

FOREWORD

This repair manual has been prepared to provide essential information on body panel repair methods (including cutting and welding operations, but excluding painting) for the TOYOTA VENZA.

Applicable models: AGV 10, 15 series
GGV 10, 15 series

This manual consists of body repair methods, exploded diagrams and illustrations of the body components and other information relating to body panel replacement such as handling precautions, etc. However, it should be noted that the front fenders of this TOYOTA model are bolted on and require no welding.

When repairing, do not cut and join areas that are not shown in this manual. Only work on the specified contents to maintain body strength.

Body construction will sometimes differ depending on specifications and country of destination. Therefore, please keep in mind that the information contained herein is based on vehicles for general destinations.

For the repair procedures and specifications other than collision-damaged body components of the TOYOTA VENZA refer to the repair manuals.

If you require the above manuals, please contact your TOYOTA dealer.

All information contained in this manual is the most up-to-date at the time of publication. However, specifications and procedures are subject to change without prior notice.

TOYOTA MOTOR CORPORATION

ABOUT THIS MANUAL

Scope of the repair work explanation

- This text explains the welding panel replacement instructions from the vehicle's white body condition. We have abbreviated the explanations of the removal and reinstallation of the equipment parts up to the white body condition and of the installation, inspection, adjustment and final inspection of equipment parts after replacing the weld panel.

Section categories

- This manual has been divided as shown below.

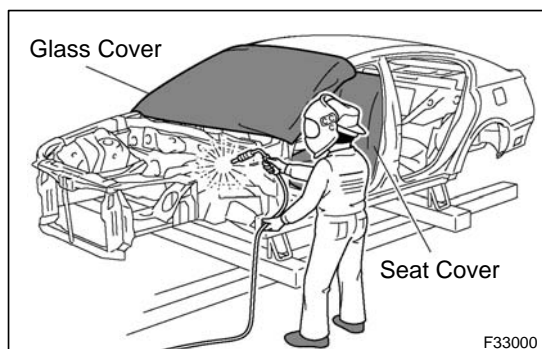
Section Title	Contents	Examples
INTRODUCTION	Explanation of general body repair. Views of welded panel replacement instructions.	Cautionary items. Views of weld panel replacement instructions.
BODY PANEL REPLACEMENT	Instructions for replacing the weld panels from the white body condition, from which bolted parts have been removed, with individual supply parts.	Front side member replacement. Quarter panel replacement.
BODY DIMENSIONS	Body aligning measurements.	Dimension diagrams.
PAINT • COATING	Scope and type of anti-rust treatment, etc. together with weld panel replacement.	Under coating. Body sealer.

Contents omitted from this manual.

- Make sure to perform the following essential procedures, although they are omitted in this manual.
 - (1) Clean and wash removed parts, if necessary.
 - (2) Visual inspection.

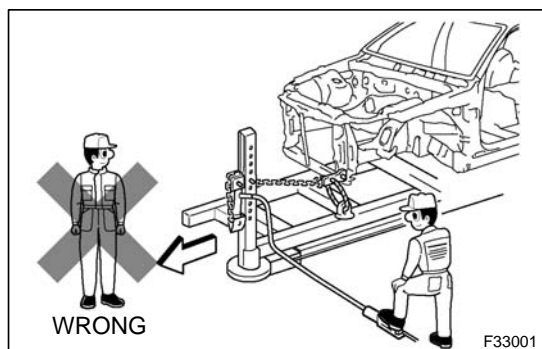
PRECAUTION

1. WORK PRECAUTIONS



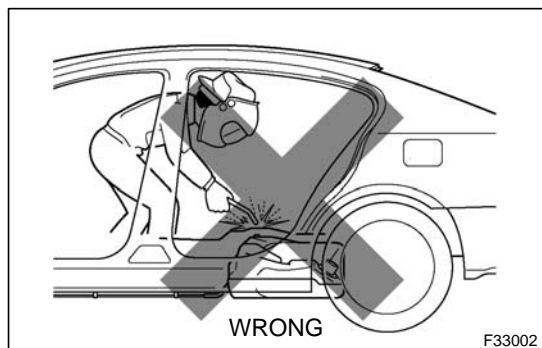
(a) VEHICLE PROTECTION

- (1) When welding, cover glass, seats, carpets, etc. with heat resistant fireproof covers to protect them.

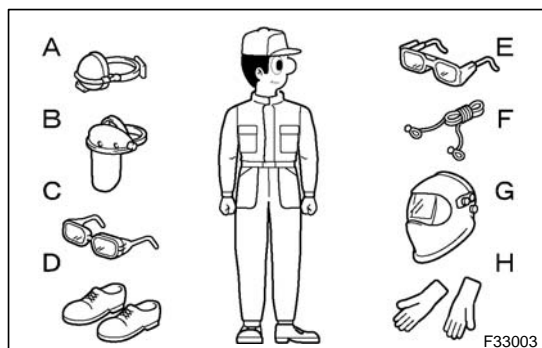


(b) SAFETY

- (1) Never stand in the path of the chain when using a puller on the body or frame, and be sure to attach a safety cable.



- (2) If it is necessary to use a frame in the area of the fuel tank, first remove the tank and plug the fuel line.



(c) SAFETY WORK CLOTHES

- (1) In addition to the usual mechanic's wear, cap and safety shoes, the appropriate gloves, head protector, welder's glasses, ear plugs, face protector, dust mask, etc. should be worn as the situation demands.

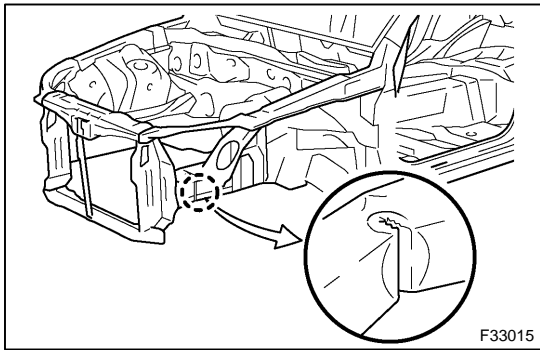
Code	Name
A	Dust mask
B	Face protector
C	Safety glasses
D	Safety shoes
E	Welder's glasses
F	Ear plugs
G	Head protector
H	Welder's gloves

2. PRECAUTIONS WHEN REPAIRING BODY FRAME PARTS (INCLUDING CRUSH BOX)



(a) PROHIBITION OF HEAT REPAIR FOR BODY FRAME PARTS

- (1) Rustproof high strength steel sheets are used for the body frame. Therefore, if these parts are heat repaired using an acetylene torch or equivalent, the crystalline structure changes, causing the strength of the steel sheets to decrease. Also, the zinc coating which is used to protect the body from rust will be damaged. This causes the surface of the steel sheets to become oxidized, which reduces their ability to resist rust.



(b) WHEN TO REPLACE FRAME PARTS

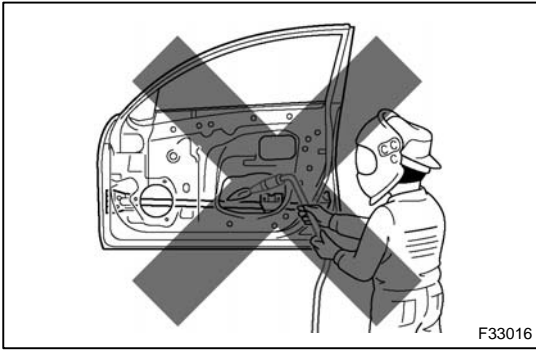
NOTICE:

Replace frame parts that have kinks.

HINT:

What is kink?

A deformation on a steel sheet that cannot be returned to its original shape by pulling or hammering due to the deformation angle being sharp.

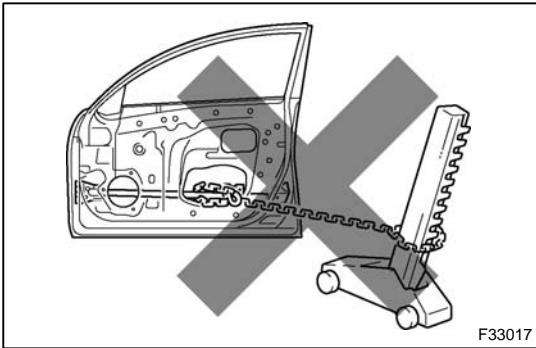


(c) REPAIR OF DOOR SIDE IMPACT BEAM IS PROHIBITED

- (1) The impact beam is designed so that it performs at 100% in its original shape. However, if the impact beam is repaired, its performance may not be the same as before the accident.

PARTS WHICH ARE PROHIBITED TO BE REPAIRED:

Door side impact beam

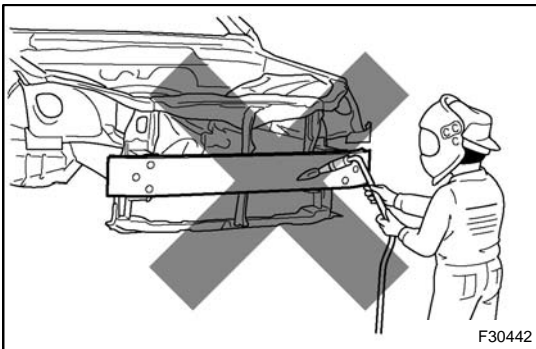


(d) REPAIR OF BUMPER REINFORCEMENT IS PROHIBITED

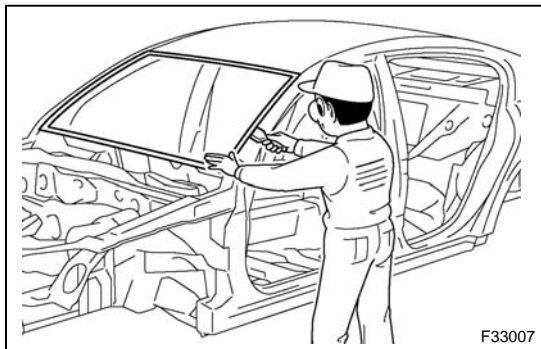
- (1) The bumper reinforcement is designed so that it performs at 100% in its original shape. However, if the bumper reinforcement is repaired, its performance may not be the same as before the accident.

PARTS WHICH ARE PROHIBITED TO BE REPAIRED:

Bumper reinforcement



3. PRECAUTIONS FOR CORRECT REPAIR

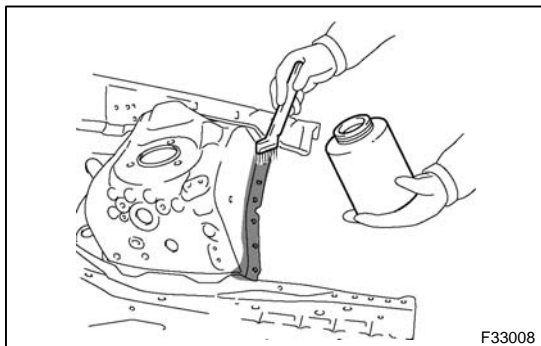


(a) REMOVAL OF ADJACENT COMPONENTS

- (1) When removing adjacent components, apply protective tape to the surrounding body and your tools to prevent damage.

NOTICE:

If the paint film is damaged, make sure to re-finish the paint.

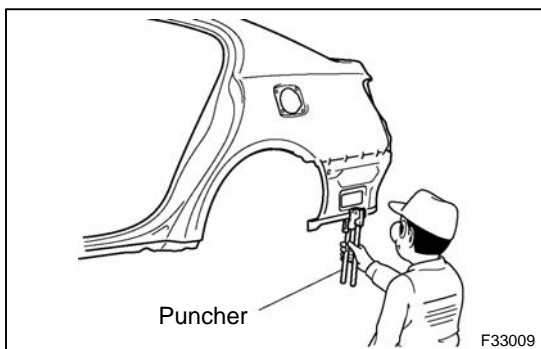


(b) ANTI-RUST TREATMENT BEFORE WELDING

- (1) Apply welding primer to the contact surfaces of the welding areas to protect them from rust.

NOTICE:

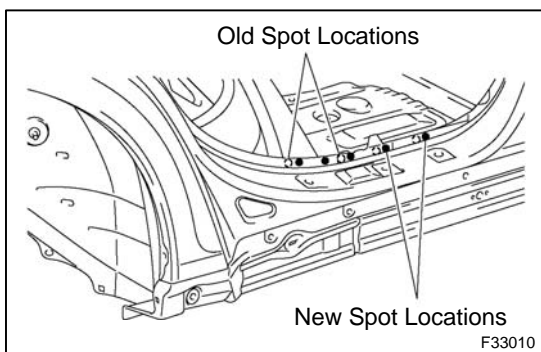
Do not apply welding primer outside of the contact surfaces.



(c) MAKING HOLES FOR PLUG WELDING

- (1) For areas where a spot welder cannot be used, use a puncher or drill to make holes for plug welding.

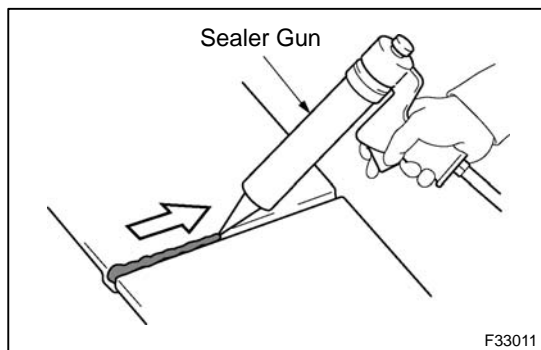
Thickness of welded portion	Diameter of plug hole
Under 1.0 mm (0.04 in.)	Over 5 mm (0.20 in.)
1.0 to 1.6 mm (0.04 to 0.06 in.)	Over 6.5 mm (0.26 in.)
1.7 to 2.3 mm (0.07 to 0.09 in.)	Over 8 mm (0.31 in.)
Over 2.4 mm (0.09 in.)	Over 10 mm (0.39 in.)



(d) WELDING PRECAUTIONS

- (1) The number of welding spots should be as follows.
Spot weld: 1.3 X No. of manufacturer's spots
Plug weld: More than No. of manufacturer's plugs
- (2) Spot weld locations
Avoid welding over previously welded areas.

4. ANTI-RUST TREATMENT AFTER INSTALLATION



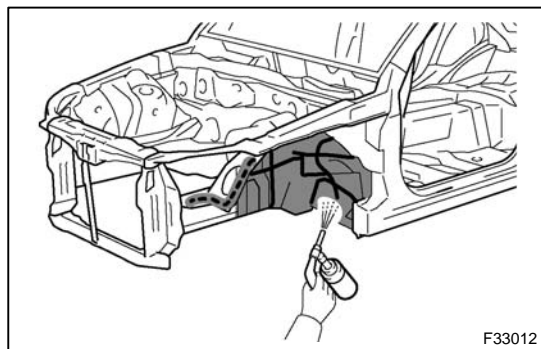
(a) BODY SEALER APPLICATION

PURPOSE:

For water-proofing and anti-rust measures, always apply the body sealer to the body panel seams and hems of the doors, hood, etc.

NOTICE:

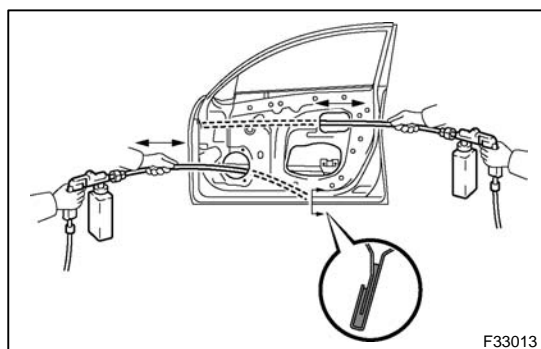
Apply body sealer neatly to parts that require a high quality appearance.



(b) UNDERCOAT APPLICATION

PURPOSE:

To prevent corrosion and protect the body from gravel, always apply a sufficient undercoating to the areas indicated.



(c) VEHICLE BODY ANTI-RUST AGENT APPLICATION

PURPOSE:

The purpose is to protect areas from rust which are difficult to paint such as the backside of the box-shaped cross section frame parts.

METHOD:

Apply anti-rust agent through the service holes and/or installation holes of the parts.

5. PROCEDURES NECESSARY WHEN BATTERY TERMINAL IS DISCONNECTED/RECONNECTED

(a) THE WORK LIST

(1) Each inspection procedure refers to the TOYOTA Repair Manual.

Necessary Procedures	Procedure Details	Effects/Inoperative Functions When Necessary Procedures are not Performed	Notes
Reset back door close position	Fully close the back door to turn off the courtesy switch.	<ul style="list-style-type: none"> Power back door function Back door closer function (w/ power back door system) 	<ul style="list-style-type: none"> If the back door is closed when disconnecting the cable from the battery terminal, it is not necessary to reset it. The power back door ECU controls the locked or unlocked state of the back door based on its memory. If the power for the power back door ECU is disconnected and reconnected, the back door will need to be unlocked before it can be operated.

NOTICE:

It may not be possible to release the steering lock or start the engine when the battery voltage is low. If this occurs, initialization of the steering lock system is required.

6. PROCEDURES NECESSARY WHEN ECU OR OTHER PARTS ARE REPLACED

(a) THE WORK LIST

(1) Each inspection procedure refers to the TOYOTA Repair Manual.

Replacement Part		Necessary Procedure	Effect/Inoperative Function when Necessary Procedures are not Performed	Note
ECM		Vehicle Identification Number (VIN) registration	MIL comes on	Use the Techstream.
		ECU communication ID registration (Engine immobiliser system) *2	Engine start	—
Automatic transaxle assembly		1. Reset memory 2. Transaxle compensation code Input 3. Perform road test to allow TCM to Learn	<ul style="list-style-type: none"> Large shift shock The deterioration of fuel efficiency 	Use the Techstream.
<ul style="list-style-type: none"> Valve body assembly Shift solenoid valve SL3 and/or SL4 		1. Reset memory 2. Reset transaxle compensation code 3. Perform road test to allow TCM to learn	<ul style="list-style-type: none"> Large shift shock The deterioration of fuel efficiency 	Use the Techstream.
Shift solenoid valve SL1 and/or SL2		Perform road test to allow TCM to learn	<ul style="list-style-type: none"> Large shift shock The deterioration of fuel efficiency 	—
TCM (If possible, read the transaxle compensation code from the previous TCM)	Possible	1. Reset memory 2. Transaxle compensation code input (Into the new TCM) 3. Perform road test to allow TCM to learn	<ul style="list-style-type: none"> Large shift shock The deterioration of fuel efficiency 	Use the Techstream.
	Impossible	1. Reset memory 2. Reset transaxle compensation code 3. Perform road test to allow TCM to learn	<ul style="list-style-type: none"> Large shift shock The deterioration of fuel efficiency 	Use the Techstream.
<ul style="list-style-type: none"> Tire pressure warning ECU Tire pressure warning valve and transmitter 		Code registration (Tire pressure warning system)	<ul style="list-style-type: none"> When DTC detection conditions of "transmitter ID not received" DTC are met, TPWS indicator blinks for 1 minute, and then illuminates. Tire pressure warning function 	—
Brake actuator assembly (Skid control ECU)		Engine variant learning	VSC function	—
Power steering ECU		Rotation angle sensor initialization and torque sensor zero point calibration	<ul style="list-style-type: none"> P/S warning light comes on EPS control 	DTC (C1515/C1525) will be stored when the power steering ECU is replaced.
Steering column		Rotation angle sensor initialization and torque sensor zero point calibration	Steering effort is different between turning steering wheel to left and right	—

Replacement Part	Necessary Procedure	Effect/Inoperative Function when Necessary Procedures are not Performed	Note
<ul style="list-style-type: none"> • Certification ECU (smart key ECU assembly) *1 • Steering lock ECU (steering lock actuator assembly) *1 • Key *1 	Code registration (Engine immobiliser system (w/ smart key system))	<ul style="list-style-type: none"> • Wireless door lock control system • Smart key system • Engine start 	—
Transponder key ECU *2	<ol style="list-style-type: none"> 1. Key code registration 2. ECU communication ID registration 	Engine start	—
<ul style="list-style-type: none"> • Door control transmitter *2 • Door control receiver *2 	Registration of recognition code (Wireless door lock control system (w/o smart key system))	Wireless door lock control system	—
Rear height control sensor sub-assembly RH	Perform headlight leveling ECU initialization	Headlight leveling function	<ul style="list-style-type: none"> • Necessary when the sensor is removed and installed • Necessary when vehicle height changes due to replacement of the suspension • Adjust the headlight aim after initializing the headlight leveling ECU
<ul style="list-style-type: none"> • Occupant classification ECU • Front passenger seat 	<ol style="list-style-type: none"> 1. Zero point calibration (Occupant classification system) 2. Sensitivity check (Occupant classification system) 	<ul style="list-style-type: none"> • Occupant classification system • Passenger airbag ON/OFF indicator • Airbag system (Front passenger side) • Seat belt warning system (Front passenger side) 	—
<ul style="list-style-type: none"> • Power window regulator motor • Door window regulator 	Initialize power window control system	<ul style="list-style-type: none"> • Automatic door glass open/close function • Jam protection function • Operation function after power switch is turned off • Remote control function 	Necessary when the regulator is removed and installed.
<ul style="list-style-type: none"> • Sliding roof ECU (sliding roof drive gear assembly) • Sliding roof glass • Sliding roof housing 	Initializing sliding roof ECU (pulse sensor initial position setting)	<ul style="list-style-type: none"> • Automatic slide open, tilt up function of sliding roof • Jam protection function 	Necessary when the sliding roof ECU is removed and installed (not necessary when the sliding roof ECU (sliding roof drive gear assembly) is removed and installed together with the sliding roof housing).
Headlight leveling ECU	Perform headlight leveling ECU initialization	Headlight leveling function	—

*1: w/ smart key system

*2: w/o smart key system

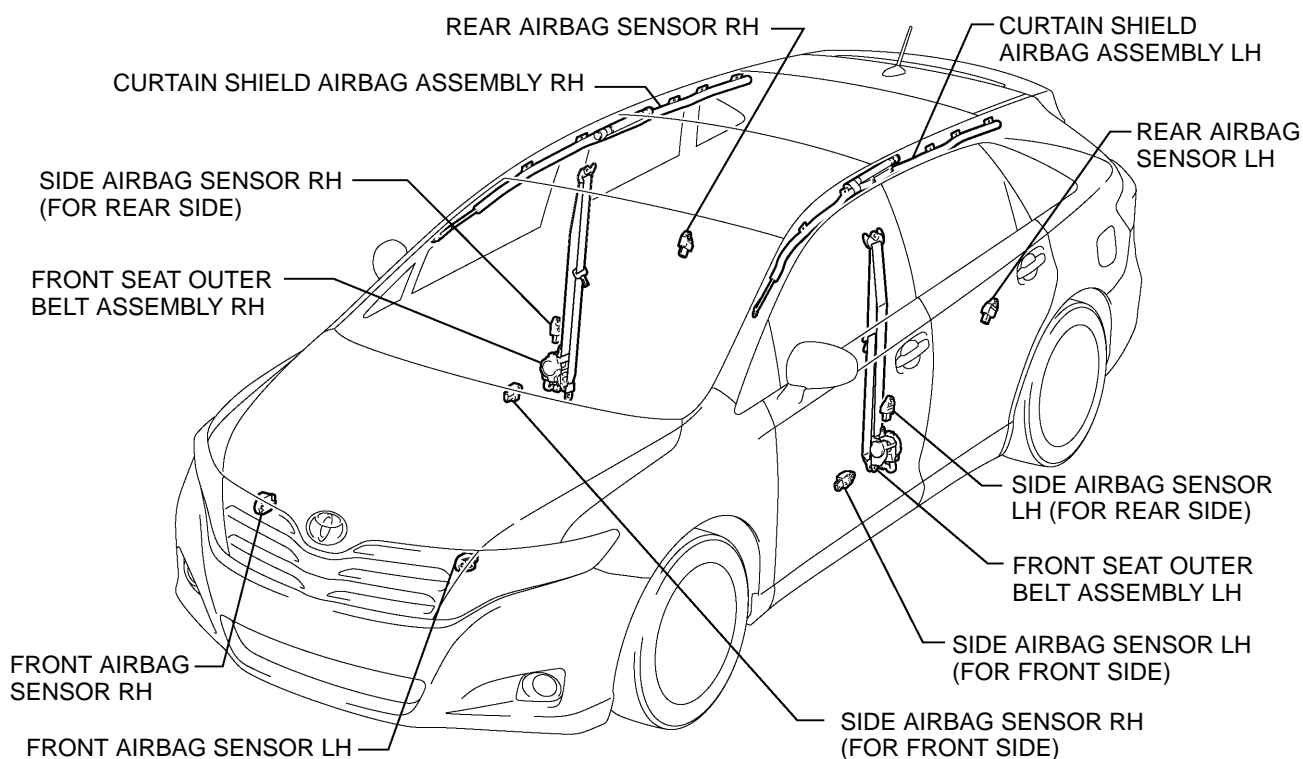
7. PRECAUTIONS FOR SRS AIRBAG SYSTEM

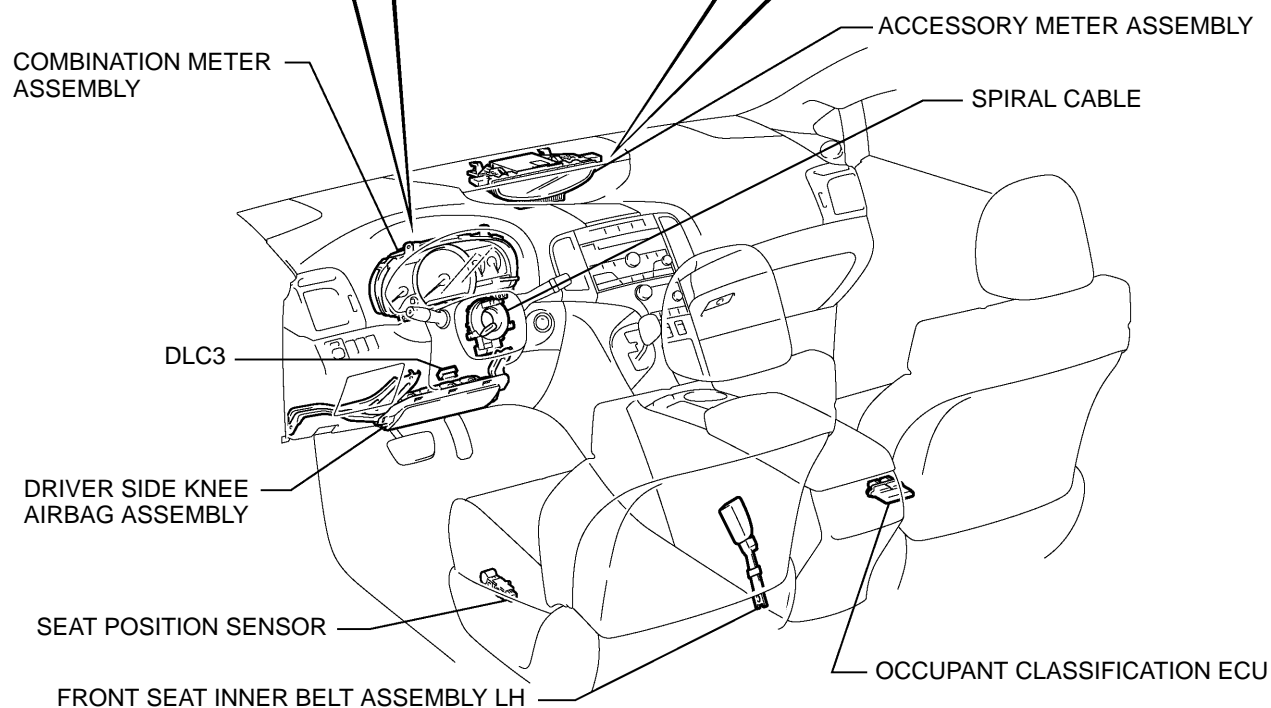
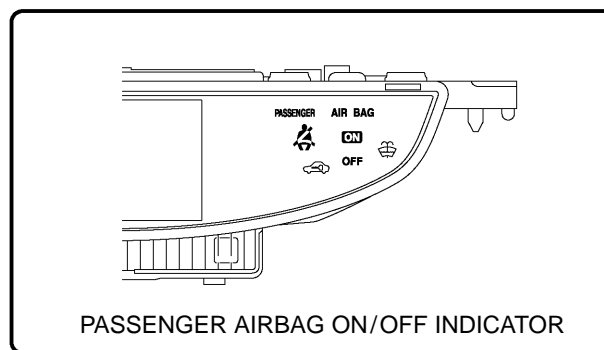
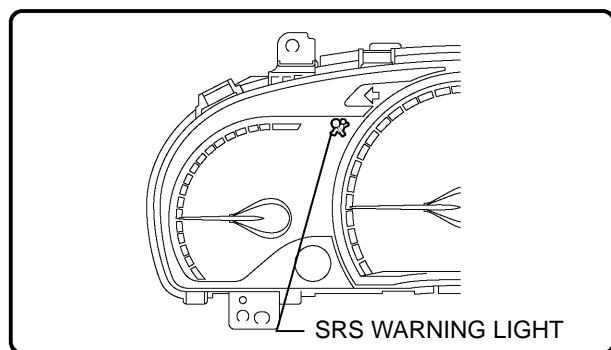
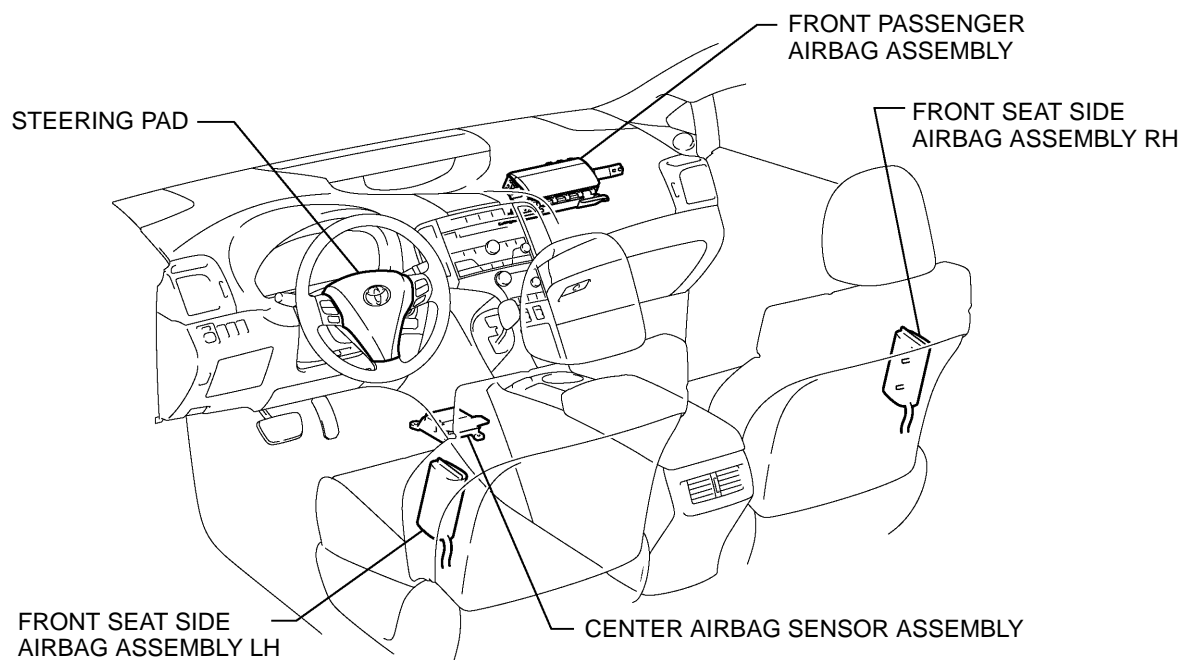
(a) HANDLING OF A VEHICLE THAT HAS BEEN DAMAGED IN A COLLISION

- (1) Refer to the TOYOTA Repair Manual for the SRS airbag system inspection procedures.
- (2) If impacts are likely to occur to the front airbag sensors, side airbag sensors, rear airbag sensors, or center airbag sensor remove each sensor as necessary beforehand.
- (3) Do not allow the front airbag sensors, side airbag sensors, rear airbag sensors, or center airbag sensor to become heated to high temperatures.
- (4) Check the wire harnesses and connectors for damage and/or melting, as some areas of the airbags and seat belt pretensioners may heat up to several hundred degrees when they operate.

(b) PRECAUTIONS FOR USING AN ELECTRIC WELDER

- (1) Check the Diagnostic Trouble Codes (DTCs).
 1. If one or more DTCs are displayed;
 - Disconnect the negative (–) terminal cable from the battery.
 - Disconnect all the malfunctioning circuit connectors.
 - Disconnect the center airbag sensor assembly connector.
 2. If DTCs are NOT displayed;
 - Inspect for damage to the electric wiring harnesses and connectors.
 - Disconnect the negative (–) terminal cable from the battery.
 - Disconnect the center airbag sensor assembly connector.





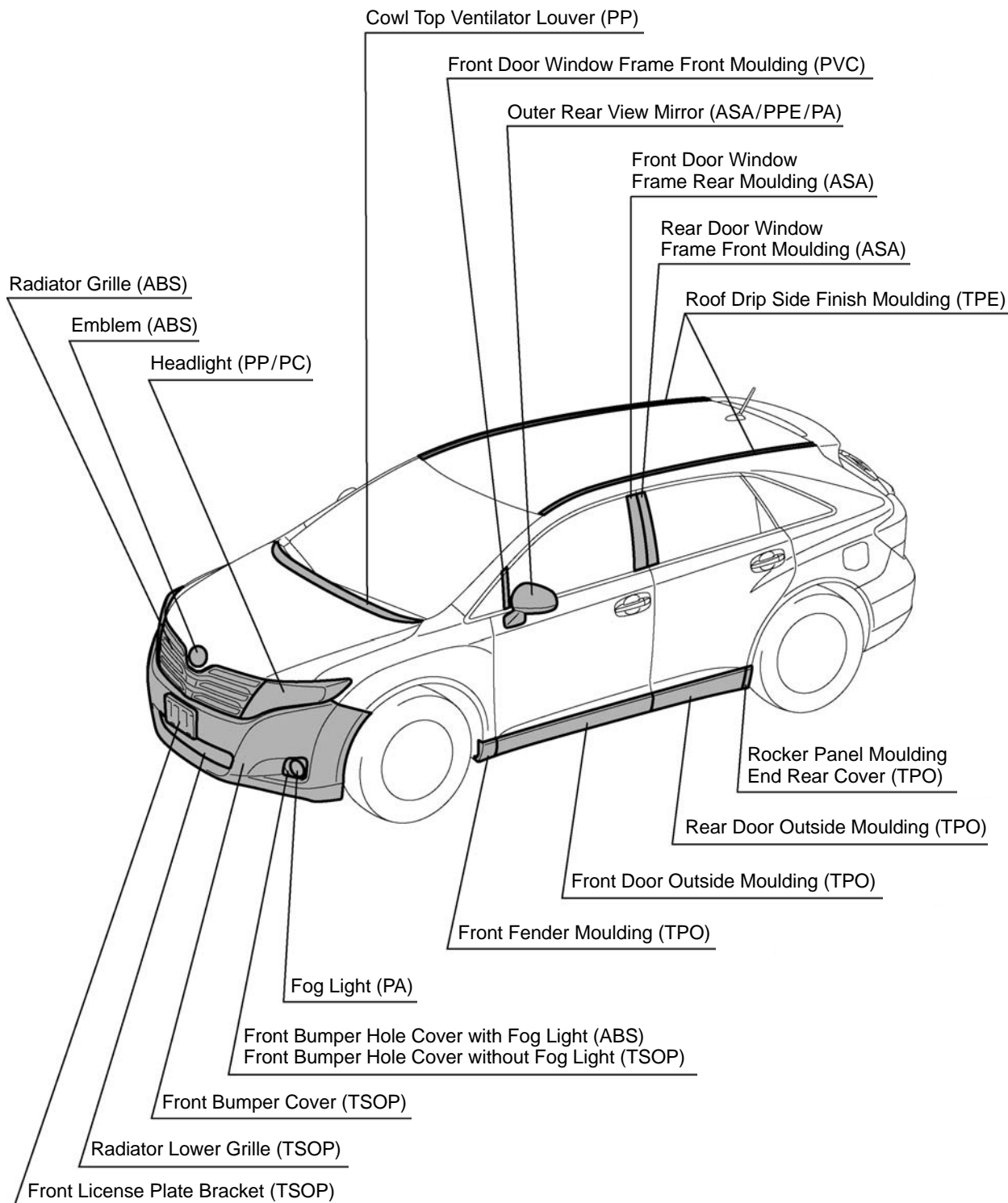
8. PRECAUTIONS FOR RESIN PARTS

(a) PLASTIC PROPERTIES CHART

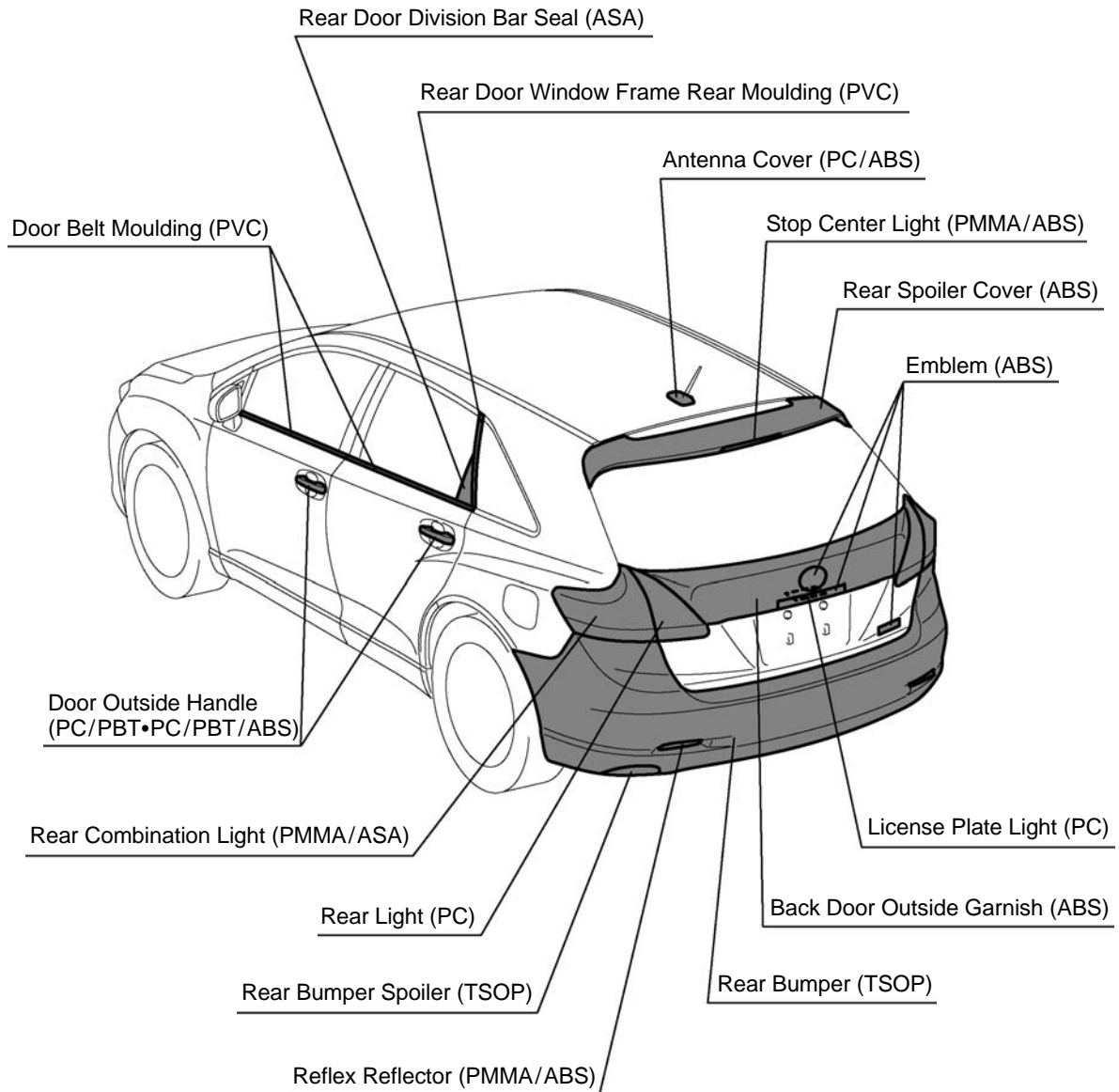
- (1) When repairing, some parts may be deformed by the heat. Therefore, confirm the properties of the plastic parts, and remove parts beforehand as necessary.

Code	Material name	Heat resistant temperature limit* °C (°F)	Resistance to alcohol or gasoline	Notes
ABS	Acrylonitrile Butadiene Styrene	80 (176)	Alcohol is harmless if applied only for short time in small amounts (e.g., quick wiping to remove grease).	Avoid gasoline and organic or aromatic solvents.
ASA	Acrylonitrile Styrene Acrylate	80 (176)	Alcohol is harmless if applied only for short time in small amounts (e.g., quick wiping to remove grease).	Avoid gasoline and organic or aromatic solvents.
PA	Polyamide (Nylon)	80 (176)	Alcohol and gasoline are harmless.	Avoid battery acid.
PBT	Polybutylene Terephthalate	160 (320)	Alcohol and gasoline are harmless.	Most solvents are harmless.
PC	Polycarbonate	120 (248)	Alcohol is harmless.	Avoid gasoline, brake fluid, wax, wax removers and organic solvents. Avoid alkali.
PMMA	Polymethyl Methacrylate	80 (176)	Alcohol is harmless if applied only for short time in small amounts.	Avoid dipping or immersing in alcohol, gasoline, solvents, etc.
PP	Polypropylene	80 (176)	Alcohol and gasoline are harmless.	Most solvents are harmless.
PPE	Polyphenylene Ether	80 (176)	Alcohol is harmless if applied only for short time in small amounts (e.g., quick wiping to remove grease).	Avoid dipping or immersing in alcohol, gasoline, solvents, etc.
PVC	Polyvinylchloride (Vinyl)	80 (176)	Alcohol and gasoline are harmless if applied only for short time in small amounts (e.g., quick wiping to remove grease).	Avoid dipping or immersing in alcohol, gasoline, solvents, etc.
TPE	Thermoplastic Elastomer	80 (176)	Alcohol is harmless. Gasoline is harmless if applied only for short time in small amounts.	Most solvents are harmless but avoid dipping in gasoline, solvents, etc.
TPO	Thermoplastic Olefine	80 (176)	Alcohol is harmless. Gasoline is harmless if applied only for short time in small amounts.	Most solvents are harmless but avoid dipping in gasoline, solvents, etc.
TSOP	TOYOTA Super Olefine Polymer	80 (176)	Alcohol and gasoline are harmless.	Most solvents are harmless.

* The heat resistant temperature means a temperature that may cause heat deformation during a procedure.

(b) THE PLASTIC BODY PARTS MATERIAL LIST

HINT :
/ Made up of 2 or more kinds materials.

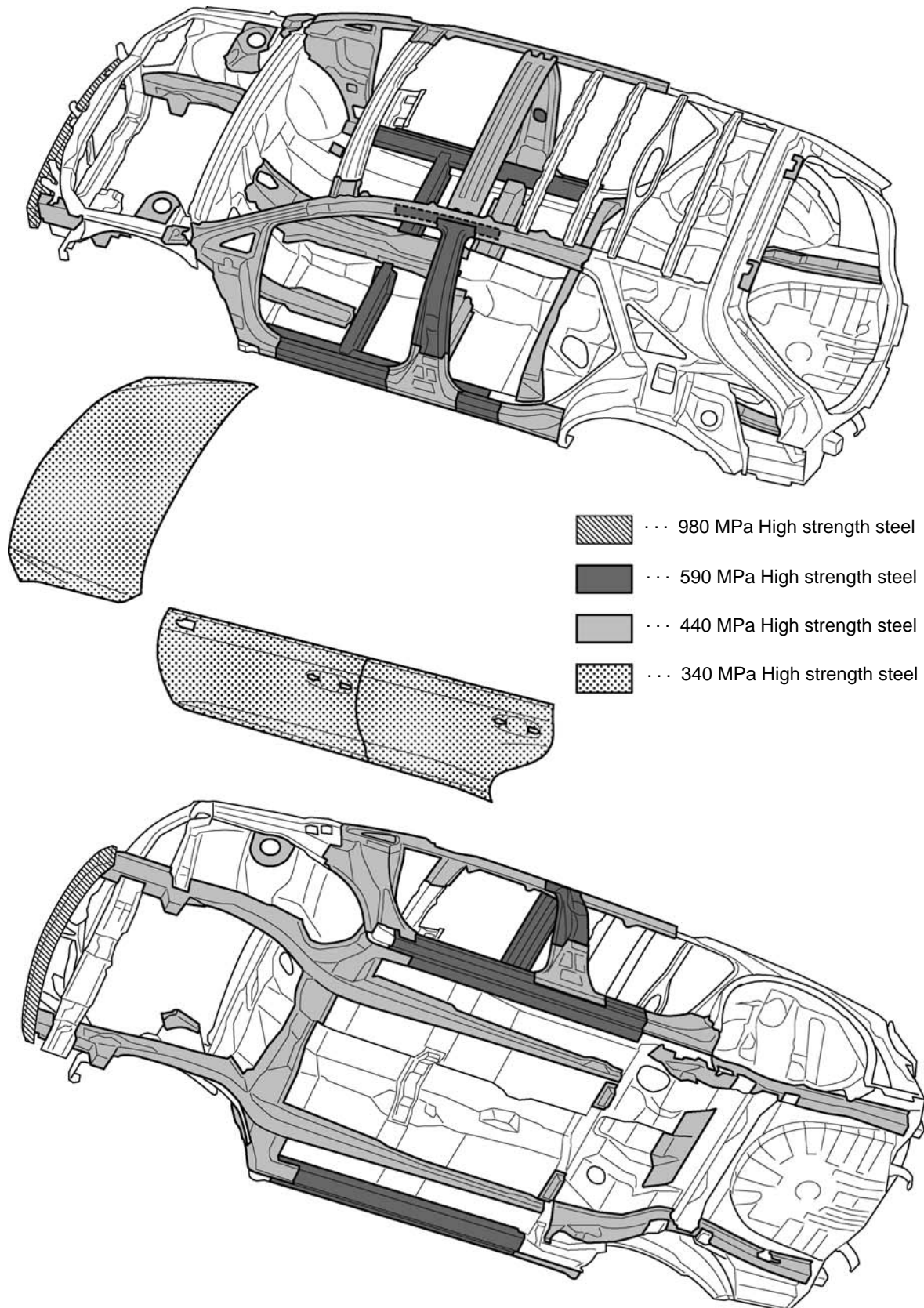


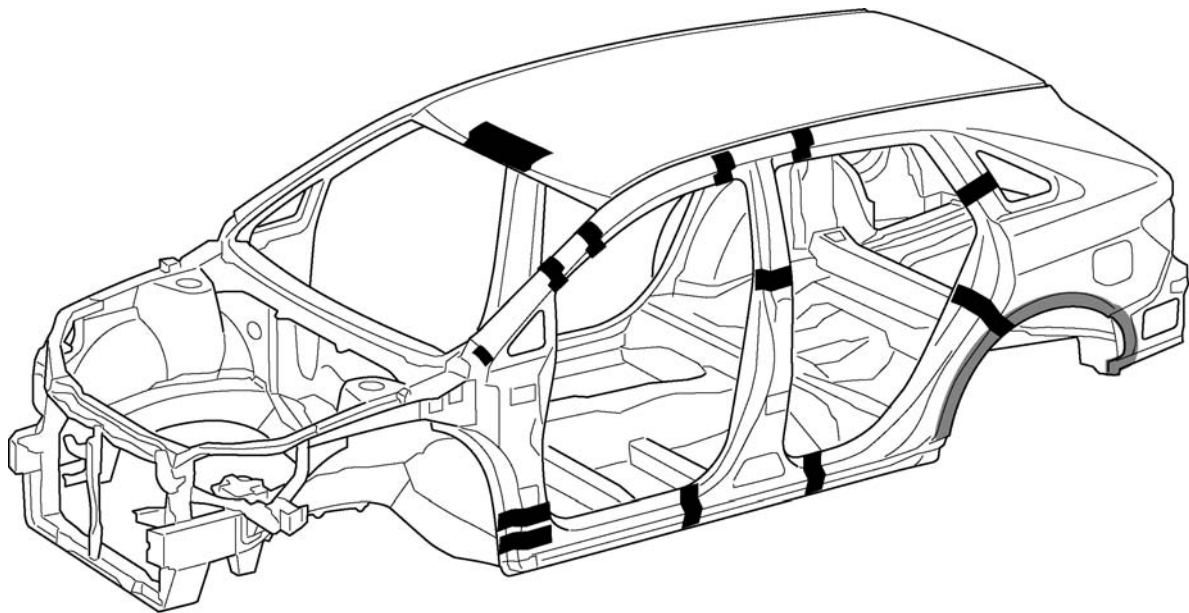
HINT :

- Resin material differs with model.
- / Made up of 2 or more kinds materials.

ABOUT THIS VEHICLE

1. STRUCTURAL OUTLINE



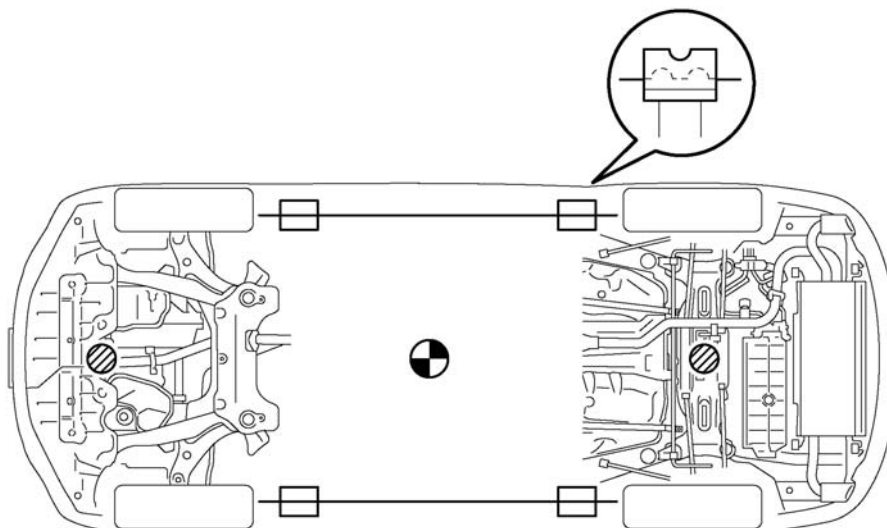


- ... Foamed sealing material application areas
- ... Adhesive application area

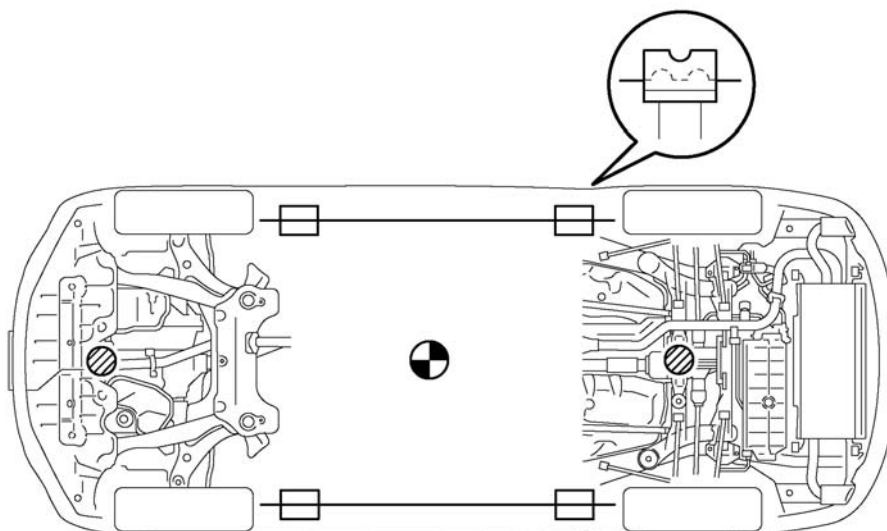
2. NOTICE ABOUT VEHICLE CONDITION WHEN JACKING UP VEHICLE

(a) NOTICE FOR USING JACK AND SAFETY STAND


for 2WD:



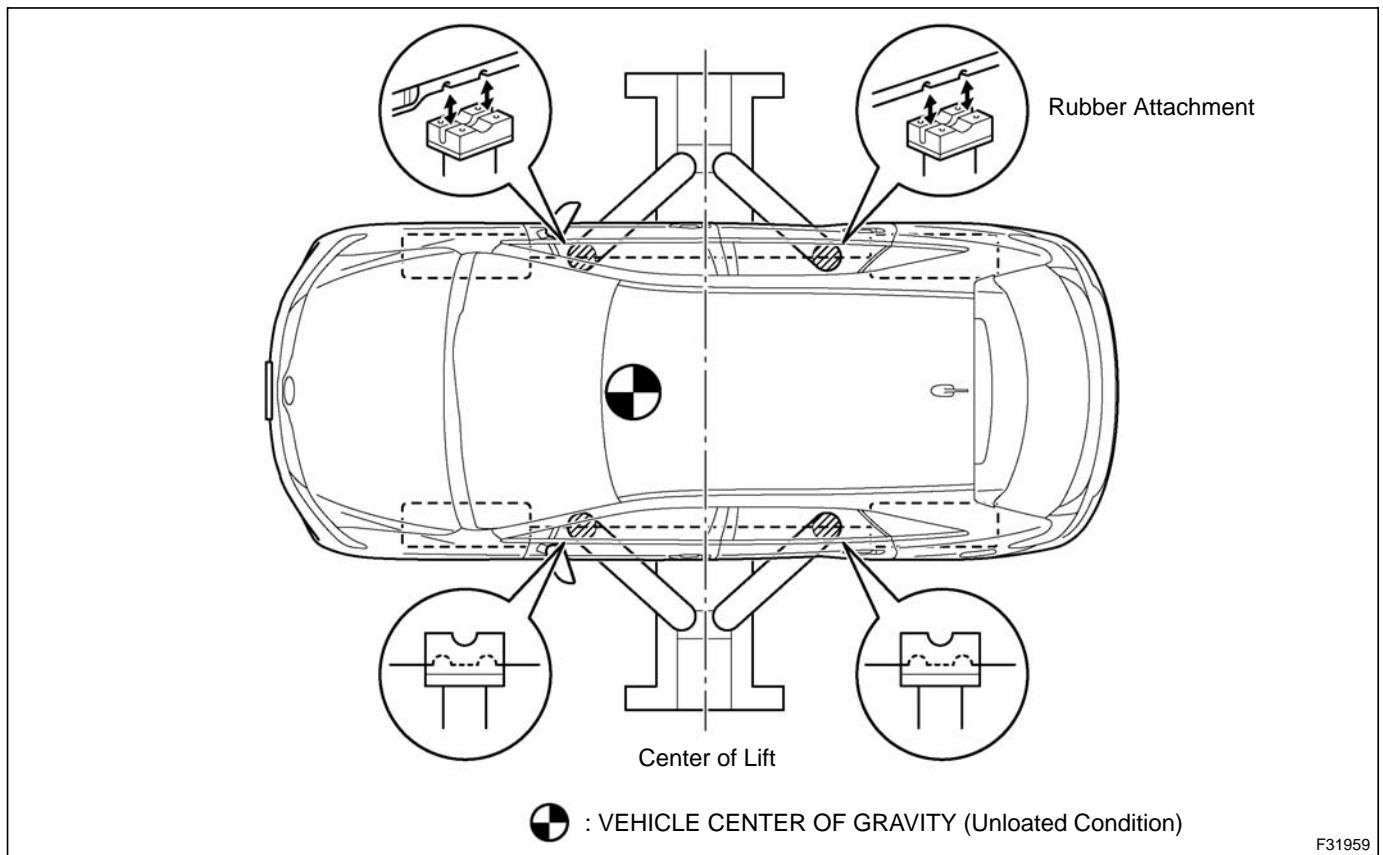
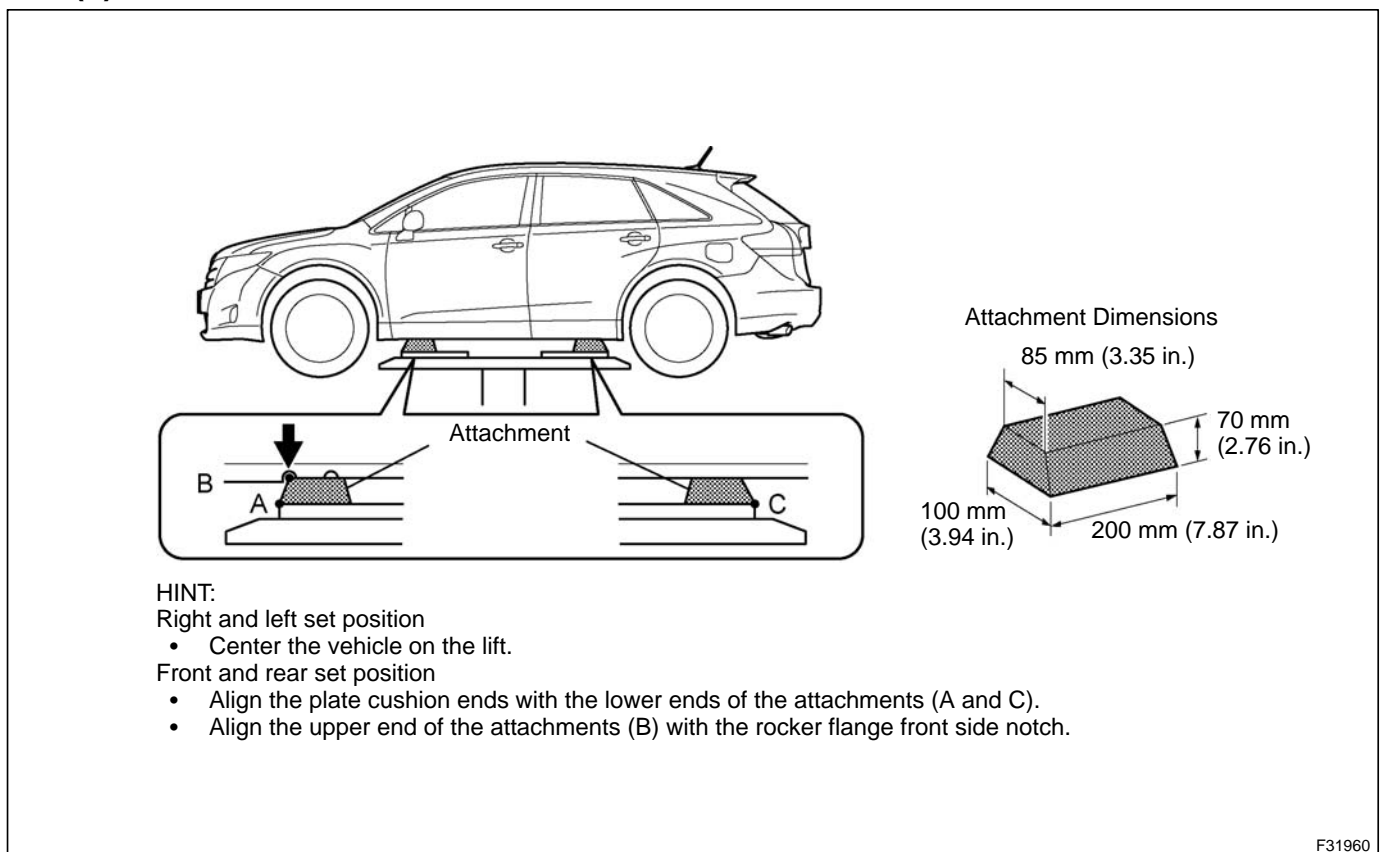
for AWD:



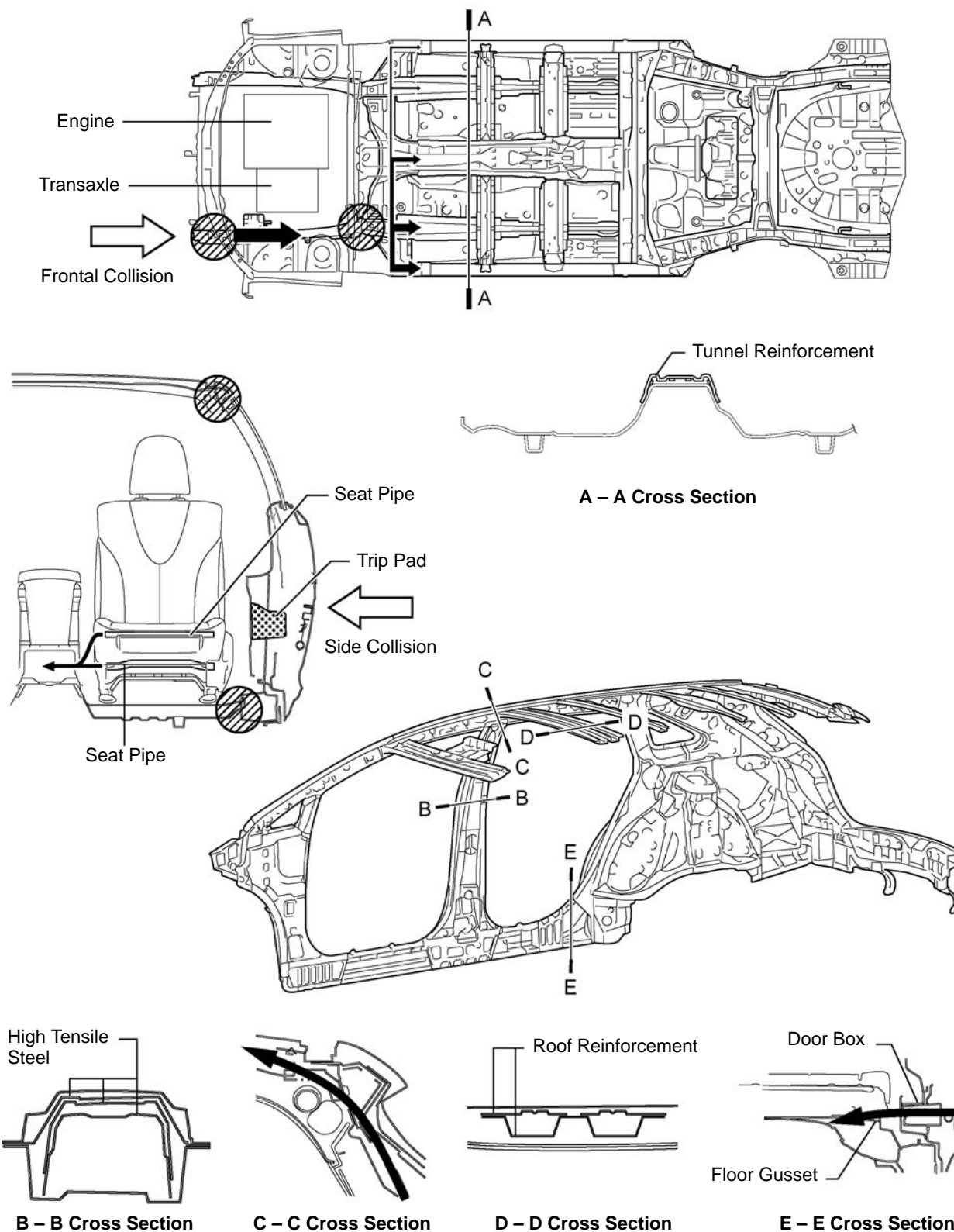
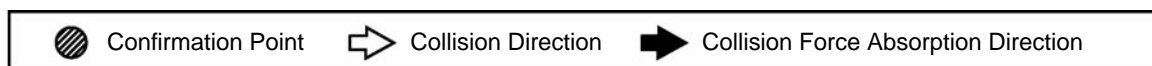
 : JACK POSITION

 : SUPPORT POSITION (Safety stand, Swing arm type lift)

 : VEHICLE CENTER OF GRAVITY (Unloaded Condition)

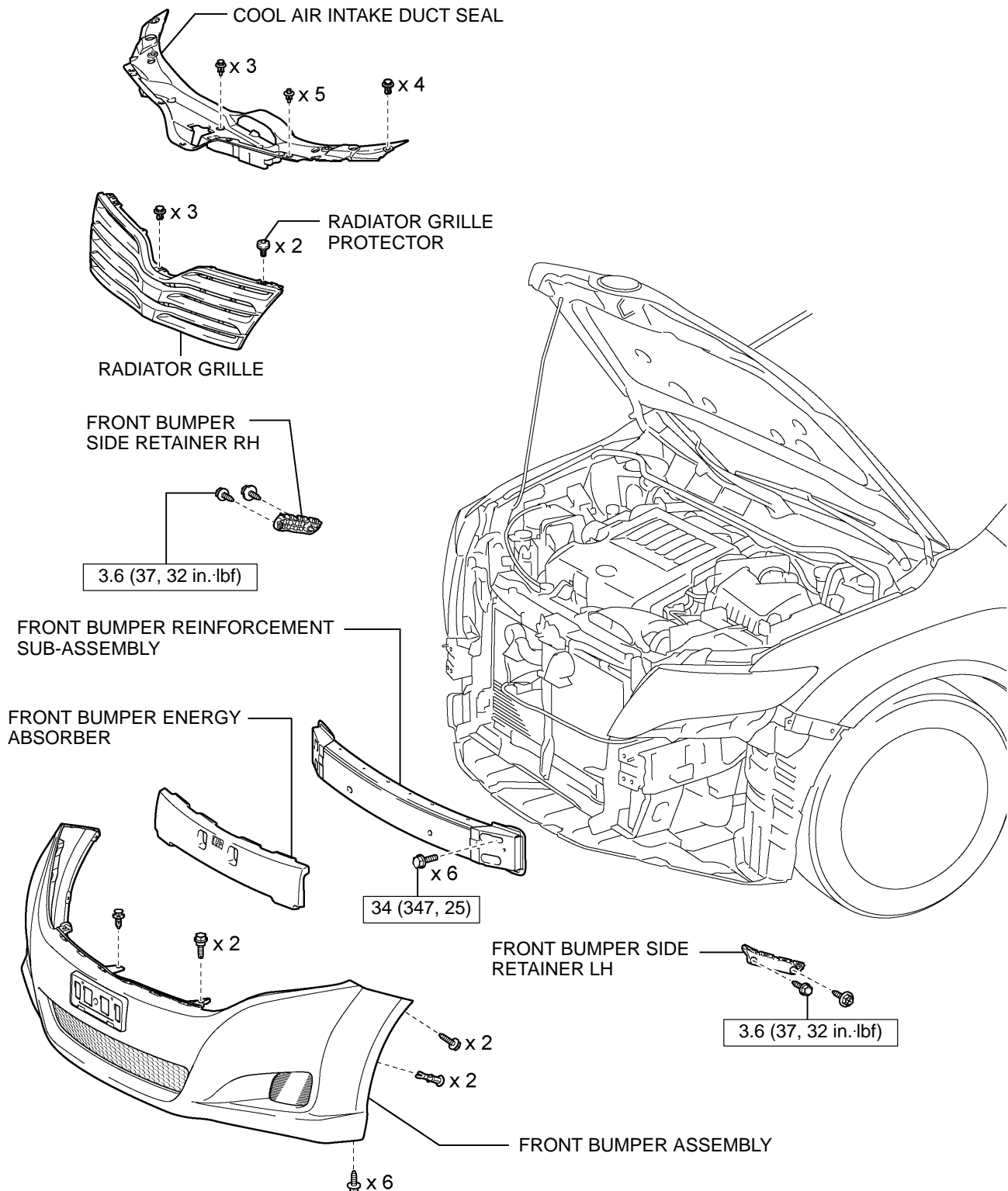
(b) NOTICE FOR USING SWING ARM TYPE LIFT**(c) NOTICE FOR USING PLATE TYPE LIFT**

3. DAMAGE DIAGNOSIS



4. COMPONENTS

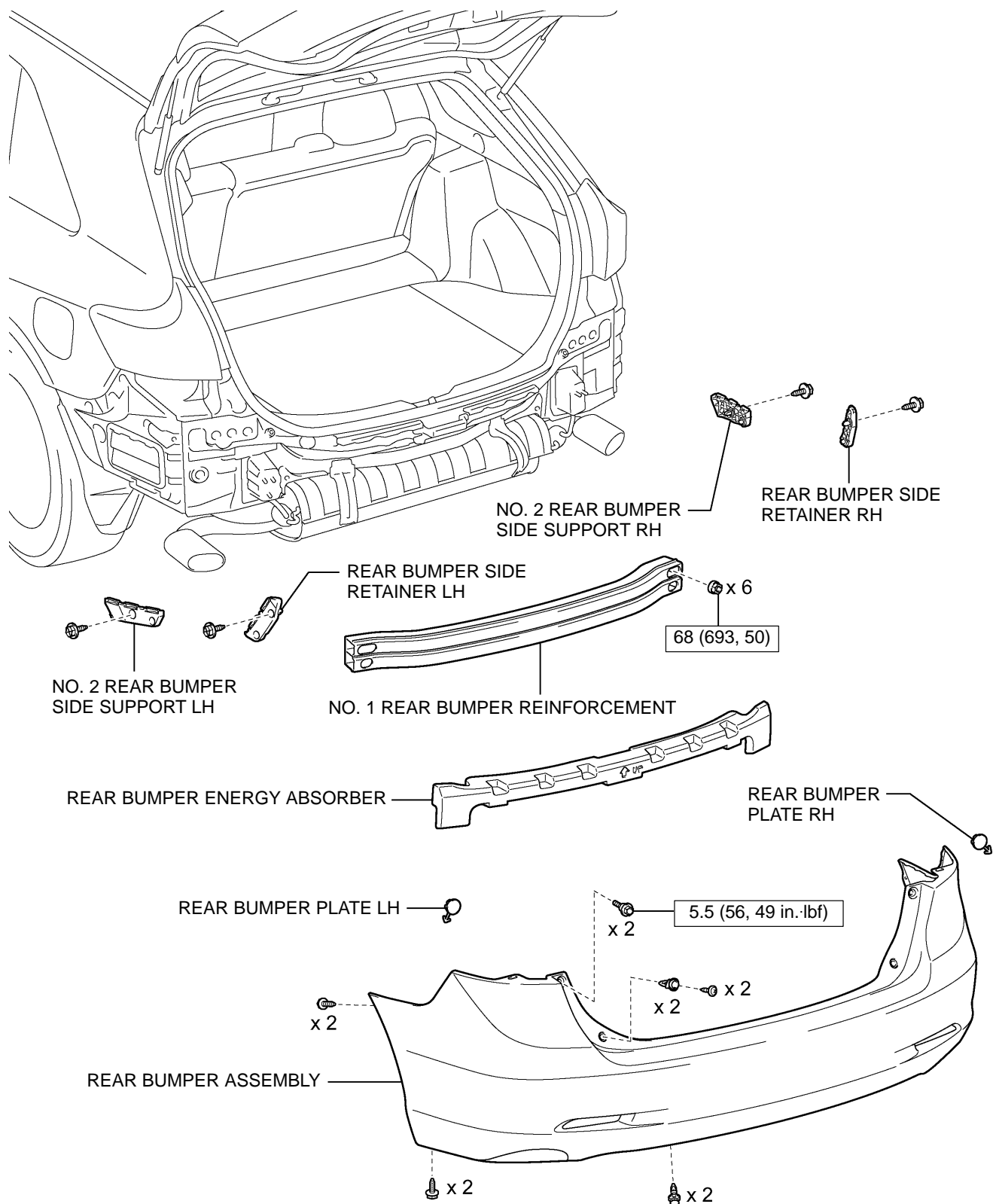
(a) FRONT BUMPER



CAUTION:

The bolts must be tightened to the torque specification, as they are related to vehicle safety during a collision.

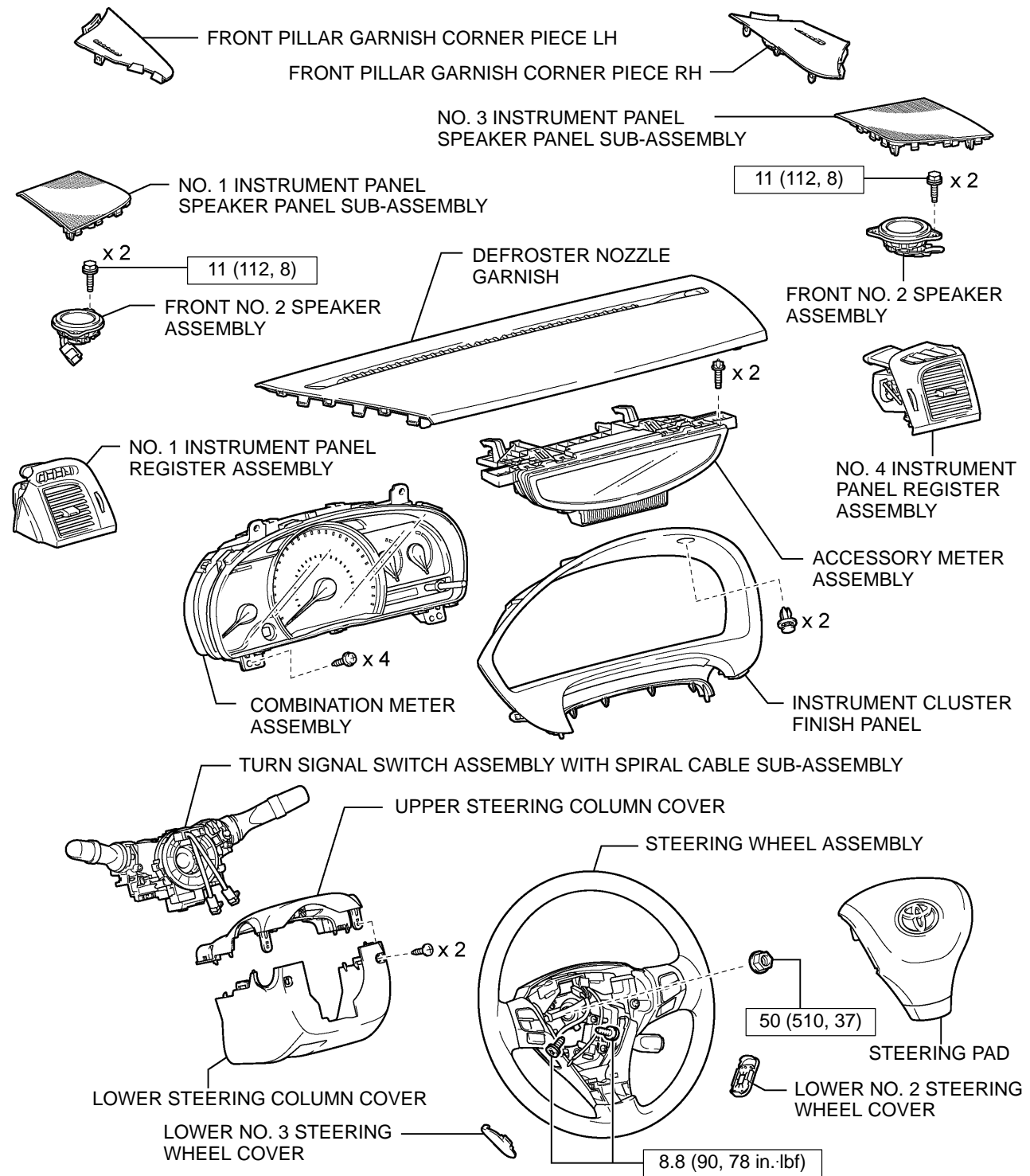
N·m (kgf·cm, ft.·lbf) : Specified torque

(b) REAR BUMPER**CAUTION:**

The bolts and nuts must be tightened to the torque specification, as they are related to vehicle safety during a collision.

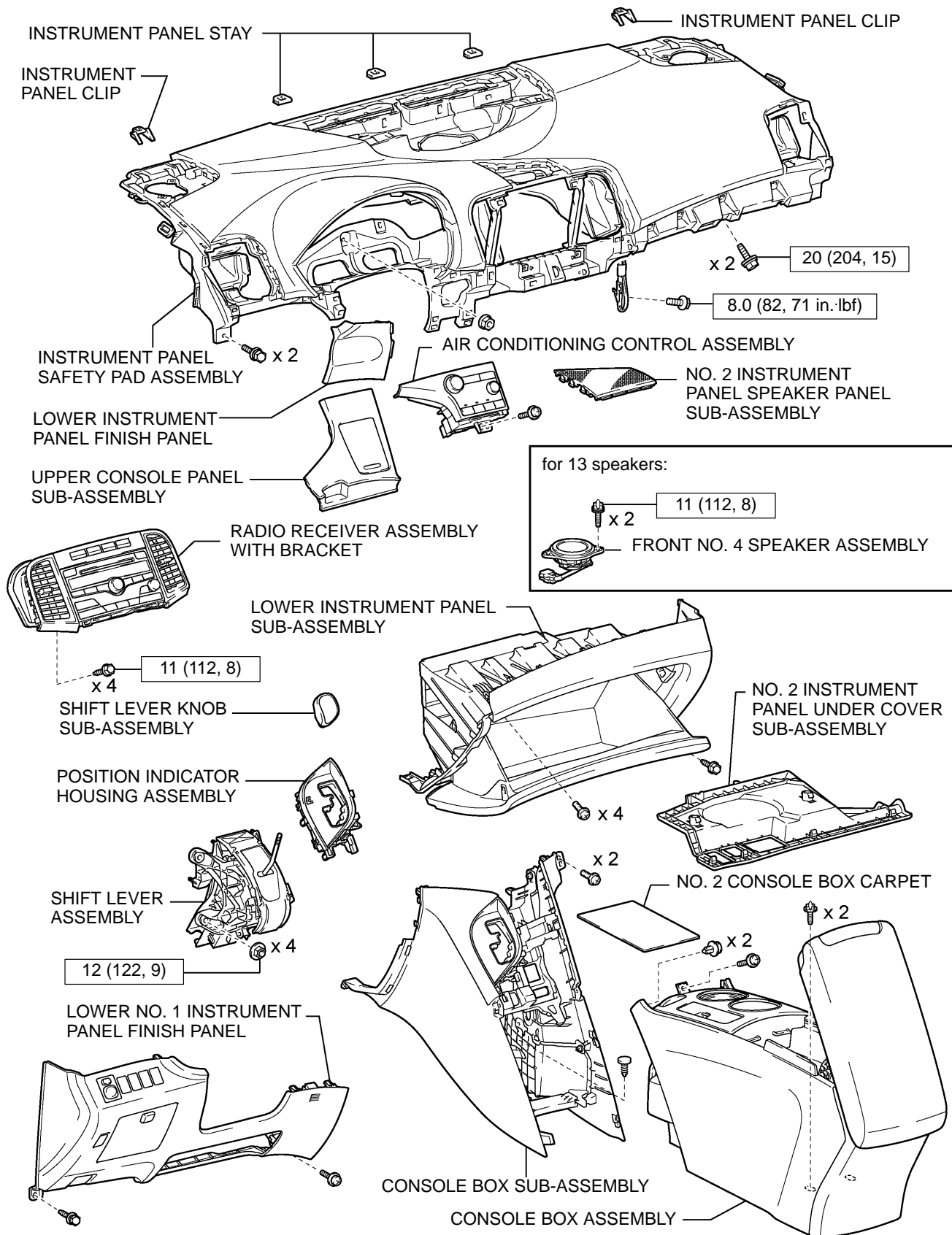
N·m (kgf·cm, ft. lbf) : Specified torque

(c) INSTRUMENT PANEL

**CAUTION:**

The bolts and nut must be tightened to the torque specification, as they are related to vehicle safety during a collision.

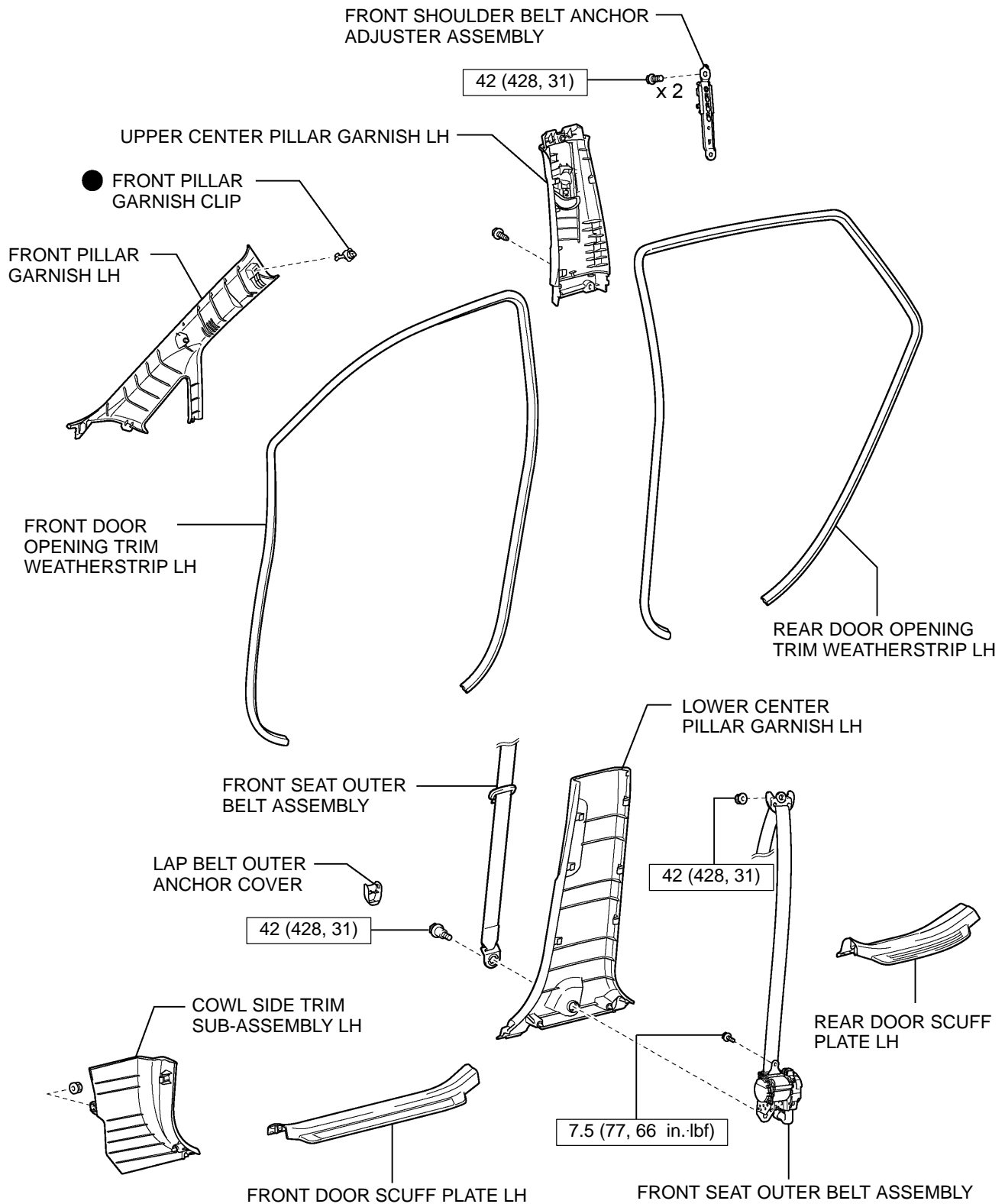
N·m (kgf·cm, ft.-lbf) : Specified torque



CAUTION:

The bolts and nuts must be tightened to the torque specification, as they are related to vehicle safety during a collision.

N·m (kgf·cm, ft.·lbf) : Specified torque

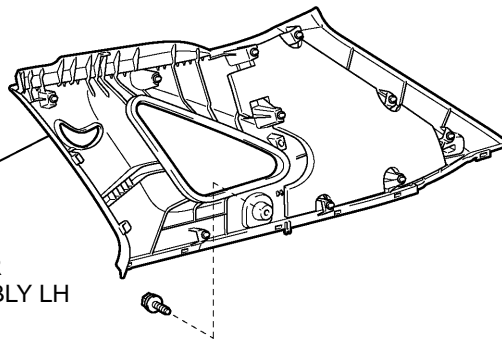
(d) INTERIOR TRIM**CAUTION:**

The bolts and nuts must be tightened to the torque specification, as they are related to vehicle safety during a collision.

N·m (kgf·cm, ft.:lbf) : Specified torque ● Non-reusable part

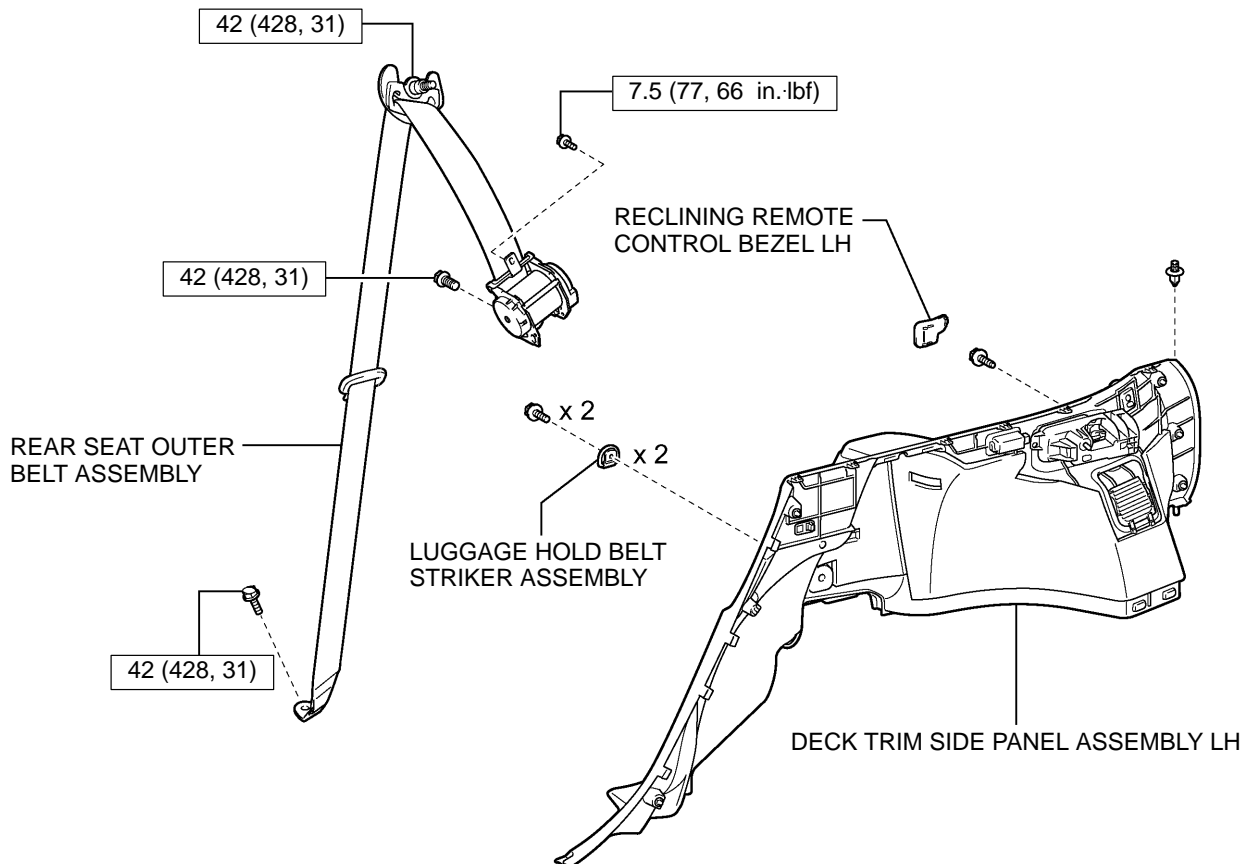
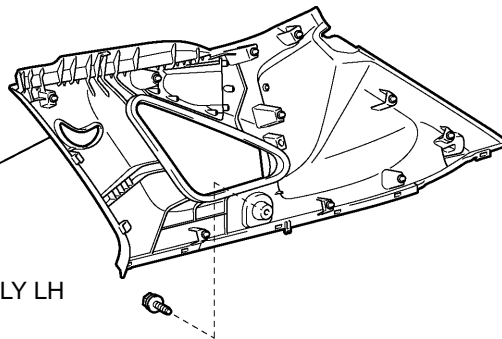
w/o Power Back Door:

ROOF SIDE INNER
GARNISH ASSEMBLY LH



w/ Power Back Door:

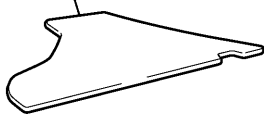
ROOF SIDE INNER
GARNISH ASSEMBLY LH



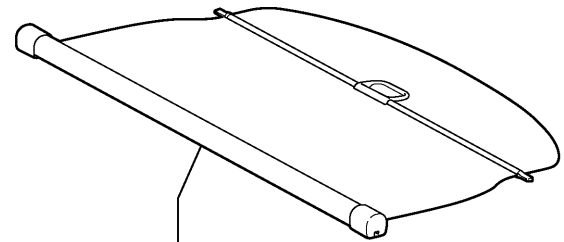
CAUTION:

The bolts must be tightened to the torque specification, as they are related to vehicle safety during a collision.

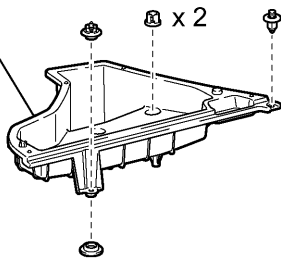
N·m (kgf·cm, ft. lbf) : Specified torque

NO. 2 DECK BOARD
SUB-ASSEMBLY

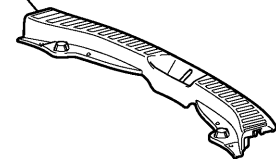
w/ Tonneau Cover:



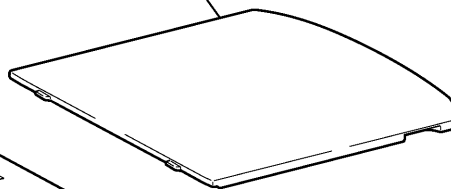
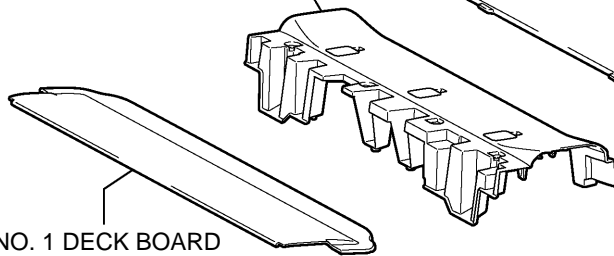
TONNEAU COVER ASSEMBLY

DECK SIDE
TRIM BOX RH

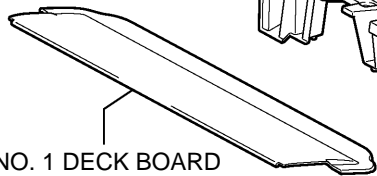
REAR FLOOR FINISH PLATE



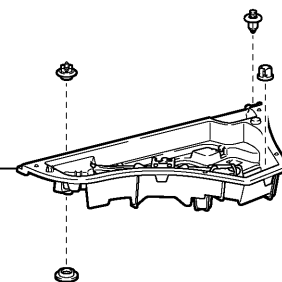
DECK BOARD ASSEMBLY

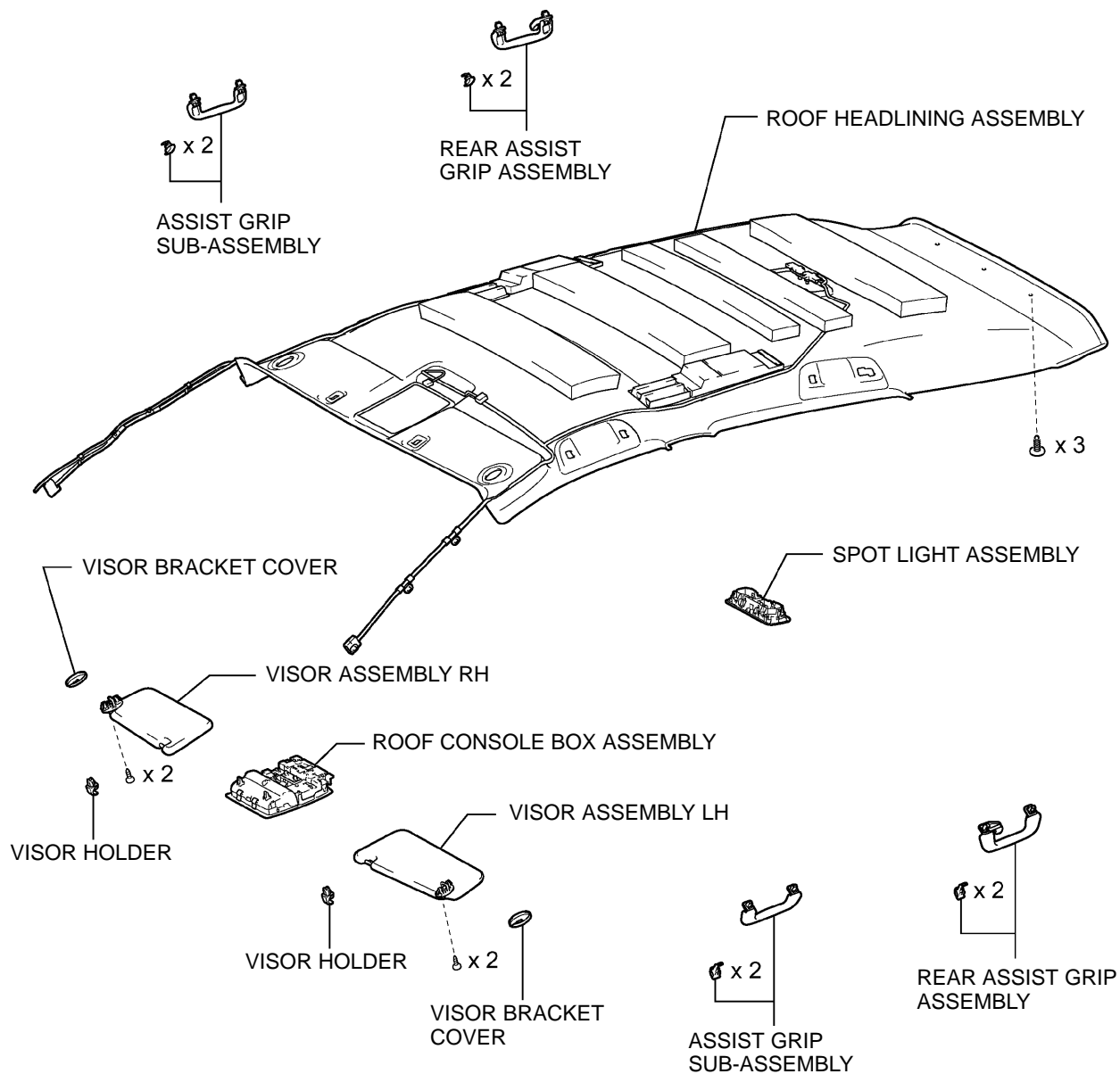
REAR SEAT SUB FLOOR
PANEL ASSEMBLY

NO. 1 DECK BOARD

NO. 3 DECK BOARD
SUB-ASSEMBLY

DECK SIDE TRIM BOX LH



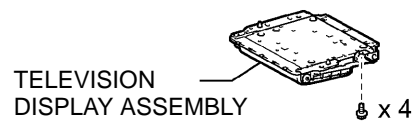


w/ EC Mirror:



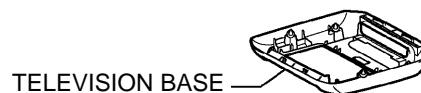
INNER REAR VIEW MIRROR
STAY HOLDER COVER

w/ Rear Seat Entertainment System:

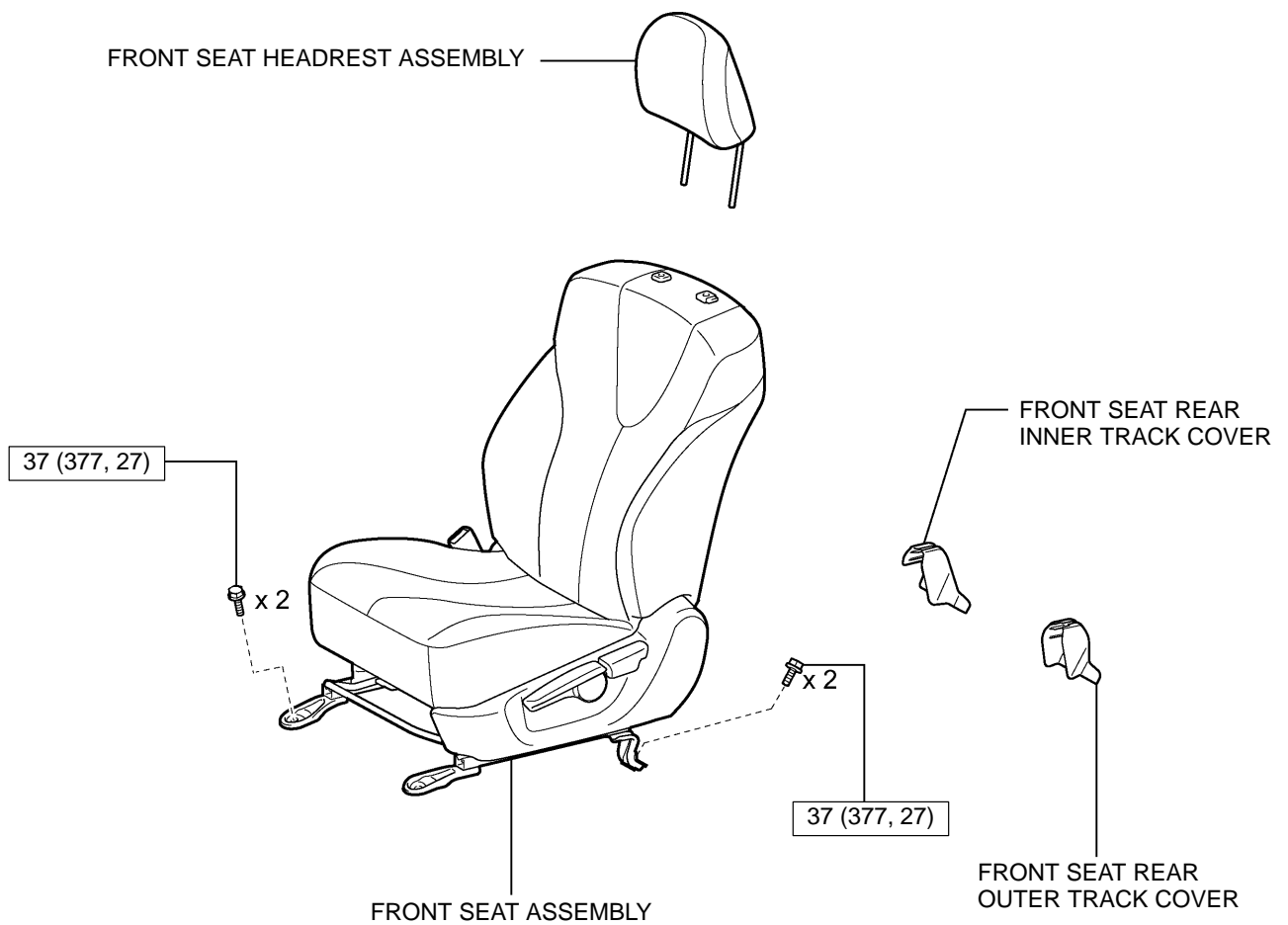


TELEVISION
DISPLAY ASSEMBLY

x 4

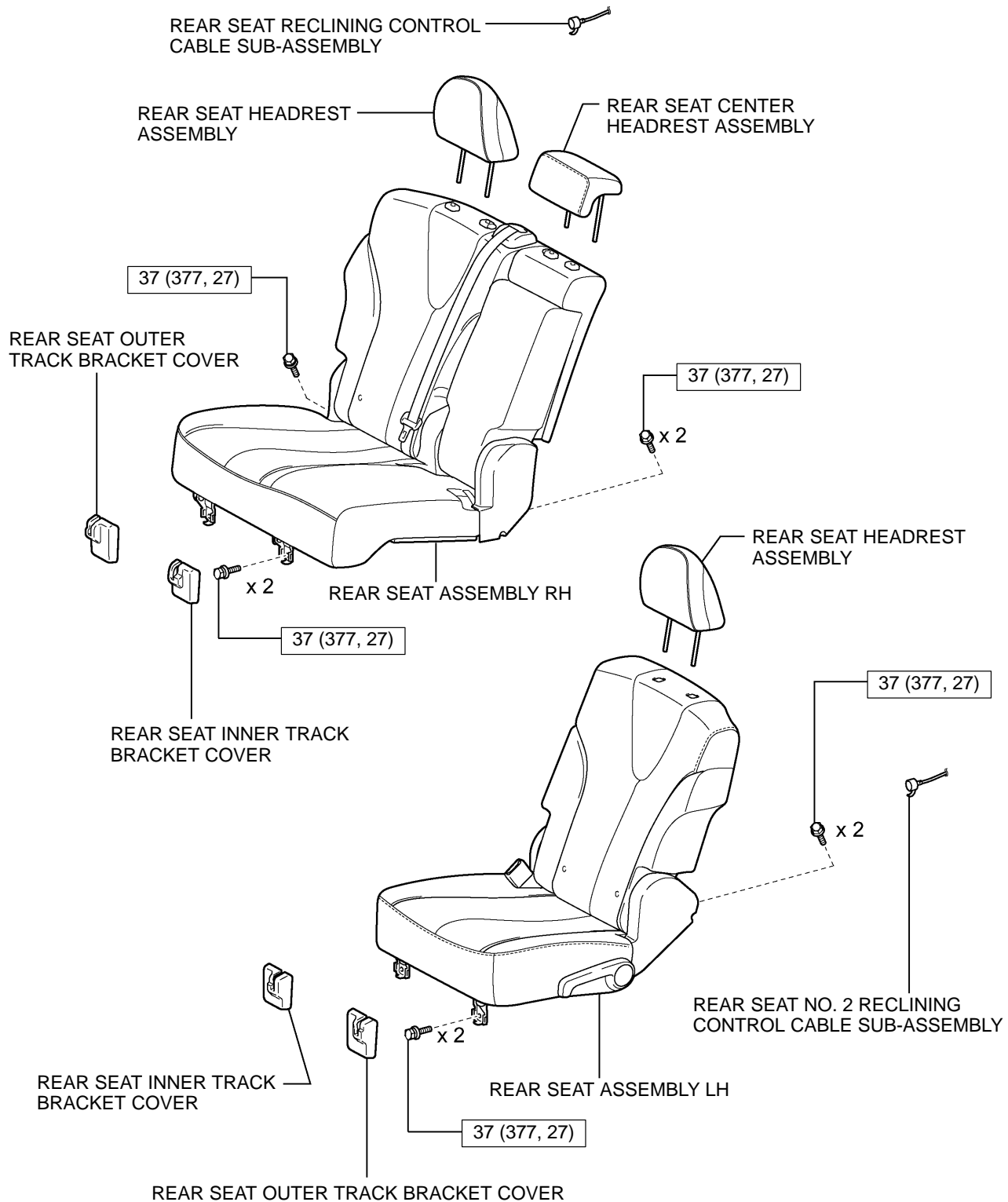


TELEVISION BASE

(e) FRONT SEAT**CAUTION:**

The bolts must be tightened to the torque specification, as they are related to vehicle safety during a collision.

N·m (kgf·cm, ft·lbf) : Specified torque

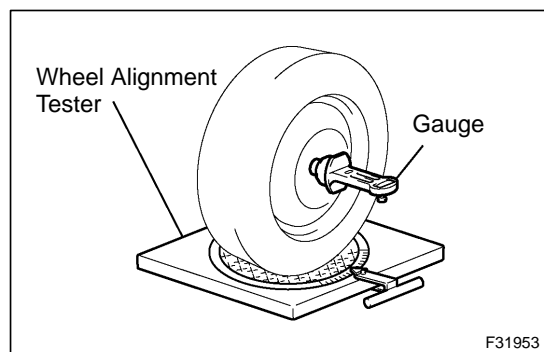
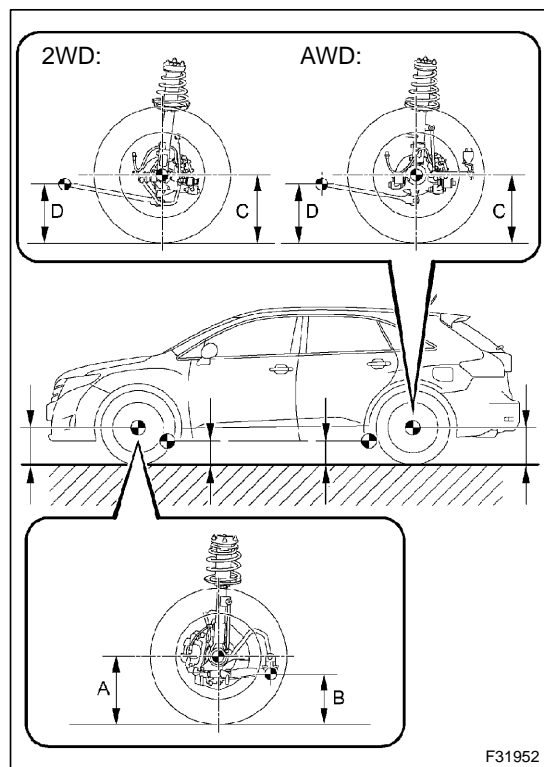
(f) REAR SEAT**CAUTION:**

The bolts must be tightened to the torque specification, as they are related to vehicle safety during a collision.

N·m (kgf·cm, ft·lbf) : Specified torque

5. WHEEL ALIGNMENT STANDARD

(a) FRONT WHEEL ALIGNMENT



(1) Vehicle height (Unloaded Vehicle):

Model	Front A – B	Rear C – D
2WD	117.7 mm (4.634 in.)	34.0 mm (1.338 in.)
AWD	117.8 mm (4.638 in.)	34.8 mm (1.370 in.)

NOTICE:

- Before inspecting the wheel alignment, adjust the vehicle height to the specified value.
- Be sure to perform measurement on a level surface.
- If it is necessary to go under the vehicle for measurement, confirm that the parking brake is applied and the vehicle is secured with chocks.

Measurement points:

A: Ground clearance of front wheel center

B: Ground clearance of No. 1 lower suspension arm bushing set bolt center

C: Ground clearance of rear wheel center

D: Ground clearance of strut rod set bolt center

(2) Camber (Unloaded Vehicle):

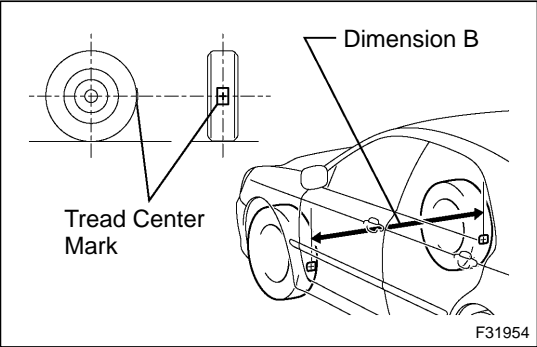
Model	Camber Inclination	Right-left Difference
2WD	0°36' +/-45' (0.60° +/-0.75°)	45' (0.75°) or less
AWD	-0°37' +/-45' (0.62° +/-0.75°)	

(3) Caster (Unloaded Vehicle):

Model	Caster Inclination	Right-left Difference
2WD	2°43' +/-45' (2.72° +/-0.75°)	45' (0.75°) or less
AWD	2°55' +/-45' (2.92° +/-0.75°)	

(4) Steering Axis Inclination (Unloaded Vehicle):

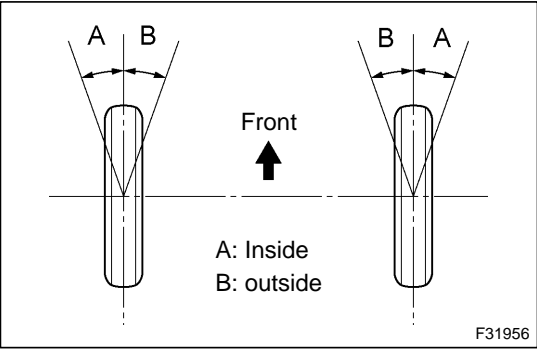
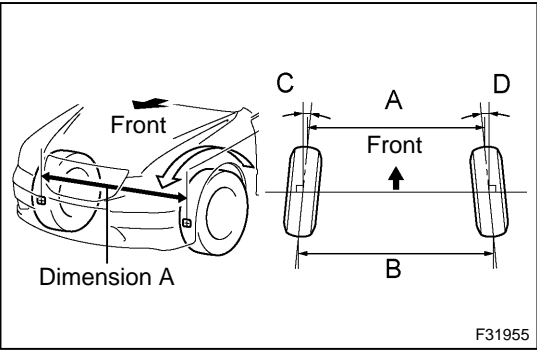
Model	Steering Axis Inclination
2WD	10°44' +/-45' (10.73° +/-0.75°)
AWD	10°45' +/-45' (10.75° +/-0.75°)



(5) Toe-in:

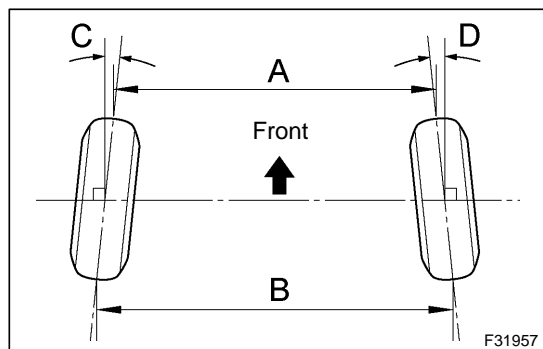
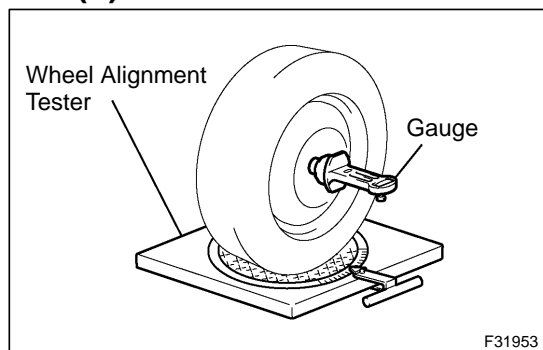
Item	Specified Condition
Toe-in (total)	C + D: 0°05' +/-12' (0.08° +/-0.2°) B – A: 1.0 +/-2 mm (0.0394 +/-0.0787 in.)

HINT:
Measure “B – A” only when “C + D” cannot be measured.



(6) Wheel Turning Angle (Unloaded Vehicle):

Model	Inside Wheel	Outside Wheel Reference
2WD	34°46' +/-2° (34.77° +/-2°)	31°03' (31.05°)
AWD	34°46' +/-2° (34.77° +/-2°)	31°03' (31.05°)

(b) REAR WHEEL ALIGNMENT**(1) Camber (Unloaded Vehicle):**

Model	Camber Inclination	Right-left Difference
2WD	$-1^{\circ}10' \pm 45'$ ($-1.17^{\circ} \pm 0.75^{\circ}$)	45' (0.75°) or less
AWD	$-0^{\circ}55' \pm 45'$ ($-0.92^{\circ} \pm 0.75^{\circ}$)	

HINT:

Camber is not adjustable. If the measurement is not within the specified range, inspect the suspension parts for damage and/or wear, and replace them if necessary.

(2) Toe-in (Unloaded Vehicle):

Model	Specified Condition	Right-left Difference
2WD	C + D: $0^{\circ}18' \pm 0^{\circ}10'$ ($0.30^{\circ} \pm 0.16^{\circ}$)	30' (0.50°) or less
	B – A: 3.6 \pm 2.0 mm (0.142 \pm 0.0787 in.)	—
AWD	C + D: $0^{\circ}21' \pm 0^{\circ}10'$ ($0.35^{\circ} \pm 0.16^{\circ}$)	30' (0.50°) or less
	B – A: 4.4 \pm 2.0 mm (0.173 \pm 0.0787 in.)	—

HINT:

Measure "B – A" only when "C + D" cannot be measured.

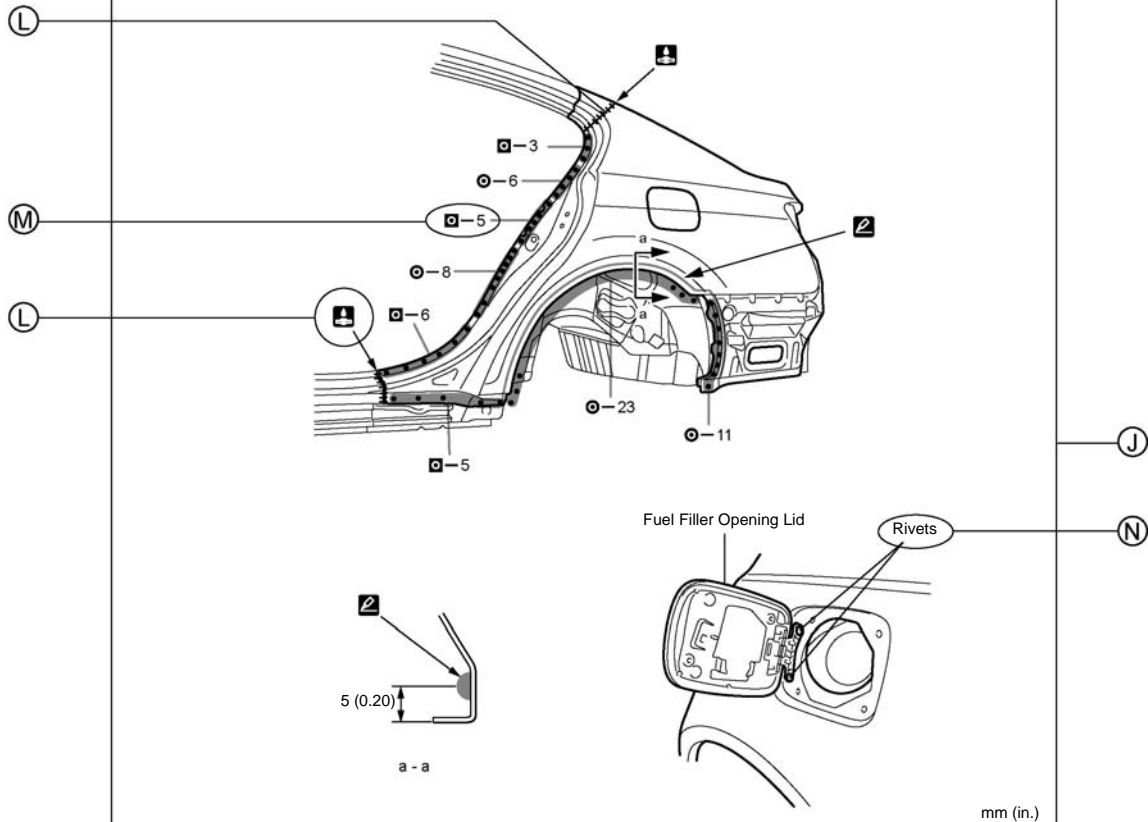
BP-36

BODY PANEL REPLACEMENT

Symbol meaning

⊙ : Spot Weld ⊠ M I : Plug Weld ⊞ : Butt Weld 2 : Body Sealer

INSTALLATION



INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 Before temporarily installing the new parts, apply body sealer to the wheel arch.
HINT:
 - 1) Apply body sealer evenly about 5 mm (0.20 in.) from the flange, avoiding any oozing.
 - 2) Apply body sealer evenly, about 3 – 4 mm (0.12 – 0.16 in.) in diameter.

① SYMBOL MEANING

② INSTALLATION DIAGRAM


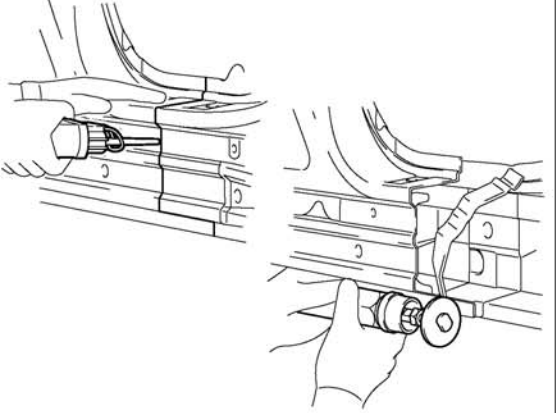




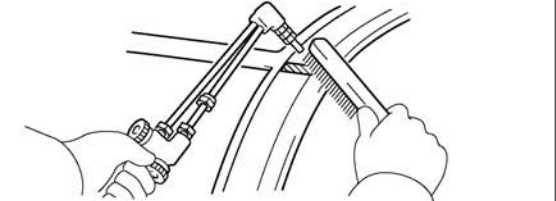

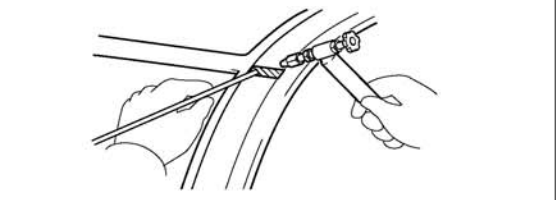
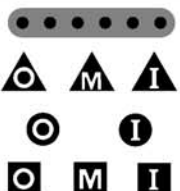
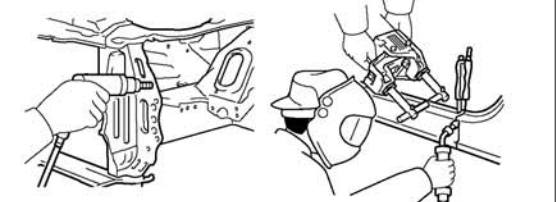

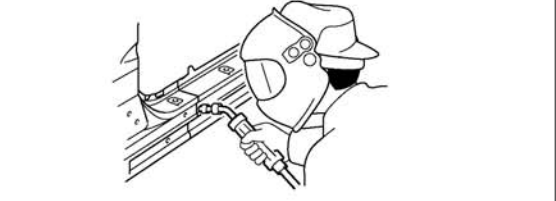



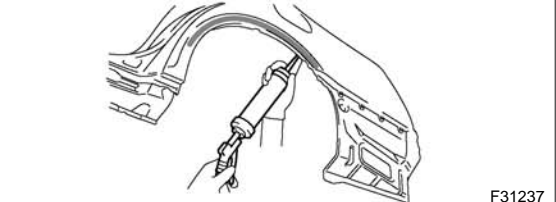
③ INSTALLATION GUIDE



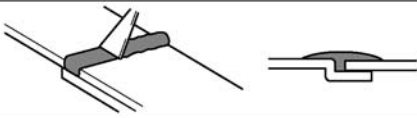

④ SYMBOLS (See page IN-34)

⑤ WELDING EXPLANATION (See page IN-36)

⑥ PART NAME

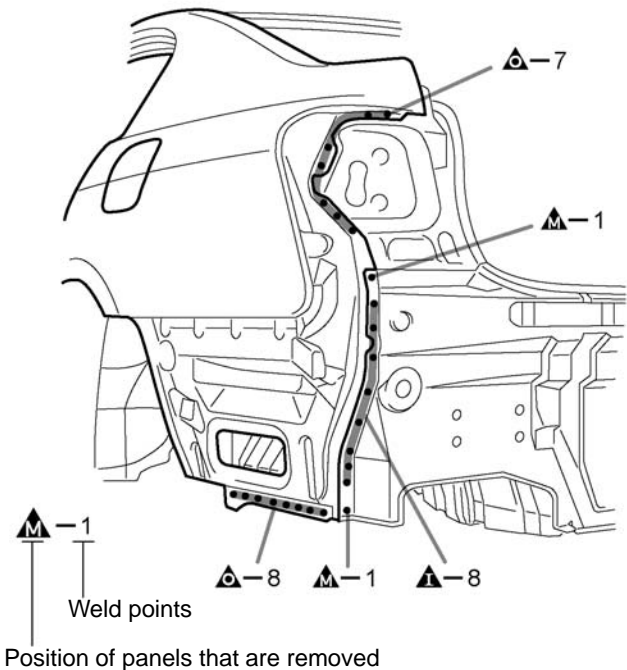
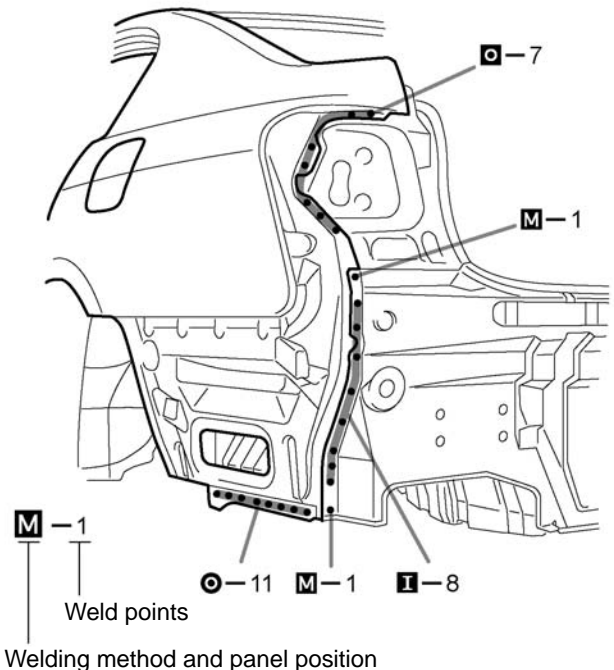
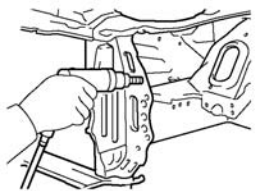
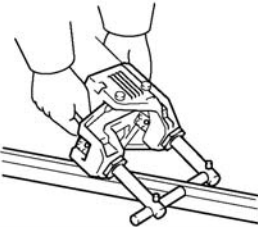
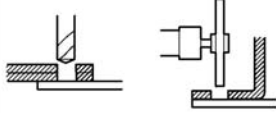

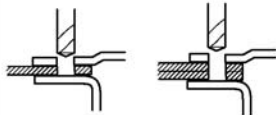
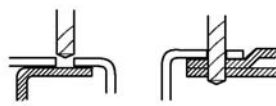
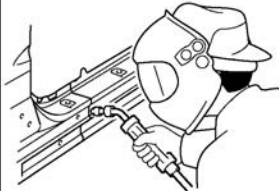
2. SYMBOLS

REPAIR AREA INDICATOR SYMBOLS		REPAIR METHOD INDICATOR SYMBOLS		ILLUSTRATION
-----	CUT		CUT AND JOIN LOCATION (SAW CUT)	
			CUT AND JOIN LOCATION (Cut Location for Supply Parts)	
			CUT LOCATION	
			CUT WITH DISC SANDER, ETC.	
////	BRAZE		BRAZING OR ARC BRAZING FOR REMOVAL	
oooo	BRAZE		BRAZE	
	WELD POINTS	—	SPOT WELD OR PLUG WELD (refer to "ILLUSTRATION OF WELD POINT SYMBOLS")	
++++	WELDING		BUTT WELD	
			FILLET WELD	
	BODY SEALER		BODY SEALER	

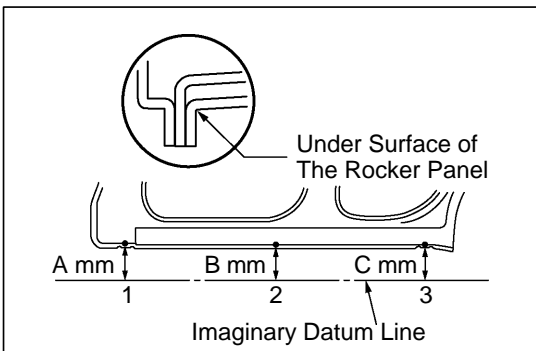
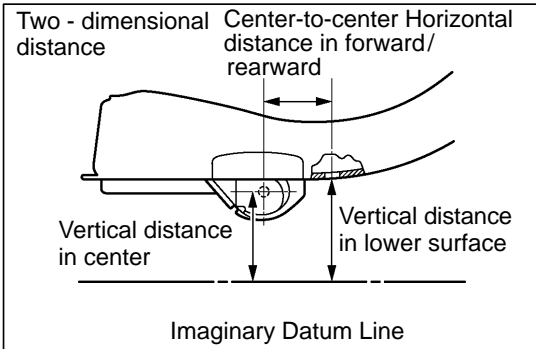
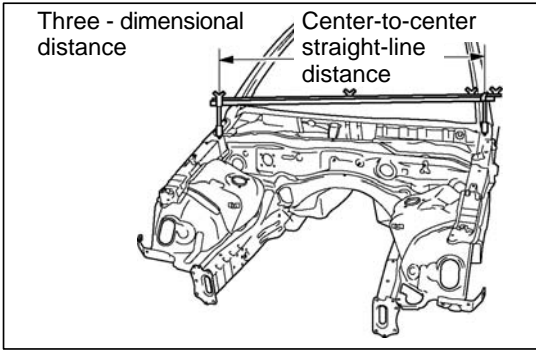
REPAIR AREA INDICATOR SYMBOLS		REPAIR METHOD INDICATOR SYMBOLS		ILLUSTRATION
—	ASSEMBLY MARK		STANDARD HOLE FOR INSTALLATION	—
	BODY SEALER	—	FLAT FINISHING	
—			NO FLAT FINISHING	

F31238

3. ILLUSTRATION OF WELD POINT SYMBOLS

REMOVAL			INSTALLATION		
 <p>Weld points</p> <p>Position of panels that are removed</p>			 <p>Weld points</p> <p>Welding method and panel position</p>		
SYMBOLS	MEANING	ILLUSTRATION	SYMBOLS	MEANING	ILLUSTRATION
▲	Remove Weld Points		●	Spot Welding	
○	Position of Panel Being Replaced is on Outside		■	Plug Welding	
M	Position of Panel Being Replaced is in Center				
I	Position of Panel Being Replaced is on Inside		+	Spot MIG Welding	

F31239

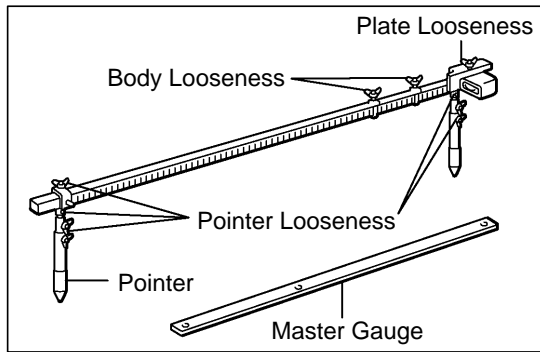


GENERAL INFORMATION

1. BASIC DIMENSIONS

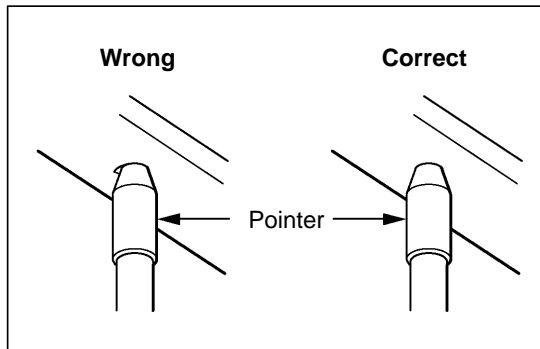
- (a) There are two types of dimensions in the diagram.
- (1) (Three - dimensional distance)
 - Straight-line distance between the centers of two measuring points.
 - (2) (Two - dimensional distance)
 - Horizontal distance in forward/rearward between the centers of two measuring points.
 - The height from an imaginary datum line.
- (b) In cases in which only one dimension is given, left and right are symmetrical.
- (c) The dimensions in the following drawing indicate actual distance. Therefore, please use the dimensions as a reference.
- (d) The line that connects the places listed below is the imaginary datum line when measuring the height. (The dimensions are printed in the text.)

SYMBOL	Name
1	The place that was lowered A mm from the under surface of the rocker panel centered on the front jack up point.
2	The place that was lowered B mm from the under surface of the rocker panel centered between 1 and 3.
3	The place that was lowered C mm from the under surface of the rocker panel centered on the rear jack up point.



2. MEASURING

- (a) Basically, all measurements are to be done with a tracking gauge. For portions where it is not possible to use a tracking gauge, a tape measure should be used.
- (b) Use only a tracking gauge that has no looseness in the body, measuring plate, or pointers.



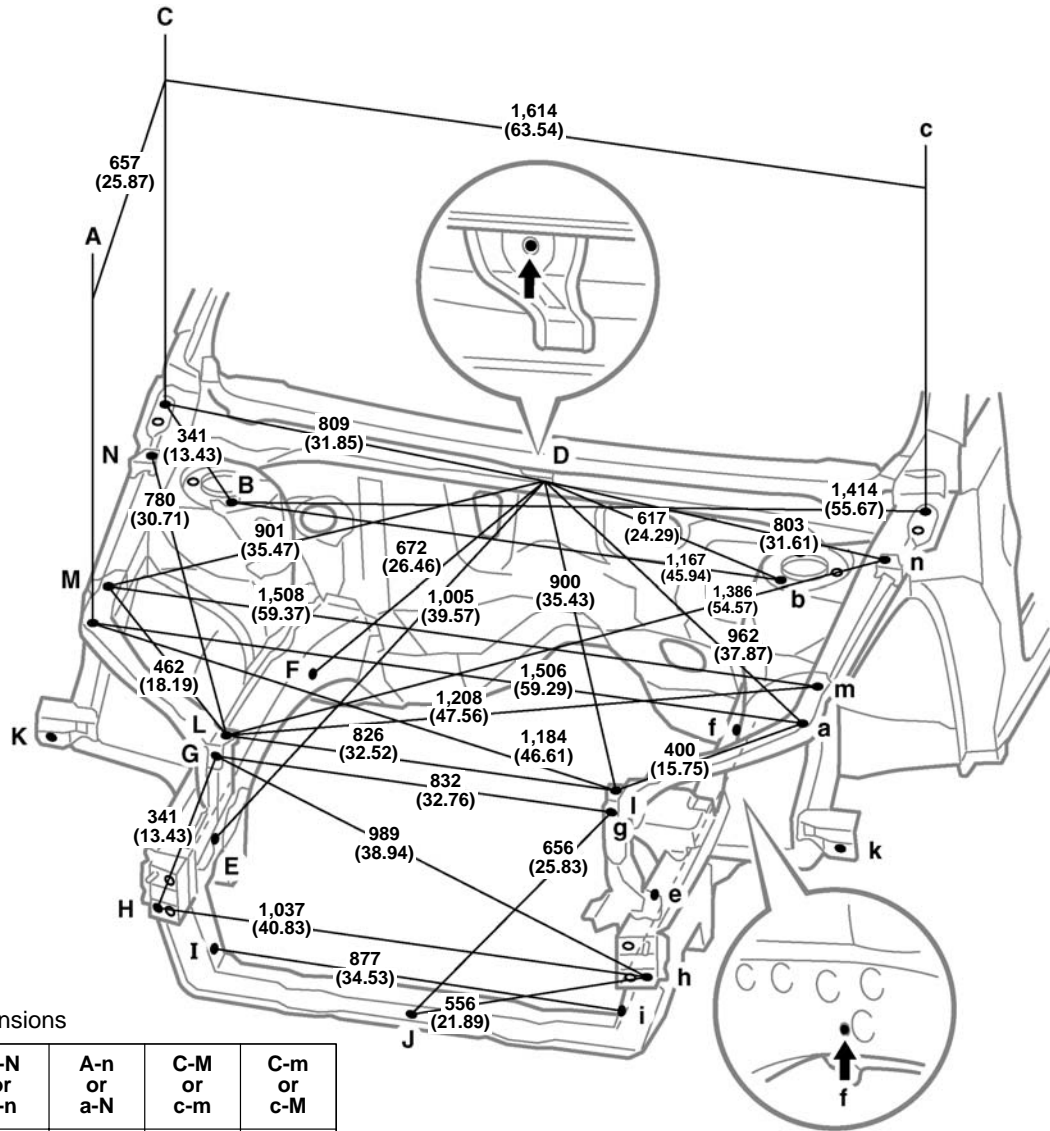
HINT:

- 1) *The height of left and right pointers must be equal.*
 - 2) *Always calibrate the tracking gauge before measuring or after adjusting the pointer height.*
 - 3) *Take care not to drop the tracking gauge or otherwise shock it.*
 - 4) *Confirm that the pointers are securely in the holes.*
- (c) When using a tape measure, avoid twists and bends in the tape.

BODY DIMENSION DRAWINGS

ENGINE COMPARTMENT

(Three - Dimensional Distance)



Vehicle Dimensions

A-c or a-C	A-N or a-n	A-n or a-N	C-M or c-m	C-m or c-M
1,692 (66.61)	480 (18.90)	1,619 (63.74)	552 (21.73)	1,655 (65.16)

D-e	D-f	K-k	N-n
1,003 (39.49)	683 (26.89)	1,675 (65.94)	1,588 (62.52)

Height from Imaginary Datum Line

A, a	C, c	H, h	L, l
783 (30.83)	892 (35.12)	361 (14.21)	683 (26.89)

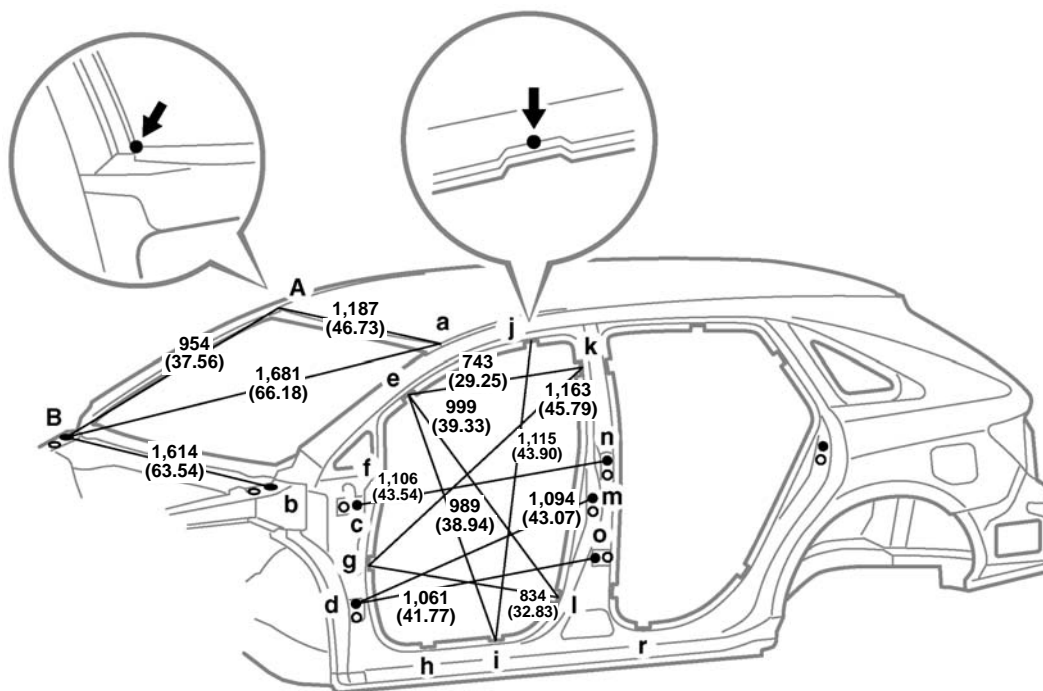
HINT: For symbols, capital letters indicate right side of vehicle, small letters indicate left side of vehicle (seen from rear).

mm (in.)

Symbol	Name	Hole dia.		
A, a	Front fender installation nut	M6 (0.24)	G, g	Radiator upper support installation nut M6 (0.24)
B, b	Front spring support hole (inner)	ø13 (0.51)	H, h	Front bumper reinforcement installation nut M10 (0.39)
C, c	Hood hinge installation nut	M8 (0.31)	I, i	Radiator side support standard hole ø10 (0.39)
D	Cowl body mounting stiffener standard hole	ø10 (0.39)	J	Hood lock support brace installation nut M6 (0.24)
E, e	Front side member standard hole	ø18 (0.71)	K, k	Radiator support to front fender bracket standard hole ø15 (0.59)
F, f	Front side member standard hole	RH: ø18 (0.71)	L, l	Radiator upper support installation nut M6 (0.24)
		LH: ø13 (0.51)	M, m	Front apron to cowl side upper member standard hole ø14 (0.55)
			N, n	Front fender installation nut M6 (0.24)

BODY OPENING AREAS (Side View: Front)

(Three - Dimensional Distance)



Vehicle Dimensions

E-e	F-f	G-g	H-h	I-i	J-j	K-k	L-l	M-m
1,395 (54.92)	1,580 (62.20)	1,559 (61.38)	1,532 (60.31)	1,532 (60.31)	1,254 (49.37)	1,377 (54.21)	1,541 (60.67)	1,690 (66.54)

C-M or c-m	E-g or e-G	E-i or e-I	E-k or e-K	G-k or g-K	G-l or g-L	H-r or h-R	I-j or i-J	K-l or k-L
1,050 (41.34)	1,608 (63.31)	1,765 (69.49)	1,573 (61.93)	1,871 (73.66)	1,760 (69.29)	1,760 (69.29)	1,779 (70.04)	1,698 (66.85)

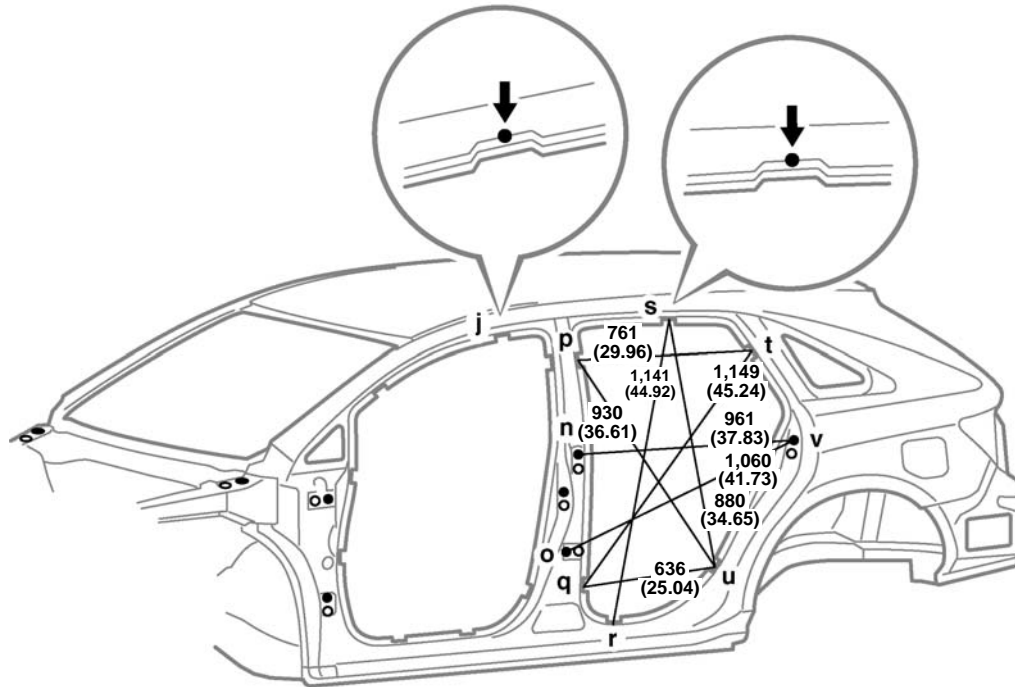
HINT: For symbols, capital letters indicate right side of vehicle, small letters indicate left side of vehicle (seen from rear).

mm (in.)

Symbol	Name	Hole dia.	I, i	Rocker panel assembly mark	—
A, a	Roof panel corner	—	J, j	Roof side rail assembly mark	—
B, b	Hood hinge installation nut	M8 (0.31)	K, k	Center body pillar assembly mark	—
C, c	Front door hinge installation nut	M8 (0.31)	L, l	Center body pillar assembly mark	—
D, d	Front door hinge installation nut	M8 (0.31)	M, m	Front door lock striker installation nut	M8 (0.31)
E, e	Front body pillar assembly mark	—	N, n	Rear door hinge installation nut	M8 (0.31)
F, f	Front body pillar assembly mark	—	O, o	Rear door hinge installation nut	M8 (0.31)
G, g	Front body pillar assembly mark	—	R, r	Rocker panel assembly mark	—
H, h	Rocker panel assembly mark	—	—	—	—

BODY OPENING AREAS (Side View: Rear)

(Three - Dimensional Distance)



Vehicle Dimensions

P-p	Q-q	R-r	S-s	T-t	U-u	V-v
1,398 (55.04)	1,541 (60.67)	1,532 (60.31)	1,247 (49.09)	1,402 (55.20)	1,555 (61.22)	1,650 (64.96)

J-s or j-S	P-t or p-T	P-u or p-U	Q-u or q-U	R-s or r-S	T-u or t-U
1,442 (56.77)	1,594 (62.76)	1,743 (68.62)	1,673 (65.87)	1,792 (70.55)	1,647 (64.84)

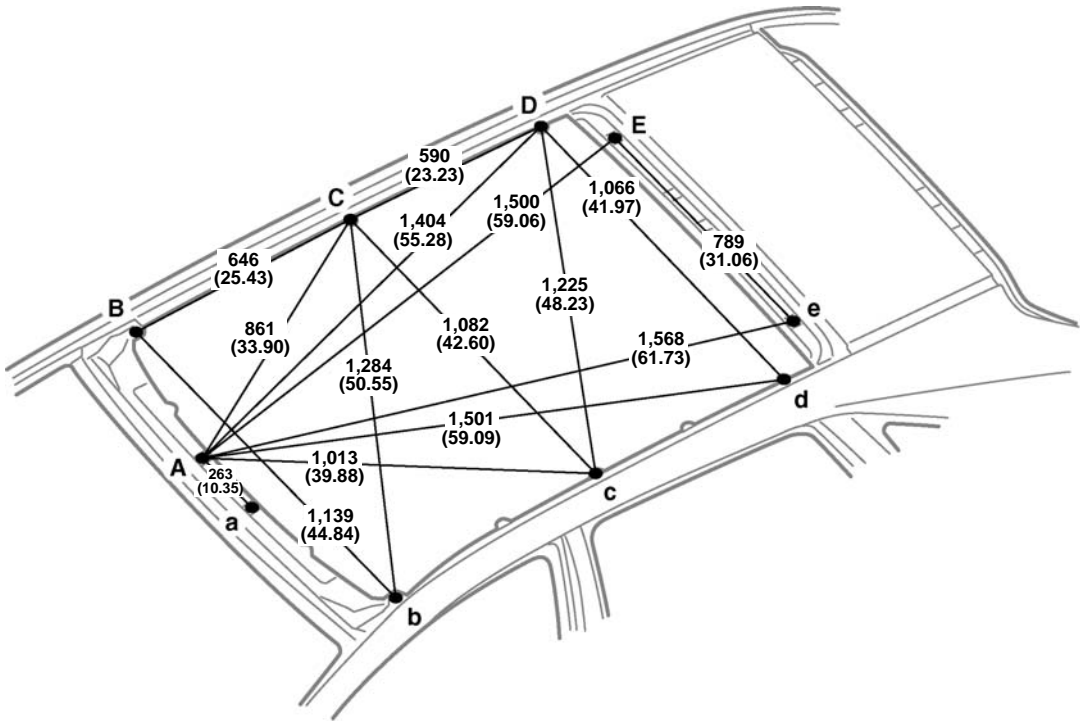
HINT: For symbols, capital letters indicate right side of vehicle, small letters indicate left side of vehicle (seen from rear).

mm (in.)

Symbol	Name	Hole dia.	R, r	Rocker panel assembly mark	—
J, j	Roof side rail assembly mark	—	S, s	Roof side rail assembly mark	—
N, n	Rear door hinge installation nut	M8 (0.31)	T, t	Quarter panel assembly mark	—
O, o	Rear door hinge installation nut	M8 (0.31)	U, u	Quarter panel assembly mark	—
P, p	Center body pillar assembly mark	—	V, v	Rear door lock striker installation nut	M8 (0.31)
Q, q	Center body pillar assembly mark	—	—	—	—

BODY OPENING AREAS (Top View)
w/ Sliding Roof

(Three - Dimensional Distance)



Vehicle Dimensions

B-E or b-e	B-e or b-E	C-E or c-e	C-e or c-E
1,376 (54.17)	1,671 (65.79)	735 (28.94)	1,180 (46.46)

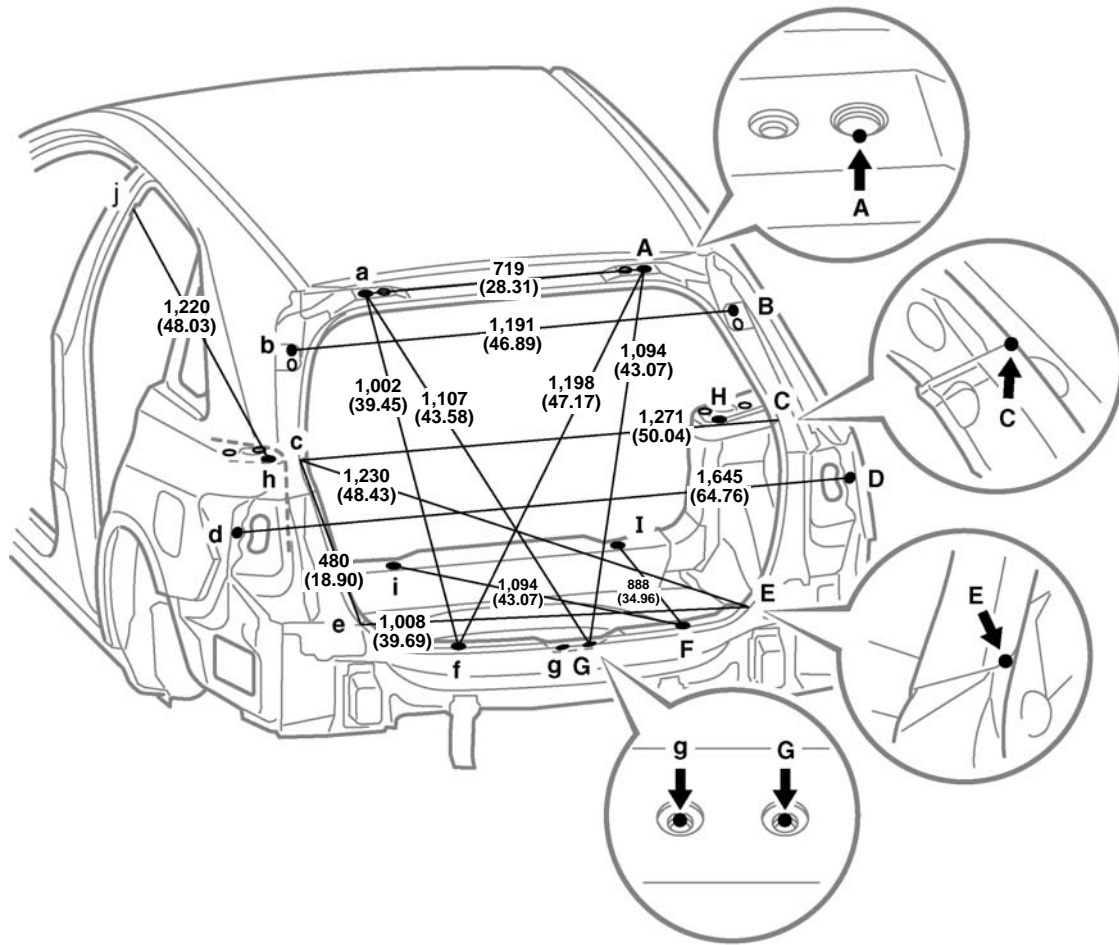
HINT: For symbols, capital letters indicate right side of vehicle, small letters indicate left side of vehicle (seen from rear).

mm (in.)

Symbol	Name	Hole dia.	C, c	Sliding roof installation hole	ø13 (0.51)
A, a	Sliding roof installation hole	ø13 (0.51)	D, d	Sliding roof installation hole	ø15 (0.59)
B, b	Sliding roof installation hole	16 x 18.5 (0.63 x 0.728)	E, e	Sliding roof installation hole	ø13 (0.51)

BODY OPENING AREAS (Rear View)

(Three - Dimensional Distance)



Vehicle Dimensions

F-f	H-h	H-j or h-J	I-i
600 (23.62)	1,194 (47.01)	1,777 (69.96)	680 (26.77)

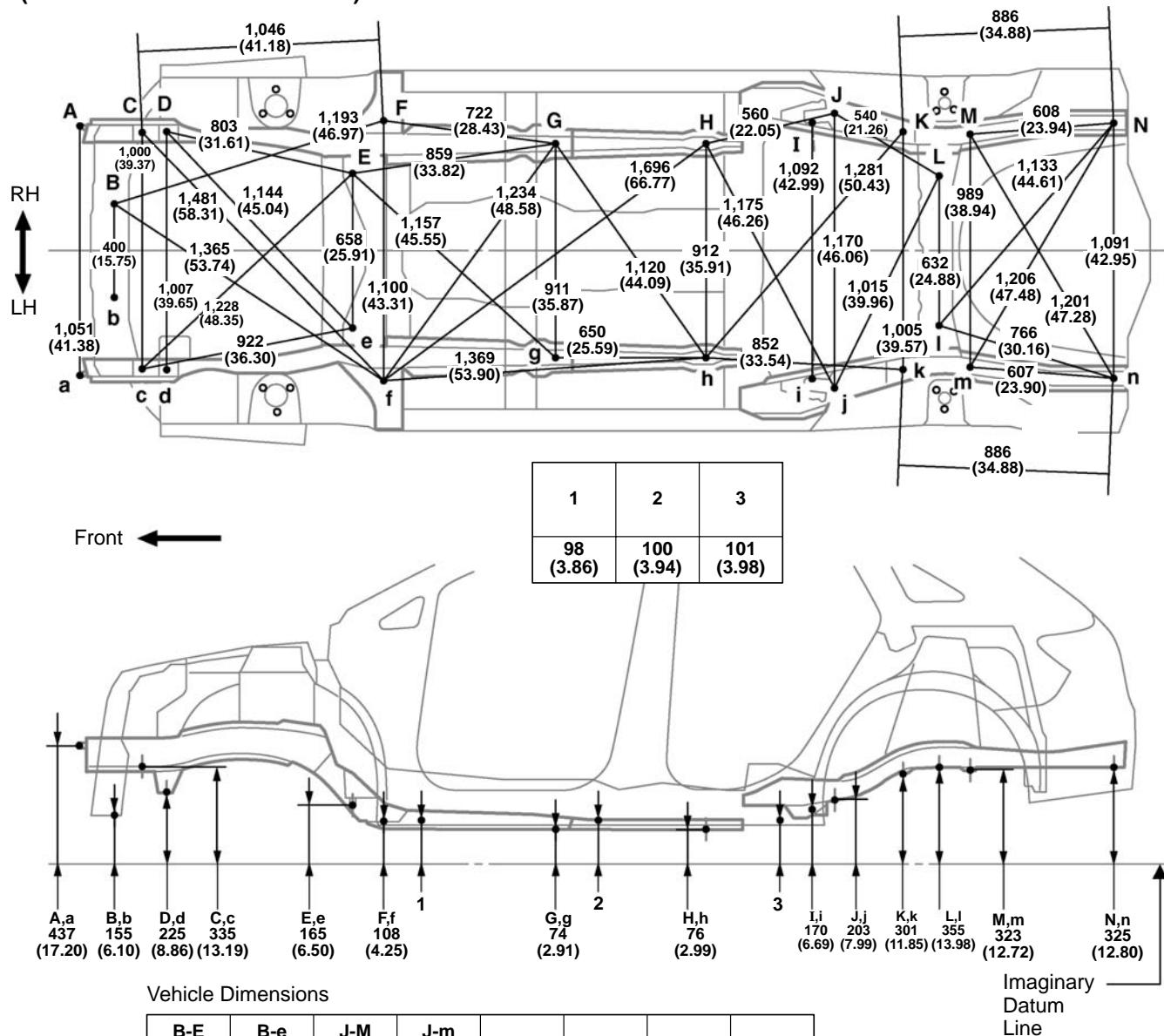
HINT: For symbols, capital letters indicate right side of vehicle, small letters indicate left side of vehicle (seen from rear).

mm (in.)

Symbol	Name	Hole dia.	F, f	Rear finish plate installation hole	ø8.5 (0.335)
A, a	Back door hinge installation hole	ø13 (0.51)	G, g	Back door lock striker installation nut	M8 (0.31)
B, b	Back door dumper stay installation nut	M6 (0.24)	H, h	Rear shock absorber installation hole	ø12.5
C, c	Roof side inner panel coner	—	I, i	Rear floor crossmember gusset standard hole	(0.492)
D, d	Quarter panel standard hole	ø13 (0.51)	J, j	Center body pillar assembly mark	ø13 (0.51)
E, e	Roof side inner panel coner	—	—	—	—

UNDER BODY 2WD

(Three - Dimensional Distance)



HINT:

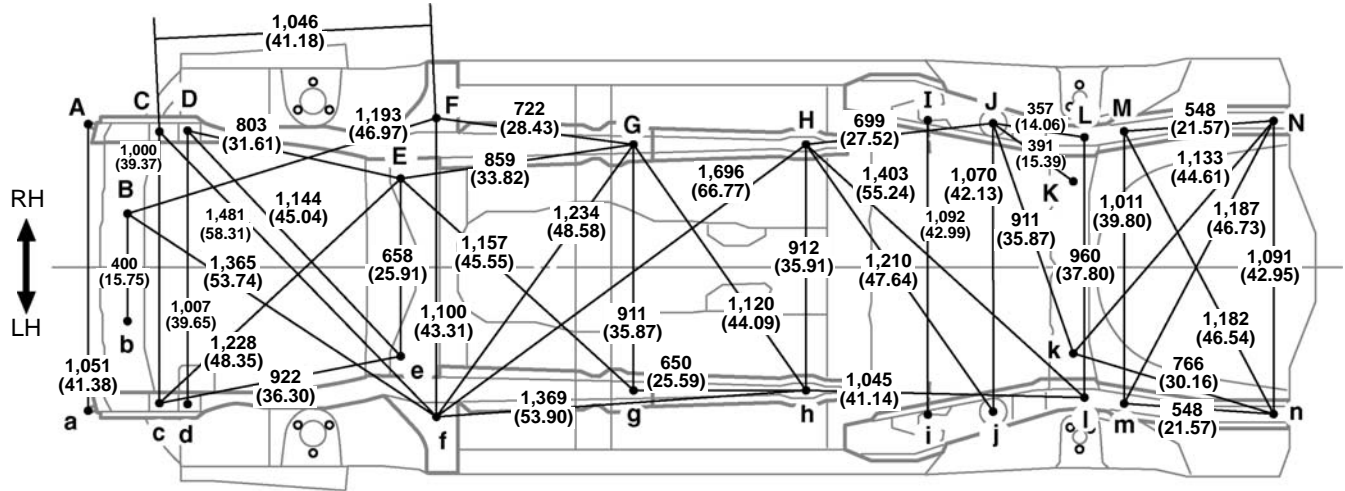
- 1) For symbols, capital letters indicate right side of vehicle, small letters indicate left side of vehicle (seen from rear).
- 2) Point N, n on the vehicle are asymmetrical.

mm (in.)

Symbol	Name	Hole dia.	H, h	Front floor under reinforcement standard hole	ø15 (0.59)
A, a	Front bumper reinforcement installation bolt	M6 (0.24)	I, i	Rear strut bar installation hole (inner)	ø12 (0.47)
B, b	Front crossmember standard hole	ø15 (0.59)	J, j	Rear floor side member standard hole	ø18 (0.71)
C, c	Front side member standard hole	ø18 (0.71)	K, k	Rear suspension member installation nut	M12 (0.47)
D, d	Front flame installation nut	M16 (0.63)	L, l	Rear floor crossmember No. 2 standard hole	ø15 (0.59)
E, e	Front flame installation nut	M16 (0.63)	M, m	Rear suspension member installation nut	M12 (0.47)
F, f	Front torque box standard hole	ø25 (0.98)	N, n	Transport hook installation nut	M10 (0.39)
G, g	Front side inner member standard hole	ø18 (0.71)	—	—	—

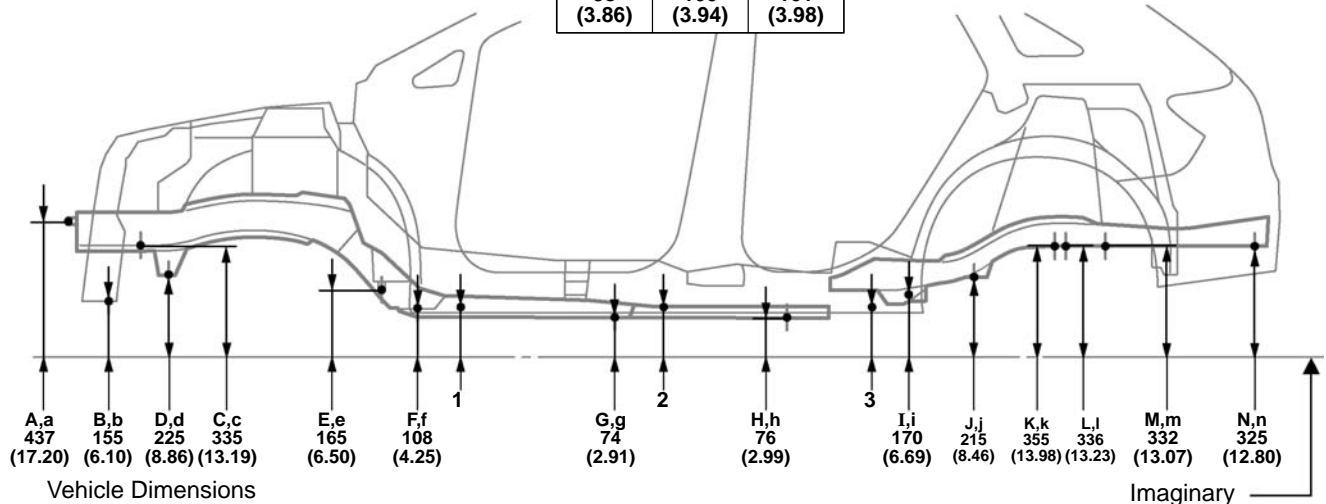
UNDER BODY AWD

(Three - Dimensional Distance)



Front ←

1	2	3
98 (3.86)	100 (3.94)	101 (3.98)



B-E or b-e	B-e or b-E	J-I or j-L	K-k	K-N	K-n	L-N	L-n	I-N	I-n
1,018 (40.08)	1,140 (44.88)	1,075 (42.32)	632 (24.88)	768 (30.24)	1,128 (44.41)	696 (27.40)	1,235 (48.62)	1,240 (48.82)	696 (27.40)

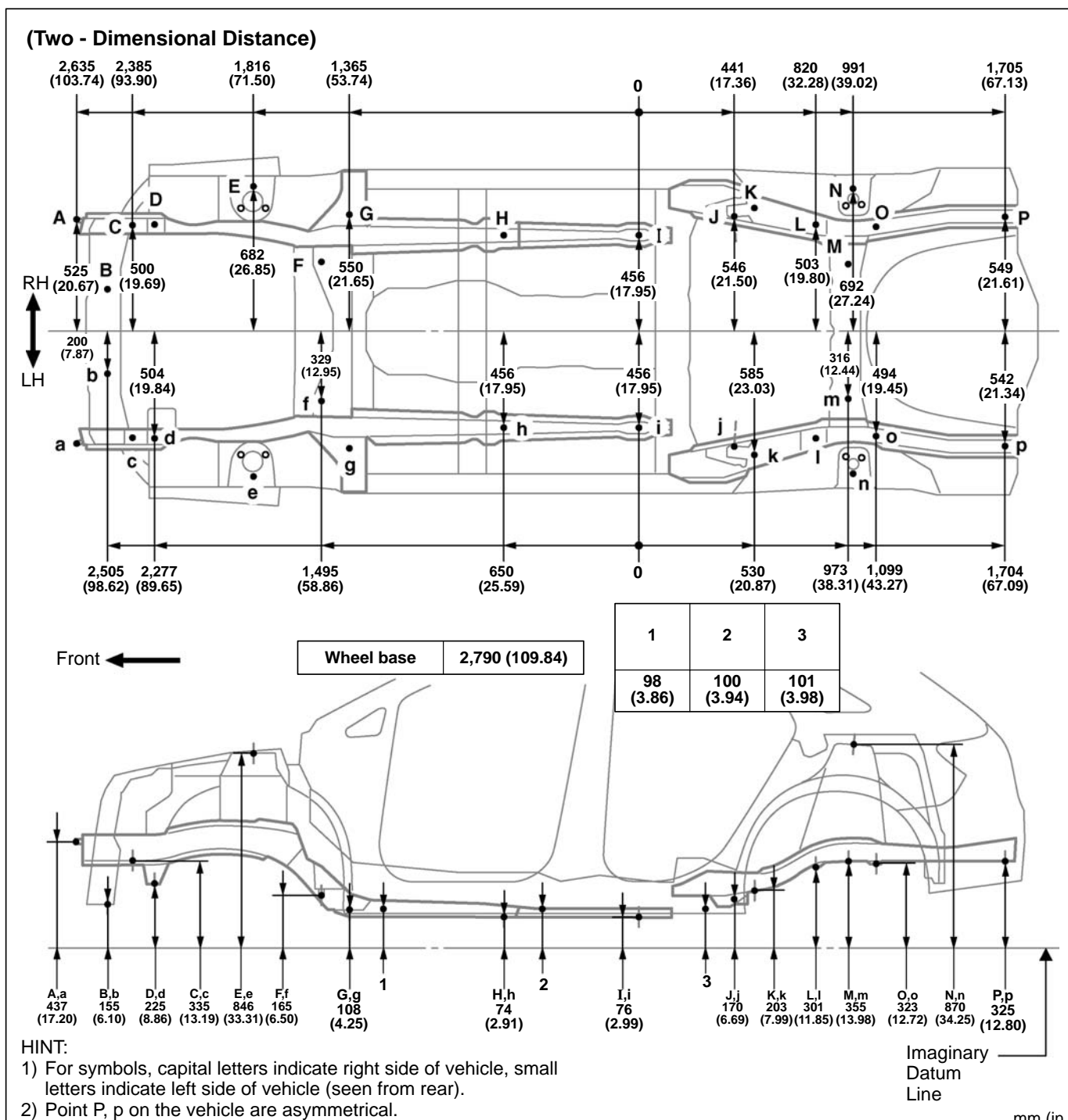
HINT:

- 1) For symbols, capital letters indicate right side of vehicle, small letters indicate left side of vehicle (seen from rear).
- 2) Point N, n on the vehicle are asymmetrical.

mm (in.)

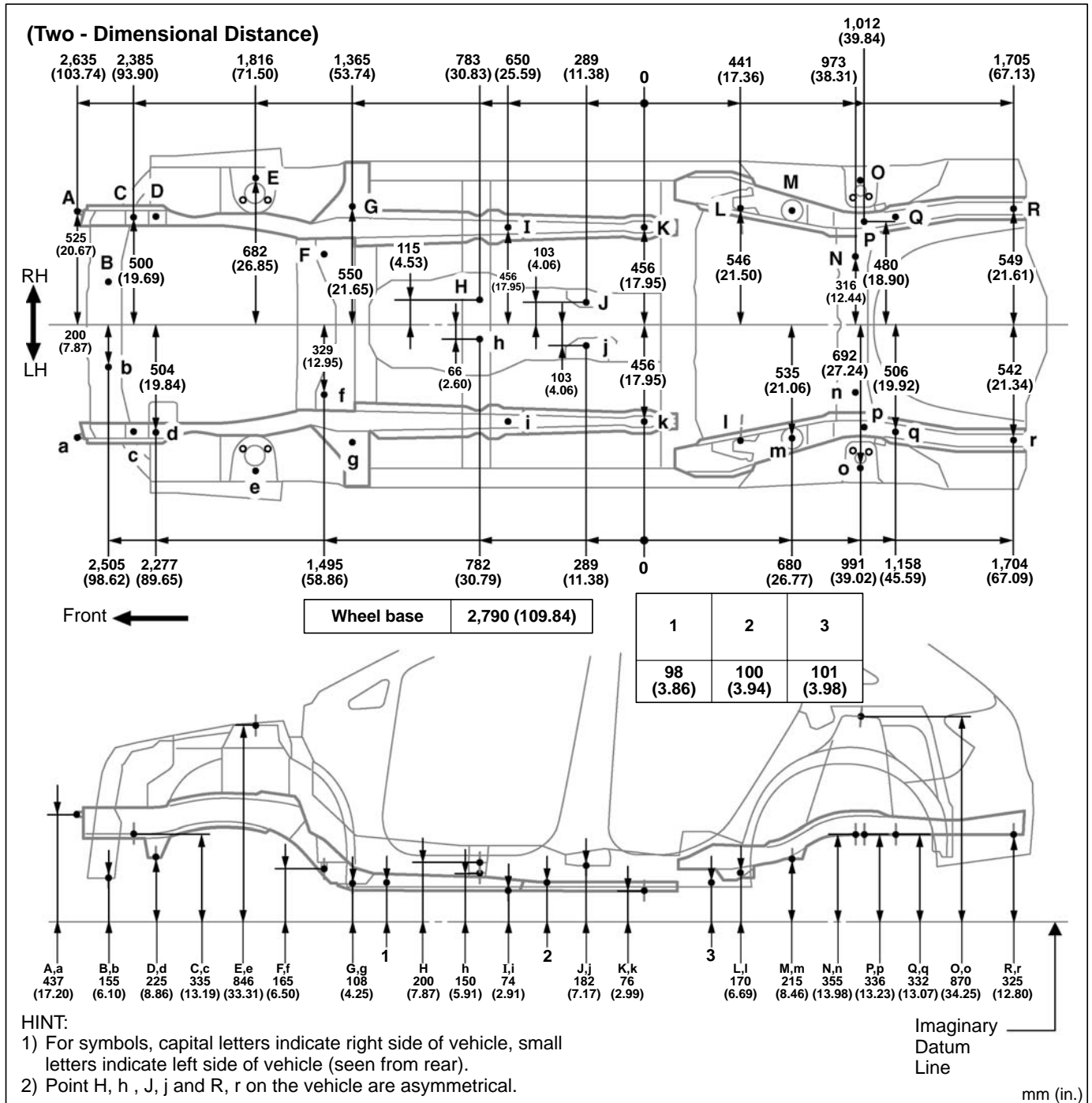
Symbol	Name	Hole dia.	H, h	Front floor under reinforcement standard hole	ø15 (0.59)
A, a	Front bumper reinforcement installation bolt	M6 (0.24)	I, i	Rear strut bar installation hole (inner)	ø12 (0.47)
B, b	Front crossmember standard hole	ø15 (0.59)	J, j	Rear suspension member installation nut	M14 (0.55)
C, c	Front side member standard hole	ø18 (0.71)	K, k	Rear floor crossmember No. 2 standard hole	ø15 (0.59)
D, d	Front flame installation nut	M16 (0.63)	L, l	Rear suspension member installation nut	M10 (0.39)
E, e	Front flame installation nut	M16 (0.63)	M, m	Rear suspension member installation nut	M10 (0.39)
F, f	Front torque box standard hole	ø25 (0.98)	N, n	Transport hook installation nut	M10 (0.39)
G, g	Front side inner member standard hole	ø18 (0.71)	—	—	—

UNDER BODY 2WD



Symbol	Name	Hole dia.	I, i	Front floor under reinforcement standard hole	ø15 (0.59)
A, a	Front bumper reinforcement installation bolt	M6 (0.24)	J, j	Rear strut bar installation hole (inner)	ø12 (0.47)
B, b	Front crossmember standard hole	ø15 (0.59)	K, k	Rear floor side member standard hole	ø18 (0.71)
C, c	Front side member standard hole	ø18 (0.71)	L, l	Rear suspension member installation nut	M12 (0.47)
D, d	Front flame installation nut	M16 (0.63)	M, m	Rear floor crossmember No. 2 standard hole	ø15 (0.59)
E, e	Front spring support installation hole	ø13 (0.51)	N, n	Rear shock absorber installation hole	ø12.5
F, f	Front flame installation nut	M16 (0.63)	O, o	Rear suspension member installation nut	(0.492)
G, g	Front torque box standard hole	ø25 (0.98)	P, p	Transport hook installation nut	M12 (0.47)
H, h	Front side inner member standard hole	ø18 (0.71)	—	—	M10 (0.39)

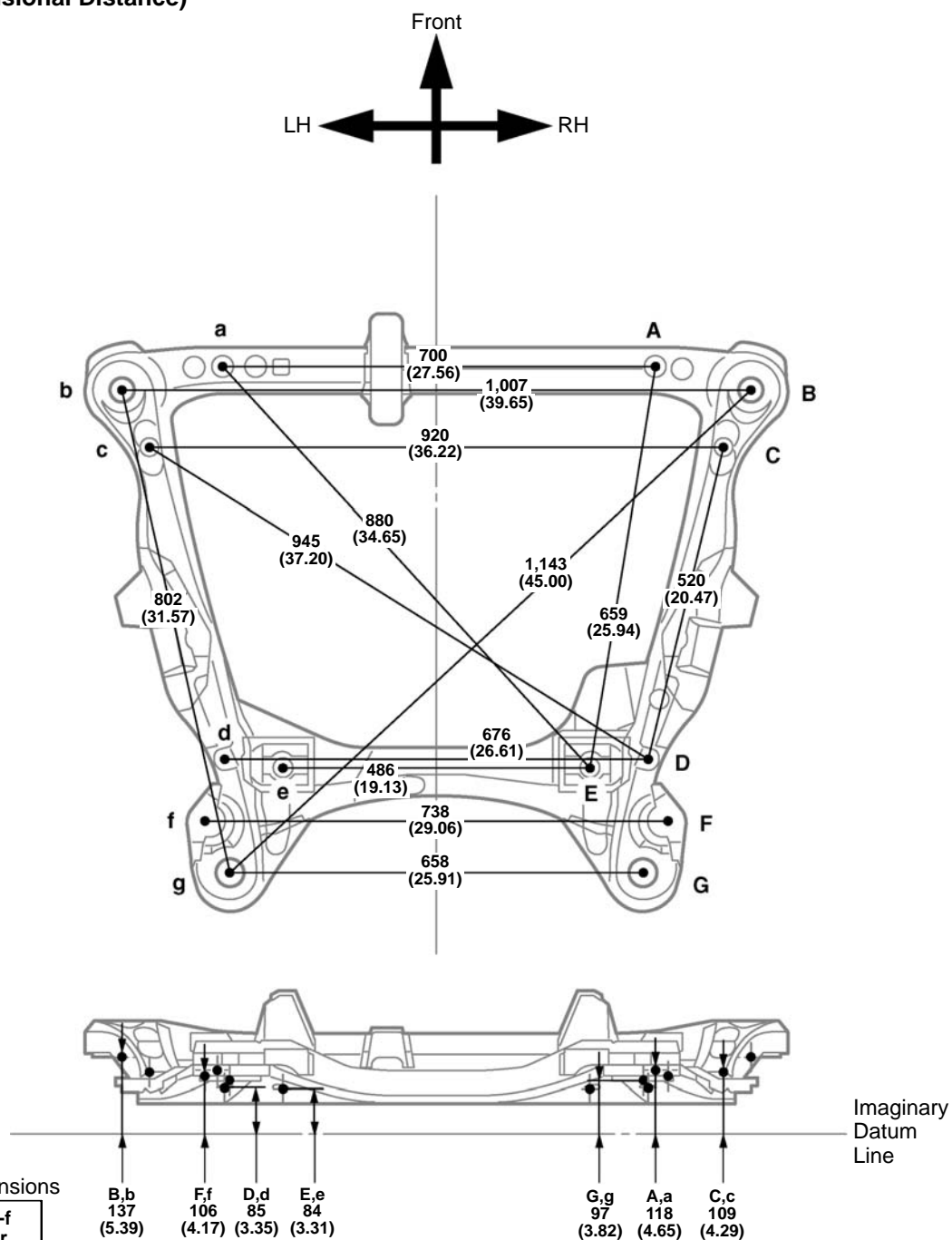
UNDER BODY AWD



Symbol	Name	Hole dia.	J, j	Propeller shaft center support bearing installation nut	M10 (0.39)
A, a	Front bumper reinforcement installation bolt	M6 (0.24)	K, k	Front floor under reinforcement standard hole	ø15 (0.59)
B, b	Front crossmember standard hole	ø15 (0.59)	L, l	Rear strut bar installation hole (inner)	ø12 (0.47)
C, c	Front side member standard hole	ø18 (0.71)	M, m	Rear suspension member installation nut	M14 (0.55)
D, d	Front flame installation nut	M16 (0.63)	N, n	Rear floor crossmember No. 2 standard hole	ø15 (0.59)
E, e	Front spring support installation hole	ø13 (0.51)	O, o	Rear shock absorber installation hole	ø12.5
F, f	Front flame installation nut	M16 (0.63)	P, p	Rear suspension member installation nut	(0.492)
G, g	Front torque box standard hole	ø25 (0.98)	Q, q	Rear suspension member installation nut	M10 (0.39)
H, h	Propeller shaft center support bearing installation nut	M10 (0.39)	R, r	Transport hook installation nut	M10 (0.39)
I, i	Front side inner member standard hole	ø18 (0.71)	—	—	M10 (0.39)

FRONT FRAME

(Three - Dimensional Distance)



HINT: For symbols, capital letters indicate right side of vehicle, small letters indicate left side of vehicle (seen from rear).

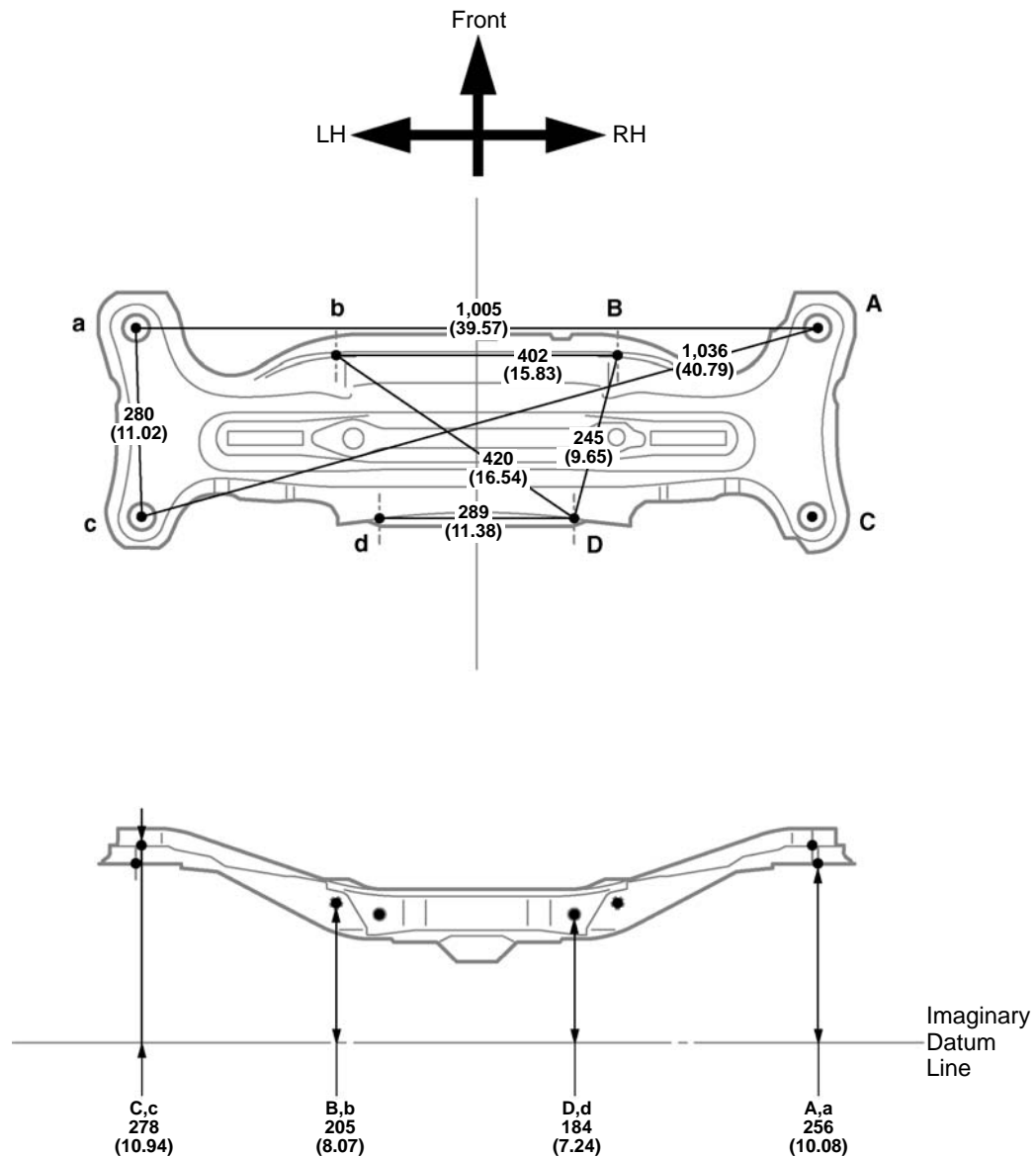
mm (in.)

Symbol	Name	Hole dia.	D, d	Front frame standard hole	ø13 (0.51)
A, a	Front frame standard hole	ø13 (0.51)	E, e	Front frame standard hole	ø13 (0.51)
B, b	Front frame installation hole	ø62 (2.44)	F, f	Lower arm installation hole	ø15 (0.59)
C, c	Front frame standard hole	ø13 (0.51)	G, g	Front frame installation hole	ø67.5 (2.66)

REAR SUSPENSION MEMBER

2WD

(Three - Dimensional Distance)



Vehicle Dimensions

C-c
989 (38.94)

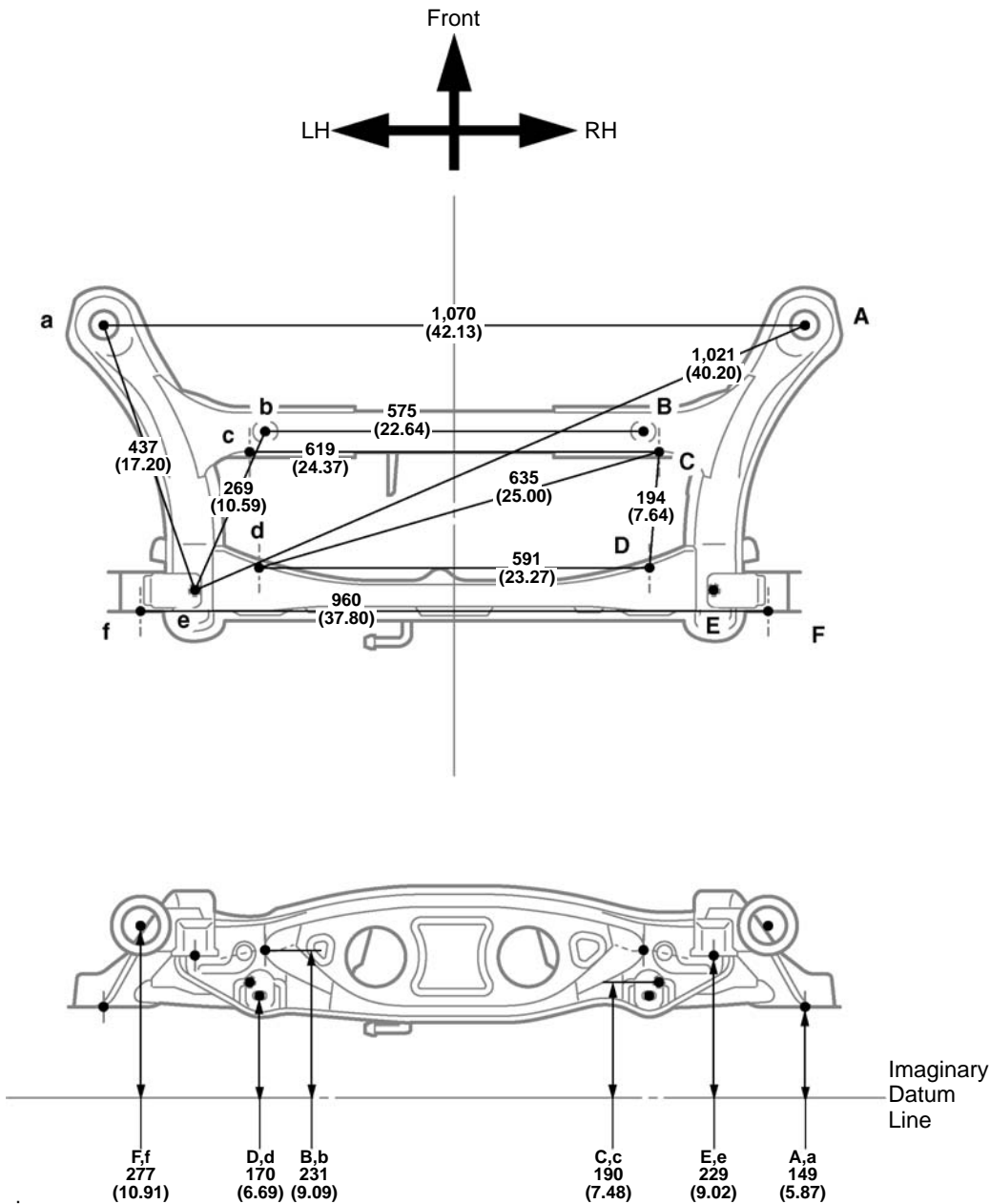
HINT: For symbols, capital letters indicate right side of vehicle, small letters indicate left side of vehicle (seen from rear).

mm (in.)

Symbol	Name	Hole dia.	C, c	Rear suspension member installation hole	ø38 (1.49)
A, a	Rear suspension member installation hole	ø38 (1.49)	D, d	Lower control arm installation hole	ø16 (0.62)
B, b	Lower control arm installation hole	ø16 (0.62)	—	—	—

REAR SUSPENSION MEMBER
AWD

(Three - Dimensional Distance)



Vehicle Dimensions

B-e or b-E	E-e
728 (28.66)	796 (31.34)

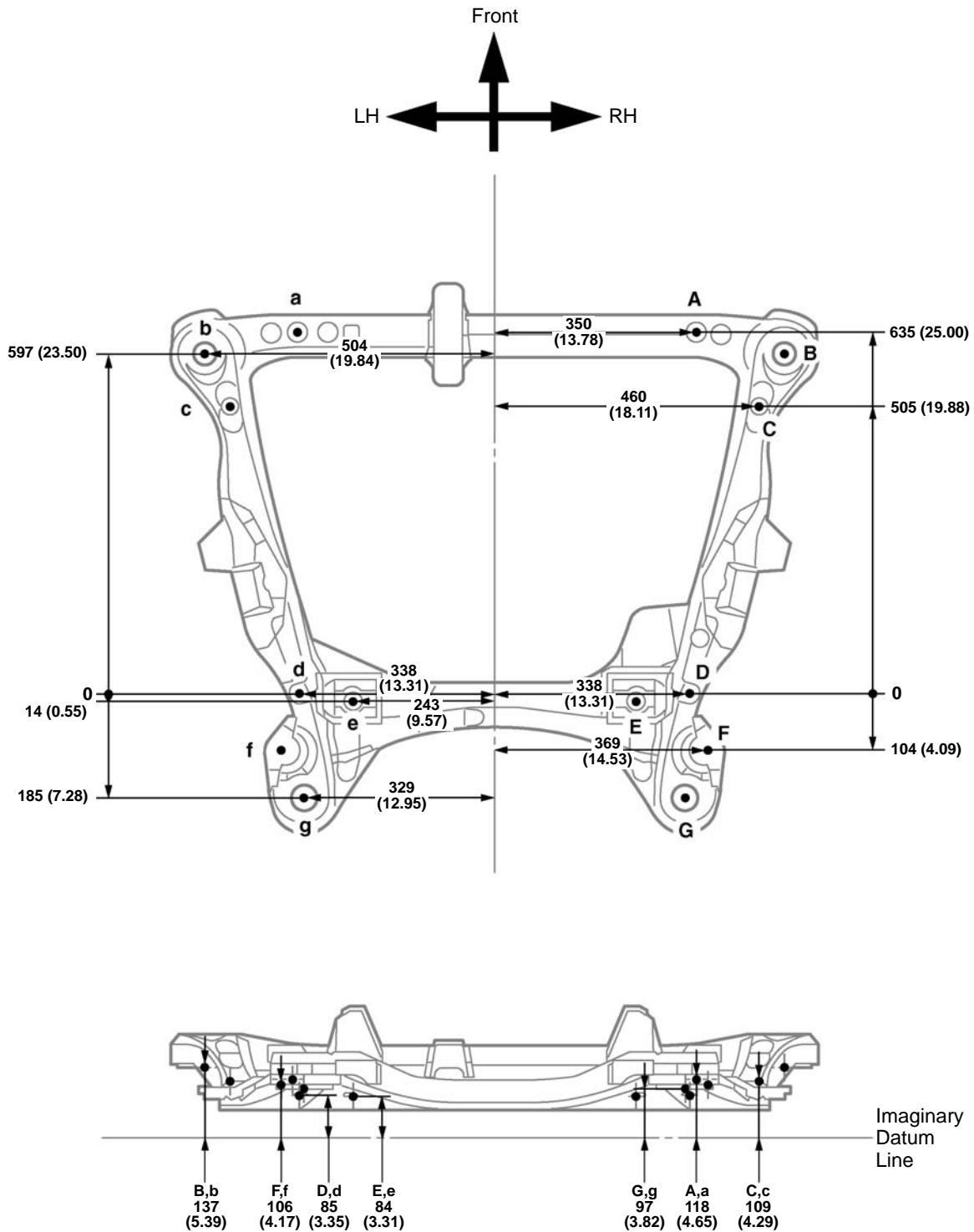
HINT: For symbols, capital letters indicate right side of vehicle, small letters indicate left side of vehicle (seen from rear).

mm (in.)

Symbol	Name	Hole dia.	D, d	Lower control arm installation hole	22.5 x 14.5 (0.886 x 0.571)
A, a	Rear suspension member installation hole	ø64 (2.52)	E, e	Rear suspension member standard hole	ø15 (0.59)
B, b	Rear suspension member standard hole	ø9 (0.35)	F, f	Rear suspension member installation hole	ø64 (2.52)
C, c	Lower control arm installation hole	ø12.5	—	—	—

FRONT FRAME

(Two - Dimensional Distance)

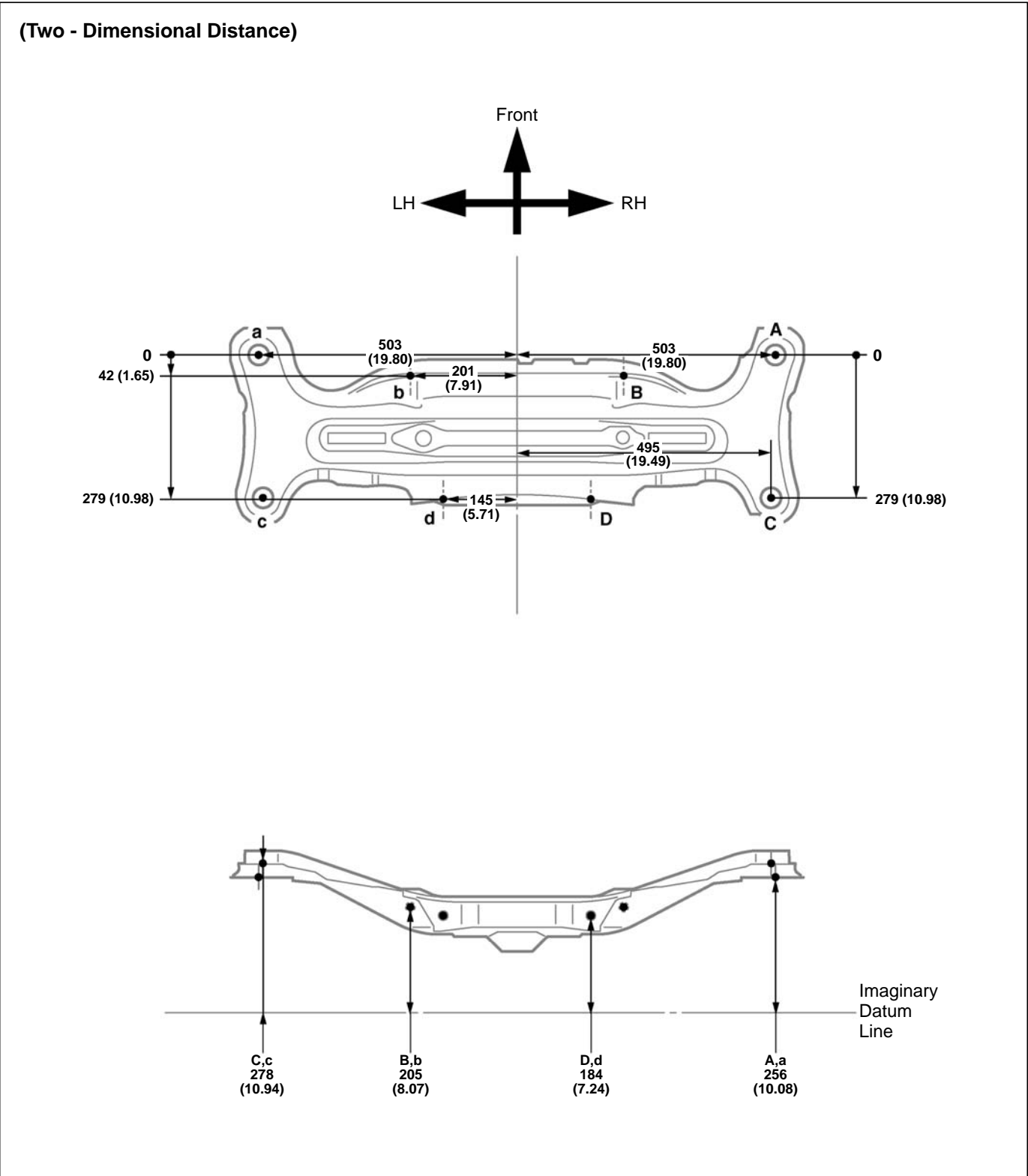


HINT: For symbols, capital letters indicate right side of vehicle, small letters indicate left side of vehicle (seen from rear).

mm (in.)

Symbol	Name	Hole dia.	D, d	Front frame standard hole	ø13 (0.51)
A, a	Front frame standard hole	ø13 (0.51)	E, e	Front frame standard hole	ø13 (0.51)
B, b	Front frame installation hole	ø62 (2.44)	F, f	Lower arm installation hole	ø15 (0.59)
C, c	Front frame standard hole	ø13 (0.51)	G, g	Front frame installation hole	ø67.5 (2.66)

REAR SUSPENSION MEMBER
2WD

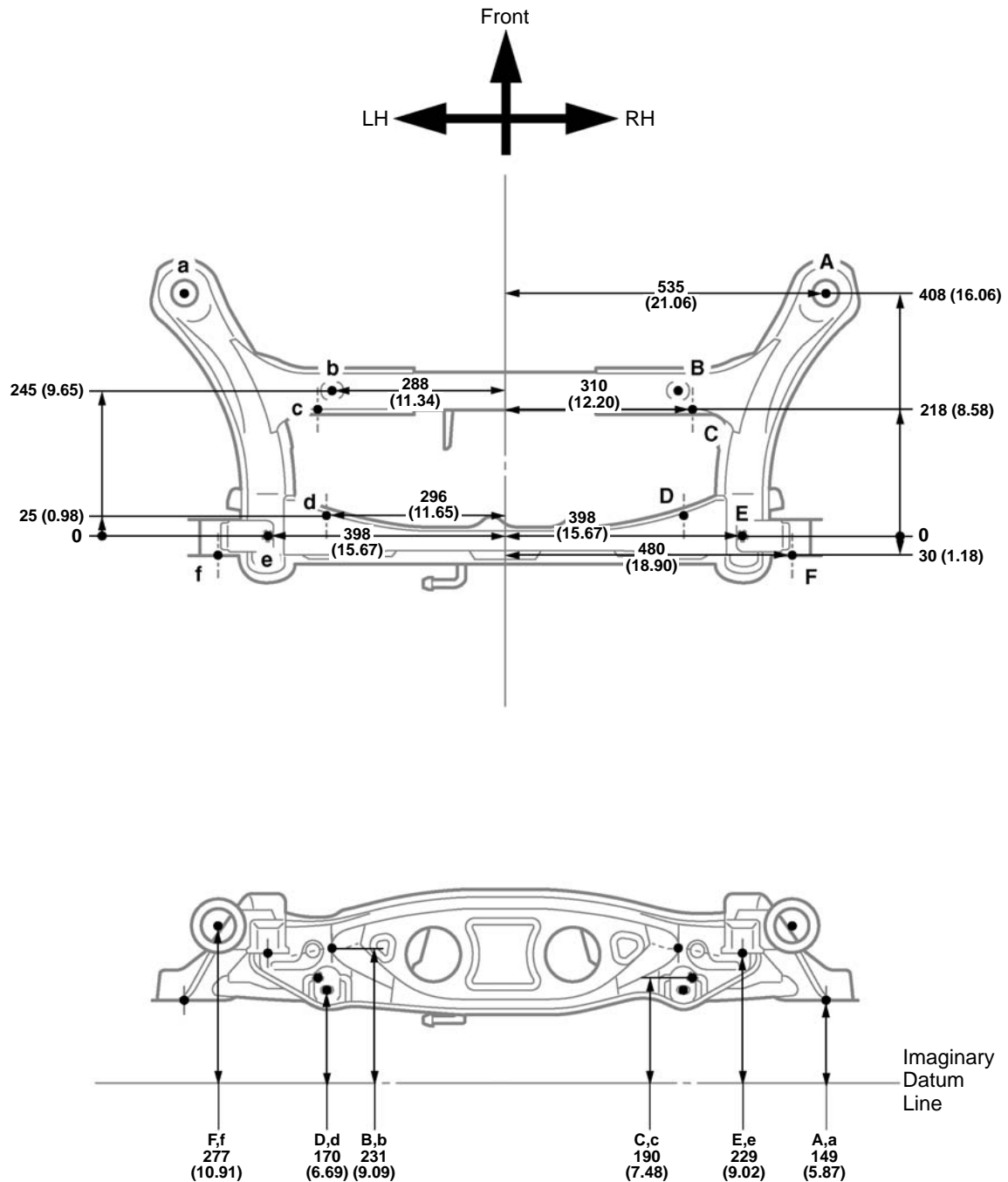


HINT: For symbols, capital letters indicate right side of vehicle, small letters indicate left side of vehicle (seen from rear).

mm (in.)

Symbol	Name	Hole dia.	C, c	Rear suspension member installation hole	ø38 (1.49)
A, a	Rear suspension member installation hole	ø38 (1.49)	D, d	Lower control arm installation hole	ø16 (0.62)
B, b	Lower control arm installation hole	ø16 (0.62)	—	—	—

(Two - Dimensional Distance)



HINT: For symbols, capital letters indicate right side of vehicle, small letters indicate left side of vehicle (seen from rear).

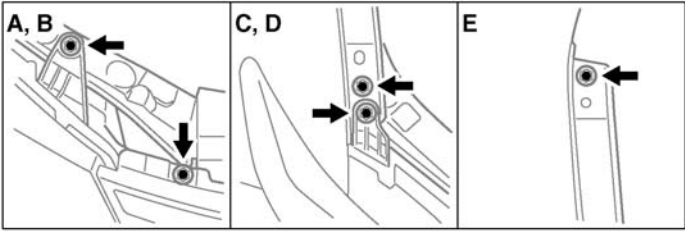
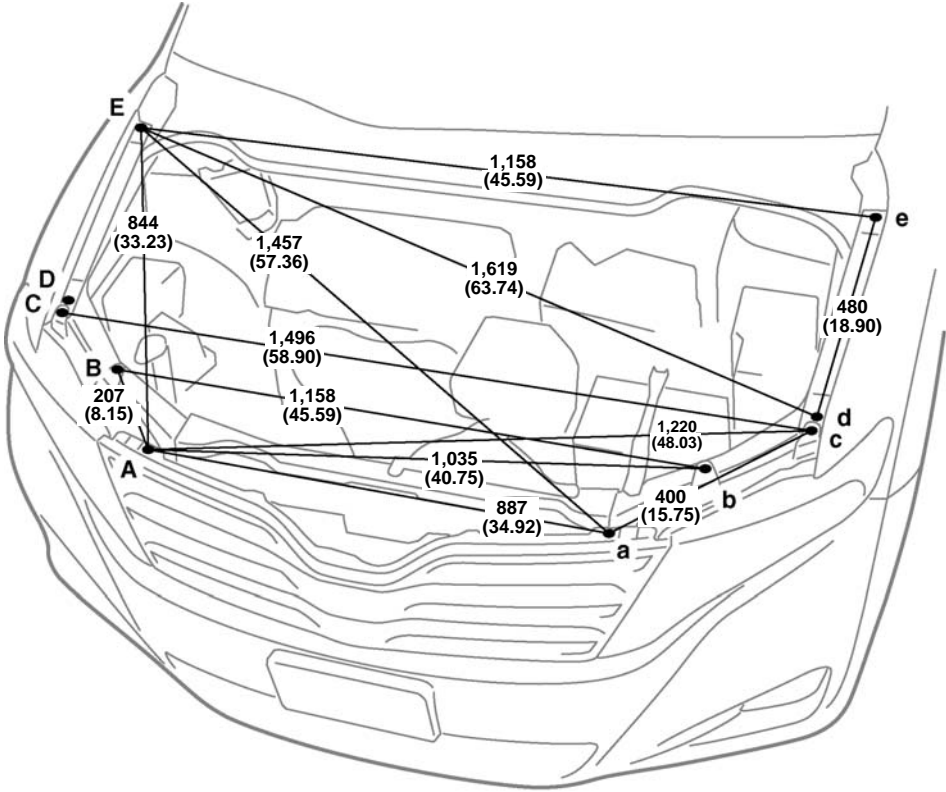
mm (in.)

Symbol	Name	Hole dia.	D, d	Lower control arm installation hole	22.5 x 14.5 (0.886 x 0.571)
A, a	Rear suspension member installation hole	ø64 (2.52)	E, e	Rear suspension member standard hole	ø15 (0.59)
B, b	Rear suspension member standard hole	ø9 (0.35)	F, f	Rear suspension member installation hole	ø64 (2.52)
C, c	Lower control arm installation hole	ø12.5	—	—	—

(0.492)

REFERENCE VALUE
ENGINE COMPARTMENT

(Three - Dimensional Distance)



Vehicle Dimensions

B-E or b-e	B-e or b-E	C-E or c-e	C-e or c-E	D-d
650 (25.59)	1,504 (59.21)	512 (20.16)	1,624 (63.94)	1,506 (59.29)

HINT:

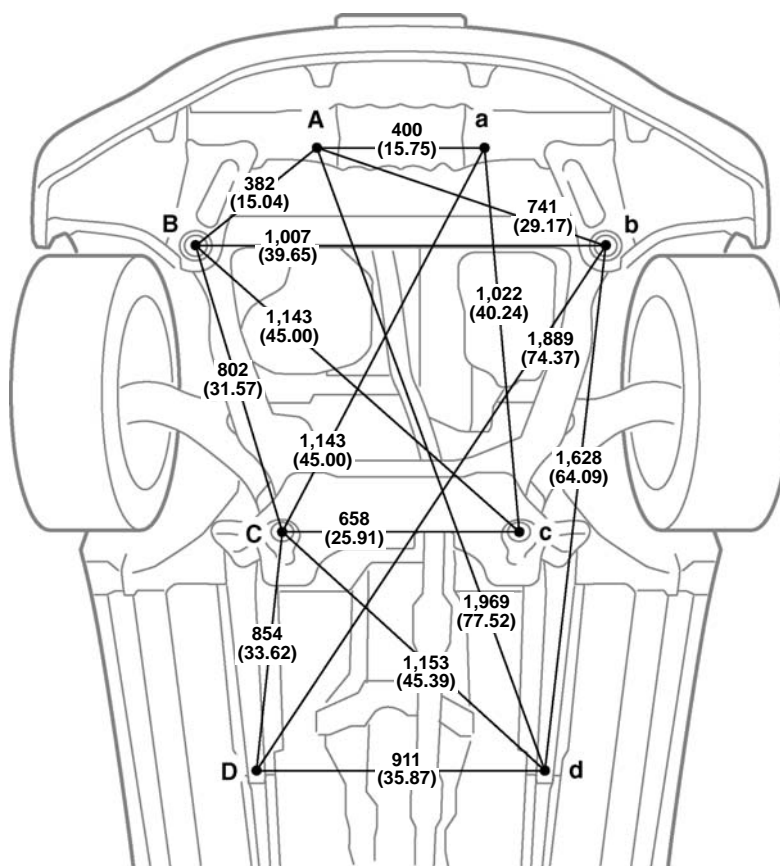
- 1) For symbols, capital letters indicate right side of vehicle, small letters indicate left side of vehicle (seen from rear).
- 2) These values are actual measurements made on model. Use these reference values.
- 3) Measure points with the radiator support opening cover and front fender upper protector removed.

mm (in.)

Symbol	Name	Hole dia.	C, c	Headlight installation bolt	—
A, a	Radiator grille installation bolt	—	D, d	Front fender installation bolt	—
B, b	Headlight installation bolt	—	E, e	Front fender installation bolt	—

UNDER BODY

(Three - Dimensional Distance)



Vehicle Dimensions

A-D or a-d
1,874 (73.78)

HINT:

- 1) For symbols, capital letters indicate right side of vehicle, small letters indicate left side of vehicle (seen from rear).
- 2) These values are actual measurements made on model. Use these reference values.
- 3) Measure points with the engine under cover NO. 1 and front floor cover removed.

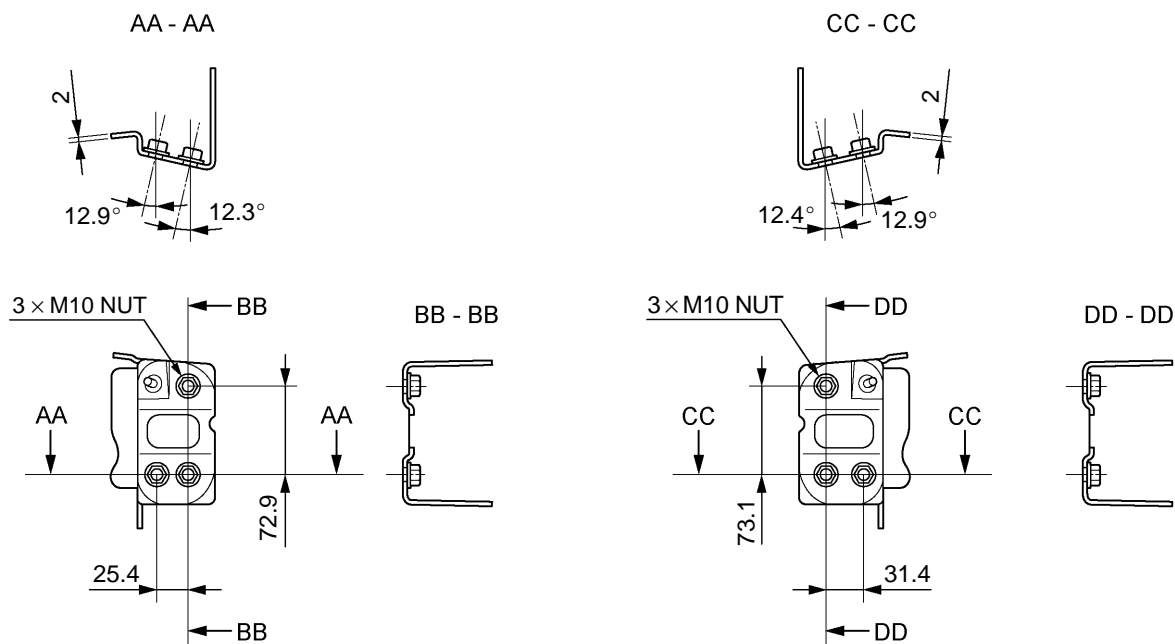
mm (in.)

Symbol	Name	Hole dia.	C, c	Front frame installation bolt	—
A, a	Front crossmember standard hole	ø15 (0.59)	D, d	Front side inner member standard hole	ø18 (0.71)
B, b	Front frame installation bolt	—	—	—	—

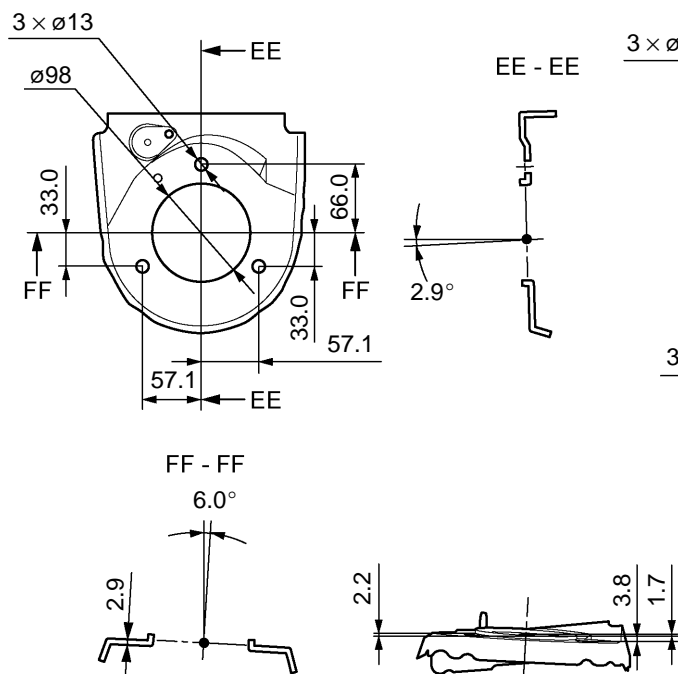
UNDER BODY

(Two - Dimensional Distance)

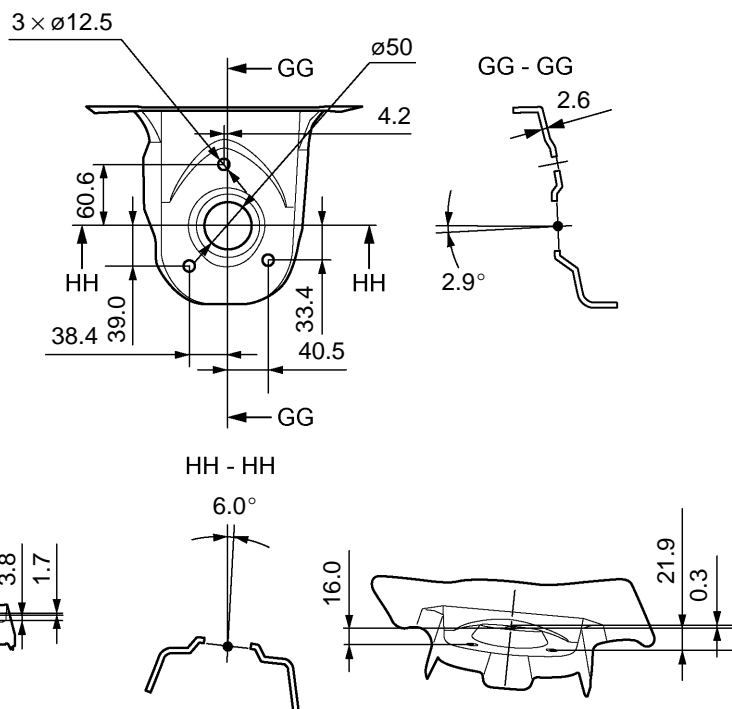
Front bumper reinforcement



Front spring support

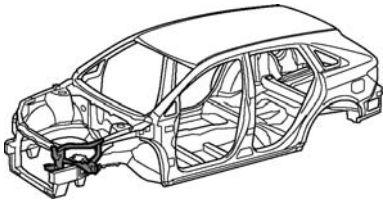


Rear spring support



mm

RADIATOR SIDE SUPPORT (ASSY)



F41417A

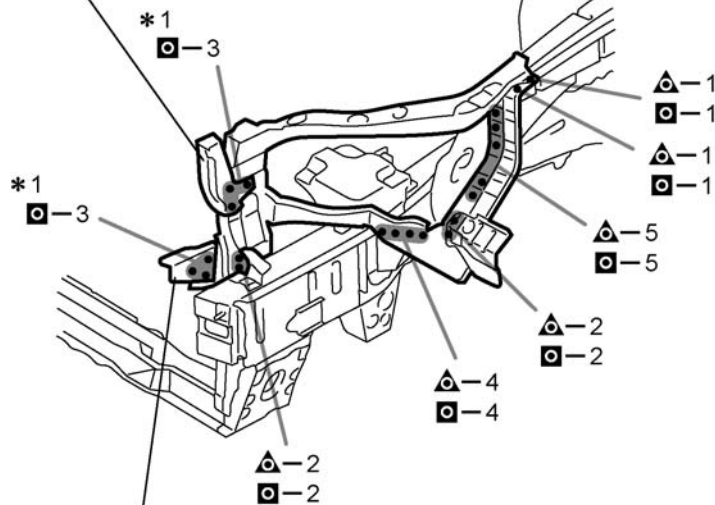
Symbol meaning

REMOVAL	△ △ : Remove Weld Points
INSTALLATION	□ I : Plug Weld

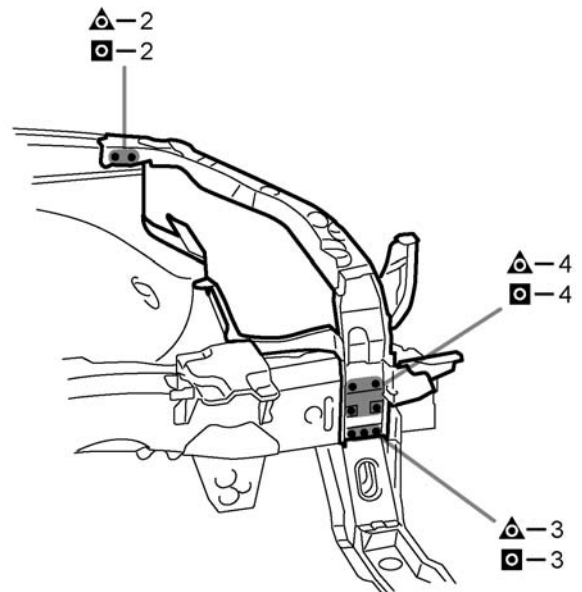
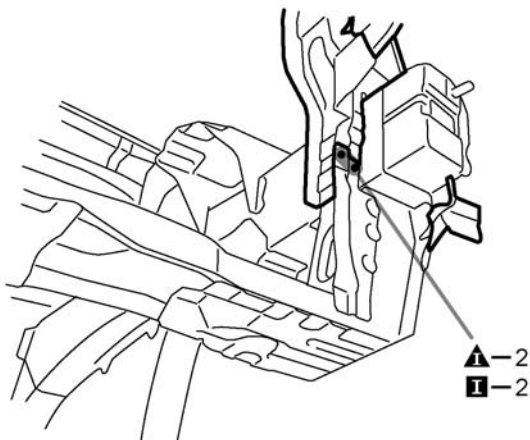
F41417B

REMOVAL-INSTALLATION

Front Bumper Upper Arm



Front Bumper Side Mounting Bracket

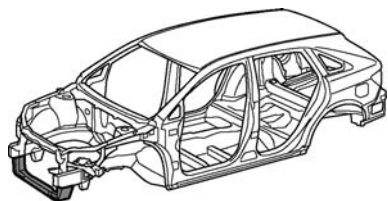


F41417

INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 *1 is only for installation.
- 4 After welding, apply body sealer to the corresponding parts. (See the paint-coating)
- 5 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

FRONT CROSSMEMBER (ASSY)



F41418A

Symbol meaning

REMOVAL

INSTALLATION

△ △ △ : Remove Weld Points

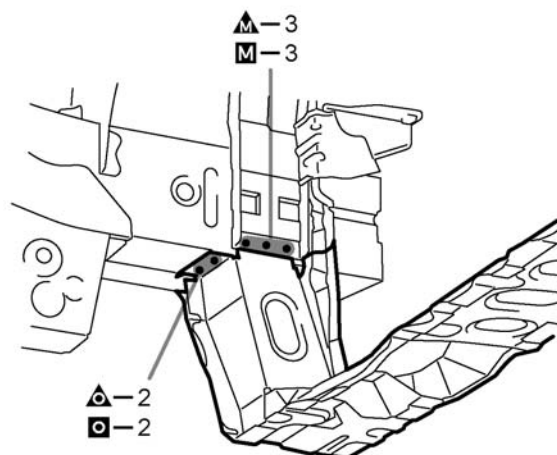
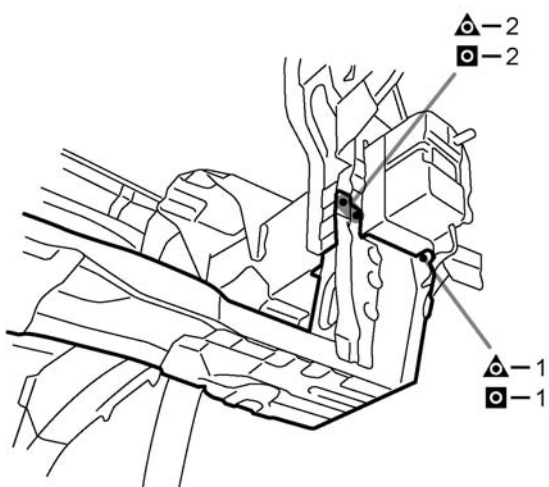
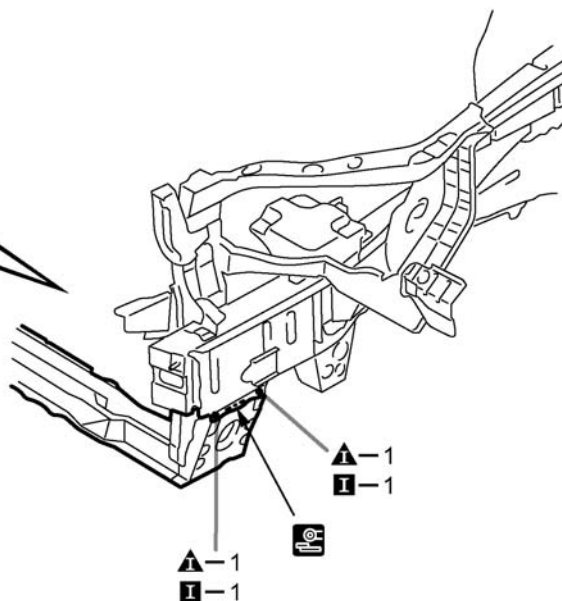
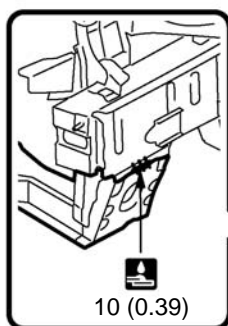
⊞ : Cut with Disc Sander etc.

⊙ M I : Plug Weld ▢ : Fillet Weld

F41418B

REMOVAL·INSTALLATION

[LH Side]



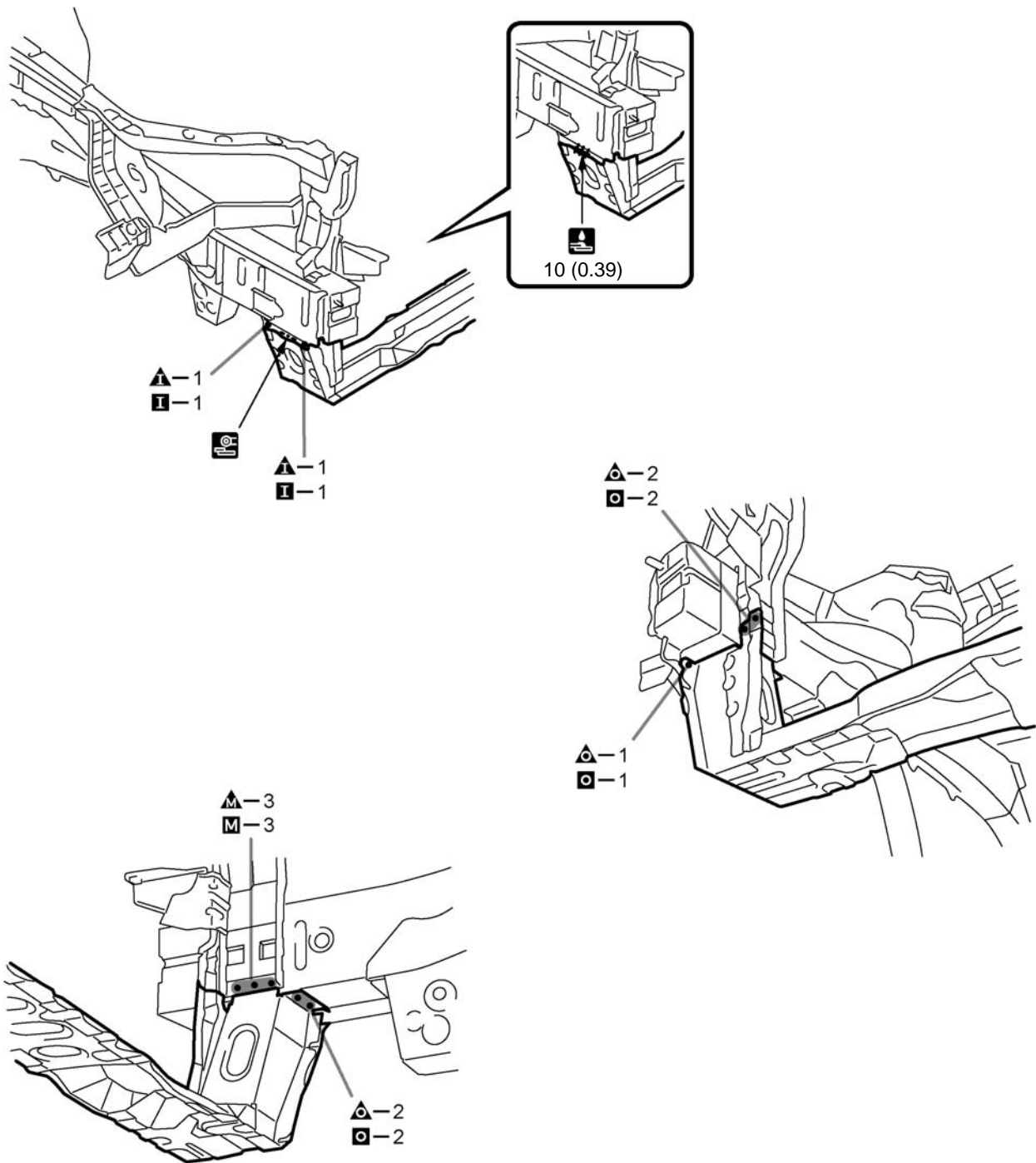
mm (in.)

F41418

INSTALLATION POINT

- 1 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)

[RH Side]



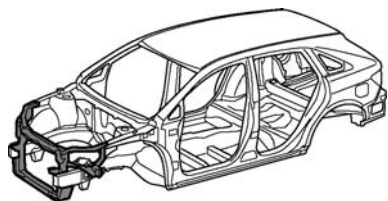
mm (in.)

F41419

INSTALLATION POINT

- 1 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 2 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

RADIATOR SUPPORT (ASSY)



F41420A

Symbol meaning

REMOVAL

INSTALLATION

△ △ : Remove Weld Points

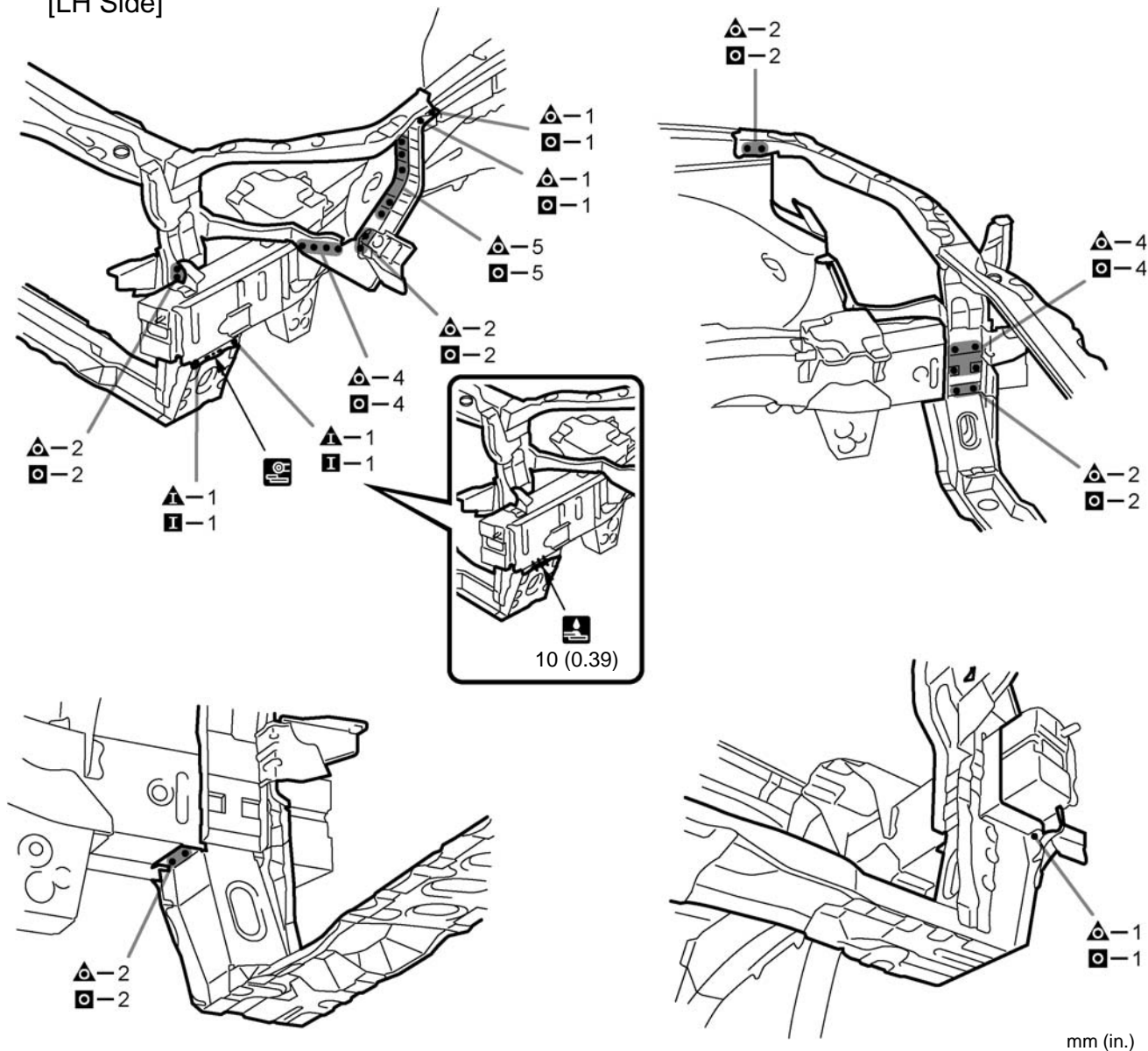
⊖ : Cut with Disc Sander etc.

⊙ I : Plug Weld ⊞ : Fillet Weld

F41420B

REMOVAL·INSTALLATION

[LH Side]

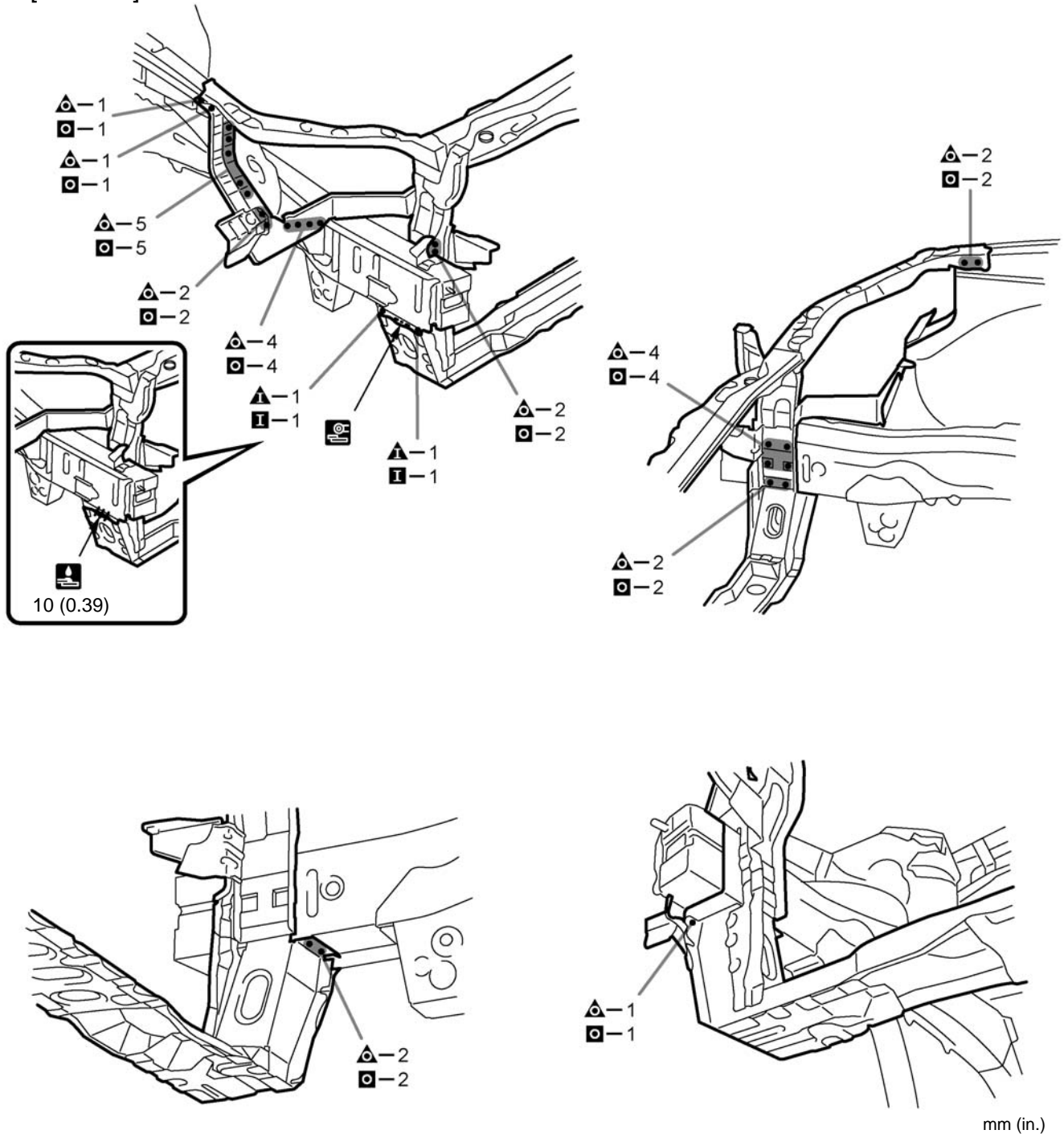


F41420

INSTALLATION POINT

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

[RH Side]

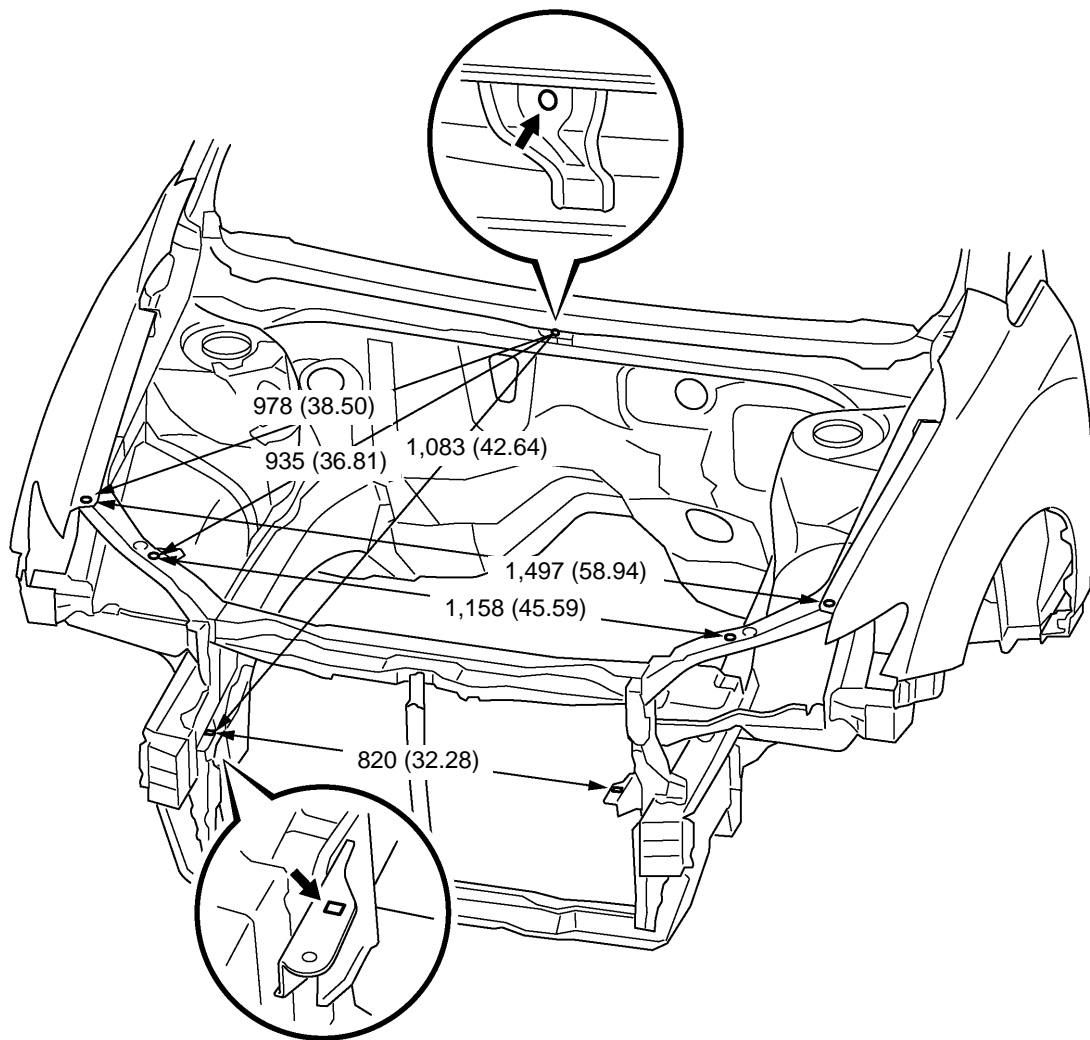


mm (in.)

F41421

INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 After welding, apply body sealer to the corresponding parts. (See the paint-coating)
- 4 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.



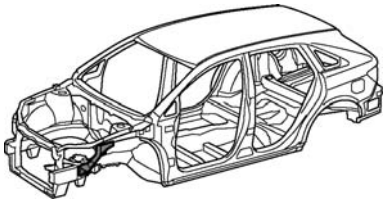
mm (in.)

F41422

INSTALLATION POINT

- 1 Measure the dimensions before installing the headlights.
- 2 These values are reference values.

FRONT FENDER FRONT APRON (ASSY)



F41423A

With the radiator side support removed.

Symbol meaning

REMOVAL

INSTALLATION

△ △ △ : Remove Weld Points

✂ : Cut with Disc Sander etc.

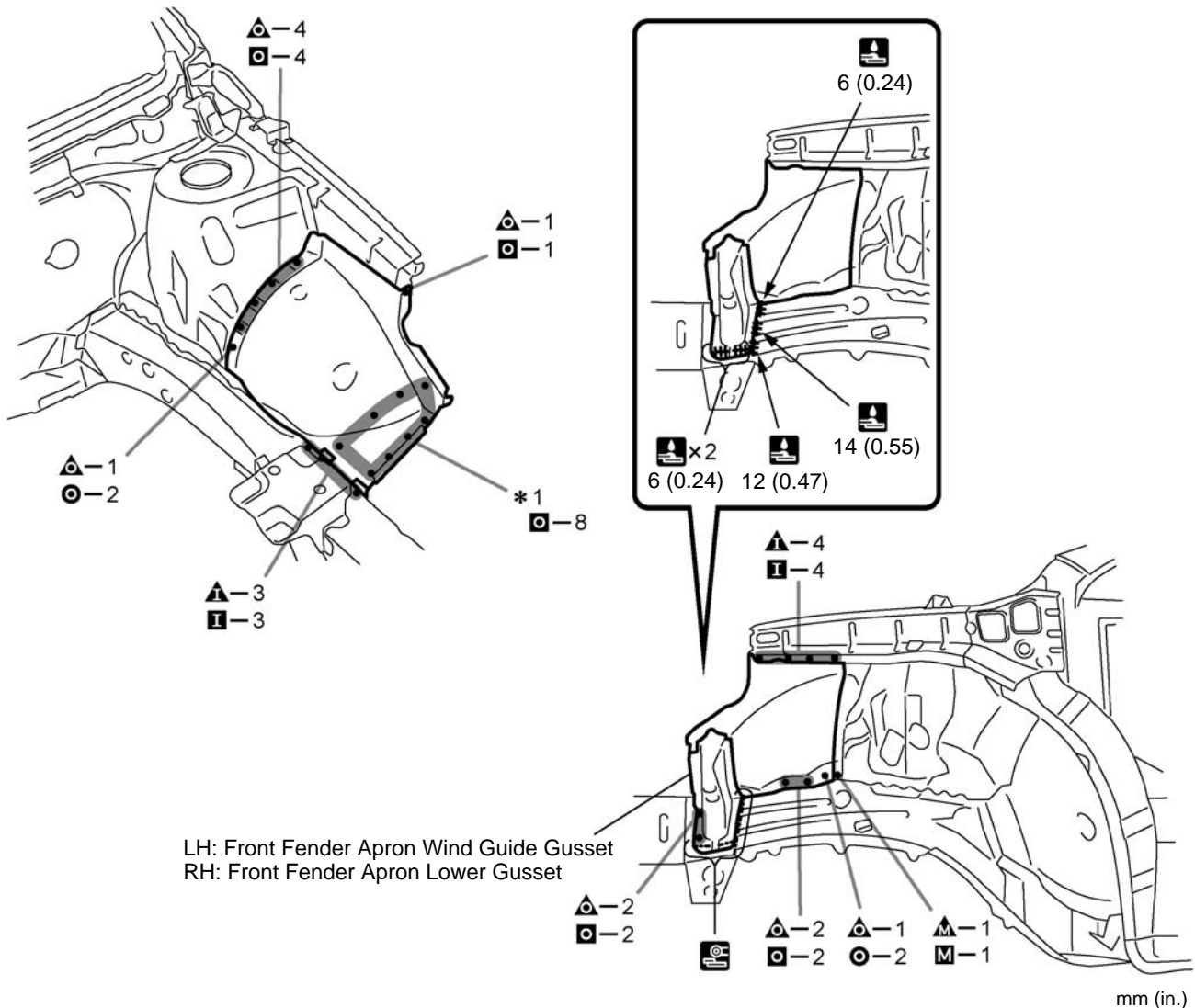
○ : Spot Weld

□ M I : Plug Weld

⬮ : Fillet Weld

F41423B

REMOVAL·INSTALLATION



F41423

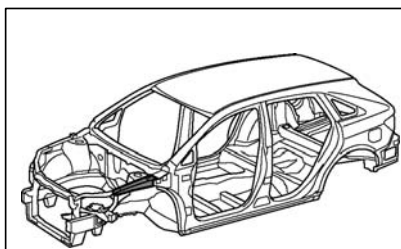
REMOVAL POINT

- 1 Remove the front fender apron wind guide gusset and front fender apron lower gusset at the same time.

INSTALLATION POINT

- 1 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 2 *1 is only for installation.
- 3 After welding, apply body sealer and undercoating to the corresponding parts. (See the paint-coating)
- 4 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

FRONT APRON TO COWL SIDE UPPER MEMBER (ASSY)



F41424A

With the radiator side support removed.

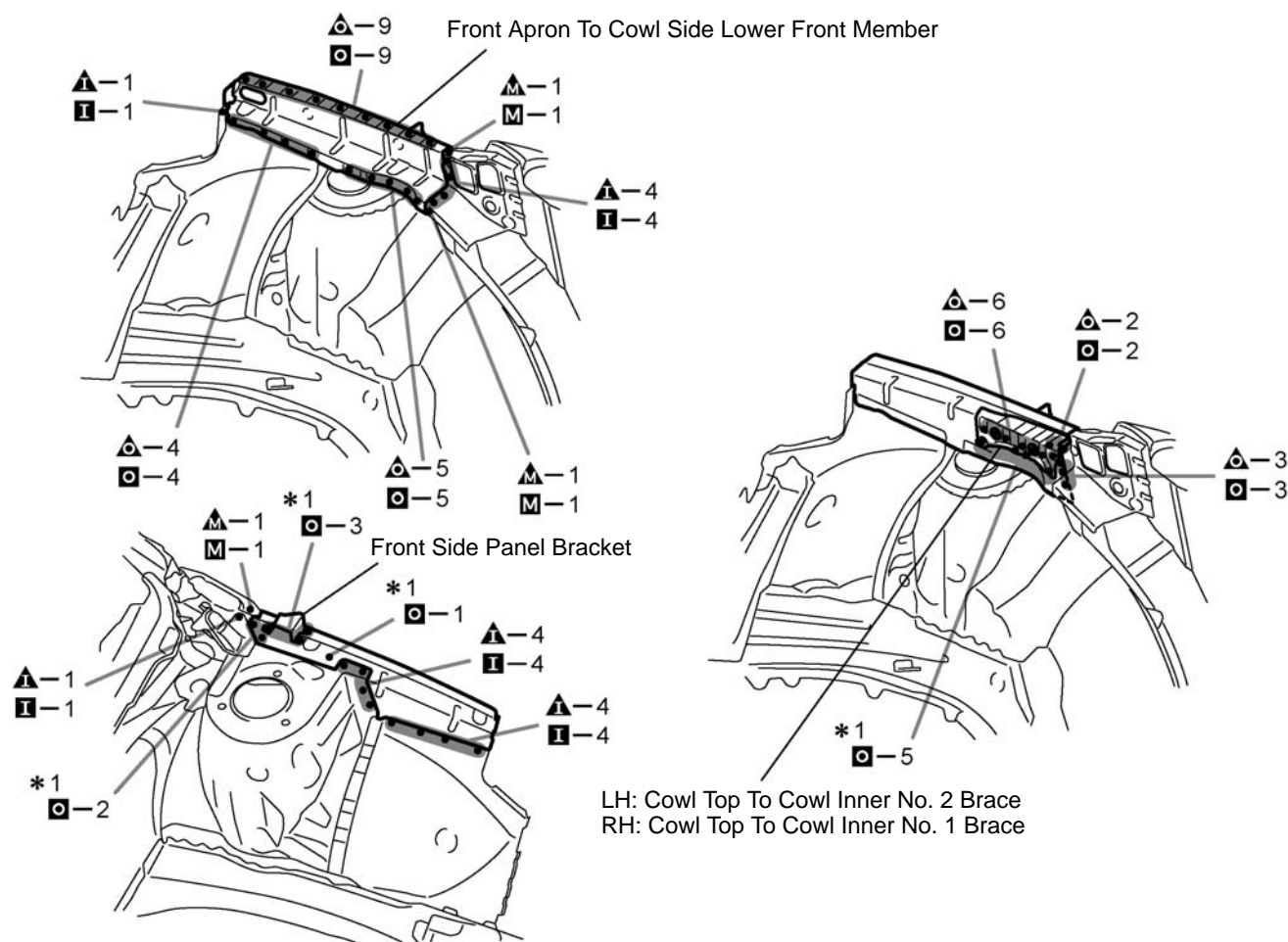
Symbol meaning

REMOVAL : Remove Weld Points

INSTALLATION : Plug Weld

F41424B

REMOVAL-INSTALLATION



F41424

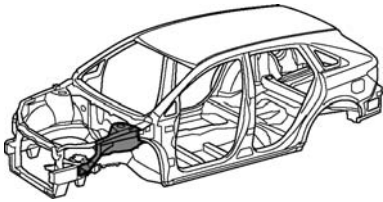
REMOVAL POINT

- 1 After removing the front apron to cowl side lower front member, remove the front apron to cowl side upper member.
- 2 Remove the cowl top to cowl inner No. 2 brace and cowl top to cowl inner No. 1 brace at the same time.

INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 *1 is only for installation.
- 4 After welding the front apron to cowl side upper member, cowl top to cowl inner No. 2 brace and cowl top to cowl inner No. 1 brace to the vehicle side, install the front apron to cowl side lower front member.
- 5 After welding, apply body sealer to the corresponding parts. (See the paint-coating)
- 6 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

FRONT FENDER APRON (ASSY)



F41425A

With the radiator side support and cowl side reinforcement removed.

Symbol meaning

REMOVAL

INSTALLATION

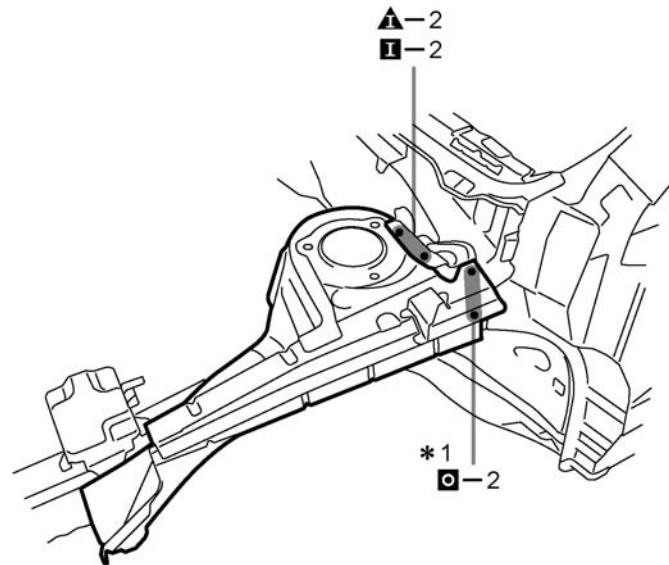
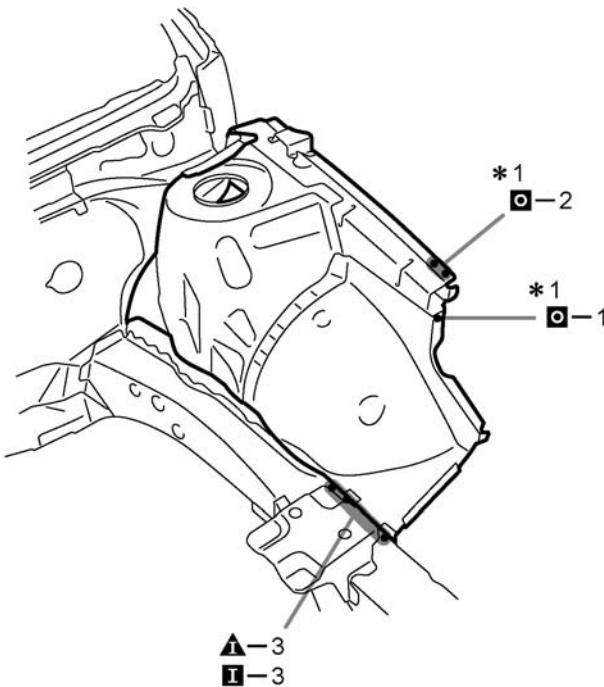
△ △ △ : Remove Weld Points

⊖ : Cut with Disc Sander etc.

⊙ M I : Plug Weld ◻ : Fillet Weld

F41425B

REMOVAL·INSTALLATION



CAUTION

Make sure to attach correctly in accordance with the body dimension diagram as this parts affects the front wheel alignment.





F41425

INSTALLATION POINT

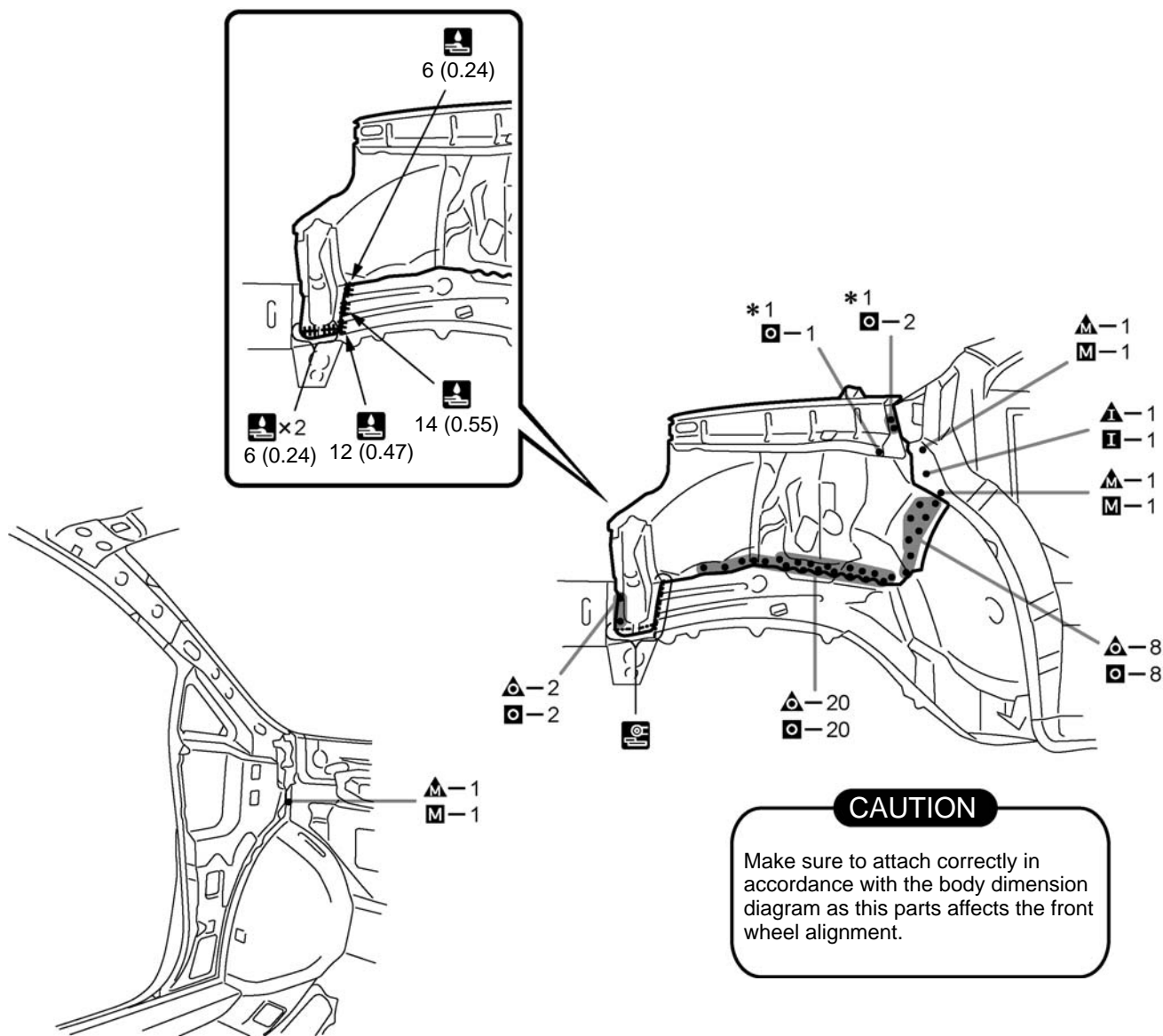
- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 *1 is only for installation.

Symbol meaning

REMOVAL    : Remove Weld Points  : Cut with Disc Sander etc.

INSTALLATION    : Plug Weld  : Fillet Weld

F41425B



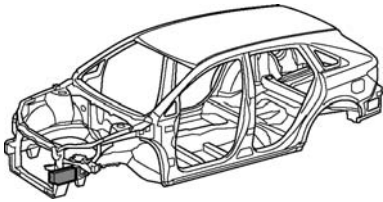
mm (in.)

F41426

INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 *1 is only for installation.
- 4 After welding, apply body sealer and undercoating to the corresponding parts. (See the paint coating)
- 5 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

FRONT SIDE MEMBER (CUT-P)



F41427A

With the radiator side support and front crossmember removed.
(Engine installed)

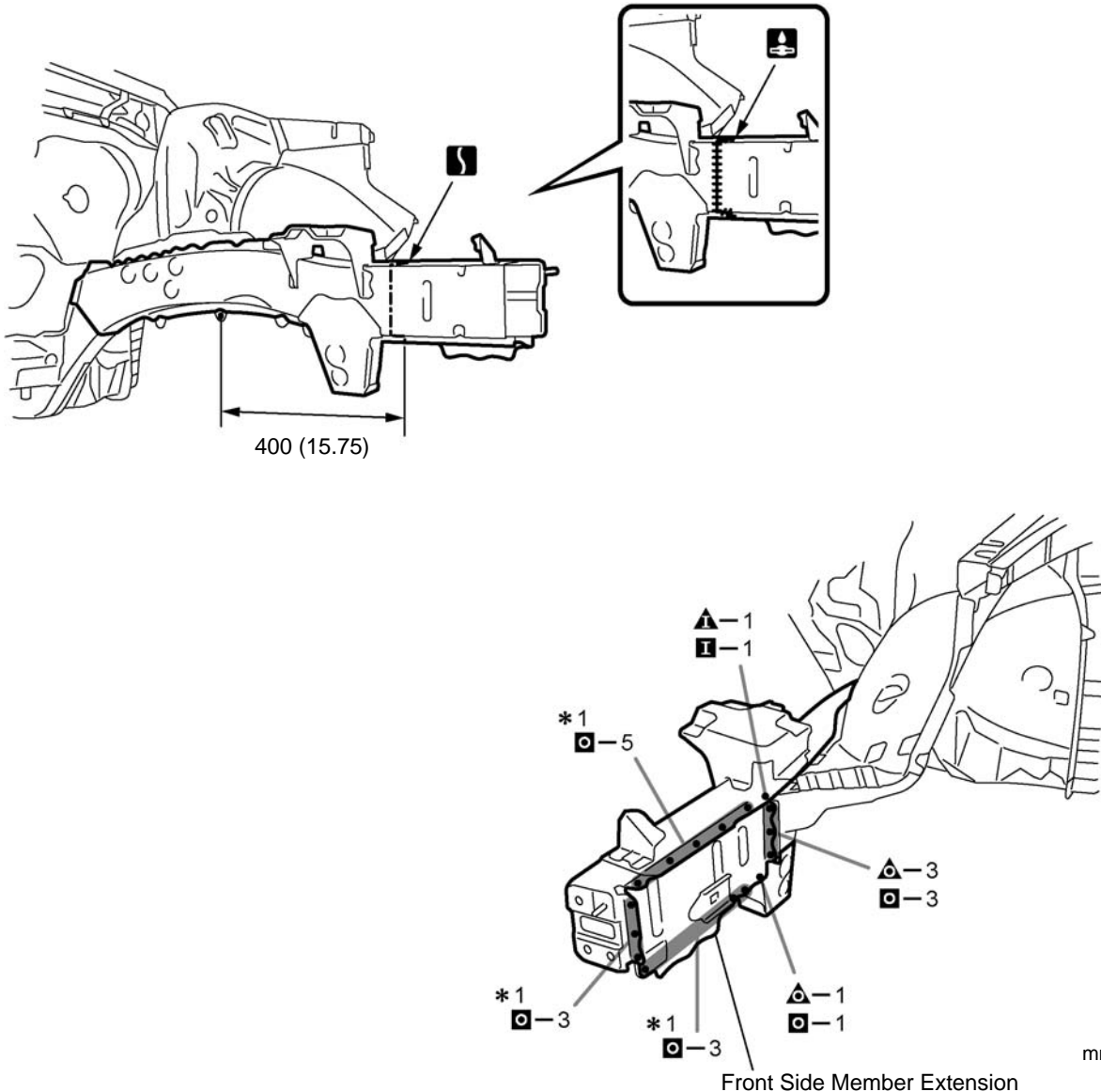
Symbol meaning

REMOVAL : Remove Weld Points : Cut and Join Location

INSTALLATION : Plug Weld : Butt Weld

F41427B

REMOVAL-INSTALLATION



F41427


REMOVAL POINT




- 1 Remove the front side member extension at the same time.

INSTALLATION POINT

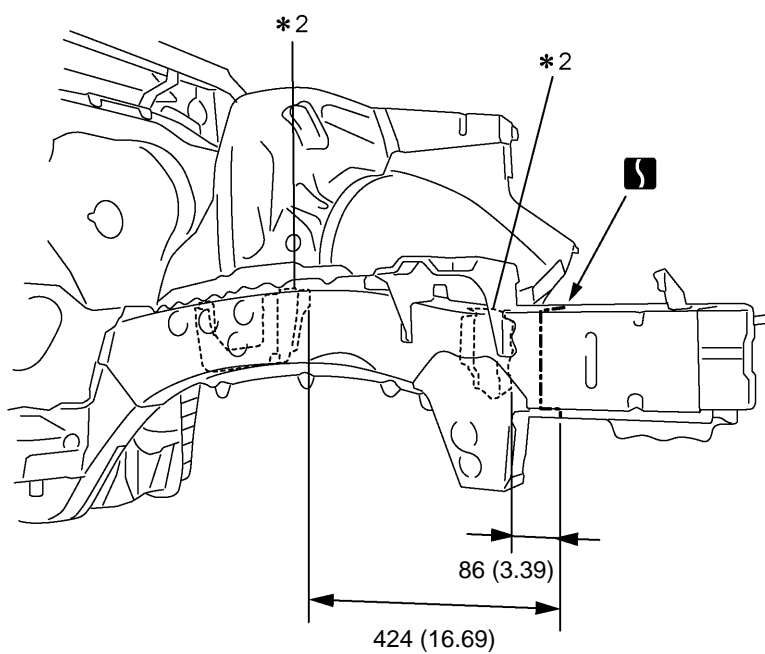
- 1 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 2 *1 is only for installation.
- 3 After welding, apply body sealer and undercoating to the corresponding parts. (See the paint-coating)
- 4 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

Symbol meaning

REMOVAL   : Remove Weld Points  : Cut and Join Location

INSTALLATION   : Plug Weld  : Butt Weld

F41427B



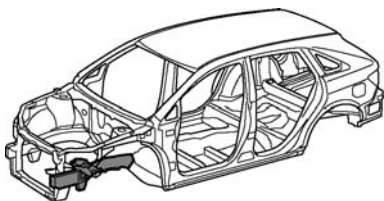
mm (in.)

F41428

REMOVAL POINT

- 1 Carefully cut the front side member so not to damage *2.
- 2 These values are reference values.

FRONT SIDE MEMBER (ASSY)



F41429A

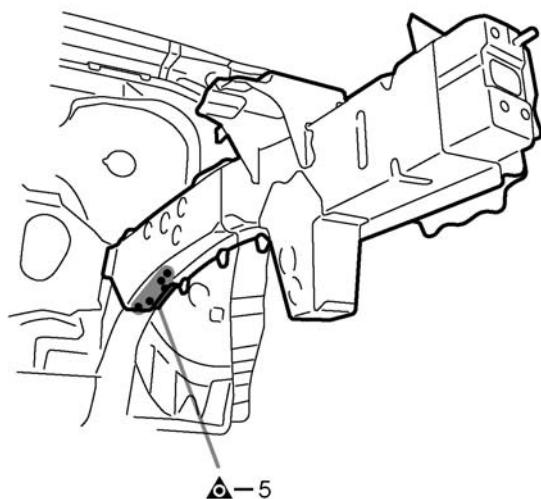
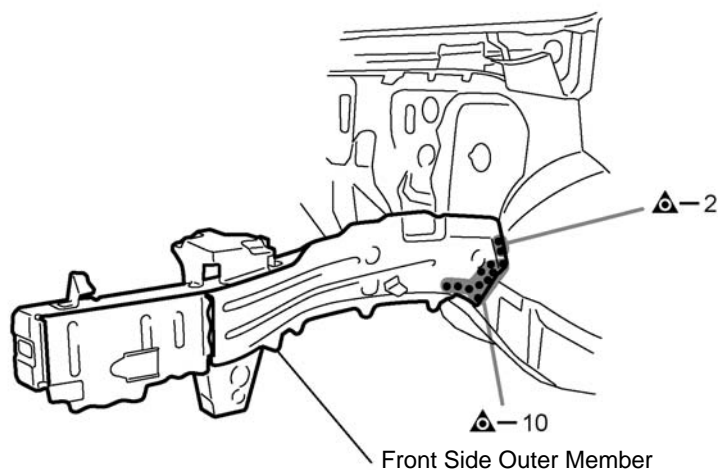
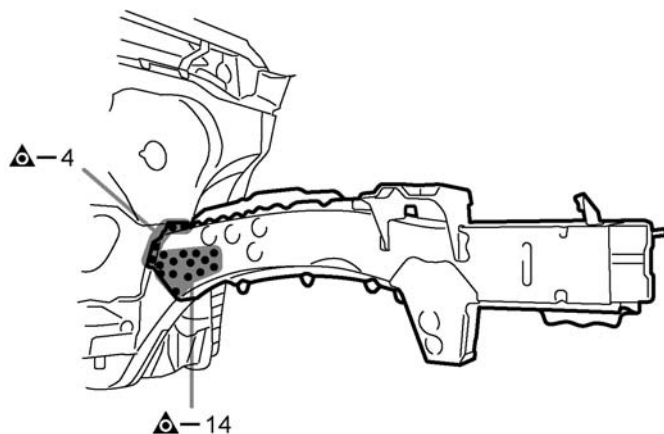
With the radiator side support, front crossmember and front fender apron removed.

Symbol meaning

△ : Remove Weld Points

F41429B

REMOVAL



F41429

REMOVAL POINT

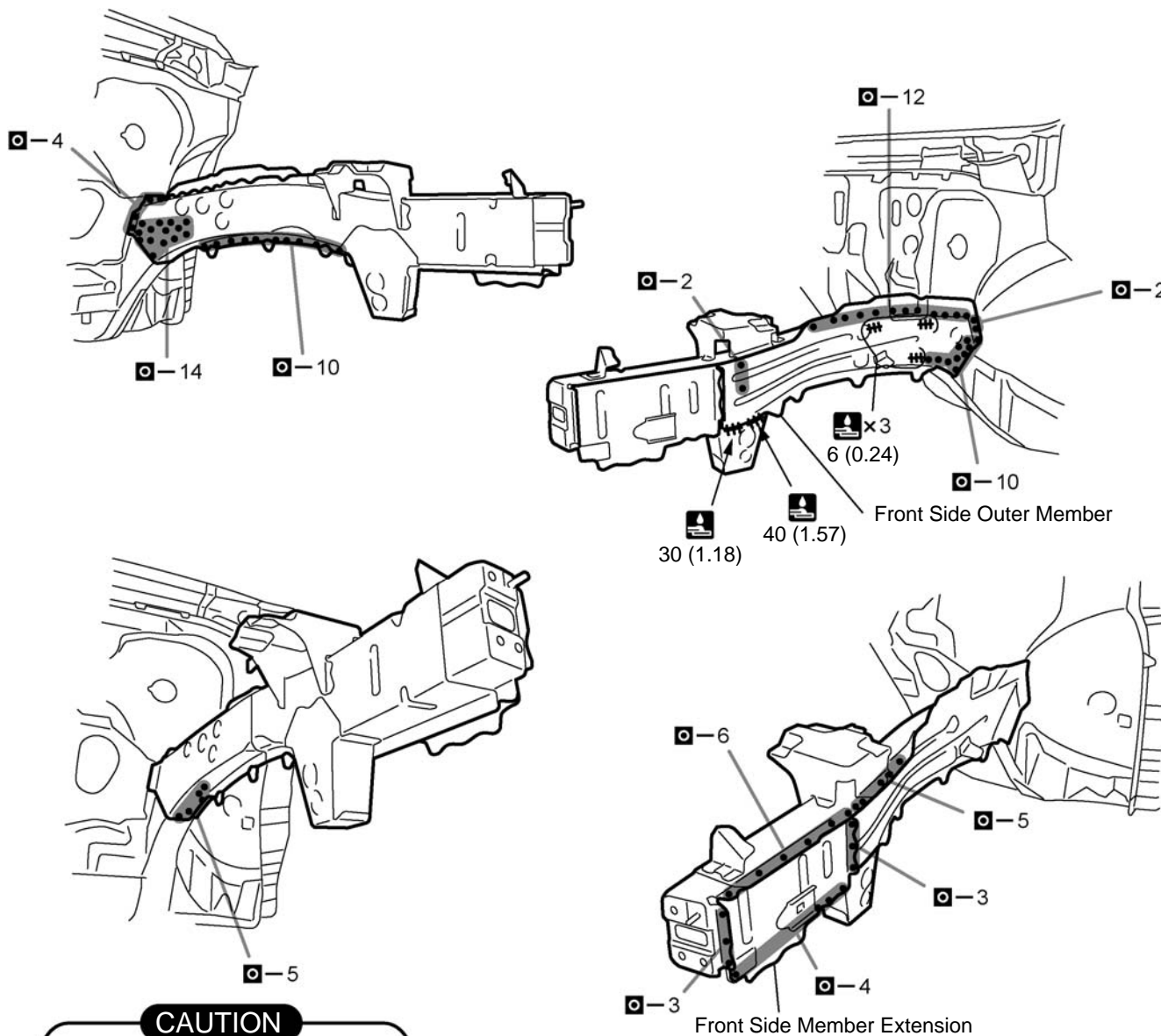
- 1 Remove the front side outer member at the same time.

Symbol meaning

 : Plug Weld : Fillet Weld

F41430B

INSTALLATION



CAUTION

Make sure to attach correctly in accordance with the body dimension diagram as this parts affects the front wheel alignment.

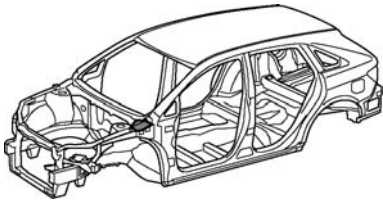
mm (in.)

F41430

INSTALLATION POINT

- 1 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 2 After welding, apply body sealer and undercoating to the corresponding parts. (See the paint-coating)
- 3 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

COWL TOP SIDE INNER PANEL (ASSY)



F41431A

Symbol meaning

REMOVAL

INSTALLATION

△ : Remove Weld Points

✂ : Cut with Disc Sander etc.

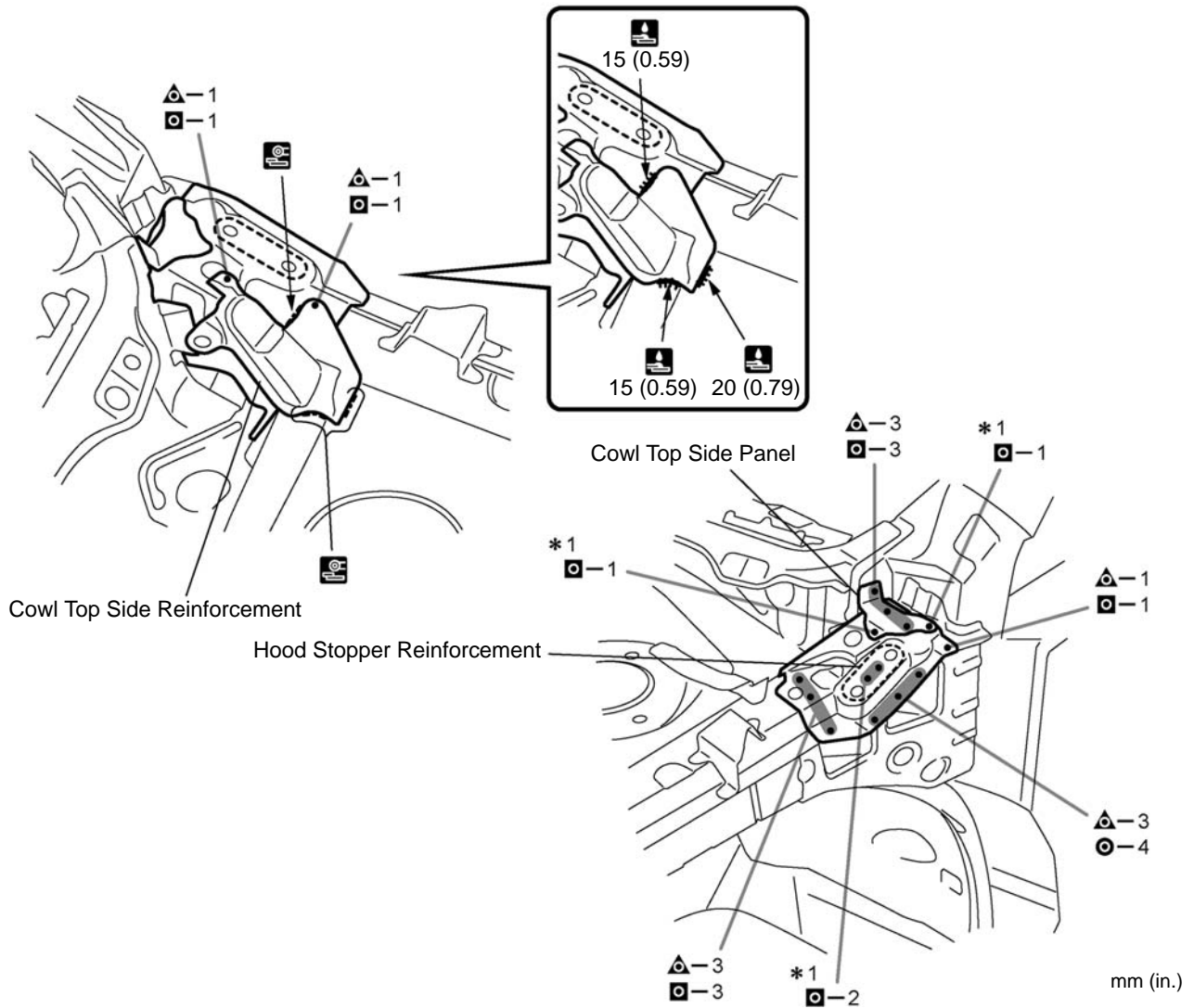
● : Spot Weld

◻ : Plug Weld

⬮ : Fillet Weld

F41431B

REMOVAL·INSTALLATION



F41431

REMOVAL POINT

- 1 After removing the cowl top side reinforcement, remove the cowl top side inner panel.
- 2 Remove the cowl top side panel at the same time.

INSTALLATION POINT

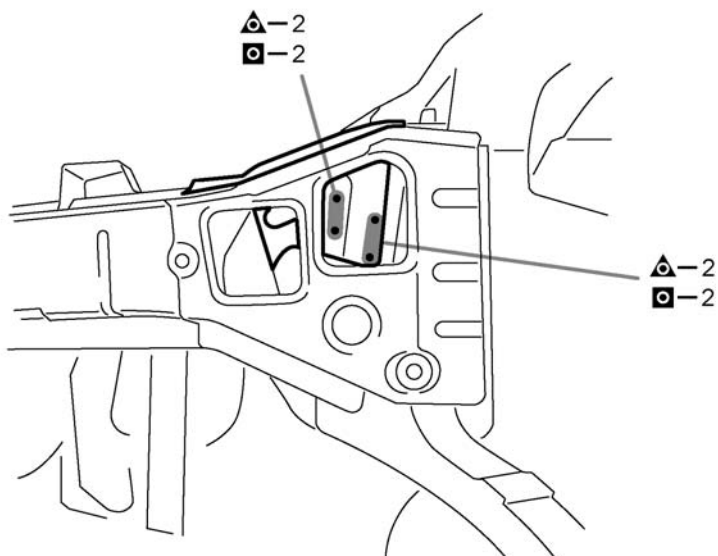
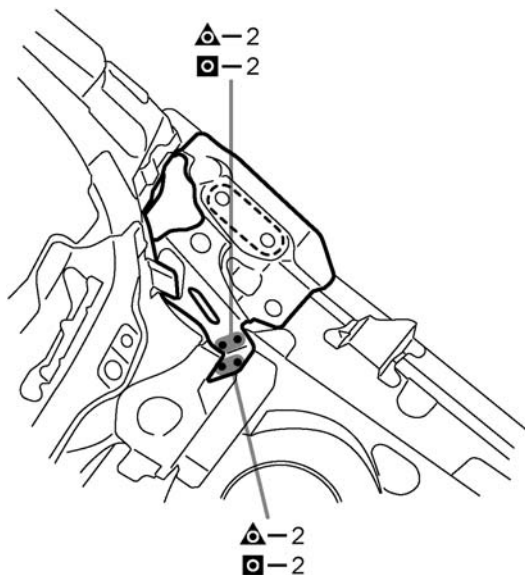
- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 *1 is only for installation.
- 4 After welding the cowl top side inner panel and cowl top side panel to the vehicle side, install the cowl top side reinforcement.

Symbol meaning

REMOVAL ▲ : Remove Weld Points ☒ : Cut with Disc Sander etc.

INSTALLATION ○ : Spot Weld ◻ : Plug Weld ▽ : Fillet Weld

F41431B

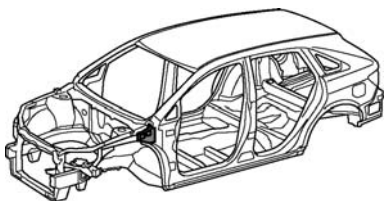


F41432

INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 After welding, apply body sealer to the corresponding parts. (See the paint-coating)
- 4 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

COWL SIDE REINFORCEMENT (ASSY)



F41433A

With the cowl top side inner panel removed.

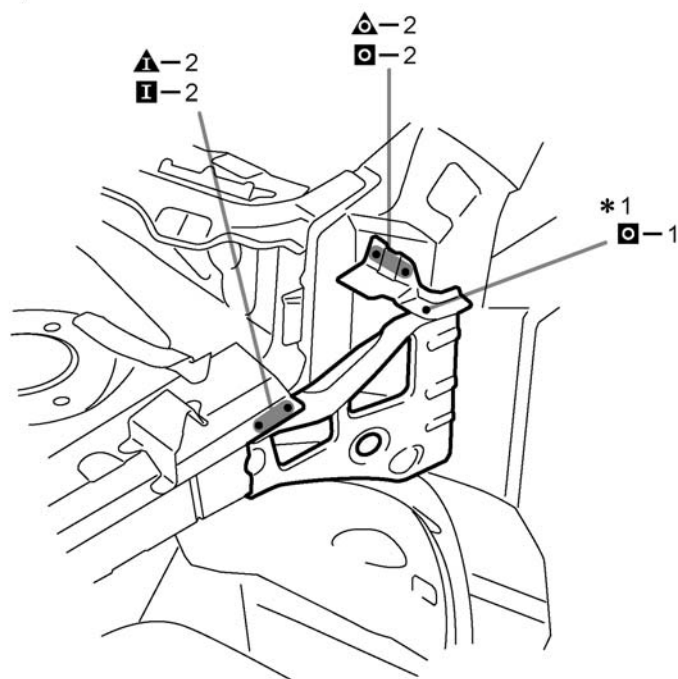
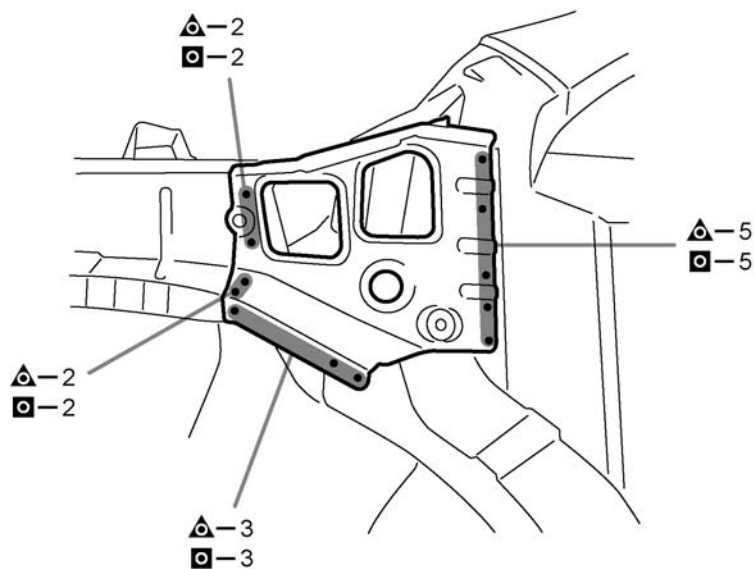
Symbol meaning

REMOVAL : Remove Weld Points

INSTALLATION : Plug Weld

F41433B

REMOVAL·INSTALLATION

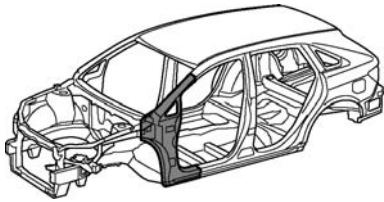


F41433

INSTALLATION POINT

- 1 *1 is only for installation.
- 2 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

FRONT BODY PILLAR (CUT)



F41434A

With the cowl side reinforcement removed.

Symbol meaning

△ △ △ : Remove Weld Points

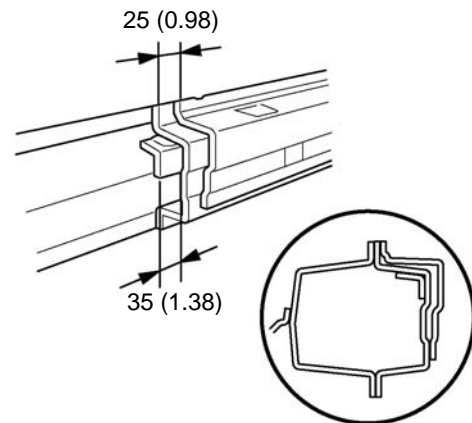
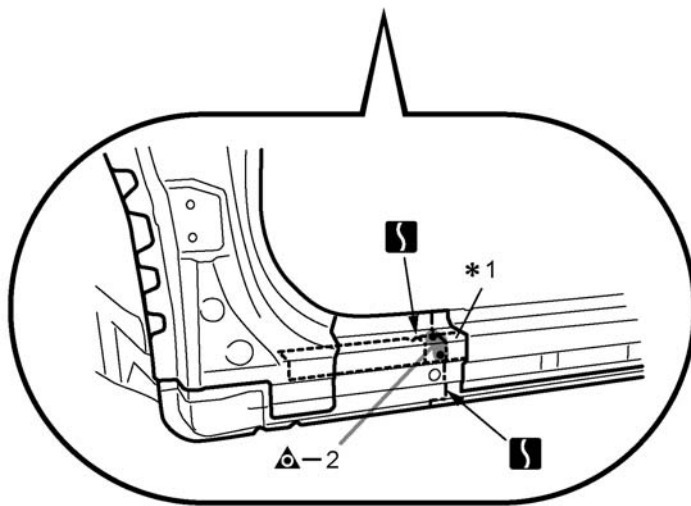
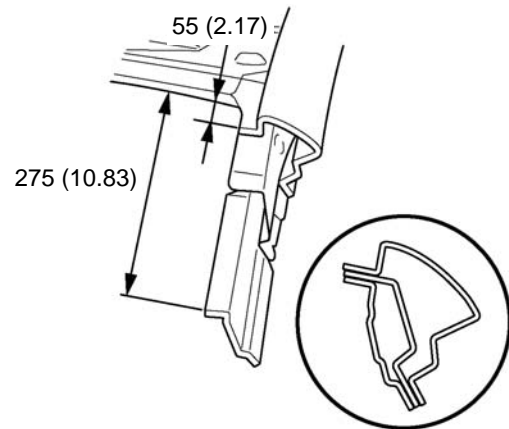
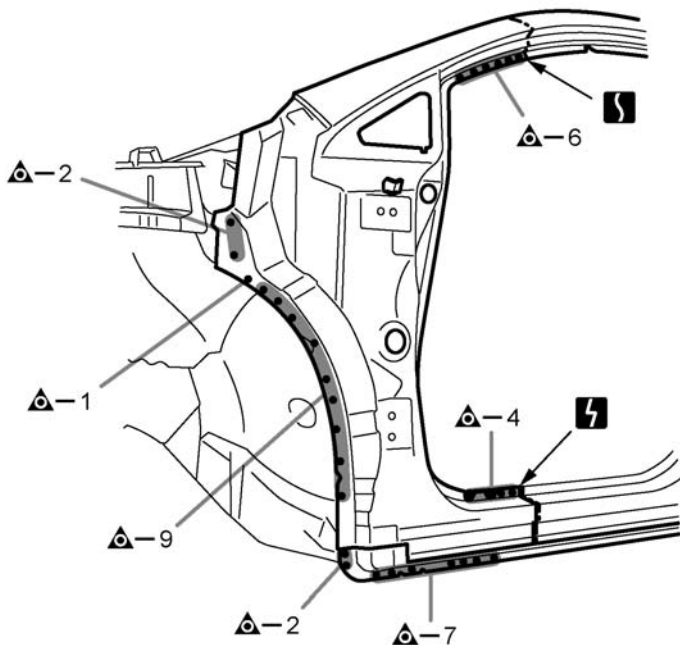
⊖ : Cut with Disc Sander etc.

⌋ : Cut and Join Location

⚡ : Cut Location for Supply Parts

F41434B

REMOVAL

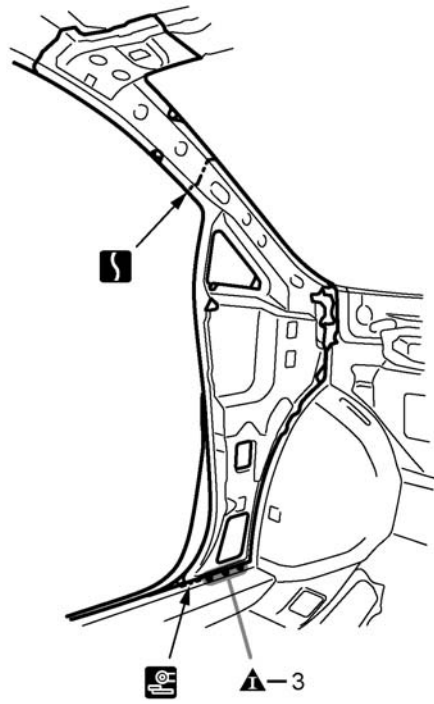
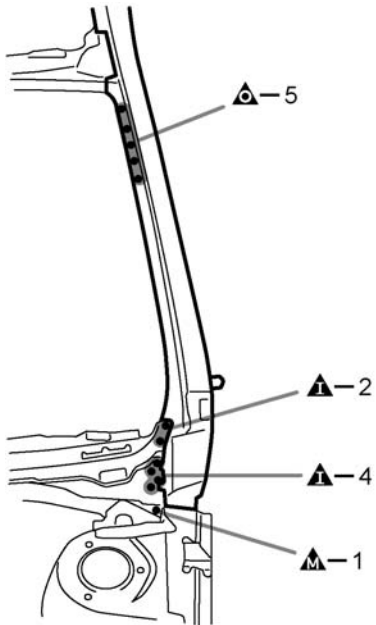


mm (in.)







F41434

REMOVAL POINT

- 1 Carefully cut the rocker outer panel so not to damage *1.



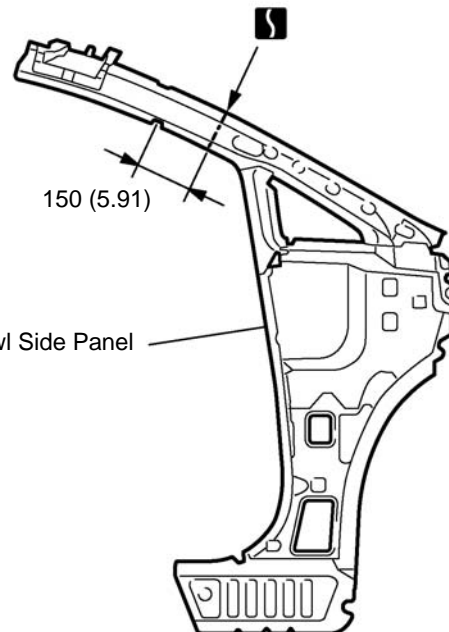
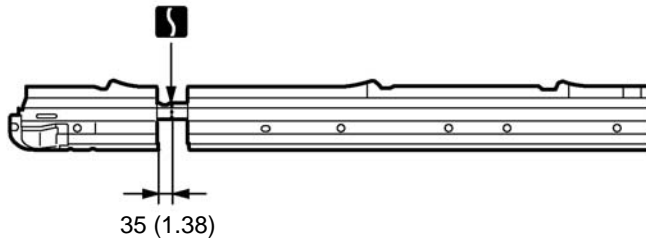
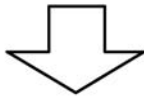
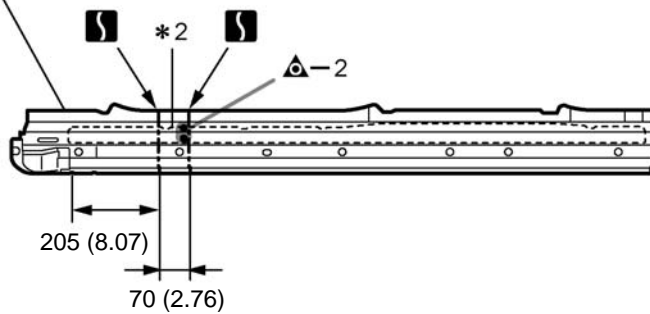
Symbol meaning

 : Remove Weld Points
  M T : Plug Weld
  : Cut and Join Location
  : Fillet Weld
 : Butt Weld
 : Body Sealer

F41436B

INSTALLATION

Rocker Outer Panel



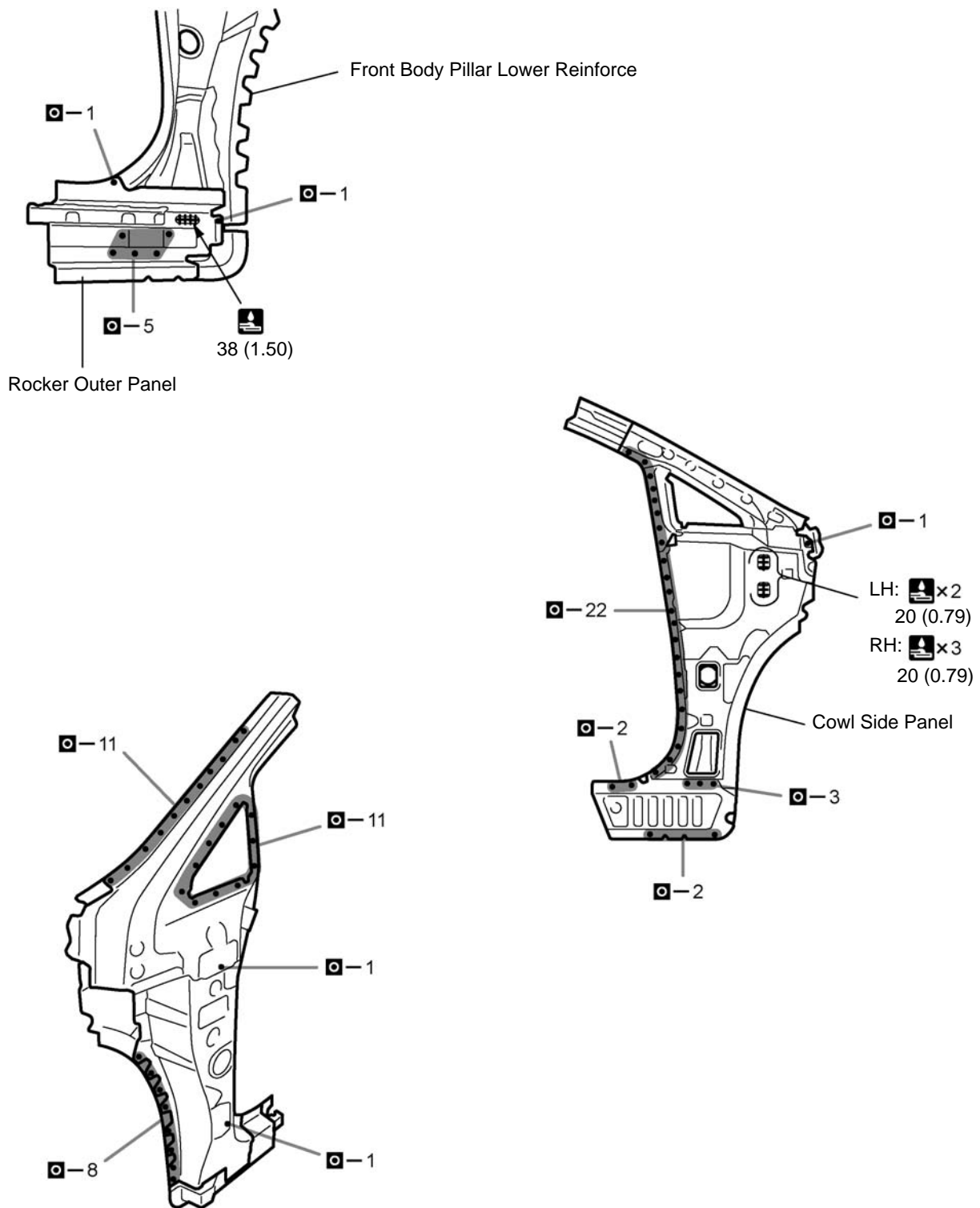
Cowl Side Panel

mm (in.)

F41436

INSTALLATION POINT

- 1 Carefully cut the rocker outer panel so not to damage *2.









mm (in.)

F41437

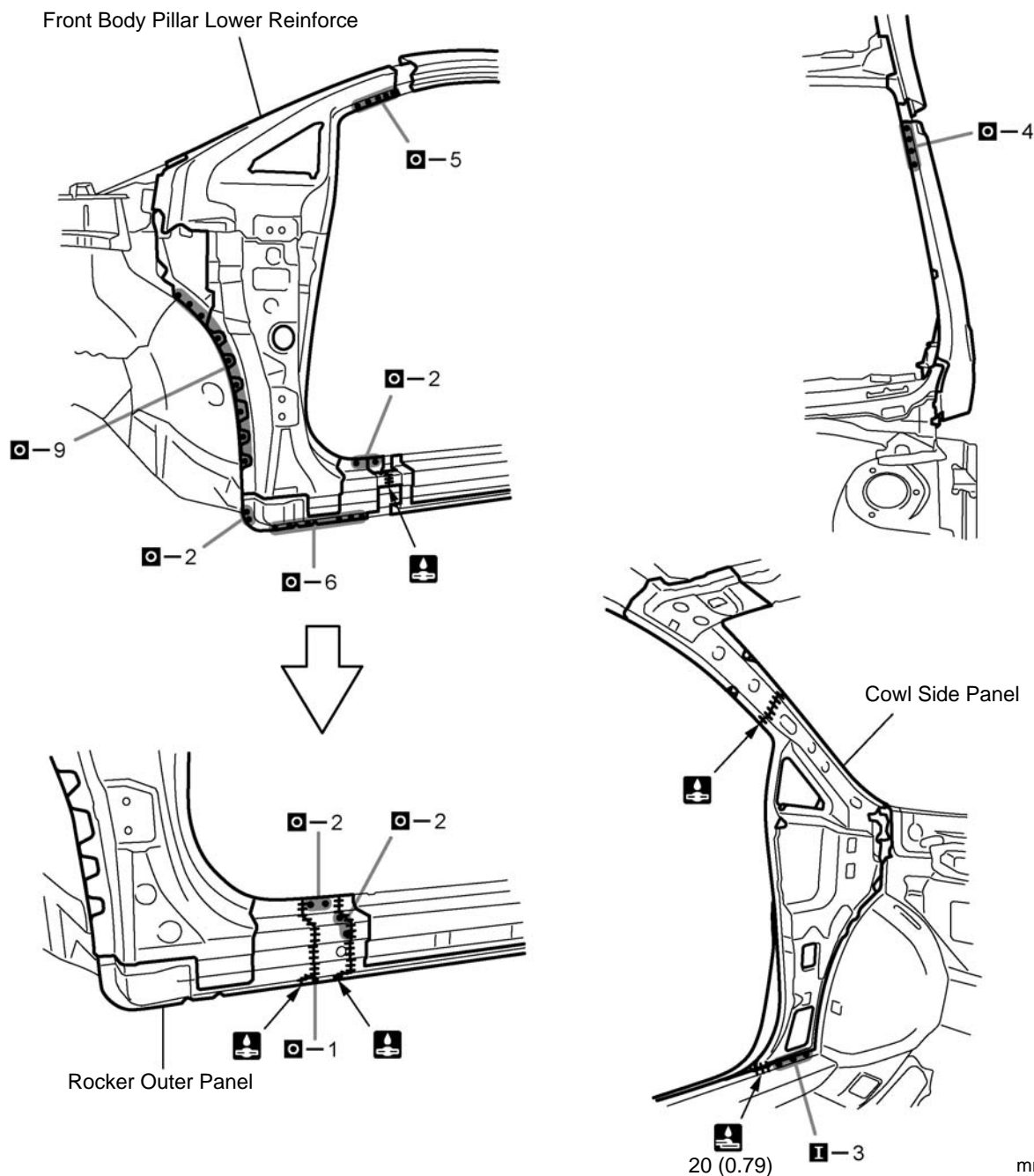
INSTALLATION POINT

- 1 Before temporarily installing the new parts, weld the rocker outer panel, front body pillar lower reinforce and cowl side panel with the standard number of welding points.

Symbol meaning

 : Remove Weld Points
  M T : Plug Weld
  : Cut and Join Location
  : Fillet Weld
 : Butt Weld
 : Body Sealer

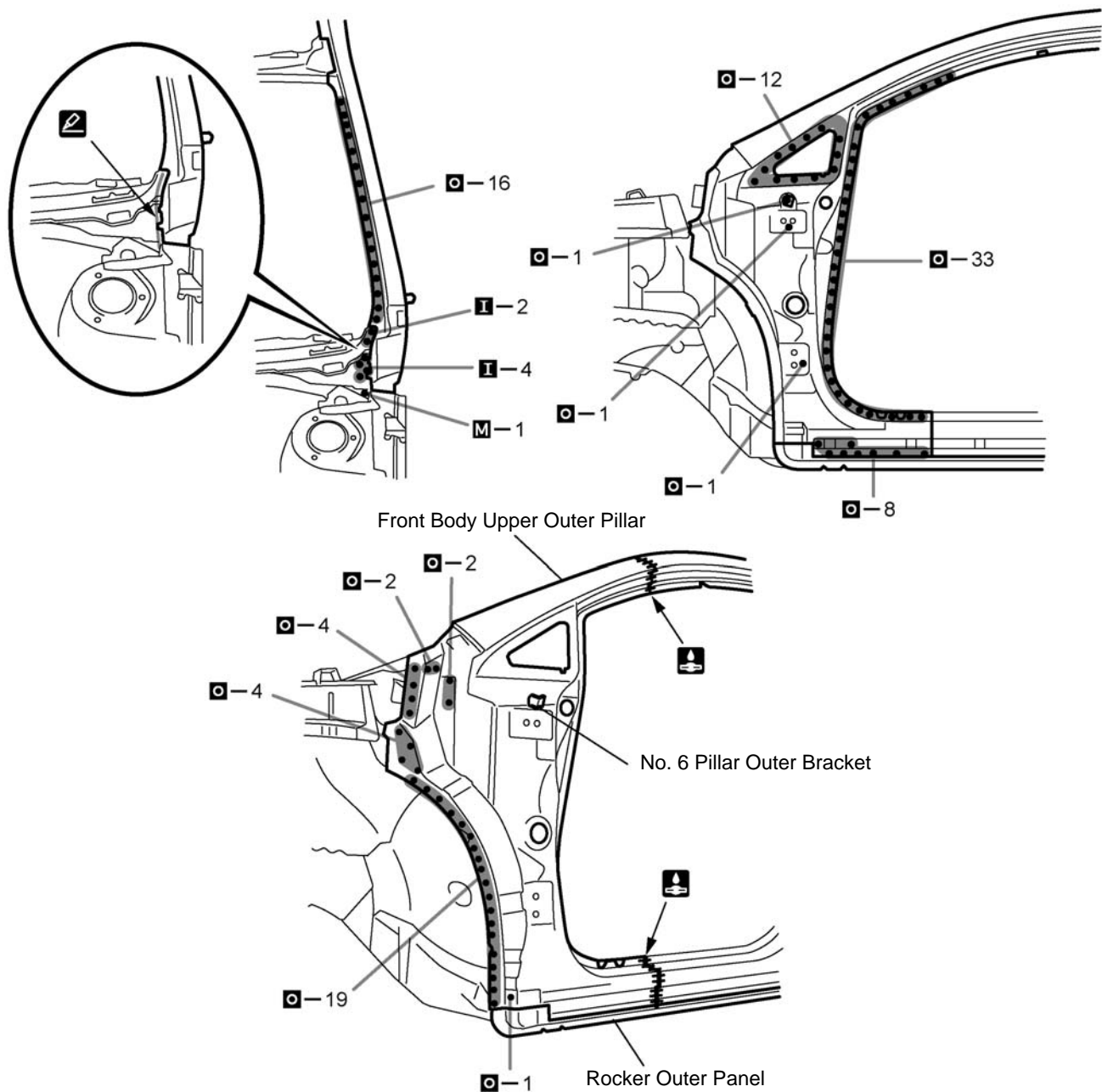
F41436B



F41438

INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 After welding the rocker outer panel, front body pillar lower reinforce and cowl side panel to the vehicle side, install the front body upper outer pillar and No. 6 pillar outer bracket.

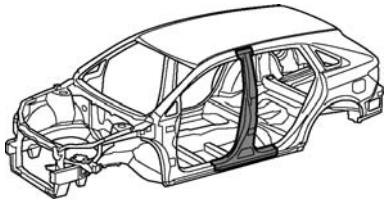


F41439

INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 Before installing a new part, apply body sealer.
HINT:
Apply sealer in an even, continuous bead.
- 4 After welding the rocker outer panel, front body pillar lower reinforce and cowl side panel to the vehicle side, install the front body upper outer pillar and No. 6 pillar outer bracket.
- 5 After welding, apply foamed sealing material to the corresponding parts. (See the paint-coating)
- 6 After welding, apply body sealer to the corresponding parts. (See the paint-coating)
- 7 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

CENTER BODY PILLAR (CUT)



F41440A

Symbol meaning

△ : Remove Weld Points

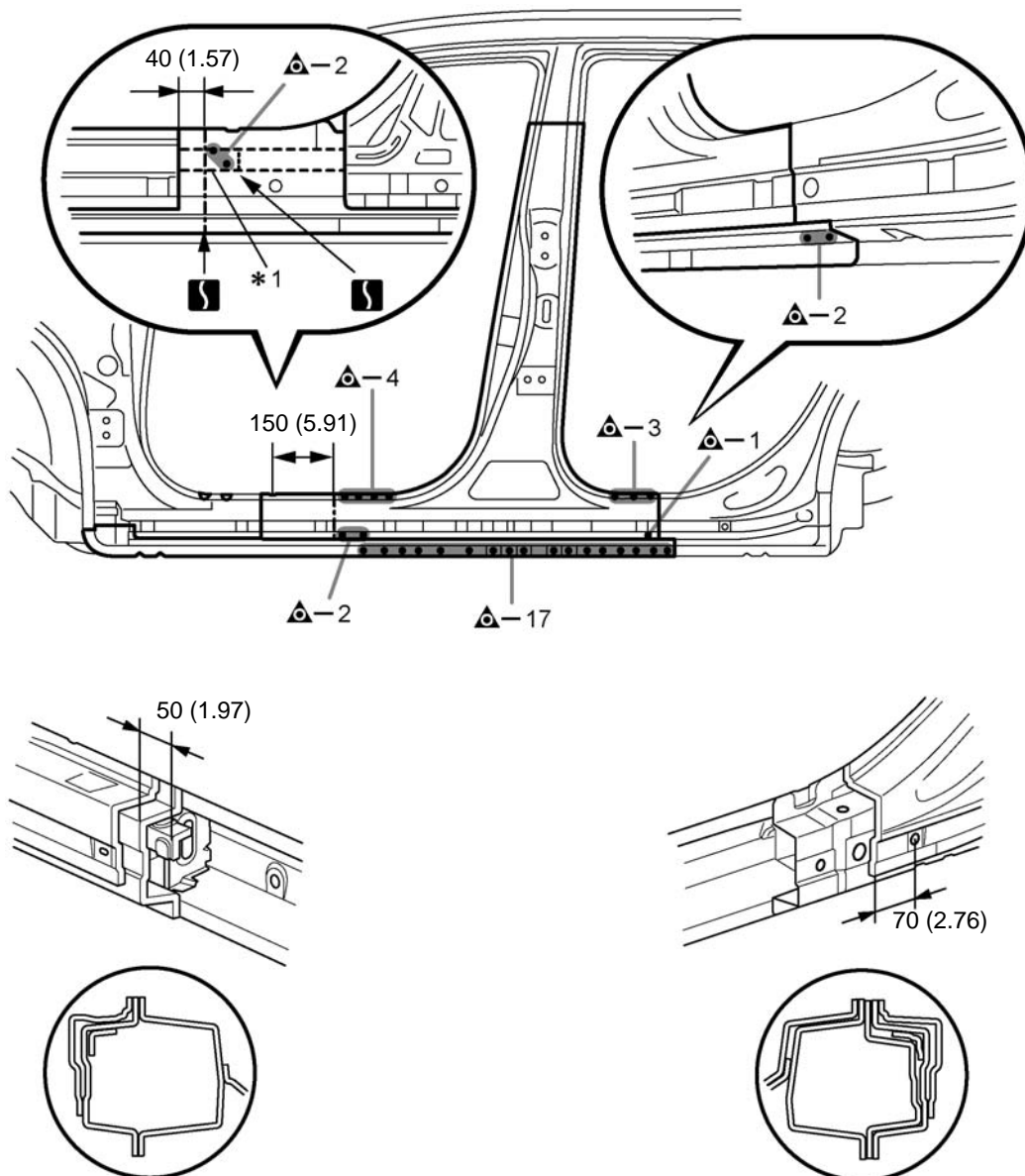
⊖ : Cut with Disc Sander etc.

⌋ : Cut and Join Location

⚡ : Cut Location for Supply Parts

F41440B

REMOVAL

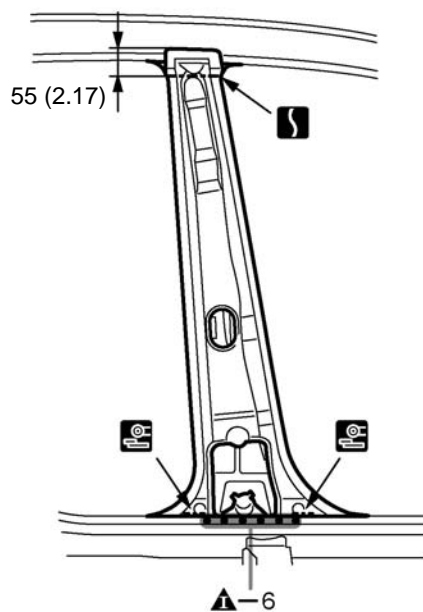
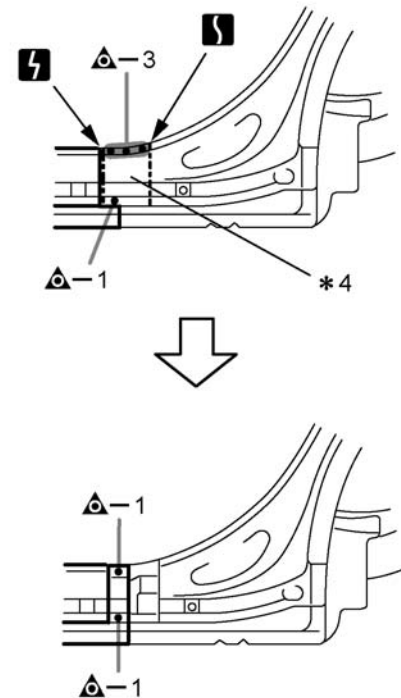
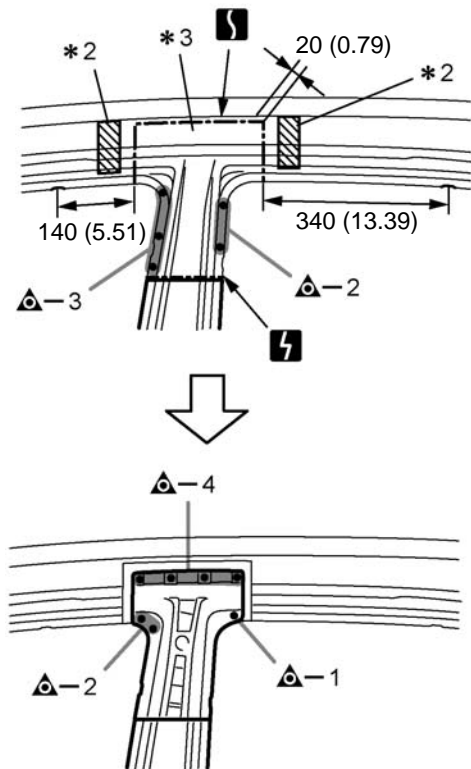


mm (in.)

F41440

REMOVAL POINT

- 1 Carefully cut the rocker outer panel so not to damage *1.



mm (in.)

F41441

REMOVAL POINT

- 1 *2 indicates the location of the foamed sealing material. Be careful when cutting as the foamed sealing material is located near the cutting position.
- 2 *3 is reused.
- 3 Reuse *4, as the area of the outer panel that is cut and joined is to the rear of the supplied part cut position.

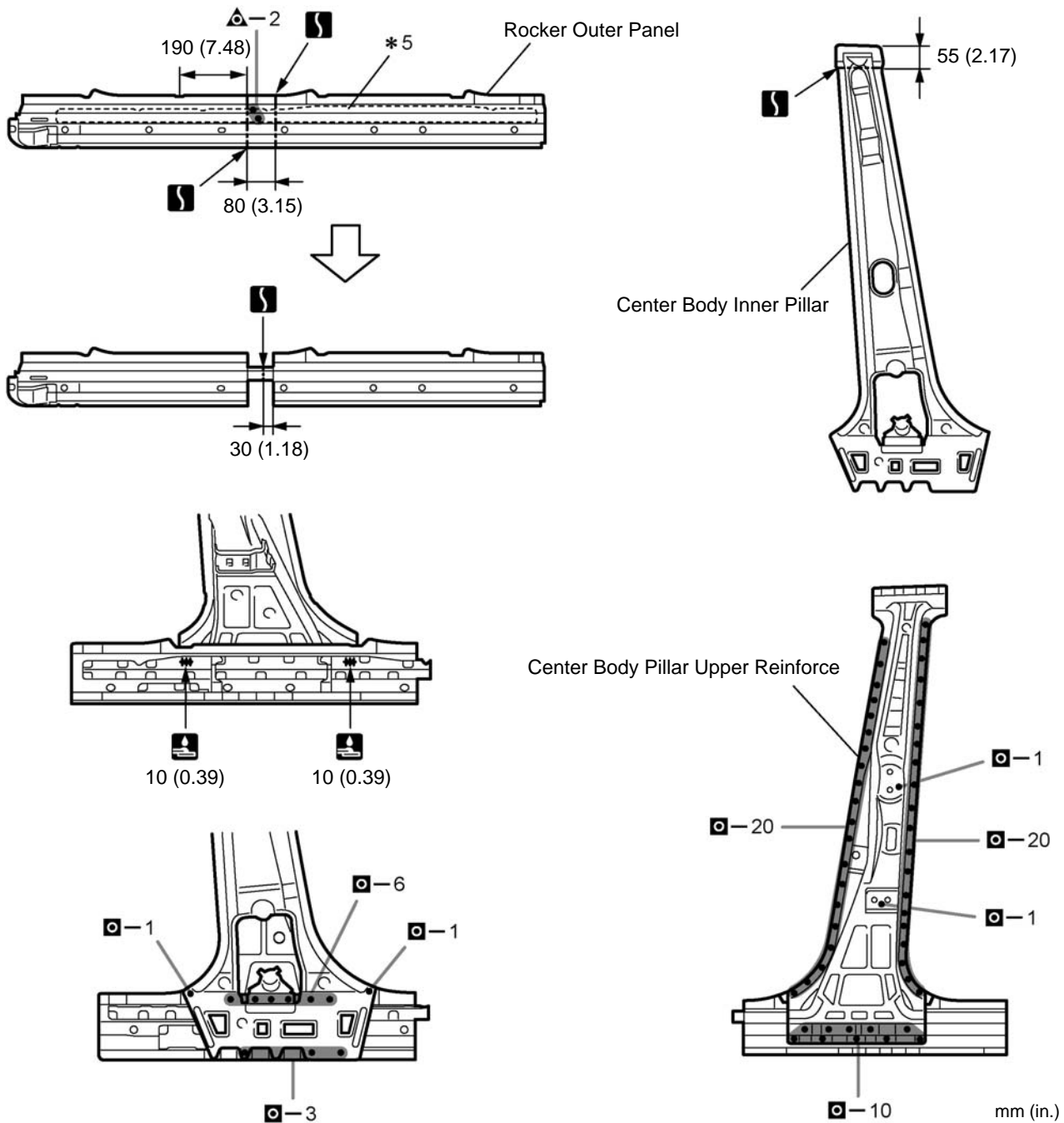
Symbol meaning

△ : Remove Weld Points □ I : Plug Weld S : Cut and Join Location

⌒ : Fillet Weld ⌒ : Butt Weld

F41442B

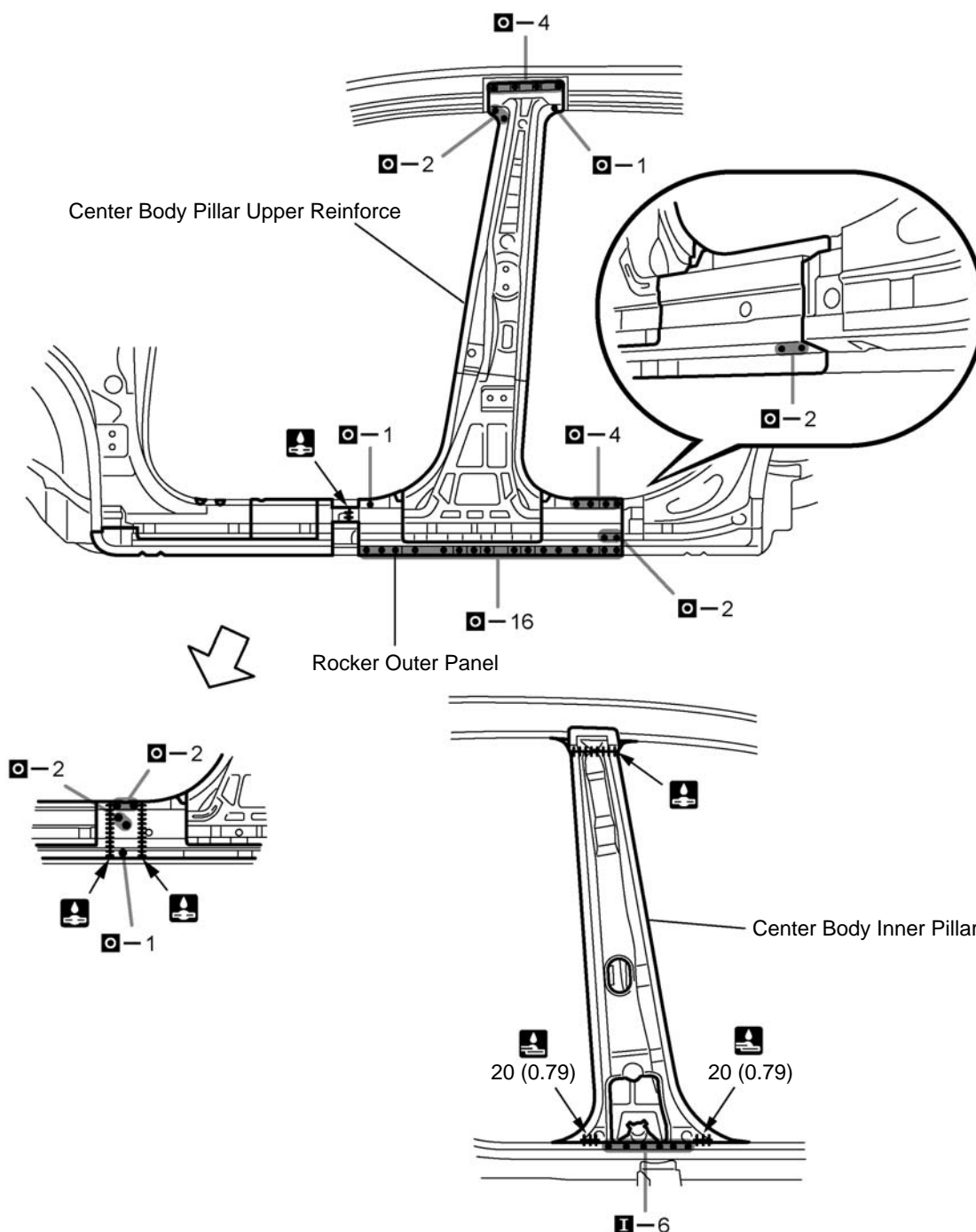
INSTALLATION



F41442

INSTALLATION POINT

- 1 Carefully cut the rocker outer panel so not to damage *5.
- 2 Before temporarily installing the new parts, weld the rocker outer panel, center body pillar upper reinforce and center body inner pillar with the standard number of welding points.



mm (in.)

F41443

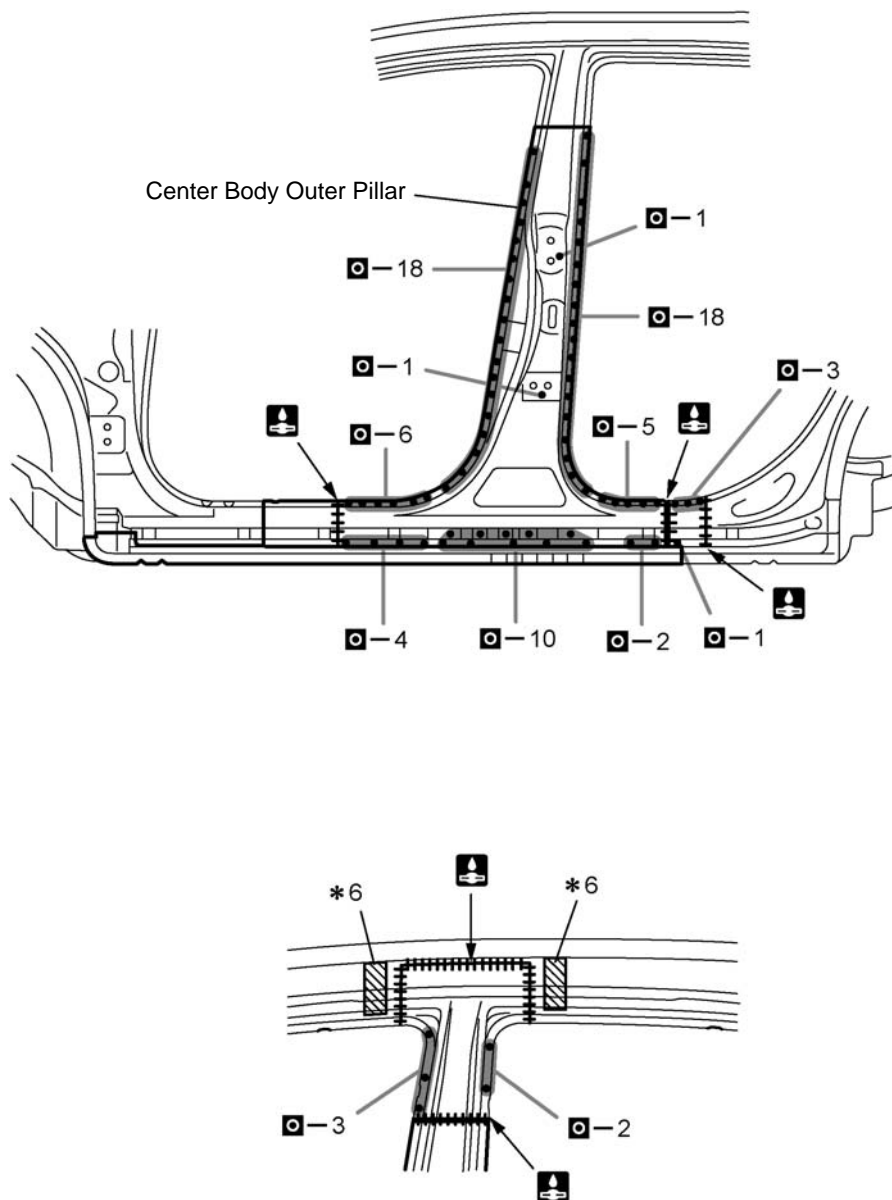
INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 After welding the rocker outer panel, center body pillar upper reinforce and center body inner pillar to the vehicle side, install the center body outer pillar.

Symbol meaning

- ▲ : Remove Weld Points □ I : Plug Weld S : Cut and Join Location
 ☐ : Fillet Weld ☐ : Butt Weld

F41442B

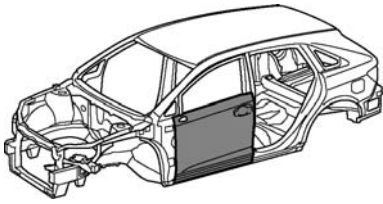


F41444

INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 After welding the rocker outer panel, center body pillar upper reinforce and center body inner pillar to the vehicle side, install the center body outer pillar.
- 4 *6 indicates the location of the foamed sealing material. Be careful when welding as the foamed sealing material is located near the area that is cut and joined together.
- 5 After welding, apply the foamed sealing material to the corresponding parts. (See the paint-coating)
- 6 After welding, apply body sealer to the corresponding parts. (See the paint-coating)
- 7 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

FRONT DOOR OUTER PANEL (ASSY)



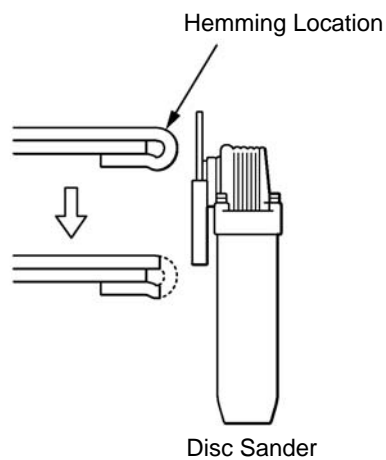
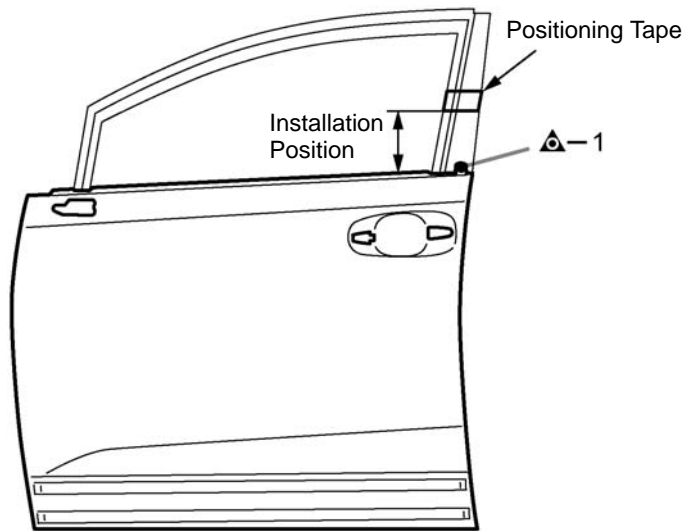
F41445A

Symbol meaning

▲ : Remove Weld Points

F41445B

REMOVAL



F41445

REMOVAL POINT

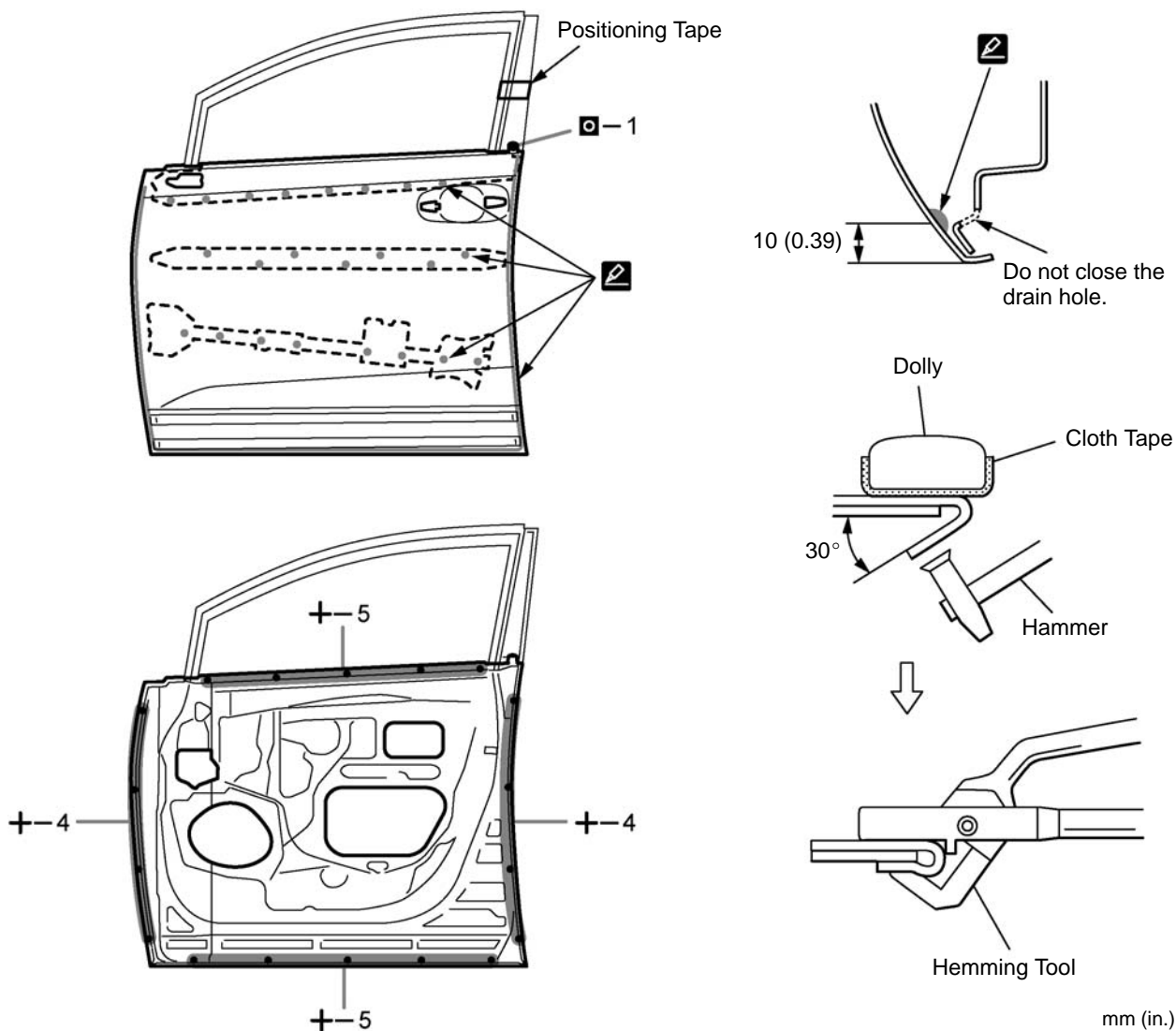
- 1 Before removing the outer panel, mark the installation position with tape.
- 2 Before removing the outer panel, establish its exact position in relation to the window frame using a reference marker, etc.
- 3 After grinding off the hemming location, remove the outer panel.

Symbol meaning

◻ : Plug Weld + : Spot MIG Weld ◻ : Body Sealer

F41446B

INSTALLATION

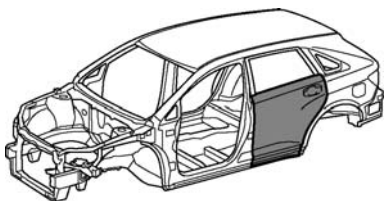


F41446

INSTALLATION POINT

- Before temporarily installing the new parts, apply body sealer to the reinforcement, side impact protection beam and backside of the new parts.
HINT:
Apply sealer evenly about 10 mm (0.39 in.) from the flange and 3 mm (0.12 in.) in diameter on the outer panel and apply just enough sealer for the reinforcement and side impact protection beam to make contact.
- Bend the flange hem about 30° with a hammer and dolly. Then, fasten tightly with a hemming tool.
HINT:
 - Perform hemming in three steps, being careful not to warp the panel.
 - If a hemming tool cannot be used, hem with a hammer and dolly.
- After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

REAR DOOR OUTER PANEL (ASSY)



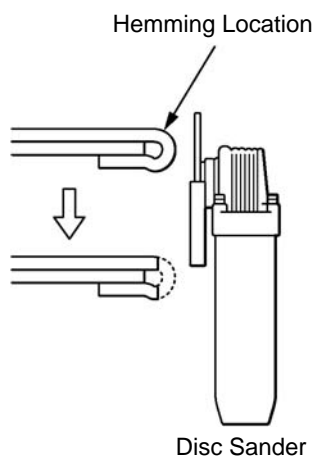
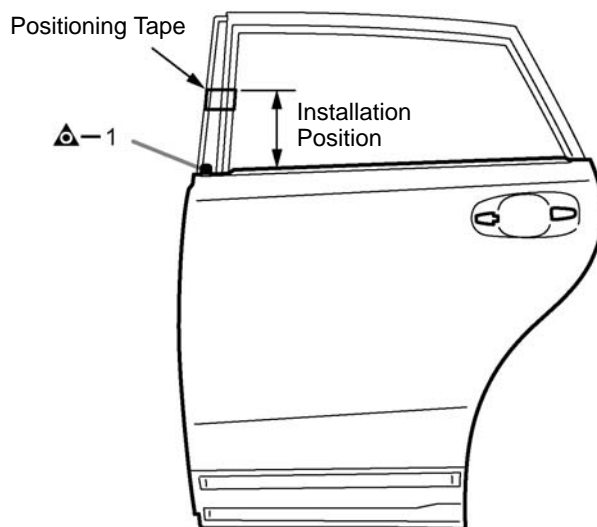
F41447A

Symbol meaning

▲ : Remove Weld Points

F41447B

REMOVAL



F41447

REMOVAL POINT

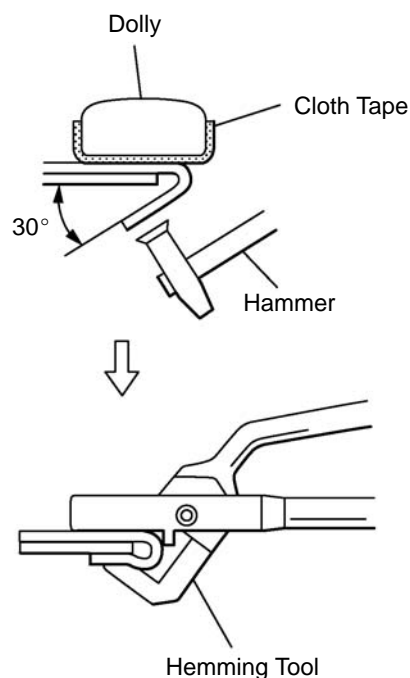
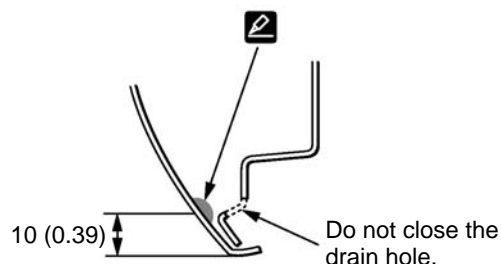
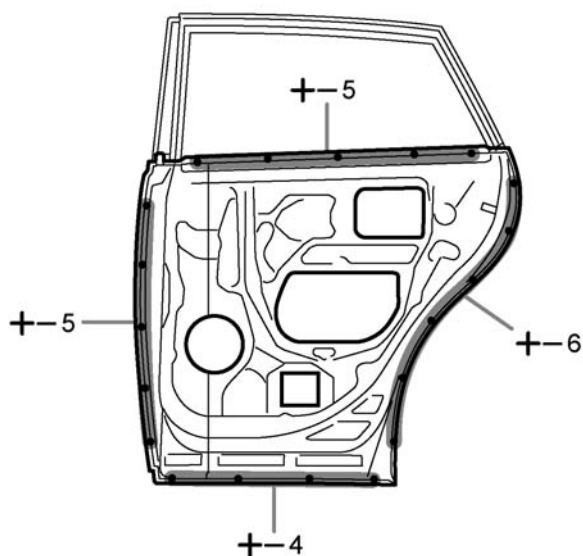
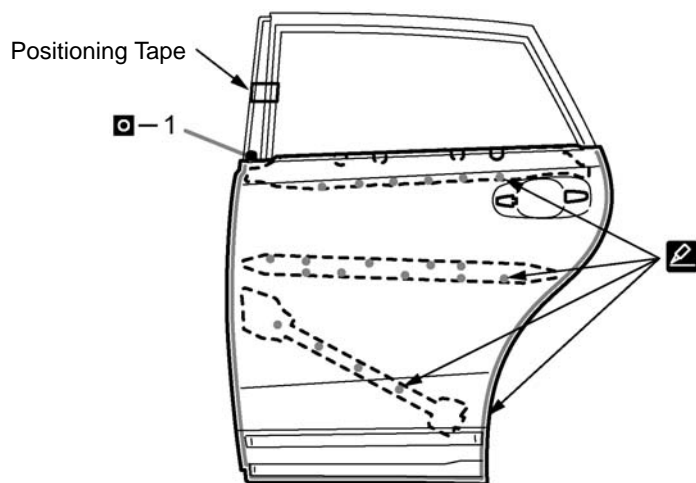
- 1 Before removing the outer panel, mark the installation position with tape.
- 2 Before removing the outer panel, establish its exact position in relation to the window frame using a reference marker, etc.
- 3 After grinding off the hemming location, remove the outer panel.

Symbol meaning

◻ : Plug Weld + : Spot MIG Weld ◻ : Body Sealer

F41448

INSTALLATION



mm (in.)

F41448B

INSTALLATION POINT

- Before temporarily installing the new parts, apply body sealer to the reinforcement, side impact protection beam and backside of the new parts.

HINT:

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

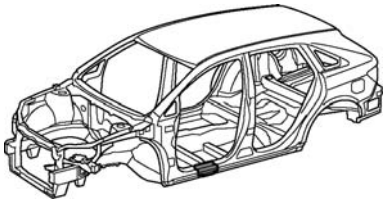
- Bend the flange hem about 30° with a hammer and dolly. Then, fasten tightly with a hemming tool.

HINT:

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

- After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

ROCKER PANEL (CUT-P)



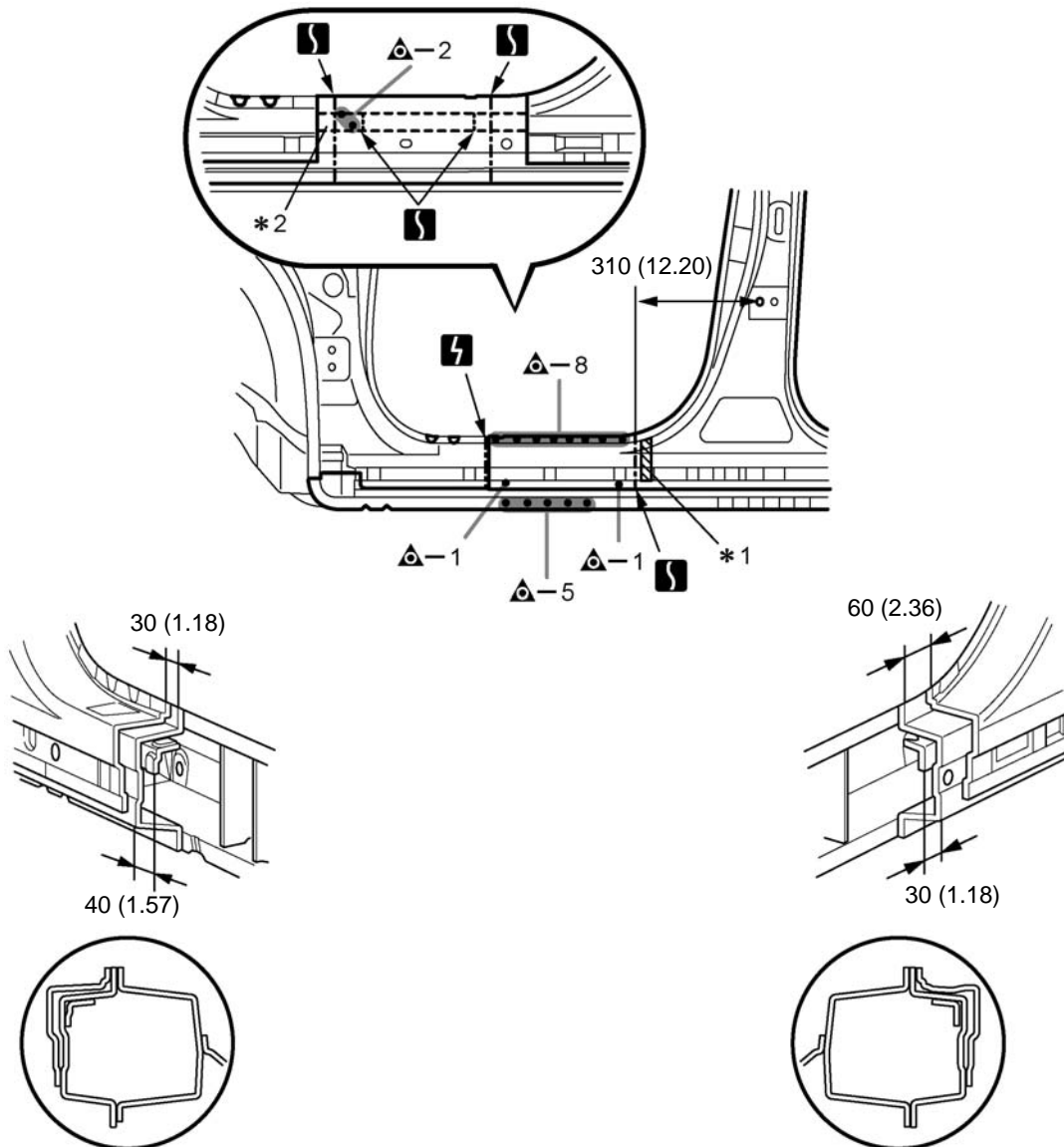
F41449A

Symbol meaning

- ▲ : Remove Weld Points S : Cut and Join Location
 ⚡ : Cut Location for Supply Parts

F41449B

REMOVAL



mm (in.)

F41449

REMOVAL POINT

- *1 indicates the location of the foamed sealing material. Be careful when cutting as the foamed sealing material is located near the cutting position.
- Carefully cut the rocker outer panel so not to damage *2.

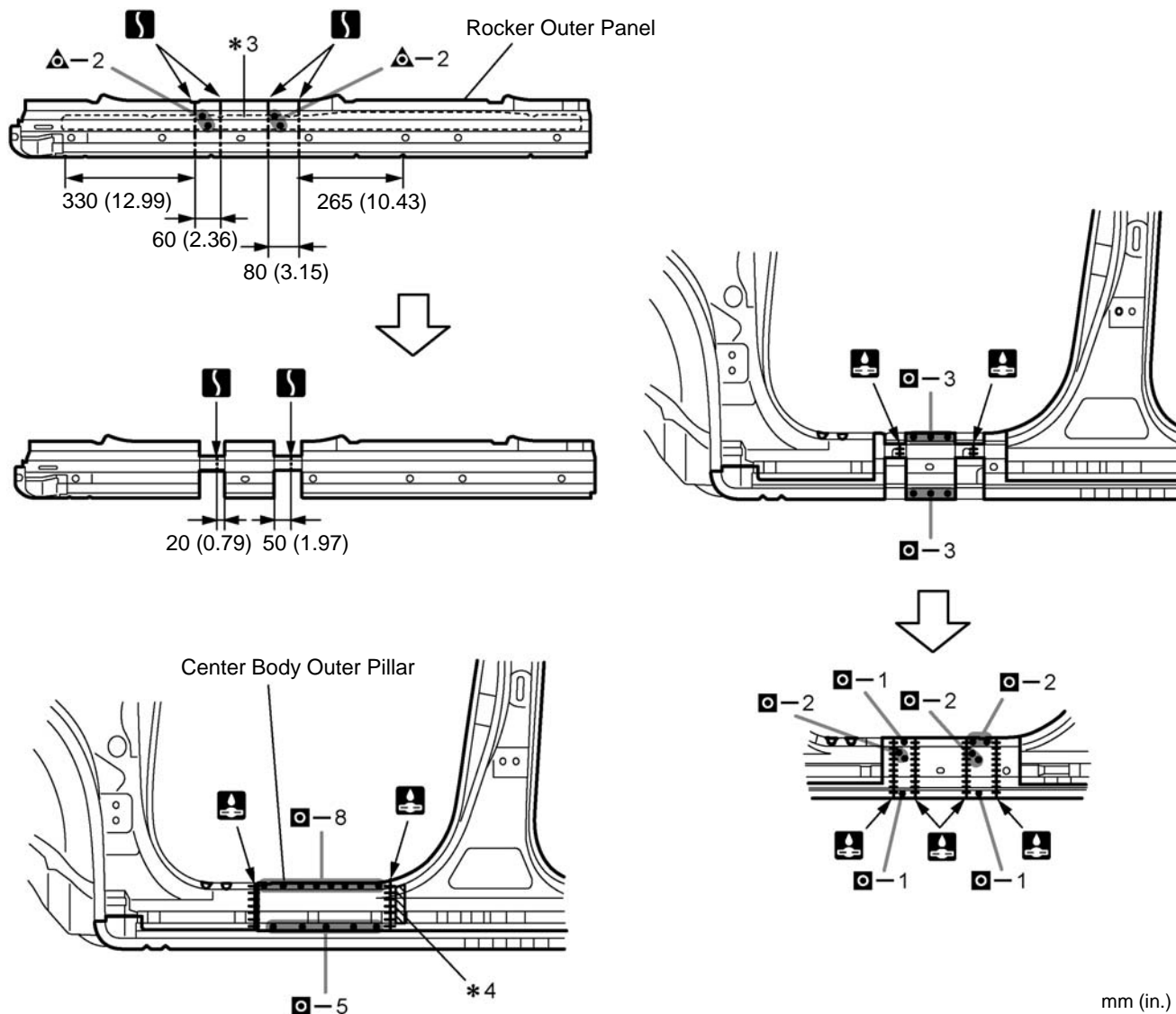
Symbol meaning

△ : Remove Weld Points □ : Plug Weld S : Cut and Join Location

⬮ : Butt Weld

F41450B

INSTALLATION



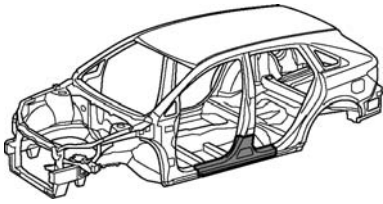
mm (in.)

F41450

INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 Carefully cut the rocker outer panel so not to damage *3.
- 4 *4 indicates the location of the foamed sealing material. Be careful when welding as the foamed sealing material is located near the area that is cut and joined together.
- 5 After welding the rocker outer panel to the vehicle side, install the center body outer pillar.
- 6 After welding, apply body sealer to the corresponding parts. (See the paint-coating)
- 7 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

ROCKER PANEL (CUT)



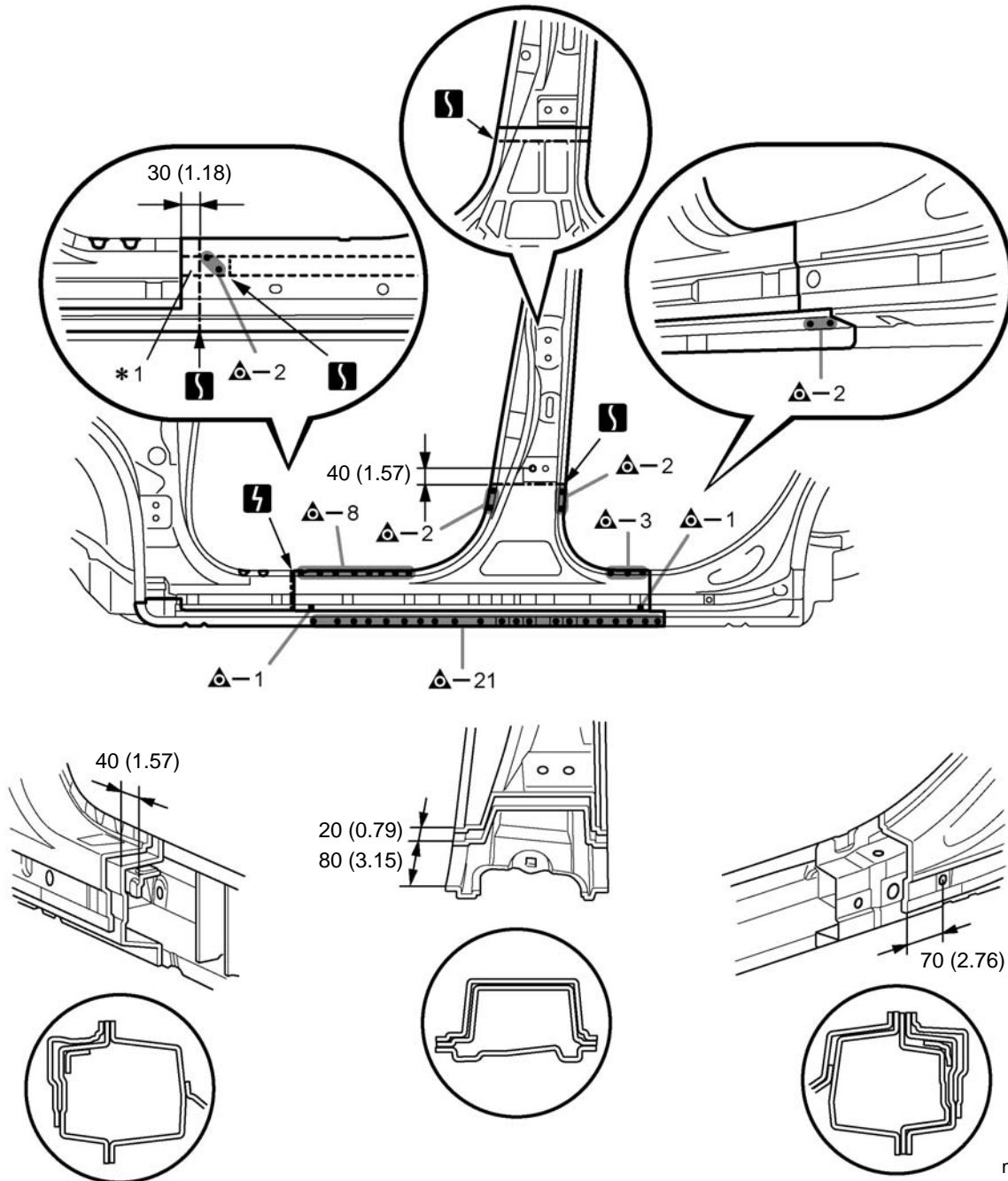
F41451A

Symbol meaning

- : Remove Weld Points
 : Cut with Disc Sander etc.
 : Cut and Join Location
 : Cut Location for Supply Parts

F41451B

REMOVAL



mm (in.)

F41451

REMOVAL POINT

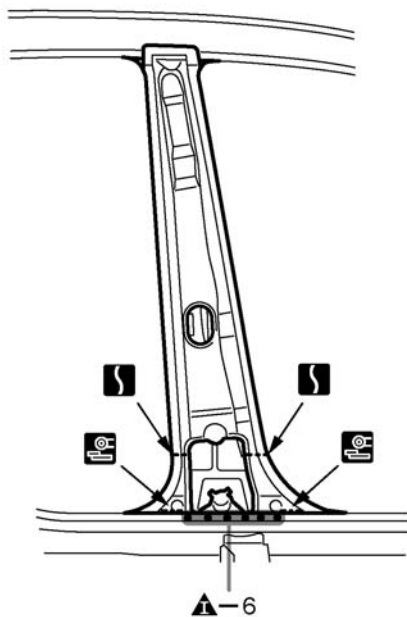
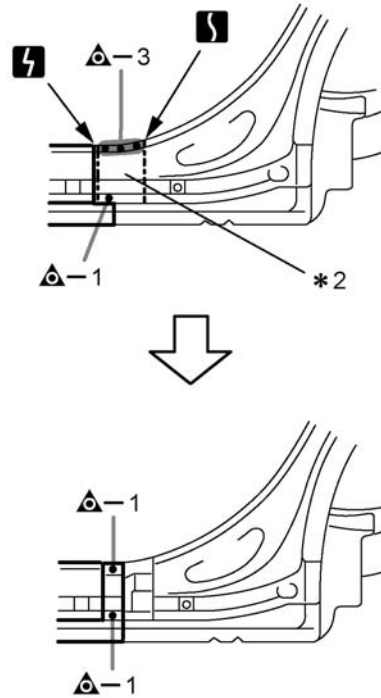
- 1 Carefully cut the rocker outer panel so not to damage *1.

Symbol meaning

⚠ ⚠ : Remove Weld Points ⚡ : Cut with Disc Sander etc.

⌂ : Cut and Join Location ⚡ : Cut Location for Supply Parts

F41451B









F41452

REMOVAL POINT

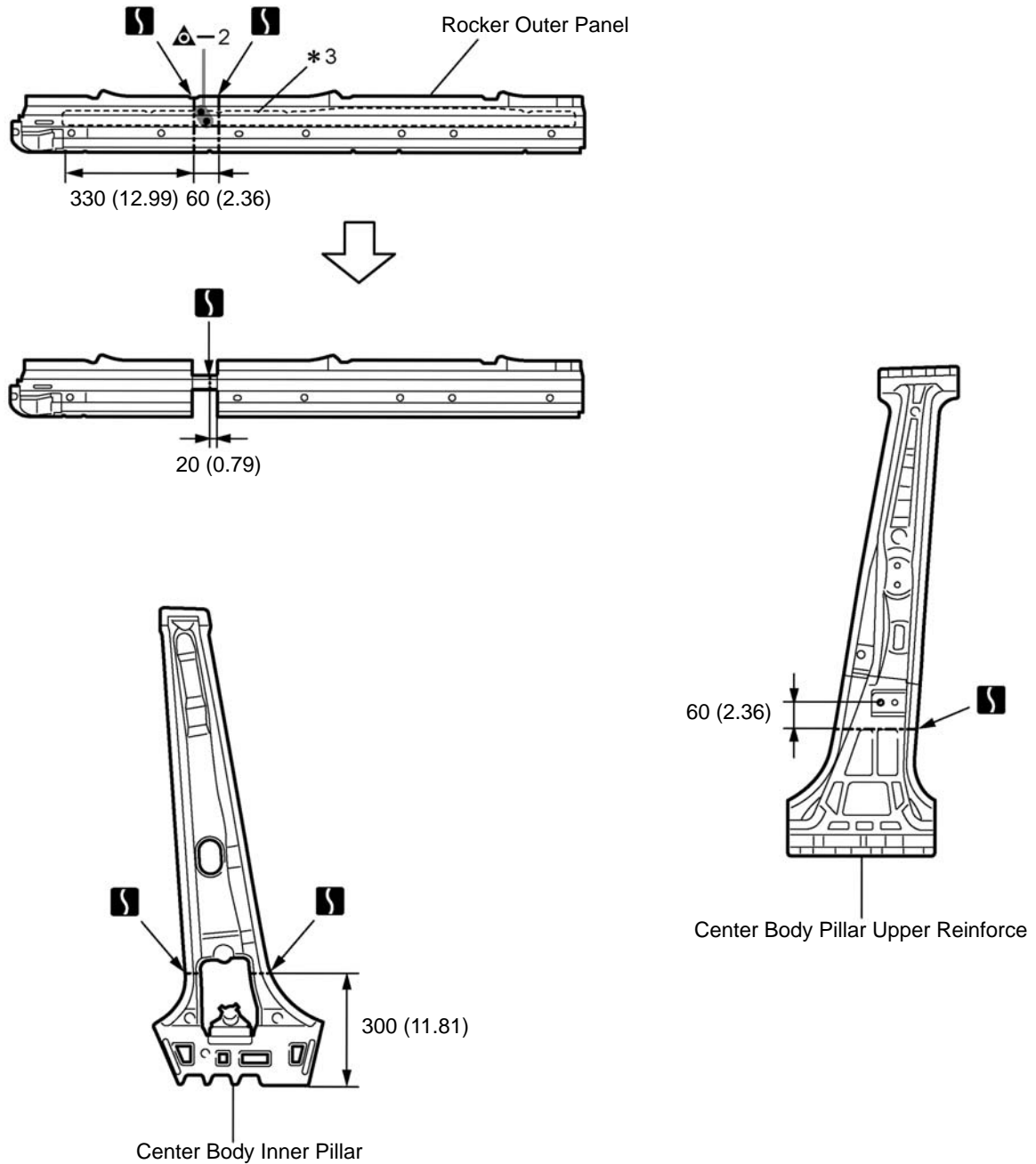
1 Reuse *2, as the area of the outer panel that is cut and joined is to the rear of the supplied part cut position.

Symbol meaning

-  : Remove Weld Points
   : Plug Weld
  : Cut and Join Location
 : Fillet Weld
 : Butt Weld

F41453B

INSTALLATION



mm (in.)

F41453

INSTALLATION POINT

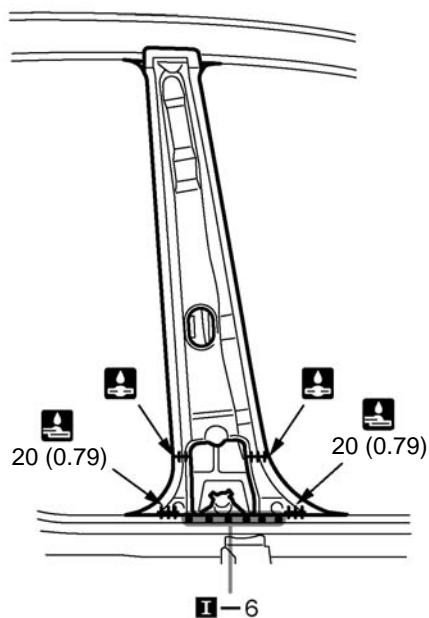
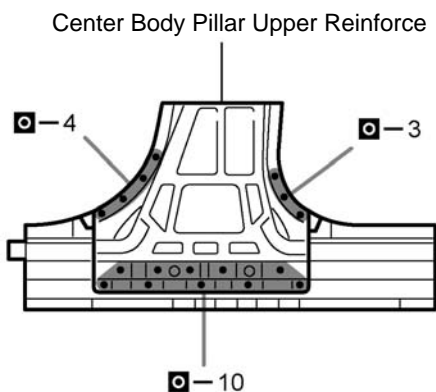
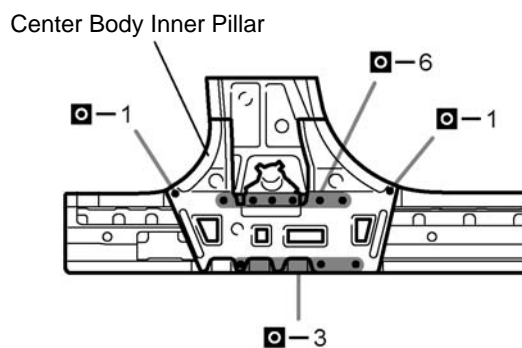
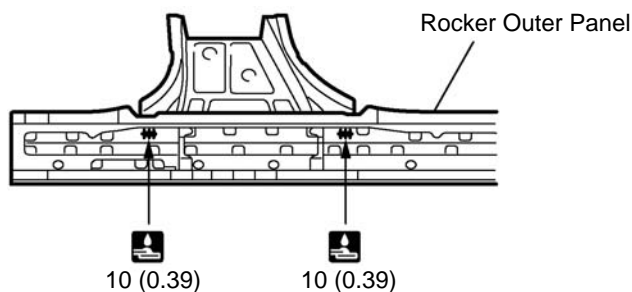
- Carefully cut the rocker outer panel so not to damage *3.

Symbol meaning

△ : Remove Weld Points □ T : Plug Weld S : Cut and Join Location

⬮ : Fillet Weld ⬮ : Butt Weld

F41453B

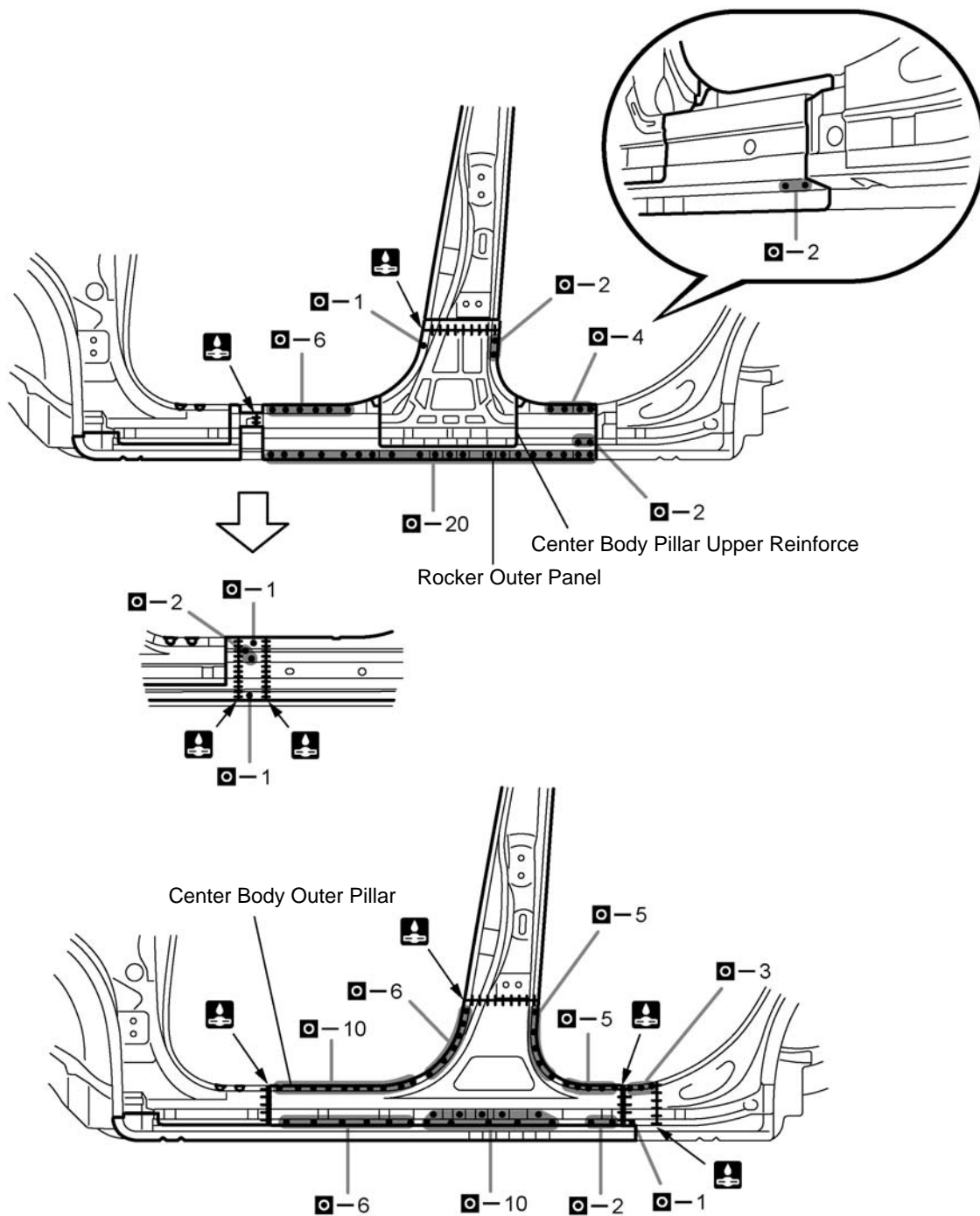


mm (in.)

F41454

INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 Before temporarily installing the new parts, weld the rocker outer panel, center body pillar upper reinforce and center body inner pillar with the standard number of welding points.
- 4 After welding the rocker outer panel, center body pillar upper reinforce and center body inner pillar to the vehicle side, install the center body outer pillar.

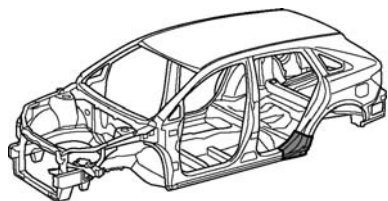


F41455

INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 After welding the rocker outer panel, center body pillar upper reinforce and center body inner pillar to the vehicle side, install the center body outer pillar.
- 4 After welding, apply the foamed sealing material to the corresponding parts. (See the paint-coating)
- 5 After welding, apply body sealer to the corresponding parts. (See the paint-coating)
- 6 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

ROCKER OUTER REINFORCE (CUT)



F41456A

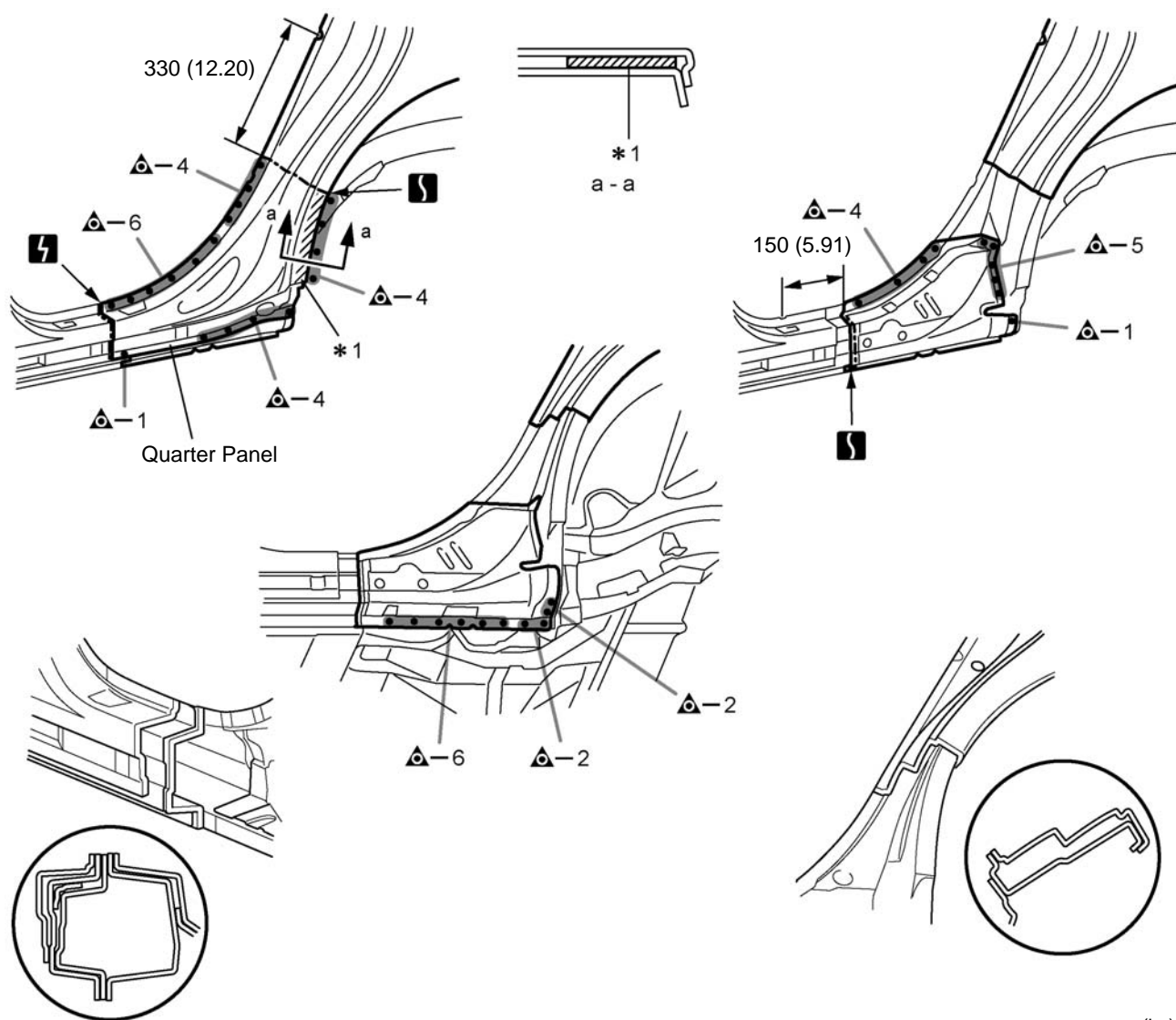
Symbol meaning

△ : Remove Weld Points S : Cut and Join Location

⚡ : Cut Location for Supply Parts

F41456B

REMOVAL



mm (in.)

F41456

REMOVAL POINT

- 1 After removing the quarter panel, remove the rocker outer reinforce.
- 2 *1 in illustration above indicates where the adhesive is located.
- 3 Roughly cut open the panel so that the adhesive can be reached. Cut through the adhesive with a cut chisel to remove the panel.

HINT:

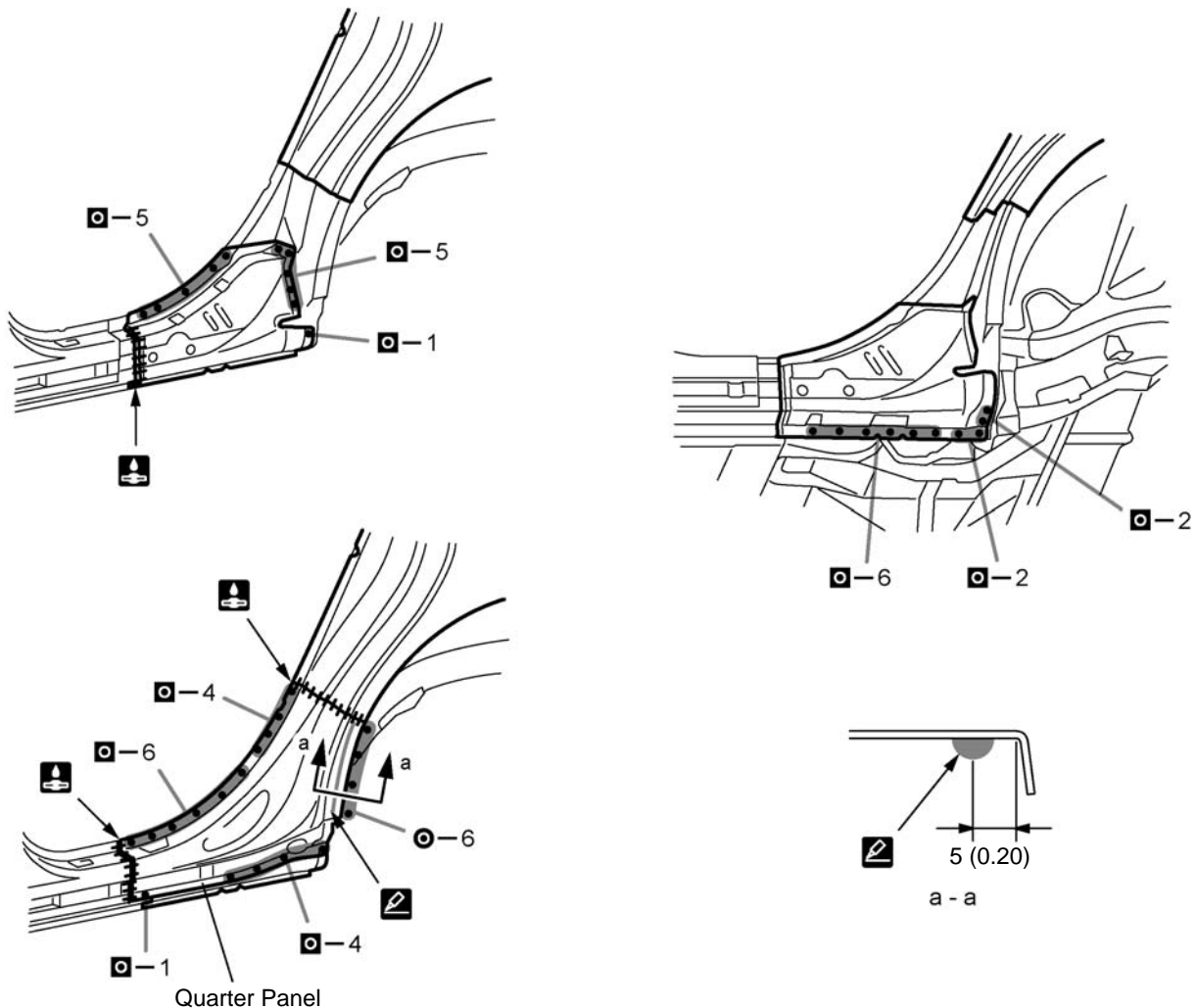
In cases where the adhesive cannot be removed with a cut chisel, heat the adhesive with an industrial heater gun or gas burner taking care not to cause panel deformation by overheating.

Symbol meaning

- : Spot Weld □ : Plug Weld 🔥 : Butt Weld
 🛡 : Body Sealer

F41457B

INSTALLATION



mm (in.)

F41457

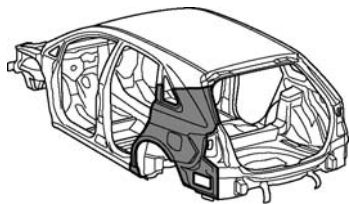
INSTALLATION POINT

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

HINT:

 - Apply body sealer evenly about 5 mm (0.20 in.) from the flange, avoiding any oozing.
 - Apply sealer evenly, about 3 – 4 mm (0.12 – 0.16 in.) in diameter.
- 4 After welding the rocker outer reinforce to the vehicle side, install the quarter panel.
- 5 After welding, apply body sealer to the corresponding parts. (See the paint-coating)
- 6 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

QUARTER PANEL (CUT)



F41458A

Quarter Panel Replacement Using Adhesive

Work Procedure	Precaution
<ol style="list-style-type: none"> 1. Cut the wheel arch portion. 2. Heat the quarter panel adhesive area and remove the quarter panel. 3. Clean off any adhesive that remains on the vehicle. 4. Using a disc grinder or belt sander, scuff and sand any adhesive that remains on the vehicle. 5. Apply adhesive to the exposed metal areas on the vehicle. Using a spatula, spread the adhesive evenly. 6. Apply adhesive to the vehicle again. 7. Using #60-120 grit sandpaper, scuff the adhesive application area on the new quarter panel. 8. Apply adhesive to the new quarter panel. Using a spatula, spread the adhesive evenly. 9. Using a vise grip or the palms of your hands, press the quarter panel so that the thickness of the adhesive is even. 10. Complete installation the new quarter panel. 11. Dry the adhesive areas of the new quarter panel. 	<ol style="list-style-type: none"> (1) Using an industrial heater gun or gas burner, heat the quarter panel to 110 to 140°C. Make sure the quarter panel does not warp. (1) Using an industrial heater gun or gas burner, heat the adhesive to 110 to 140°C. (2) Using a scraper, scrape away the adhesive. (3) If adhesive remains, the strength of any subsequently applied adhesive will be weak. (1) Scuff at a width of approximately 10 mm (0.39 in.) over the previous adhesive coating. (1) Hardening Time Estimation With dryer or equivalent (60°C): 60 minutes (complete hardening: 90 minutes) Ambient temperature (25°C): 12 hours (complete hardening: 24 hours)

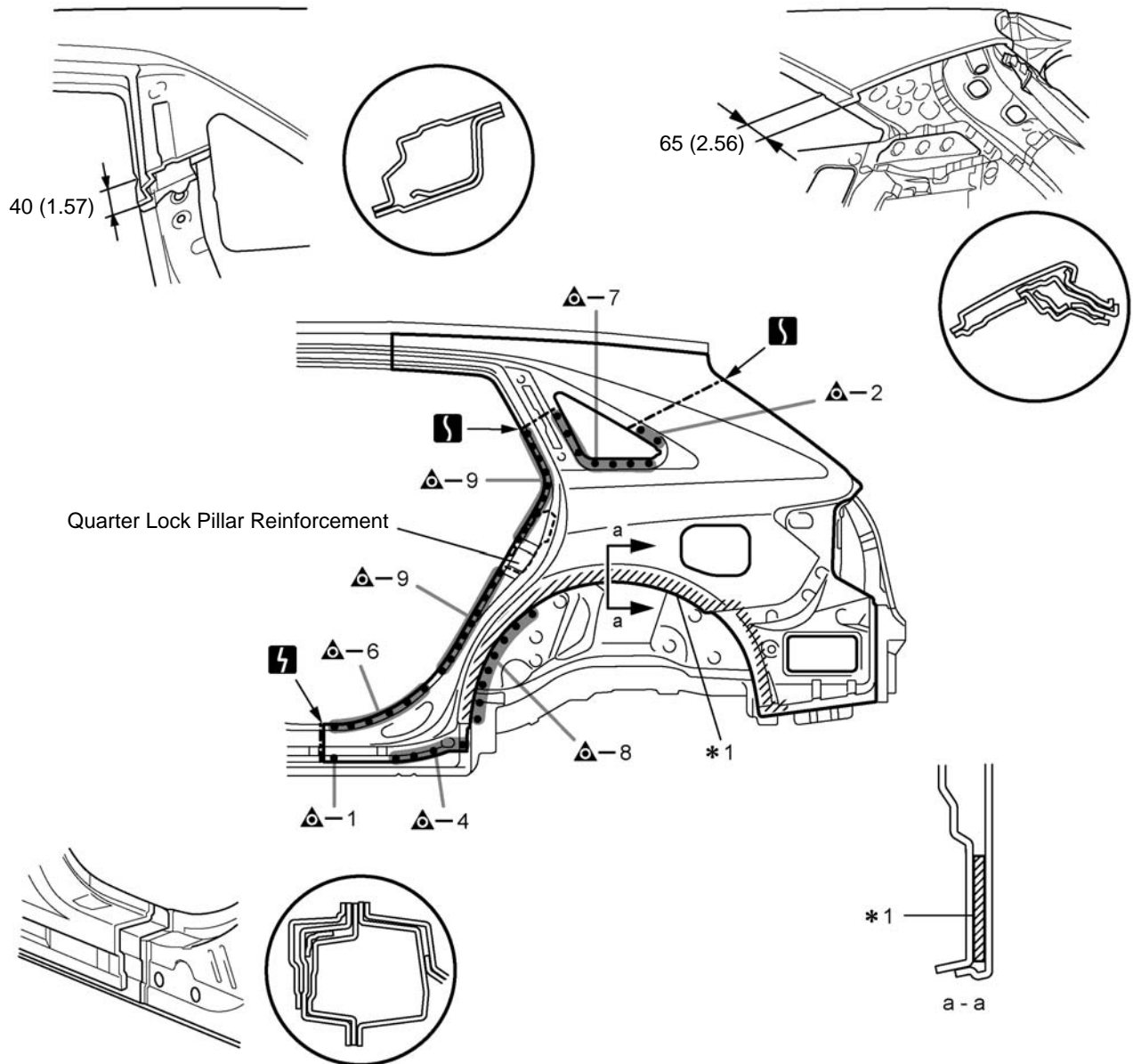
Symbol meaning

△ △ △ : Remove Weld Points S : Cut and Join Location

⚡ : Cut Location for Supply Parts

F41458B

REMOVAL



mm (in.)

F41458

REMOVAL POINT

- 1 Remove the quarter lock pillar reinforcement at the same time.
- 2 *1 in illustration above indicates where the adhesive is located.
- 3 Roughly cut open the panel so that the adhesive can be reached. Cut through the adhesive with a cut chisel to remove the panel.

HINT:

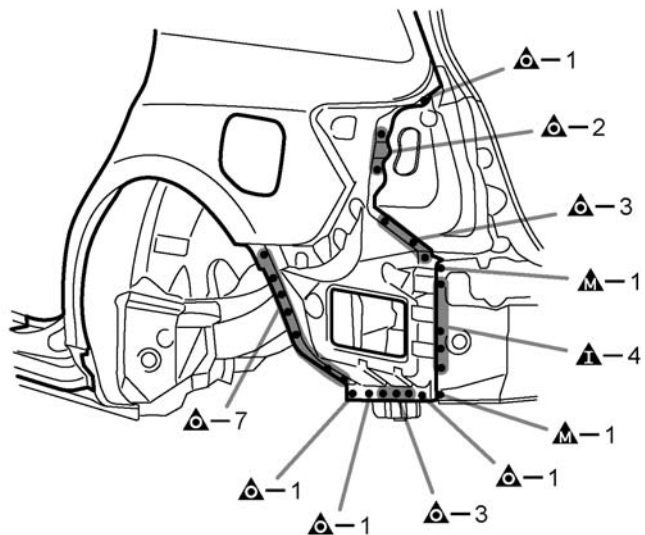
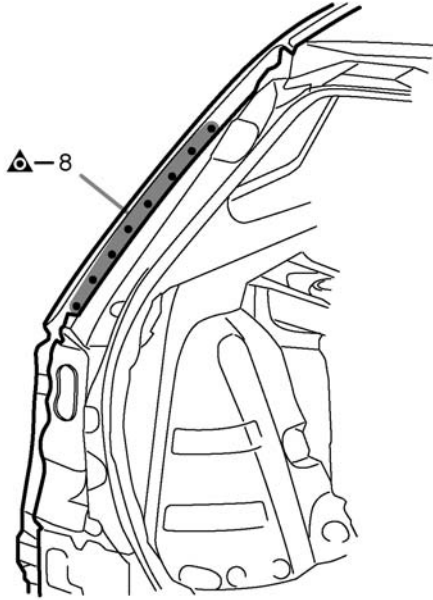
In cases where the adhesive cannot be removed with a cut chisel, heat the adhesive with an industrial heater gun or gas burner taking care not to cause panel deformation by overheating.

Symbol meaning

△ △ △ : Remove Weld Points S : Cut and Join Location

⚡ : Cut Location for Supply Parts

F41458B



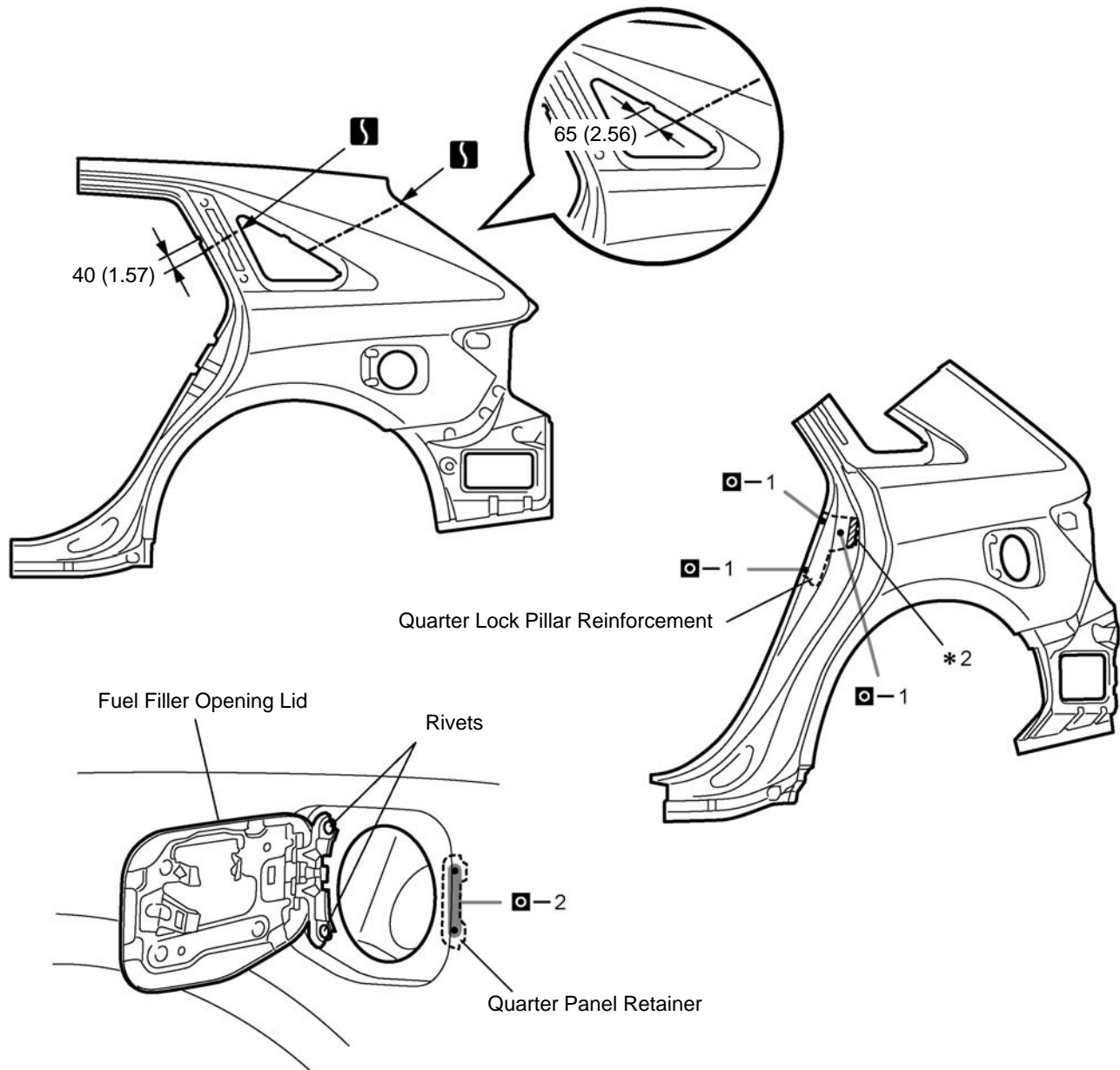
F41459

Symbol meaning

- : Spot Weld □ M I : Plug Weld S : Cut and Join Location
 ■ : Butt Weld ■ : Body Sealer

F41460B

INSTALLATION



mm (in.)

F41460

INSTALLATION POINT

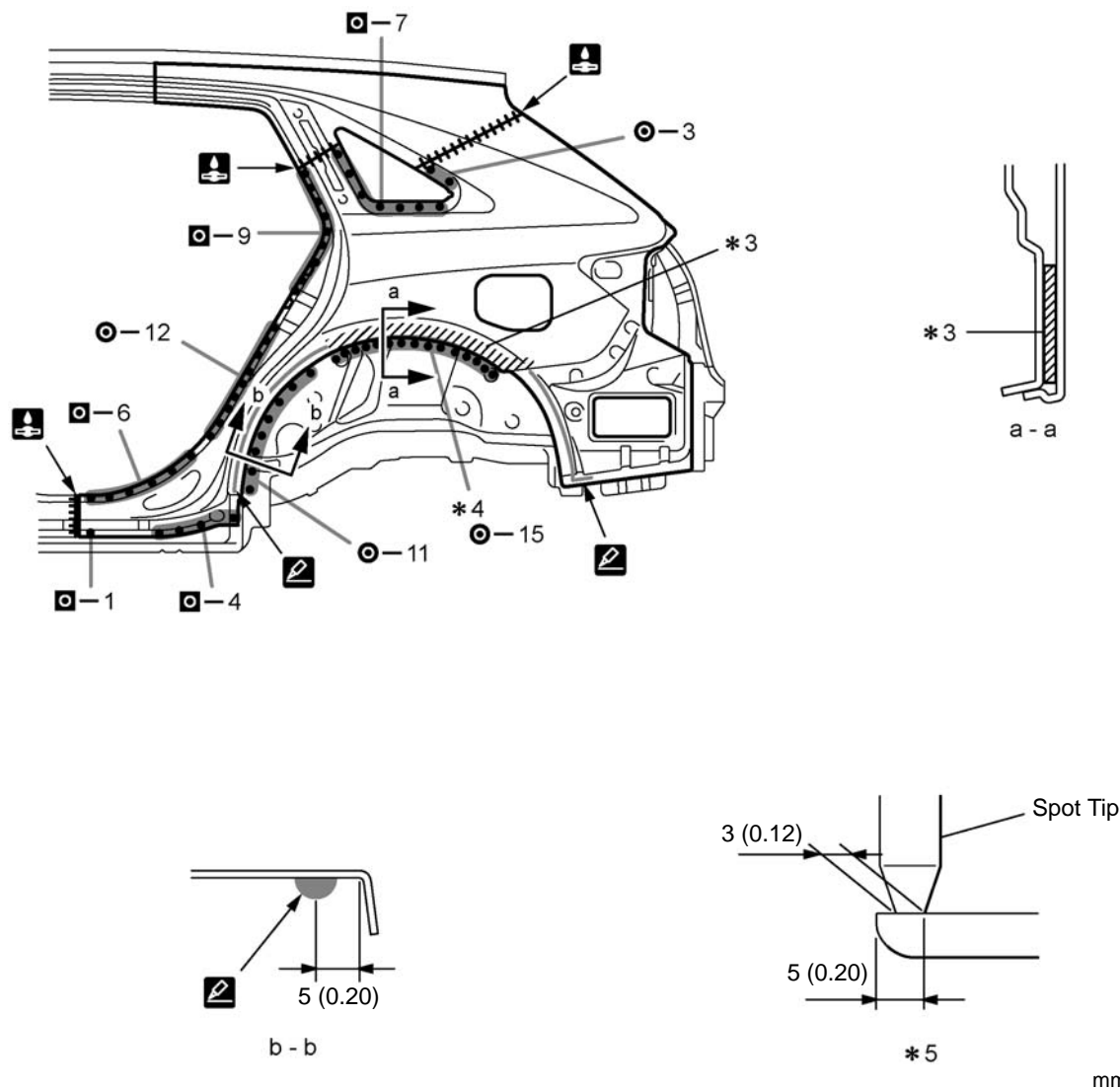
- Before temporarily installing the new parts, weld the quarter lock pillar reinforcement and quarter panel retainer with the standard number of welding points.
- Apply adhesive (3M™ Automix™ Panel Bonding Adhesive #8115) to the area indicated by *2 in the illustration.
HINT:
 Apply enough adhesive for the panels to stick to each other.

Symbol meaning

 : Spot Weld
 M **I** : Plug Weld
 : Cut and Join Location

 : Butt Weld  : Body Sealer

F41460B

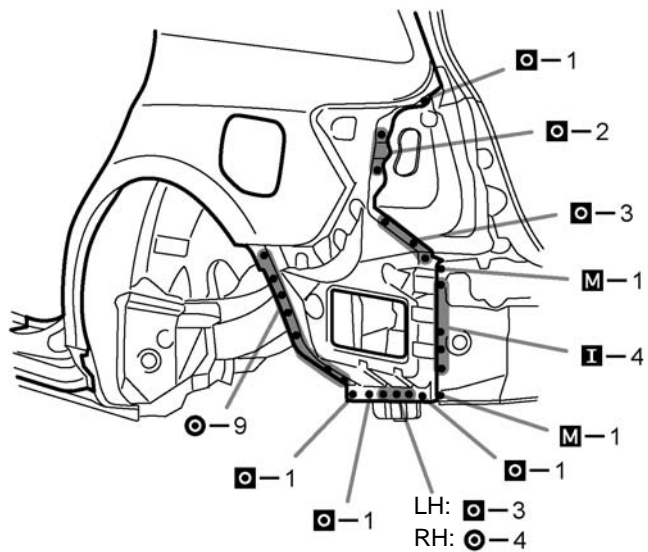
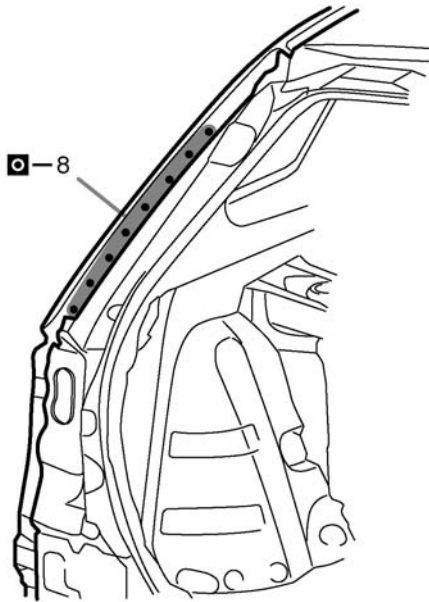


mm (in.)

F41461

INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 Apply adhesive (3M™ Automix™ Panel Bonding Adhesive #8115) to the area indicated by *3 in the illustration.
HINT:
Apply enough adhesive for the panels to stick to each other.
- 4 Perform spot-welding on the flange indicated by *4 in the illustration. Modify/cut the spot tip as shown in the illustration*5 so that it can fit in to the narrow flange.
- 5 Before installing a new part, apply body sealer.
HINT:
 - Apply body sealer evenly about 5 mm (0.20 in.) from the flange, avoiding any oozing.
 - Apply sealer evenly, about 3 – 4 mm (0.12 – 0.16 in.) in diameter.

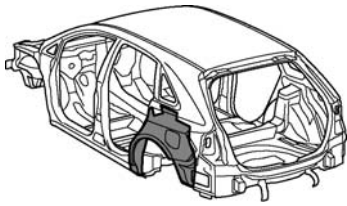


F41462

INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 After welding, apply foamed sealing material to the corresponding parts. (See the paint-coating)
- 4 After welding, apply body sealer to the corresponding parts. (See the paint-coating)
- 5 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

QUARTER WHEEL HOUSING OUTER PANEL (ASSY)



F41463A

With the rocker outer reinforce and quarter panel removed.

Symbol meaning

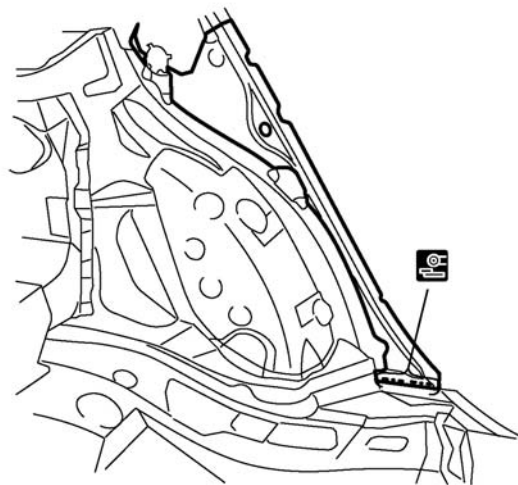
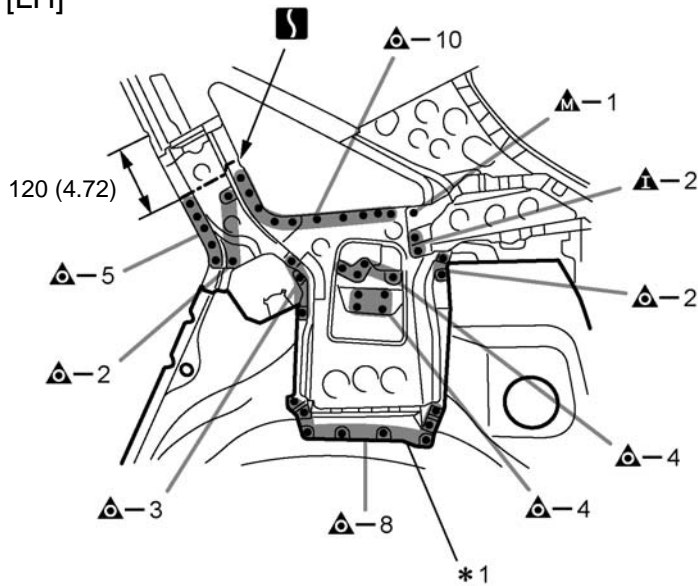
▲▲▲ : Remove Weld Points ☞ : Cut with Disc Sander etc.

☞ : Cut and Join Location

F41463B

REMOVAL

[LH]



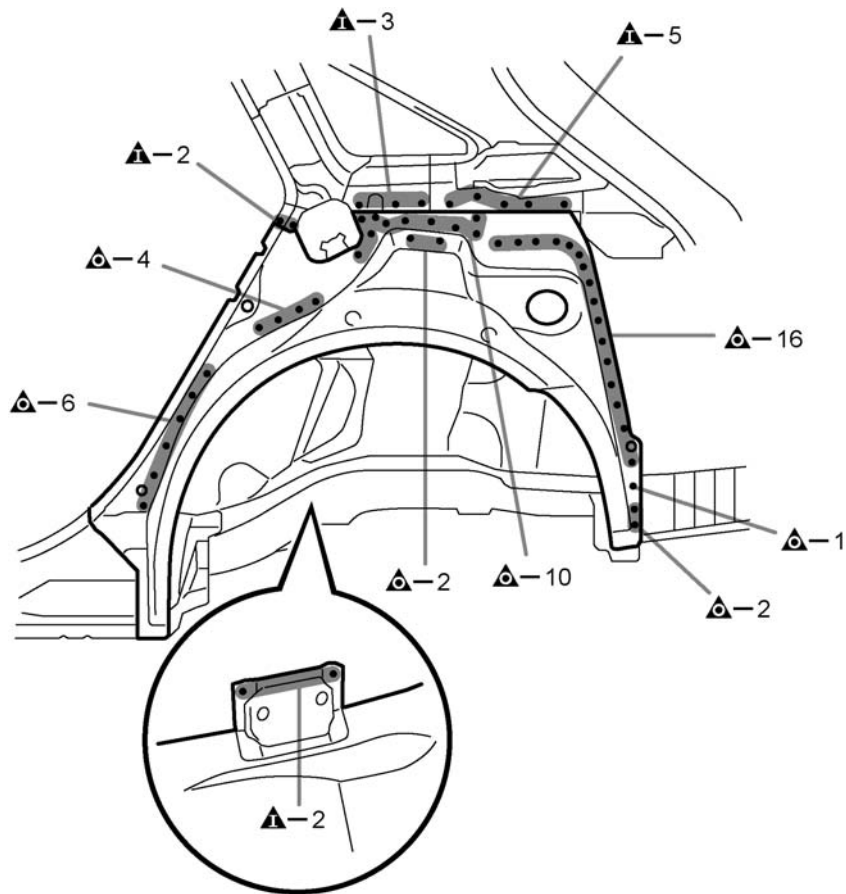
mm (in.)

F41463


REMOVAL POINT


- 1 *1 is reused.
- 2 After removing the *1, remove the quarter wheel housing outer panel.

[LH]



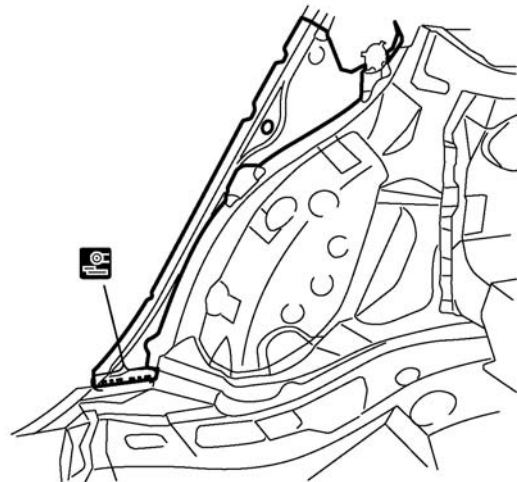
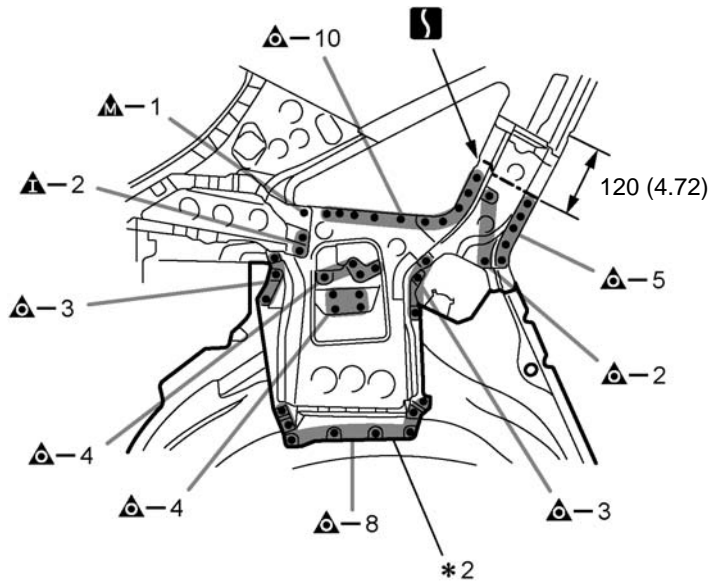
Symbol meaning

△ △ △ : Remove Weld Points  : Cut with Disc Sander etc.

 : Cut and Join Location

F41463B

[RH]



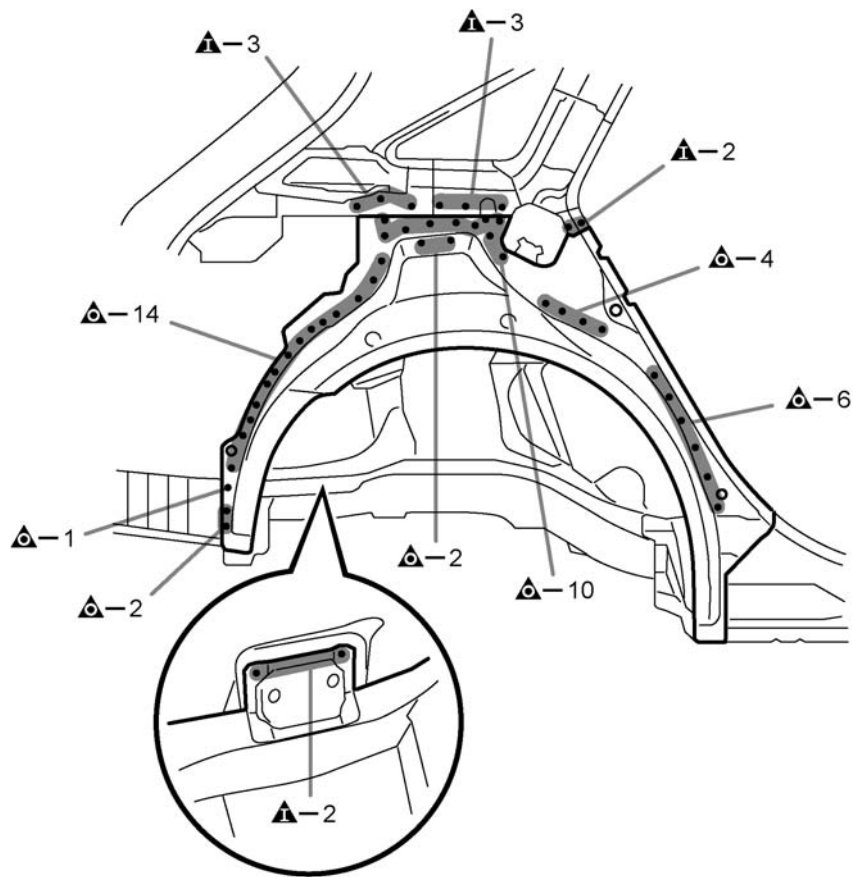
mm (in.)

F41465


REMOVAL POINT

- 1 *2 is reused.
- 2 After removing the *2, remove the quarter wheel housing outer panel.

[RH]



Symbol meaning

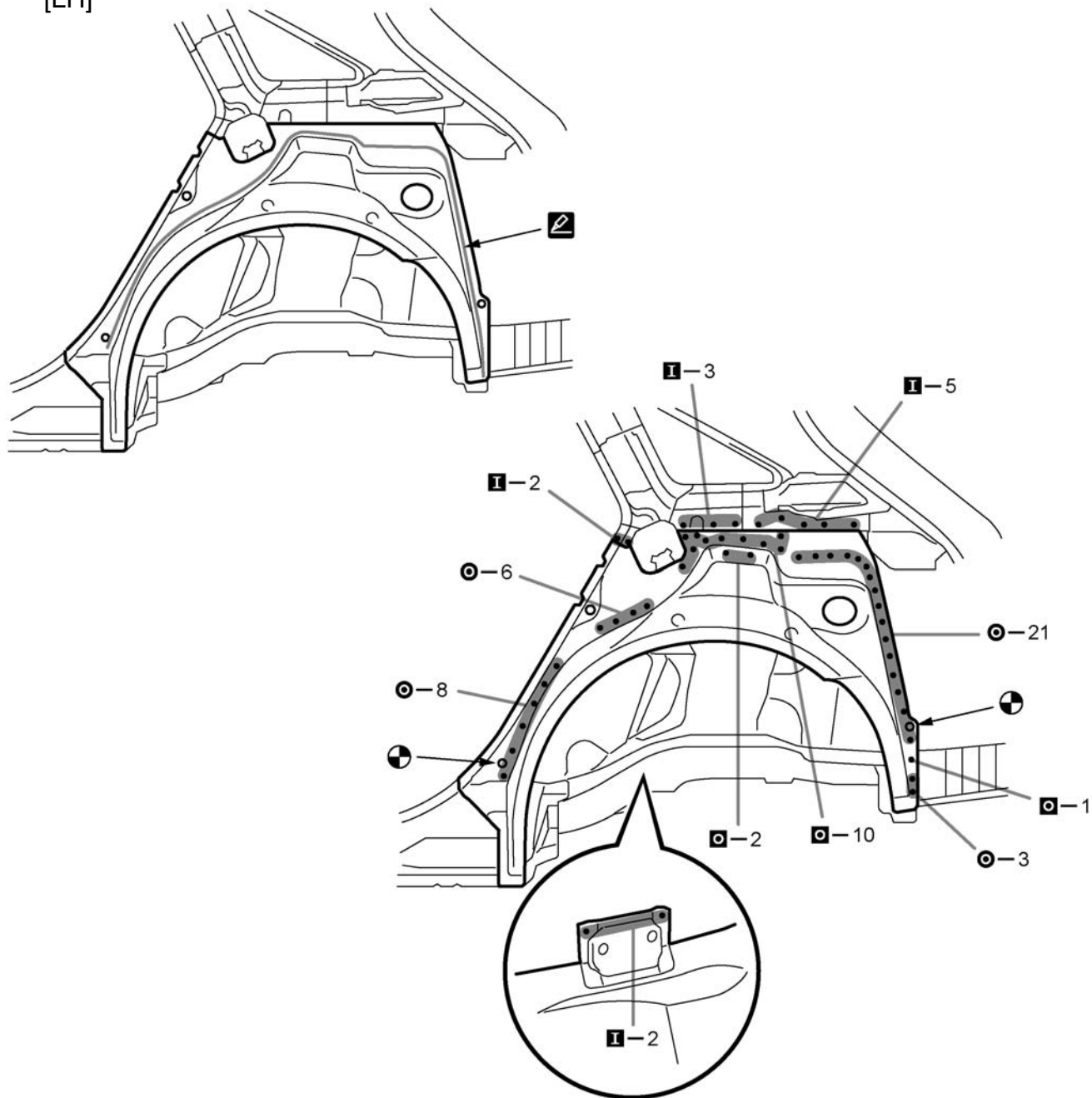
⊙ : Spot Weld □ M I : Plug Weld  : Fillet Weld

 : Butt Weld  : Body Sealer

F41467B

INSTALLATION

[LH]



F41467

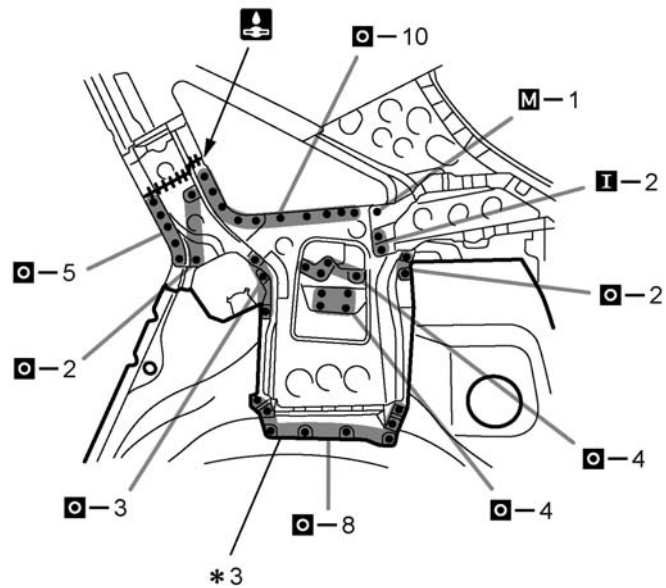
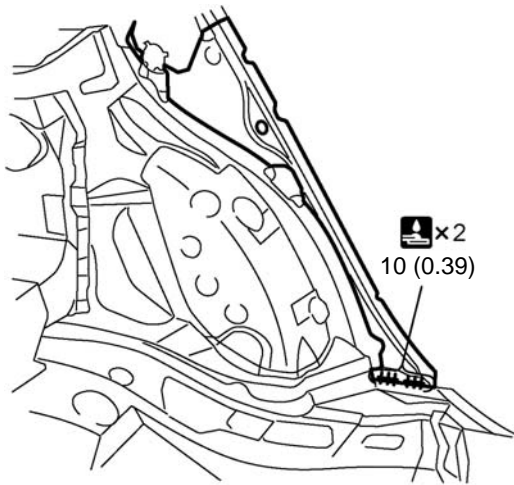
INSTALLATION POINT

- 1 For positioning of the new parts, align the installation standard holes of the outer panel and the inner panel.
- 2 Before installing a new part, apply body sealer.

HINT:

Apply sealer in an even, continuous bead.

[LH]



mm (in.)

F41468

INSTALLATION POINT

- 1 After welding the quarter wheel housing outer panel to the vehicle side, install the *3.
- 2 After welding, apply body sealer and undercoating to the corresponding parts. (See the paint-coating)
- 3 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

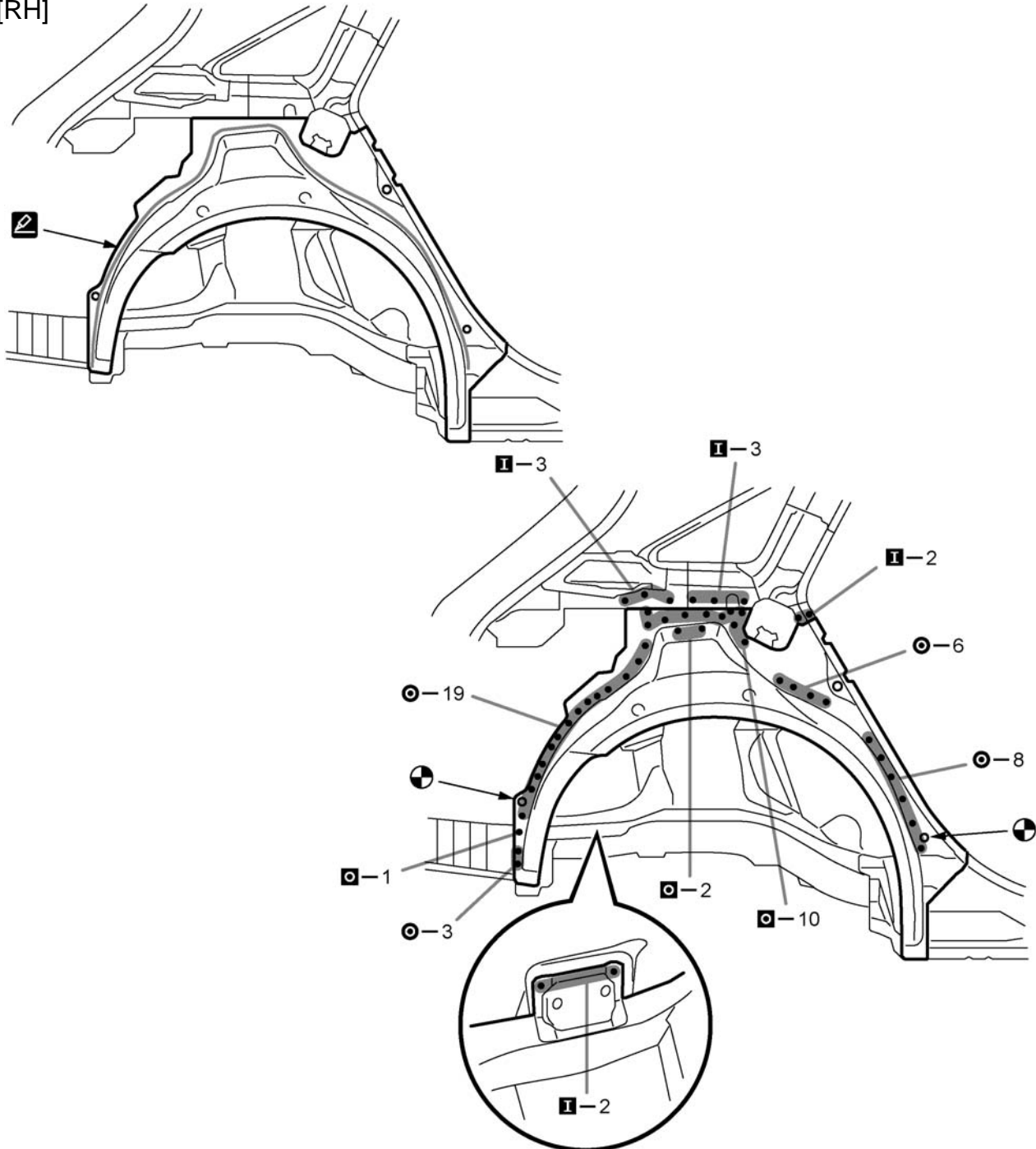
Symbol meaning

○ : Spot Weld □ M I : Plug Weld ■ : Fillet Weld

■ : Butt Weld ■ : Body Sealer

F41467B

[RH]



F41469

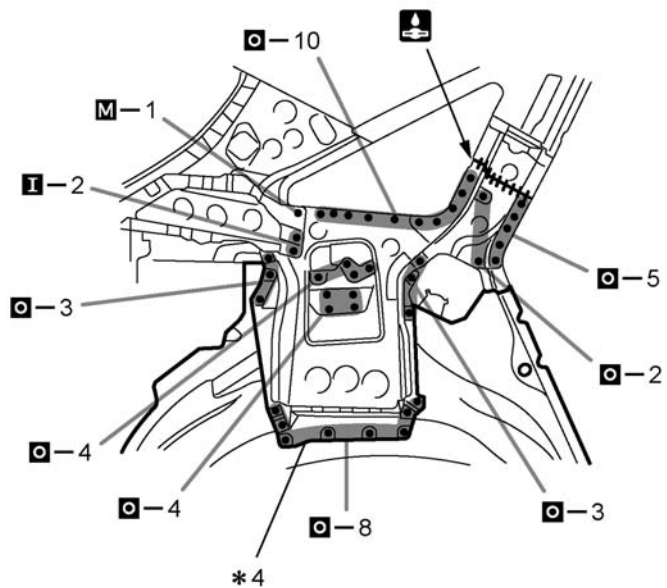
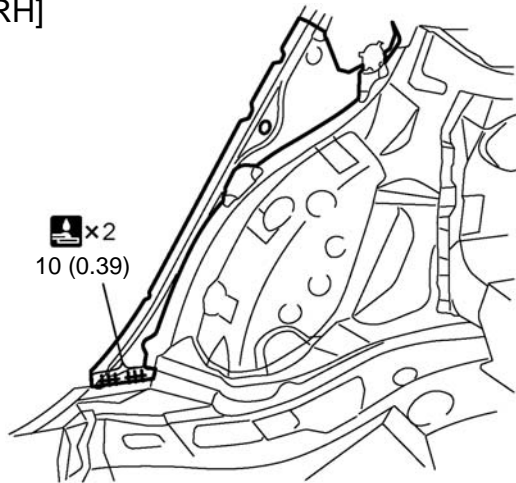
INSTALLATION POINT

- 1 For positioning of the new parts, align the installation standard holes of the outer panel and the inner panel.
- 2 Before installing a new part, apply body sealer.

HINT:

Apply sealer in an even, continuous bead.

[RH]



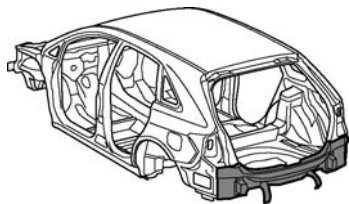
mm (in.)

F41470

INSTALLATION POINT

- 1 After welding the quarter wheel housing outer panel to the vehicle side, install the *4.
- 2 After welding, apply body sealer and undercoating to the corresponding parts. (See the paint-coating)
- 3 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

BODY LOWER BACK PANEL (ASSY)



F41471A

Symbol meaning

REMOVAL

△ : Remove Weld Points

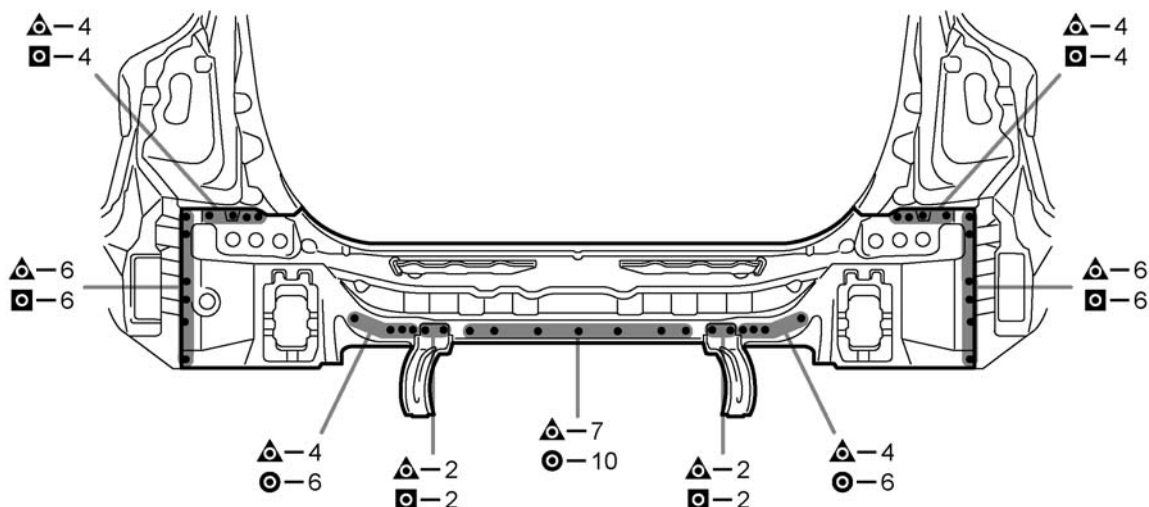
INSTALLATION

● : Spot Weld

◻ : Plug Weld

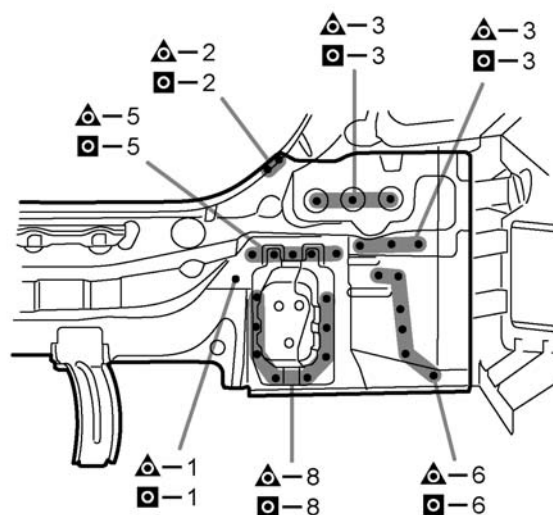
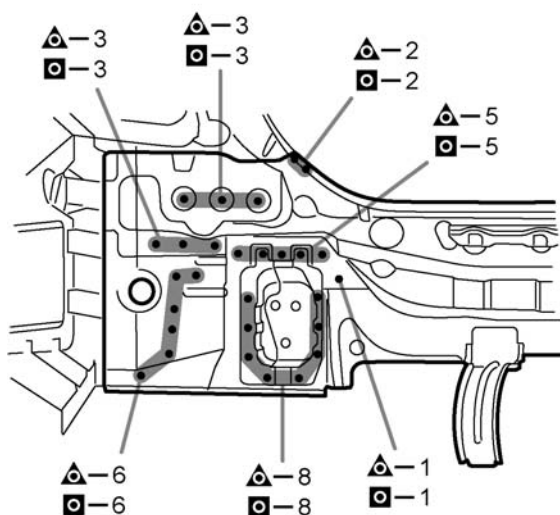
F41471B

REMOVAL·INSTALLATION



[LH Side]

[RH Side]

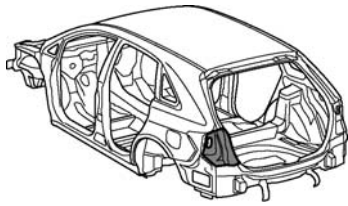


F41471

INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 After welding, apply body sealer and undercoating to the corresponding parts. (See the paint coating)
- 4 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

BACK DOOR OPENING TROUGH (ASSY)



F41472A

With the quarter panel and body lower back panel removed.

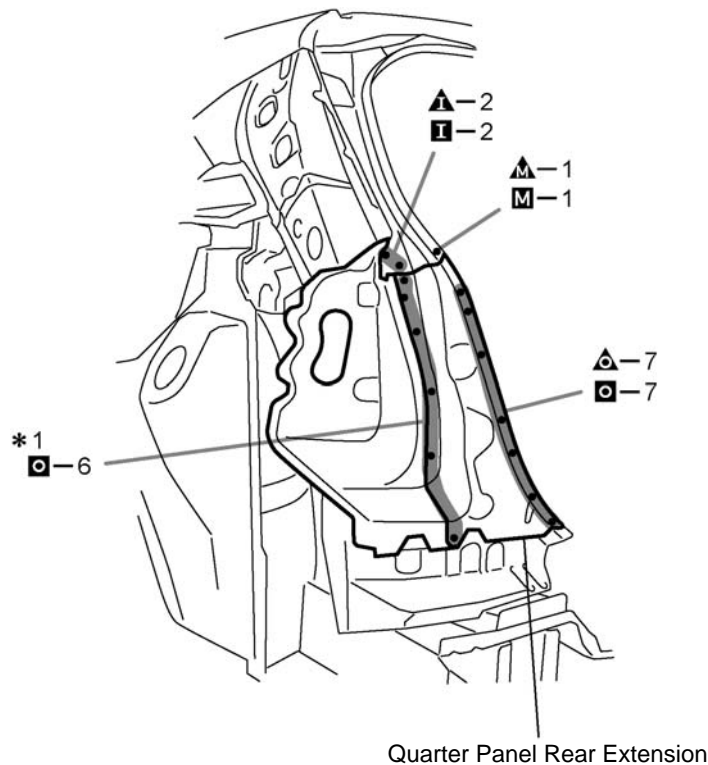
Symbol meaning

REMOVAL : Remove Weld Points

INSTALLATION : Plug Weld

F41472B

REMOVAL·INSTALLATION



F41472

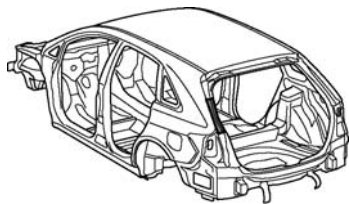
REMOVAL POINT

- 1 Remove the quarter panel rear extension at the same time.

INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 *1 is only for installation.
- 4 After welding, apply body sealer to the corresponding parts. (See the paint-coating)
- 5 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

QUARTER PANEL UPPER REAR EXTENSION (CUT)



F41473A

With the back door opening trough removed.

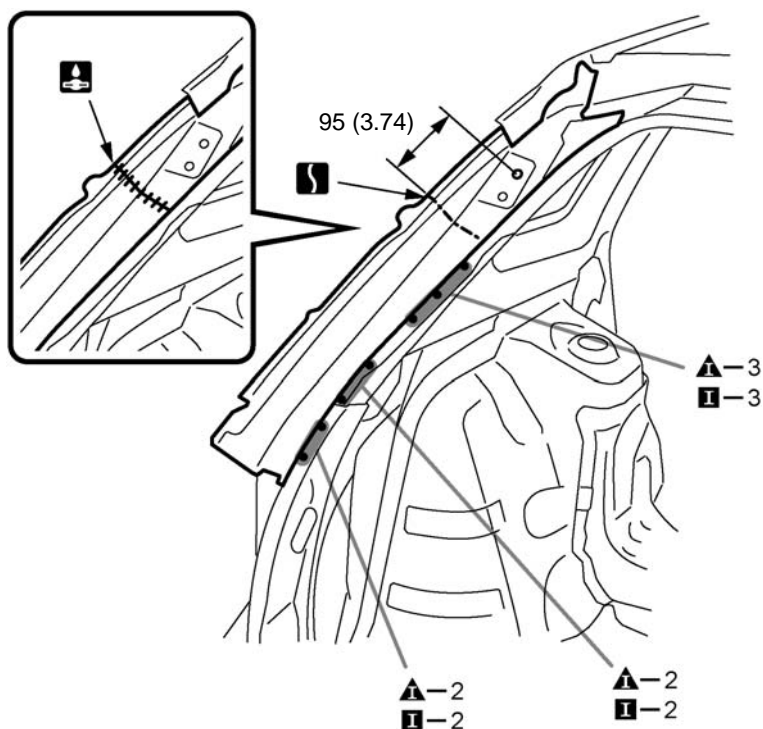
Symbol meaning

REMOVAL ▲ : Remove Weld Points S : Cut and Join Location

INSTALLATION I : Plug Weld B : Butt Weld

F41473B

REMOVAL·INSTALLATION



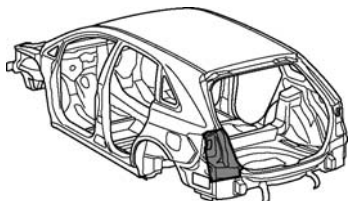
mm (in.)

F41473

INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

ROOF SIDE INNER FRONT PANEL (CUT)



F41474A

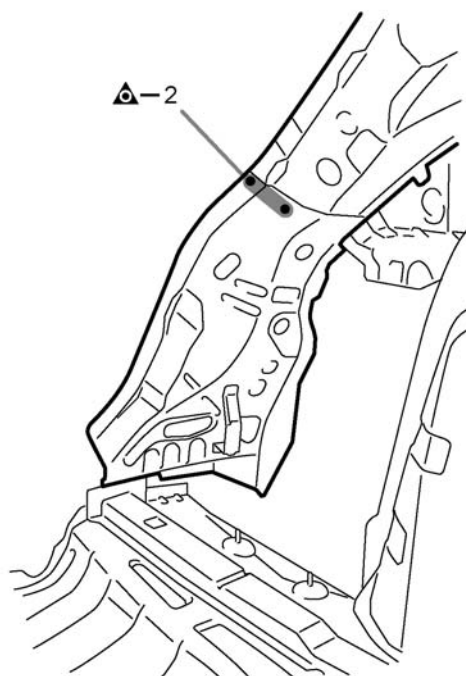
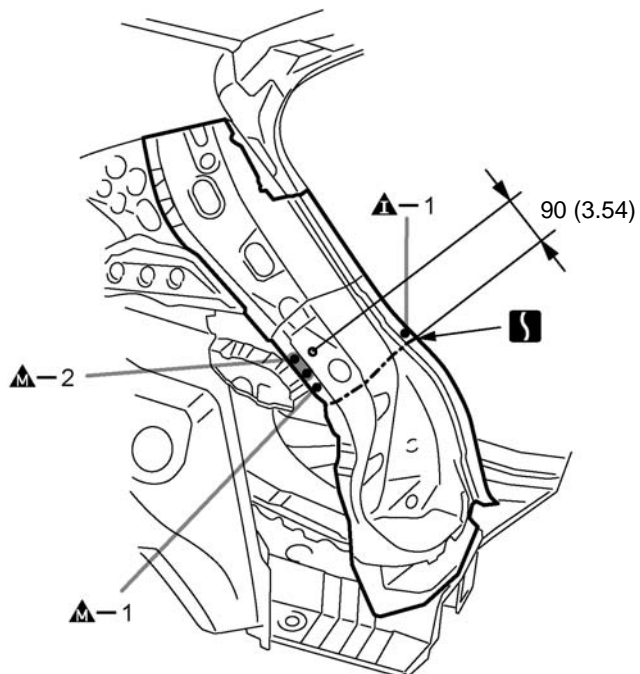
With the quarter panel upper rear extension removed.

Symbol meaning

⚠ ⚠ ⚠ : Remove Weld Points S : Cut and Join Location

F41474B

REMOVAL



mm (in.)

F41474

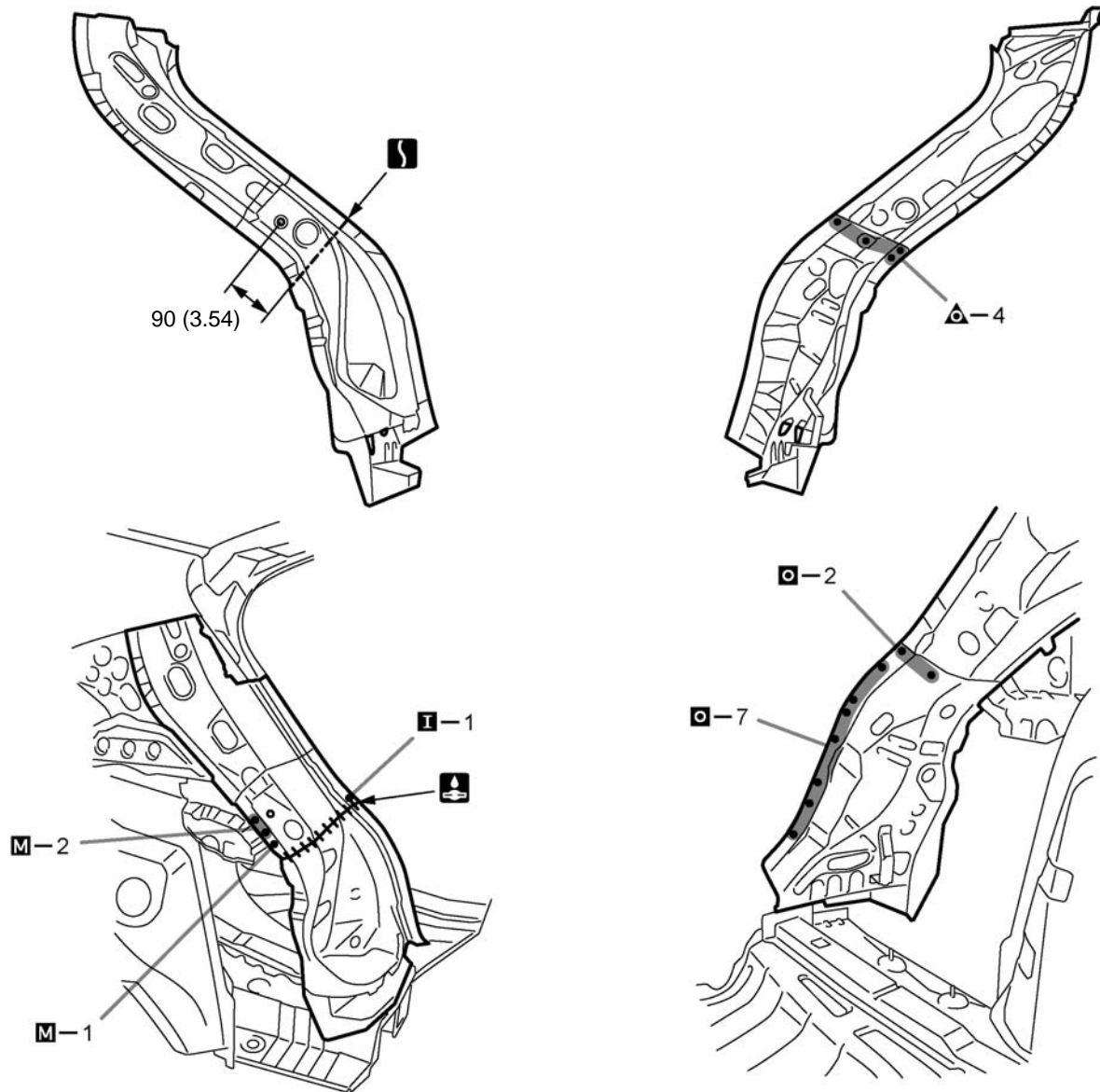
Symbol meaning

△ : Remove Weld Points ◻ M I : Plug Weld S : Cut and Join Location

⬮ : Butt Weld

F41475B

INSTALLATION



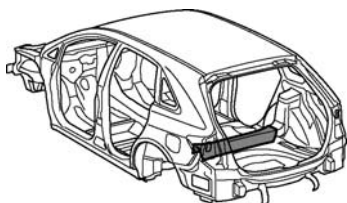
mm (in.)

F41475

INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 If the entire supply part is not needed, remove the part of the supply part that is needed.
- 4 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

REAR FLOOR CROSSMEMBER GUSSET (ASSY)



F41476A

Symbol meaning

REMOVAL

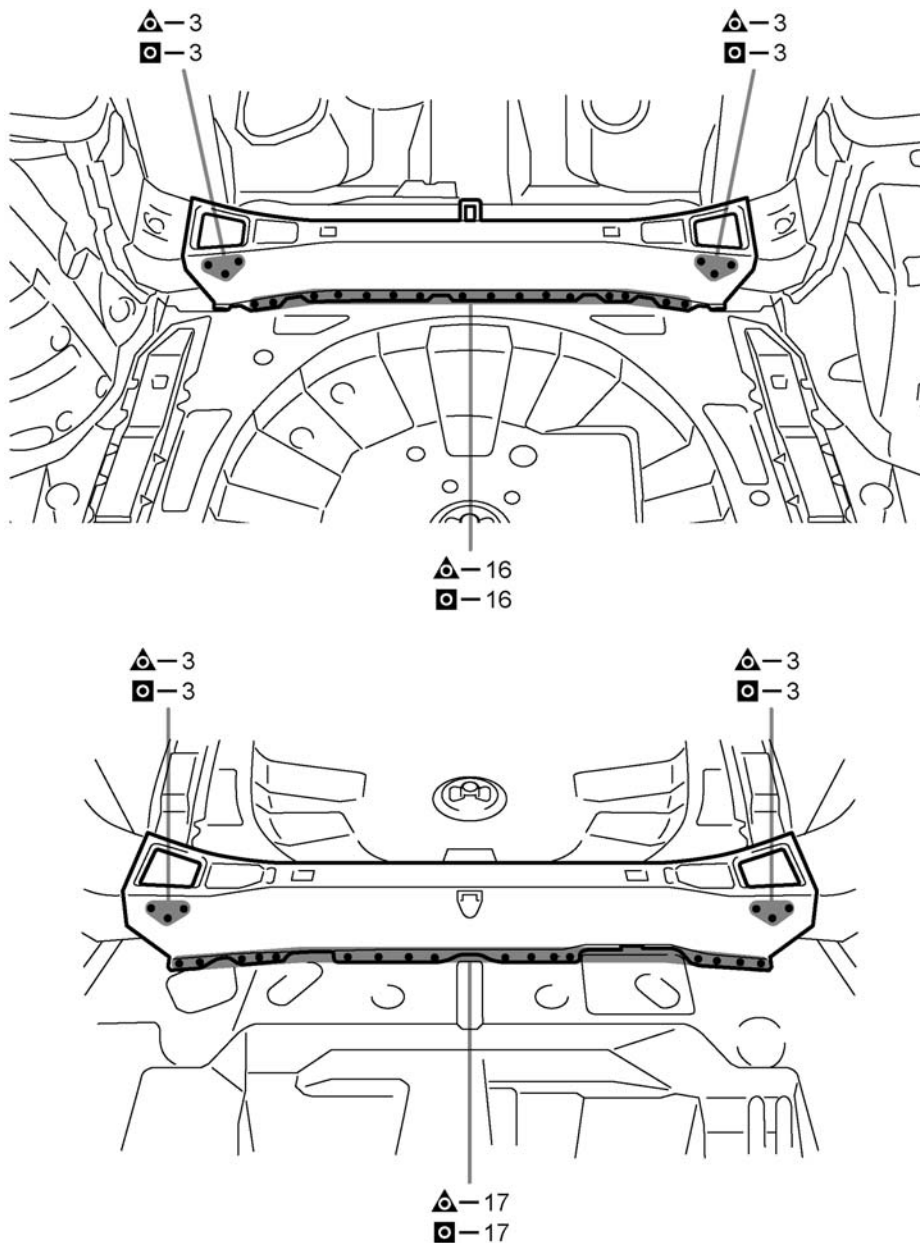
△ : Remove Weld Points

INSTALLATION

◻ : MIG Plug Weld

F41476B

REMOVAL·INSTALLATION

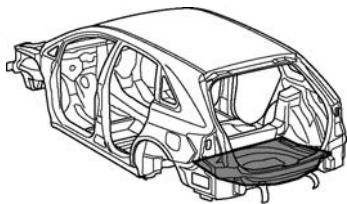


F41476

INSTALLATION POINT

- 1 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 2 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

REAR FLOOR PAN (ASSY)



F41477A

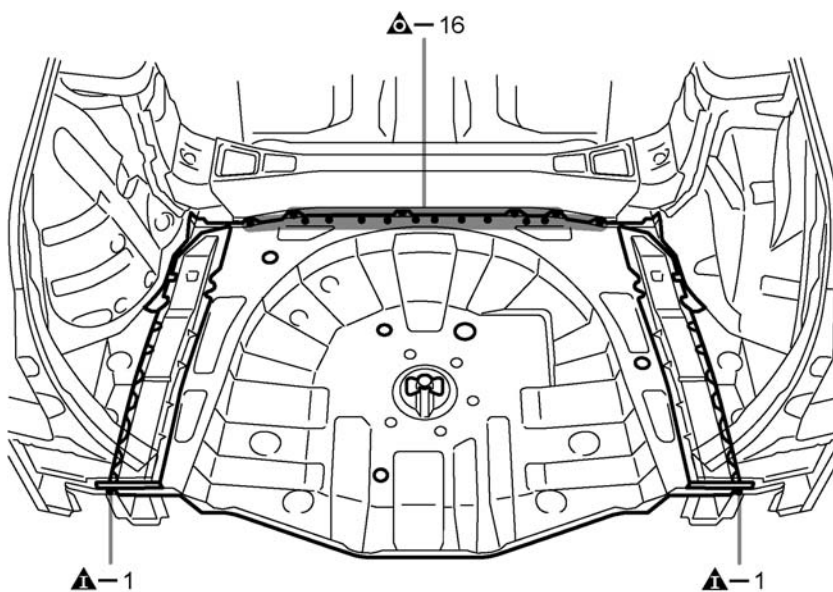
With the body lower back panel removed.

Symbol meaning

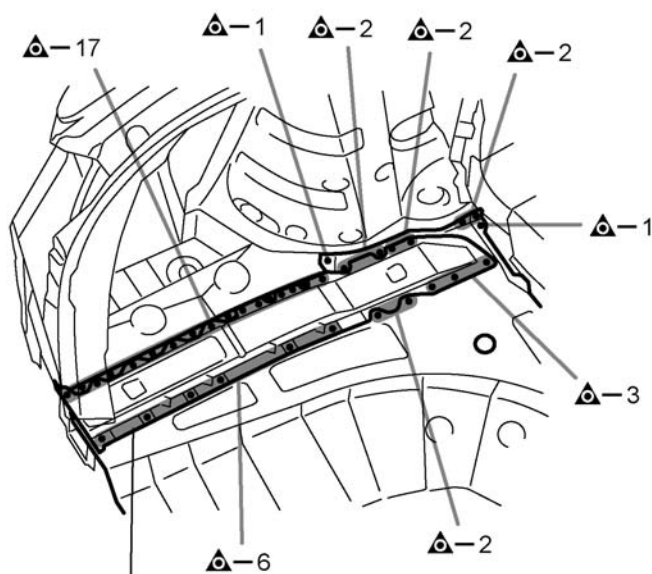
△ △ △ : Remove Weld Points

F41477B

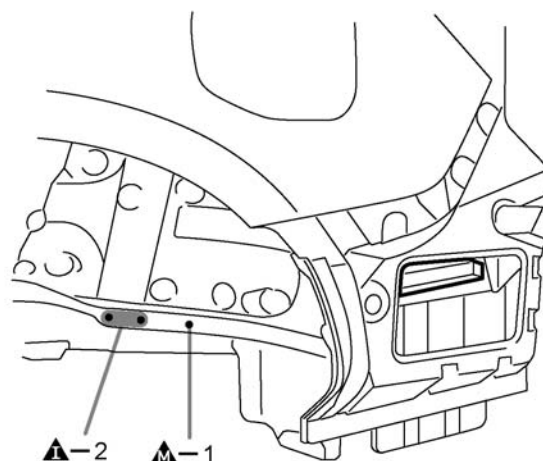
REMOVAL



[LH Side]



Rear Floor Panel No. 1 Reinforcement

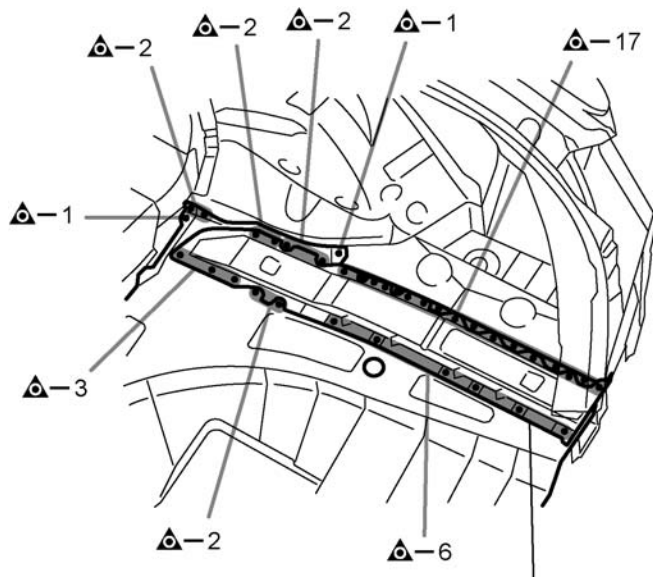


F41477

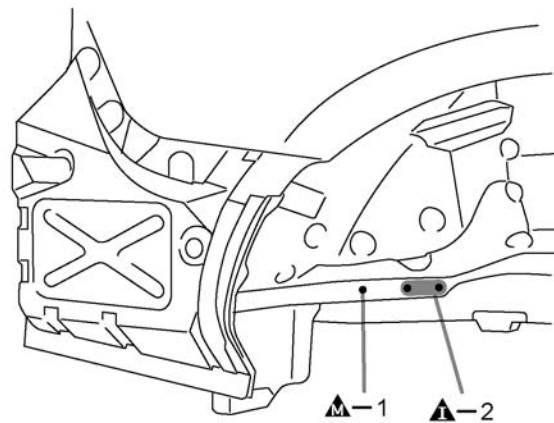
REMOVAL POINT

- 1 Remove the rear floor panel No. 1 reinforcement at the same time.


[RH Side]



Rear Floor Panel No. 1 Reinforcement

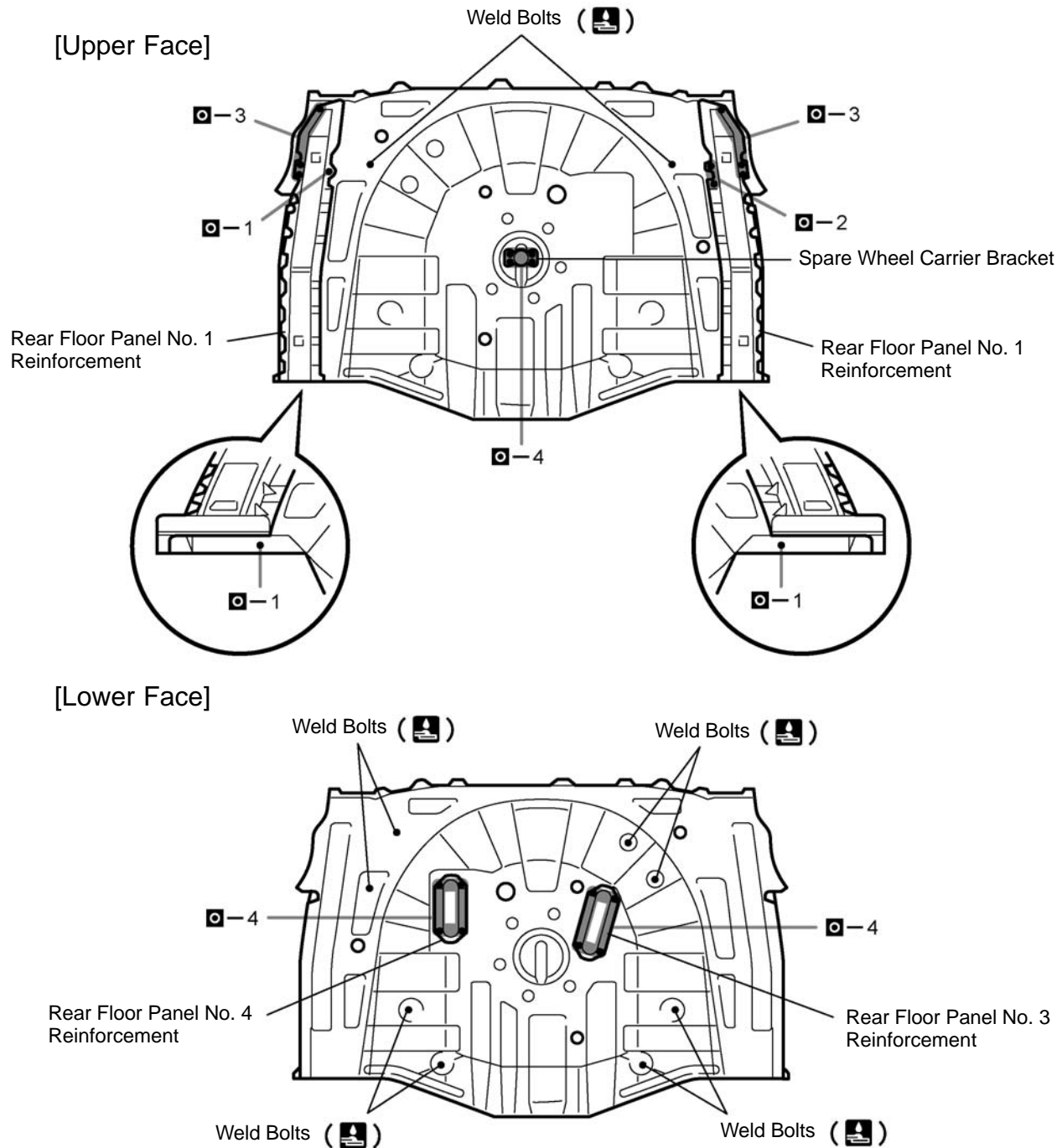


Symbol meaning

◻ M I : Plug Weld  : Fillet Weld

F41479B

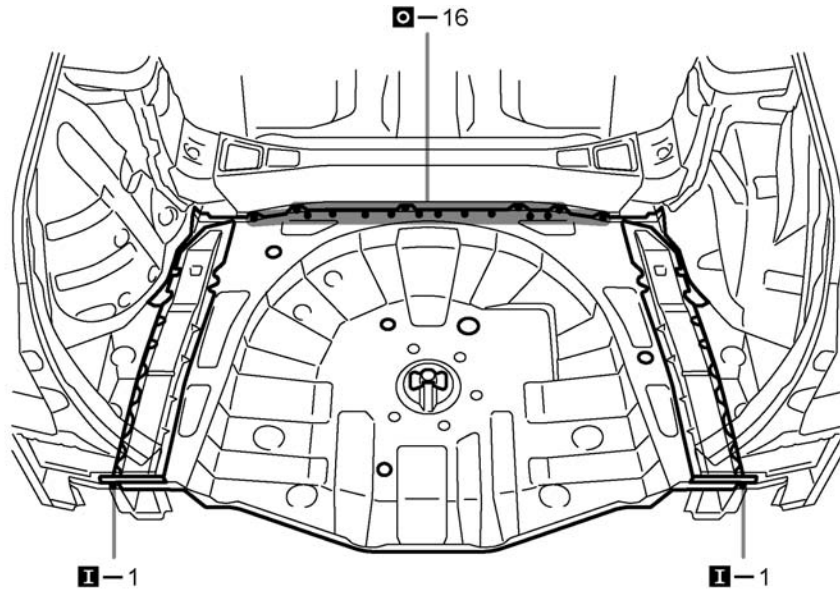
INSTALLATION



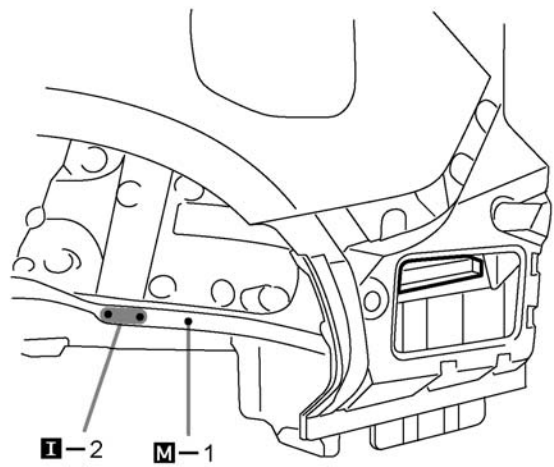
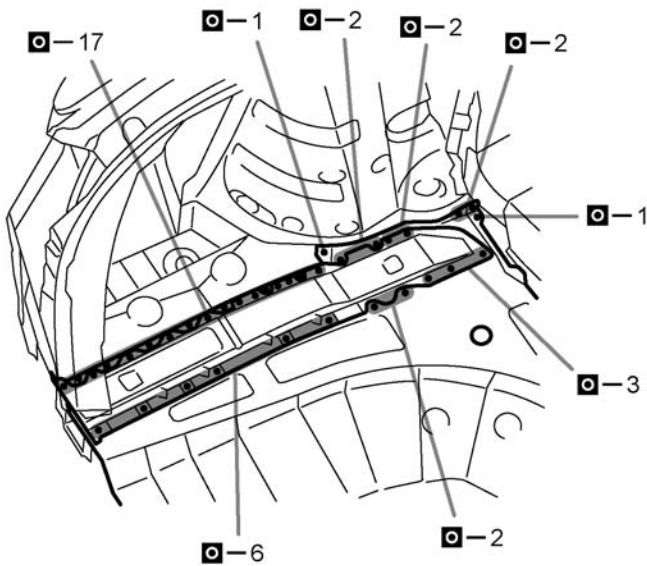
F41479

INSTALLATION POINT


- 1 Before temporarily installing the new parts, weld the spare wheel carrier bracket, rear floor panel No. 1 reinforcement, rear floor panel No. 3 reinforcement, rear floor panel No. 4 reinforcement and weld bolts with the standard number of welding points.



[LH Side]

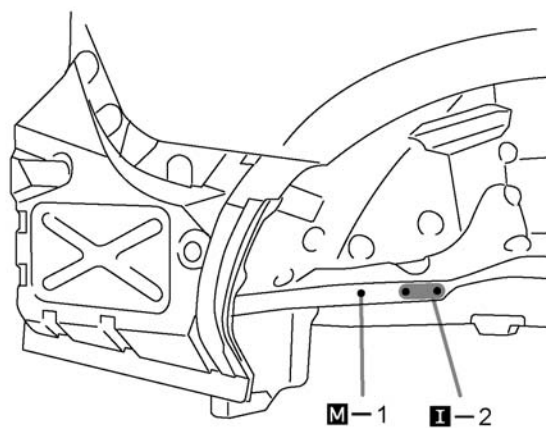
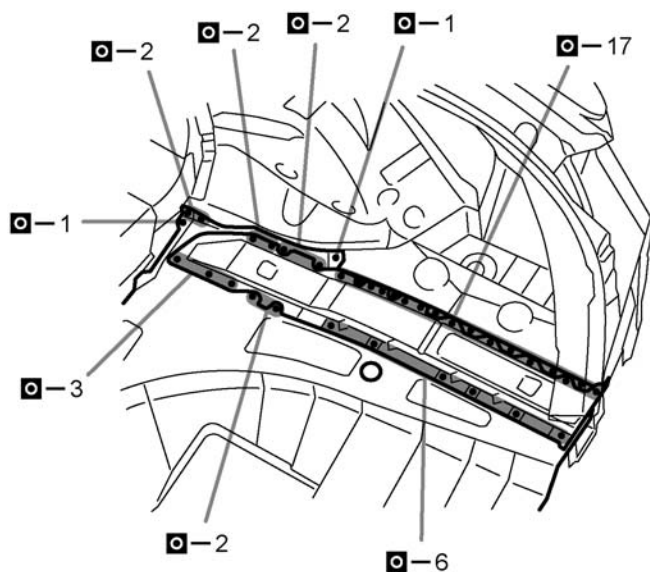


Symbol meaning

 **M I** : Plug Weld
  : Fillet Weld

F41479B

[RH Side]

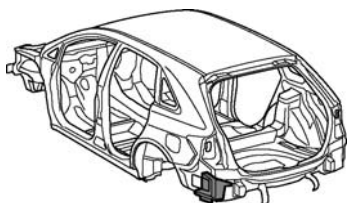


F41481

INSTALLATION POINT

- 1 After welding, apply body sealer and undercoating to the corresponding parts. (See the paint coating)
- 2 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

REAR FLOOR SIDE PANEL (ASSY)



F41482A

With the body lower back panel removed.

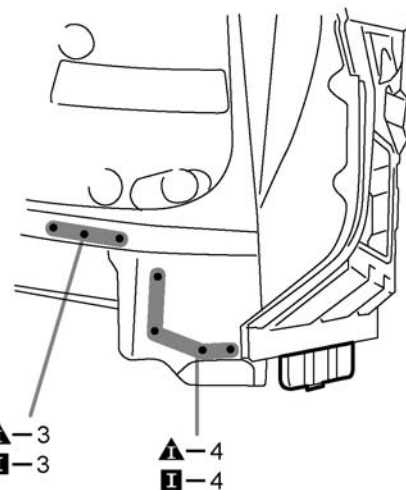
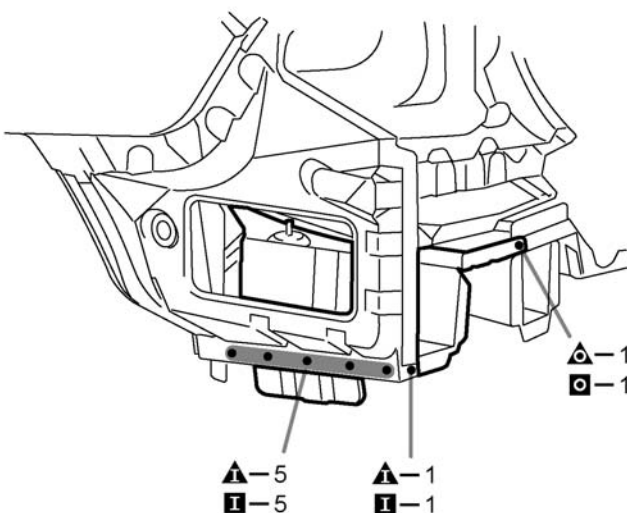
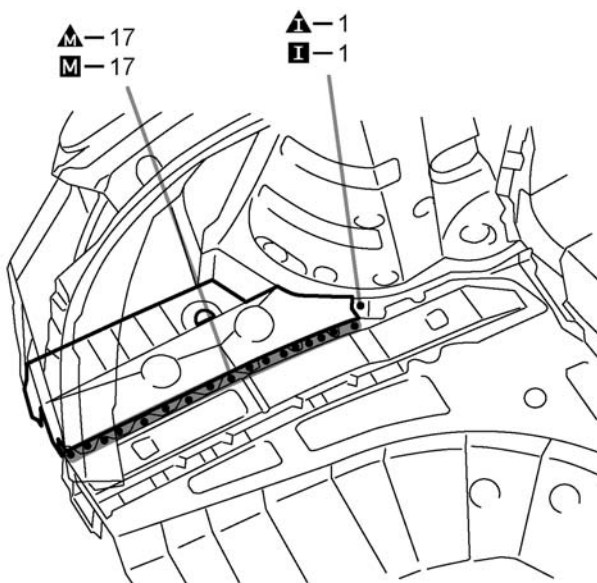
Symbol meaning

REMOVAL : Remove Weld Points

INSTALLATION : Plug Weld

F41482B

REMOVAL·INSTALLATION

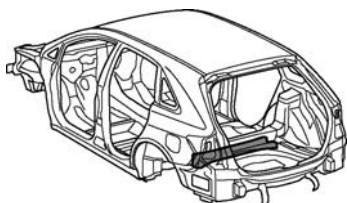


F41482

INSTALLATION POINT

- 1 After welding, apply body sealer and undercoating to the corresponding parts. (See the paint-coating)
- 2 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

REAR FLOOR CROSSMEMBER NO. 2 (ASSY)



F41483A

With the rear floor crossmember gusset and rear floor pan removed.

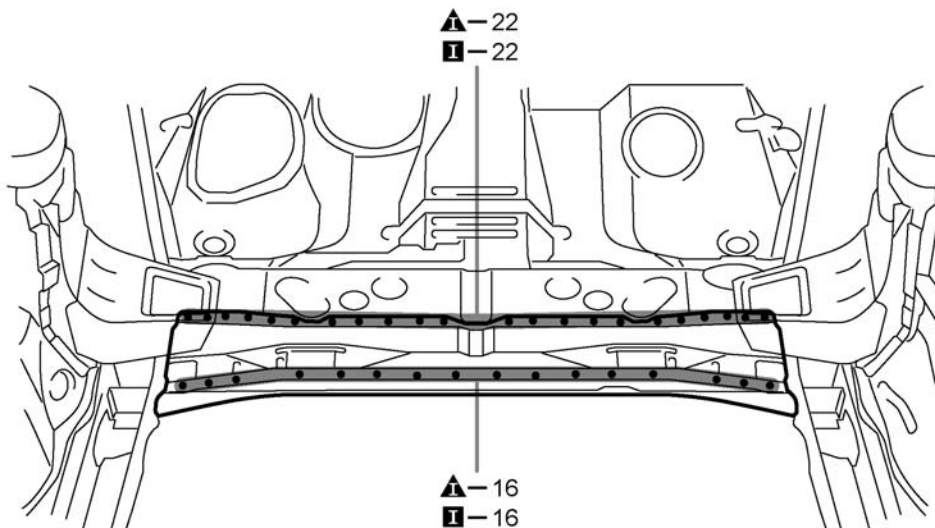
Symbol meaning

REMOVAL ▲ ▲ : Remove Weld Points

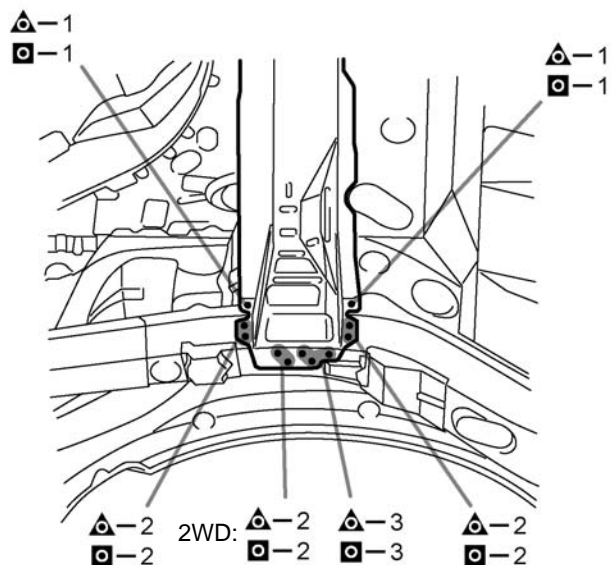
INSTALLATION ◻ ◻ : Plug Weld

F41483B

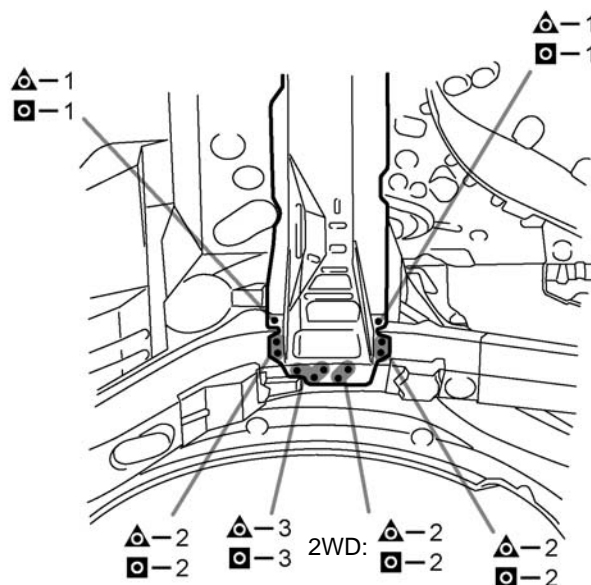
REMOVAL-INSTALLATION



[LH Side]



[RH Side]

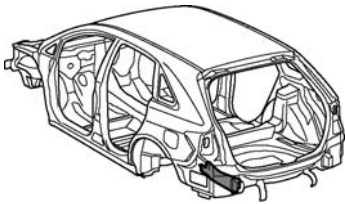


F41483

INSTALLATION POINT

- 1 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 2 After welding, apply undercoating to the corresponding parts. (See the paint coating)
- 3 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

REAR FLOOR SIDE REAR MEMBER (ASSY)



F41484A

With the body lower back panel removed.

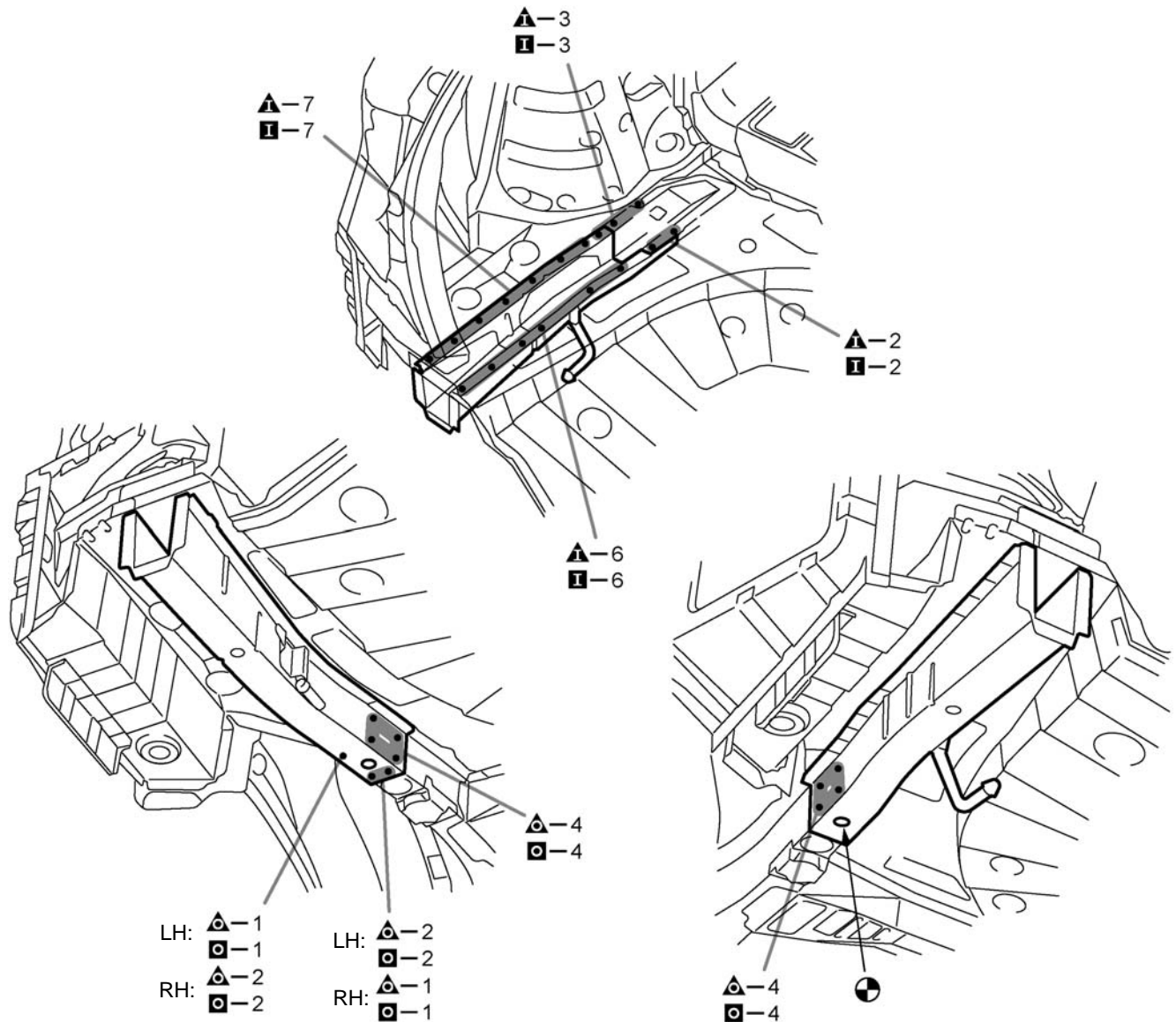
Symbol meaning

REMOVAL : Remove Weld Points

INSTALLATION : Plug Weld

F41484B

REMOVAL·INSTALLATION

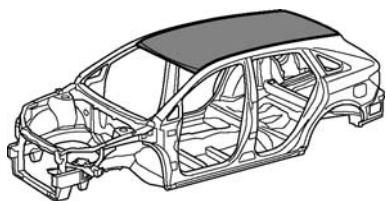


F41484

INSTALLATION POINT

- 1 For positioning of the new parts, align the installation standard holes of the rear floor side rear member and the member.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 After welding, apply undercoating to the corresponding parts. (See the paint coating)
- 4 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

ROOF PANEL (ASSY): w/o Sliding Roof



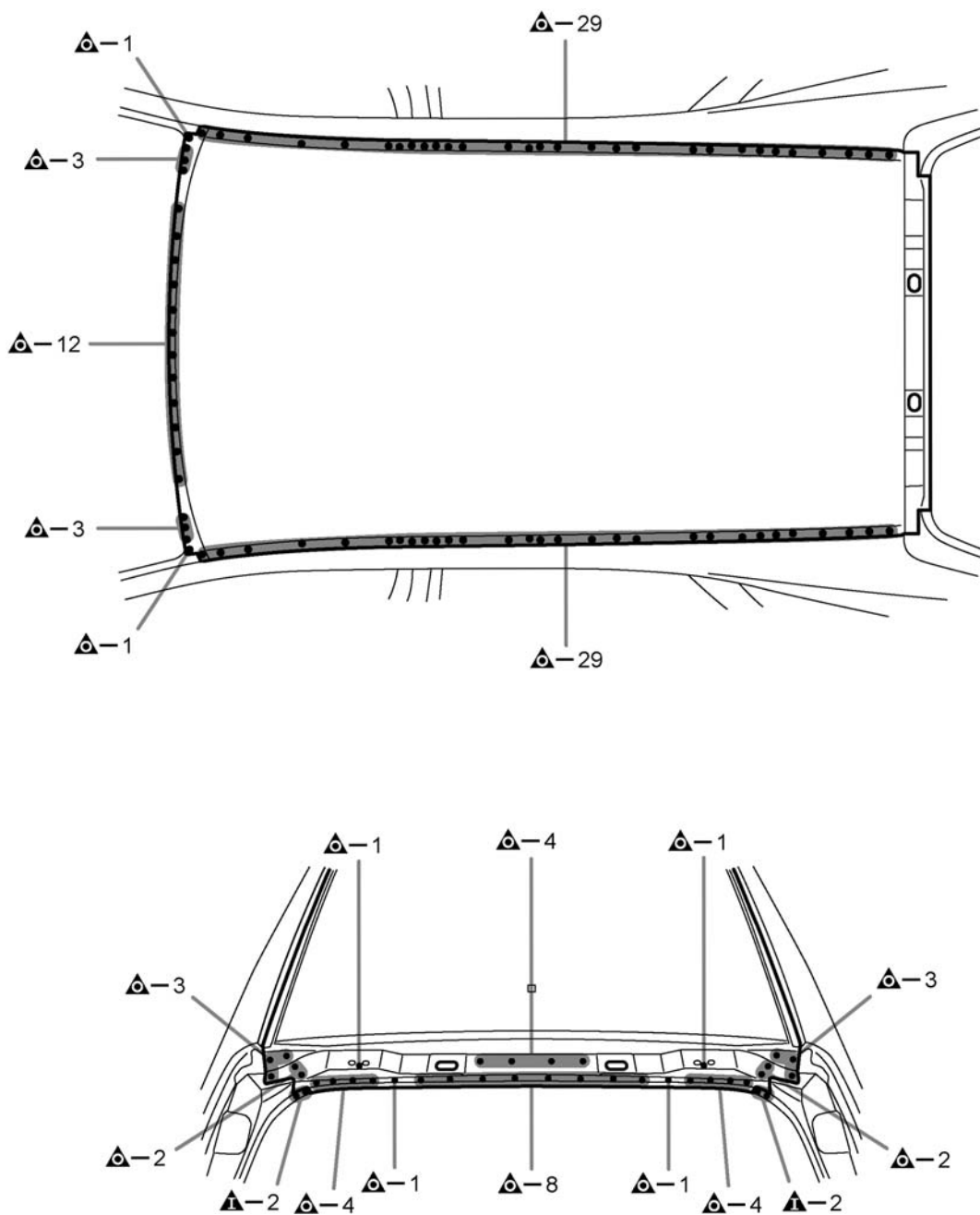
F41485A

Symbol meaning

△△ : Remove Weld Points

F41485B

REMOVAL



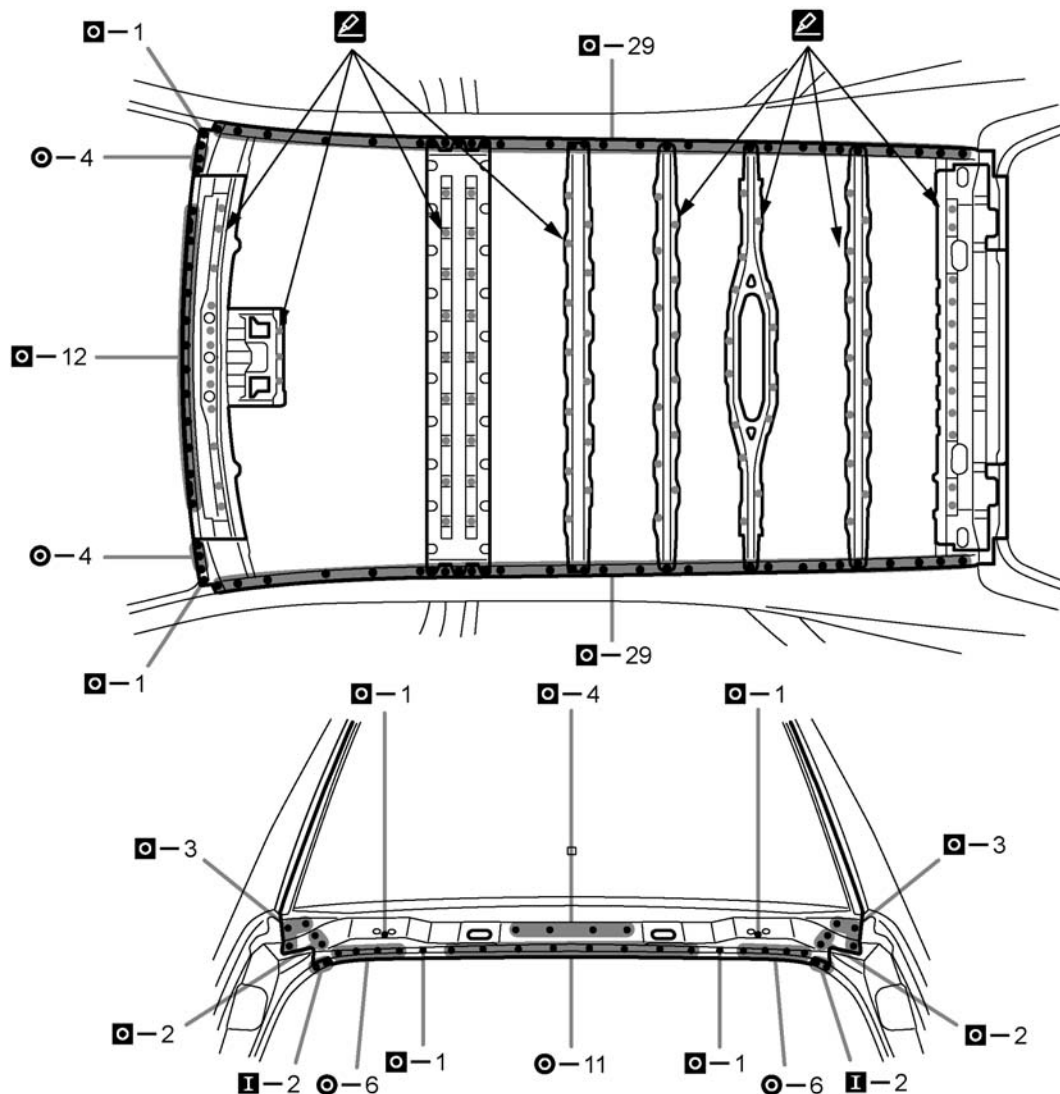
F41485

Symbol meaning

○ : Spot Weld □ I : Plug Weld ▢ : Body Sealer

F41486B

INSTALLATION



F41486

INSTALLATION POINT

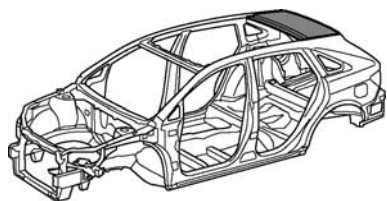
- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 After the roof panel reinforcement is welded to the new parts, install the roof panel to the vehicle side.
- 4 Before temporarily installing the new parts, apply body sealer to the windshield header panel, roof panel reinforcement and back door opening frame.

HINT:

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

- 5 After welding, apply the foamed sealing material to the corresponding parts. (See the paint coating)
- 6 After welding, apply body sealer to the corresponding parts. (See the paint coating)
- 7 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

ROOF PANEL (ASSY): w/ Sliding Roof



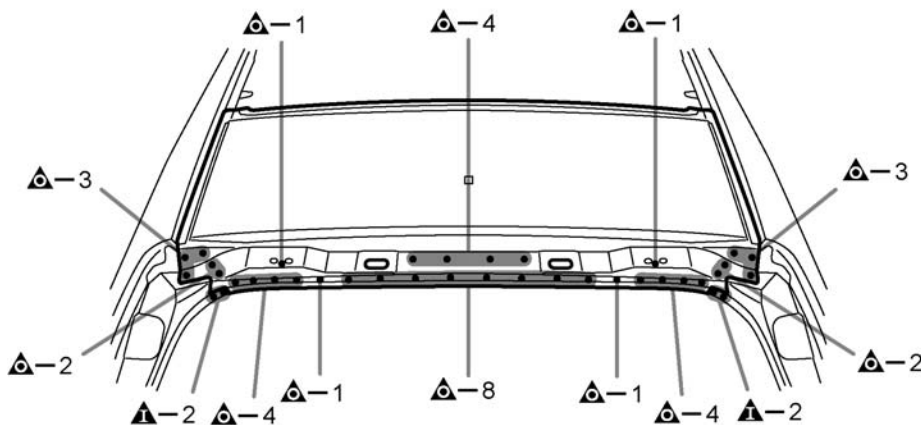
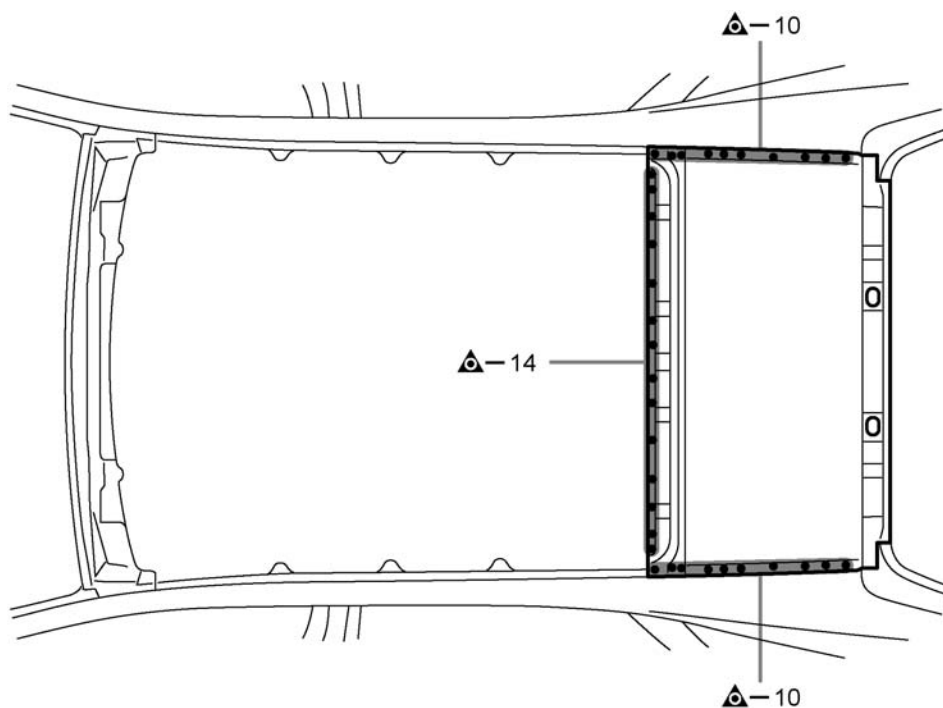
F41487A

Symbol meaning

△△ : Remove Weld Points

F41487B

REMOVAL



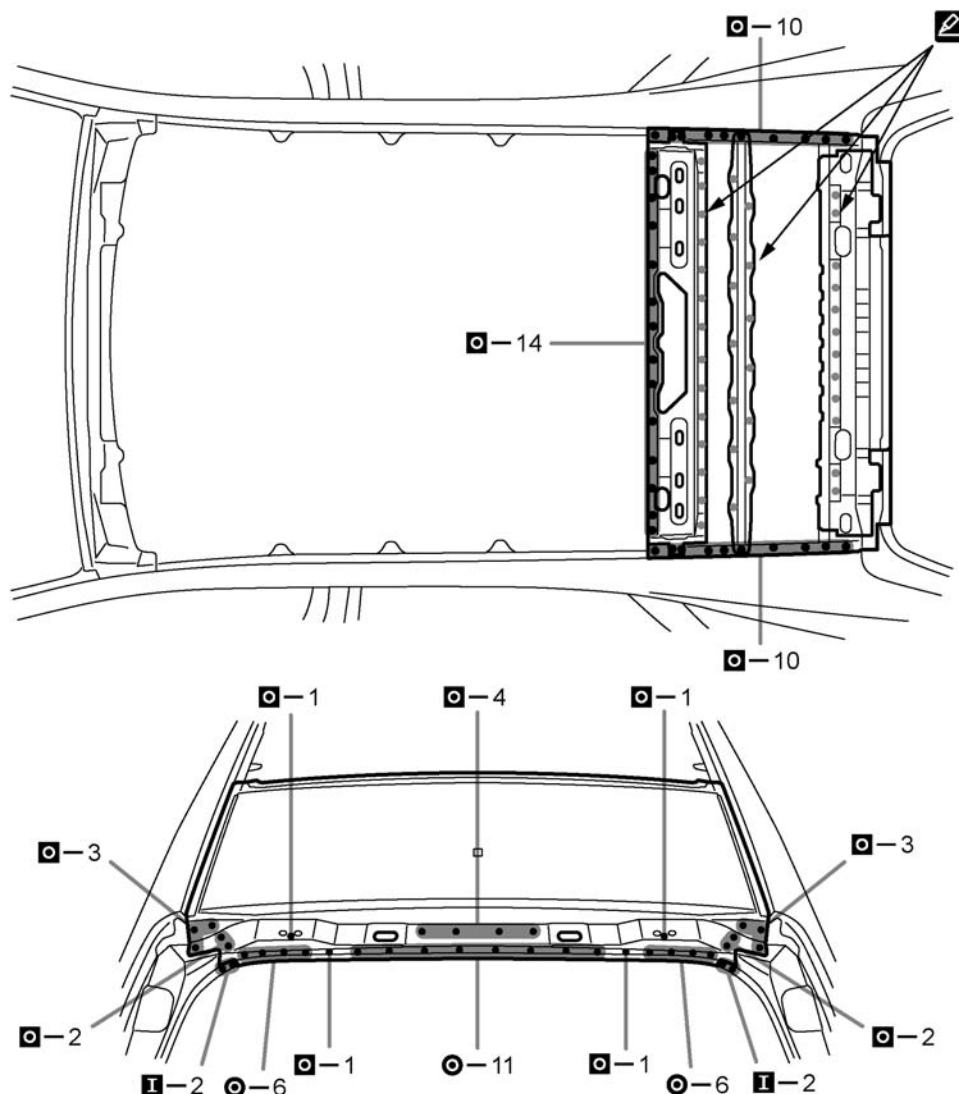
F41487

Symbol meaning

○ : Spot Weld □ I : Plug Weld ▨ : Body Sealer

F41488B

INSTALLATION



F41488

INSTALLATION POINT

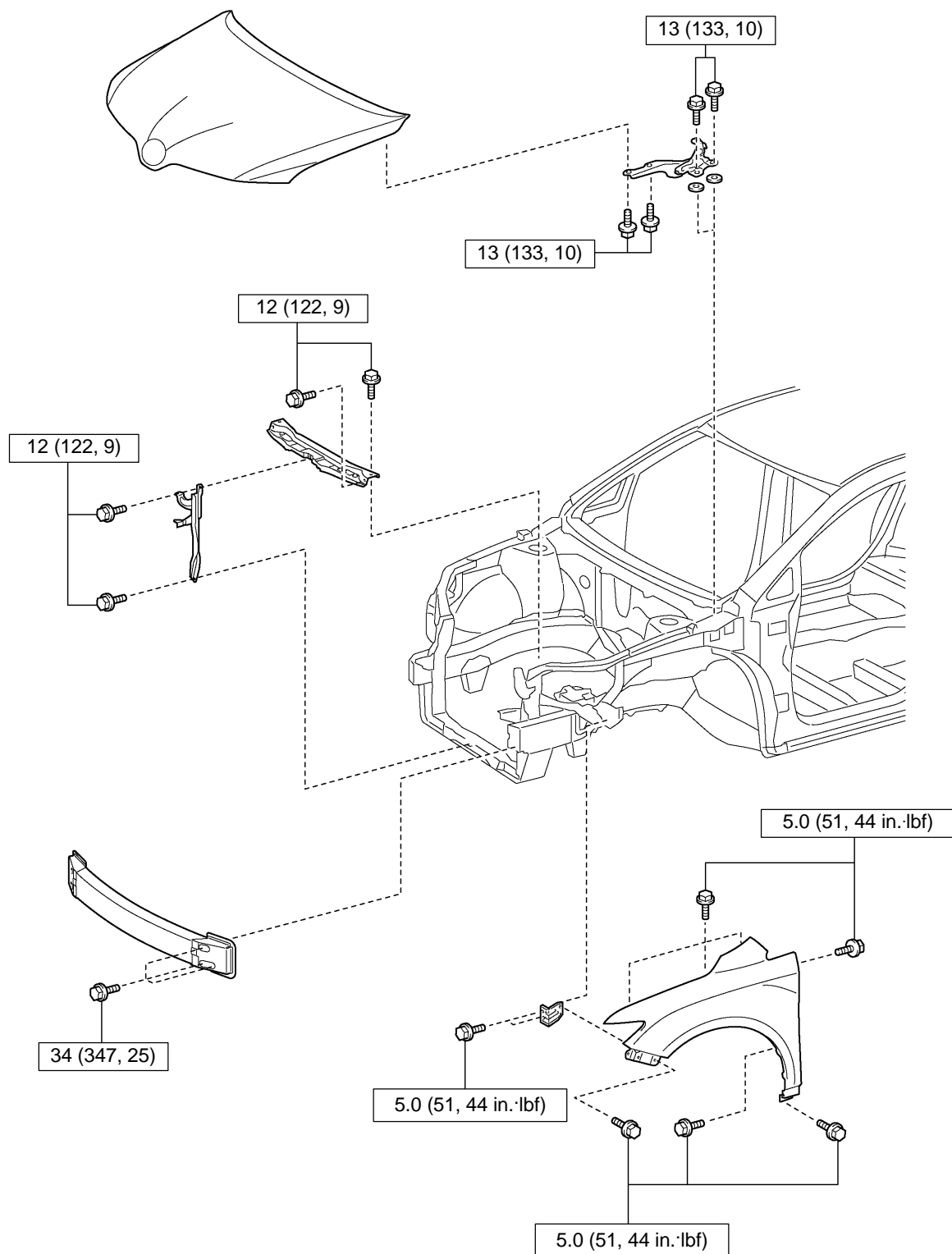
- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 After the roof panel reinforcement is welded to the new parts, install the roof panel to the vehicle side.
- 4 Before temporarily installing the new parts, apply body sealer to the windshield header panel, roof panel reinforcement and back door opening frame.

HINT:

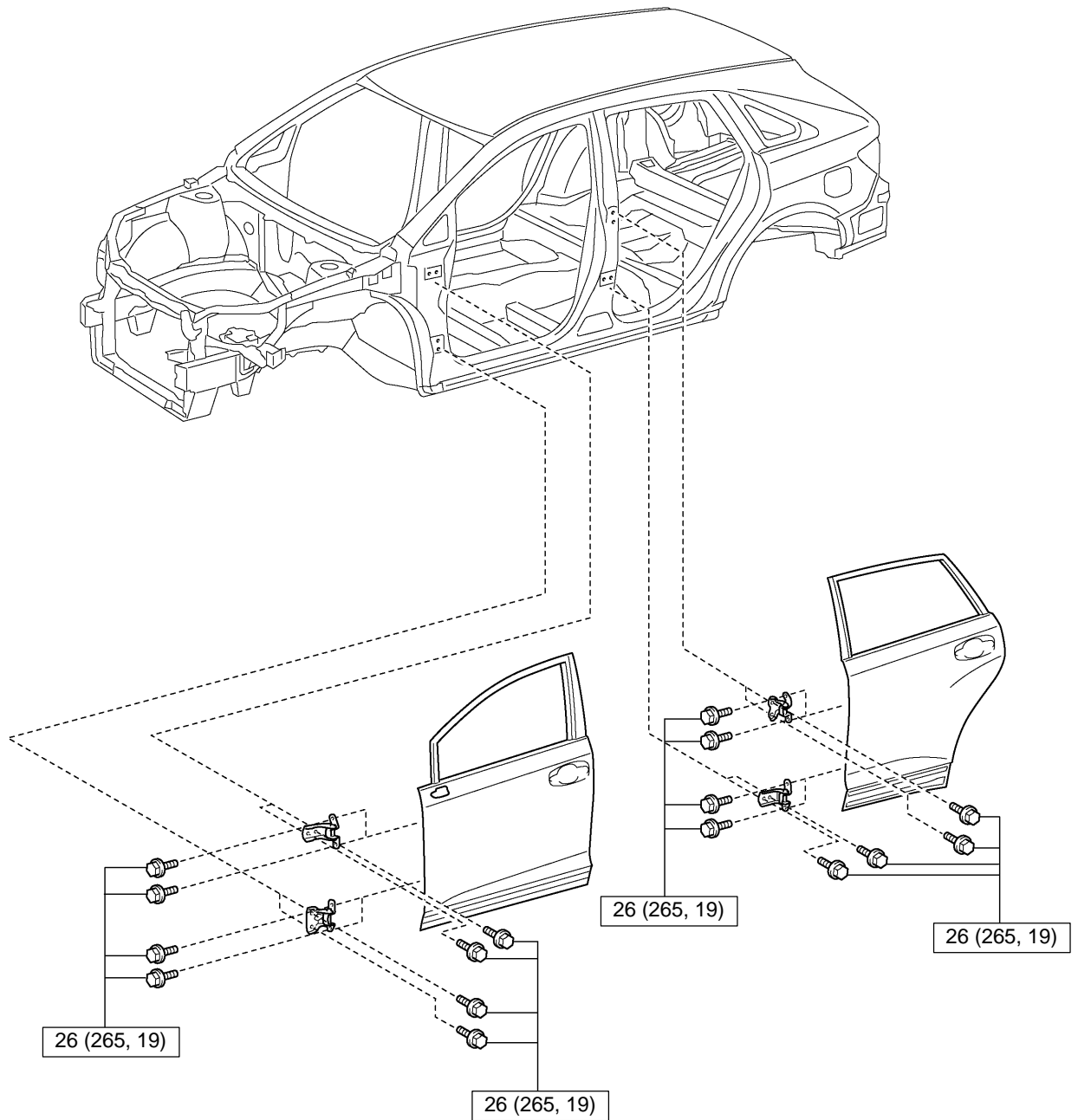
Apply just enough sealer for the new parts to make contact.

- 5 After welding, apply body sealer to the corresponding parts. (See the paint coating)
- 6 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

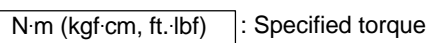
OUTER PANEL INSTALLATION TORQUE



N·m (kgf·cm, ft.·lbf) : Specified torque

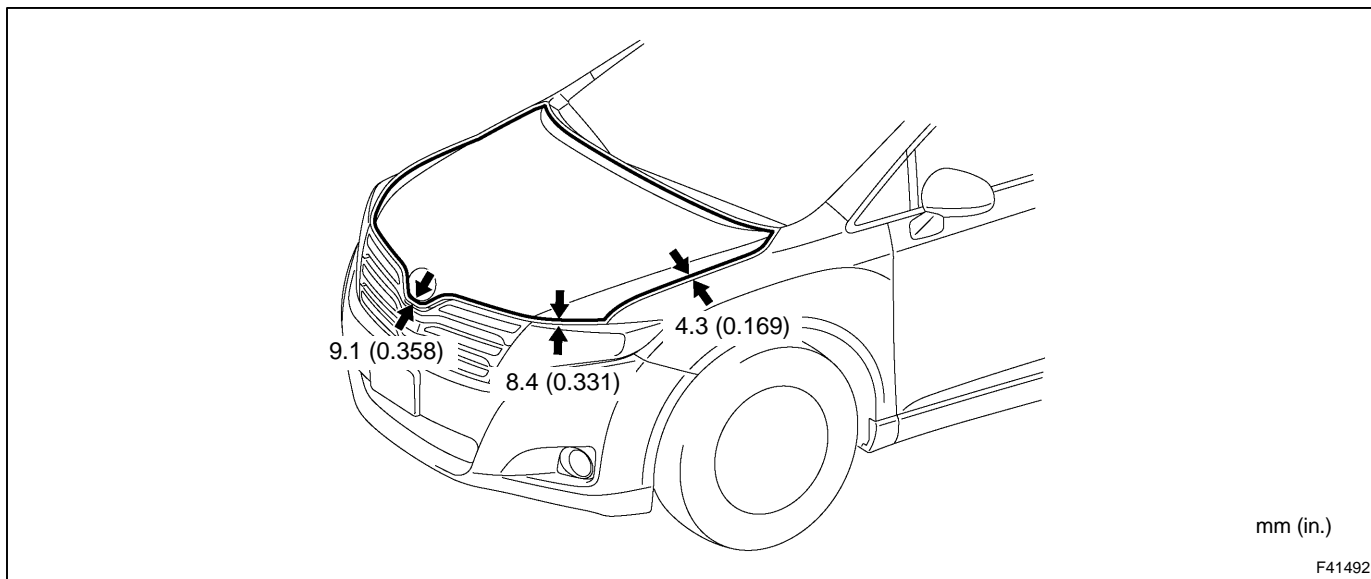


N·m (kgf·cm, ft·lbf) : Specified torque



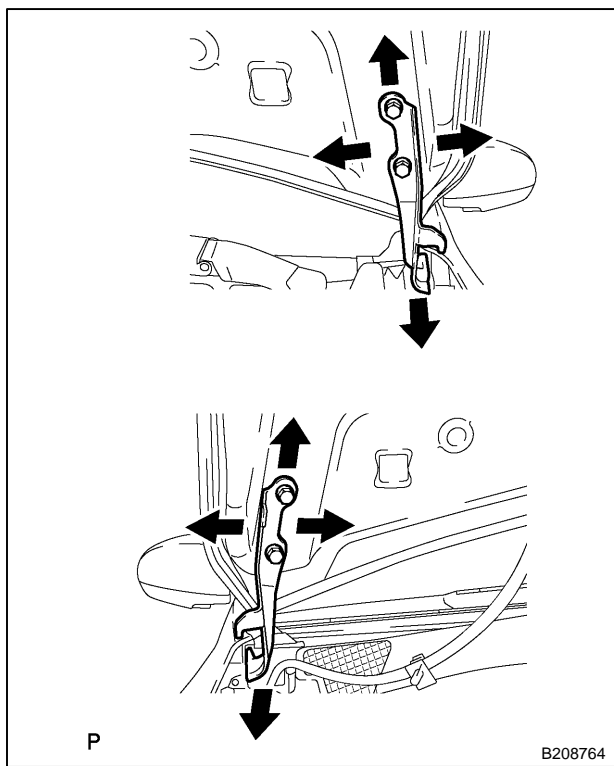
FIT STANDARD/ADJUSTMENT METHOD/TORQUE SPECIFICATION

1. HOOD



HINT:

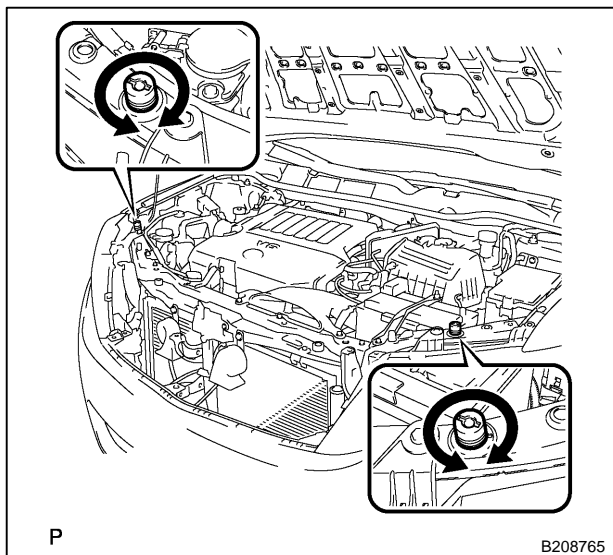
Centering bolts are used to mount the hood hinge and hood lock. The hood and hood lock cannot be adjusted with the centering bolts installed. Substitute the centering bolts with standard bolts when making adjustments.



- (a) Horizontally and vertically adjust the hood.
- (1) Loosen the 4 hinge bolts of the hood.
 - (2) Adjust the clearance between the hood and front fender by moving the hood.
 - (3) Tighten the 4 hinge bolts after the adjustment.

Torque:

13 N·m (133 kgf·cm, 10 ft·lbf)

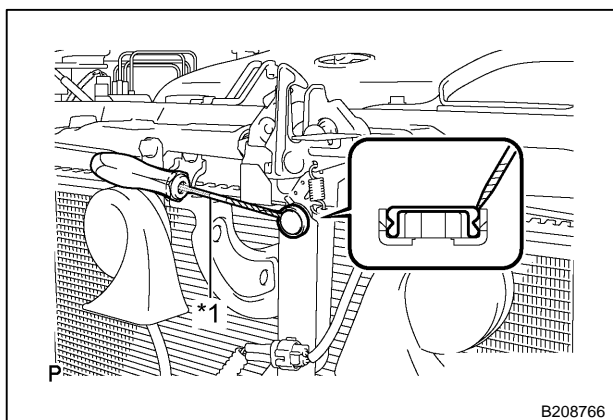


(b) Adjust the height of the front end of the hood using the cushion rubbers.

- (1) Adjust the 2 cushion rubbers so that the heights of the hood and fender are aligned.

HINT:

Raise or lower the front end of the hood by turning the 2 cushion rubbers.



(c) Adjust the hood lock.

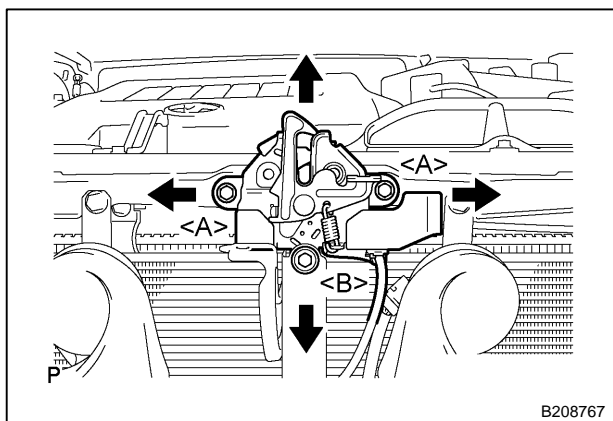
- (1) Using a screwdriver, remove the hood lock nut cap.

Text in Illustration

*1	Protective Tape
----	-----------------

HINT:

Tape the screwdriver tip before use.



- (2) Loosen the 3 bolts.
- (3) Tighten the bolts after the adjustment.

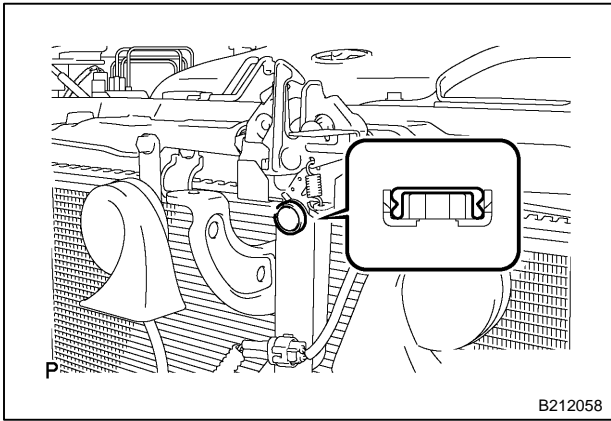
Torque: <A>

7.5 N·m (77 kgf·cm, 66 in·lbf)

**Torque: **

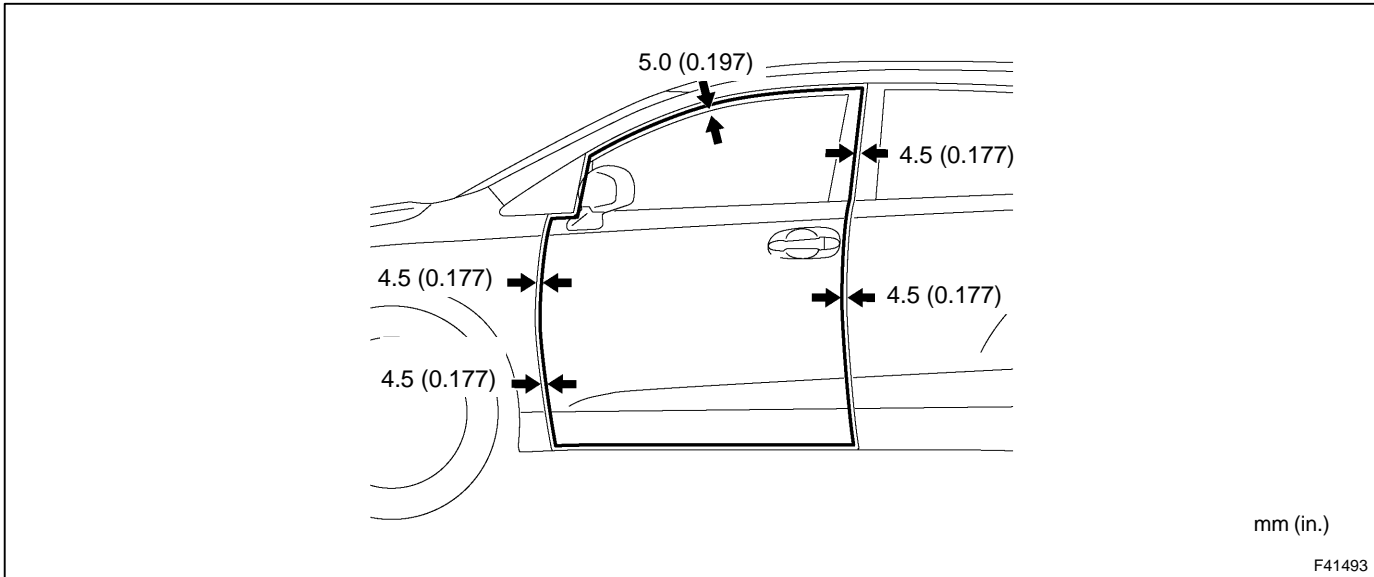
8.0 N·m (82 kgf·cm, 71 in·lbf)

- (4) Check that the striker can engage with the hood lock smoothly.



(d) Install a new hood lock nut cap.

2. FRONT DOOR

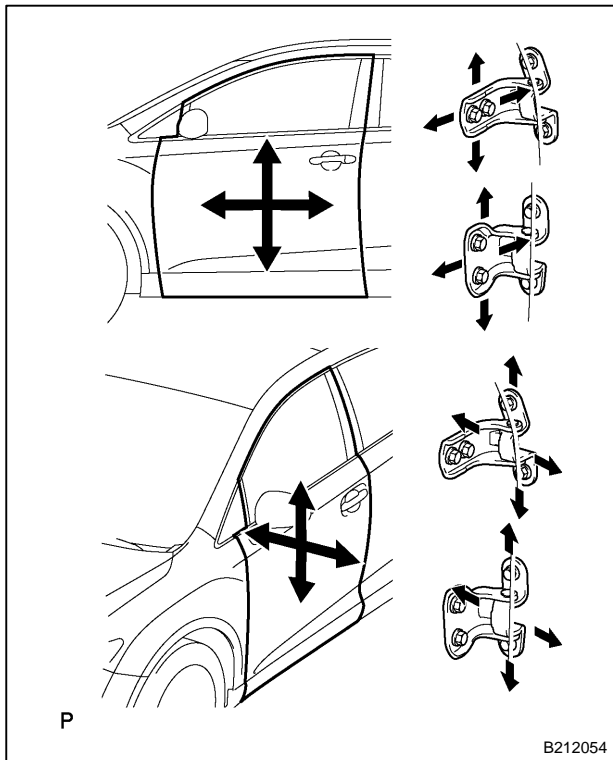


CAUTION:

Before adjusting the door positions of vehicles equipped with side and curtain shield airbags, be sure to disconnect the battery. After adjustment, check that the SRS warning light is operating normally and there are no SRS DTCs output.

HINT:

- Use the same procedure for the RH side and LH side.
- The procedure listed below is for the LH side.
- Centering bolts are used to mount the door hinge to the vehicle body and door. The door cannot be adjusted with the centering bolts installed on it. Substitute the centering bolts with standard bolts when making adjustments.



- (a) Using SST, loosen the hinge bolts on the vehicle body and adjust the door position.

SST

09812-00010

- (b) Tighten the hinge bolts on the vehicle body after the adjustment.

Torque:

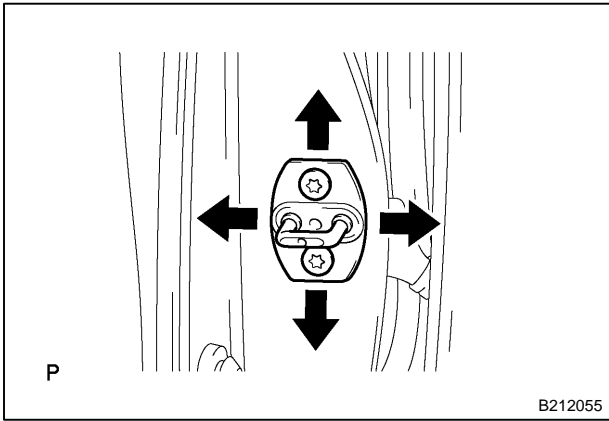
26 N·m (265 kgf·cm, 19 ft·lbf)

- (c) Loosen the hinge bolts on the door and adjust the door position.

- (d) Tighten the hinge bolts on the door after the adjustment.

Torque:

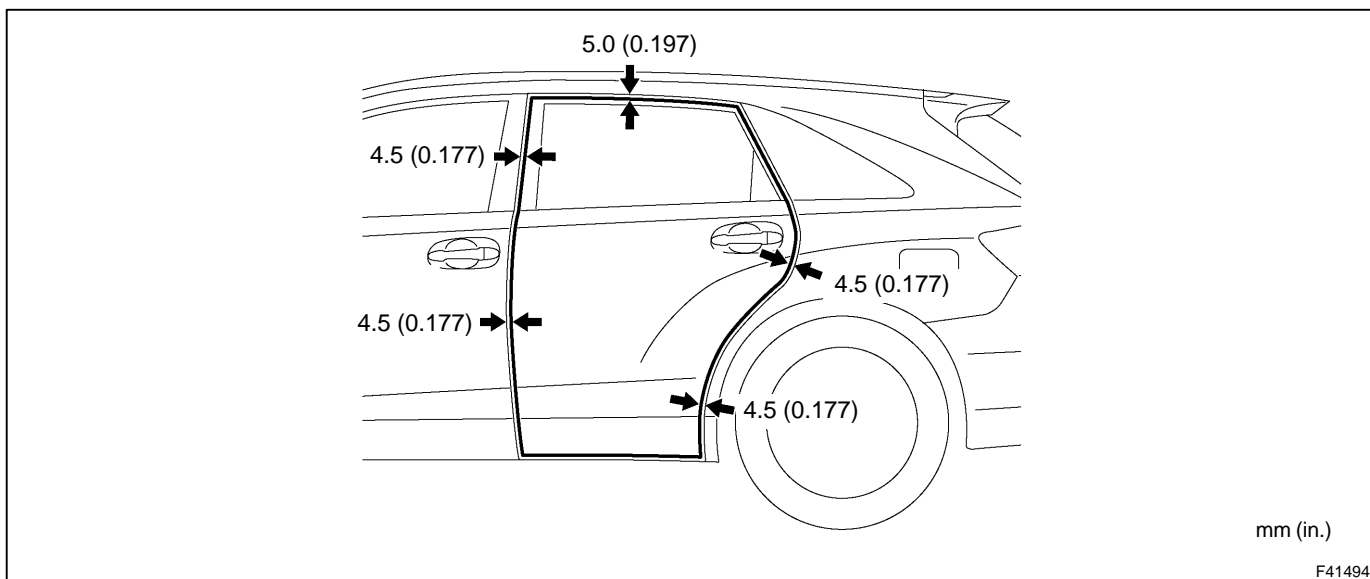
26 N·m (265 kgf·cm, 19 ft·lbf)



- (e) Using a T40 "TORX" socket wrench, slightly loosen the striker mounting screws.
- (f) Using a brass bar and a hammer, hit the striker to adjust its position.
- (g) Using a T40 "TORX" socket wrench, tighten the striker mounting screws after the adjustment.

Torque:**23 N·m (235 kgf·cm, 17 ft·lbf)**

3. REAR DOOR

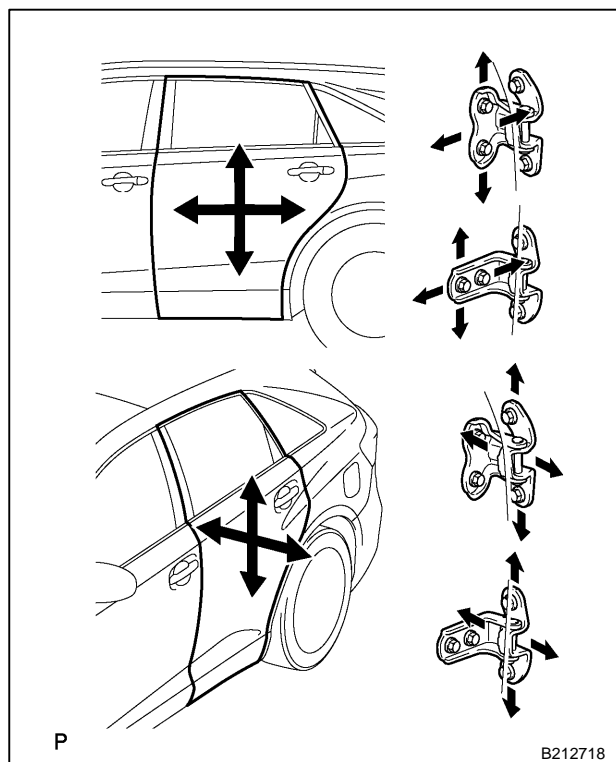


CAUTION:

Before adjusting the door positions of vehicles equipped with side and curtain shield airbags, be sure to disconnect the battery. After adjustment, check that the SRS warning light is operating normally and there are no SRS DTCs output.

HINT:

- Use the same procedure for the RH side and LH side.
- The procedure listed below is for the LH side.
- Centering bolts are used to mount the door hinge to the vehicle body and door. The door cannot be adjusted with the centering bolts installed. Substitute the centering bolts with standard bolts when making adjustments.



- Using SST, loosen the hinge bolts on the vehicle body and adjust the door position.

SST
09812-00010

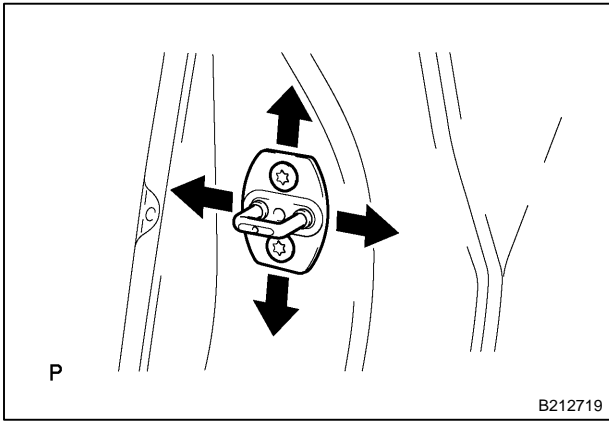
- Tighten the hinge bolts on the vehicle body after the adjustment.

Torque:
26 N·m (265 kgf·cm, 19 ft·lbf)

- Loosen the hinge bolts on the door and adjust the door position.

- Tighten the hinge bolts on the door after the adjustment.

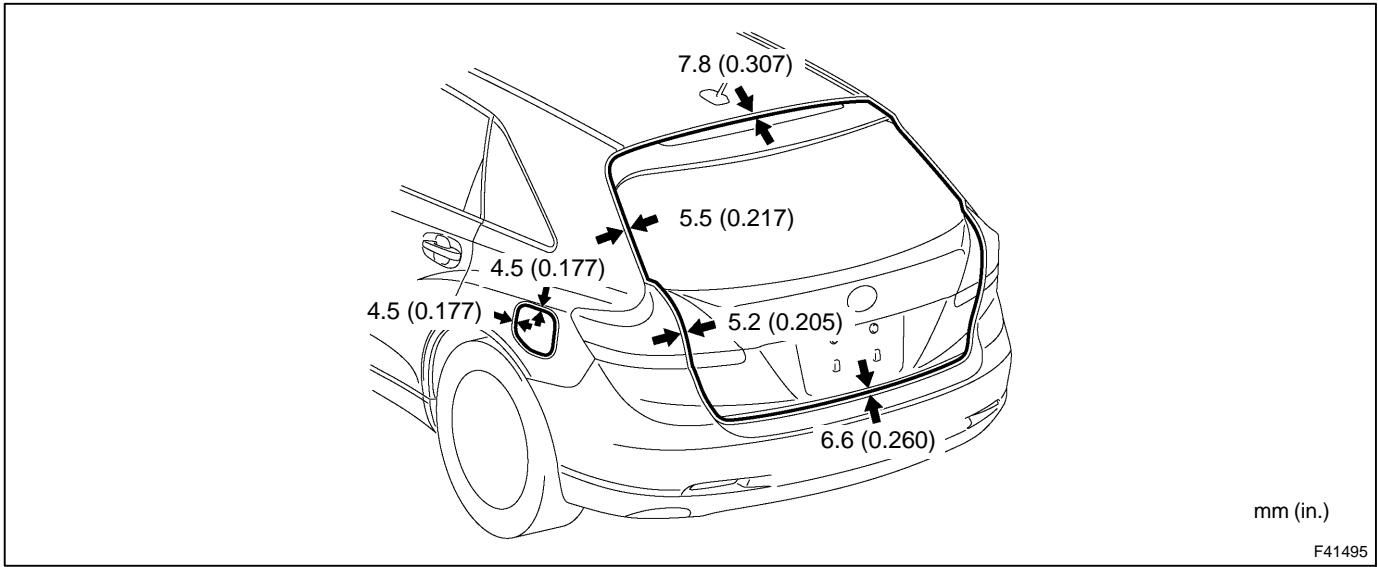
Torque:
26 N·m (265 kgf·cm, 19 ft·lbf)



- (e) Using a T40 "TORX" socket wrench, slightly loosen the striker mounting screws.
- (f) Using a brass bar and a hammer, hit the striker to adjust its position.
- (g) Using a T40 "TORX" socket wrench, tighten the striker mounting screws after the adjustment.

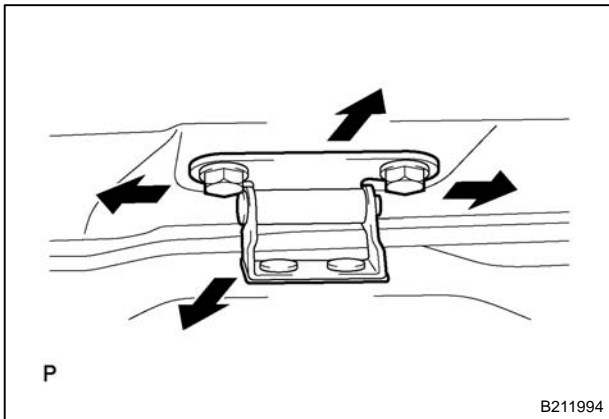
Torque:**23 N·m (235 kgf·cm, 17 ft·lbf)**

4. BACK DOOR



HINT:

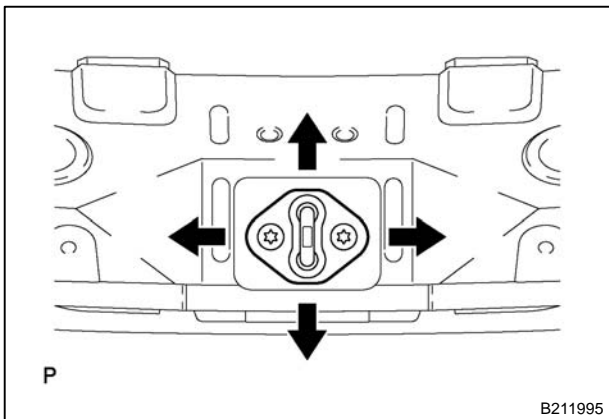
- Use the same procedure for the RH side and LH side.
- The following procedure is for the LH side.
- Centering bolts are used to mount the door hinge to the vehicle body and door. The door cannot be adjusted with the centering bolts installed. Substitute the centering bolts with standard bolts (with washers) when making adjustments.



- Before adjusting the upper end of the back door up and down or left and right, loosen the bolts.
- Tighten the body side hinge after the adjustment.

Torque:

19 N·m (194 kgf·cm, 14 ft·lbf)



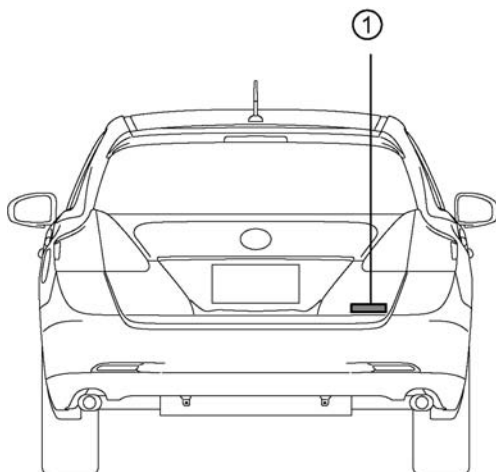
- Using a T40 "TORX" socket wrench, slightly loosen the striker mounting screws.
- Using a brass bar and a hammer, hit the striker to adjust its position.
- Using a T40 "TORX" socket wrench, tighten the striker mounting screws after the adjustment.

Torque:

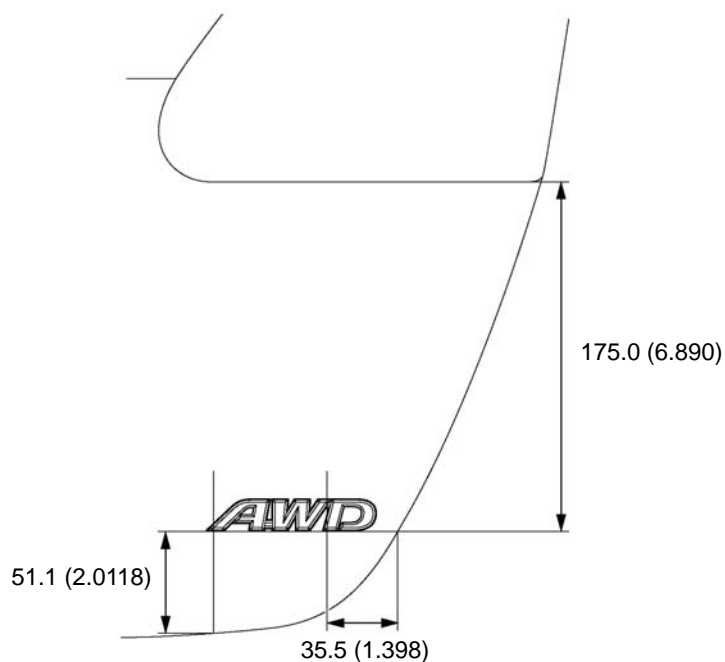
23 N·m (235 kgf·cm, 17 ft·lbf)

NAME PLATE APPLICATION PROCEDURE

- 1 Heat the double-sided tape remaining on the body with an infrared lamp or equivalent.
HINT:
Heat the tape to 40 to 60° C for approximately 1 to 2 minutes.
- 2 Wipe off the remaining double-sided tape using a clean cloth or equivalent.
HINT:
If a name plate is installed without thoroughly removing the remaining double-sided tape from the body, the name plate will not adhere properly. Make sure to thoroughly wipe off the double-sided tape.
- 3 After cleaning the installation area of the body with degreasing agent, attach the name plate to the position shown in the illustration.
HINT:
The working environment should be 20° C when installing the name plate. If the working environment is below 20° C, heat the installation area of the body to 20 to 30° C and then install the name plate.



① NO. 3 BACK DOOR NAME PLATE



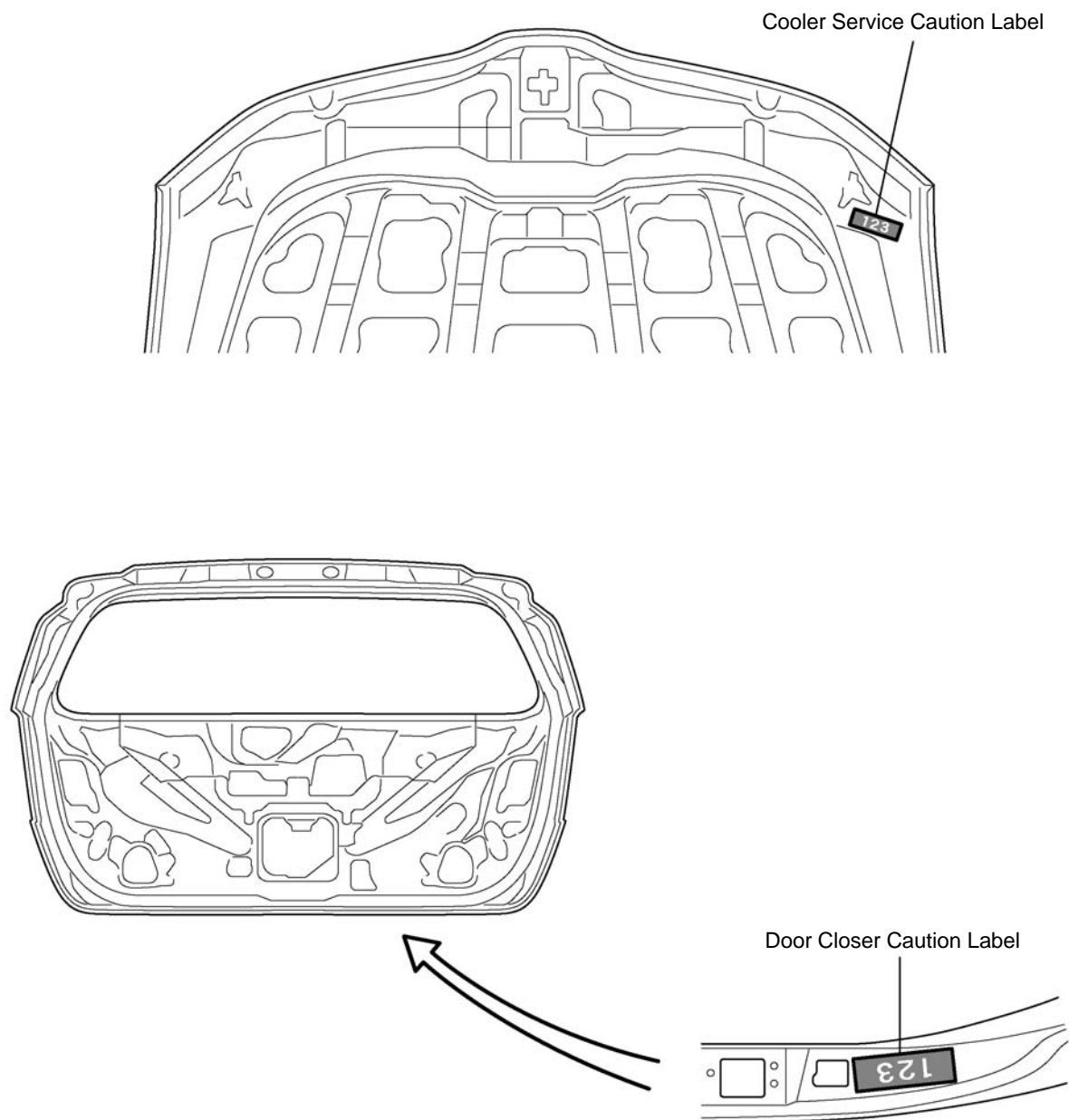
mm (in.)

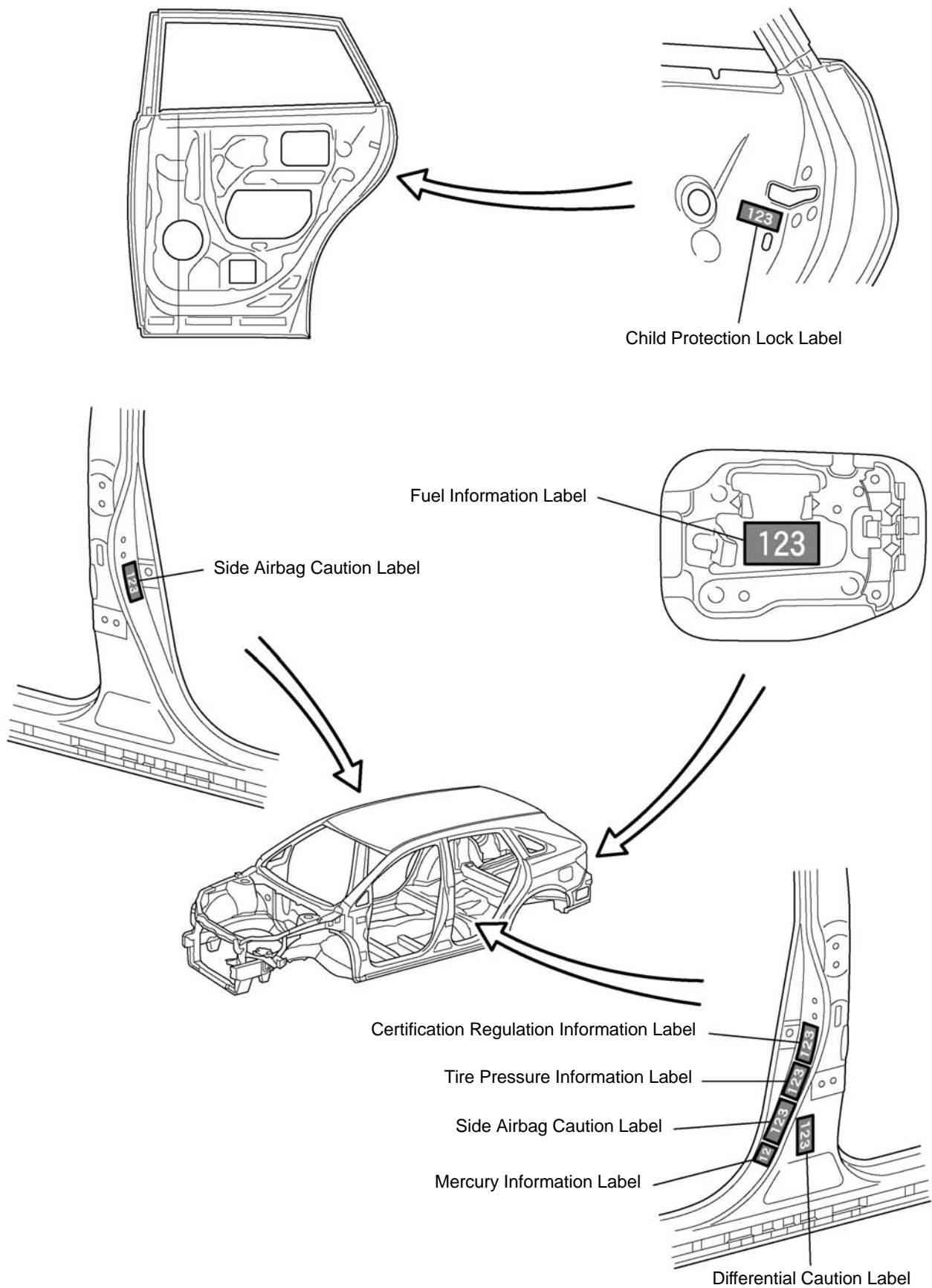
CAUTION LABEL ATTACHMENT POSITION

- 1 After using a degreasing agent to clean the surfaces of the body where the caution labels will be attached, attach the caution labels to the positions shown in the illustration.

HINT:

- Attach each caution label with its orientation the same as the numbers shown in the illustration.
- Make sure the caution label is not attached over a spot weld.
- When attaching the caution label, make sure not to touch the label's adhesive surface.
- To prevent the edges of the caution label from peeling, apply extra pressure to the label's periphery.
- If the work area's temperature is 5° C or less, the caution label's adhesive will deteriorate. It is recommended that you heat the label to 20 to 40° C.





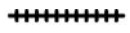
MEMO

BODY PANEL SEALING AREAS

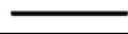
- 1 Be sure to apply body sealer to the body panel joints and door edges (tip of outer panel folded part), etc., to waterproof and rustproof them.

HINT:

- Apply degreasing agent to a clean cloth and clean the sealer application areas.
- After removing the applied spot sealer from the sealer application areas using thinner or equivalent, rust-proof the areas by applying primer or equivalent. Then apply body sealer.
- If sealer is unnecessarily applied to an area, apply degreasing agent to a clean cloth and clean off the sealer immediately.



Flat Finishing

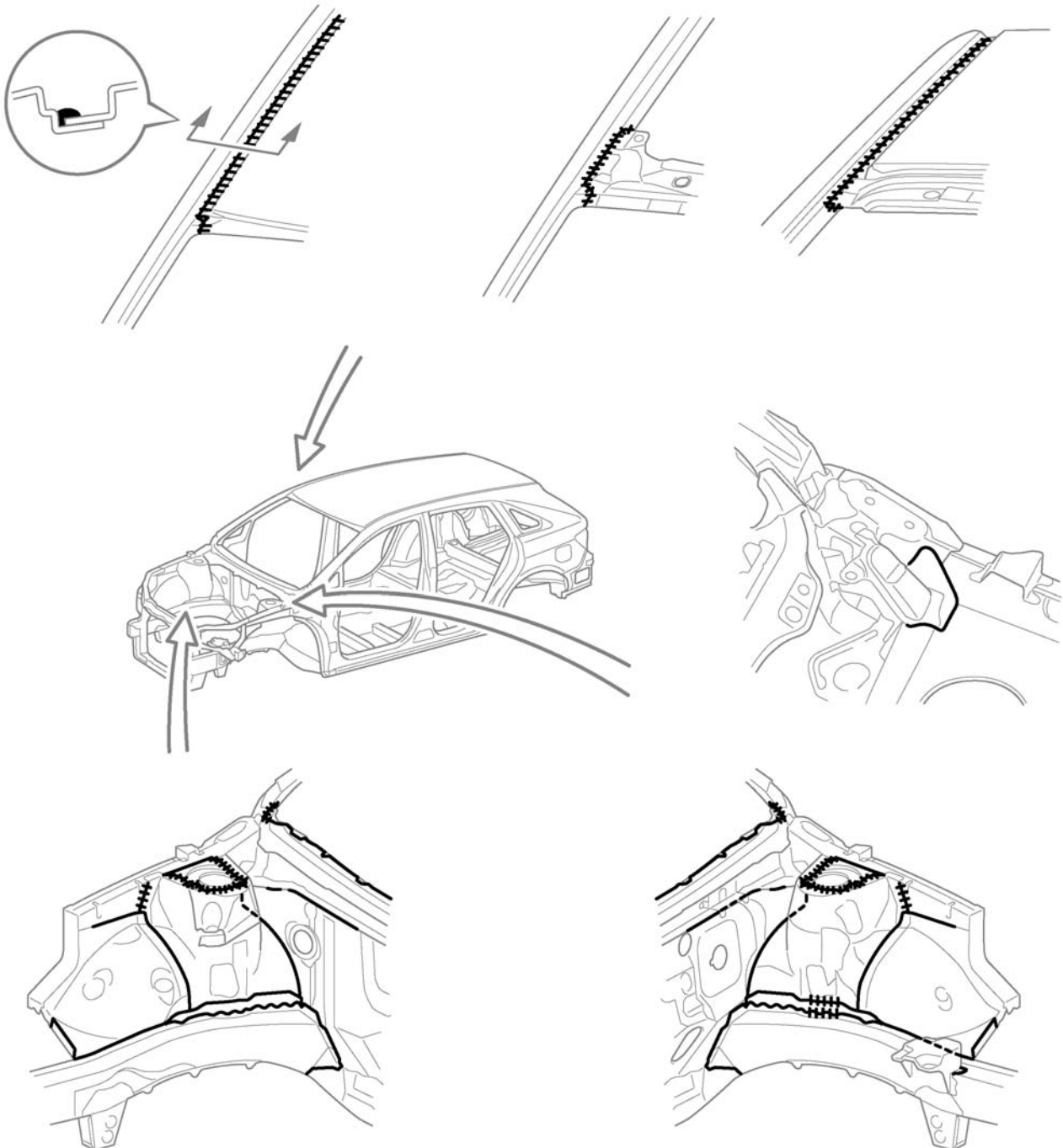


No Flat Finishing

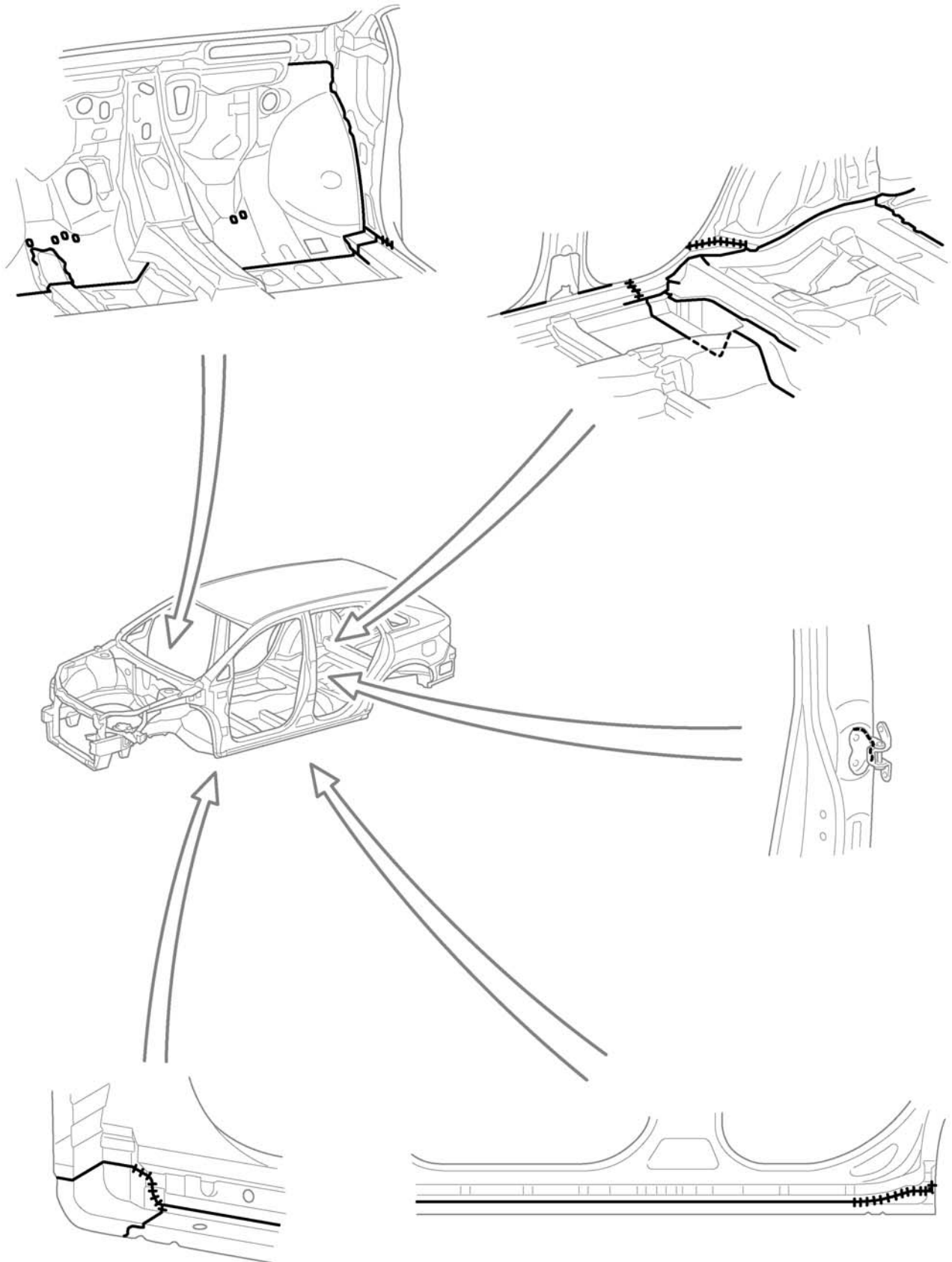
1. ENGINE COMPARTMENT

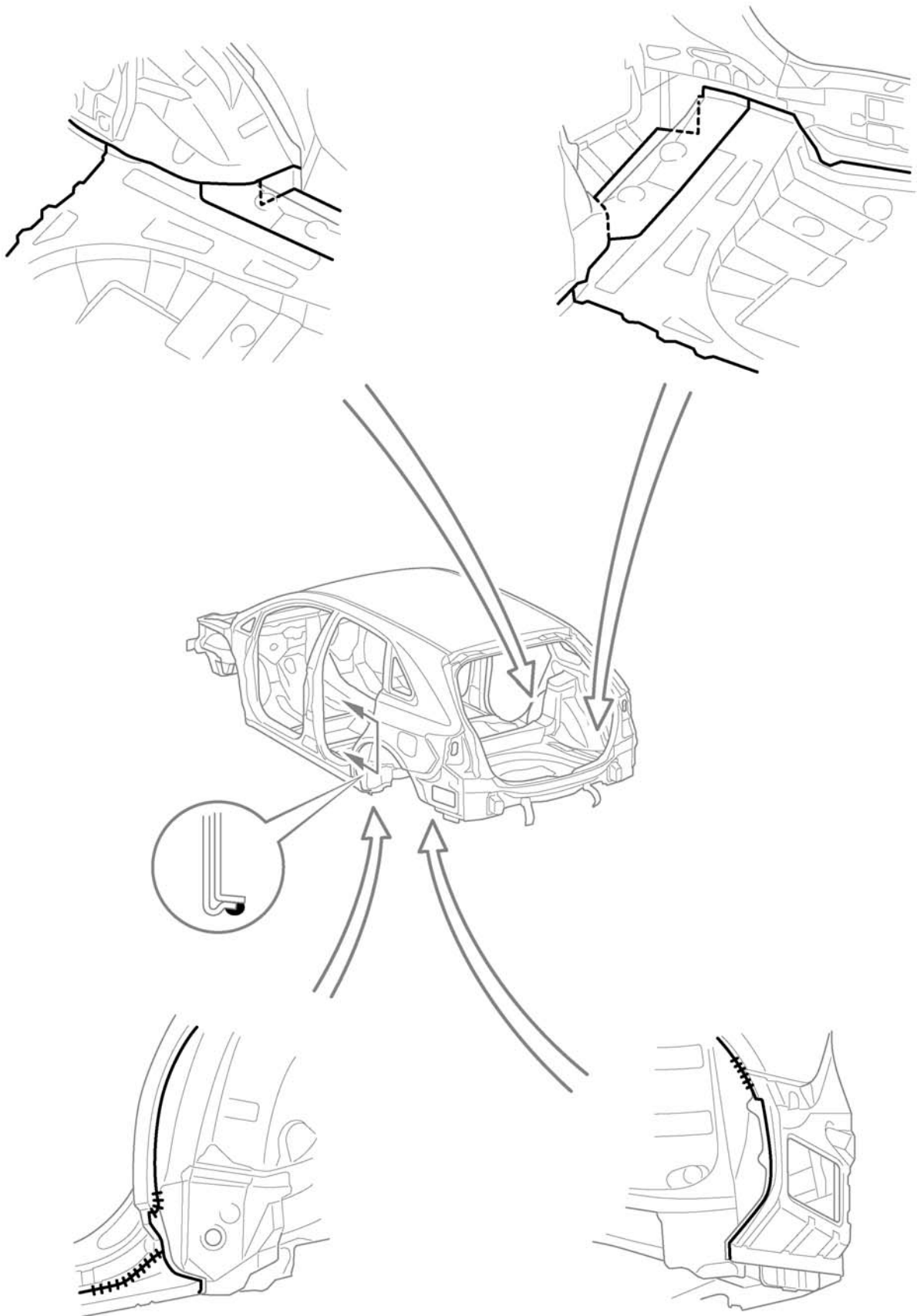
[w/o Sliding Roof]

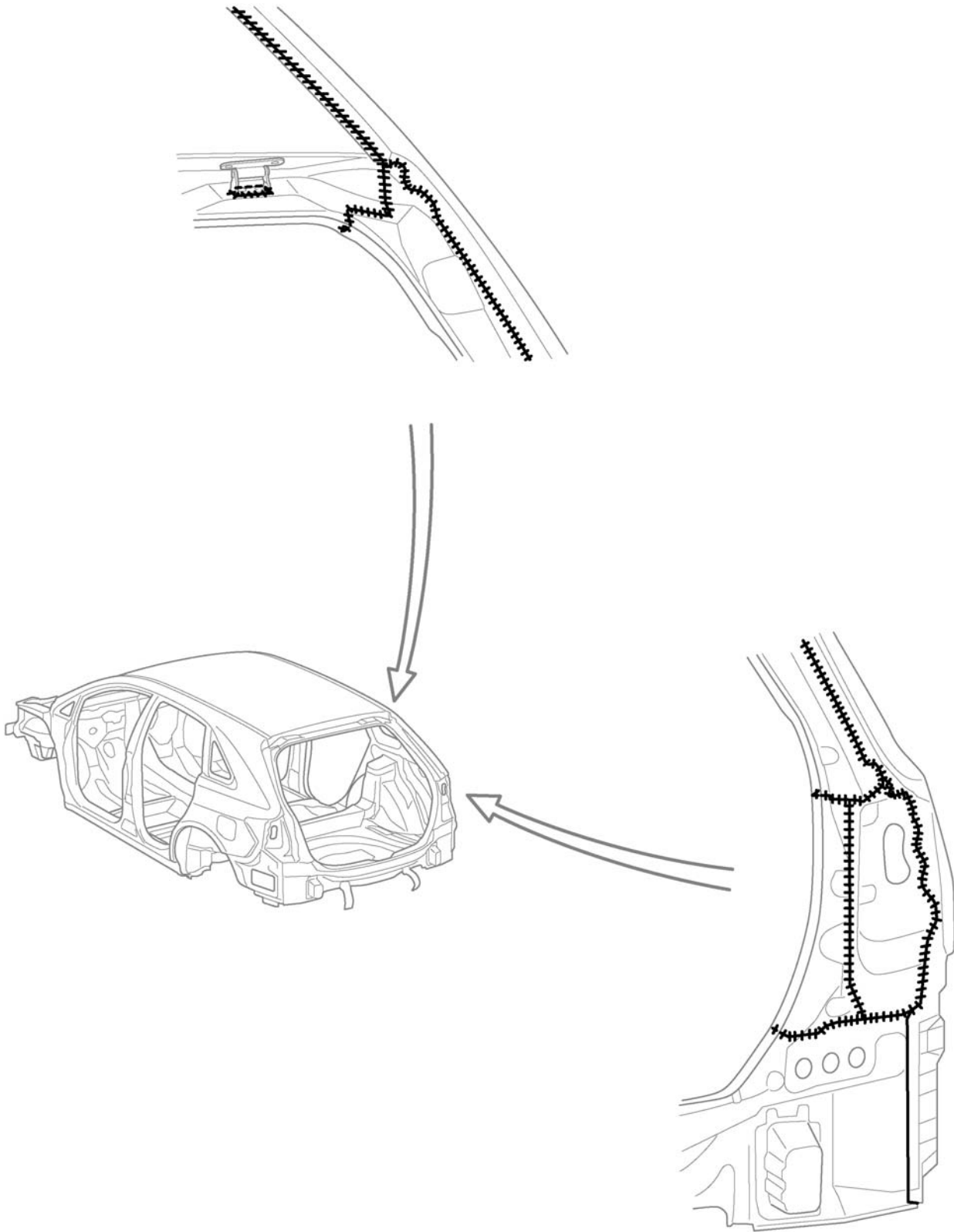
[w/ Sliding Roof]



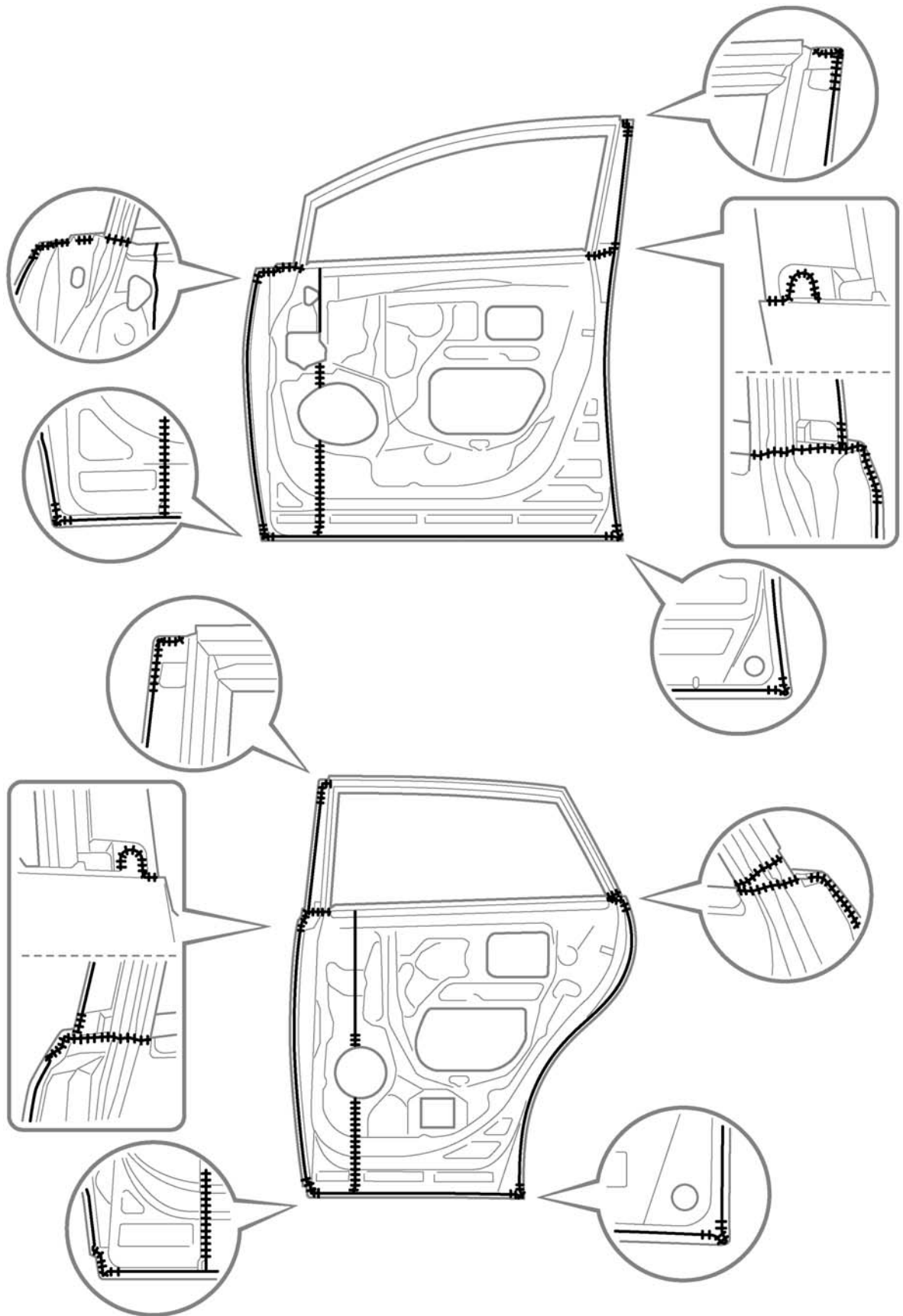
2. INSIDE

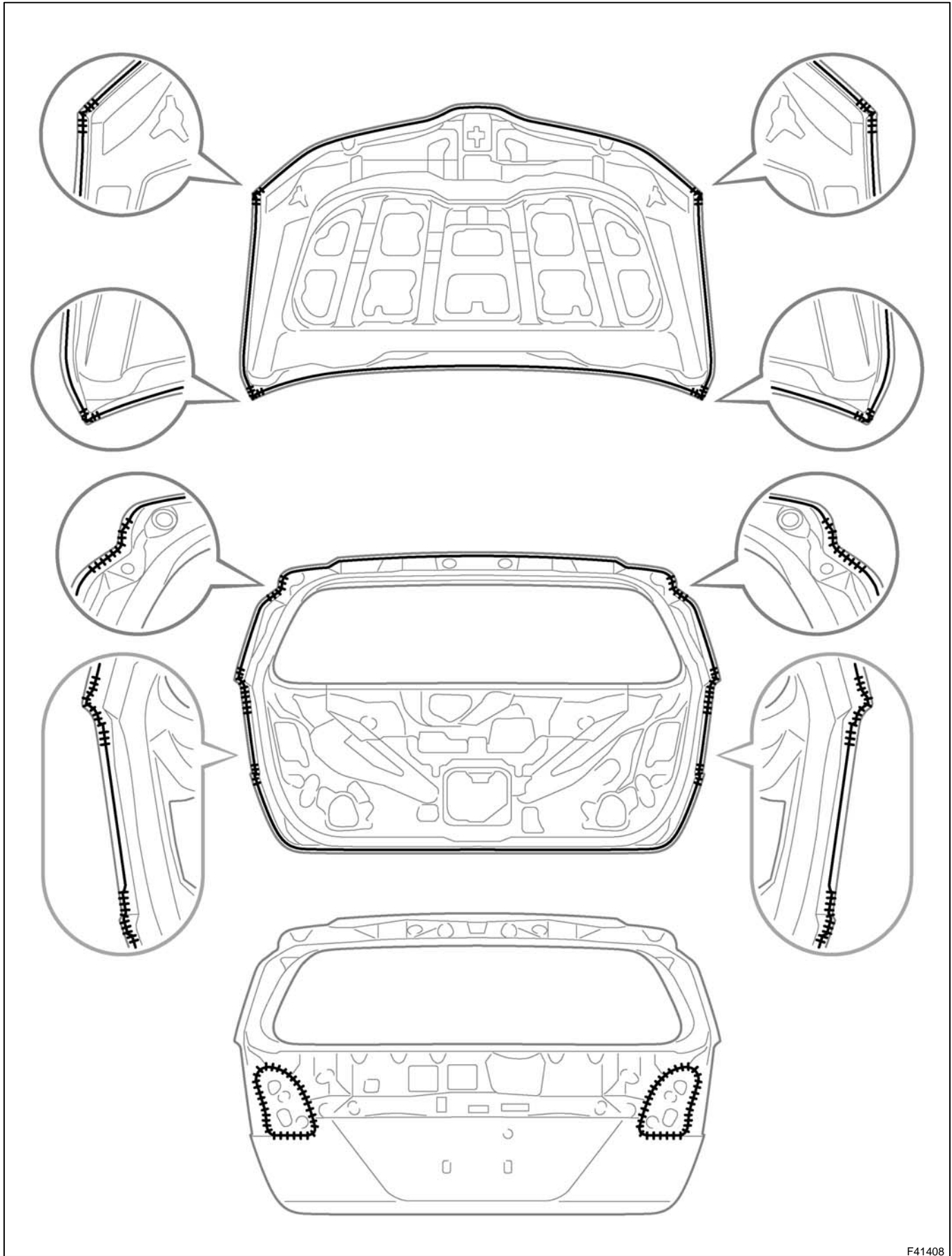




3. OUTSIDE

4. DOOR PARTS





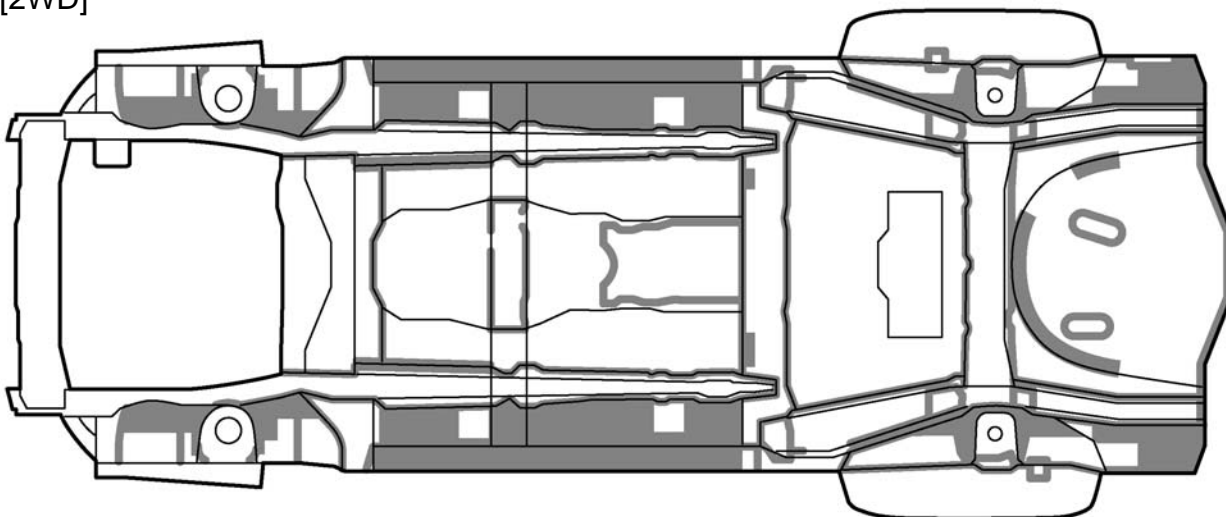
BODY PANEL UNDERCOATING AREAS

- 1 Apply undercoating to the chassis, floor underside, sheet metal fitting weld points of the body, and inside of the wheel house to prevent rust and noise, as well as protect the body from gravel.

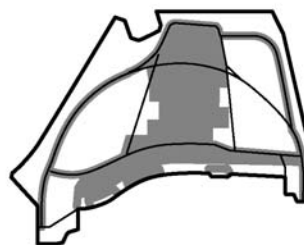
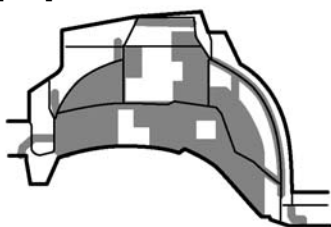
HINT:

- Work must be performed while wearing the appropriate protective gear and in a well-ventilated area.
- Apply degreasing agent to a clean cloth and clean any dirt and oil from the application areas.
- Cover the surrounding areas of the application areas with masking paper to avoid coating unnecessary areas.
- Do not coat high temperature areas, such as the tailpipe, or moving parts, such as the drive shaft.
- Do not leave any gaps between the panel joints.
- Apply sealer to the panel joints in advance.

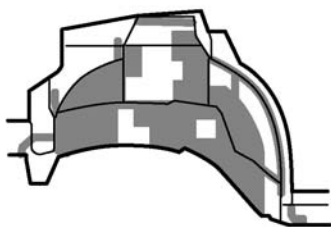
[2WD]



[LH]



[RH]

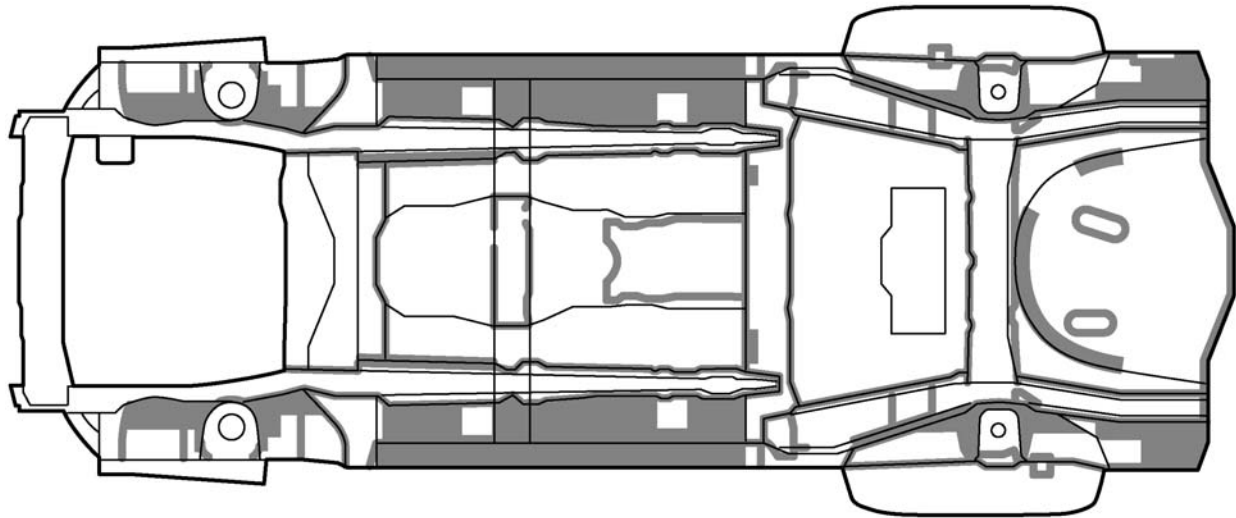


F41409

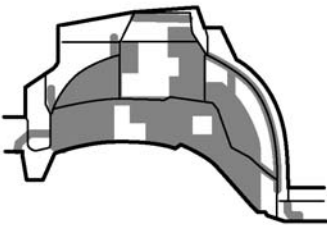
REFERENCE

- 1 Referring to the notes above, undercoating should be applied according to the specifications for your country.

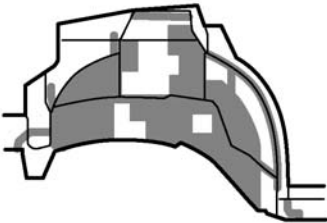
[AWD]



[LH]



[RH]



F41410

REFERENCE

- 1 Referring to the notes above, undercoating should be applied according to the specifications for your country.

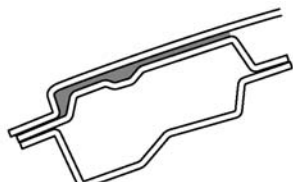
FOAMED SEALING MATERIAL APPLICATION AREAS

- 1 If an increase in temperature or other condition damages the foamed sealing material when repairing or replacing the panel, fill in the insufficient areas with foamed sealing material. The following illustration shows the areas for one side, but the foamed sealing material must be applied equally to both the left and right sides.

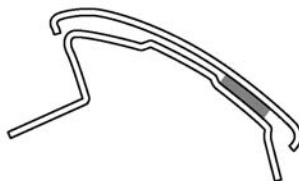
HINT:

- Work must be performed while wearing the appropriate protective gear and in a well-ventilated area.
- Apply tape or equivalent to any holes, nuts, etc., near the areas to be filled.

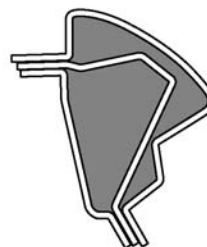
[w/o Sliding Roof]



a - a



b - b

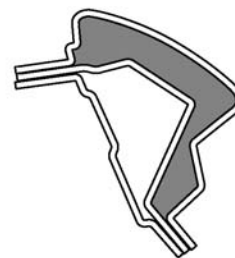


c - c

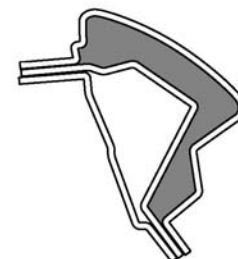
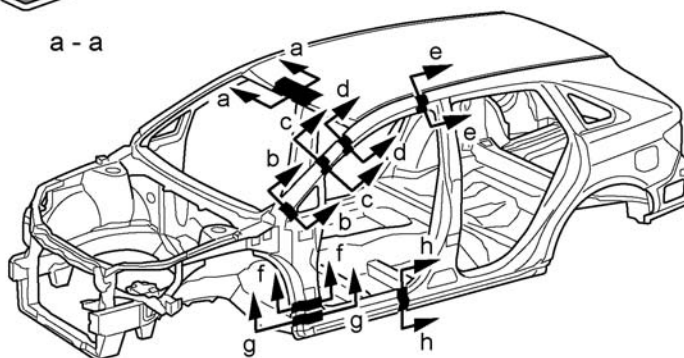
[w/ Sliding Roof]



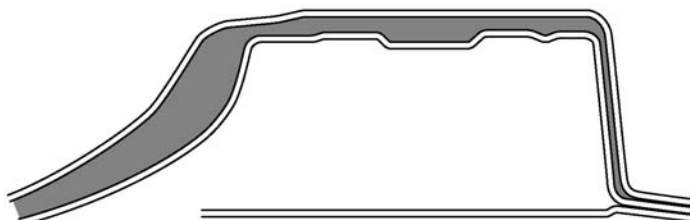
a - a



d - d



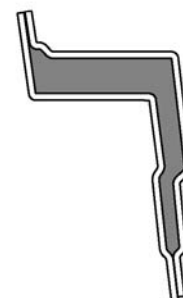
e - e



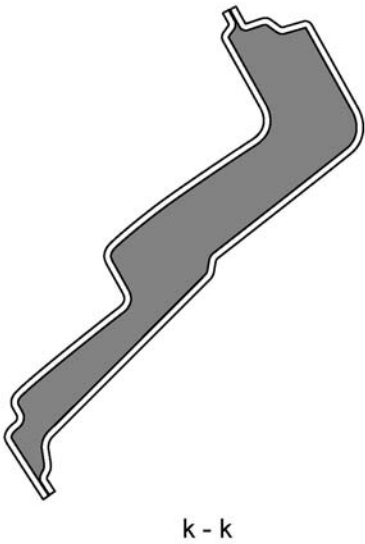
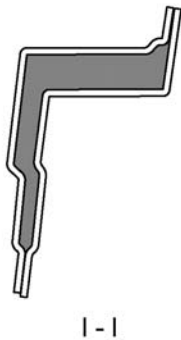
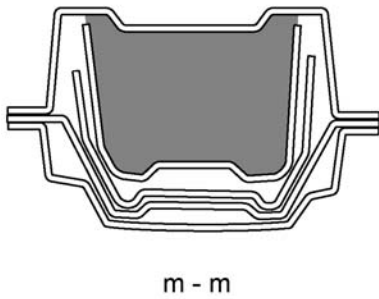
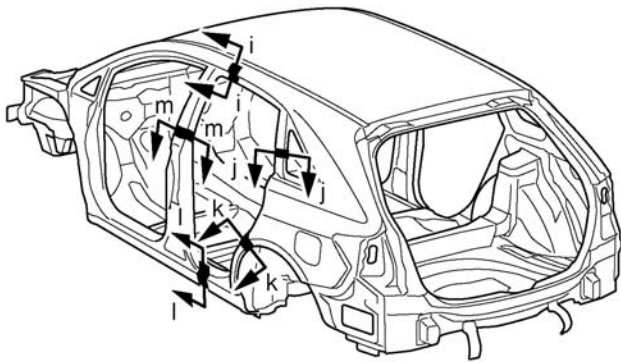
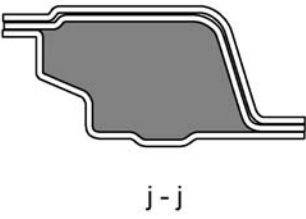
f - f



g - g



h - h

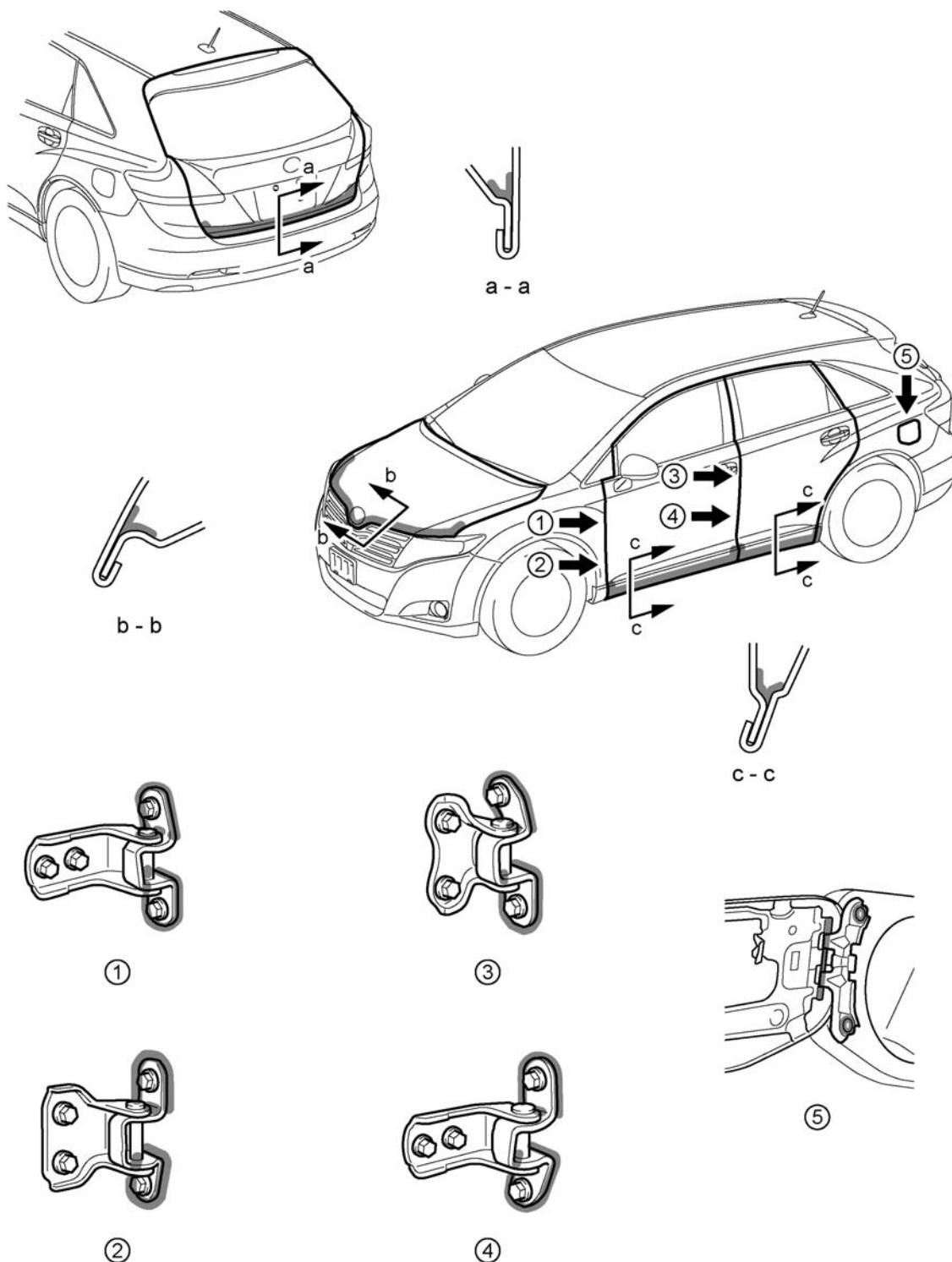


BODY PANEL ANTI-RUST AGENT (WAX) APPLICATION AREAS

- 1 Apply anti-rust agent (wax) to the doors and hood edges (tips of outer panel folded parts) and undersides, areas around hinges, etc., to prevent rust. Coat the undersides of the edges using a nozzle and air gun, and coat the areas around the hinges using a brush.

HINT:

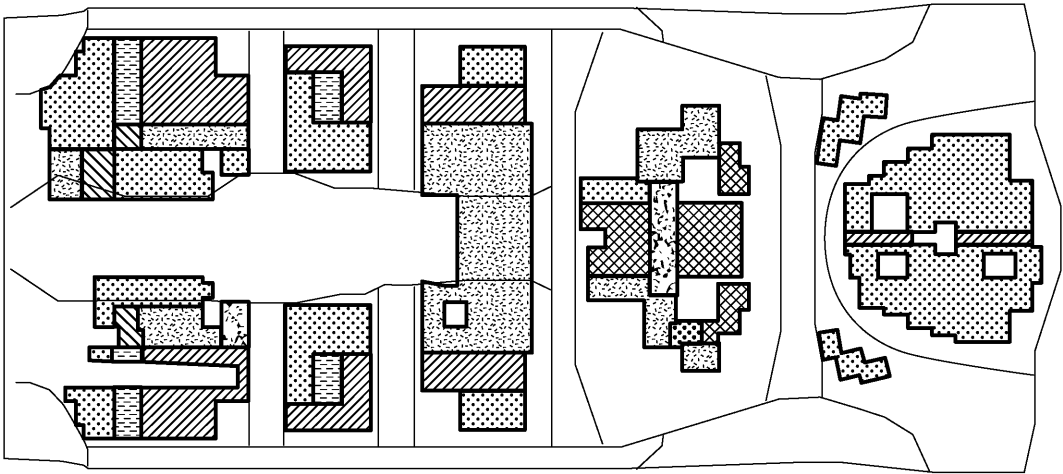
If anti-rust agent (wax) is unnecessarily applied to an area, apply degreasing agent to a clean cloth and clean off the anti-rust agent (wax) immediately.



SILENCER SHEET INSTALLATION AREAS

Thickness of Silencer Sheet mm (in.)

- ... 1.3 (0.051)
- ... 1.8 (0.071)
- ... 2.1 (0.083)
- ... 2.3 (0.091)
- ... 2.8 (0.110)
- ... 3.3 (0.130)
- ... 4.0 (0.157)
- ... 4.7 (0.185)

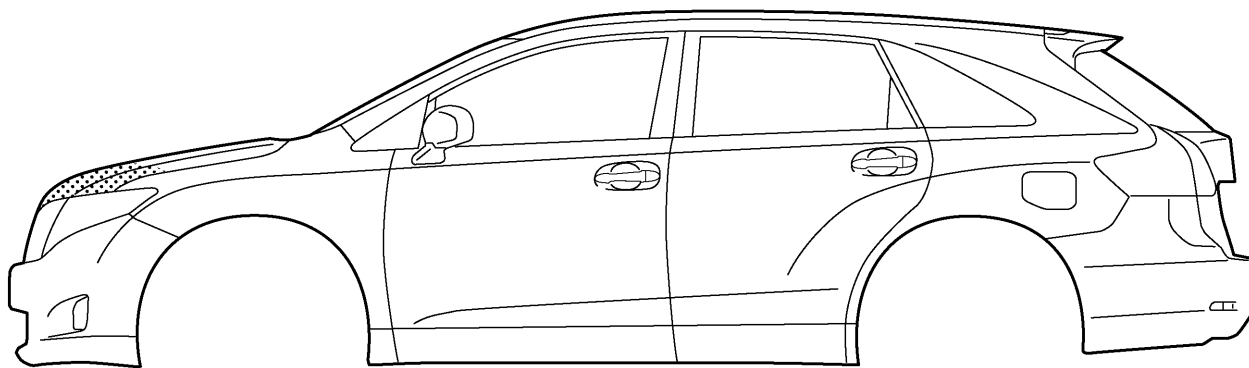
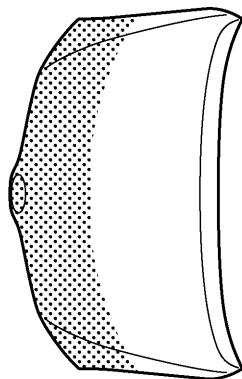


BODY PANEL ANTI-CHIPPING PAINT APPLICATION AREAS

- 1 To protect the body from damage due to gravel, apply the anti-chipping paint to the rocker panels, wheel arches, and lower parts of the doors.

HINT:

- Work must be performed while wearing the appropriate protective gear and in a well-ventilated area.
- Apply anti-chipping paint to the indicated areas first, before applying the top coat.
- If anti-chipping paint is unnecessarily applied to an area, apply degreasing agent to a clean cloth and clean the paint off immediately.



... Soft - Chip Primer

MEMO