

SECTION

BRM

BODY REPAIR

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BODY EXTERIOR PAINT COLOR

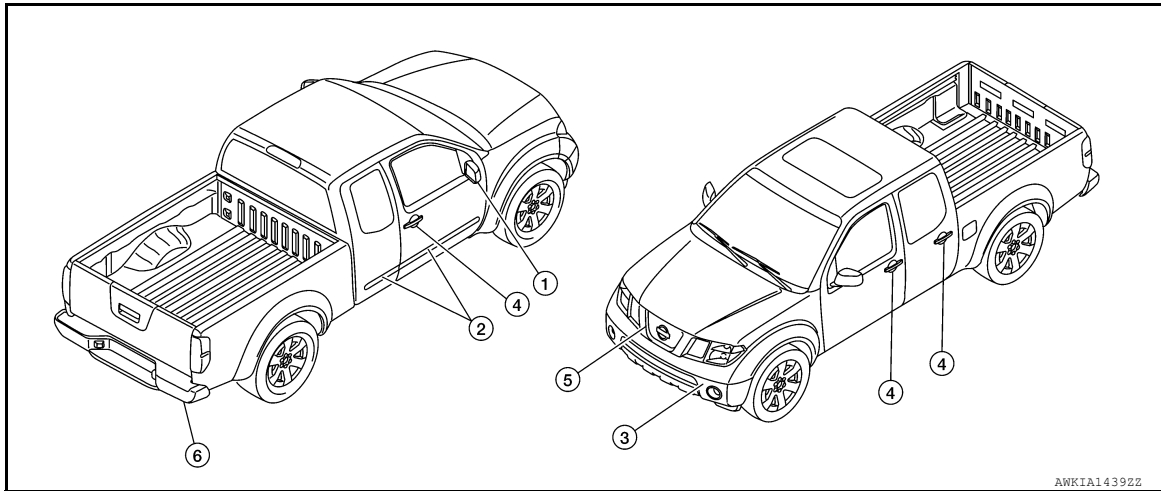
< FEATURES OF NEW MODEL >

FEATURES OF NEW MODEL

BODY EXTERIOR PAINT COLOR

Body Exterior Paint Color

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AWKIA14392Z

USA												
Component				Color code	NAH	EAF	B17	K23	K26	KH3	QAK	RAQ
				Description	Red	Orange	Blue	Silver	Gray	Black	White	Blue
				Paint type	M	M	M	M	M	S	S	M
				Cross linked clear coat	t	t	t	t	t	t	t	t
1	Door Mirror	King Cab	S	Black	—	—	—	—	—	—	—	—
			SV	Black	—	—	—	—	—	—	—	—
			SL	Chrome	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P
			Pro-4X	Body Color	NAH	EAF	B17	K23	K26	KH3	QAK	RAQ
		Crew Cab	SV	Black	—	—	—	—	—	—	—	—
			SL	Chrome	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P
			Pro-4X	Body Color	NAH	EAF	B17	K23	K26	KH3	QAK	RAQ
2	Side Guard Molding	Crew Cab	SL	Body color	NAH	EAF	B17	K23	K26	KH3	QAK	RAQ
3	Front Bumper	King Cab	S	Half Black	—	—	—	—	—	—	—	—
			SV/ Pro-4X	Body Color	NAH	EAF	B17	K23	K26	KH3	QAK	RAQ
		Crew Cab	S	Half Black	—	—	—	—	—	—	—	—
			SL	Chrome	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P
			SV/ Pro-4X	Body Color	NAH	EAF	B17	K23	K26	KH3	QAK	RAQ
4	Outside Door Handle	King Cab	S	Black	—	—	—	—	—	—	—	—
			SV	Black	—	—	—	—	—	—	—	—
			SL	Chrome	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P
			Pro-4X	Body Color	NAH	EAF	B17	K23	K26	KH3	QAK	RAQ
		Crew Cab	SV	Black	—	—	—	—	—	—	—	—
			SL	Chrome	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P
			Pro-4X	Body Color	NAH	EAF	B17	K23	K26	KH3	QAK	RAQ

BODY EXTERIOR PAINT COLOR

< FEATURES OF NEW MODEL >

USA												
Component				Color code	NAH	EAF	B17	K23	K26	KH3	QAK	RAQ
				Description	Red	Orange	Blue	Silver	Gray	Black	White	Blue
				Paint type	M	M	M	M	M	S	S	M
				Cross linked clear coat	t	t	t	t	t	t	t	t
5	Front Grille	King Cab	S	Chrome	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P
			SV	Chrome	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P
			Desert Runner	Satin Chrome	—	—	—	—	—	—	—	—
			Pro-4X	Satin Chrome	—	—	—	—	—	—	—	—
		Crew Cab	S	Chrome	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P
			SV	Chrome	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P
			SL	Chrome	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P
			Desert Runner	Satin Chrome	—	—	—	—	—	—	—	—
			Pro-4X	Satin Chrome	—	—	—	—	—	—	—	—
6	Rear Bumper	King Cab	S	Chrome	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P
			SV	Chrome	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P
			Desert Runner	Body Color	NAH	EAF	B17	K23	K26	KH3	QAK	RAQ
			Pro-4X	Body Color	NAH	EAF	B17	K23	K26	KH3	QAK	RAQ
		Crew Cab	S	Chrome	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P
			SV	Chrome	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P
			SL	Chrome	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P
			Desert Runner	Body Color	NAH	EAF	B17	K23	K26	KH3	QAK	RAQ
			Pro-4X	Body Color	NAH	EAF	B17	K23	K26	KH3	QAK	RAQ

M: Metallic; S: 1- Coat Solid, 2S: 2-Coat Solid, 2P: 2-Coat Pearl, PM: Pearl + Metallic, t: Primerless carbamate clear coat

†: Cross-linked clear coat

CANADA												
Component				Color code	NAH	EAF	B17	K23	K26	KH3	QAK	RAQ
				Description	Red	Orange	Blue	Silver	Gray	Black	White	Blue
				Paint type	M	M	M	M	M	S	S	M
				Cross linked clear coat	t	t	t	t	t	t	t	t
1	Door Mirror	King Cab	S	Black	—	—	—	—	—	—	—	—
			SV	Black	—	—	—	—	—	—	—	—
			SL	Chrome	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P
			Pro-4X	Body Color	NAH	EAF	B17	K23	K26	KH3	QAK	RAQ
		Crew Cab	SV	Black	—	—	—	—	—	—	—	—
			SL	Chrome	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P
			Pro-4X	Body Color	NAH	EAF	B17	K23	K26	KH3	QAK	RAQ

BODY EXTERIOR PAINT COLOR

< FEATURES OF NEW MODEL >

CANADA												
Component				Color code	NAH	EAF	B17	K23	K26	KH3	QAK	RAQ
				Description	Red	Orange	Blue	Silver	Gray	Black	White	Blue
				Paint type	M	M	M	M	M	S	S	M
				Cross linked clear coat	t	t	t	t	t	t	t	t
2	Side Guard Molding	Crew Cab	SL	Body color	NAH	EAF	B17	K23	K26	KH3	QAK	RAQ
3	Front Bumper	King Cab	S	Half Black	—	—	—	—	—	—	—	—
			SV/ Pro-4X	Body Color	NAH	EAF	B17	K23	K26	KH3	QAK	RAQ
		Crew Cab	SL	Chrome	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P
			SV/ Pro-4X	Body Color	NAH	EAF	B17	K23	K26	KH3	QAK	RAQ
4	Outside Door Handle	King Cab	S	Black	—	—	—	—	—	—	—	—
			SV	Black	—	—	—	—	—	—	—	—
			SL	Chrome	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P
			Pro-4X	Body Color	NAH	EAF	B17	K23	K26	KH3	QAK	RAQ
		Crew Cab	SV	Black	—	—	—	—	—	—	—	—
			SL	Chrome	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P
			Pro-4X	Body Color	NAH	EAF	B17	K23	K26	KH3	QAK	RAQ
5	Front Grille	King Cab	S	Chrome	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P
			SV	Chrome	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P
			Pro-4X	Satin Chrome	—	—	—	—	—	—	—	—
		Crew Cab	SV	Chrome	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P
			SL	Chrome	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P
			Pro-4X	Satin Chrome	—	—	—	—	—	—	—	—
6	Rear Bumper	King Cab	S	Chrome	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P
			SV	Chrome	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P
			Pro-4X	Body Color	NAH	EAF	B17	K23	K26	KH3	QAK	RAQ
		Crew Cab	SV	Chrome	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P
			SL	Chrome	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P
			Pro-4X	Body Color	NAH	EAF	B17	K23	K26	KH3	QAK	RAQ

M: Metallic; S: 1- Coat Solid, 2S: 2-Coat Solid, 2P: 2-Coat Pearl, PM: Pearl + Metallic, t: Primerless carbamate clear coat

†: Cross-linked clear coat

MEXICO											
Component			Color code	EAF	B17	K23	K26	KH3	QAK	NAH	RAQ
			Description	Orange	Blue	Silver	Gray	Black	White	Red	Blue
			Paint type	M	M	M	M	S	S	M	M
			Clear coat	t	t	t	t	t	t	t	t
1	Door Mirror	SV	Black	—	—	—	—	—	—	—	—
		SL	Chrome	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P
		Pro-4X	Body Color	EAF	B17	K23	K26	KH3	QAK	NAH	RAQ

BODY EXTERIOR PAINT COLOR

< FEATURES OF NEW MODEL >

MEXICO											
Component			Color code	EAF	B17	K23	K26	KH3	QAK	NAH	RAQ
			Description	Orange	Blue	Silver	Gray	Black	White	Red	Blue
			Paint type	M	M	M	M	S	S	M	M
			Clear coat	t	t	t	t	t	t	t	t
2	Side Guard Molding	SL	Body color	EAF	B17	K23	K26	KH3	QAK	NAH	RAQ
3	Front Bumper	SV/ Pro-4X	Body Color	EAF	B17	K23	K26	KH3	QAK	NAH	RAQ
4	Outside Door Handle	SV	Black	—	—	—	—	—	—	—	—
		SL	Chrome	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P
		Pro-4X	Body Color	EAF	B17	K23	K26	KH3	QAK	NAH	RAQ
5	Front Grille	SV	Chrome	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P
		Pro-4X	Satin Chrome	—	—	—	—	—	—	—	—
6	Rear Bumper	SV	Chrome	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P	Cr2P
		Pro-4X	Body Color	EAF	B17	K23	K26	KH3	QAK	NAH	RAQ

M: Metallic; S: 1- Coat Solid, 2S: 2-Coat Solid, 2P: 2-Coat Pearl, PM: Pearl + Metallic, t: Primerless carbamate clear coat

†: Cross-linked clear coat

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PRECAUTIONS

< PRECAUTION >

PRECAUTION

PRECAUTIONS

Precaution for Supplemental Restraint System (SRS) "AIR BAG" and "SEAT BELT PRE-TENSIONER"

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The Supplemental Restraint System such as "AIR BAG" and "SEAT BELT PRE-TENSIONER", used along with a front seat belt, helps to reduce the risk or severity of injury to the driver and front passenger for certain types of collision. This system includes seat belt switch inputs and dual stage front air bag modules. The SRS system uses the seat belt switches to determine the front air bag deployment, and may only deploy one front air bag, depending on the severity of a collision and whether the front occupants are belted or unbelted. Information necessary to service the system safely is included in the SR and SB section of this Service Manual.

WARNING:

- To avoid rendering the SRS inoperative, which could increase the risk of personal injury or death in the event of a collision which would result in air bag inflation, all maintenance must be performed by an authorized NISSAN/INFINITI dealer.
- Improper maintenance, including incorrect removal and installation of the SRS, can lead to personal injury caused by unintentional activation of the system. For removal of Spiral Cable and Air Bag Module, see the SR section.
- Do not use electrical test equipment on any circuit related to the SRS unless instructed to in this Service Manual. SRS wiring harnesses can be identified by yellow and/or orange harnesses or harness connectors.

PRECAUTIONS WHEN USING POWER TOOLS (AIR OR ELECTRIC) AND HAMMERS

WARNING:

- When working near the Airbag Diagnosis Sensor Unit or other Airbag System sensors with the Ignition ON or engine running, DO NOT use air or electric power tools or strike near the sensor(s) with a hammer. Heavy vibration could activate the sensor(s) and deploy the air bag(s), possibly causing serious injury.
- When using air or electric power tools or hammers, always switch the Ignition OFF, disconnect the battery, and wait at least 3 minutes before performing any service.

HANDLING PRECAUTIONS

< PRECAUTION >

HANDLING PRECAUTIONS

Handling Precaution for Plastics

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HANDLING PRECAUTIONS FOR PLASTICS

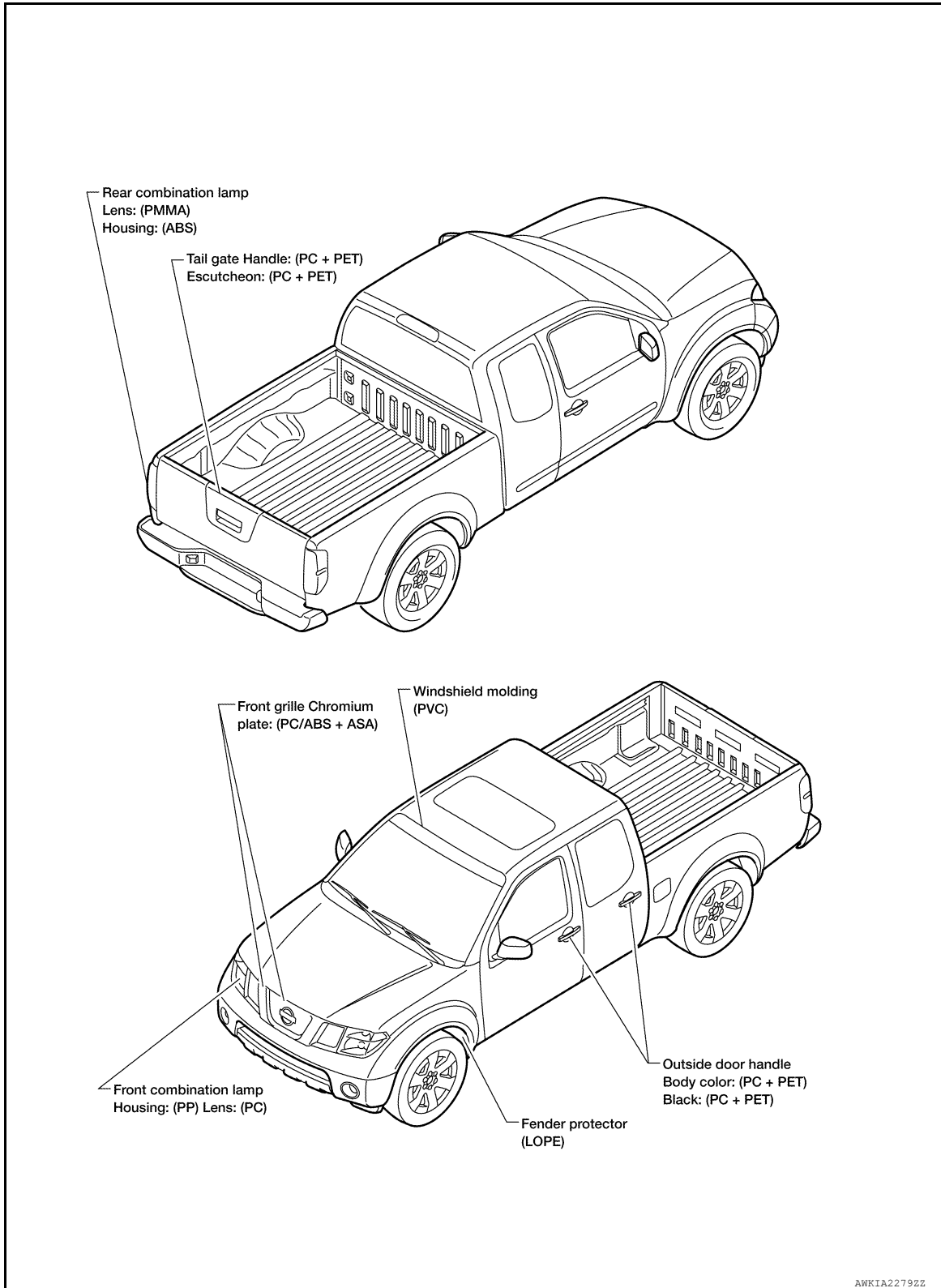
Abbreviation	Material name	Heat resisting temperature °C (°F)	Resistance to gasoline and solvents	Other cautions
PE	Polyethylene	60 (140)	Gasoline and most solvents are harmless if applied for a very short time (wipe up quickly).	Flammable
PVC	Polyvinyl Chloride	80 (176)	Same as above.	Poison gas is emitted when burned.
EPM/EPDM	Ethylene Propylene (Diene) rubber	80 (176)	Same as above.	Flammable
TPO/TPR	Thermoplastic Olefine/Thermoplastic Rubber	80 (176)	Same as above.	Flammable
PP	Polypropylene	90 (194)	Same as above.	Flammable, avoid battery acid.
UP	Polyester thermoset	90 (194)	Same as above.	Flammable
PS	Polystyrene	80 (176)	Avoid solvents.	Flammable
ABS	Acrylonitrile Butadiene Styrene resin	80 (176)	Avoid gasoline and solvents.	
AES	Acrylonitrile Ethylene Styrene	80 (176)	Same as above.	
PMMA	Polymethyl Methacrylate	85 (185)	Same as above.	
AAS	Acrylonitrile Acrylic Styrene	85 (185)	Same as above.	
AS	Acrylonitrile Styrene	85 (185)	Same as above.	
EVA	Polyvinyl Ethyl Acetate	90 (194)	Same as above.	
ASA	Acrylonitrile Styrene Acrylate	100 (222)	Same as above.	Flammable
PPO/PPE	Polyphenylene Oxide/Polyphenylene Ether	110 (230)	Same as above.	
PC	Polycarbonate	120 (248)	Same as above.	
PAR	Polyacrylate	180 (356)	Same as above.	
L-LDPE	Linear Low Density PE	45 (100)	Gasoline and most solvents are harmless.	Flammable
PUR	Polyurethane	90 (194)	Same as above.	
TPU	Thermoplastic Urethane	110 (230)	Same as above.	
PPC	Polypropylene Composite	115 (239)	Same as above.	Flammable
POM	Polyacetal	120 (248)	Same as above.	Avoid battery acid.
PBT+PC	Polybutylene Terephthalate+Polycarbonate	120 (248)	Same as above.	Flammable
PA	Polyamide (Nylon)	140 (284)	Same as above.	Avoid immersing in water.
PBT	Polybutylene Terephthalate	140 (284)	Same as above.	
FRP	Fiber Reinforced Plastics	170 (338)	Same as above.	Avoid battery acid.
PET	Polyethylene Terephthalate	180 (356)	Same as above.	
PEI	Polyetherimide	200 (392)	Same as above.	

1. When repairing and painting a portion of the body adjacent to plastic parts, consider their characteristics (influence of heat and solvent) and remove them if necessary or take suitable measures to protect them.
2. Plastic parts should be repaired and painted using methods suiting the materials' characteristics.

HANDLING PRECAUTIONS

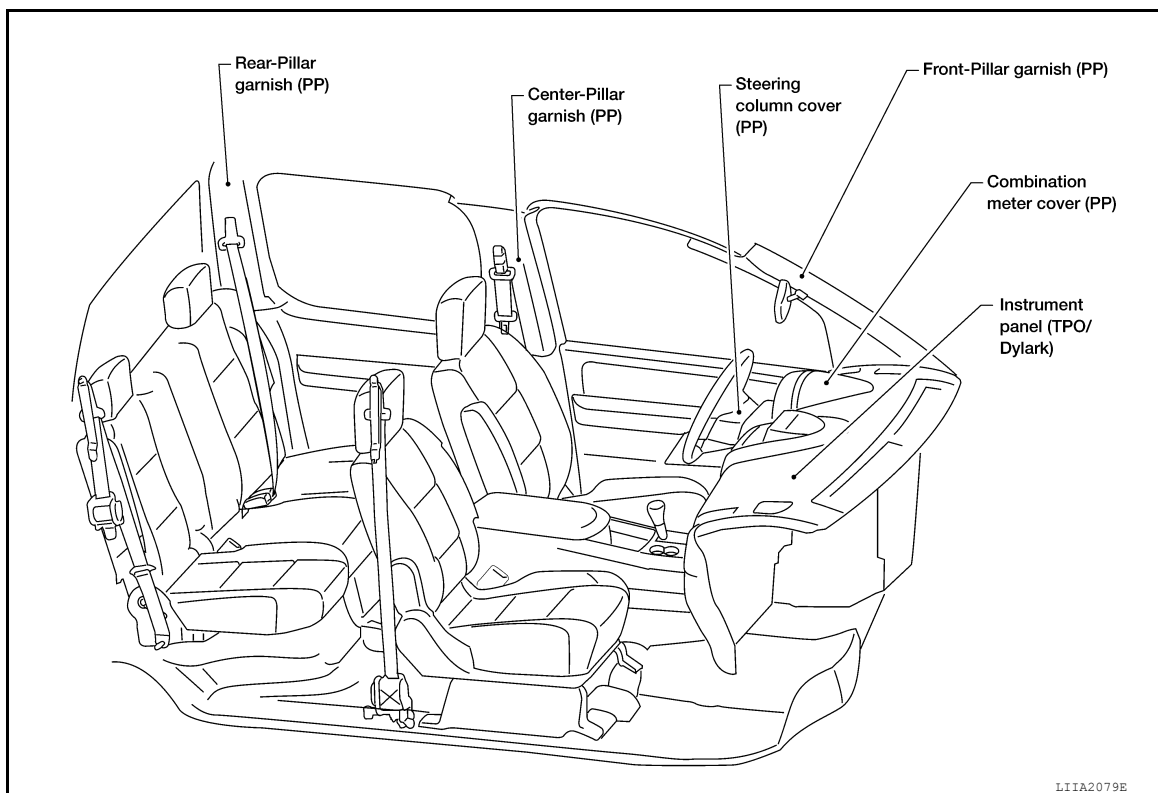
< PRECAUTION >

LOCATION OF PLASTIC PARTS



HANDLING PRECAUTIONS

< PRECAUTION >



A

B

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D

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N

O

P

BODY COMPONENT PARTS

< REMOVAL AND INSTALLATION >

REMOVAL AND INSTALLATION

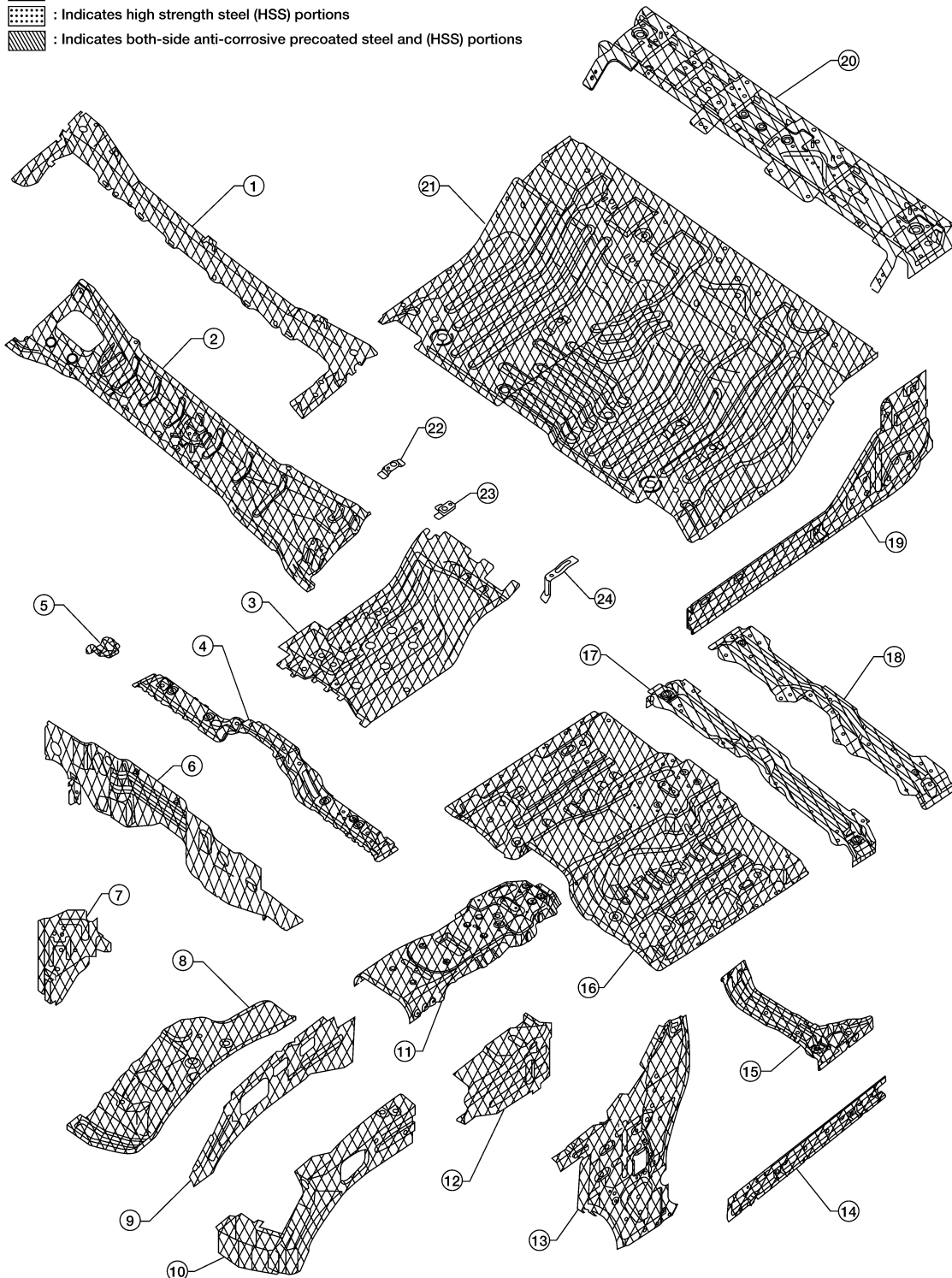
BODY COMPONENT PARTS

Body Component Parts

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UNDERBODY COMPONENT PARTS

-  : Indicates both-side anti-corrosive precoated steel portions
-  : Indicates high strength steel (HSS) portions
-  : Indicates both-side anti-corrosive precoated steel and (HSS) portions



LI1A2026E

BODY COMPONENT PARTS

< REMOVAL AND INSTALLATION >

1. Upper dash crossmember	A
2. Upper dash	
3. Rear floor reinforcement	
4. Front seat crossmember	B
5. 2nd crossmember extension	
6. Lower dash	
7. Battery tray	C
8. Hoodledge lower panel (RH/LH)	
9. Hoodledge inner panel (RH/LH)	
10. Hoodledge reinforcement (RH/LH)	D
11. Front floor reinforcement	
12. Hoodledge rear reinforcement (RH/LH)	
13. Side dash (RH/LH)	E
14. Inner sill (RH/LH)	
15. 2nd crossmember (RH/LH)	F
16. Front floor	
17. Front seat crossmember	
18. Center pillar crossmember	G
19. Inner sill extension (RH/LH)	
20. Cross-cab brace	
21. Rear floor	H
22. subwoofer bracket	
23. Storage box bracket	
24. Accessory storage box bracket	I

BODY COMPONENT PARTS

J

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L

M

N

O

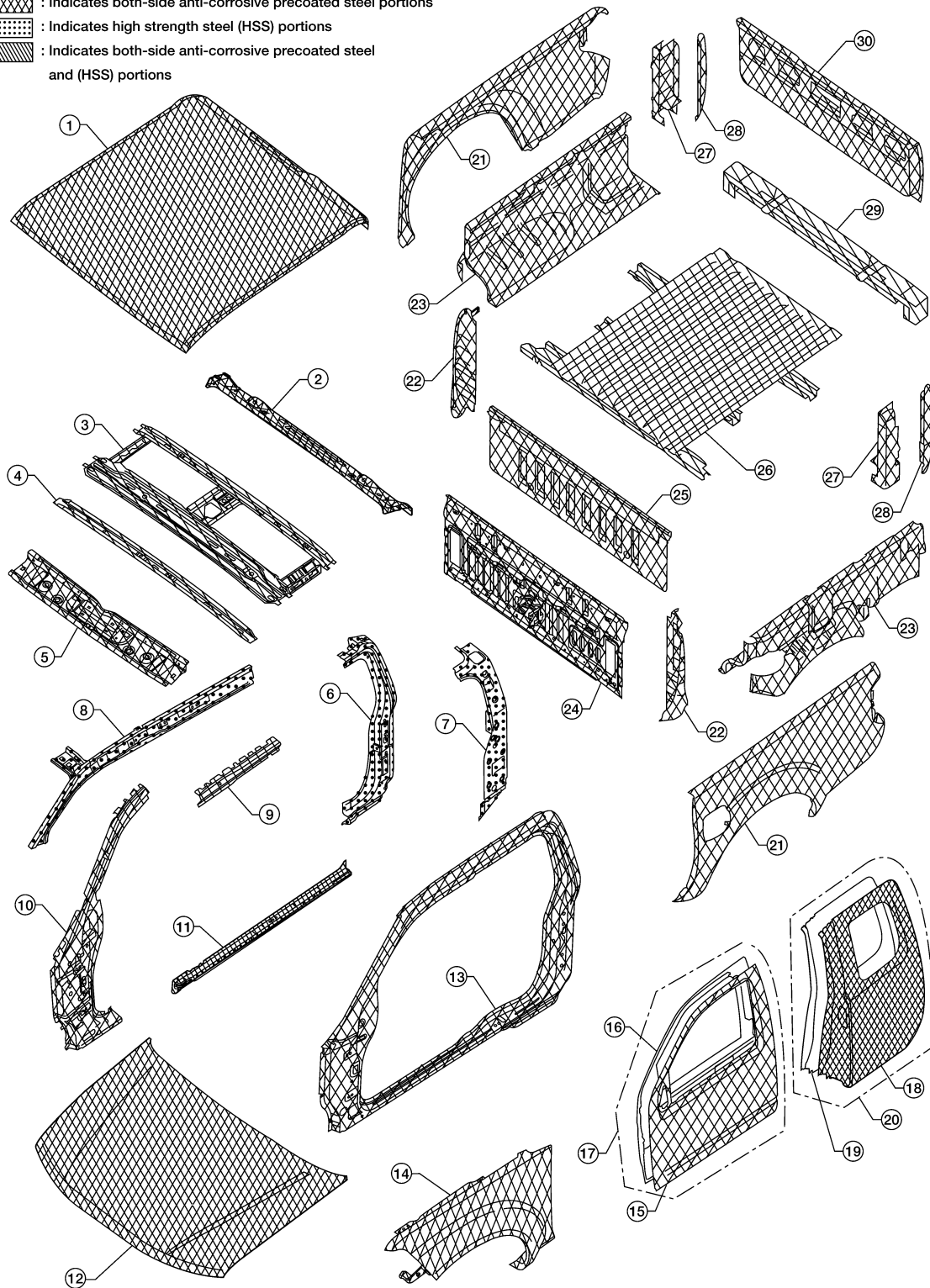
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BODY COMPONENT PARTS

< REMOVAL AND INSTALLATION >

King Cab

-  : Indicates both-side anti-corrosive precoated steel portions
-  : Indicates high strength steel (HSS) portions
-  : Indicates both-side anti-corrosive precoated steel and (HSS) portions



LIIA2027E

1. Roof
2. Rear roof rail
3. Roof bow No. 2
4. Roof bow No. 1
5. Front roof rail (RH/LH)
6. Lock pillar reinforcement (RH/LH)

BODY COMPONENT PARTS

< REMOVAL AND INSTALLATION >

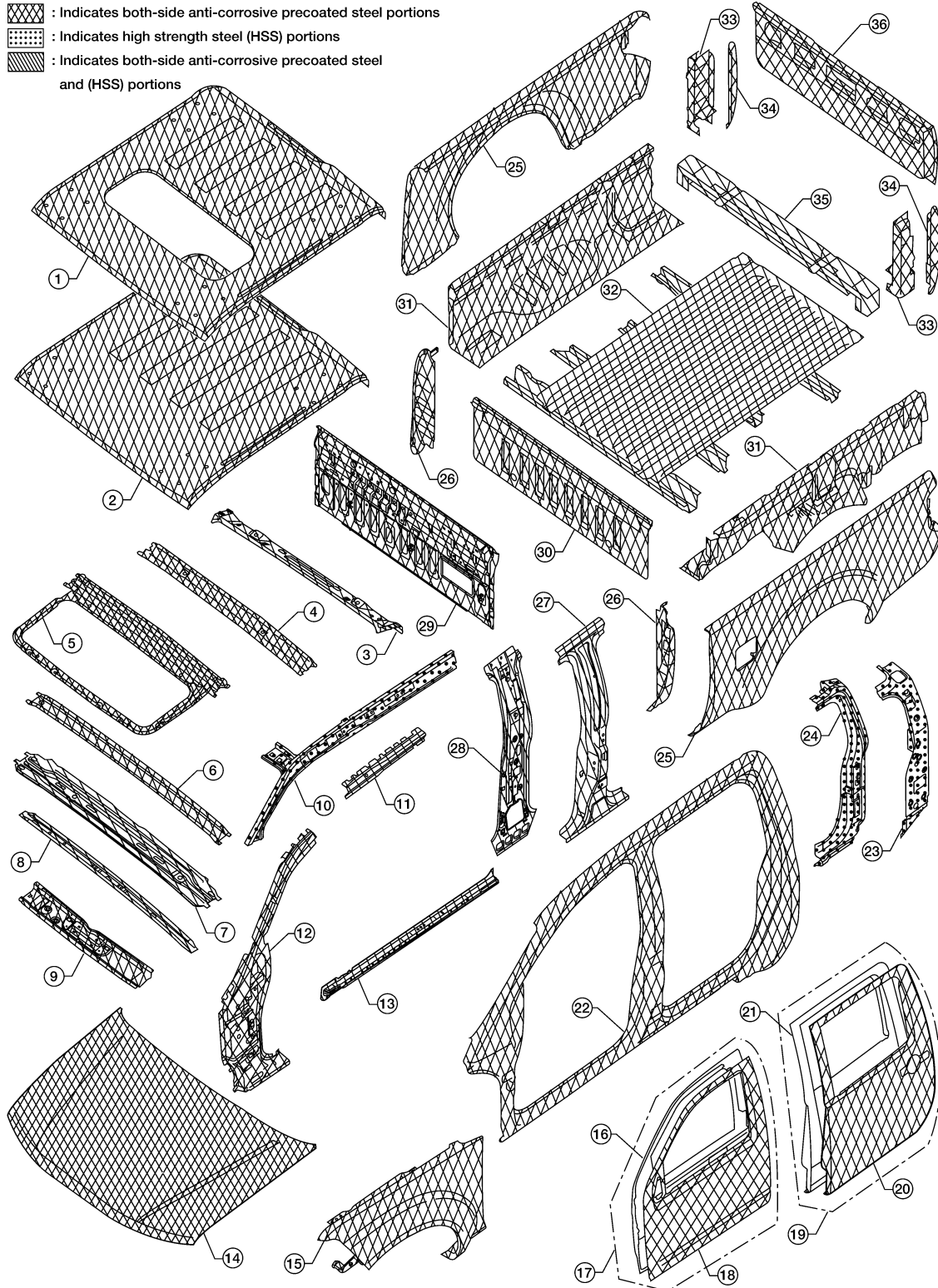
7. Lock pillar inner (RH/LH)	A
8. Front pillar inner, upper (RH/LH)	
9. Roof side rail (RH/LH)	
10. Front pillar reinforcement (RH/LH)	
11. Inner sill (RH/LH)	B
12. Hood	
13. Body side panel (RH/LH)	C
14. Front fender (RH/LH)	
15. Front door outer (RH/LH)	
16. Front door inner (RH/LH)	D
17. Front door assembly (RH/LH)	
18. Rear door (RH/LH)	
19. Rear door inner (RH/LH)	E
20. Rear door assembly (RH/LH)	
21. Bed side outer (RH/LH)	F
22. Front outer strut (RH/LH)	
23. Bed side inner (RH/LH)	
24. Rear panel	G
25. Bed front panel	
26. Floor board assembly	
27. Rear strut inner (RH/LH)	H
28. Rear strut outer (RH/LH)	
29. Rear floor bolster assembly	
30. Tail gate	I
	J
	BRM
	L
	M
	N
	O
	P

BODY COMPONENT PARTS

< REMOVAL AND INSTALLATION >

Crew Cab

-  : Indicates both-side anti-corrosive precoated steel portions
-  : Indicates high strength steel (HSS) portions
-  : Indicates both-side anti-corrosive precoated steel and (HSS) portions



LIIA2028E

1. Roof (with sunroof)
2. Roof
3. Rear roof rail
4. Roof bow No. 4

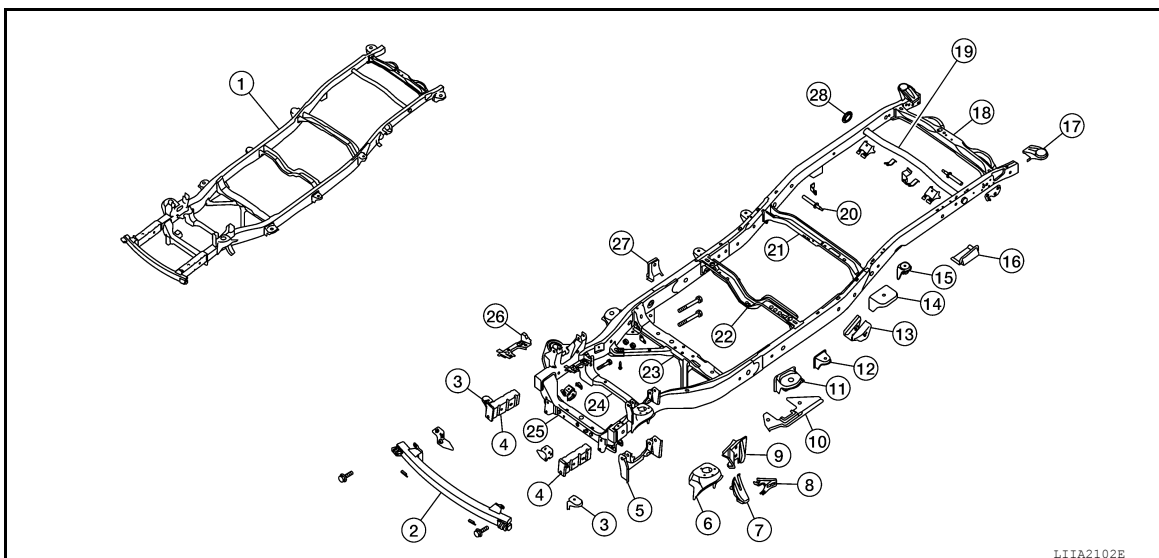
BODY COMPONENT PARTS

< REMOVAL AND INSTALLATION >

5. Sunroof reinforcement
6. Roof bow No. 3
7. Roof bow No. 2
8. Roof bow No. 1
9. Front roof rail
10. Front pillar inner, upper (RH/LH)
11. Roof side rail reinforcement (RH/LH)
12. Front pillar reinforcement (RH/LH)
13. Outer sill reinforcement (RH/LH)
14. Hood
15. Front fender (RH/LH)
16. Front door inner (RH/LH)
17. Front door assembly (RH/LH)
18. Front door outer panel
19. Rear door assembly (RH/LH)
20. Rear door outer (RH/LH)
21. Rear door inner (RH/LH)
22. Body side outer (RH/LH)
23. Rear lock pillar inner (RH/LH)
24. Rear side inner reinforcement (RH/LH)
25. Bed side outer panel (RH/LH)
26. Front outer strut (RH/LH)
27. Center pillar brace (RH/LH)
28. Center pillar inner (RH/LH)
29. Rear panel
30. Bed front panel
31. Bed side inner (RH/LH)
32. Floor board assembly
33. Rear inner strut (RH/LH)
34. Rear outer strut (RH/LH)
35. Rear floor bolster assembly
36. Tail gate

FRAME COMPONENT PARTS

Crew Cab



A
B
C
D
E
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H
I
J
L
M
N
O
P

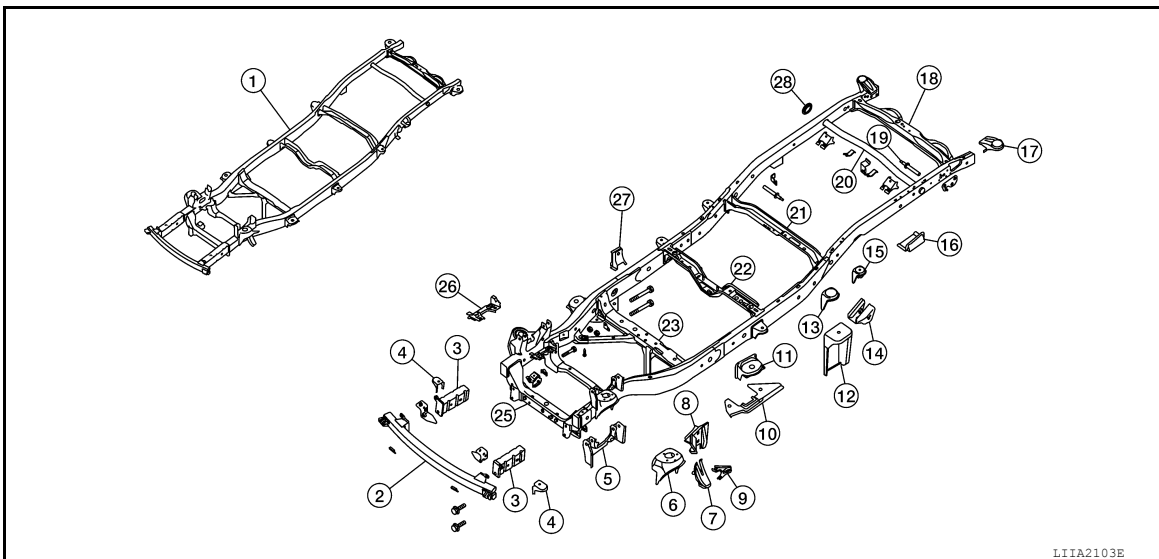
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BODY COMPONENT PARTS

< REMOVAL AND INSTALLATION >

1. Frame assembly
2. 1st crossmember assembly
3. 1st cab mounting bracket (RH/LH)
4. Front side member extension assembly (RH/LH)
5. Front upper link mounting bracket (RH/LH)
6. Front shock absorber bracket (RH/LH)
7. Bound bumper bracket (RH/LH)
8. Front brake hose bracket (RH/LH)
9. Panhard rod reinforcement bracket (RH/LH)
10. 4th crossmember gusset (RH/LH)
11. 2nd cab mounting bracket (RH/LH)
12. 3rd cab mounting bracket (RH/LH)
13. Cab mounting bracket (RH/LH)
14. Rear spring front bracket assembly (RH/LH)
15. 2nd rear body mounting bracket (RH/LH)
16. Rear bound bumper bracket (RH/LH)
17. 5th rear body mounting bracket (RH/LH)
18. 9th crossmember assembly
19. Front upper crossmember
20. Rear shock absorber pin (RH/LH)
21. 6th crossmember assembly
22. (2wd) Center bearing bracket assembly, (4wd) 5th crossmember assembly
23. 4th crossmember assembly
24. 3rd crossmember assembly
25. 2nd crossmember assembly
26. Engine mounting bracket assembly (RH/LH)
27. 4th crossmember gusset (RH/LH)
28. Crossmember collar (RH/LH)

King Cab



1. Frame assembly
2. 1st crossmember assembly
3. Front side member extension assembly (RH/LH)
4. 1st cab mounting bracket (RH/LH)
5. Front upper link mounting bracket (RH/LH)

BODY COMPONENT PARTS

< REMOVAL AND INSTALLATION >

6. Front shock absorber bracket (RH/LH)	A
7. Bound bumper bracket (RH/LH)	
8. Panhard rod reinforcement bracket (RH/LH)	
9. Front brake hose bracket (RH/LH)	B
10. 4th crossmember gusset (RH/LH)	
11. 2nd cab mounting bracket (RH/LH)	
12. 3rd cab mounting bracket (RH/LH)	C
13. 1st rear body mounting bracket (RH/LH)	
14. Rear spring front bracket assembly (RH/LH)	
15. 2nd rear body mounting bracket (RH/LH)	D
16. Rear bound bumper bracket (RH/LH)	
17. 5th rear body mounting bracket (RH/LH)	
18. 9th crossmember assembly	E
19. Rear shock absorber pin (RH/LH)	
20. Front upper crossmember	F
21. 6th crossmember assembly	
22. (2wd) Center bearing bracket assembly, (4wd) 5th crossmember assembly	
23. 4th crossmember assembly	G
24. 3rd crossmember assembly	
25. 2nd crossmember assembly	
26. Engine mounting bracket assembly (RH/LH)	H
27. 4th crossmember gusset (RH/LH)	
28. Crossmember collar (RH/LH)	I
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CORROSION PROTECTION

< REMOVAL AND INSTALLATION >

CORROSION PROTECTION

Corrosion Protection

INFOID:000000008792159

DESCRIPTION

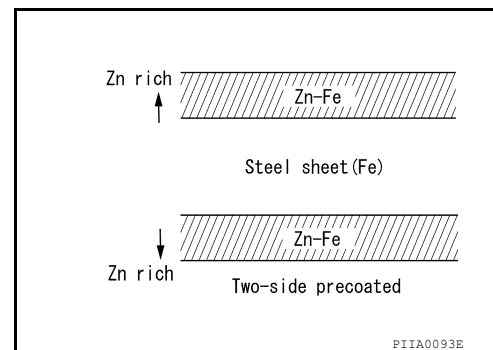
To provide improved corrosion prevention, the following anti-corrosive measures have been implemented in NISSAN production plants. When repairing or replacing body panels, it is necessary to use the same anti-corrosive measures.

Anti-corrosive Pre-coated Steel (Galvannealed Steel)

To improve repairability and corrosion resistance, a new type of anti-corrosive pre-coated steel sheet has been adopted replacing conventional zinc-coated steel sheet.

Galvannealed steel is electroplated and heated to form Zinc-iron alloy, which provides excellent and long term corrosion resistance with cationic electrode position primer.

NISSAN Genuine Service Parts are fabricated from galvannealed steel. Therefore, it is recommended that GENUINE NISSAN PARTS or equivalent be used for panel replacement to maintain the anti-corrosive performance built into the vehicle at the factory.



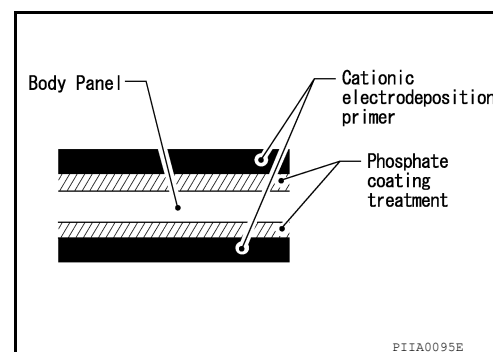
Phosphate Coating Treatment and Cationic Electrodeposition Primer

A phosphate coating treatment and a cationic electrode position primer, which provide excellent corrosion protection, are employed on all body components.

NISSAN Genuine Service Parts are also treated in the same manner. Therefore, it is recommended that GENUINE NISSAN PARTS or equivalent be used for panel replacement to maintain anti-corrosive performance built into the vehicle at the factory.

CAUTION:

Confine paint removal during welding operations to an absolute minimum.



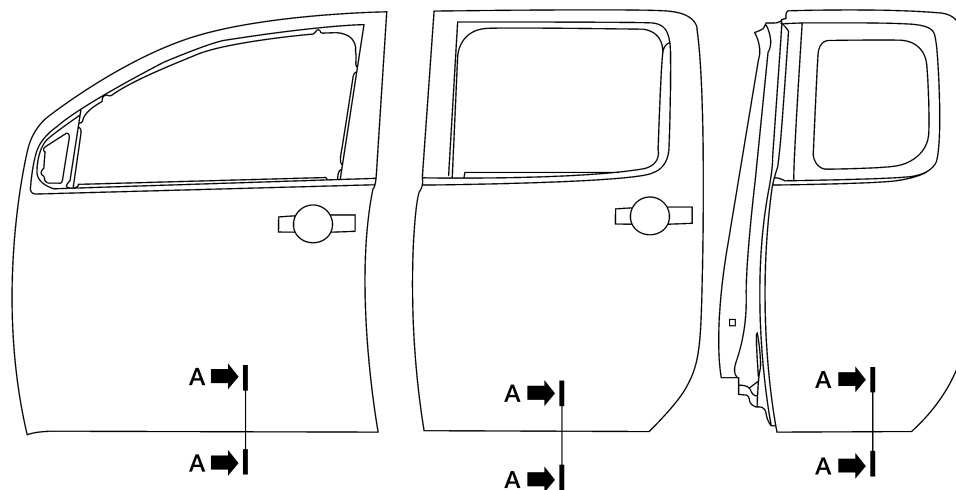
ANTI-CORROSIVE WAX

To improve corrosion resistance, anti-corrosive wax is applied inside the body sill and inside other closed sections. Accordingly, when replacing these parts, be sure to apply anti-corrosive wax to the appropriate areas of

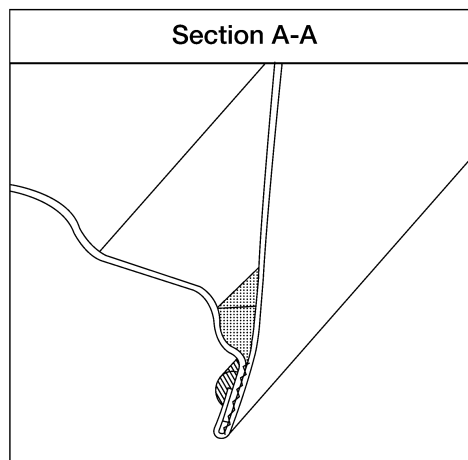
CORROSION PROTECTION

< REMOVAL AND INSTALLATION >

the new parts. Select an excellent anti-corrosive wax which will penetrate after application and has a long shelf life.



 : Indicates outside body sealant
 : Indicates anti-corrosive wax coated portions



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UNDERCOATING

The underside of the floor and wheelhouse are undercoated to prevent rust, vibration, noise and stone chipping. Therefore, when such a panel is replaced or repaired, apply undercoating to that part. Use an undercoating which is rust preventive, soundproof, vibration-proof, shock-resistant, adhesive, and durable.

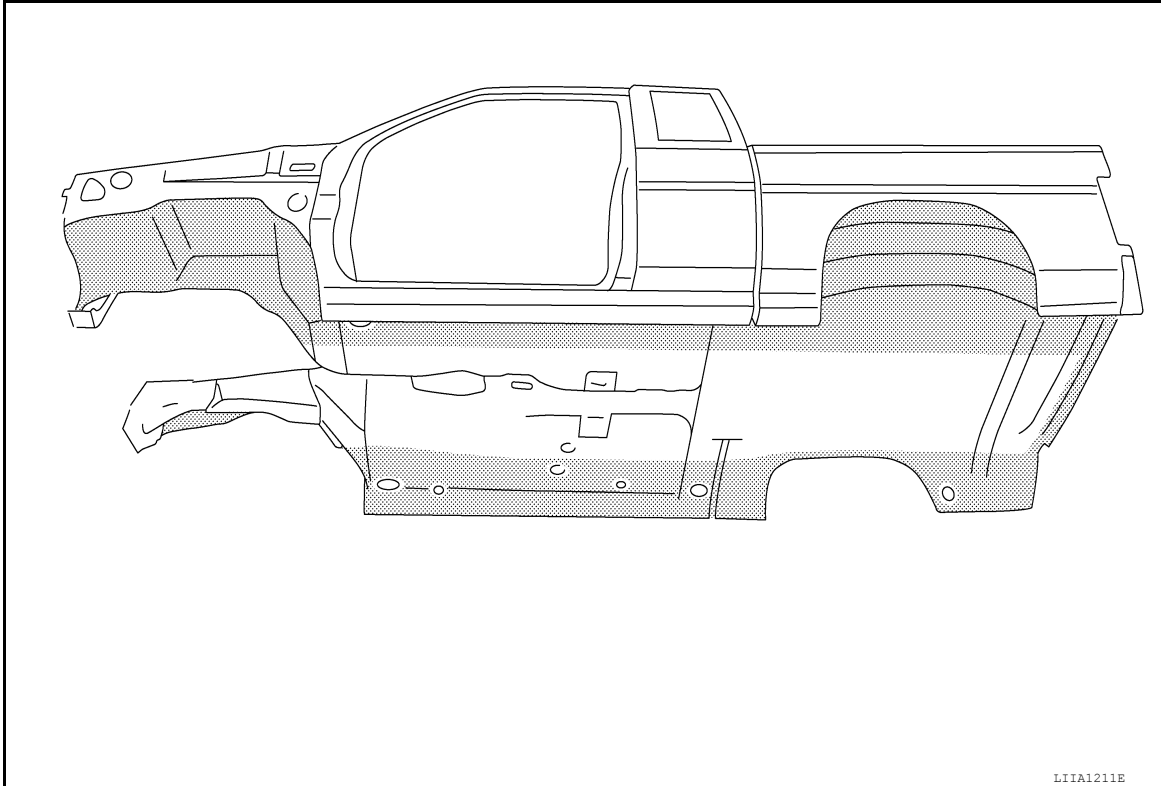
Precautions in Undercoating

1. Do not apply undercoating to any place unless specified (such as the areas above the muffler and three way catalyst which are subjected to heat).
2. Do not undercoat the exhaust pipe or other parts which become hot.
3. Do not undercoat rotating parts.

CORROSION PROTECTION

< REMOVAL AND INSTALLATION >

4. Apply bitumen wax after applying undercoating.



Body Sealing

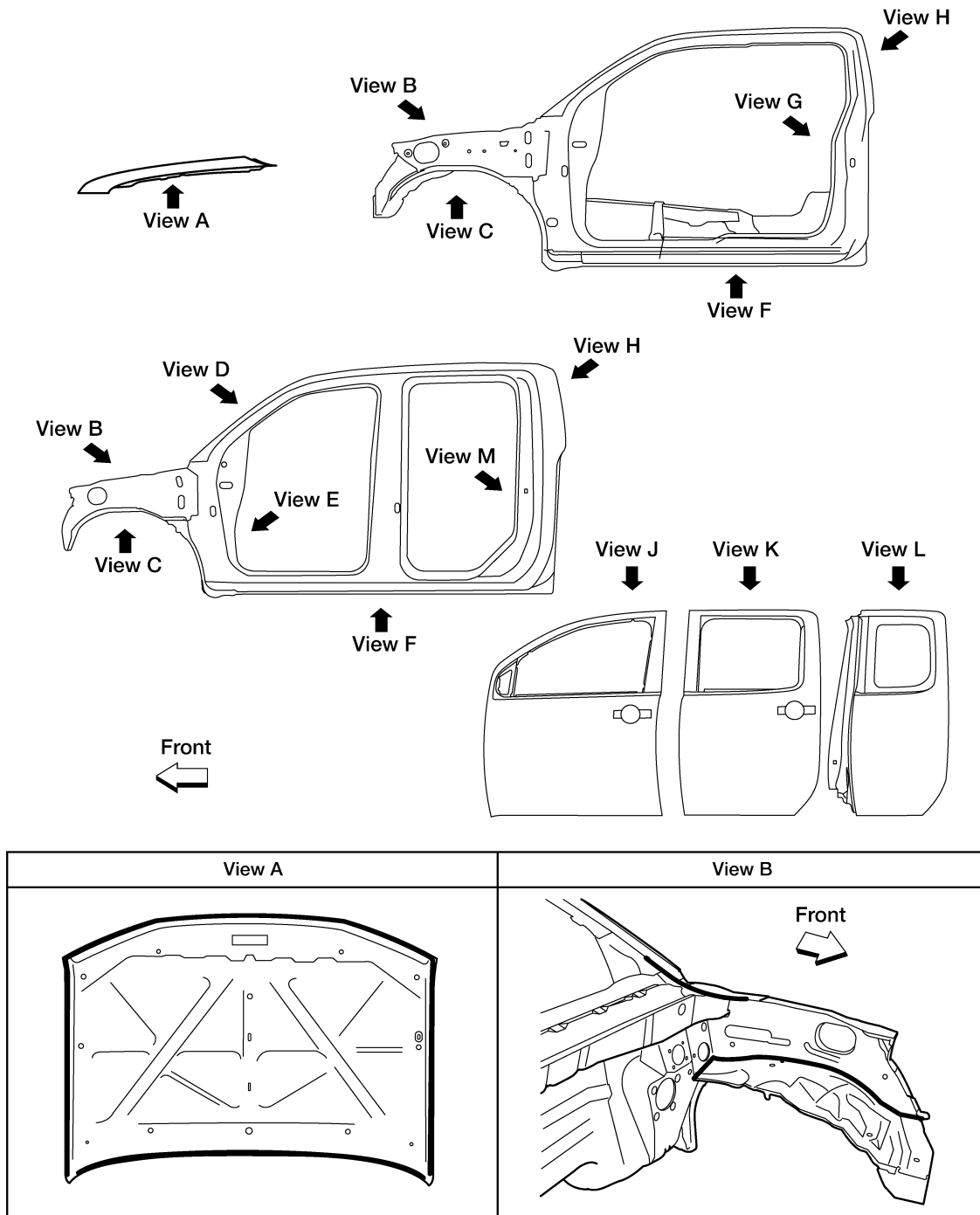
INFOID:000000008792160

DESCRIPTION

CORROSION PROTECTION

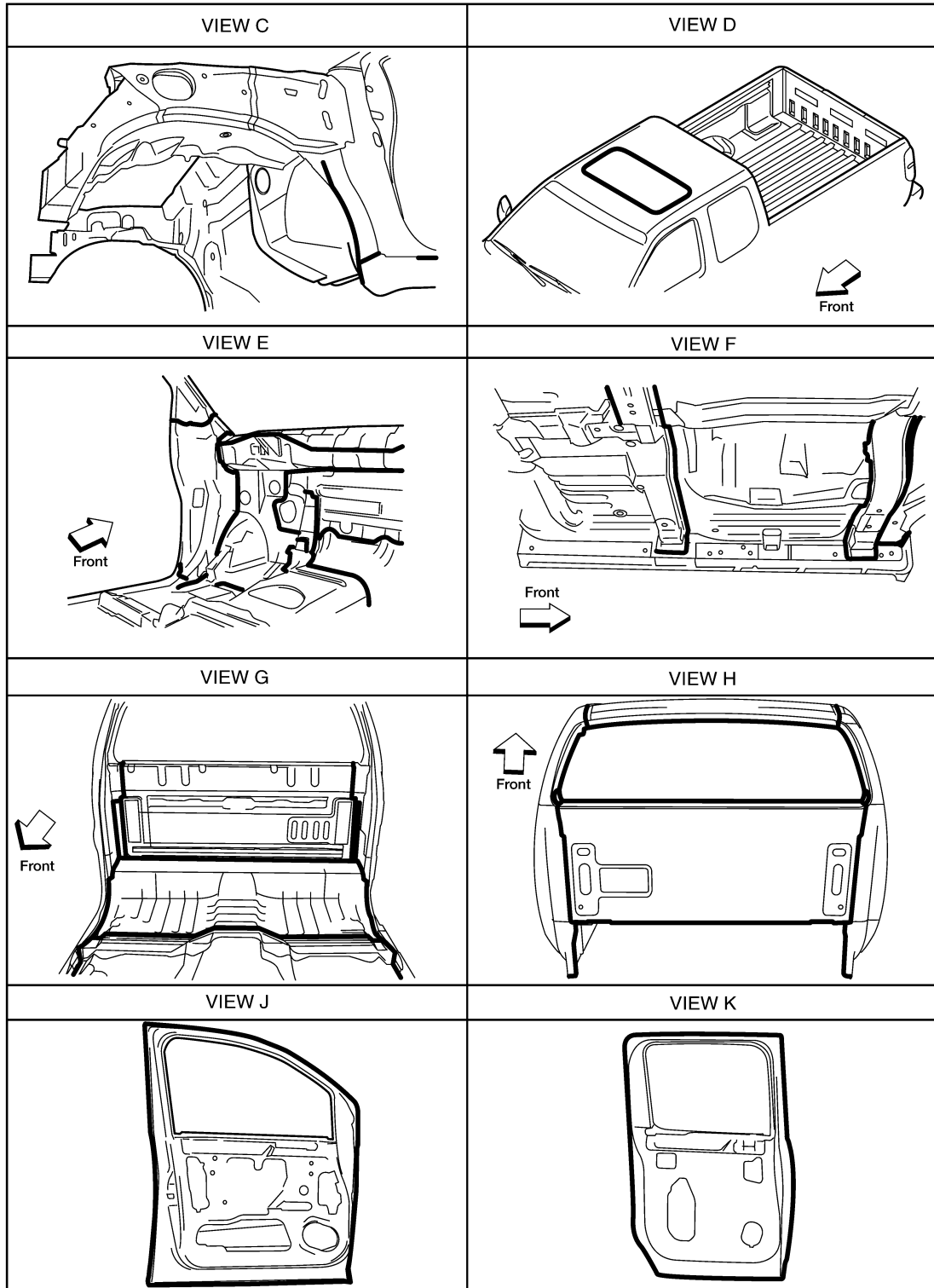
< REMOVAL AND INSTALLATION >

The following figure shows the areas which are sealed at the factory. Sealant which has been applied to these areas should be smooth and free from cuts or gaps. Care should be taken not to apply an excess amount of sealant and not to allow other unaffected parts to come into contact with the sealant.



CORROSION PROTECTION

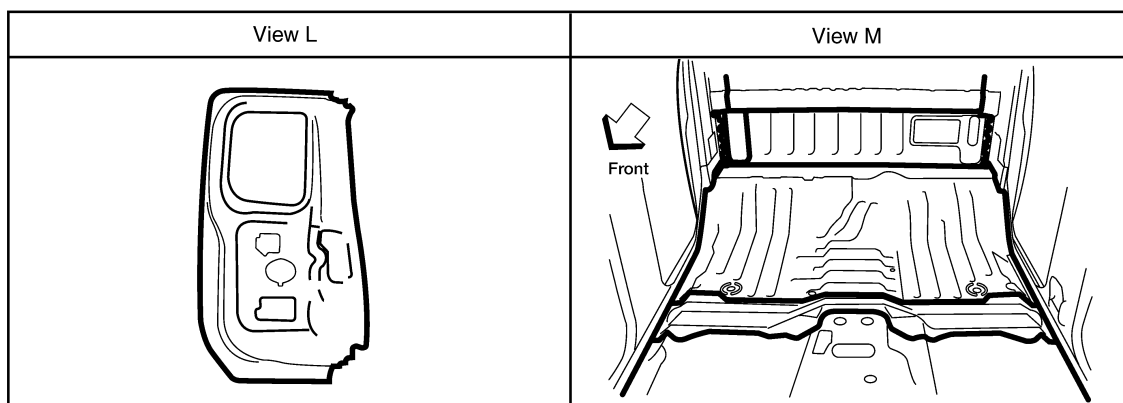
< REMOVAL AND INSTALLATION >



LI1A2002E

CORROSION PROTECTION

< REMOVAL AND INSTALLATION >



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BRM

LIIA2003E

BODY CONSTRUCTION

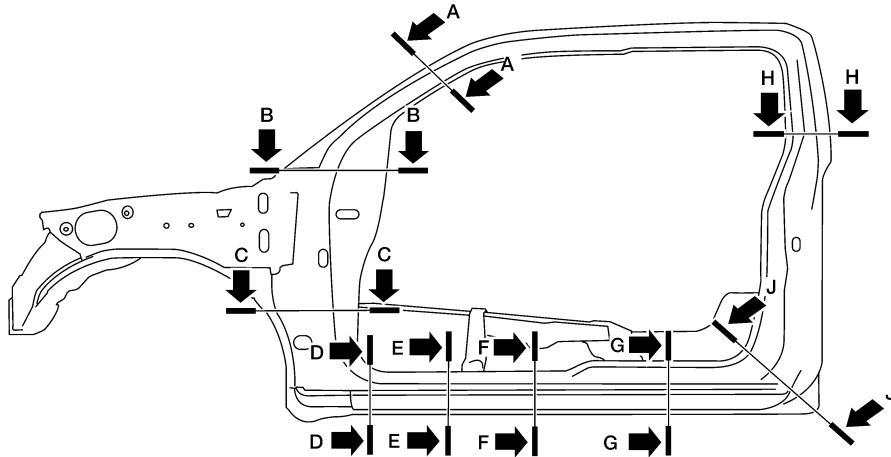
< REMOVAL AND INSTALLATION >

BODY CONSTRUCTION

Body Construction

INFOID:000000008792161

BODY CONSTRUCTION KING CAB

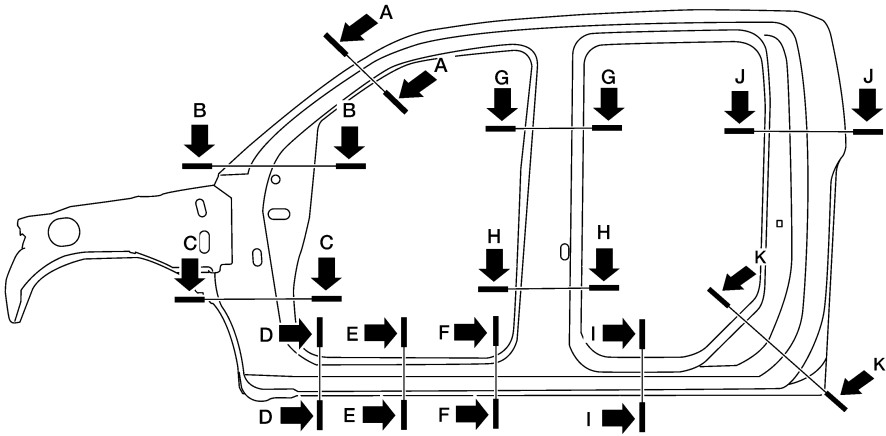


Section A-A	Section B-B	Section C-C	Section D-D
Section E-E	Section F-F	Section G-G	Section H-H
Section J-J			

LI1A1999E

BODY CONSTRUCTION

< REMOVAL AND INSTALLATION >
BODY CONSTRUCTION CREW CAB



Section A-A	Section B-B	Section C-C	Section D-D
Section E-E	Section F-F	Section G-G	Section H-H
Section I-I	Section J-J	Section K-K	

LIIA2000E

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BODY ALIGNMENT

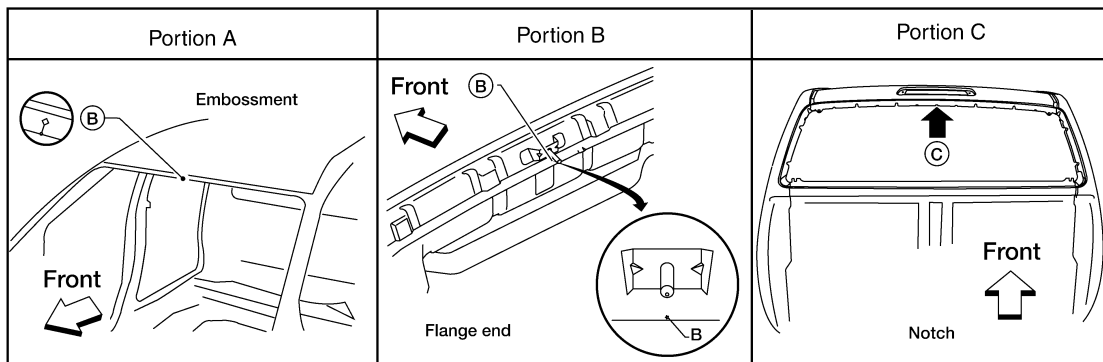
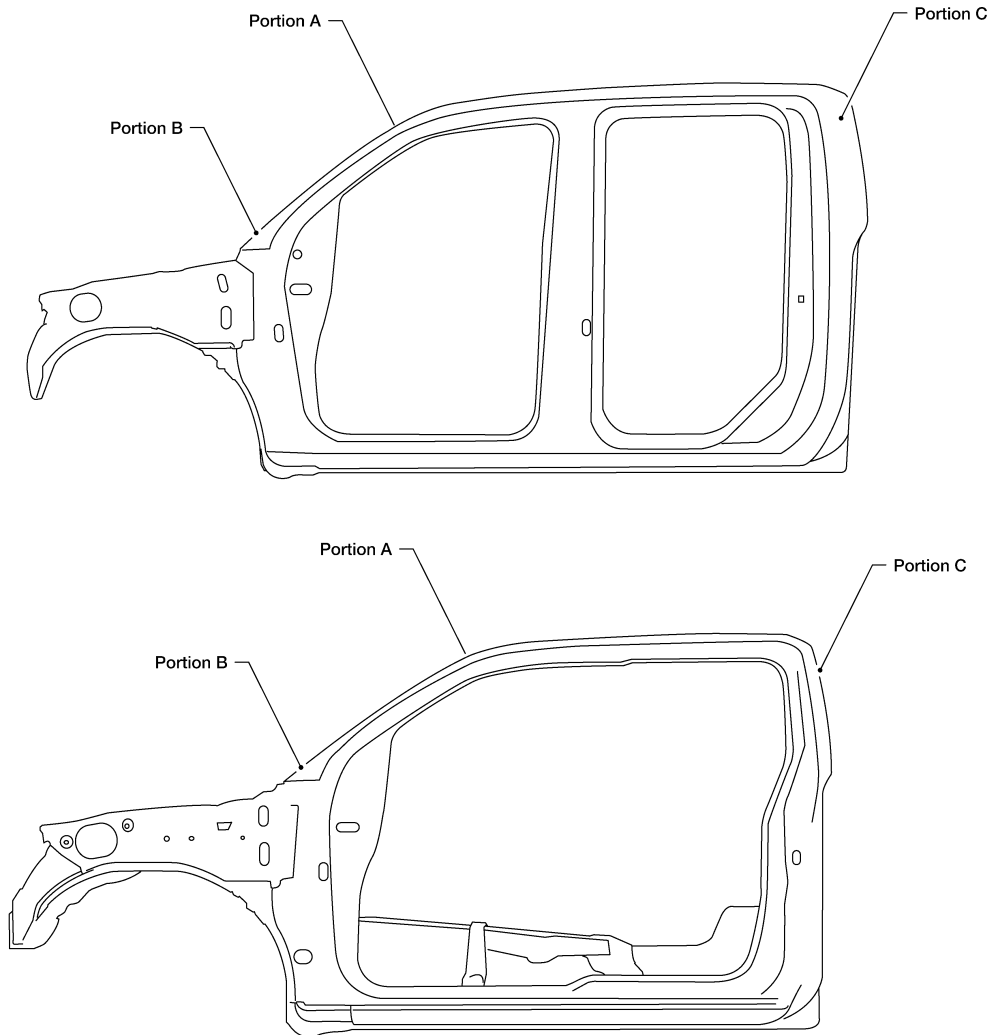
< REMOVAL AND INSTALLATION >

BODY ALIGNMENT

Body Alignment

INFOID:000000008792162

BODY CENTER MARKS



AWKIA1441GB

A mark has been placed on each part of the body to indicate the vehicle center. When repairing parts damaged by an accident which might affect the vehicle frame (members, pillars, etc.), more accurate and effective repair will be possible by using these marks together with body alignment specifications.

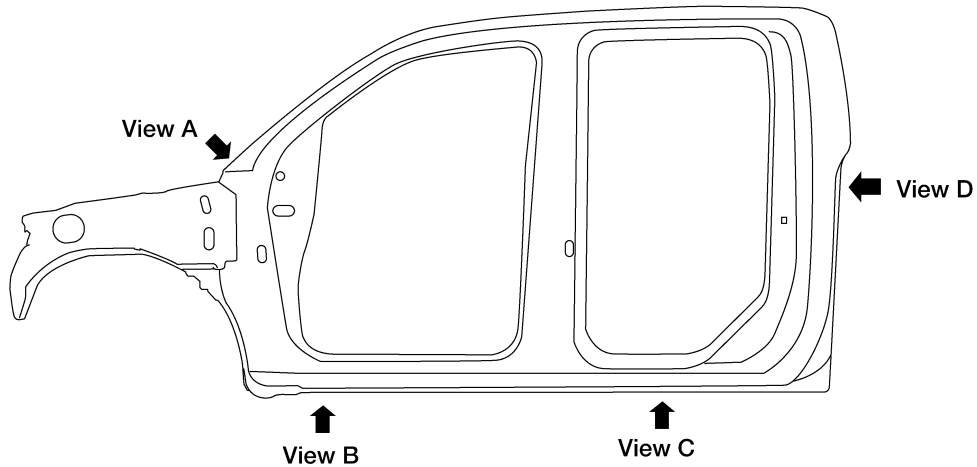
BODY ALIGNMENT

< REMOVAL AND INSTALLATION >

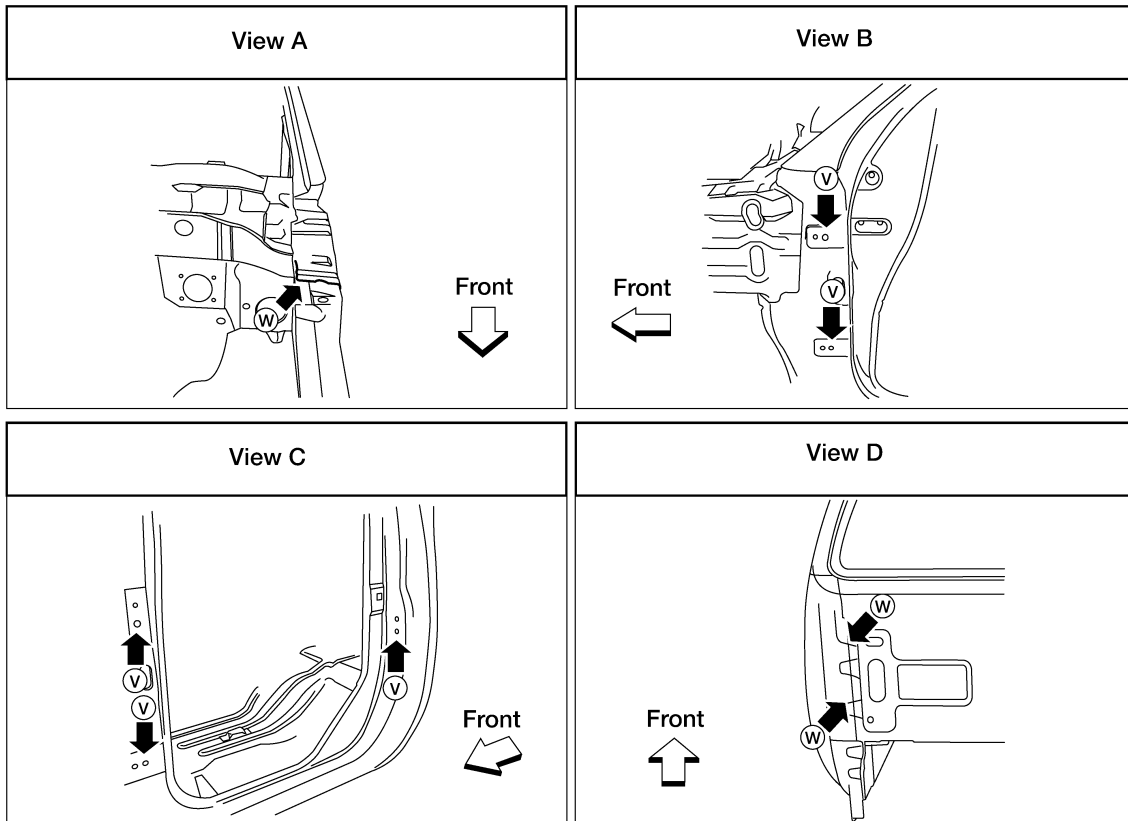
PANEL PARTS MATCHING MARKS

A mark has been placed on each body panel to indicate the parts matching positions. When repairing parts damaged by an accident which might affect the vehicle structure (members, pillars, etc.), more accurate and effective repair will be possible by using these marks together with body alignment specifications.

Crew Cab



Type V: Type W:

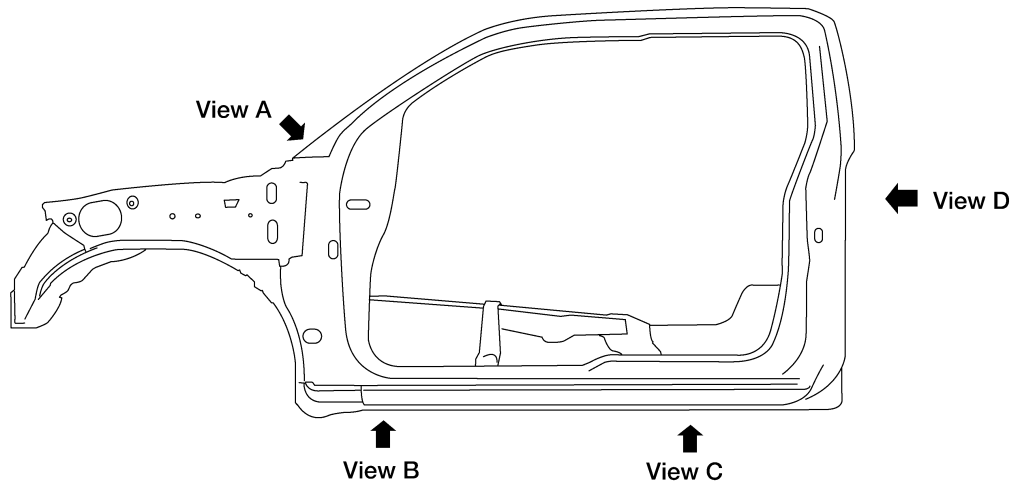


ANKIA1442GB

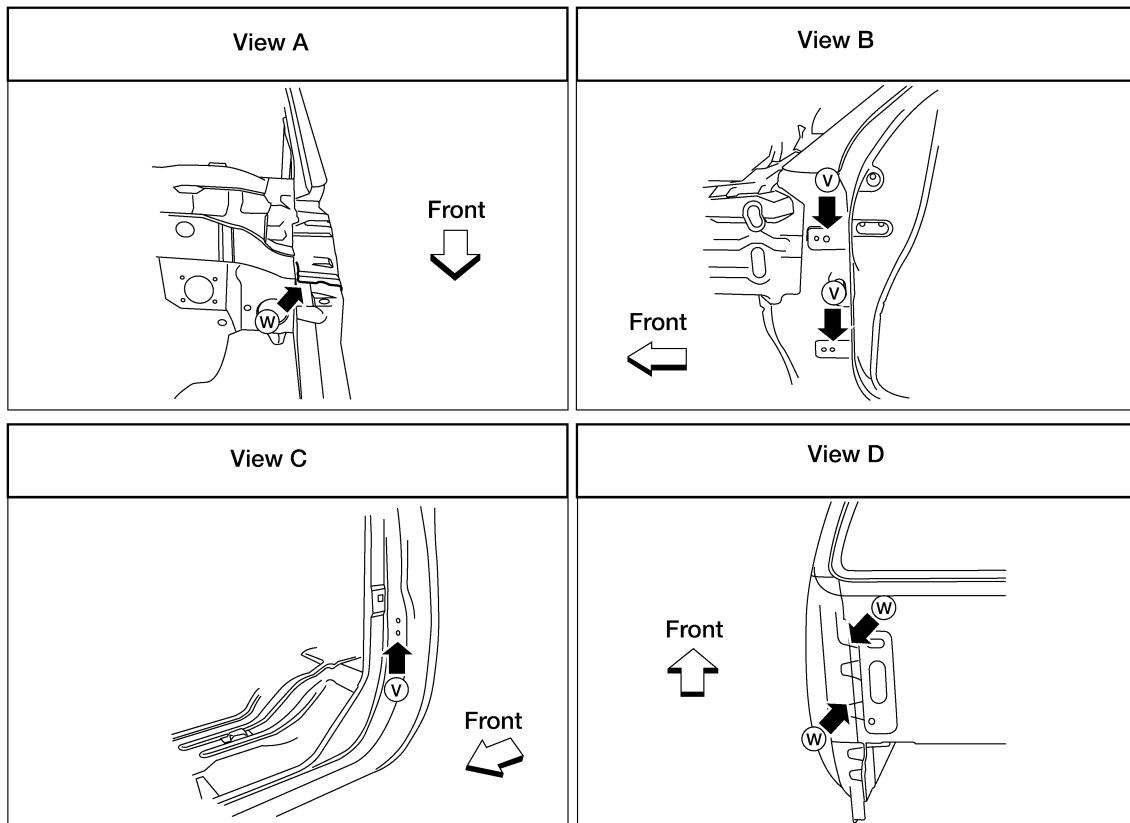
BODY ALIGNMENT

< REMOVAL AND INSTALLATION >

King Cab



Type V: ○ ----- □ □
 Type W: ● ----- □ □



AWKIA1443GB

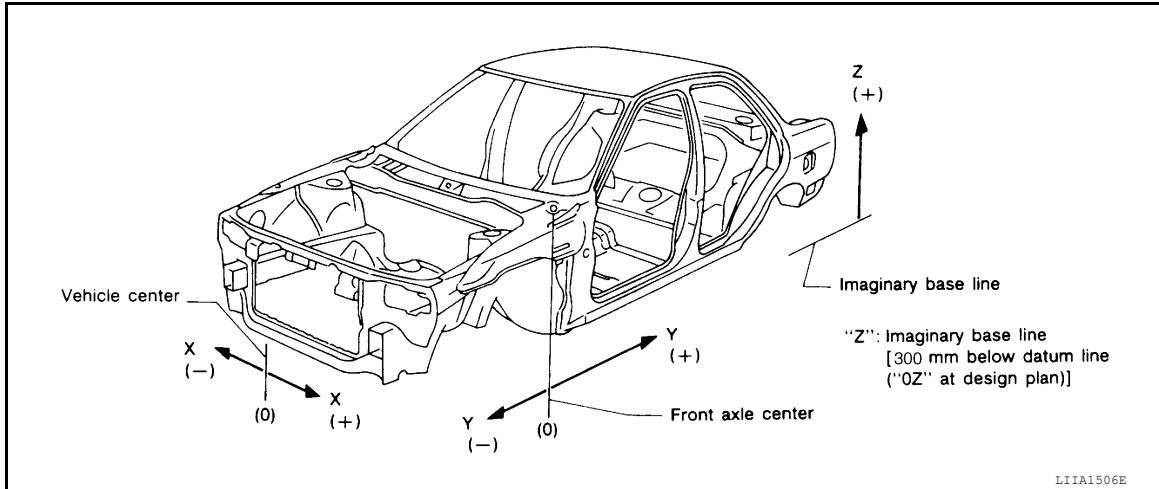
DESCRIPTION

- All dimensions indicated in the figures are actual.
- When using a tracking gauge, adjust both pointers to equal length. Then check the pointers and gauge itself to make sure there is no free play.
- When a measuring tape is used, check to be sure there is no elongation, twisting or bending.
- Measurements should be taken at the center of the mounting holes.
- An asterisk (*) following the value at the measuring point indicates that the measuring point on the other side is symmetrically the same value.

BODY ALIGNMENT

< REMOVAL AND INSTALLATION >

- The coordinates of the measurement points are the distances measured from the standard line of "X", "Y" and "Z".



ENGINE COMPARTMENT

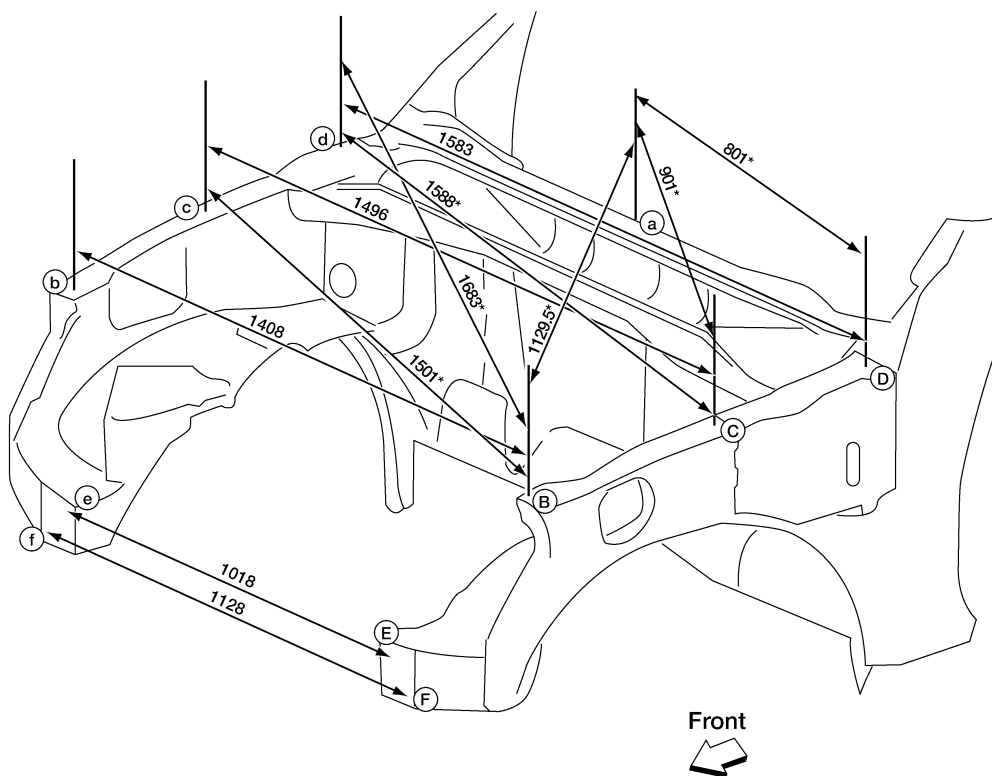
BODY ALIGNMENT

< REMOVAL AND INSTALLATION >

Measurement

All dimensions indicated in this figure are actual.

Figures marked with an (*) indicate symmetrically identical dimensions on both right and left hand sides of the vehicle.



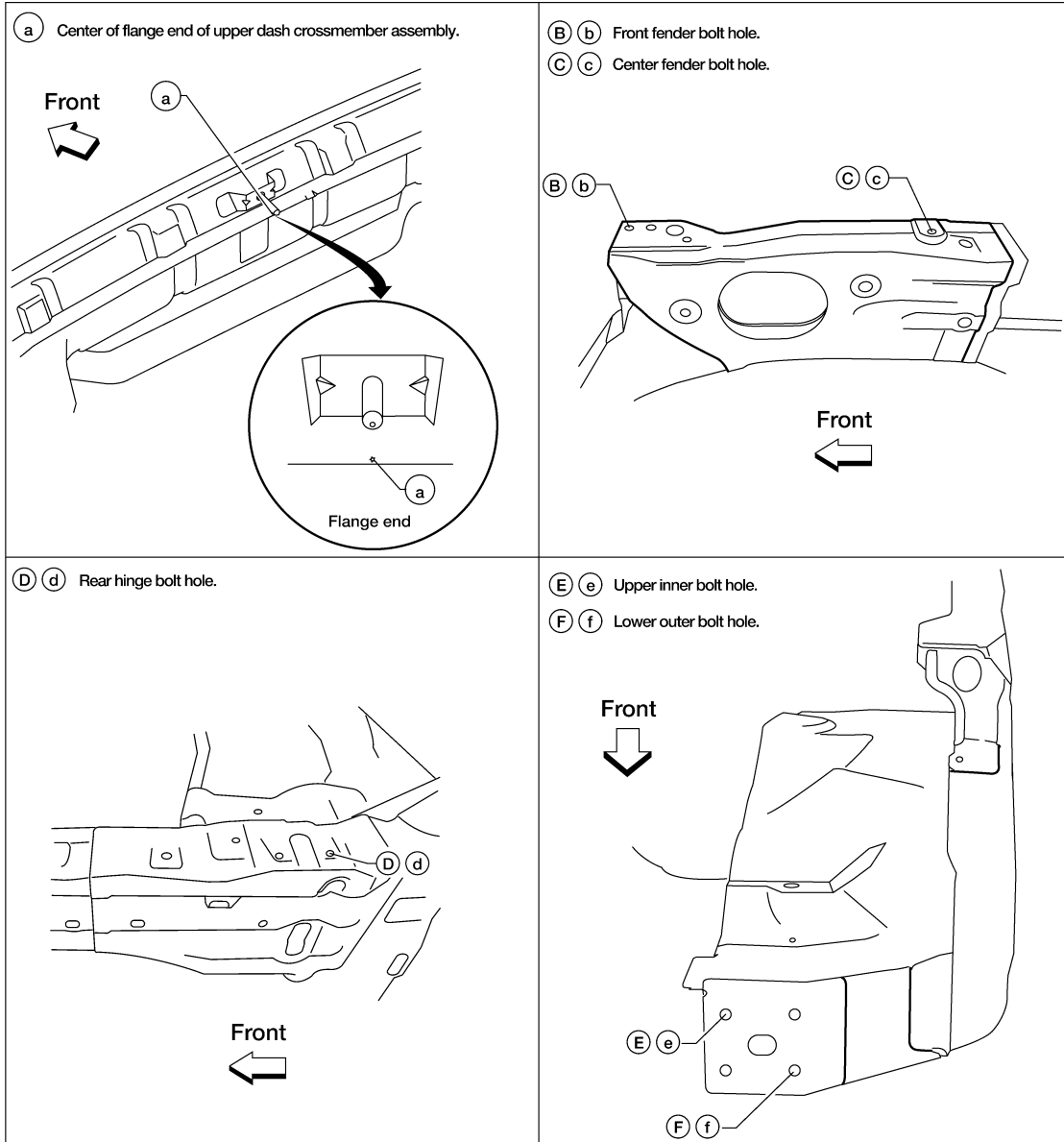
Unit: mm

AWKIA1576GB

BODY ALIGNMENT

< REMOVAL AND INSTALLATION >

Measurement Points



UNDERBODY

BODY ALIGNMENT

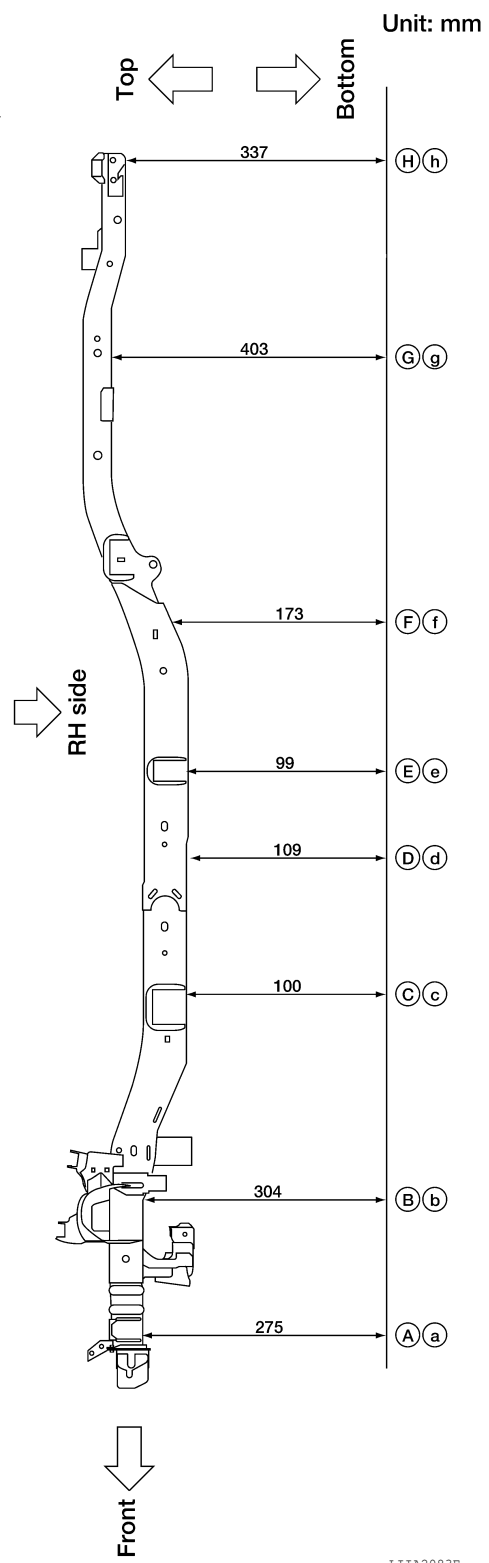
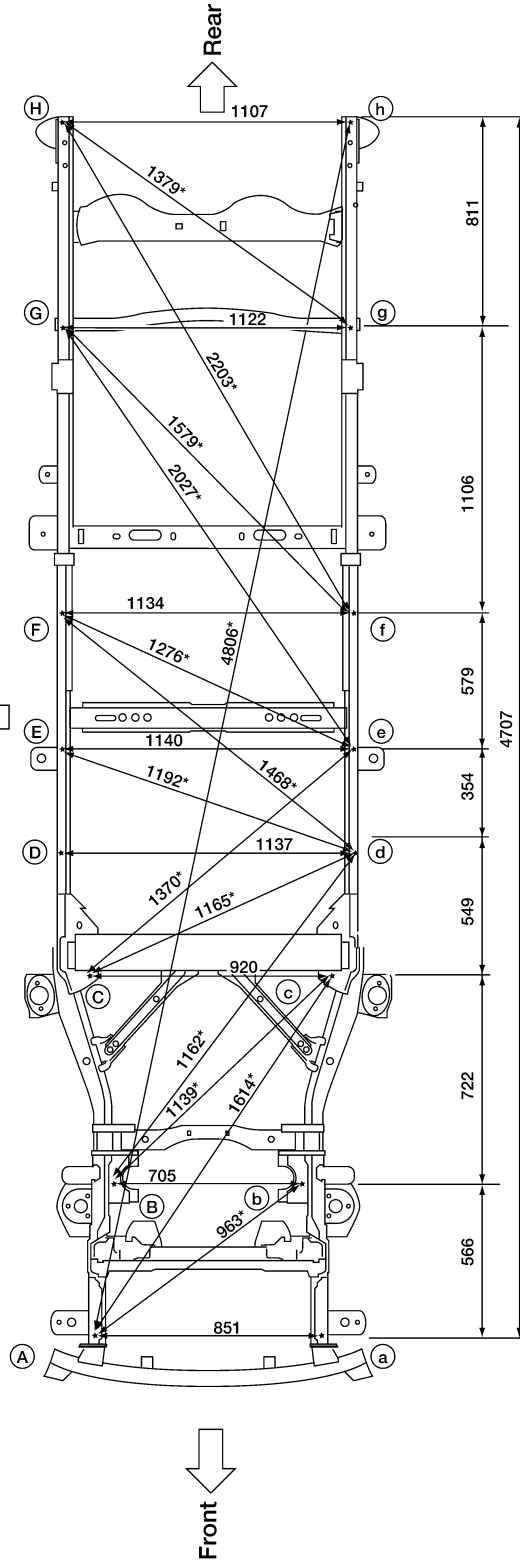
< REMOVAL AND INSTALLATION >

Measurement

Figures marked with a (*) indicate symmetrically identical dimensions on both right and left hand sides of the vehicle.

As viewed from underside.

All dimensions indicated in this figure are actual.

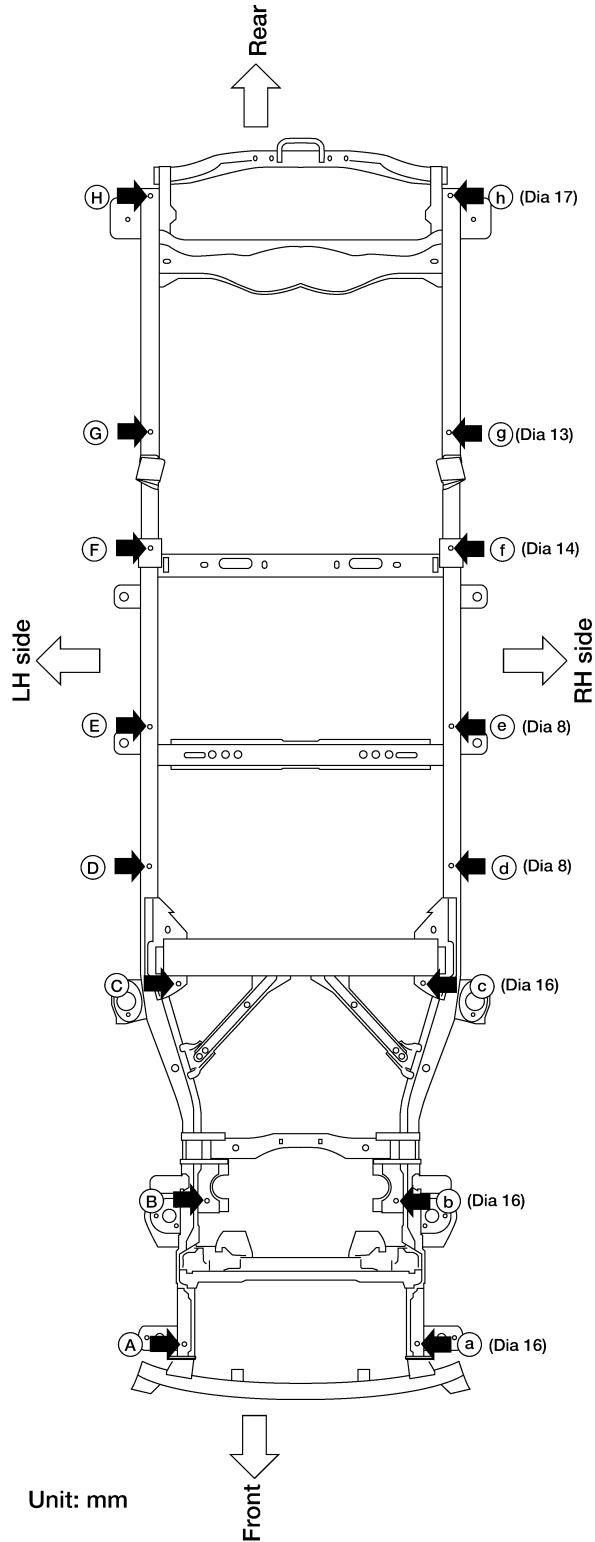


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BODY ALIGNMENT

< REMOVAL AND INSTALLATION >

Measurement Points



Coordinates:

(A) a
X : ± 425
Y : -531
Z : 275
(B) b
X : ± 353
Y : 35
Z : 304
(C) c
X : ± 460
Y : 807
Z : 100
(D) d
X : ± 568
Y : 1356
Z : 109
(E) e
X : ± 570
Y : 1710
Z : 99
(F) f
X : ± 567
Y : 2285
Z : 173
(G) g
X : ± 562
Y : 3365
Z : 403
(H) h
X : ± 553
Y : 4173
Z : 337

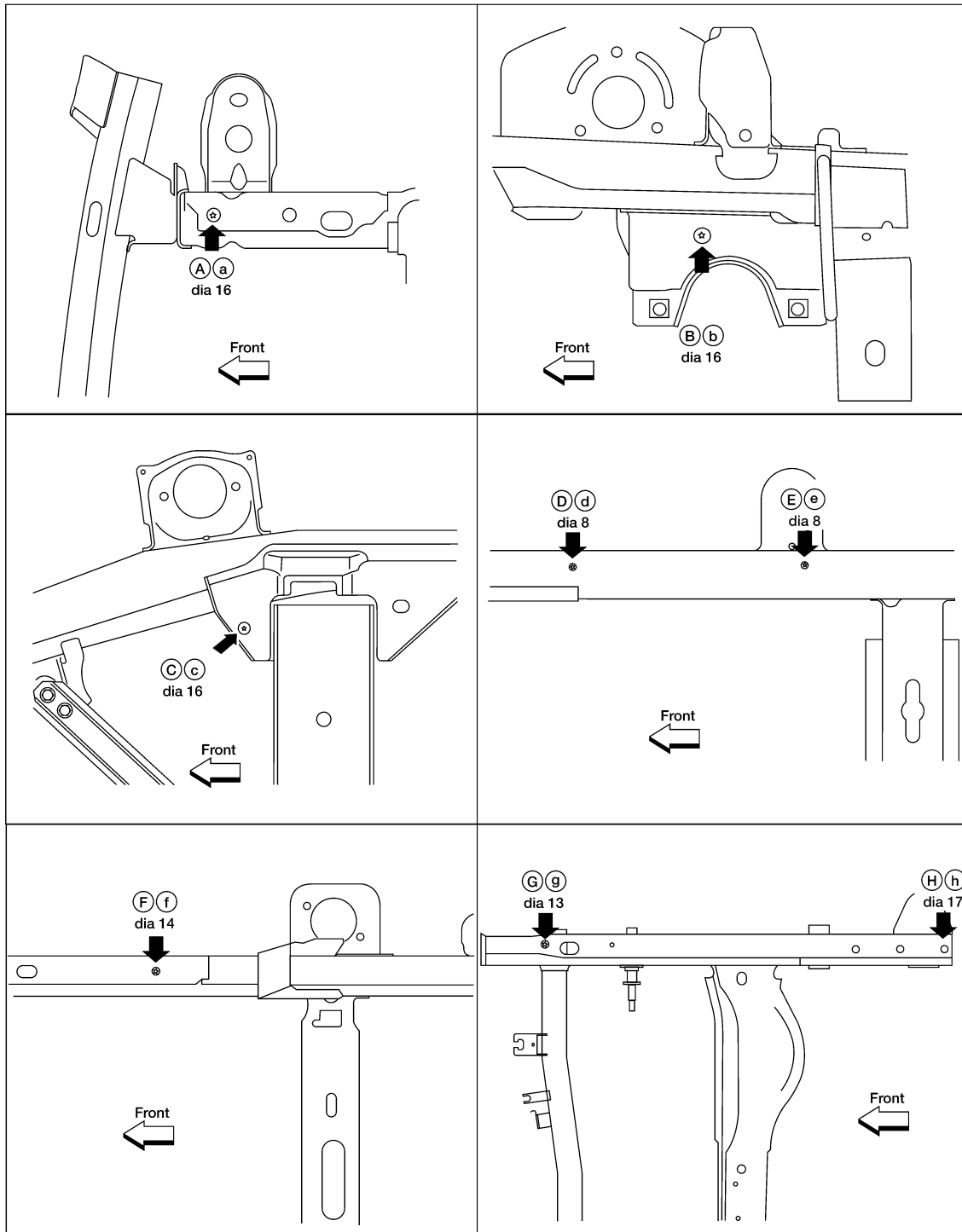
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ANKIA1578GB

BODY ALIGNMENT

< REMOVAL AND INSTALLATION >



Coordinates:	(A,a)	(B,b)	(C,c)	(D,d)	(E,e)	(F,f)	(G,g)	(H,h)
	X : ± 425	X : ± 353	X : ± 460	X : ± 568	X : ± 570	X : ± 567	X : ± 562	X : ± 553
	Y : -531	Y : 35	Y : 807	Y : 1356	Y : 1710	Y : 2285	Y : 3365	Y : 4123
	Z : 275	Z : 304	Z : 100	Z : 109	Z : 99	Z : 173	Z : 403	Z : 337
Unit: mm								

Unit: mm

LIIA2085E

BODY ALIGNMENT

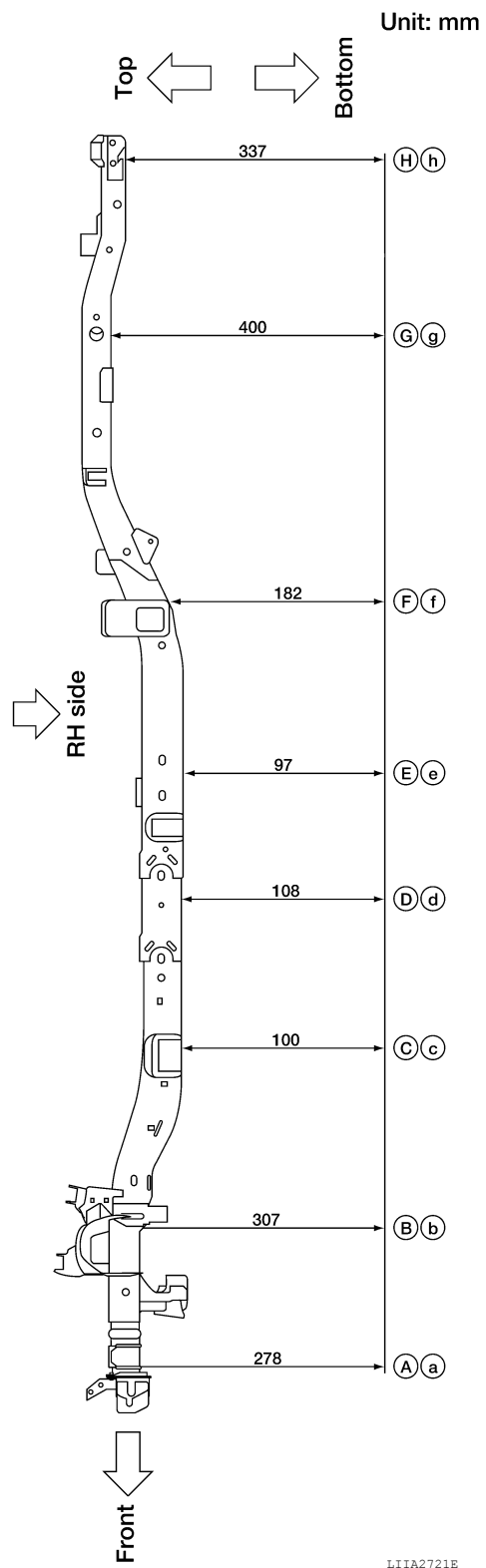
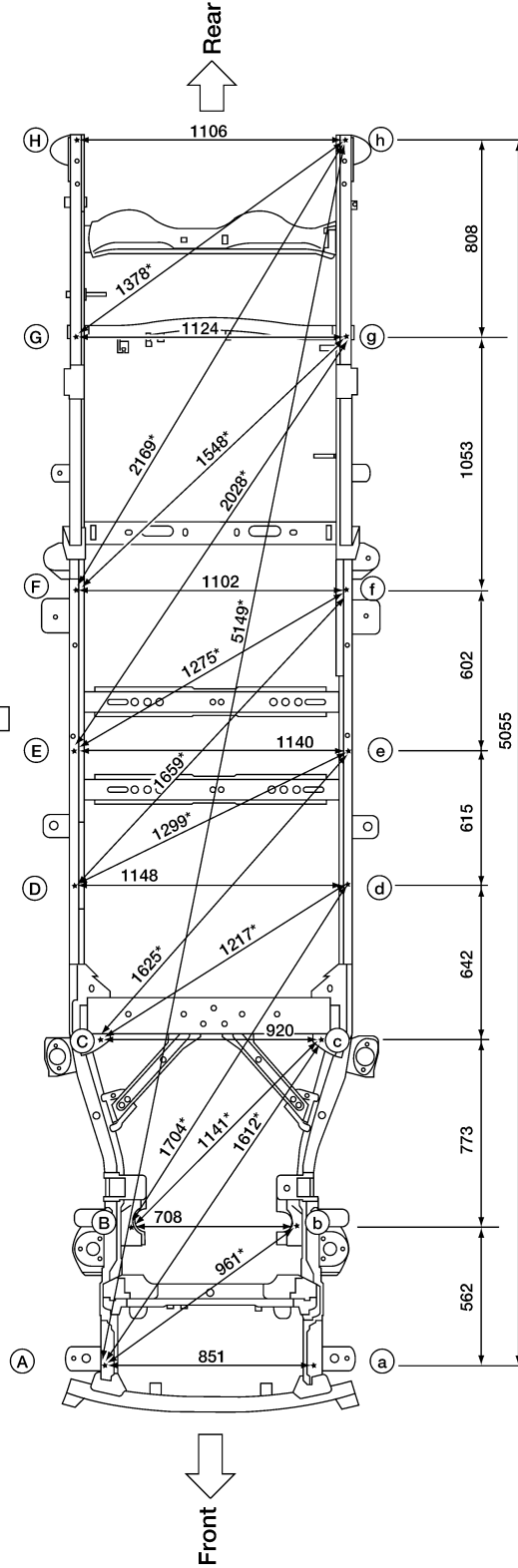
< REMOVAL AND INSTALLATION >

Measurement (Crew Cab Long Bed)

Figures marked with a (*) indicate symmetrically identical dimensions on both right and left hand sides of the vehicle.

As viewed from underside.

All dimensions indicated in this figure are actual.



L11A2721E

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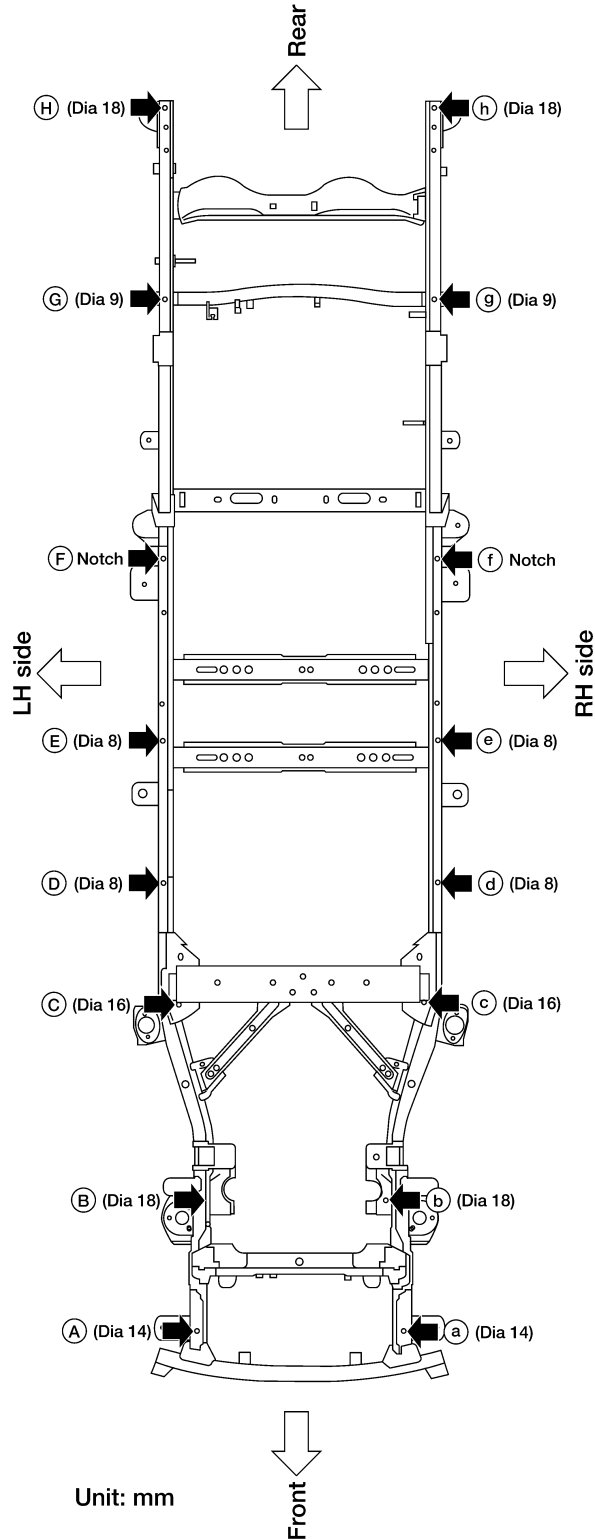
BODY ALIGNMENT

< REMOVAL AND INSTALLATION >

Measurement Points (Crew Cab Long Bed)

As viewed from underside.

All dimensions indicated in this figure are actual.



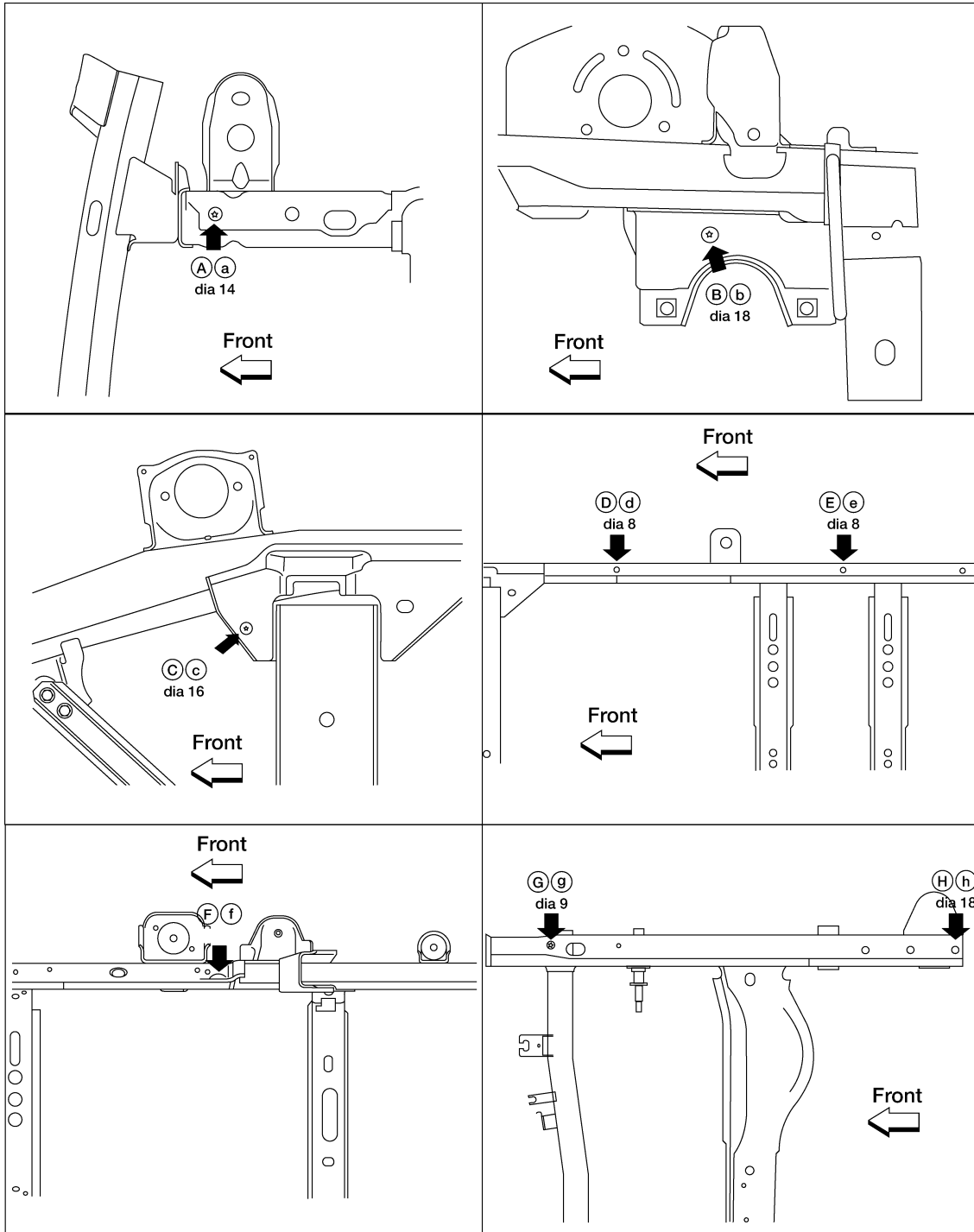
Coordinates:

(A), (a)	X : ± 425.5
	Y : -528
	Z : 278
(B), (b)	X : ± 354
	Y : 34
	Z : 307
(C), (c)	X : ± 460
	Y : 807
	Z : 100
(D), (d)	X : ± 574
	Y : 1449
	Z : 108
(E), (e)	X : ± 570
	Y : 2064
	Z : 97
(F), (f)	X : ± 551
	Y : 2666
	Z : 182
(G), (g)	X : ± 562
	Y : 3719
	Z : 400
(H), (h)	X : ± 553
	Y : 4527
	Z : 337

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BODY ALIGNMENT

< REMOVAL AND INSTALLATION >



Coordinates: (A), (a)		(B), (b)	(C), (c)	(D), (d)	(E), (e)	(F), (f)	(G), (g)	(H), (h)
X : ± 425.5		X : ± 354	X : ± 460	X : ± 574	X : ± 570	X : ± 551	X : ± 562	X : ± 553
Y : -528		Y : 34	Y : 807	Y : 1449	Y : 2064	Y : 2666	Y : 3719	Y : 4527
Z : 278		Z : 307	Z : 100	Z : 108	Z : 97	Z : 182	Z : 400	Z : 337

Unit: mm

AWKIA1446GB

PASSENGER COMPARTMENT

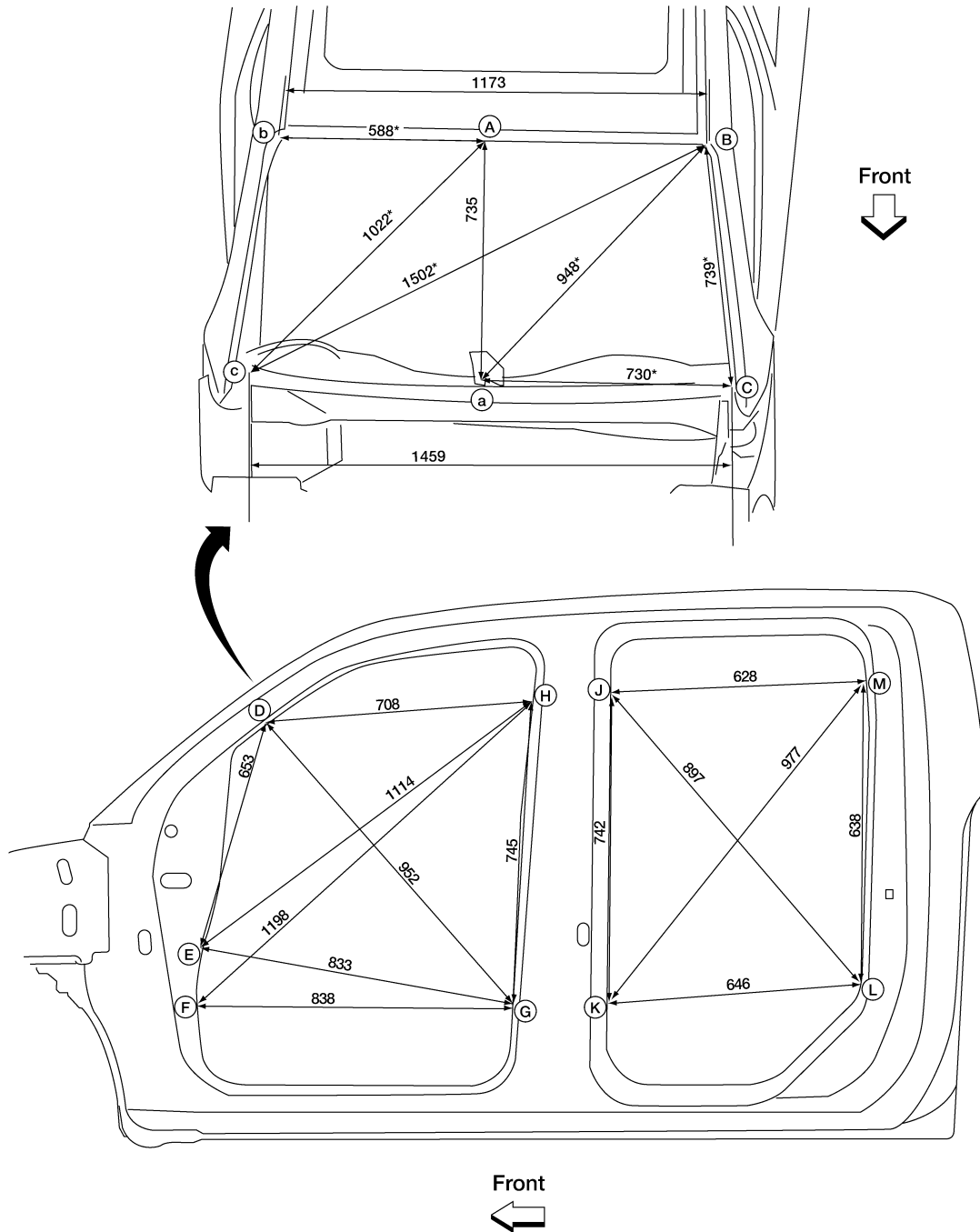
Measurement

BODY ALIGNMENT

< REMOVAL AND INSTALLATION >

Crew Cab

Figures marked with a (*) indicate symmetrically identical dimensions on both right and left hand sides of the vehicle.



Unit: mm

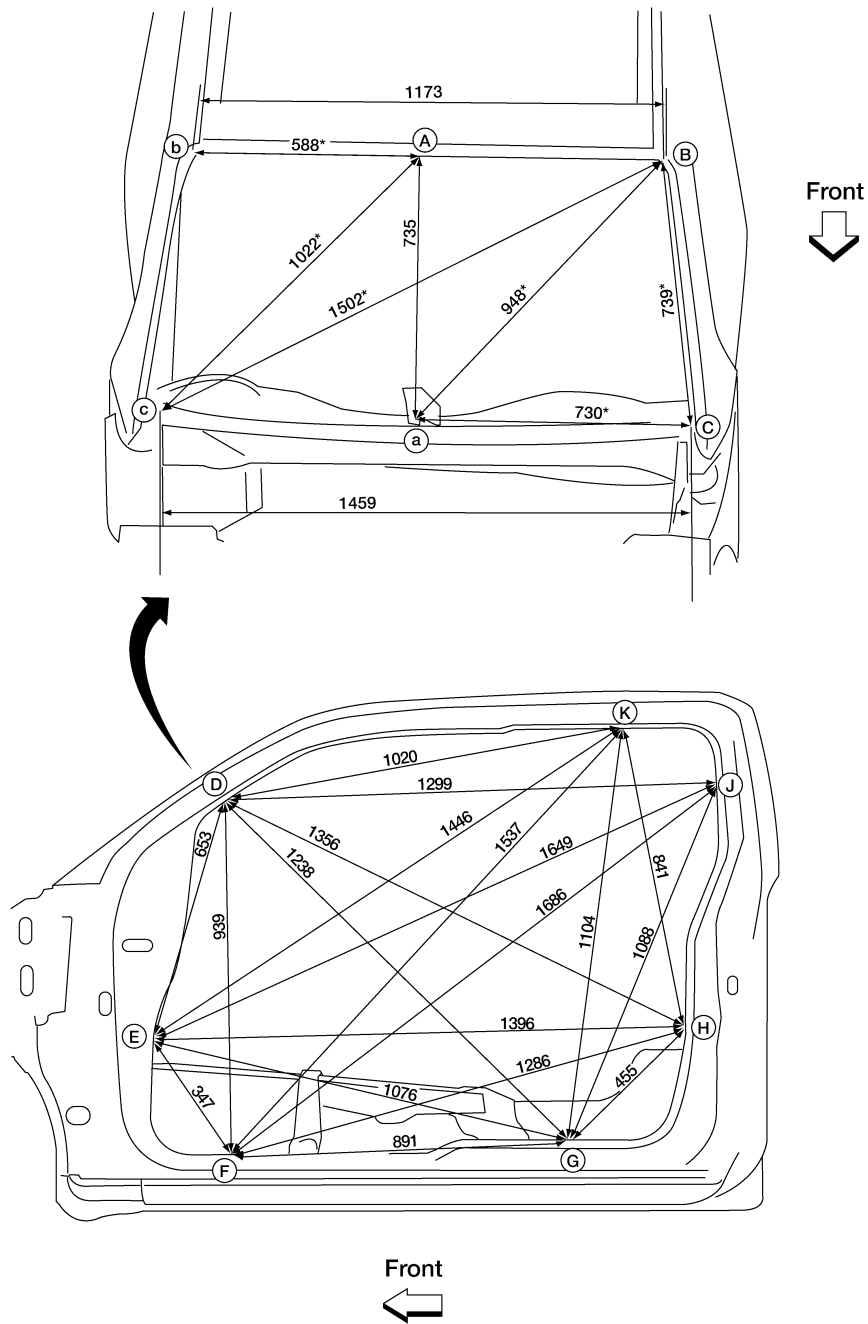
AWKIA1447GB

BODY ALIGNMENT

< REMOVAL AND INSTALLATION >

King Cab

Figures marked with a (*) indicate symmetrically identical dimensions on both right and left hand sides of the vehicle.



Unit: mm

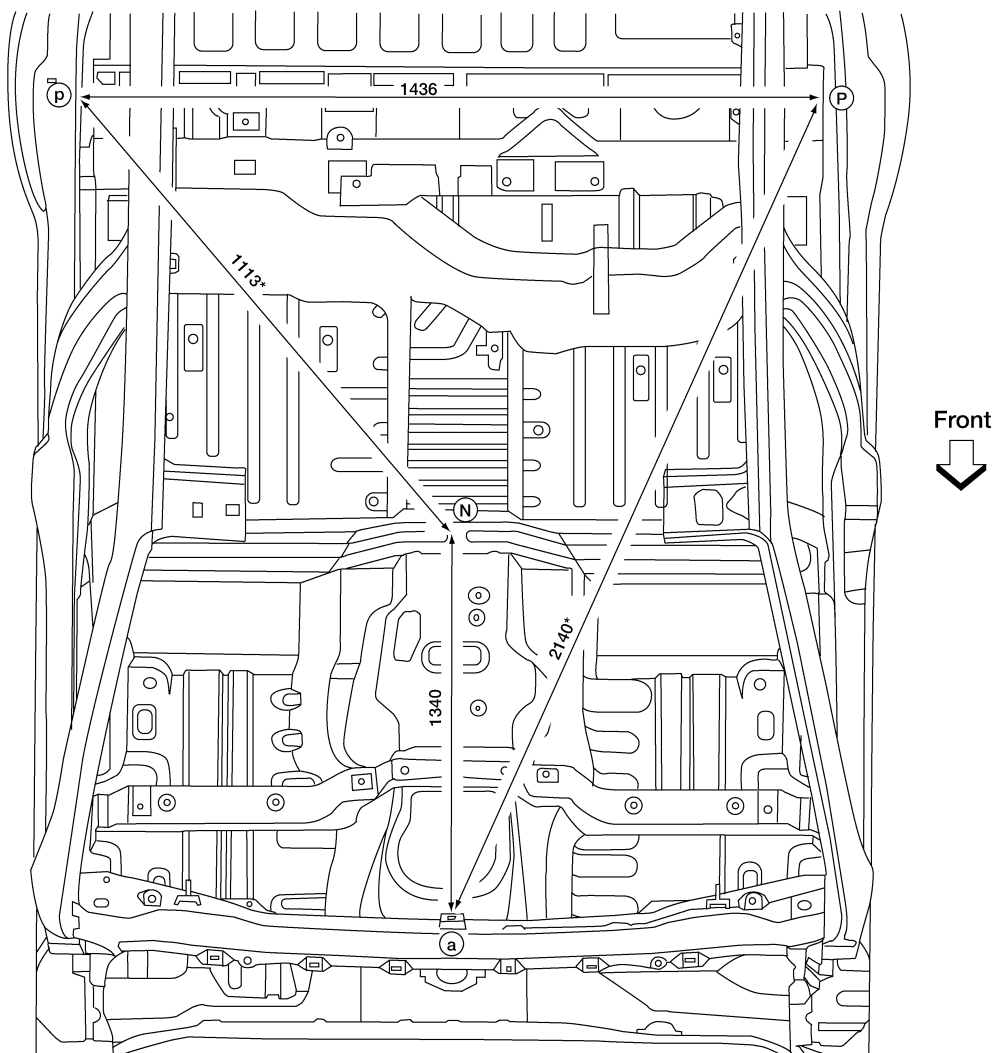
AWKIA1448GB

BODY ALIGNMENT

< REMOVAL AND INSTALLATION >

Crew Cab

Figures marked with a (*) indicate symmetrically identical dimensions on both right and left hand sides of the vehicle.



Unit: mm

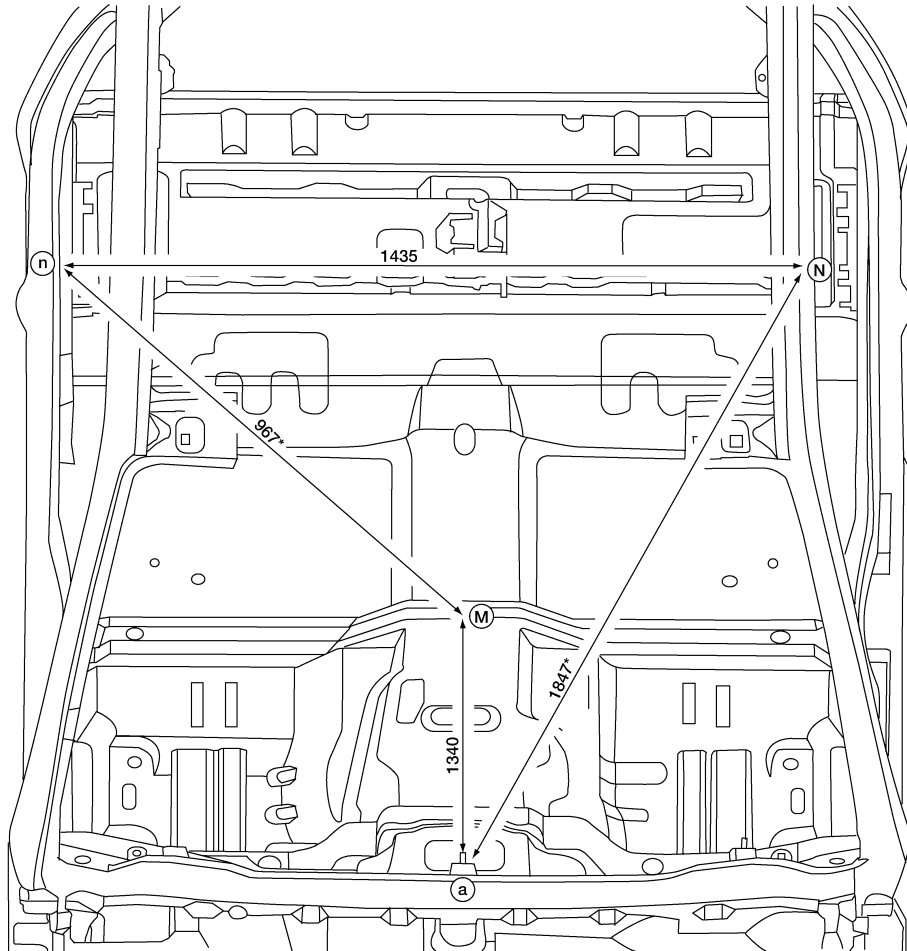
AWKIA1449GB

BODY ALIGNMENT

< REMOVAL AND INSTALLATION >

King Cab

Figures marked with a (*) indicate symmetrically identical dimensions on both right and left hand sides of the vehicle.



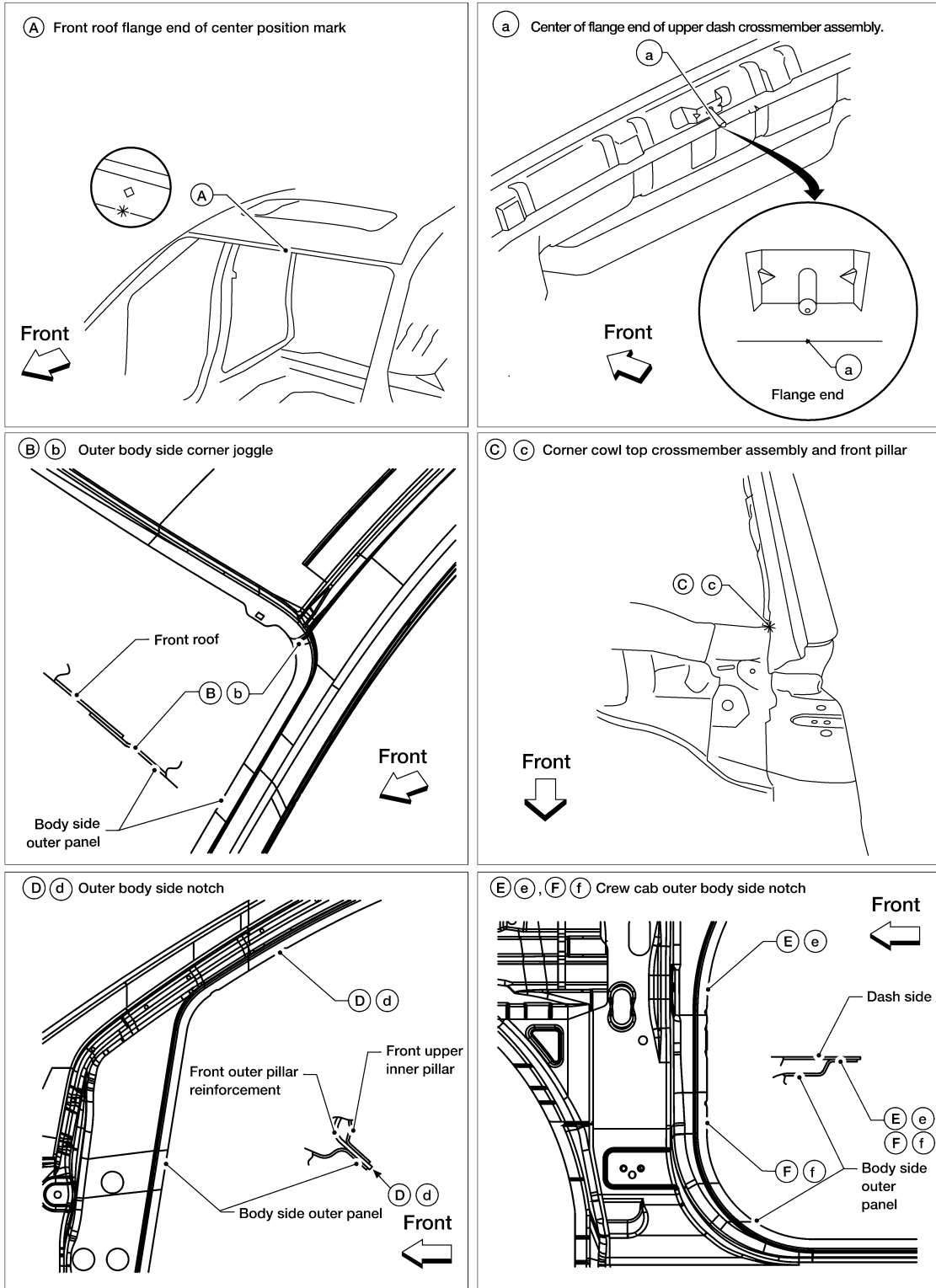
Unit: mm

AWKIA1450GB

BODY ALIGNMENT

< REMOVAL AND INSTALLATION >

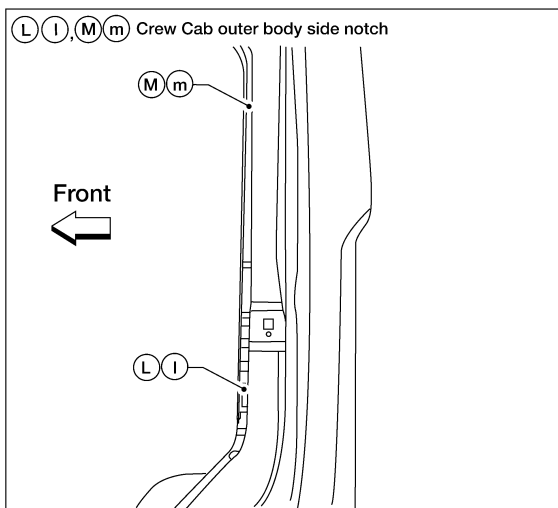
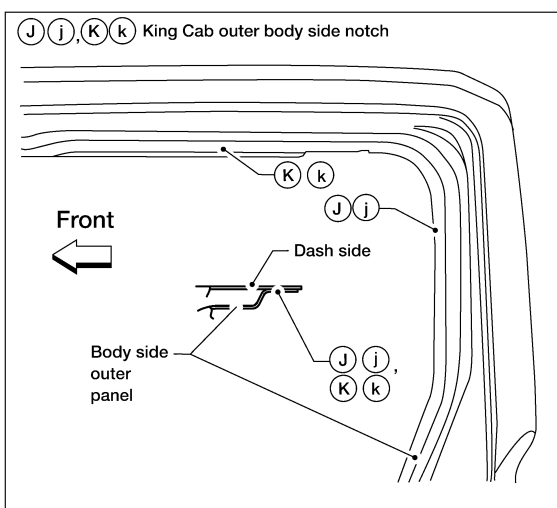
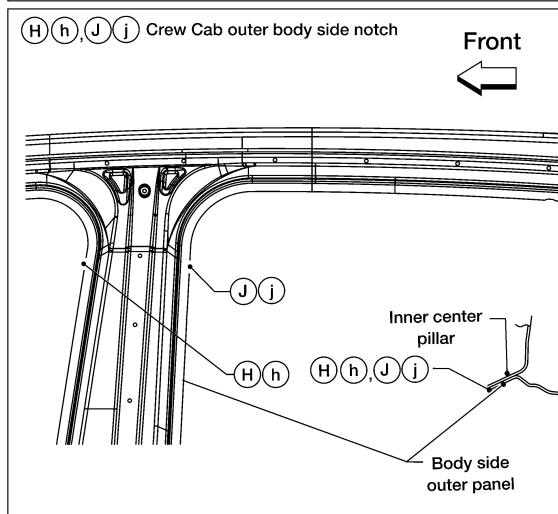
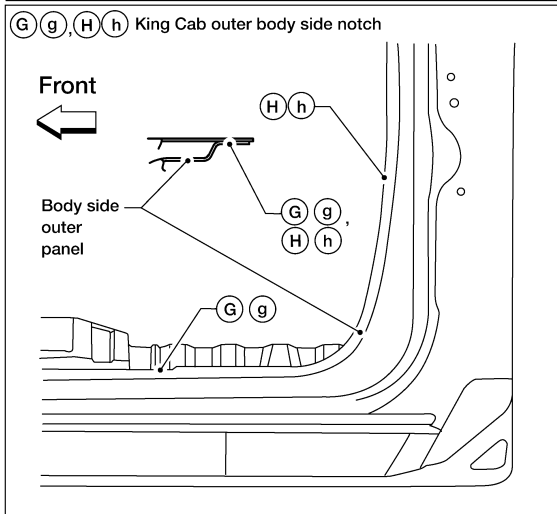
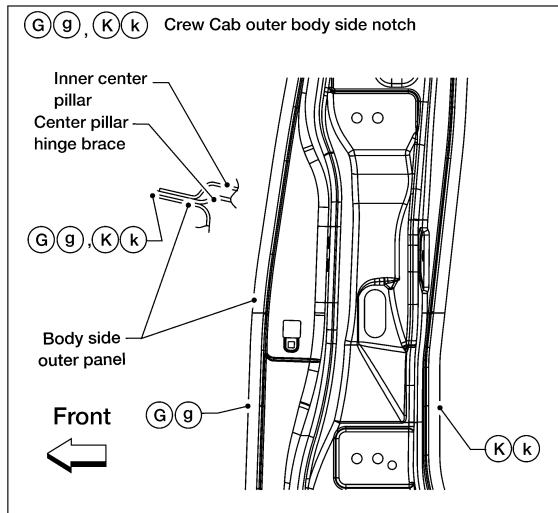
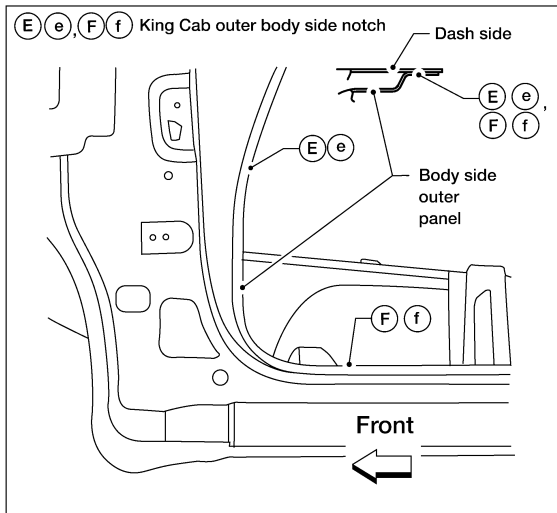
Measurement Points



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BODY ALIGNMENT

< REMOVAL AND INSTALLATION >

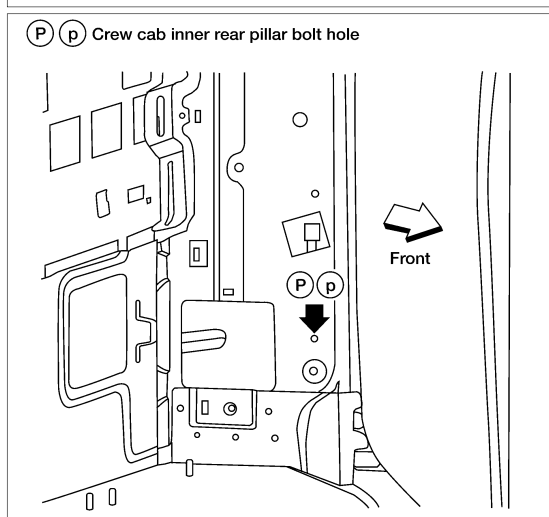
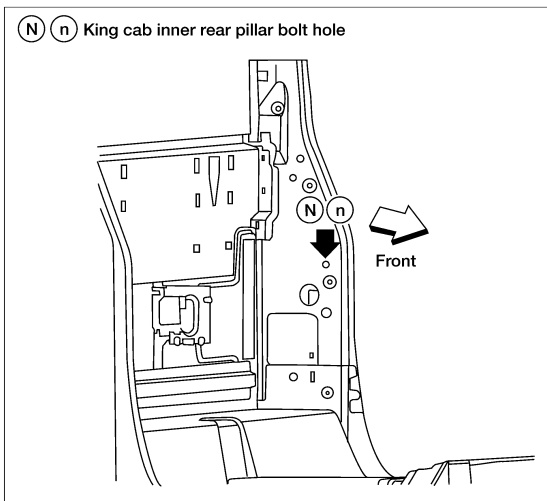
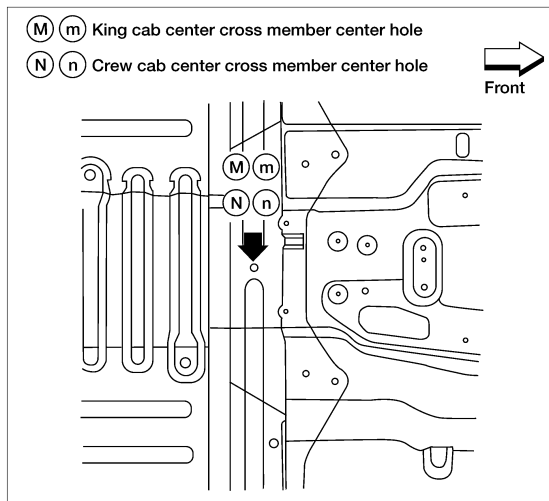


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BODY ALIGNMENT

< REMOVAL AND INSTALLATION >



LI1A2092E

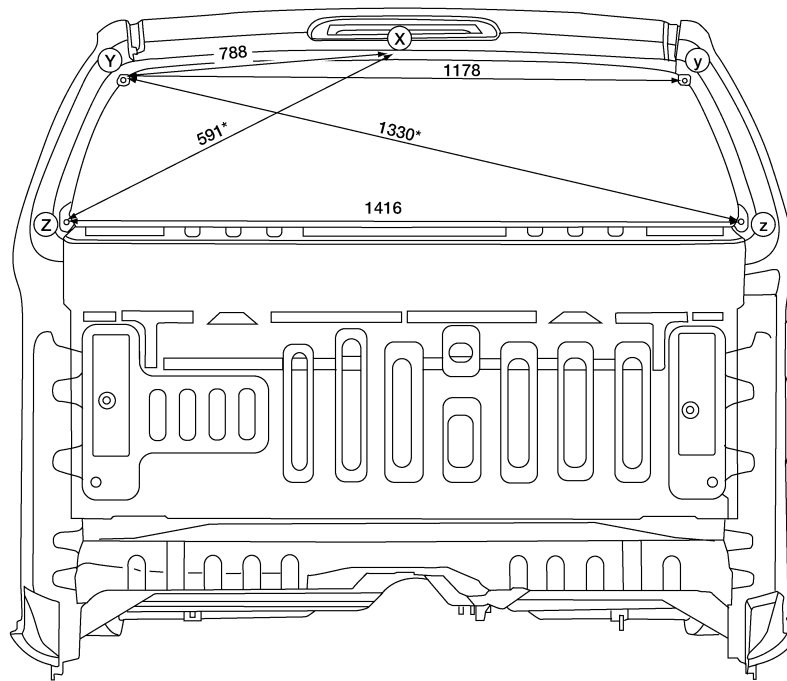
REAR BODY

BODY ALIGNMENT

< REMOVAL AND INSTALLATION >

Measurement

Figures marked with a (*) indicate symmetrically identical dimensions on both right and left sides of the vehicle.



Front



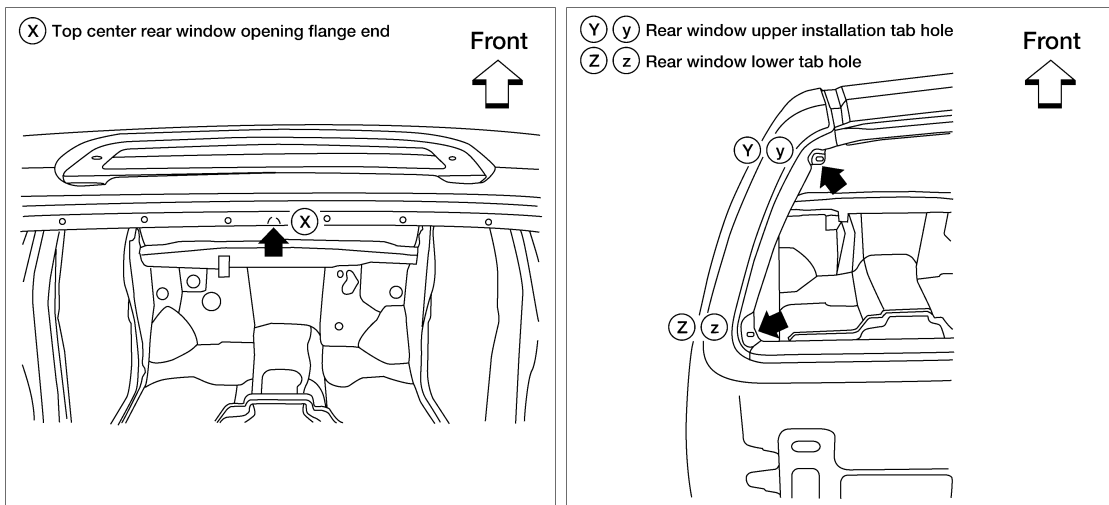
Unit: mm

ANKIA1453GB

BODY ALIGNMENT

< REMOVAL AND INSTALLATION >

Measurement Points



AWKIA1454GB

PICKUP BED

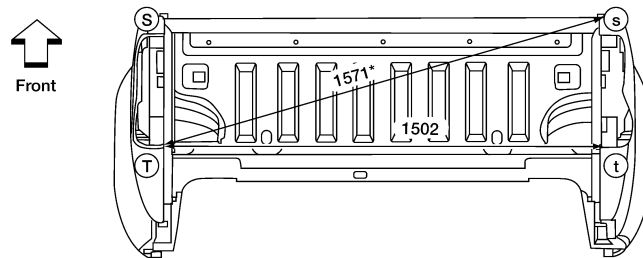
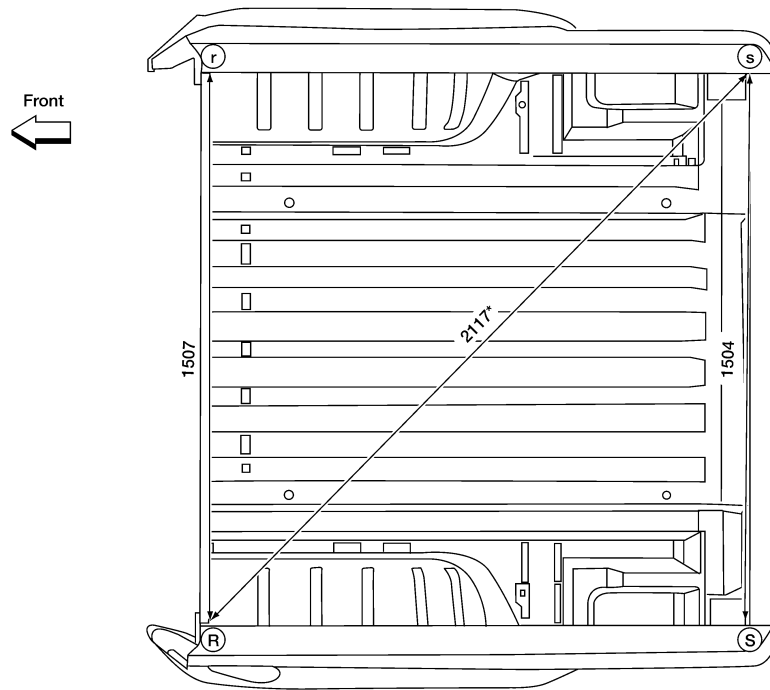
Measurements

BODY ALIGNMENT

< REMOVAL AND INSTALLATION >

Crew Cab

Figures marked with a (*) indicate symmetrically identical dimensions on both right and left sides of the vehicle.



Unit: mm

LIIA2095E

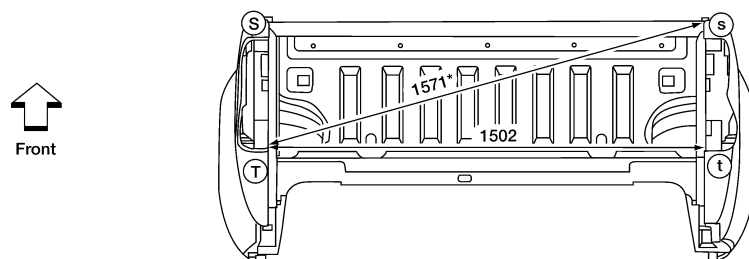
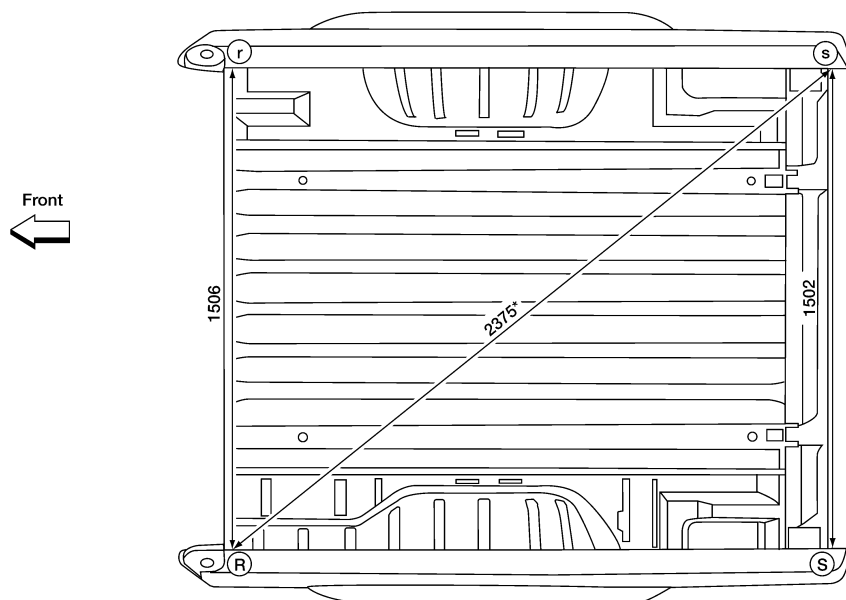
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BODY ALIGNMENT

< REMOVAL AND INSTALLATION >

King Cab

Figures marked with a (*) indicate symmetrically identical dimensions on both right and left sides of the vehicle.



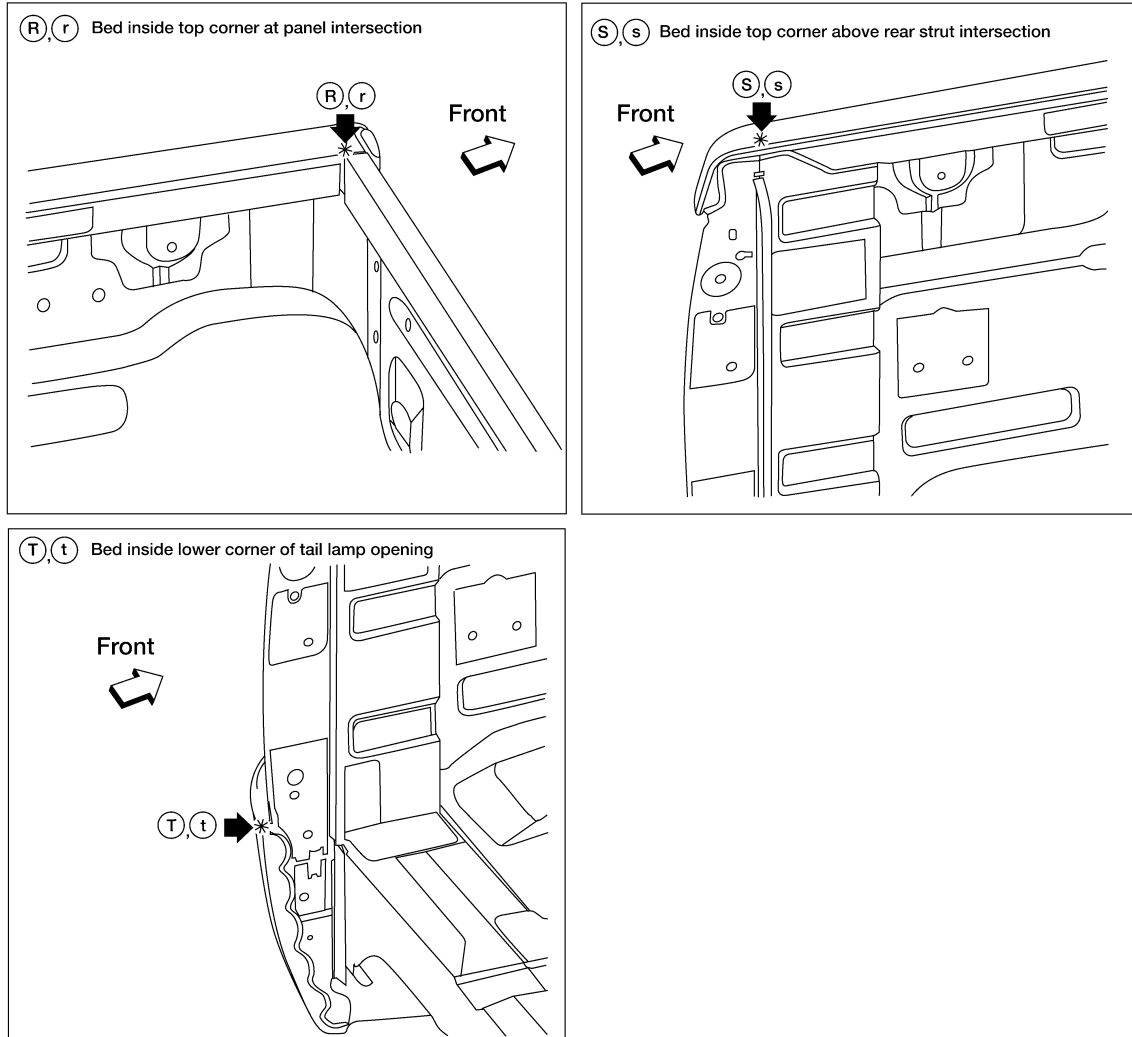
Unit: mm

LIIA2096E

BODY ALIGNMENT

< REMOVAL AND INSTALLATION >

Measurement points



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ANKIA1455GB

INFOID:000000008792163

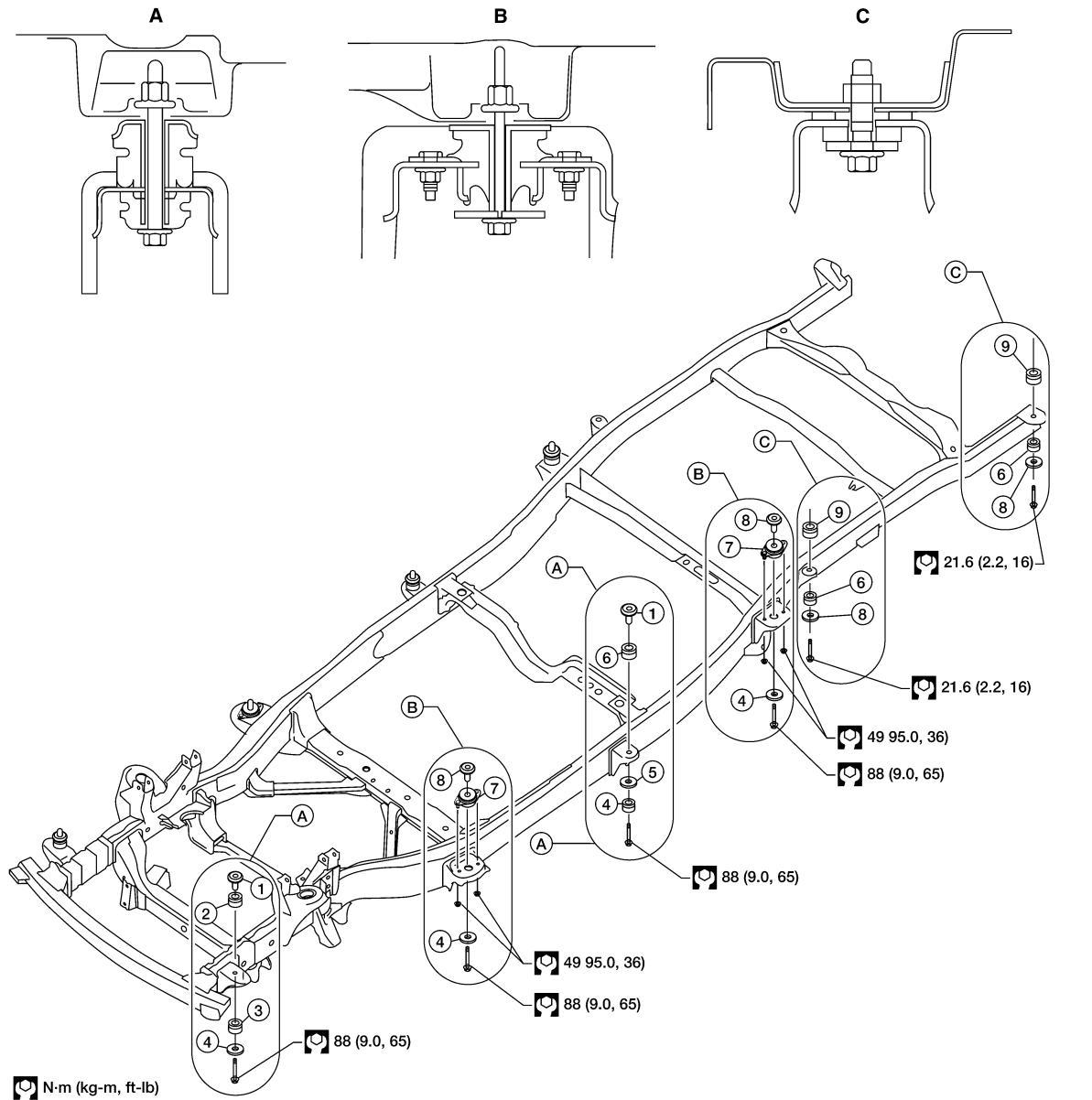
Body Mounting

- When removing, be sure to replace bolts and nuts (sealant applied bolts or self-lock nuts are used for all positions).
- Unless otherwise noted, the bushings and insulators have paint marks that are to be installed facing outward.

BODY ALIGNMENT

< REMOVAL AND INSTALLATION >

Crew Cab

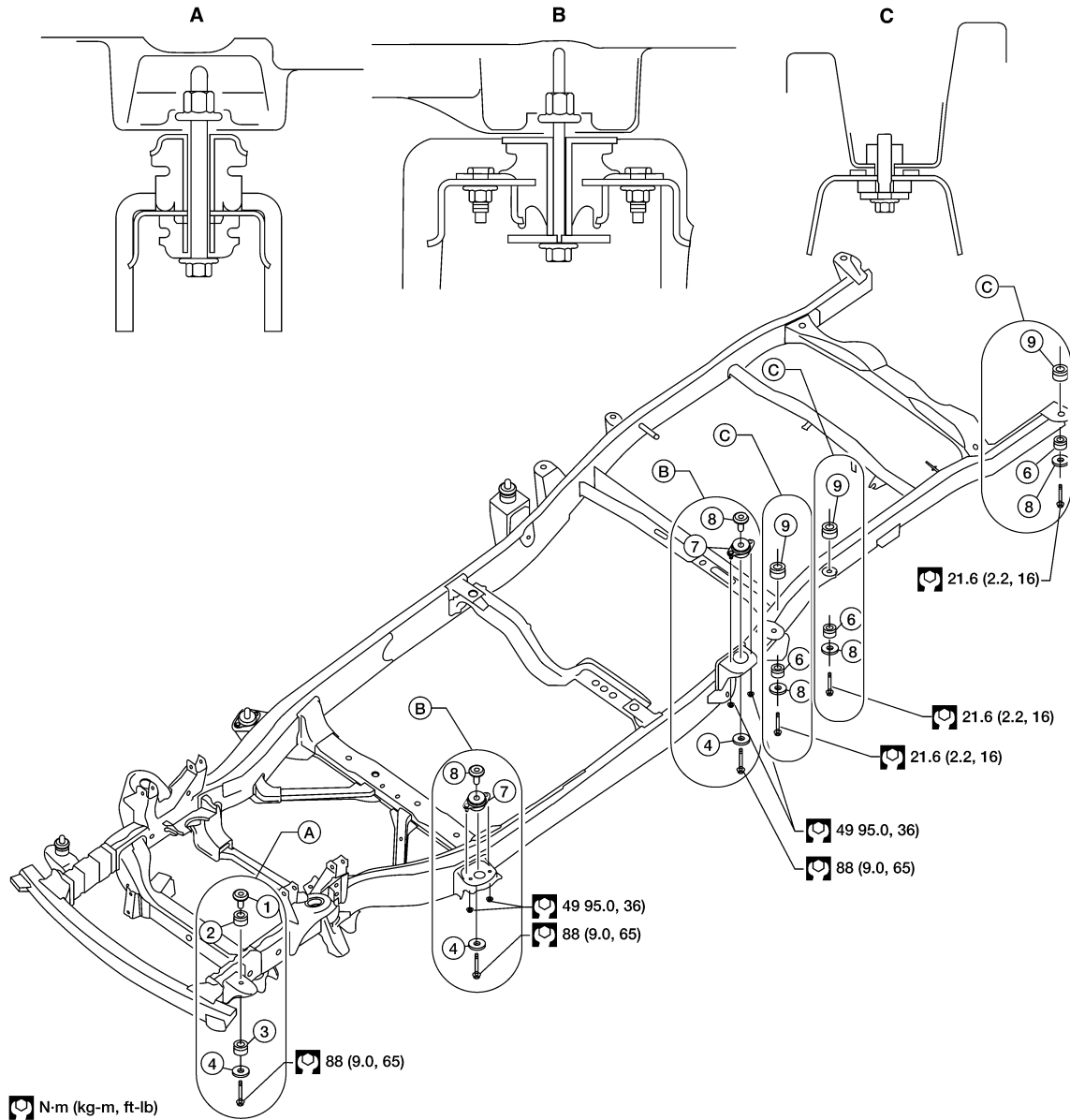


LI1A2100E

BODY ALIGNMENT

< REMOVAL AND INSTALLATION >

King Cab



- | | | |
|-------------------------|------------------|-------------------------------------|
| 1. Gold washer | 2. Upper bushing | 3. Lower bushing |
| 4. Black washer | 5. Washer | 6. Upper bushing without paint mark |
| 7. Body mount insulator | 8. Body washer | 9. Shim |

LI1A2101E

REPAIRING HIGH STRENGTH STEEL

< REMOVAL AND INSTALLATION >

REPAIRING HIGH STRENGTH STEEL

Precaution in Repairing High Strength Steel

INFOID:000000008792164

High strength steel is used for body panels in order to reduce vehicle weight.

Accordingly, precautions in repairing automotive bodies made of high strength steel are described below:

HIGH STRENGTH STEEL (HSS) USED IN NISSAN VEHICLES

Tensile strength	NISSAN/INFINITI designation	Major applicable parts
373 N/mm ² (38kg/mm ² , 54klb/sq in)	SP130	• Front inner pillar upper • Front pillar hinge brace • Outer front pillar reinforcement • Other reinforcements
785-981N/mm ² (80-100kg/mm ² 114-142klb/sq in)	SP150	• Outer sill reinforcement • Main back pillar

SP130 is the most commonly used HSS.

SP150 HSS is used only on parts that require much more strength.

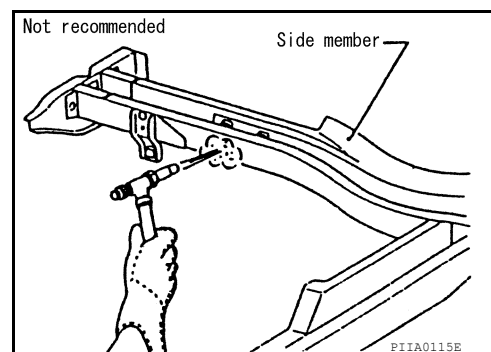
Read the following precautions when repairing HSS:

1. Additional points to consider

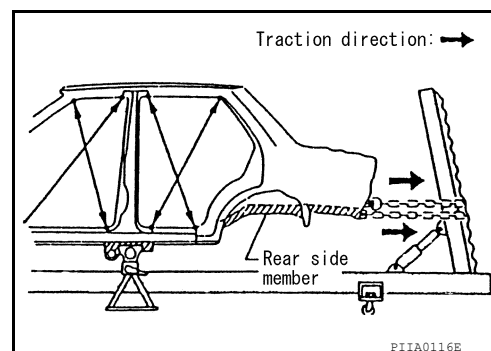
- The repair of reinforcements (such as side members) by heating is not recommended since it may weaken the component. When heating is unavoidable, do not heat HSS parts above 550°C (1,022°F).

Verify heating temperature with a thermometer.

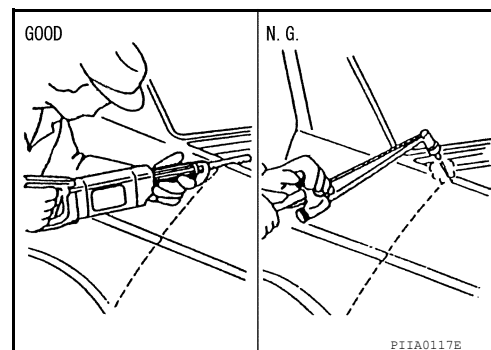
(Crayon-type and other similar type thermometer are appropriate.)



- When straightening body panels, use caution in pulling any HSS panel. Because HSS is very strong, pulling may cause deformation in adjacent portions of the body. In this case, increase the number of measuring points, and carefully pull the HSS panel.



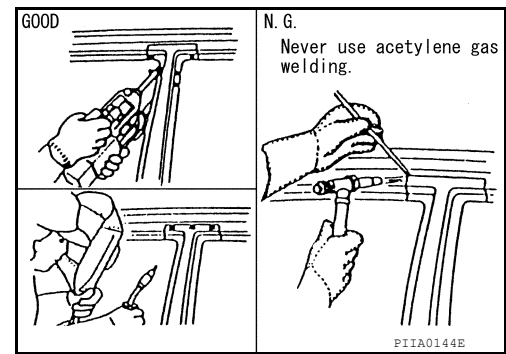
- When cutting HSS panels, avoid gas (torch) cutting if possible. Instead, use a saw to avoid weakening surrounding areas due to heat. If gas (torch) cutting is unavoidable, allow a minimum margin of 50 mm (1.97in).



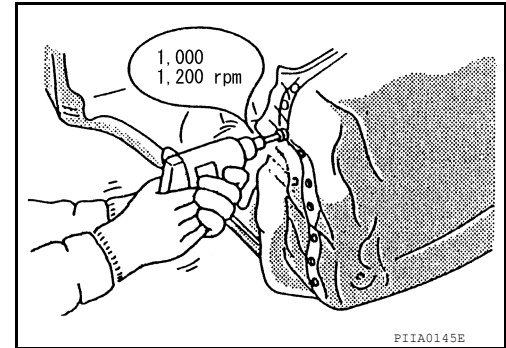
REPAIRING HIGH STRENGTH STEEL

< REMOVAL AND INSTALLATION >

- When welding HSS panels, use spot welding whenever possible in order to minimize weakening surrounding areas due to heat.
If spot welding is impossible, use M.I.G. welding. Do not use gas (torch) welding because it is inferior in welding strength.



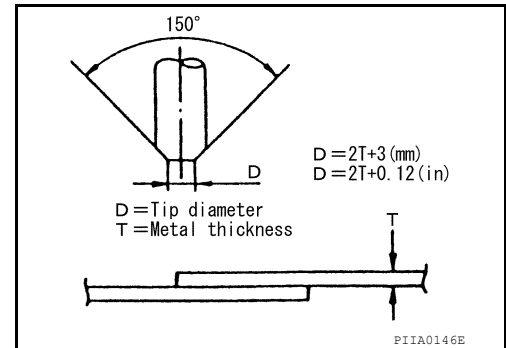
- The spot weld on HSS panels is harder than that of an ordinary steel panel.
Therefore, when cutting spot welds on a HSS panel, use a low speed high torque drill (1,000 to 1,200 rpm) to increase drill bit durability and facilitate the operation.
- SP150 HSS panels with a tensile strength of 785 to 981 N/mm² (80 to 100 kg/mm², 114 to 142 klb/sq in), used as reinforcement in the door guard beams, is too strong to repair. When these HSS parts are damaged, the outer panels also sustain substantial damage; therefore, the assembly parts must be replaced.



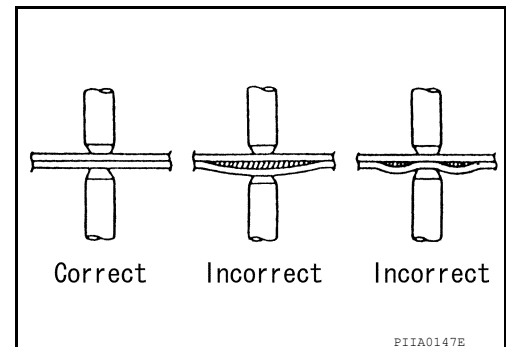
2. Precautions in spot welding HSS

This work should be performed under standard working conditions. Always note the following when spot welding HSS:

- The electrode tip diameter must be sized properly according to the metal thickness.



- The panel surfaces must fit flush to each other, leaving no gaps.



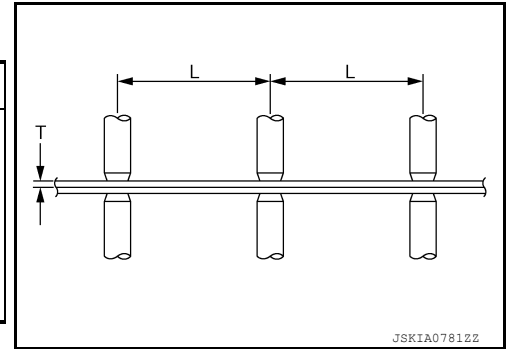
REPAIRING HIGH STRENGTH STEEL

< REMOVAL AND INSTALLATION >

- Follow the specifications for the proper welding pitch.

Unit: mm (in)

Thickness (T)	Minimum pitch (L)
0.6 (0.024)	10 (0.39) or over
0.8 (0.031)	12 (0.47) or over
1.0 (0.039)	18 (0.71) or over
1.2 (0.047)	20 (0.79) or over
1.6 (0.063)	27 (1.06) or over
1.8 (0.071)	31 (1.22) or over



REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

REPLACEMENT OPERATIONS

Replacement Operation

INFOID:000000008792165

DESCRIPTION

This section is prepared for technicians who have attained a high level of skill and experience in repairing collision-damaged vehicles and also use modern service tools and equipment. Persons unfamiliar with body repair techniques should not attempt to repair collision-damaged vehicles by using this section.

Technicians are also encouraged to read Body Repair Manual (Fundamentals) in order to ensure that the original functions and quality of the vehicle can be maintained. The Body Repair Manual (Fundamentals) contains additional information, including cautions and warnings, that are not including in this manual. Technicians should refer to both manuals to ensure proper repairs.

Please note that this information is prepared for worldwide usage, and as such, certain procedures may not apply in some regions or countries.

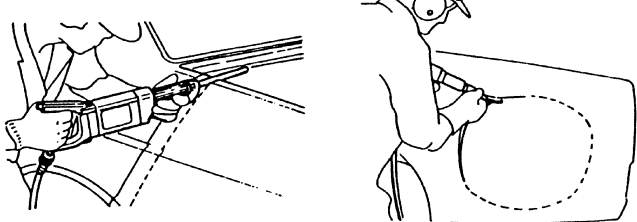
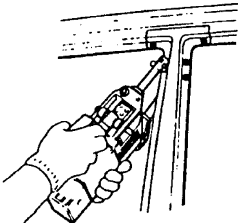
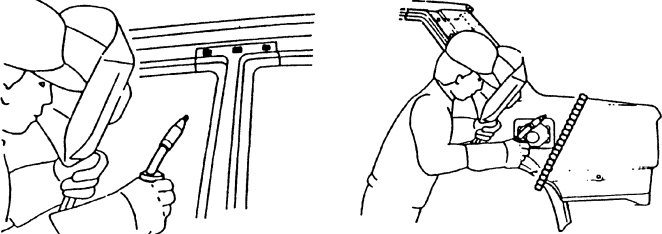
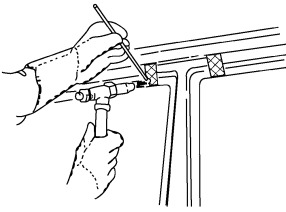
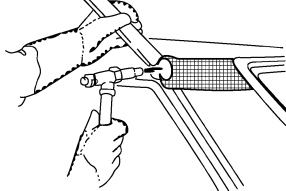
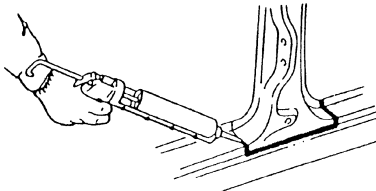
The symbols used in this section for cutting and welding / brazing operations are as shown.

A
B
C
D
E
F
G
H
I
J
L
M
N
O
P

BRM

REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

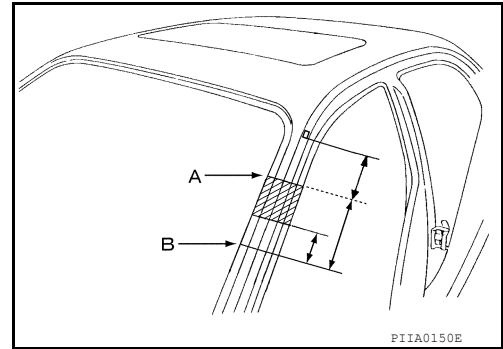
 Saw cut or air chisel cut			
Spot weld	 2-spot welds		
	 3-spot welds		
 MIG plug weld			
 MIG seam weld/ Point weld			
 Brazing			
 Soldering			
 Sealing			

PIIA0149E

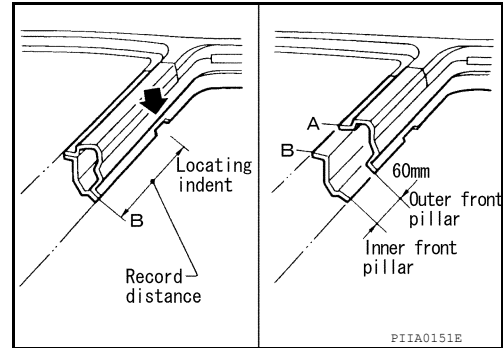
REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

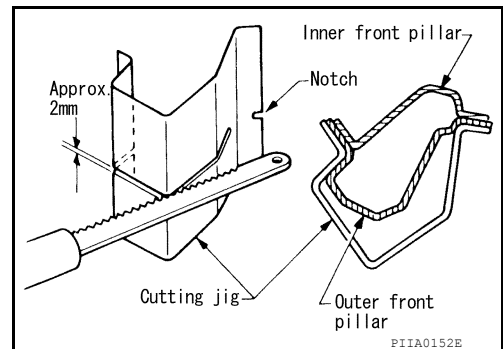
- Front pillar butt joint can be determined anywhere within shaded area as shown in the figure. The best location for the butt joint is at position A due to the construction of the vehicle. Refer to the front pillar section.



- Determine cutting position and record distance from the locating indent. Use this distance when cutting the service part. Cut outer front pillar over 60 mm above inner front pillar cut position.

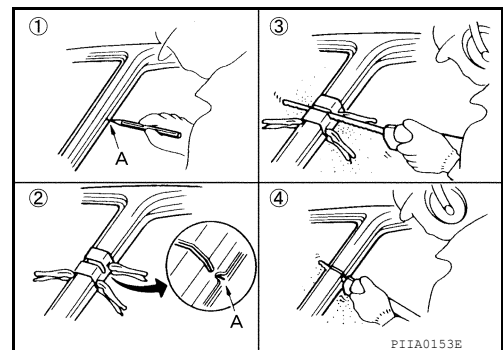


- Prepare a cutting jig to make outer pillar easier to cut. Also, this will permit service part to be accurately cut at joint position.



- An example of cutting operation using a cutting jig is as follows.

- Mark cutting lines.
A: Cut position of outer pillar
B: Cut position of inner pillar
- Align cutting line with notch on jig. Clamp jig to pillar.
- Cut outer pillar along groove of jig. (At position A)
- Remove jig and cut remaining portions.
- Cut inner pillar at position B in same manner.



HOODLEDGE

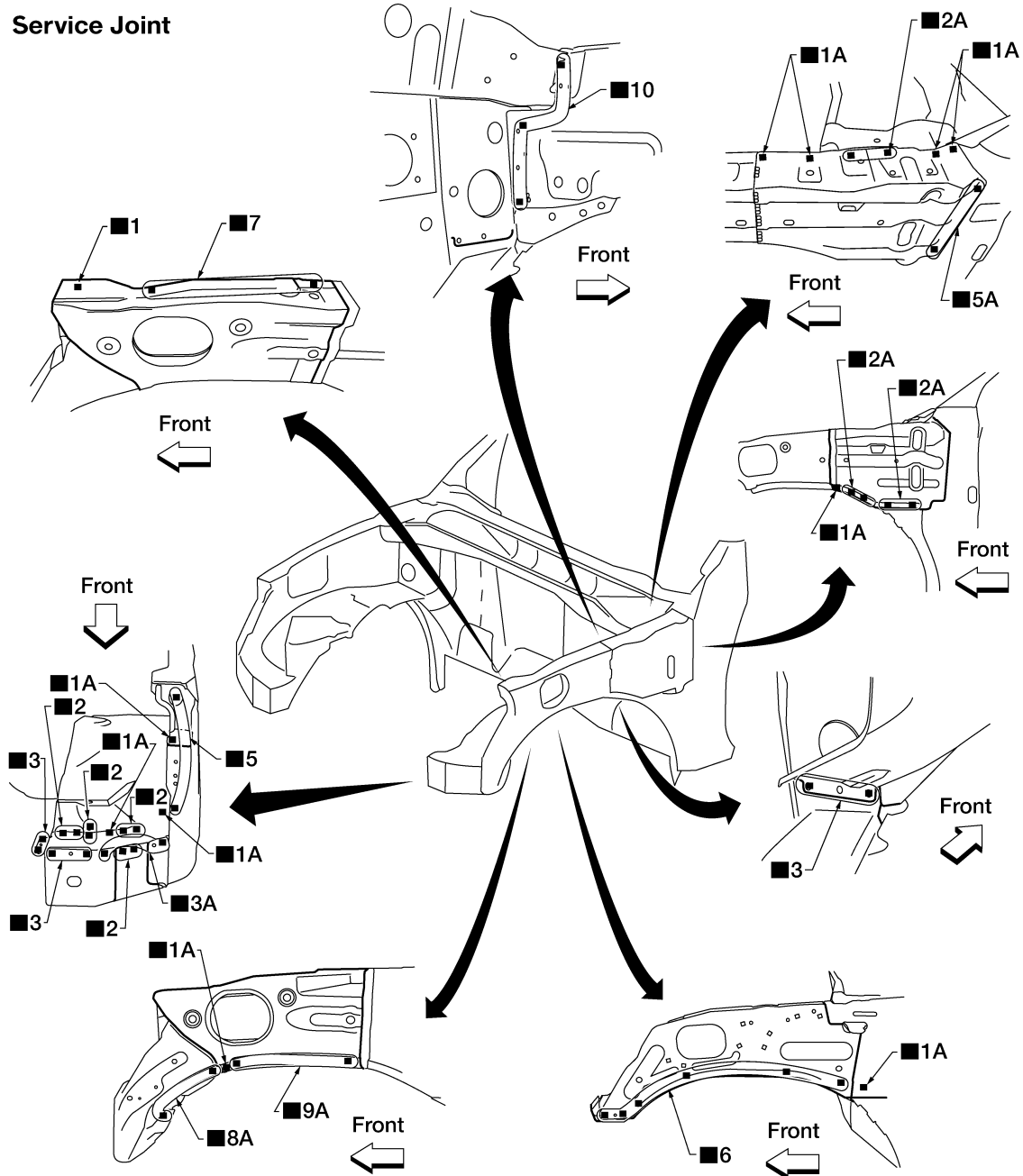
LH Side

REPLACEMENT OPERATIONS

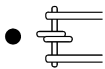
< REMOVAL AND INSTALLATION >

- Work after radiator core support has been removed.

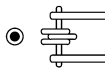
Service Joint



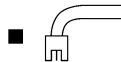
2-spot welds



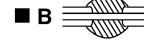
3-spot welds



MIG Plug weld



For 3 panels plug weld method



MIG seam weld/
Point weld



AWKIA1456GB

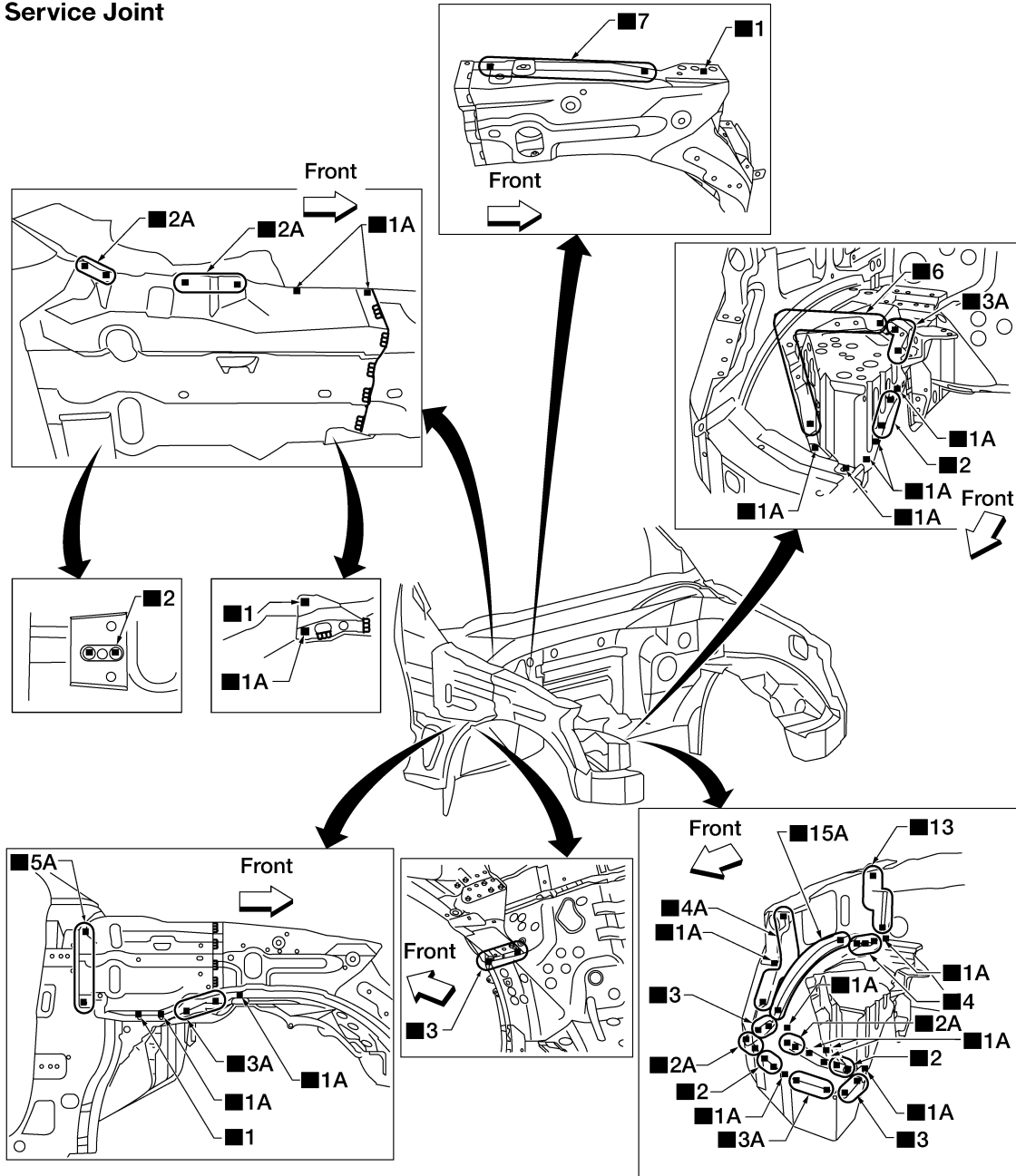
RH Side

REPLACEMENT OPERATIONS

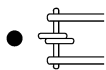
< REMOVAL AND INSTALLATION >

- Work after radiator core support has been removed.

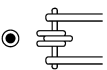
Service Joint



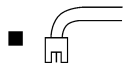
2-spot welds



3-spot welds



MIG Plug weld



For 3 panels plug weld method



MIG seam weld/
Point weld



AWKIA1457GB

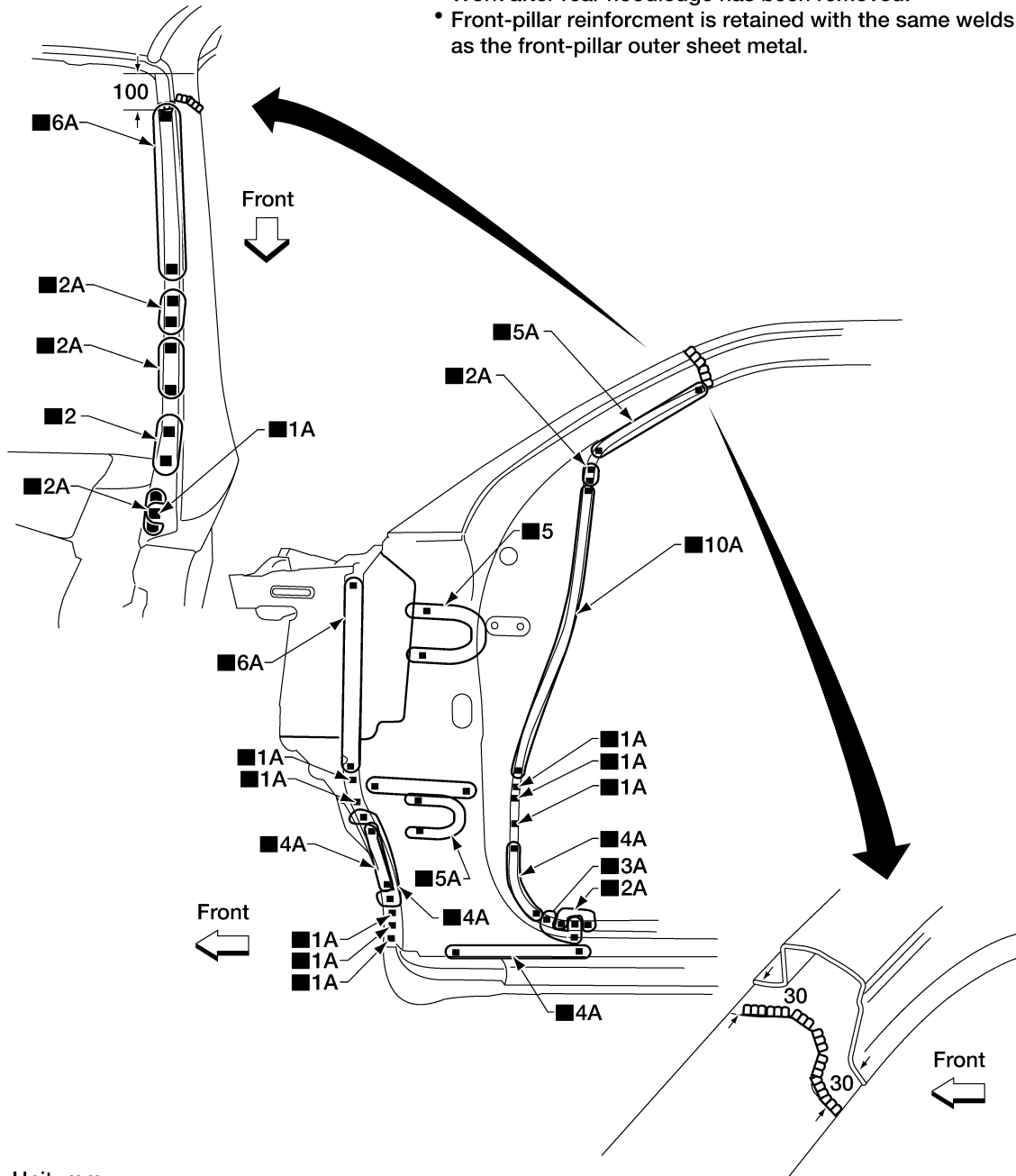
REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

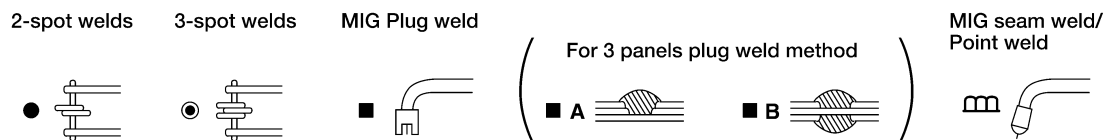
FRONT PILLAR

Service Joint

- Work after rear hoodledge has been removed.
- Front-pillar reinforcement is retained with the same welds as the front-pillar outer sheet metal.



Unit: mm



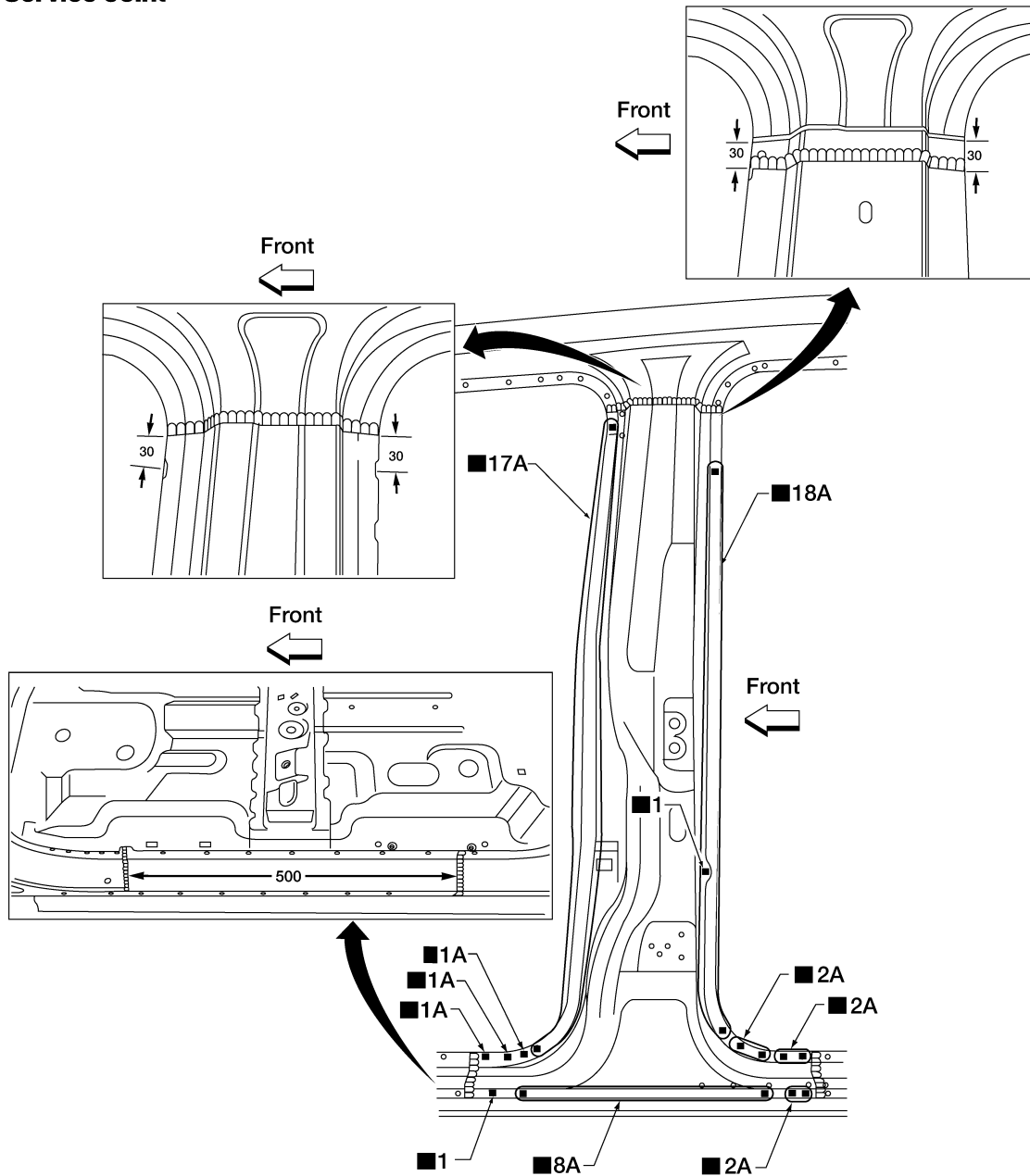
AWKIA1458GB

REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

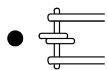
CENTER PILLAR (CREW CAB ONLY)

Service Joint

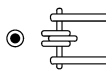


Unit: mm

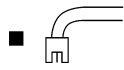
2-spot welds



3-spot welds



MIG Plug weld



For 3 panels plug weld method



MIG seam weld/
Point weld



AWKIA1459GB

OUTER SILL

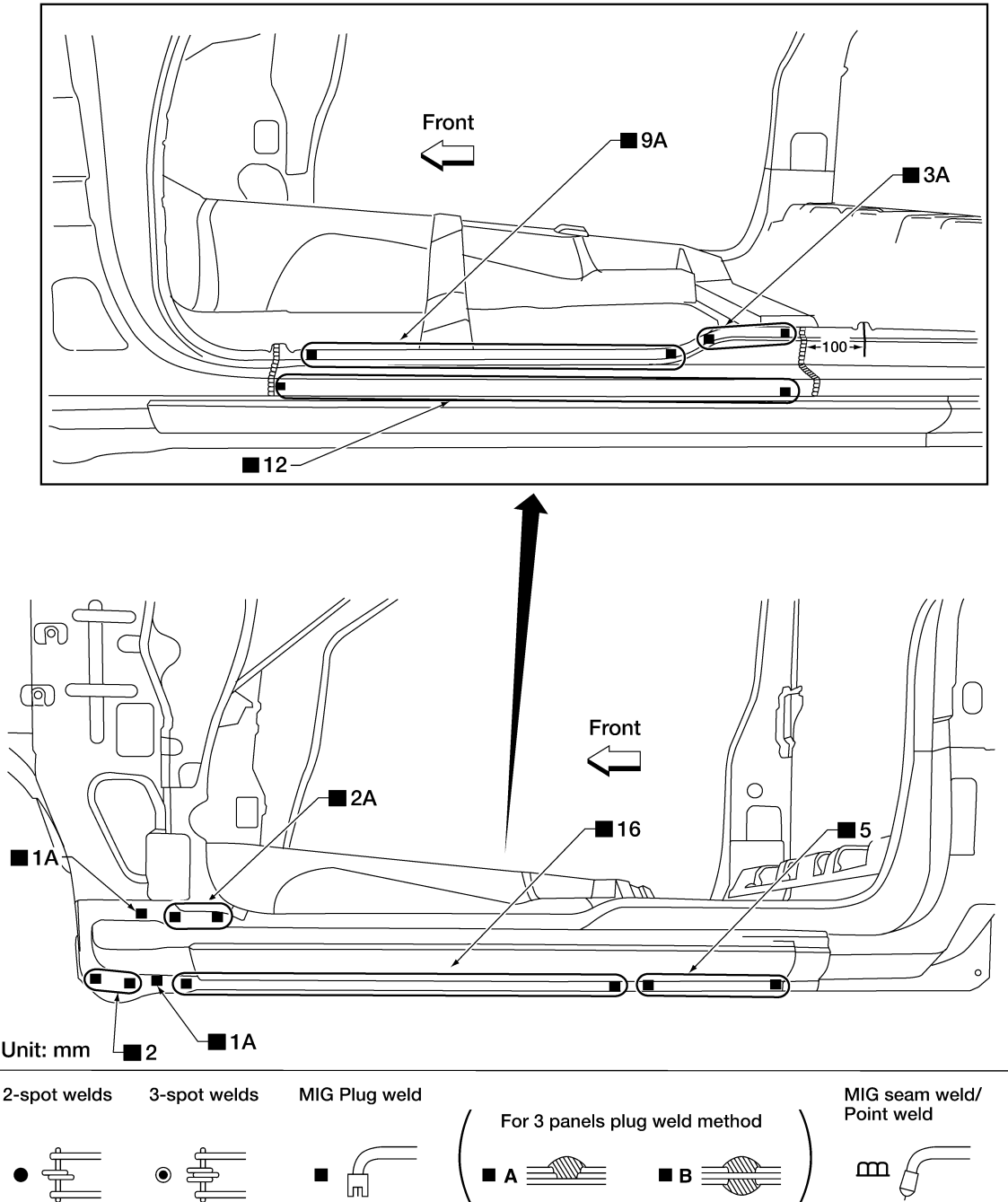
King Cab

REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

Work with front pillar outer, front pillar reinforcement, and rear pillar outer removed.

Service Joint



AWKIA1460GB

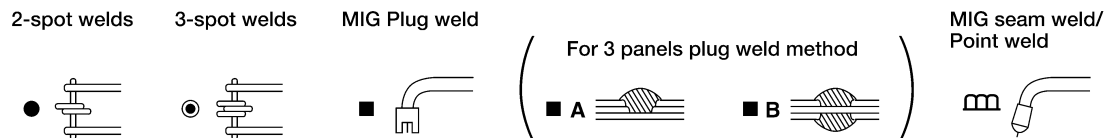
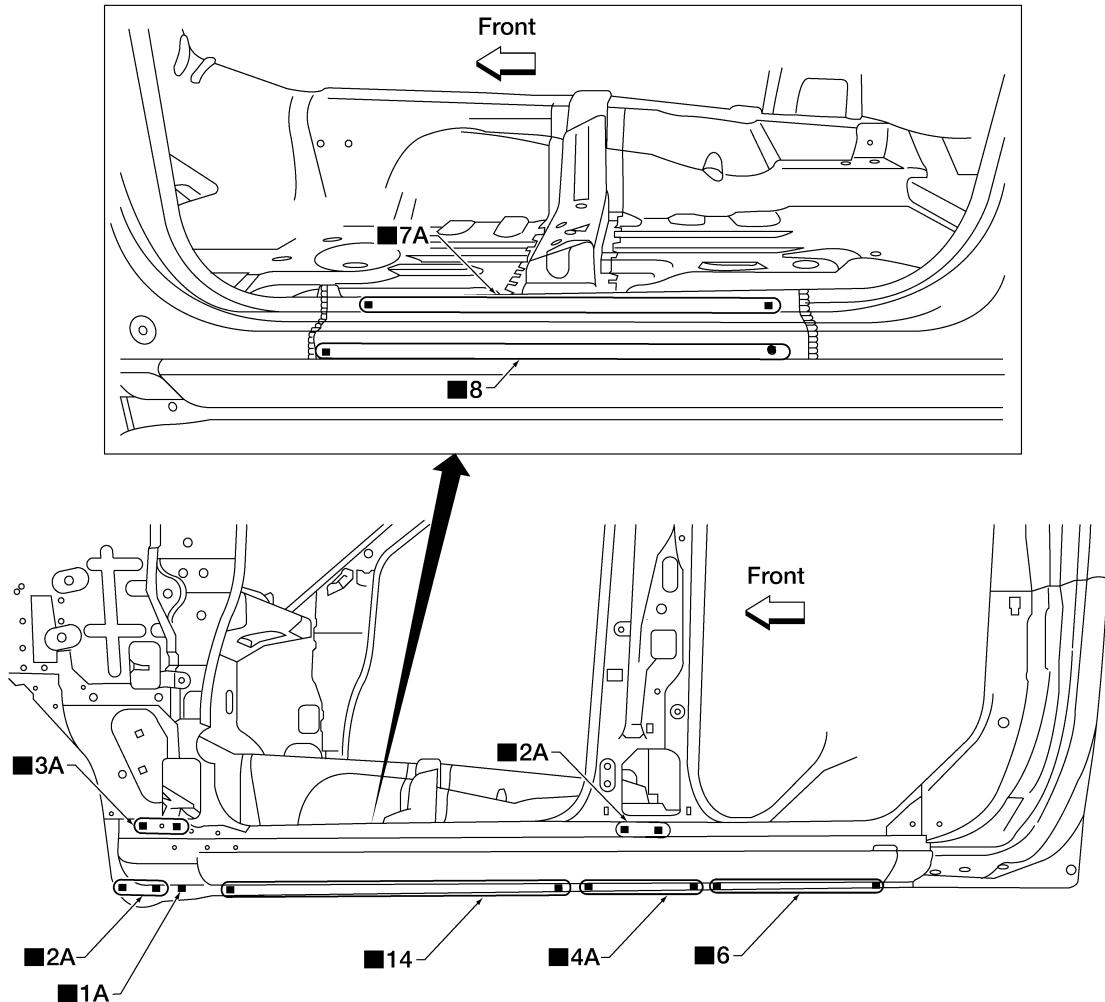
Crew Cab

REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

Work with front pillar outer, front pillar reinforcement, center pillar outer, center pillar reinforcement, and rear pillar outer removed.

Service Joint



AWKIA1461GB

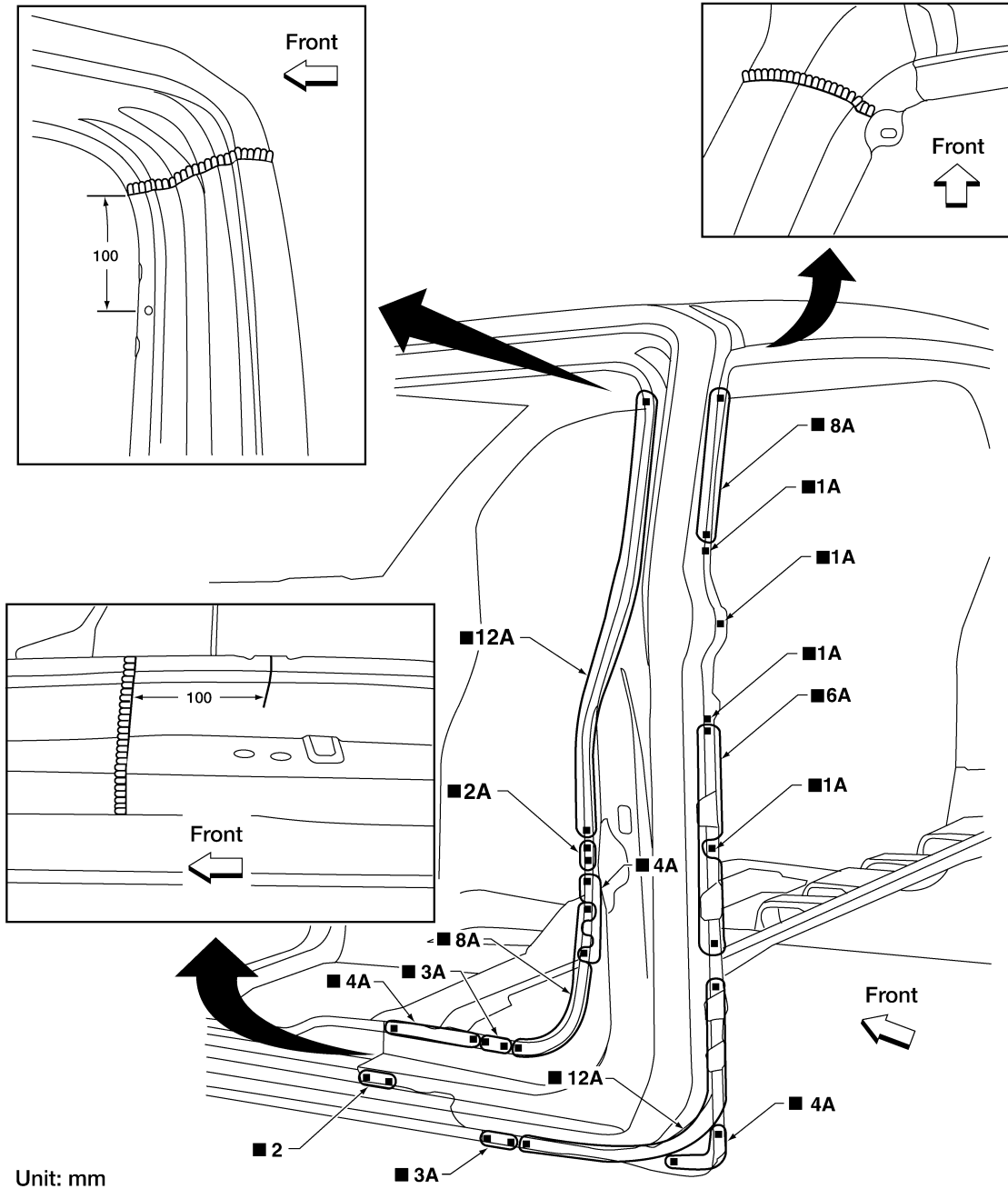
REAR CAB PILLAR

REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

King Cab

Service Joint



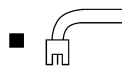
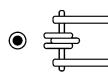
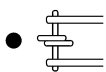
2-spot welds

3-spot welds

MIG Plug weld

For 3 panels plug weld method

MIG seam weld/
Point weld

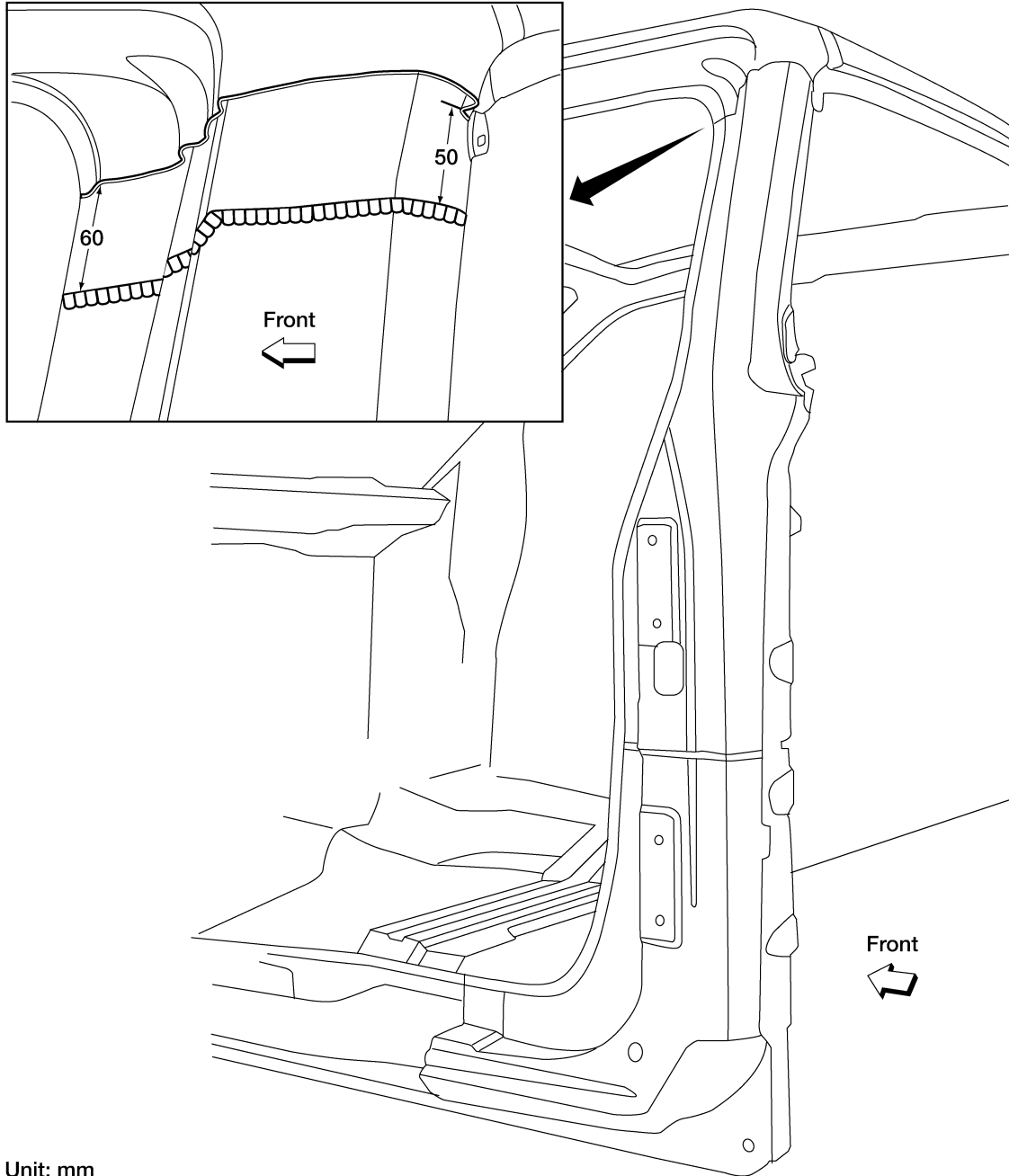


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REPLACEMENT OPERATIONS

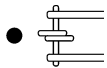
< REMOVAL AND INSTALLATION >

Service Joint

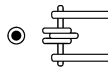


Unit: mm

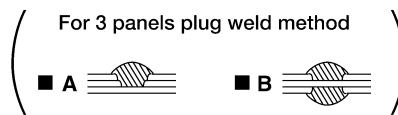
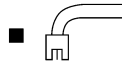
2-spot welds



3-spot welds



MIG Plug weld



MIG seam weld/
Point weld



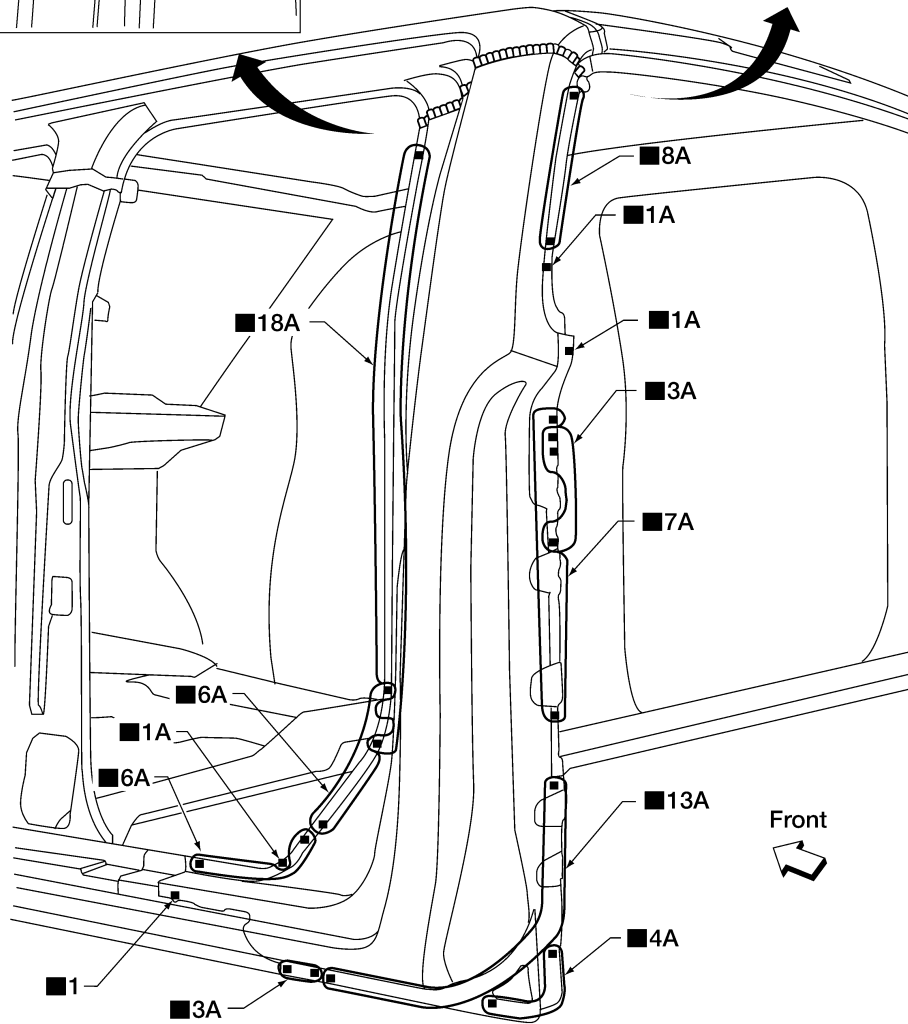
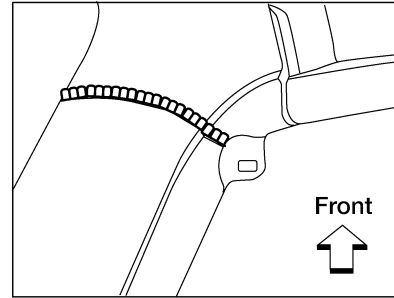
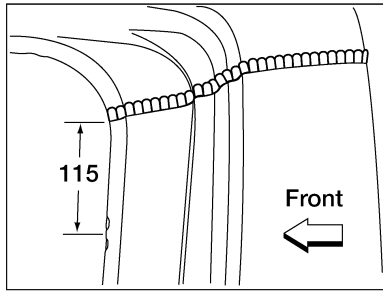
AWKIA1463GB

REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

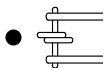
Crew Cab

Service Joint



Unit: mm

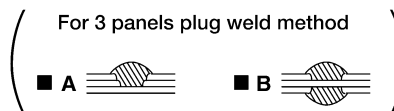
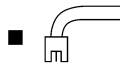
2-spot welds



3-spot welds



MIG Plug weld



MIG seam weld/
Point weld

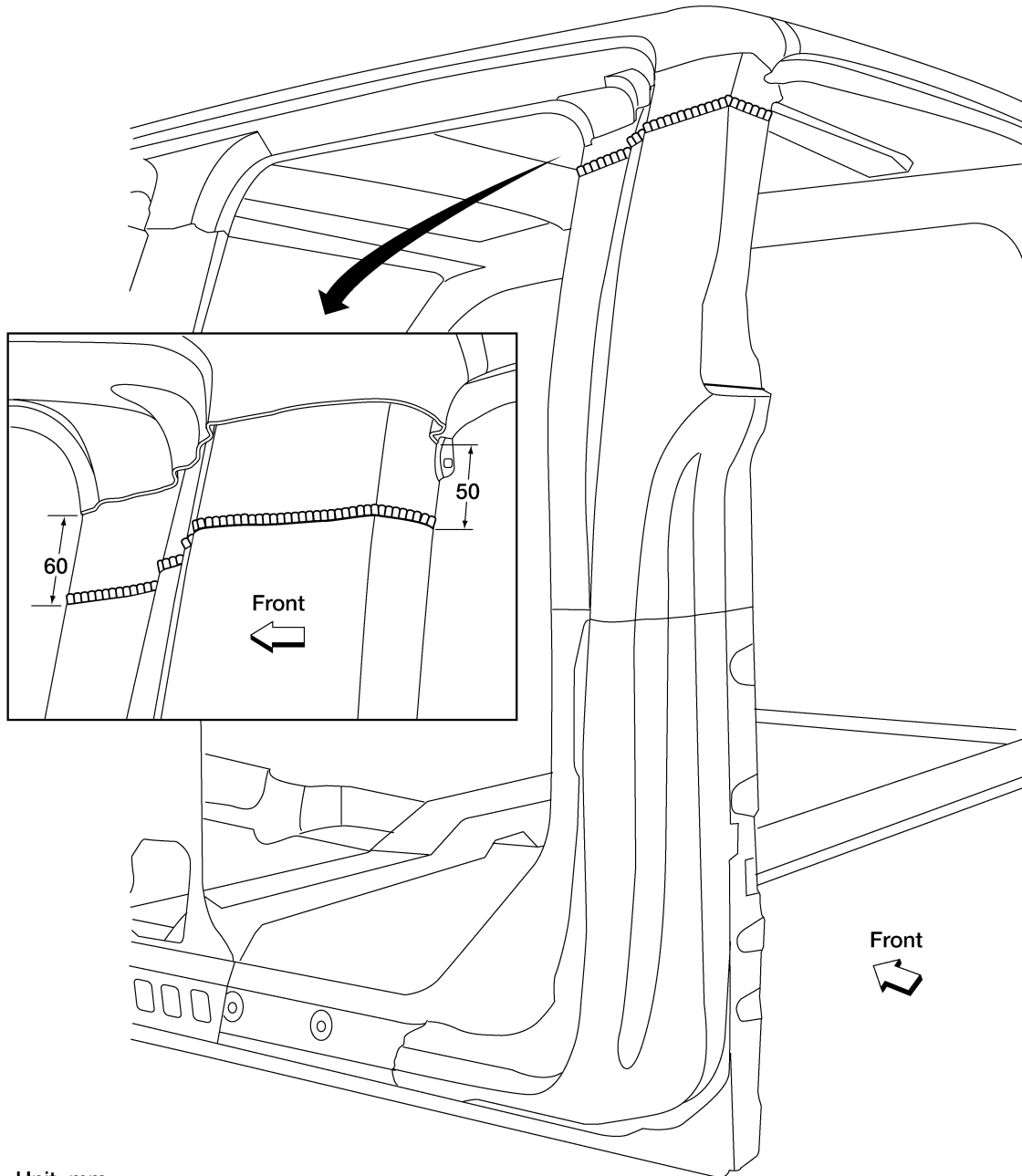


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REPLACEMENT OPERATIONS

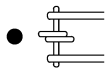
< REMOVAL AND INSTALLATION >

Service Joint

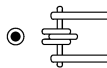


Unit: mm

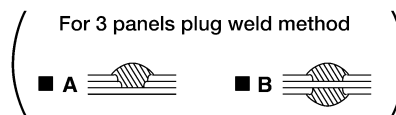
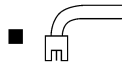
2-spot welds



3-spot welds



MIG Plug weld



MIG seam weld/
Point weld



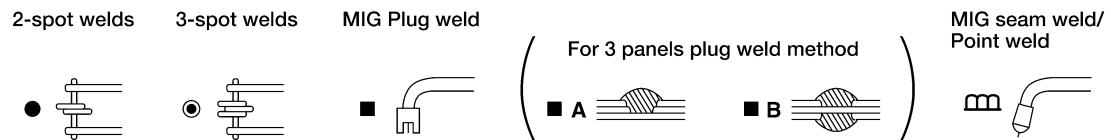
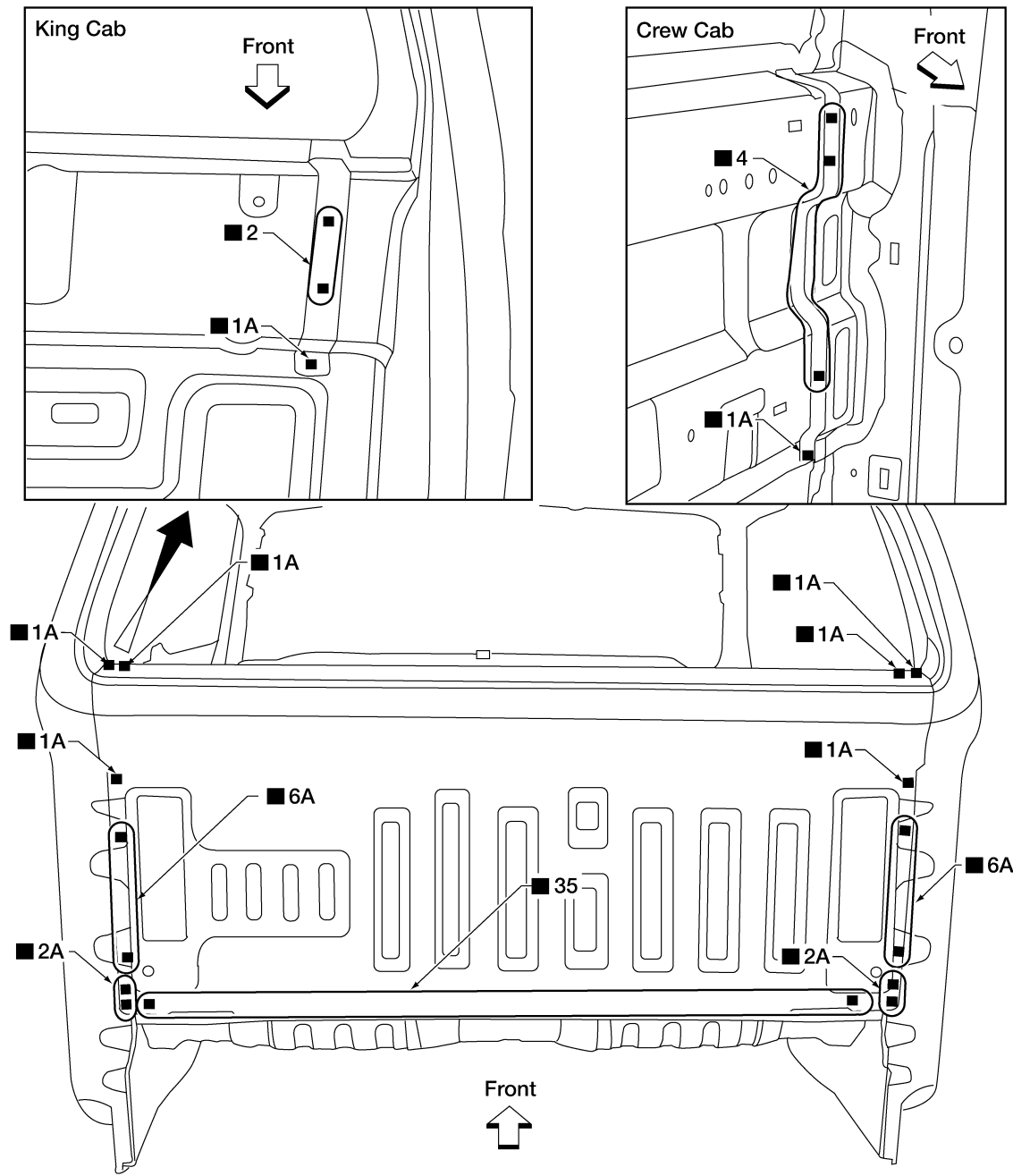
AWKIA1465GB

REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

REAR PANEL

Service Joint



AWKIA1466GB

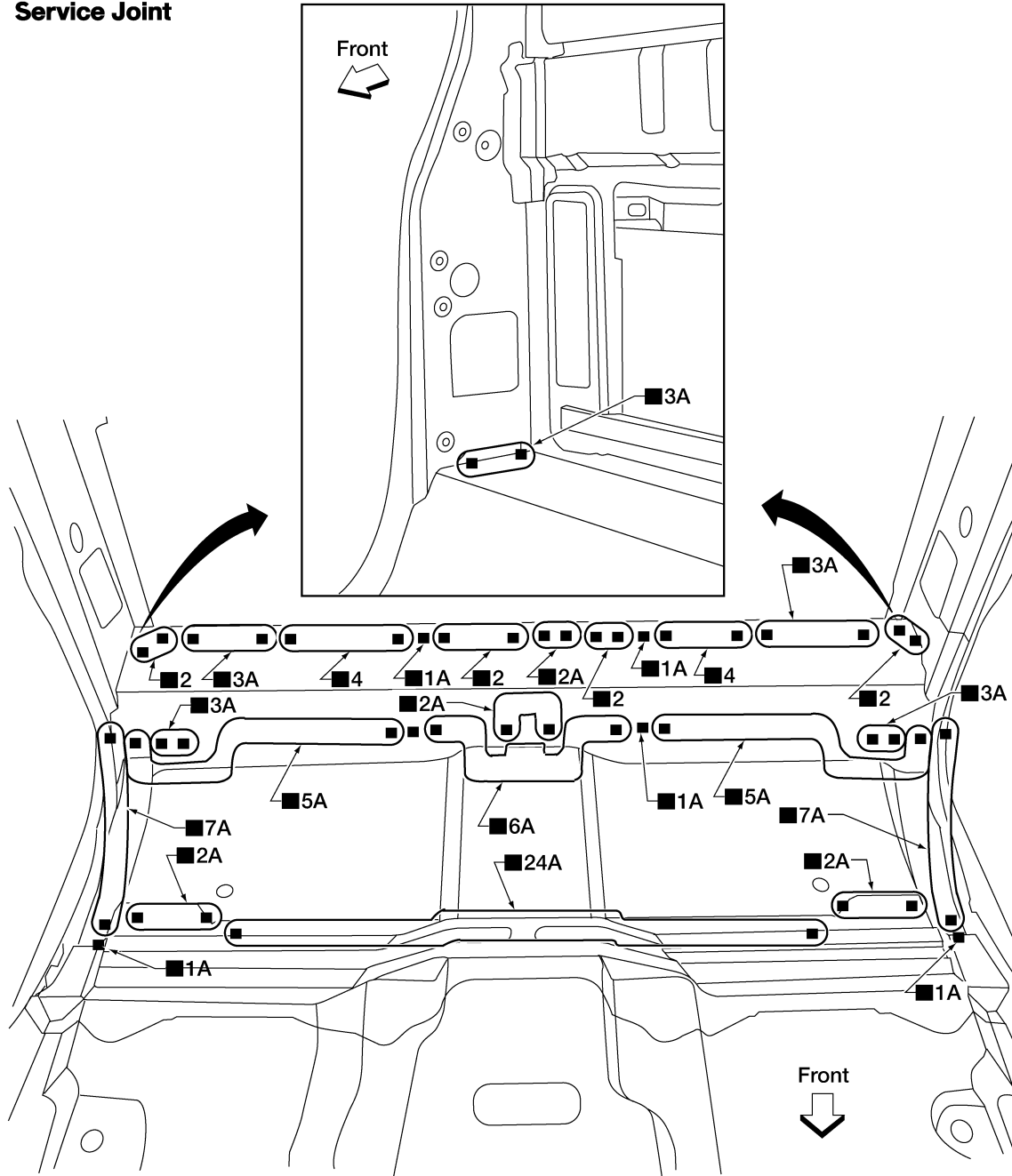
REAR FLOOR REAR

REPLACEMENT OPERATIONS

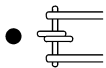
< REMOVAL AND INSTALLATION >

King Cab

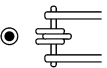
Service Joint



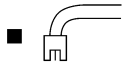
2-spot welds



3-spot welds



MIG Plug weld



For 3 panels plug weld method

■ A ■ B

MIG seam weld/
Point weld



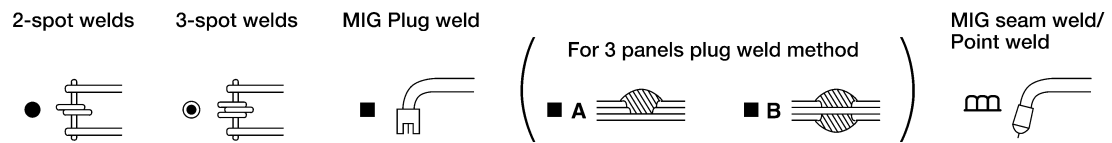
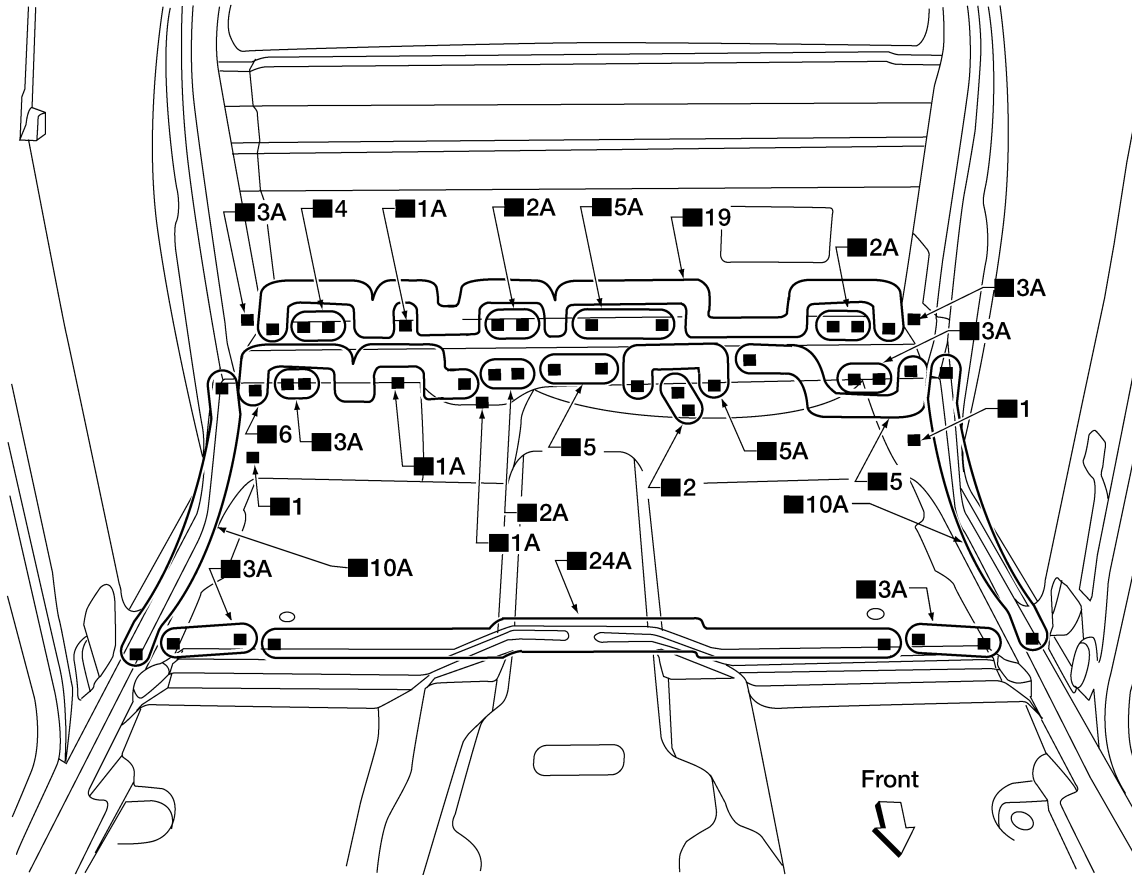
ANKIA1467GB

REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

Crew Cab

Service Joint



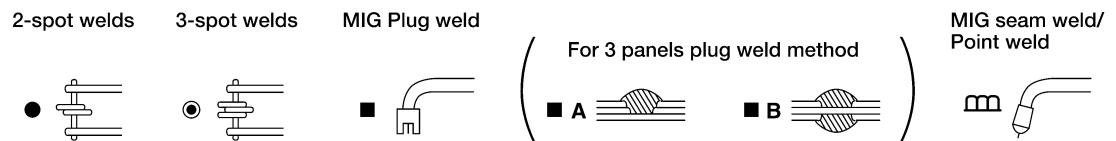
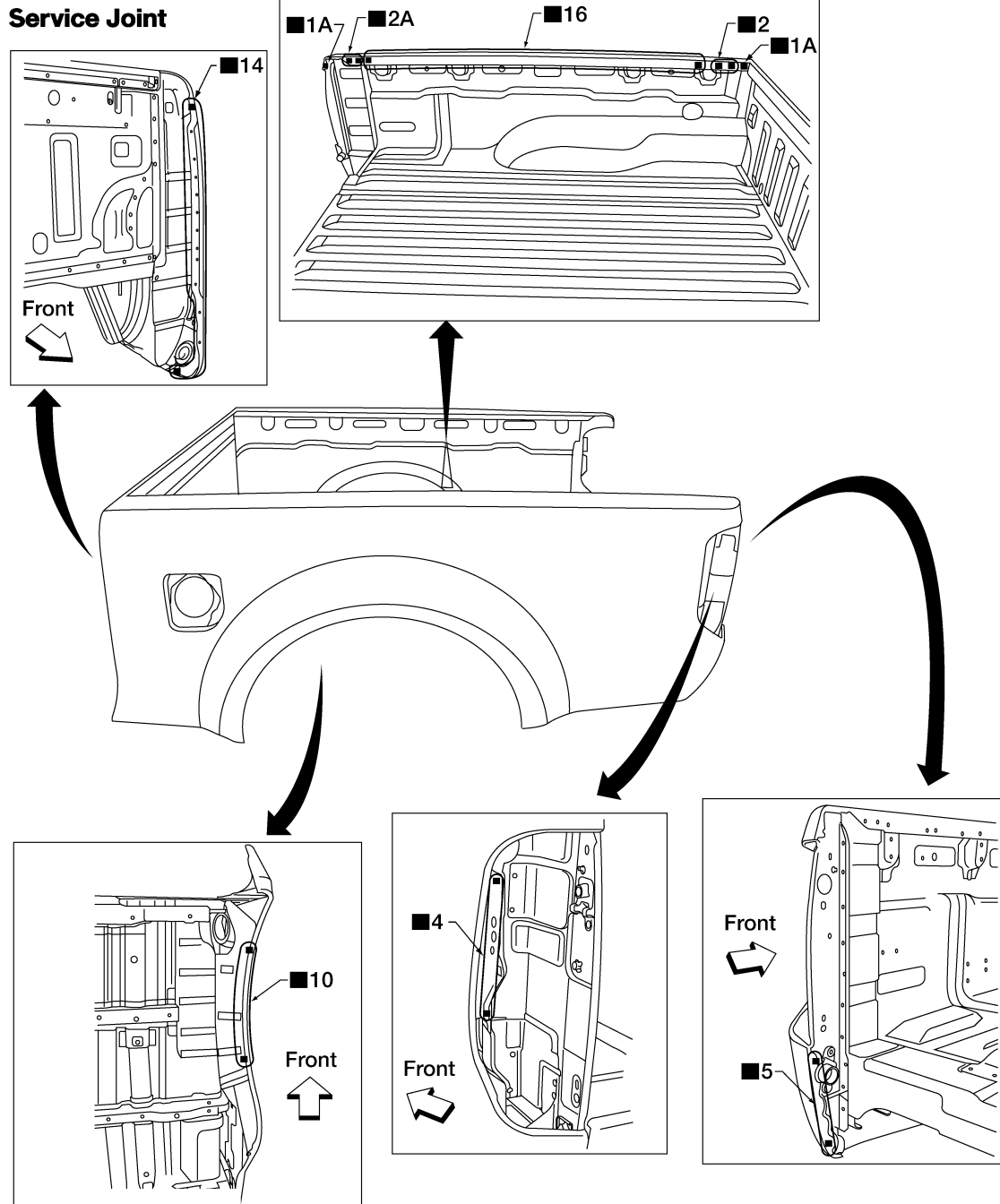
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PICKUP BED

REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

King Cab



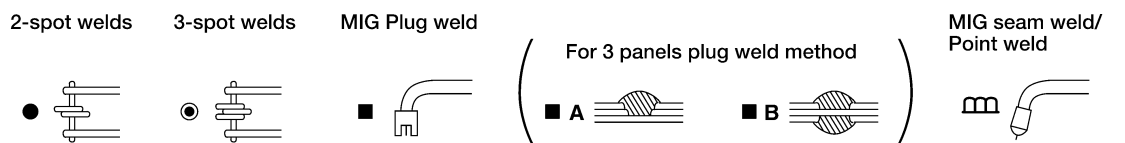
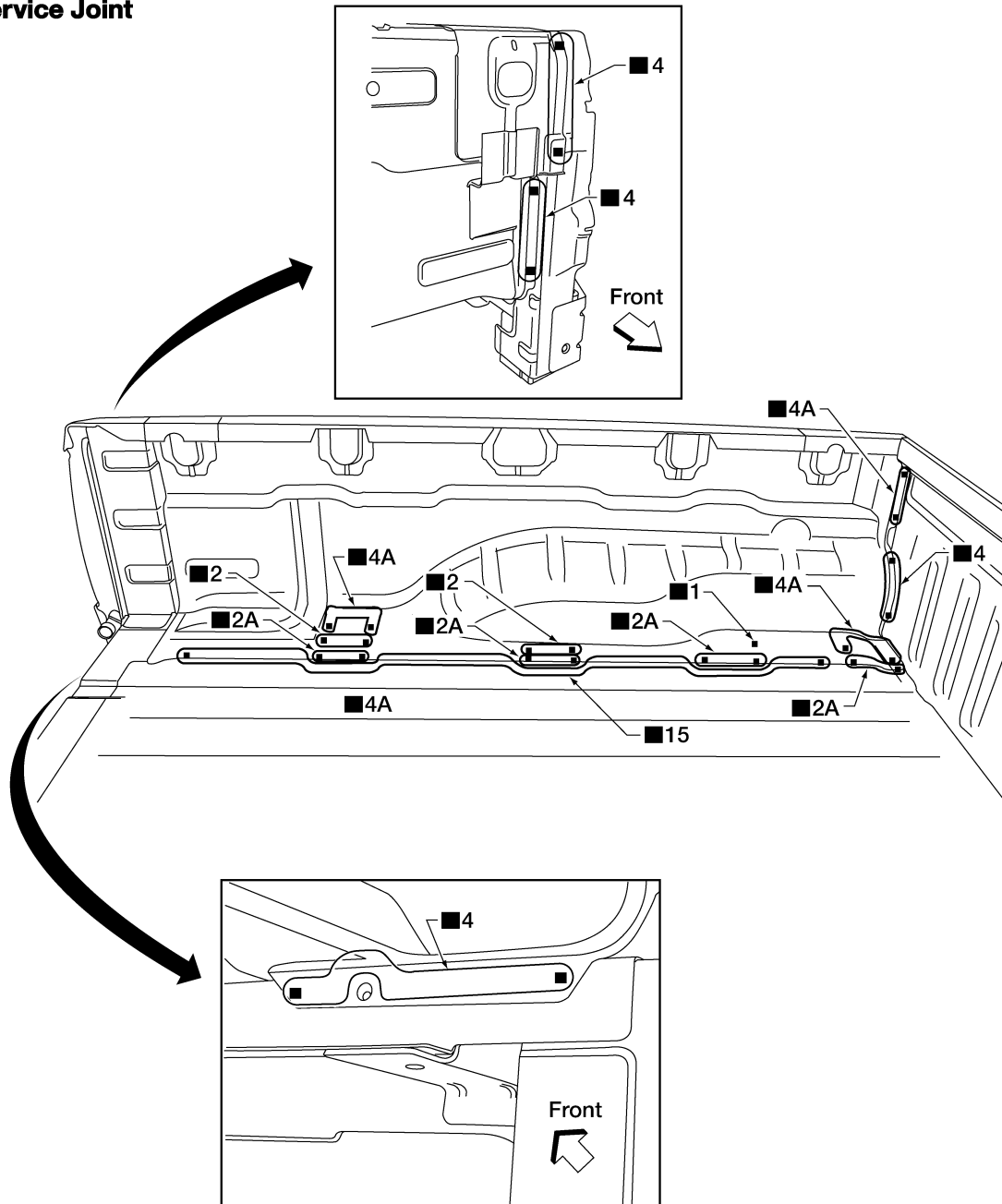
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REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

Service Joint

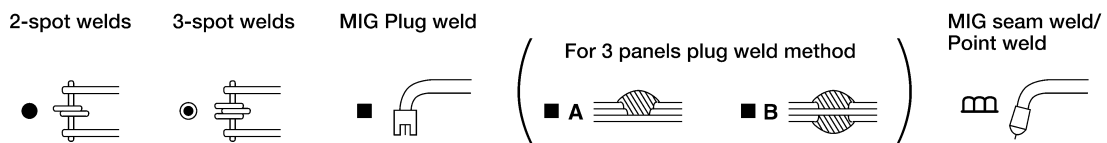
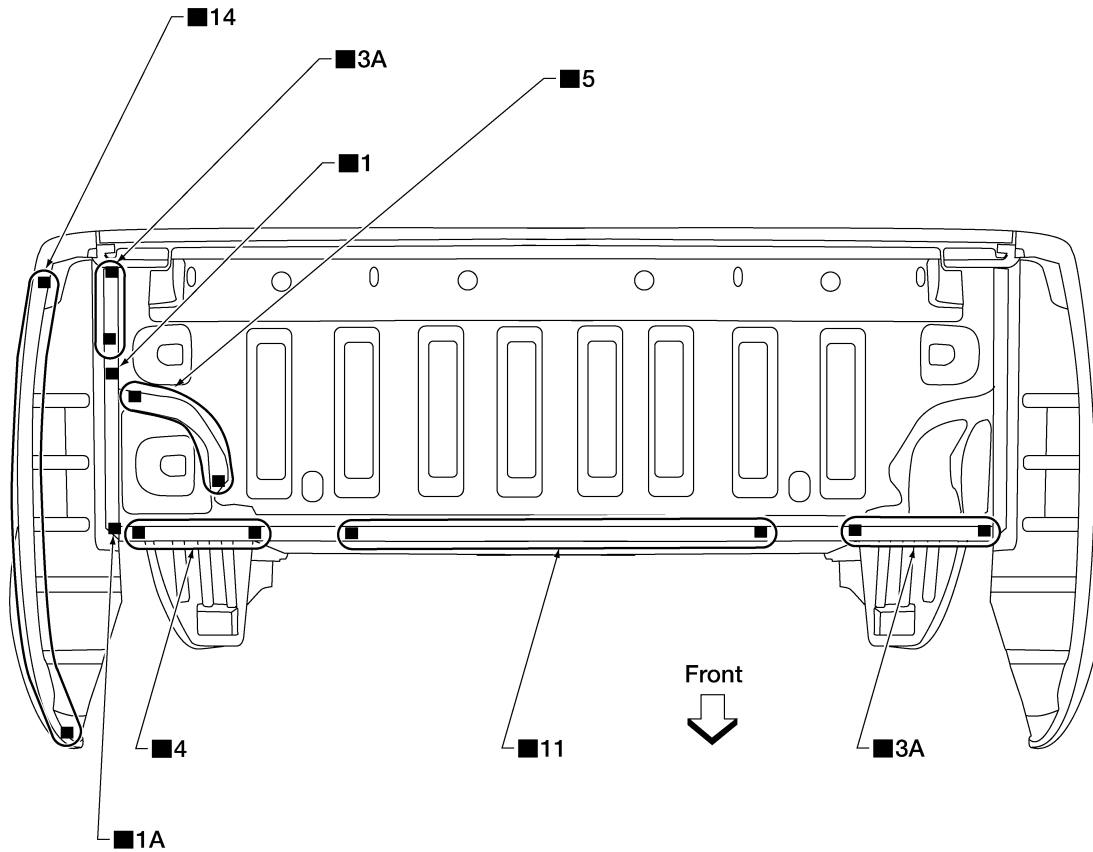


AWKIA1470GB

REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

Service Joint

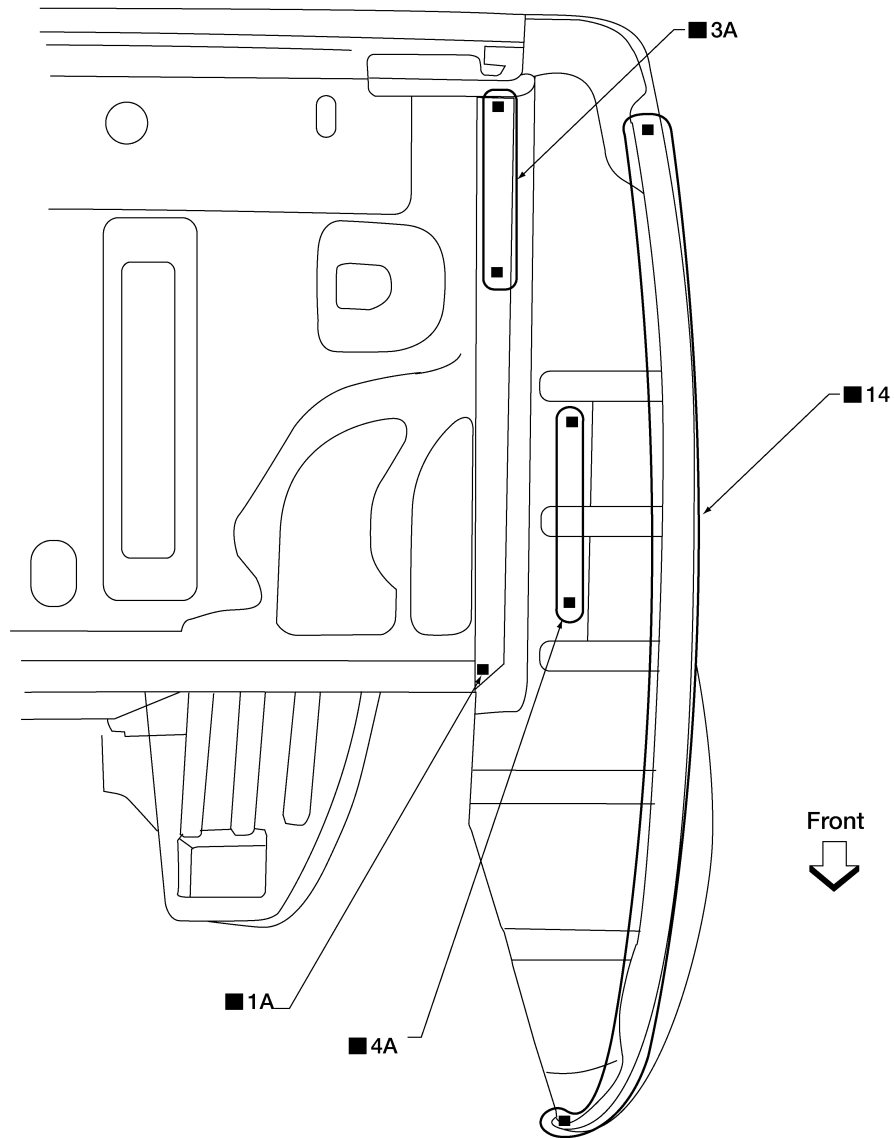


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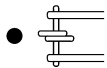
REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

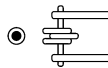
Service Joint



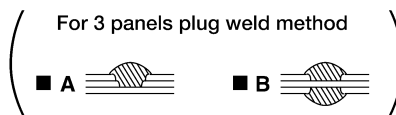
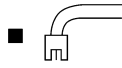
2-spot welds



3-spot welds



MIG Plug weld



MIG seam weld/
Point weld

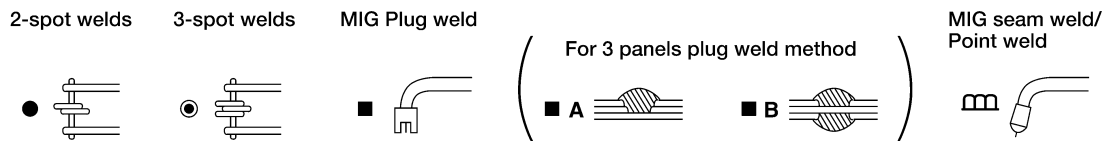
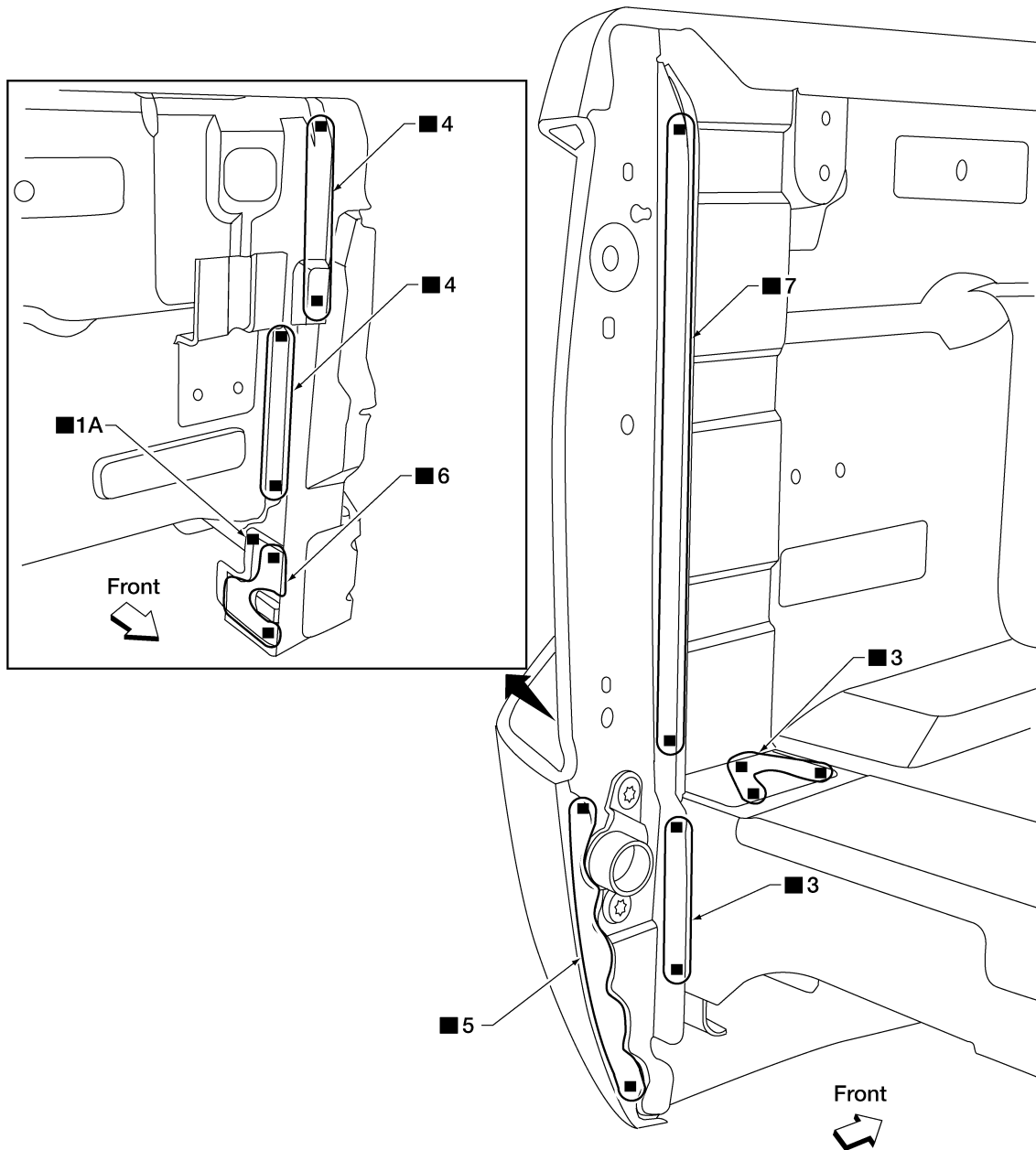


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REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

Service Joint

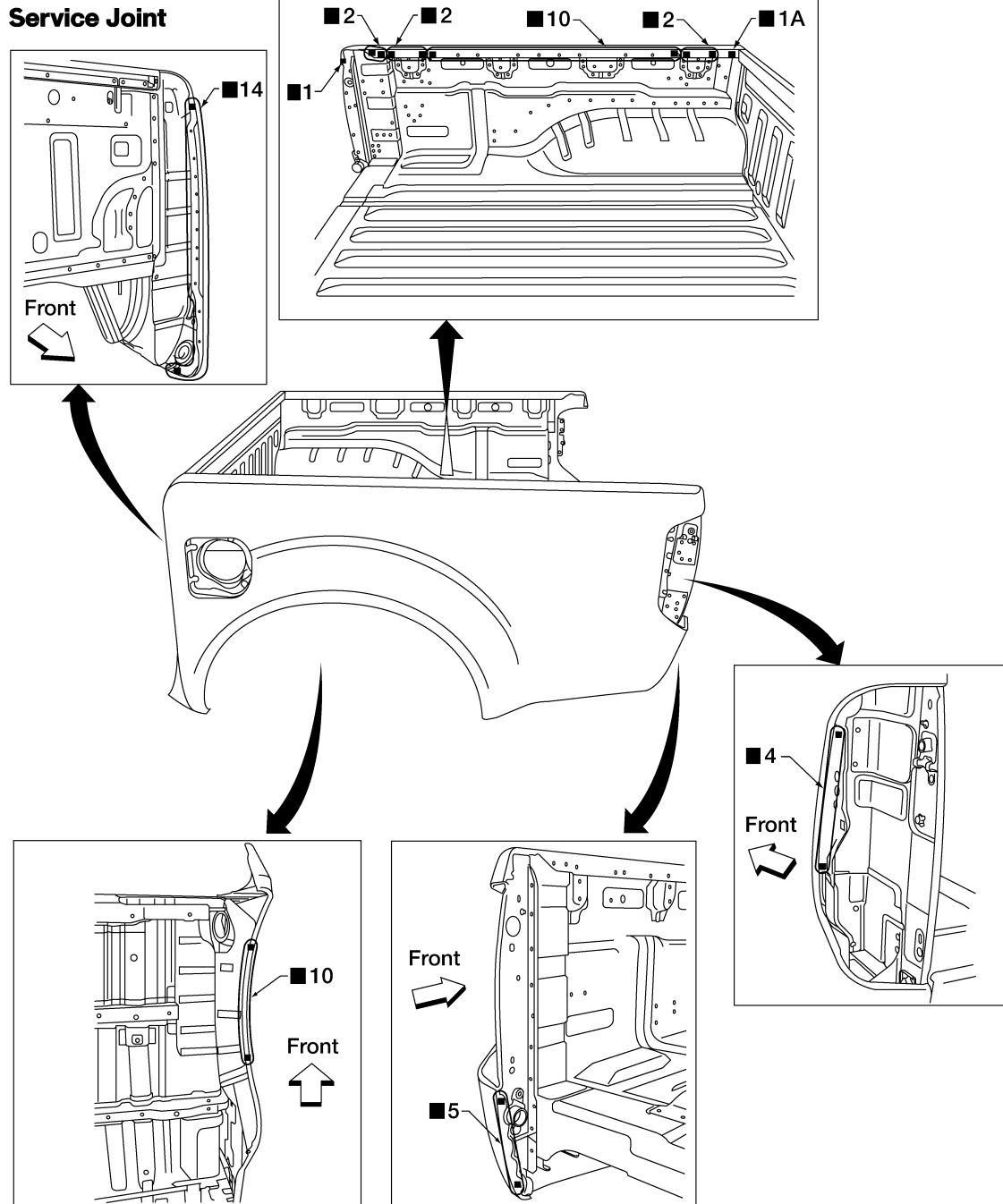


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REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

Crew Cab



2-spot welds

3-spot welds

MIG Plug weld

(For 3 panels plug weld method)

MIG seam weld/
Point weld

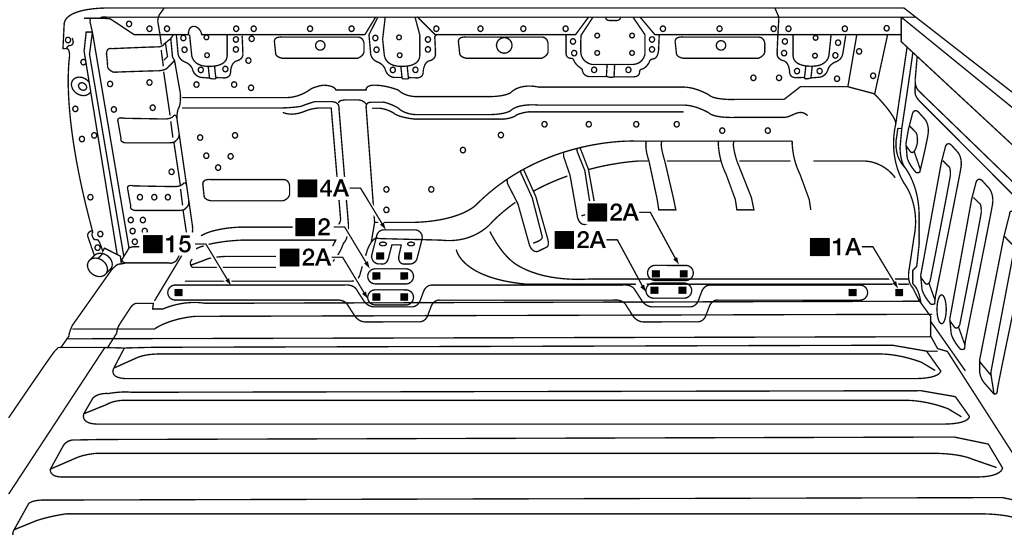


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REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

Service Joint



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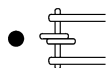
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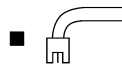
2-spot welds



3-spot welds



MIG Plug weld



For 3 panels plug weld method

■ A ■ B

MIG seam weld/
Point weld



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N

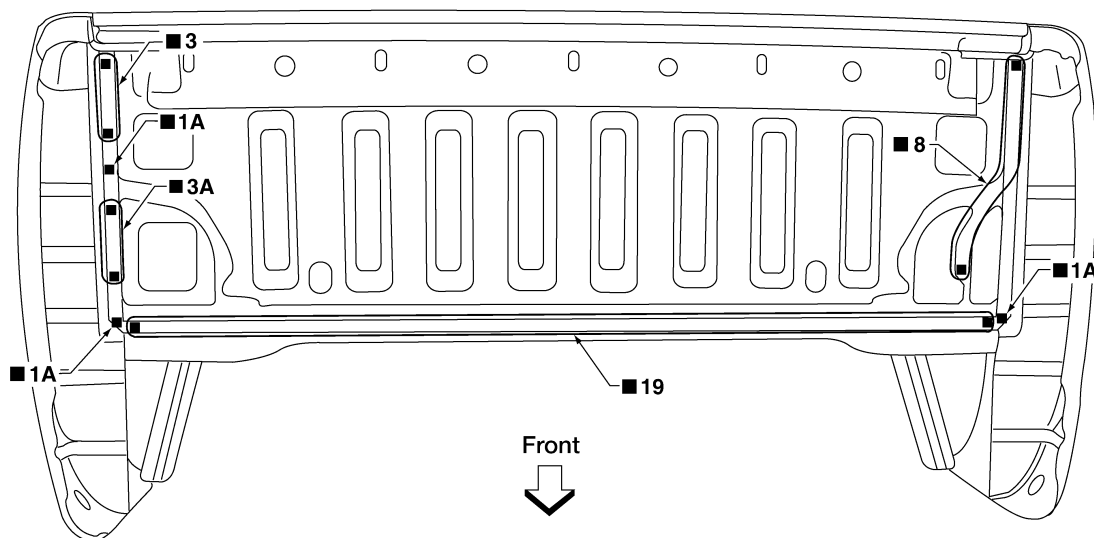
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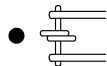
REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

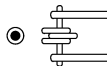
Service Joint



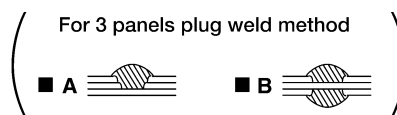
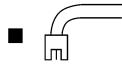
2-spot welds



3-spot welds



MIG Plug weld



MIG seam weld/
Point weld

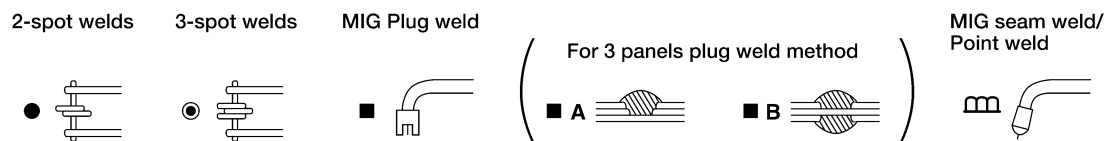
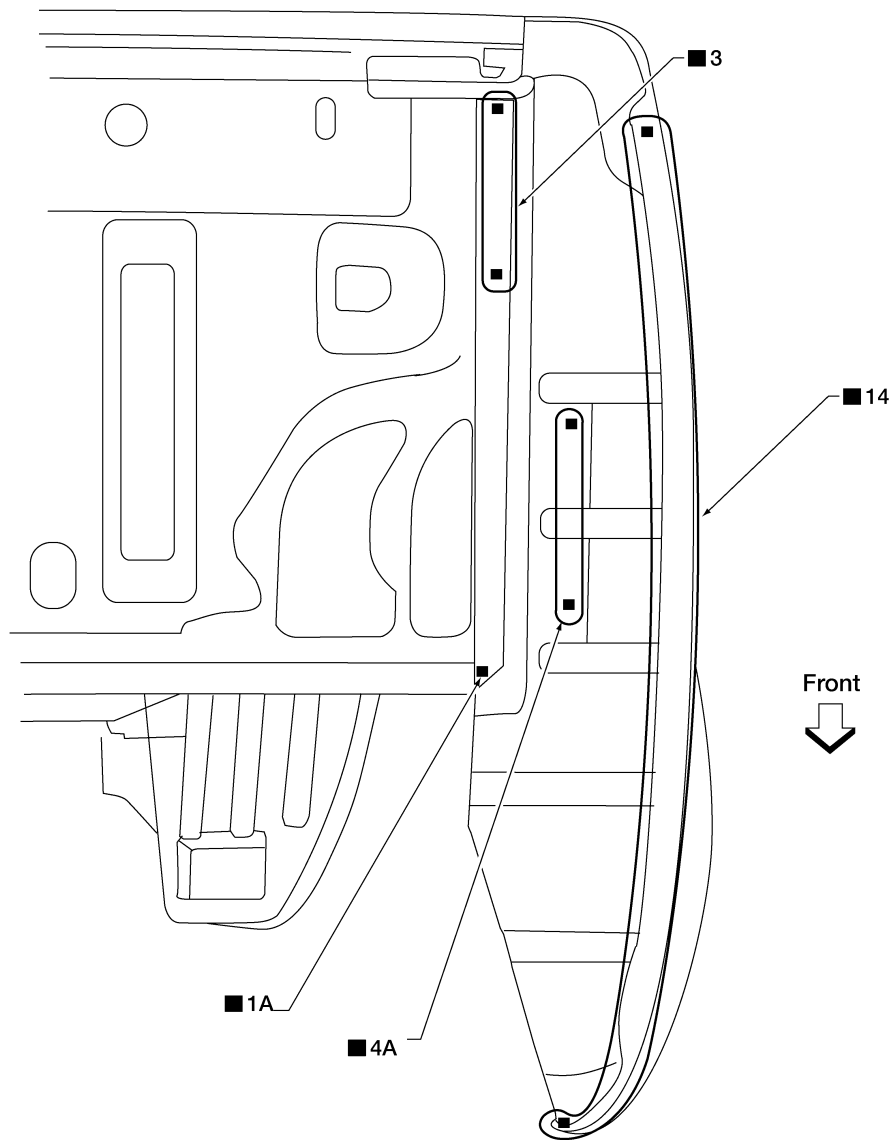


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REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

Service Joint

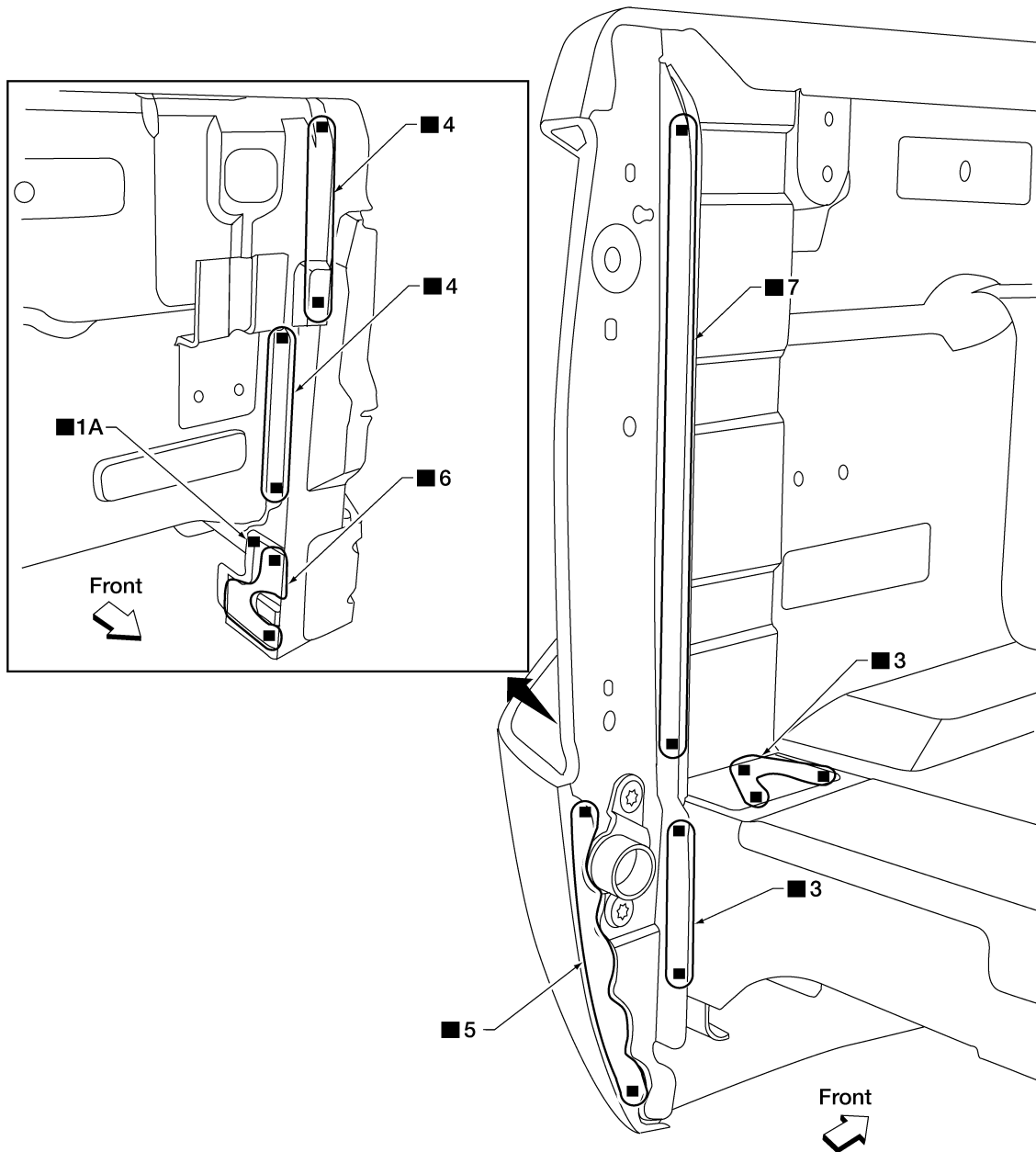


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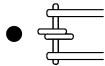
REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

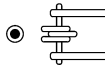
Service Joint



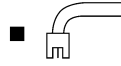
2-spot welds



3-spot welds



MIG Plug weld



For 3 panels plug weld method
 (■ A ■ B)

MIG seam weld/
Point weld



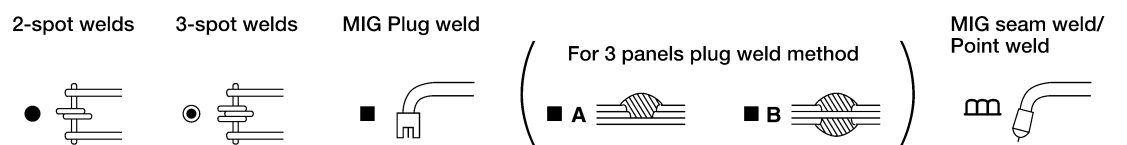
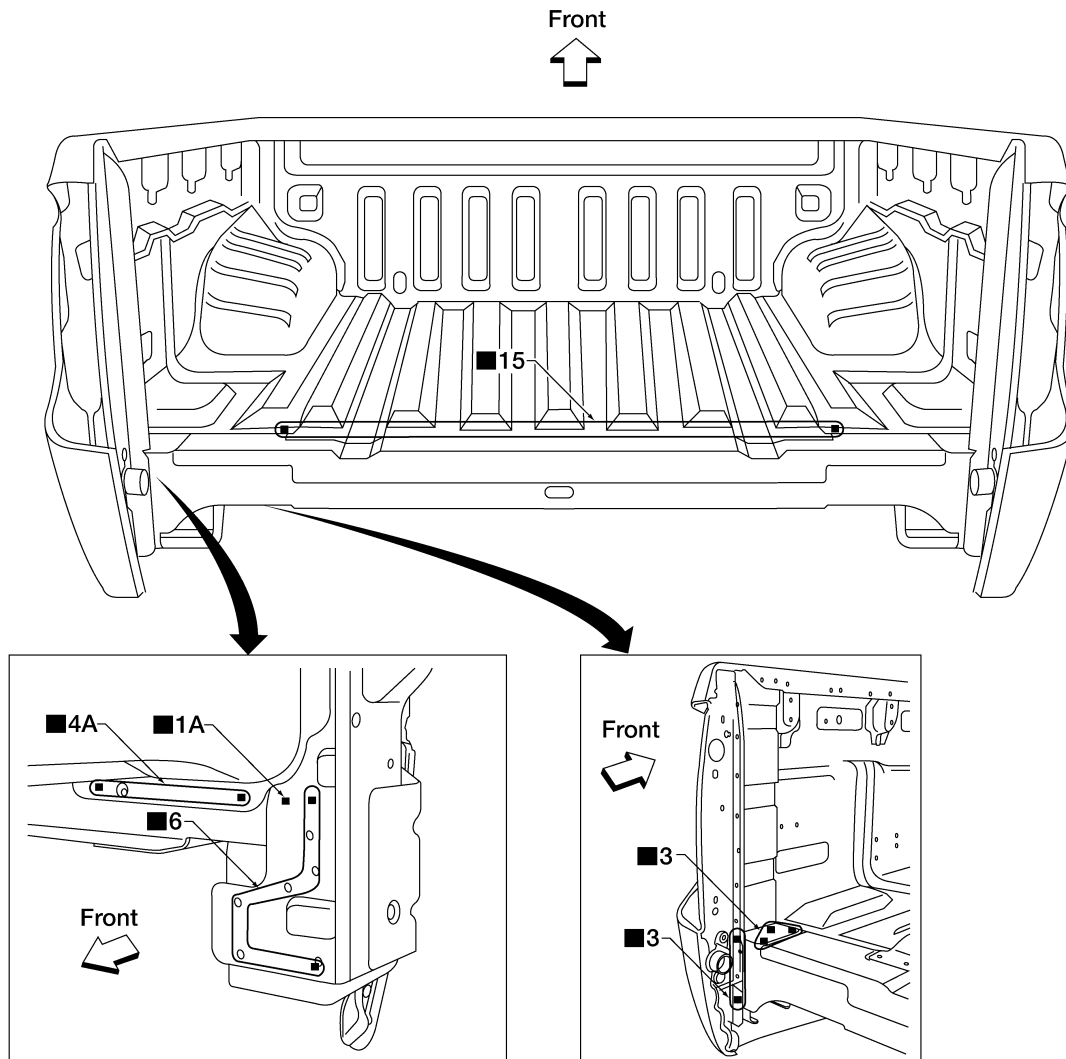
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REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

Rear Crossmember

Service Joint



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CRUSH HORN

CAUTION:

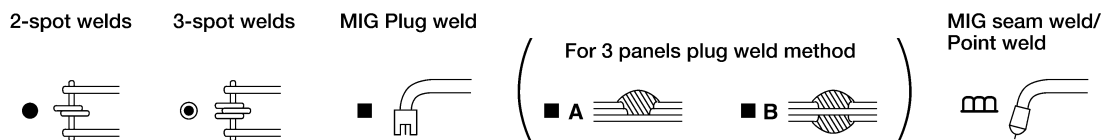
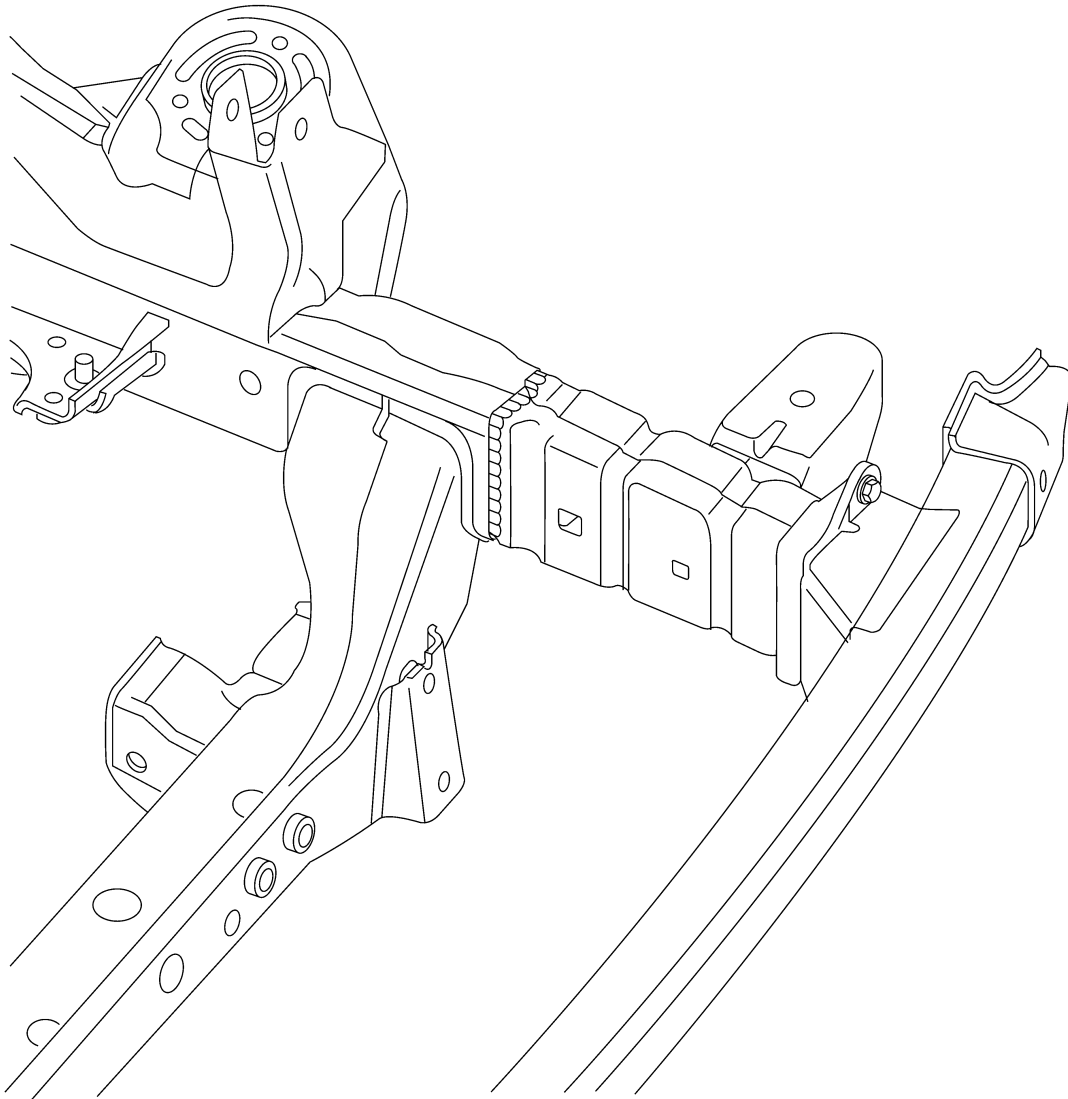
When replacing a damaged crush horn on N50 model, do not choose partial replacement method, such as cutting and butt-joint welding the crush horn.

REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

Be sure to replace the entire crush horn when the crush horn has damage at the back of the body mounting bracket.

Service Joint



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Foam Repair

During factory body assembly, foam insulators are installed in certain body panels and locations around the vehicle. Use the following procedure(s) to replace any factory-installed foam insulators.

URETHANE FOAM APPLICATIONS

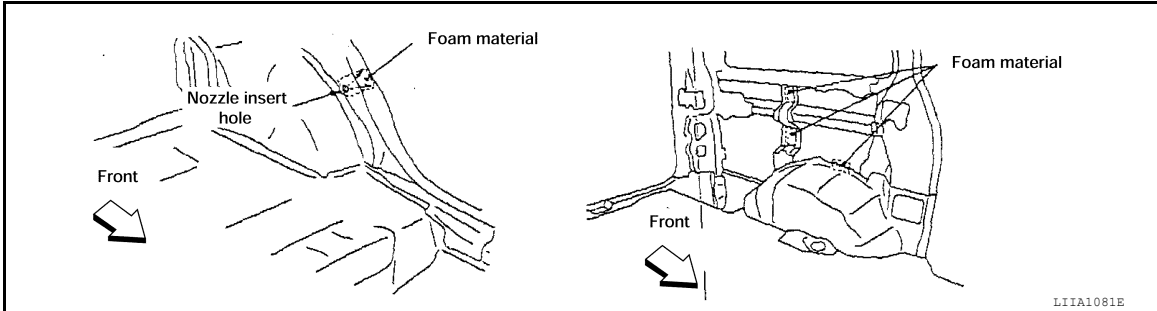
REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

Use commercially available spray foam for sealant (foam material) repair of material used on vehicle. Read instructions on product for fill procedures.

FILL PROCEDURES

1. Fill procedures after installation of service part.
 - Remove foam material remaining on vehicle side.
 - Clean area in which foam was removed.
 - Install service part.
 - Insert nozzle into hole near fill area and fill foam material or fill in enough to close gap with the service part.



2. Fill procedures before installation of service part.
 - Remove foam material remaining on vehicle side.
 - Clean area in which foam was removed.
 - Fill foam material on wheelhouse outer side.

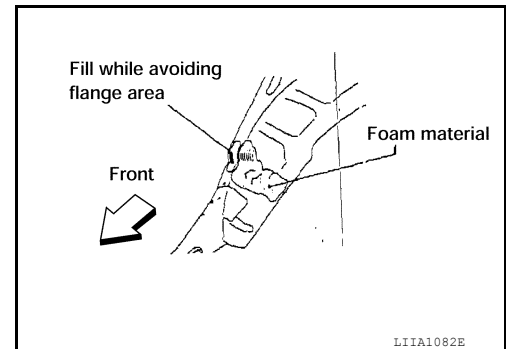
NOTE:

Fill in enough to close gap with service part while avoiding flange area.

- Install service part.

NOTE:

Refer to label for information on working times.



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