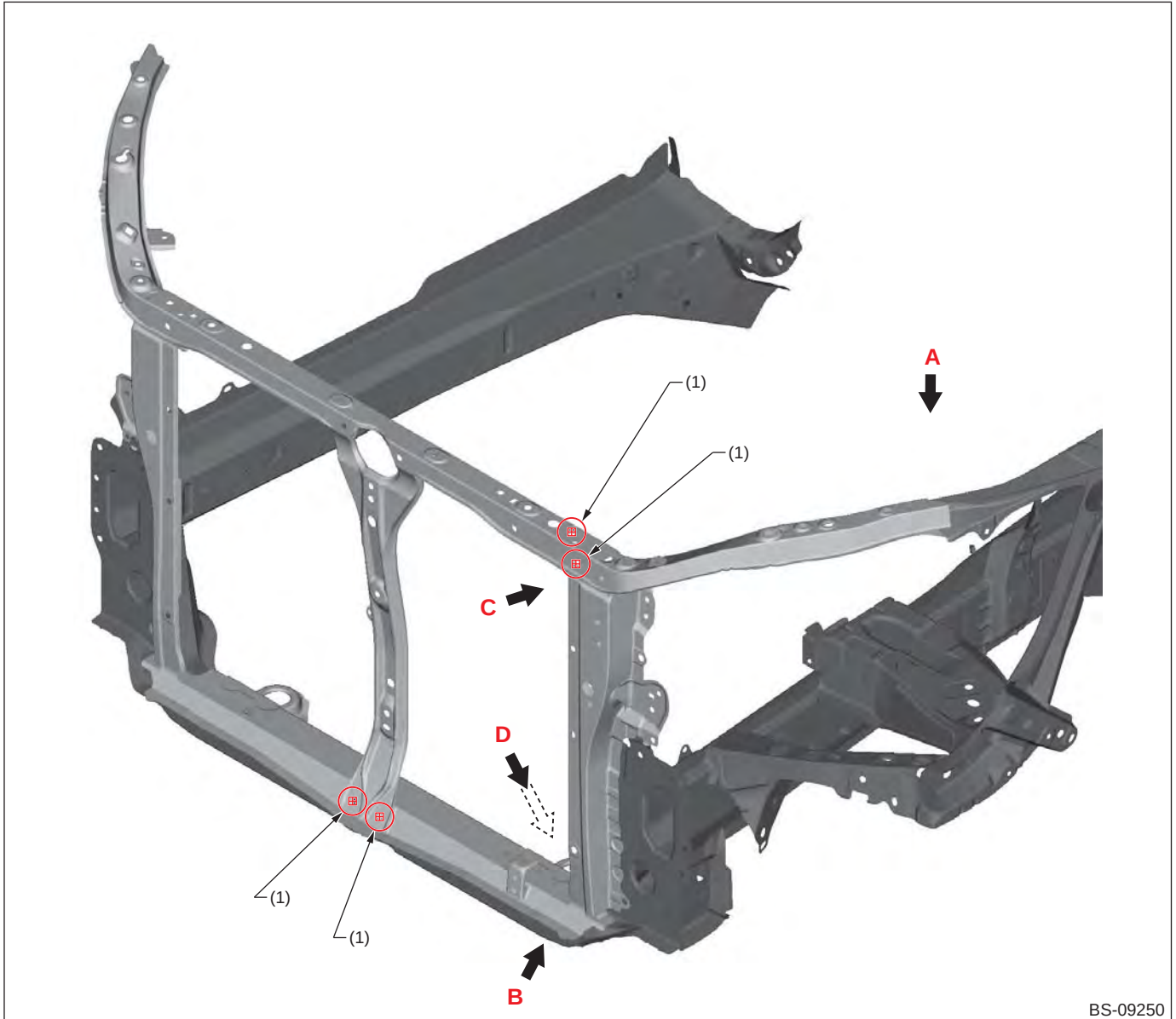


8. Panel Replacement

8-1. Radiator Panel (Total replacement)

A: REMOVAL

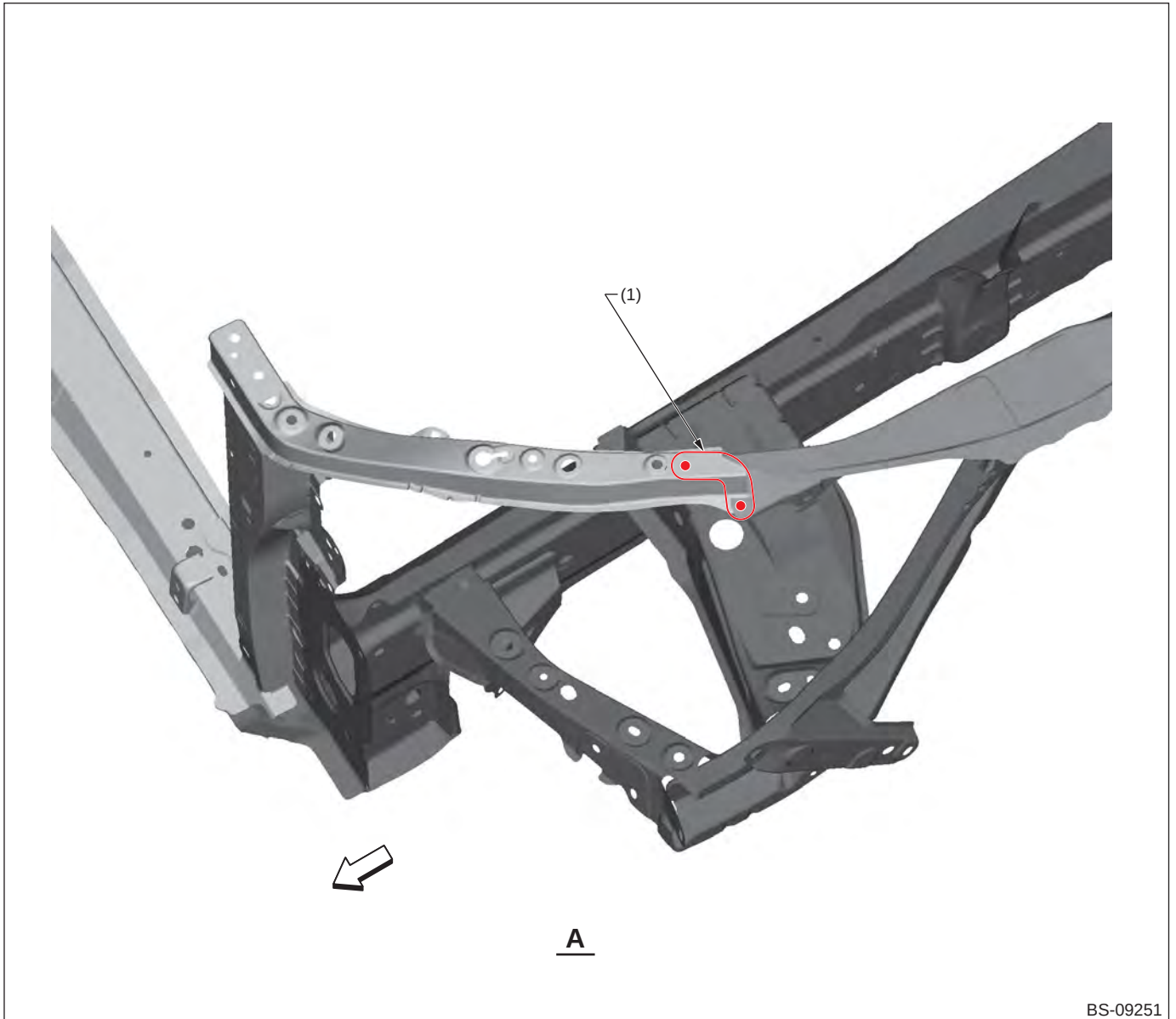
• Overall view



(1) 1 point (bolt)

Panel Replacement

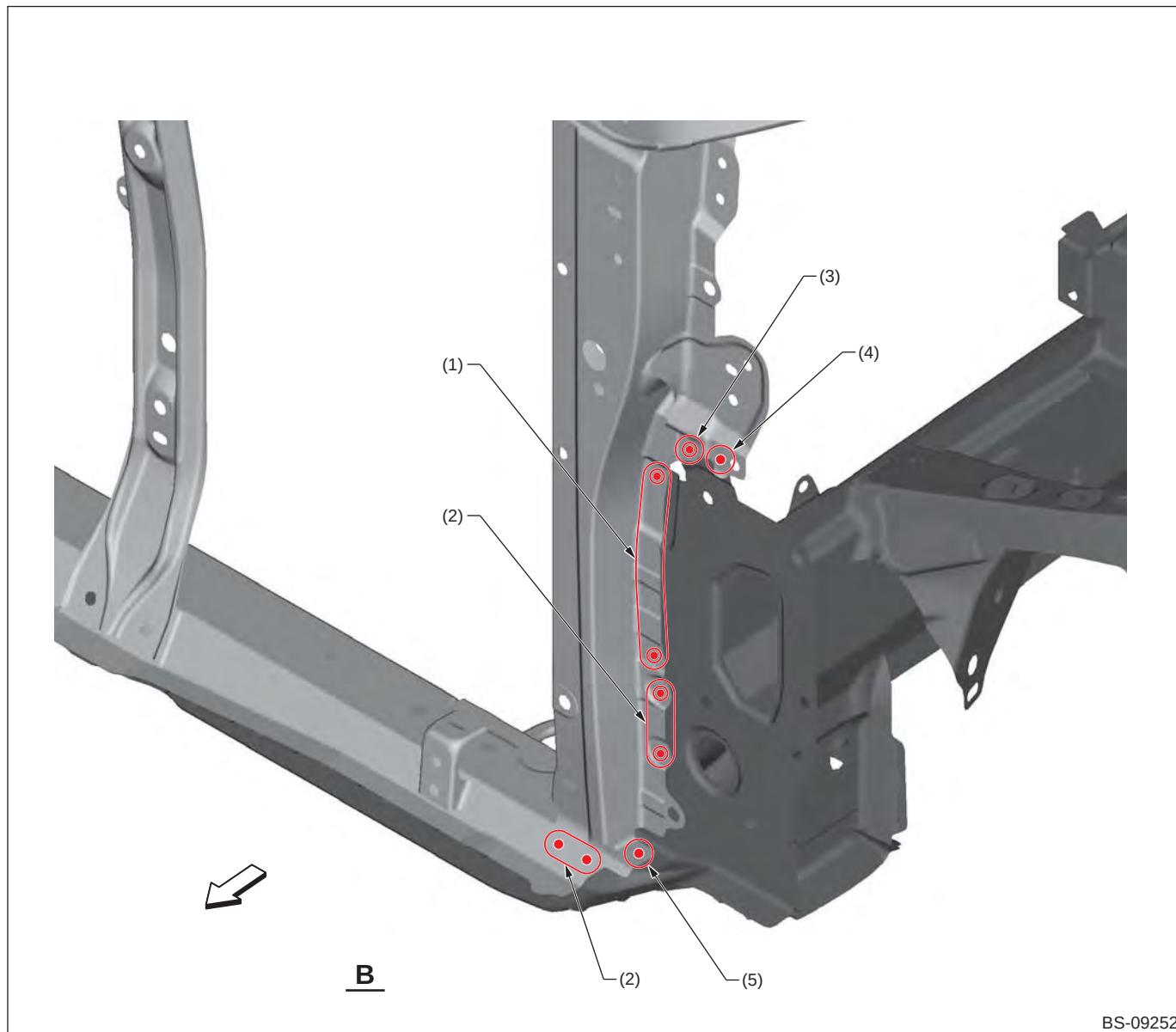
- Views A



(1) 3 points (top · 1)

Panel Replacement

• Views B



(1) 3 points (outside · 2)

(2) 2 points (outside · 1)

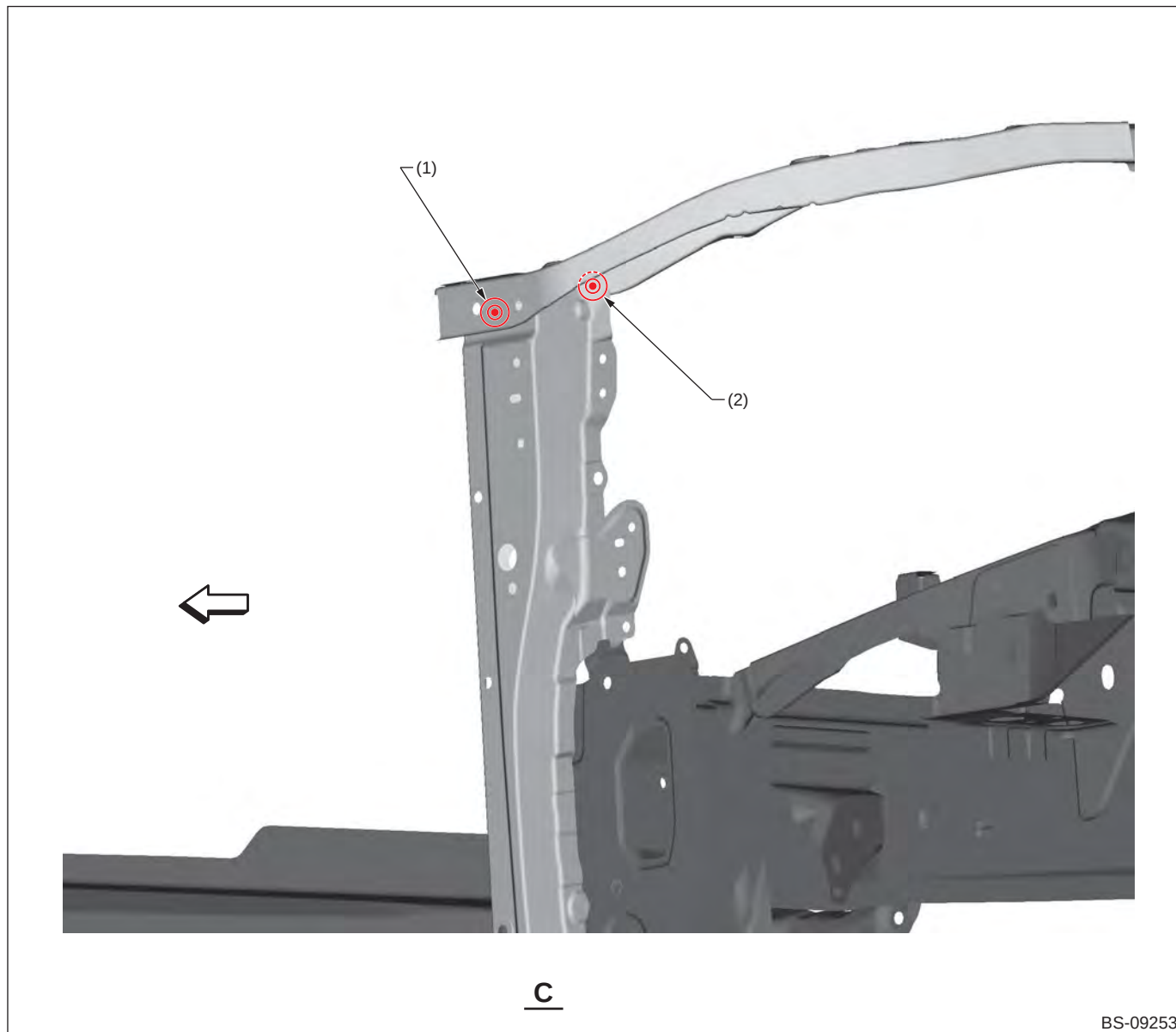
(3) 1 point (outside · 2)

(4) 1 point (outside · 1)

(5) 1 point (top · 1)

Panel Replacement

• Views C

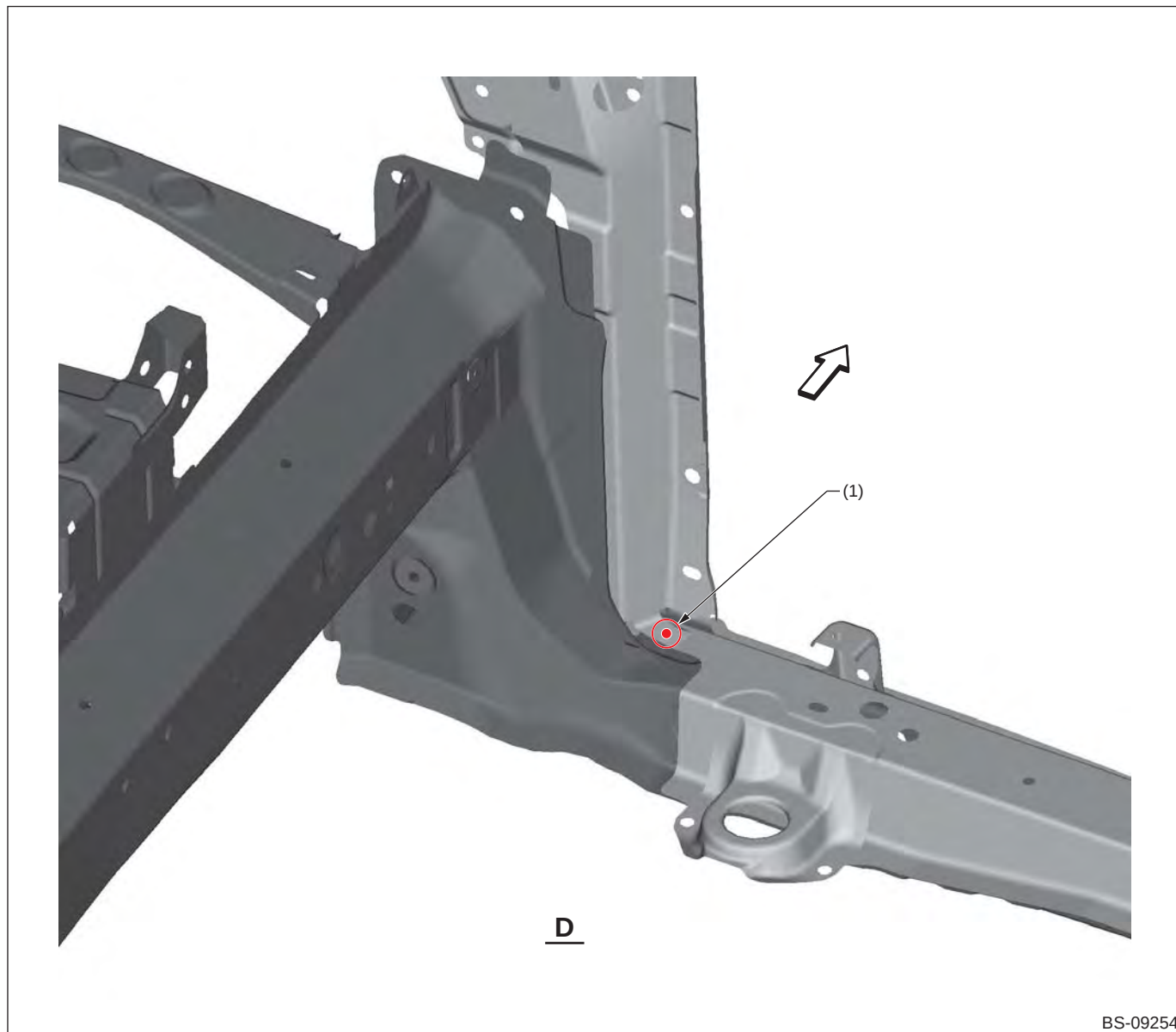


(1) 1 point (outside · 1)

(2) 1 point (inside · 1)

Panel Replacement

• Views D

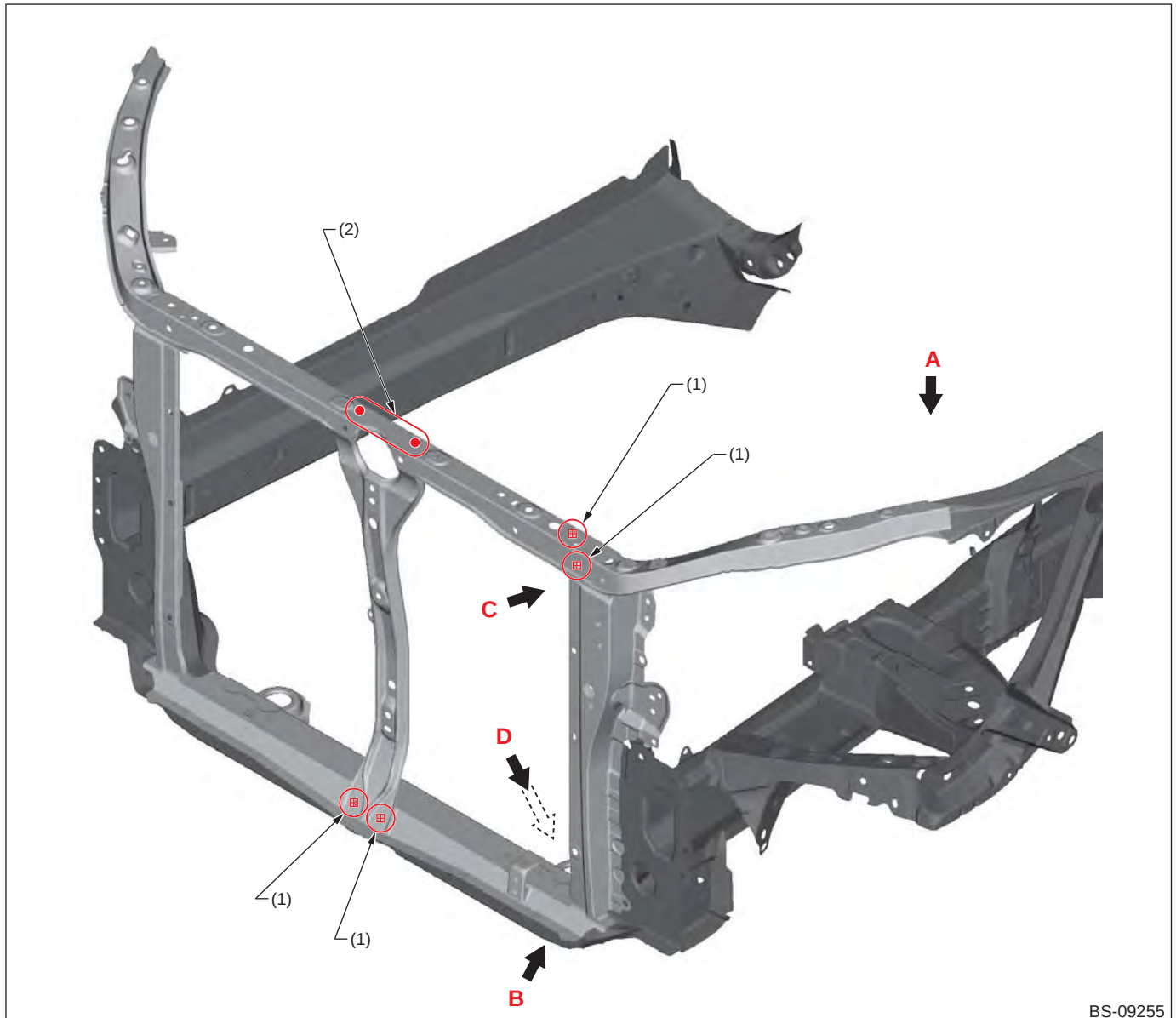


(1) 1 point (top · 1)

Panel Replacement

B: INSTALLATION

• Overall view



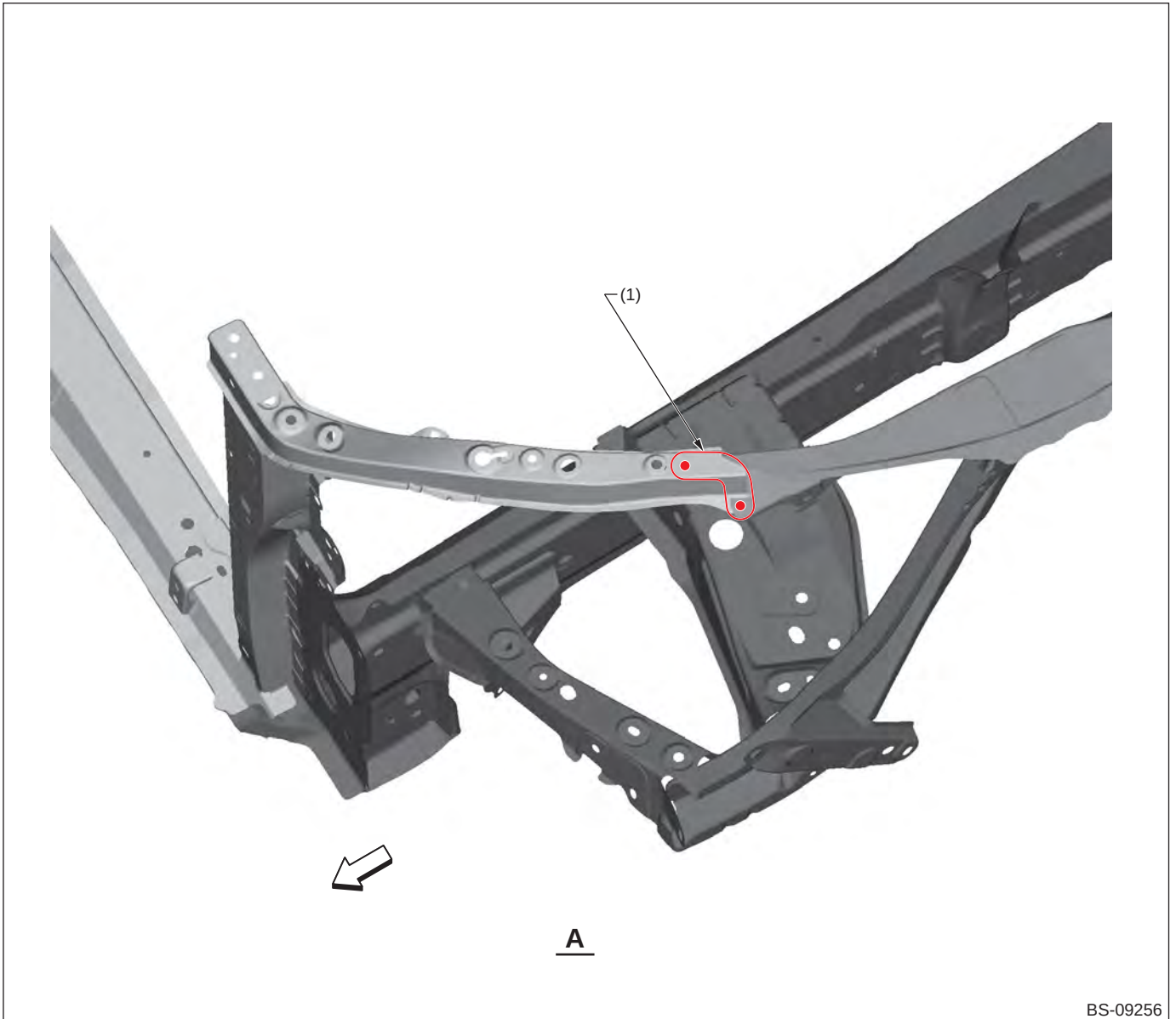
BS-09255

(1) 1 point (bolt)

(2) 2 points

Panel Replacement

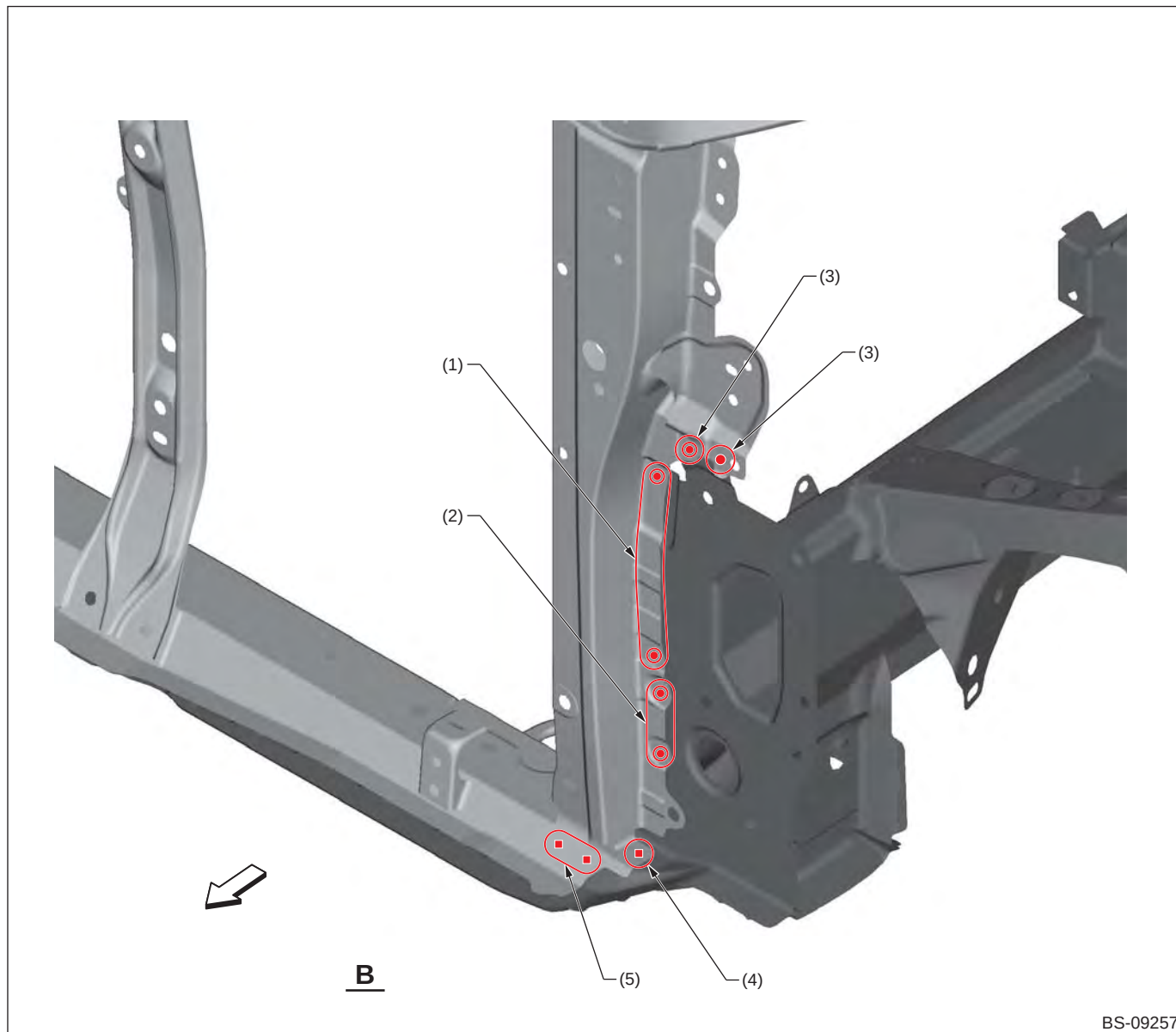
- Views A



(1) 3 points

Panel Replacement

• Views B



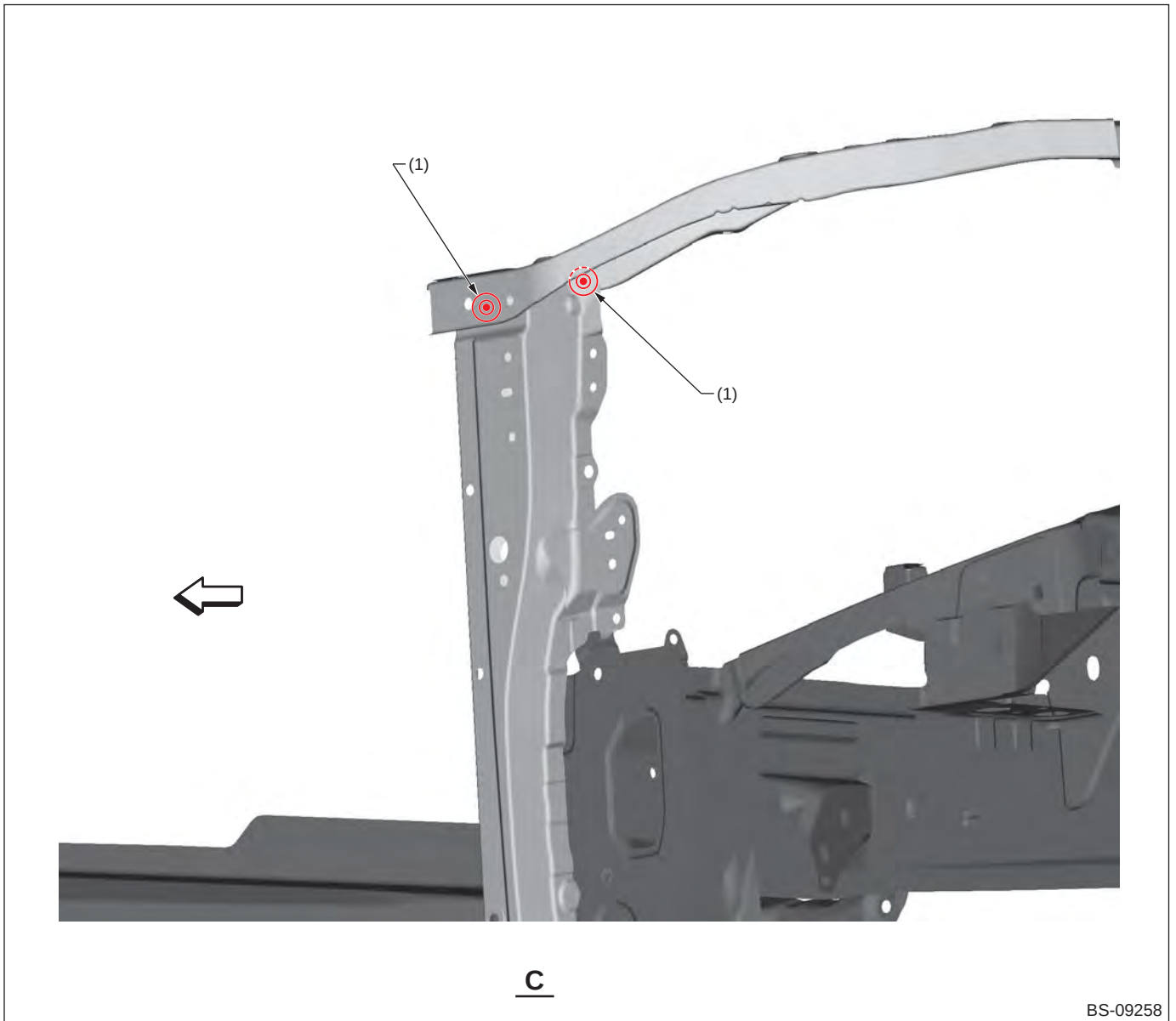
(1) 3 points
(2) 2 points

(3) 1 point
(4) 1 point (service)

(5) 2 points (service)

Panel Replacement

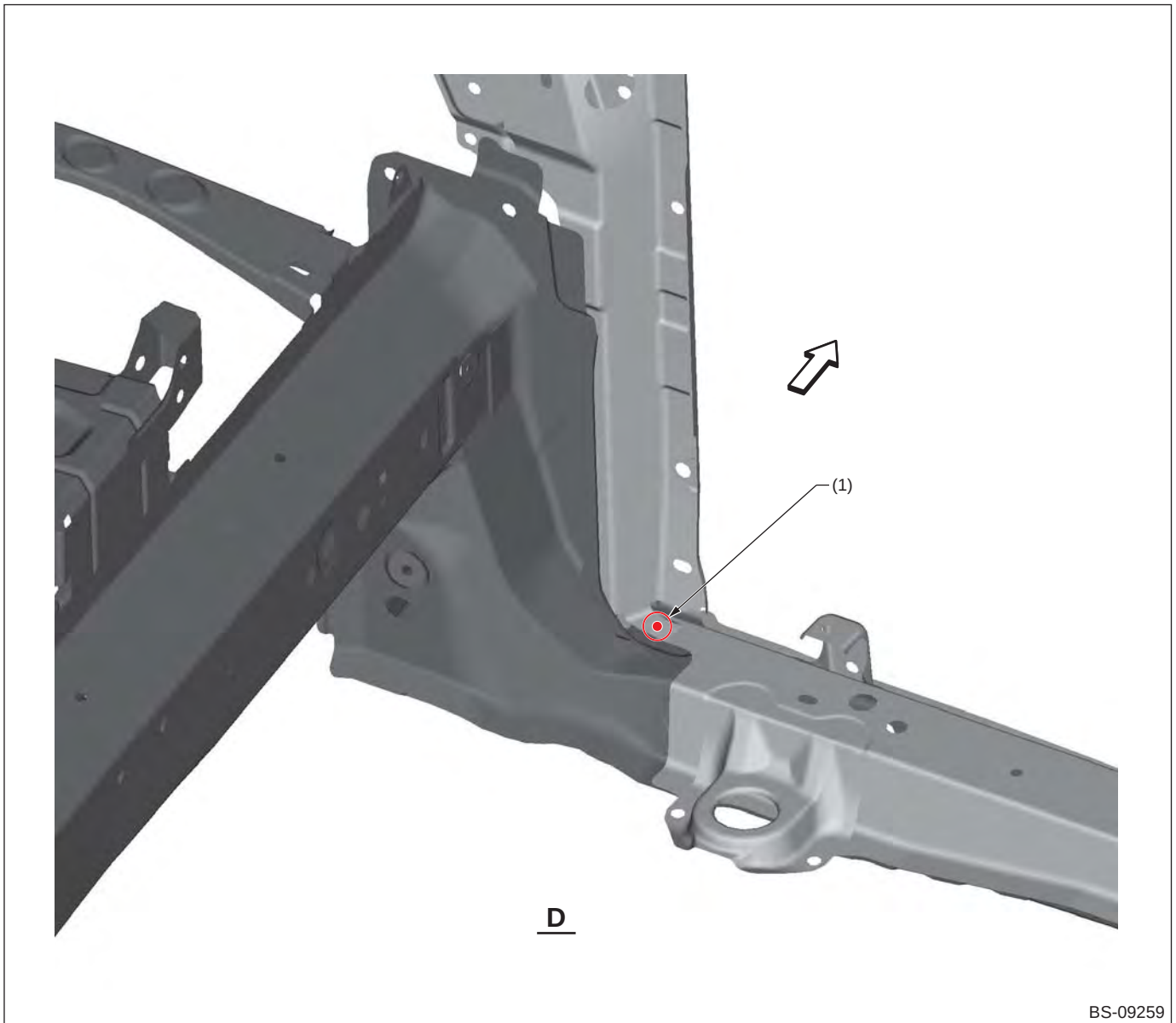
- Views C



(1) 1 point

Panel Replacement

- Views D

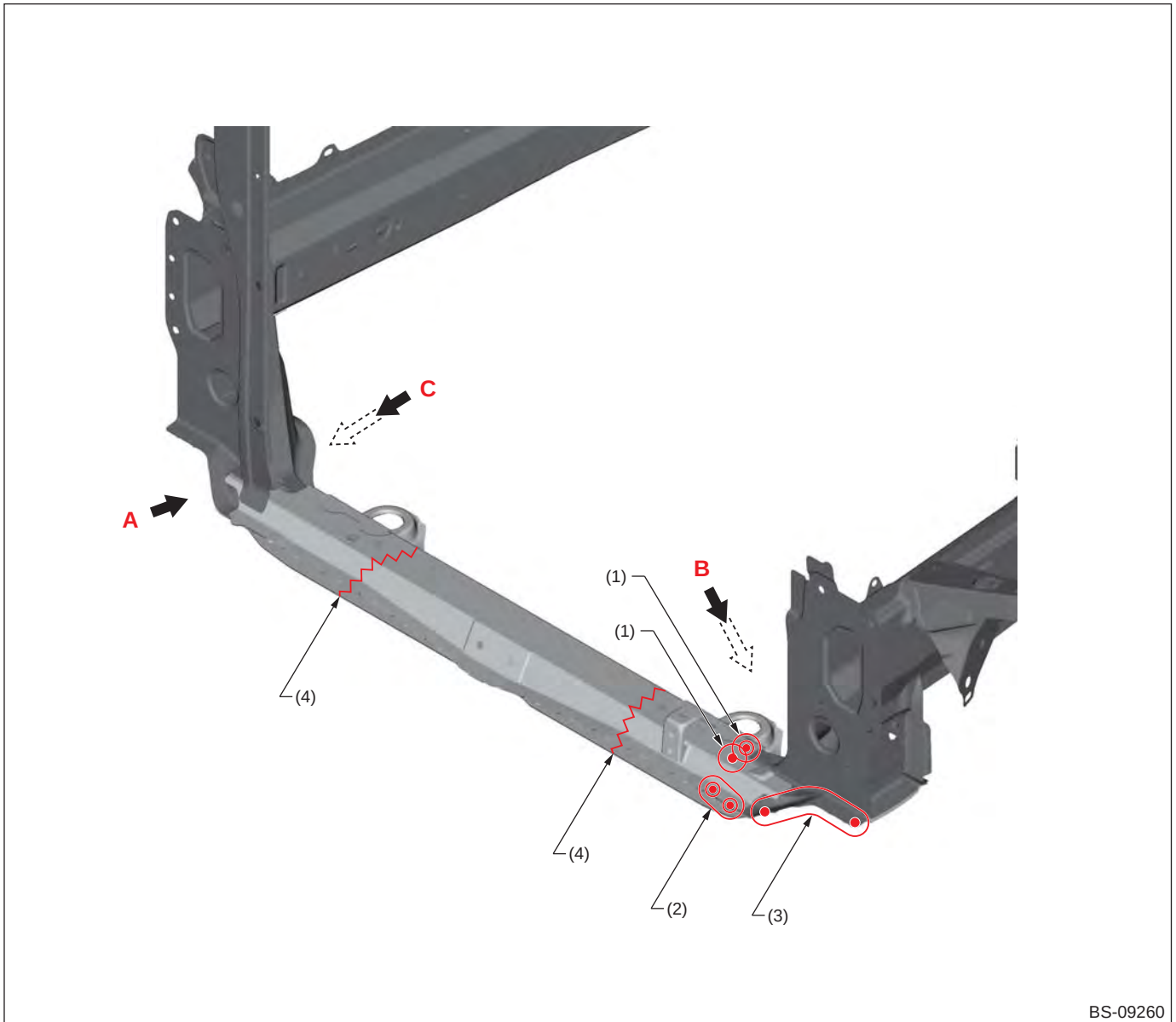


(1) 1 point (service)

8-2. Radiator Core Support (Total replacement)

A: REMOVAL

• Overall view



BS-09260

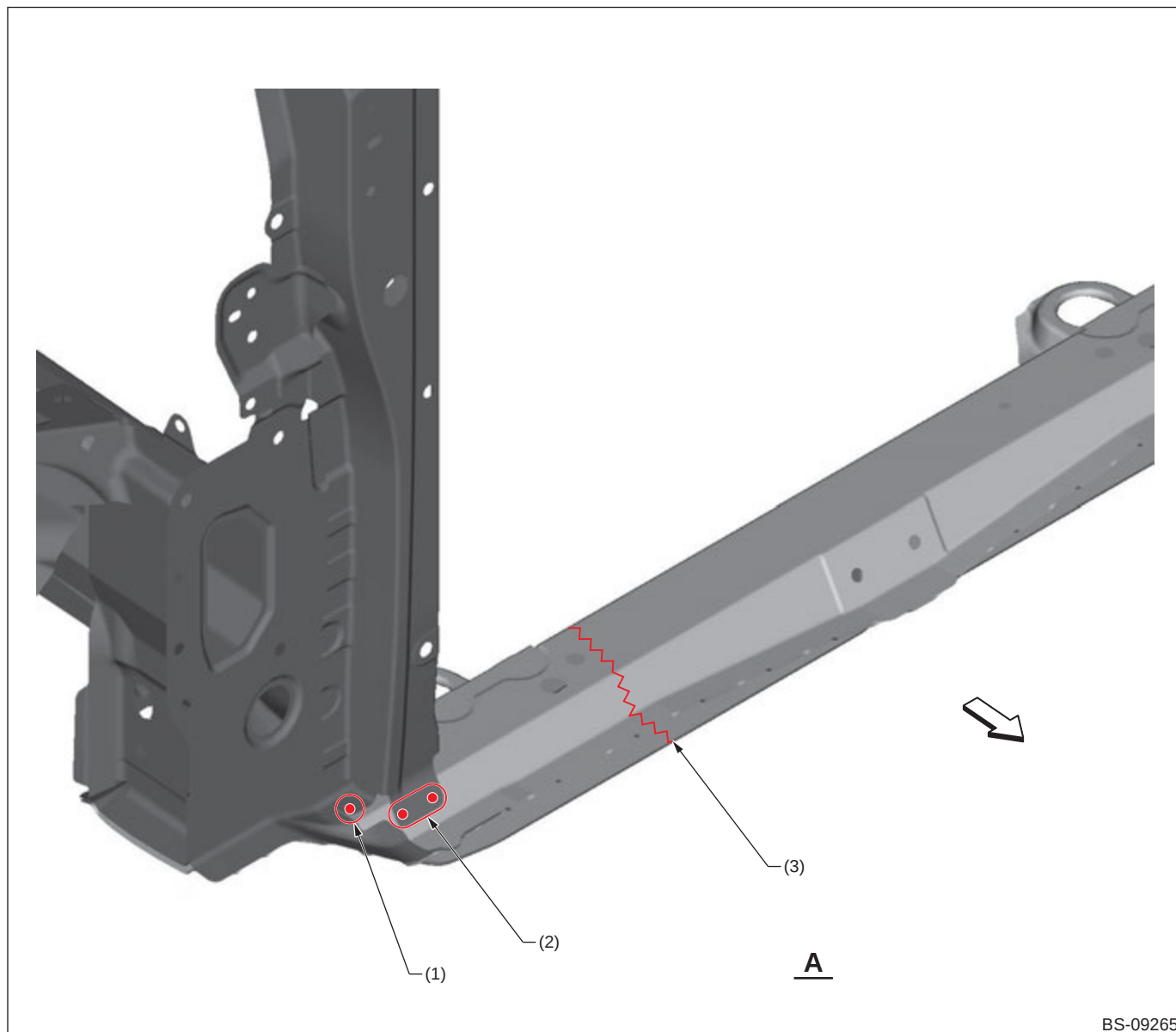
- (1) 1 point (top · 1)
(2) 2 points (top · 1)

- (3) 5 points (top · 1)

- (4) Rough cutting

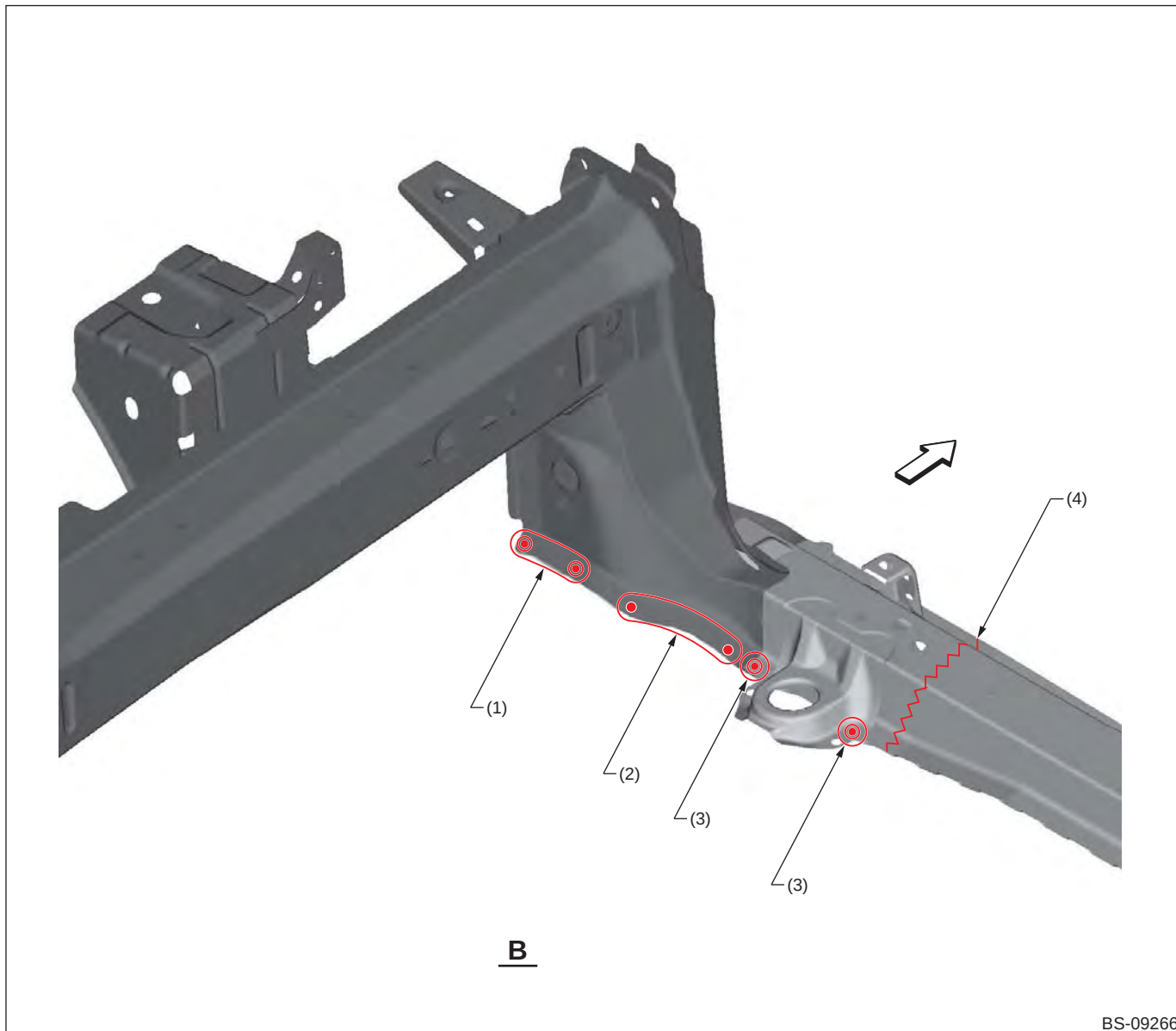
Panel Replacement

• Views A



Panel Replacement

• Views B



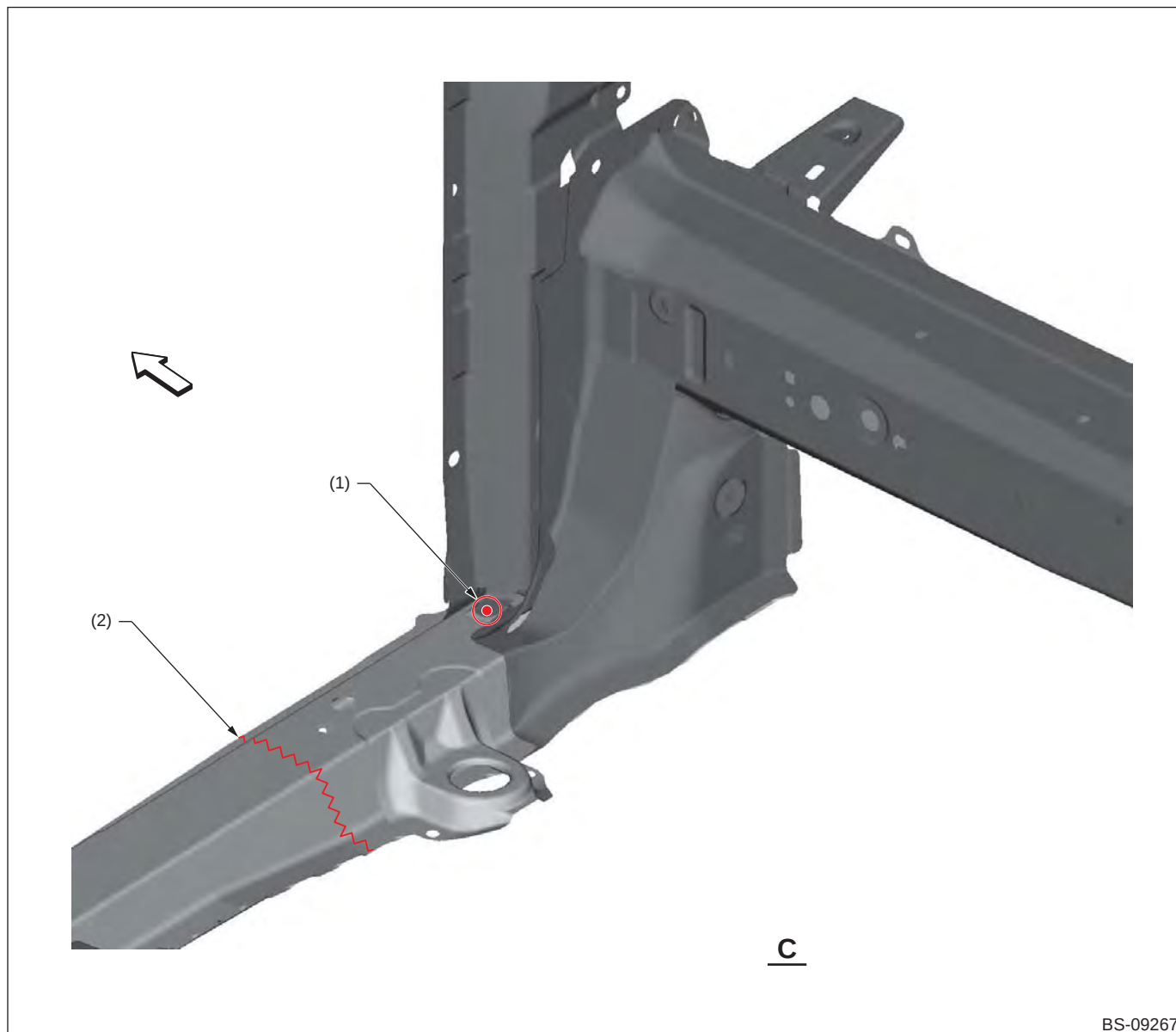
(1) 2 points (bottom · 1)
(2) 3 points (bottom · 1)

(3) 1 point (bottom · 1)

(4) Rough cutting

Panel Replacement

• Views C

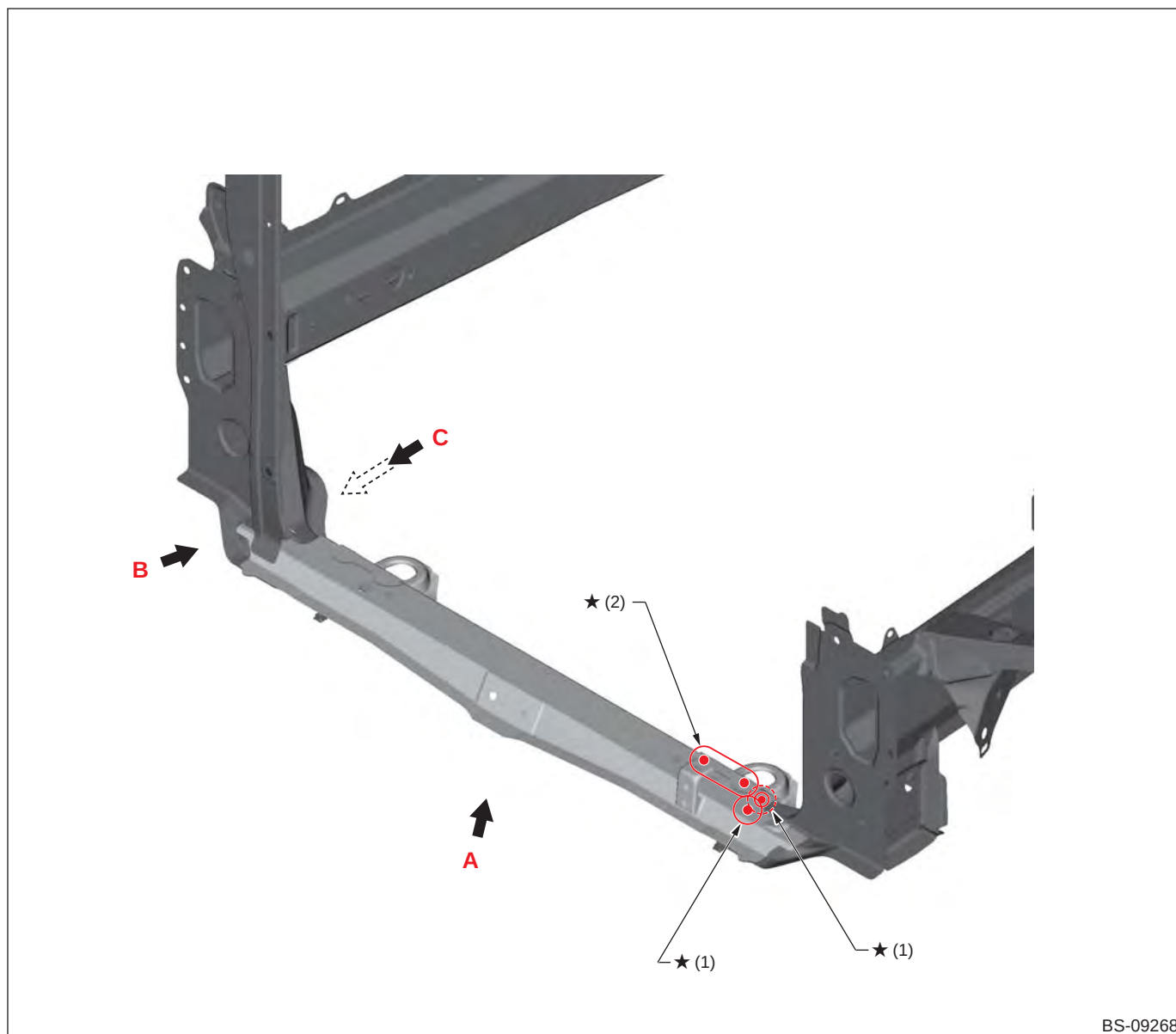


(1) 1 point (top · 1)

(2) Rough cutting

B: INSTALLATION

• Overall view



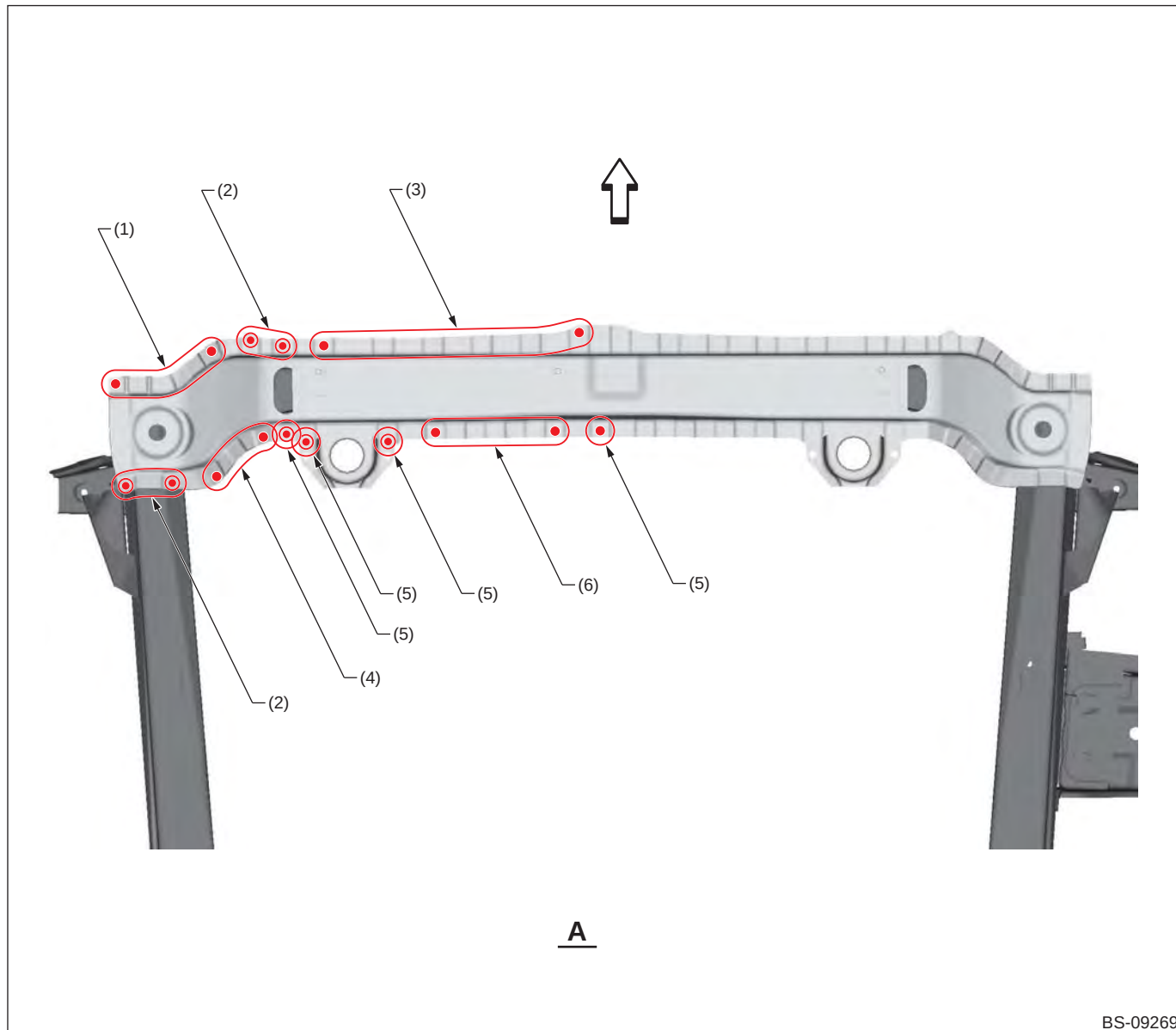
(1) 1 point

(2) 2 points

★: Before radiator B is installed, this point is welded.

Panel Replacement

• Views A



(1) 5 points
(2) 2 points

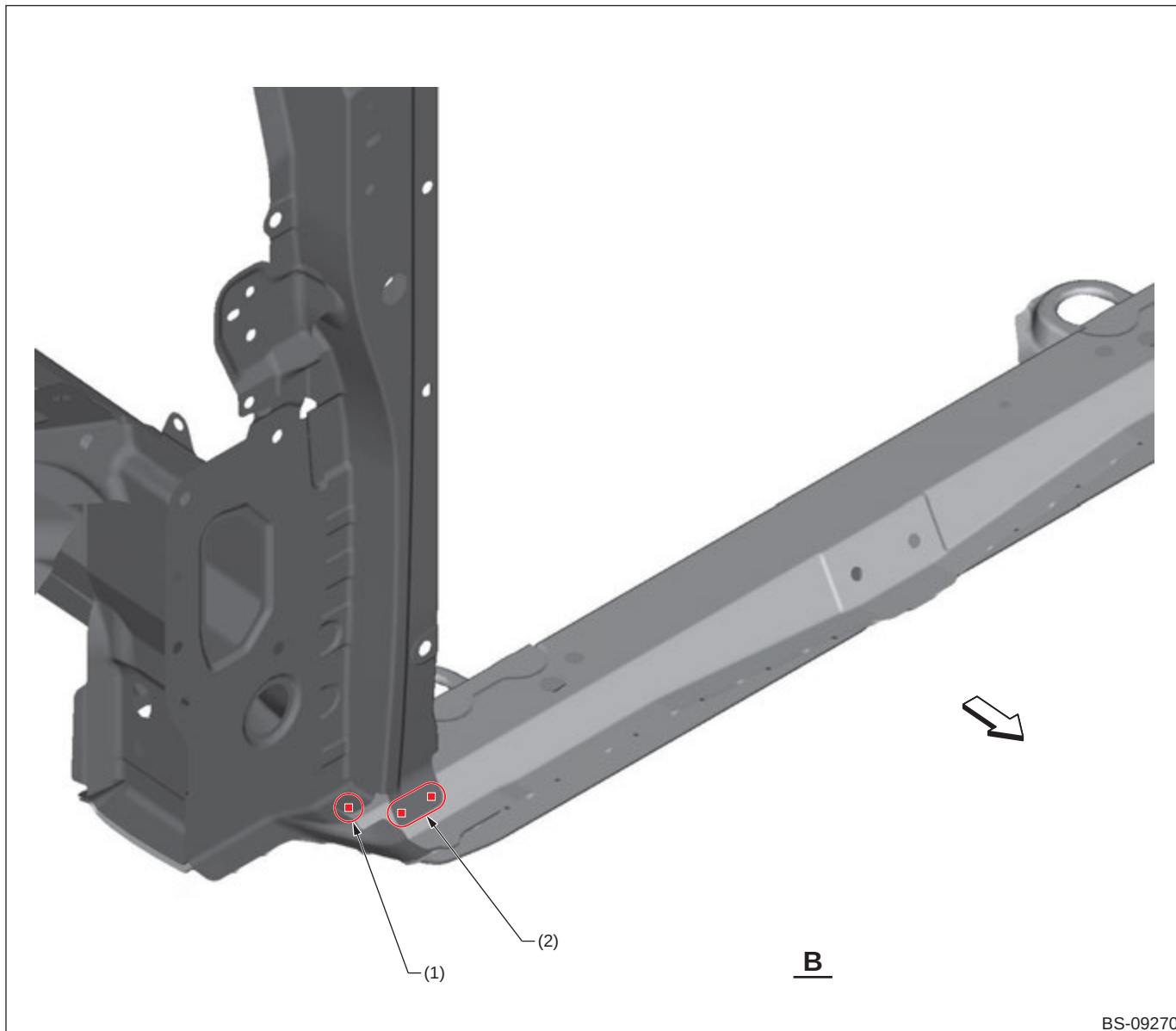
(3) 6 points
(4) 3 points

(5) 1 point
(6) 4 points

BS-09269

Panel Replacement

- Views B

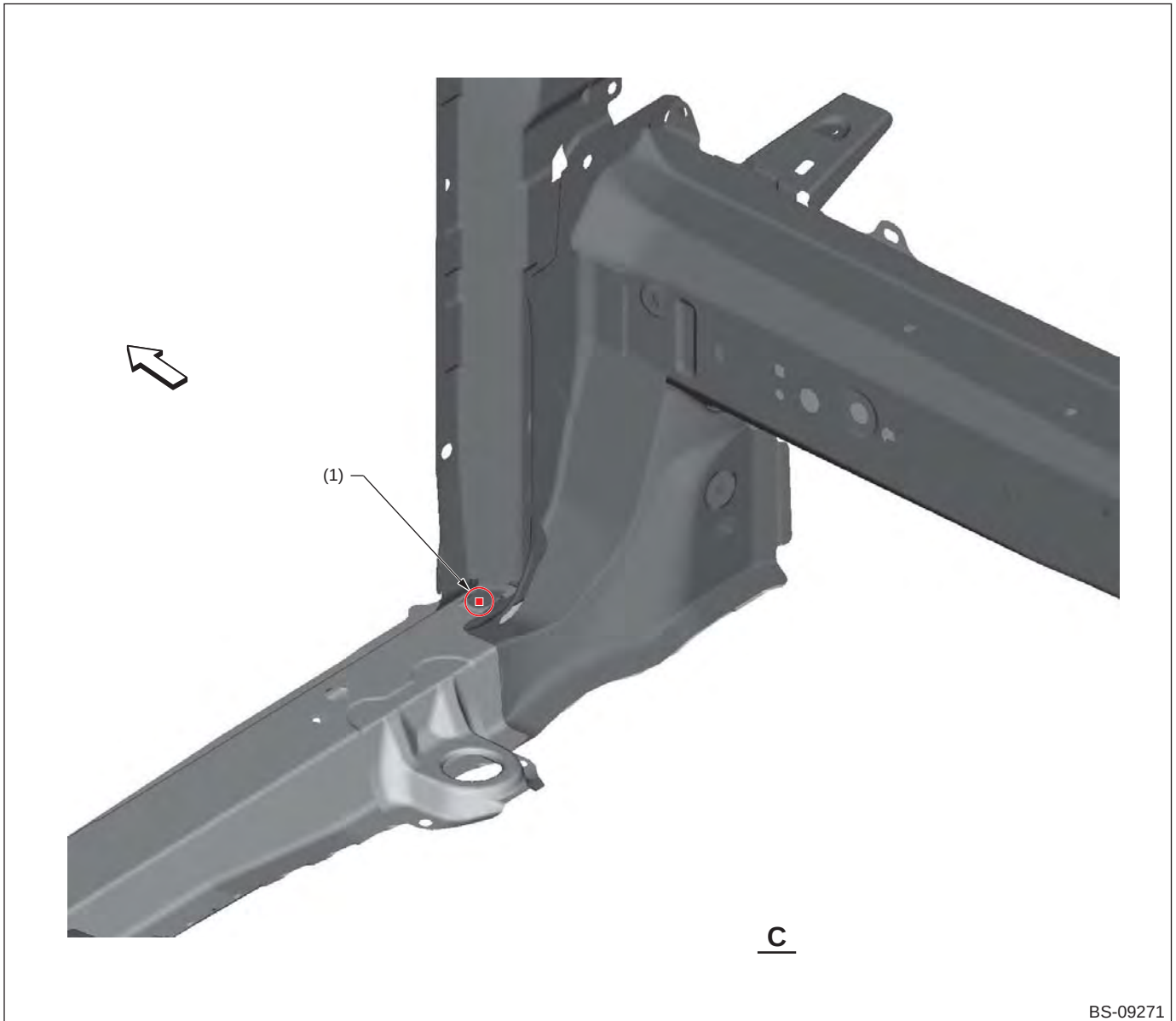


(1) 1 point (service)

(2) 2 points (service)

Panel Replacement

- Views C



BS-09271

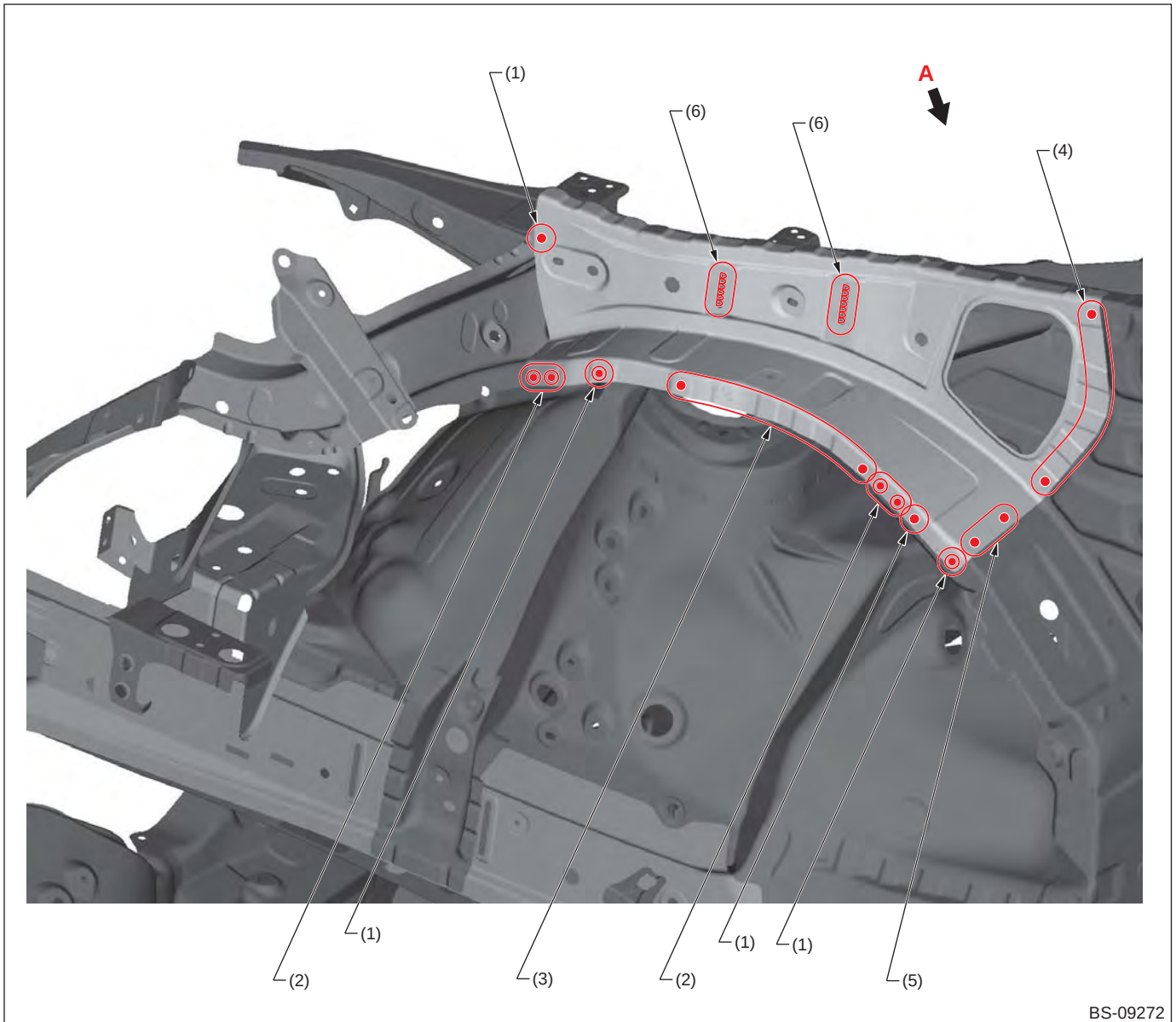
(1) 1 point (service)

Panel Replacement

8-3. Side Upper Frame (Total replacement)

A: REMOVAL

• Overall view 1



BS-09272

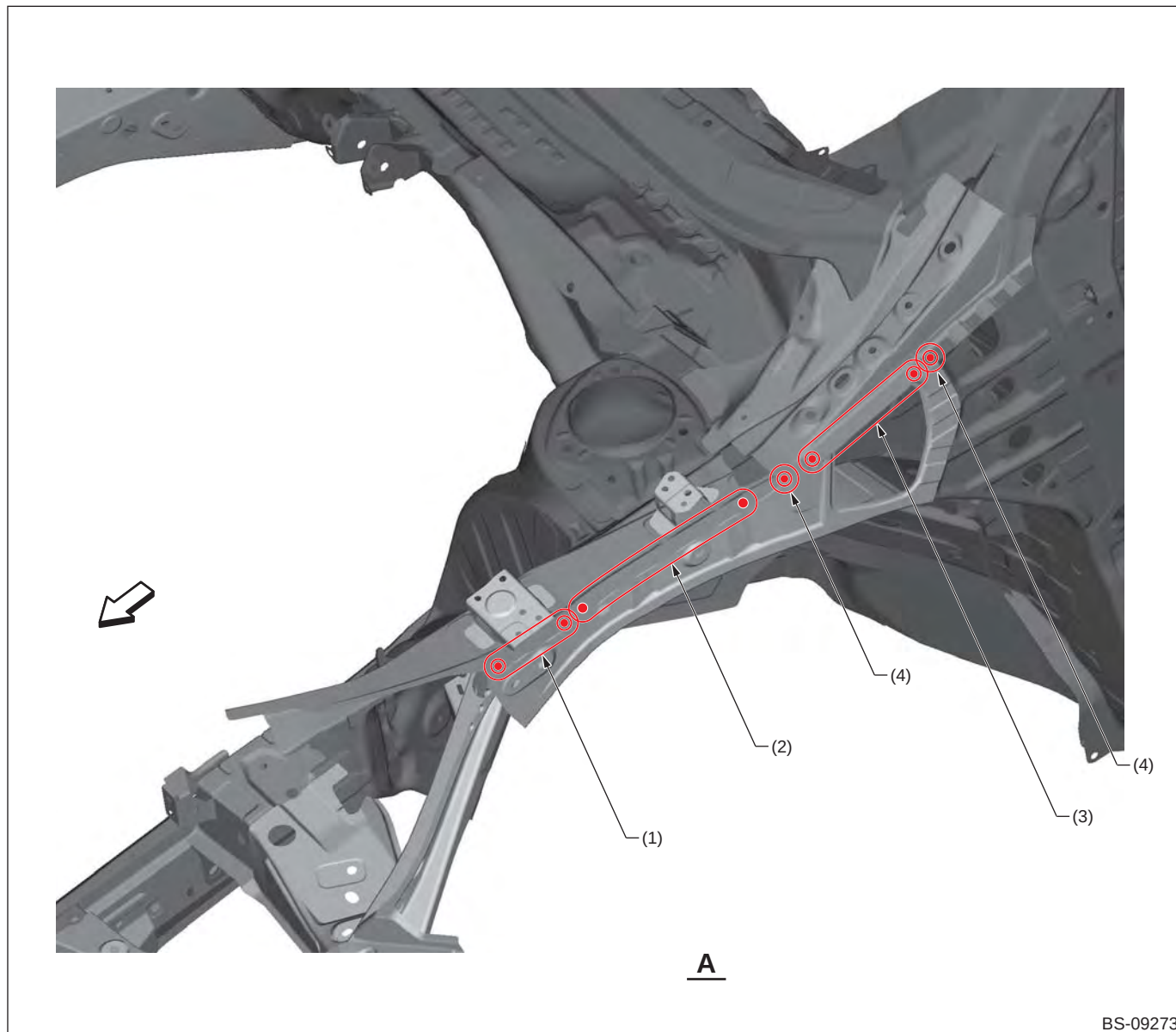
(1) 1 point (outside · 1)
(2) 2 points (outside · 1)

(3) 6 points (outside · 1)
(4) 5 points (outside · 1)

(5) 3 points (outside · 1)
(6) 1 point (outside · 1 belt sander)

Panel Replacement

• Views A



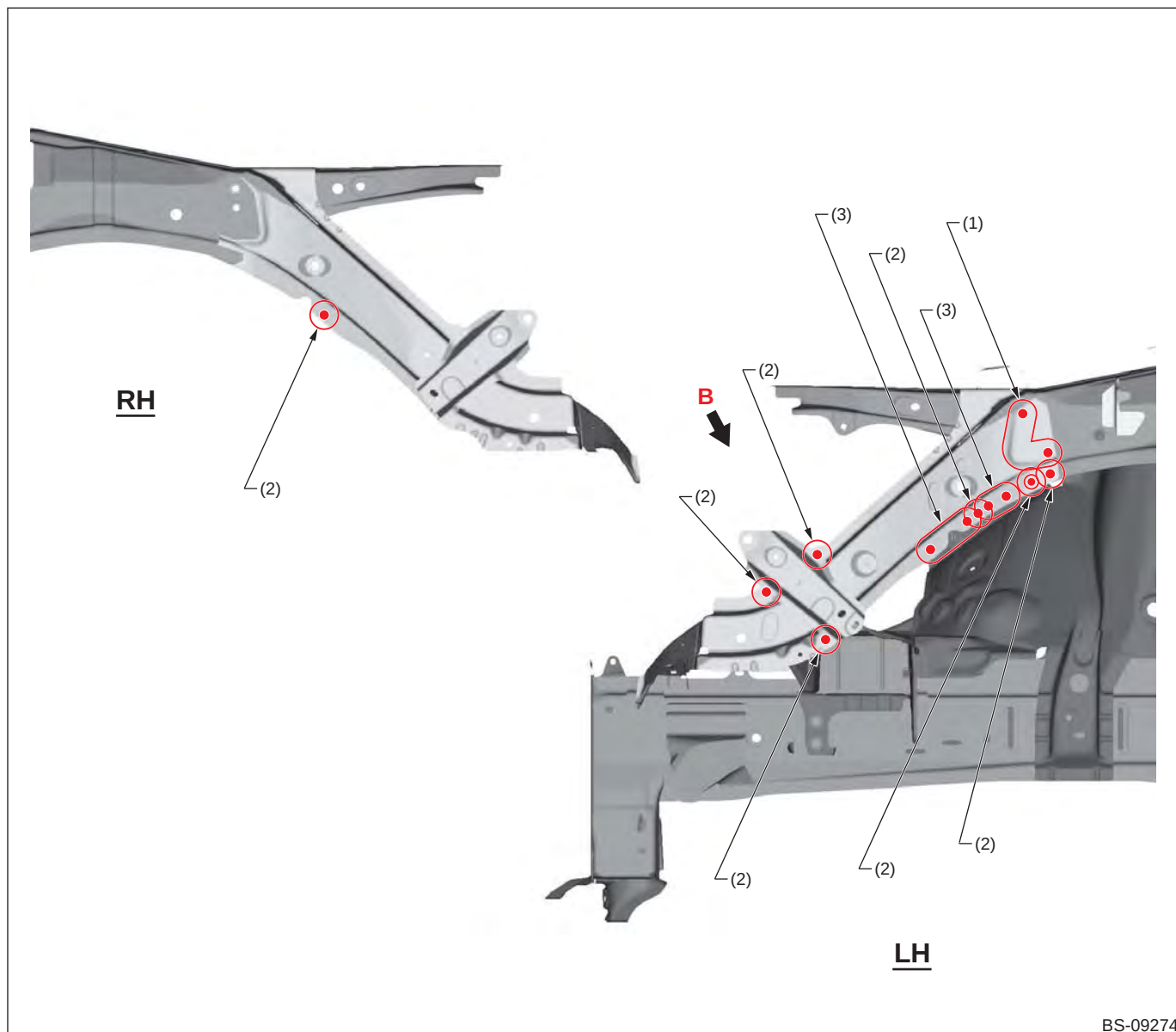
(1) 2 points (bottom · 1)
(2) 5 points (bottom · 1)

(3) 3 points (bottom · 1)

(4) 1 point (bottom · 1)

Panel Replacement

• Overall view 2



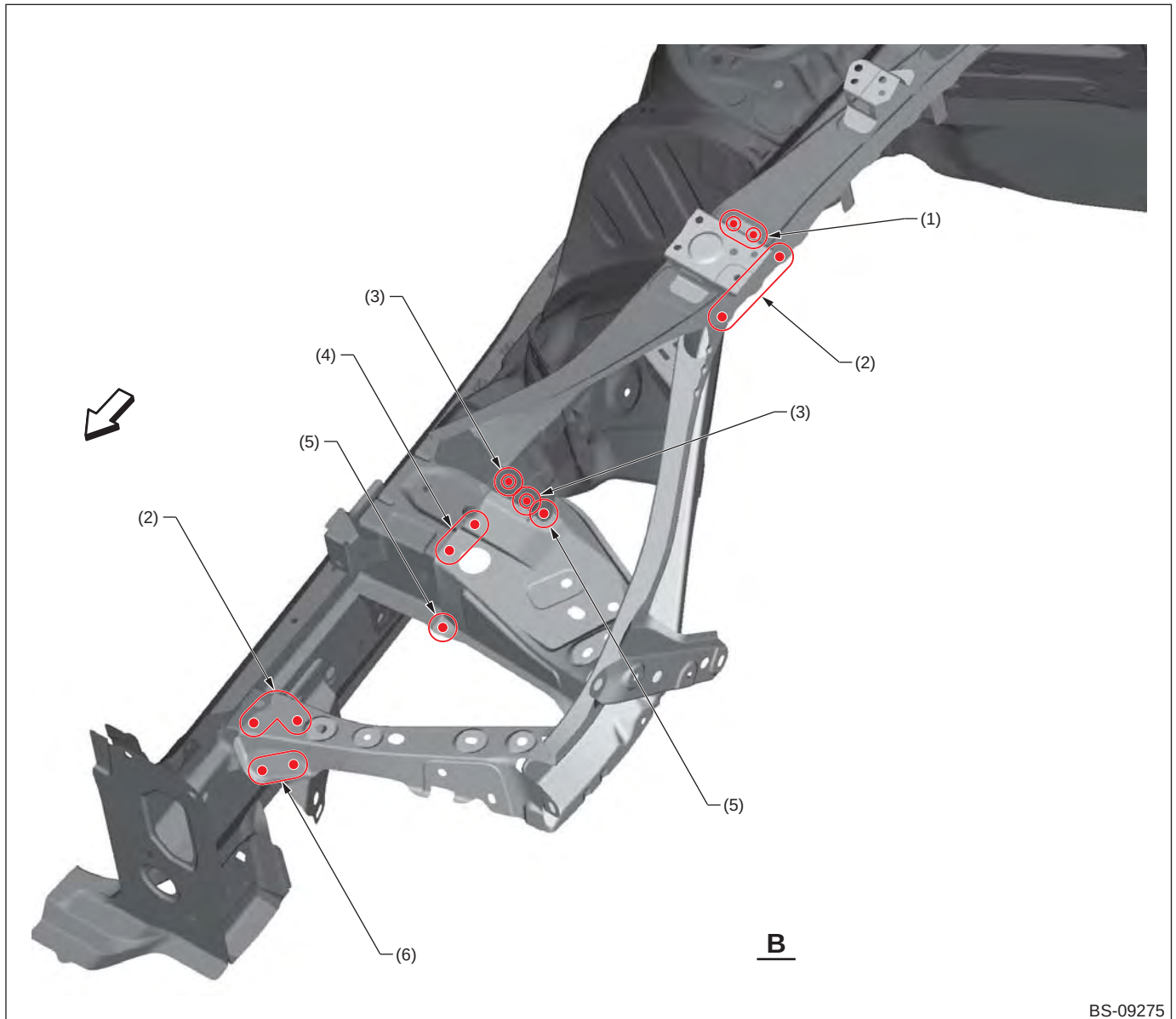
(1) 3 points (outside · 1)

(2) 1 point (outside · 1)

(3) 2 points (outside · 1)

Panel Replacement

• Views B (LH)



BS-09275

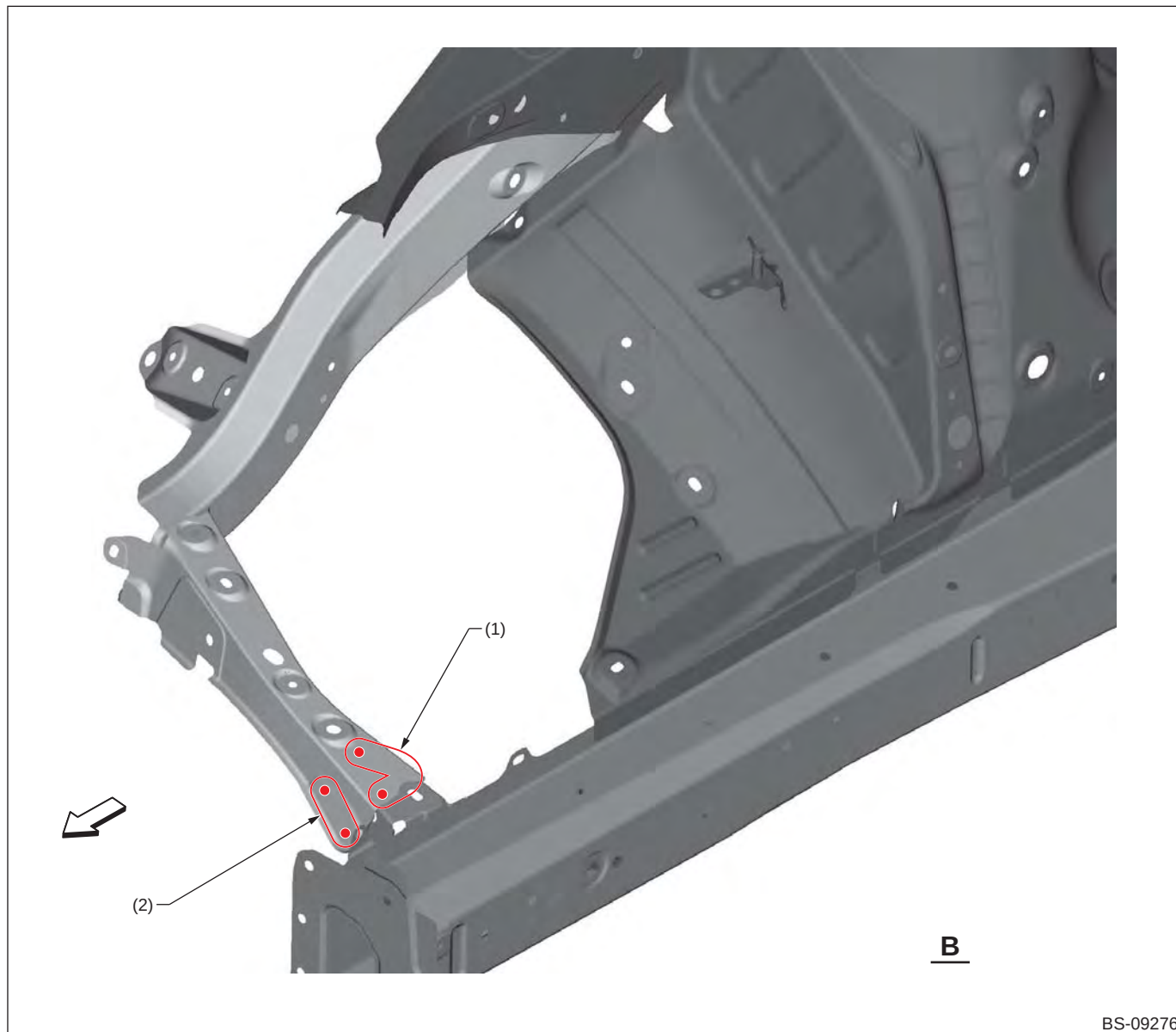
(1) 2 points (top · 2)
(2) 3 points (top · 1)

(3) 1 point (top · 2)
(4) 2 points (top · 1)

(5) 1 point (top · 1)
(6) 2 points (outside · 1)

Panel Replacement

- Views B (RH)



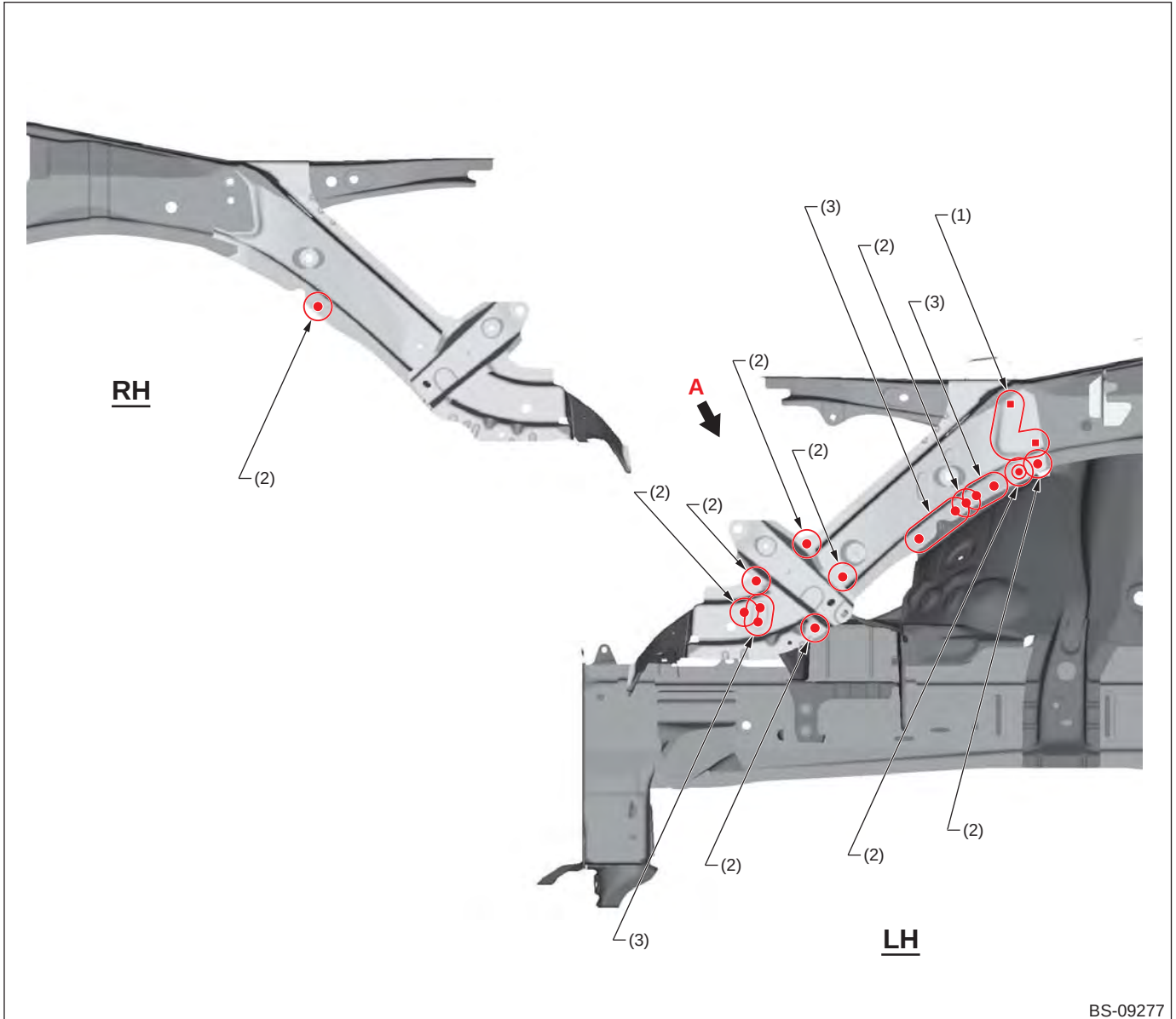
(1) 3 points (top · 1)

(2) 2 points (outside · 1)

Panel Replacement

B: INSTALLATION

• Overall view 1



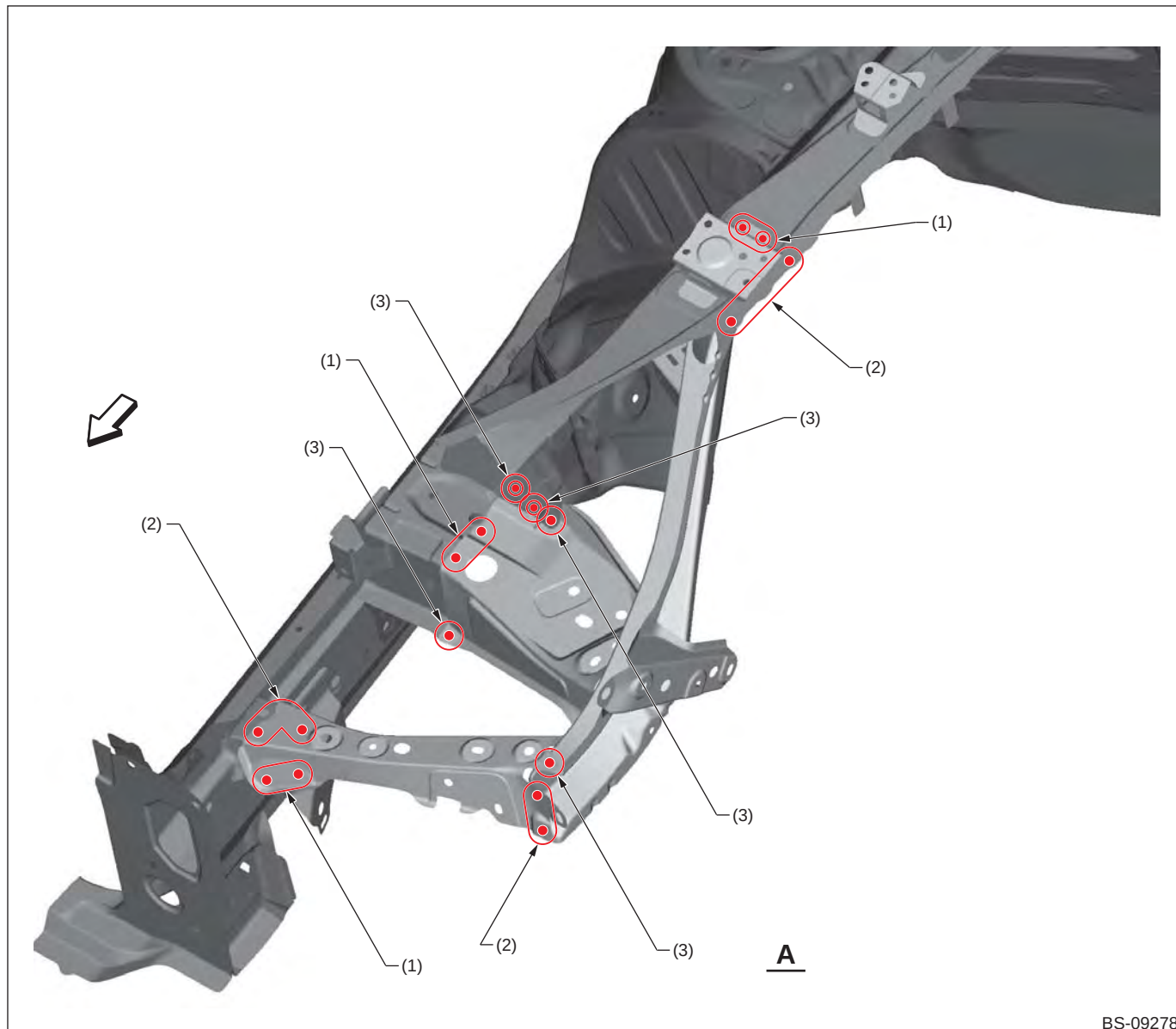
(1) 3 points (service)

(2) 1 point

(3) 2 points

Panel Replacement

• Views A (LH)



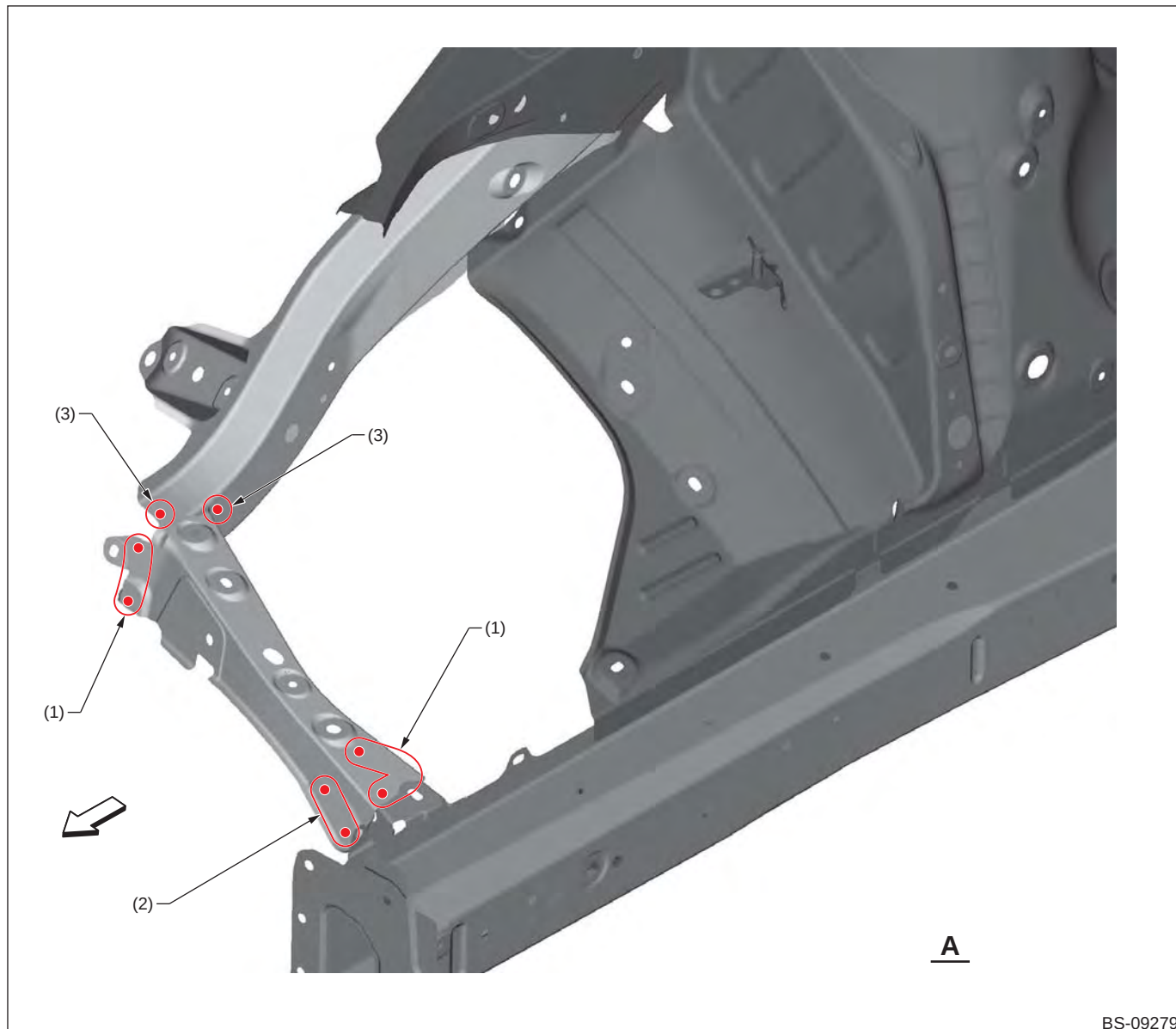
(1) 2 points

(2) 3 points

(3) 1 point

Panel Replacement

• Views A (RH)



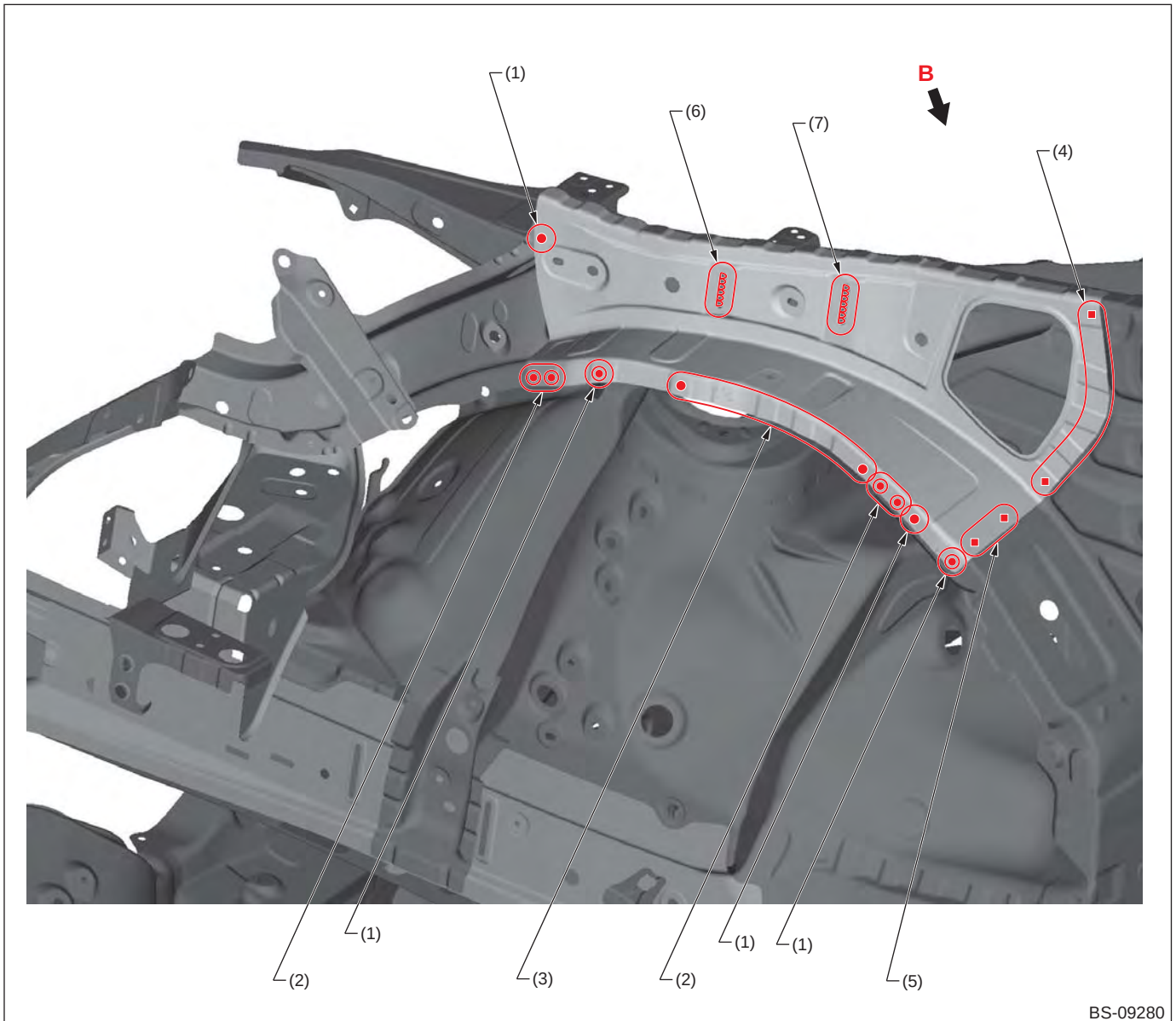
(1) 3 points

(2) 2 points

(3) 1 point

Panel Replacement

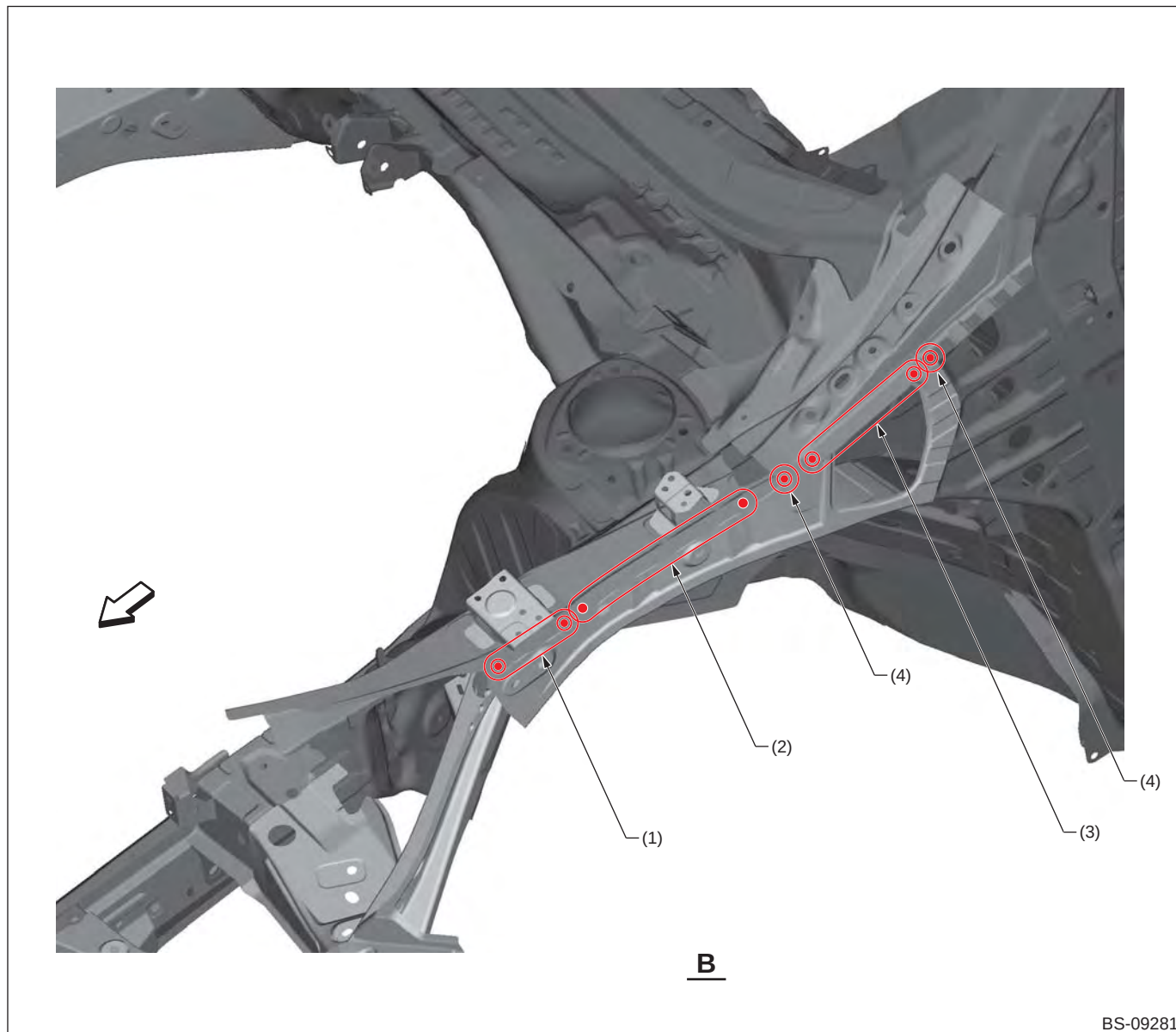
• Overall view 2



- | | | |
|--------------|---|---|
| (1) 1 point | (4) 5 points (service) | (7) 1 point (Continuous welding)
(19 mm [0.75 in]) |
| (2) 2 points | (5) 3 points (service) | |
| (3) 6 points | (6) 1 point (Continuous welding)
(14 mm [0.55 in]) | |

Panel Replacement

• Views B



(1) 2 points
(2) 5 points

(3) 3 points

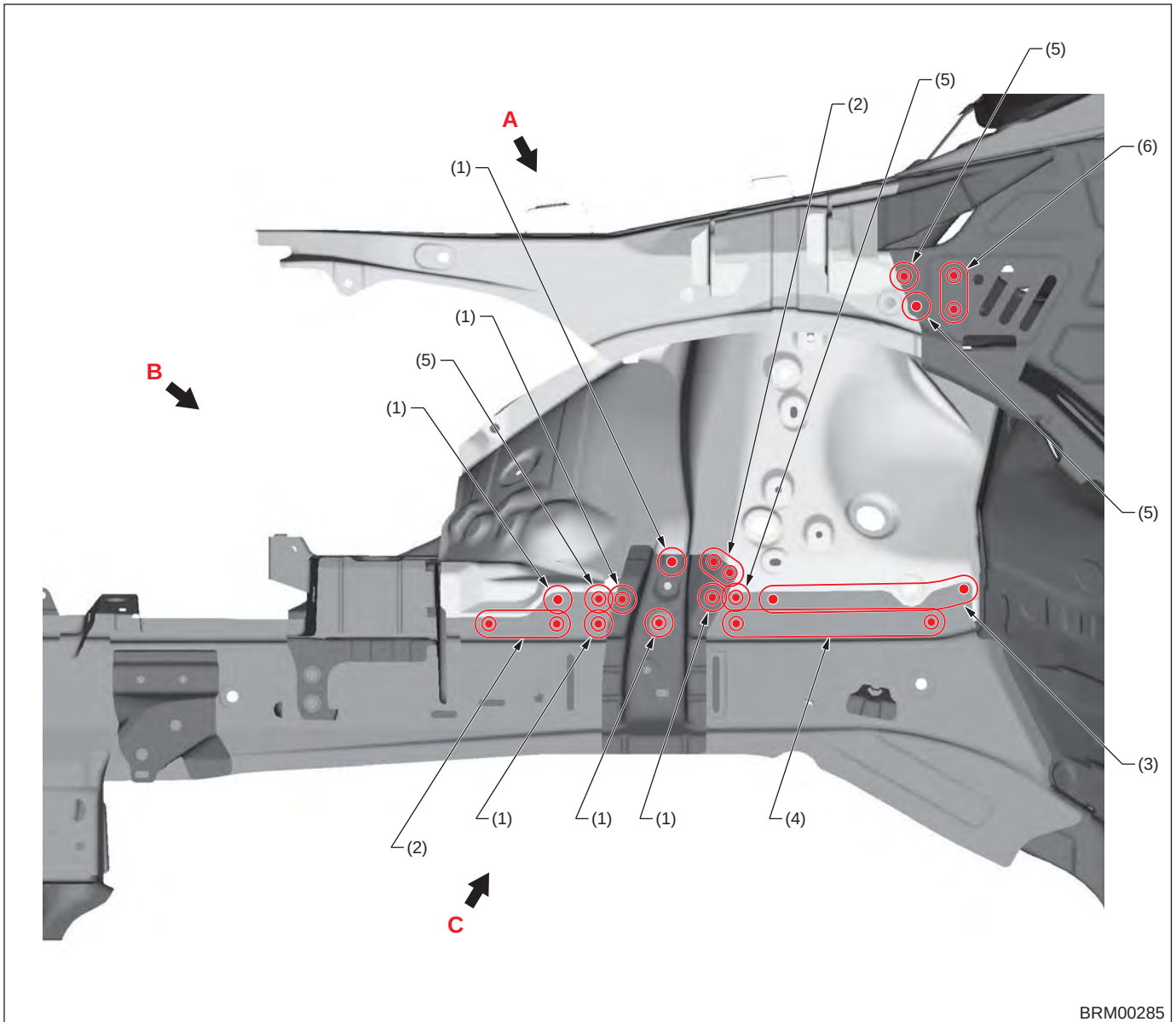
(4) 1 point

Panel Replacement

8-4. Front Wheel Apron (Total replacement)

A: REMOVAL

• Overall view



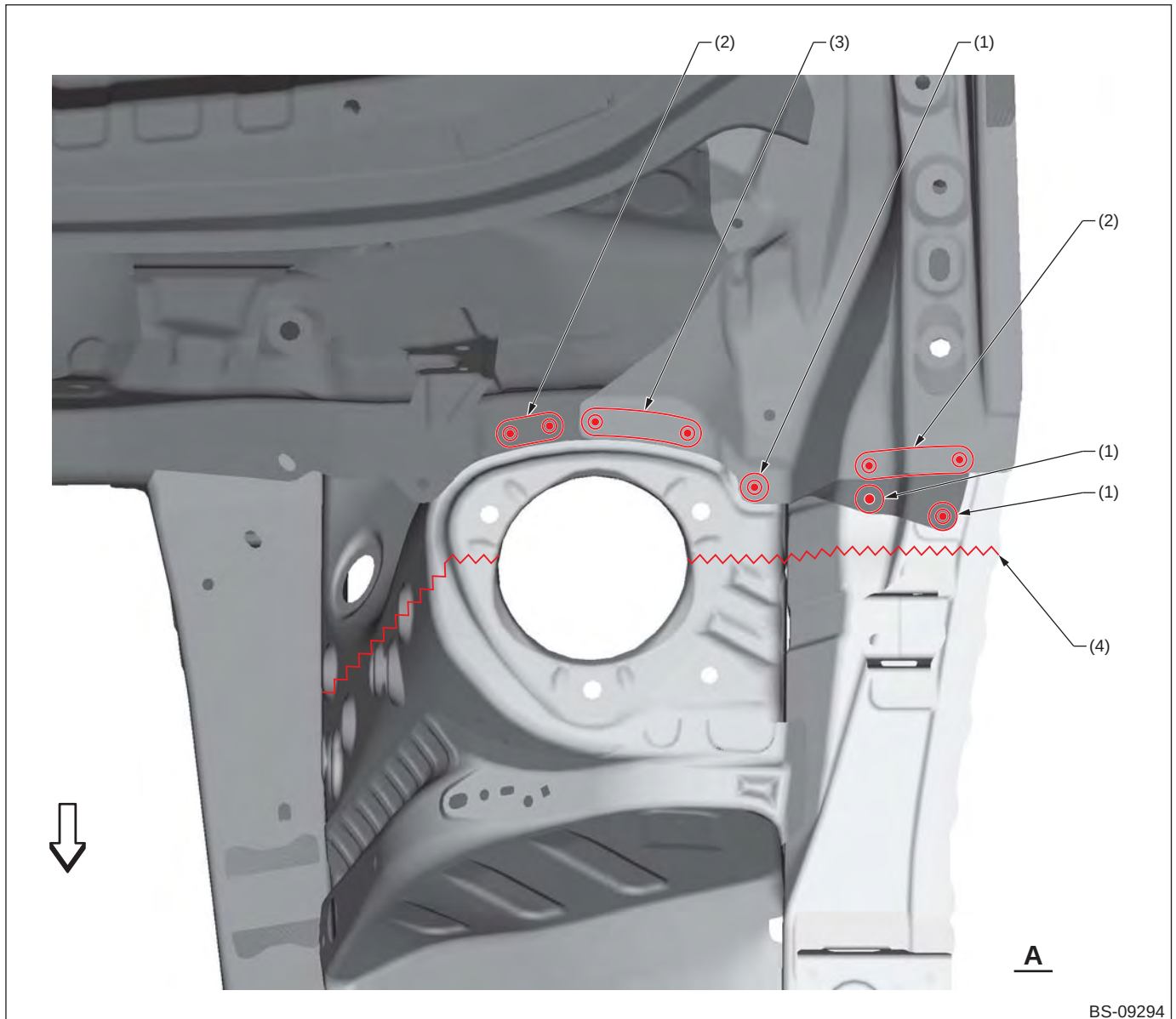
(1) 1 point (inside · 1)
(2) 2 points (inside · 1)

(3) 6 points (inside · 1)
(4) 4 points (inside · 1)

(5) 1 point (outside · 1)
(6) 2 points (outside · 1)

Panel Replacement

• Views A



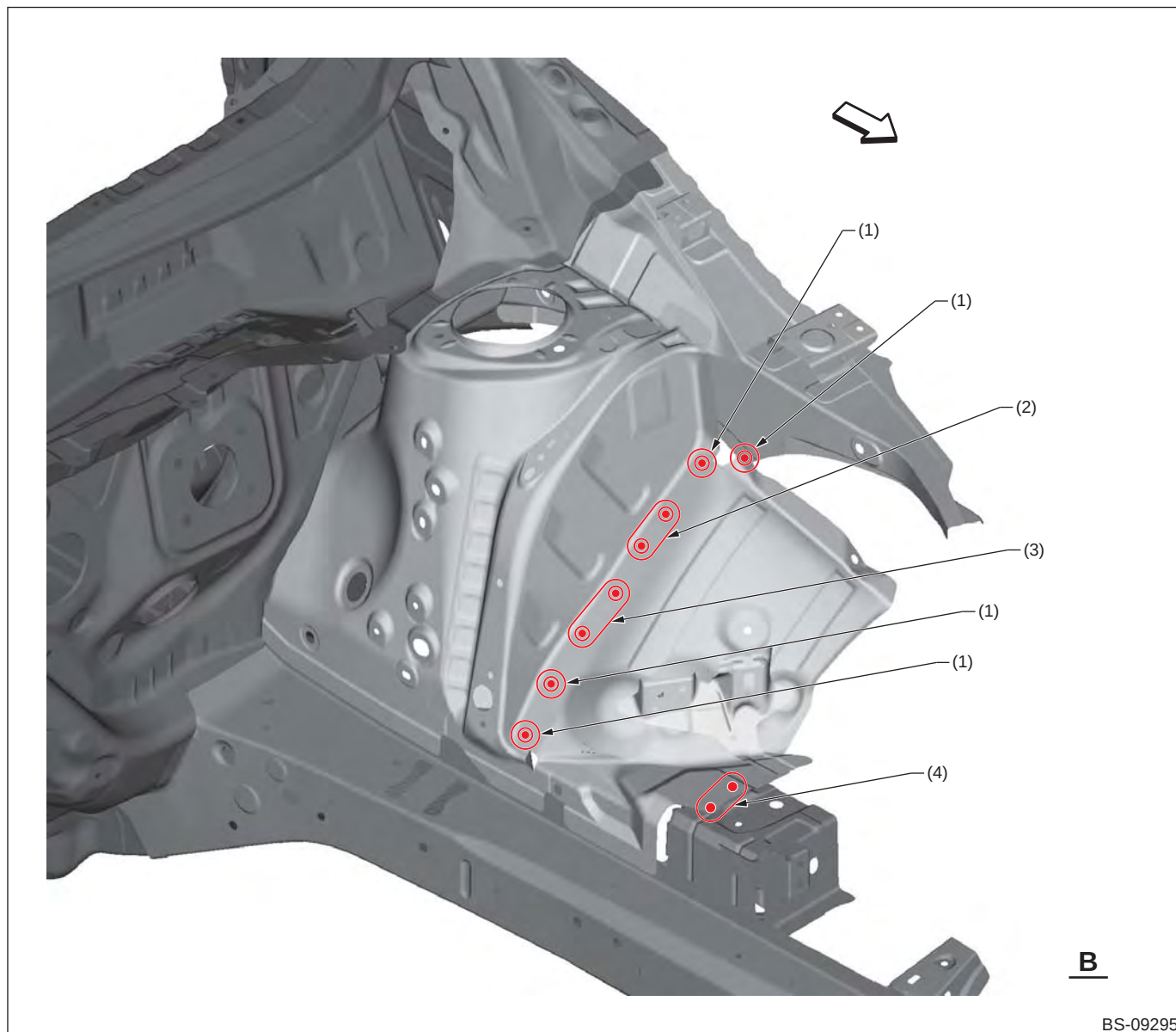
- (1) 1 point (bottom · 1)
(2) 2 points (bottom · 1)

- (3) 3 points (bottom · 1)

- (4) Rough cutting

Panel Replacement

• Views B (LH)



BS-09295

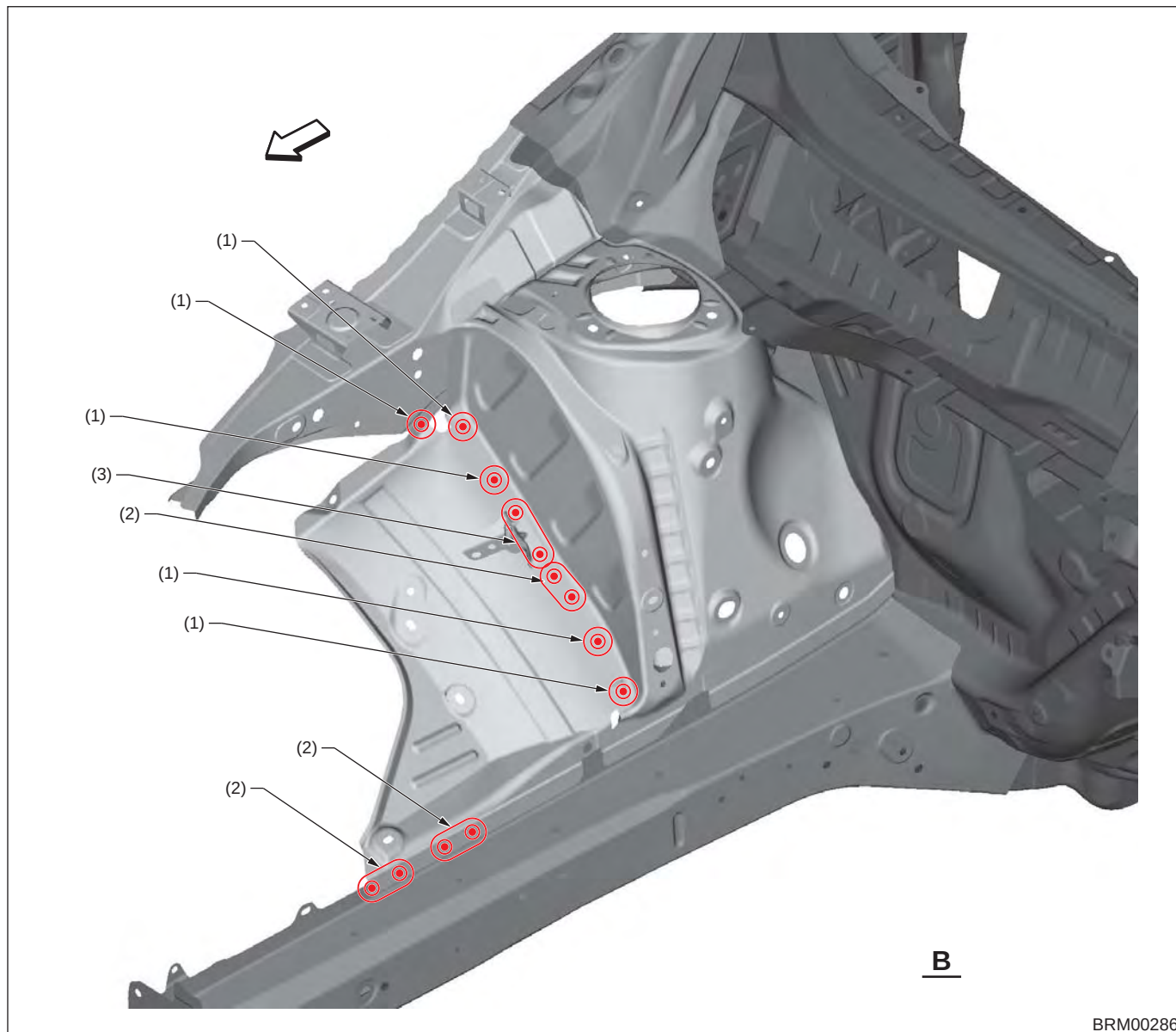
- (1) 1 point (inside · 1)
(2) 2 points (inside · 1)

- (3) 3 points (inside · 1)

- (4) 2 points (top · 1)

Panel Replacement

• Views B (RH)



BRM00286

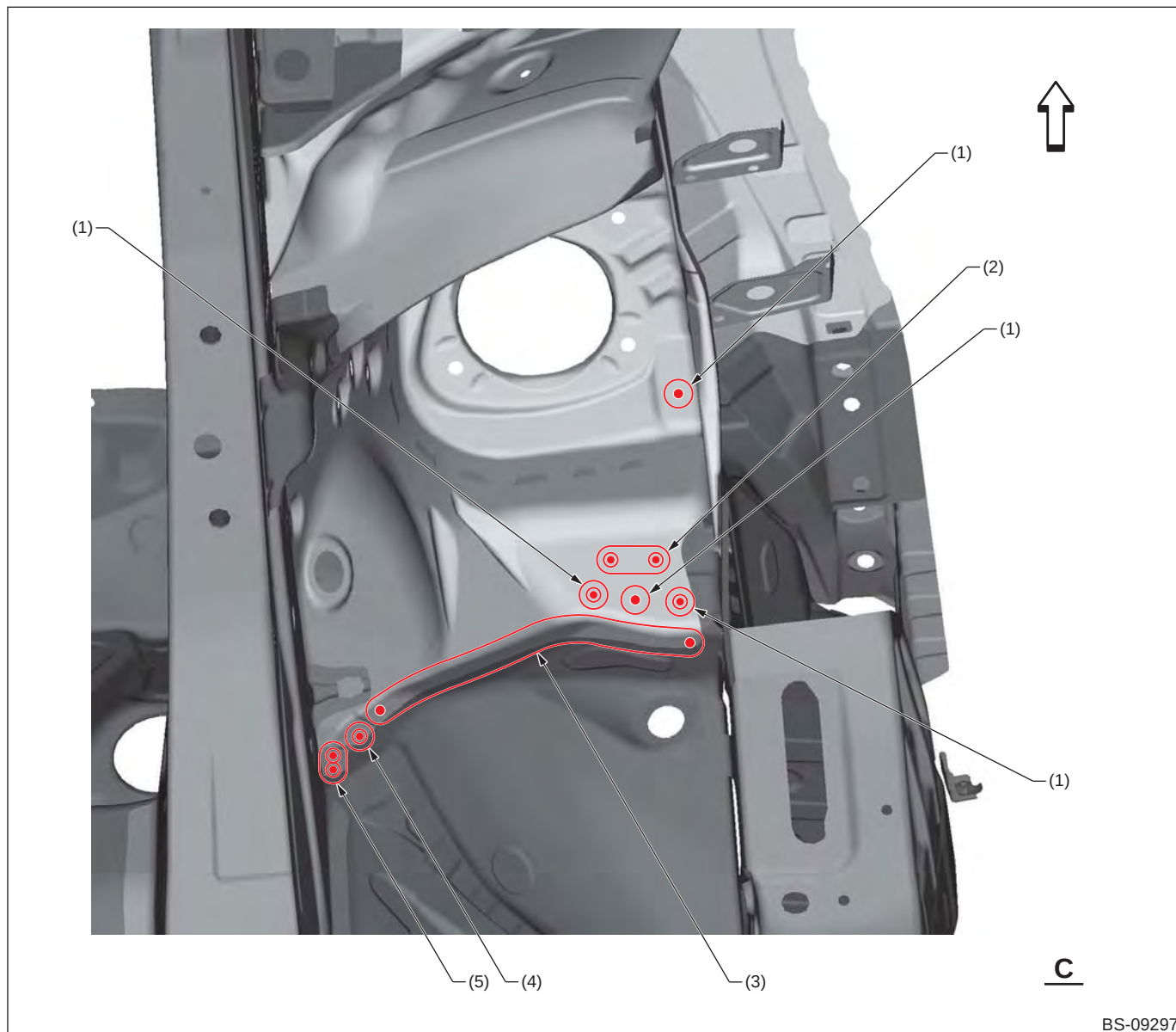
(1) 1 point (inside · 1)

(2) 2 points (inside · 1)

(3) 2 points (inside · 2)

Panel Replacement

• Views C



BS-09297

(1) 1 point (bottom · 1)
(2) 2 points (bottom · 1)

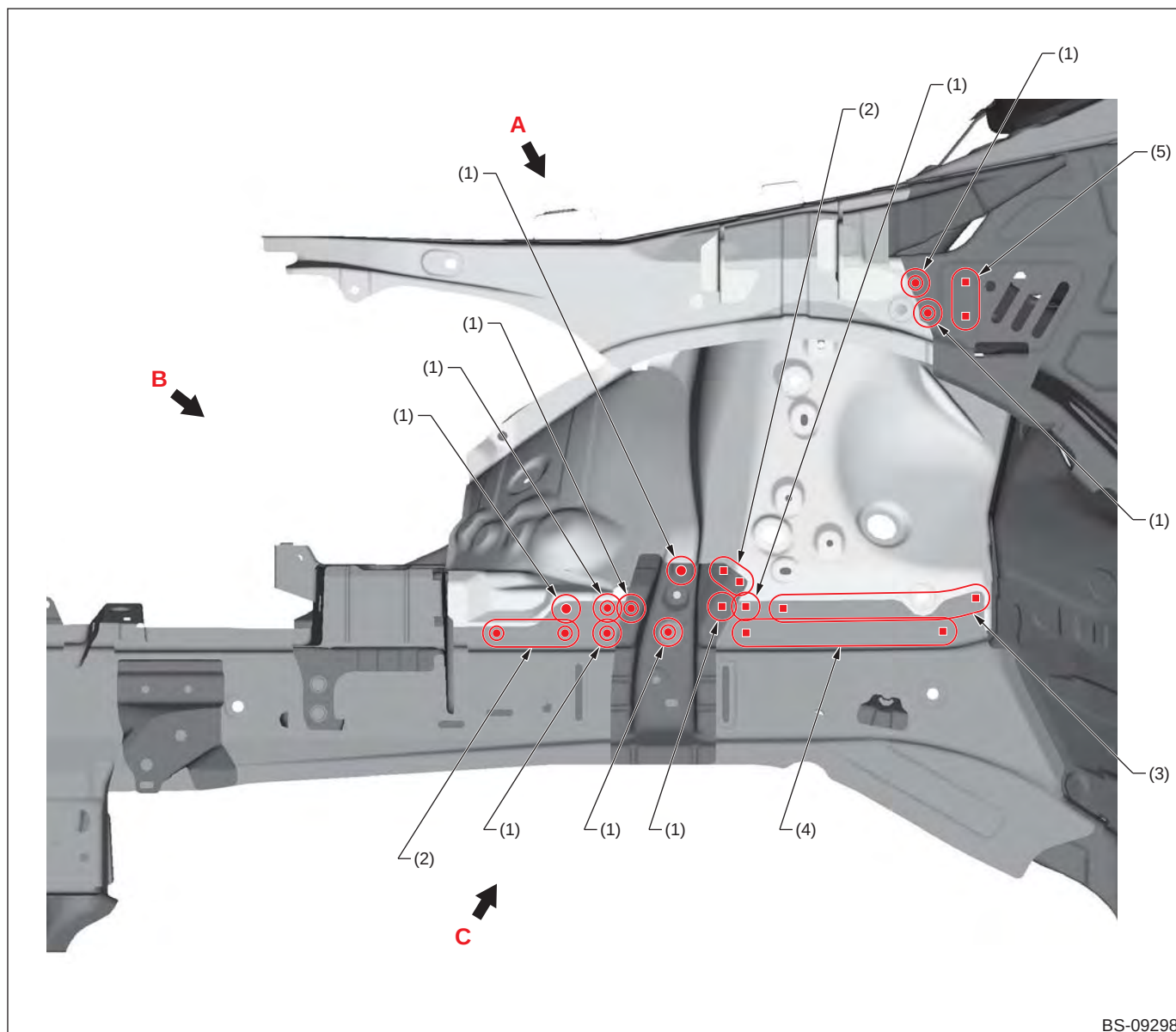
(3) 8 points (outside · 1)
(4) 1 point (outside · 1)

(5) 2 points (outside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



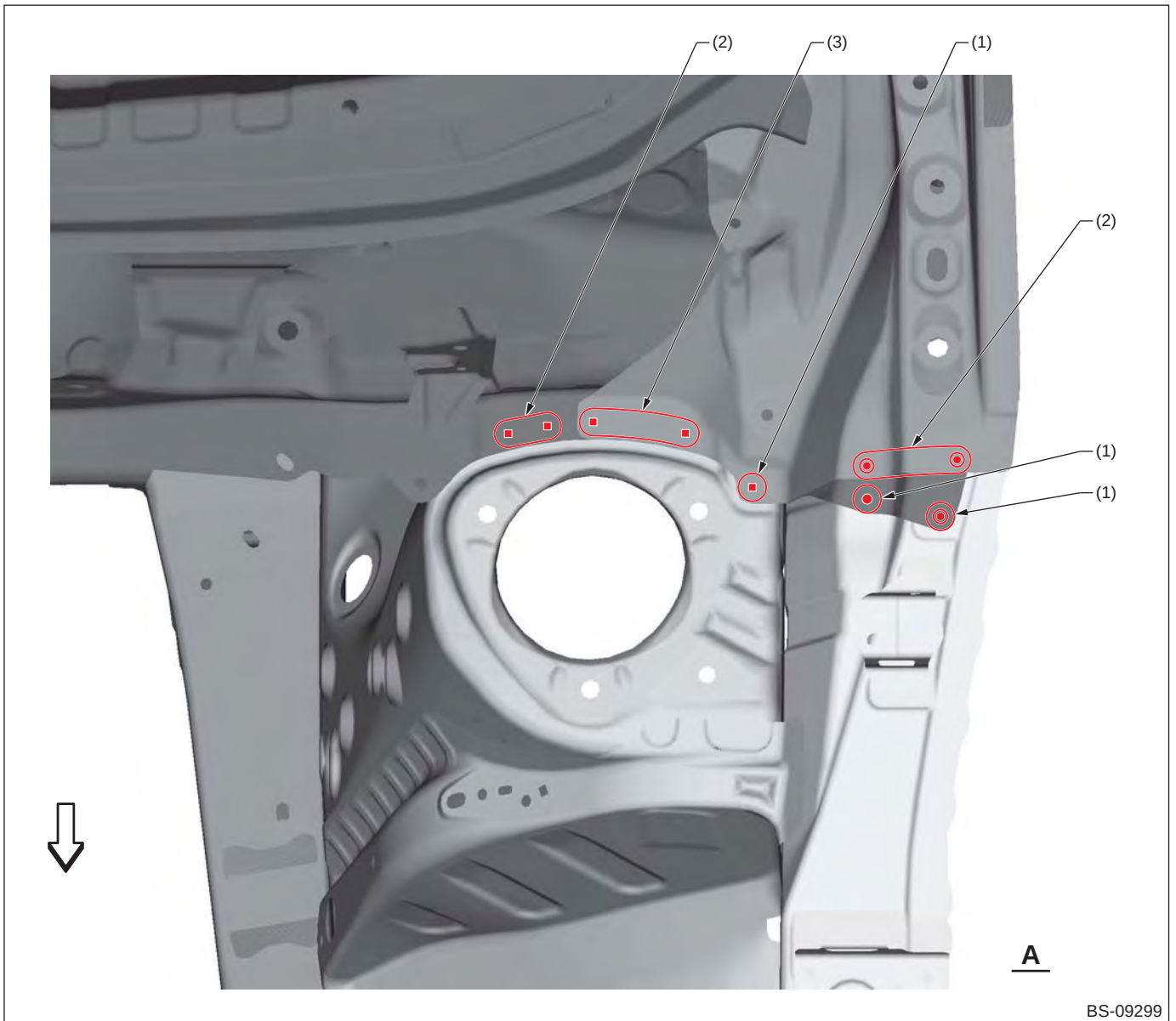
(1) 1 point
(2) 2 points

(3) 6 points
(4) 4 points

(5) 2 points (service · matching)

Panel Replacement

• Views A



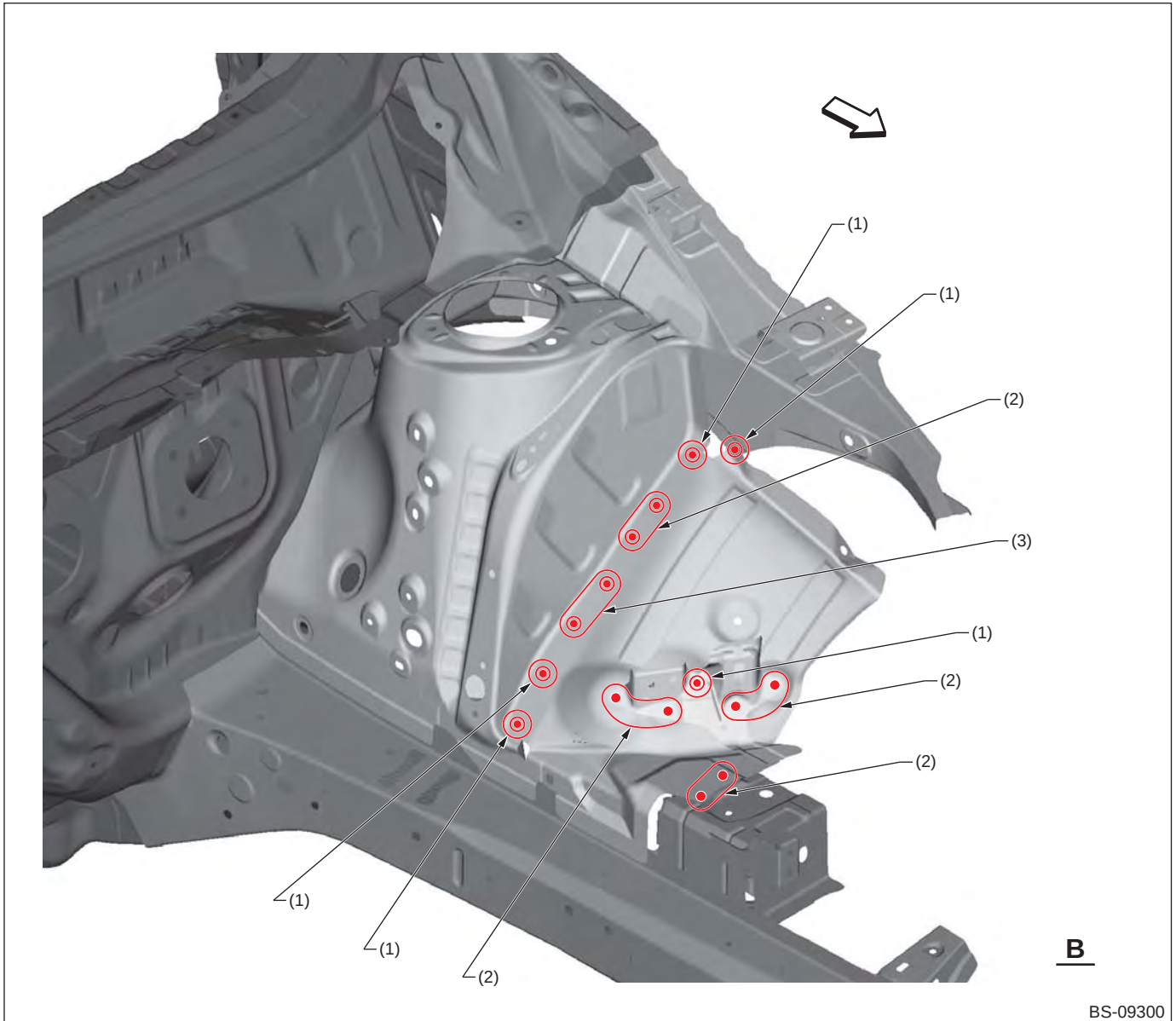
(1) 1 point

(2) 2 points

(3) 3 points

Panel Replacement

• Views B (LH)



BS-09300

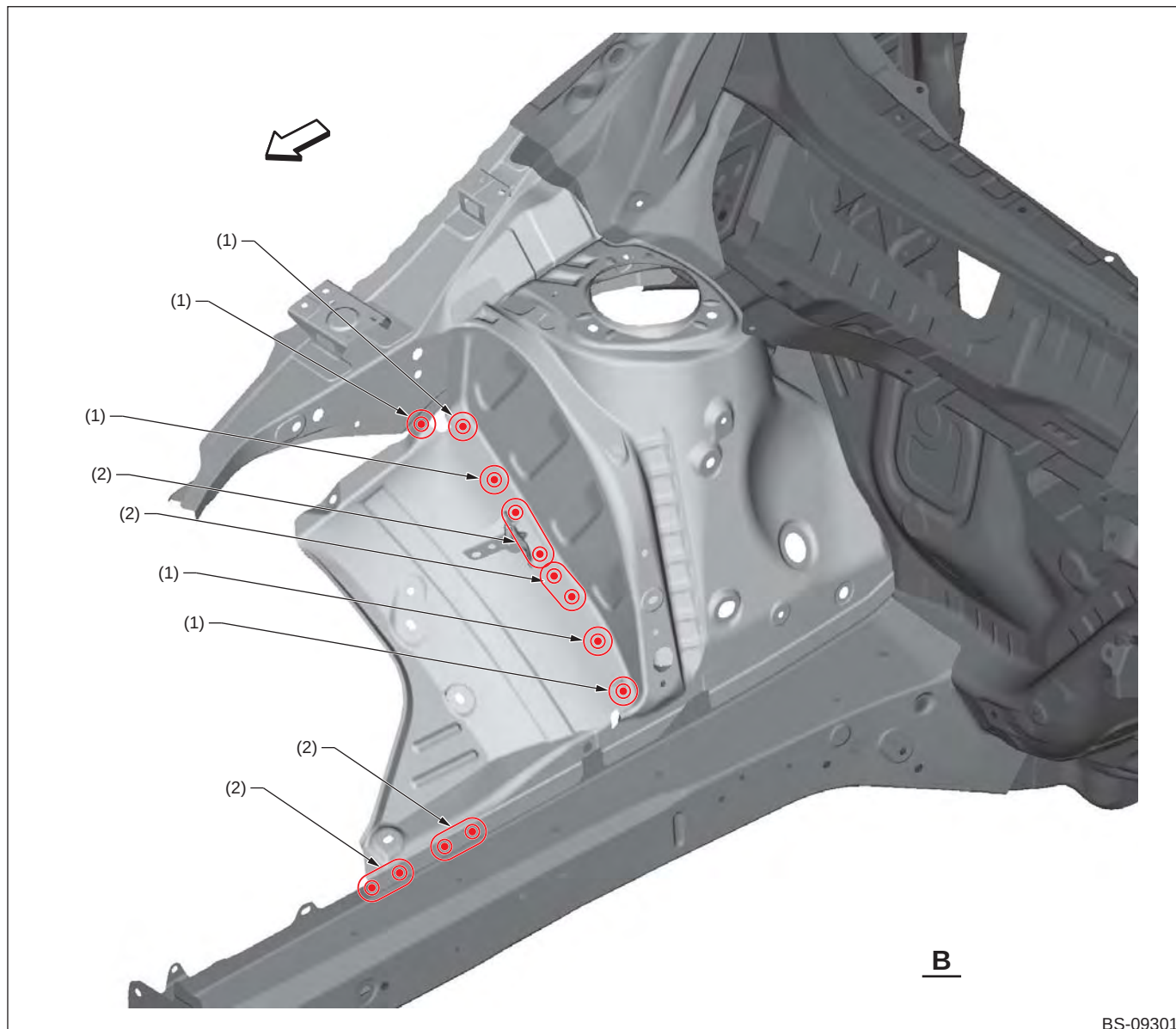
(1) 1 point

(2) 2 points

(3) 3 points

Panel Replacement

• Views B (RH)

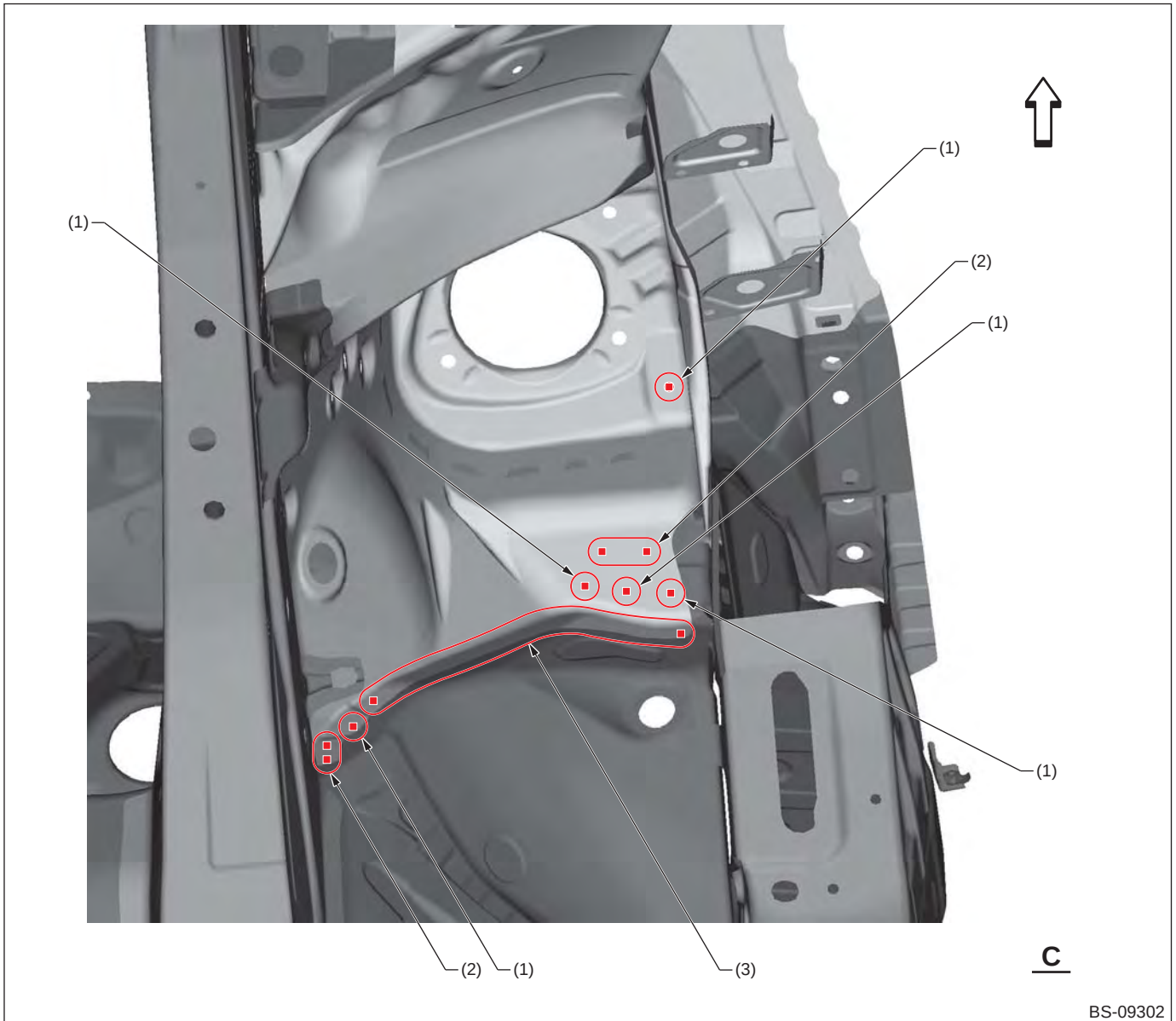


BS-09301

(1) 1 point

(2) 2 points

- **Views C**



BS-09302

(1) 1 point (service)

(2) 2 points (service)

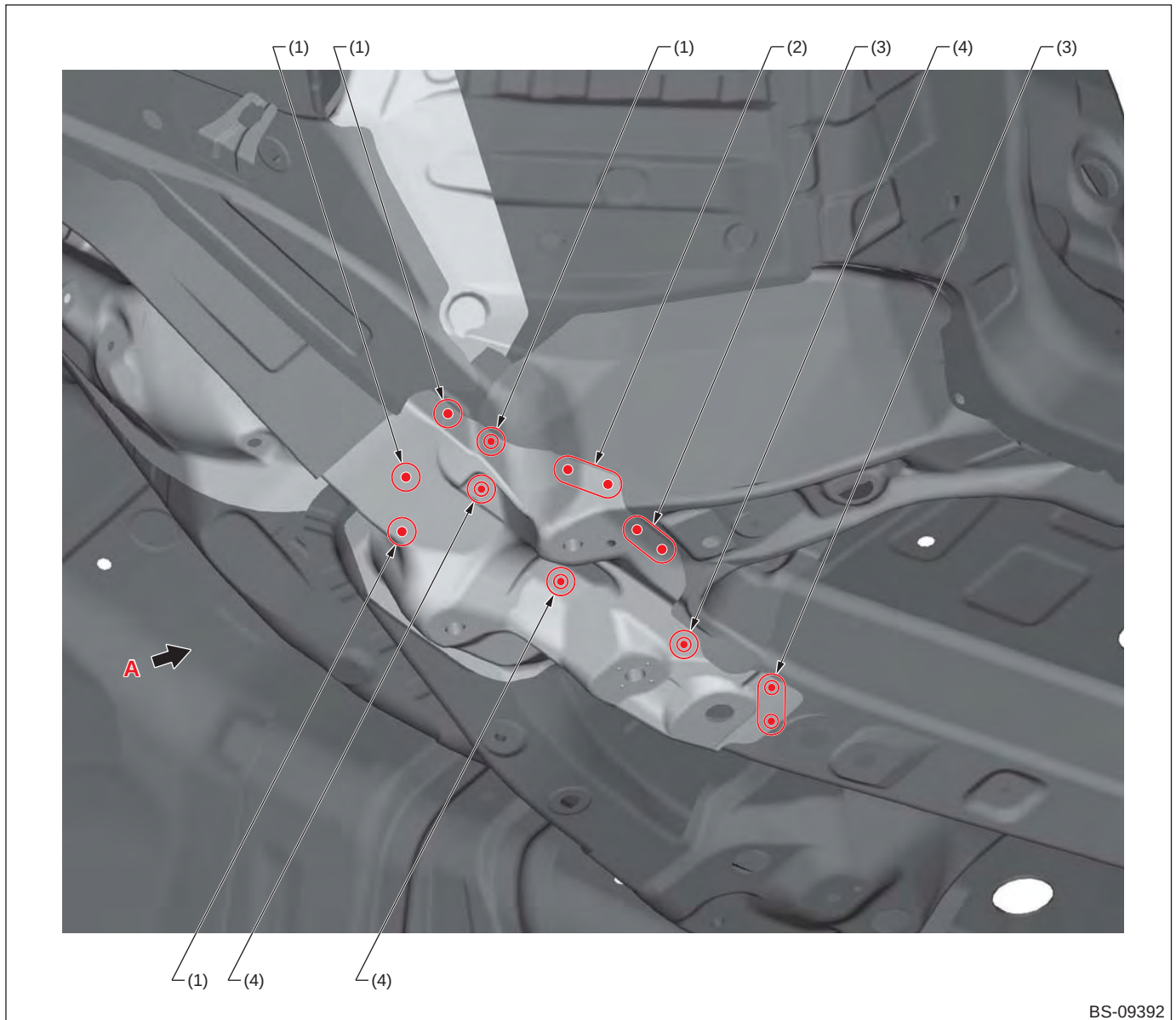
(3) 8 points (service)

Panel Replacement

8-5. Toe Board Reinforcement (Total replacement)

A: REMOVAL

• Overall view 1



BS-09392

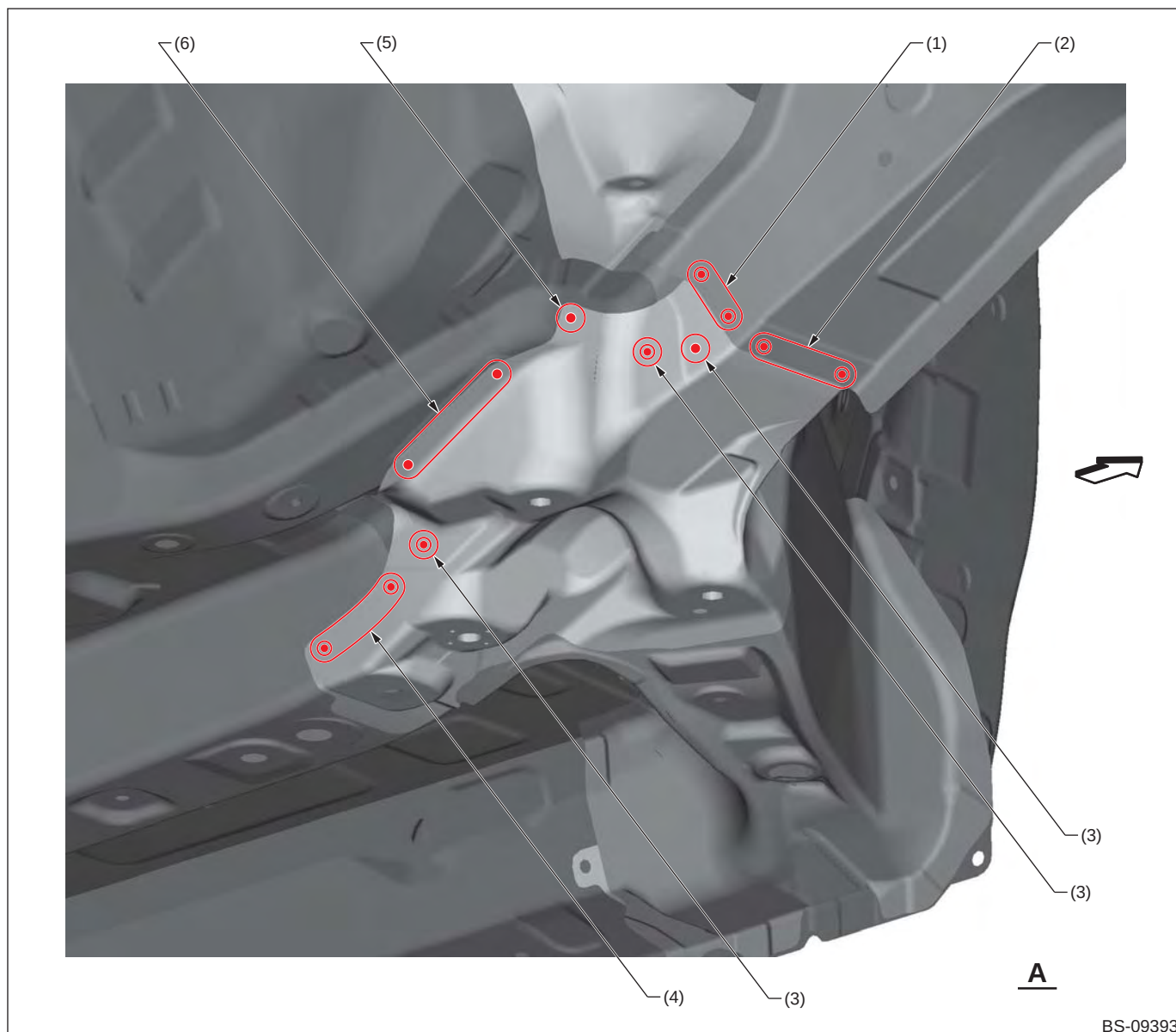
- (1) 1 point (outside · 1)
(2) 2 points (outside · 1)

- (3) 2 points (bottom · 1)

- (4) 1 point (bottom · 1)

Panel Replacement

• Views A



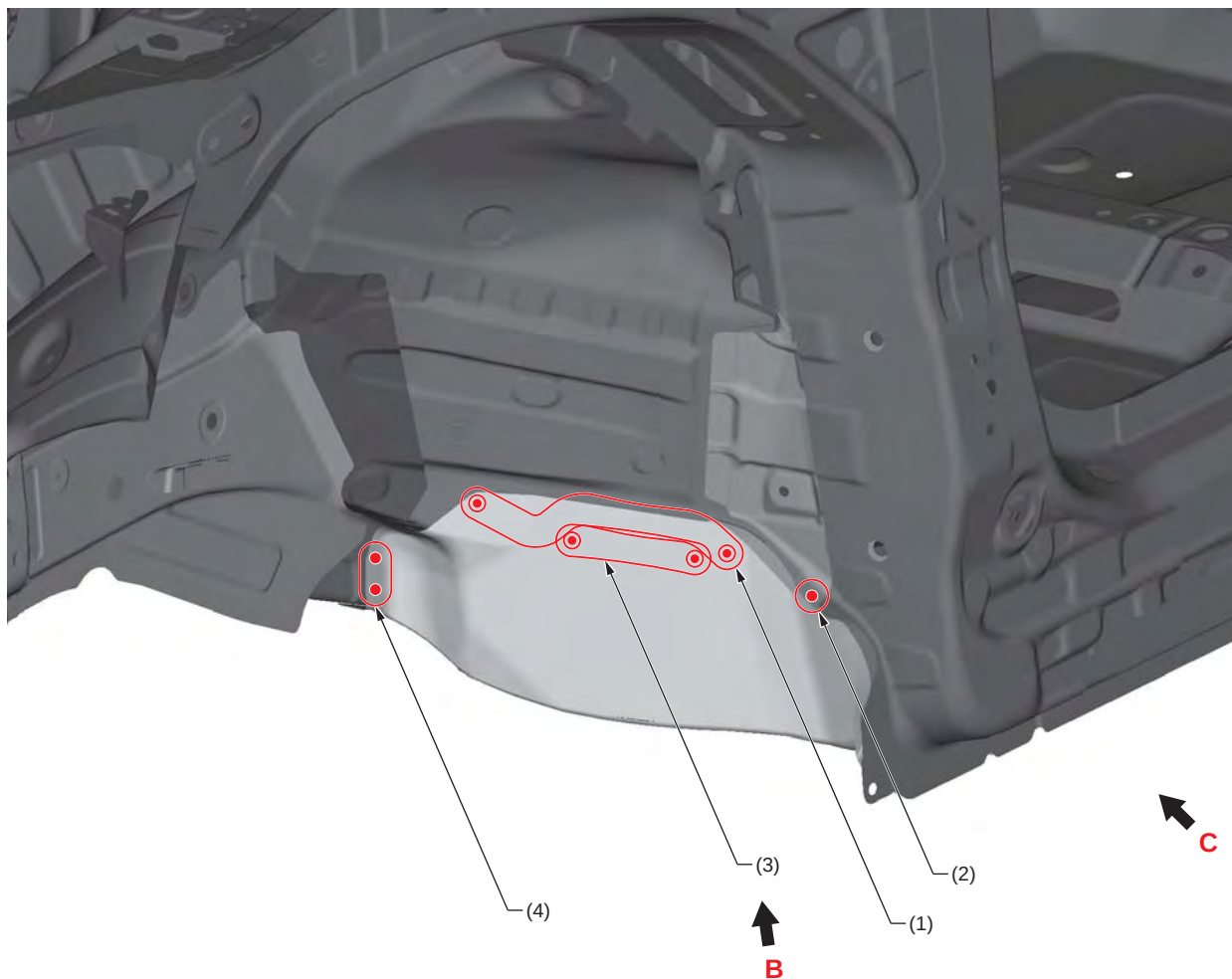
(1) 2 points (inside · 2)
(2) 3 points (outside · 2)

(3) 1 point (inside · 1)
(4) 3 points (inside · 1)

(5) 1 point (outside · 1)
(6) 3 points (outside · 1)

Panel Replacement

• Overall view 2



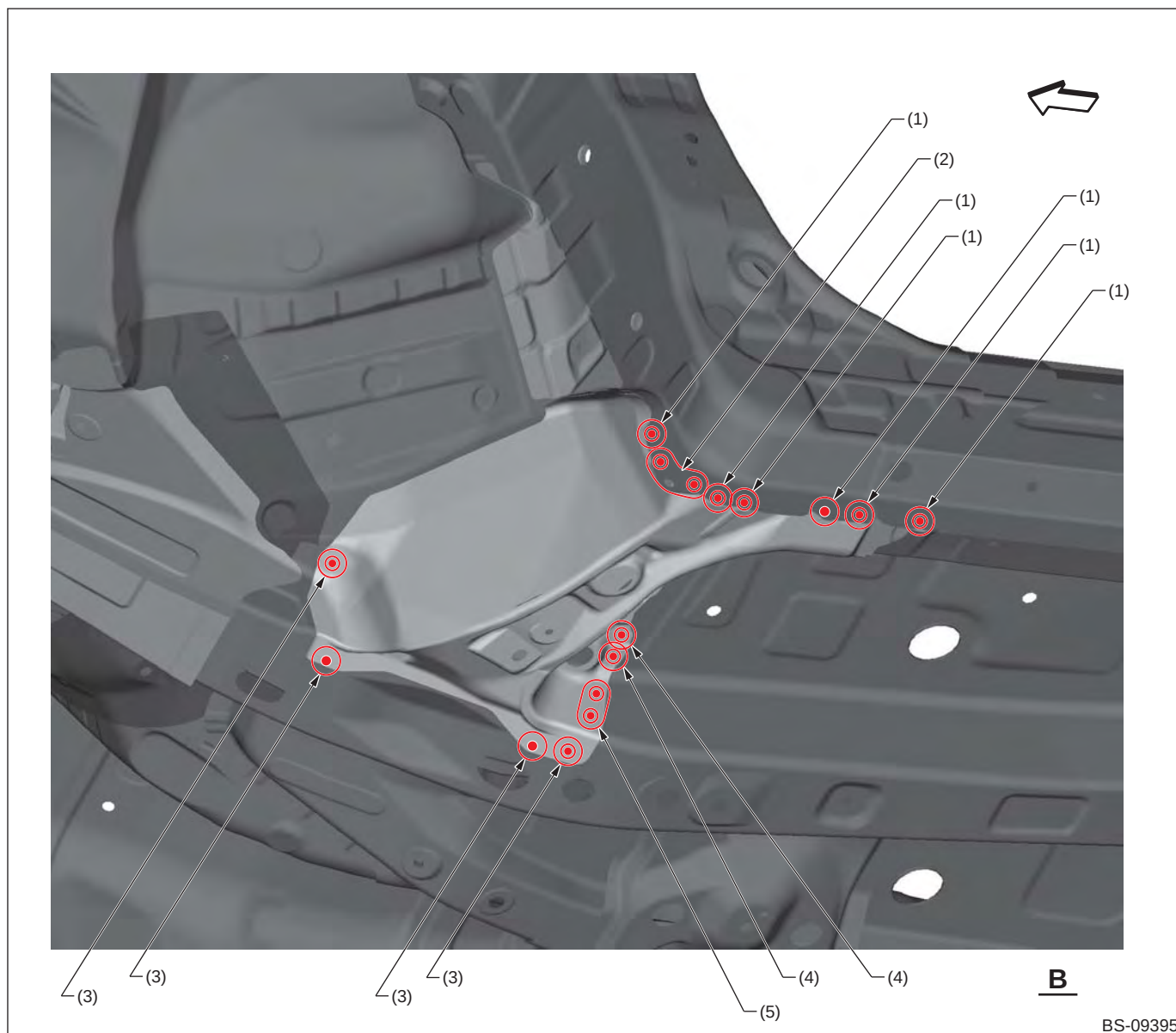
(1) 6 points (outside · 1)
(2) 1 point (outside · 1)

(3) 5 points (outside · 1)

(4) 2 points (outside · 1)

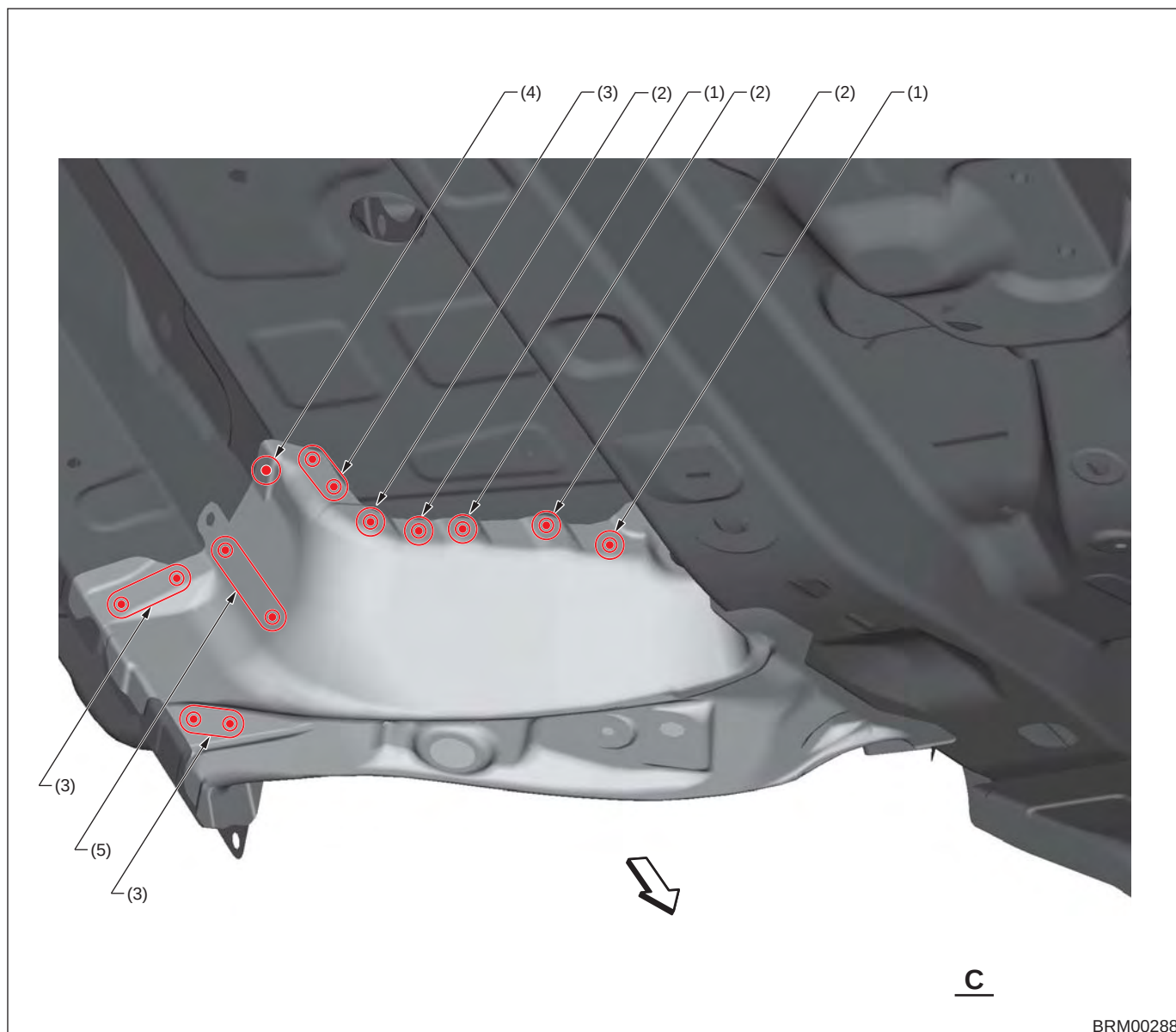
Panel Replacement

• Views B



Panel Replacement

• Views C



(1) 1 point (bottom · 2)
(2) 1 point (bottom · 1)

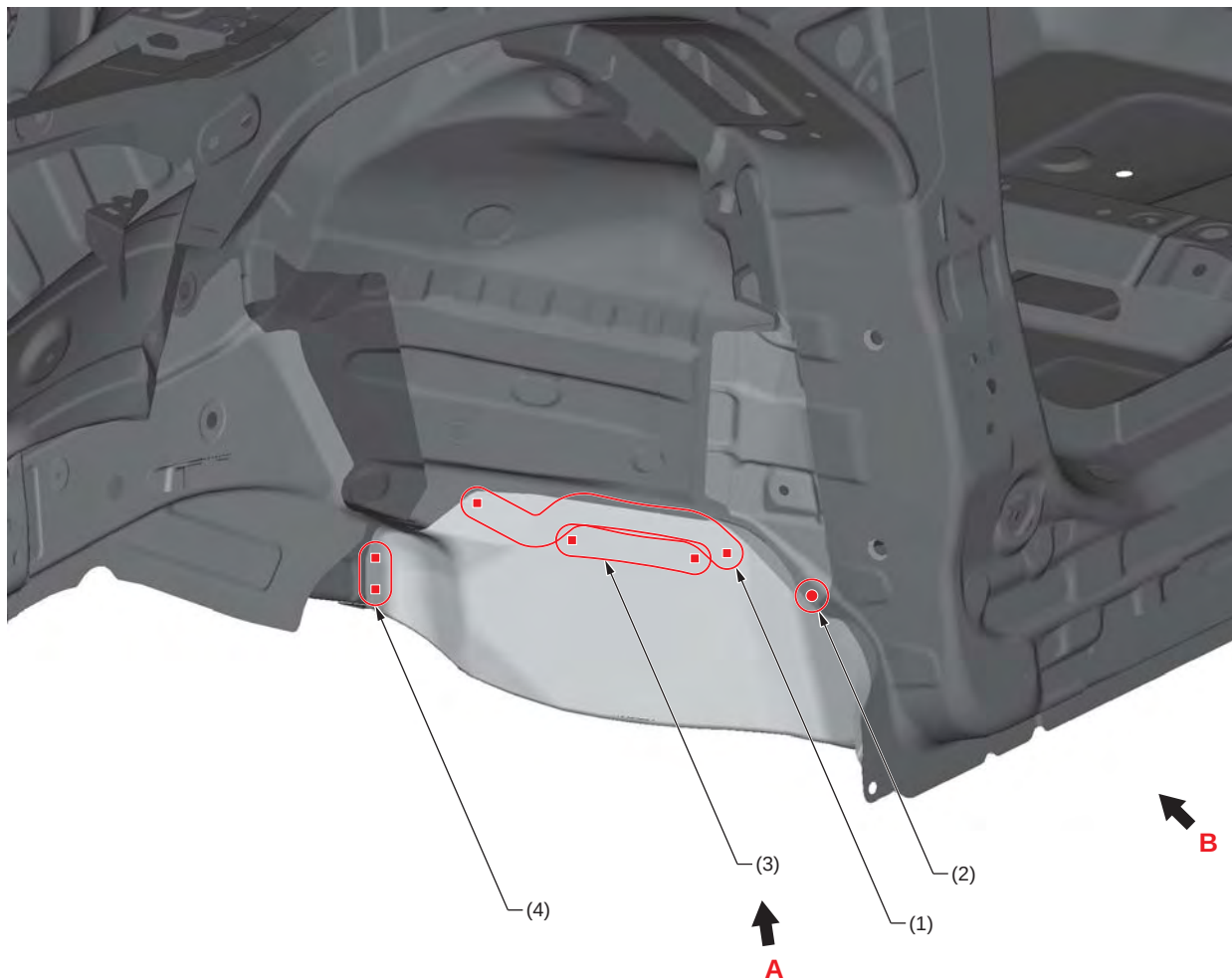
(3) 2 points (bottom · 1)
(4) 1 point (inside · 1)

(5) 2 points (inside · 1)

Panel Replacement

B: INSTALLATION

• Overall view 1



BS-09397

(1) 6 points (service)

(2) 1 point

(3) 5 points (service)

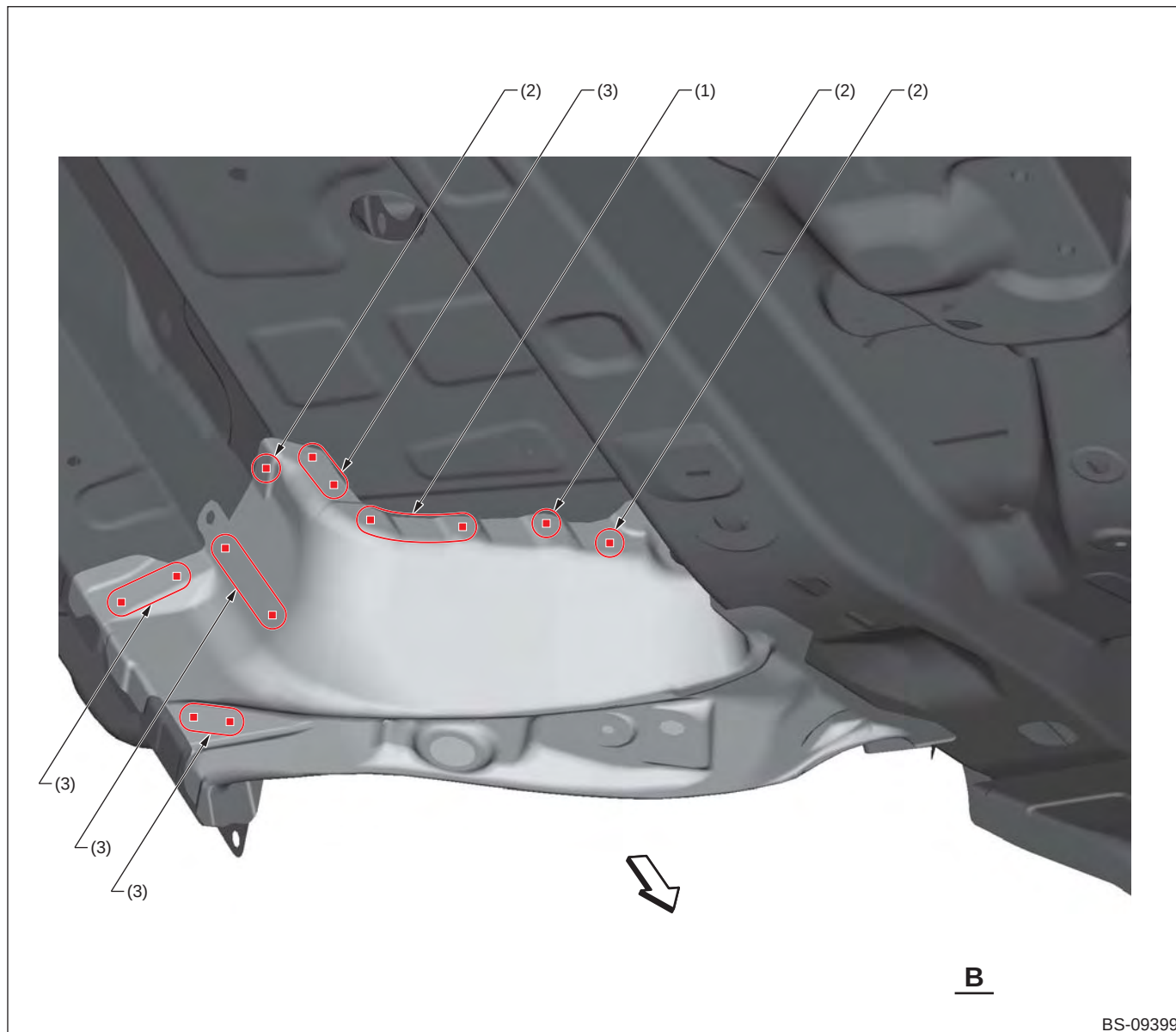
(4) 2 points (service)

- **Views A**

- | | |
|------------------|---|
| [y] Plug welding | A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2
B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %) |
|------------------|---|

Panel Replacement

• Views B



(1) 3 points (service)

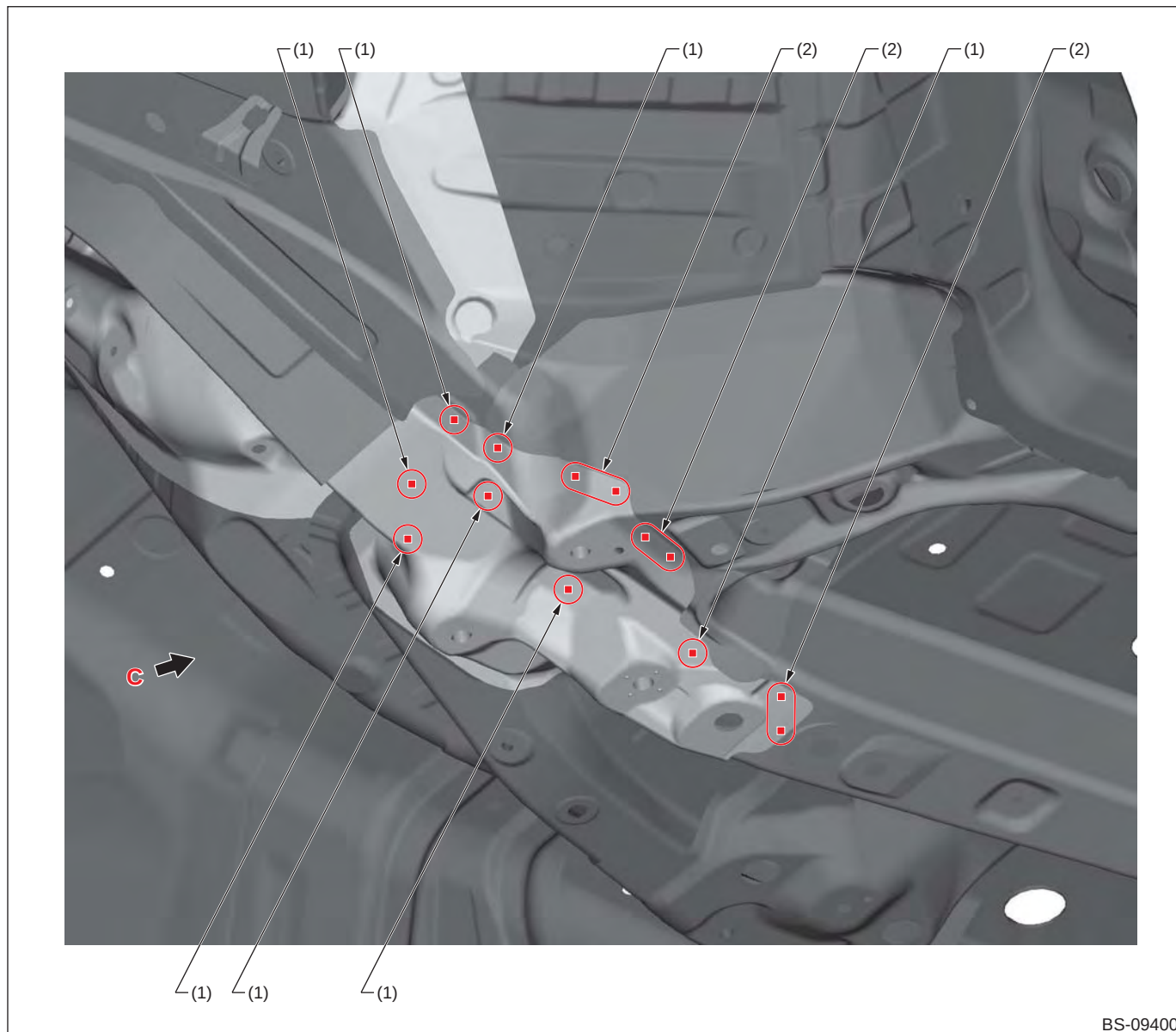
(2) 1 point (service)

(3) 2 points (service)

BS-09399

Panel Replacement

• Overall view 2

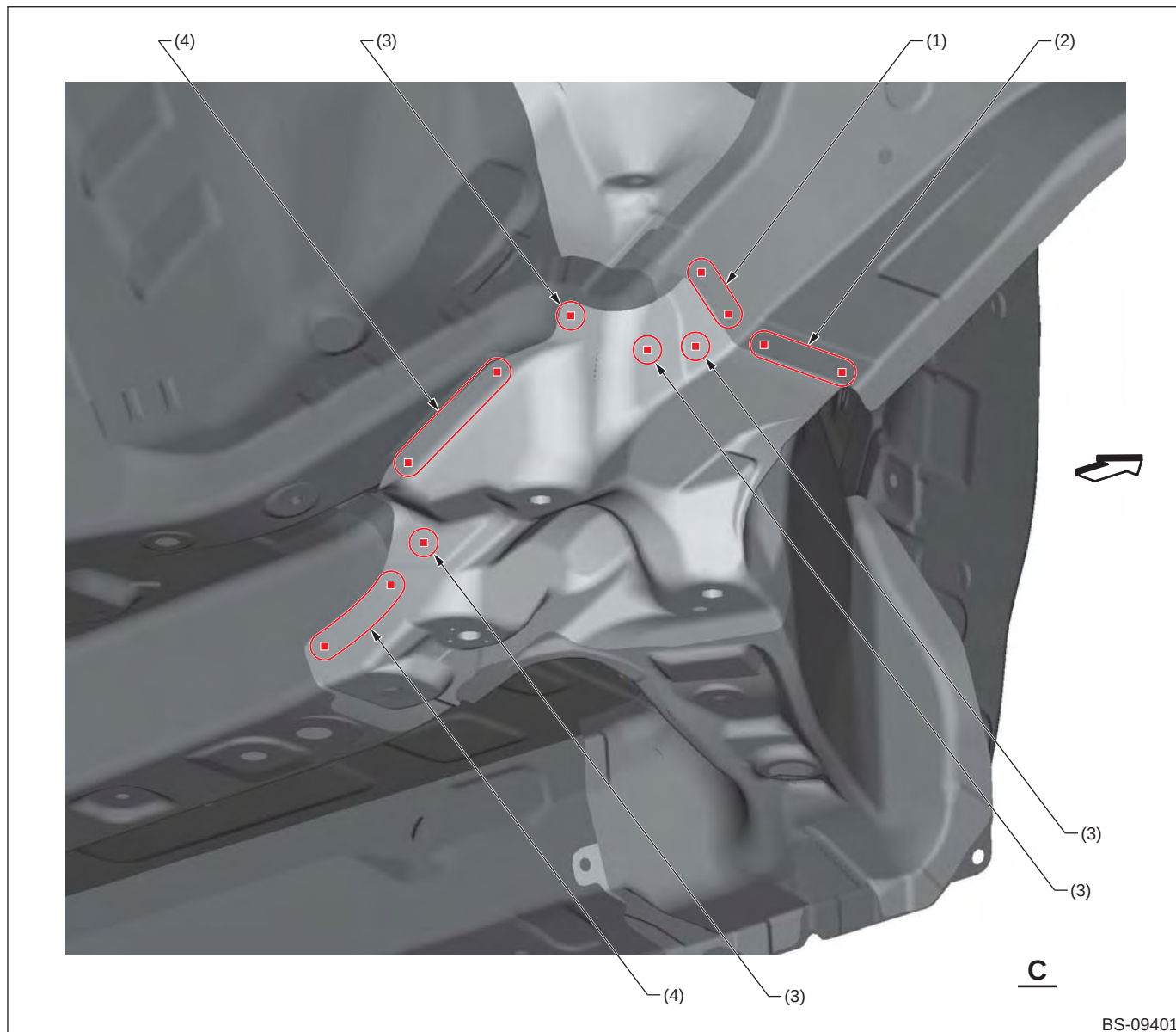


(1) 1 point (service)

(2) 2 points (service)

Panel Replacement

• Views C



(1) 2 points
(2) 3 points

(3) 1 point (service)

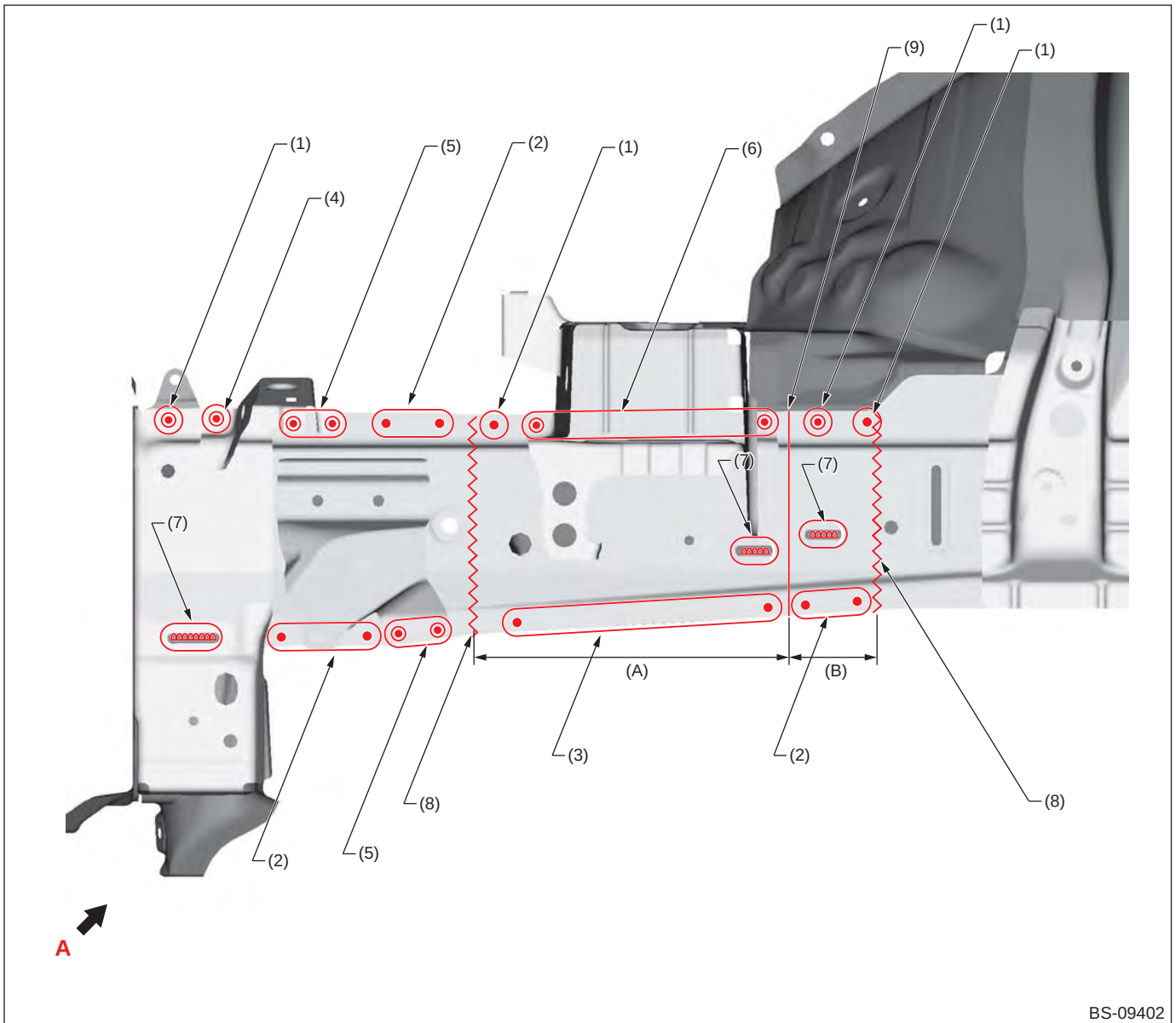
(4) 3 points (service)

Panel Replacement

8-6. Closing Plate LH (Partial replacement)

A: REMOVAL

• Overall view (The radiator panel has been removed. The wheel apron should be removed depending on level of damage.)



(A) 216 mm [8.50 in]

(B) 55 mm [2.17 in]

(1) 1 point (outside · 1)

(4) 1 point (outside · 2)

(7) 1 point (outside · 1 belt sander)

(2) 2 points (outside · 1)

(5) 2 points (outside · 2)

(8) Cut position

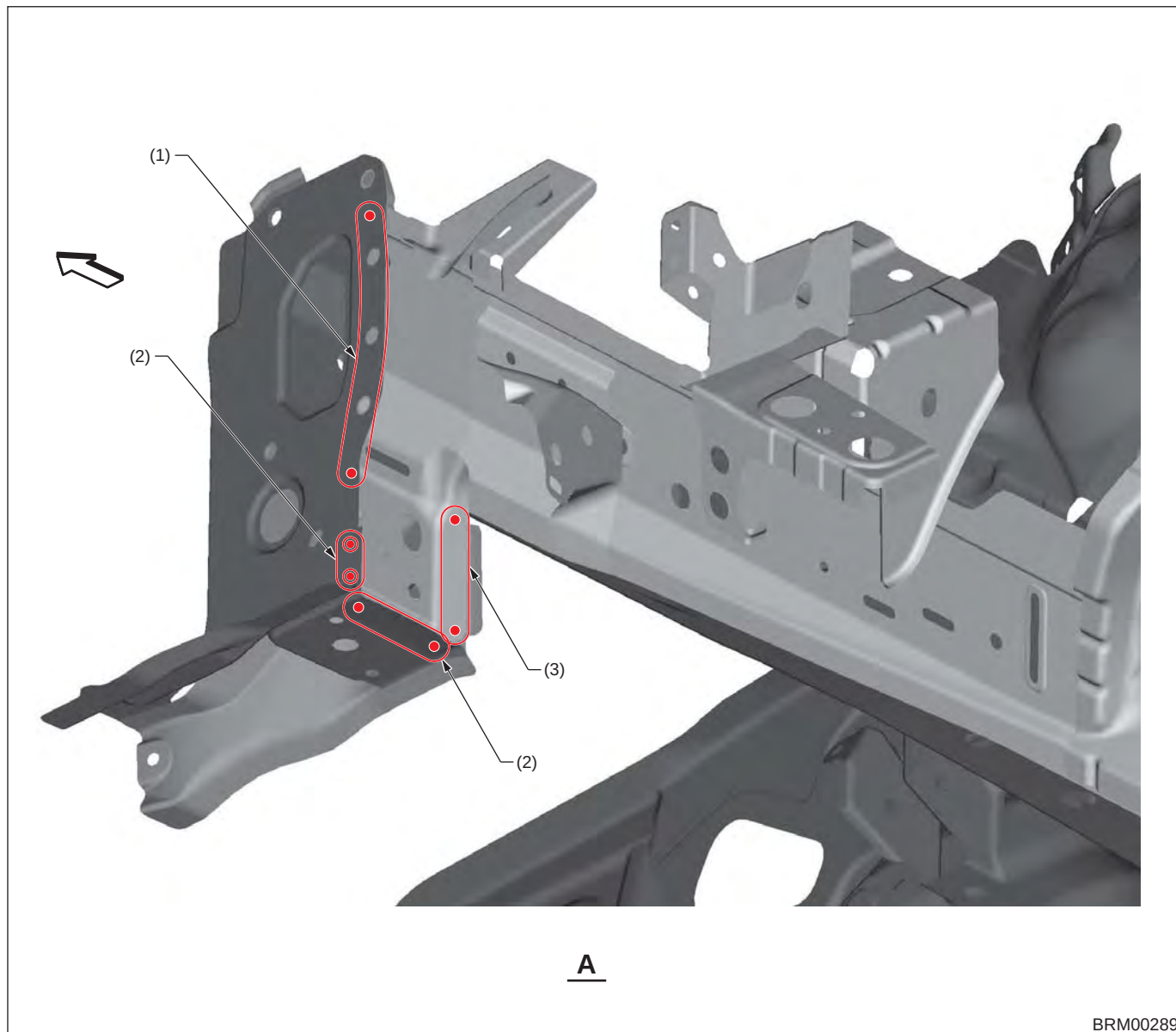
(3) 7 points (outside · 1)

(6) 6 points (outside · 2)

(9) Tailored line

Panel Replacement

• Views A



(1) 4 points (inside · 1)

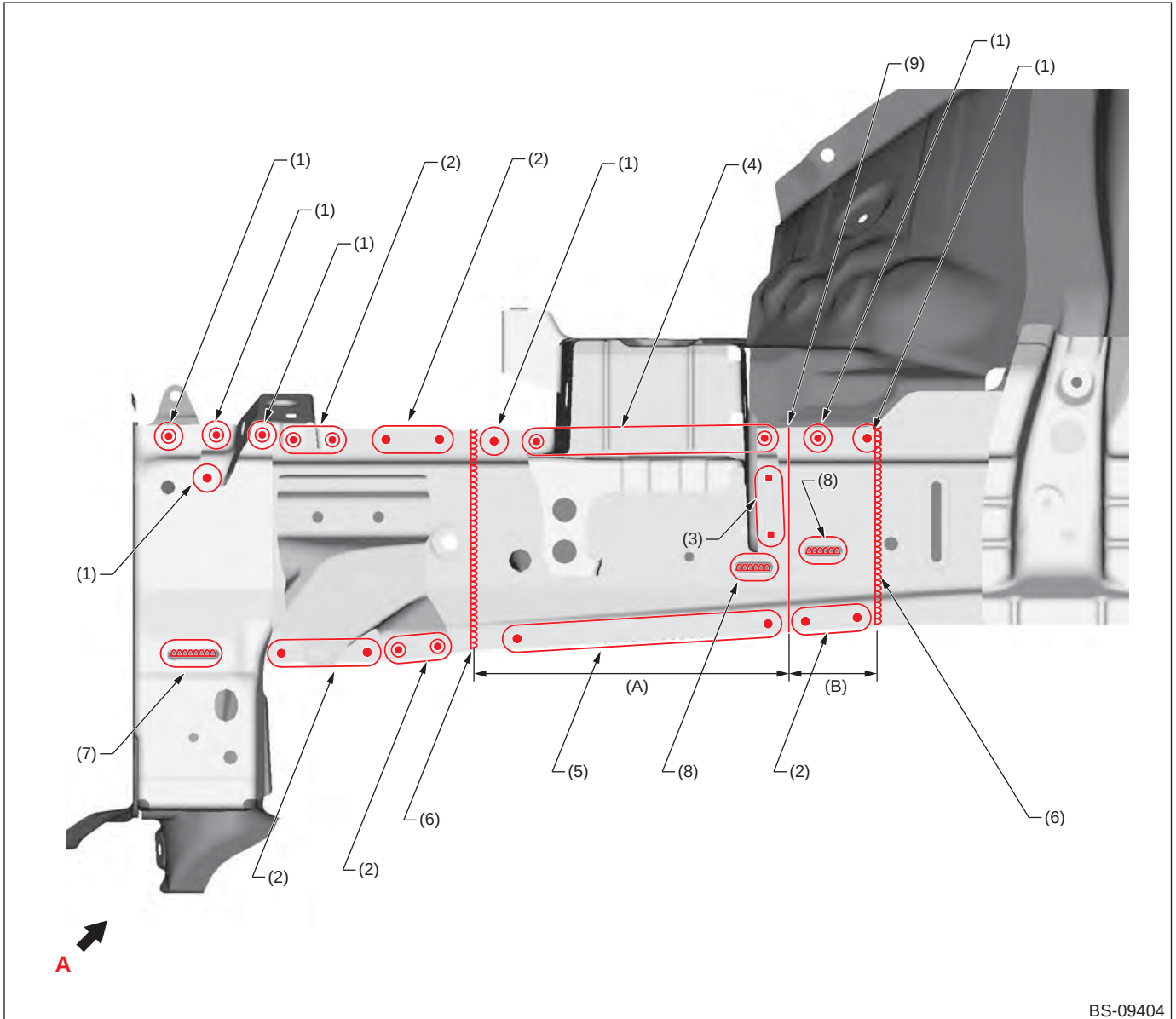
(2) 2 points (inside · 1)

(3) 4 points (outside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



(A) 216 mm [8.50 in]

(B) 55 mm [2.17 in]

(1) 1 point

(4) 6 points

(7) 1 point (Continuous welding)
(20 mm [0.79 in])

(2) 2 points

(5) 7 points

(8) 1 point (Continuous welding)
(10 mm [0.39 in])

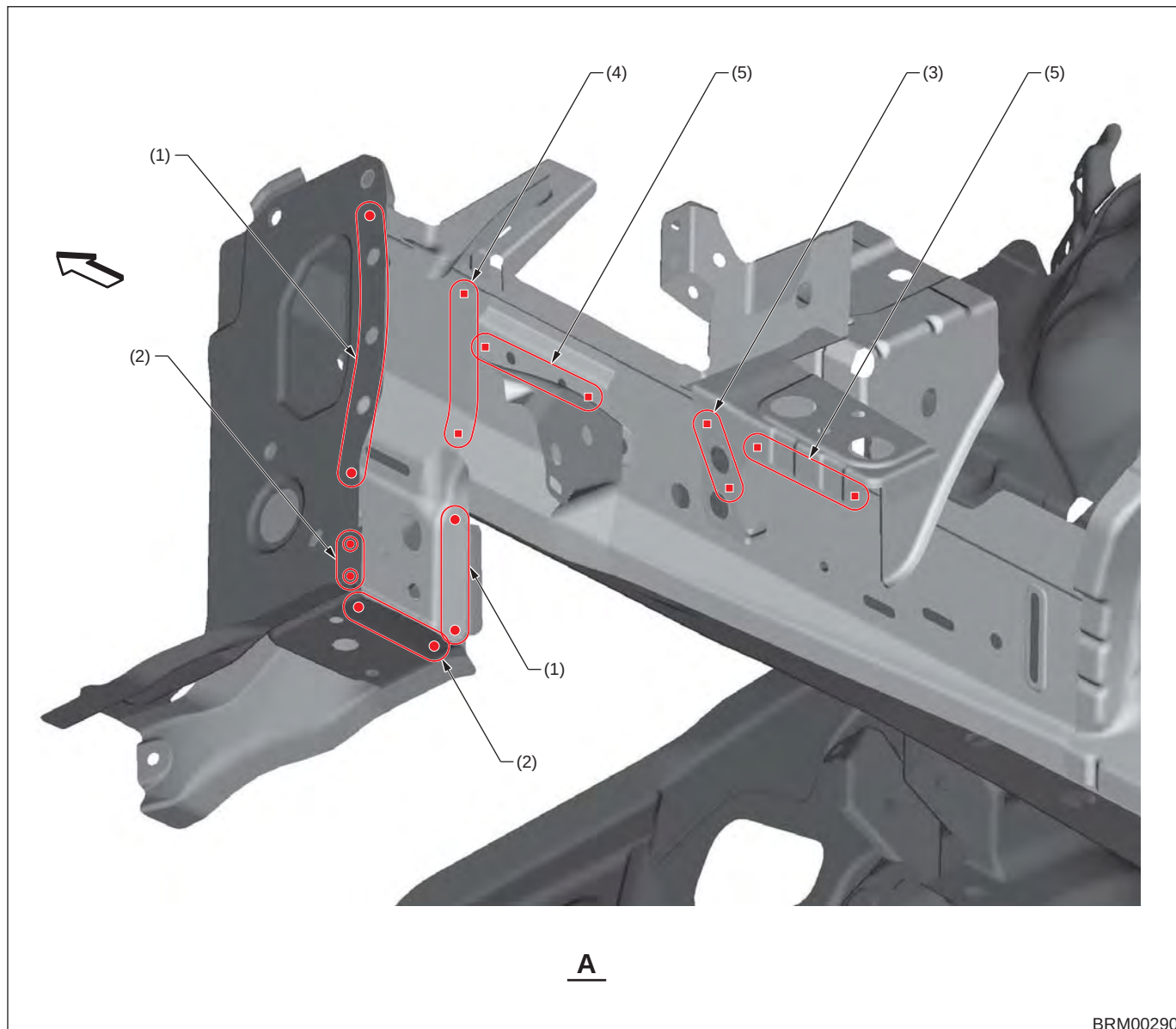
(3) 3 points (service)

(6) 1 point (Continuous welding)

(9) Tailored line

Panel Replacement

• Views A



(1) 4 points
(2) 2 points

(3) 2 points (service)
(4) 4 points (service)

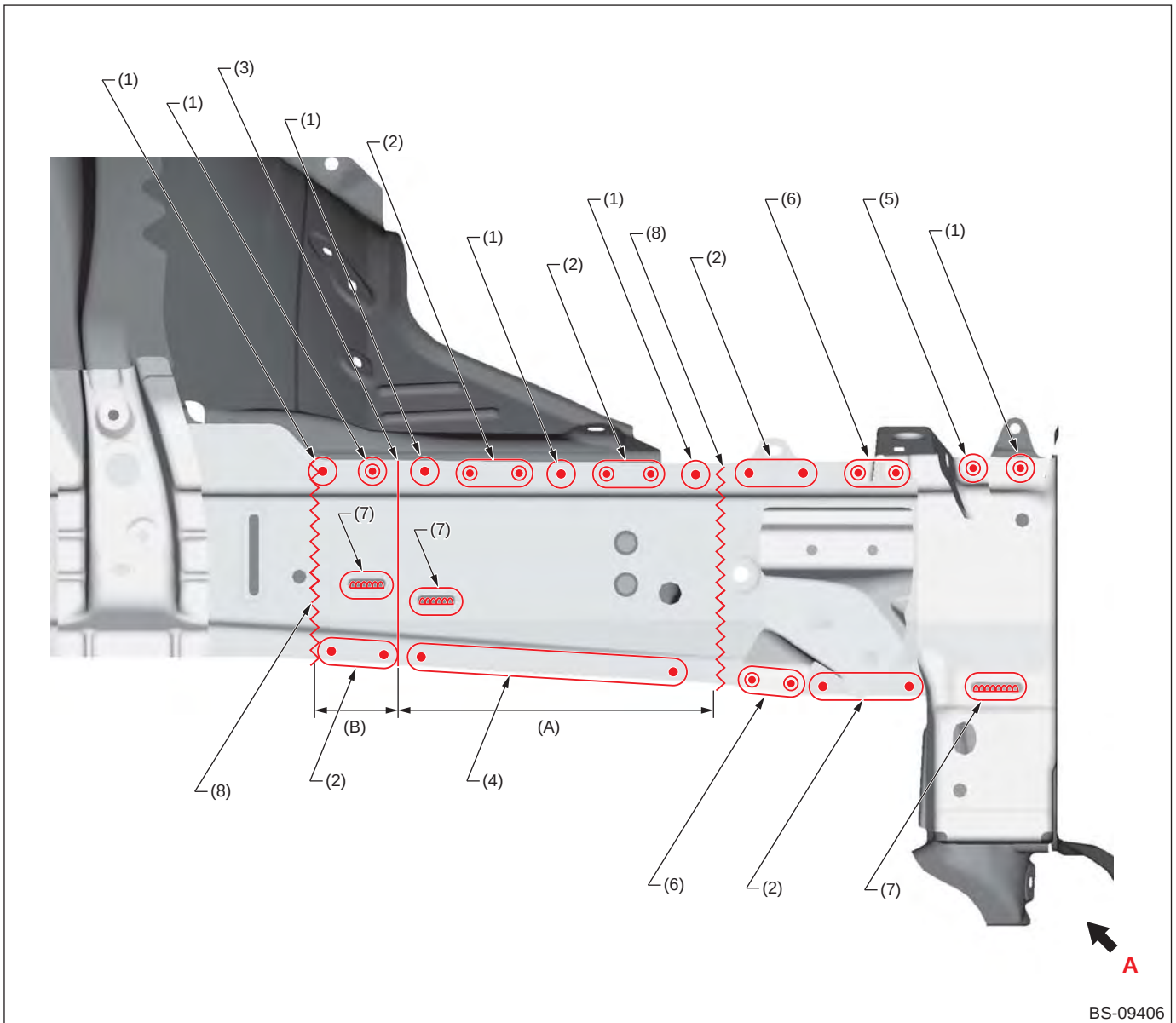
(5) 3 points (service)

Panel Replacement

8-7. Closing Plate RH (Partial replacement)

A: REMOVAL

• Overall view (The radiator panel has been removed. The wheel apron should be removed depending on level of damage.)



(A) 213 mm [8.39 in]

(B) 53 mm [2.09 in]

(1) 1 point (outside · 1)

(4) 7 points (outside · 1)

(7) 1 point (outside · 1 belt sander)

(2) 2 points (outside · 1)

(5) 1 point (outside · 2)

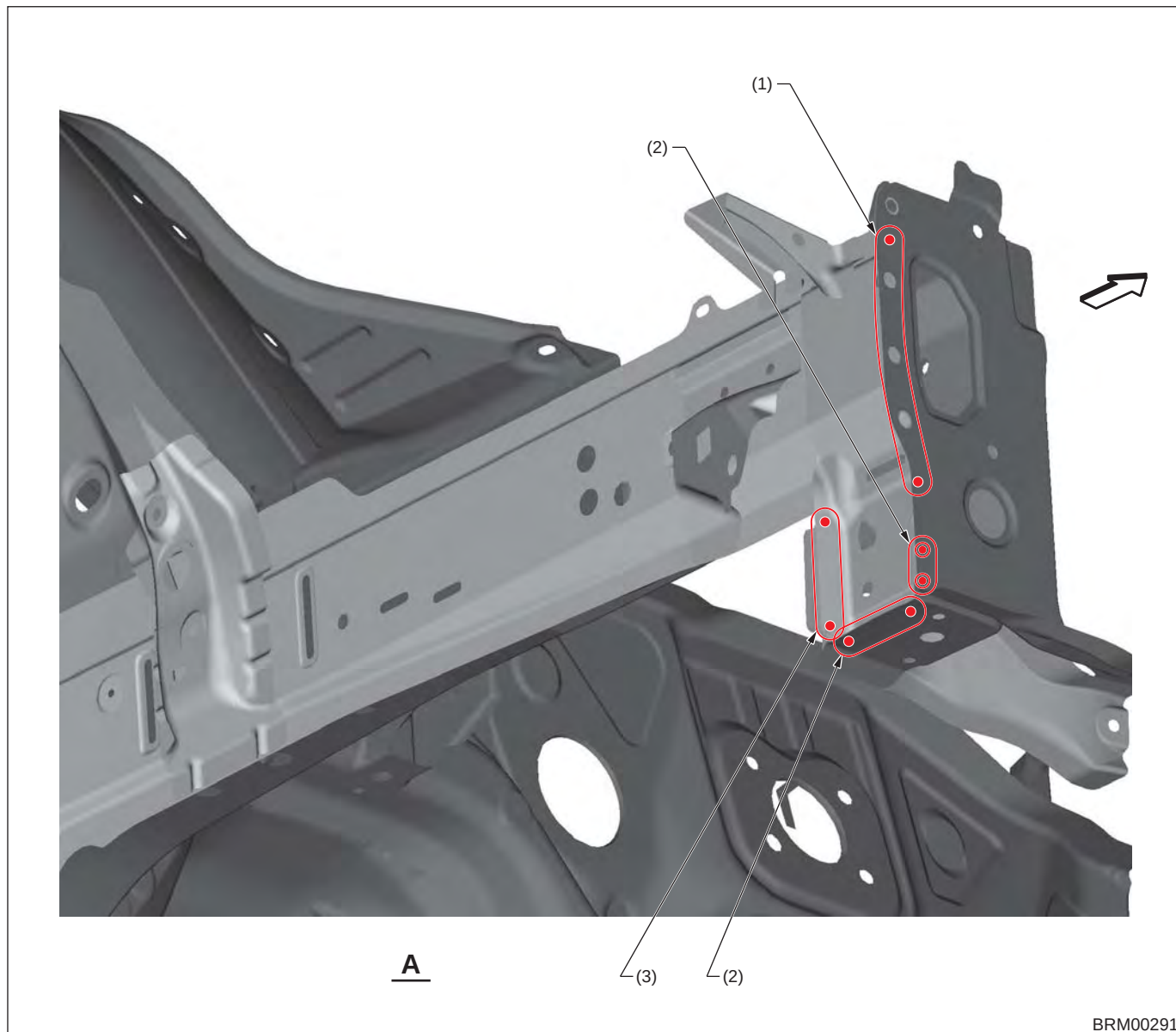
(8) Cut position

(3) Tailored line

(6) 2 points (outside · 2)

Panel Replacement

• Views A



(1) 4 points (inside · 1)

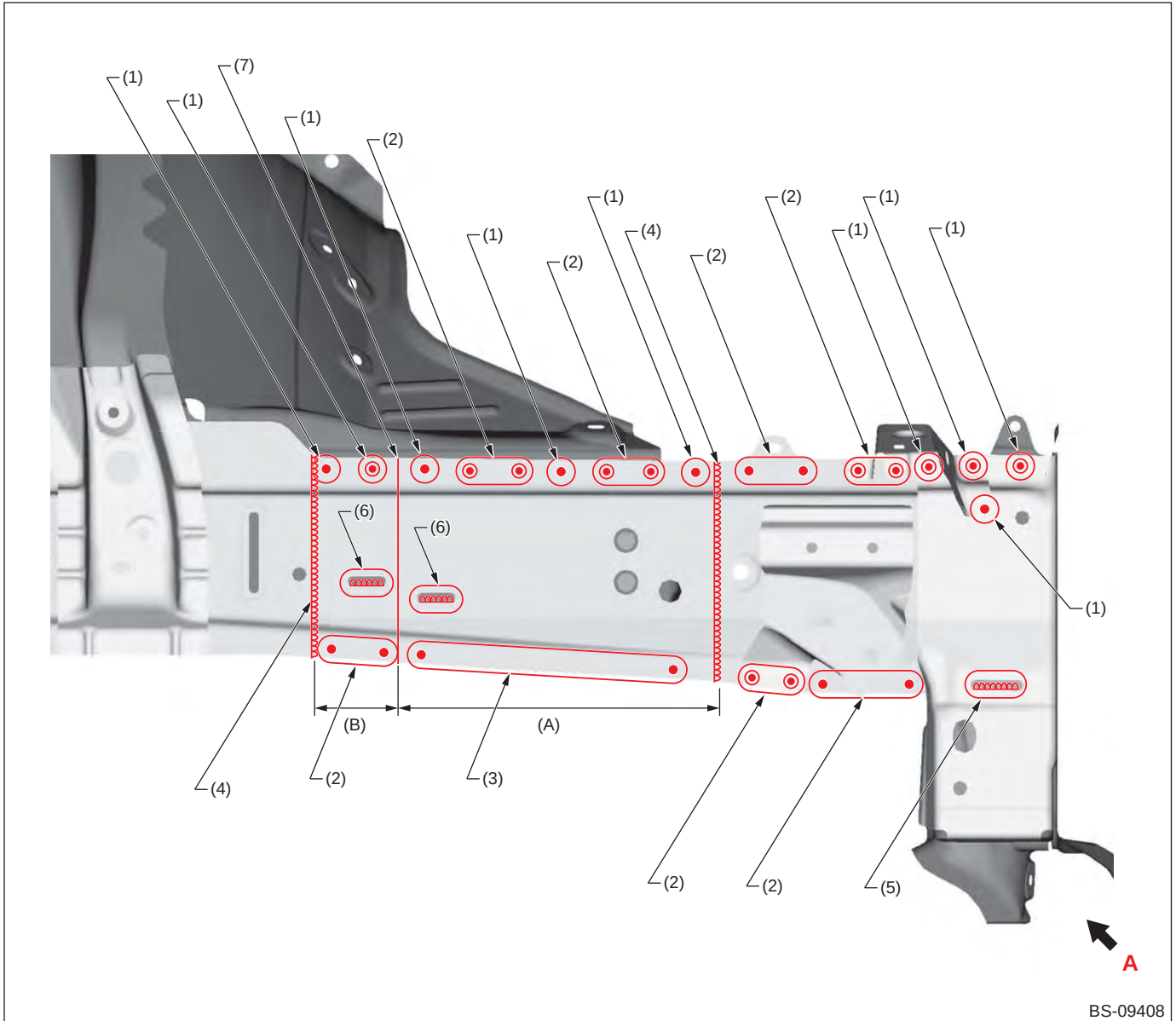
(2) 2 points (inside · 1)

(3) 4 points (outside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



(A) 213 mm [8.39 in]

(B) 53 mm [2.09 in]

(1) 1 point

(4) 1 point (Continuous welding)

(7) Tailored line

(2) 2 points

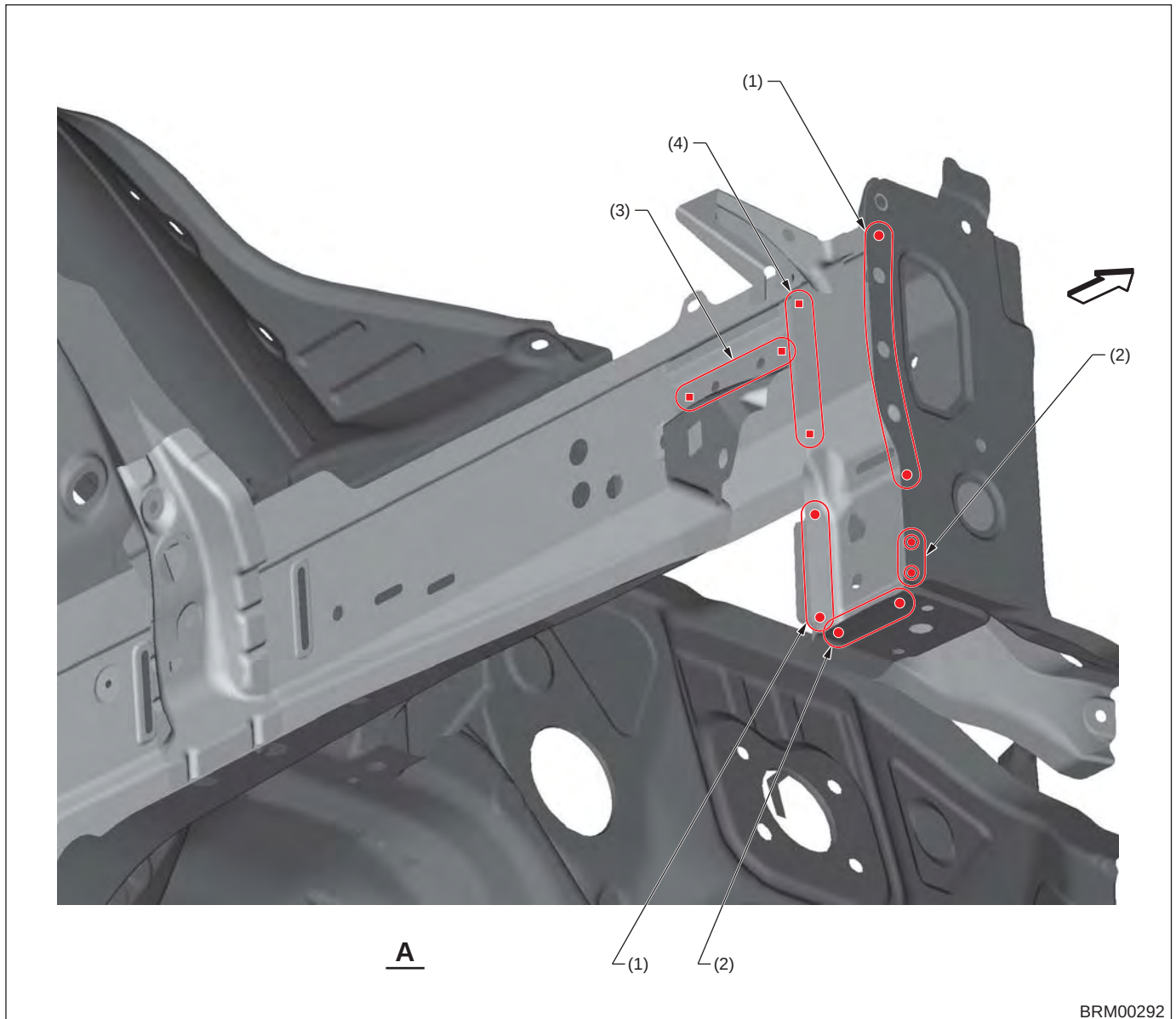
(5) 1 point (Continuous welding)
(20 mm [0.79 in])

(3) 7 points

(6) 1 point (Continuous welding)
(10 mm [0.39 in])

Panel Replacement

• Views A



(1) 4 points
(2) 2 points

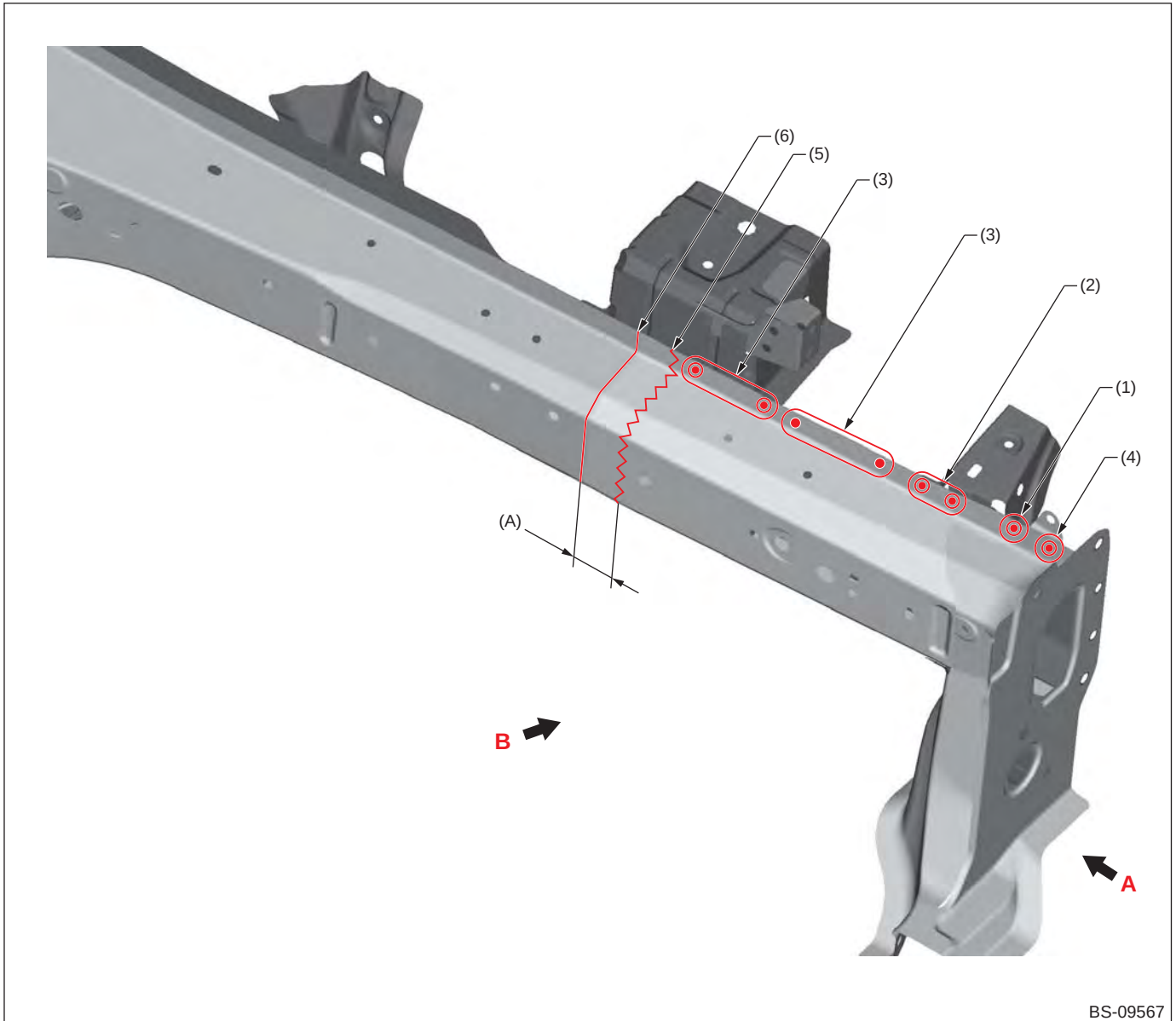
(3) 3 points (service)

(4) 4 points (service)

8-8. Front Side Frame (Partial replacement)

A: REMOVAL

- Overall view (The radiator panel has been removed. The front wheel apron should be removed depending on level of damage.)



BS-09567

(A) 37 mm [1.46 in]

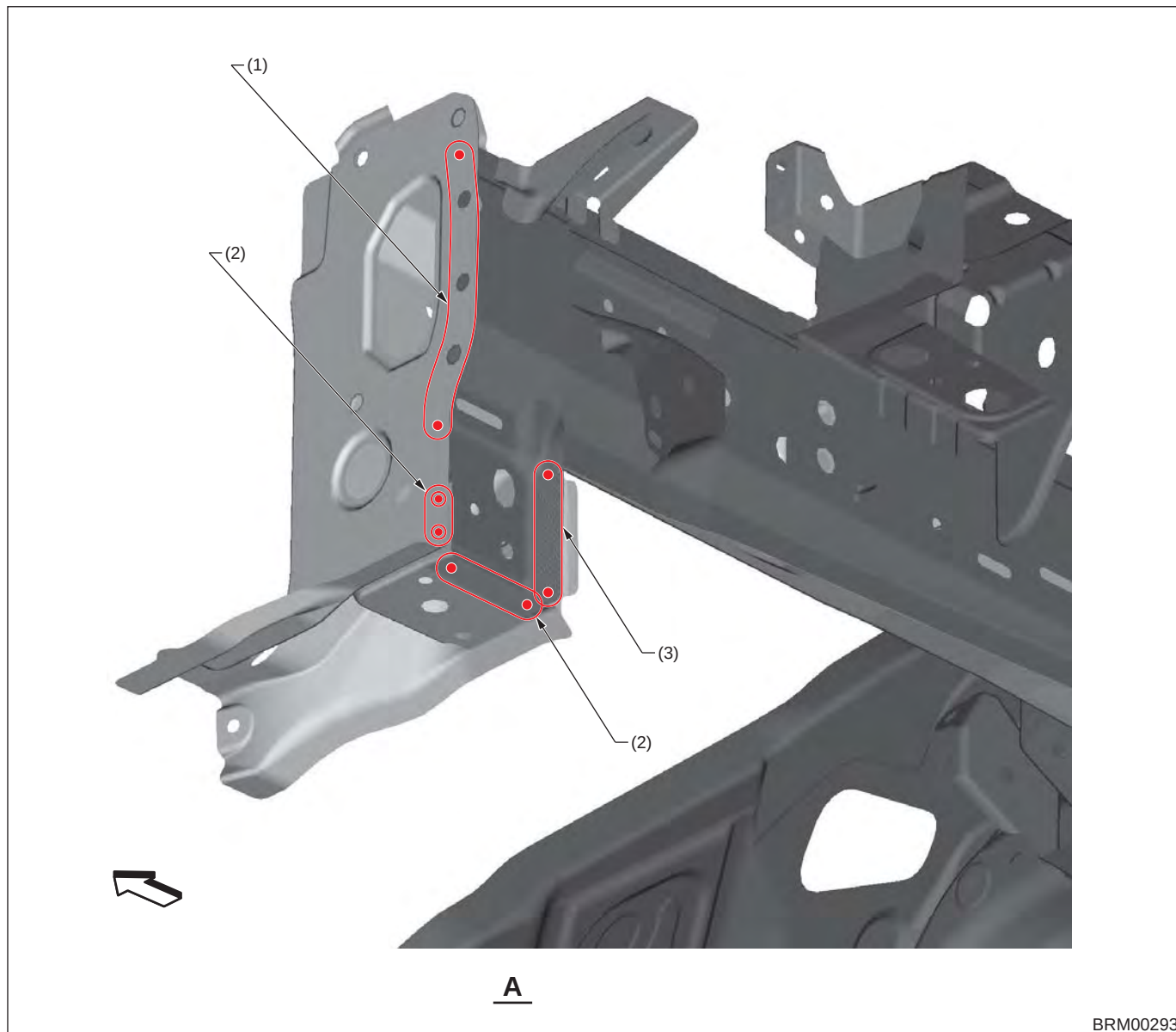
(1) 1 point (inside · 1)
(2) 2 points (inside · 1)

(3) 3 points (inside · 1)
(4) 1 point (inside · 2)

(5) Cut position
(6) Tailored line

Panel Replacement

• Views A



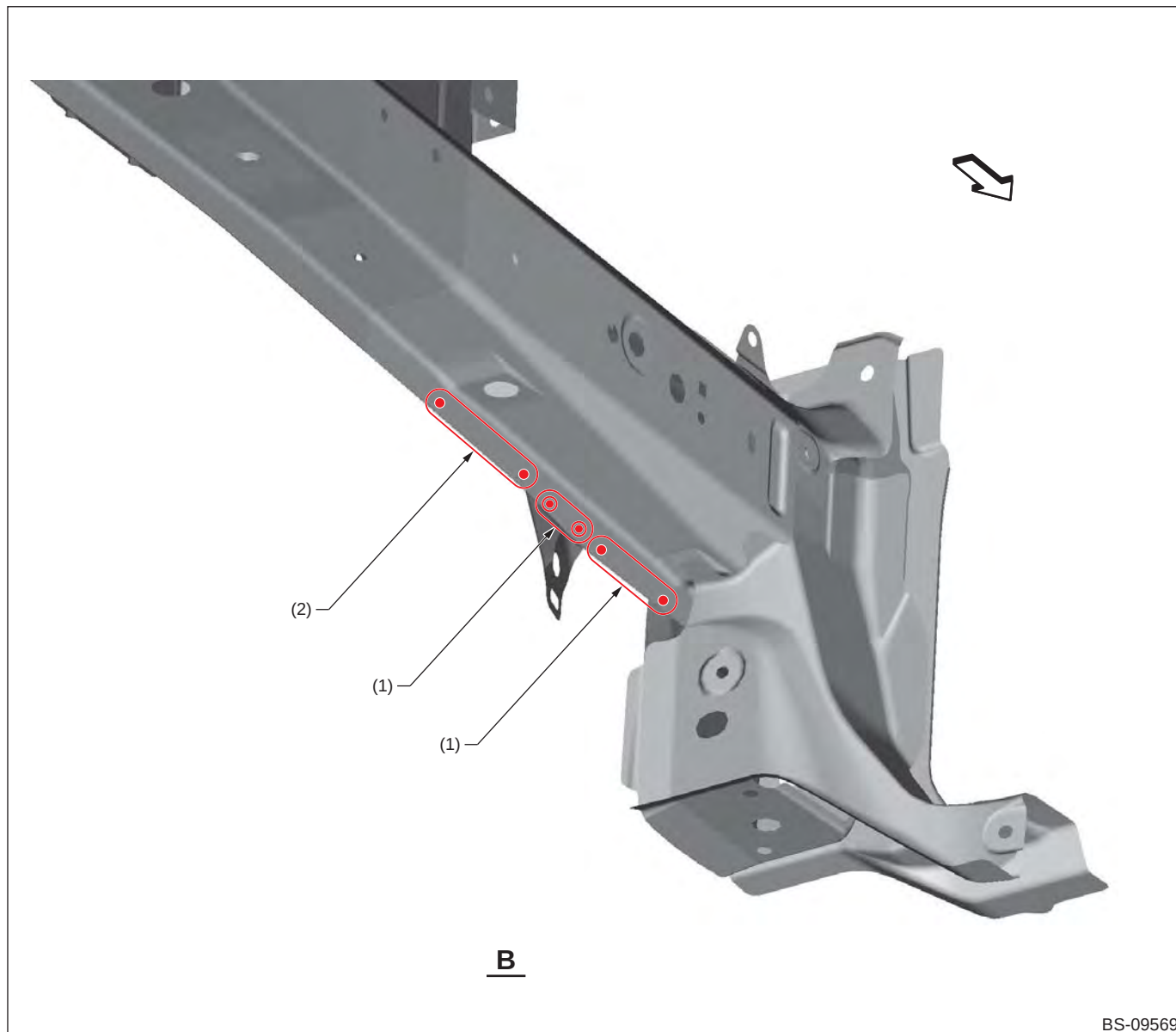
(1) 4 points (inside · 1)

(2) 2 points (inside · 1)

(3) 4 points (outside · 1)

Panel Replacement

• Views B



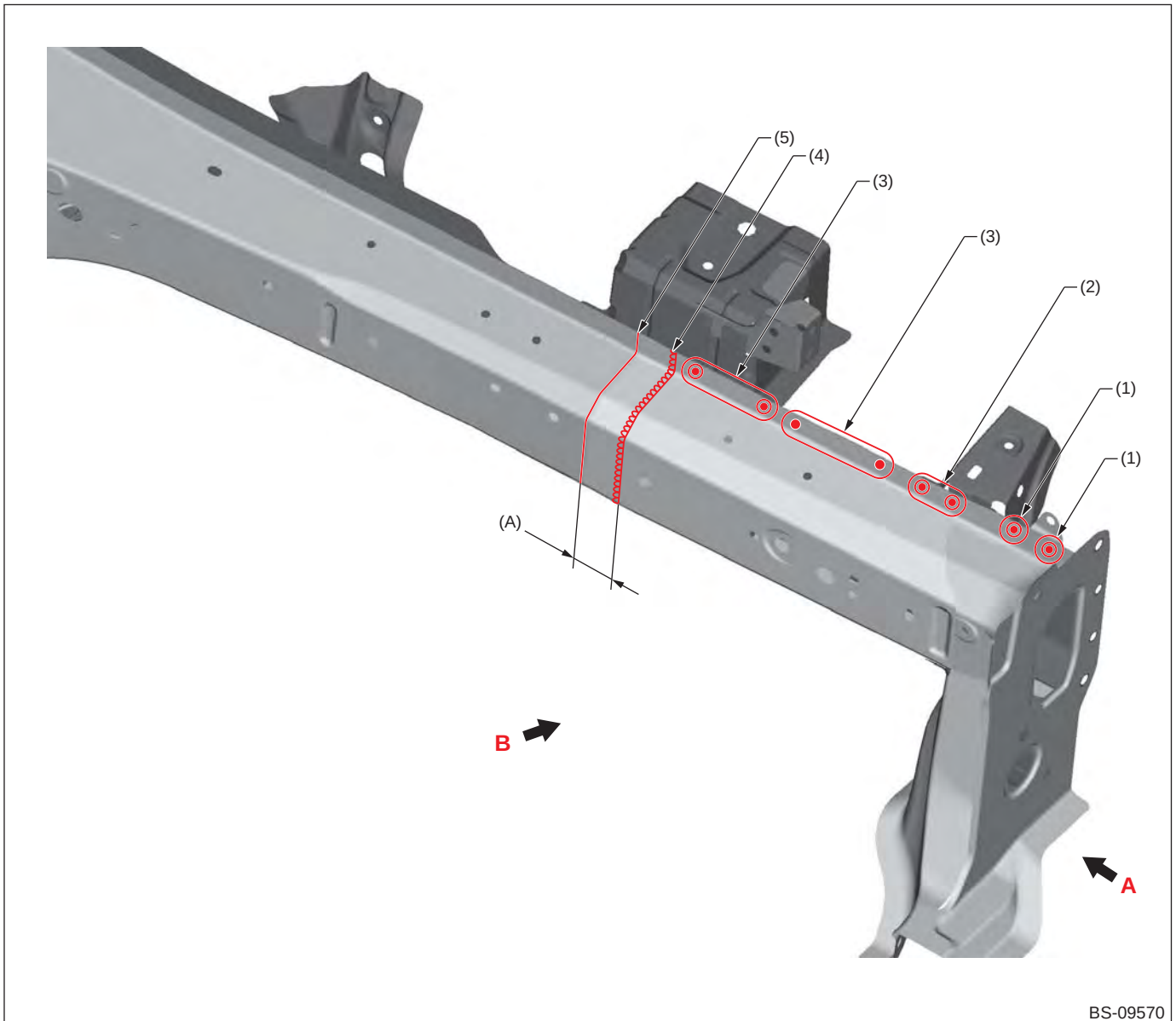
(1) 2 points (inside · 1)

(2) 4 points (inside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



(A) 37 mm [1.46 in]

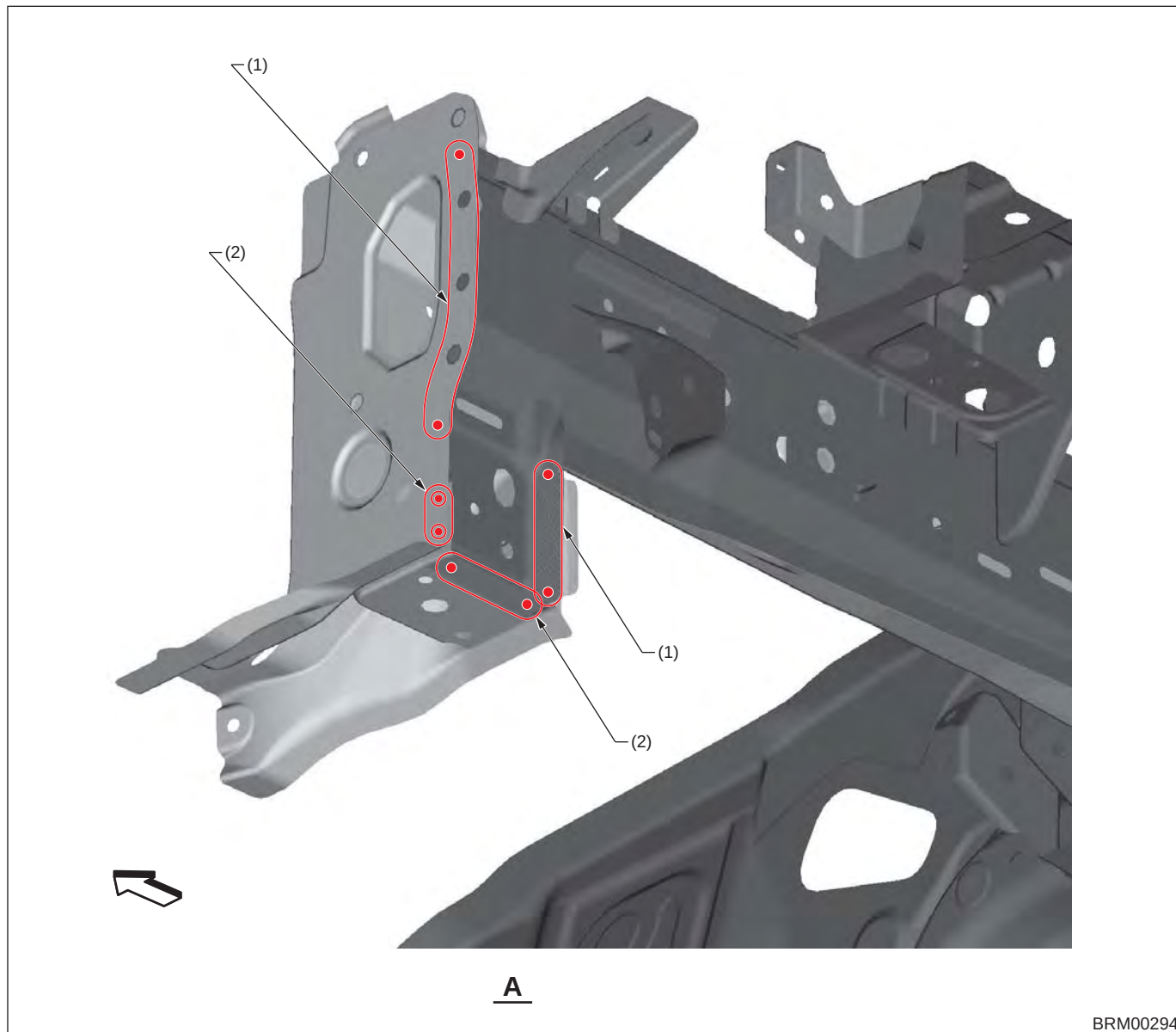
(1) 1 point
(2) 2 points

(3) 3 points
(4) 1 point (Continuous welding)

(5) Tailored line

Panel Replacement

• Views A

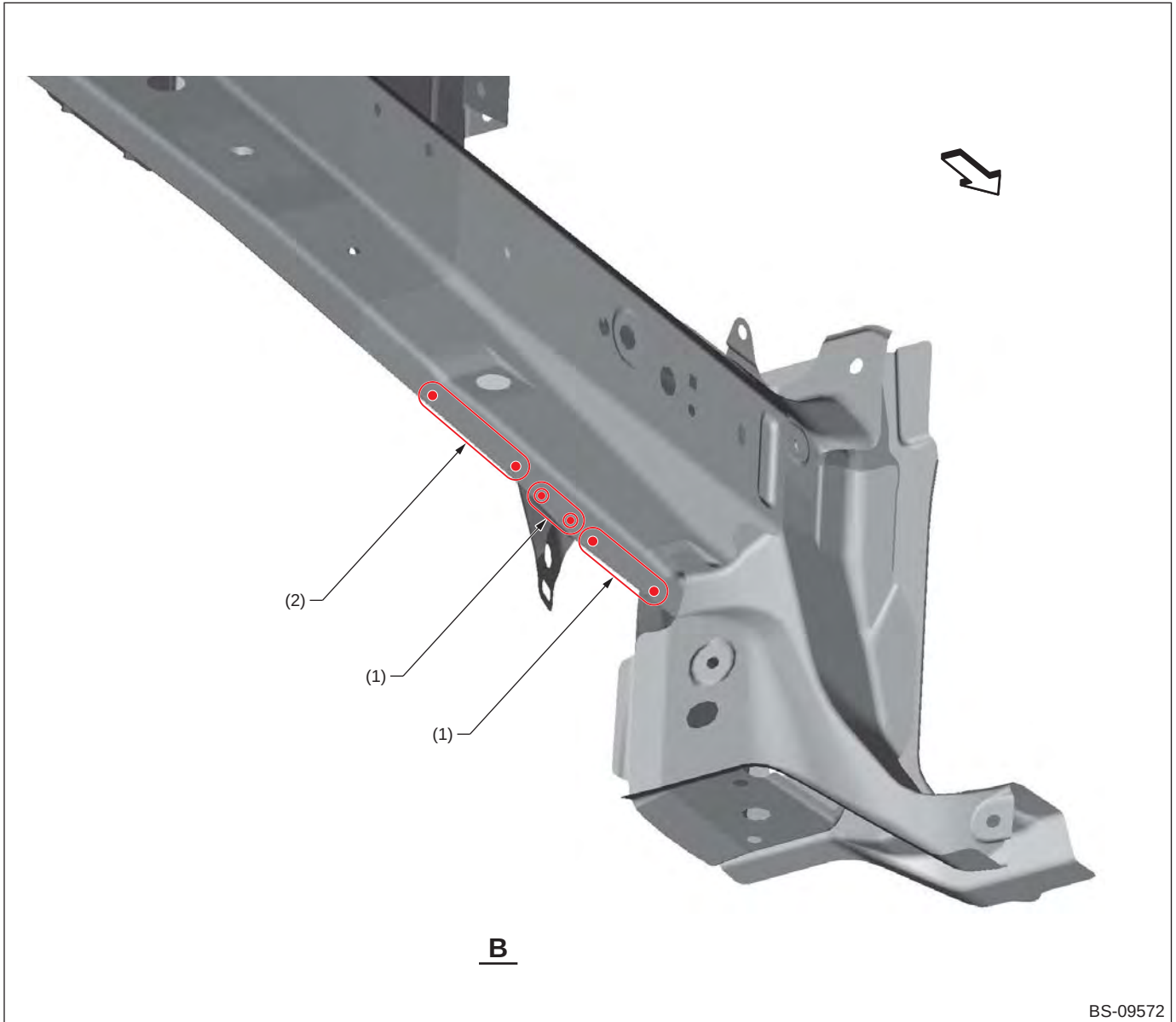


(1) 4 points

(2) 2 points

Panel Replacement

- Views B



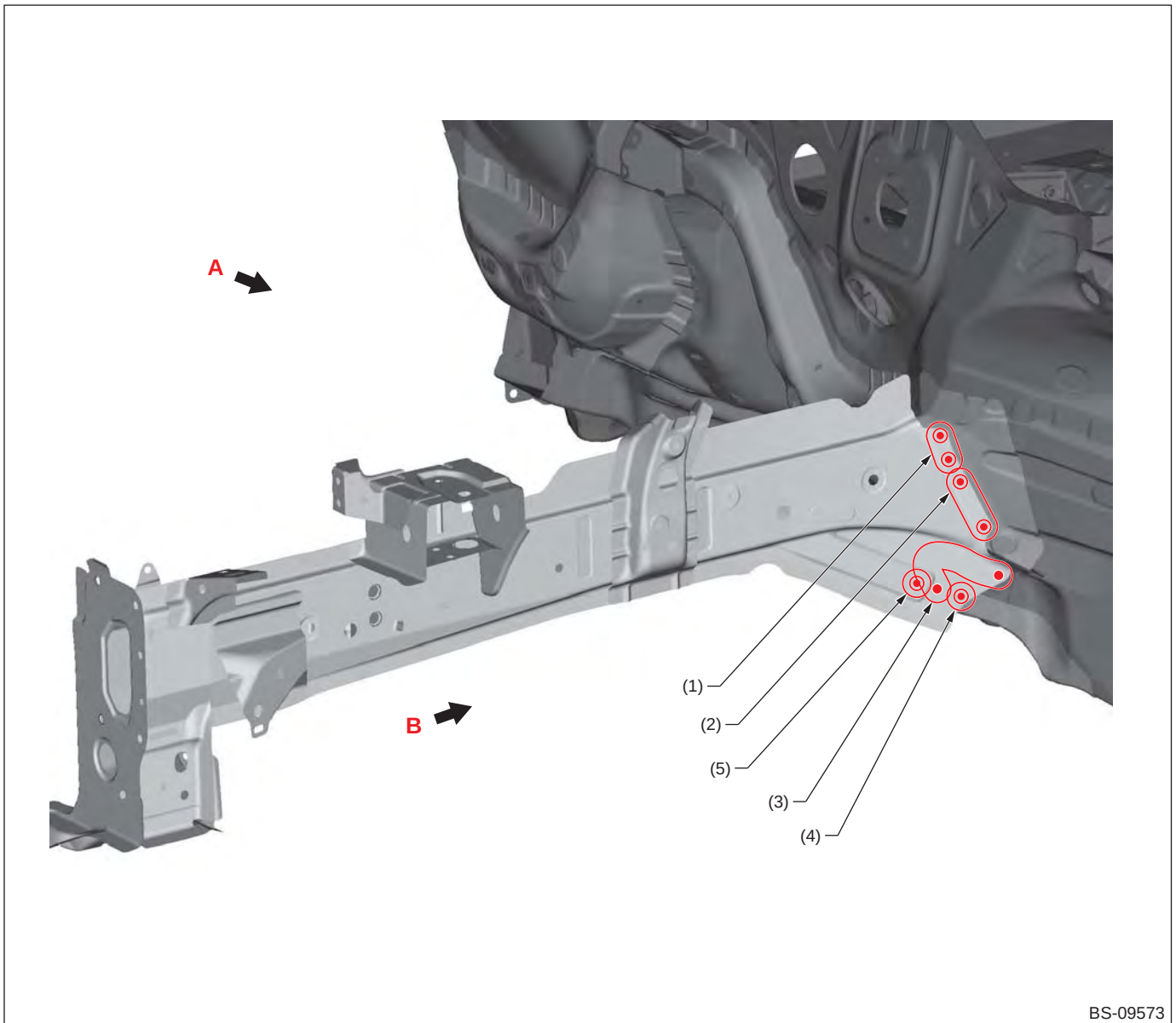
(1) 2 points

(2) 4 points

8-9. Front Side Frame (Total replacement)

A: REMOVAL

- Overall view (The radiator panel has been removed. The front wheel apron should be removed depending on level of damage.)



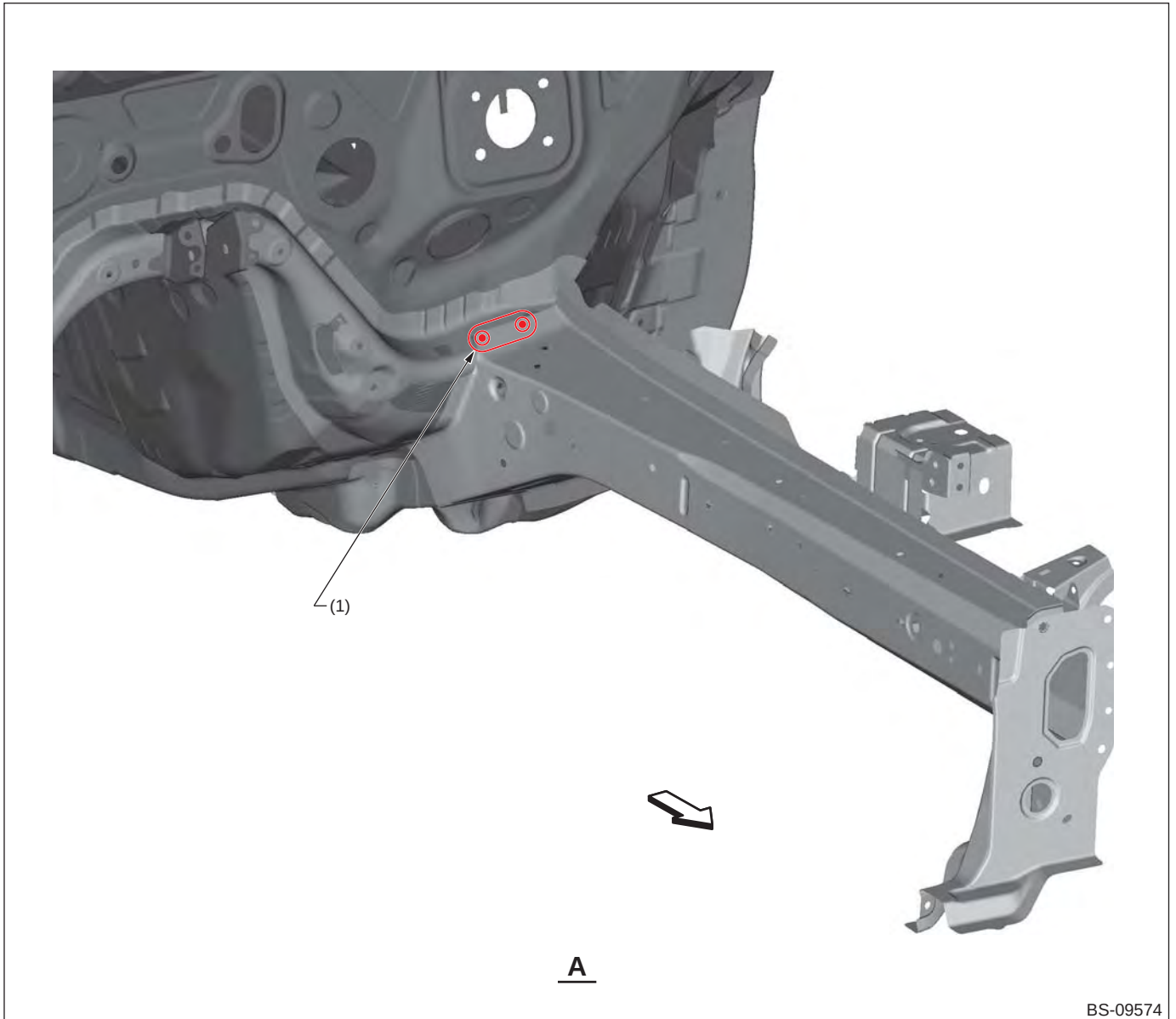
(1) 2 points (outside · 1)
(2) 3 points (outside · 1)

(3) 5 points (outside · 1)
(4) 1 point (outside · 1)

(5) 1 point (outside · 2)

Panel Replacement

- Views A

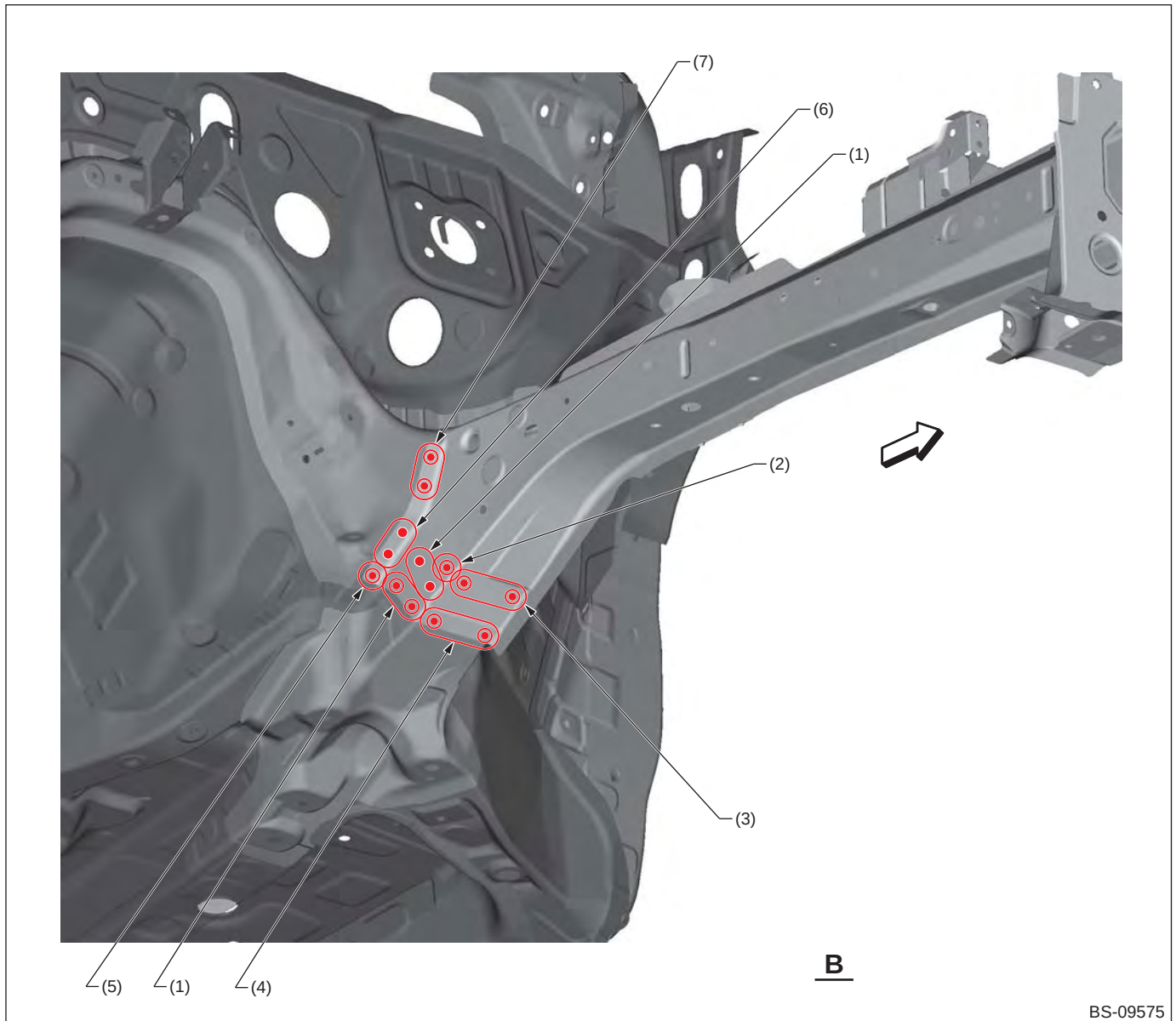


BS-09574

(1) 3 points (top · 1)

Panel Replacement

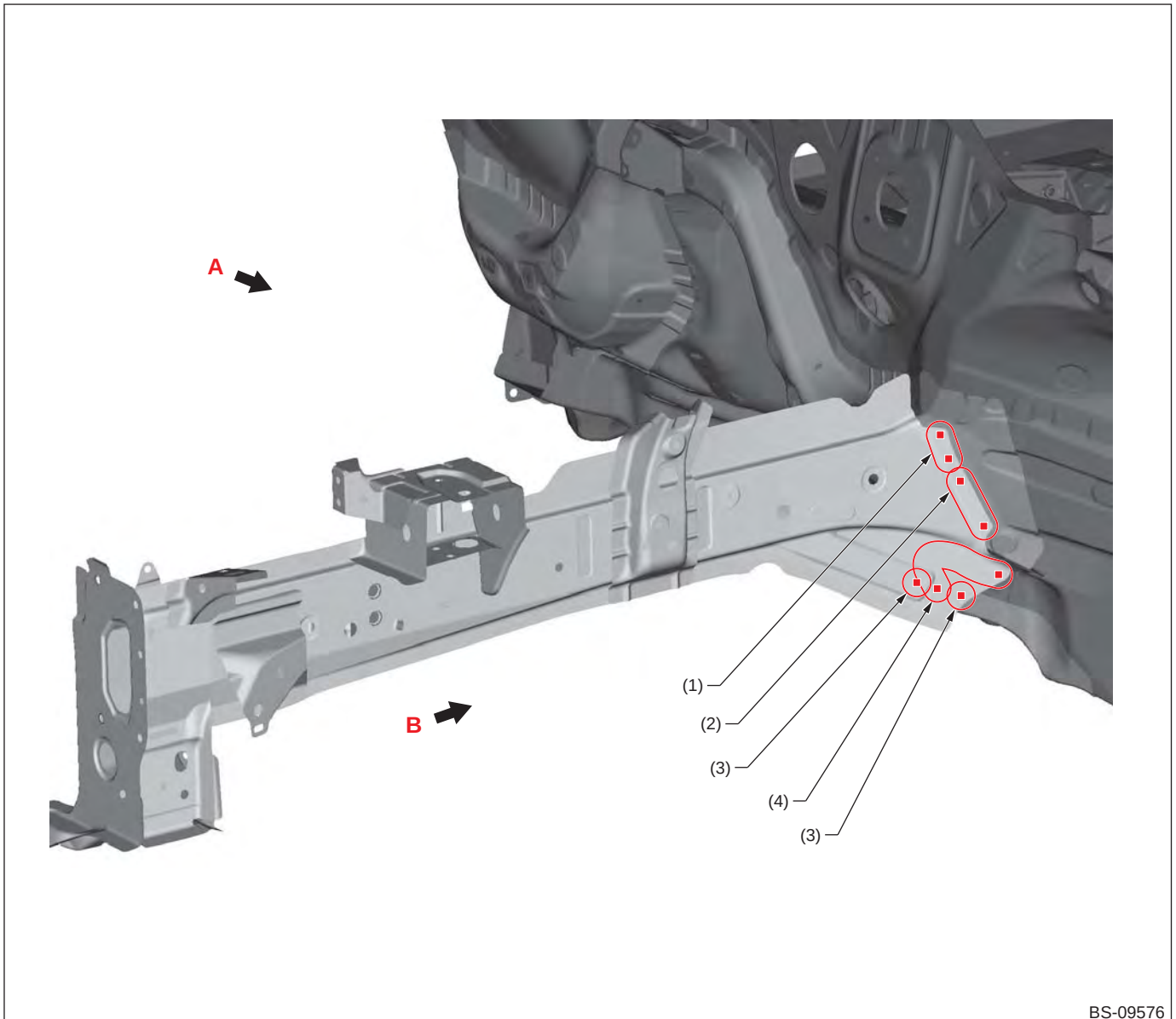
• Views B



- | | | |
|---------------------------|---------------------------|----------------------------|
| (1) 2 points (inside · 1) | (4) 3 points (bottom · 1) | (7) 2 points (outside · 1) |
| (2) 1 point (inside · 2) | (5) 1 point (bottom · 1) | |
| (3) 3 points (bottom · 2) | (6) 2 points (bottom · 1) | |

B: INSTALLATION

• Overall view



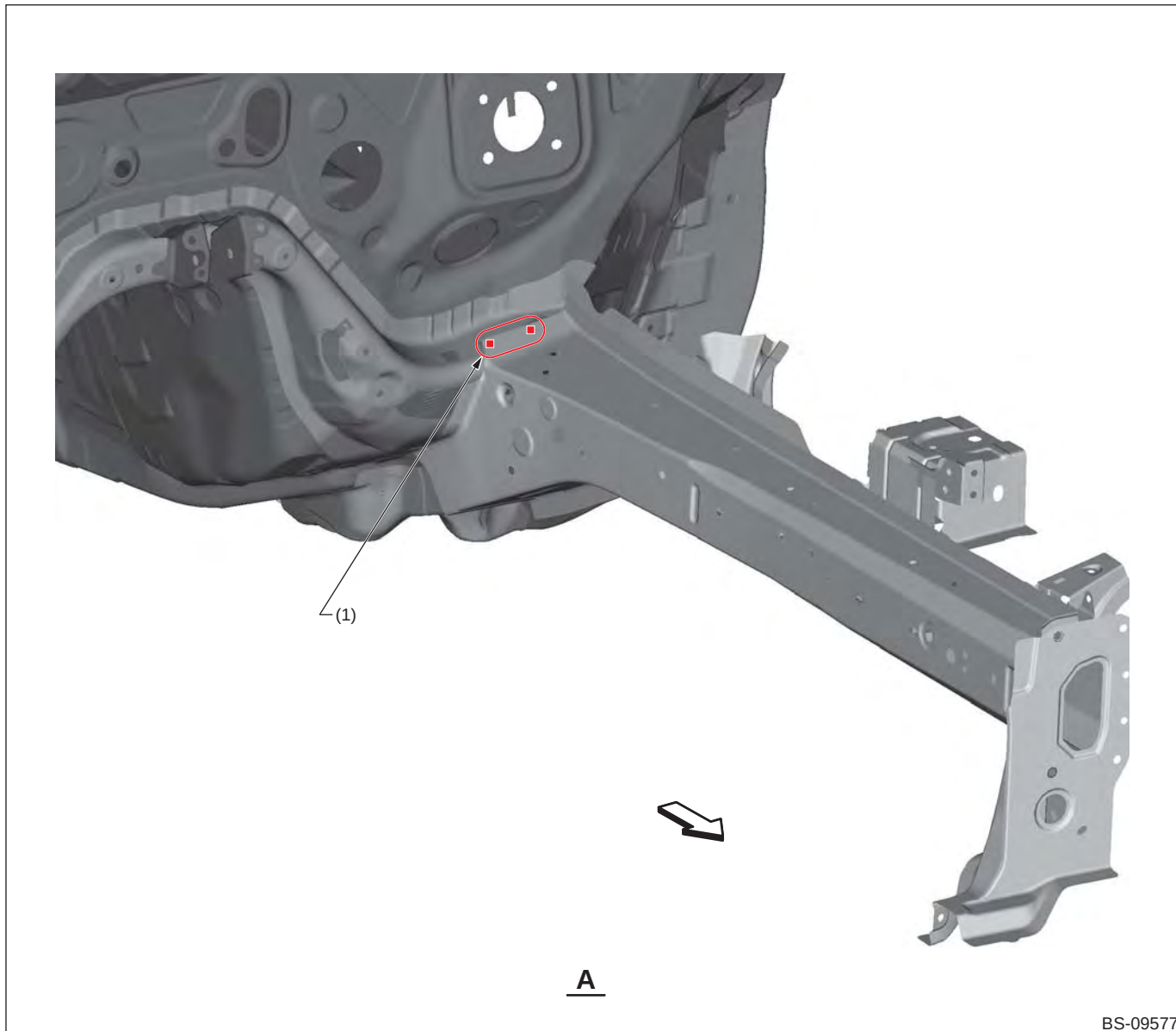
(1) 2 points (service)
(2) 3 points (service)

(3) 1 point (service)

(4) 5 points (service)

Panel Replacement

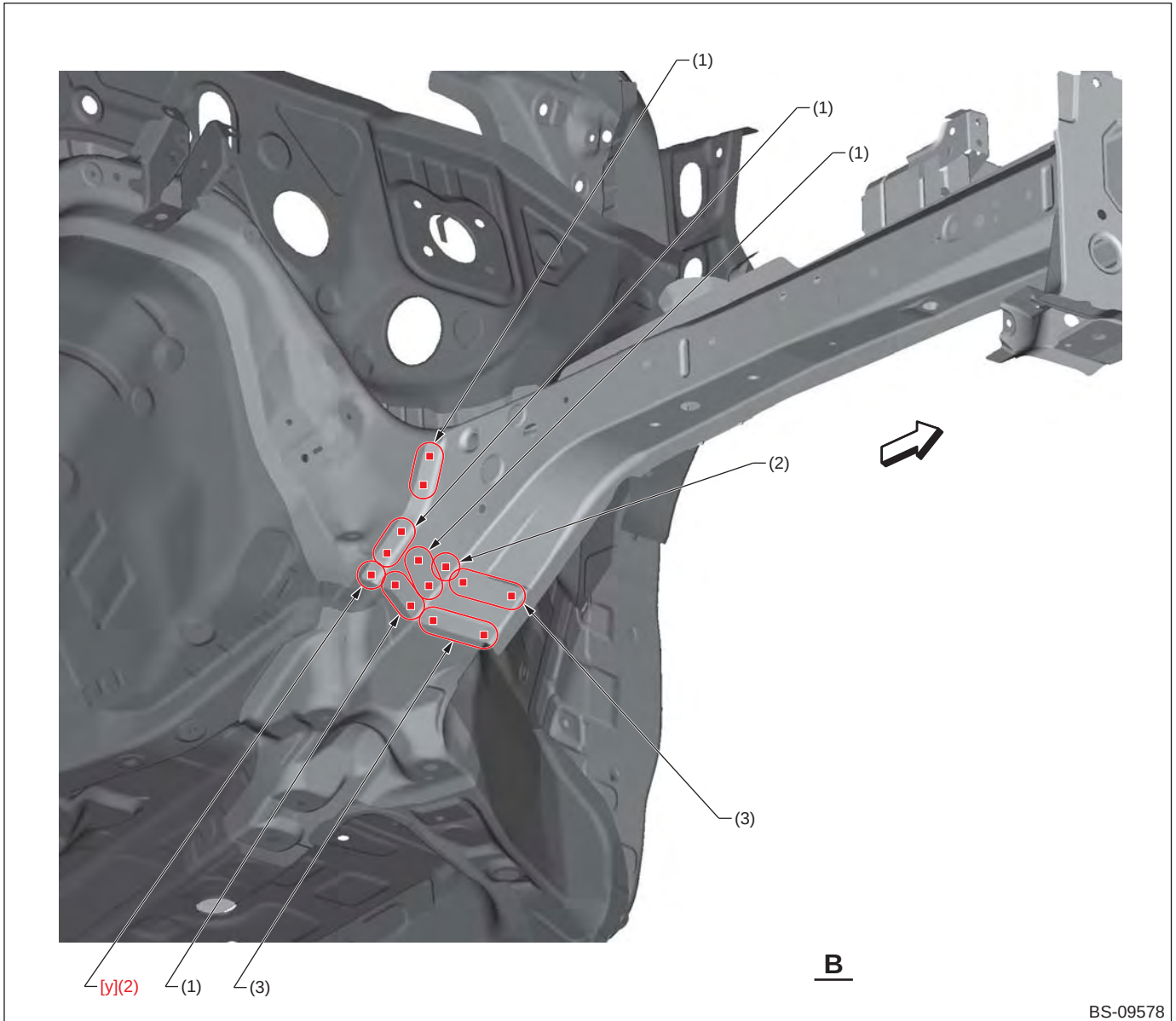
- Views A



(1) 3 points (service)

Panel Replacement

• Views B



BS-09578

(1) 2 points (service)

(2) 1 point (service)

(3) 3 points (service)

[y] Plug welding

A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2

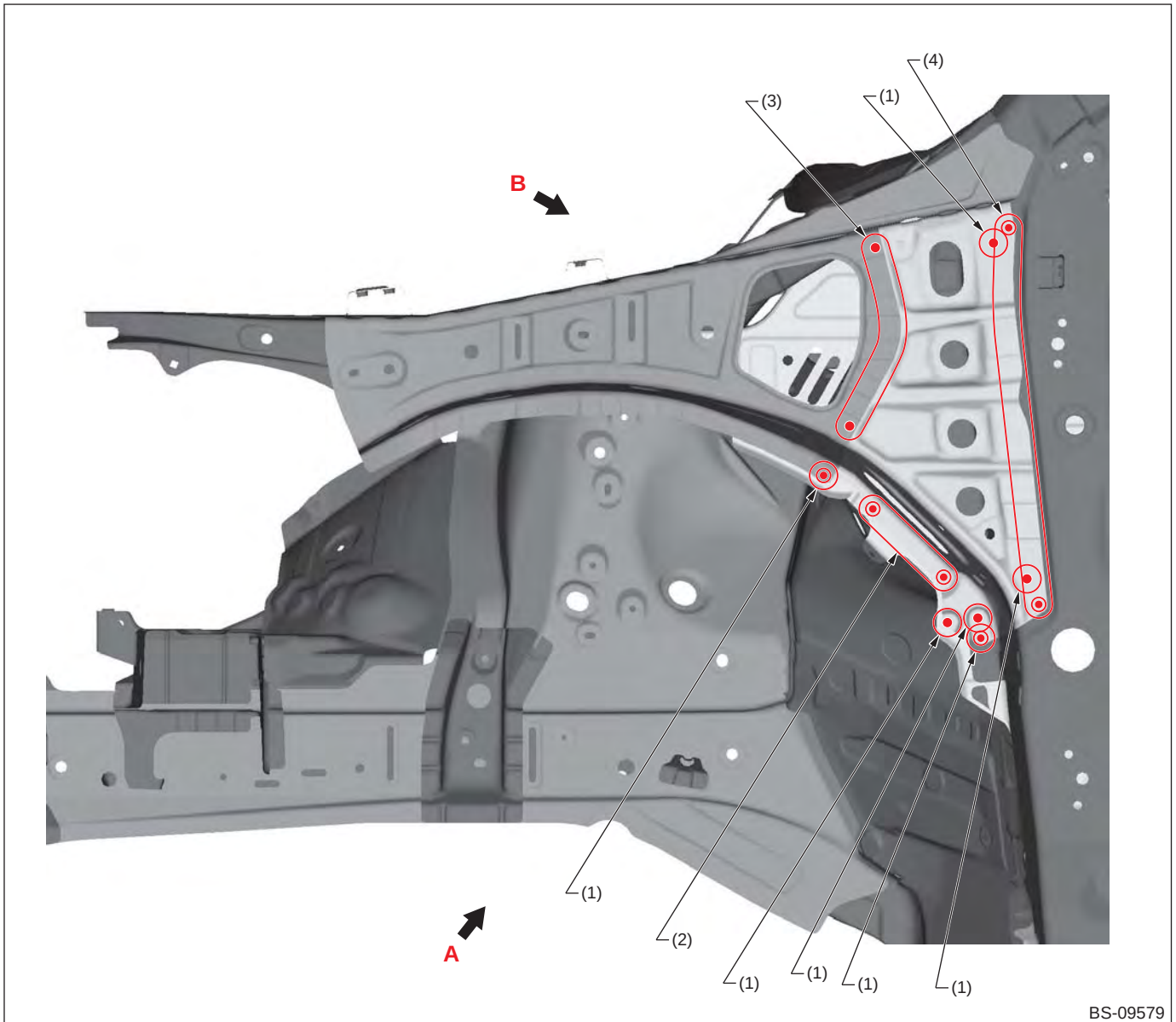
B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

8-10. Front Pillar Outer (Partial replacement)

A: REMOVAL

• Overall view 1



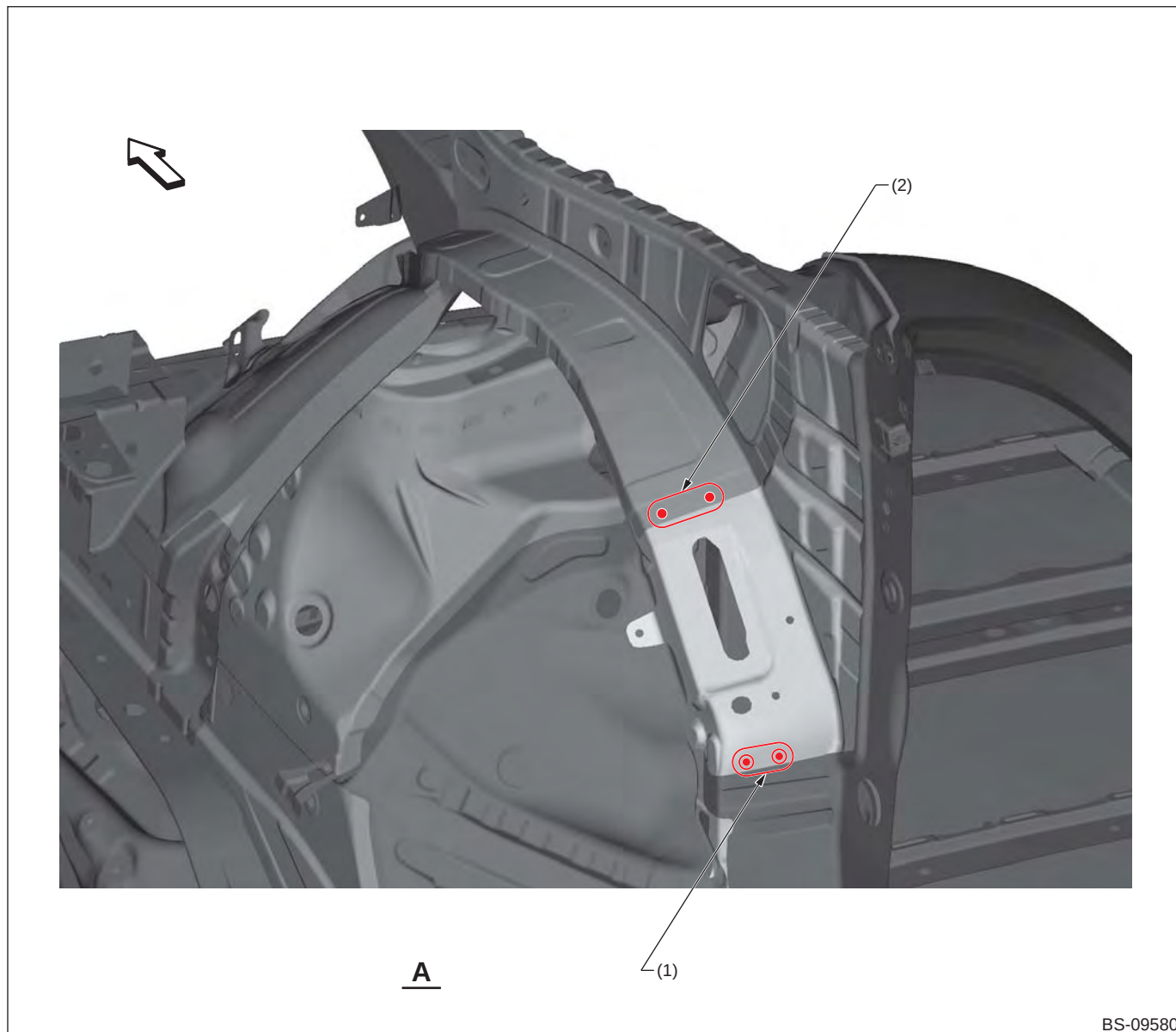
- (1) 1 point (outside · 1)
(2) 4 points (outside · 1)

- (3) 5 points (outside · 1)

- (4) 7 points (outside · 1)

Panel Replacement

• Views A



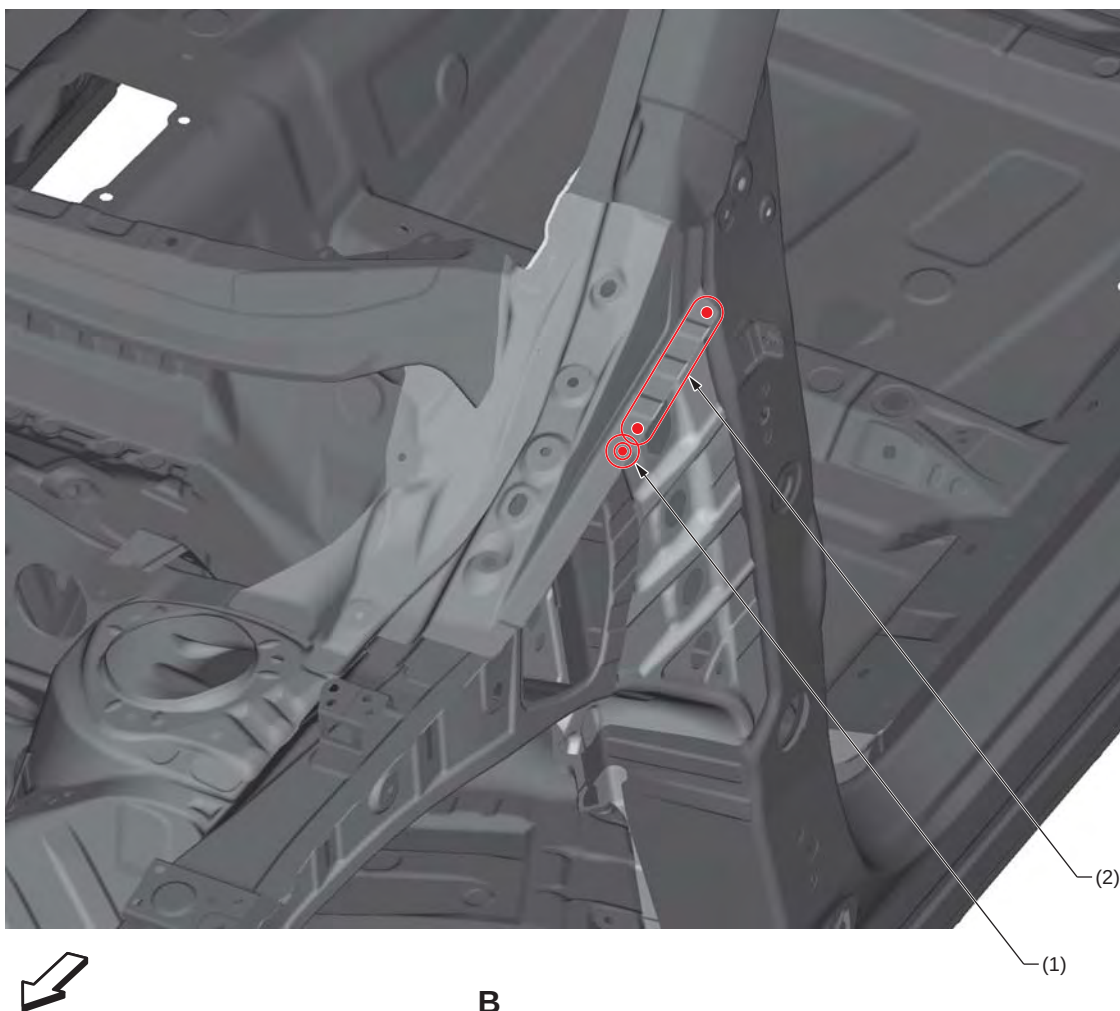
(1) 2 points (outside · 1)

(2) 3 points (outside · 1)

BS-09580

Panel Replacement

• Views B



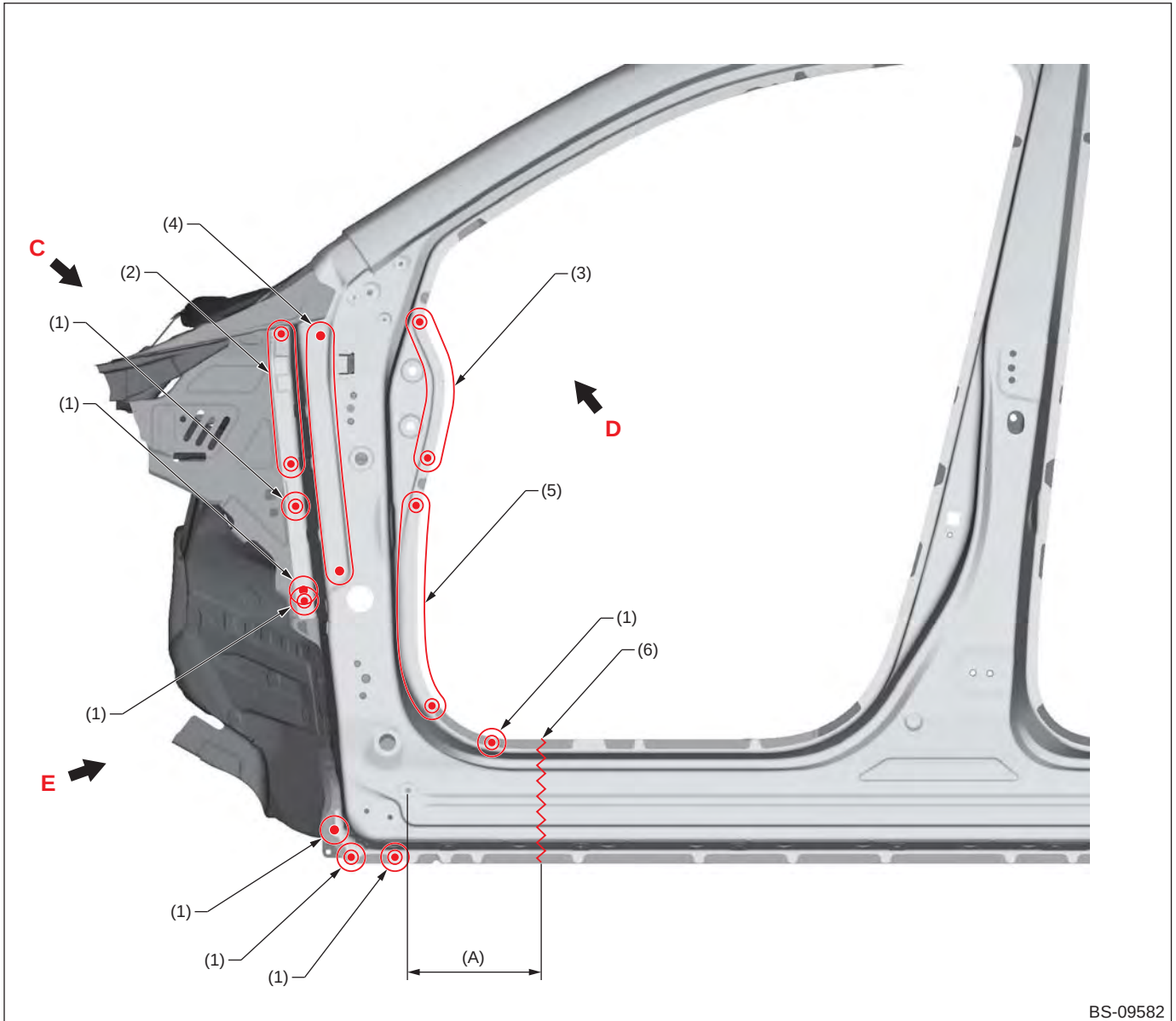
BS-09581

(1) 4 points (bottom · 1)

(2) 1 point (bottom · 2)

Panel Replacement

• Overall view 2



(A) 217 mm [8.54 in]

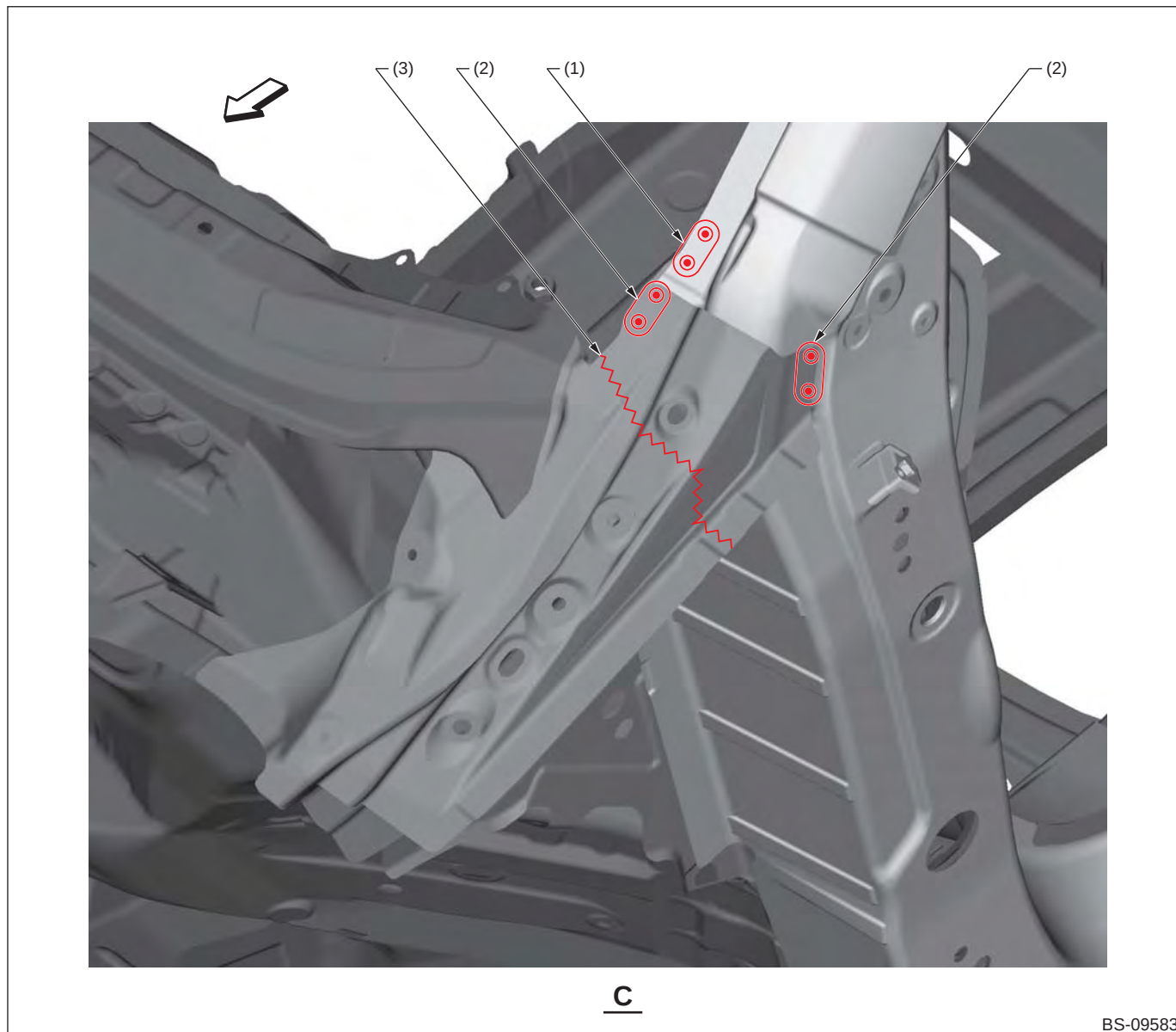
(1) 1 point (outside · 1)
(2) 4 points (outside · 1)

(3) 6 points (outside · 1)
(4) 7 points (outside · 1)

(5) 13 points (outside · 1)
(6) Cut position

Panel Replacement

• Views C



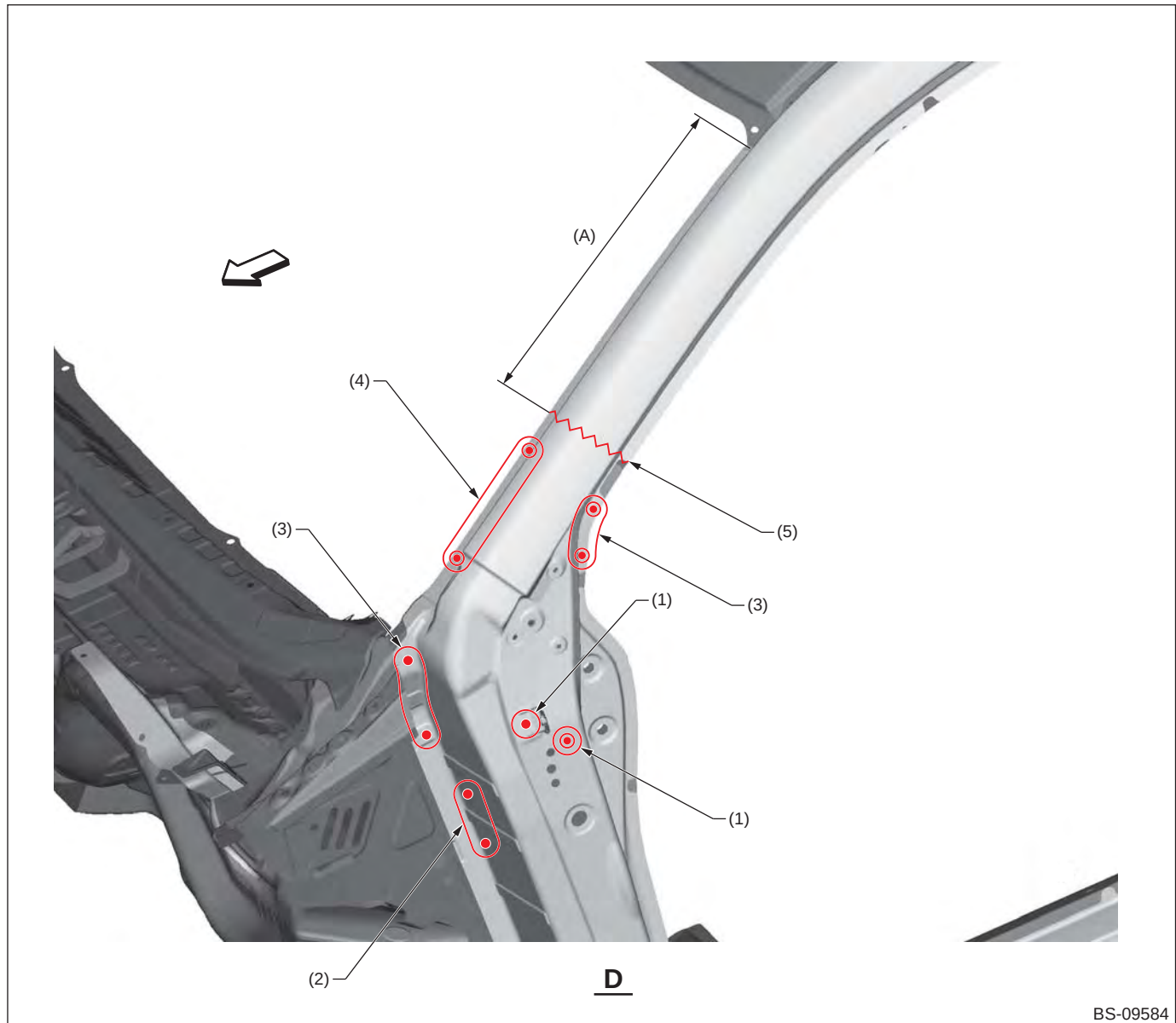
(1) 2 points (outside · 1)

(2) 2 points (outside · 2)

(3) Rough cutting

Panel Replacement

• Views D



BS-09584

(A) 416 mm [16.38 in]

(1) 1 point (outside · 1)

(2) 2 points (outside · 1)

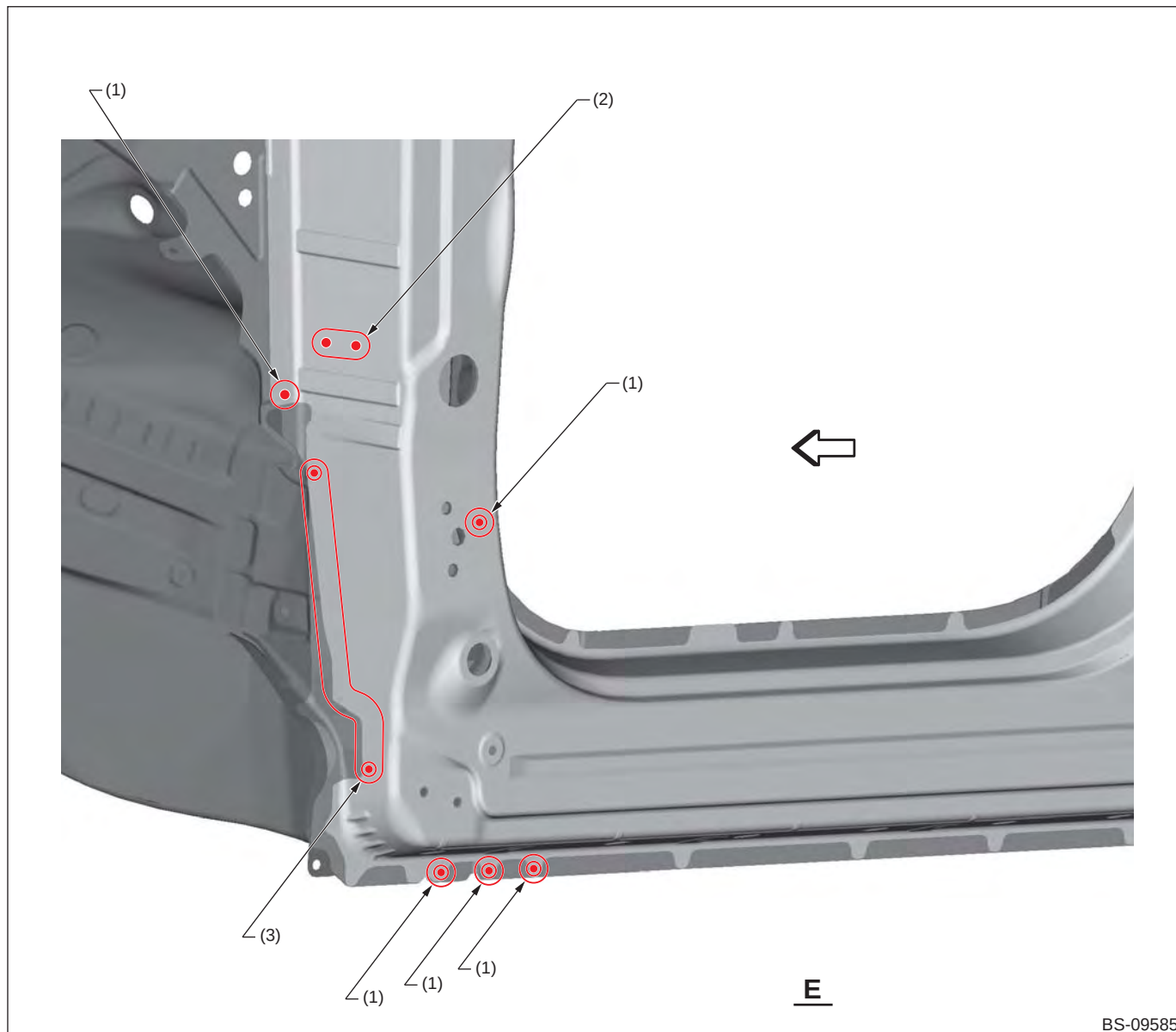
(3) 3 points (outside · 1)

(4) 5 points (outside · 1)

(5) Cut position

Panel Replacement

• Views E



BS-09585

(1) 1 point (outside · 1)

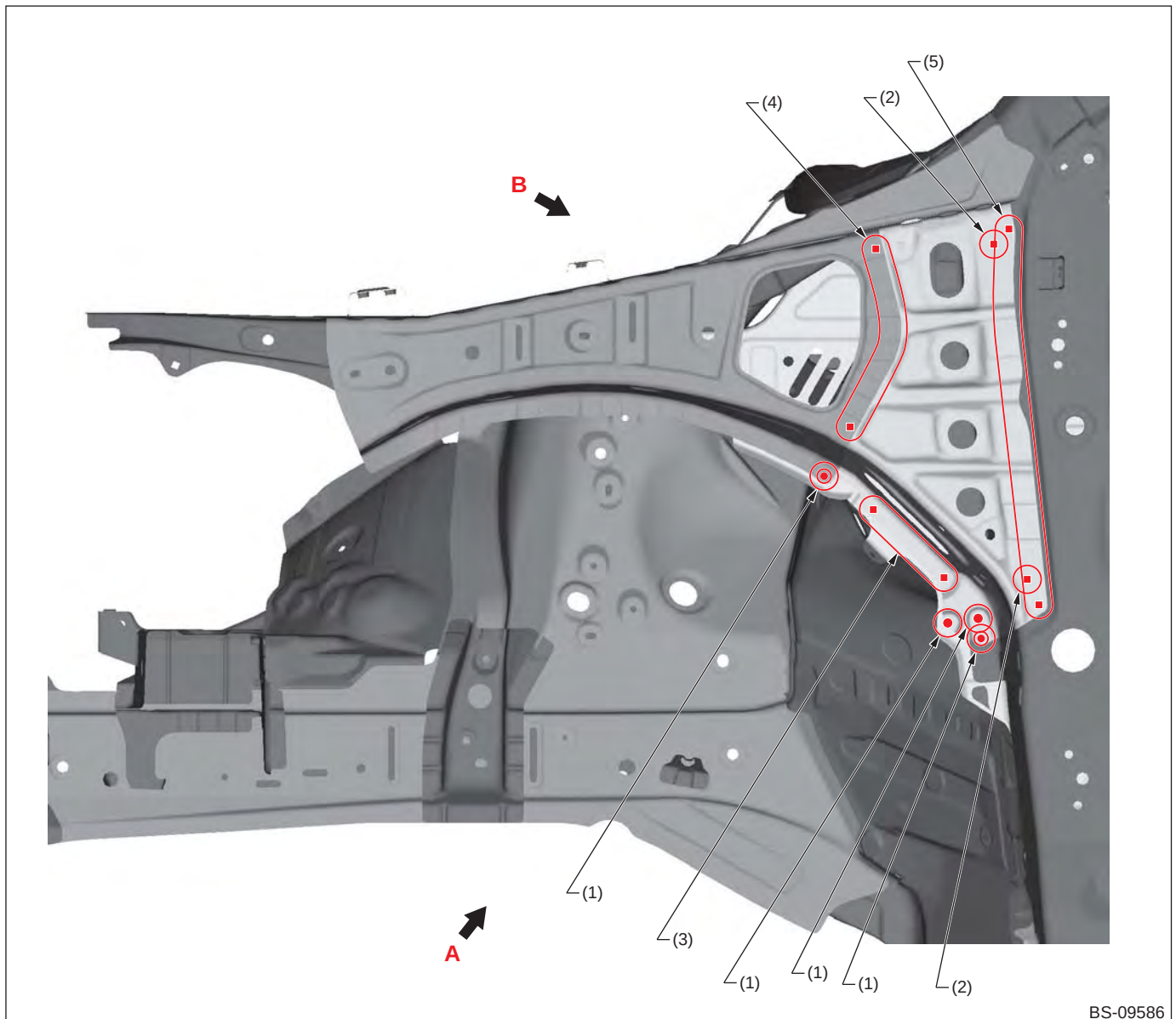
(2) 2 points (outside · 1)

(3) 5 points (outside · 1)

Panel Replacement

B: INSTALLATION

• Overall view 1



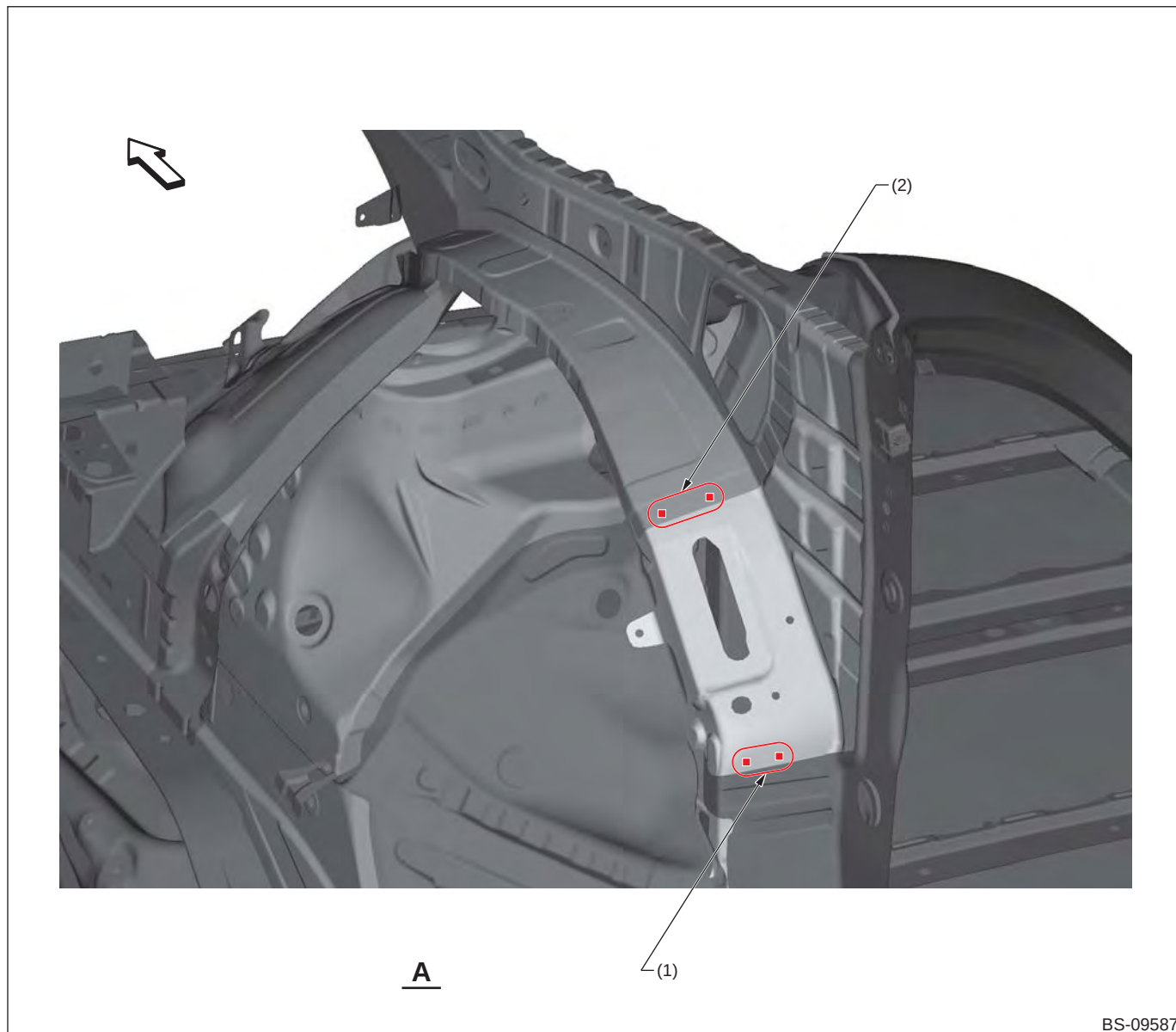
(1) 1 point
(2) 1 point (service)

(3) 4 points (service)
(4) 5 points (service)

(5) 7 points (service)

Panel Replacement

• Views A



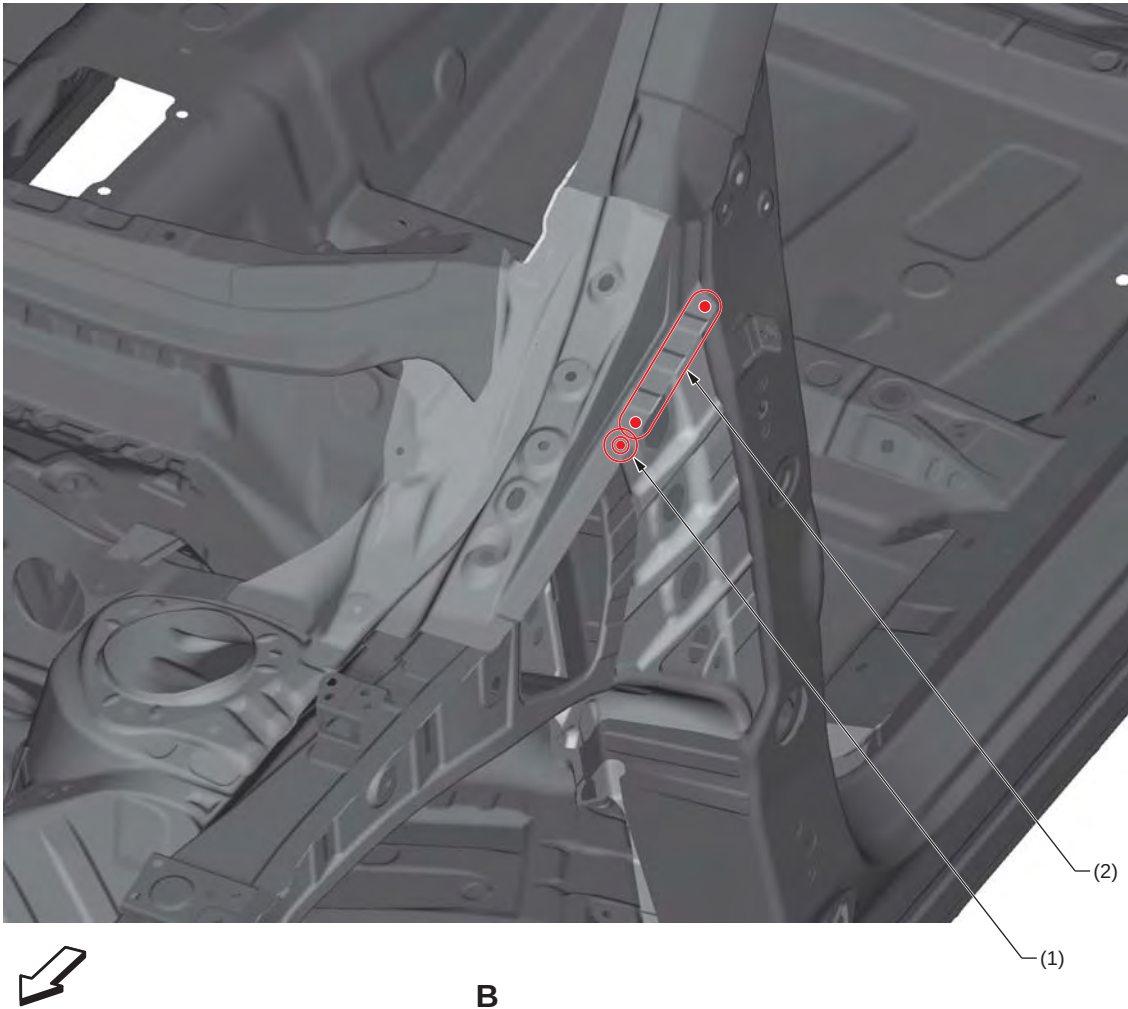
BS-09587

(1) 2 points (service)

(2) 3 points

Panel Replacement

- Views B



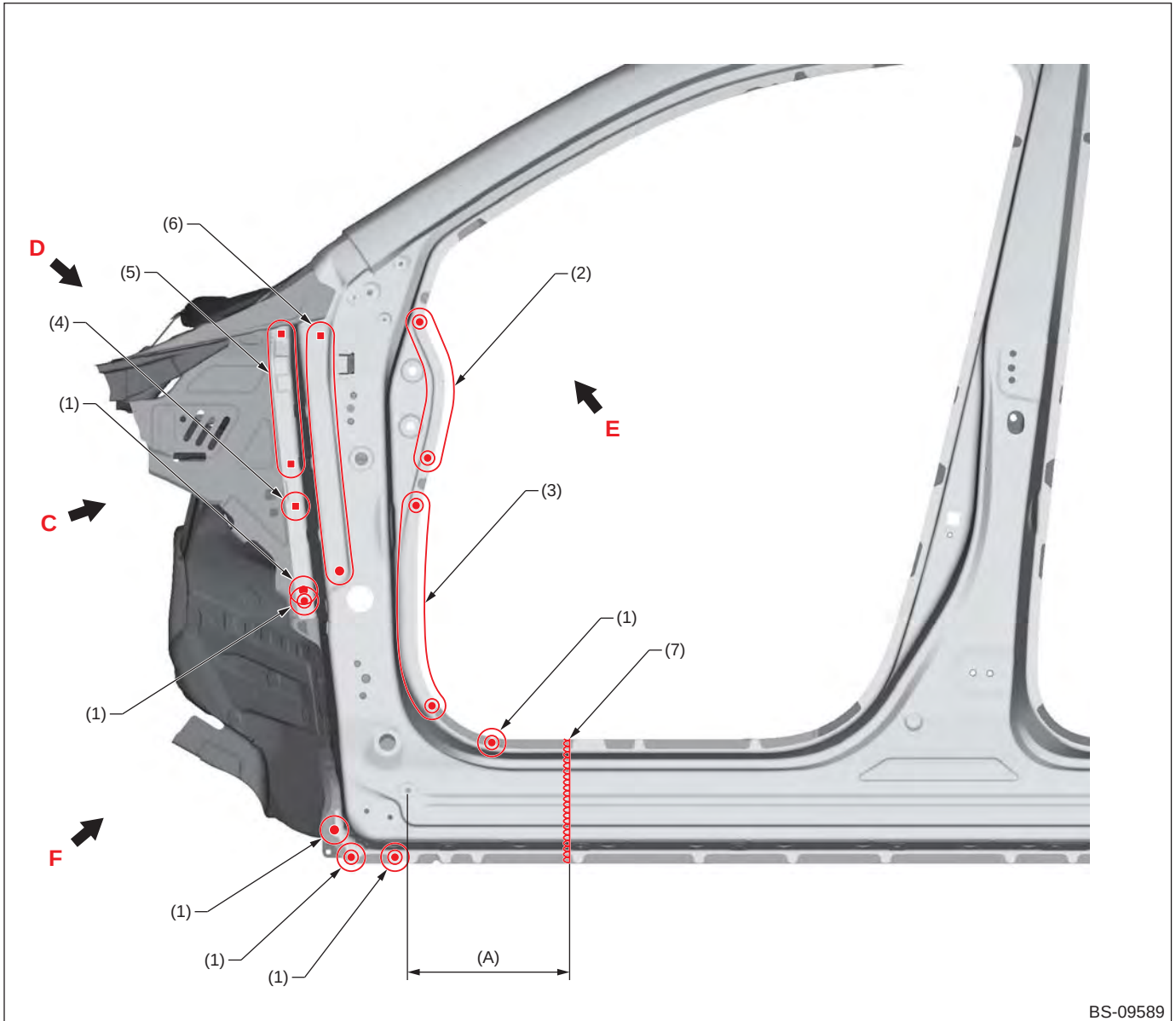
BS-09588

(1) 1 point

(2) 4 points

Panel Replacement

• Overall view 2



(A) 261 mm [10.28 in]

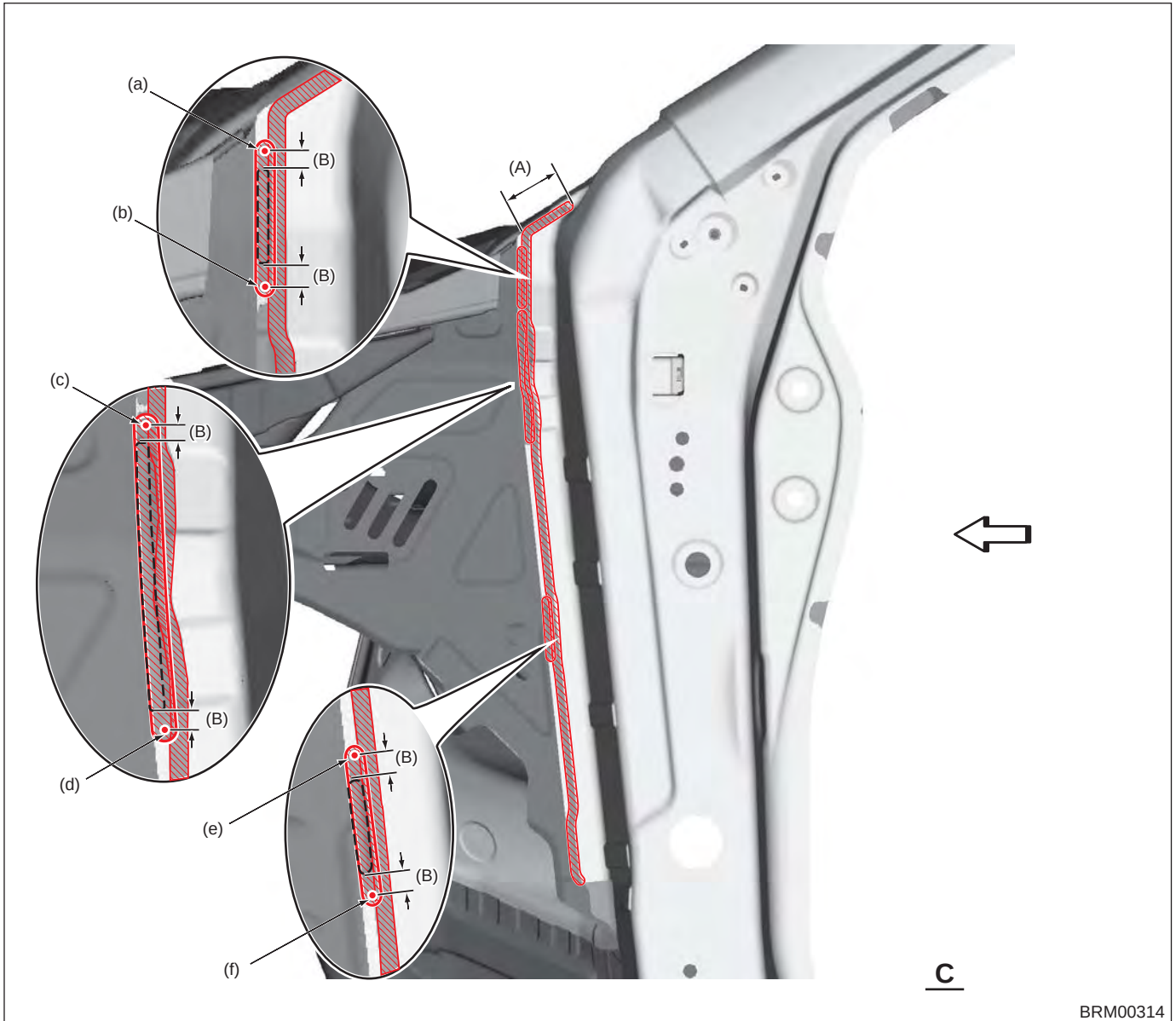
- (1) 1 point
- (2) 6 points
- (3) 13 points

- (4) 1 point (service)
- (5) 4 points (service)
- (6) 7 points (service)

- (7) 1 point (Continuous welding)

Panel Replacement

• Views C



BRM00314

(A) 50 mm [1.97 in]

(B) 5 mm [0.20 in]

(a) A point

(c) C point

(e) E point

(b) B point

(d) D point

(f) F point

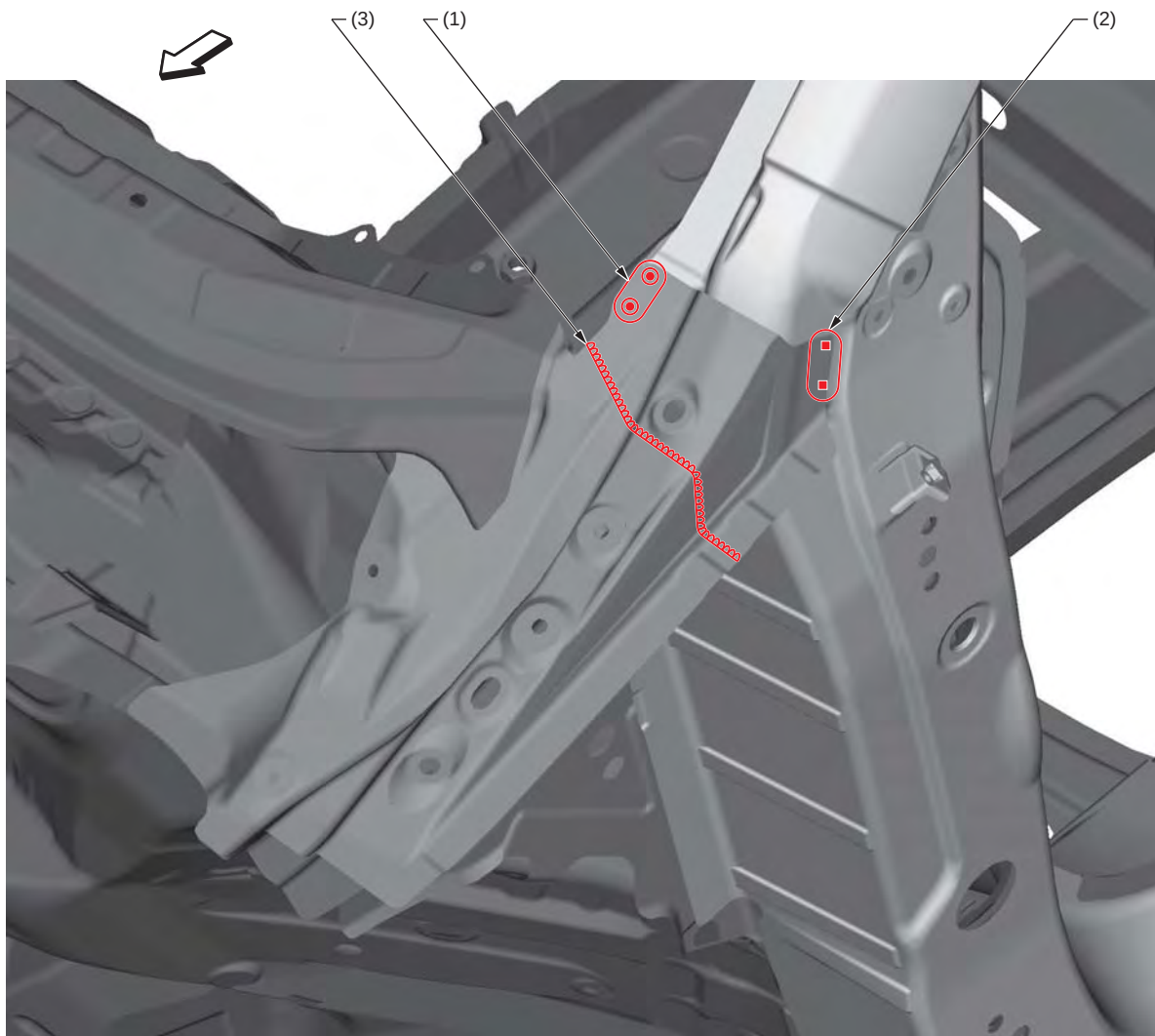
 : Spotting sealer application location (Spotting sealer or sealing [Three Bond 4101 (004403063)])

Note:

- For (a) — (b), (c) — (d) and (e) — (f), apply adhesive in two rows.
- For (a) — (b), (c) — (d) and (e) — (f), lay the first and second rows and apply adhesive.
- For the second row of (a) — (b), (c) — (d) and (e) — (f), apply adhesive to the side panel outer R tangent.

Panel Replacement

• Views D



D

BS-09591

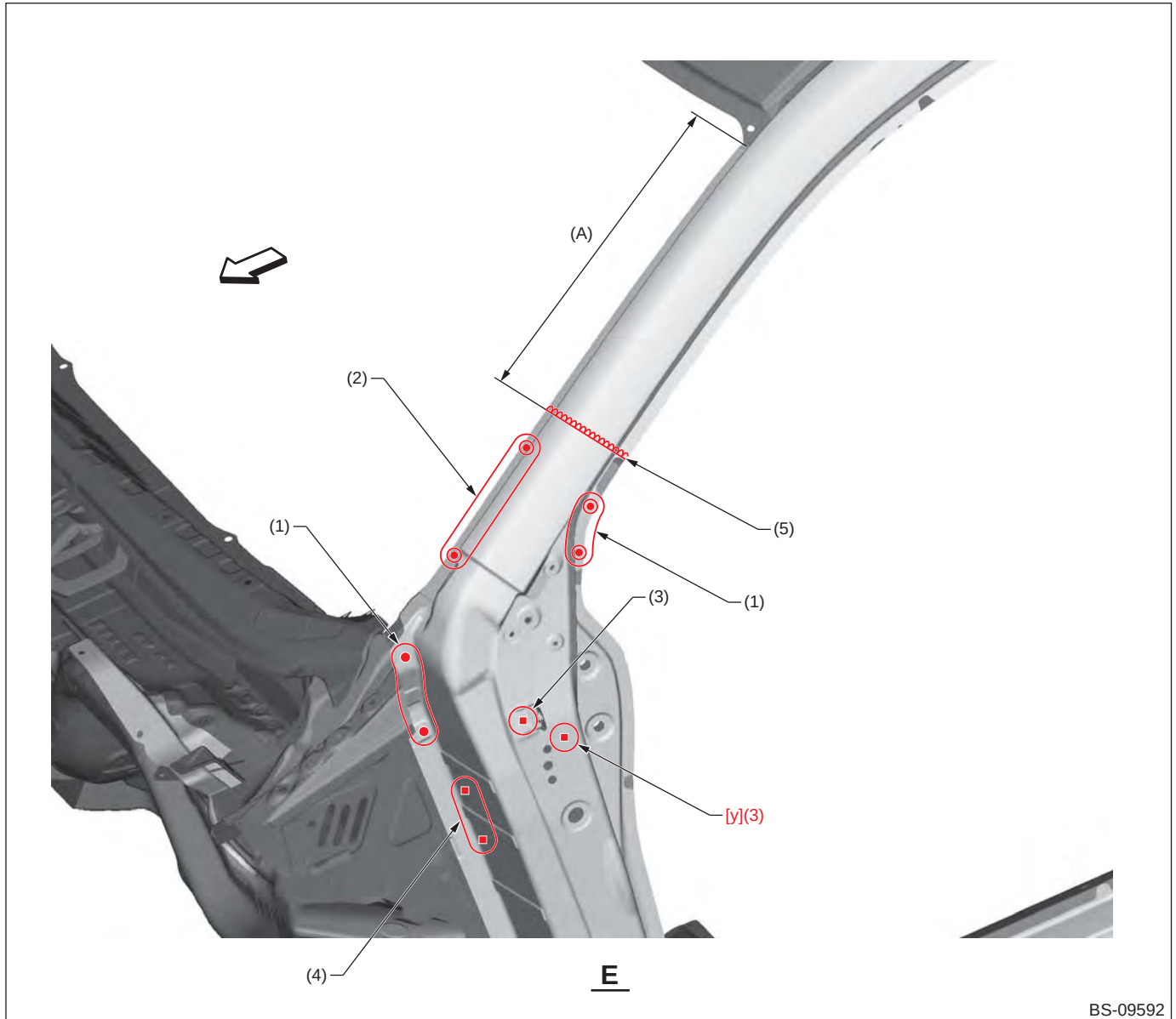
(1) 2 points

(2) 2 points (service)

(3) 1 point (Continuous welding)

Panel Replacement

• Views E



BS-09592

(A) 416 mm [16.38 in]

(1) 3 points

(2) 5 points

(3) 1 point (service)

(4) 2 points (service)

(5) 1 point (Continuous welding)

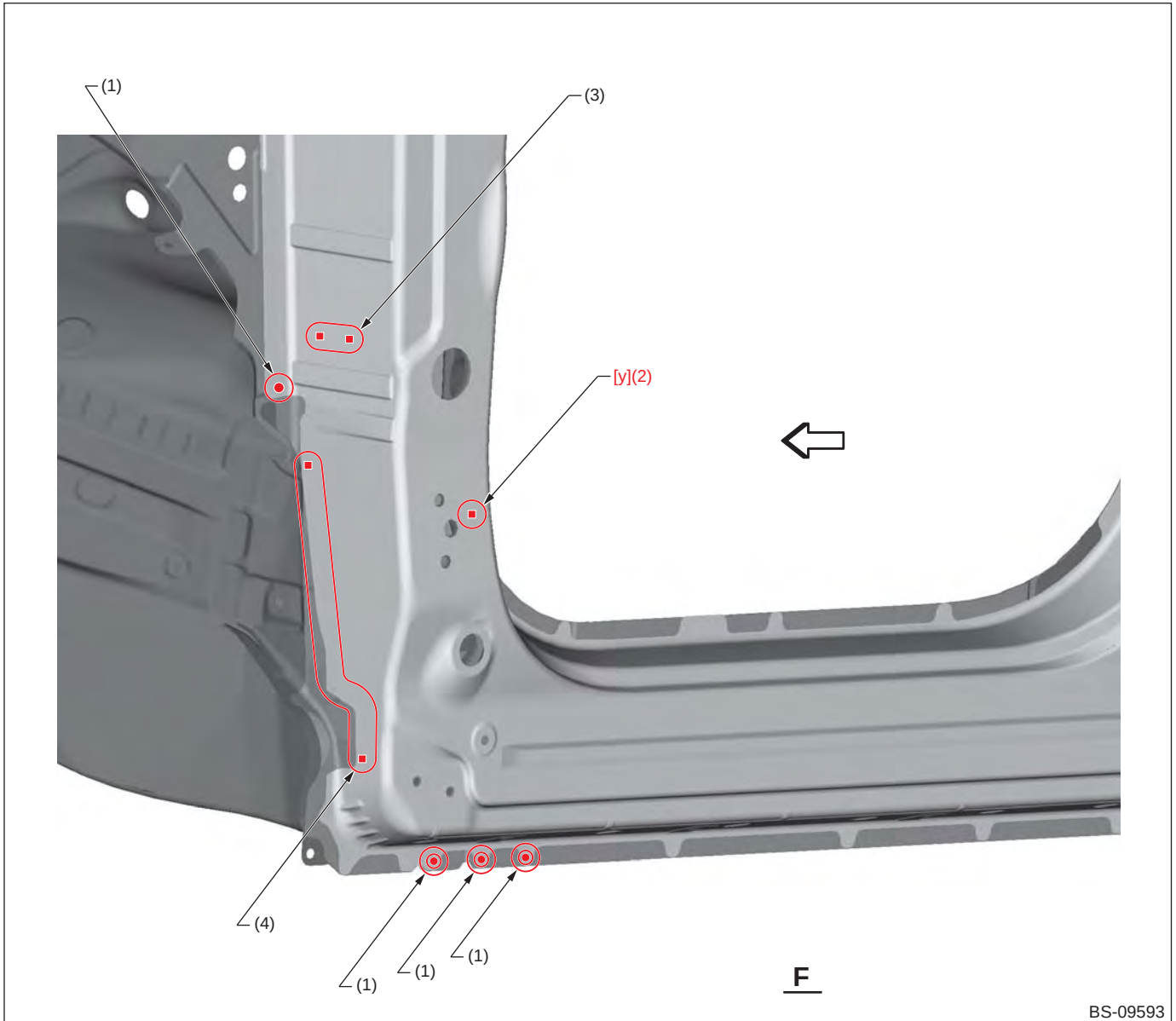
[y] Plug welding

A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2

B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

• Views F



BS-09593

(1) 1 point

(2) 1 point (service)

(3) 2 points (service)

(4) 5 points (service)

[y] Plug welding

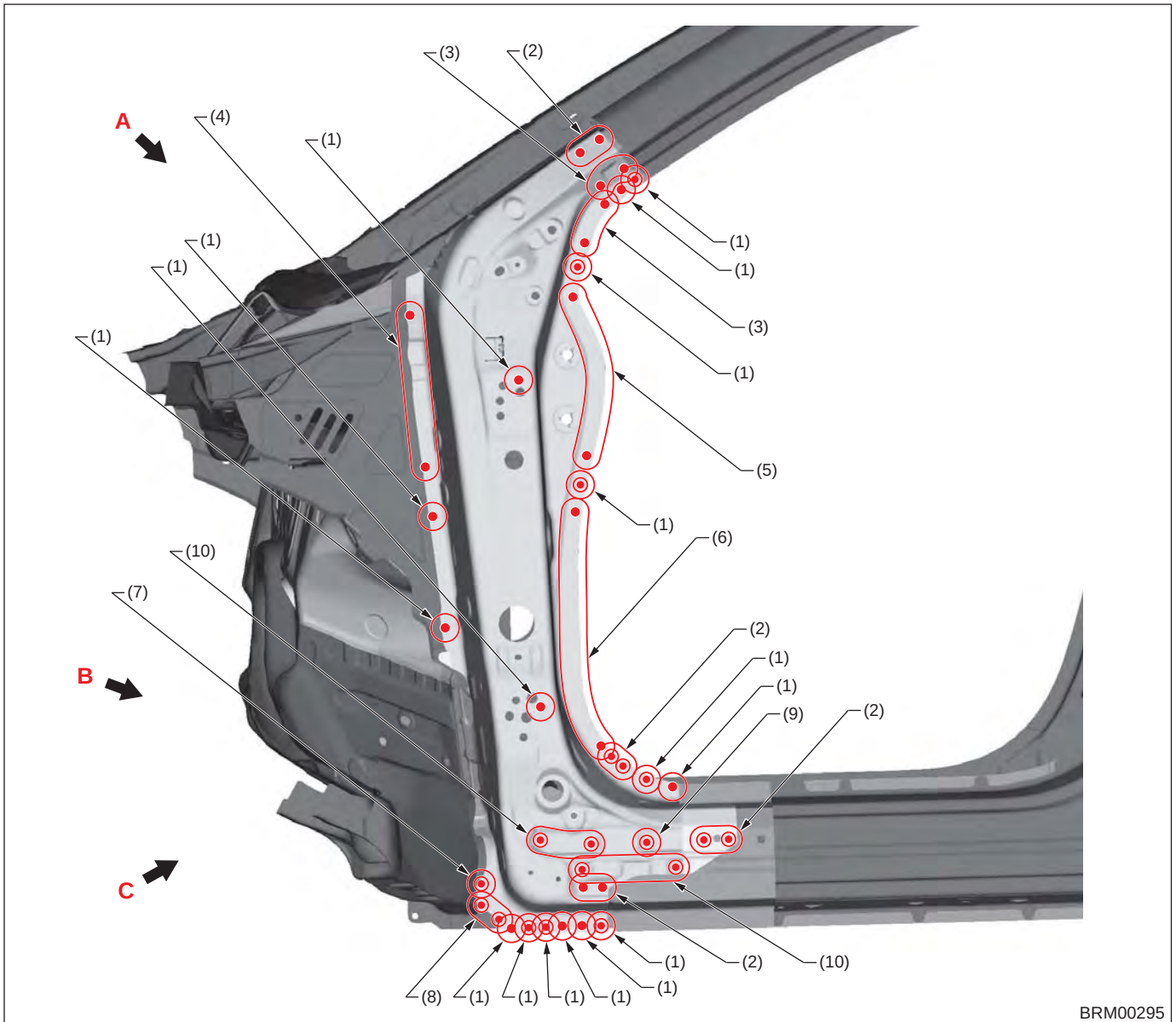
A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2

B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

8-11. Front Pillar Reinforcement (Total replacement)

A: REMOVAL

• Overall view

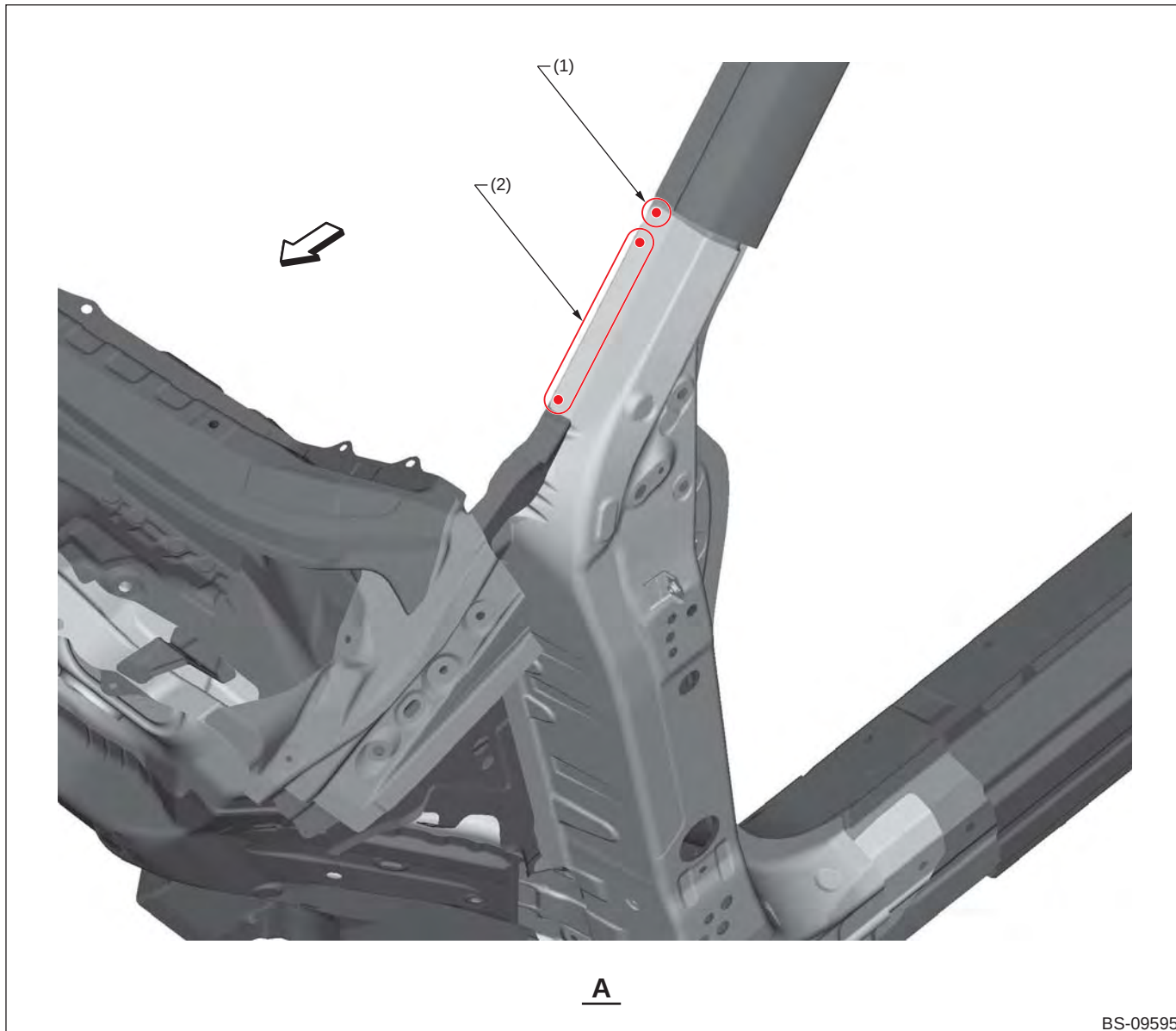


BRM00295

- | | | |
|----------------------------|-----------------------------|-----------------------------|
| (1) 1 point (outside · 1) | (5) 6 points (outside · 1) | (9) 1 point (outside · 2) |
| (2) 2 points (outside · 1) | (6) 13 points (outside · 1) | (10) 3 points (outside · 2) |
| (3) 3 points (outside · 1) | (7) 1 point (inside · 1) | |
| (4) 4 points (outside · 1) | (8) 2 points (inside · 1) | |

Panel Replacement

• Views A

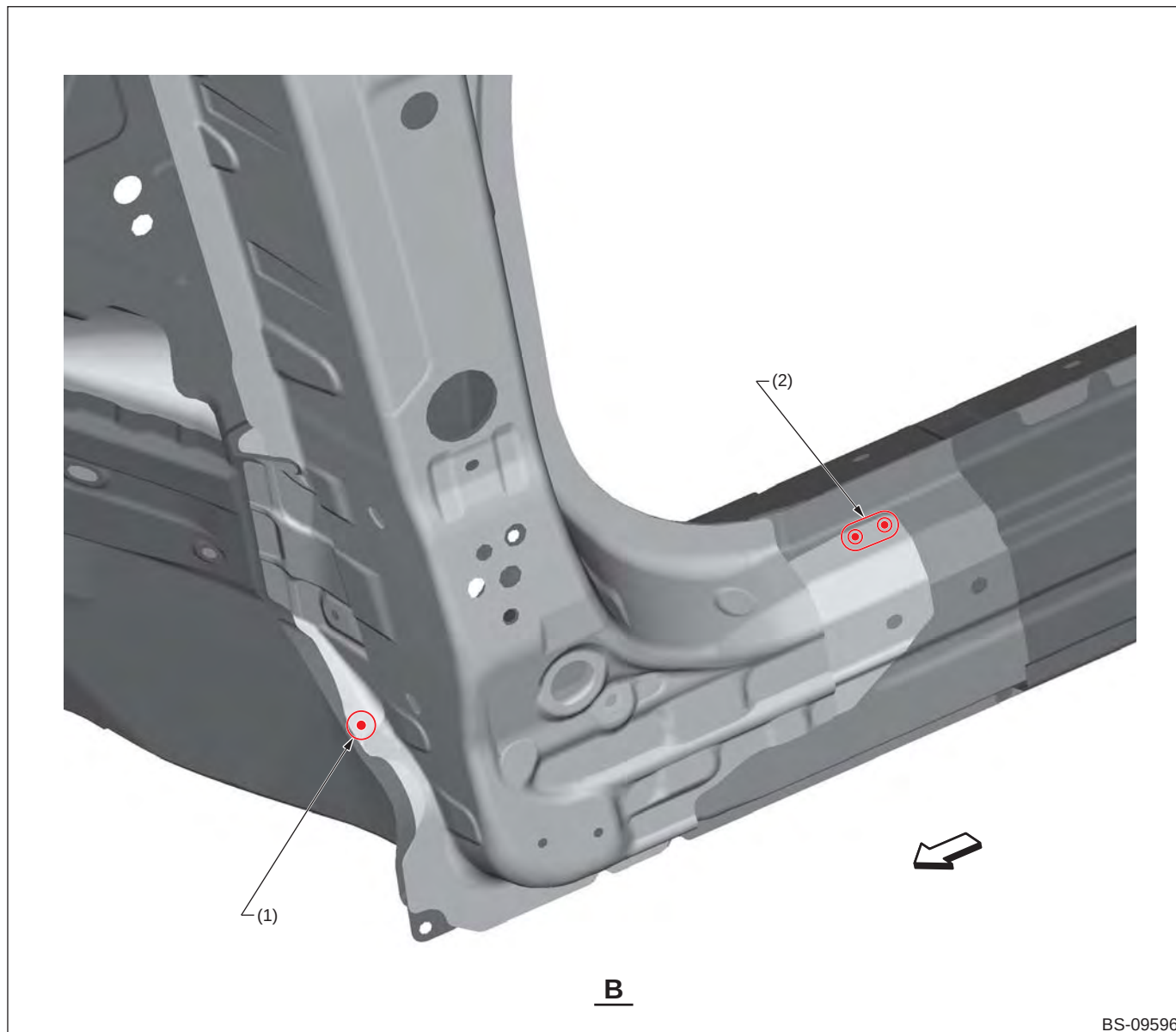


(1) 1 point (outside · 1)

(2) 5 points (outside · 1)

Panel Replacement

• Views B

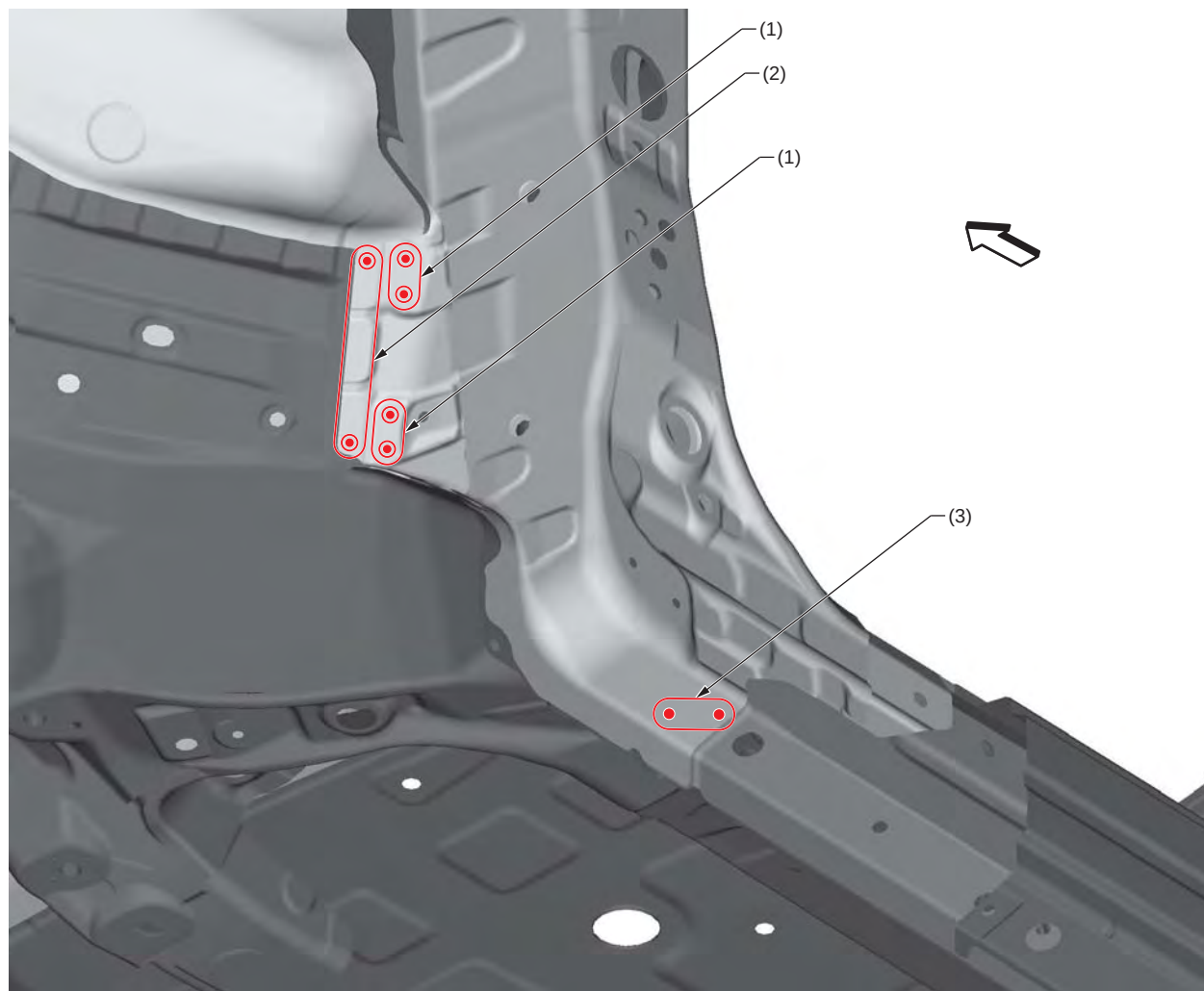


(1) 1 point (outside · 1)

(2) 2 points (top · 1)

Panel Replacement

• Views C



C

BS-09597

(1) 2 points (outside · 1)

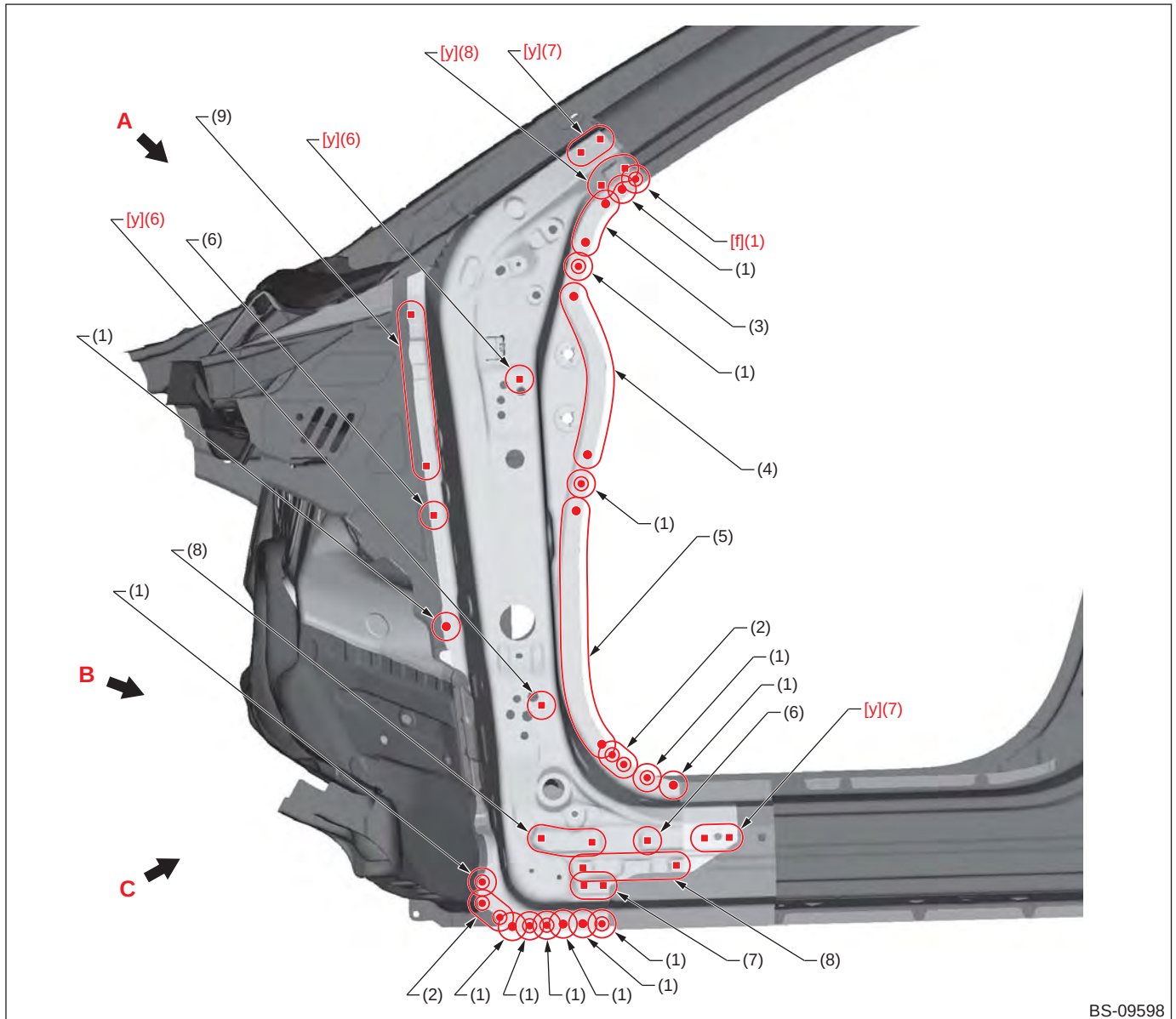
(2) 6 points (outside · 1)

(3) 2 points (bottom · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BS-09598

- (1) 1 point
- (2) 2 points
- (3) 3 points

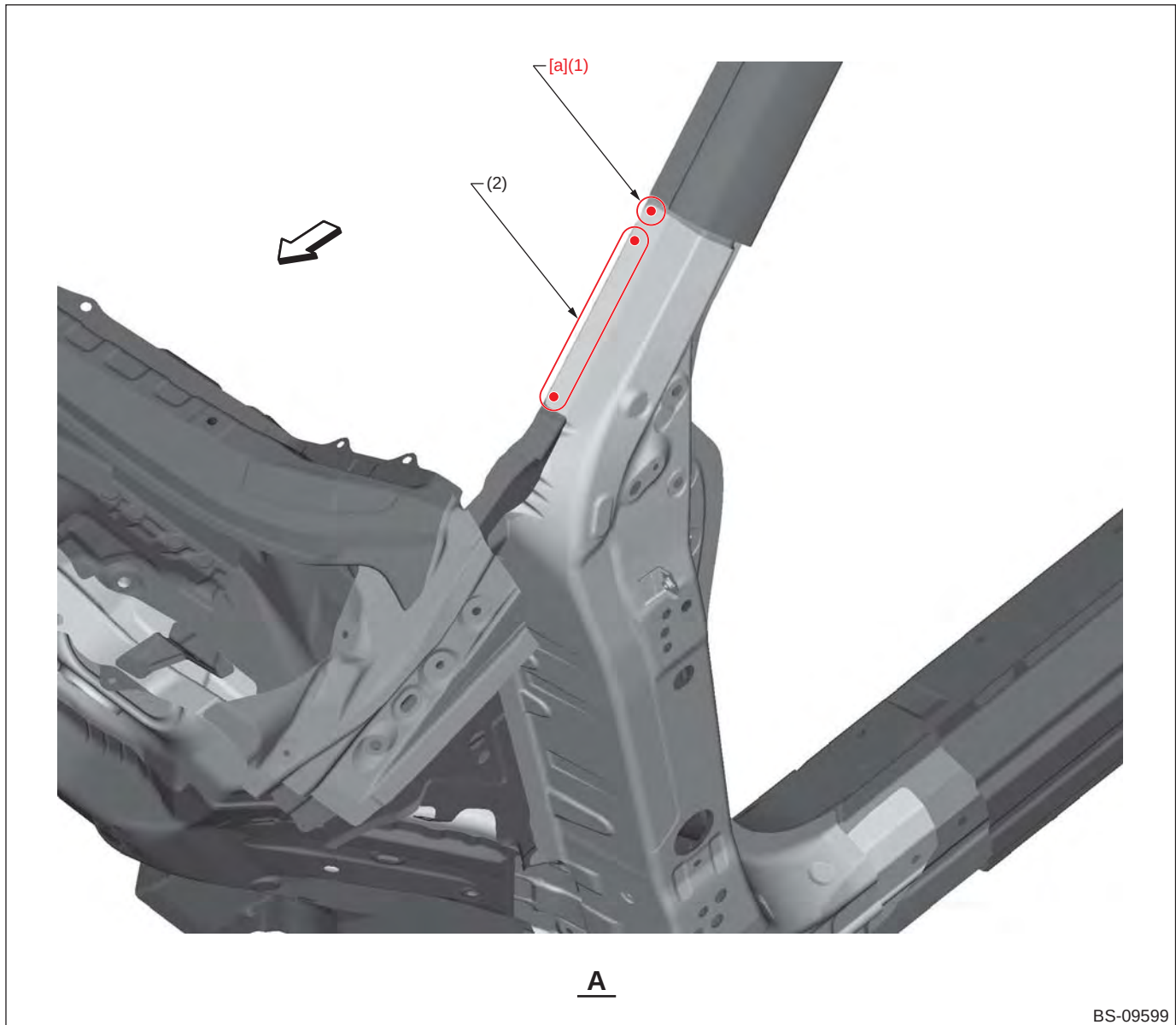
- (4) 6 points
- (5) 13 points
- (6) 1 point (service)

- (7) 2 points (service)
- (8) 3 points (service)
- (9) 4 points (service)

[f] Spot welding	Compression: 3.5 kN, Current: 8.0 kA, Welding time: 25 cyc
[y] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2 B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

• Views A



BS-09599

(1) 1 point

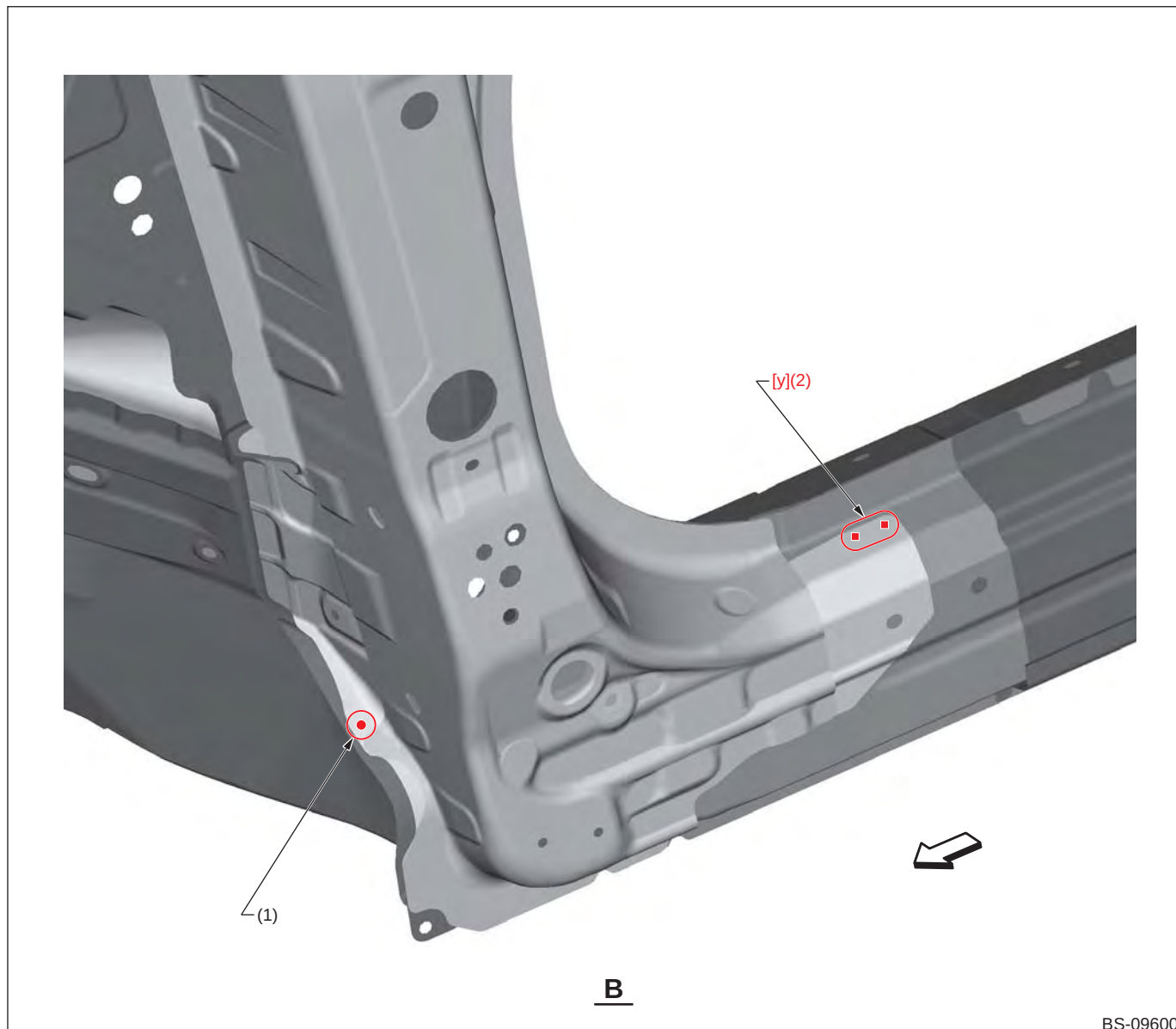
(2) 5 points

[a] Spot welding

Compression: 5.0 kN, Current: 7.5 kA, Welding time: 18 cyc

Panel Replacement

• Views B



(1) 1 point

(2) 2 points (service)

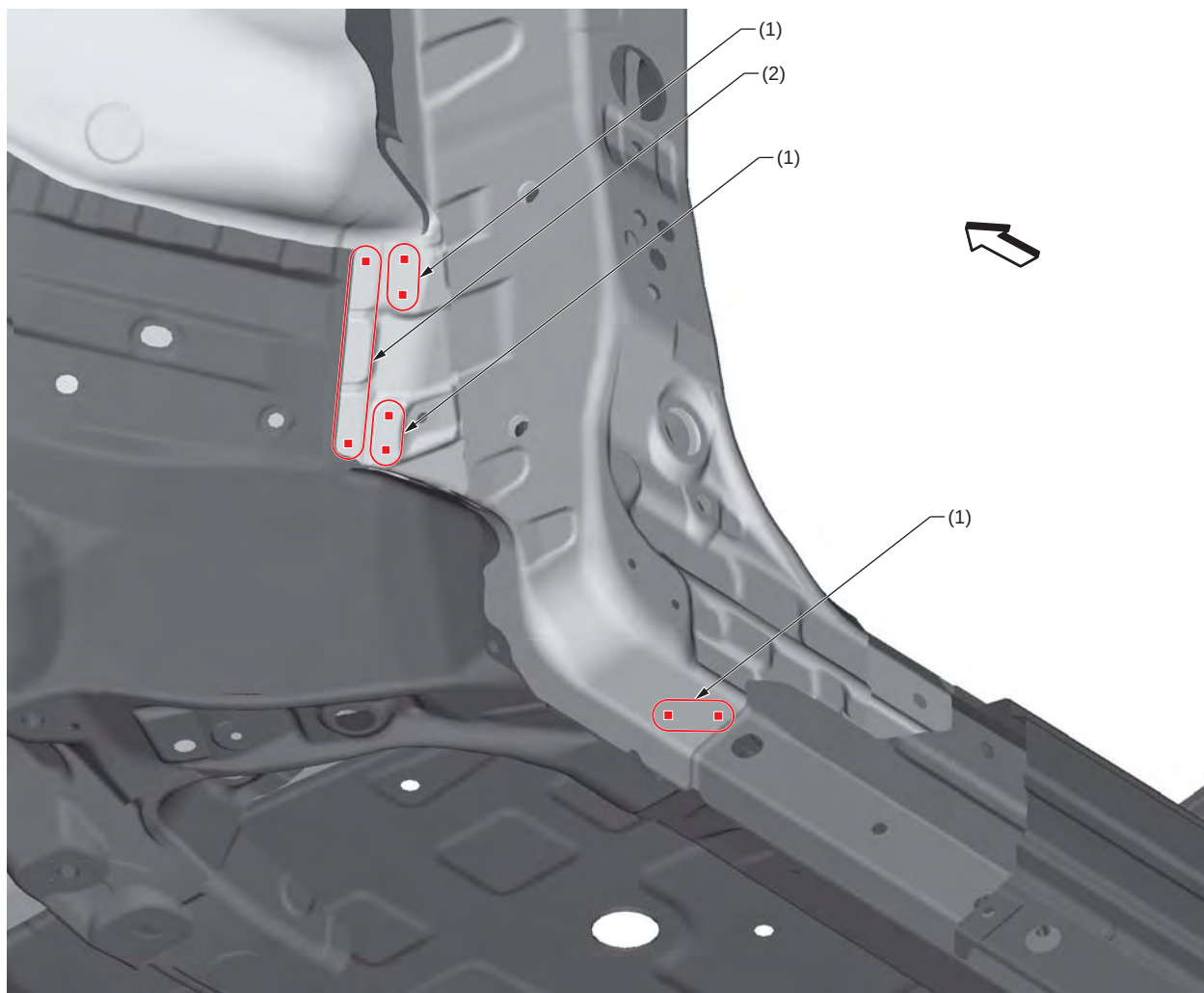
[y] Plug welding

A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2

B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

• Views C



BS-09601

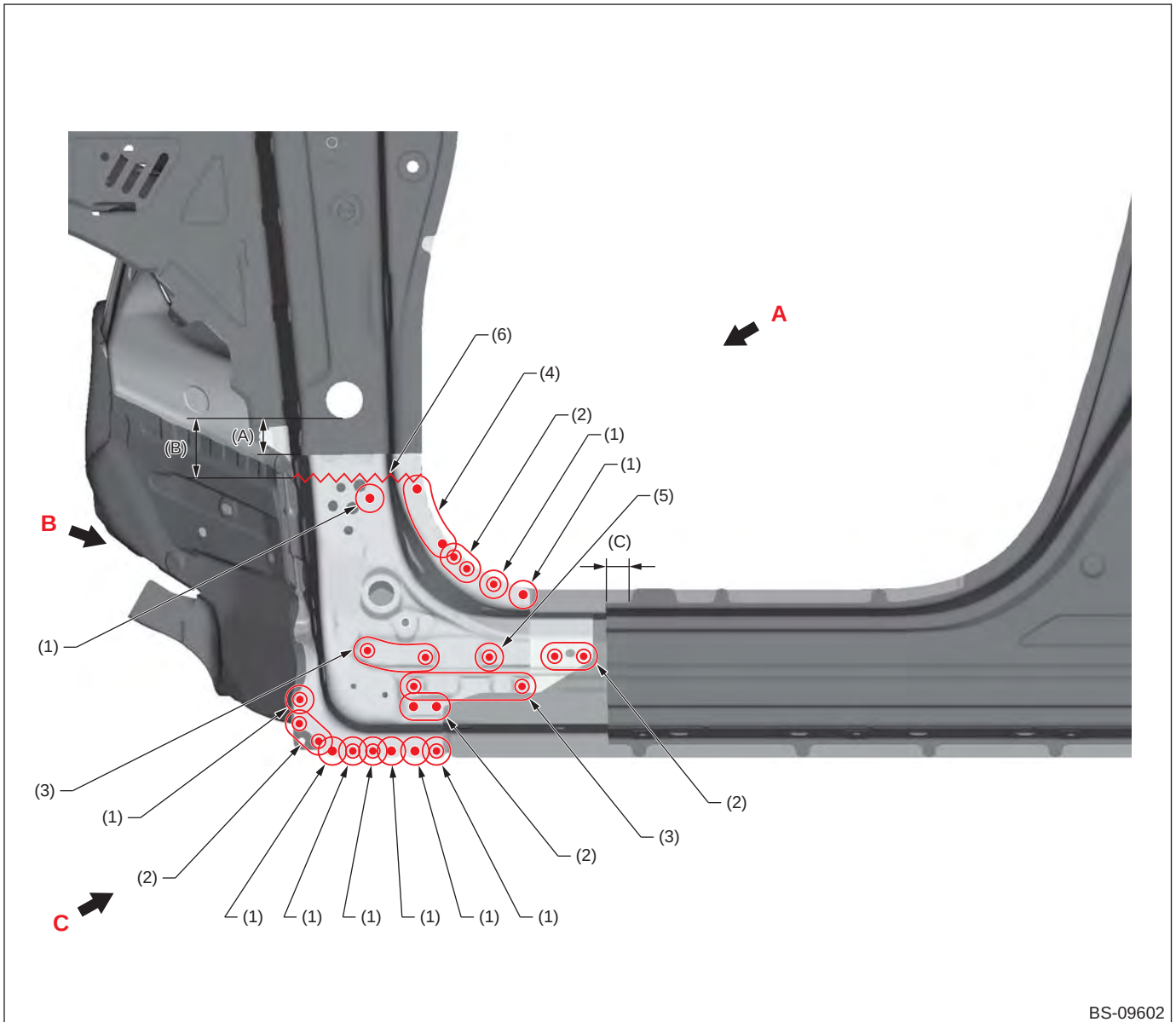
(1) 2 points (service)

(2) 6 points (service)

8-12. Front Pillar Reinforcement (Partial replacement)

A: REMOVAL

• Overall view



BS-09602

(A) 40 mm [1.57 in]

(B) 60 mm [2.36 in]

(C) 27 mm [1.06 in]

(1) 1 point (outside · 1)

(3) 3 points (outside · 2)

(5) 1 point (outside · 2)

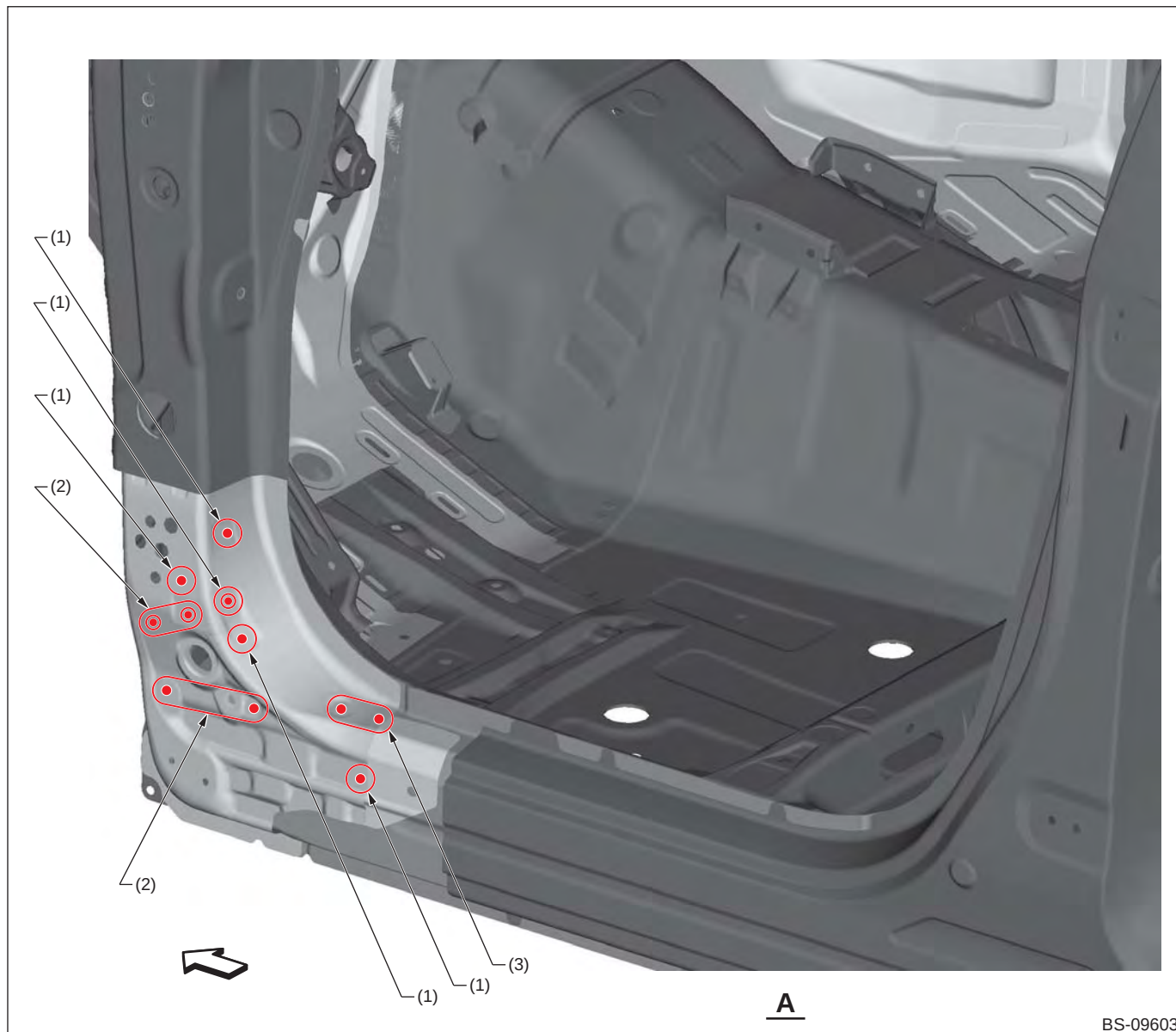
(2) 2 points (outside · 1)

(4) 4 points (outside · 1)

(6) Cut position

Panel Replacement

• Views A



(1) 1 point (outside · 1)

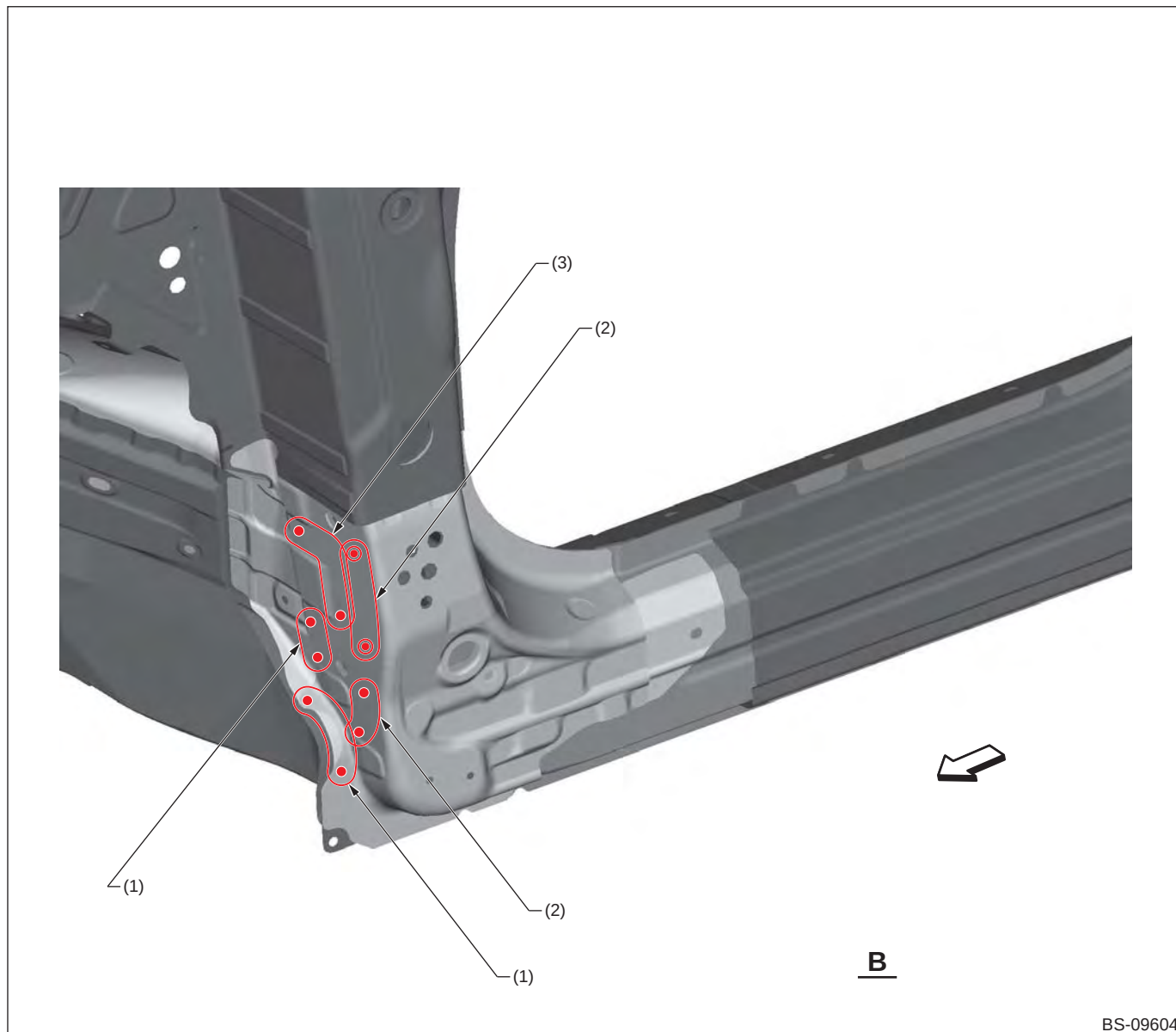
(2) 2 points (outside · 1)

(3) 2 points (top · 1)

BS-09603

Panel Replacement

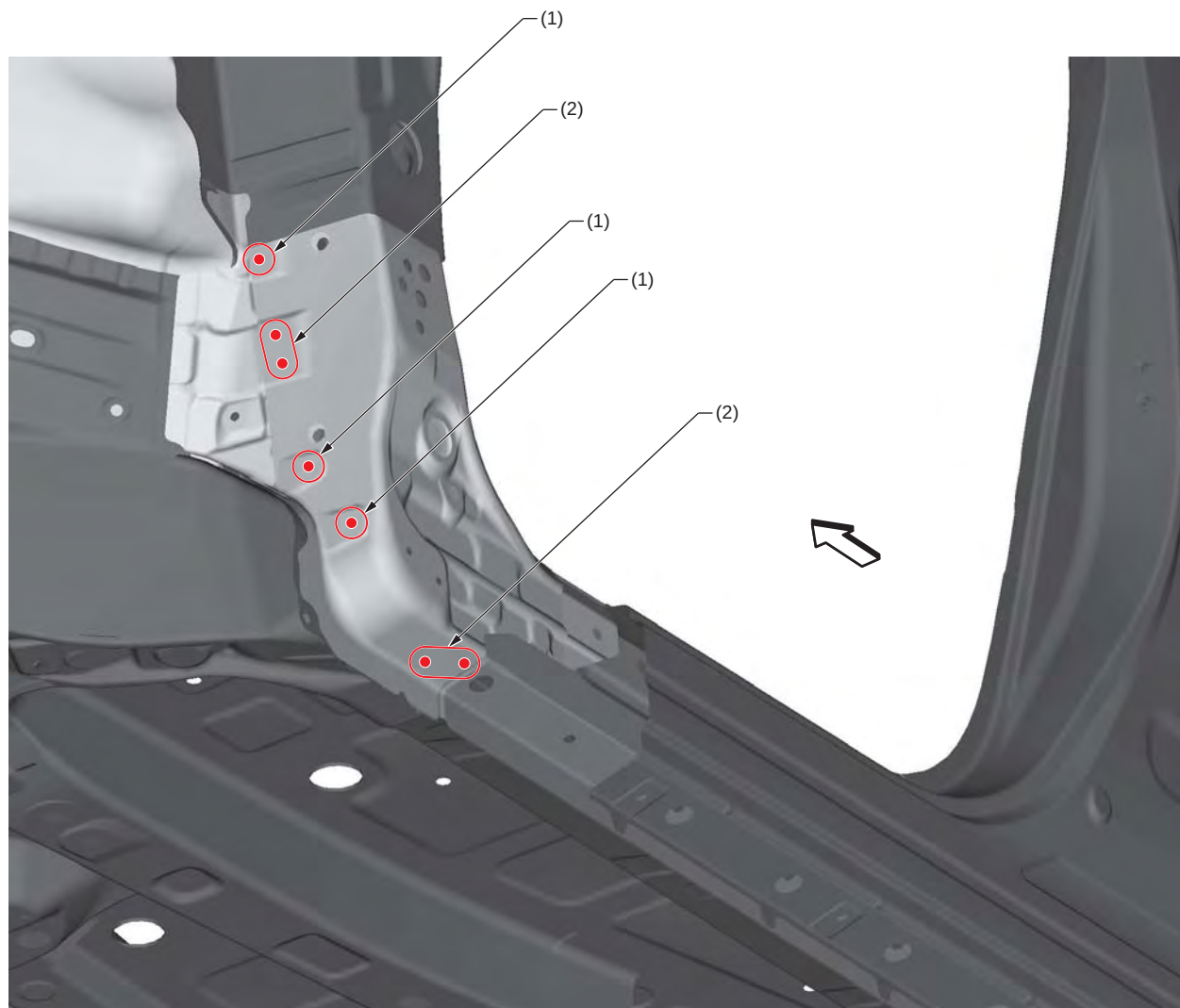
• Views B



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Panel Replacement

• Views C



BS-09605

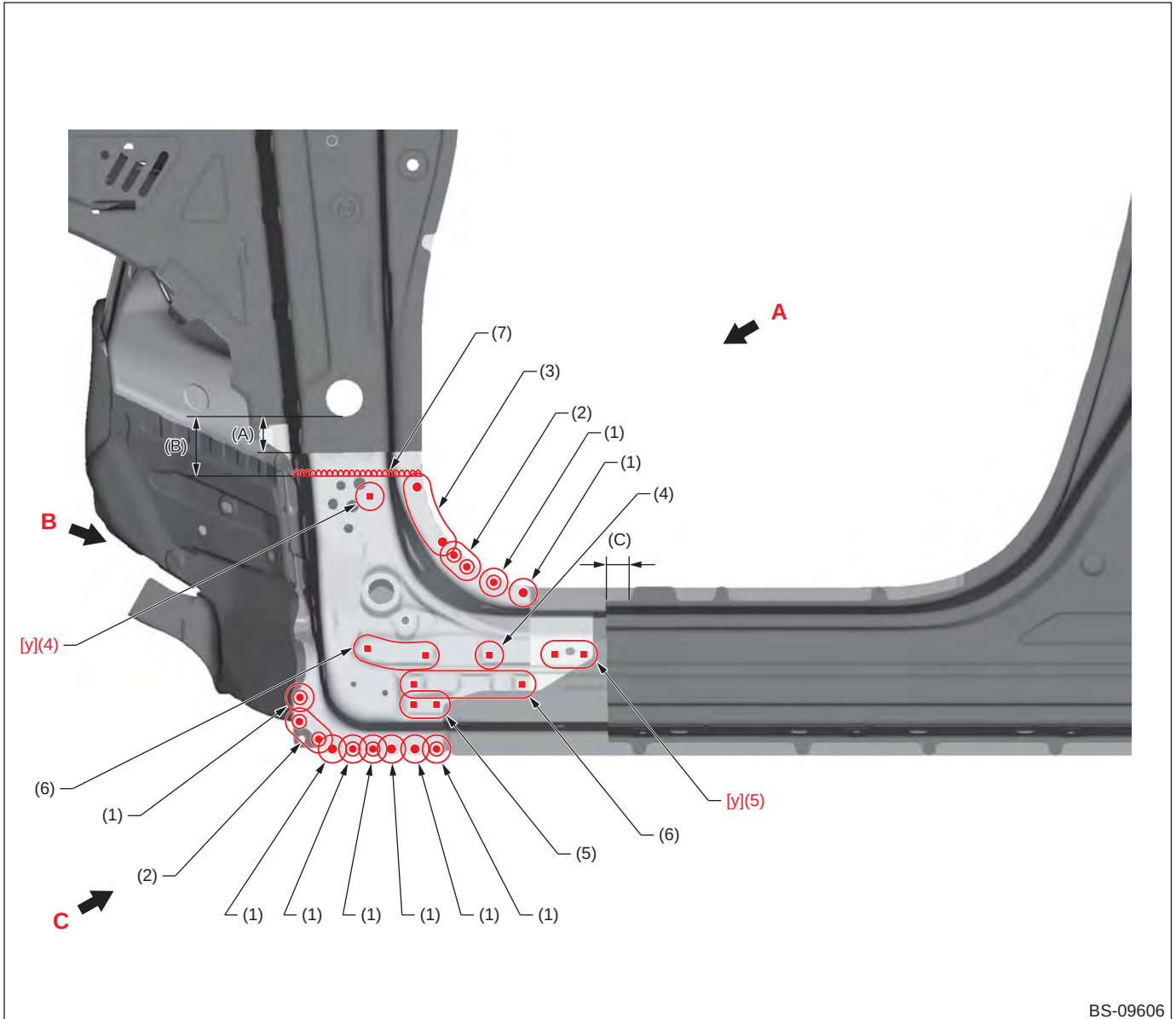
(1) 1 point (outside · 1)

(2) 2 points (outside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BS-09606

(A) 40 mm [1.57 in]

(B) 60 mm [2.36 in]

(C) 27 mm [1.06 in]

(1) 1 point

(4) 1 point (service)

(7) 1 point (Continuous welding)

(2) 2 points

(5) 2 points (service)

(3) 4 points

(6) 3 points (service)

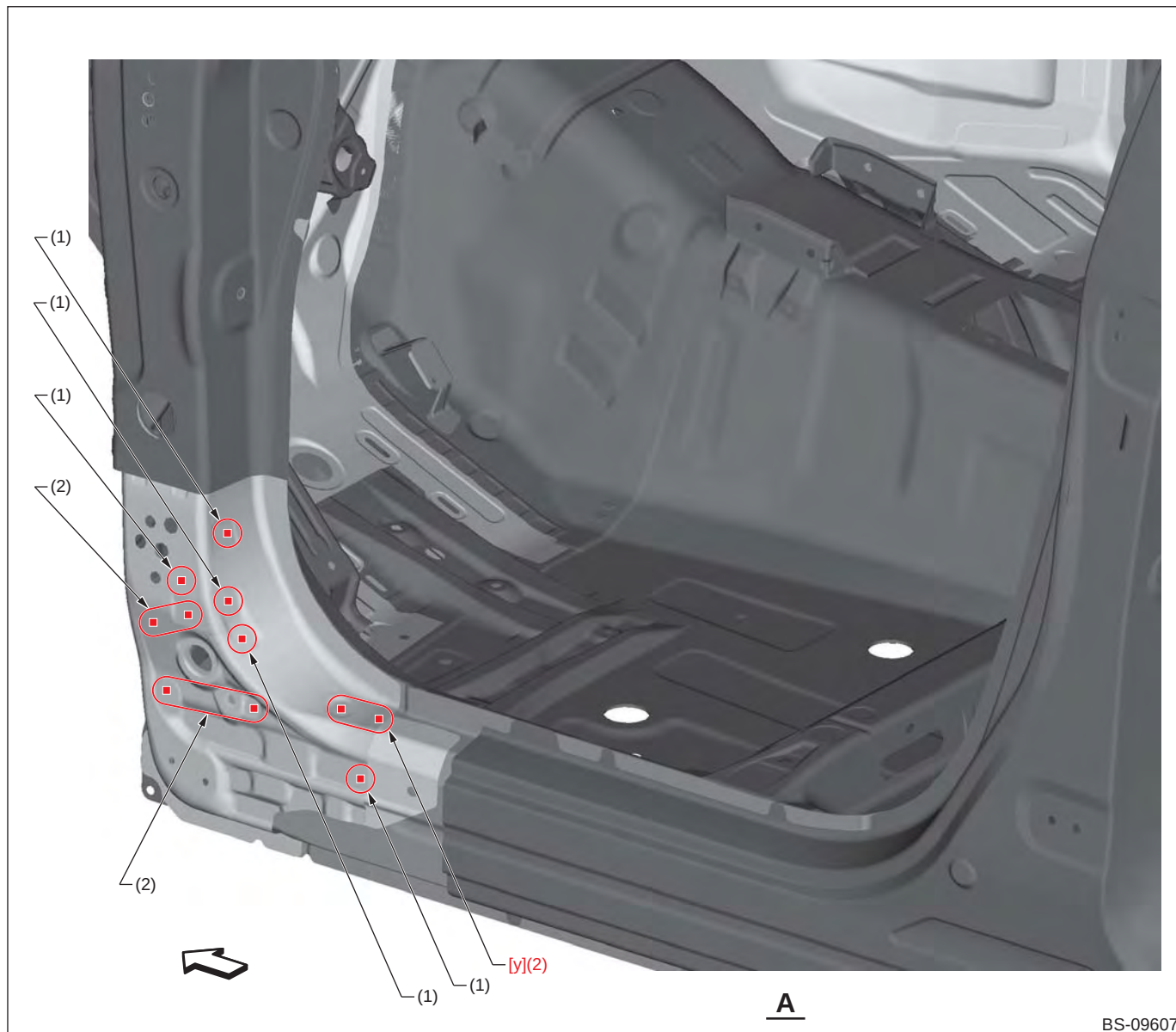
[y] Plug welding

A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2

B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

• Views A



BS-09607

(1) 1 point (service)

(2) 2 points (service)

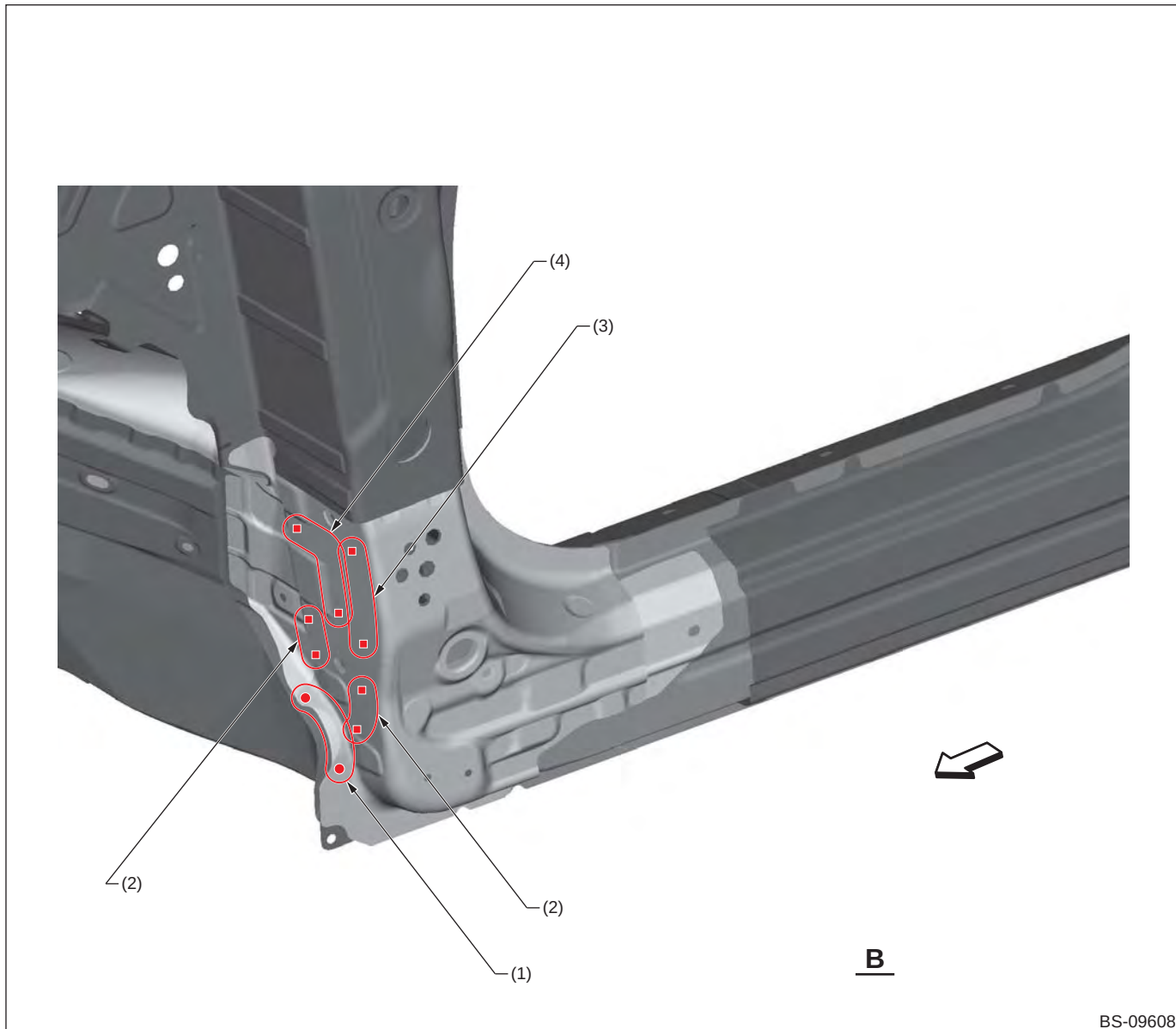
[y] Plug welding

A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2

B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

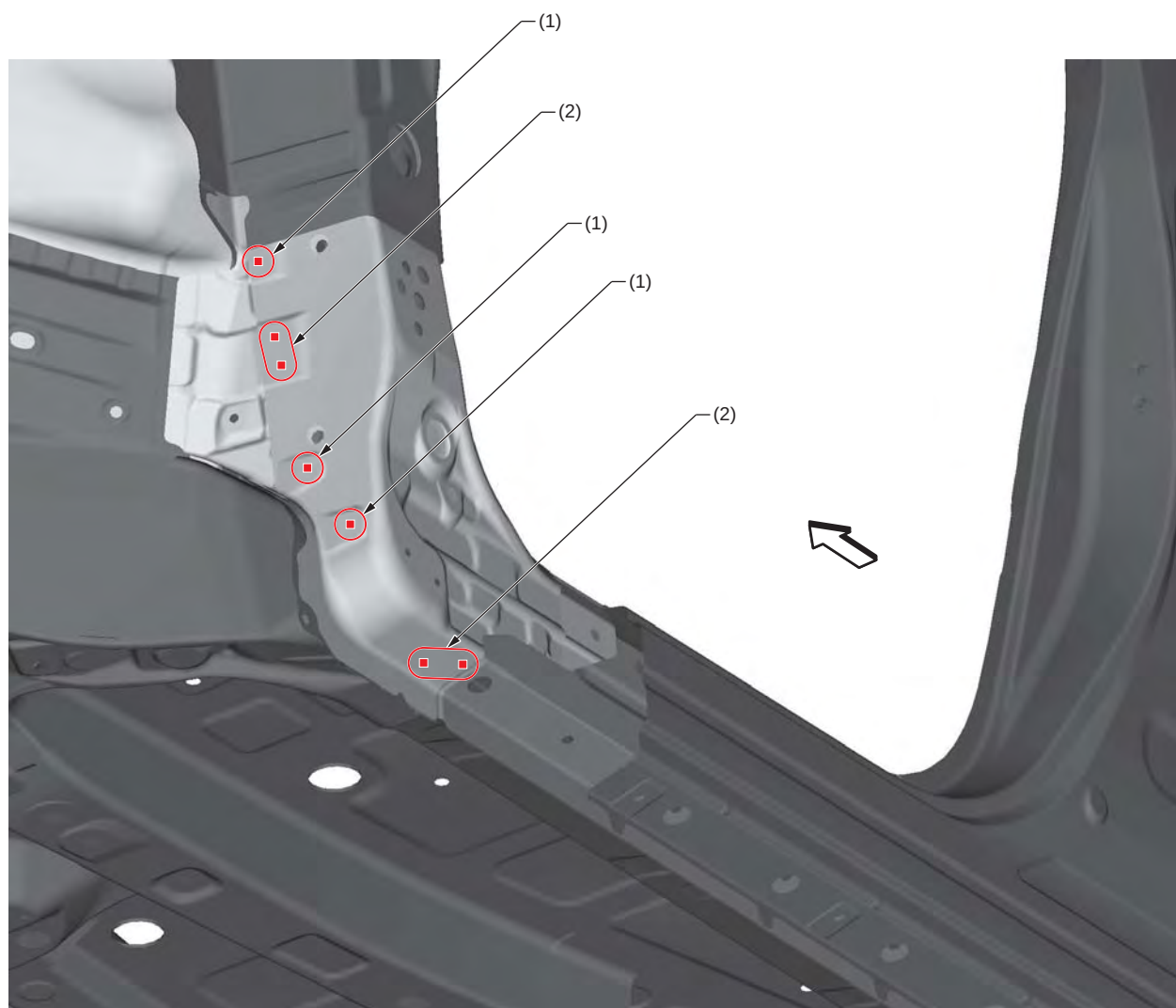
Panel Replacement

• Views B



Panel Replacement

• Views C



BS-09609

(1) 1 point (service)

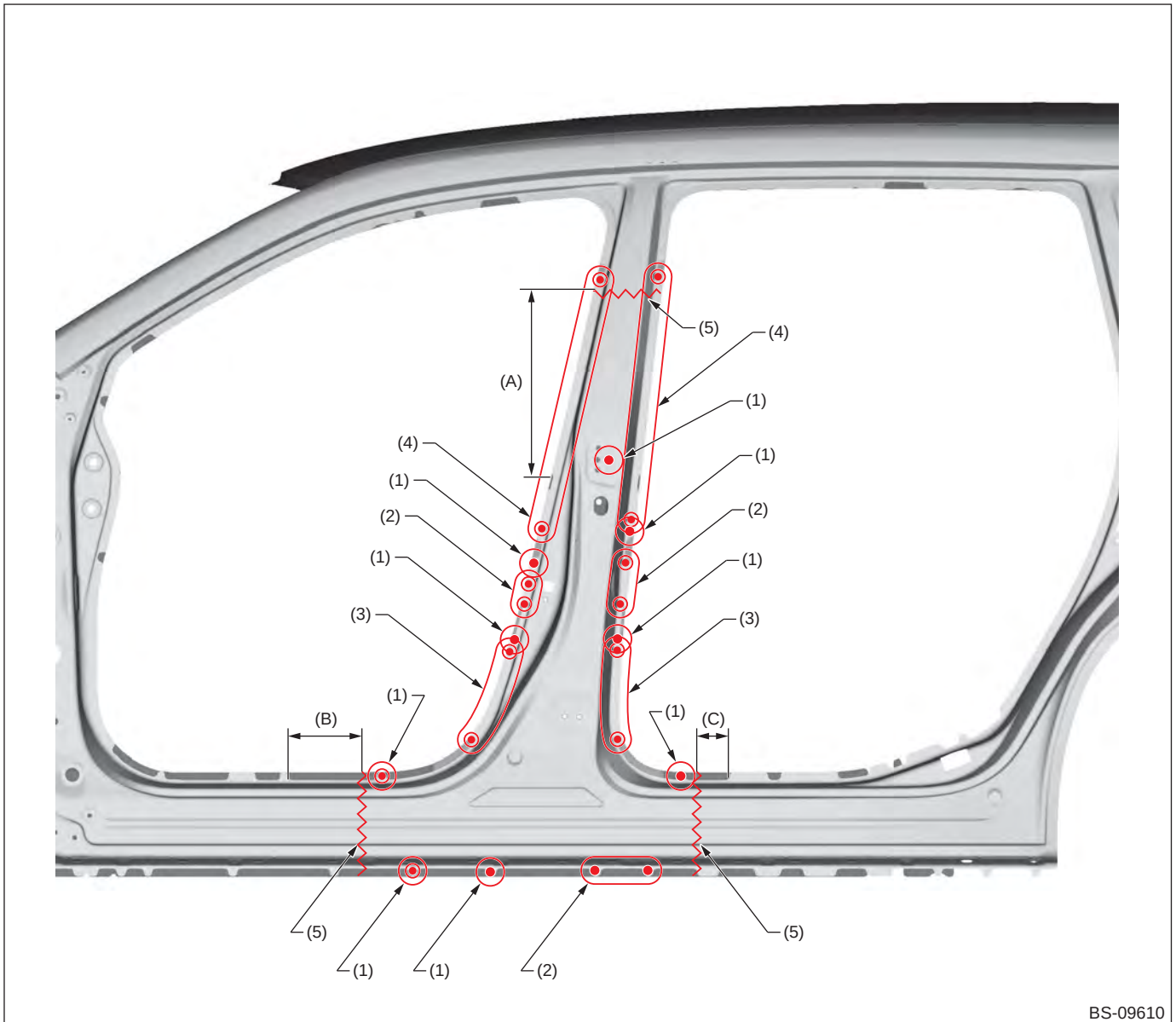
(2) 2 points (service)

Panel Replacement

8-13. Center Pillar Outer Panel (Partial replacement)

A: REMOVAL

• Overall view



BS-09610

(A) 386 mm [15.20 in]

(B) 127 mm [5.00 in]

(C) 63 mm [2.48 in]

(1) 1 point (outside · 1)

(3) 8 points (outside · 1)

(5) Cut position

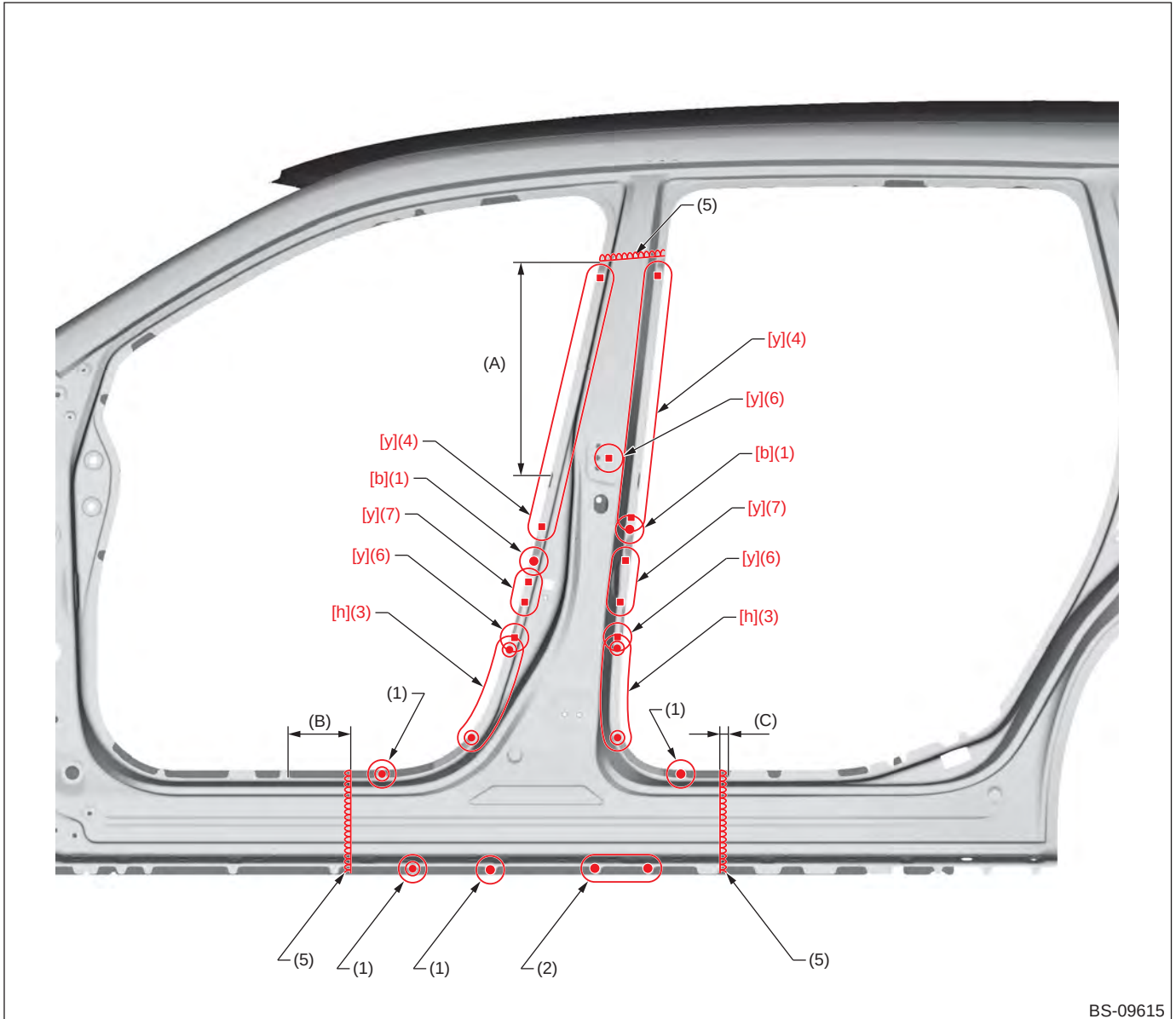
(2) 2 points (outside · 1)

(4) 13 points (outside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BS-09615

(A) 430 mm [16.93 in]

(B) 125 mm [4.92 in]

(C) 21 mm [0.83 in]

(1) 1 point

(4) 13 points (service)

(7) 2 points (service)

(2) 2 points

(5) 1 point (Continuous welding)

(3) 8 points

(6) 1 point (service)

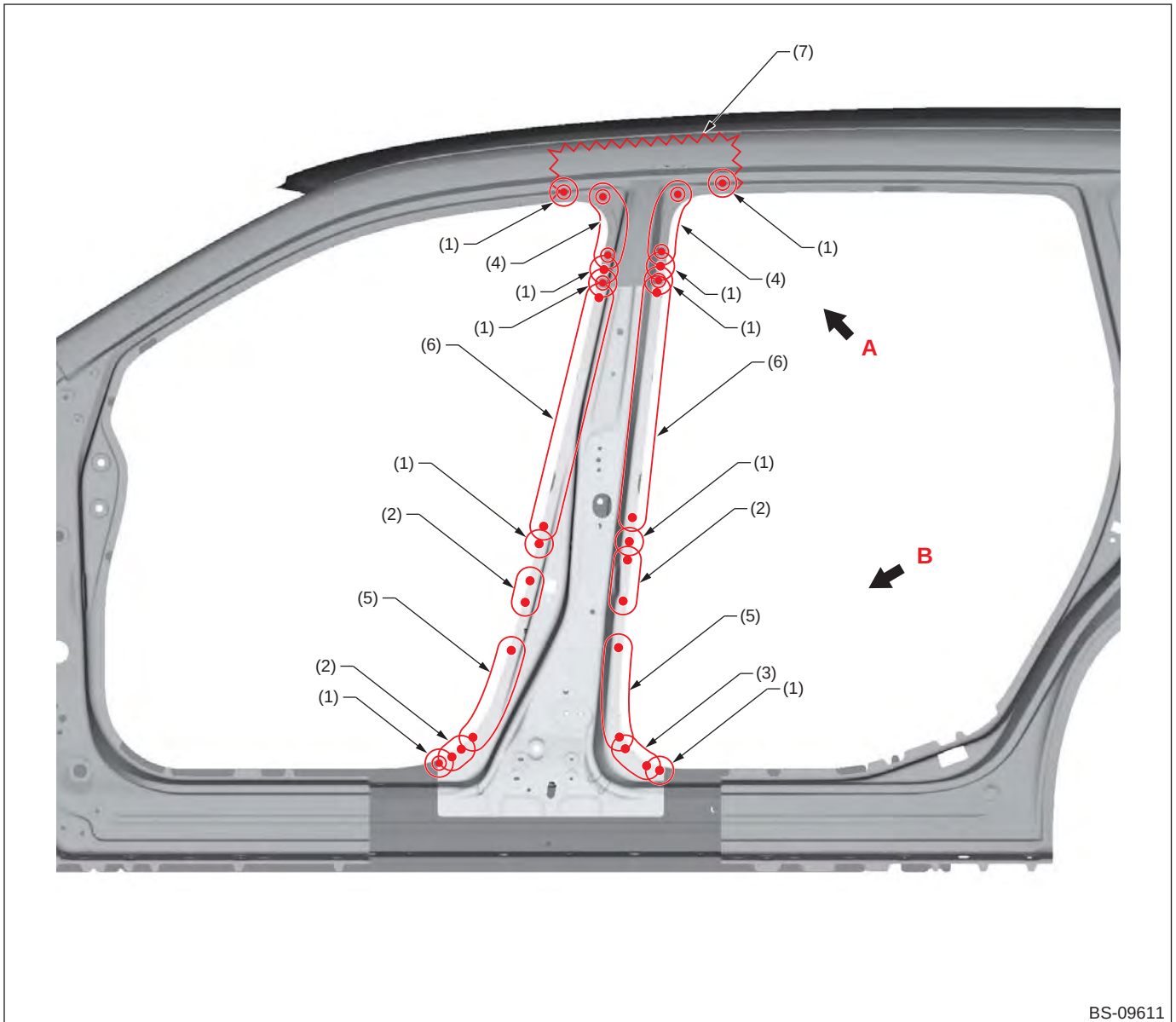
[b] Spot welding	Compression: 2.6 kN, Current: 6.0 kA, Welding time: 17 cyc
[h] Spot welding	Compression: 4.0 kN, Current: 8.5 kA, Welding time: 20 cyc
[y] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2 B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

8-14. Center Pillar Reinforcement Outer (Total replacement)

A: REMOVAL

• Overall view

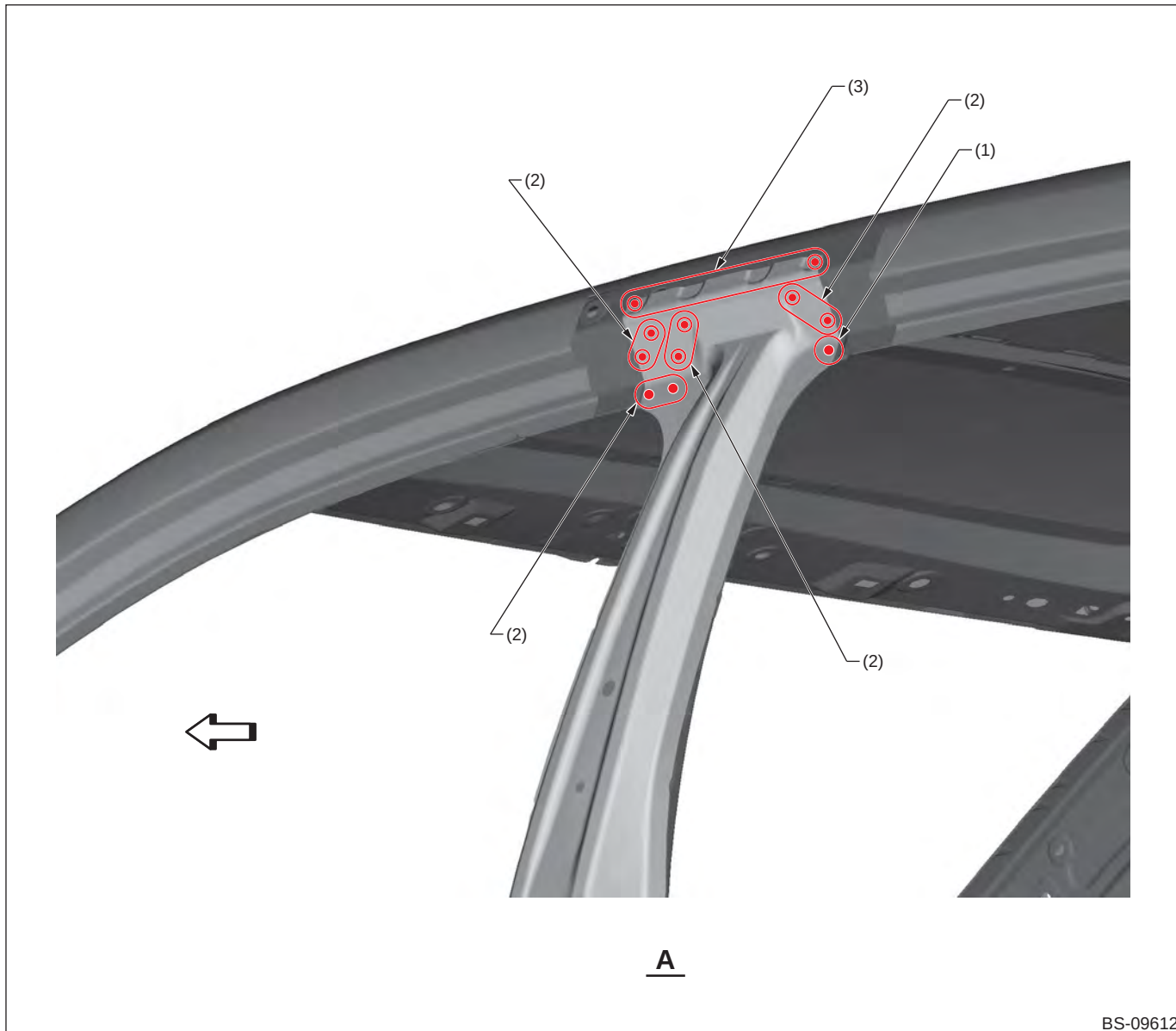


- | | | |
|----------------------------|-----------------------------|-------------------|
| (1) 1 point (outside · 1) | (4) 7 points (outside · 2) | (7) Rough cutting |
| (2) 2 points (outside · 1) | (5) 8 points (outside · 1) | |
| (3) 3 points (outside · 1) | (6) 12 points (outside · 1) | |

Note: The cut part can be reused depending on level of damage.

Panel Replacement

• Views A

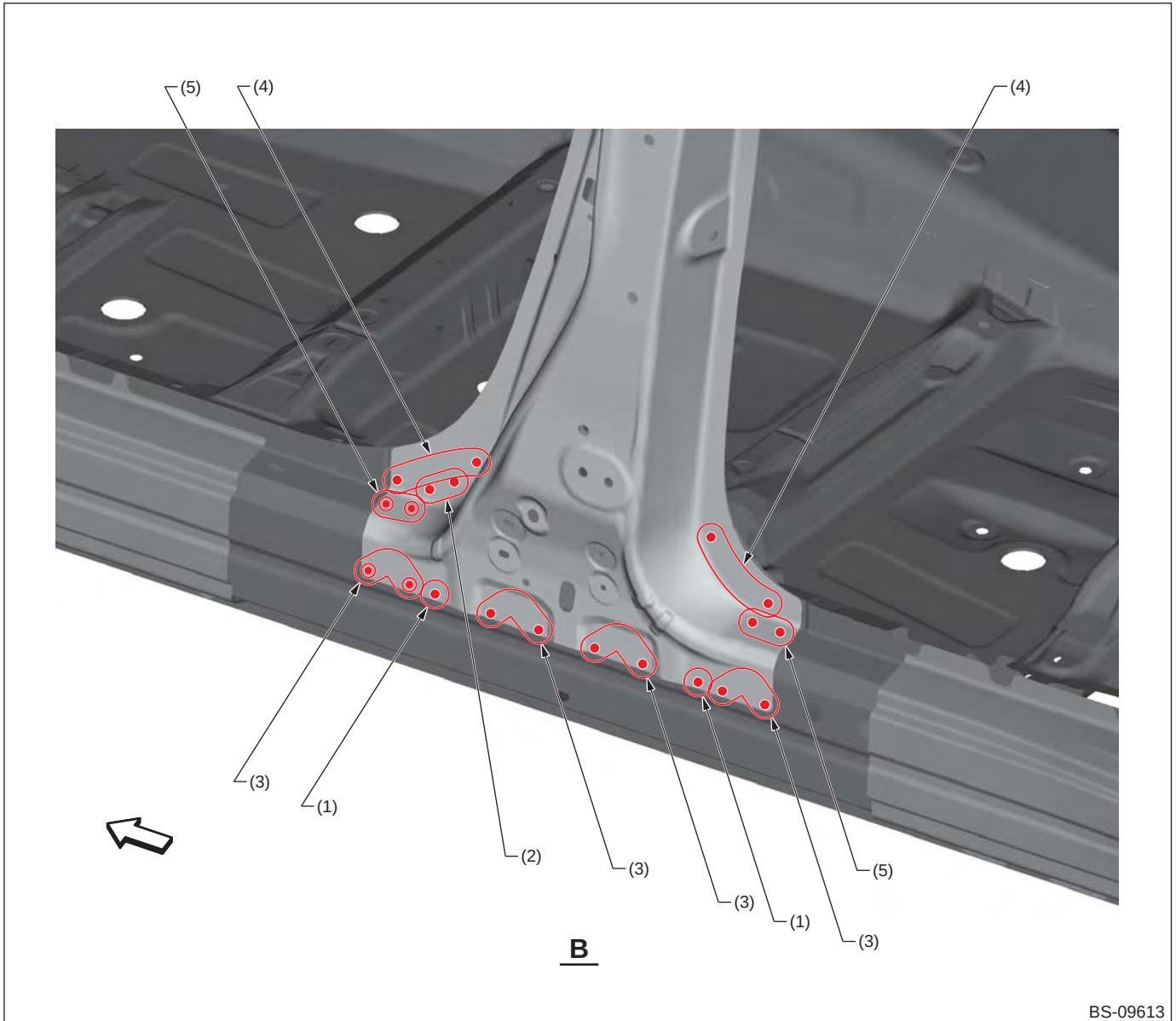


BS-09612

- (1) 1 point (outside - 1 belt sander) (2) 2 points (outside - 1 belt sander) (3) 4 points (outside - 1 belt sander)

Panel Replacement

• Views B

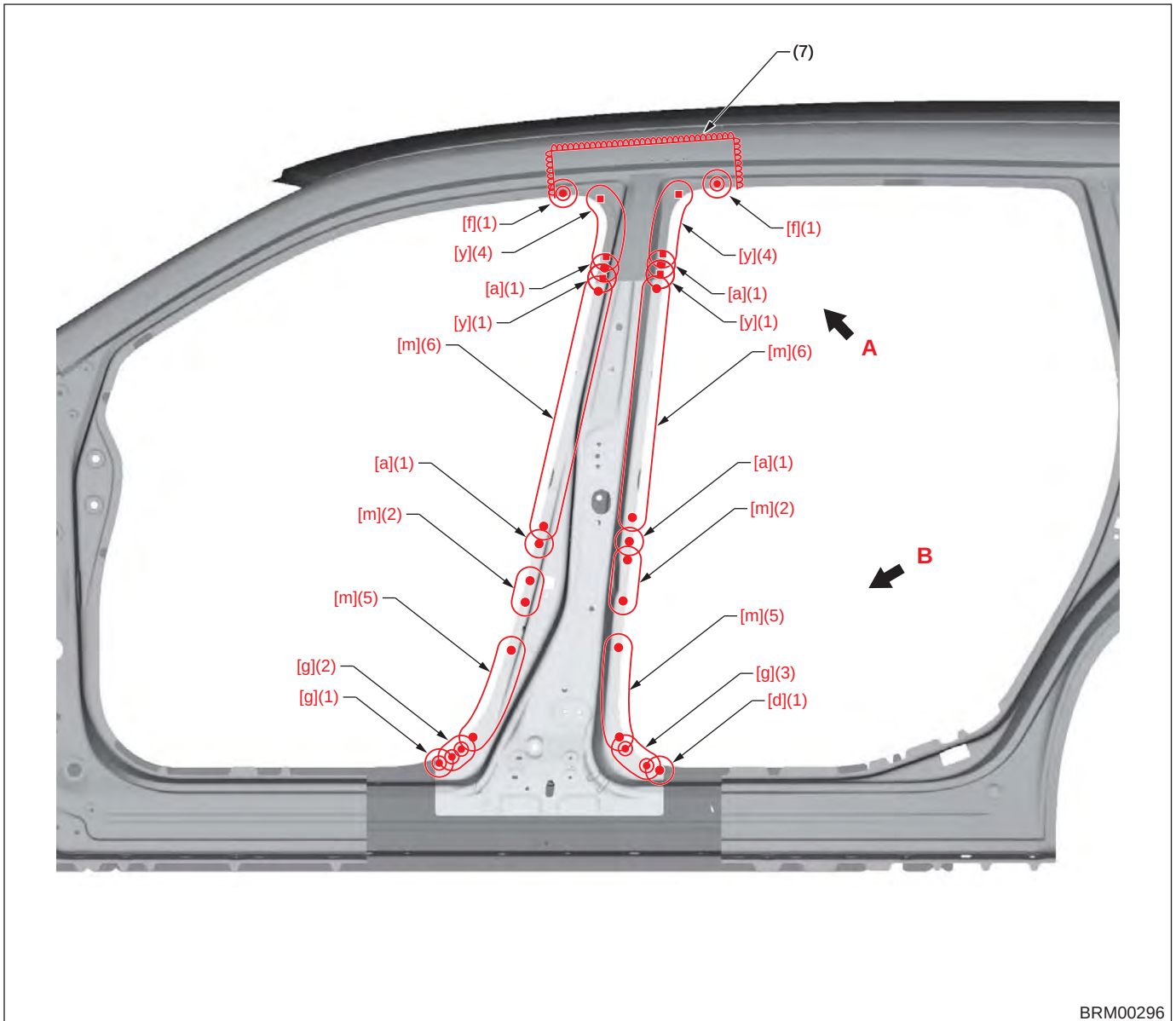


- | | | |
|--|--|------------------------------------|
| (1) 1 point (outside · 1 belt sander) | (3) 3 points (outside · 1 belt sander) | (5) 2 points (top · 1 belt sander) |
| (2) 2 points (outside · 1 belt sander) | (4) 5 points (outside · 1 belt sander) | |

Panel Replacement

B: INSTALLATION

• Overall view



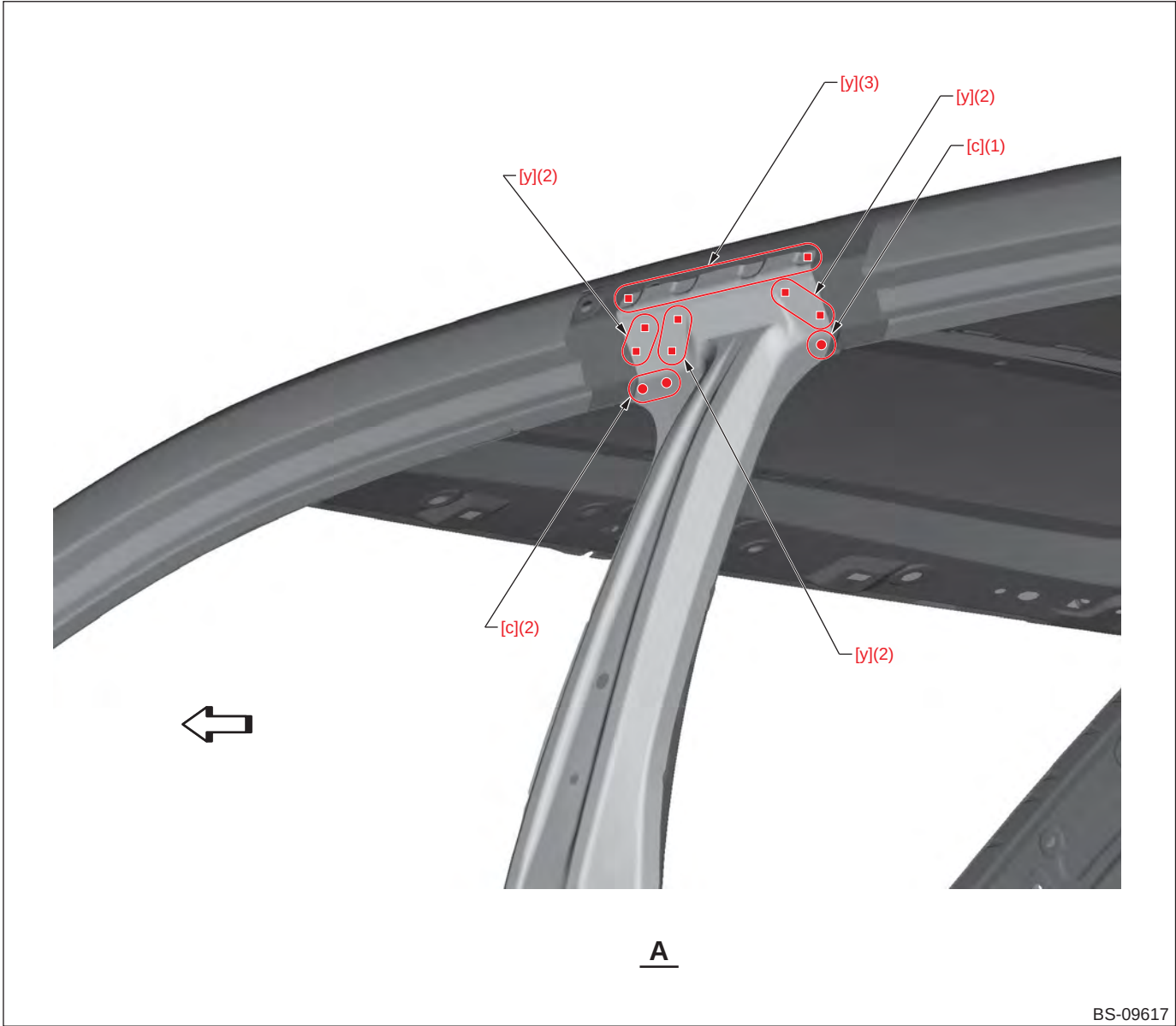
BRM00296

- | | | |
|--------------|---------------|----------------------------------|
| (1) 1 point | (4) 7 points | (7) 1 point (Continuous welding) |
| (2) 2 points | (5) 8 points | |
| (3) 3 points | (6) 12 points | |

[a] Spot welding	Compression: 5.0 kN, Current: 7.5 kA, Welding time: 18 cyc
[d] Spot welding	Compression: 4.0 kN, Current: 8.0 kA, Welding time: 14 cyc
[f] Spot welding	Compression: 3.5 kN, Current: 8.0 kA, Welding time: 25 cyc
[g] Spot welding	Compression: 4.0 kN, Current: 6.5 kA, Welding time: 25 cyc
[m] Spot welding	Compression: 3.5 kN, Current: 7.5 kA, Welding time: 25 cyc
[y] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2 B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

• Views A



BS-09617

(1) 1 point

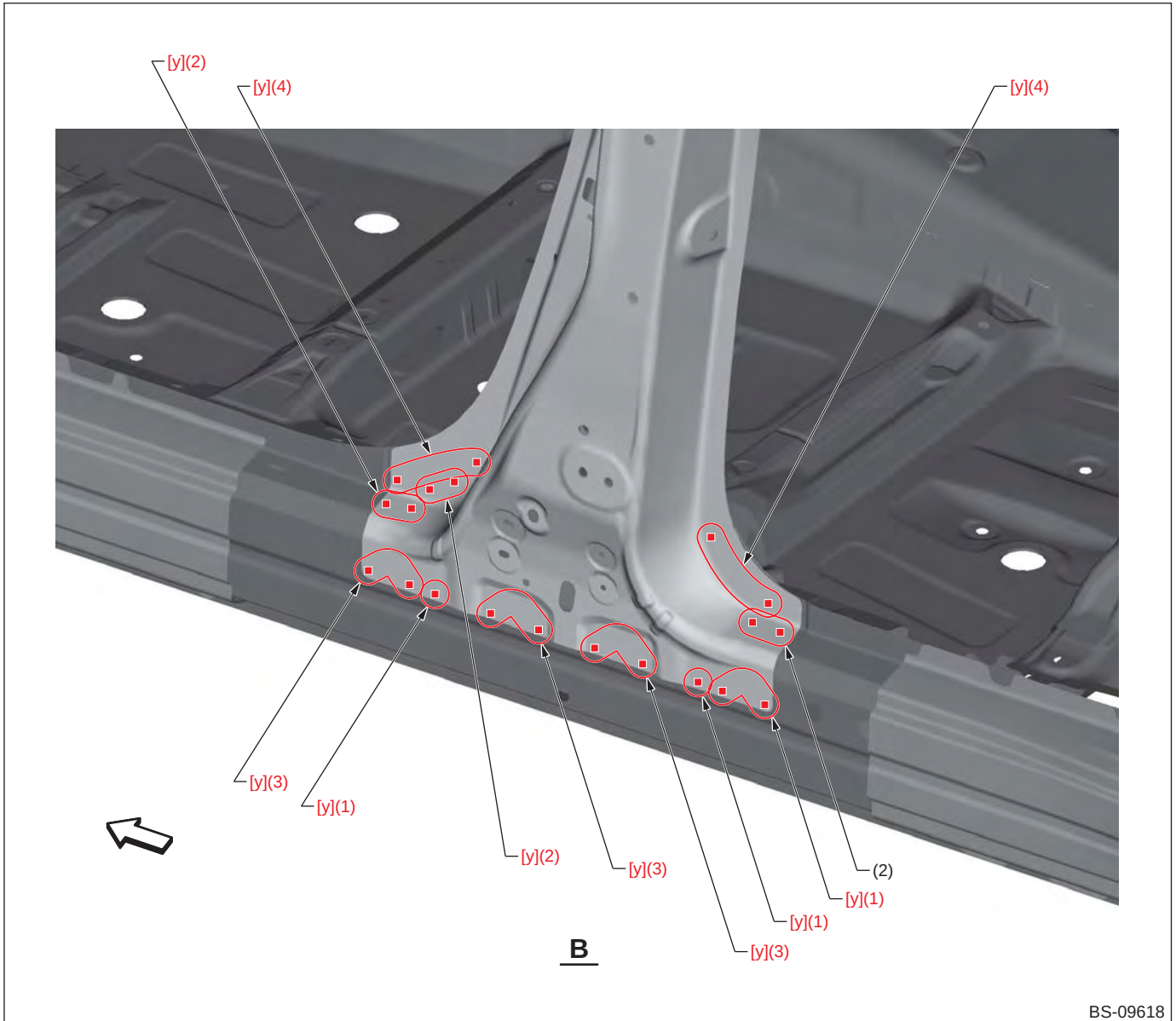
(2) 2 points

(3) 4 points

[c] Spot welding	Compression: 4.4 kN, Current: 7.5 kA, Welding time: 16 cyc
[y] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2 B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

• Views B



(1) 1 point
(2) 2 points

(3) 3 points

(4) 5 points

[y] Plug welding

A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2

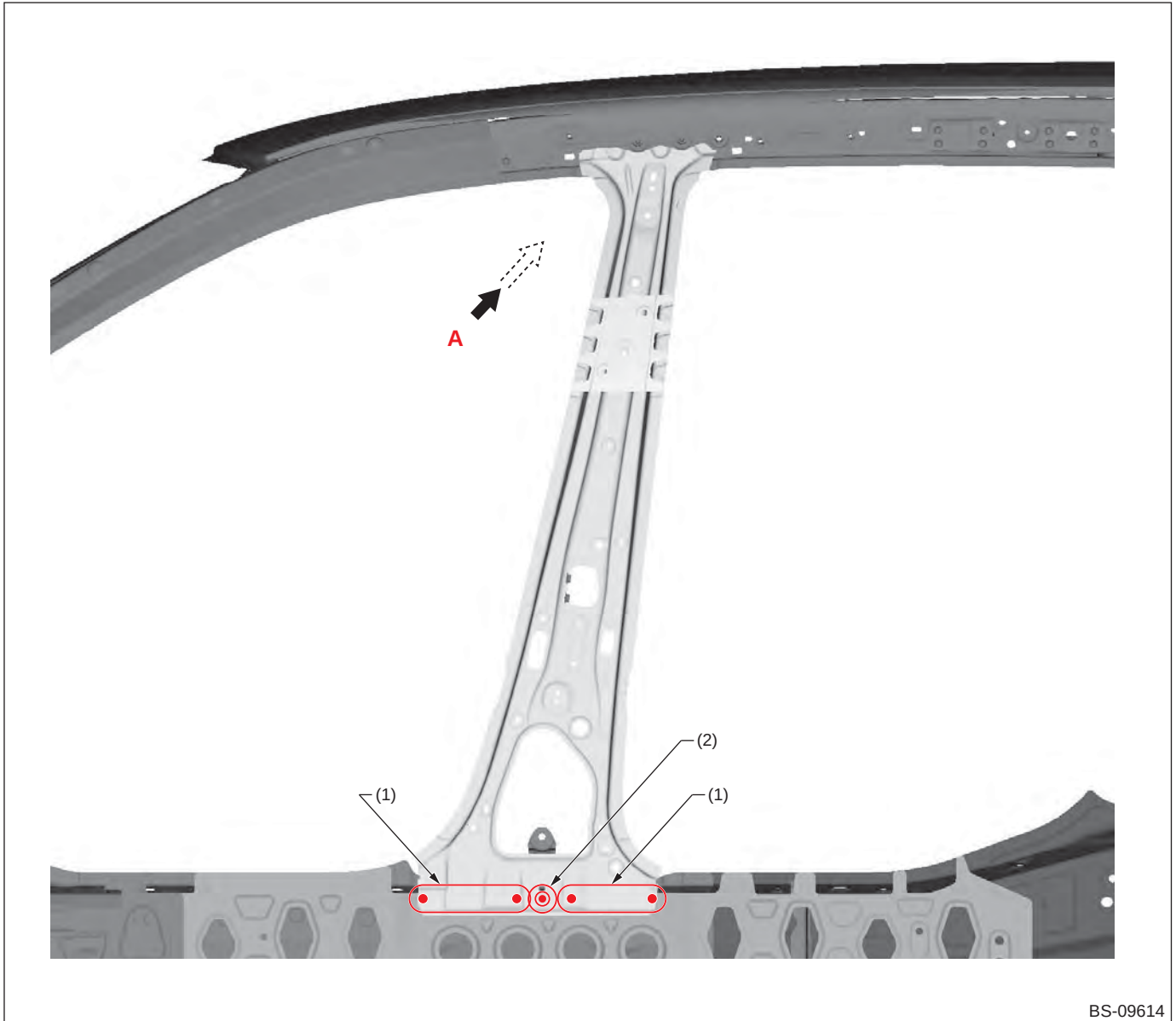
B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

8-15. Center Pillar Inner (Total replacement)

A: REMOVAL

• Overall view (Center pillar, center pillar reinforcement side sill and side sill reinforcement outer has been removed.)

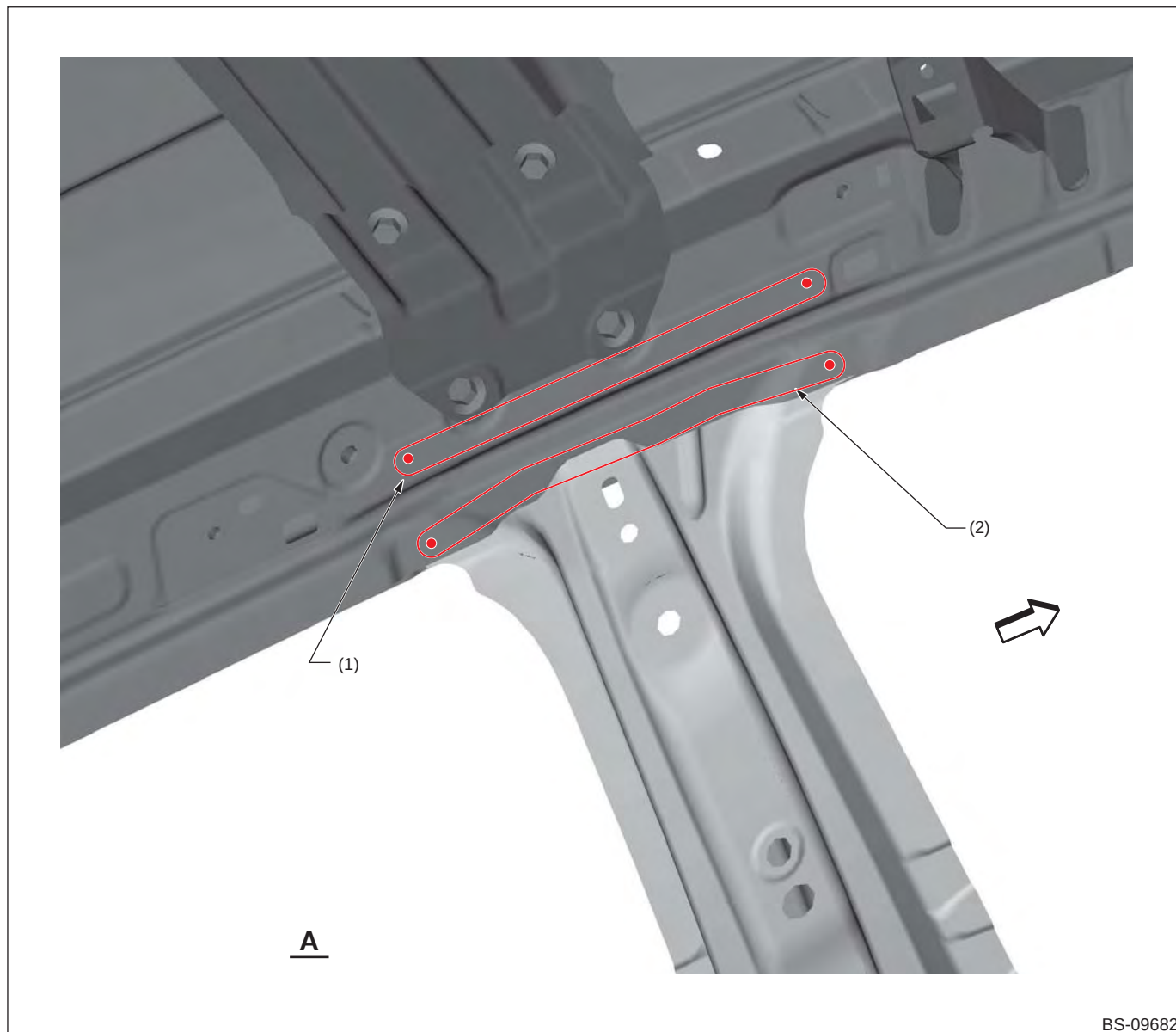


(1) 4 points (outside · 1)

(2) 1 point (outside · 2)

Panel Replacement

• Views A



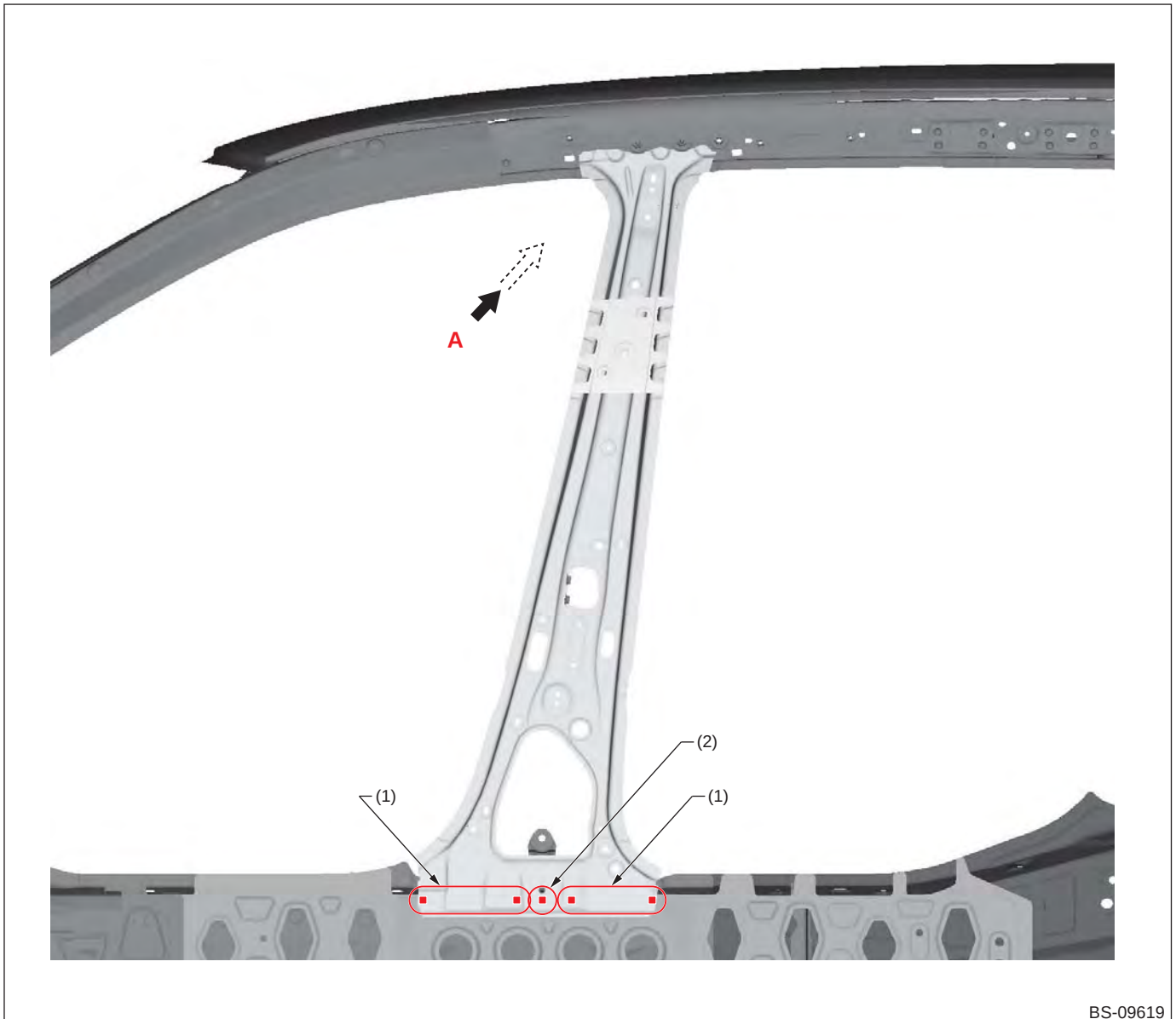
(1) 4 points (inside · 1)

(2) 5 points (inside · 1)

Panel Replacement

B: INSTALLATION

• Overall view

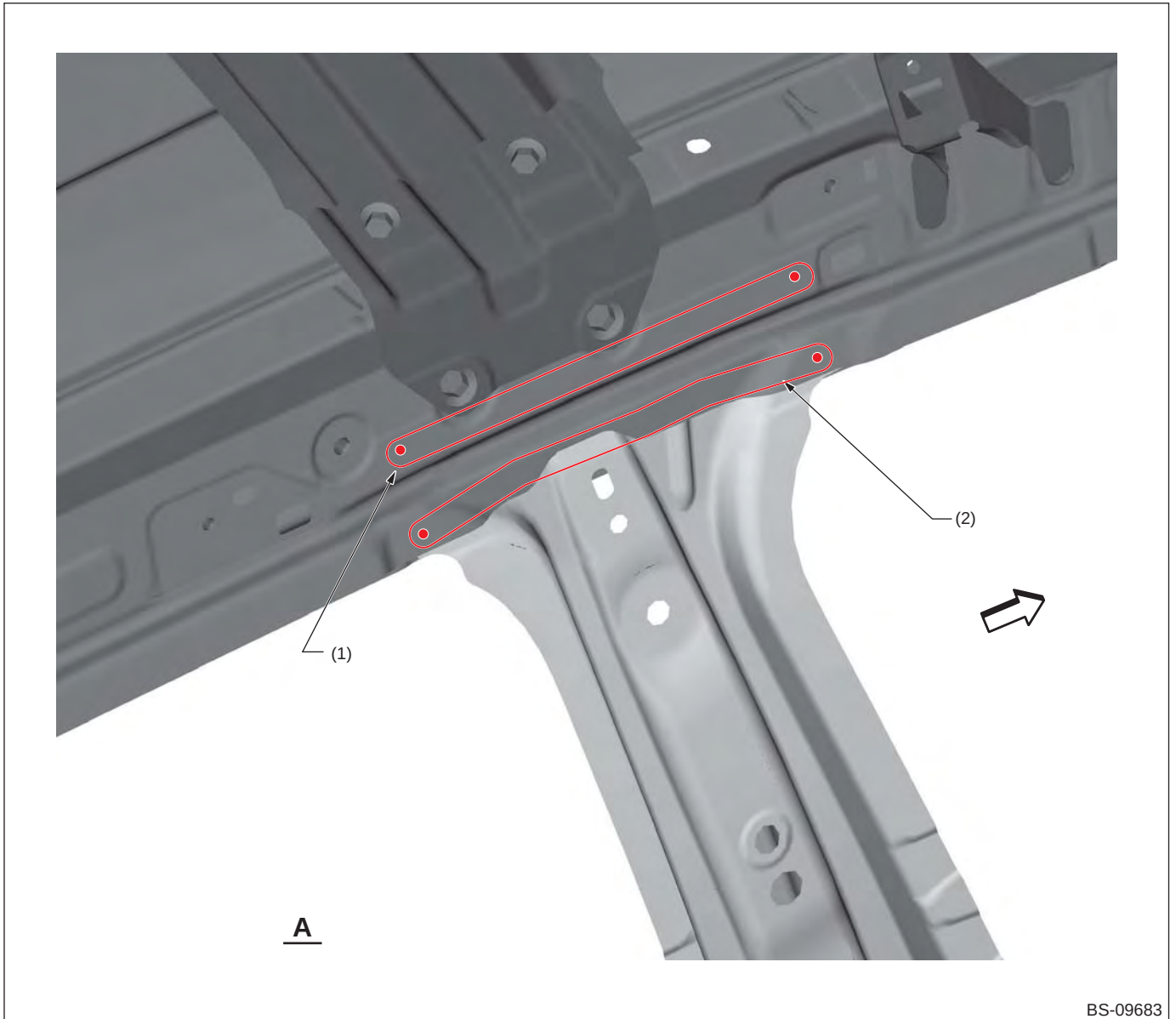


(1) 4 points

(2) 1 point

Panel Replacement

• Views A



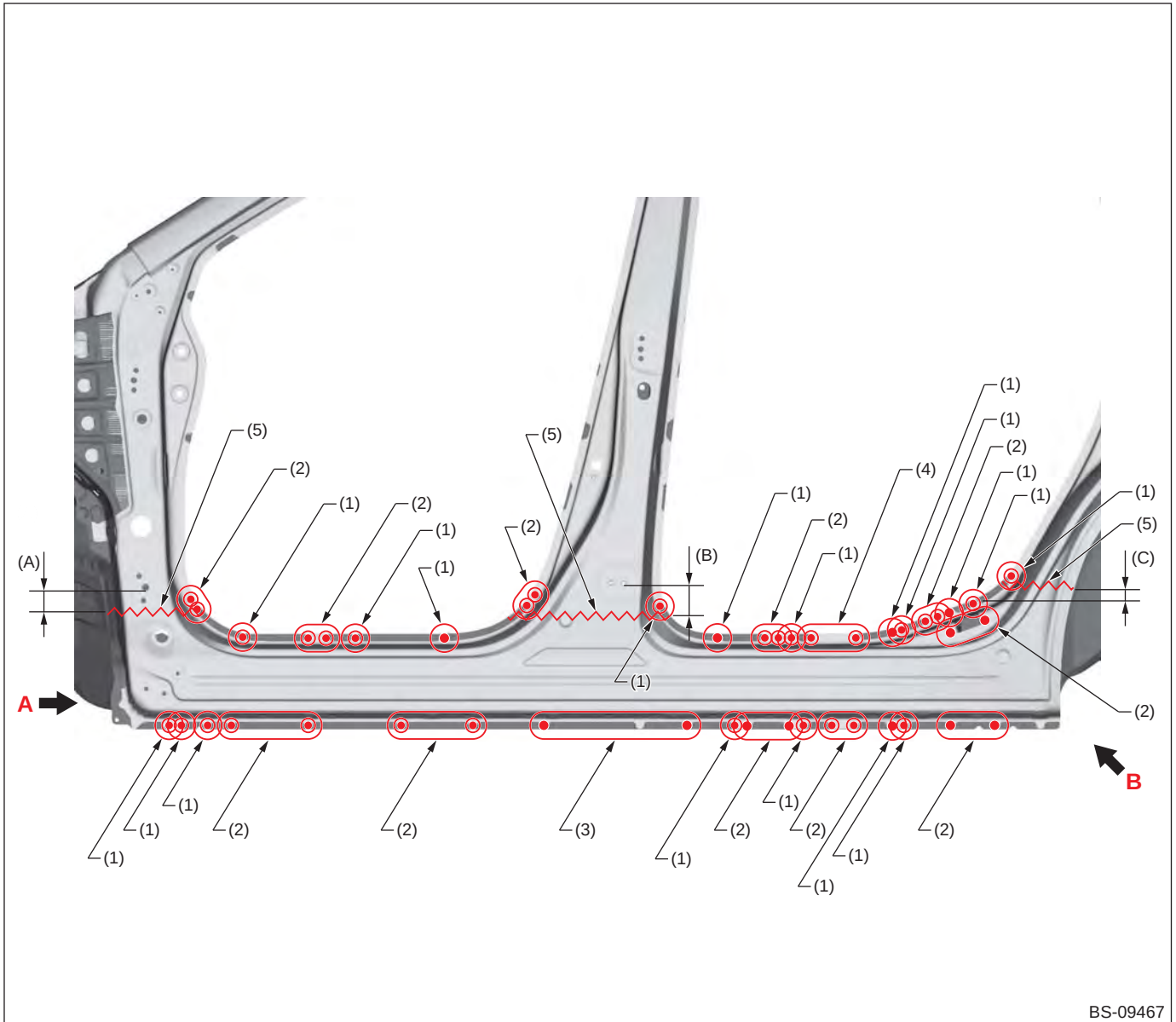
(1) 4 points

(2) 5 points

8-16. Side Sill Outer Panel (Partial replacement)

A: REMOVAL

• Overall view



BS-09467

(A) 40 mm [1.57 in]

(B) 70 mm [2.76 in]

(C) 10 mm [0.39 in]

(1) 1 point (outside · 1)

(3) 3 points (outside · 1)

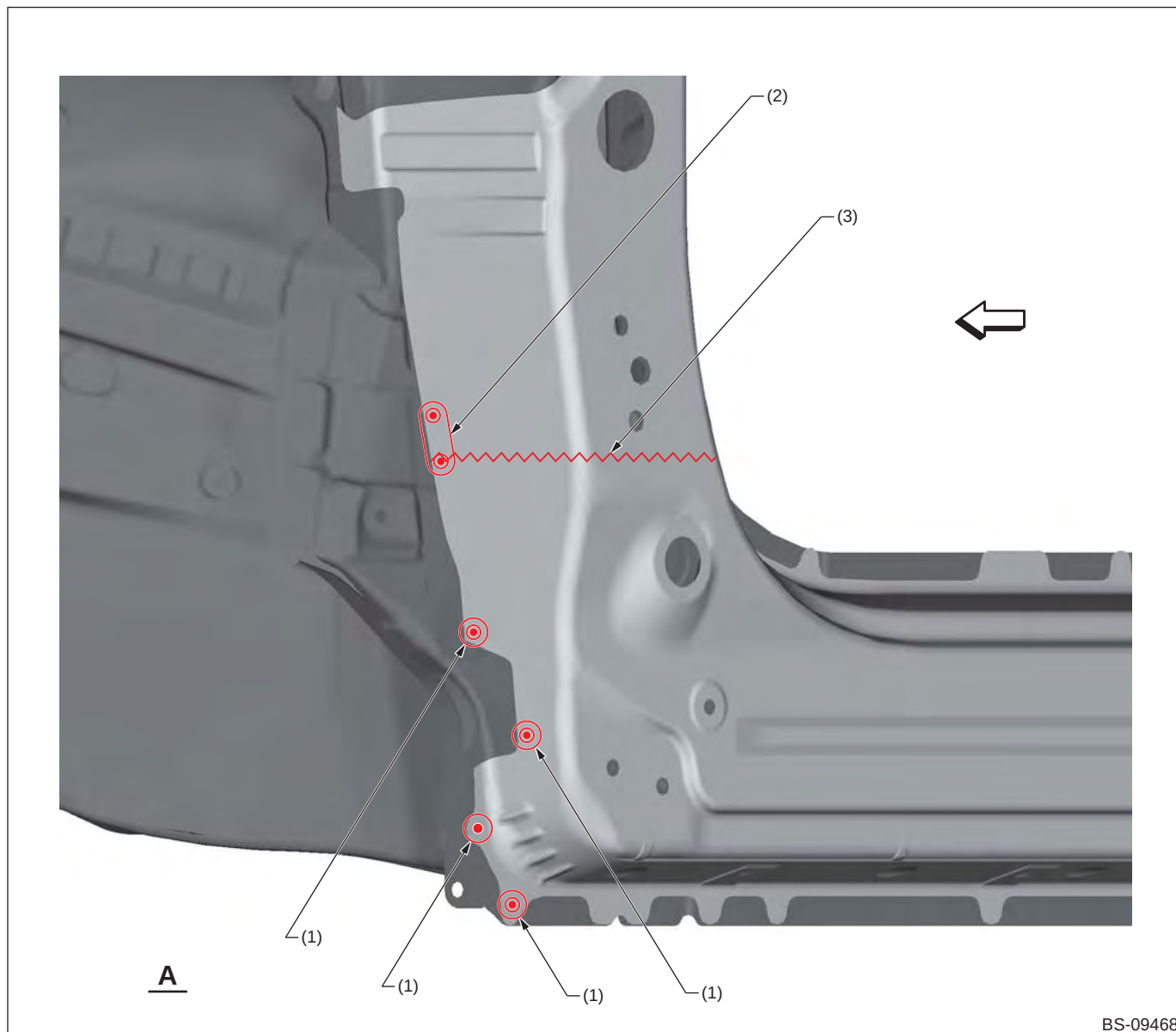
(5) Cut position

(2) 2 points (outside · 1)

(4) 4 points (outside · 1)

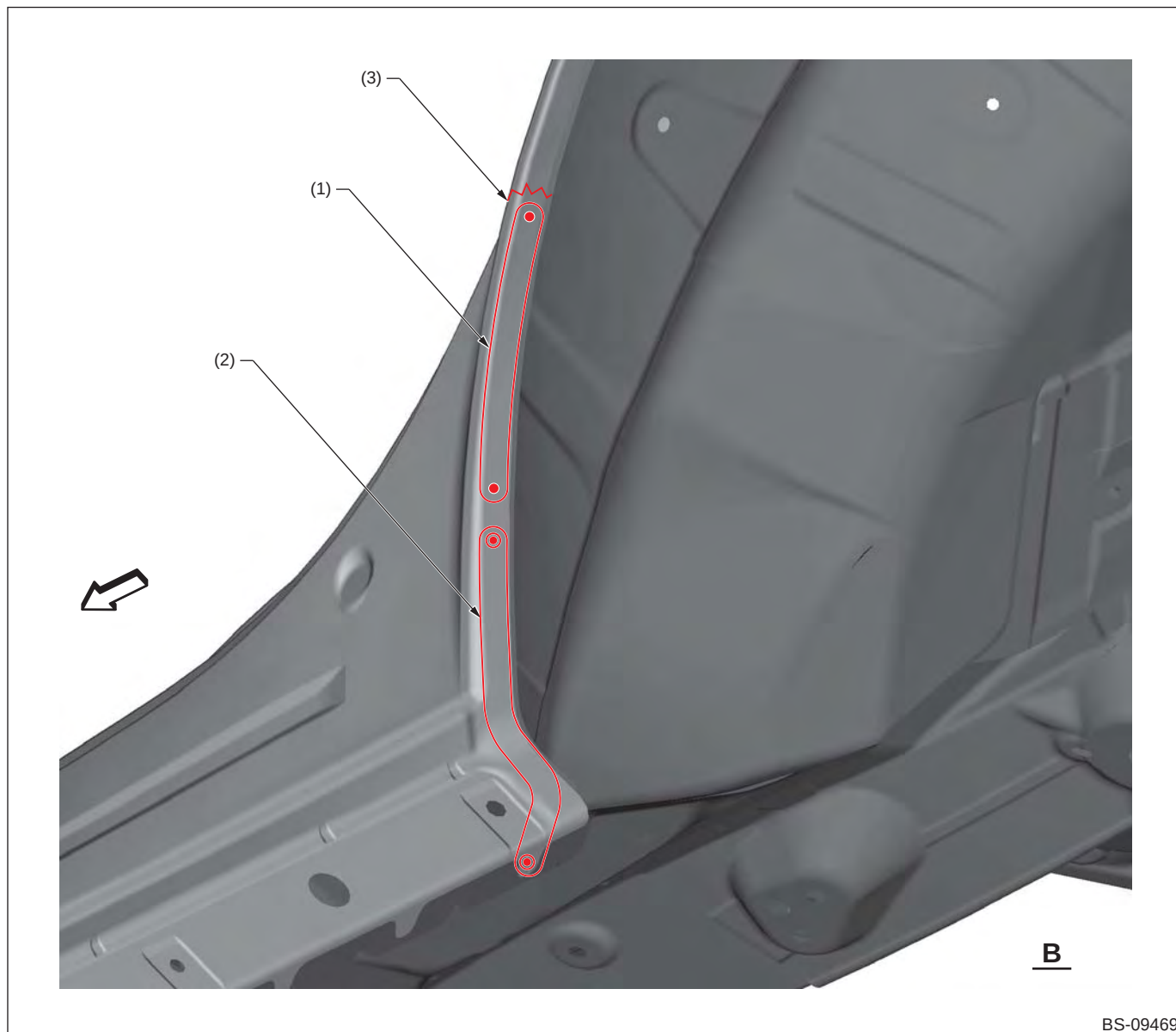
Panel Replacement

• Views A



Panel Replacement

• Views B



BS-09469

(1) 3 points (outside · 1)

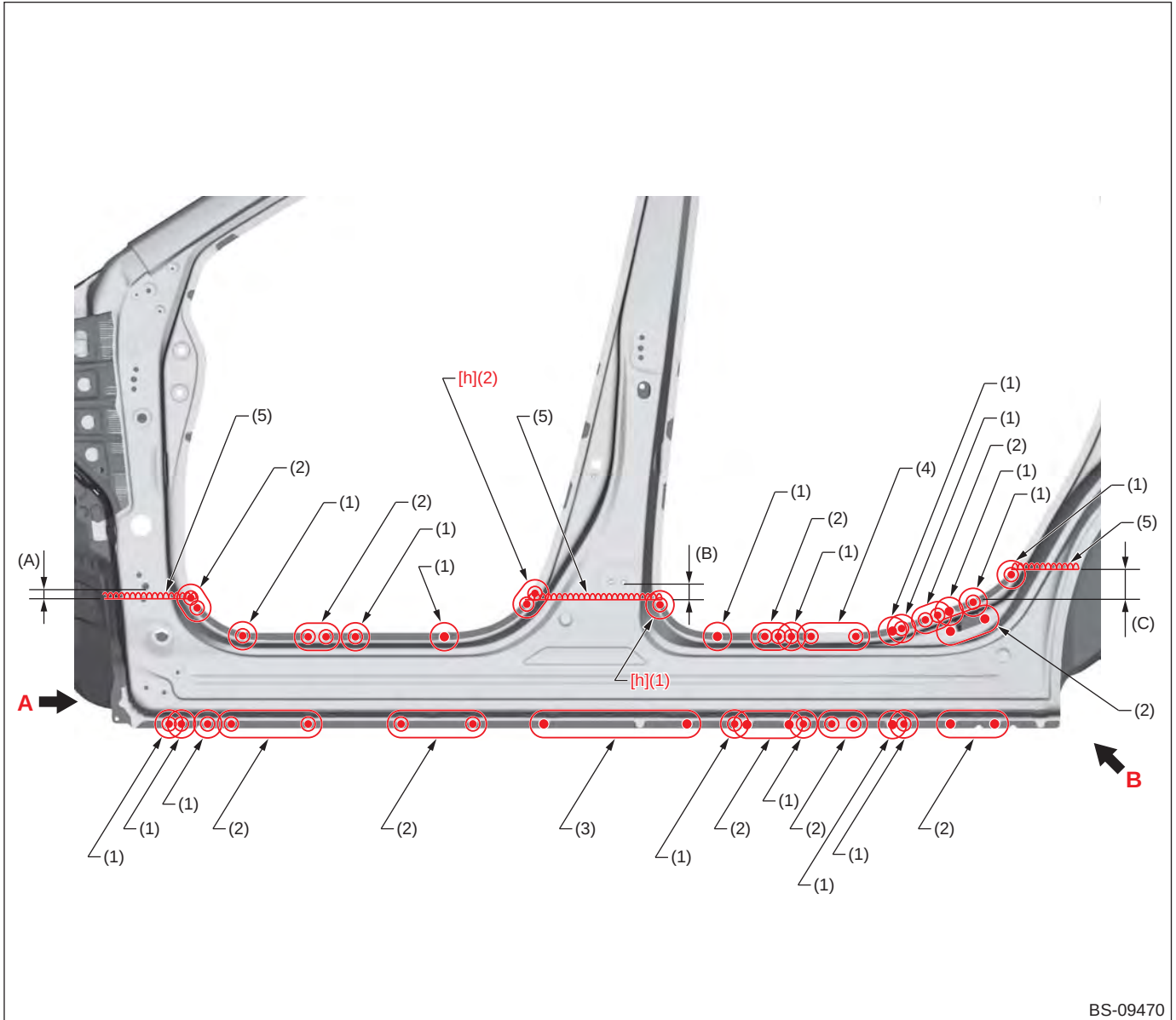
(2) 4 points (outside · 1)

(3) Cut position

Panel Replacement

B: INSTALLATION

• Overall view



(A) 15 mm [0.59 in]

(B) 50 mm [1.97 in]

(C) 90 mm [3.54 in]

(1) 1 point

(3) 3 points

(5) 1 point (Continuous welding)

(2) 2 points

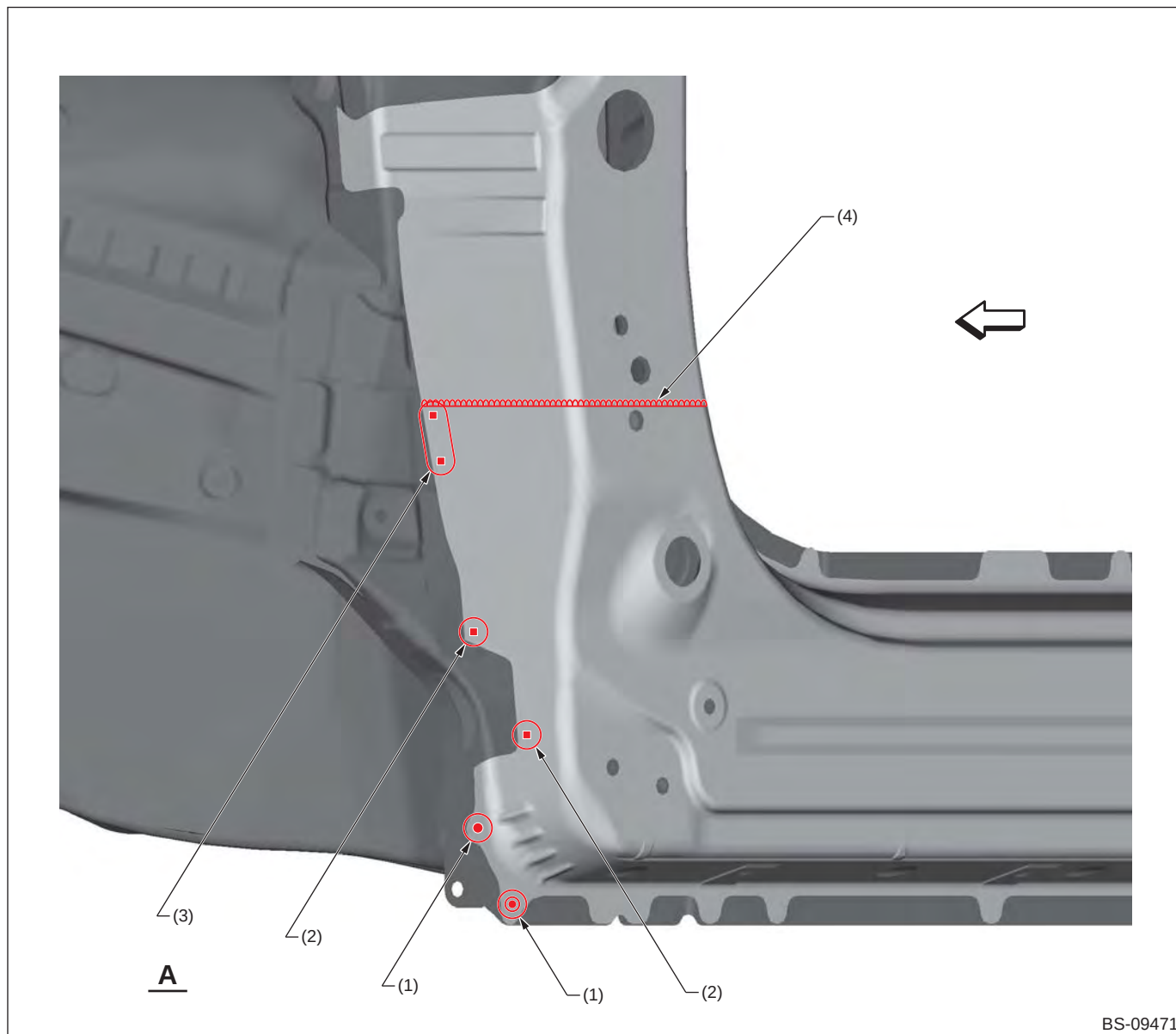
(4) 4 points

[h] Spot welding

Compression: 4.0 kN, Current: 8.5 kA, Welding time: 20 cyc

Panel Replacement

• Views A



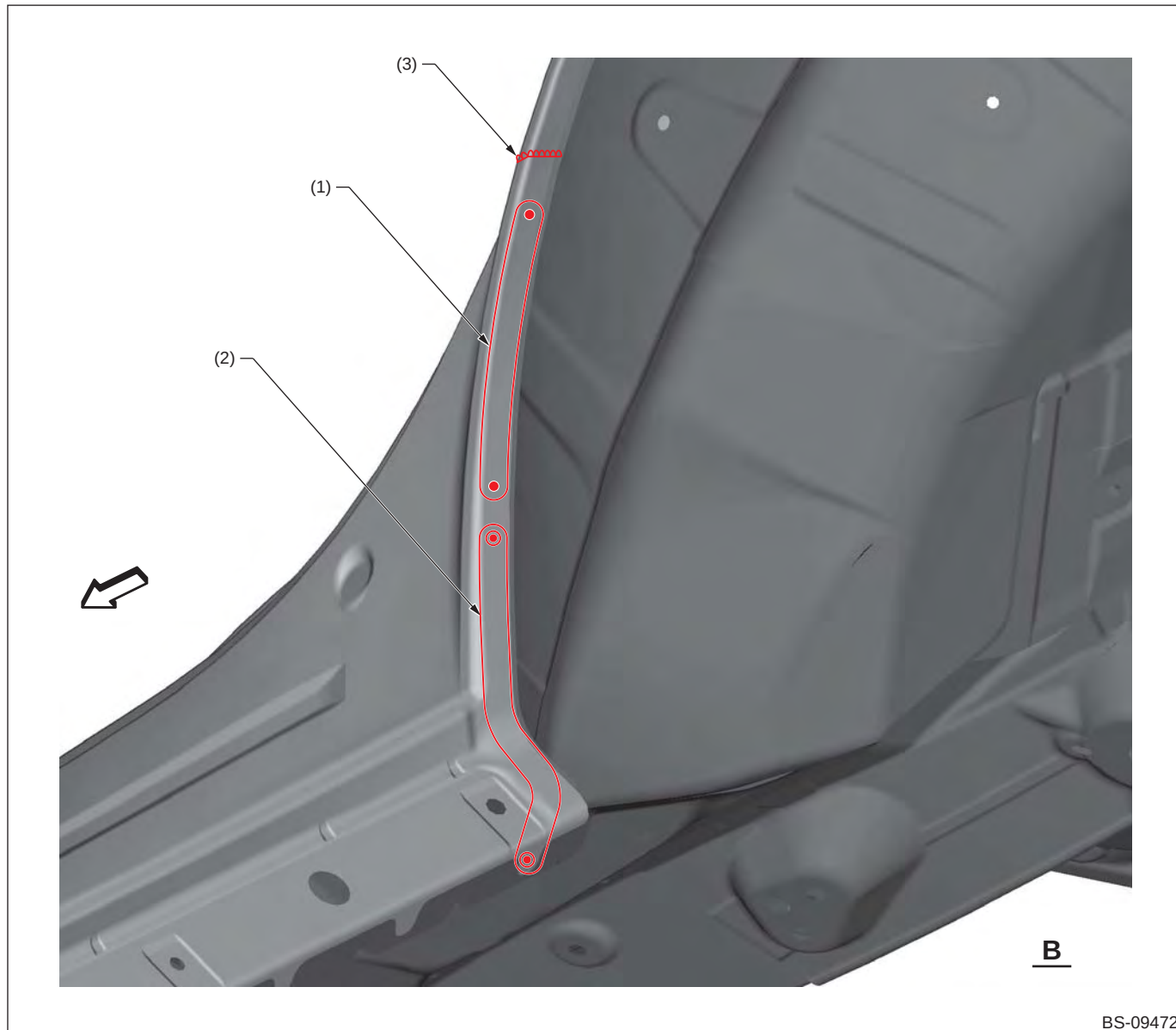
- (1) 1 point
- (2) 1 point (service)

- (3) 2 points (service)

- (4) 1 point (Continuous welding)

Panel Replacement

• Views B



BS-09472

(1) 3 points

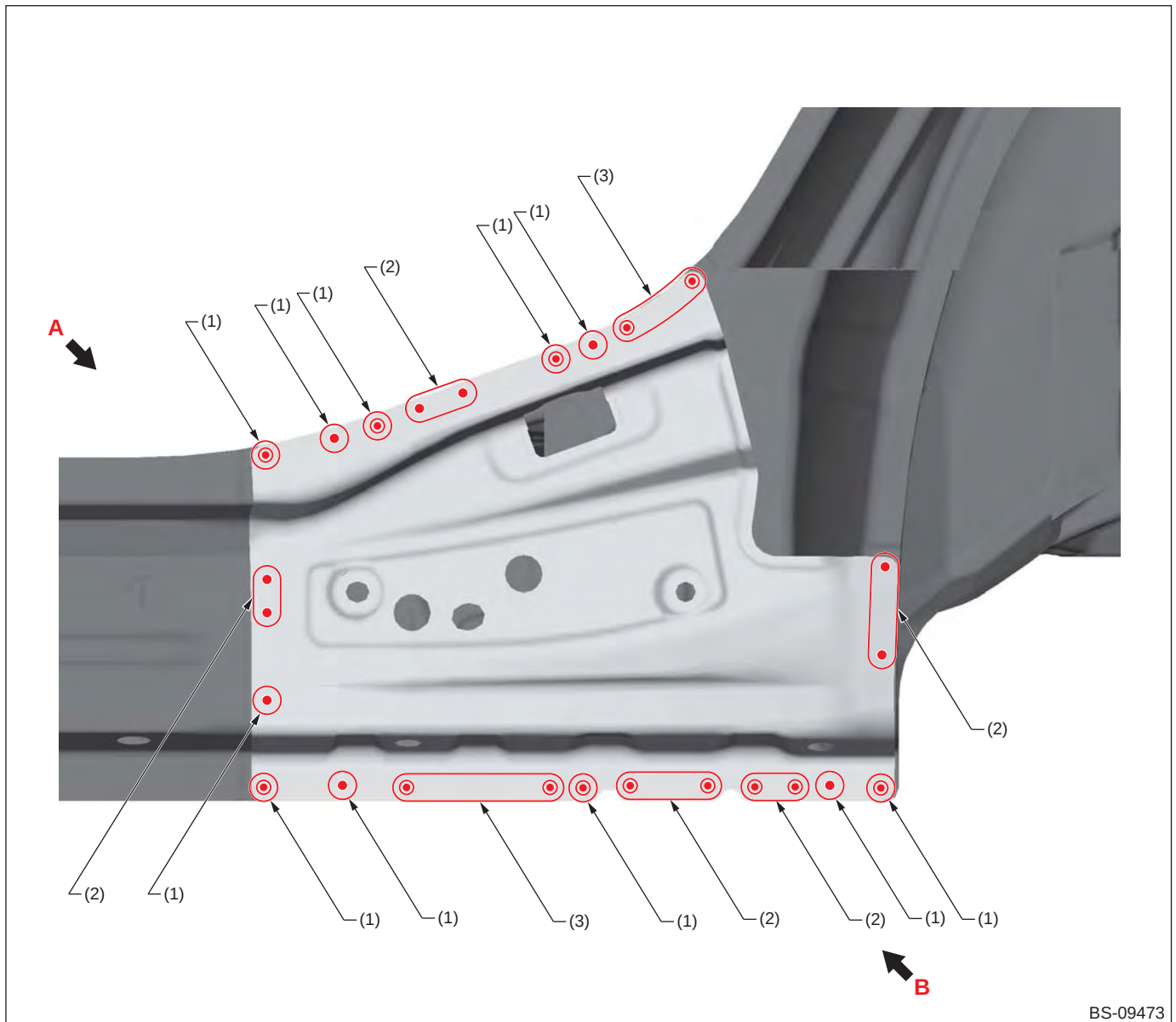
(2) 4 points

(3) 1 point (Continuous welding)

8-17. Side Sill Reinforcement Outer Rear (Total replacement)

A: REMOVAL

• Overall view



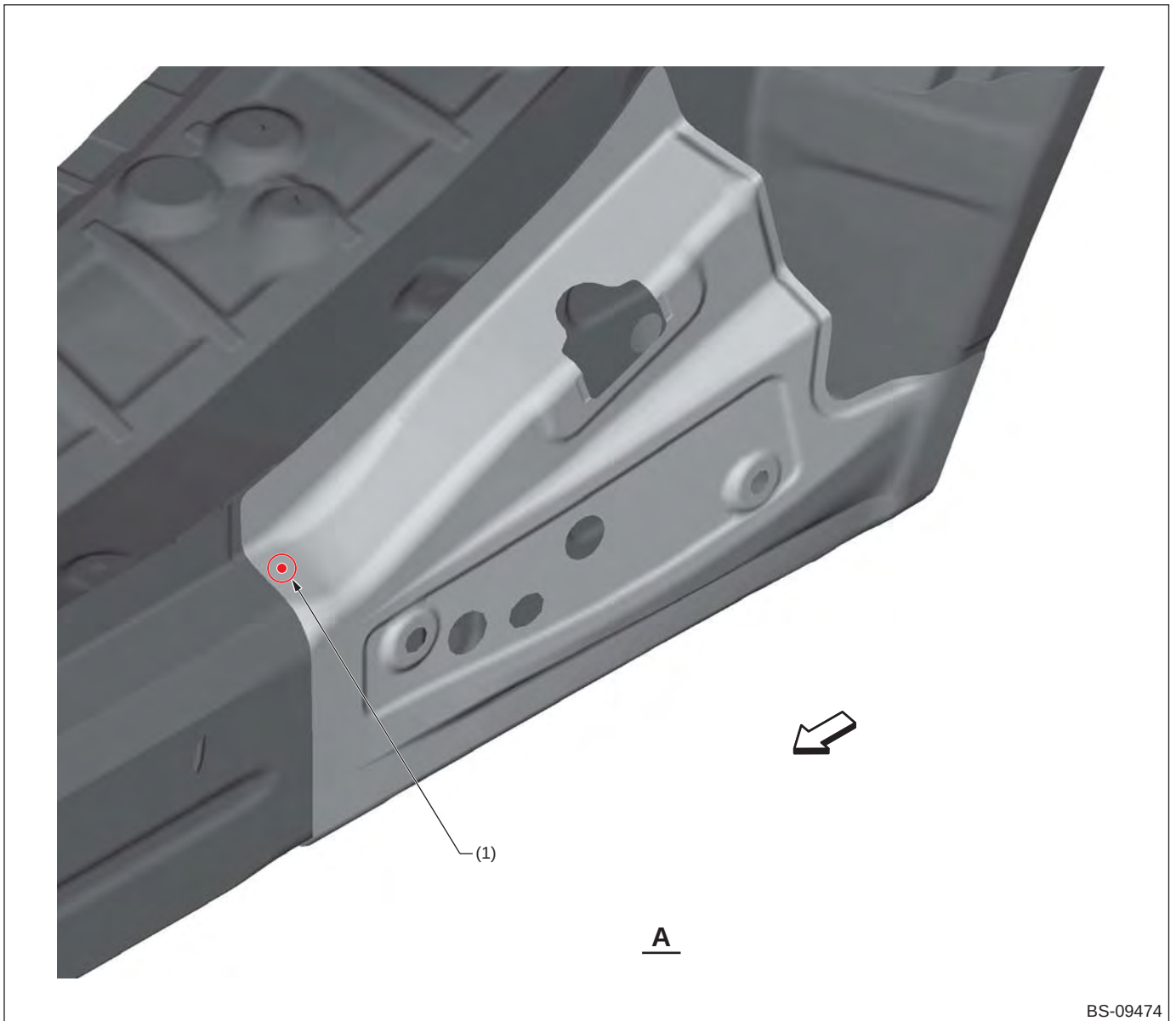
(1) 1 point (outside · 1)

(2) 2 points (outside · 1)

(3) 3 points (outside · 1)

Panel Replacement

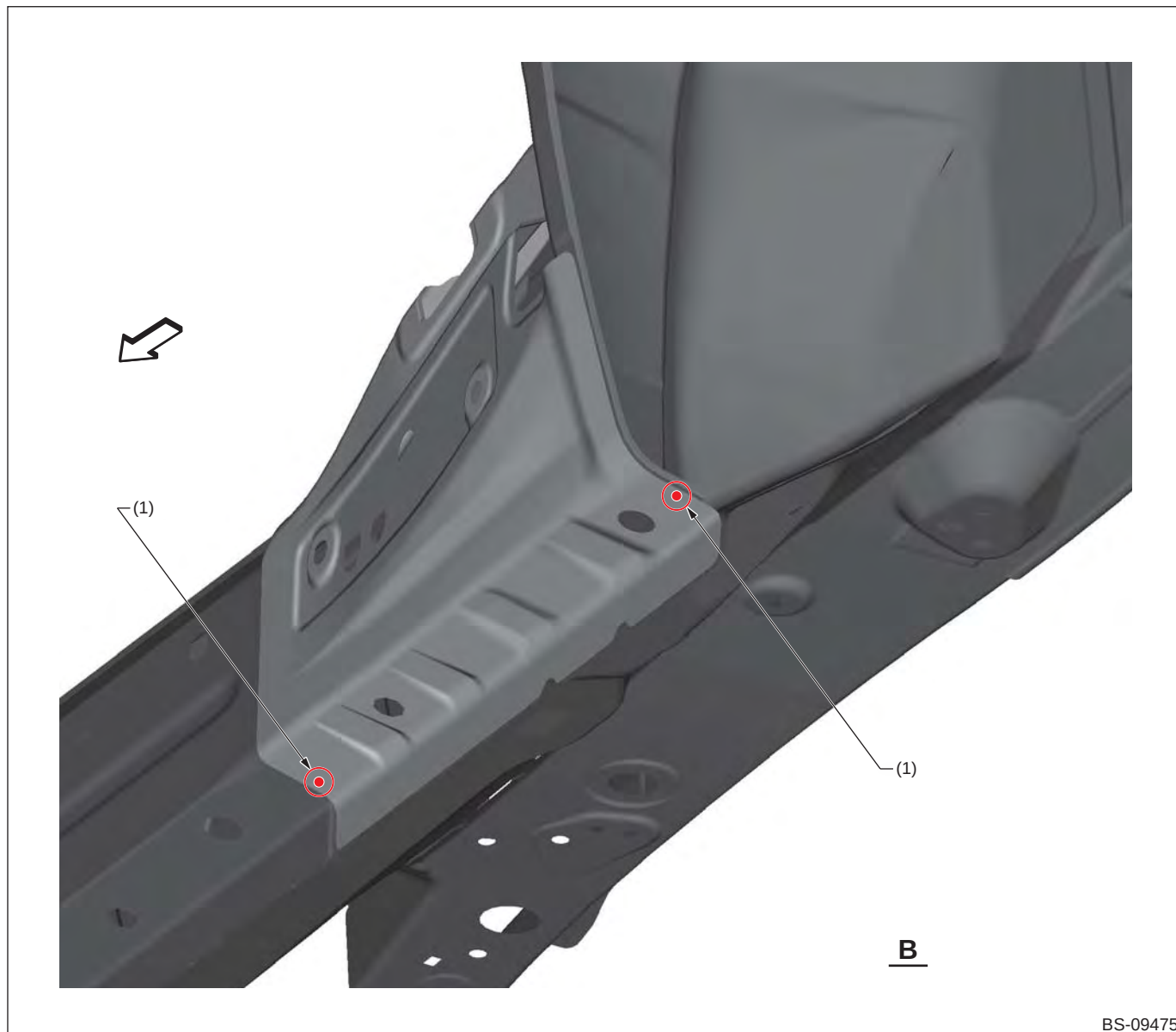
• Views A



(1) 1 point (outside · 1)

Panel Replacement

• Views B



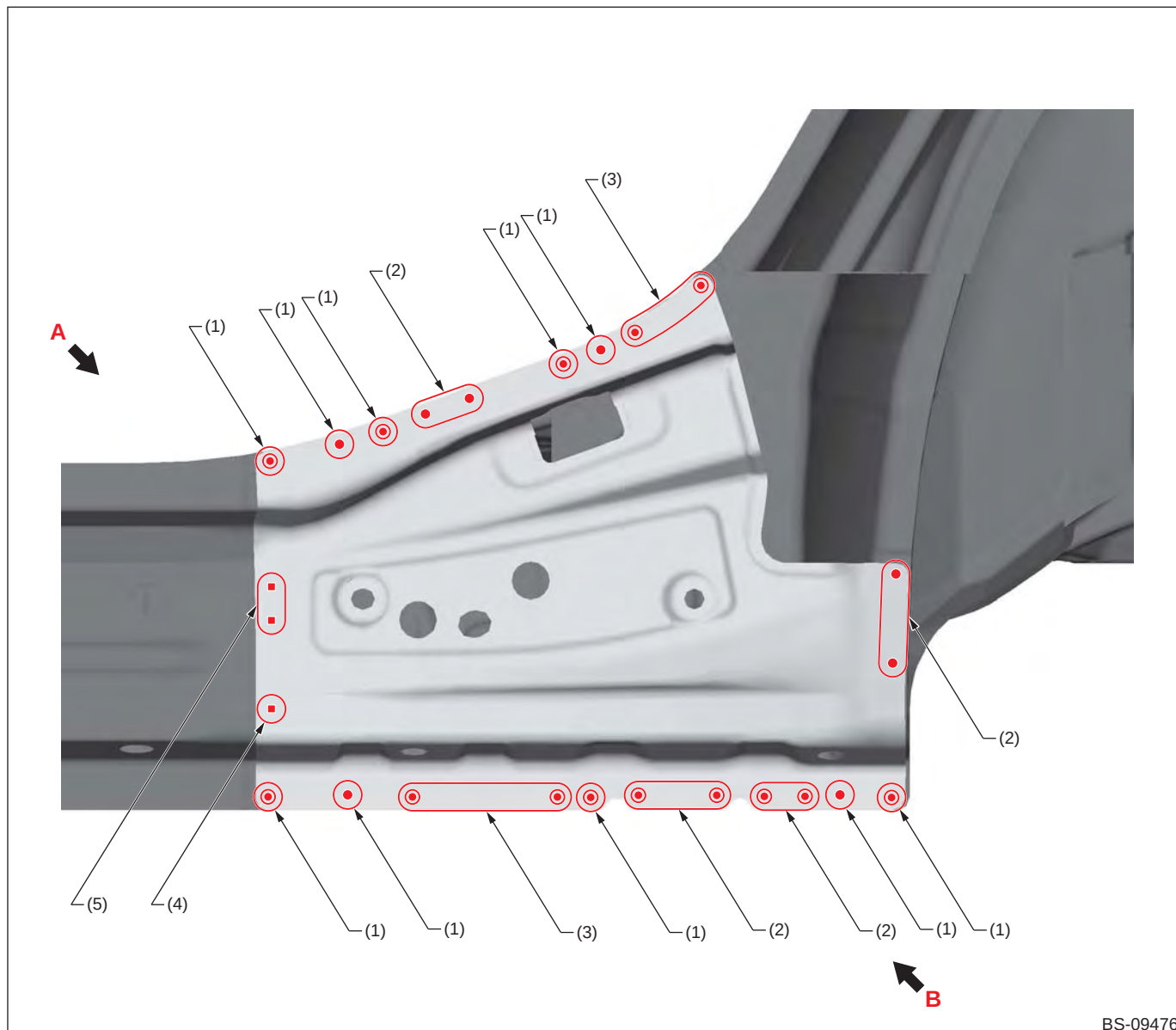
BS-09475

(1) 1 point (outside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



(1) 1 point
(2) 2 points

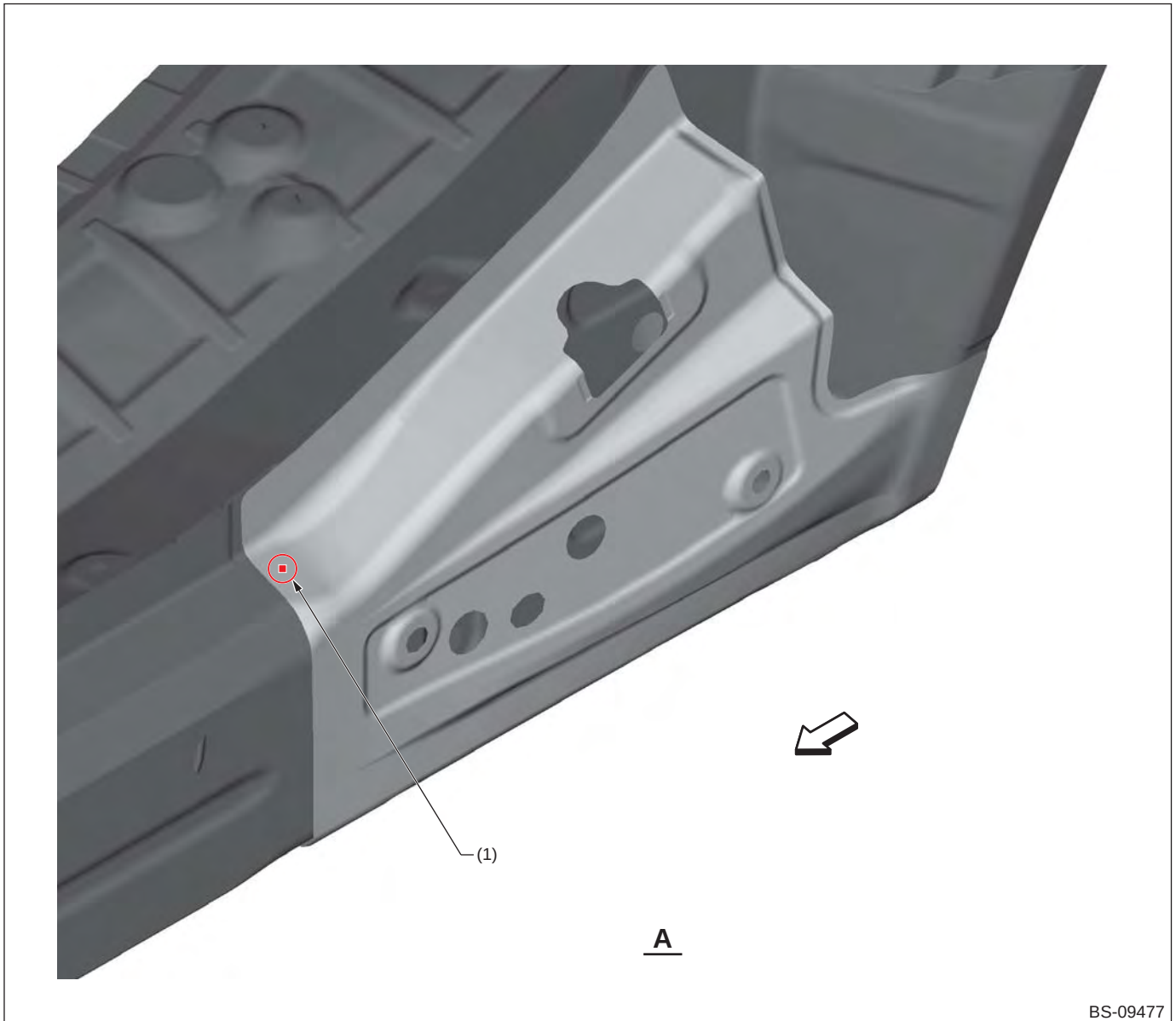
(3) 3 points
(4) 1 point (service)

(5) 2 points (service)

BS-09476

Panel Replacement

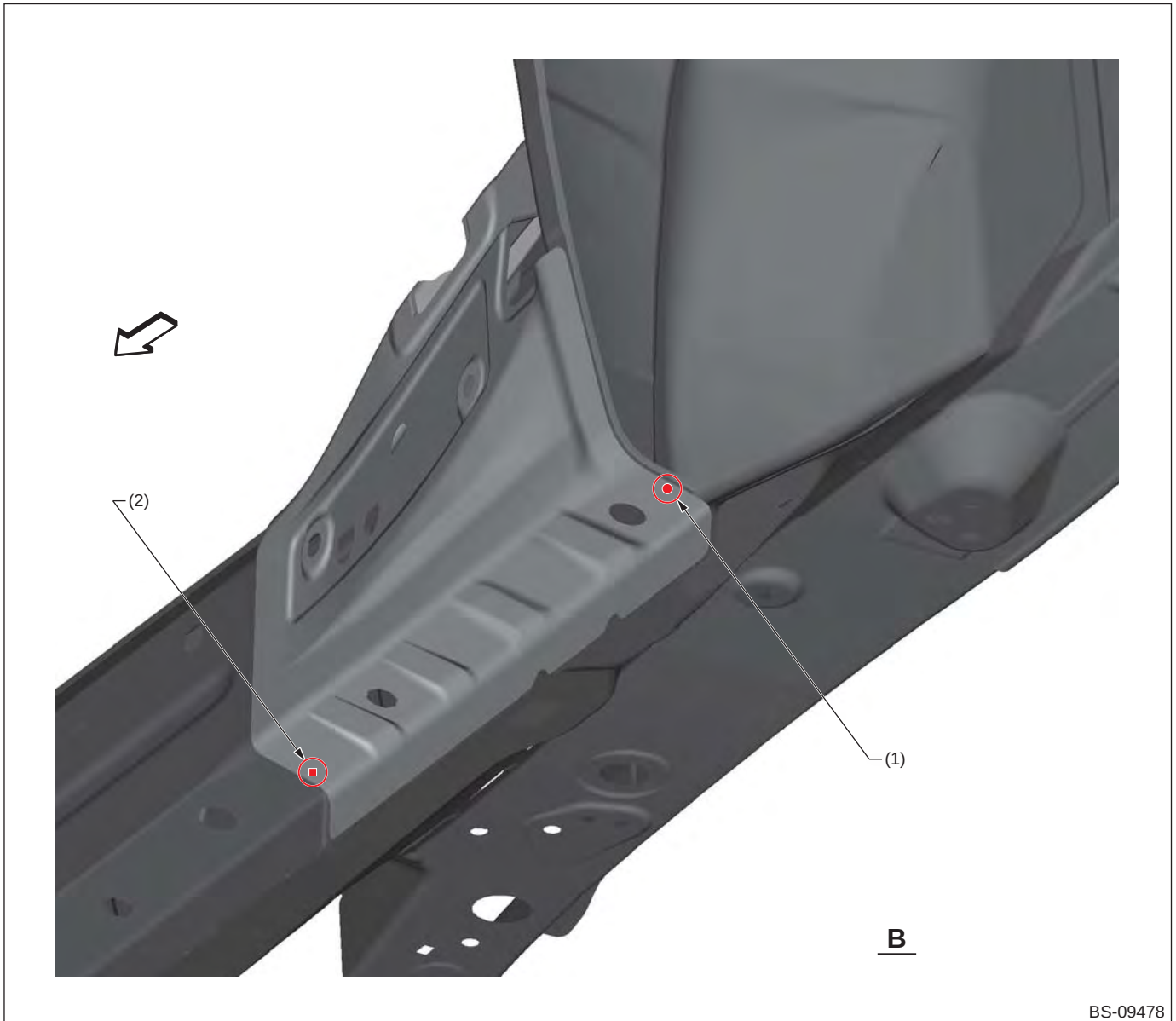
- Views A



(1) 1 point (service)

Panel Replacement

- Views B



BS-09478

(1) 1 point

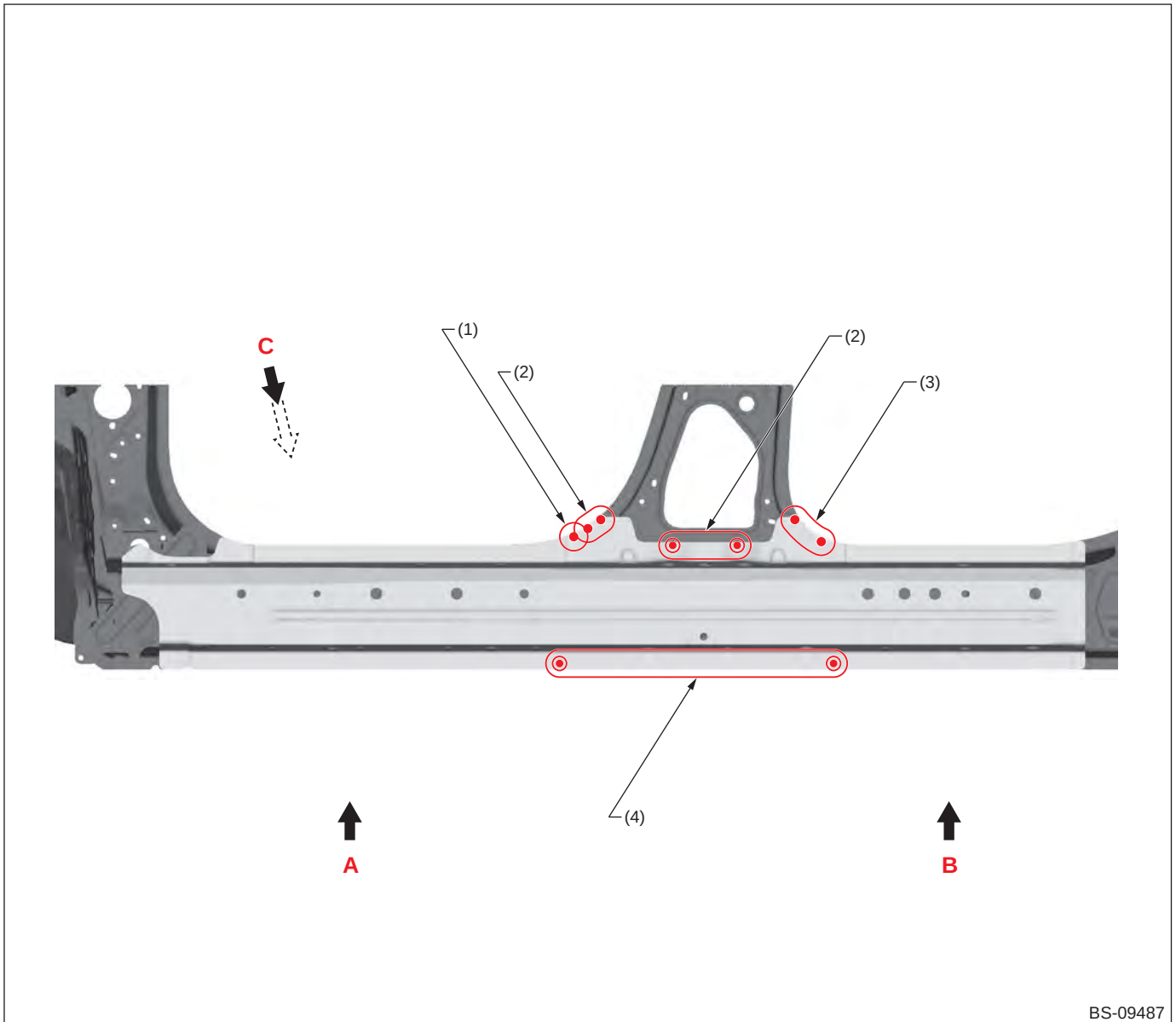
(2) 1 point (service)

Panel Replacement

8-18. Side Sill Reinforcement Outer (Total replacement)

A: REMOVAL

• Overall view

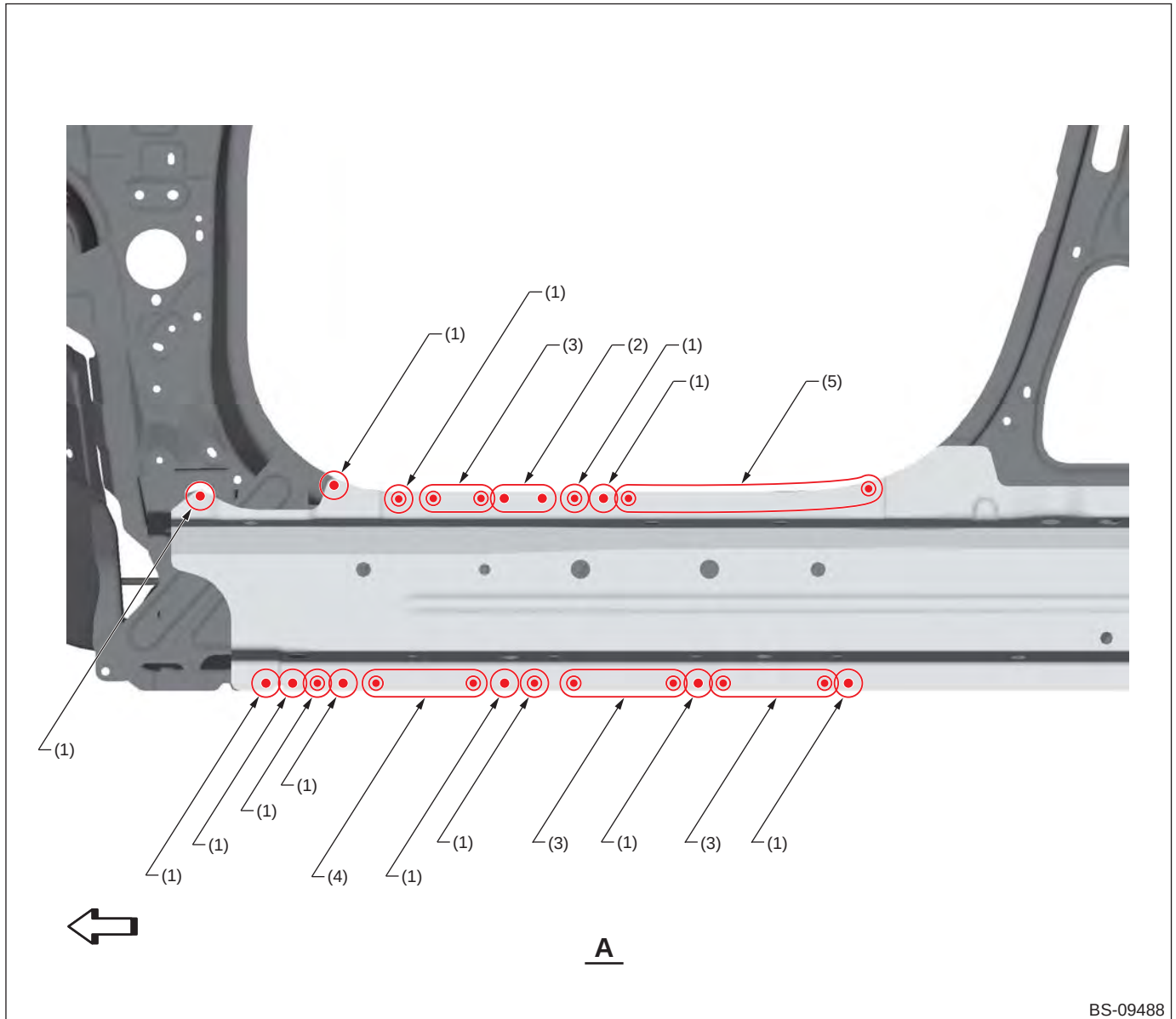


(1) 1 point (outside · 1)
(2) 2 points (outside · 1)

(3) 3 points (outside · 1)

(4) 10 points (outside · 1)

- **Views A**

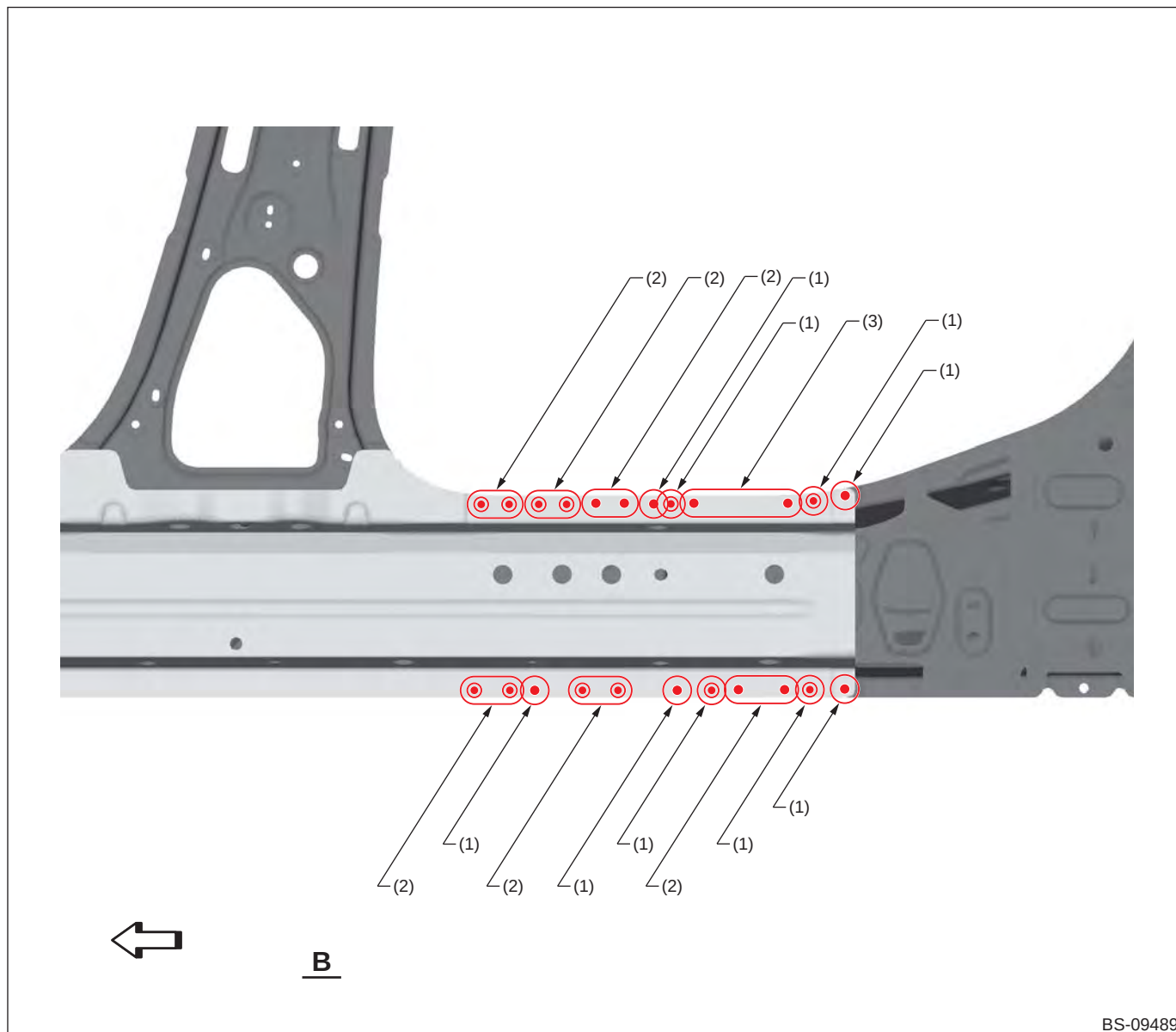


BS-09488

- (1) 1 point (outside · 1) (3) 3 points (outside · 1) (5) 8 points (outside · 1)
- (2) 2 points (outside · 1) (4) 4 points (outside · 1)

Panel Replacement

• Views B



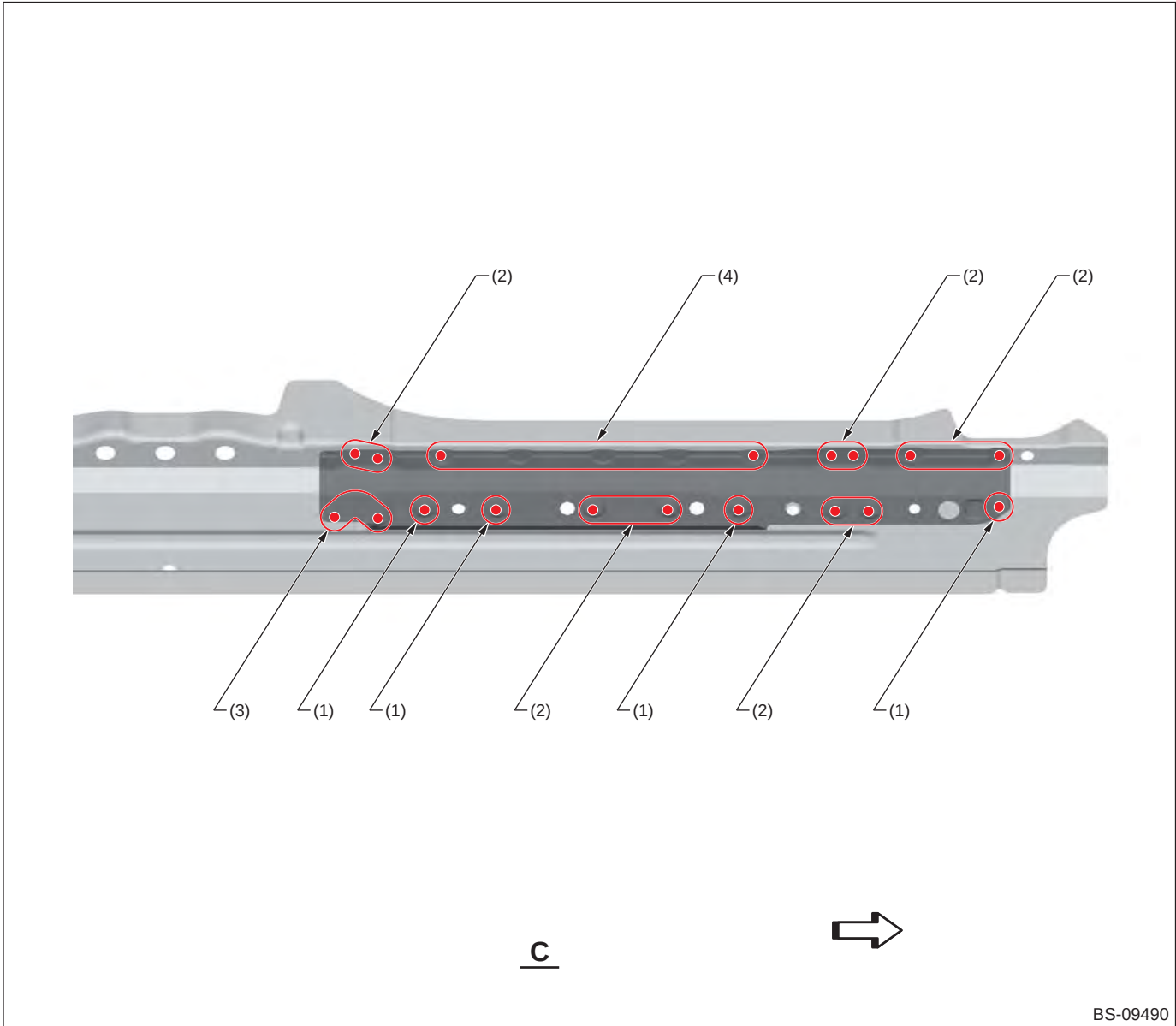
(1) 1 point (outside · 1)

(2) 2 points (outside · 1)

(3) 4 points (outside · 1)

Panel Replacement

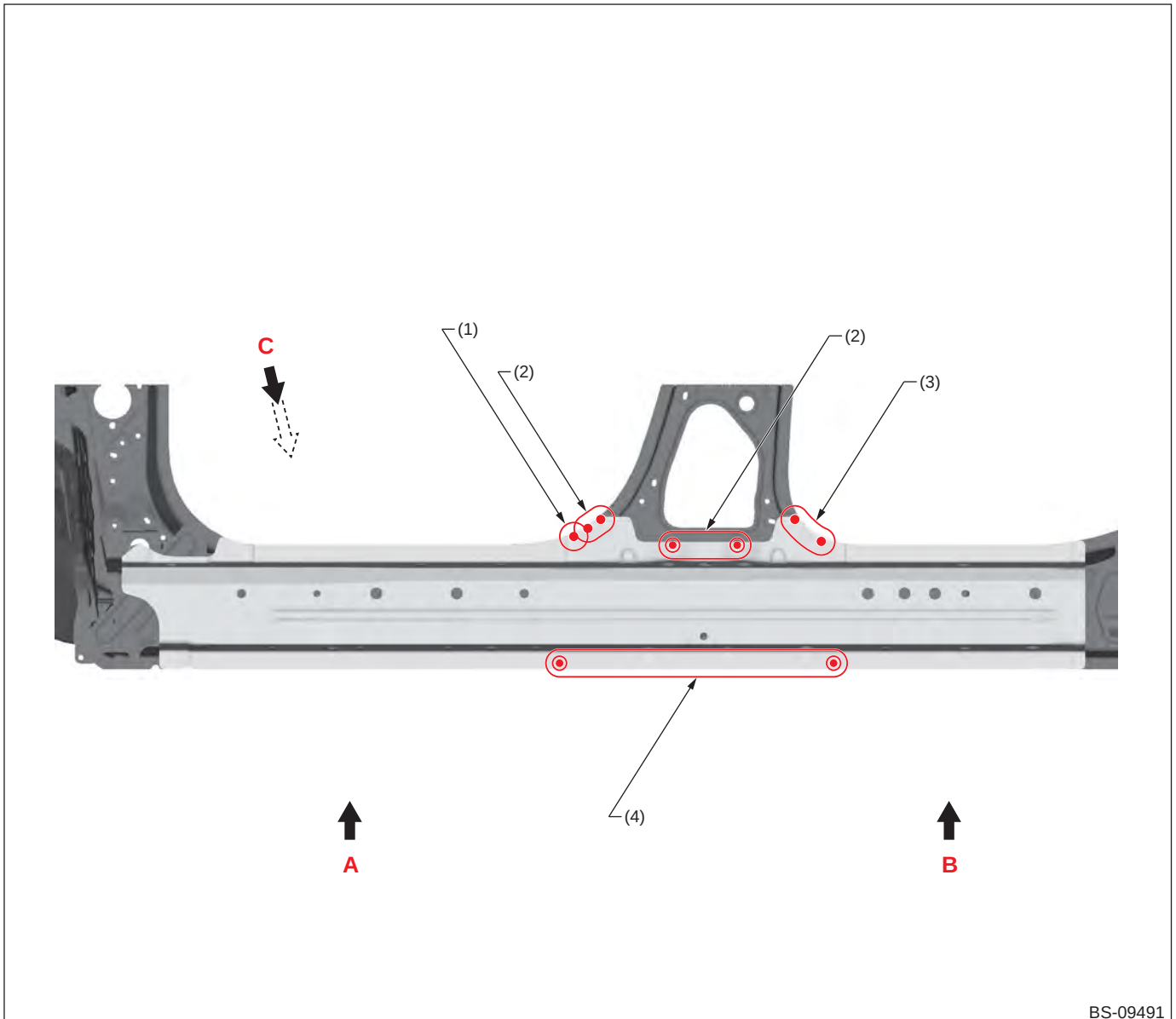
• Views C



Panel Replacement

B: INSTALLATION

• Overall view



BS-09491

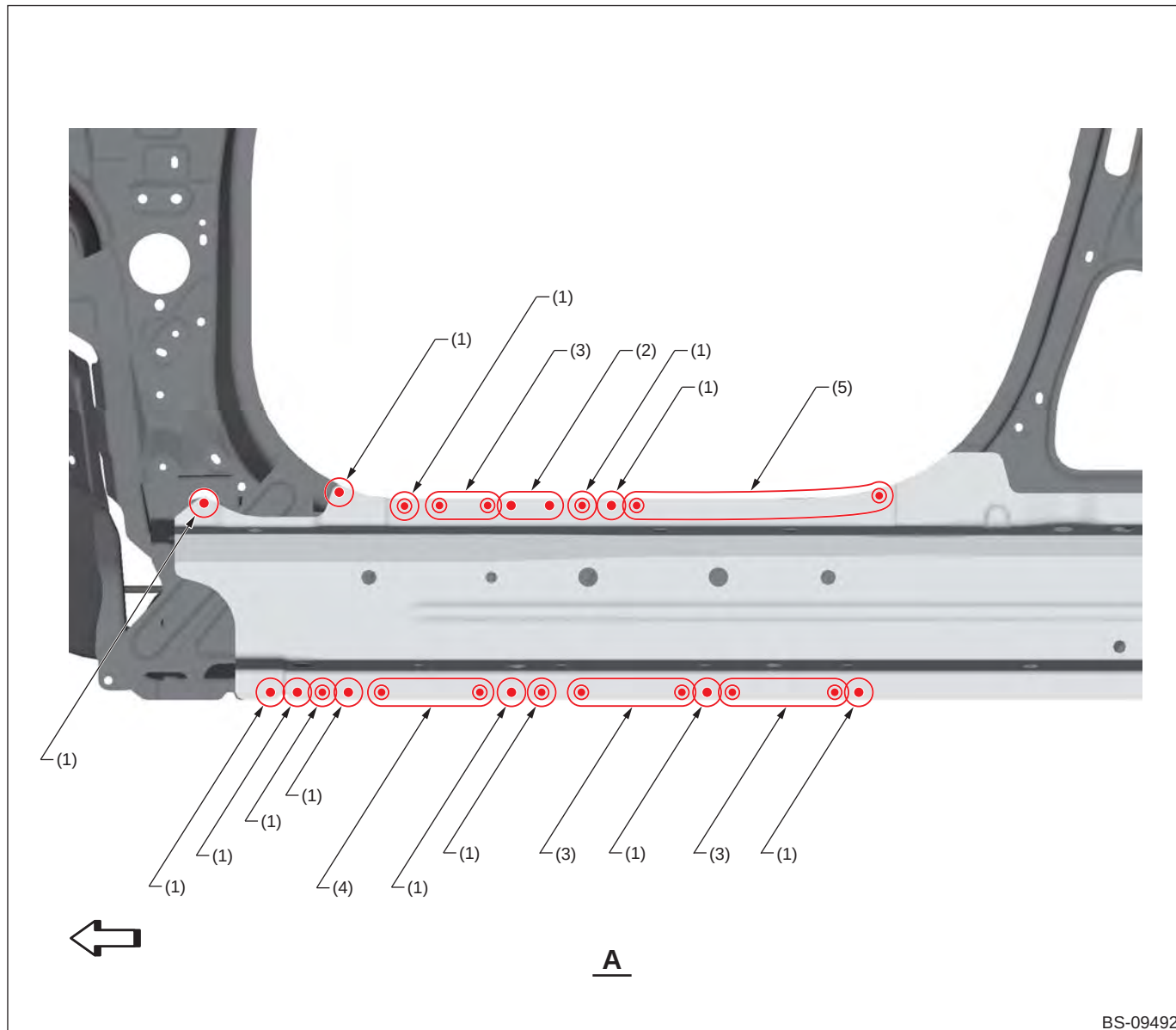
- (1) 1 point
(2) 2 points

- (3) 3 points

- (4) 10 points

Panel Replacement

• Views A



BS-09492

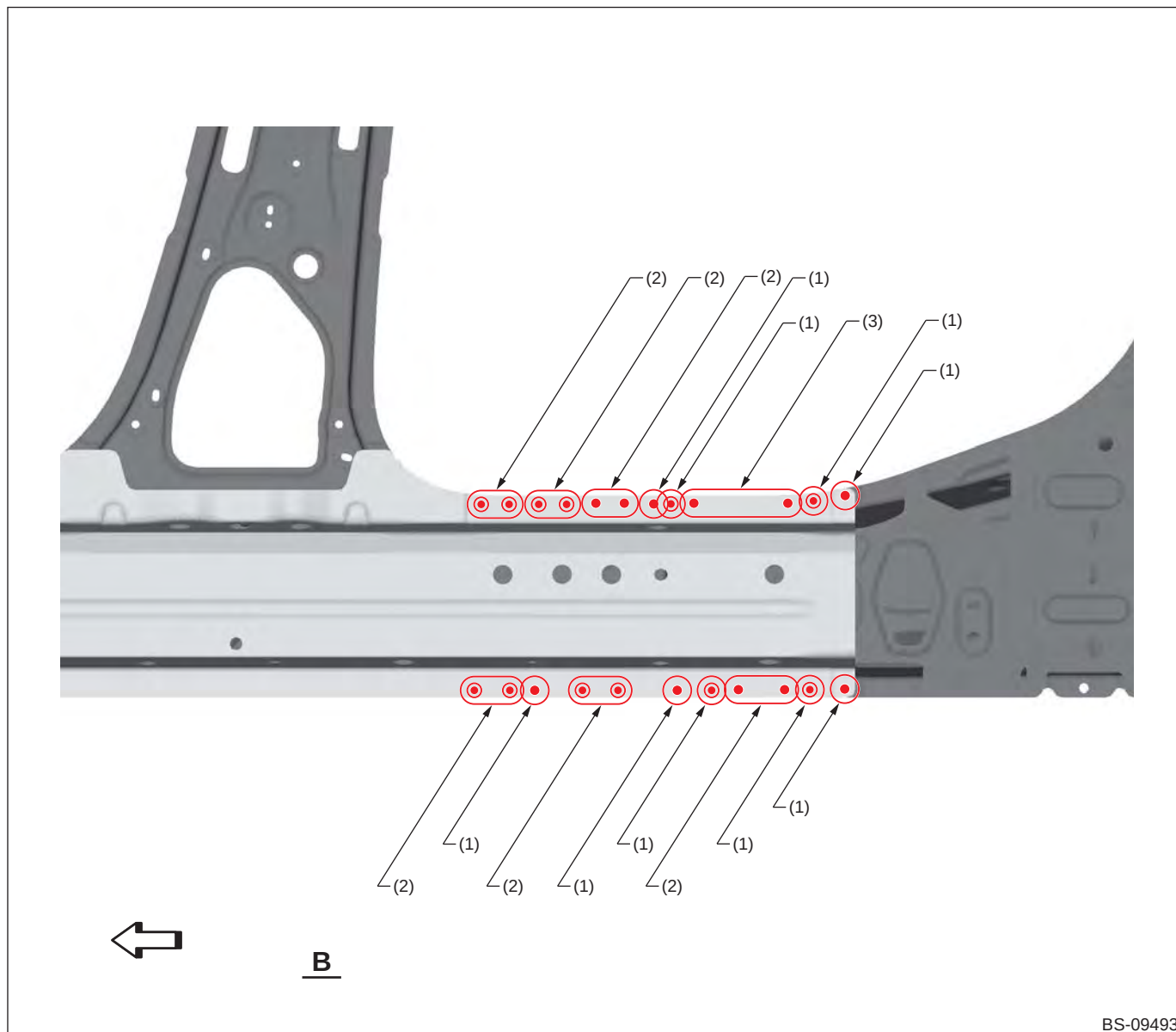
(1) 1 point
(2) 2 points

(3) 3 points
(4) 4 points

(5) 8 points

Panel Replacement

• Views B



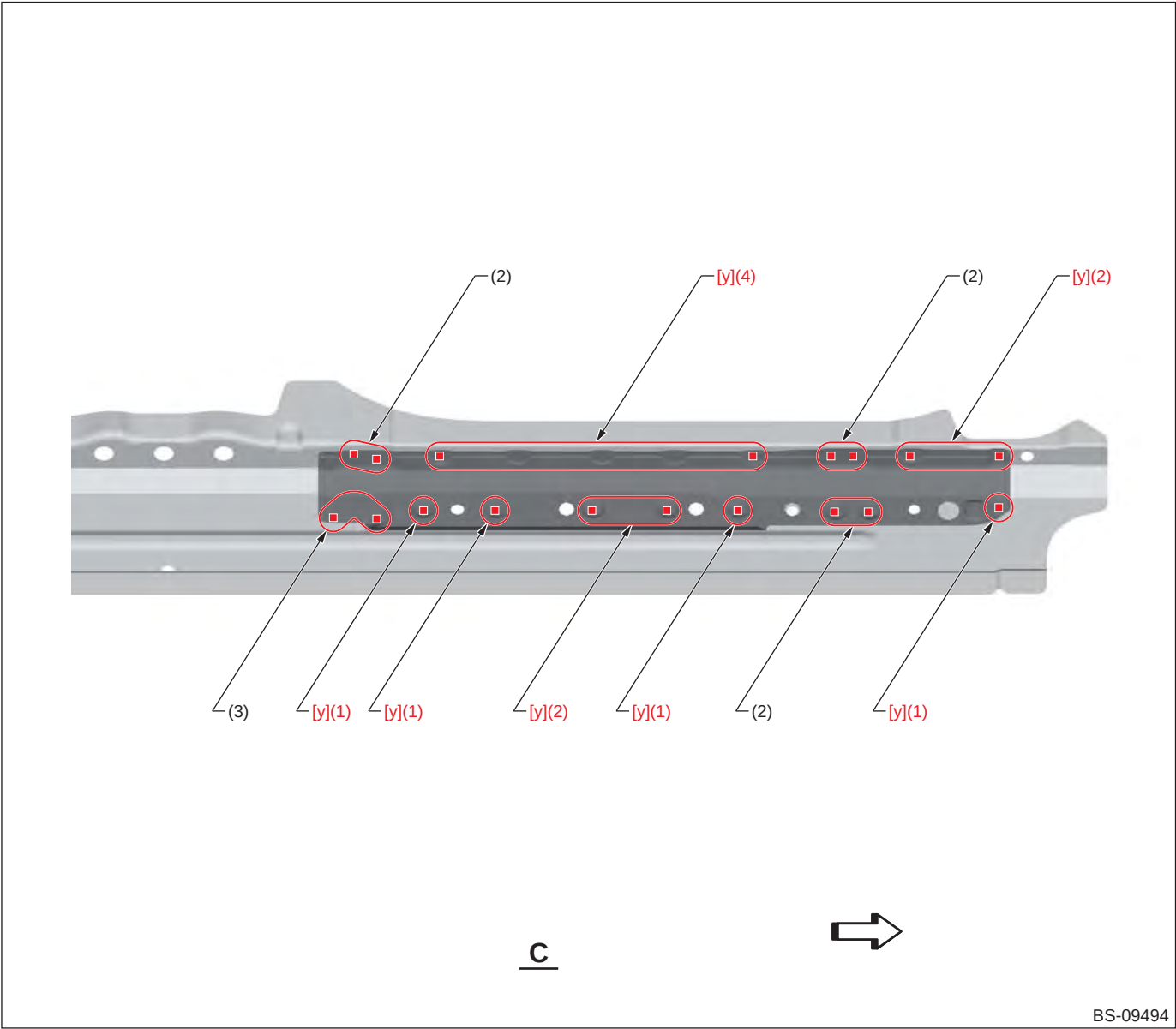
(1) 1 point

(2) 2 points

(3) 4 points

Panel Replacement

• Views C



- (1) 1 point
- (2) 2 points

- (3) 3 points

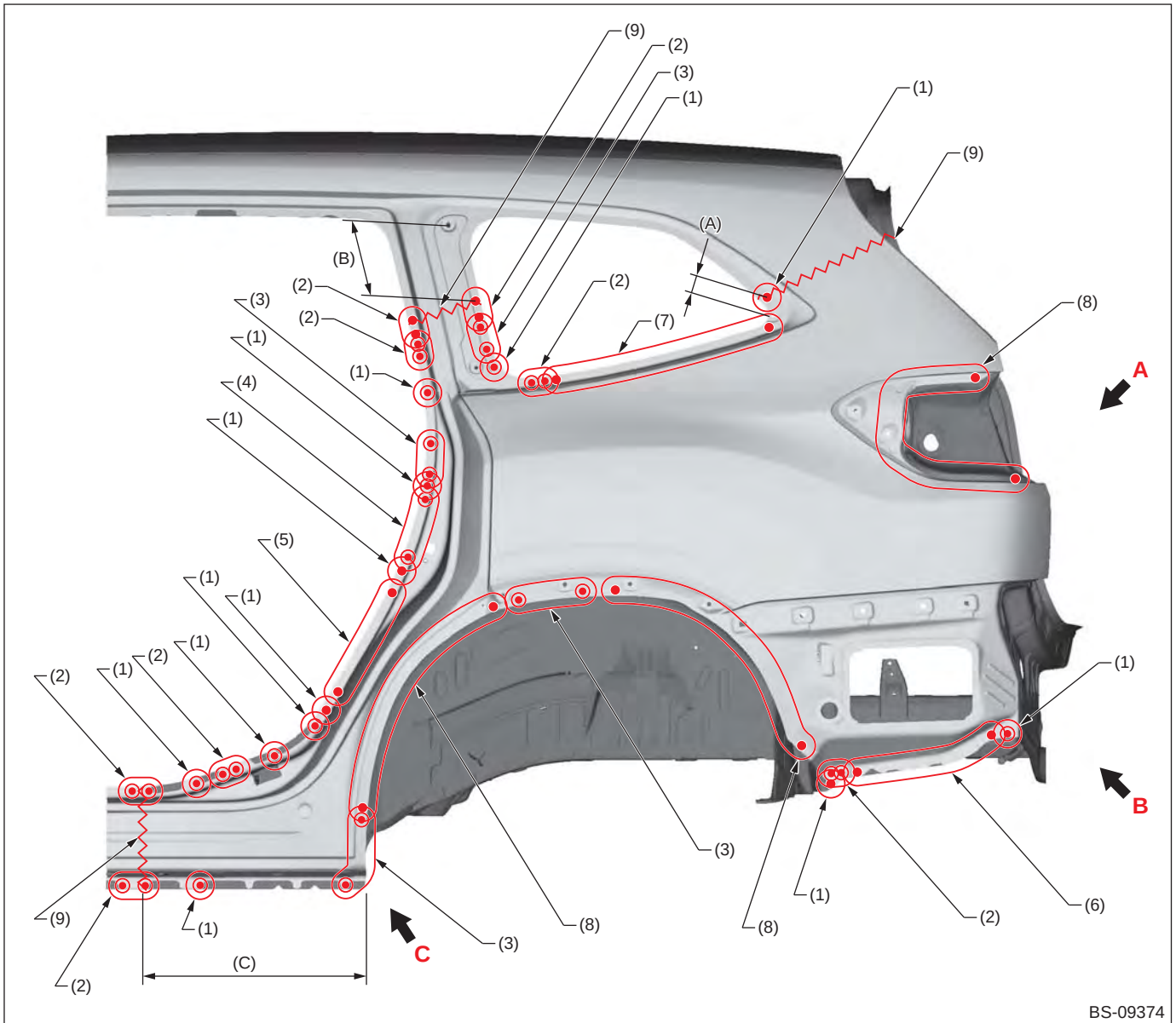
- (4) 5 points

[y] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2 B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)
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8-19. Rear Quarter Panel (Partial replacement)

A: REMOVAL

• Overall view



BS-09374

(A) 30 mm [1.18 in]

(B) 180 mm [7.09 in]

(C) 450 mm [17.72 in]

(1) 1 point (outside · 1)

(4) 4 points (outside · 1)

(7) 8 points (outside · 1)

(2) 2 points (outside · 1)

(5) 5 points (outside · 1)

(8) 9 points (outside · 1)

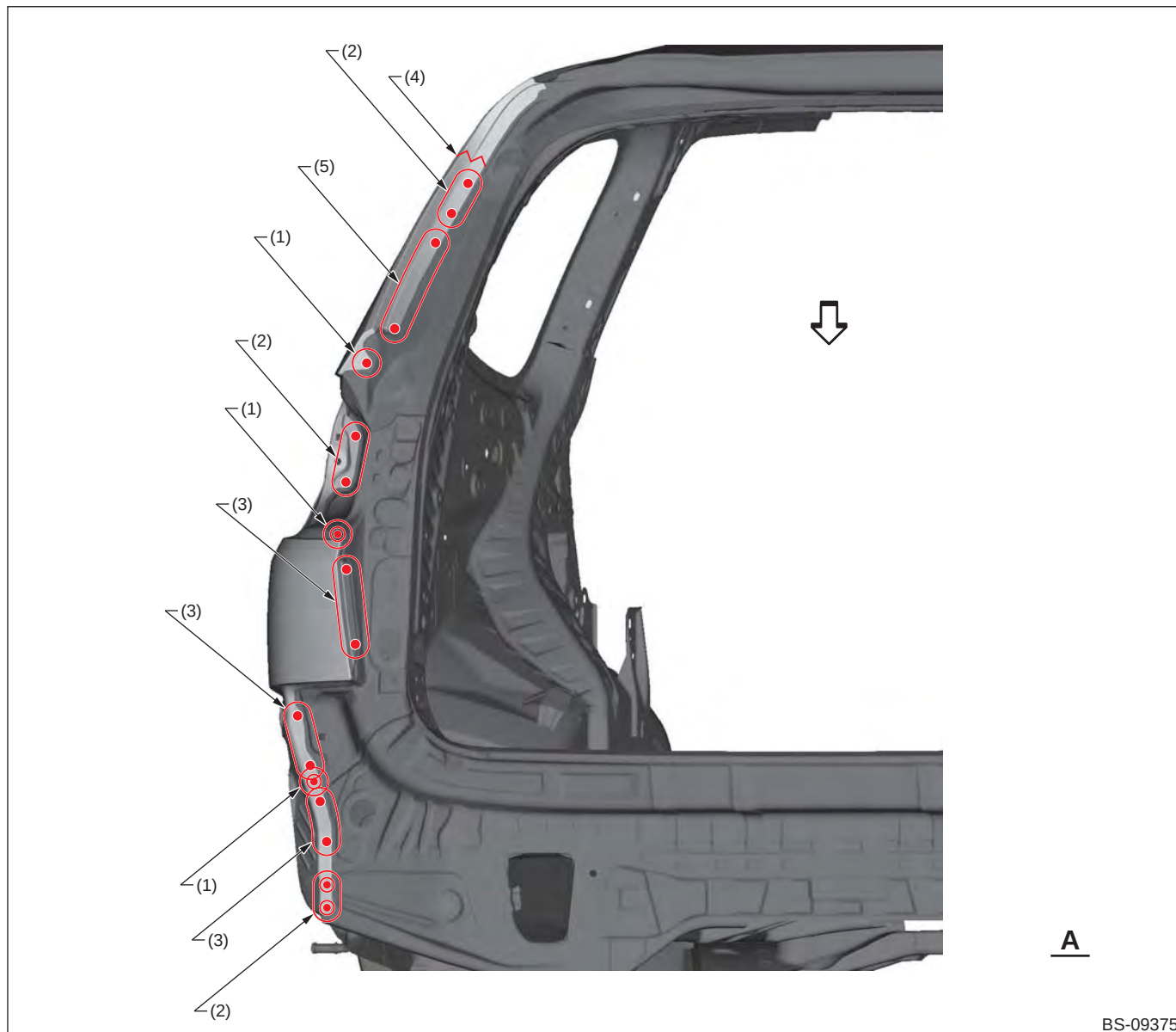
(3) 3 points (outside · 1)

(6) 7 points (outside · 1)

(9) Cut position

Panel Replacement

• Views A



BS-09375

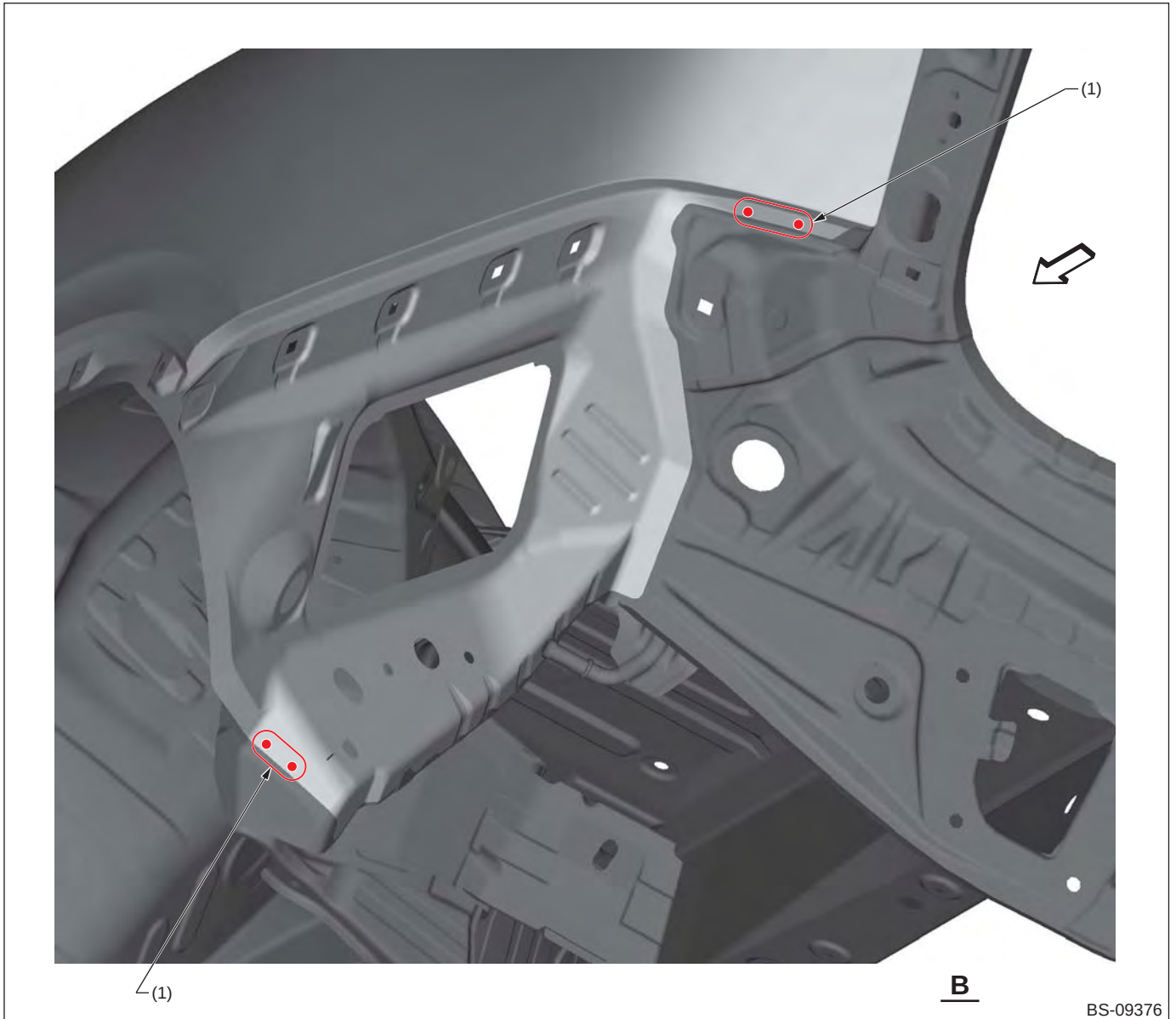
(1) 1 point (outside · 1)
(2) 2 points (outside · 1)

(3) 3 points (outside · 1)
(4) Cut position

(5) 4 points (outside · 1)

Panel Replacement

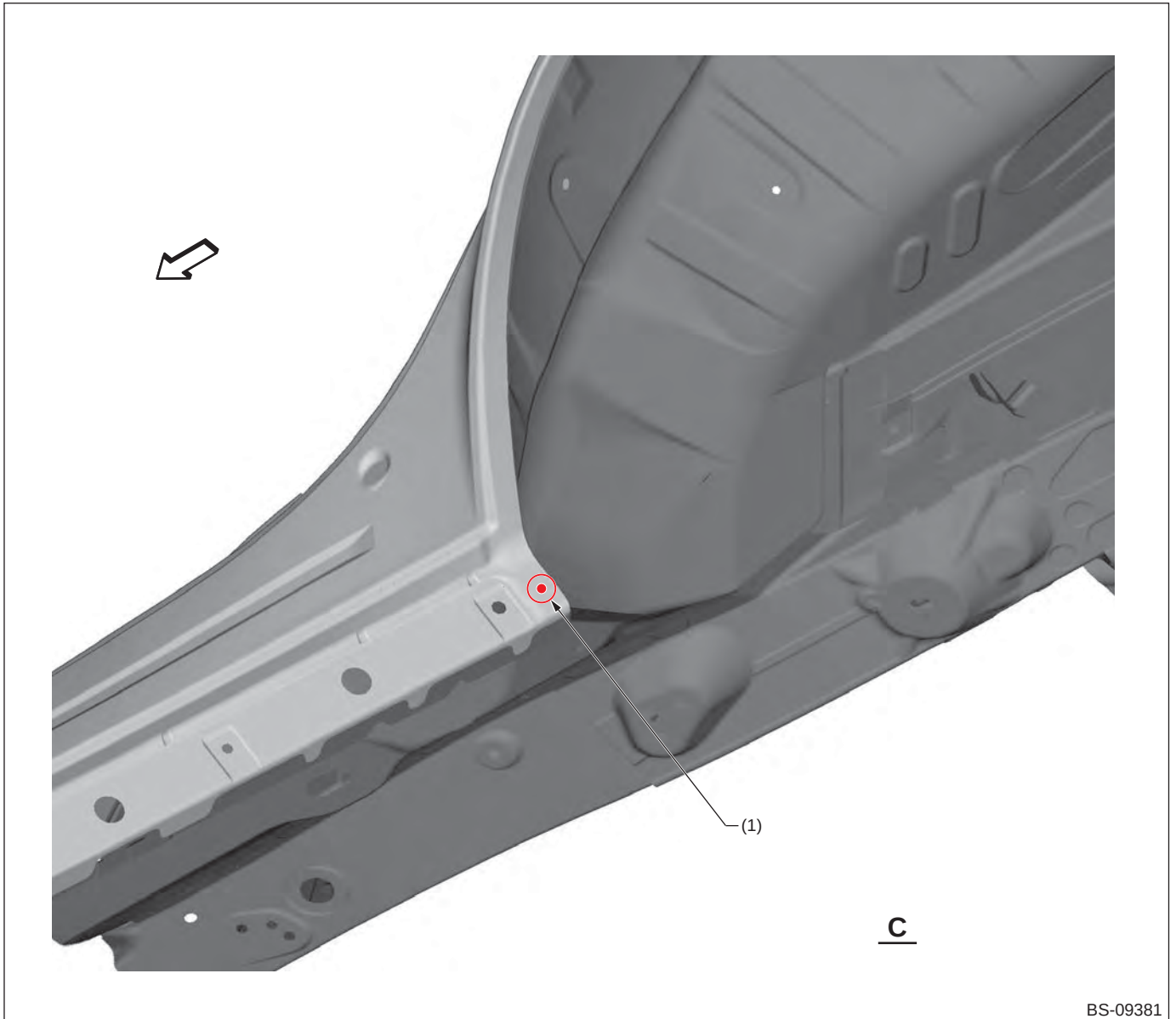
• Views B



(1) 2 points (outside · 1)

Panel Replacement

- Views C

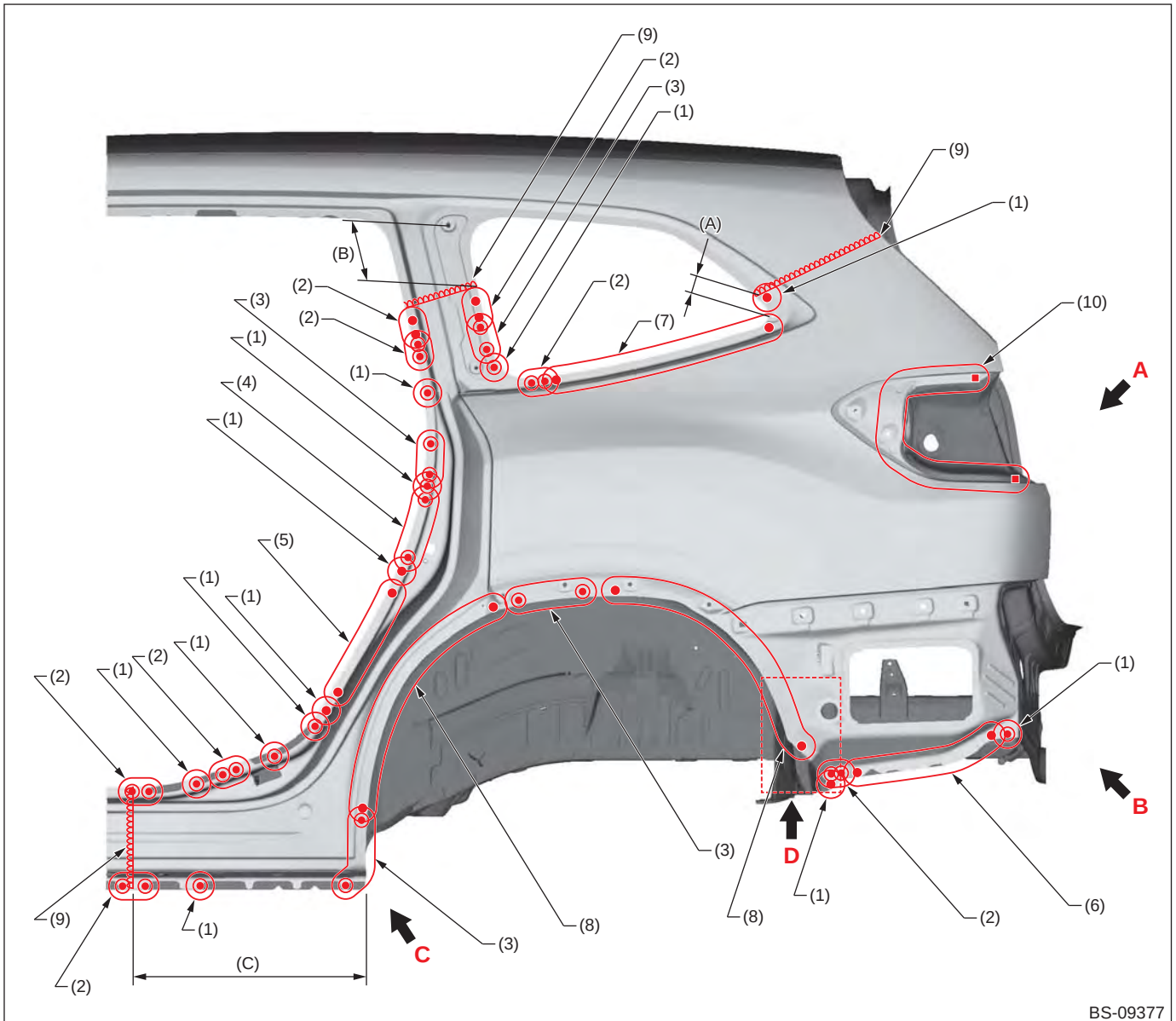


(1) 1 point (outside · 1)

Panel Replacement

B: INSTALLATION

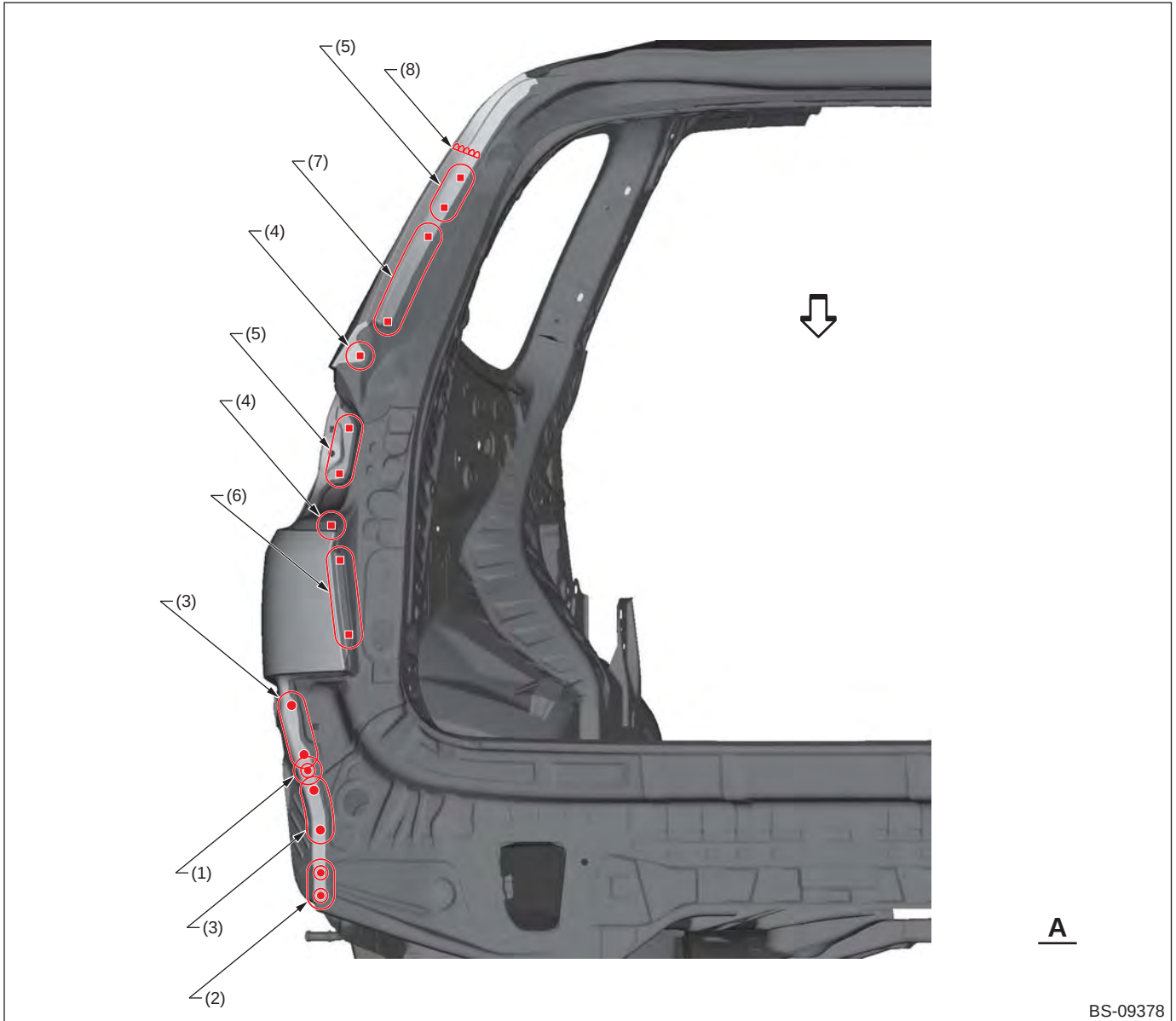
• Overall view



BS-09377

Panel Replacement

• Views A



BS-09378

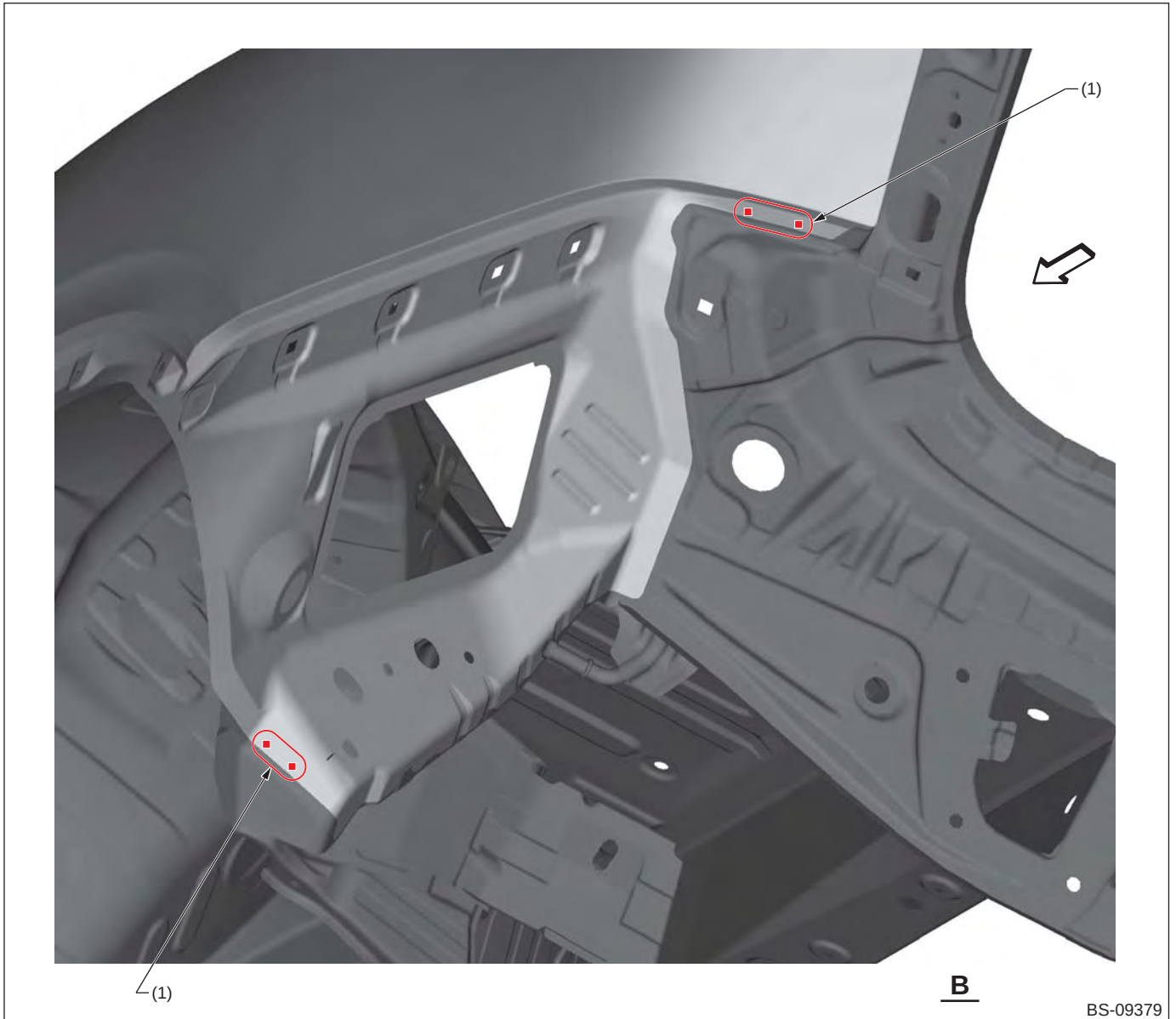
- (1) 1 point
- (2) 2 points
- (3) 3 points

- (4) 1 point (service)
- (5) 2 points (service)
- (6) 3 points (service)

- (7) 4 points (service)
- (8) 1 point (Continuous welding)

Panel Replacement

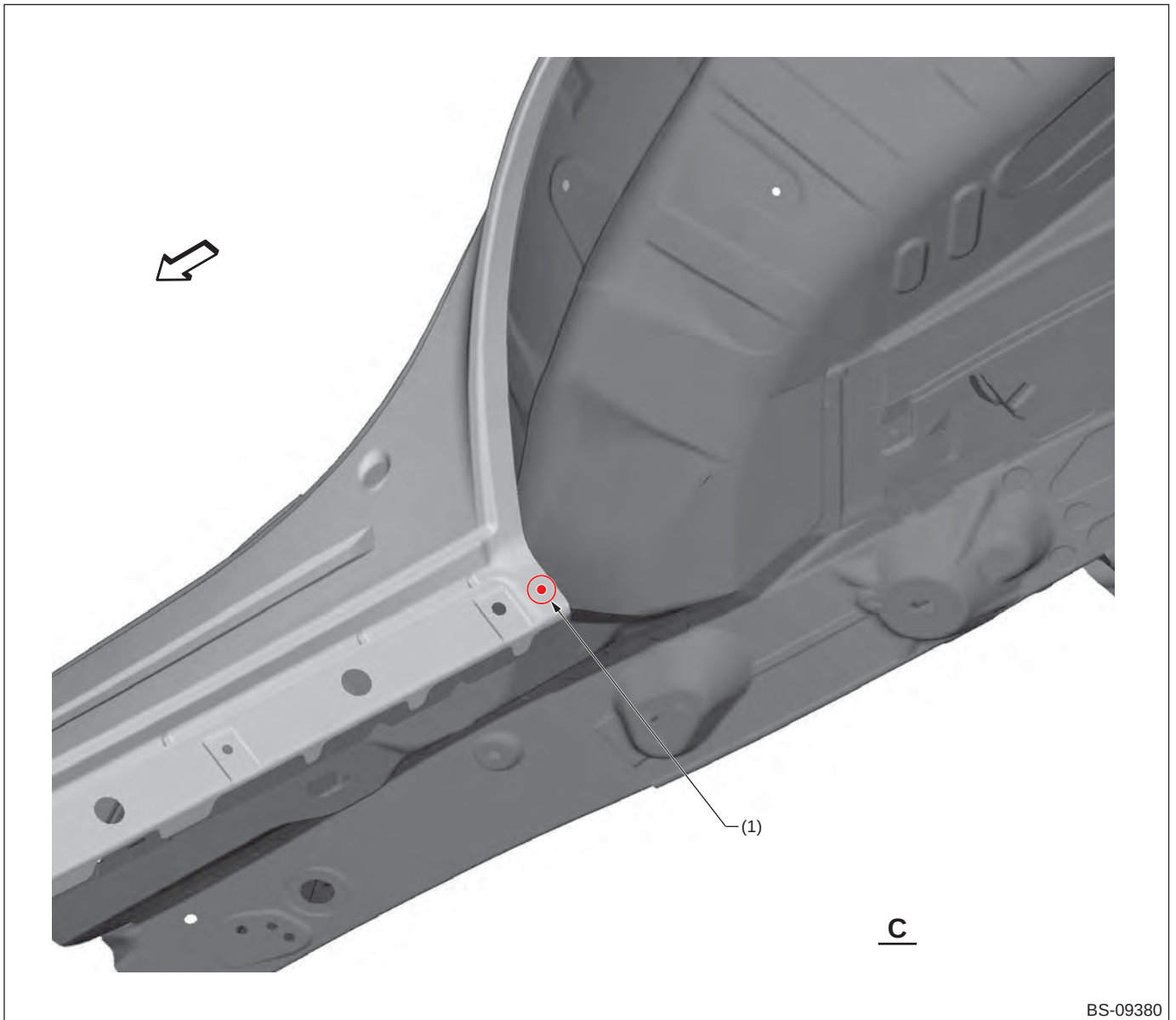
• Views B



(1) 2 points (service)

Panel Replacement

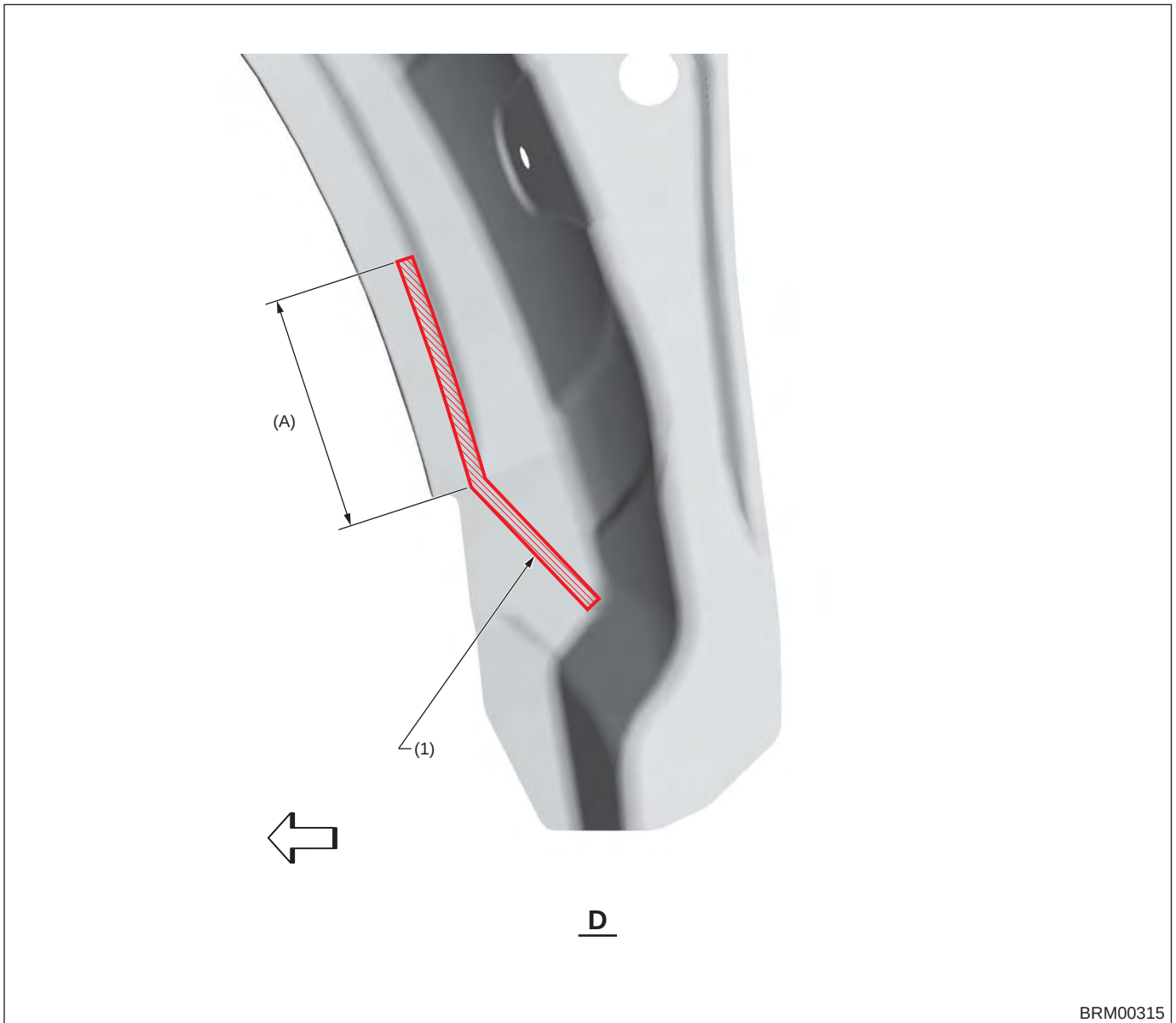
- Views C



(1) 1 point

Panel Replacement

• Views D



(A) 80 mm [3.15 in]

(1) Spotting sealer

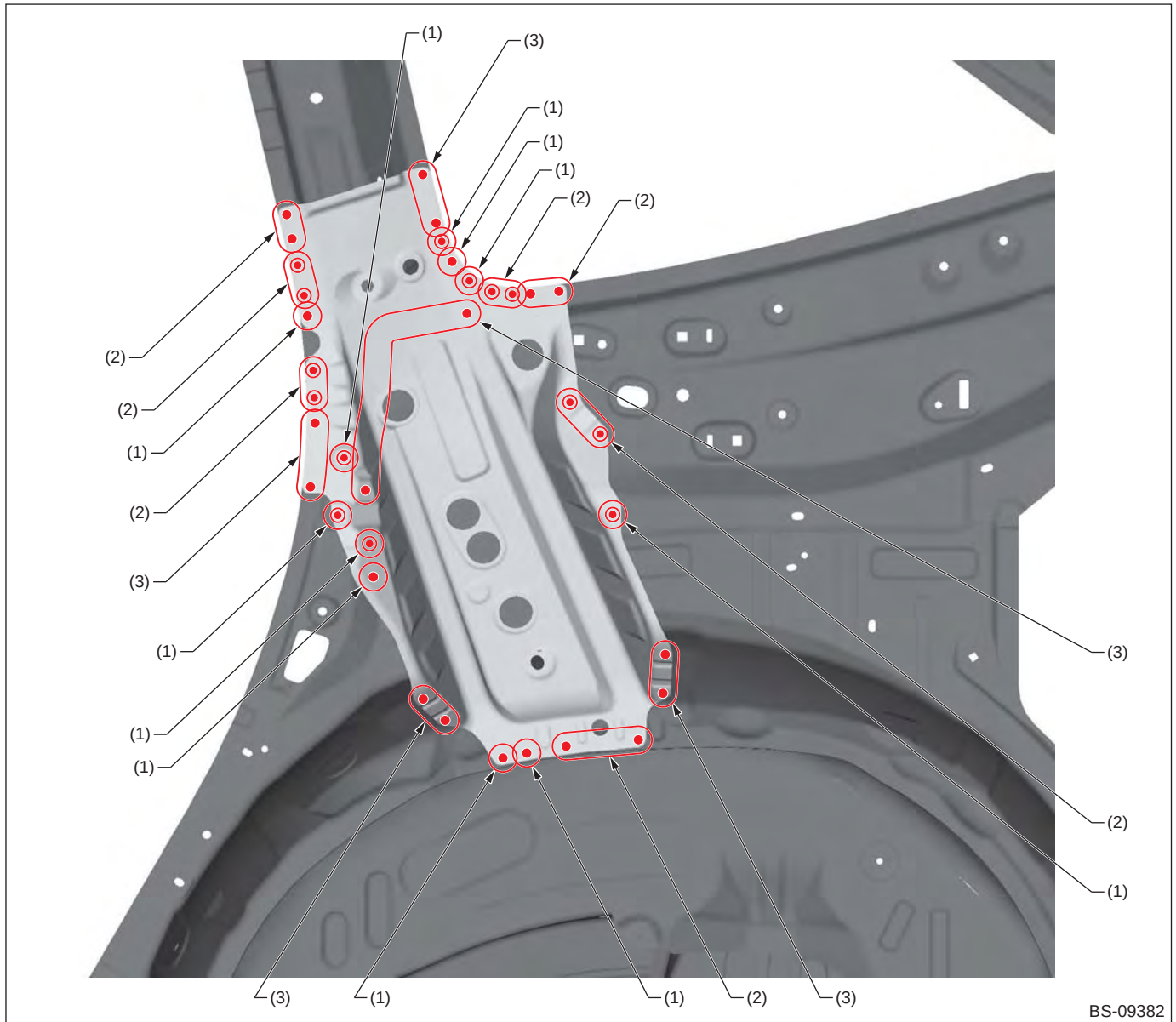
 : Spotting sealer application location (Spotting sealer or sealing [Three Bond 4101 (004403063)])
Note: Fill spotting sealer between the panel side out and arch rear inner.

Panel Replacement

8-20. Rear Pillar Reinforcement Outer (Total replacement)

A: REMOVAL

- **Overall view**



BS-09382

(1) 1 point (outside · 1)

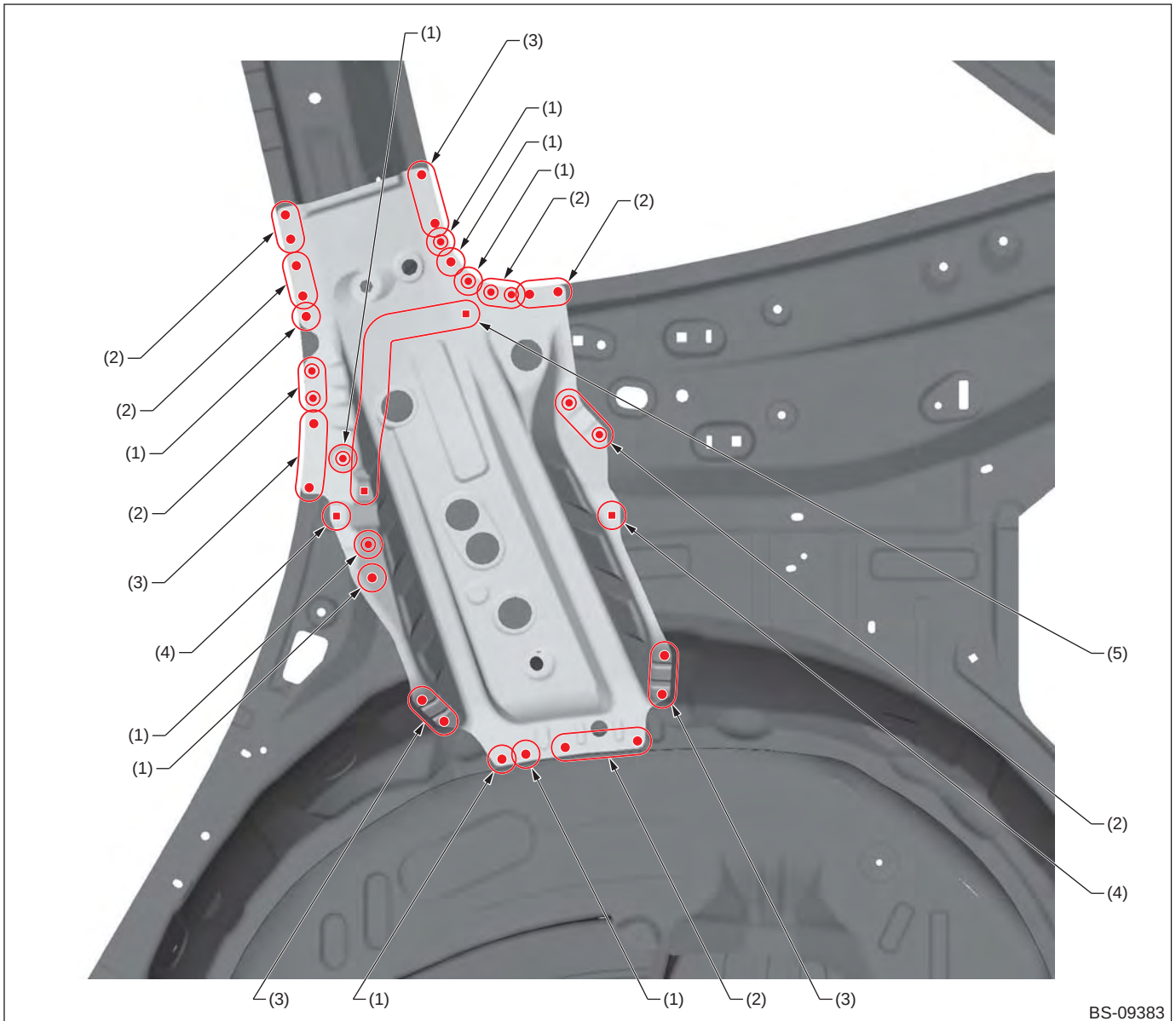
(2) 2 points (outside · 1)

(3) 3 points (outside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BS-09383

(1) 1 point
(2) 2 points

(3) 3 points
(4) 1 point (service)

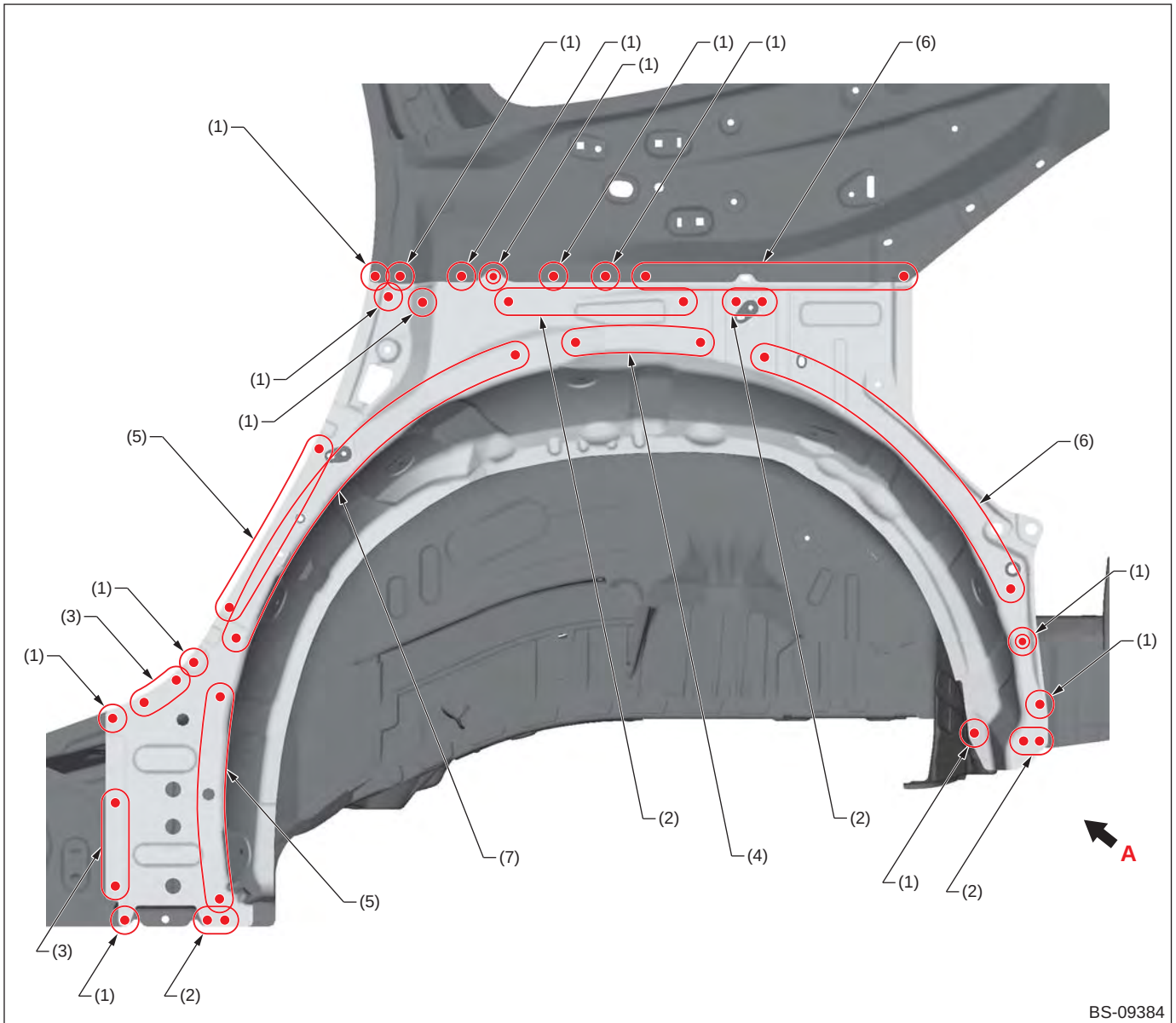
(5) 3 points (service)

Panel Replacement

8-21. Arch Rear Inner LH (Total replacement)

A: REMOVAL

• Overall view



BS-09384

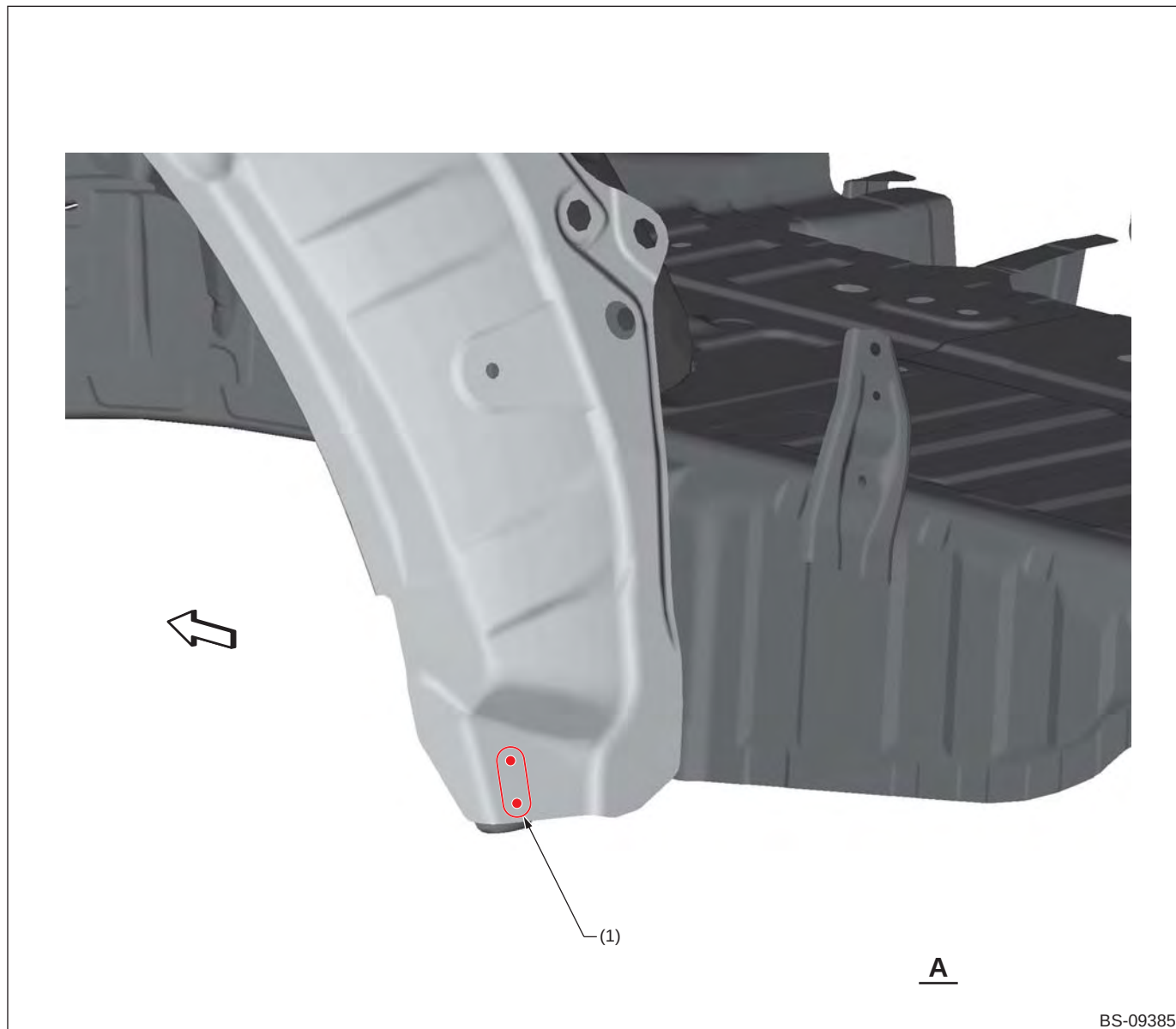
- (1) 1 point (outside · 1)
- (2) 2 points (outside · 1)
- (3) 3 points (outside · 1)

- (4) 4 points (outside · 1)
- (5) 5 points (outside · 1)
- (6) 6 points (outside · 1)

- (7) 8 points (outside · 1)

Panel Replacement

- Views A



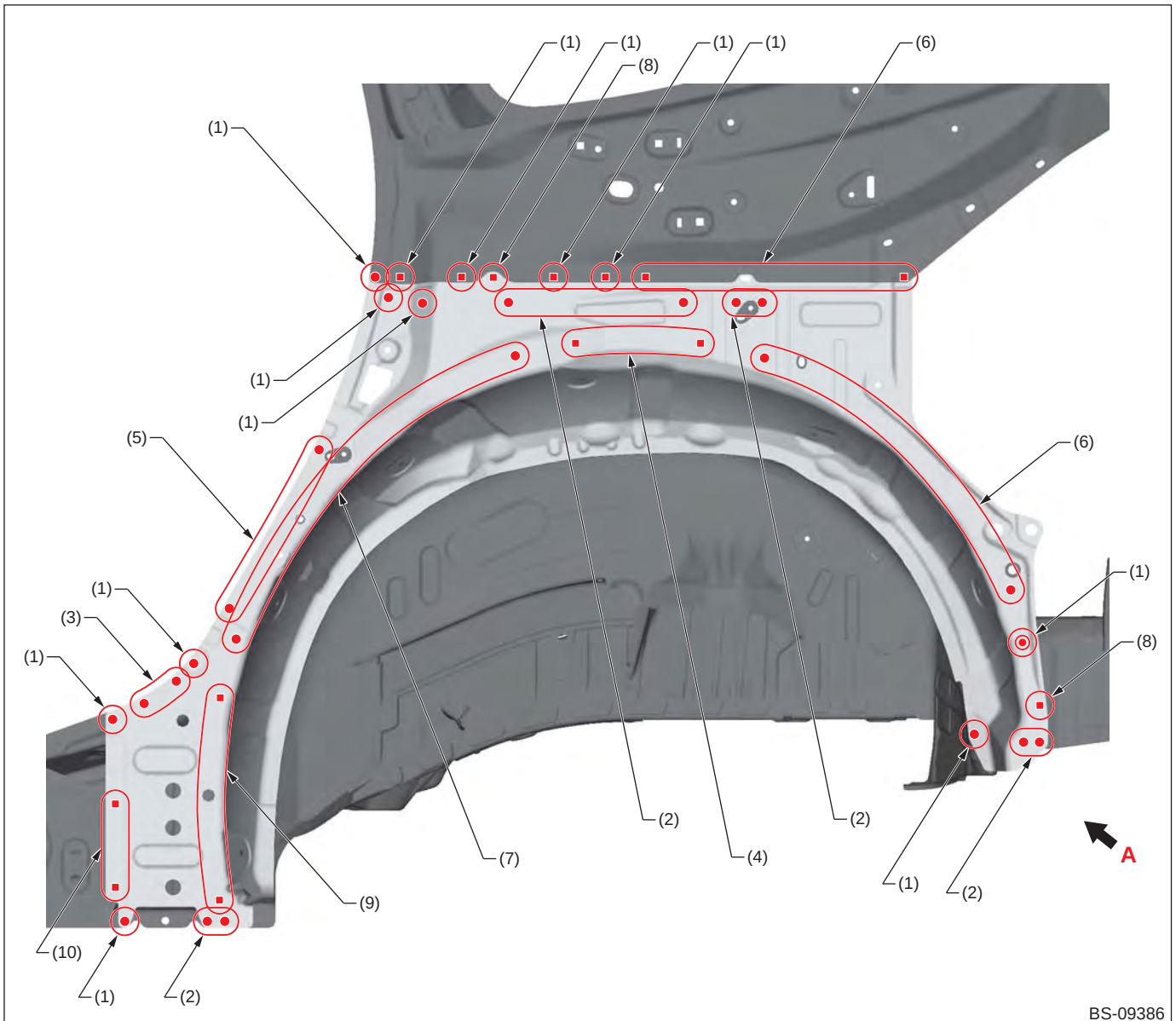
BS-09385

(1) 2 points (outside · 1)

Panel Replacement

B: INSTALLATION

• Overall view

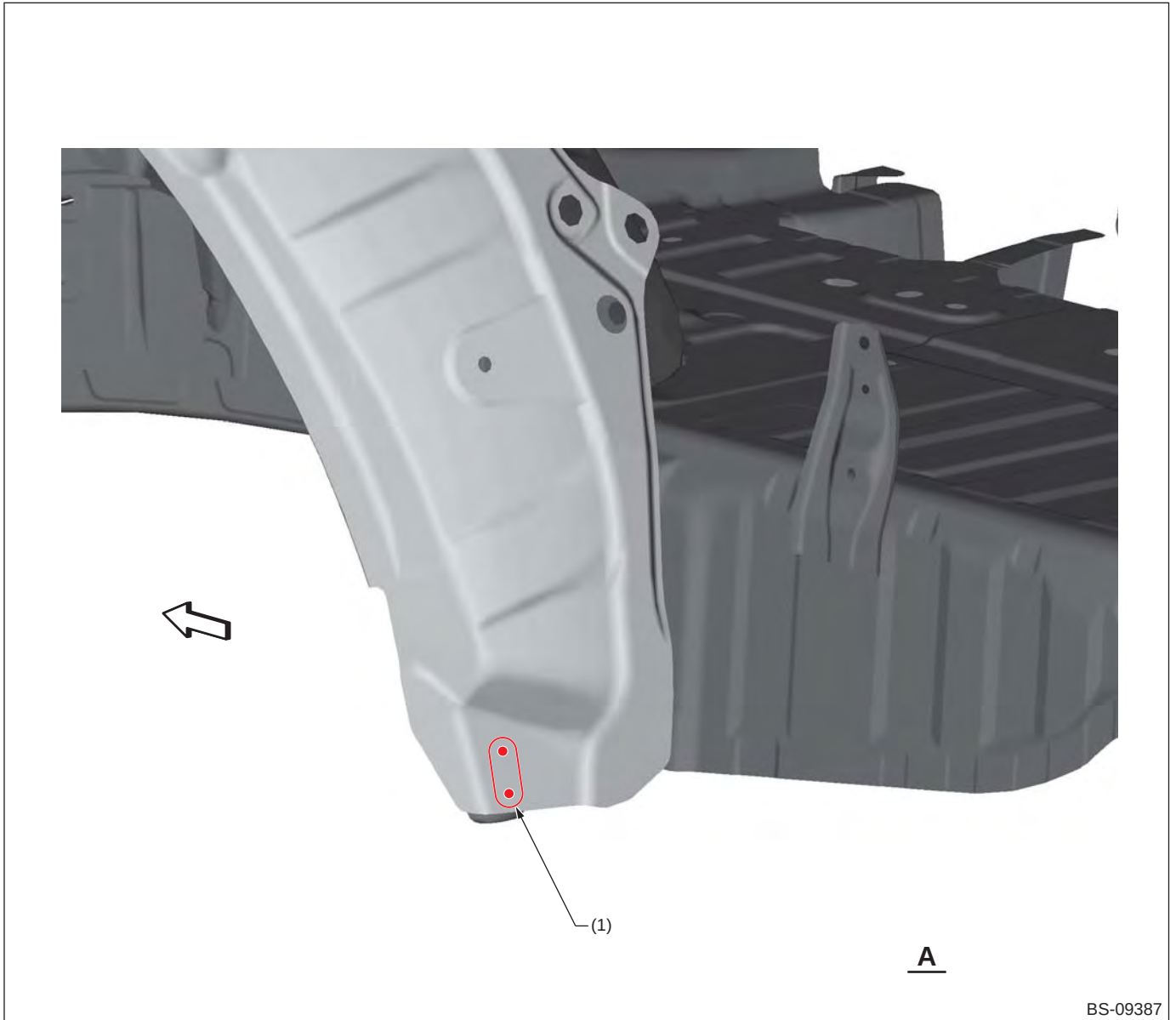


BS-09386

- | | | |
|------------------------|-----------------------|-------------------------|
| (1) 1 point | (5) 5 points | (9) 5 points (service) |
| (2) 2 points | (6) 6 points | (10) 3 points (service) |
| (3) 3 points | (7) 8 points | |
| (4) 4 points (service) | (8) 1 point (service) | |

Panel Replacement

- Views A



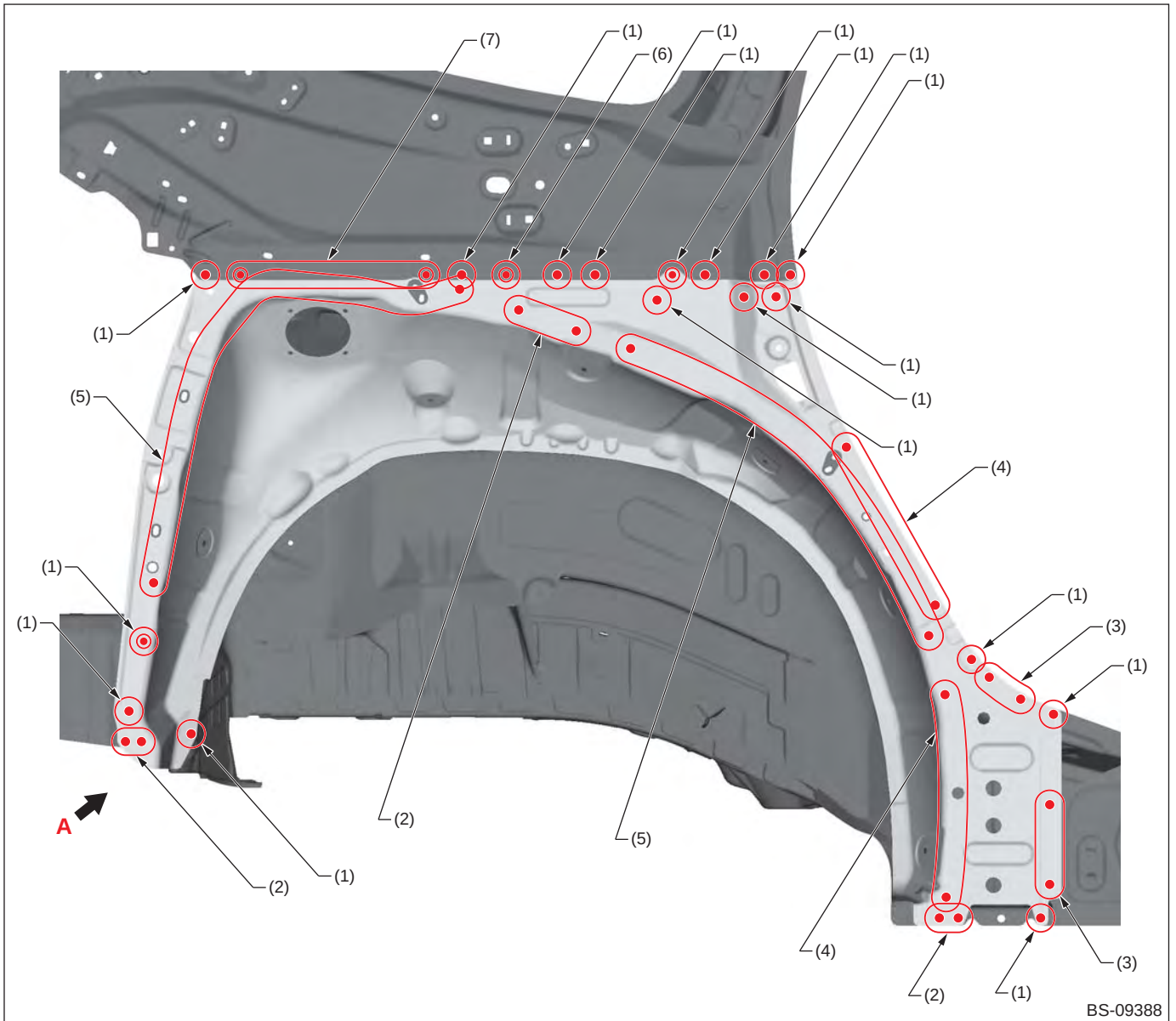
BS-09387

(1) 2 points

8-22. Arch Rear Inner RH (Total replacement)

A: REMOVAL

• Overall view



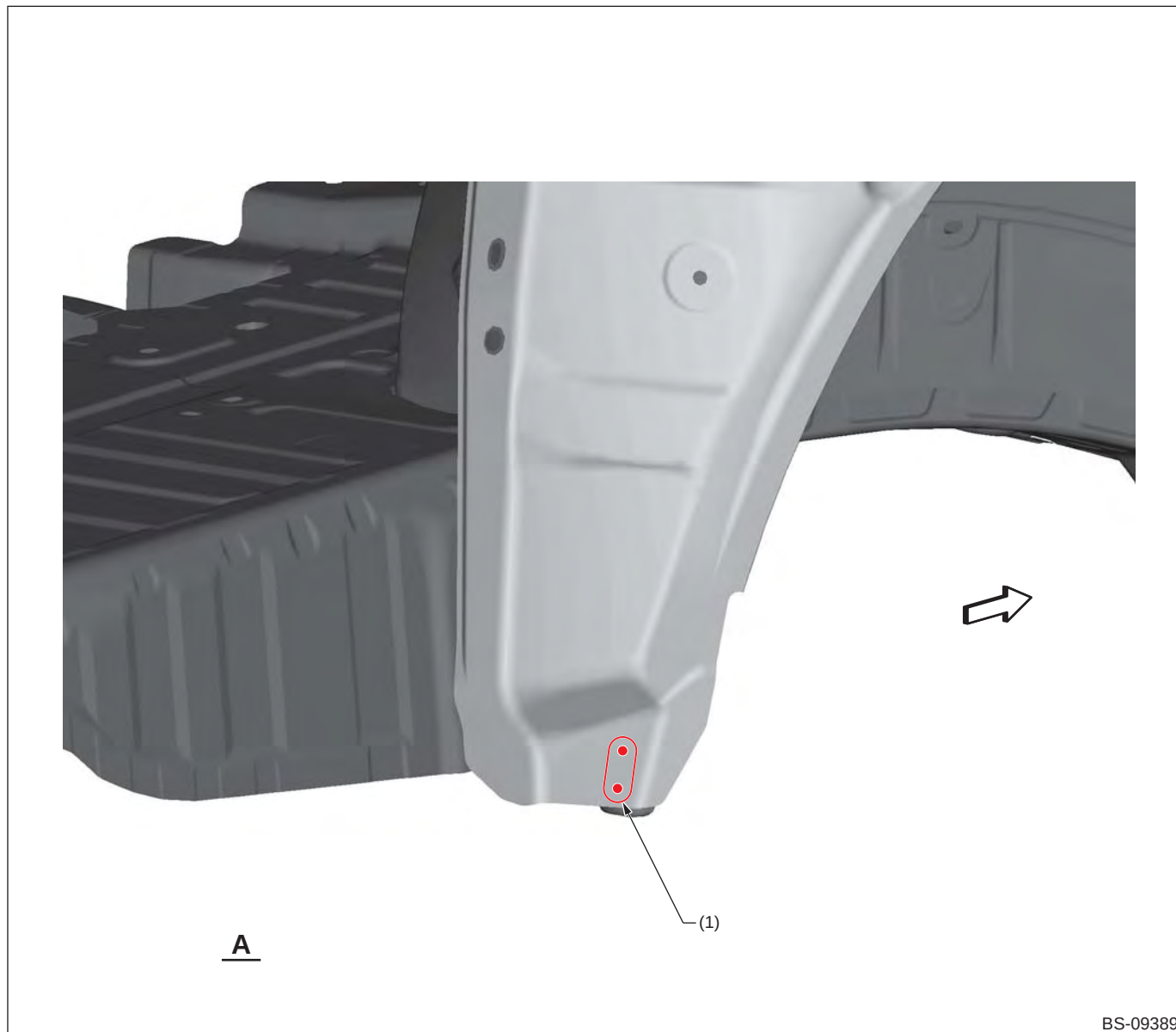
- (1) 1 point (outside · 1)
- (2) 2 points (outside · 1)
- (3) 3 points (outside · 1)

- (4) 5 points (outside · 1)
- (5) 8 points (outside · 1)
- (6) 1 point (outside · 2)

- (7) 5 points (outside · 2)

Panel Replacement

- Views A

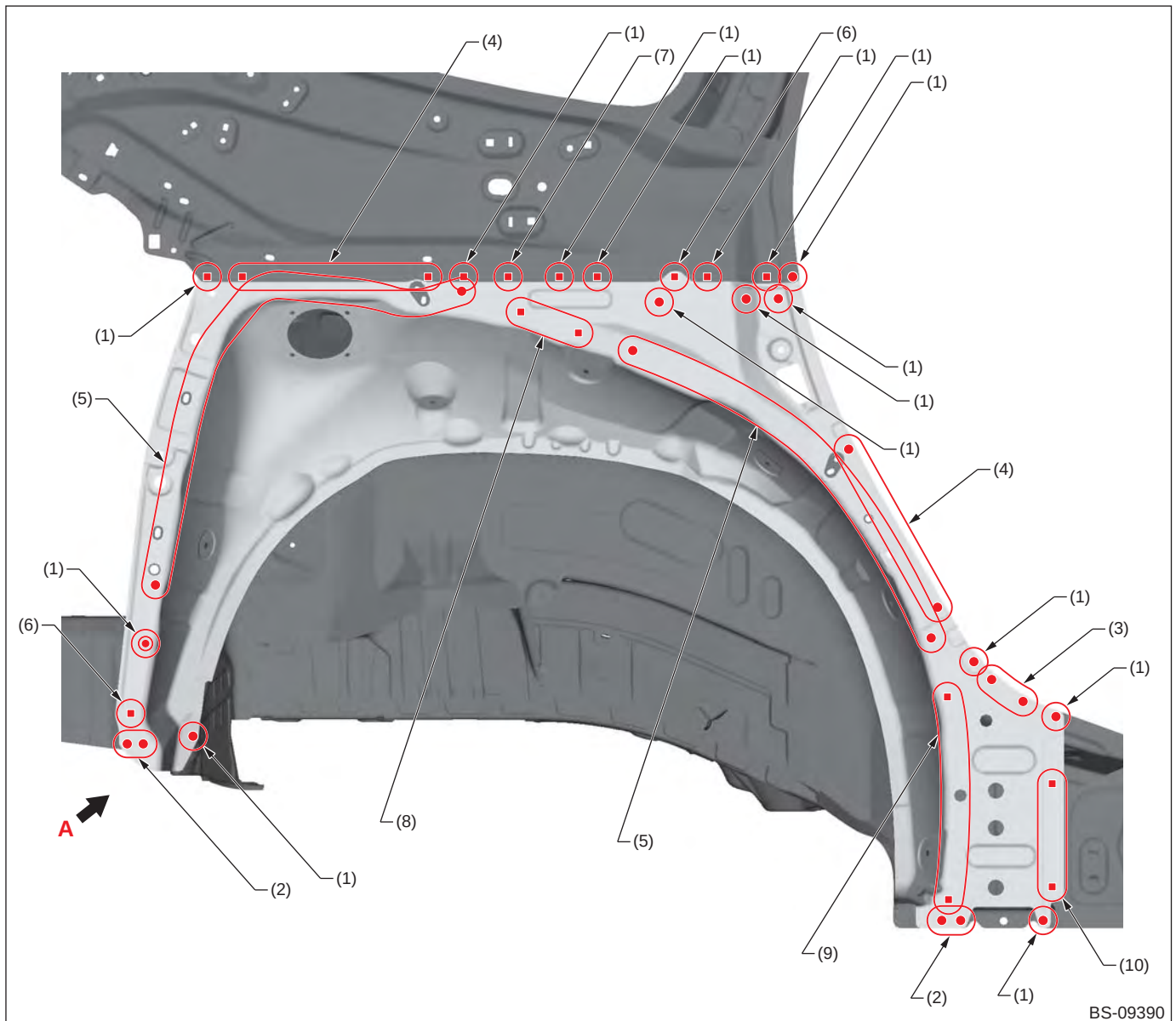


(1) 2 points (outside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



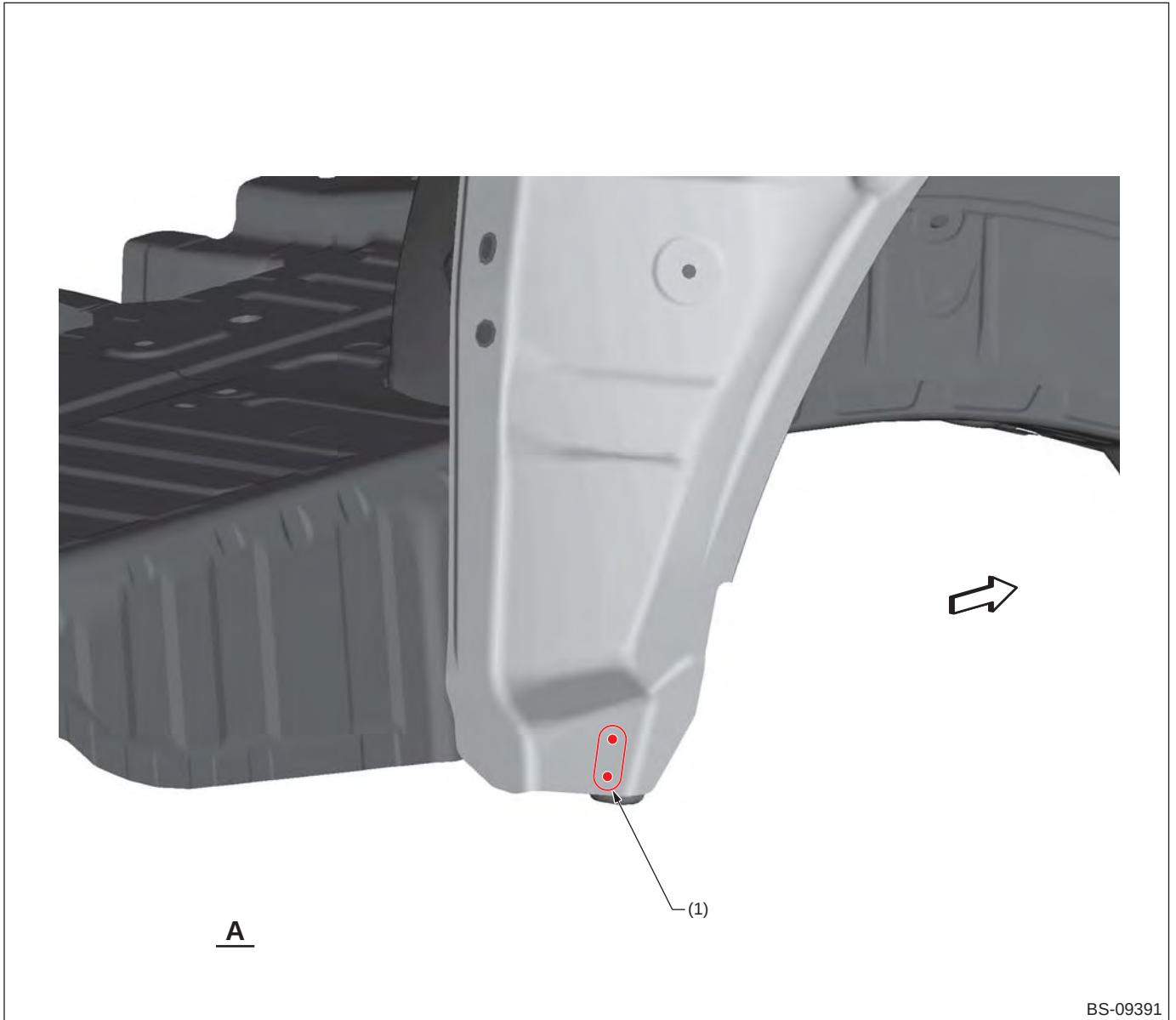
- (1) 1 point
- (2) 2 points
- (3) 3 points
- (4) 5 points

- (5) 8 points
- (6) 1 point (service)
- (7) 1 point (service · matching)
- (8) 2 points (service)

- (9) 5 points (service)
- (10) 3 points (service)

Panel Replacement

- Views A

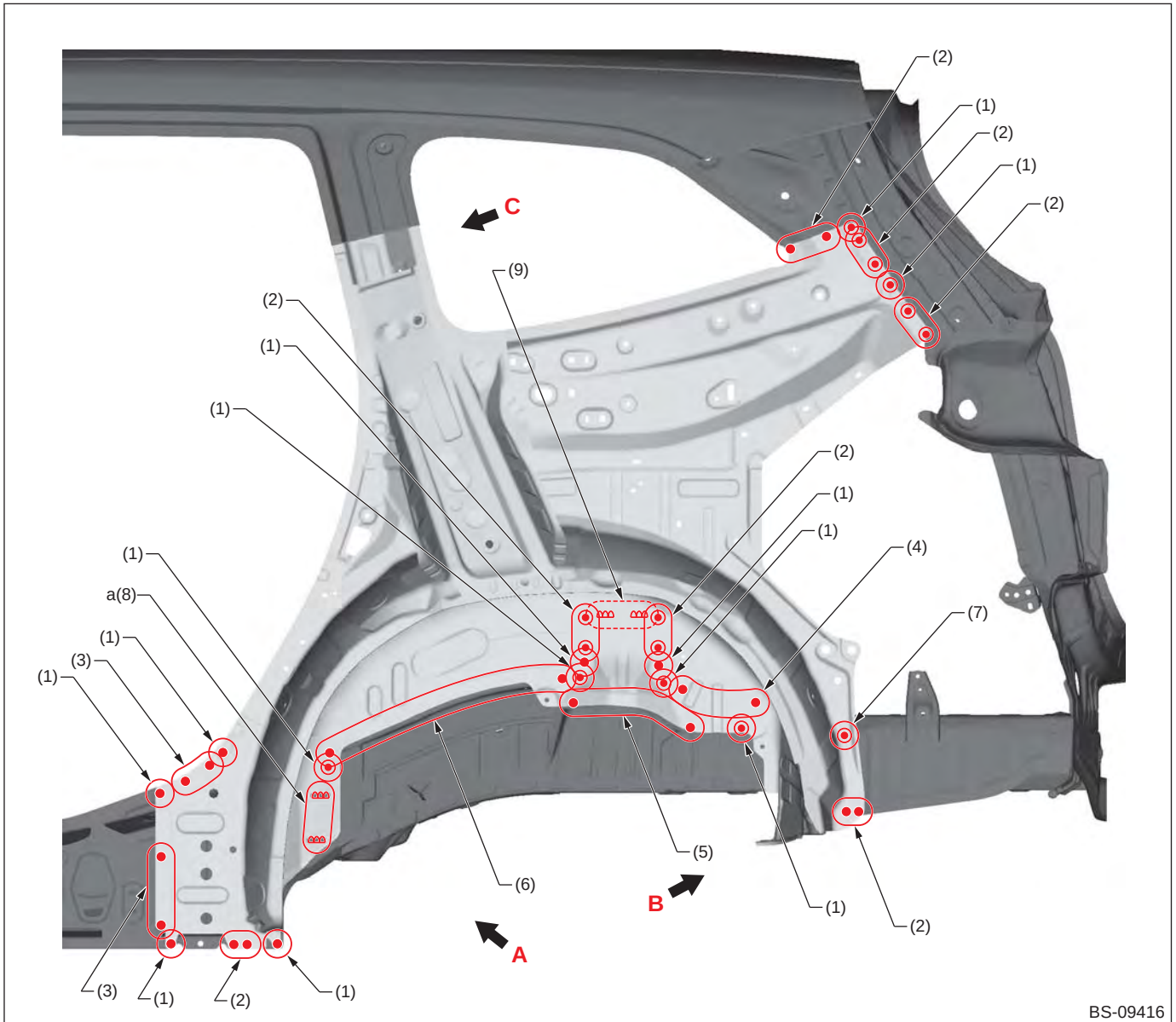


(1) 2 points

8-23. Rear Quarter Inner LH (Partial replacement)

A: REMOVAL

• Overall view



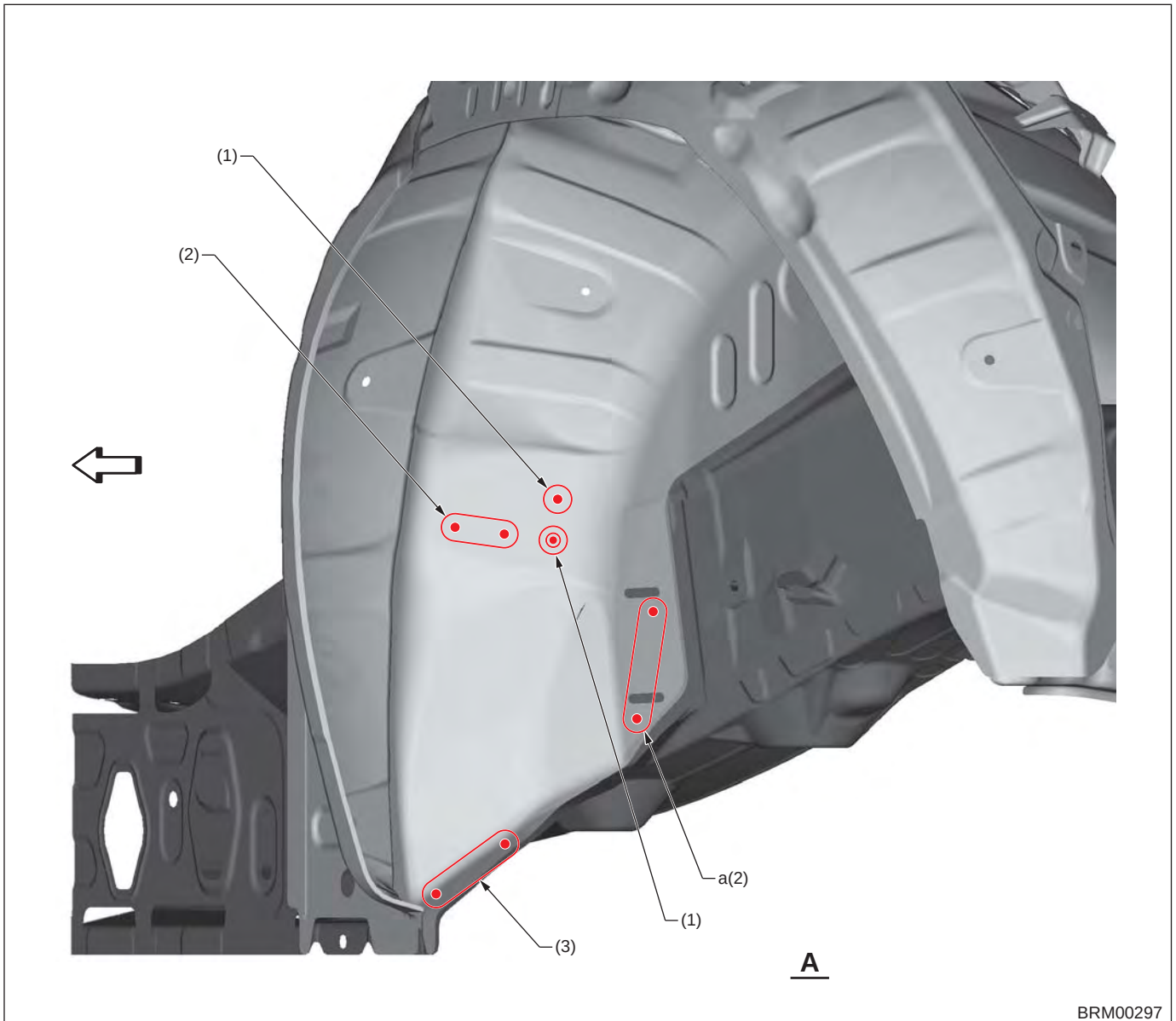
BS-09416

- | | | |
|----------------------------|----------------------------|--|
| (1) 1 point (outside · 1) | (4) 4 points (outside · 1) | (7) 1 point (outside · 2) |
| (2) 2 points (outside · 1) | (5) 6 points (outside · 1) | (8) 2 points (outside · 1 belt sander) |
| (3) 3 points (outside · 1) | (6) 9 points (outside · 1) | (9) 2 points (inside · 1 belt sander) |

Note: Welding points in part "a" vary depending on each vehicle model (spot or arc welding).

Panel Replacement

• Views A



(1) 1 point (outside · 1)

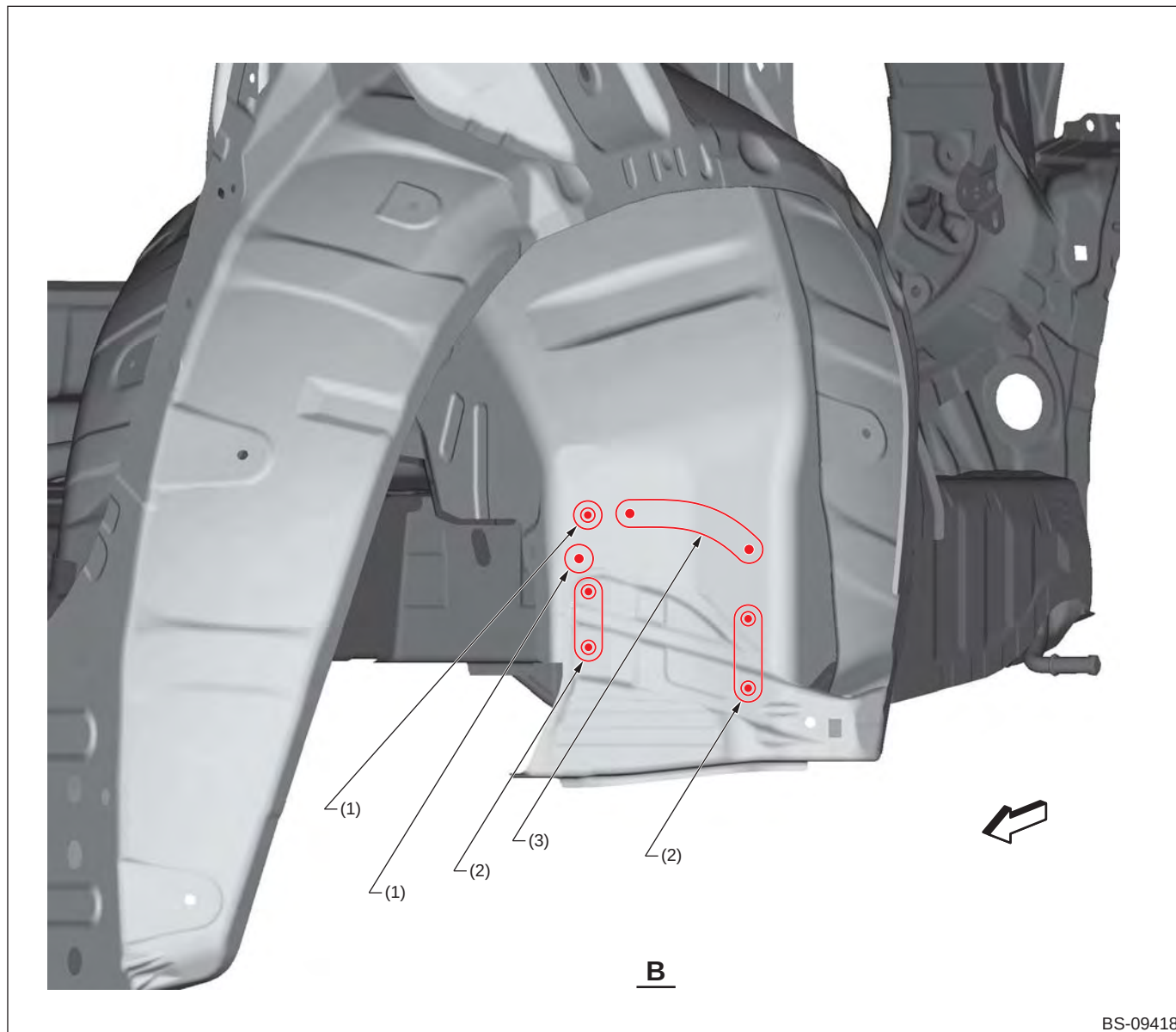
(2) 2 points (outside · 1)

(3) 3 points (outside · 1)

Note: Welding points in part "a" vary depending on each vehicle model (spot or arc welding).

Panel Replacement

• Views B



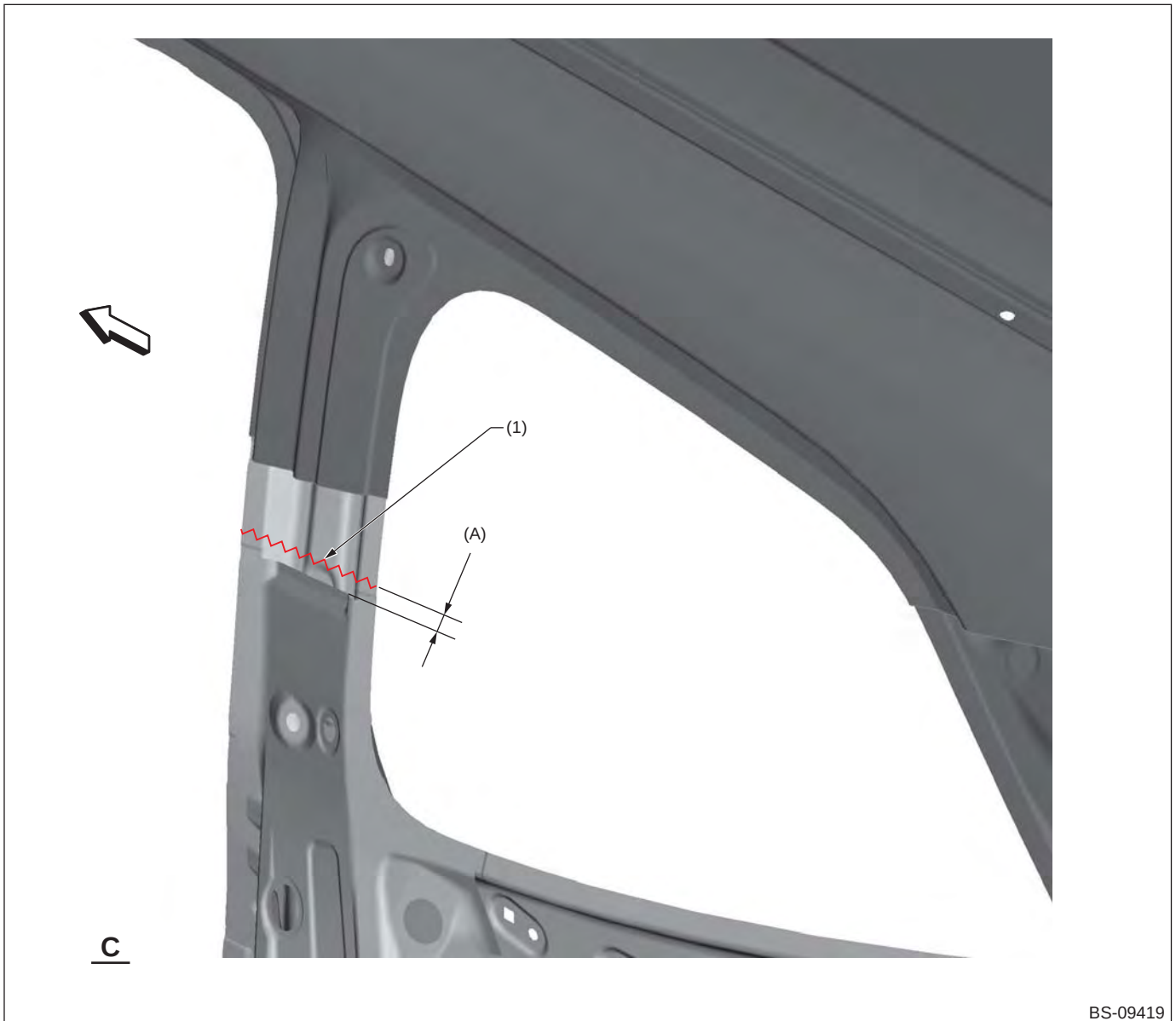
(1) 1 point (outside · 1)

(2) 2 points (outside · 2)

(3) 4 points (outside · 1)

Panel Replacement

• Views C



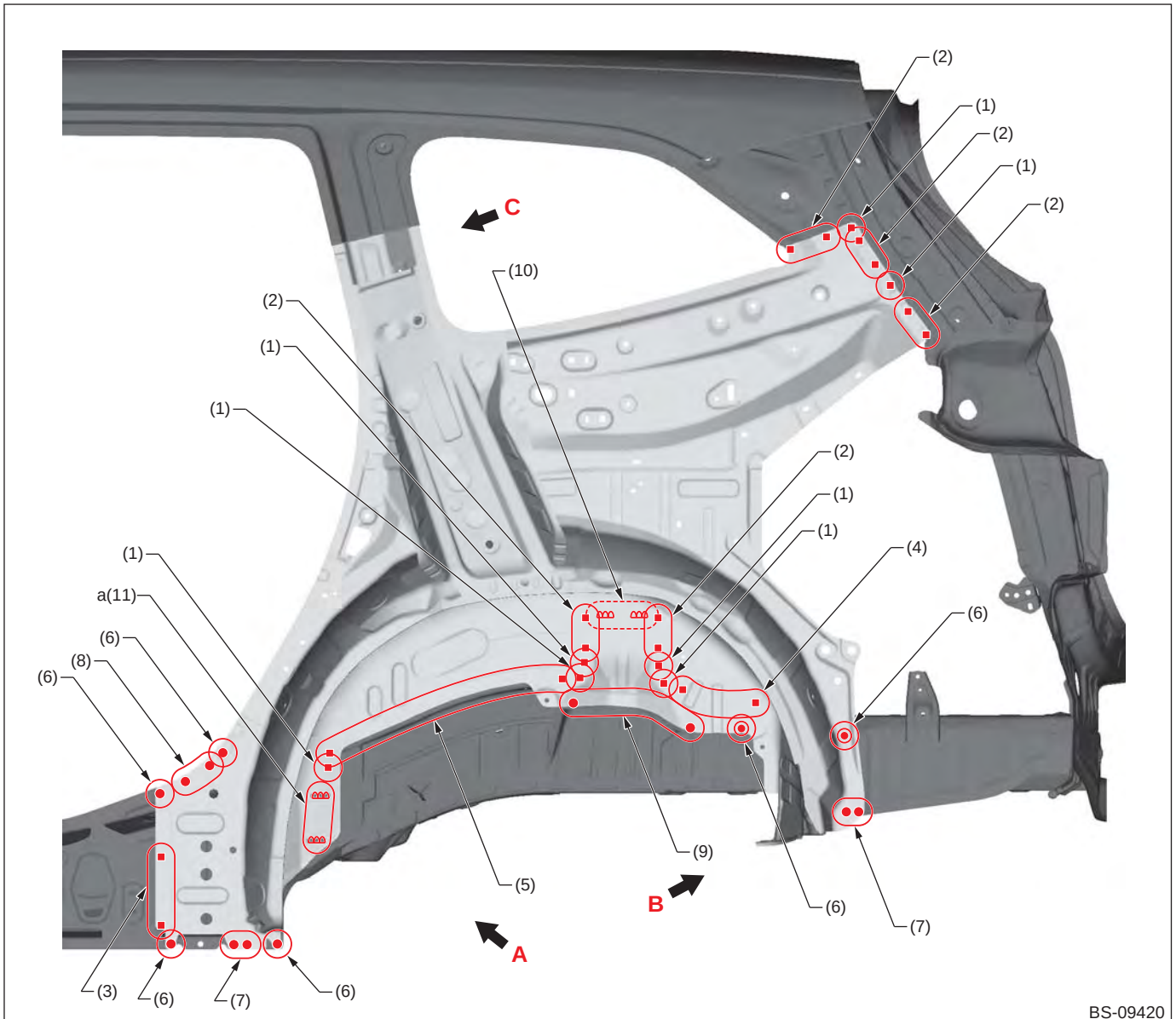
(A) 10 mm [0.39 in]

(1) Cut position

Panel Replacement

B: INSTALLATION

• Overall view

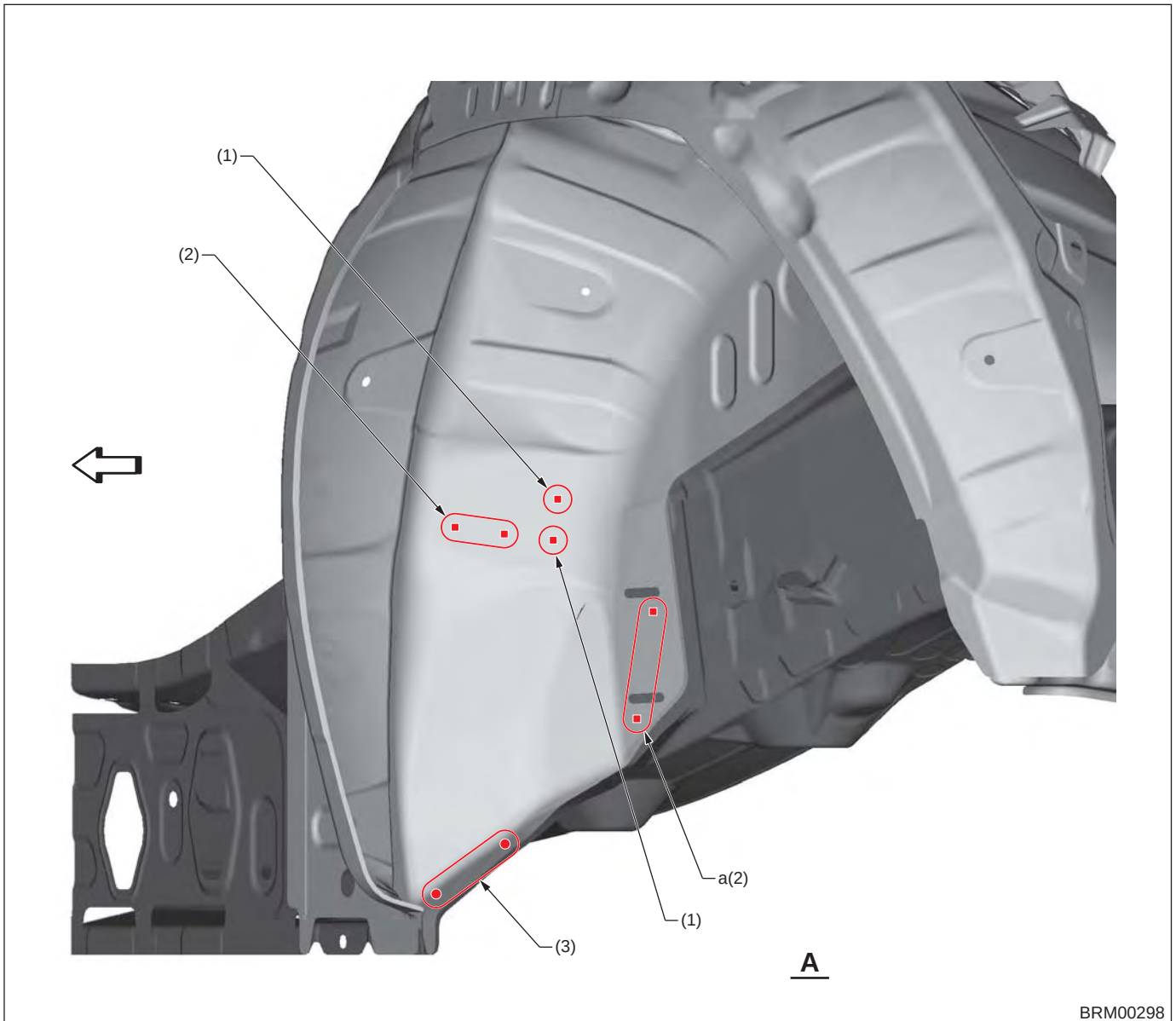


- | | | |
|------------------------|------------------------|---|
| (1) 1 point (service) | (5) 9 points (service) | (9) 6 points |
| (2) 2 points (service) | (6) 1 point | (10) 2 points (Continuous welding)
(5 mm [0.20 in]) |
| (3) 3 points (service) | (7) 2 points | (11) 2 points (Continuous welding)
(10 mm [0.39 in]) |
| (4) 4 points (service) | (8) 3 points | |

Note: Welding points in part "a" vary depending on each vehicle model (spot or arc welding).

Panel Replacement

• Views A



BRM00298

(1) 1 point (service)

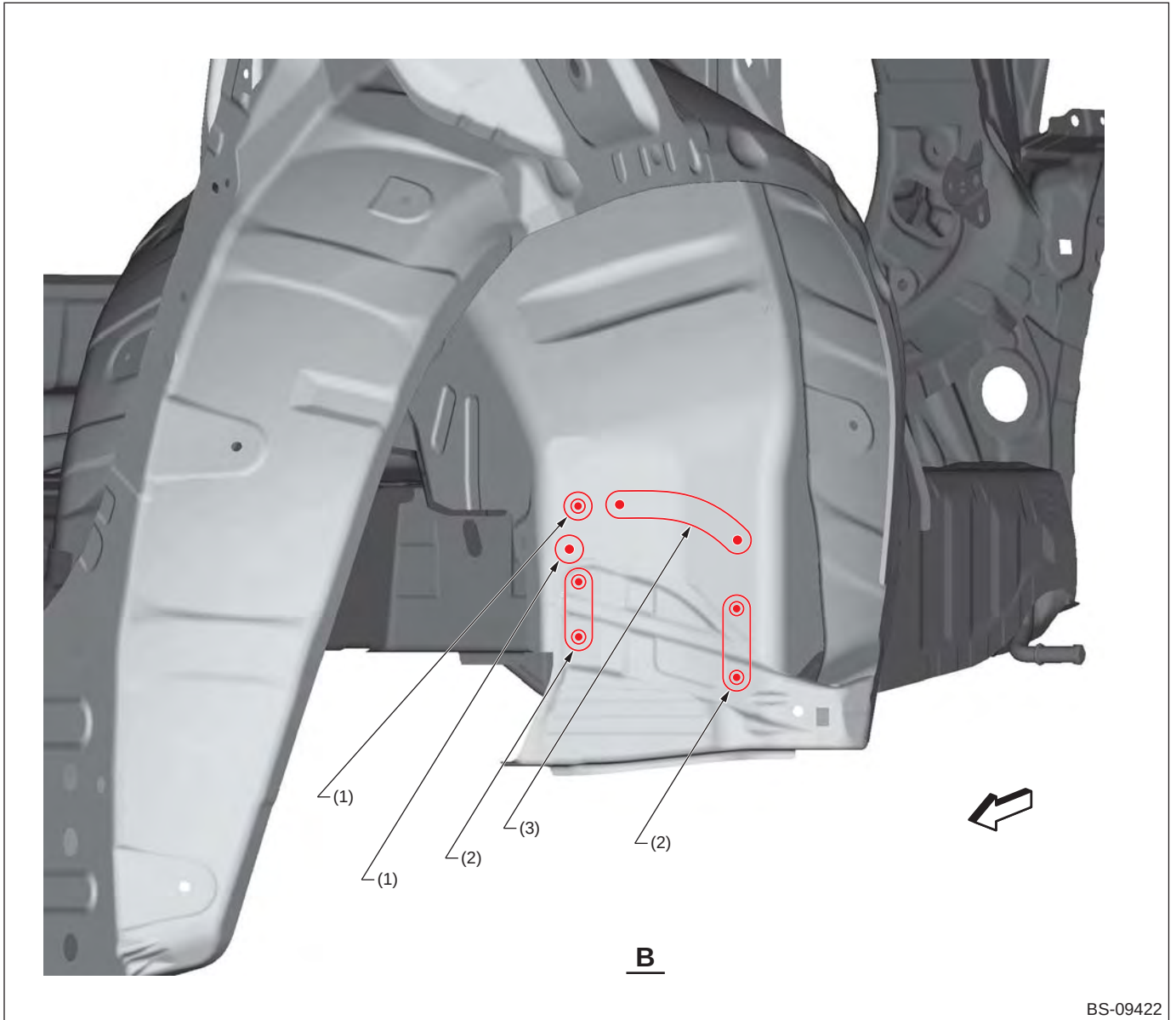
(2) 2 points (service)

(3) 3 points

Note: Welding points in part "a" vary depending on each vehicle model (spot or arc welding).

Panel Replacement

• Views B



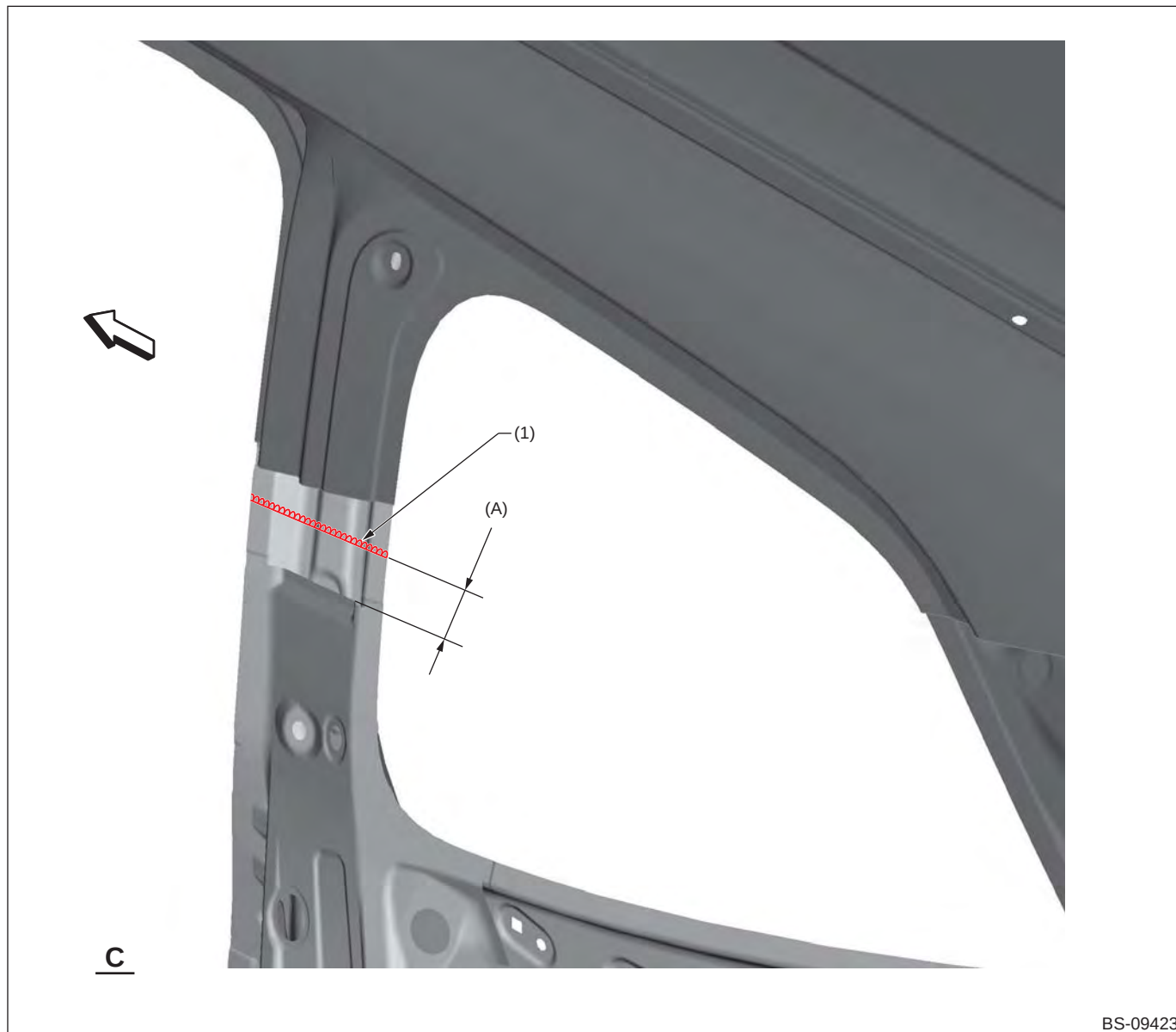
(1) 1 point

(2) 2 points

(3) 4 points

Panel Replacement

• Views C



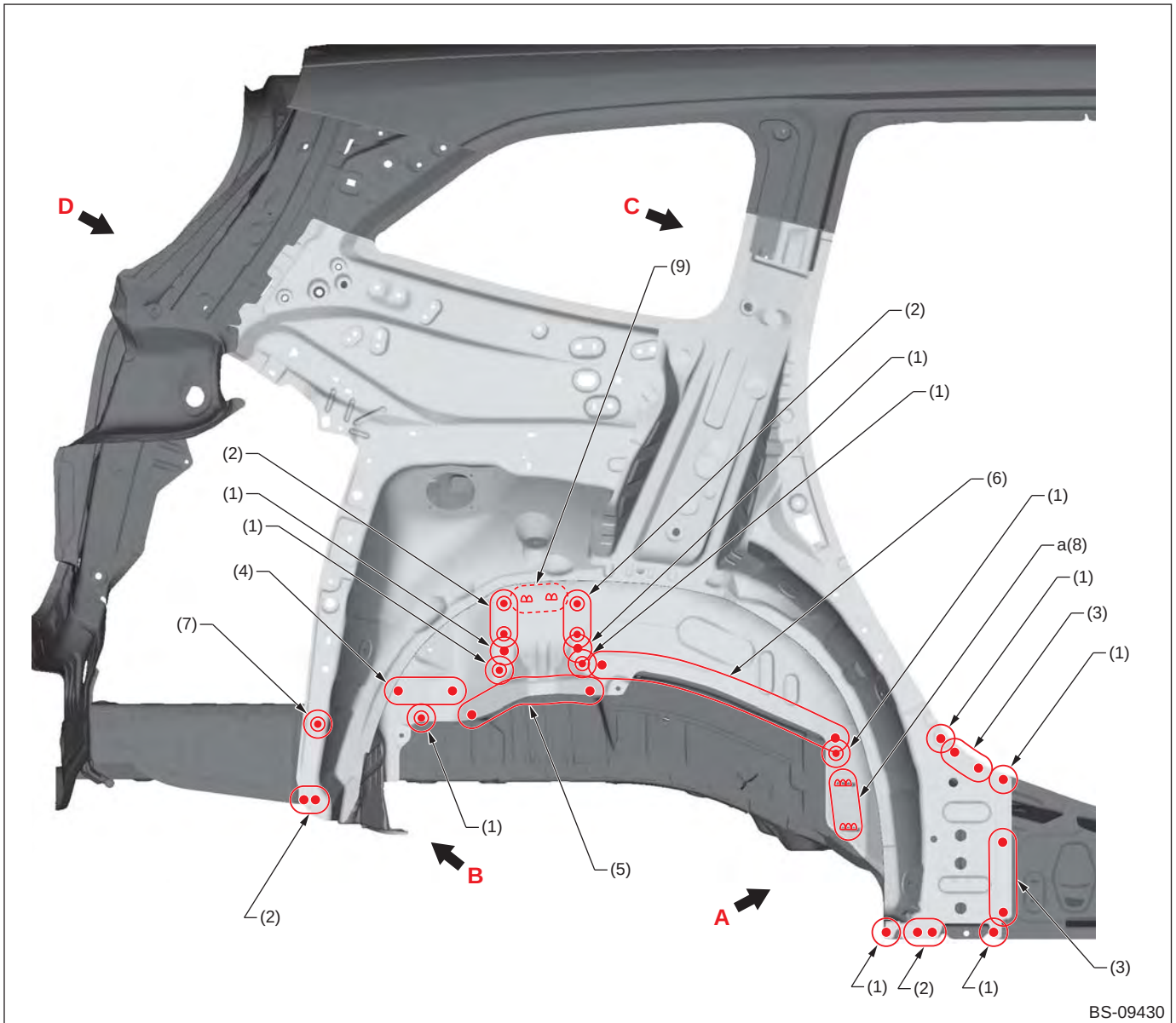
(A) 30 mm [1.18 in]

(1) 1 point (Continuous welding)

8-24. Rear Quarter Inner RH (Partial replacement)

A: REMOVAL

• Overall view



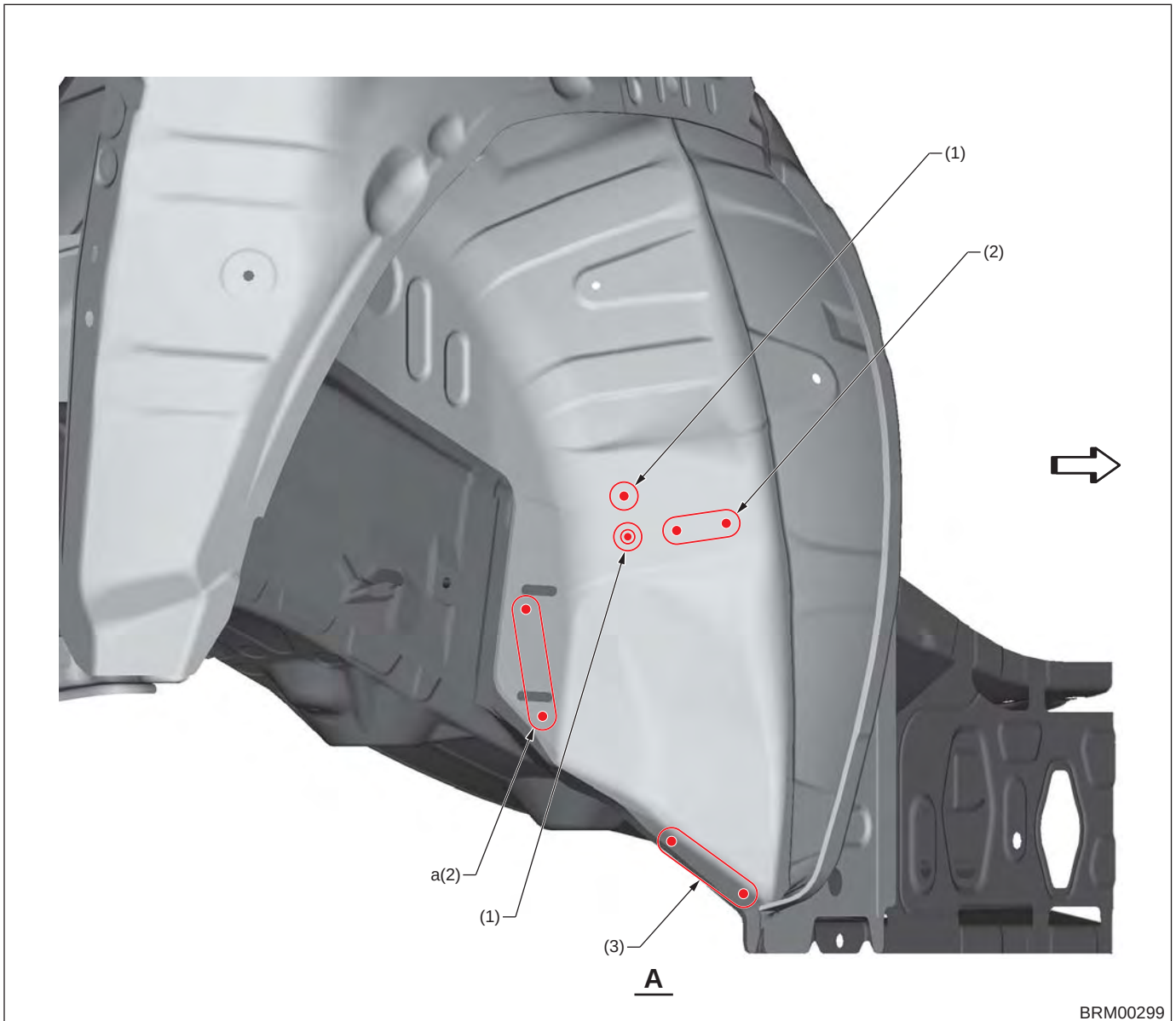
BS-09430

- | | | |
|----------------------------|----------------------------|--|
| (1) 1 point (outside · 1) | (4) 4 points (outside · 1) | (7) 1 point (outside · 2) |
| (2) 2 points (outside · 1) | (5) 6 points (outside · 1) | (8) 2 points (outside · 1 belt sander) |
| (3) 3 points (outside · 1) | (6) 9 points (outside · 1) | (9) 2 points (inside · 1 belt sander) |

Note: Welding points in part "a" vary depending on each vehicle model (spot or arc welding).

Panel Replacement

• Views A



(1) 1 point (outside · 1)

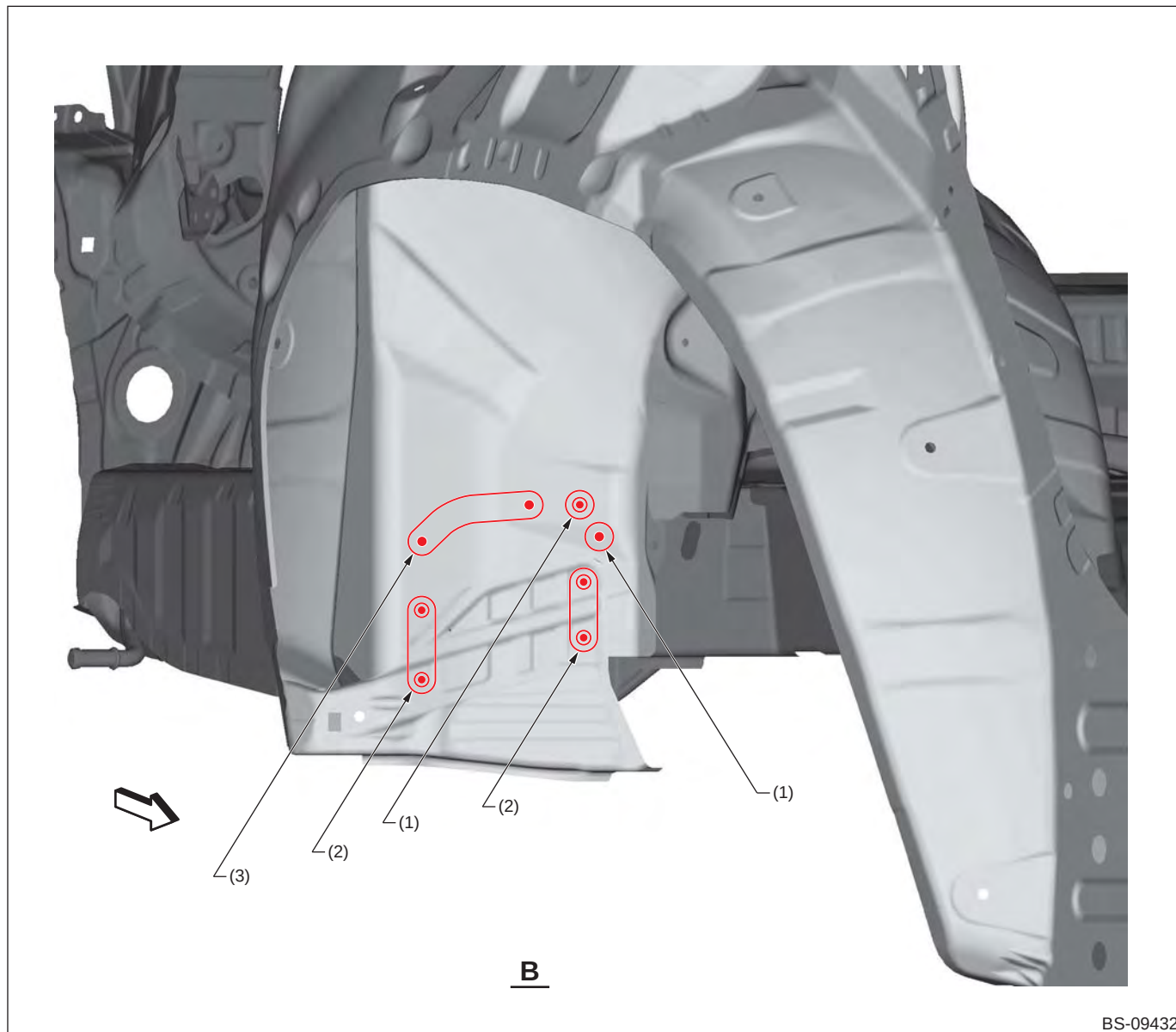
(2) 2 points (outside · 1)

(3) 3 points (outside · 1)

Note: Welding points in part "a" vary depending on each vehicle model (spot or arc welding).

Panel Replacement

• Views B



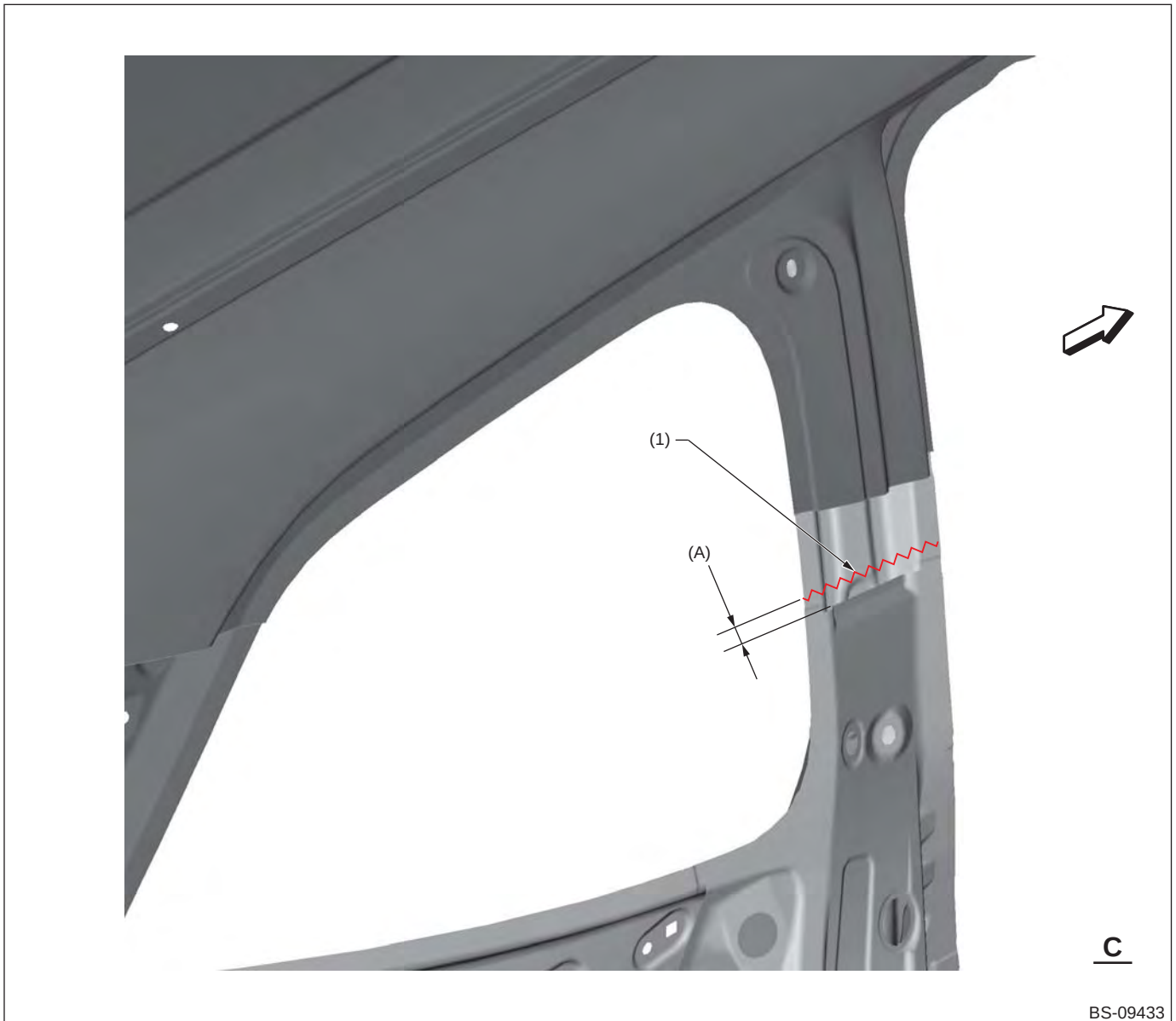
(1) 1 point (outside · 1)

(2) 2 points (outside · 1)

(3) 3 points (outside · 1)

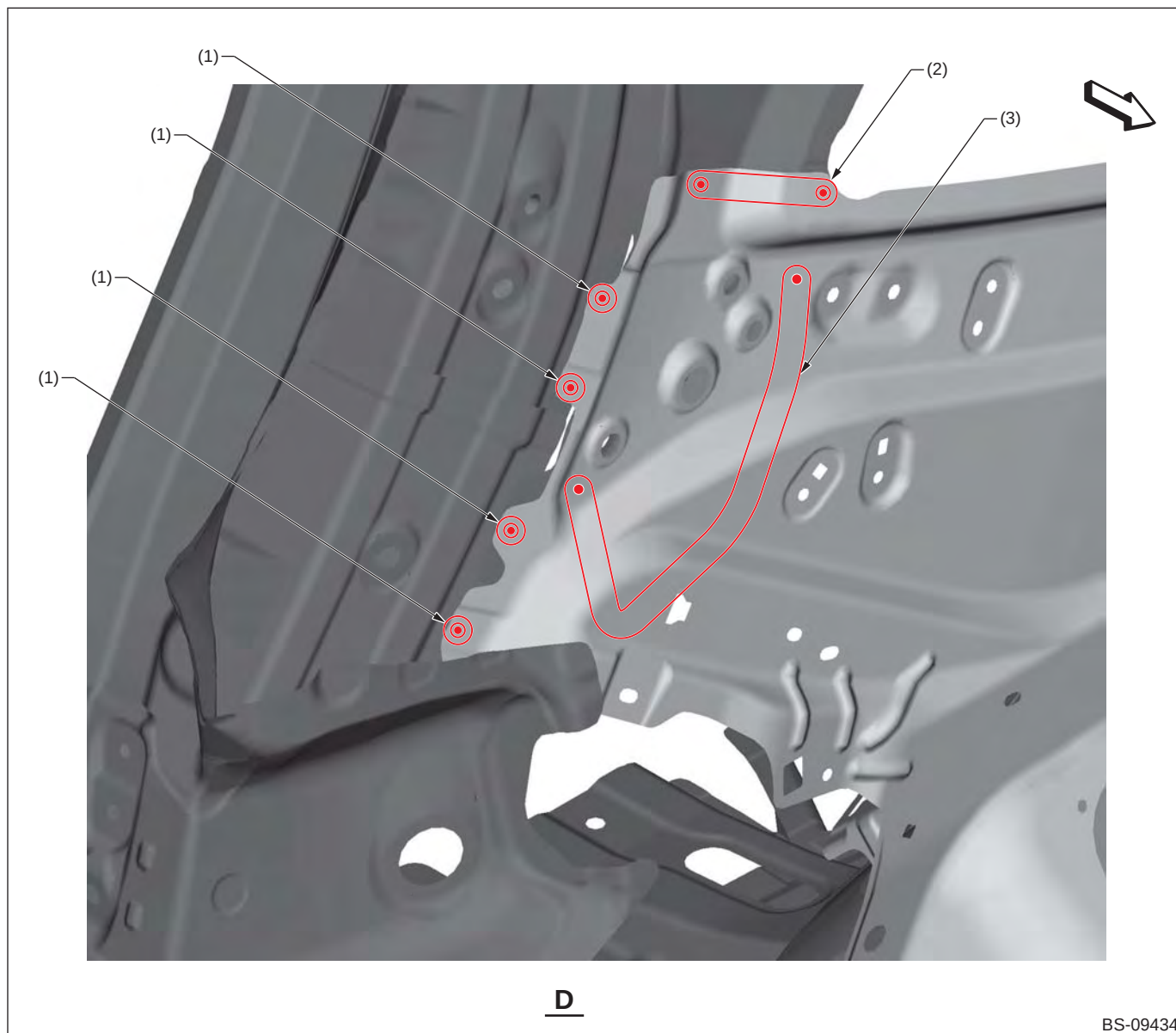
Panel Replacement

• Views C



Panel Replacement

• Views D



(1) 1 point (inside · 2)

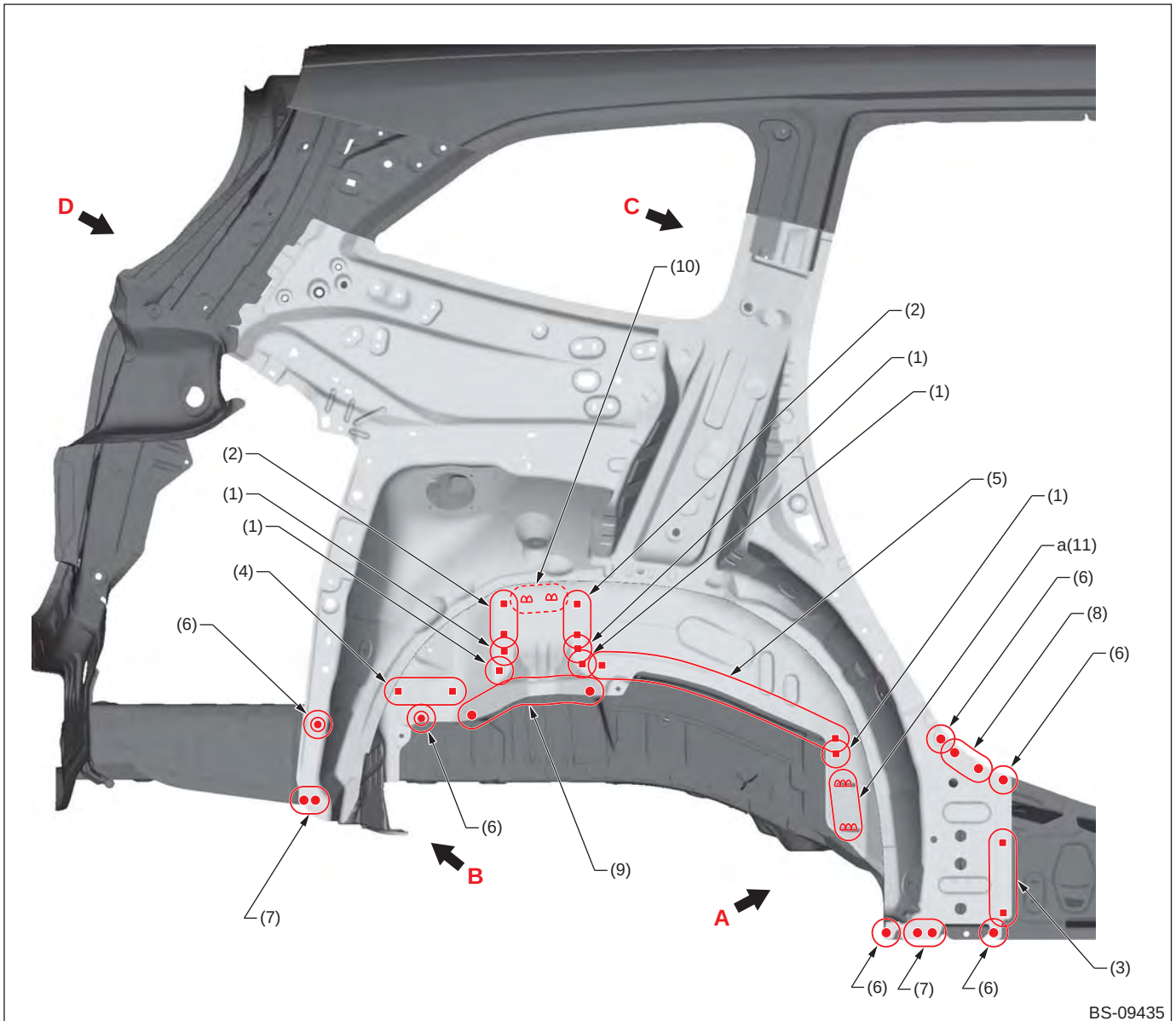
(2) 2 points (inside · 2)

(3) 5 points (inside · 1)

Panel Replacement

B: INSTALLATION

• Overall view

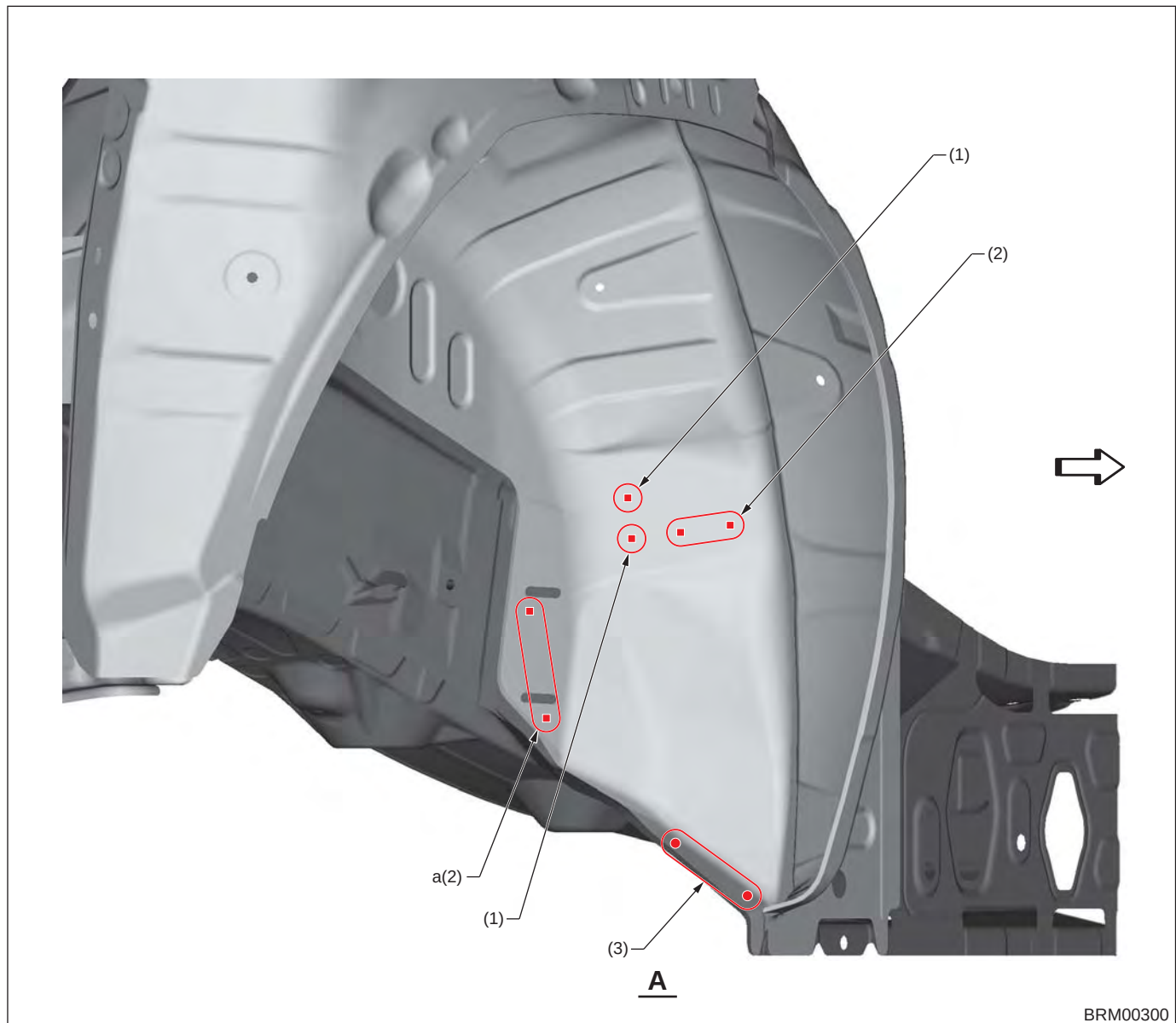


- | | | |
|------------------------|------------------------|--|
| (1) 1 point (service) | (5) 9 points (service) | (9) 6 points |
| (2) 2 points (service) | (6) 1 point | (10) 2 points (Continuous welding) (5 mm [0.20 in]) |
| (3) 3 points (service) | (7) 2 points | (11) 2 points (Continuous welding) (10 mm [0.39 in]) |
| (4) 4 points (service) | (8) 3 points | |

Note: Welding points in part "a" vary depending on each vehicle model (spot or arc welding).

Panel Replacement

• Views A



(1) 1 point (service)

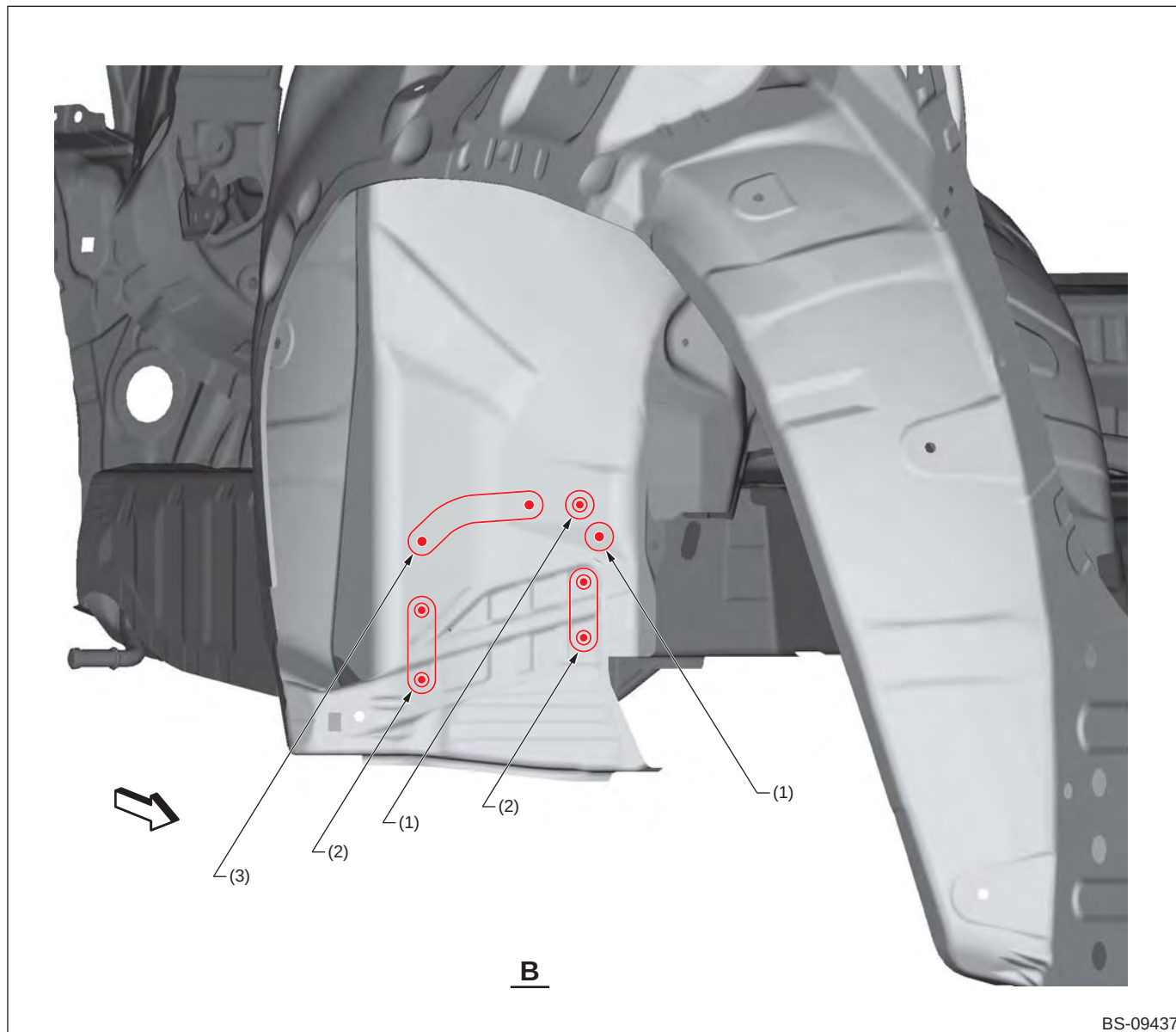
(2) 2 points (service)

(3) 3 points

Note: Welding points in part "a" vary depending on each vehicle model (spot or arc welding).

Panel Replacement

• Views B



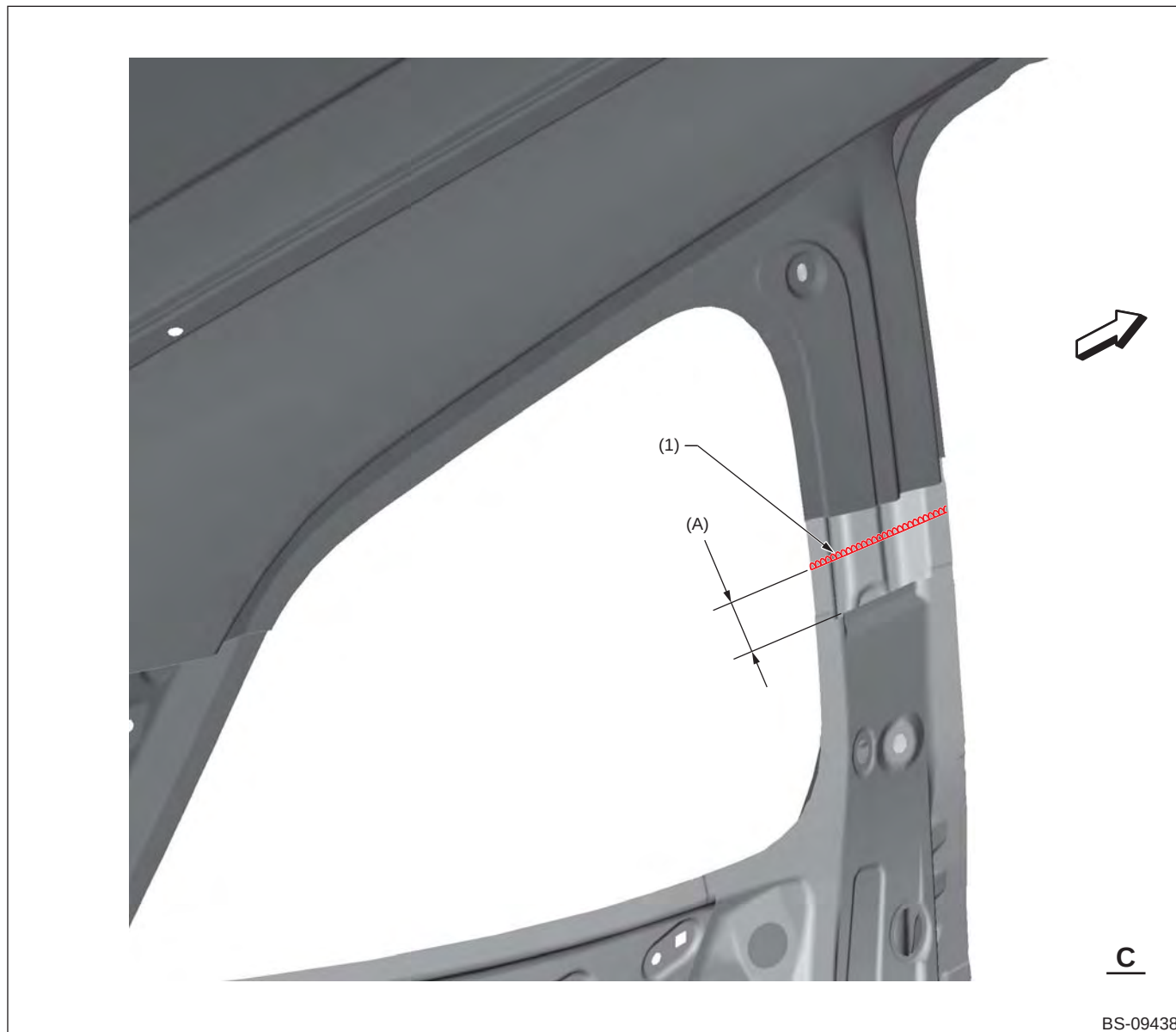
(1) 1 point

(2) 2 points

(3) 3 points

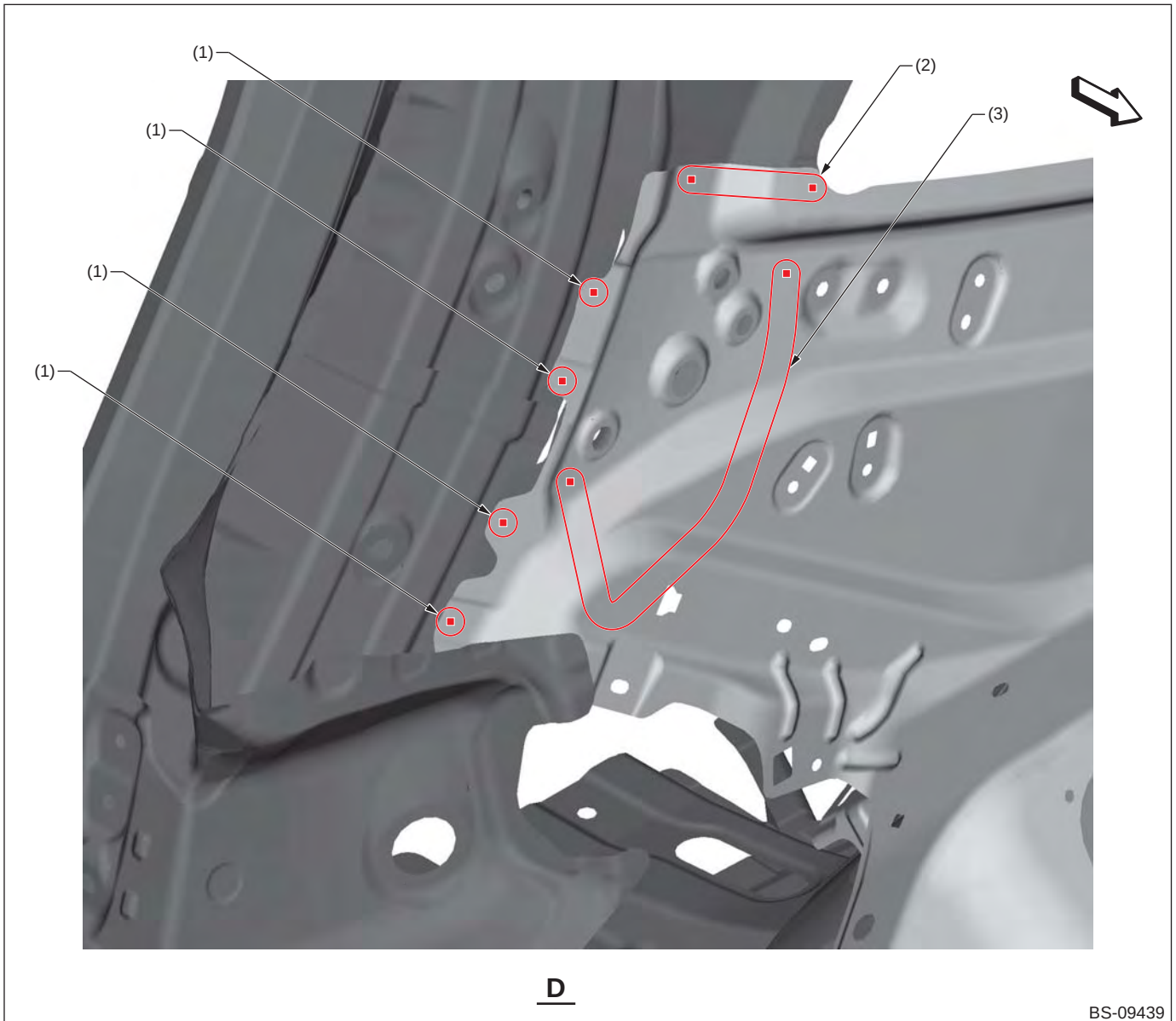
Panel Replacement

• Views C



Panel Replacement

• Views D



BS-09439

(1) 1 point

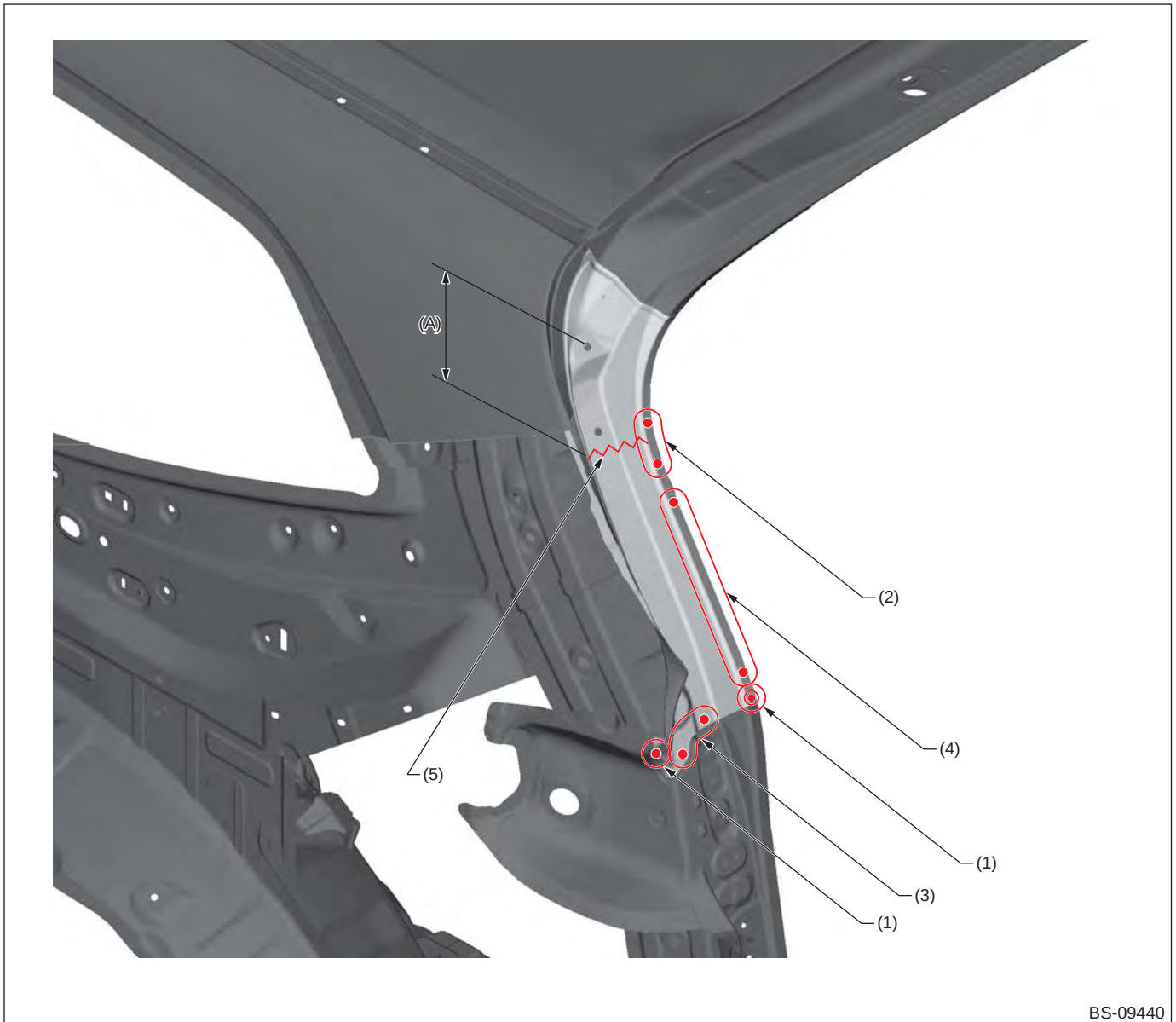
(2) 2 points

(3) 5 points

8-25. D Pillar Extension (Partial replacement)

A: REMOVAL

• Overall view



(A) 110 mm [4.33 in]

(1) 1 point (outside · 1)
(2) 2 points (outside · 1)

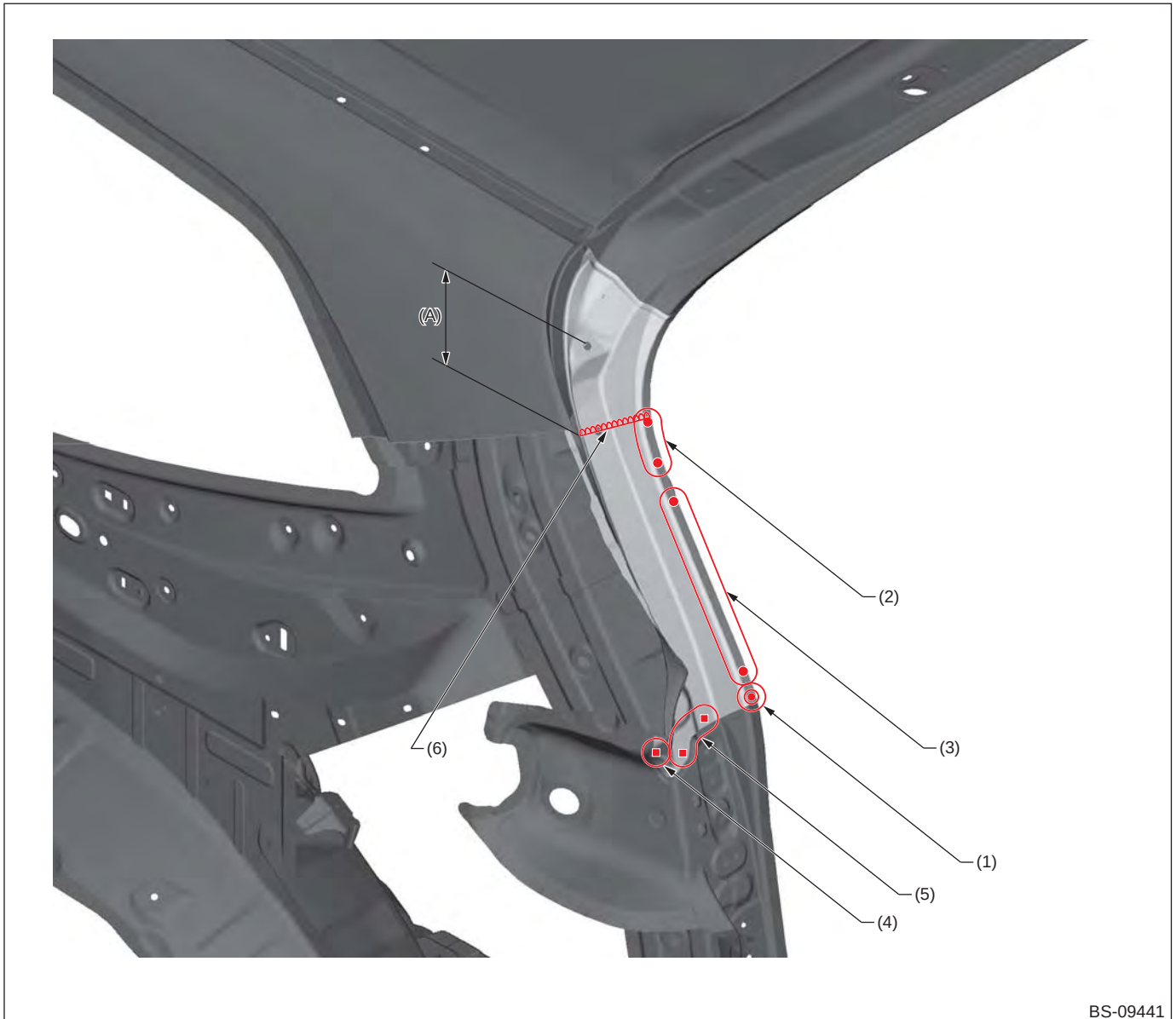
(3) 3 points (outside · 1)
(4) 5 points (outside · 1)

(5) Cut position

Panel Replacement

B: INSTALLATION

• Overall view



(A) 90 mm [3.54 in]

(1) 1 point
(2) 2 points

(3) 5 points
(4) 1 point (service)

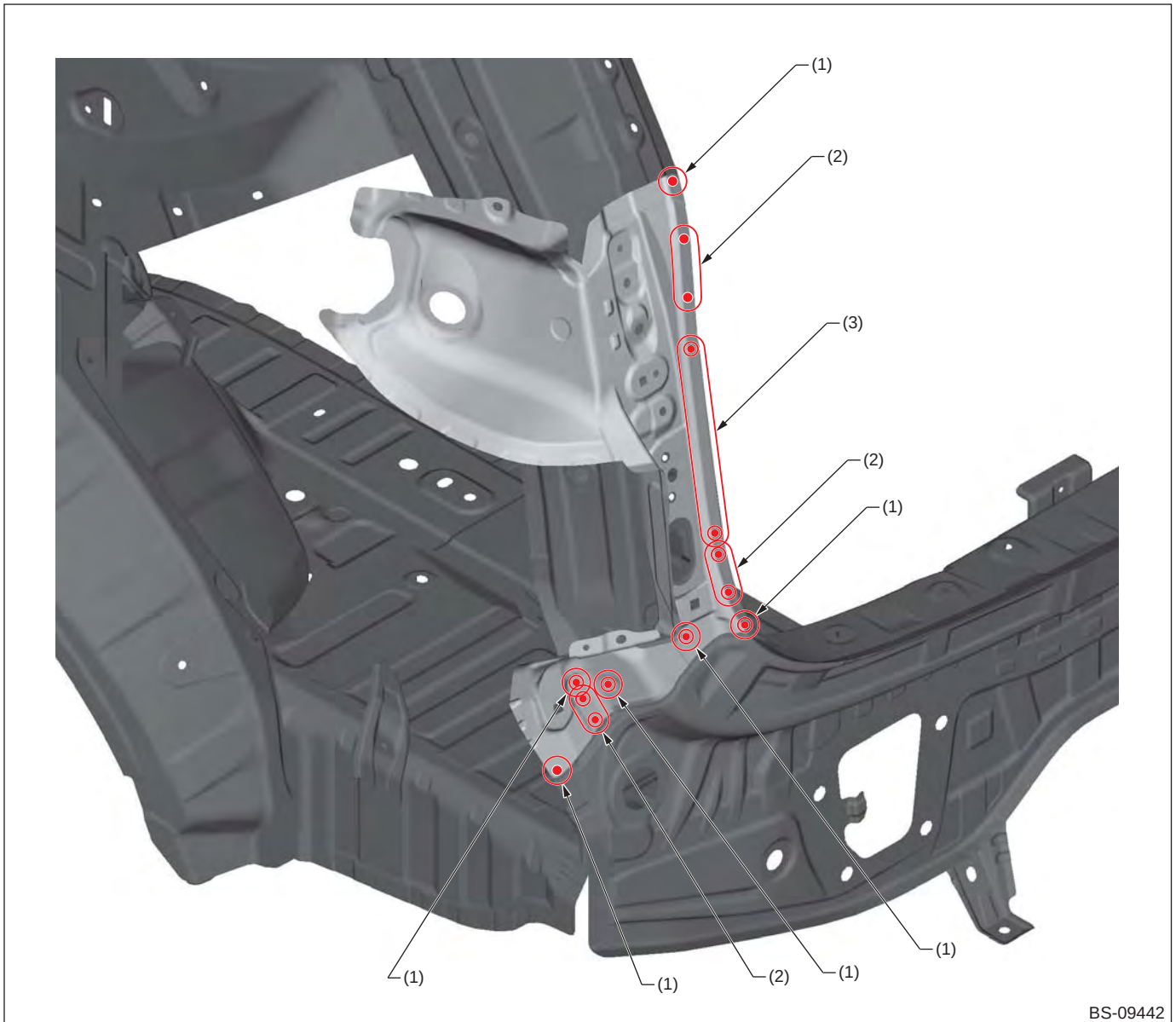
(5) 3 points (service)
(6) 1 point (Continuous welding)

Panel Replacement

8-26. Rear Quarter End Panel (Total replacement)

A: REMOVAL

• Overall view



BS-09442

(1) 1 point (outside · 1)

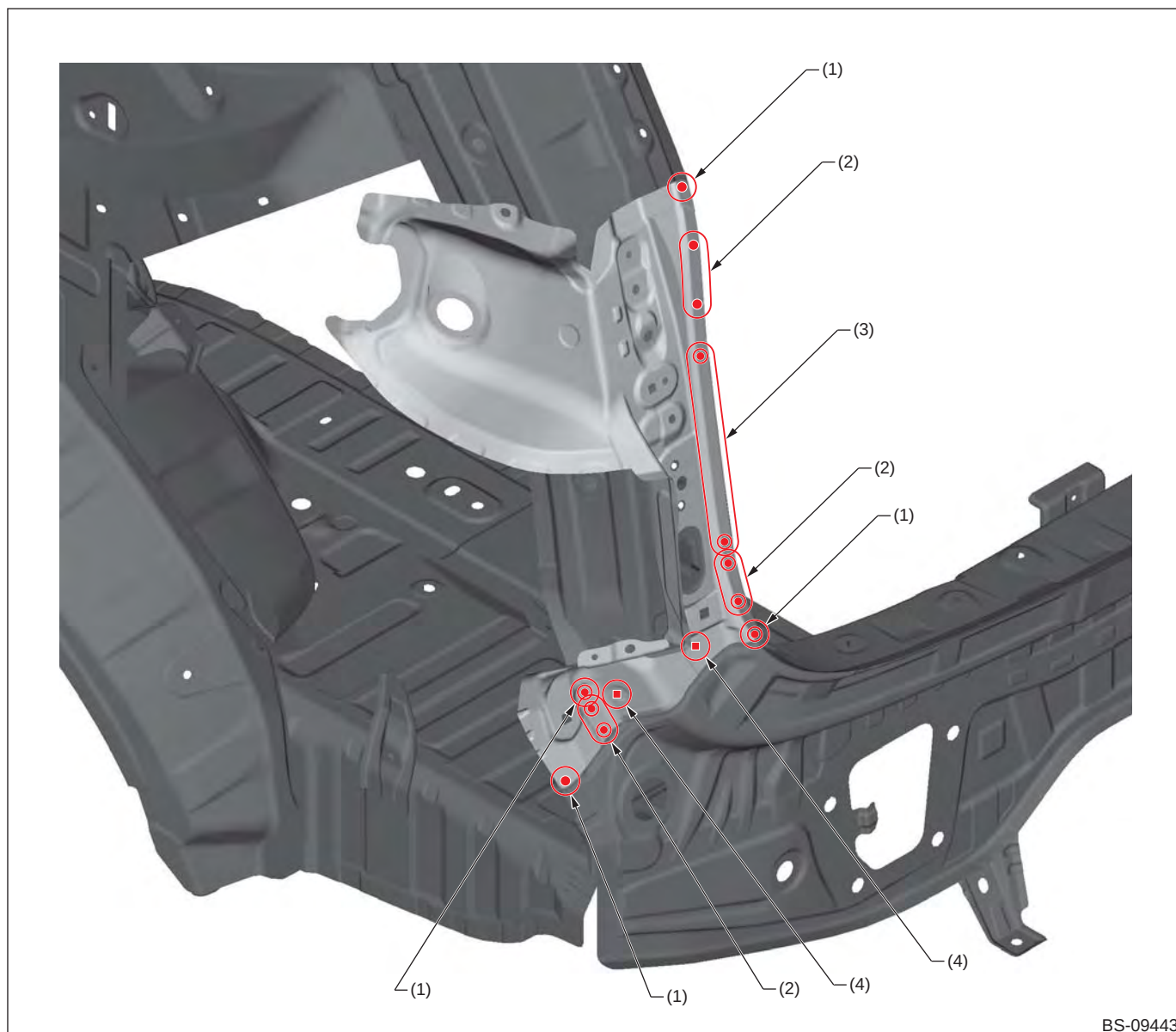
(2) 2 points (outside · 1)

(3) 5 points (outside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



(1) 1 point
(2) 2 points

(3) 5 points

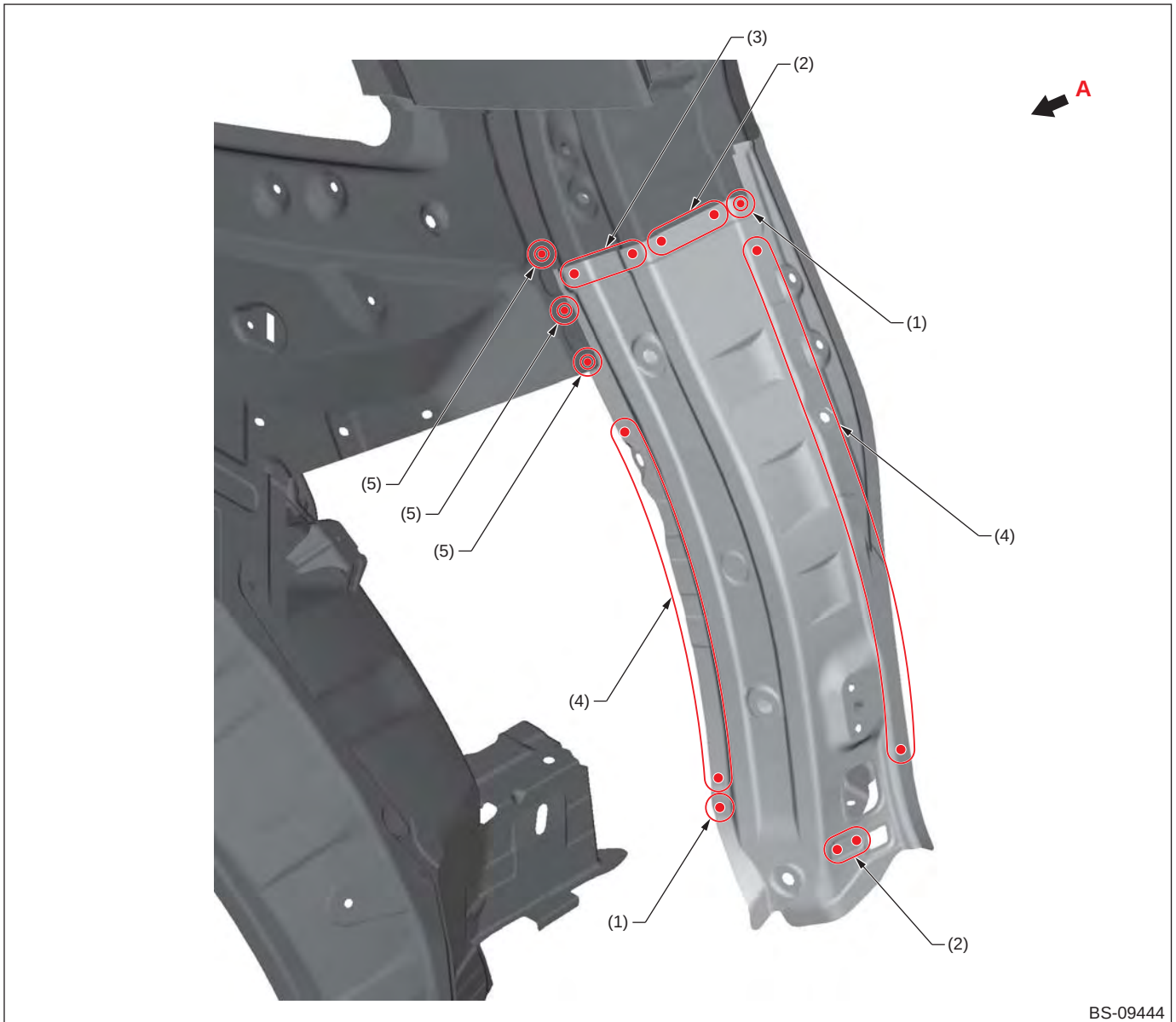
(4) 1 point (service)

Panel Replacement

8-27. D Pillar Reinforcement LH (Partial replacement)

A: REMOVAL

• Overall view



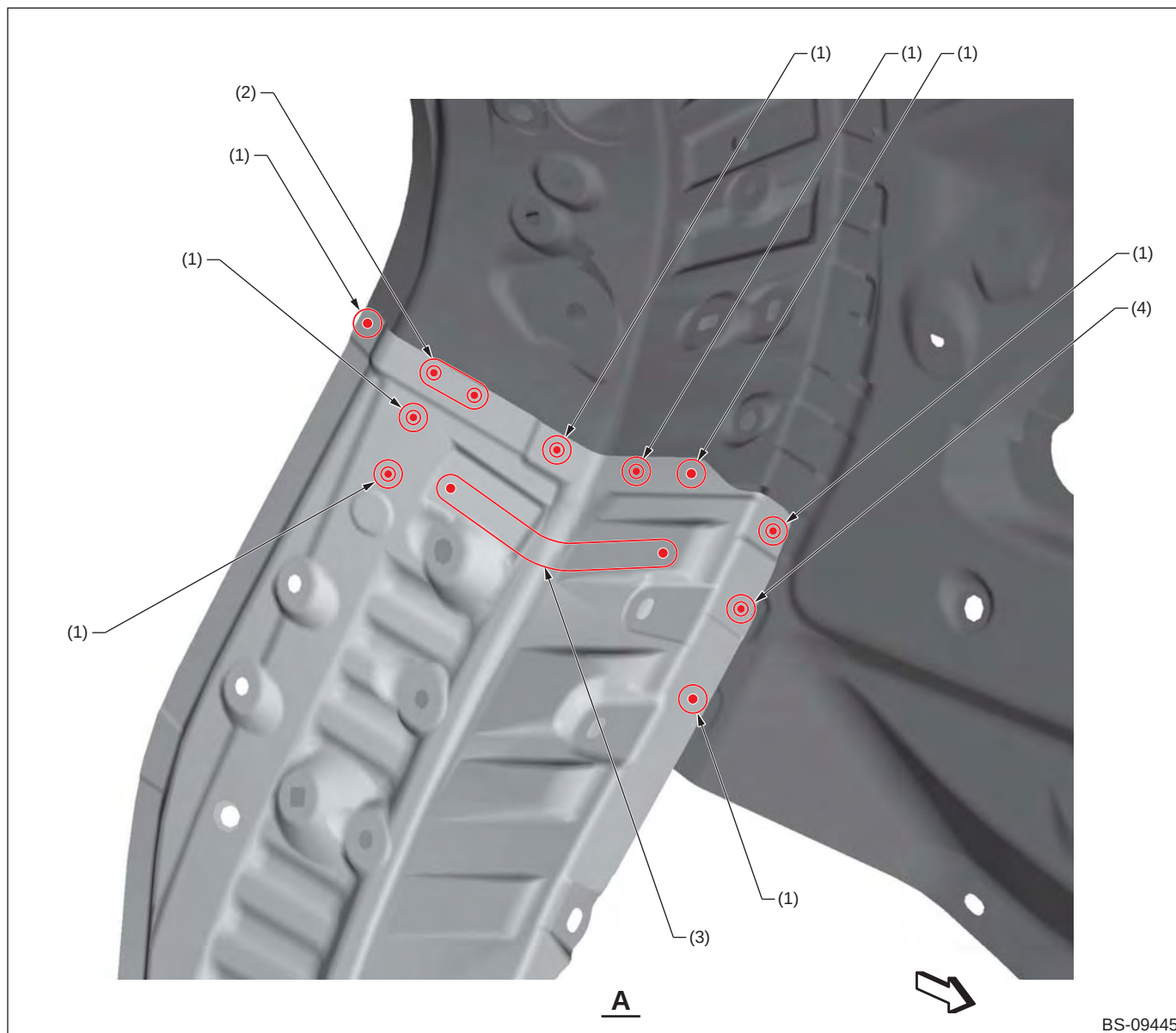
(1) 1 point (outside · 1)
(2) 2 points (outside · 1)

(3) 3 points (outside · 1)
(4) 7 points (outside · 1)

(5) 1 point (inside · 2)

Panel Replacement

• Views A



(1) 1 point (inside · 1)
(2) 2 points (inside · 1)

(3) 4 points (inside · 1)

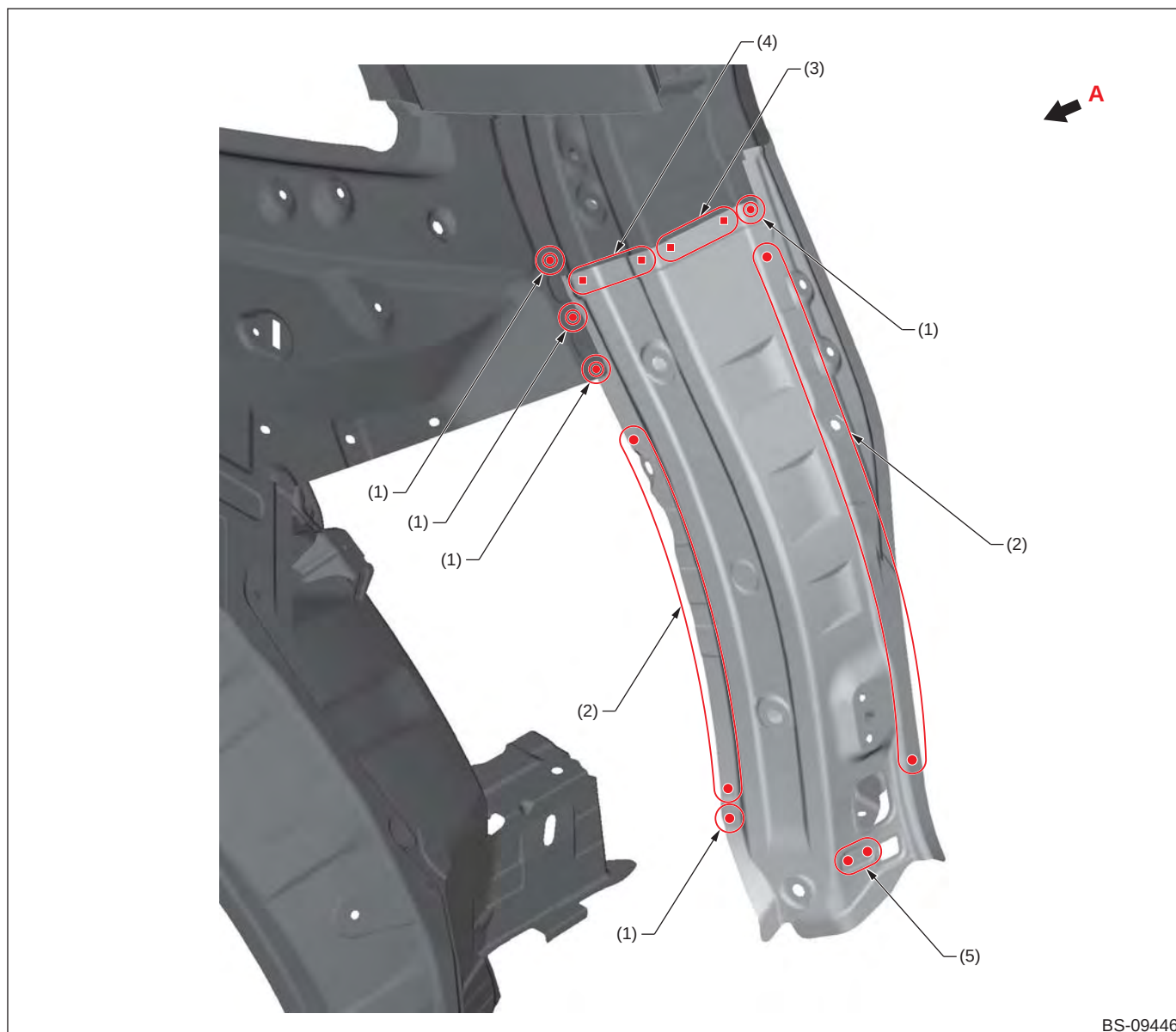
(4) 1 point (inside · 2)

BS-09445

Panel Replacement

B: INSTALLATION

• Overall view



BS-09446

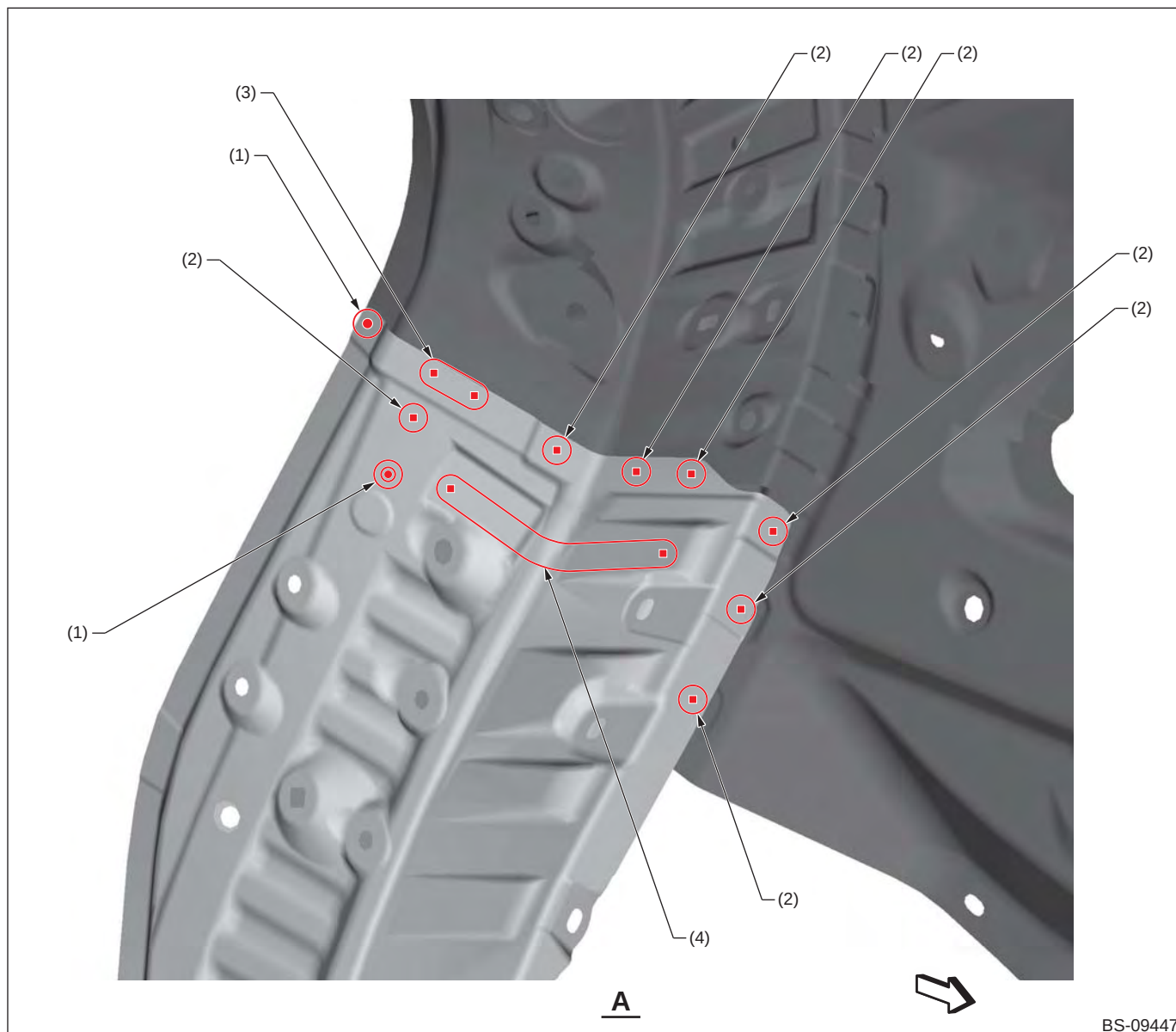
(1) 1 point
(2) 7 points

(3) 2 points (service)
(4) 3 points (service)

(5) 2 points

Panel Replacement

• Views A



- (1) 1 point
(2) 1 point (service)

- (3) 2 points (service)

- (4) 4 points (service)

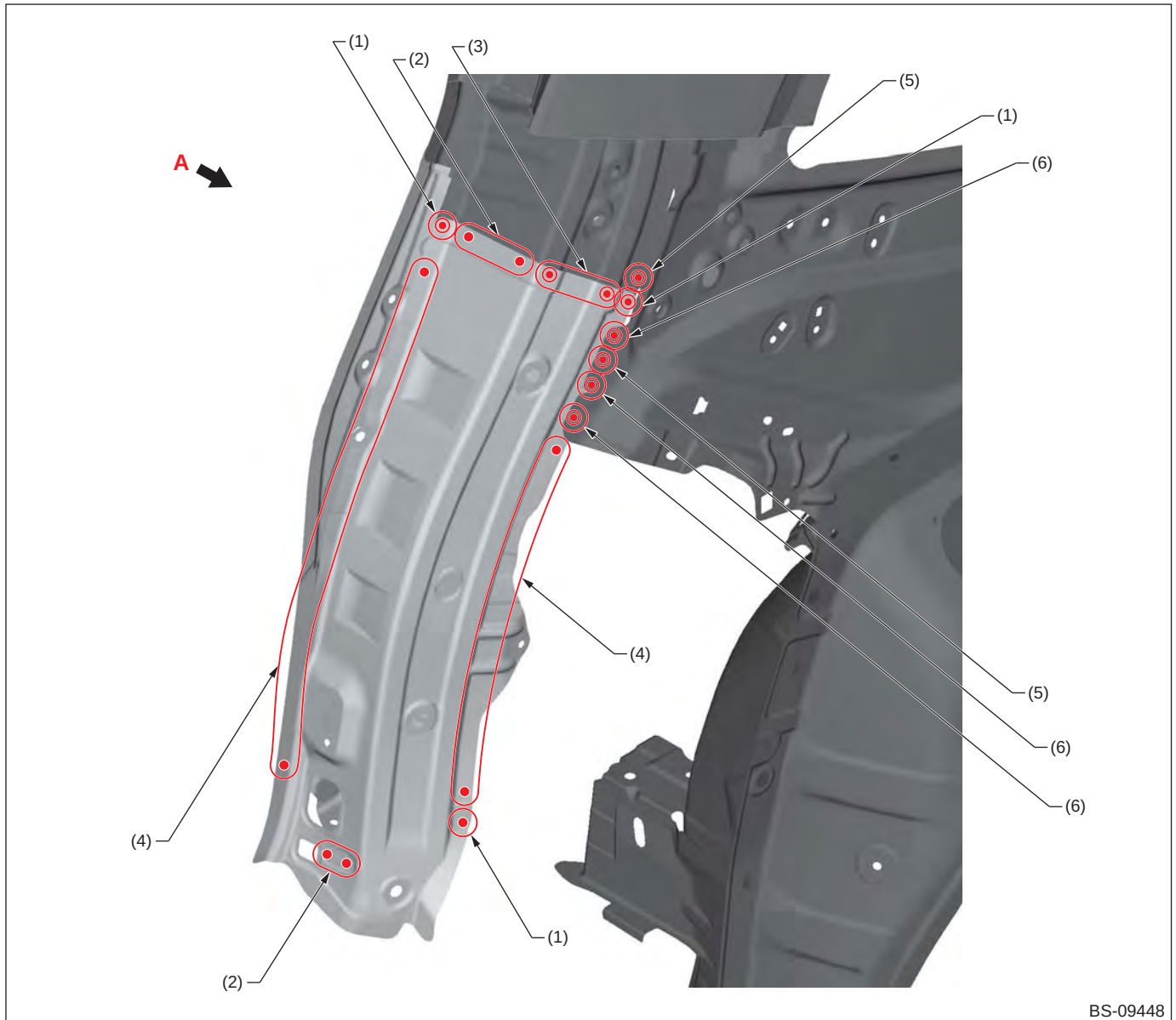
BS-09447

Panel Replacement

8-28. D Pillar Reinforcement RH (Partial replacement)

A: REMOVAL

• Overall view



BS-09448

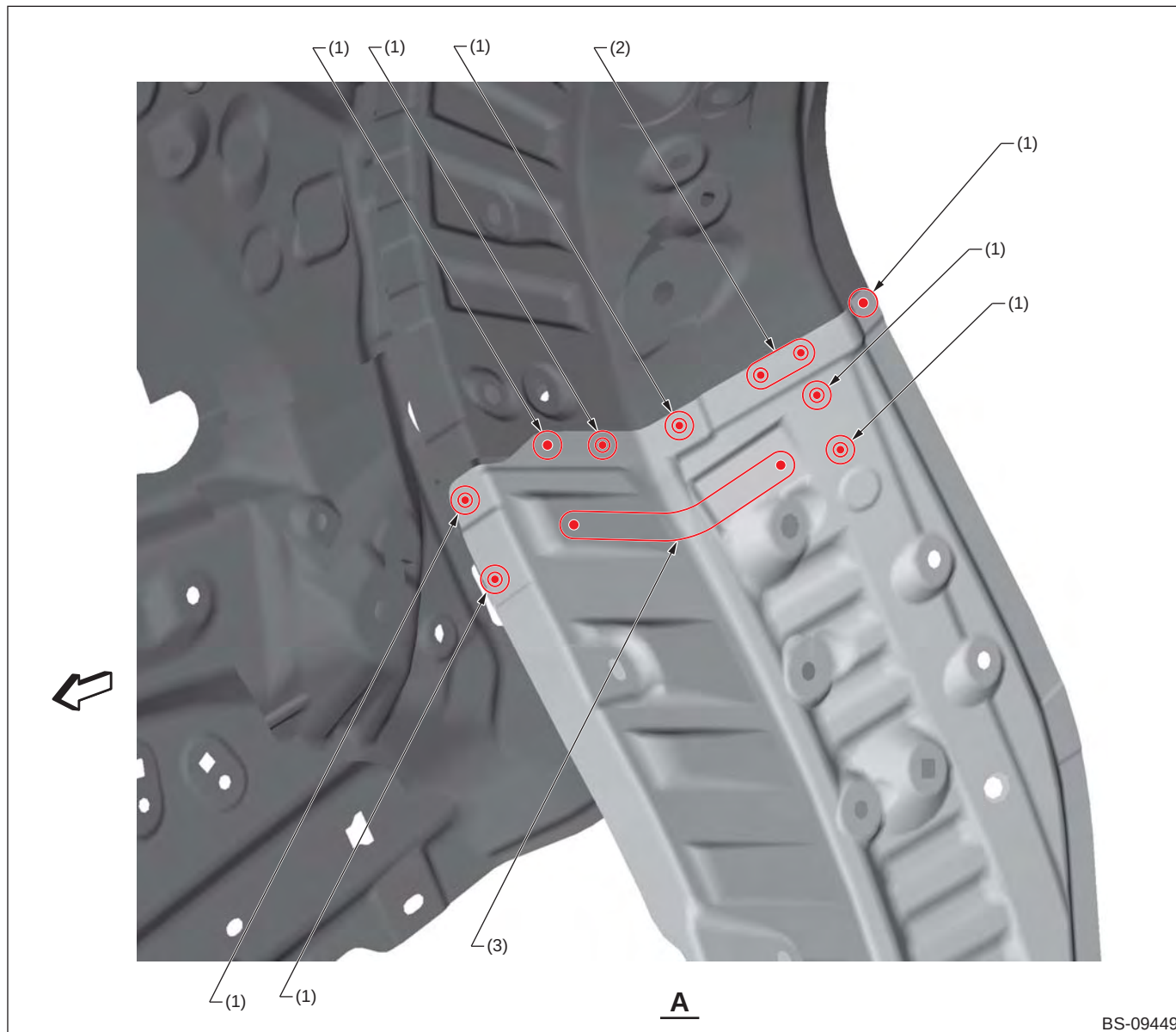
(1) 1 point (outside - 1)
(2) 2 points (outside - 1)

(3) 3 points (outside - 1)
(4) 7 points (outside - 1)

(5) 1 point (inside - 1)
(6) 1 point (inside - 2)

Panel Replacement

• Views A



BS-09449

(1) 1 point (inside · 1)

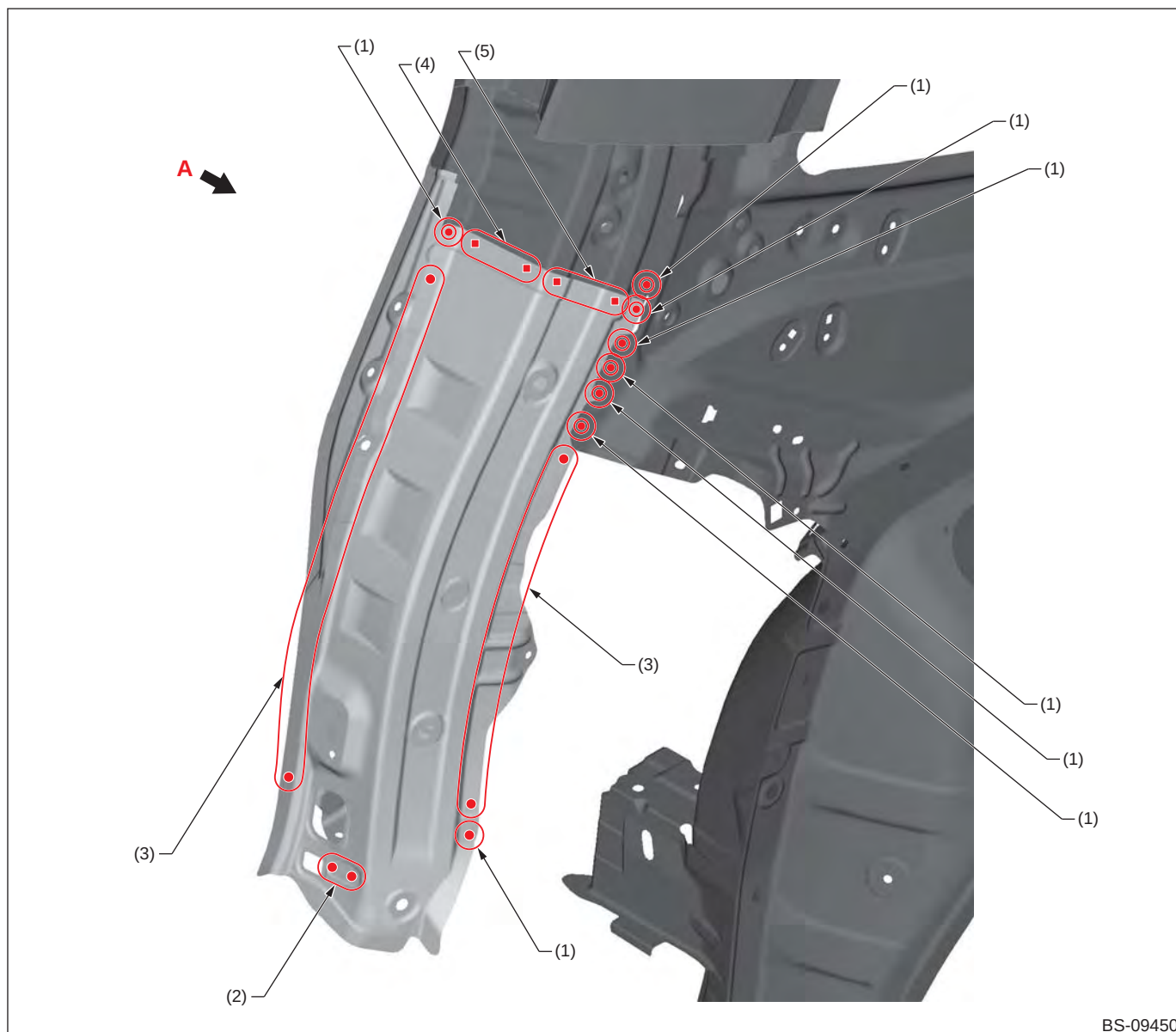
(2) 2 points (inside · 1)

(3) 4 points (inside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



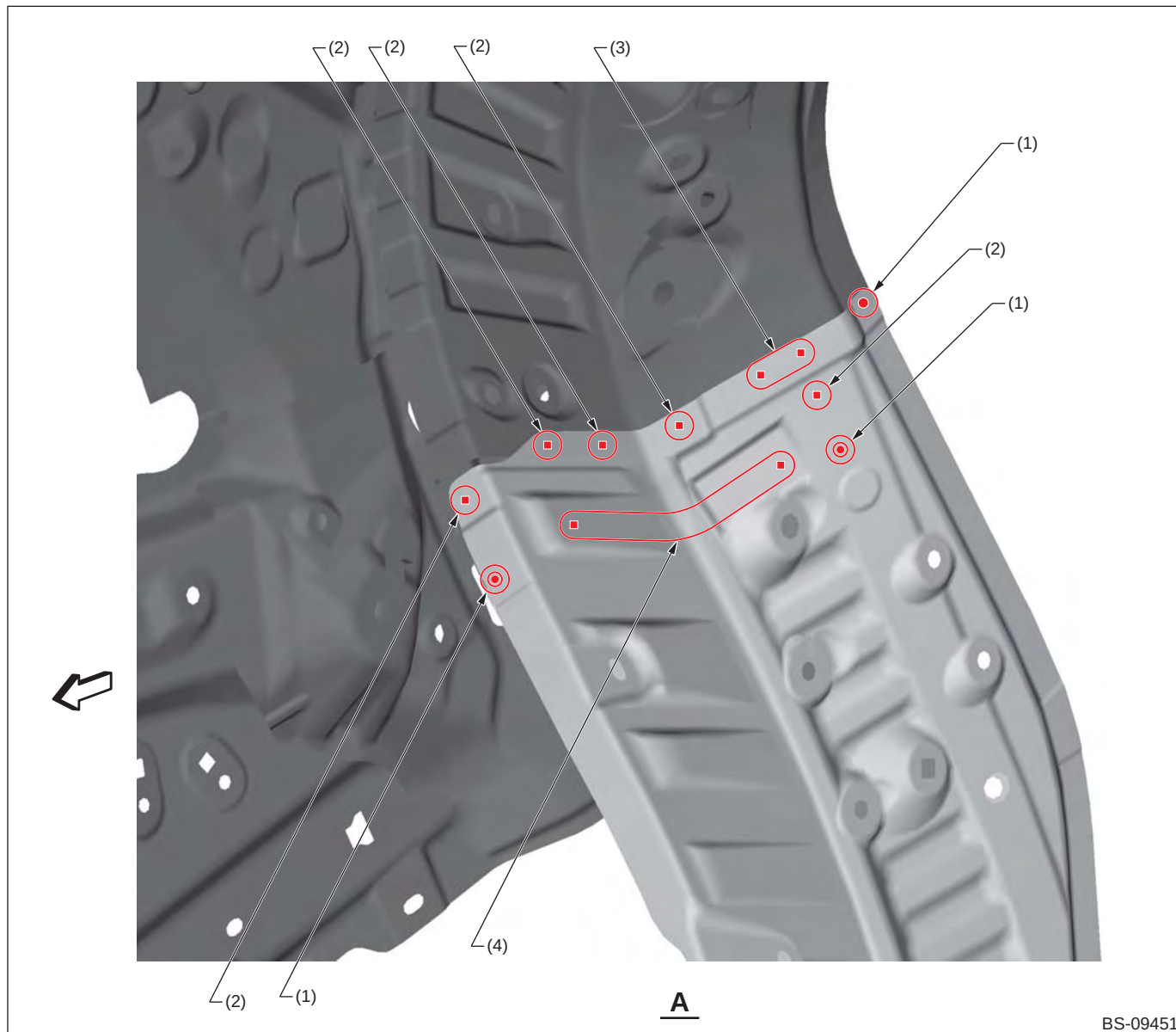
- (1) 1 point
- (2) 2 points

- (3) 7 points
- (4) 2 points (service)

- (5) 3 points (service)

Panel Replacement

• Views A



BS-09451

(1) 1 point

(2) 1 point (service)

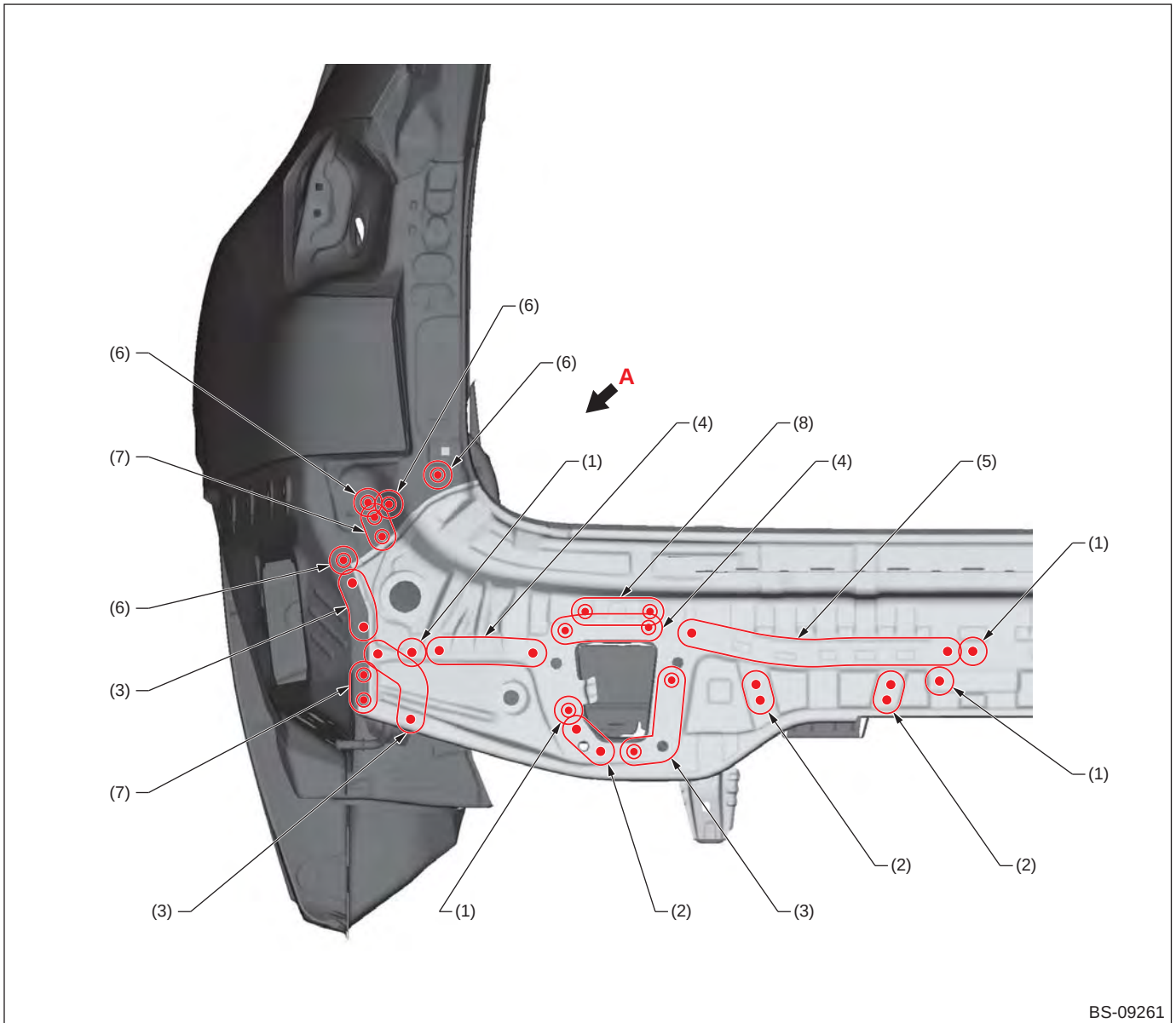
(3) 2 points (service)

(4) 4 points (service)

8-29. Rear Skirt (Total replacement)

A: REMOVAL

• Overall view



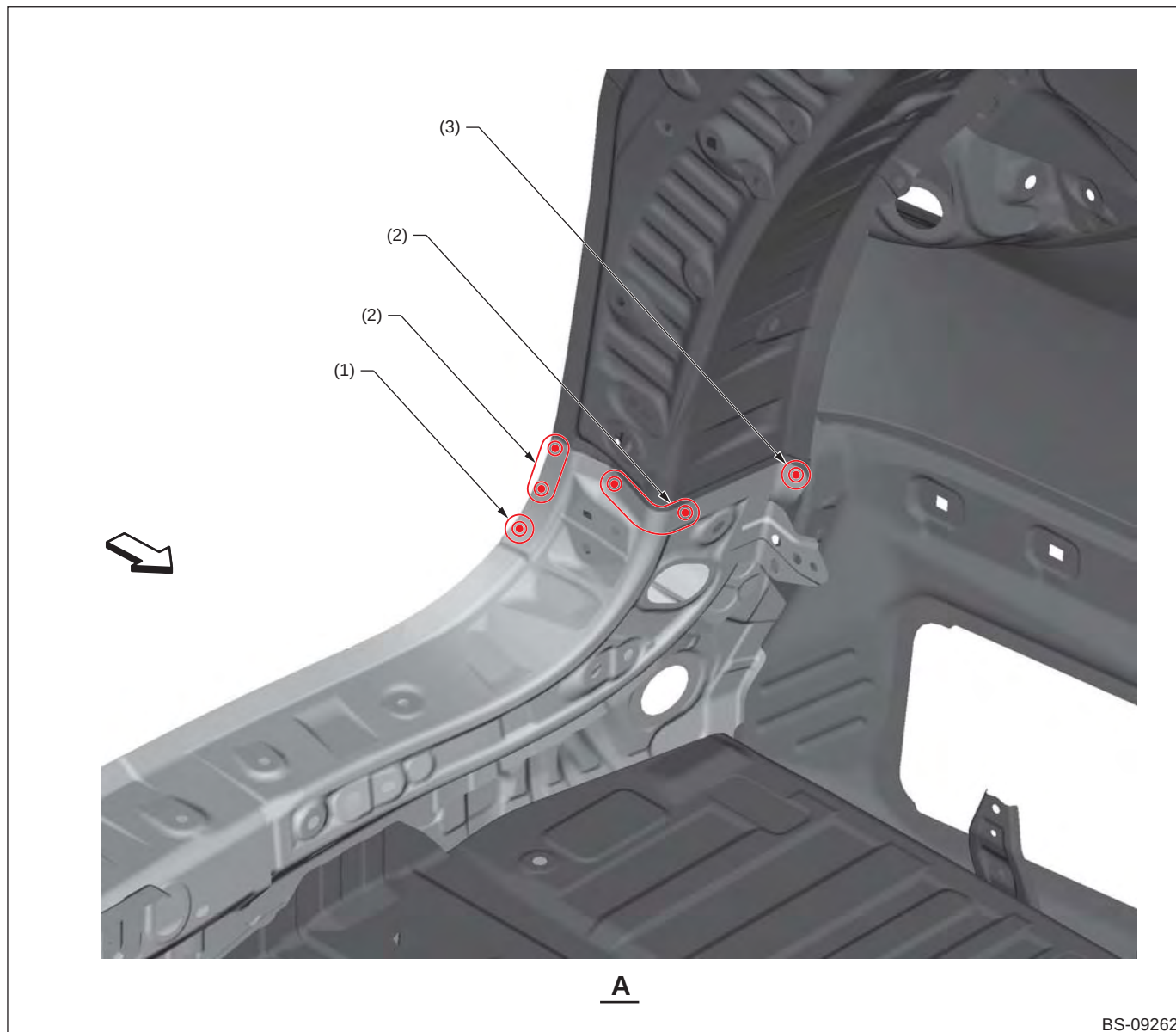
- (1) 1 point (outside · 1)
- (2) 2 points (outside · 1)
- (3) 3 points (outside · 1)

- (4) 4 points (outside · 1)
- (5) 8 points (outside · 1)
- (6) 1 point (outside · 2)

- (7) 2 points (outside · 2)
- (8) 3 points (outside · 2)

Panel Replacement

• Views A



BS-09262

(1) 1 point (inside · 2)

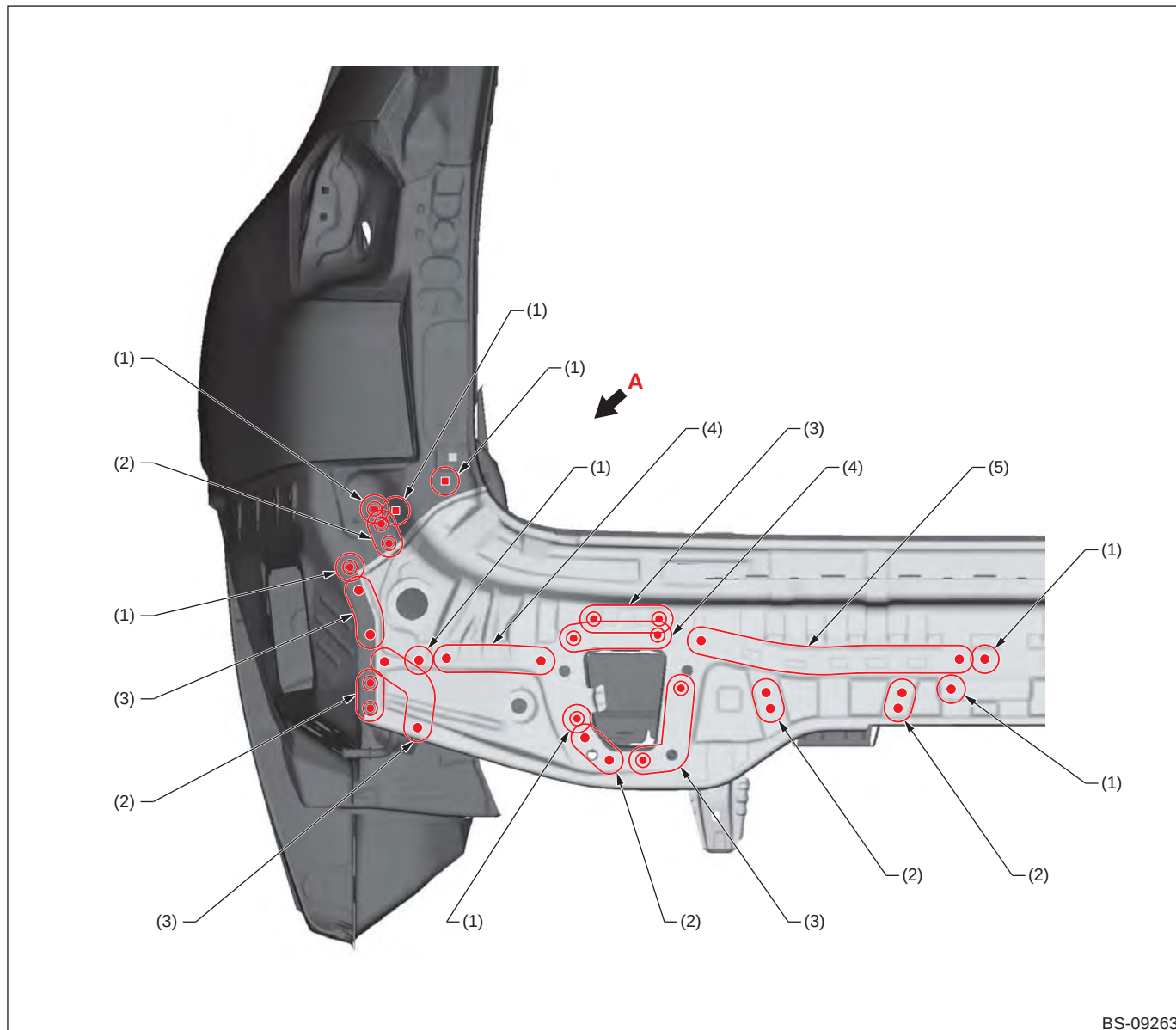
(2) 2 points (inside · 1)

(3) 1 point (inside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



(1) 1 point
(2) 2 points

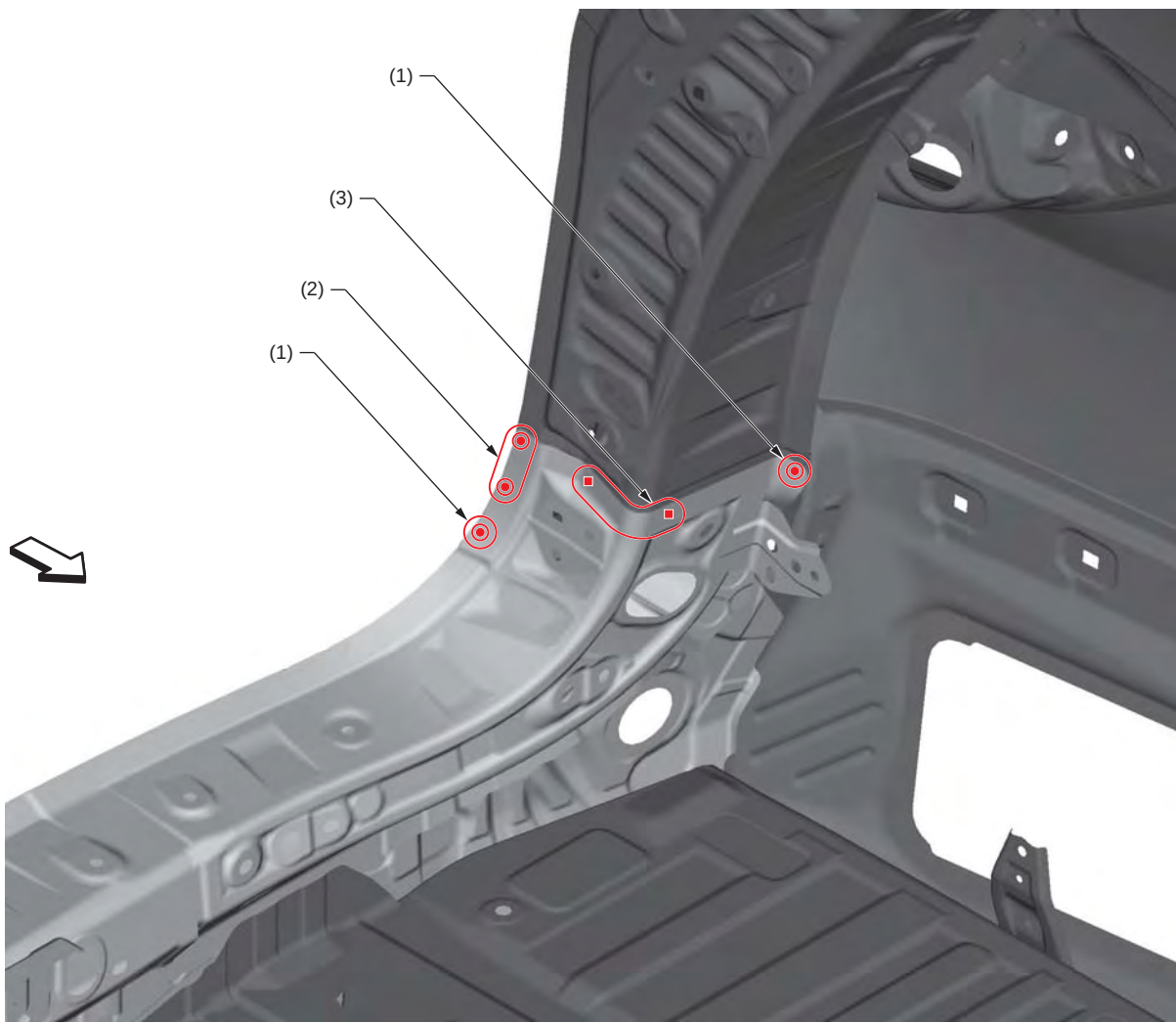
(3) 3 points
(4) 4 points

(5) 8 points

BS-09263

Panel Replacement

• Views A



A

BS-09264

(1) 1 point

(2) 2 points

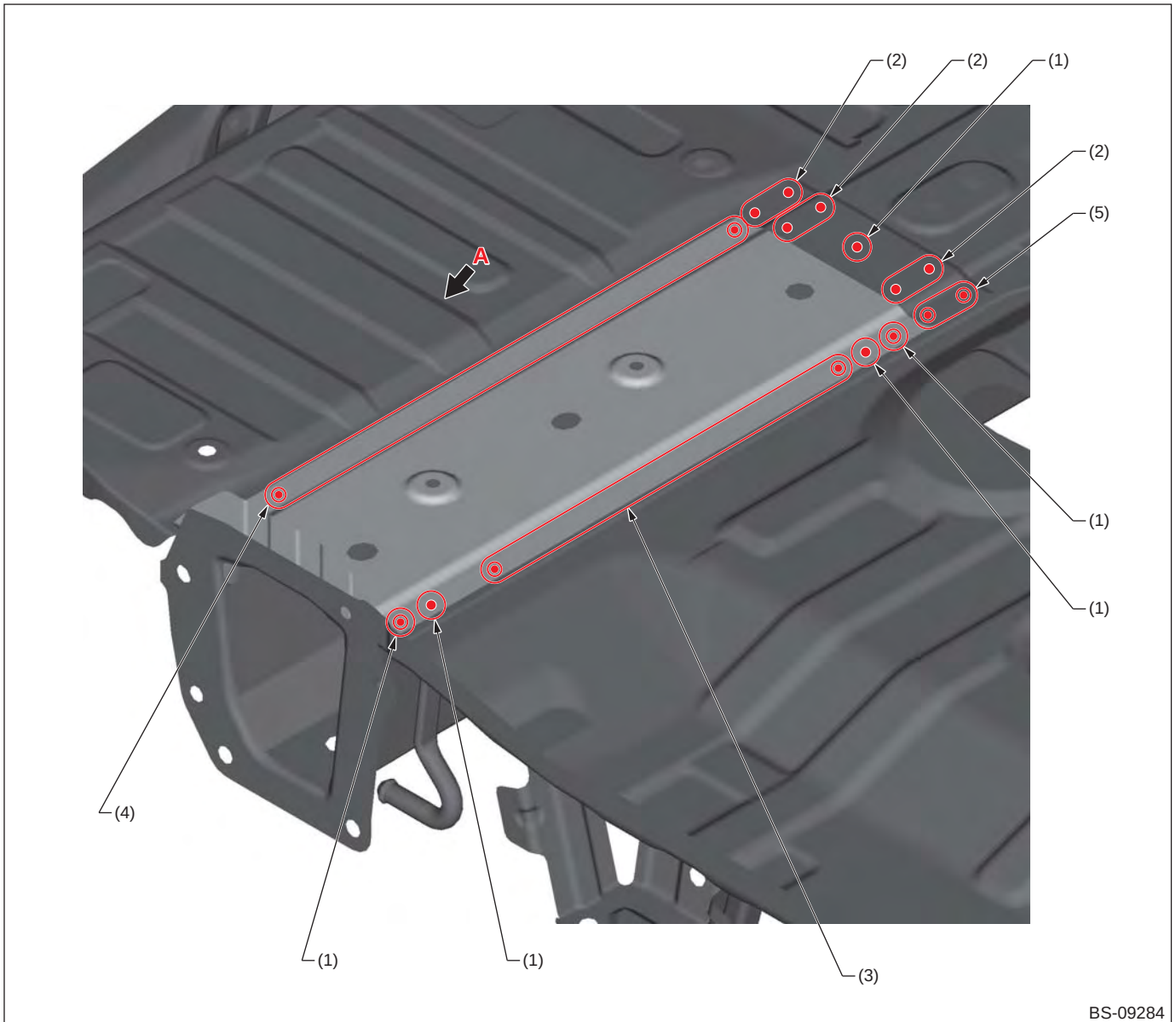
(3) 2 points (service)

Panel Replacement

8-30. Rear Side Frame Upper Rear (Total replacement)

A: REMOVAL

• Overall view



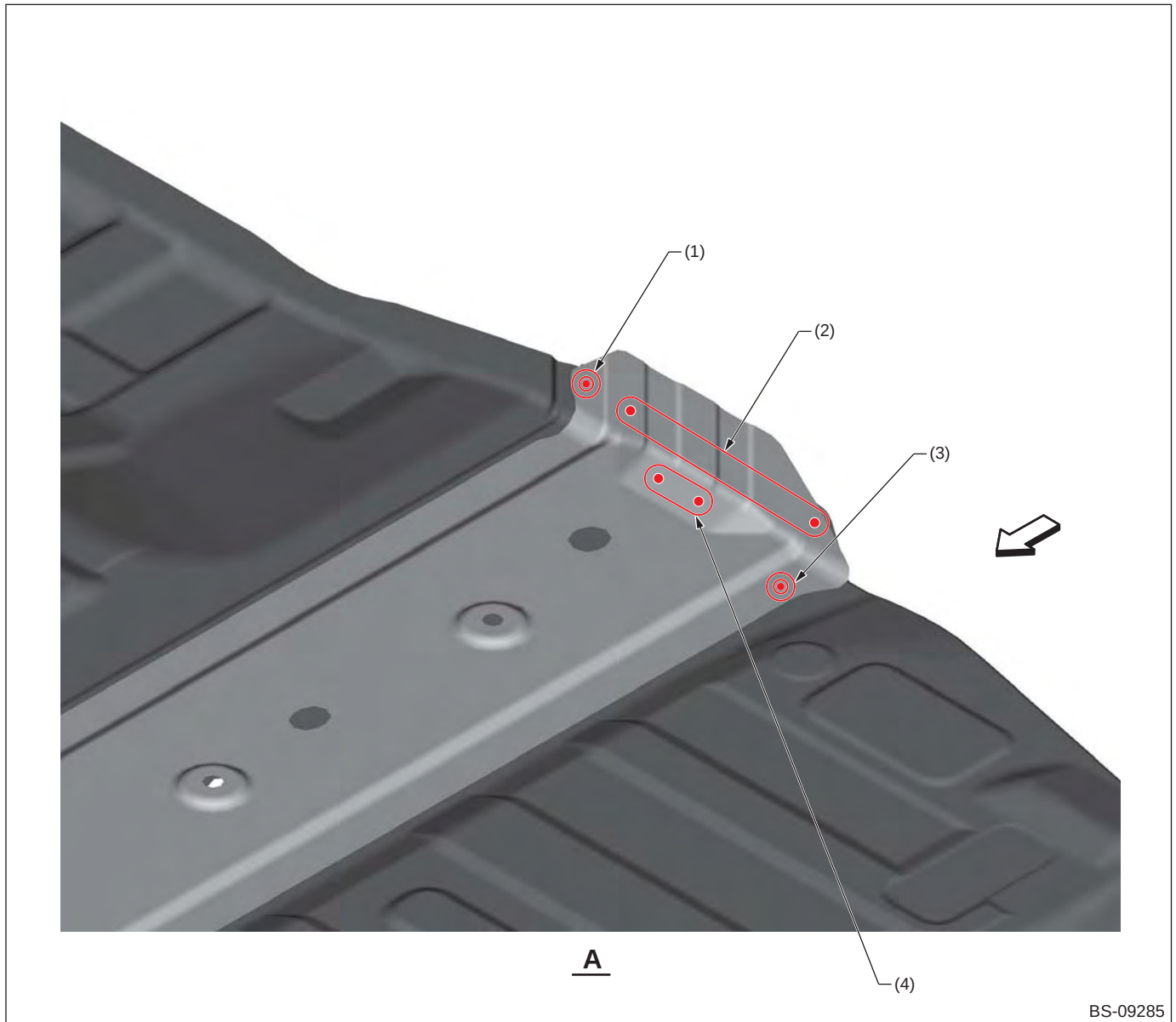
(1) 1 point (top · 1)
(2) 2 points (top · 1)

(3) 7 points (top · 1)
(4) 8 points (top · 1)

(5) 2 points (top · 2)

Panel Replacement

• Views A



- (1) 1 point (inside · 1)
(2) 4 points (inside · 1)

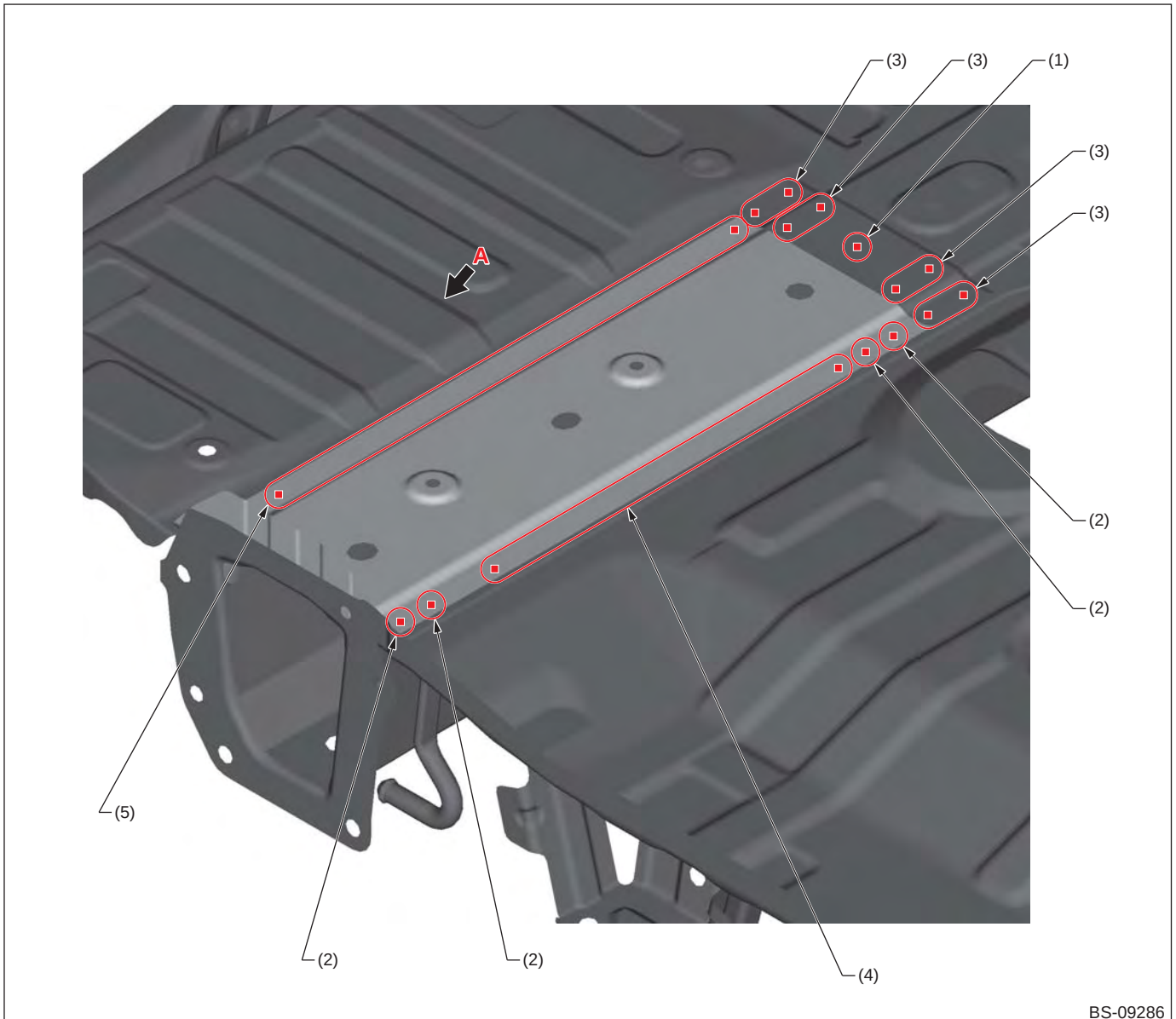
- (3) 1 point (top · 1)

- (4) 2 points (inside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



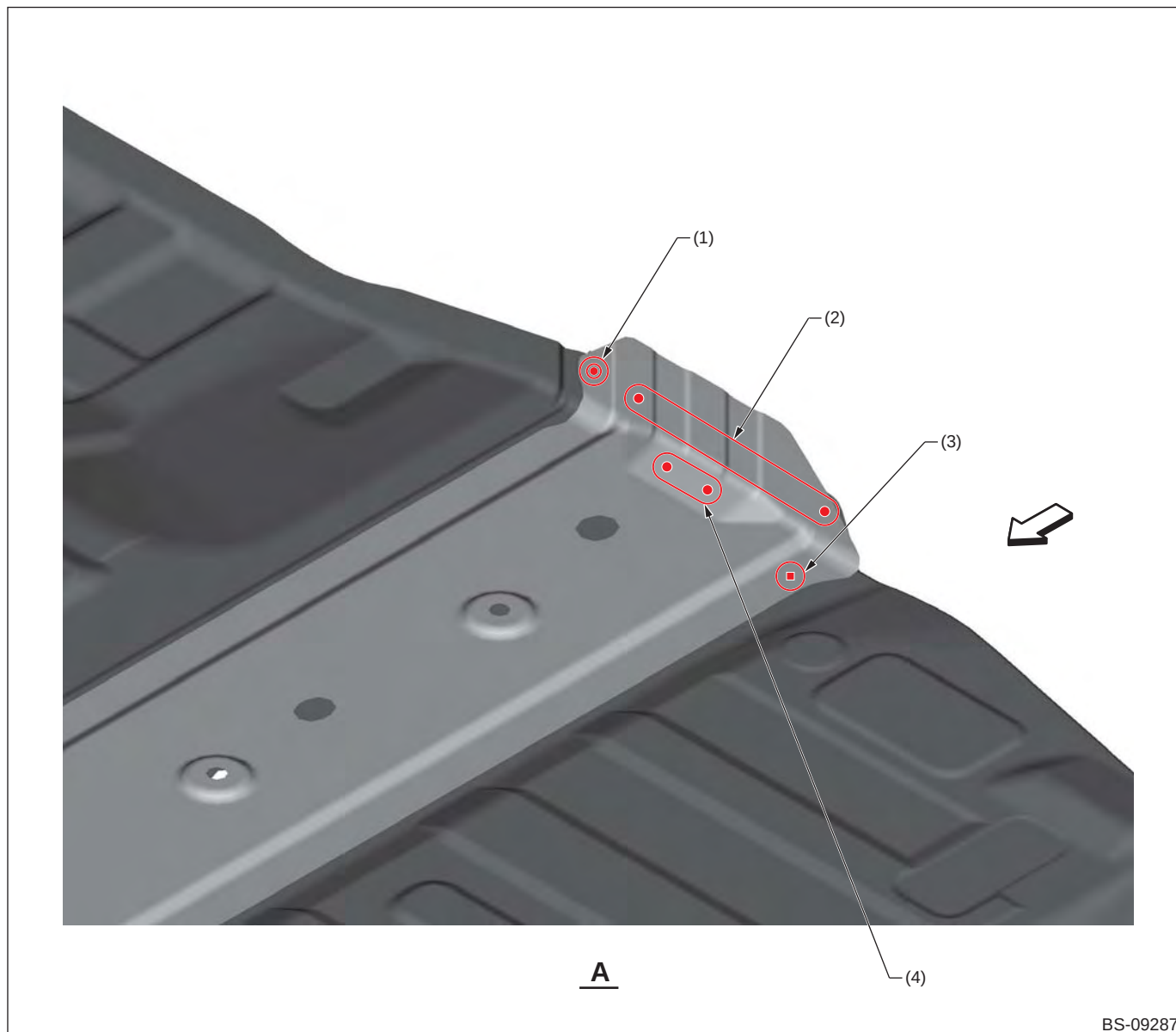
(1) 1 point
(2) 1 point (service)

(3) 2 points
(4) 7 points (service)

(5) 8 points (service)

Panel Replacement

• Views A



(1) 1 point
(2) 4 points

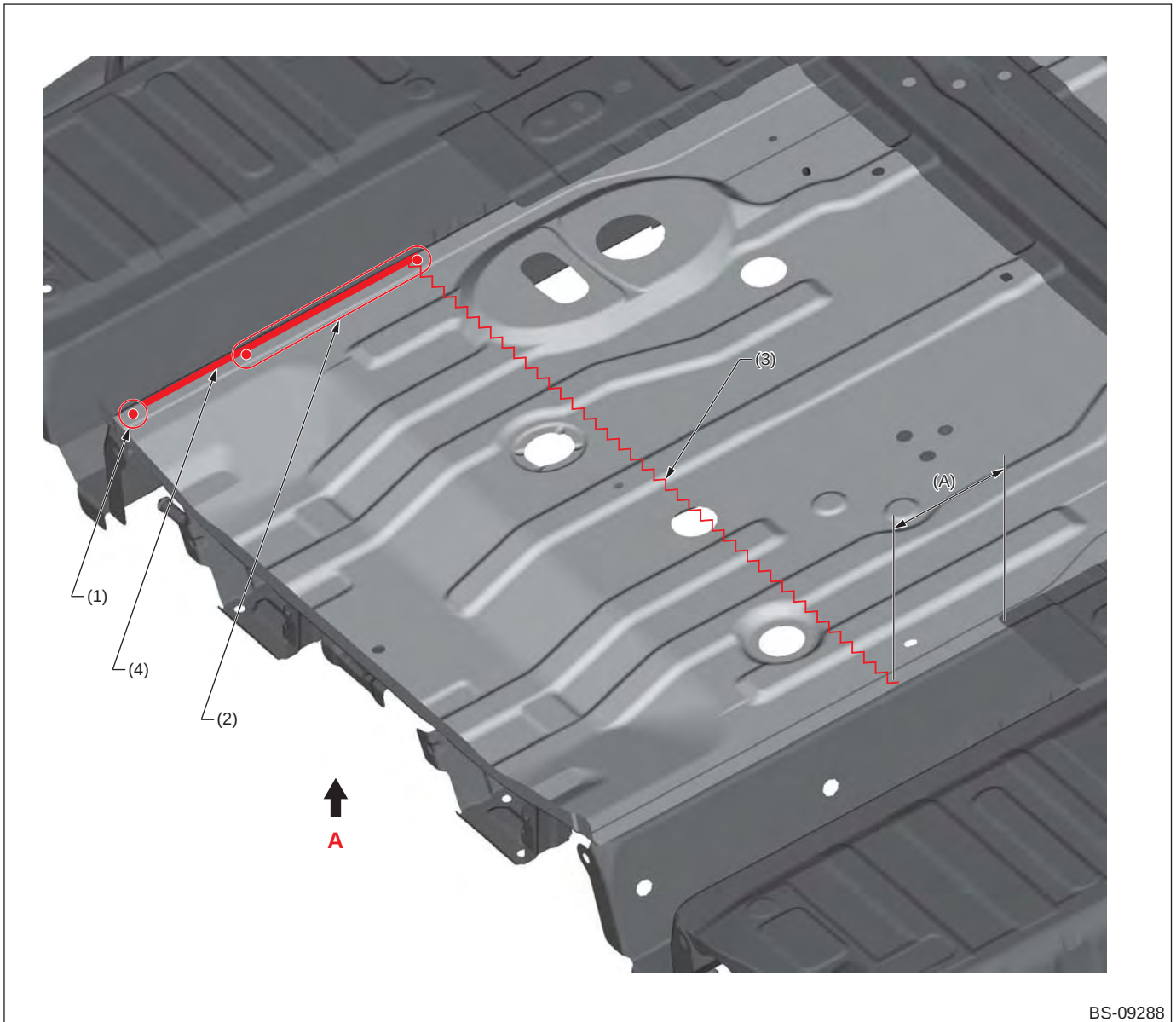
(3) 1 point (service)

(4) 2 points

8-31. Rear Floor Pan (Partial replacement)

A: REMOVAL

• Overall view



BS-09288

(A) 110 mm [4.33 in]

(1) 1 point (top · 1)

(3) Cut position

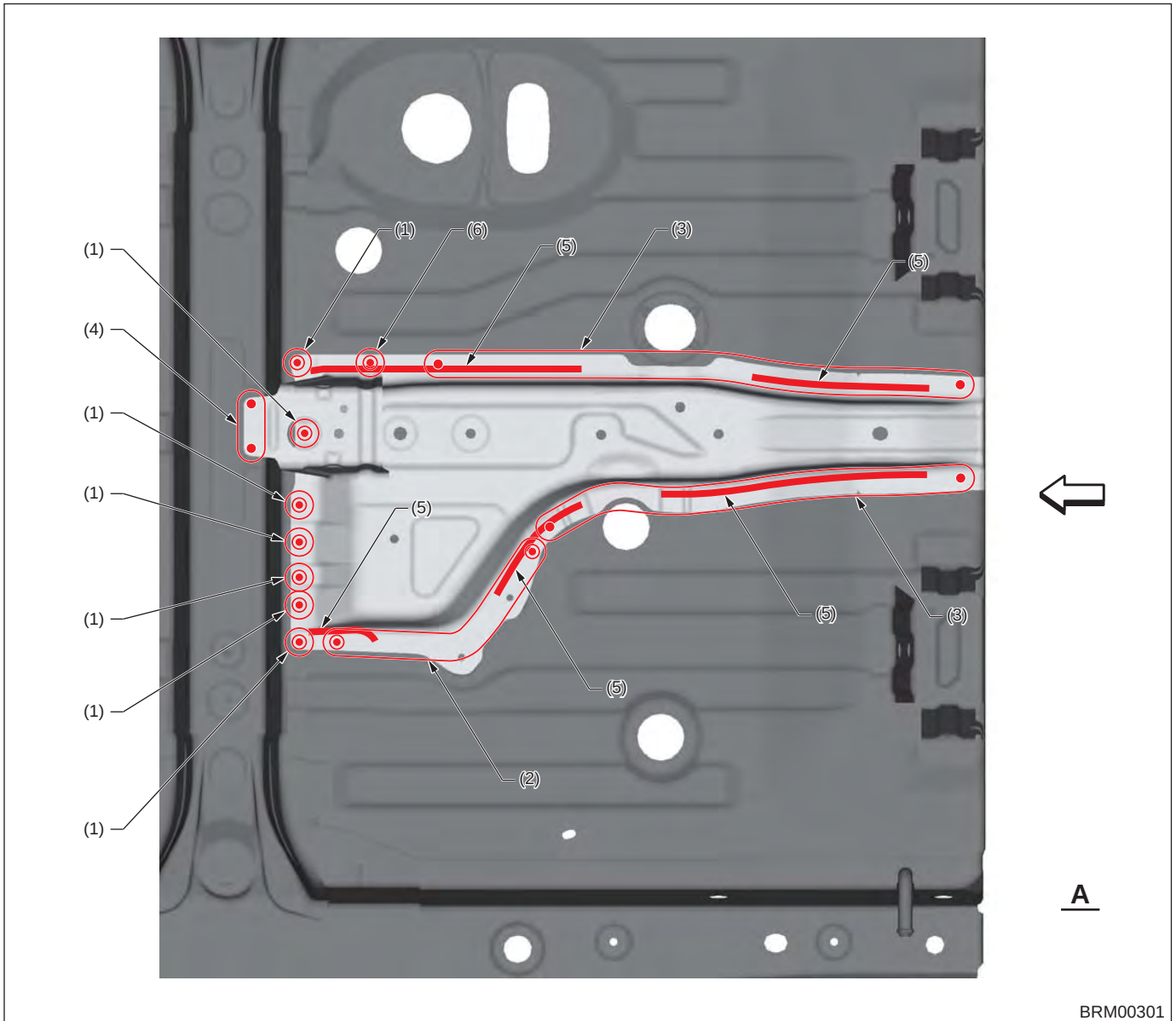
(4) Structural adhesive

(2) 6 points (top · 1)

— : Structural adhesive application location

Panel Replacement

• Views A



BRM00301

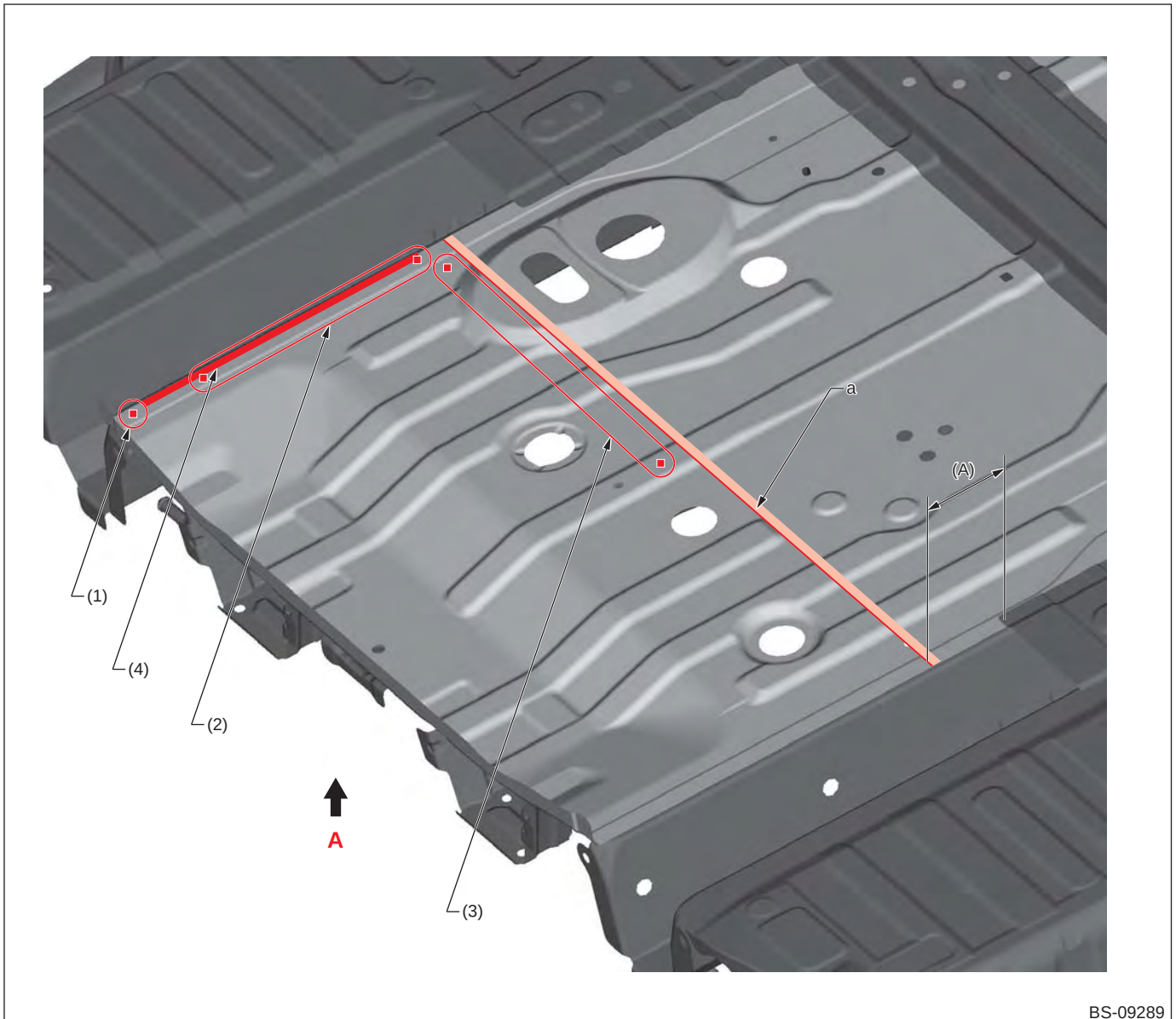
- | | | |
|---------------------------|---------------------------|--------------------------|
| (1) 1 point (bottom · 1) | (3) 8 points (bottom · 1) | (5) Structural adhesive |
| (2) 4 points (bottom · 1) | (4) 2 points (bottom · 1) | (6) 1 point (bottom · 2) |

— : Structural adhesive application location

Panel Replacement

B: INSTALLATION

• Overall view



BS-09289

(A) 85 mm [3.35 in]

(1) 1 point (service)

(3) 8 points (service)

(4) Structural adhesive

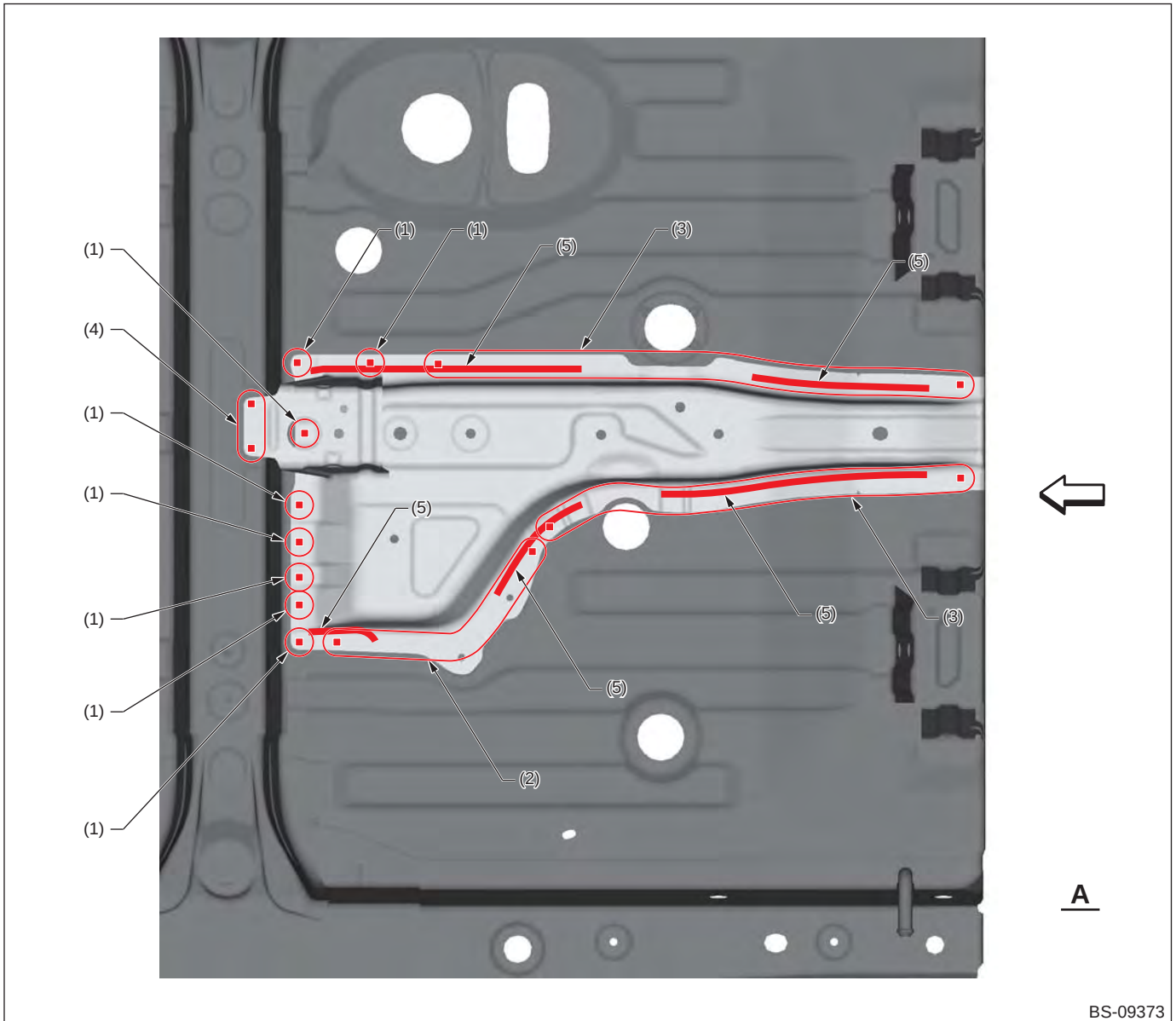
(2) 6 points (service)

— : Structural adhesive application location

Note: Apply sealing agent to the floor pan fitting parts (front and rear) of section "a".

Panel Replacement

• Views A



BS-09373

- | | | |
|------------------------|------------------------|-------------------------|
| (1) 1 point (service) | (3) 8 points (service) | (5) Structural adhesive |
| (2) 4 points (service) | (4) 2 points (service) | |

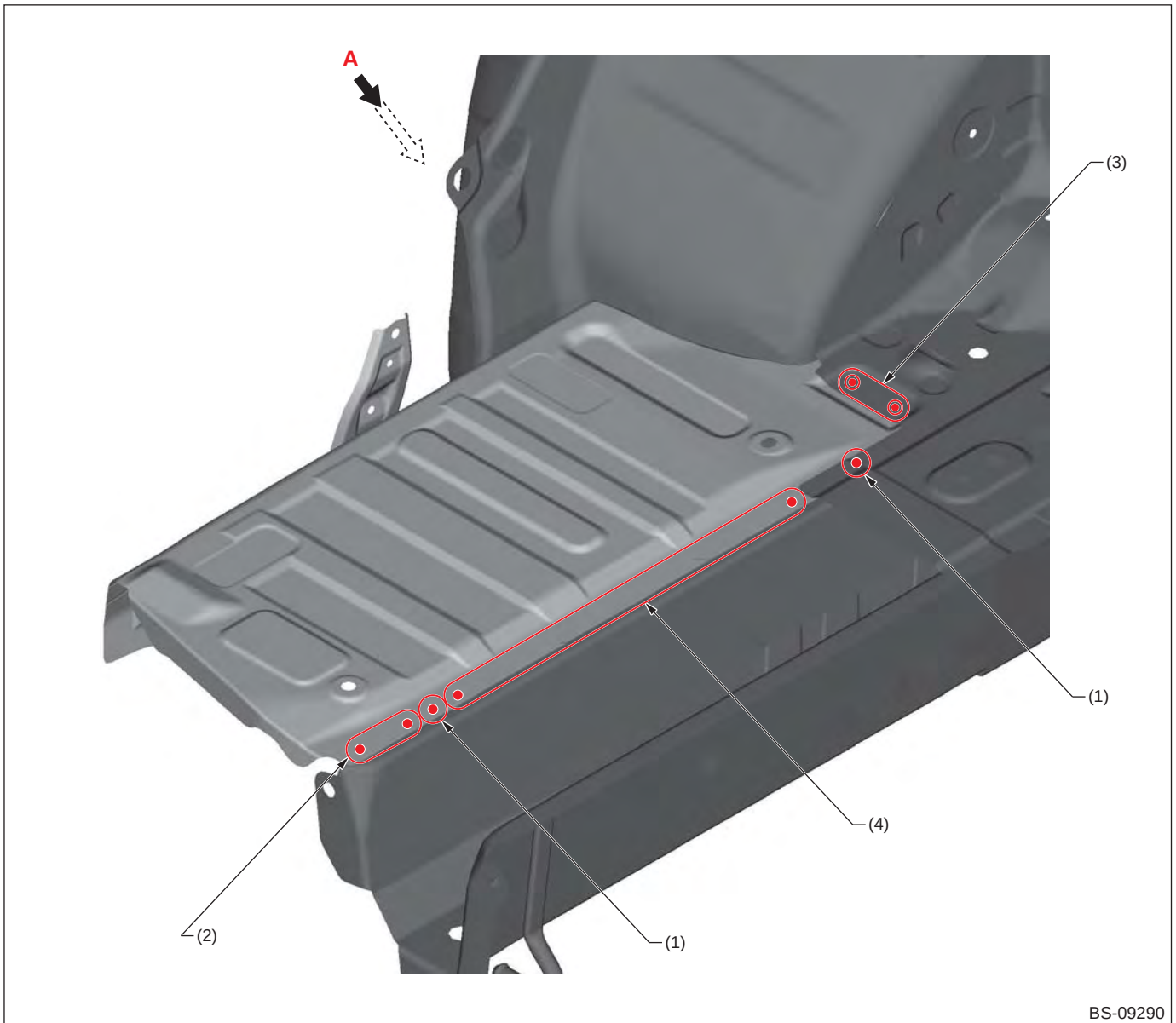
— : Structural adhesive application location

Panel Replacement

8-32. Rear Floor Side (Total replacement)

A: REMOVAL

• Overall view



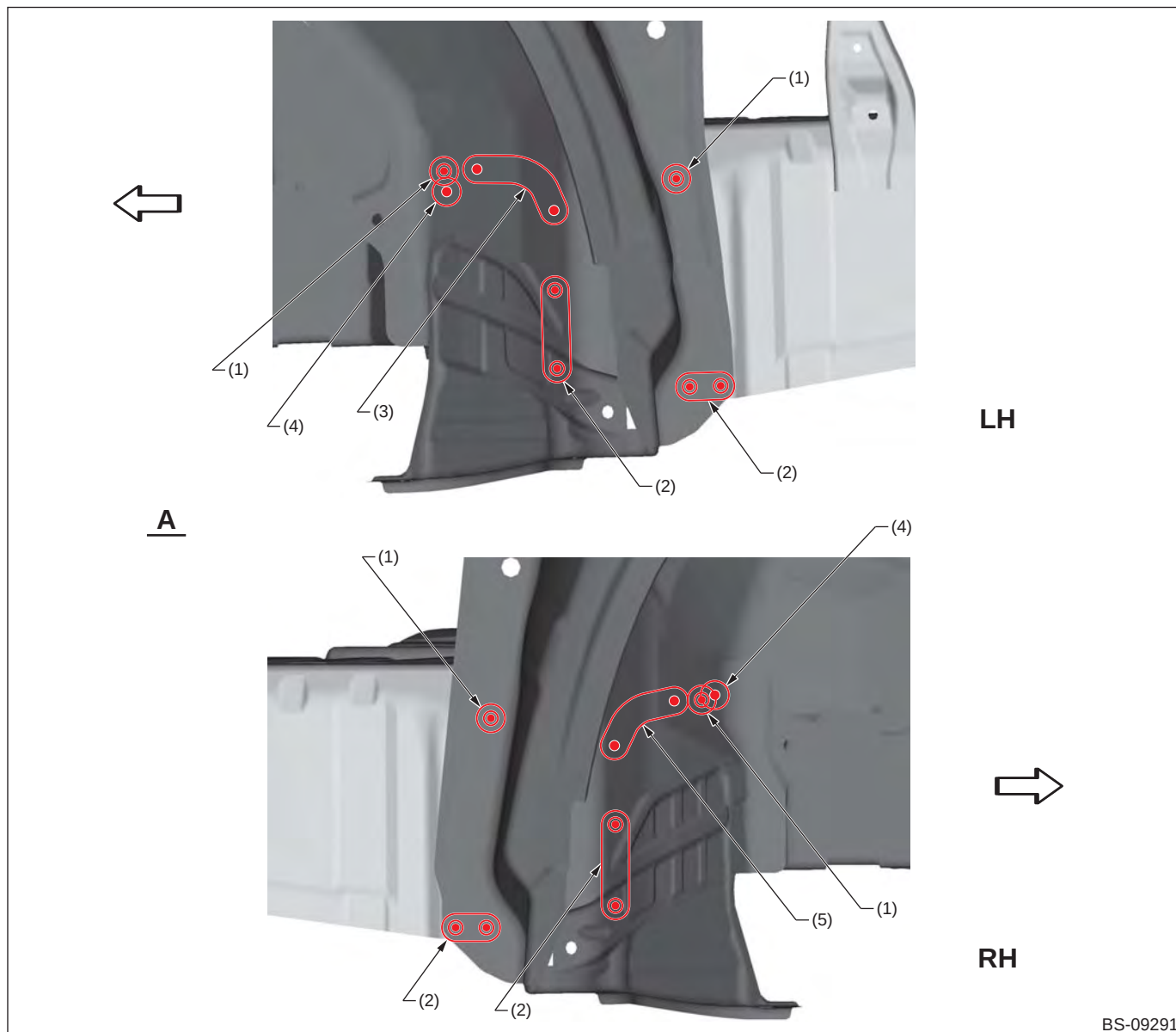
(1) 1 point (top · 1)
(2) 2 points (top · 1)

(3) 2 points (top · 2)

(4) 7 points (top · 1)

Panel Replacement

• Views A



(1) 1 point (outside · 2)
(2) 2 points (inside · 1)

(3) 4 points (inside · 1)
(4) 1 point (inside · 1)

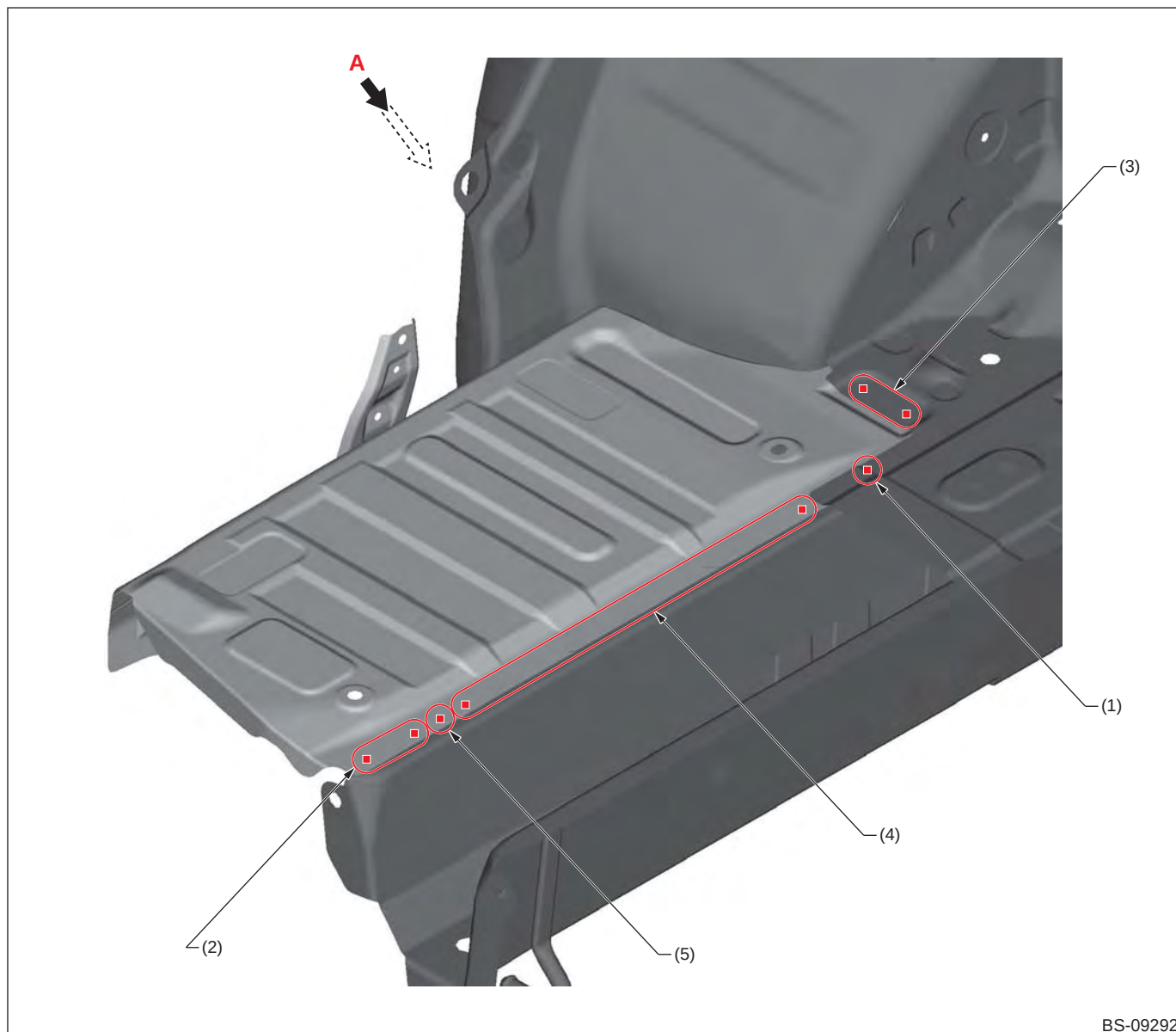
(5) 3 points (inside · 1)

BS-09291

Panel Replacement

B: INSTALLATION

• Overall view



(1) 1 point
(2) 2 points (service)

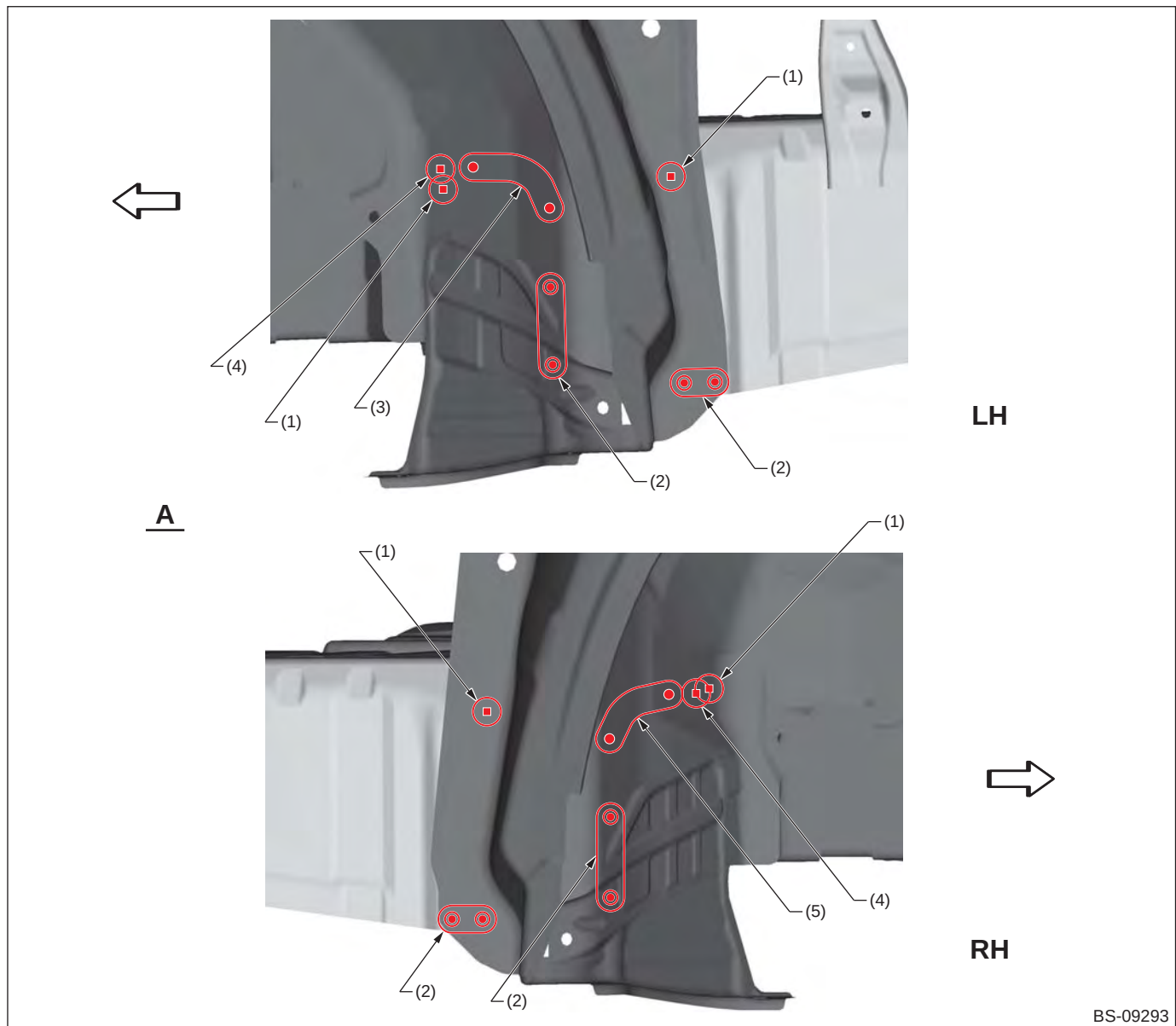
(3) 2 points
(4) 7 points (service)

(5) 1 point (service)

BS-09292

Panel Replacement

• Views A



(1) 1 point
(2) 2 points

(3) 4 points
(4) 1 point (service - matching)

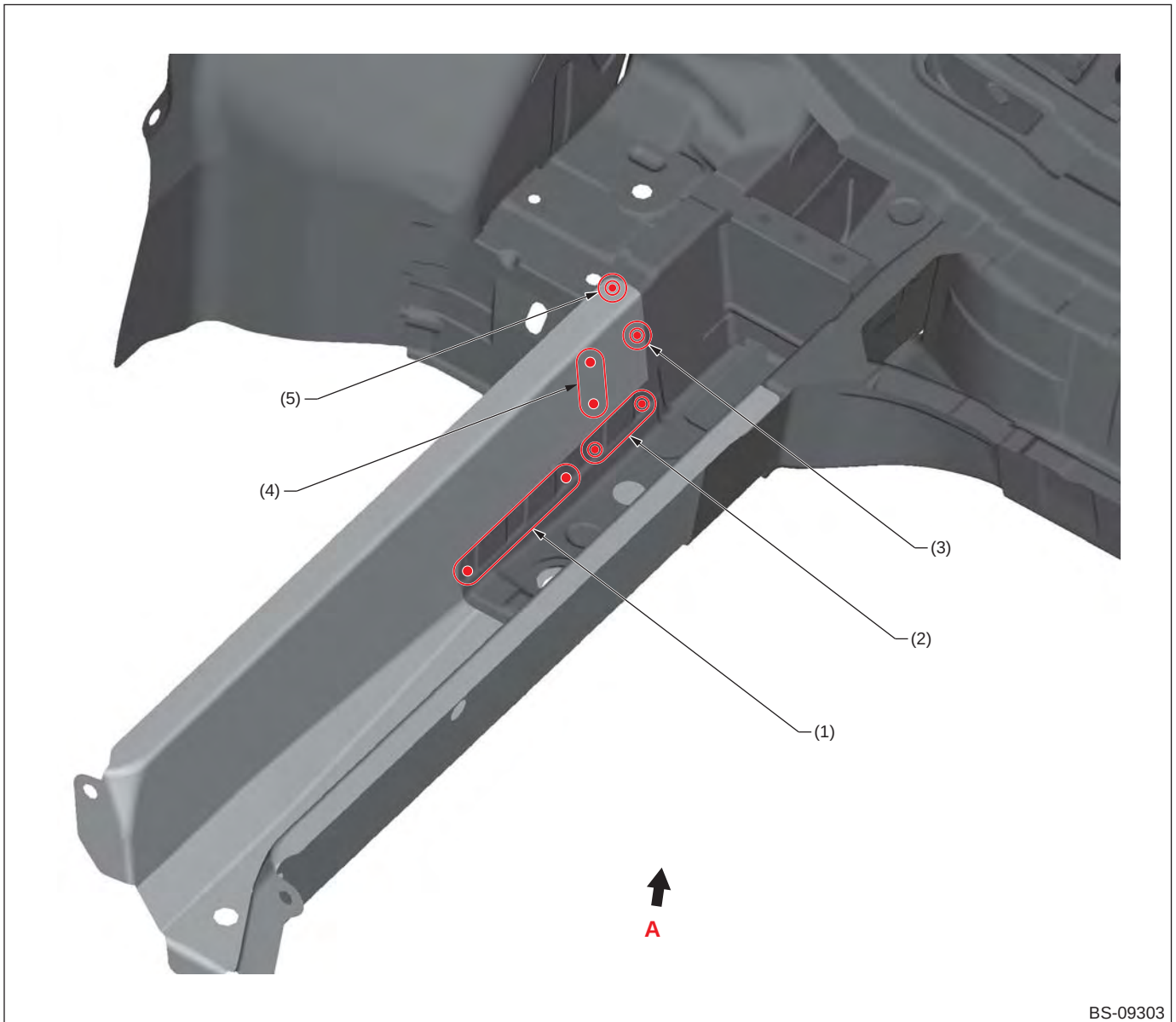
(5) 3 points

Panel Replacement

8-33. Rear Side Frame Lower Rear (Total replacement)

A: REMOVAL

• Overall view



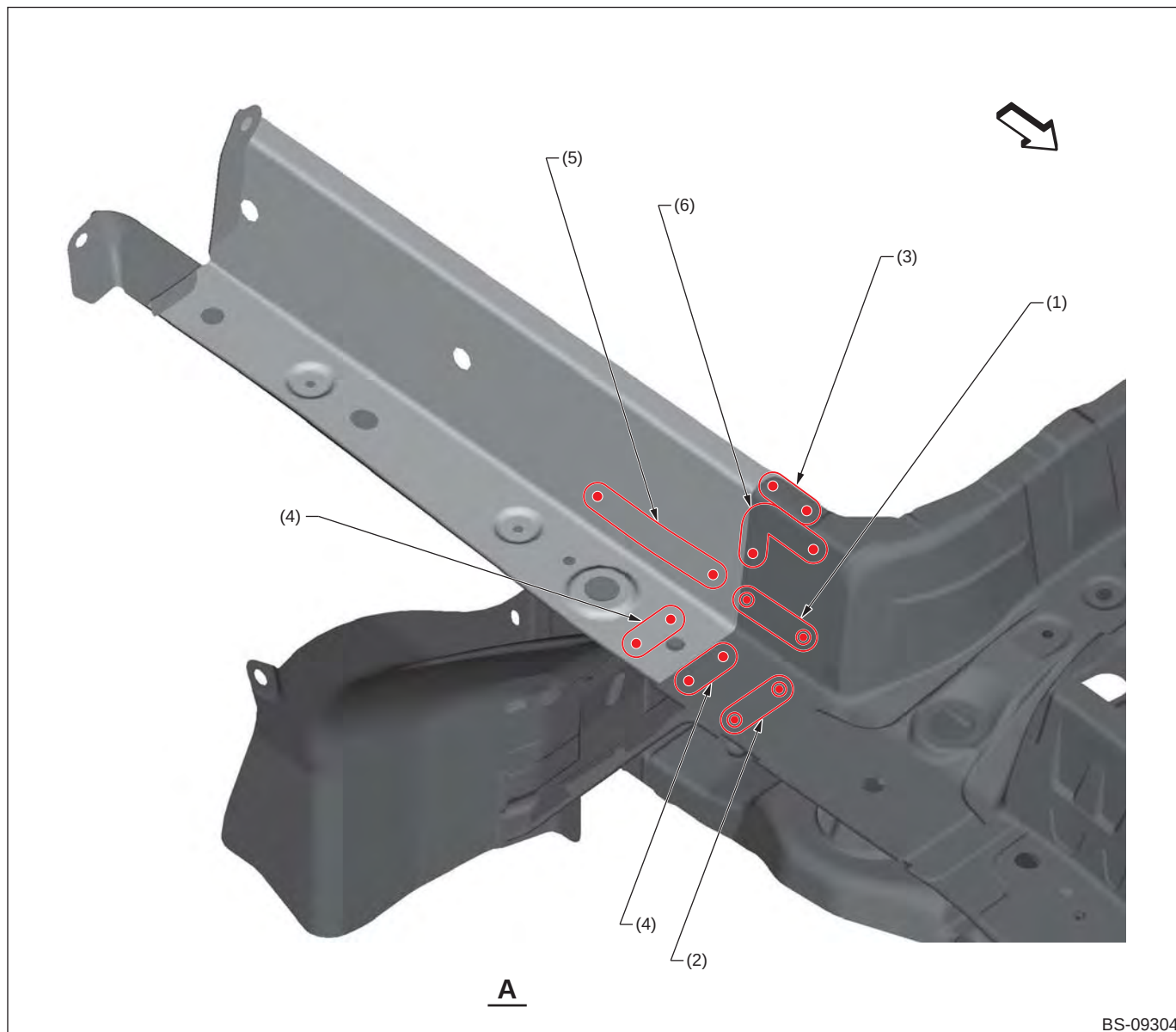
(1) 3 points (outside · 1)
(2) 2 points (outside · 2)

(3) 1 point (inside · 1 belt sander)
(4) 2 points (inside · 1 belt sander)

(5) 1 point (top · 1)

Panel Replacement

• Views A



BS-09304

(1) 2 points (outside · 2)
(2) 2 points (bottom · 2)

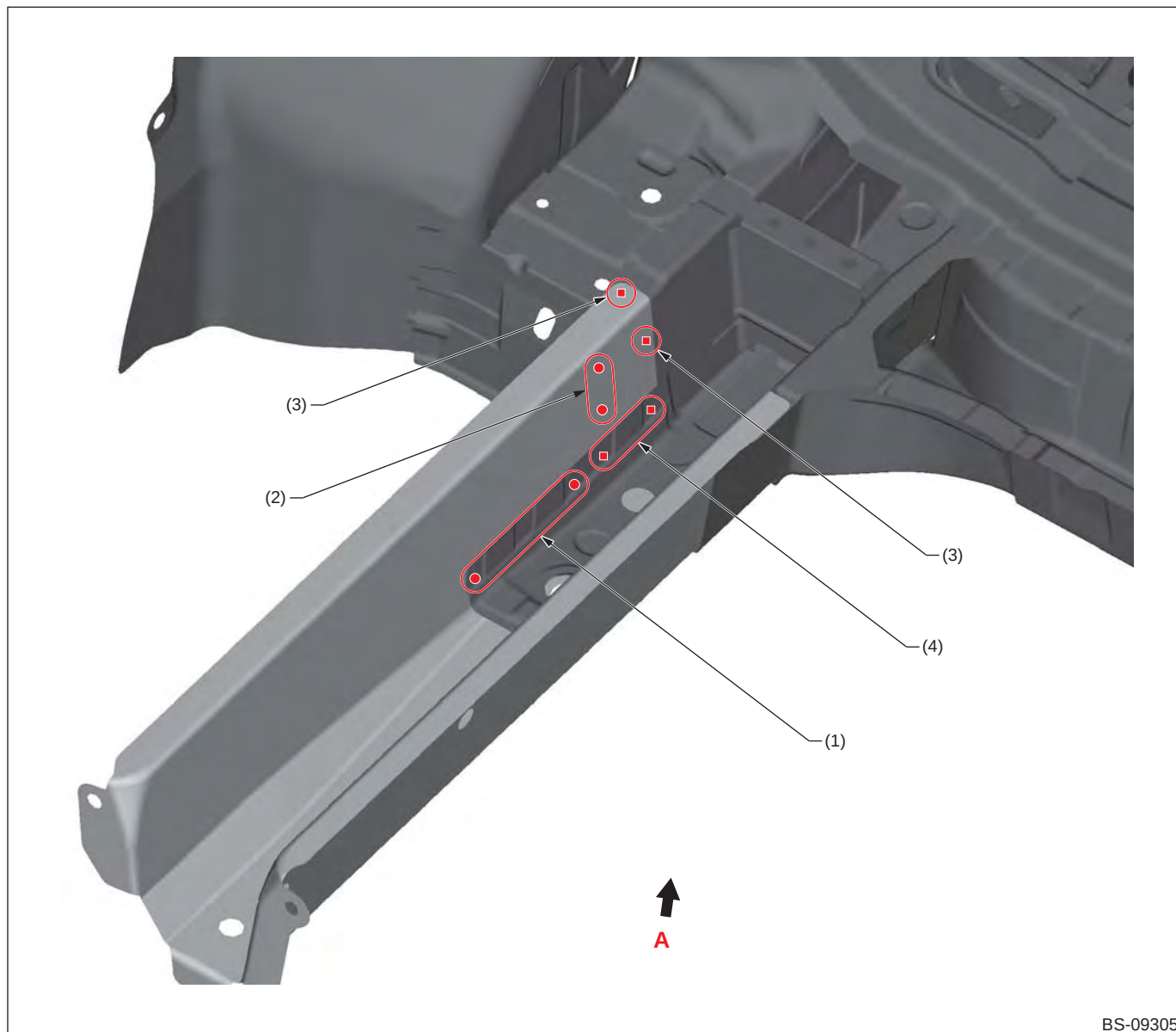
(3) 2 points (top · 1)
(4) 2 points (bottom · 1)

(5) 3 points (outside · 1)
(6) 3 points (inside · 1 belt sander)

Panel Replacement

B: INSTALLATION

• Overall view



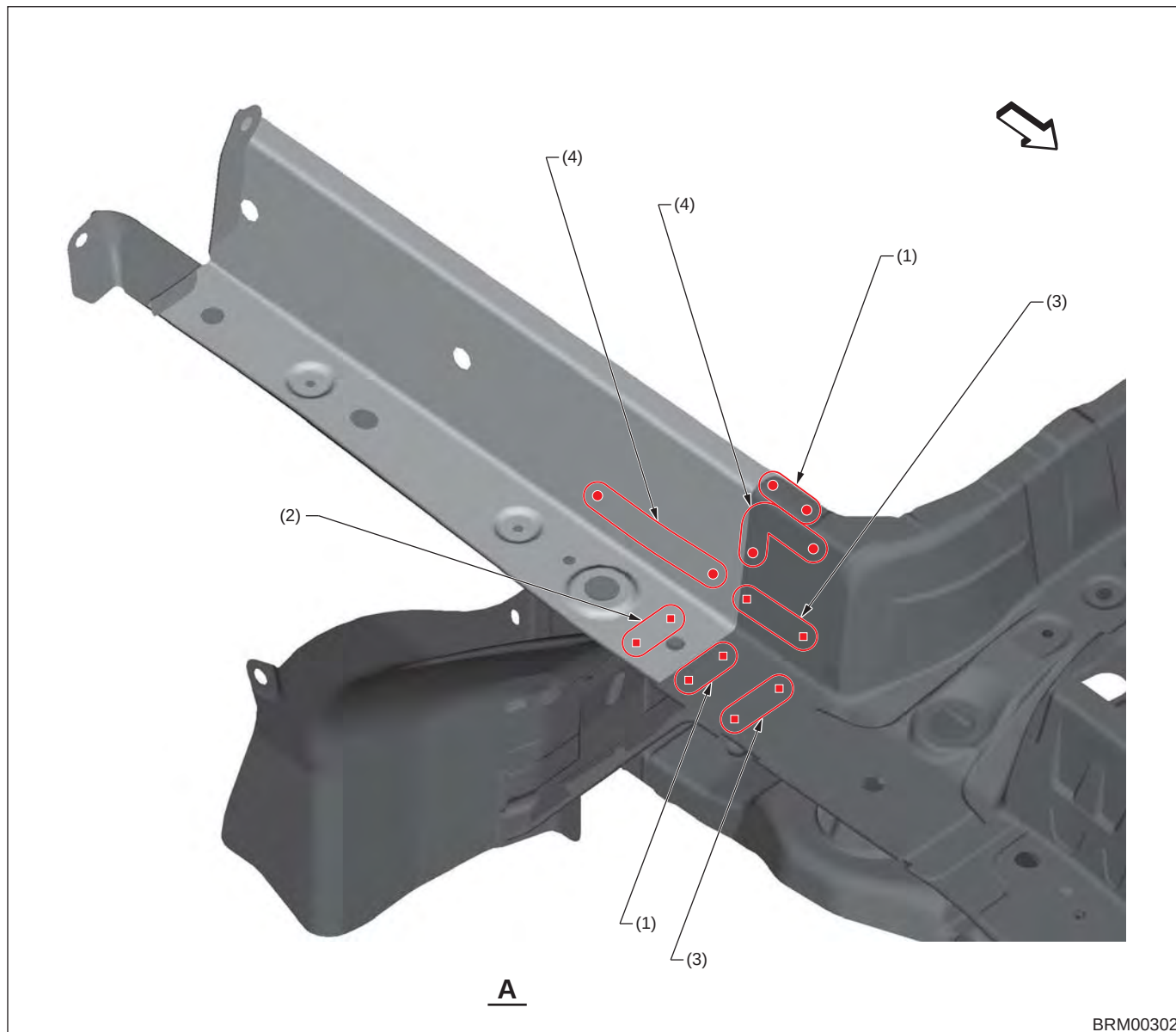
- (1) 3 points
- (2) 2 points

- (3) 1 point (service)

- (4) 2 points (service · matching)

Panel Replacement

• Views A



BRM00302

- (1) 2 points
- (2) 2 points (service)

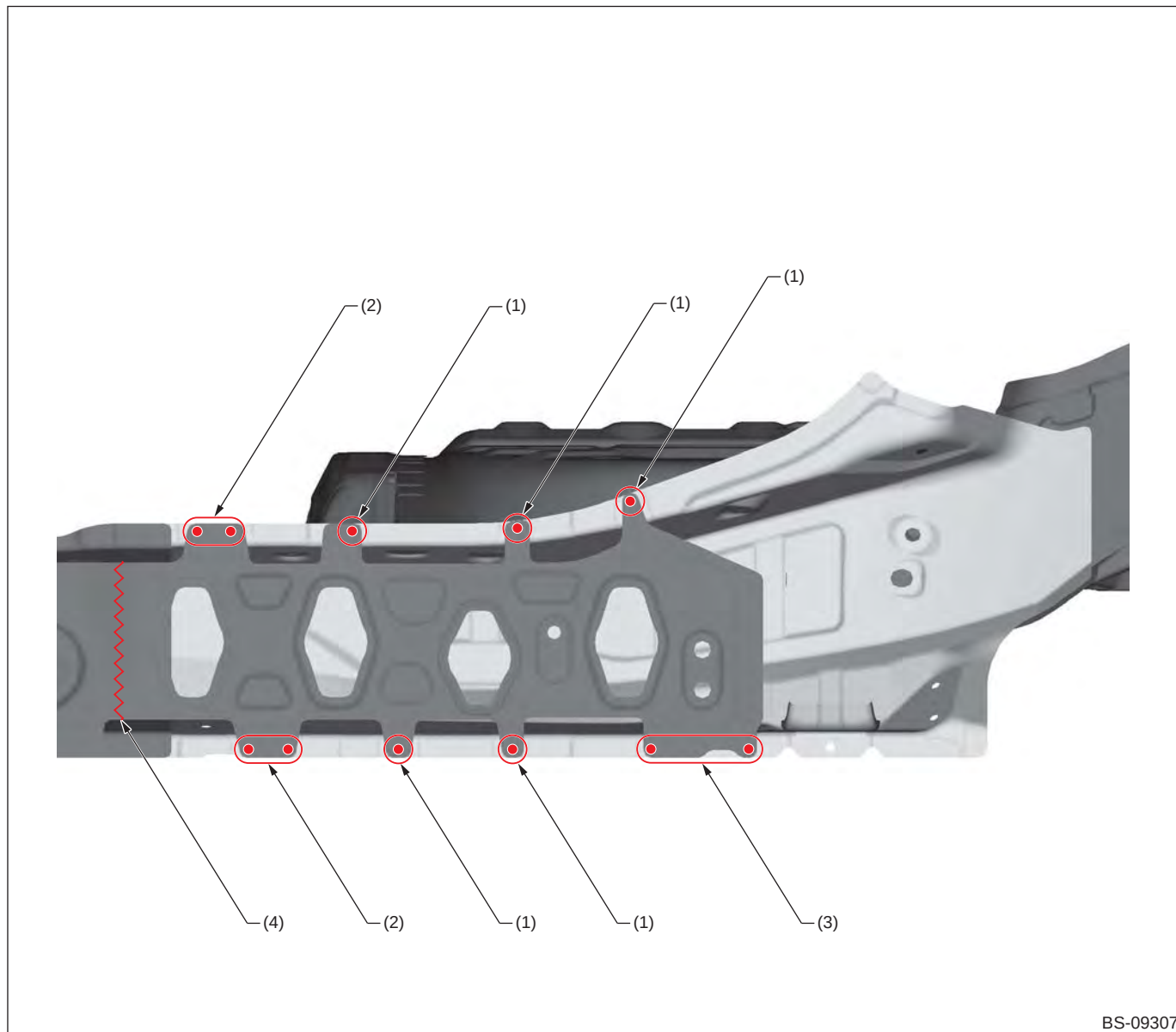
- (3) 2 points (service · matching)

- (4) 3 points

8-34. Side sill inner Rear (Total replacement)

A: REMOVAL

• Overall view 1



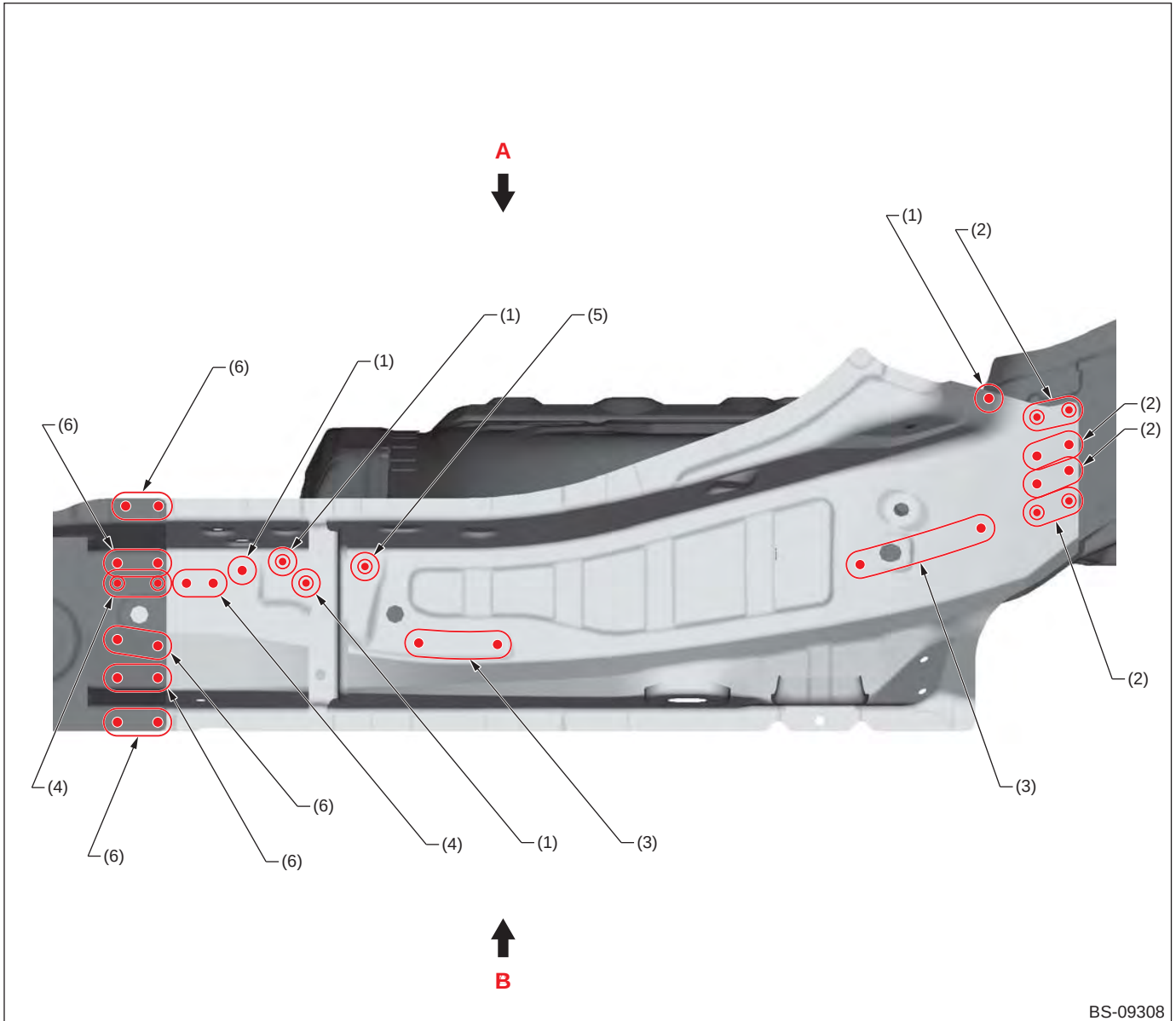
(1) 1 point (outside · 1)
(2) 2 points (outside · 1)

(3) 3 points (outside · 1)

(4) Rough cutting

Panel Replacement

• Overall view 2



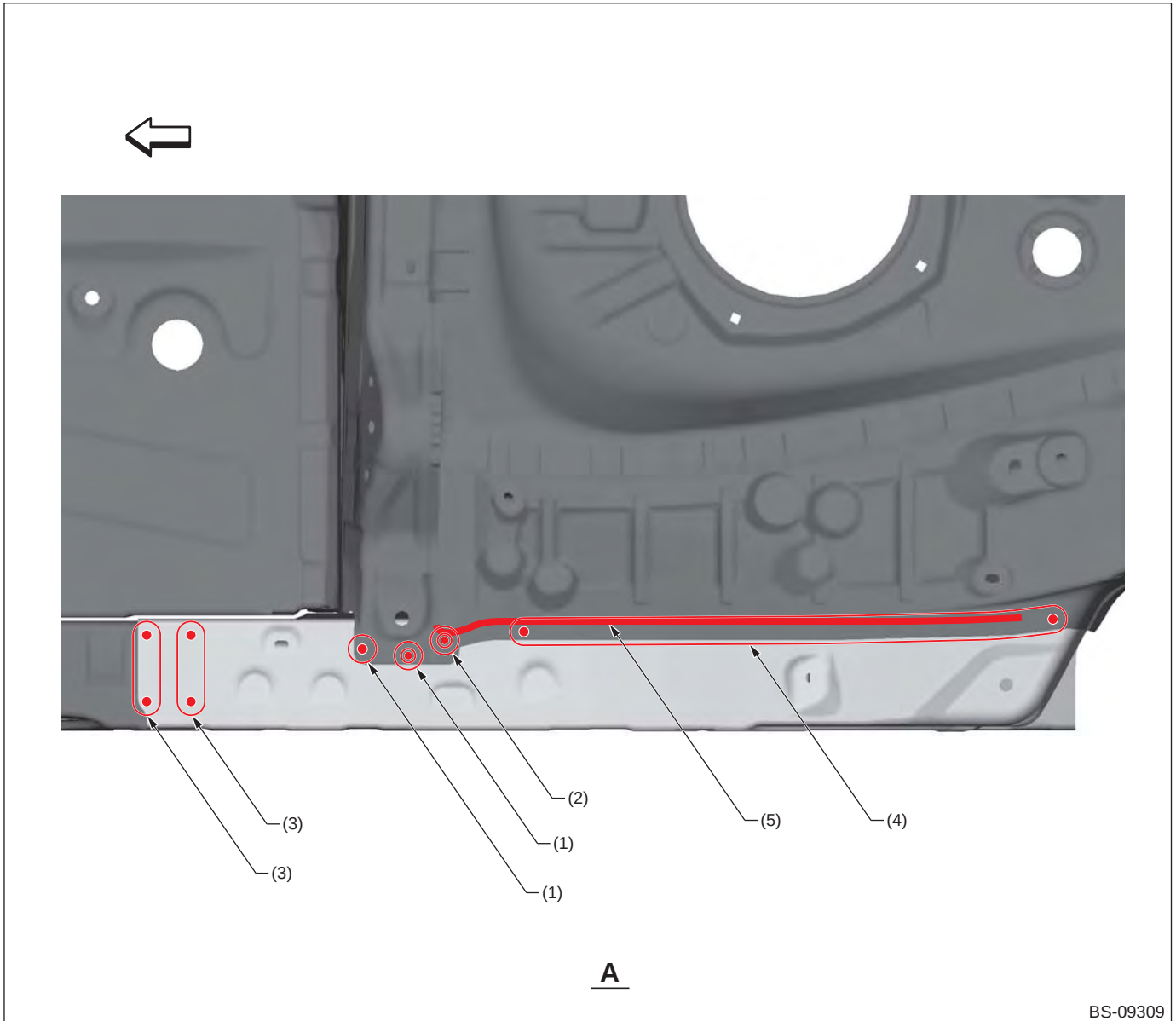
(1) 1 point (outside · 1)
(2) 2 points (outside · 1)

(3) 3 points (outside · 1)
(4) 2 points (outside · 2)

(5) 1 point (outside · 2)
(6) 2 points (inside · 1)

Panel Replacement

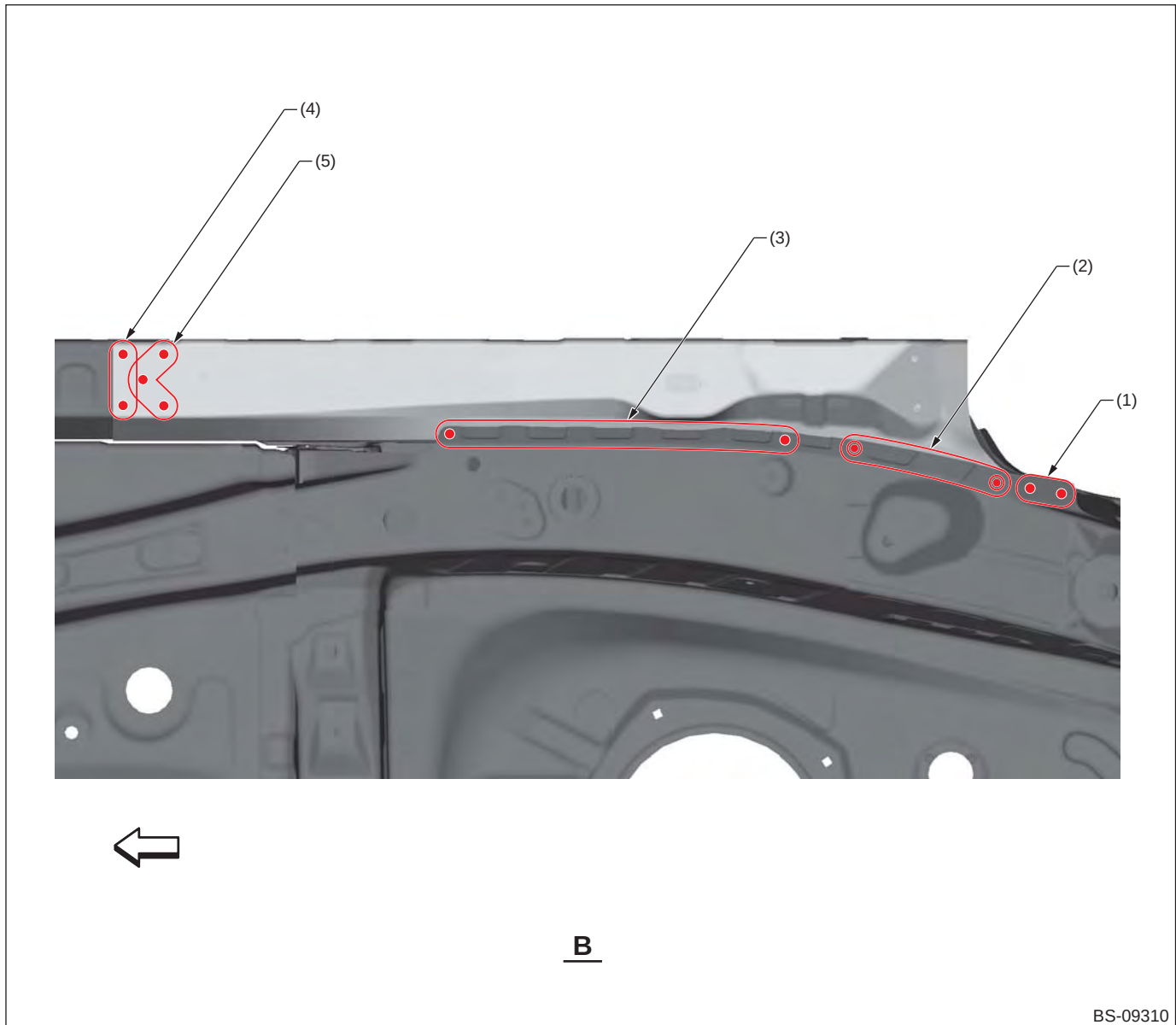
• Views A



- (1) 1 point (top · 1) (3) 2 points (top · 1) (5) Structural adhesive
(2) 1 point (top · 2) (4) 8 points (top · 1)
- : Structural adhesive application location

Panel Replacement

• Views B



(1) 2 points (outside · 1)
(2) 3 points (outside · 1)

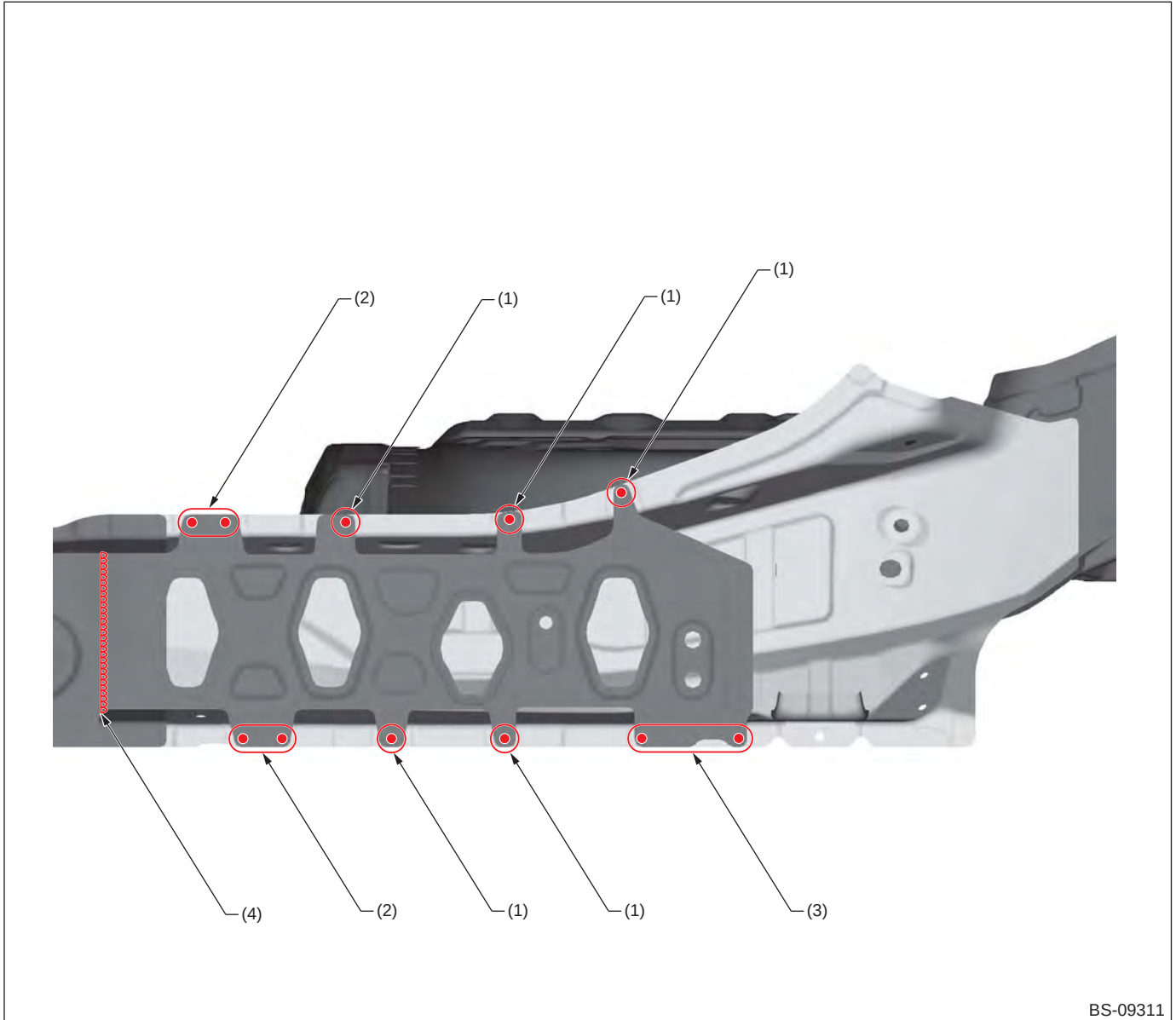
(3) 6 points (outside · 1)
(4) 2 points (bottom · 1)

(5) 3 points (bottom · 1)

Panel Replacement

B: INSTALLATION

• Overall view 1



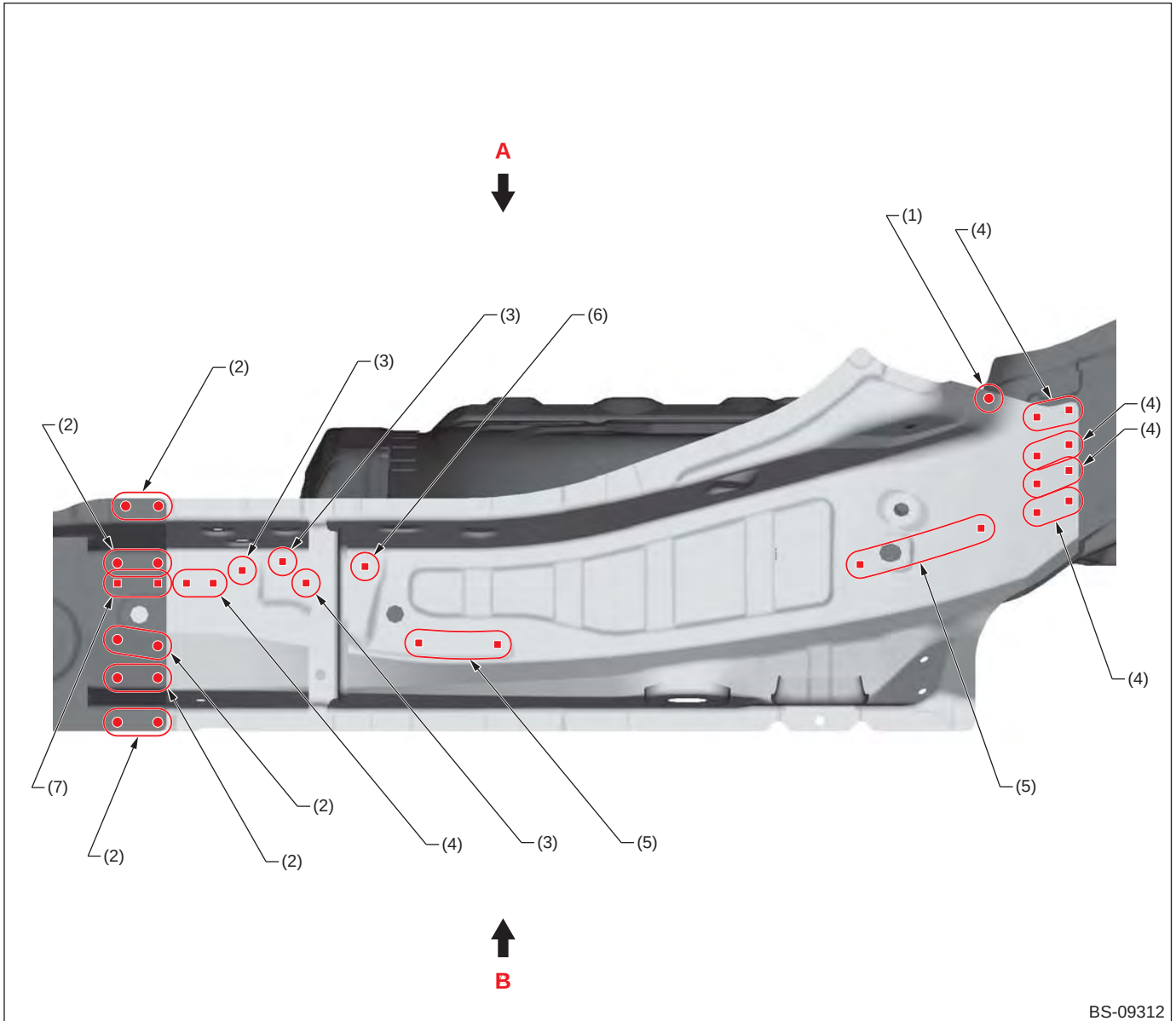
- (1) 1 point
- (2) 2 points

- (3) 3 points

- (4) 1 point (Continuous welding)

Panel Replacement

• Overall view 2

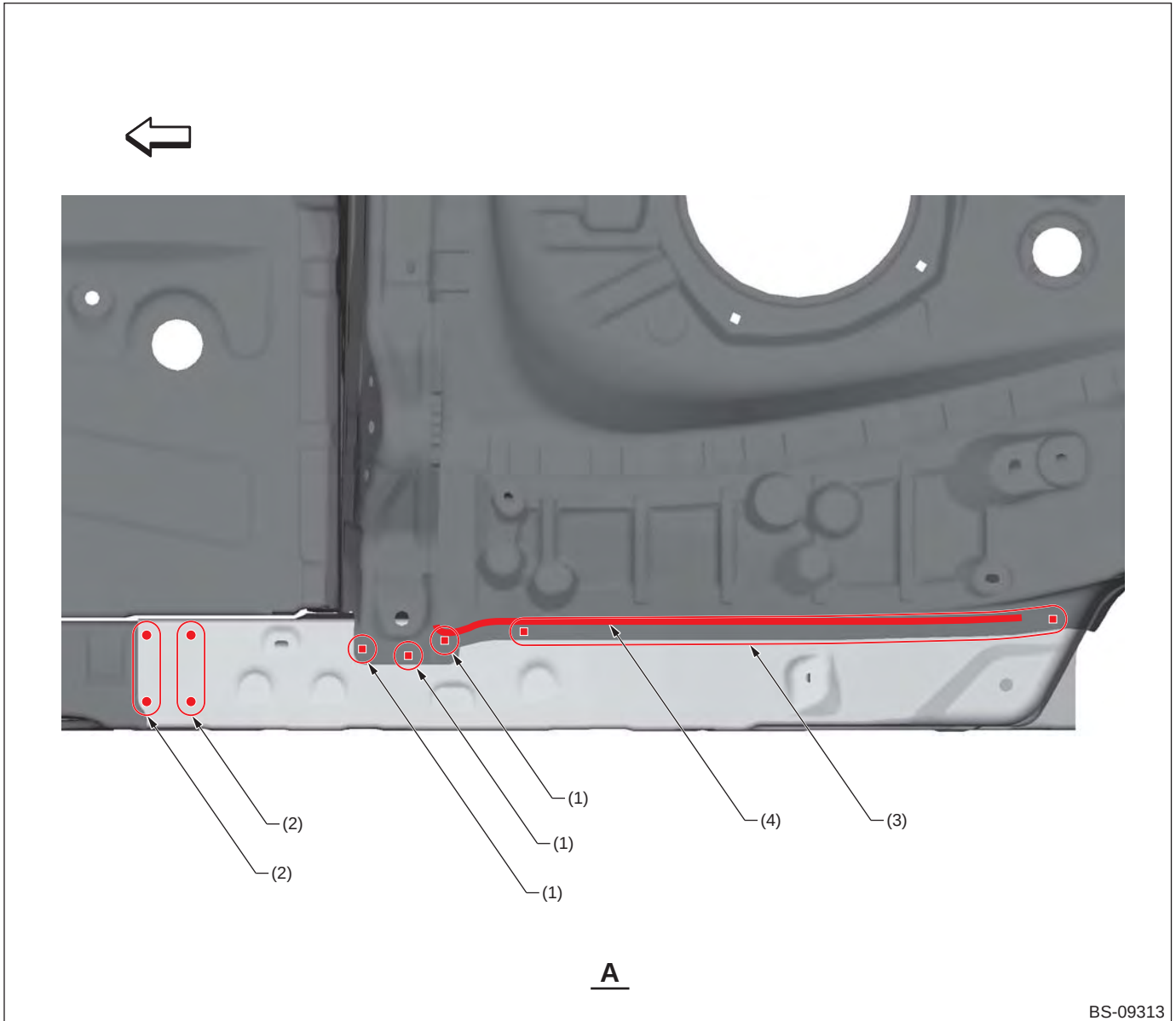


BS-09312

- | | | |
|-----------------------|----------------------------------|-----------------------------------|
| (1) 1 point | (4) 2 points (service) | (7) 2 points (service · matching) |
| (2) 2 points | (5) 3 points (service) | |
| (3) 1 point (service) | (6) 1 point (service · matching) | |

Panel Replacement

• Views A



- (1) 1 point
- (2) 2 points

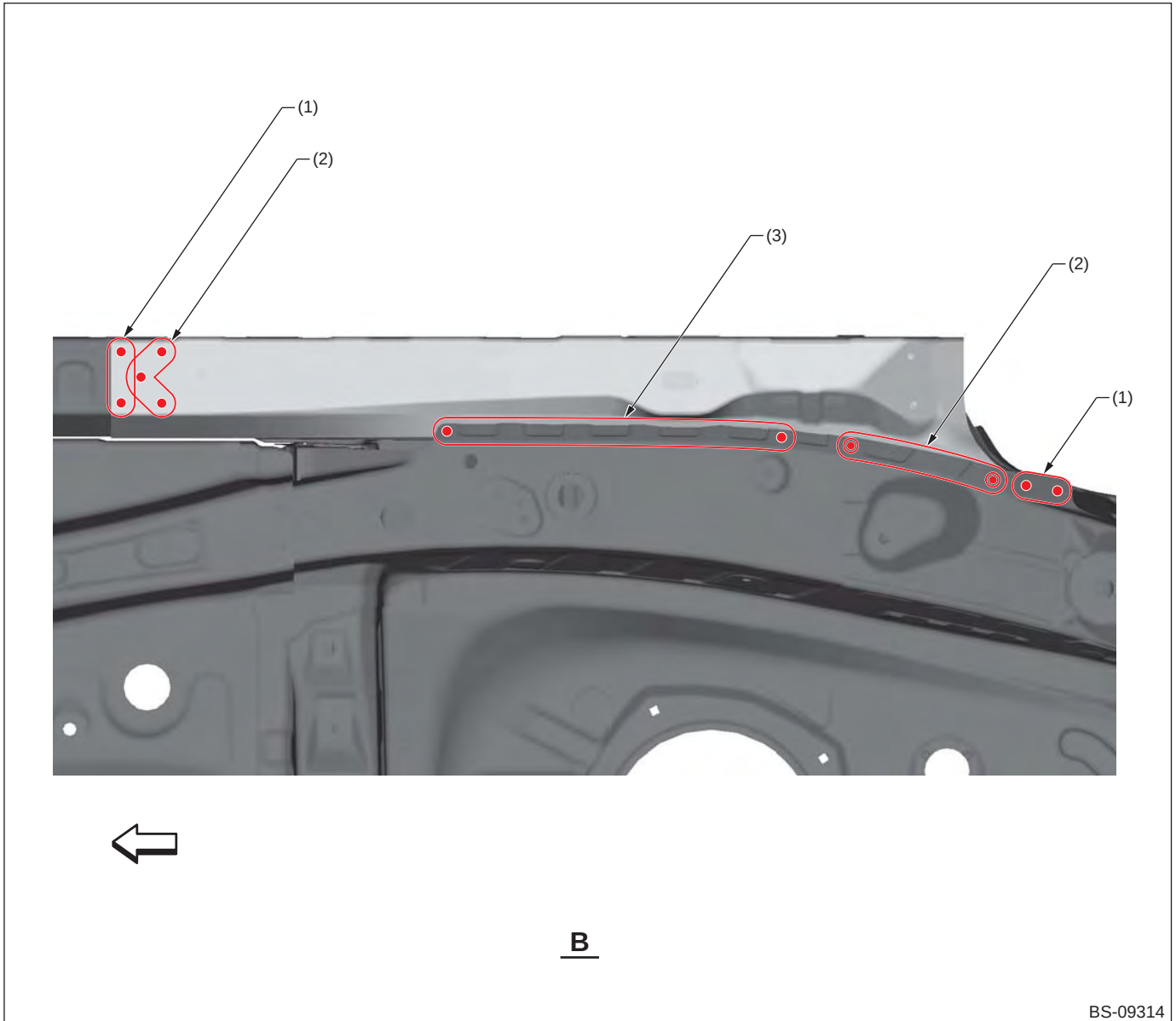
- (3) 8 points

- (4) Structural adhesive

— : Structural adhesive application location

Panel Replacement

• Views B



(1) 2 points

(2) 3 points

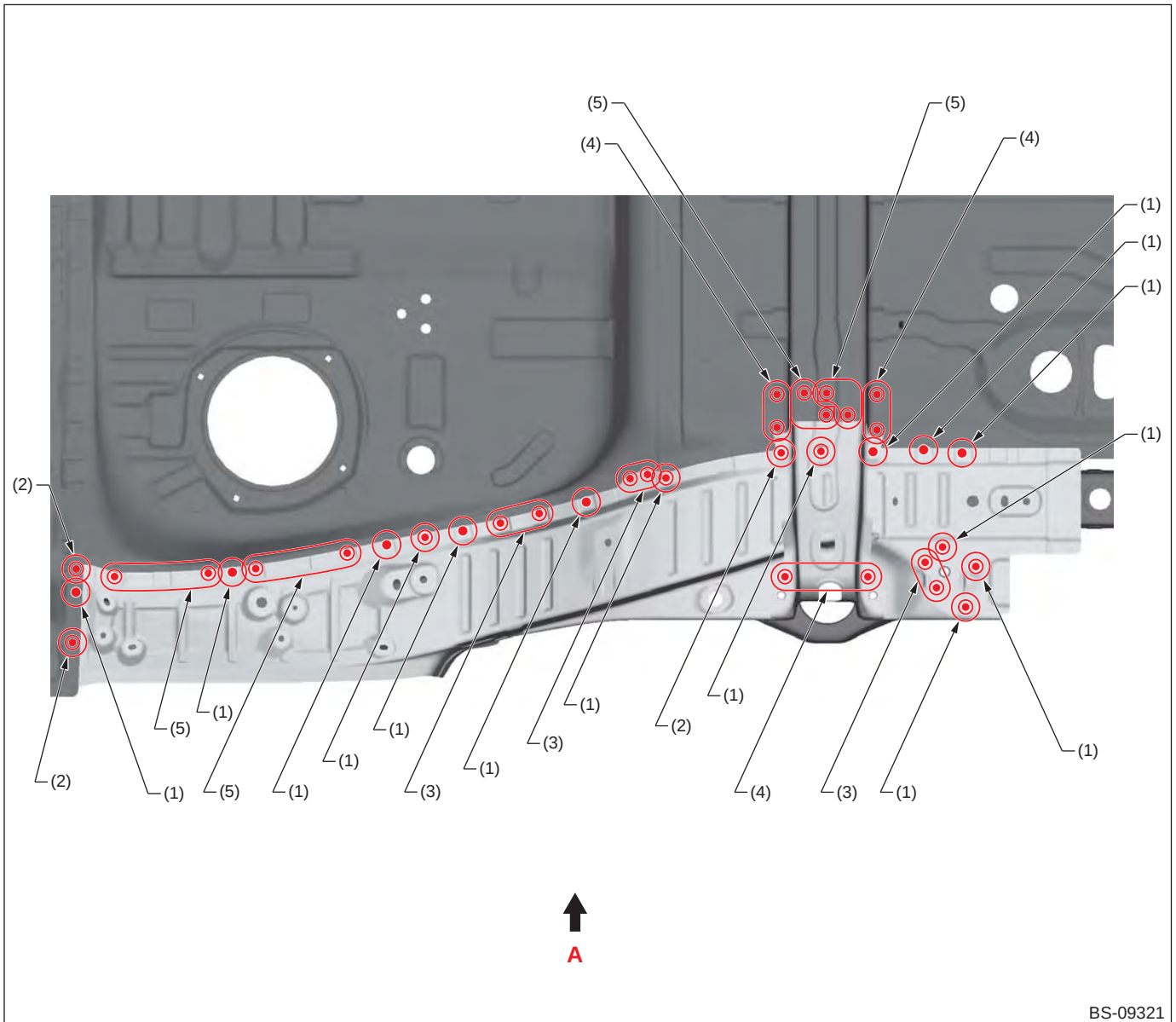
(3) 6 points

Panel Replacement

8-35. Rear Side Frame Upper (Total replacement)

A: REMOVAL

• Overall view



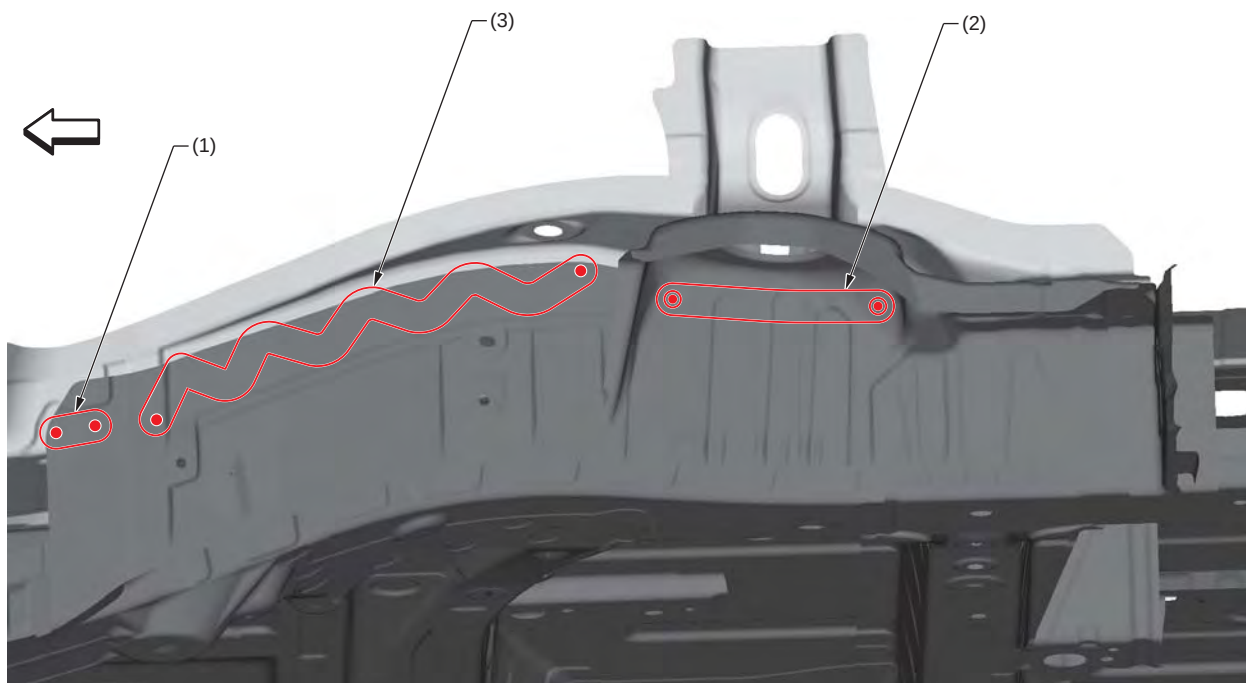
(1) 1 point (top · 1)
(2) 1 point (top · 2)

(3) 2 points (top · 1)
(4) 2 points (top · 2)

(5) 3 points (top · 1)

Panel Replacement

• Views A



A

BS-09322

(1) 2 points (inside · 1)

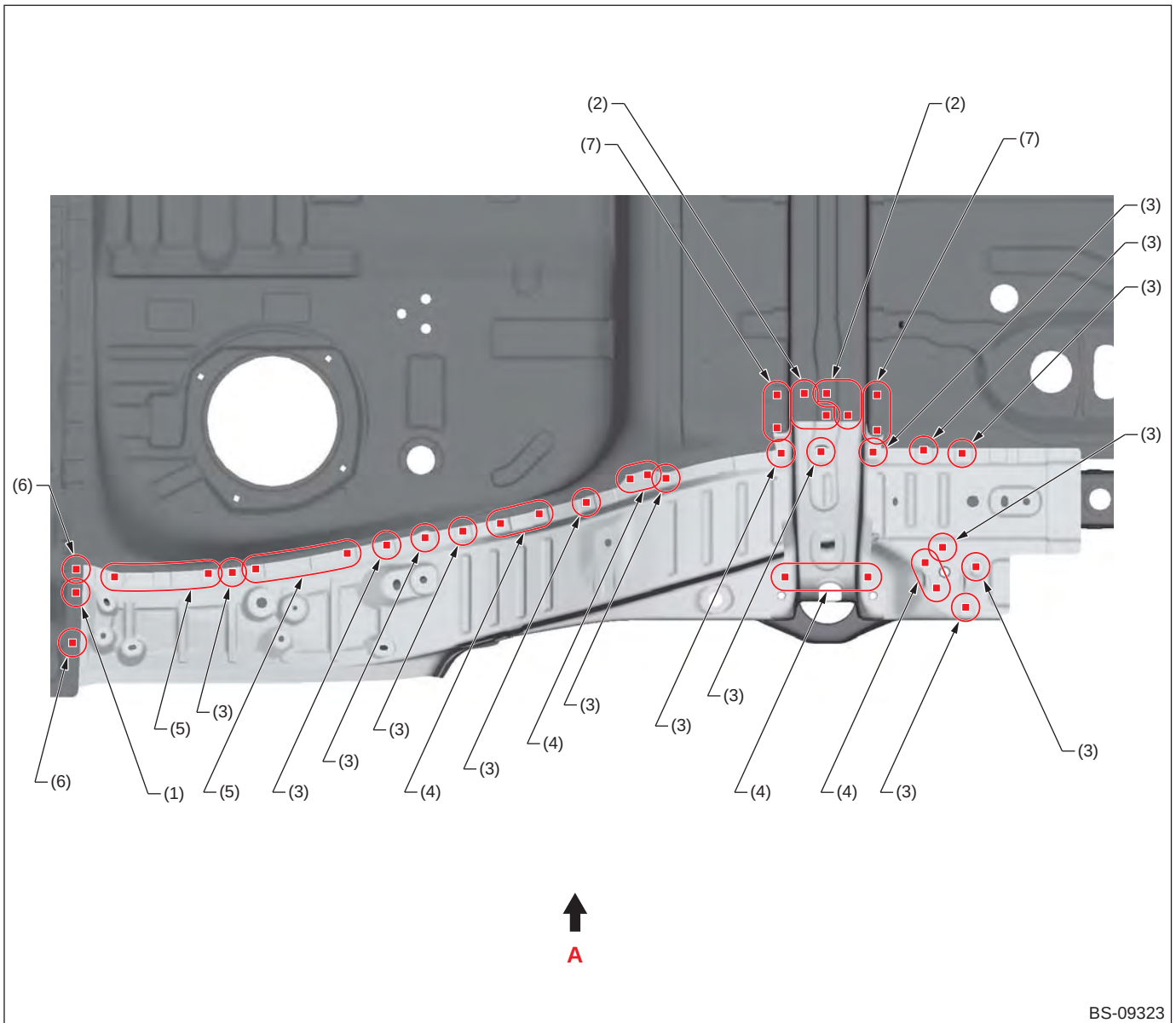
(2) 3 points (outside · 2)

(3) 10 points (outside · 1)

Panel Replacement

B: INSTALLATION

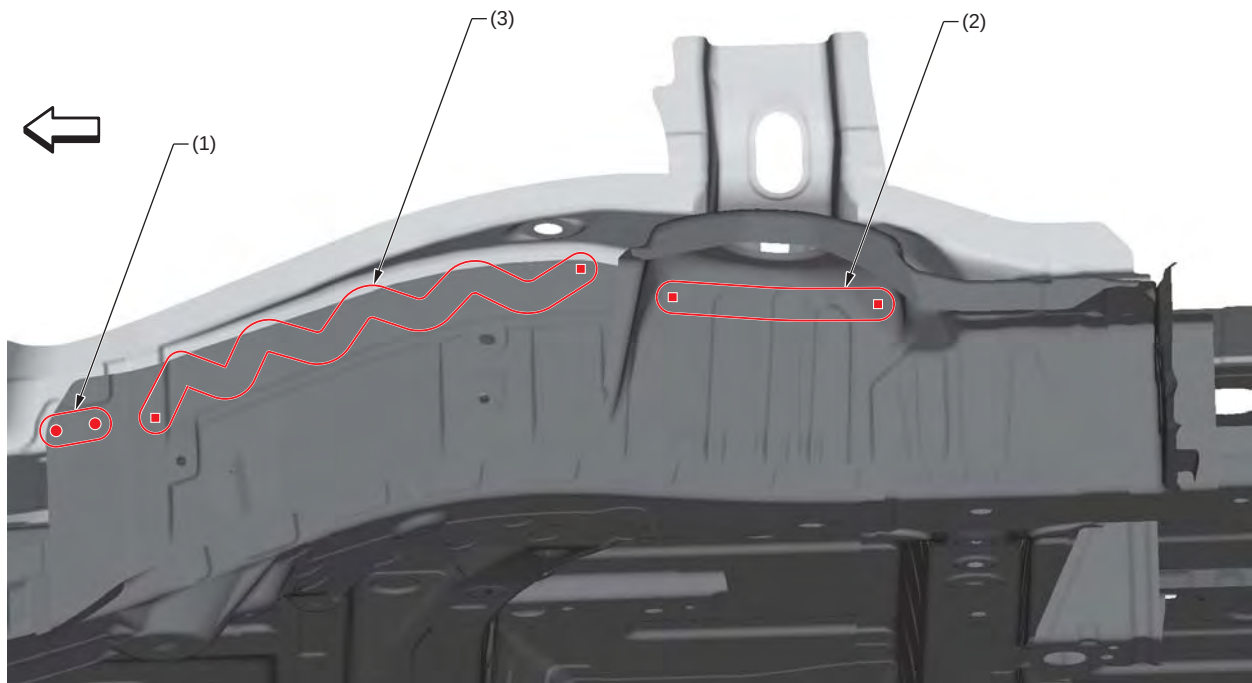
• Overall view



- | | | |
|-----------------------|----------------------------------|-----------------------------------|
| (1) 1 point | (4) 2 points (service) | (7) 2 points (service · matching) |
| (2) 3 points | (5) 3 points (service) | |
| (3) 1 point (service) | (6) 1 point (service · matching) | |

Panel Replacement

• Views A



A

BS-09324

(1) 2 points

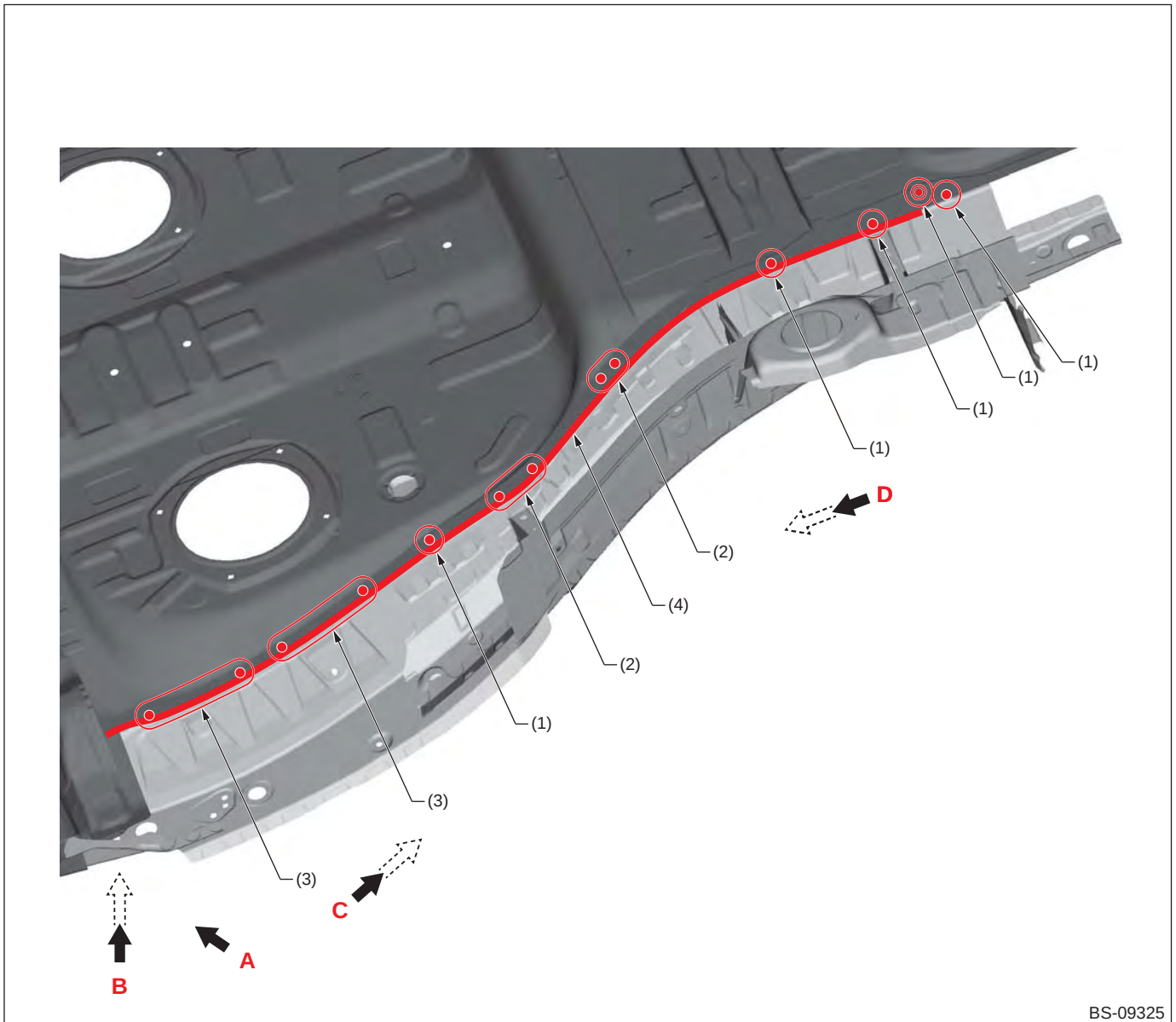
(2) 3 points (service)

(3) 10 points (service)

8-36. Rear Side Frame (Total replacement)

A: REMOVAL

• Overall view



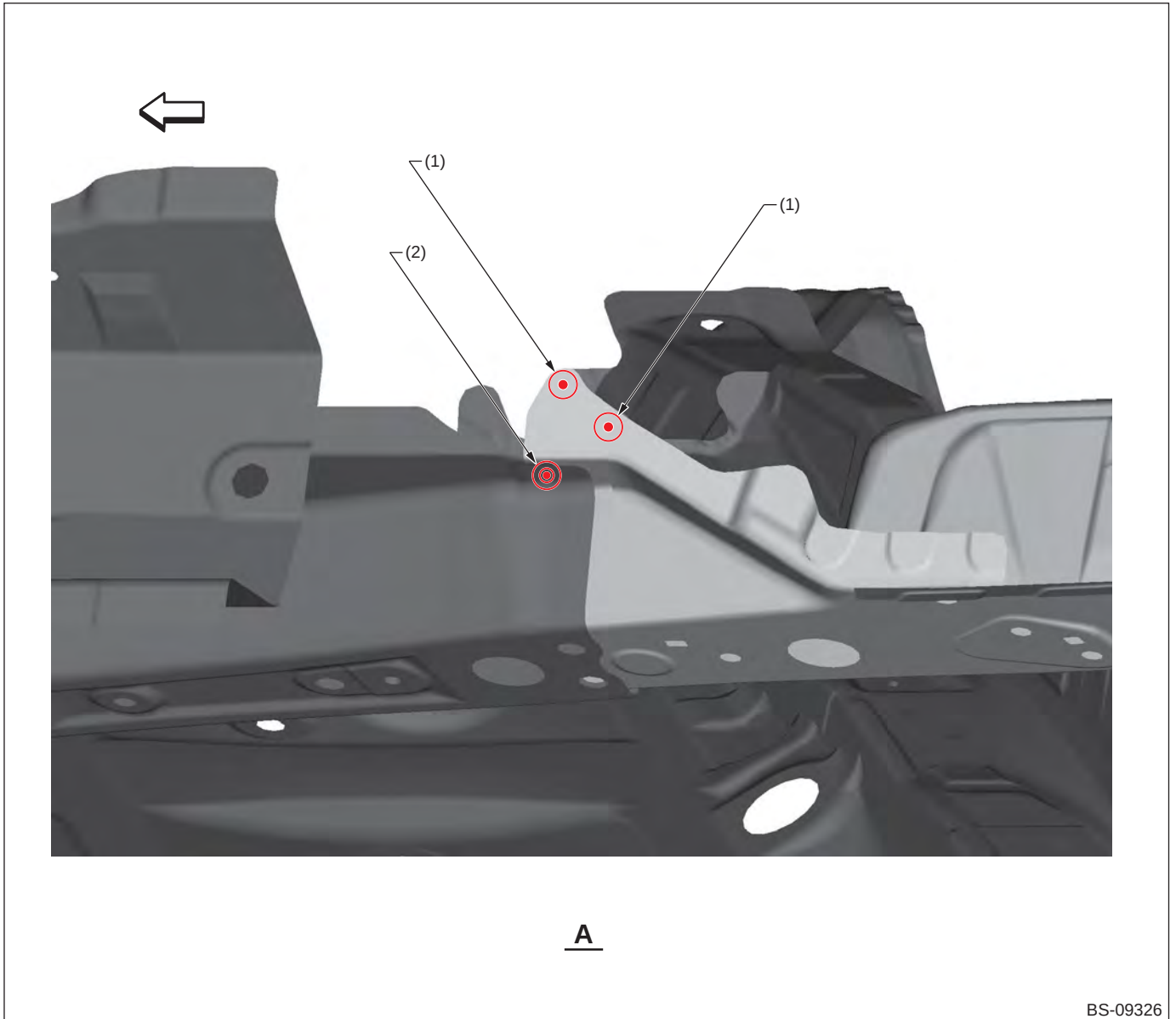
BS-09325

- (1) 1 point (top · 1)
- (2) 2 points (top · 1)
- (3) 3 points (top · 1)
- (4) Structural adhesive

— : Structural adhesive application location

Panel Replacement

• Views A

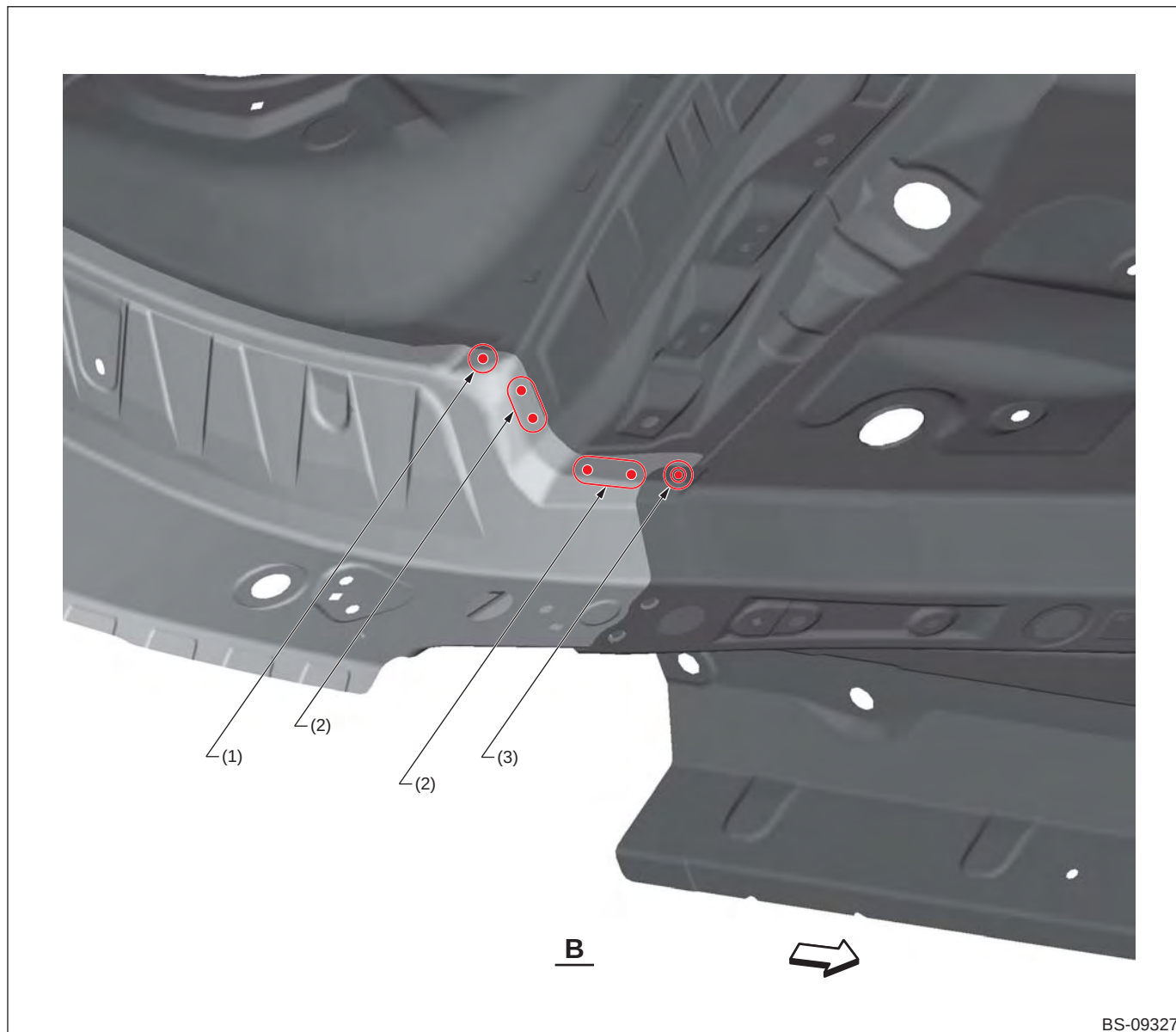


(1) 1 point (outside · 1)

(2) 1 point (top · 2)

Panel Replacement

• Views B



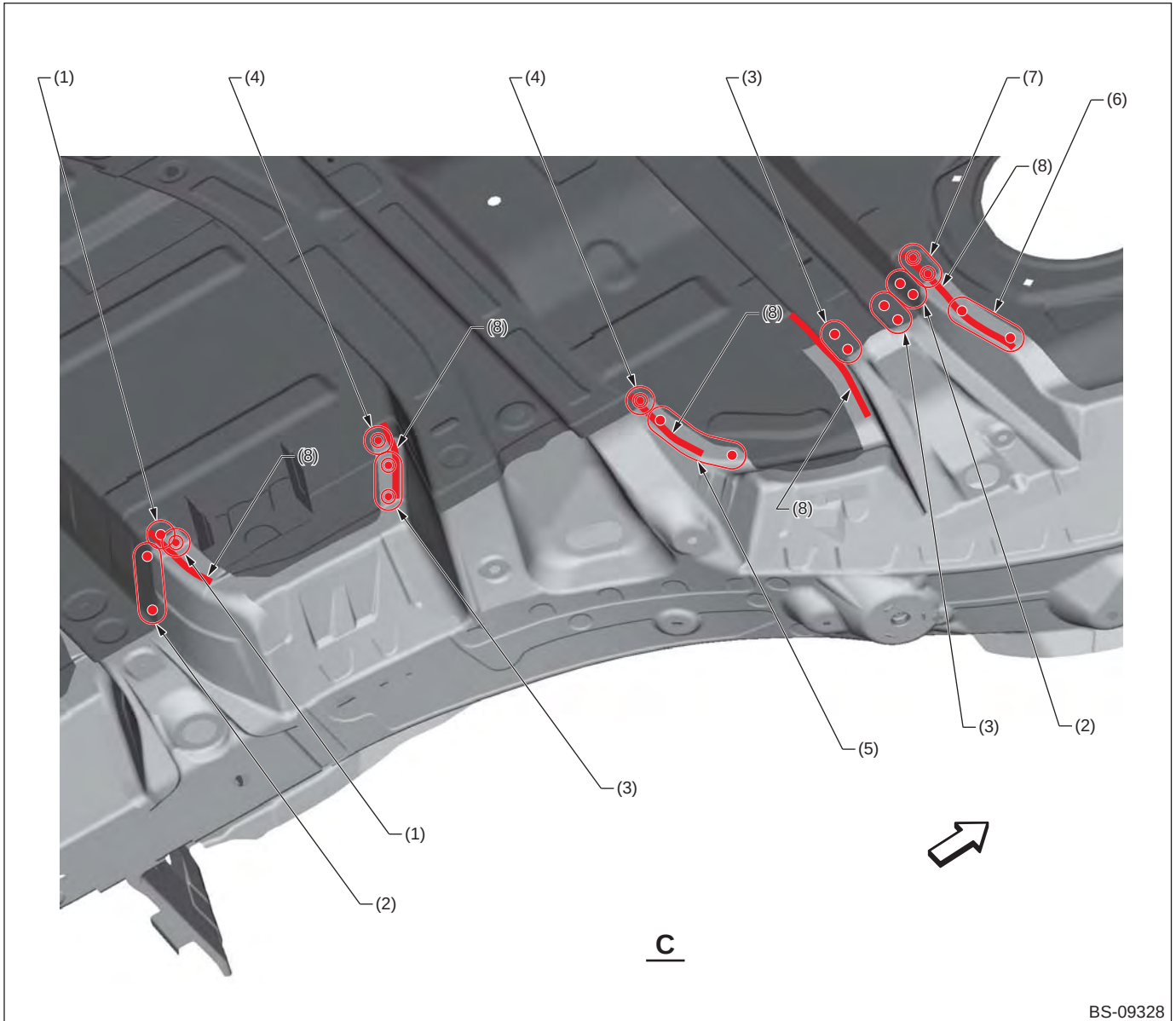
(1) 1 point (bottom · 1)

(2) 2 points (bottom · 1)

(3) 1 point (bottom · 2)

Panel Replacement

• Views C



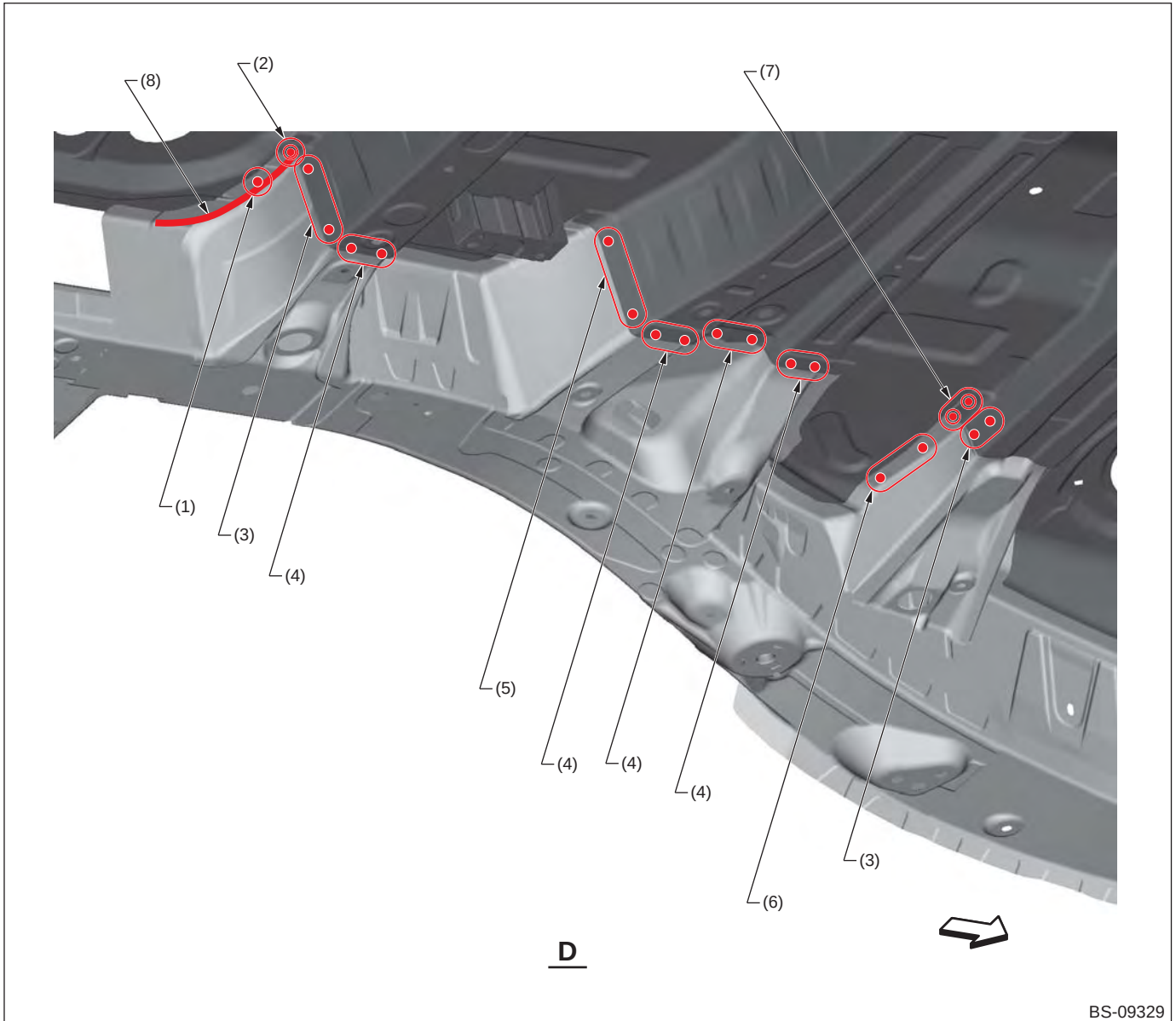
BS-09328

- | | | |
|----------------------------|---------------------------|---------------------------|
| (1) 1 point (bottom · 1) | (4) 1 point (bottom · 2) | (7) 2 points (bottom · 2) |
| (2) 2 points (outside · 1) | (5) 4 points (bottom · 1) | (8) Structural adhesive |
| (3) 2 points (bottom · 1) | (6) 3 points (bottom · 1) | |

— : Structural adhesive application location

Panel Replacement

• Views D



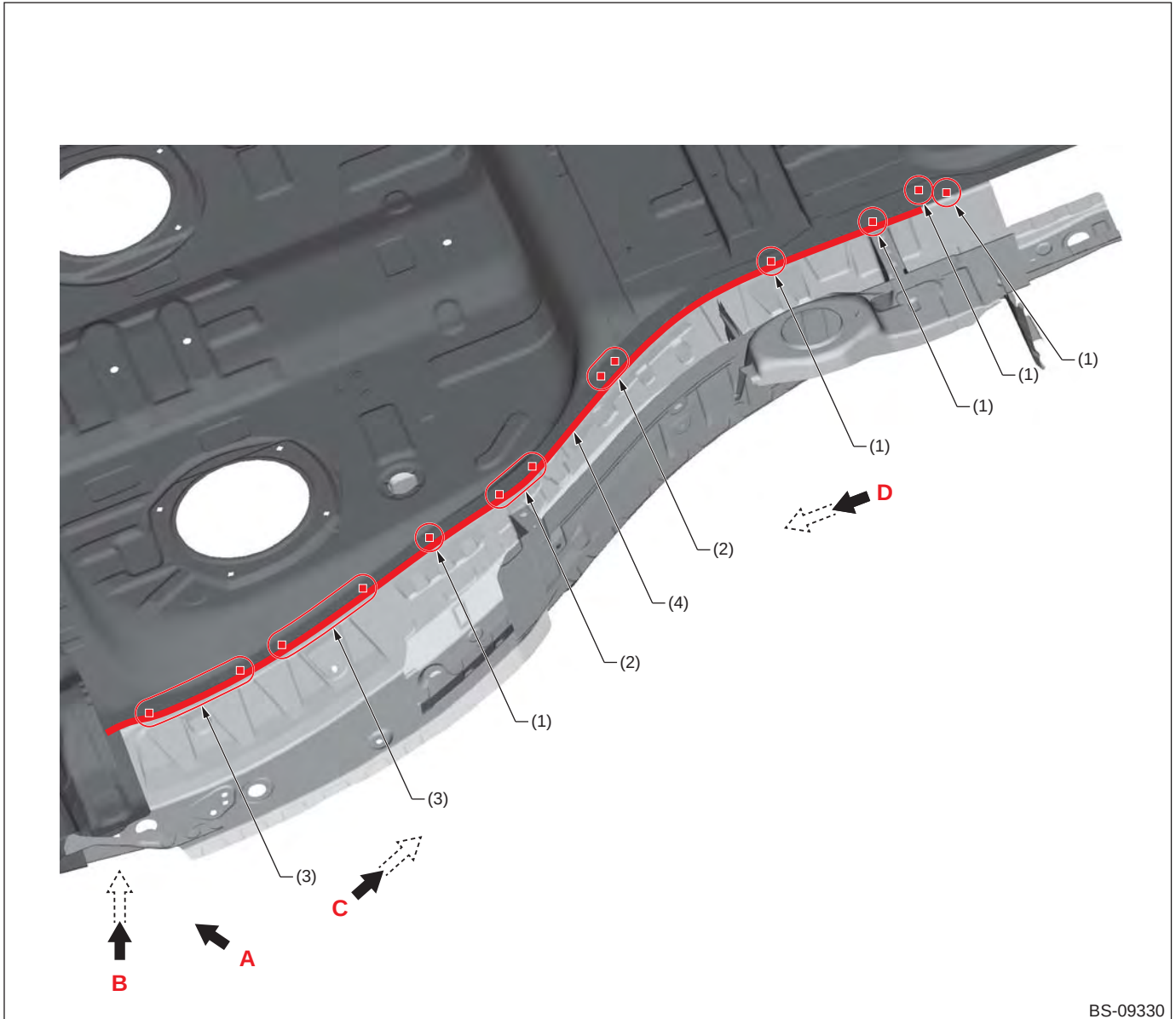
- | | | |
|----------------------------|----------------------------|---------------------------|
| (1) 1 point (bottom · 1) | (4) 2 points (bottom · 1) | (7) 2 points (bottom · 2) |
| (2) 1 point (bottom · 2) | (5) 3 points (outside · 1) | (8) Structural adhesive |
| (3) 2 points (outside · 1) | (6) 3 points (bottom · 1) | |

— : Structural adhesive application location

Panel Replacement

B: INSTALLATION

• Overall view



- (1) 1 point
- (2) 2 points

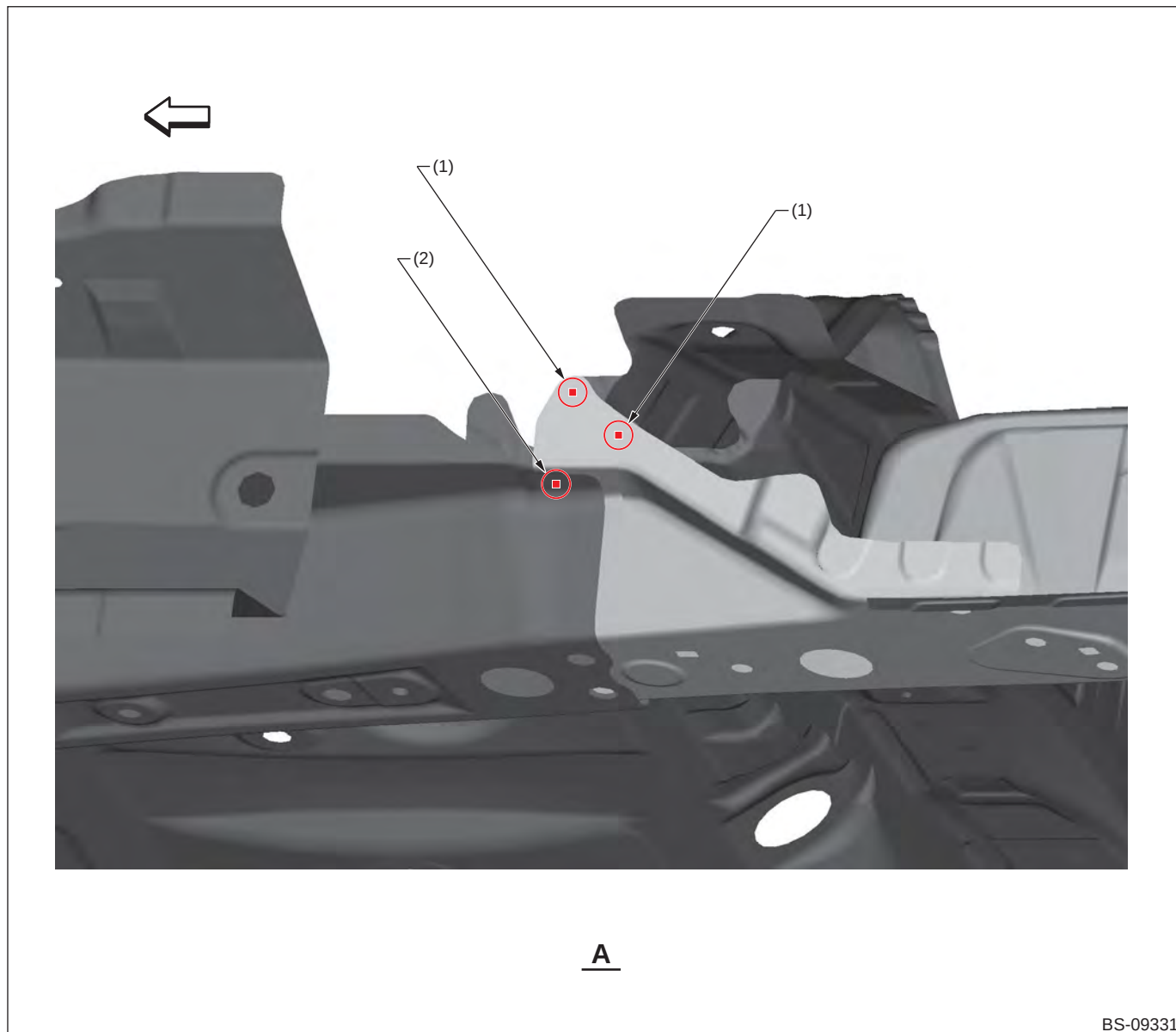
- (3) 3 points

- (4) Structural adhesive

— : Structural adhesive application location

Panel Replacement

• Views A

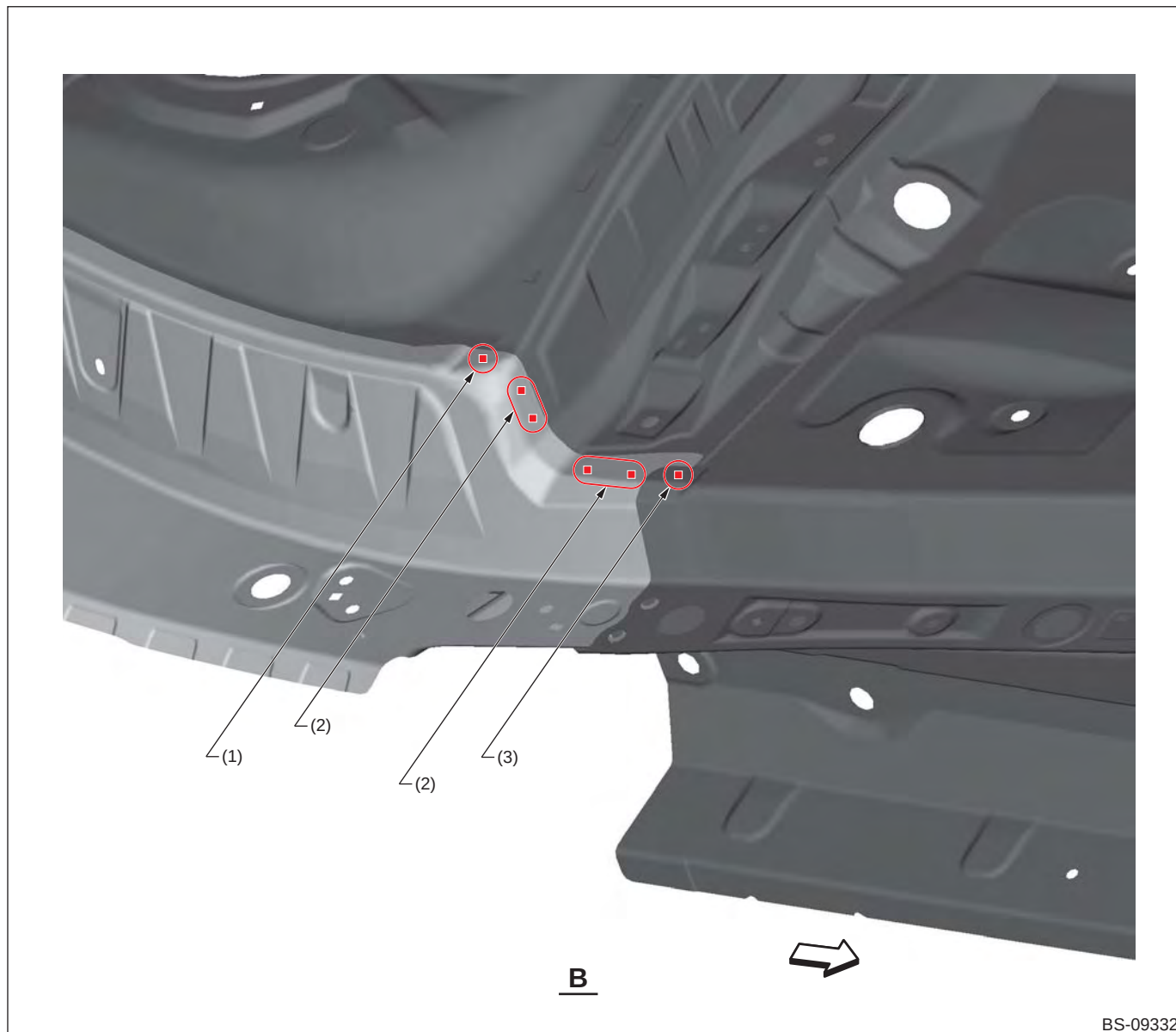


(1) 1 point (service)

(2) 1 point (service · matching)

Panel Replacement

• Views B



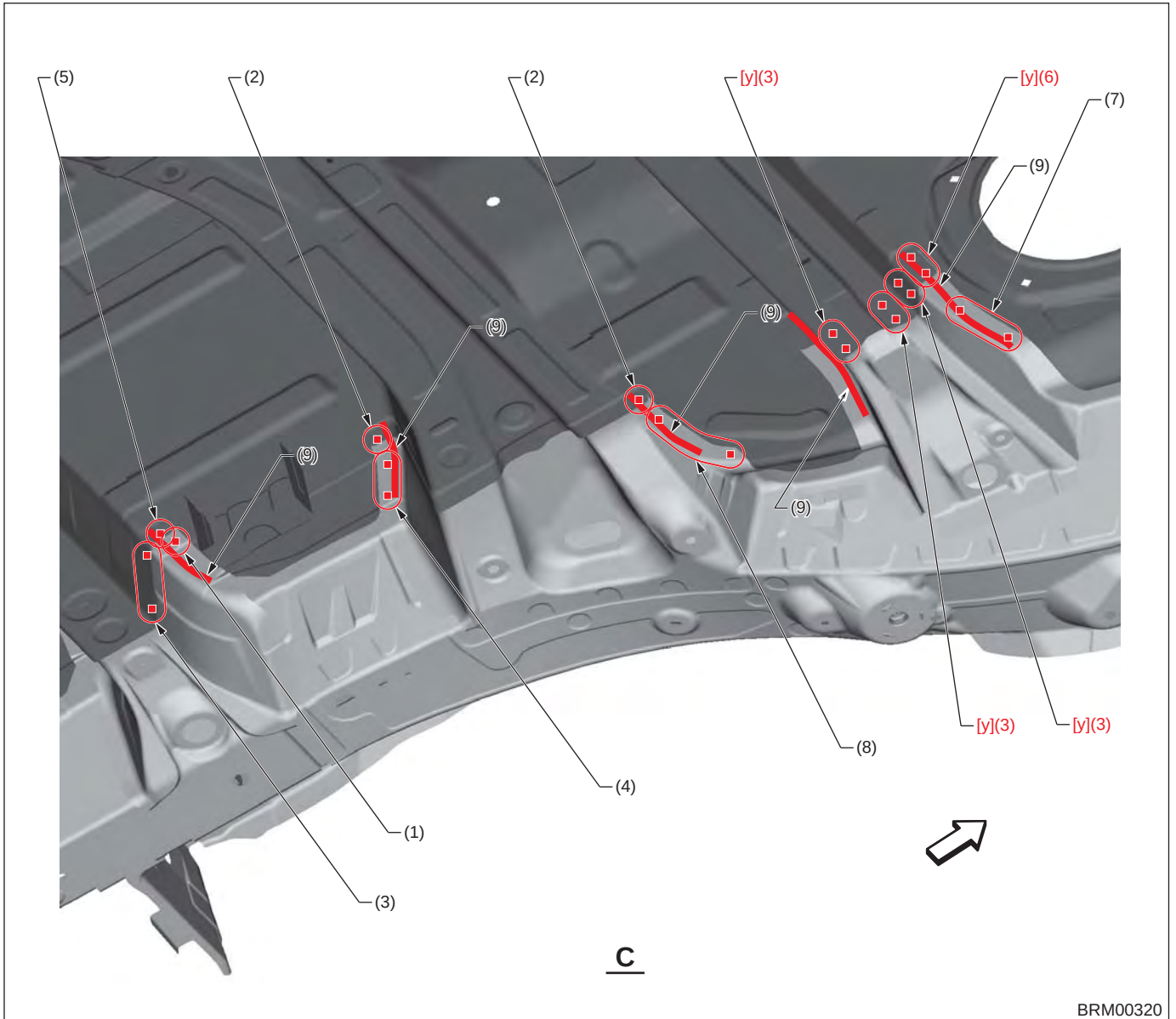
(1) 1 point (service)

(2) 2 points (service)

(3) 3 points (service · matching)

Panel Replacement

• Views C



BRM00320

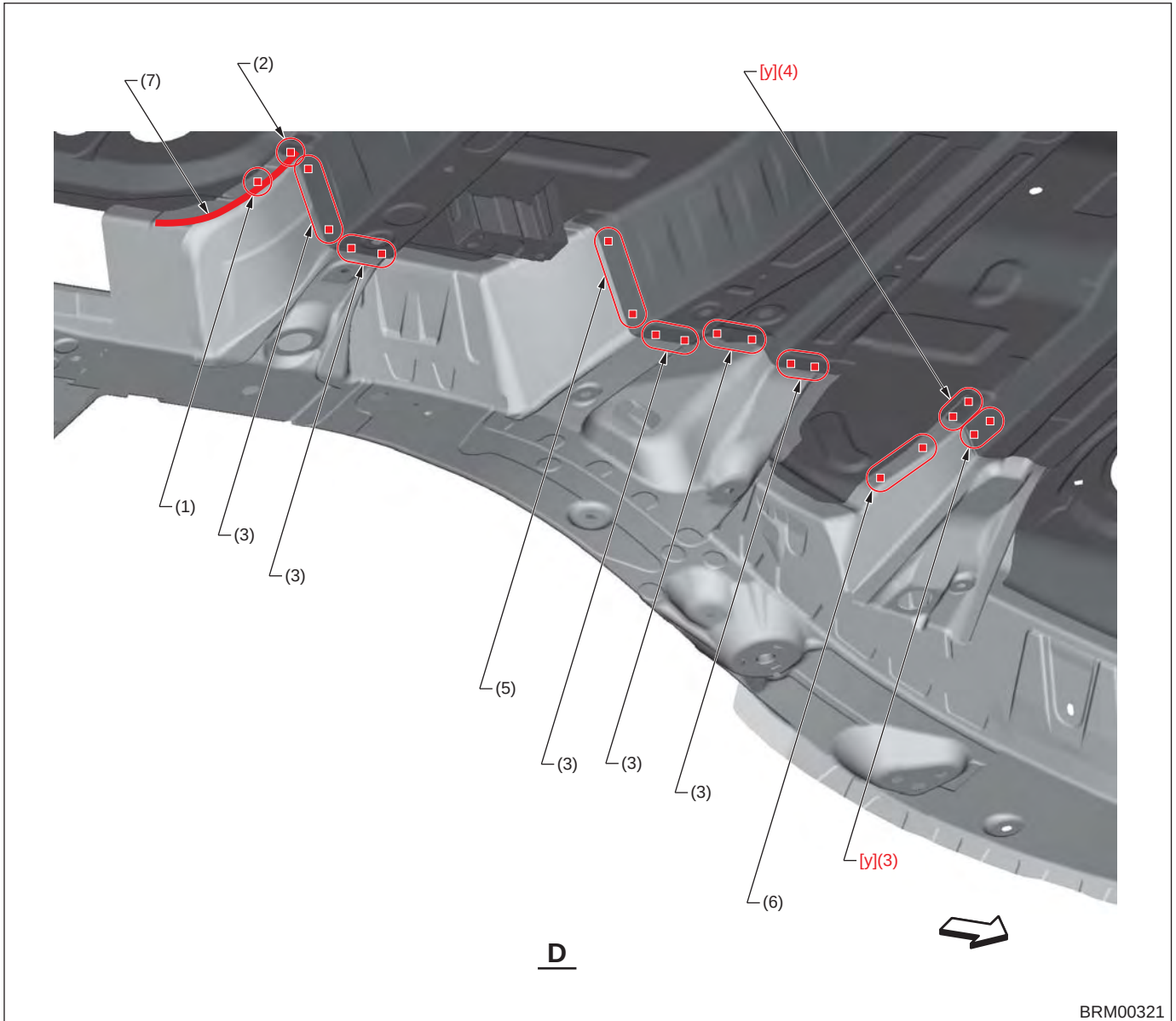
- | | | |
|----------------------------------|-----------------------------------|-------------------------|
| (1) 1 point (service) | (4) 2 points (service) | (7) 3 points (service) |
| (2) 1 point (service · matching) | (5) 1 point | (8) 4 points (service) |
| (3) 2 points | (6) 2 points (service · matching) | (9) Structural adhesive |

— : Structural adhesive application location

[y] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2 B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)
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Panel Replacement

• Views D



- | | | |
|----------------------------------|-----------------------------------|-------------------------|
| (1) 1 point (service) | (4) 2 points (service · matching) | (7) Structural adhesive |
| (2) 1 point (service · matching) | (5) 3 points | |
| (3) 2 points | (6) 3 points (service) | |

— : Structural adhesive application location

[y] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2 B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)
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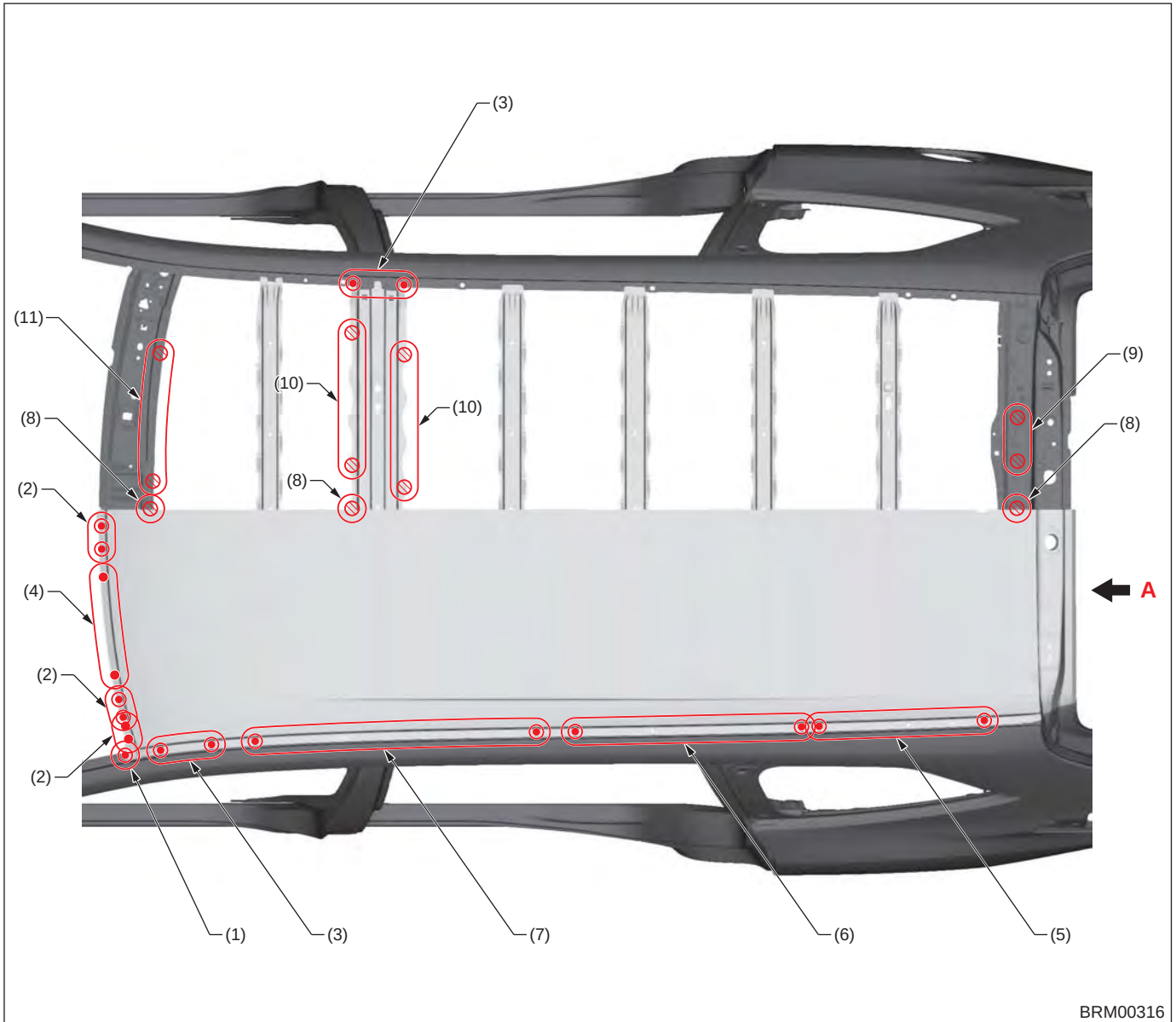
Panel Replacement

8-37. Roof panel (Total replacement)

Model without sunroof

A: REMOVAL

• Overall view



- (1) 1 point (top · 1)
- (2) 2 points (top · 1)
- (3) 3 points (top · 1)
- (4) 6 points (top · 1)

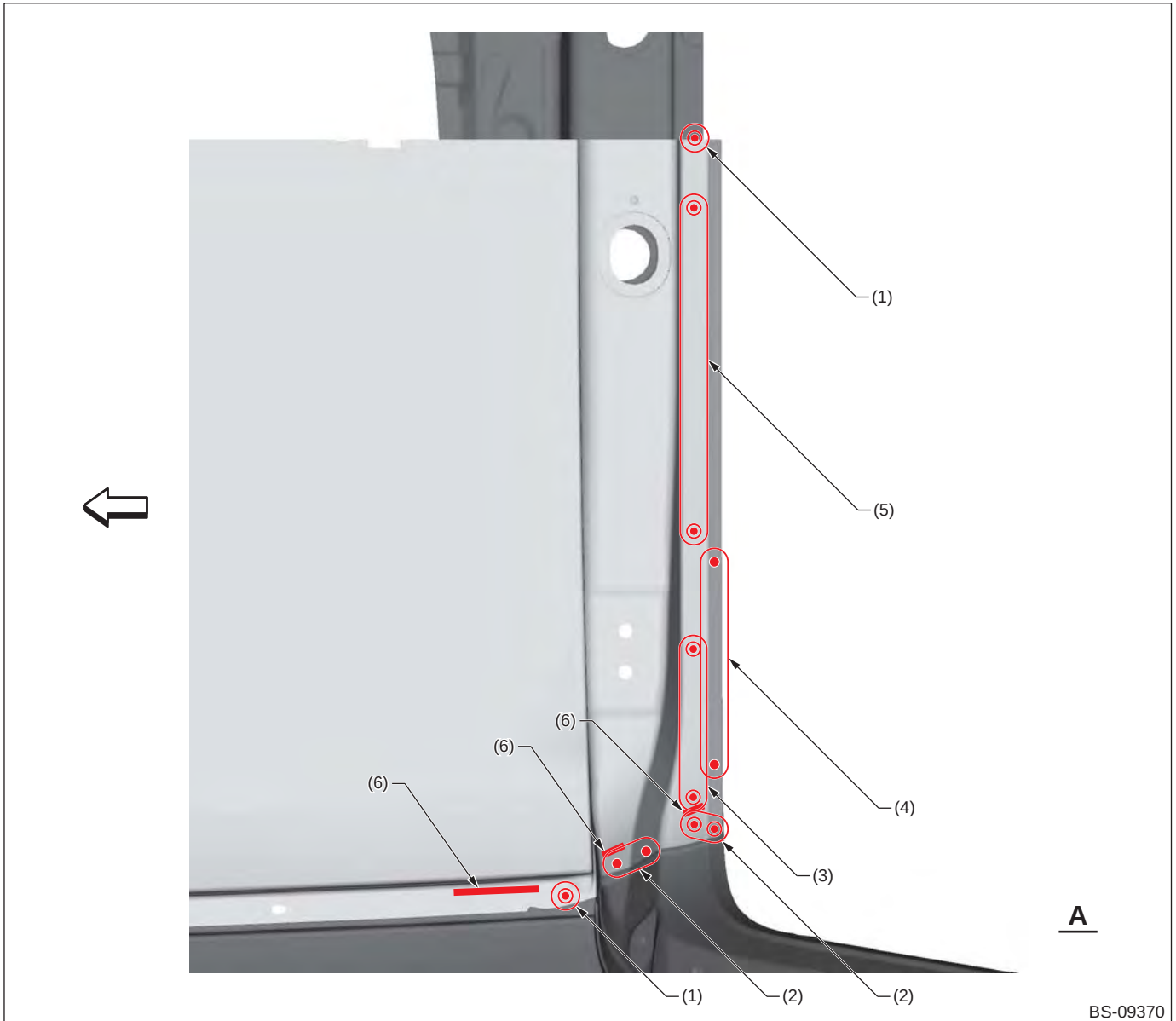
- (5) 7 points (top · 1)
- (6) 8 points (top · 1)
- (7) 10 points (top · 1)
- (8) 1 point

- (9) 2 points
- (10) 4 points
- (11) 5 points

 : Application of adhesive

Panel Replacement

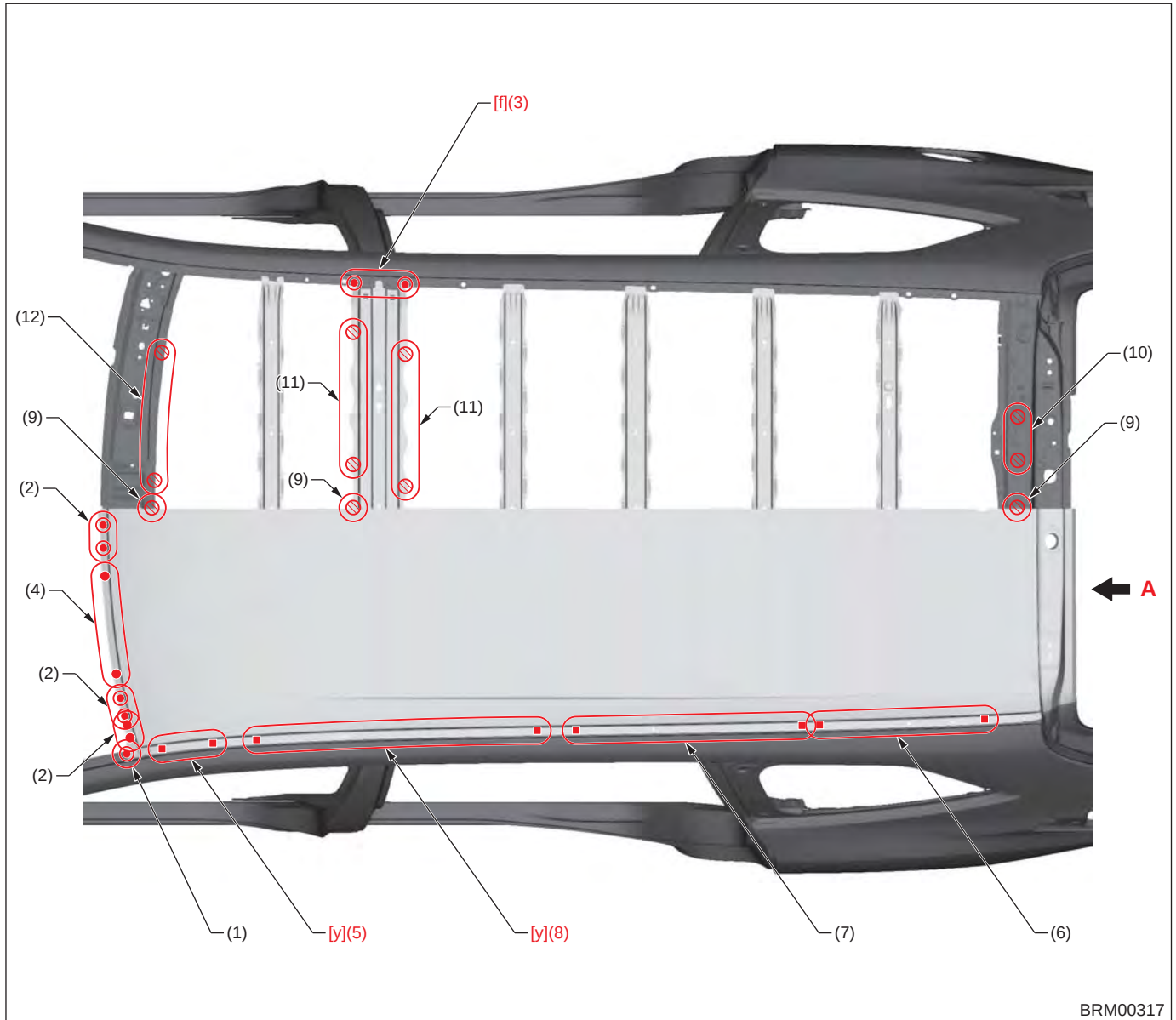
• Views A



Panel Replacement

B: INSTALLATION

• Overall view



BRM00317

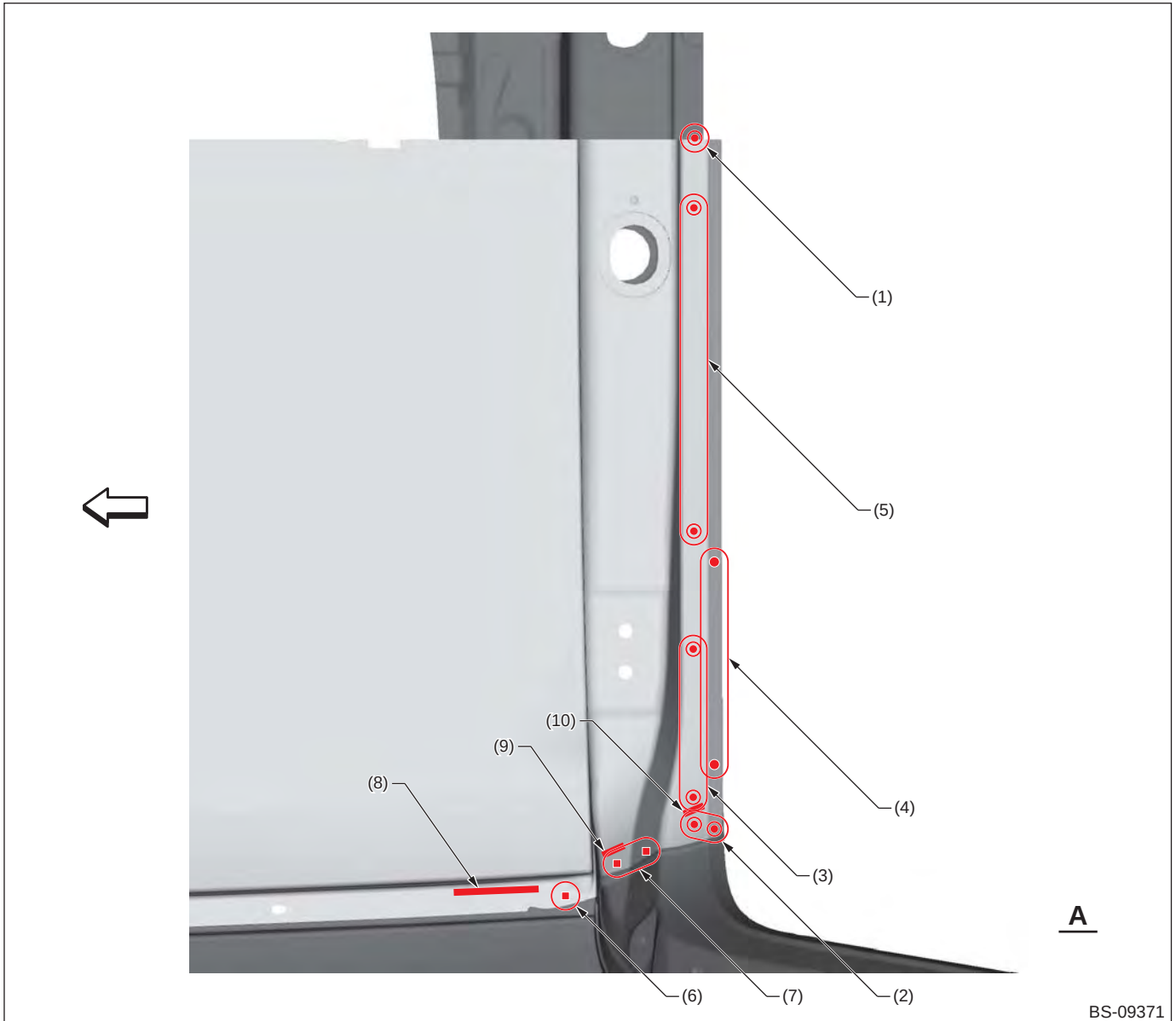
- | | | |
|--------------|-------------------------|---------------|
| (1) 1 point | (5) 3 points (service) | (9) 1 point |
| (2) 2 points | (6) 7 points (service) | (10) 2 points |
| (3) 3 points | (7) 8 points (service) | (11) 4 points |
| (4) 4 points | (8) 10 points (service) | (12) 5 points |

 : Application of adhesive

[f] Spot welding	Compression: 3.5 kN, Current: 8.0 kA, Welding time: 25 cyc
[y] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2 B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

• Views A



- | | | |
|--------------|---|--|
| (1) 1 point | (5) 5 points | (9) Structural adhesive 18 mm [0.71 in] |
| (2) 2 points | (6) 1 point (service) | (10) Structural adhesive 15 mm [0.59 in] |
| (3) 3 points | (7) 2 points (service) | |
| (4) 4 points | (8) Structural adhesive 60 mm [2.36 in] | |

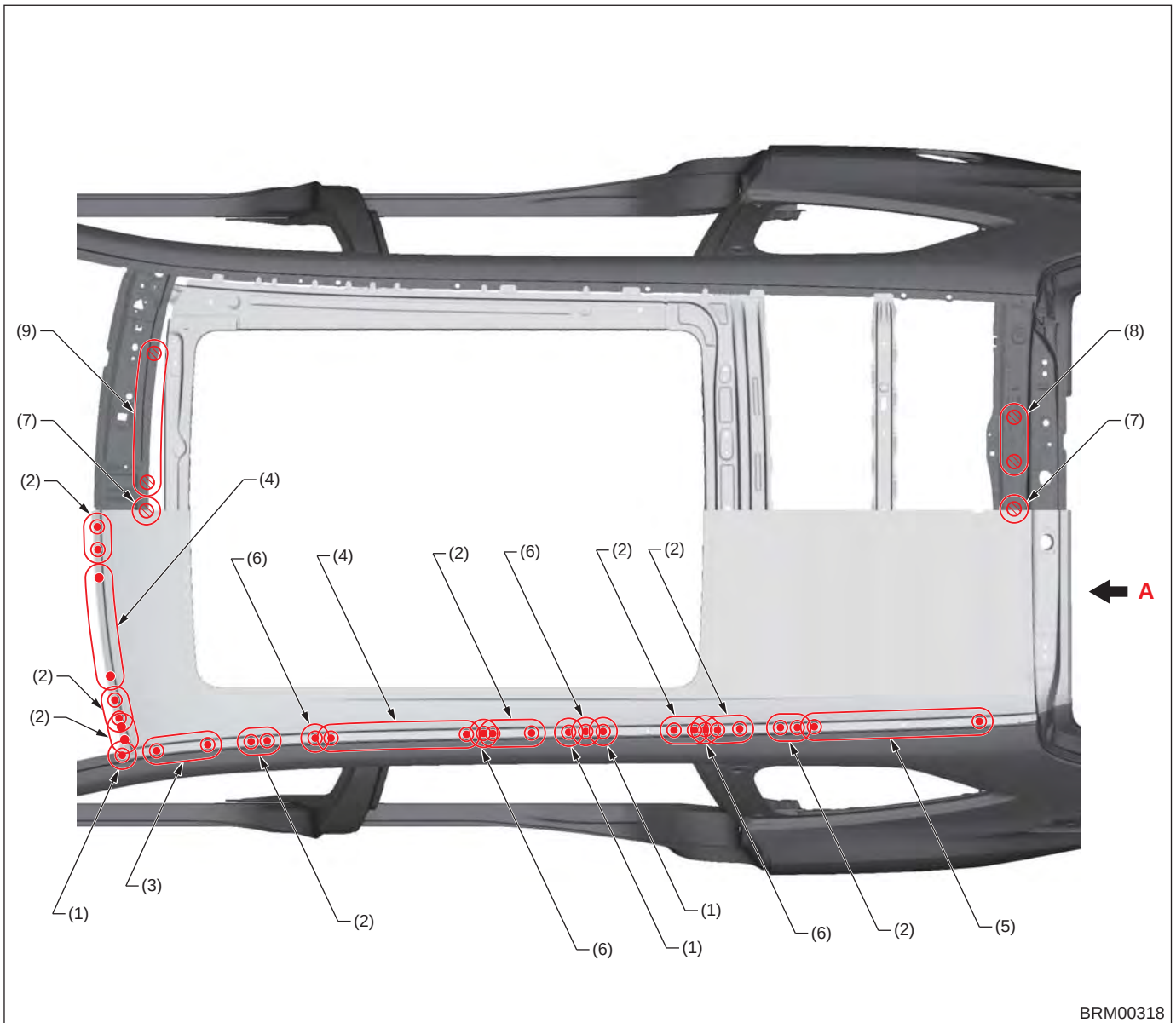
— : Structural adhesive application location

Panel Replacement

Model with sunroof

A: REMOVAL

• Overall view



BRM00318

- (1) 1 point (top · 1)
- (2) 2 points (top · 1)
- (3) 3 points (top · 1)

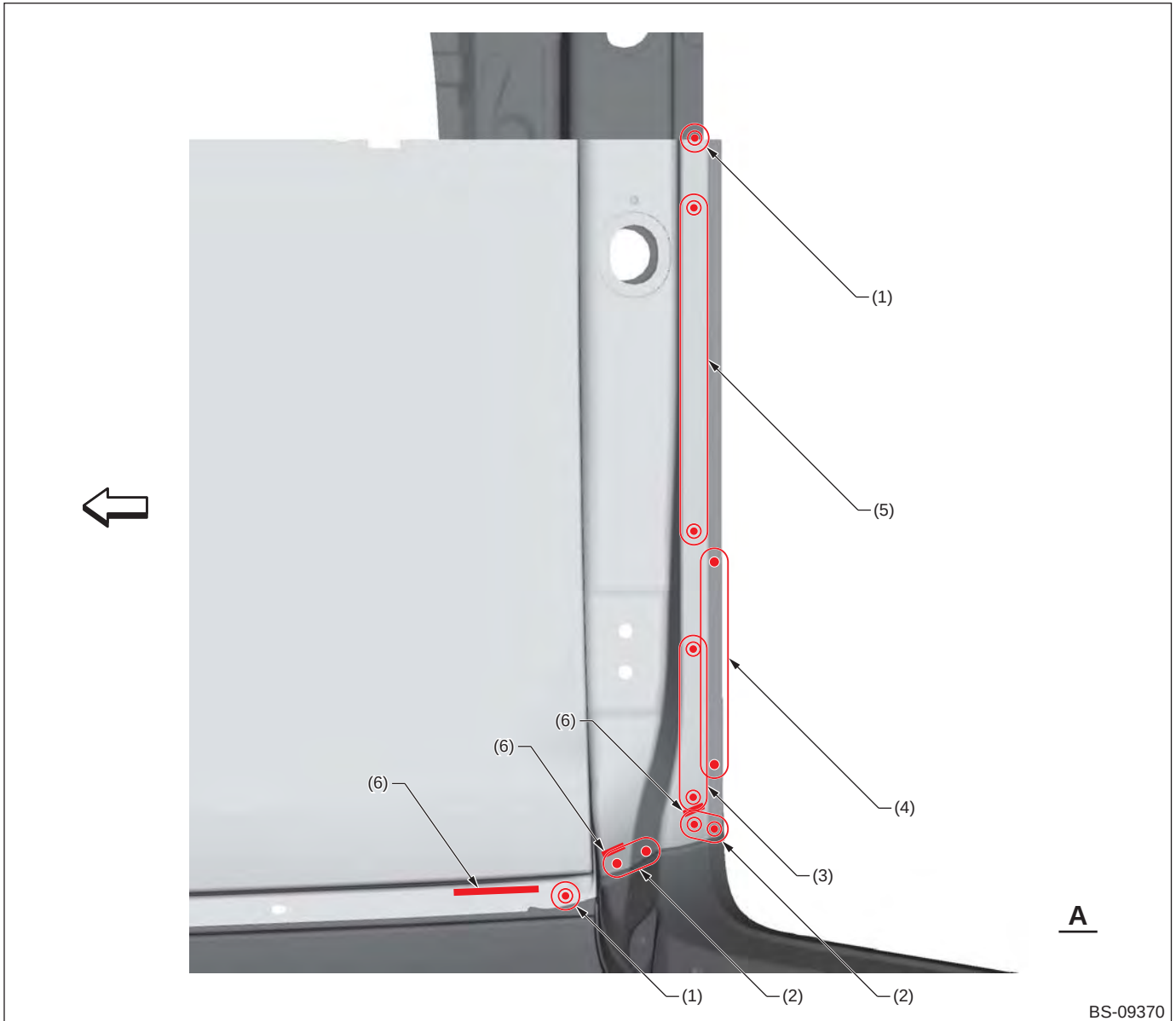
- (4) 6 points (top · 1)
- (5) 7 points (top · 1)
- (6) 1 point (top · 2)

- (7) 1 point
- (8) 2 points
- (9) 5 points

 : Application of adhesive

Panel Replacement

• Views A



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(1) 1 point (top · 1)
(2) 2 points (top · 1)

(3) 3 points (top · 1)
(4) 4 points (top · 1)

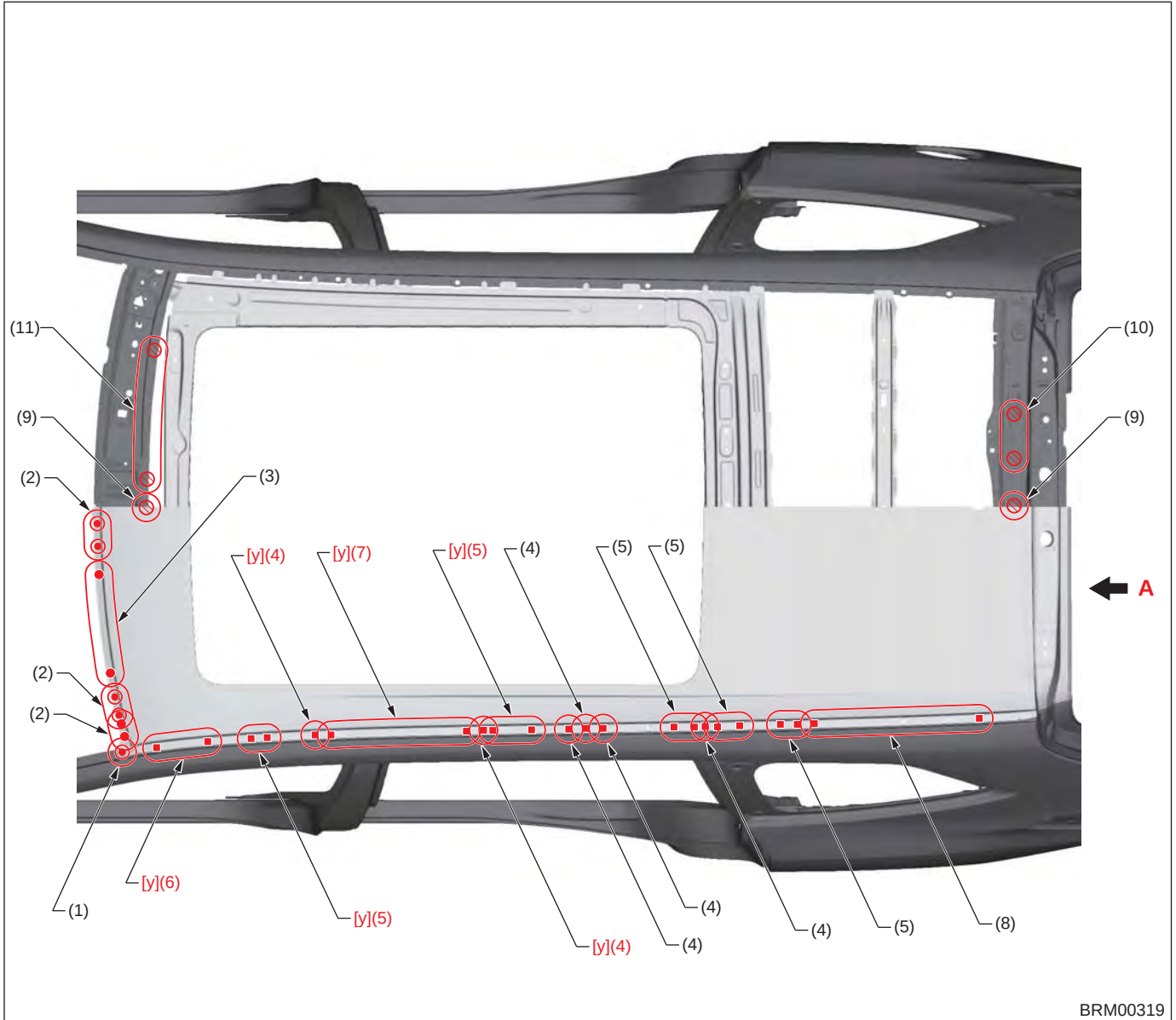
(5) 5 points (top · 1)
(6) Structural adhesive

— : Structural adhesive application location

Panel Replacement

B: INSTALLATION

• Overall view



- | | | |
|-----------------------|------------------------|---------------|
| (1) 1 point | (5) 2 points (service) | (9) 1 point |
| (2) 2 points | (6) 3 points (service) | (10) 2 points |
| (3) 6 points | (7) 6 points (service) | (11) 5 points |
| (4) 1 point (service) | (8) 7 points (service) | |

 : Application of adhesive

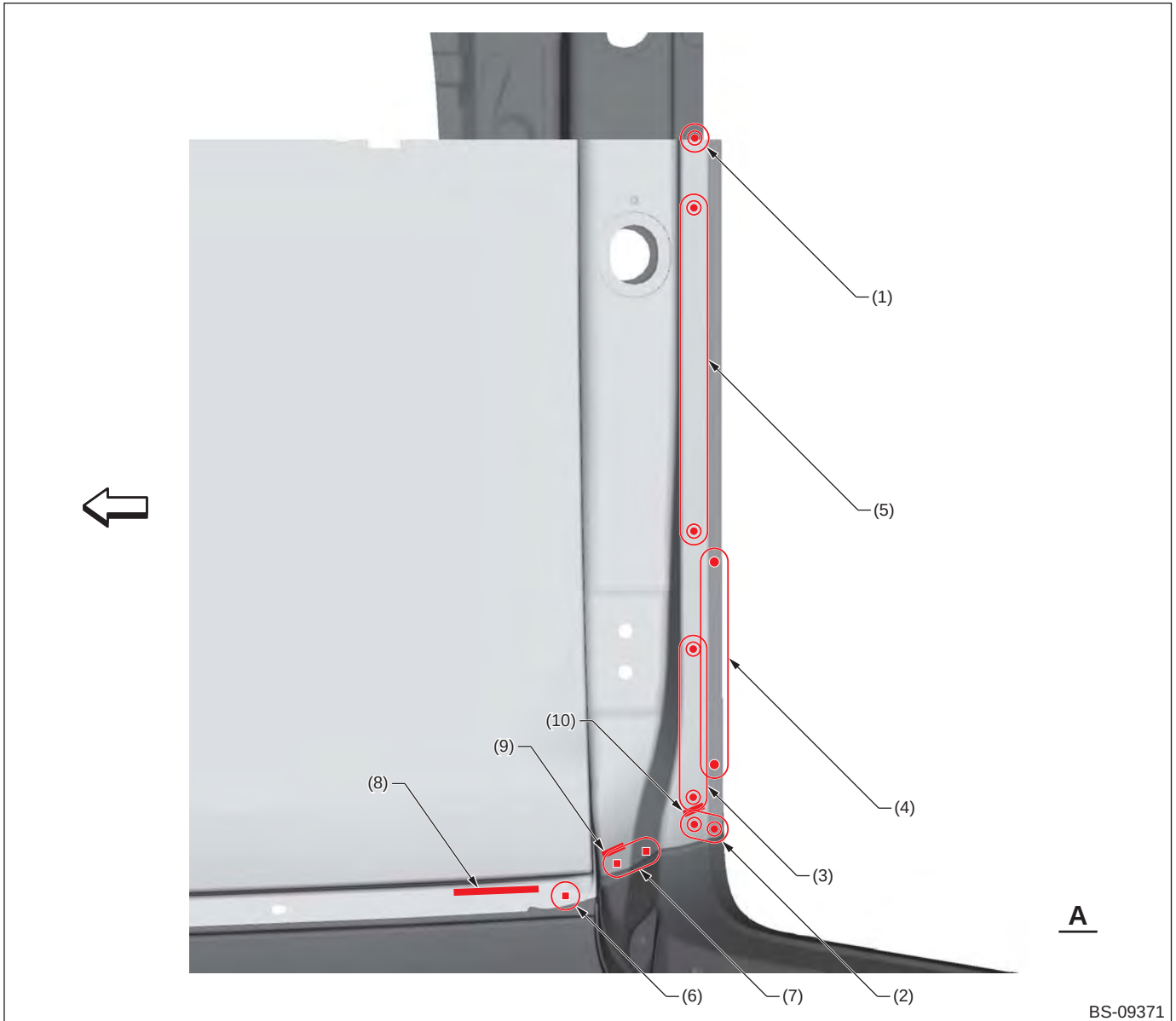
[y] Plug welding

A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2

B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

• Views A



- | | | |
|--------------|---|--|
| (1) 1 point | (5) 5 points | (9) Structural adhesive 18 mm [0.71 in] |
| (2) 2 points | (6) 1 point (service) | (10) Structural adhesive 15 mm [0.59 in] |
| (3) 3 points | (7) 2 points (service) | |
| (4) 4 points | (8) Structural adhesive 60 mm [2.36 in] | |

— : Structural adhesive application location