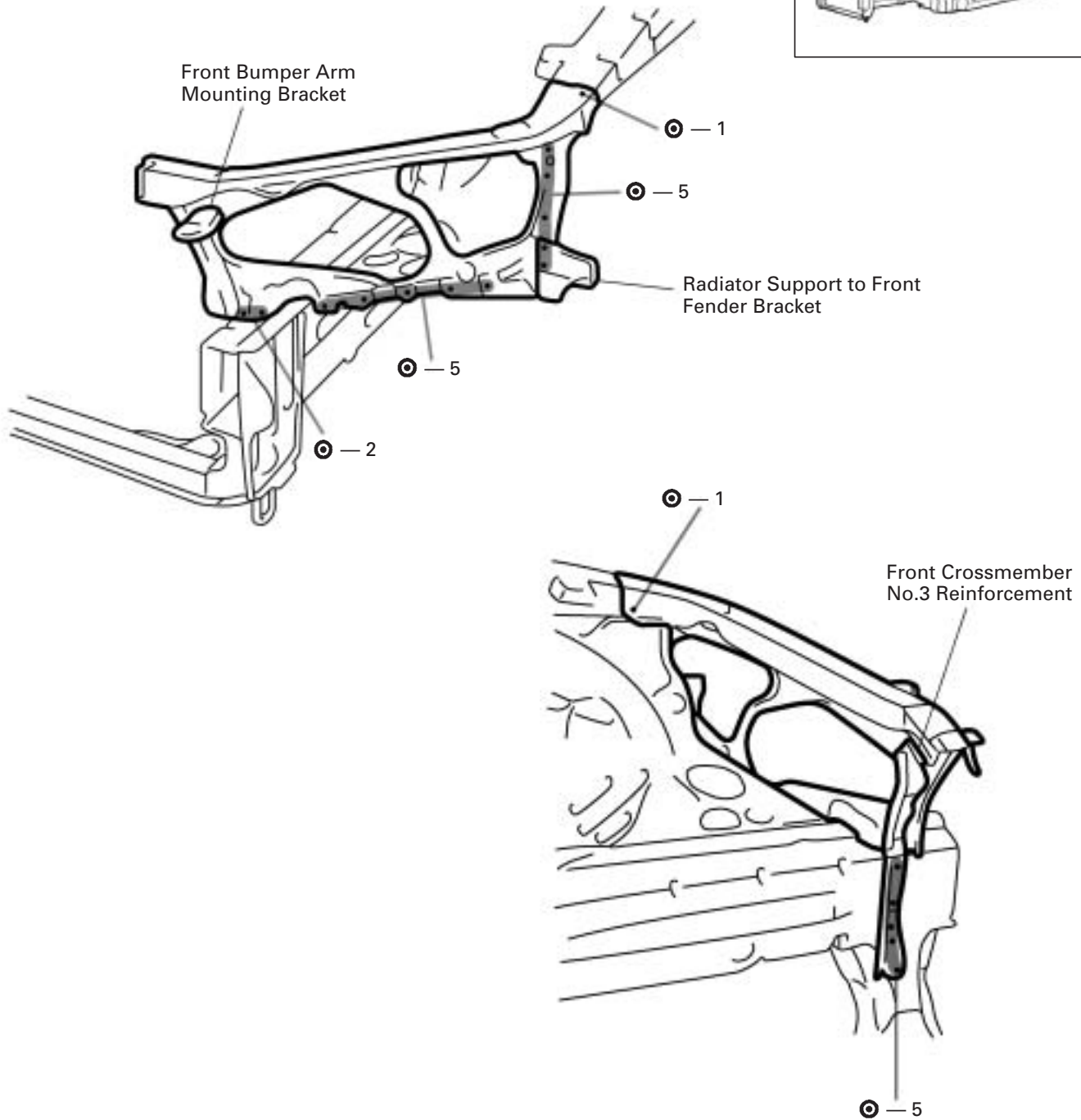
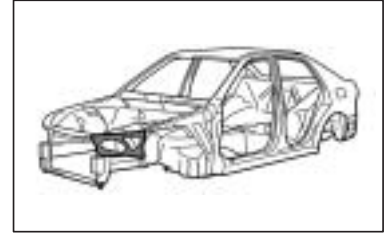


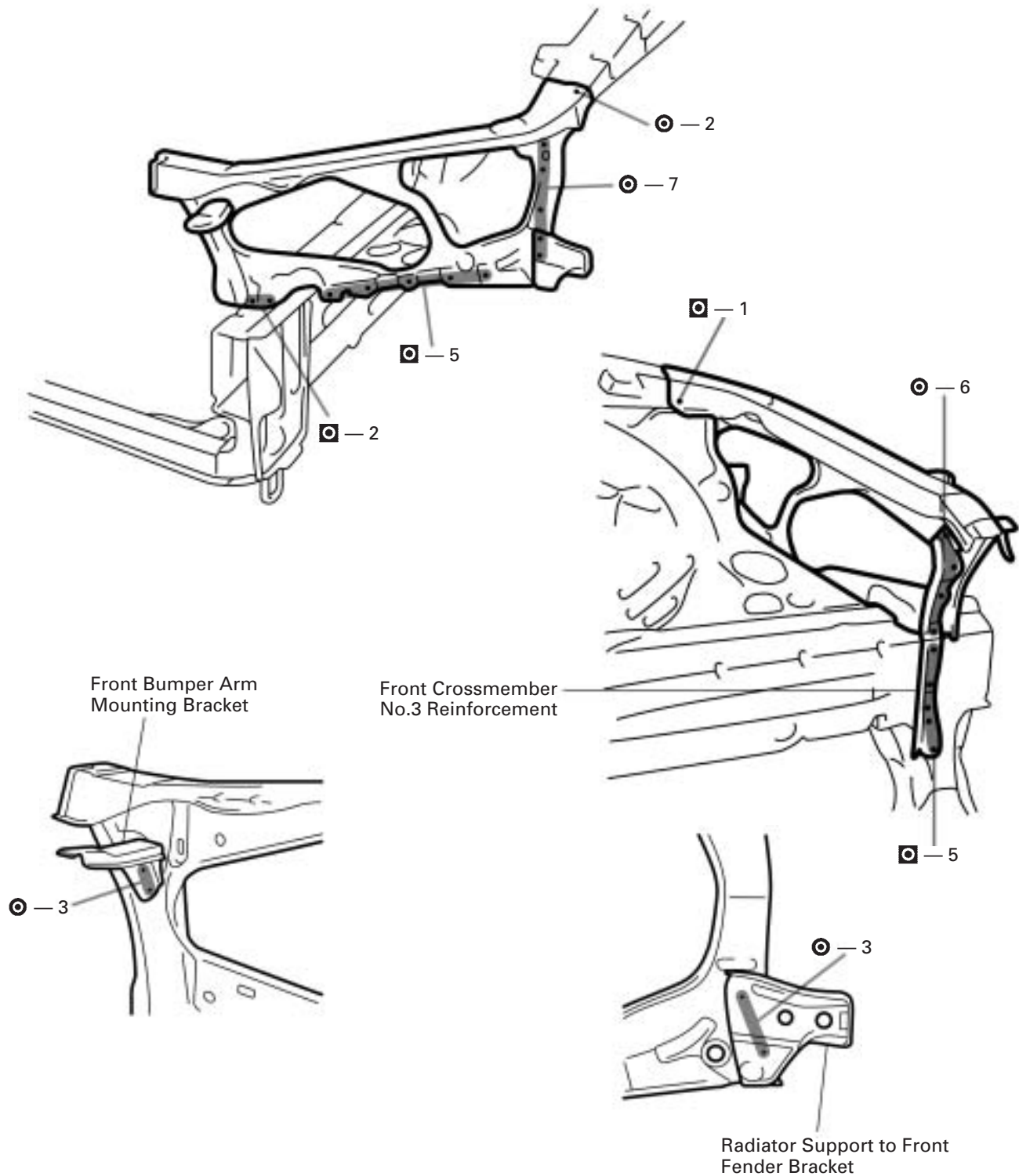
RADIATOR SIDE SUPPORT (ASSY)

REMOVAL



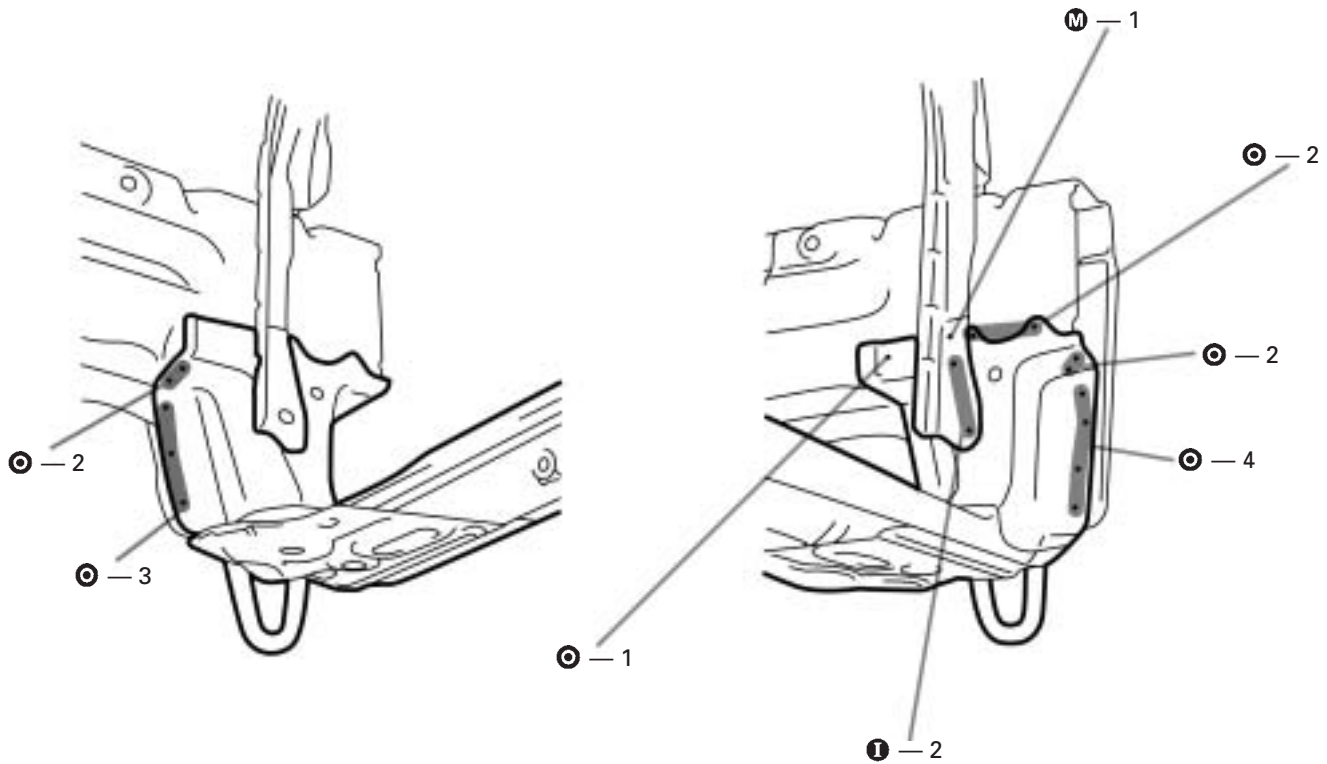
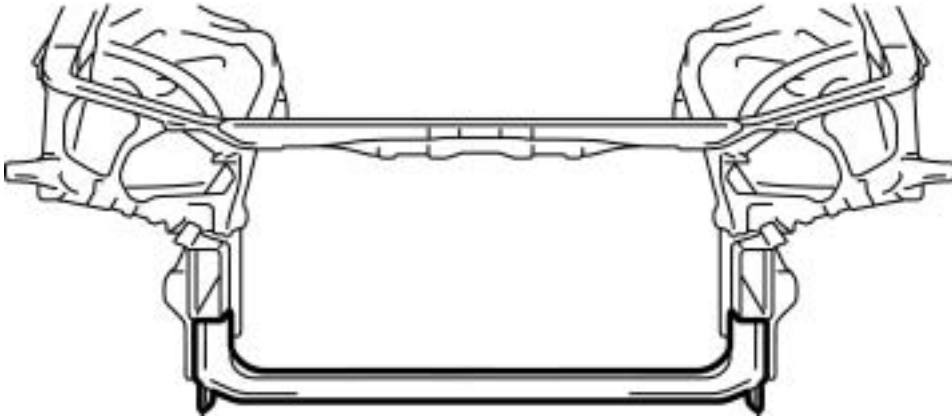
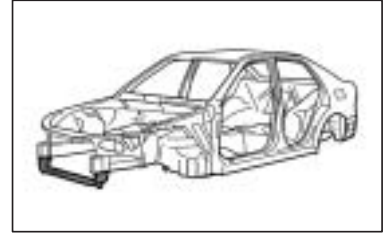
1. Replace the radiator support to front fender bracket, front bumper arm mounting bracket and front crossmember No.3 reinforcement at the same time.

INSTALLATION

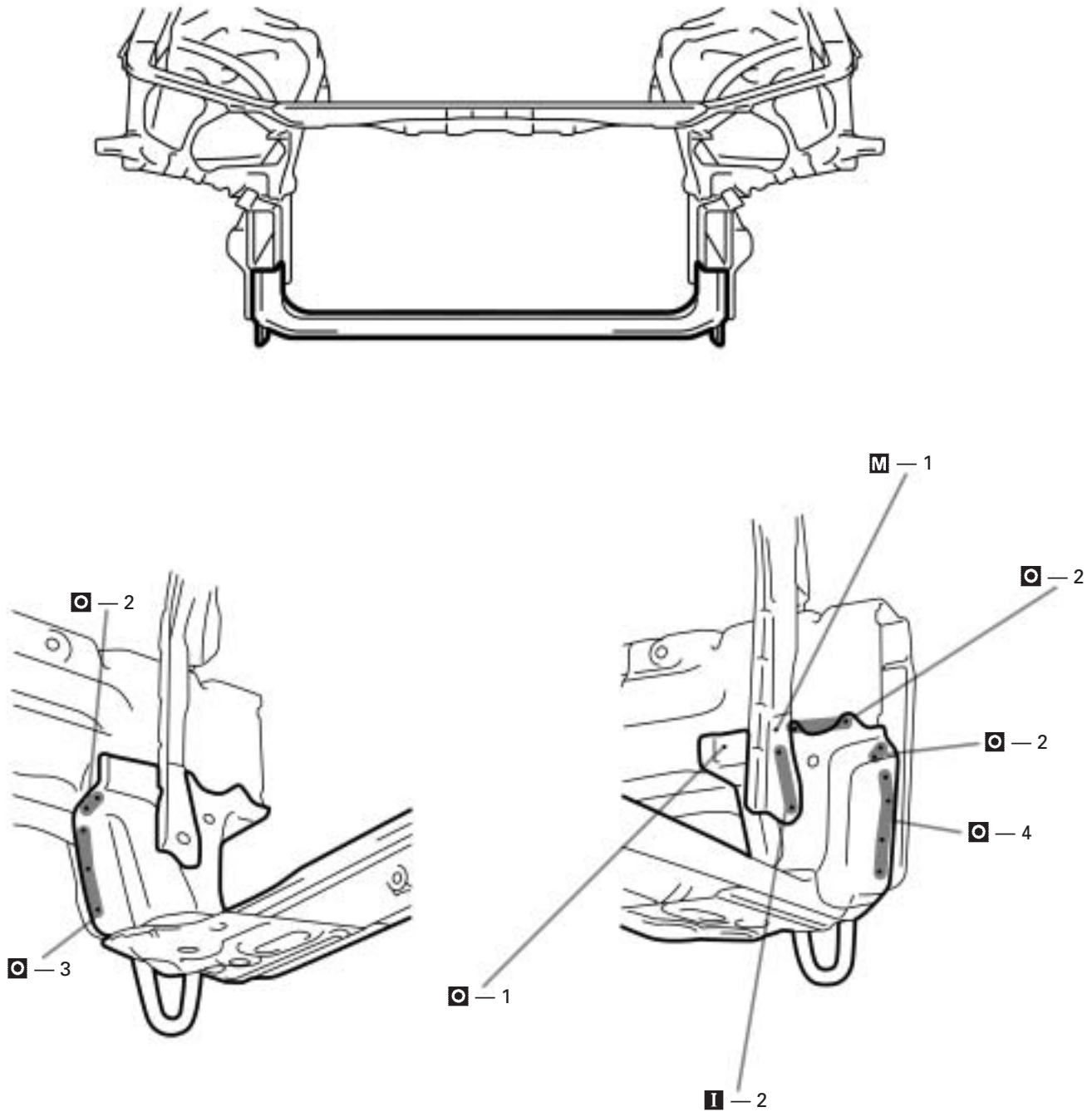


1. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.

HINT: First install the radiator upper center support.

FRONT CROSSMEMBER (ASSY)**REMOVAL**

INSTALLATION

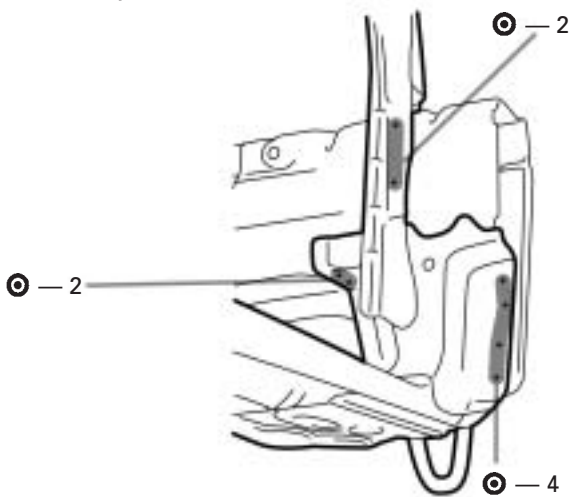
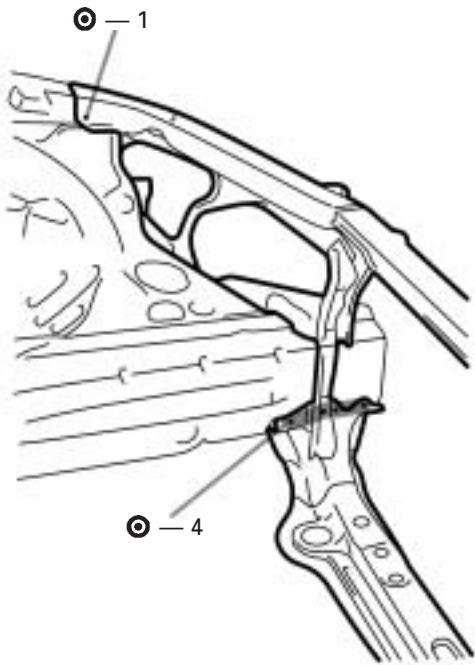
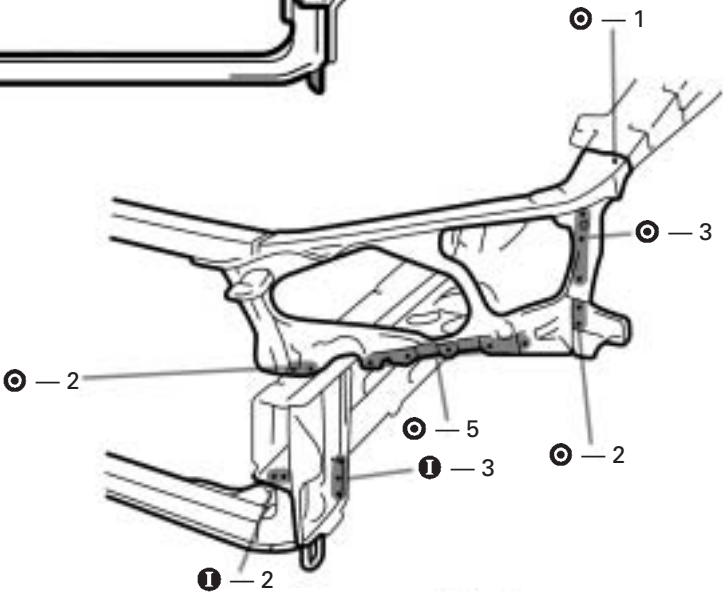
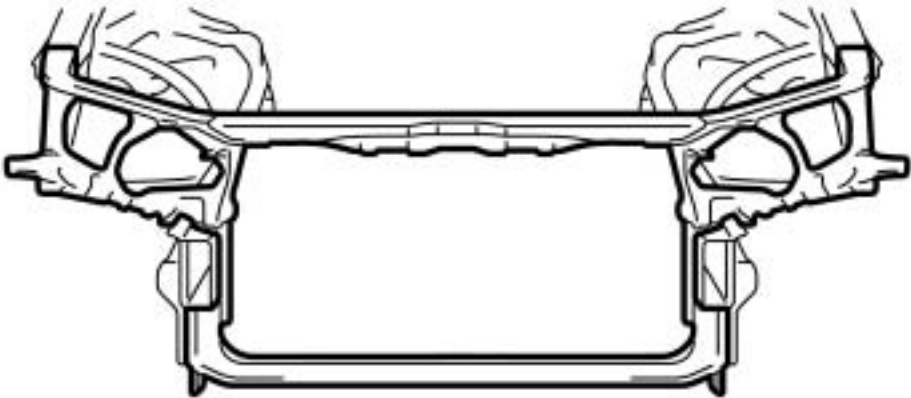
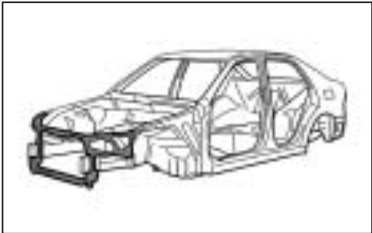


1. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.

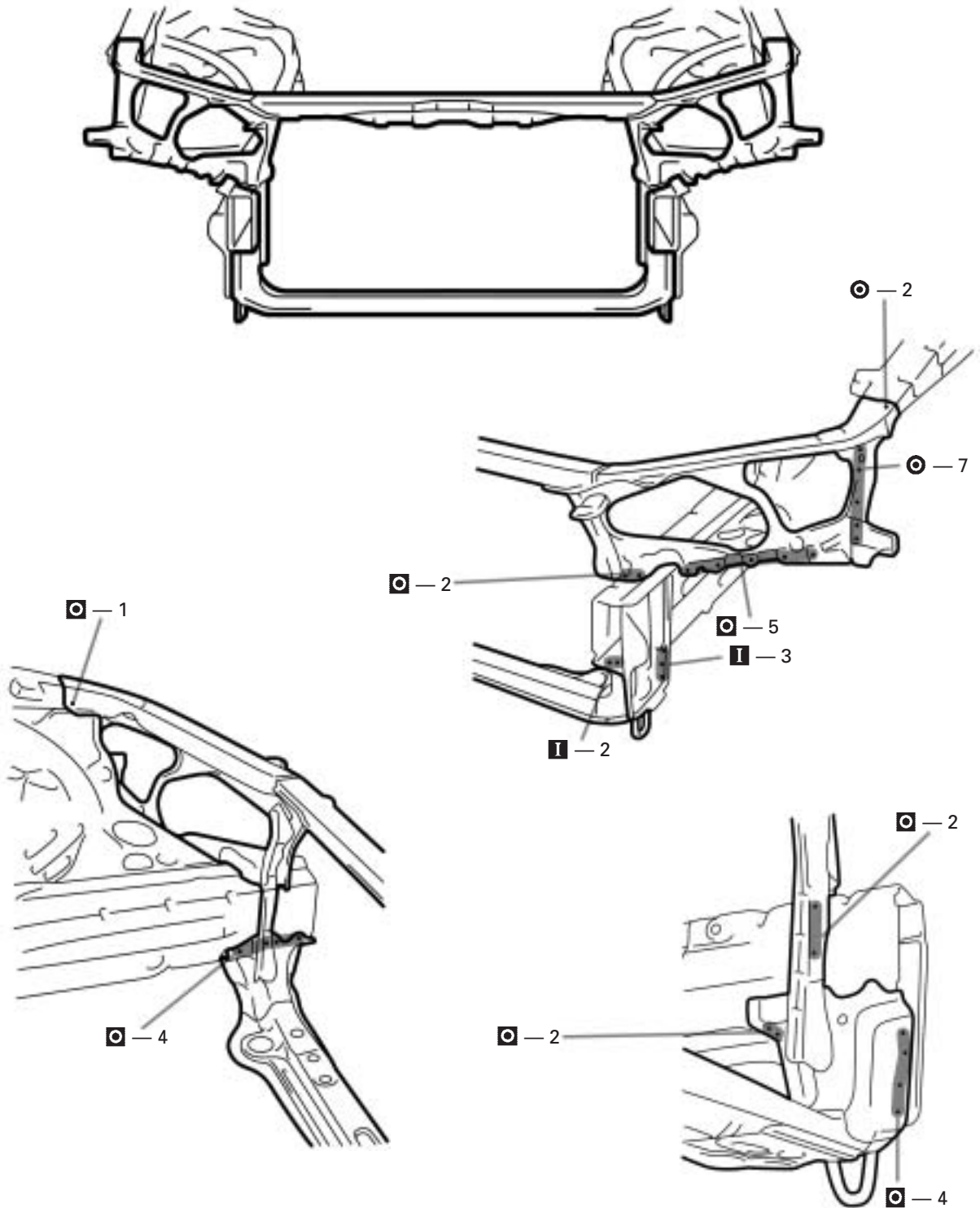
HINT: First install the hood lock support.

RADIATOR SUPPORT (ASSY)

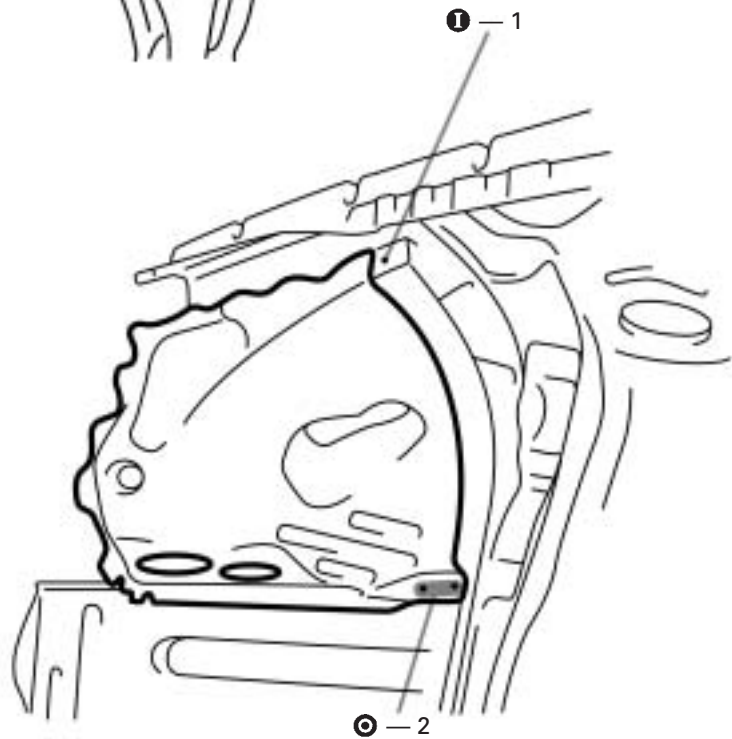
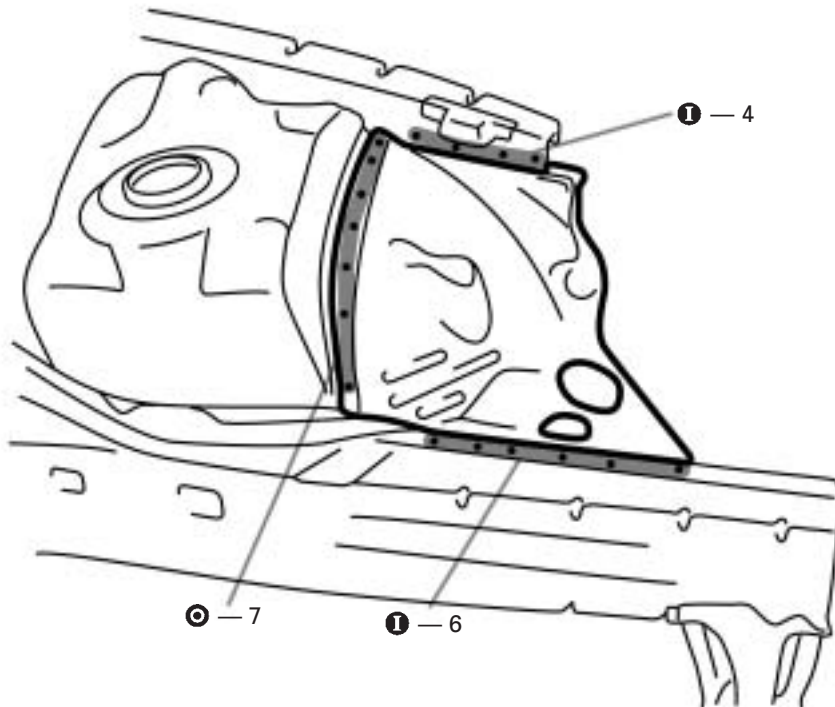
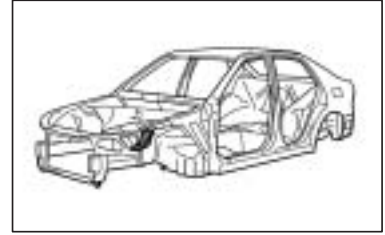
REMOVAL



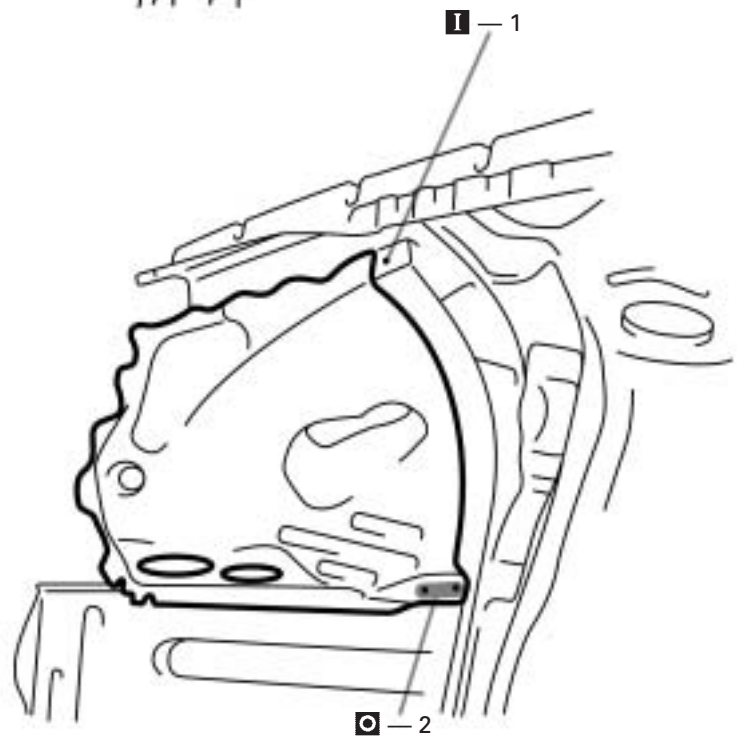
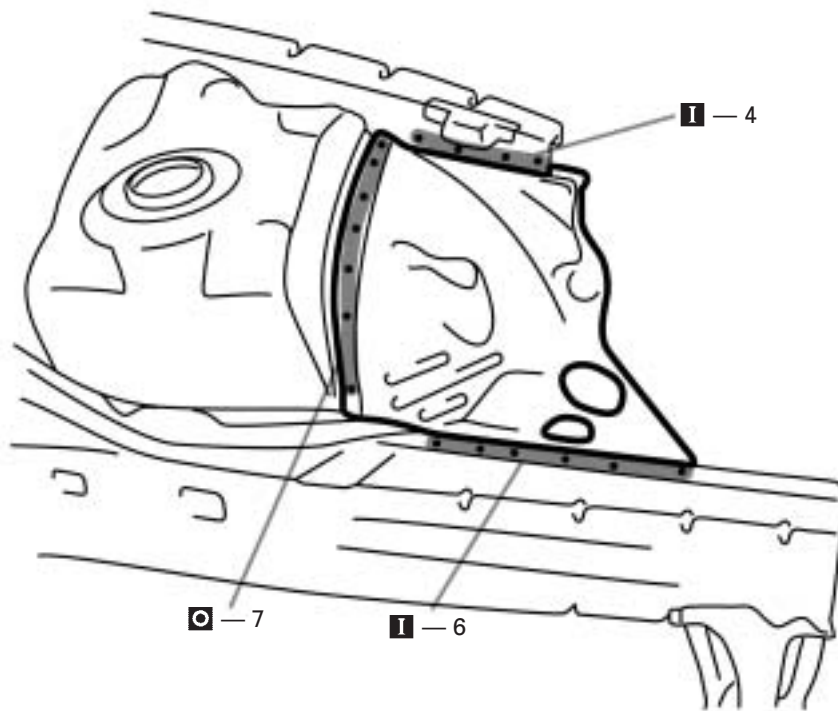
INSTALLATION



1. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.

FRONT FENDER FRONT APRON (ASSY)**REMOVAL (With the radiator side support removed.)**

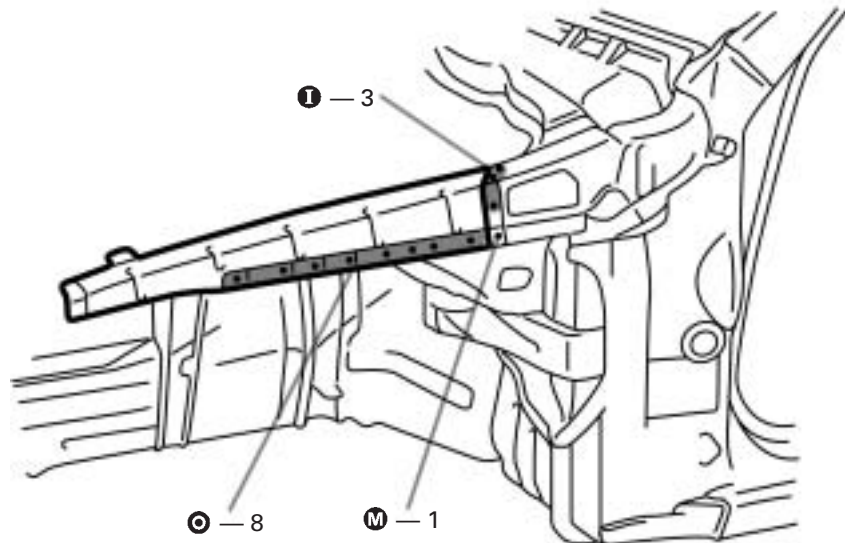
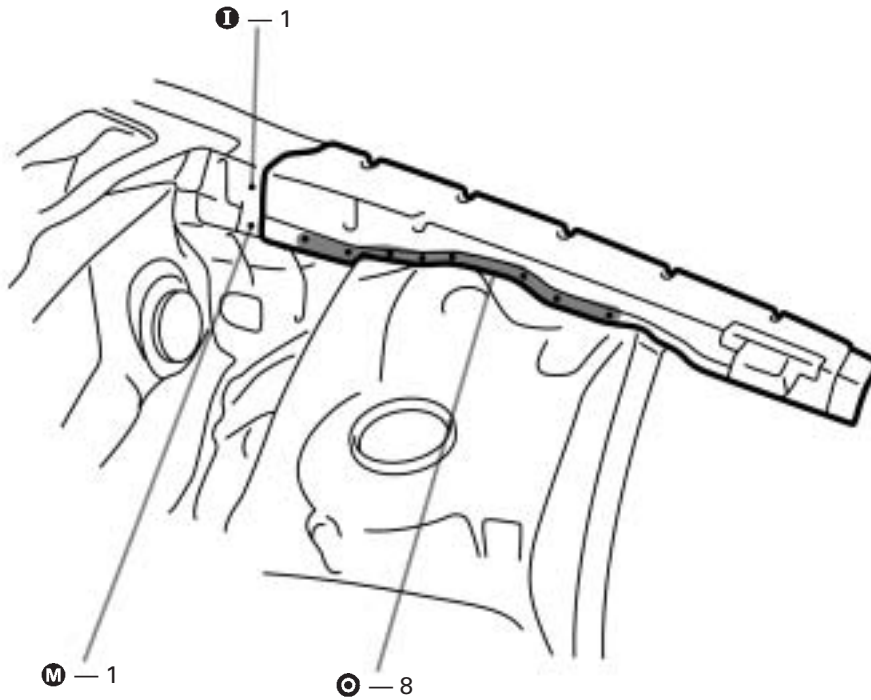
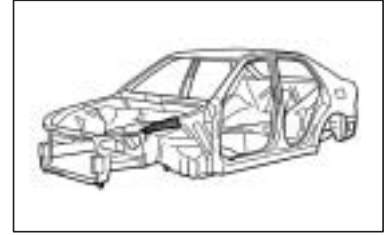
INSTALLATION



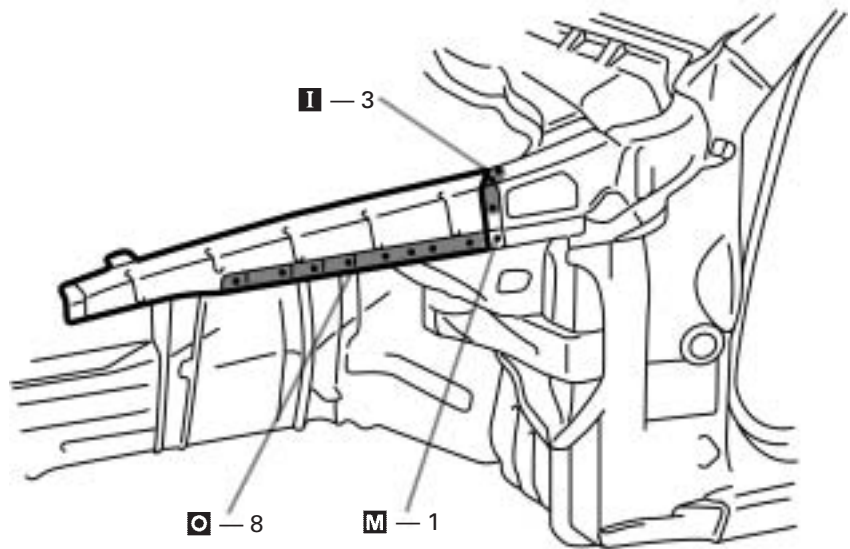
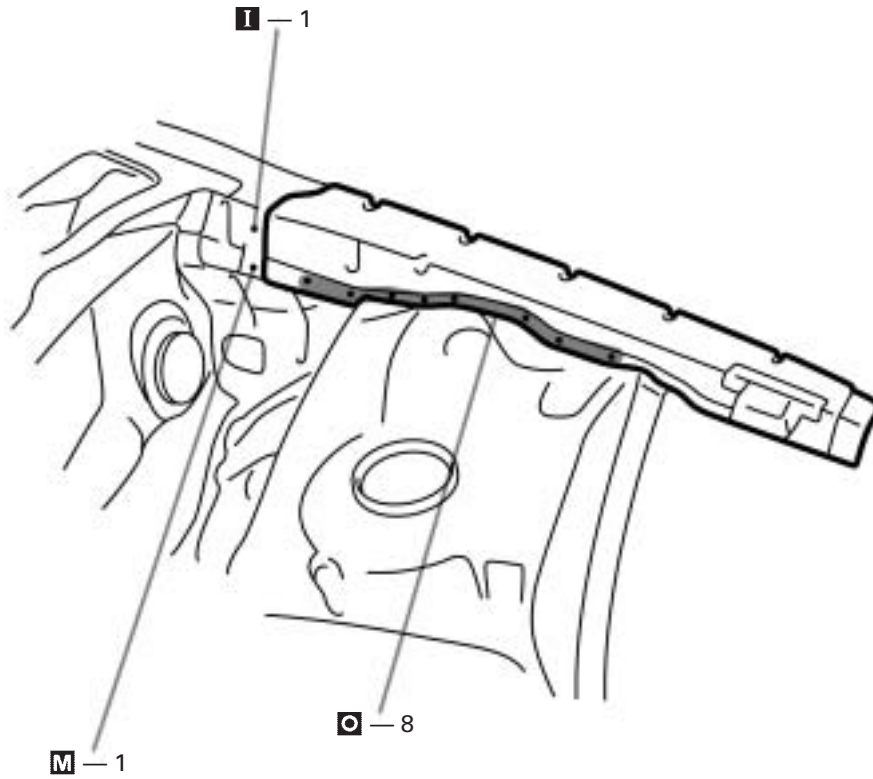
1. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.

FRONT APRON TO COWL SIDE MEMBER (ASSY)

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



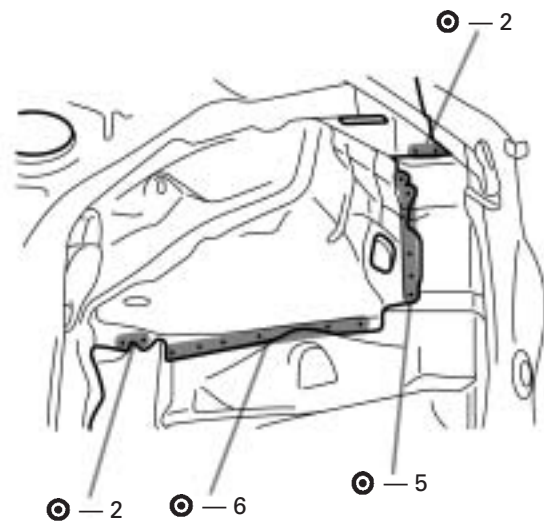
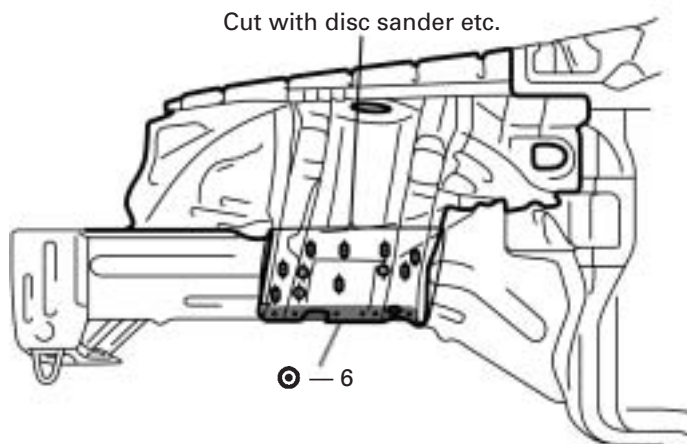
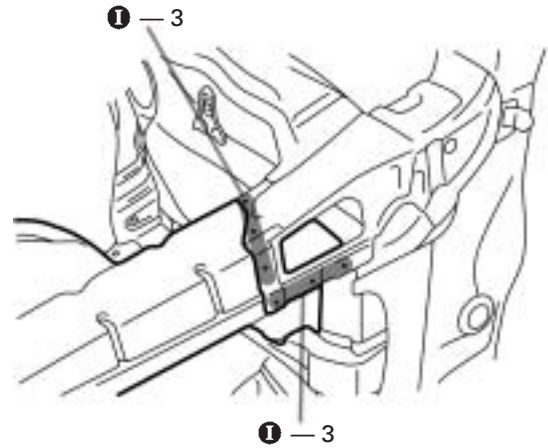
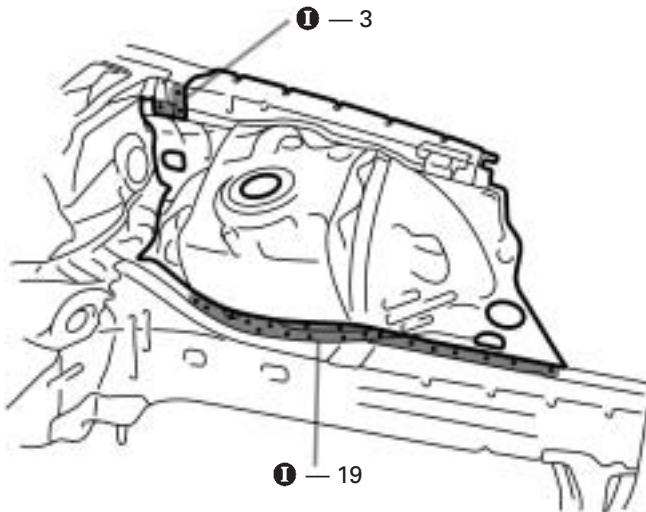
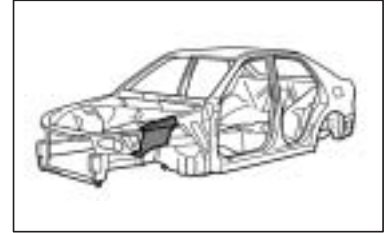
INSTALLATION



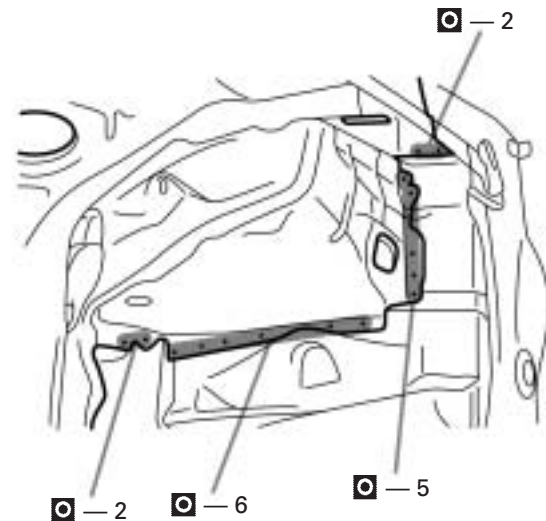
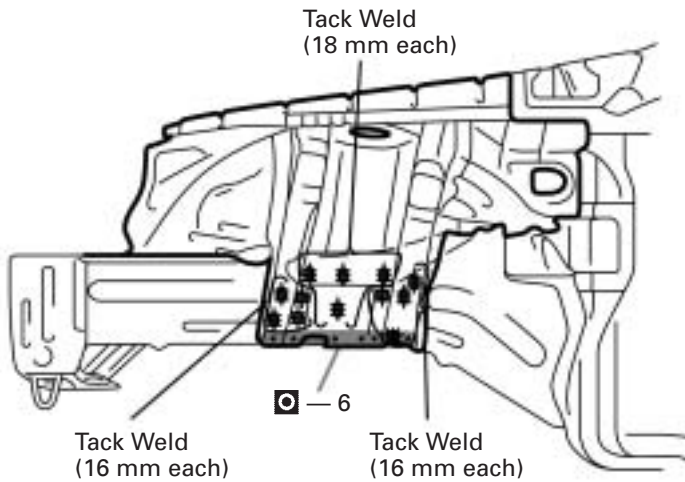
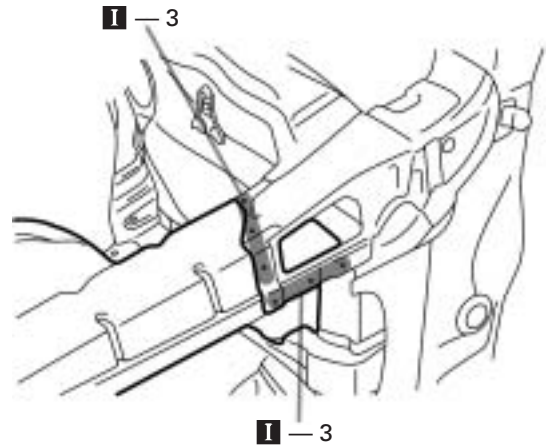
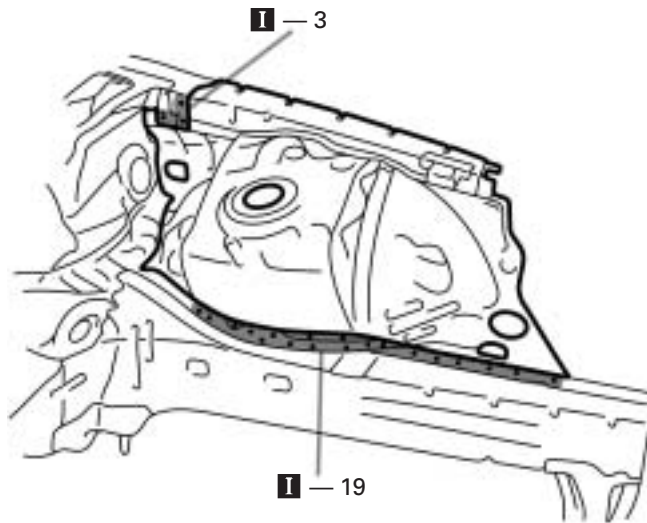
1. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.
2. Temporarily install the front fender and hood, and check the fit.

FRONT FENDER APRON (ASSY)

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



INSTALLATION

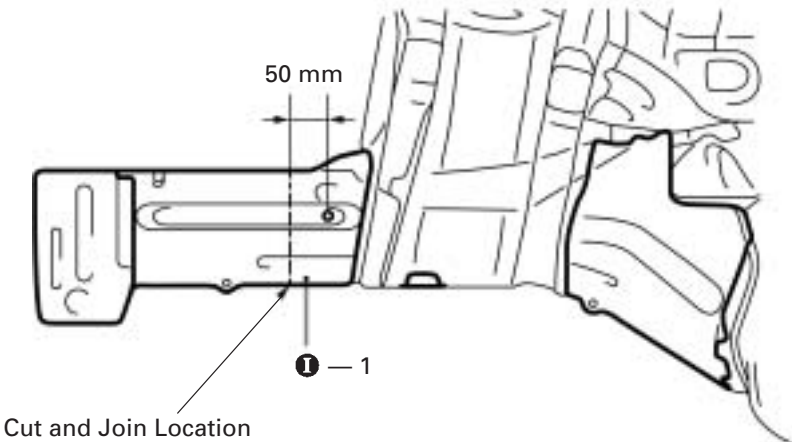
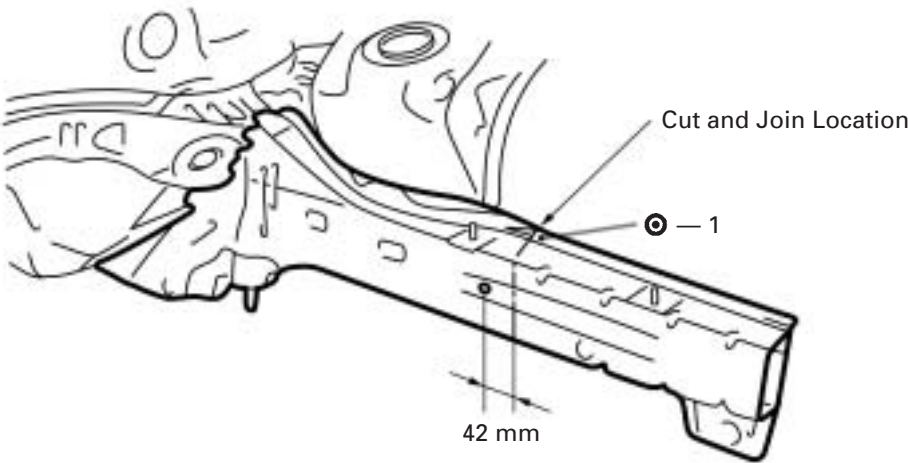
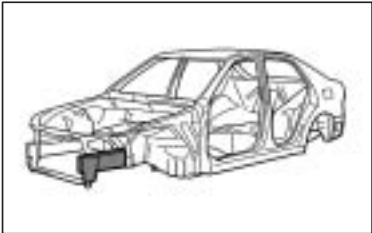


mm	in.
16	0.63
18	0.71

1. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.
2. Measurements must be accurate with the body dimension diagram, as this affects the front wheel alignment.
3. Temporarily install the front fender and hood, and check the fit.

FRONT SIDE MEMBER (CUT-P)

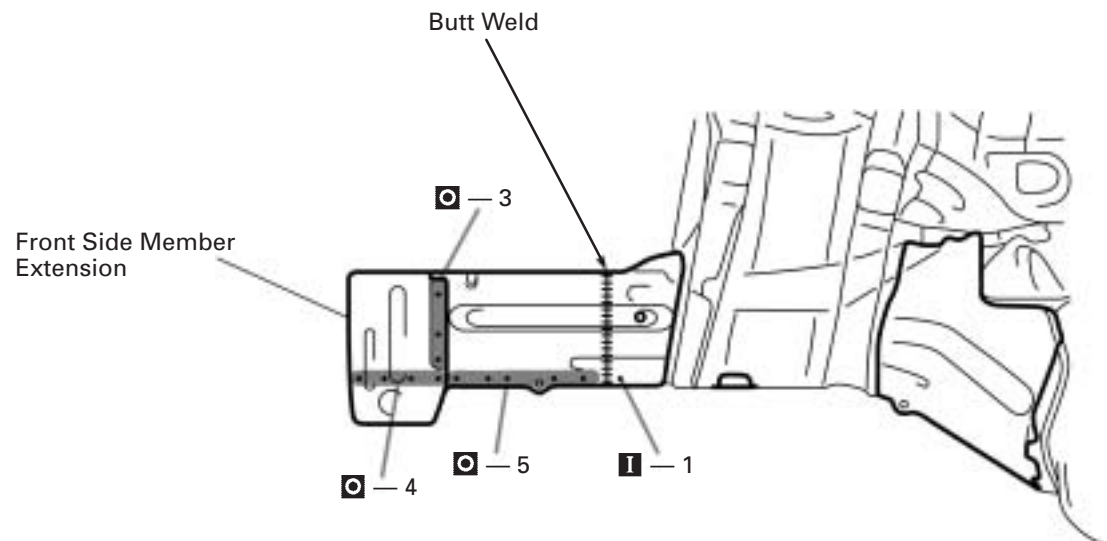
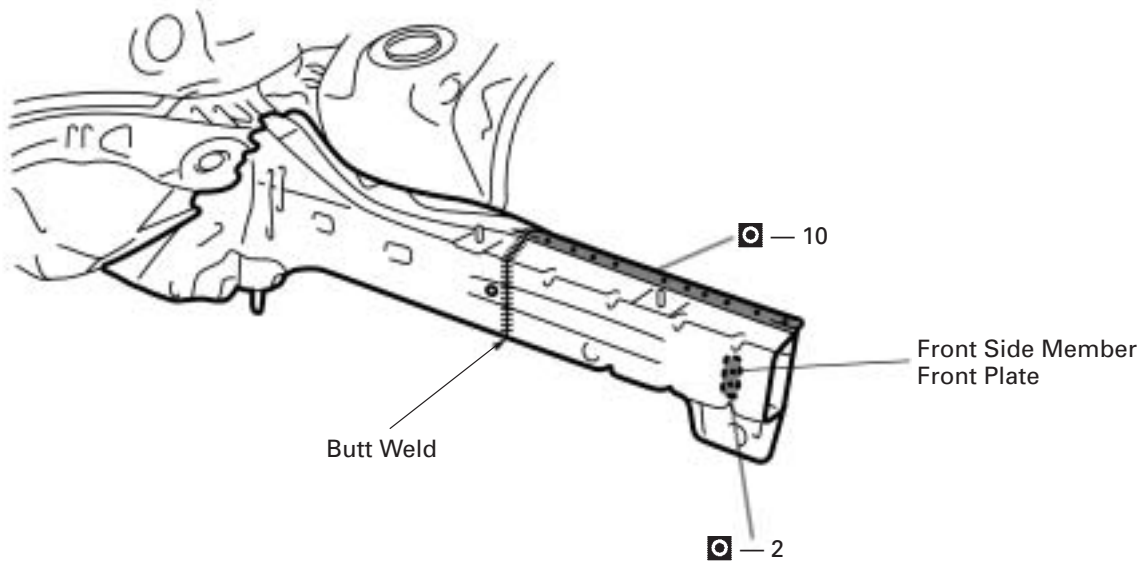
REMOVAL (With the front crossmember and front fender front apron removed.)



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

mm	in.
42	1.65
50	1.97

INSTALLATION

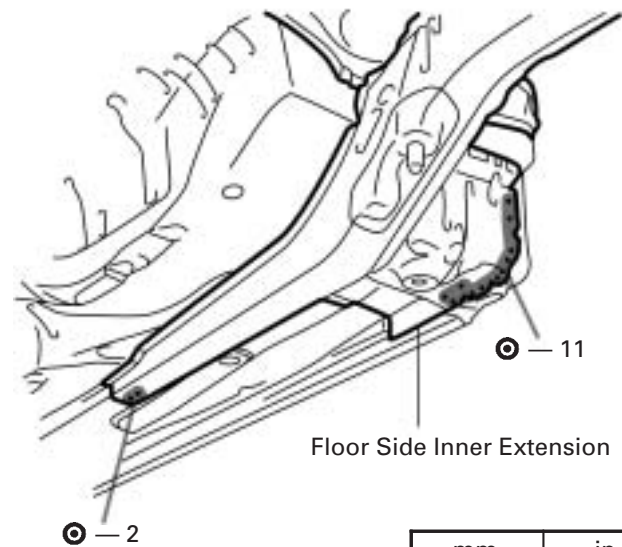
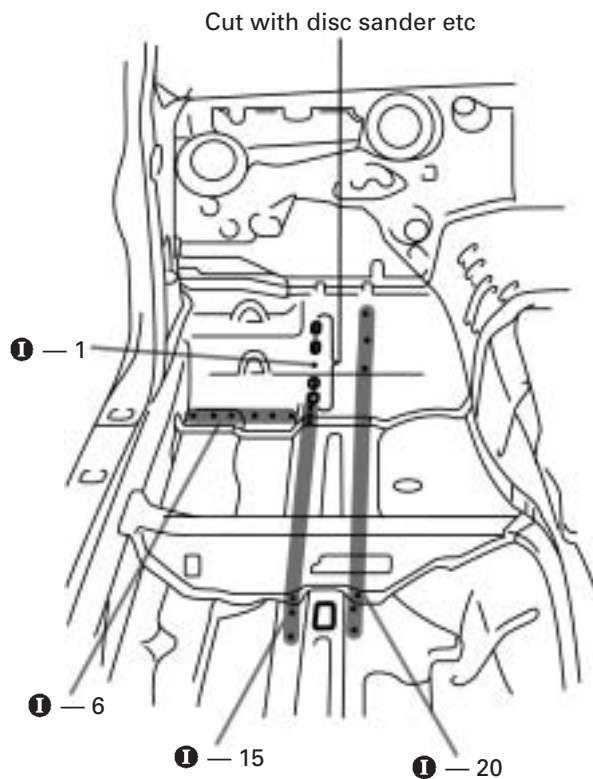
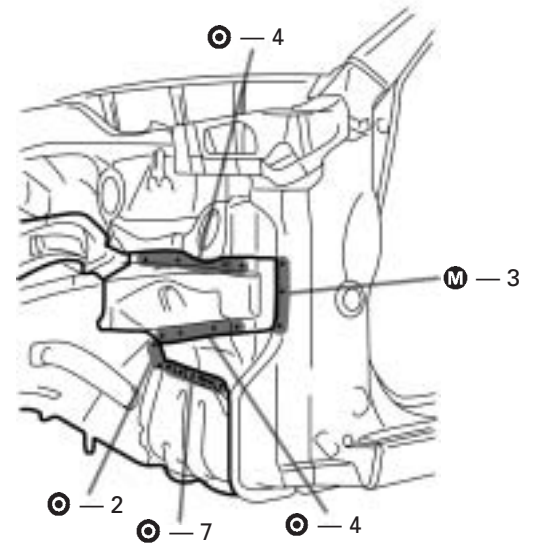
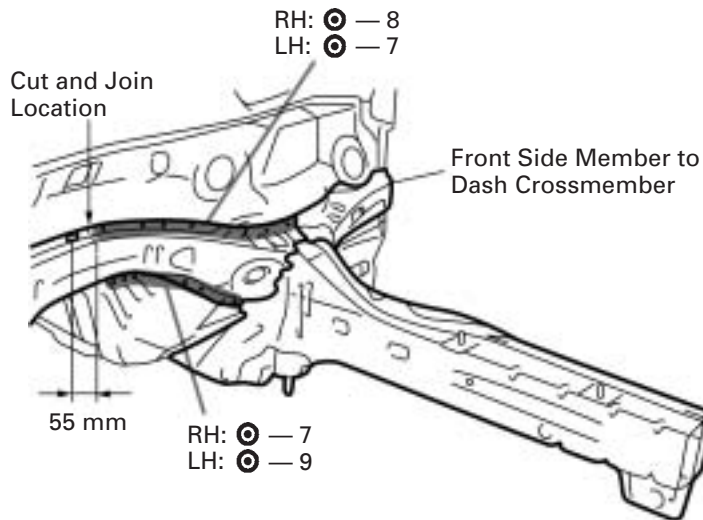
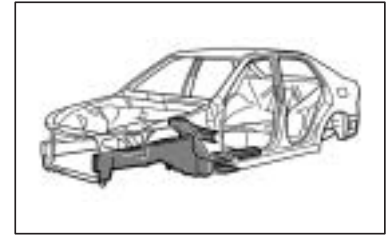


1. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.

- MEMO -

FRONT SIDE MEMBER (ASSY)

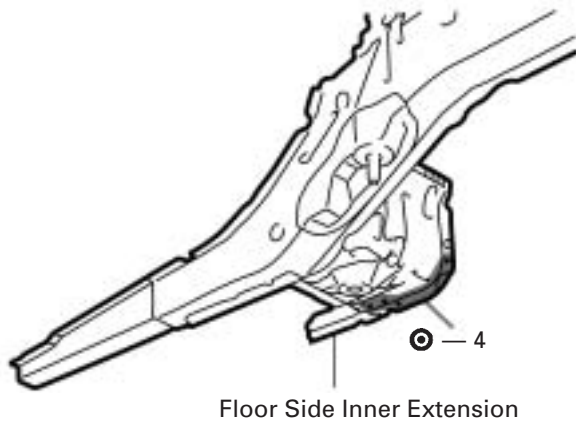
REMOVAL (With the front crossmember and front fender apron removed.)



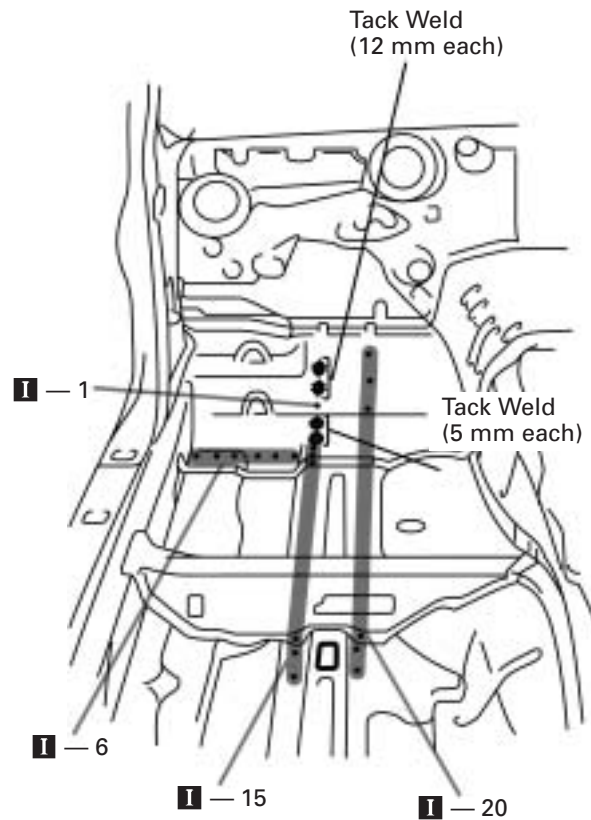
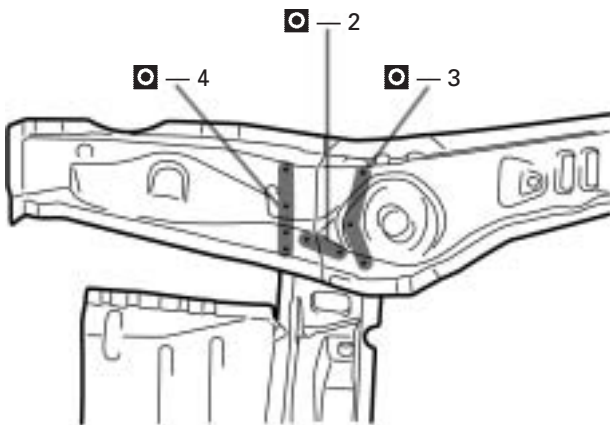
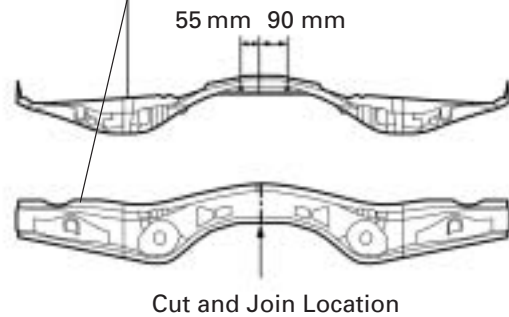
mm	in.
55	2.17

1. Cut the front side member to dash crossmember at the location shown above, and replace it at the same time as front side member.
2. Leave the floor side inner extension to the vehicle.

INSTALLATION

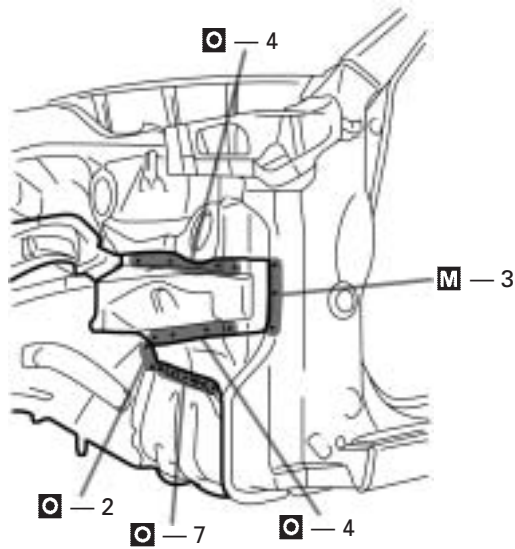
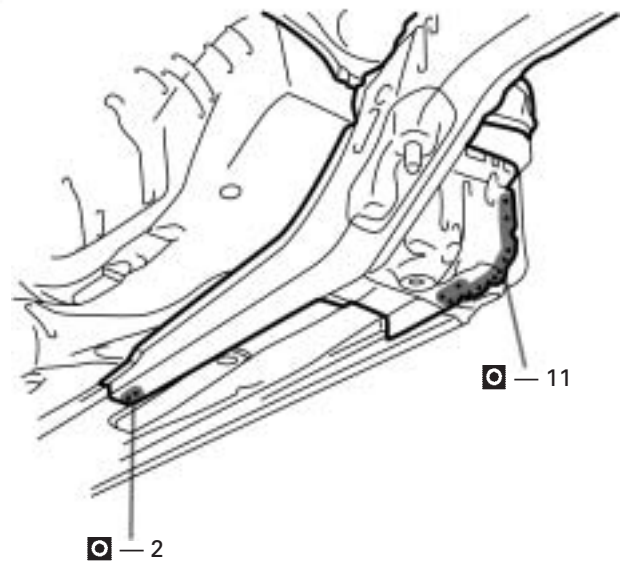
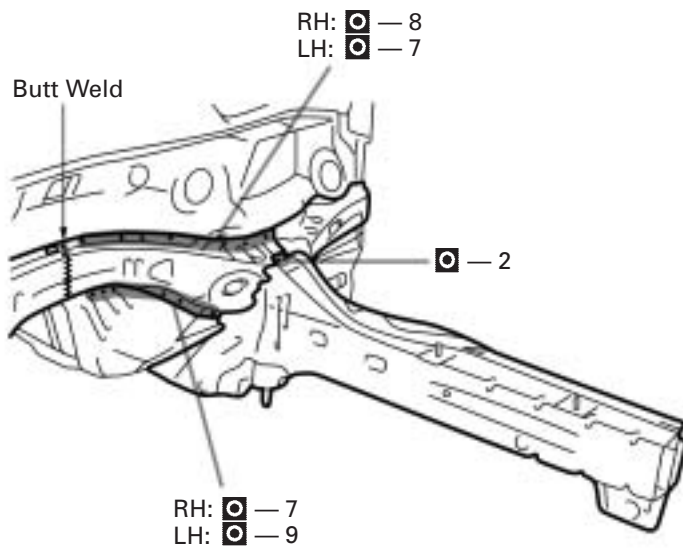


Front Side Member to Dash Crossmember



mm	in.
5	0.20
12	0.47
55	2.17
90	3.54

1. Cut the front side member to dash crossmember at the location shown above, and weld the front side member with standard points.
2. Remove the floor side inner extension from the new parts of front side member.

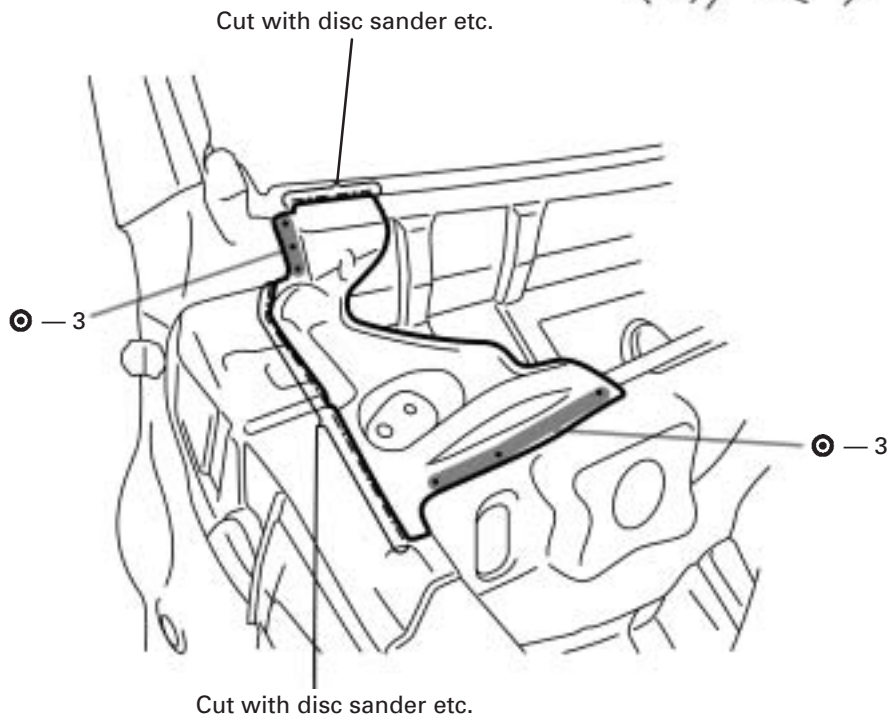
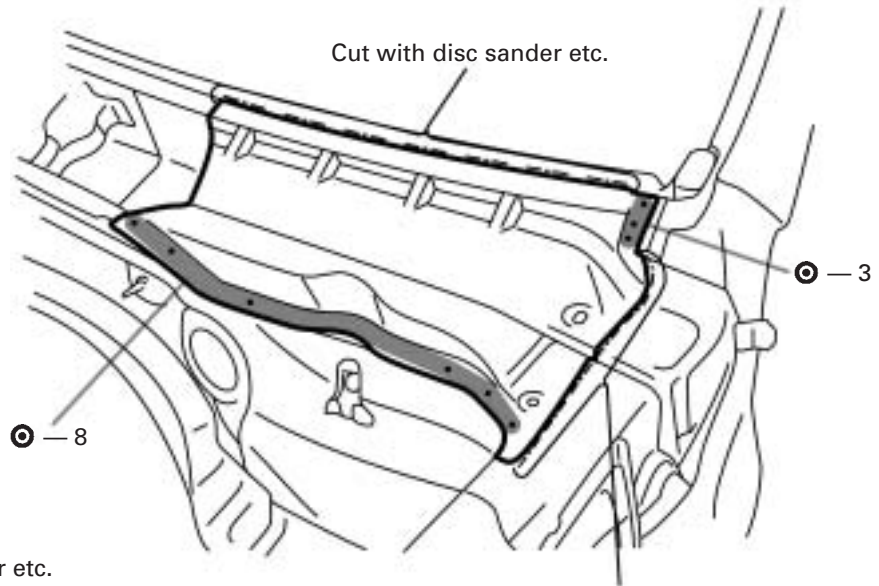
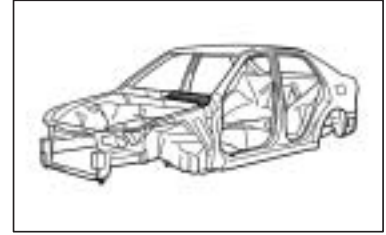


- Temporarily install the new parts and measure each part in accordance with the body dimension diagram.

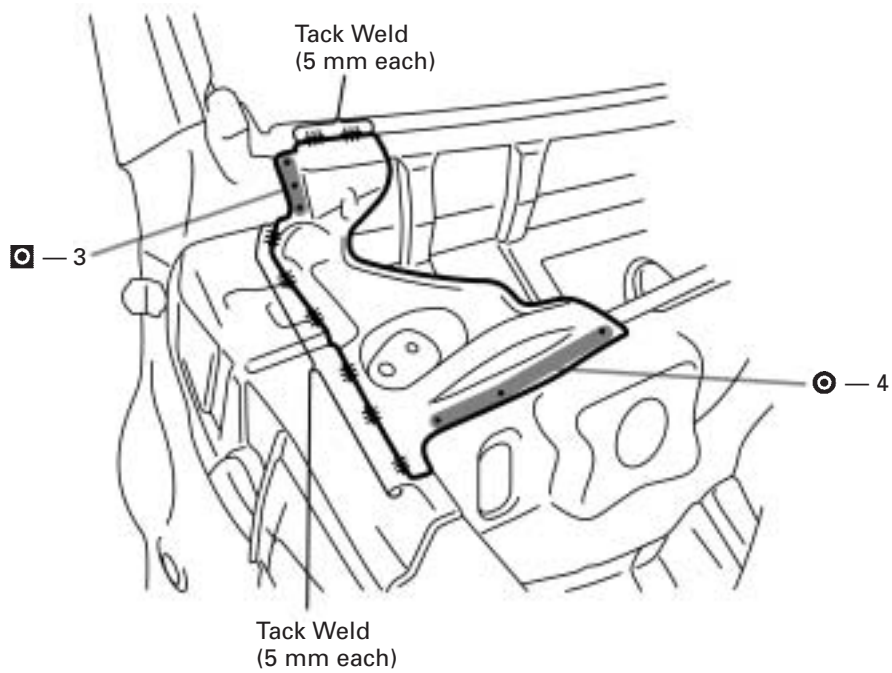
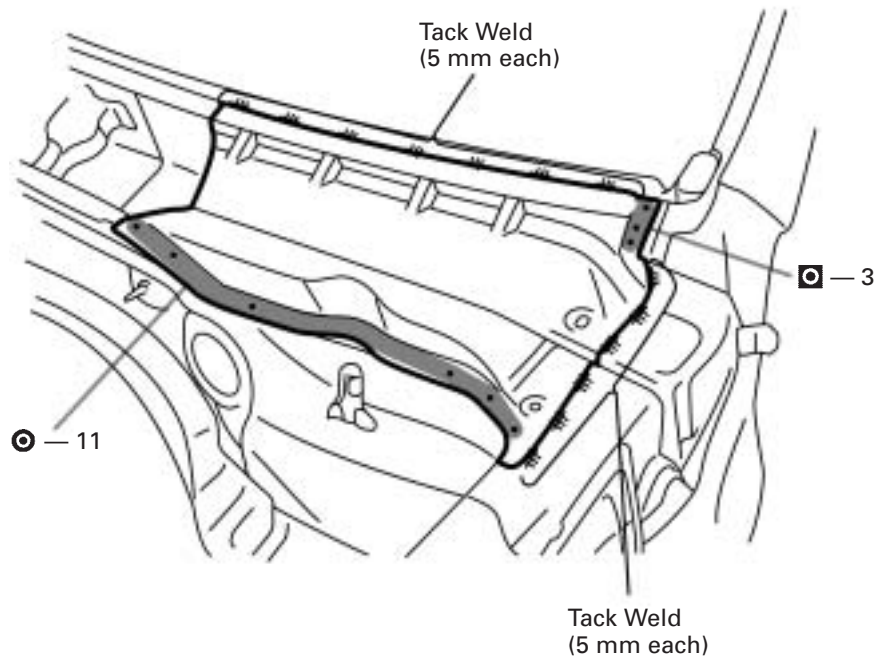
HINT: Make sure each measurement is correct, as this parts affects the front wheel alignment.

COWL TOP TO APRON BRACE (ASSY)

REMOVAL

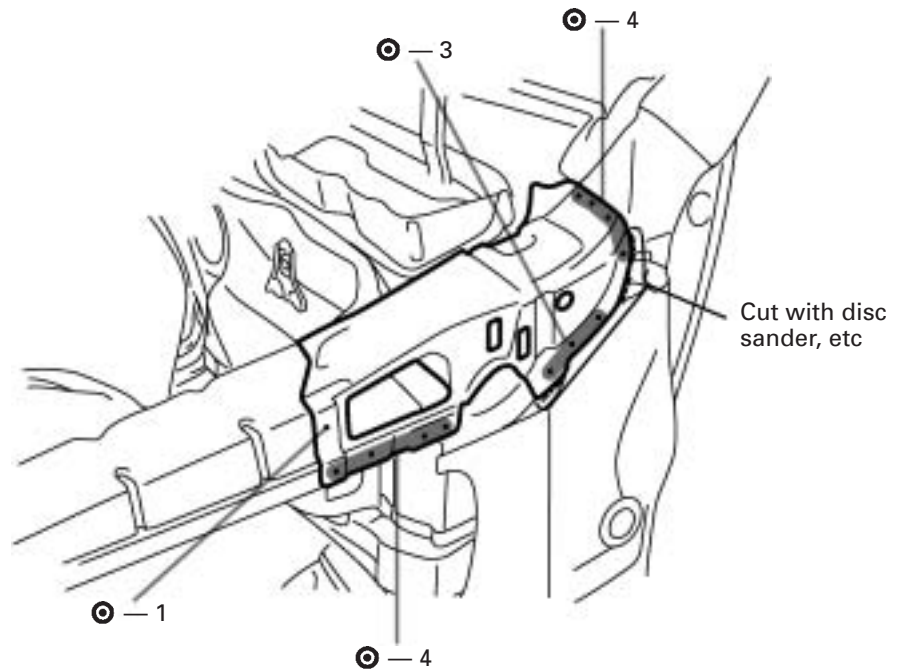
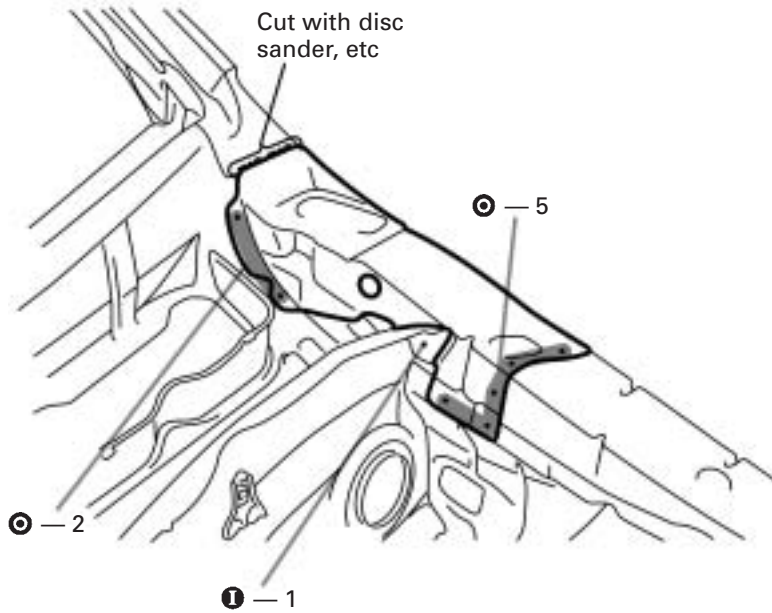
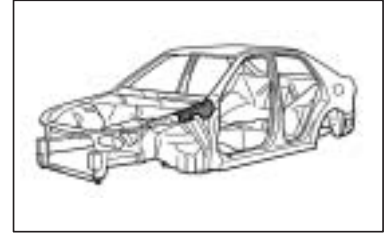


INSTALLATION

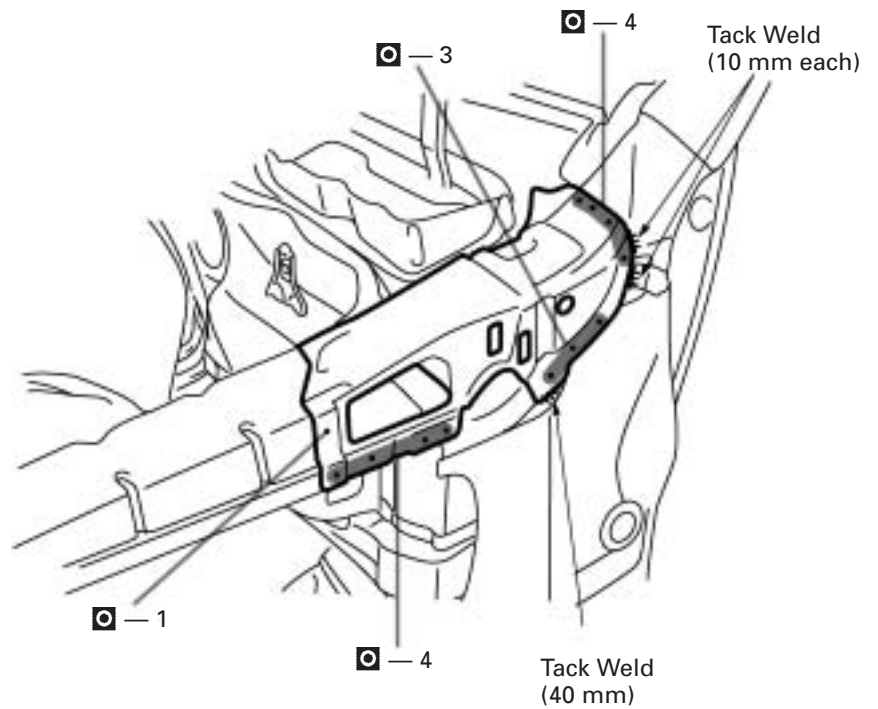
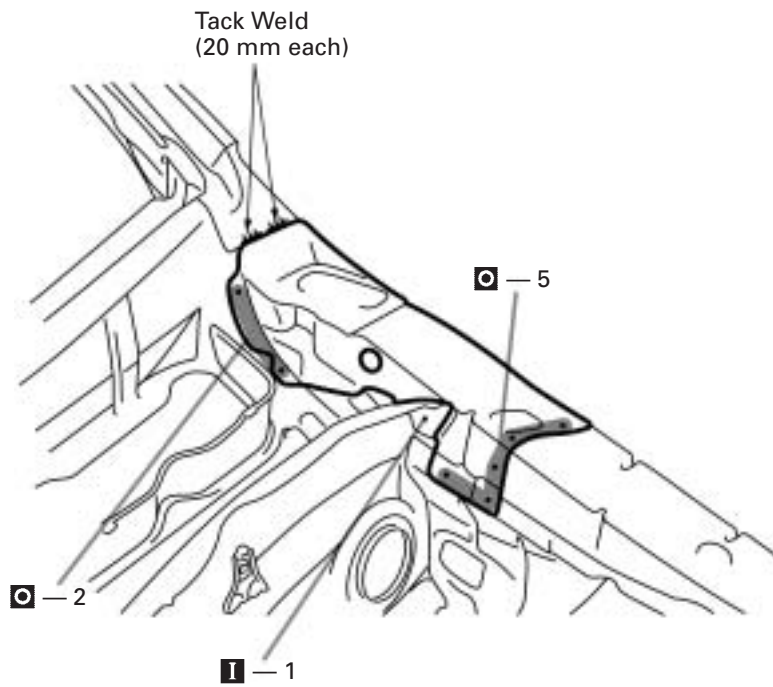


COWL TOP SIDE PANEL (ASSY)

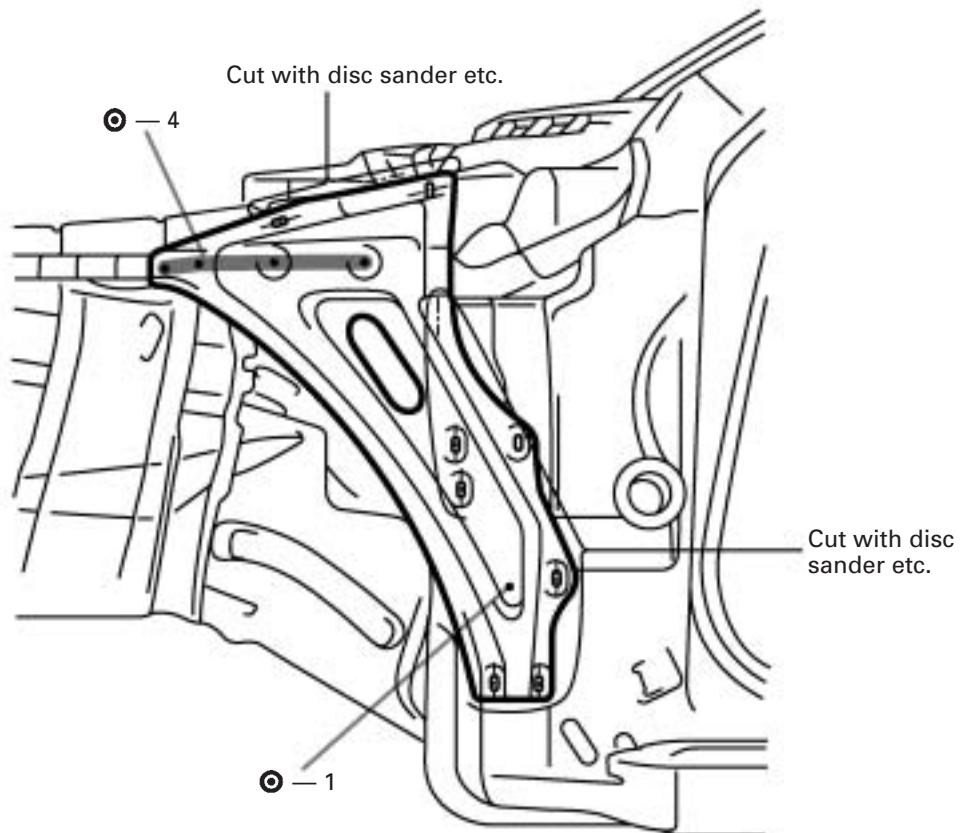
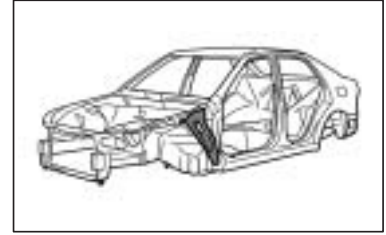
REMOVAL (With the cowl top to apron brace and front body pillar lower gusset removed.)



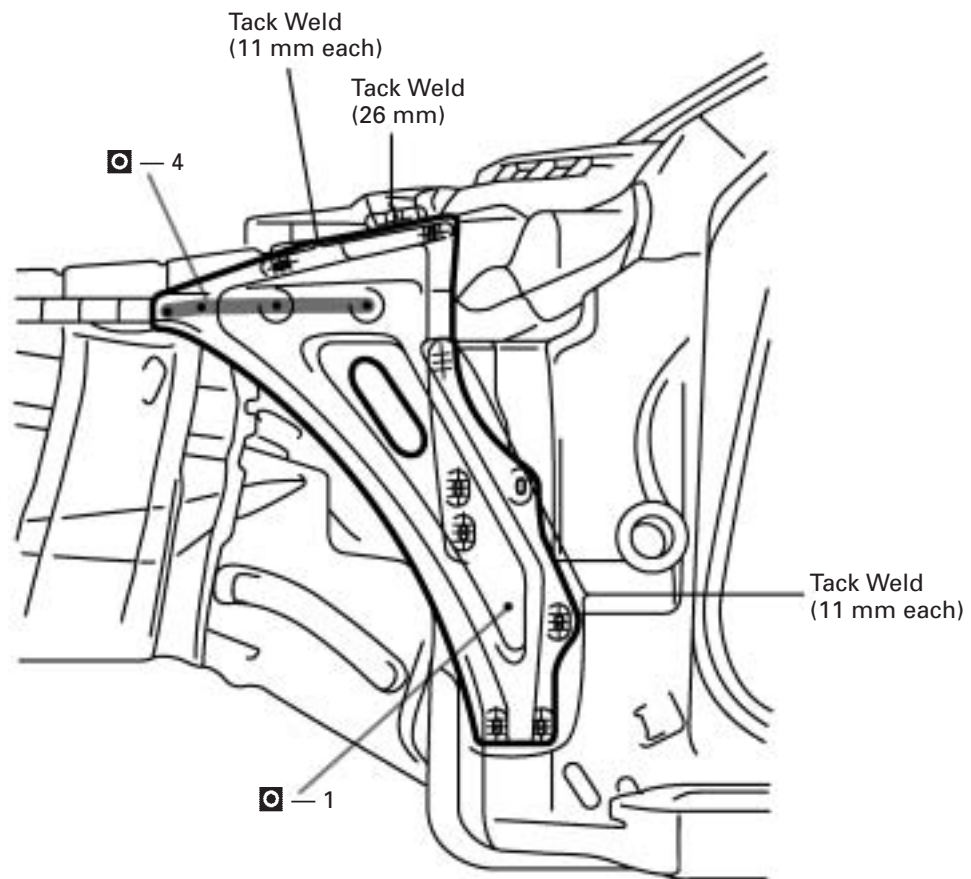
INSTALLATION



mm	in.
10	0.39
20	0.79
40	1.57

FRONT BODY PILLER LOWER GUSSET (ASSY)**REMOVAL**

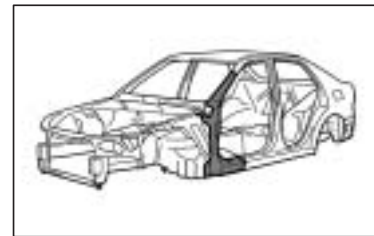
INSTALLATION



mm	in.
11	0.43
26	1.02

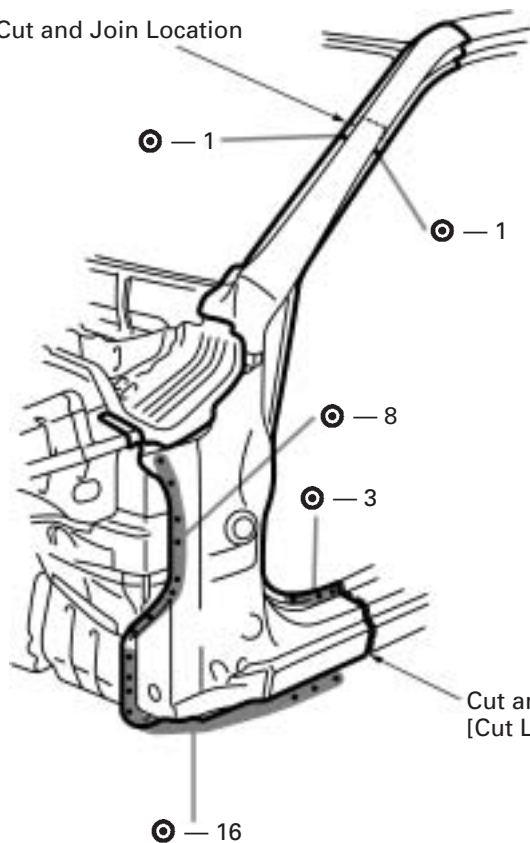
FRONT BODY PILLAR (CUT)

REMOVAL (With the cowl top side panel removed.)



[Cut and Join Location]

Cut and Join Location



Front Body Pillar Upper Inner Reinforcement

Front Body Pillar Upper Reinforce

130 mm

1 — 3

200 mm

70 mm

1 — 1

Rocker Panel No.1 Reinforcement

1 — 1

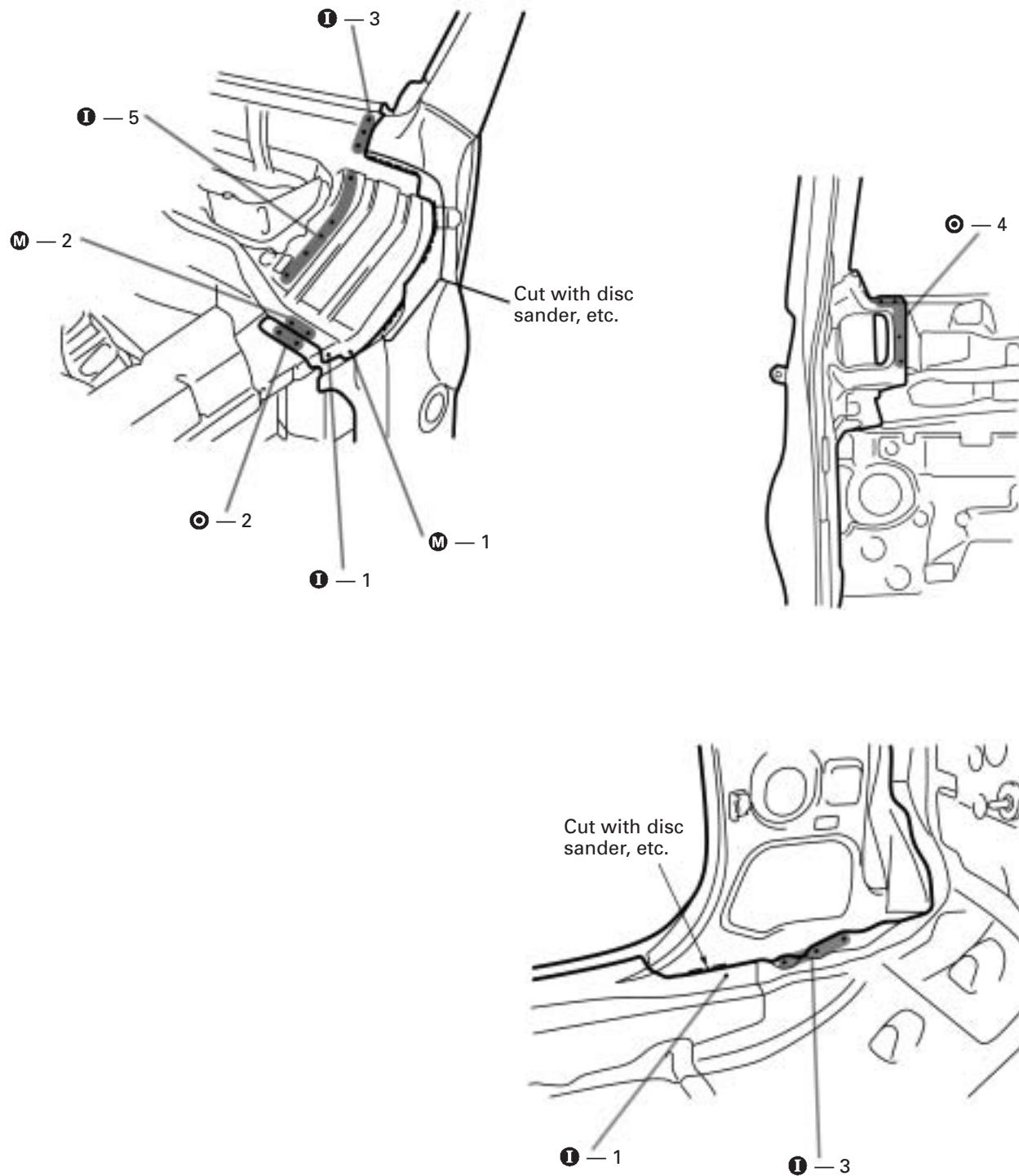
15 mm

10 mm

[Cut and Join Location]

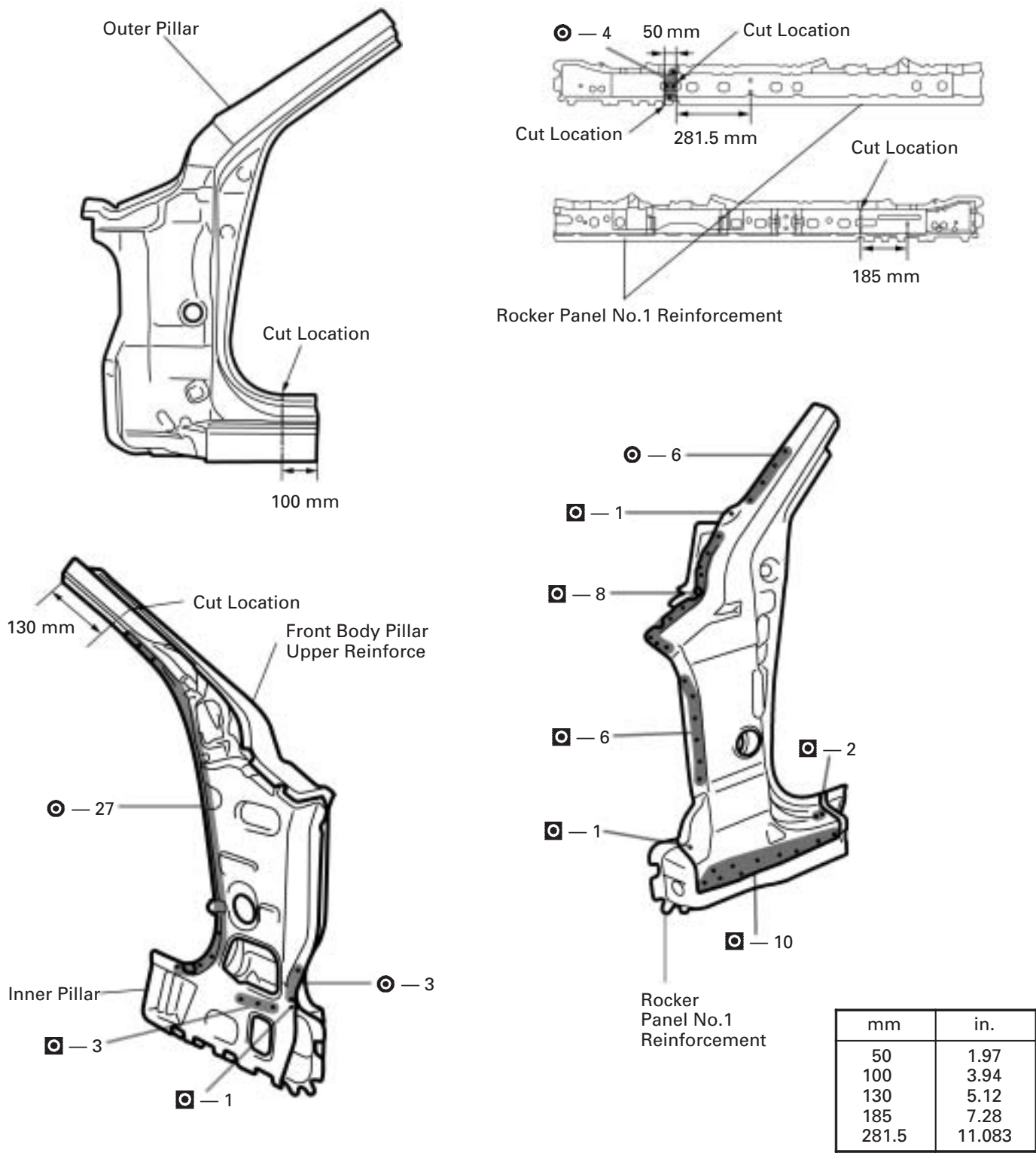
mm	in.
10	0.39
15	0.59
70	2.76
130	5.12
200	7.87

1. Cut and join the parts at the locations as shown above.
2. Shift the each cut and join locations of the outer pillar and inner pillar.
3. Shift the each cut and join locations of the outer panel and rocker panel No.1 reinforcement.

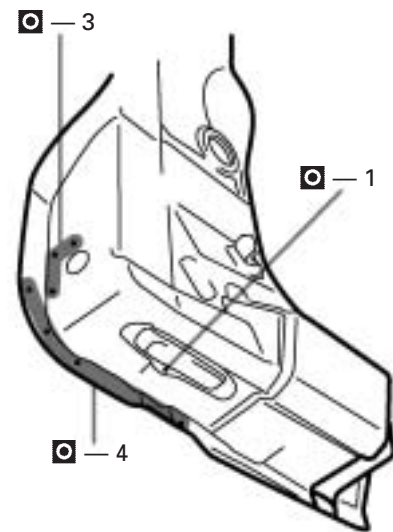
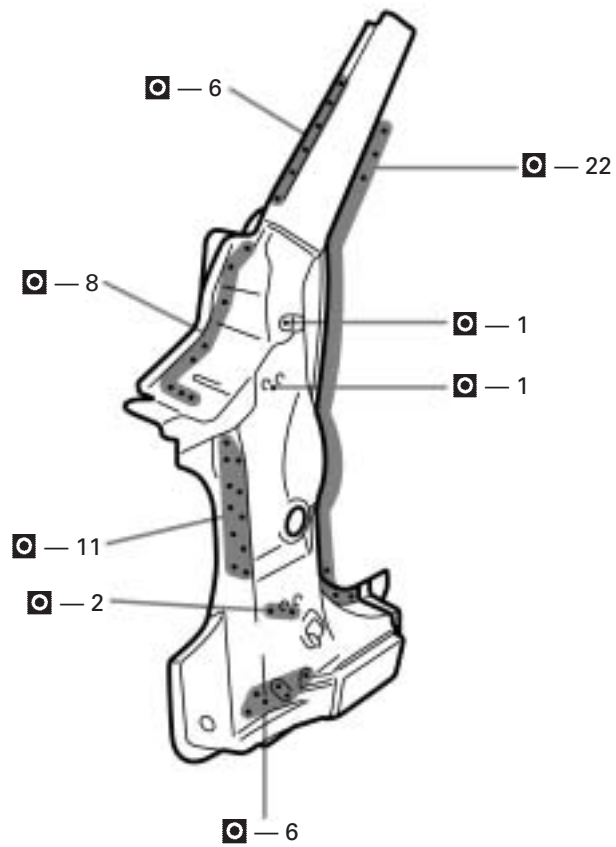


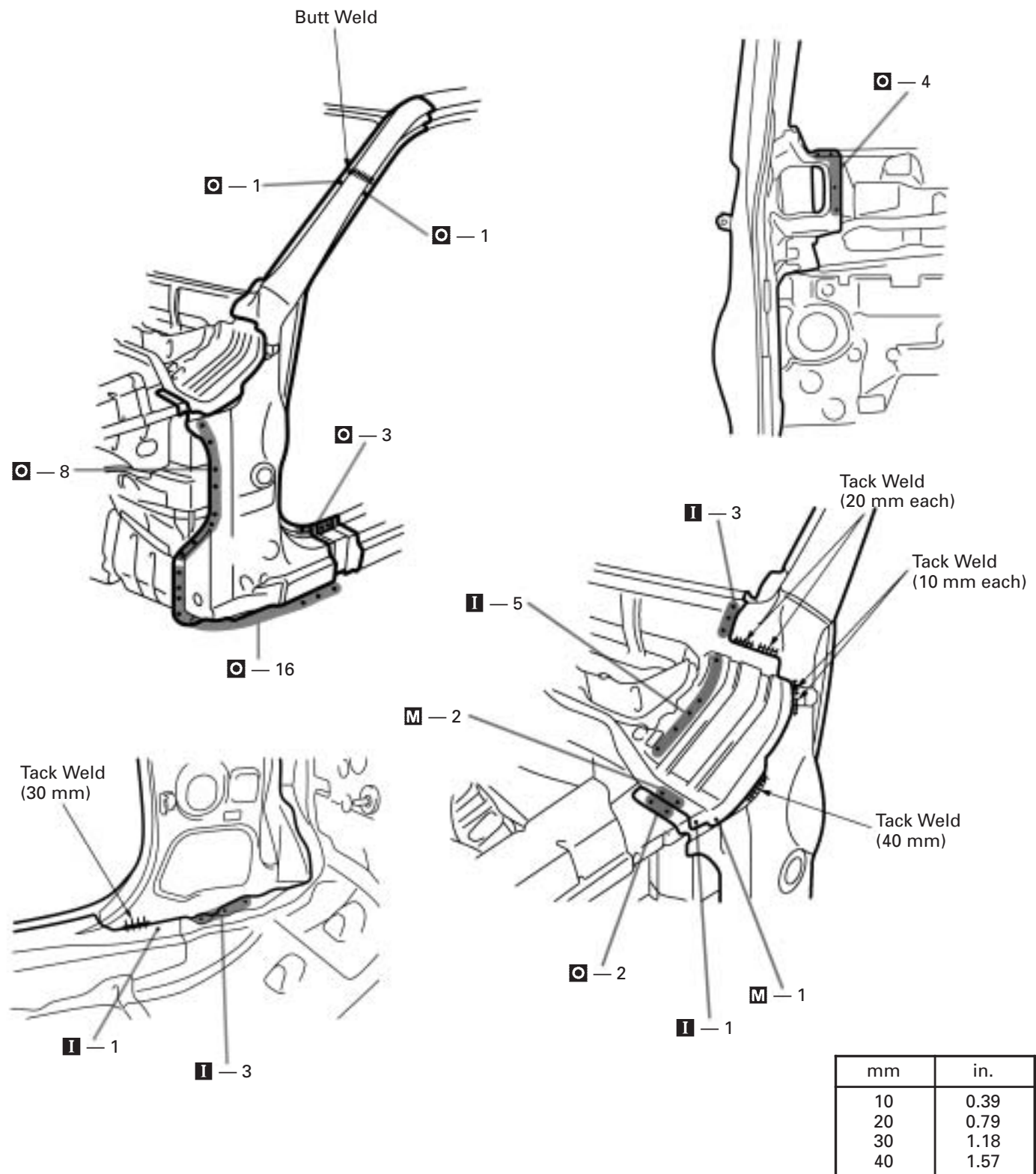
4. Remove the section from where the inner pillar was cut off and rejoined to 130 mm (5.12 in.) below, then remove the front body pillar upper reinforce from the front body pillar upper inner reinforcement.
5. Remove the remaining foamed material from the vehicle side.

INSTALLATION

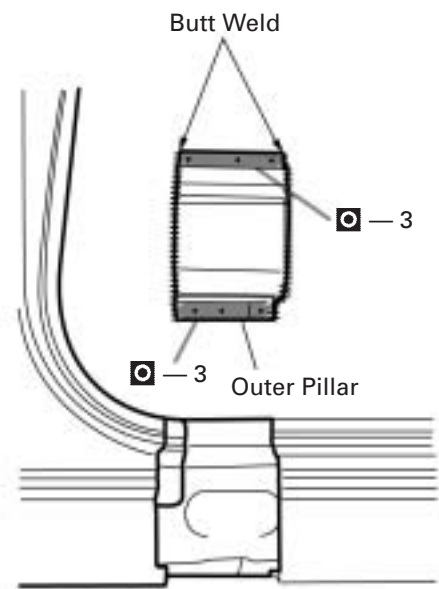
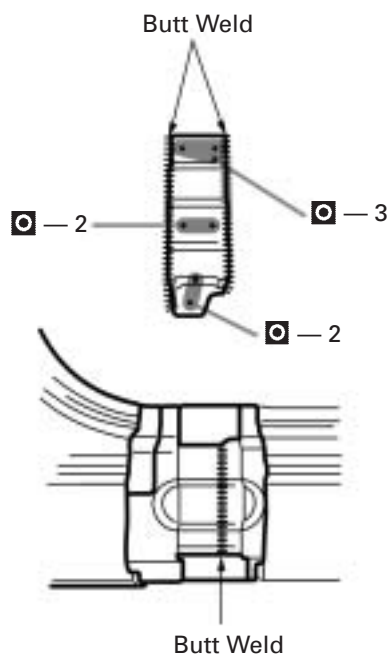
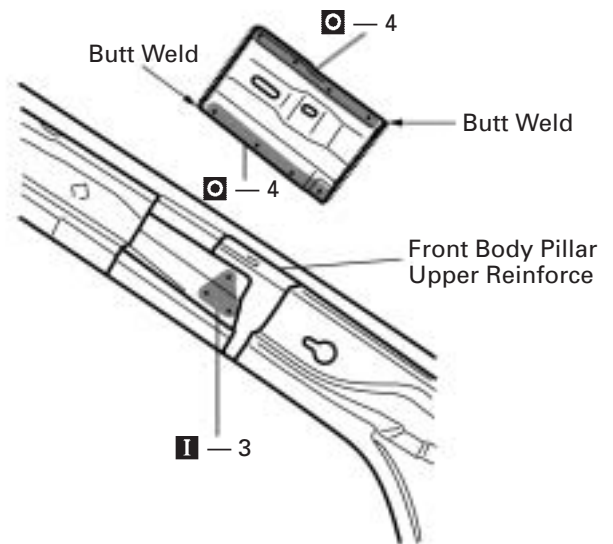
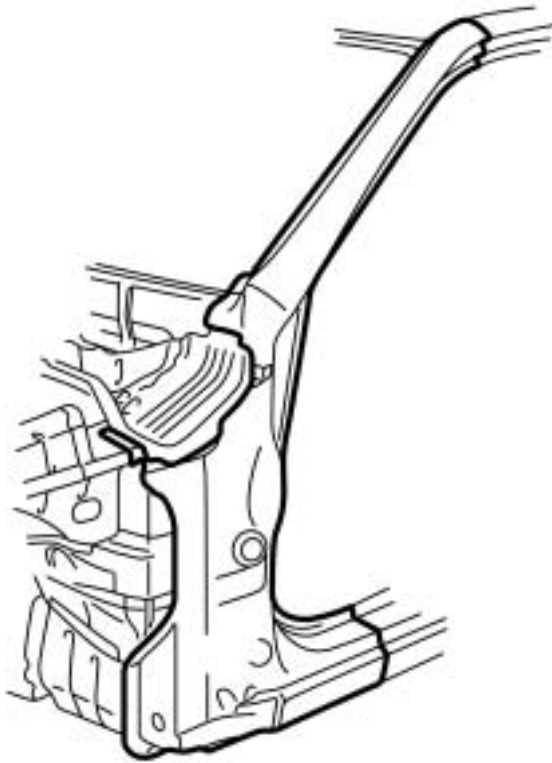


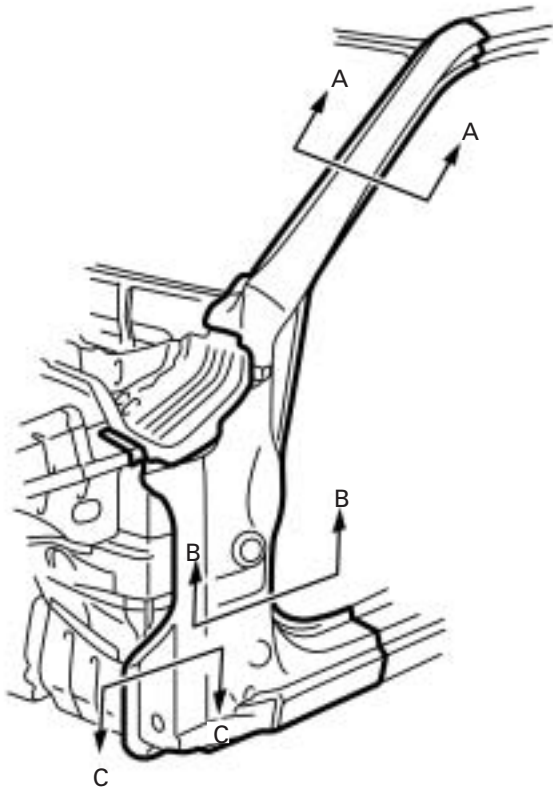
1. Cut off a 100 mm (3.94 in.) wide piece from the pillar outer's rocker panel section.
2. Cut the new parts for the rocker panel No.1 reinforcement at the locations as shown above.
3. Cut off a 130 mm (5.12 in.) wide piece from the pillar inner upper section.
4. Before temporarily installing the new parts weld the outer pillar, front body pillar upper reinforce, rocker panel No.1 reinforcement and inner pillar with standard points.





5. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.
6. Before welding the new parts, check the fit of the front door, front fender and windshield glass.





[Foamed Materials Application Areas]

A - A



B - B



C - C

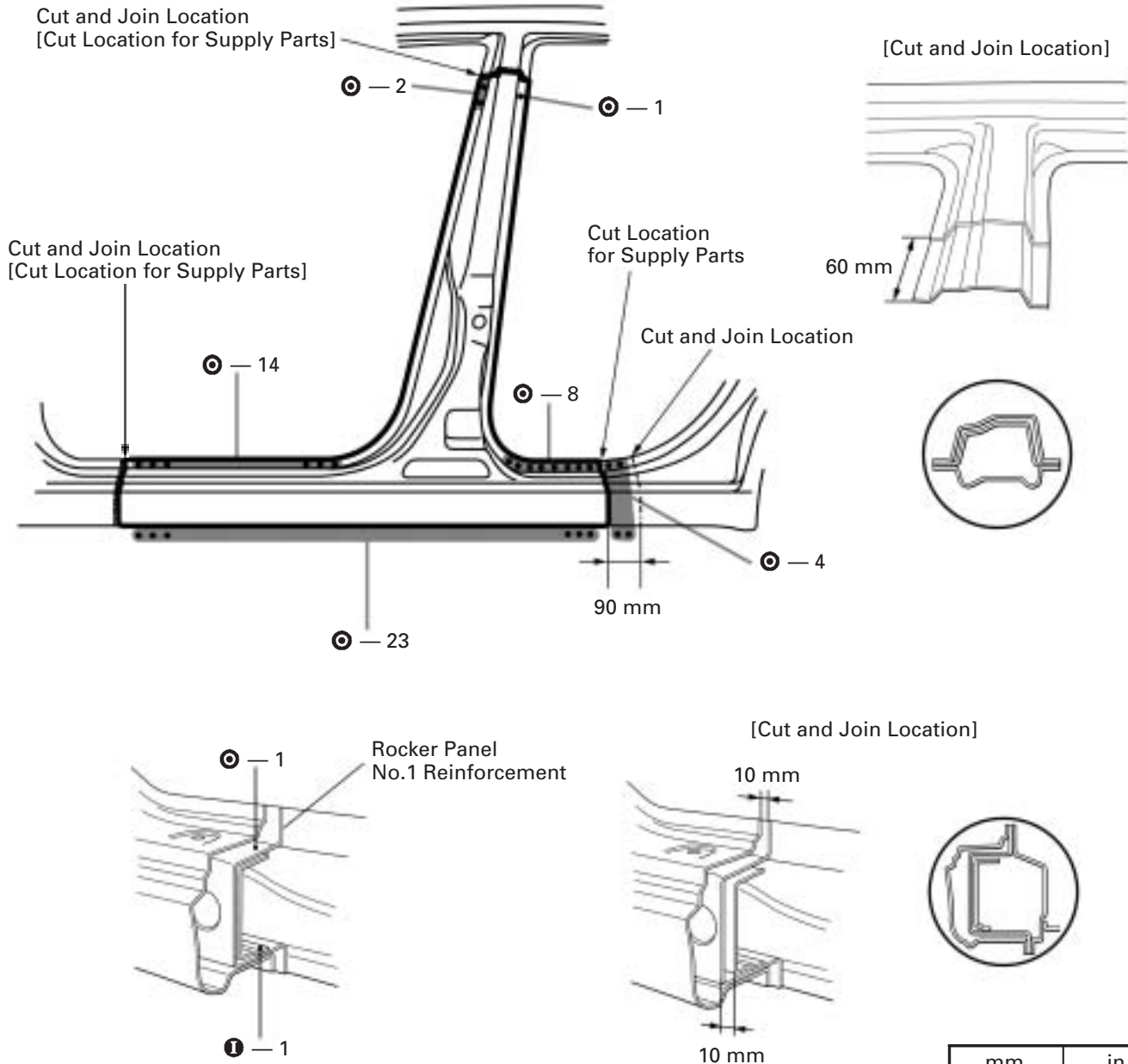
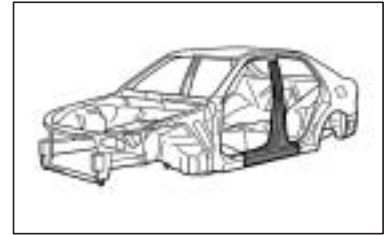


7. After installing the new parts, apply foamed materials.

– MEMO –

CENTER BODY PILLAR (CUT)

REMOVAL



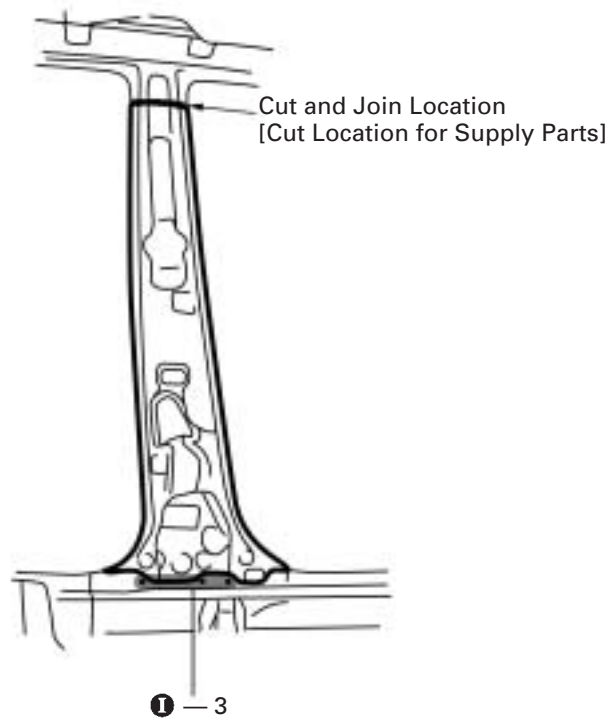
mm	in.
10	0.39
60	2.36
90	3.54

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

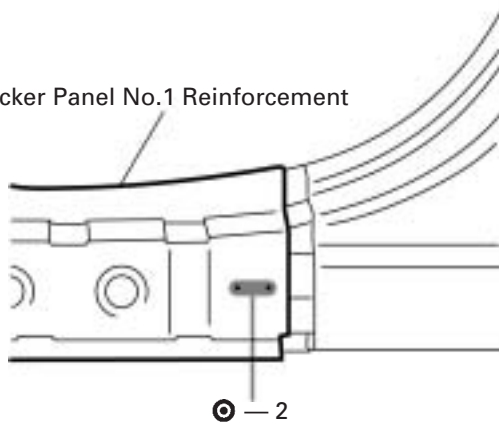
HINT:

- 1) Shift the each cut and join locations of the center outer pillar, reinforcement and inner pillar.
- 2) Shift the each cut and join locations of the rocker outer and rocker panel No.1 reinforcement.

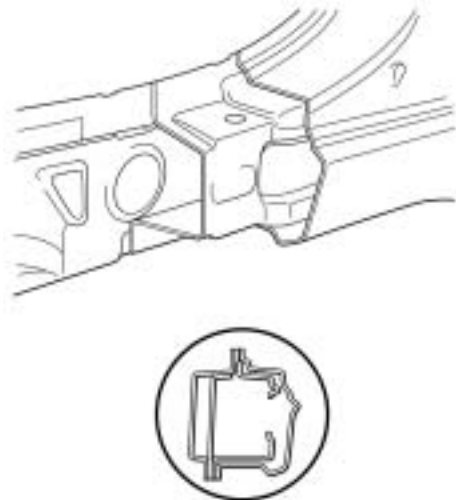
2. In order to cut the rocker panel rear section behind the cut location for supply parts, reuse the quarter panel section.
3. Remove the quarter panel at the location shown above, and remove the rocker panel No.1 reinforcement.



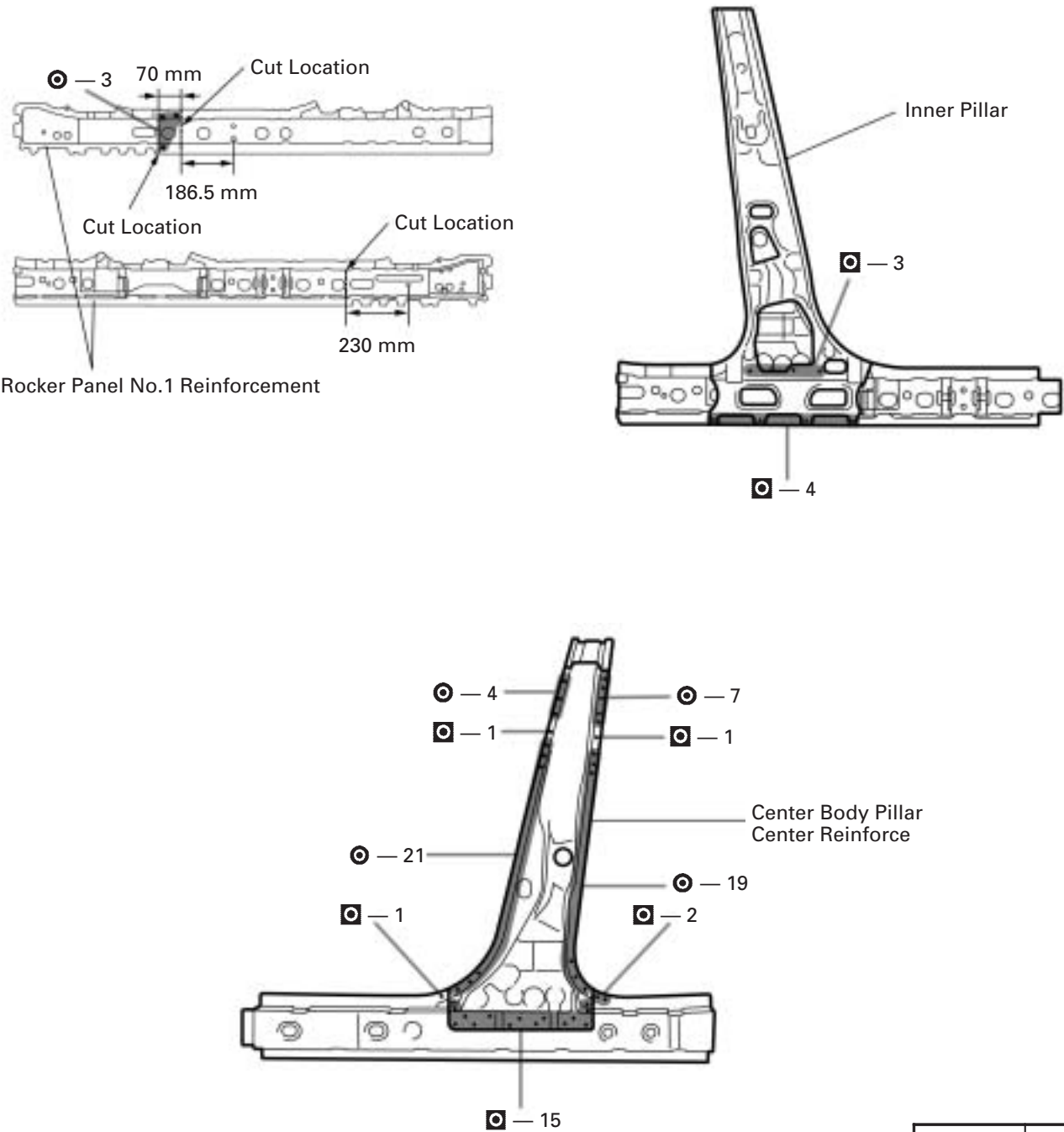
Rocker Panel No.1 Reinforcement



[Cut and Join Location]



INSTALLATION

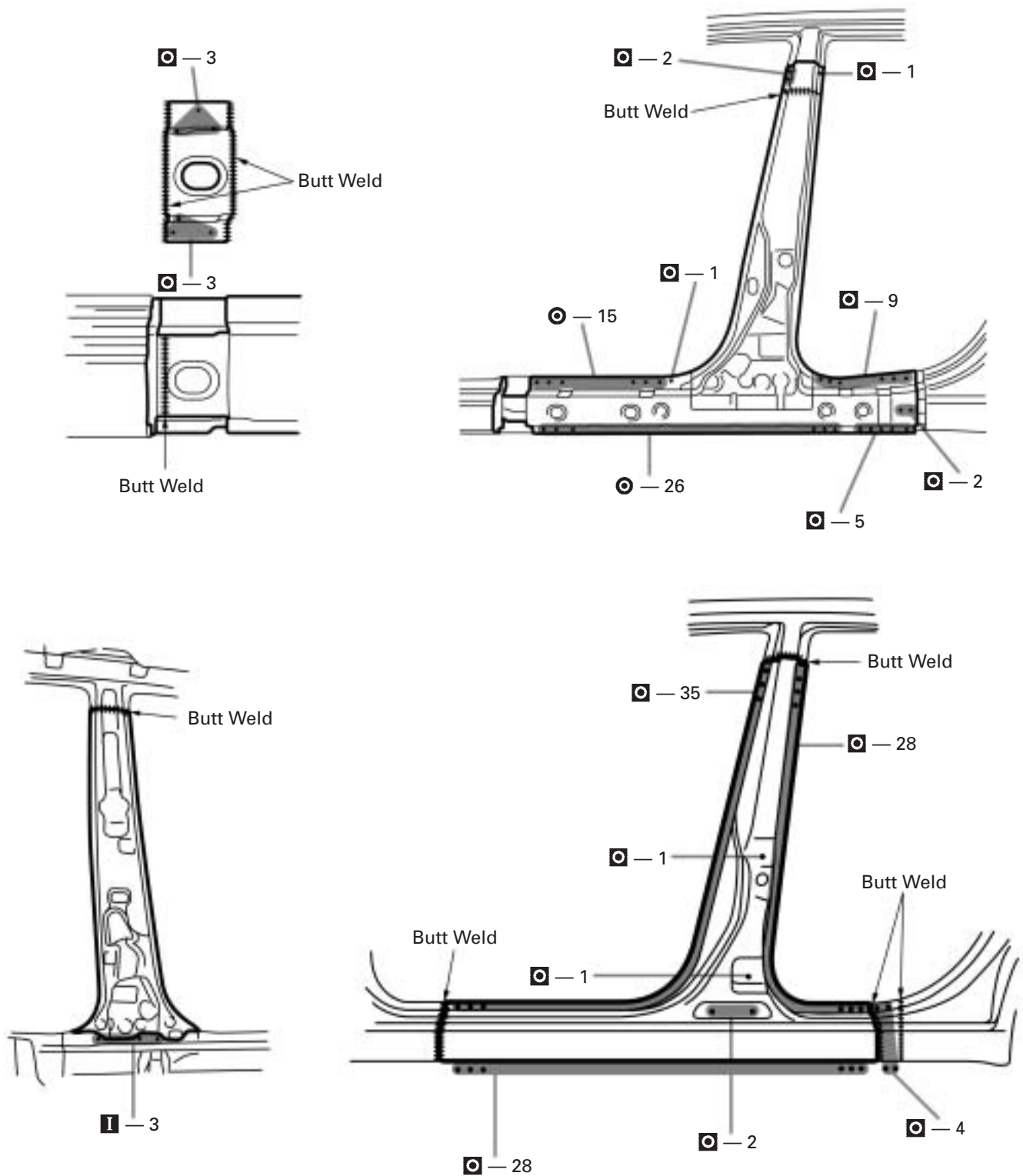


mm	in.
70	2.76
186.5	7.343
230	9.06

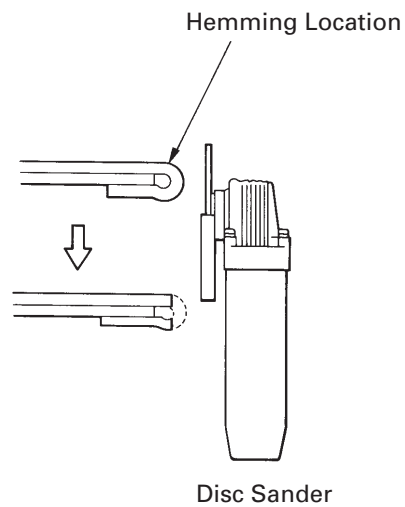
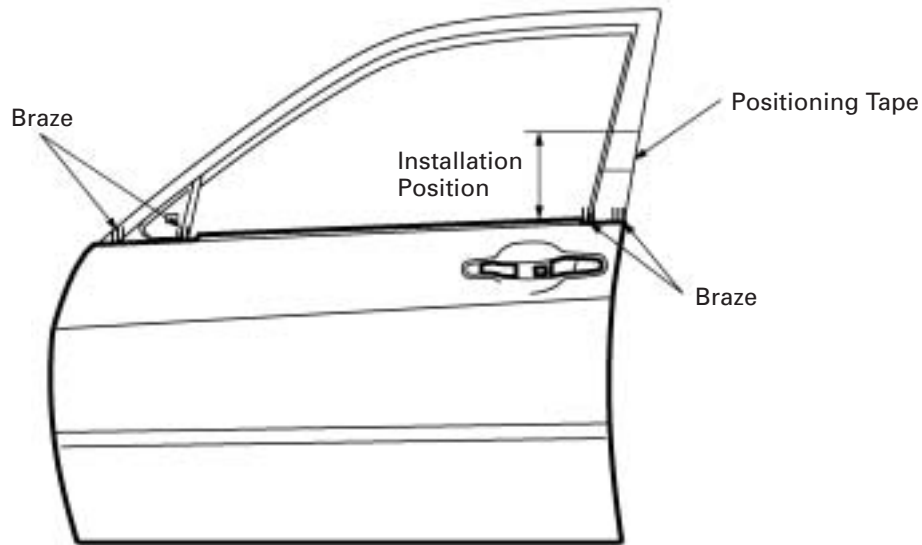
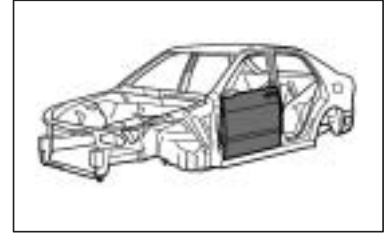
1.

Cut the new parts for the rocker panel No.1 reinforcement at the locations as shown above.
2.

Before temporarily installing the new parts, weld the center body pillar center reinforcement, rocker panel No.1 reinforcement and inner pillar with standard points.

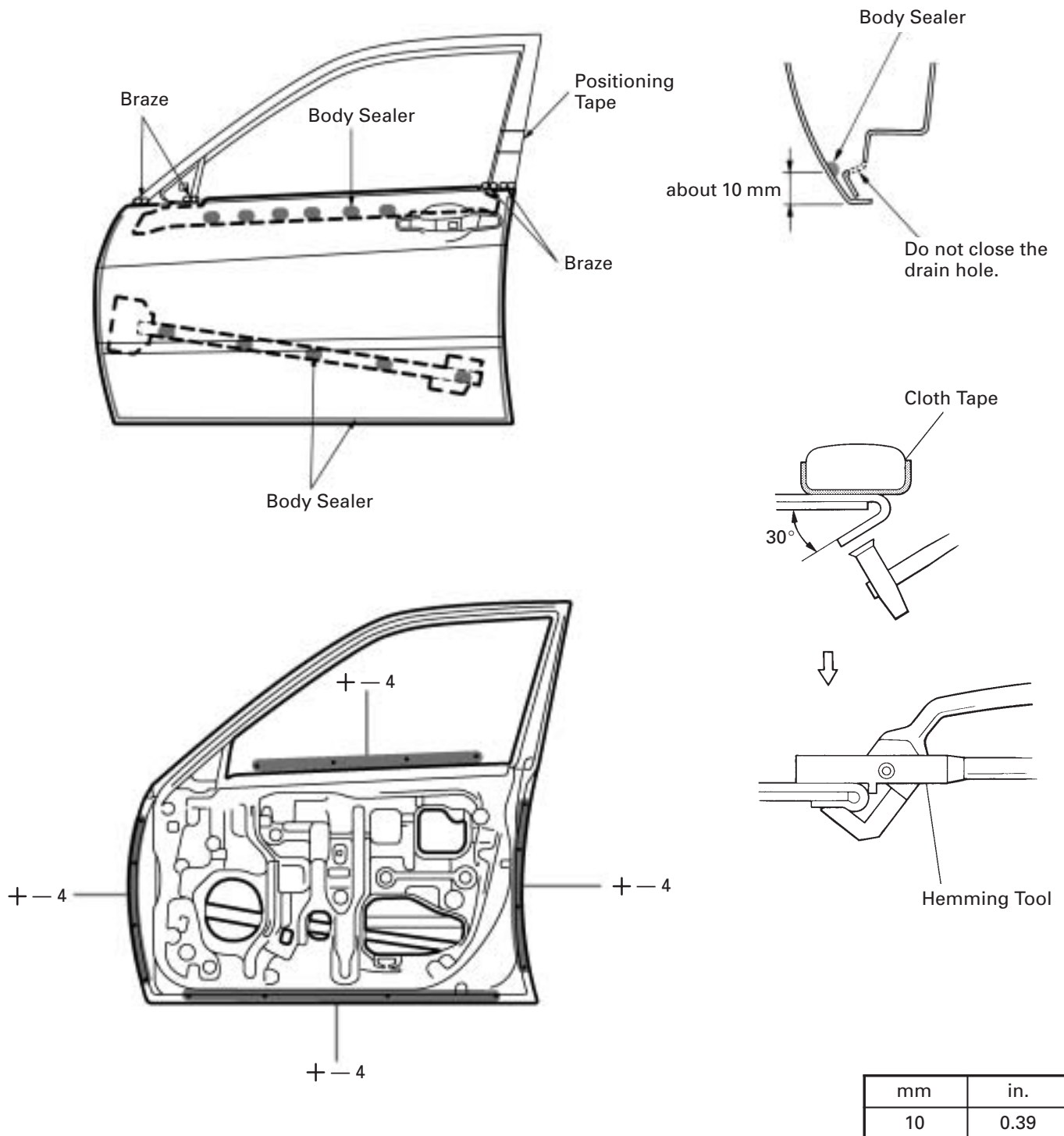


3. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.
4. Before welding the new parts, check the fit of the front door and rear door.
5. After welding the center body pillar center reinforce, rocker panel No.1 reinforcement and inner pillar to the vehicle install the outer pillar.

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

1. Before removing the outer panel, make the installation position with a tape.
2. After grinding off the hemming location, remove the outer panel.

INSTALLATION



- 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 just enough sealer for the reinforcement and side impact beam to touch the new panel. Apply sealer evenly around the flange area, about 10 mm (0.39 in) from the edge, as shown.
- 2) For other sealing points, refer to section AR.

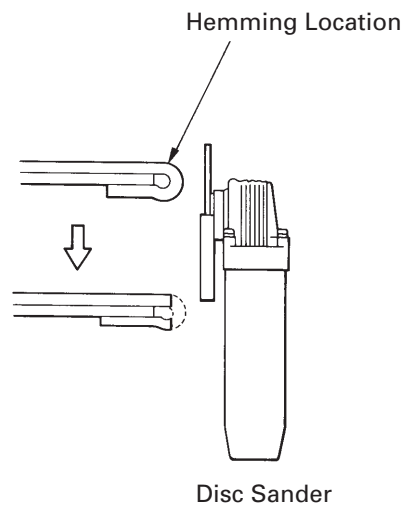
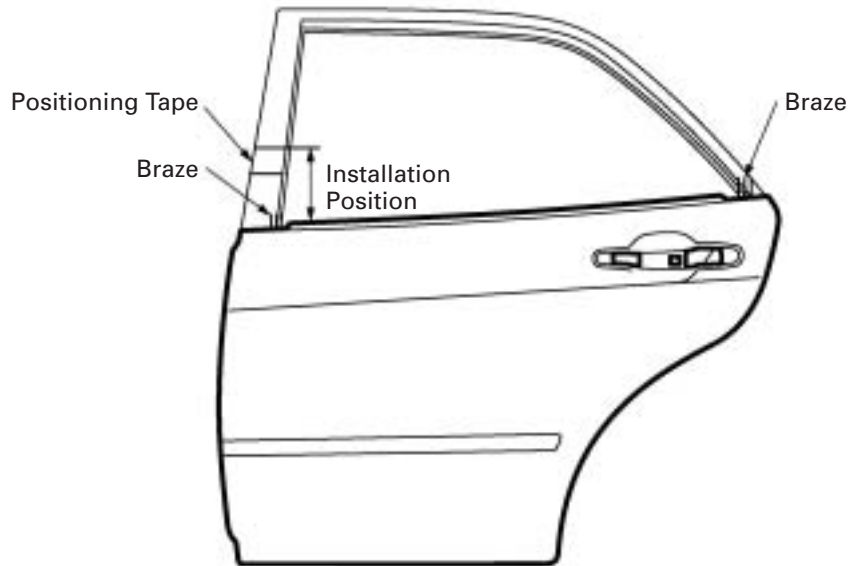
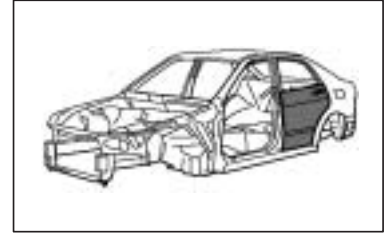
- Bend the flange hem about 30° with a hammer and dolly, then fasten tightly with a hemming tool.

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.

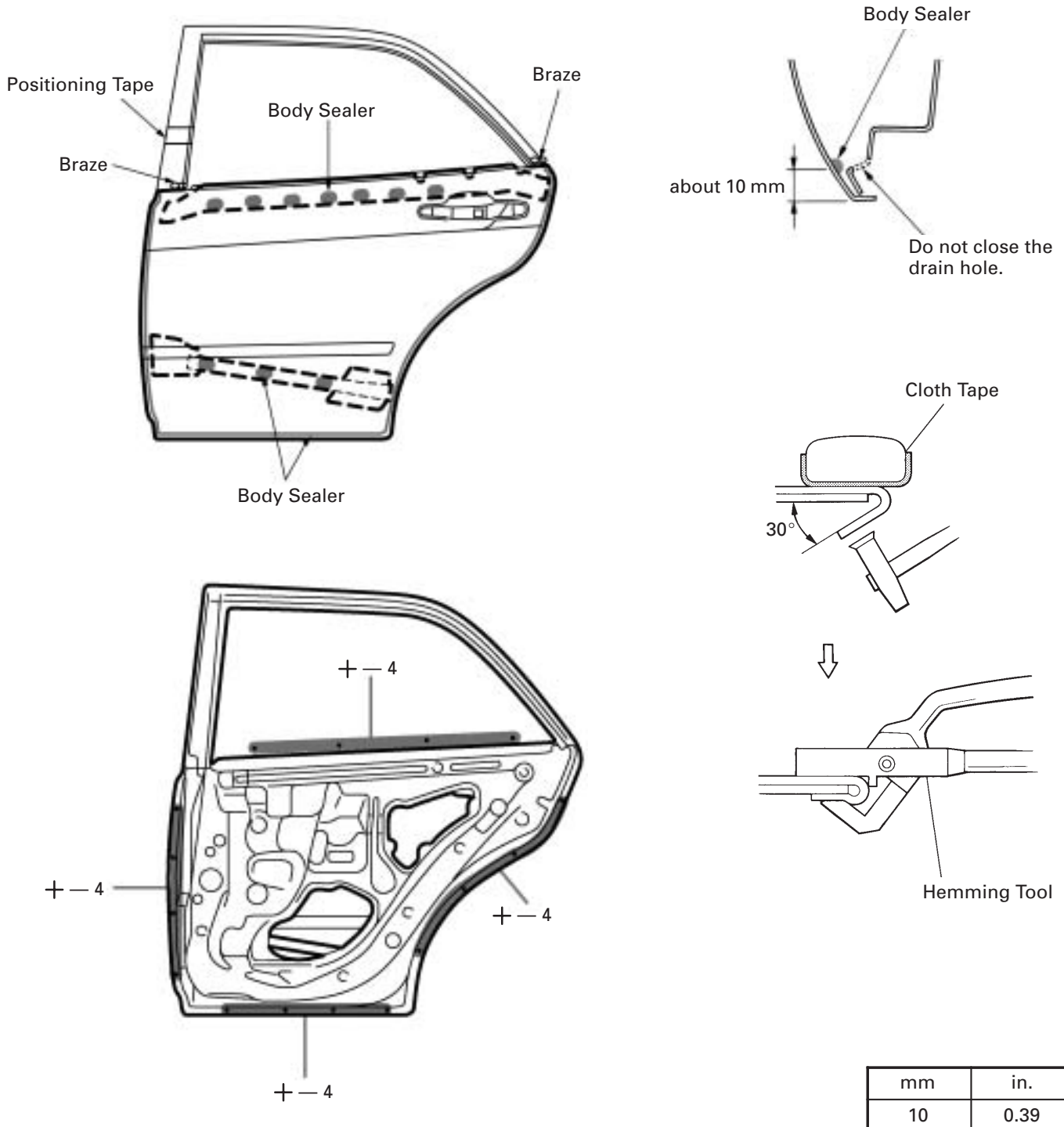
REAR DOOR OUTER PANEL (ASSY)

REMOVAL



1. Before removing the outer panel, make the installation position with a tape.
2. After grinding off the hemming location, remove the outer panel.

INSTALLATION



- 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 just enough sealer for the reinforcement and side impact beam to touch the new panel. Apply sealer evenly around the flange area, about 10 mm (0.39 in.) from the edge, as shown.
- 2) For other sealing points, refer to section AR.

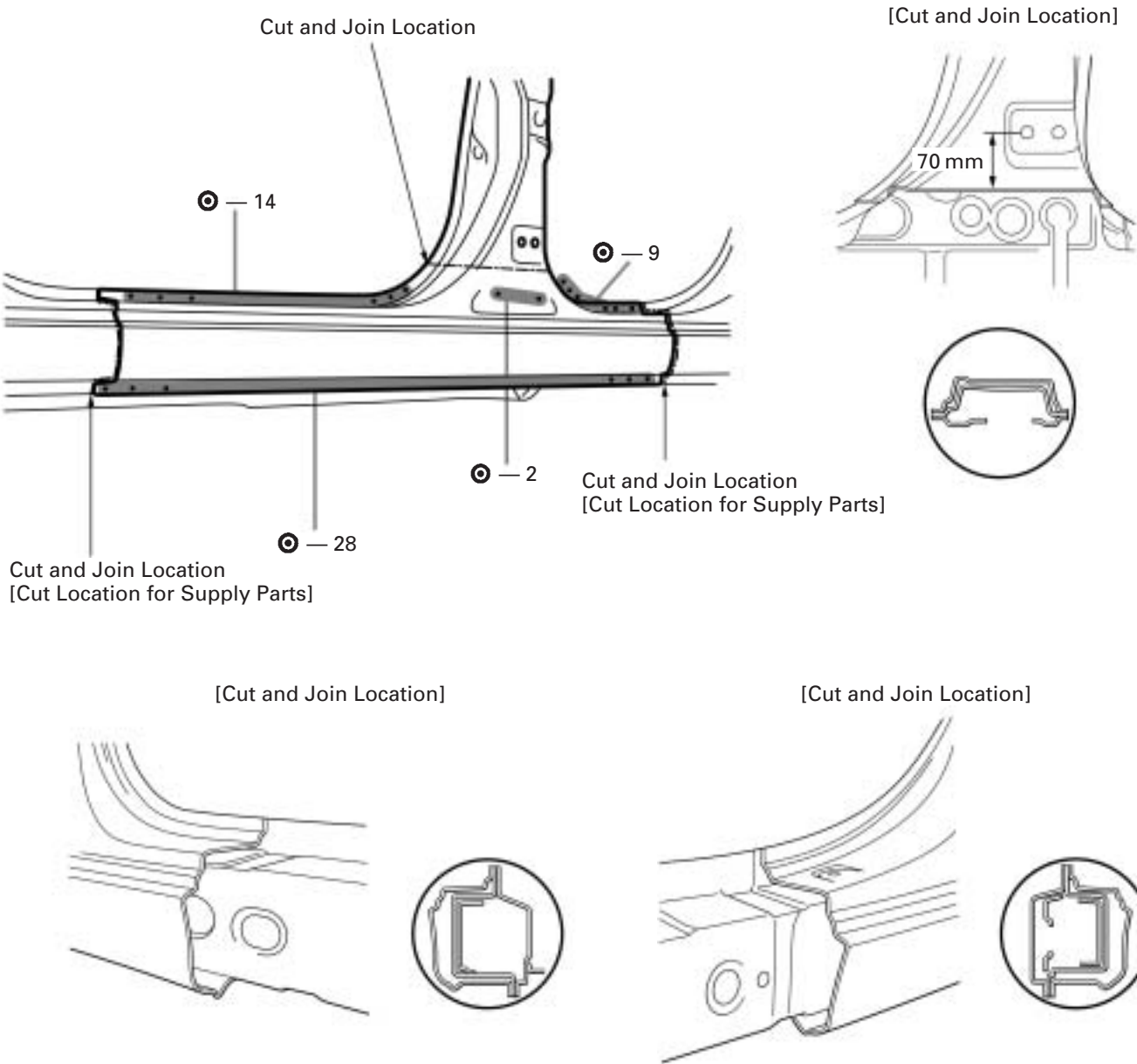
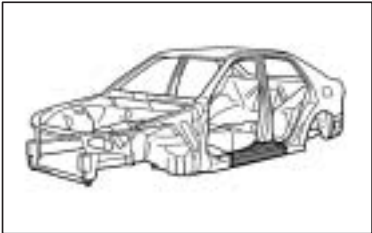
2. Bend the flange hem about 30° with a hammer and dolly, then fasten tightly with a hemming tool.

HINT:

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

ROCKER OUTER PANEL (CUT)

REMOVAL

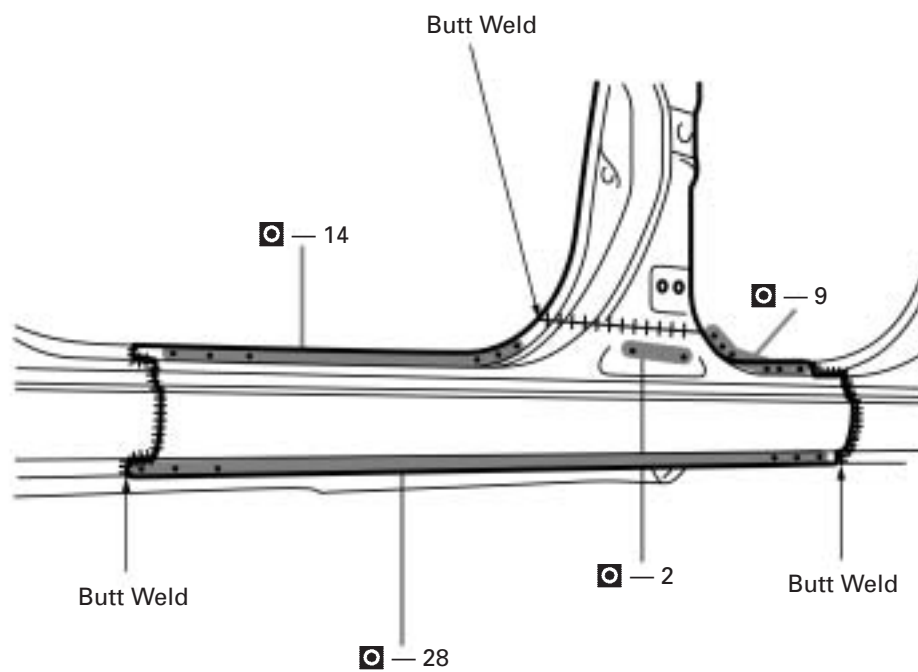


- 1. Cut and join the parts at the locations as shown above.

HINT: Take care not to damage the internal reinforcement of the rocker panel and center body pillar.

mm	in.
70	2.76

INSTALLATION



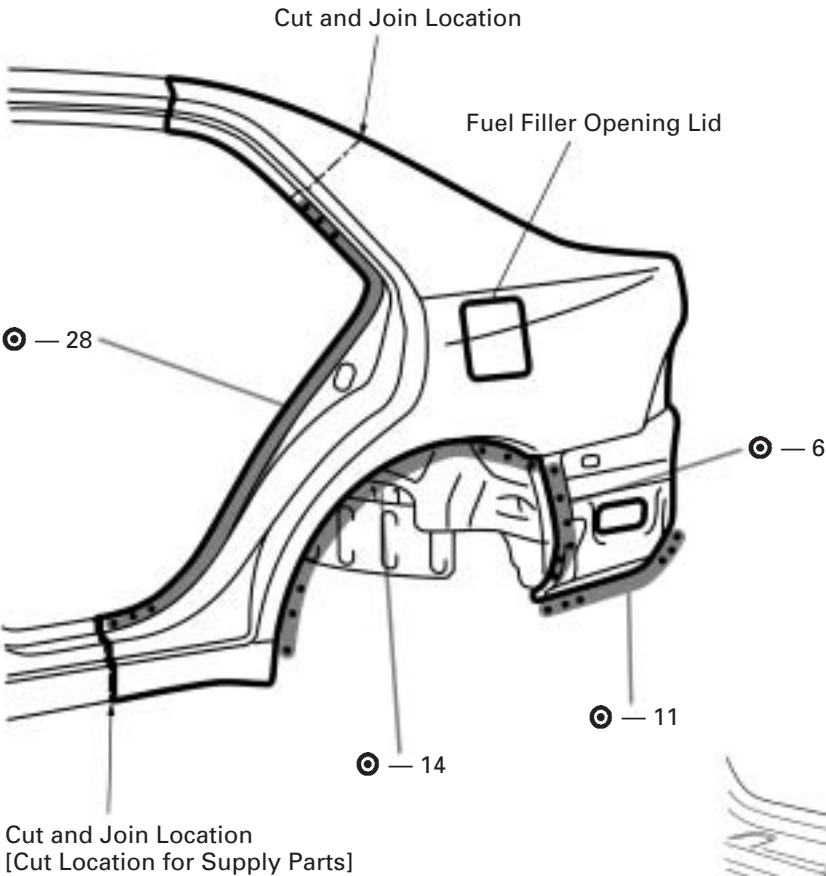
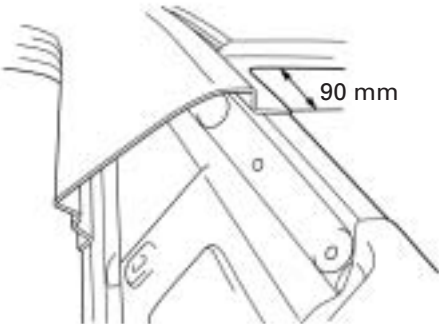
1. Temporarily install the new parts and check the fit of the front door and rear door.

QUARTER PANEL (CUT)

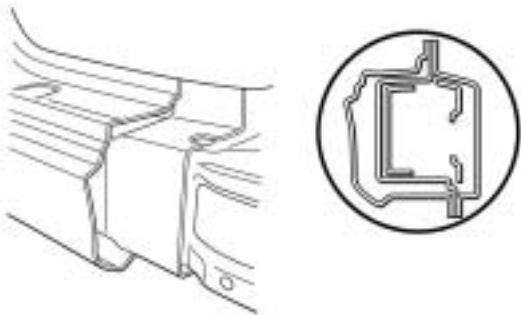
REMOVAL



[Cut and Join Location]

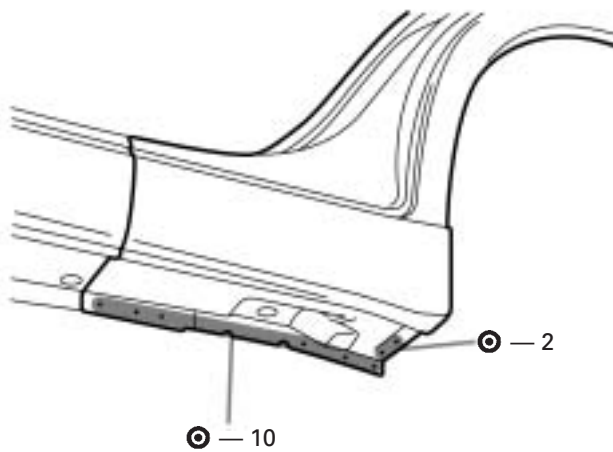
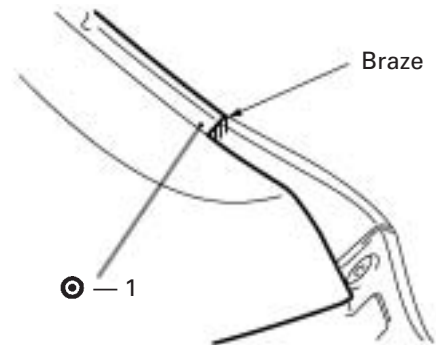
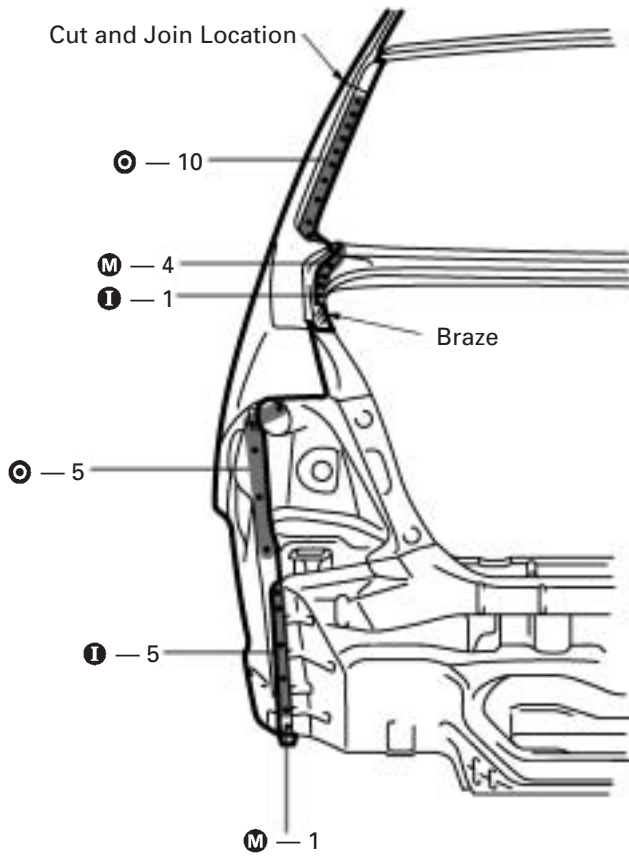


[Cut and Join Location]

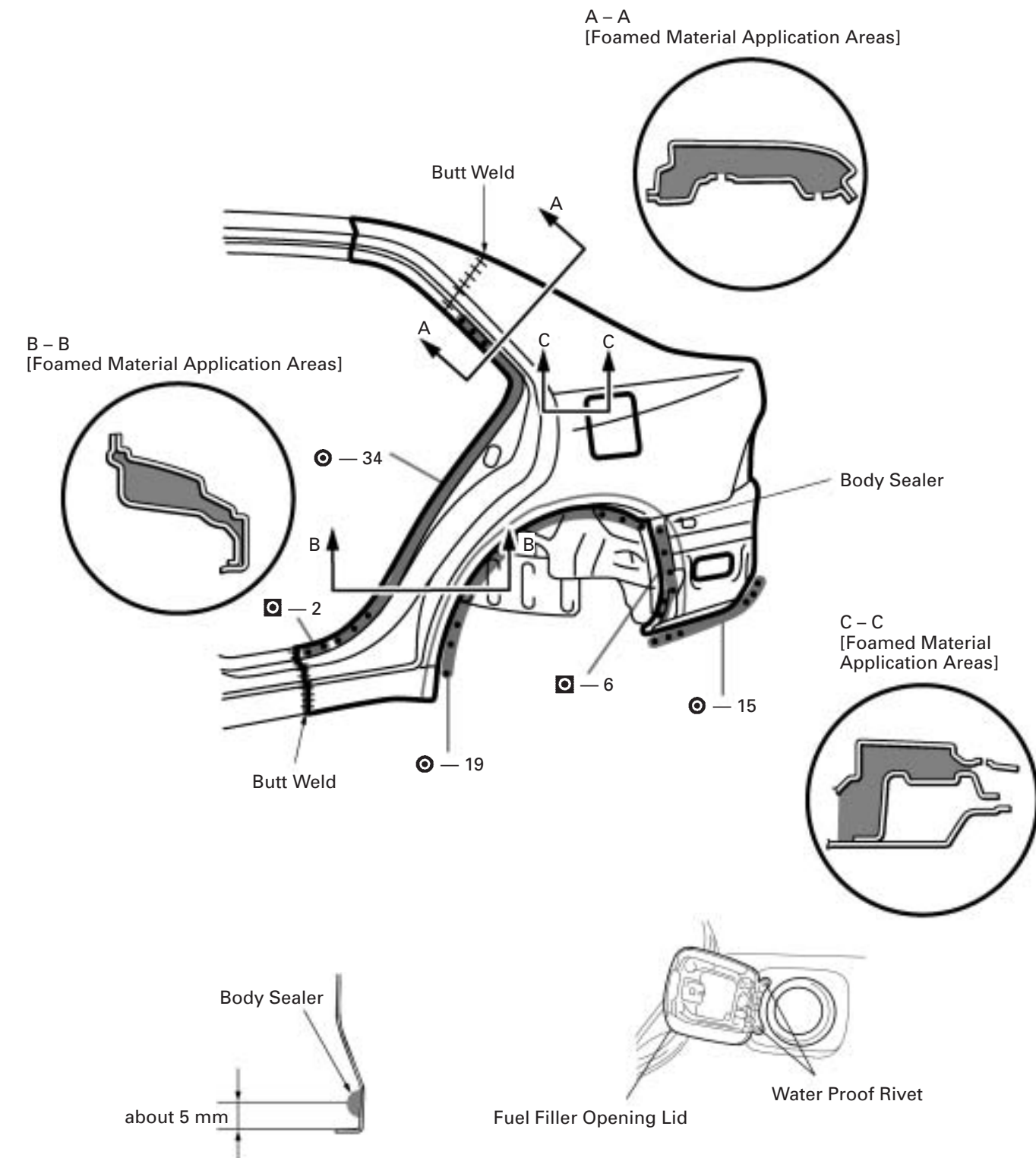


mm	in.
90	3.54

1. Cut and join the parts at the locations as shown above.
2. Replace the fuel filler opening lid at the same time as the quarter panel.



INSTALLATION

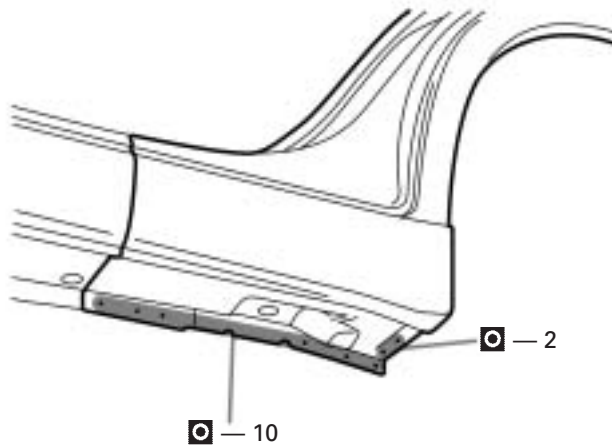
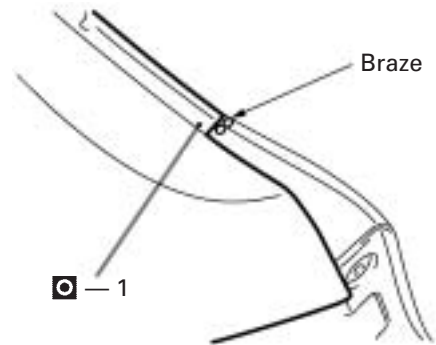
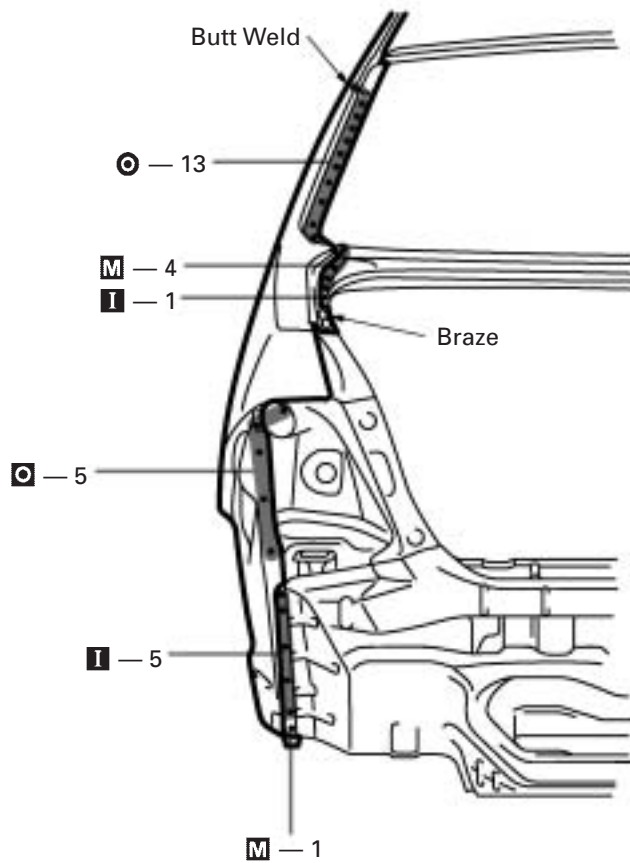


1. Before temporarily installing the new parts, apply body sealer to the wheel arch.

HINT:

- 1) Apply body sealer 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.
- 3) For other sealing points, refer to section AR.

2. Temporarily install the new parts and check the fit of the rear door, luggage compartment door and rear combination light.



3. Attach the fuel filler opening lid by rivets to the quarter panel.

HINT:

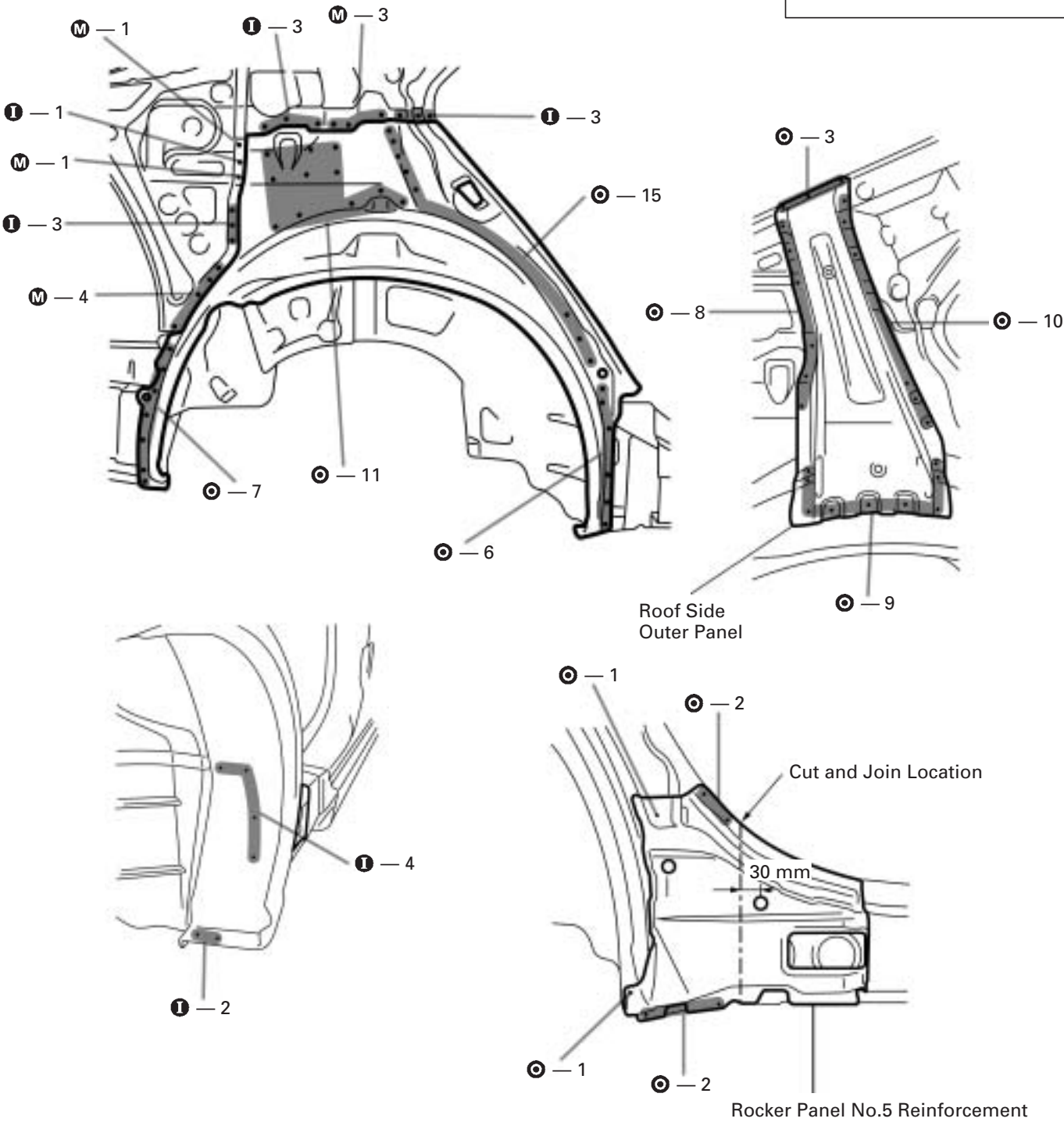
- 1) Use waterproof rivets.
- 2) Refer to the introduction when installing rivets.

4. After installing the new parts, apply foamed materials.

QUARTER WHEEL HOUSING OUTER PANEL
(ASSY): Right Side



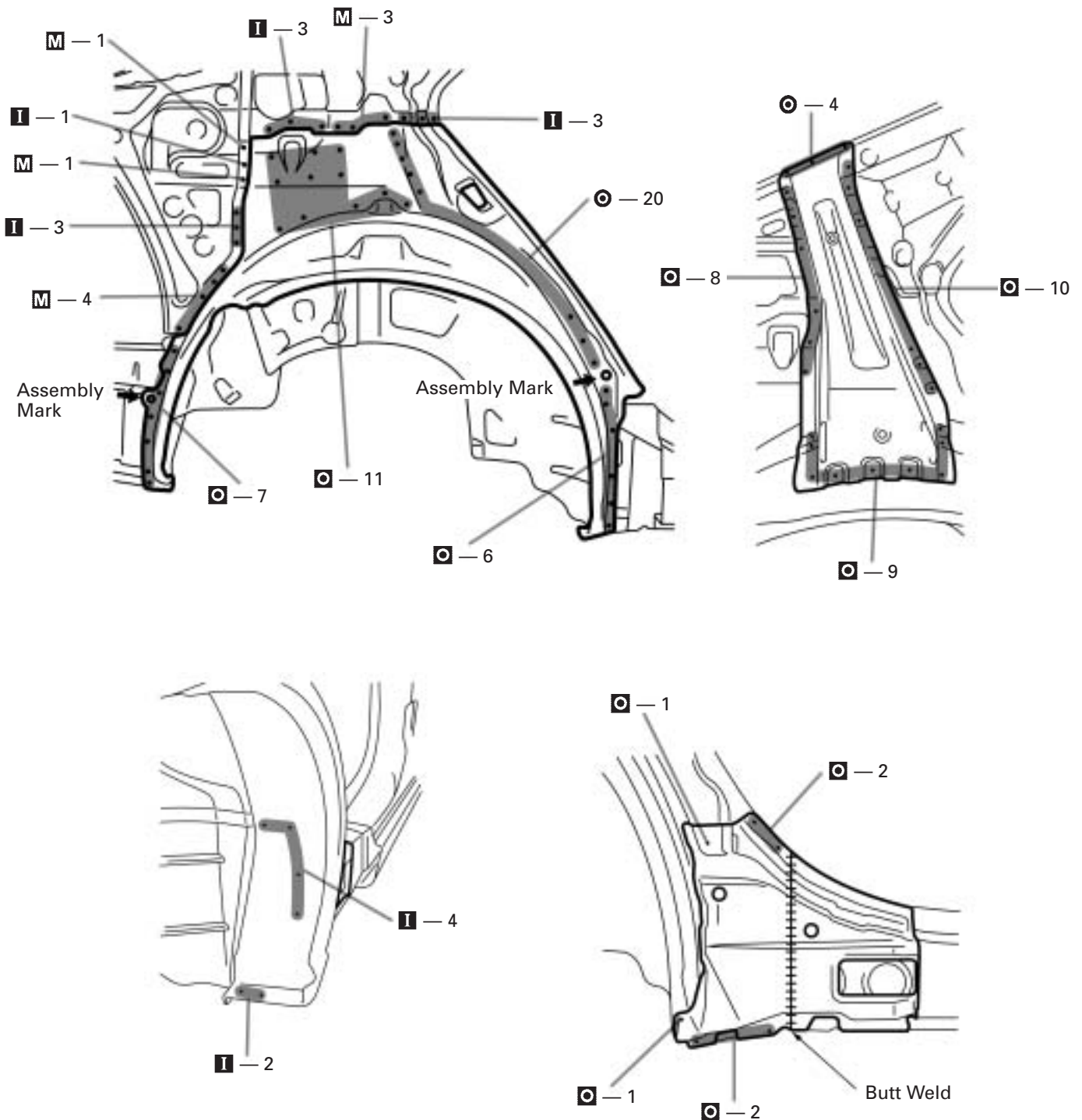
REMOVAL (With the quarter panel removed.)



1. Remove the roof side outer panel and rocker panel No.5 reinforcement at the locations shown above, and remove the quarter wheel housing outer panel.

mm	in.
30	1.18

INSTALLATION

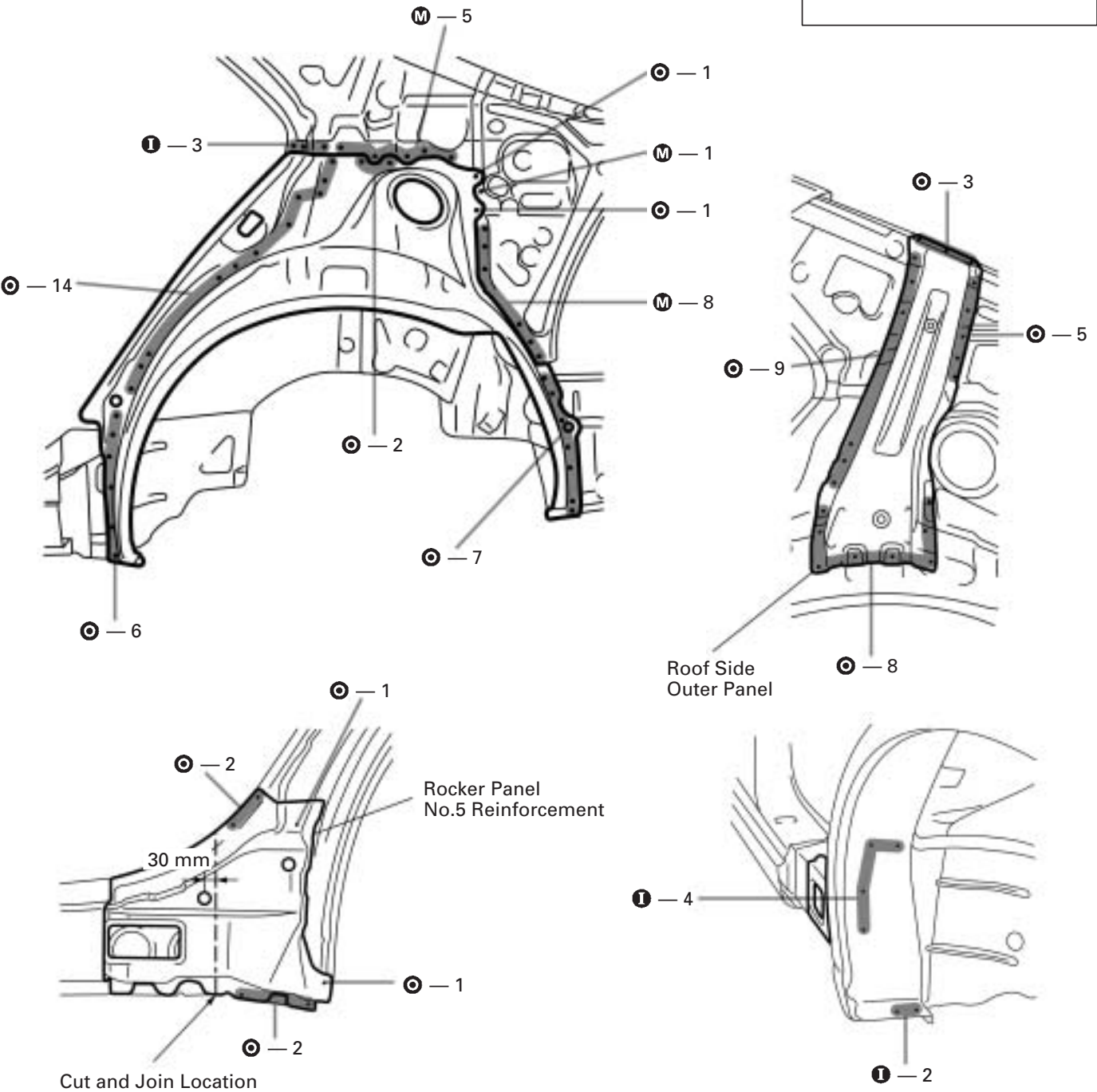


1. Determine the position of the new parts by the assembly marks of the inner and outer panels.
2. Before welding the new parts, temporarily install the quarter panel and check the fit.

QUARTER WHEEL HOUSING OUTER PANEL
(ASSY): Left Side



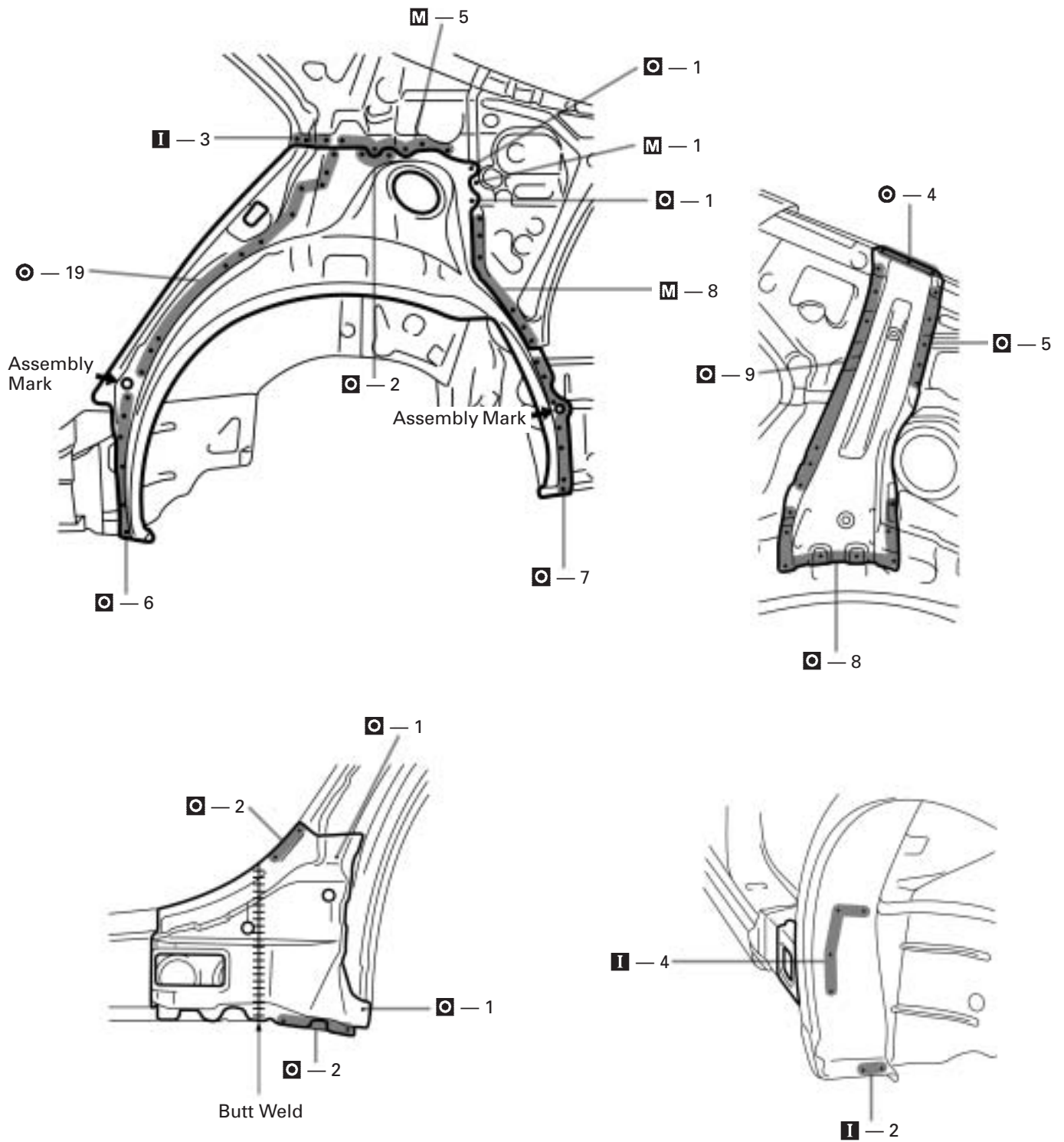
REMOVAL (With the quarter panel removed.)



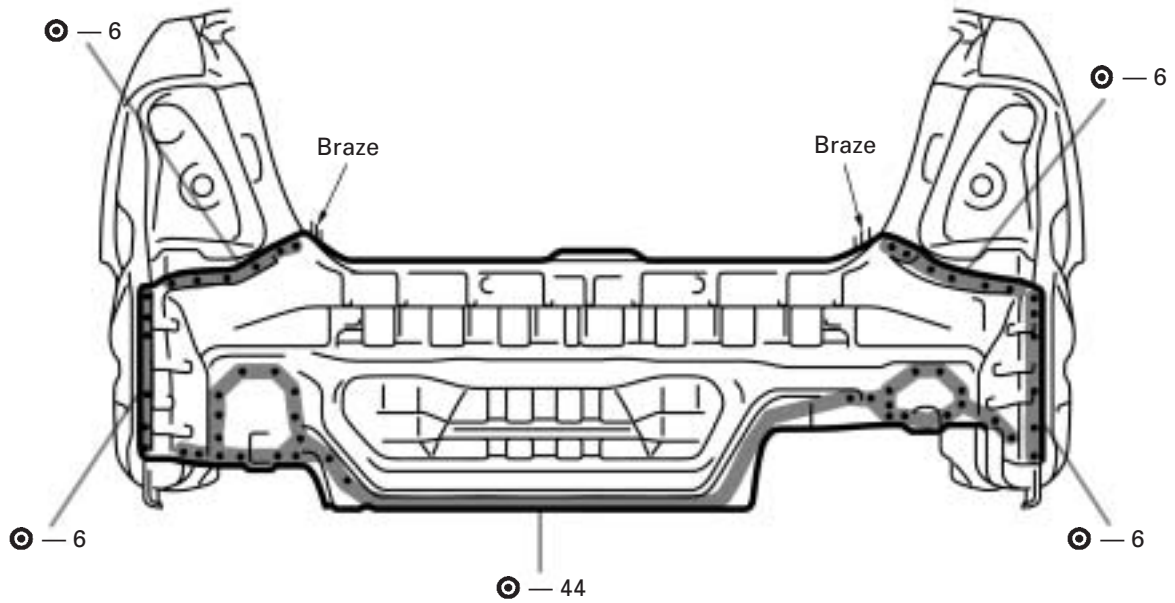
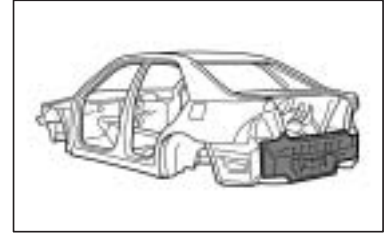
1. Remove the roof side outer panel and rocker panel No.5 reinforcement at the locations shown above, and remove the quarter wheel housing outer panel.

mm	in.
30	1.18

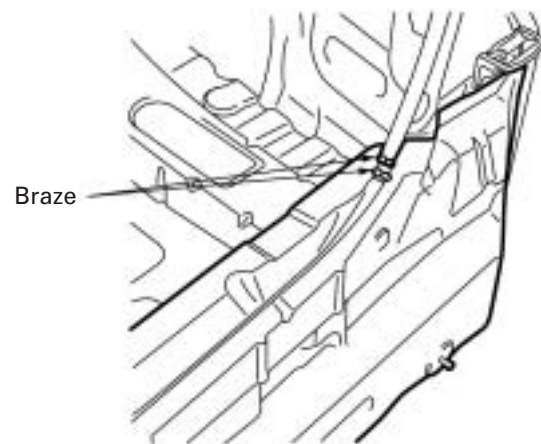
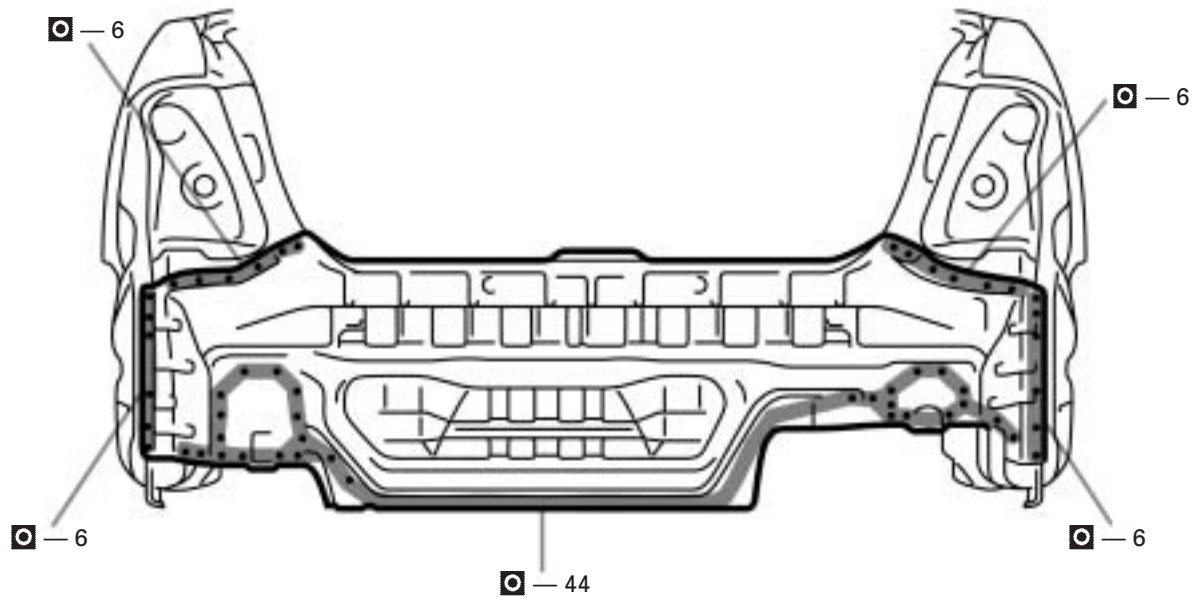
INSTALLATION



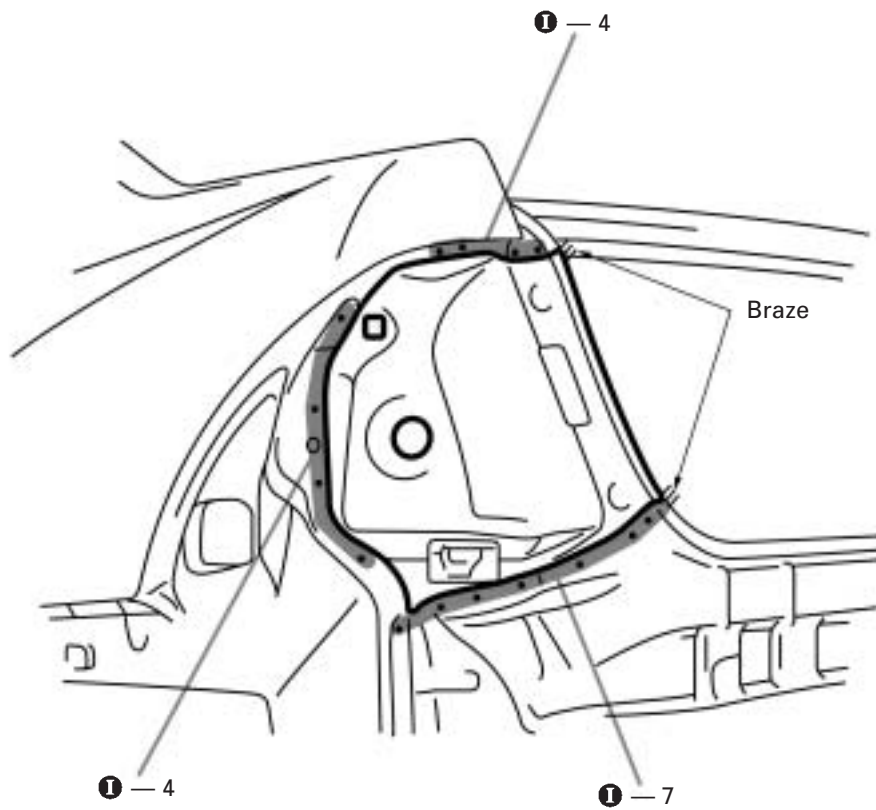
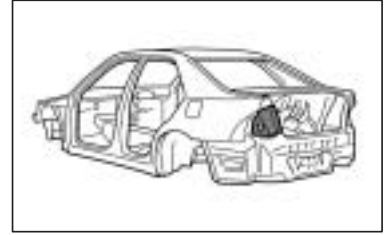
1. Determine the position of the new parts by the assembly marks of the inner and outer panels.
2. Before welding the new parts, temporarily install the quarter panel and check the fit.

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

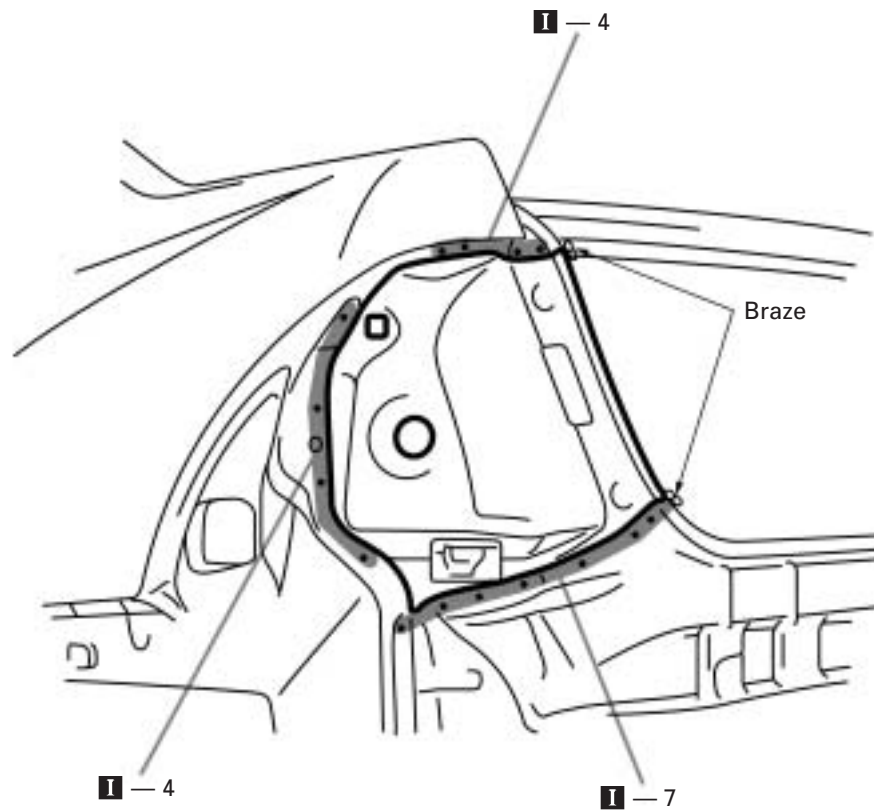
INSTALLATION



1. Temporarily installing the new parts, check the fit of the luggage compartment door and rear combination light.

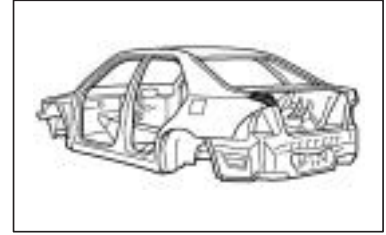
QUARTER PANEL END HOUSING (ASSY)**REMOVAL**

INSTALLATION

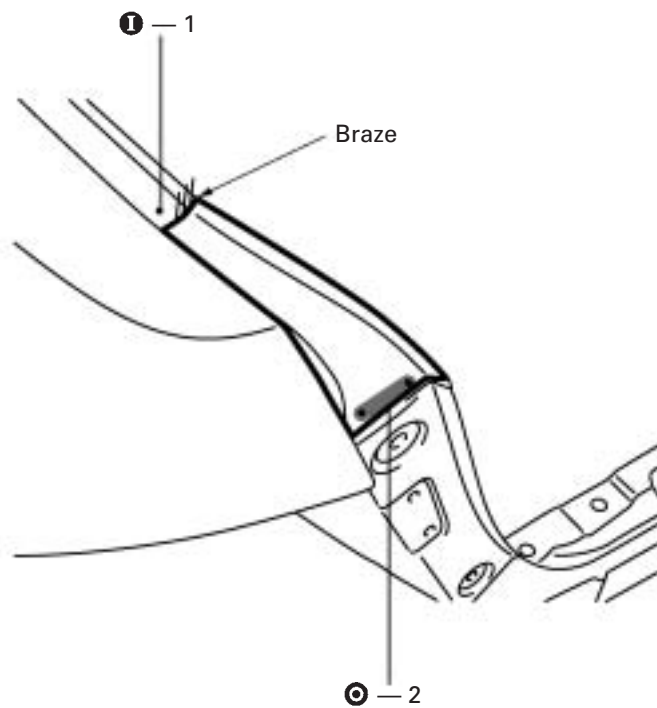
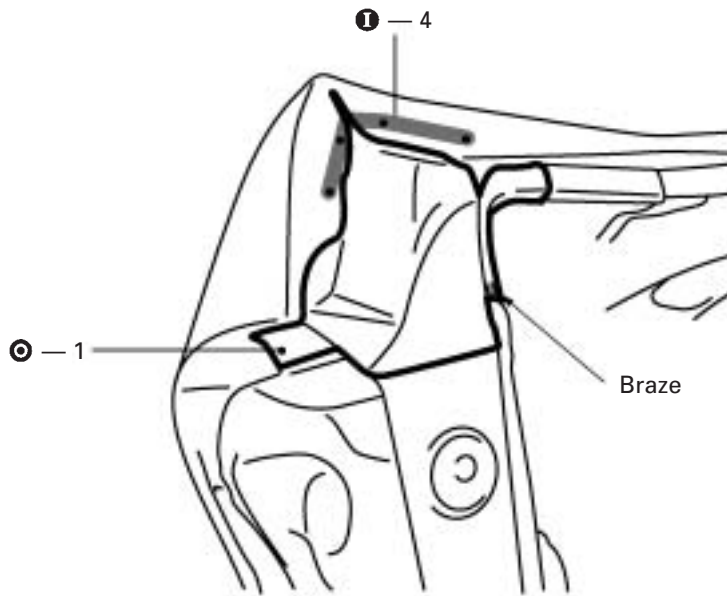


1. Temporarily installing the new parts, check the fit of the luggage compartment door and rear combination light.

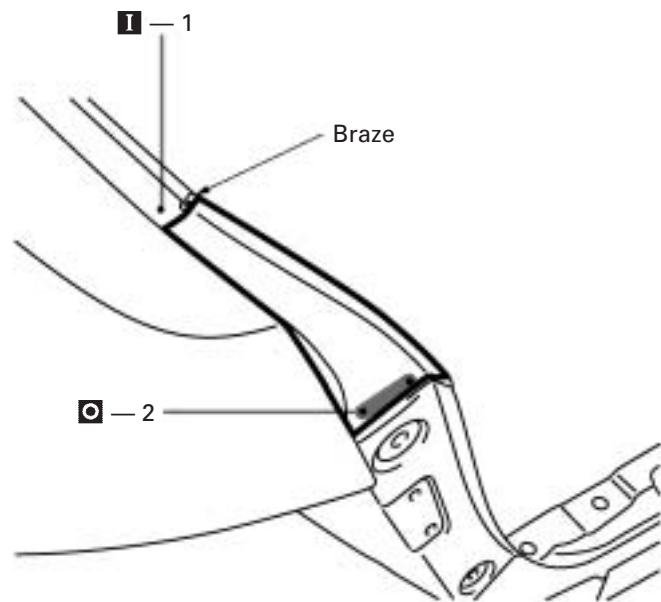
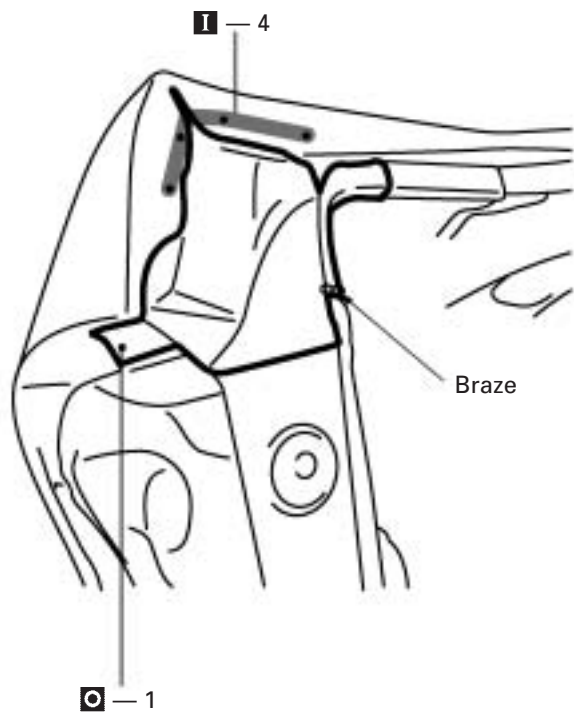
LUGGAGE COMPARTMENT OPENING TROUGH (ASSY)

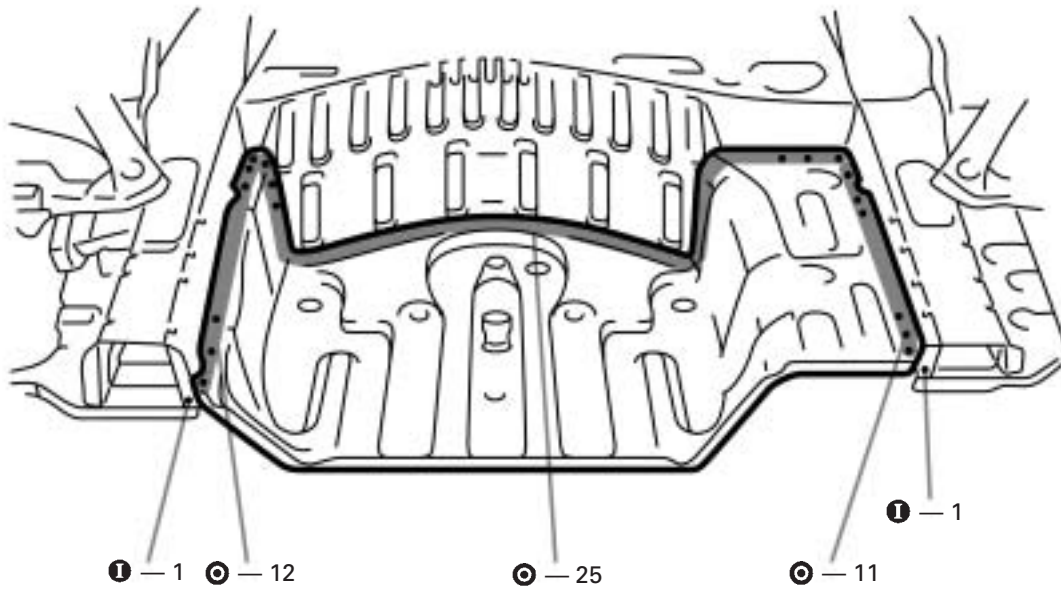


REMOVAL

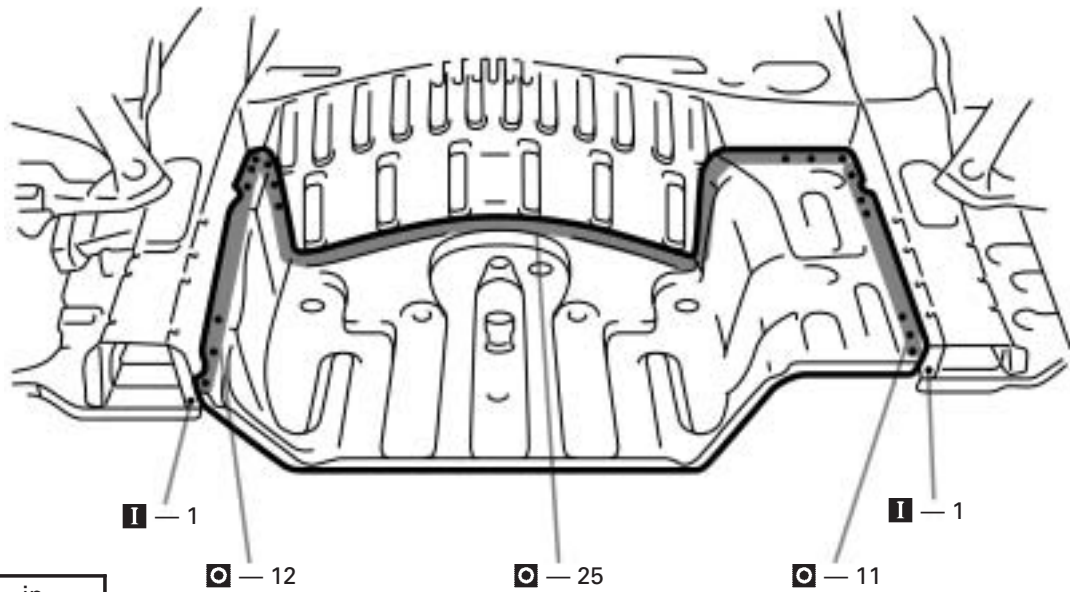
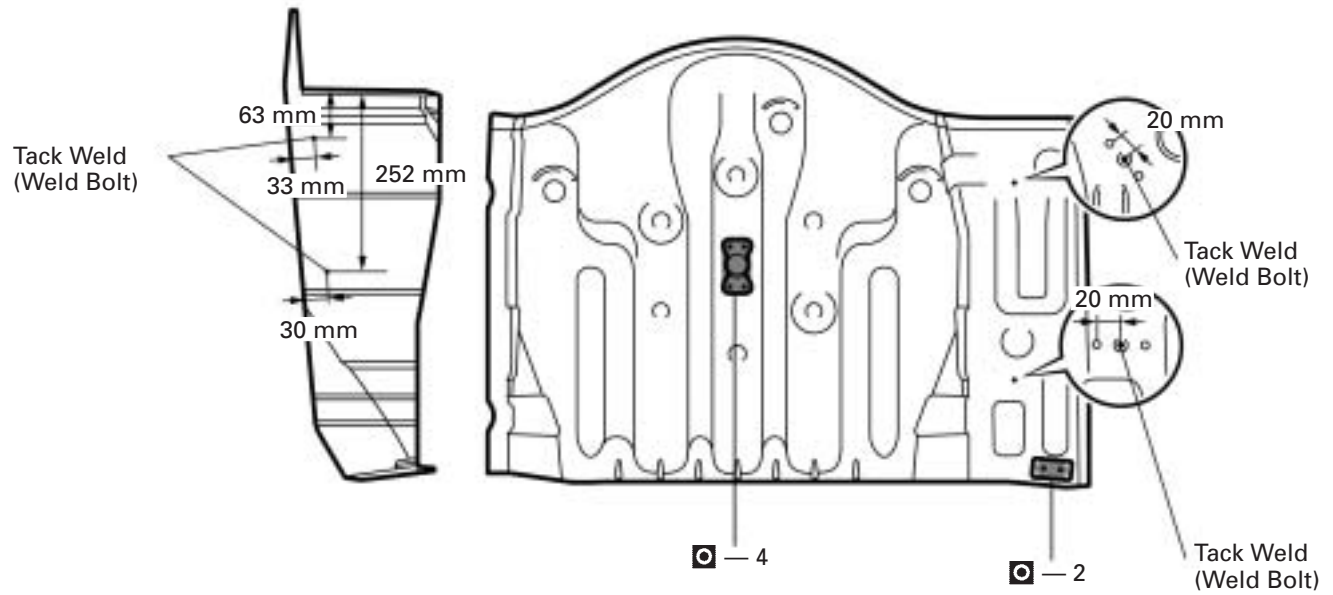


INSTALLATION



REAR FLOOR PAN (ASSY)**REMOVAL (With the body lower back panel removed.)**

INSTALLATION



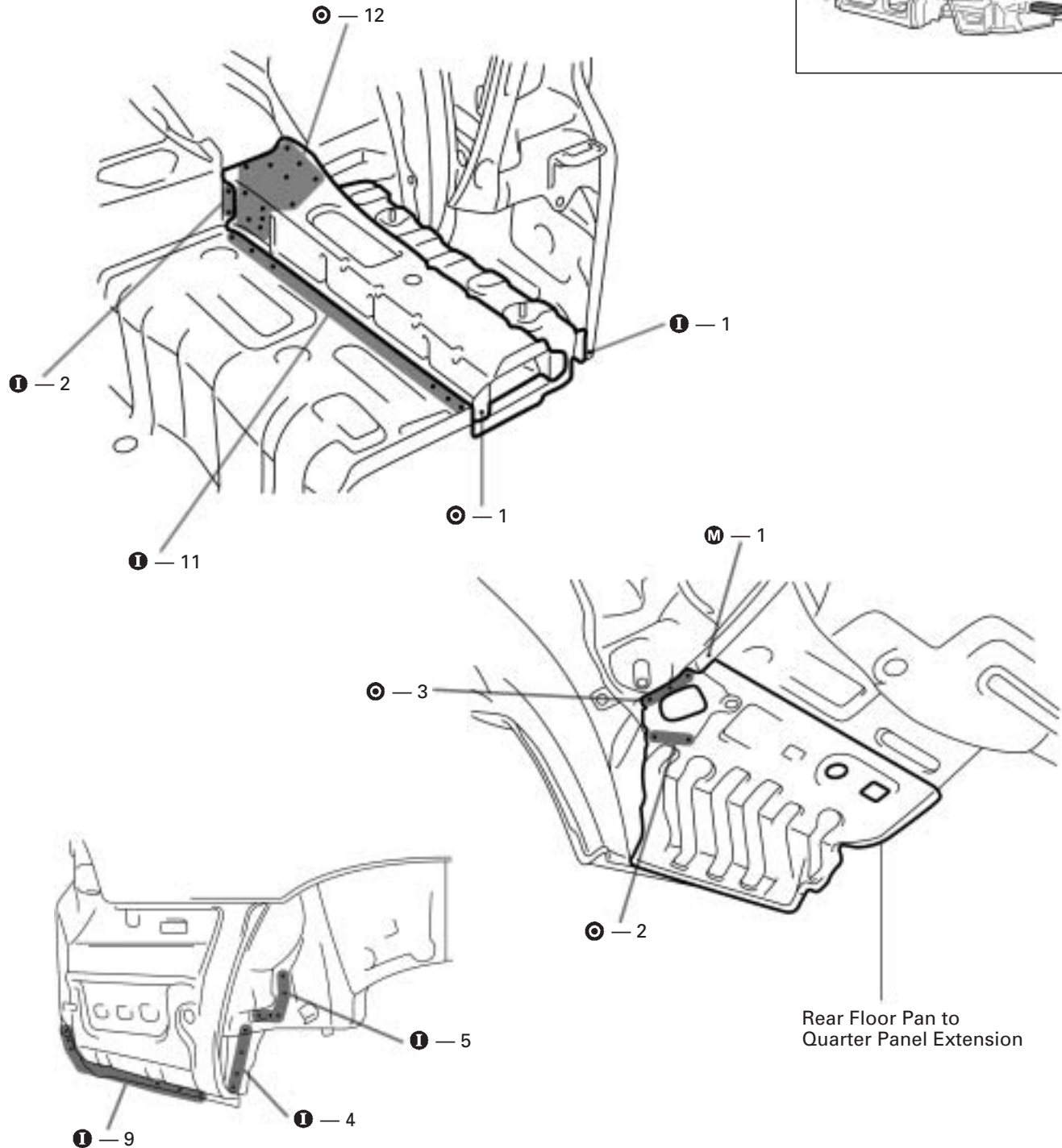
mm	in.
20	0.79
30	1.18
33	1.30
63	2.48
252	9.92

1. Install the weld bolt in the position shown on the above diagram.
2. Before welding the weld bolts, check the fit of the aerodynamic parts.

- MEMO -

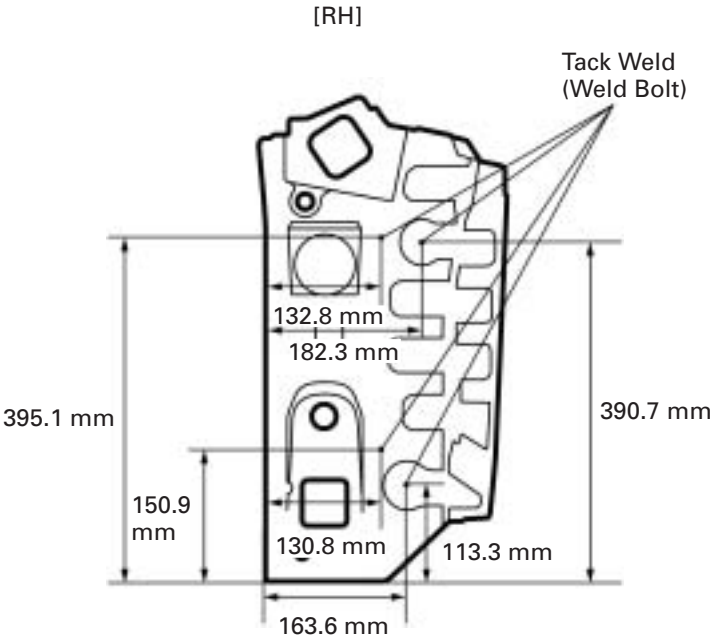
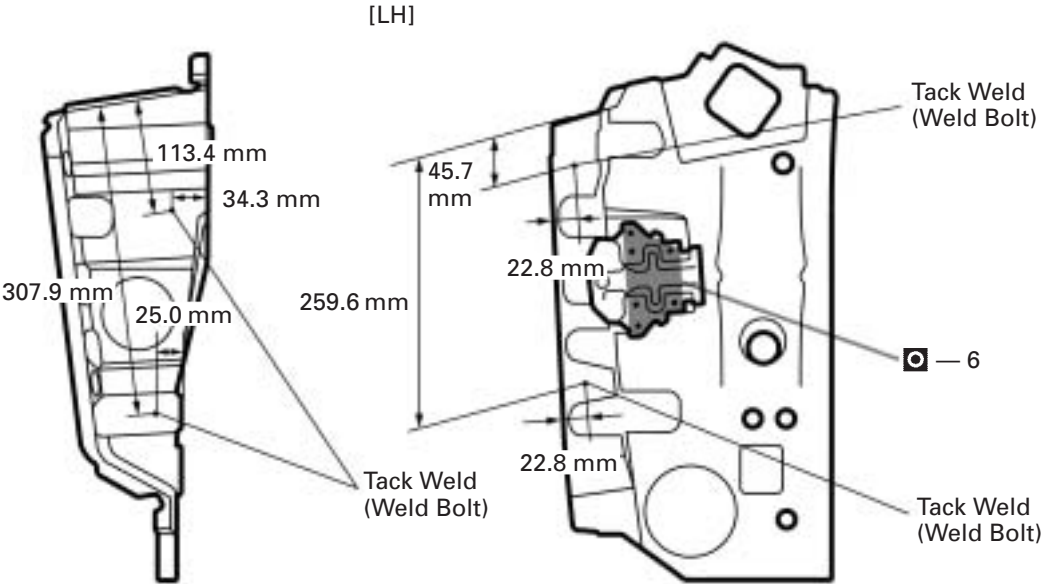
REAR FLOOR SIDE REAR MEMBER (ASSY)

REMOVAL (With the body lower back panel removed.)



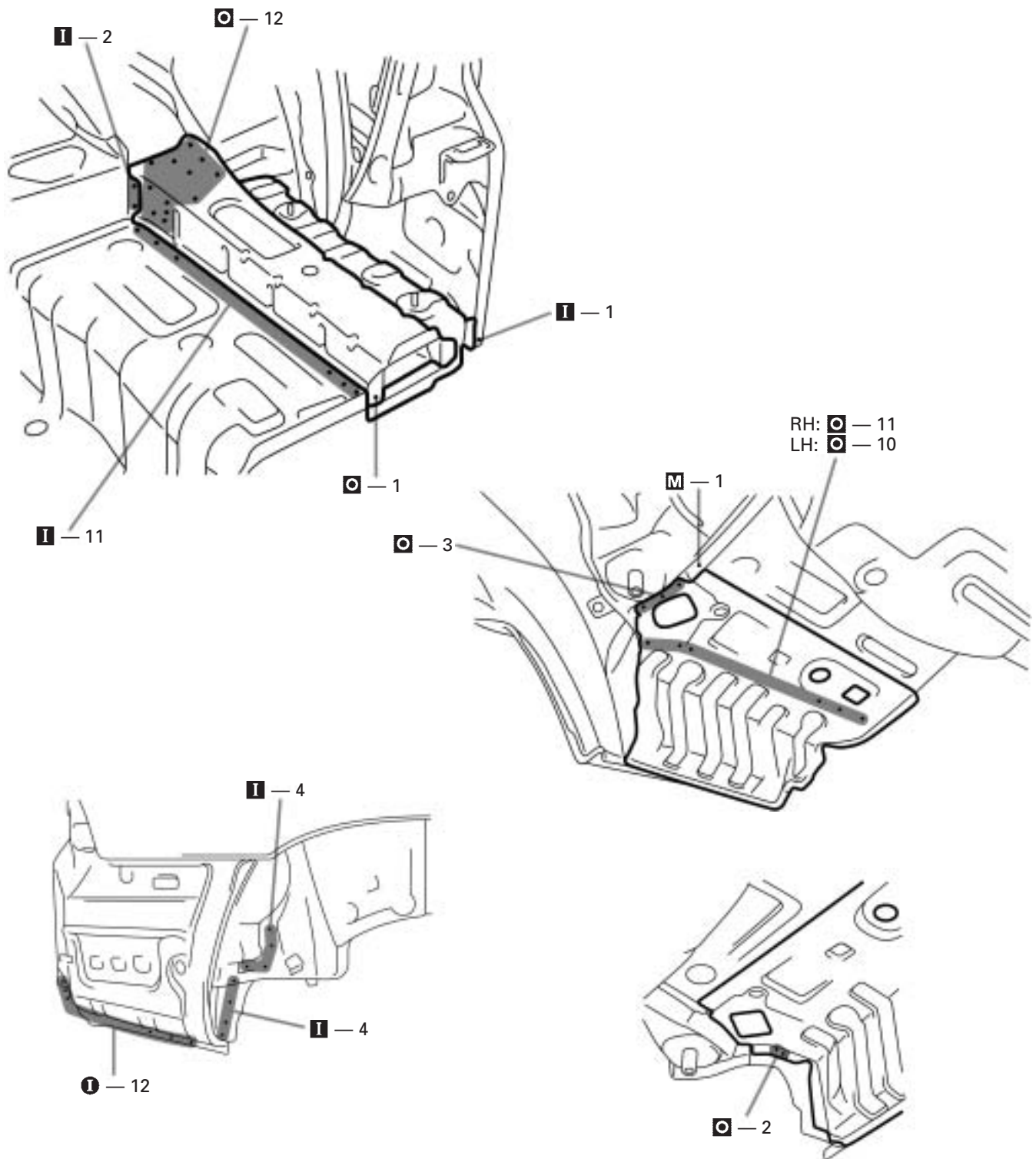
1. Replace the rear floor pan to quarter panel extension at the same time as the rear floor side rear member.

INSTALLATION



mm	in.
22.8	0.898
25.0	0.984
34.3	1.350
45.7	1.799
113.3	4.461
113.4	4.465
130.8	5.150
132.8	5.228
150.9	5.941
163.6	6.441
182.3	7.177
259.6	10.220
307.9	12.122
390.7	15.382
395.1	15.555

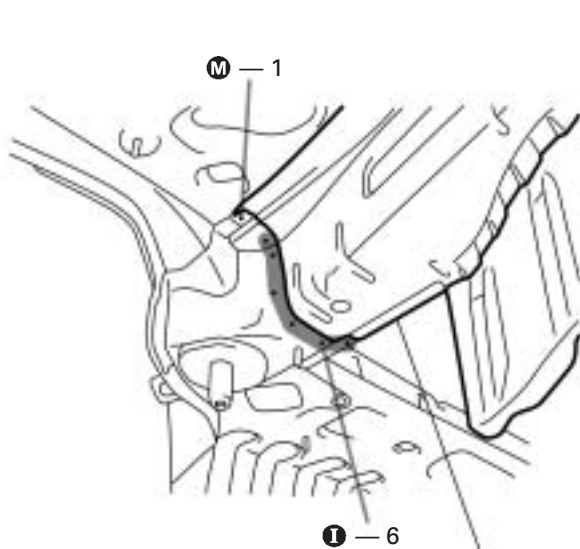
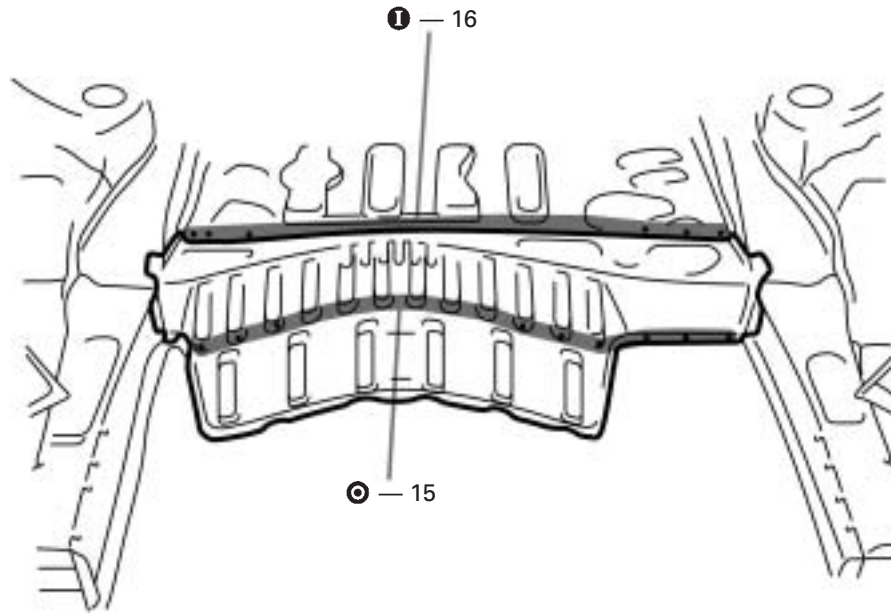
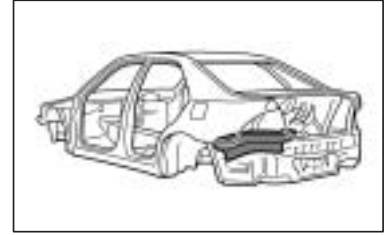
1. Install the weld bolt at the location shown above.
2. Before welding the weld bolts, check the fit of the aerodynamic parts.



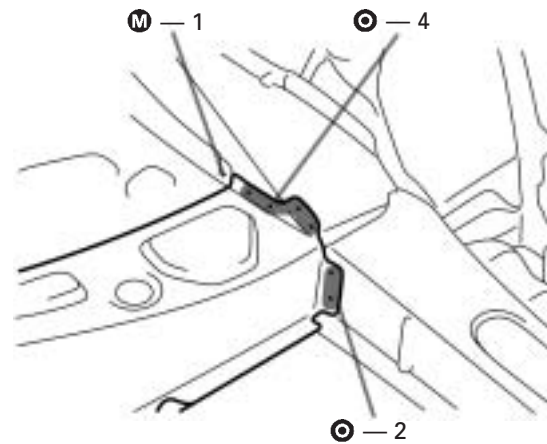
3. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.
4. After welding the rear floor side rear member, install the rear floor pan to quarter panel extension.

REAR FLOOR No.1 CROSSMEMBER (ASSY) REAR FLOOR No.2 CROSSMEMBER (ASSY)

REMOVAL (With the rear floor pan removed.)

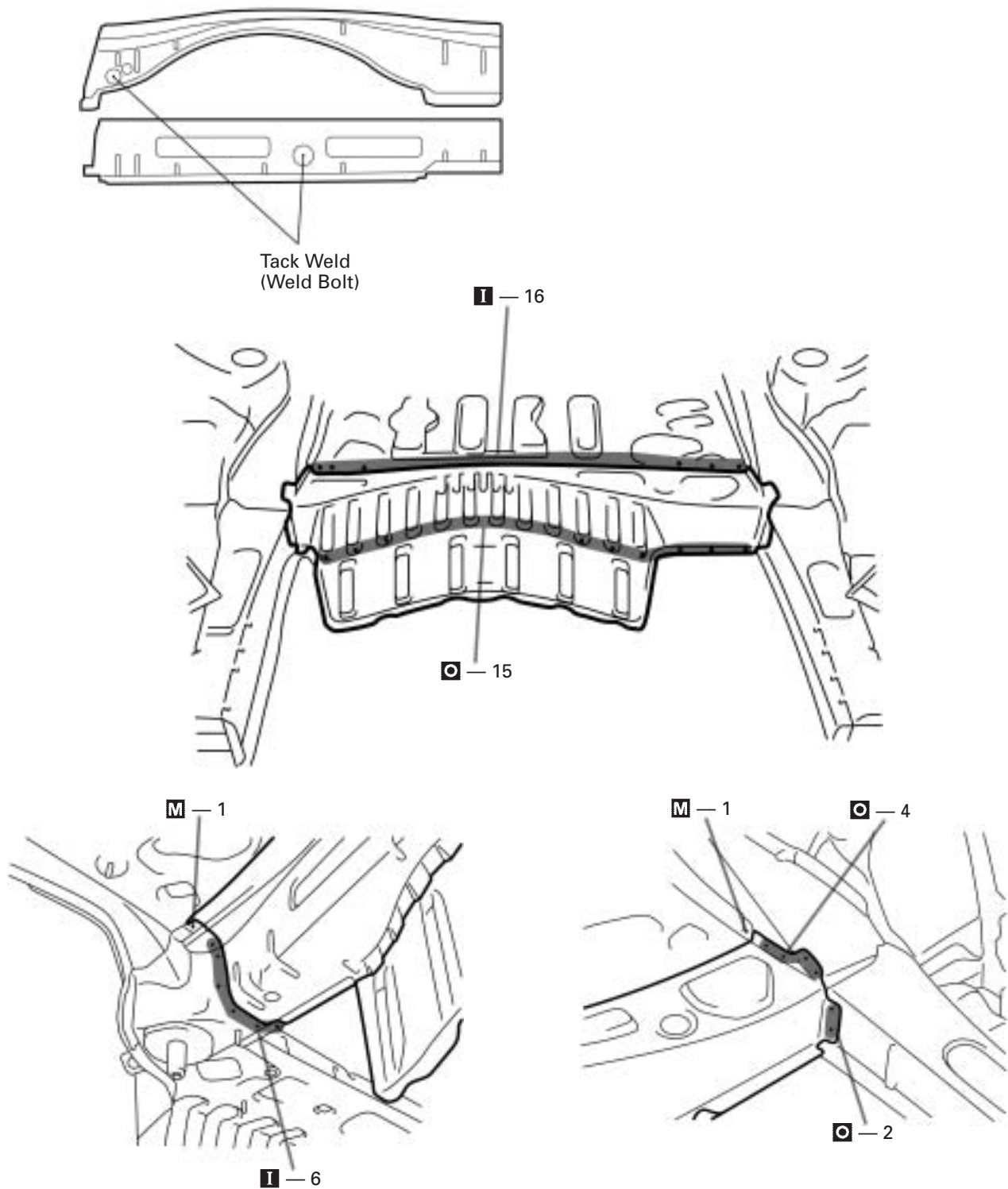


Rear Floor No.2 Crossmember

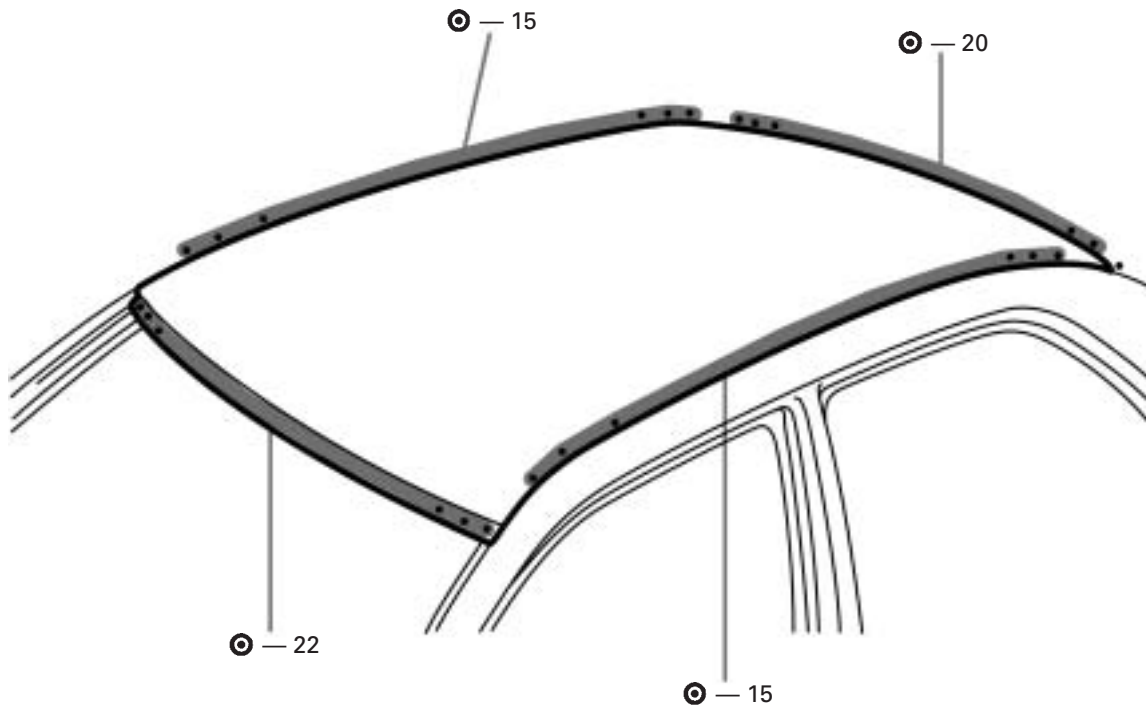
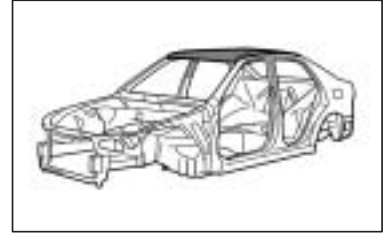


1. After removing the rear floor No.1 crossmember, remove the rear floor No.2 crossmember.

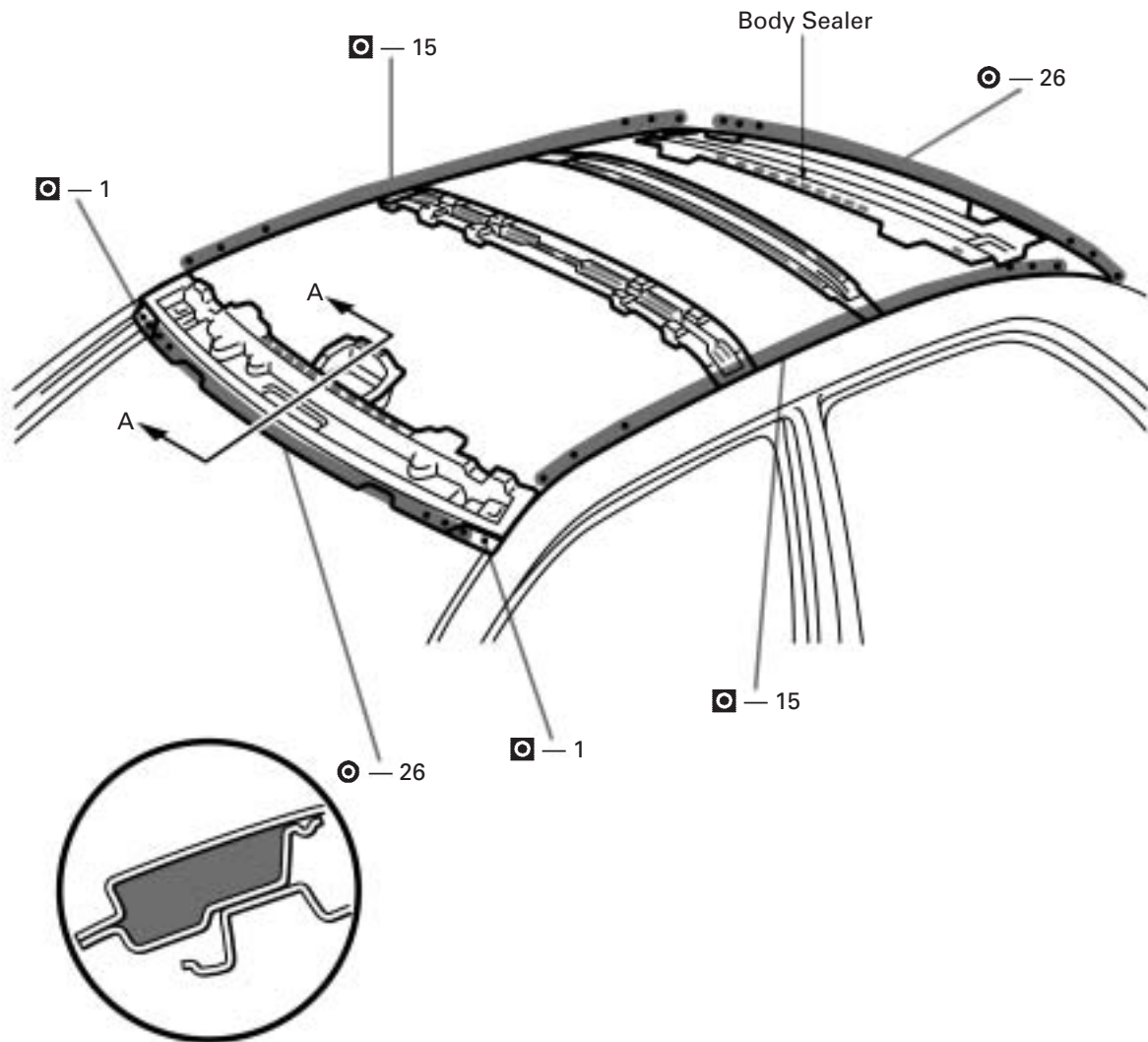
INSTALLATION



1. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.
2. Attach the weld bolt to the center of the bearing surface.

ROOF PANEL (ASSY): w/o Moon Roof**REMOVAL**

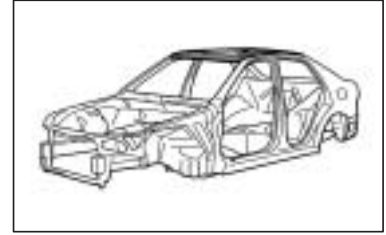
INSTALLATION



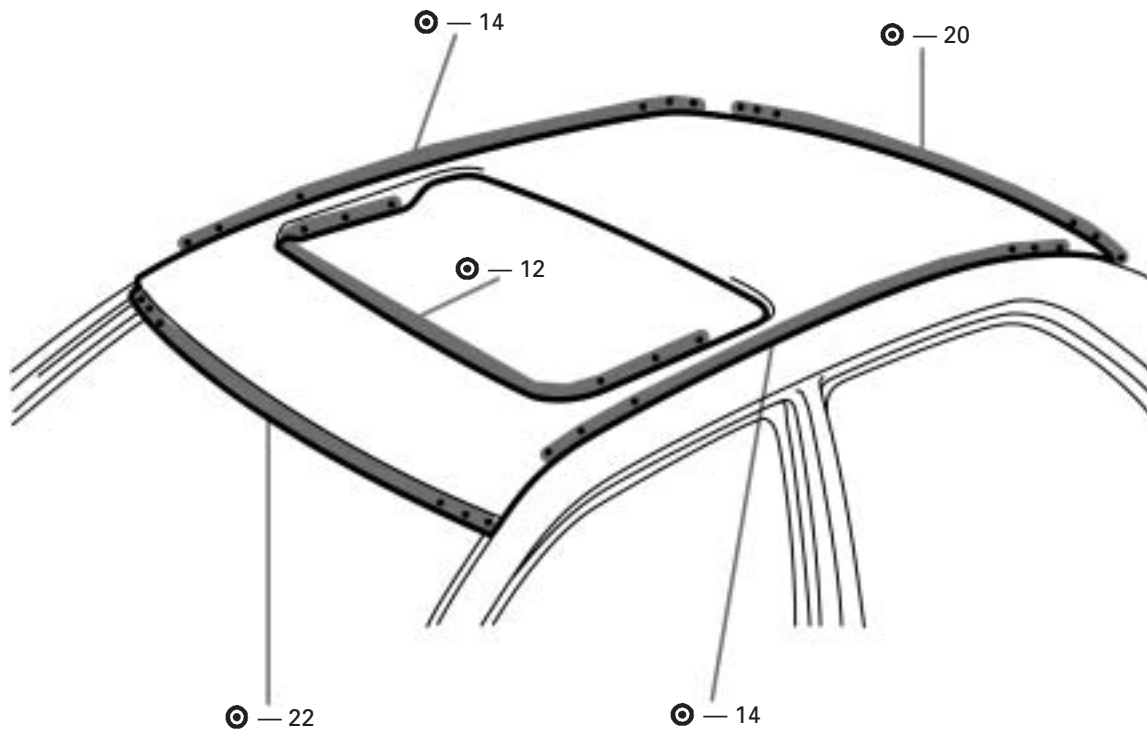
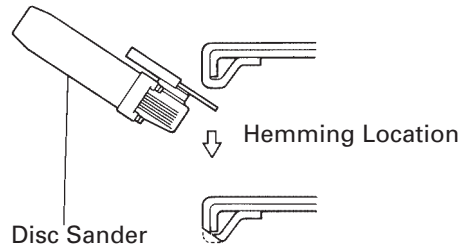
A - A
[Foamed Materials Application Area]

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

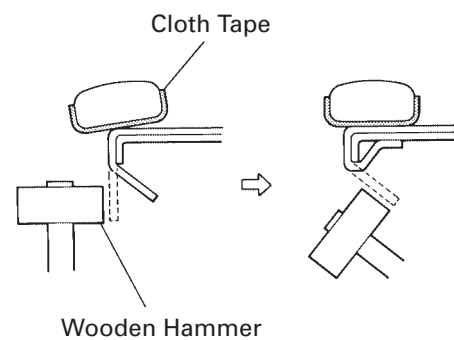
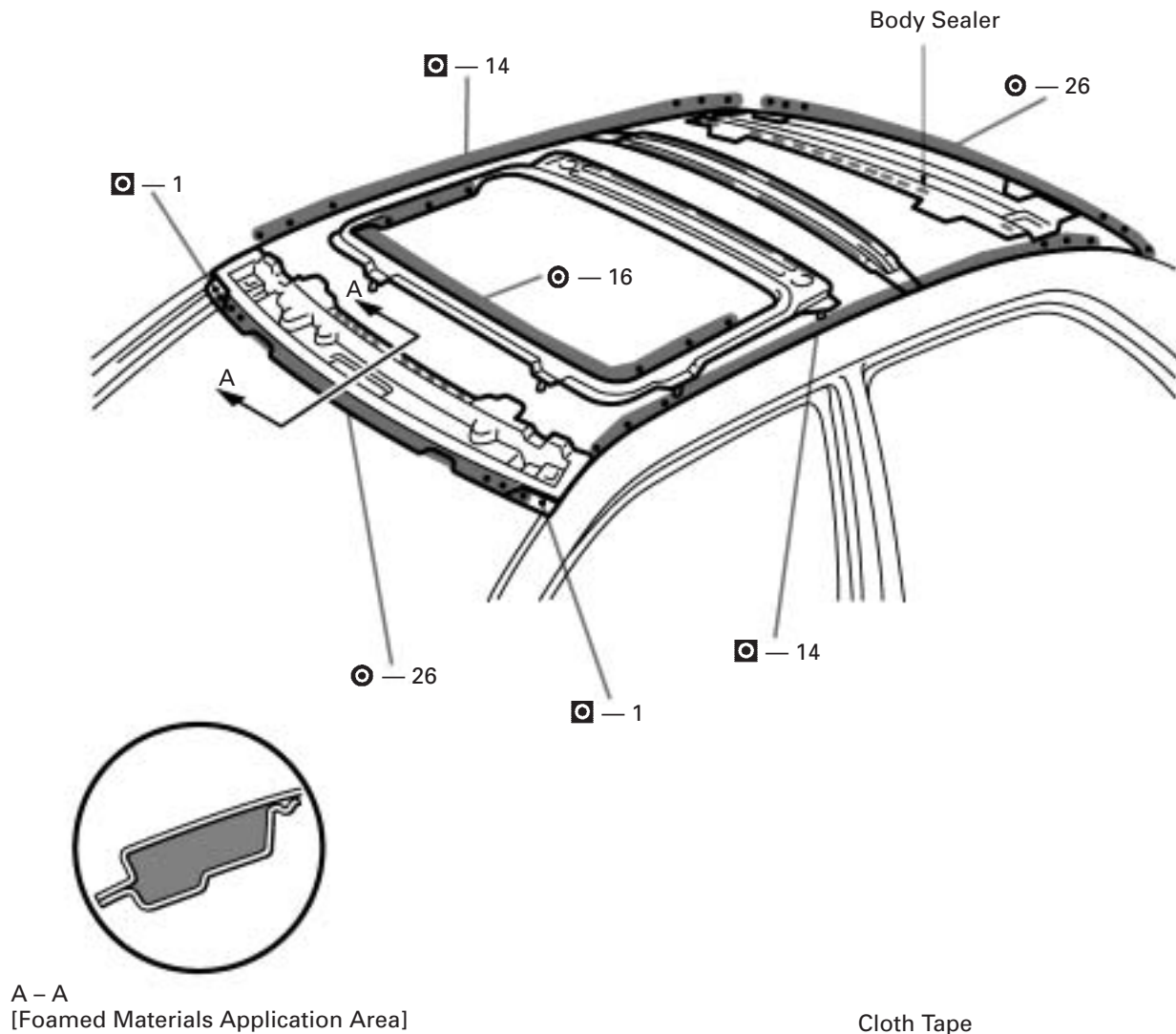
HINT: Apply just enough sealer for the new parts to make contact.

ROOF PANEL (ASSY): w/ Moon Roof**REMOVAL**

[If reusing the roof panel reinforcement]



INSTALLATION



1. Before temporarily installing the new parts, apply body sealer to the windshield header panel, roof panel reinforcement and back window frame.
2. After installing the new parts, apply foamed materials.
3. Bend the flange hem with a wooden hammer and dolly.

HINT: Apply just enough sealer for the new parts to make contact.

HINT: Perform hemming three steps, being careful not to warp the panel.

