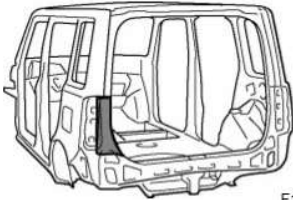
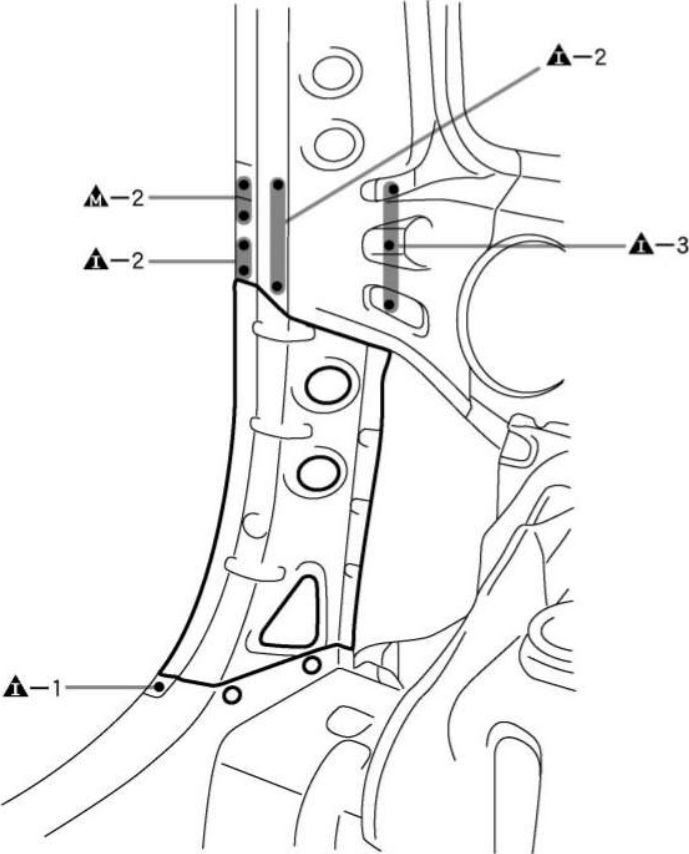


BODY PANEL REPLACEMENT

BP-49

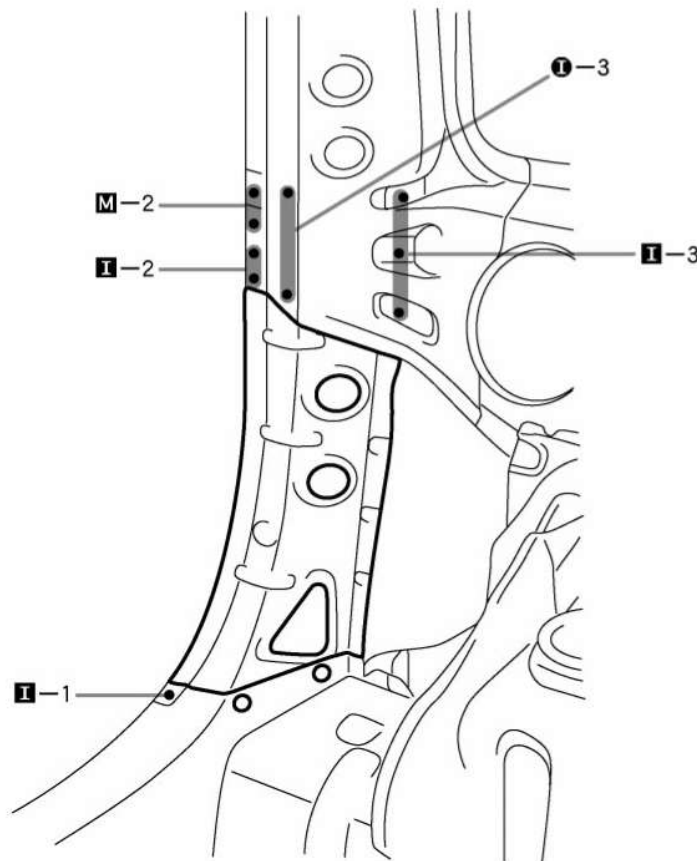
BACK DOOR OPENING SIDE REINFORCEMENT (ASSY)	 F15646A
REPLACEMENT With the roof side inner front extension removed.	
REMOVAL  F15646	

BP-50

BODY PANEL REPLACEMENT

INSTALLATION

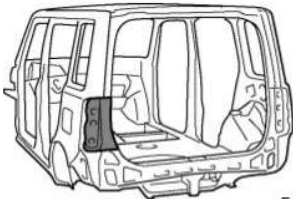
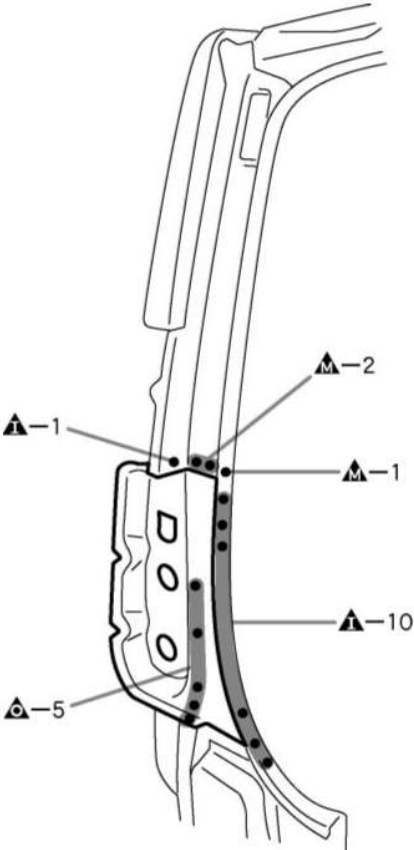
- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



F15647

BODY PANEL REPLACEMENT

BP-45

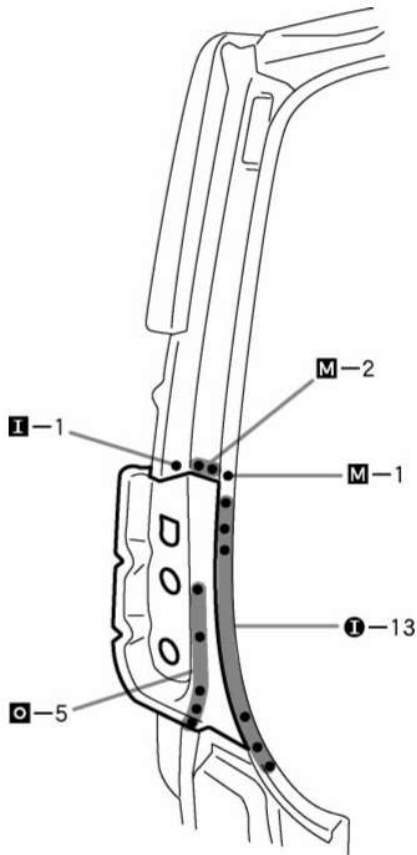
BACK DOOR OPENING TROUGH (ASSY)	 F15642A
REPLACEMENT With the body lower back panel and quarter panel removed.	
REMOVAL  F15642	

BP-46

BODY PANEL REPLACEMENT

INSTALLATION

- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



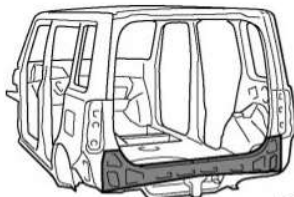
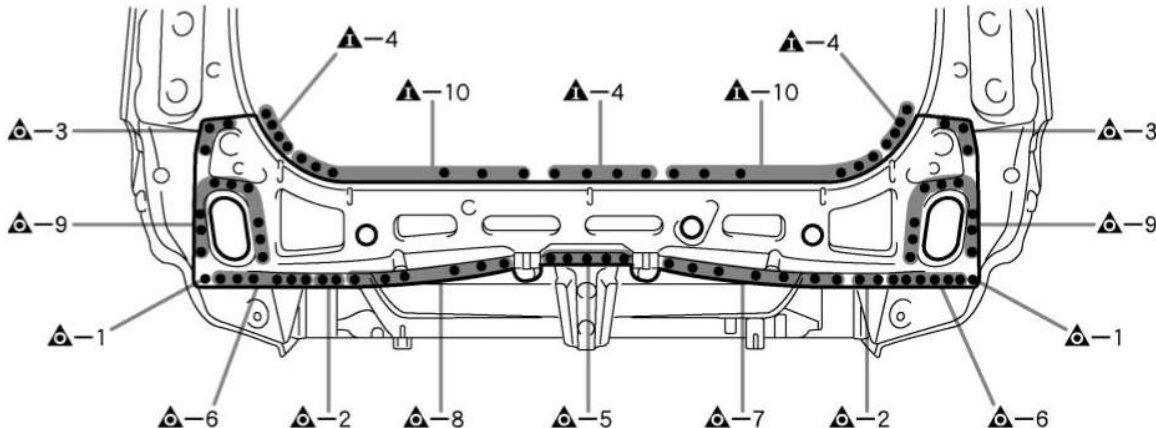
F15643

POINT

- 1 Inspect the fitting of the back door and rear combination light, etc., before welding, since this affects the appearance of the finish.

BODY PANEL REPLACEMENT

BP-43

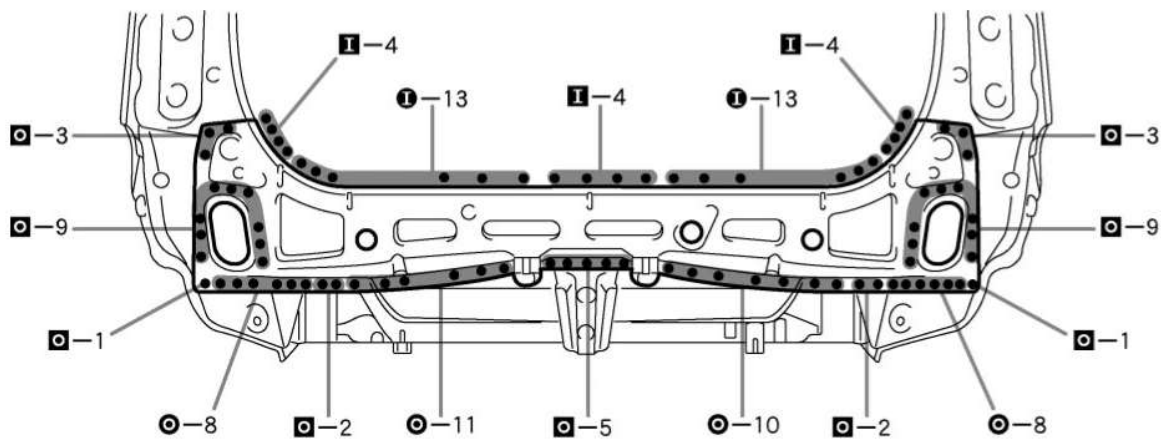
BODY LOWER BACK PANEL (ASSY)		 F15640A
REPLACEMENT		
REMOVAL		
 F15640		

BP-44

BODY PANEL REPLACEMENT

INSTALLATION

- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



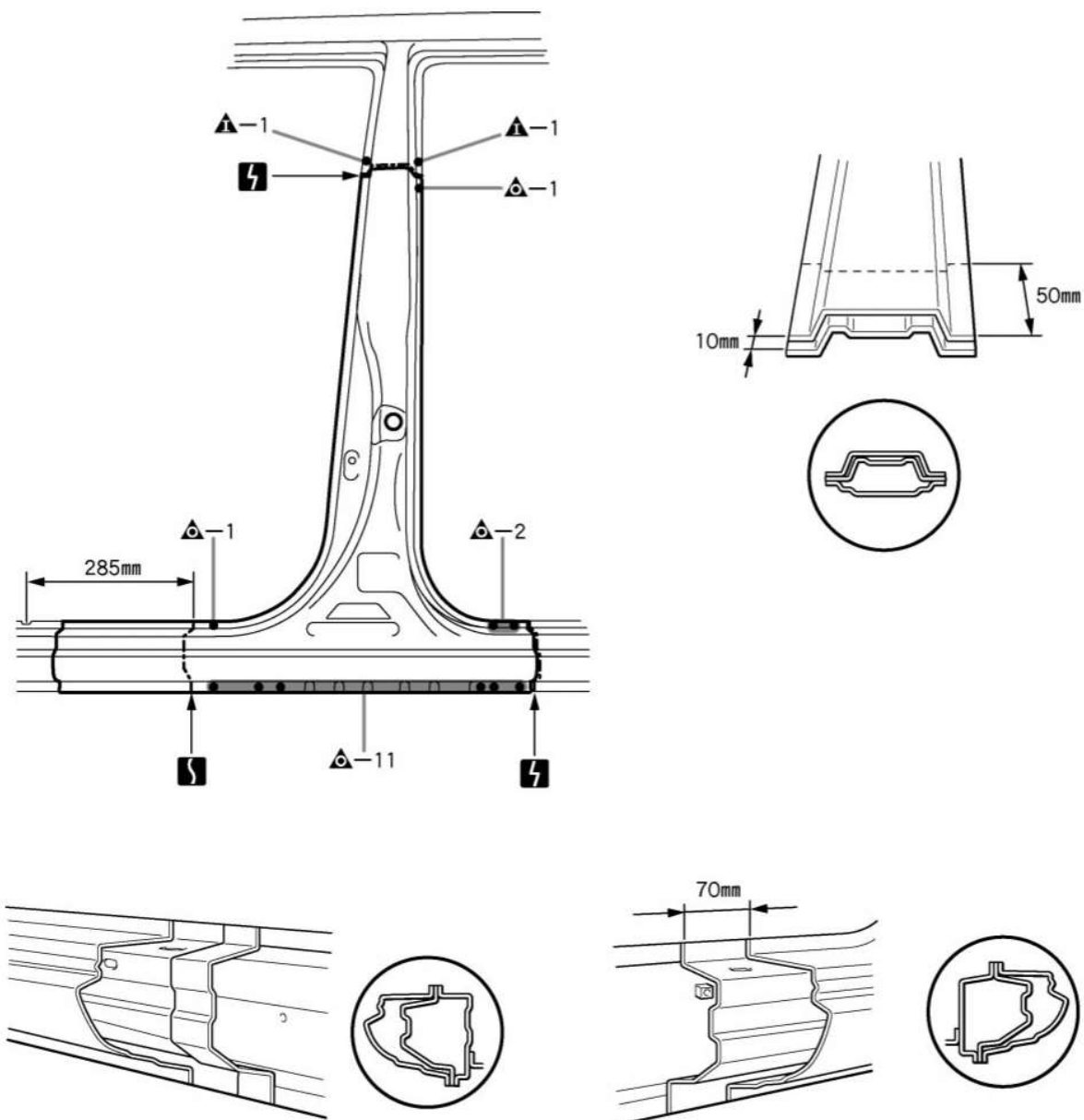
F15641

POINT

- 1 Inspect the fitting of the back door and rear combination light, etc., before welding, since this affects the appearance of the finish.

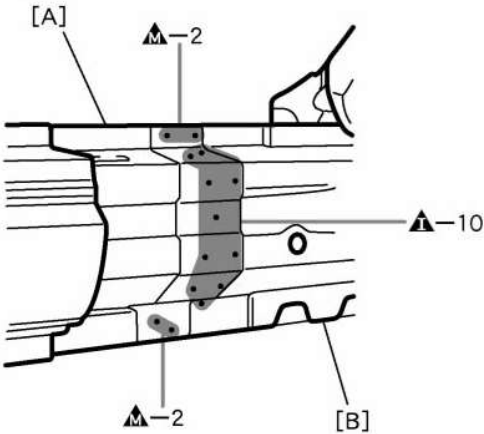
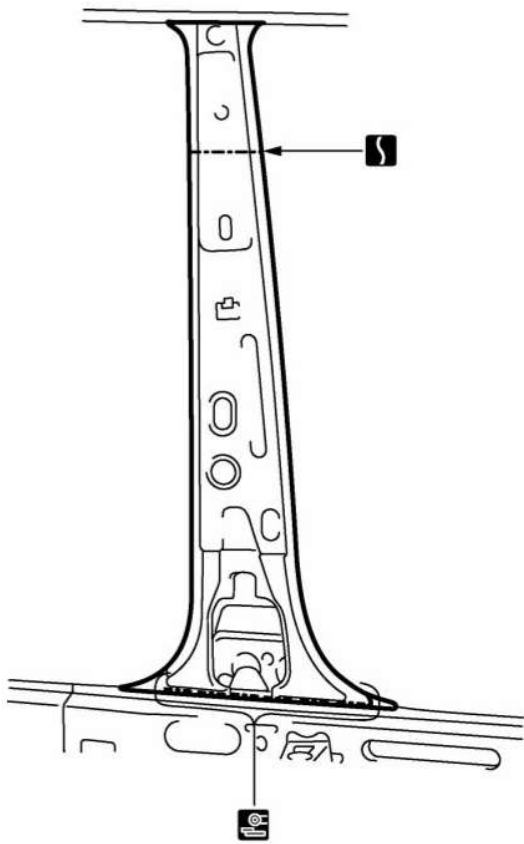
BP-26

BODY PANEL REPLACEMENT

CENTER BODY PILLAR (CUT)		 F15626A	
REPLACEMENT			
REMOVAL			
 F15626			
10mm (0.39in.)	50mm (1.97in.)	70mm (2.76in.)	285mm (11.22in.)

BODY PANEL REPLACEMENT

BP-27



F15627

POINT

- 1. Leave the [A] to the vehicle and remove the [B].

PART NAME

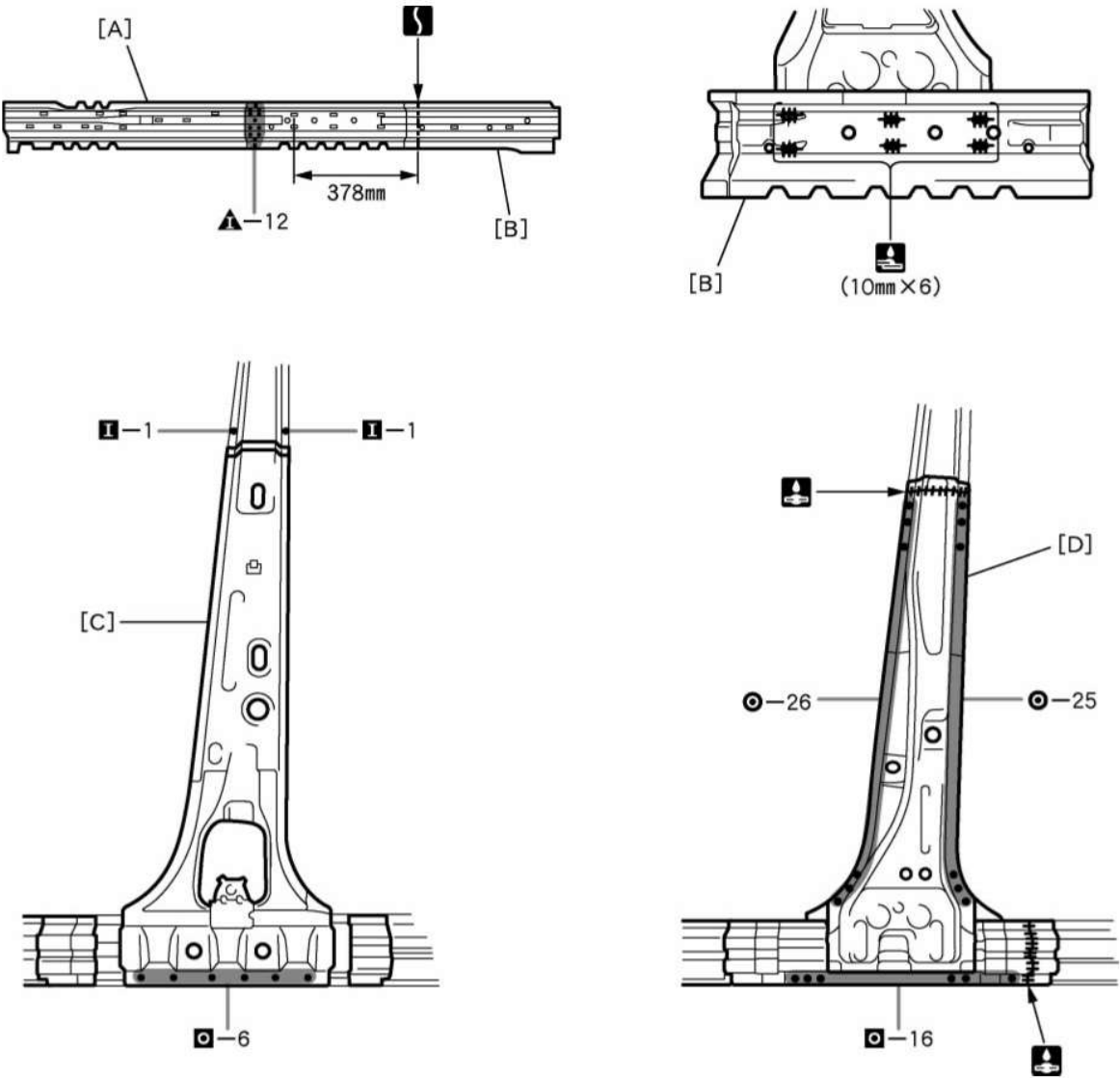
[A] Rocker Panel Reinforcement No.1 [B] Rocker Panel Reinforcement No.4

BP-28

BODY PANEL REPLACEMENT

INSTALLATION

- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



F15628

POINT

- 1 Remove the [B] from [A].
- 2 Before temporarily installing the new parts, weld the [B], [C] and [D] with standard points.
- 3 Cut the outer pillar section and rocker section and butt weld their reinforcements before installing the outer pillar.

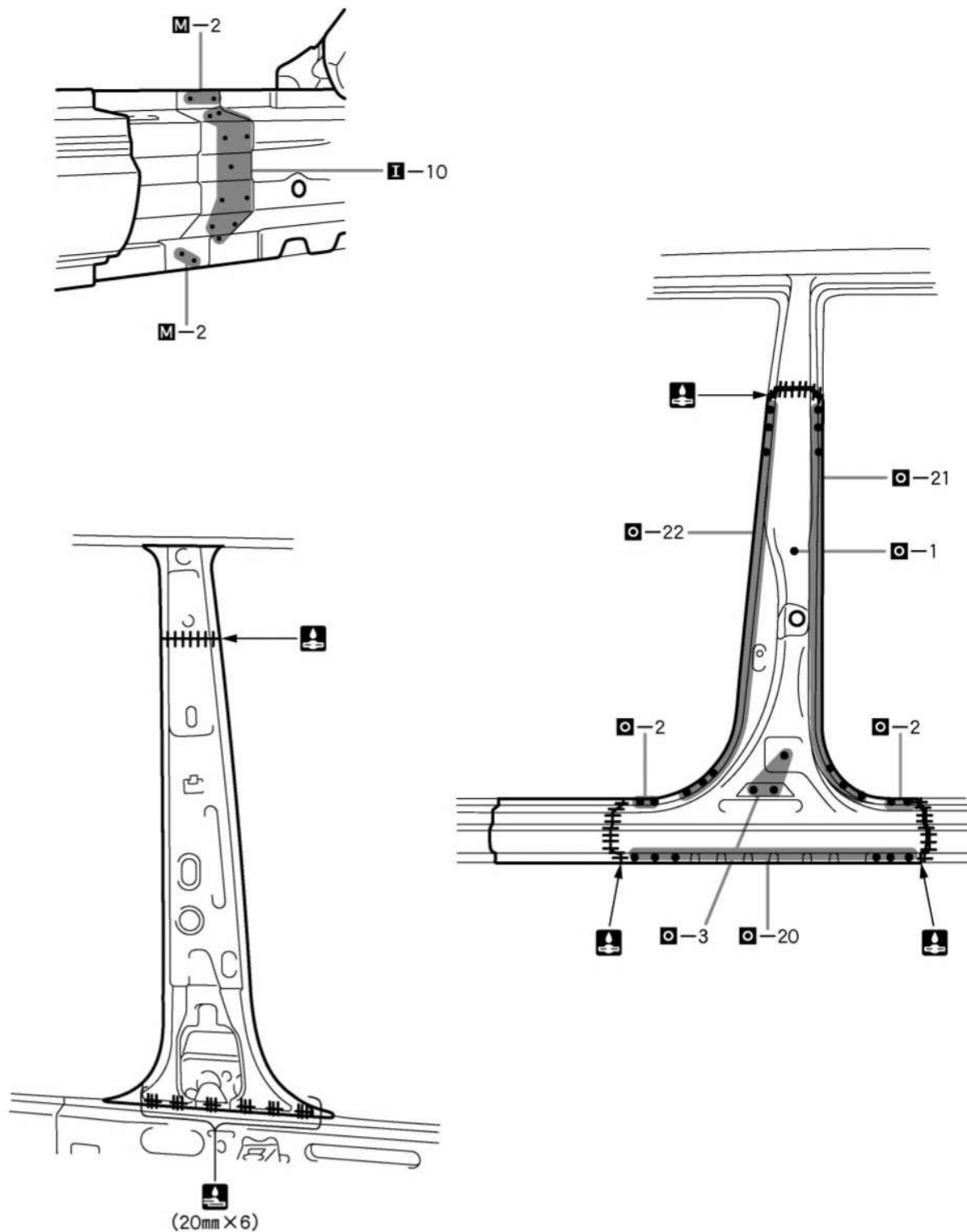
PART NAME

- [A] Rocker panel No.1 Reinforcement [B] Rocker Panel No.4 Reinforcement
[C] Center Body Inner Pillar [D] Center Body Pillar Upper Reinforcement

10mm (0.39in.) 378mm (14.89in.)

BODY PANEL REPLACEMENT

BP-29



F15629

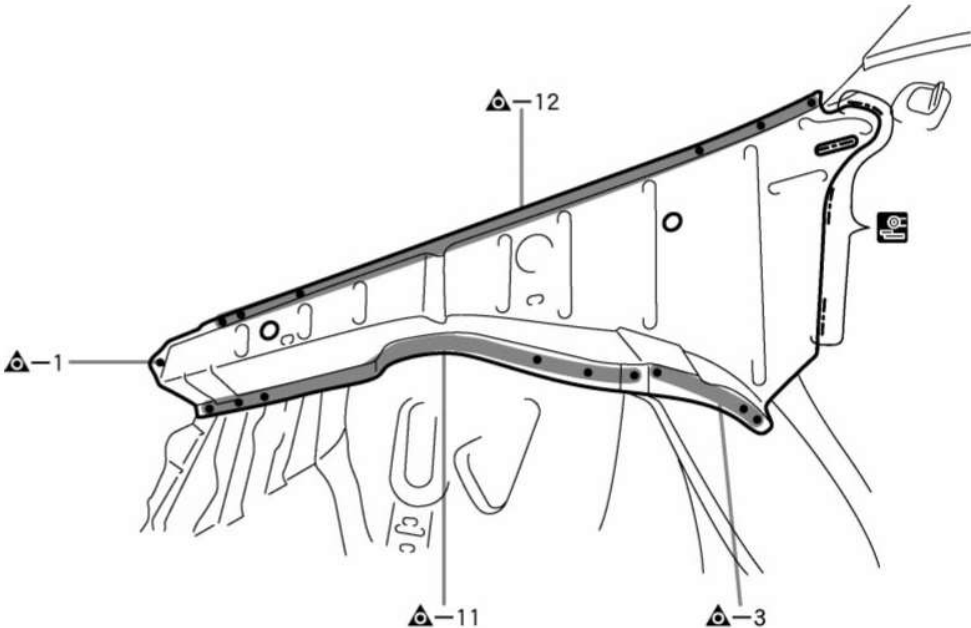
POINT

- 1 Inspect the fitting of the front door and rear door, etc., before welding, since this affects the appearance of the finish.
- 2 After welding the reinforcement to the vehicle side, install the outer panel.

20mm (0.79in.)

BP-20

BODY PANEL REPLACEMENT

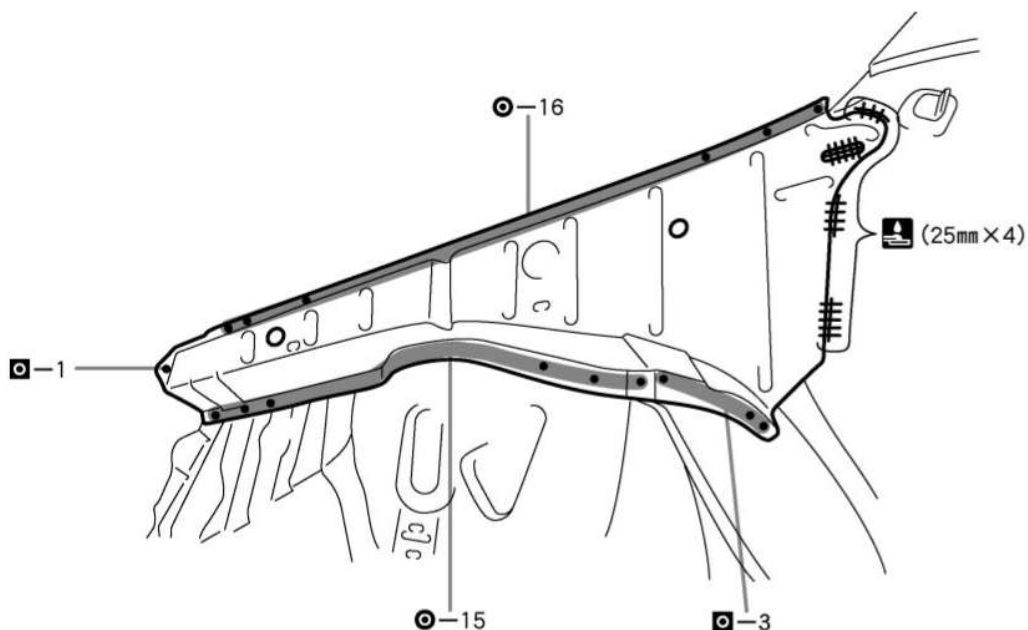
COWL TOP SIDE PANEL (ASSY)	 F15611A
REPLACEMENT	
REMOVAL	
 F15611	

BODY PANEL REPLACEMENT

BP-21

INSTALLATION

- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.

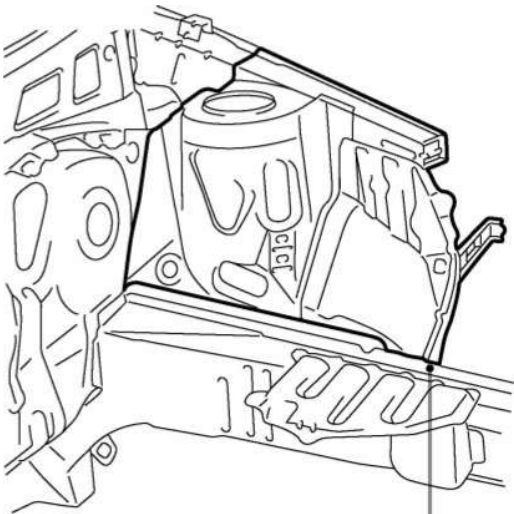
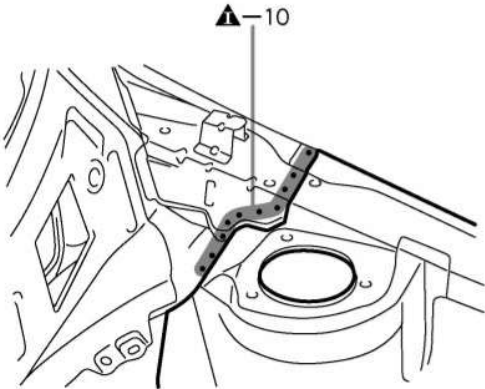
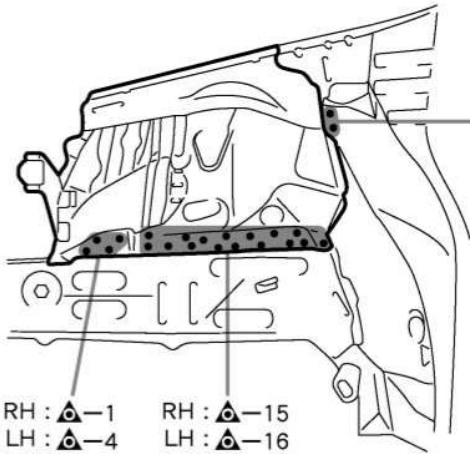
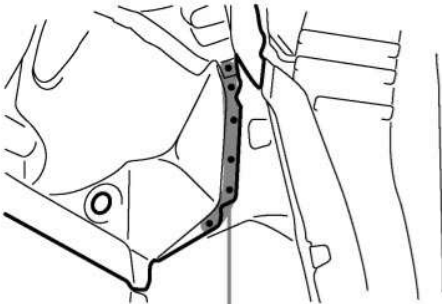


F15612

25mm (0.98in.)

BODY PANEL REPLACEMENT

BP-13

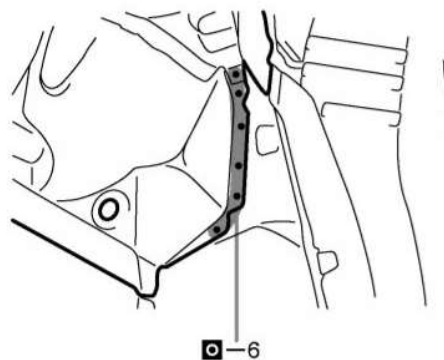
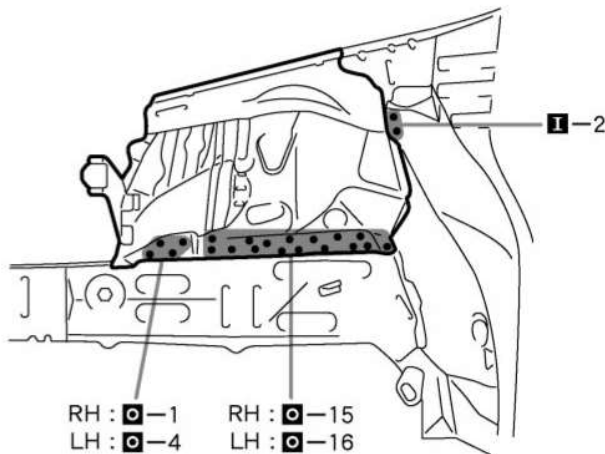
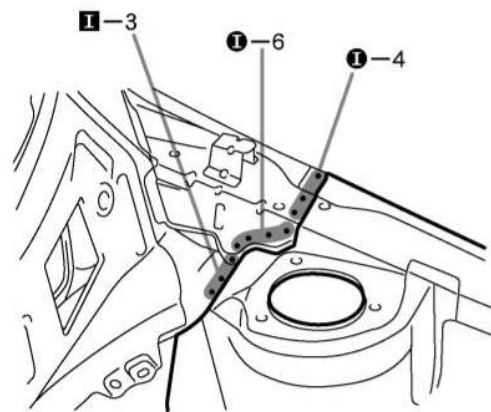
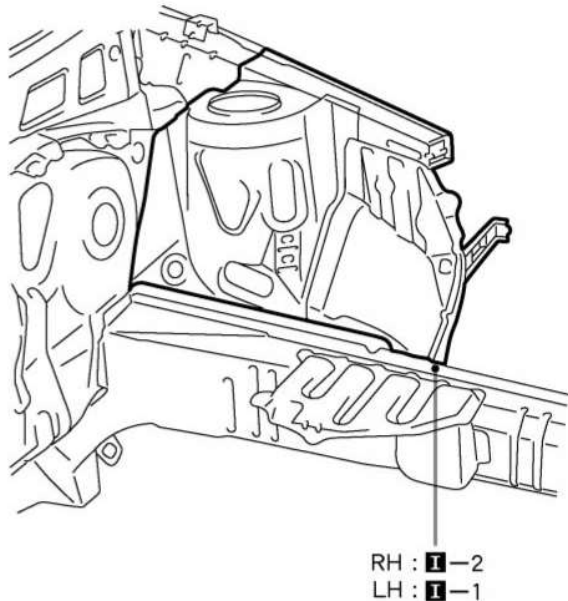
FRONT FENDER APRON (ASSY) REPLACEMENT With the radiator upper support and cowl top side panel removed.	 F15615A
REMOVAL  RH : ▲-2 LH : ▲-1  ▲-10  RH : ▲-1 RH : ▲-15 LH : ▲-4 LH : ▲-16  ▲-6 F15615	

BP-14

BODY PANEL REPLACEMENT

INSTALLATION

- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



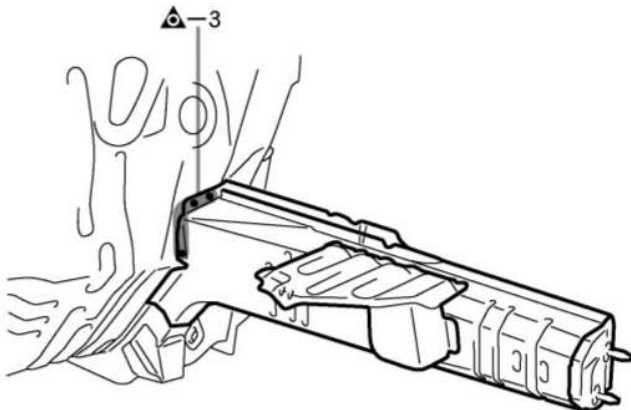
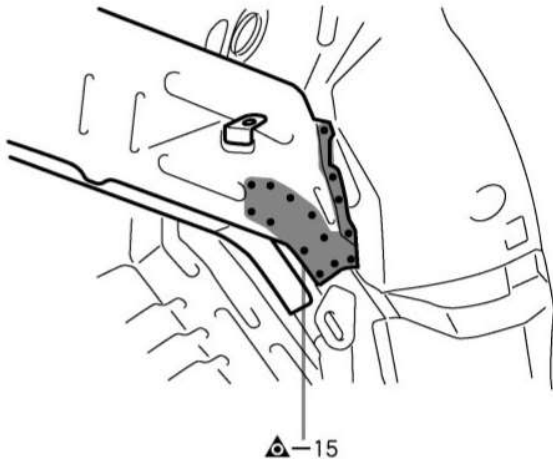
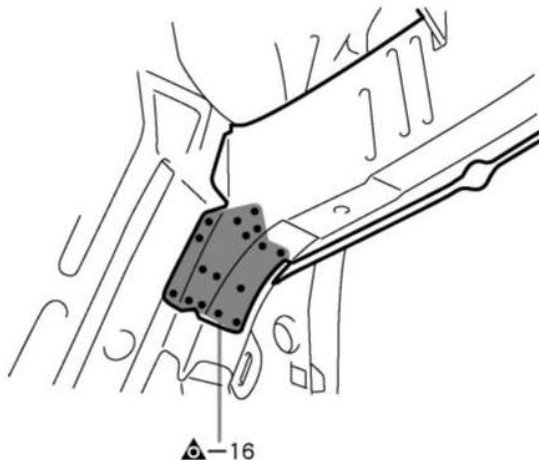
F15616

POINT

- 1 Inspect the fitting of the front fender and hood, etc. before welding, since this affects the appearance of the finish.
- 2 Make sure each measurement is correct, as this parts affects the front wheel alignment.

BODY PANEL REPLACEMENT

BP-17

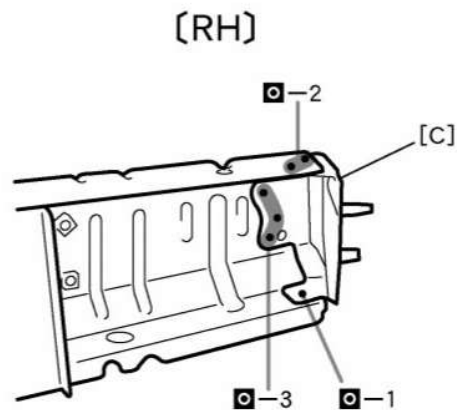
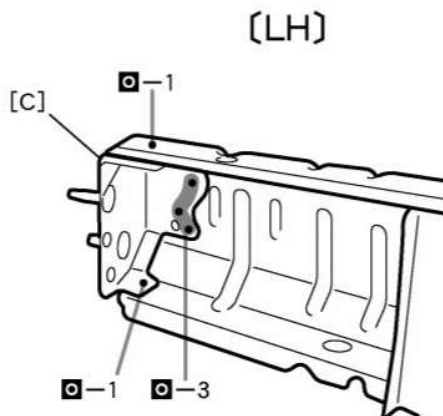
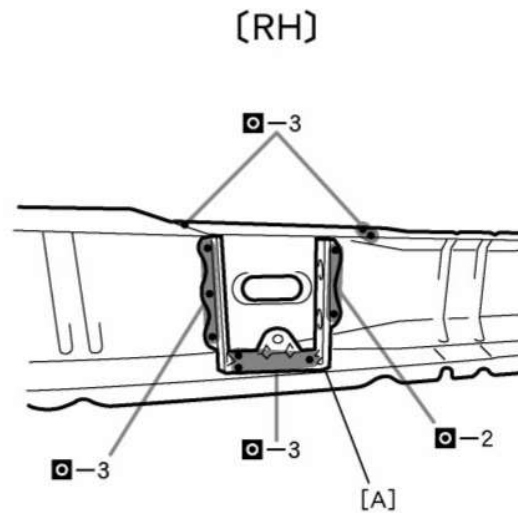
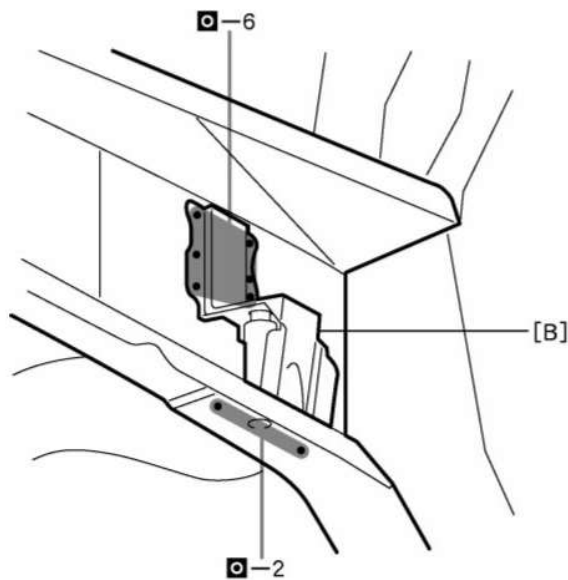
FRONT SIDE MEMBER (ASSY)		 F15619A
REPLACEMENT With the radiator side support and front fender apron removed.		
REMOVAL		
  		

BP-18

BODY PANEL REPLACEMENT

INSTALLATION

- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



F15620

POINT

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

PART NAME

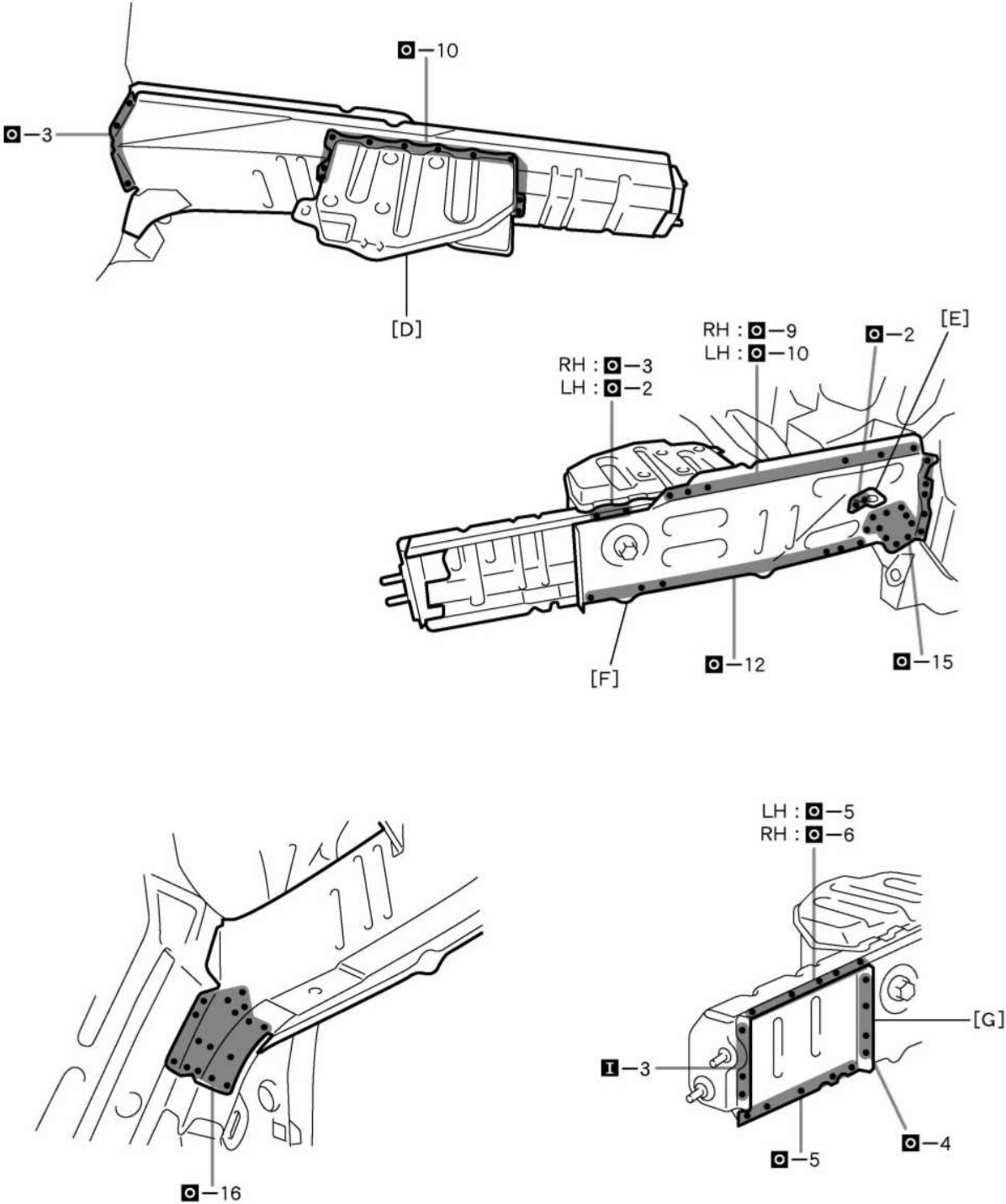
[A] Front Side Member No.3 Reinforcement (RH only)

[B] Front Suspension Member Mounting Front Bracket

[C] Front Bumper Arm

BODY PANEL REPLACEMENT

BP-19



PART NAME

- [D] Buttery Support [E] Flexible Hose No.1 Bracket [F] Front Side Member Outer Plate
[G] Front Bumper Mounting Reinforcement (RH: Front Side Member Front Plate)

F15621

BODY PANEL REPLACEMENT

BP-11

FRONT APRON TO COWL SIDE UPPER MEMBER (ASSY)

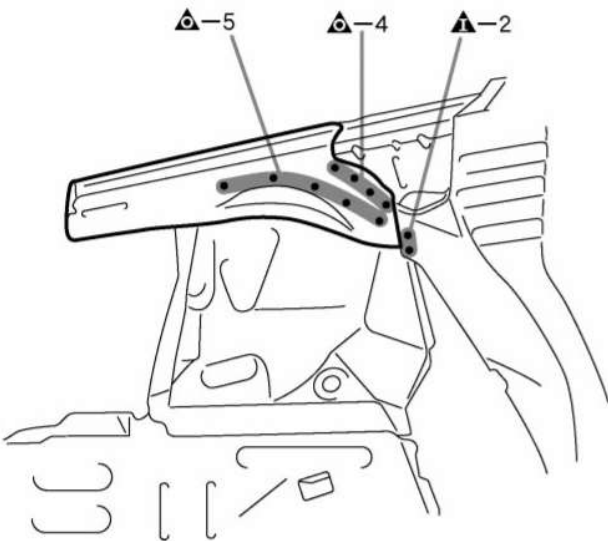
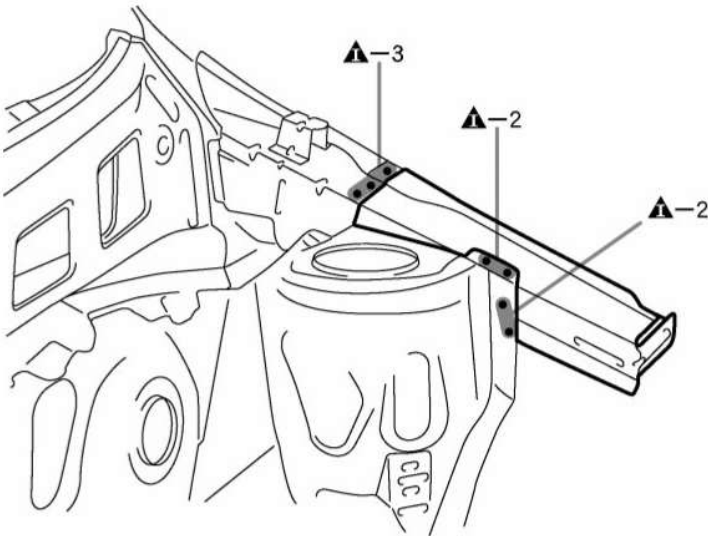
REPLACEMENT

With the front fender front apron and cowl top side panel removed.



F15613A

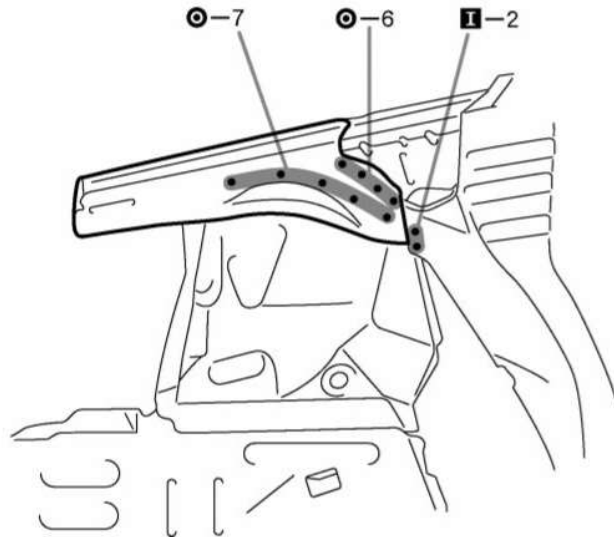
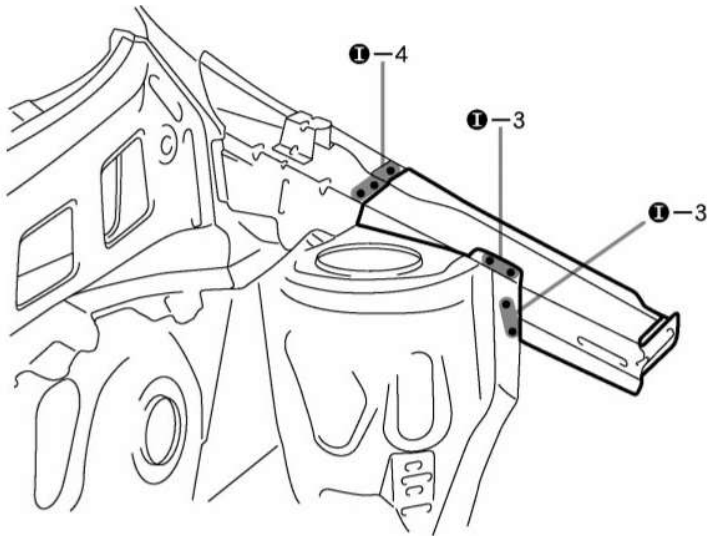
REMOVAL



F15613

BP-12**BODY PANEL REPLACEMENT****INSTALLATION**

- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



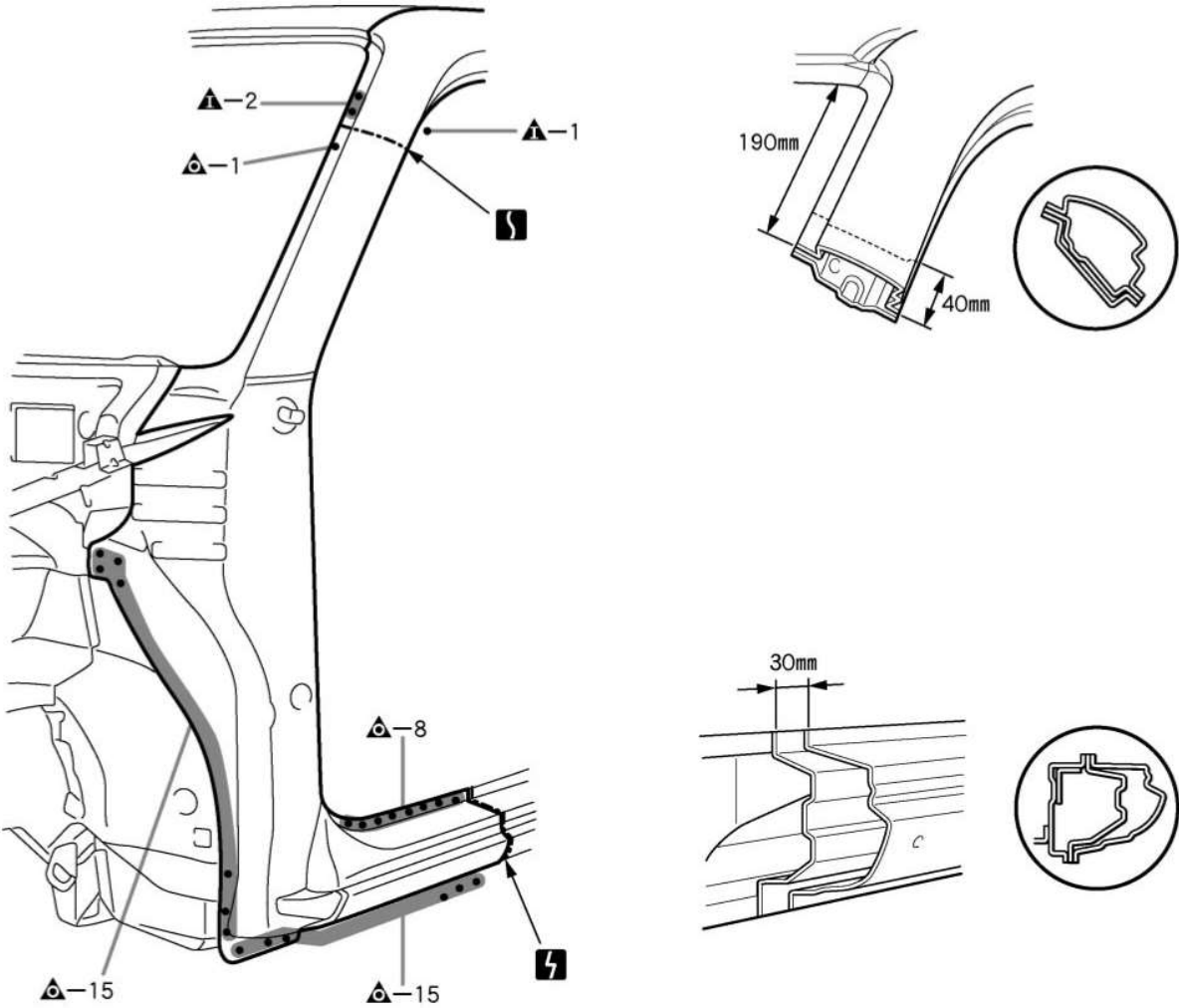
F15614

POINT

- 1 Inspect the fitting of the front fender and hood, etc. before welding, since this affects the appearance of the finish.

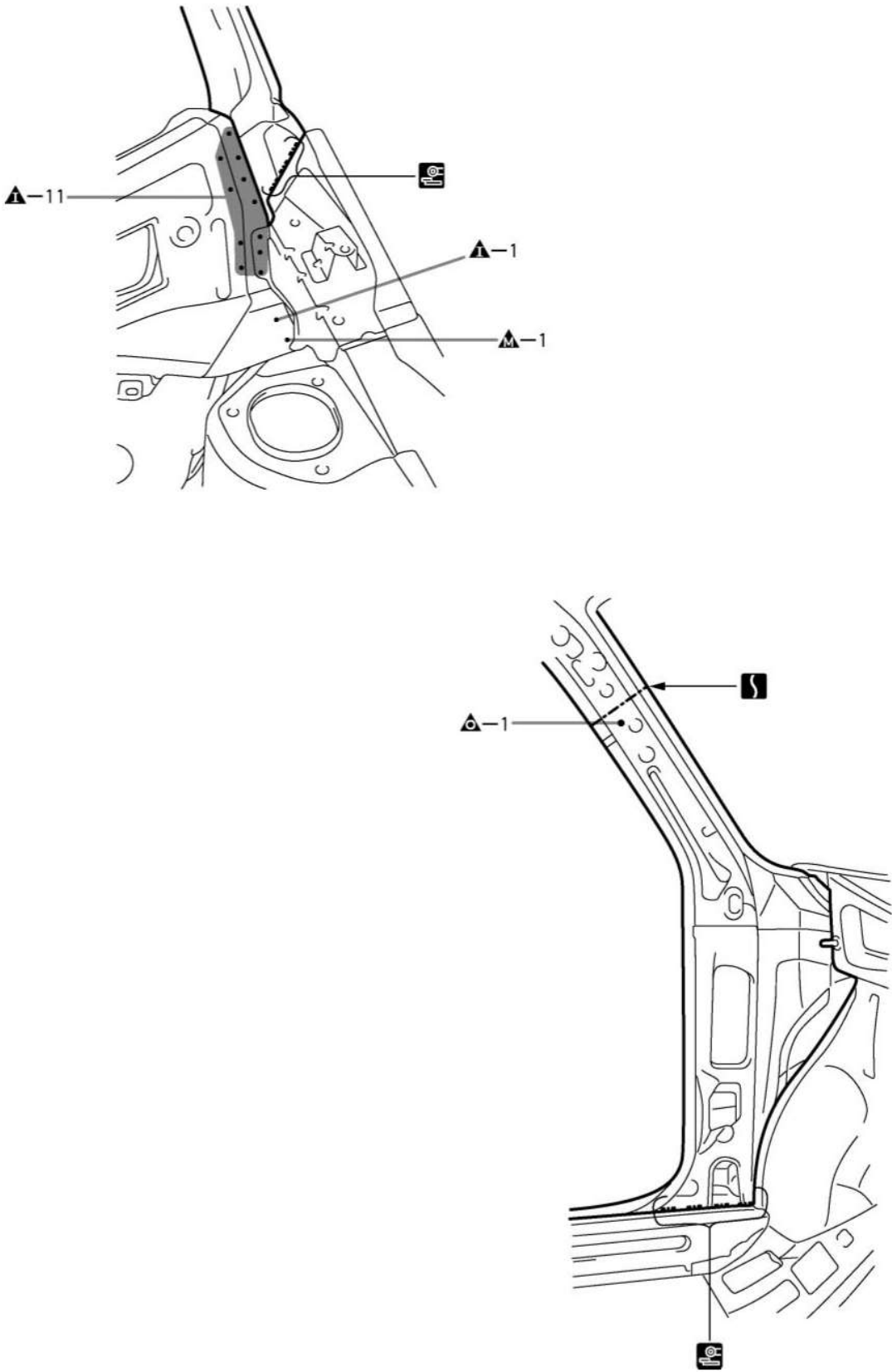
BP-22

BODY PANEL REPLACEMENT

FRONT BODY PILLAR (CUT) REPLACEMENT With the cowl top side panel removed.	 F15622A
REMOVAL  F15622	
30mm (1.18in.) 40mm (1.57in.) 190mm (7.48in.)	

BODY PANEL REPLACEMENT

BP-23



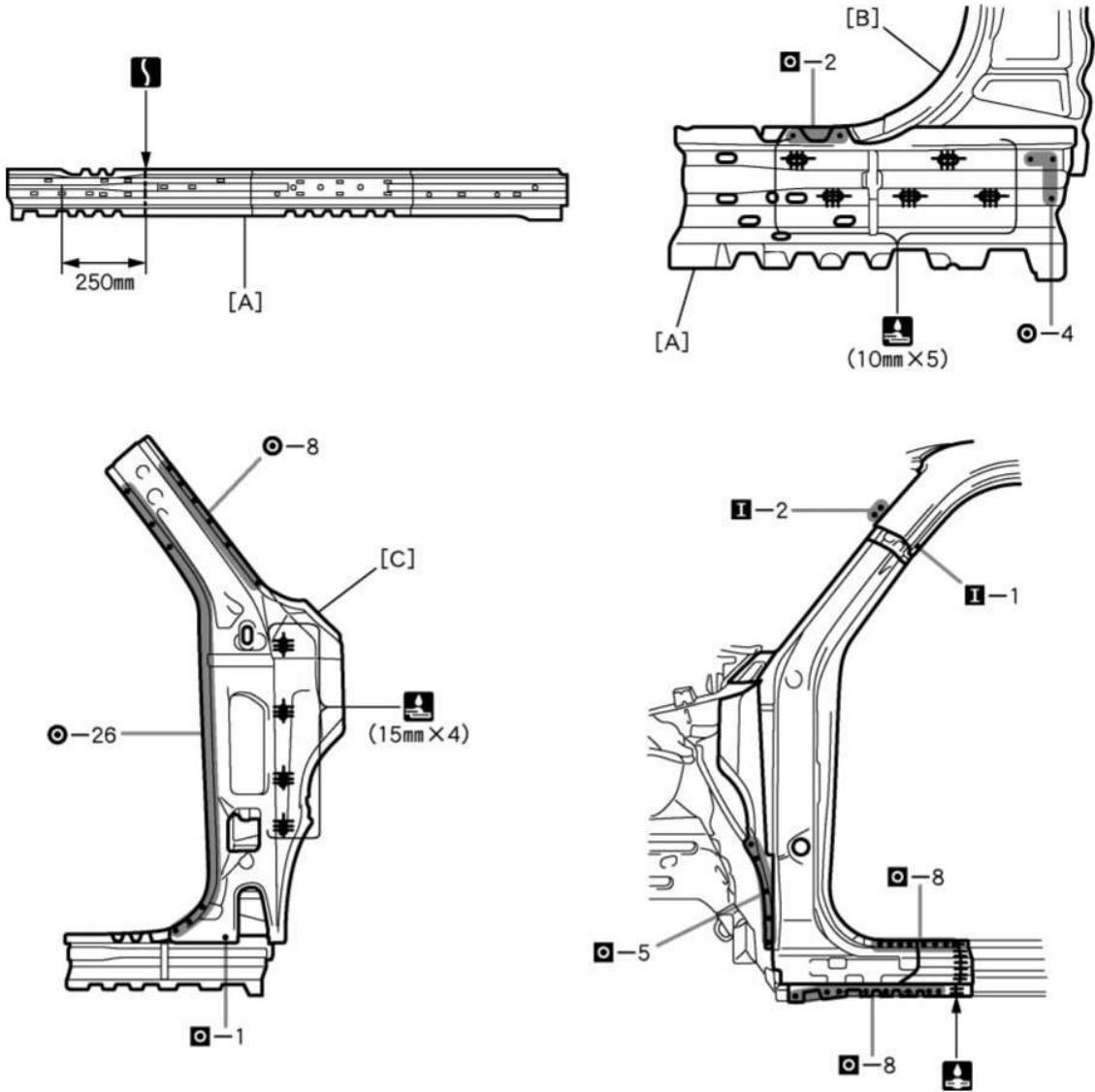
cardiagn.com

F15623

BP-24 BODY PANEL REPLACEMENT

INSTALLATION

- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



F15624

POINT

- 1 Before temporarily installing the new parts, weld the [A], [B] and [C] with standard points.
- 2 Cut the outer pillar section and rocker section and butt weld their reinforcements before installing the outer panel.

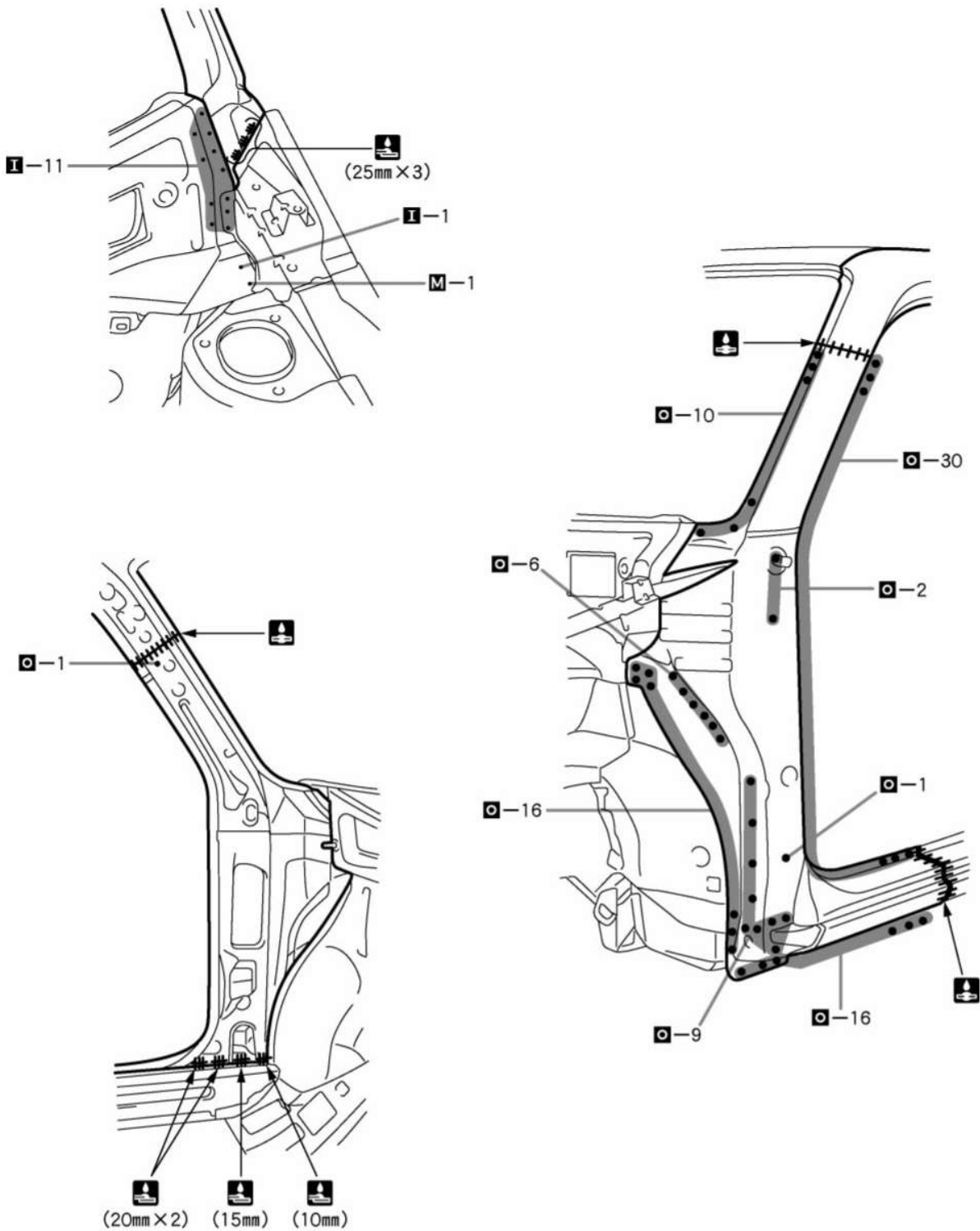
PART NAME

- [A] Rocker Outer Reinforcement [B] Front Body Pillar Lower Reinforcement
[C] Front Body Inner Pillar

10mm (0.39in.) 15mm (0.59in.)

BODY PANEL REPLACEMENT

BP-25



F15625

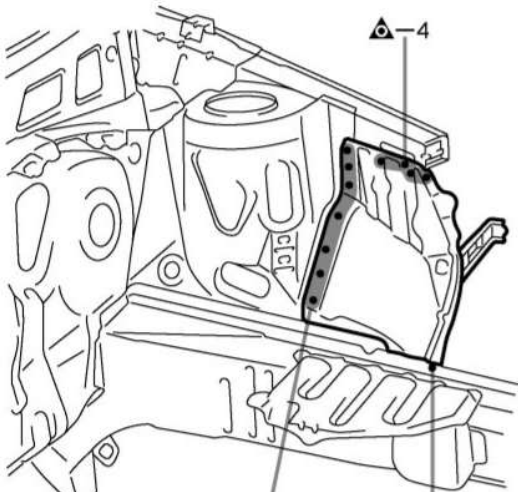
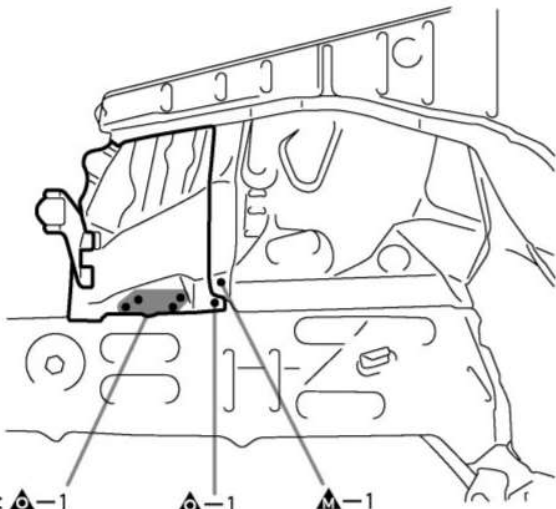
POINT

- 1 Inspect the fitting of the front door, front fender and windshield glass, etc., before welding, since this affects the appearance of the finish.

10mm (0.39in.) 15mm (0.59in.) 20mm (0.79in.) 25mm (0.98in.)

BODY PANEL REPLACEMENT

BP-9

FRONT FENDER FRONT APRON (ASSY)		 F15609A
REPLACEMENT With the radiator upper support removed.		
REMOVAL		
 RH : 2 LH : 1  RH : 1 LH : 4		

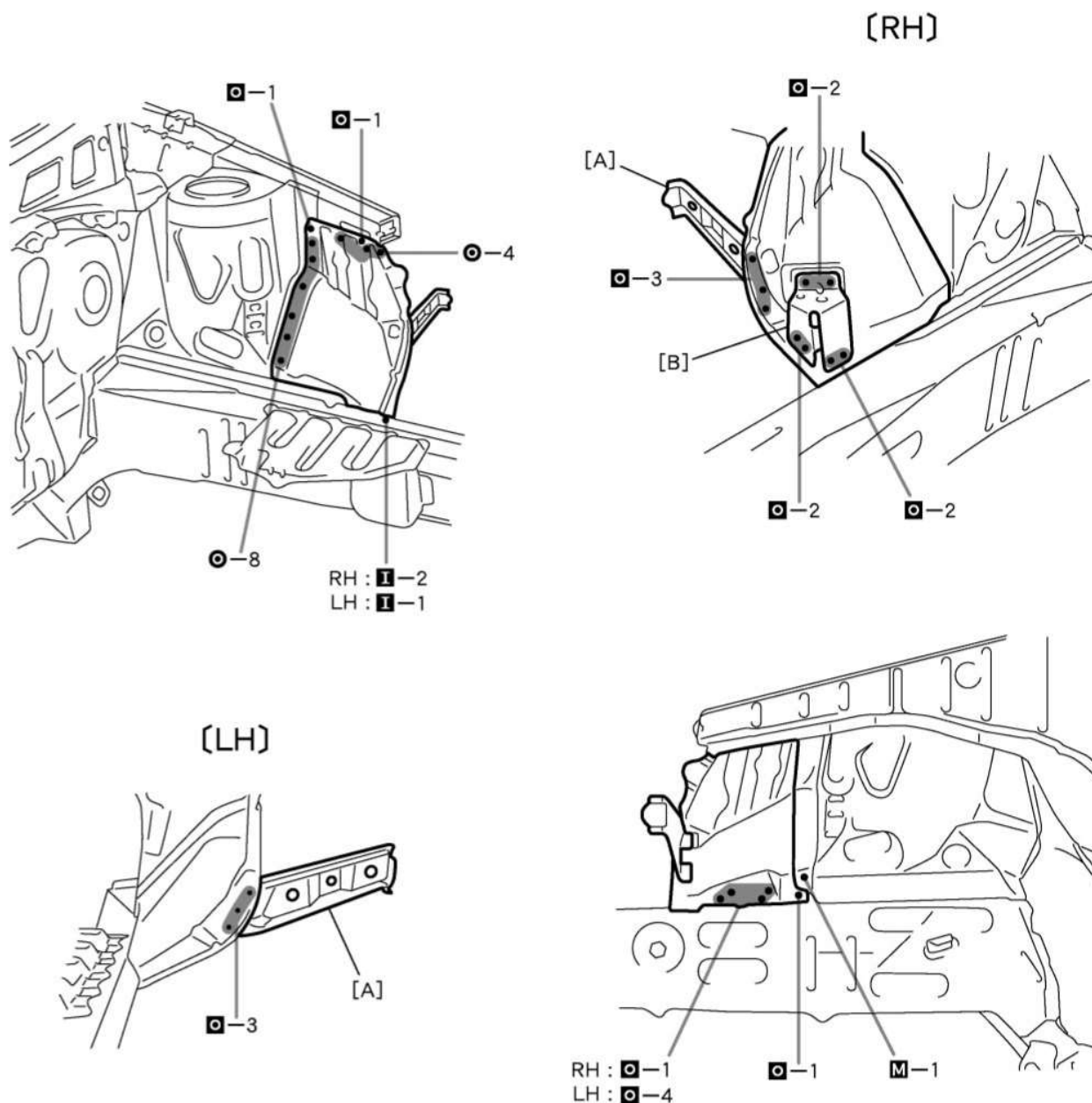
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BP-10

BODY PANEL REPLACEMENT

INSTALLATION

- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



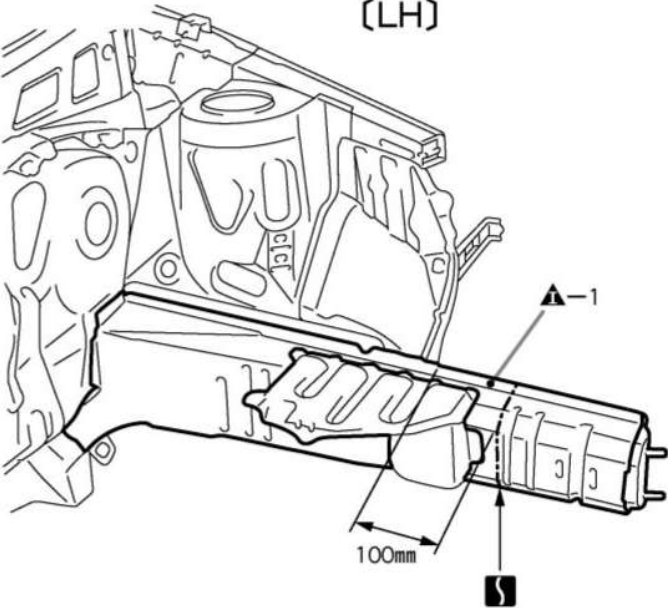
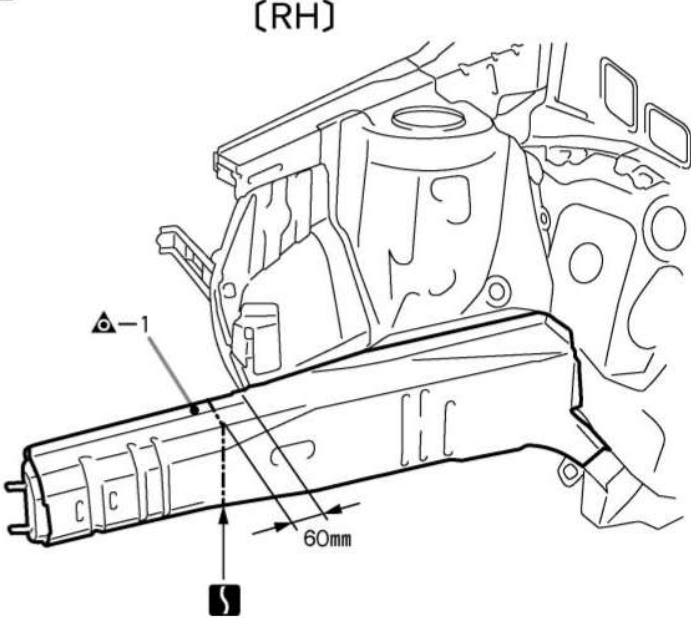
F15610

POINT

- 1 Inspect the fitting of the front fender and hood, etc. before welding, since this affects the appearance of the finish.

PART NAME

- [A] Front Fender Mounting Bracket [B] Engine Front Support Retainer (RH Only)

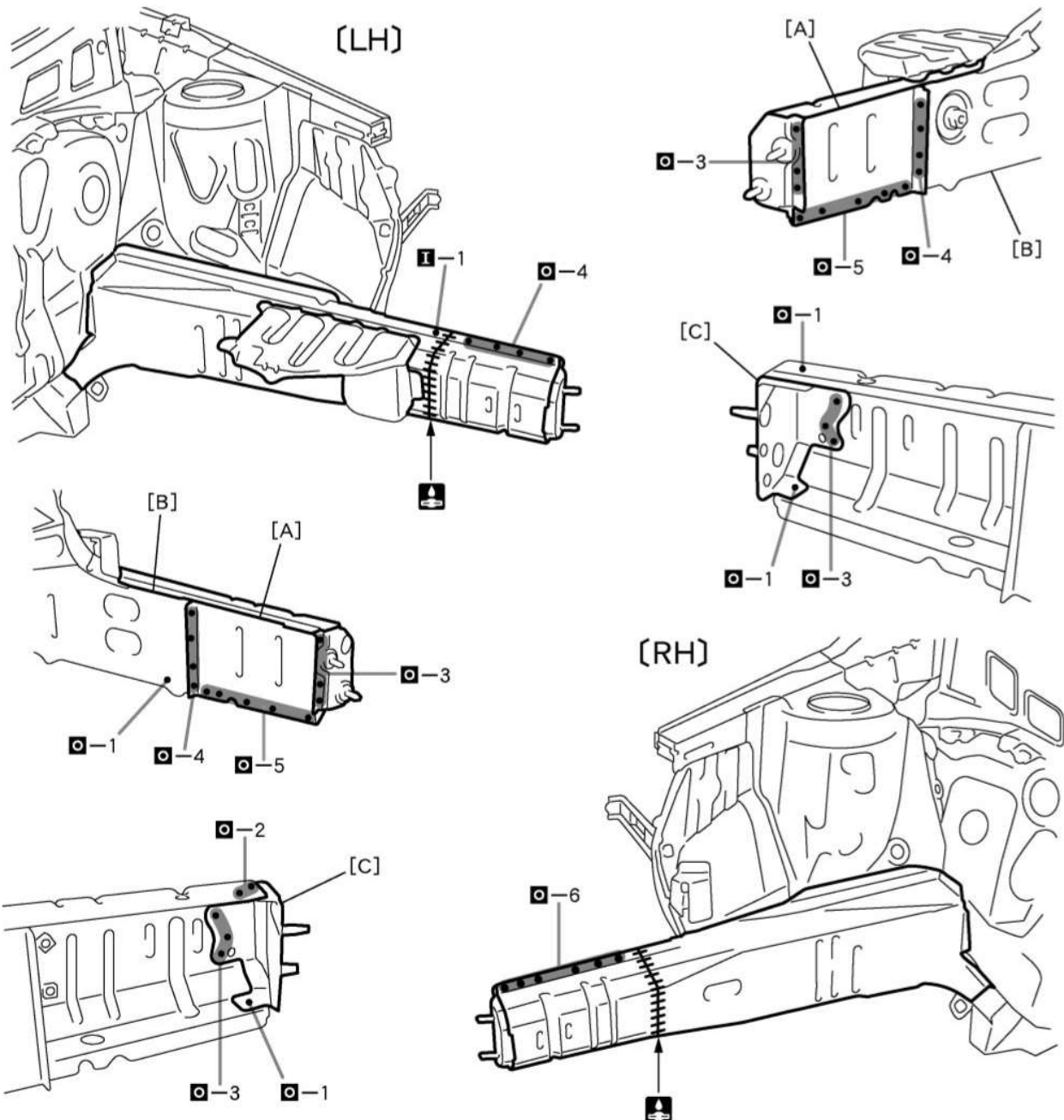
FRONT SIDE MEMBER (CUT-P)	
REPLACEMENT With the radiator side support removed.	 F15617A
REMOVAL	
(LH)  [A] 100mm 1 4 (RH)  60mm 1 4 [B] 1 4 F15617	
POINT 1 Remove the [A] or [B] at the same time. PART NAME [A] Front Bumper Mounting Reinforcement 60mm (2.36in.) [B] Front Side Member Front Plate 100mm (3.94in.)	

BP-16

BODY PANEL REPLACEMENT

INSTALLATION

- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



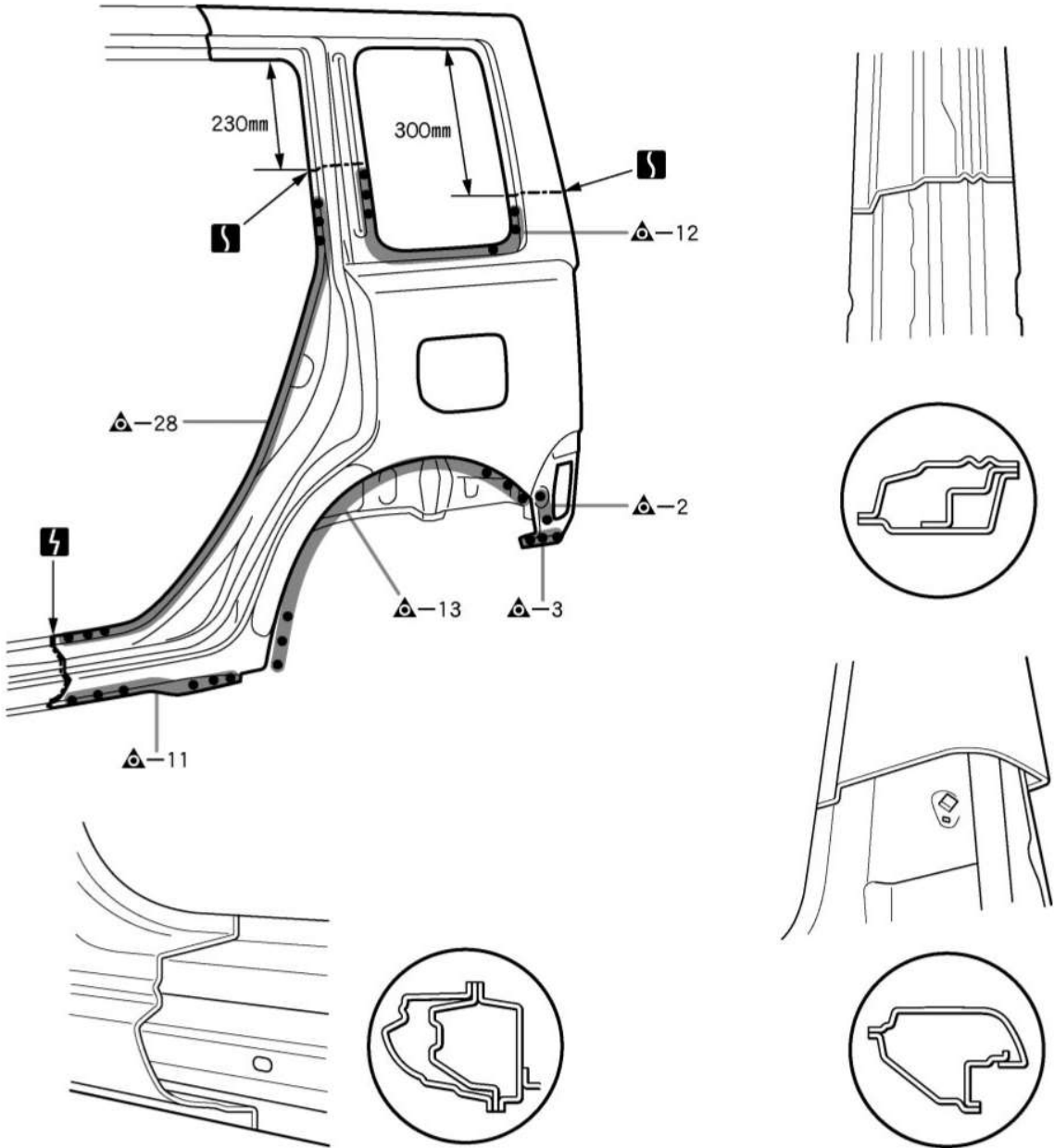
F15618

PART NAME

- [A] Front Bumper Mounting Reinforcement (RH: Front Side Member Front Plate)
 [B] Front Side Member Outer Plate [C] Front Bumper Arm

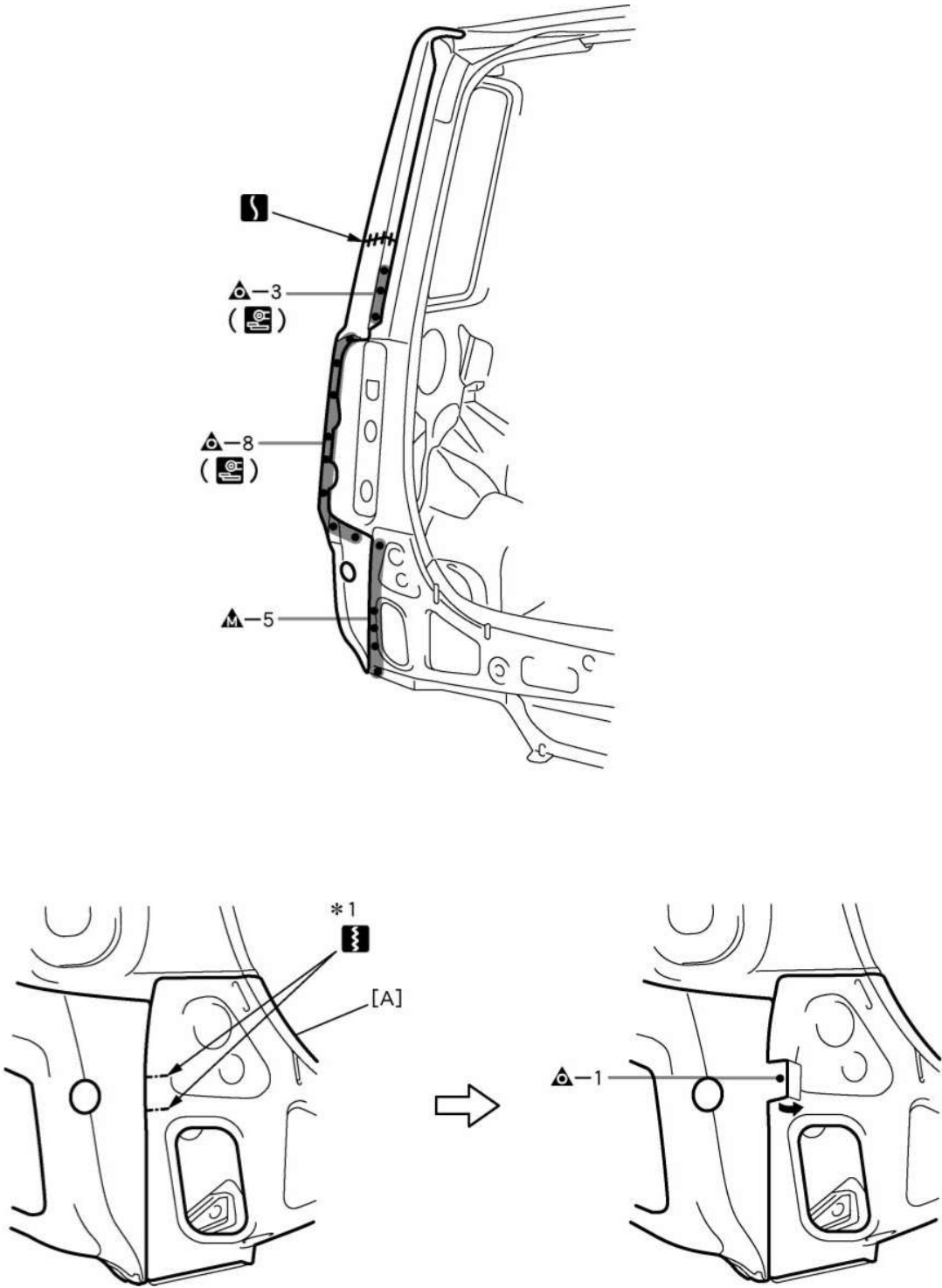
BP-36

BODY PANEL REPLACEMENT

QUARTER PANEL (CUT)	 F15633A
REPLACEMENT	
REMOVAL  F15633 230mm (9.06in.) 300mm (11.8in.)	

BODY PANEL REPLACEMENT

BP-37



POINT
1 *1: Make an incision in the [A] and bend it this side.
PART NAME
[A] Body Lower Back Panel

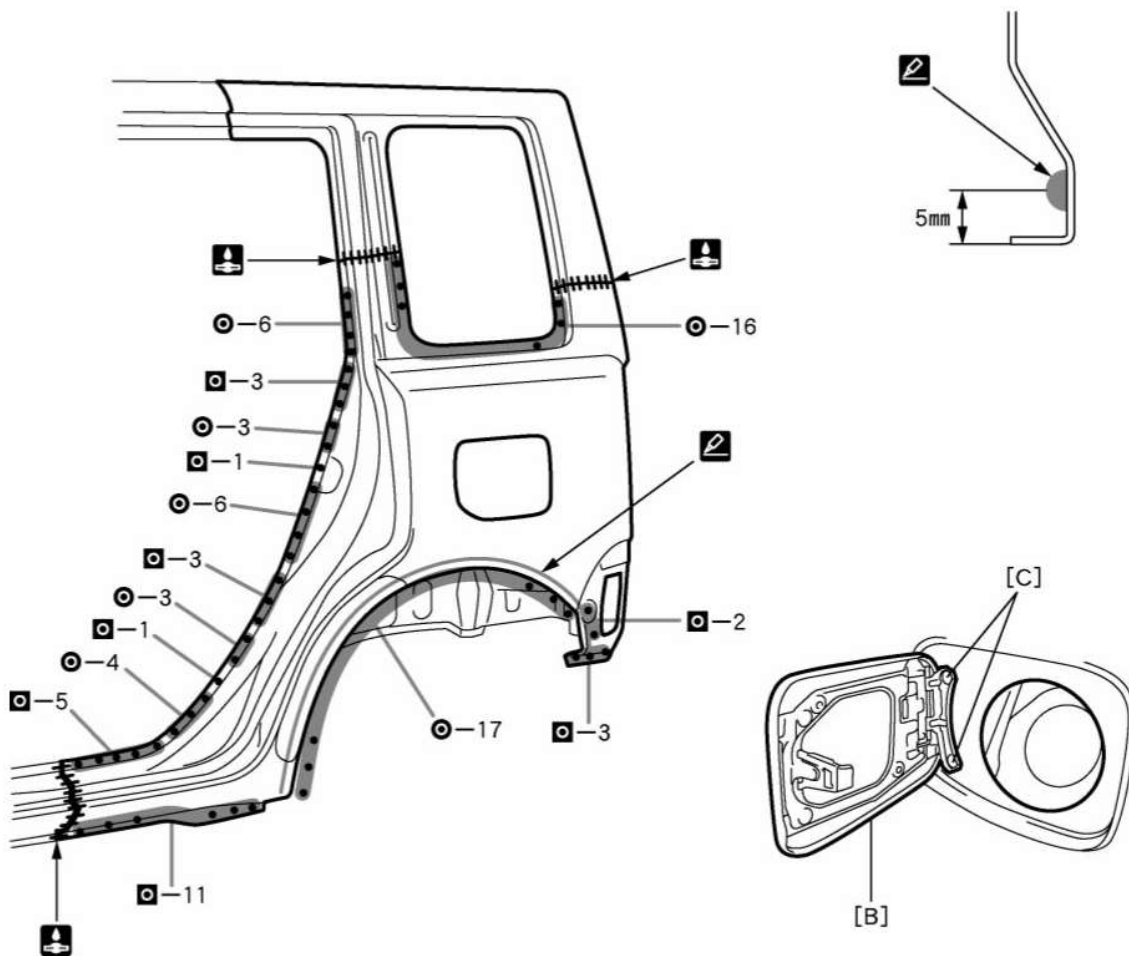
F15634

BP-38

BODY PANEL REPLACEMENT

INSTALLATION

- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



F15635

POINT

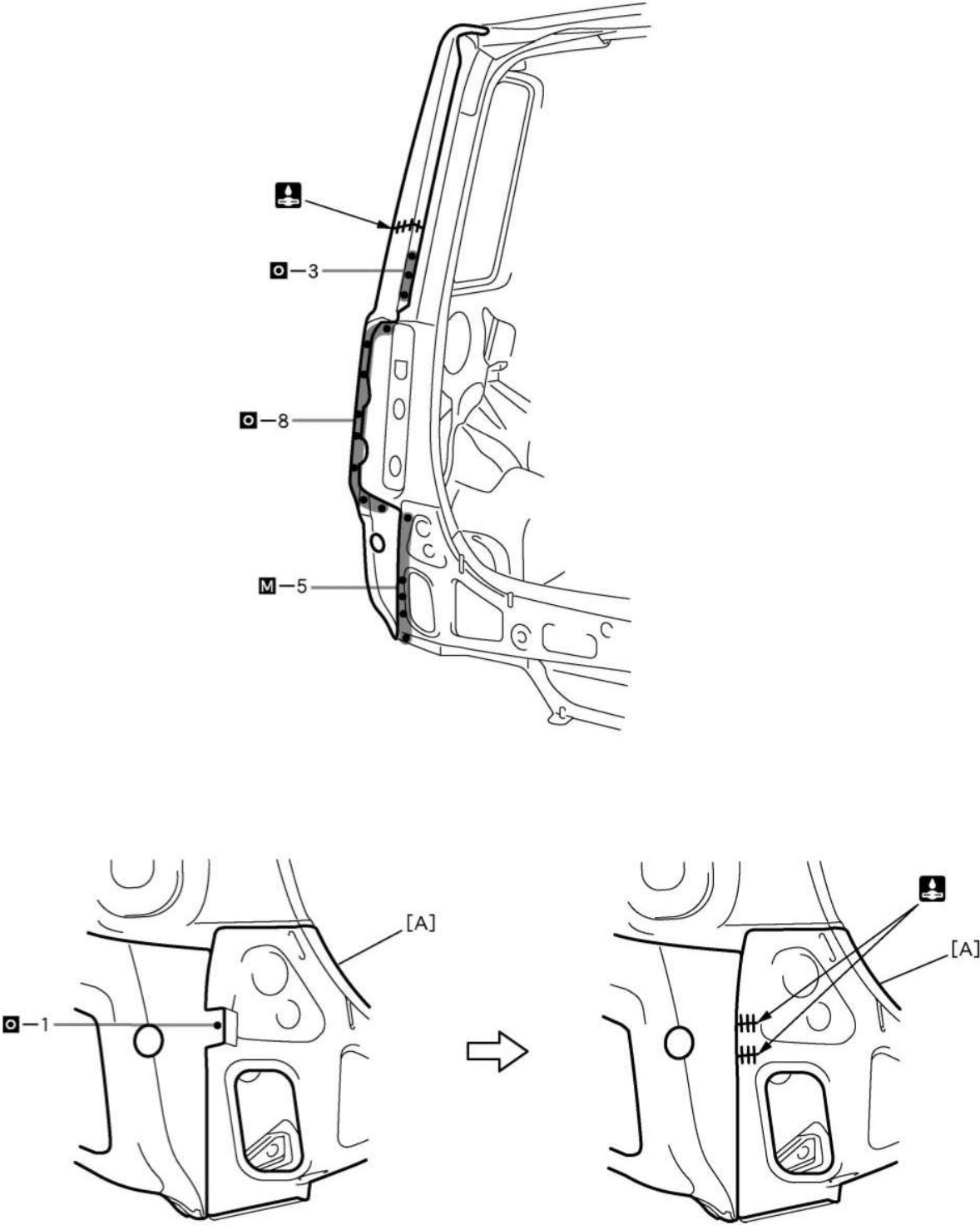
- Before temporarily installing the new parts, apply sealer to wheel arch.
HINT:
1) Apply body sealer about 5mm (0.20in.) from the flange, avoiding any oozing.
2) Apply sealer evenly, about 3 - 4mm (0.12 - 0.16in.) in diameter.
- Inspect the fitting of the rear door, back door and rear combination light, etc., before welding, since this affects the appearance of the finish.

PART NAME

[B] Fuel Filler Opening Lid [C] Waterproof Rivets

BODY PANEL REPLACEMENT

BP-39

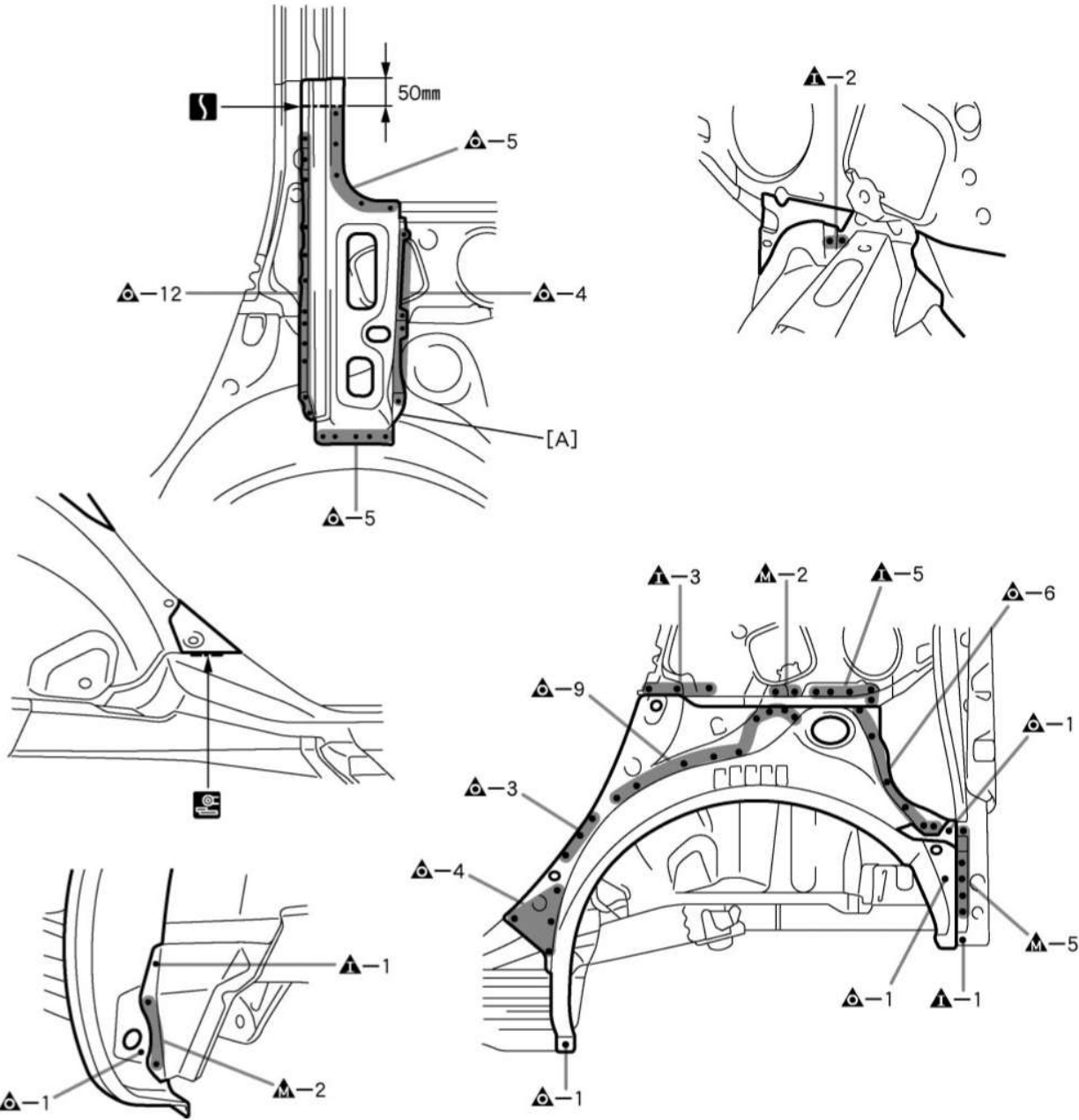


PART NAME
[A] Body Lower Back Panel

F15636

BP-40

BODY PANEL REPLACEMENT

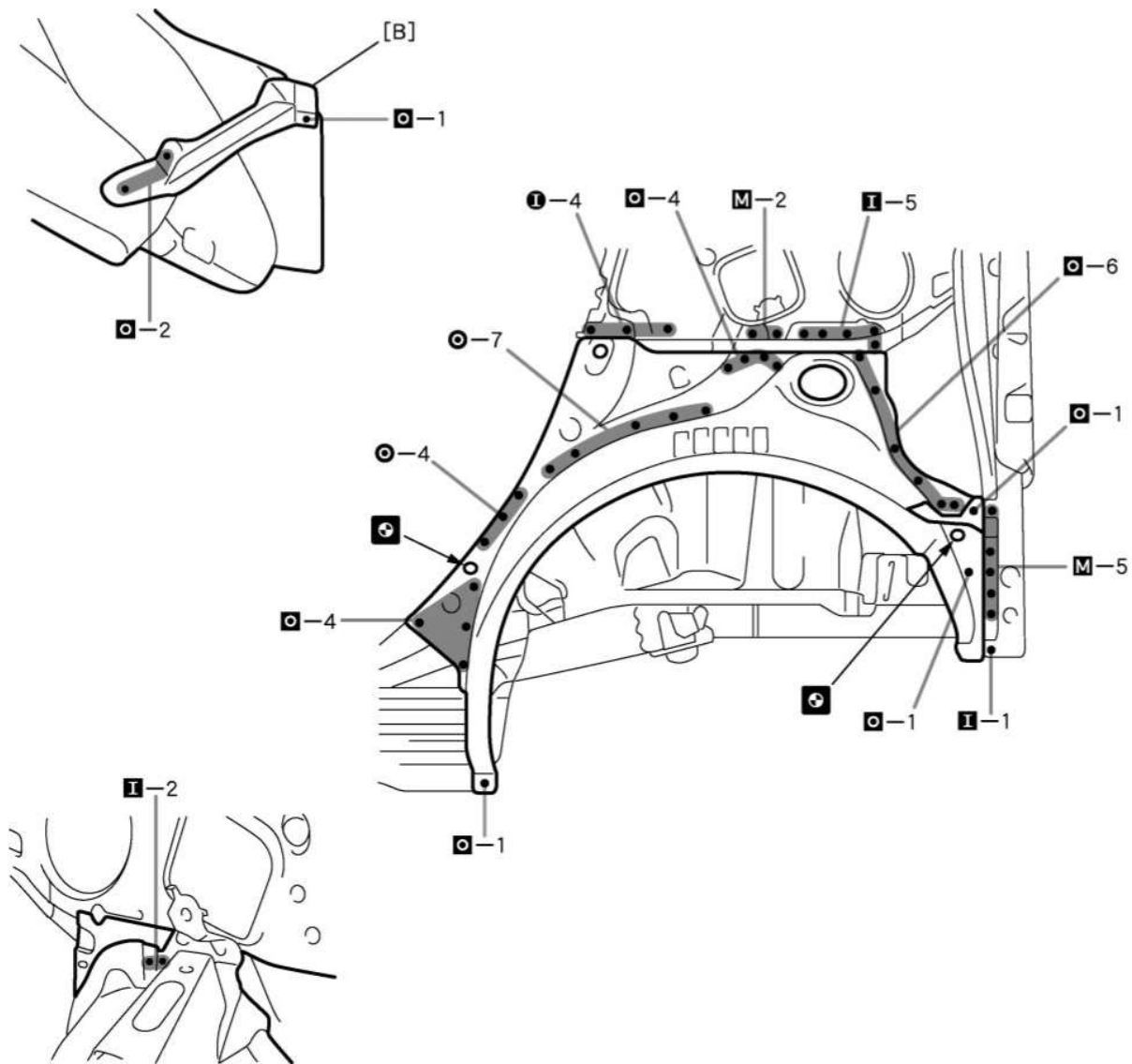
QUARTER WHEEL HOUSING OUTER PANEL (ASSY)	 F15637A
REPLACEMENT With the quarter panel removed.	
REMOVAL 	
POINT 1 After removing [A], remove the quarter wheel housing outer panel. PART NAME [A] Roof Side Outer Panel 50mm (1.97in.)	

BODY PANEL REPLACEMENT

BP-41

INSTALLATION

- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



F15638

POINT

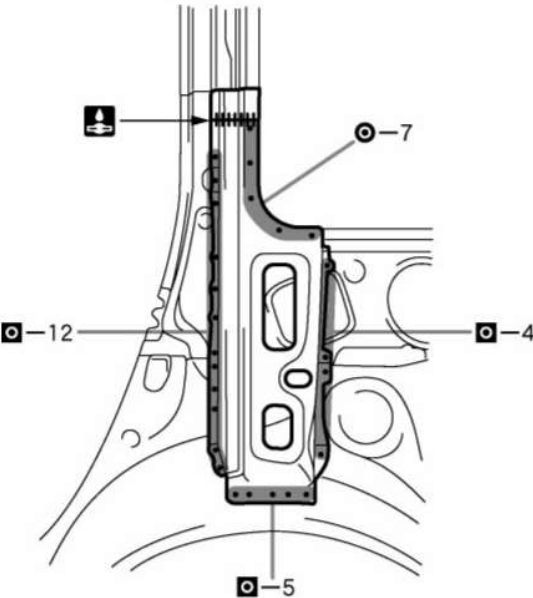
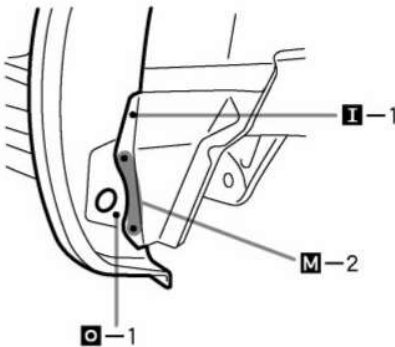
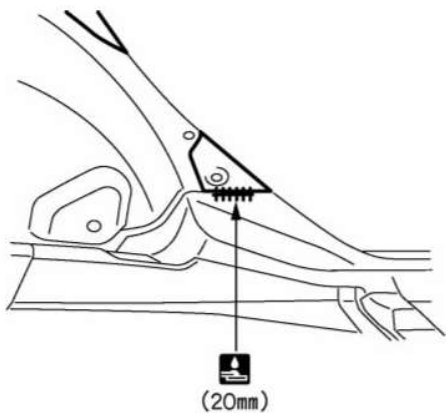
- 1 Determine the position of the new parts by assembly marks of the inner and outer panels.

PART NAME

[B] Quarter Wheel Housing Center Gusset

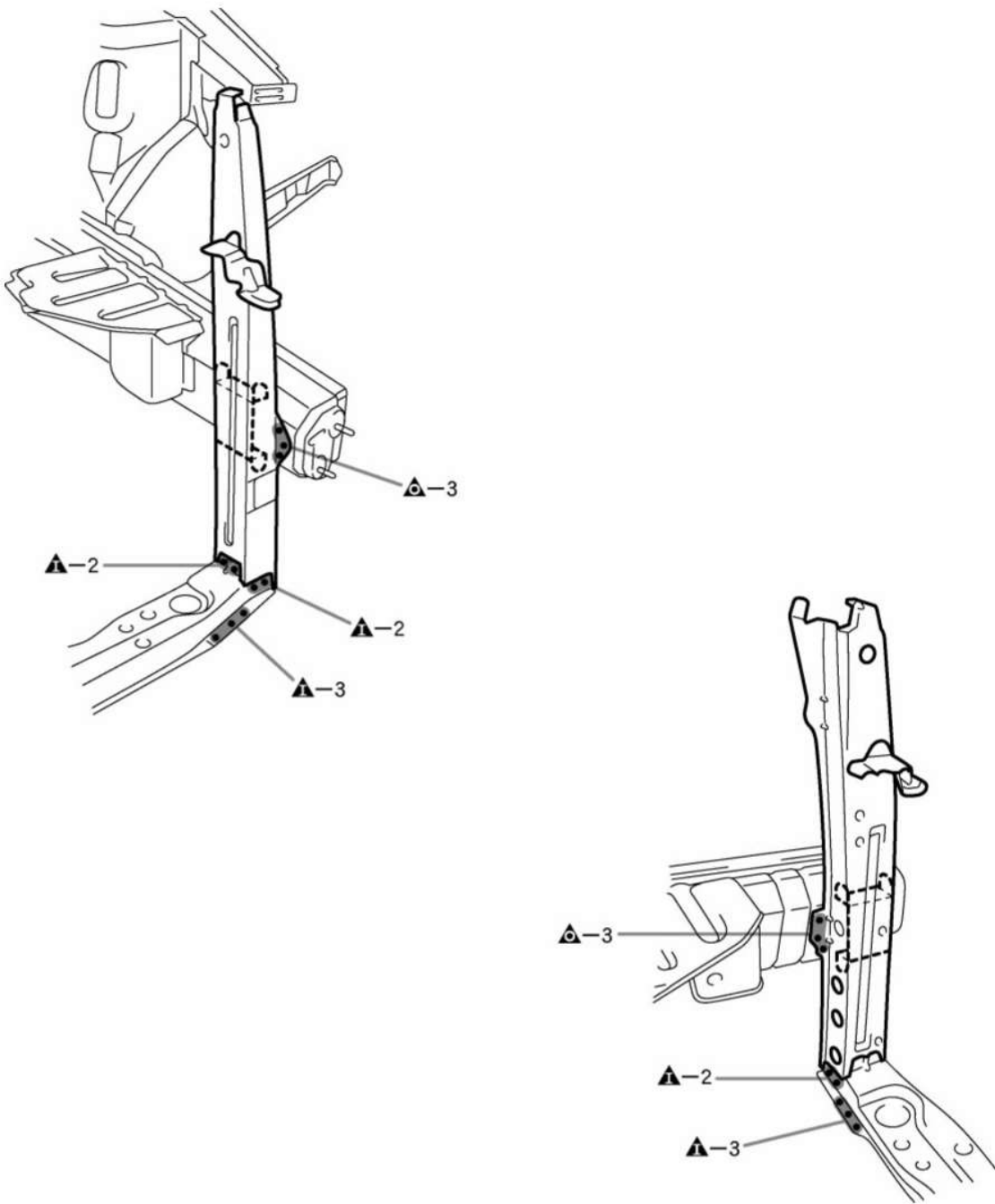
BP-42

BODY PANEL REPLACEMENT



F15639

20mm (0.79in.)

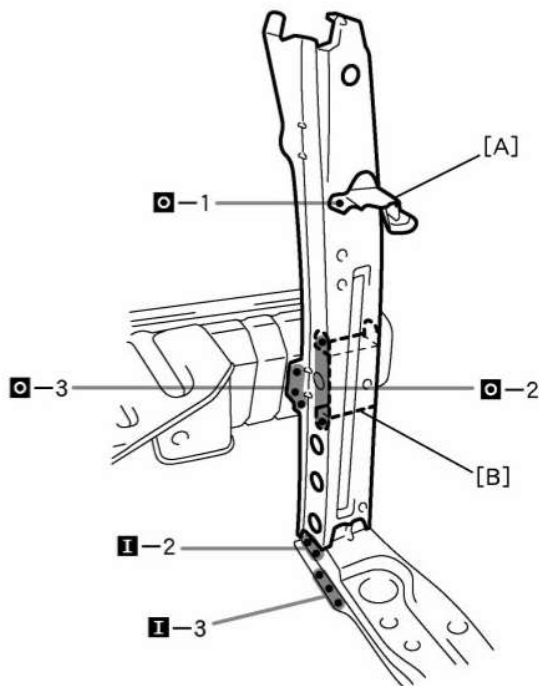
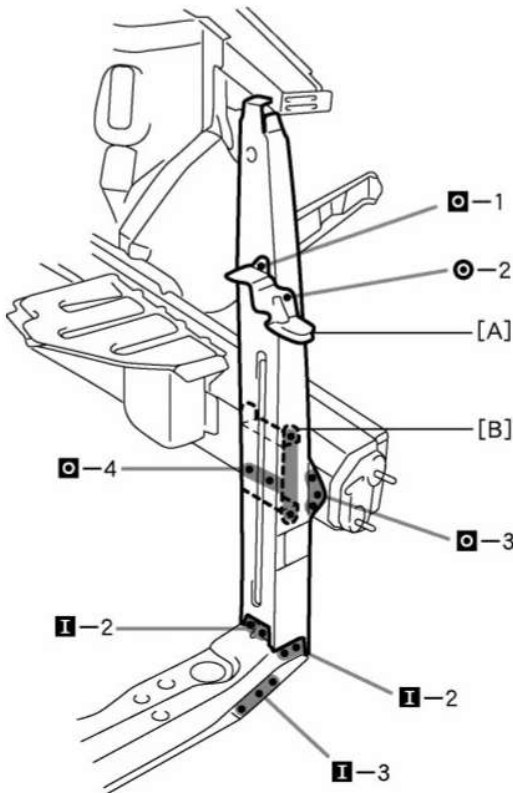
RADIATOR SIDE SUPPORT (ASSY)		 F15603A
REPLACEMENT With the radiator upper support removed.		
REMOVAL		
		

BP-4

BODY PANEL REPLACEMENT

INSTALLATION

- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



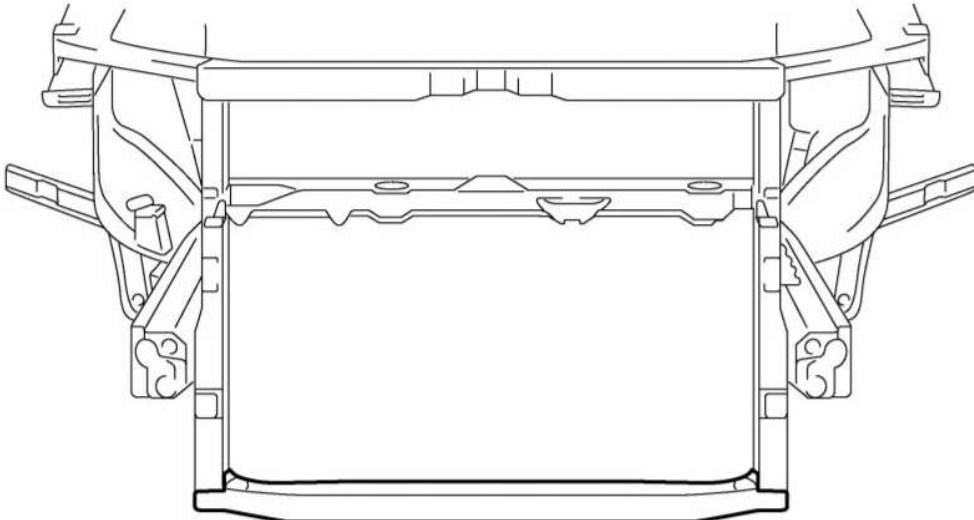
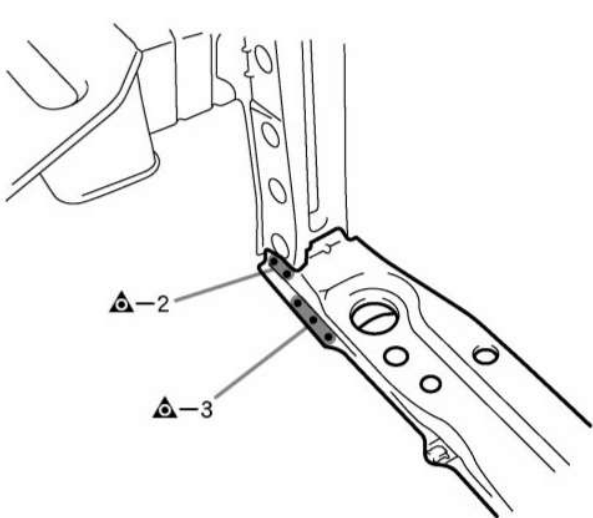
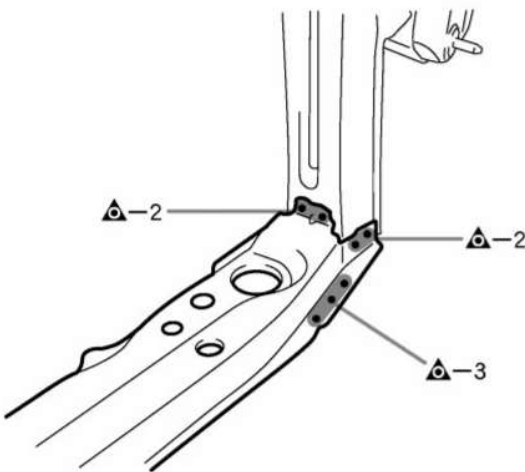
F15604

PART NAME

[A] Front Bumper Side Mounting Bracket [B] Radiator Support Reinforcement

BODY PANEL REPLACEMENT

BP-5

RADIATOR LOWER SUPPORT (ASSY)		 F15605A
REPLACEMENT		
REMOVAL		
		
 		

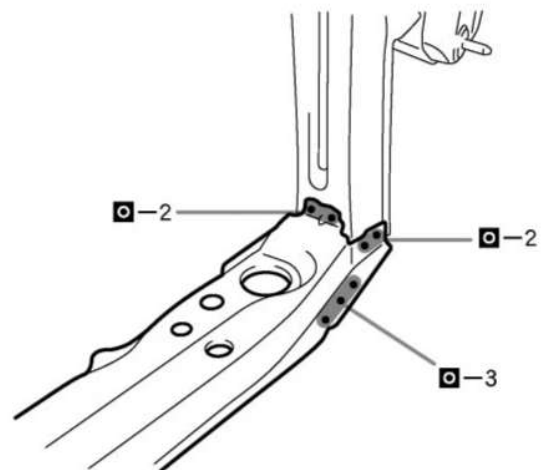
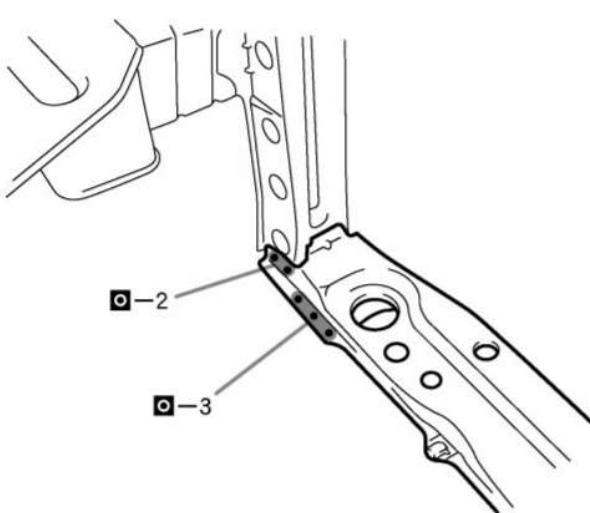
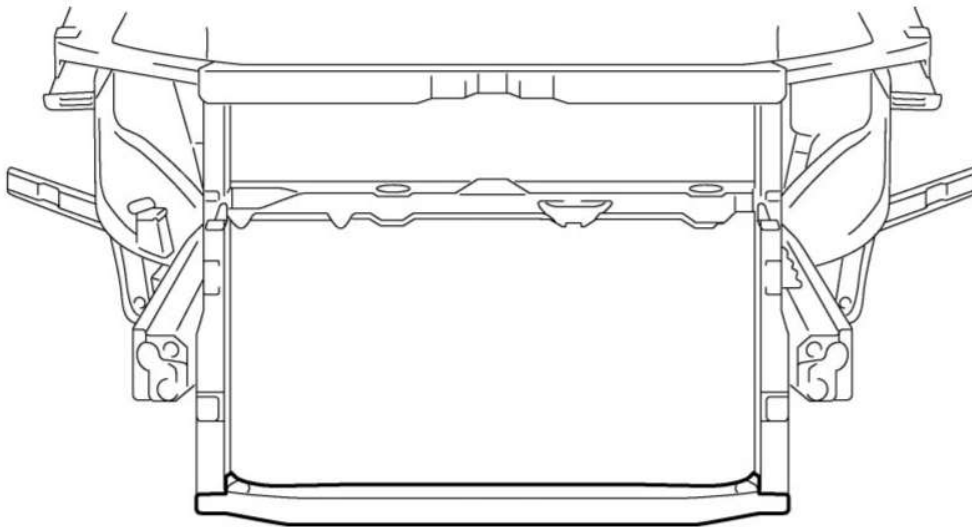
F15605

BP-6

BODY PANEL REPLACEMENT

INSTALLATION

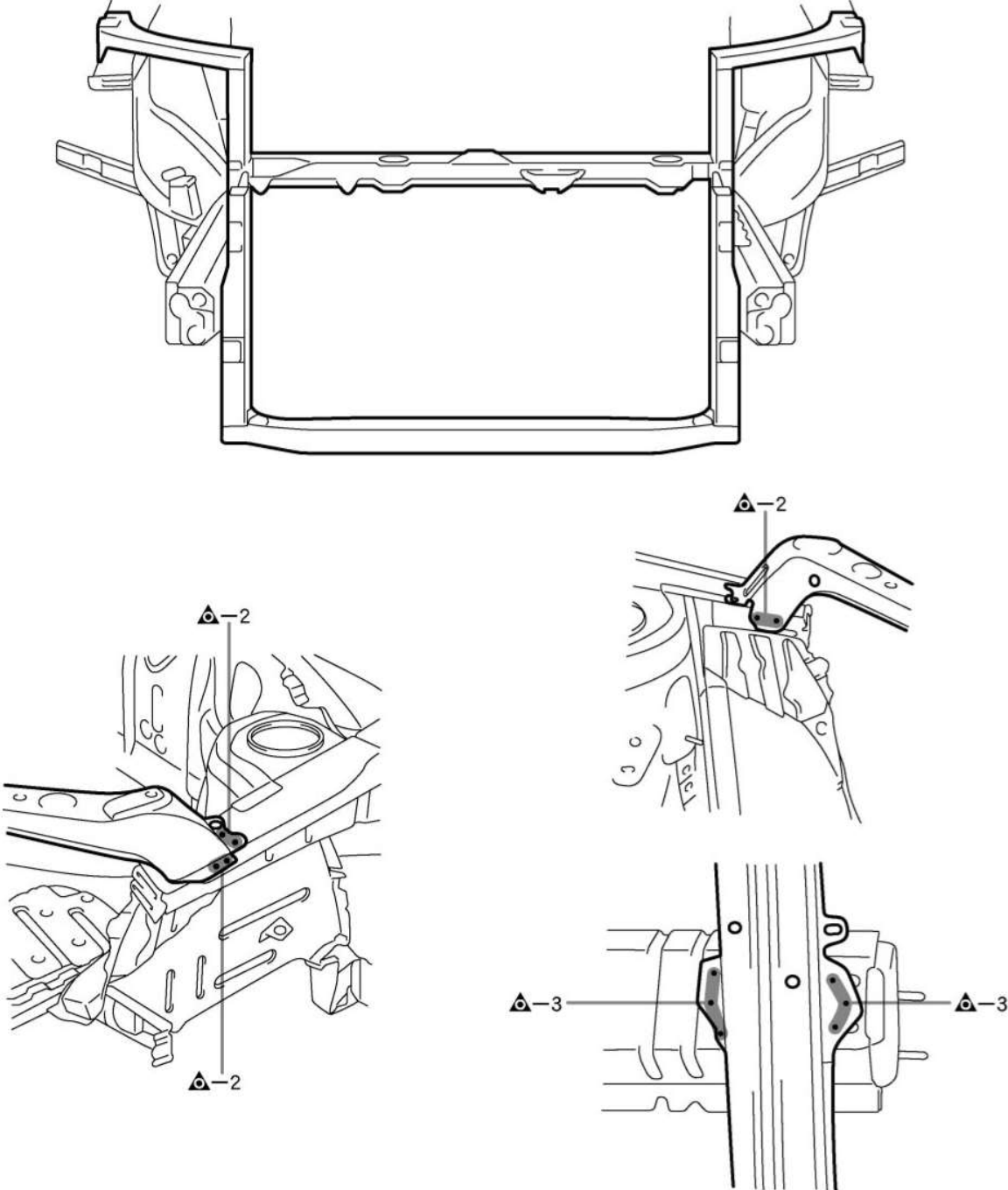
- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



F15606

BODY PANEL REPLACEMENT

BP-7

RADIATOR SUPPORT (ASSY)	 F15607A
REPLACEMENT	
REMOVAL	
	

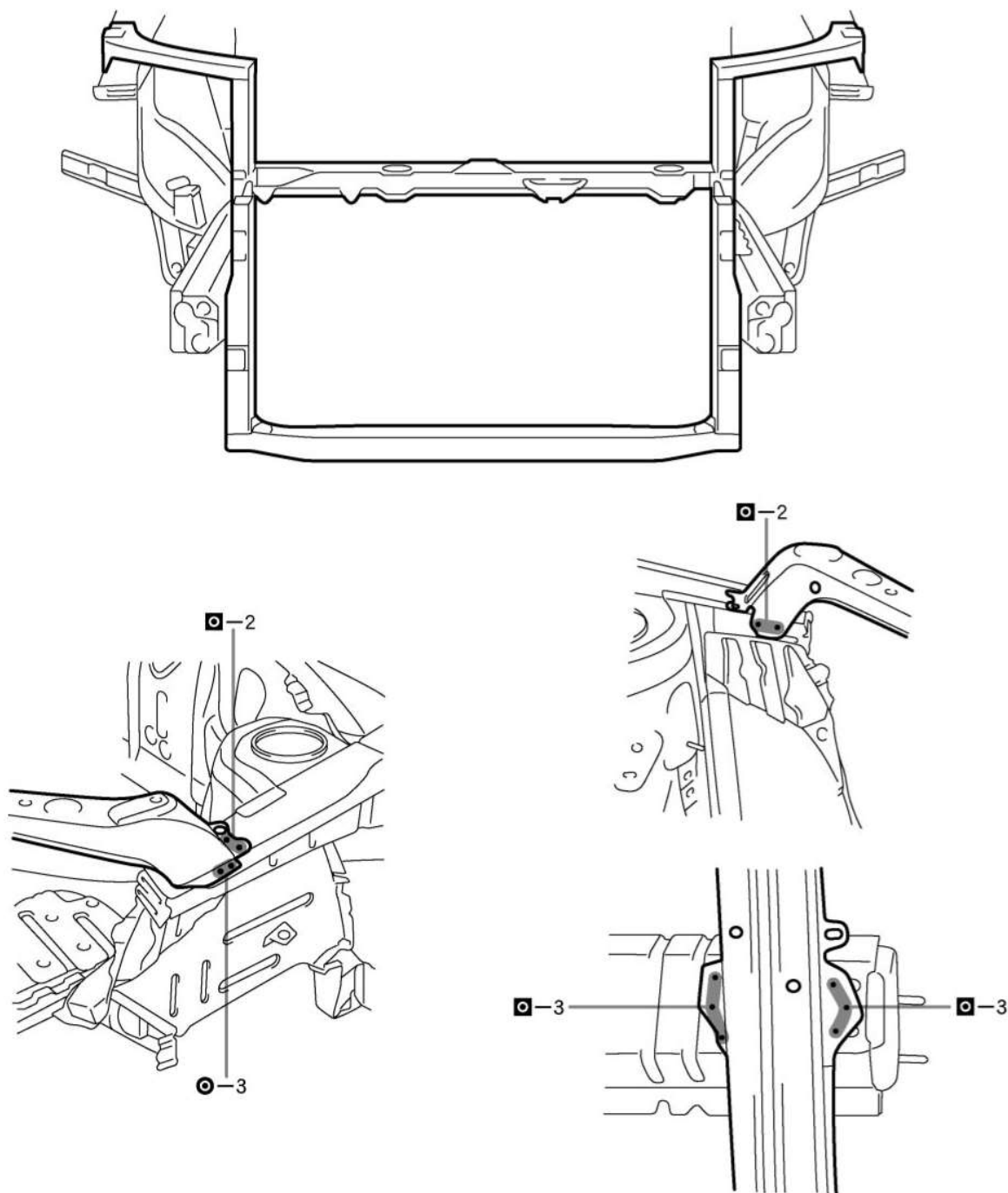
cardiagn.com

BP-8

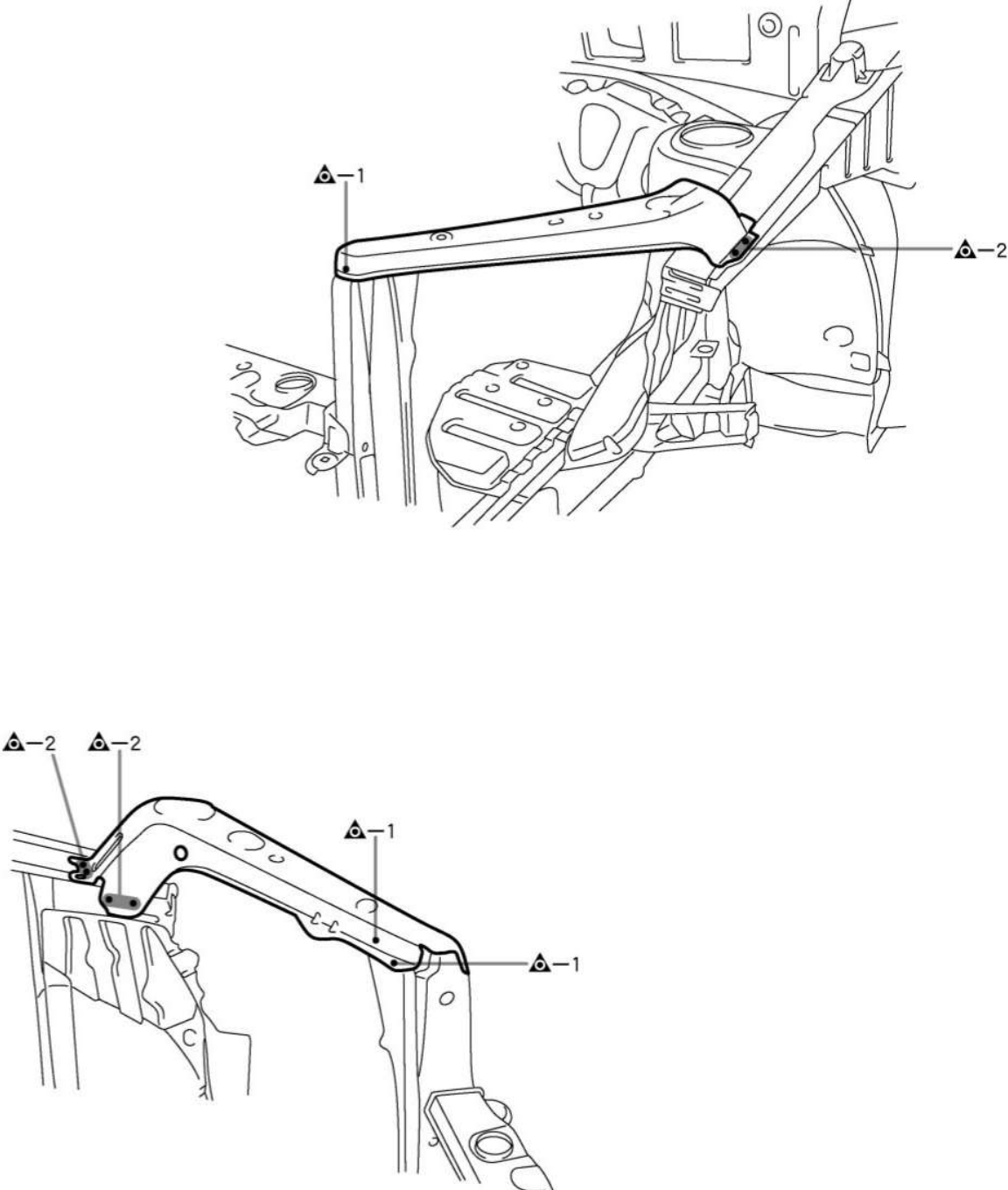
BODY PANEL REPLACEMENT

INSTALLATION

- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



F15608

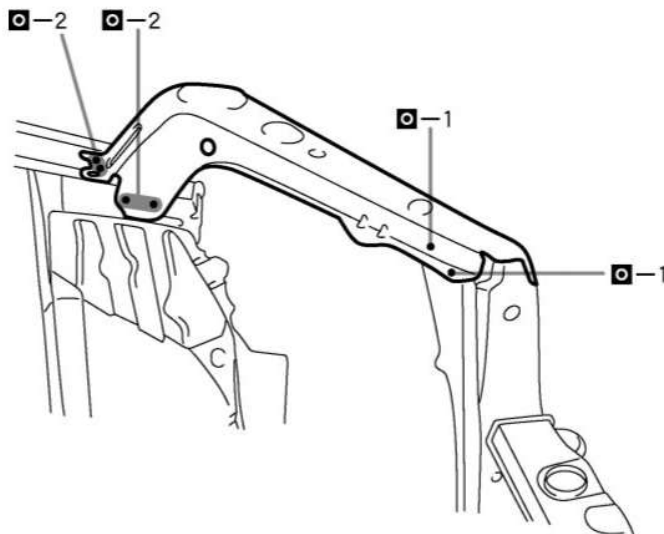
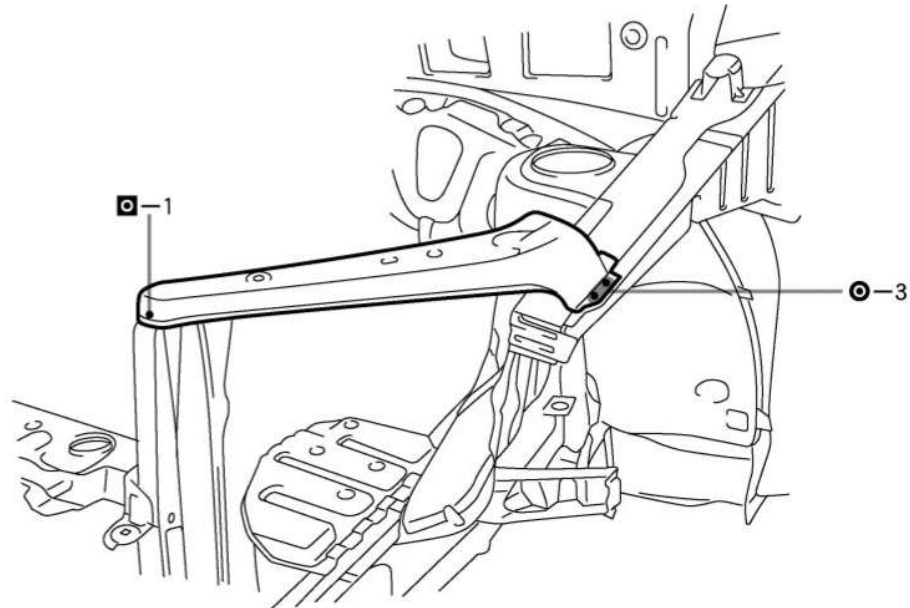
RADIATOR UPPER SUPPORT (ASSY)	 F15601A
REPLACEMENT	
REMOVAL	
	

BP-2

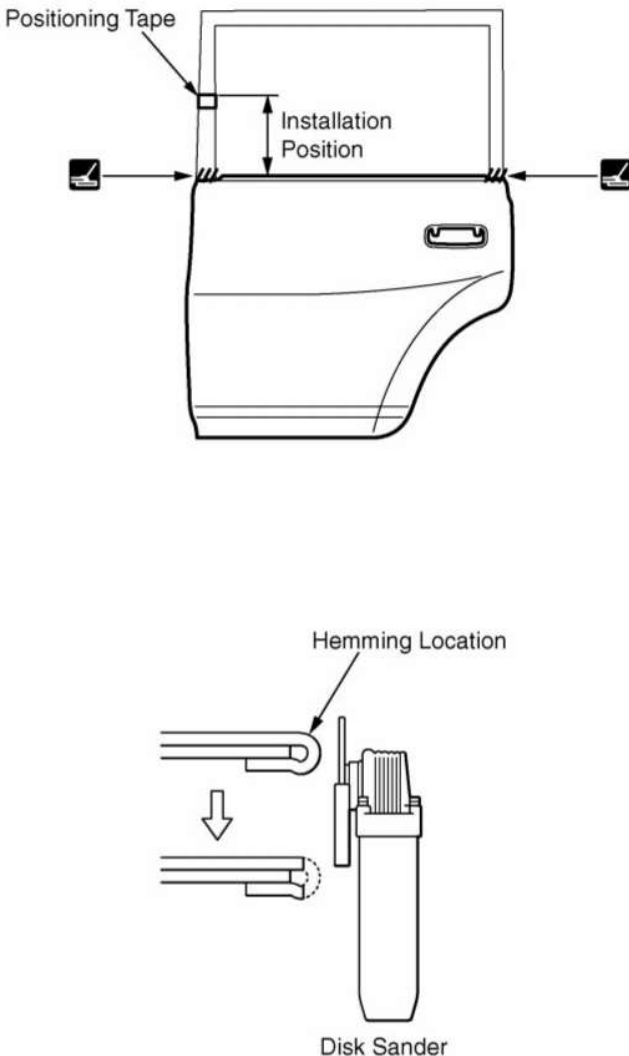
BODY PANEL REPLACEMENT

INSTALLATION

- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



F15602

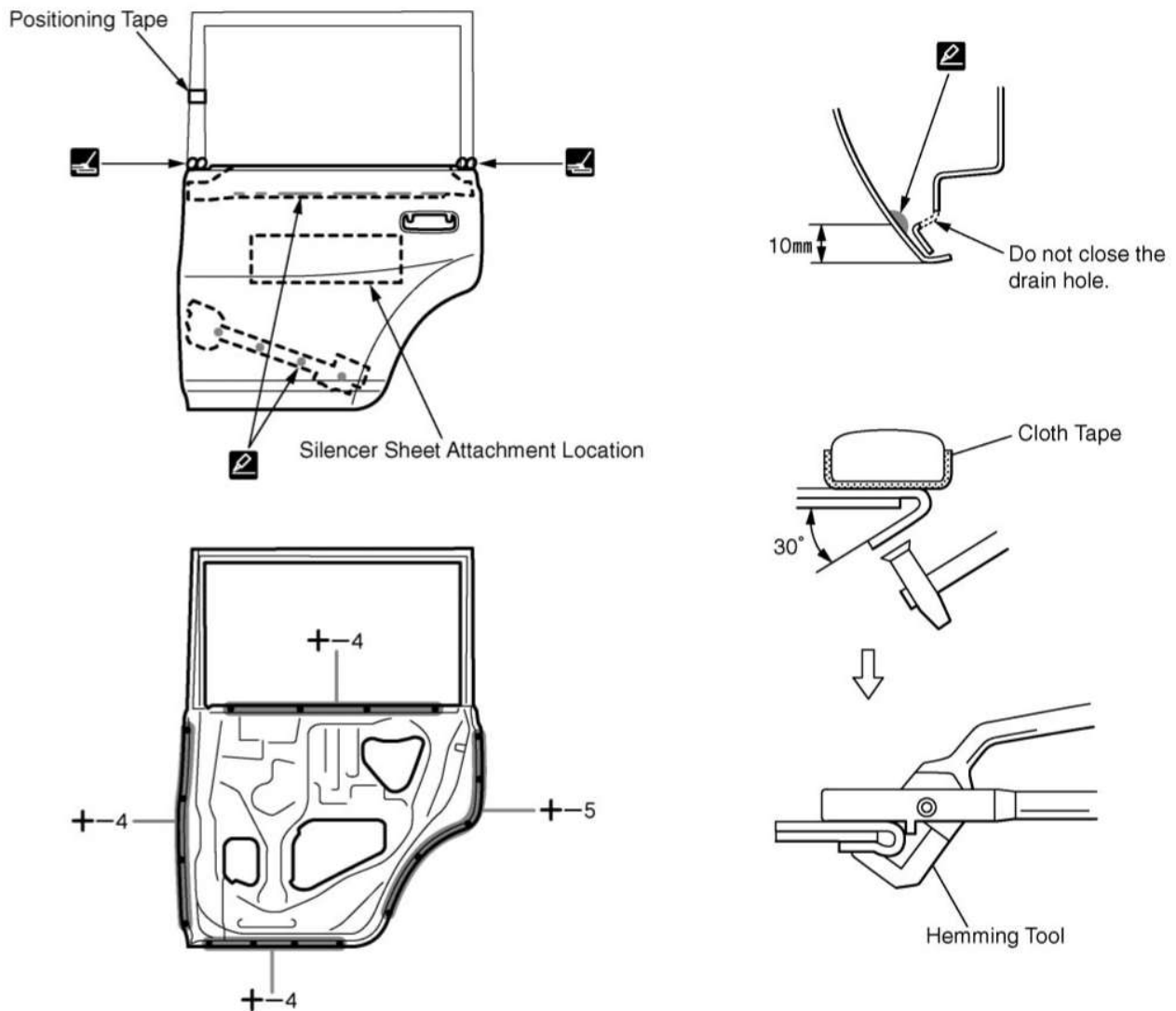
BP-30 BODY PANEL REPLACEMENT	
REAR DOOR OUTER PANEL (ASSY)	 F15678a
REPLACEMENT	
REMOVAL	
 F15678	
POINT 1 Before removing the outer panel, mark the installation position with a tape. 2 Before removing the outer panel, establish its exact position in relation to the window frame using a reference marker, etc. 3 After grinding off the hemming location, remove the outer panel.	

BODY PANEL REPLACEMENT

BP-31

INSTALLATION

- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



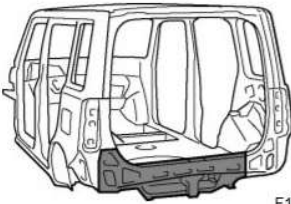
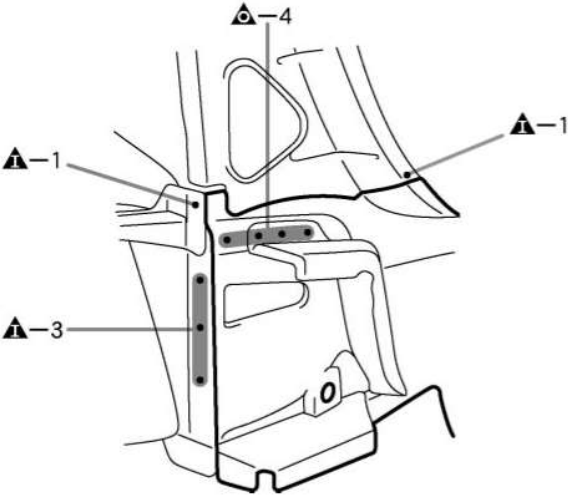
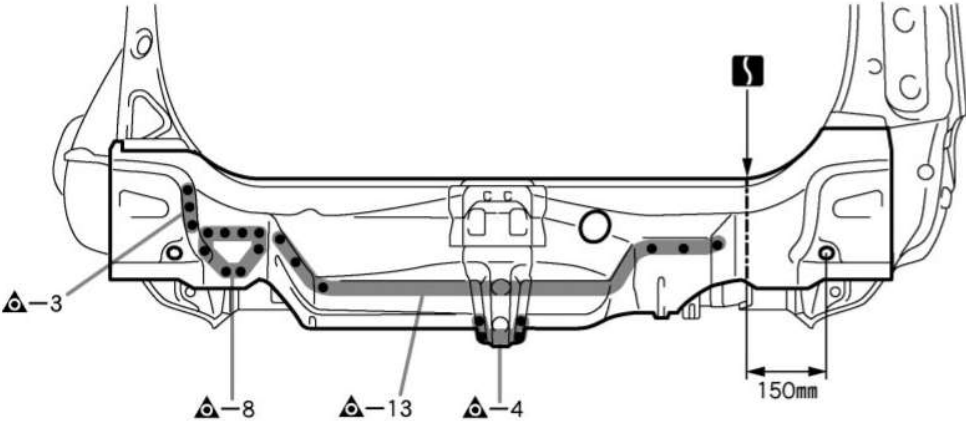
F15679

POINT

- 1 Before temporarily installing the new parts, apply body sealer to the reinforcement, side impact protection beam and back side of the new parts.
HINT:
1) Apply sealer evenly about 10mm (0.39in.) from the flange and 3mm (0.12in.) in diameter to the outer panel and apply just enough sealer for the reinforcement and side impact protection beam to make contact.
- 2 Bend the flange hem about 30° with a hammer and dolly, then fasten tightly with a hemming tool.
HINT:
1) Perform hemming in three steps, being careful not to warp the panel.
2) If a hemming tool cannot be used, hem with a hammer and dolly.

BODY PANEL REPLACEMENT

BP-53

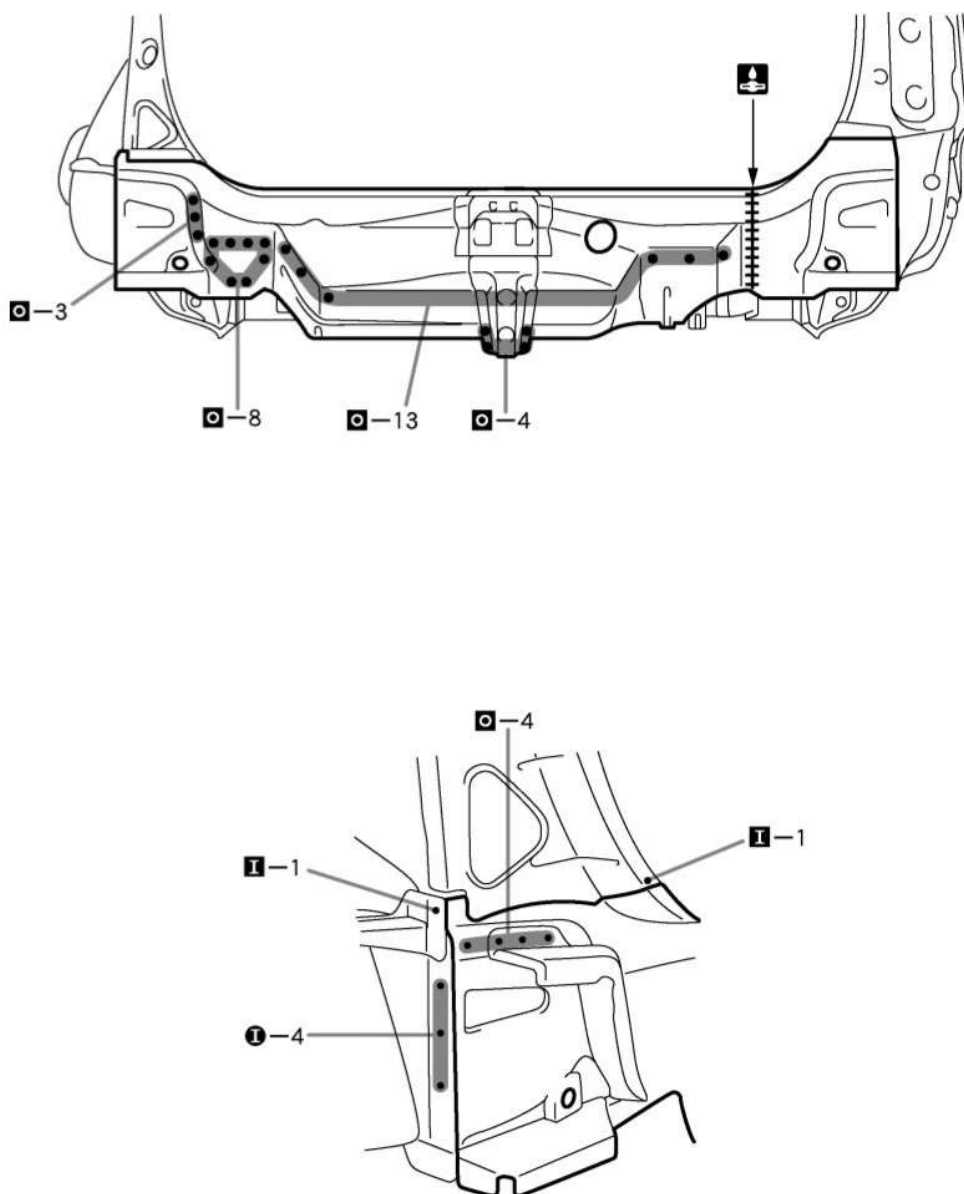
REAR FLOOR NO.5 CROSSMEMBER (CUT)	
REPLACEMENT With the roof side inner front extension removed.	 F15650A
REMOVAL	
 F15650	
150mm (5.90in.)	

BP-54

BODY PANEL REPLACEMENT

INSTALLATION

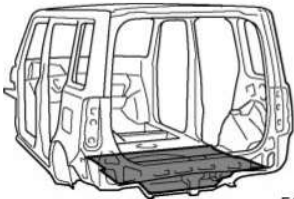
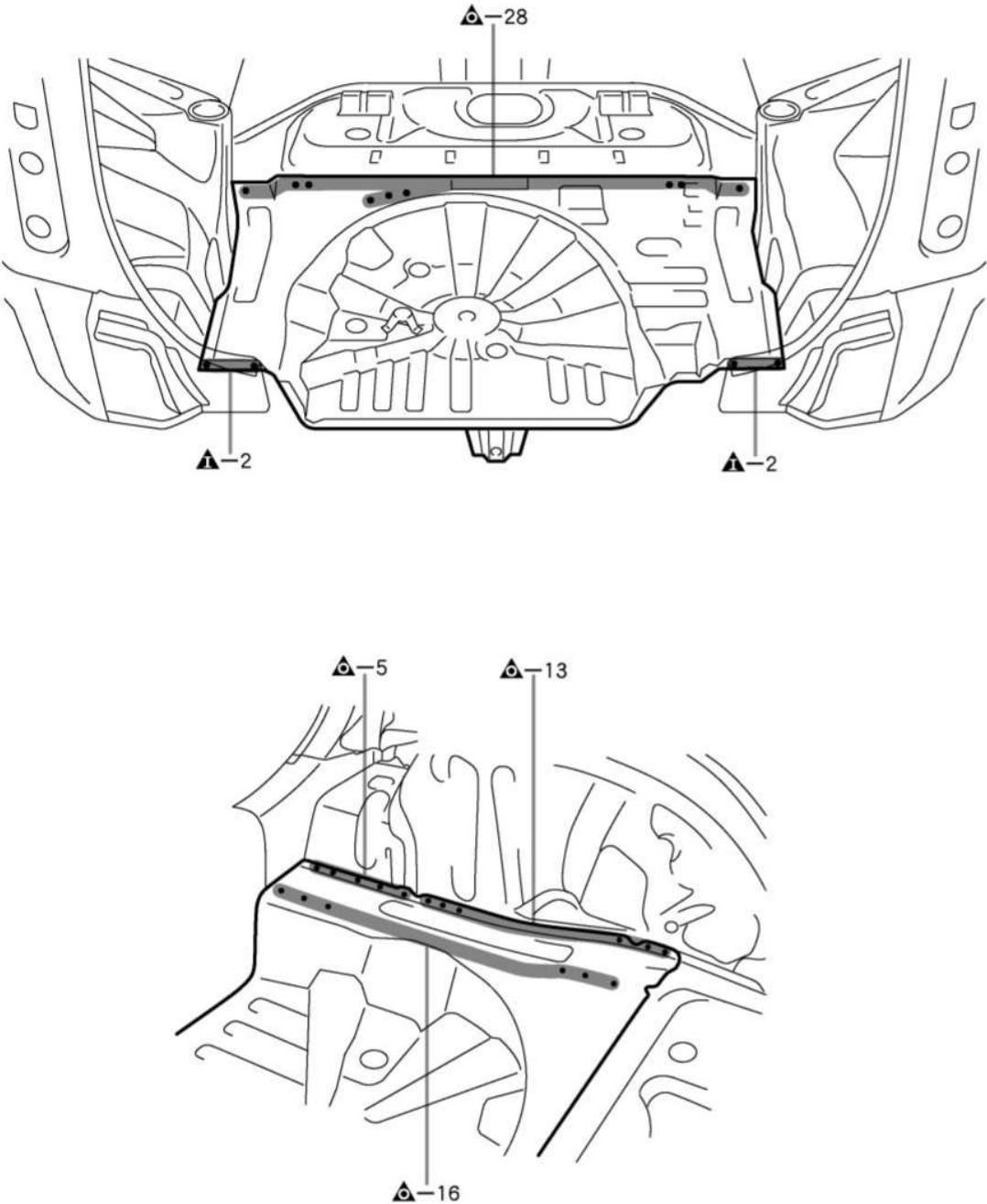
- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



F15651

BODY PANEL REPLACEMENT

BP-55

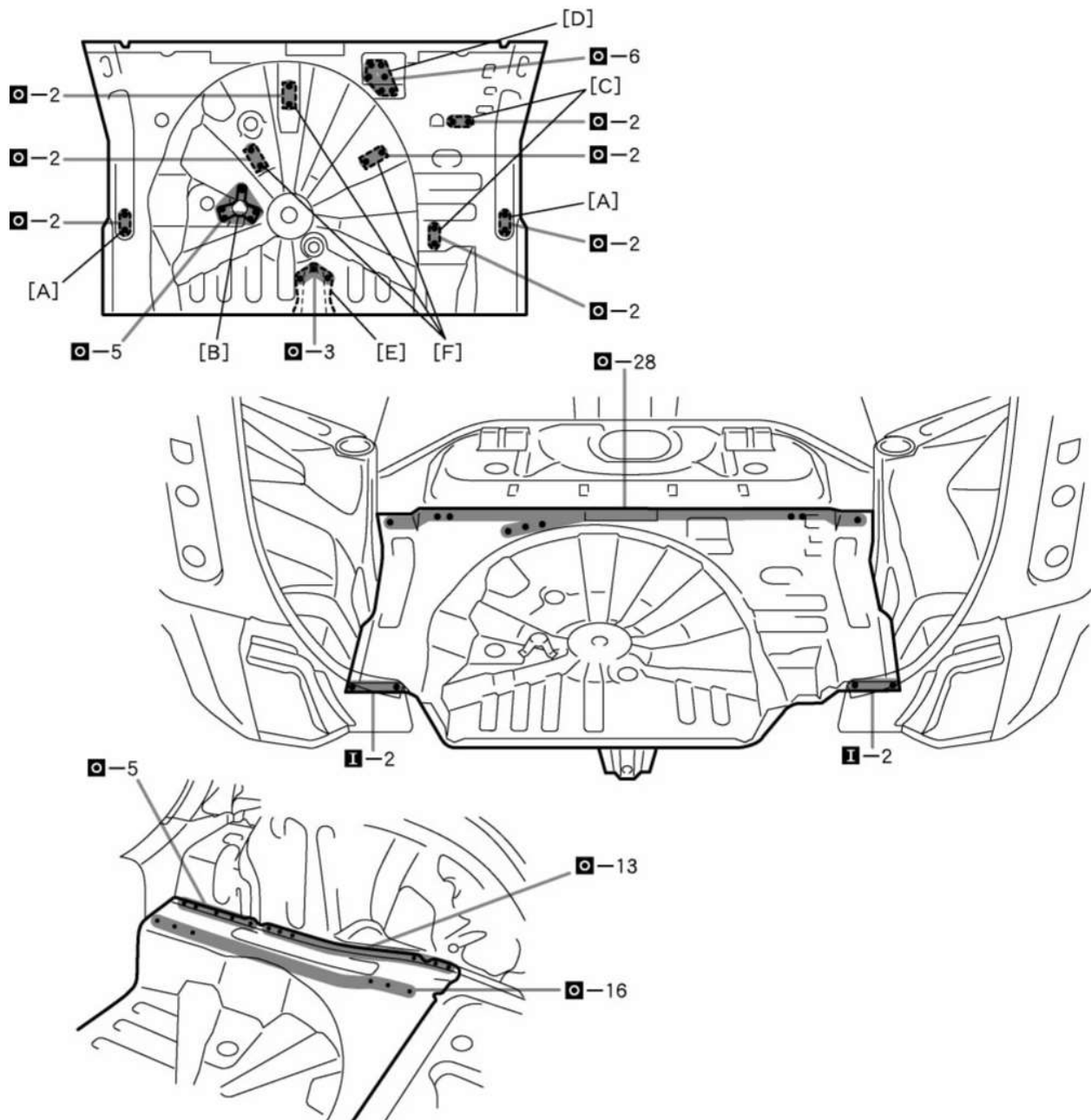
REAR FLOOR PAN (ASSY)	 F15652A
REPLACEMENT With the rear floor crossmember No.5 (CUT-H) removed.	
REMOVAL  F15652	

BP-56

BODY PANEL REPLACEMENT

INSTALLATION

- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



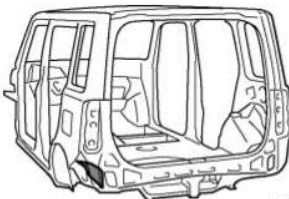
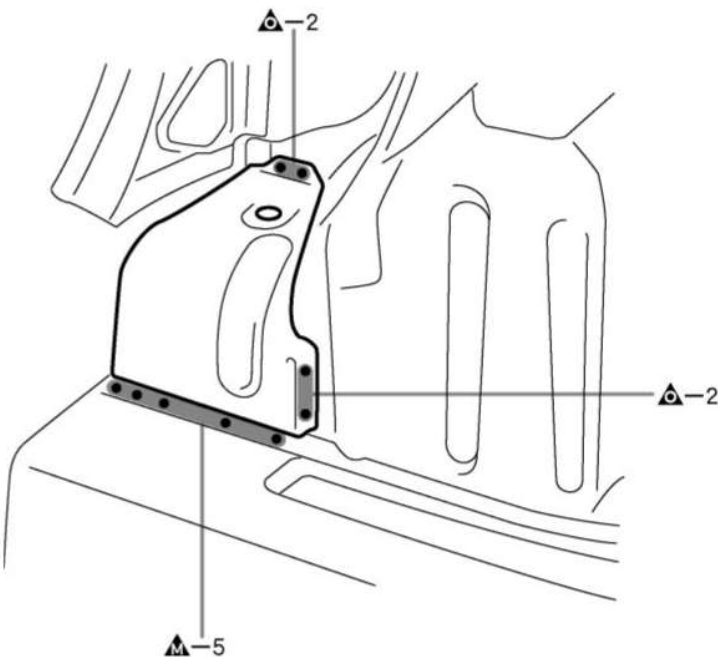
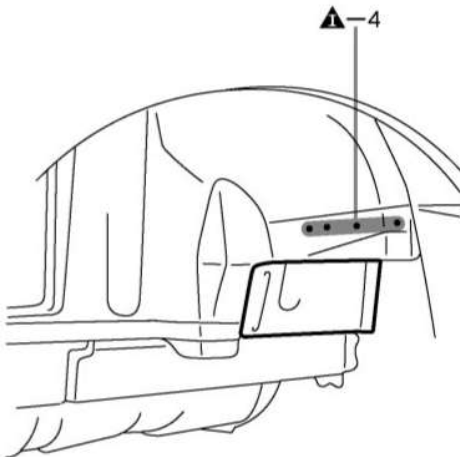
F15653

PART NAME

- | | |
|--|-------------------------------|
| [A] Rear Floor Pan Inner Reinforcement | [B] Spare Wheel Clamp Bracket |
| [C] Rear Floor Heat Insulator No.3 Bracket | [D] Floor Clamp Bracket |
| [E] Jack Up Bracket | [F] Fuel Tube Bracket |

BODY PANEL REPLACEMENT

BP-57

REAR FLOOR PAN EXTENSION (ASSY)		 F15654A
REPLACEMENT With the rear floor No.5 crossmember removed.		
REMOVAL		
 		

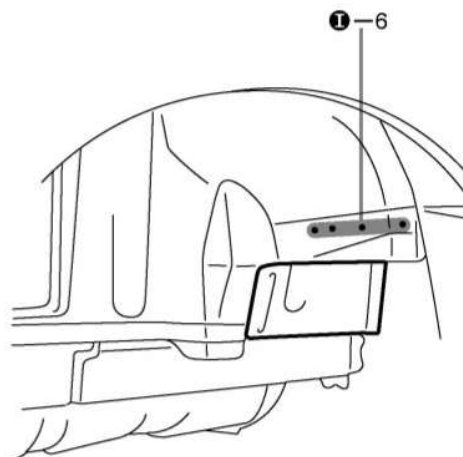
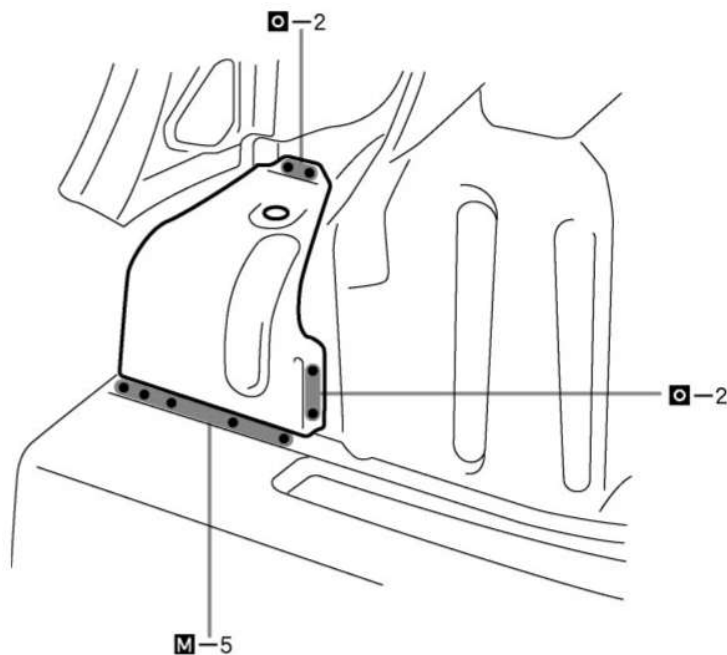
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BP-58

BODY PANEL REPLACEMENT

INSTALLATION

- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



F15655

BODY PANEL REPLACEMENT

BP-59

REAR FLOOR SIDE MEMBER
REINFORCEMENT (ASSY)

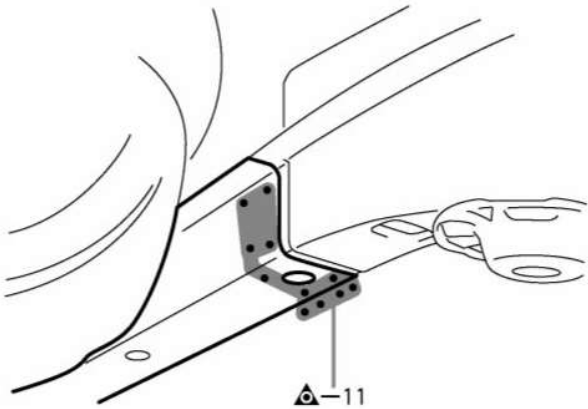
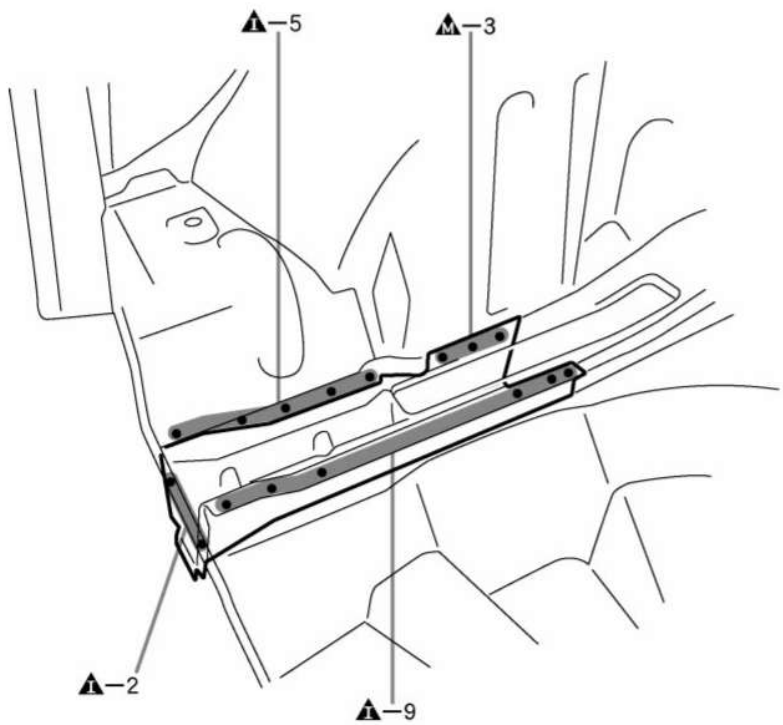
REPLACEMENT

With the rear floor crossmember No.5 removed.



F15656A

REMOVAL



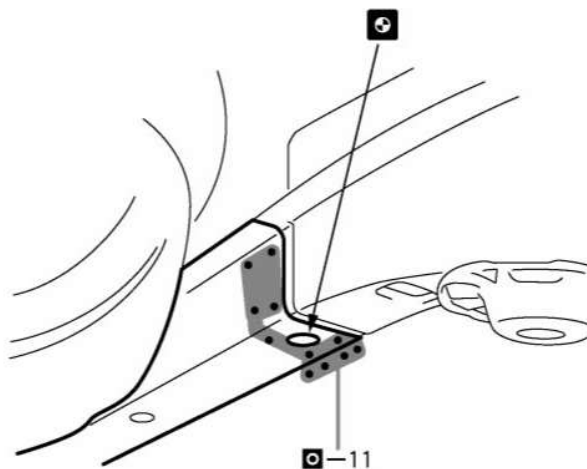
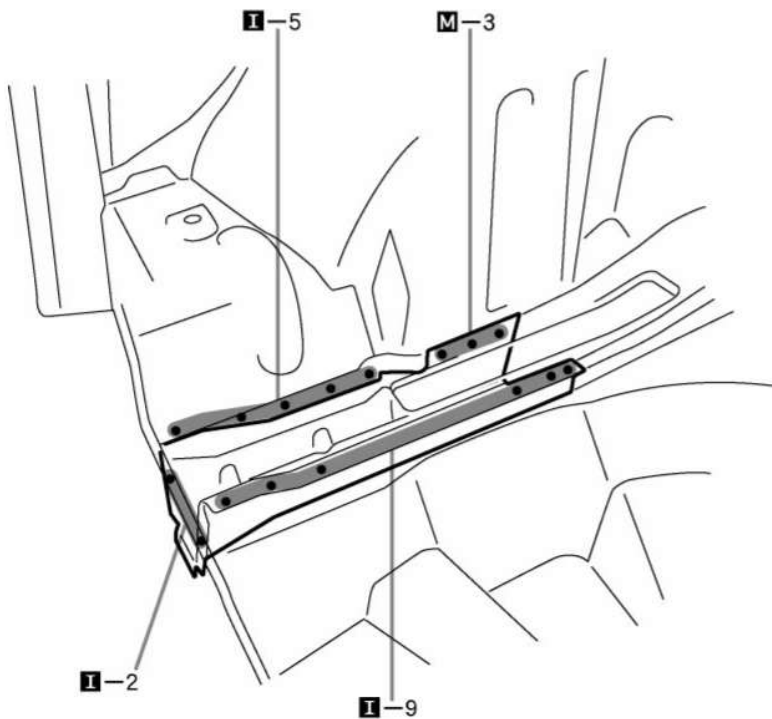
F15656

BP-60

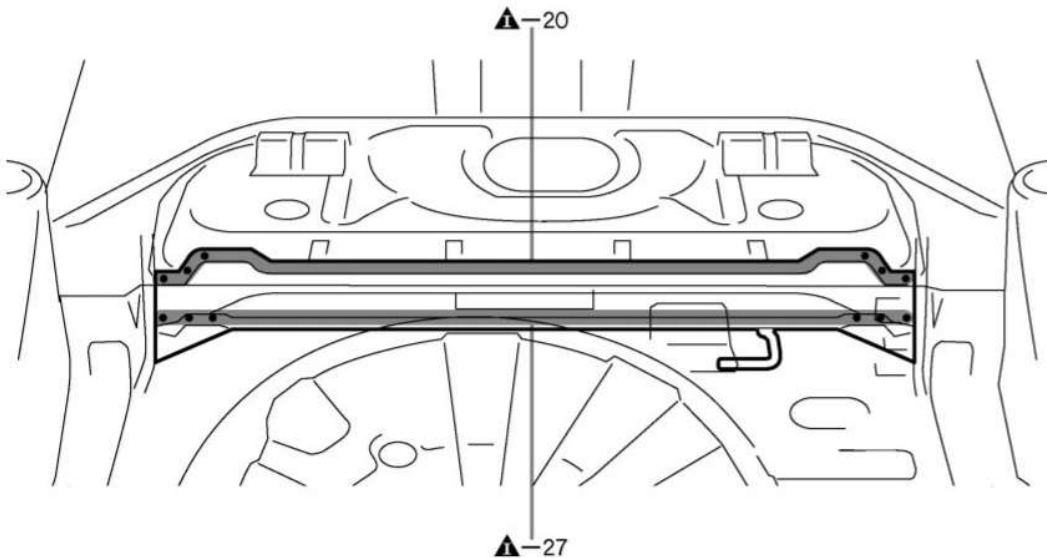
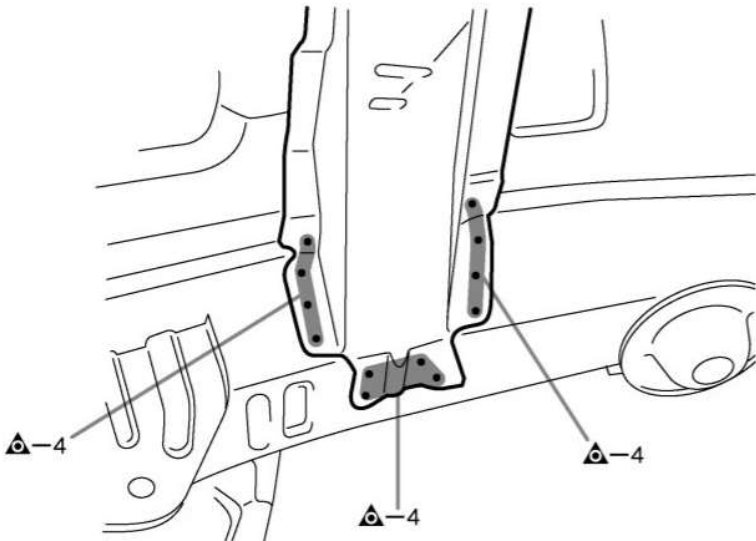
BODY PANEL REPLACEMENT

INSTALLATION

- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



F15657

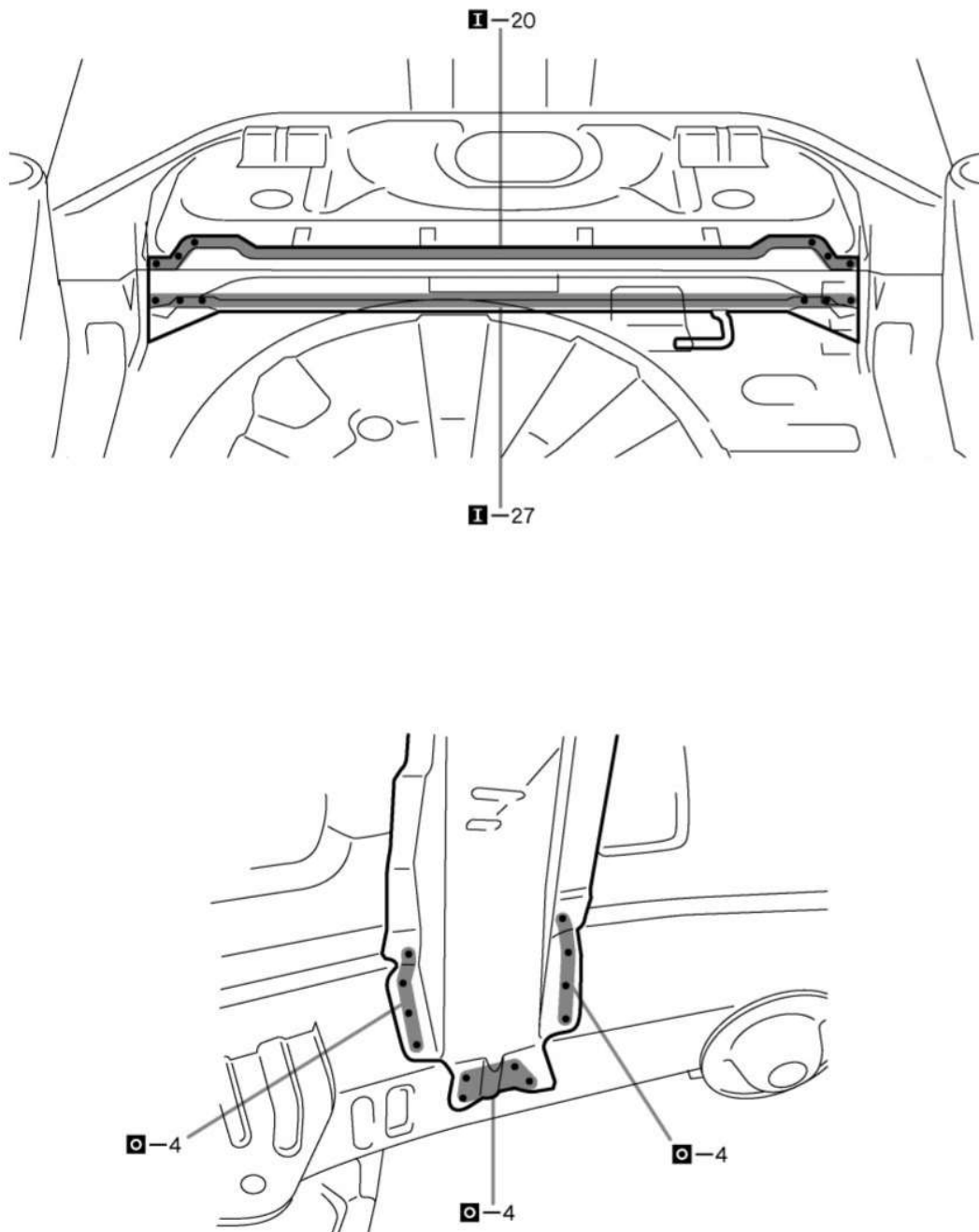
REAR FLOOR NO.2 CROSSMEMBER (ASSY)		 F15658A
REPLACEMENT		
REMOVAL		
  F15658		

BP-62

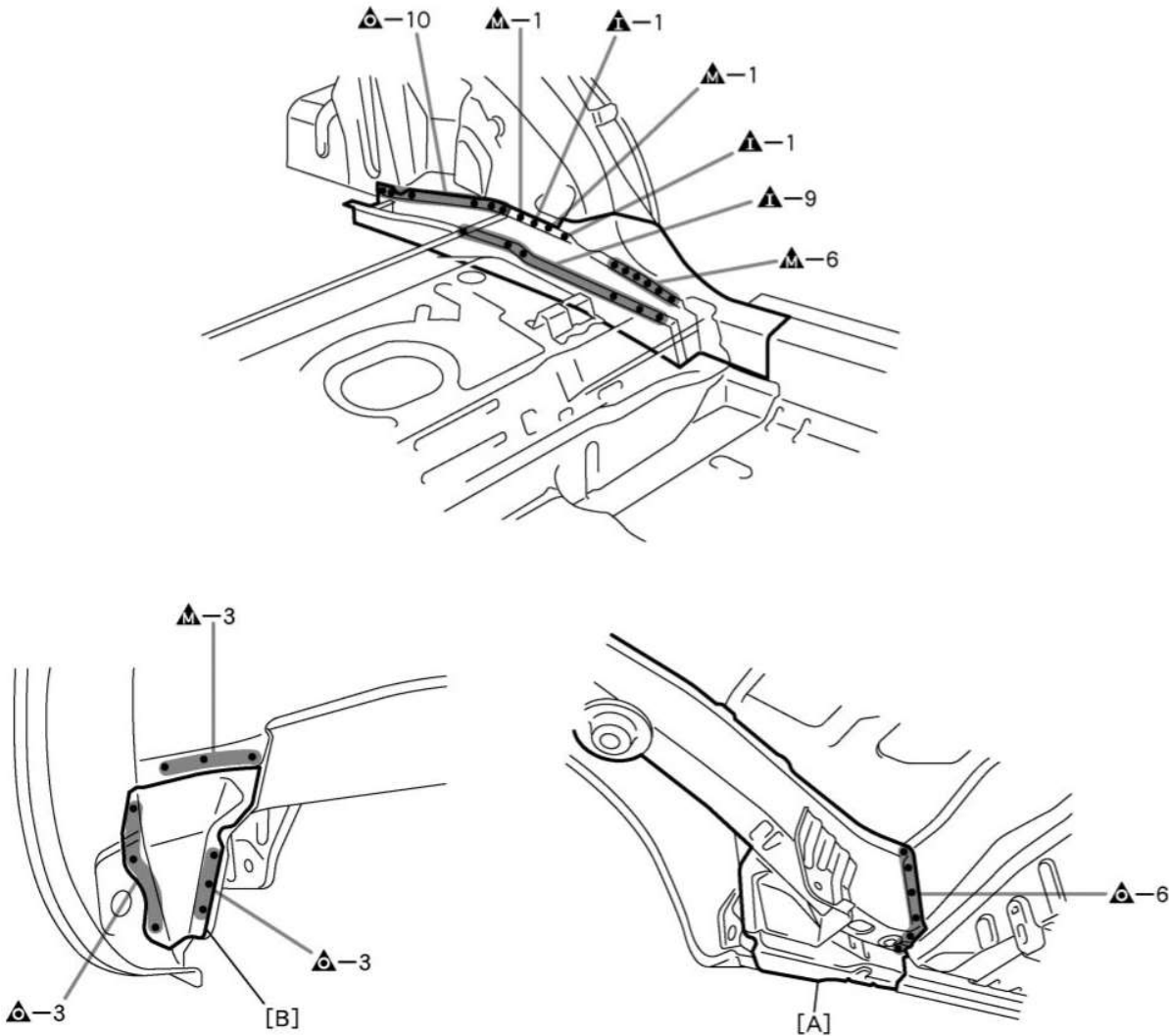
BODY PANEL REPLACEMENT

INSTALLATION

- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.

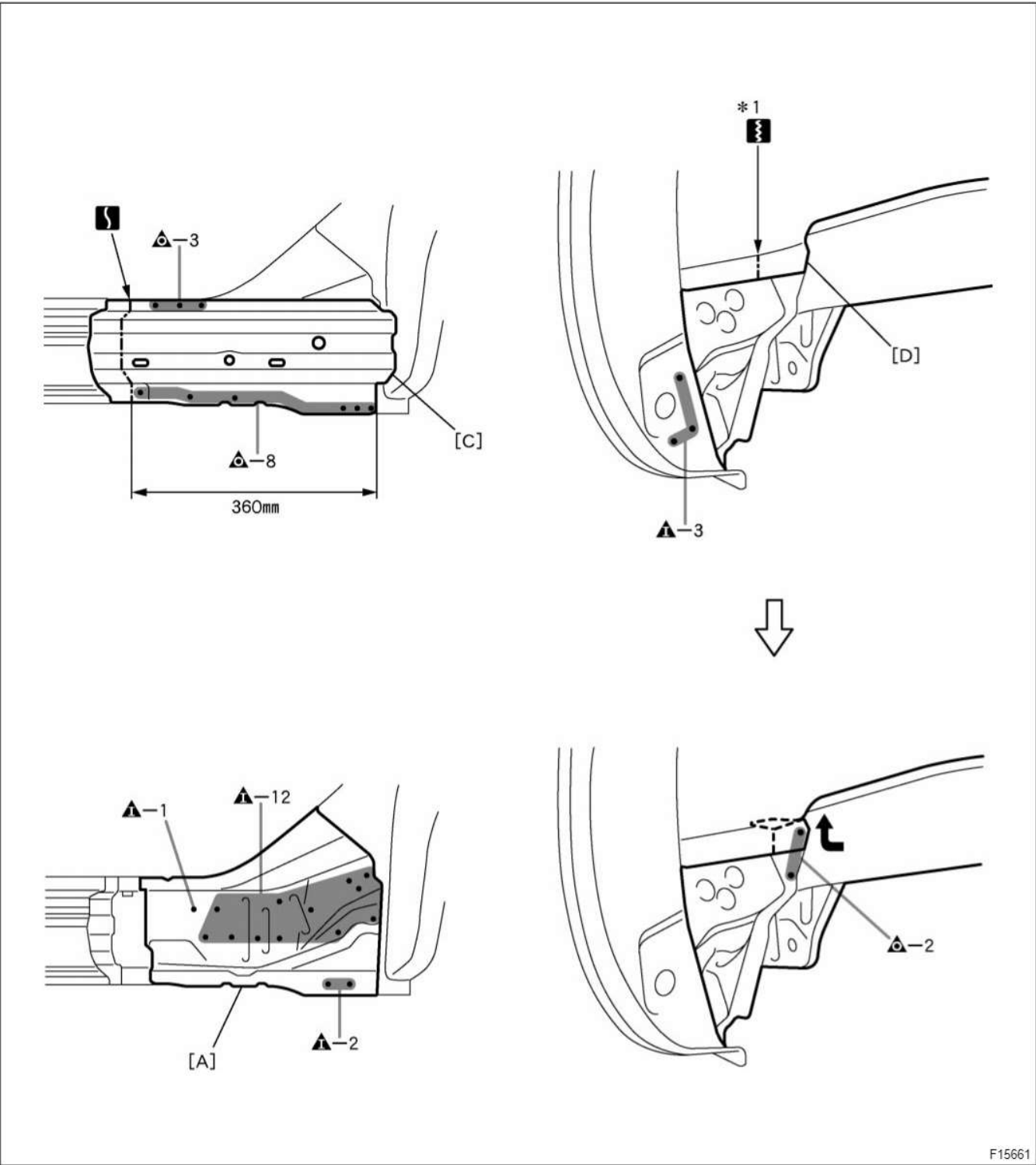


F15659

REAR FLOOR SIDE MEMBER (ASSY) REPLACEMENT With the rear floor pan, rear floor crossmember No.2 and rear floor side member reinforcement removed.	 F15660A
REMOVAL  F15660	
POINT 1 Leave the [A] to the vehicle. 2 [B] and [C] are reused. PART NAME [A] Floor Side Inner Rear Member [B] Quarter Wheel Housing Front Gusset	

BP-64

BODY PANEL REPLACEMENT



F15661

POINT

1 *1: Make an incision in the [D] and bend it upward.

PART NAME

[A] Floor Side Inner Rear Member [C] Rocker Outer Reinforcement
[D] Quarter Wheel Housing Inner Panel

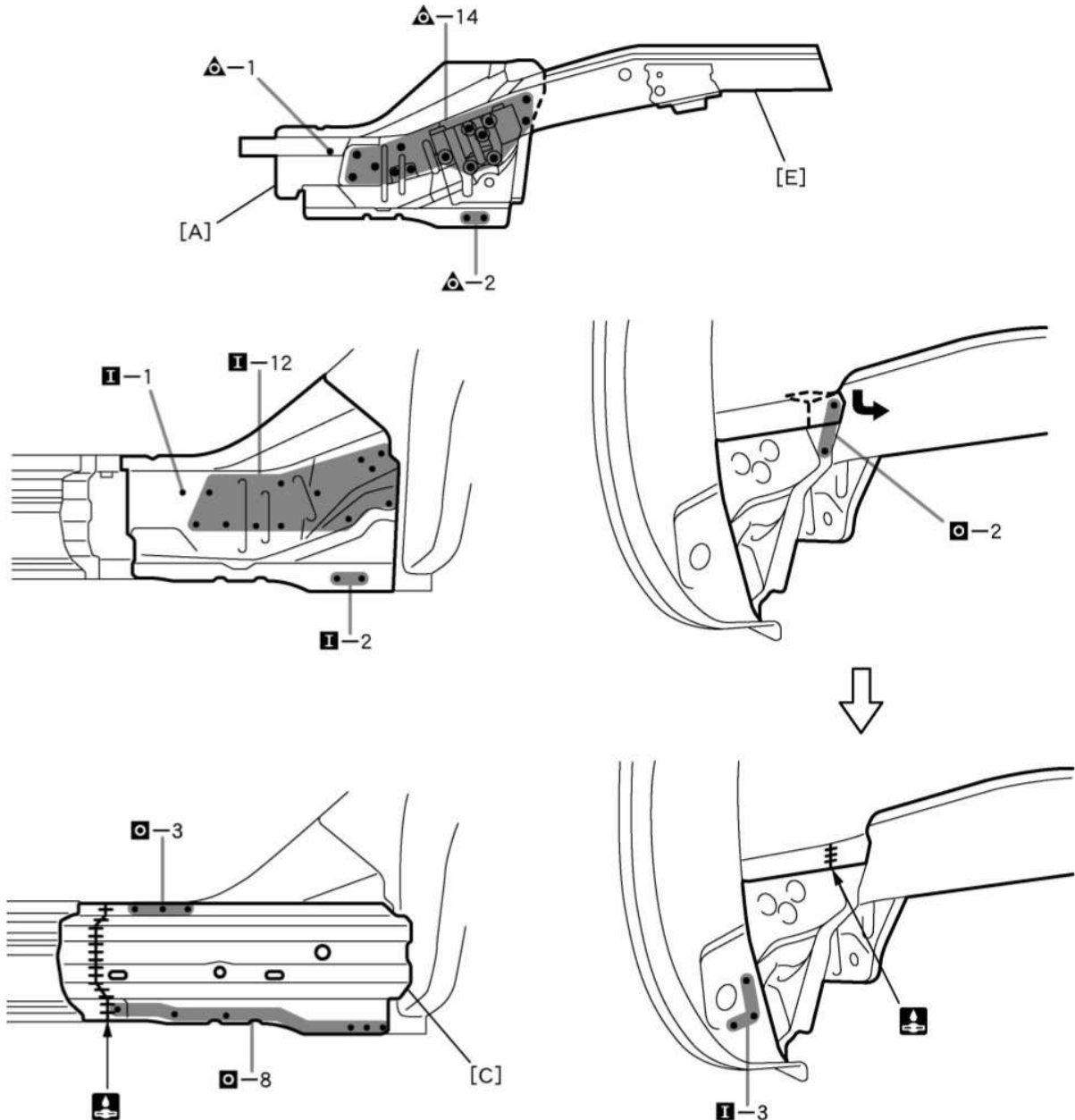
360mm (14.17in.)

BODY PANEL REPLACEMENT

BP-65

INSTALLATION

- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



F15662

POINT

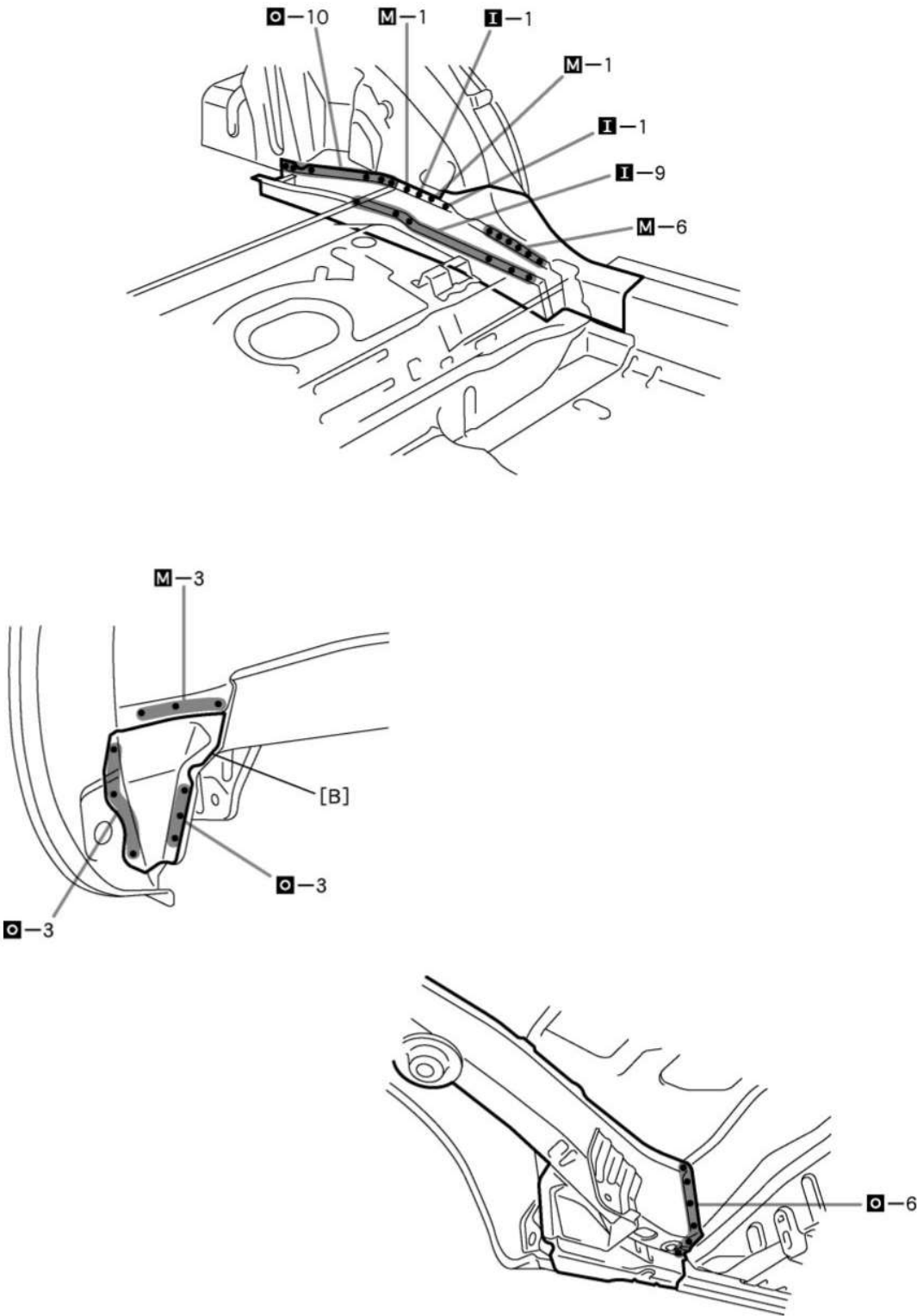
- 1 Remove the [A] from the [E] before the installation.

PART NAME

- [A] Floor Side Inner Rear Member [C] Rocker Outer Reinforcement
[E] Rear Floor Side Member

BP-66

BODY PANEL REPLACEMENT

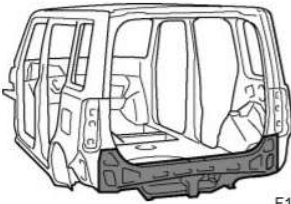
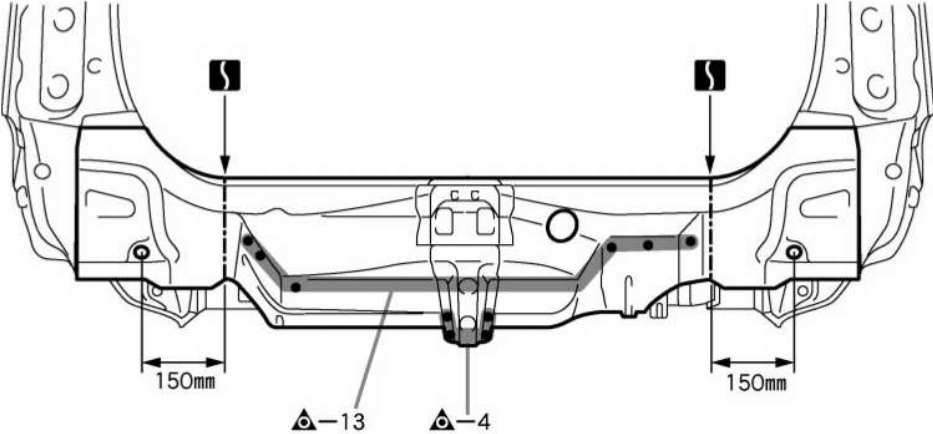


F15663

PART NAME
[B] Quarter Wheel Housing Front Gusset

BODY PANEL REPLACEMENT

BP-51

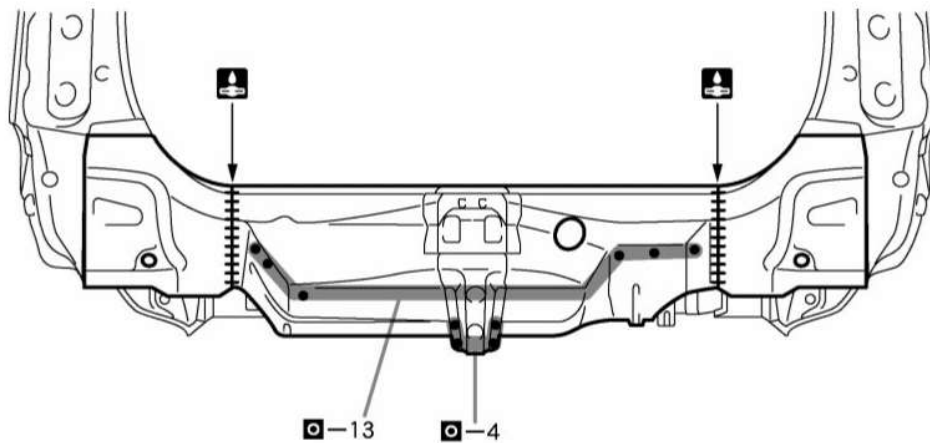
REAR FLOOR NO.5 CROSSMEMBER (CUT-H)	
REPLACEMENT With the body lower back panel removed.	 F15648A
REMOVAL	
 F15648	
150mm (5.90in.)	

BP-52

BODY PANEL REPLACEMENT

INSTALLATION

- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



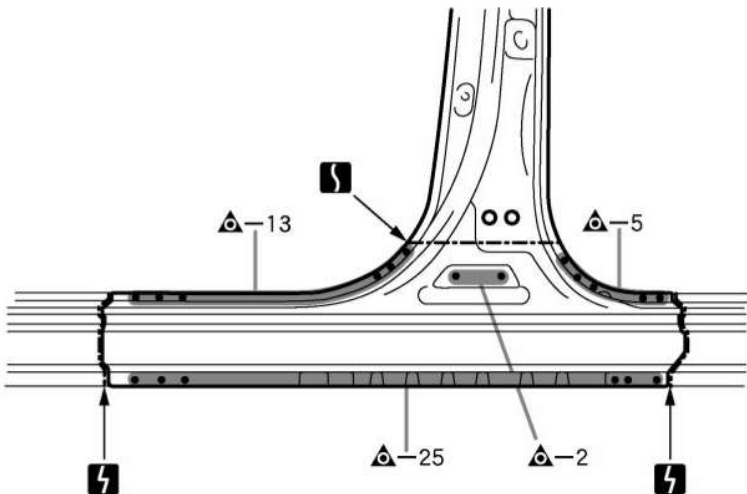
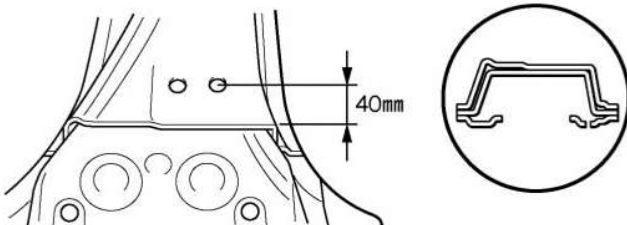
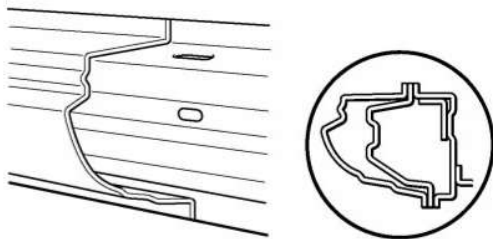
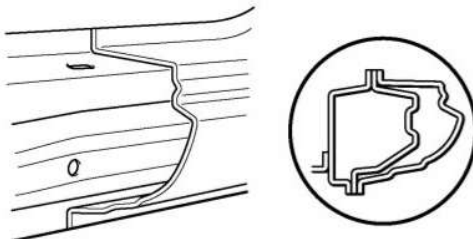
F15649

POINT

- 1 Inspect the fitting of the back door and rear combination light, etc., before welding, since this affects the appearance of the finish.

BP-34

BODY PANEL REPLACEMENT

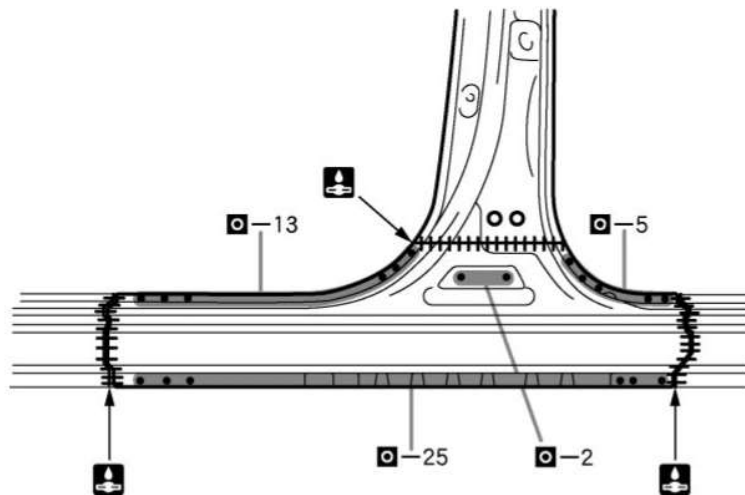
ROCKER OUTER PANEL (CUT)		 F15631A
REPLACEMENT		
REMOVAL		
		
		
		
		
F15631		
40mm (1.57in.)		

BODY PANEL REPLACEMENT

BP-35

INSTALLATION

- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



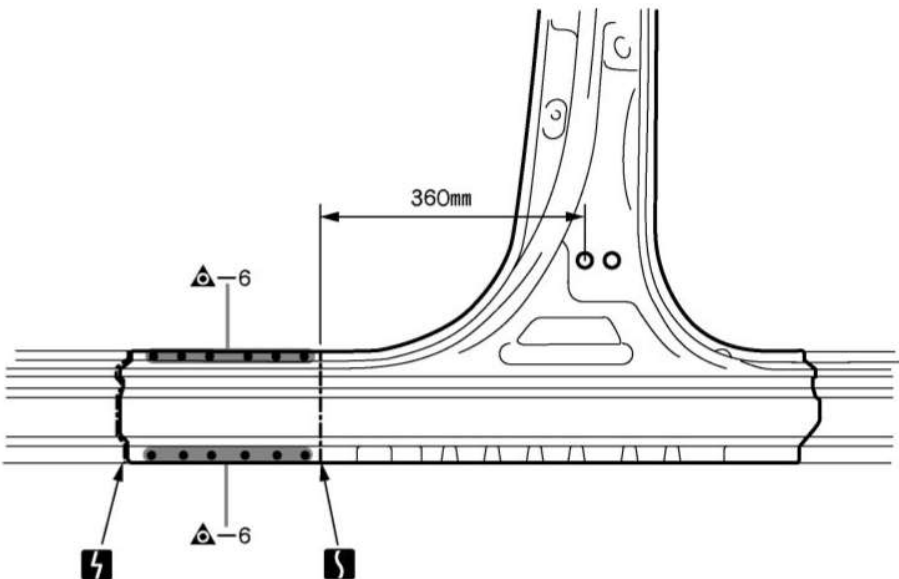
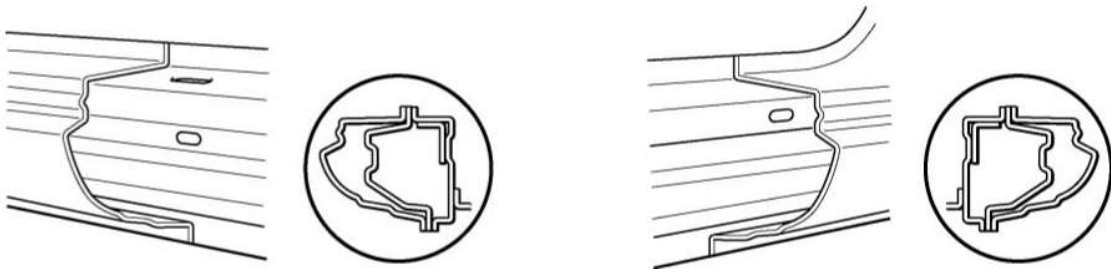
F15632

POINT

- 1 Inspect the fitting of the front door and rear door, etc., before welding, since this affects the appearance of the finish.

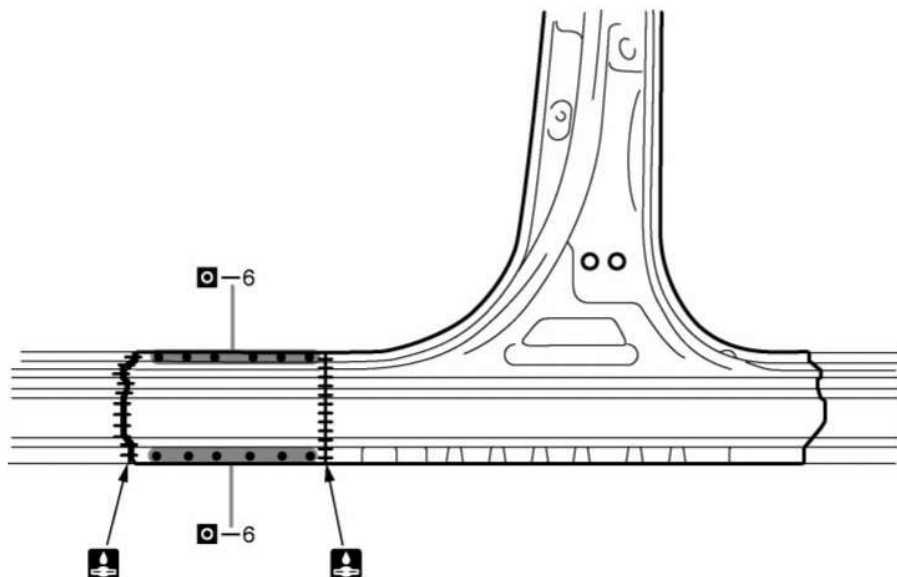
BP-32

BODY PANEL REPLACEMENT

ROCKER OUTER PANEL (CUT-P)		 F15629-2A
REPLACEMENT		
REMOVAL		
		
		
F15629-2		
360mm (14.17in.)		

BODY PANEL REPLACEMENT**BP-33****INSTALLATION**

- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



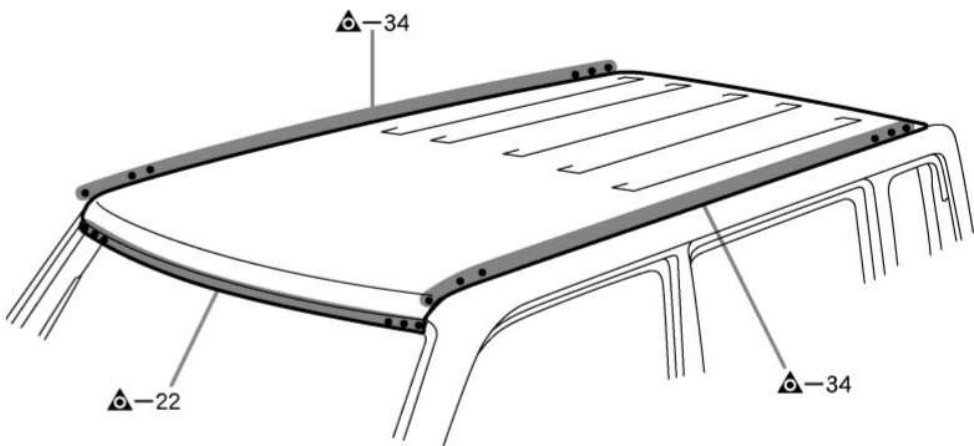
F15630

POINT

- 1 Inspect the fitting the front door, etc., before welding, since this affects the appearance of the finish.

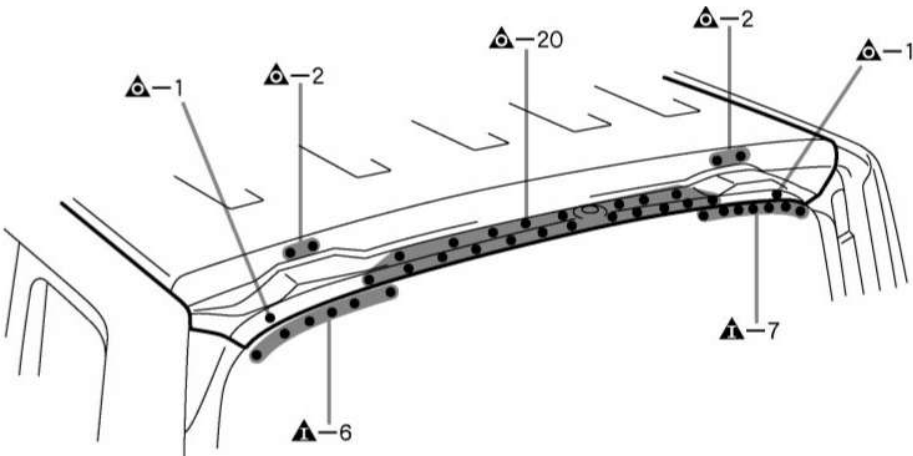
BODY PANEL REPLACEMENT

BP-67

ROOF PANEL (ASSY)	 F15664A
REPLACEMENT	
REMOVAL	
 F15664	

BP-68

BODY PANEL REPLACEMENT



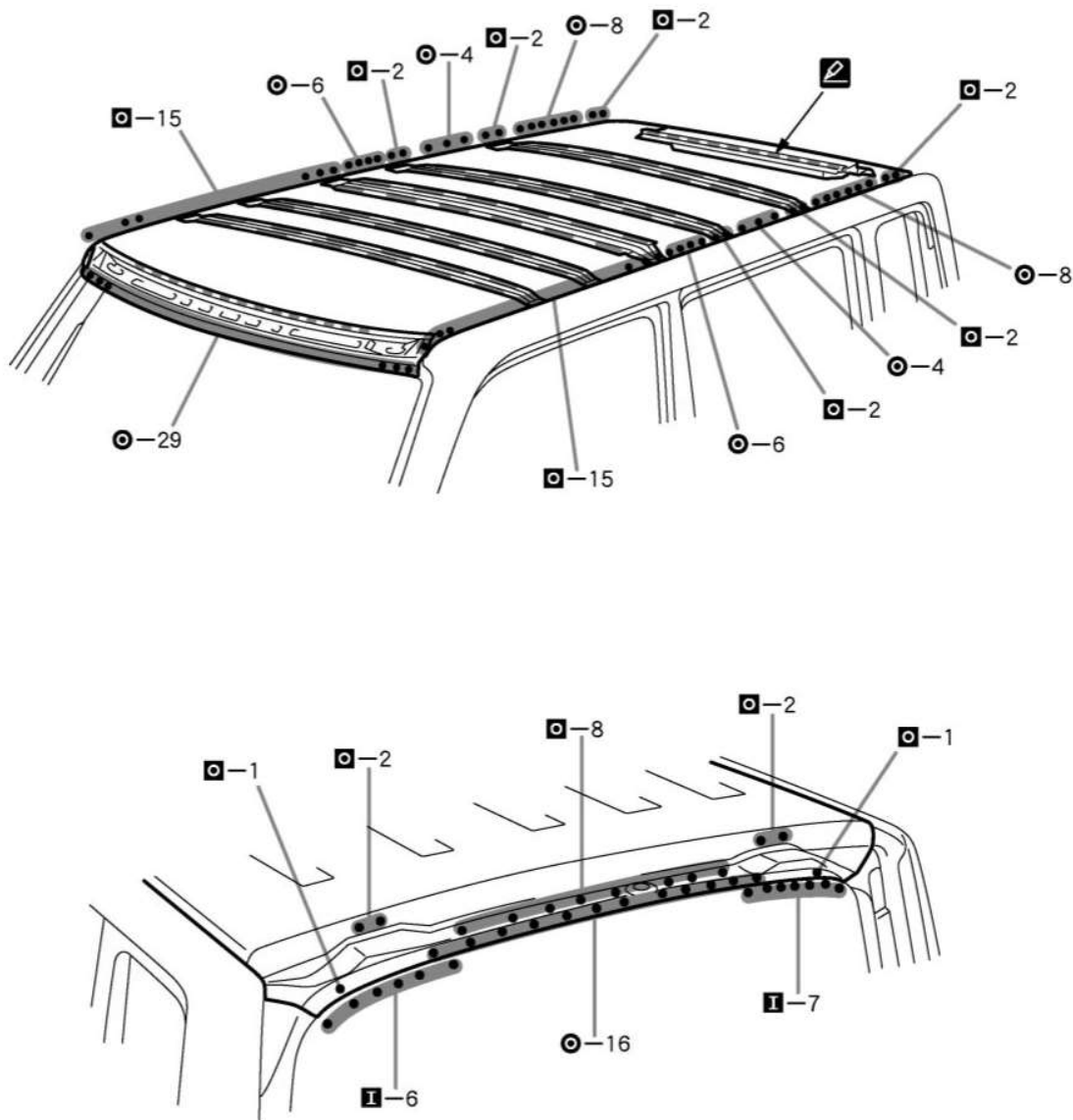
F15665

BODY PANEL REPLACEMENT

BP-69

INSTALLATION

- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



F15666

POINT

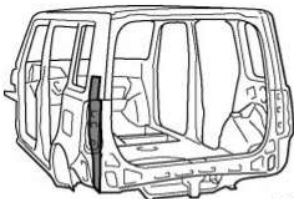
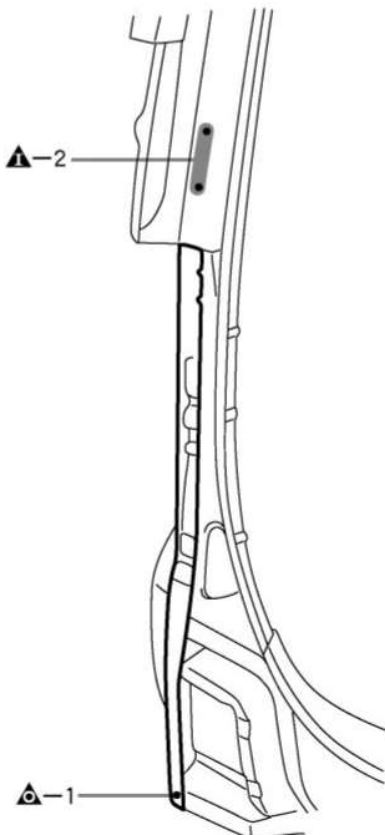
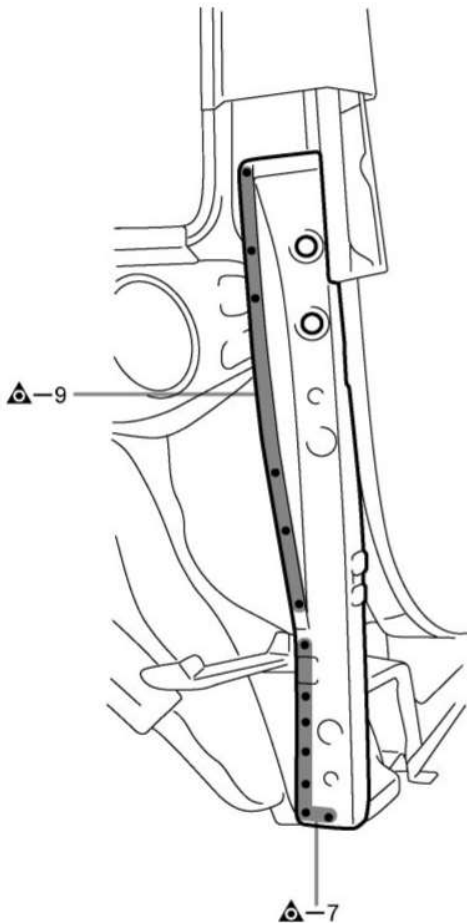
- 1 Apply just enough sealer for the new parts to make contact.

POINT

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

HINT:

- 1) Apply just enough sealer for the new parts to make contact.

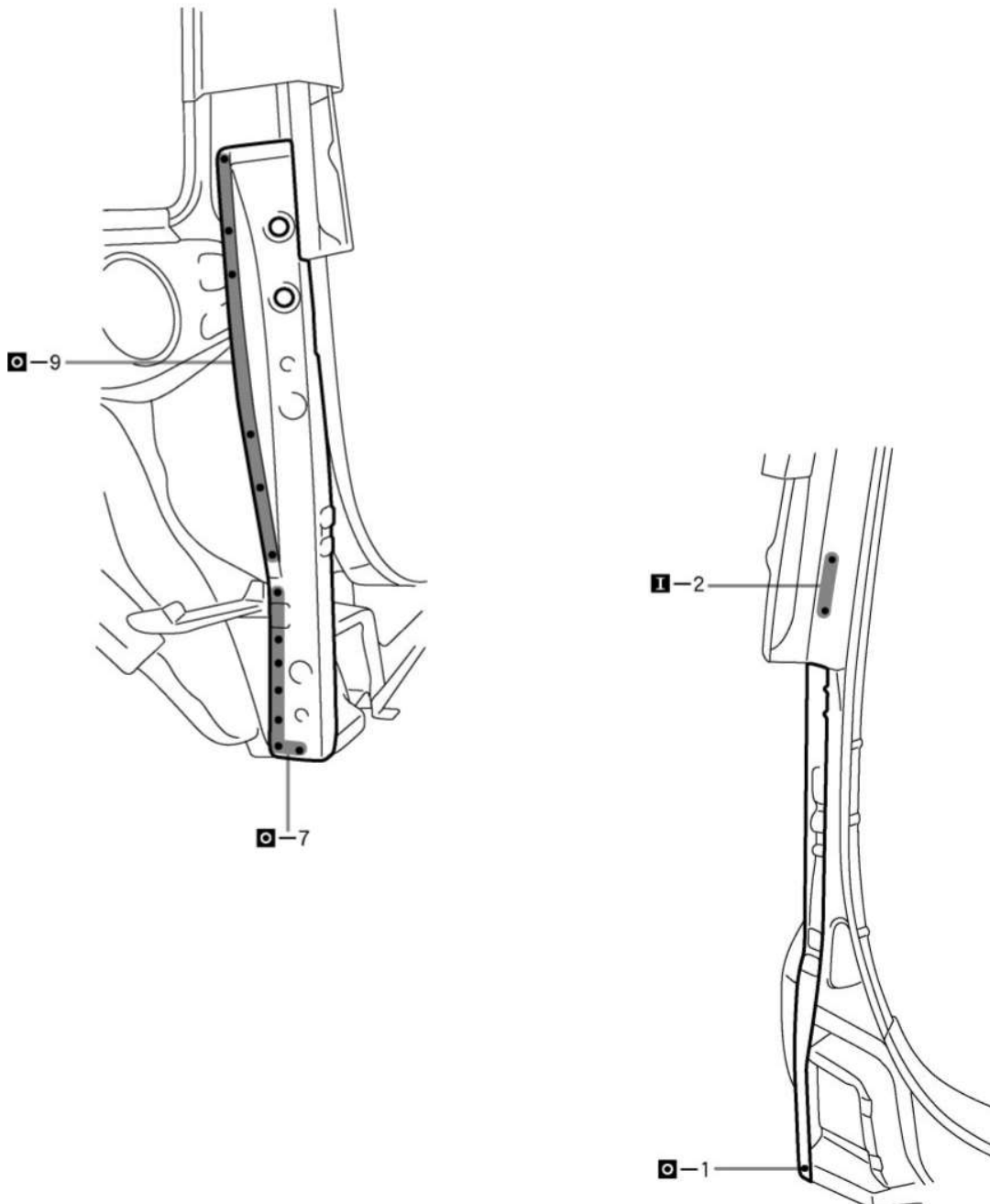
BODY PANEL REPLACEMENT		BP-47
ROOF SIDE INNER FRONT EXTENSION (ASSY) REPLACEMENT With the back door opening trough removed.		 F15644A
REMOVAL  F15644		

BP-48

BODY PANEL REPLACEMENT

INSTALLATION

- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



F15645