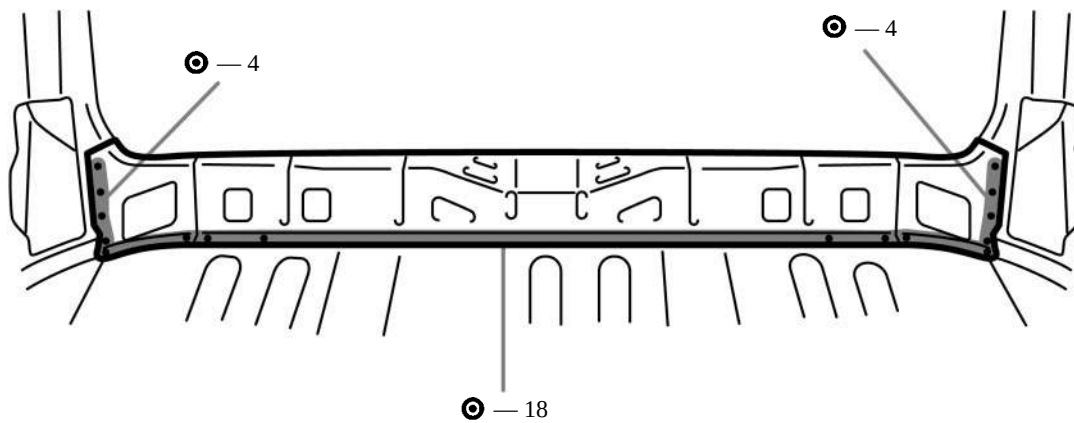
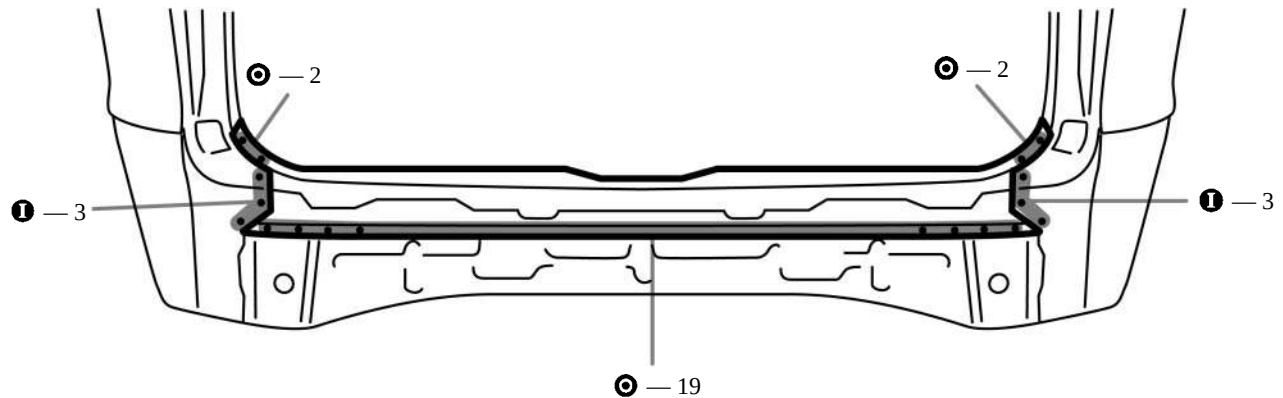
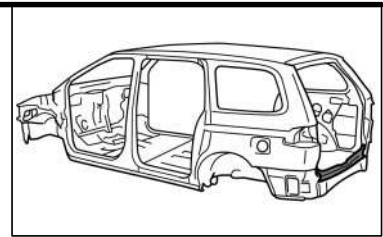
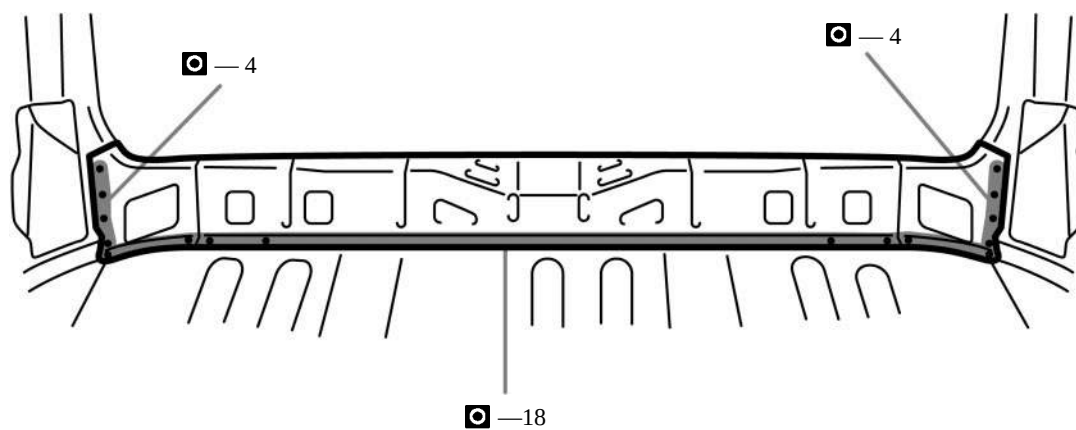
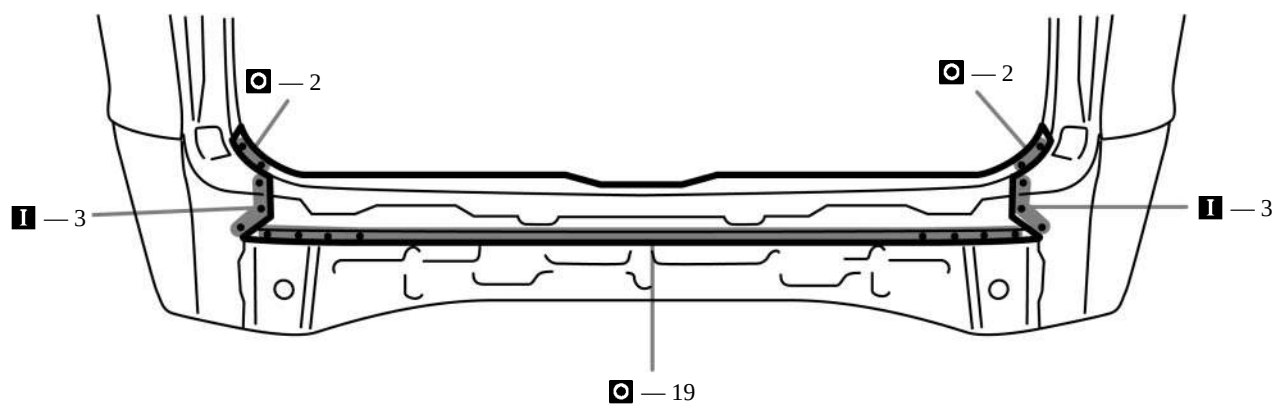


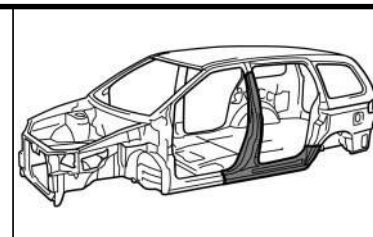
BODY LOWER BACK PANEL (ASSY)**REMOVAL**

INSTALLATION

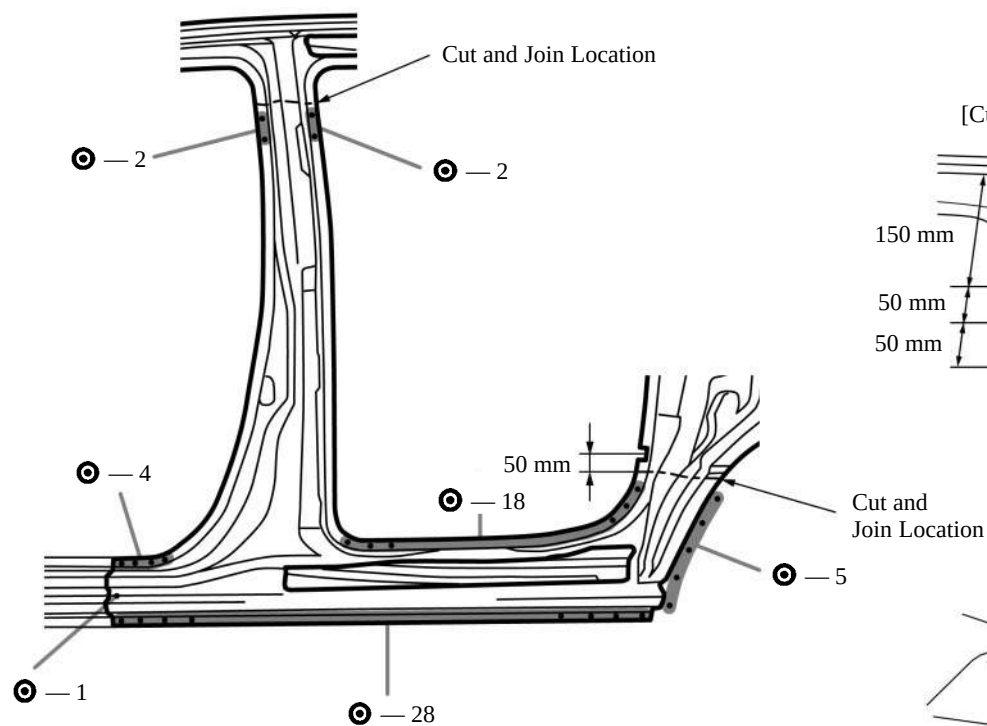
1. Temporarily install the new parts and check the fit of the back door.

CENTER BODY PILLAR (CUT)

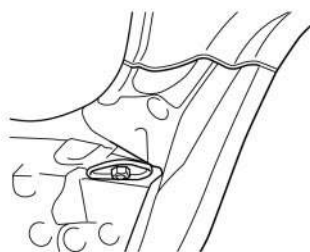
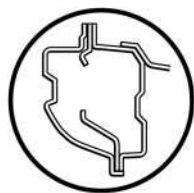
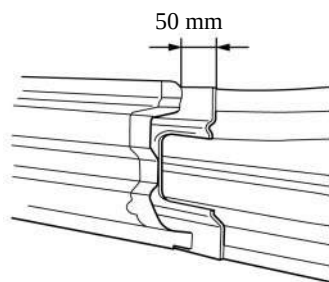
REMOVAL



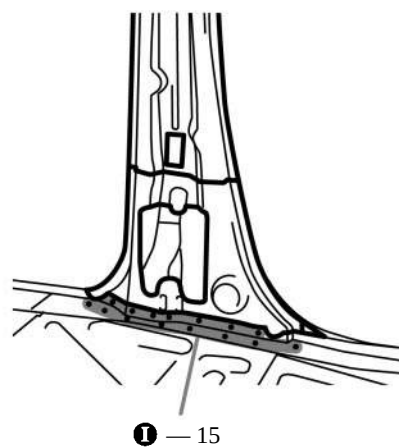
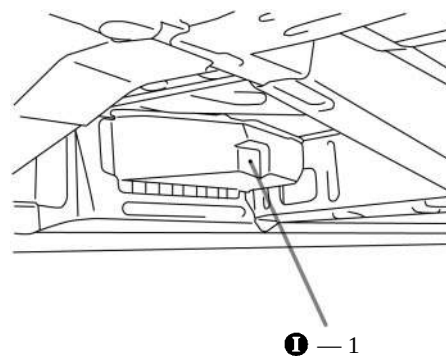
[Cut and Join Location]



[Cut and Join Locations]



mm	in.
50	1.97
150	5.91

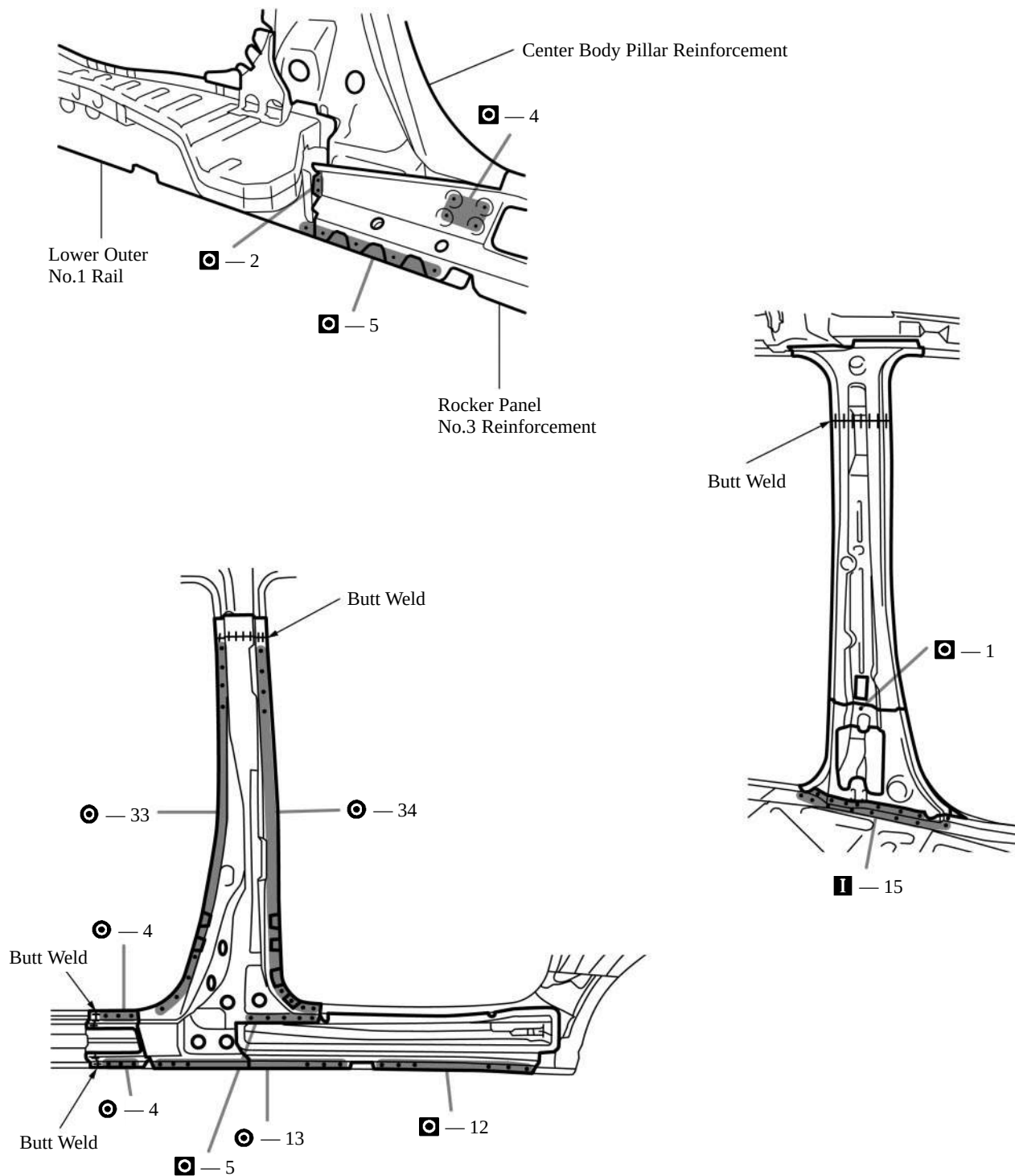


1. Cut and join the parts at the locations as shown above.

HINT:

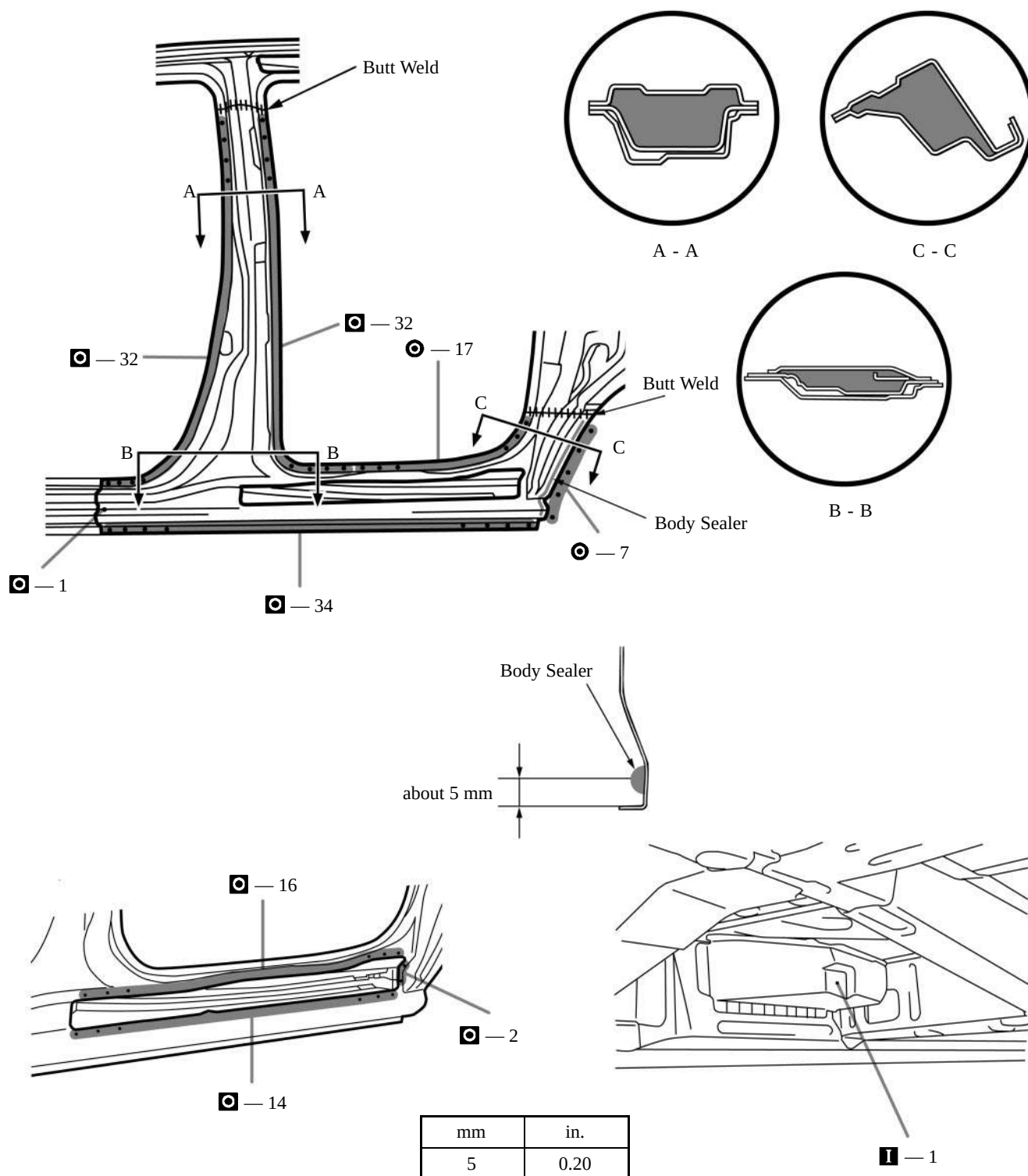
- 1) Shift the each cut and join locations of the center outer pillar, reinforcement and inner pillar.
- 2) Shift the each cut and join locations of the rocker outer panel and rocker No.3 reinforcement.

INSTALLATION



1. Before temporarily installing the new parts, weld the rocker panel No.3 reinforcement and center body pillar reinforcement and lower outer No.1 rail with standard points.
2. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.
3. Before welding the new parts, check the fit of the front door and slide door.

[Foamed Material Application Areas]



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

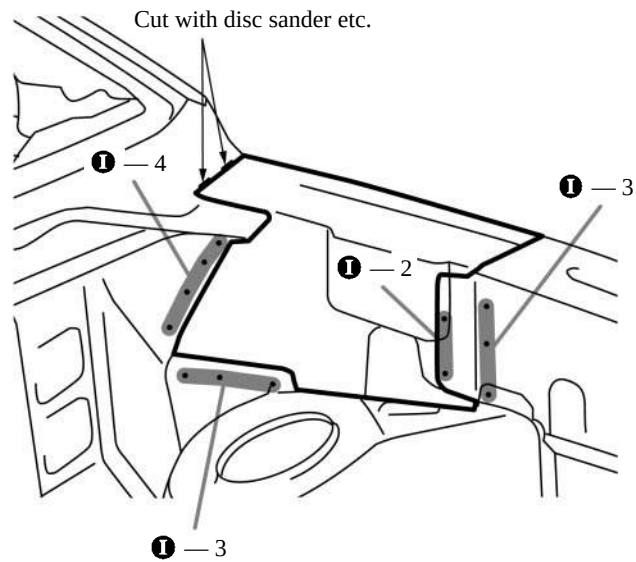
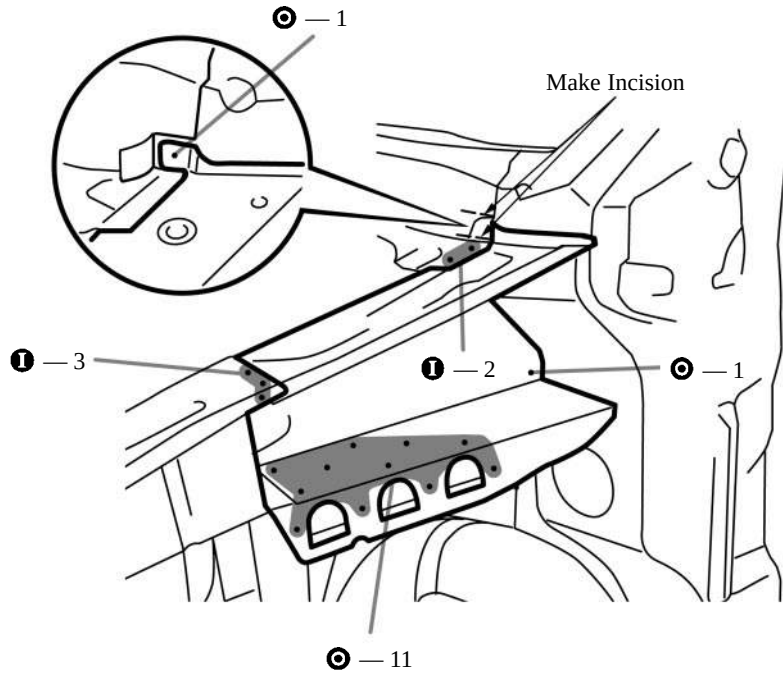
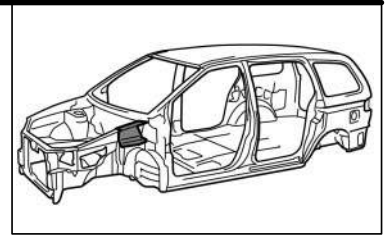
HINT:

- 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.

5. After welding the center and rocker reinforcement and inner pillar to the vehicle install the outer pillar.
6. Apply foamed material to the pillar and quarter sections.

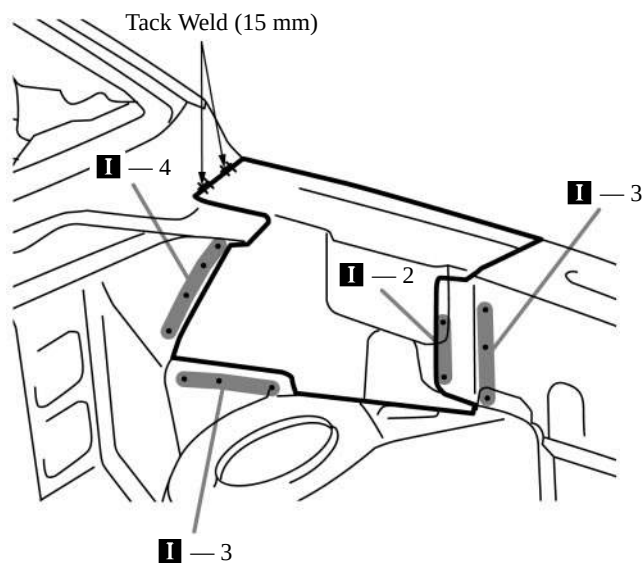
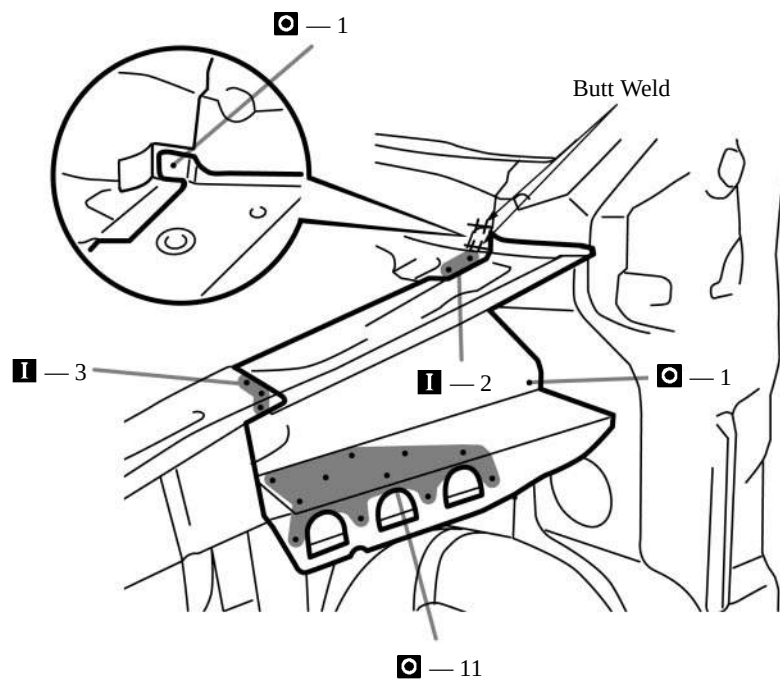
COWL TOP SIDE INNER PANEL (ASSY)

REMOVAL (With the cowl top side outer panel removed.)



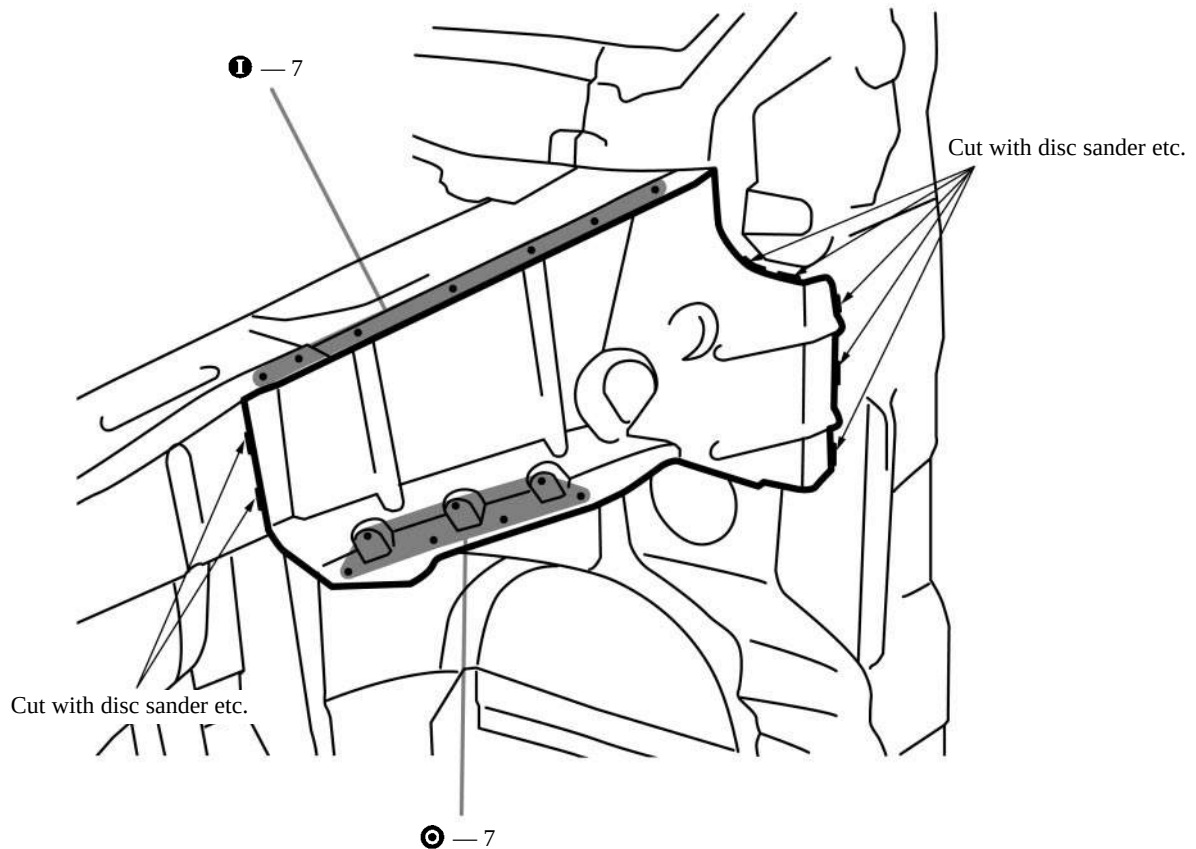
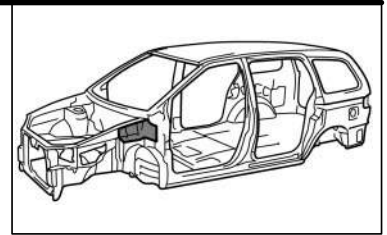
1. Make an incision in the cowl top panel and bend as shown above. Drill out the spot welds and separate the cowl top side inner panel.

INSTALLATION

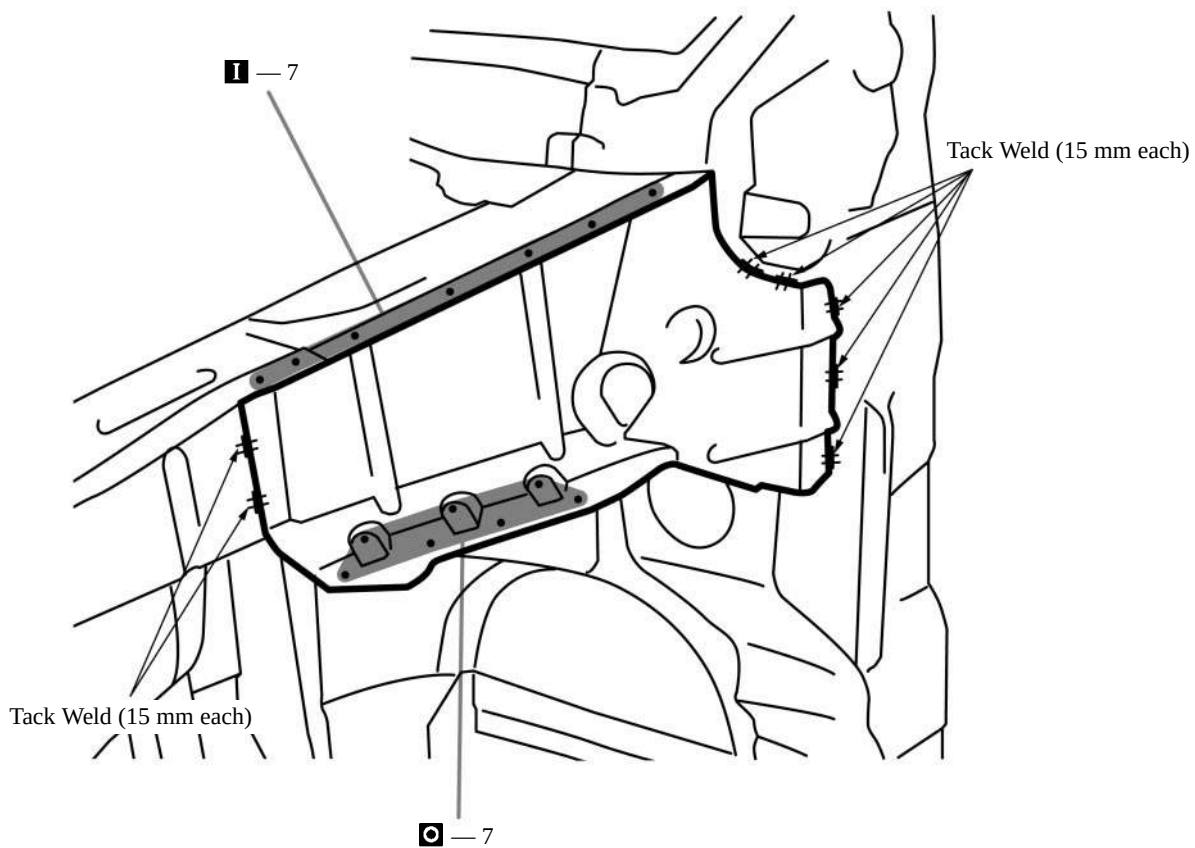


mm	in.
15	0.59

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

COWL TOP SIDE OUTER PANEL (ASSY)**REMOVAL**

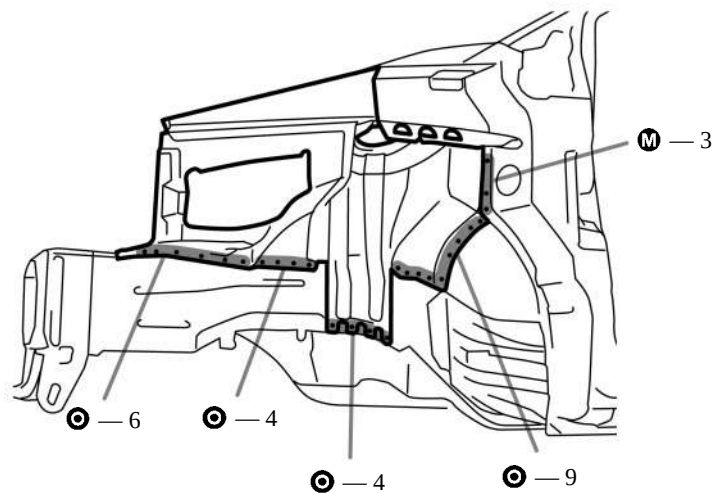
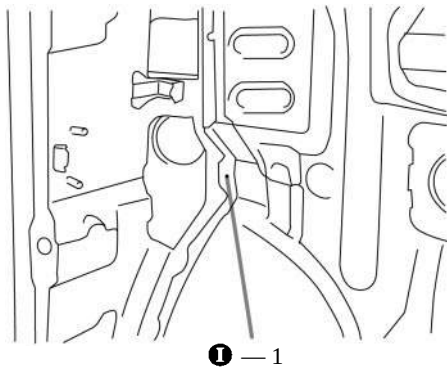
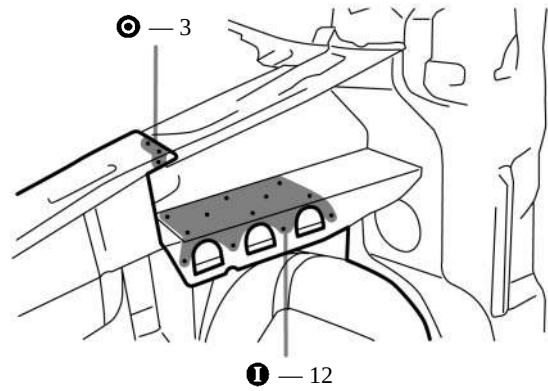
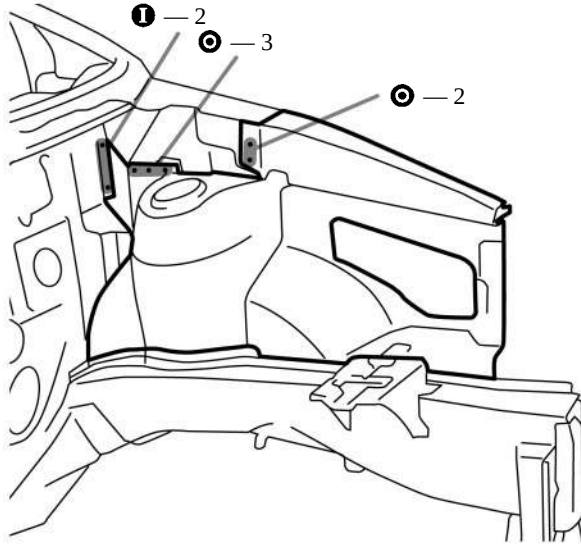
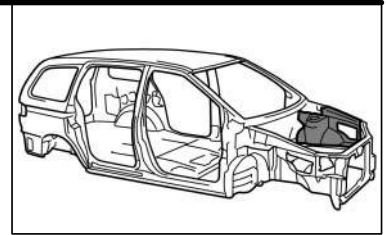
INSTALLATION



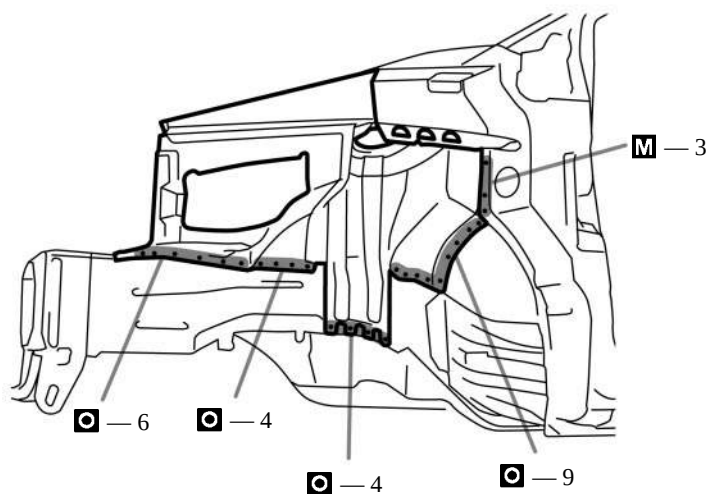
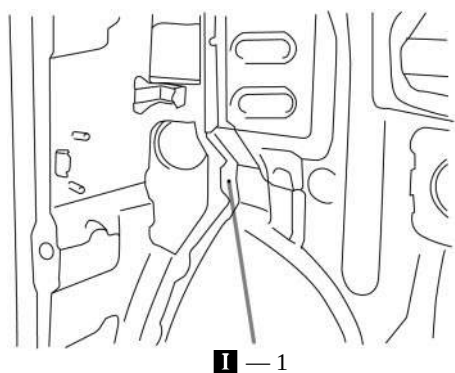
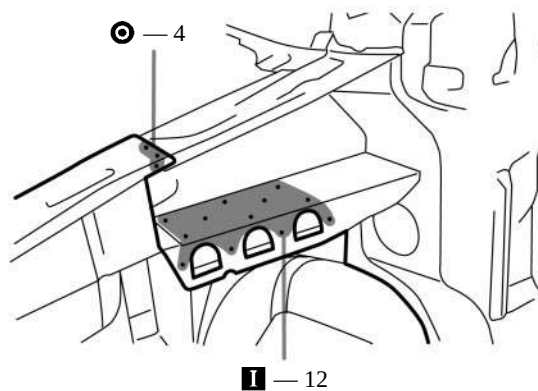
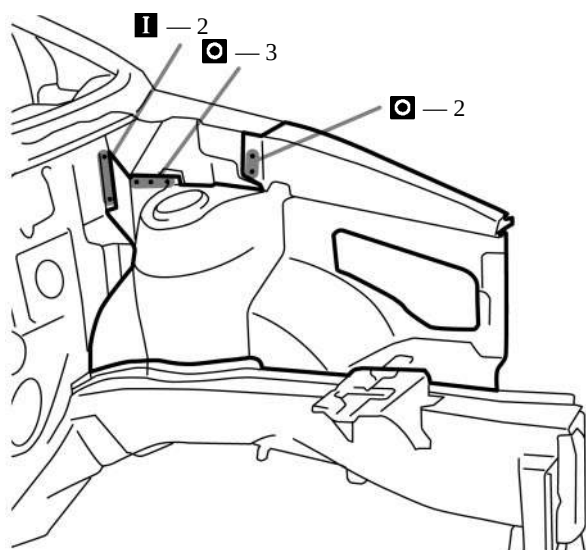
mm	in.
15	0.59

FRONT FENDER APRON (ASSY)

REMOVAL (With the radiator side support, cowl top side outer panel removed.)



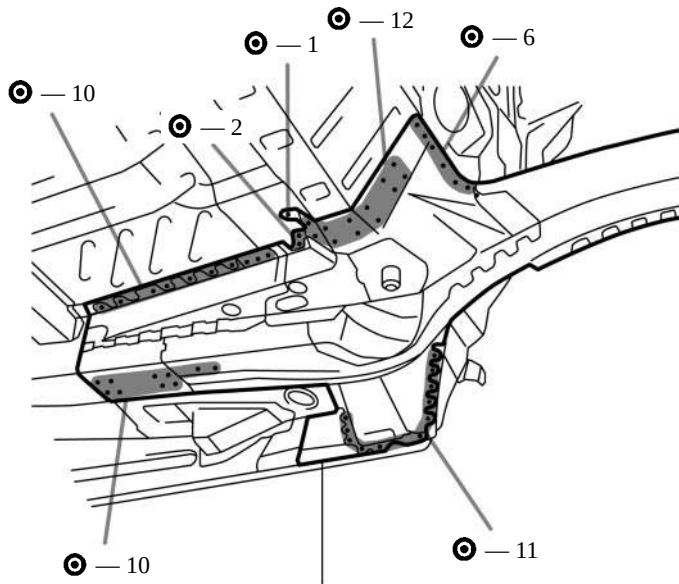
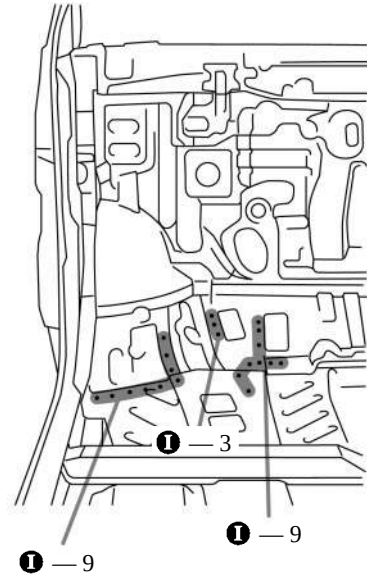
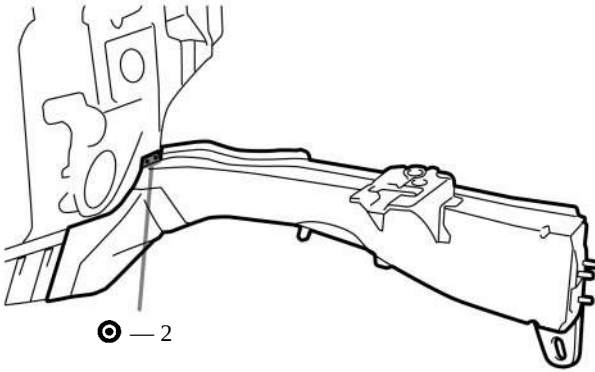
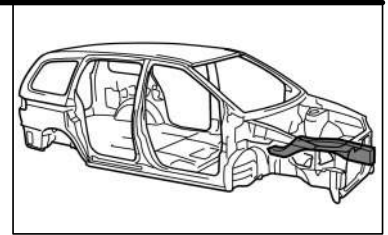
INSTALLATION



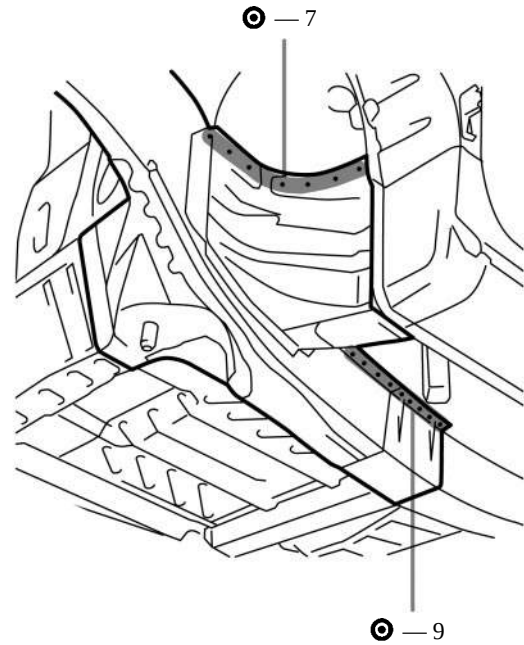
1. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.
2. Measurements must be accurate with the body dimension diagram, as this affects the front wheel alignment.
3. Temporarily install the front fender and hood, and check the fit.

FRONT SIDE MEMBER (ASSY)

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

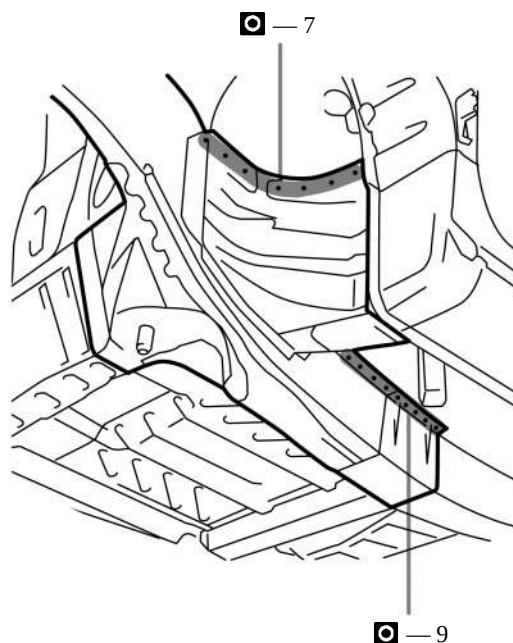
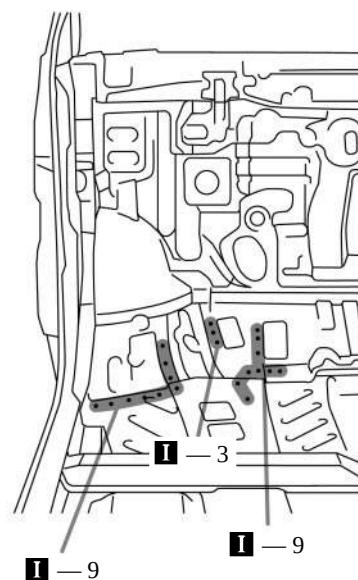
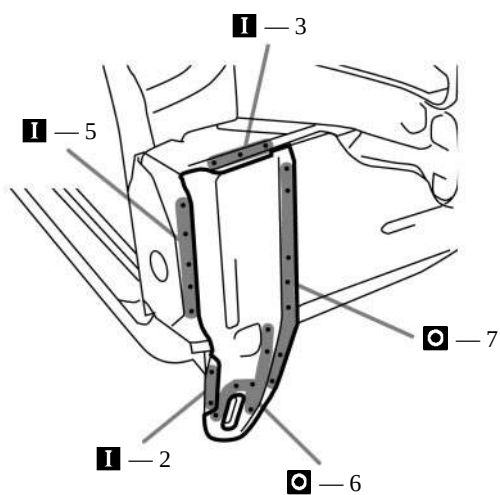
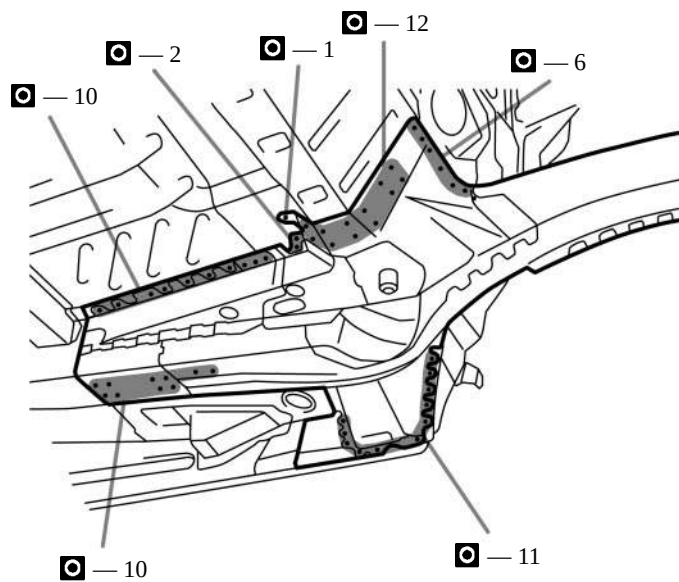
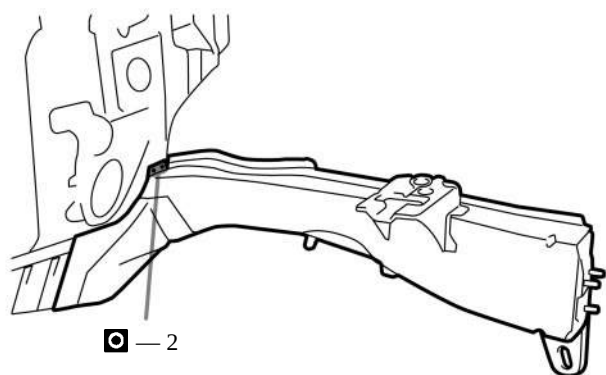


Floor Side Member No.1 Reinforcement



1. Leave the floor side member No.1 reinforcement to the vehicle. Remove the front side member.

INSTALLATION

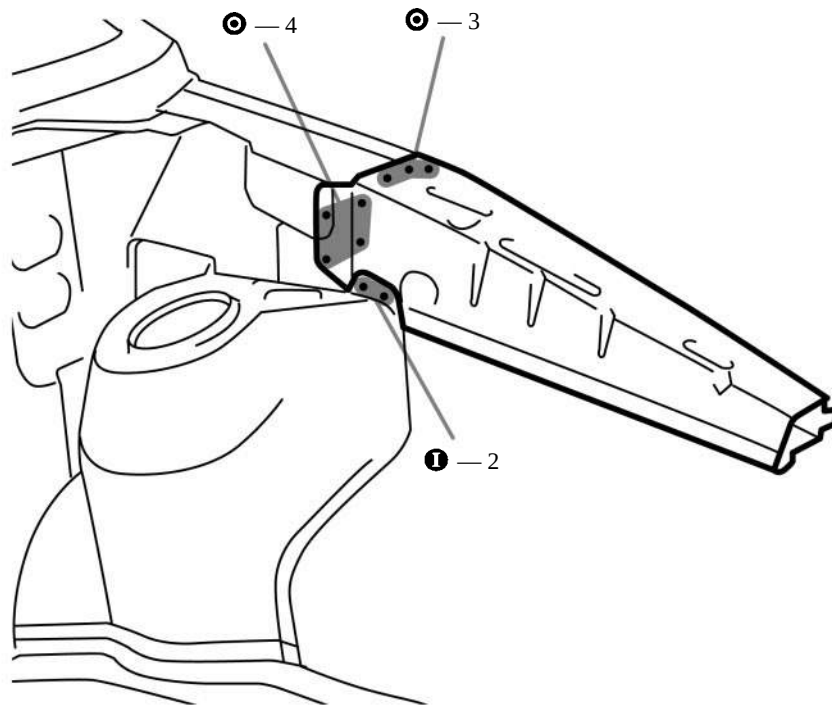
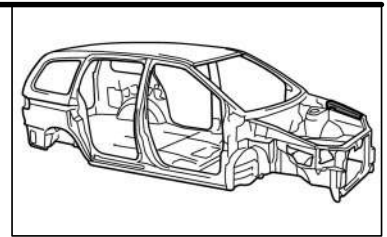


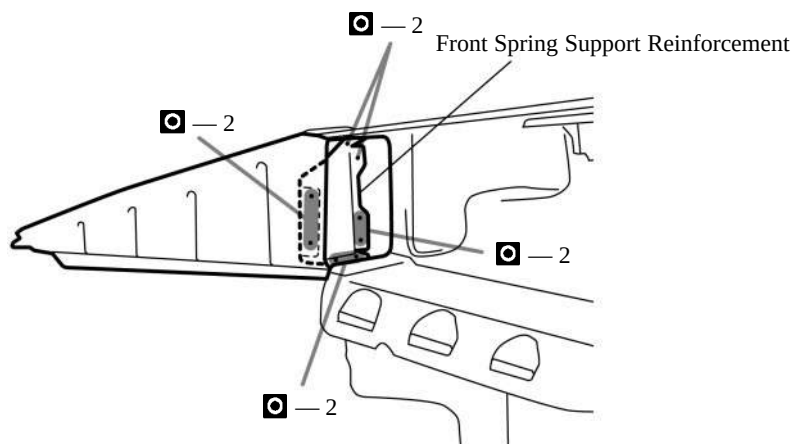
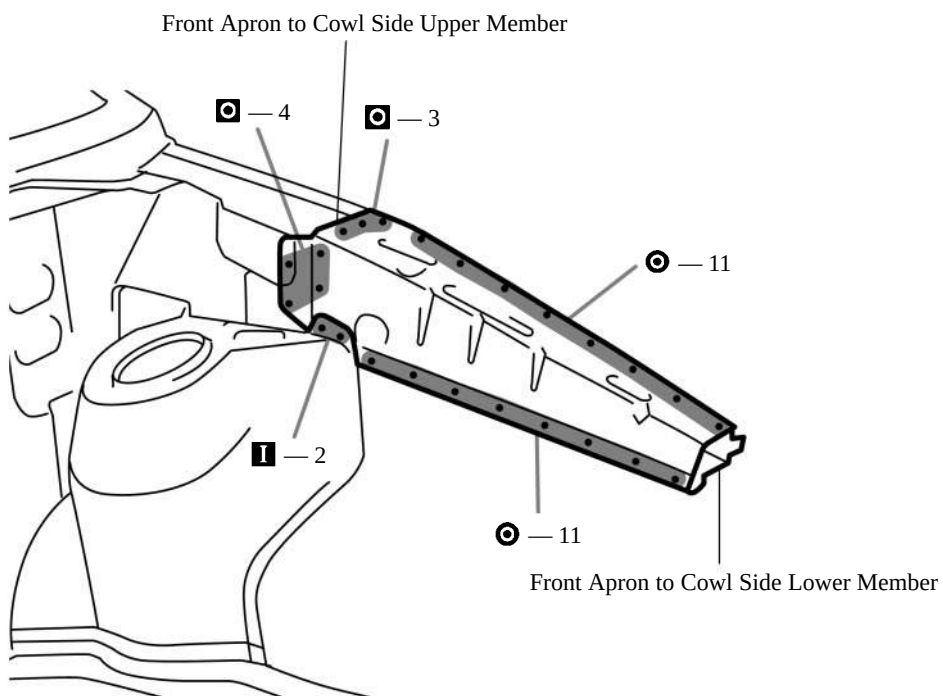
1. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.

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

FRONT APRON TO COWL SIDE MEMBER (ASSY)

REMOVAL (With the front fender front apron, cowl top side outer panel removed.)

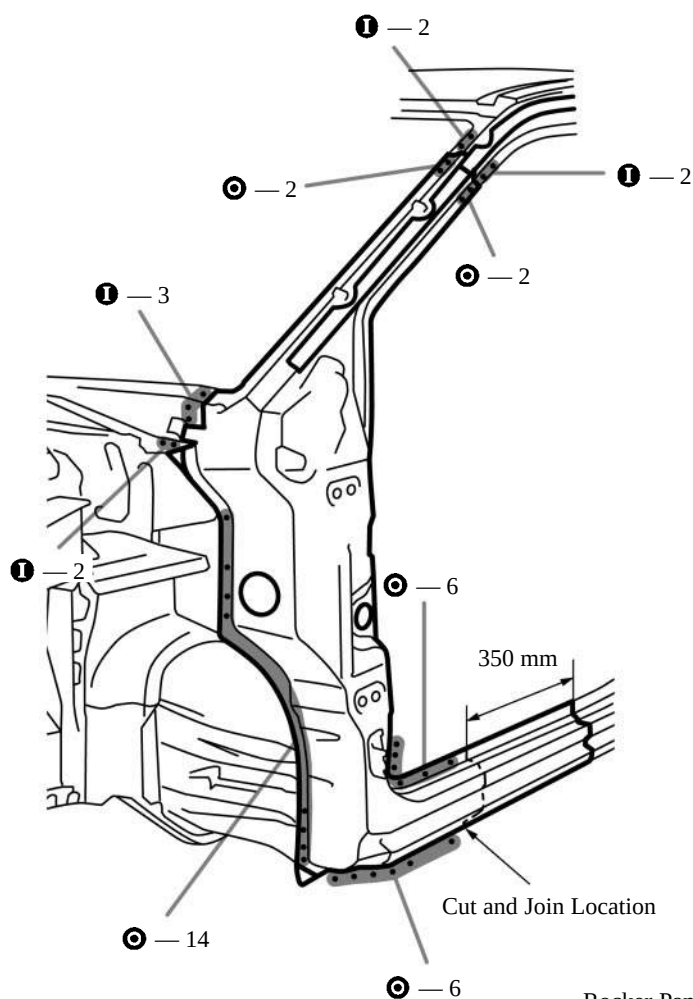
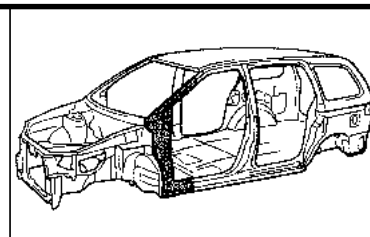


INSTALLATION

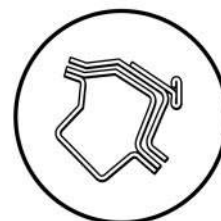
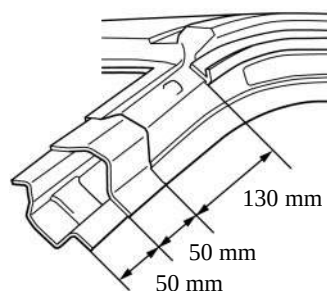
1. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.

FRONT BODY PILLAR (CUT)

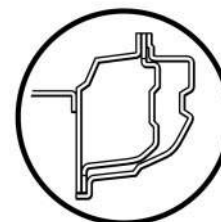
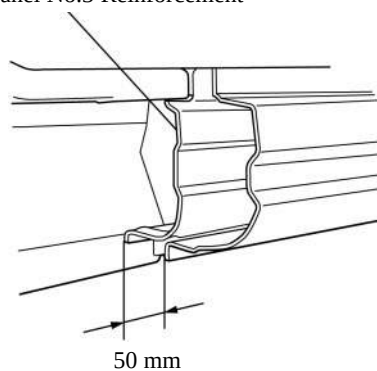
REMOVAL (With the cowl top side inner panel removed.)



[Cut and Join Locations]

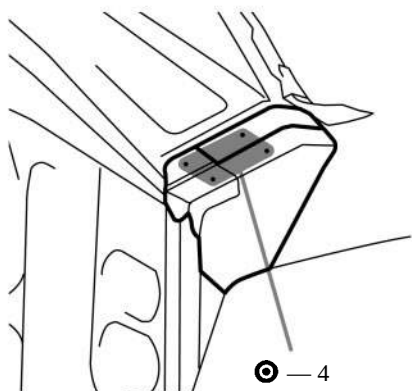
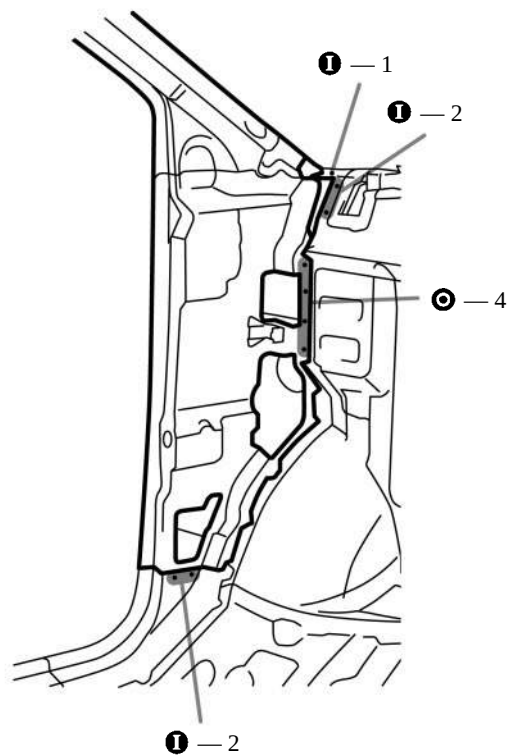
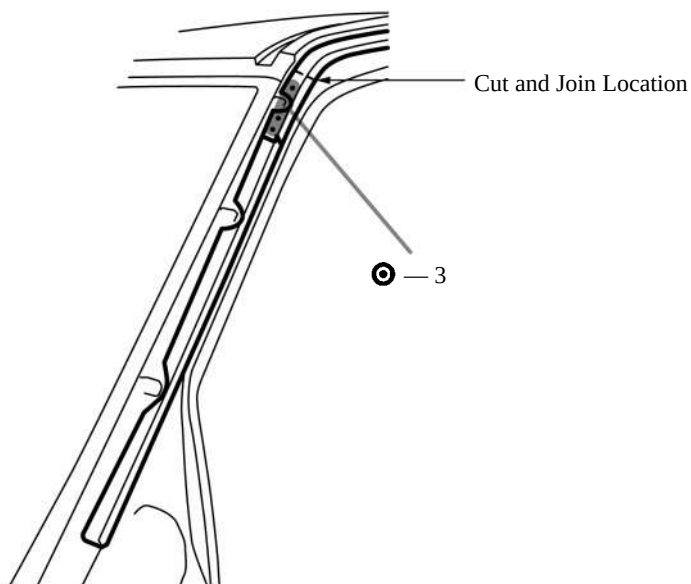


Rocker Panel No.3 Reinforcement

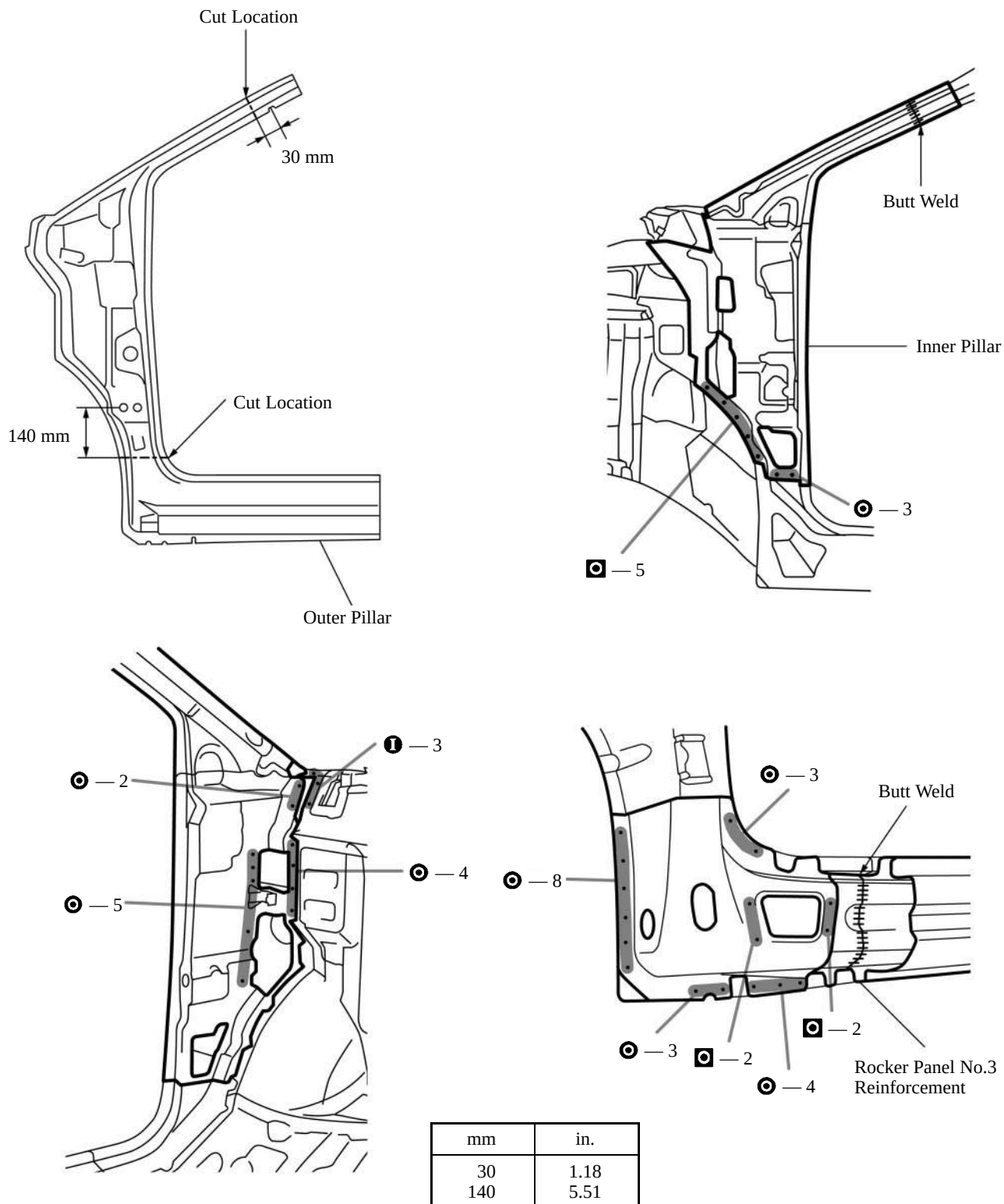


mm	in.
50	1.97
130	5.12
350	13.78

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, inner pillar and roof drip channel.
3. Shift the each cut and join locations of the outer panel, rocker panel No.3 reinforcement.



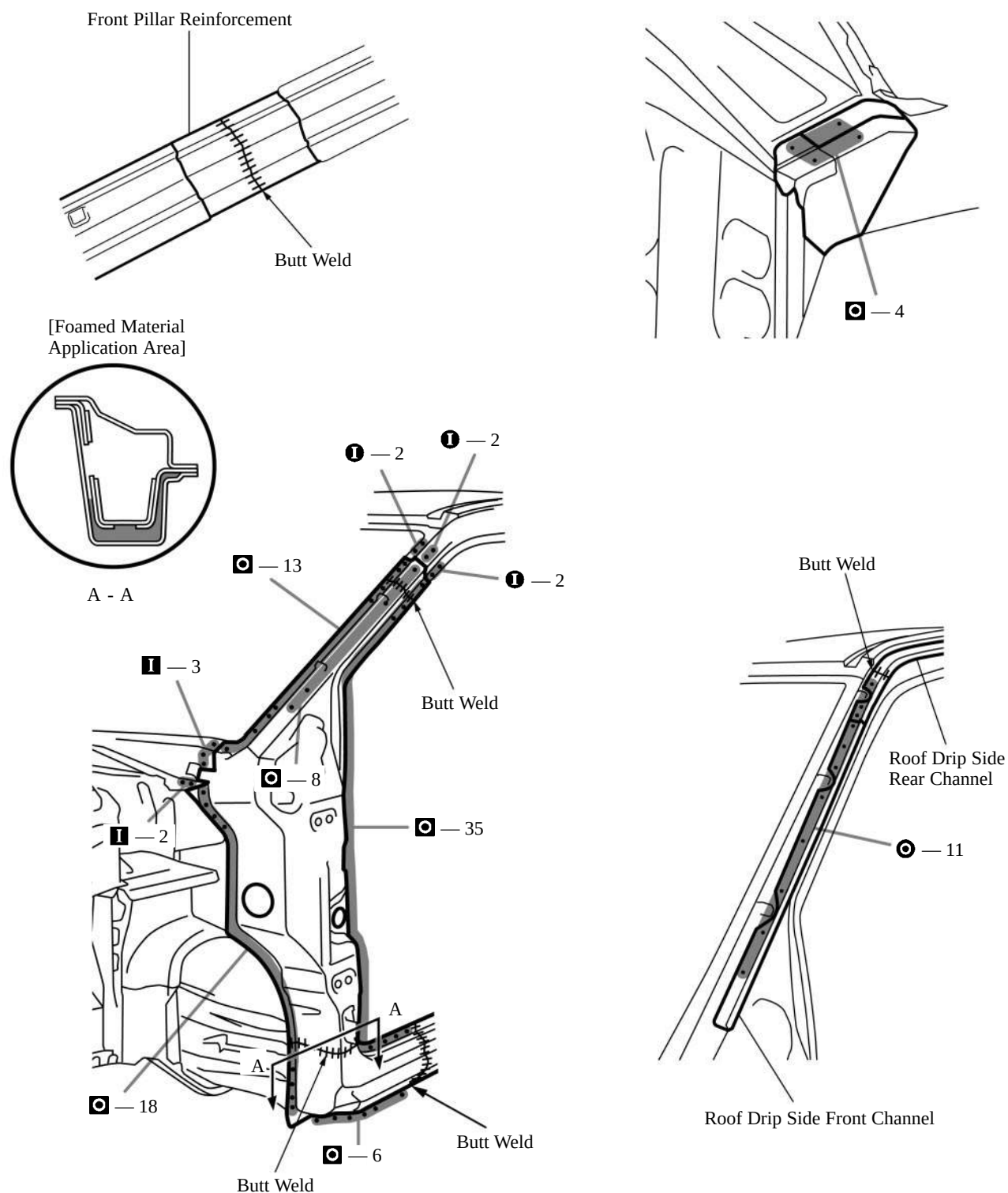
INSTALLATION



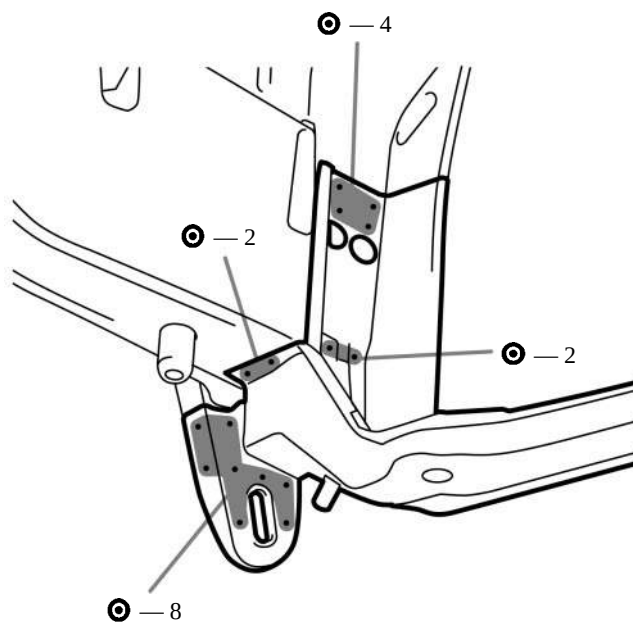
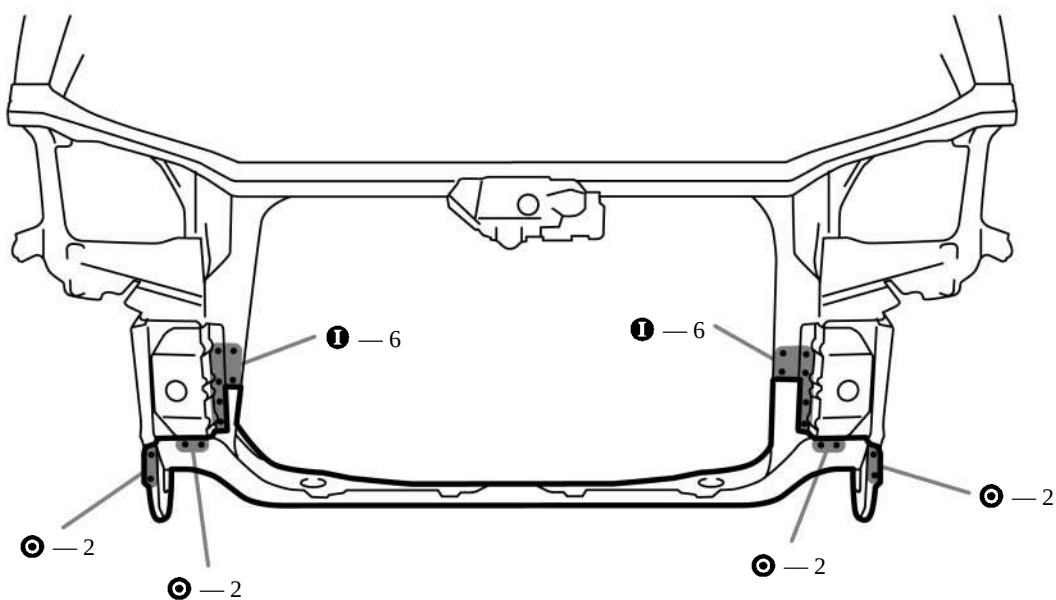
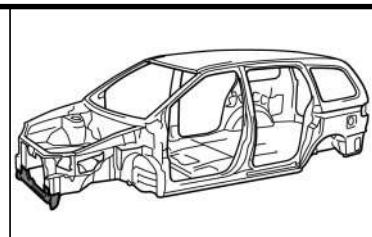
1. Cut the new parts for the outer pillar at the shown above.

HINT: After butt welding the rocker panel No.3 reinforcement and front body pillar reinforcement attach it to the upper and lower area of the outer pillar.

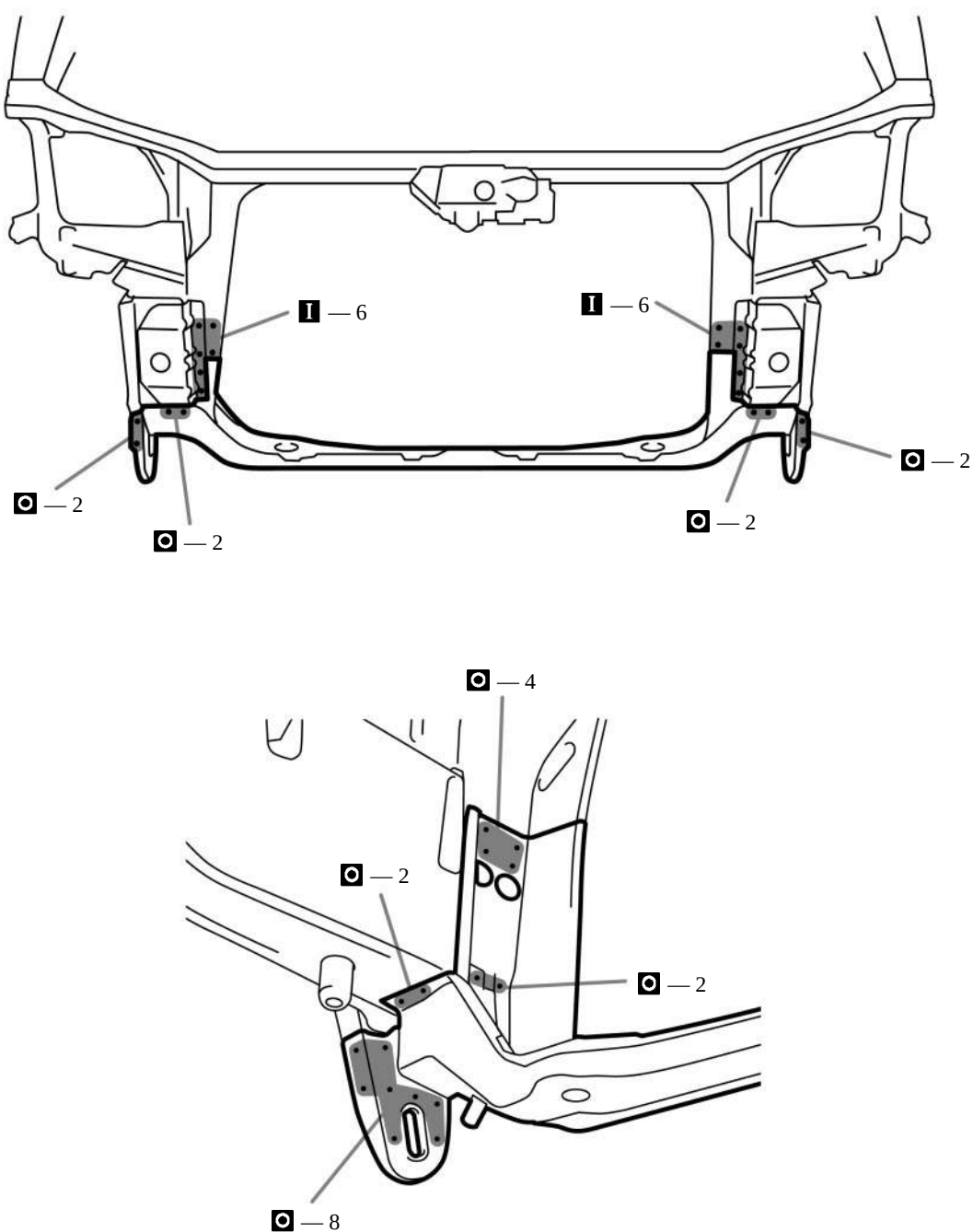
2. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.



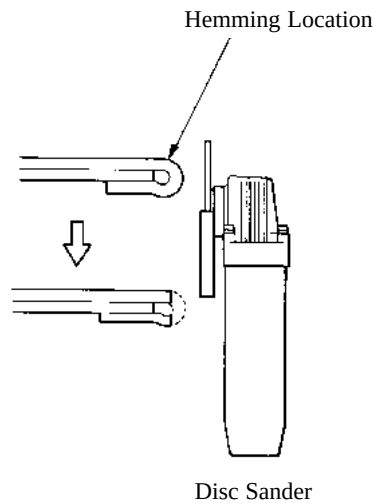
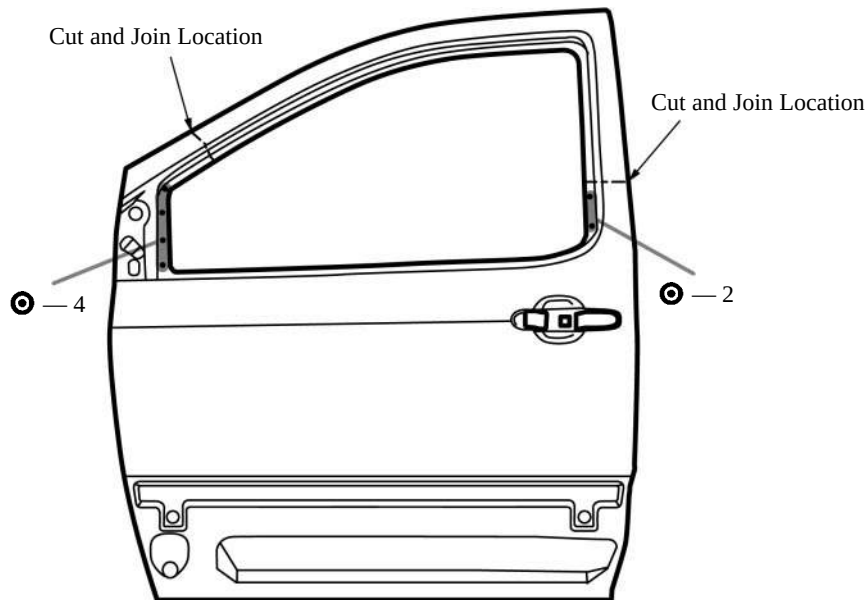
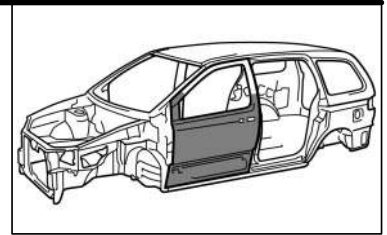
3. Before welding the new parts, check the fit of the front door, front fender and windshield glass.
4. After installing the new parts, apply foamed material.

FRONT CROSSMEMBER (ASSY)**REMOVAL**

INSTALLATION

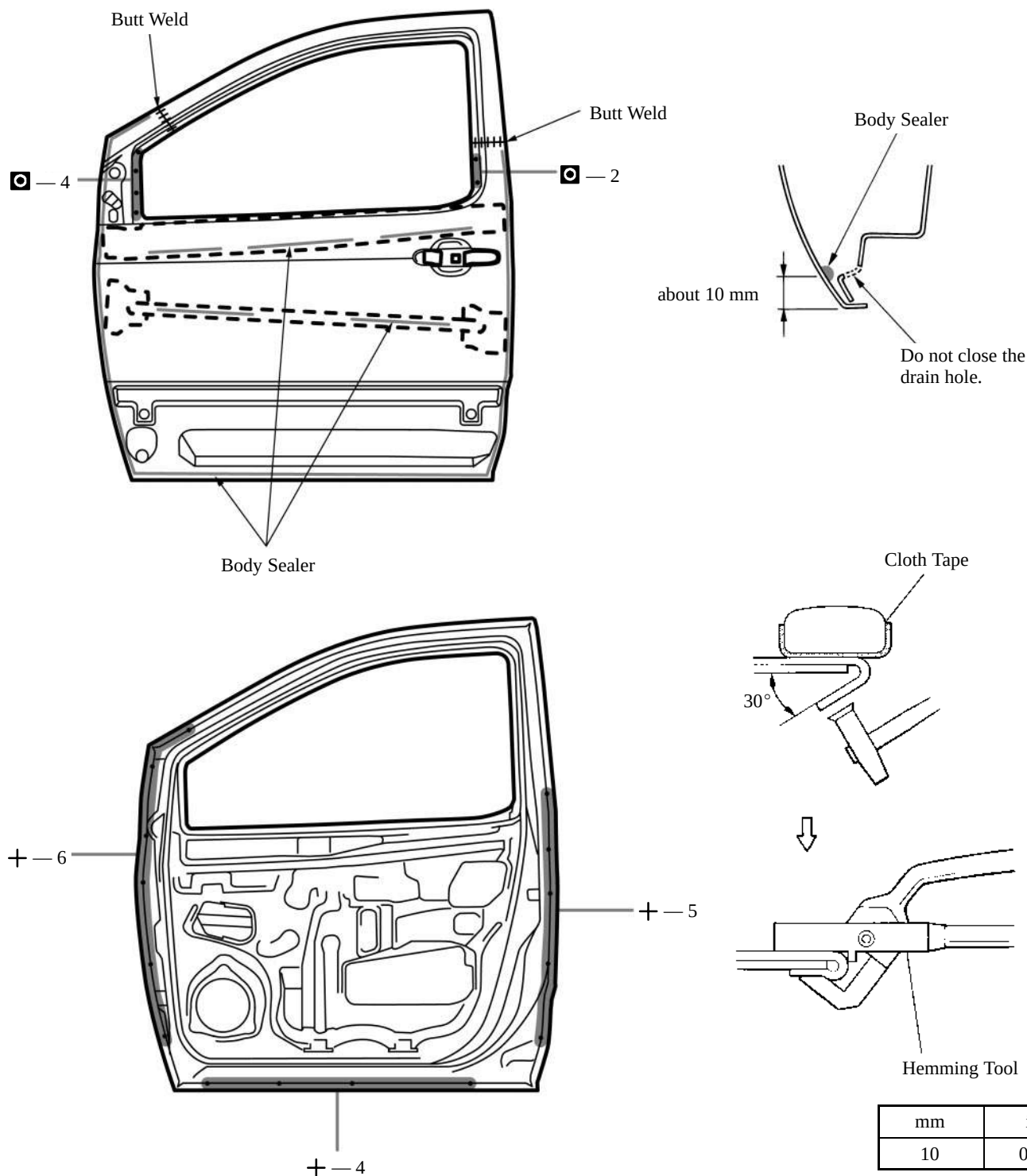


1. Temporarily install the new parts and measure each part in accordance with body dimension diagram.

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

1. Cut and join the parts at the locations as shown above.
2. After grinding off the hemming location, remove the outer panel.

INSTALLATION



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

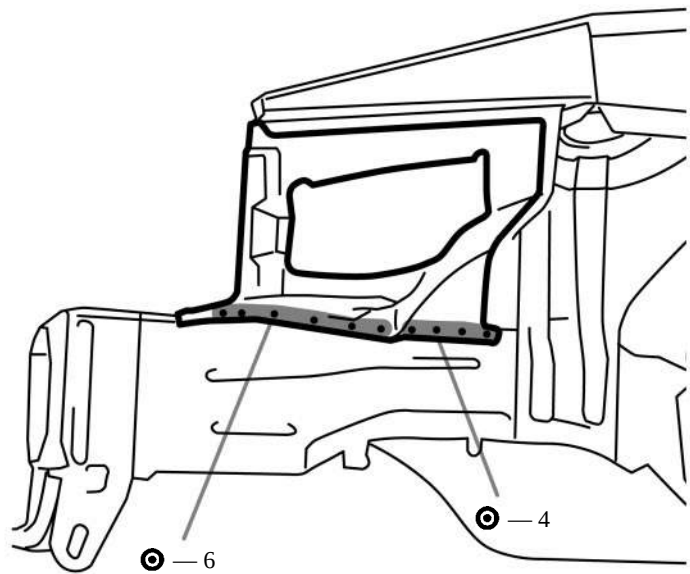
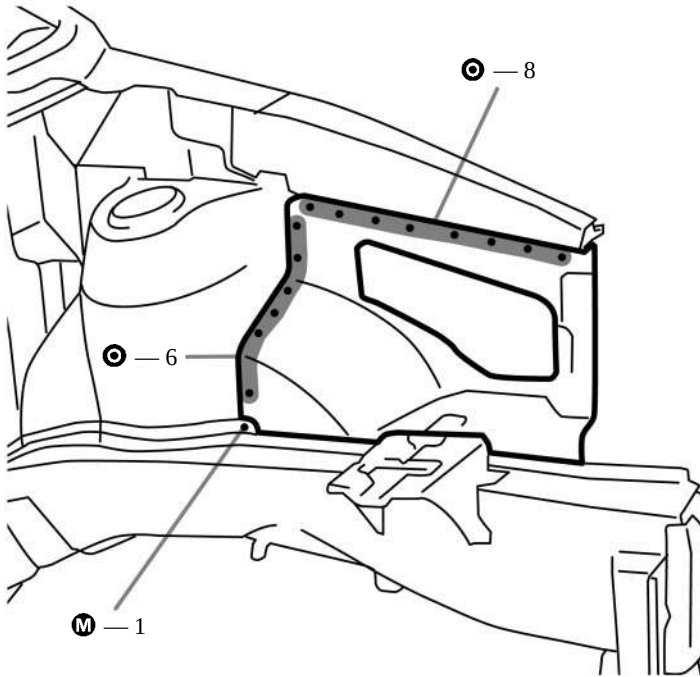
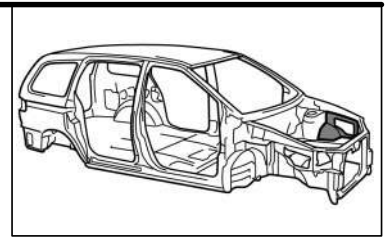
HINT:

- 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.
- For other sealing points, refer to section AR.

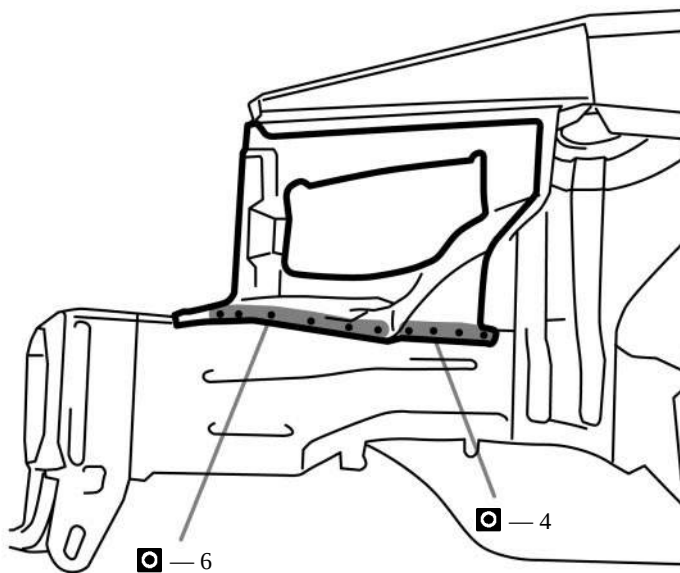
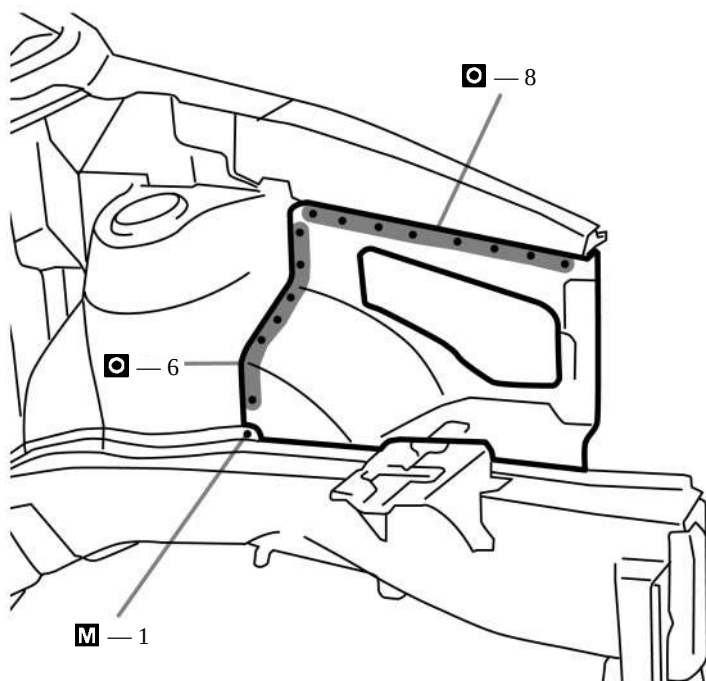
- Bend the flange hem about 30° with a hammer and dolly, then fasten tightly with a hemming tool.

HINT:

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

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

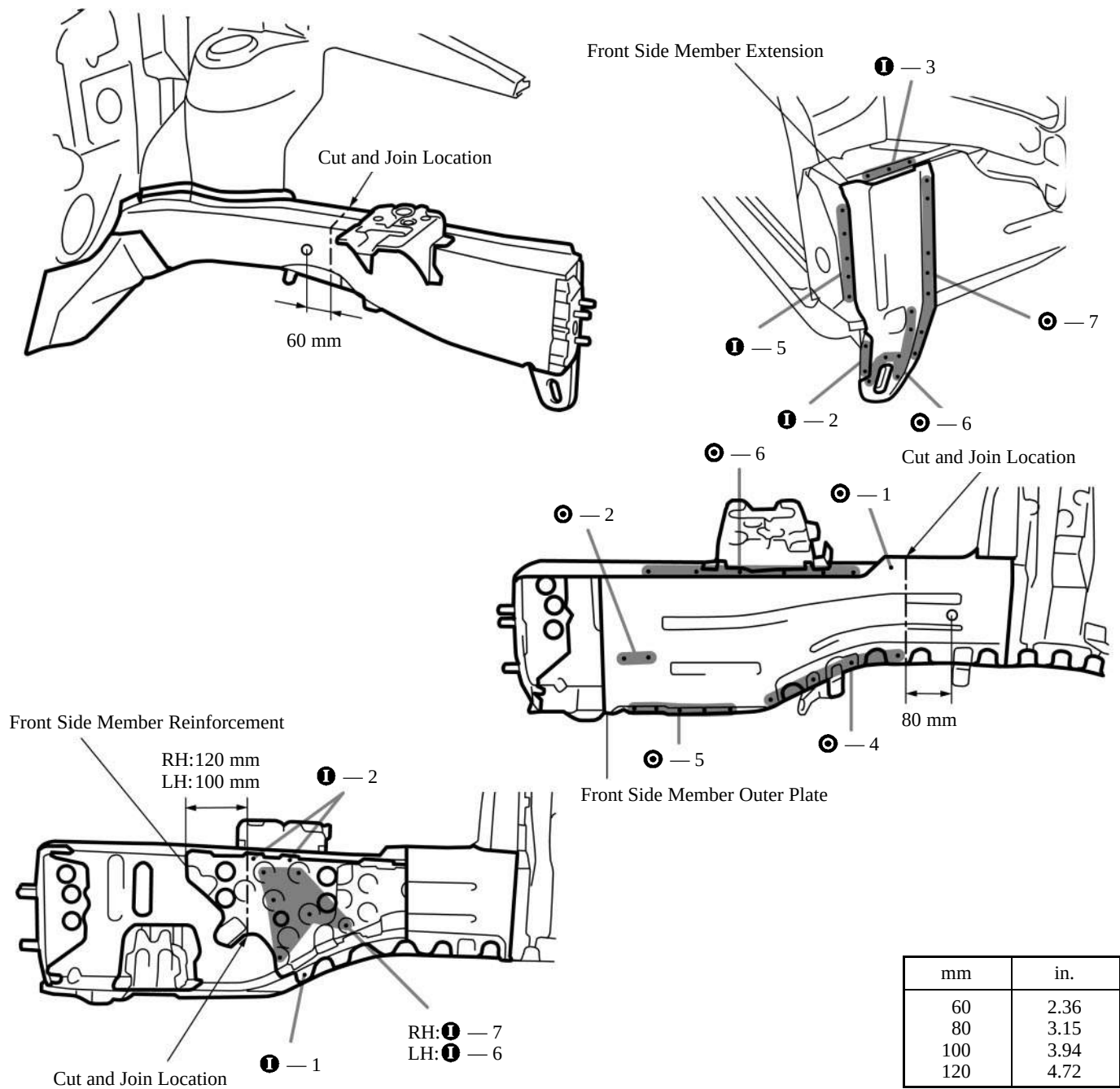
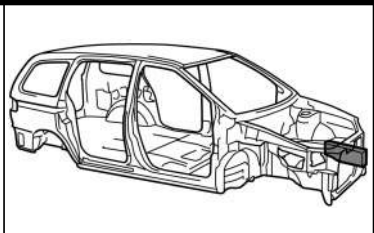
INSTALLATION



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

FRONT SIDE MEMBER (CUT-P)

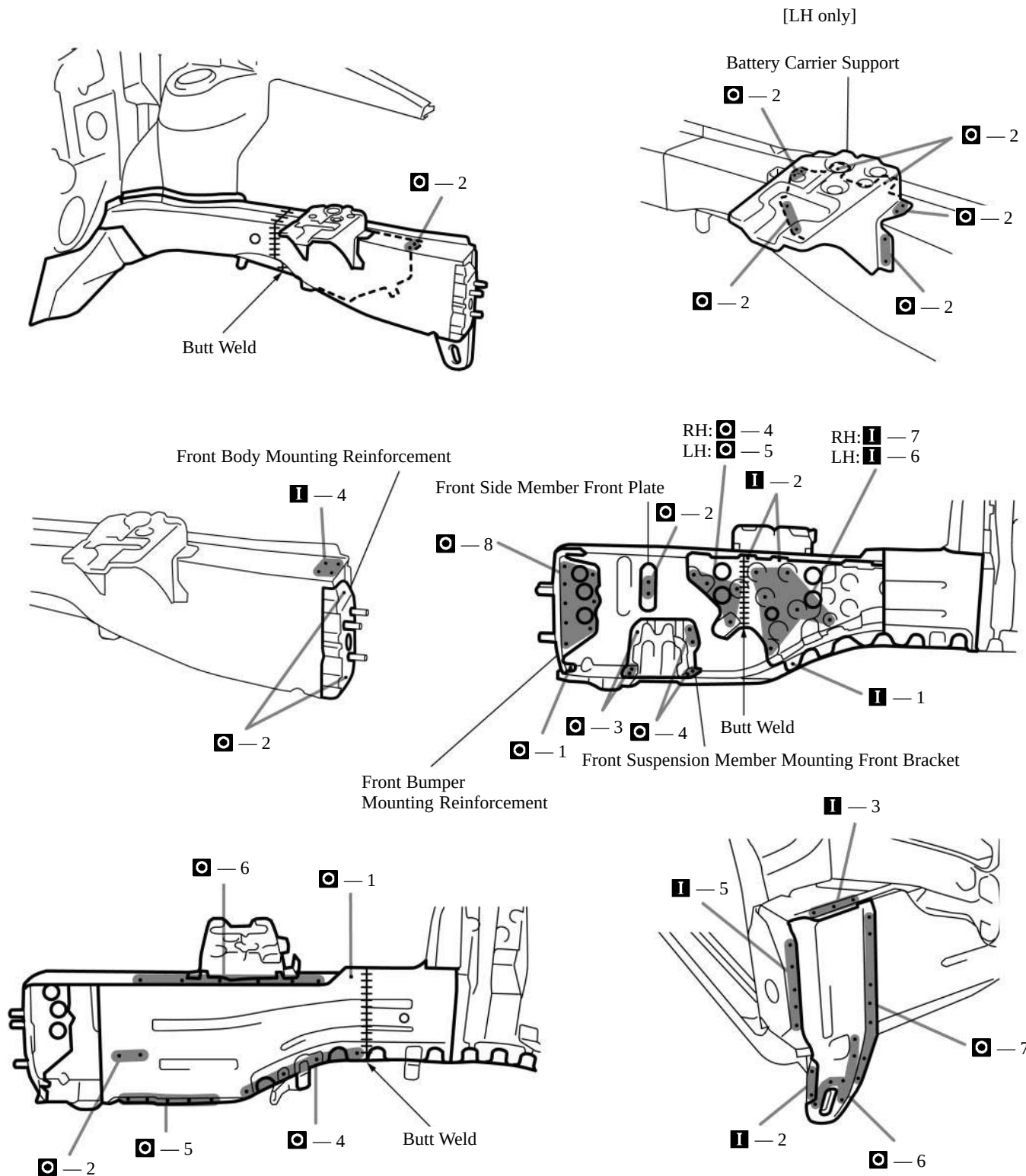
REMOVAL (With the front crossmember, front fender front apron removed.)



1. After removing the front side member outer plate and front side member extension, remove the front side member reinforcement.
2. Shift each cut and join locations of the front side outer member, front side inner member and front side member reinforcement.

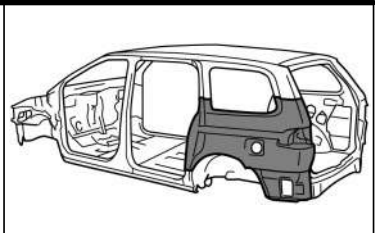
mm	in.
60	2.36
80	3.15
100	3.94
120	4.72

INSTALLATION

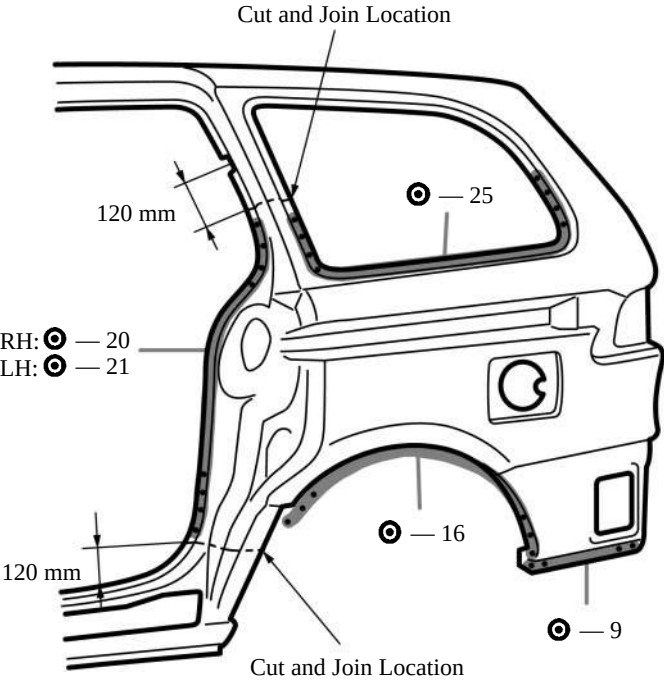


1. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.

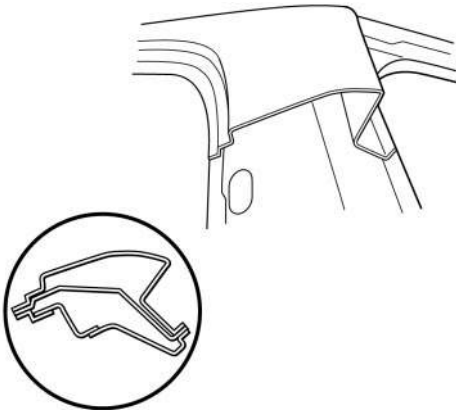
QUARTER PANEL (CUT): 4-Door Right Side, 5-Door



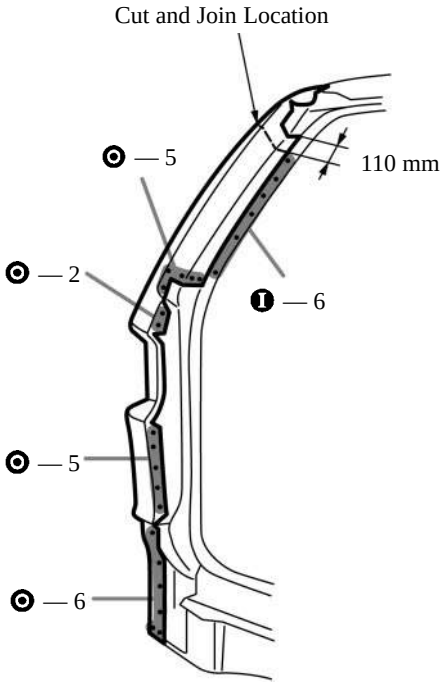
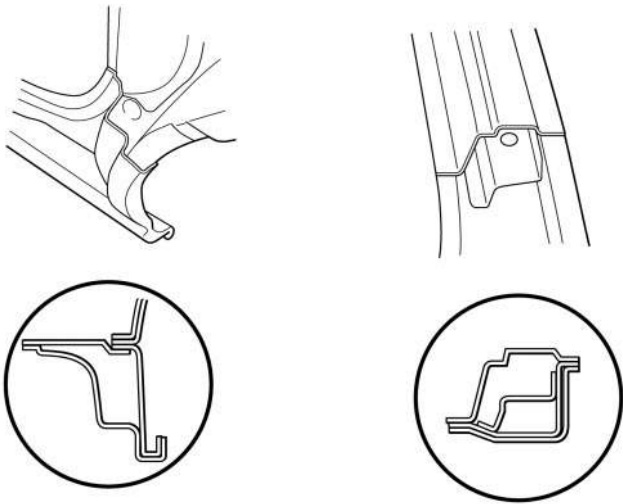
REMOVAL



[Cut and Join Location]



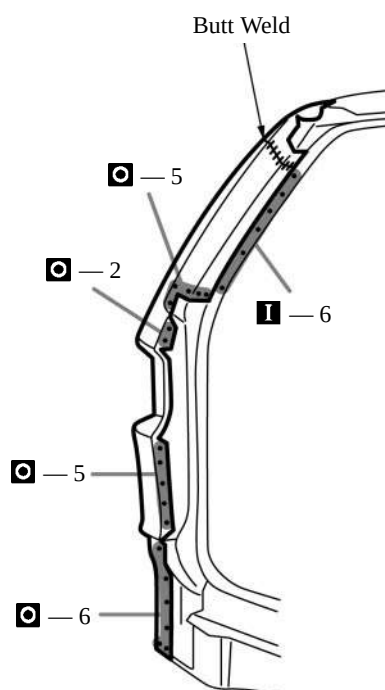
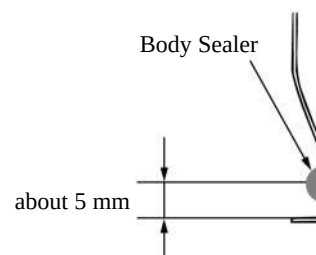
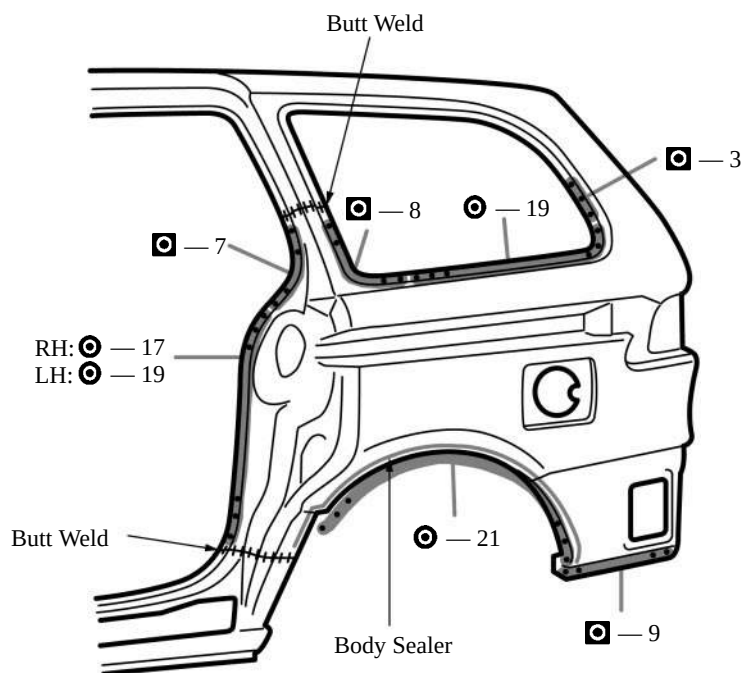
[Cut and Join Locations]



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

mm	in.
110	4.33
120	4.72

INSTALLATION

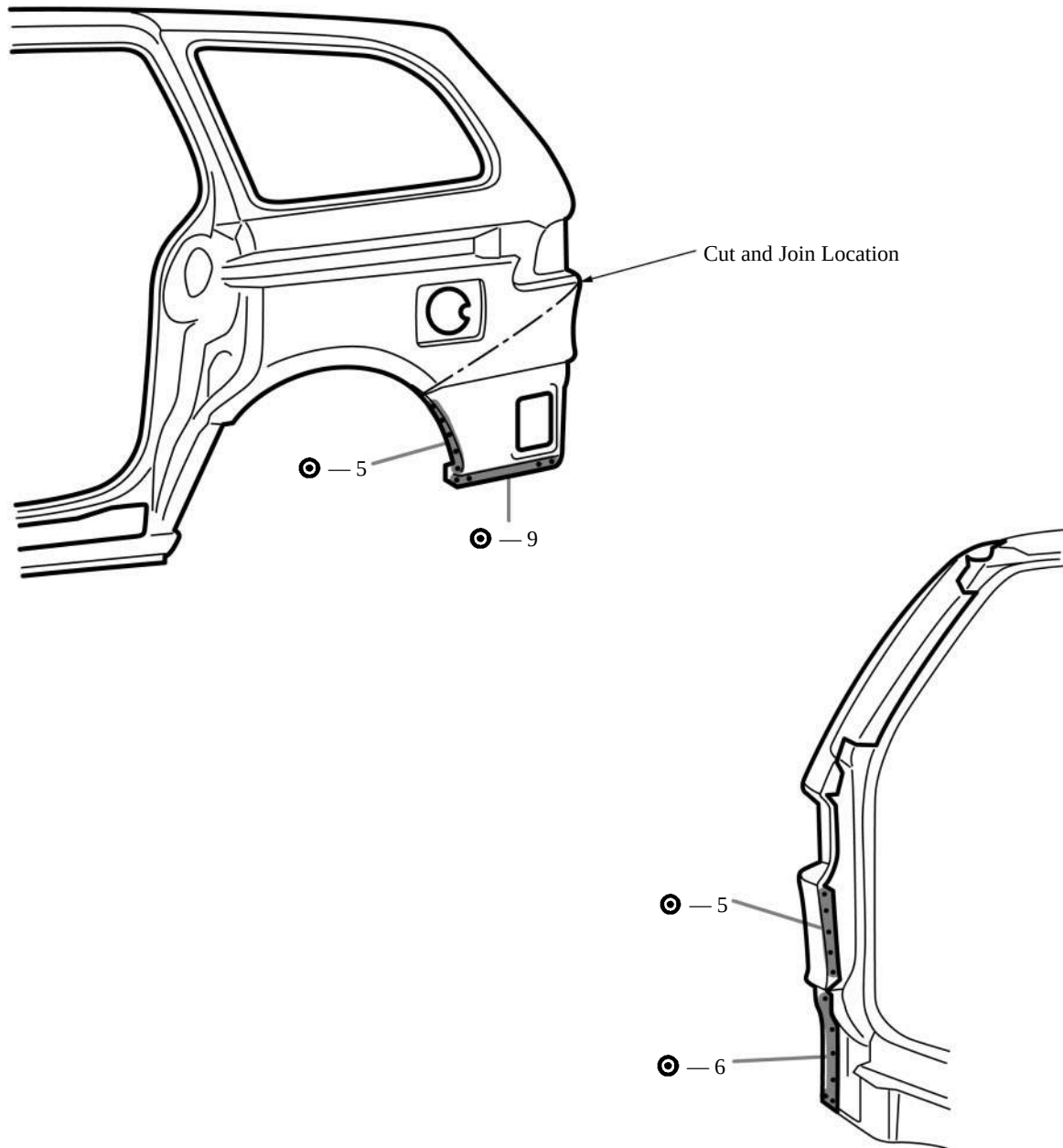
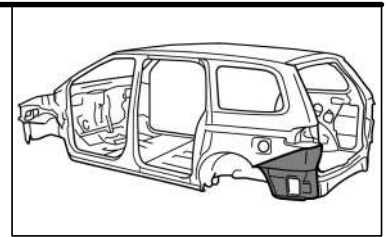


mm	in.
5	0.20

- Before temporarily installing the new parts, apply body sealer to the wheel arch.
- Temporarily installing the new parts, check the fit of the slide door, back door and rear combination light.

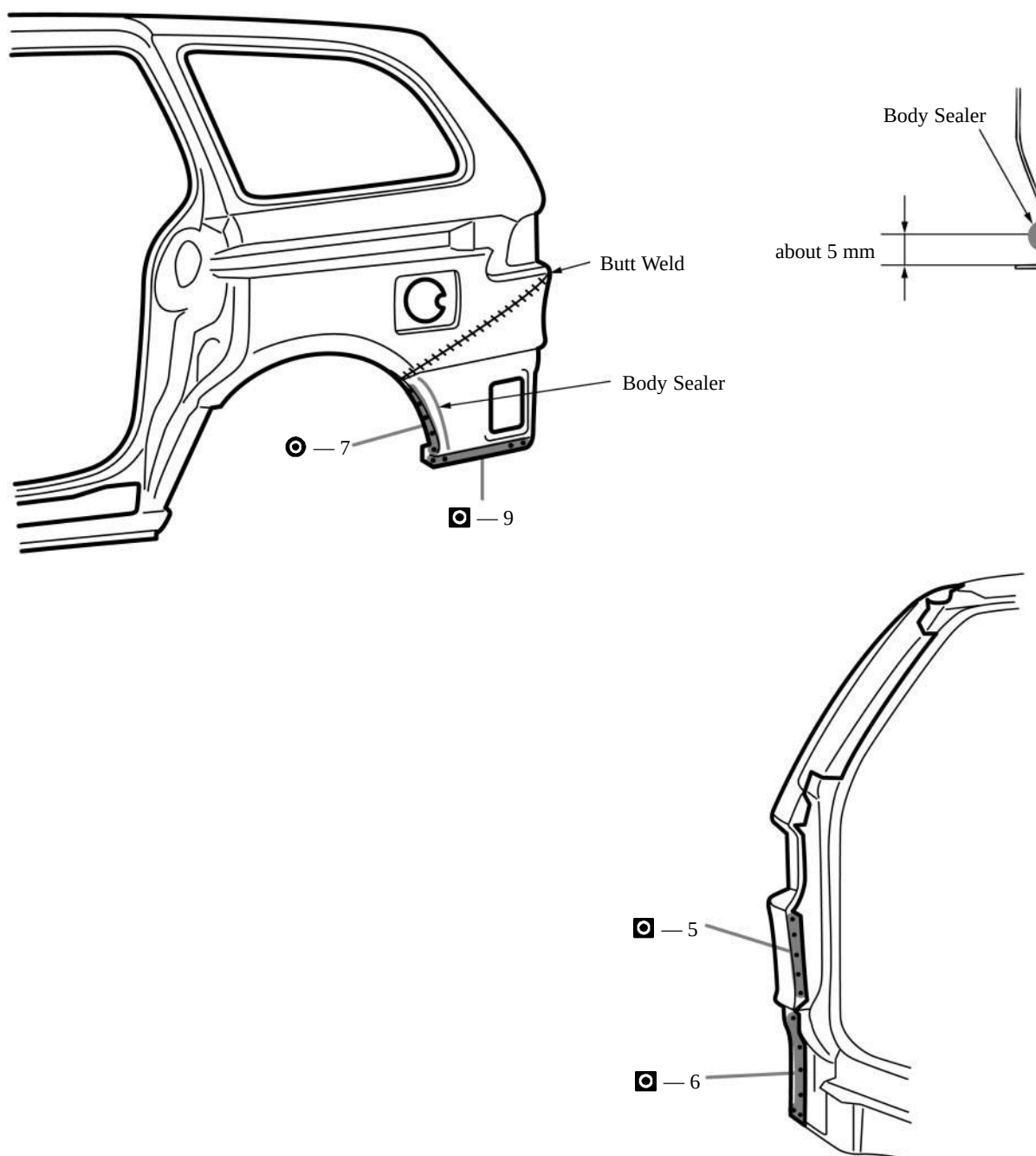
HINT:

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

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

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

INSTALLATION



mm	in.
5	0.20

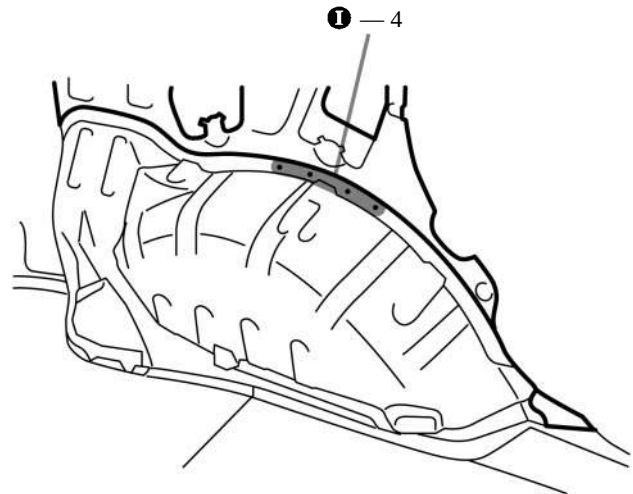
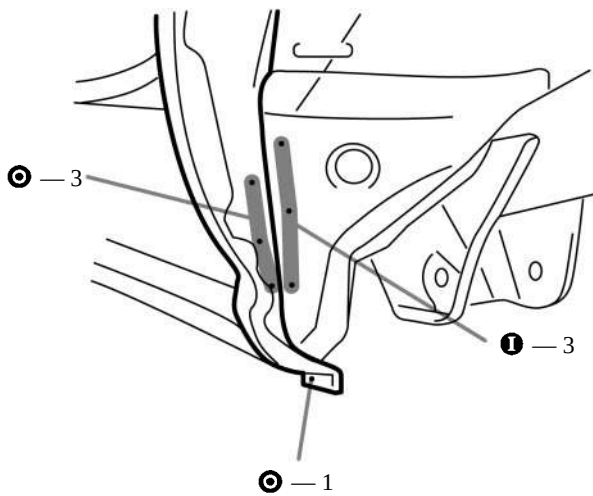
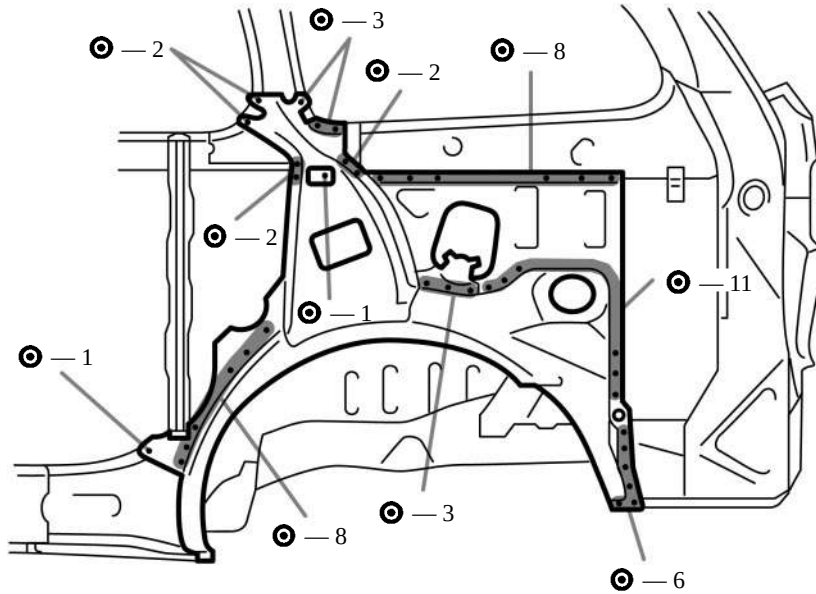
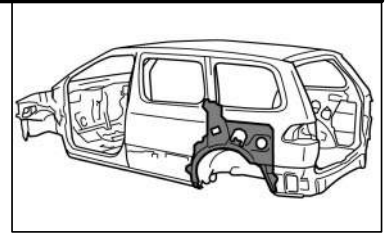
1. Before temporarily installing the new parts, apply body sealer to the wheel arch.
2. Temporarily installing the new parts, check the fit of the back door.

HINT:

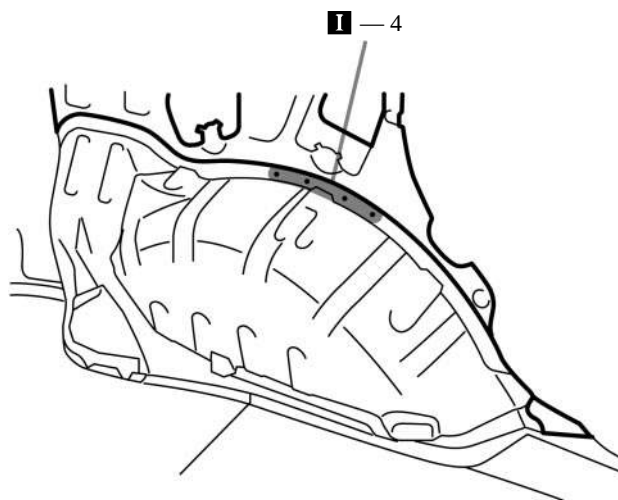
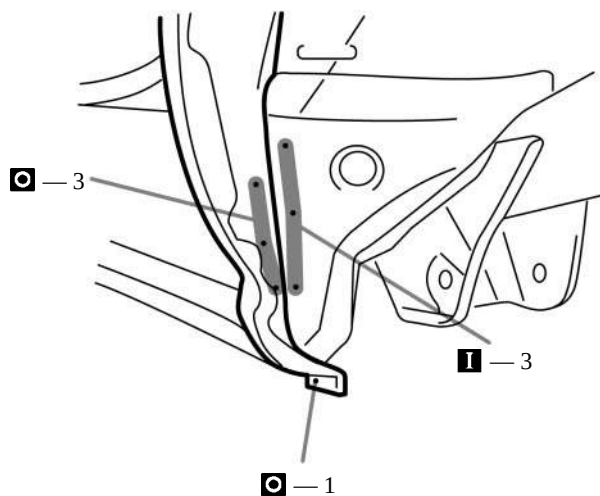
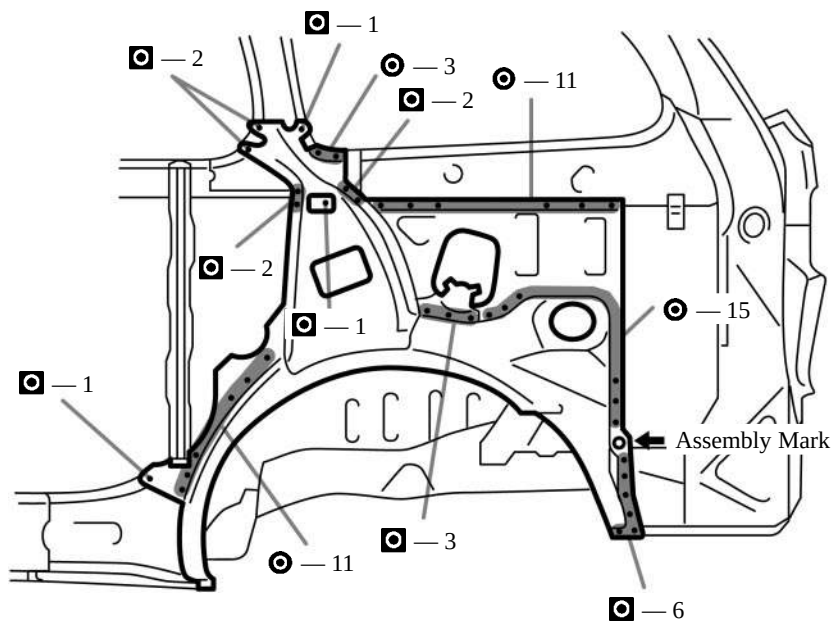
- 1) Apply body sealer about 5 mm (0.20 in.) from the flange, avoiding any oozing.
- 2) Apply sealer evenly, about 3 - 4 mm (0.12 - 0.16 in.) in diameter.
- 3) For other sealing points, refer to section AR.

QUARTER WHEEL HOUSING OUTER PANEL (ASSY): 4-Door Left Side

REMOVAL (With the quarter panel removed.)

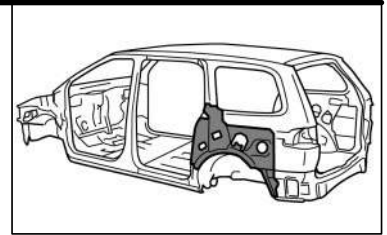


INSTALLATION

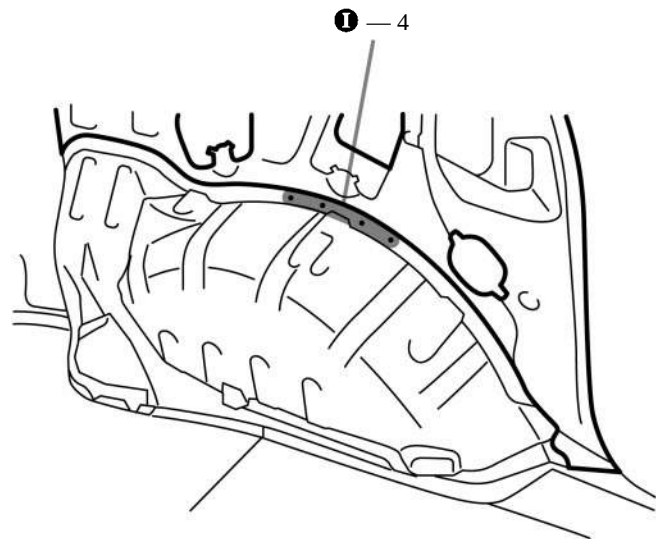
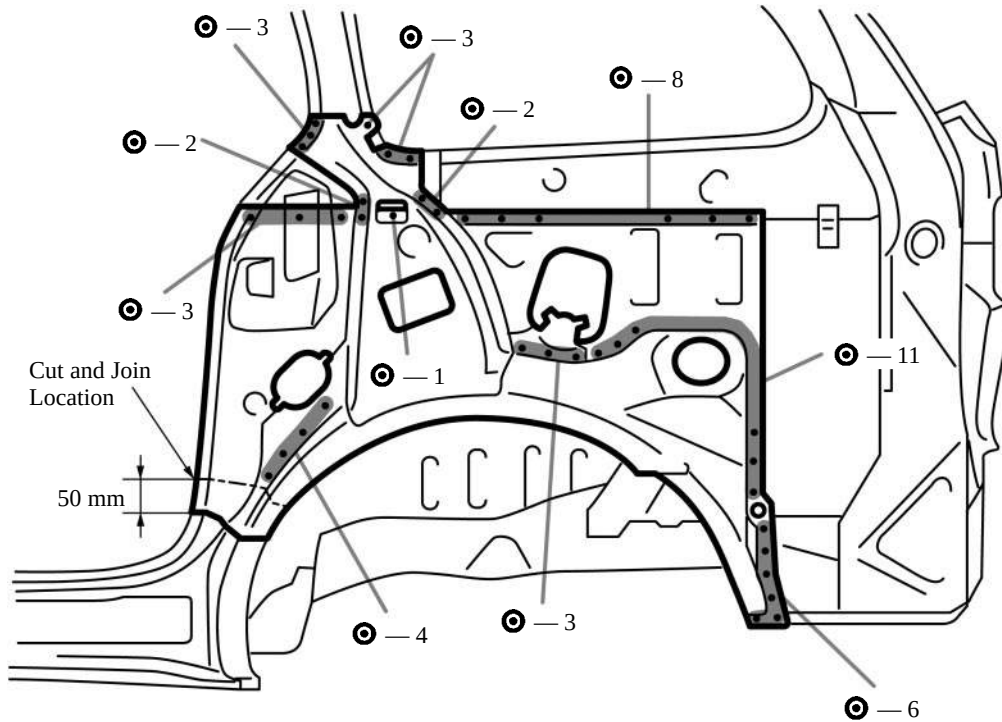


1. Determine the position of the new parts by the assembly marks of the inner and outer panels.
2. Before welding the new parts, temporarily install the quarter panel and check the fit.

QUARTER WHEEL HOUSING OUTER PANEL (CUT): 5-Door Left Side



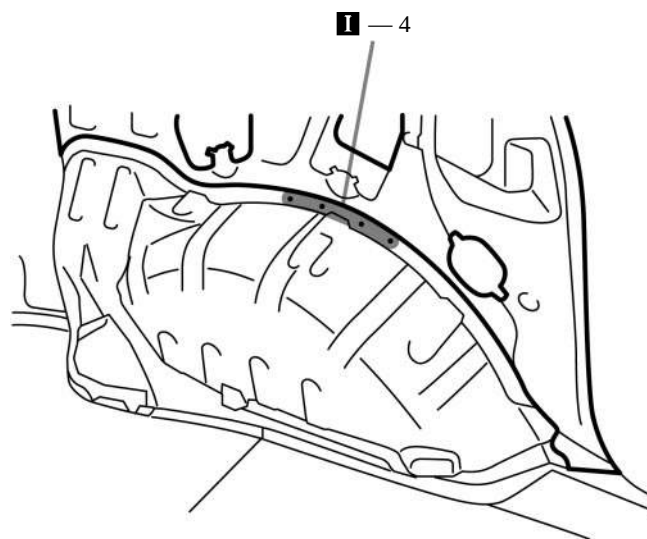
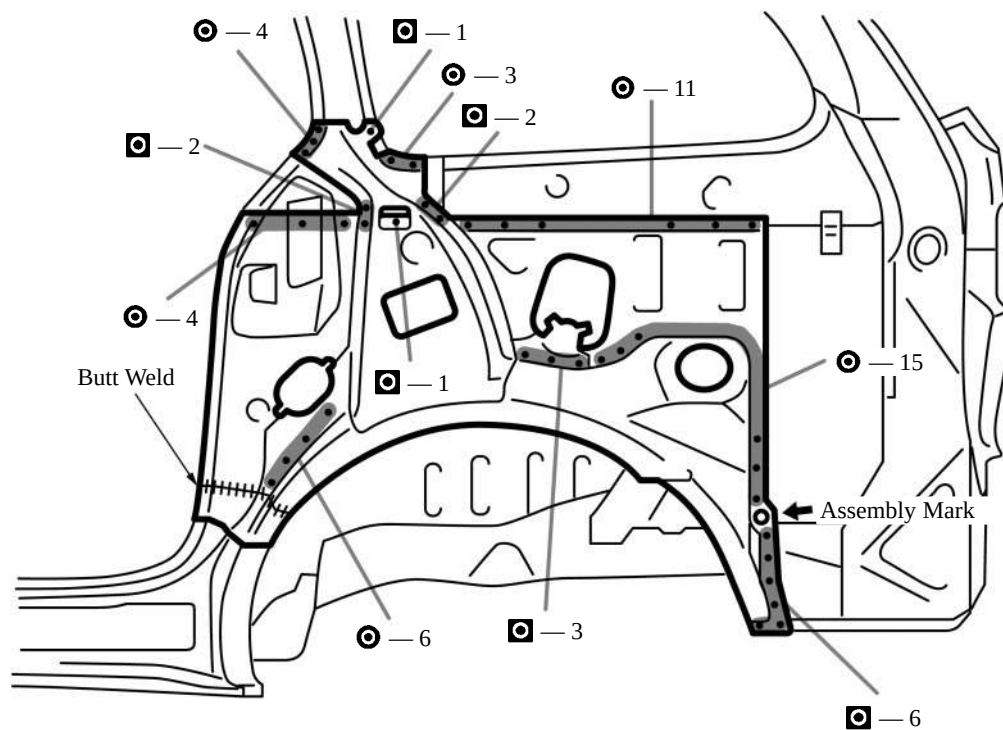
REMOVAL (With the quarter panel removed.)



mm	in.
50	1.97

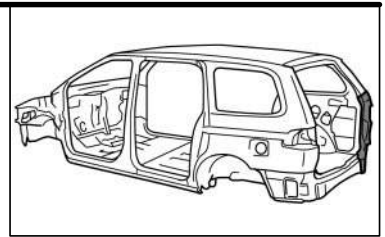
1. Cut and join the parts at the location as shown above.

INSTALLATION

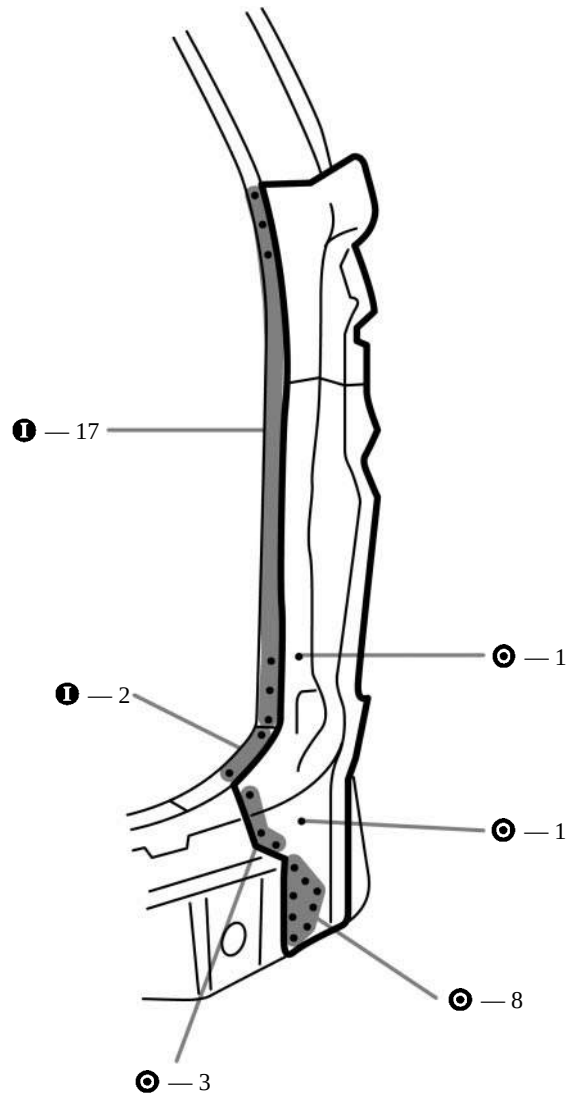


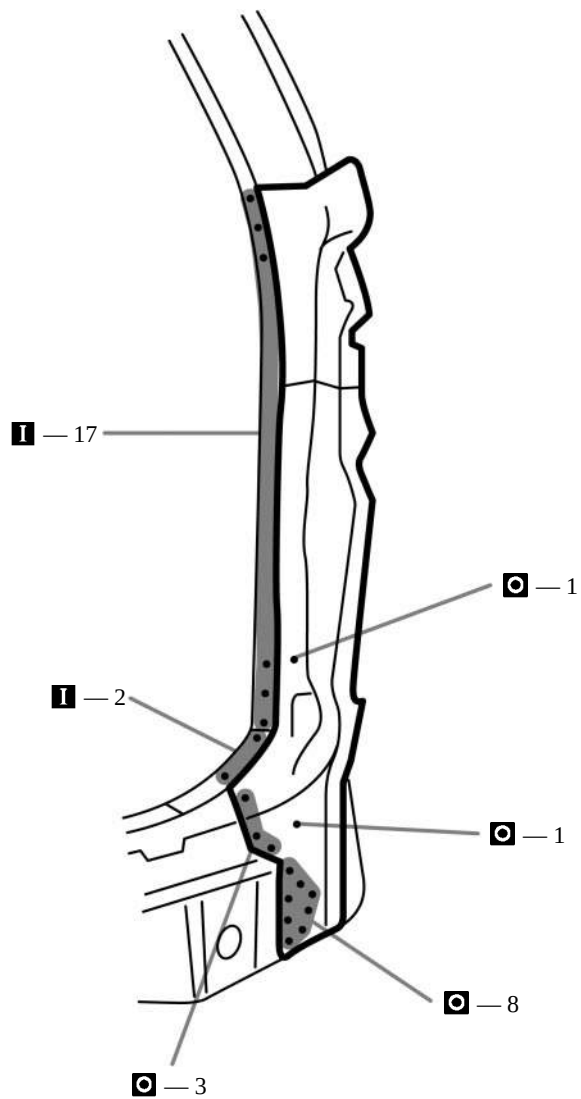
1. Determine the position of the new parts by the assembly marks of the inner and outer panels.
2. Before welding the new parts, temporarily install the quarter panel and check the fit.

QUARTER PANEL REAR LOWER EXTENSION (ASSY)



REMOVAL (With the quarter panel removed.)

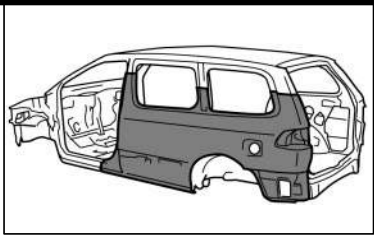
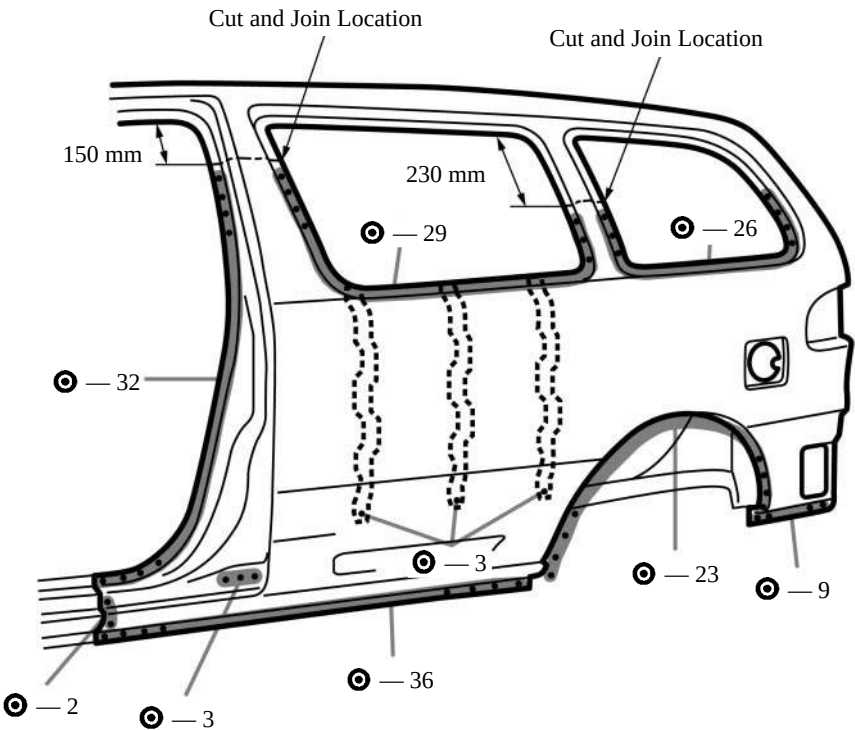


INSTALLATION

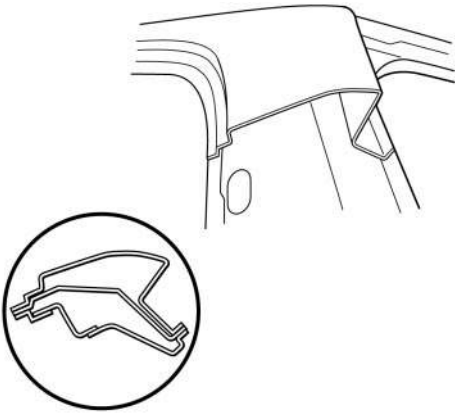
1. Before welding the new parts, temporarily install the quarter panel and check the fit.

QUARTER PANEL (CUT): 4-Door Left Side

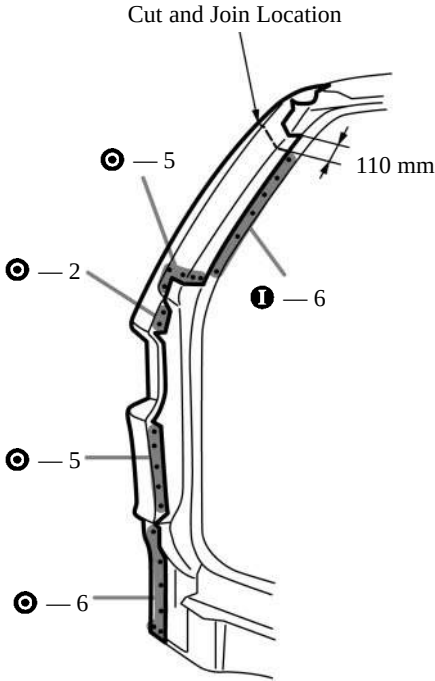
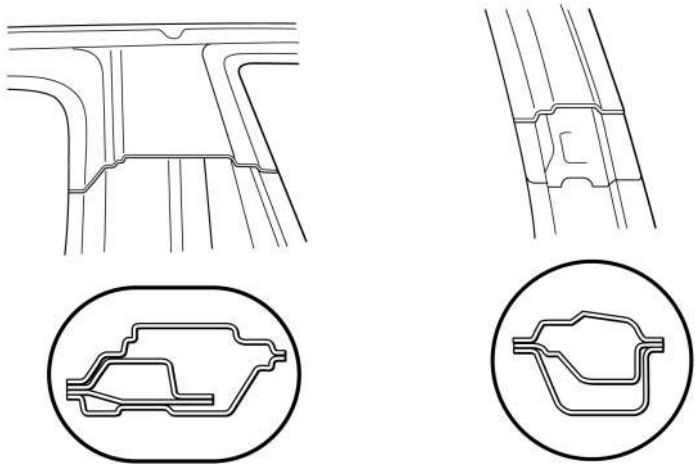
REMOVAL



[Cut and Join Location]



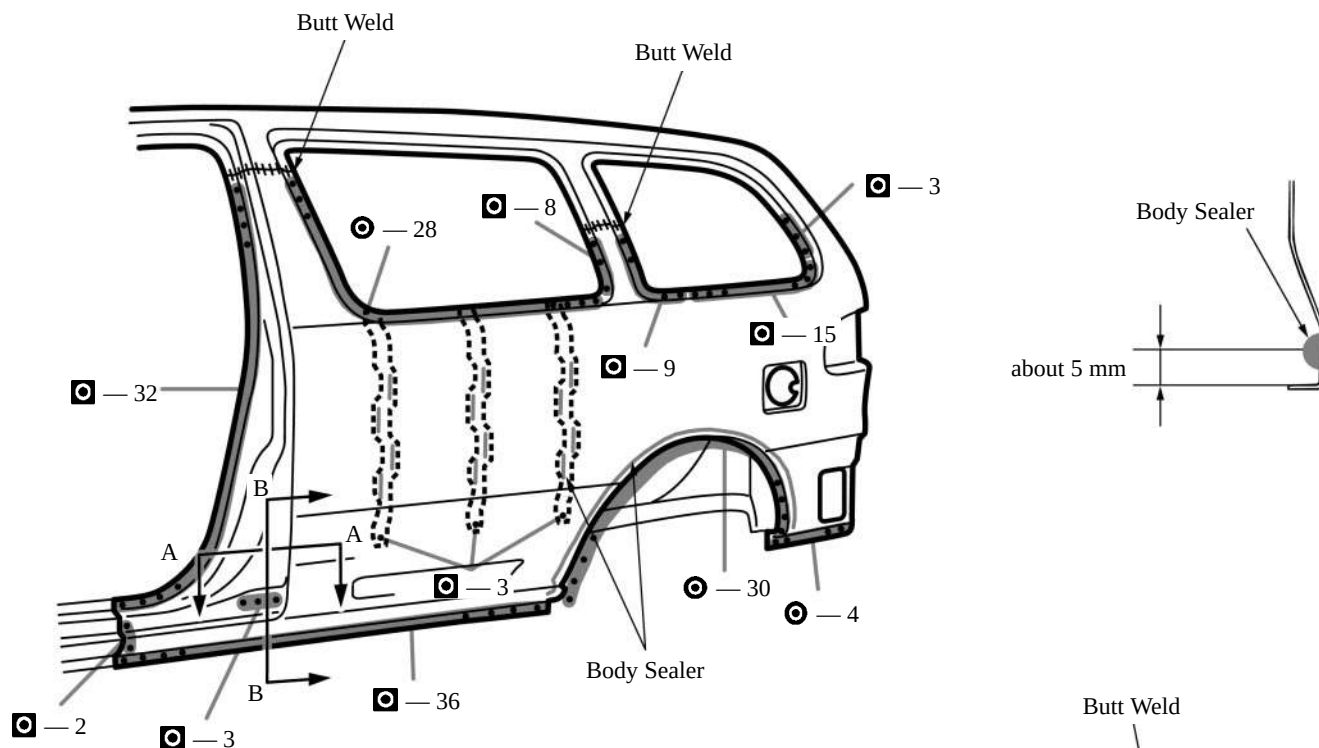
[Cut and Join Locations]



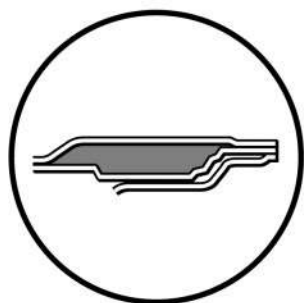
mm	in.
110	4.33
150	5.91
230	9.06

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

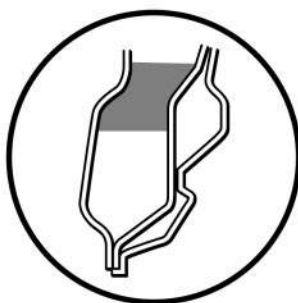
INSTALLATION



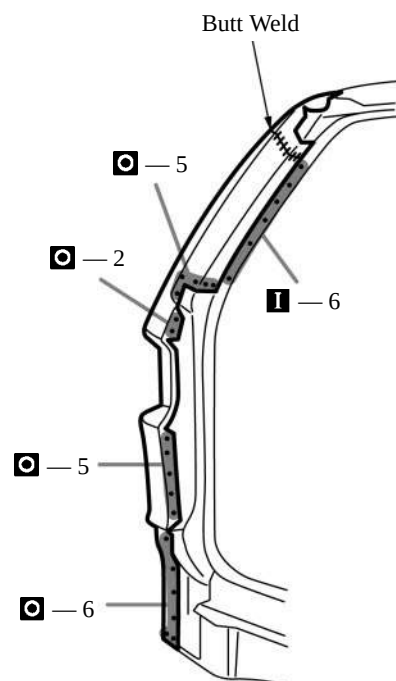
[Foamed Material Application Areas]



A - A



B - B

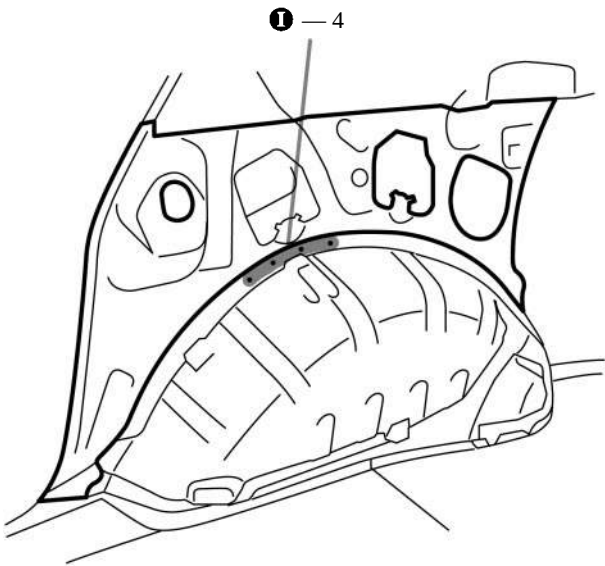
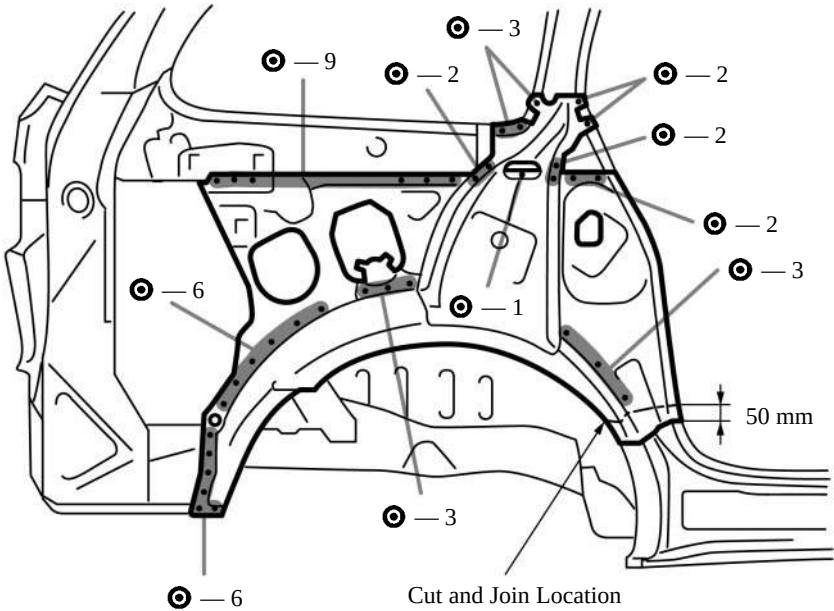
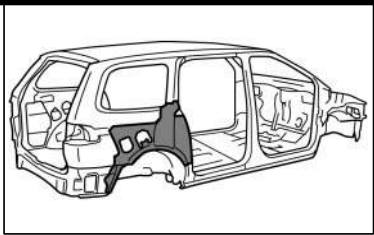


mm	in.
5	0.20

- Before temporarily installing the new parts, apply body sealer to the wheel arch.
 - Temporarily install the new parts and check the fit of the front door, back door and rear combination light.
 - After installing the newparts, apply foamed material.
- HINT:**
- Apply body sealer about 5 mm (0.20 in.) from the flange, avoiding any oozing.
 - Apply sealer evenly, about 3 - 4 mm (0.12 - 0.16 in.) in diameter.
 - For other sealing points, refer to Section AR.

QUARTER WHEEL HOUSING OUTER PANEL (CUT): Right Side

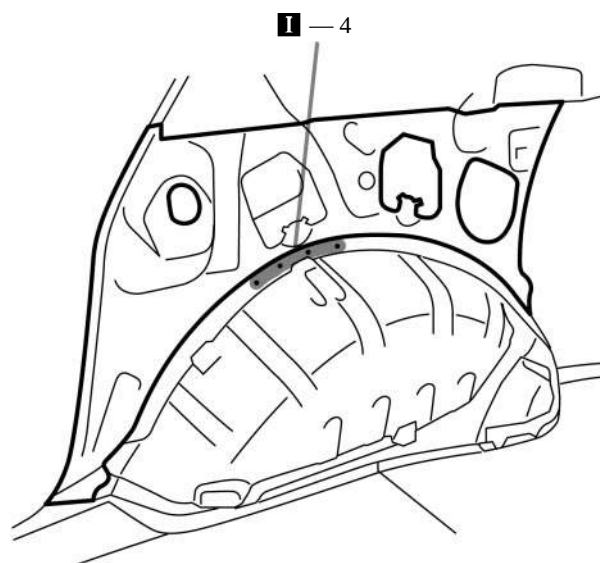
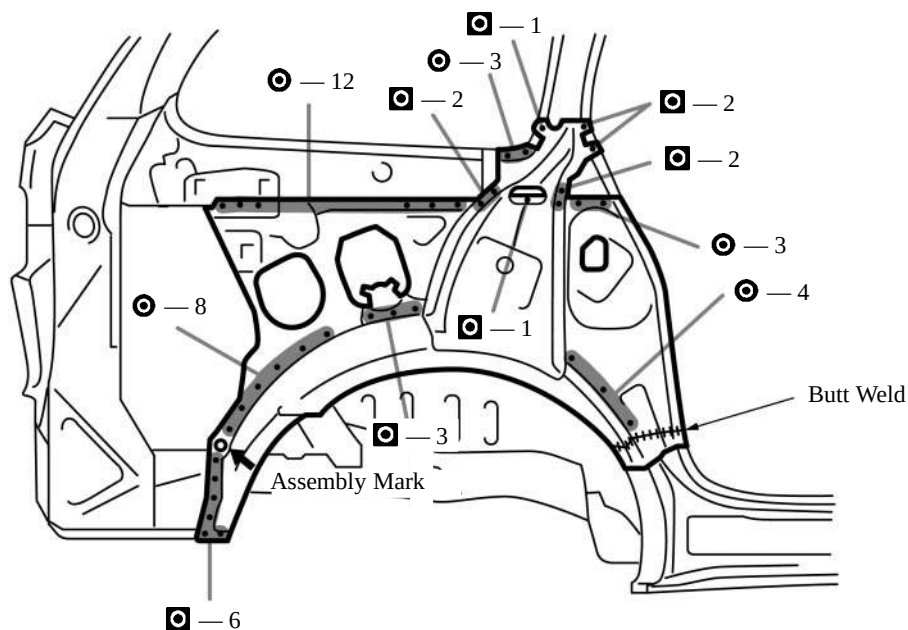
REMOVAL (With the quarter panel removed.)



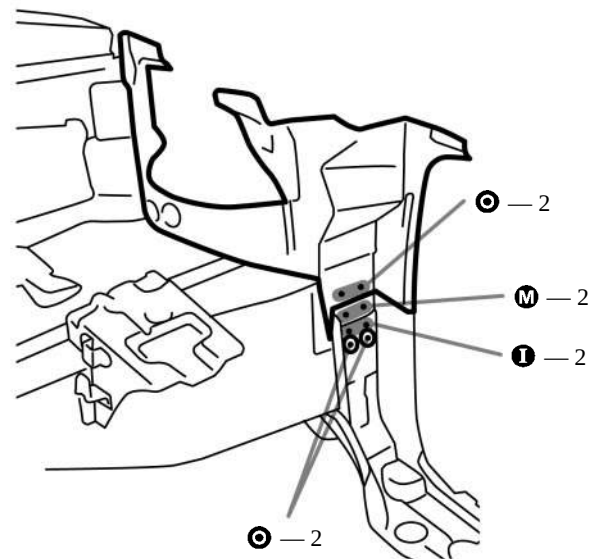
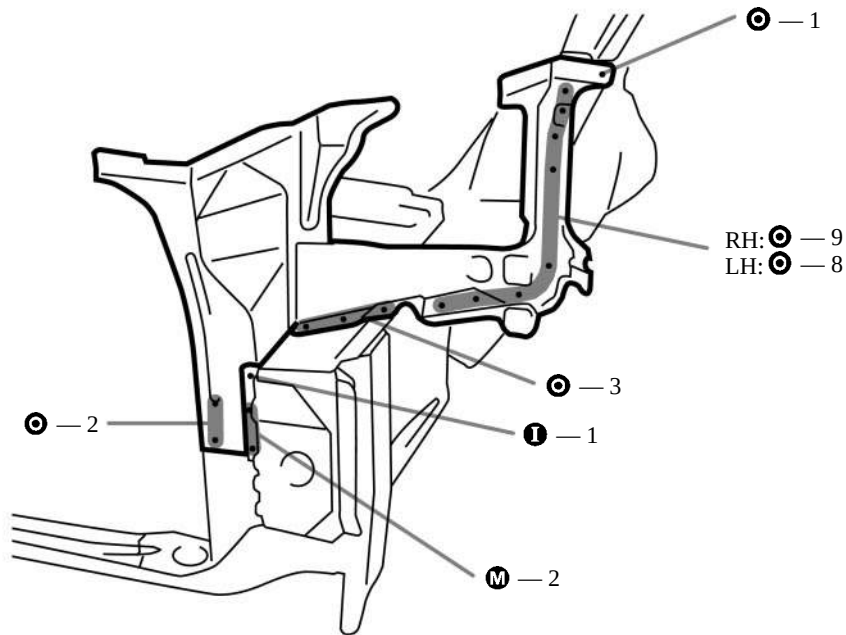
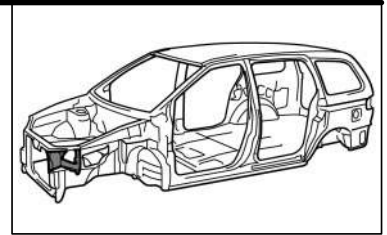
mm	in.
50	1.97

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

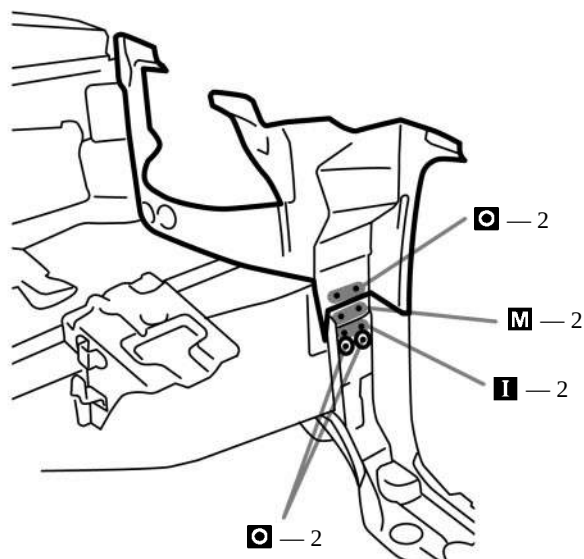
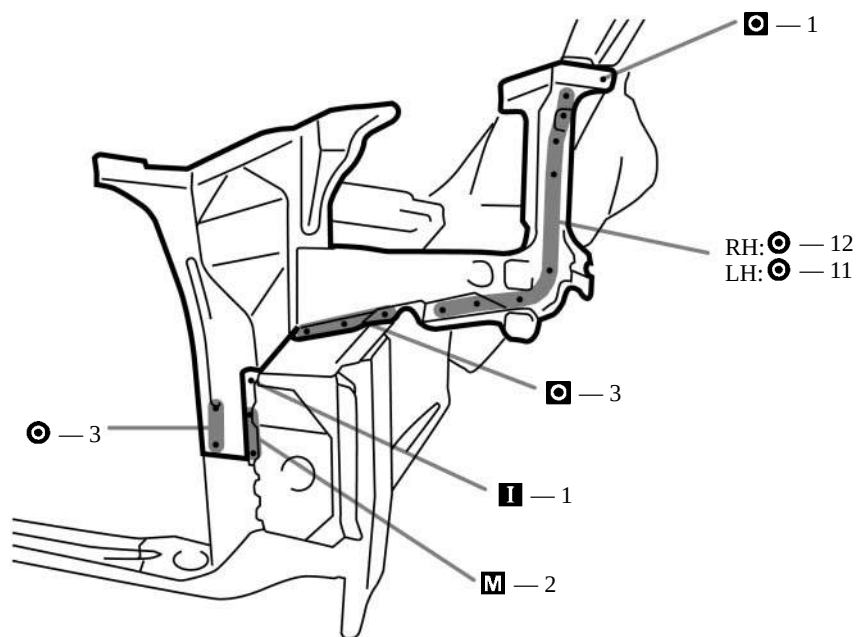
INSTALLATION



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.

RADIATOR SIDE SUPPORT (ASSY)**REMOVAL (With the radiator upper support removed.)**

INSTALLATION

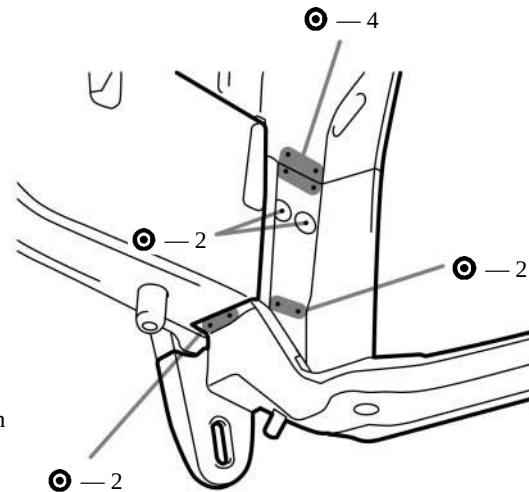
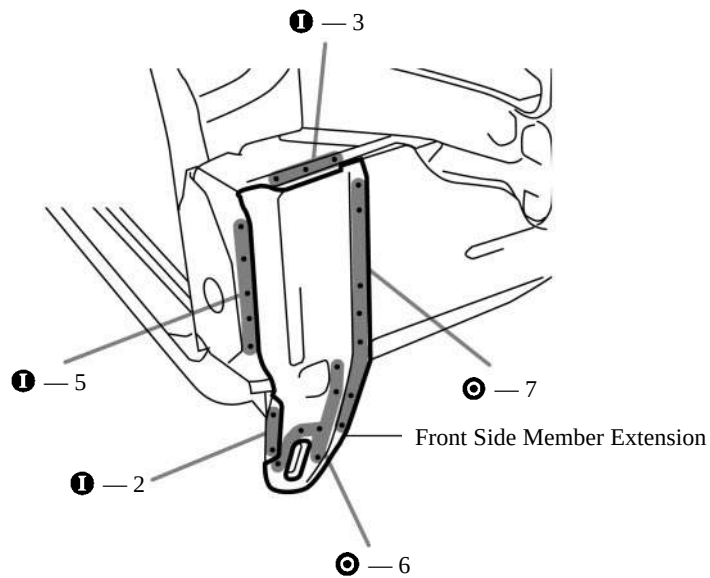
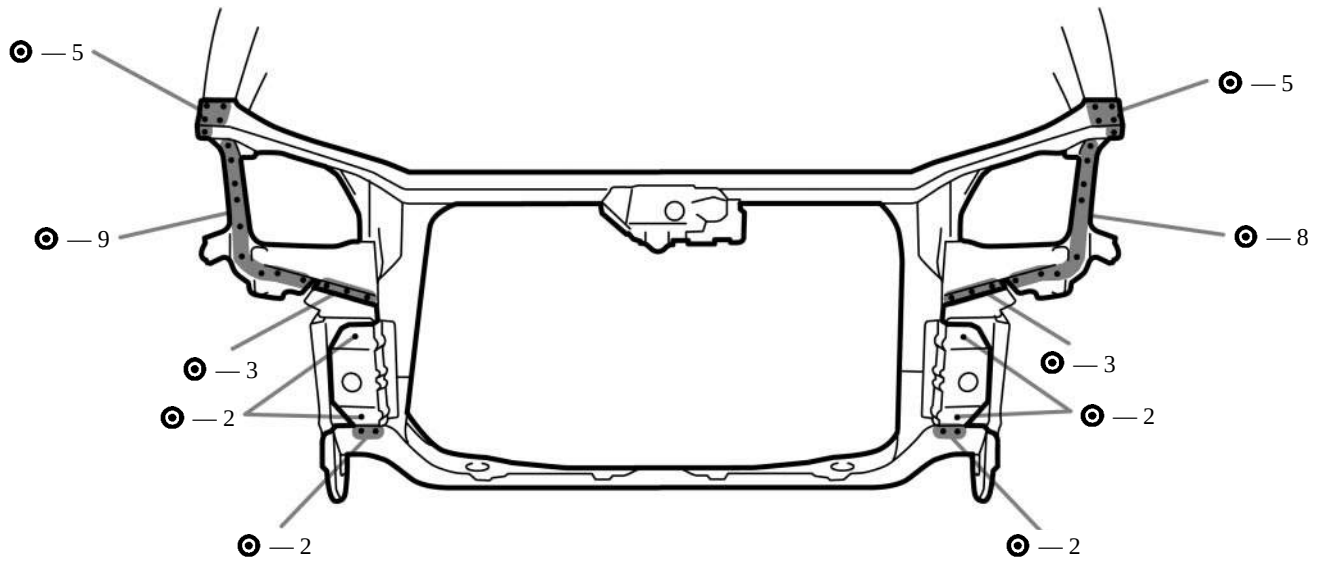
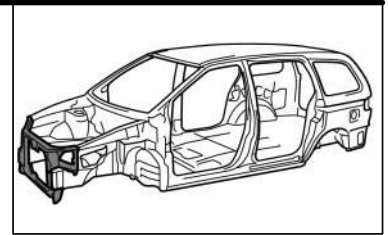


1. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.

HINT: First install the radiator upper support.

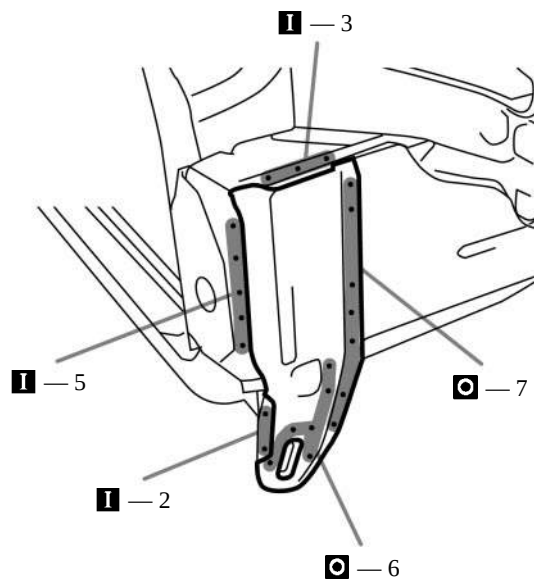
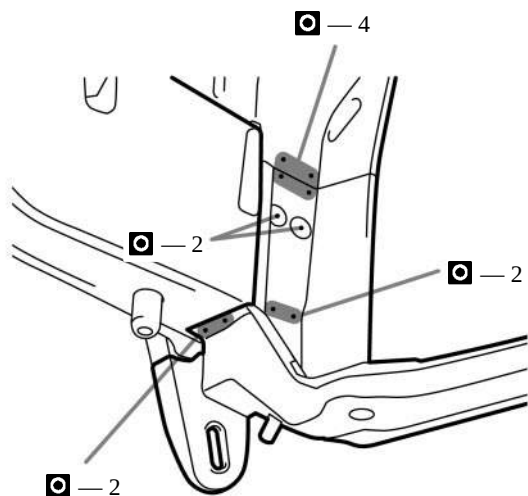
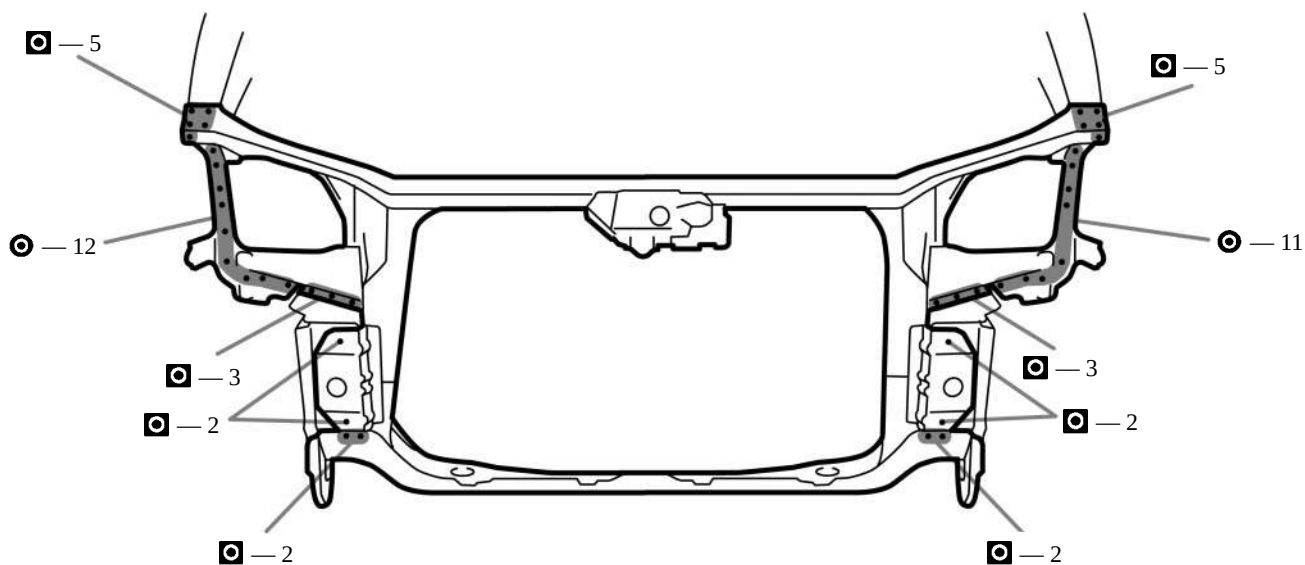
RADIATOR SUPPORT (ASSY)

REMOVAL

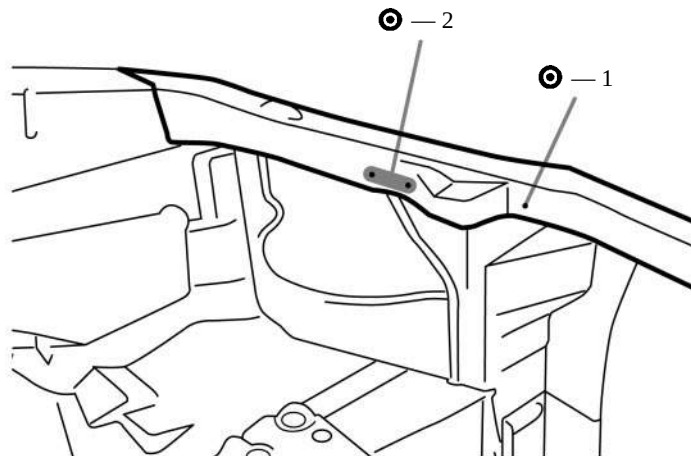
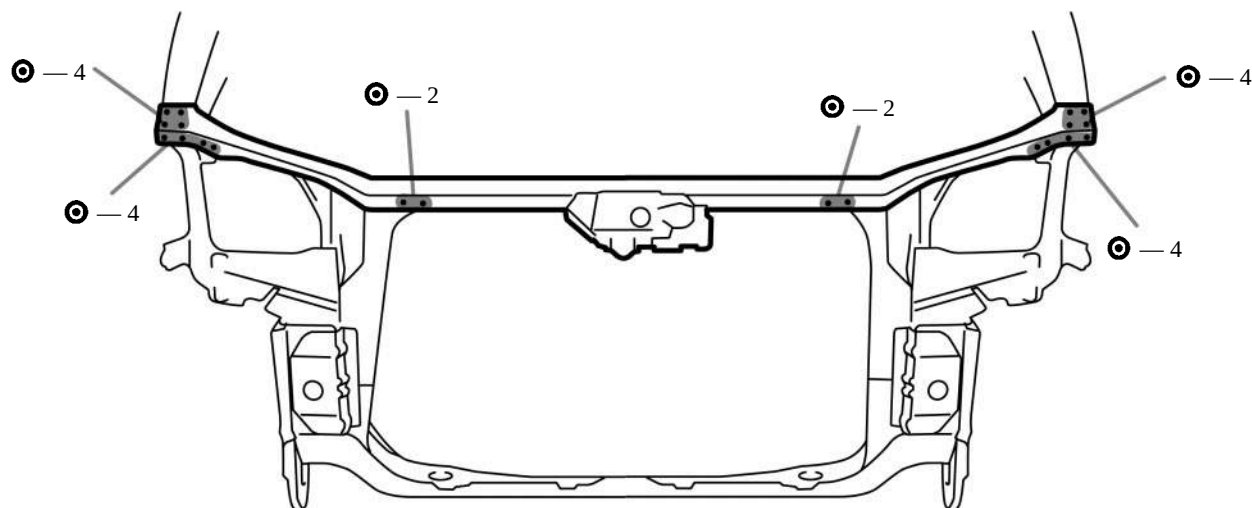
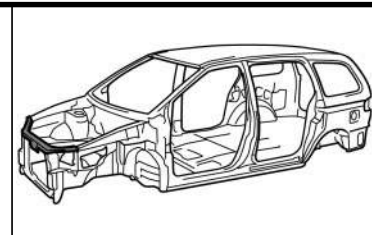


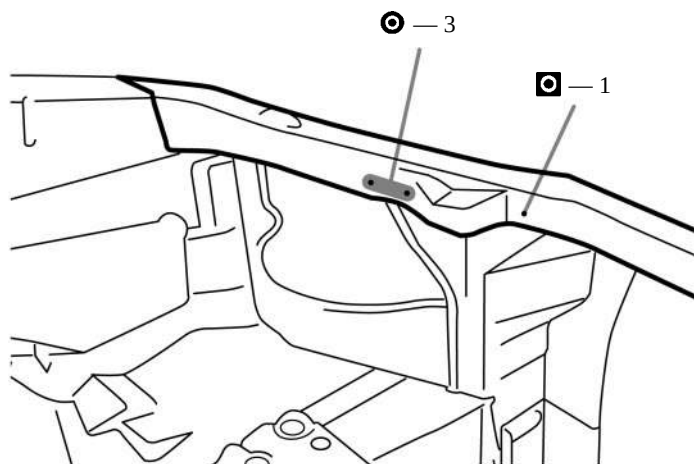
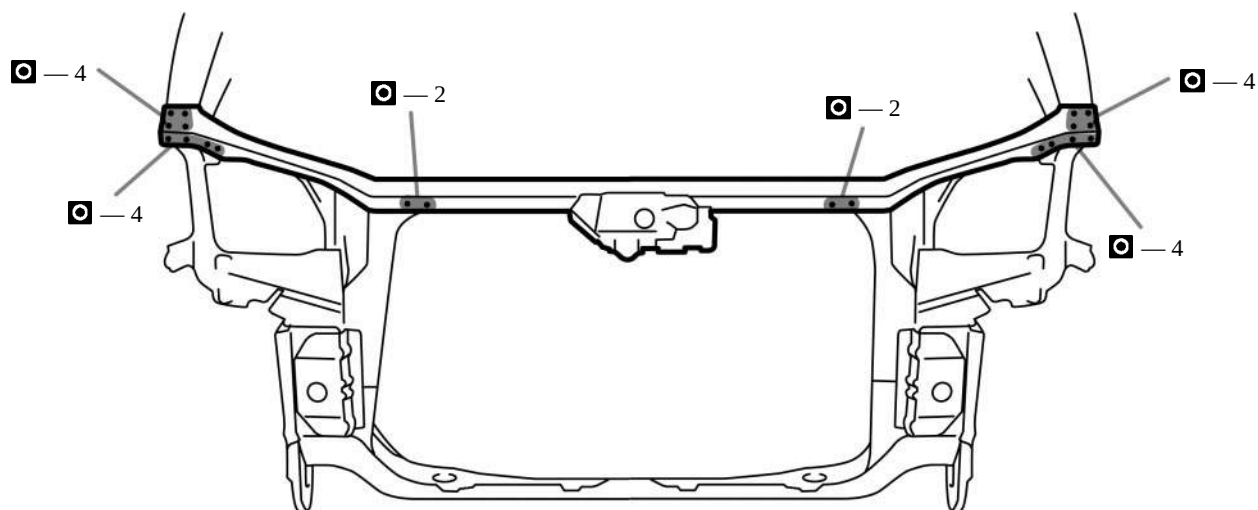
1. After removing the front side member extension, remove the radiator support.

INSTALLATION



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

RADIATOR UPPER SUPPORT (ASSY)**REMOVAL**

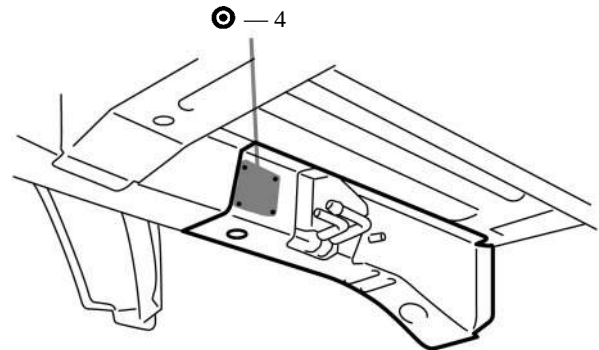
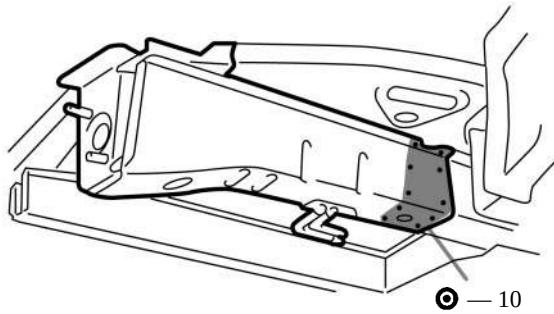
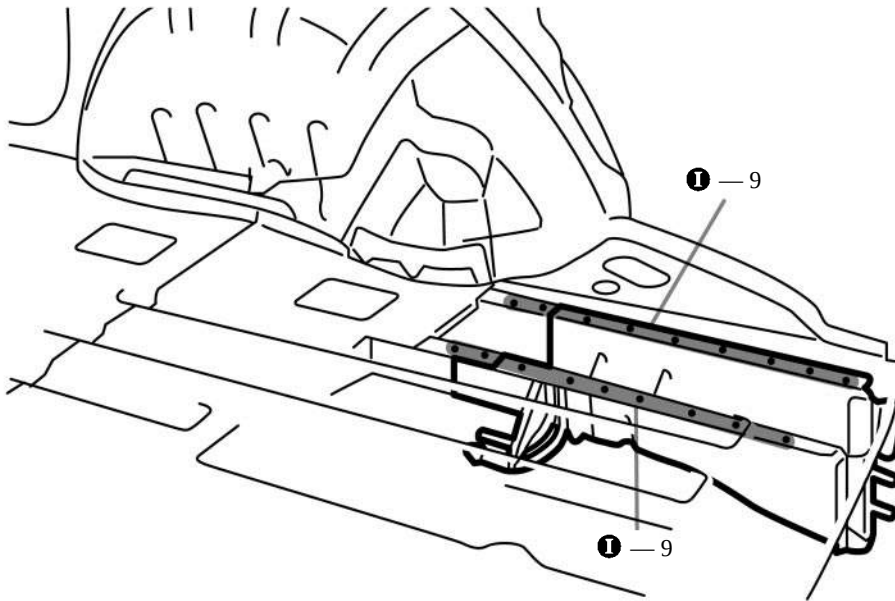
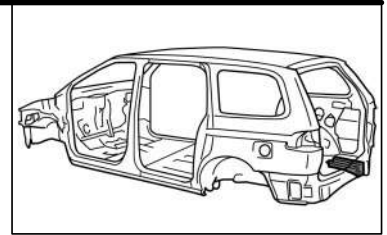
INSTALLATION

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

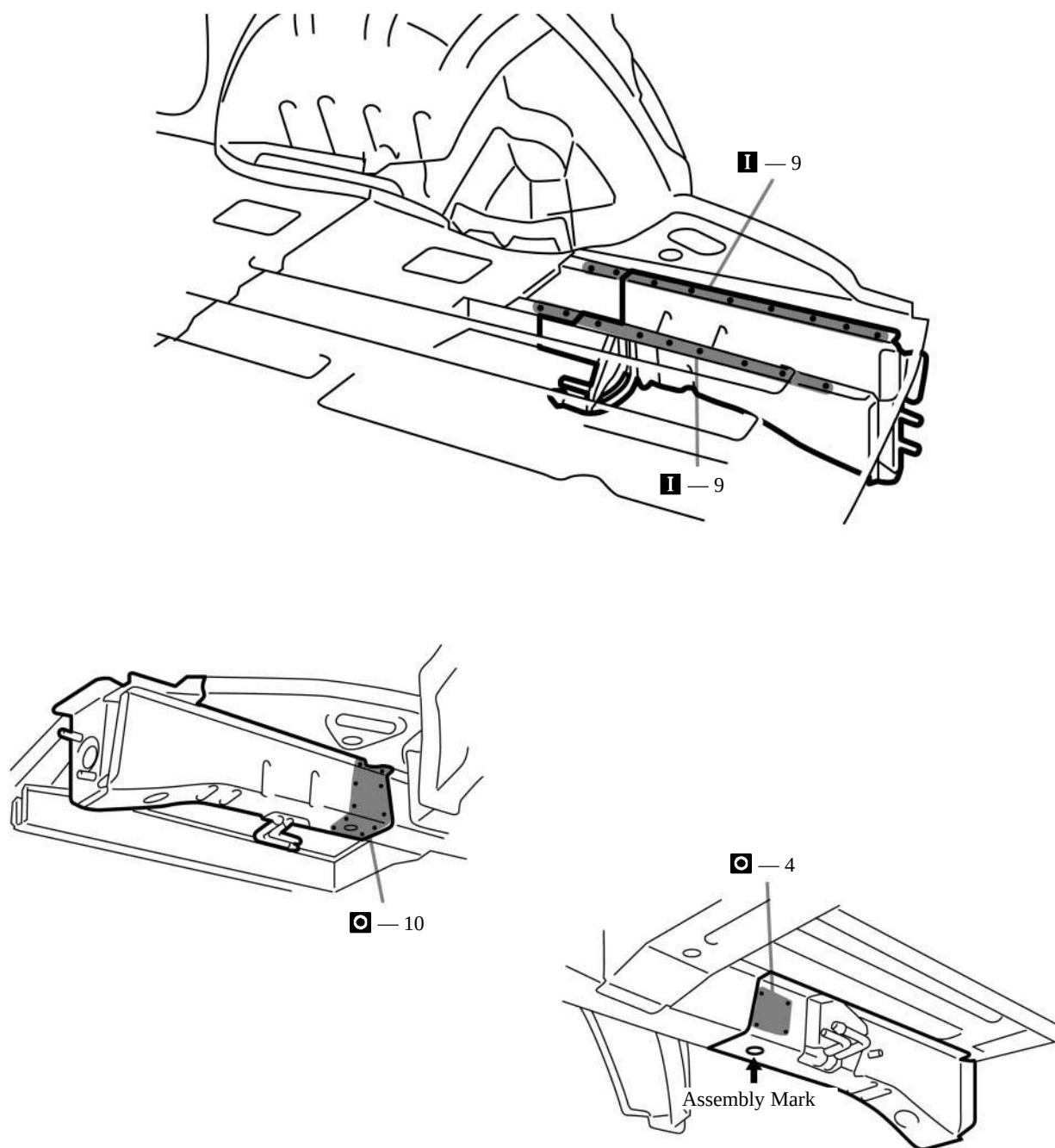
HINT: First install the hood lock support.

REAR FLOOR SIDE REAR MEMBER (ASSY)

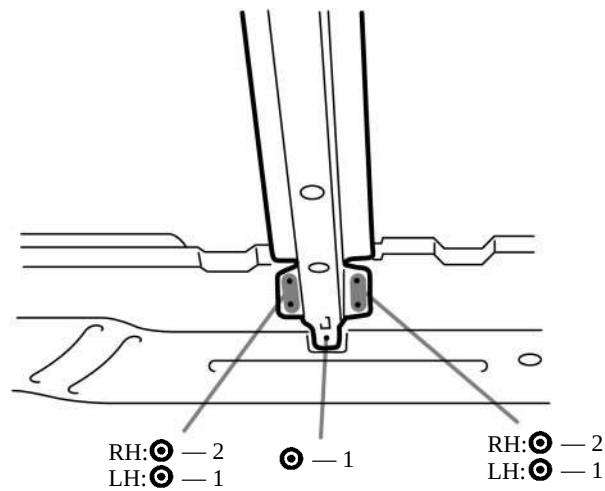
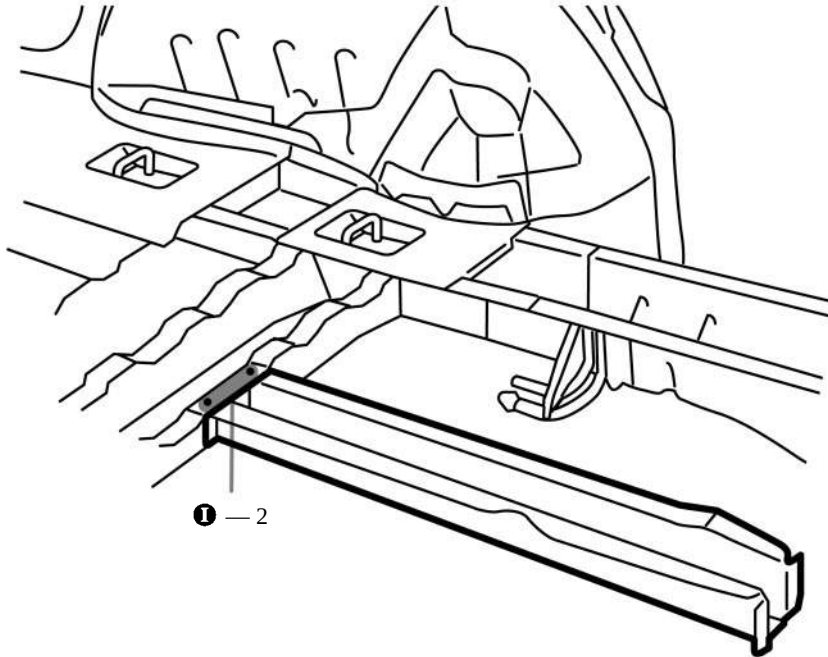
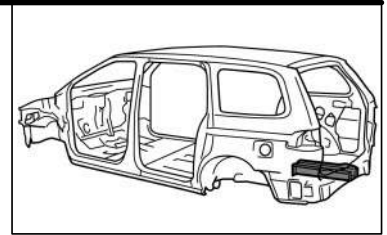
REMOVAL (With the roof side inner panel, rear floor No.6 crossmember removed.)



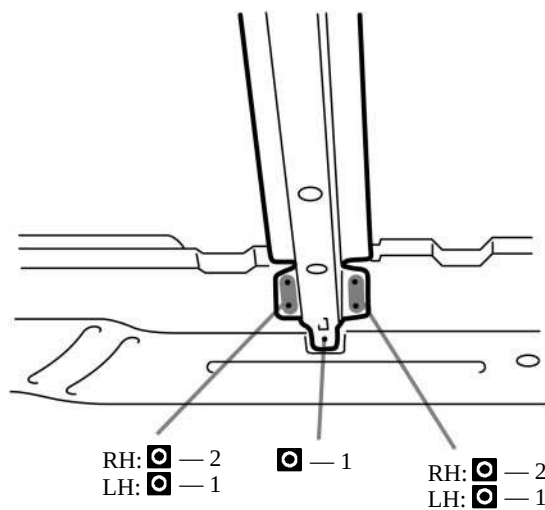
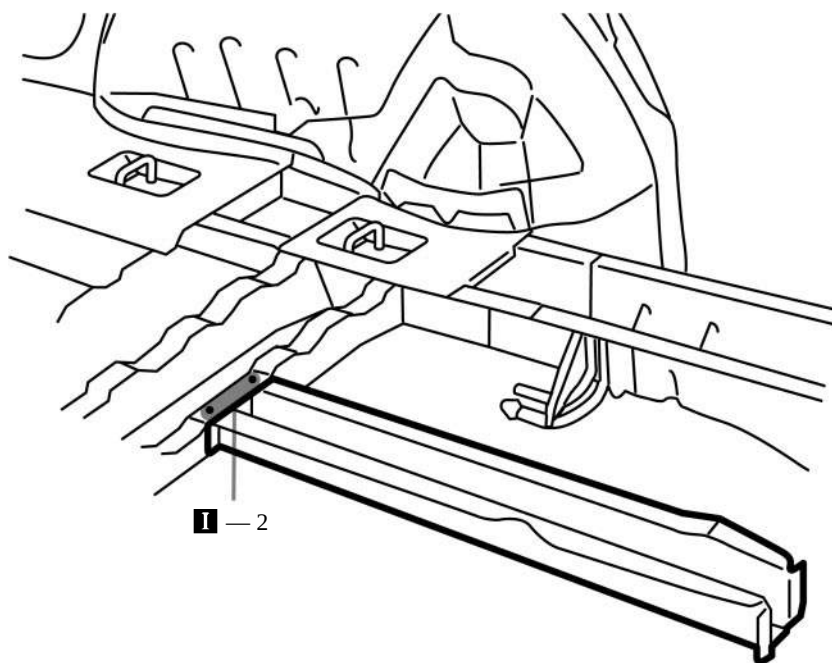
INSTALLATION

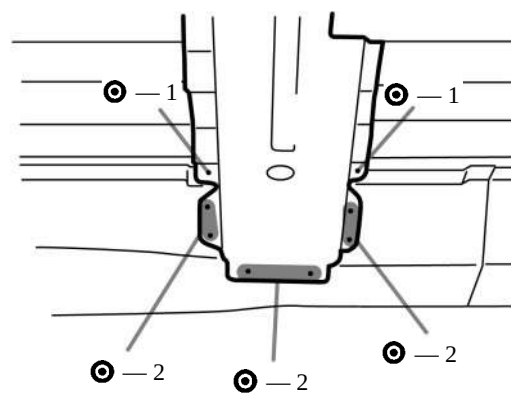
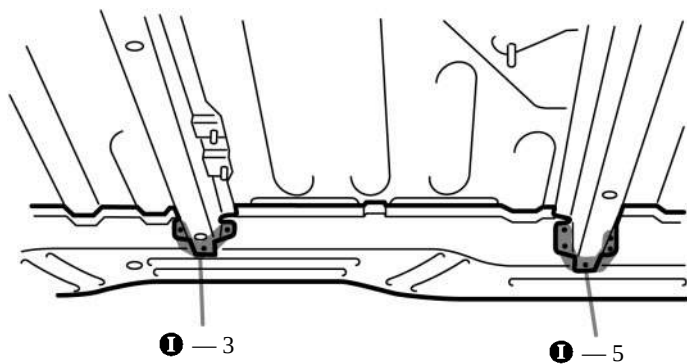
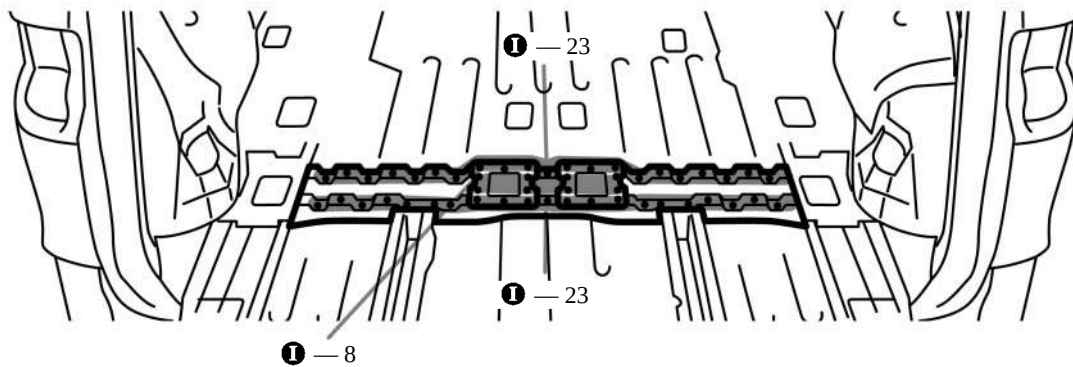
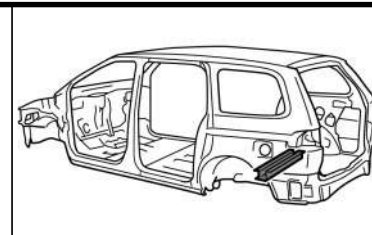


1. When temporarily installing the new parts, determine the installation position by the assembly mark. Then, measure each part i accordance with the body dimension diagram.

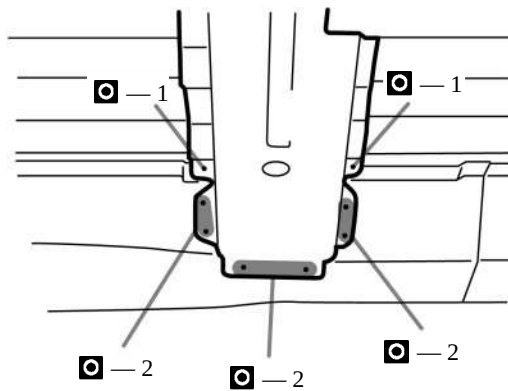
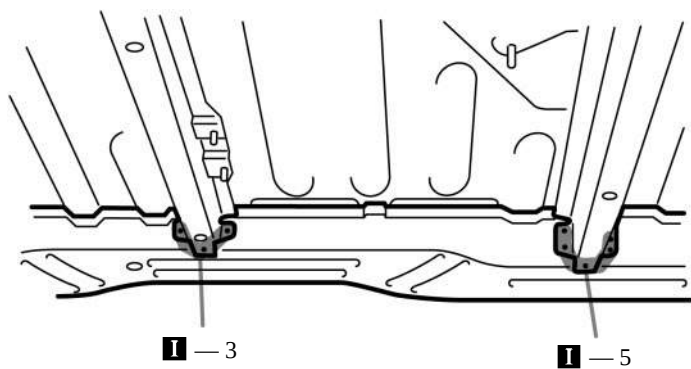
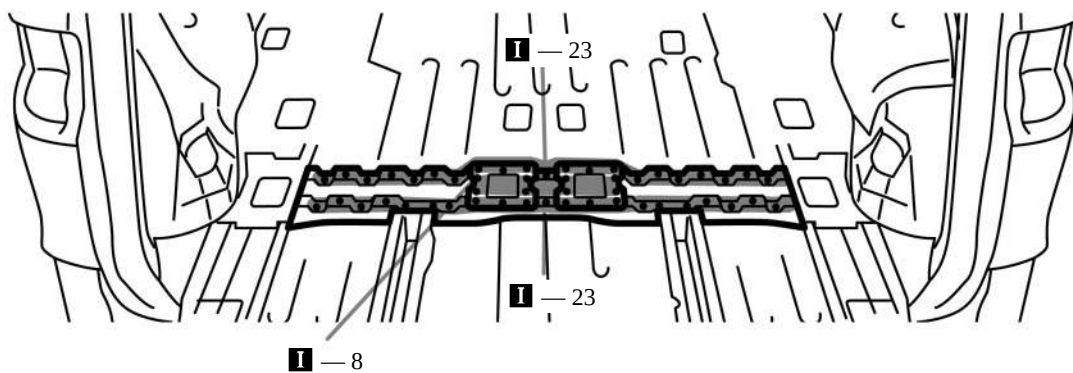
REAR FLOOR PAN REINFORCEMENT (ASSY)**REMOVAL (With the rear floor pan removed.)**

INSTALLATION



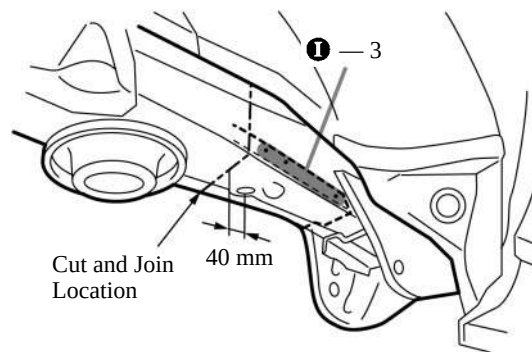
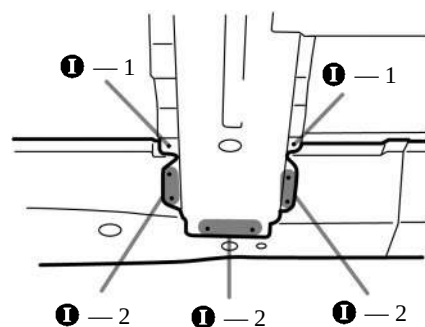
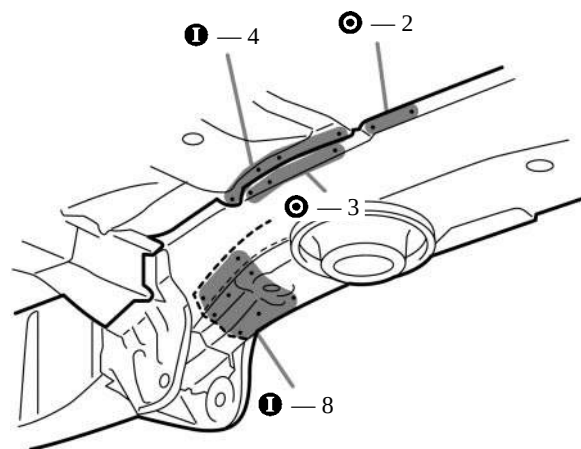
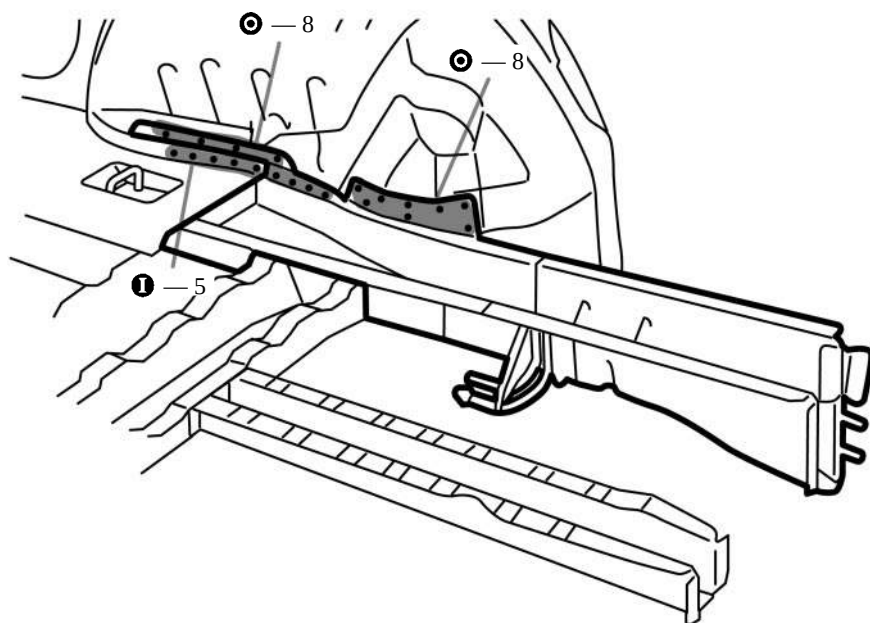
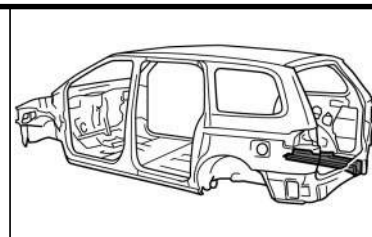
REAR FLOOR No.5 CROSSMEMBER (ASSY)**REMOVAL**

INSTALLATION



REAR FLOOR SIDE MEMBER (CUT)

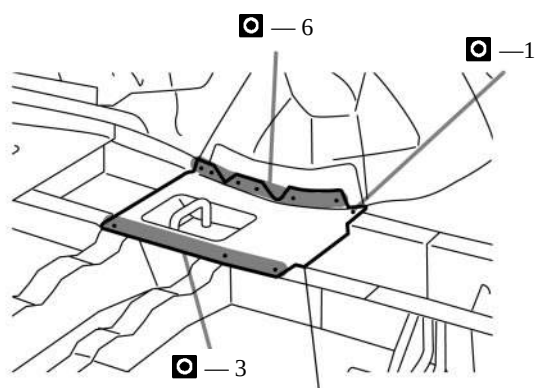
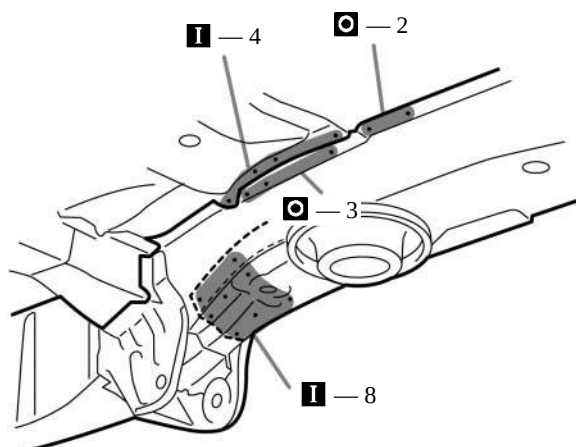
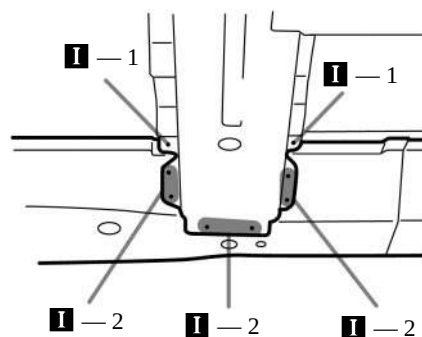
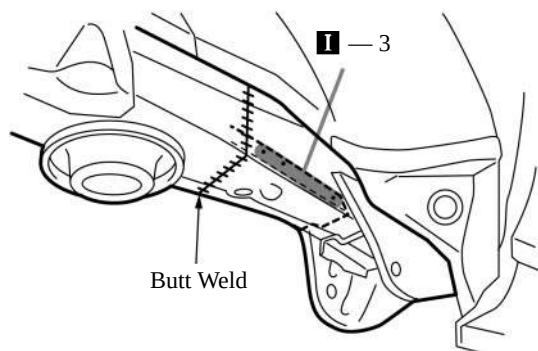
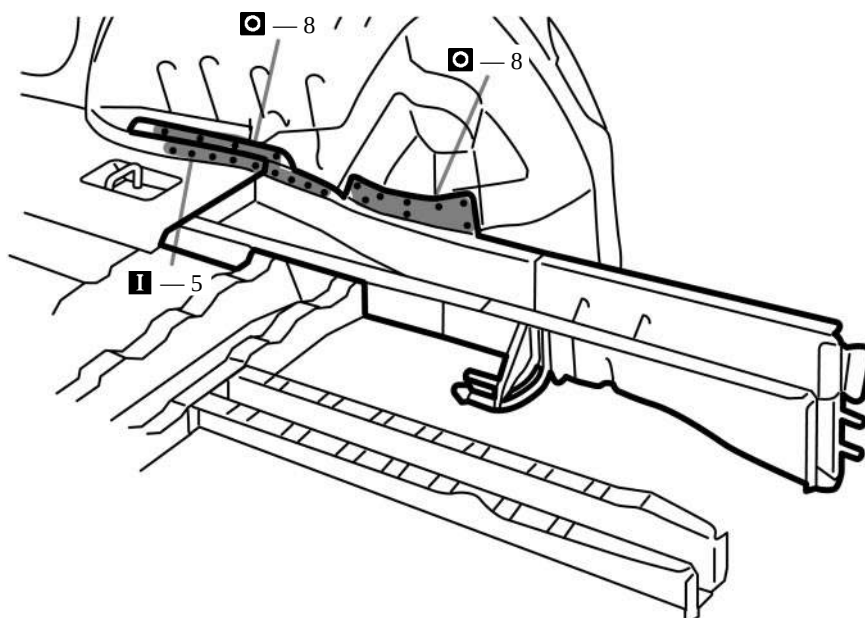
REMOVAL (With the rear floor pan, roof side inner panel removed.)



mm	in
40	1.57

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

INSTALLATION

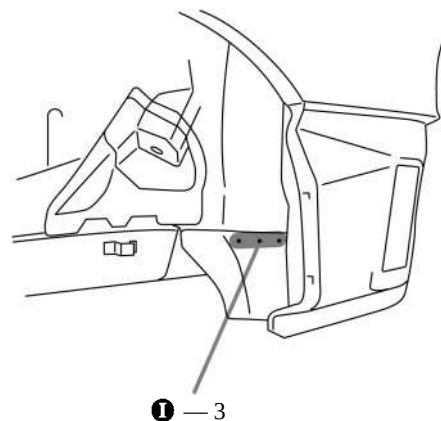
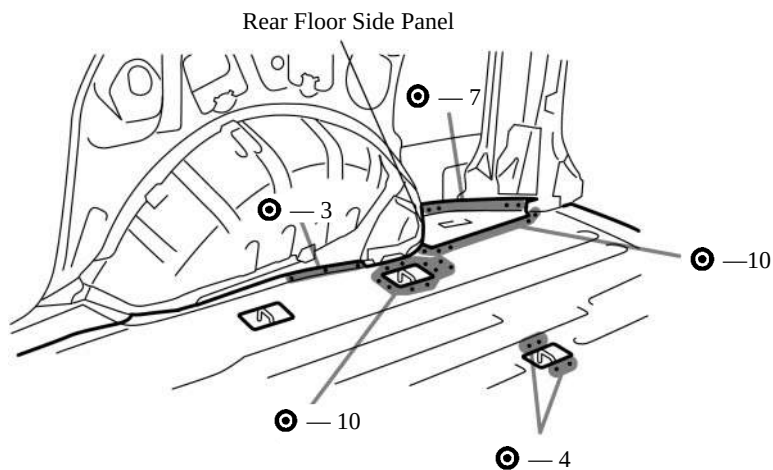
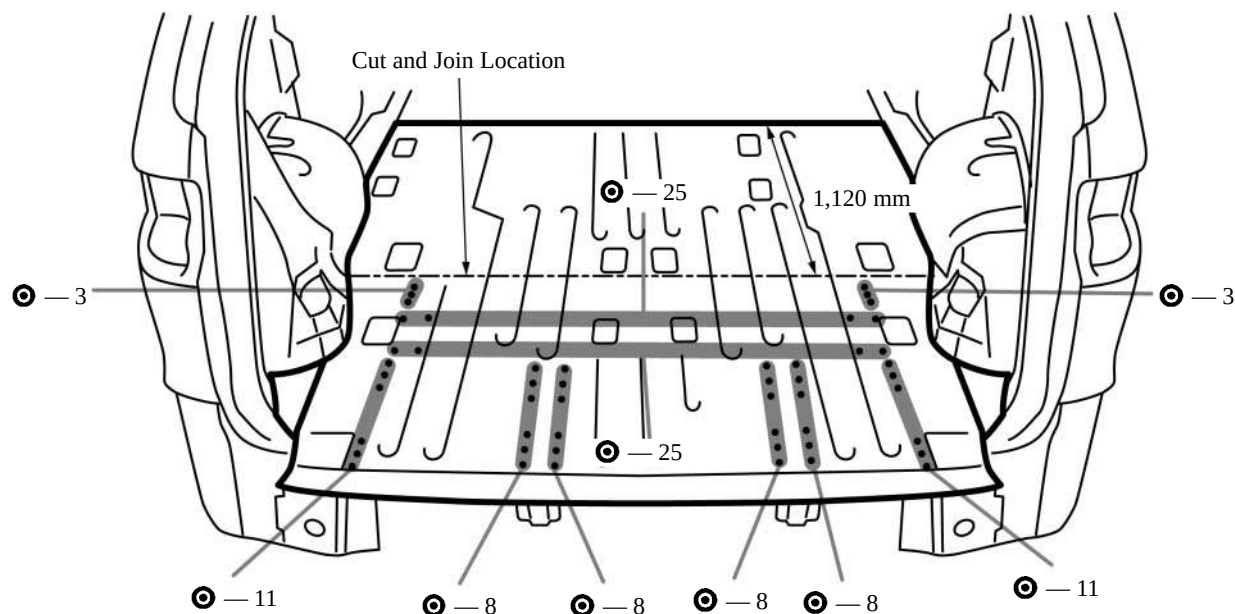
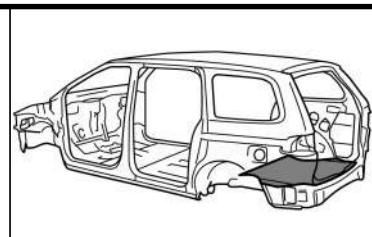


Rear Seat Leg No.2 Reinforcement

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

REAR FLOOR PAN (CUT)

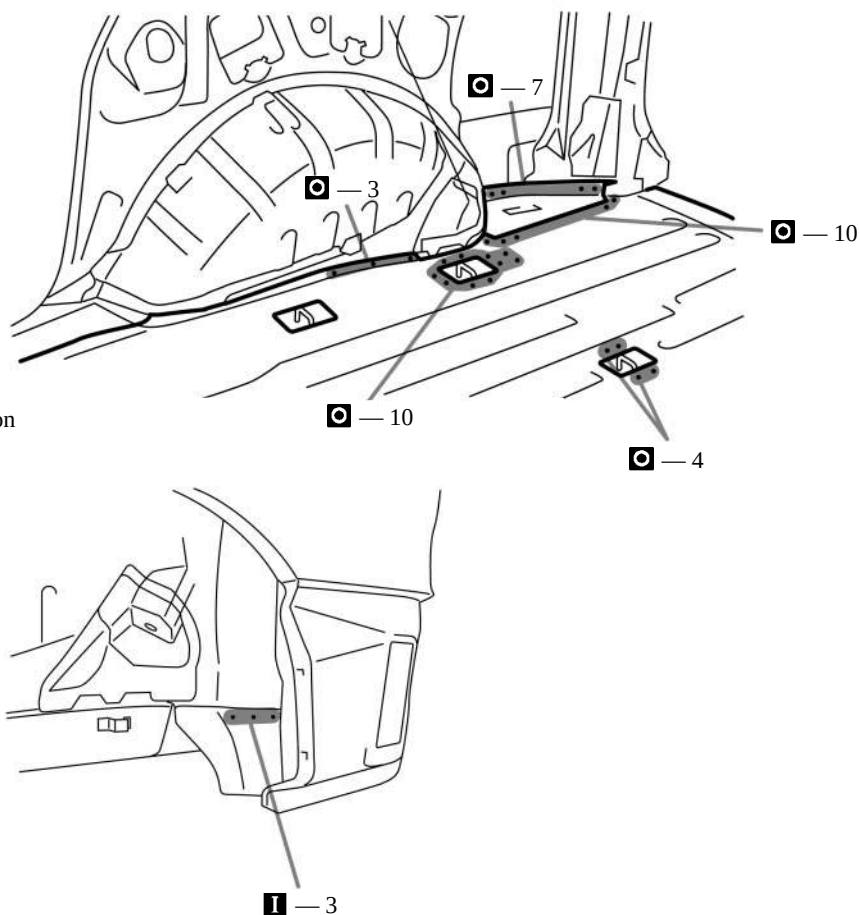
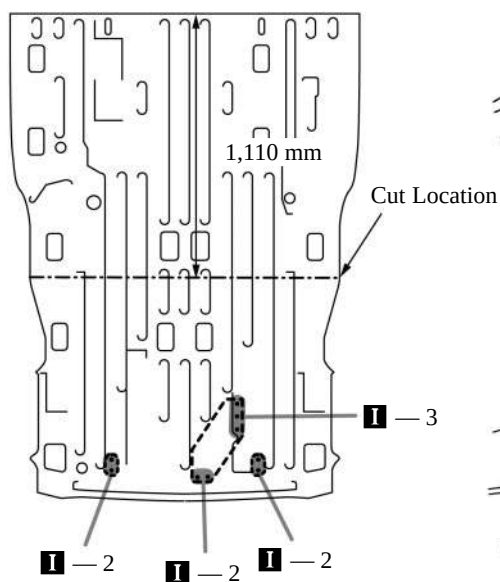
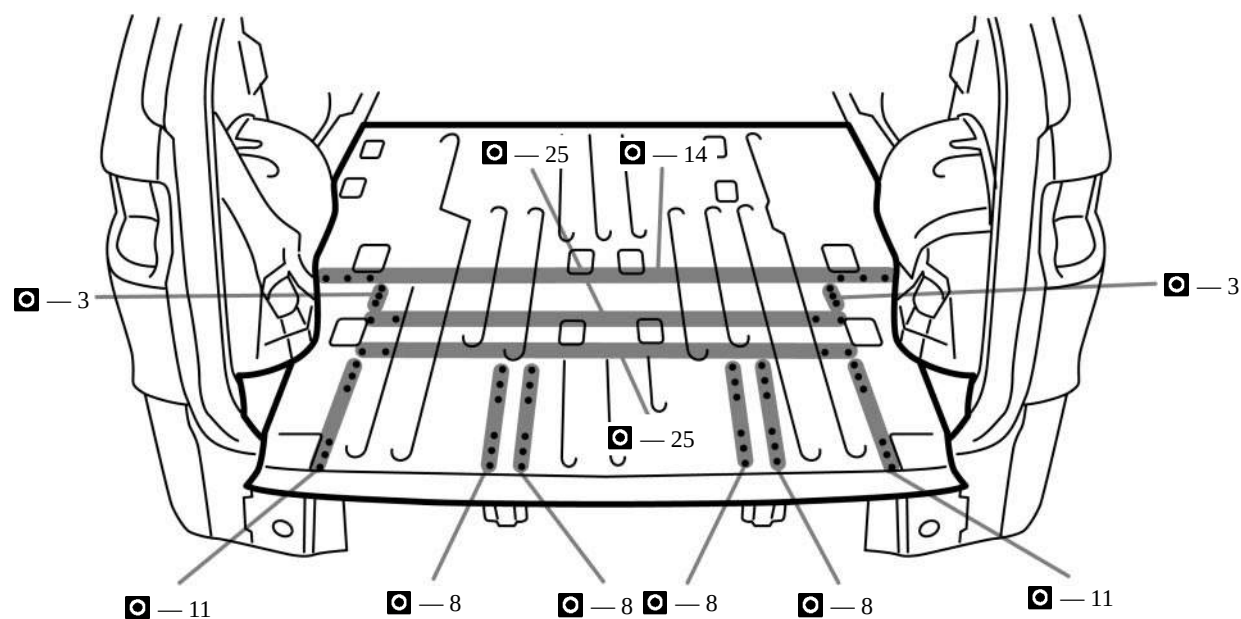
REMOVAL (With the body lower back panel, rear floor No.6 crossmember removed.)



mm	in.
1,120	44.09

1. Cut and join the parts at the location as shown above.
2. Replace the rear floor side panel at the same time.

INSTALLATION



mm	in.
1,110	43.70

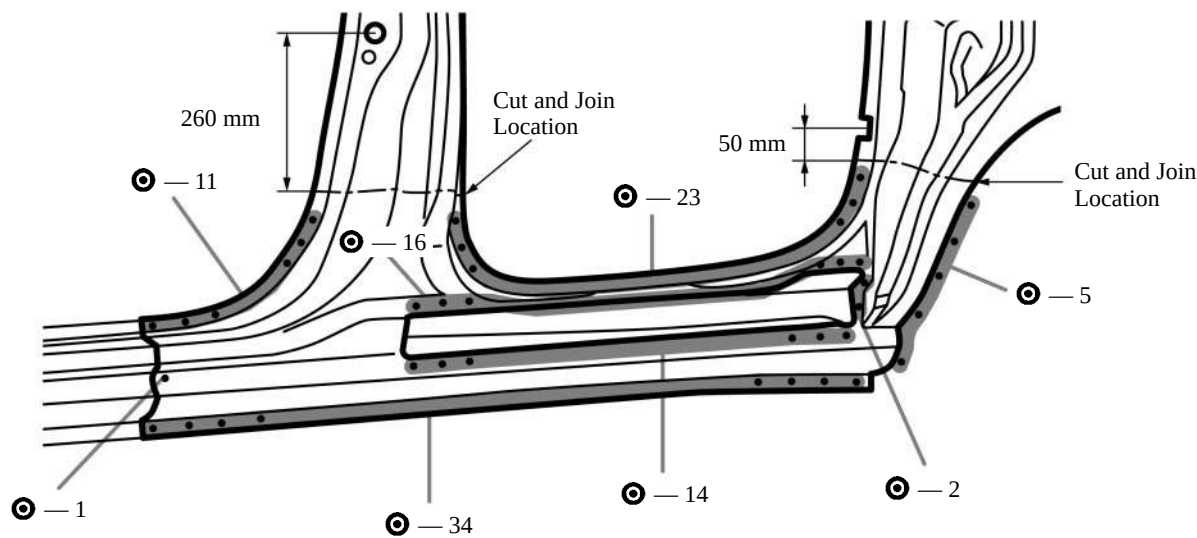
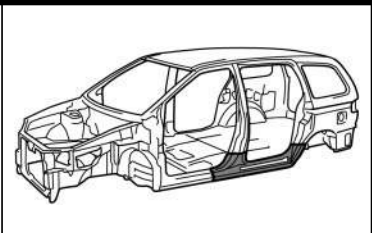
1. Cut the new parts at the location as shown above.
2. Plug weld the overlapping portion of the new parts.

HINT: Be sure the portion to be welded are align and not loose.

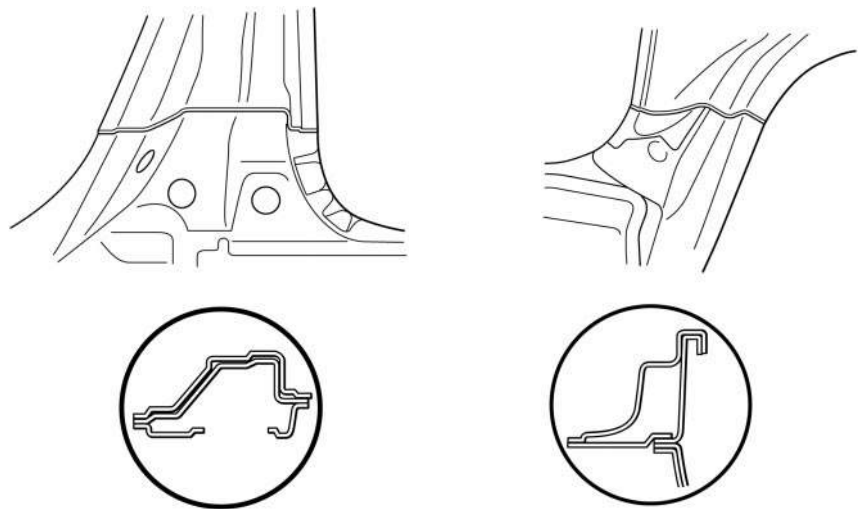
3. Coat the overlapping opening poriton from the both sides with body sealer.

ROCKER OUTER REAR PANEL (CUT)

REMOVAL



[Cut and Join Locations]

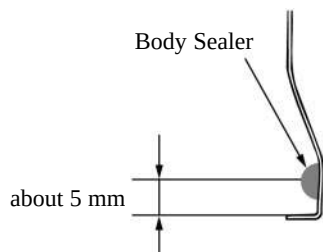


mm	in.
50	1.97
260	10.24

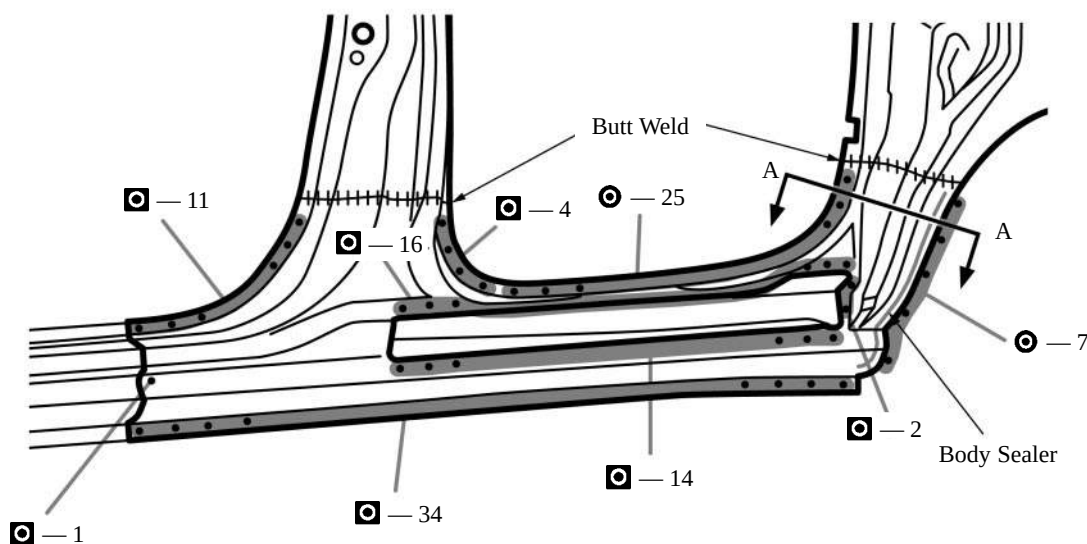
1. Cut and join the parts at the locations as shown above.

INSTALLATION

[Foamed Material Application Area]



A - A

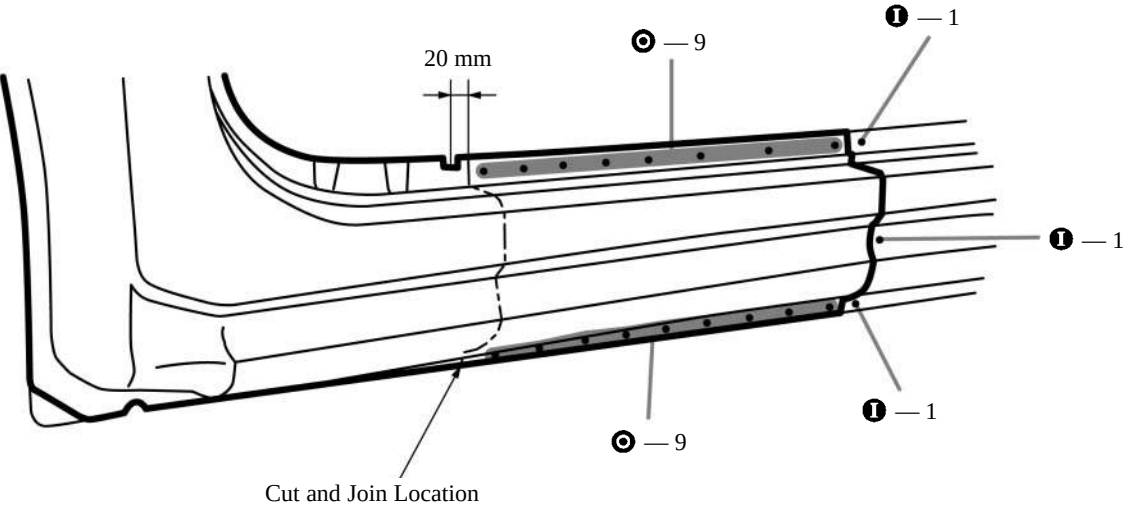
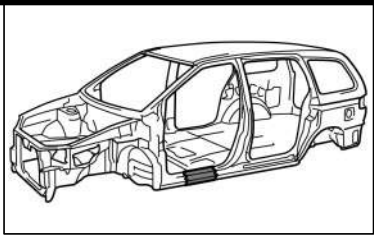


mm	in.
5	0.20

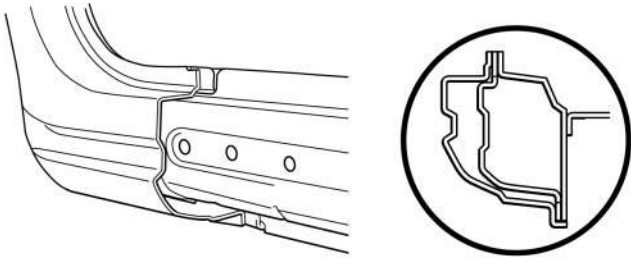
- Before temporarily installing the new parts, apply body sealer to the wheel arch.
 - Temporarily install the new parts and check the fit of the front door and slide door.
 - Apply foamed material to the quarter section.
- HINT:**
- Apply body sealer about 5 mm (0.20 in.) from the flange, avoiding any oozing.
 - Apply sealer evenly, about 3 - 4 mm (0.12 - 0.16 in.) in diameter.
 - For other sealing points, refer to section AR.

ROCKER OUTER PANEL (CUT)

REMOVAL

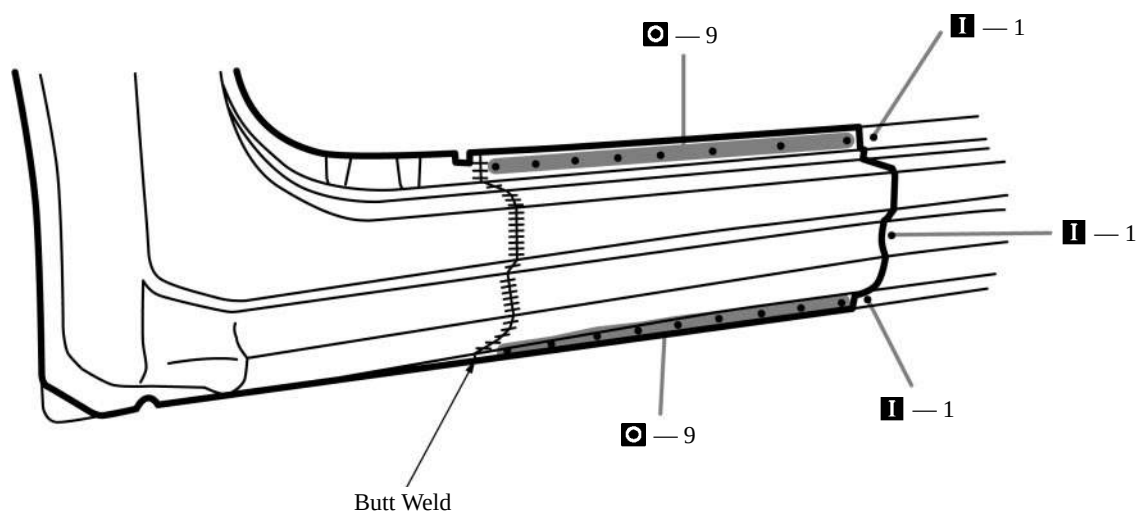


[Cut and Join Location]



mm	in.
20	0.79

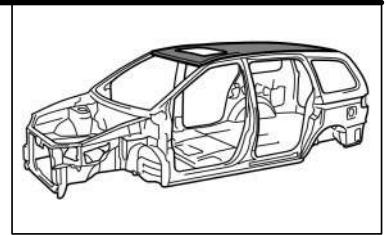
1. Cut and join the parts at the location as shown above.

INSTALLATION

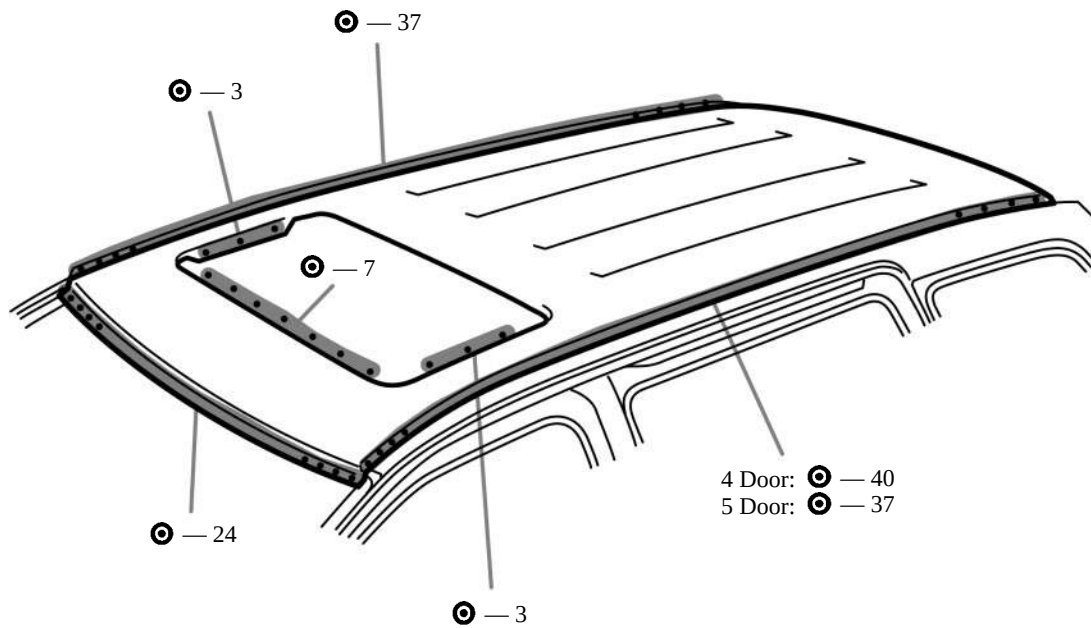
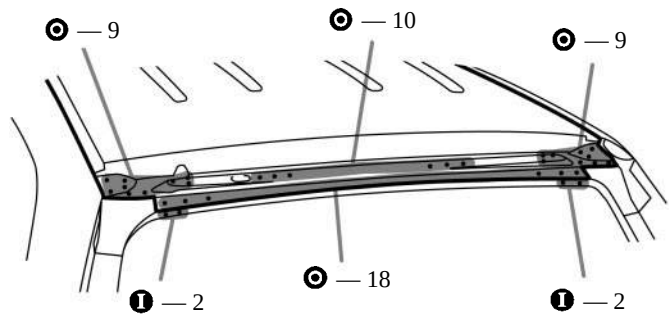
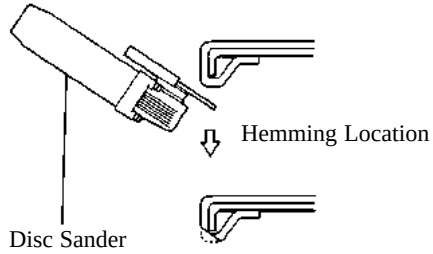
1. Temporarily install the new parts and check the fit of the front door.

ROOF PANEL (ASSY): Sun Roof

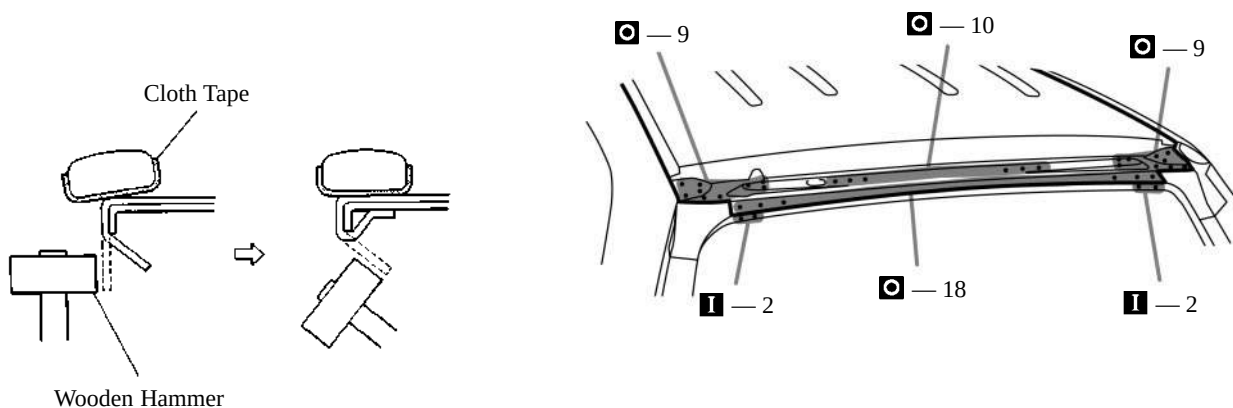
REMOVAL



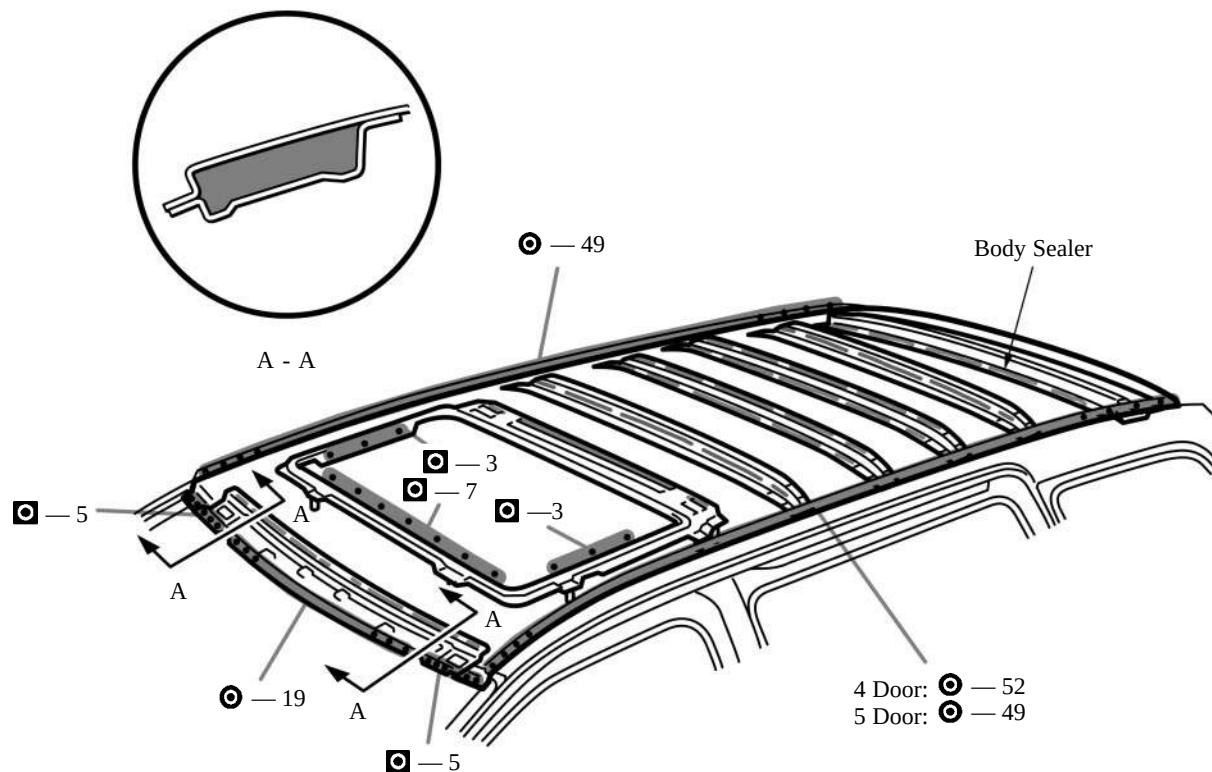
[If resusing the roof panel reinforcement]



INSTALLATION



[Foamed Material Application Areas]



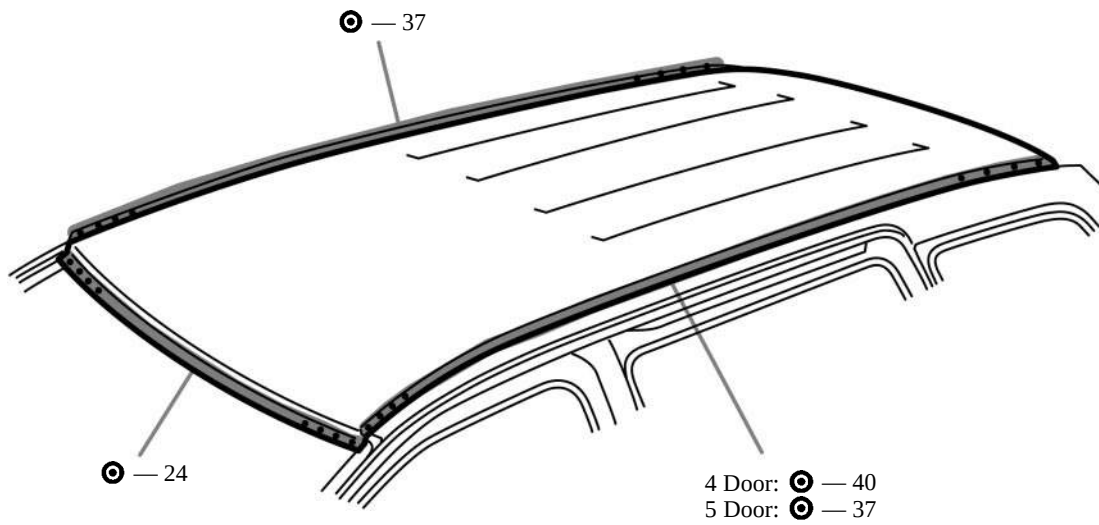
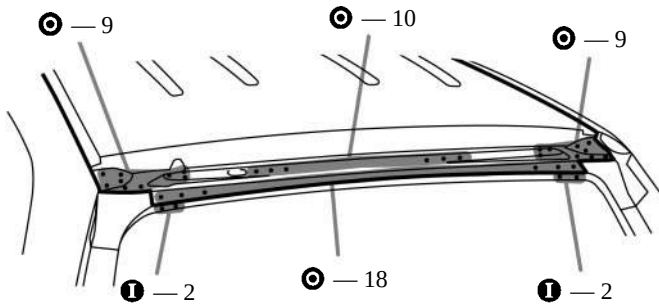
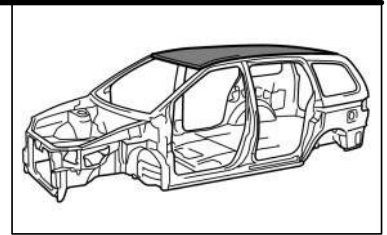
1. Before temporarily installing the new parts, apply body sealer to the windshield header panel, roof panel reinforcement and back window frame.

HINT:

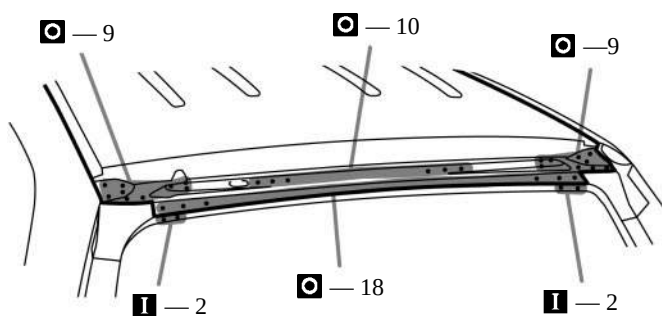
- 1) Apply just enough sealer for the new parts to make contact.
- 2) For other sealing points, refer to Section AR.

2. Bend the flange hem with a wooden hammer and dolly.

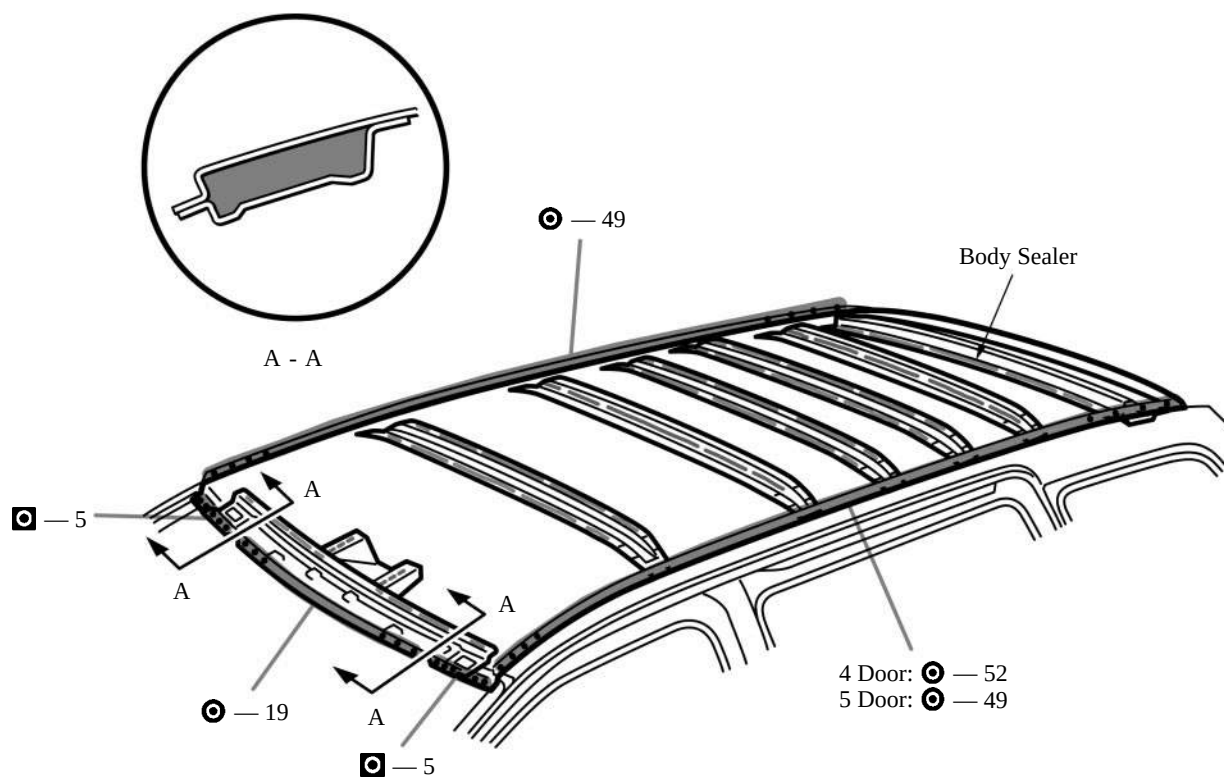
HINT: Perform hemming three steps, being careful not to warp the panel.

ROOF PANEL (ASSY): Nomal Roof**REMOVAL**

INSTALLATION



[Foamed Material Application Areas]



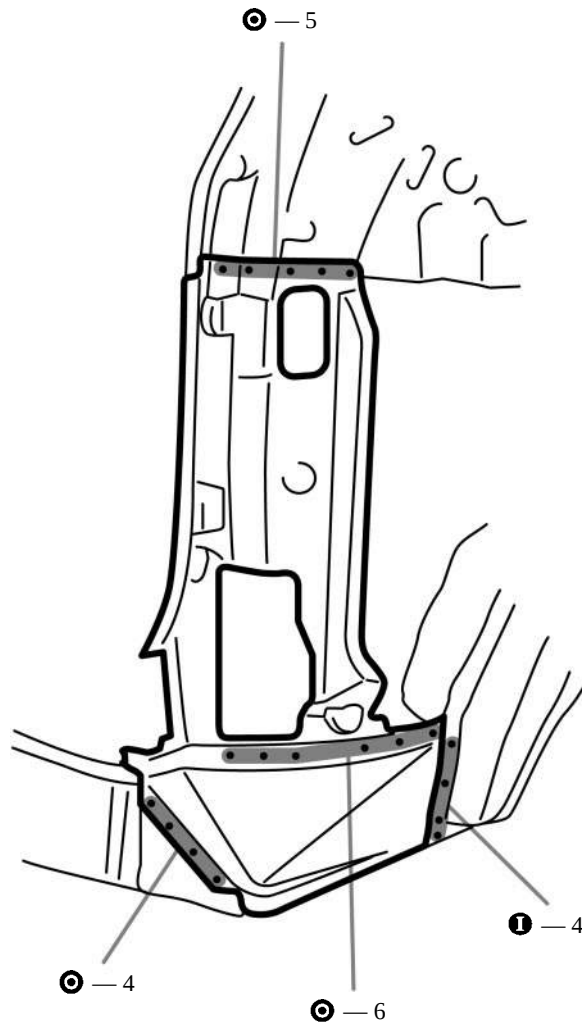
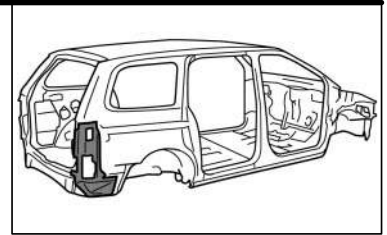
1. Before temporarily installing the new parts, apply body sealer to the windshield header panel, roof panel reinforcement and back window frame.

HINT:

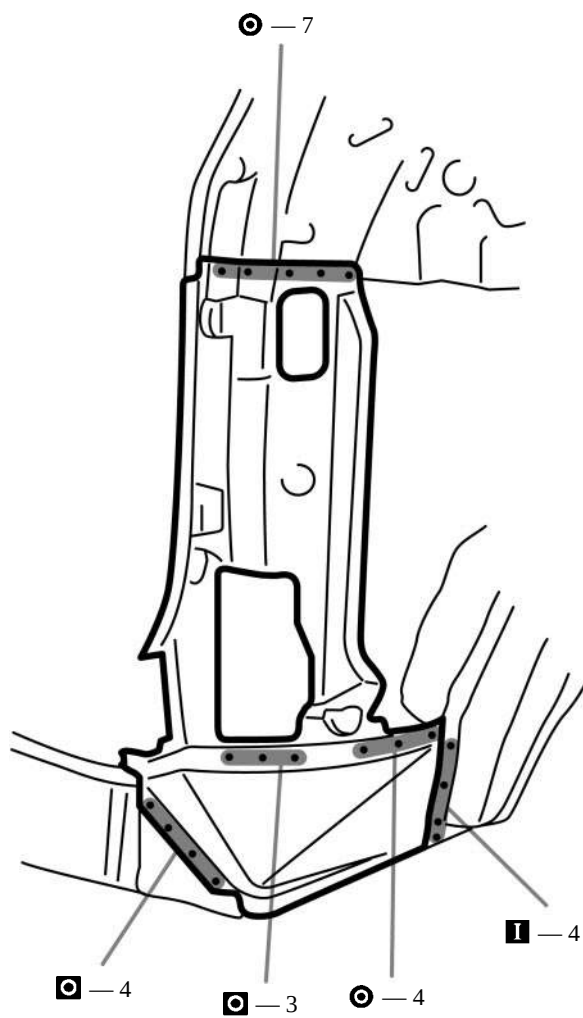
- 1) Apply just enough sealer for the new parts to make contact.
- 2) For other sealing points, refer to Section AR.

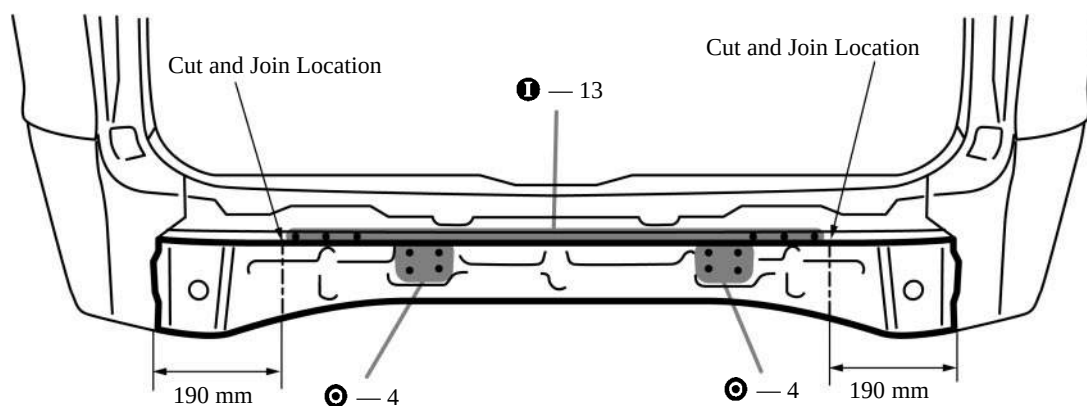
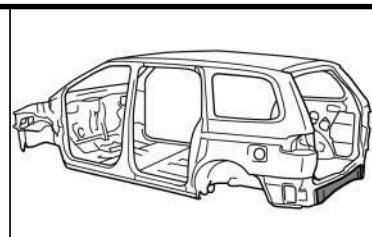
ROOF SIDE INNER PANEL (ASSY)

REMOVAL (With the body lower back panel, roof side outer panel removed.)



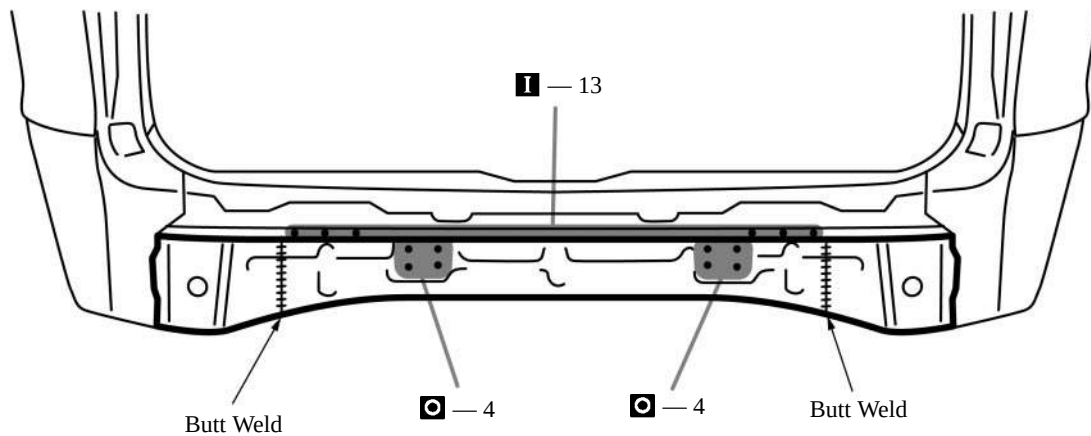
INSTALLATION

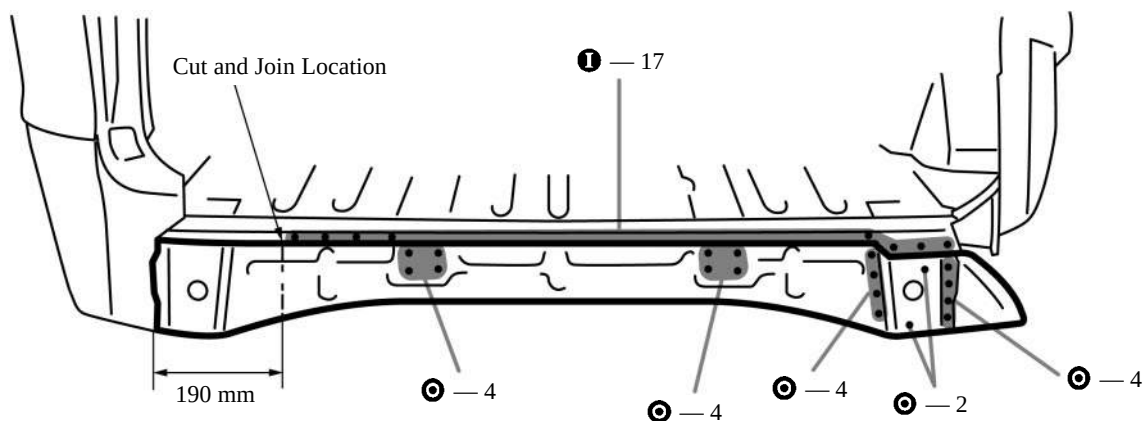
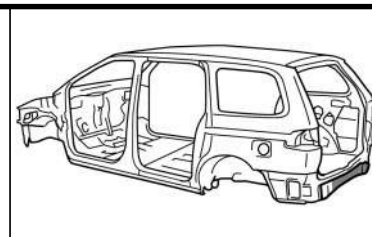


REAR FLOOR No.6 CROSSMEMBER (CUT)**REMOVAL**

mm	in.
190	7.48

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

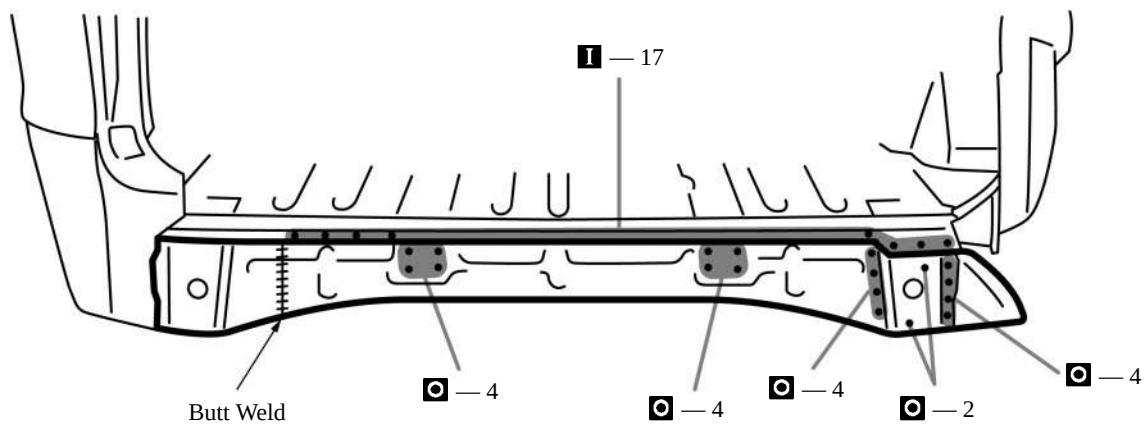
INSTALLATION

REAR FLOOR No.6 CROSSMEMBER (CUT)**REMOVAL (With the roof side inner panel removed.)**

mm	in.
190	7.48

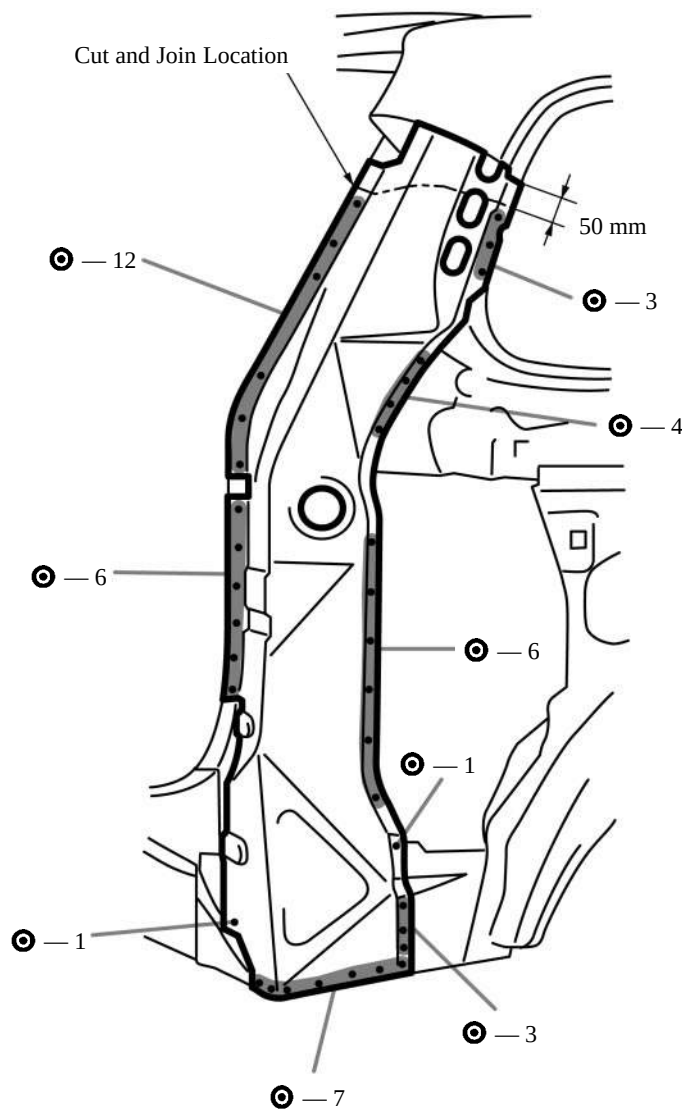
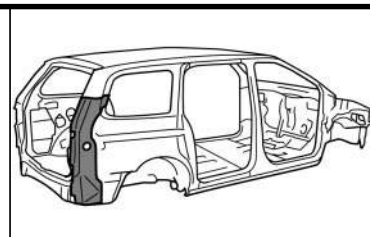
1. Cut and join the parts at the location as shown above.

INSTALLATION



ROOF SIDE OUTER PANEL (CUT)

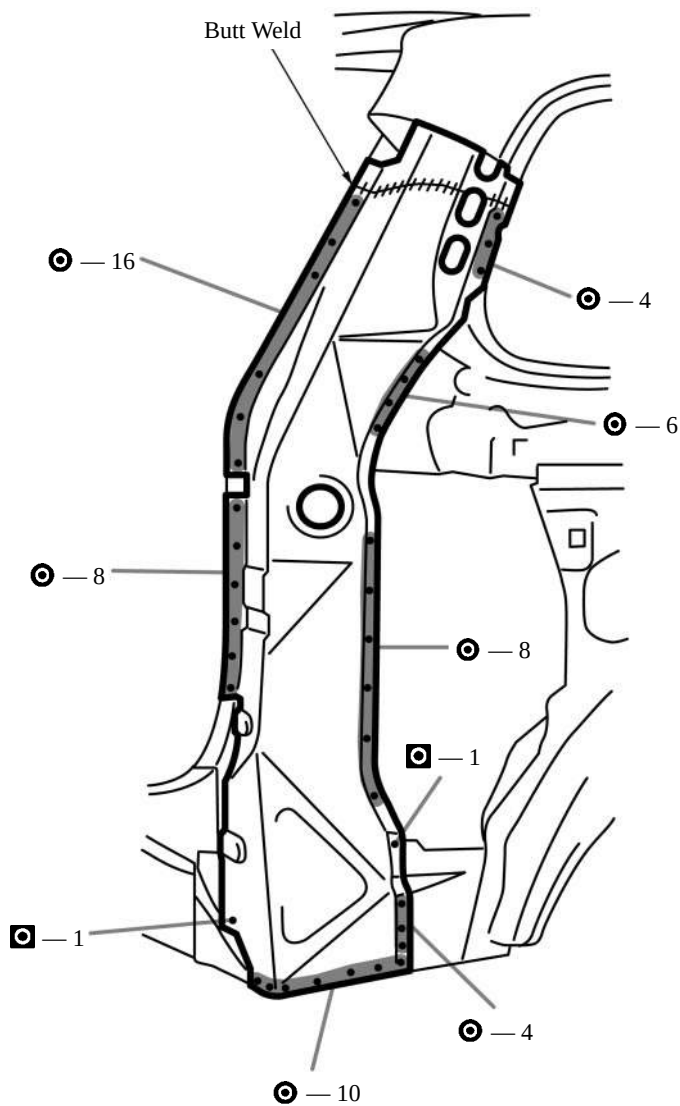
REMOVAL (With the quarter panel rear lower extension removed.)

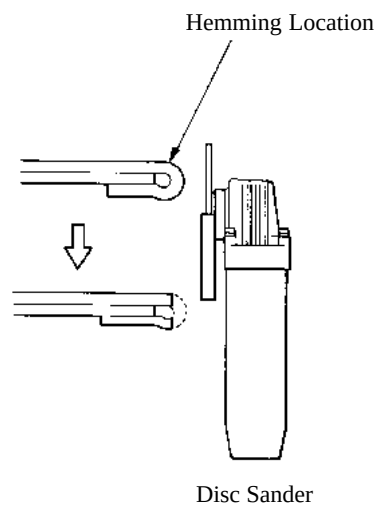
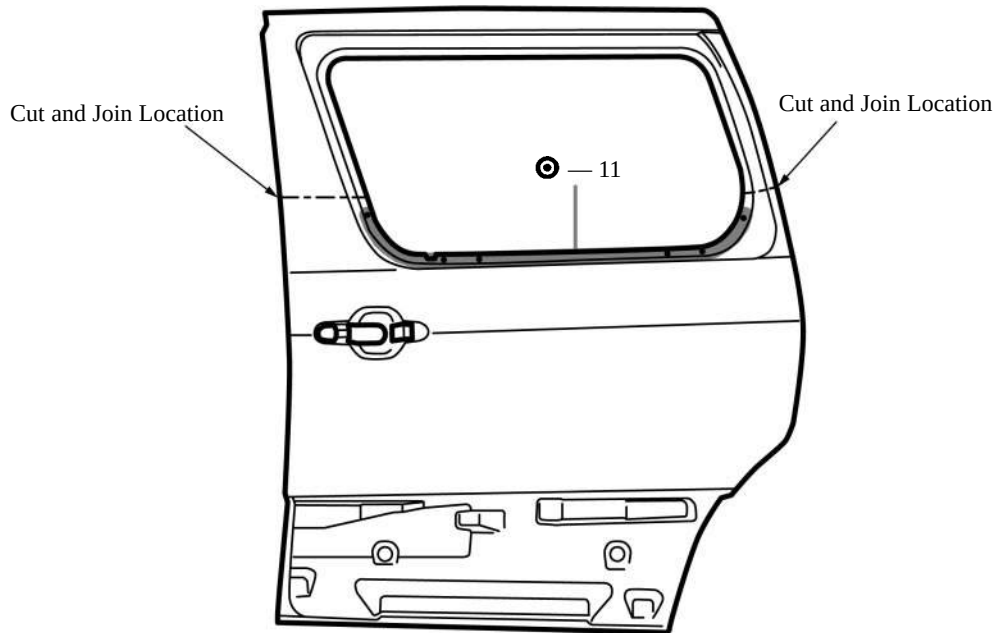
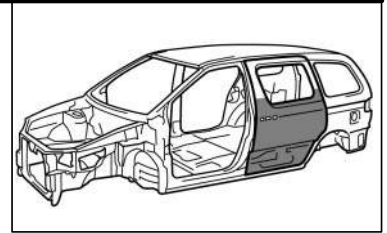


mm	in.
50	1.97

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

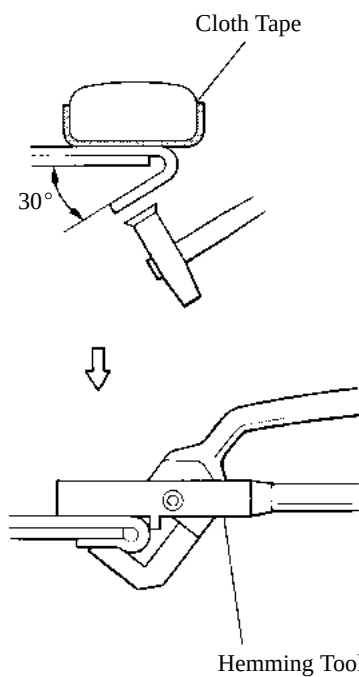
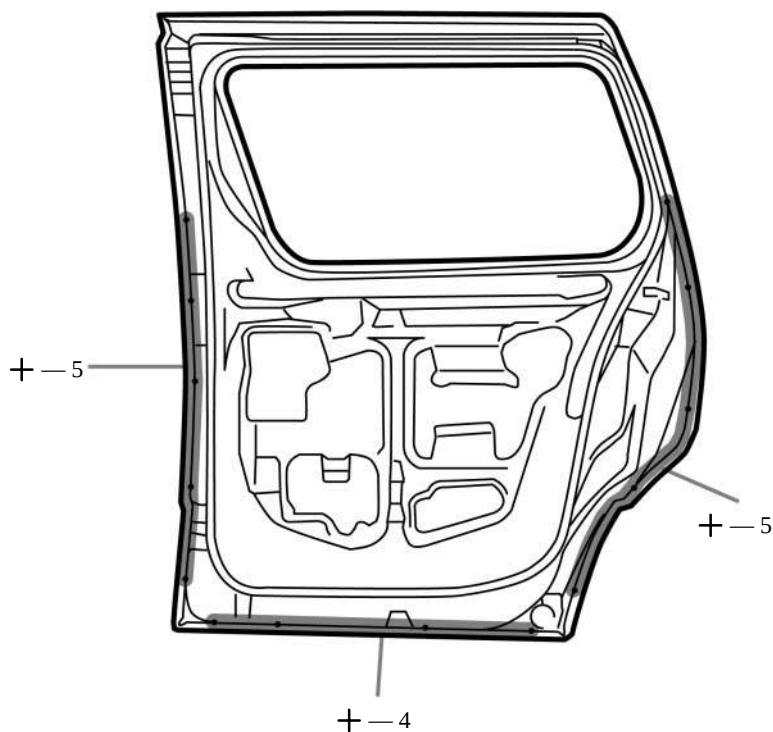
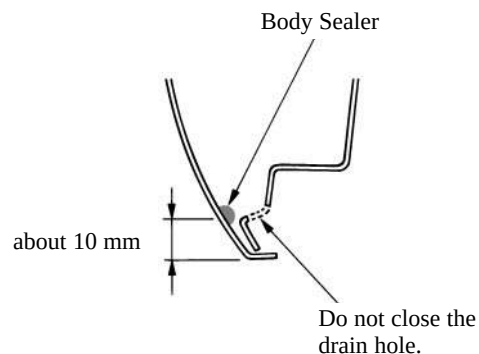
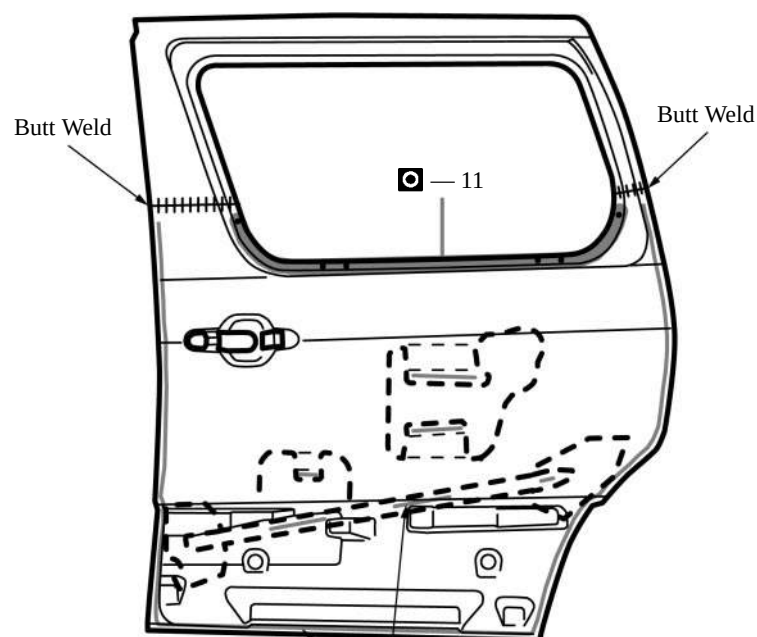
INSTALLATION



SLIDE DOOR OUTER PANEL (CUT)**REMOVAL**

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