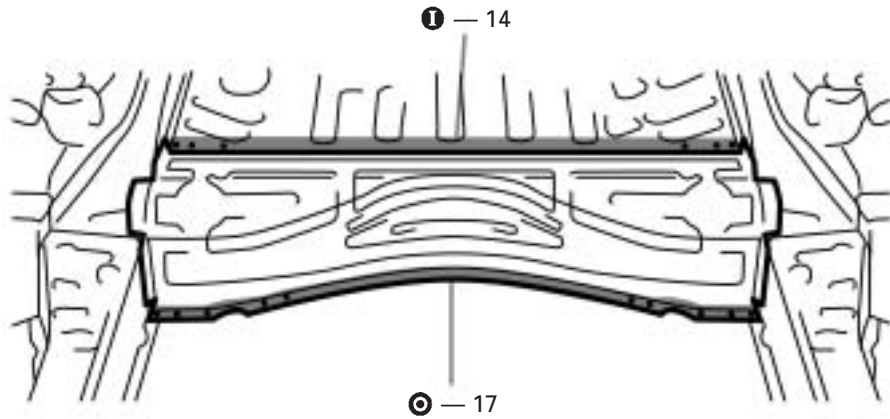


1. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.
2. After welding the rear floor side rear member, install the quarter panel extension.
3. Attach the weld bolt to the center of the bearing surface.

REAR FLOOR NO.1 CROSSMEMBER, REAR FLOOR NO.2 CROSSMEMBER (ASSY)

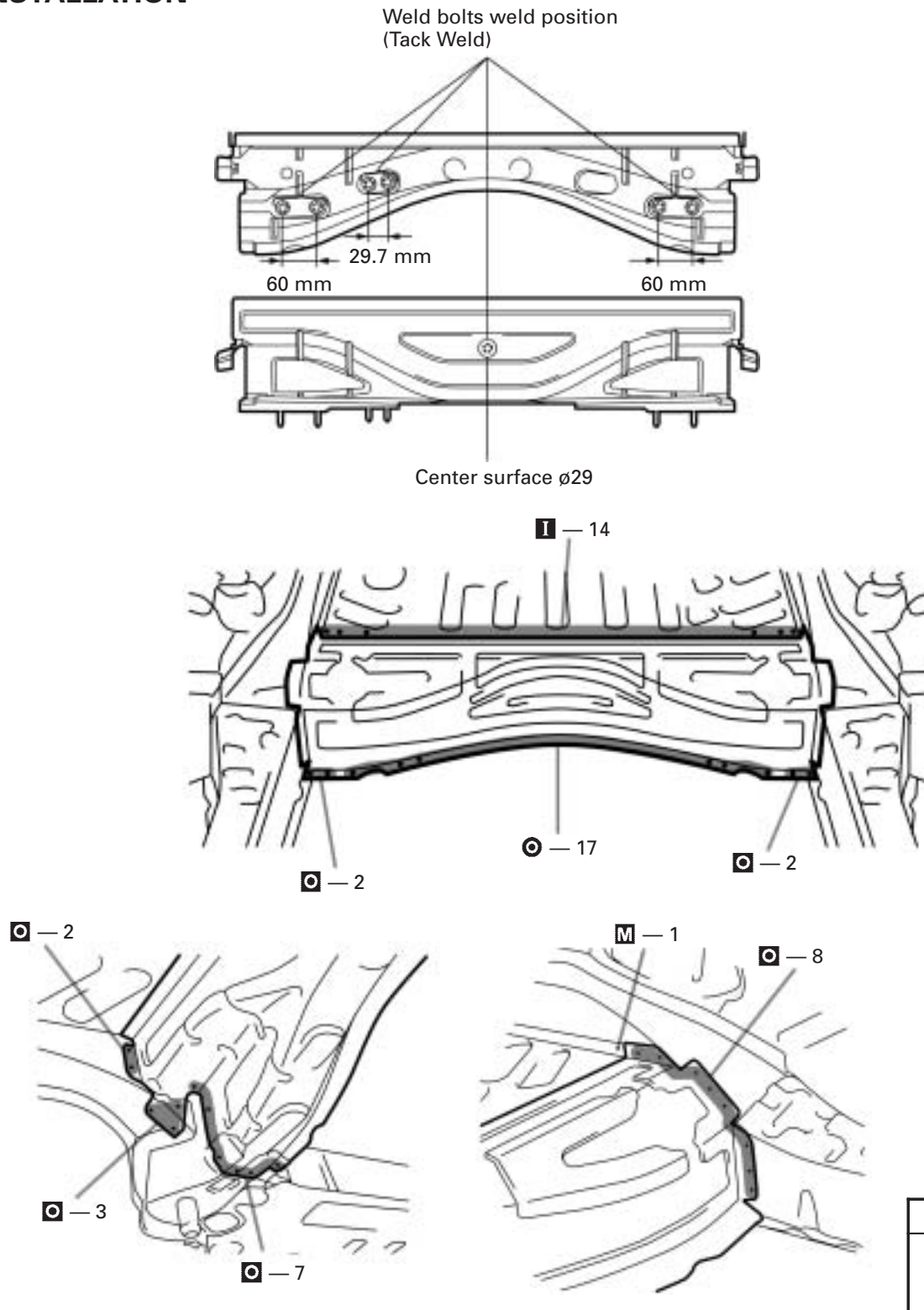


REMOVAL (With the rear floor pan removed.)

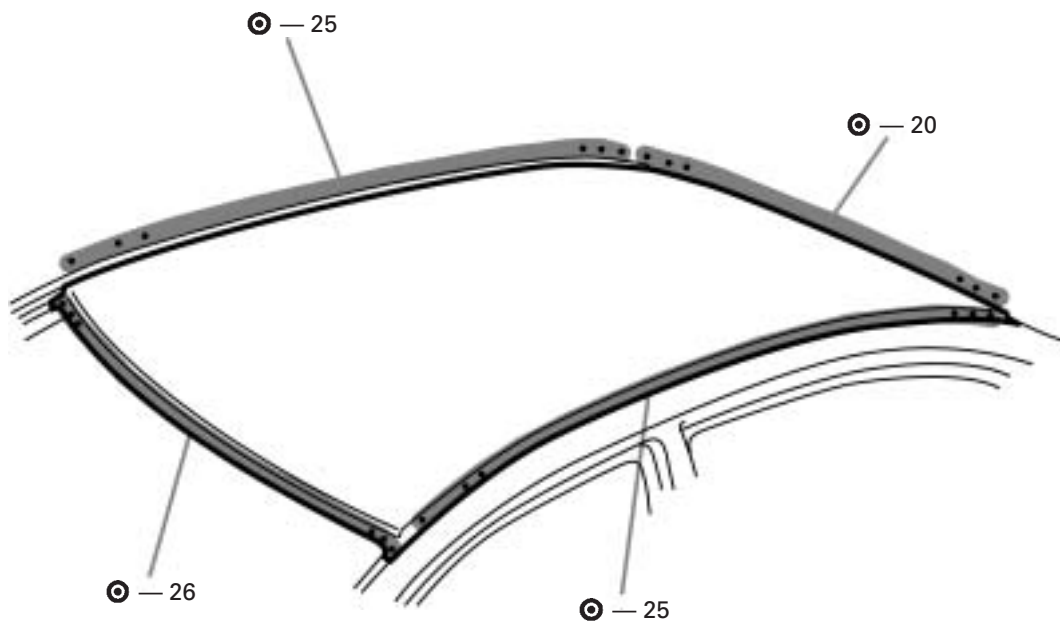
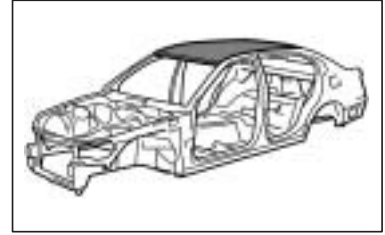


1. After removing the rear floor No.1 crossmember, remove the rear floor No.2 crossmember.

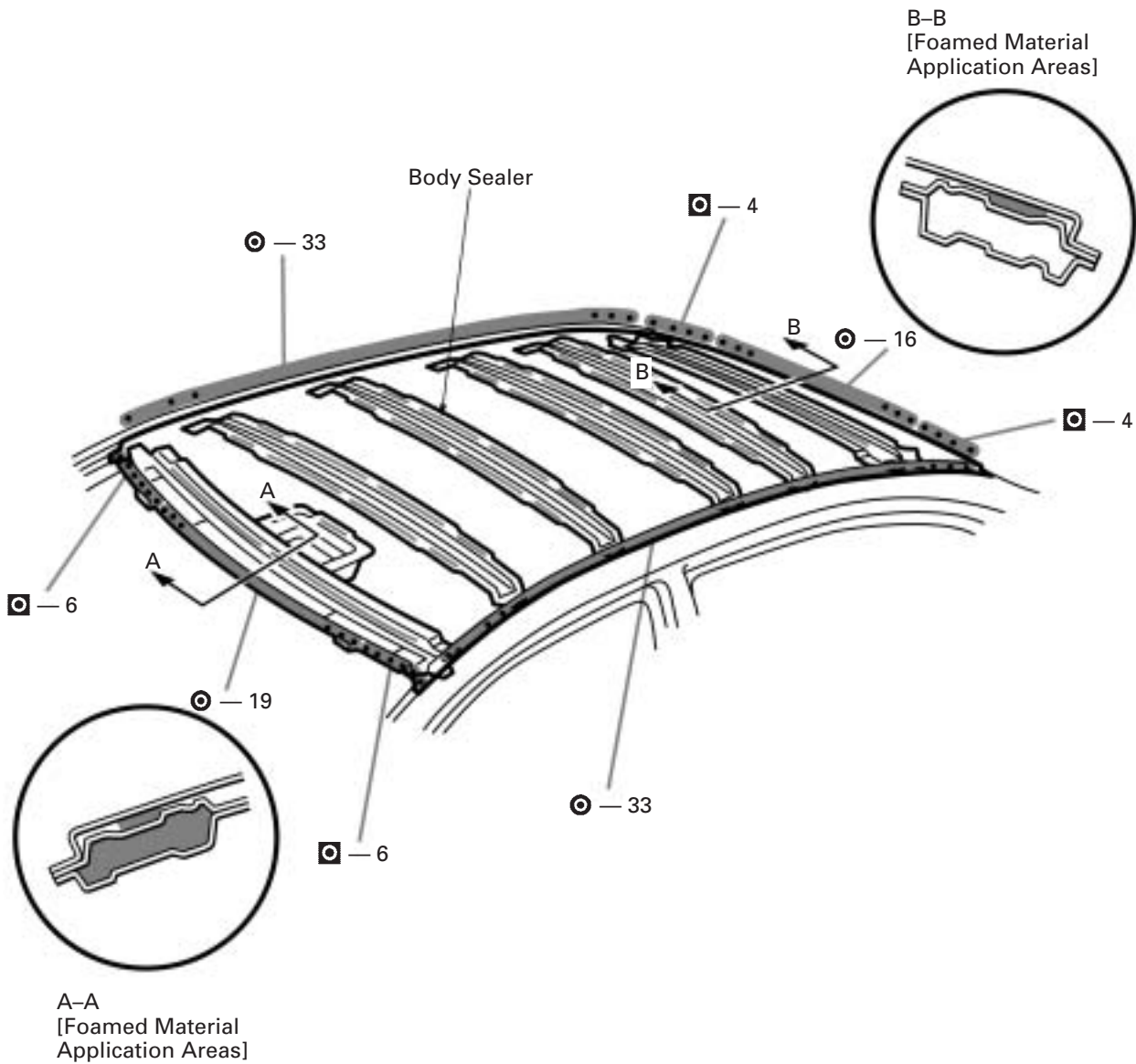
INSTALLATION



1. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.
2. Remove the weld of the weld bolts on the panel surface.

ROOF PANEL (ASSY): w/o Moon Roof**REMOVAL**

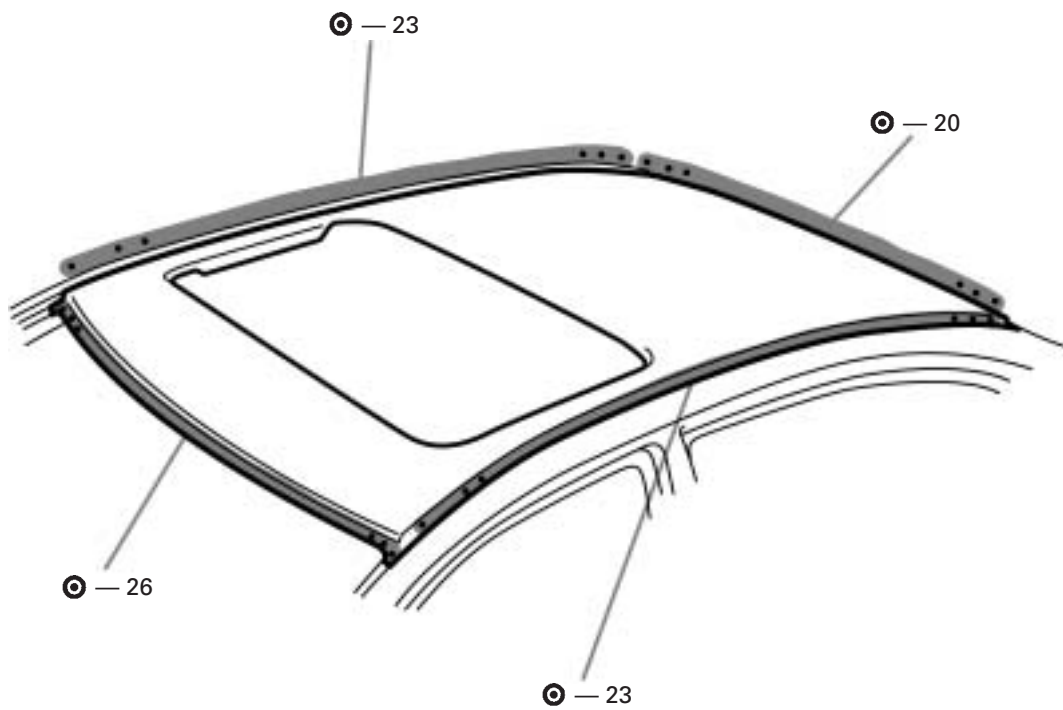
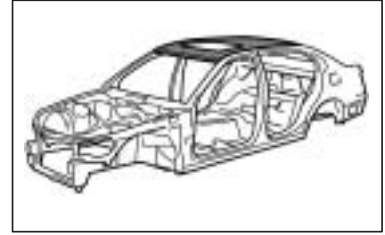
INSTALLATION



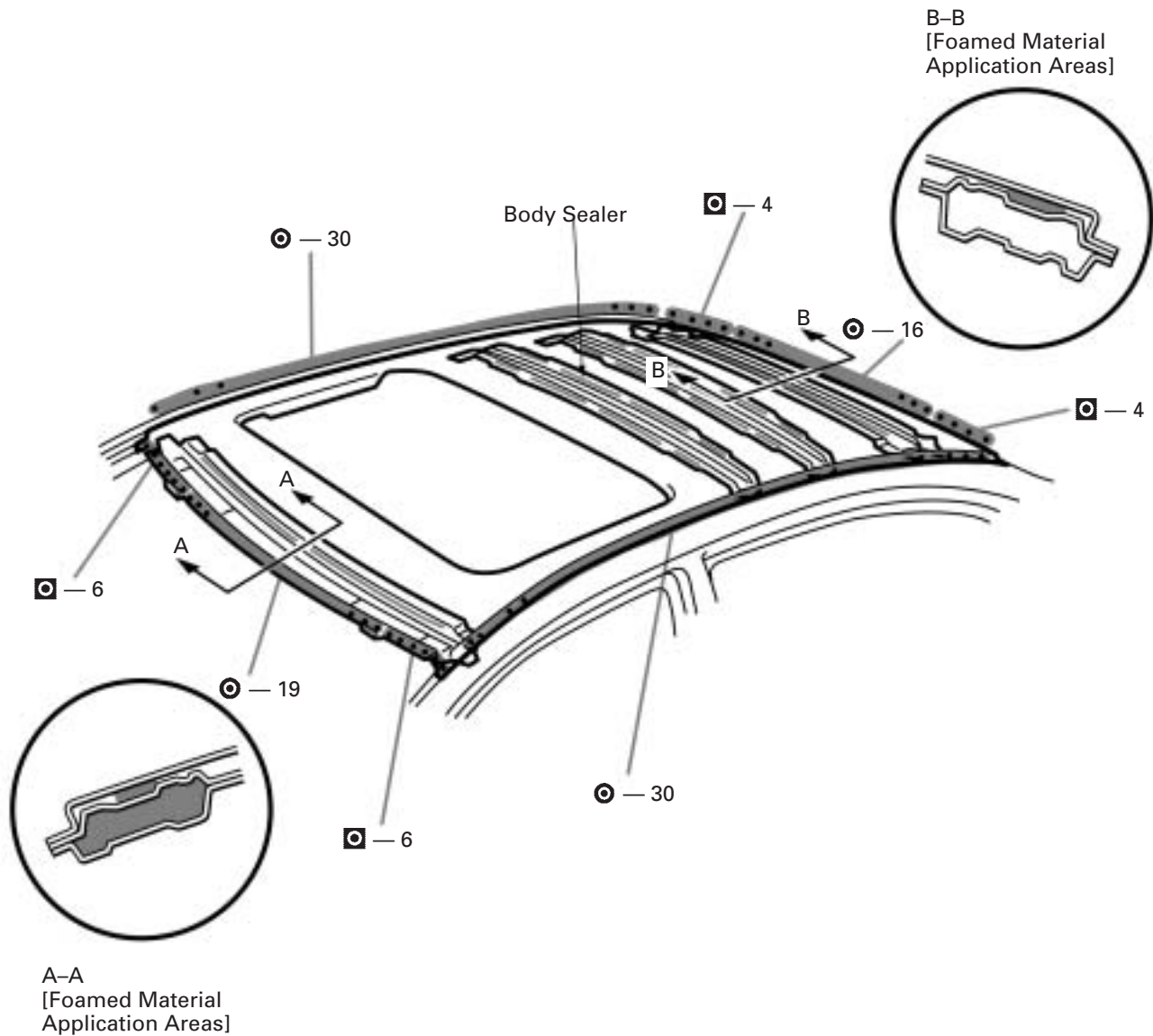
1. Before temporarily installing the new parts, apply body sealer to the windshield header panel, roof panel reinforcement and back window opening frame.
2. Apply foamed material to the pillar section.

HINT:

- 1) Apply just enough sealer for the new parts to make contact.
- 2) For other sealing points, refer to section AR.

ROOF PANEL (ASSY): w/ Moon Roof**REMOVAL**

INSTALLATION



1. Before temporarily installing the new parts, apply body sealer to the windshield header panel, roof panel reinforcement and back window opening frame.
2. Apply foamed material to the pillar section.

HINT:

- 1) Apply just enough sealer for the new parts to make contact.
- 2) For other sealing points, refer to section AR.

