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BODY STRUCTURE [PANEL REPLACEMENT]

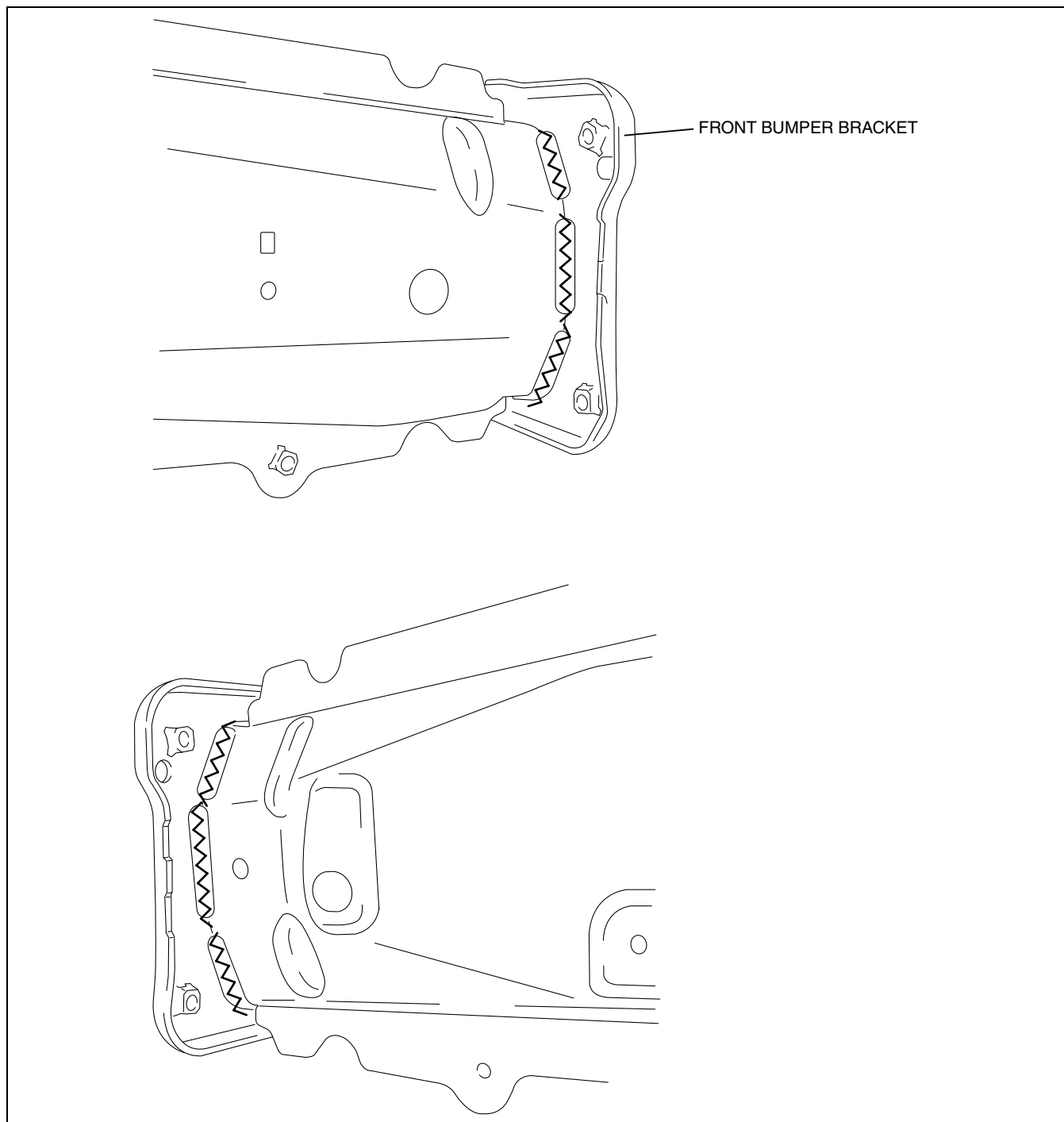
FRONT BUMPER BRACKET REMOVAL

C3U098053896B01

1. Remove the front bumper bracket.

Caution

- Only the procedure for the left side is described. The shape for the right side is different.



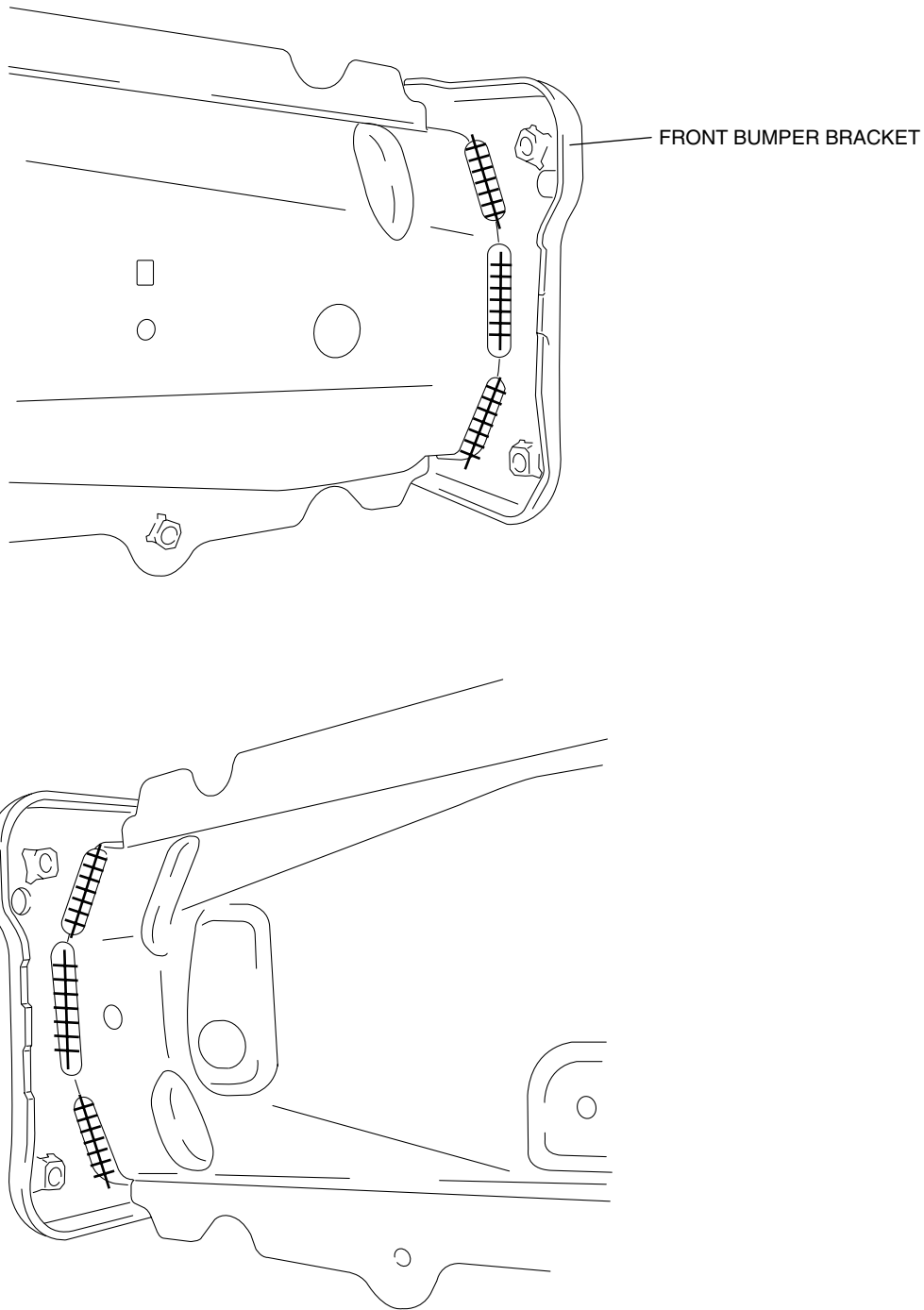
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BODY STRUCTURE [PANEL REPLACEMENT]

FRONT BUMPER BRACKET INSTALLATION

C3U098053896B02

1. When installing new parts, measure and adjust the body as necessary to conform with standard dimensions.
2. After temporarily installing new parts, make sure the related parts fit properly.



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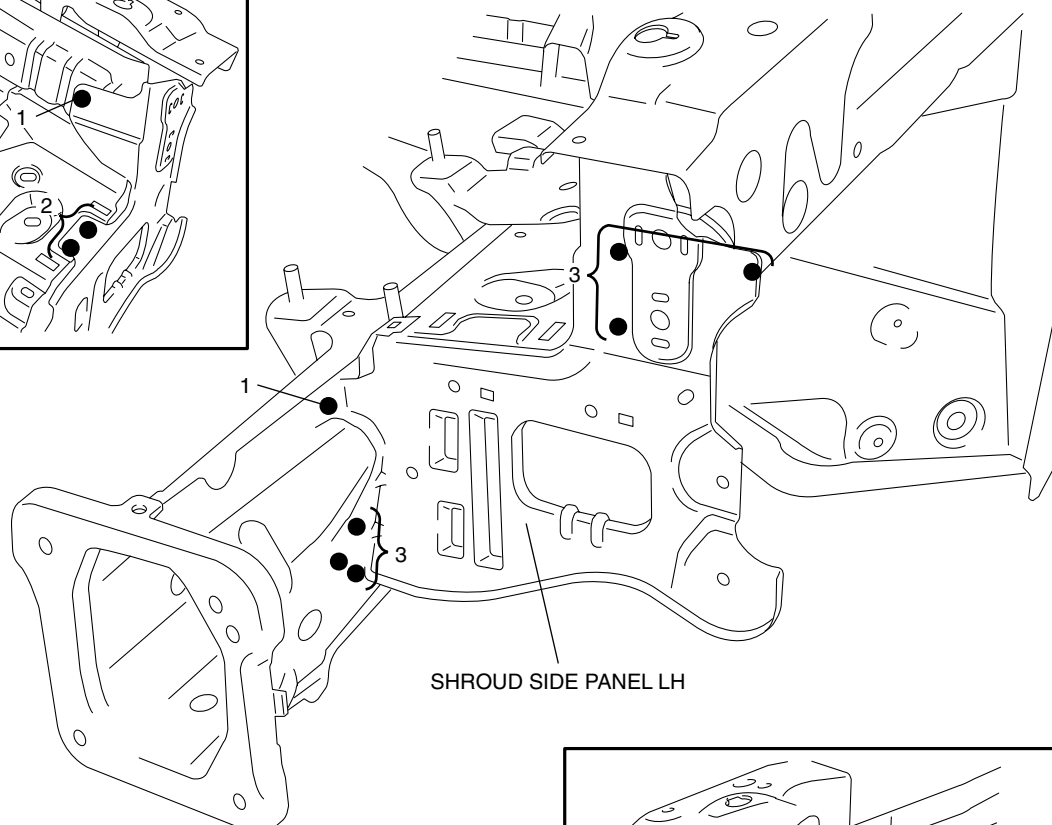
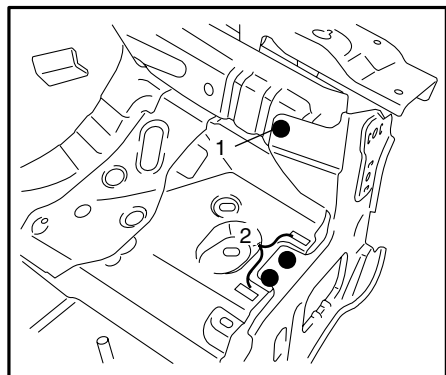
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BODY STRUCTURE [PANEL REPLACEMENT]

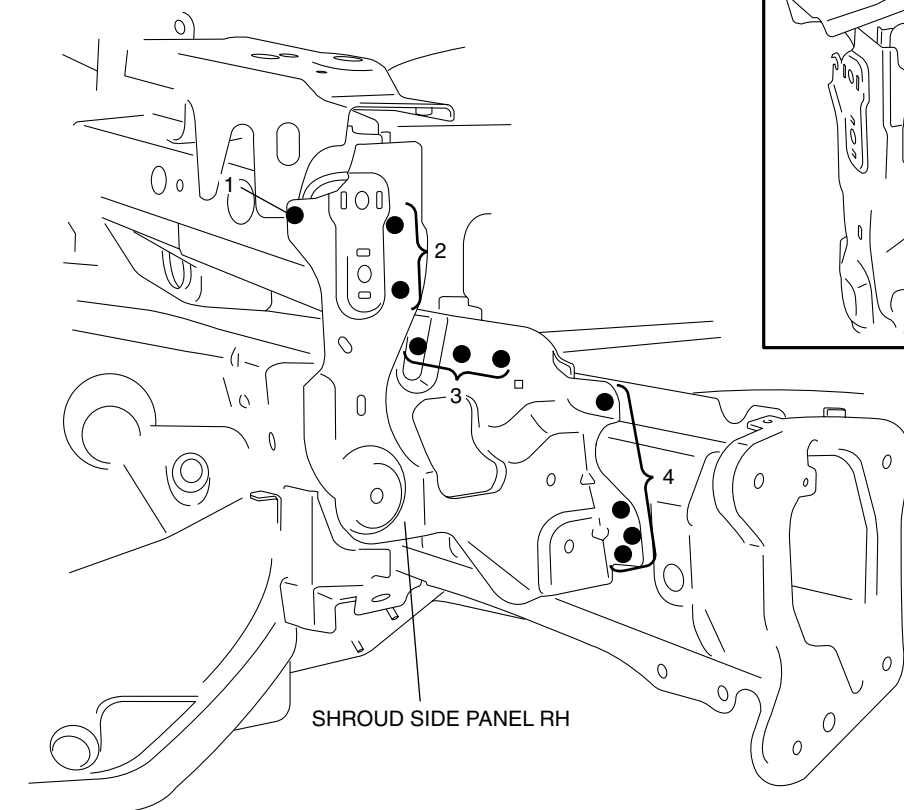
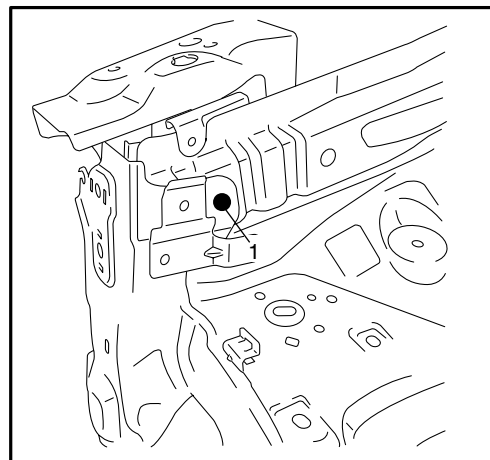
SHROUD SIDE PANEL REMOVAL

C3U098053140B01

1. Remove the shroud side panel.



SHROUD SIDE PANEL LH



SHROUD SIDE PANEL RH

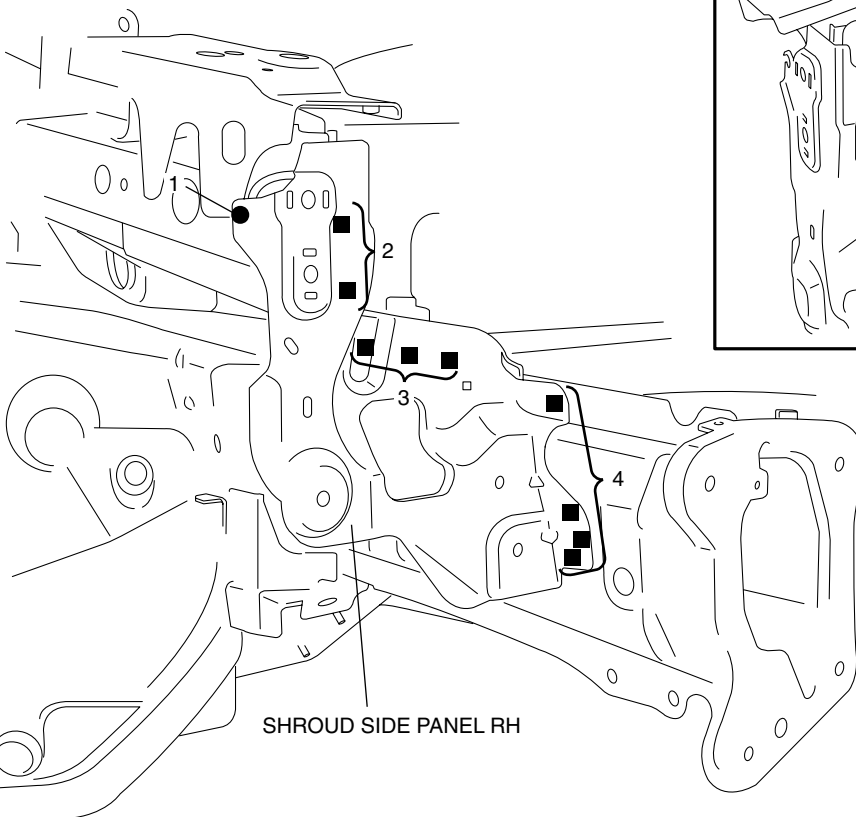
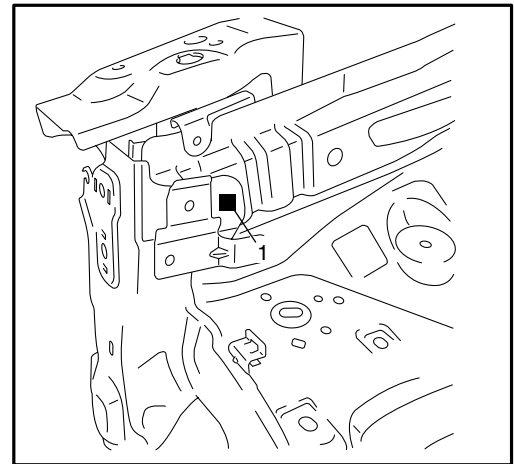
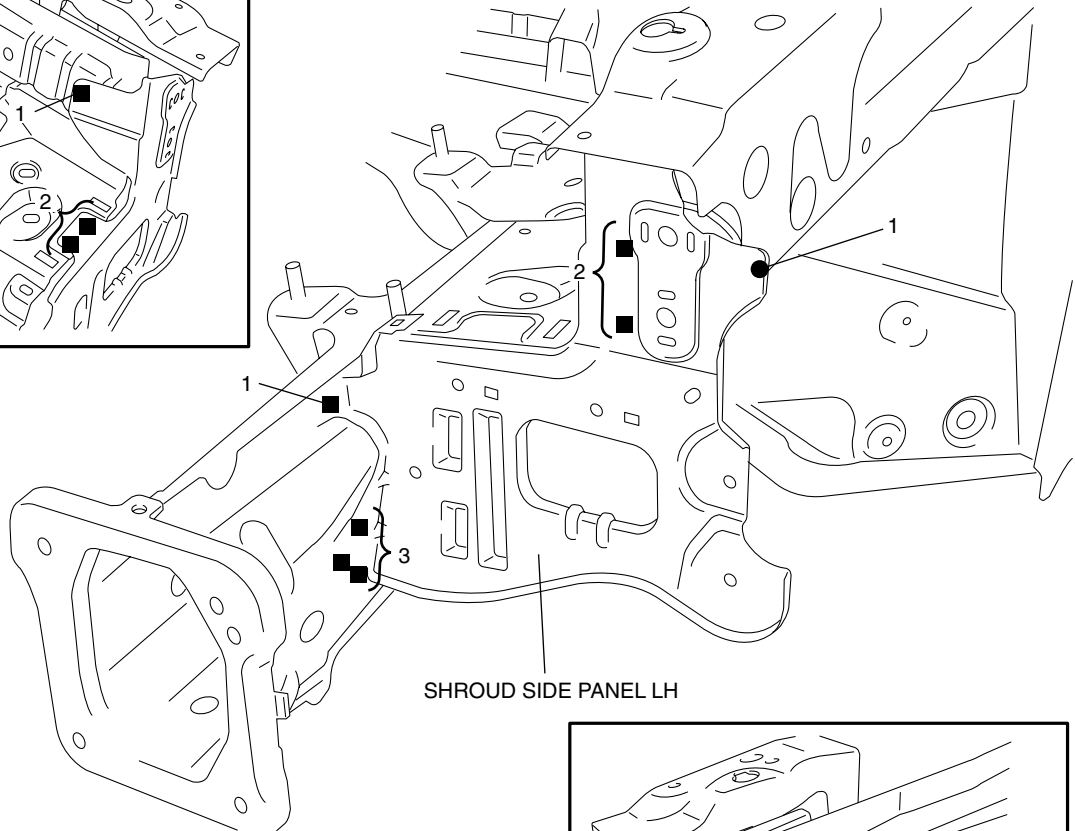
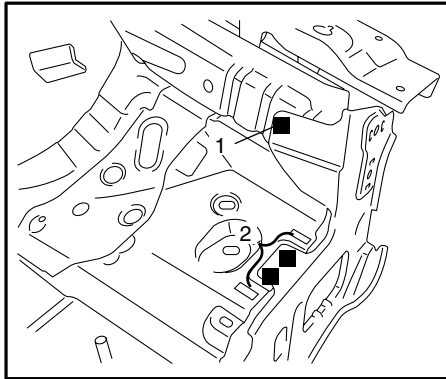
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BODY STRUCTURE [PANEL REPLACEMENT]

SHROUD SIDE PANEL INSTALLATION

C3U098053140B02

1. When installing new parts, measure and adjust the body as necessary to conform with standard dimensions.
2. Drill holes for plug welds before installing new parts.
3. After temporarily installing new parts, make sure the related parts fit properly.



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BODY STRUCTURE [PANEL REPLACEMENT]

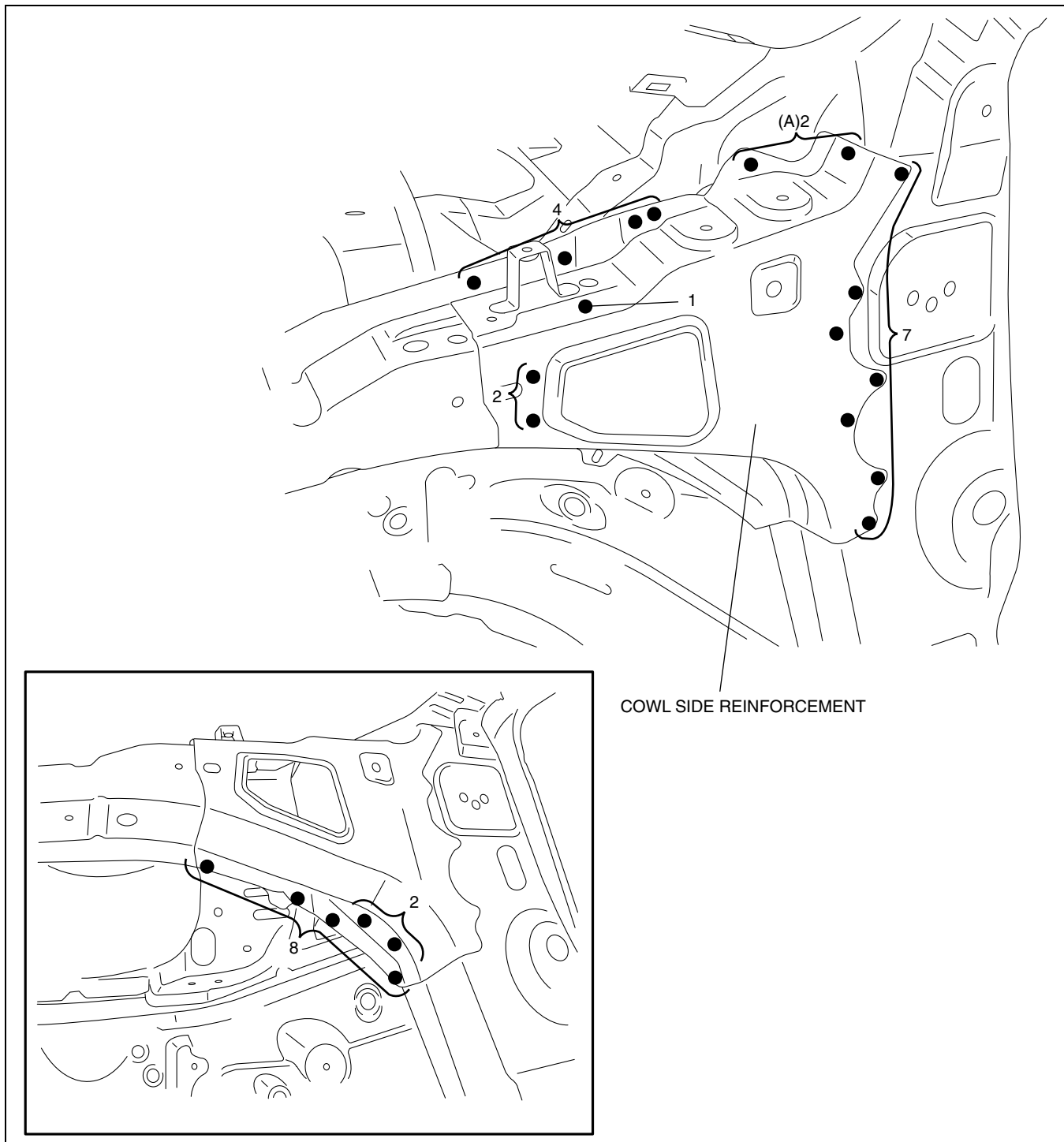
COWL SIDE REINFORCEMENT REMOVAL

C3U098053290B01

1. Remove the cowl side reinforcement.

Caution

- Be careful not to damage the windshield when drilling the 2 locations indicated by (A).



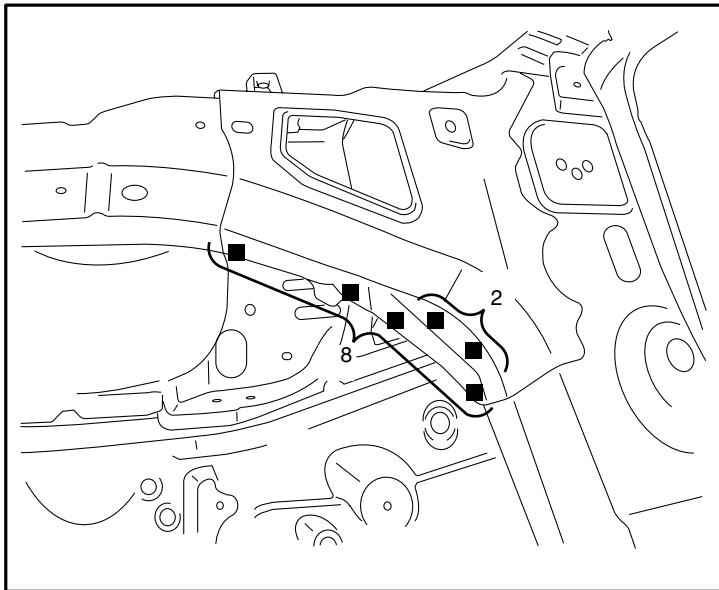
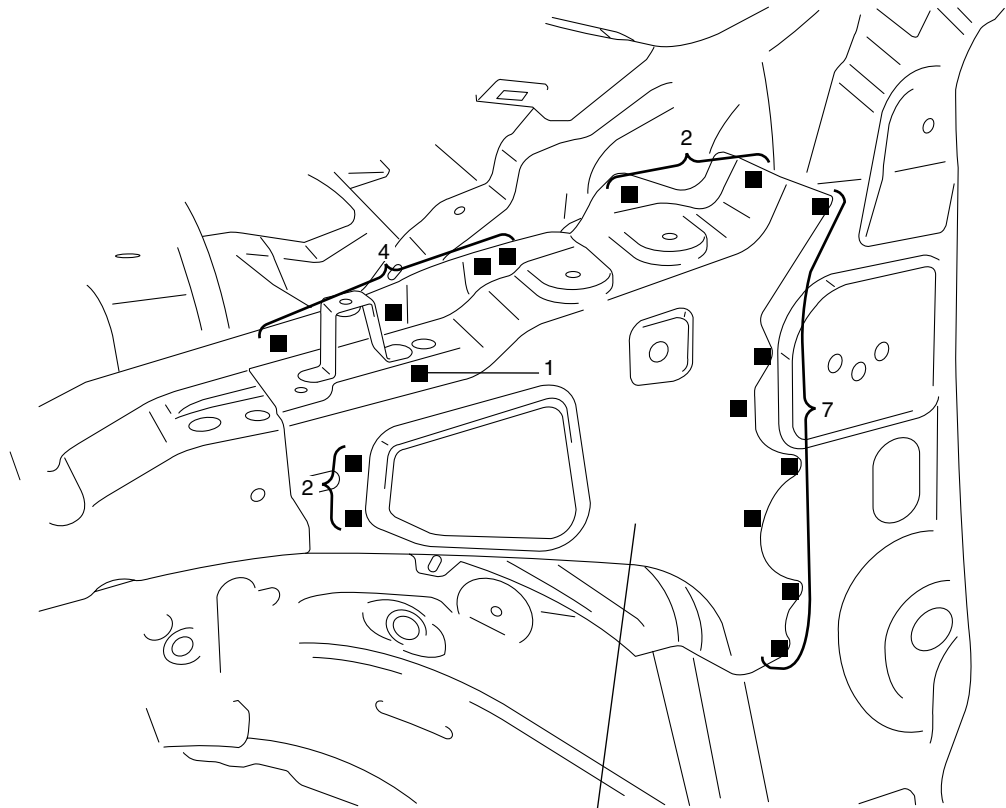
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BODY STRUCTURE [PANEL REPLACEMENT]

COWL SIDE REINFORCEMENT INSTALLATION

C3U098053290B02

1. When installing new parts, measure and adjust the body as necessary to conform with standard dimensions.
2. Drill holes for plug welds before installing new parts.
3. After temporarily installing new parts, make sure the related parts fit properly.



COWL SIDE REINFORCEMENT

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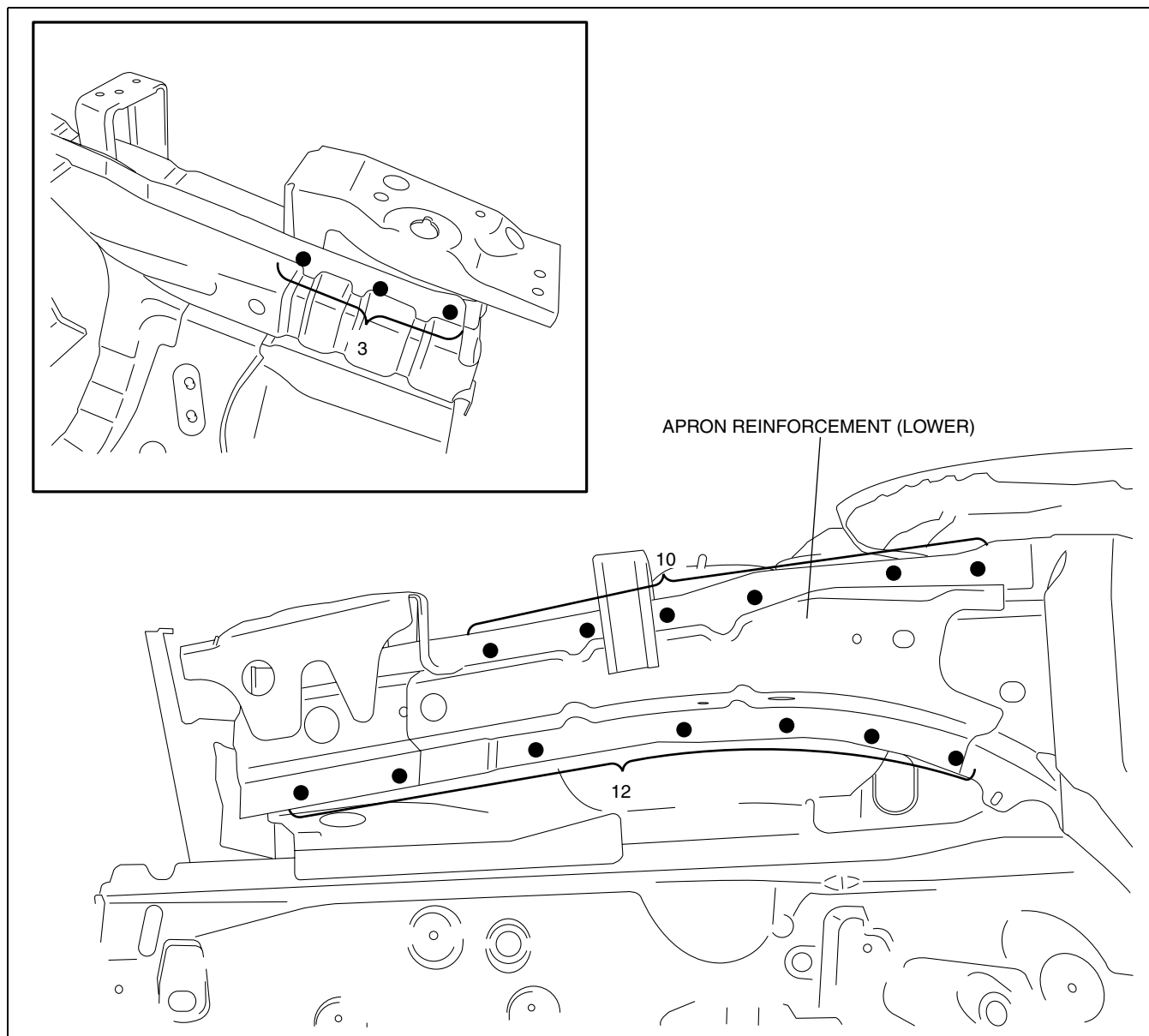
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BODY STRUCTURE [PANEL REPLACEMENT]

APRON REINFORCEMENT (LOWER) REMOVAL

C3U098053260B01

1. Remove the apron reinforcement (lower).



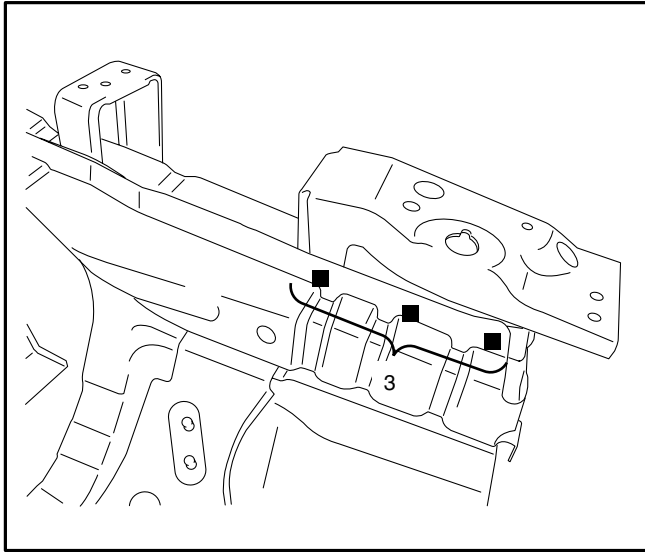
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BODY STRUCTURE [PANEL REPLACEMENT]

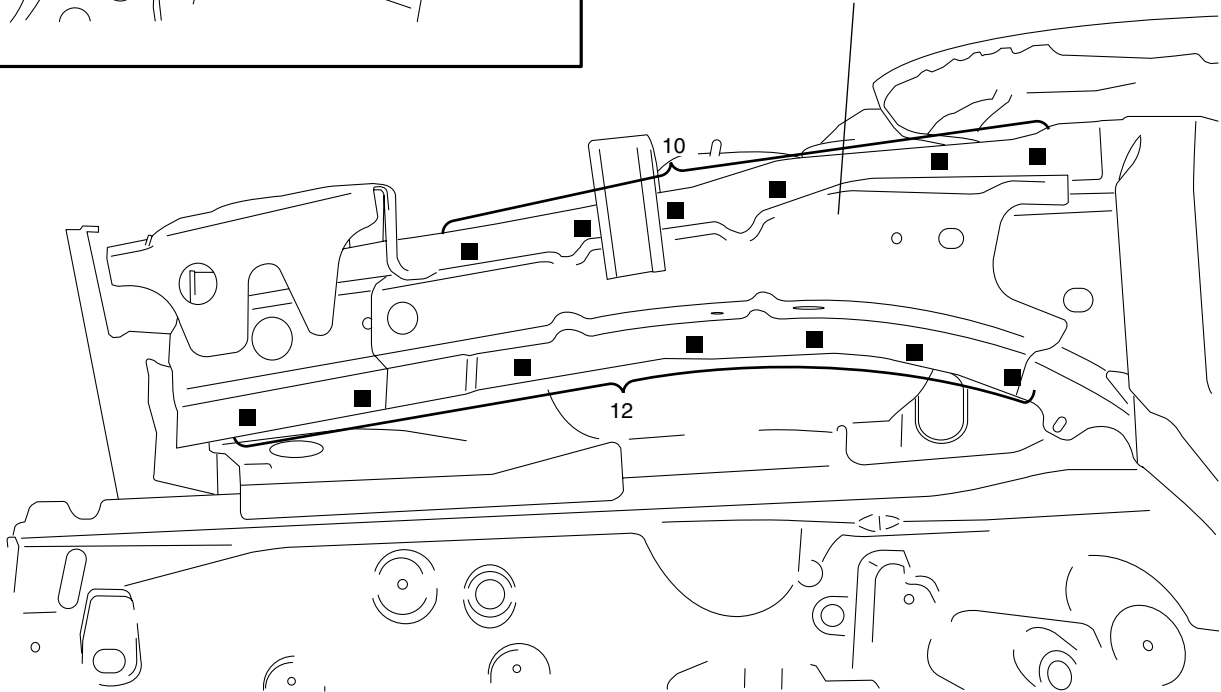
APRON REINFORCEMENT (LOWER) INSTALLATION

C3U098053260B02

1. When installing new parts, measure and adjust the body as necessary to conform with standard dimensions.
2. Drill holes for plug welds before installing new parts.
3. After temporarily installing new parts, make sure the related parts fit properly.



APRON REINFORCEMENT (LOWER)



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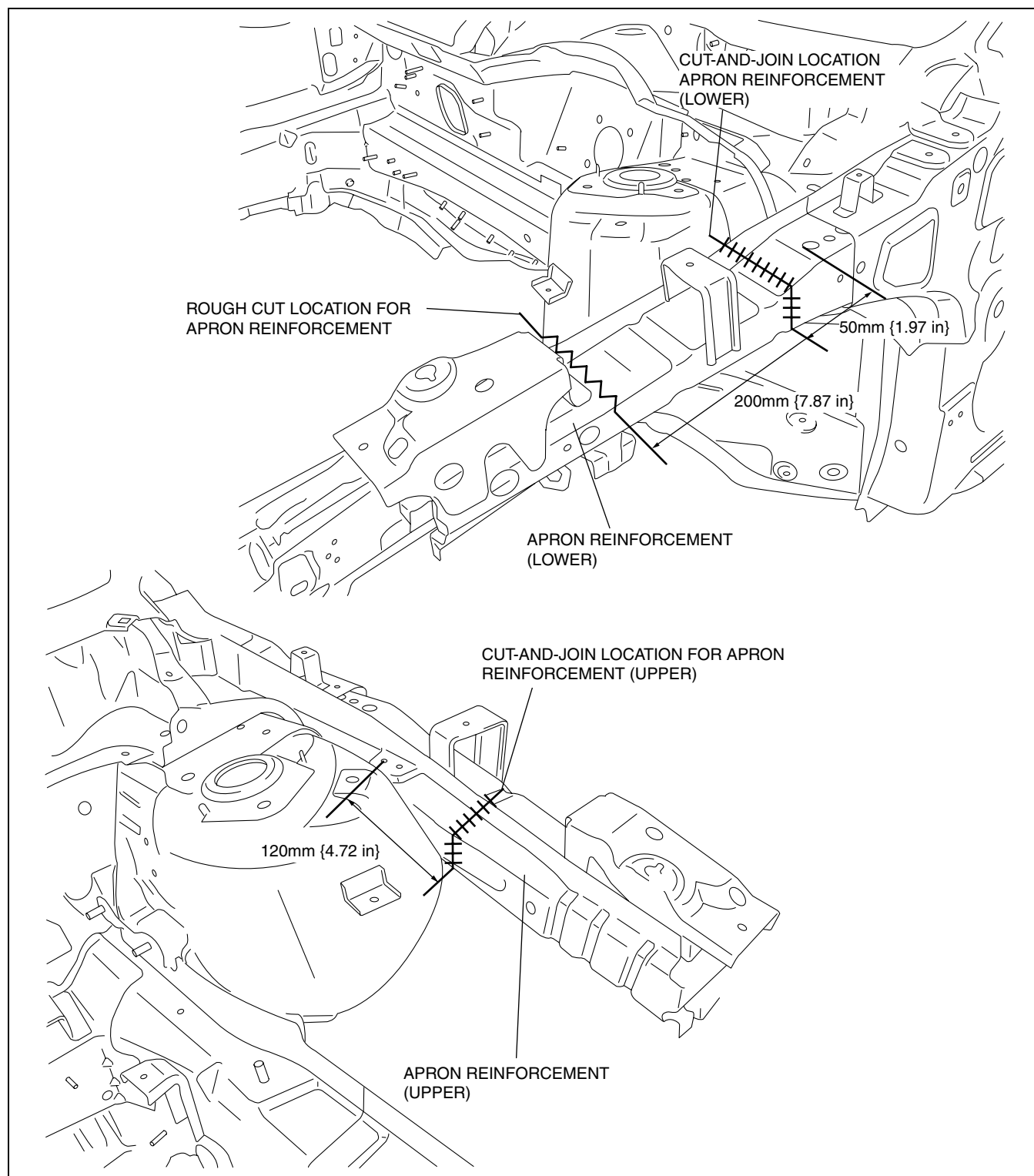
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BODY STRUCTURE [PANEL REPLACEMENT]

APRON REINFORCEMENT (PARTIAL CUTTING) REMOVAL

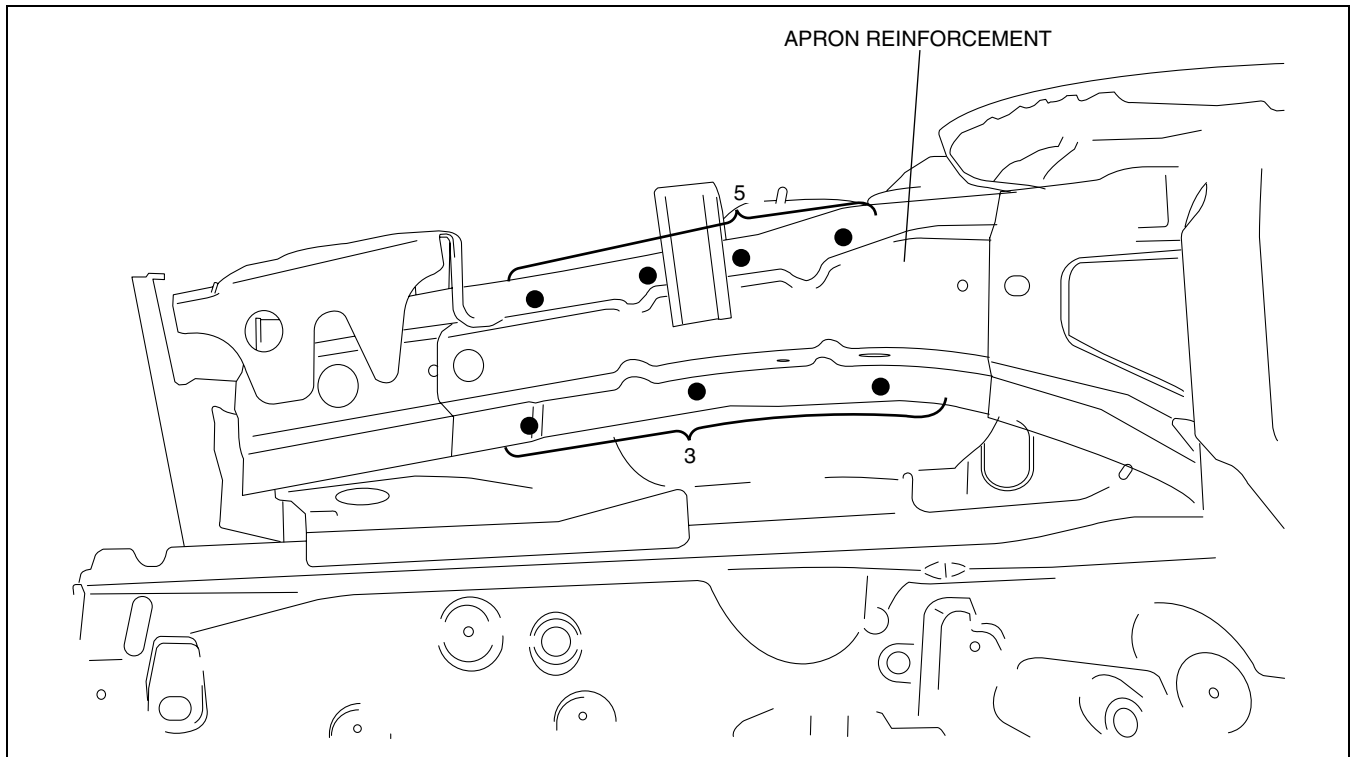
C3U098053260B03

1. Rough cut at the locations shown in the figure to remove damaged parts.
2. Remove the apron reinforcement.



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BODY STRUCTURE [PANEL REPLACEMENT]



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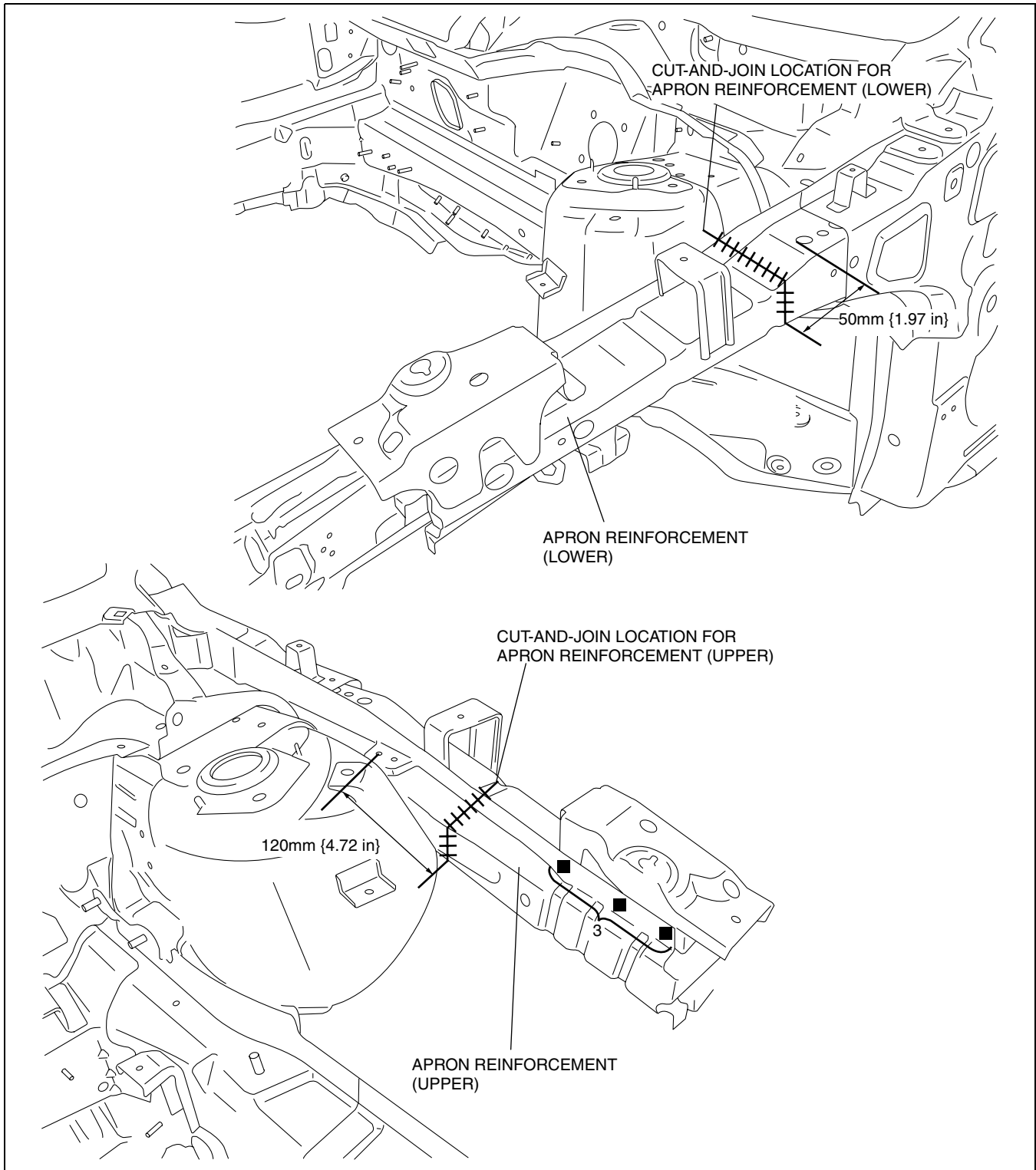
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BODY STRUCTURE [PANEL REPLACEMENT]

APRON REINFORCEMENT (PARTIAL CUTTING) INSTALLATION

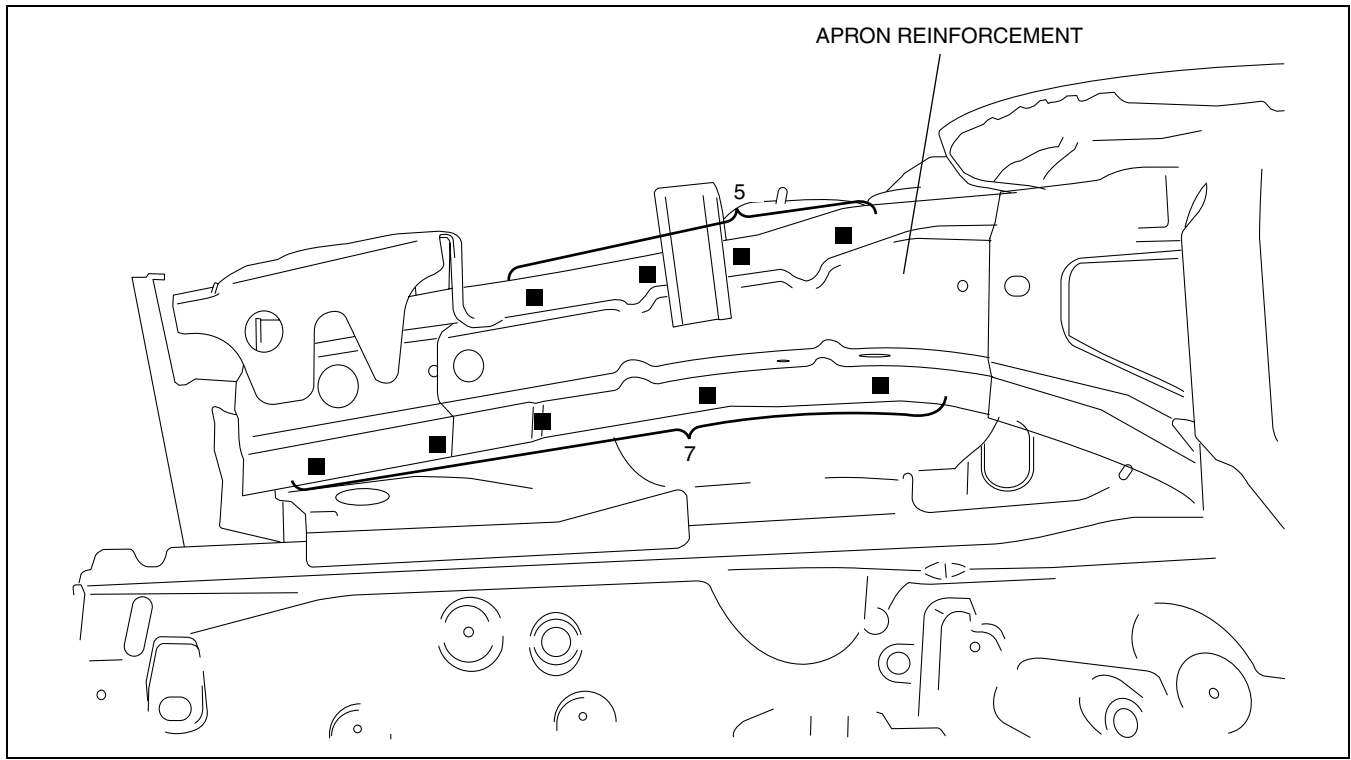
C3U098053260B04

1. When installing new parts, measure and adjust the body as necessary to conform with standard dimensions.
2. Drill holes for plug welds before installing new parts.
3. After temporarily installing new parts, make sure the related parts fit properly.



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BODY STRUCTURE [PANEL REPLACEMENT]



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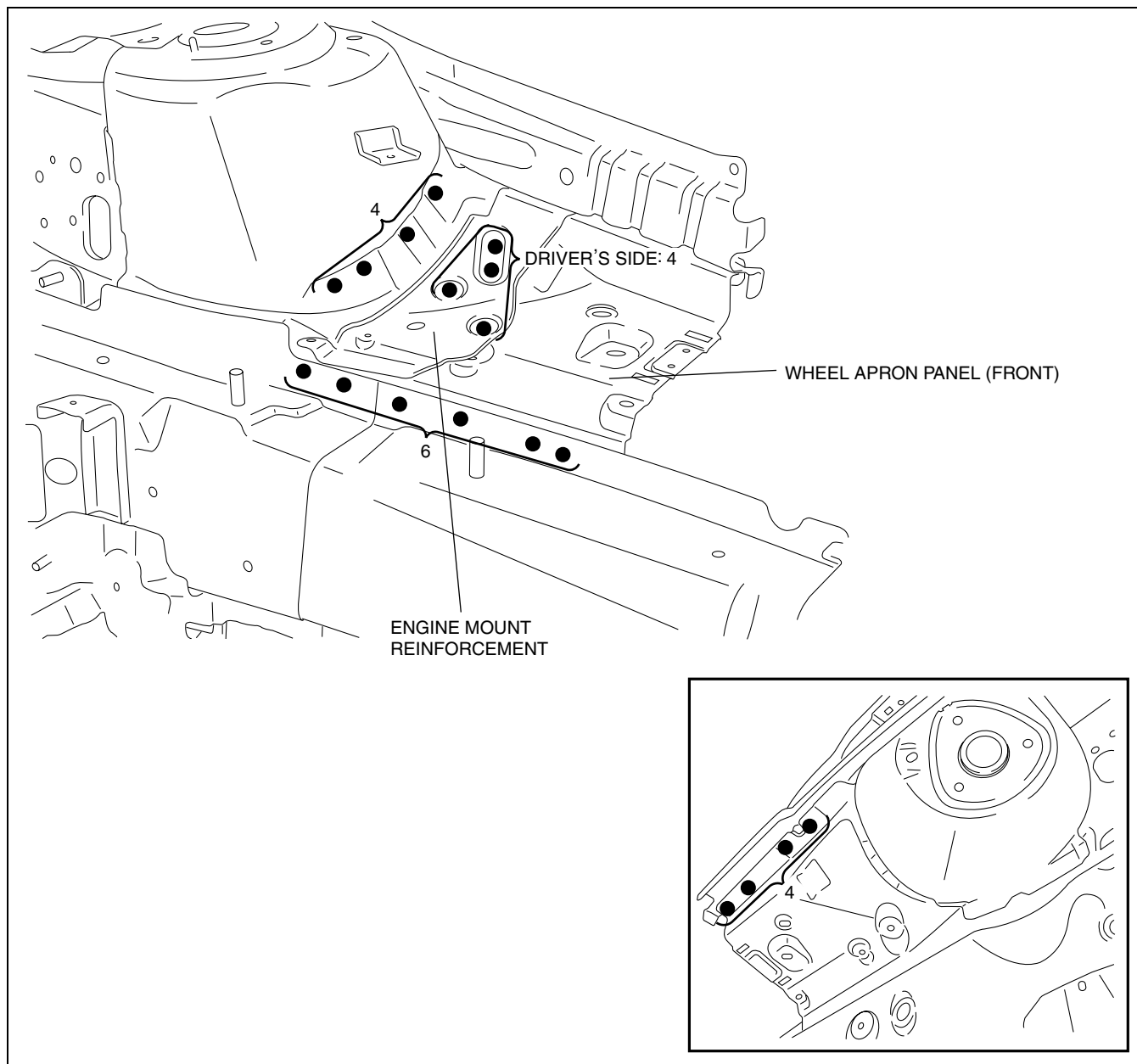
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BODY STRUCTURE [PANEL REPLACEMENT]

WHEEL APRON PANEL (FRONT) REMOVAL

C3U098053210B01

1. Remove the wheel apron panel (front).



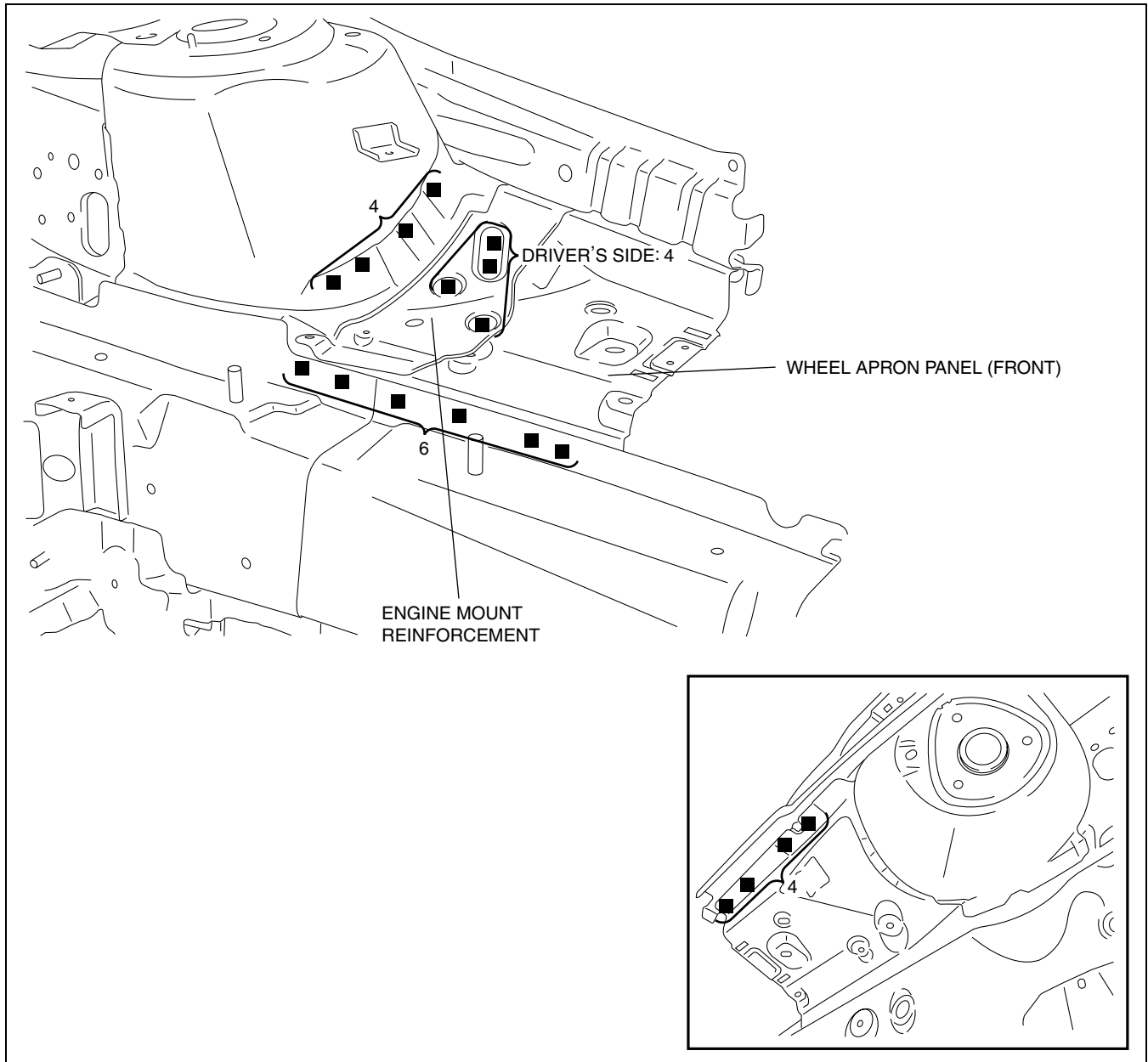
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BODY STRUCTURE [PANEL REPLACEMENT]

WHEEL APRON PANEL (FRONT) INSTALLATION

C3U098053210B02

1. When installing new parts, measure and adjust the body as necessary to conform with standard dimensions.
2. Drill holes for plug welds before installing new parts.
3. After temporarily installing new parts, make sure the related parts fit properly.



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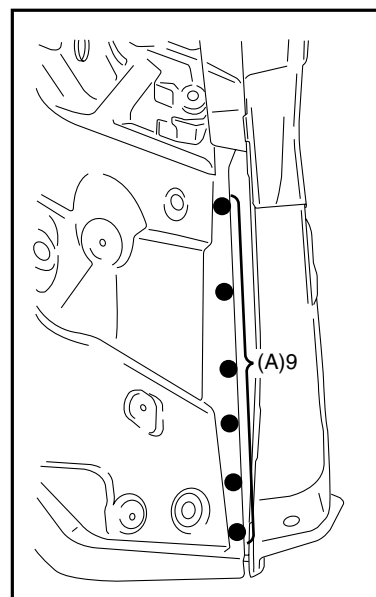
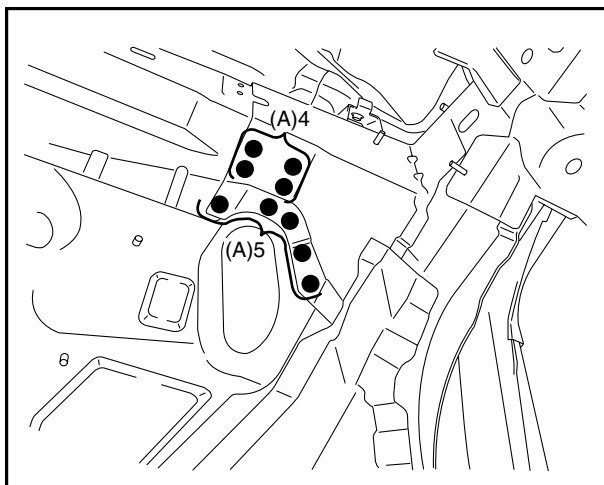
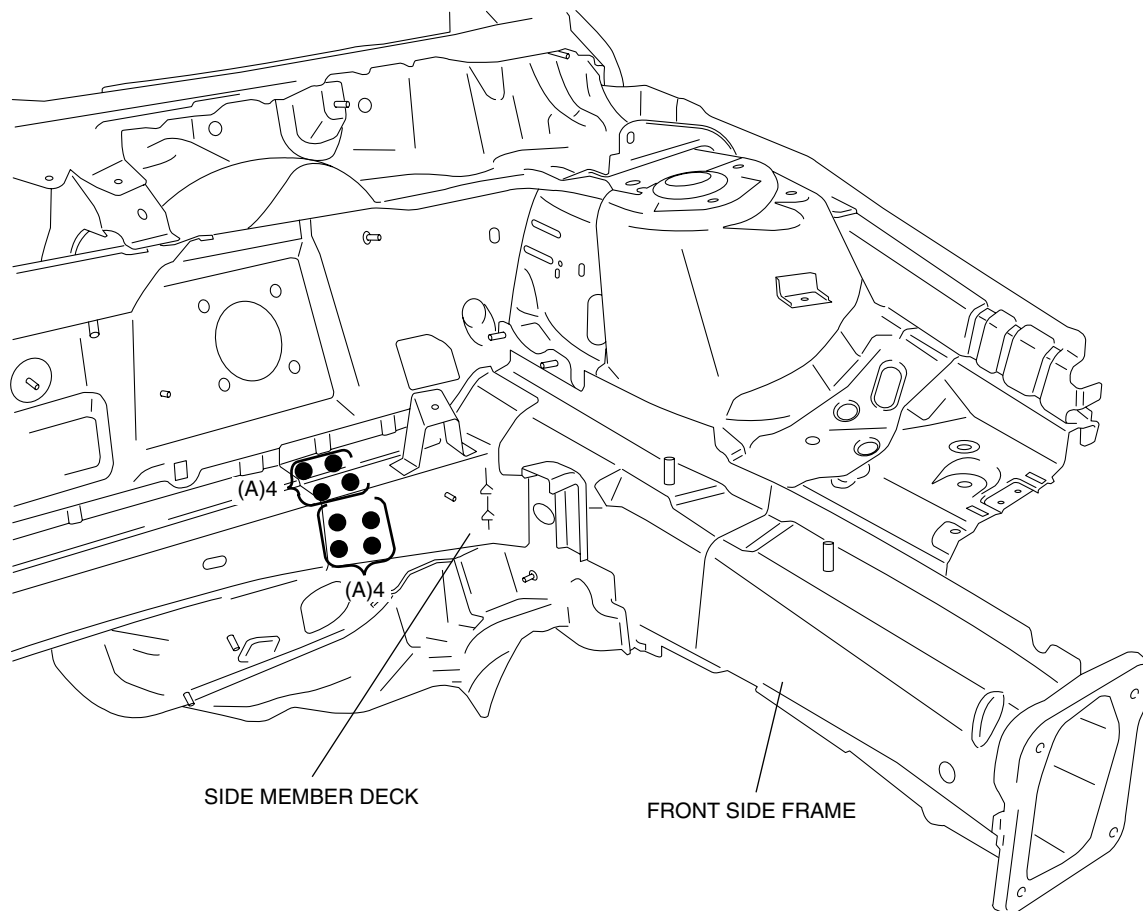
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BODY STRUCTURE [PANEL REPLACEMENT]

FRONT SIDE FRAME COMPONENT REMOVAL

C3U098053300B01

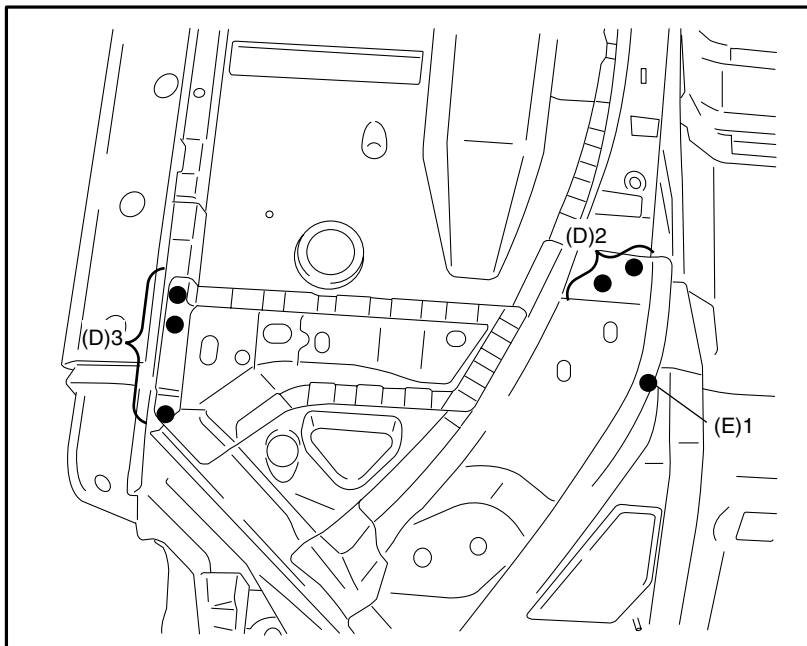
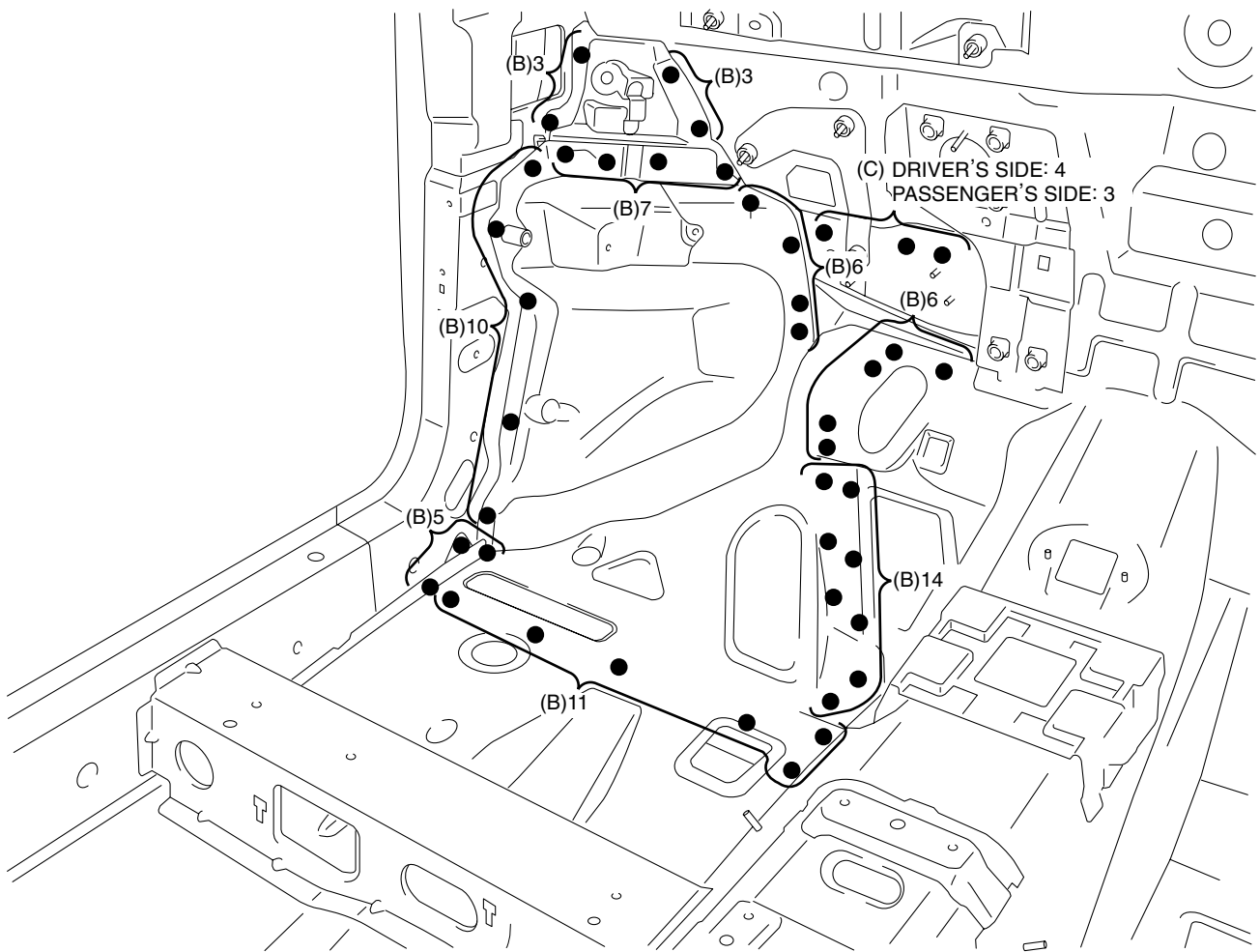
1. Drill the 26 locations indicated by (A).



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BODY STRUCTURE [PANEL REPLACEMENT]

2. Drill the 65 locations indicated by (B), 4 locations on the driver's side indicated by (C), and 3 locations on the passenger's side.
3. Drill the 5 locations indicated by (D) from the bottom.
4. Drill the 1 location indicated by (E) from the bottom, as it cannot be seen from the interior.



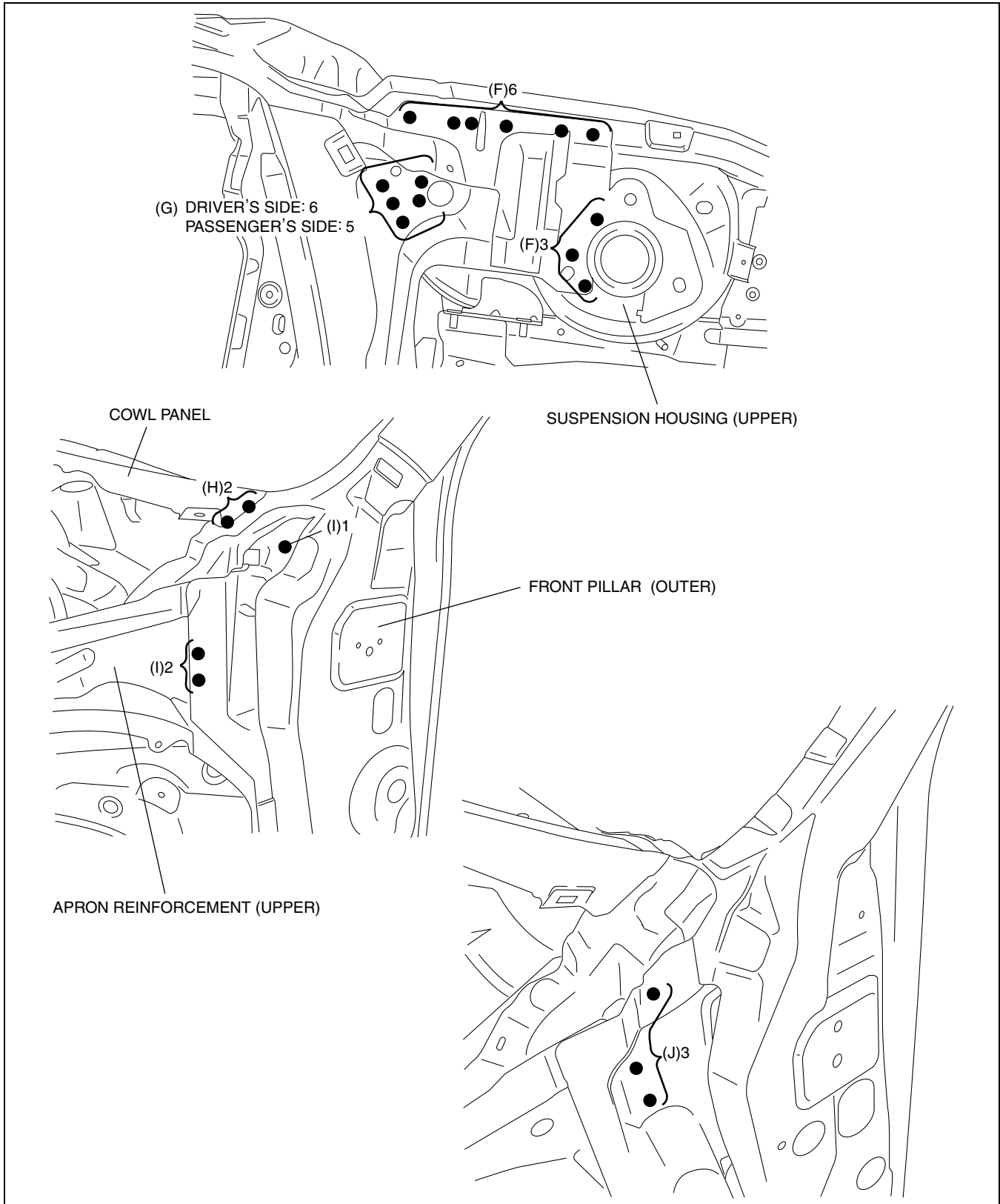
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BODY STRUCTURE [PANEL REPLACEMENT]

5. Drill the 9 locations indicated by (F), 6 locations on the driver's side indicated by (G), 5 locations on the passenger's side.
6. When the front side frame component is being removed, the hinge pillar (inner) may interfere with the apron reinforcement (upper) and make removal difficult, drill the 2 locations indicated by (H), 3 locations indicated by (I), and then open the front pillar (outer) outward.
7. Drill the 3 locations indicated by (J), and remove the front side frame component.



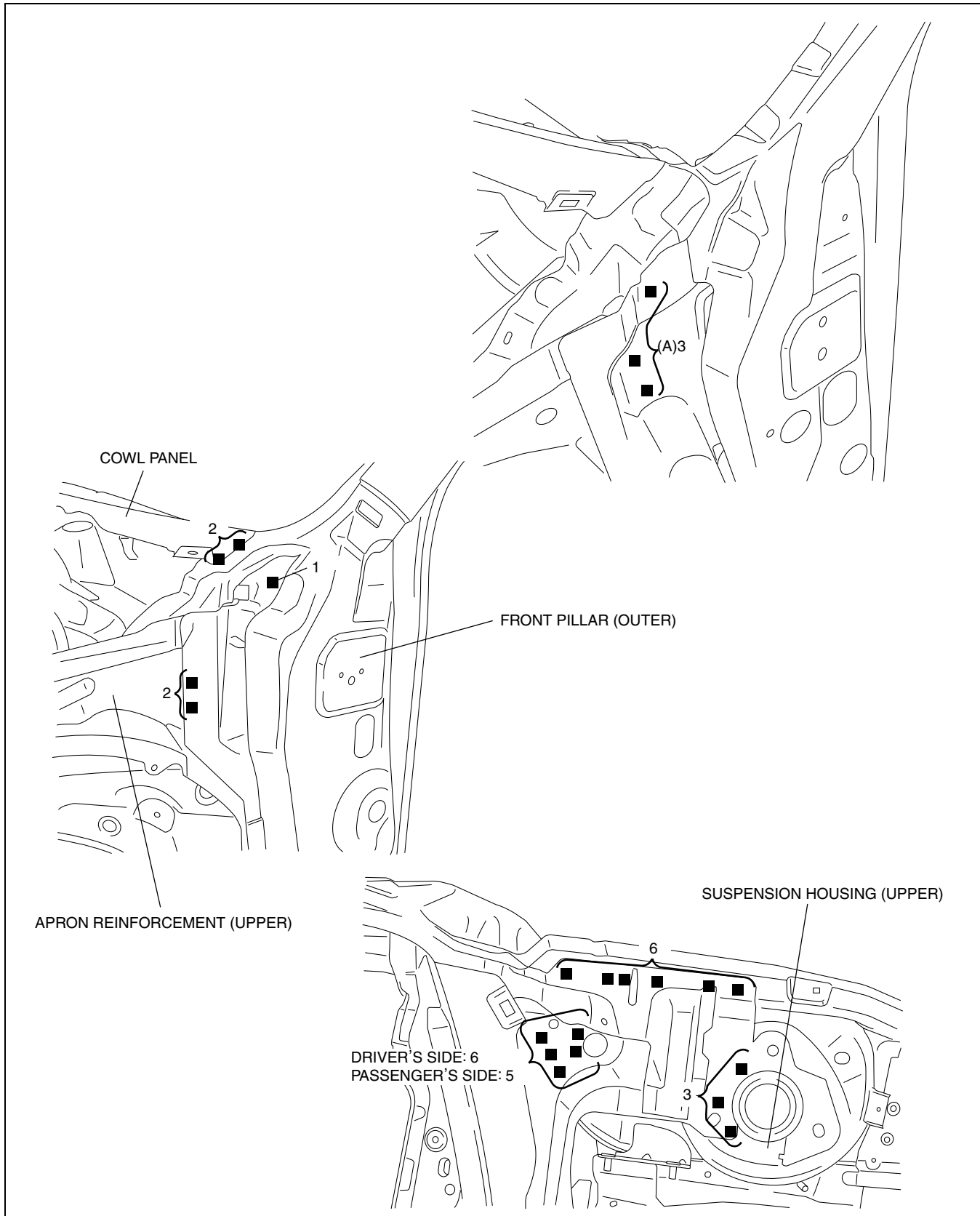
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BODY STRUCTURE [PANEL REPLACEMENT]

FRONT SIDE FRAME COMPONENT INSTALLATION

C3U098053300B02

1. When installing new parts, measure and adjust the body as necessary to conform with standard dimensions.
2. Drill holes for plug welds before installing new parts.
3. Weld the 3 locations indicated by (A) and temporarily install the front side frame component.
4. After temporarily installing new parts, make sure the related parts fit properly.
5. Weld the remaining weld locations and install the front side frame component.

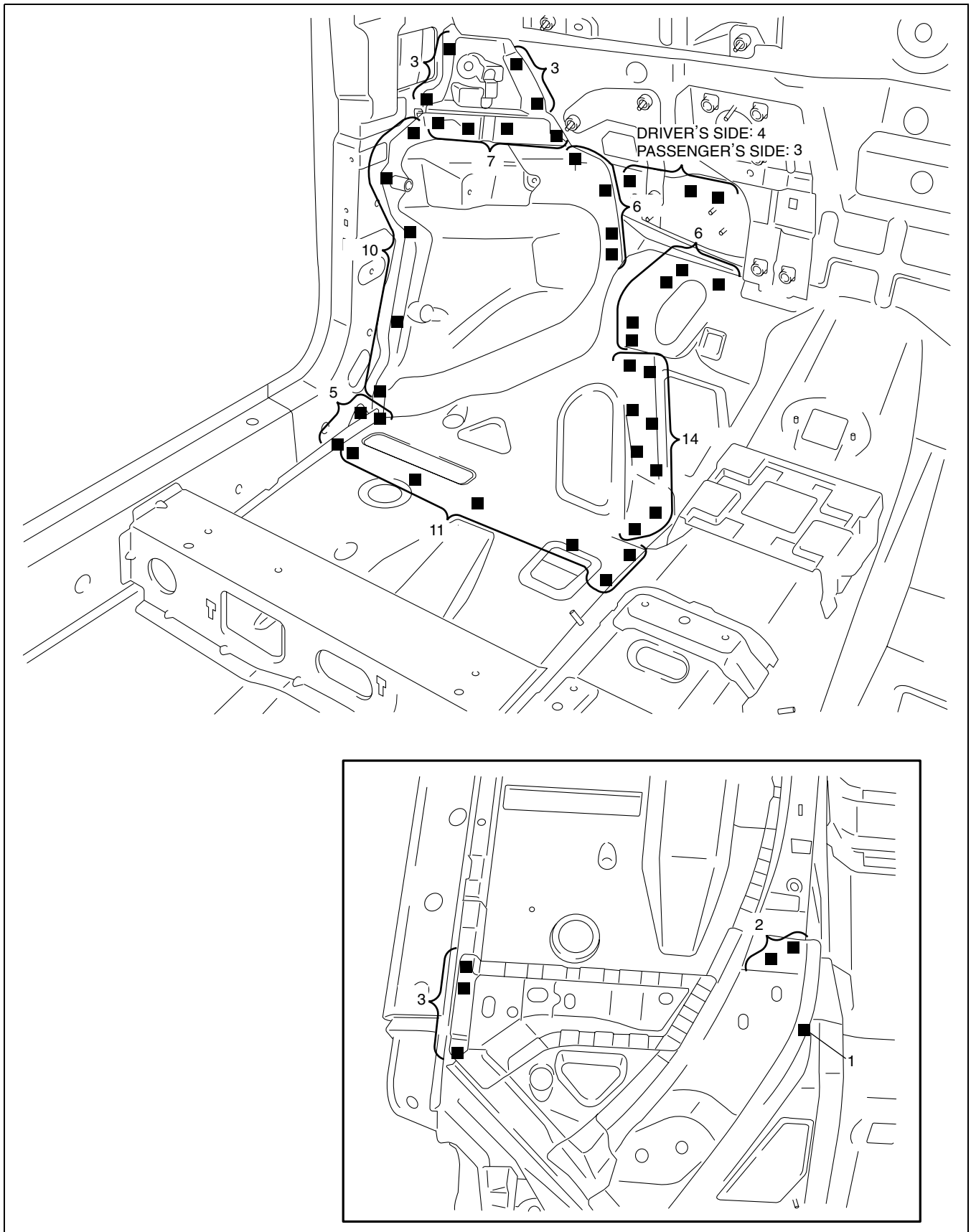


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BODY STRUCTURE [PANEL REPLACEMENT]

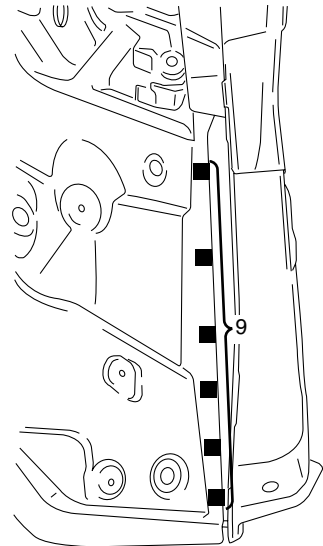
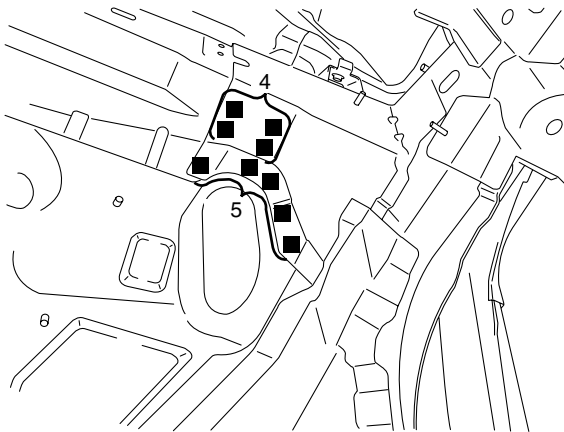
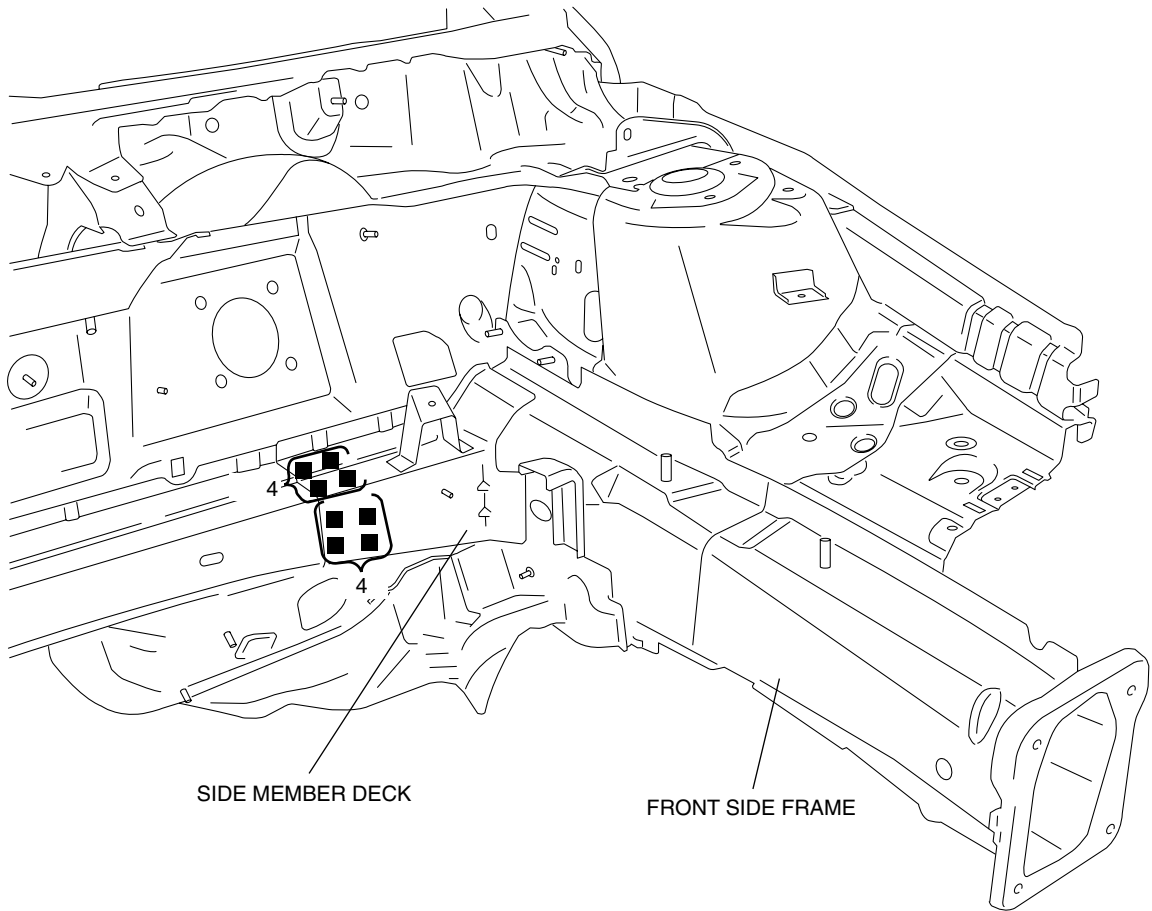


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BODY STRUCTURE [PANEL REPLACEMENT]

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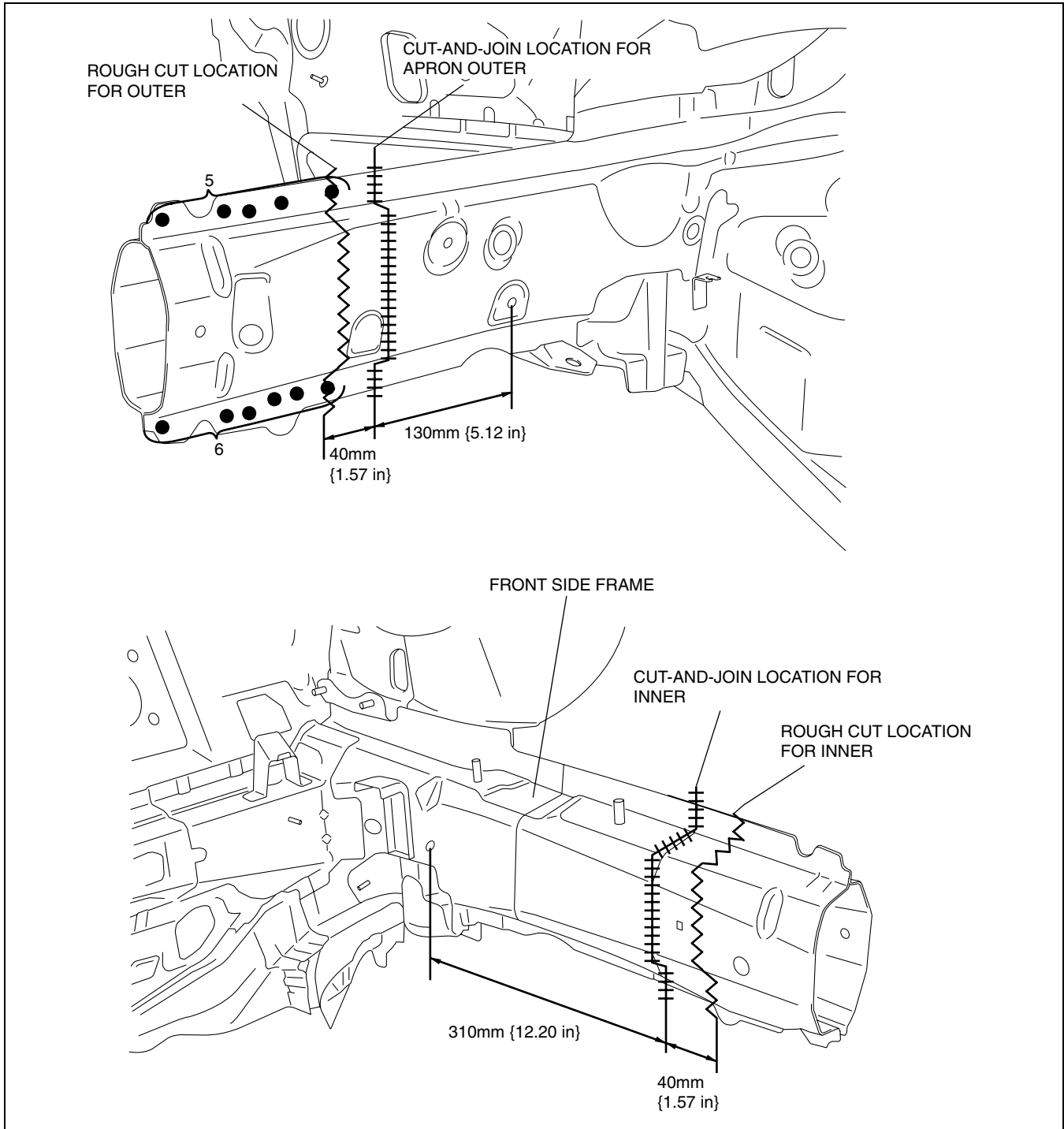
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BODY STRUCTURE [PANEL REPLACEMENT]

FRONT SIDE FRAME (PARTIAL CUTTING) REMOVAL

C3U098053300B03

1. Rough cut and remove the damaged part of the front side frame.



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FRONT SIDE FRAME (PARTIAL CUTTING) INSTALLATION

C3U098053300B04

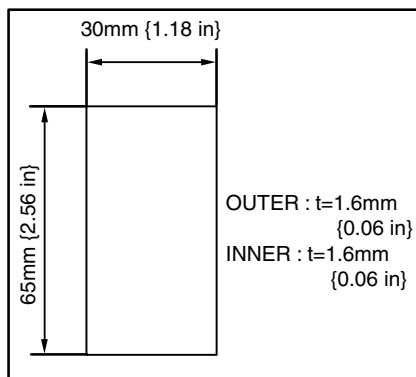
Caution

- The cut-and-joint area indicates the maximum size range of the installation position.

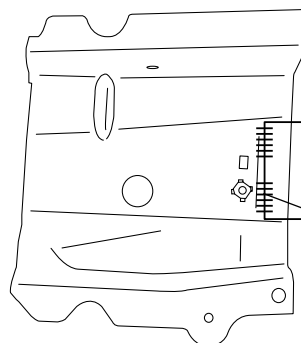
1. Make a reinforcement panel using the material of the front side frame.
2. To cut-and-join the new and existing parts, cut at the locations for the new part indicated in the figure below and bevel the locations where the new and existing parts are joined.
3. When installing the new parts, trial-fit new and existing parts, and then measure and adjust the body to conform with standard dimensions.

BODY STRUCTURE [PANEL REPLACEMENT]

4. To install the inner, trial-fit the new and existing parts, weld the existing parts and the reinforcement, and then butt weld the new and existing parts.
5. Because the outer cannot be welded to the existing parts from the inside of the frame, drill 2 plug weld holes at the locations indicated by (A) on the existing parts. Install the reinforcement and the existing parts by plug welding from the outside of the frame, then butt weld the new and existing parts.
6. Grind the area where the inner and outer are butt welded with a disk grinder to finish the surface.

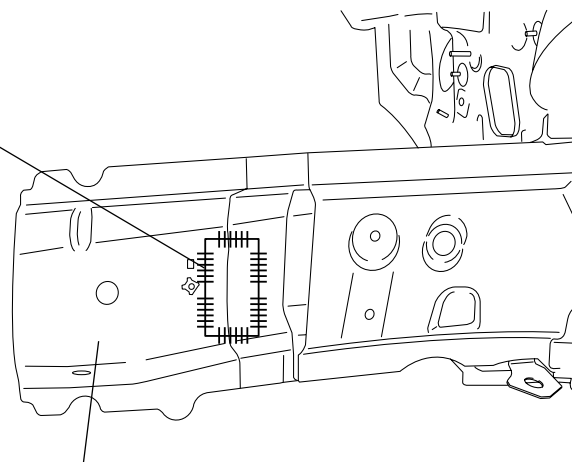


REINFORCEMENT

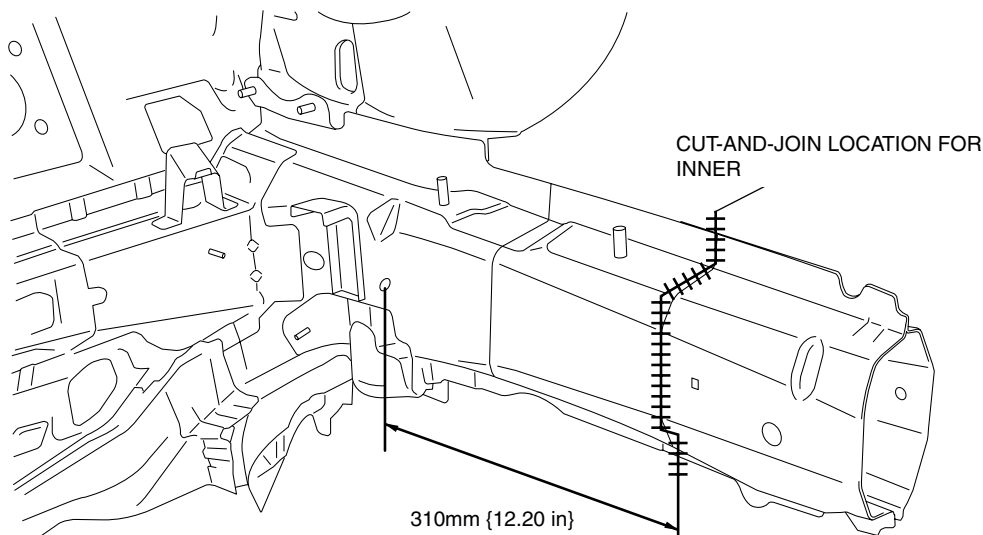


NEW FRONT SIDE FRAME (INNER)

L=10mm {0.39 in} x 6



FRONT SIDE FRAME (INNER)

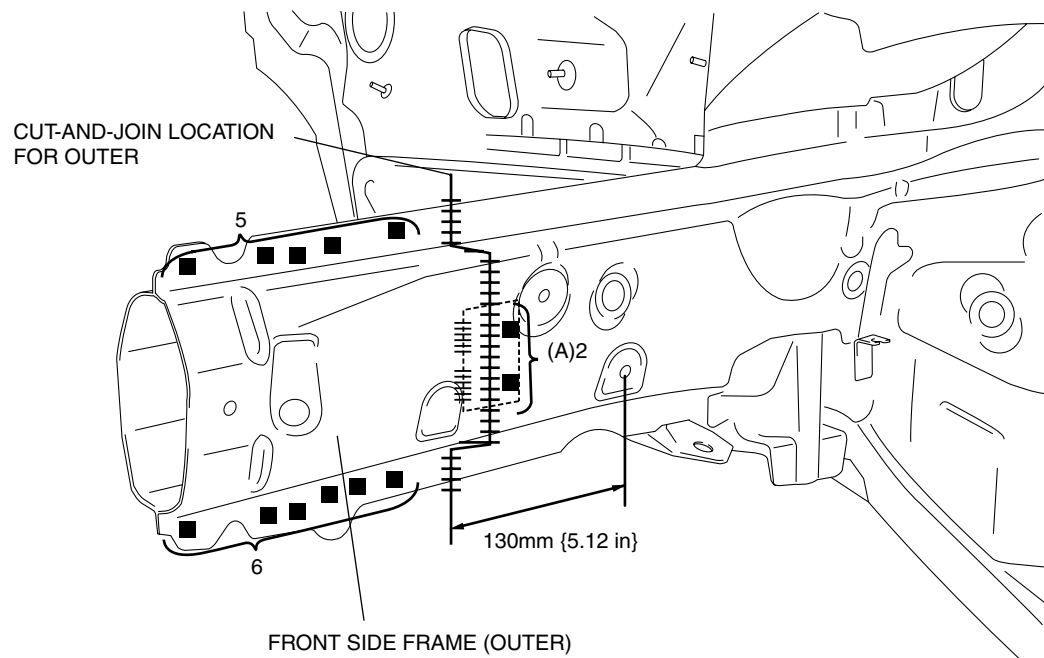
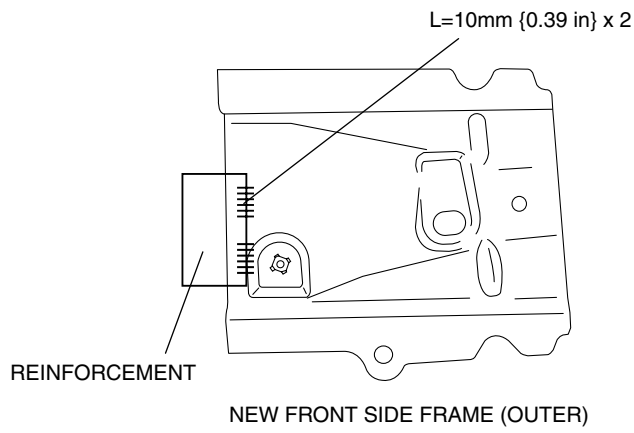


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BODY STRUCTURE [PANEL REPLACEMENT]



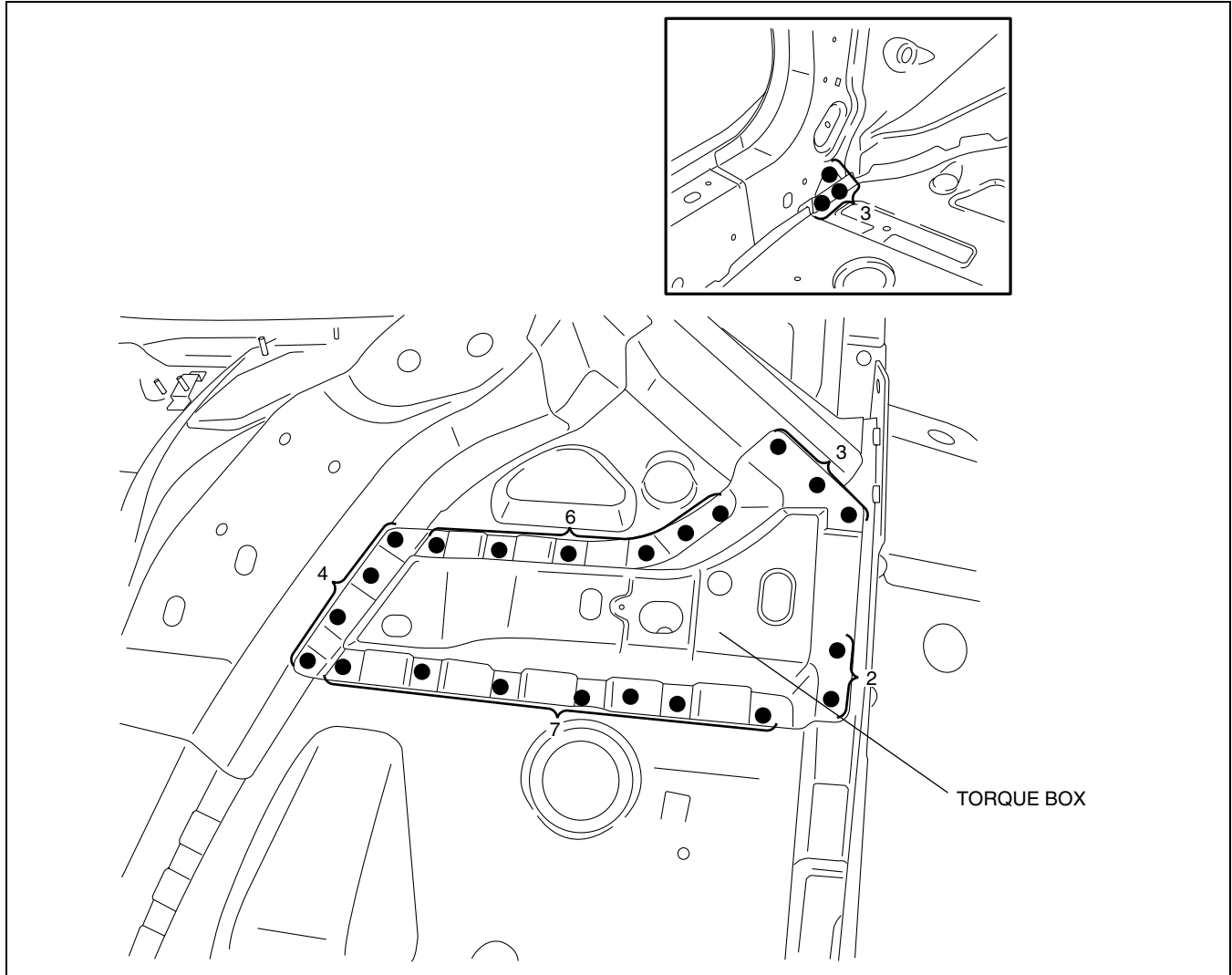
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BODY STRUCTURE [PANEL REPLACEMENT]

TORQUE BOX REMOVAL

C3U098053381B01

1. Remove the torque box.



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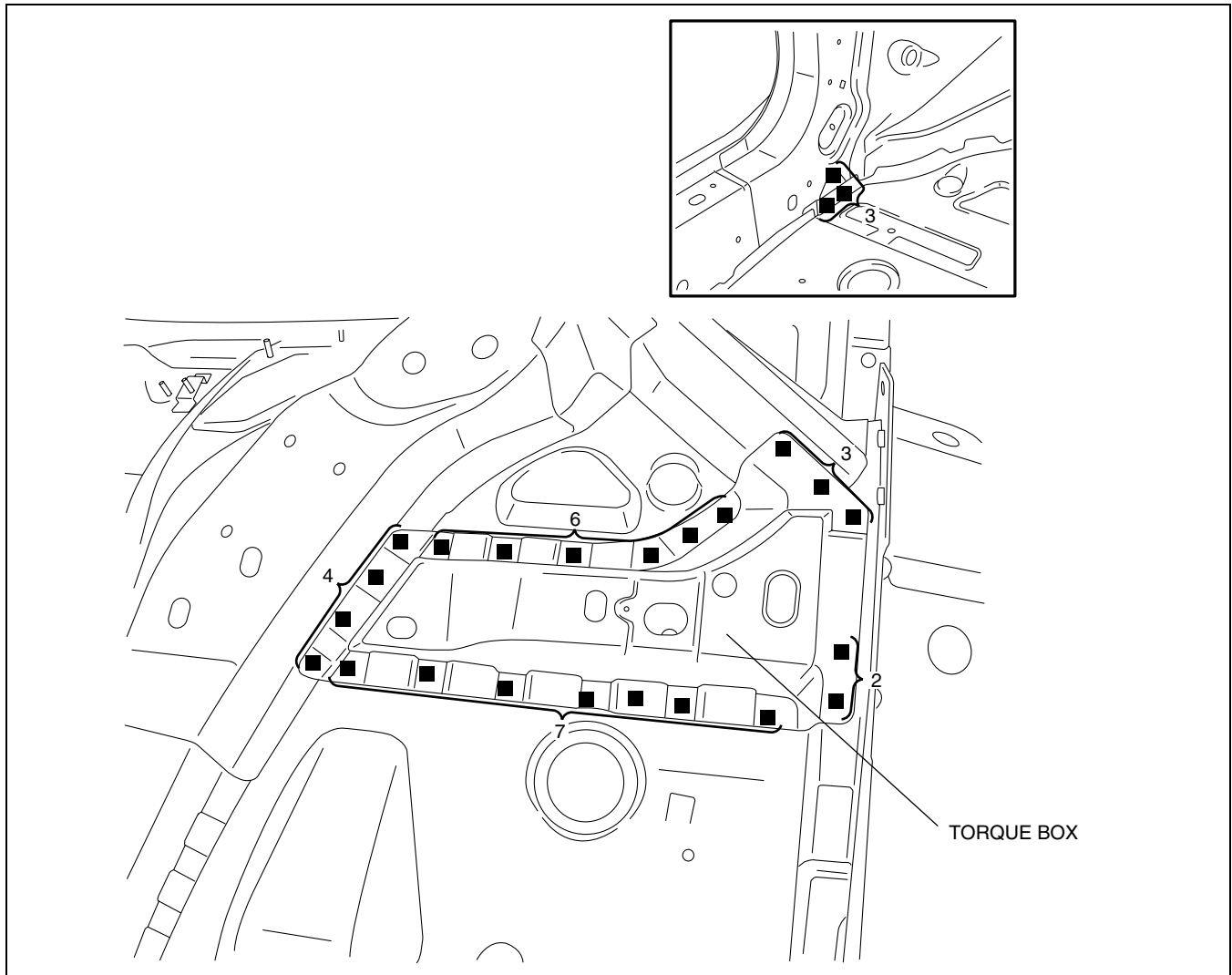
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BODY STRUCTURE [PANEL REPLACEMENT]

TORQUE BOX INSTALLATION

C3U098053381B02

1. When installing new parts, measure and adjust the body as necessary to conform with standard dimensions.
2. Drill holes for plug welds before installing new parts.
3. After temporarily installing new parts, make sure the related parts fit properly.



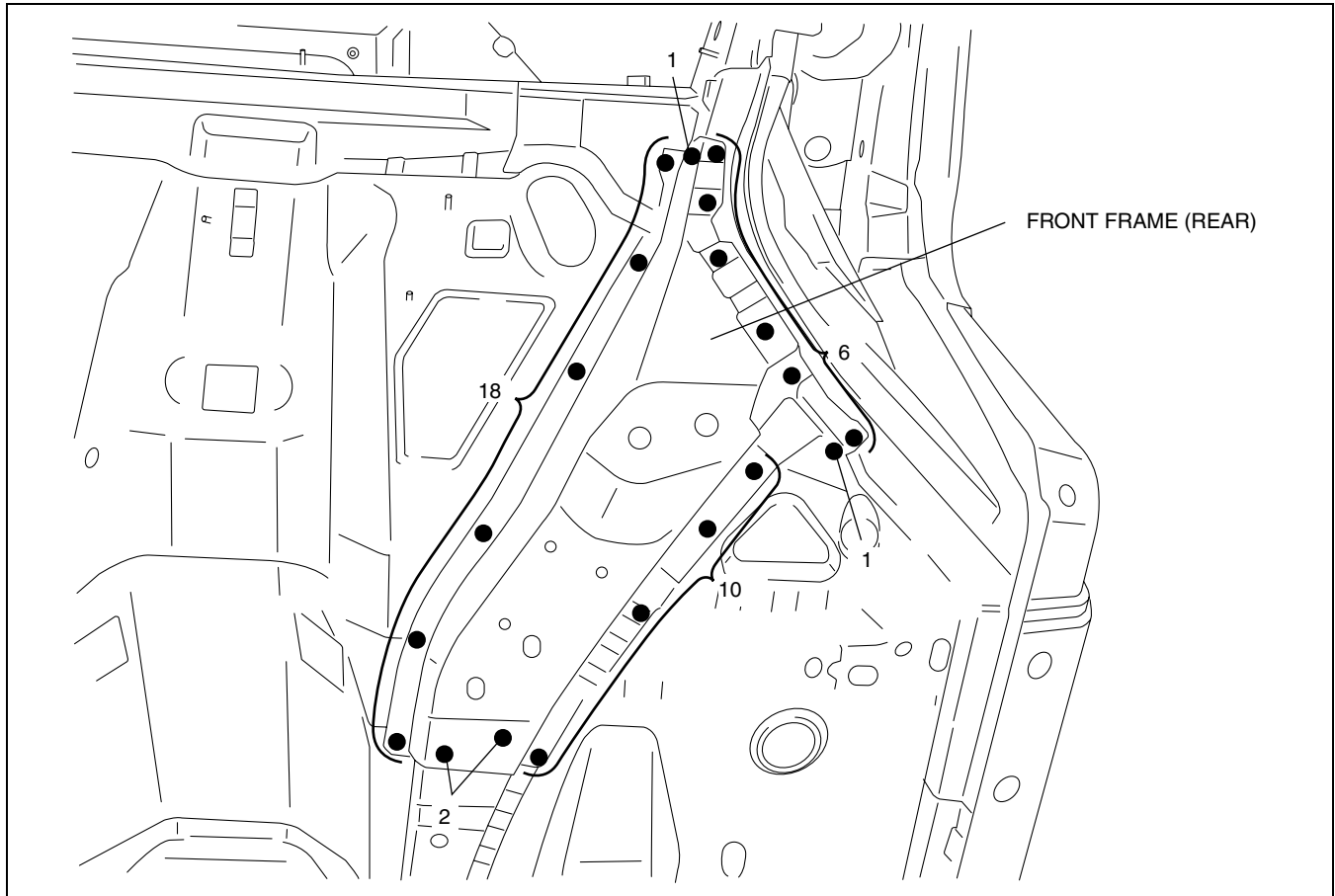
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BODY STRUCTURE [PANEL REPLACEMENT]

FRONT FRAME (REAR) REMOVAL

C3U098053390B01

1. Remove the front frame (rear).



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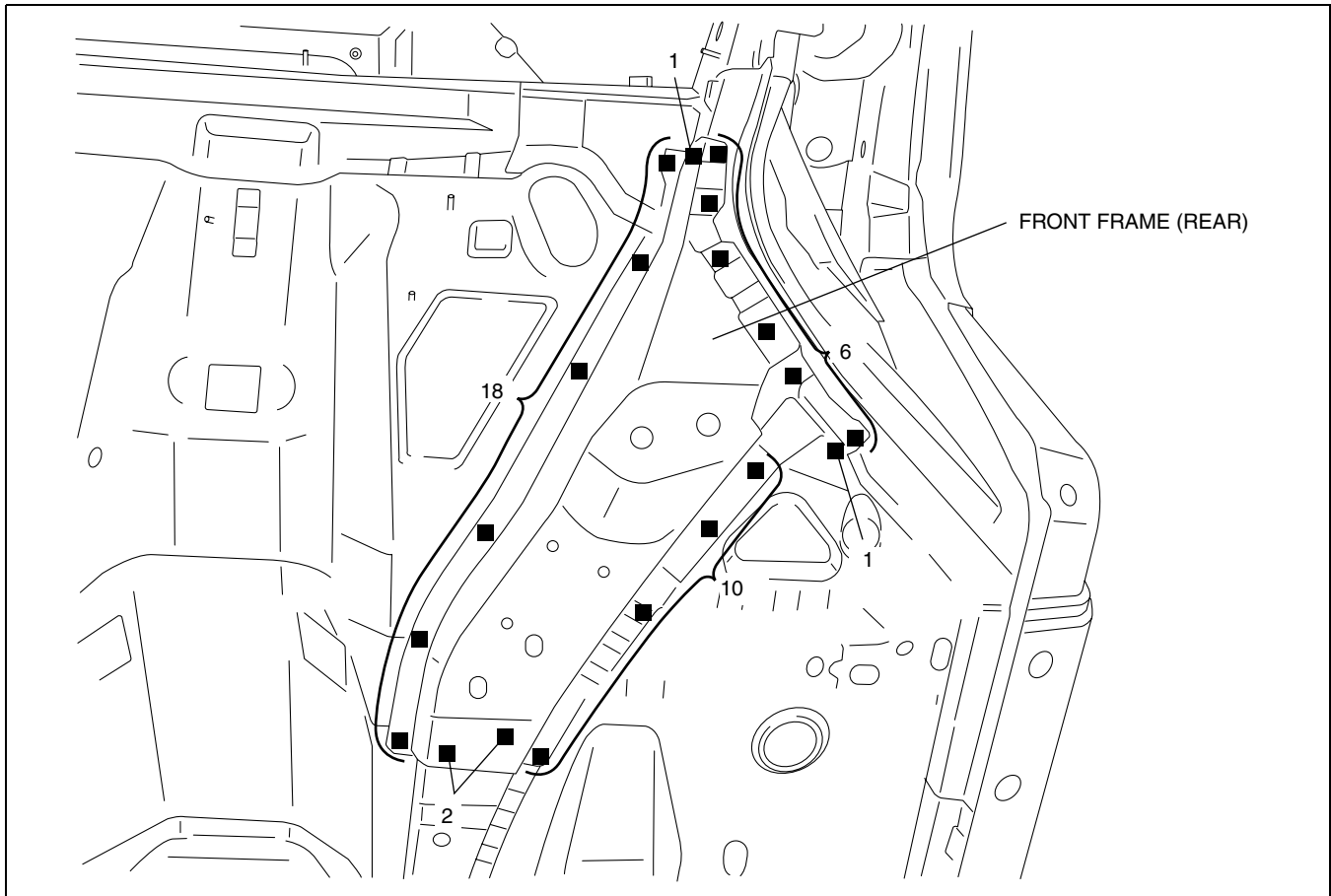
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BODY STRUCTURE [PANEL REPLACEMENT]

FRONT FRAME (REAR) INSTALLATION

C3U098053390B02

1. When installing new parts, measure and adjust the body as necessary to conform with standard dimensions.
2. Drill holes for plug welds before installing new parts.
3. After temporarily installing new parts, make sure the related parts fit properly.



B3E0980B073

FRONT PILLAR REMOVAL

C3U098074090B01

1. Rough cut area (A) and drill the 69 locations indicated by (B).

Caution

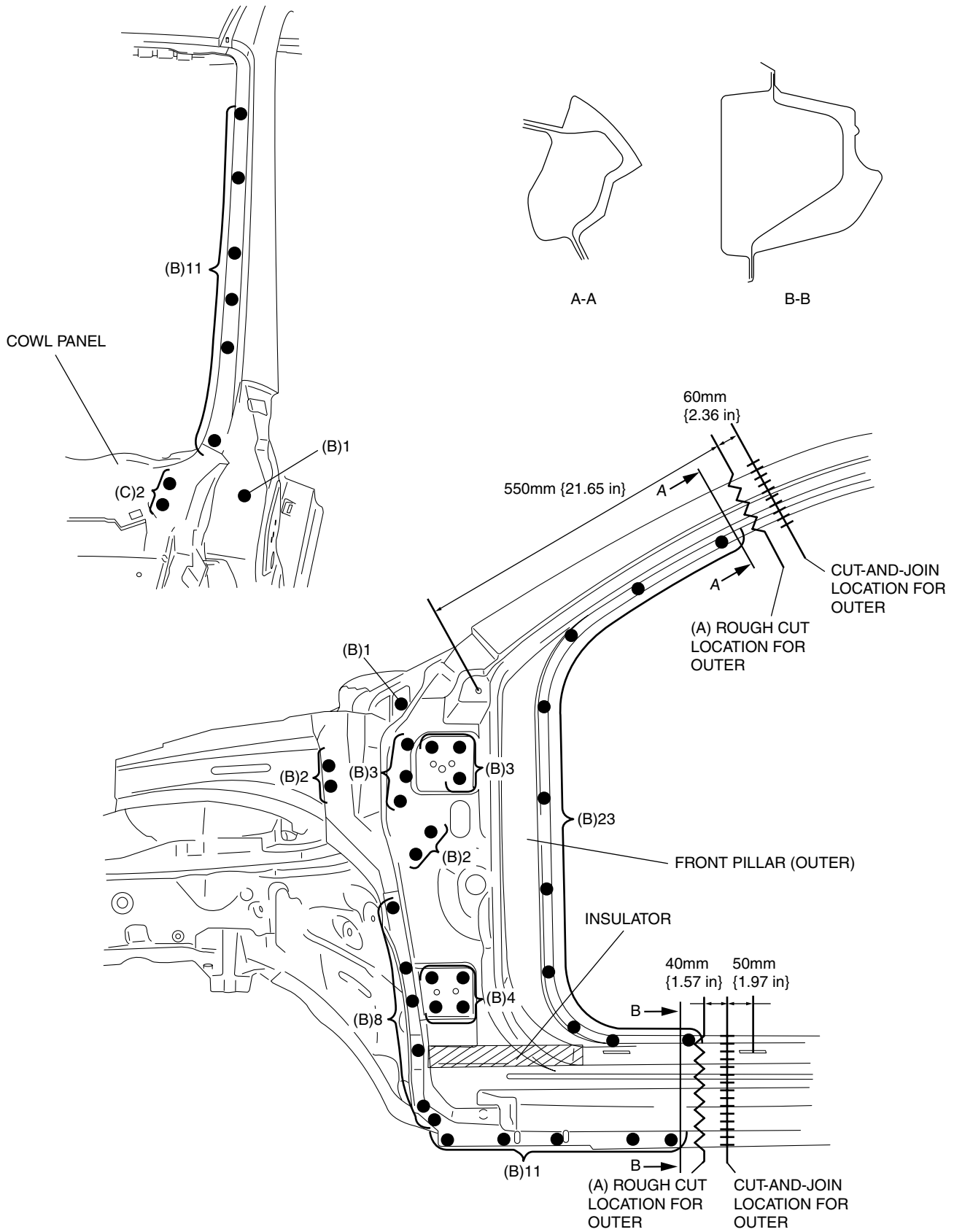
- Avoid cutting with a blowtorch or similar tools as the insulator (shaded area) is flammable.

2. When the front pillar (outer) is being removed, the cowl panel may interfere with the front pillar (outer) and make removal difficult. Therefore, drill the 2 locations indicated by (C) and then open the cowl panel outward.
3. Remove the front pillar (outer).

BODY STRUCTURE [PANEL REPLACEMENT]

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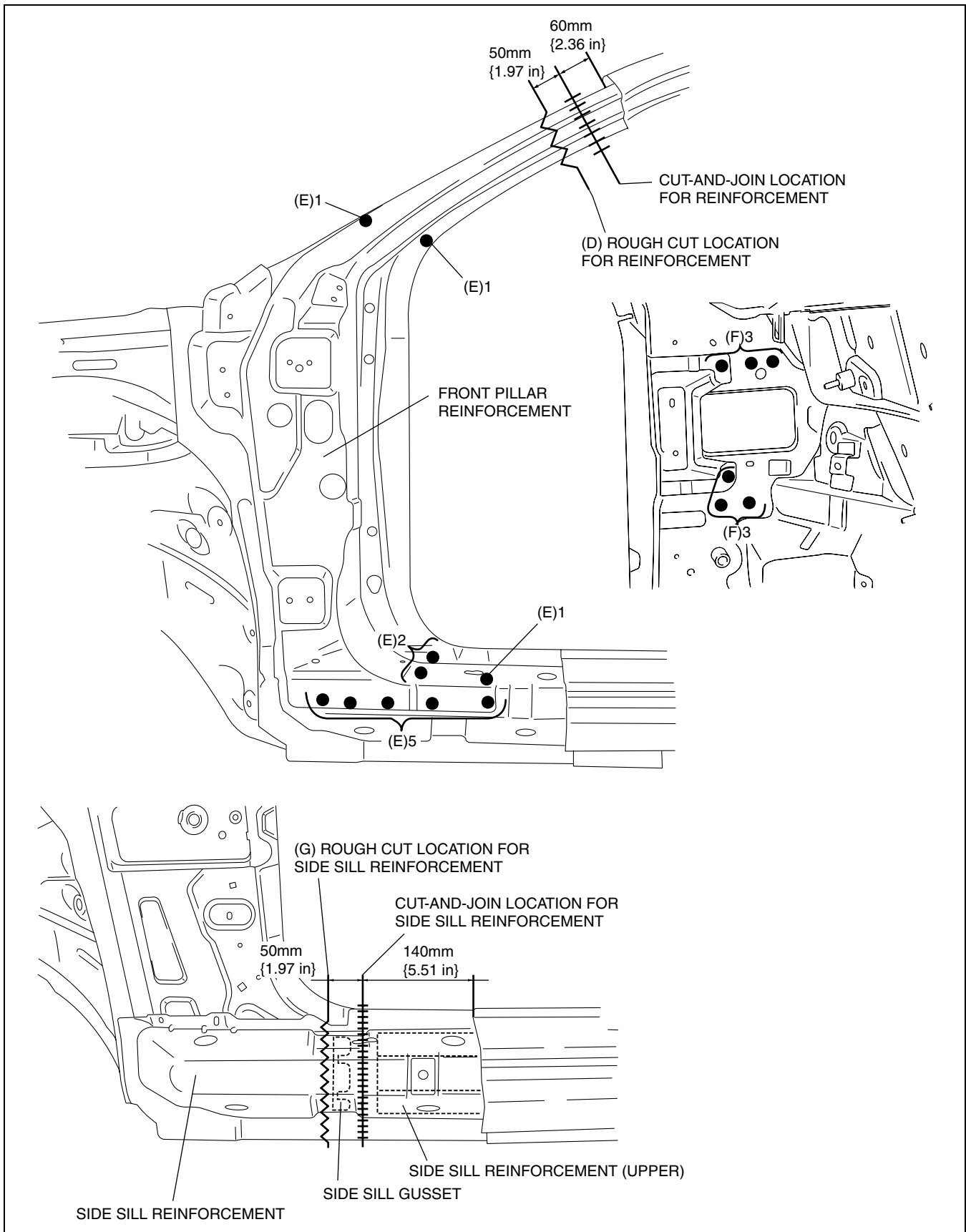
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BODY STRUCTURE [PANEL REPLACEMENT]

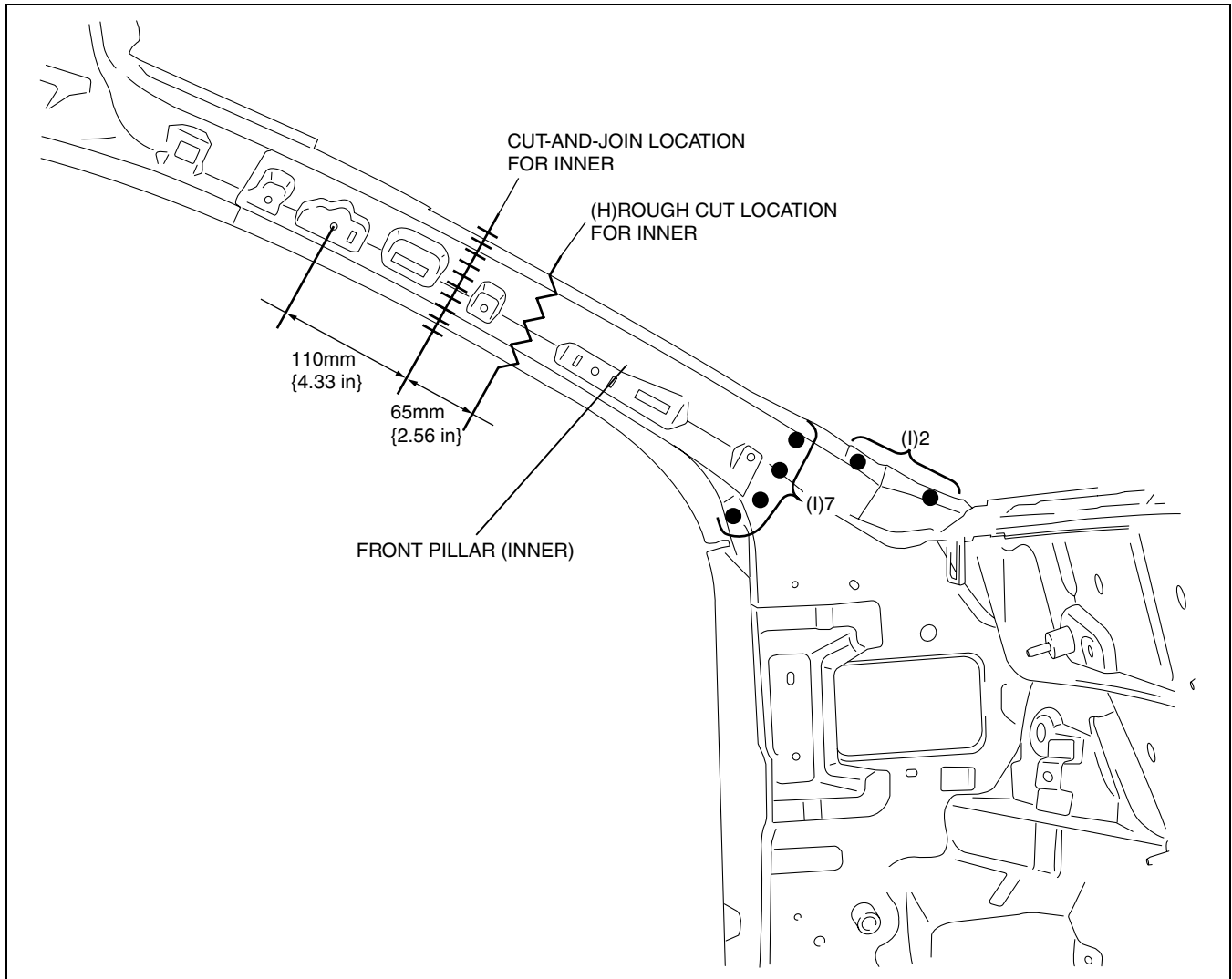
4. Rough cut area (D) and drill the 10 locations indicated by (E).
5. Drill the 6 locations indicated by (F) from the interior.
6. Remove the front pillar reinforcement.
7. Rough cut area (G) and remove the side sill reinforcement.



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BODY STRUCTURE [PANEL REPLACEMENT]

8. Rough cut area (H), drill the 9 locations indicated by (I), and then remove the front pillar (inner).



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BODY STRUCTURE [PANEL REPLACEMENT]

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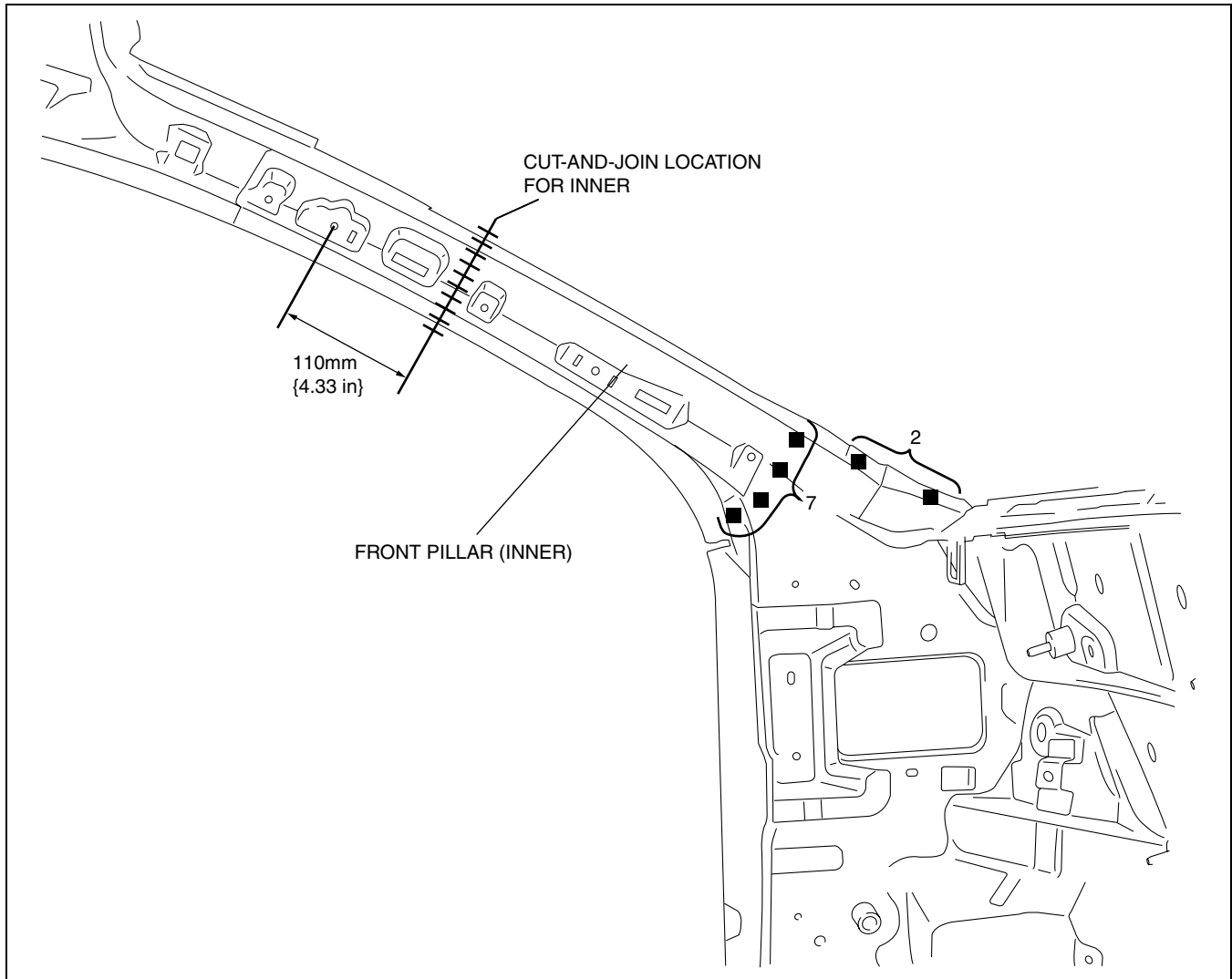
FRONT PILLAR INSTALLATION

1. When joining and cutting the new and existing parts, trial fit the new part in position, and then measure and adjust the body as necessary to conform with standard dimensions.
2. Drill holes for plug welds before installing new parts.

Note

- In areas where the outer, reinforcement, inner, and other parts are in 3-4 layers, drill holes for plug welds in all but the innermost panel.

3. After temporarily installing new parts, make sure the related parts fit properly.

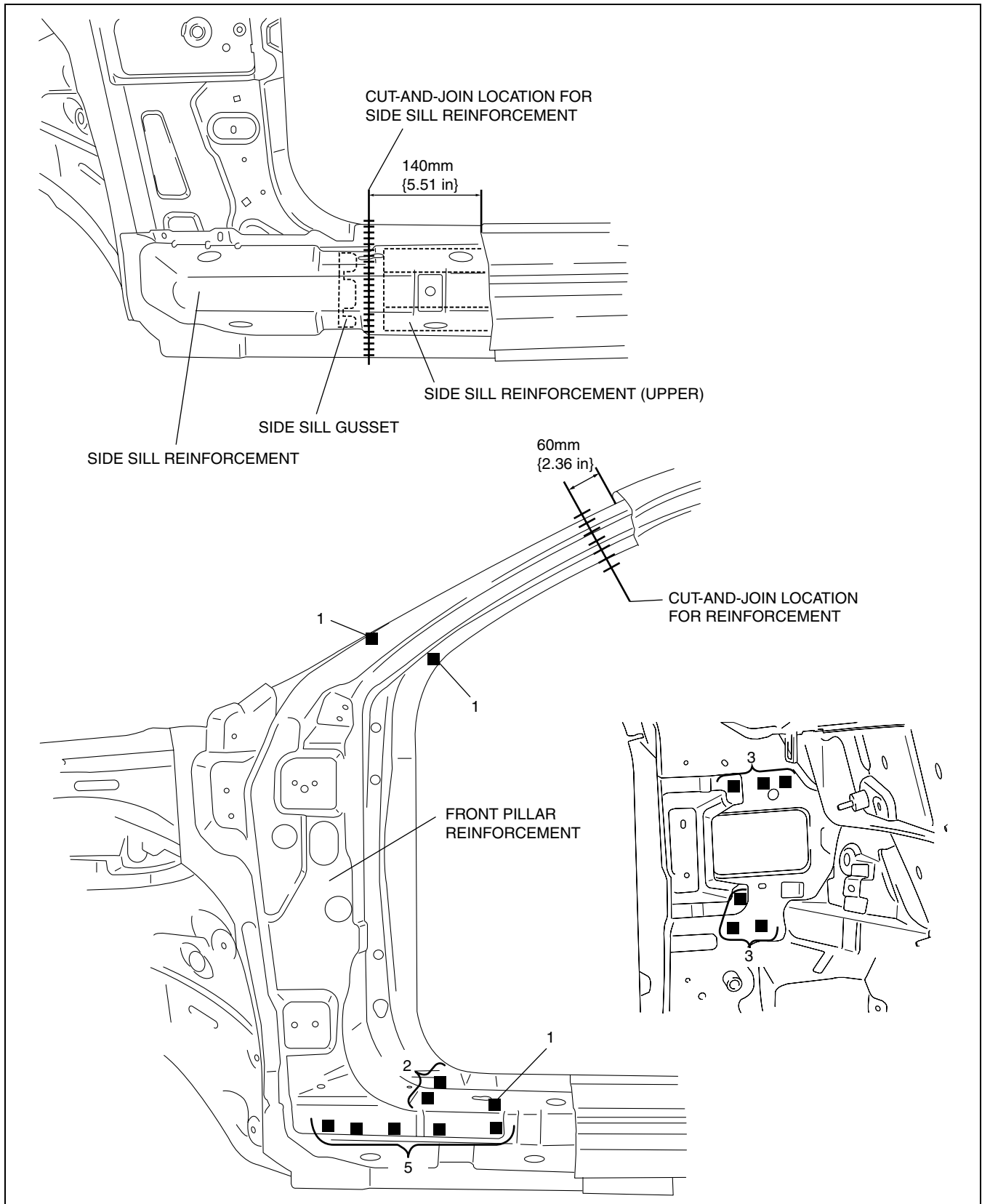


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BODY STRUCTURE [PANEL REPLACEMENT]

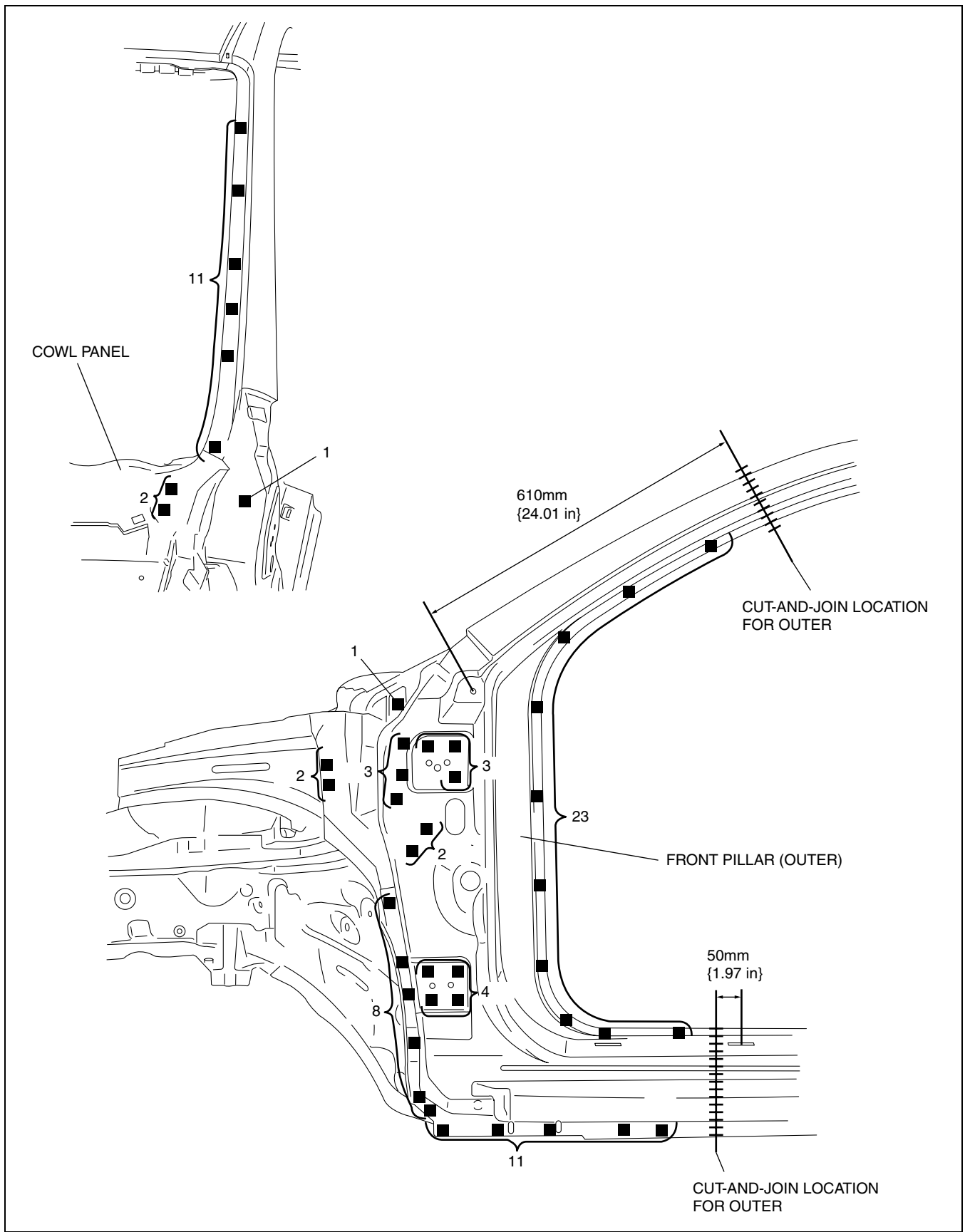
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BODY STRUCTURE [PANEL REPLACEMENT]



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BODY STRUCTURE [PANEL REPLACEMENT]

CENTER PILLAR REMOVAL

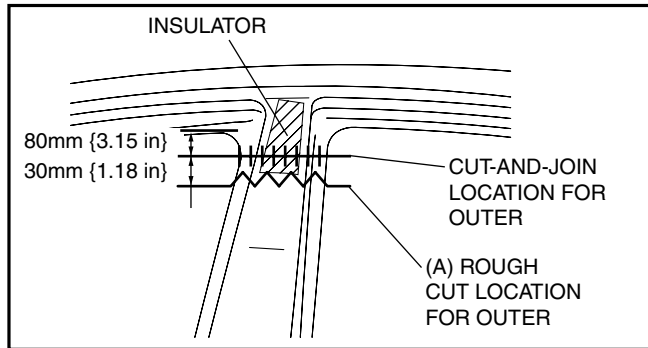
C3U098070350B01

1. Rough cut area (A), drill the 59 locations indicated by (B), and then remove the center pillar (outer).

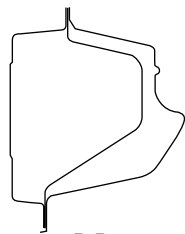
Caution

- Avoid cutting with a blowtorch or similar tools as the insulator (shaded area) is flammable.

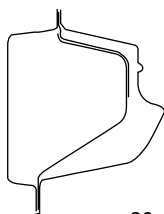
2. Rough cut area (C), drill the 18 locations indicated by (D), and then remove the center pillar reinforcement.
3. Rough cut area (E), drill the 4 locations indicated by (F), and then remove the side sill reinforcement.
4. Drill the 19 locations indicated by (G) and remove the center pillar (inner).



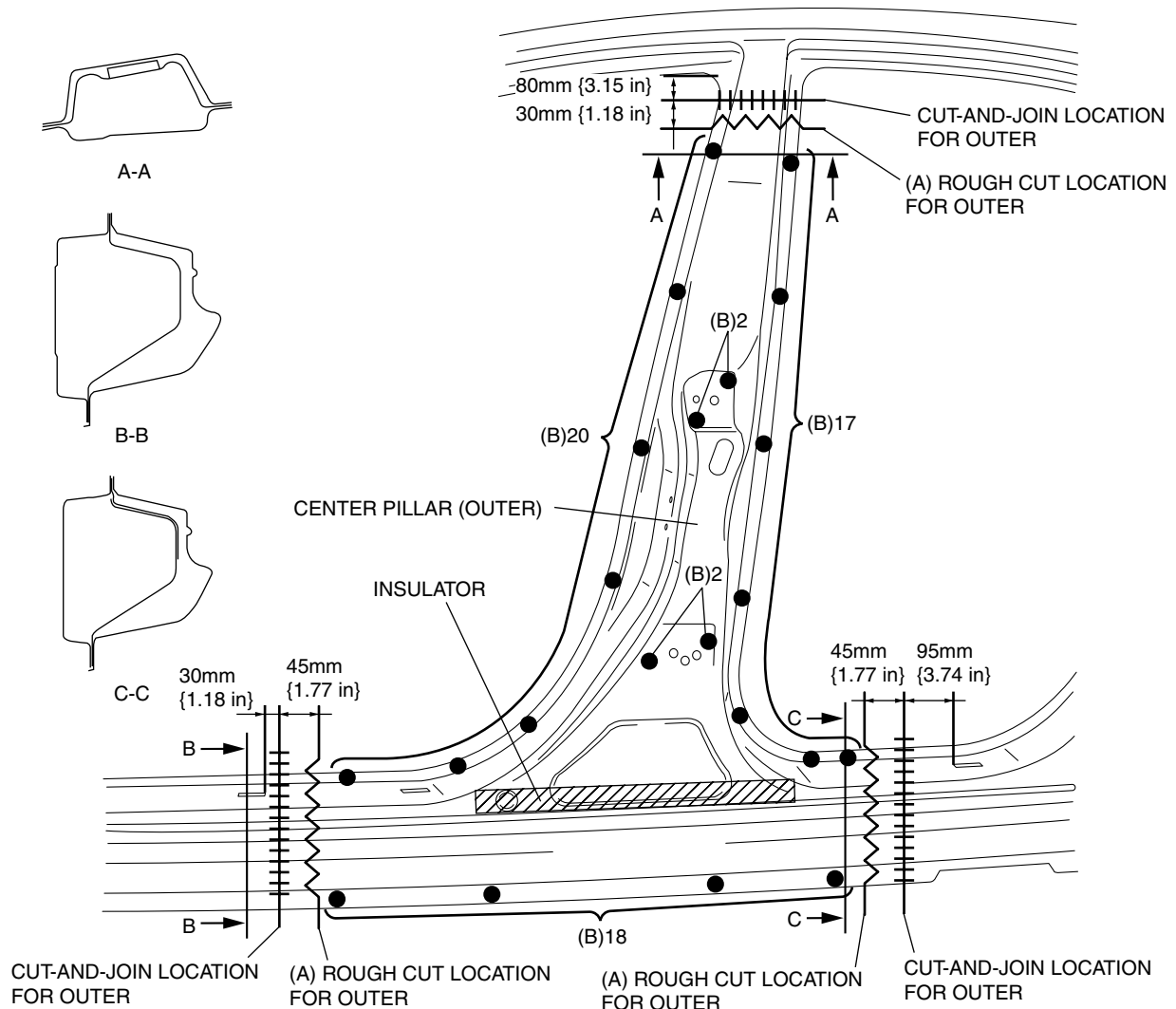
A-A



B-B



C-C

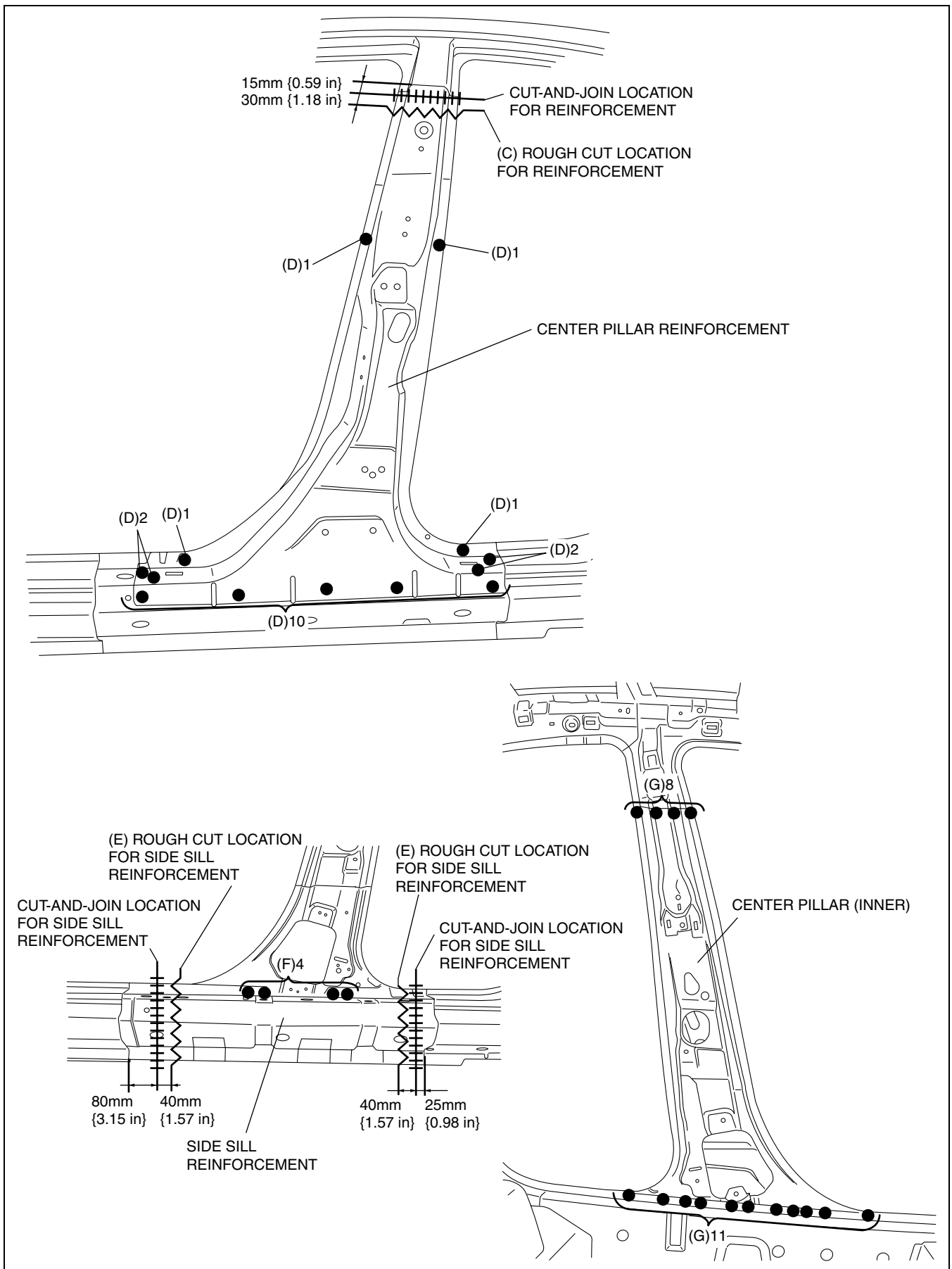


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BODY STRUCTURE [PANEL REPLACEMENT]



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BODY STRUCTURE [PANEL REPLACEMENT]

CENTER PILLAR INSTALLATION

C3U098070350B02

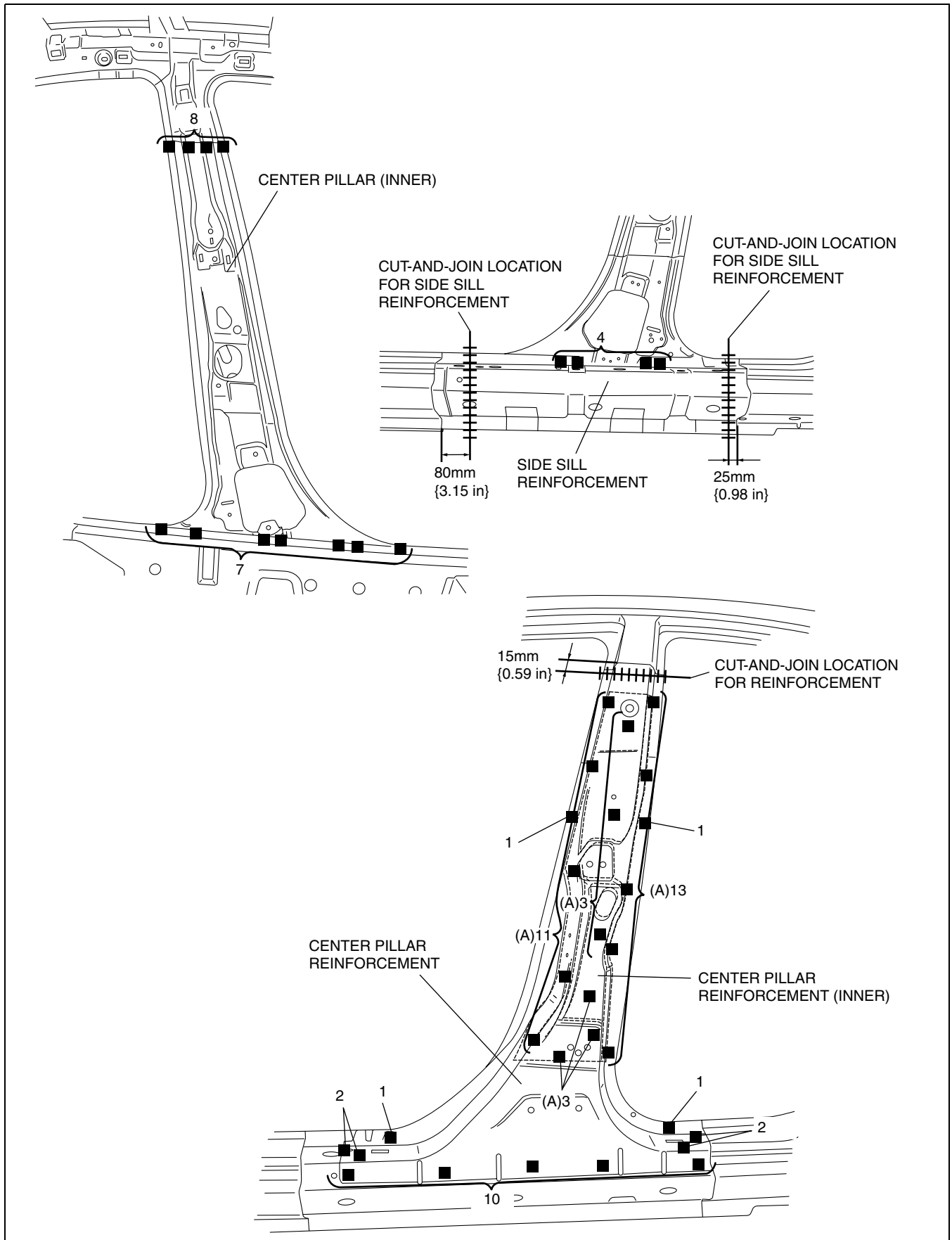
1. When joining and cutting the new and existing parts, trial fit the new part in position, and then measure and adjust the body as necessary to conform with standard dimensions.
2. Drill holes for plug welds before installing new parts.

Note

- In areas where the outer, reinforcement, inner, and other parts are in 3-4 layers, drill holes for plug welds in all but the innermost panel.
3. Install in the following order: inner, reinforcement, and outer.
 4. Weld the 30 locations indicated by (A) and install the center pillar reinforcement (inner) to the center pillar reinforcement.
 5. After temporarily installing new parts, make sure the related parts fit properly.

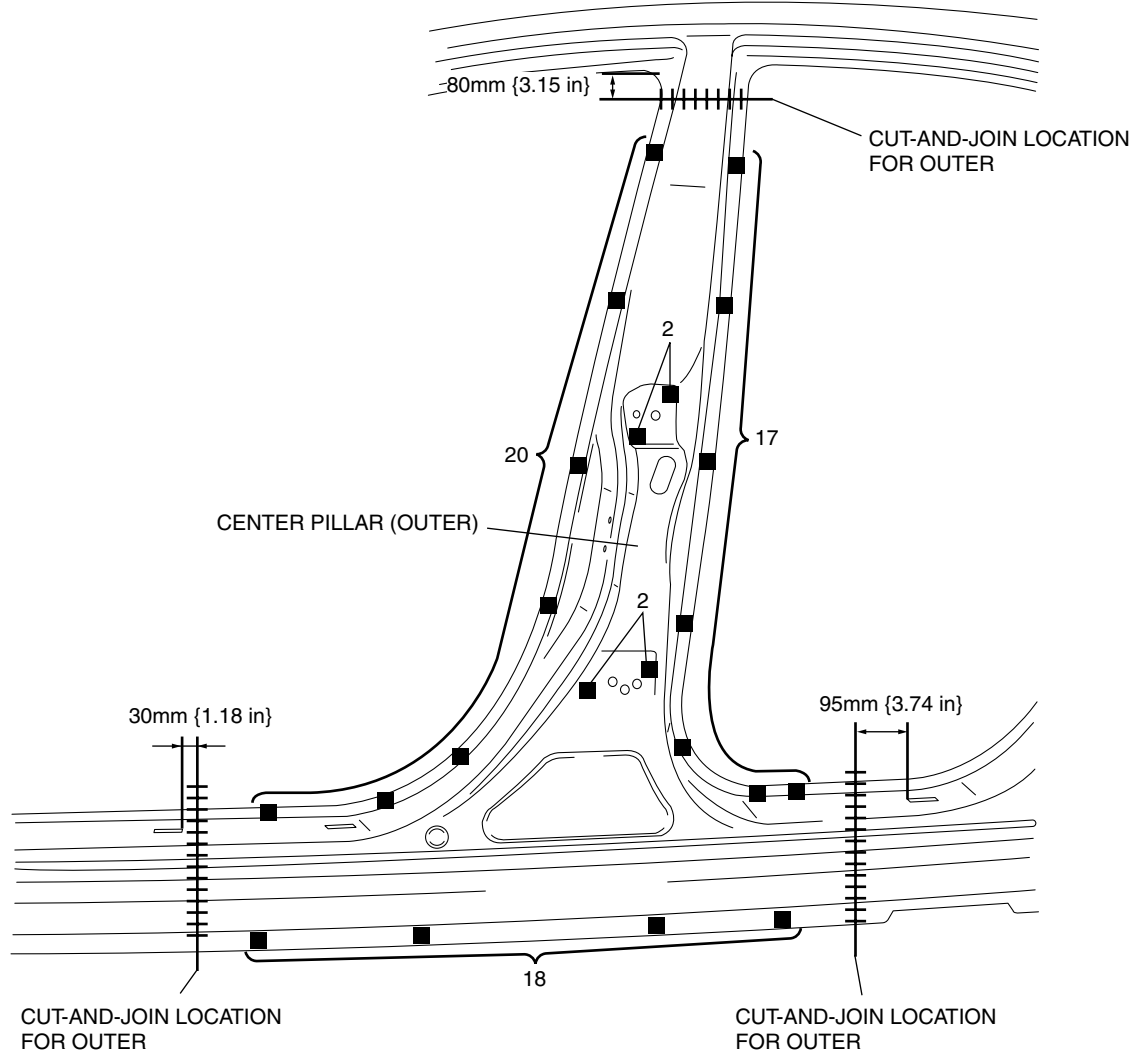
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BODY STRUCTURE [PANEL REPLACEMENT]



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BODY STRUCTURE [PANEL REPLACEMENT]



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BODY STRUCTURE [PANEL REPLACEMENT]

REAR FENDER PANEL REMOVAL

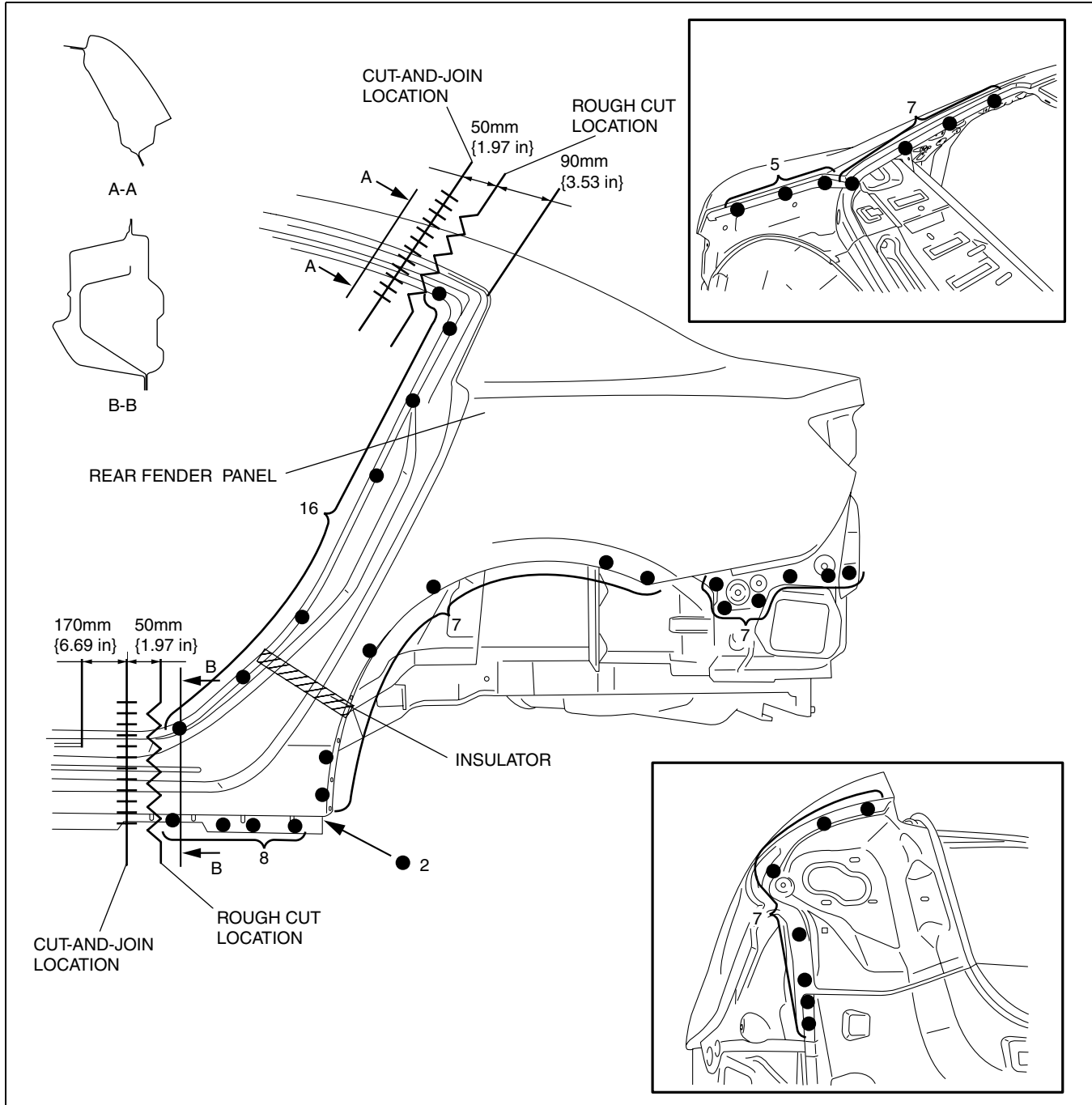
C3U098074100B01

4SD

Caution

- Avoid cutting with a blowtorch or similar tools as the insulator (shaded area) is flammable.

1. The rear fender panel and the rear pillar (inner) are joined with glue at the wheel arch line. Use a chisel or similar tool to separate the rear fender panel from the rear pillar (inner), then remove the rear fender panel.



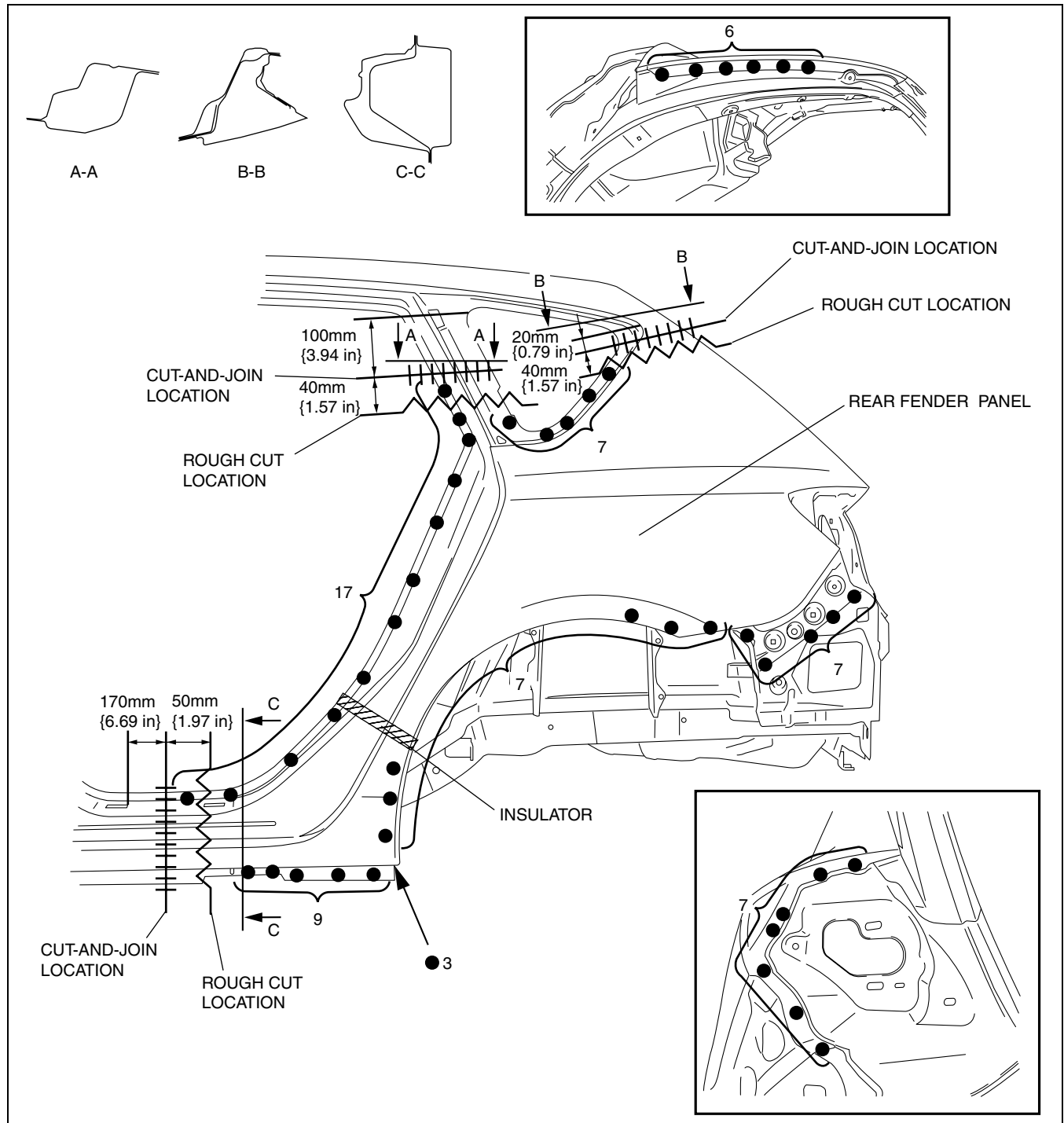
B3E0980B084

5HB

Caution

- Avoid cutting with a blowtorch or similar tools as the insulator (shaded area) is flammable.

1. The rear fender panel and the rear pillar (inner) are joined with glue at the wheel arch line. Use a chisel or similar tool to separate the rear fender panel from the rear pillar (inner), then remove the rear fender panel.



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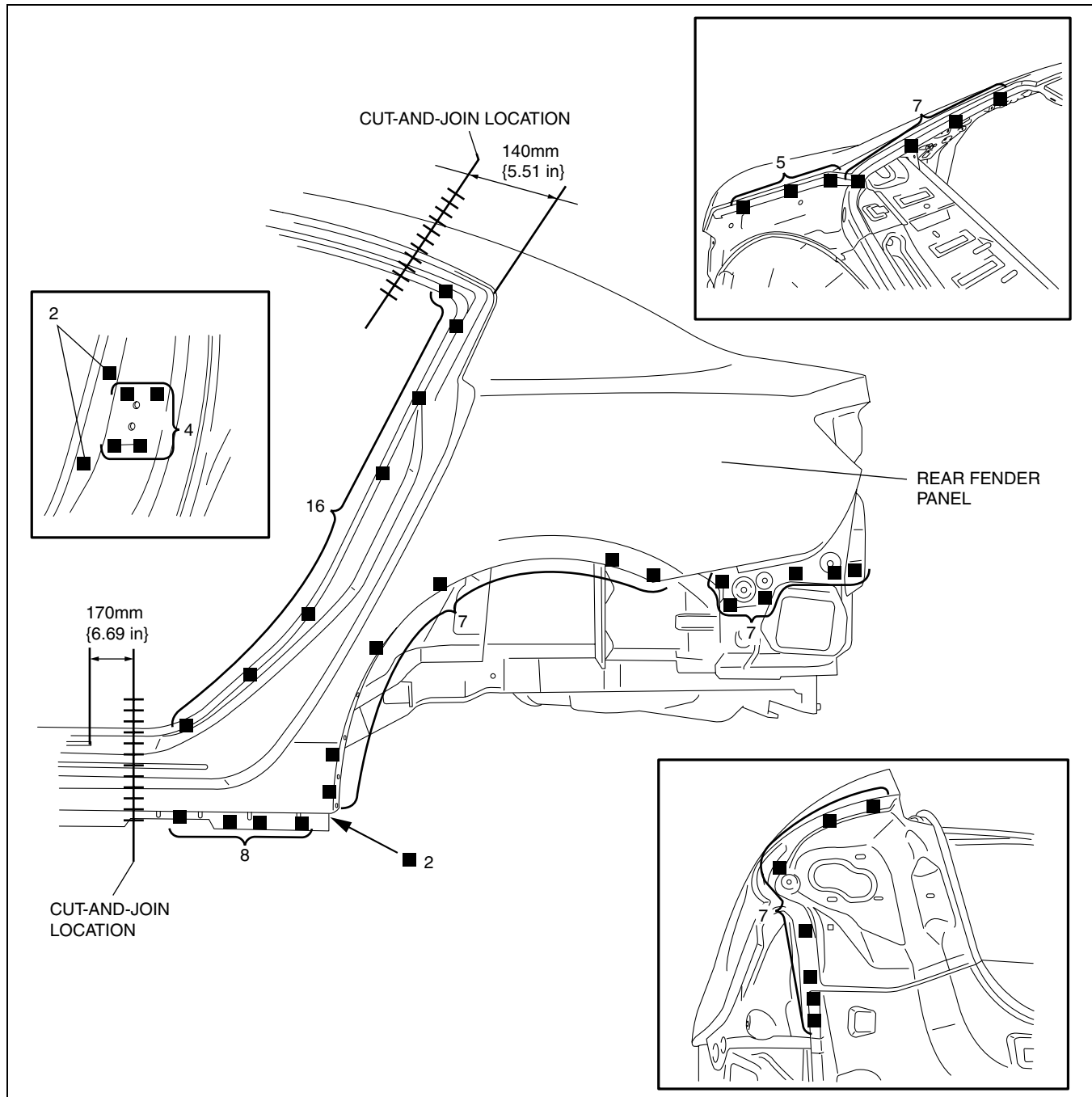
BODY STRUCTURE [PANEL REPLACEMENT]

REAR FENDER PANEL INSTALLATION

C3U098074100B02

4SD

1. When joining and cutting the new and existing parts, trial fit the new part in position, and then measure and adjust the body as necessary to conform with standard dimensions.
2. Drill holes for plug welds before installing new parts.
3. Before installing new parts, apply spot weld sealer to the wheel arch line.
4. After temporarily installing new parts, make sure the related parts fit properly.

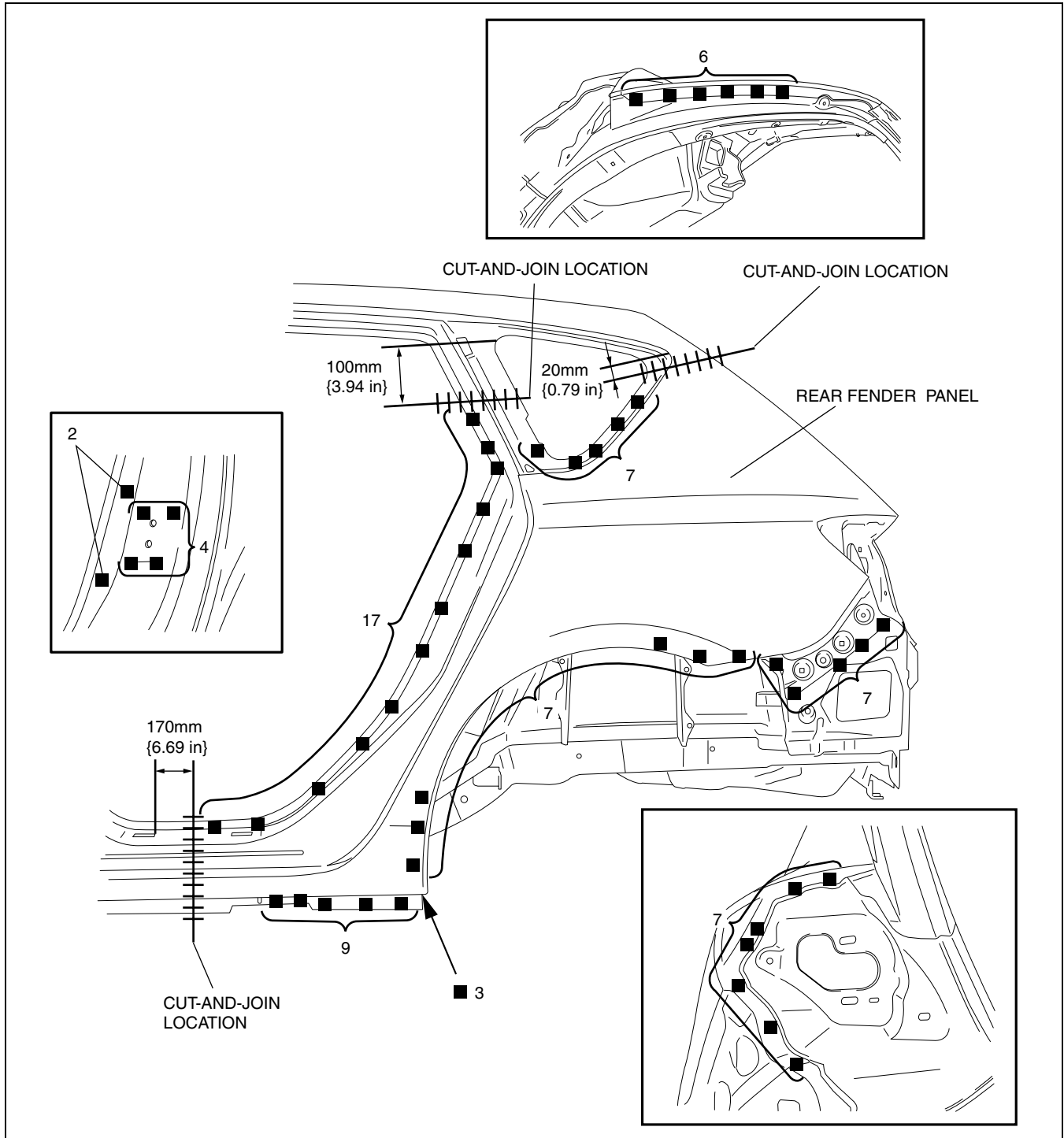


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BODY STRUCTURE [PANEL REPLACEMENT]

5HB

1. When joining and cutting the new and existing parts, trial fit the new part in position, and then measure and adjust the body as necessary to conform with standard dimensions.
2. Drill holes for plug welds before installing new parts.
3. Before installing new parts, apply spot weld sealer to the wheel arch line.
4. After temporarily installing new parts, make sure the related parts fit properly.



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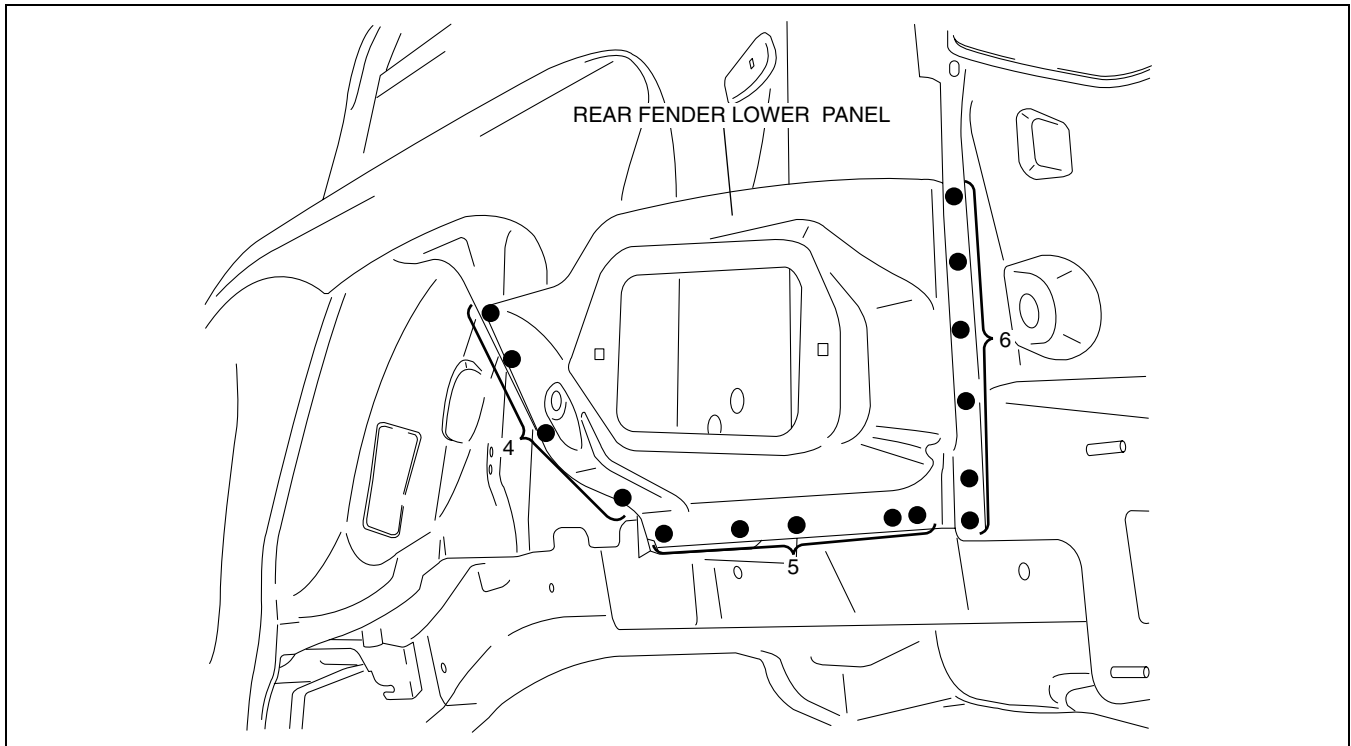
BODY STRUCTURE [PANEL REPLACEMENT]

REAR FENDER LOWER PANEL REMOVAL

C3U098074100B03

4SD

1. Remove the rear fender lower panel.

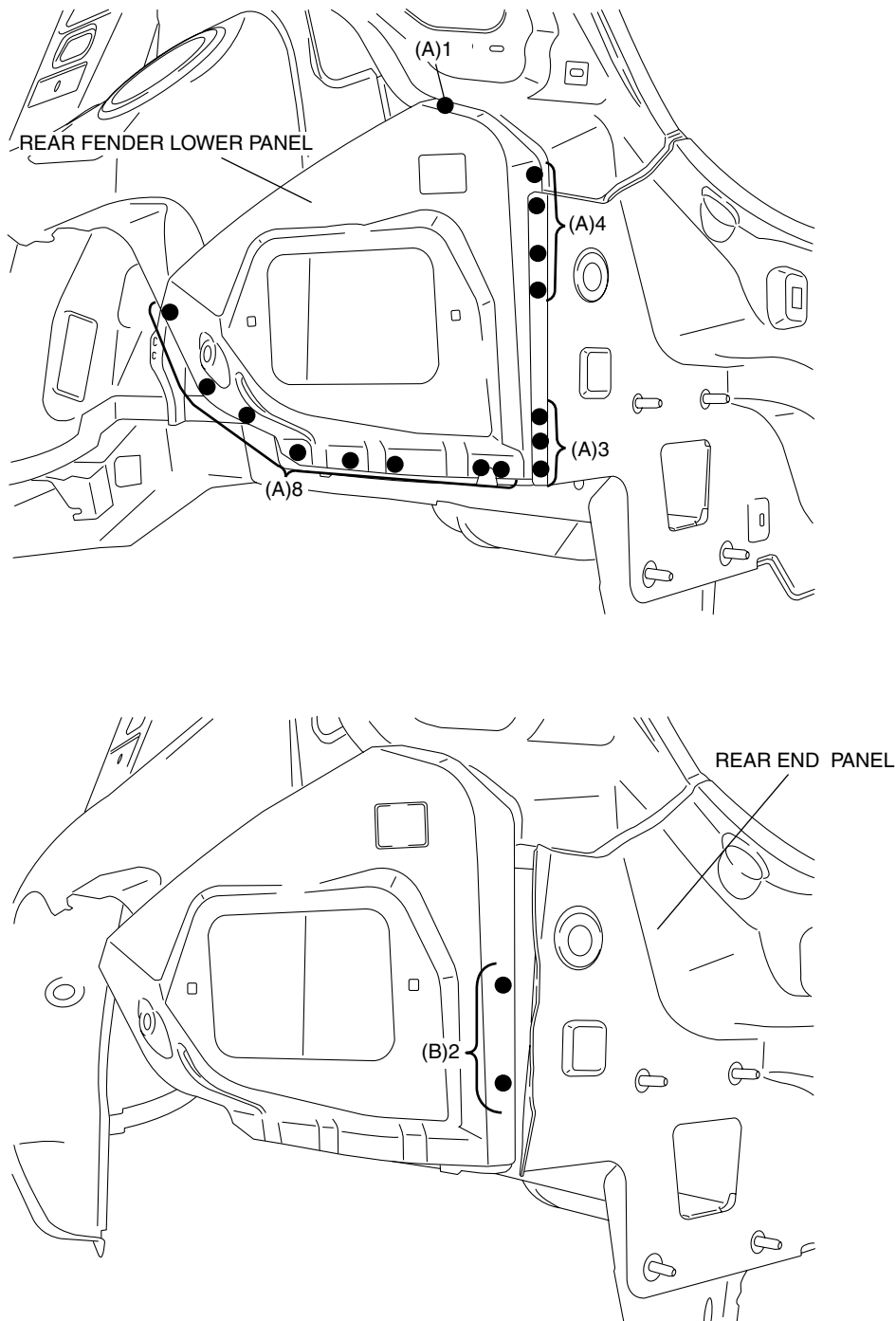


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BODY STRUCTURE [PANEL REPLACEMENT]

5HB

1. Drill the 16 locations indicated by (A).
2. Drill the 2 locations indicated by (B) and remove the rear fender lower panel.



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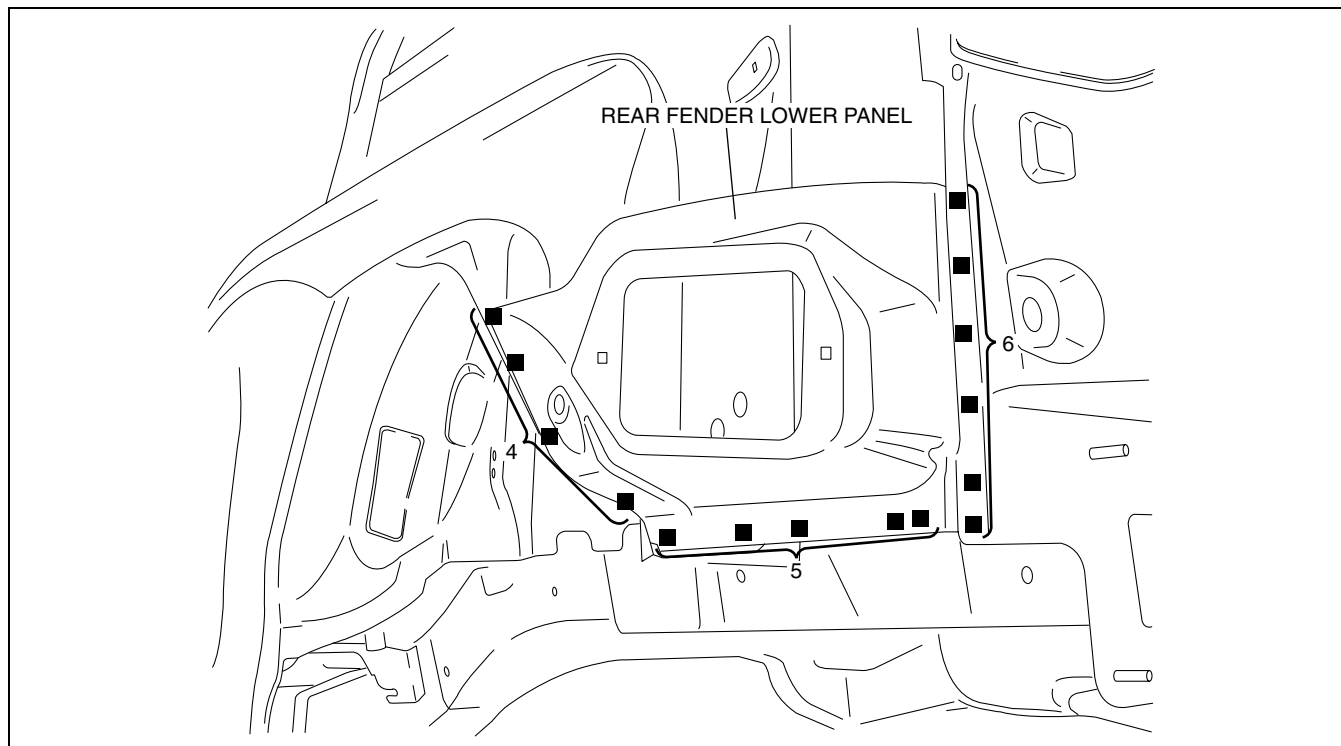
BODY STRUCTURE [PANEL REPLACEMENT]

REAR FENDER LOWER PANEL INSTALLATION

C3U098074100B04

4SD

1. When installing new parts, measure and adjust the body as necessary to conform with standard dimensions.
2. Drill holes for plug welds before installing new parts.
3. After temporarily installing new parts, make sure the related parts fit properly.

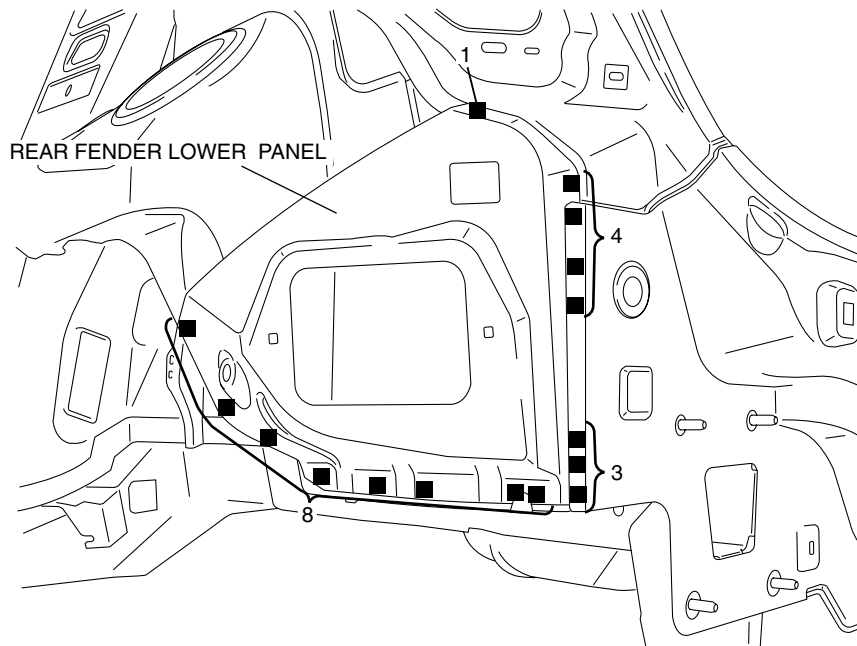
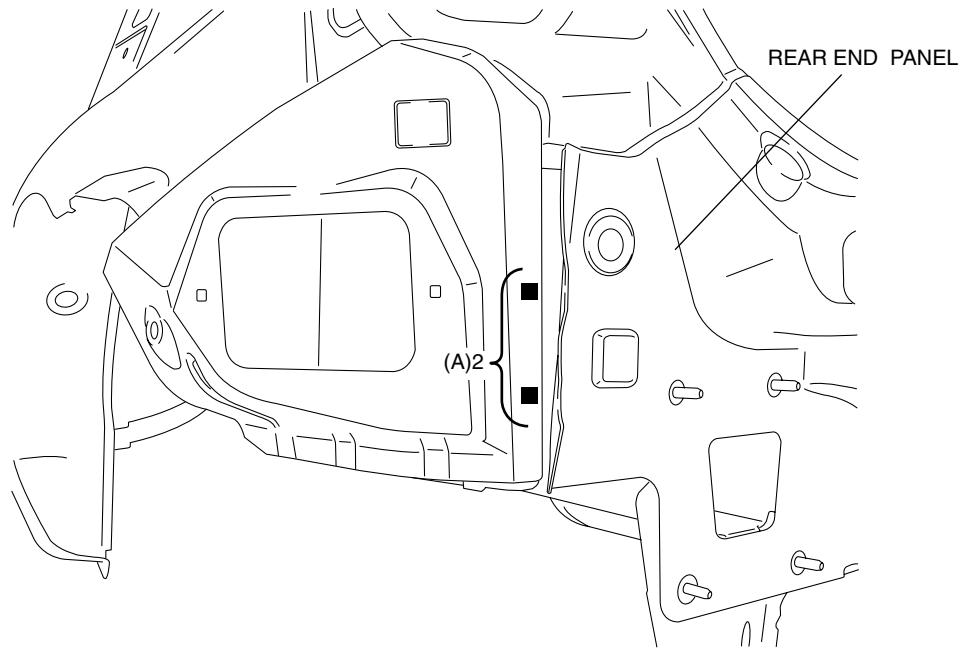


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BODY STRUCTURE [PANEL REPLACEMENT]

5HB

1. When installing new parts, measure and adjust the body as necessary to conform with standard dimensions.
2. Drill holes for plug welds before installing new parts.
3. Weld the 2 locations indicated by (A) and install the rear fender lower panel.
4. After temporarily installing new parts, make sure the related parts fit properly.



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BODY STRUCTURE [PANEL REPLACEMENT]

SIDE SILL PANEL REMOVAL

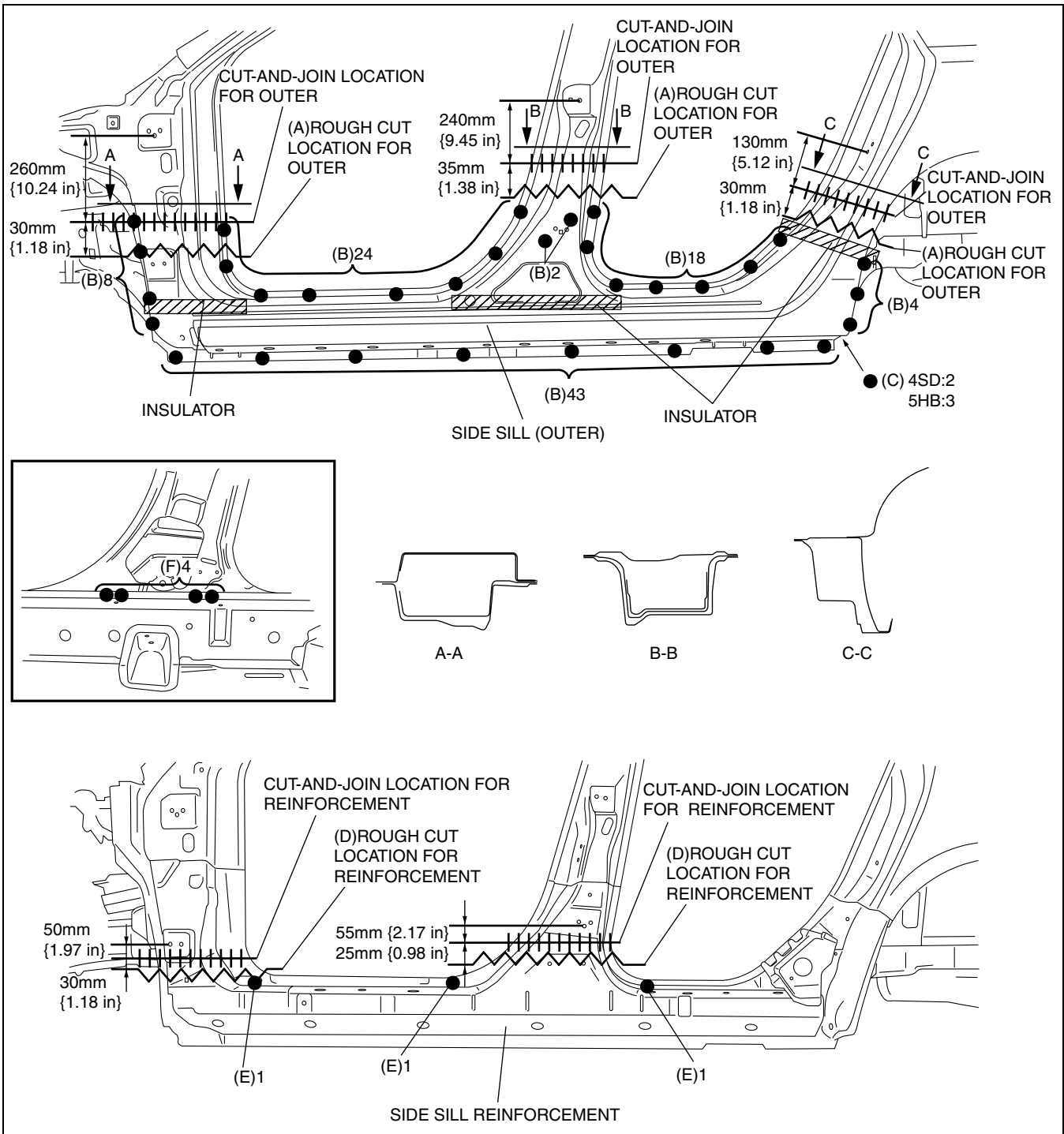
C3U098070270B01

1. Rough cut area (A), drill the 99 locations indicated by (B), the 2 locations (4SD) or 3 locations (5HB) indicated by (C), and then remove the side sill (outer).

Caution

- Avoid cutting with a blowtorch or similar tools as the insulator (shaded area) is flammable.

2. Rough cut area (D) and drill the 3 locations indicated by (E).
3. Drill the 4 locations indicated by (F) from the interior and remove the side sill reinforcement.



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BODY STRUCTURE [PANEL REPLACEMENT]

SIDE SILL PANEL INSTALLATION

C3U098070270B02

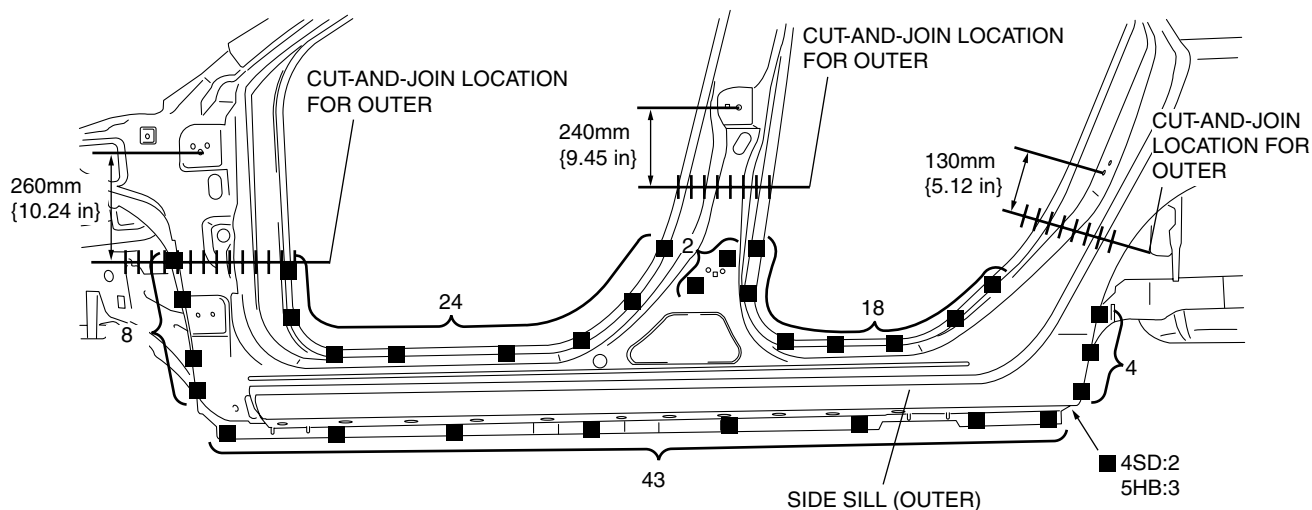
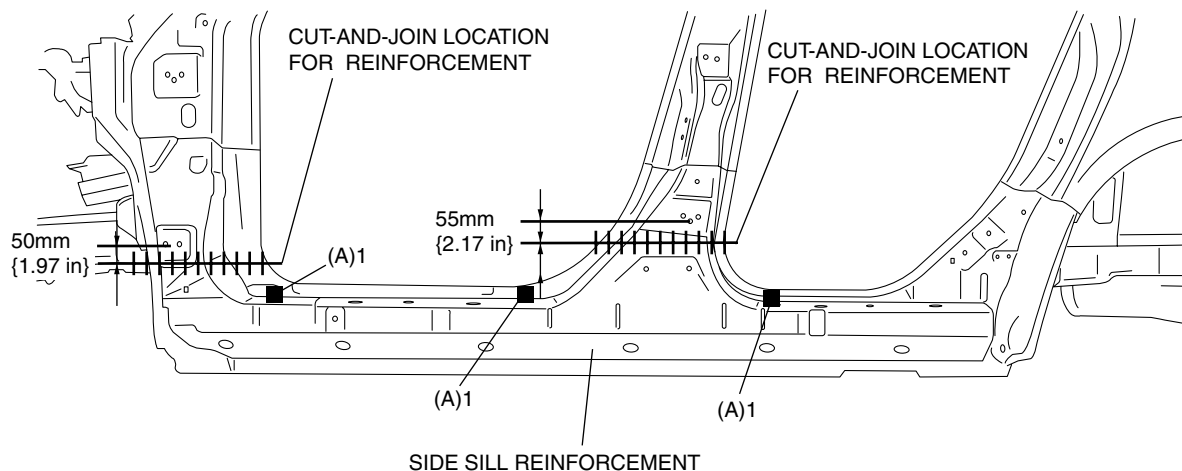
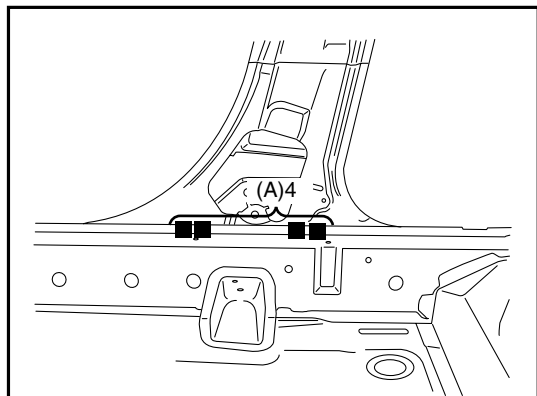
1. When joining and cutting the new and existing parts, trial fit the new part in position, and then measure and adjust the body as necessary to conform with standard dimensions.
2. Drill holes for plug welds before installing new parts.

Note

- In areas where the outer, reinforcement, inner, and other parts are in 3-4 layers, drill holes for plug welds in all but the innermost panel.

3. Weld the 7 locations indicated by (A) and temporarily install the side sill reinforcement.
4. After temporarily installing new parts, make sure the related parts fit properly.

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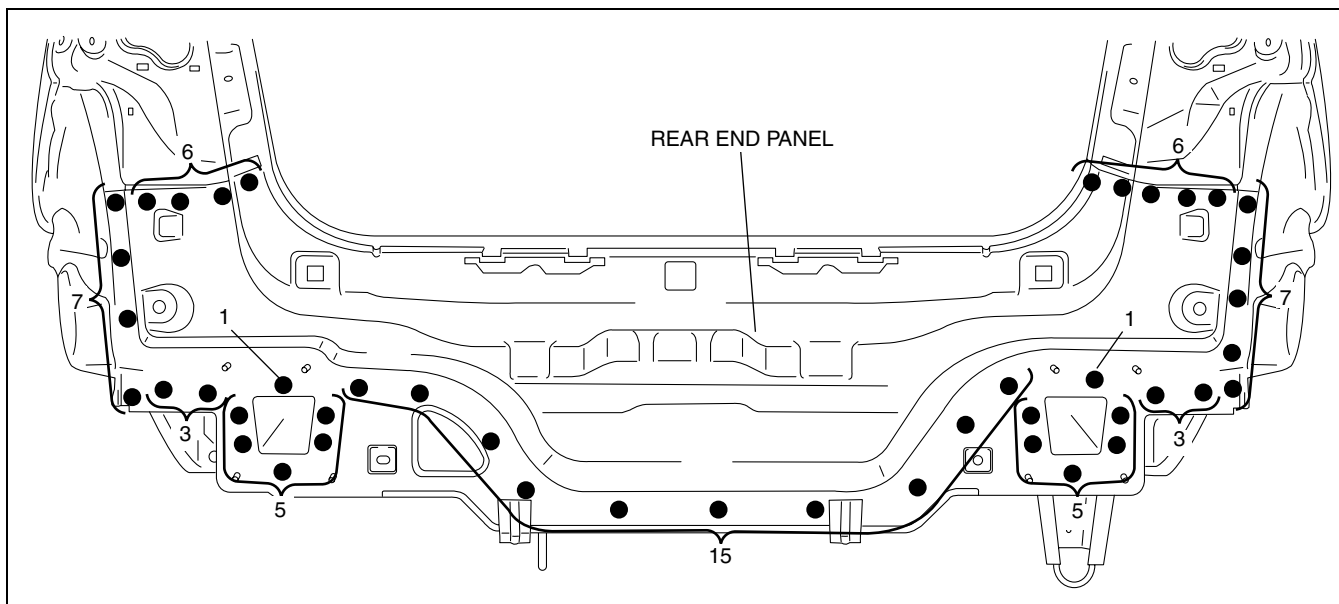
BODY STRUCTURE [PANEL REPLACEMENT]

REAR END PANEL REMOVAL

C3U098070750B01

4SD

1. Remove the rear end panel.

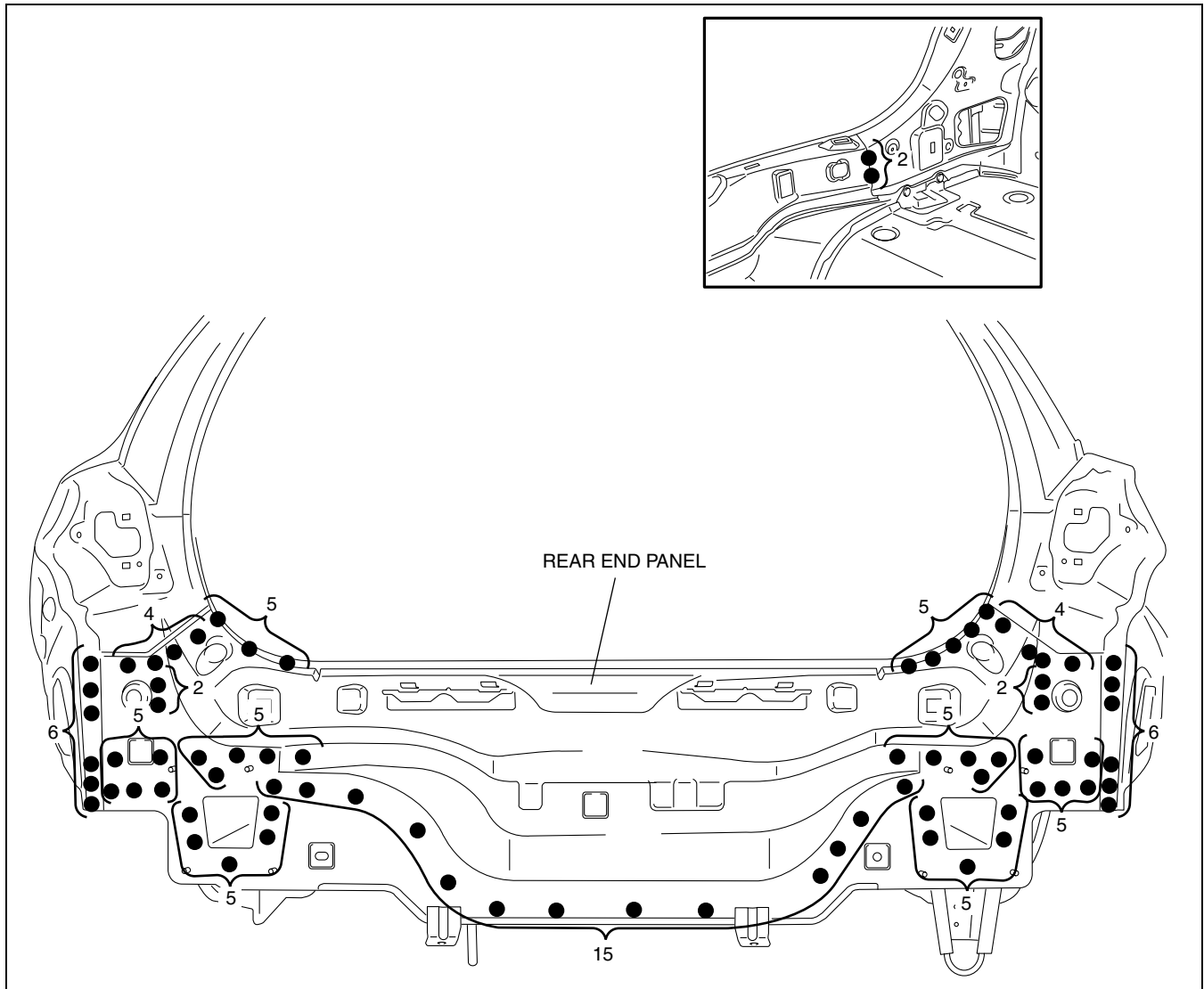


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BODY STRUCTURE [PANEL REPLACEMENT]

5HB

1. Remove the rear end panel.



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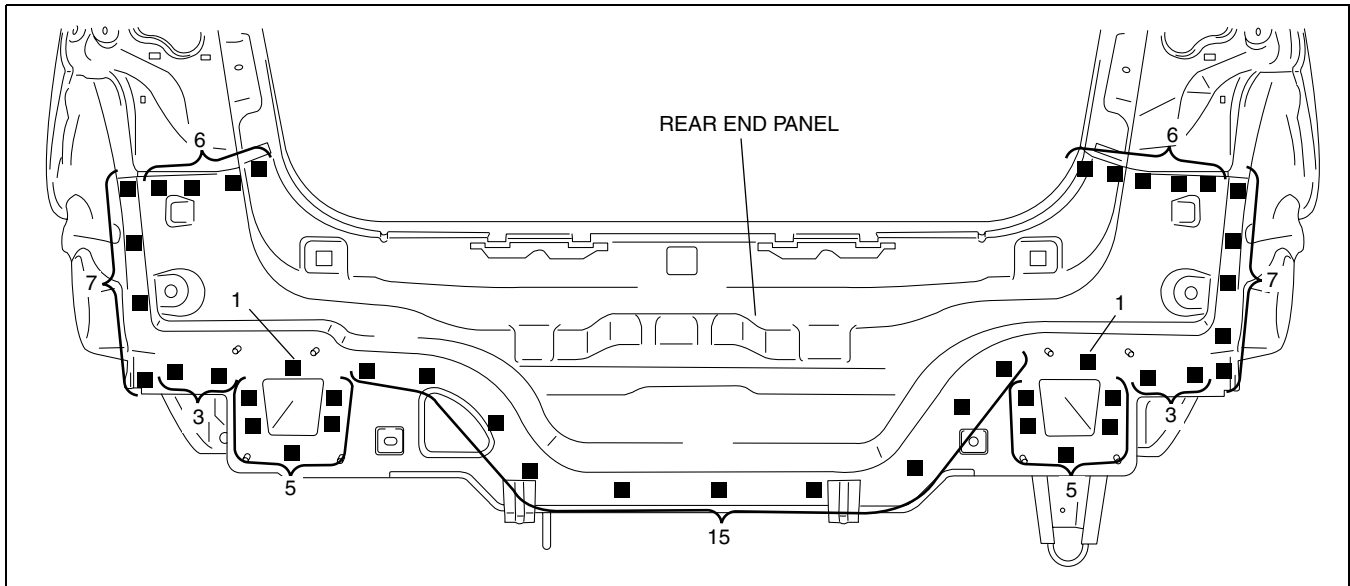
BODY STRUCTURE [PANEL REPLACEMENT]

REAR END PANEL INSTALLATION

C3U098070750B02

4SD

1. When installing new parts, measure and adjust the body as necessary to conform with standard dimensions.
2. Drill holes for plug welds before installing new parts.
3. After temporarily installing new parts, make sure the related parts fit properly.

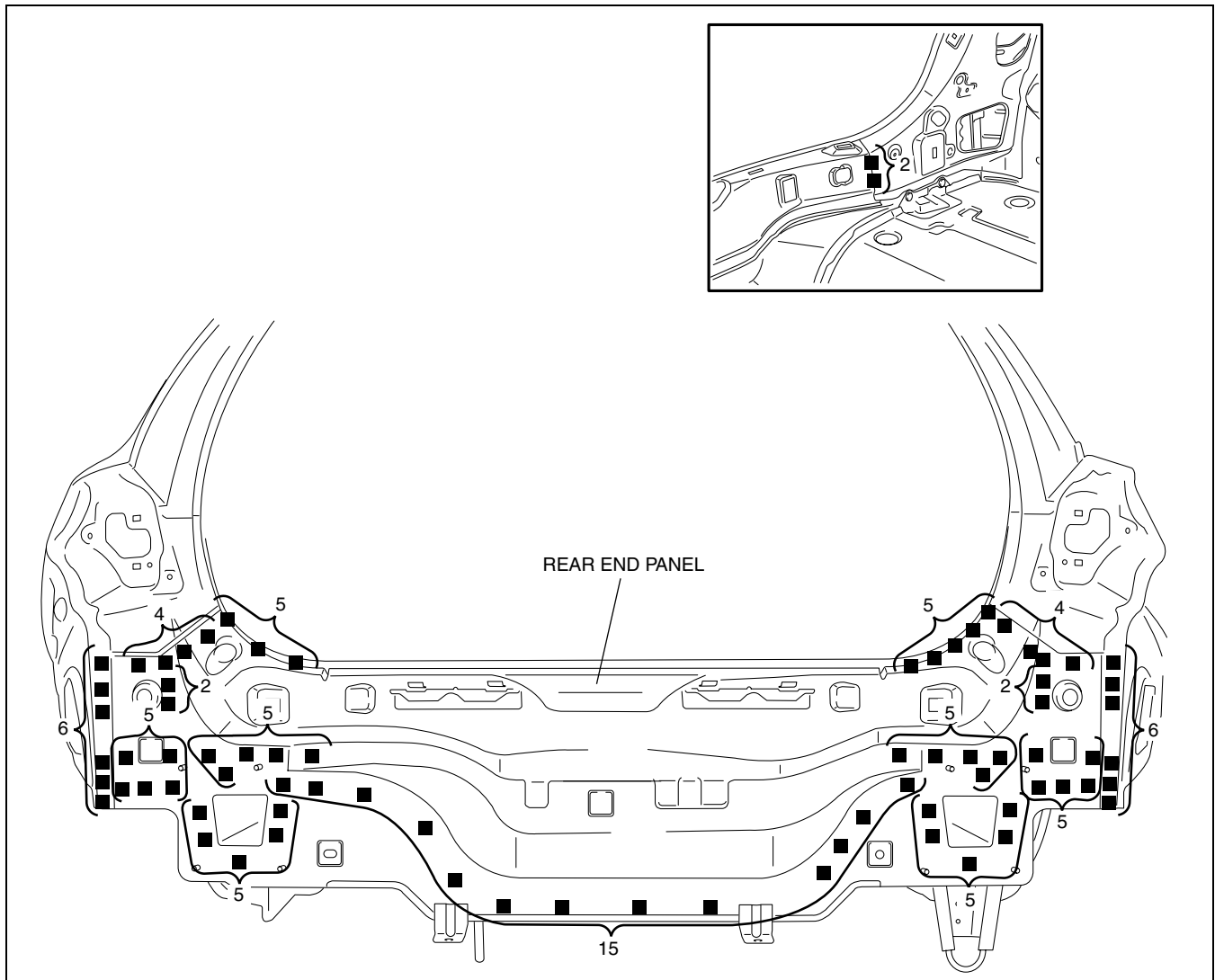


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BODY STRUCTURE [PANEL REPLACEMENT]

5HB

1. When installing new parts, measure and adjust the body as necessary to conform with standard dimensions.
2. Drill holes for plug welds before installing new parts.
3. After temporarily installing new parts, make sure the related parts fit properly.



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BODY STRUCTURE [PANEL REPLACEMENT]

REAR FENDER RAIN RAIL AND CORNER PLATE REMOVAL

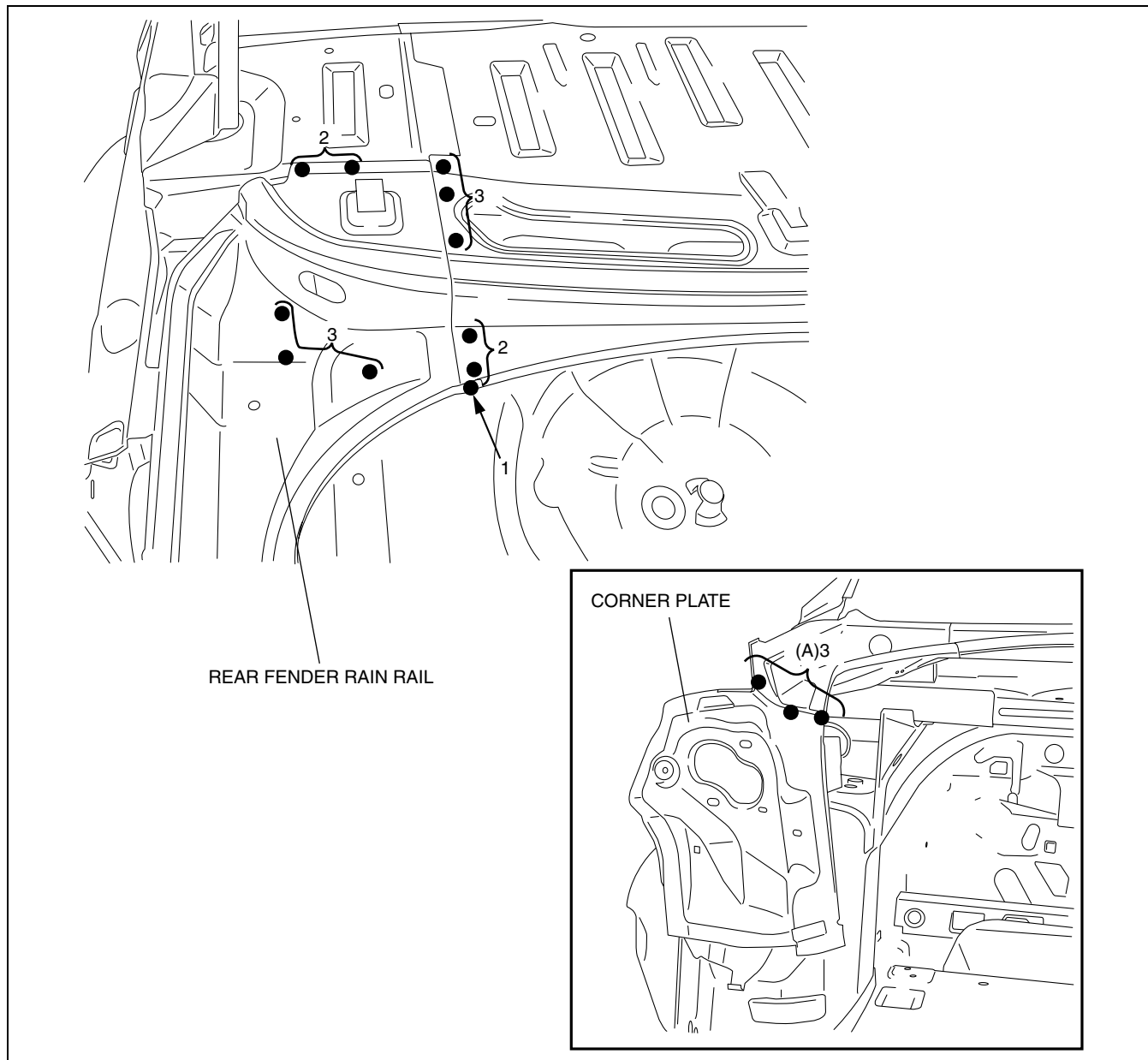
C3U098070440B01

4SD

1. Remove the rear fender rain rail and corner plate.

Note

- When removing the rear fender rain rail and the corner plate separately, drill the 3 locations indicated by (A).



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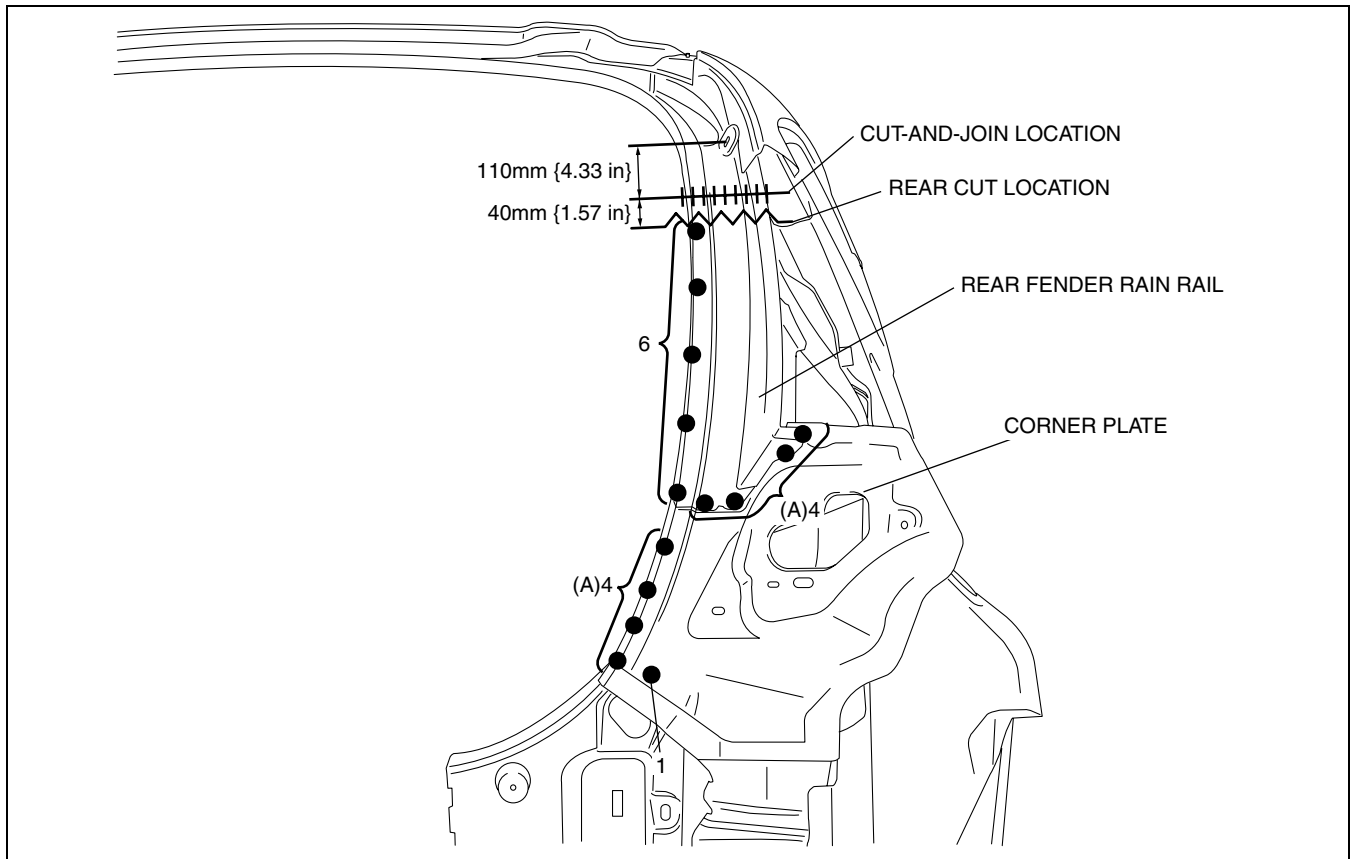
BODY STRUCTURE [PANEL REPLACEMENT]

5HB

1. Remove the rear fender rain rail and corner plate.

Note

- When removing the rear fender rain rail and the corner plate separately, drill the 8 locations indicated by (A).



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BODY STRUCTURE [PANEL REPLACEMENT]

REAR FENDER RAIN RAIL AND CORNER PLATE INSTALLATION

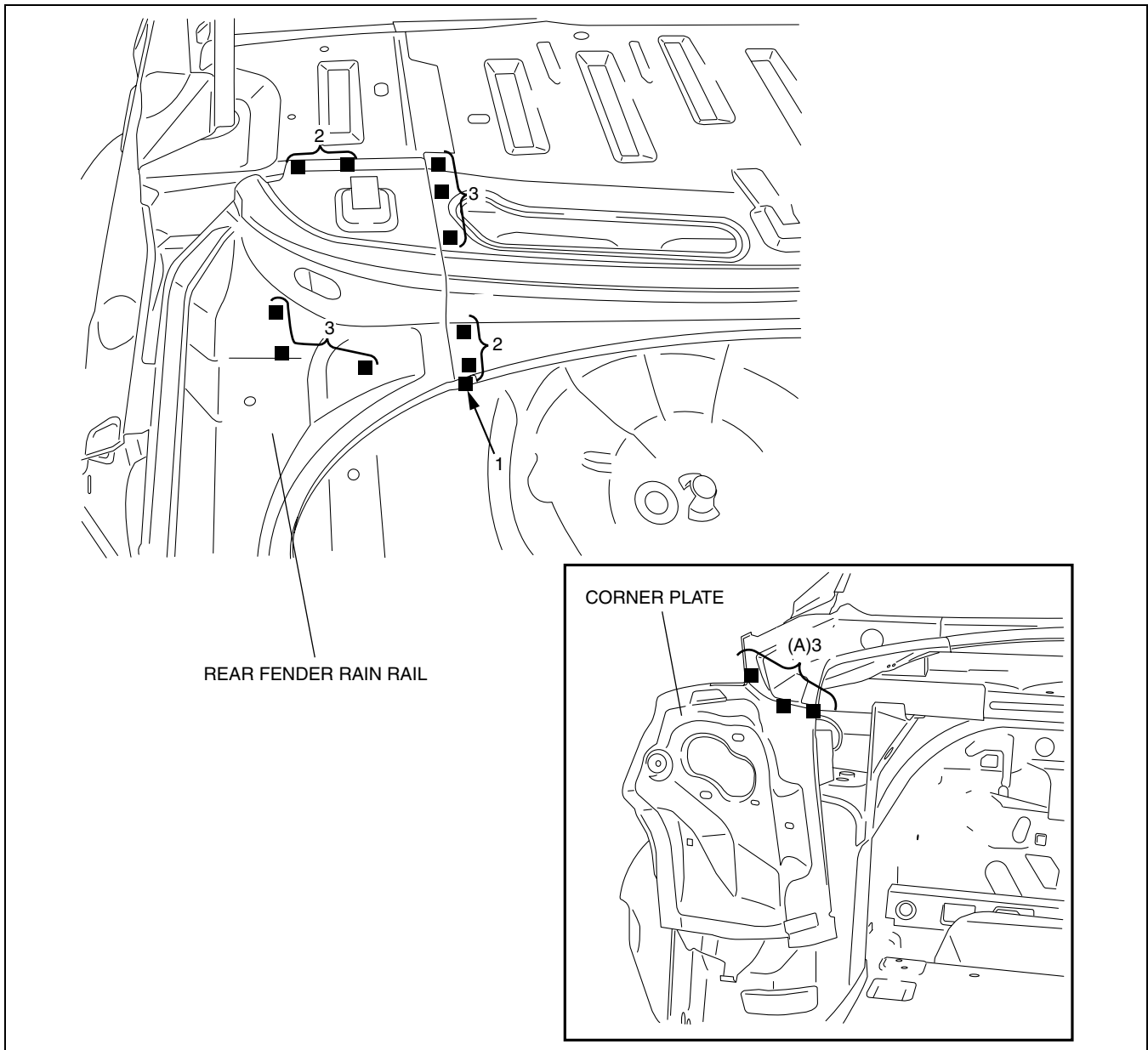
C3U098070440B02

4SD

1. When installing new parts, measure and adjust the body as necessary to conform with standard dimensions.
2. Drill holes for plug welds before installing new parts.
3. After temporarily installing new parts, make sure the related parts fit properly.

Note

- When replacing the rear fender rain rail and corner plate separately, weld the 3 locations indicated by (A).



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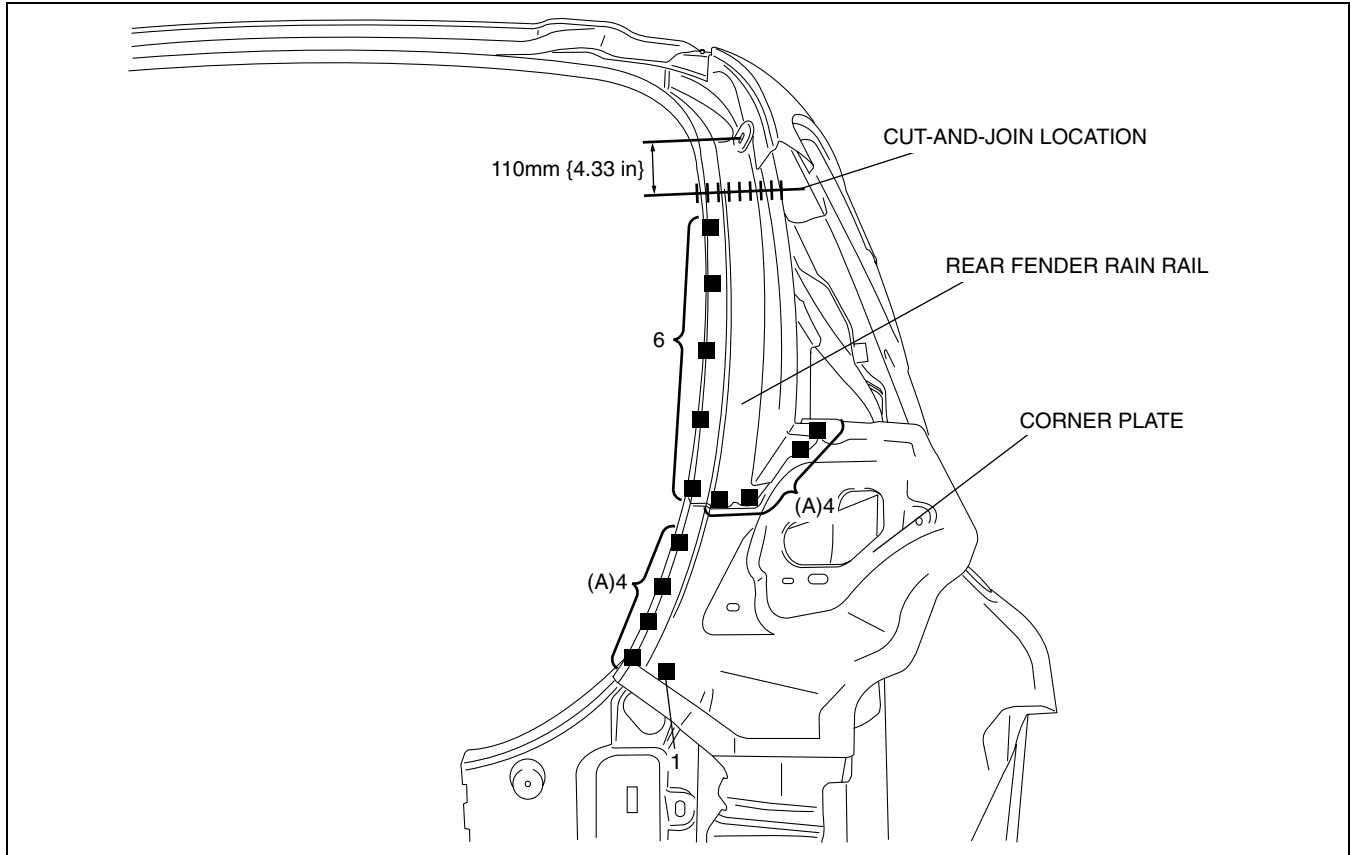
BODY STRUCTURE [PANEL REPLACEMENT]

5HB

1. When installing new parts, measure and adjust the body as necessary to conform with standard dimensions.
2. Drill holes for plug welds before installing new parts.
3. After temporarily installing new parts, make sure the related parts fit properly.

Note

- When replacing the rear fender rain rail and corner plate separately, weld the 8 locations indicated by (A).



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BODY STRUCTURE [PANEL REPLACEMENT]

REAR FLOOR PAN REMOVAL

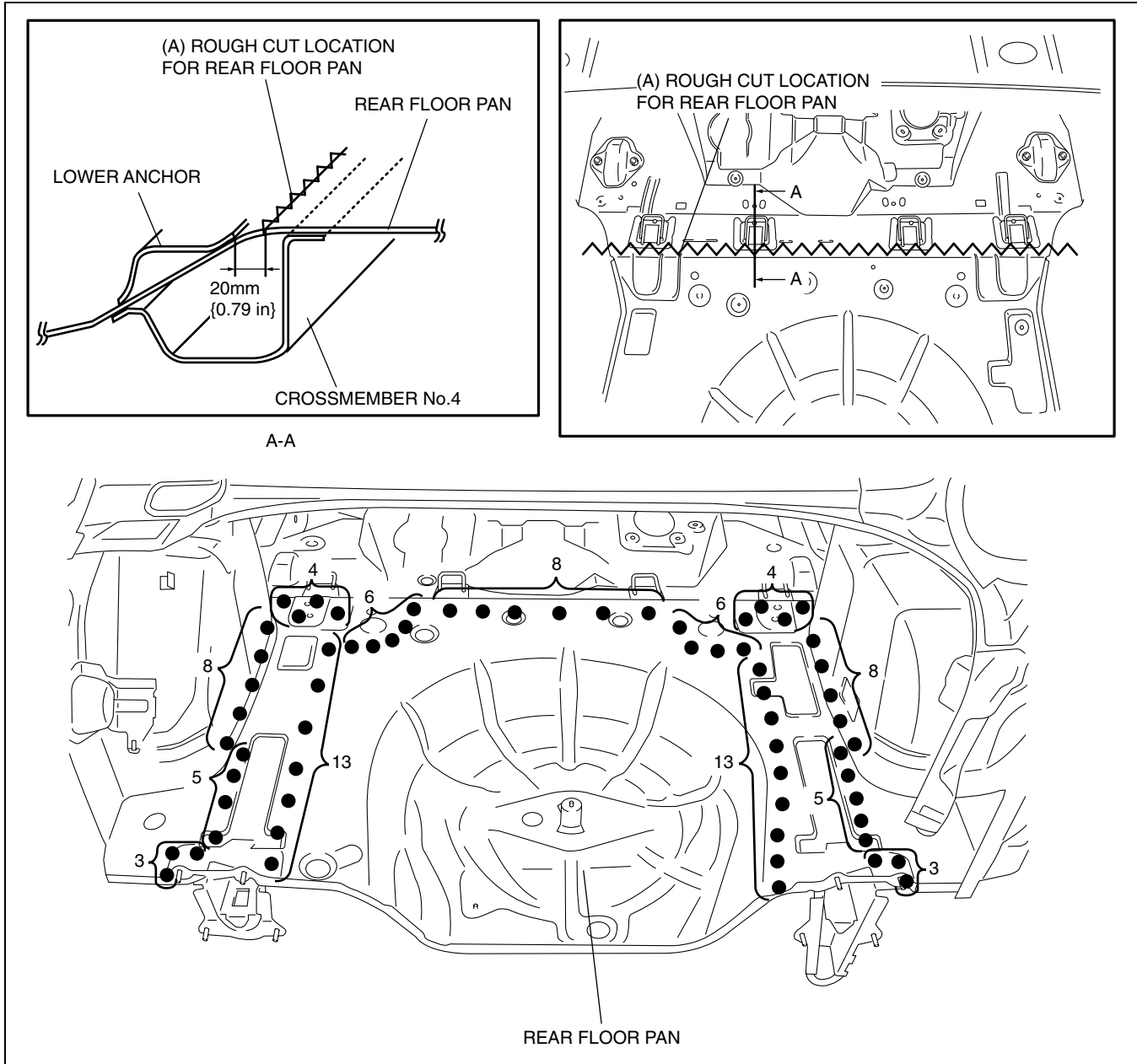
C3U098053750B01

1. Rough cut area (A).

Caution

- When rough cutting area (A), cut 20mm {0.79 in} away from the flange (towards rear) at the rear of the lower anchor.

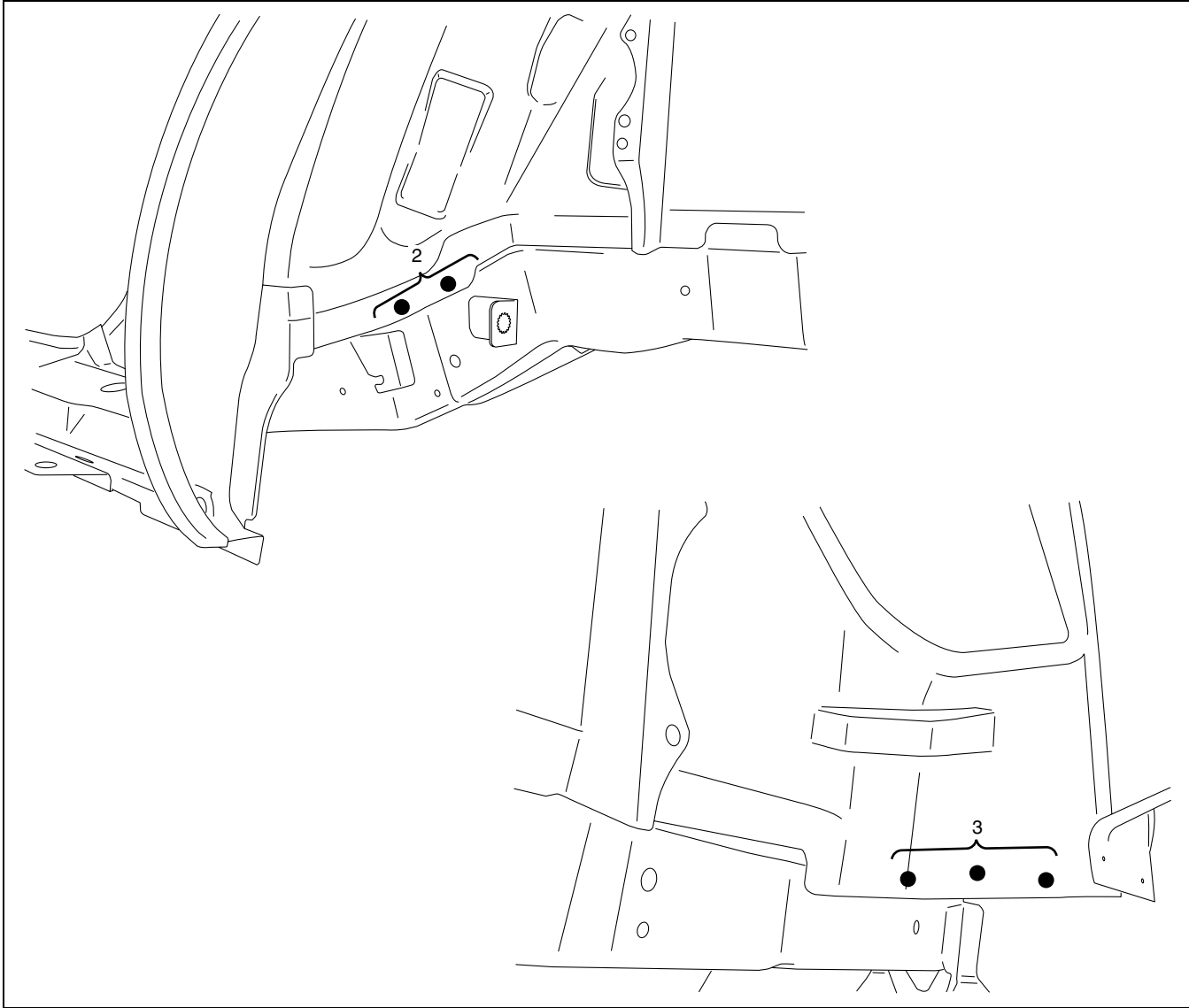
2. Remove the rear floor pan.



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BODY STRUCTURE [PANEL REPLACEMENT]

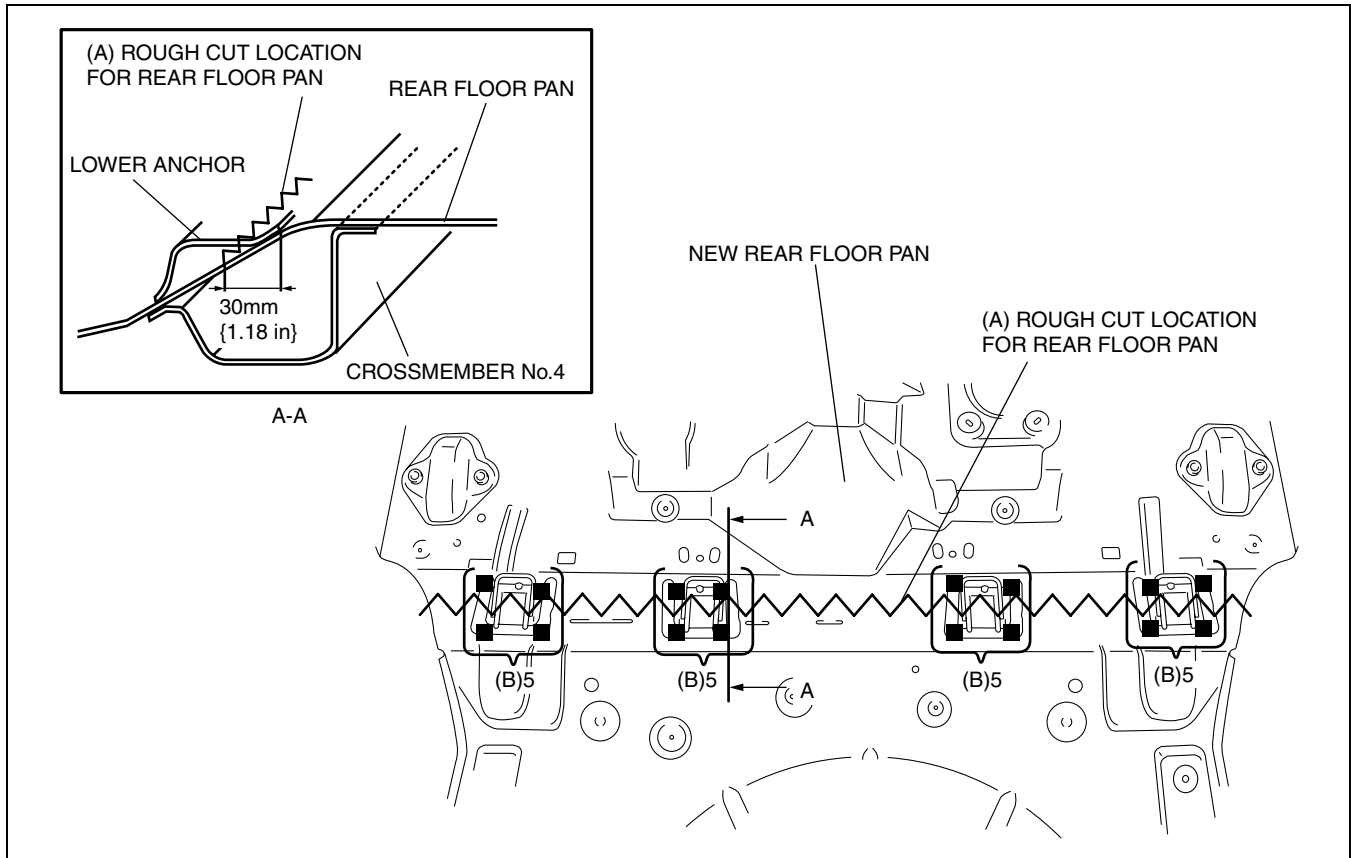
REAR FLOOR PAN INSTALLATION

C3U098053750B02

1. To prepare for installation, cut area (A) on the new rear floor pan, drill the 20 locations indicated by (B) and then remove the lower anchor.

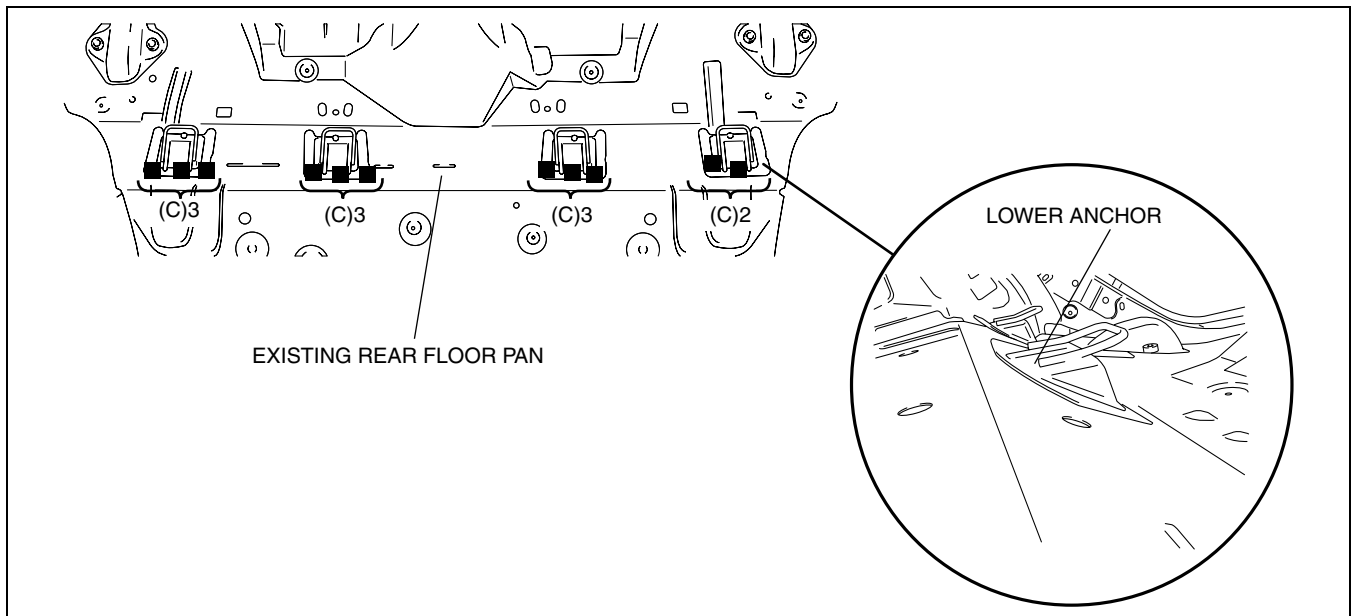
Caution

- When rough cutting area (A), cut 30 mm {1.18 in} away from the flange (towards front) at the rear of the lower anchor.



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2. Drill the 11 locations indicated by (A).
3. Separate the lower anchor where joined using a chisel or similar tool and bend upwards to facilitate installation.



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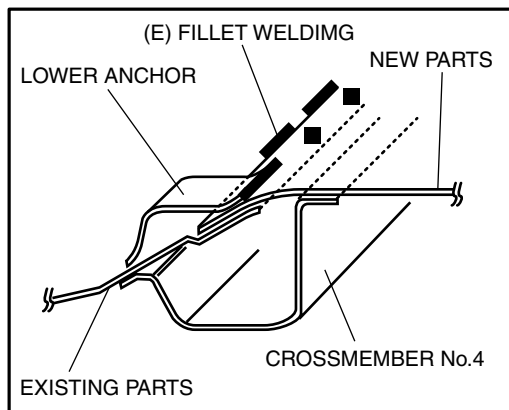
BODY STRUCTURE [PANEL REPLACEMENT]

4. Apply spot sealer to the areas where both the overlapping ends of the new and existing parts will be welded. Adhere the sections to be welded, and plug weld in 18 locations indicated by (D). Fillet weld along the seams of the lower anchor, and new and existing parts at the locations indicated by (E).

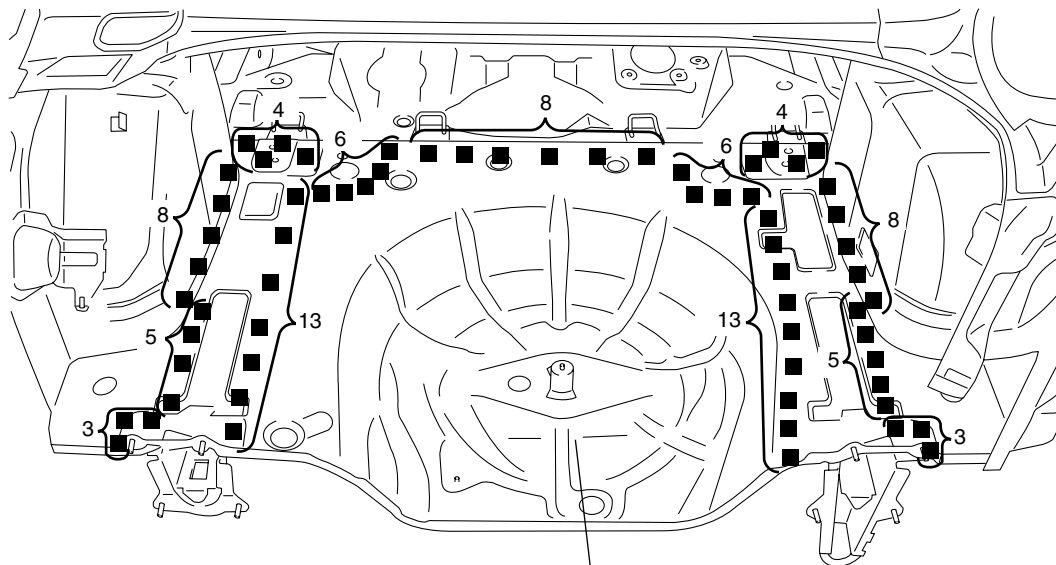
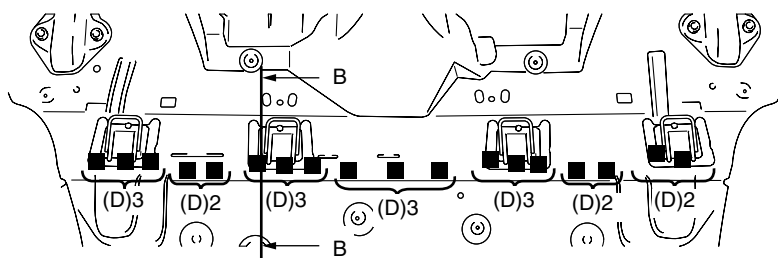
Note

- Create a flange with flanging seal where new and existing parts are joined.

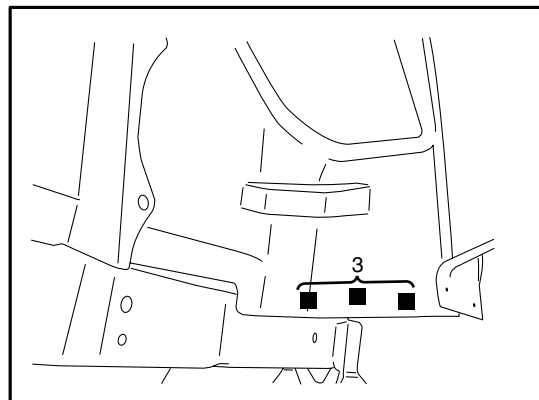
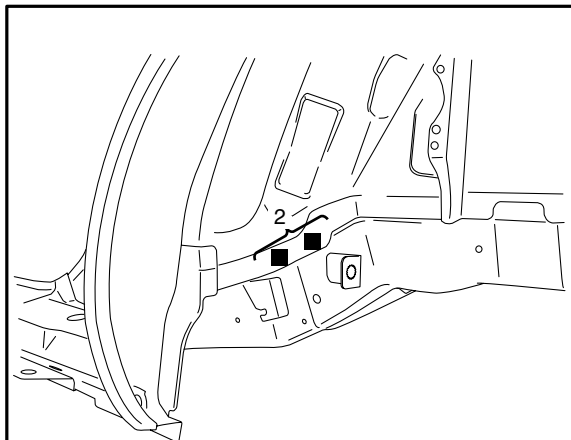
5. Weld the remaining weld locations and install the rear floor pan.



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REAR FLOOR PAN



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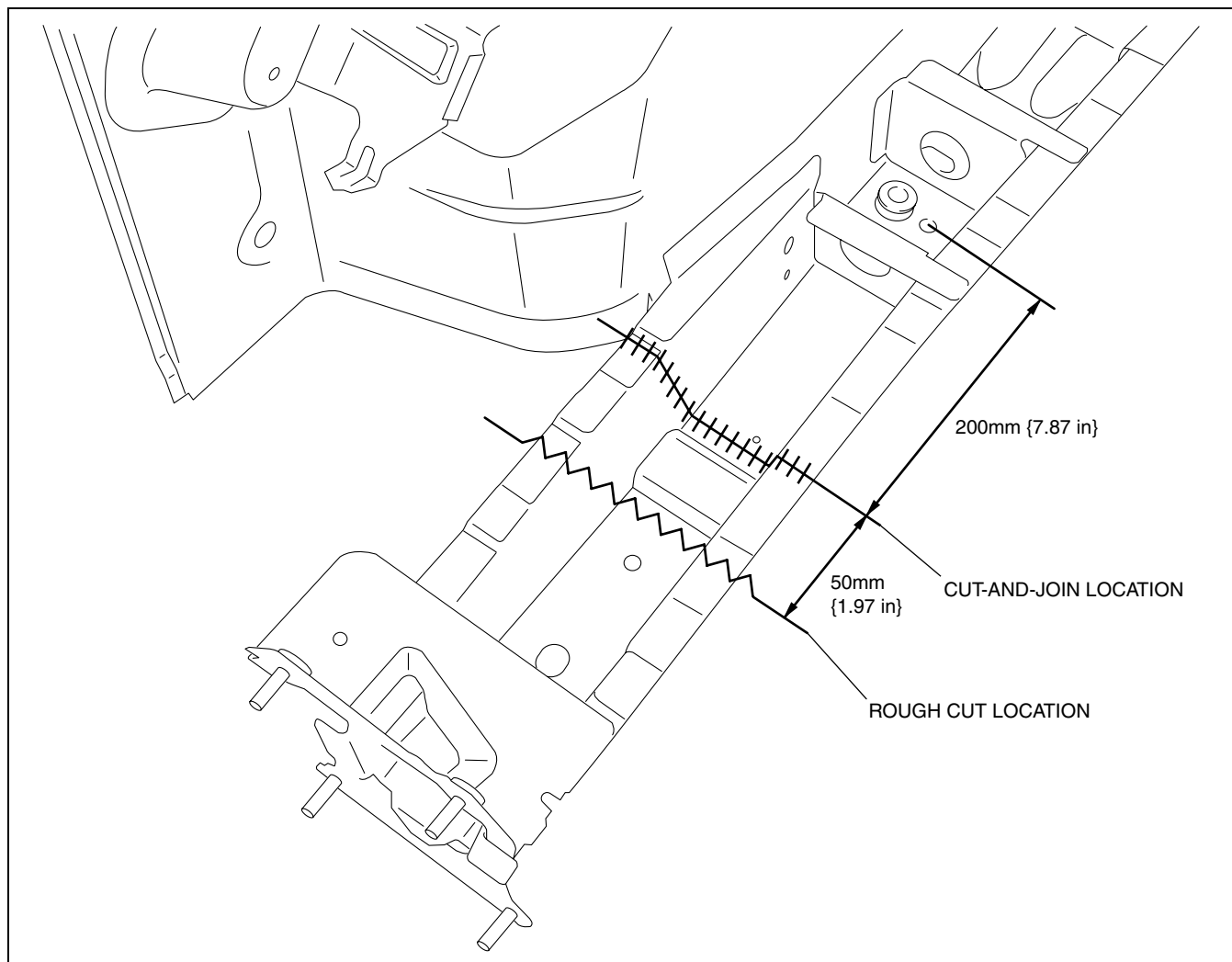
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BODY STRUCTURE [PANEL REPLACEMENT]

REAR SIDE FRAME (PARTIAL CUTTING) REMOVAL

C3U098053810B01

1. Rough cut and remove the damaged part of the rear side frame.



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BODY STRUCTURE [PANEL REPLACEMENT]

REAR SIDE FRAME (PARTIAL CUTTING) INSTALLATION

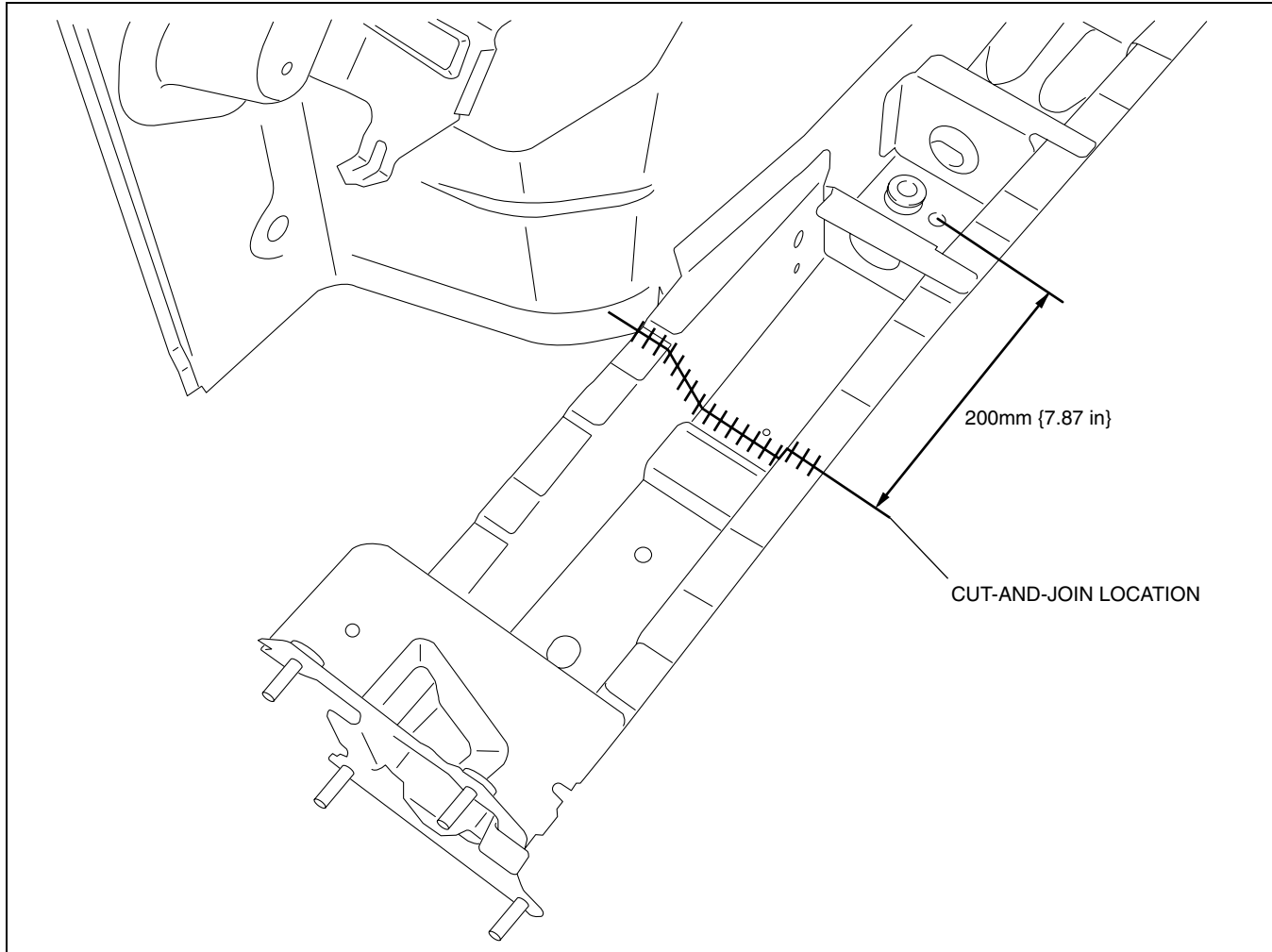
C3U098053810B02

1. Cut the new and existing parts at the cut-and-join location, and bevel the parts.
2. To cut-and-join the new part, cut at the locations indicated in the figure below and bevel the cut-and-join locations of the new parts.
3. When installing the new parts, trial-fit new and existing parts, and then measure and adjust the body to conform with standard dimensions.
4. After temporarily installing new parts, make sure the related parts fit properly.

Caution

- The cut-and-join area indicates the maximum size range of the installation position.

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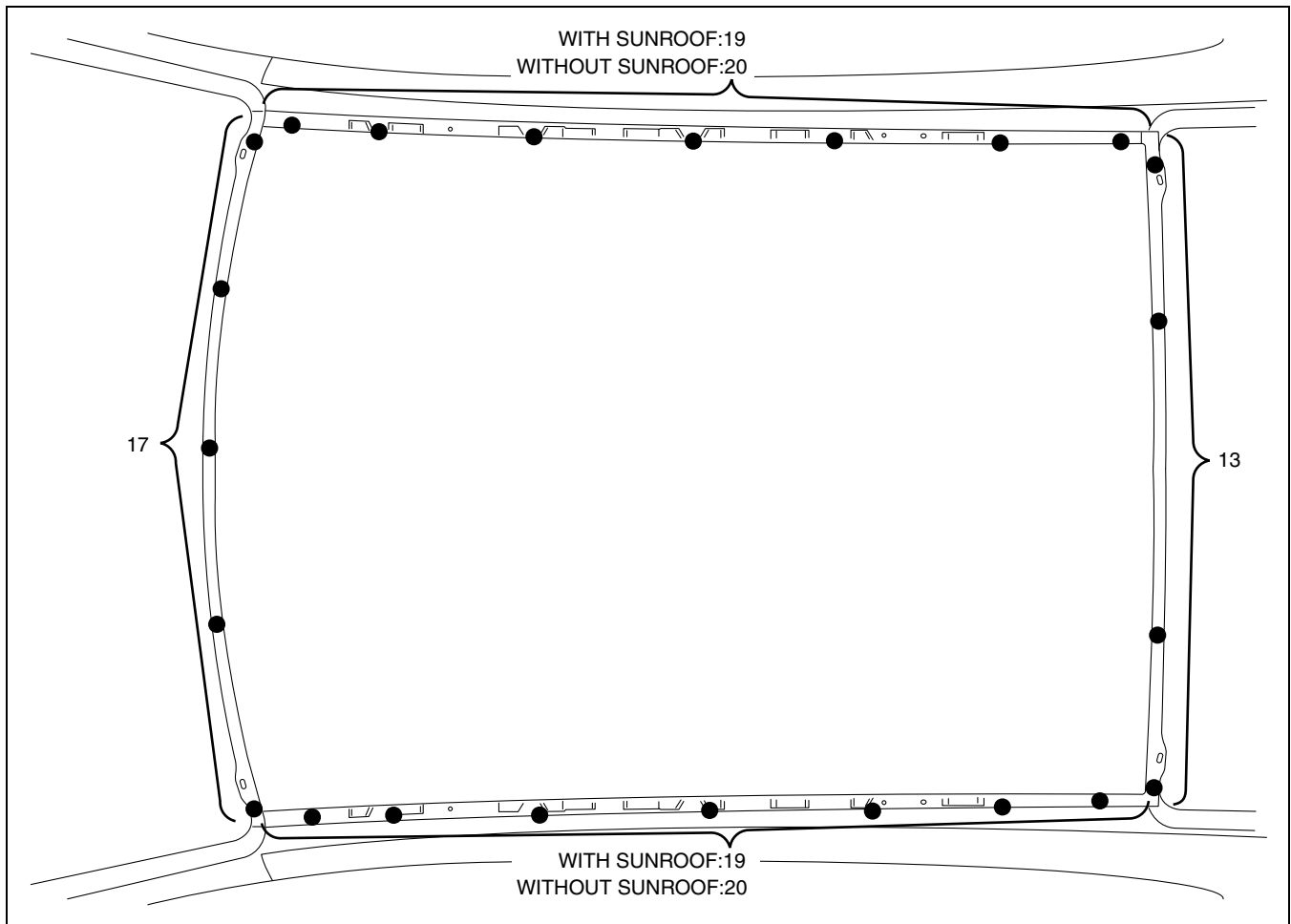
BODY STRUCTURE [PANEL REPLACEMENT]

ROOF PANEL REMOVAL

C3U098070600B01

4SD

1. Remove the roof panel.

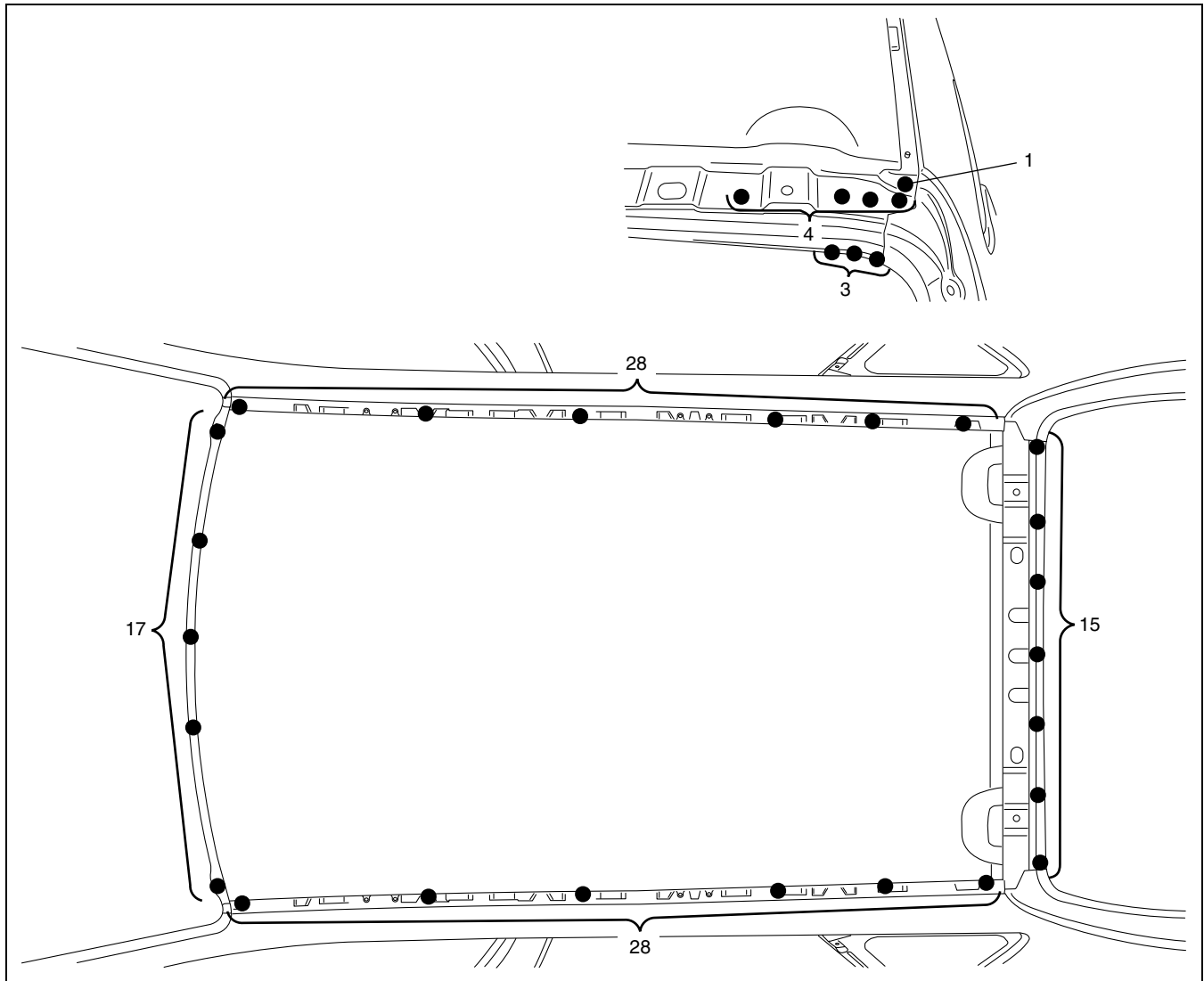


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BODY STRUCTURE [PANEL REPLACEMENT]

5HB

1. Remove the roof panel.



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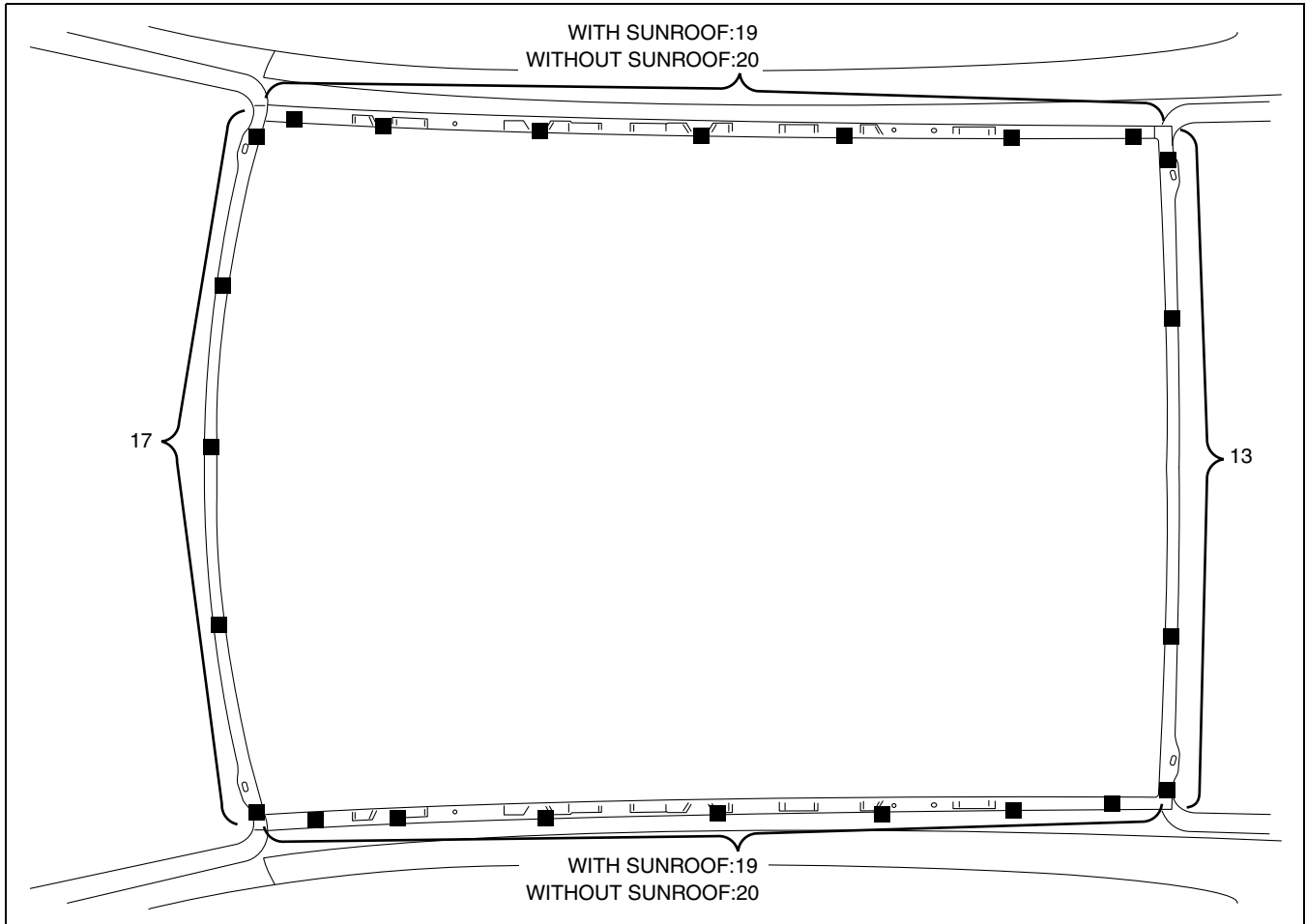
BODY STRUCTURE [PANEL REPLACEMENT]

ROOF PANEL INSTALLATION

C3U098070600B02

4SD

1. When installing new parts, measure and adjust the body as necessary to conform with standard dimensions.
2. Drill holes for plug welds before installing new parts.
3. After temporarily installing new parts, make sure the related parts fit properly.



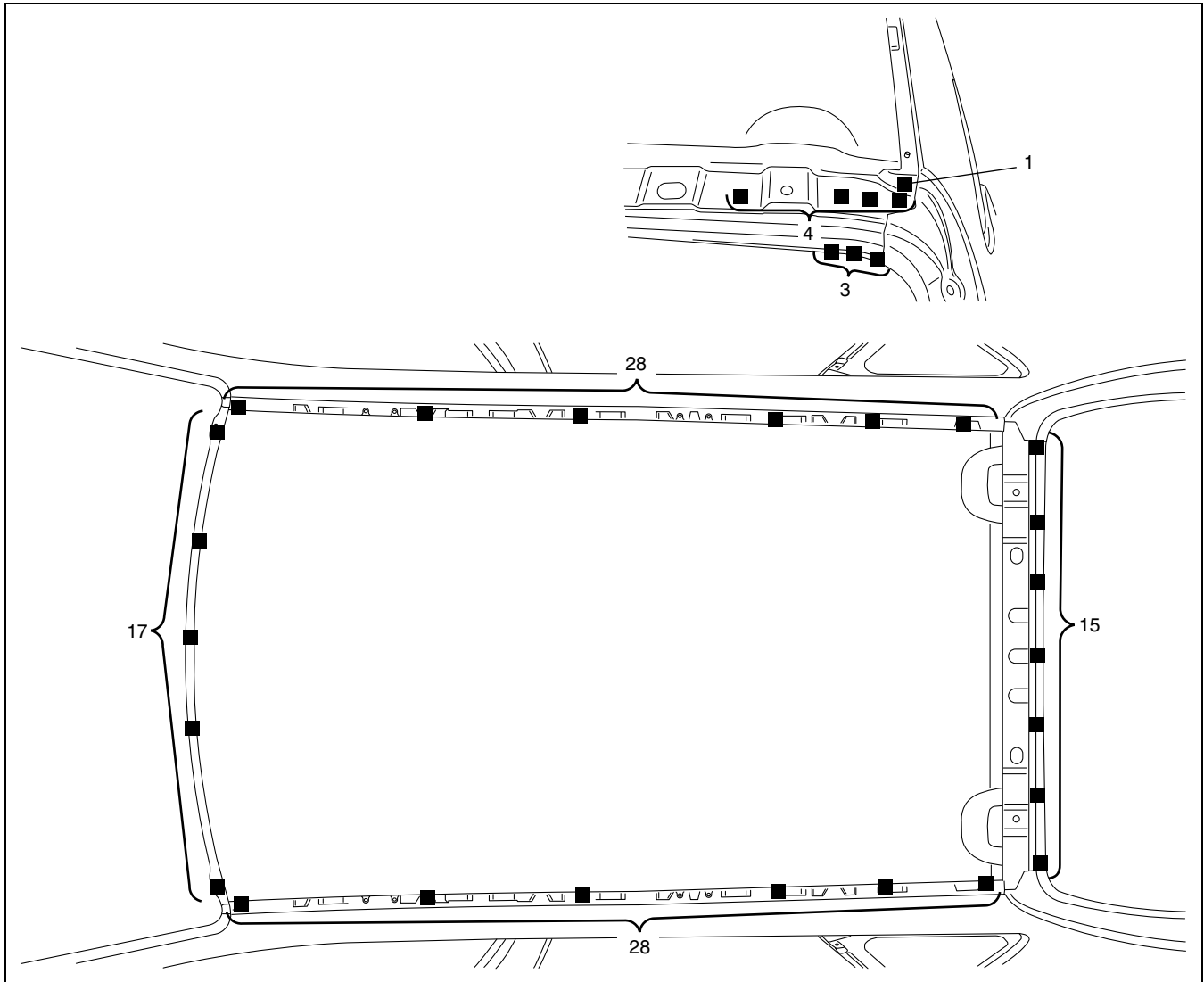
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BODY STRUCTURE [PANEL REPLACEMENT]

5HB

1. When installing new parts, measure and adjust the body as necessary to conform with standard dimensions.
2. Drill holes for plug welds before installing new parts.
3. After temporarily installing new parts, make sure the related parts fit properly.



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