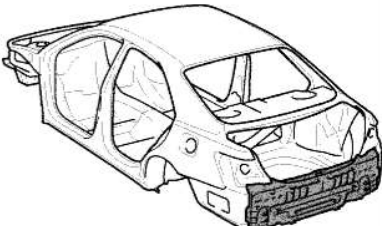


BODY LOWER BACK PANEL (ASSY)



F25743A

Symbol meaning

REMOVAL ▲ : Remove Weld Points

INSTALLATION ◻ : MIG Plug Weld

F25743B

REMOVAL-INSTALLATION

▲-6
◻-6

▲-14
◻-14

▲-16
◻-16

▲-2
◻-2

▲-10
◻-10

▲-1
◻-1

▲-3
◻-3

▲-6
◻-6

F25743

INSTALLATION POINT

1

Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.

2

Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)

3

After welding, apply body sealer and undercoating to the corresponding parts. (See the paint coating)

4

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

BODY PANEL REPLACEMENT

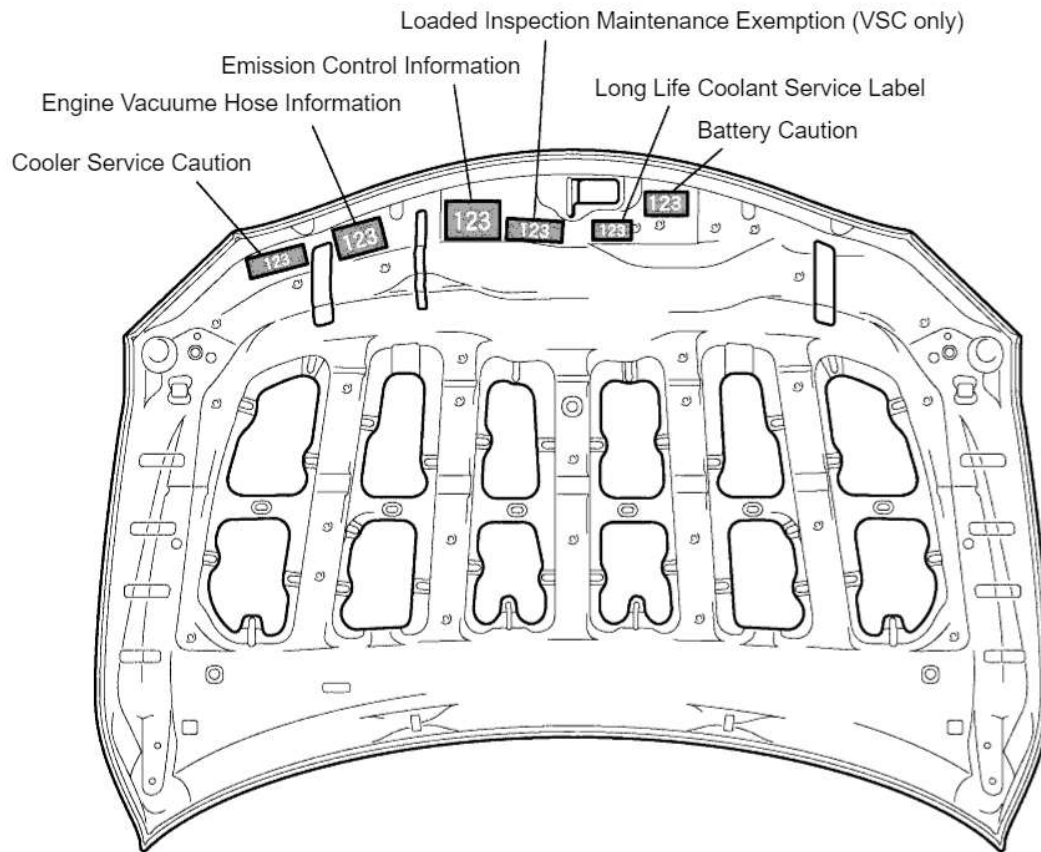
BP-75

CAUTION LABEL ATTACHMENT POSITION

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

HINT:

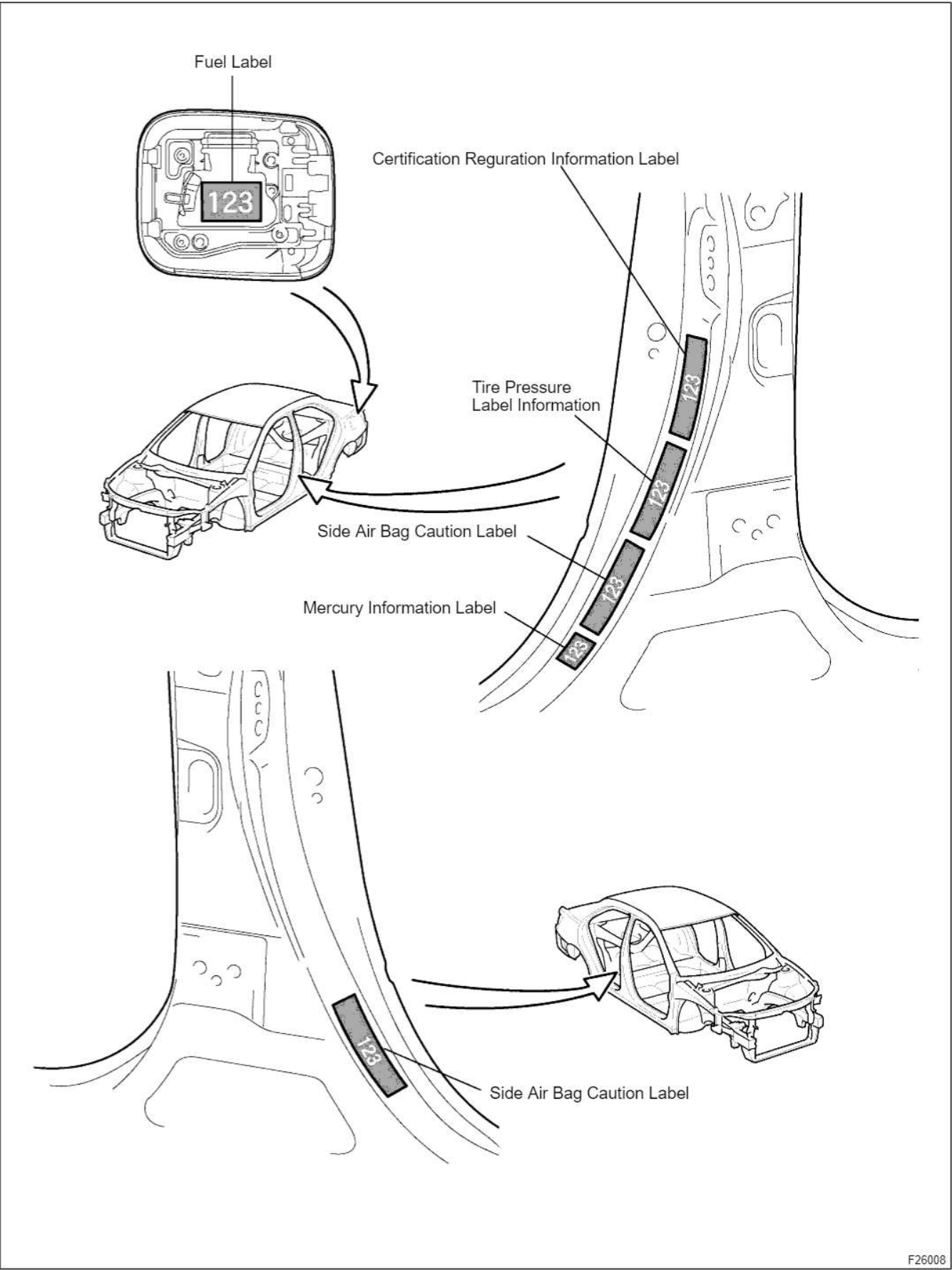
- 1) Attach each caution label with its orientation the same as the numbers shown in the illustration.
- 2) Make sure the caution label is not attached over a spot weld.
- 3) When attaching the caution label, make sure not to touch the label's adhesive surface.
- 4) To prevent the edges of the caution label from peeling, apply extra pressure to the label's periphery.
- 5) If the work area's temperature is 5°C or less, the caution label's adhesive will deteriorate. It is recommended that you heat the label to 20 to 40°C.



F26007

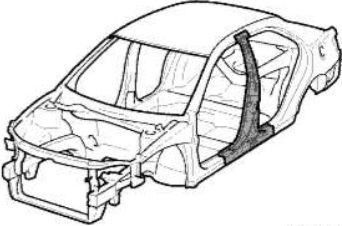
BP-76

BODY PANEL REPLACEMENT



F26008

CENTER BODY PILLAR (CUT)



F25726A

Symbol meaning

  : Remove Weld Points

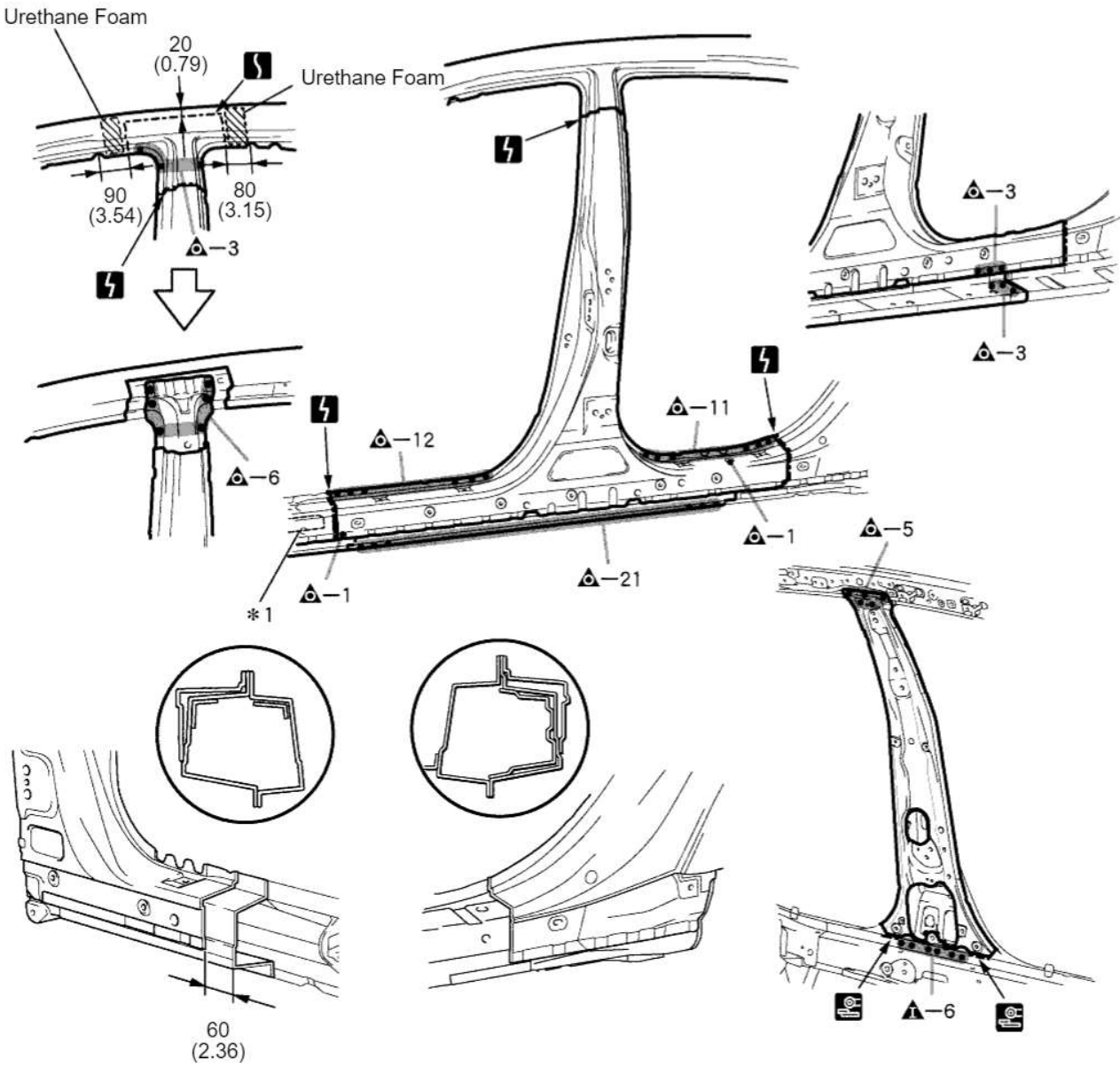
 : Cut with disc sander, etc.

 : Cut and Join Location

 : Cut Location for Supply Parts

F25726B

REMOVAL



Urethane Foam

20 (0.79)

90 (3.54)

80 (3.15)

Urethane Foam

mm (in.)

F25726

REMOVAL POINT

1 *1: Take care not to damage the internal reinforcement.

BODY PANEL REPLACEMENT

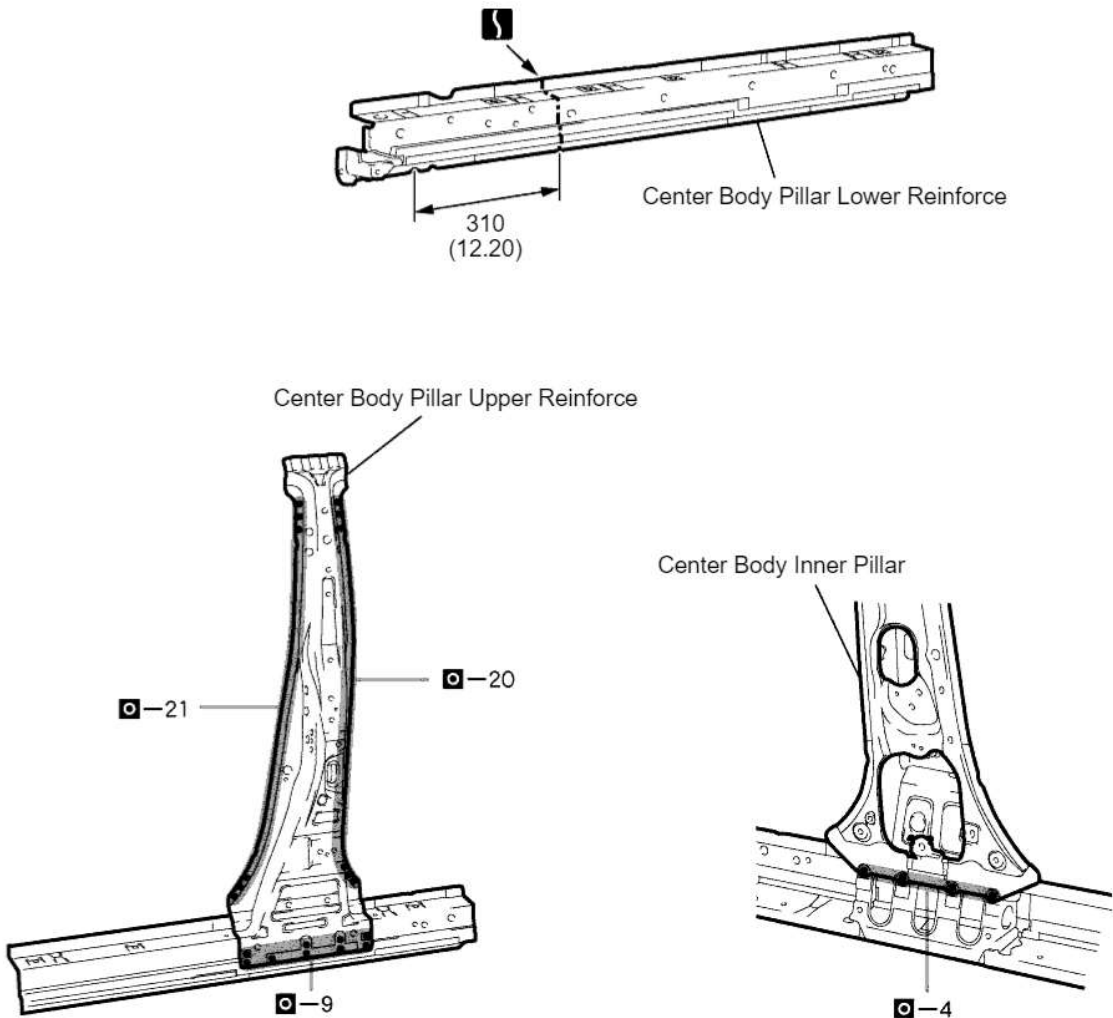
BP-25

Symbol meaning

-  : MIG Plug Weld  : Cut and Join Location
-  : Tack Weld  : Butt Weld

F25727B

INSTALLATION



mm (in.)

F25727

INSTALLATION POINT

- 1 Before temporarily installing the new parts, weld the center body pillar lower reinforce, center body pillar upper reinforce and center body inner pillar with the standard number of welding points.

BP-26

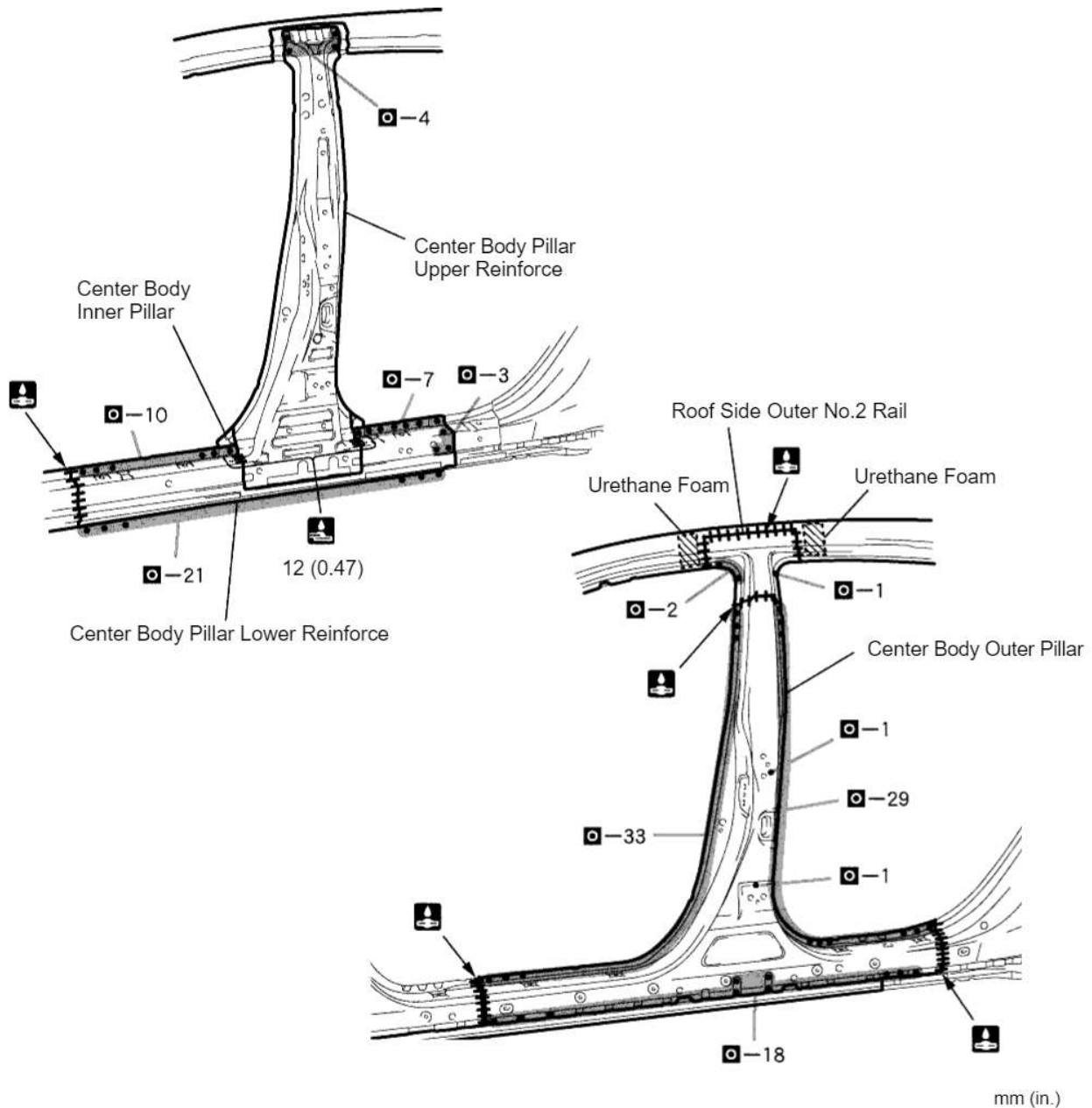
BODY PANEL REPLACEMENT

Symbol meaning

◻ I : MIG Plug Weld ◻ : Cut and Join Location

◻ : Tack Weld ◻ : Butt Weld

F25727B



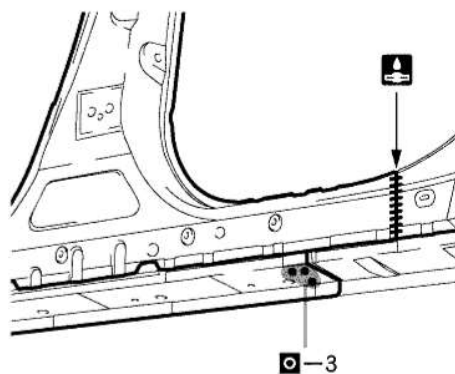
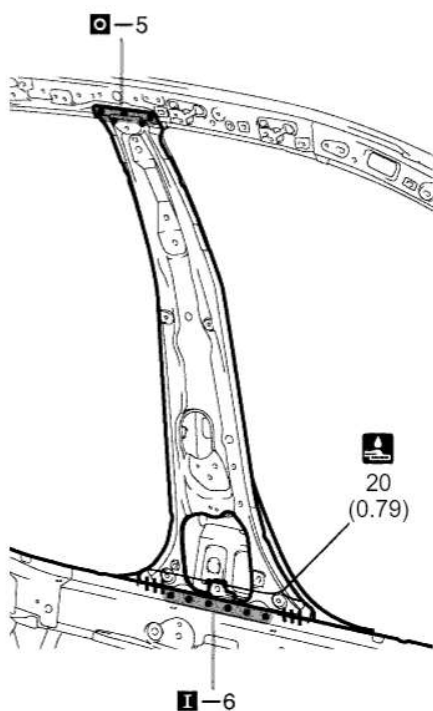
F25728

INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 After welding the center body pillar lower reinforce, center body pillar upper reinforce and center body inner pillar to the vehicle side, install the center body outer pillar and roof side outer No.2 rail.

BODY PANEL REPLACEMENT

BP-27

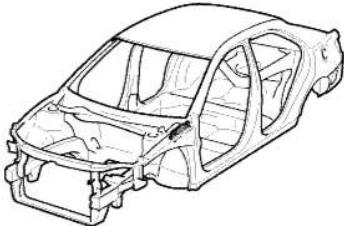


F25808

INSTALLATION POINT

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

COWL TOP OUTER PANEL (ASSY)



F25721A

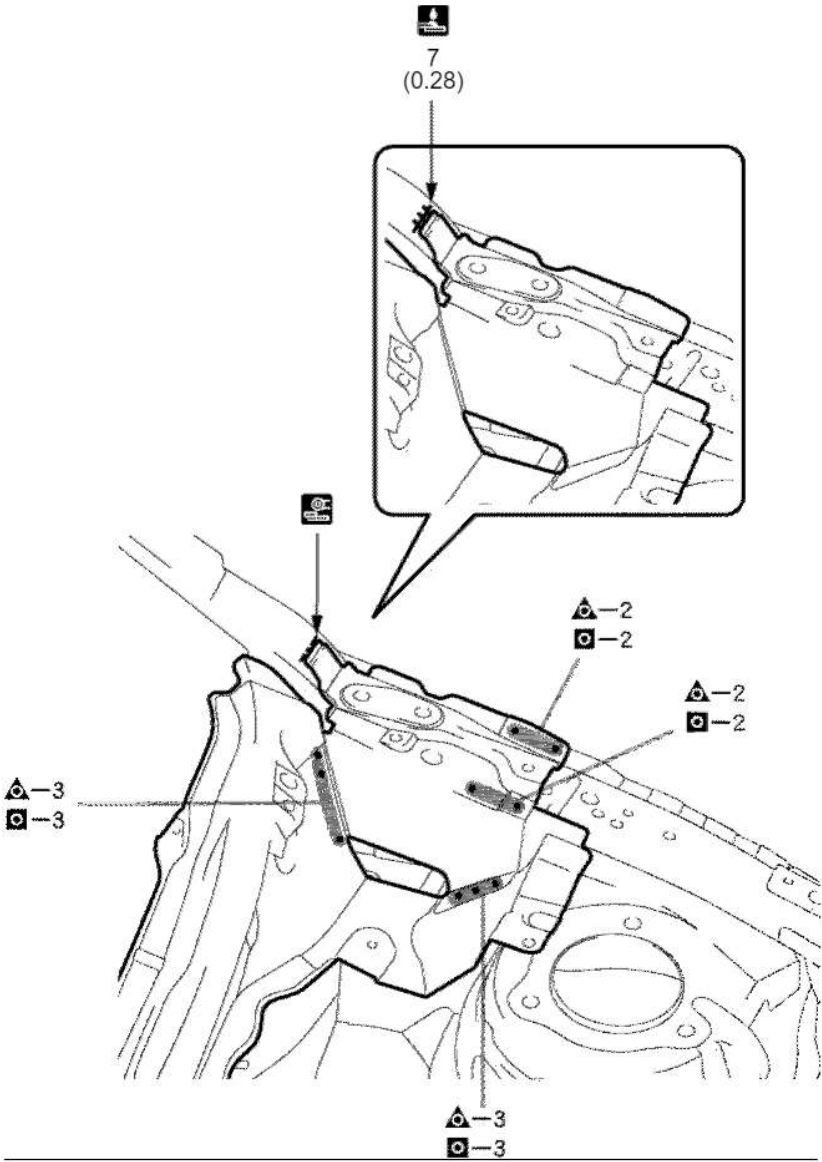
With the cowl top side reinforcement and front body pillar lower gusset removed.

Symbol meaning

REMOVAL	 : Remove Weld Points	 : Cut with disc sander, etc.
INSTALLATION	 : MIG Plug Weld	 : Tack Weld

F25721B

REMOVAL-INSTALLATION



7
(0.28)

2
2

2
2

3
3

3
3

mm (in.)

F25721

INSTALLATION POINT

1

Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)

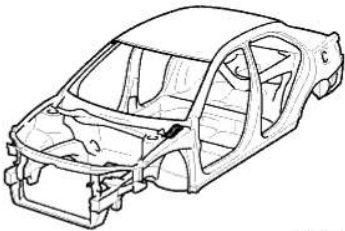
2

After welding, apply body sealer to the corresponding parts. (See the paint coating)

3

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

COWL TOP SIDE REINFORCEMENT (ASSY)



F25720A

Symbol meaning

REMOVAL  : Cut with disc sander, etc.

INSTALLATION  : Tack Weld

F25720B

REMOVAL-INSTALLATION

13 (0.51)

15 (0.59)

15 (0.59)

10 (0.39)

25 (0.98)

mm (in.)

F25720

INSTALLATION POINT

1 After welding, apply body sealer to the corresponding parts. (See the paint-coating)

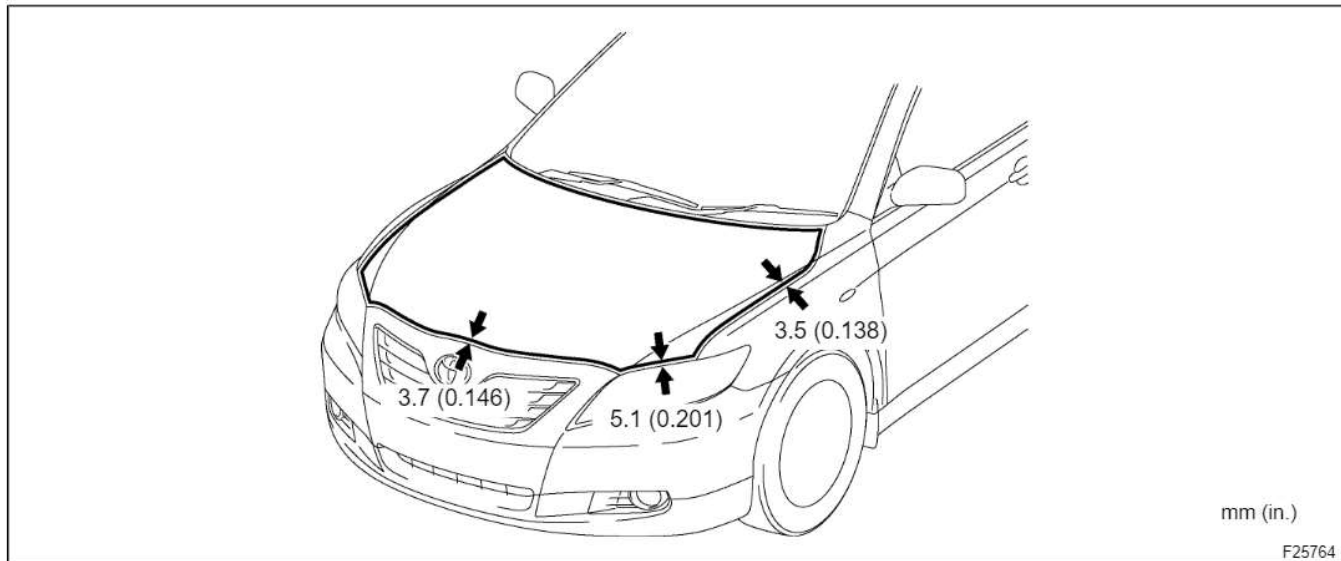
2 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

BP-66

BODY PANEL REPLACEMENT

FIT STANDARD/ADJUSTMENT METHOD/TORQUE SPECIFICATION

HOOD SUB-ASSEMBLY



1. ADJUST HOOD SUB-ASSEMBLY

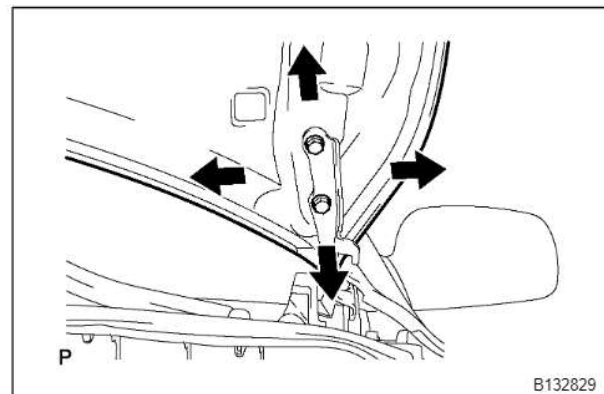
HINT:

- Centering bolts are used to mount the hood hinge and hood lock. The hood and hood lock cannot be adjusted with the centering bolts on. Substitute the centering bolts with standard bolts (with washers) when making adjustments.

- Horizontally and vertically adjust the hood.
 - Loosen the 4 hinge bolts of the hood.
 - Adjust the clearance between the hood and front fender by moving the hood.
 - Tighten the 4 hinge bolts after the adjustment.

Torque:

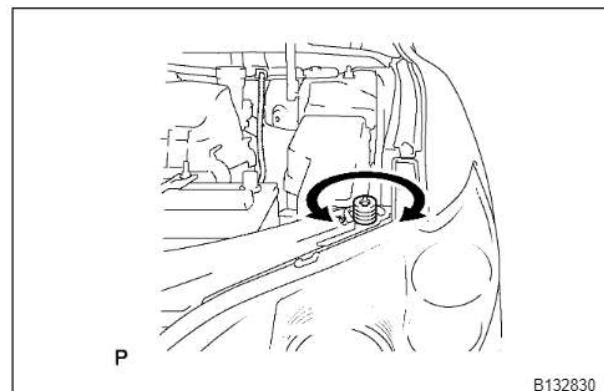
13 N·m (133 kgf·cm, 10 ft·lbf)



- Adjust the height of the front end of the hood using the cushion rubber.
 - Adjust the cushion rubber so that the height of the hood and fender are aligned.

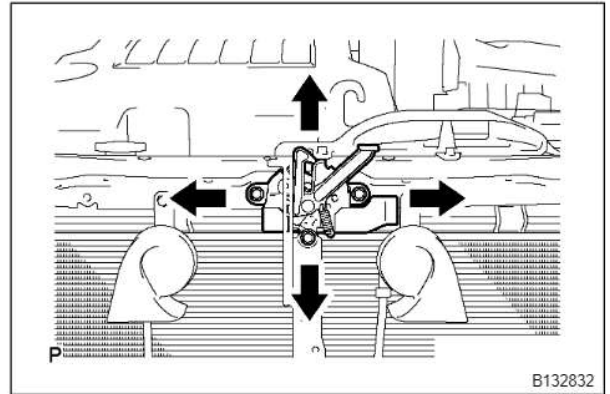
HINT:

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



BODY PANEL REPLACEMENT**BP-67**

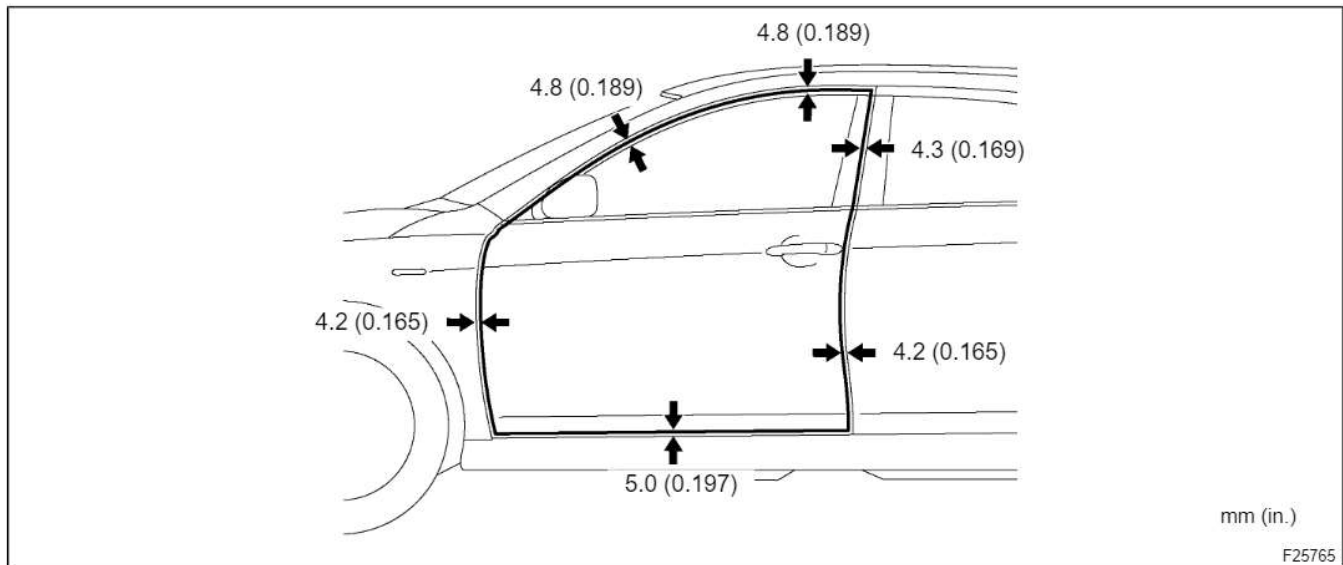
- c. Adjust the hood lock.
 - i. Loosen the 3 bolts.
 - ii. Tighten the bolts after the adjustment.
- Torque:**
7.5 N·m (77 kgf·cm, 66 in·lbf)
- iii. Check that the striker can engage with the hood lock smoothly.



BP-68

BODY PANEL REPLACEMENT

FRONT DOOR



1. ADJUST FRONT DOOR

HINT:

- Before adjusting the door position for vehicles equipped with side airbags and curtain shield airbags, be sure to disconnect the battery. After adjustment, inspect the SRS warning light, the side airbag system, and the curtain shield airbag system for normal operation. Then initialize both airbag systems.
 - Use the same procedures for the RH side and LH side.
 - The procedures listed below are for the LH side.
 - Centering bolts are used to mount the door hinge to the vehicle body and door. The door cannot be adjusted with the centering bolts on. Substitute the centering bolts with standard bolts (with washers) when making adjustment.
- Using SST, loosen the hinge bolts on the vehicle body and adjust the door position.

SST

09812-00010

- Tighten the hinge bolts on the vehicle body after the adjustment.

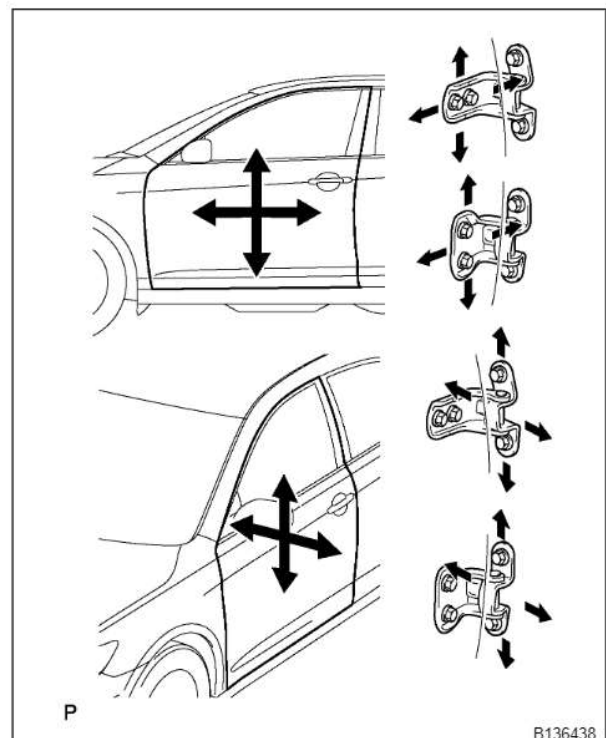
Torque:

26 N·m (265 kgf·cm, 19 ft·lbf)

- Loosen the hinge bolts on the door and adjust the door position.
- Tighten the hinge bolts on the door after the adjustment.

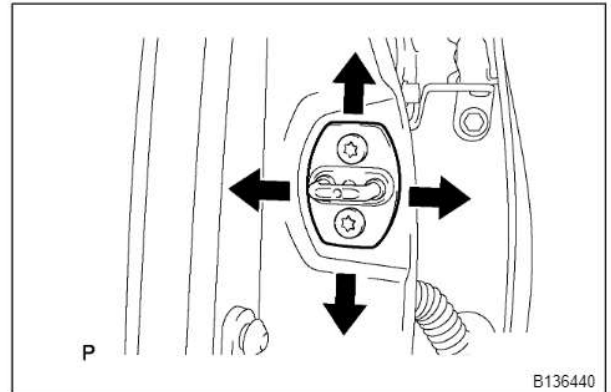
Torque:

26 N·m (265 kgf·cm, 19 ft·lbf)



BODY PANEL REPLACEMENT**BP-69**

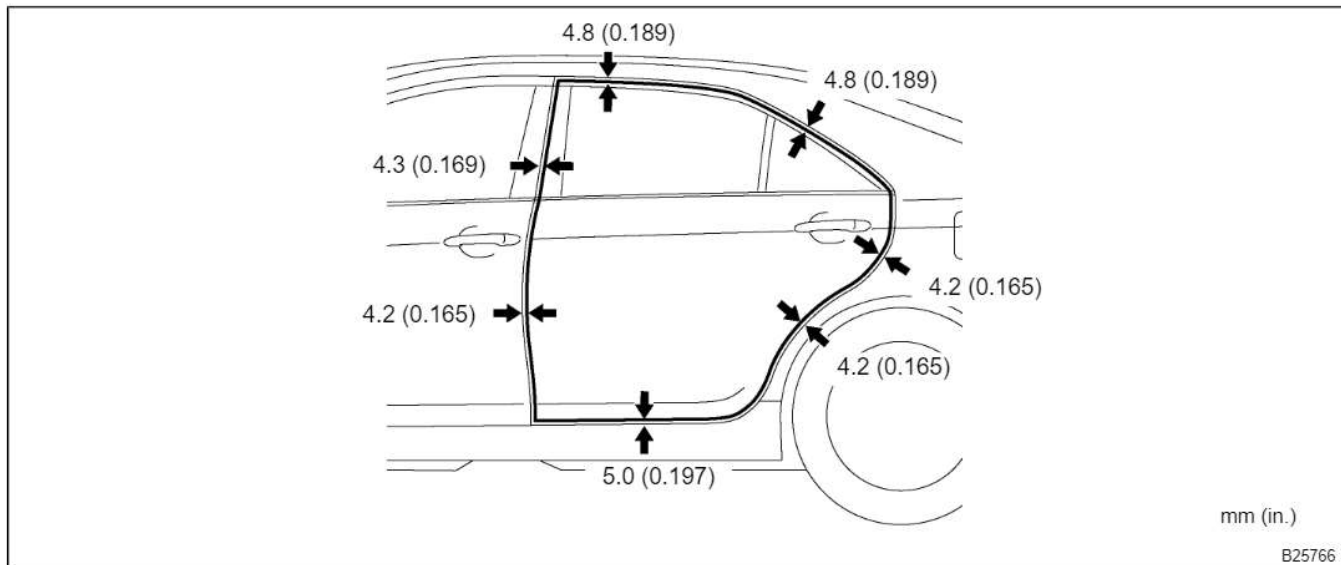
- e. Adjust the striker position by slightly loosening the striker mounting screws with a "TORX" socket wrench (T40) and hitting the striker with a plastic hammer.
- f. Using a "TORX" socket wrench (T40), tighten the striker mounting screws after the adjustment.

Torque:**23 N·m (235 kgf·cm 17 ft·lbf)**

BP-70

BODY PANEL REPLACEMENT

REAR DOOR



1. ADJUST REAR DOOR

HINT:

- Before adjusting the door position for vehicles equipped with side airbags and curtain shield airbags, be sure to disconnect the battery. After adjustment, inspect the SRS warning light, the side airbag system, and the curtain shield airbag system for normal operation. Then initialize both airbag systems.
- Use the same procedures for the RH side and LH side.
- The procedures listed below are for the LH side.
- Centering bolts are used to mount the door hinge to the vehicle body and door. The door cannot be adjusted with the centering bolts on. Substitute the centering bolts with standard bolts (with washers) when making adjustments.

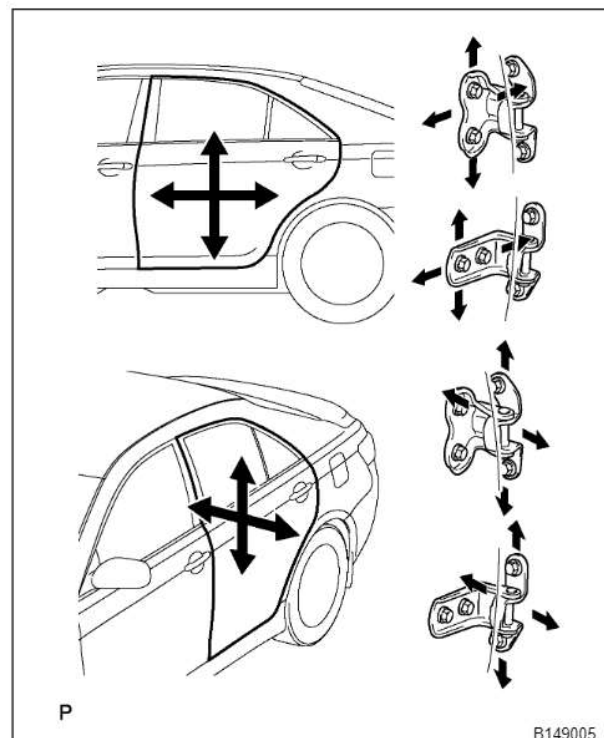
- Loosen the hinge bolts on the vehicle body and adjust the door position.

SST**09812-00010**

- Tighten the hinge bolts on the vehicle body after the adjustment.

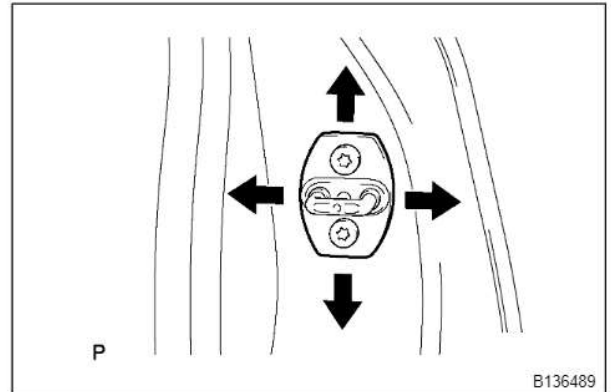
Torque:**26 N·m (265 kgf·cm, 19 ft·lbf)**

- Loosen the hinge bolts on the door and adjust the door position.
- Tighten the hinge bolts on the door after the adjustment.

Torque:**26 N·m (265 kgf·cm, 19 ft·lbf)**

BODY PANEL REPLACEMENT**BP-71**

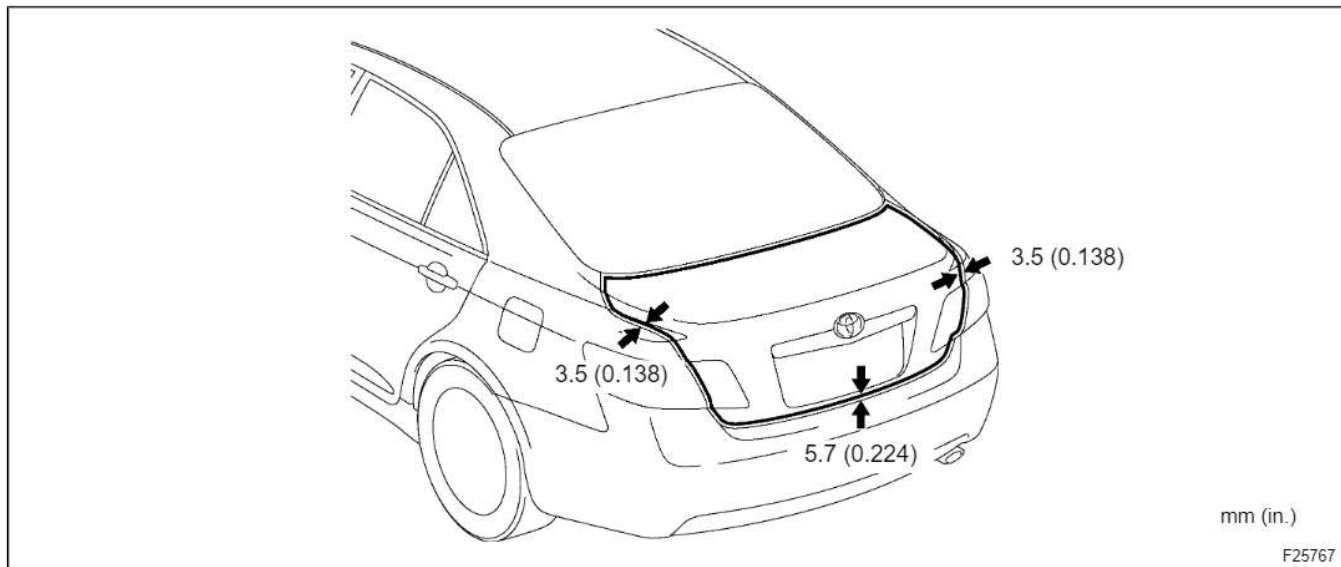
- e. Adjust the striker position by slightly loosening the striker mounting screws with a "TORX" socket wrench (T40) and hitting the striker with a plastic hammer.
- f. Using a "TORX" socket wrench (T40), tighten the striker mounting screws after the adjustment.

Torque:**23 N·m (235 kgf·cm, 17 ft·lbf)**

BP-72

BODY PANEL REPLACEMENT

LUGGAGE COMPARTMENT DOOR



1. ADJUST LUGGAGE COMPARTMENT DOOR

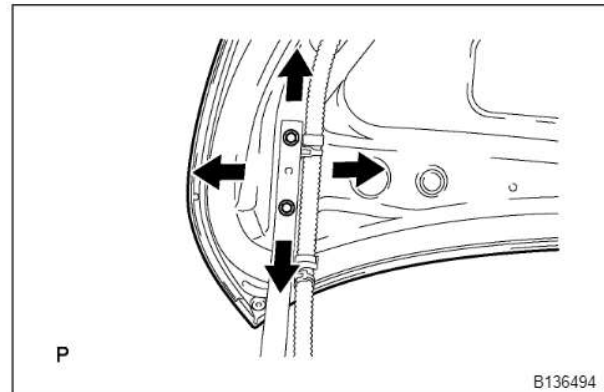
HINT:

- Centering bolts are used to mount the door hinge to the door. The door cannot be adjusted with the centering bolts on. Substitute the centering bolts with standard bolts (with washers) when making adjustments.

- Loosen the door side hinge bolts to adjust the door horizontally and vertically.

Torque:

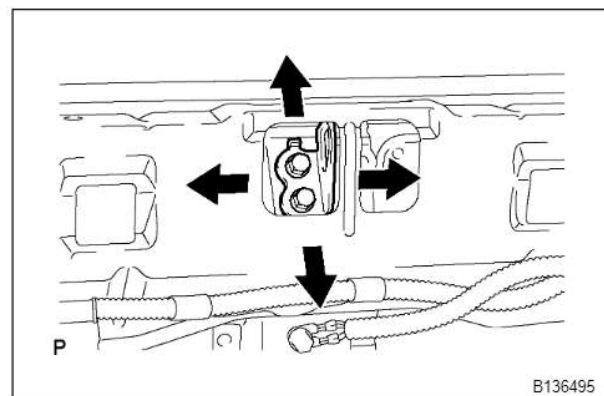
7.5 N·m (77 kgf·cm, 66 in·lbf)



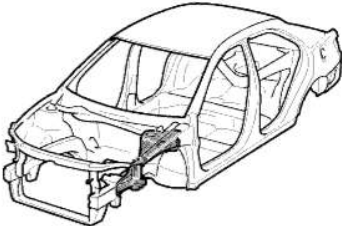
- Adjust the striker position by slightly loosening the striker mounting screws and hitting the striker with a plastic hammer.
- Tighten the striker mounting screws after the adjustment.

Torque:

5.5 N·m (56 kgf·cm, 49 in·lbf)



FRONT FENDER APRON (ASSY)



F25710A

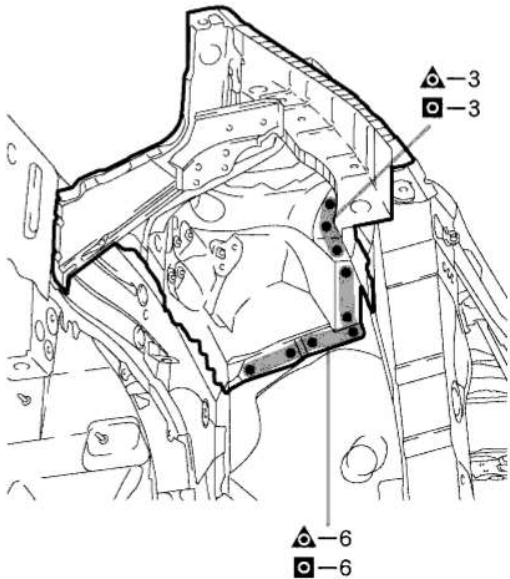
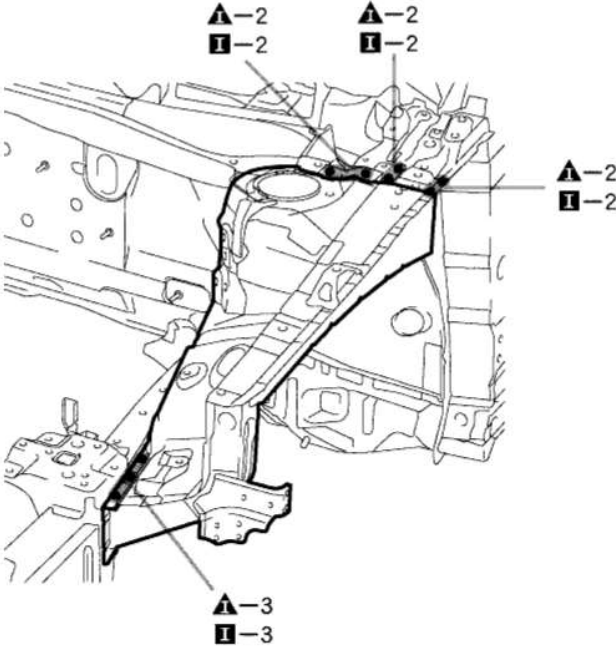
With the radiator support and front body pillar lower gusset removed.

Symbol meaning

REMOVAL	▲ ▲ ▲ : Remove Weld Points	⚙️ : Cut with disc sander, etc.
INSTALLATION	Ⓞ M I : MIG Plug Weld	🔥 : Tack Weld

F25710B

REMOVAL-INSTALLATION



CAUTION

Make sure to attach correctly in accordance with the body dimension diagram as this parts affects the front wheel alignment.

F25710

INSTALLATION POINT

1

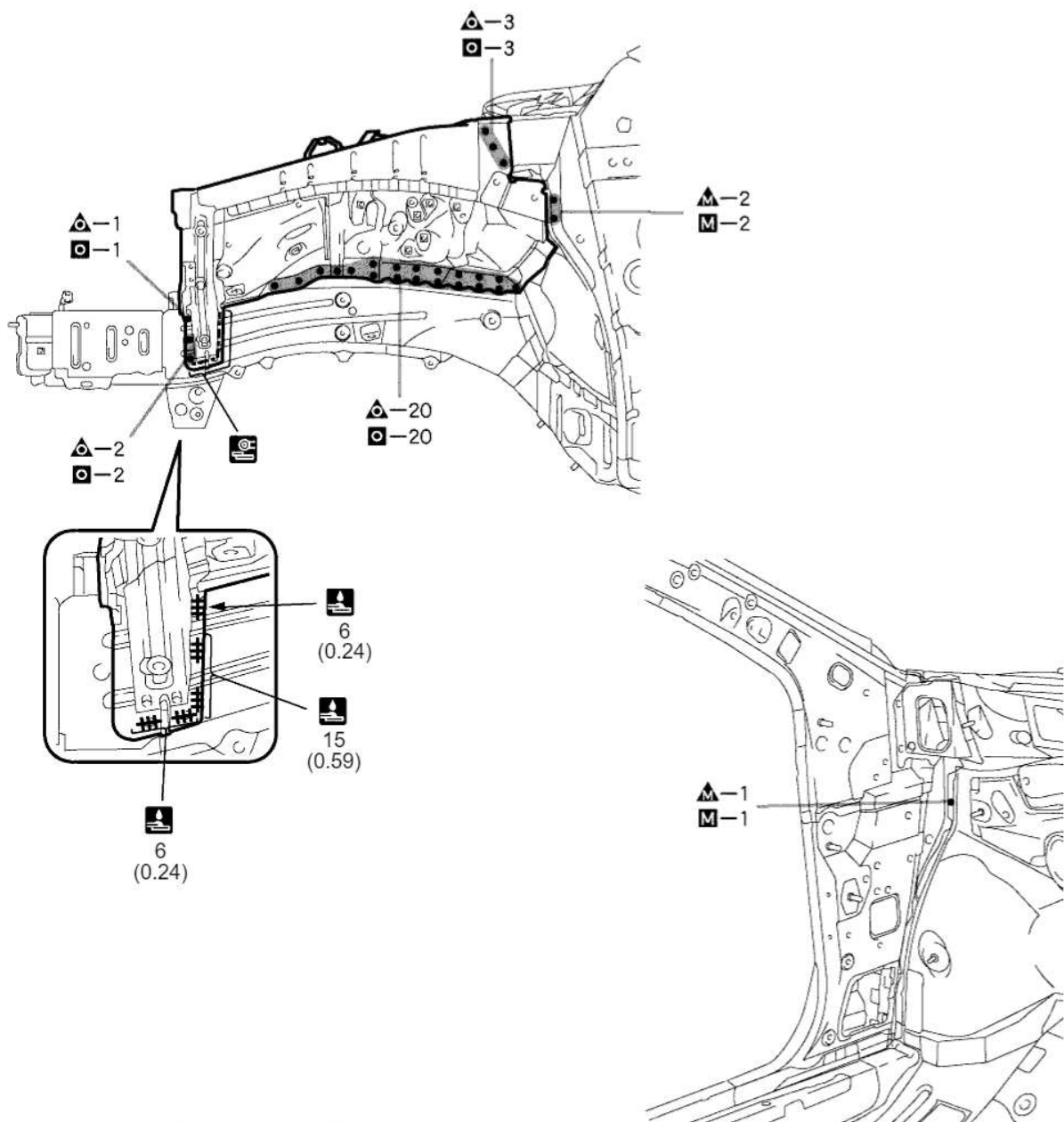
Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.

2

Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)

BODY PANEL REPLACEMENT

BP-11

**CAUTION**

Make sure to attach correctly in accordance with the body dimension diagram as this parts affects the front wheel alignment.

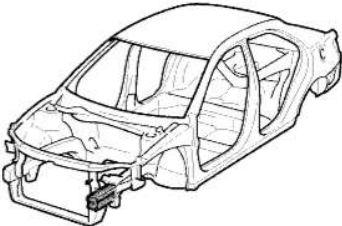
mm (in.)

F25711

INSTALLATION POINT

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

FRONT SIDE MEMBER (CUT-P)



F25712A

With the radiator support removed.

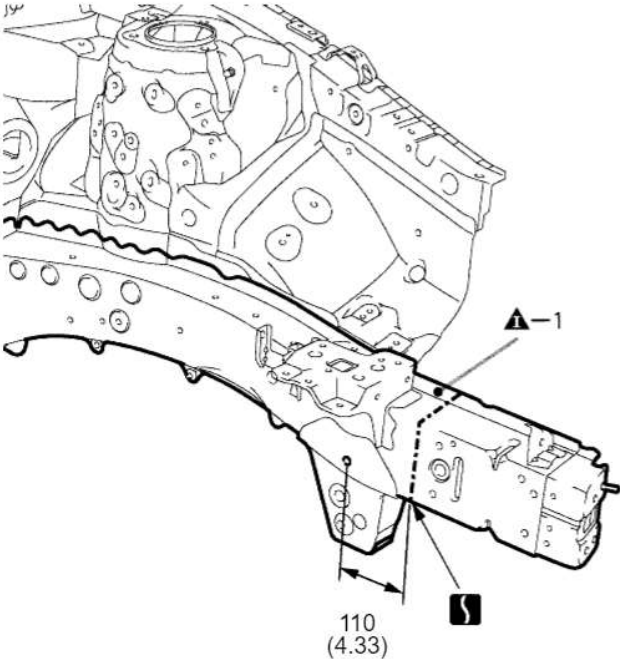
Symbol meaning

  : Remove Weld Points

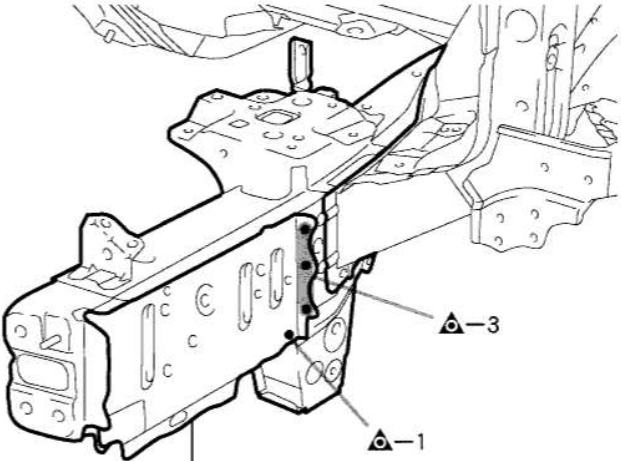
 : Cut and Join Location

F25712B

REMOVAL



110
(4.33)



Front Side Member Extension

mm (in.)

F25712

REMOVAL POINT

1 Remove the front side member extension at the same time.

BODY PANEL REPLACEMENT

BP-13

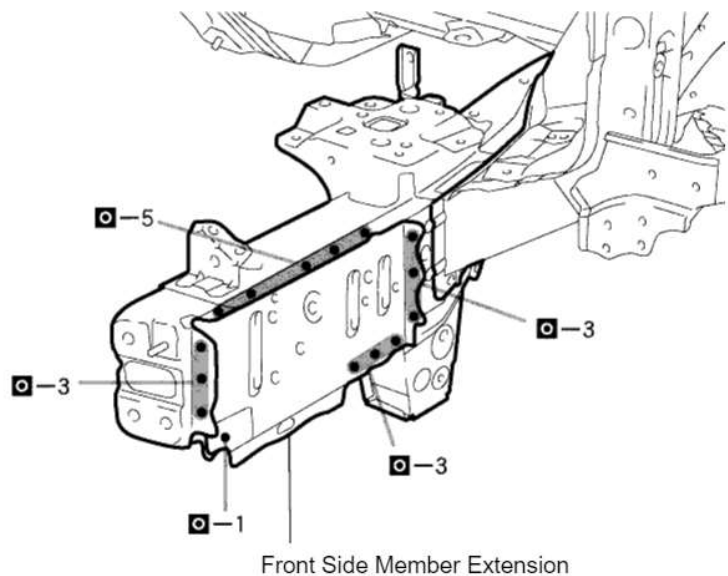
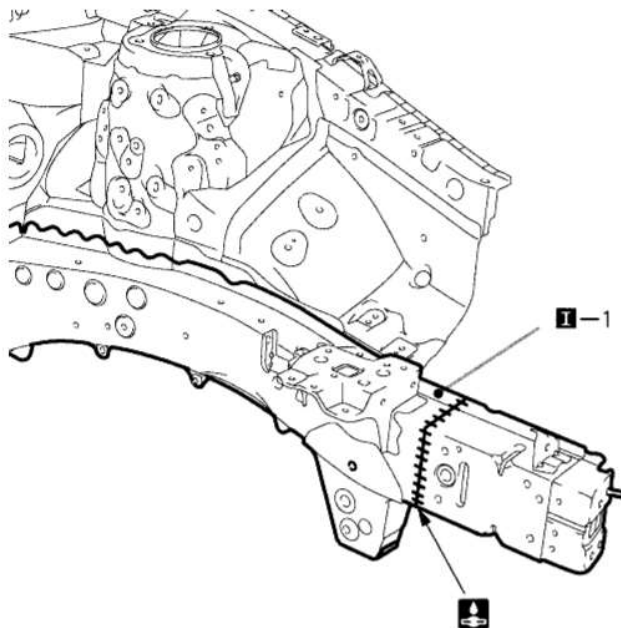
Symbol meaning

 : MIG Plug Weld

 : Butt Weld

F25713B

INSTALLATION

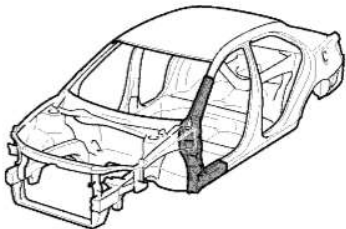


F25713

INSTALLATION POINT

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

FRONT BODY PILLAR (CUT)



F25722A

With the cowl top outer panel removed.

Symbol meaning



: Cut with disc sander, etc.



: Cut and Join Location



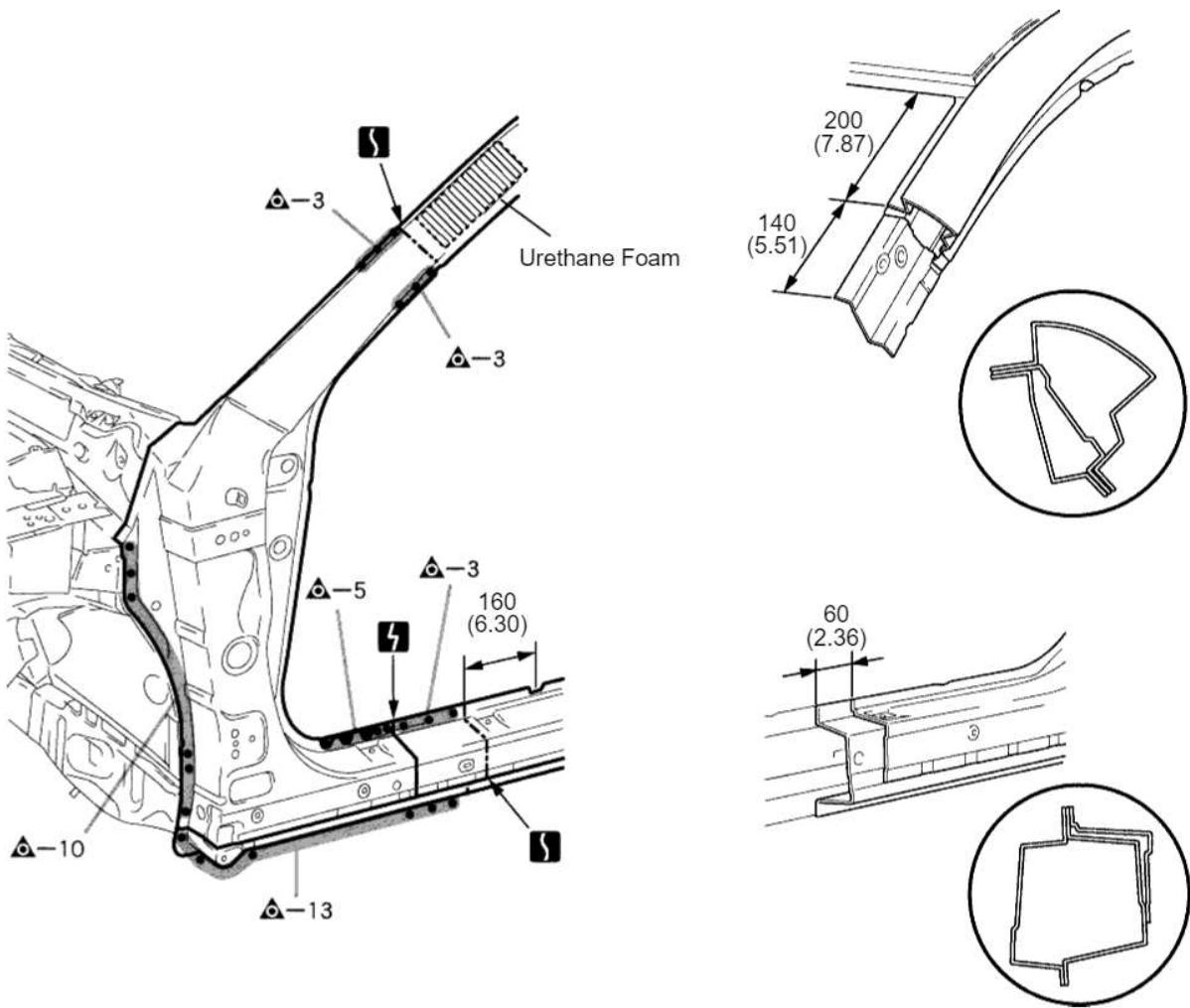
: Remove Weld Points



: Cut Location for Supply Parts

F25722B

REMOVAL



mm (in.)

F25722

BP-20

BODY PANEL REPLACEMENT

Symbol meaning

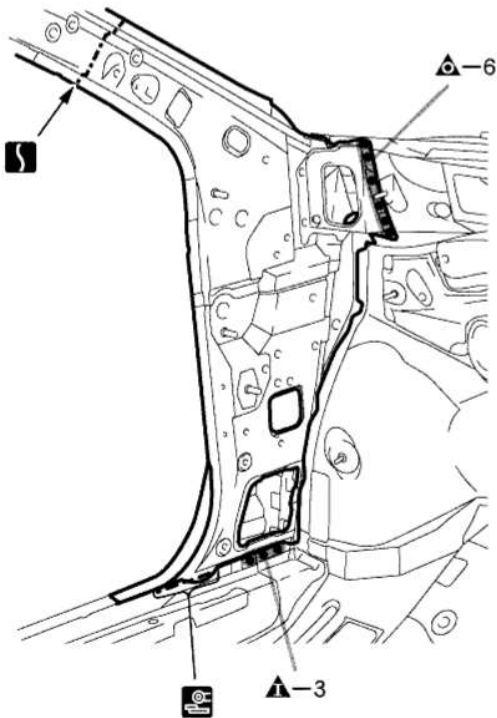
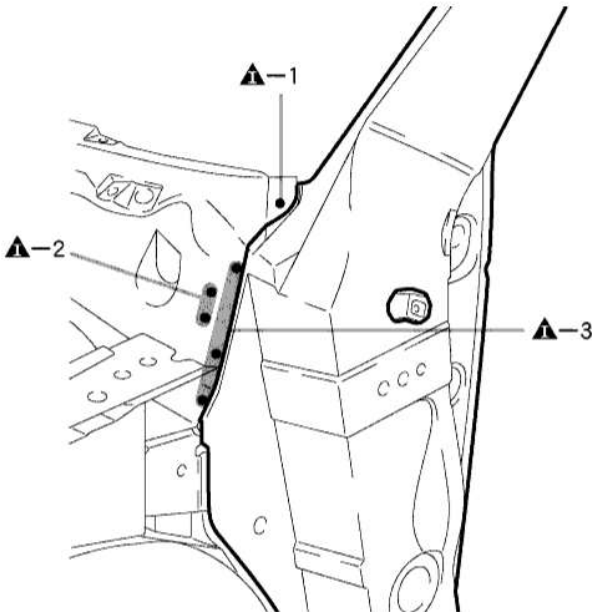
 : Cut with disc sander, etc.

 : Cut and Join Location

  : Remove Weld Points

 : Cut Location for Supply Parts

F25722B



F25723

BODY PANEL REPLACEMENT

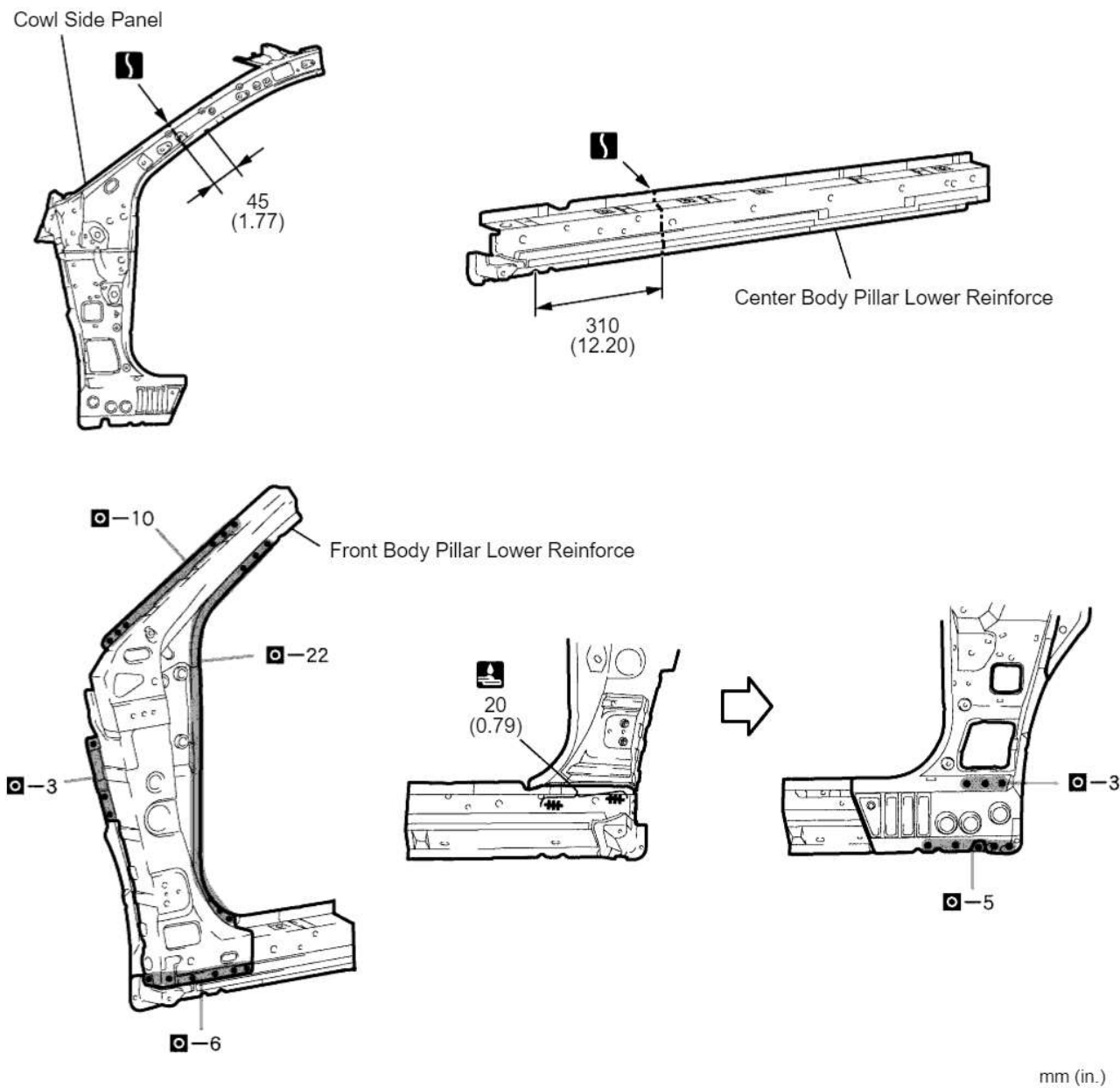
BP-21

Symbol meaning

-  **I** : MIG Plug Weld
  : Cut and Join Location
 : Tack Weld
  : Butt Weld
  : Body Sealer

F25724B

INSTALLATION



F25724

INSTALLATION POINT

- 1 Before temporarily installing the new parts, weld the center body pillar lower reinforce, front body pillar lower reinforce and cowl side panel with the standard number of welding points.

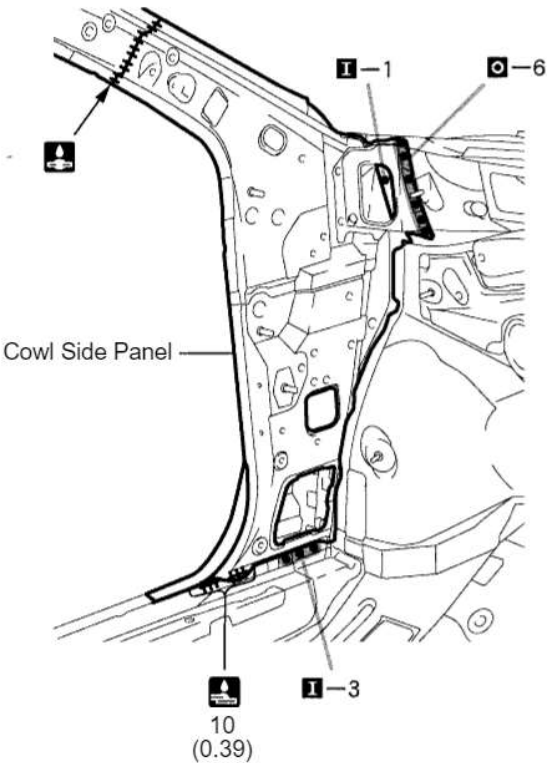
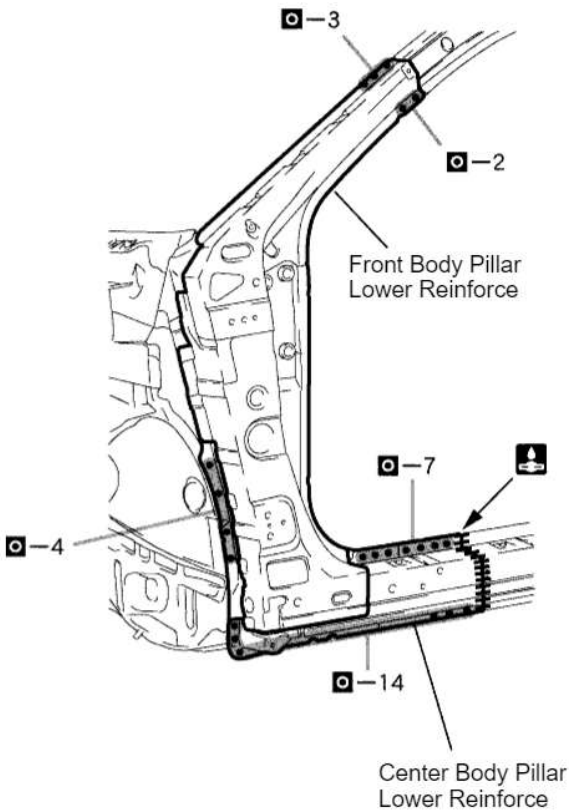
BP-22

BODY PANEL REPLACEMENT

Symbol meaning

- ⊙ 1 : MIG Plug Weld ✂ : Cut and Join Location
⊙ : Tack Weld ⊕ : Butt Weld ✍ : Body Sealer

F25724B



mm (in.)

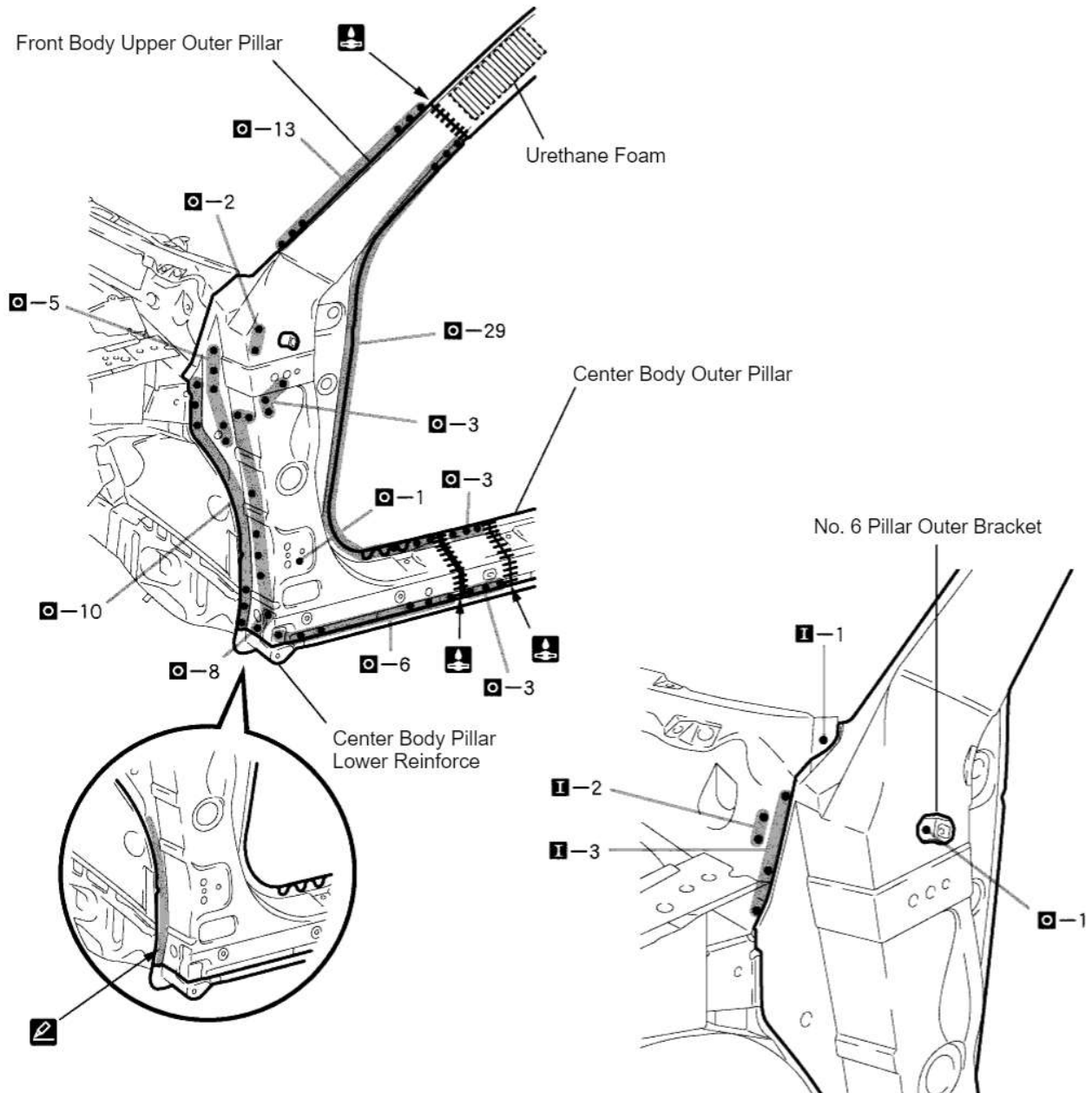
F25725

INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 After welding the center body pillar lower reinforce, front body pillar lower reinforce and cowl side panel to the vehicle side, install the front body upper outer pillar and center body outer pillar.

BODY PANEL REPLACEMENT

BP-23



F25807

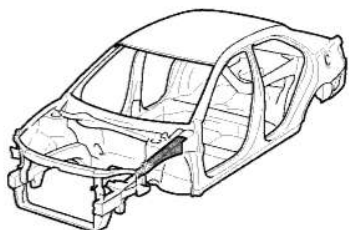
INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 Before installing a new part, apply body sealer.
HINT:
1) Apply sealer in an even, continuous bead.
- 4 After welding the center body pillar lower reinforce and front body pillar lower reinforce to the vehicle side, install the front body upper outer pillar, center body outer pillar and No.6 pillar outer bracket.
- 5 After welding, apply the polyurethane foam to the corresponding parts. (See the paint coating)
- 6 After welding, apply body sealer and undercoating to the corresponding parts. (See the paint coating)
- 7 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

BP-8

BODY PANEL REPLACEMENT

FRONT APRON TO COWL SIDE UPPER MEMBER (ASSY)



F25709A

With the front fender front apron and front body pillar lower gusset removed.

Symbol meaning

REMOVAL

△ △ △ : Remove Weld Points

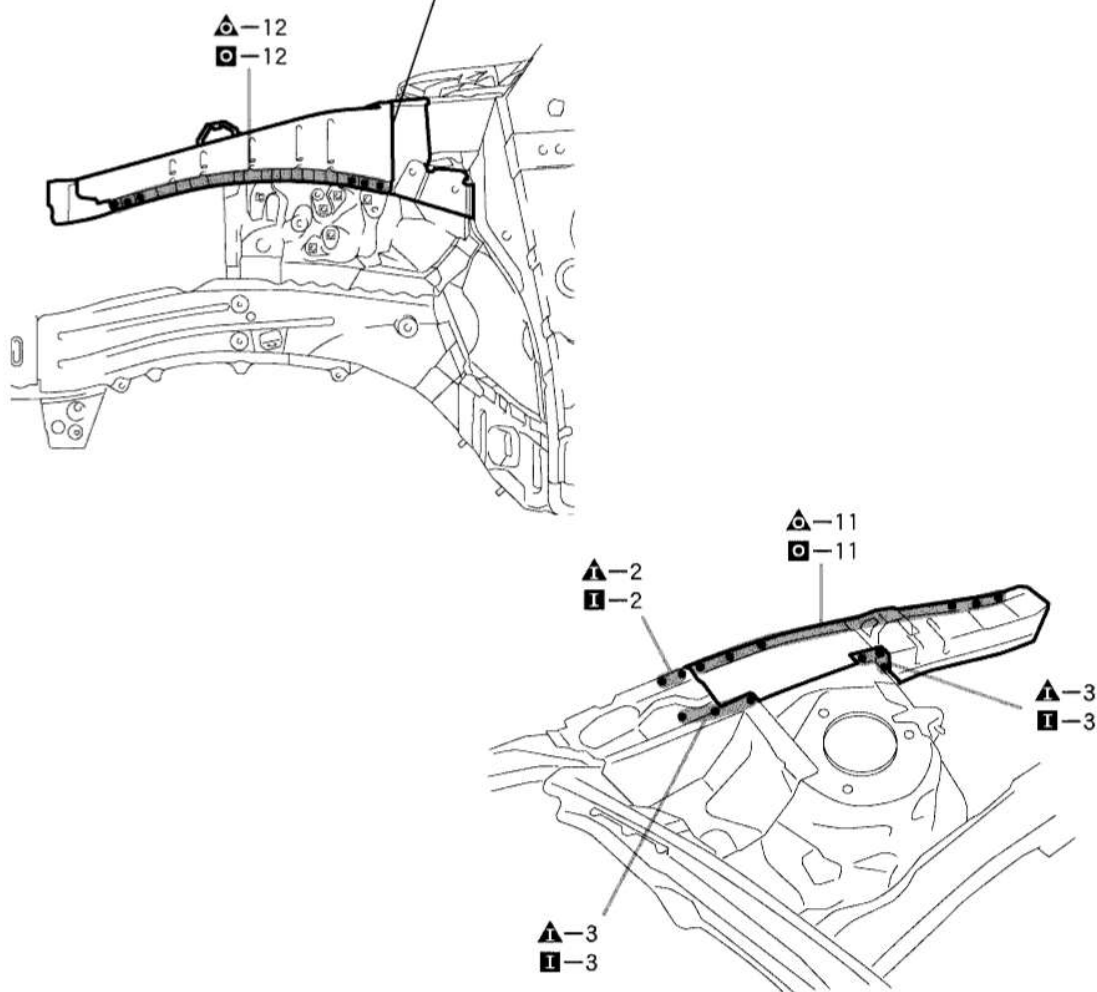
INSTALLATION

□ M I : MIG Plug Weld

F25709B

REMOVAL-INSTALLATION

Front Apron To Cowl Side Lower Front Member



F25709

REMOVAL POINT

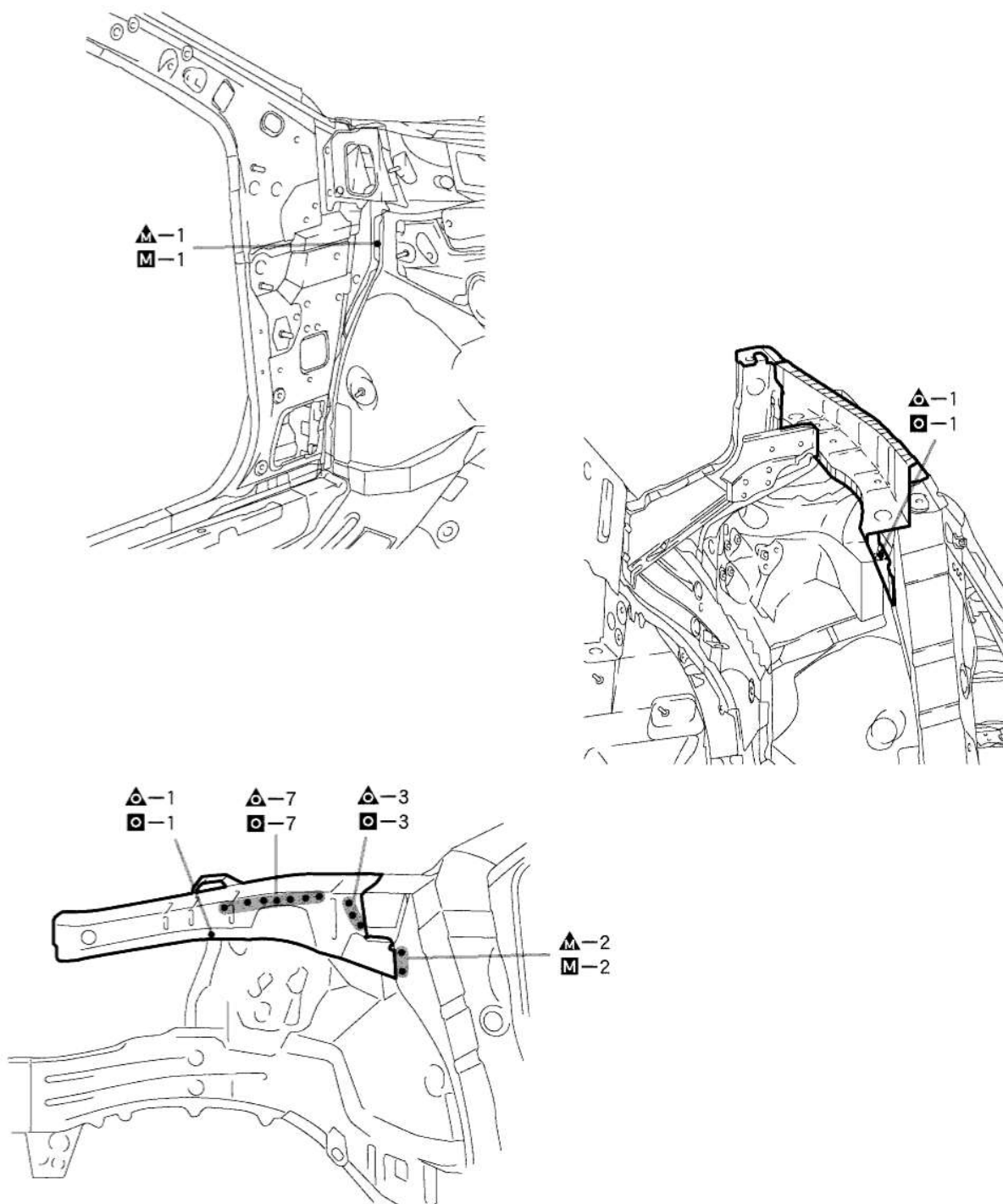
- 1 After removing the front apron to cowl side lower front member, remove the front apron to cowl side upper member.

INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 After welding the to the front apron to cowl side upper member vehicle side, install the front apron to cowl side lower front member.

BODY PANEL REPLACEMENT

BP-9



F25805

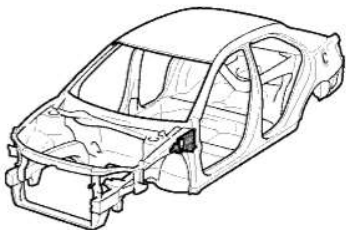
INSTALLATION POINT

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

BODY PANEL REPLACEMENT

BP-17

FRONT BODY PILLAR LOWER GUSSET (ASSY)



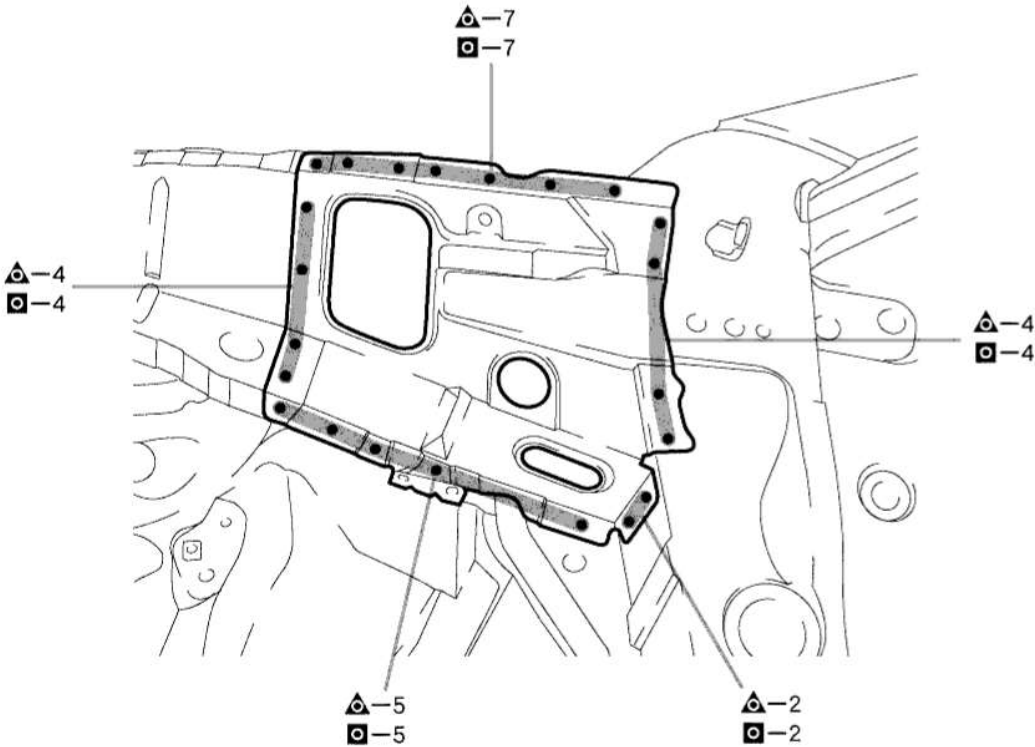
F25719A

Symbol meaning

- | | |
|--------------|------------------------|
| REMOVAL | ▲ : Remove Weld Points |
| INSTALLATION | ◻ : MIG Plug Weld |

F25719B

REMOVAL-INSTALLATION

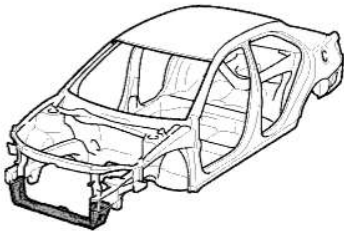


F25719

INSTALLATION POINT

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

FRONT CROSSMEMBER (ASSY)



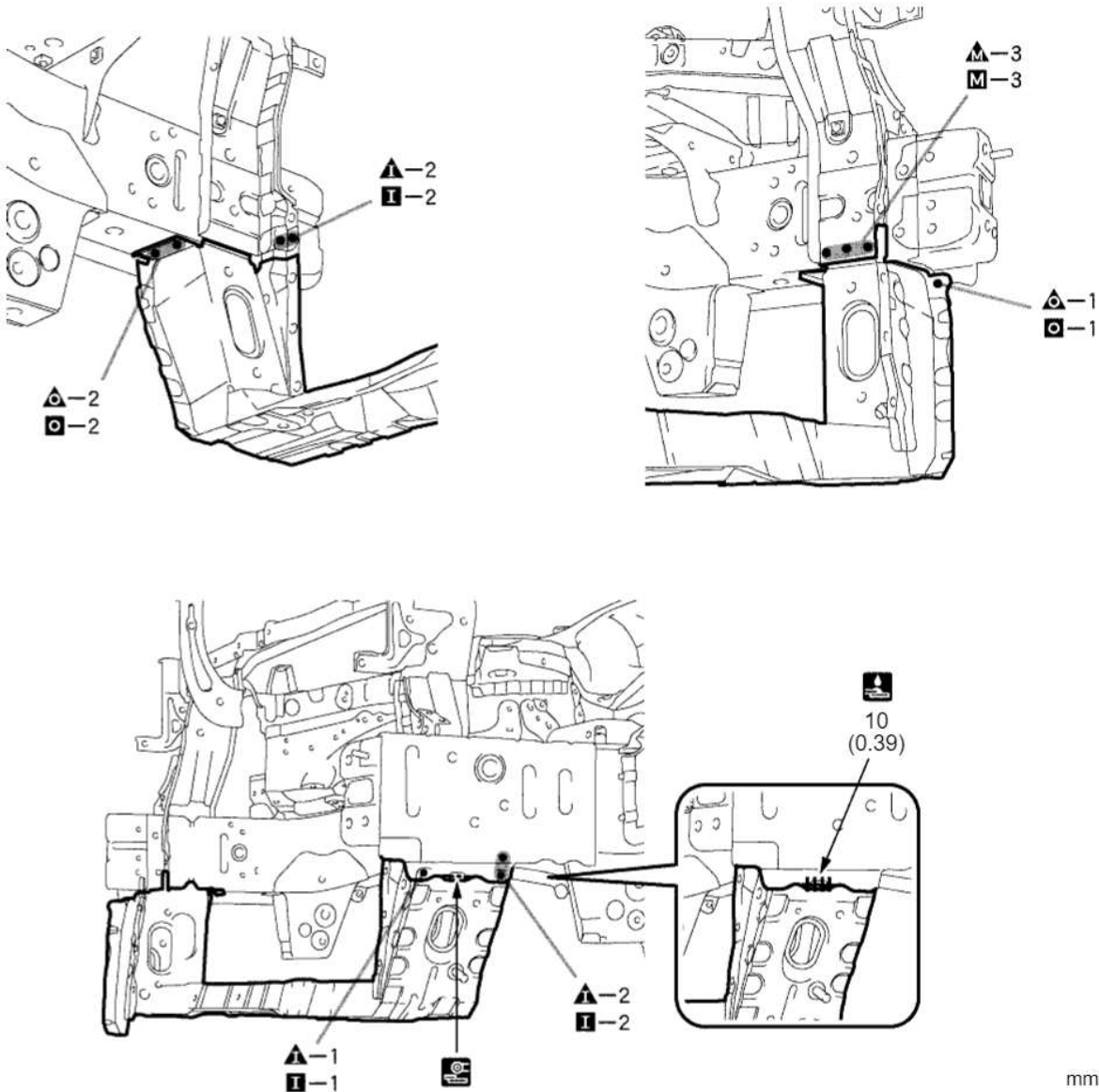
F25705A

Symbol meaning

REMOVAL	▲ ▲ ▲ : Remove Weld Points	☞ : Cut with disc sander, etc.
INSTALLATION	Ⓞ M I : MIG Plug Weld	⚡ : Tack Weld

F25705B

REMOVAL-INSTALLATION

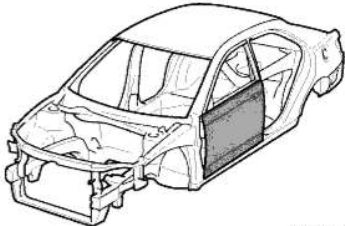
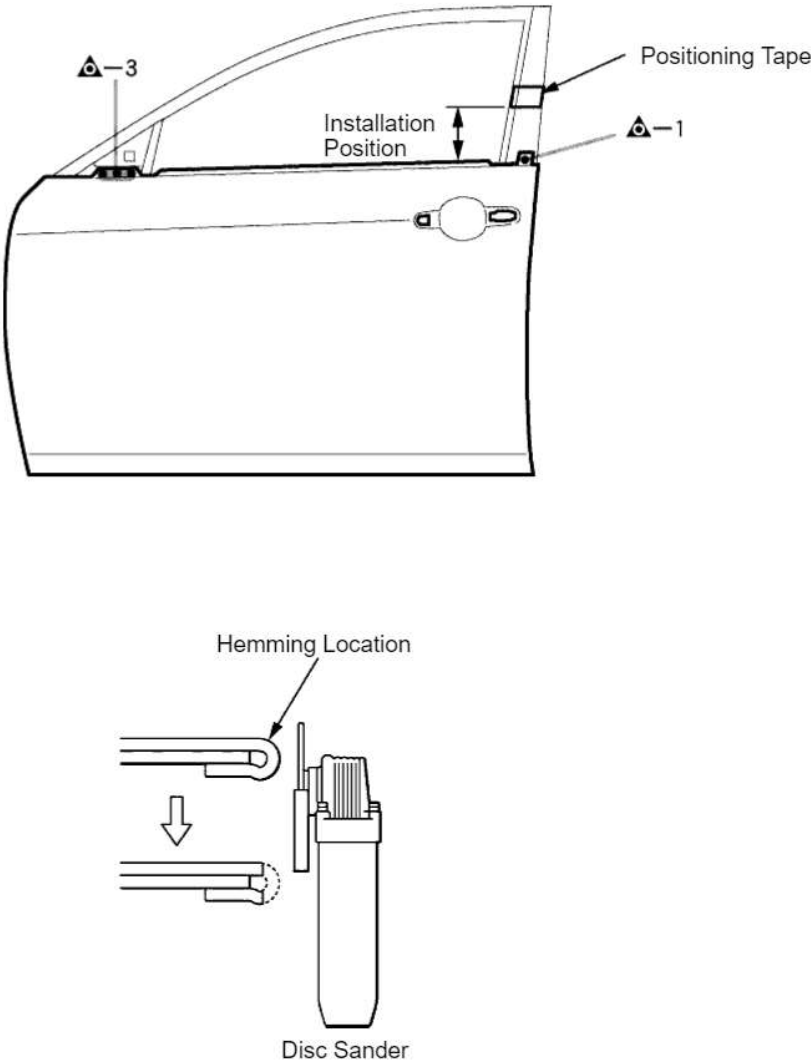


F25705

INSTALLATION POINT

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

FRONT DOOR OUTER PANEL (ASSY)

 F25757A	Symbol meaning ⚠ : Remove Weld Points F25757B
REMOVAL	
 Positioning Tape Installation Position ⚠-1 ⚠-3 Hemming Location Disc Sander F25757	
REMOVAL POINT - Before removing the outer panel, mark the installation position with tape. - Before removing the outer panel, establish its exact position in relation to the window frame using a reference marker, etc. - After grinding off the hemming location, remove the outer panel.	

BODY PANEL REPLACEMENT

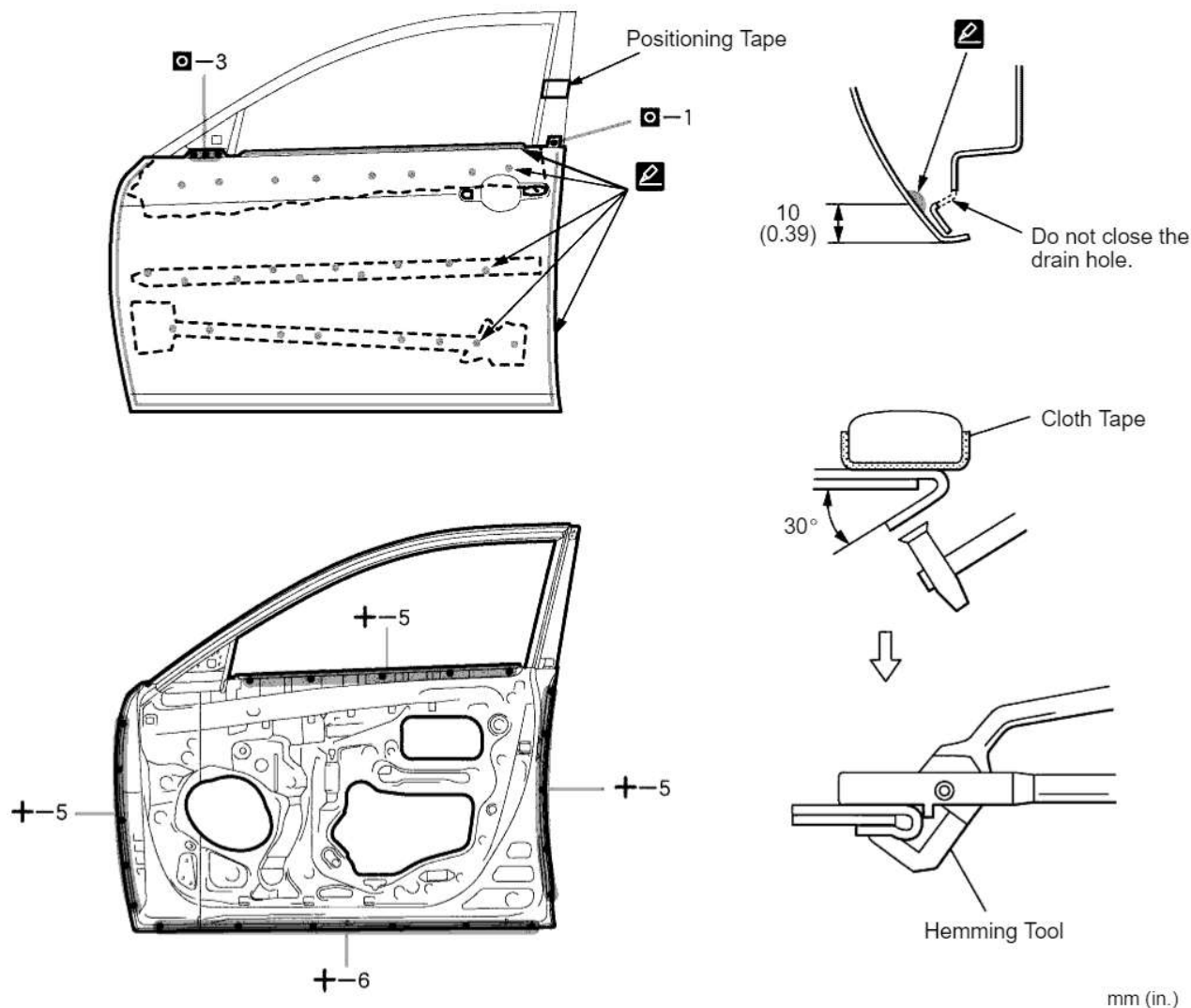
BP-29

Symbol meaning

◻ : MIG Plug Weld + : Spot MIG Weld ◻ : Body Sealer

F25758B

INSTALLATION



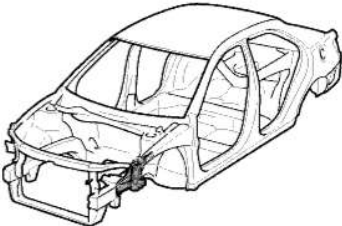
mm (in.)

F25758

INSTALLATION POINT

- Before temporarily installing the new parts, apply body sealer to the reinforcement, side impact protection beam and backside of the new parts.
HINT:
 - Apply sealer evenly about 10 mm (0.39 in.) from the flange and 3 mm (0.12 in.) in diameter on the outer panel and apply just enough sealer for the reinforcement and side impact protection beam to make contact.
- 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.
- After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

FRONT FENDER FRONT APRON (ASSY)



F25707A

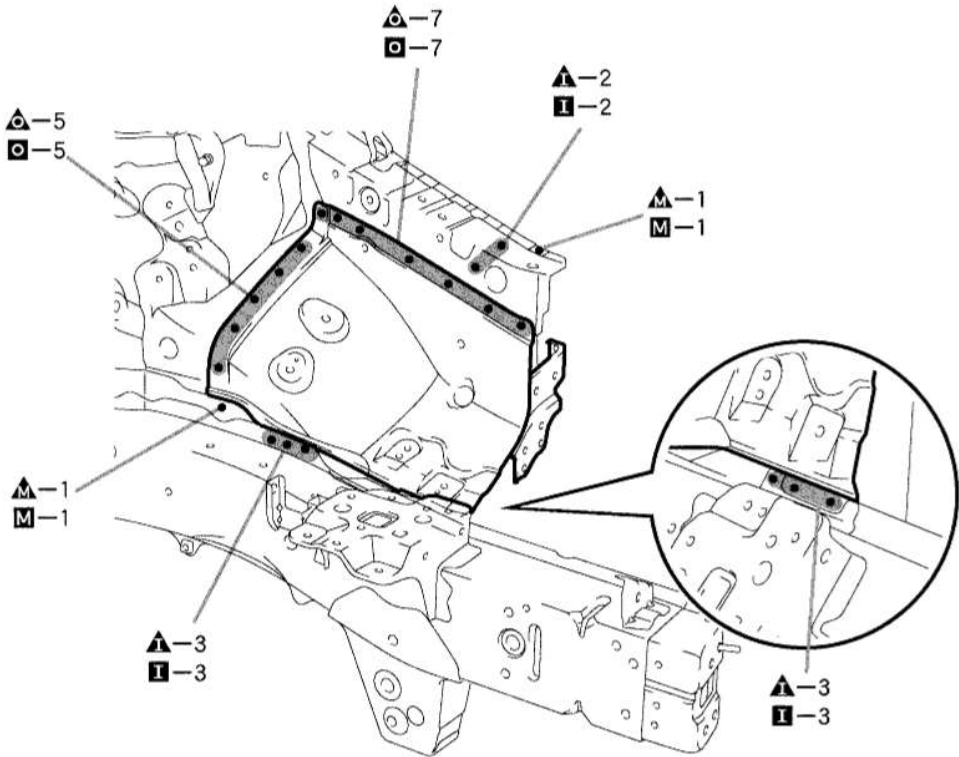
With the radiator support removed.

Symbol meaning

REMOVAL	: Remove Weld Points	: Cut with disc sander, etc.
INSTALLATION	: MIG Plug Weld	: Tack Weld

F25707B

REMOVAL-INSTALLATION



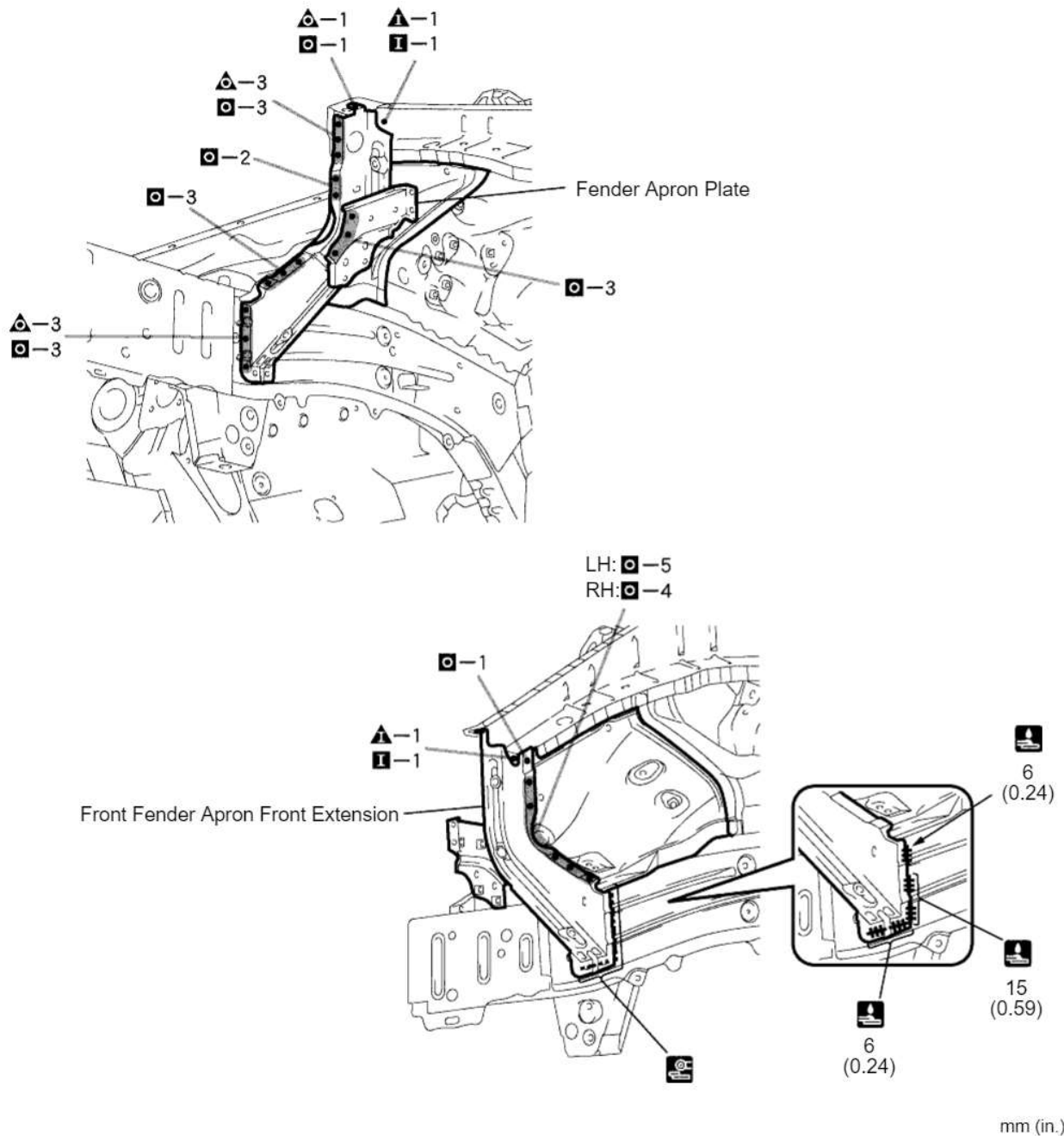
F25707

INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)

BODY PANEL REPLACEMENT

BP-7



F25708

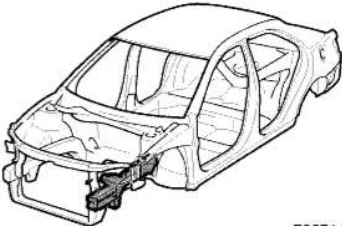
REMOVAL POINT

- 1 Remove the front fender apron front extension at the same time.

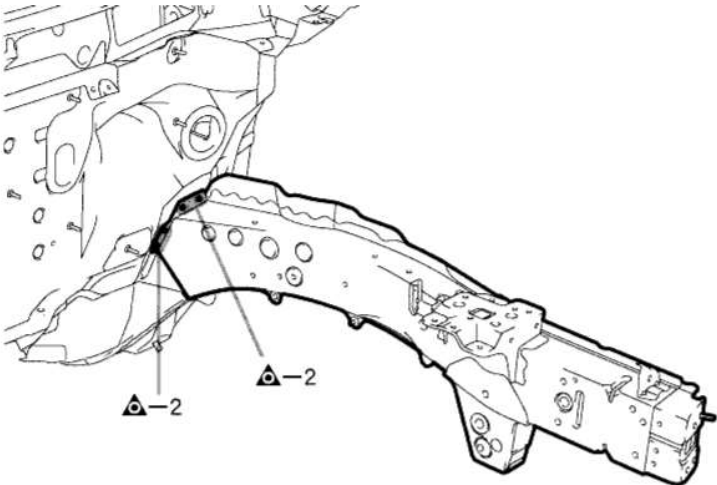
INSTALLATION POINT

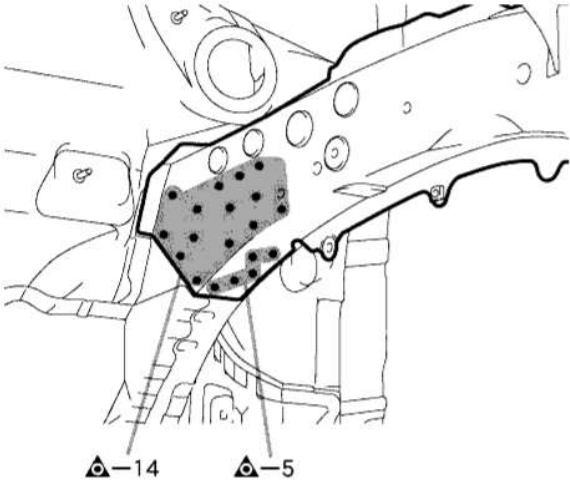
- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 After welding,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

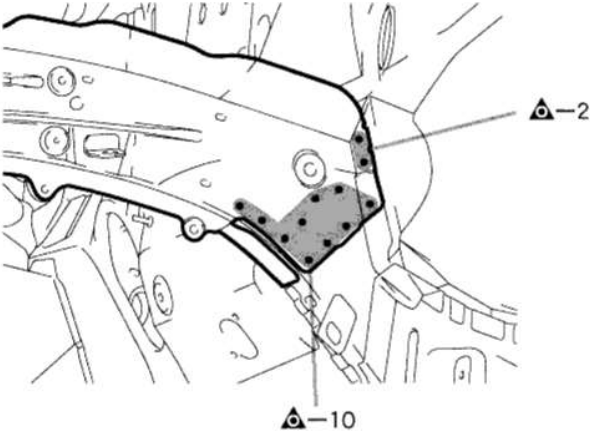
FRONT SIDE MEMBER (CUT-H)

 F25714A	With the front fender apron removed. Symbol meaning ▲ : Remove Weld Points F25714B
--	--

REMOVAL







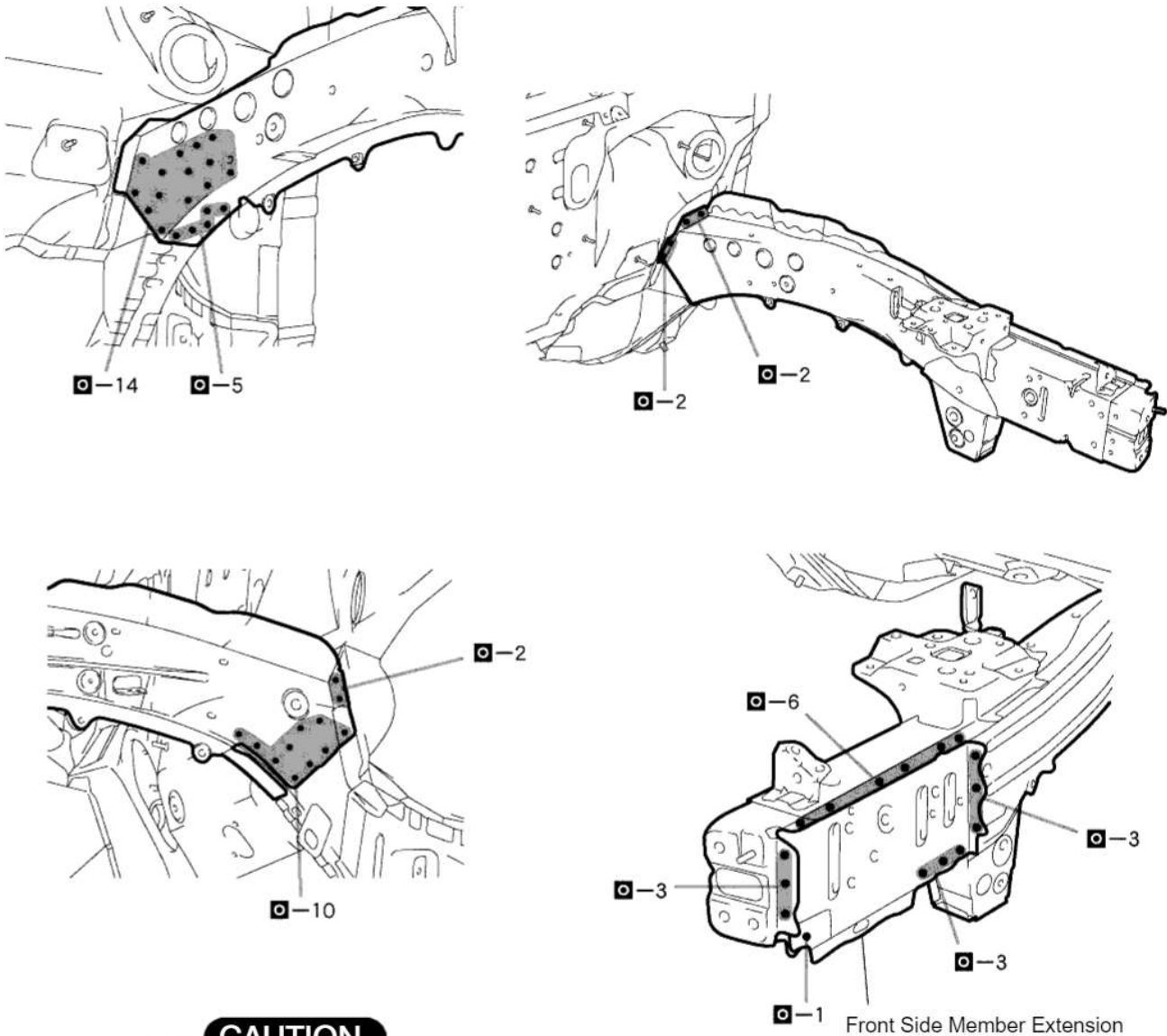
F25714

Symbol meaning

◻ : MIG Plug Weld

F25715B

INSTALLATION



CAUTION

Make sure to attach correctly in accordance with the body dimention diagram as this parts affects the front wheel alignment.

F25715

INSTALLATION POINT

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

BODY PANEL REPLACEMENT

BP-73

NAME PLATE APPLICATION PROCEDURE

- (a) Heat the double-sided tape remaining on the body with an infrared lamp or equivalent.

HINT:

Heat the tape to 40 to 60° C for approximately 1 to 2 minutes.

- (b) Wipe off the remaining double-sided tape using a clean cloth or equivalent.

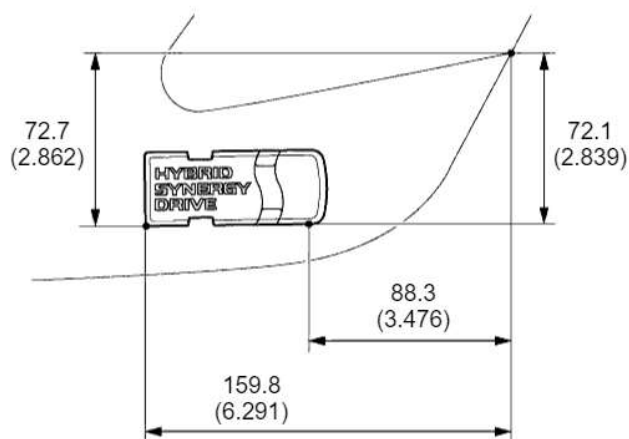
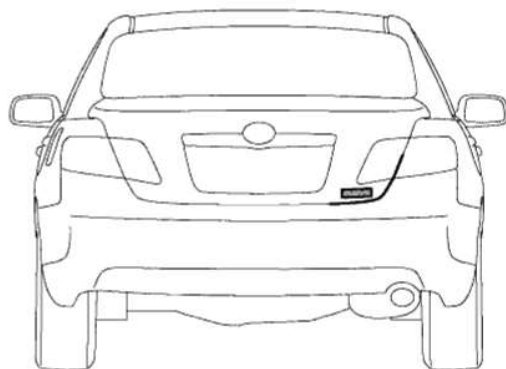
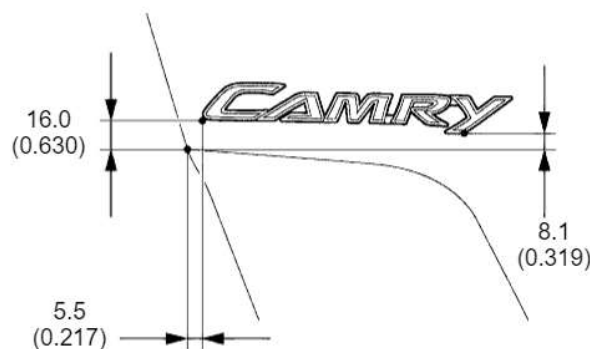
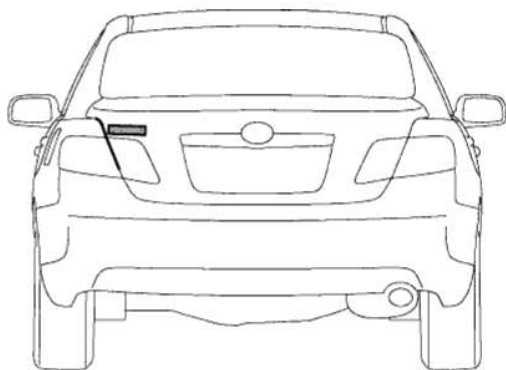
HINT:

If a name plate is installed without thoroughly removing the remaining double-sided tape from the body, the name plate will not adhere properly. Make sure to thoroughly wipe off the double-sided tape.

- (c) After cleaning the installation area of the body with degreasing agent, attach the name plate to the position shown in the illustration.

HINT:

The working environment should be 20° C when installing the name plate. If the working environment is below 20° C, heat the installation area of the body to 20 to 30° C and then install the name plate.

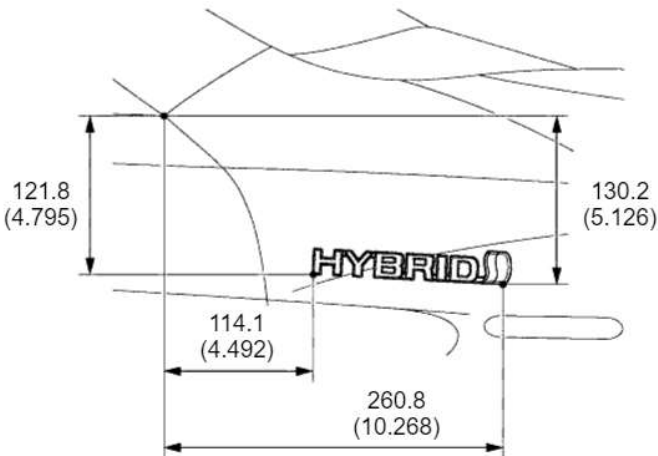
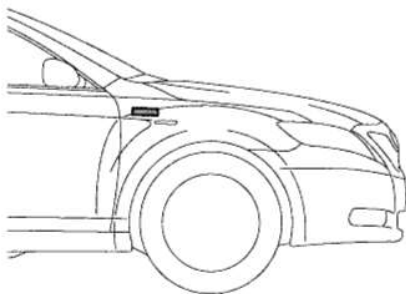
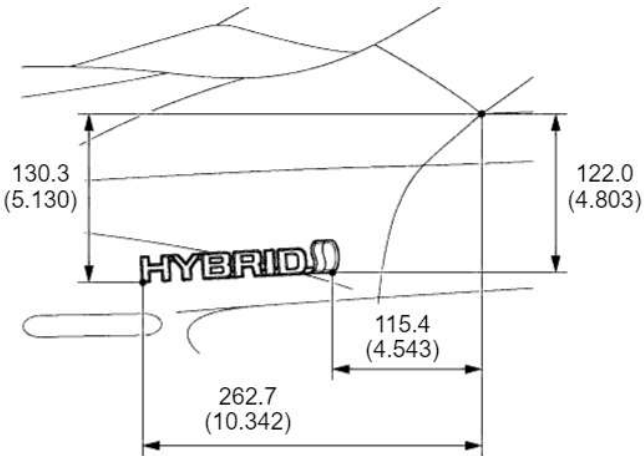
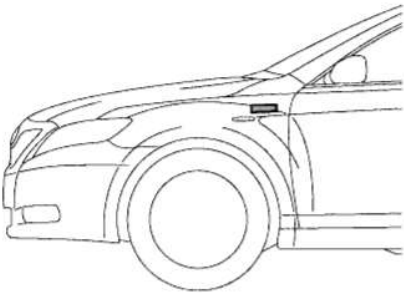


mm (in.)

F26010

BP-74

BODY PANEL REPLACEMENT



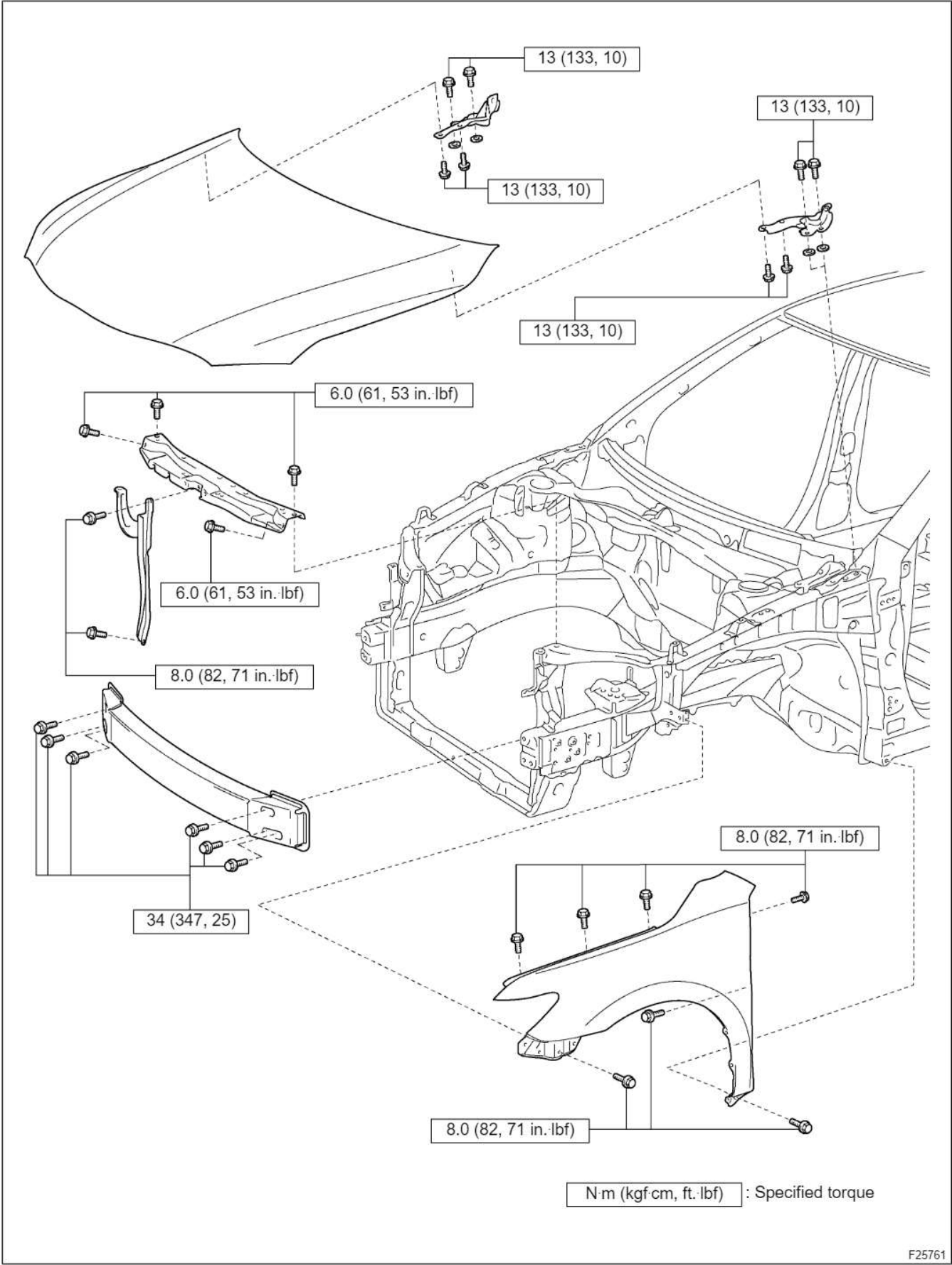
mm (in.)

F25810

BODY PANEL REPLACEMENT

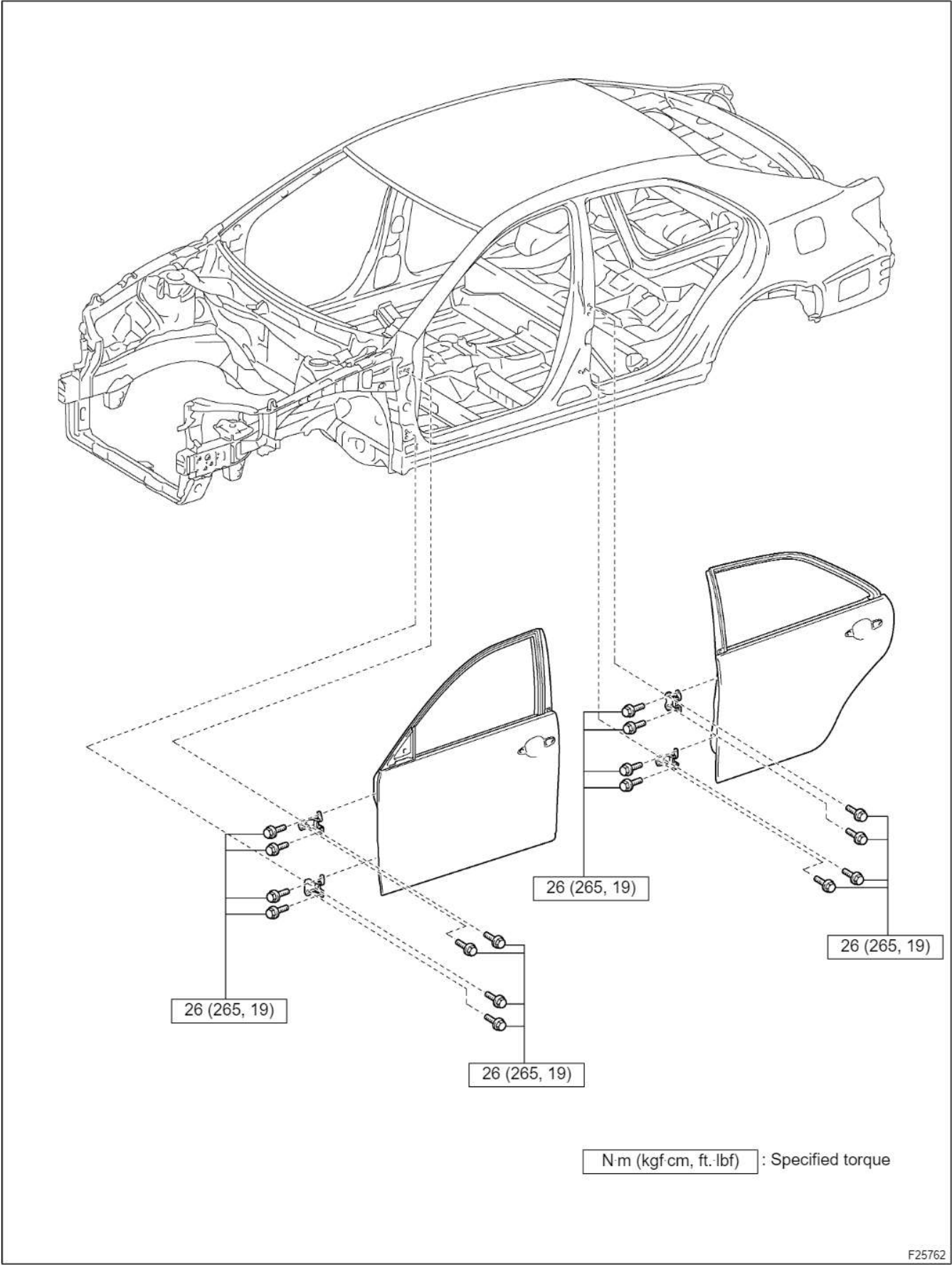
BP-63

OUTER PANEL INSTALLATION TORQUE



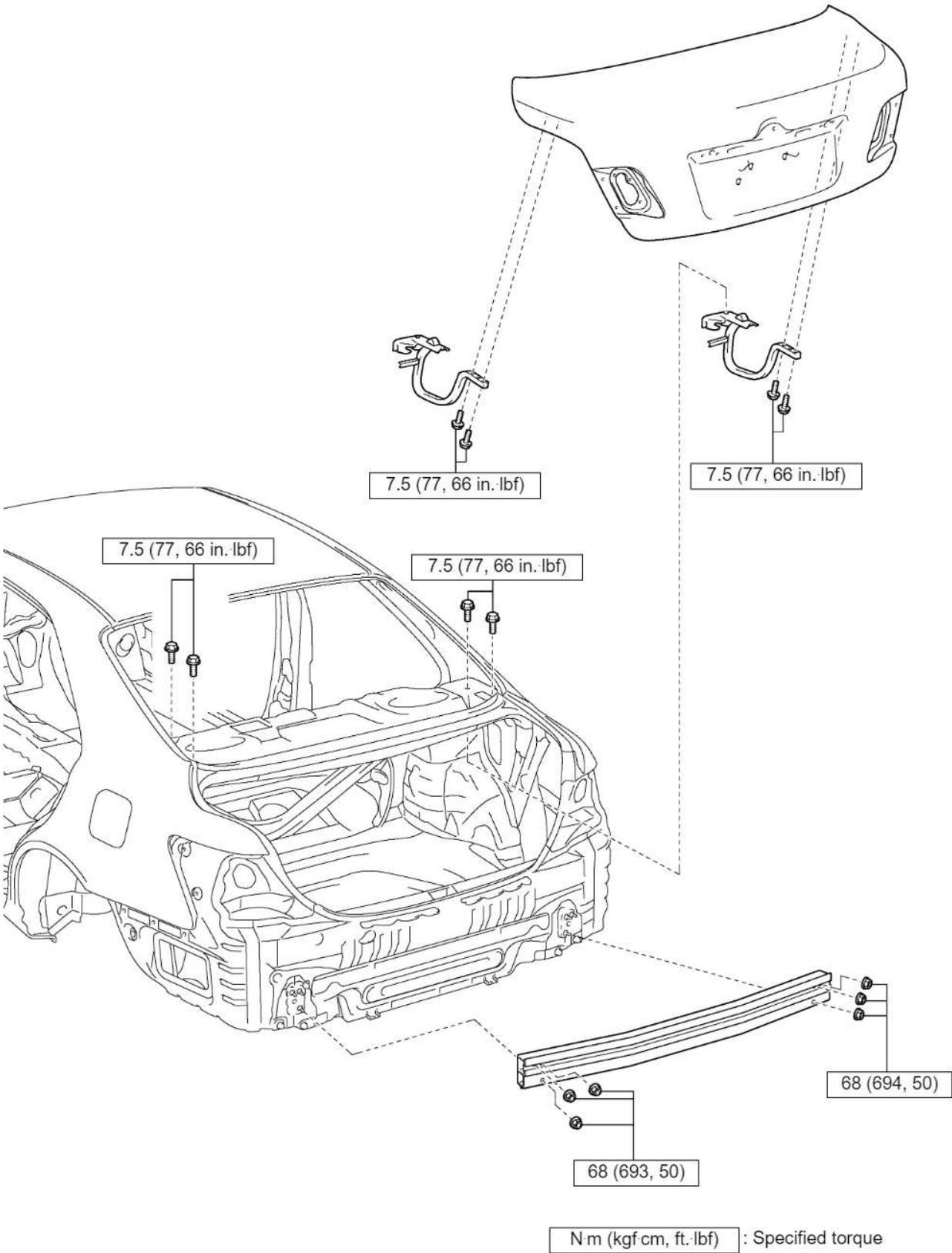
BP-64

BODY PANEL REPLACEMENT



BODY PANEL REPLACEMENT

BP-65

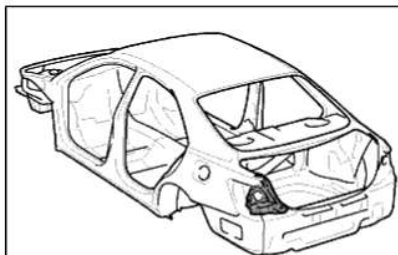


F25763

BP-48

BODY PANEL REPLACEMENT

QUARTER PANEL END HOUSING (ASSY)



F25744A

Symbol meaning

REMOVAL

▲ ▲ : Remove Weld Points

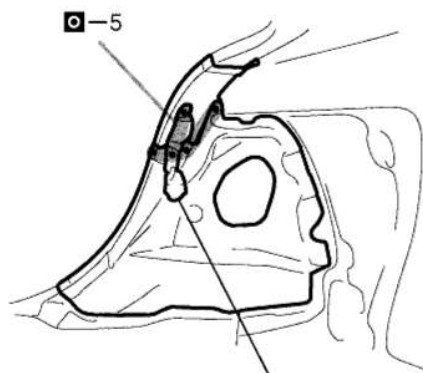
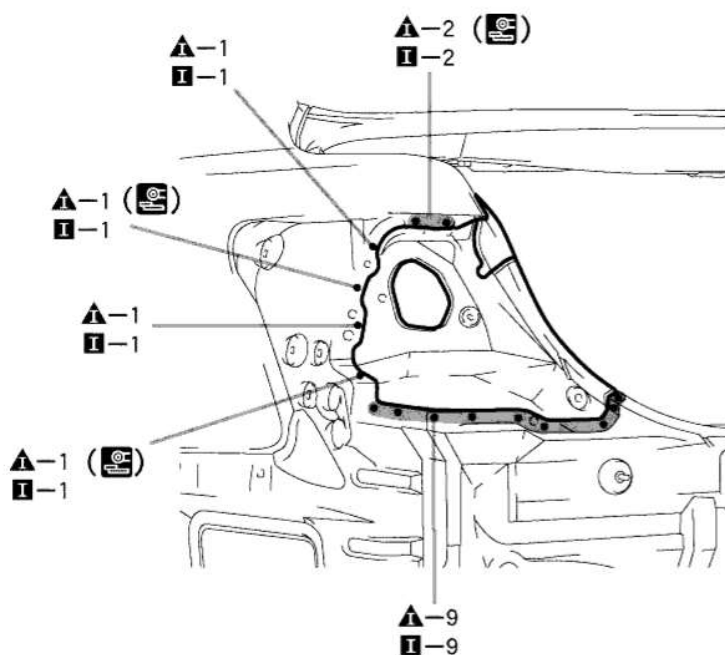
⊙ : Cut with disc sander, etc.

INSTALLATION

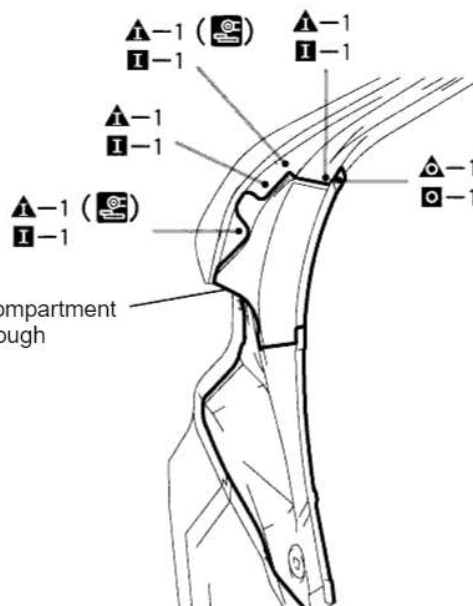
⊙ I : MIG Plug Weld

F25744B

REMOVAL-INSTALLATION



Luggage Compartment Trim No. 1 Bracket

Luggage Compartment
Opening Trough

F25744

REMOVAL POINT

- 1 Remove the luggage compartment opening trough at the same time.

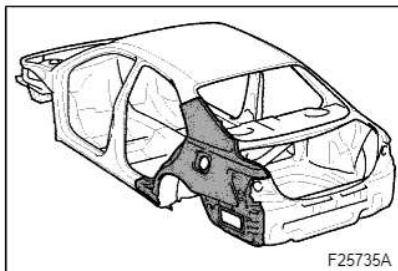
INSTALLATION POINT

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

BP-36

BODY PANEL REPLACEMENT

QUARTER PANEL (CUT)



Quarter Panel Replacement Using Adhesive

Work Procedure	Precaution
1 Cut the wheel arch portion. 2 Heat the quarter panel adhesive area and remove the quarter panel. 3 Clean off any adhesive that remains on the vehicle. 4 Using a disc grinder or belt sander, scuff and sand any adhesive that remains on the vehicle. 5 Apply adhesive to the exposed metal areas on the vehicle. Using a spatula, spread the adhesive evenly. 6 Apply adhesive to the vehicle again. 7 Using #60-240 grit sandpaper, scuff the adhesive application area on the new quarter panel. 8 Apply adhesive to the new quarter panel. Using a spatula, spread the adhesive evenly. 9 Using a vise or the palms of your hands, press the quarter panel so that the thickness of the adhesive is even. 10 Complete installation the new quarter panel. 11 Dry the adhesive areas of the new quarter panel.	(1) Using an industrial dryer or oxygen acetylene burner, heat the quarter panel to 110 to 140°C. Make sure the quarter panel does not warp. (1) Using a gas burner, heat the adhesive to 110 to 140°C. (2) Using a scraper, scrape away the adhesive. (3) If adhesive remains, the strength of any subsequently applied adhesive will be weak. (1) Scuff at a width of approximately 10 mm over the previous adhesive coating. (1) Hardening Time Estimation With dryer or equivalent (60°C) : 60 minutes (complete hardening: 90 minutes) Ambient temperature (25°C) : 12 hours (complete hardening: 24 hours)

BODY PANEL REPLACEMENT

BP-37

Symbol meaning

: Remove Weld Points

: Cut with disc sander, etc.

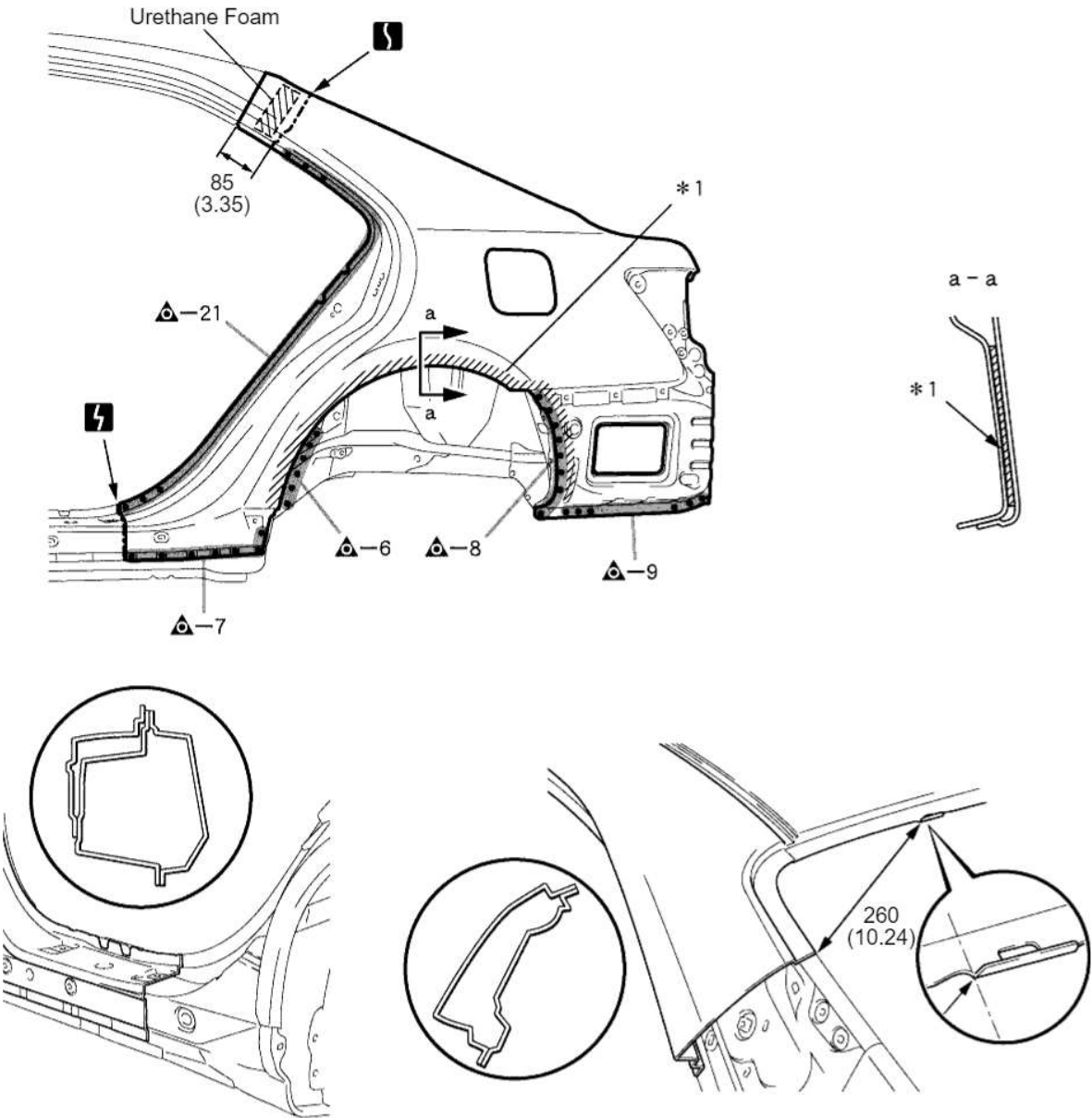
: Cut Location for Supply Parts

: Cut and Join Location

: Braze

F25735B

REMOVAL



mm (in.)

F25735

REMOVAL POINT

- *1 in illustration above indicates where the adhesive is.
- Roughly cut open the wheel arch of the panel so that the adhesive can be reached. Cut through the adhesive with a cut chisel to remove the panel.
HINT:
 - If the cut chisel cannot reach the adhesive, heat the adhesive with a heat gun, oxygen-acetylene burner. When heating, do not deform the quarter housing outer panel.

BP-38

BODY PANEL REPLACEMENT

Symbol meaning

 : Cut with disc sander, etc.

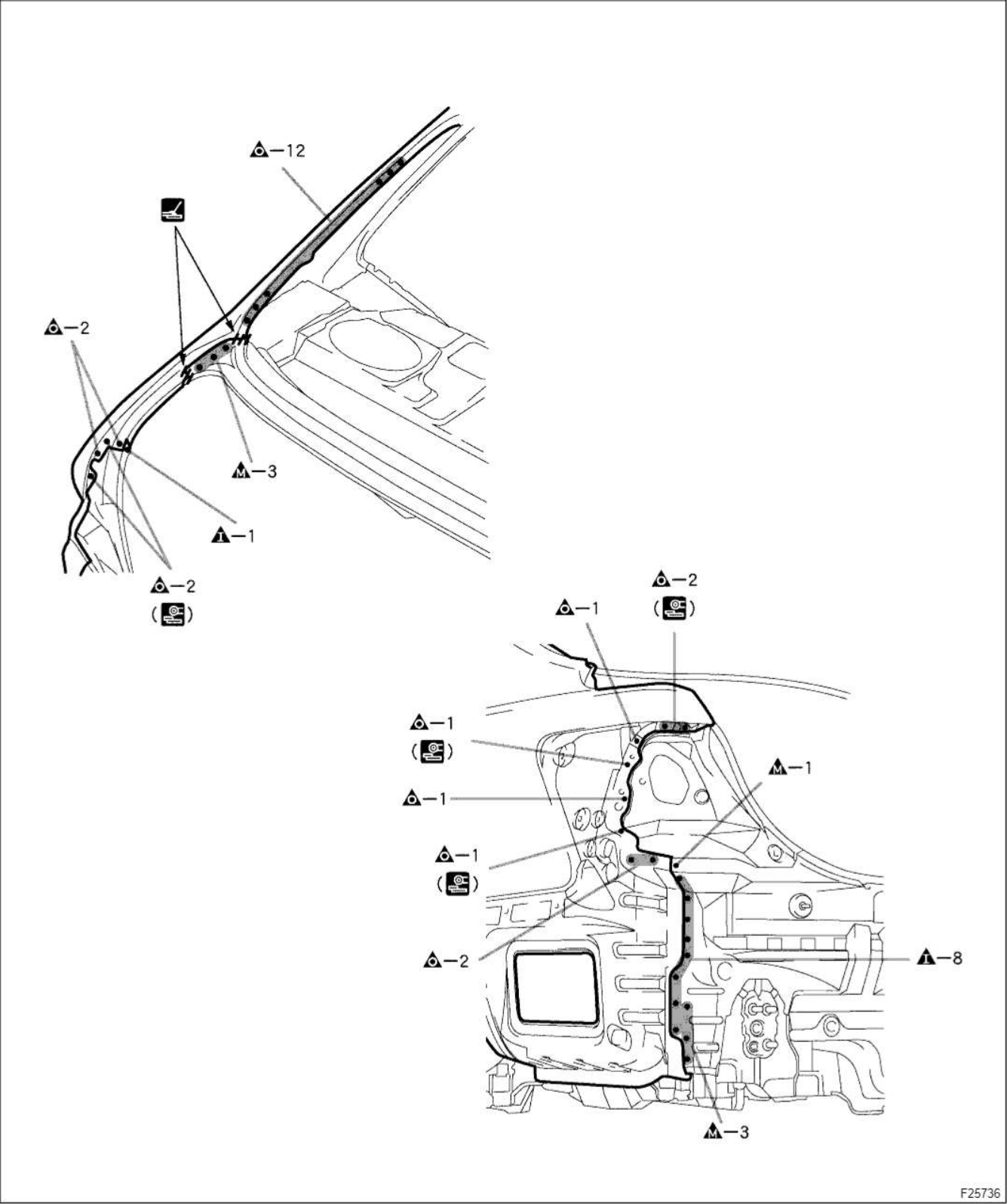
 : Cut Location for Supply Parts

   : Remove Weld Points

 : Cut and Join Location

 : Braze

F25735B



The diagram illustrates the removal of a car body panel. It shows a side profile of the rear section of a vehicle. Key features include:

- Weld points to be removed, indicated by triangles with numbers: 1, 2, 3, 8, 12.
- Cut locations for supply parts, indicated by lightning bolt symbols.
- Cut and join locations, indicated by a symbol showing two lines meeting at a point.
- Braze locations, indicated by a symbol showing a weld bead.

F25736

BODY PANEL REPLACEMENT

BP-39

Symbol meaning

⊙ : Spot Weld

◻ M I : MIG Plug Weld

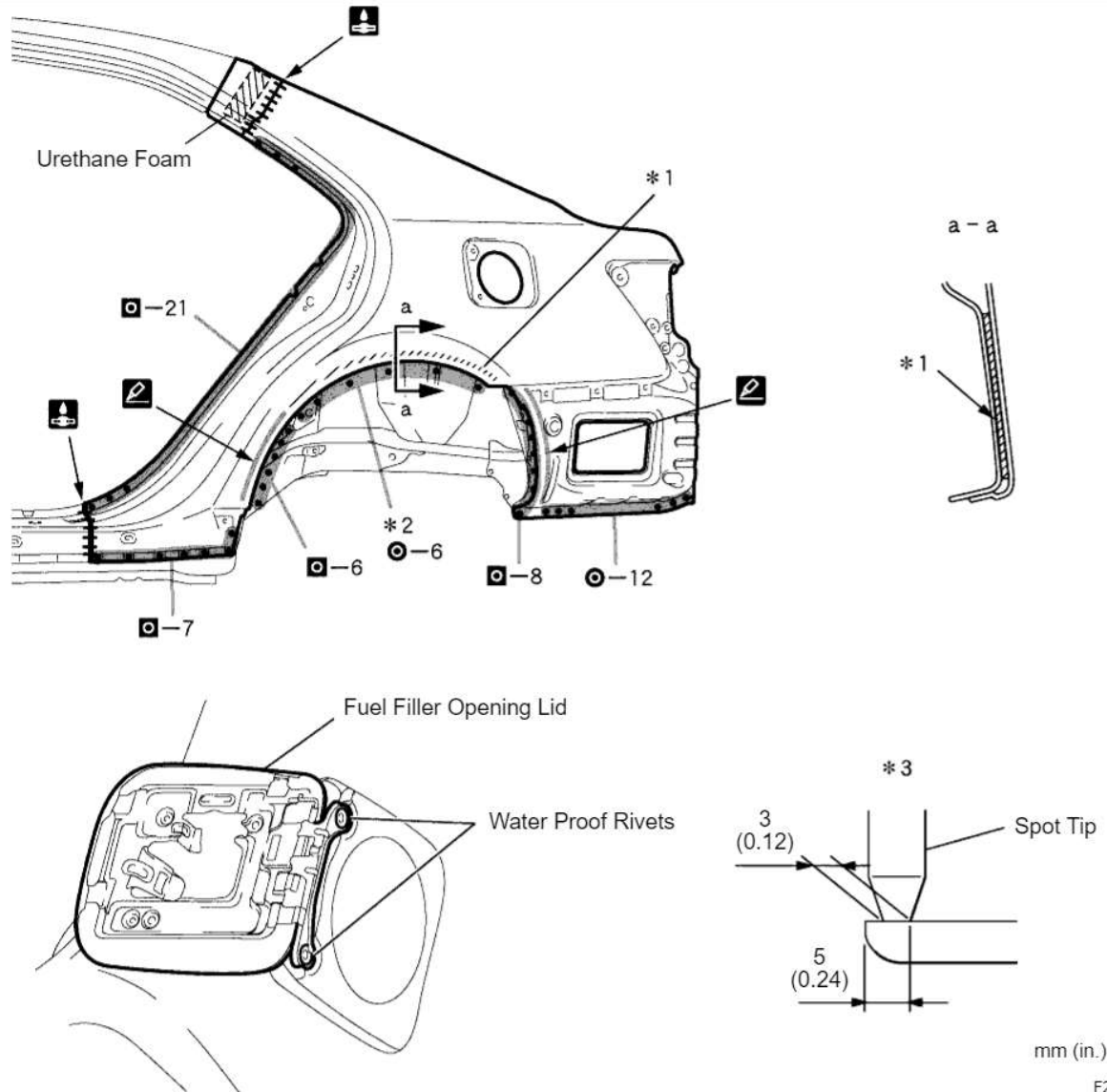
⌞ : Butt Weld

◻ : Body Sealer

⌞ : Braze

F25737B

INSTALLATION



F26012

INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 Apply adhesive(3M™ Automix™ Panel Bonding Adhesive #8115) to the area indicated by *1 in illustration.
HINT:
1) Apply enough adhesive for the panels to stick to each other.
- 4 Perform spot-welding on the flange indicated by *2 in the illustration. Modify/cut the spot tip as shown in the illustration (*3) so that it can fit in to the narrow flange.
- 5 Before installing a new part, apply body sealer.
HINT:
1) Apply sealer in an even, continuous bead.

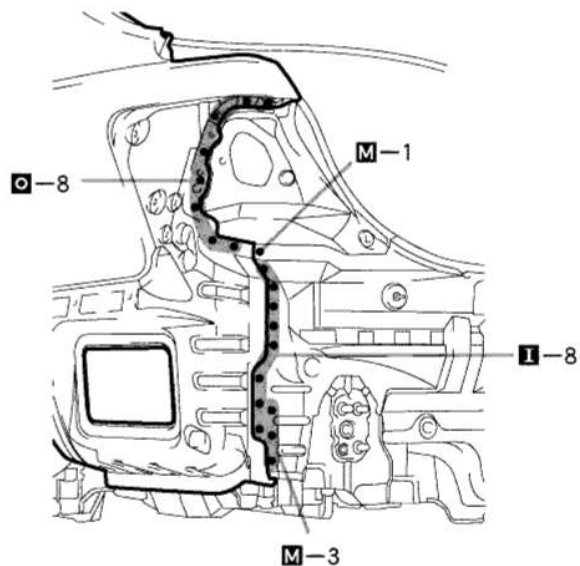
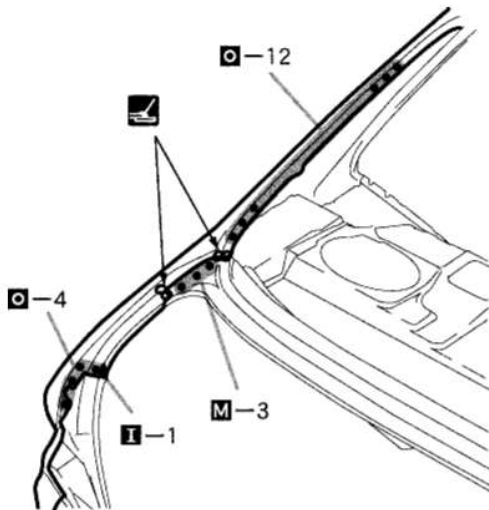
BP-40

BODY PANEL REPLACEMENT

Symbol meaning

 : Spot Weld
  **M** **I** : MIG Plug Weld
  : Butt Weld
  : Body Sealer
  : Braze

F25737B

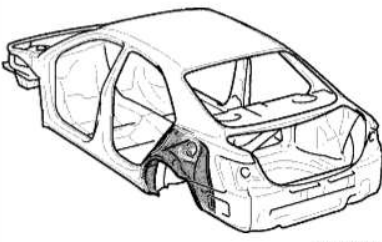


F25738

INSTALLATION POINT

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

QUARTER WHEEL HOUSING OUTER PANEL (ASSY)



F25739A

With the quarter panel removed.

Symbol meaning	
REMOVAL	△ △ △ : Remove Weld Points
INSTALLATION	○ M T : MIG Plug Weld

⊞ : Cut with disc sander, etc.

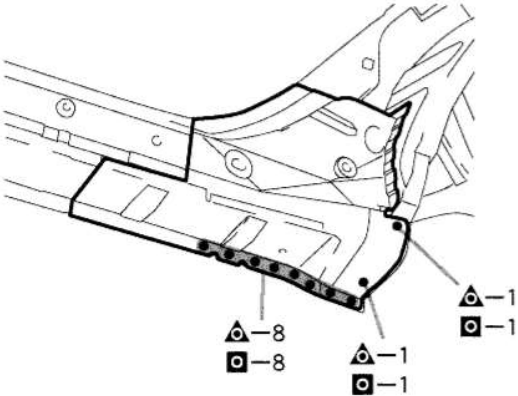
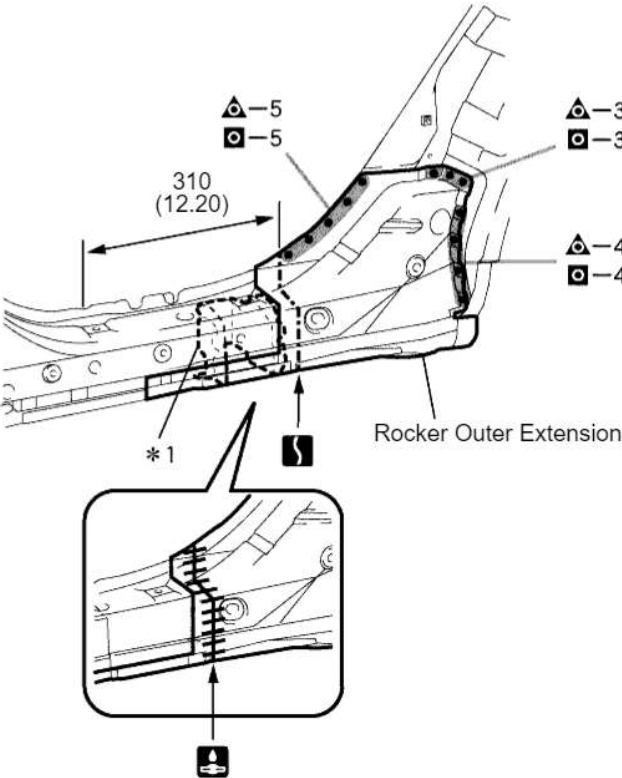
⌋ : Cut and Join Location

⊞ : Tack Weld ⊞ : Butt Weld

F25739B

REMOVAL-INSTALLATION

[LH]



mm (in.)

F25739

REMOVAL POINT

- 1 *1: Take care not to damage the internal reinforcement.
- 2 After removing the rocker outer extension, remove the quarter wheel housing outer panel.

INSTALLATION POINT

- 1 After welding the quarter wheel housing outer panel to the vehicle side, install the rocker outer extension.

BP-42

BODY PANEL REPLACEMENT

Symbol meaning

REMOVAL

▲

▲

▲

Remove Weld Points

INSTALLATION

◻

M

I

MIG Plug Weld

✂

✂

Cut with disc sander, etc.

✂

✂

Cut and Join Location

⚡

⚡

Tack Weld

⚡

⚡

Butt Weld

[LH]

▲-3

◻-3

Roof Side Outer Panel

▲-3

◻-3

▲-4

◻-4

▲-3

◻-3

▲-7

◻-7

▲-1

M-1

▲-1

I-1

▲-4

M-4

▲-2

I-2

▲-3

I-3

▲-12

◻-12

▲-2

M-2

▲-5

◻-5

▲-1

◻-1

▲-1

M-1

▲-1

I-1

REMOVAL POINT

1 After removing the roof side outer panel, remove the quarter wheel housing outer panel.

INSTALLATION POINT

1 After welding the quarter wheel housing outer panel to the vehicle side, install the roof side outer panel.

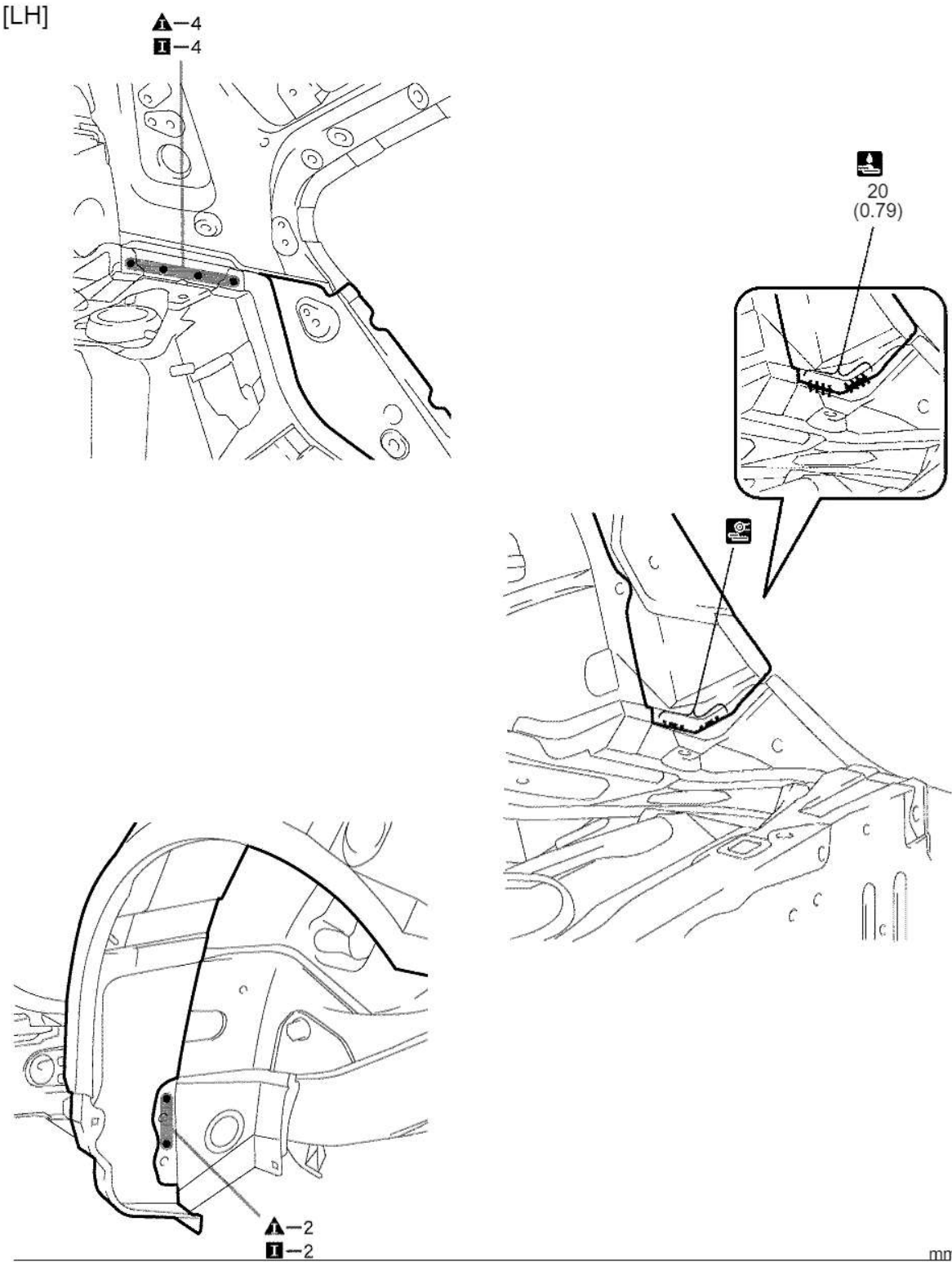
<https://cardiagn.com/body-panel-replacement-07-camry-hybrid/>

48/76

BODY PANEL REPLACEMENT

BP-43

[LH]



INSTALLATION POINT

- 1 After welding, apply body sealer and undercoating to the corresponding parts. (See the paint-coating)
- 2 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

BP-44

BODY PANEL REPLACEMENT

Symbol meaning

REMOVAL

INSTALLATION

: Remove Weld Points

: Cut and Join Location

: MIG Plug Weld

: Cut with disc sander, etc.

: Tack Weld

: Butt Weld

F25739B

[RH]

Rocker Outer Extension

* 1

1

8

* 1

mm (in.)

F25795

REMOVAL POINT

1

2

INSTALLATION POINT

1

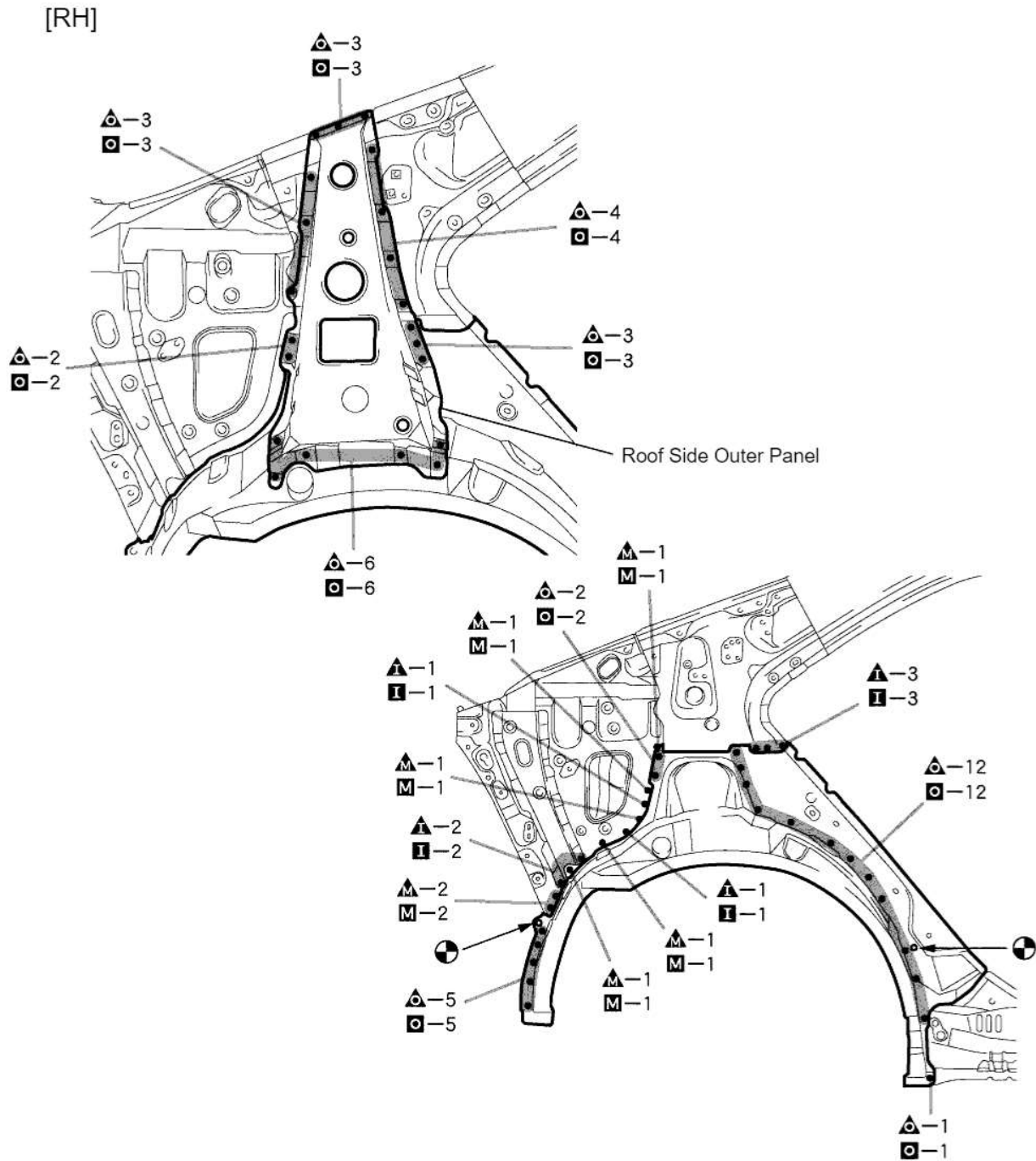
*1: Take care not to damage the internal reinforcement.

After removing the rocker outer extension, remove the quarter wheel housing outer panel.

After welding the quarter wheel housing outer panel to the vehicle side, install the rocker outer extension.

BODY PANEL REPLACEMENT

BP-45



F25741

REMOVAL POINT

- 1 After removing the roof side outer panel, remove the quarter wheel housing outer panel.

INSTALLATION POINT

- 1 After welding the quarter wheel housing outer panel to the vehicle side, install the roof side outer panel.

BP-46

BODY PANEL REPLACEMENT

Symbol meaning

REMOVAL

INSTALLATION

: Remove Weld Points

: MIG Plug Weld

: Cut with disc sander, etc.

: Cut and Join Location

: Tack Weld

: Butt Weld

F25739B

[RH]

mm (in.)

F25796

INSTALLATION POINT

1

After welding, apply body sealer and undercoating to the corresponding parts. (See the paint-coating)

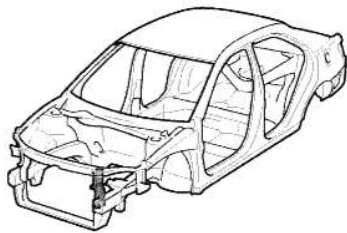
2

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

BP-2

BODY PANEL REPLACEMENT

RADIATOR SUPPORT UPPER BRACE (ASSY)



F25702A

With the radiator upper support removed.

Symbol meaning

REMOVAL

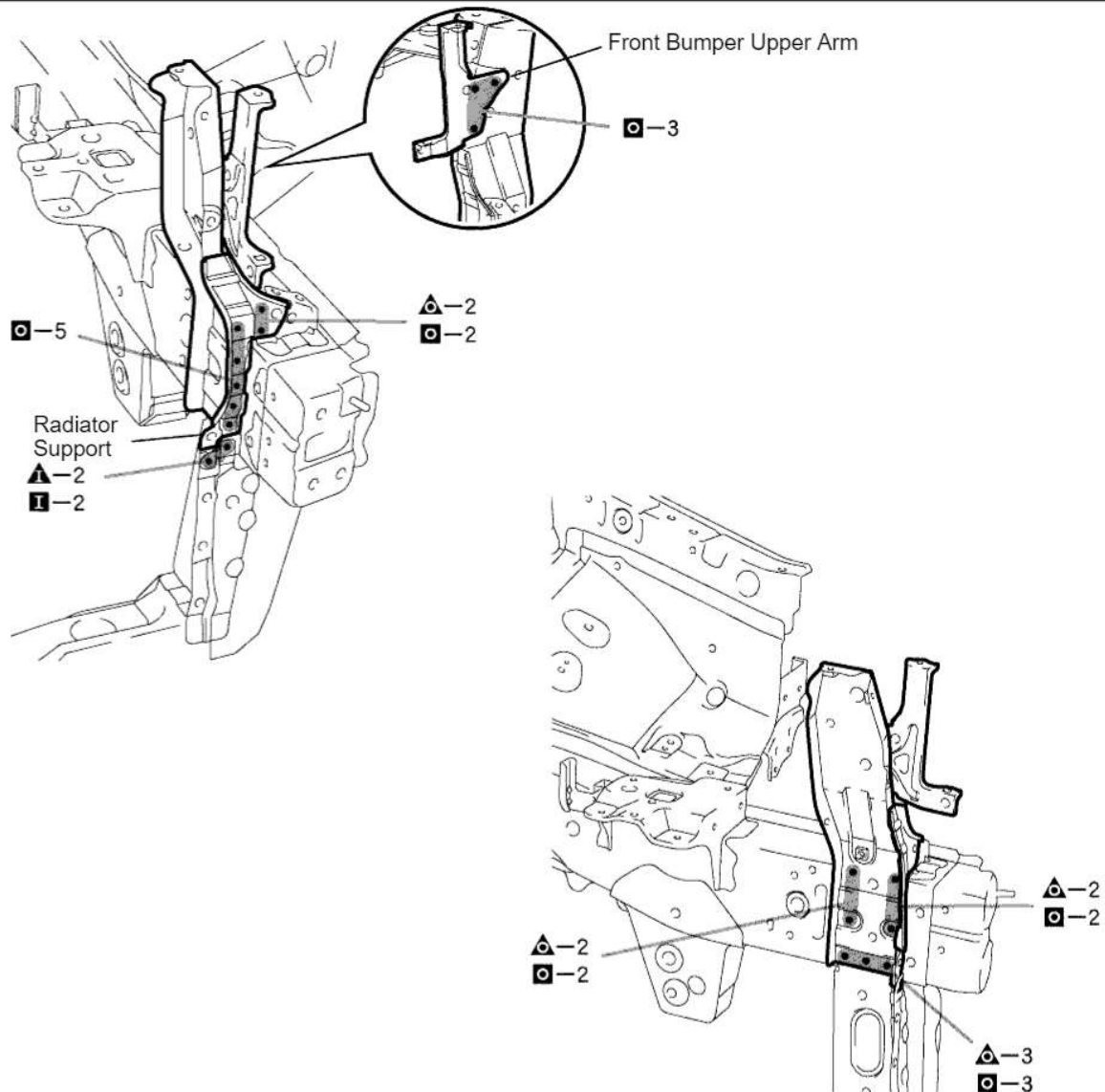
△ △ : Remove Weld Points

INSTALLATION

□ ■ : MIG Plug Weld

F25702B

REMOVAL-INSTALLATION



F25702

REMOVAL POINT

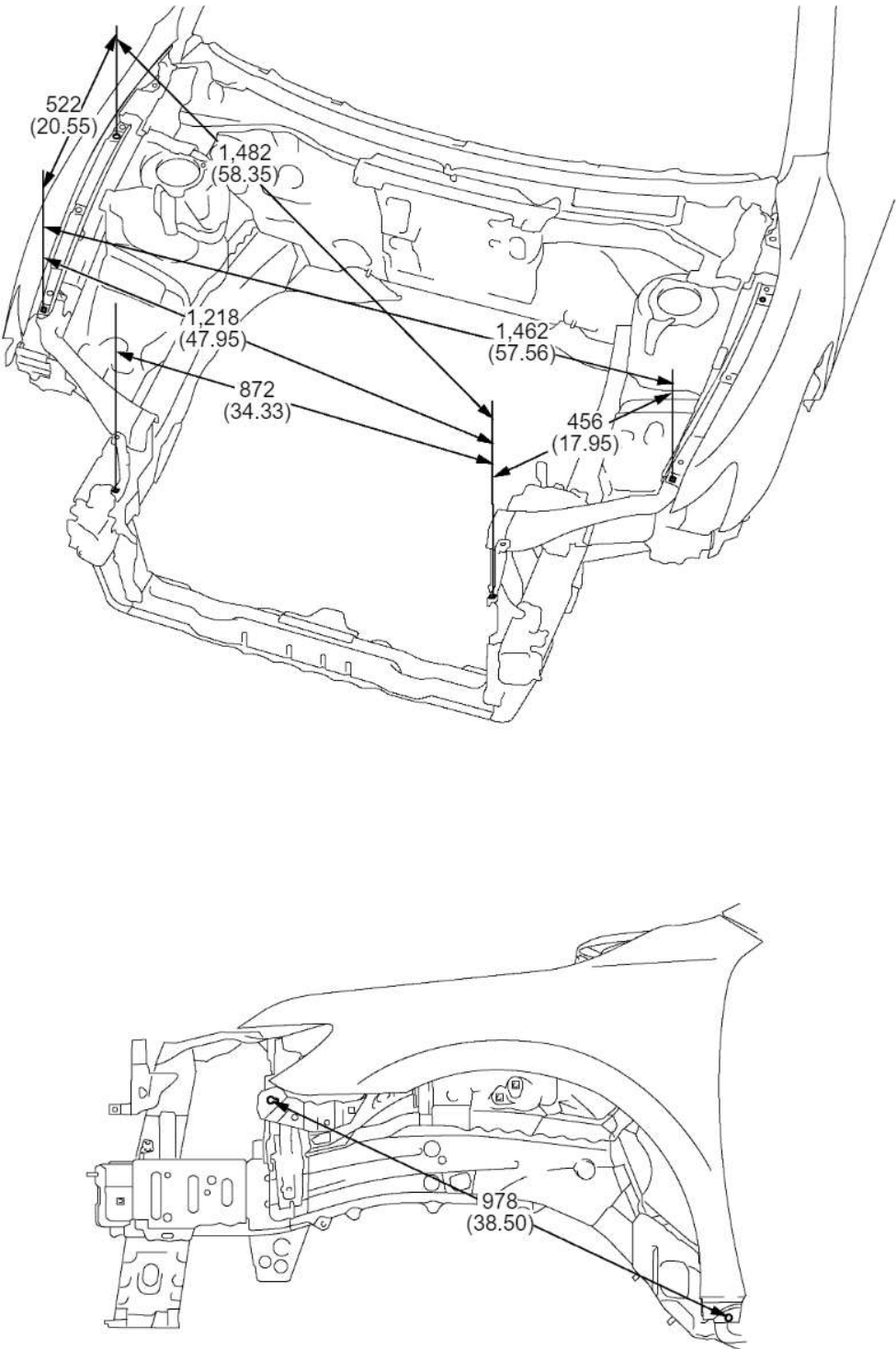
- 1 Remove the radiator support at the same time.

INSTALLATION POINT

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

BODY PANEL REPLACEMENT

BP-3



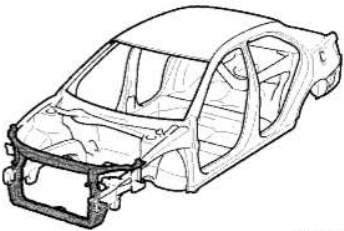
mm (in.)

F25704

INSTALLATION POINT

- 1 Measure the dimensions before installing the headlights.
- 2 These values are reference values.

RADIATOR SUPPORT (ASSY)

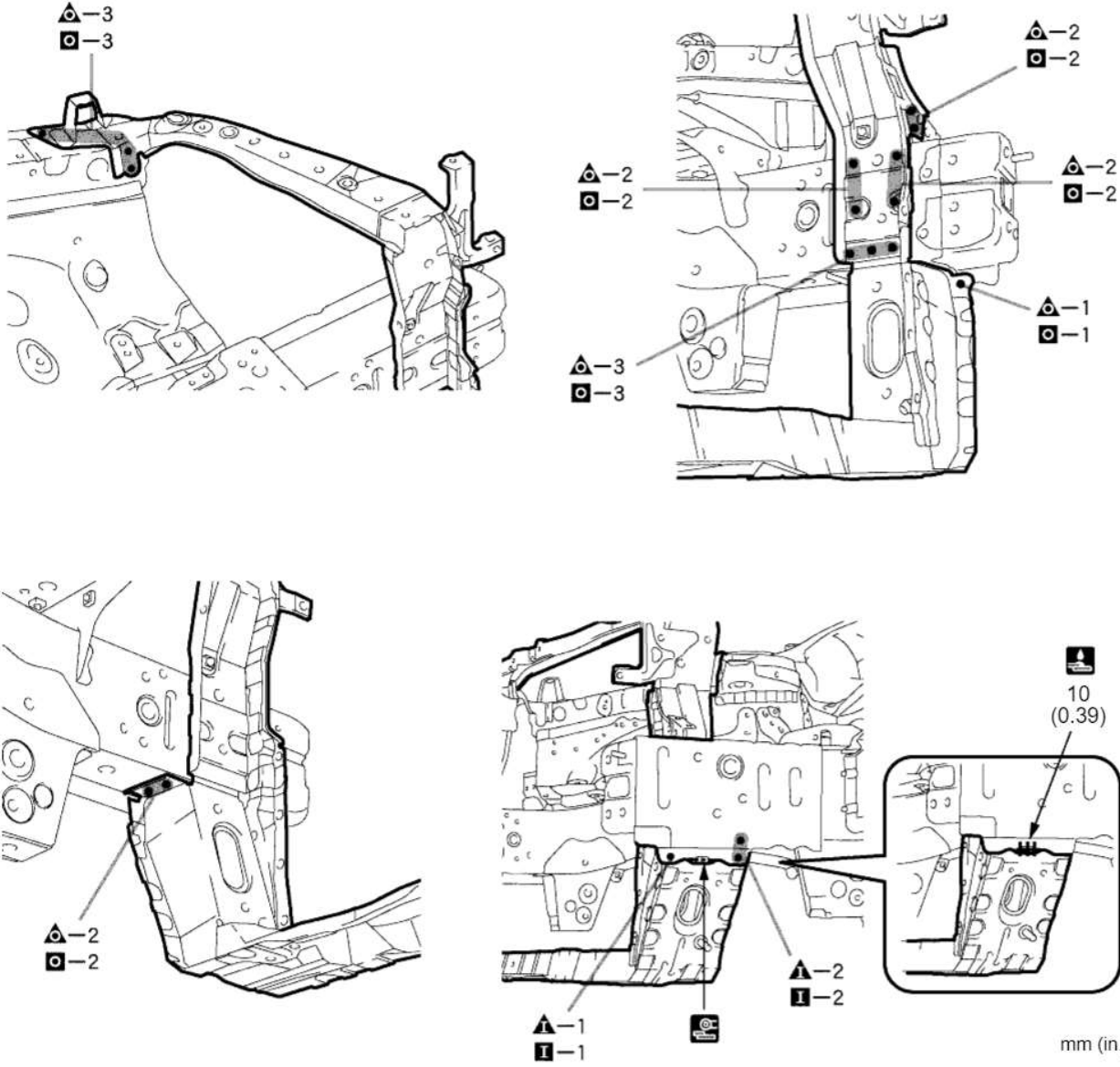


F25706A

Symbol meaning

REMOVAL	: Remove Weld Points	: Cut with disc sander, etc.
INSTALLATION	: MIG Plug Weld	: Tack Weld

REMOVAL-INSTALLATION



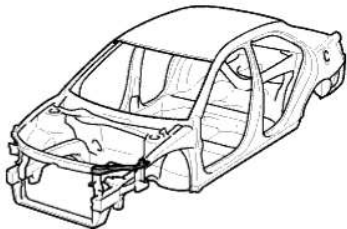
mm (in.)

F25706

INSTALLATION POINT

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

RADIATOR UPPER SUPPORT (ASSY)



F25701A

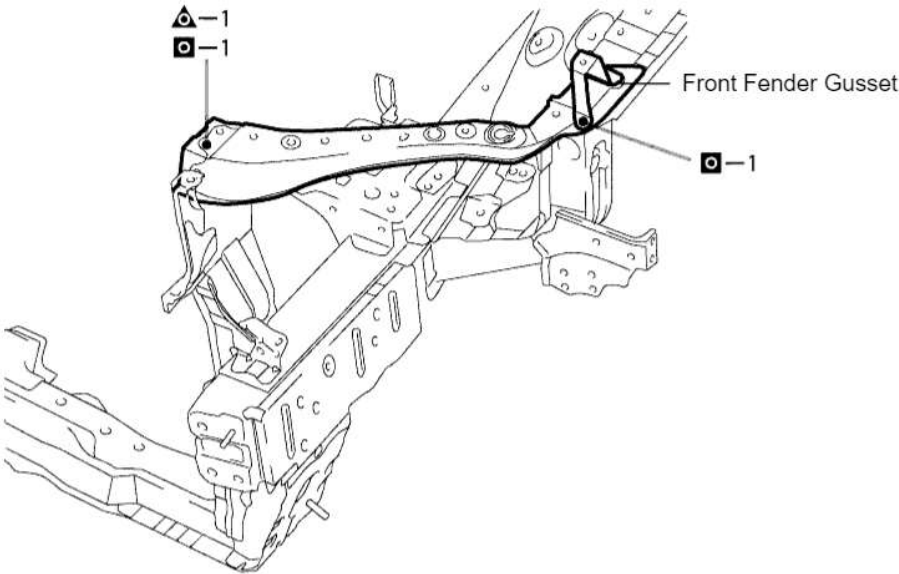
Symbol meaning

REMOVAL ▲ : Remove Weld Points

INSTALLATION ◻ : MIG Plug Weld

F25701B

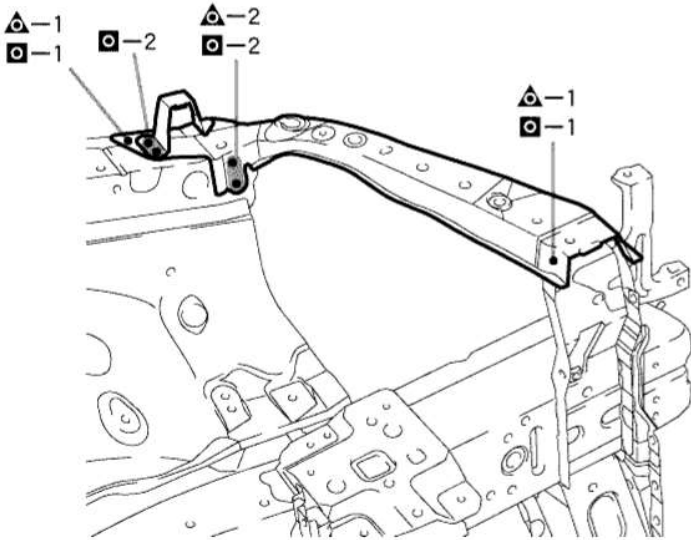
REMOVAL-INSTALLATION



Front Fender Gusset

▲-1

◻-1



▲-1

◻-1

▲-2

◻-2

▲-1

◻-1

F25701

INSTALLATION POINT

1

Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.

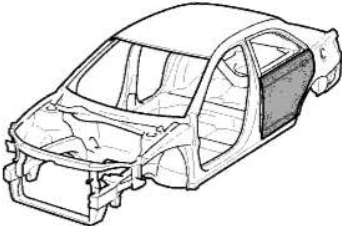
2

Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)

3

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

REAR DOOR OUTER PANEL (ASSY)



F25759A

Symbol meaning

⚠ : Remove Weld Points

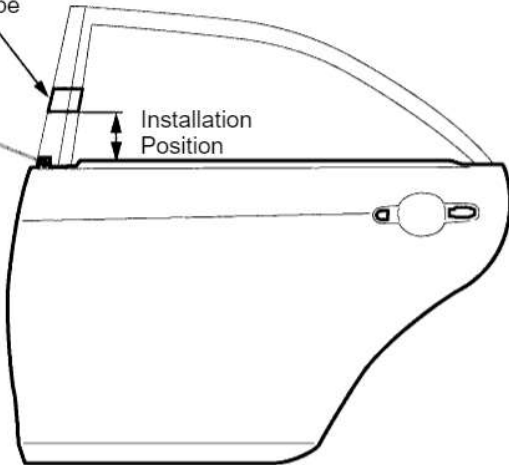
F25759B

REMOVAL

Positioning Tape

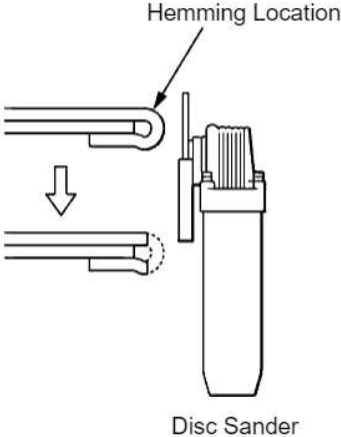
⚠-1

Installation Position



Hemming Location

Disc Sander



F25759

- REMOVAL POINT**
- 1 Before removing the outer panel, mark the installation position with tape.
 - 2 Before removing the outer panel, establish its exact position in relation to the window frame using a reference marker, etc.
 - 3 After grinding off the hemming location, remove the outer panel.

BODY PANEL REPLACEMENT

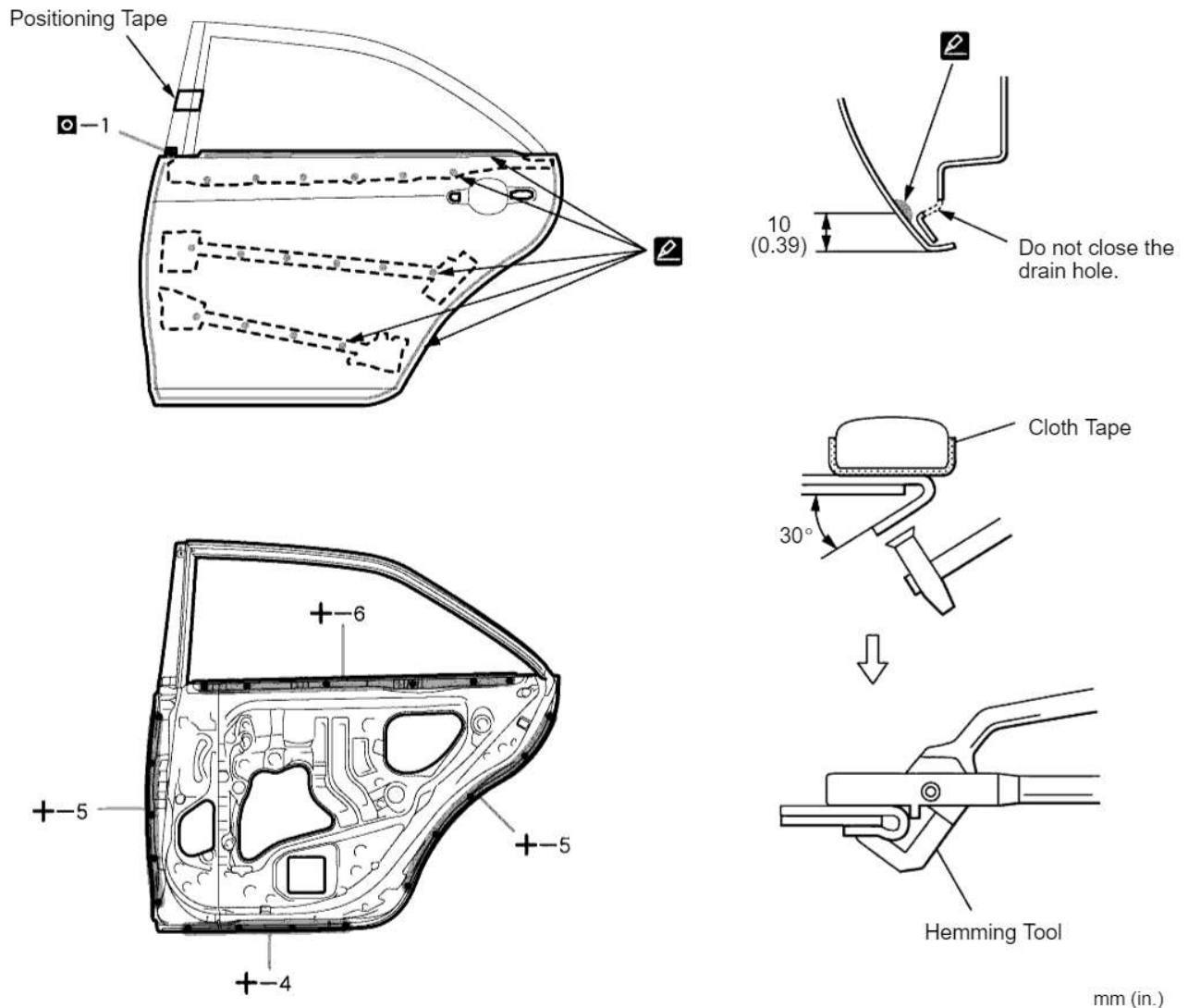
BP-31

Symbol meaning

⊙ : MIG Plug Weld + : Spot MIG Weld  : Body Sealer

F25760B

INSTALLATION



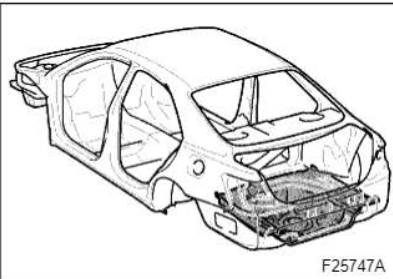
mm (in.)

F25760

INSTALLATION POINT

- 1 Before temporarily installing the new parts, apply body sealer to the reinforcement, side impact protection beam and backside of the new parts.
HINT:
 - 1) Apply sealer evenly about 10 mm (0.39 in.) from the flange and 3 mm (0.12 in.) in diameter on the outer panel and apply just enough sealer for the reinforcement and side impact protection beam to make contact.
- 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.
- 3 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

REAR FLOOR PAN (ASSY)



F25747A

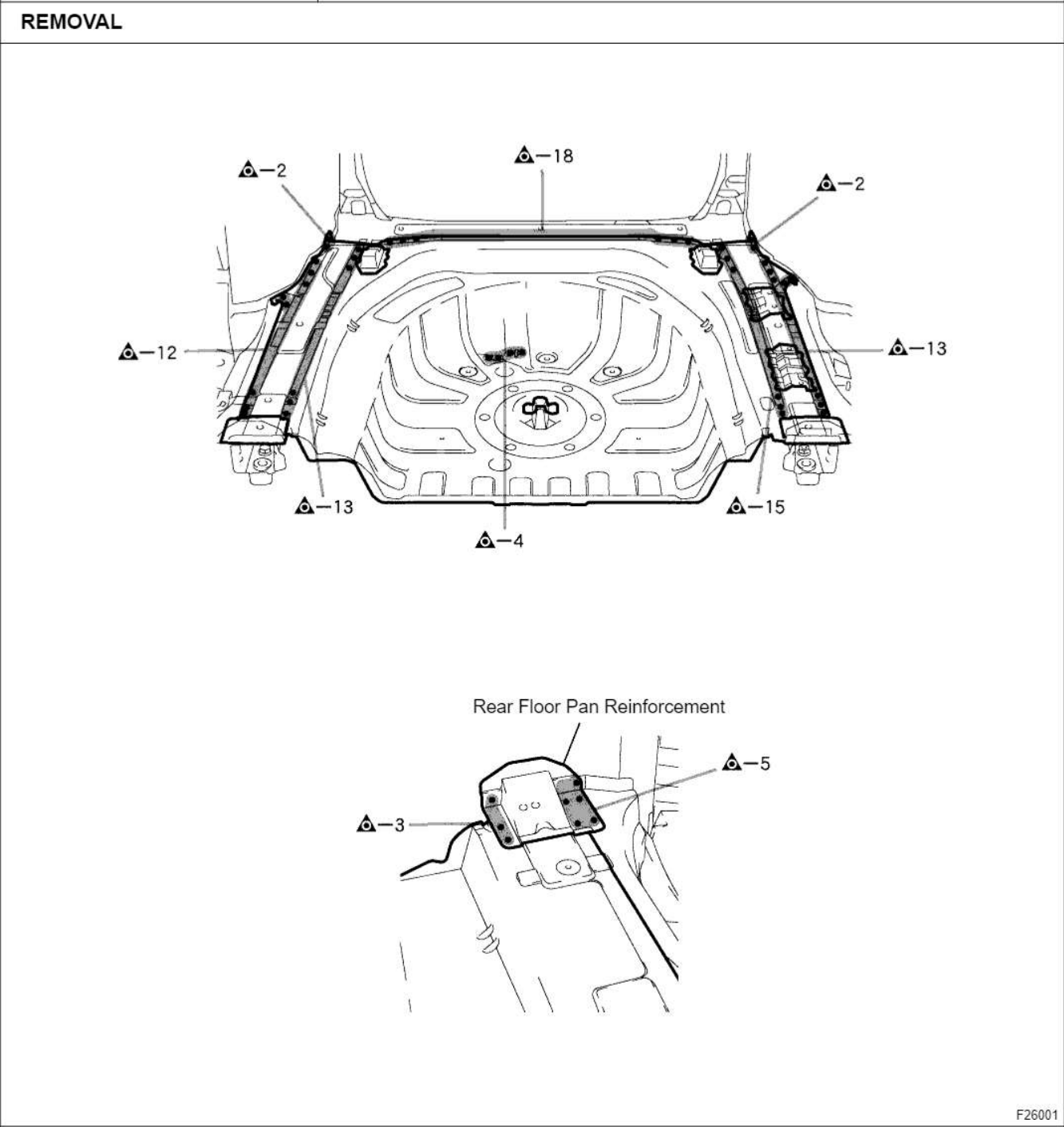
With the rear floor no.3 crossmember removed.

Symbol meaning

▲ ▲ ▲ : Remove Weld Points

F25747B

REMOVAL



Rear Floor Pan Reinforcement

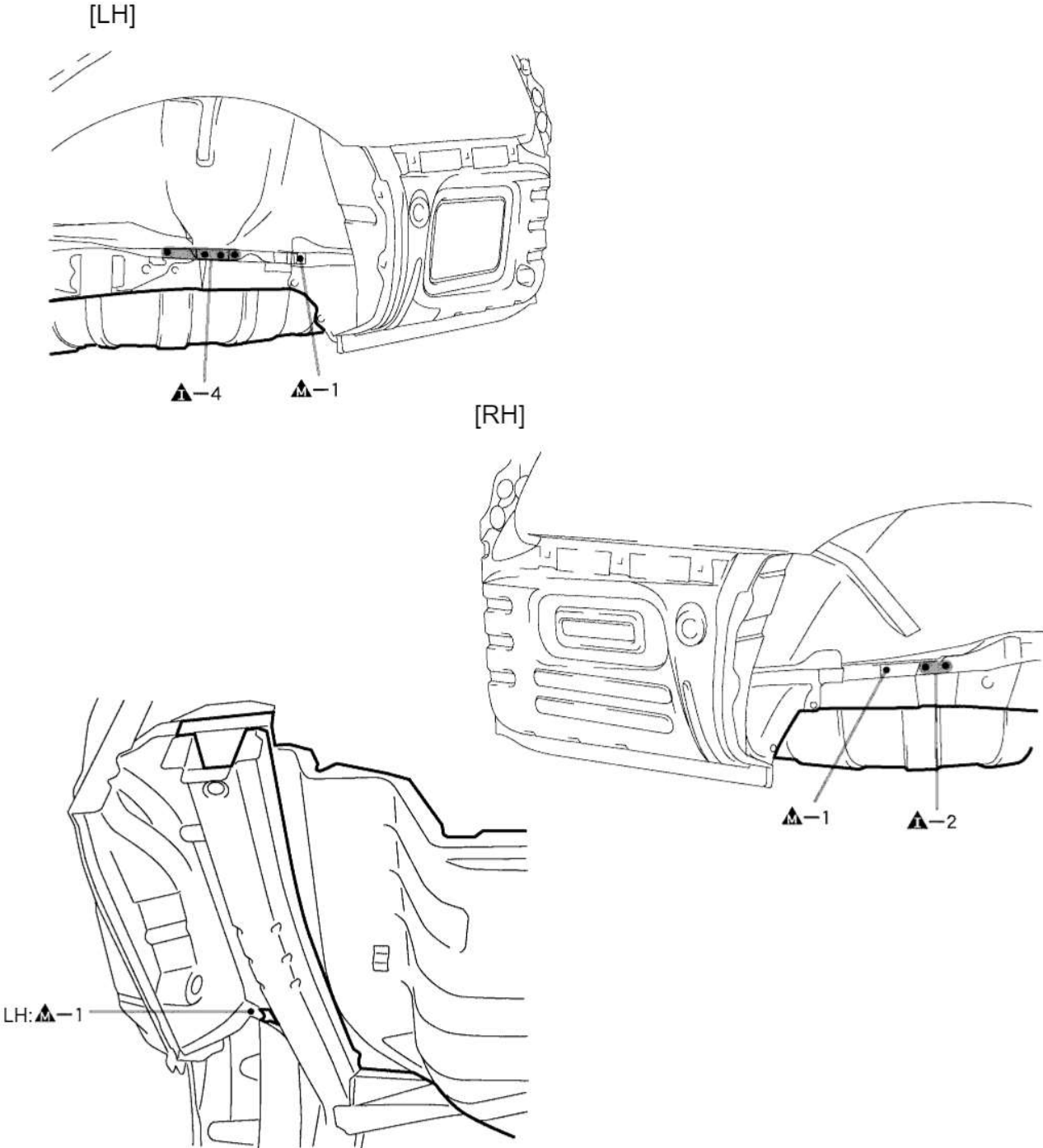
F26001

REMOVAL POINT

1 Remove the rear floor pan reinforcement at the same time.

BODY PANEL REPLACEMENT

BP-51



F26002

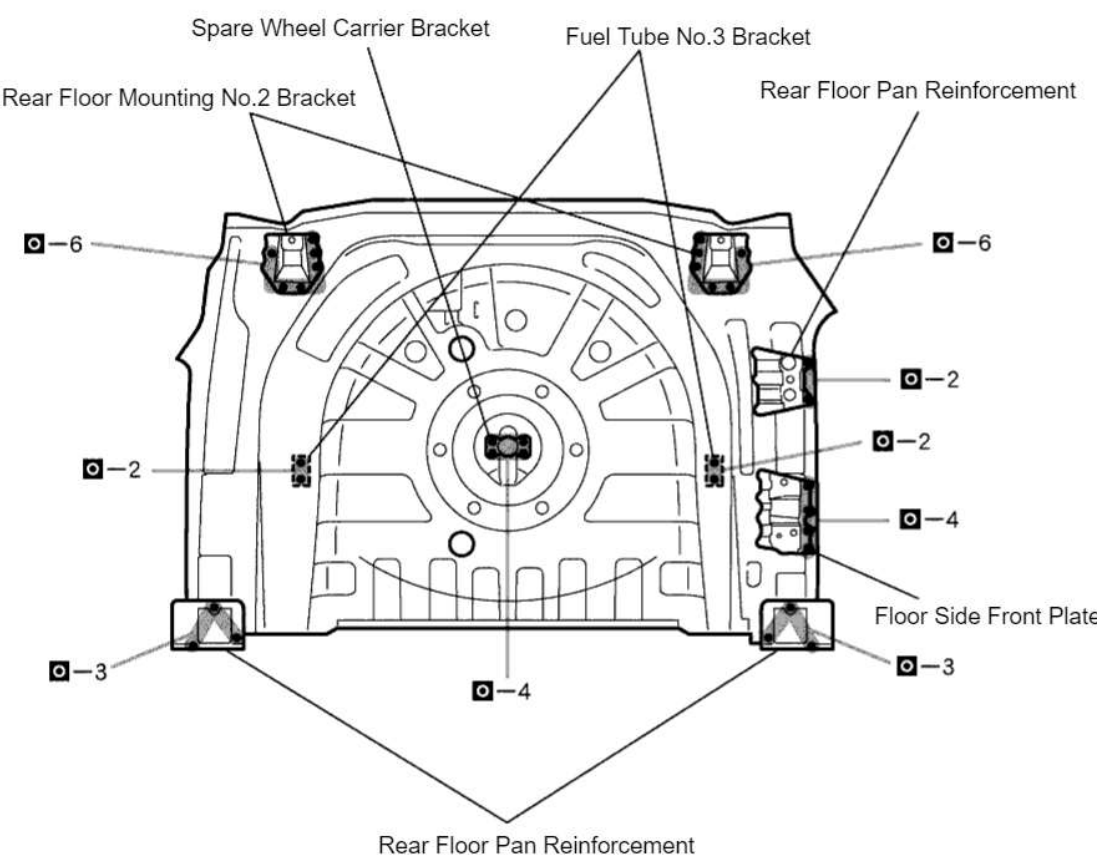
Symbol meaning

 **M** **I** : MIG Plug Weld

 : Tack Weld

F25749B

INSTALLATION



The diagram shows the rear floor pan reinforcement area with various components and welding points labeled:

- Spare Wheel Carrier Bracket
- Fuel Tube No.3 Bracket
- Rear Floor Mounting No.2 Bracket
- Rear Floor Pan Reinforcement
- Welding points: 6, 2, 4, 3
- Floor Side Front Plate

F26003

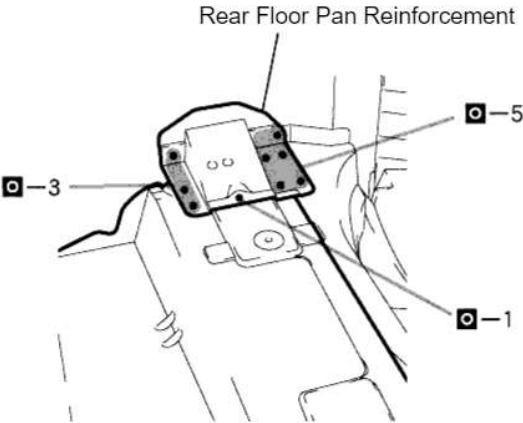
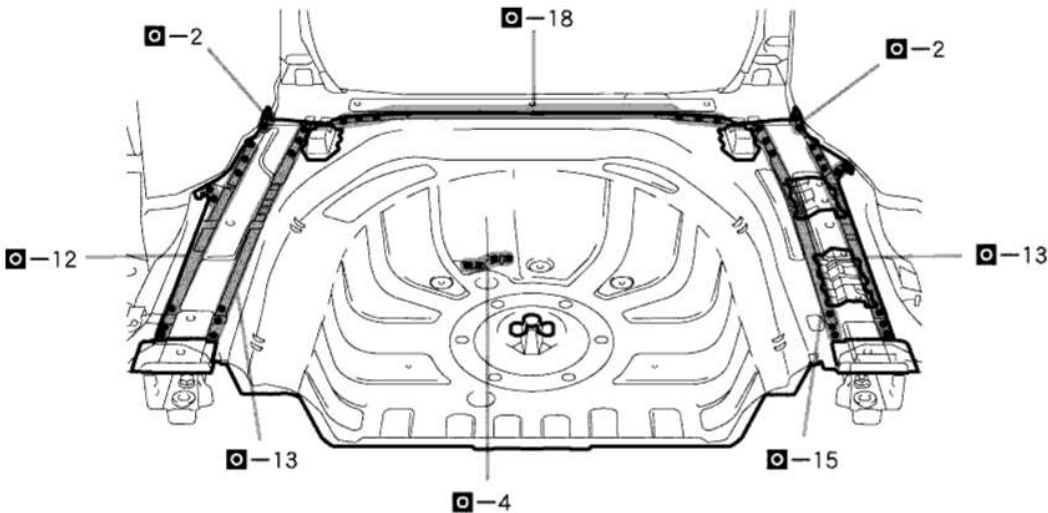
INSTALLATION POINT

1

Before temporarily installing the new parts, weld the spare wheel carrier bracket, fuel tube No.3 bracket, rear floor mounting No.2 bracket, rear floor pan reinforcement and floor side front plate with the standard number of welding points.

BODY PANEL REPLACEMENT

BP-53



BP-54

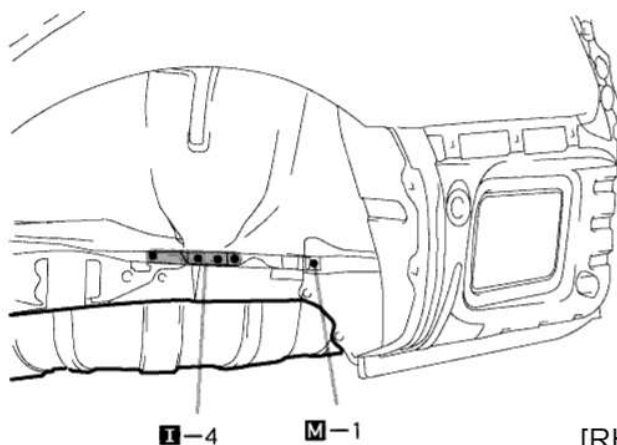
BODY PANEL REPLACEMENT

Symbol meaning

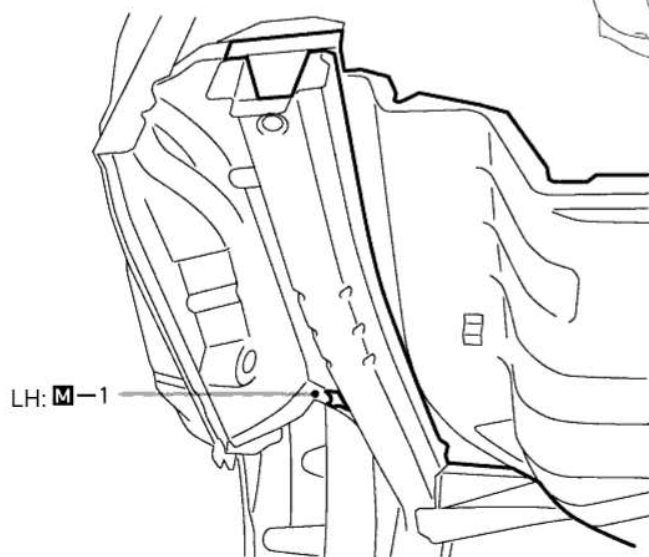
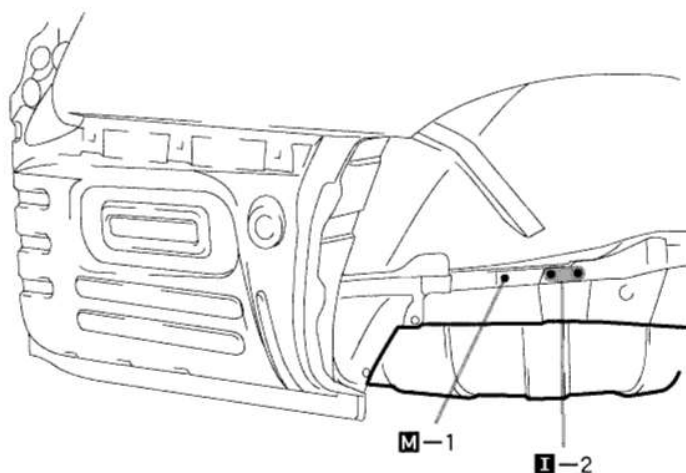
 **M** **I** : MIG Plug Weld
  : Tack Weld

F25749B

[LH]



[RH]

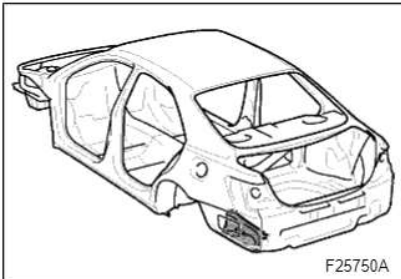


F26005

INSTALLATION POINT

- 1 After welding, apply body sealer and undercoating to the corresponding parts. (See the paint-coating)
- 2 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

REAR FLOOR SIDE PANEL (ASSY)



F25750A

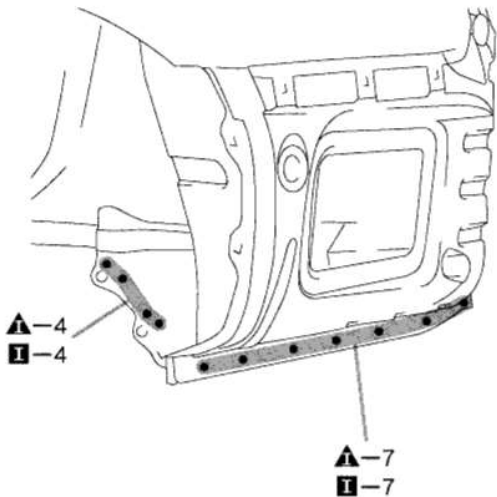
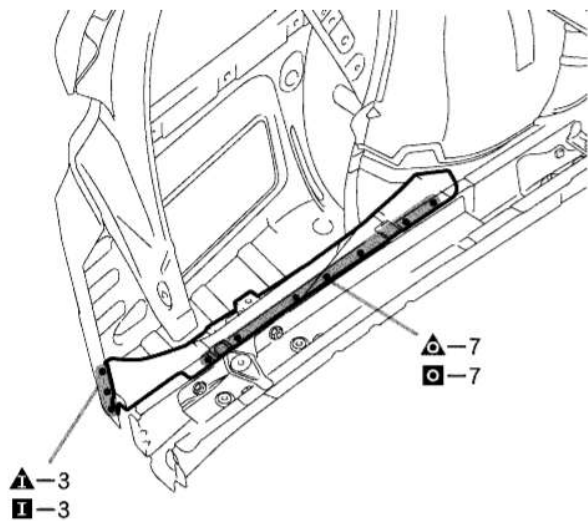
With the rear floor pan removed.

Symbol meaning	
REMOVAL	⚠ ⚠ : Remove Weld Points
INSTALLATION	Ⓜ Ⓜ : MIG Plug Weld

F25750B

REMOVAL-INSTALLATION

[LH]



F25750

INSTALLATION POINT

- 1 After welding, apply body sealer and undercoating to the corresponding parts. (See the paint-coating)
- 2 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

BP-56

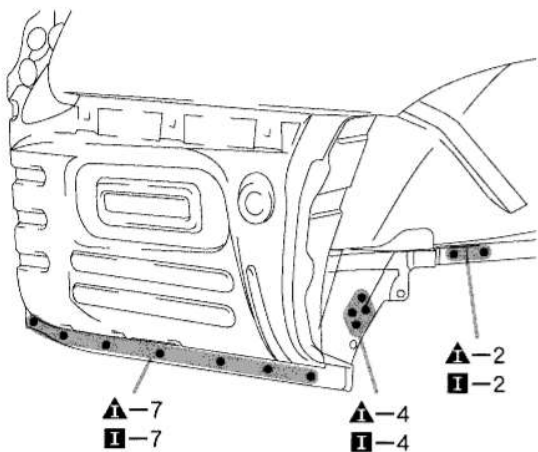
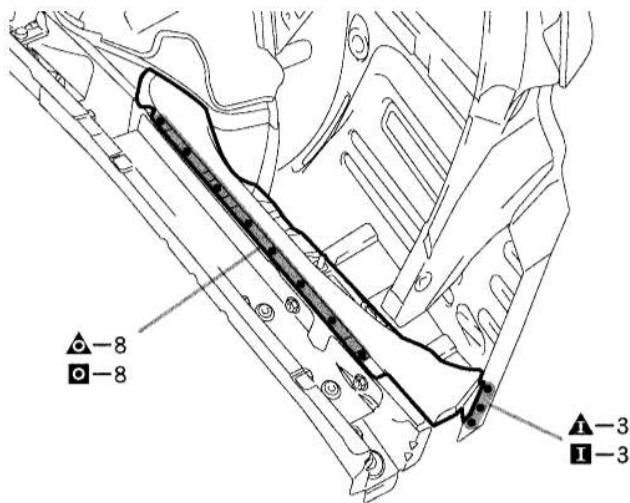
BODY PANEL REPLACEMENT

Symbol meaning

- REMOVAL
- INSTALLATION
-   : Remove Weld Points
-   : MIG Plug Weld

F25750B

[RH]

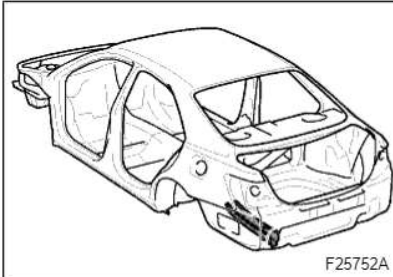


F25751

INSTALLATION POINT

- 1
- 2
- After welding, apply body sealer and undercoating to the corresponding parts. (See the paint coating)
- After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

REAR FLOOR SIDE REAR MEMBER (ASSY)



F25752A

With the rear floor no.3 crossmember removed.

Symbol meaning

REMOVAL ⚠ ⚠ : Remove Weld Points

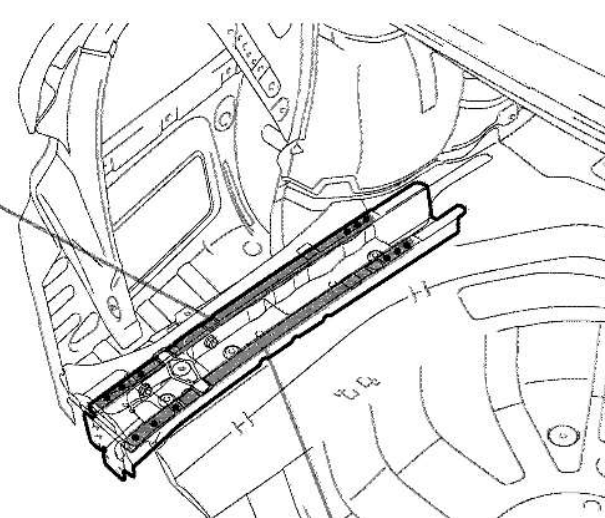
INSTALLATION ◻ ◻ : MIG Plug Weld

F25752B

REMOVAL-INSTALLATION

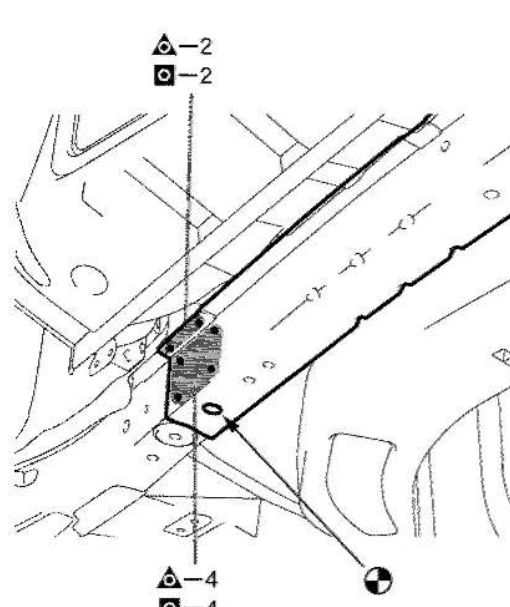
LH: ⚠-11
◻-11

RH: ⚠-12
◻-12



⚠-2
◻-2

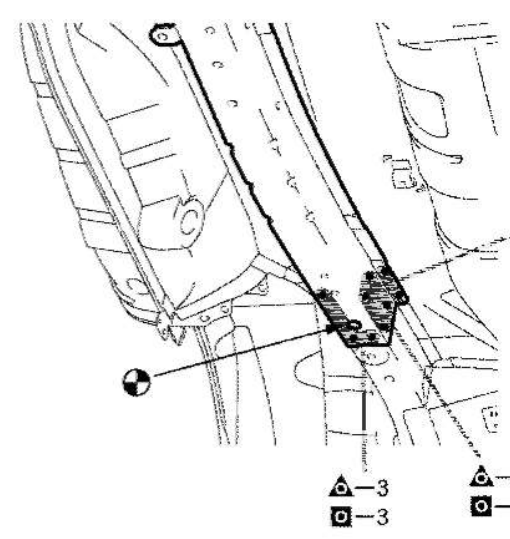
⚠-13
◻-13



⚠-2
◻-2

⚠-3
◻-3

⚠-4
◻-4

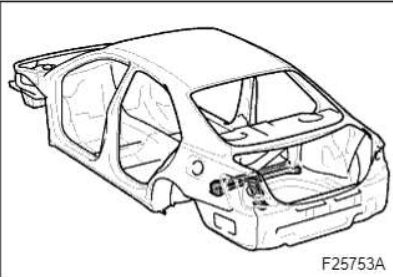


F25752

INSTALLATION POINT

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

REAR FLOOR NO. 2 CROSSMEMBER (ASSY)



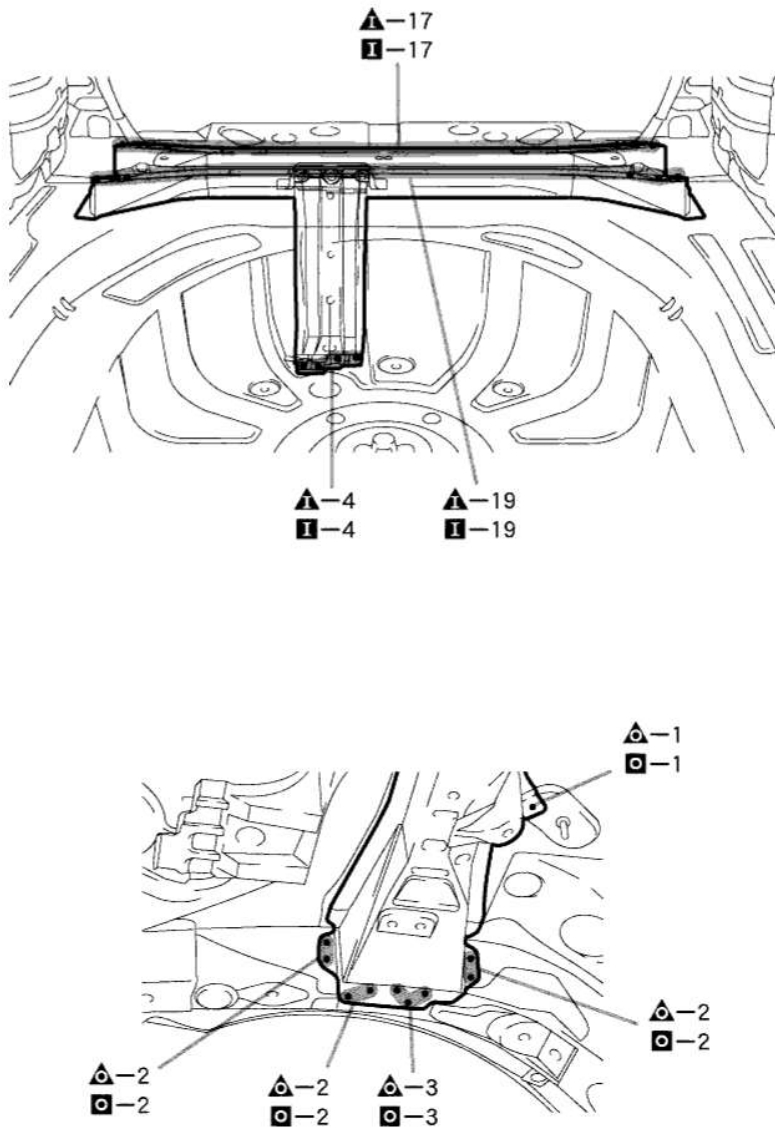
F25753A

Symbol meaning

REMOVAL	△ △ : Remove Weld Points
INSTALLATION	□ T : MIG Plug Weld

F25753B

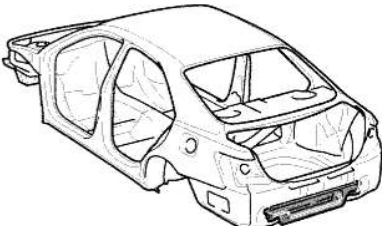
REMOVAL-INSTALLATION



F25753

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

REAR FLOOR NO. 3 CROSSMEMBER (ASSY)



F25746A

With the body lower back panel removed.

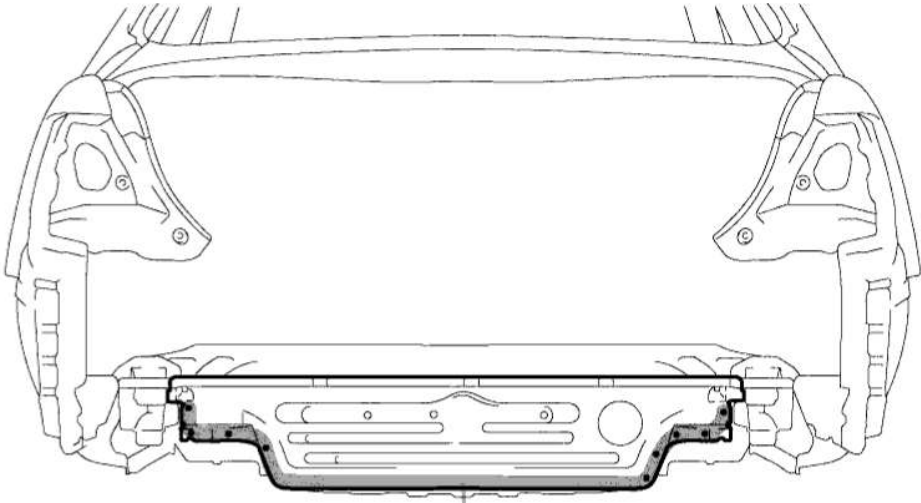
Symbol meaning

REMOVAL ▲ : Remove Weld Points

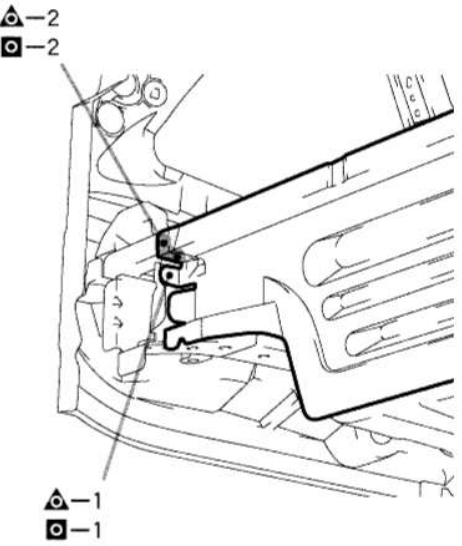
INSTALLATION ● : Spot Weld ◻ : MIG Plug Weld

F25746B

REMOVAL-INSTALLATION

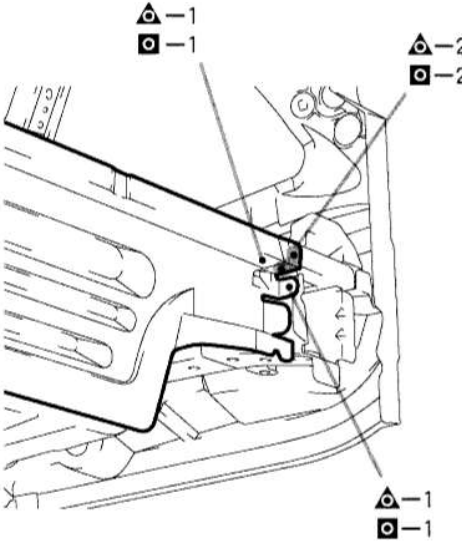


▲-16
●-21



▲-2
◻-2

▲-1
◻-1



▲-1
◻-1

▲-2
◻-2

▲-1
◻-1

F25746

INSTALLATION POINT

1

Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.

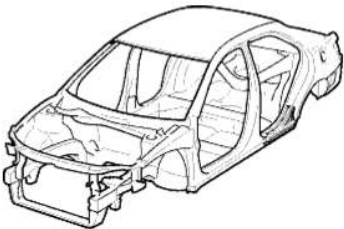
2

After welding, apply body sealer and undercoating to the corresponding parts. (See the paint-coating)

3

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

ROCKER OUTER EXTENSION (ASSY)



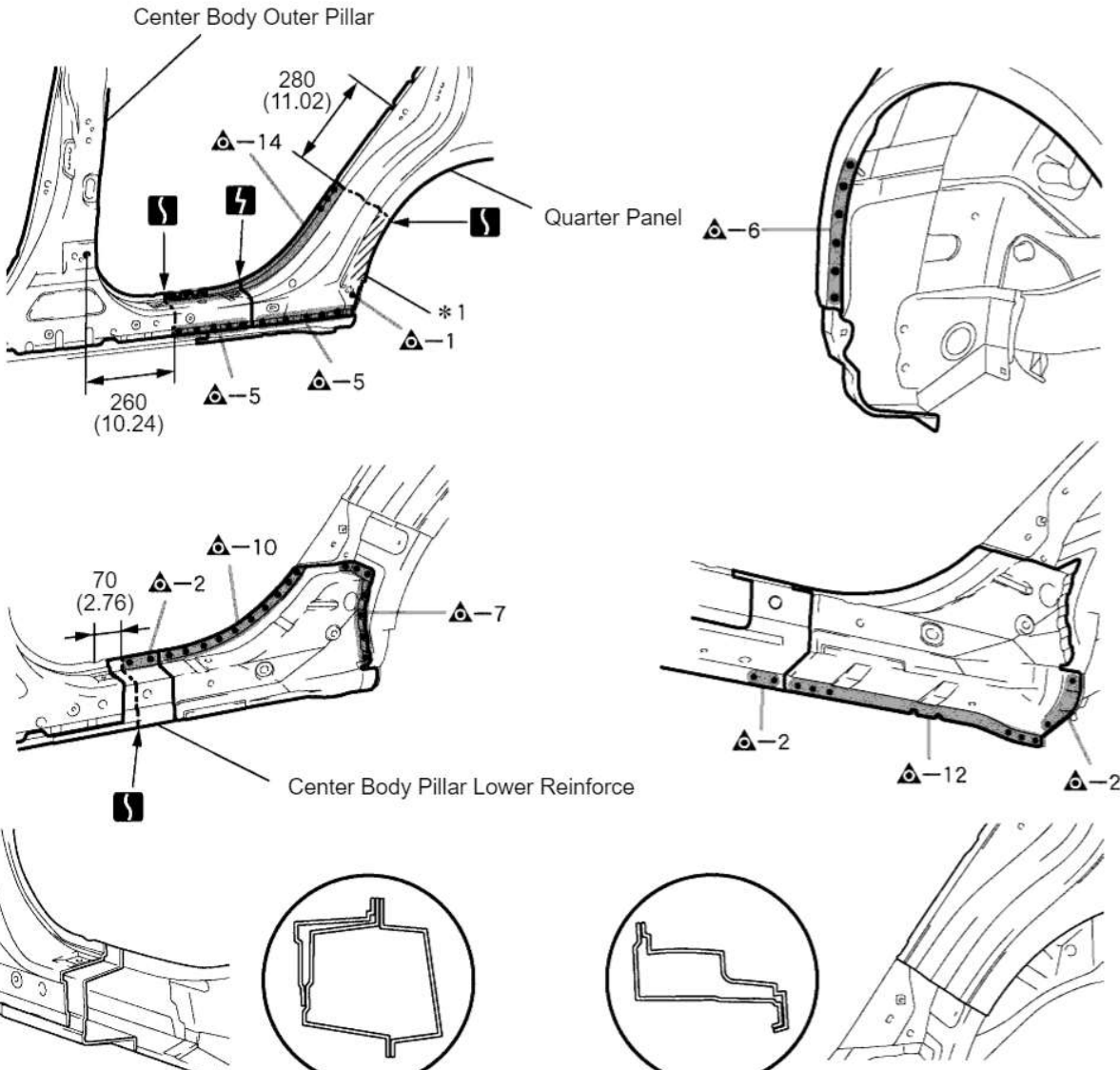
F25731A

Symbol meaning

△ : Remove Weld Points S : Cut and Join Location ⚡ : Cut Location for Supply Parts

F25731B

REMOVAL



Center Body Outer Pillar

280 (11.02)

△-14

△-1

△-5

△-5

260 (10.24)

*1

Quarter Panel

△-6

70 (2.76)

△-10

△-2

△-7

Center Body Pillar Lower Reinforce

△-2

△-12

△-2

mm (in.)

F25731

- REMOVAL POINT**
- 1 *1 in illustration above indicates where the adhesive is.
 - 2 After removing the center body outer pillar and quarter panel, remove the rocker outer extension and center body pillar lower reinforce.

BODY PANEL REPLACEMENT

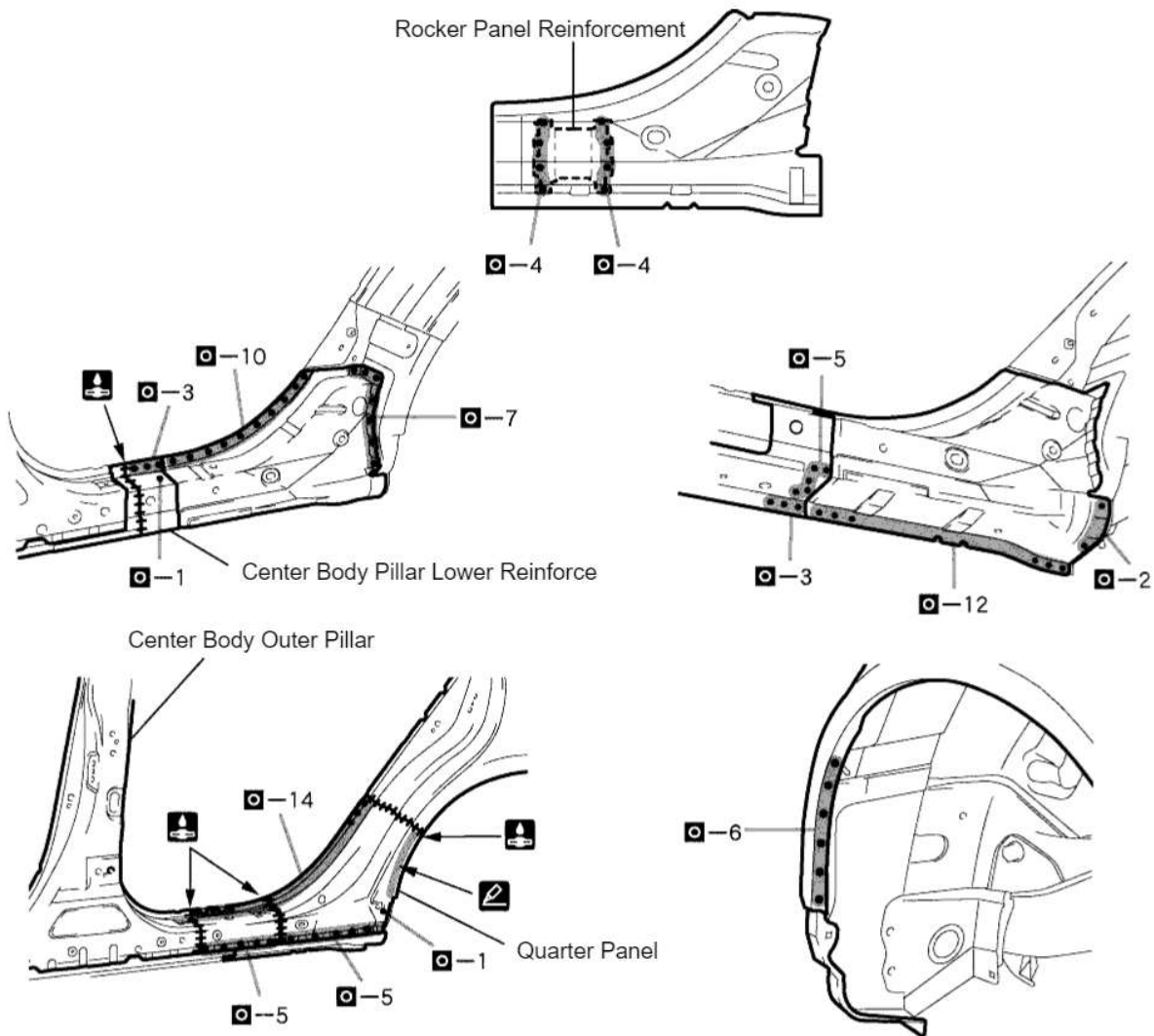
BP-35

Symbol meaning

◻ : MIG Plug Weld 🔥 : Butt Weld 🔧 : Body Sealer

F25732B

INSTALLATION



F25732

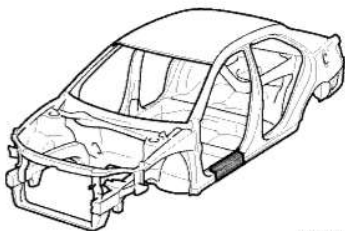
INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 Before temporarily installing the new parts, weld the rocker panel reinforcement and rocker outer extension with the standard number of welding points.
- 4 Before installing a new part, apply body sealer.

HINT:

1) Apply sealer in an even, continuous bead.
- 5 After welding the center body pillar lower reinforce and rocker outer extension to the vehicle side, install the center body outer pillar and quarter panel.
- 6 After welding, apply body sealer and undercoating to the corresponding parts. (See the paint coating)
- 7 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

ROCKER OUTER PANEL (CUT-P)



F25729A

Symbol meaning

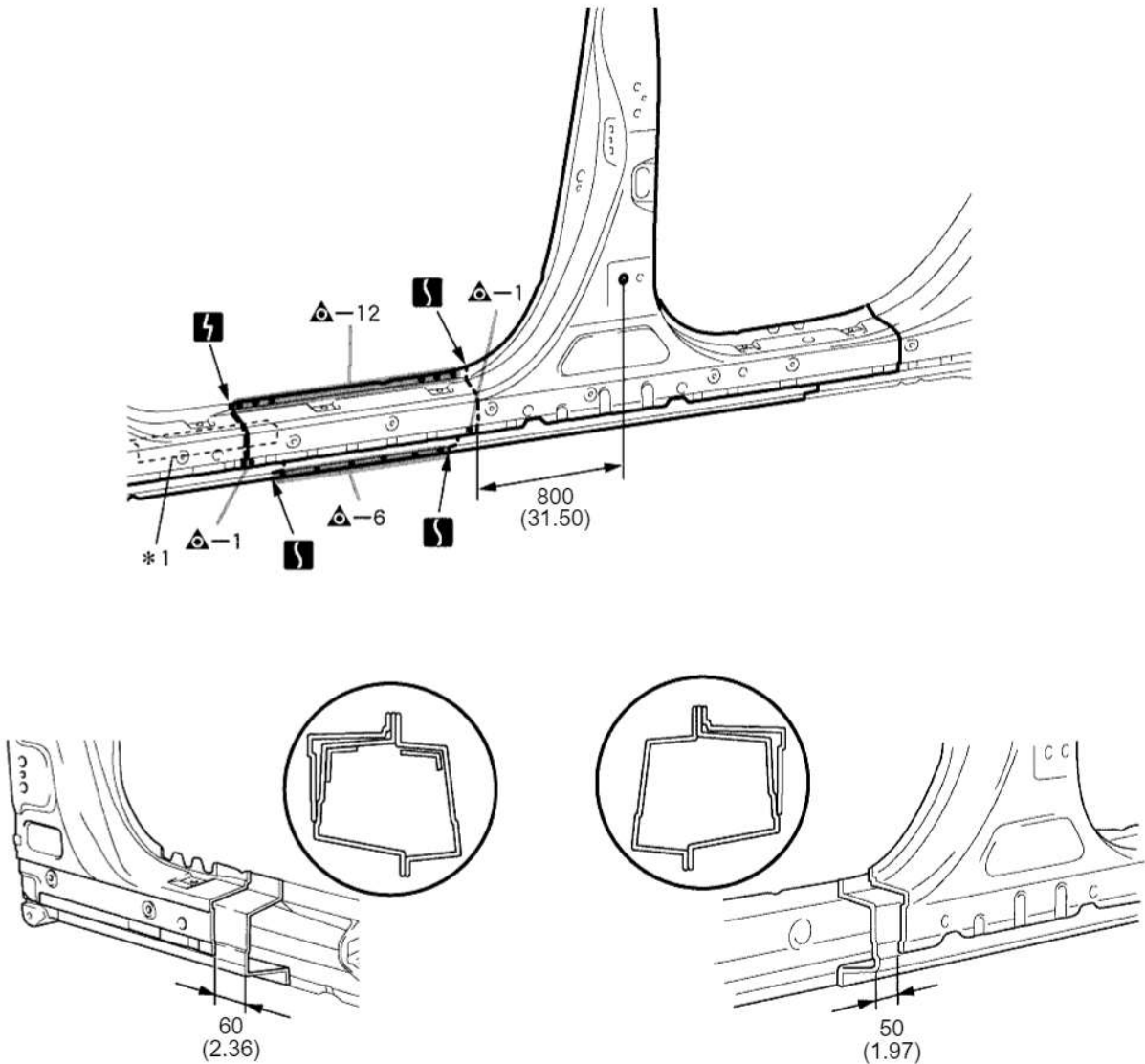
 : Cut and Join Location

 : Remove Weld Points

 : Cut Location for Supply Parts

F25729B

REMOVAL



mm (in.)

F25729

REMOVAL POINT

1 *1: Take care not to damage the internal reinforcement.

BODY PANEL REPLACEMENT

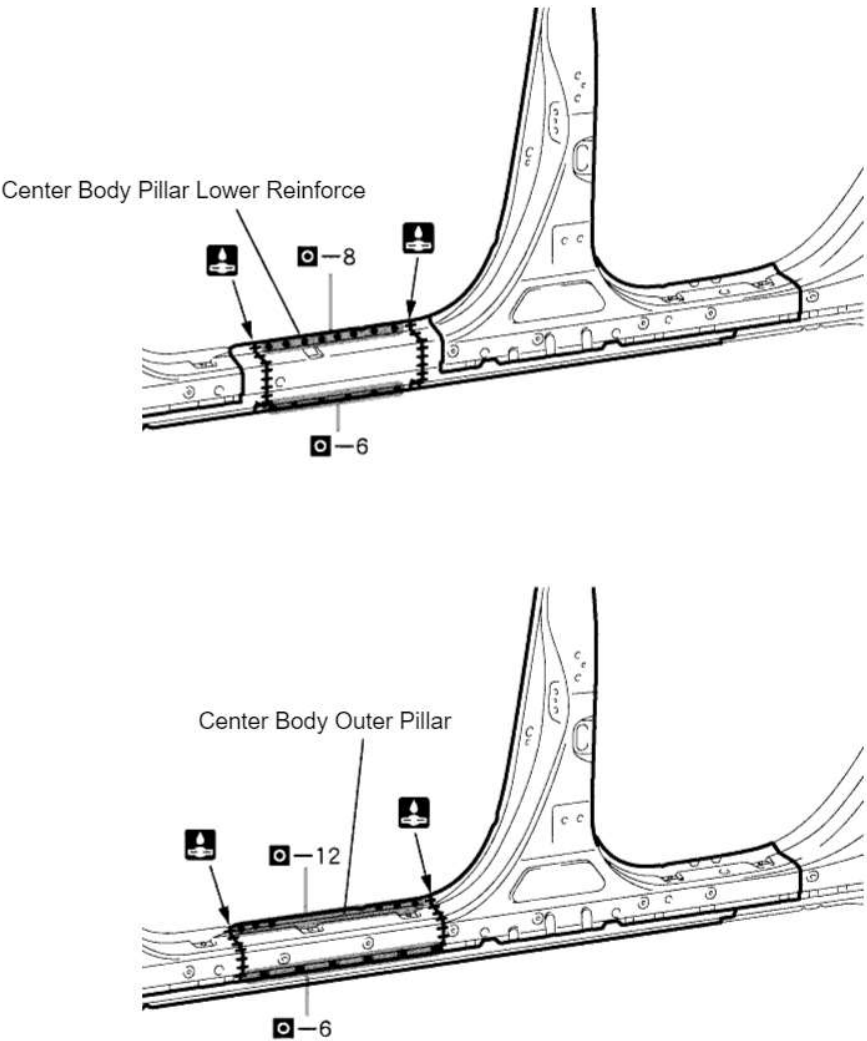
BP-33

Symbol meaning

⊙ : MIG Plug Weld S : Cut and Join Location 🔥 : Butt Weld

F25730B

INSTALLATION



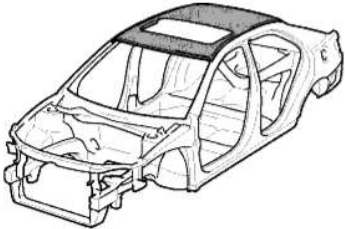
mm (in.)

F25730

INSTALLATION POINT

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

ROOF PANEL (ASSY): Moon Roof



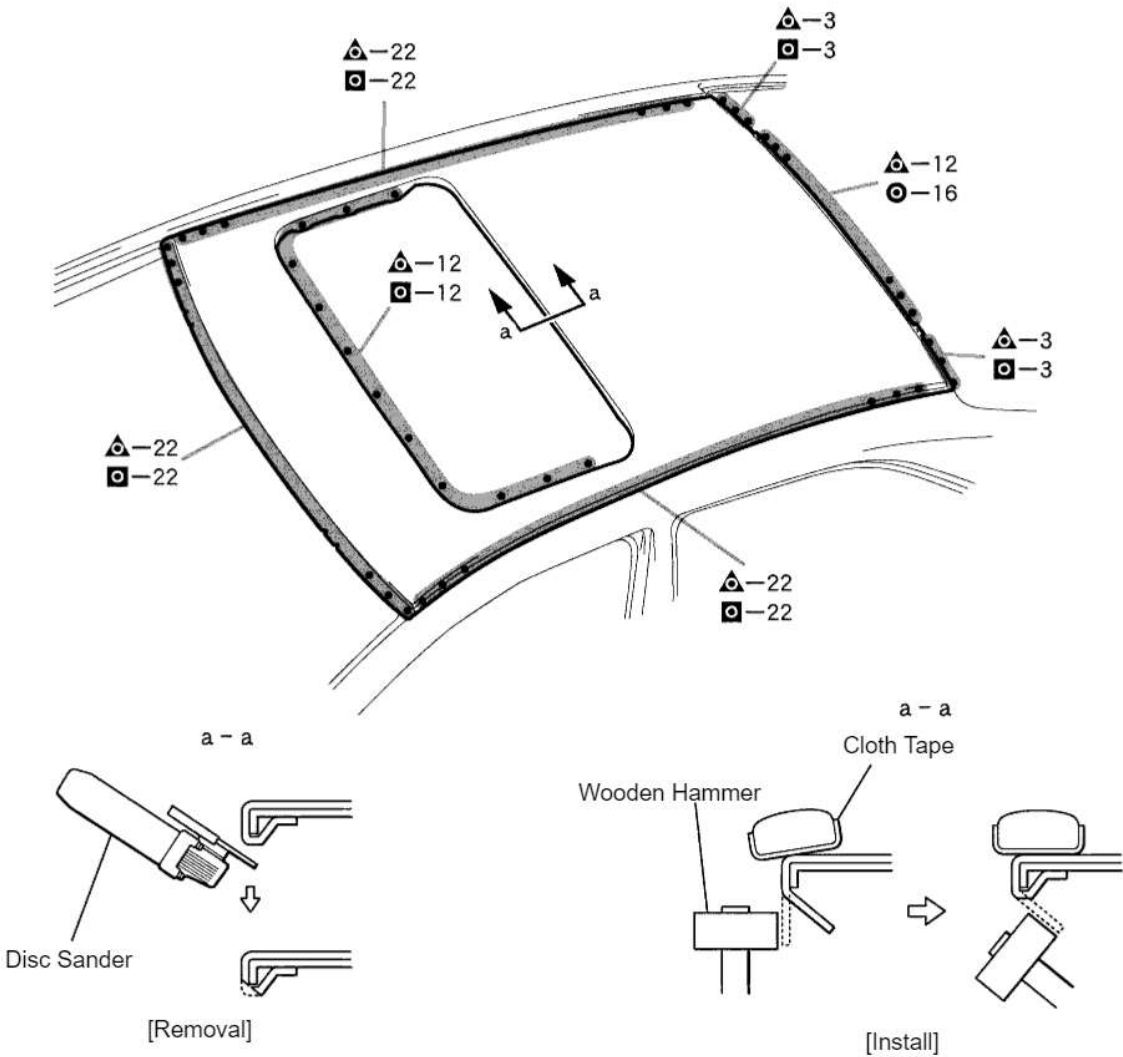
F25755A

Symbol meaning

REMOVAL	△ : Remove Weld Points
INSTALLATION	○ : Spot Weld ◻ : MIG Plug Weld ▨ : Body Sealer

F25755B

REMOVAL-INSTALLATION



△-22
◻-22

△-3
◻-3

△-12
◻-16

△-22
◻-22

△-22
◻-22

△-22
◻-22

△-3
◻-3

△-22
◻-22

△-12
◻-12

a - a

a - a

Disc Sander

[Removal]

Wooden Hammer

Cloth Tape

[Install]

F25755

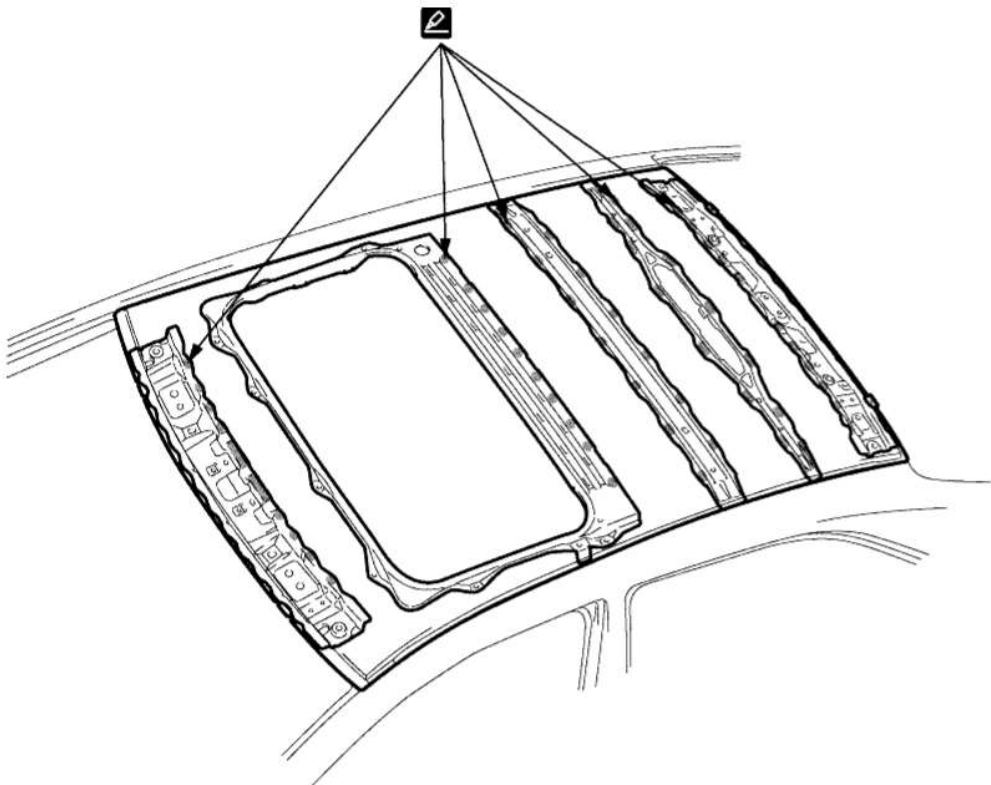
INSTALLATION POINT

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

Symbol meaning

REMOVAL	▲ : Remove Weld Points
INSTALLATION	⊙ : Spot Weld ◻ : MIG Plug Weld ◻ : Body Sealer

F25755B

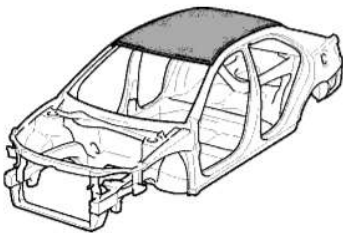


F25756

INSTALLATION POINT

- 1 Before temporarily installing the new parts, apply body sealer to the windshield header panel, roof panel reinforcement and back door opening frame.
- HINT:*
- 1) Apply just enough sealer for the new parts to make contact.

ROOF PANEL (ASSY): Normal Roof



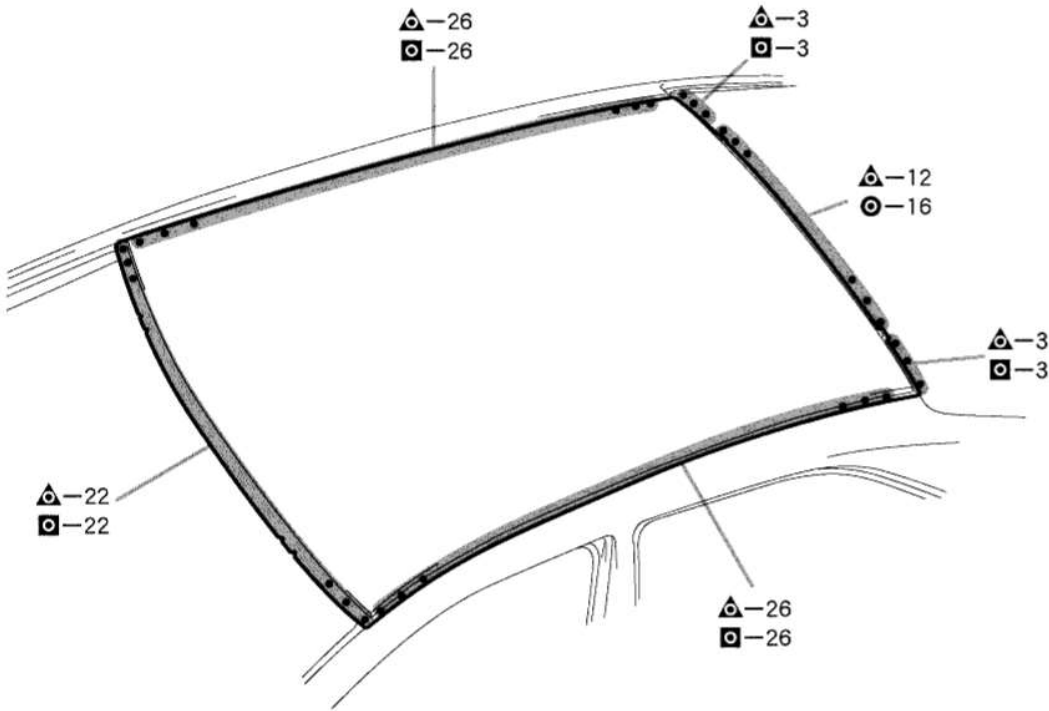
F25754A

Symbol meaning

REMOVAL	△ : Remove Weld Points
INSTALLATION	○ : Spot Weld ◻ : MIG Plug Weld ▨ : Body Sealer

F25754B

REMOVAL-INSTALLATION



F25754

INSTALLATION POINT

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

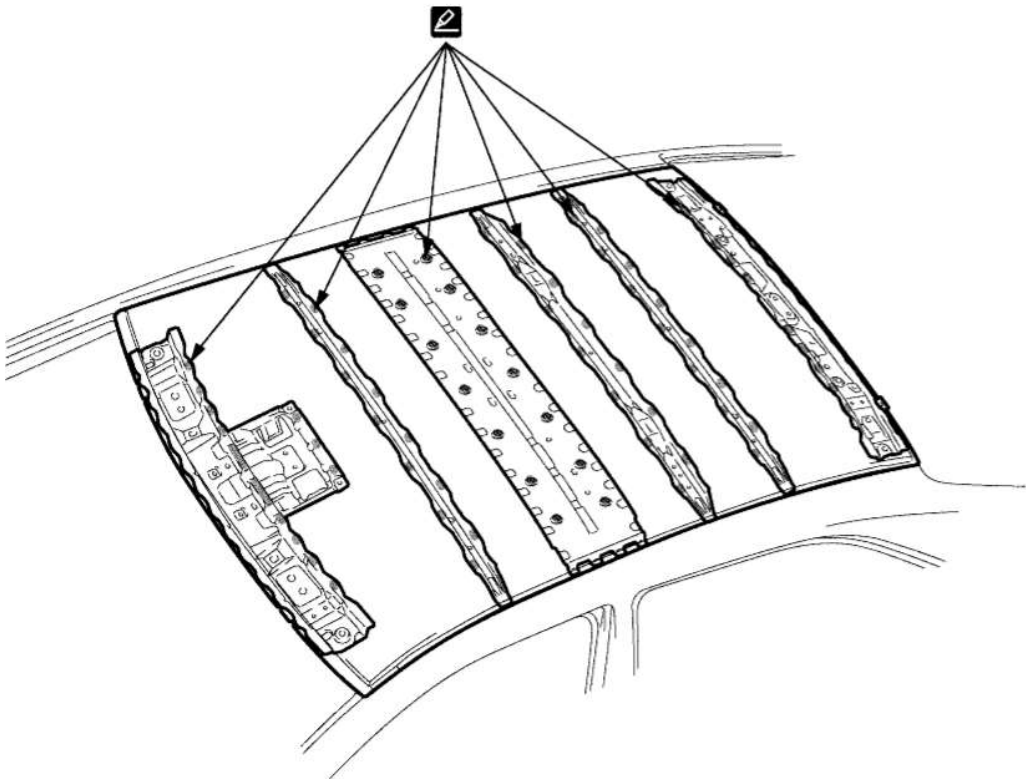
BP-60

BODY PANEL REPLACEMENT

Symbol meaning

REMOVAL	⚠ : Remove Weld Points
INSTALLATION	⦿ : Spot Weld ◻ : MIG Plug Weld ◻ : Body Sealer

F25754B



F25806

INSTALLATION POINT

- 1 Before temporarily installing the new parts, apply body sealer to the windshield header panel, roof panel reinforcement and back door opening frame.
HINT:
1) Apply just enough sealer for the new parts to make contact.