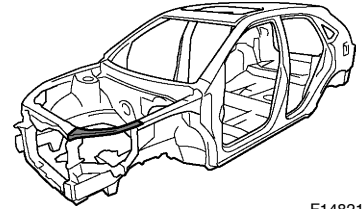
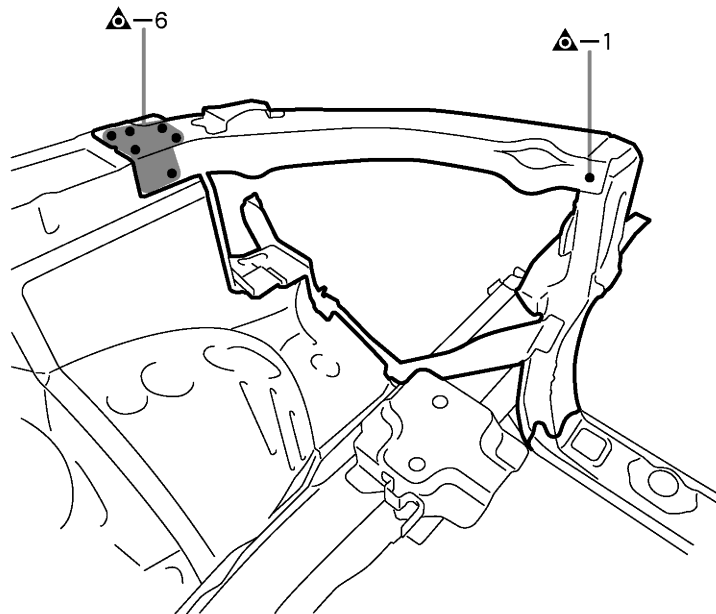
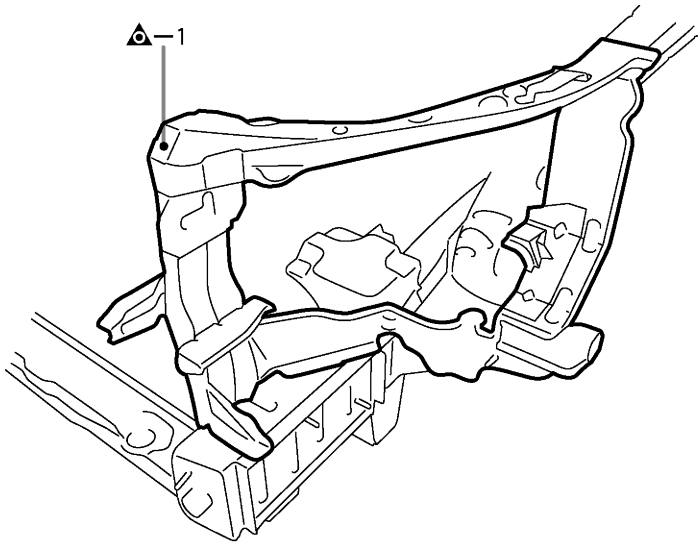


RADIATOR UPPER SUPPORT (ASSY)**REPLACEMENT**

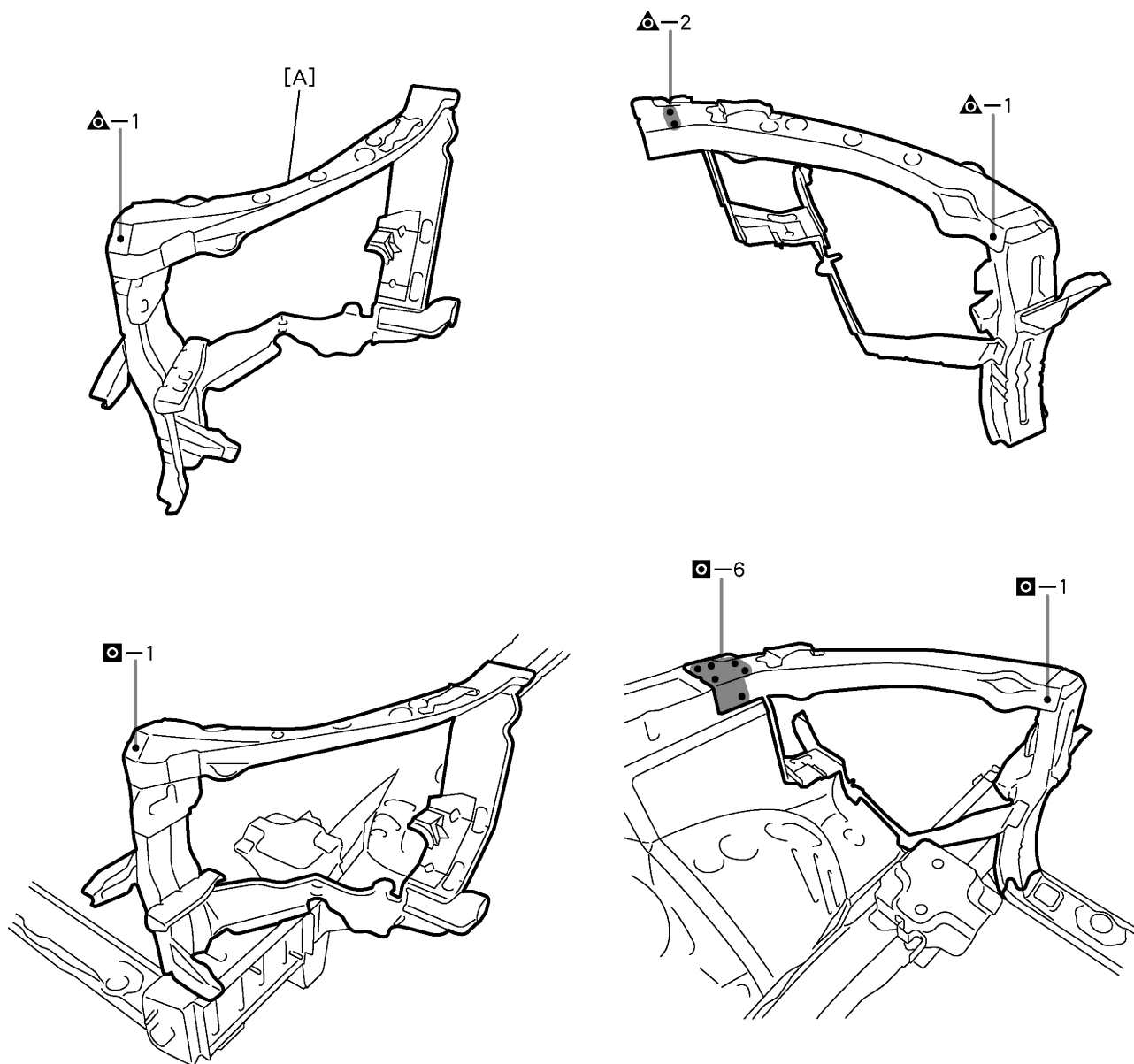
F14821-A

REMOVAL

F20651

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.



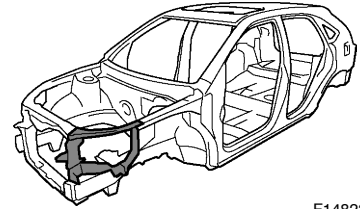
F20652

POINT

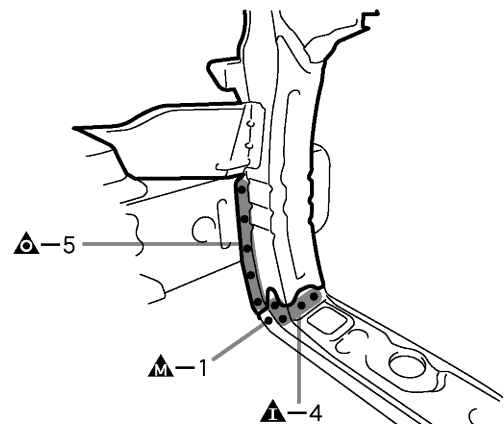
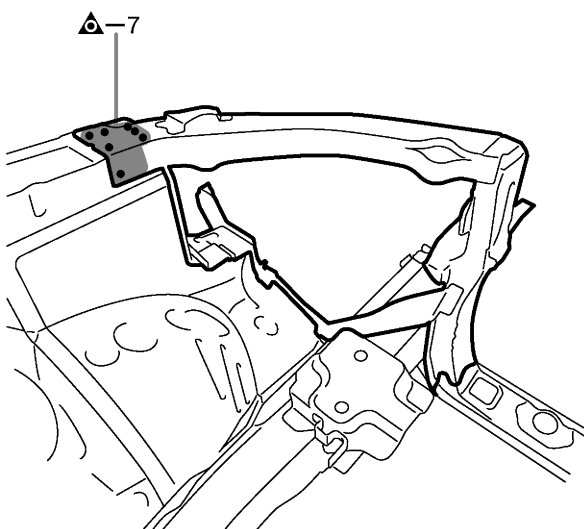
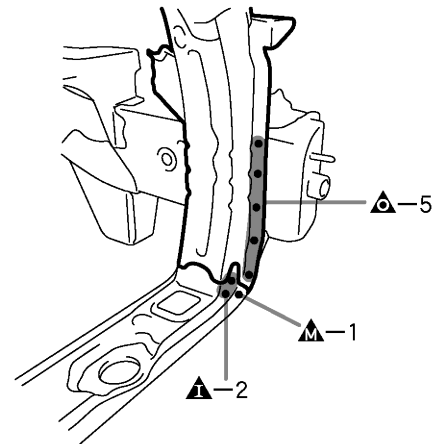
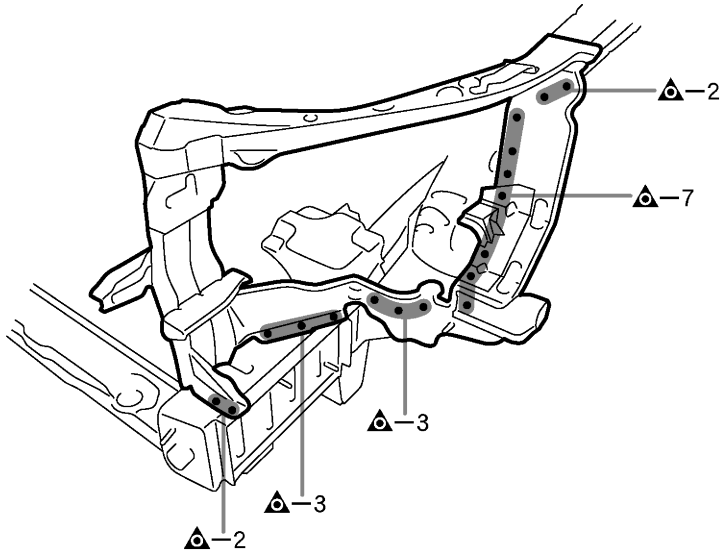
- 1 Remove the [A] from the new parts.
- 2 Inspect the fitting of the front fender and hood, etc., before welding, since this affects the appearance of the finish.

PART NAME

[A] Radiator Upper Support

RADIATOR SIDE SUPPORT (ASSY)**REPLACEMENT**

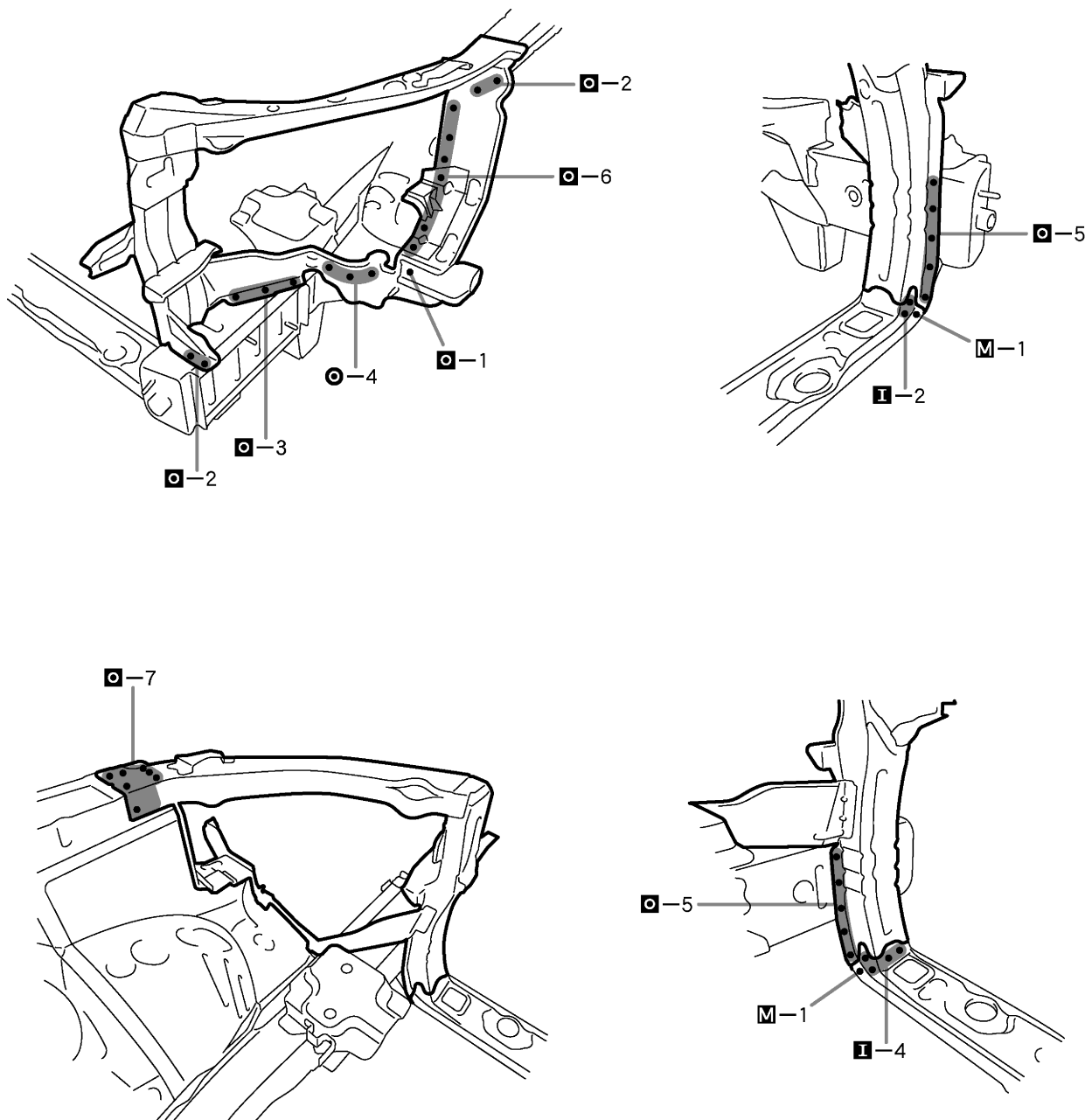
F14823-A

REMOVAL

F20653

INSTALLATION

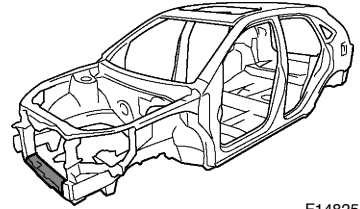
- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply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



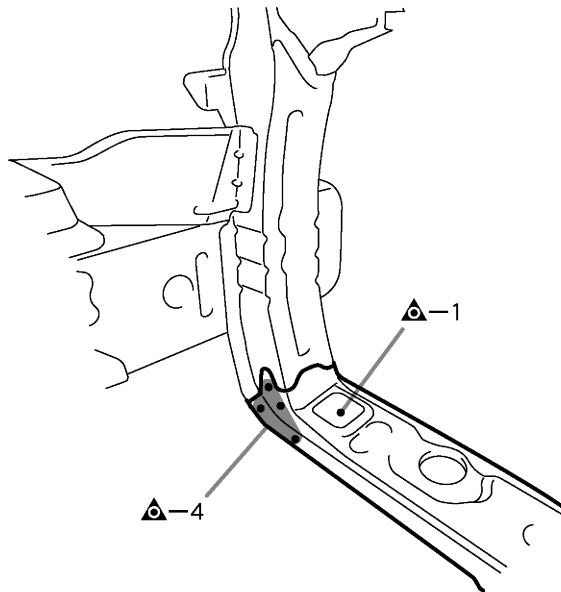
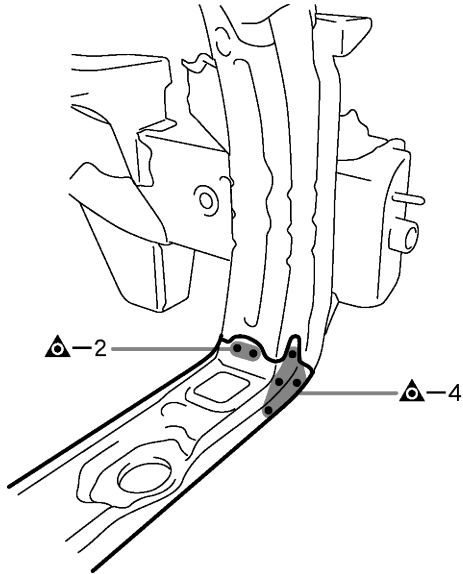
F20654

POINT

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

FRONT CROSSMEMBER (ASSY)**REPLACEMENT**

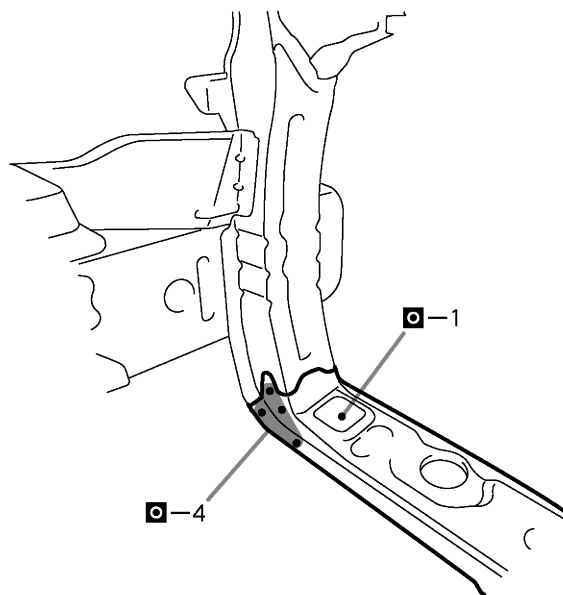
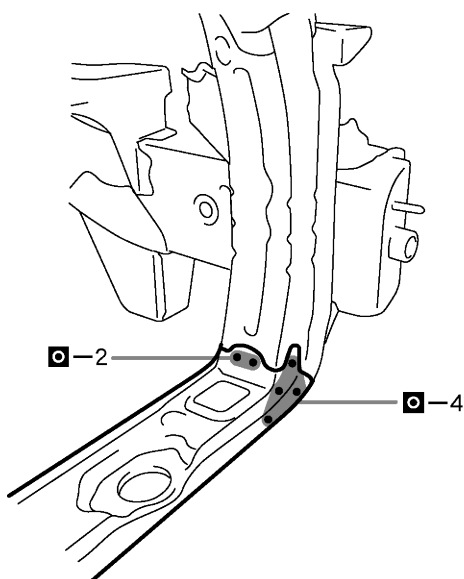
F14825-A

REMOVAL

F14825

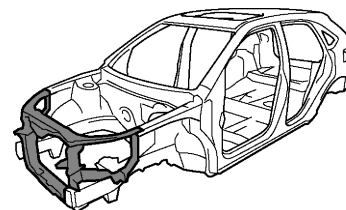
INSTALLATION

- 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.



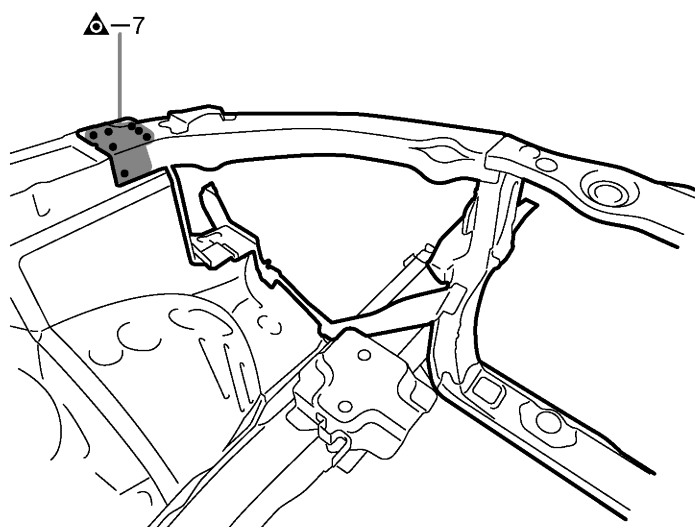
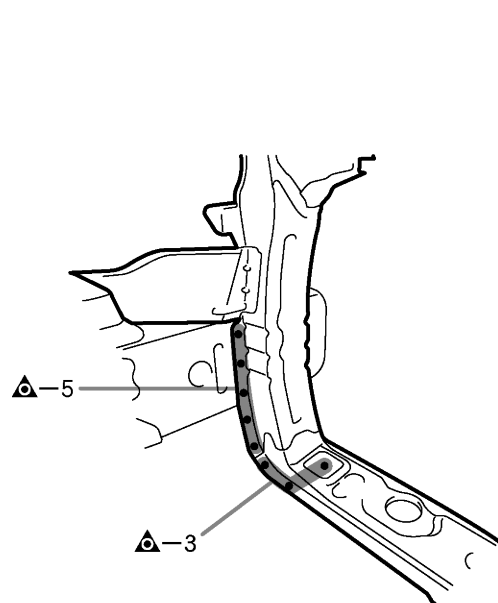
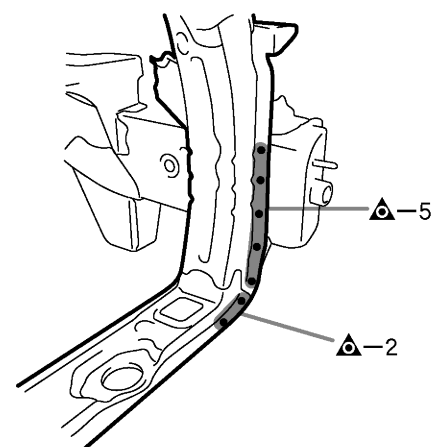
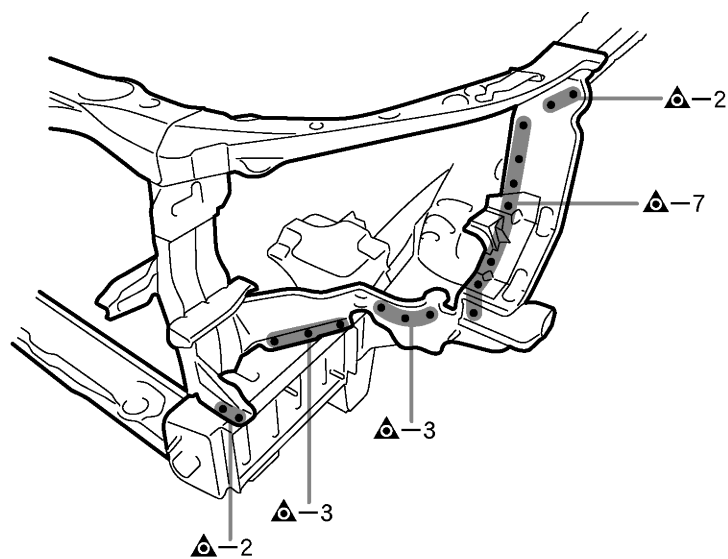
RADIATOR SUPPORT (ASSY)

REPLACEMENT



F14829-A

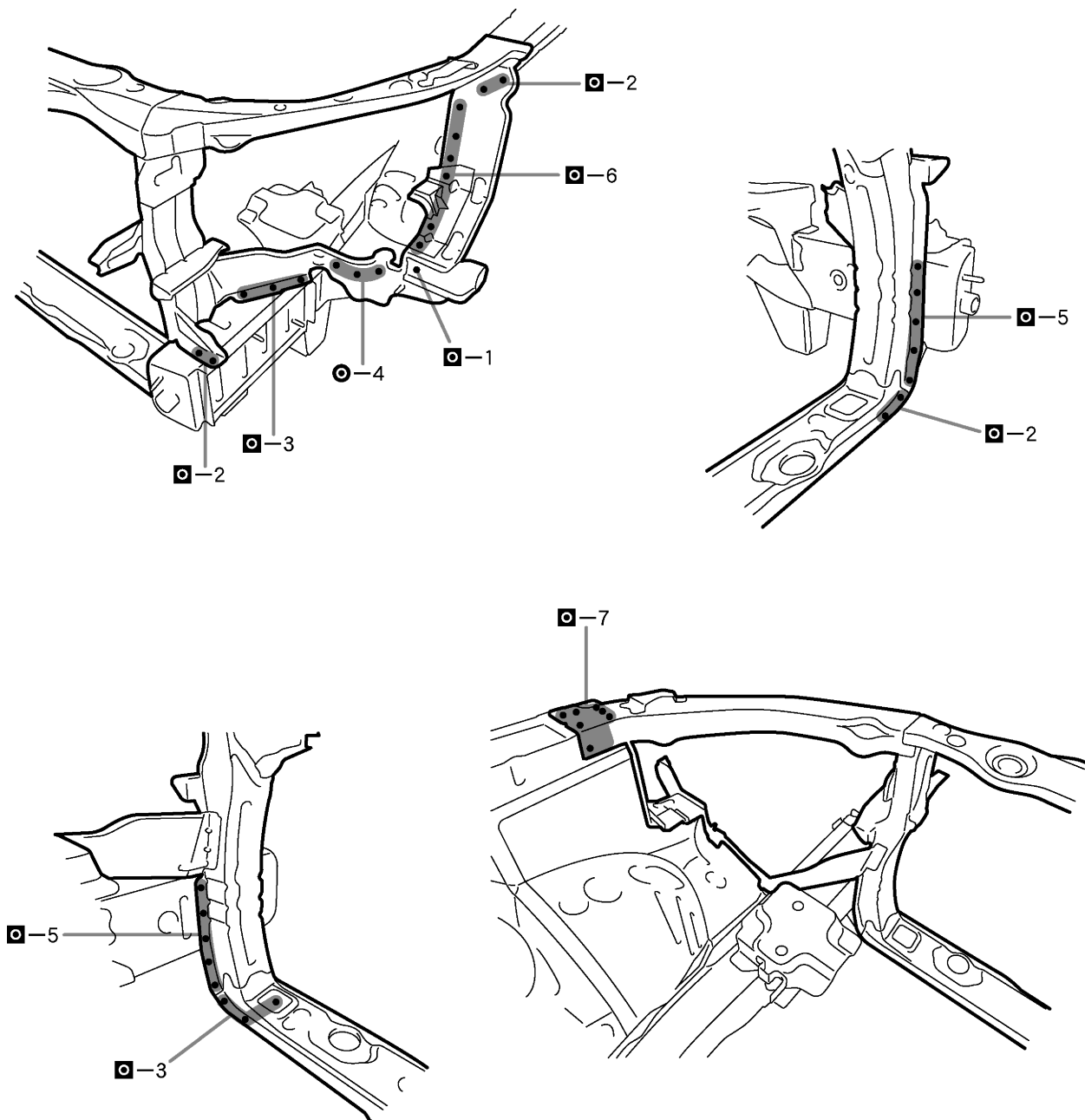
REMOVAL



F20655

INSTALLATION

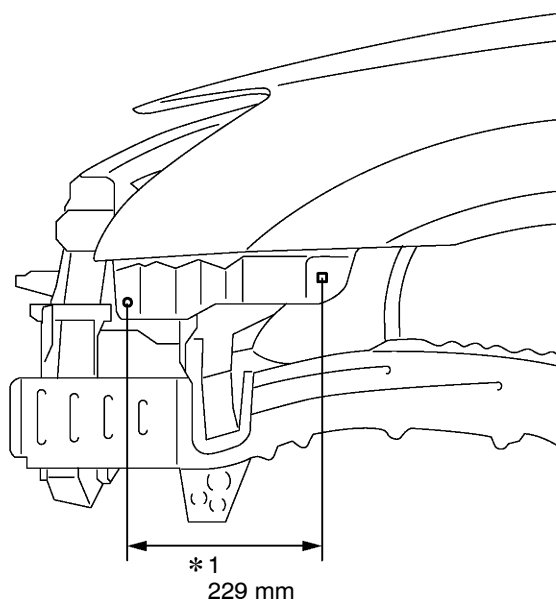
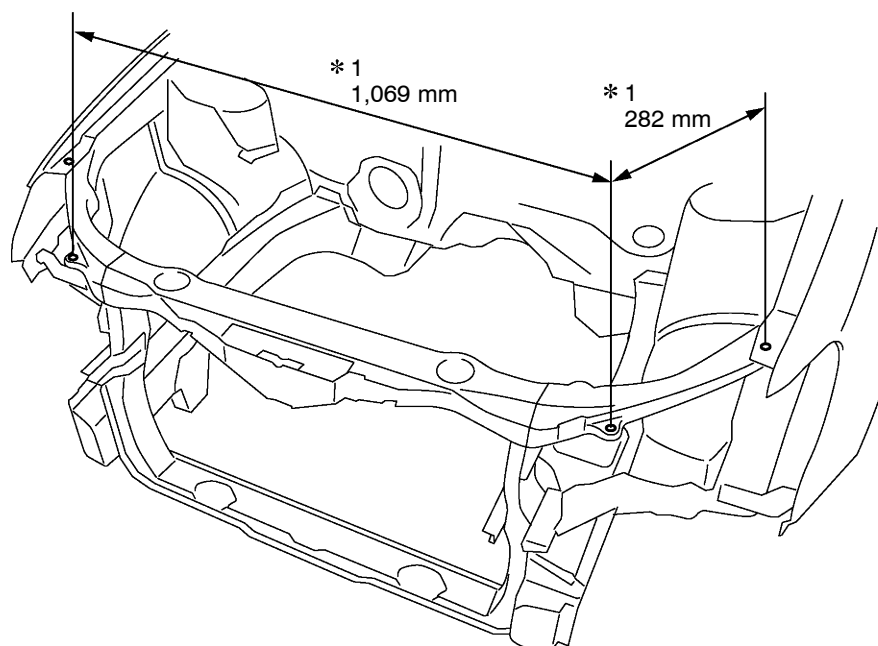
- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply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



F20656

POINT

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



F14831

POINT

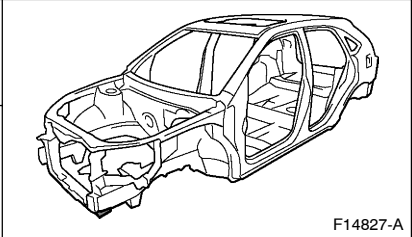
- 1 Measure the dimensions before installing the headlights.
- 2 *1: Reference value

229 mm (9.02 in.)

282 mm (11.10 in.)

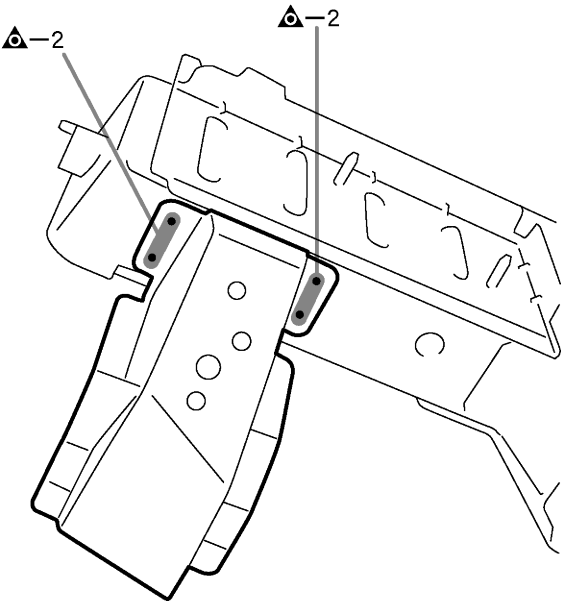
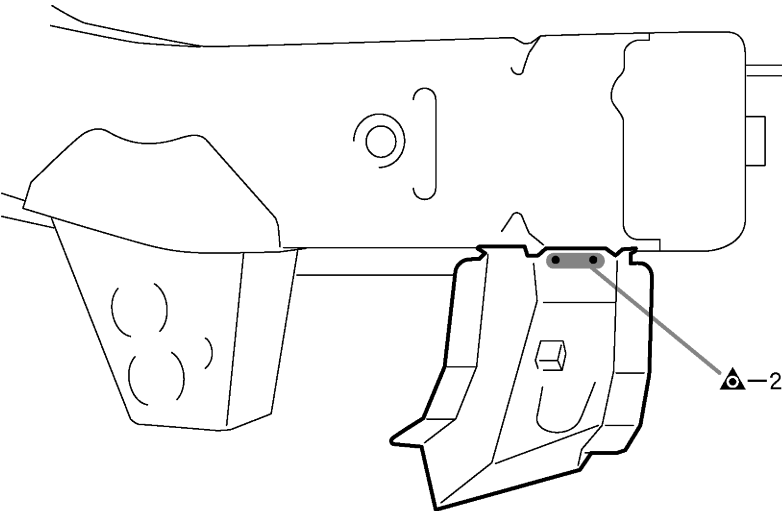
1,069 mm (42.09 in.)

**FRONT CROSSMEMBER NO.1
REINFORCEMENT (ASSY)**



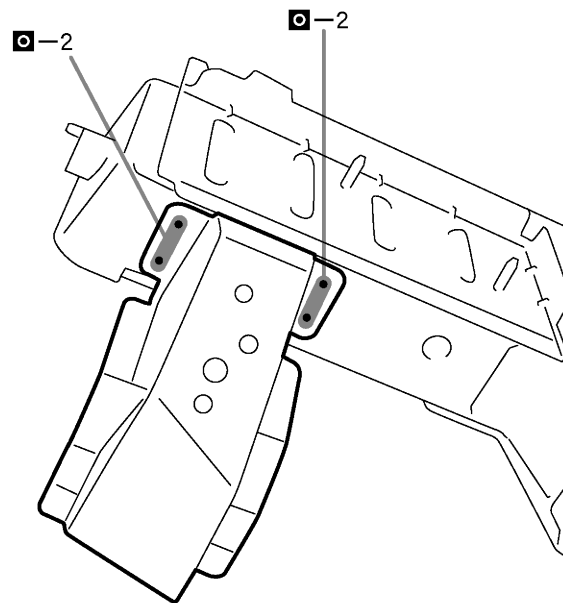
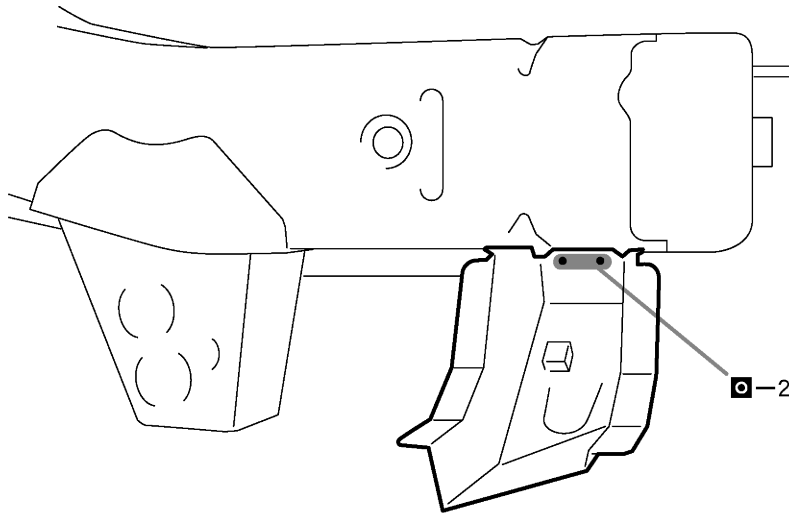
REPLACEMENT
With the radiator side support and front crossmember removed.

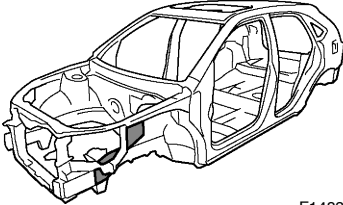
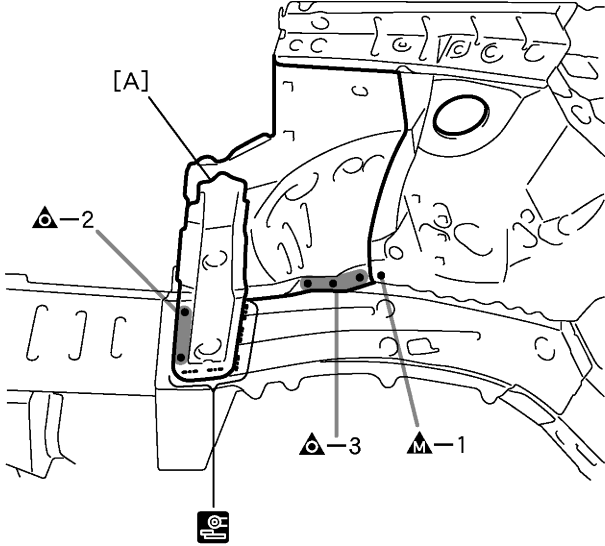
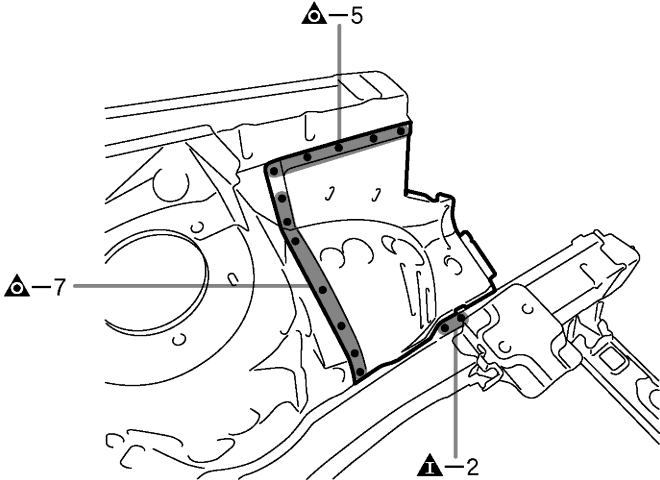
REMOVAL



INSTALLATION

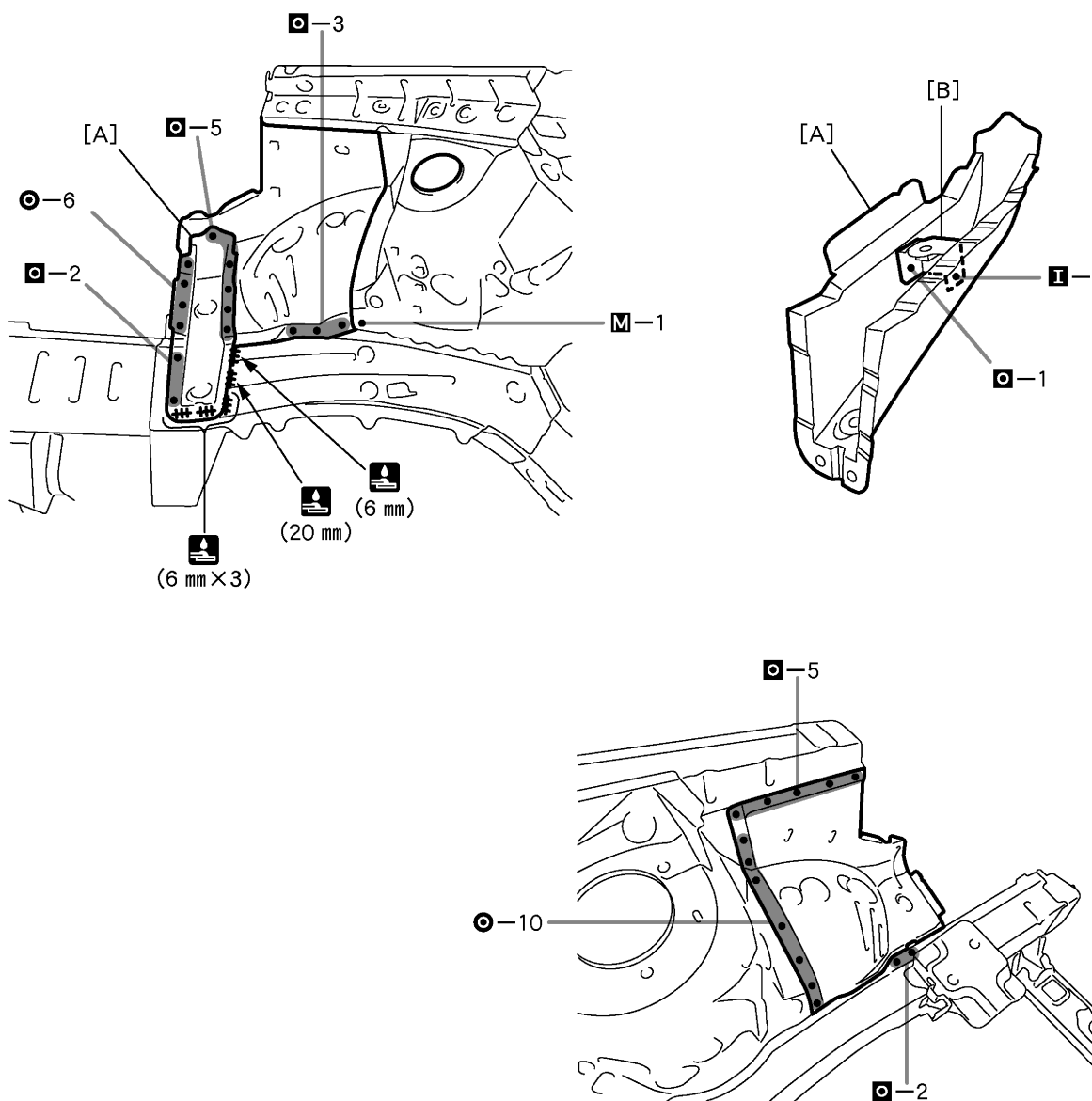
- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply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



FRONT FENDER FRONT APRON (ASSY) REPLACEMENT With the radiator side support removed.	 F14832-A
REMOVAL   F14832	
POINT 1 Remove the [A] at the same time. PART NAME [A] Front Fender Apron Wind Guide Gusset	

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.



F20657

PART NAME

[A] Front Fender Apron Wind Guide Gusset

[B] Front Fender Apron Front Reinforcement (RH Only)

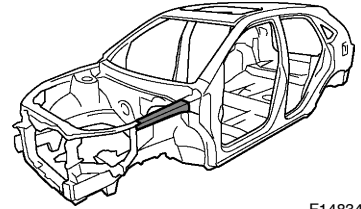
6 mm (0.24 in.)

20 mm (0.79 in.)

FRONT APRON TO COWL SIDE UPPER MEMBER (ASSY)

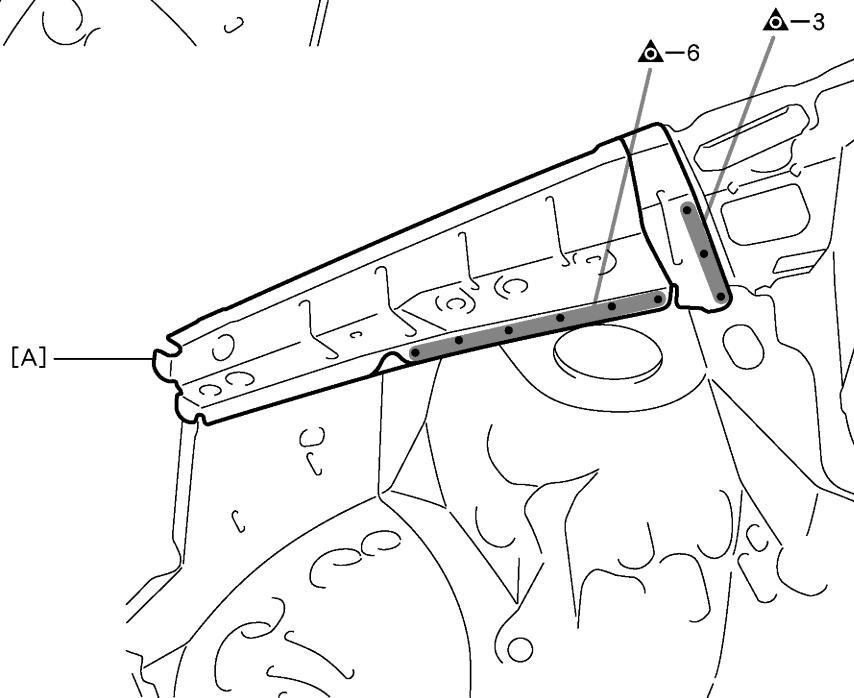
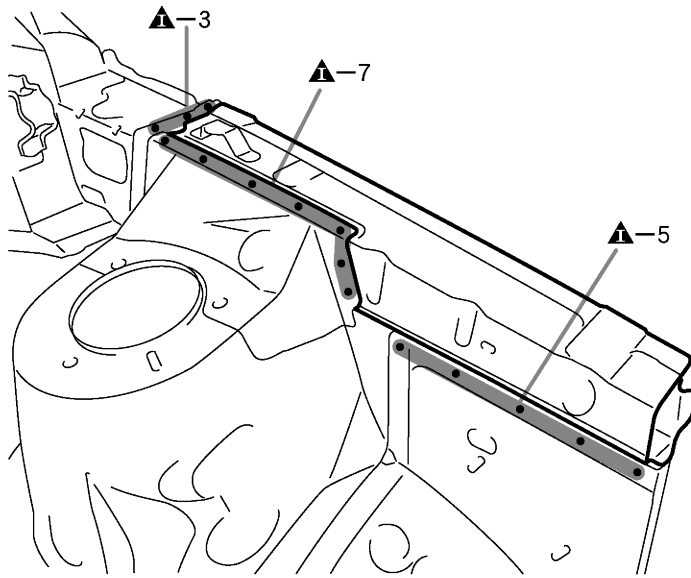
REPLACEMENT

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



F14834-A

REMOVAL



F14834

POINT

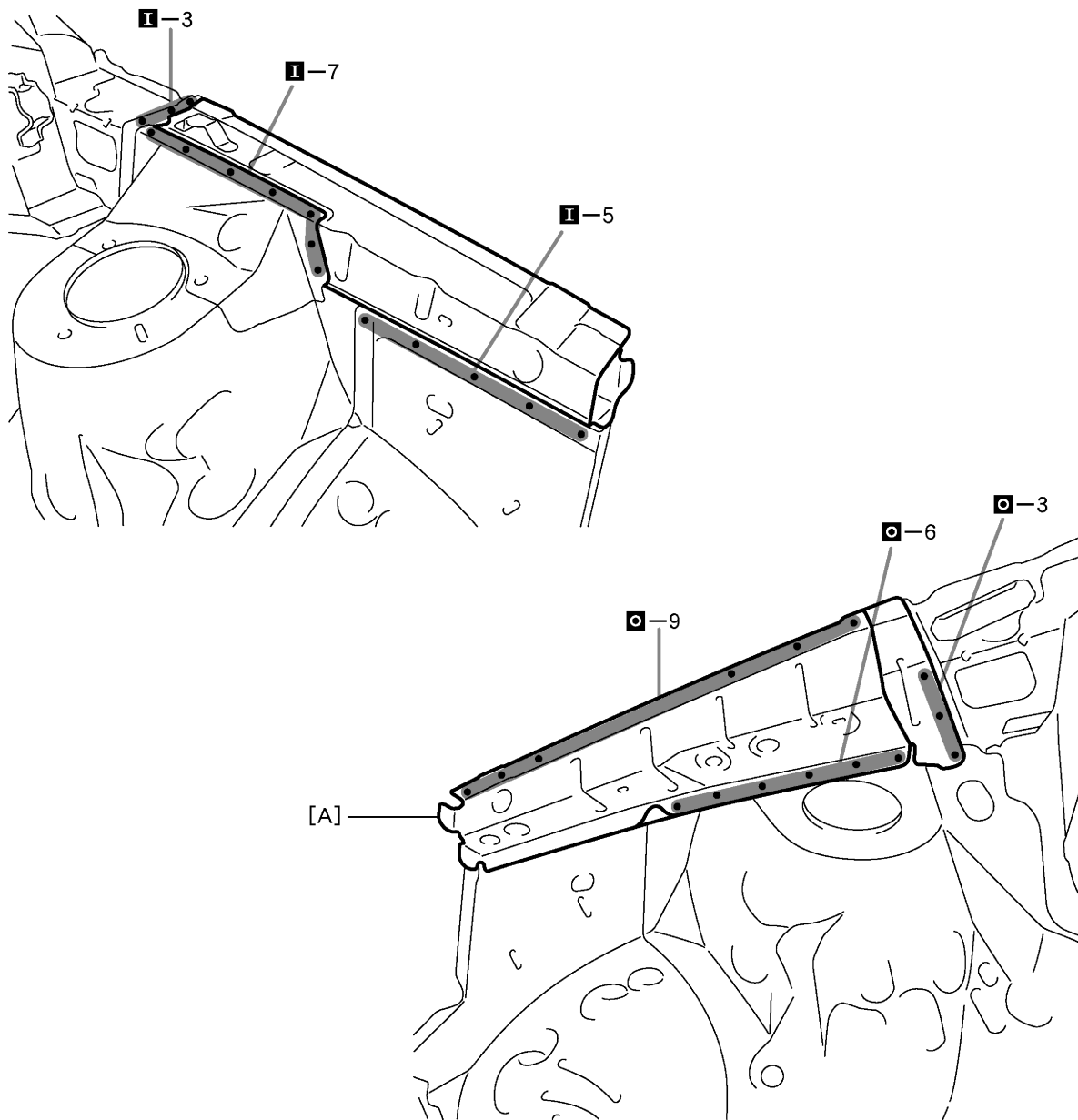
- 1 Remove the [A] at the same time.

PART NAME

[A] Front Apron To Cowl Side Lower Member

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.



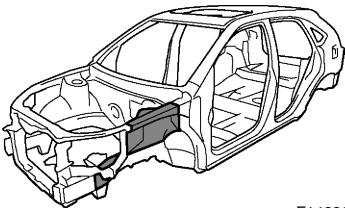
F14835

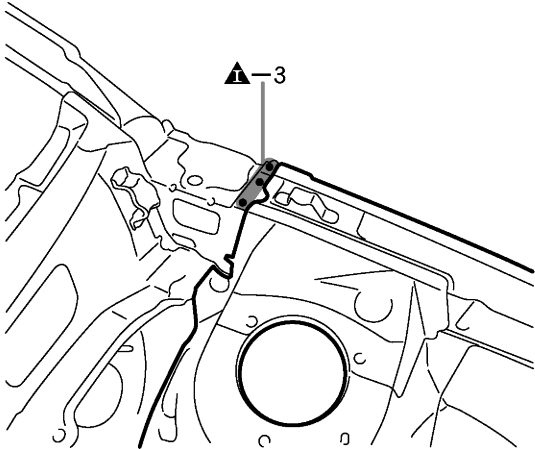
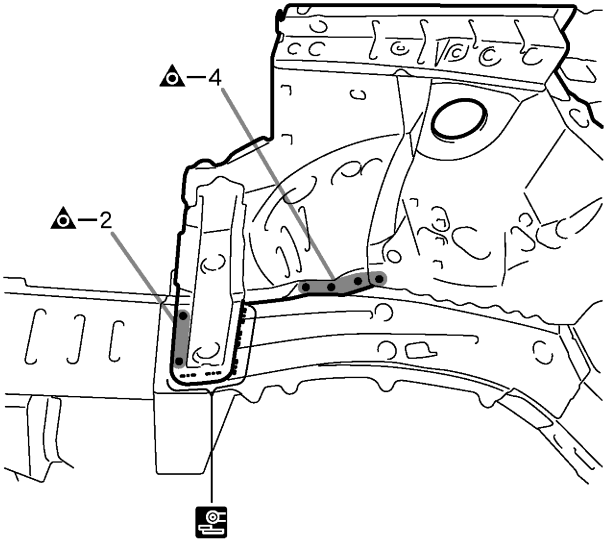
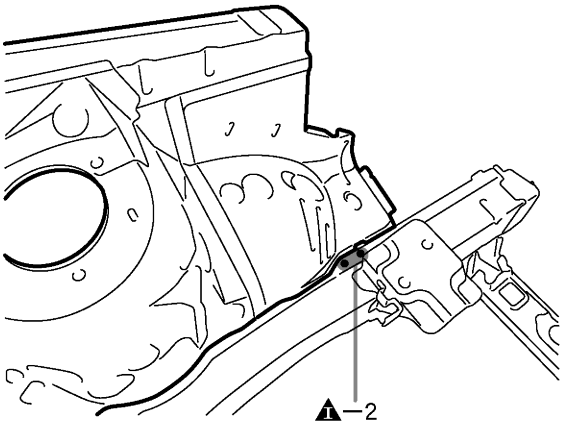
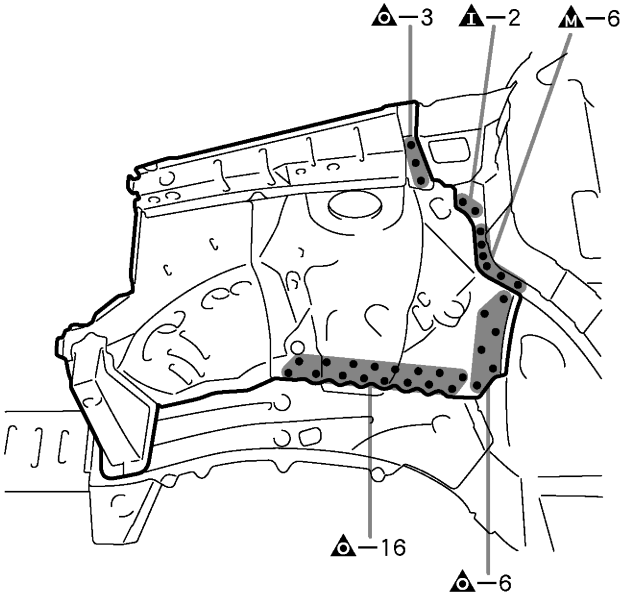
POINT

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

PART NAME

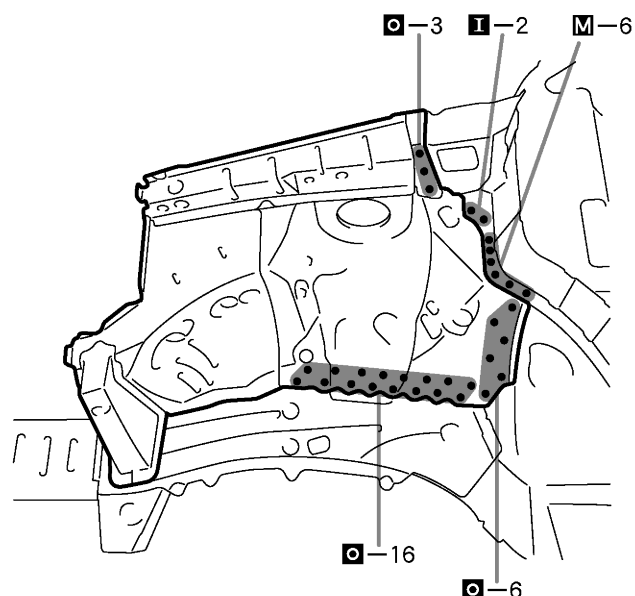
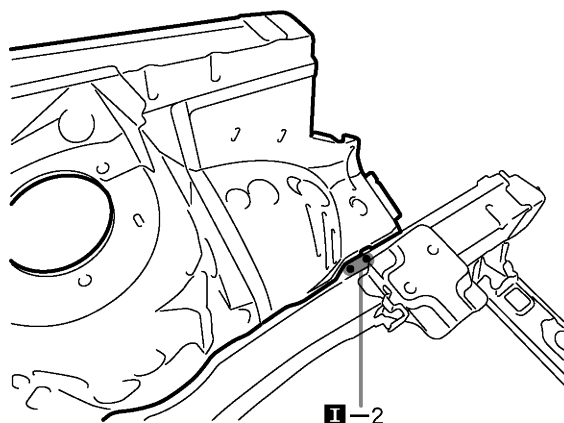
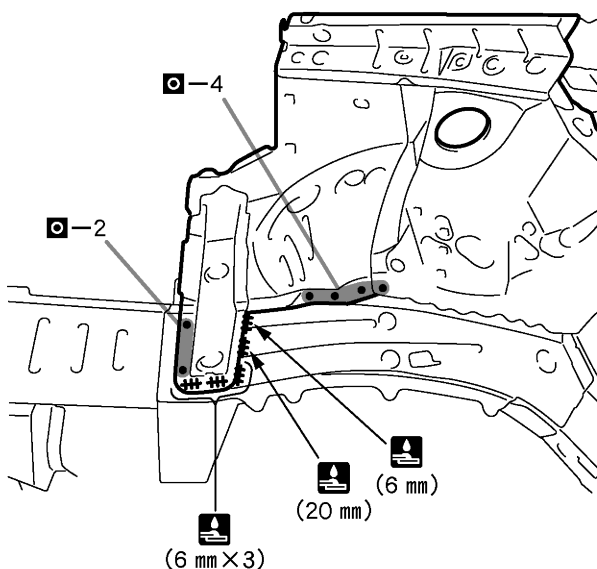
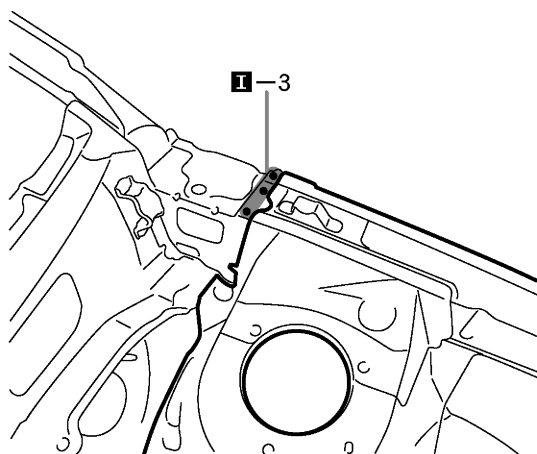
[A] Front Apron To Cowl Side Lower Member

FRONT FENDER APRON (ASSY) REPLACEMENT With the radiator side support and front body pillar lower gusset removed.	 F14836-A
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REMOVAL    

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.



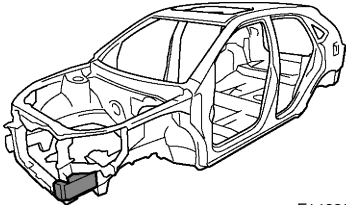
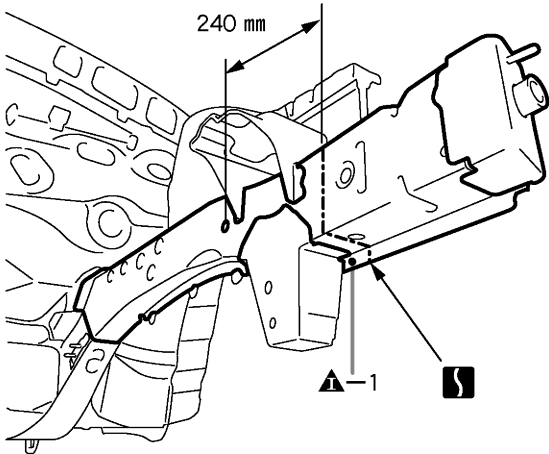
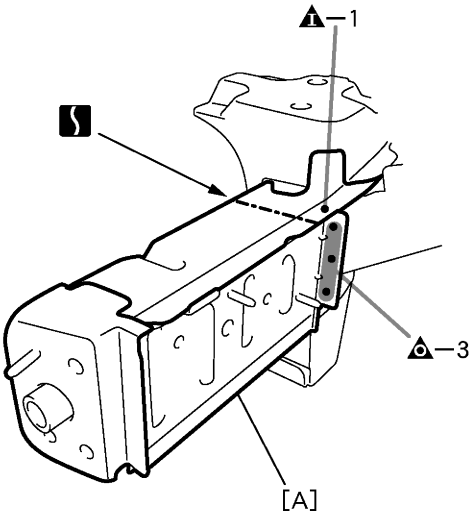
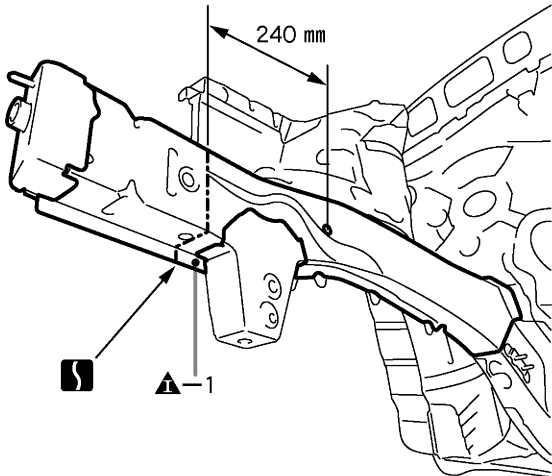
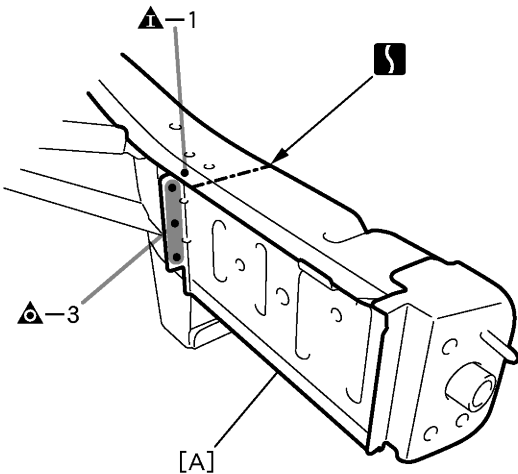
F20709

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.

6 mm (0.24 in.)

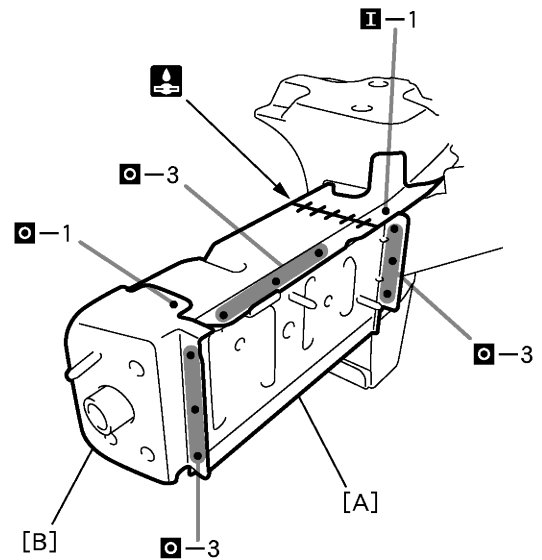
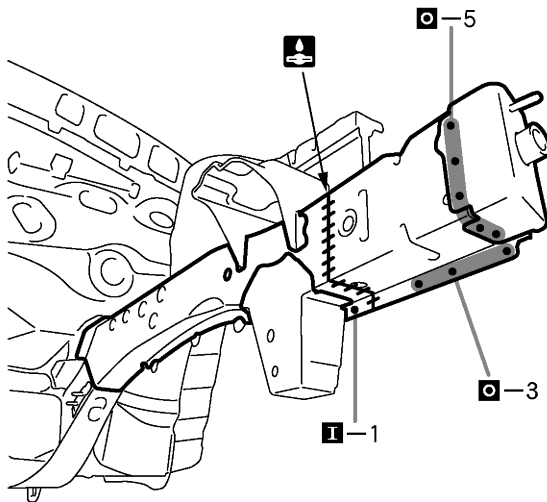
20 mm (0.79 in.)

FRONT SIDE MEMBER (CUT-P) REPLACEMENT With the front crossmember No.1 reinforcement removed.	 F14838-A
REMOVAL [LH]   [RH]   F14838	PART NAME [A] Front Side Member Extension 240 mm (9.45 in.)

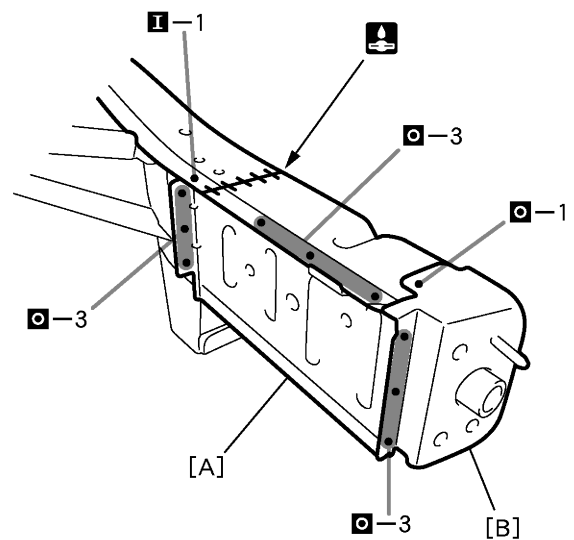
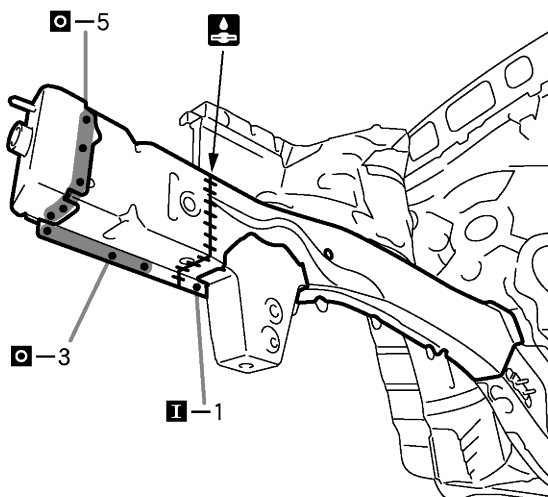
INSTALLATION

- 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.

[LH]



[RH]

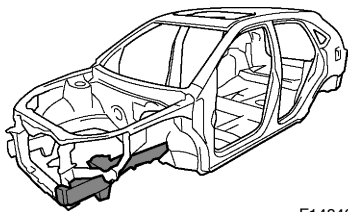


F14839

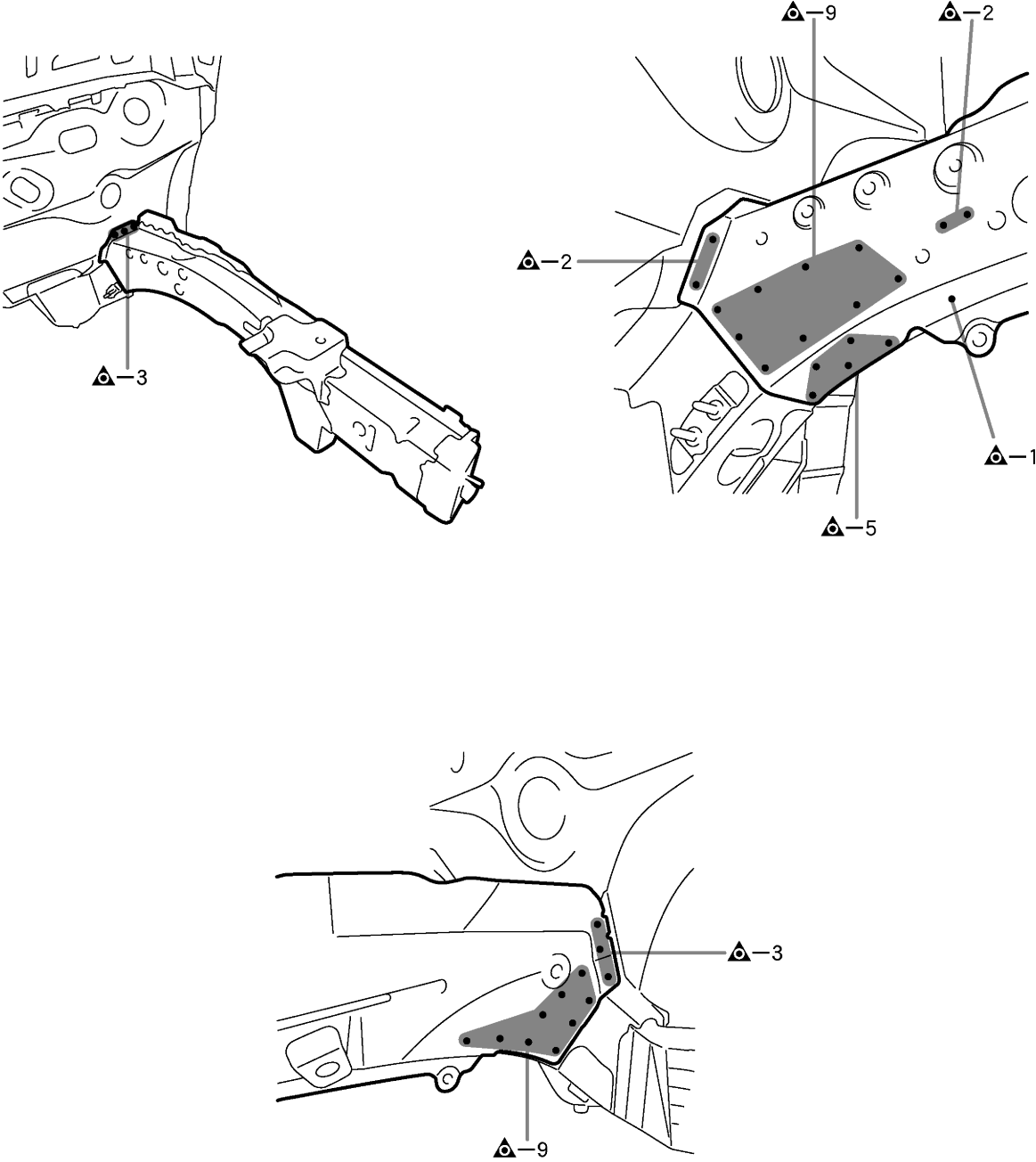
PART NAME

[A] Front Side Member Extension

[B] Body Mounting No.1 Bracket

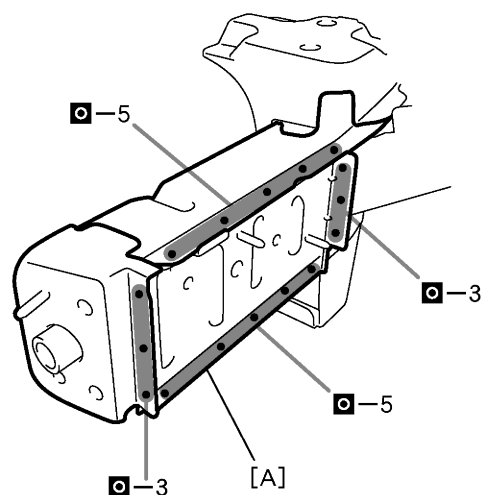
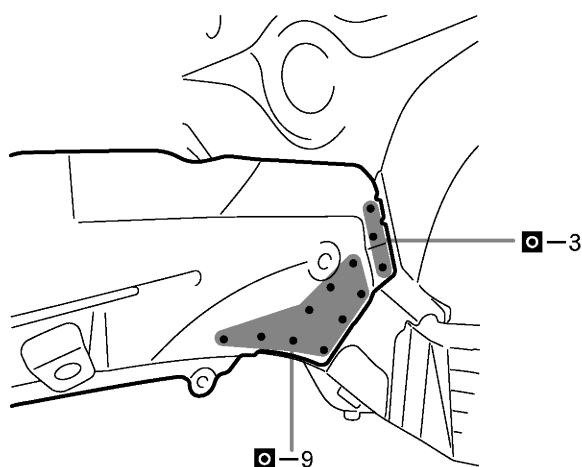
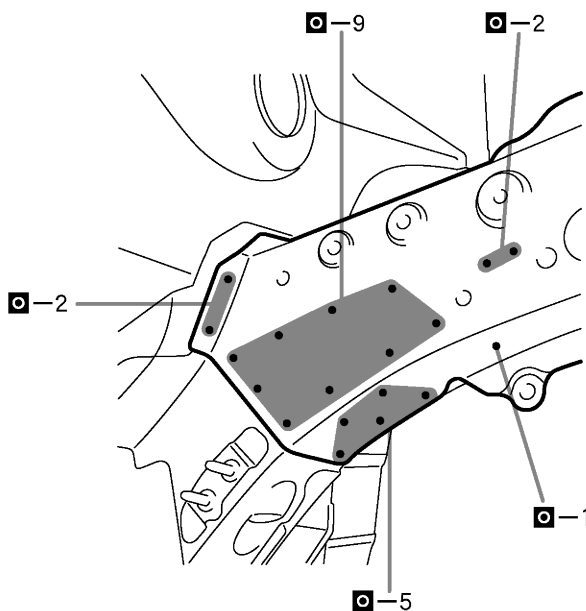
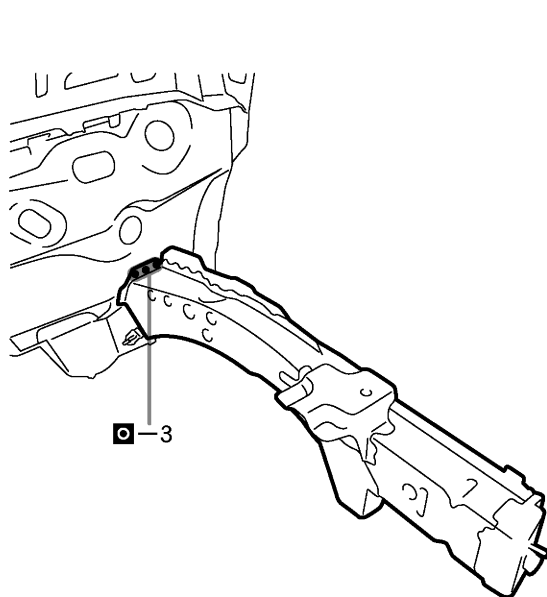
FRONT SIDE MEMBER (ASSY)	 F14840-A
REPLACEMENT With the front fender apron and front crossmember No.1 reinforcement removed.	

REMOVAL



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.



F14841

POINT

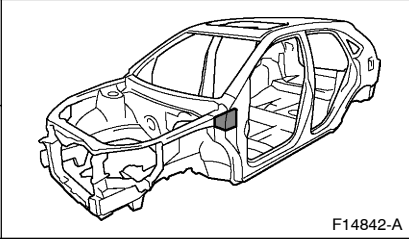
- 1 Make sure each measurement is correct, as this parts affects the front wheel alignment.

PART NAME

[A] Front Side Member Extension

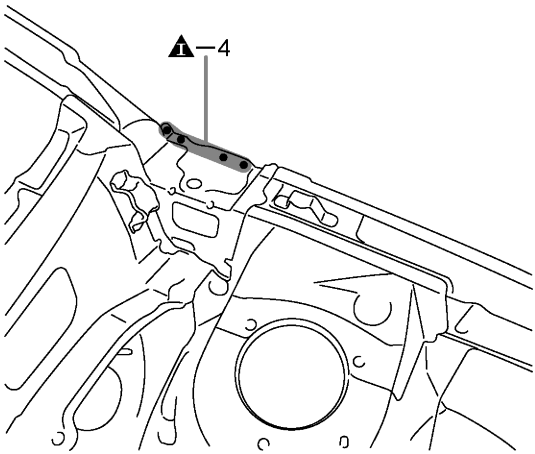
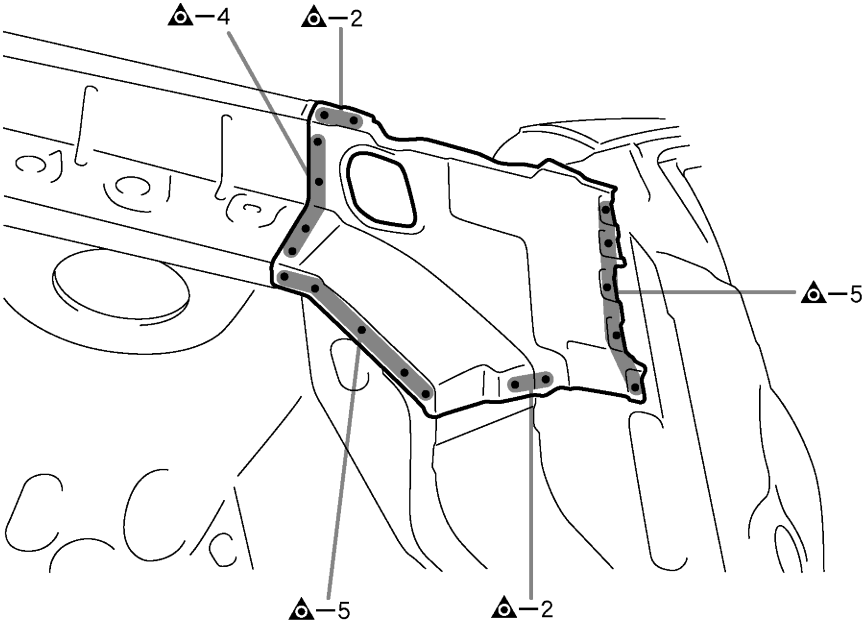
FRONT BODY PILLAR LOWER GUSSET (ASSY)

REPLACEMENT



F14842-A

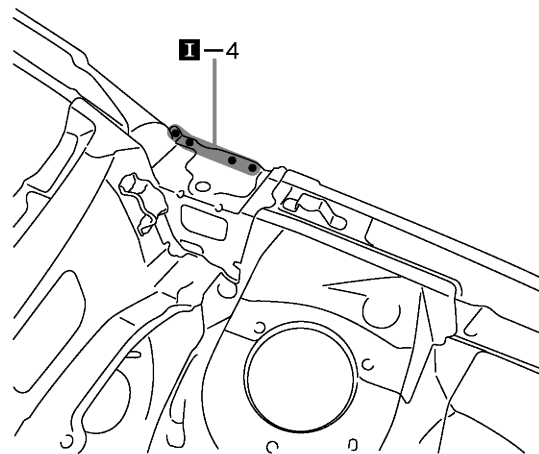
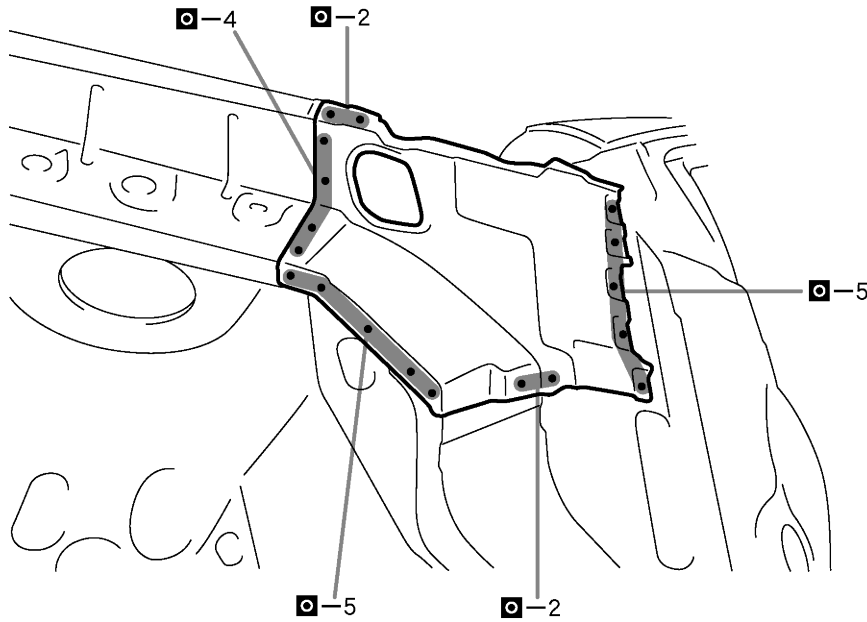
REMOVAL



F14842

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.



FRONT BODY PILLAR (CUT)

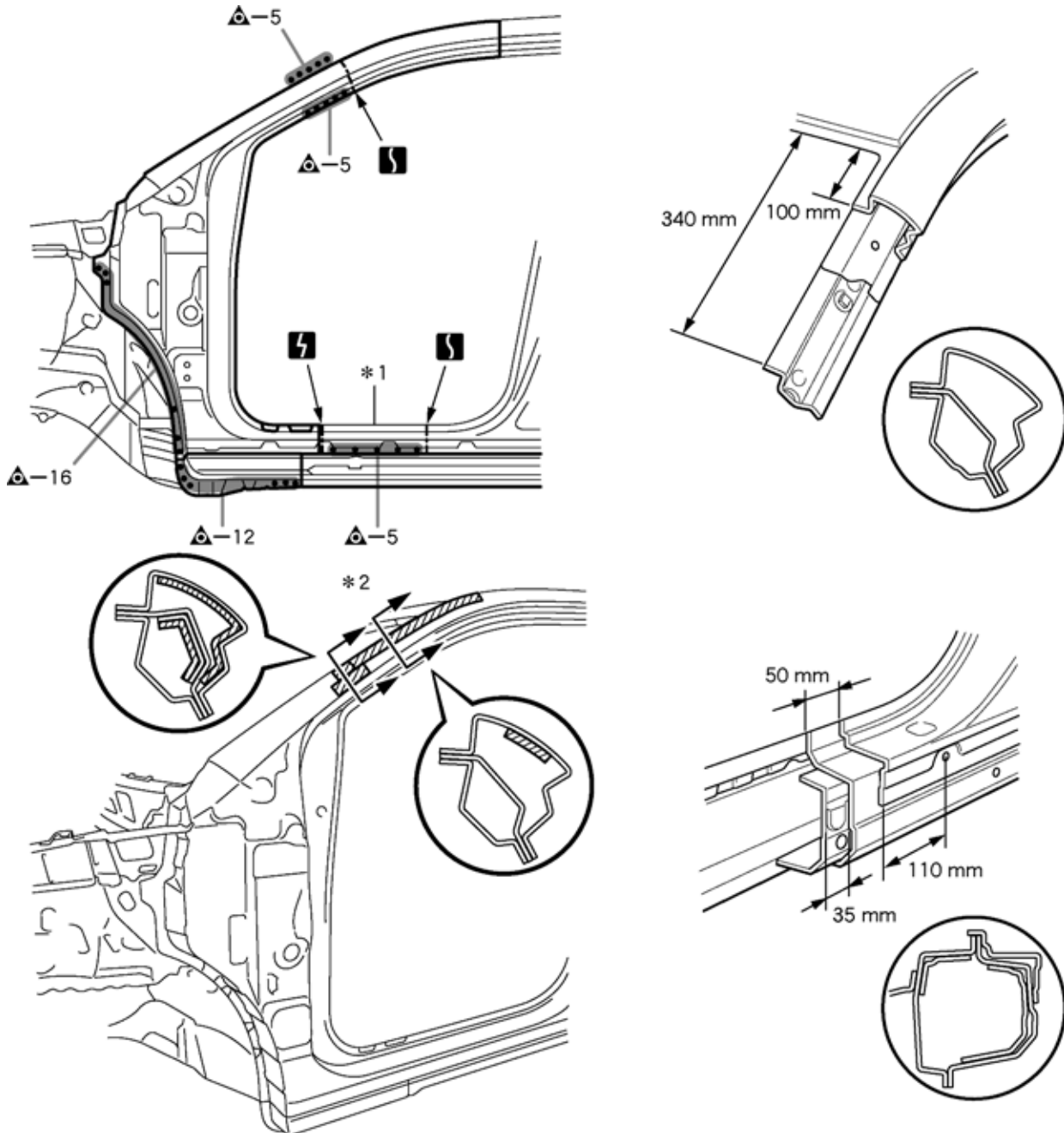
REPLACEMENT

With the front pillar lower gusset removed.



F14844-A

REMOVAL

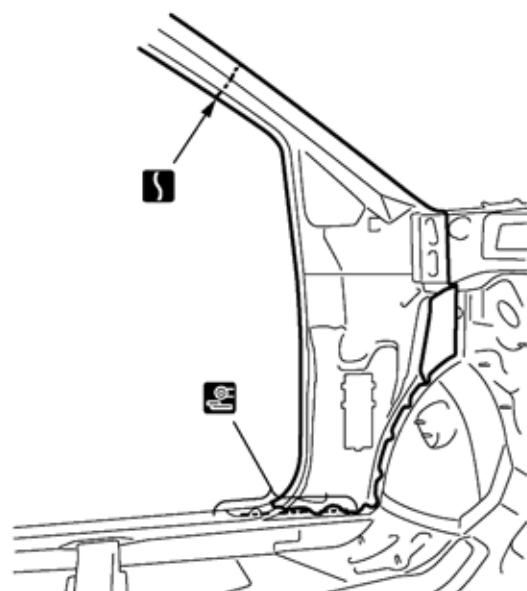
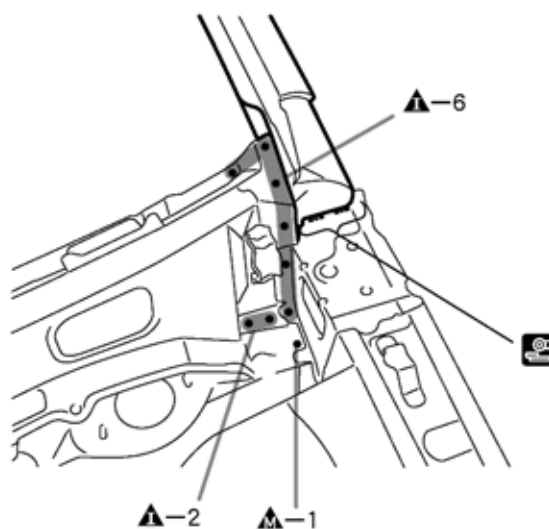
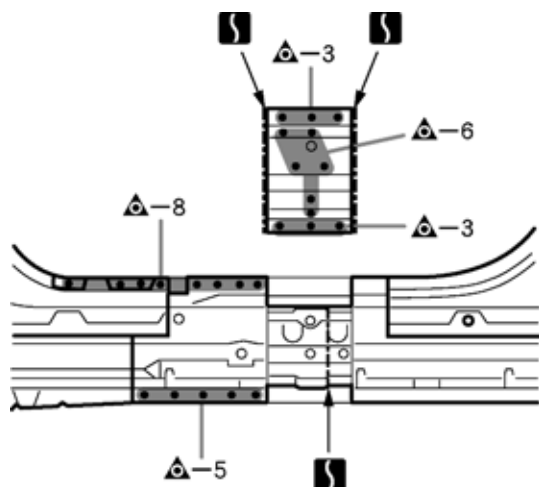


F20667

POINT

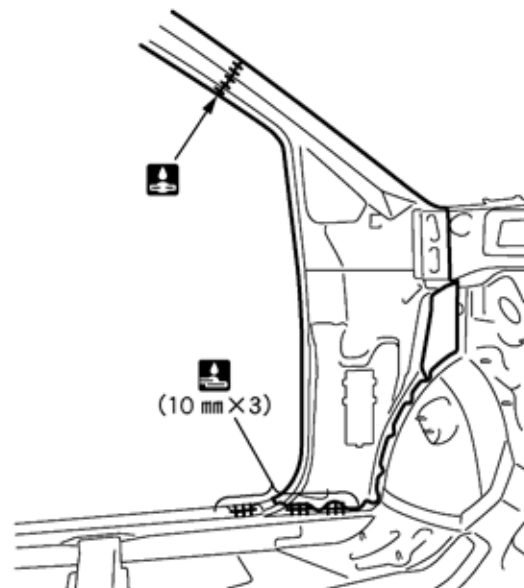
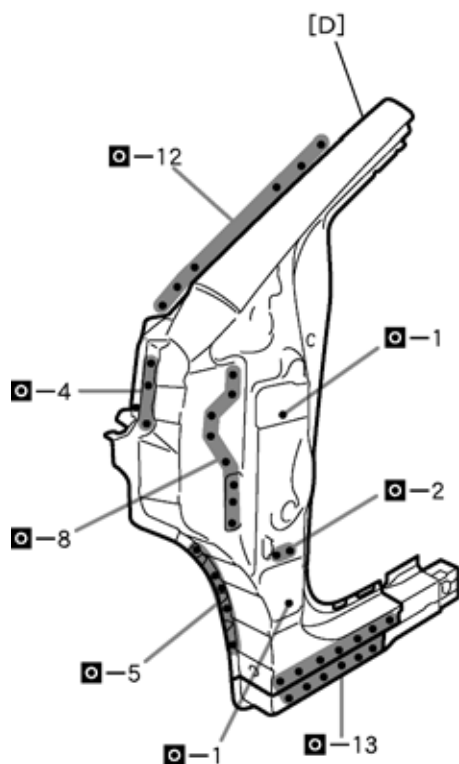
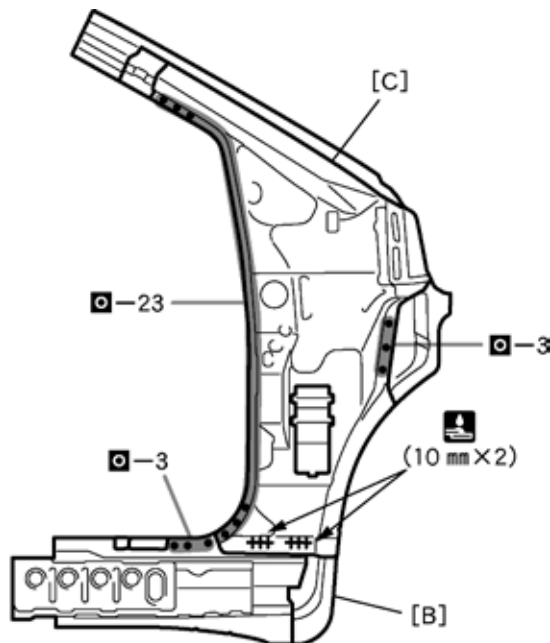
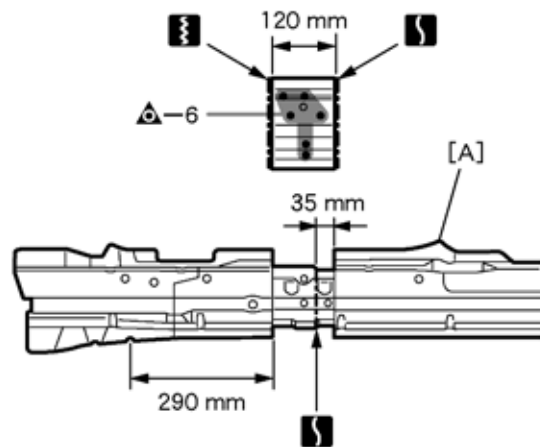
- 1 *1: This part of the outer panel is reused, because the rocker panel section is cut off at the rear position behind the supplied parts cut position of the outer panel.
- 2 *2: When cutting the front body pillar, be careful not to cut the pad.

35 mm (1.38 in.) 50 mm (1.97 in.) 100 mm (3.94 in.) 110 mm (4.33 in.) 340 mm (13.39 in.)



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.



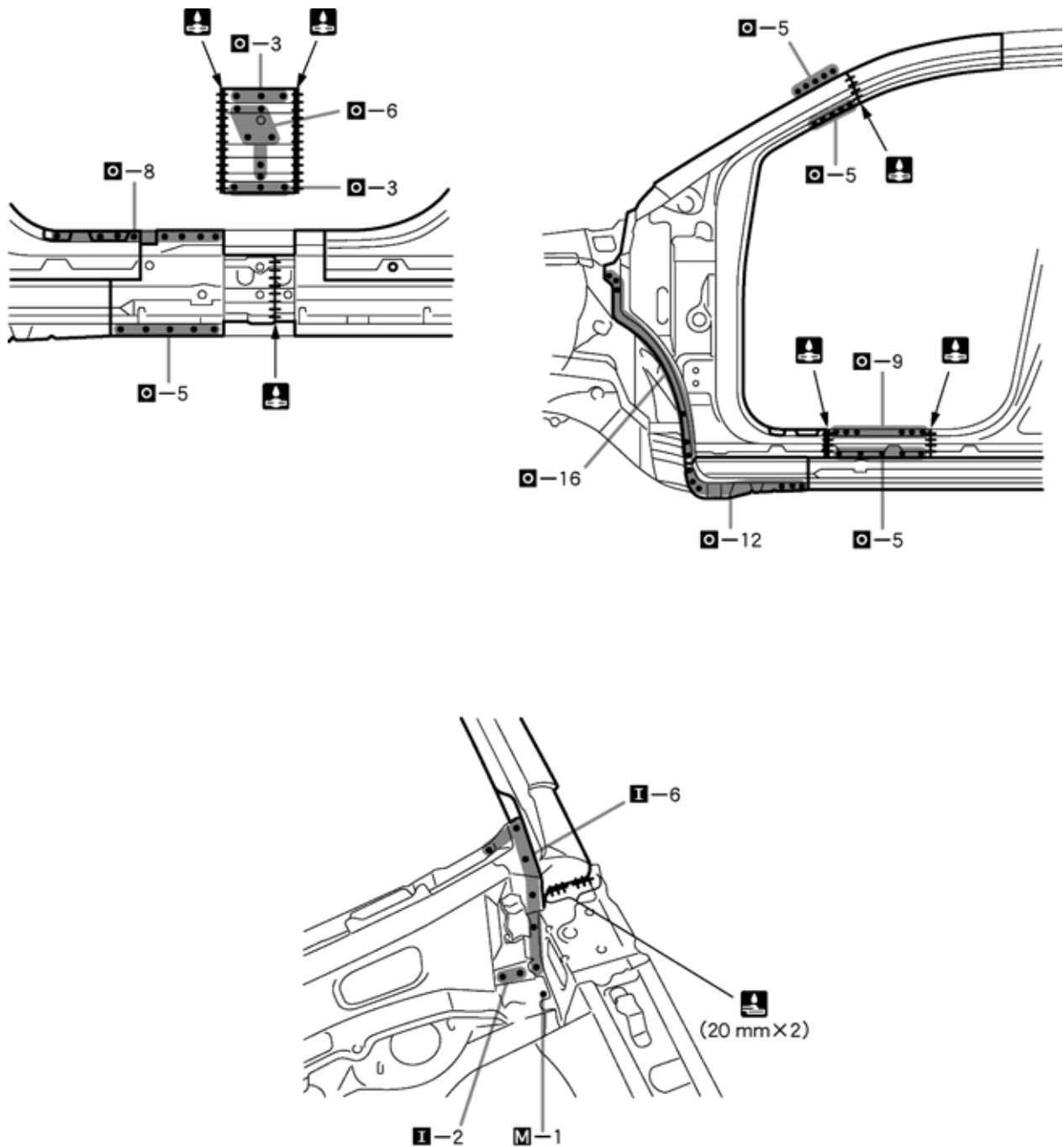
F20658

POINT

1 Before temporarily installing the new parts, weld the [A], [B], [C] and [D] with standard points.

PART NAME

[A] Rocker Outer Panel	[B] Front Pillar Lower Reinforcement	[C] Front Body Inner Pillar
[D] Outer Panel		
10 mm (0.39 in.)	35 mm (1.83 in.)	120 mm (4.72 in.)
		290 mm (11.42 in.)



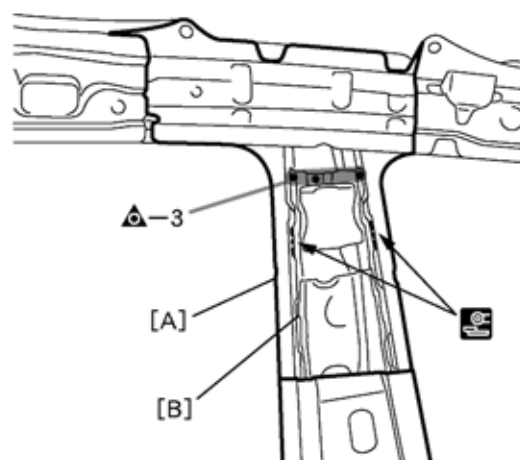
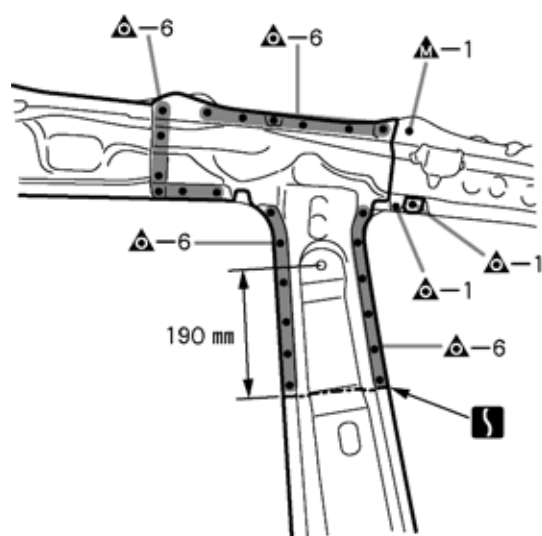
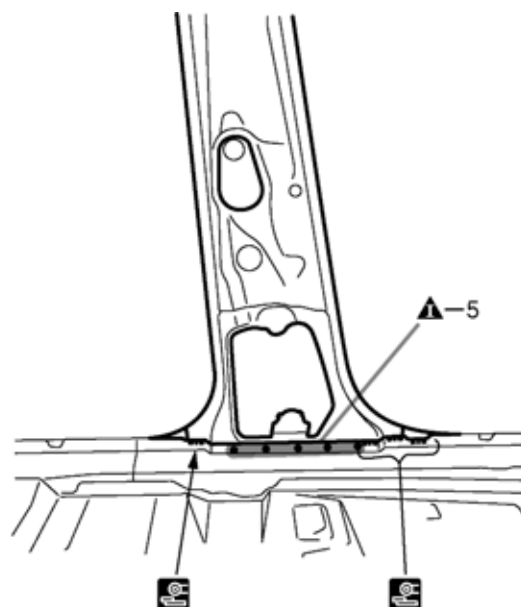
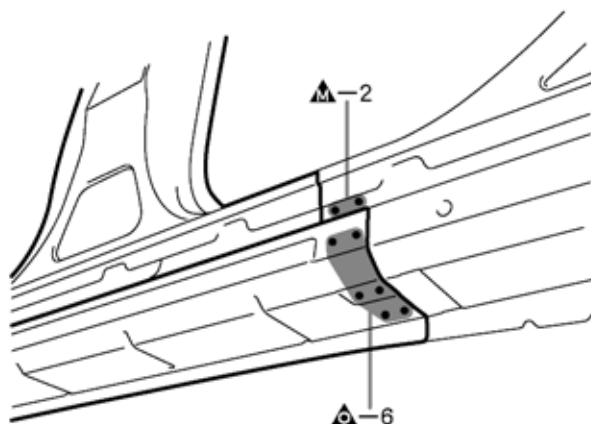
F20669

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.

20 mm (0.79 in.)

85 mm (3.35 in.) 120 mm (4.72 in.) 140 mm (5.51 in.) 150 mm (5.91 in.) 690 mm (27.17 in.)



F14849

POINT

1 Separate [A] and [B] at the weld part, at then remove the center body pillar.

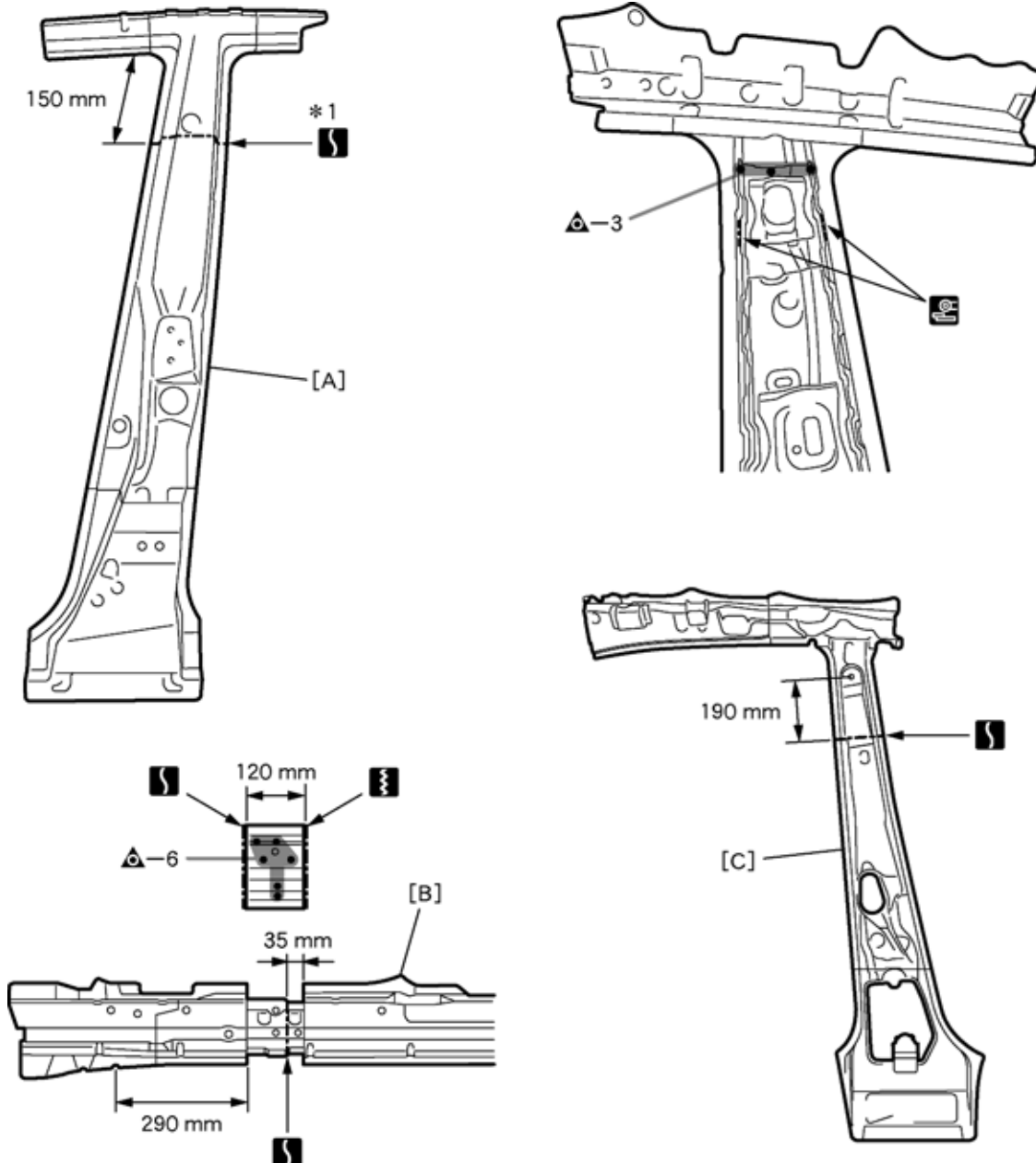
PART NAME

[A] Center Body Pillar Upper Reinforcement
190 mm (7.48 in.)

[B] Center Body Pillar Upper Hinge No.1 Reinforcement

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.



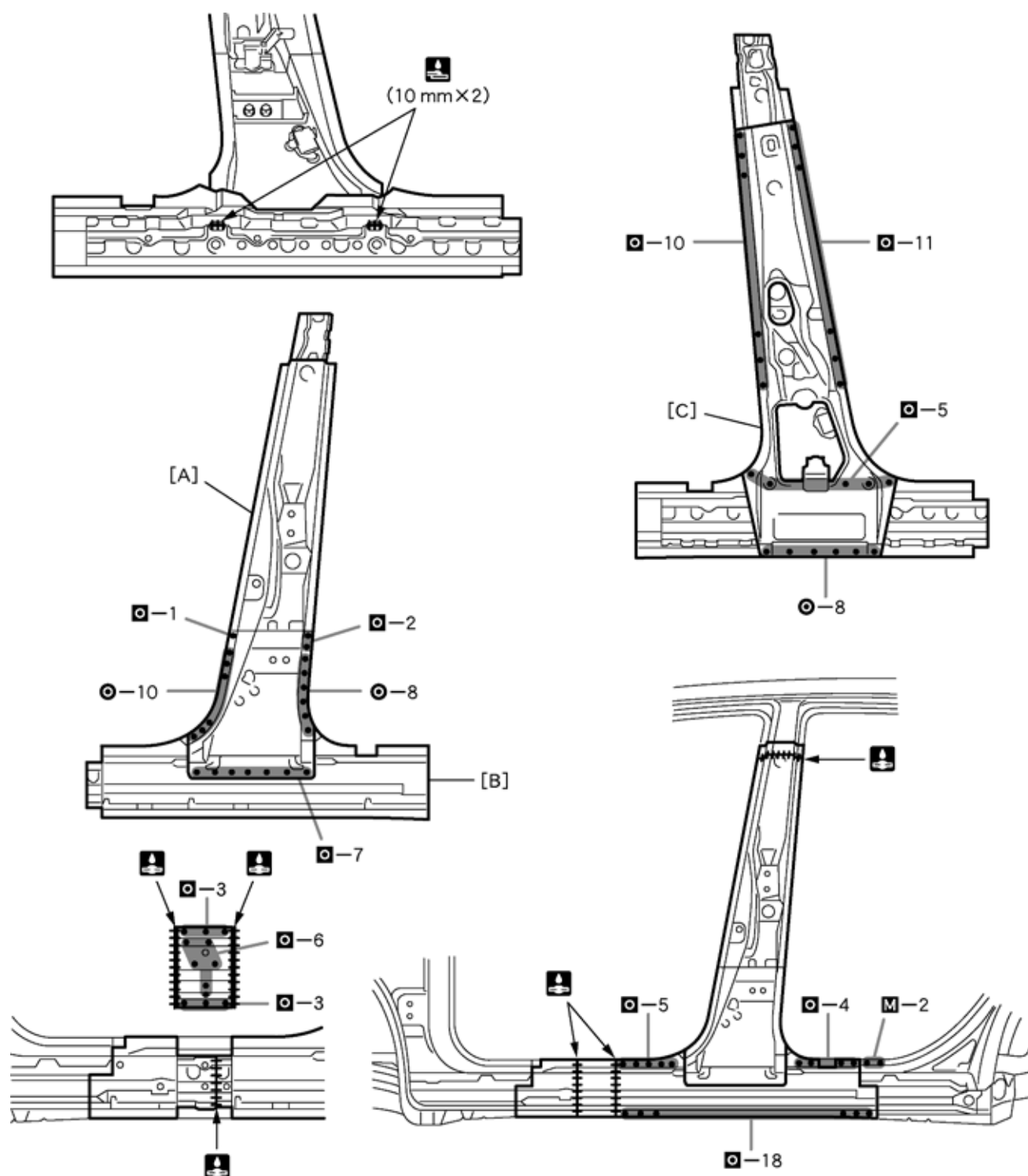
F20671

POINT

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

PART NAME

[A] Center Body Pillar Reinforcement	[B] Rocker Outer Panel	[C] Center Body Inner Pillar
35 mm (1.38 in.)	120 mm (4.72 in.)	150 mm (5.91 in.)
		190 mm (7.48 in.)
		290 mm (11.42 in.)



F20672

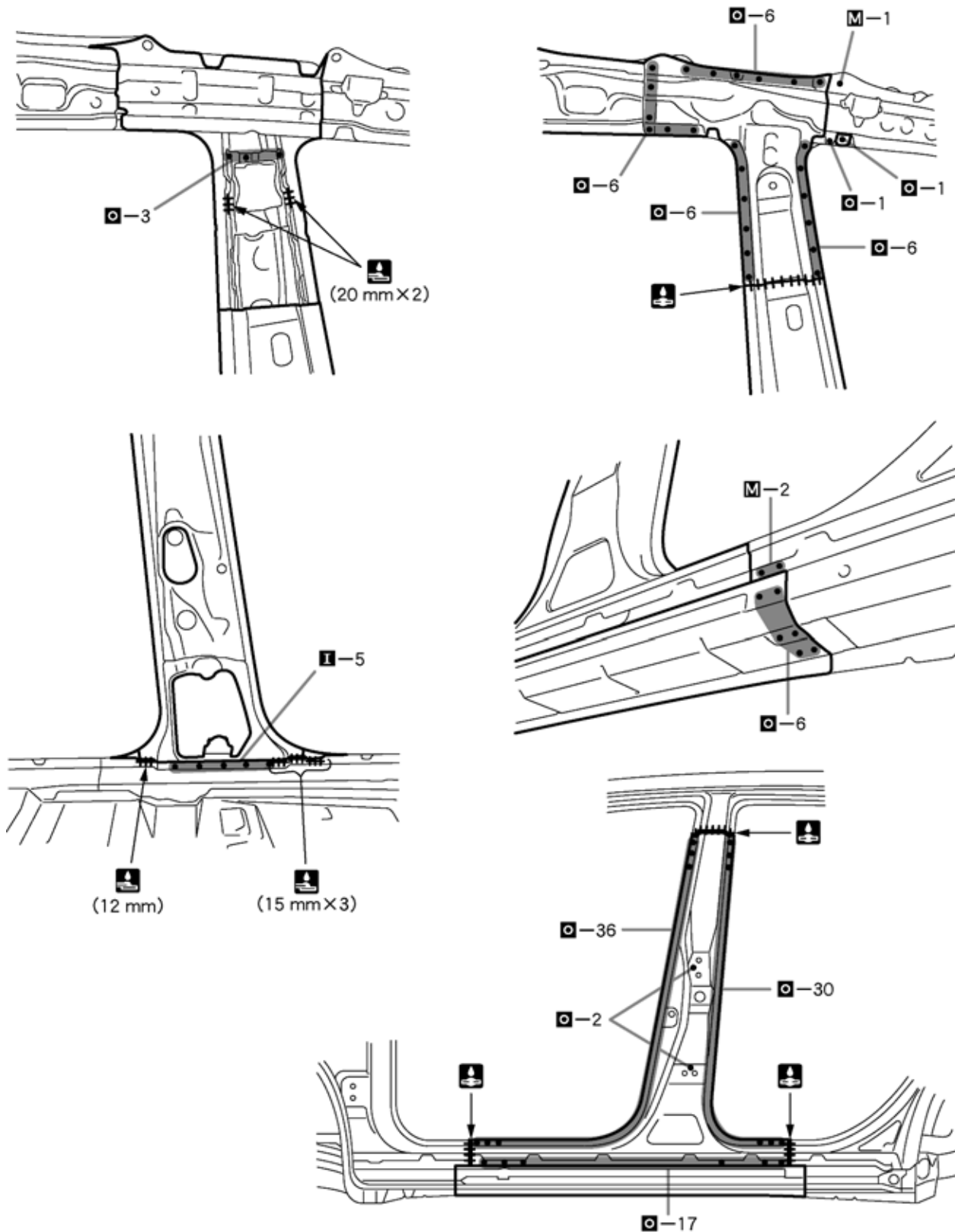
POINT

- 1 Before temporarily installing the new parts, weld the [A], [B] and [C] with the standard points.
- 2 Inspect the fitting of the front door and rear door, etc., before welding, since this affects the appearance of the finish.

PART NAME

[A] Center Body Pillar Reinforcement [B] Rocker Outer Panel [C] Center Body Inner Pillar

10 mm (0.39 in.)



F20673

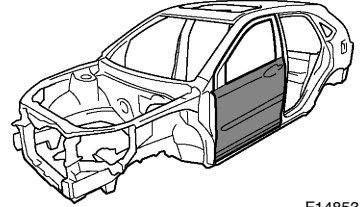
POINT

- 1 After welding the reinforcement to the vehicle side, install the outer panel.

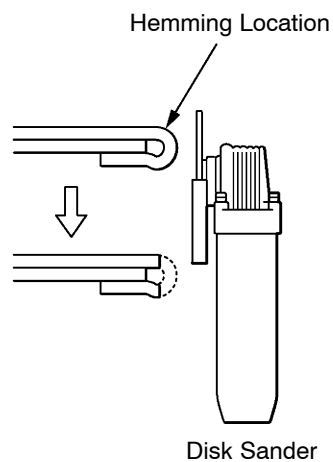
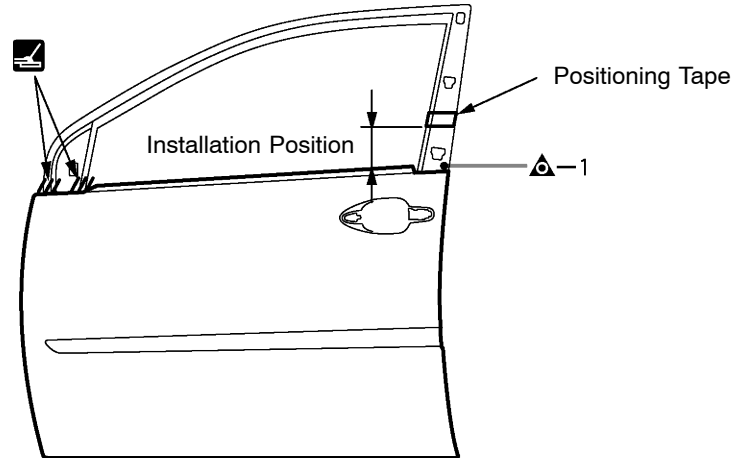
12 mm (0.47 in.)

15 mm (0.59 in.)

20 mm (0.79 in.)

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

F14853-A

REMOVAL

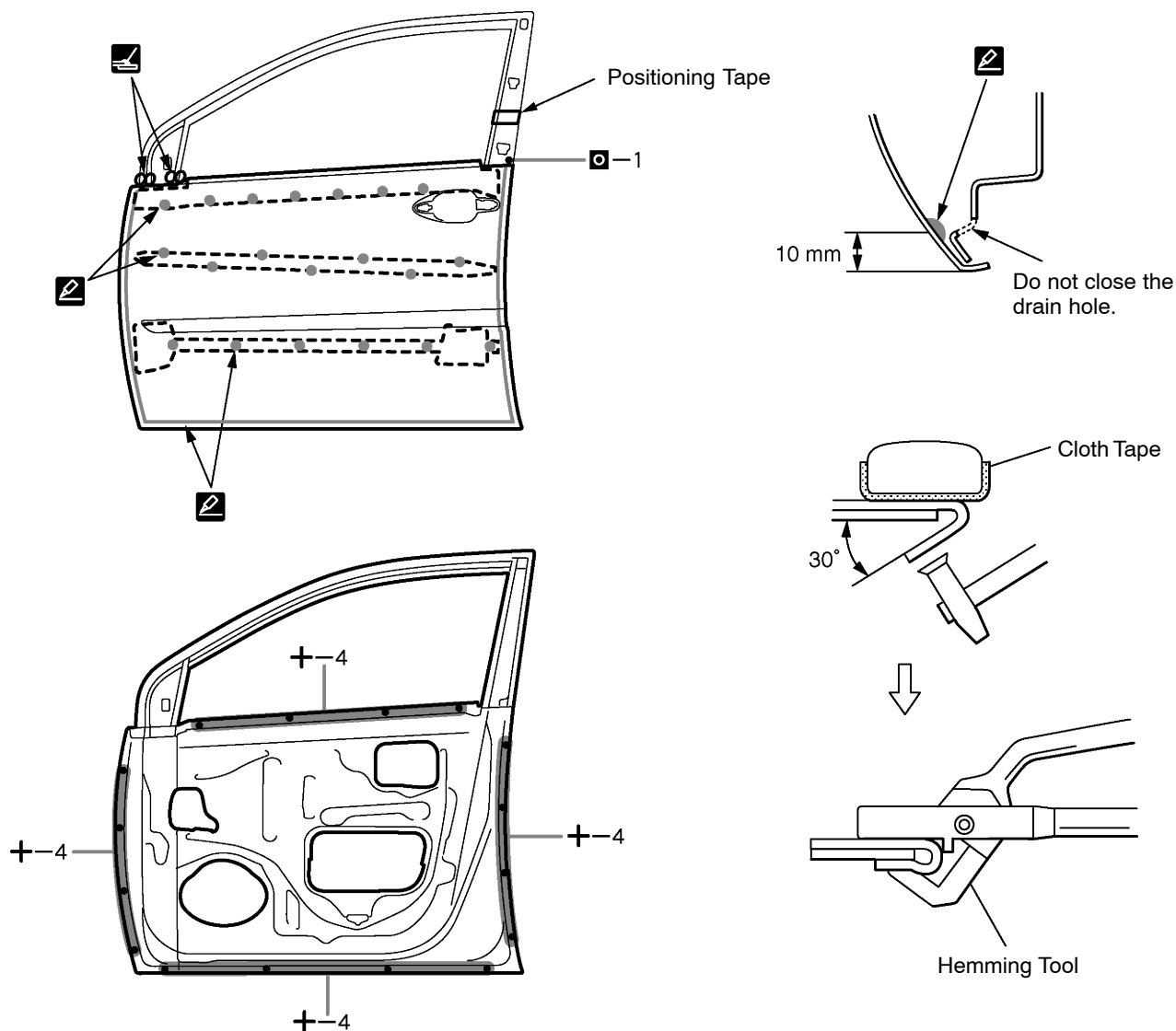
F14853

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.

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.



F20674

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.

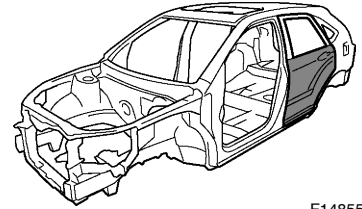
HINT:

- 1) Apply sealer evenly about 10 mm (0.39 in.) from the flange and 3 mm (0.12 in.) in diameter to the outer panel and apply just enough sealer for the reinforcement and side impact protection beam to make contact.

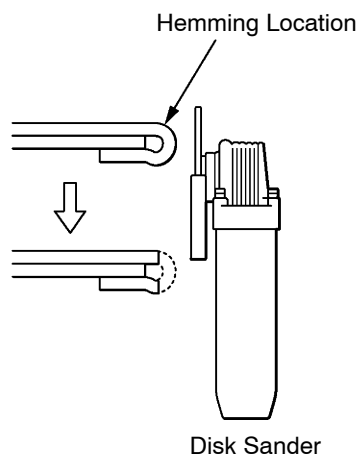
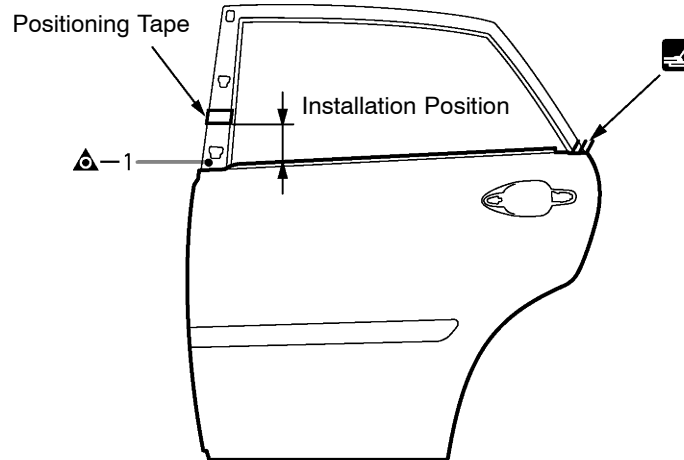
- 2 Bend the flange hem about 30° with a hammer and dolly, then fasten tightly with a hemming tool.

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.

REAR DOOR OUTER PANEL (ASSY)**REPLACEMENT**

F14855-A

REMOVAL

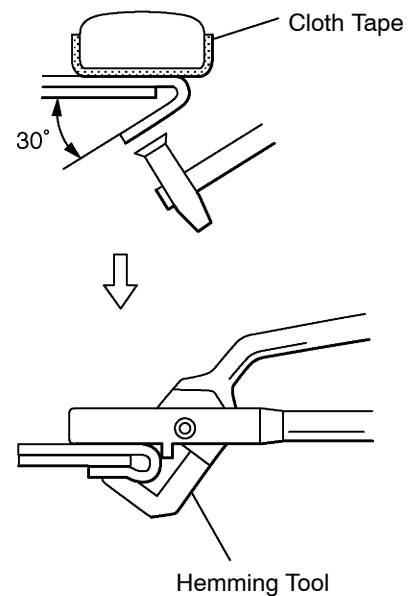
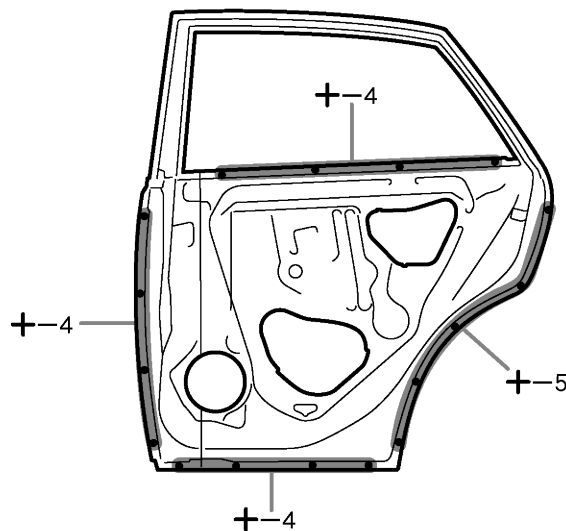
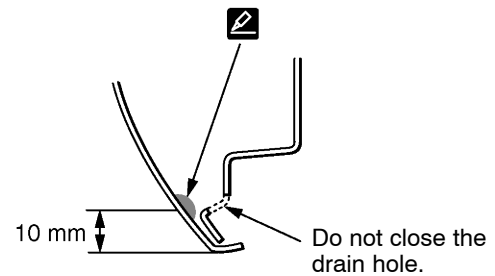
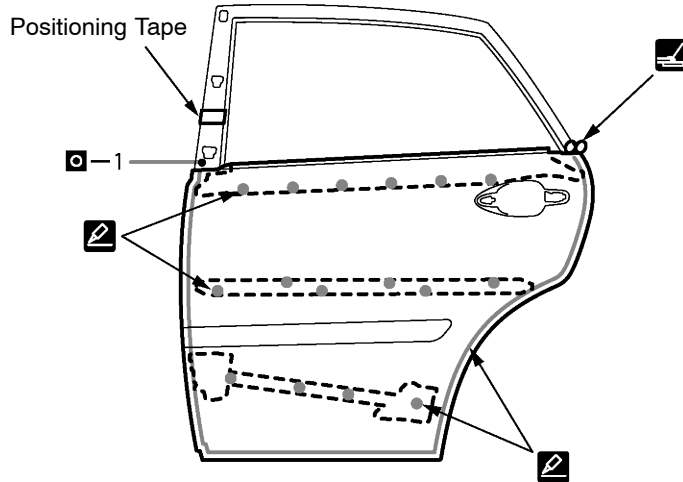
F14855

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.

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.



F20675

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 10 mm (0.39 in.) from the flange and 3 mm (0.12 in.) 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.

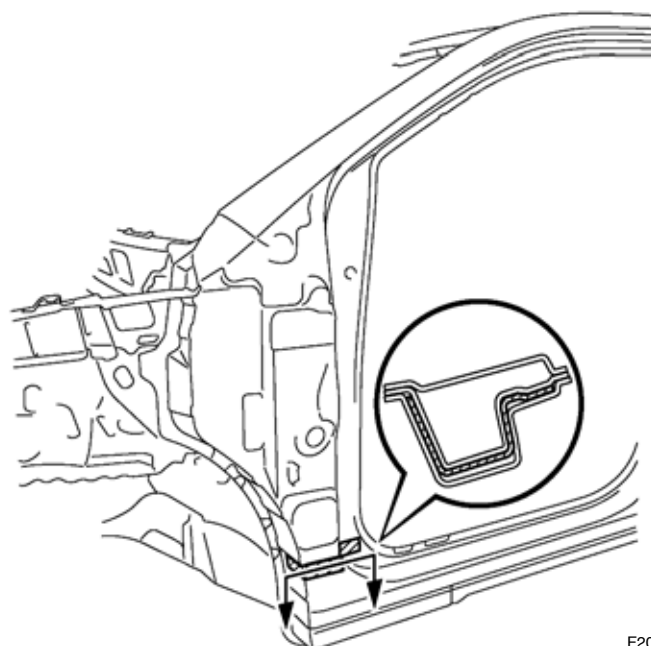
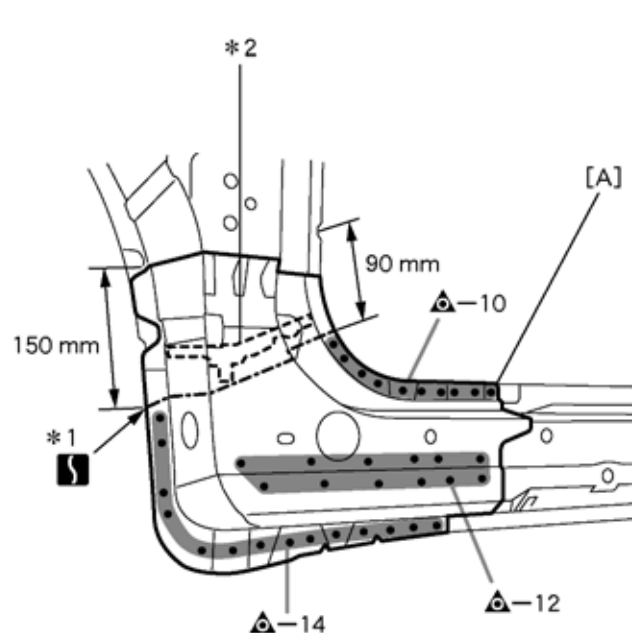
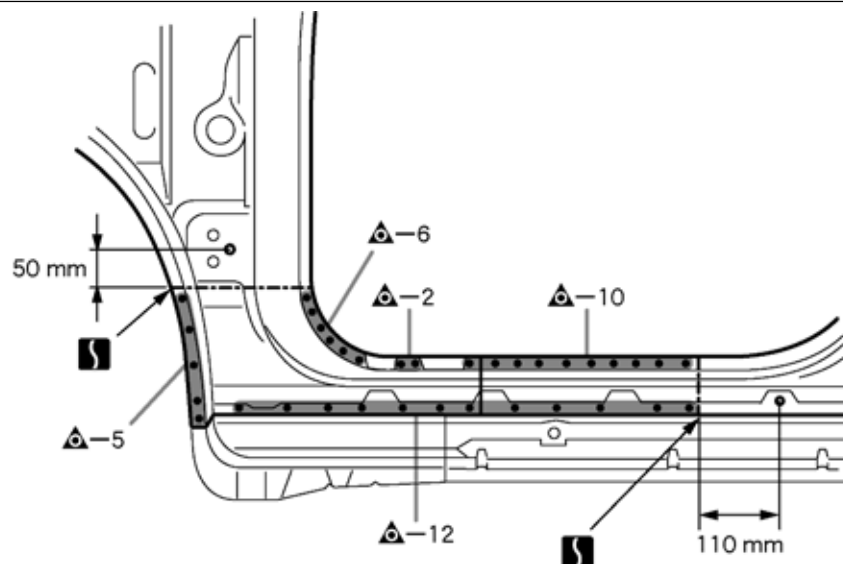
ROCKER OUTER PANEL (CUT-P)

REPLACEMENT



F20692-A

REMOVAL



F20692

POINT

- 1 [A] is Reuse.
- 2 *1: When cutting the [A], be careful not to cut the *2. The *2 is apporoximately 15 mm (0.59 in.) above the [A].
- 3 When cutting the outer panel, be careful not to cut the pad.

PART NAME

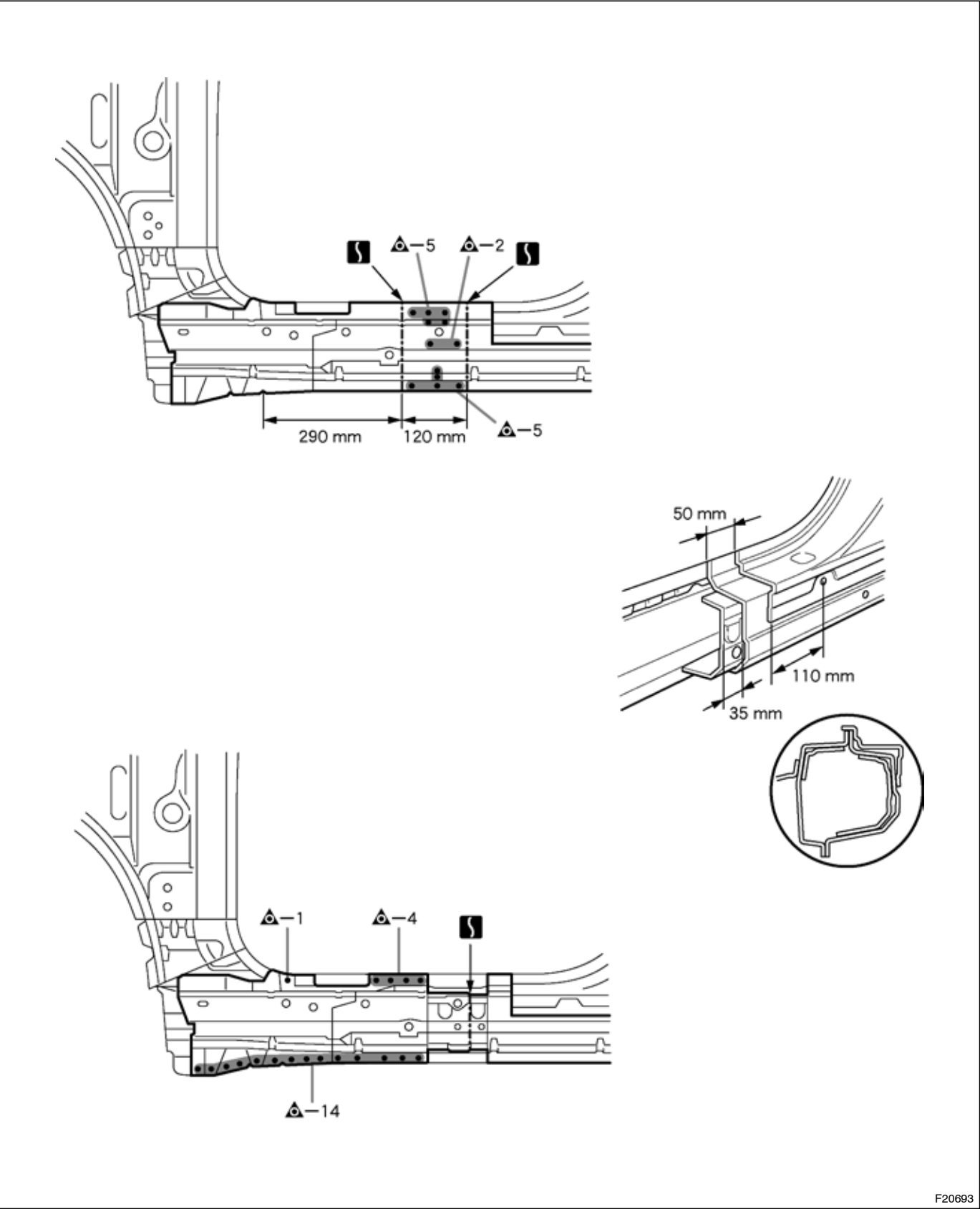
[A] Front Pillar Lower Reinforcement

50 mm (1.97 in.)

90 mm (3.54 in.)

110 mm (4.33 in.)

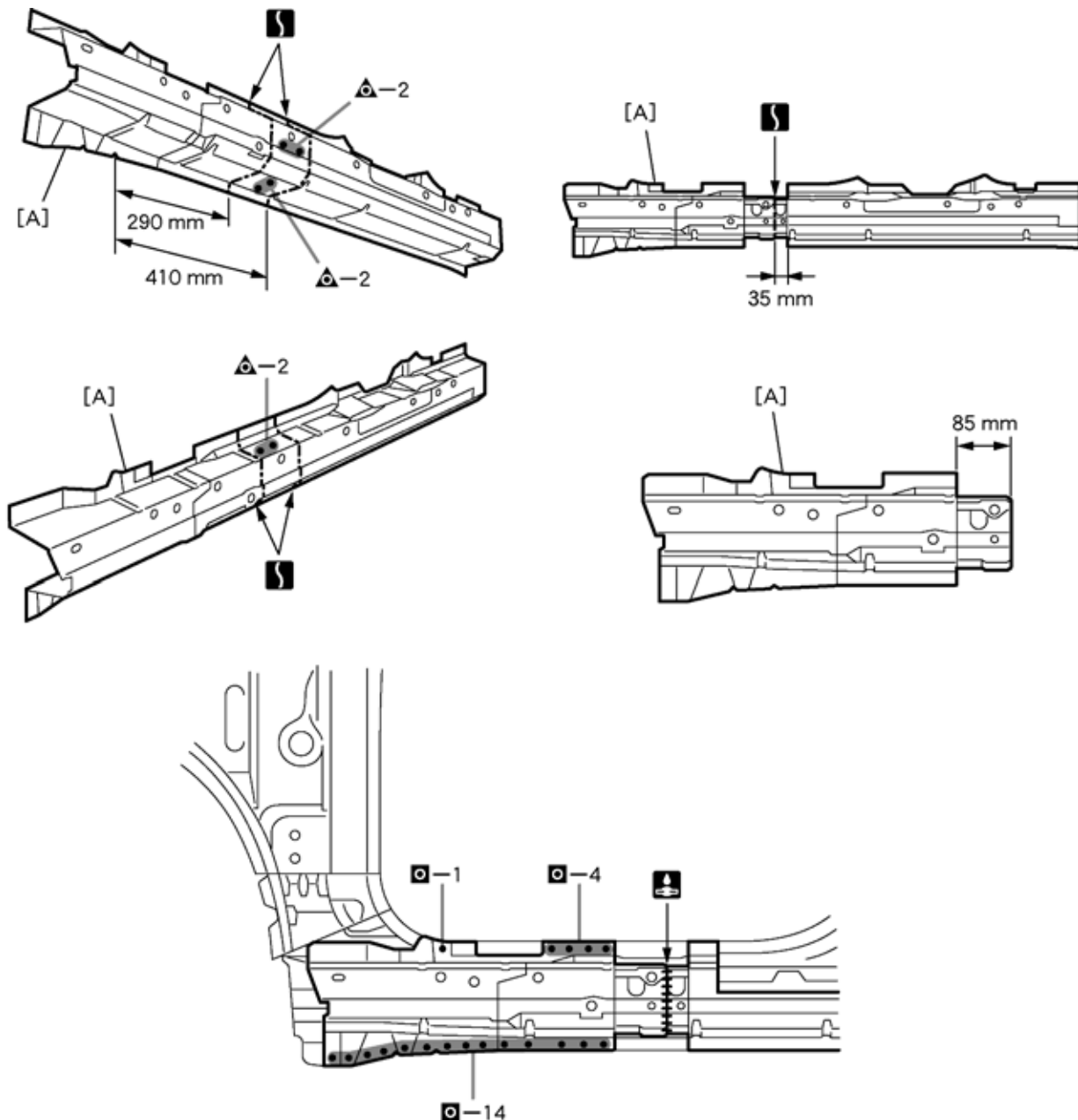
150 mm (5.91 in.)



F20693

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.



F20694

POINT

- 1 After welding the [A] to the vehicle side, install the outer panel.

PART NAME

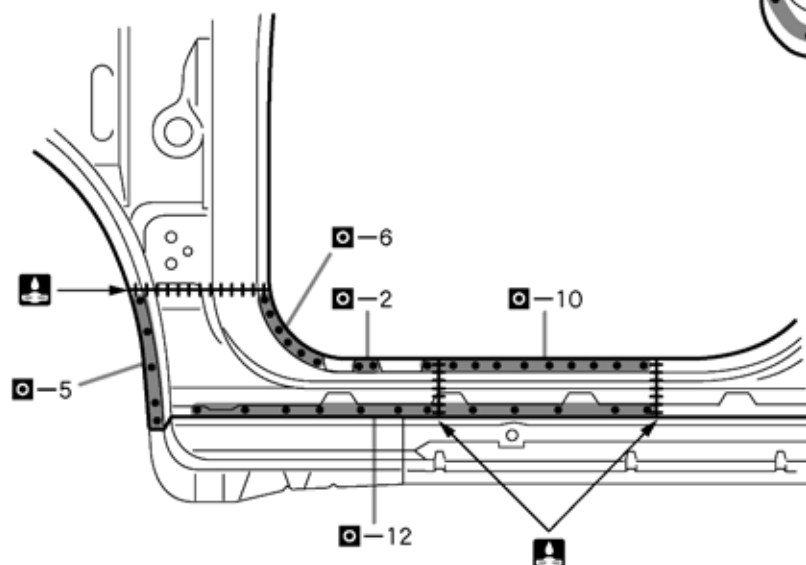
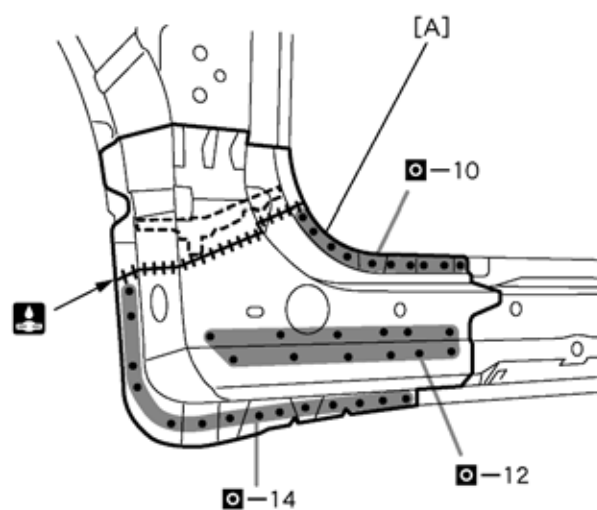
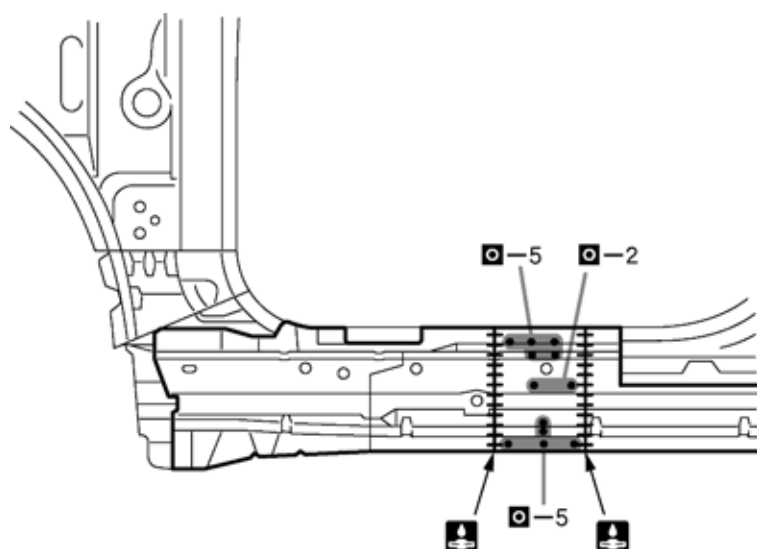
[A] Rocker Outer Panel

35 mm (1.38 in.)

85 mm (3.35 in.)

290 mm (11.42 in.)

410 mm (16.14 in.)



F20695

POINT

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

PART NAME

[A] Front Pillar Lower Reinforcement

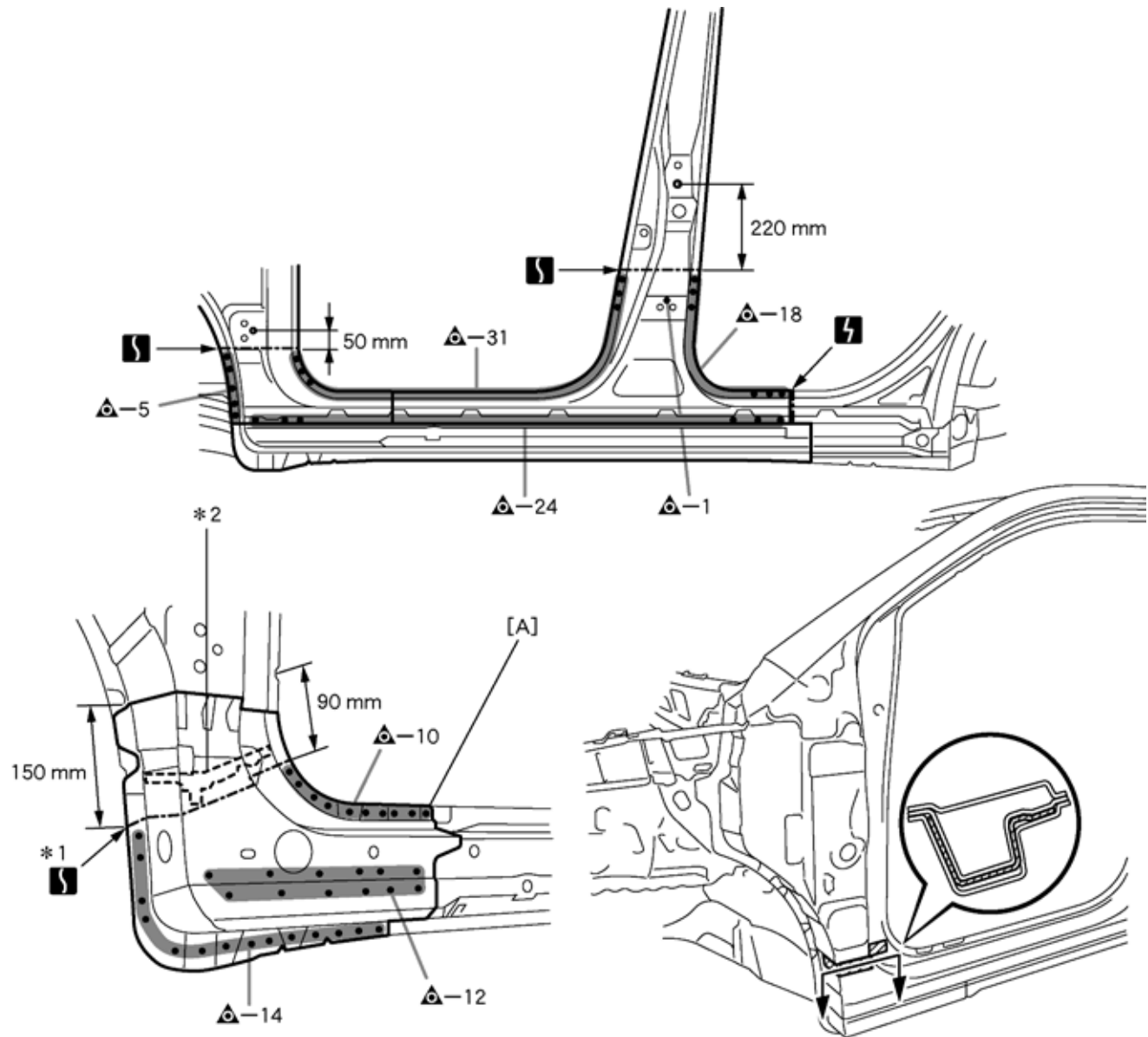
ROCKER OUTER PANEL (CUT)

REPLACEMENT



F20696-A

REMOVAL



F20696

POINT

- 1 [A] is Reuse.
- 2 *1: When cutting the [A], be careful not to cut the *2. The *2 is approximately 15 mm (0.59 in.) above the [A].
- 3 When cutting the outer panel, be careful not to cut the pad.

PART NAME

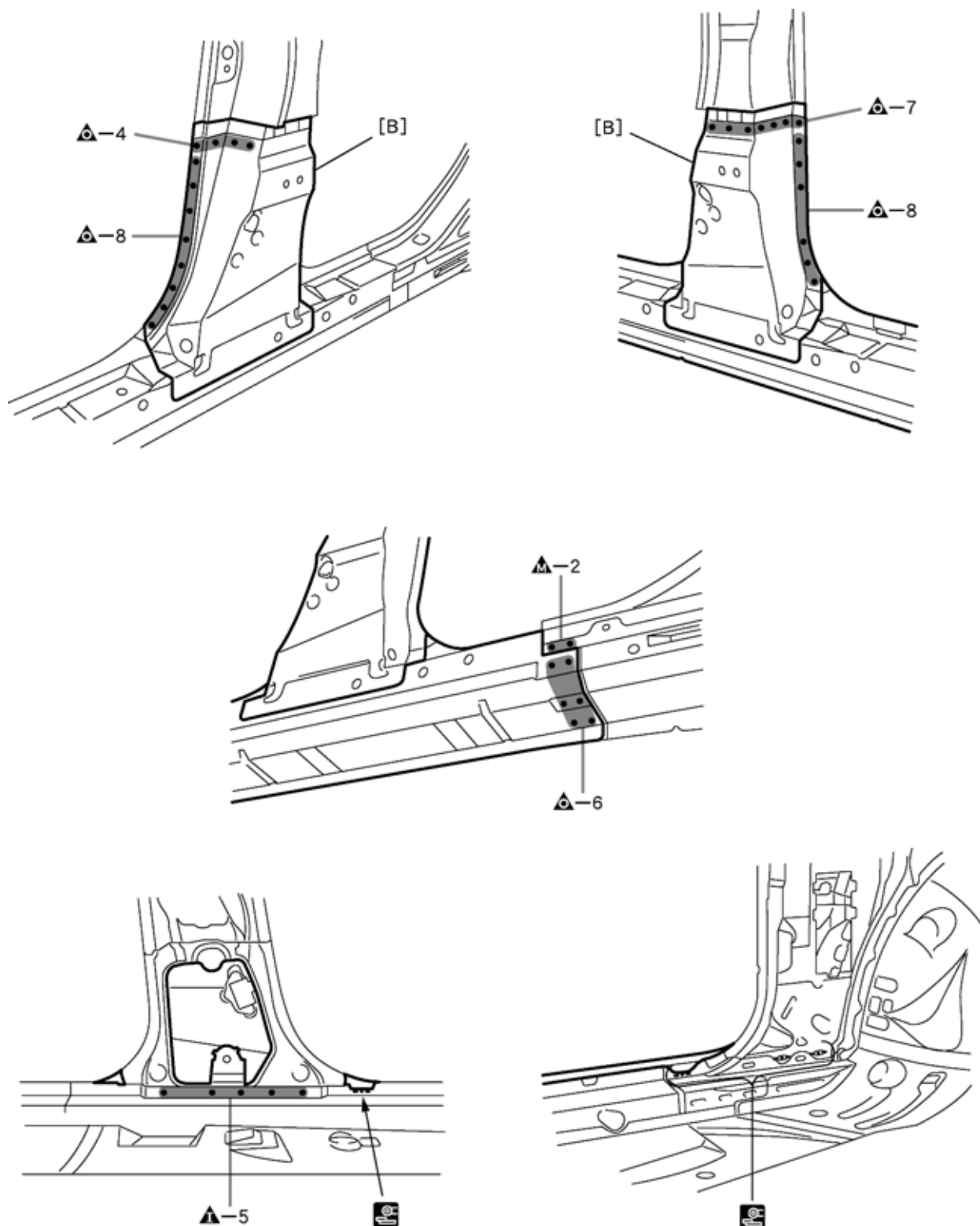
[A] Front Pillar Lower Reinforcement

50 mm (1.97 in.)

90 mm (3.54 in.)

150 mm (5.91 in.)

220 mm (8.66 in.)



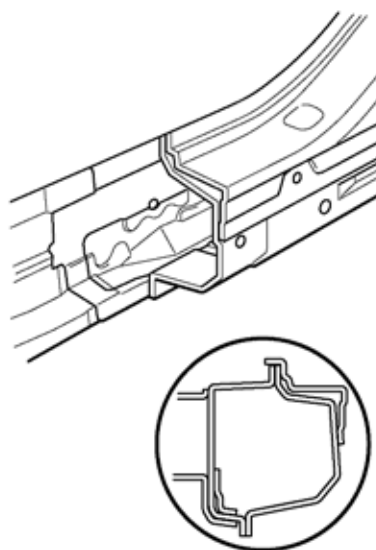
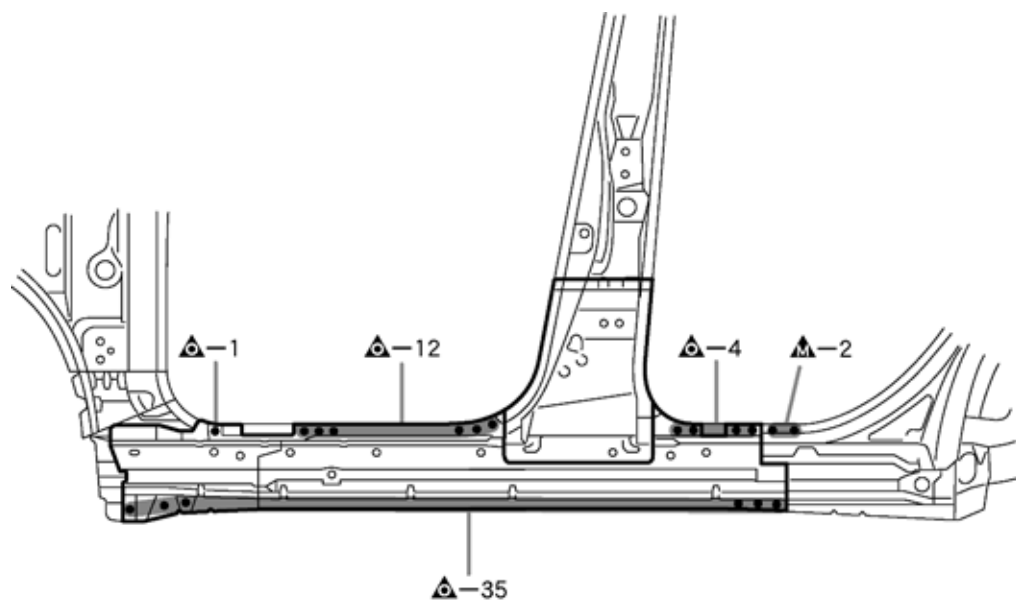
F20697

POINT

- 1 Remove the [B] at the same time.
- 2 After removing the outer panel, remove the rocker outer panel.

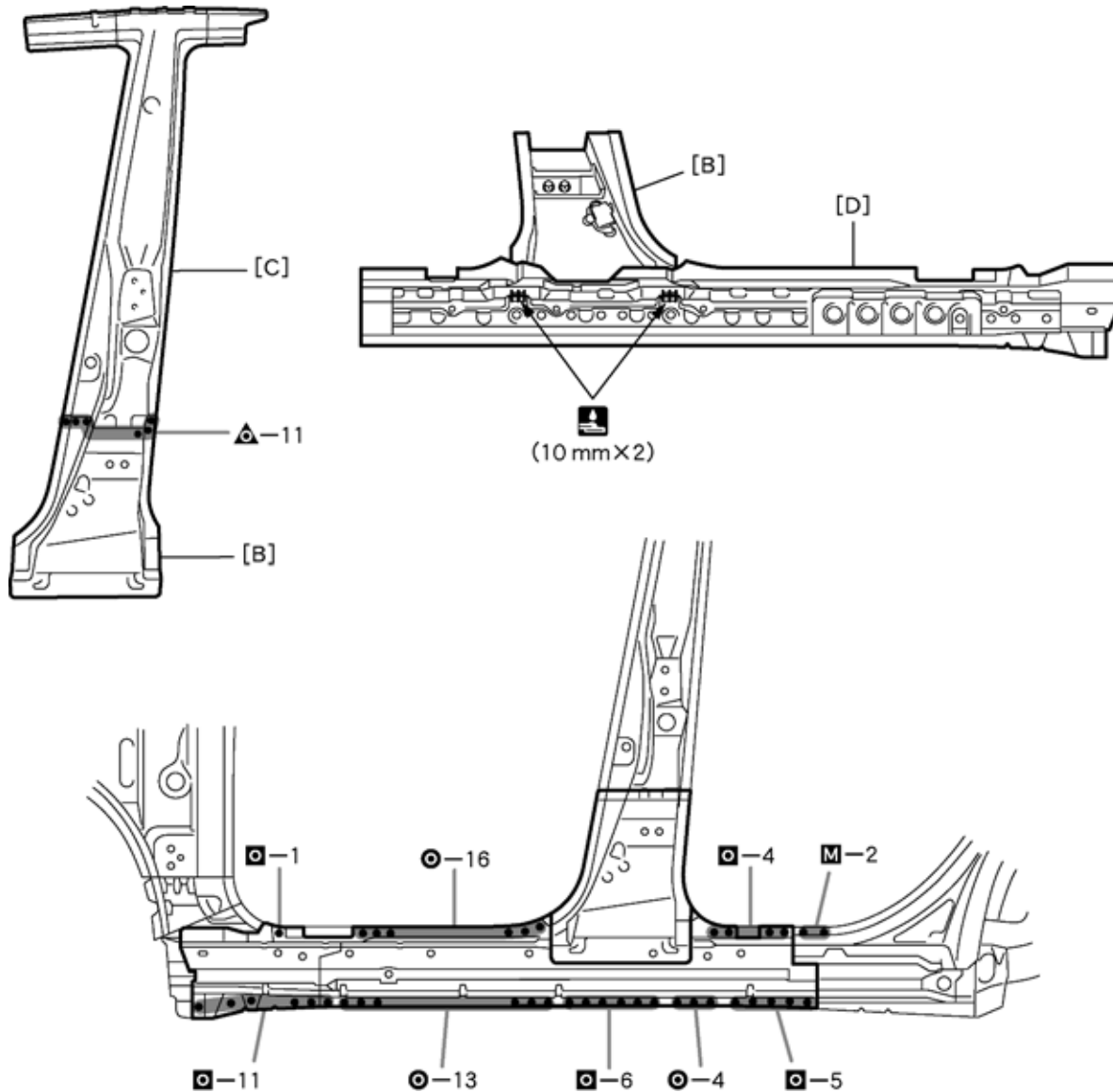
PART NAME

[B] Center Body Pillar Lower Reinforcement



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.



F20699

POINT

- 1 Remove the [B] from the [C].
- 2 Inspect the fitting of the front door and rear door etc., before welding, since this affects the appearance of the finish.

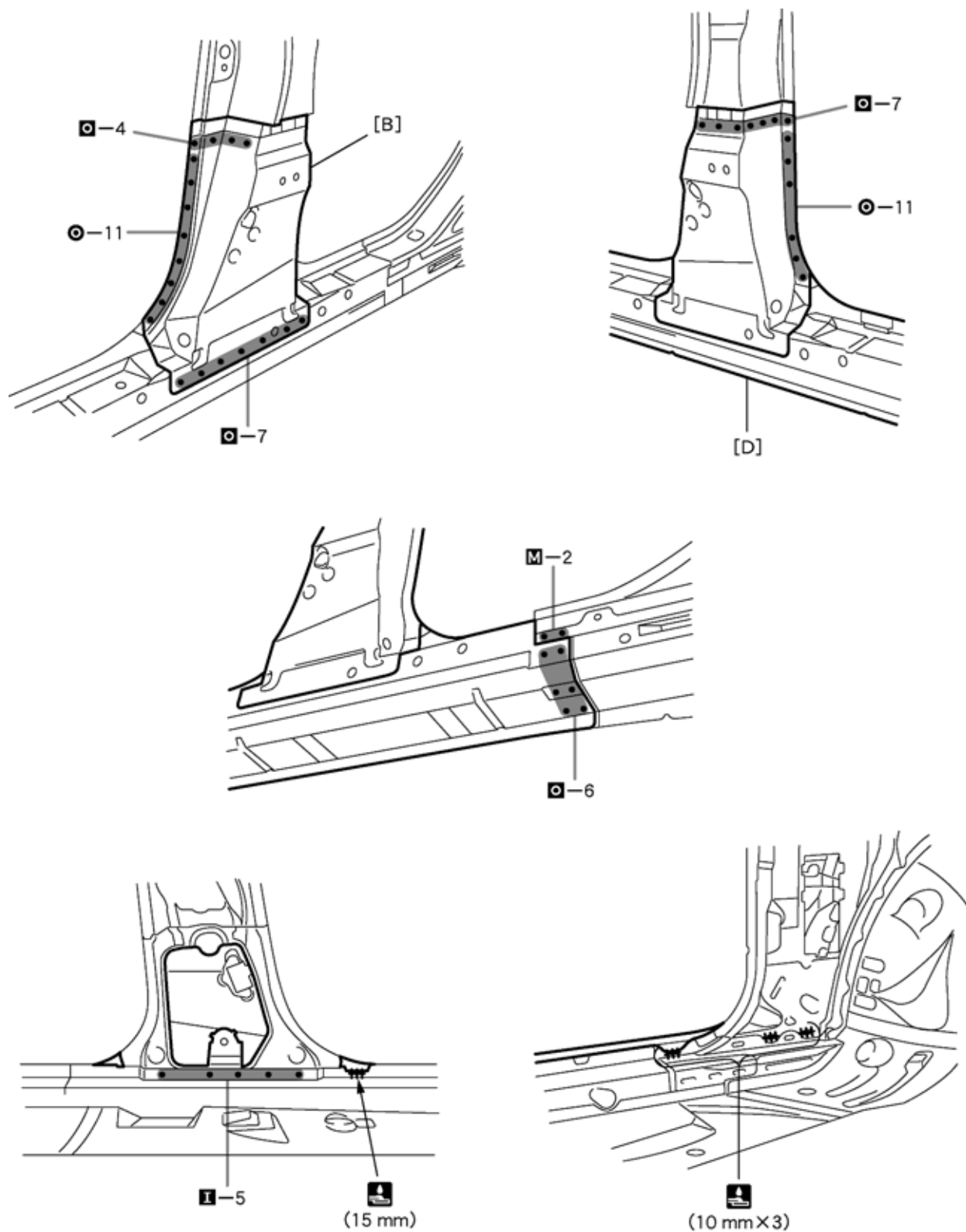
PART NAME

[B] Center Body Pillar Lower Reinforcement

[C] Center Body Pillar Upper Reinforcement

[D] Rocker Outer Panel

10 mm (0.39 in.)



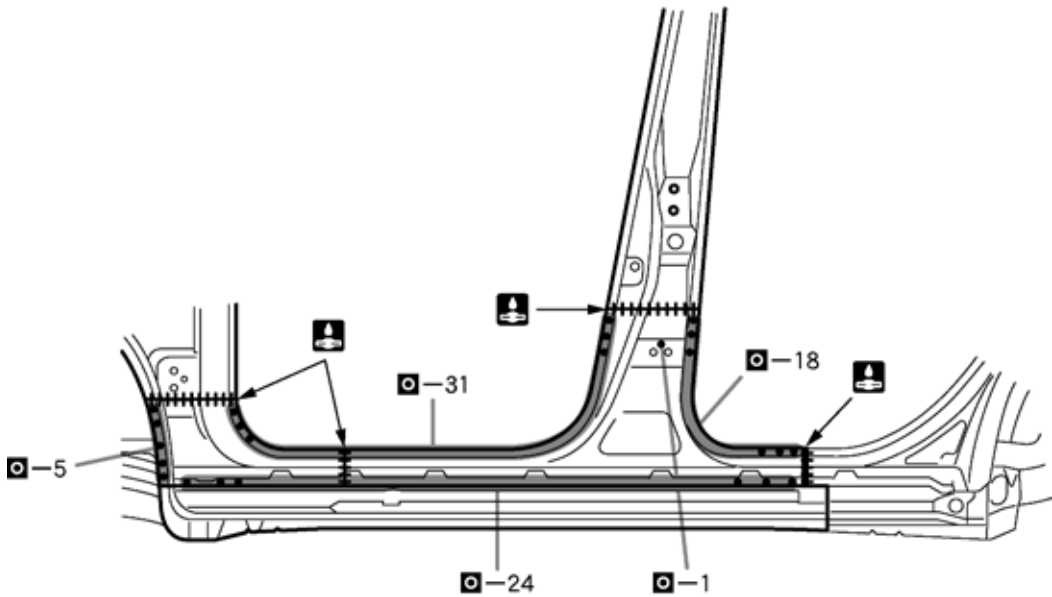
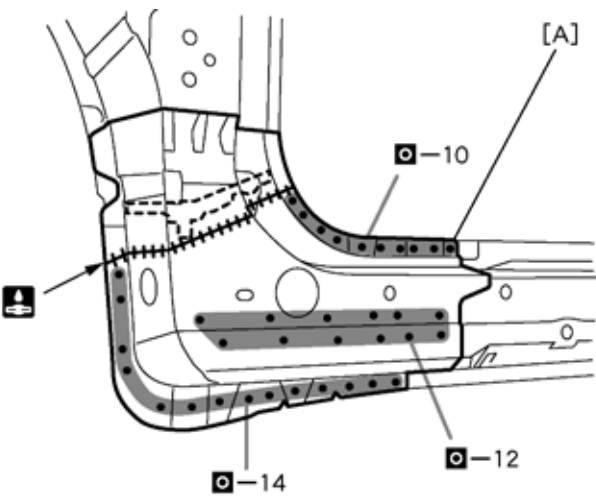
F20700

POINT

1 After welding the [B] and [D] to the vehicle side, install the outer panel.

PART NAME

[B] Center Body Pillar Lower Reinforcement [D] Rocker Outer Panel



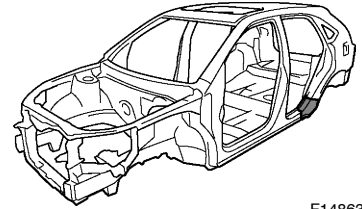
F20701

PART NAME
[A] Front Pillar Lower Reinforcement

ROCKER PANEL NO.5 REINFORCEMENT (CUT)

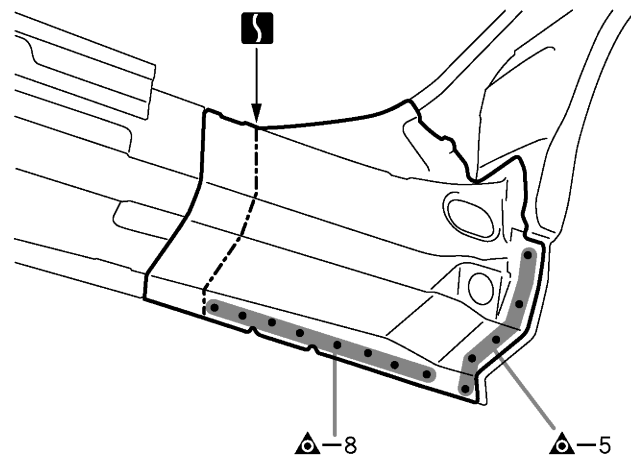
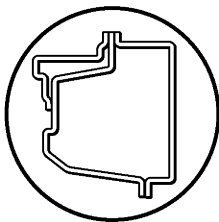
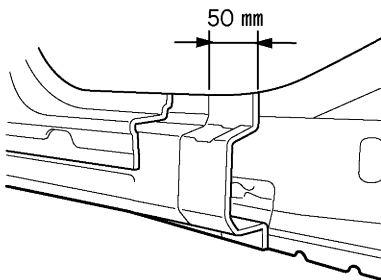
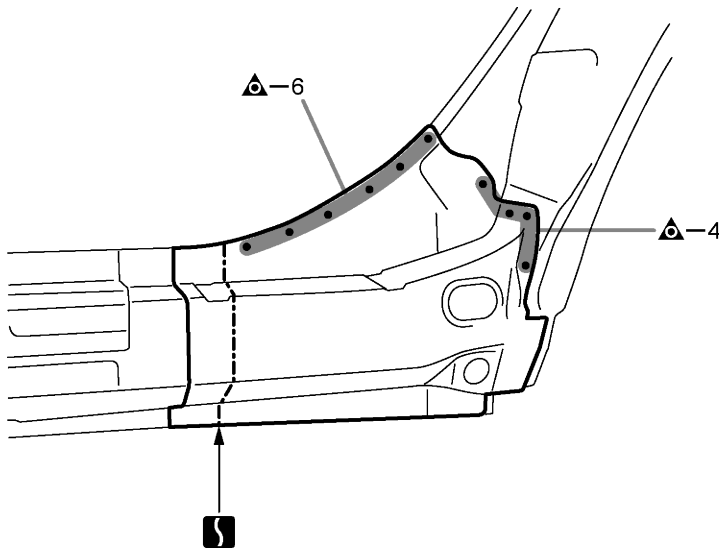
REPLACEMENT

With the quarter panel removed.



F14863-A

REMOVAL

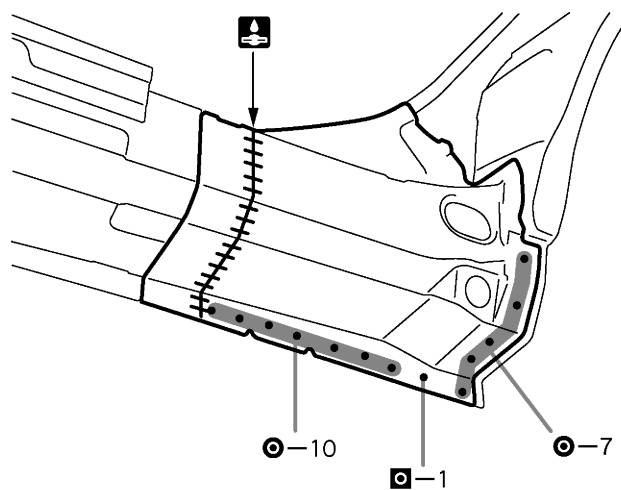
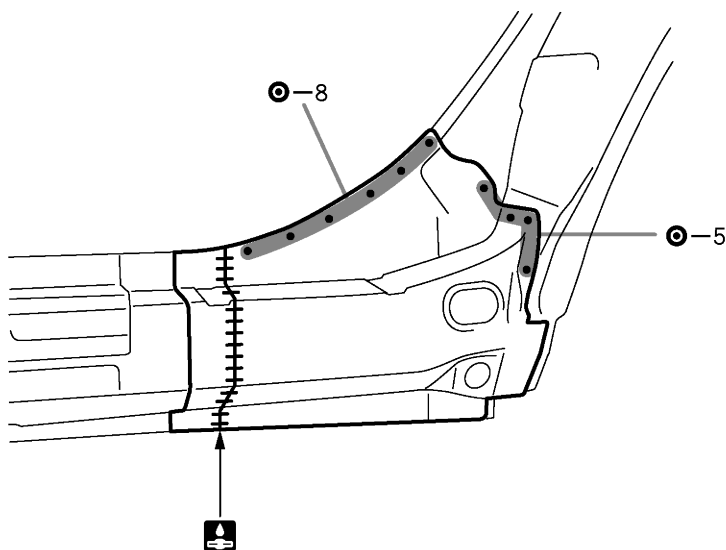


F14863

50 mm (1.97 in.)

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.



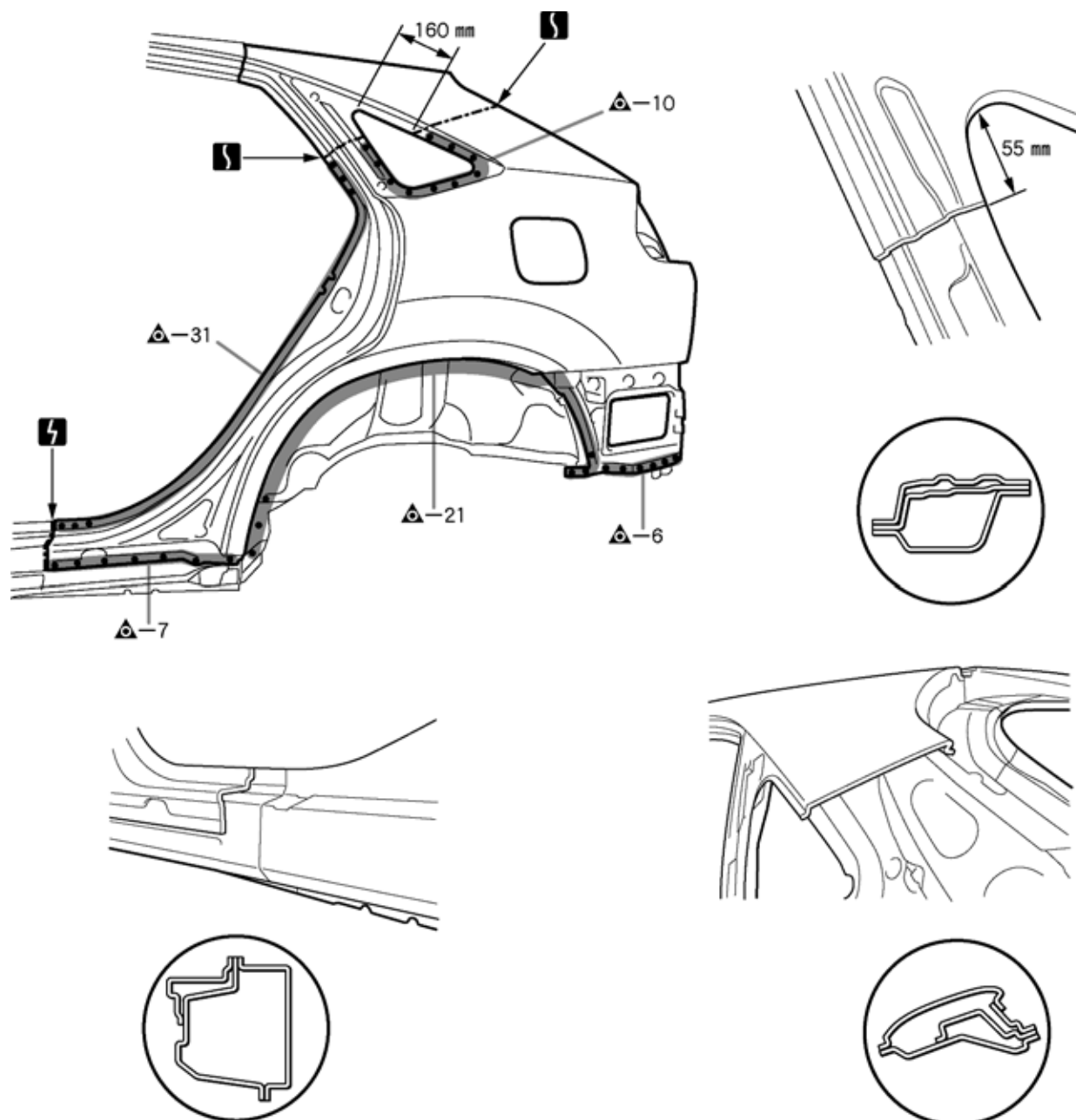
QUARTER PANEL (CUT)

REPLACEMENT



F14865-A

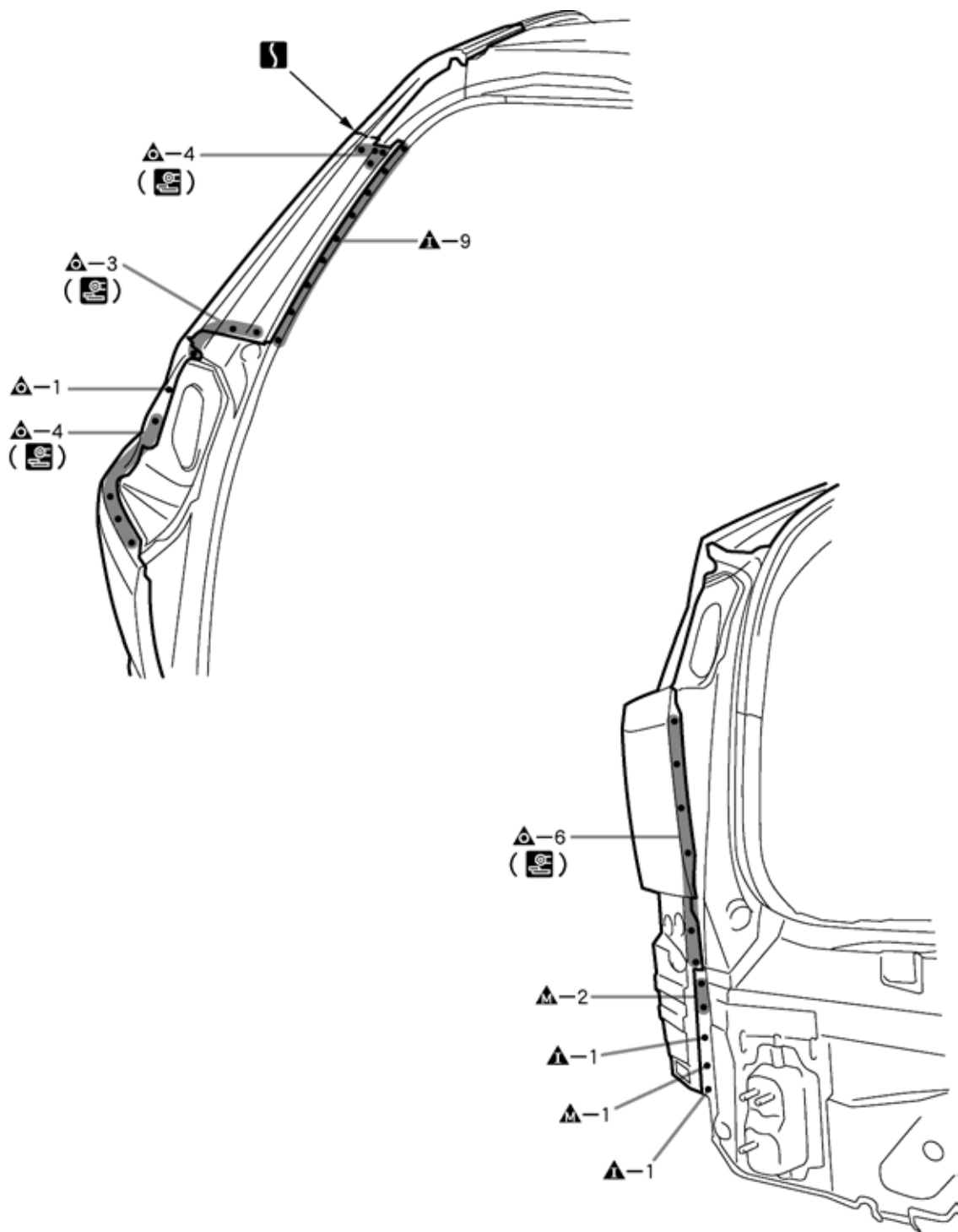
REMOVAL



F20710

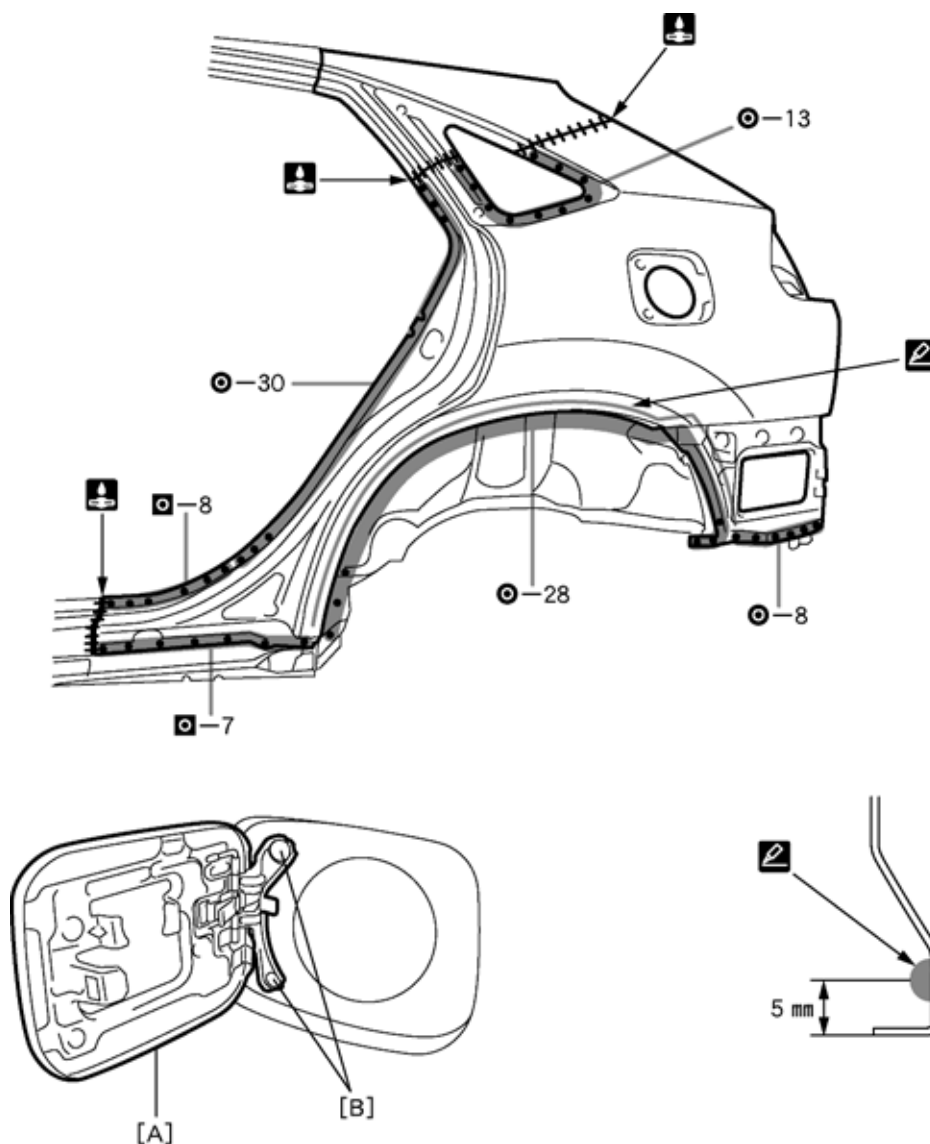
55 mm (2.17 in.)

160 mm (6.30 in.)



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.



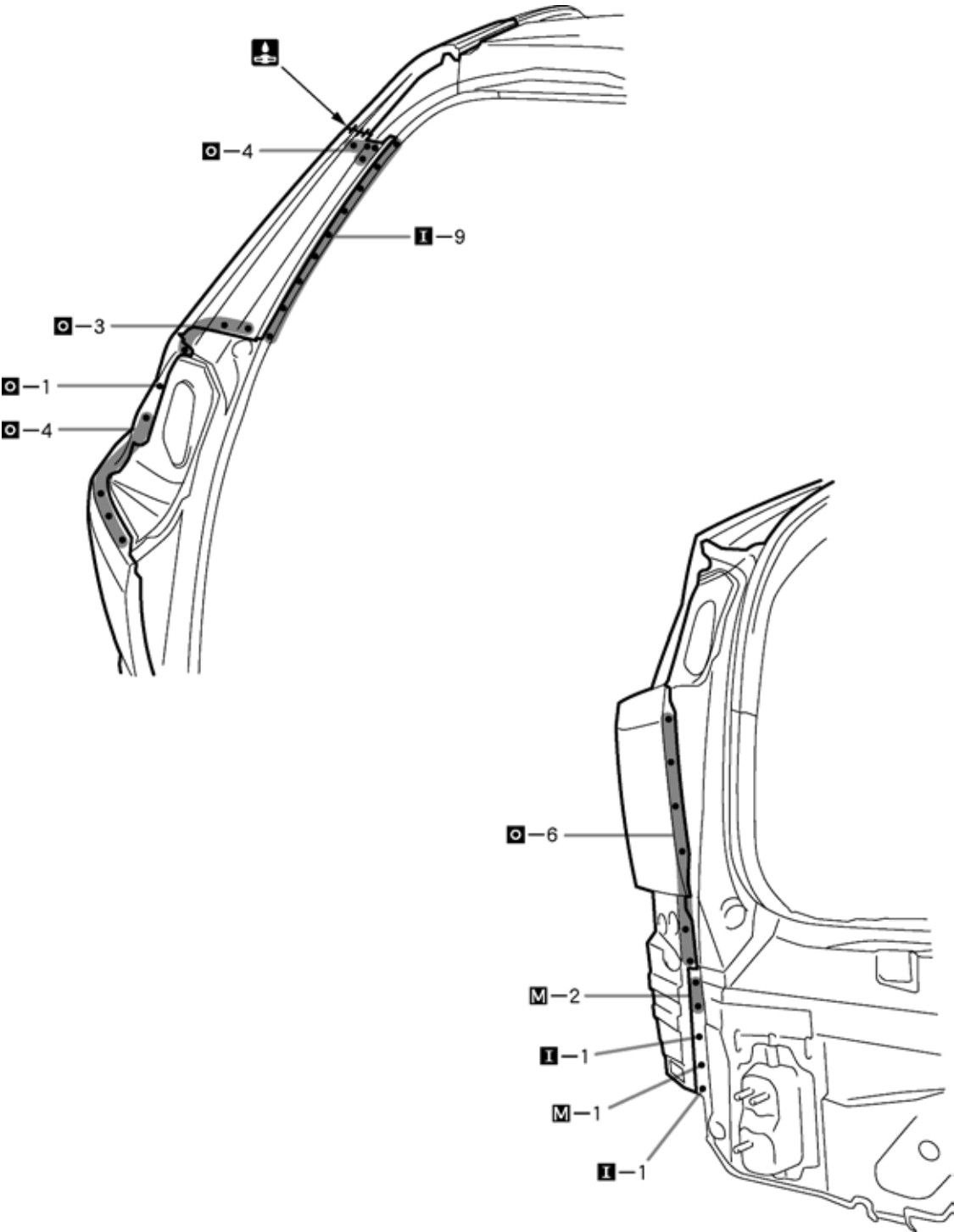
F20712

POINT

- 1 Before temporarily installing the new parts, apply body sealer to the wheel arch.
HINT:
 - 1) Apply body sealer evenly about 5 mm (0.20 in.) from the flange, avoiding any oozing.
 - 2) Apply sealer evenly, about 3 – 4 mm (0.12 – 0.16 in.) in diameter.
- 2 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

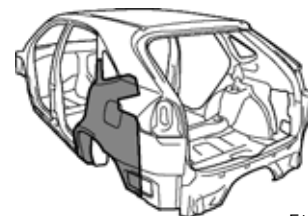
[A] Fuel Filler Opening Lid [B] Rivets



QUARTER WHEEL HOUSING OUTER PANEL (ASSY)

REPLACEMENT

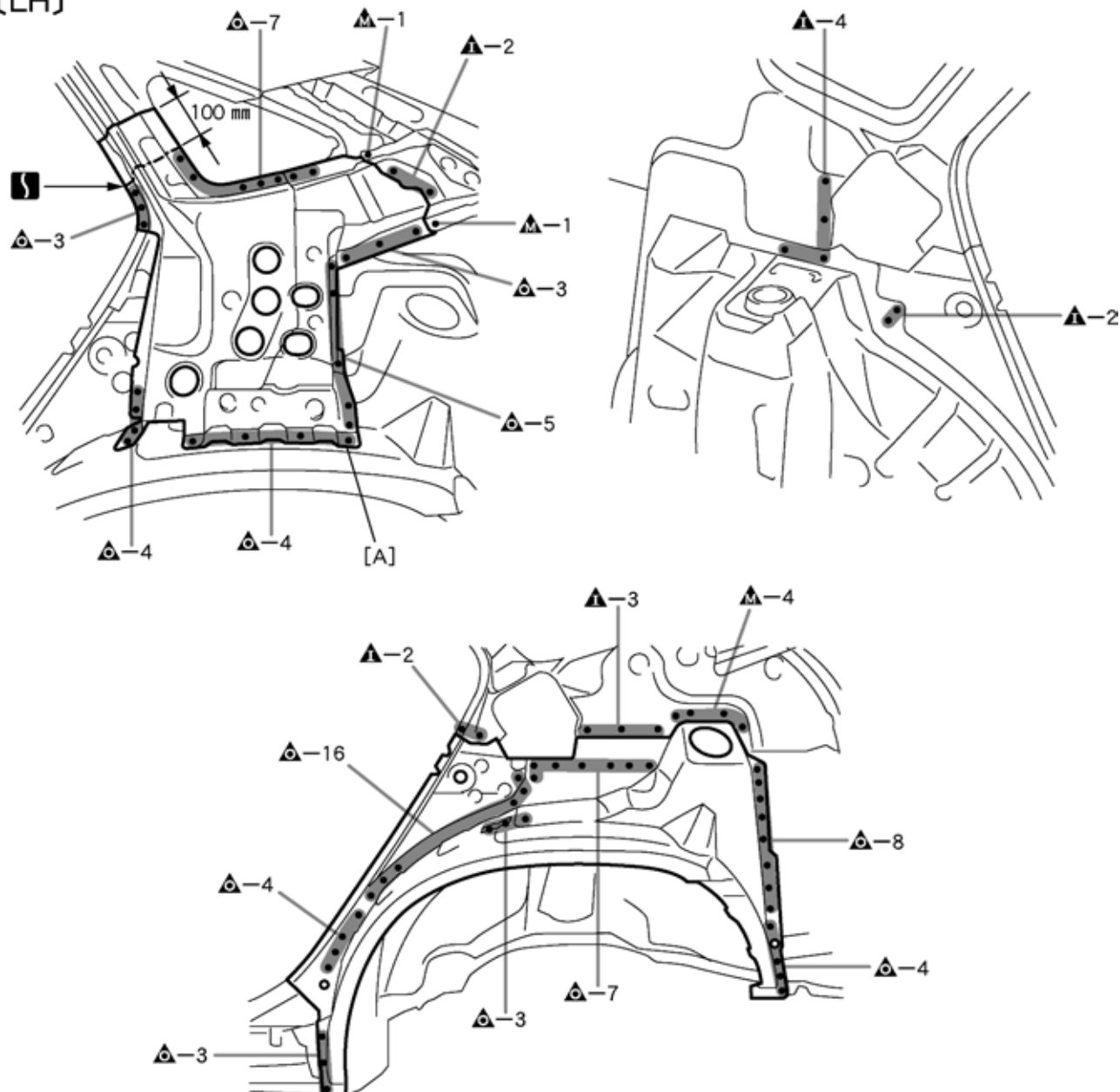
With the rocker panel No.5 reinforcement removed.



F14871-A

REMOVAL

[LH]



F20714

POINT

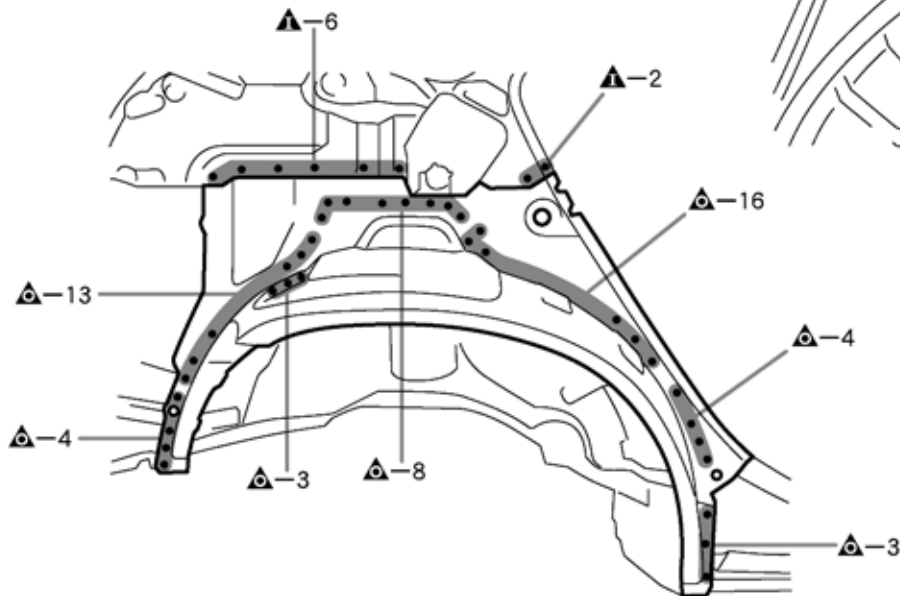
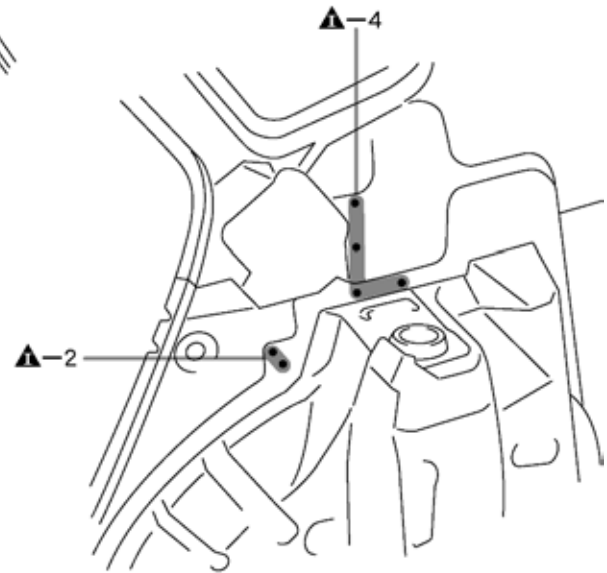
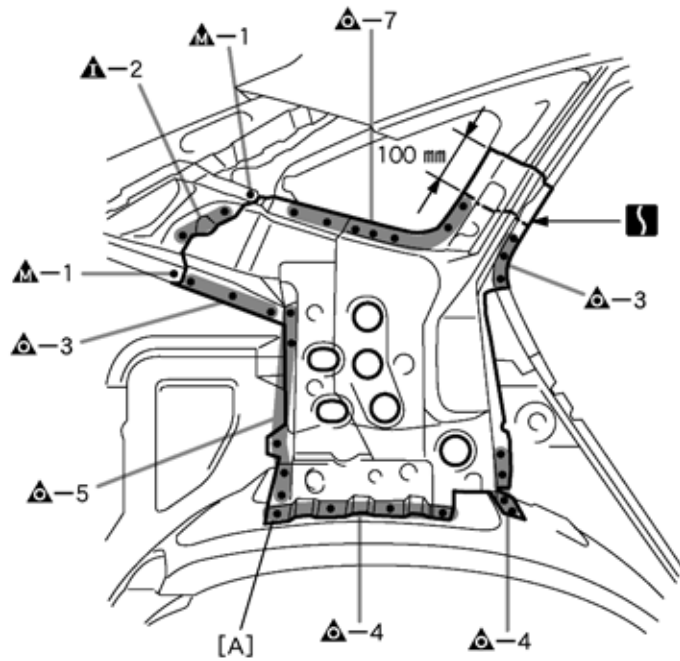
1 After removing the [A], remove the quarter wheel housing outer panel.

PART NAME

[A] Roof Side Inner Panel

100 mm (3.94 in.)

[RH]



F20715

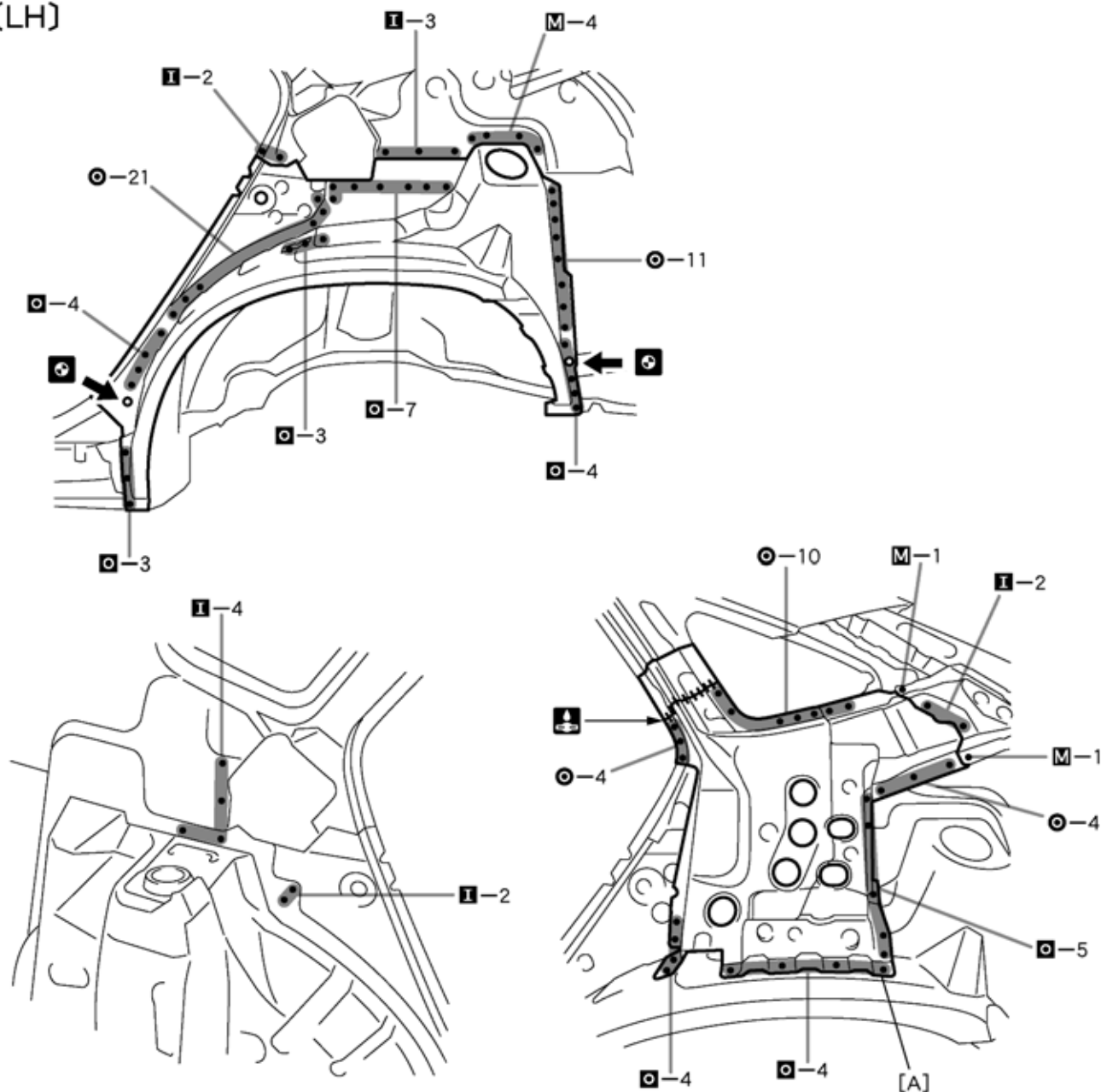
PART NAME

[A] Roof Side Inner Panel

100 mm (3.94 in.)

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.

(LH)

F20716

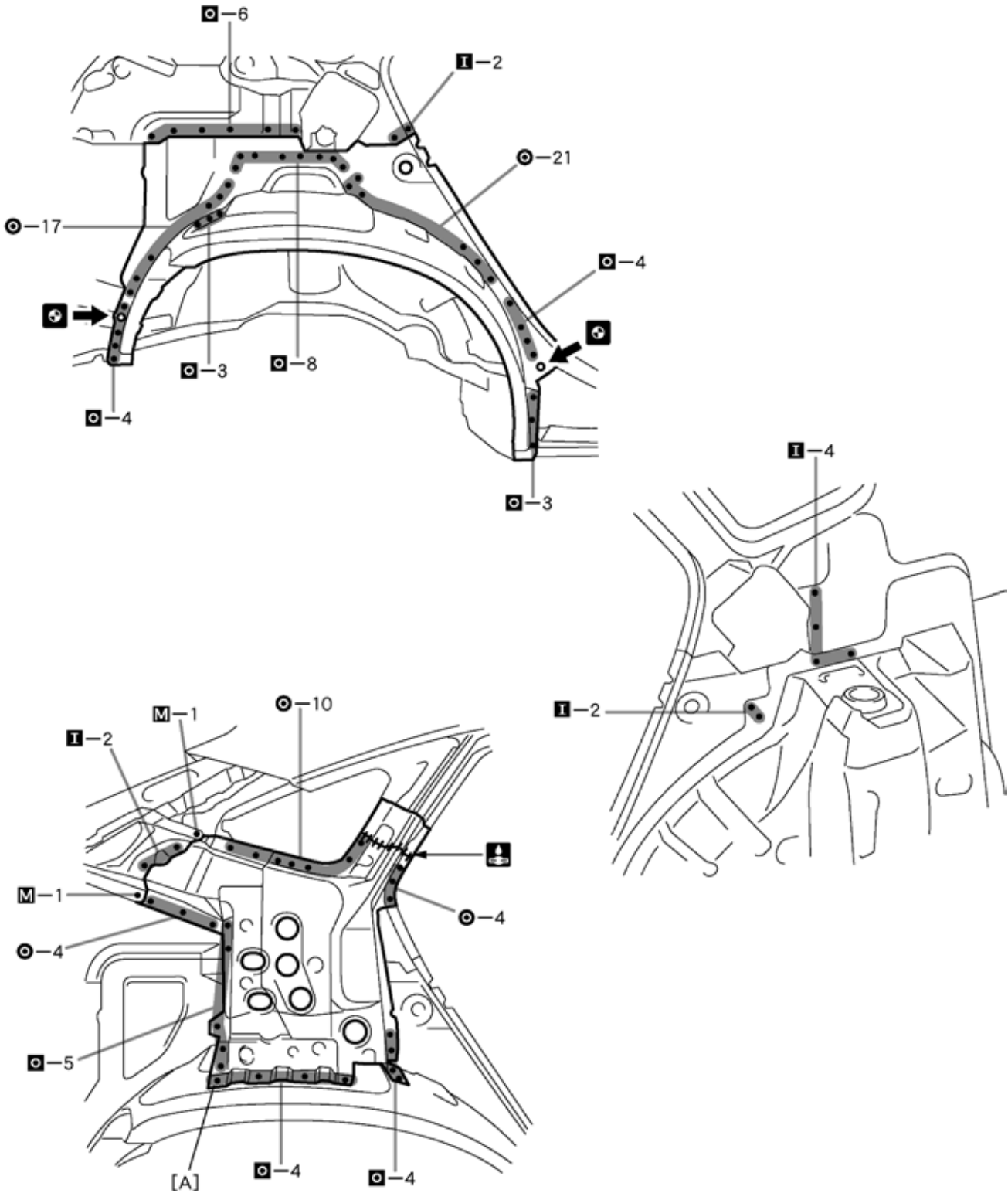
POINT

- 1 Determine the position of the new parts by assembly marks of the inner and outer panels.
- 2 After welding the quarter wheel housing outer panel to the vehicle side install the [A].

PART NAME

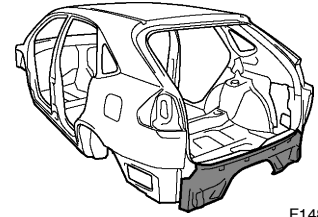
[A] Roof Side Inner Panel

[RH]

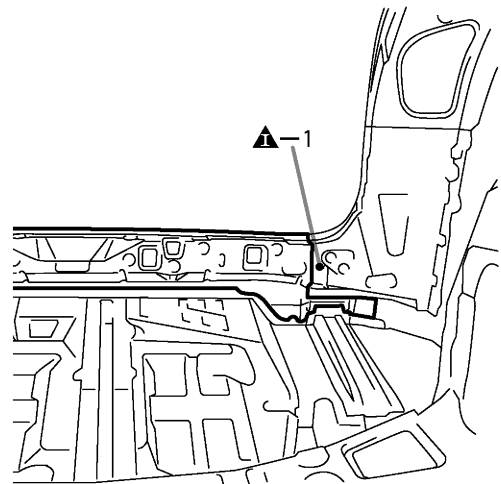
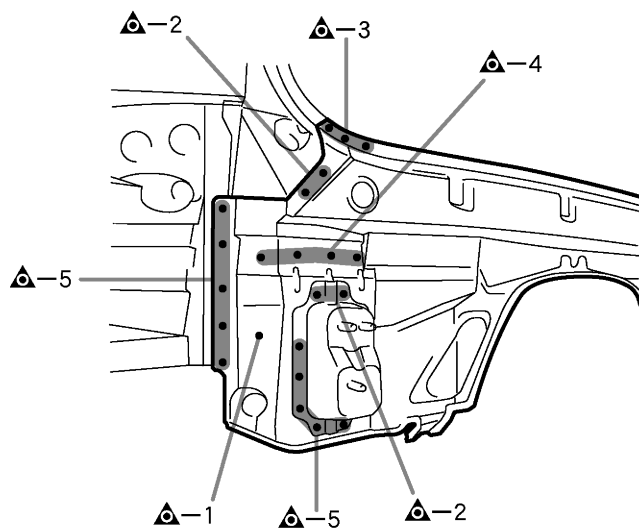
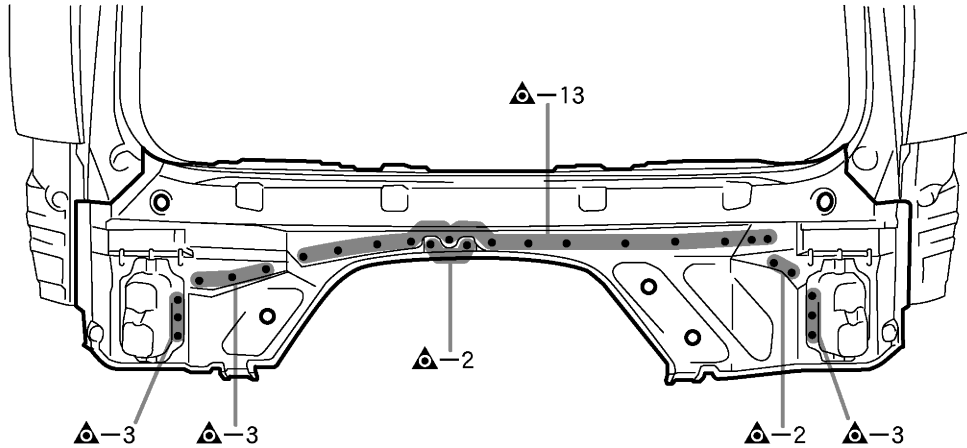


F20717

PART NAME
[A] Roof Side Inner Panel

BODY LOWER BACK PANEL (ASSY)**REPLACEMENT**

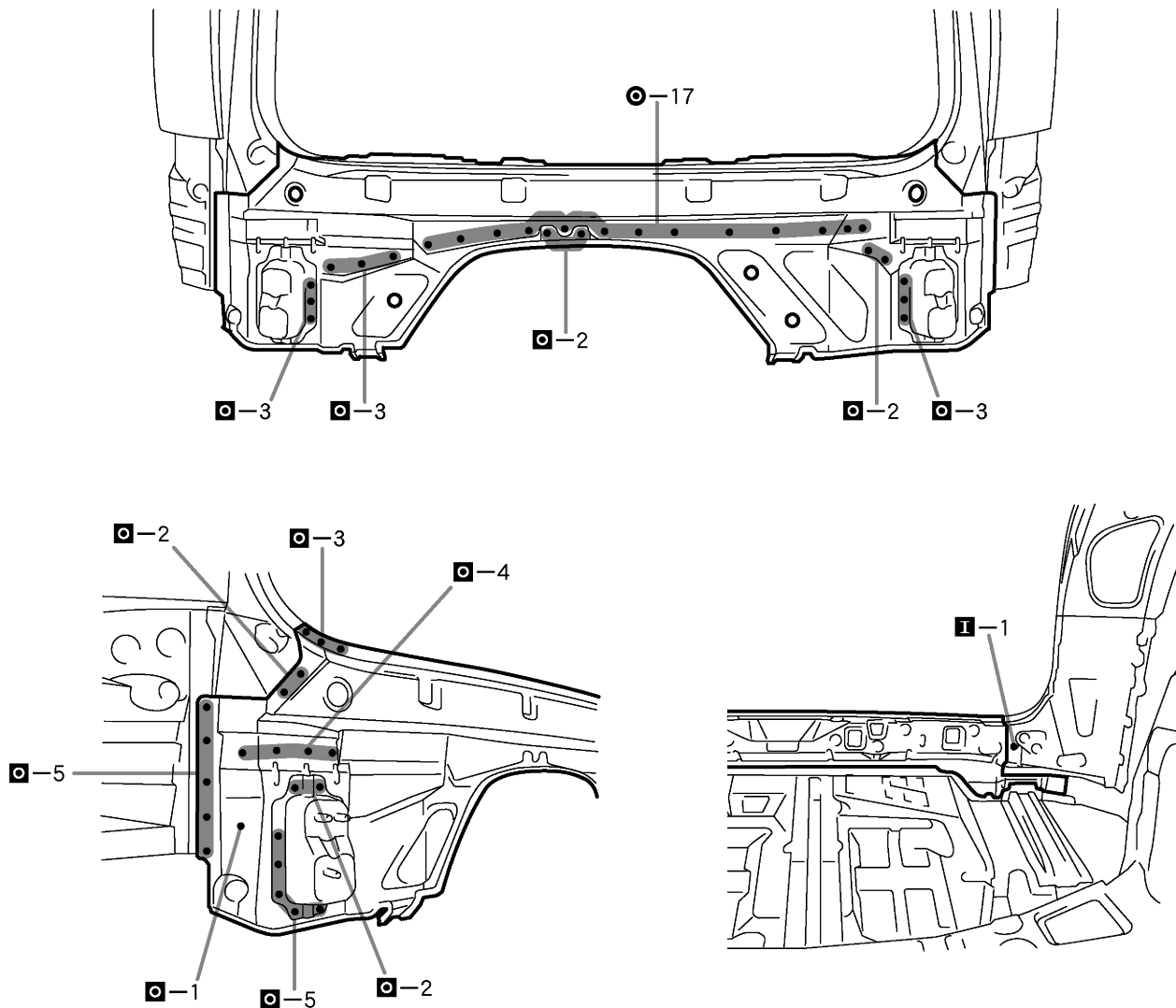
F14875-A

REMOVAL

F14875

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.



F14876

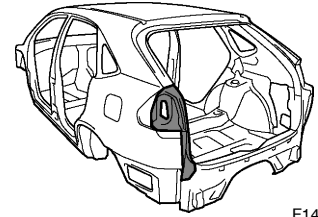
POINT

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

REAR BODY REAR SIDE CORNER PANEL (ASSY)

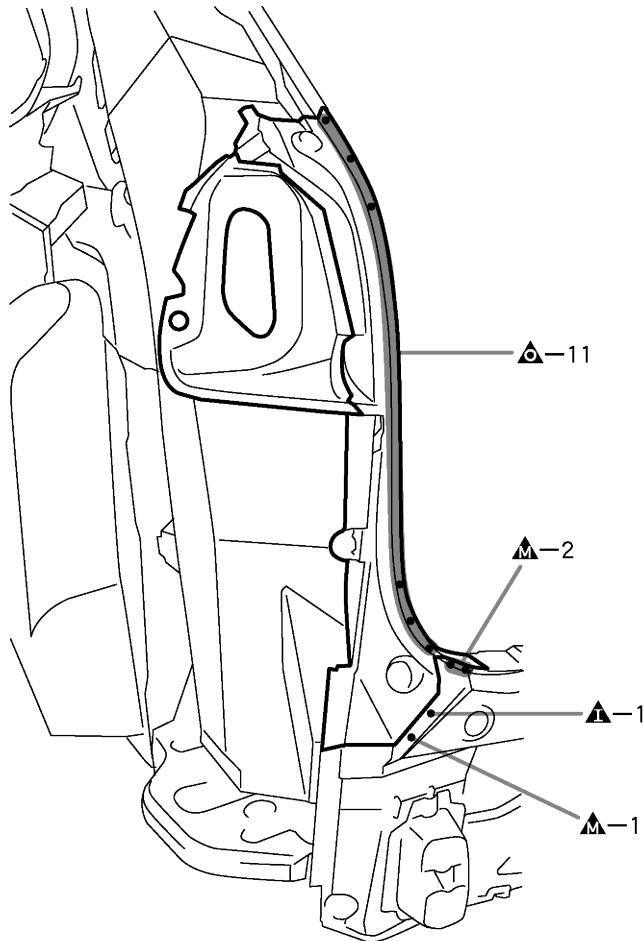
REPLACEMENT

With the quarter panel removed.



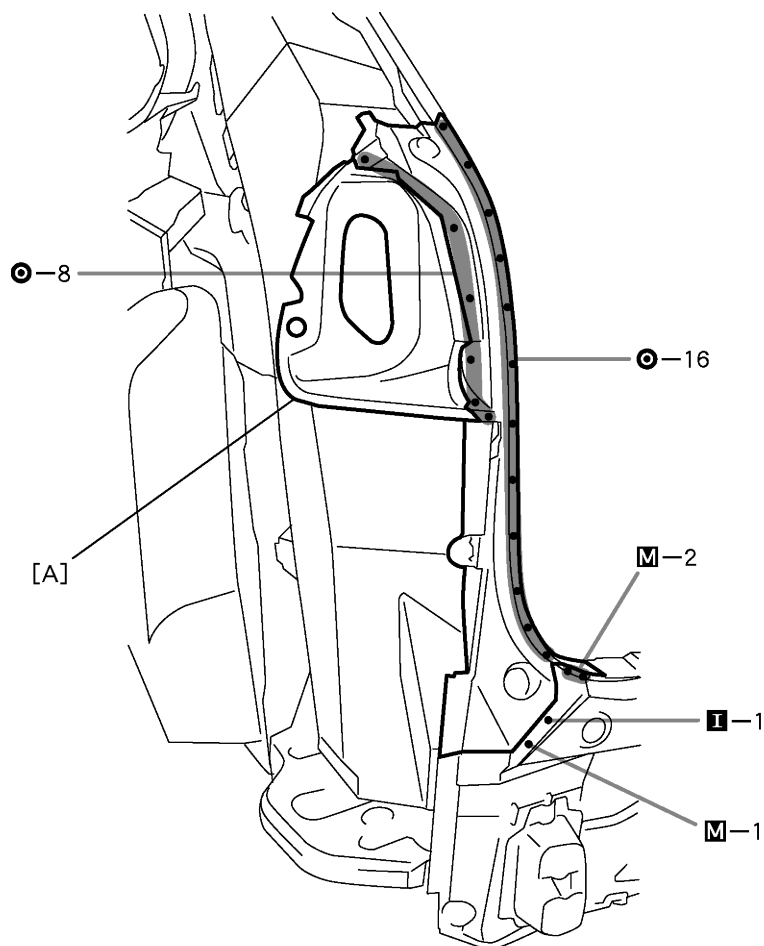
F14877-A

REMOVAL



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.



F14878

POINT

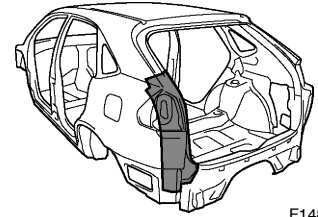
- 1 Inspect the fitting of the back door and rear combination light, etc., before welding, since this affects the appearance of the finish.

PART NAME

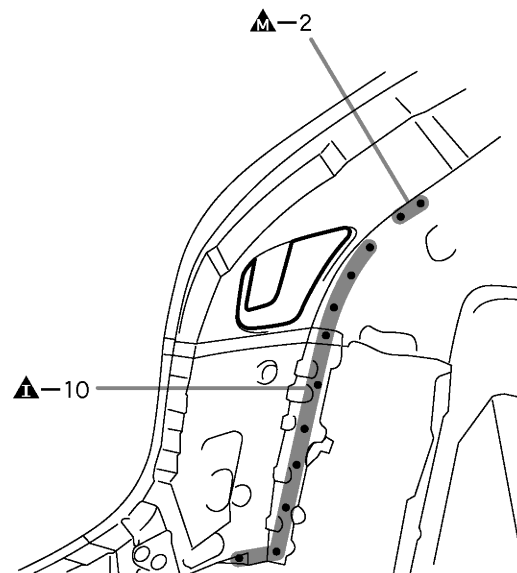
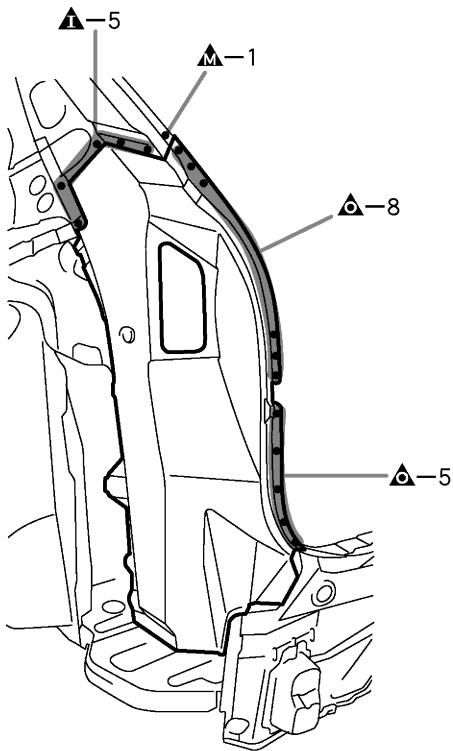
[A] Back Door Opening Trough

ROOF SIDE INNER REAR PANEL (ASSY)**REPLACEMENT**

With the rear body rear side corner panel removed.



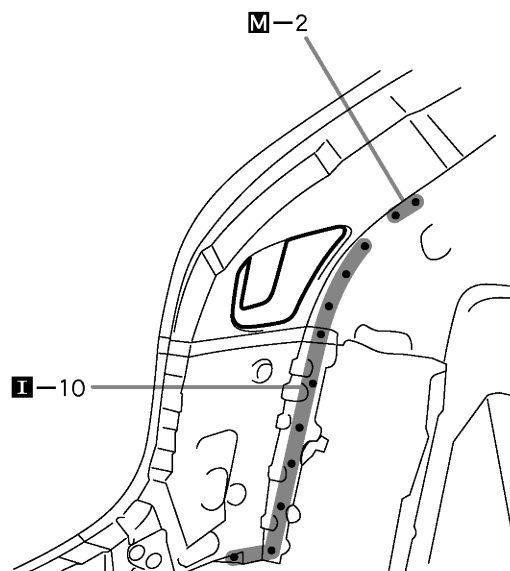
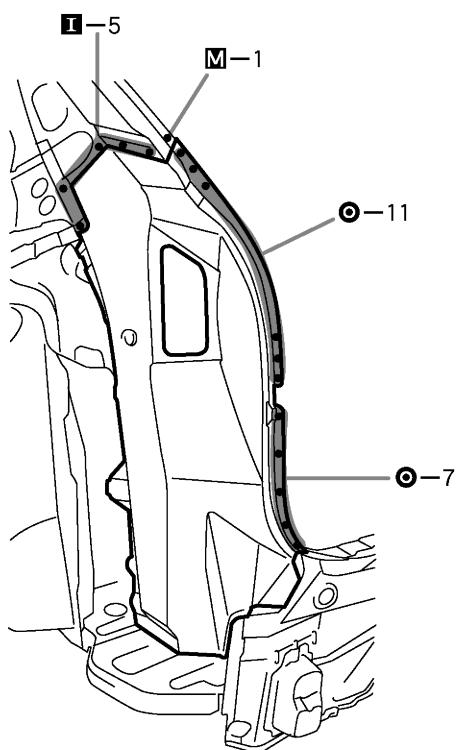
F14879-A

REMOVAL

F14879

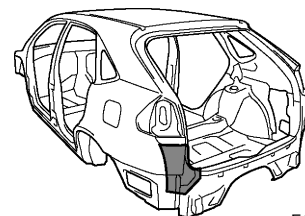
INSTALLATION

- 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.

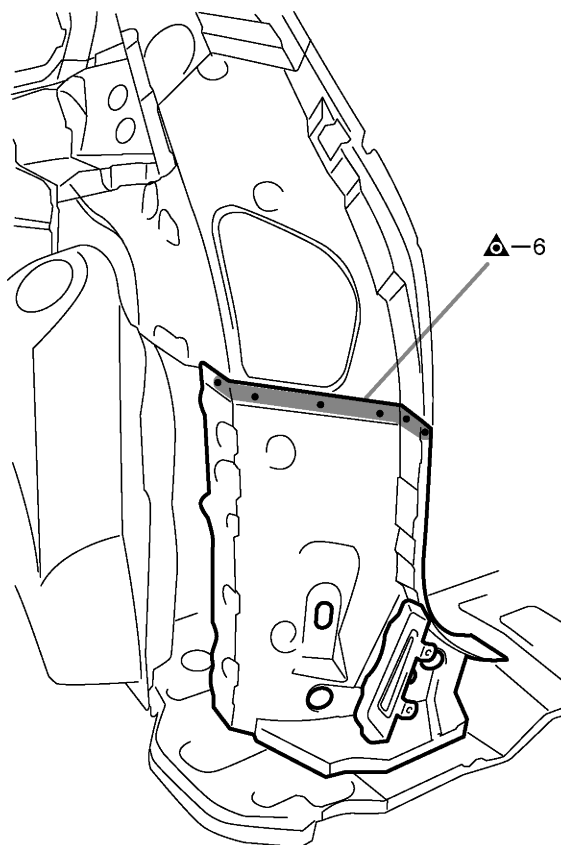


ROOF SIDE INNER FRONT PANEL (ASSY)**REPLACEMENT**

With the body lower back panel and roof side inner rear panel removed.



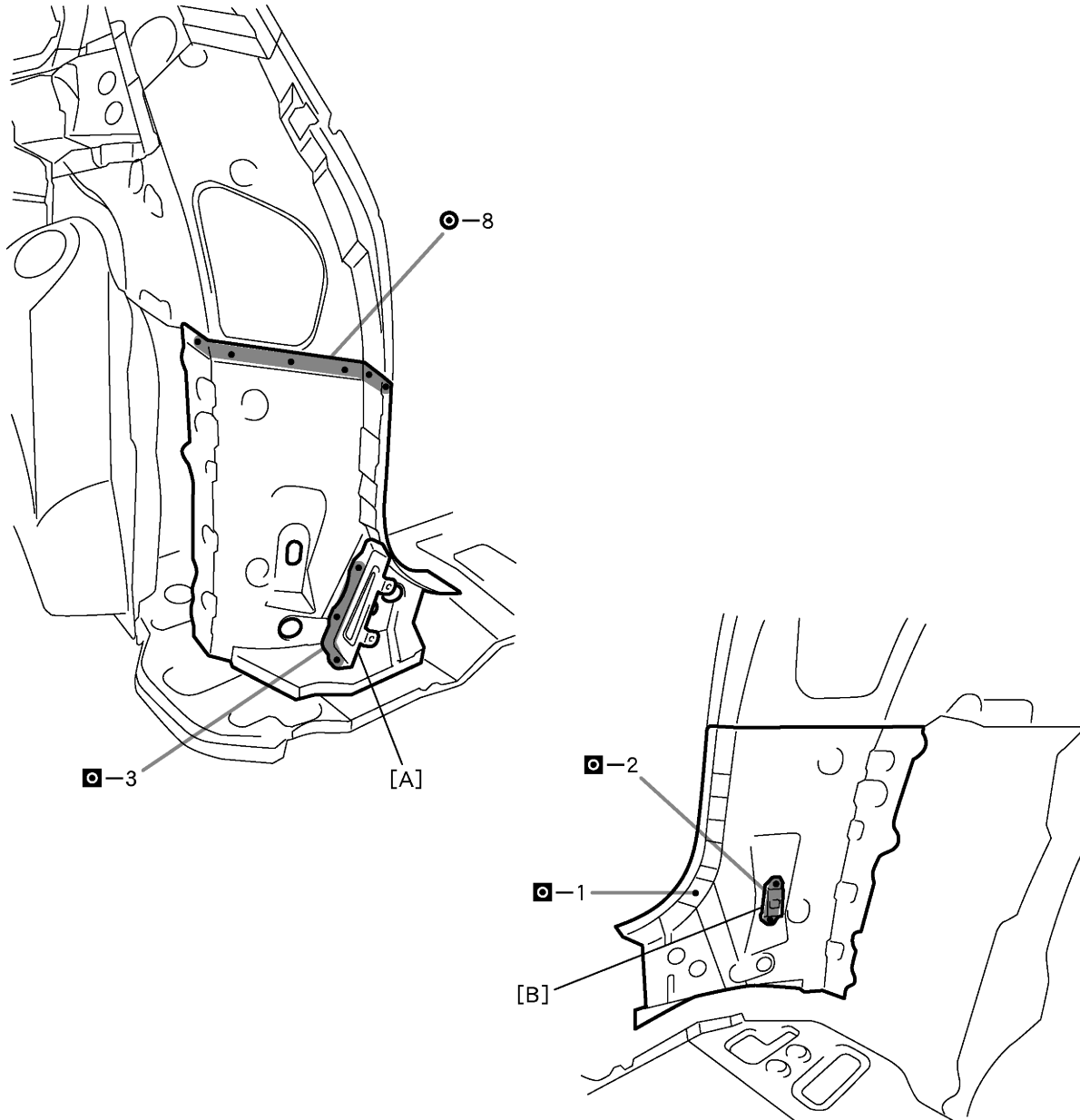
F14881-A

REMOVAL

F14881

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.

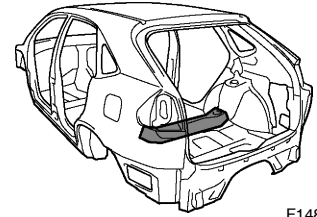


F14882

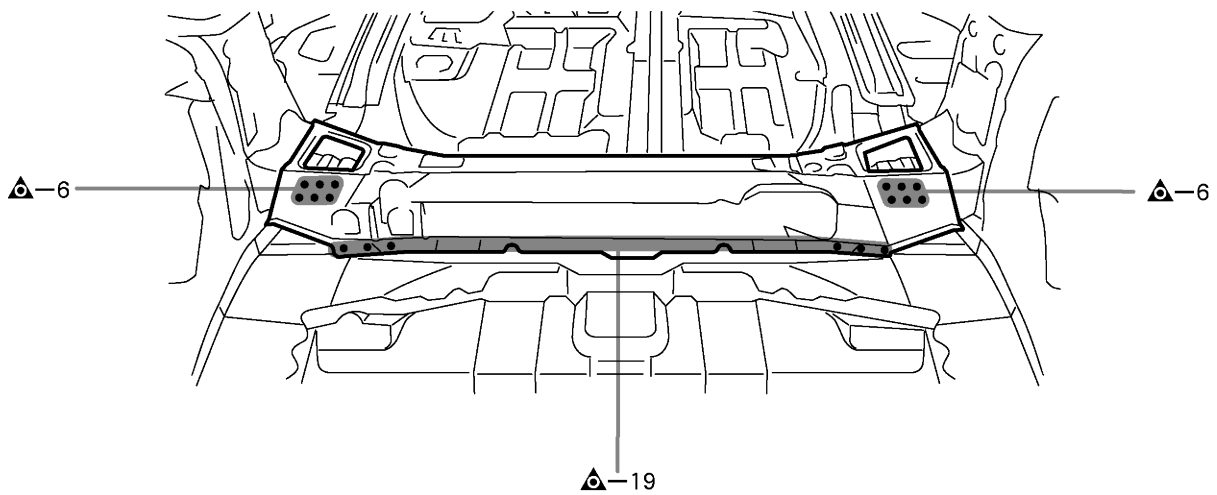
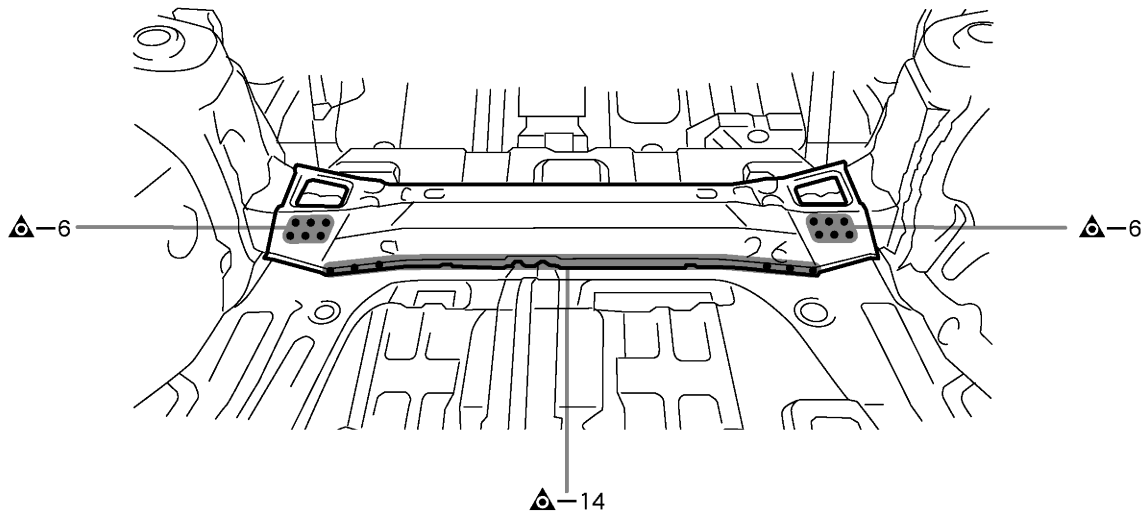
PART NAME

[A] Back Door Opening Side Reinforcement

[B] Rope Hook Bar No.1 Bracket

**REAR FLOOR CENTER CROSSMEMBER
(ASSY)****REPLACEMENT**

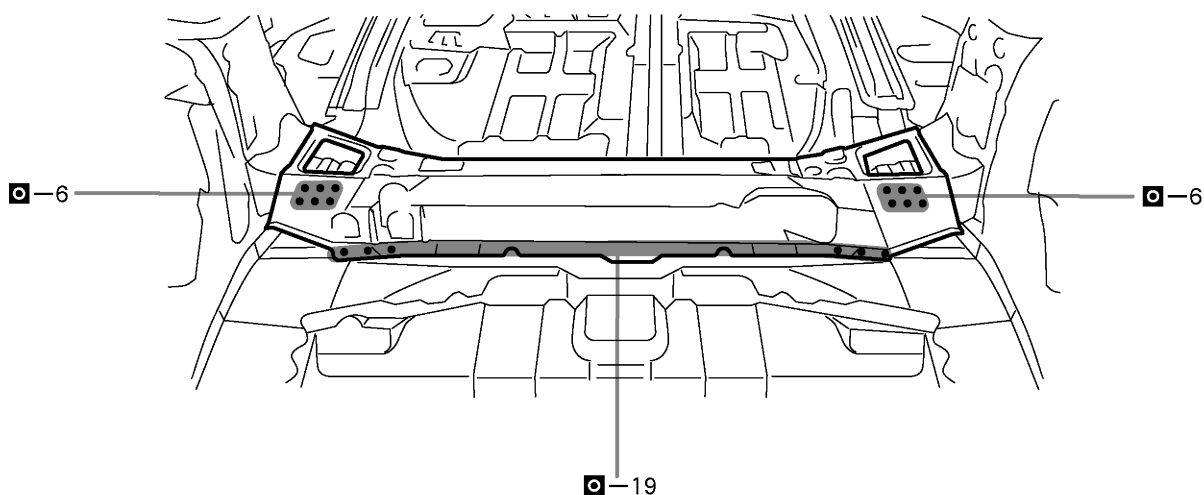
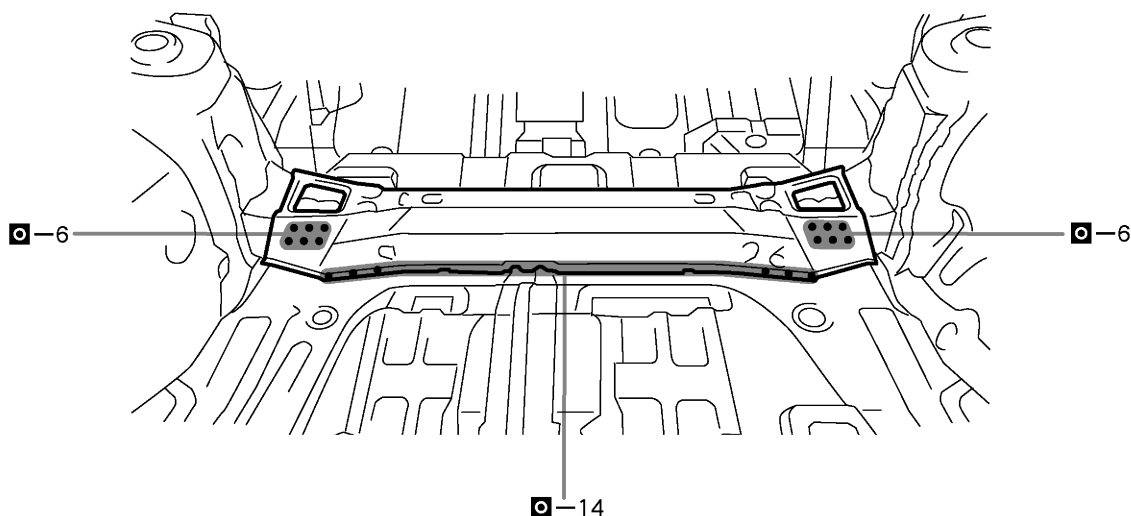
F14883-A

REMOVAL

F20659

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.



REAR FLOOR PAN (CUT)

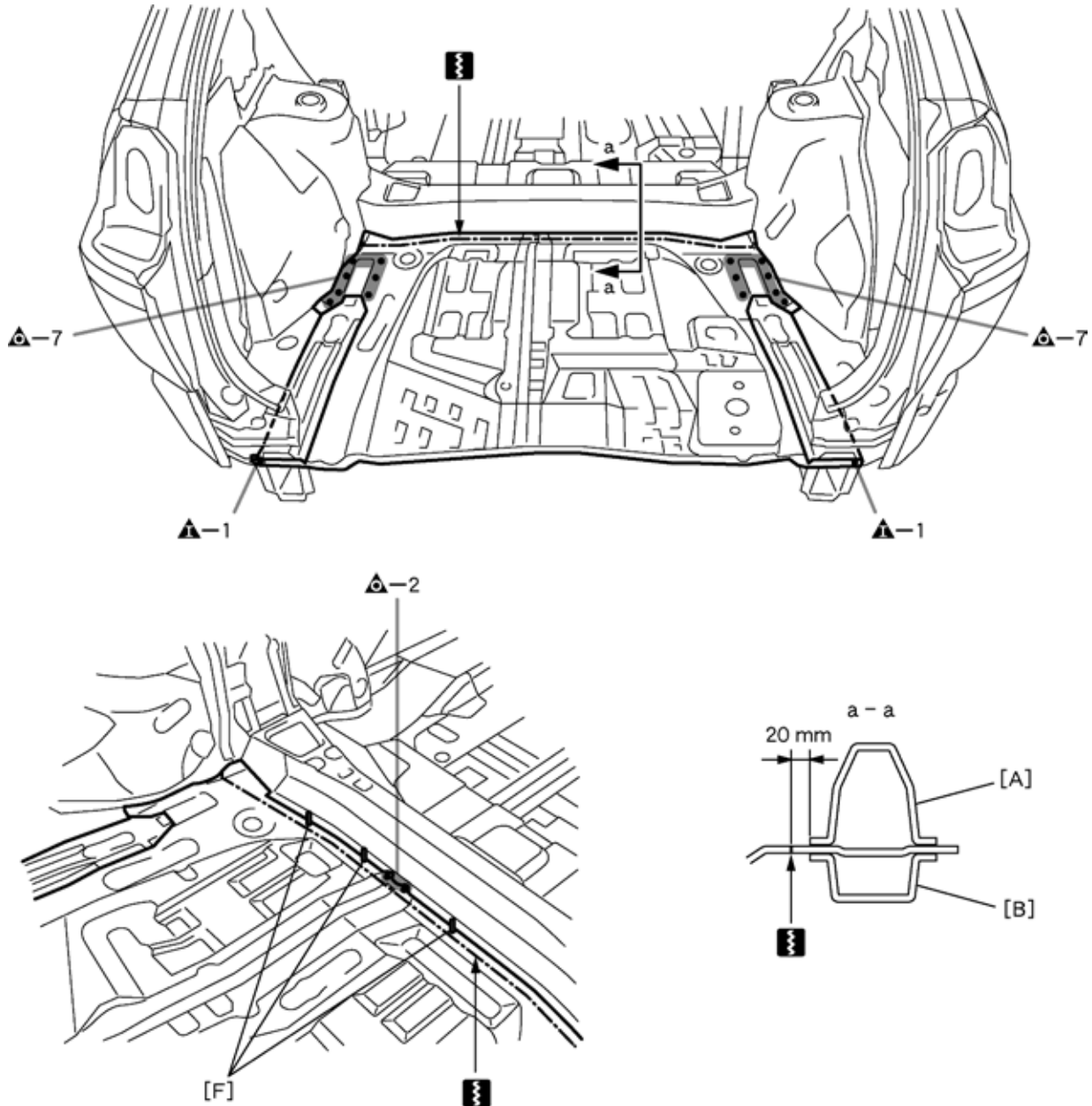
REPLACEMENT

With the body lower back panel removed.



F12092-A

REMOVAL



F20702

POINT

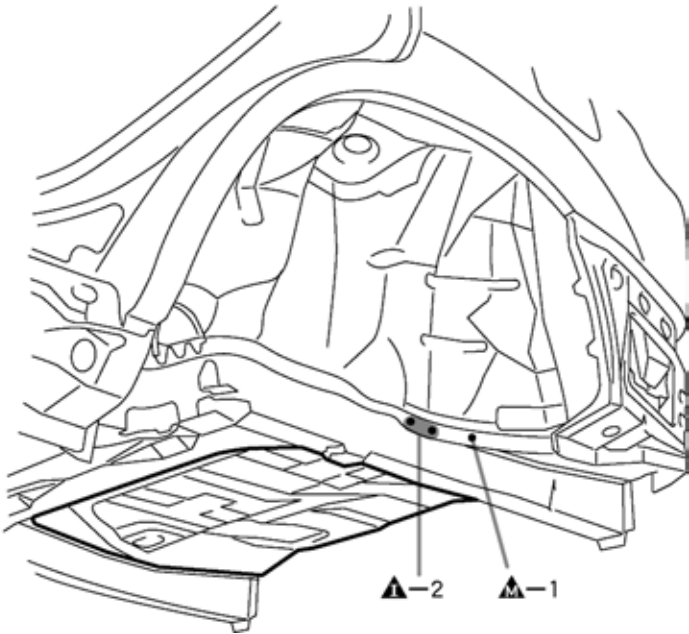
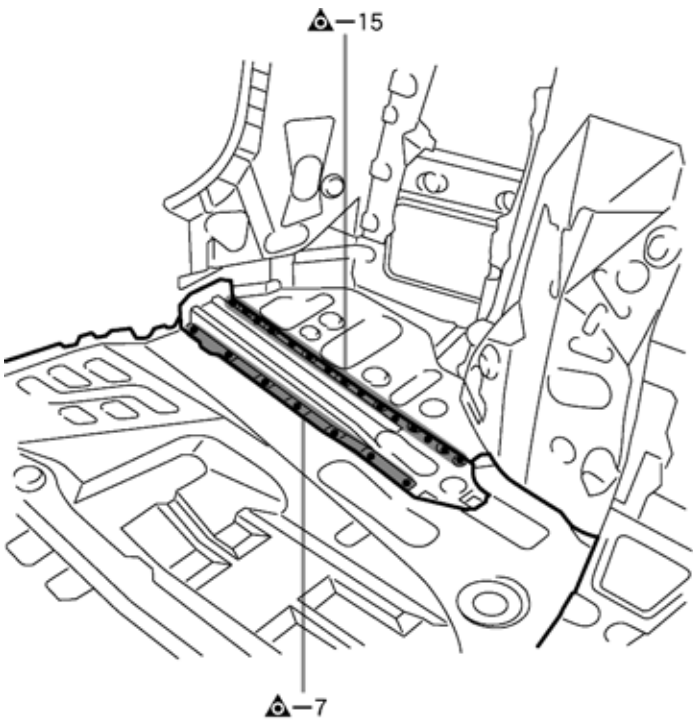
1 Remove the [F] at the same time.

PART NAME

[A] Rear Floor Center Crossmember
20 mm (0.79 in.)

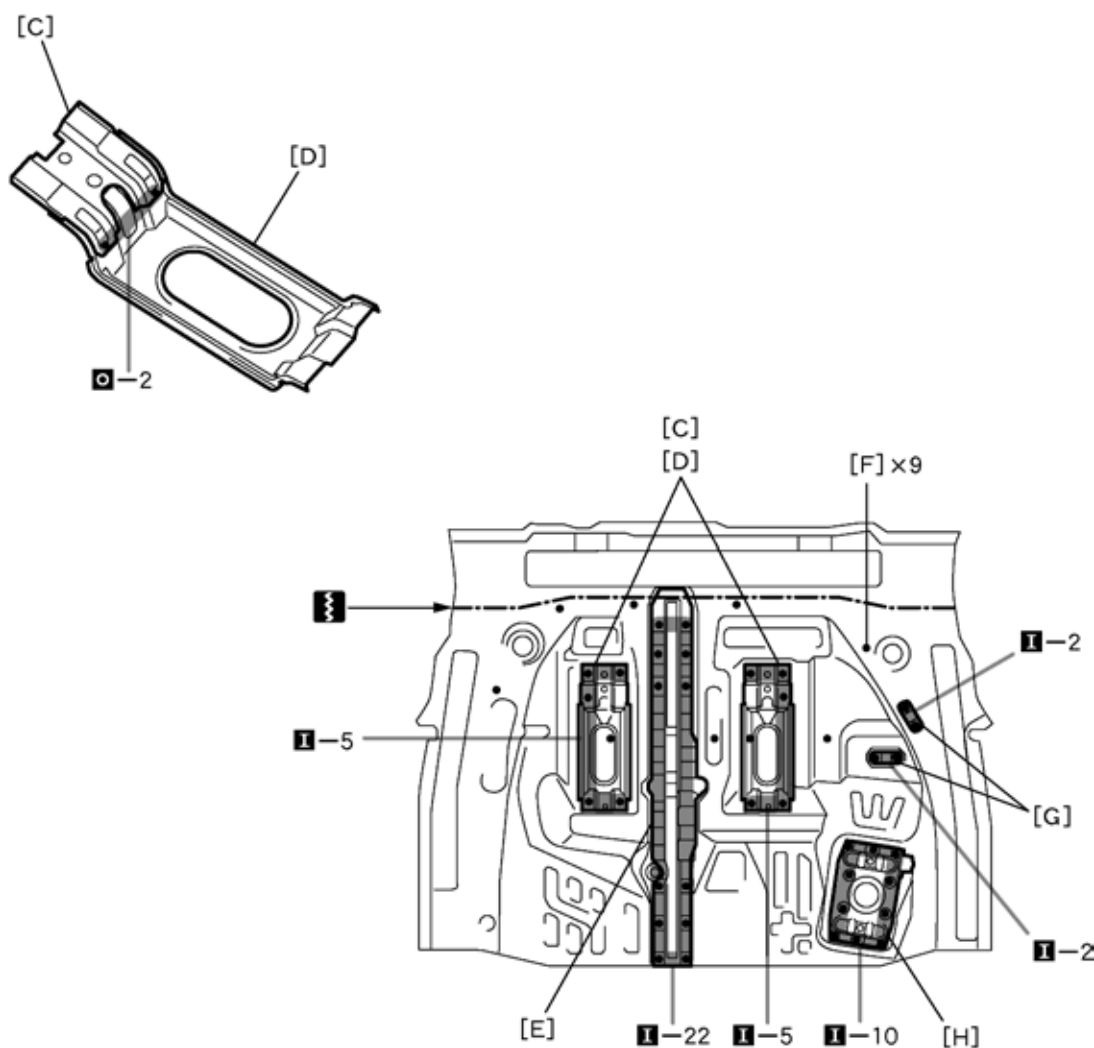
[B] Rear Floor No.2 Crossmember

[F] Weld Bolt



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.



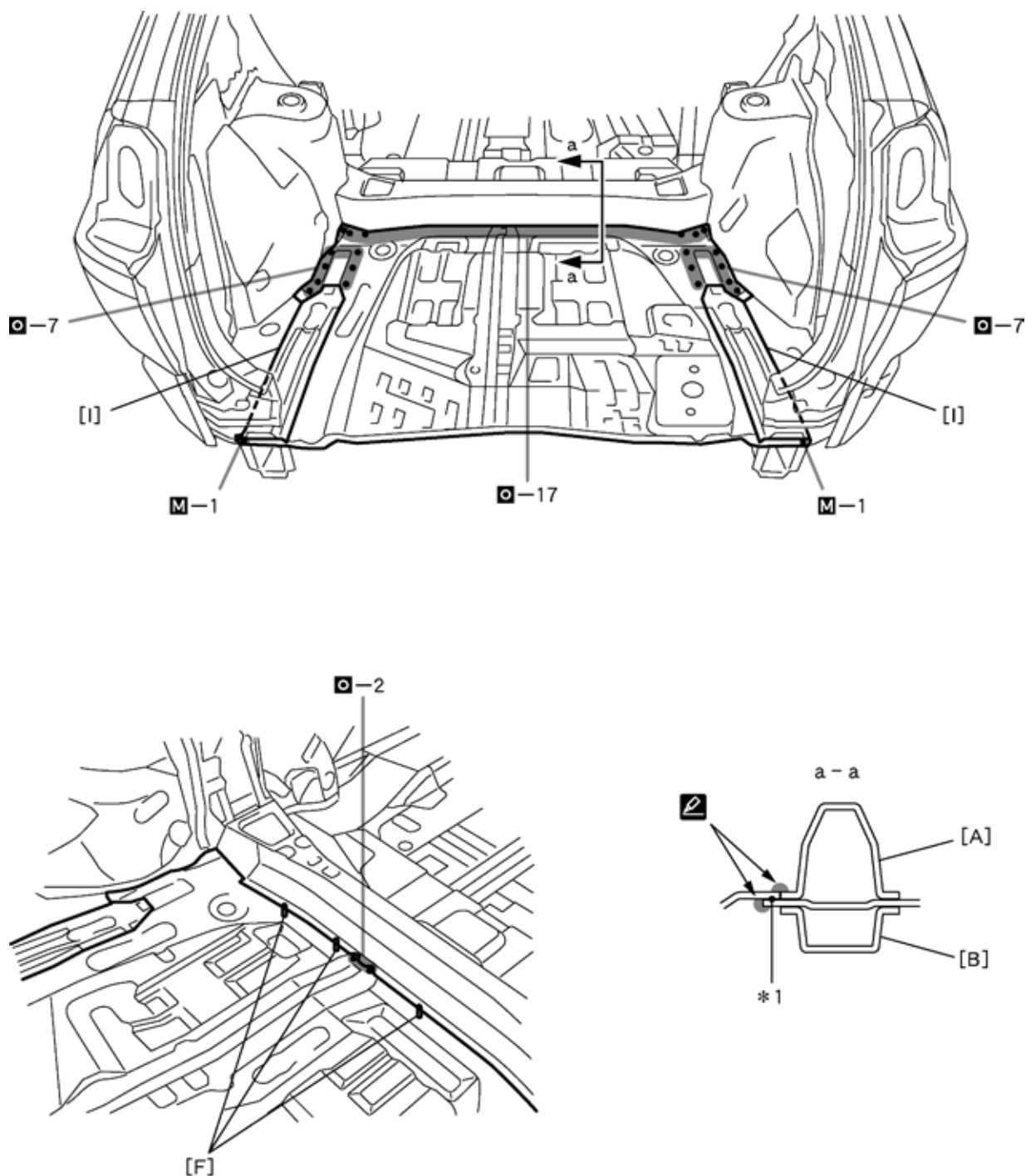
F20661

POINT

- 1 Cut the new parts so that it overlaps the previous cut location by approximately 20 mm (0.79 in.).
- 2 Attach the [F] to center of the bearing surface.

PART NAME

- | | |
|--|---------------------------------|
| [C] Rear Floor Side Panel Rear Extension | [D] Rear Floor Panel Extension |
| [E] Rear Floor Pan No.2 Extension | [F] Weld Bolt |
| [G] Rear Floor Heat Insulator No.3 Bracket | [H] Spare Wheel Carrier Bracket |



F20704

POINT

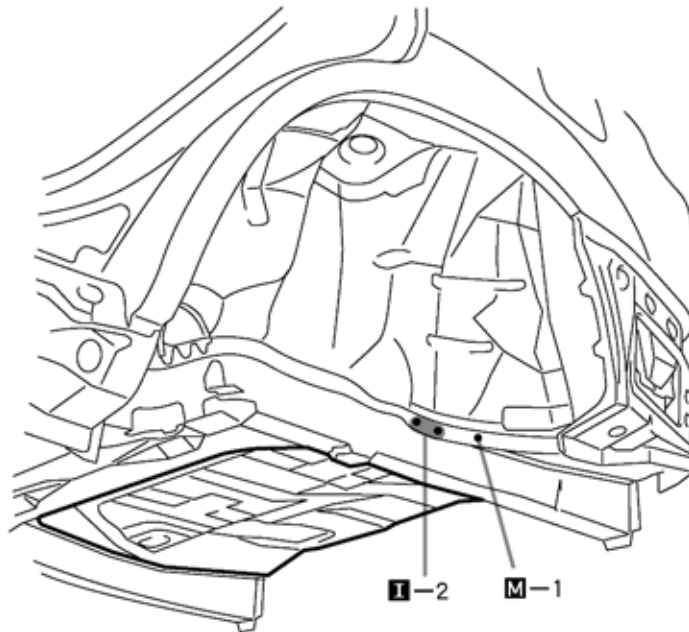
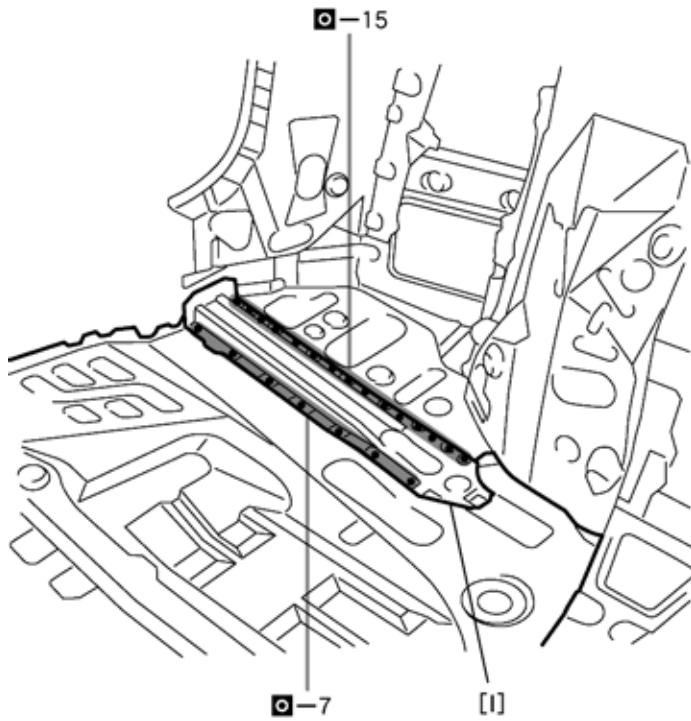
- 1 *1: Plug weld the overlapping portion of the new part.

HINT:

- 1) *Be sure that the portion to be welded are aligned and not loose.*
 2) Coat the overlapping opening portion from the both sides with body sealer.

PART NAME

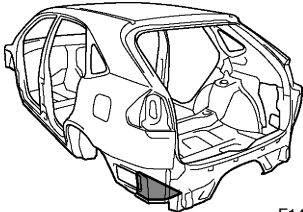
- | | | | | | |
|-----|-------------------------------------|-----|-----------------------------|-----|-----------|
| [A] | Rear Floor Center Crossmember | [B] | Rear Floor No.2 Crossmember | [F] | Weld Bolt |
| [I] | Rear Floor Panel No.1 Reinforcement | | | | |



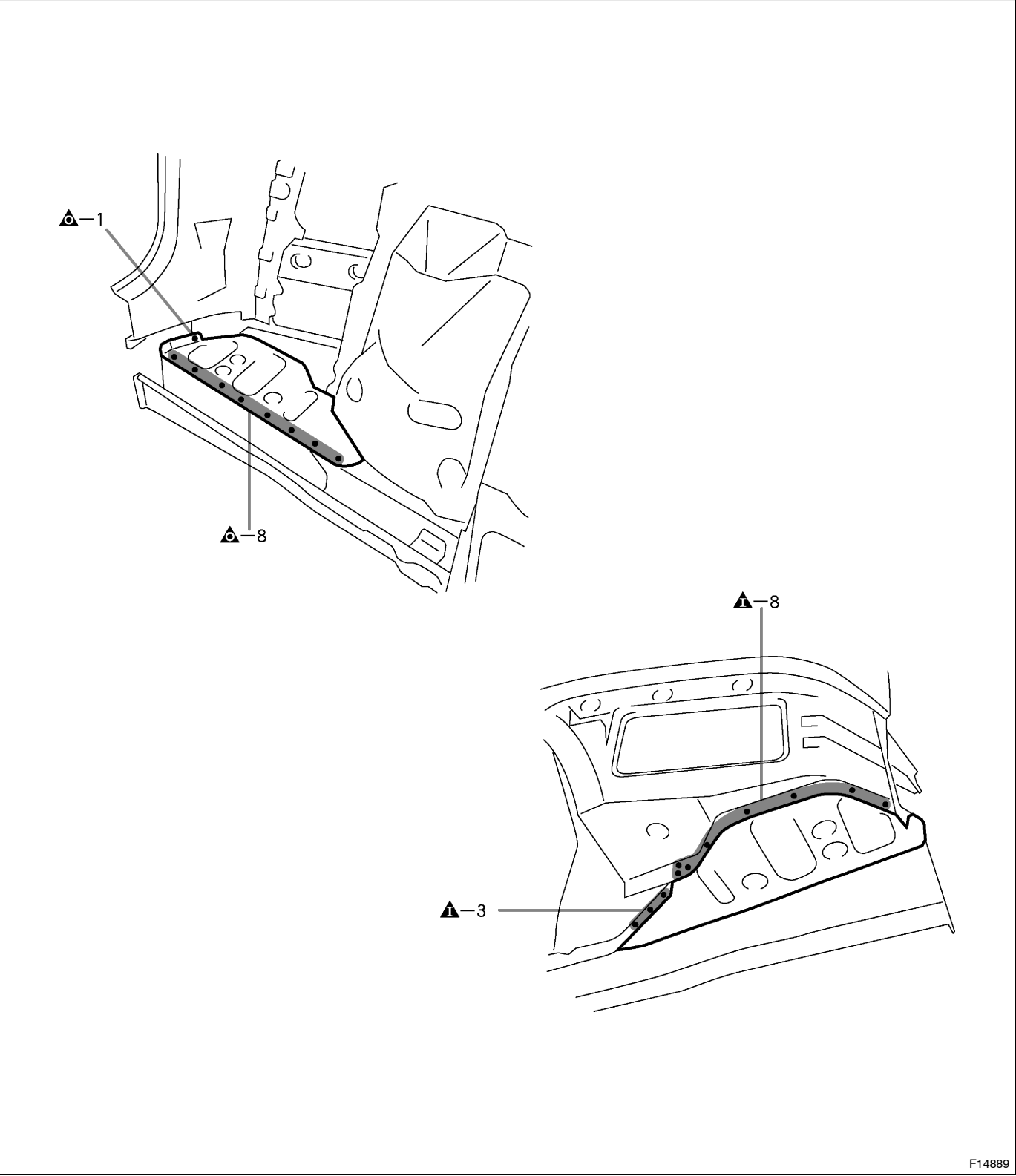
F20705

PART NAME

[I] Rear Floor Panel No.1 Reinforcement

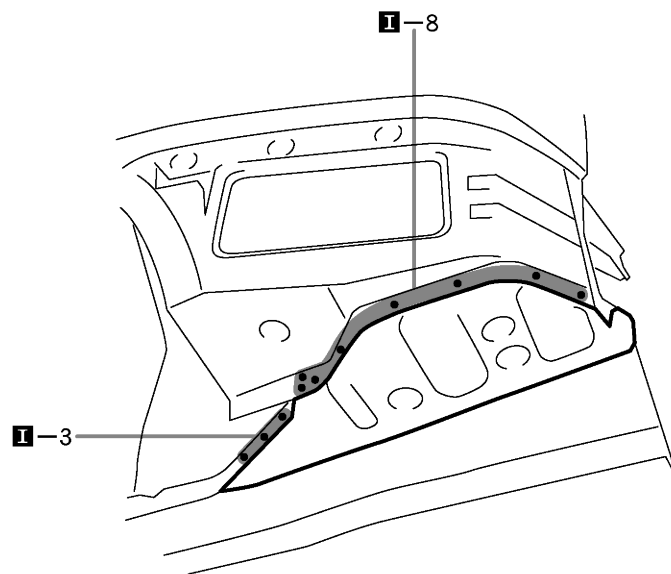
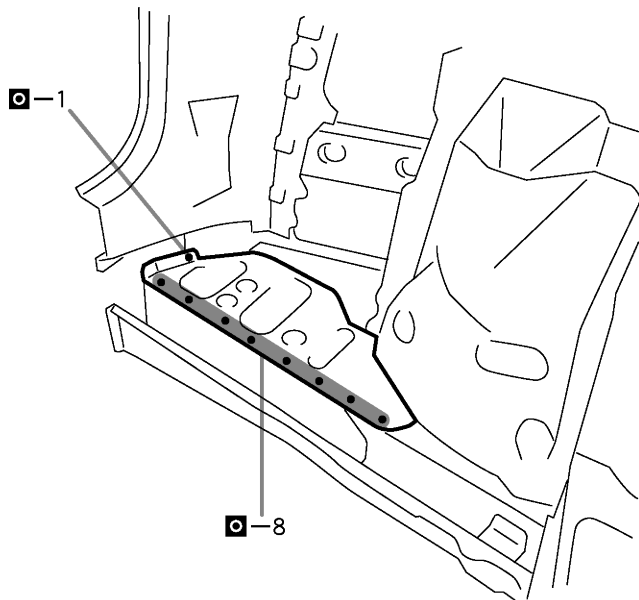
REAR FLOOR SIDE PANEL (ASSY)	 F14889-A
REPLACEMENT With the rear floor pan removed.	

REMOVAL



INSTALLATION

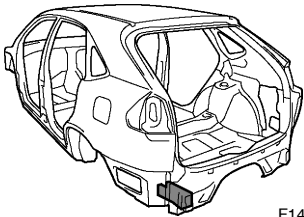
- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply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



REAR FLOOR NO.3 CROSSMEMBER (CUT-H)

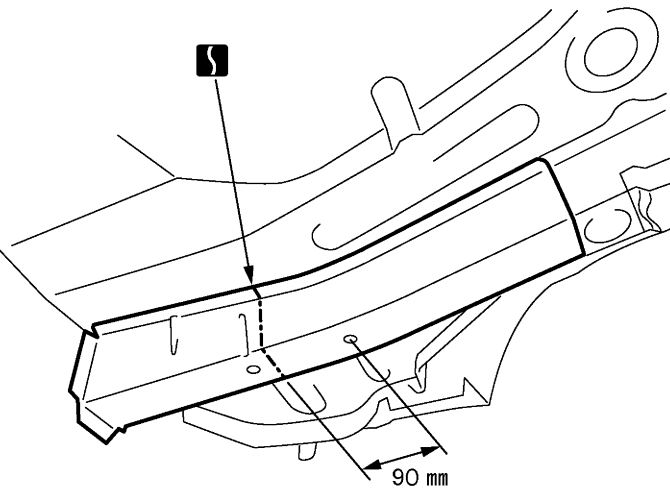
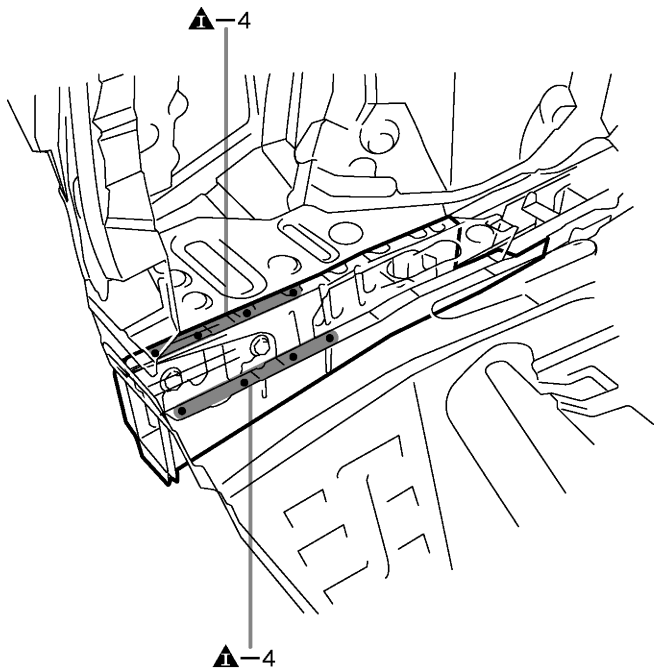
REPLACEMENT

With the body lower back panel removed.



F14818-A

REMOVAL

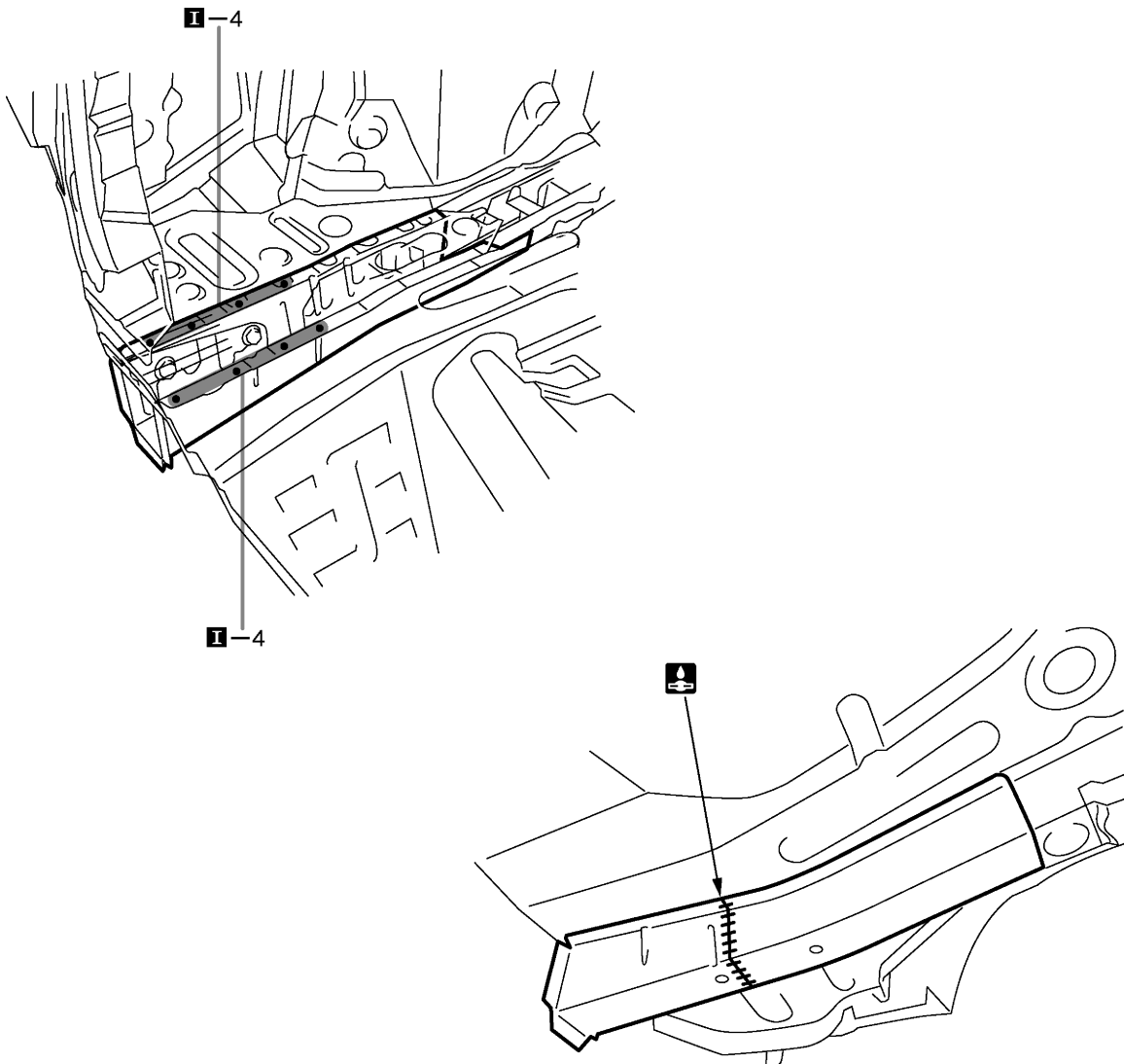


F20719

90 mm (3.54 in.)

INSTALLATION

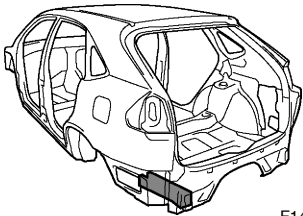
- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply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



REAR FLOOR NO.3 CROSSMEMBER (ASSY)

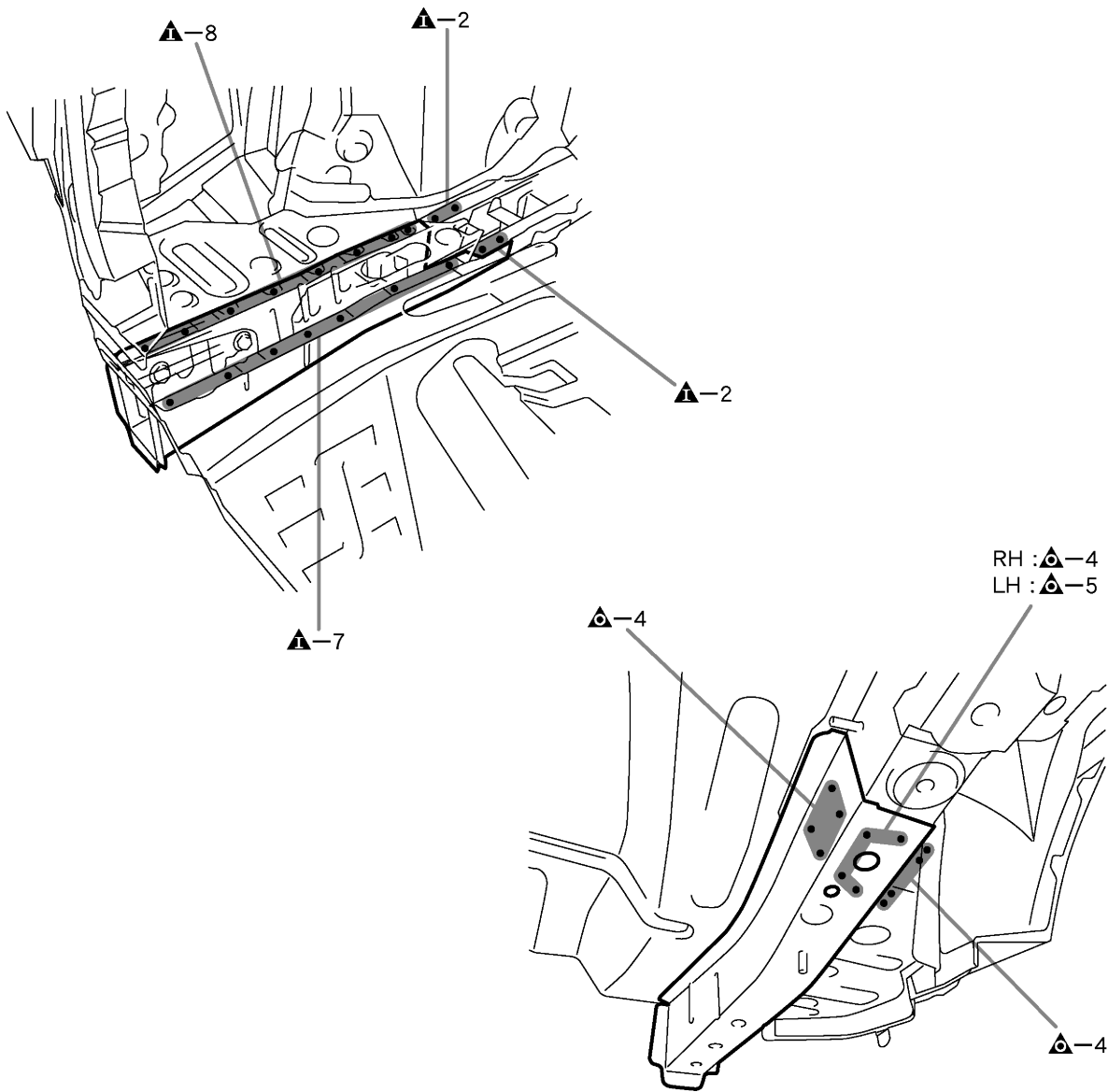
REPLACEMENT

With the body lower back panel removed.



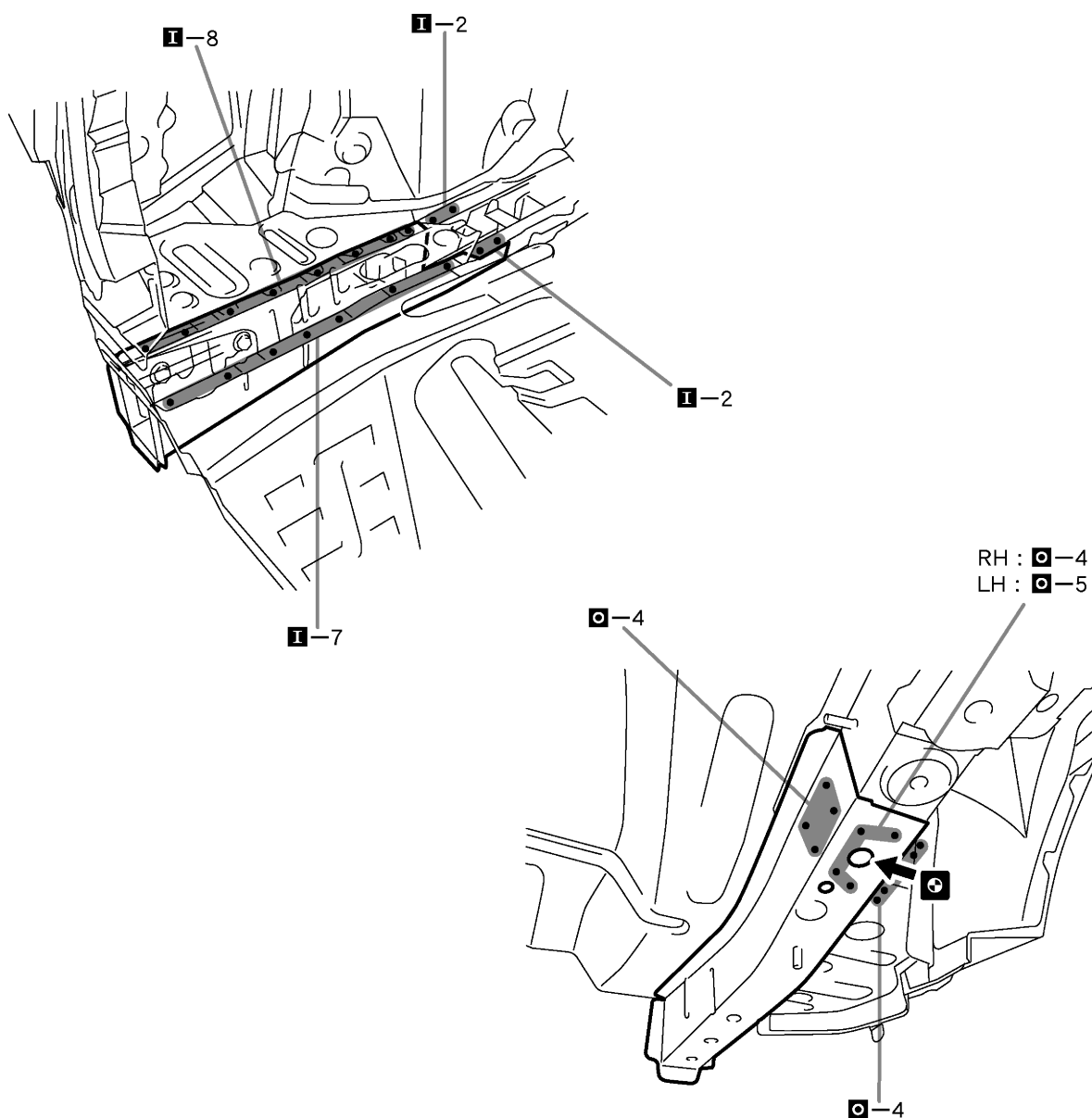
F14891-A

REMOVAL



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.



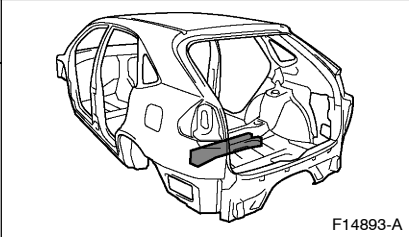
F20721

POINT

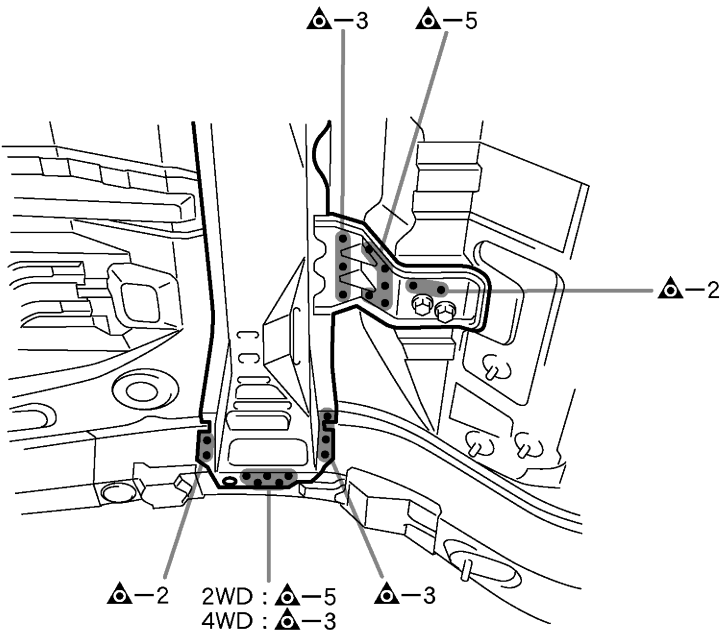
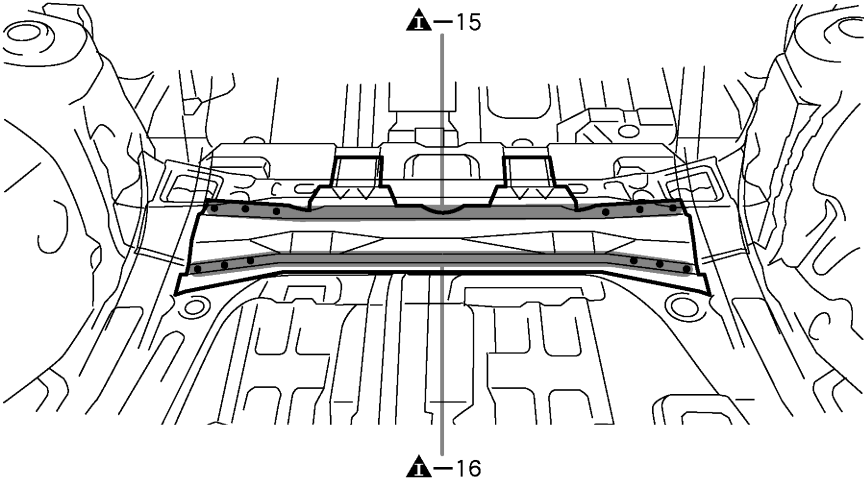
- 1 When temporarily installing the new parts, determine the installation position by the assembly mark.

REAR FLOOR NO.2 CROSSMEMBER (ASSY)

REPLACEMENT

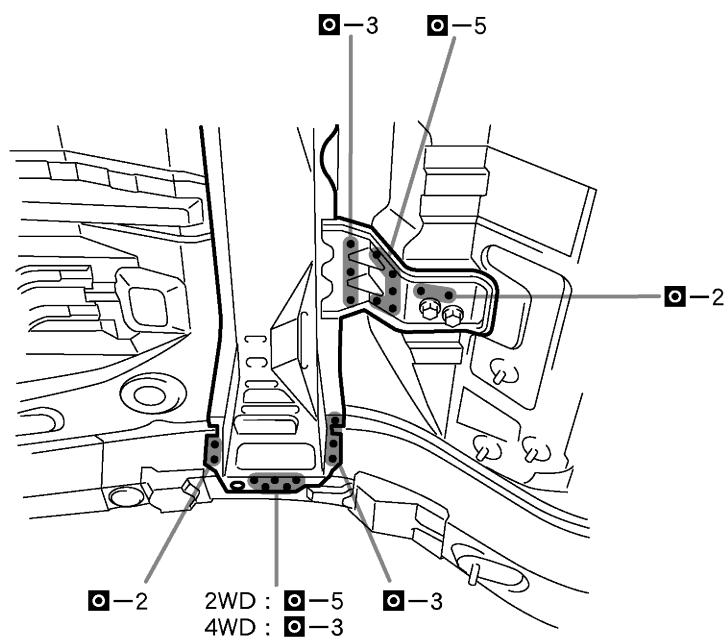
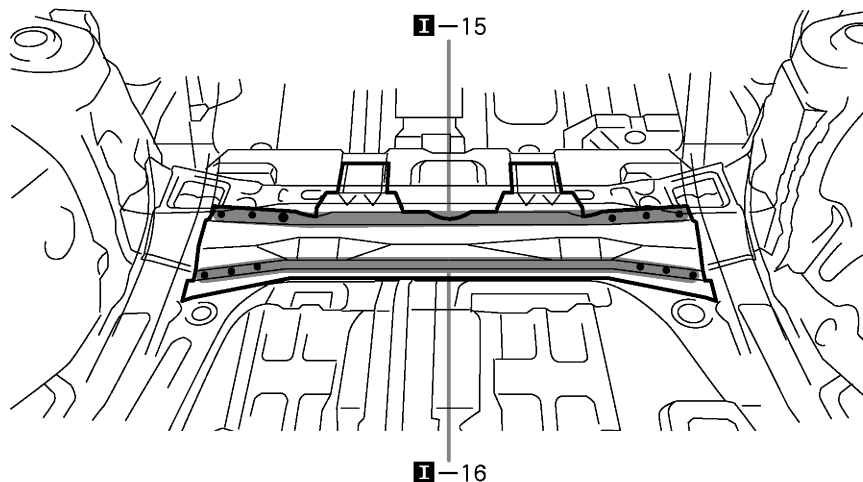


REMOVAL



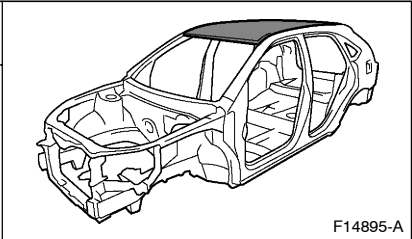
INSTALLATION

- 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.



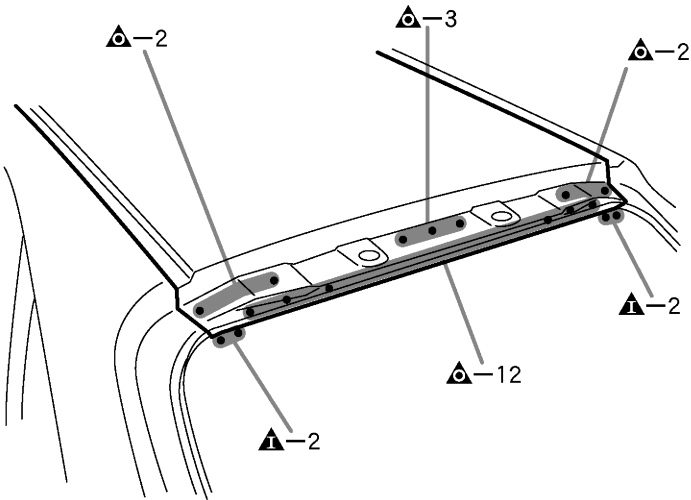
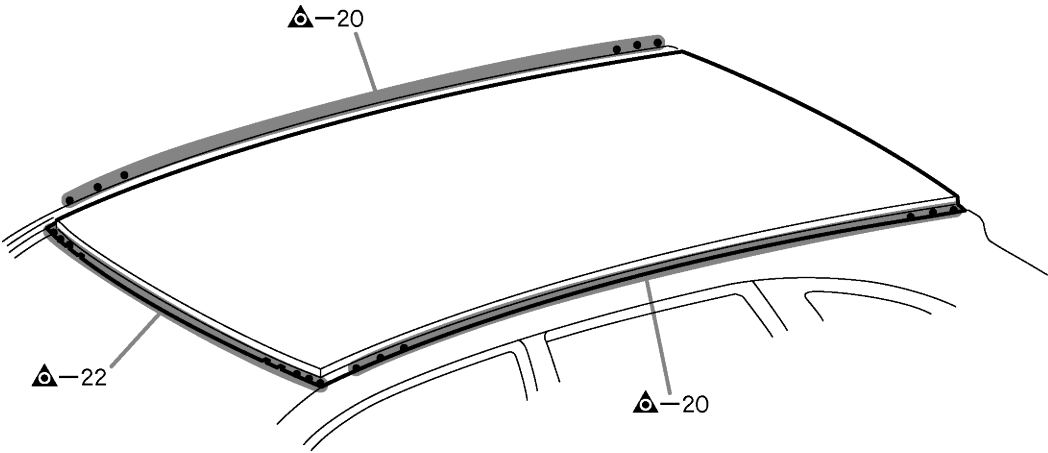
ROOF PANEL (ASSY): w/o Moon Roof

REPLACEMENT



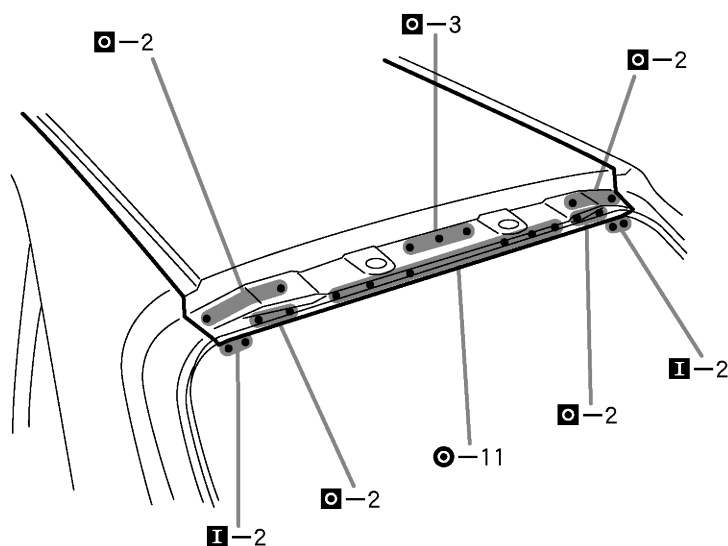
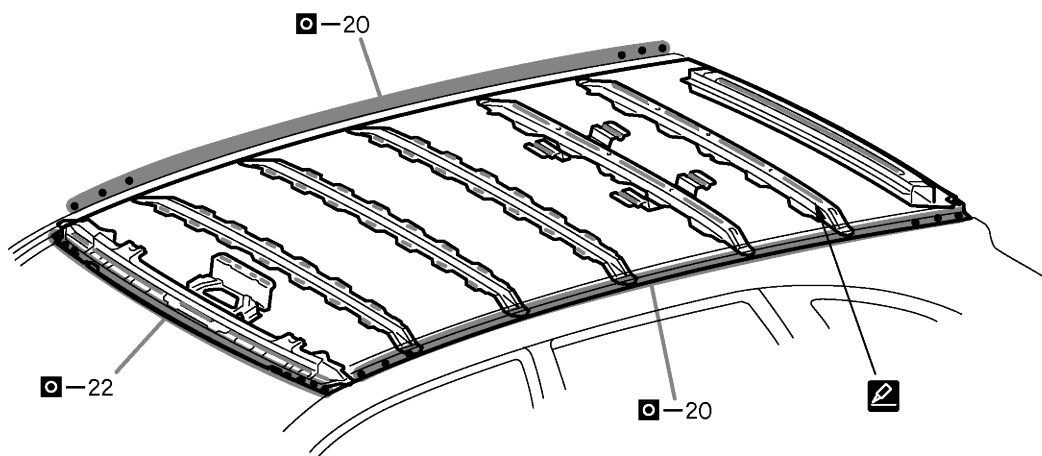
F14895-A

REMOVAL



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.



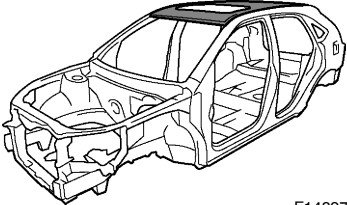
F20723

POINT

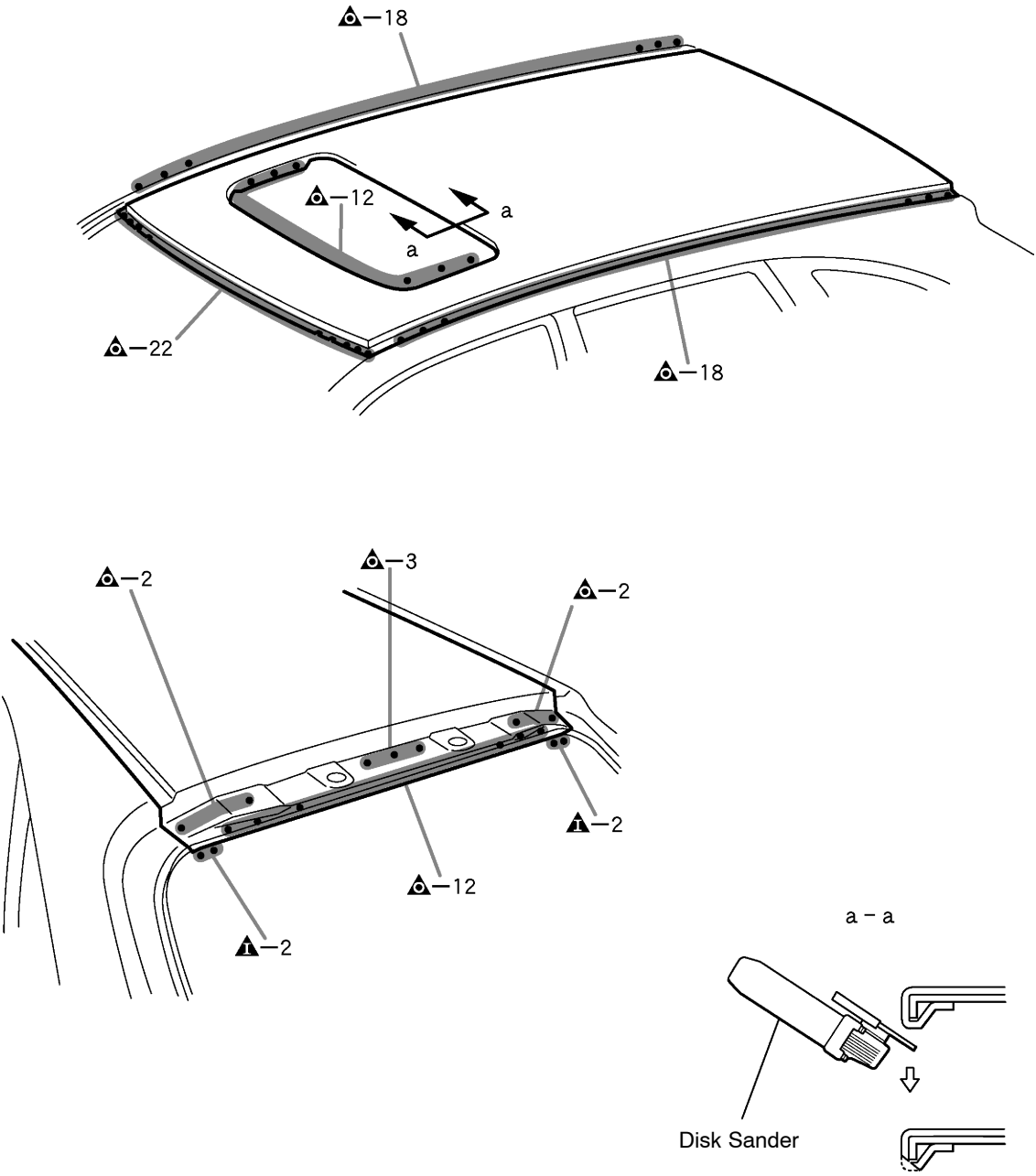
- 1 Before temporarily installing the new parts, apply body sealer to the windshield header panel, roof panel reinforcement and back door opening frame.

HINT:

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

ROOF PANEL (ASSY): w/ Moon Roof	 F14897-A
REPLACEMENT	

REMOVAL



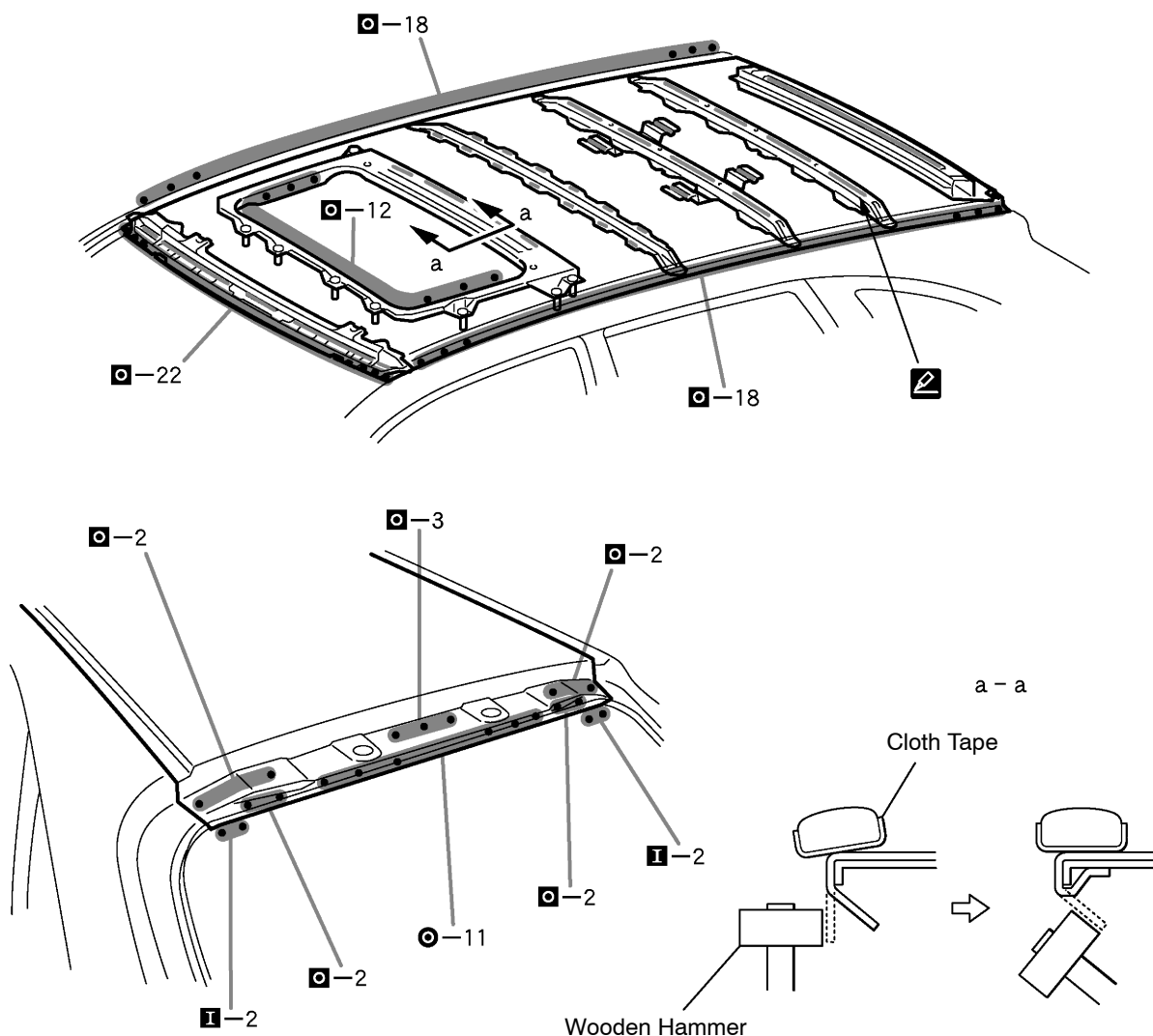
F20724

POINT

- 1 If reusing the roof panel reinforcement, trim the hemming location using a disc sander, etc.

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.

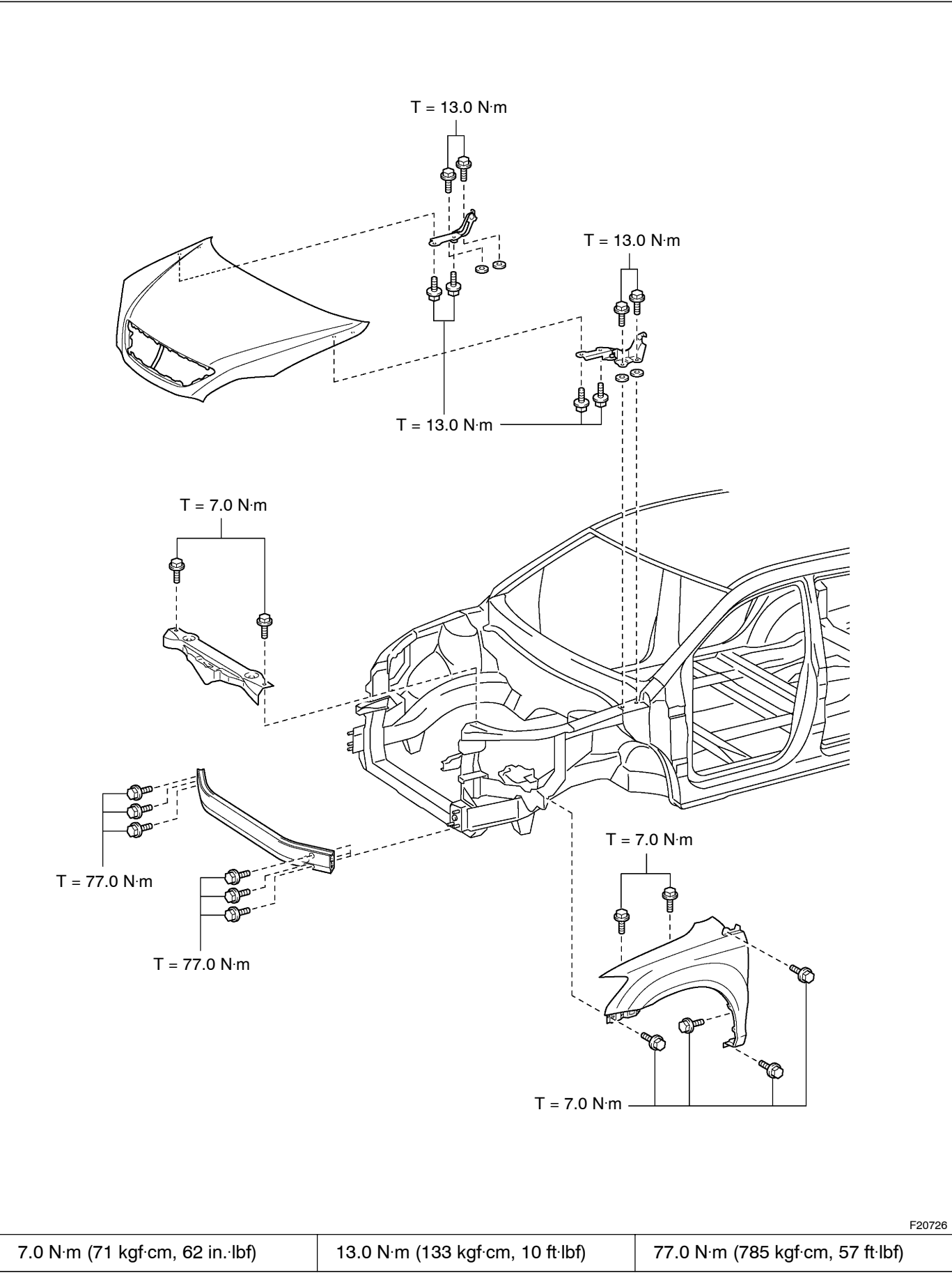


F20725

POINT

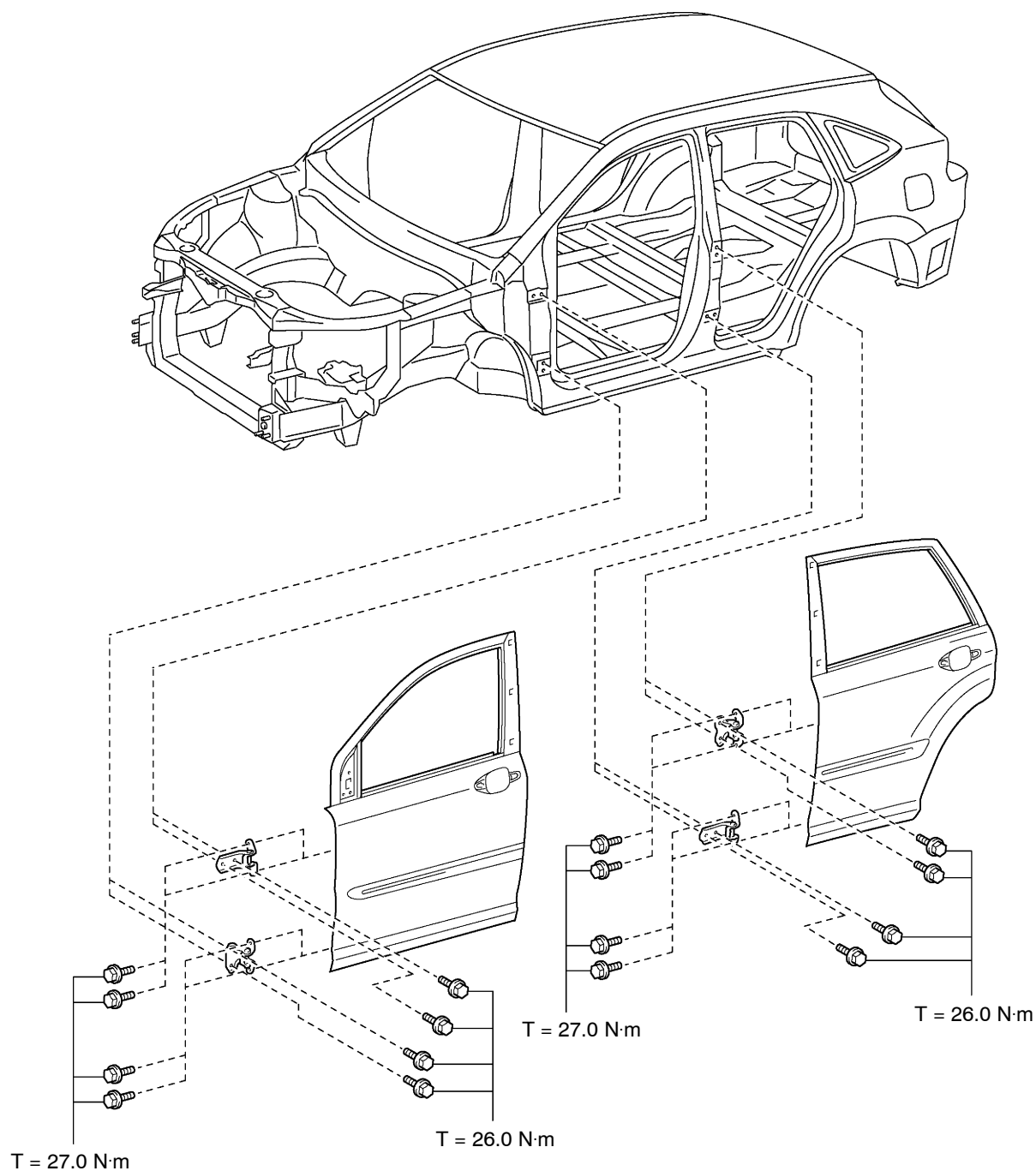
- 1 Before temporarily installing the new parts, apply body sealer to the windshield header panel, roof panel reinforcement and back door opening frame.
HINT:
1) Apply just enough sealer for the new parts to make contact.
- 2 Bend the flange hem with a wooden hammer and dolly.
HINT:
1) Perform hemming three steps, being careful not to warp the panel.

OUTER PANEL INSTALLATION TORQUE



F20726

7.0 N·m (71 kgf·cm, 62 in·lbf)	13.0 N·m (133 kgf·cm, 10 ft·lbf)	77.0 N·m (785 kgf·cm, 57 ft·lbf)
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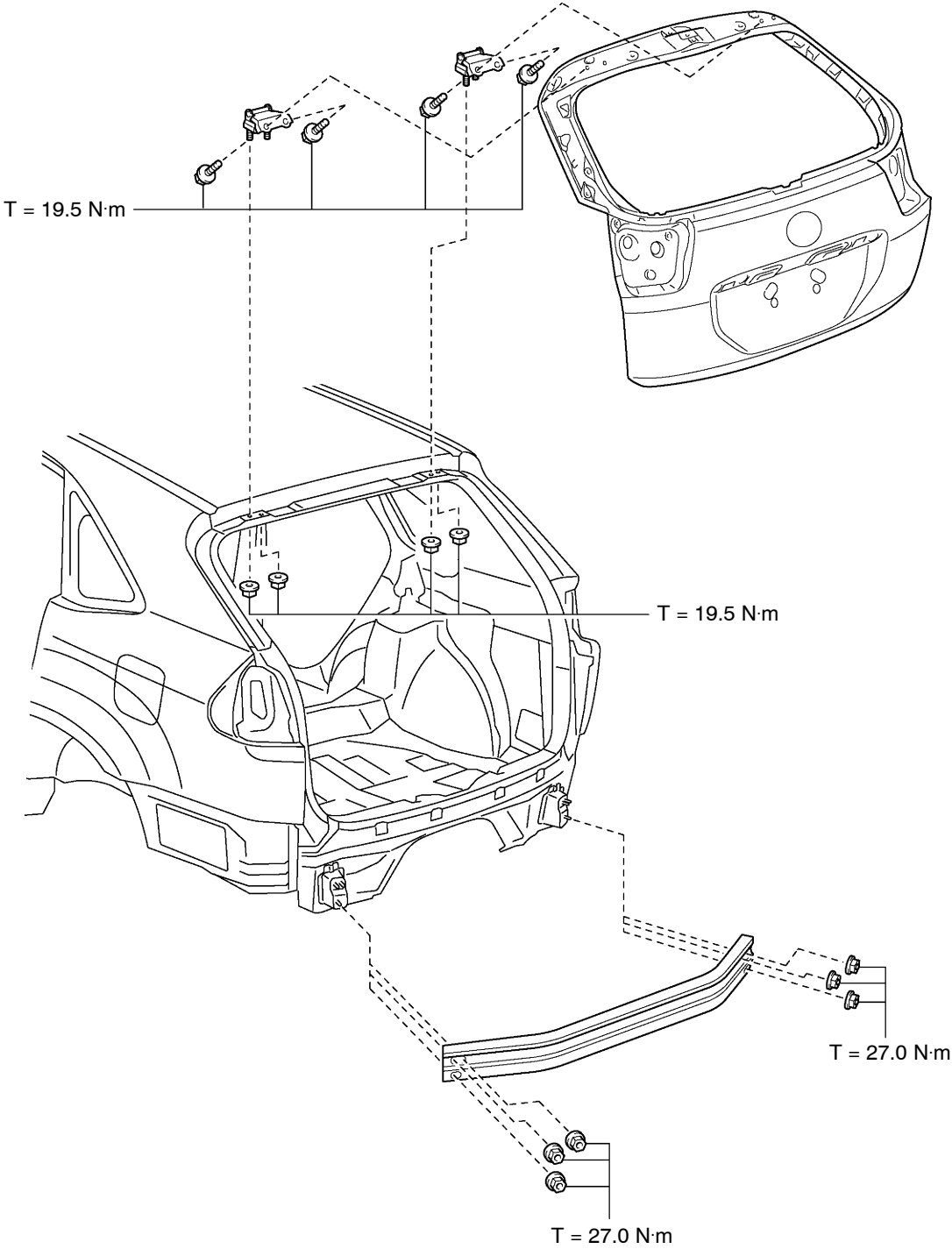


F14814

26.0 N·m (265 kgf·cm, 35 ft·lbf)

27.0 N·m (275 kgf·cm, 37 ft·lbf)

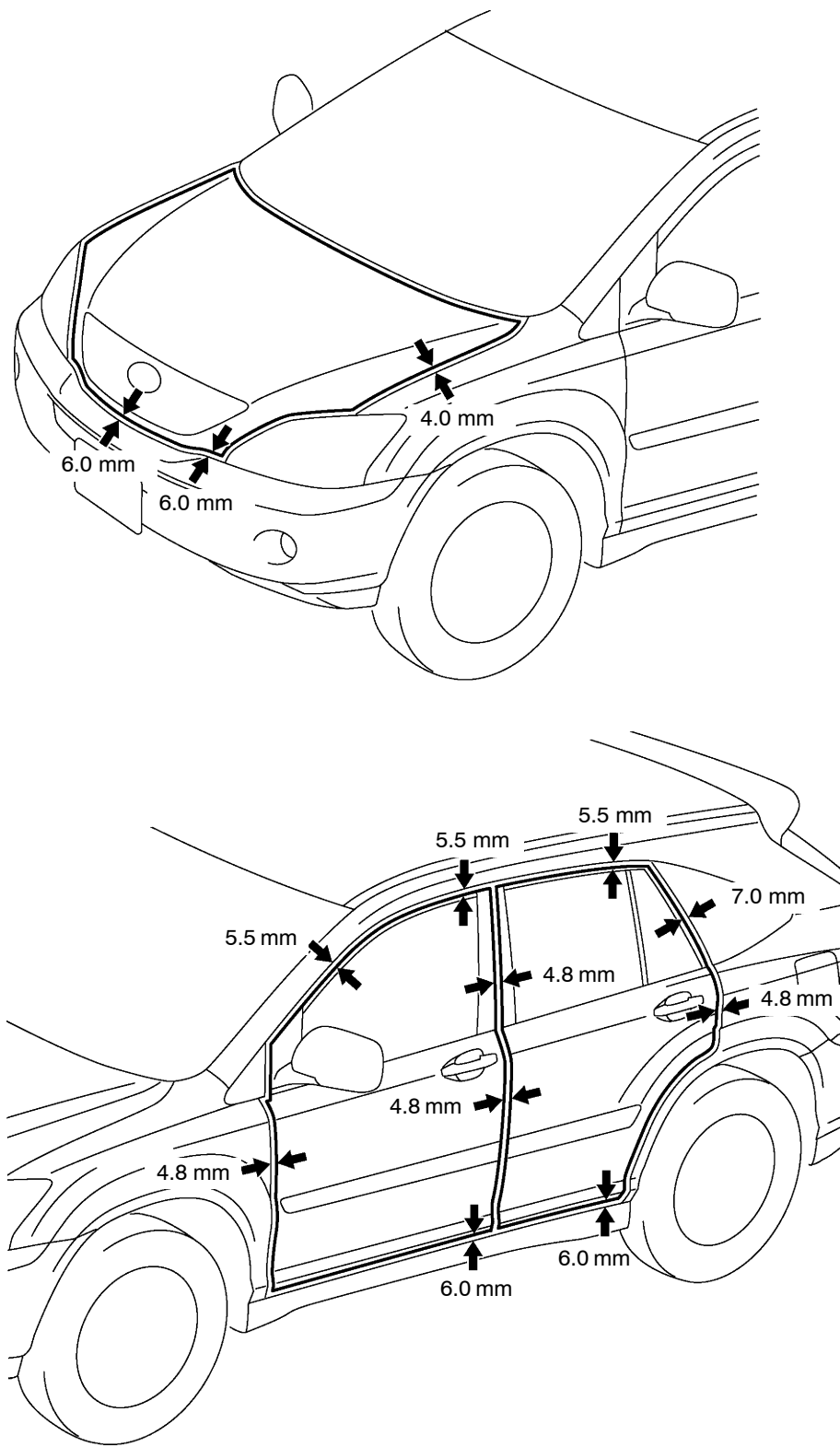
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F20727

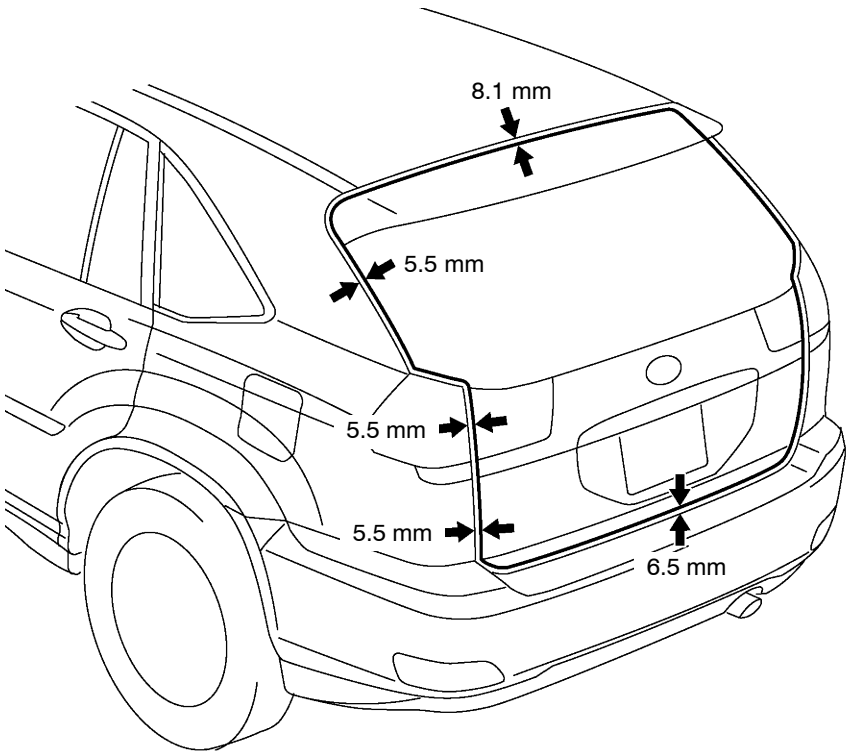
19.5 N·m (199 kgf·cm, 14 ft·lbf)	27.0 N·m (275 kgf·cm, 20 ft·lbf)	—
----------------------------------	----------------------------------	---

FIT STANDARDS



F20706

4.0 mm (0.157 in.)	4.8 mm (0.189 in.)	5.5 mm (0.217 in.)
6.0 mm (0.236 in.)	7.0 mm (0.276 in.)	—



F14812

5.5 mm (0.217 in.)

6.5 mm (0.256 in.)

8.1 mm (0.319 in.)