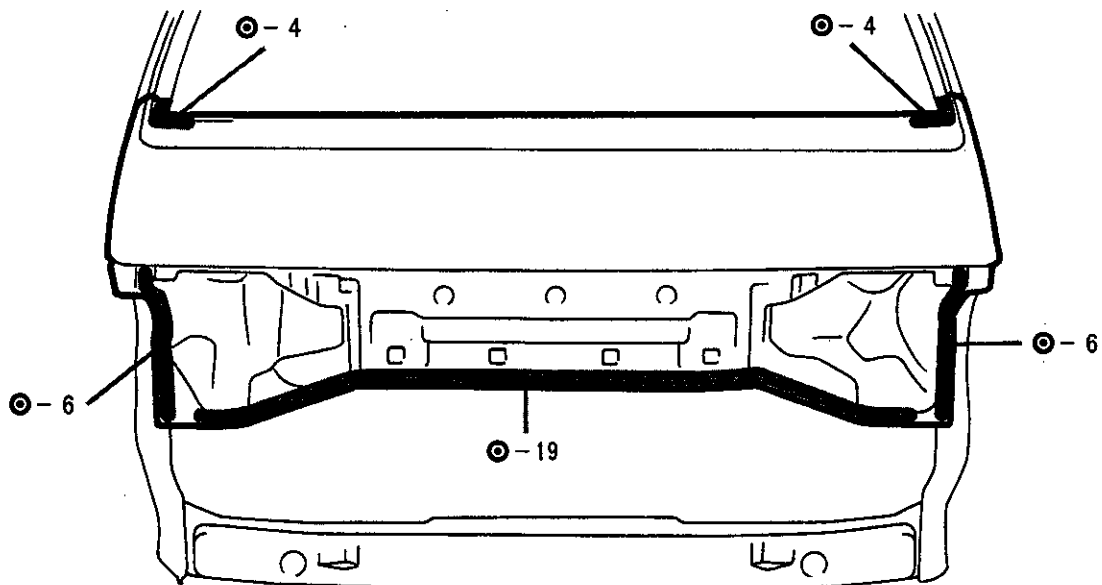
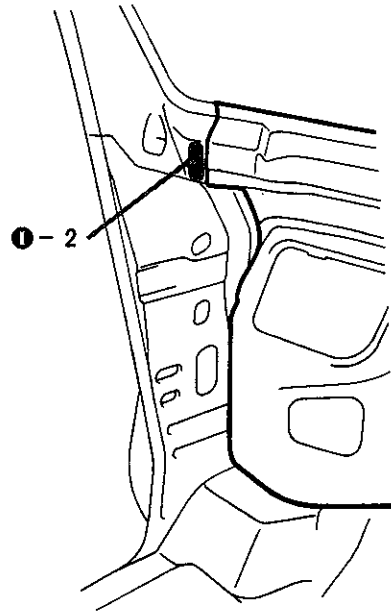
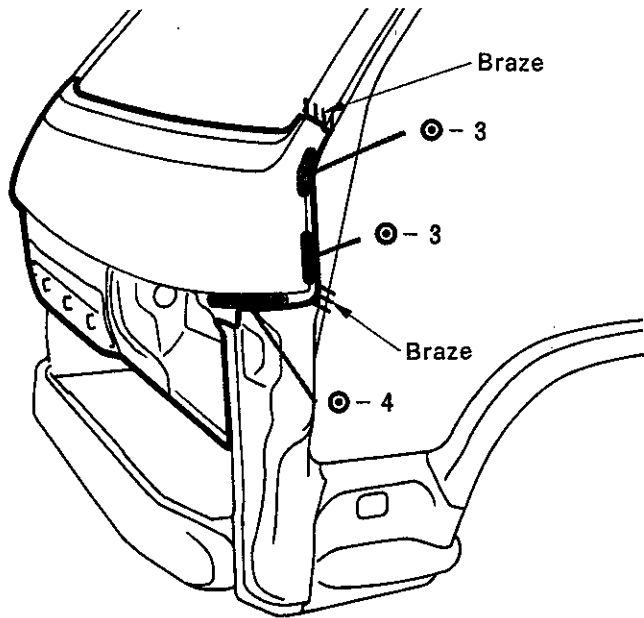
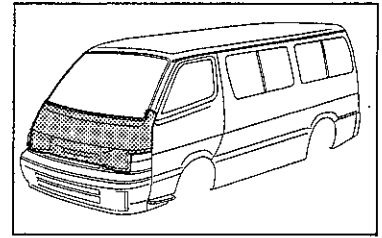
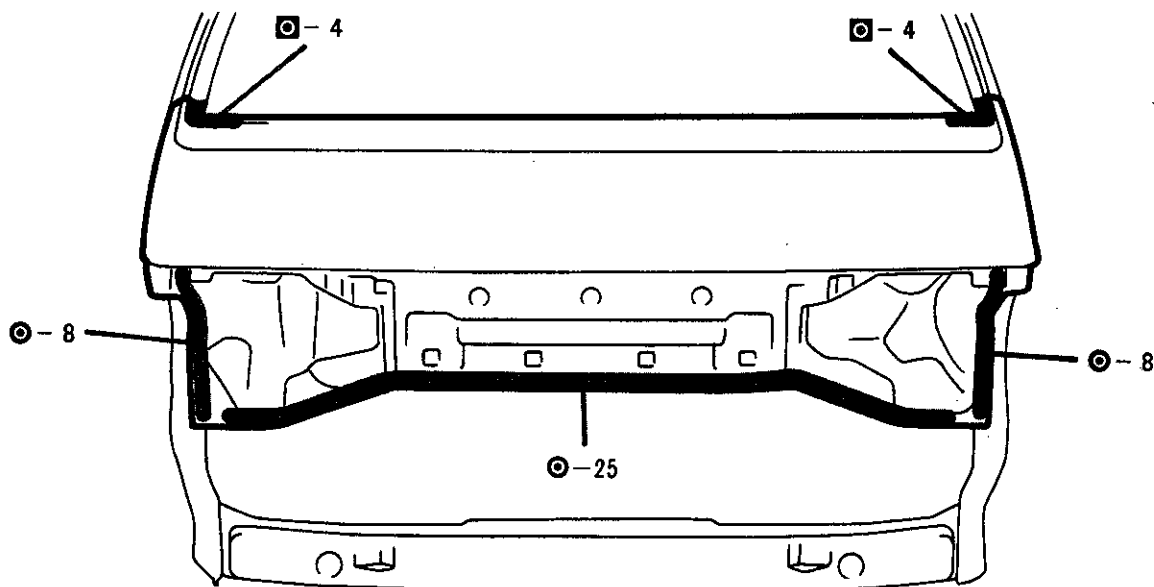
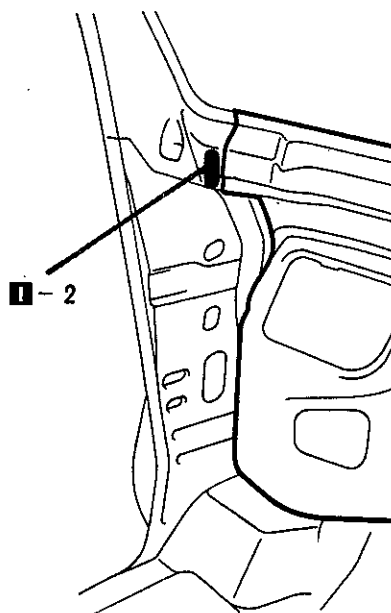
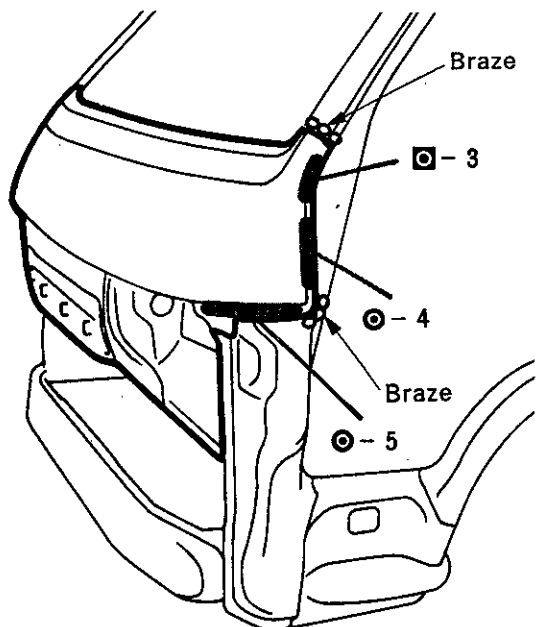


FRONT PANEL (ASSY)**REMOVAL**

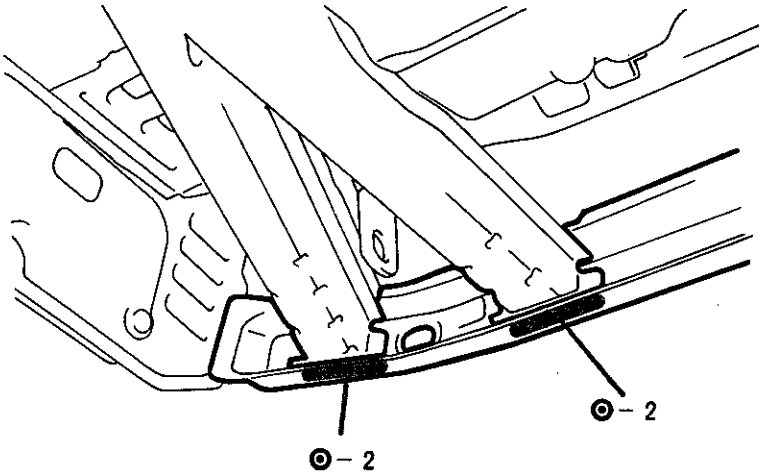
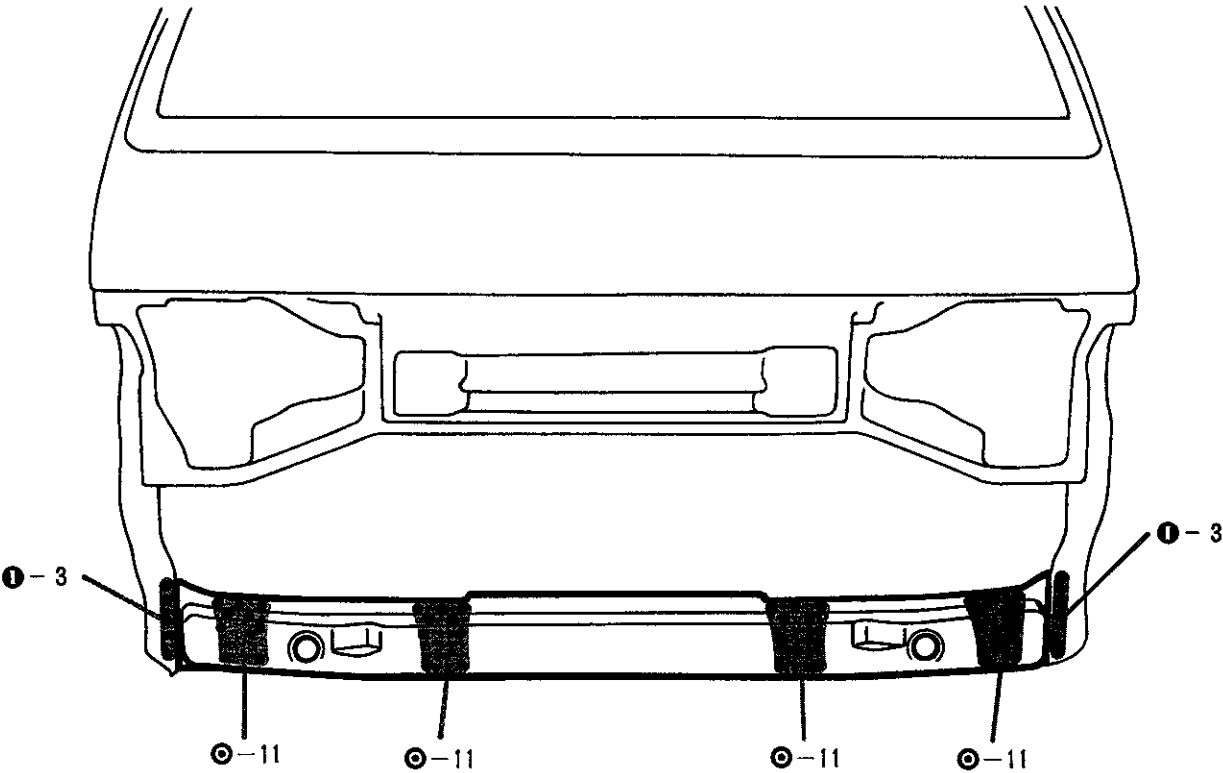
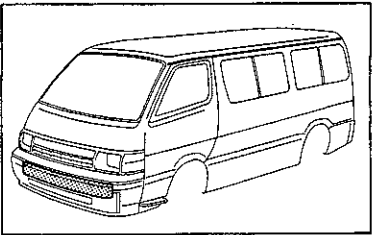
INSTALLATION



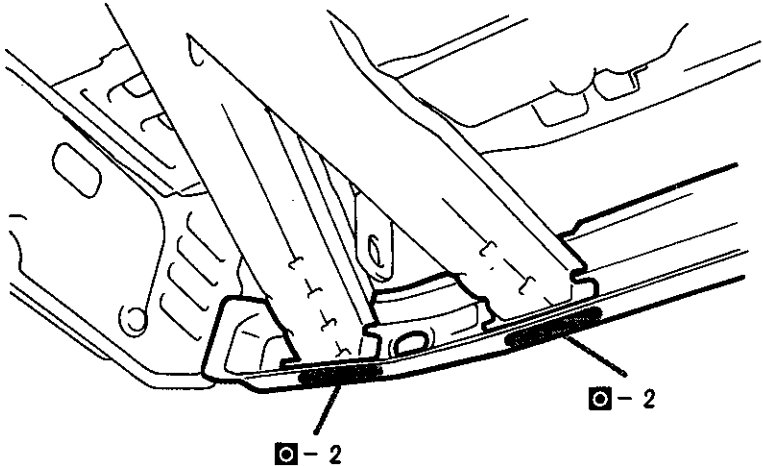
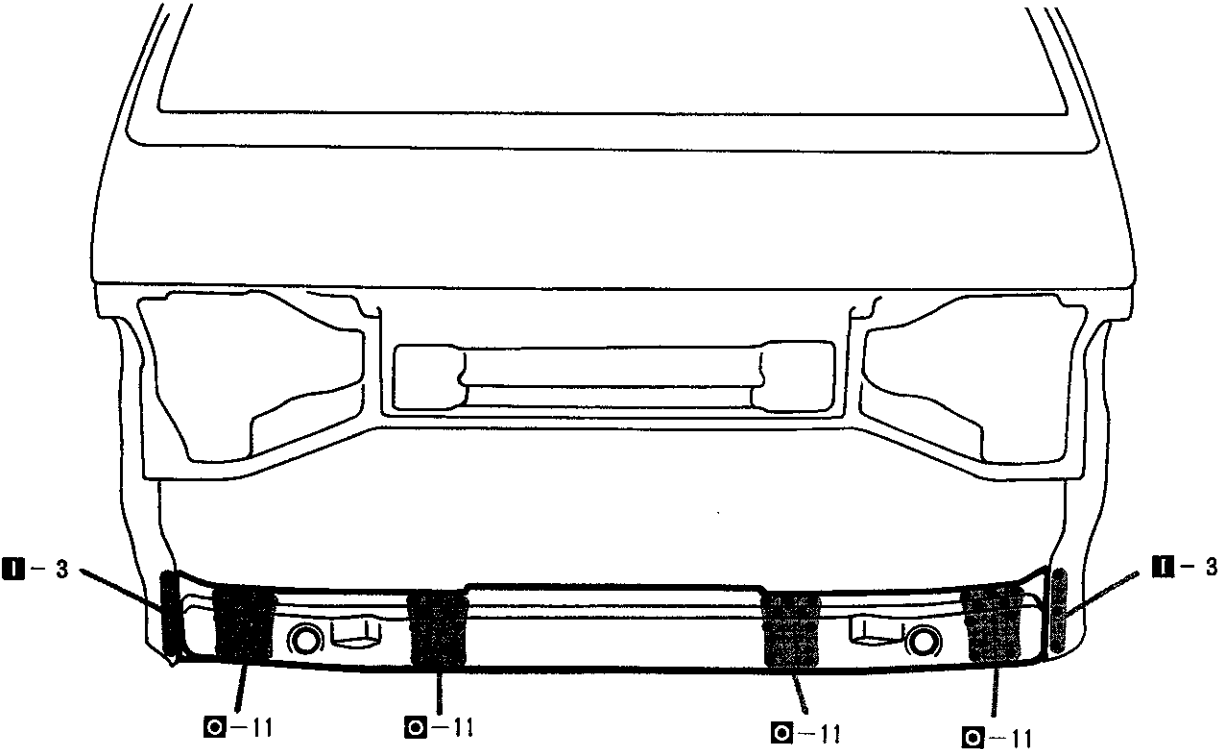
1. Temporarily install the new parts and check the fit of the radiator grille, headlight housing and windshield glass.

FRONT CROSSMEMBER (ASSY)

REMOVAL

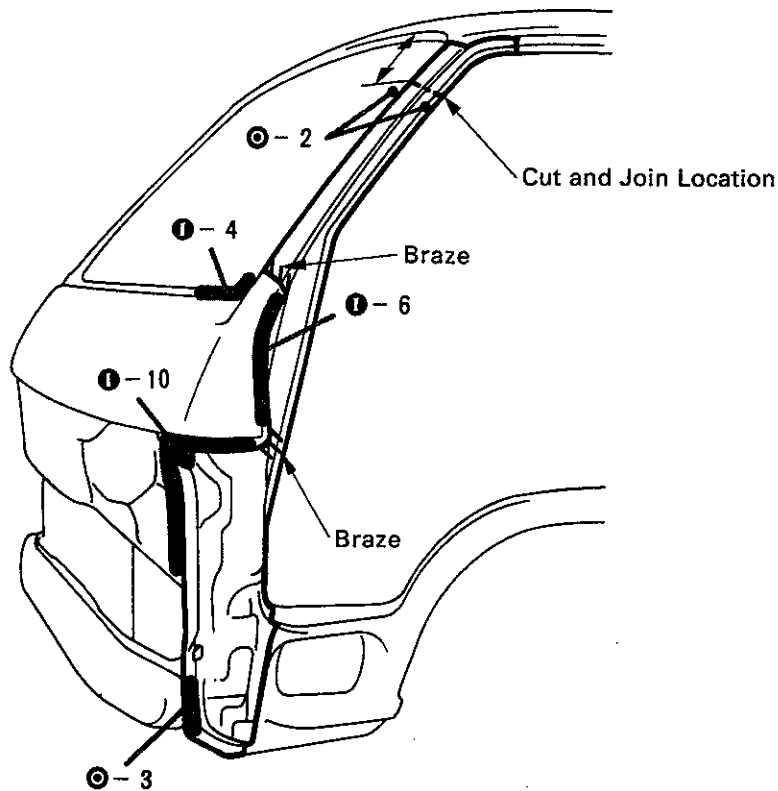
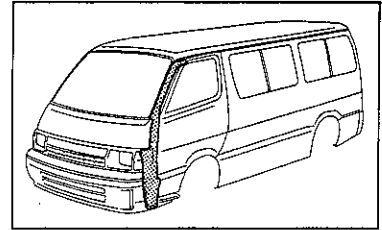


INSTALLATION

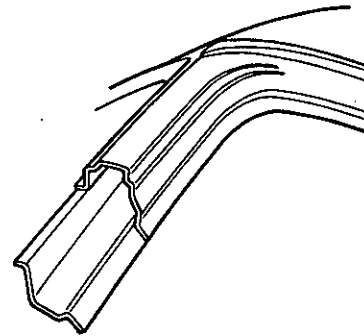


FRONT BODY PILLAR (CUT)

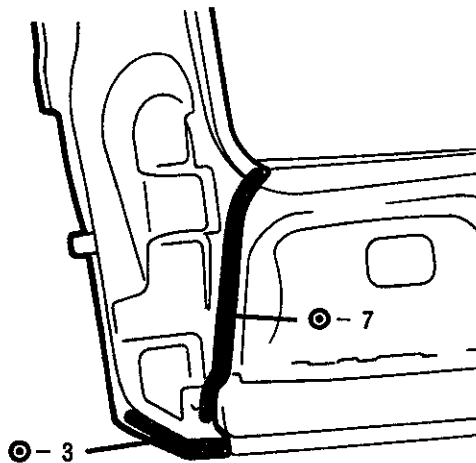
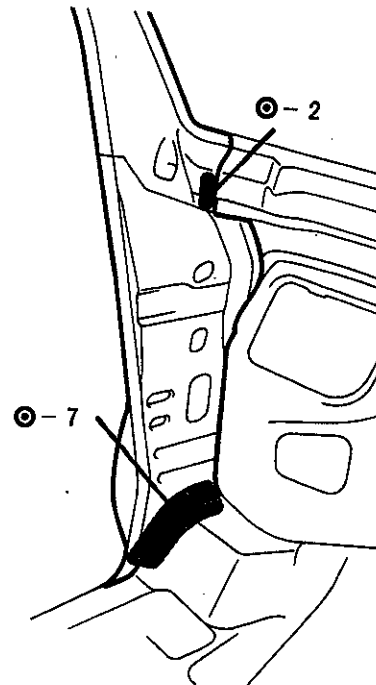
REMOVAL



[Cut and Join Location]



[View from Interior]

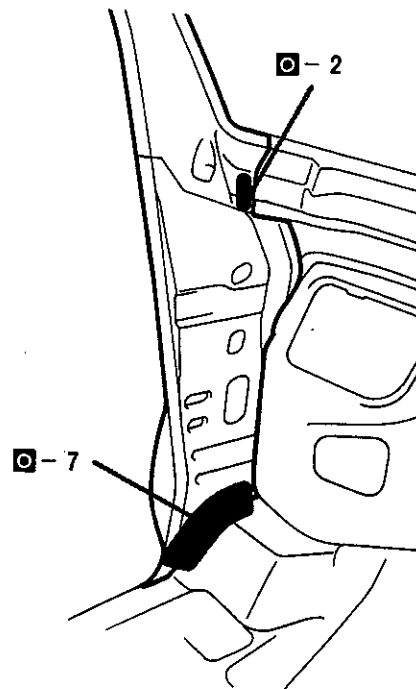
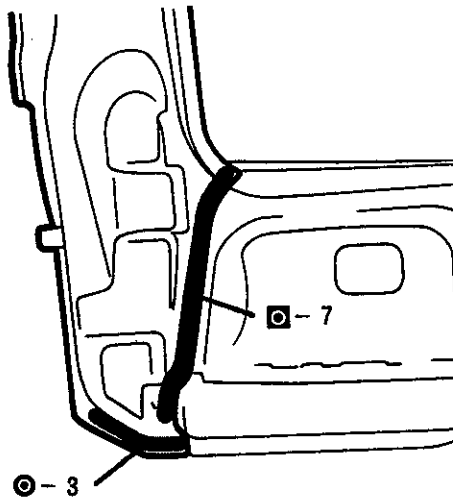
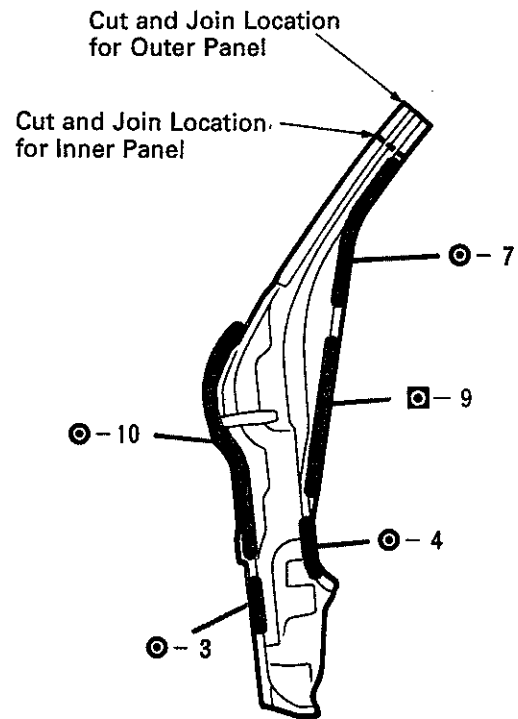
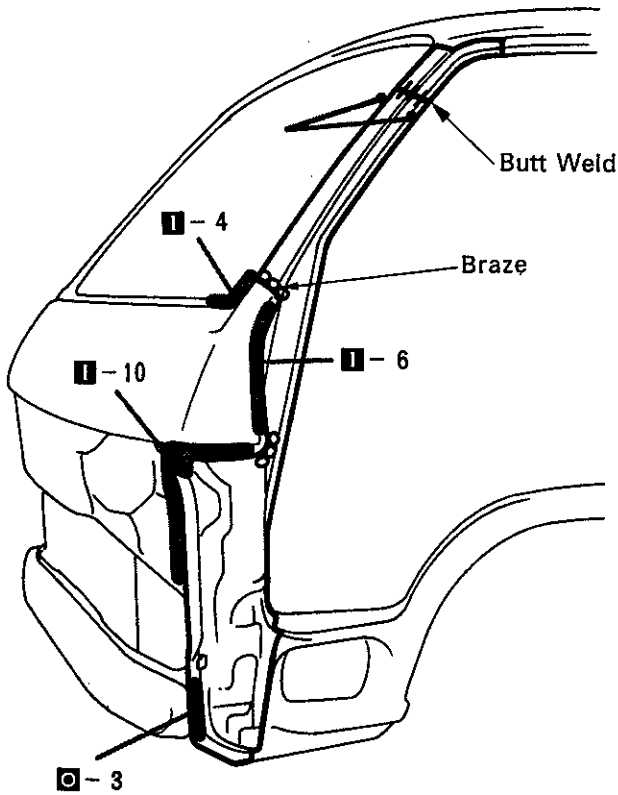


1. Cut and join the parts at the locations shown above.
- 3) Before cutting, remove the antenna cord.

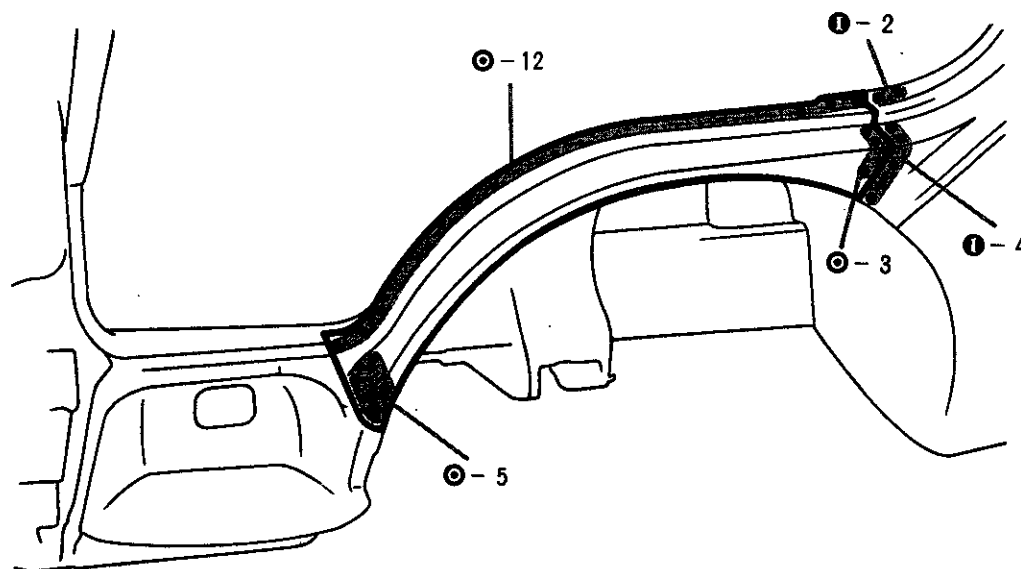
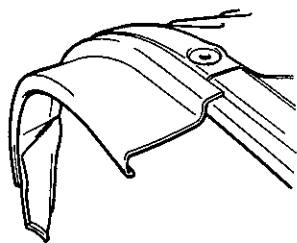
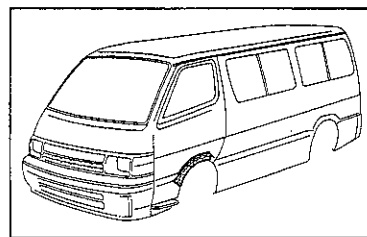
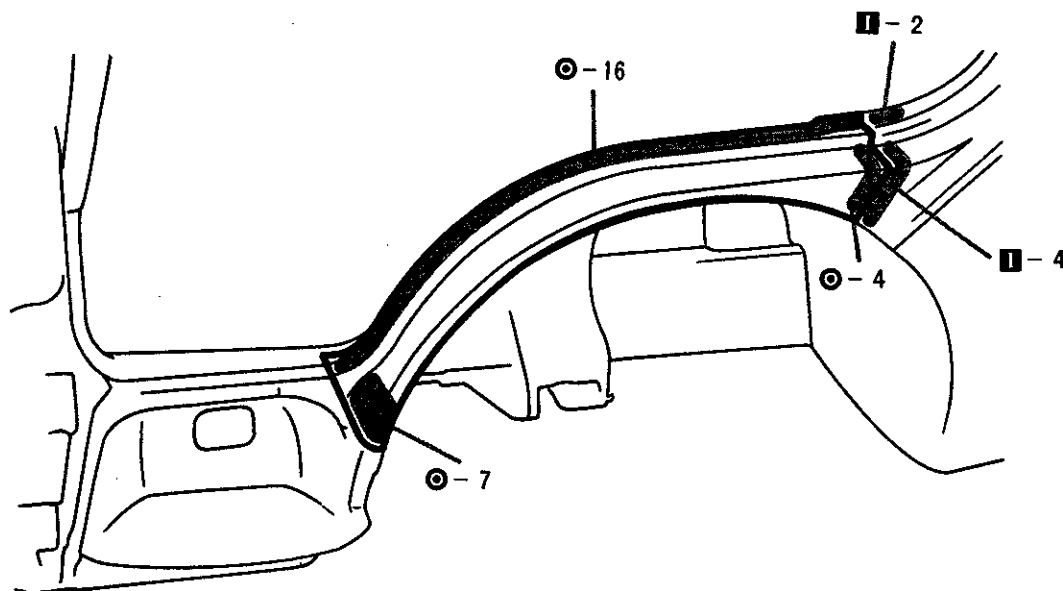
NOTICE:

- 1) Avoid the antenna installation hole for the cut and join location.
- 2) As shown above, cut and join the front body pillar outer and inner at position shifted above 50 mm (1.97 in.).

INSTALLATION



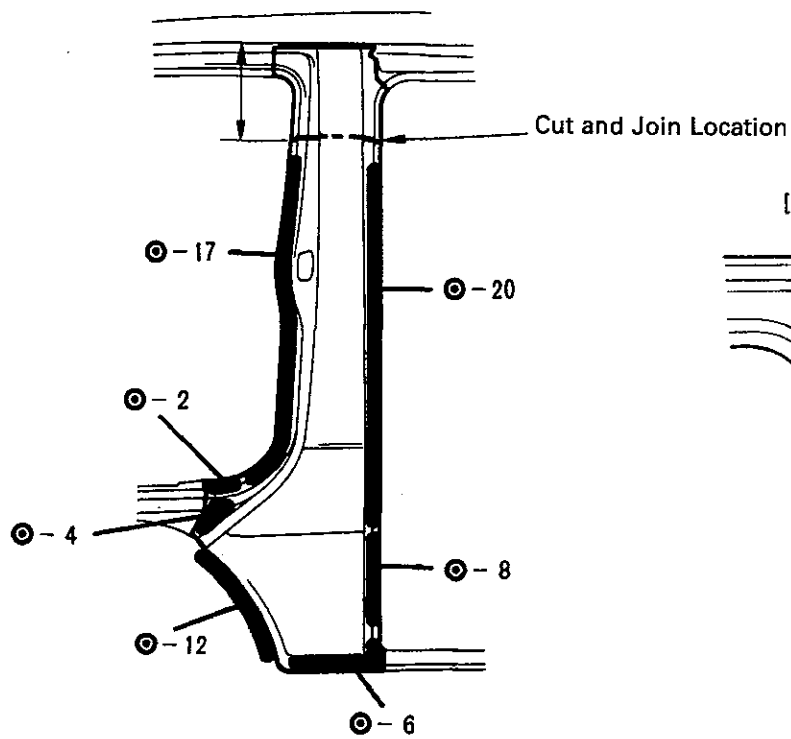
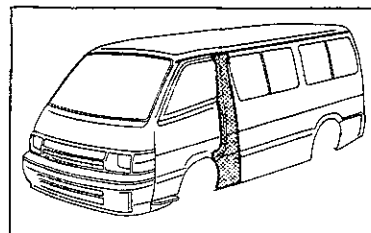
1. Before temporarily installing the new parts, weld the outer and inner panel at the standard points.
2. Temporarily install the new parts and check the fit of the front door and windshield glass.

FENDER OUTER PANEL (ASSY)**REMOVAL****INSTALLATION**

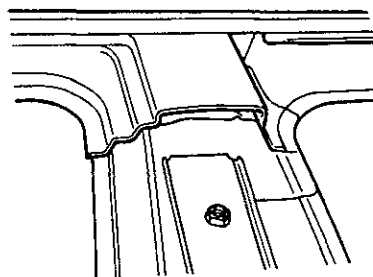
1. Temporarily install the new parts and check the fit of the front door.

CENTER BODY PILLAR OUTER (CUT)

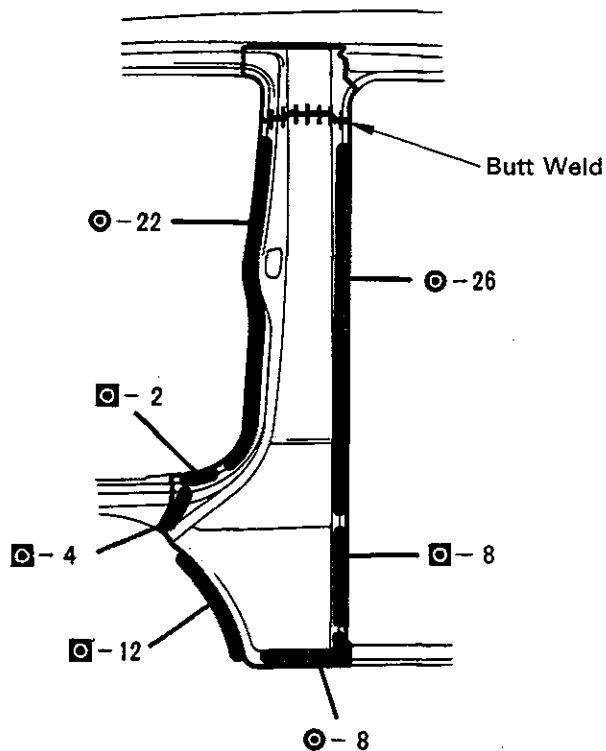
REMOVAL



[Cut and Join Location]



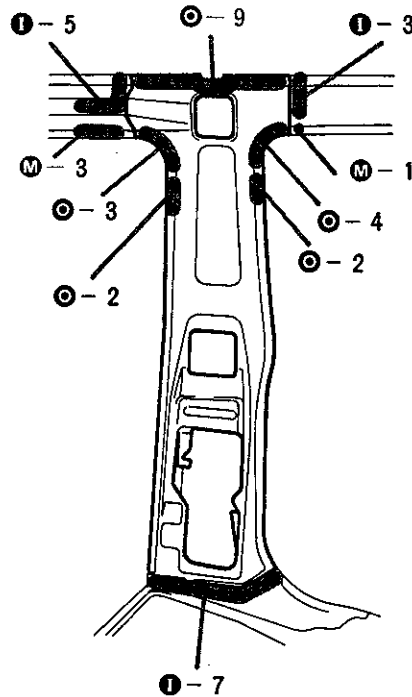
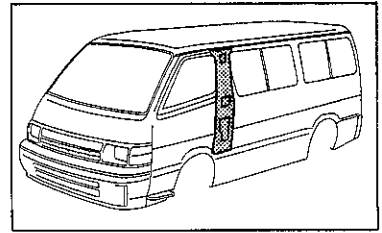
INSTALLATION



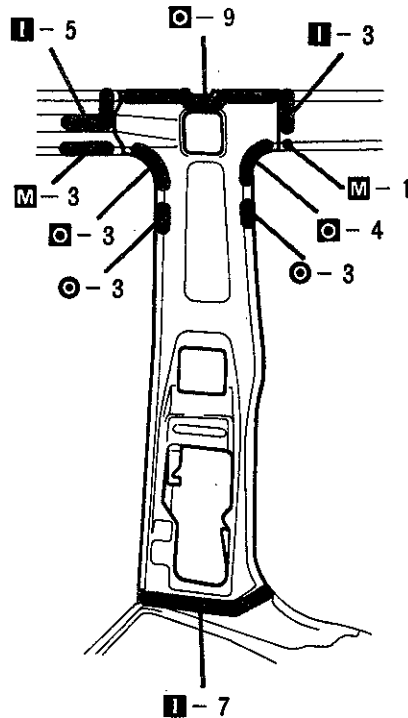
1. Temporarily install the new parts and check the fit of the sliding door.

CENTER BODY PILLAR INNER (ASSY)

REMOVAL (With the center body pillar outer removed.)



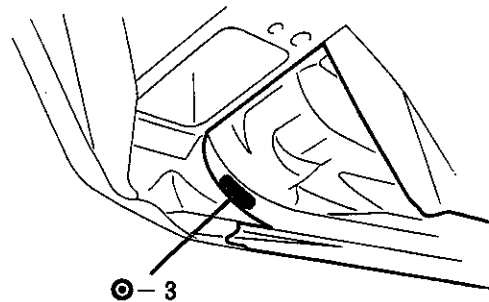
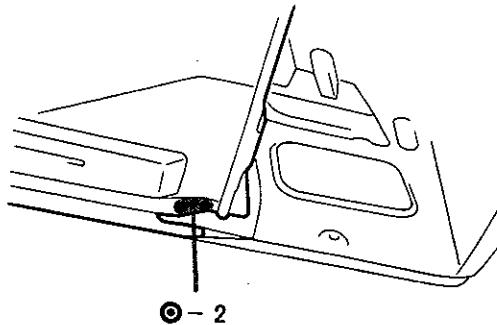
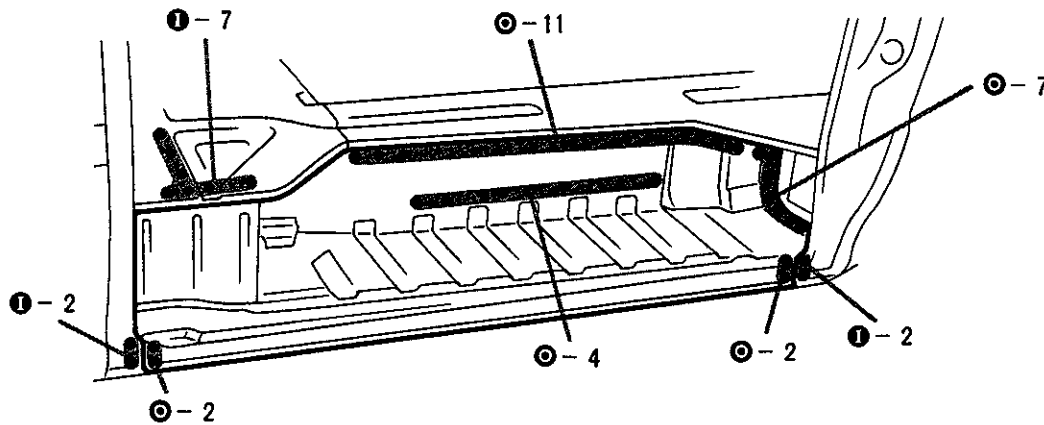
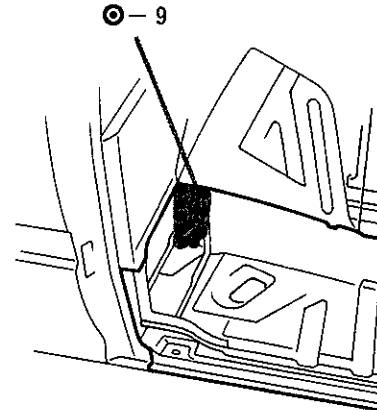
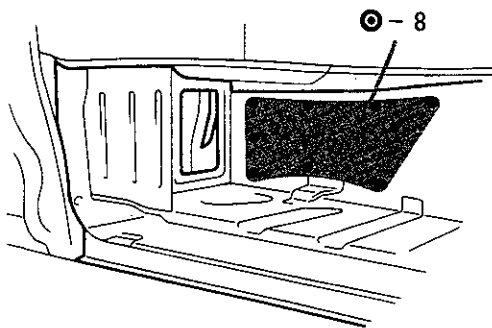
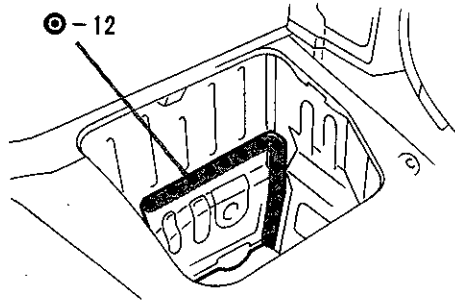
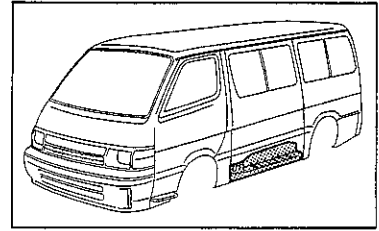
INSTALLATION



1. Before welding the new parts, temporarily install the center body pillar outer and check the fit.

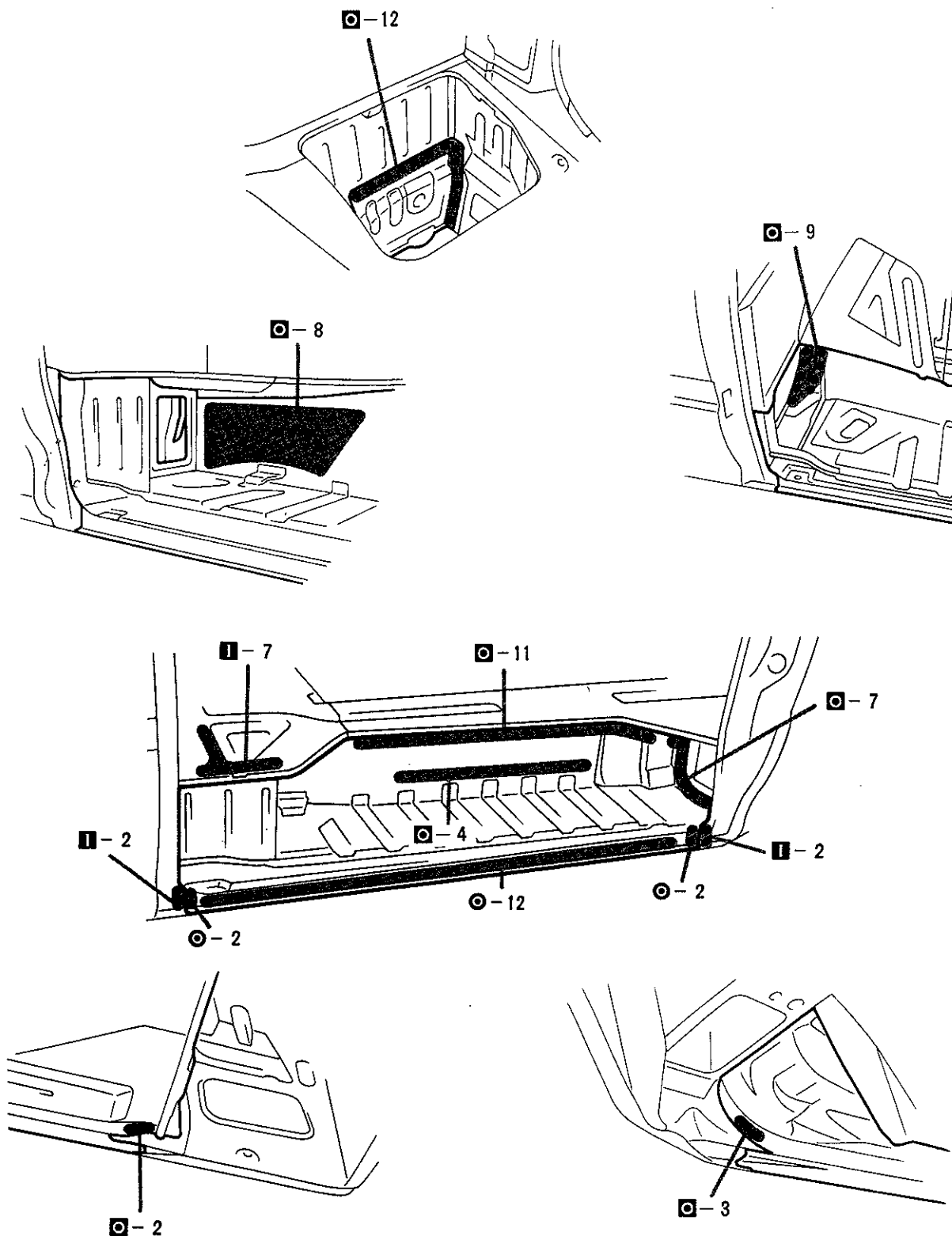
REAR FLOOR STEP, ROCKER OUTER PANEL (ASSY)

REMOVAL

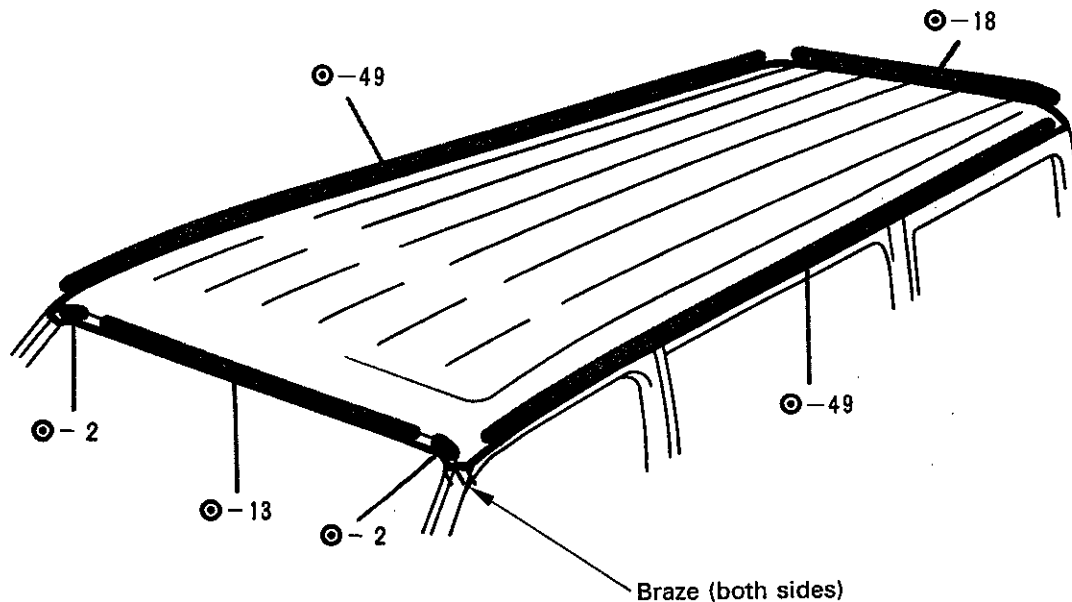
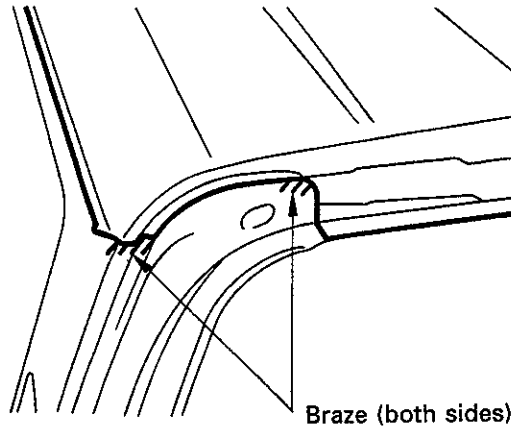
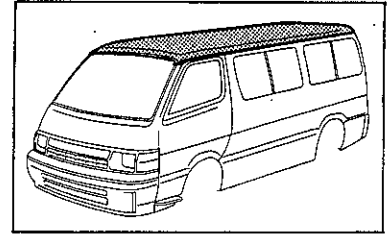


1. Insise the lower side of the floor pan where the front side member is welded, then remove it.

INSTALLATION



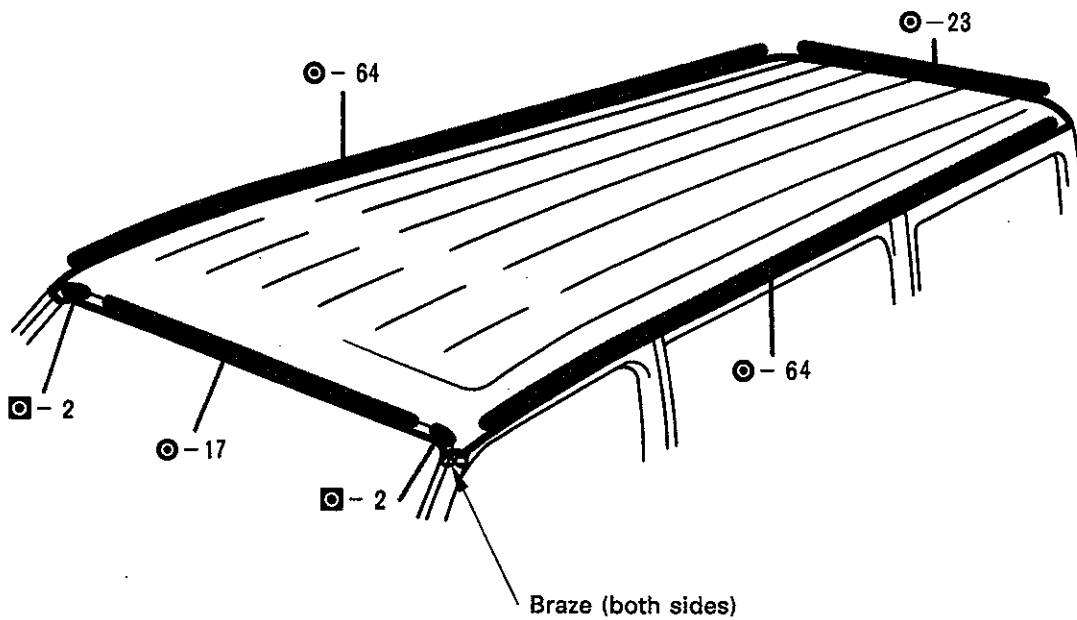
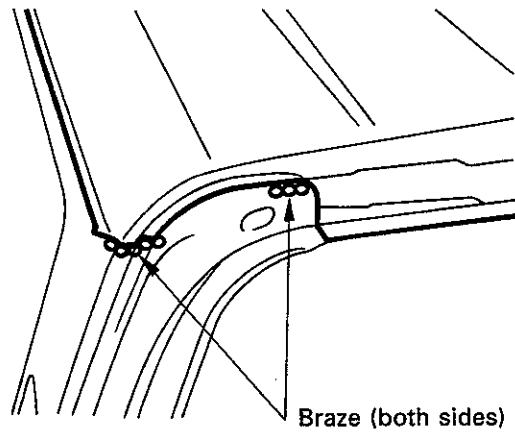
1. Temporarily install the new parts and check the fit of the sliding door.

ROOF PANEL (ASSY): Standard Wheel Base and Standard Roof**REMOVAL**

1. Heat the brazed areas of the front body pillar, quarter panel and back door opening side flange and scrape off the brazing with a wire brush.

NOTICE: Be careful not to overheat the brazed areas.

INSTALLATION

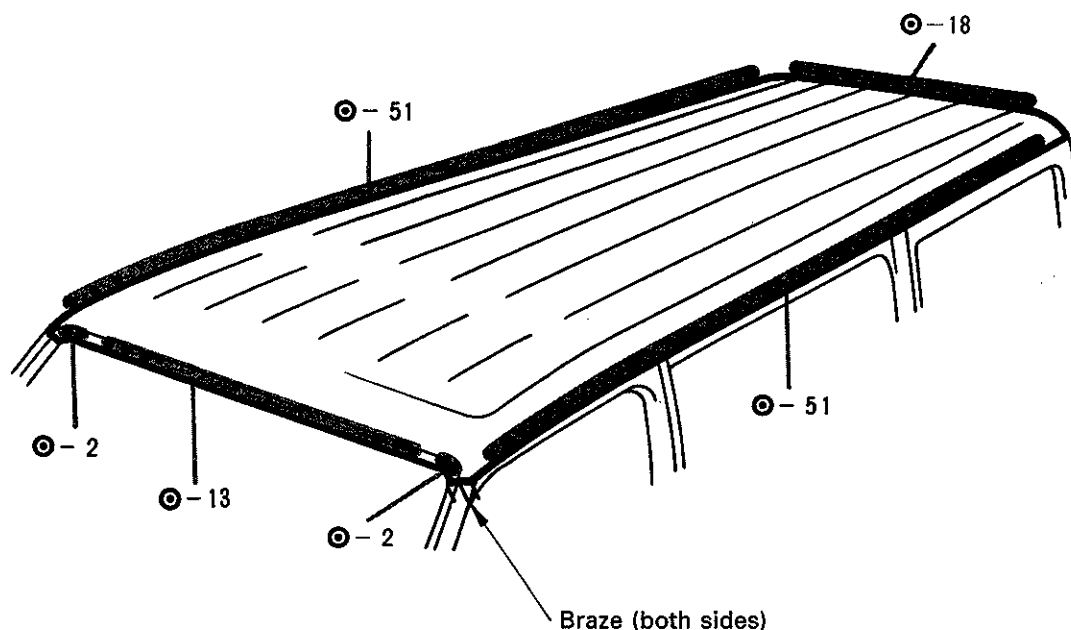
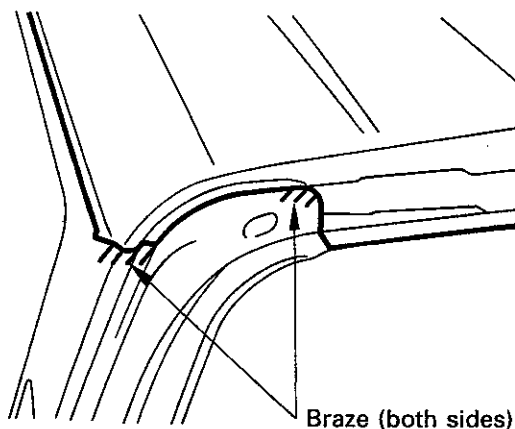
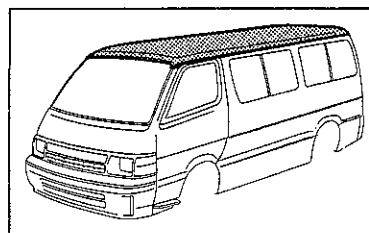


1. Braze the front body pillar, quarter panel and back door opening side flame connections.

NOTICE: Before performing these operations, place a wet rag on the roof panel to protect it from damage.

ROOF PANEL (ASSY): Long Wheel Base and Standard Roof

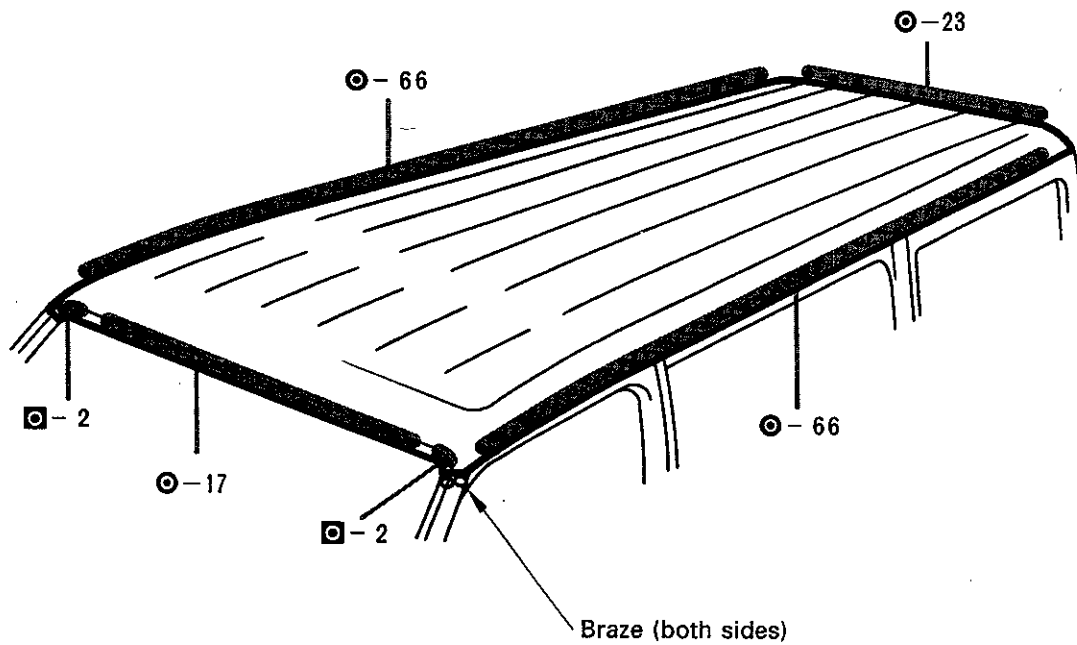
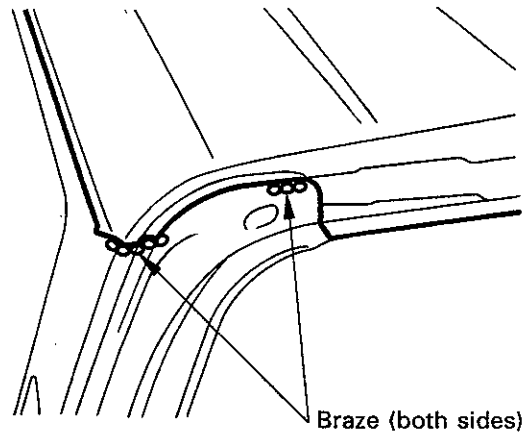
REMOVAL



1. Heat the brazed areas of the front body pillar, quarter panel and back door opening side flange and scrape off the brazing with a wire brush.

NOTICE: Be careful not to overheat the front body pillar.

INSTALLATION

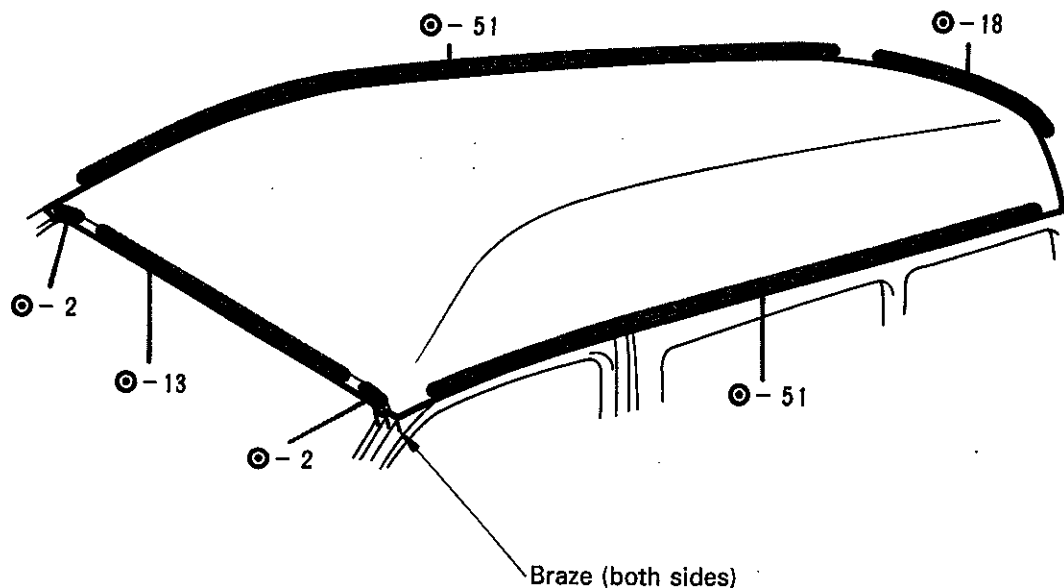
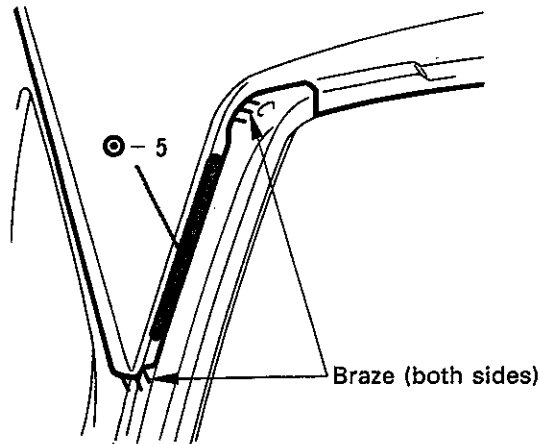
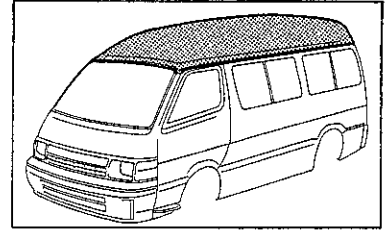


1. Braze the front body pillar, quarter panel and back door opening side flame connections.

NOTICE: Before performing these operations, place a wet rag on the roof panel to protect it from damage.

ROOF PANEL (ASSY): Long Wheel Base and High Roof

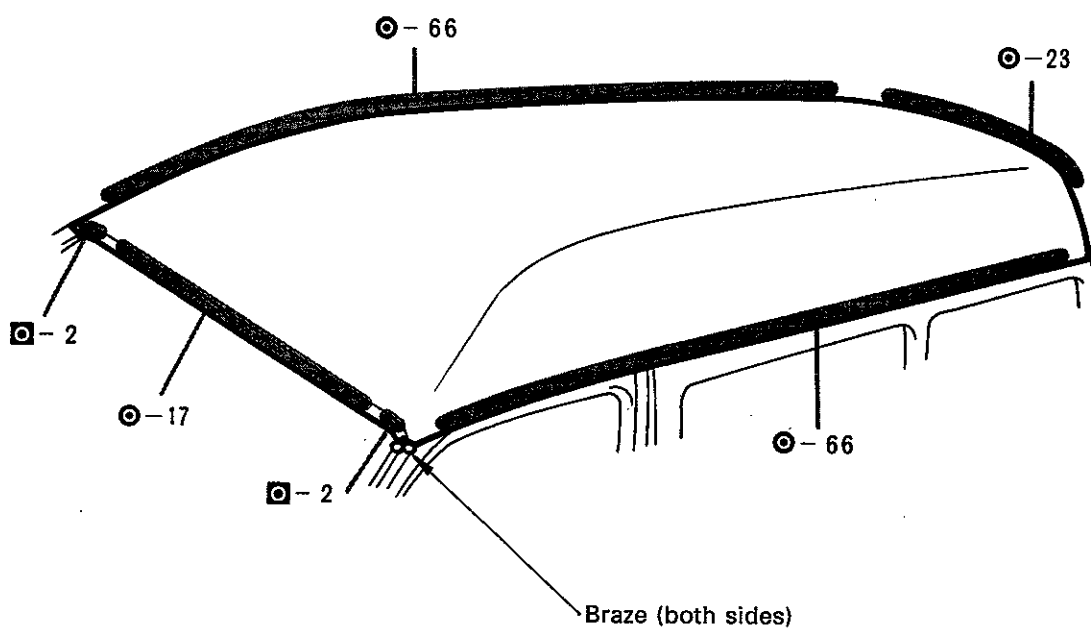
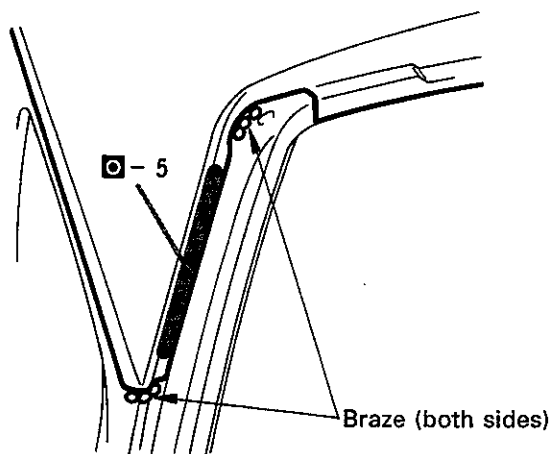
REMOVAL



1. Heat the brazed areas of the front body pillar, quarter panel and back door opening side flange and scrape off the brazing with a wire brush.

NOTICE: Be careful not overheat the brazed areas.

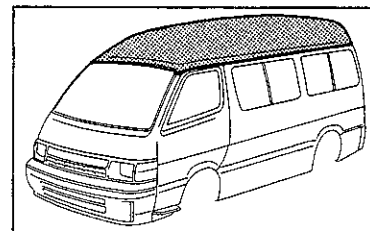
INSTALLATION



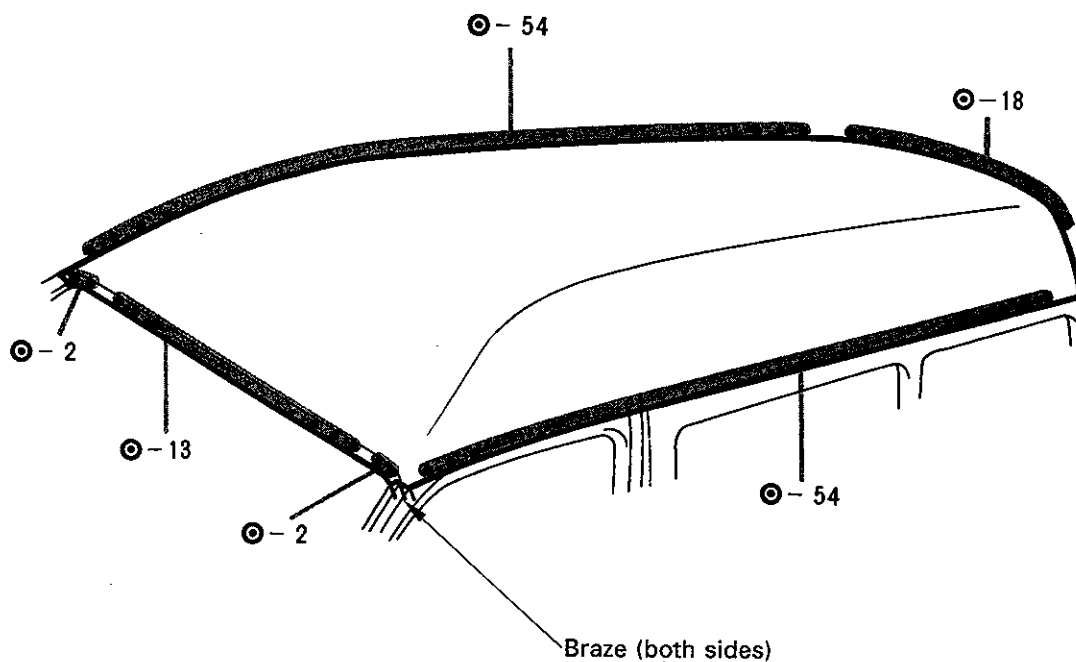
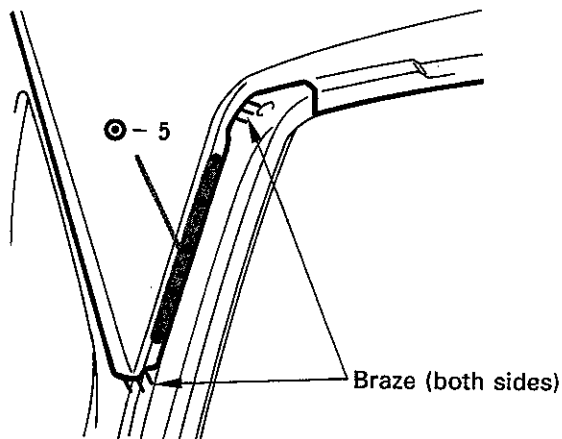
1. Braze the front body pillar, quarter panel and back door opening side flame connections.

NOTICE: Before performing these operations, place a wet rag on the roof panel to protect it from damage.

ROOF PANEL (ASSY): Super Long Wheel Base



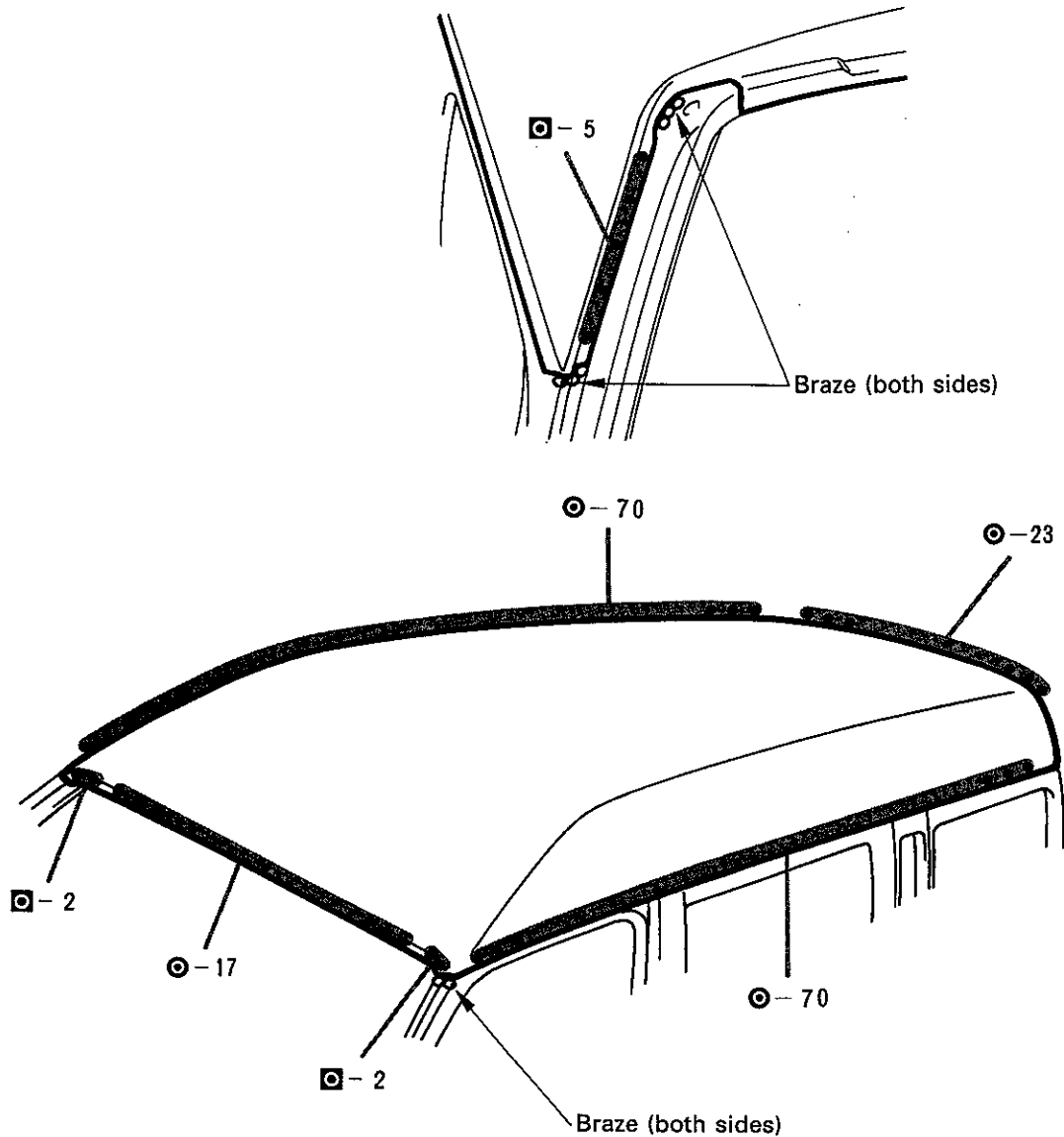
REMOVAL



1. Heat the brazed areas of the front body pillar, quarter panel and back door opening side panel and scrape off the brazing with a wire brush.

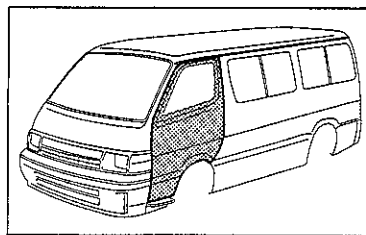
NOTICE: Be careful not to overheat the brazed areas.

INSTALLATION

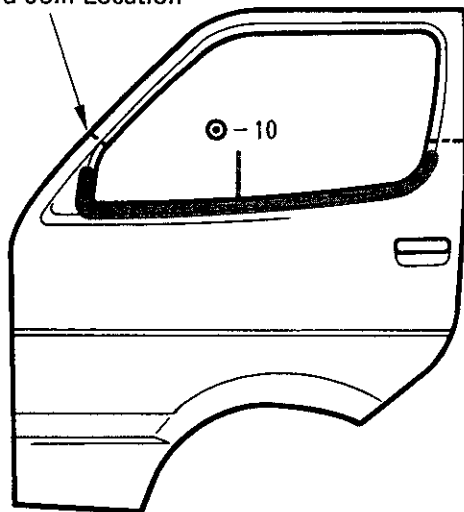


1. Braze the front body pillar, quarter panel and back door opening side flame connections.

NOTICE: Before performing these operations, place a wet rag on the roof panel to protect it from damage.

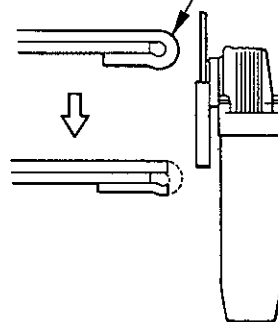
FRONT DOOR OUTER PANEL (ASSY)**REMOVAL**

Cut and Join Location

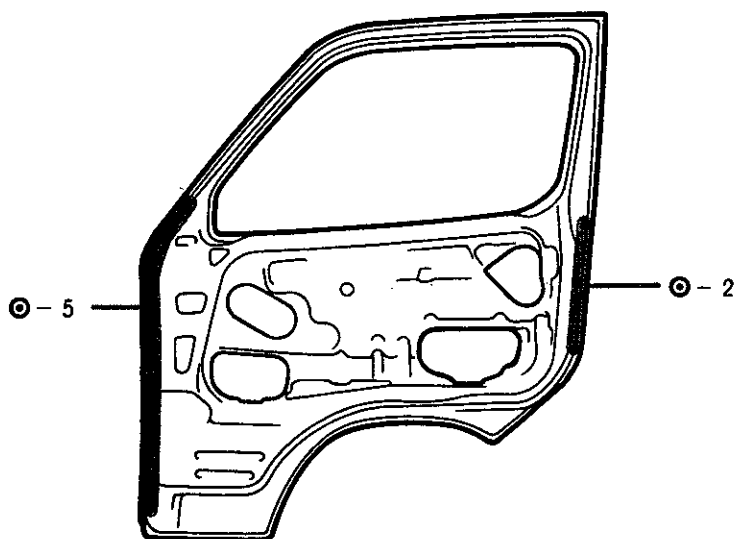


Cut and Join Location

Hemming Location

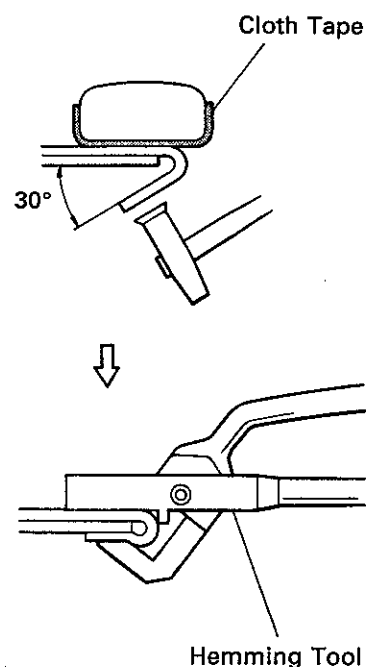
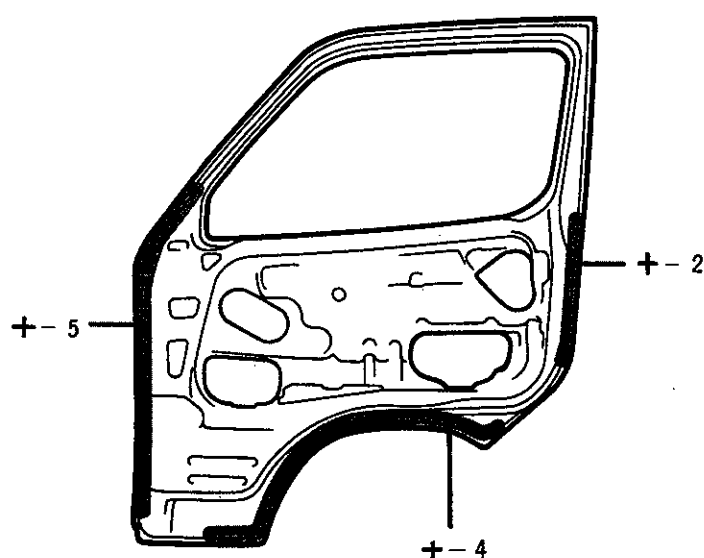
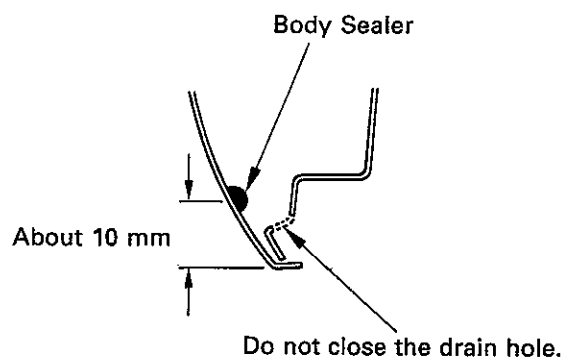
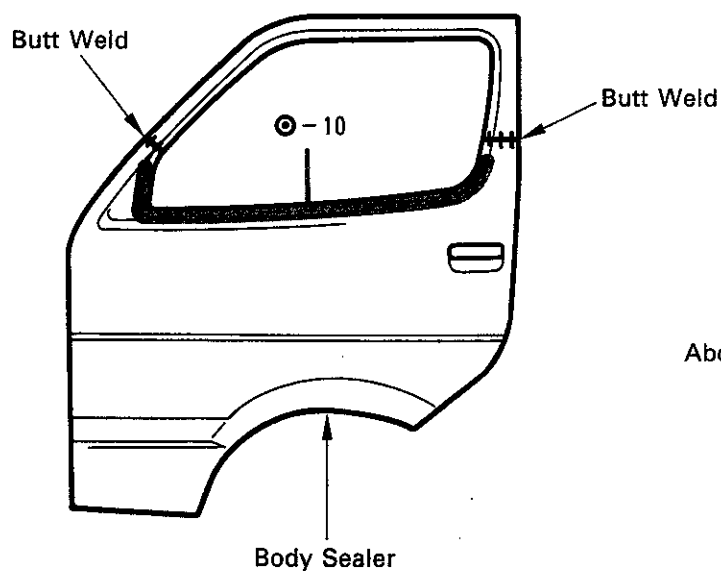


Disc Sander



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

INSTALLATION



1. Before temporarily installing the new parts, apply body sealer to the back side of the new parts.

HINT:

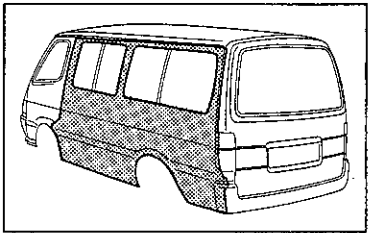
- 1) Apply sealer evenly about 10 mm (0.39 in.) from the flange and 3 mm (0.12 in.) in diameter.
- 2) For other sealing points refer to section AR.

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

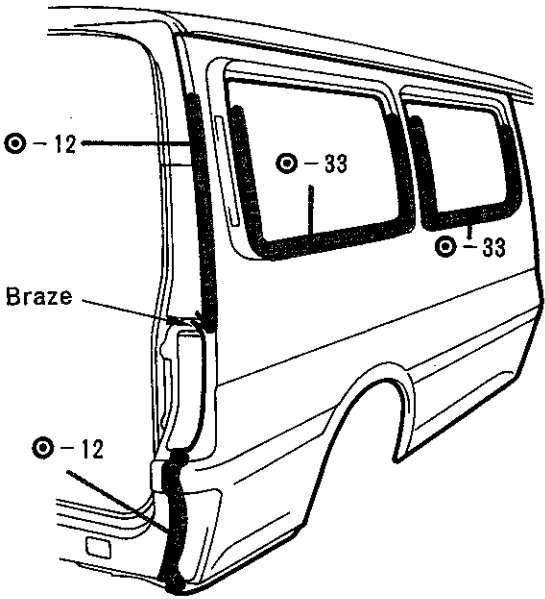
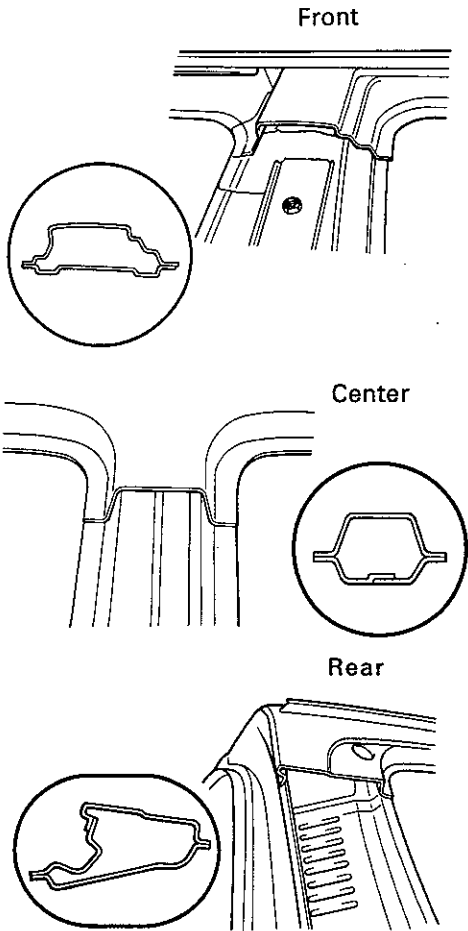
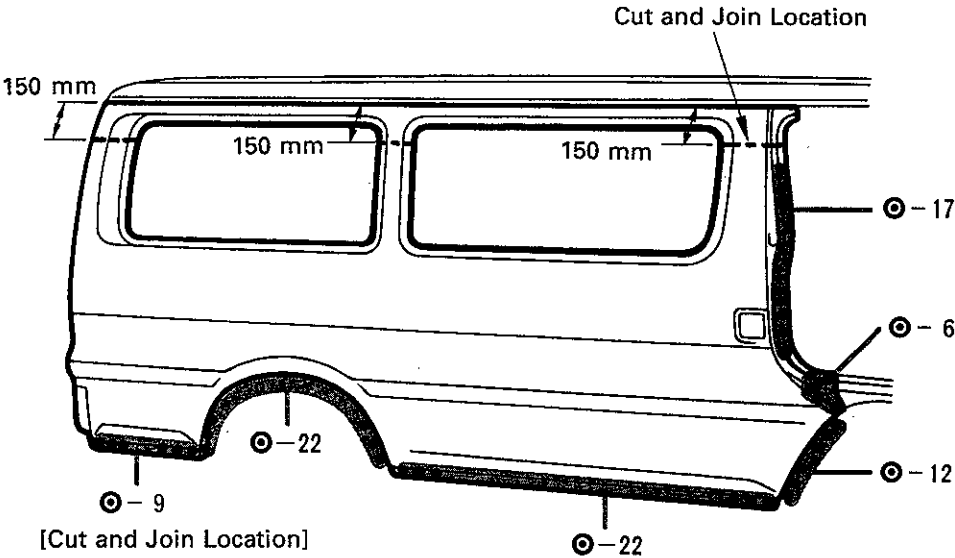
HINT:

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

QUARTER PANEL (CUT): Without Slide Door Side (Standard Wheel Base and Glass Van)



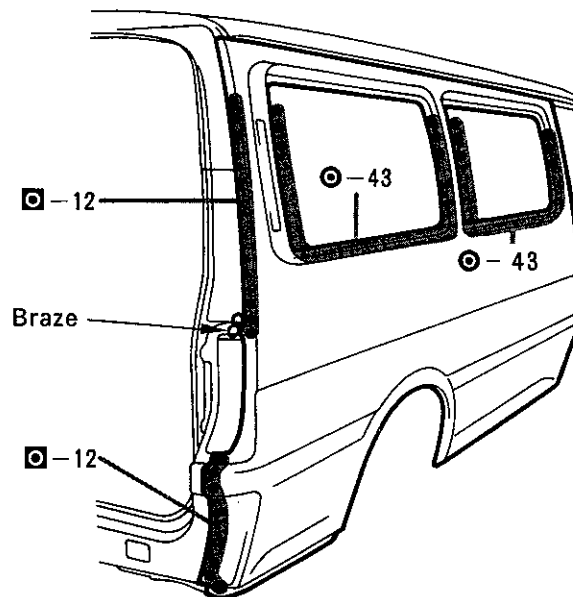
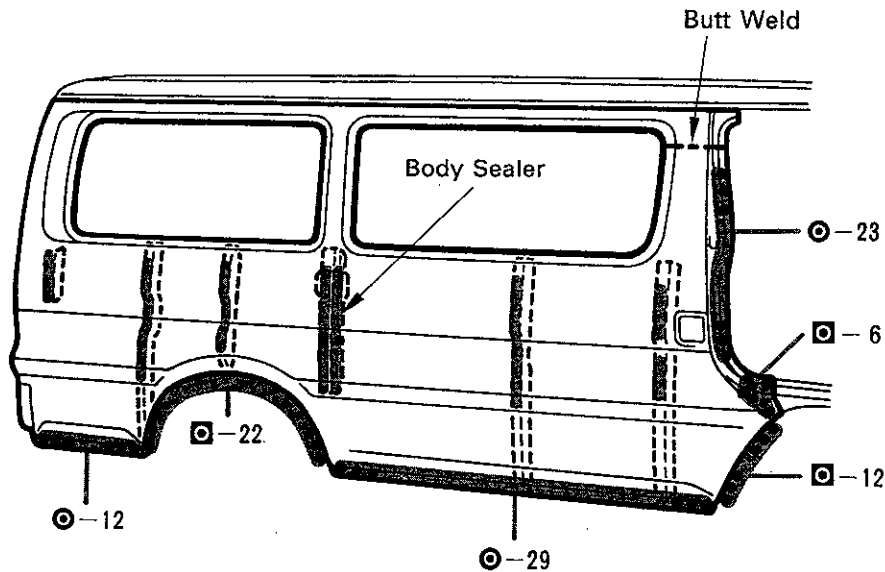
REMOVAL



mm	in.
150	5.91

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

INSTALLATION

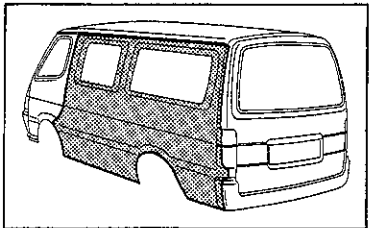


1. Before temporarily installing the new parts, apply body sealer to the locations shown above.
2. Temporarily install the new parts and check the fit of the front door, back door and rear combination light.

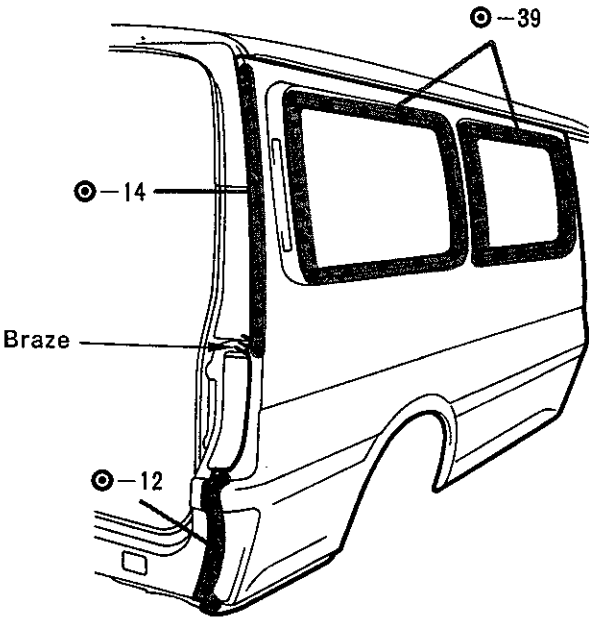
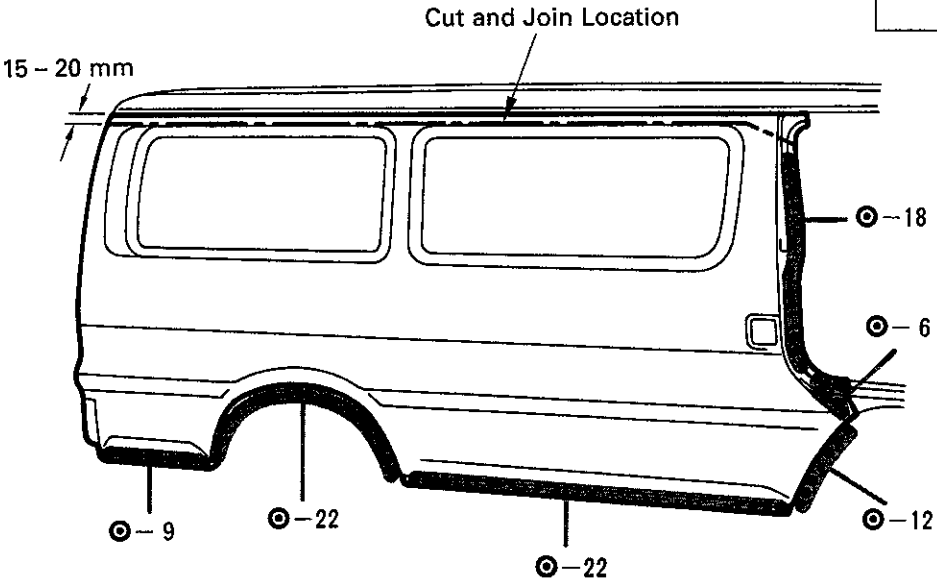
HINT:

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

QUARTER PANEL (CUT): Without Slide Door Side (Standard Wheel Base and Panel Van)



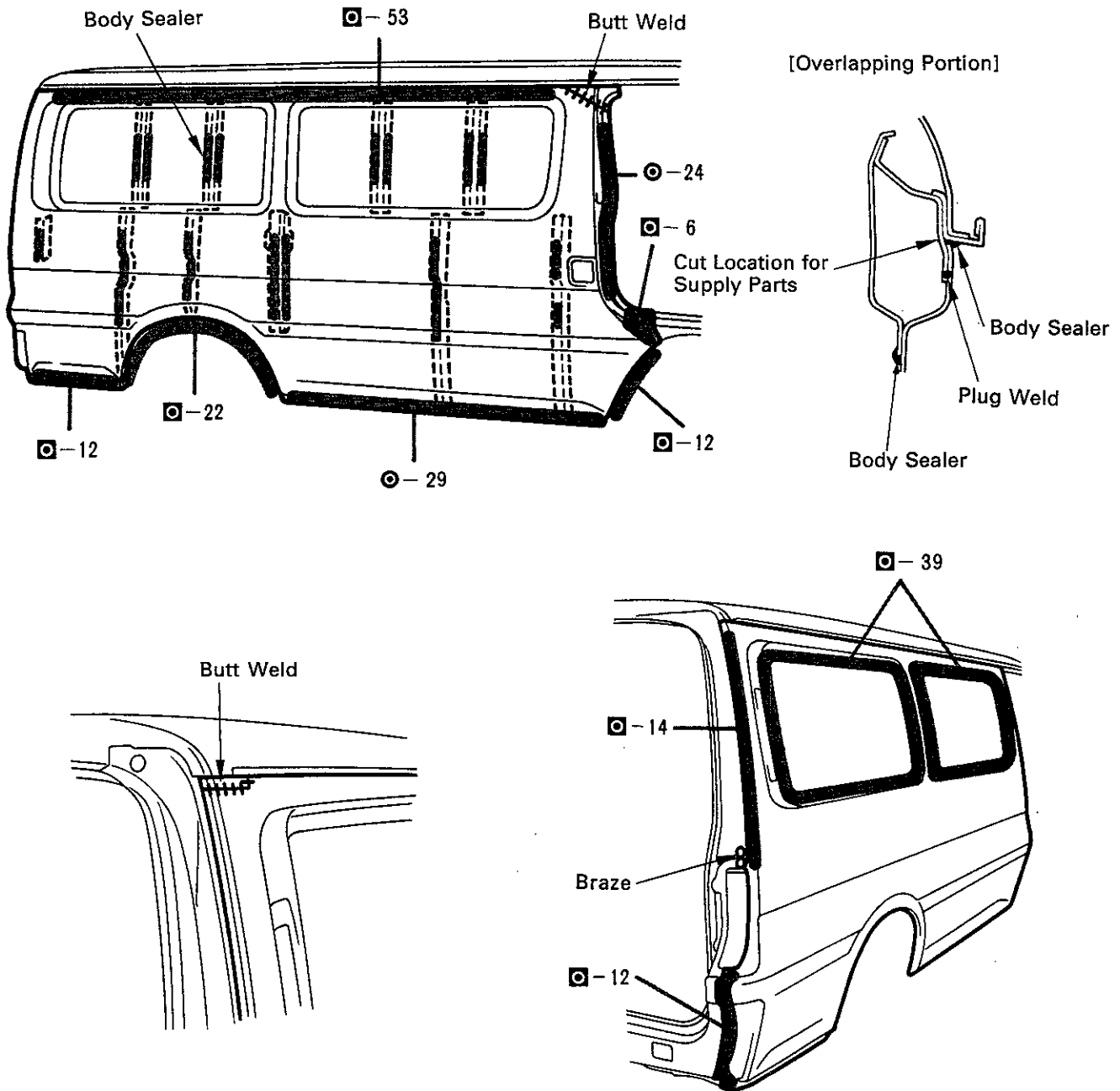
REMOVAL



mm	in.
15	0.59
20	0.79

1. Cut the parts at the locations shown above.

INSTALLATION



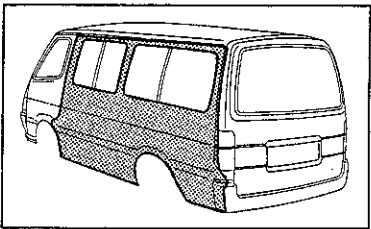
1. Before temporarily installing the new parts, apply body sealer to the locations shown above.

HINT:

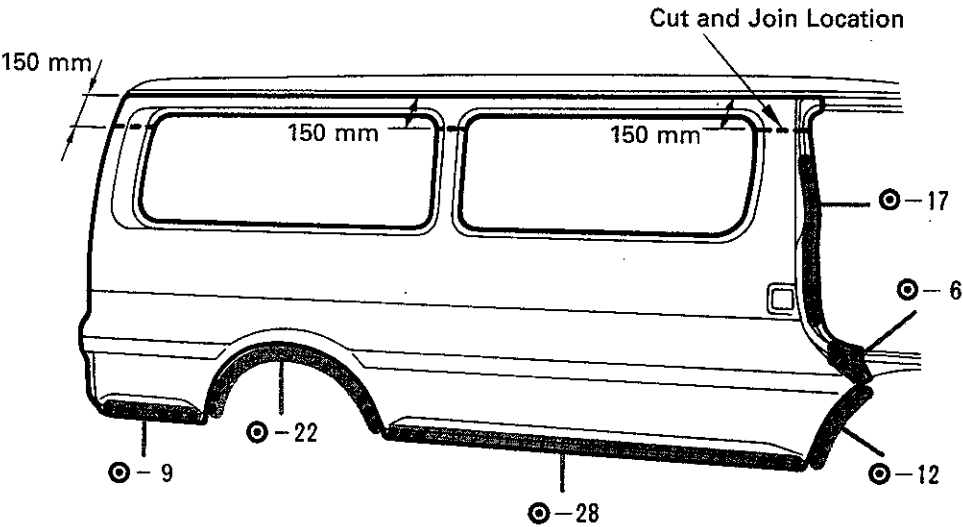
- 1) After welding the new parts, apply body sealer to the overlapping portion.
- 2) Apply just enough sealer for the new parts to make contact.

- 3) For other sealing points, refer to section AR.
2. Temporarily installing the new parts and check the fit of the front door, back door and rear combination light.
3. Overlap the new parts to the vehicle side panel, then plug weld it.

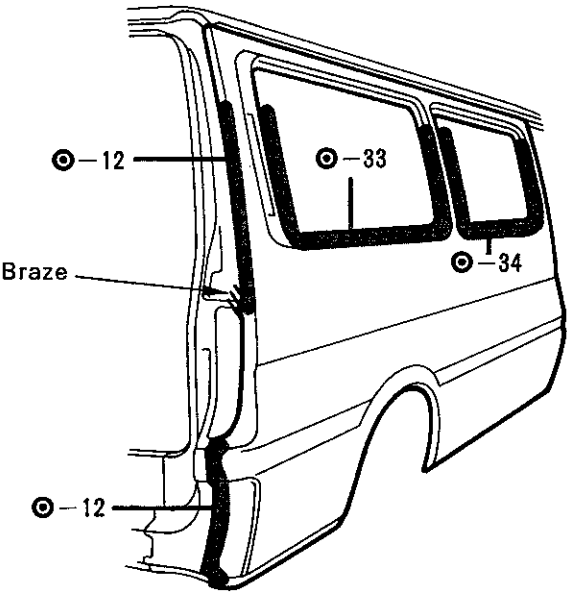
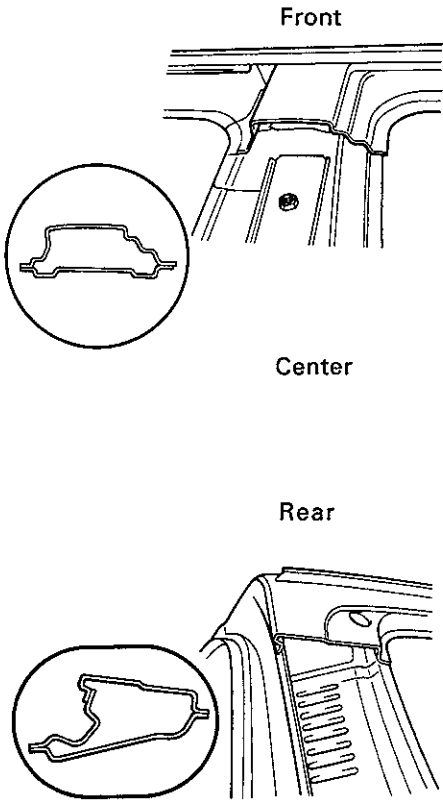
QUARTER PANEL (CUT): Without Slide Door Side (Long Wheel Base and Glass Van)



REMOVAL



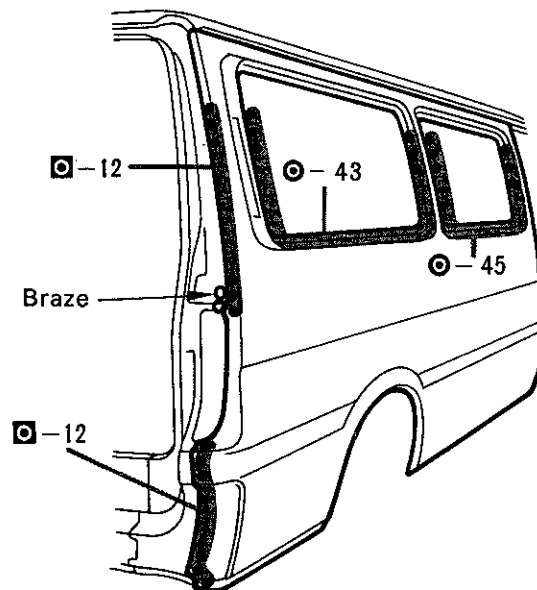
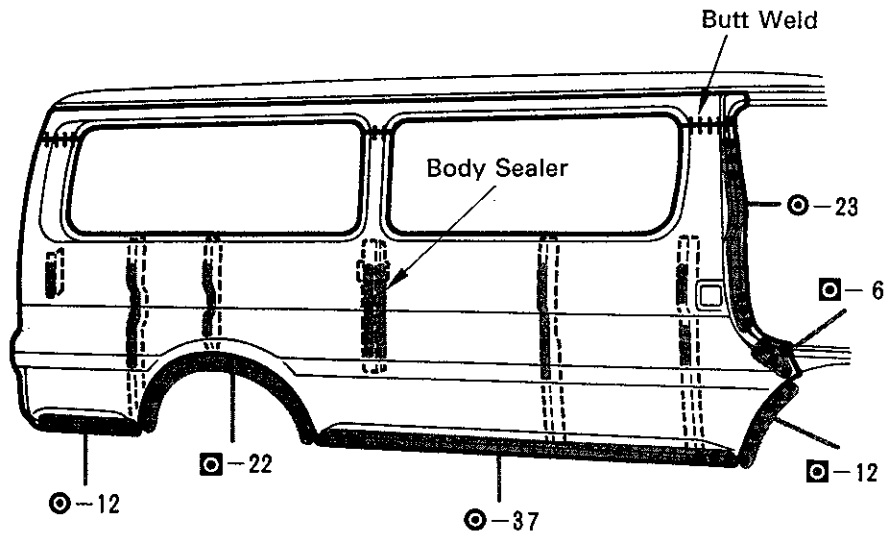
[Cut and Join Location]



mm	in.
150	5.91

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

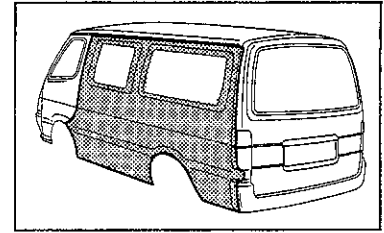
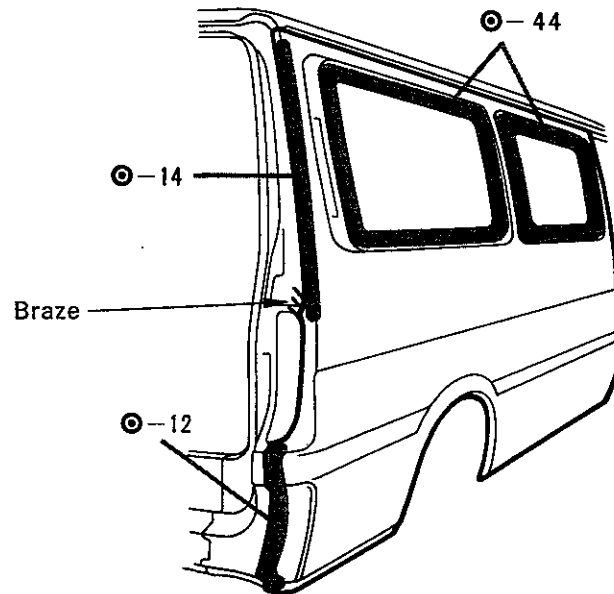
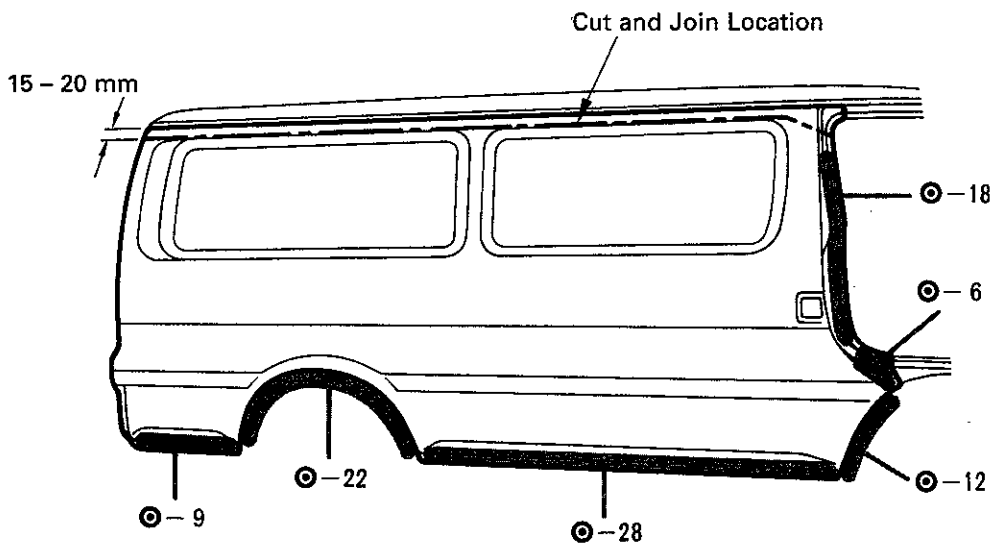
INSTALLATION



1. Before temporarily installing the new parts, apply body sealer to the locations shown above.
2. Temporarily install the new parts and check the fit of the front door, back door and rear combination light.

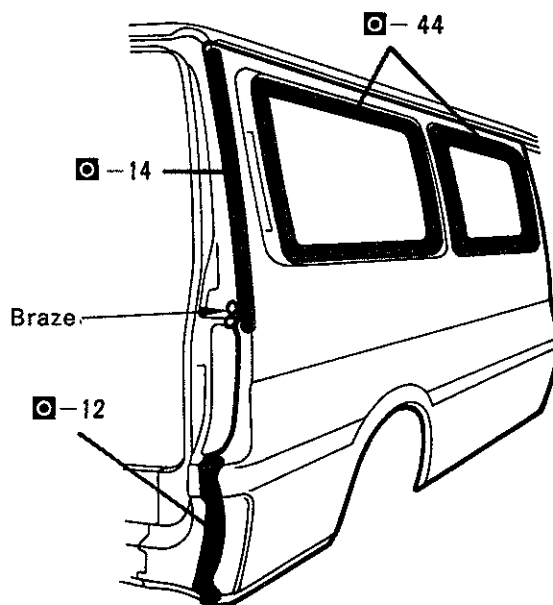
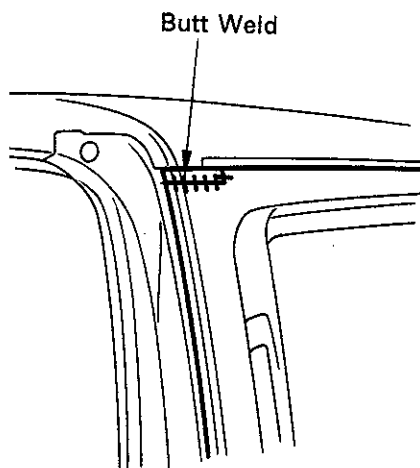
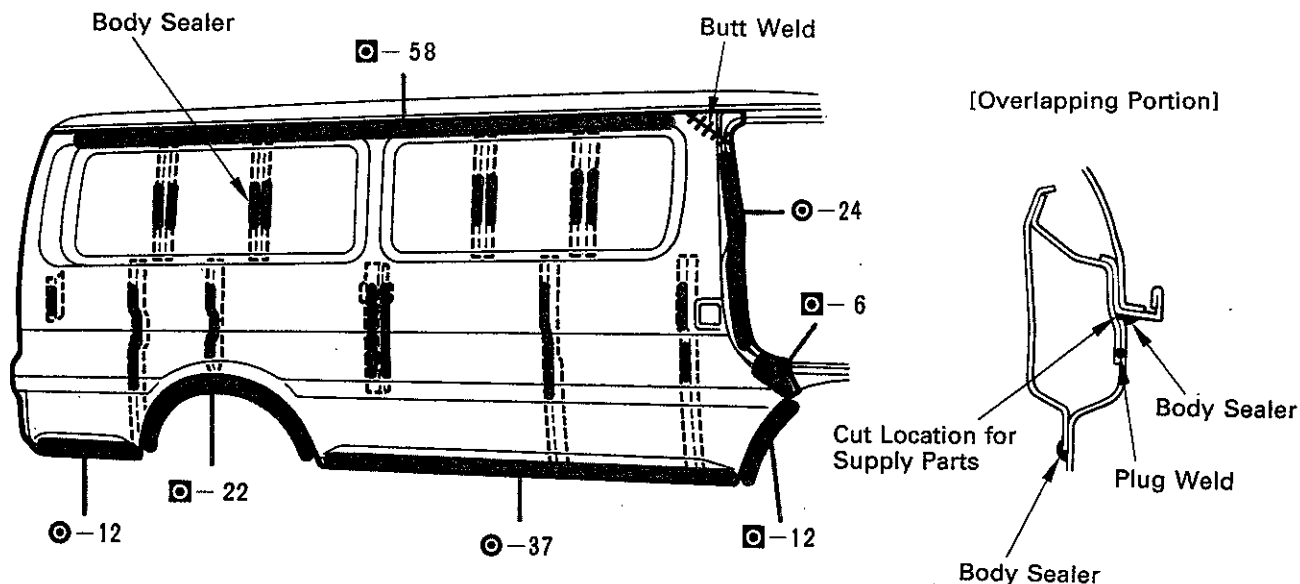
HINT:

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

QUARTER PANEL (CUT): Without Slide Door Side (Long Wheel Base and Panel Van)**REMOVAL**

1. Cut the parts at the locations shown above.

INSTALLATION



1. Before temporarily installing the new parts, apply body sealer to the locations shown above.

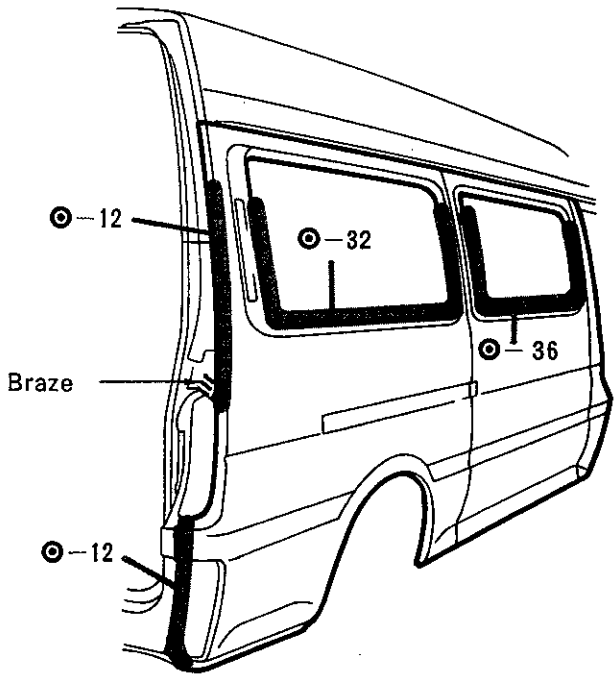
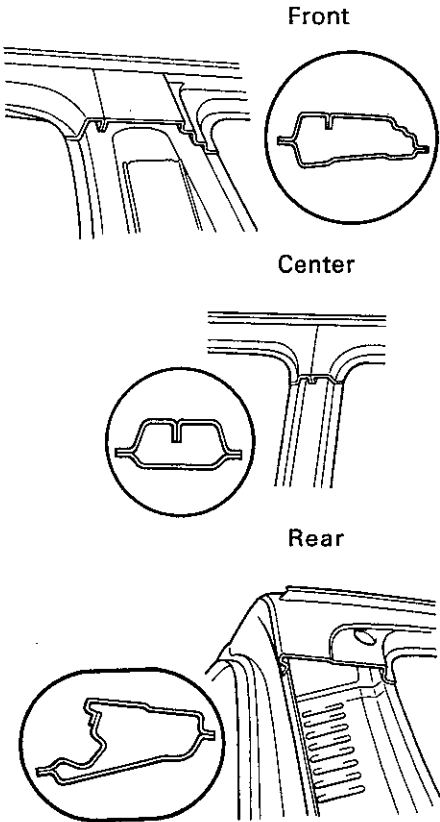
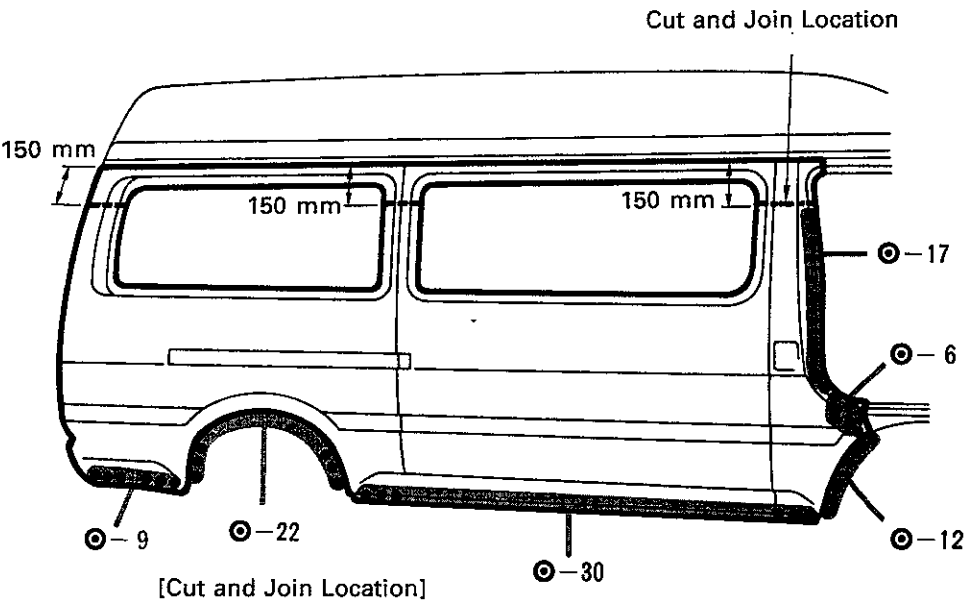
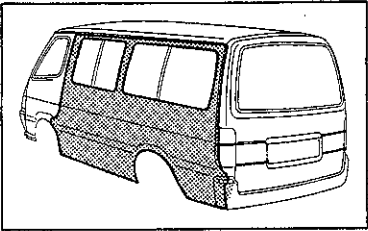
HINT:

- 1) After welding the new parts, apply body sealer to the overlapping portion.
- 2) Apply just enough sealer for the new parts to make contact.

- 3) For other sealing points, refer to section AR.
2. Temporarily installing the new parts and check the fit of the front door, back door and rear combination light.
3. Overlap the new parts to the vehicle side panel, then plug weld it.

QUARTER PANEL (CUT): Without Slide Door Side (Super Long Wheel Base)

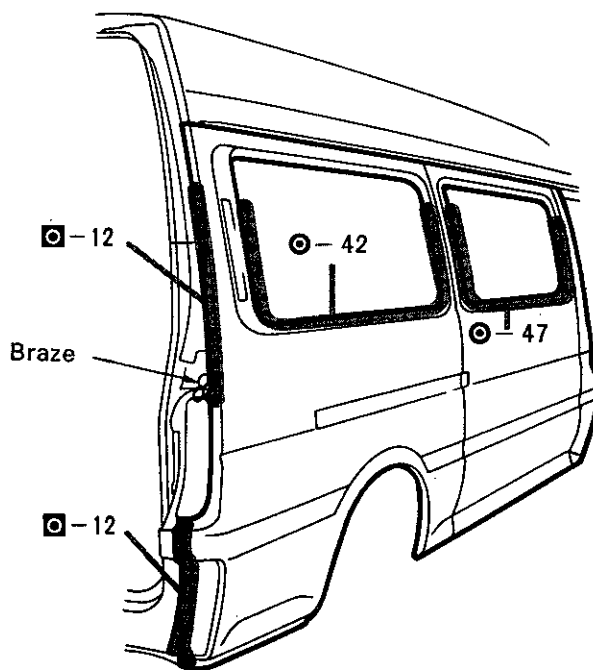
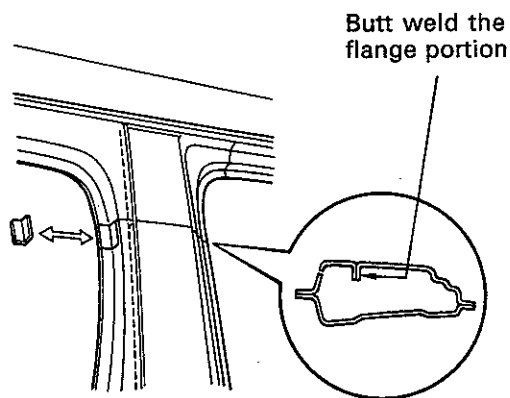
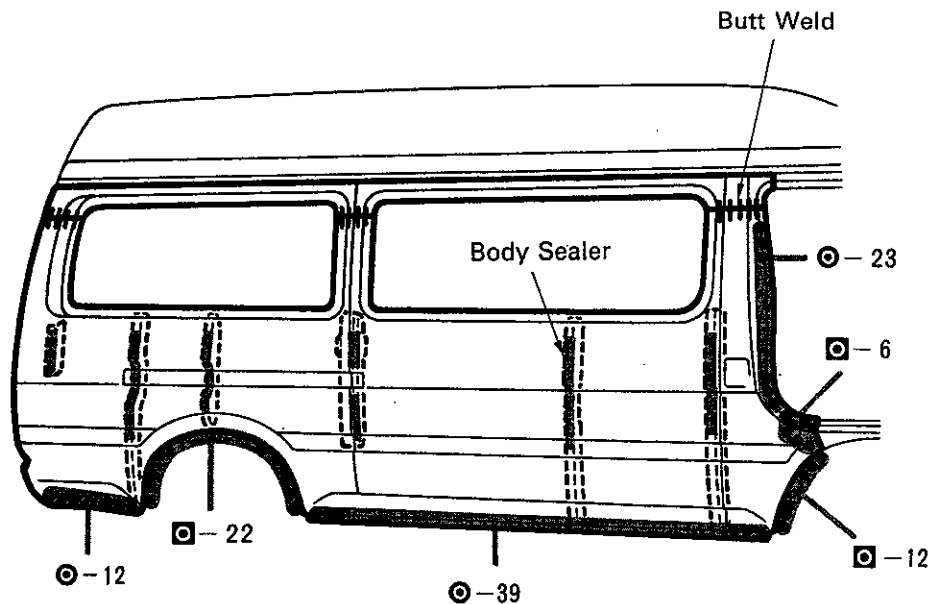
REMOVAL



mm	in.
150	5.91

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

INSTALLATION



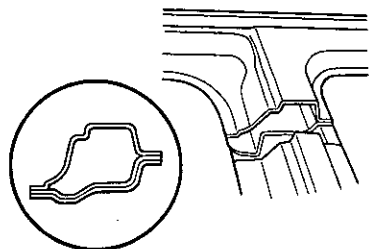
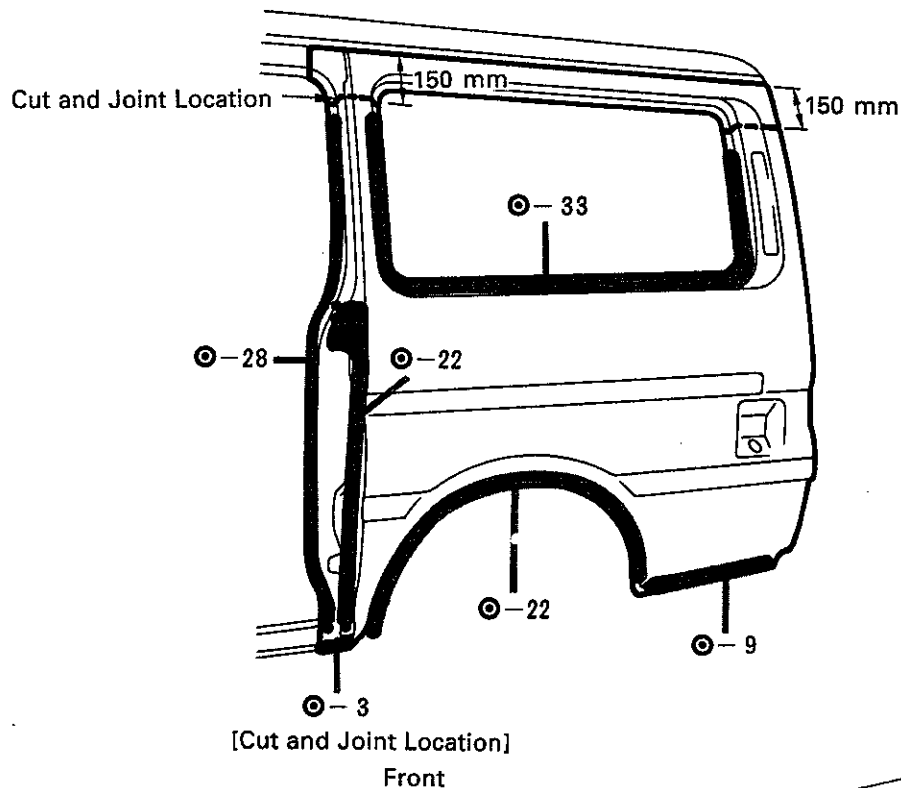
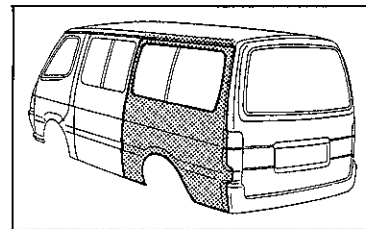
1. Before temporarily installing the new parts, apply body sealer to the locations shown above.
2. Temporarily install the new parts and check the fit of the front door, back door and rear combination light.

HINT:

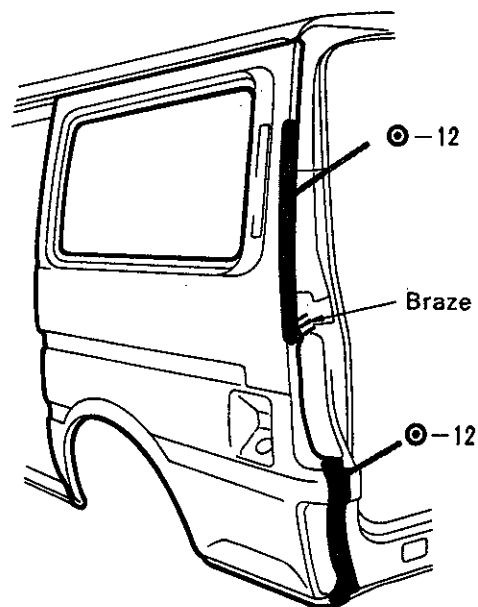
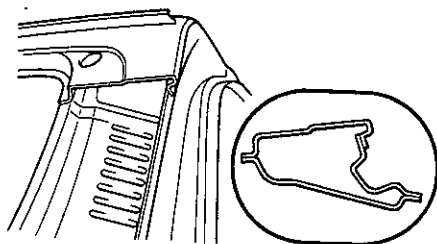
- 1) Apply just enough sealer for the new parts to make contact.
- 2) For other sealing points, refer to section AR.

QUARTER PANEL (CUT): With Slide Door Side (Standard Wheel Base and Glass Van)

REMOVAL



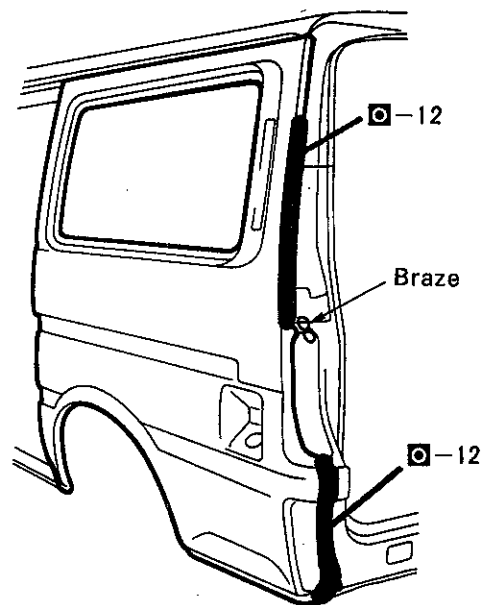
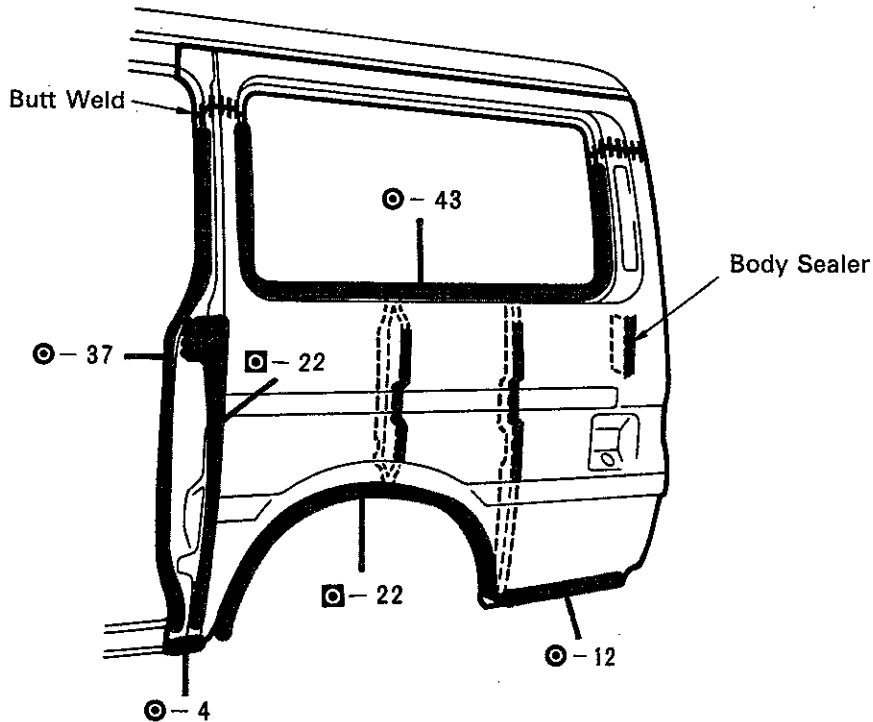
Rear



mm	in.
150	5.91

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

INSTALLATION



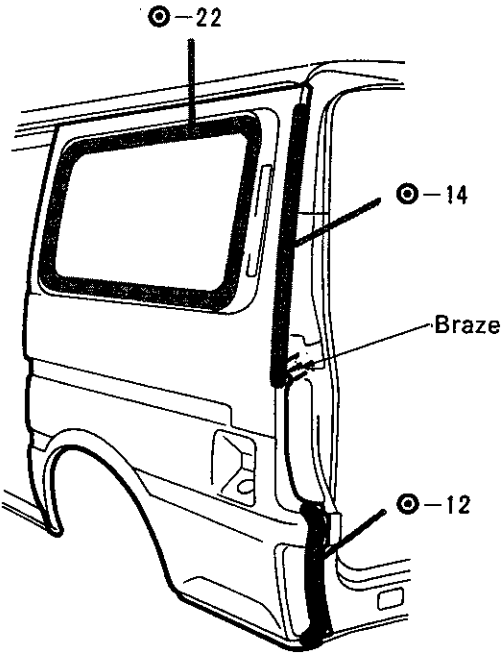
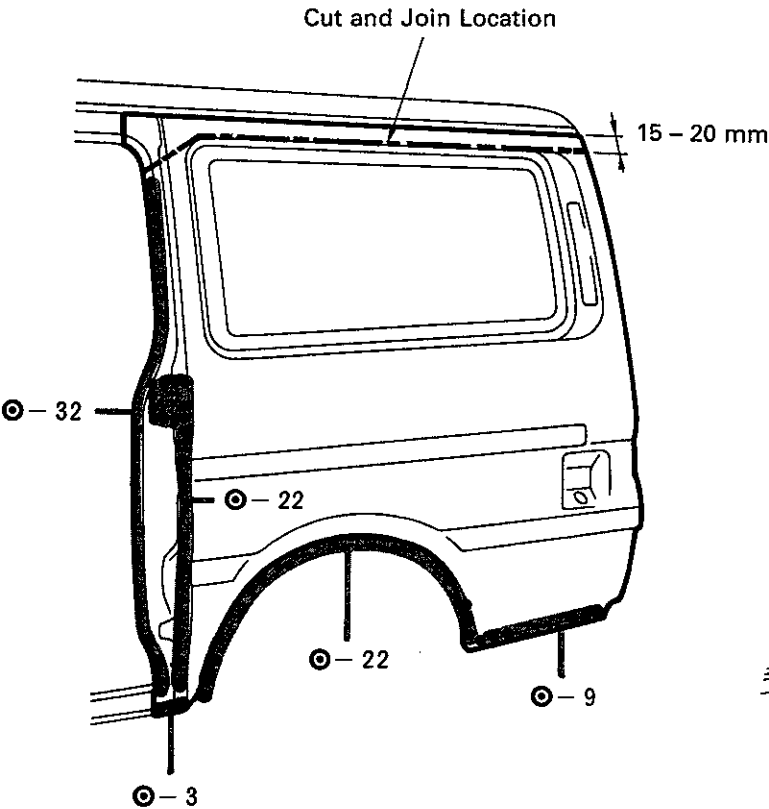
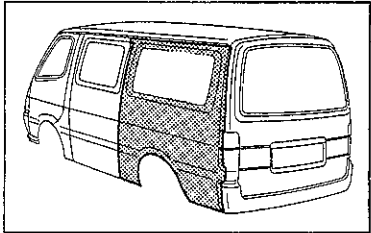
1. Before temporarily installing the new parts, apply body sealer to the locations shown above.
2. Temporarily install the new parts and check the fit of the slide door, back door and rear combination light.

HINT:

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

QUARTER PANEL (CUT): With Slide Door
Side (Standard Wheel Base and Panel Van)

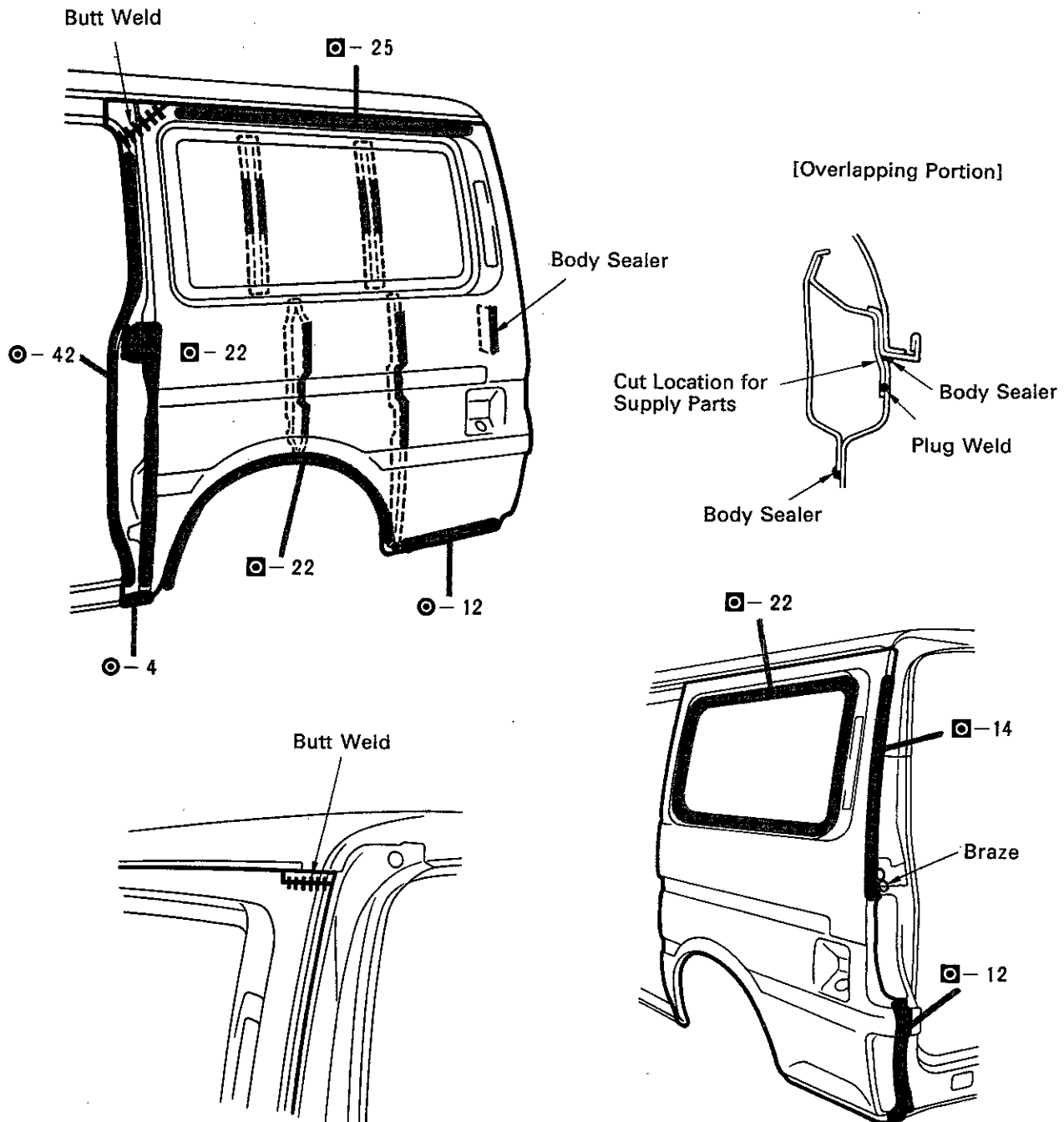
REMOVAL



mm	in.
15	0.59
20	0.79

1. Cut the parts at the locations shown above.

INSTALLATION



1. Before temporarily installing the new parts, apply body sealer to the locations shown above.

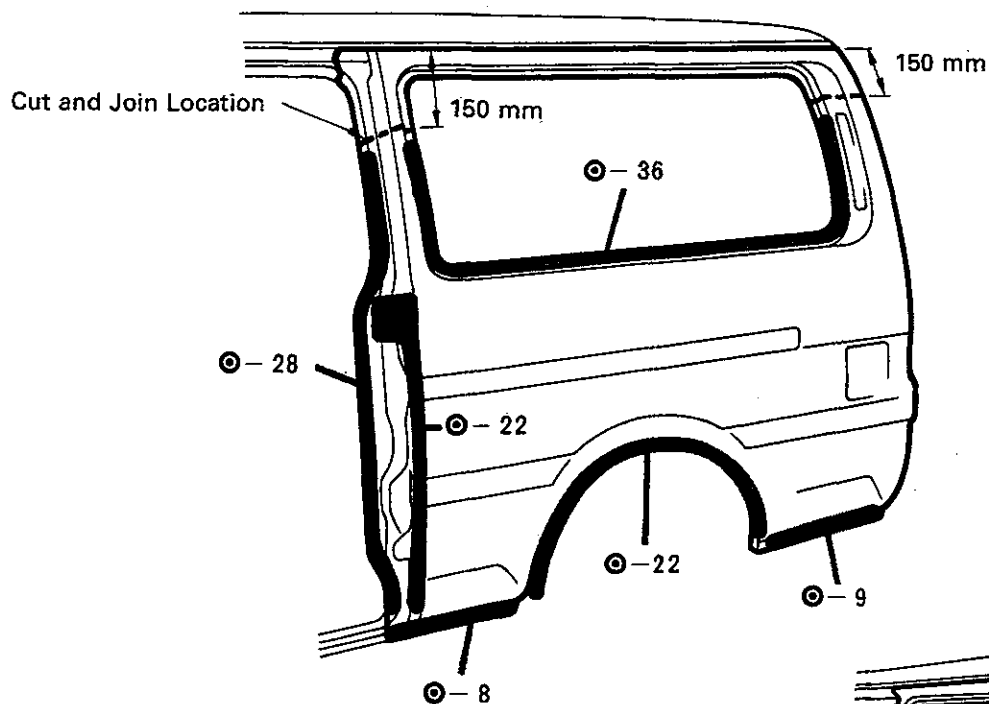
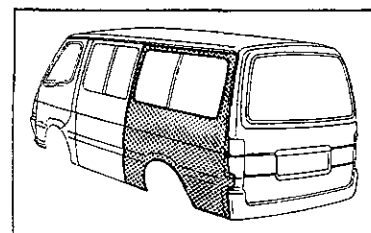
HINT:

- 1) After welding the new parts, apply body sealer to the overlapping portion.
- 2) Apply just enough sealer for the new parts to make contact.

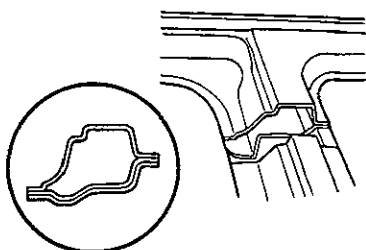
- 3) For other sealing points, refer to section AR.
2. Temporarily installing the new parts and check the fit of the slide door, back door and rear combination light.
3. Overlap the new parts to the vehicle side panel, then plug weld it.

QUARTER PANEL (CUT): With Slide Door Side (Long Wheel Base and Glass Van)

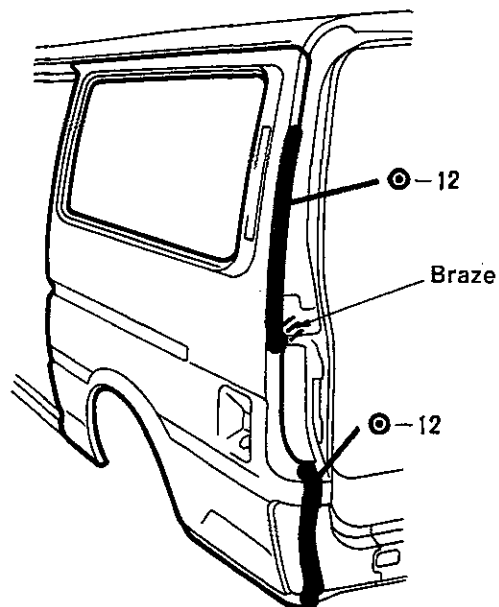
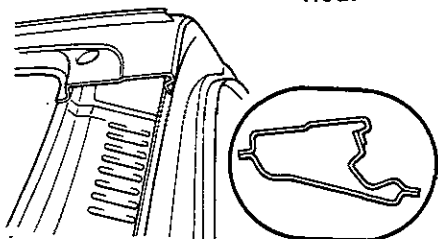
REMOVAL



[Cut and Join Location]
Front



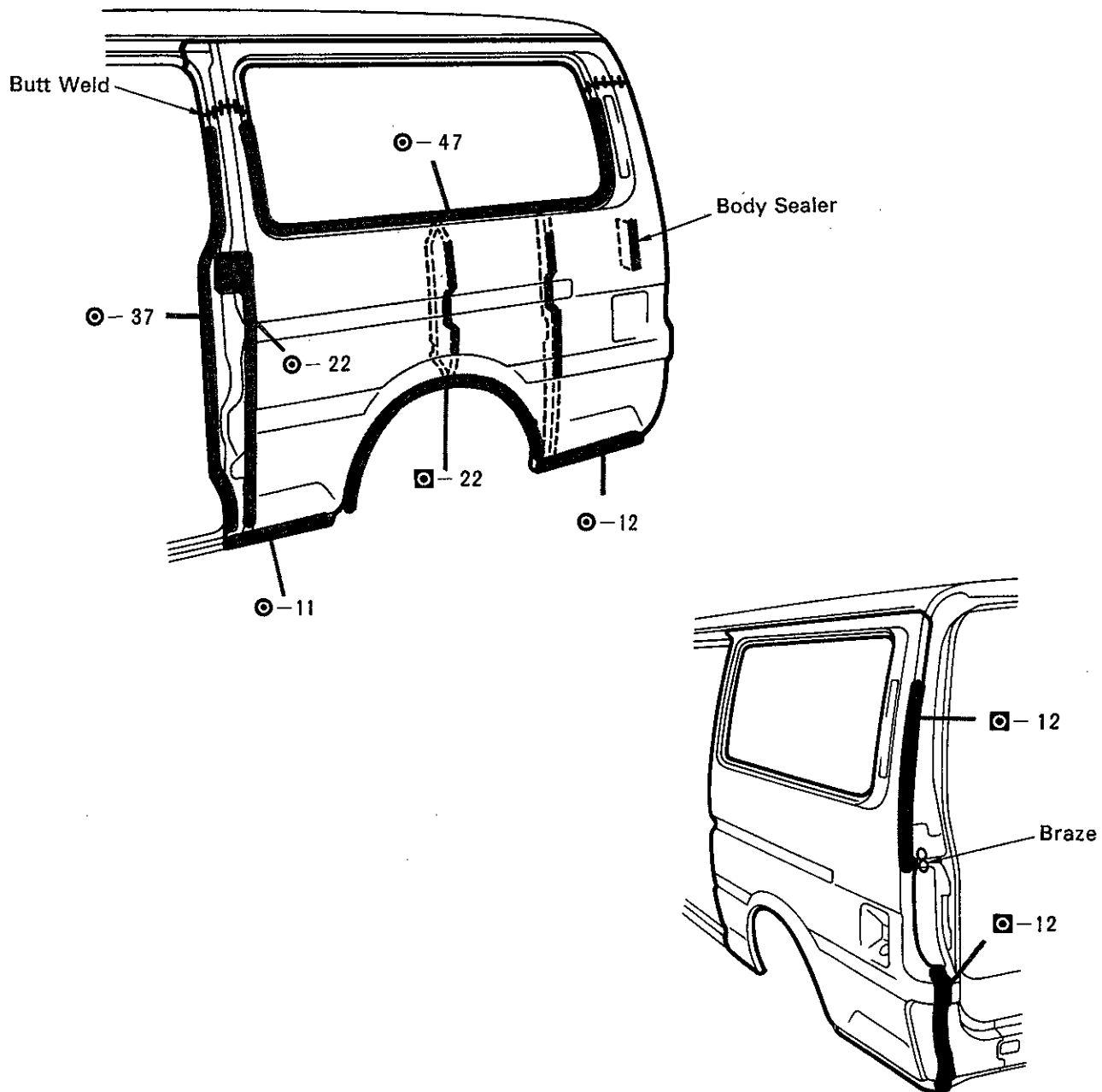
Rear



mm	in.
150	5.91

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

INSTALLATION



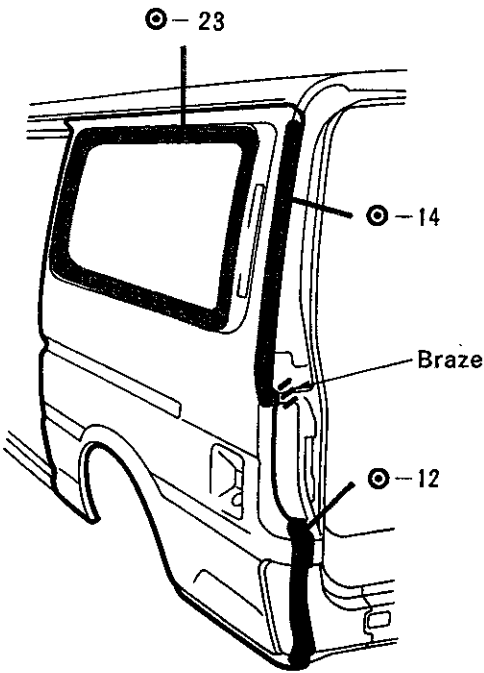
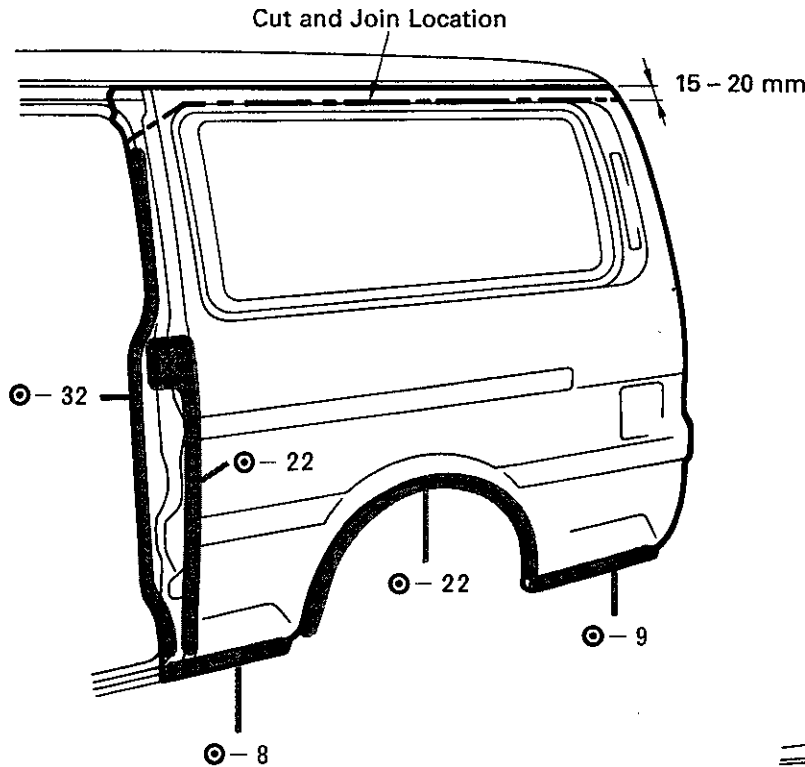
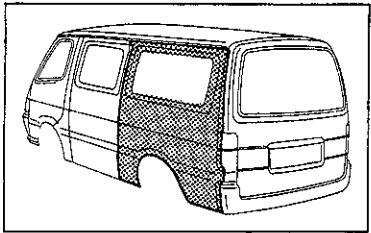
1. Before temporarily installing the new parts, apply body sealer to the locations shown above.
2. Temporarily install the new parts and check the fit of the slide door, back door and rear combination light.

HINT:

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

QUARTER PANEL (CUT): With Slide Door Side (Long Wheel Base and Panel Van)

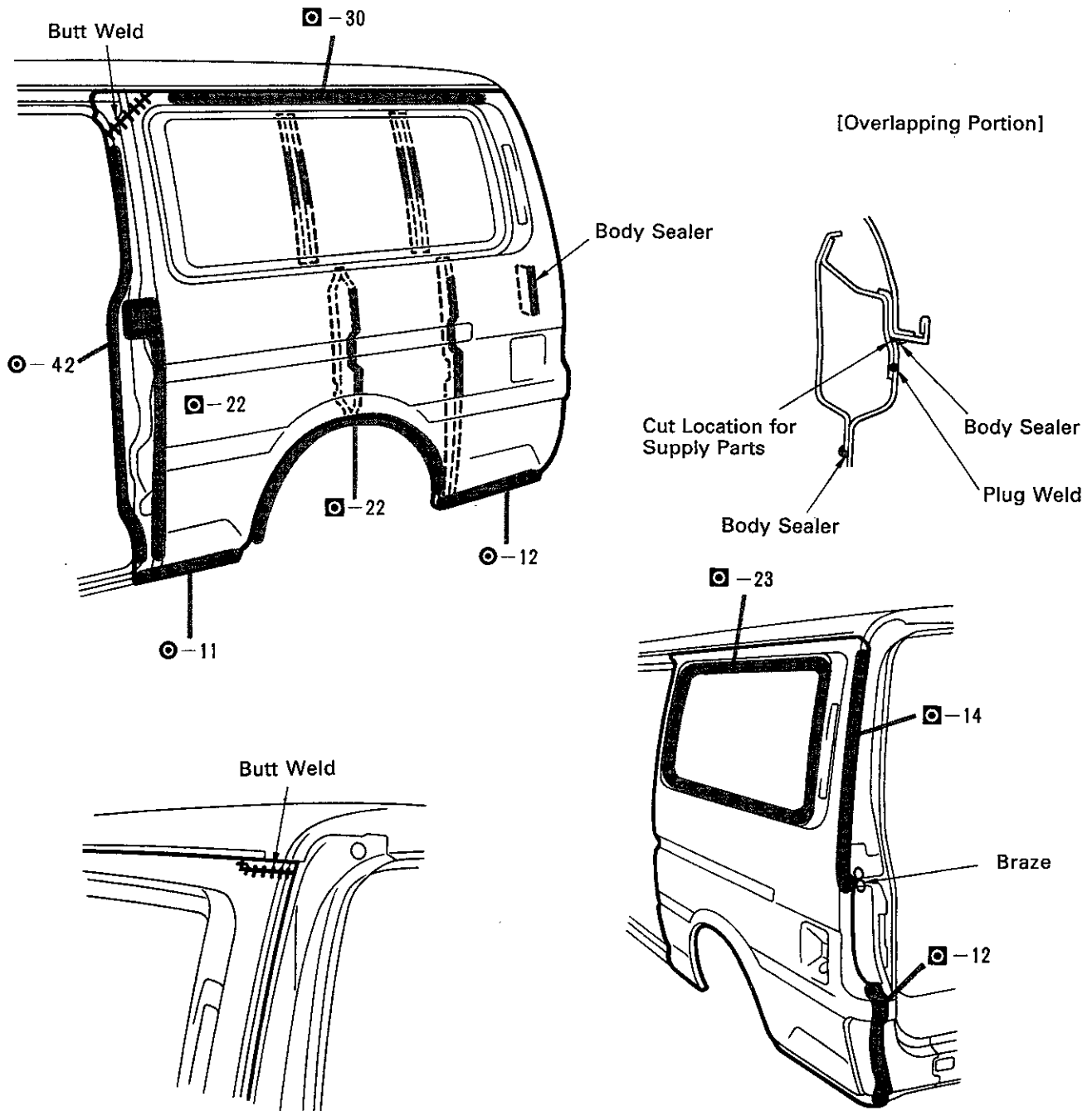
REMOVAL



mm	in.
15	0.59
20	0.79

1. Cut the parts at the locations shown above.

INSTALLATION



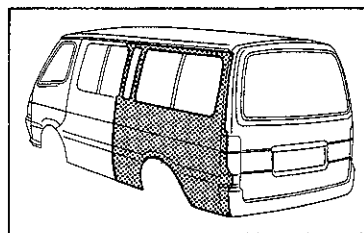
1. Before temporarily installing the new parts, apply body sealer to the locations shown above.

HINT:

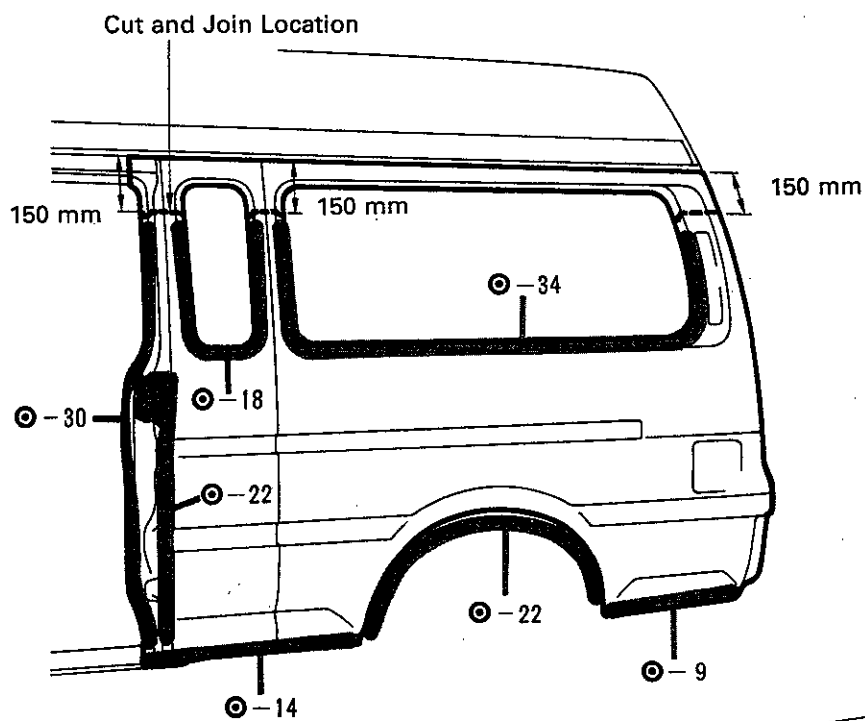
- 1) After welding the new parts, apply body sealer to the overlapping portion.
- 2) Apply just enough sealer for the new parts to make contact.

- 3) For other sealing points, refer to section AR.
2. Temporarily installing the new parts and check the fit of the slide door, back door and rear combination light.
3. Overlap the new parts to the vehicle side panel, then plug weld it.

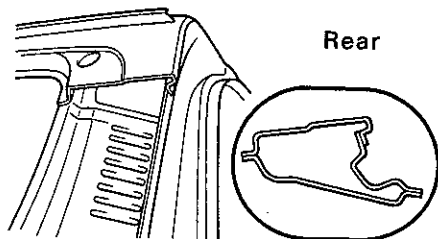
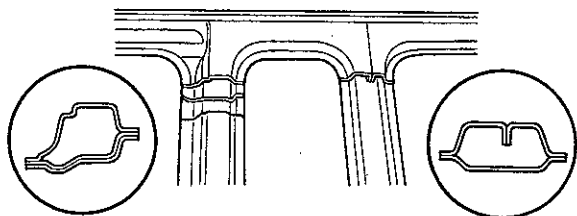
QUARTER PANEL (CUT): With Slide Door Side (Super Long Wheel Base)



REMOVAL



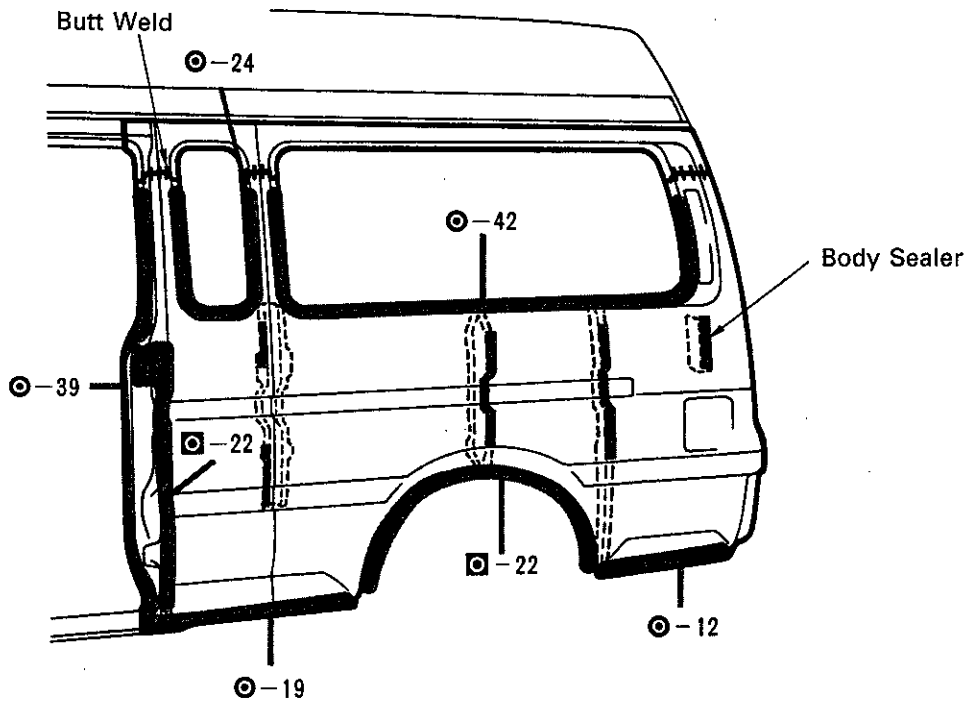
Front [Cut and Join Location] Center



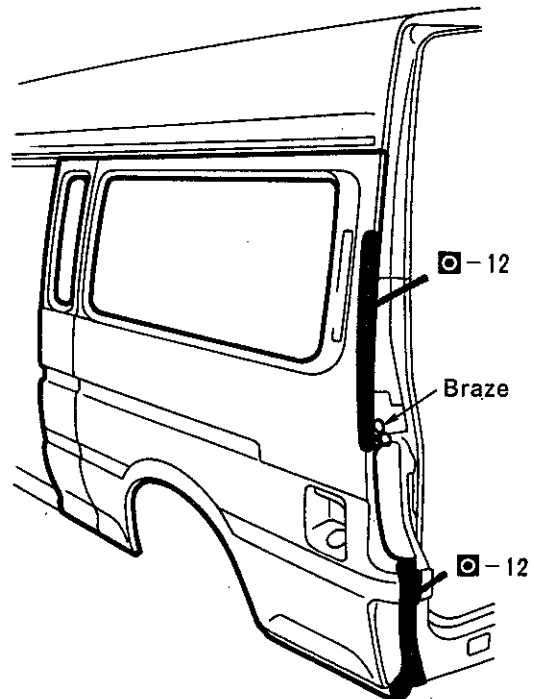
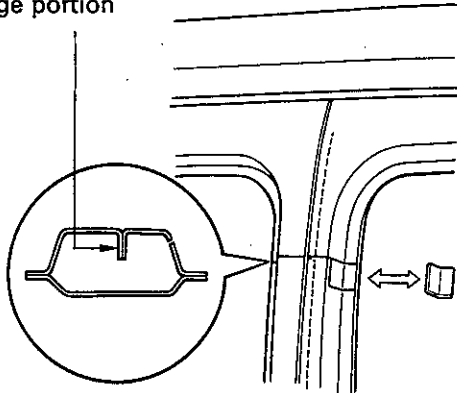
mm	in.
150	5.91

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

INSTALLATION



Butt weld the
flange portion



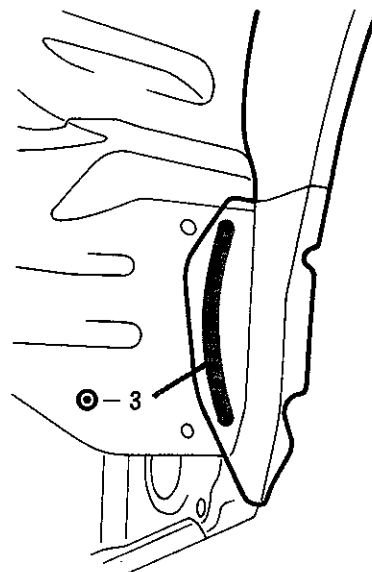
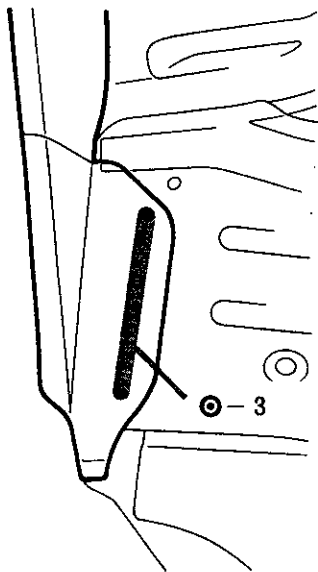
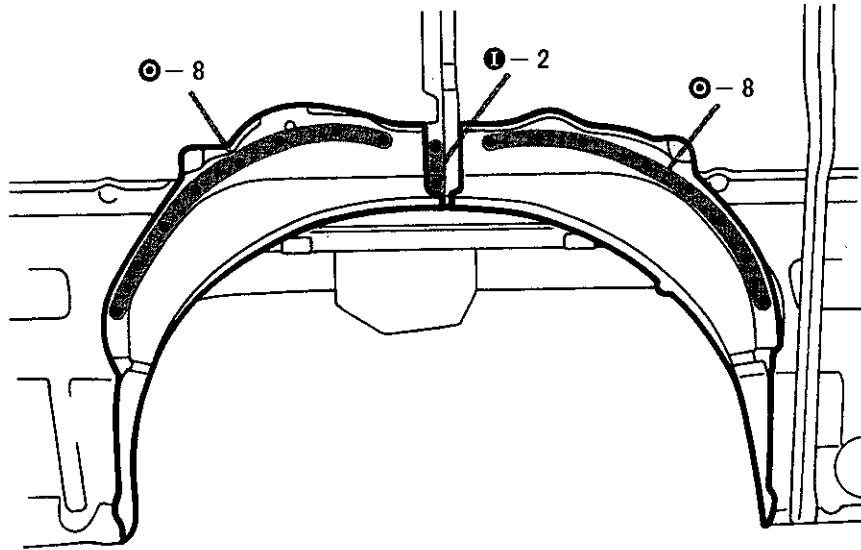
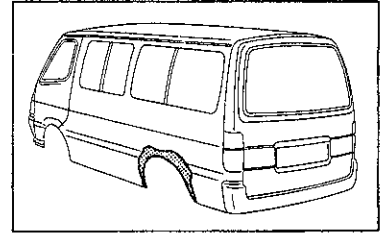
1. Before temporarily installing the new parts, apply body sealer to the locations shown above.
2. Temporarily install the new parts and check the fit of the slide door, back door and rear combination light.

HINT:

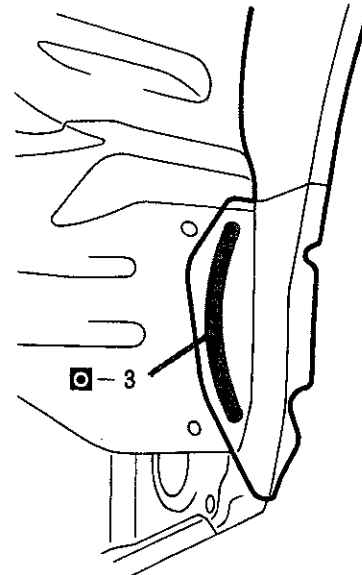
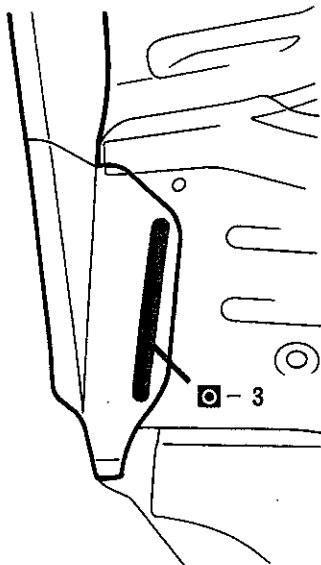
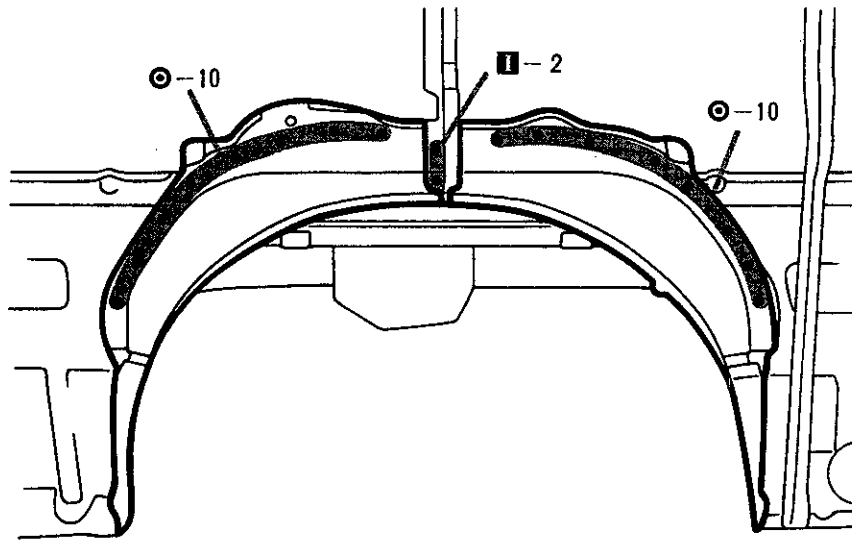
- 1) Apply just enough sealer for the new parts to make contact.
- 2) For other sealing points, refer to section AR.

QUARTER WHEEL HOUSING OUTER PANEL (ASSY)

REMOVAL (With the quarter panel removed.)



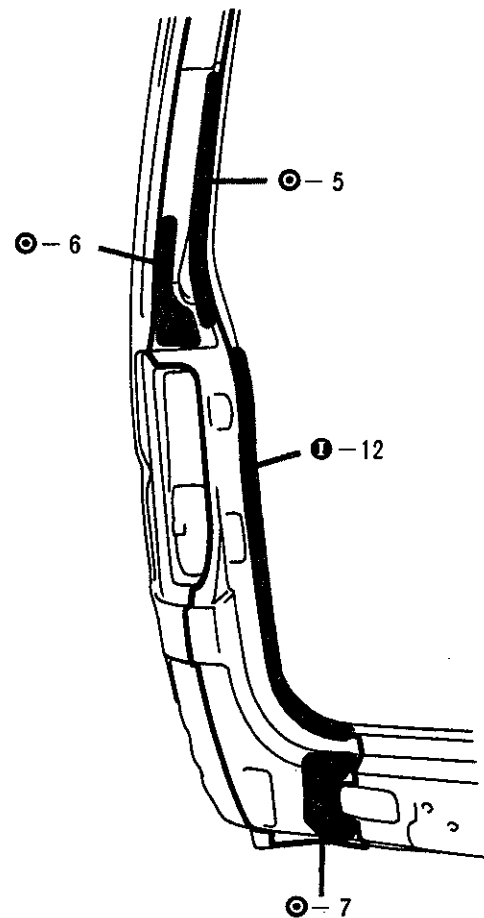
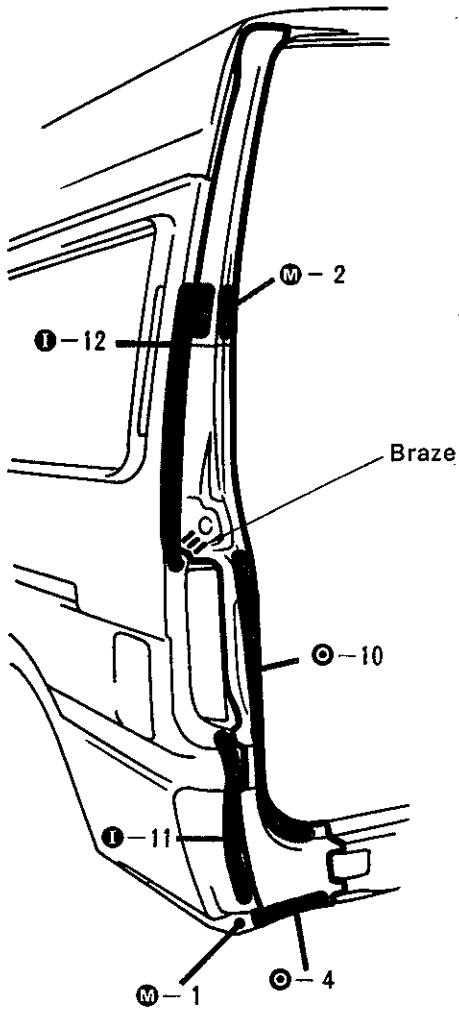
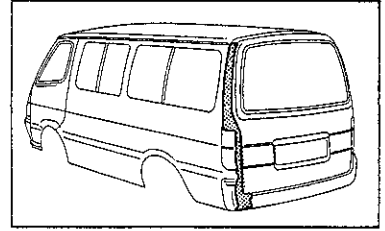
INSTALLATION



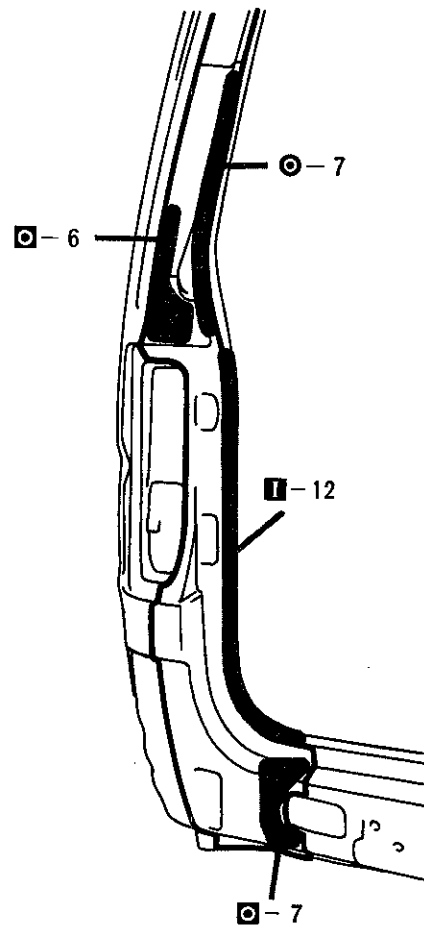
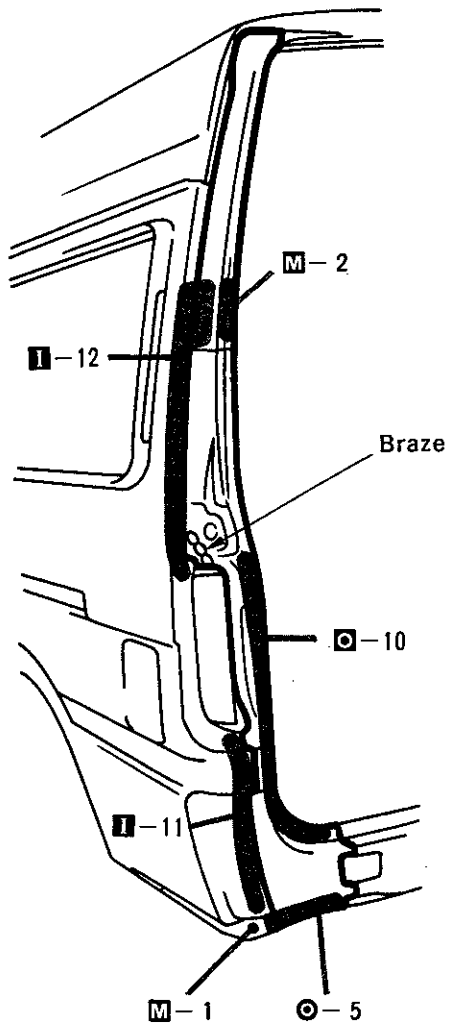
1. Before welding the new parts, temporarily install the quarter panel and check the fit.

BACK DOOR OPENING SIDE FLAME (ASSY)

REMOVAL

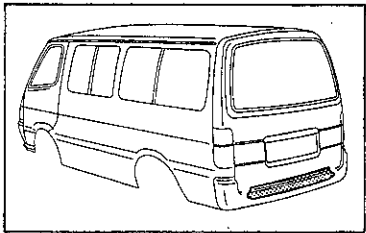


INSTALLATION

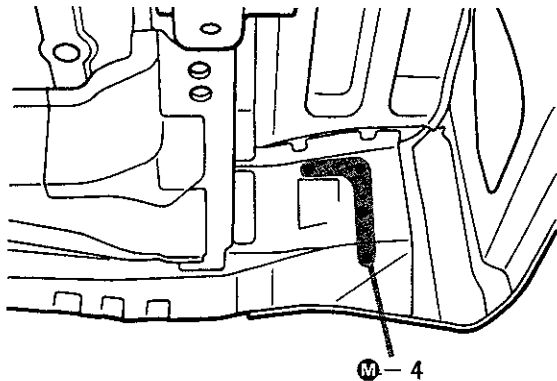


1. Temporarily install the new parts and check the fit of the back door and rear combination light.

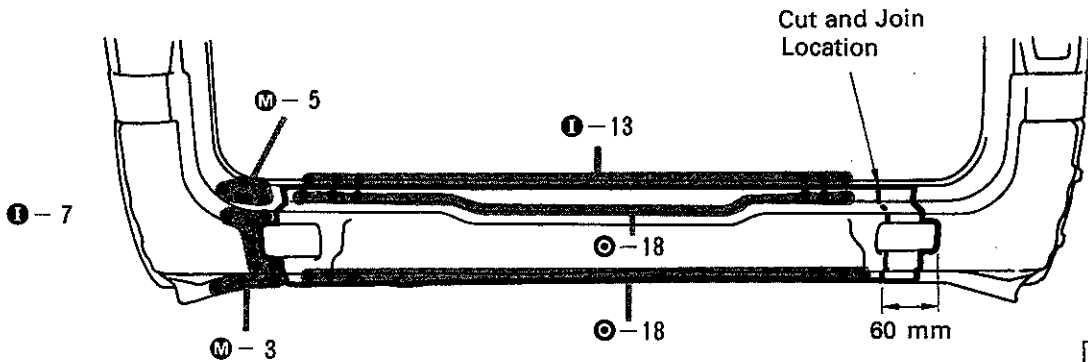
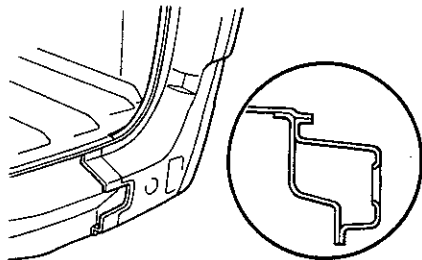
**REAR FLOOR REAR CROSSMEMBER OUTER
(CUT)**



REMOVAL

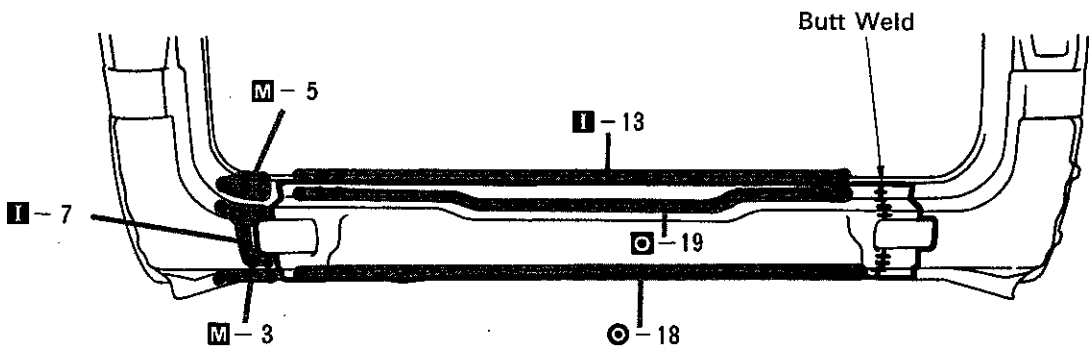
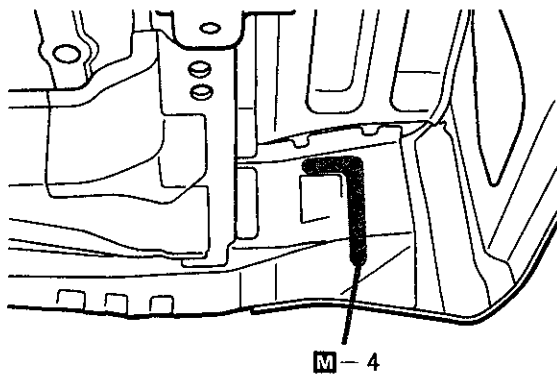


[Cut and Join Location]



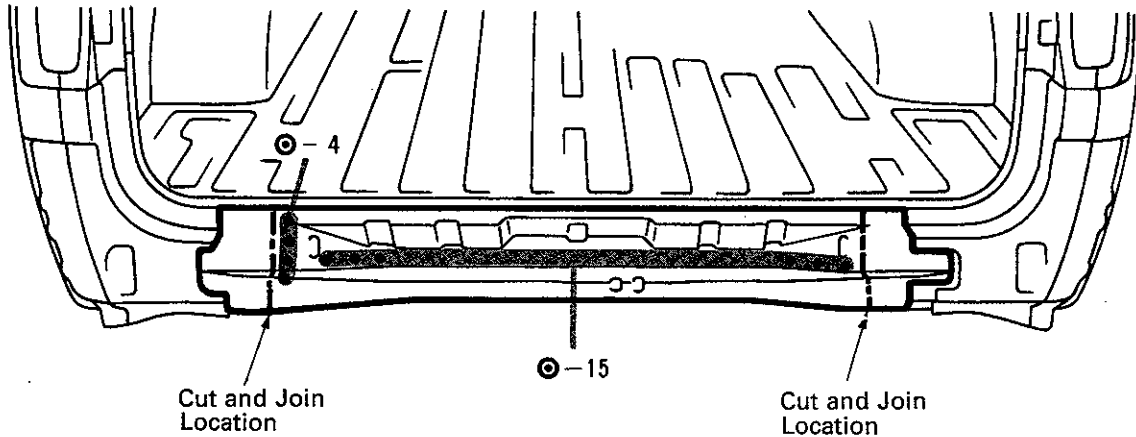
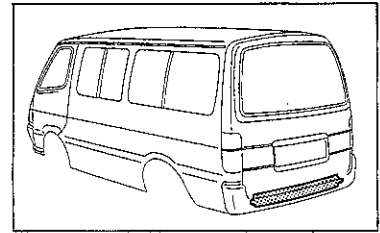
mm	in.
60	2.36

INSTALLATION



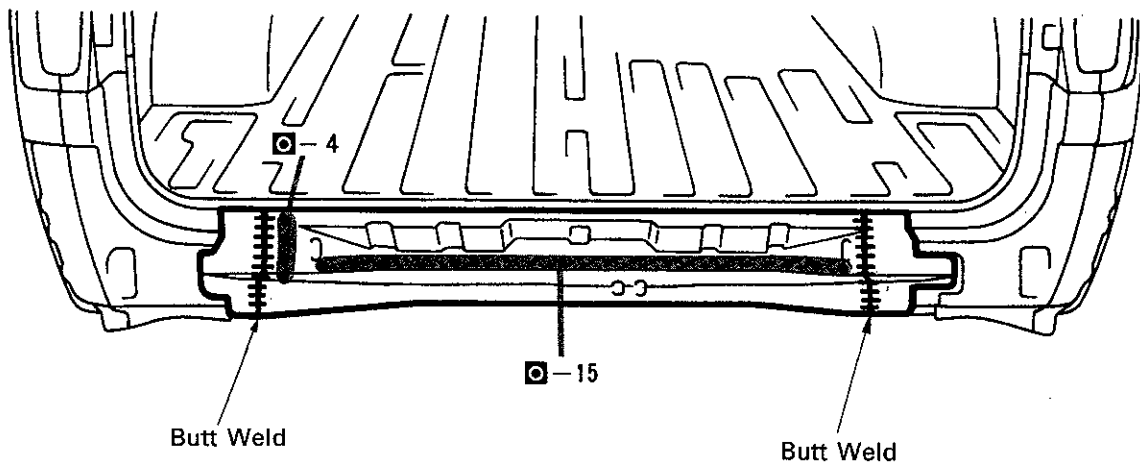
REAR FLOOR REAR CROSSMEMBER INNER (CUT)

REMOVAL (With the rear floor rear crossmember outer removed.)



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

INSTALLATION



1. Before welding the new parts, temporarily install the rear floor rear crossmember outer and check the fit of the back door.

