Collision Repair

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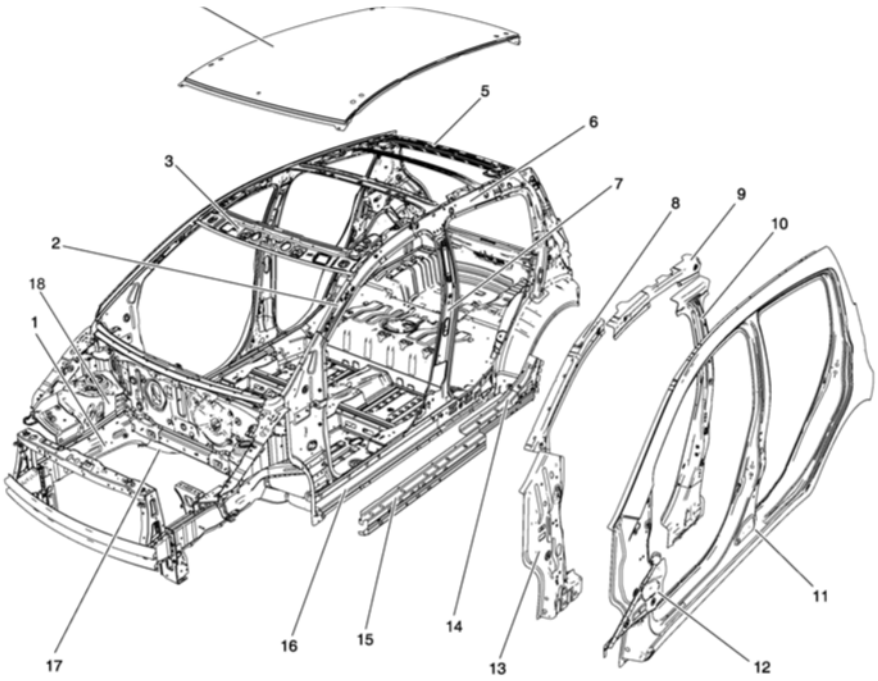
Visual Identification

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1. **BODY REPAIR**
2. COLLISION REPAIR
3. VISUAL IDENTIFICATION
4.

Structure Identification

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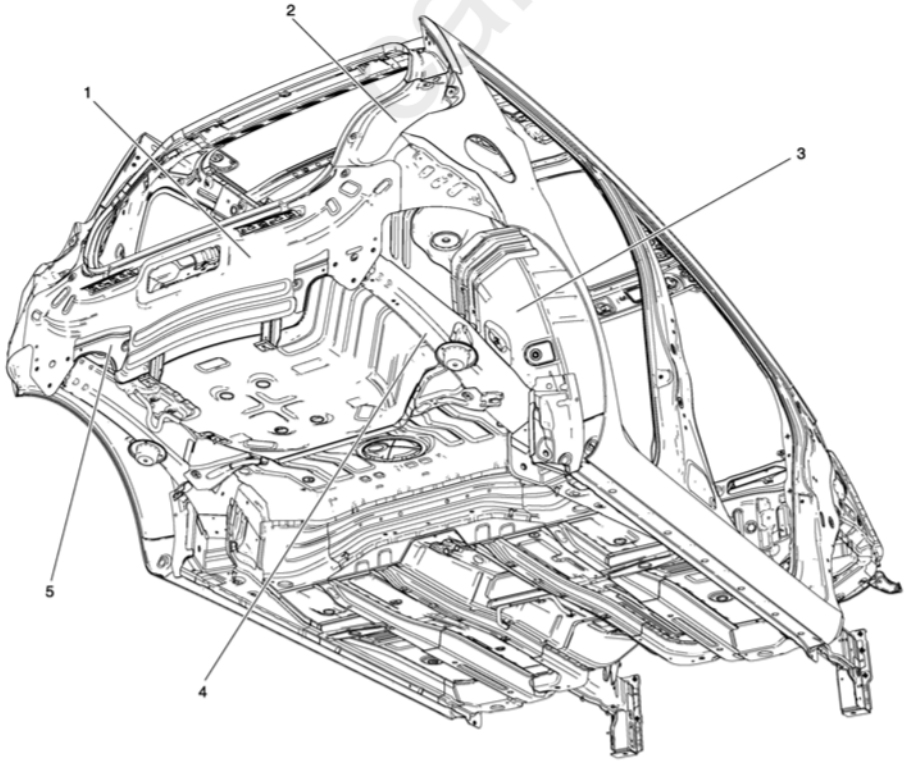
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Front View

Number	Description	Material	Procedure
1	Front Compartment Side Rail (Front)	High Strength Low Alloy Steel	Front Compartment Side Rail Bracket Replacement
2	Roof Inner Front Side Rail	Dual Phase Steel	â€”
3	Roof Front Inner Panel	Mild Steel	Roof Front Header Panel Replacement
4	Roof Panel	Mild Steel	Roof Outer Panel Replacement
5	Roof Rear Inner Panel Assembly	Mild Steel	Roof Rear Header Panel Replacement
6	Roof Inner Rear Side Rail	Dual Phase Steel	â€”
7	Center Pillar Inner Panel	Dual Phase Steel	Body Lock Pillar Inner Panel Replacement
8	Roof Outer Front Side Rail	Dual Phase Steel	â€”
9	Roof Outer Rear Side Rail	Dual Phase Steel	â€”
10	Center Pillar Reinforcement	High Strength Low Alloy Steel	Body Lock Pillar Outer Panel Reinforcement Replacement
11	Body Side Outer Panel	Mild Steel	Front Hinge Pillar Body Sectioning
12	Front Compartment Upper Side Rail	High Strength Low Alloy Steel	Front Compartment Upper Side Rail Replacement
13	Hinge Pillar Outer Lower Reinforcement	Dual Phase Steel	Body Hinge Pillar Lower Reinforcement Replacement
14	Rocker Outer Panel Center Pillar Reinforcement Assembly	Dual Phase Steel	Body Side Outer Panel Reinforcement Replacement
15	Rocker Front Outer Panel Reinforcement	Ultra High Strength Dual Phase Steel	Body Side Outer Panel Reinforcement Replacement
16	Rocker Inner Panel	Dual Phase Steel	â€”
17	Floor Panel #2 Cross Bar	Ultra High Strength Dual Phase Steel	â€”
18	Floor Panel #1 Cross Bar	Ultra High Strength Dual Phase Steel	â€”
19	Front Compartment Side Rail (Rear)	Mild Steel	Front Compartment Side Rail Bracket Replacement
20	Front Wheelhouse Rear Panel	High Strength Low Alloy Steel	Front Wheelhouse Panel Replacement

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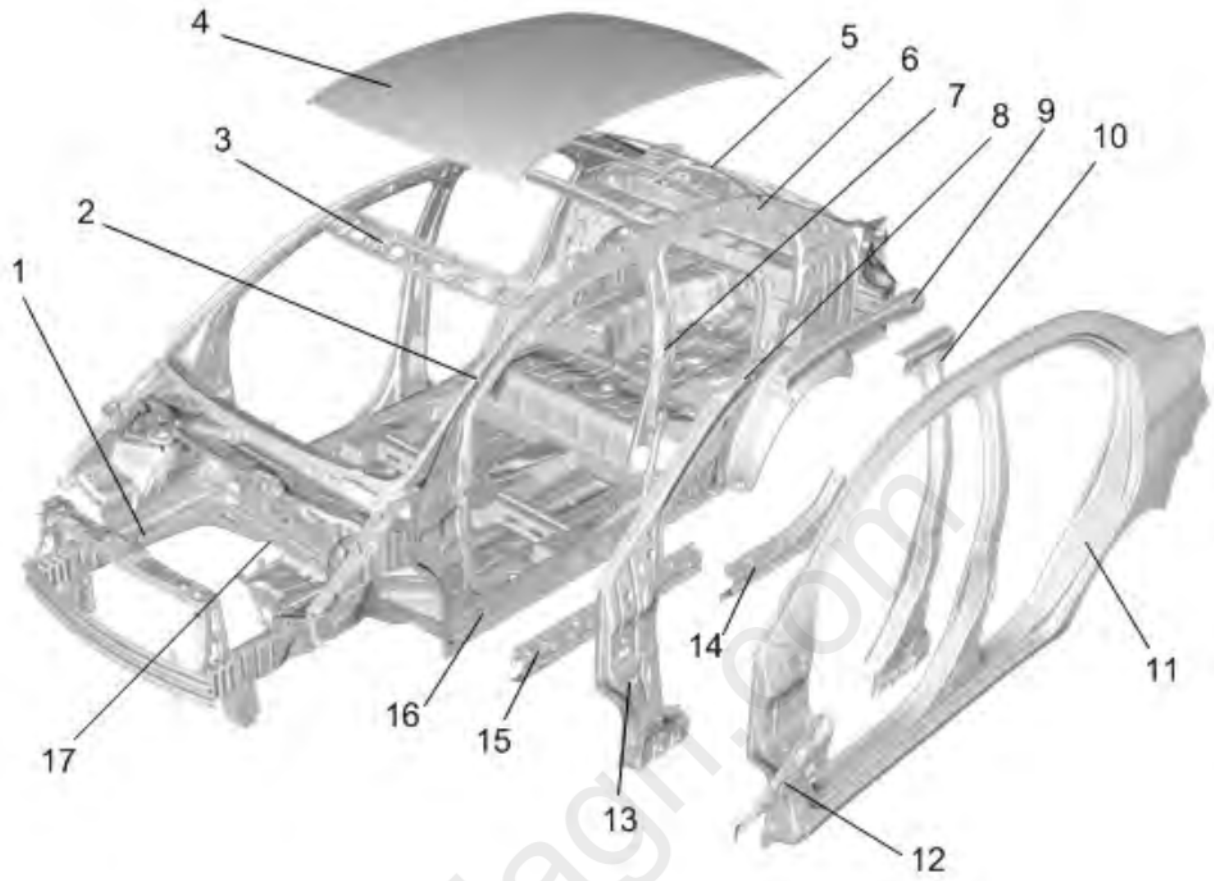
Rear View

Number	Description	Material	Procedure
1	Rear End Lower Panel	High Strength Low Alloy Steel	Rear End Panel Replacement
2	Body Tail Lamp Fill Panel	Mild Steel	Tail Lamp Pocket Replacement
3	Rear Wheelhouse Inner Panel	High Strength Low Alloy Steel	Quarter Inner Panel Replacement
4	Underbody Rear Side Rear Rail	High Strength Low Alloy Steel	Rear Rail Sectioning
5	Rear End Lower Panel Reinforcement	High Strength Low Alloy Steel	Rear End Panel Replacement

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1. BODY REPAIR
2. COLLISION REPAIR
3. VISUAL IDENTIFICATION
4.

Structure Identification (4NB)



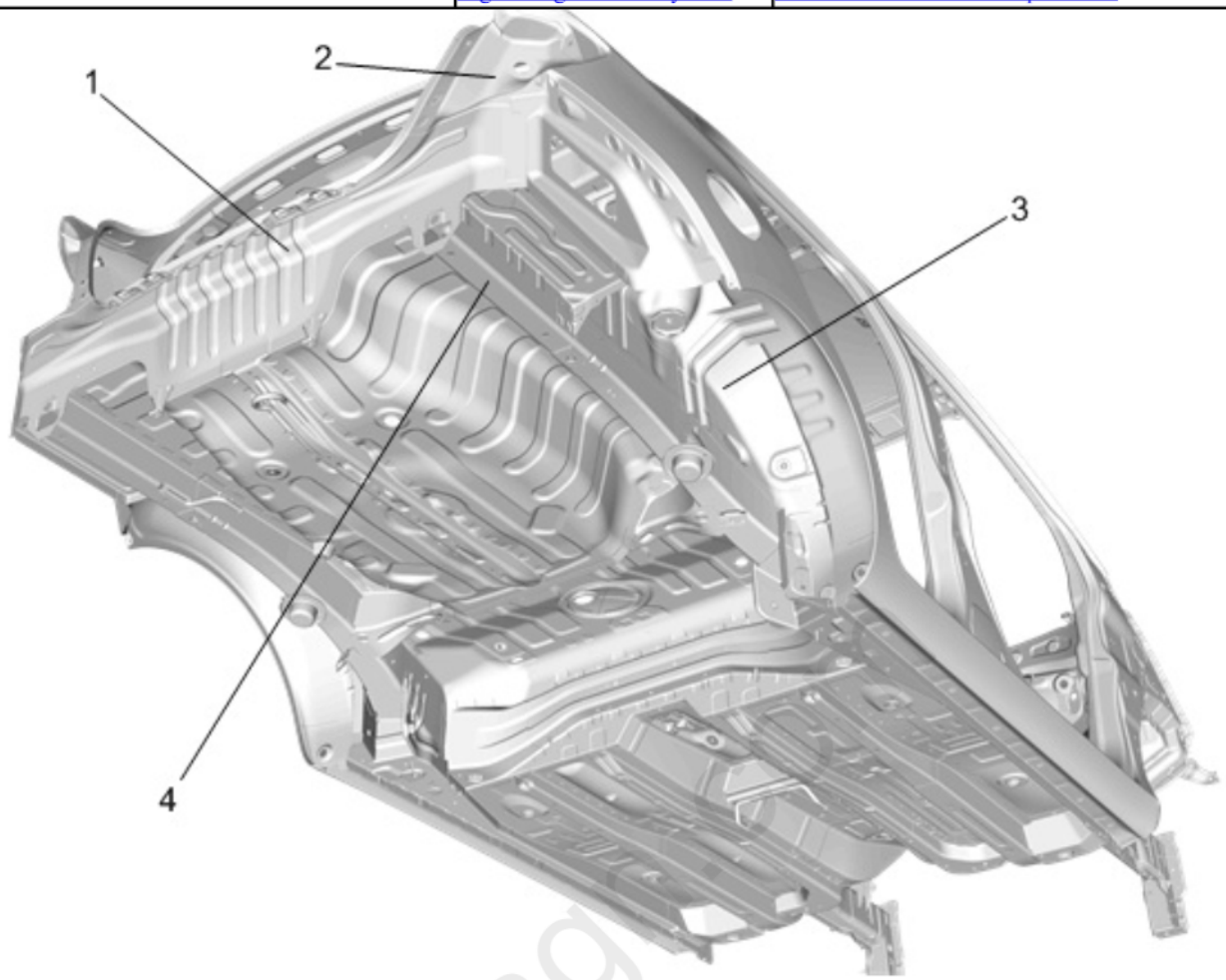
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Front View

Number	Description	Material	Procedure
1	Front Compartment Side Rail (Front)	High Strength Low Alloy Steel	Front Compartment Side Rail Bracket Replacement
2	Roof Inner Front Side Rail	Dual Phase Steel	â€”
3	Roof Front Inner Panel	Mild Steel	Roof Front Header Panel Replacement
4	Roof Panel	Mild Steel	Roof Outer Panel Replacement
5	Roof Rear Inner Panel Assembly	Mild Steel	Roof Rear Header Panel Replacement
6	Roof Inner Rear Side Rail	Dual Phase Steel	â€”
7	Center Pillar Inner Panel	Dual Phase Steel	Body Lock Pillar Inner Panel Replacement
8	Roof Outer Front Side Rail	Dual Phase Steel	â€”
9	Roof Outer Rear Side Rail	Dual Phase Steel	â€”
10	Center Pillar Reinforcement	High Strength Low Alloy Steel	Body Lock Pillar Outer Panel Reinforcement Replacement
11	Body Side Outer Panel	Mild Steel	Front Hinge Pillar Body Sectioning
12	Front Compartment Upper Side Rail	High Strength Low Alloy Steel	Front Compartment Upper Side Rail Replacement
13	Hinge Pillar Outer Lower Reinforcement	Dual Phase Steel	Body Hinge Pillar Lower Reinforcement Replacement
14	Rocker Outer Panel Center Pillar Reinforcement Assembly	Dual Phase Steel	Body Side Outer Panel Reinforcement Replacement
15	Rocker Front Outer Panel Reinforcement	Ultra High Strength Dual Phase Steel	Body Side Outer Panel Reinforcement Replacement
16	Rocker Inner Panel	Dual Phase Steel	â€”
17	Floor Panel #2 Cross Bar	Ultra High Strength Dual Phase Steel	â€”
18	Floor Panel #1 Cross Bar	Ultra High Strength Dual Phase Steel	â€”

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Number	Description	Material	Procedure
19	Front Compartment Side Rail (Rear)	Mild Steel	Front Compartment Side Rail Bracket Replacement
20	Front Wheelhouse Rear Panel	High Strength Low Alloy Steel	Front Wheelhouse Panel Replacement



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Rear View

Number	Description	Material	Procedure
1	Rear End Lower Panel	High Strength Low Alloy Steel	Rear End Panel Replacement
2	Body Tail Lamp Fill Panel	Mild Steel	Tail Lamp Pocket Replacement
3	Rear Wheelhouse Inner Panel	High Strength Low Alloy Steel	Quarter Inner Panel Replacement
4	Underbody Rear Side Rear Rail	High Strength Low Alloy Steel	Rear Rail Sectioning
5	Rear End Lower Panel Reinforcement	High Strength Low Alloy Steel	Rear End Panel Replacement

Description and Operation

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1. **BODY REPAIR**
2. COLLISION REPAIR
3. DESCRIPTION AND OPERATION
4.

Dual Phase Steel

This information provides repair recommendations and general guidelines for steel classified as Dual Phase Steel with a tensile strength up to and including 800â€‰MPa, also known as DP.

General Motors recommends the following when repairing or replacing this type of steel during collision repair.

Note**:**

The use of heat to repair damage is not recommended for this classification of steel.

Recommended Repairs

- Cold repairs can be performed on this type of steel, unless the damage includes kinks. If the damage includes kinks, the part should be replaced.
- Sectioning or partial replacement of this type of steel is recommended only at approved locations, in a specific sectioning procedure.
- This type of steel can be used as a sleeve, or backer plate, when recommended in a specific sectioning procedure.
- Squeeze resistance spot welding can be used to replace factory spot welds, where applicable.
- MIG plug welding and MIG stitch welding can be used on this type of steel.
- MIG brazing can be used on this type of steel.

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1. **BODY REPAIR**
2. COLLISION REPAIR
3. DESCRIPTION AND OPERATION
4.

High Strength Low Alloy Steel

This information provides repair recommendations and general guidelines for steel classified as High Strength Low Alloy Steel, also known as HSLA. This type of steel normally has a tensile strength range from 300â€“700â€‰MPa.

General Motors recommends the following when repairing or replacing this type of steel during collision repair.

Recommended Repairs

- Cold repairs can be performed on this type of steel, unless the damage includes kinks. If the damage includes kinks, the part should be replaced.
- Controlled use of heat can be used to repair damage, if the heat does not exceed 650Â°â€‰C (1200Â°â€‰F). The heat should be applied a maximum of 2â€‰times, for up to 90â€‰seconds.
- Sectioning or partial replacement of this type of steel is recommended only at approved locations, in a specific sectioning procedure.
- This type of steel can be used as a sleeve, or backer plate, during sectioning procedures.
- Squeeze resistance spot welding can be used to replace factory spot welds, where applicable.
- MIG plug welding and MIG stitch welding can be used on this type of steel.
- MIG Brazing can be used on this type of steel.

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1. **BODY REPAIR**
2. COLLISION REPAIR
3. DESCRIPTION AND OPERATION
4.

Mild Steel

This information provides repair recommendations and general guidelines for steel classified as Mild Steel. This type of steel normally has a tensile strength less than 270â€‰MPa. This includes the common steel names of:

- Mild Steel
- Bake Hardenable Steel (BH)
- Solid Solution Strengthened Steel

General Motors recommends the following when repairing or replacing this type of steel during collision repair.

Recommended Repairs

- Cold repairs can be performed on this type of steel, unless the damage includes kinks. If the damage includes kinks, the part should be replaced.
- Controlled use of heat can be used to repair damage, if the heat does not exceed 650Â°â€‰C (1200Â°â€‰F). The heat should be applied a maximum of 2â€‰times, for up to 90â€‰seconds.
- Sectioning or partial replacement of this type of steel is recommended only at approved locations, in a specific sectioning procedure.
- This type of steel can be used as a sleeve, or backer plate, when recommended in a specific sectioning procedure.
- Squeeze resistance spot welding can be used to replace factory spot welds, where applicable
- MIG plug welding and MIG stitch welding can be used on this type of steel.
- MIG Brazing can be used on this type of steel.

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1. **BODY REPAIR**
2. COLLISION REPAIR
3. DESCRIPTION AND OPERATION
4.

Ultra High Strength Dual Phase Steel

This information provides repair recommendations and general guidelines for steel classified as Ultra High Strength Dual Phase Steel (Dual Phase Steel with a tensile strength greater than 800â€‰MPa), also known as DPX.

General Motors recommends the following when repairing or replacing this type of steel during collision repair.

Note**:**

- Repair of this type of steel is not recommended.
- This type of steel should be replaced at factory joints only. Sectioning or partial replacement is not recommended.
- The use of heat to repair damage is not recommended for this type of steel.
- Stitch welding is not recommended for this type of steel.
- This classification of steel can not be used as a backing reinforcement or a sleeve for a sectioning joint, unless a specific procedure is available.

  Recommended Repairs
- Squeeze resistance spot welding can be used to replace factory spot welds, where applicable.
- MIG plug welding can be used to replace factory spot welds.
- MIG brazing can be used to replace factory spot welds.

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Repair Instructions

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1. **BODY REPAIR**
2. COLLISION REPAIR
3. REPAIR INSTRUCTIONS
4.

Overlap/Backing Plate Sectioning

1. Warning**:**

   Refer to Approved Equipment for Collision Repair Warning.

2. Fit the service panel to the vehicle to ensure a proper fit.
3. Measure and mark a line at the sail panel 120â€‰mm (4 3â€‰in) from the back glass opening and 70â€‰mm (2 34â€‰in) rearward from the rocker panel locating hole edge of the service panel.
4. Cut along the line to trim the service panel.
5. Fabricate a 50â€‰mm (2â€‰in) backer plate so that the panel will fit behind the sectioning joint at the sail panel.
6. Fabricate a 100â€‰mm (4â€‰in) backer plate for the rocker panel.
7. Drill 8â€‰mm (516â€‰in) plug weld holes as necessary in the locations noted from the original panel.
8. Bevel the sail panel and service panel edges at the sectioned area to approximately 10â€‰degrees.
9. Grind a 50â€‰mm (2â€‰in) area of the outer surface on the vehicle to remove any corrosion, E-coat, primers, coatings and galvanizing that may be present.
10. At the section area on the service panel, grind a 50â€‰mm (2â€‰in) area of the back side to remove any corrosion, E-coat, primers, coatings and galvanizing that may be present.
11. Drill plug weld holes approximately 13â€‰mm (12â€‰in) from the edge of the cuts the sectioning areas of the service panel and the original panel.
12. Prepare all mating surfaces as necessary.
13. Apply GM-approved weld-thru coating or equivalent to all mating surfaces. Refer to Anti-Corrosion Treatment and Repair.
14. Position and clamp or screw the backer plate with half of the backer plate exposed at the sectioning joint.
15. Note**:**

    Leave a gap of 1 12â€‰times the thickness of the metal at the sectioning joint to the original panel.

16. Position the service panel to overlap the backer plate and 1 12â€‰times the thickness up to the original panel.
17. Check for proper fit and alignment to the vehicle. Clamp the panels together.
18. Plug weld the backer plate accordingly.
19. Stitch weld along the entire sectioning joint, make 25â€‰mm (1â€‰in) welds along the seam with 25â€‰mm (1â€‰in) gaps between them.
20. Complete the stitch weld.
21. Clean and prepare all welded surfaces of the entire sectioning joint.
22. Note**:**

    Always follow the system manufacturer\'s instructions for application, handling, and curing.

23. Apply a lightweight body filler to the backer plate area.

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1. **BODY REPAIR**
2. COLLISION REPAIR
3. REPAIR INSTRUCTIONS
4.

Drivetrain and Front Suspension Frame Front Support Replacement

Removal Procedure

1. Warning**:**

   Refer to Approved Equipment for Collision Repair Warning

2. Warning**:**

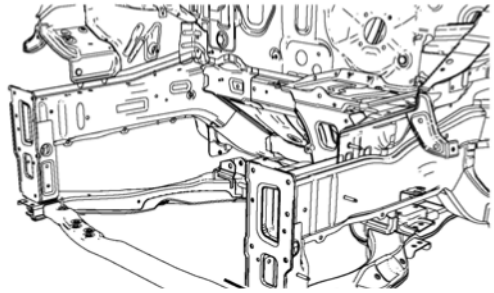
   Refer to Collision Sectioning Warning

3. Warning**:**

   Refer to Glass and Sheet Metal Handling Warning

4. Disable the SIR System. Refer to SIR Disabling and Enabling
5. Disconnect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection
6. Remove all related panels and components.
7. Visually inspect the damage. Repair as much of the damage as possible.
8. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair

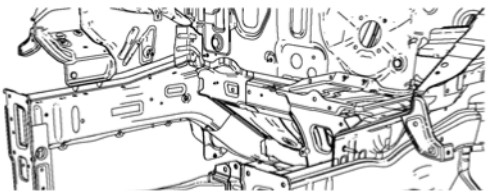
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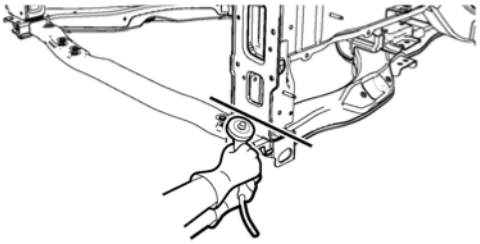


9. Click here for full size

10. Create cut lines on the drivetrain and front suspension frame front support.



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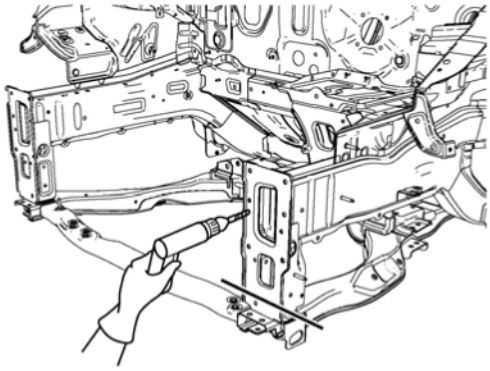


11. [Click here for full size]
12. Note:

    Do not damage any inner panels or reinforcements.

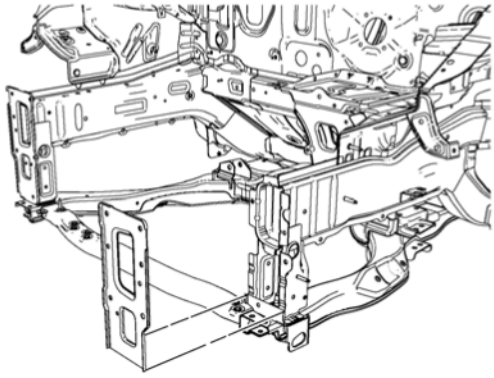
13. Cut the panel where sectioning is to be performed.

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14. Click here for full size
15. Locate and mark all the necessary factory welds of the drivetrain and front suspension frame front support.
16. Drill all factory welds. Note the number and location of welds for installation of the service assembly.

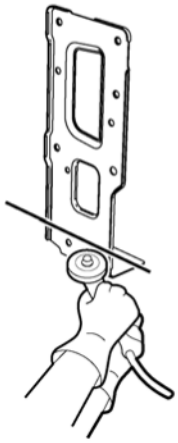
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17. Click here for full size
18. Remove the damaged drivetrain and front suspension frame front support.

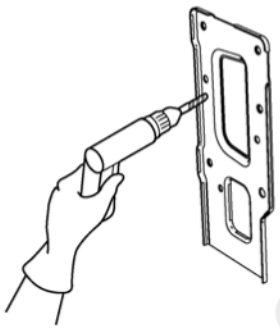
Installation Procedure



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1. Click here for full size
2. Cut the drivetrain and front suspension frame front support in corresponding locations to fit the remaining original panel. The sectioning joint should be trimmed to allow a gap of one-and-one-half-times the metal thickness at the sectioning joint.
3. Create a 50â€‰mm (2â€‰in) backing plate from the unused portion of the service part.
4. Drill 8â€‰mm (516â€‰in) along the sectioning cut on the remaining original part. Locate these holes 13â€‰mm (12â€‰in) from the edge of part and spaced 40â€‰mm (112â€‰in) apart.
5. Prepare all mating surfaces as necessary.

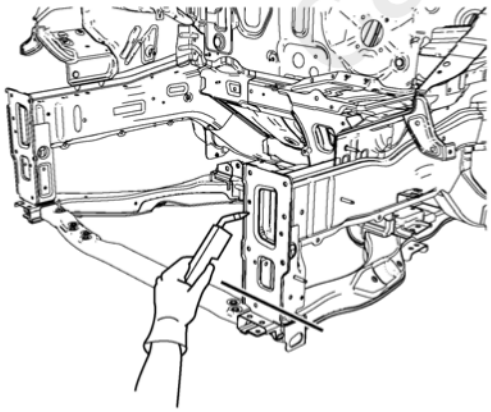
6. Fit the backing plates halfway into the sectioning joints, clamp in place and plug weld to the vehicle.
7. Align the drivetrain and front suspension frame front support.



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8. Click here for full size
9. Drill 8â€‰mm (516â€‰in) for plug welding along the edges of the front suspension frame front support as noted from the original panel.
10. Clean and prepare the attaching surfaces for welding.
11. Position the front suspension frame front support on the vehicle.
12. Verify the fit of the front suspension frame front support.
13. Clamp the front suspension frame front support into position.

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14. Click here for full size

15. Plug weld accordingly.

16. To create a solid weld with minimum heat distortion, make 25 mm (1 in) stitch welds along the seam with 25â€‰mm (1â€‰in) gaps between them. Then go back and complete the stitch weld.

17. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.

18. Paint the repaired area. Refer to Basecoat/Clearcoat Paint Systems.

19. Install all related panels and components.

20. Connect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.

21. Enable the SIR system. Refer to SIR Disabling and Enabling.

Related Part Information

Part Name	Catalog Name	Part Code
Drivetrain and Front Suspension Frame Front Support	SUPPORT,DRIVETRAIN & FRT SUSP FRM FRT	6581A
Drivetrain and Front Suspension Frame Front Support	SUPPORT,DRIVETRAIN & FRT SUSP FRM FRT	6581B

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1. **BODY REPAIR**
2. COLLISION REPAIR
3. REPAIR INSTRUCTIONS
4.

Front Compartment Side Rail Bracket Replacement

Removal Procedure

1. Warning**:**

   Refer to Approved Equipment for Collision Repair Warning.

2. Warning**:**

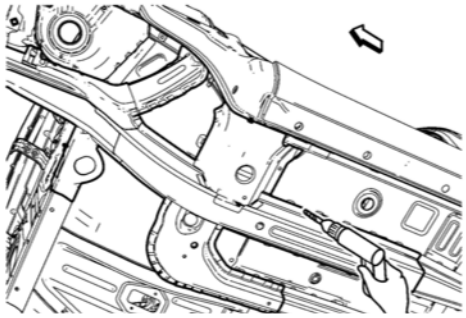
   Refer to Glass and Sheet Metal Handling Warning.

3. Note**:**

   In the Removal Procedure, steps 6, 7 and 8 are exactly the same except with different graphics.

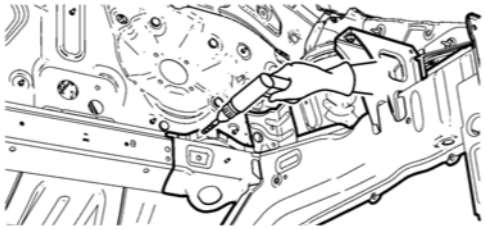
4. Disable the SIR System. Refer to SIR Disabling and Enabling.
5. Disconnect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.
6. Remove all the related panels and components.
7. Visually inspect the damage. Repair as much of the damage as possible.
8. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.

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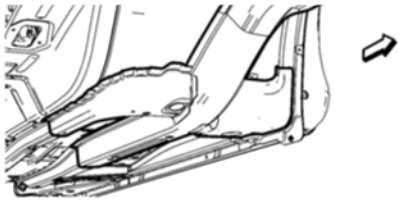




9. Click here for full size
10. Locate and mark all the necessary factory welds and weld seams of the front compartment side rail.



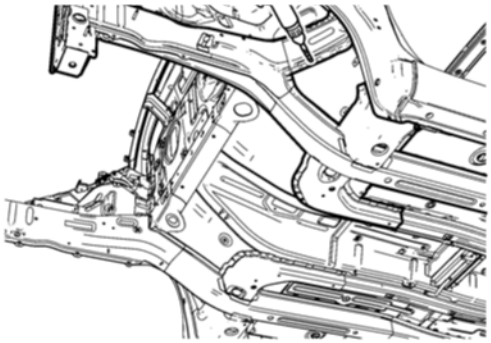
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11. Click here for full size
12. Locate and mark all the necessary factory welds and weld seams of the front compartment side rail.



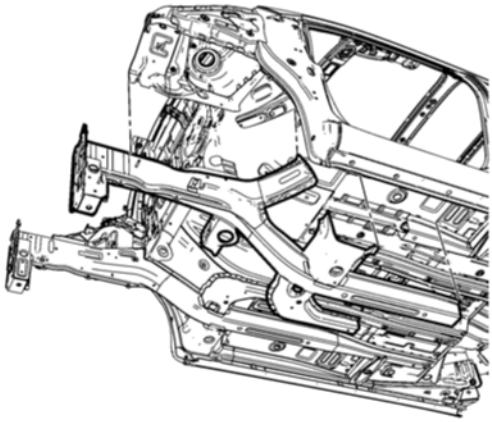
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13. Click here for full size

14. Locate and mark all the necessary factory welds and weld seams of the front compartment side rail.

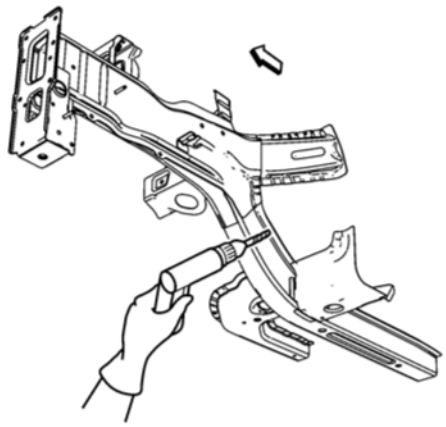
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15. Click here for full size
16. Remove the front compartment side rail wheelhouse panel.

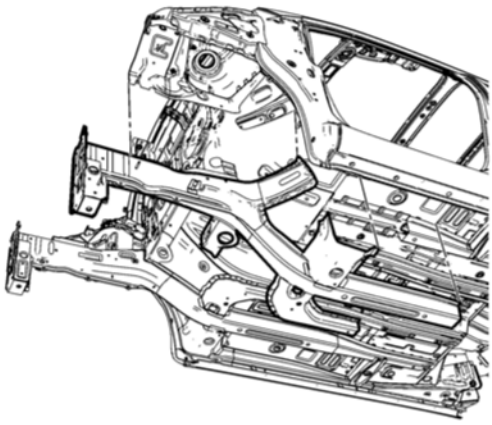
Installation Procedure

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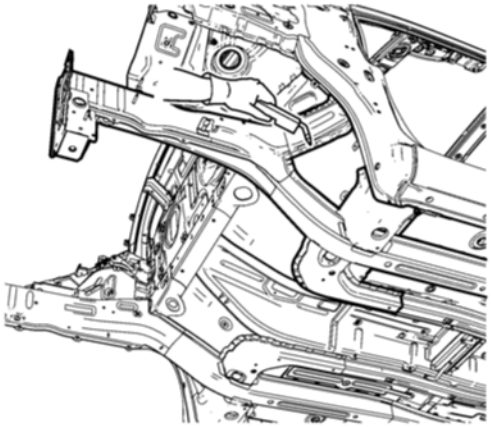
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1. Click here for full size
2. Drill 8â€‰mm (5/16â€‰in) for plug welding along the edges of the front compartment side rail as noted from the original panel.
3. Clean and prepare the attaching surfaces for welding.



4. Click here for full size
5. Position the front compartment side rail on the vehicle.
6. Verify the fit of the front compartment side rail on the vehicle.
7. Clamp the front compartment side rail into position.

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8. Click here for full size
9. Plug the weld accordingly.
10. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.

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11. Paint the repaired area. Refer to Basecoat/Clearcoat Paint Systems.
12. Install all the related panels and components.
13. Connect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.
14. Enable the SIR system. Refer to SIR Disabling and Enabling.

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1. **BODY REPAIR**
2. COLLISION REPAIR
3. REPAIR INSTRUCTIONS
4.

Front Wheelhouse Panel Replacement

Removal Procedure

1. Warning**:**

   Refer to Approved Equipment for Collision Repair Warning.

2. Warning**:**

   Refer to Glass and Sheet Metal Handling Warning.

3. Disable the SIR system. Refer to SIR Disabling and Enabling.

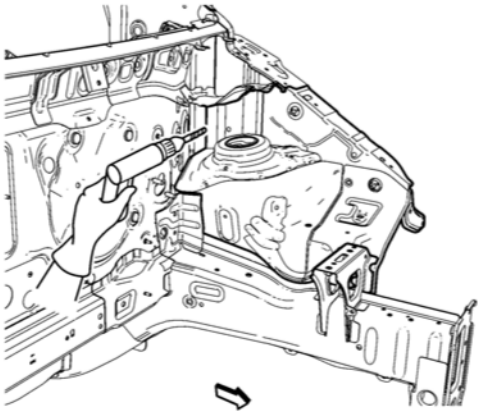
4. Disconnect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.

5. Remove all related panels and components.

6. Visually inspect the damage. Repair as much of the damage as possible.

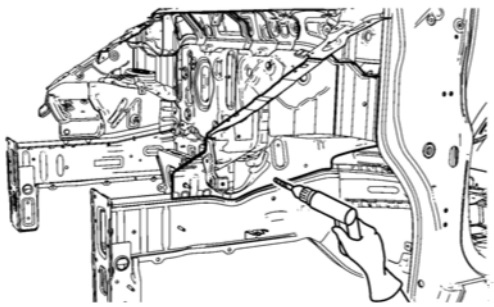
7. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.

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8. Click here for full size

9. Locate and mark all the necessary factory welds and weld seams of the front wheelhouse panel.



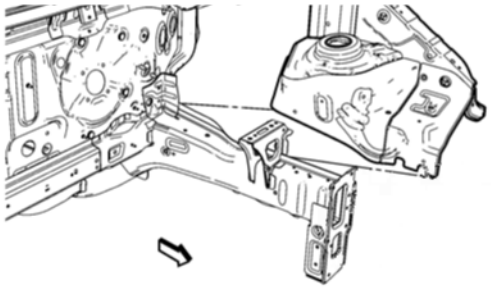
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10. Click here for full size
11. Drill all factory welds. Note the number and location of welds for installation of the service assembly.
12. Cut the adhesive in the front area and where the front wheelhouse and the front compartment side rail overlap with an appropriate tool.

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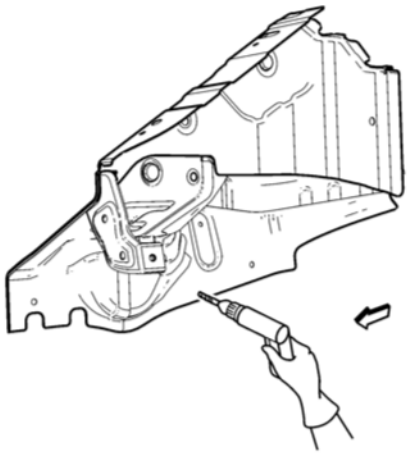




13. Click here for full size
14. Remove the front wheelhouse panel.

Installation Procedure

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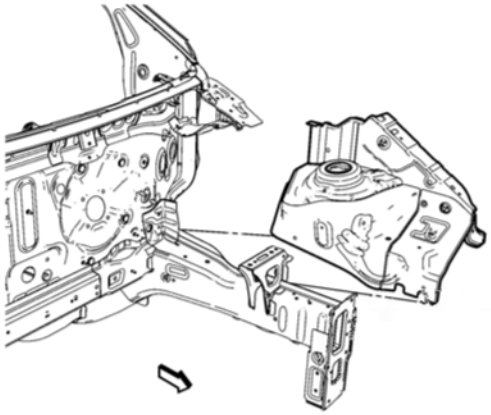
1. Click here for full size
2. Note**:**

   Double the number of drills at the flange where the front wheelhouse panel and front compartment side rail overlap.

3. Drill 8â€‰mm (5/16â€‰in) for plug welding along the edges of the wheelhouse panel as noted from the original panel.

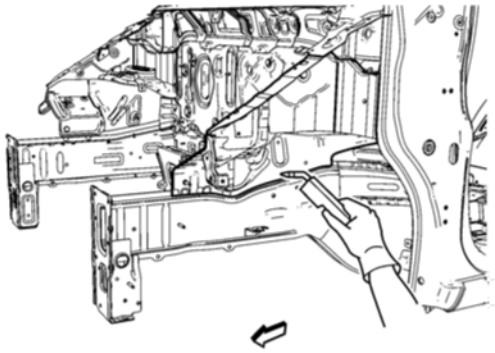
4. Clean and prepare the attaching surfaces for welding.

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5. Click here for full size
6. Position the wheelhouse panel on the vehicle.
7. Verify the fit of the wheelhouse panel on the vehicle.
8. Clamp the wheelhouse panel into position.

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9. Click here for full size
10. Plug weld accordingly.
11. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.
12. Paint the repaired area. Refer to Basecoat/Clearcoat Paint Systems.

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13. Install all related panels and components.
14. Connect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.
15. Enable the SIR system. Refer to SIR Disabling and Enabling.

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1. **BODY REPAIR**
2. COLLISION REPAIR
3. REPAIR INSTRUCTIONS
4.

Front Compartment Upper Side Rail Replacement

Removal Procedure

1. Warning**:**

   Refer to Approved Equipment for Collision Repair Warning.

2. Warning**:**

   Refer to Glass and Sheet Metal Handling Warning.

3. Disable the SIR System. Refer to SIR Disabling and Enabling.

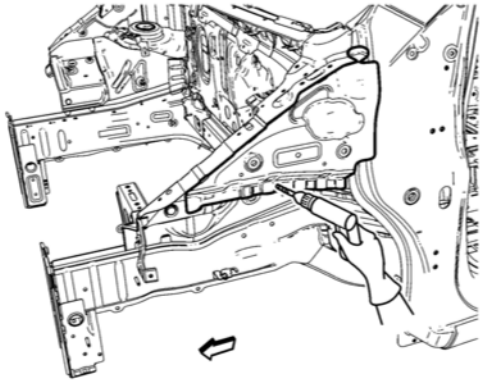
4. Disconnect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.

5. Remove all related panels and components.

6. Visually inspect the damage. Repair as much of the damage as possible.

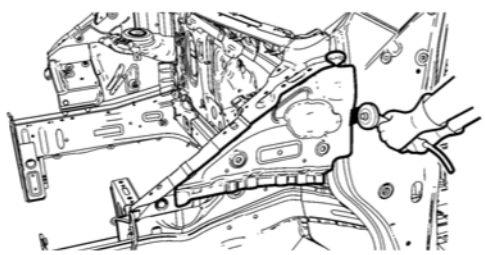
7. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.

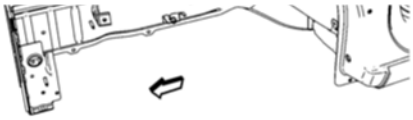
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8. Click here for full size
9. Locate and mark all the necessary factory welds and weld seams of the front compartment upper side rail.
10. Drill all factory welds. Note the number and location of welds for installation of the service assembly.

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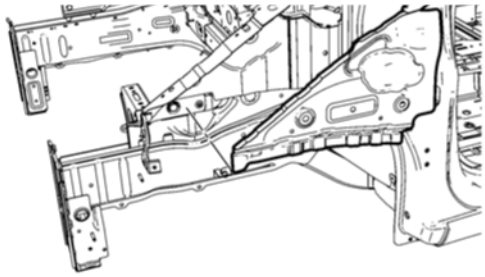




11. Click here for full size
12. Grind factory weld seams.

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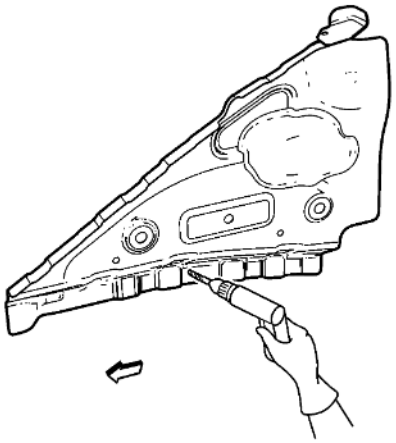




13. Click here for full size
14. Remove the front compartment upper side rail.

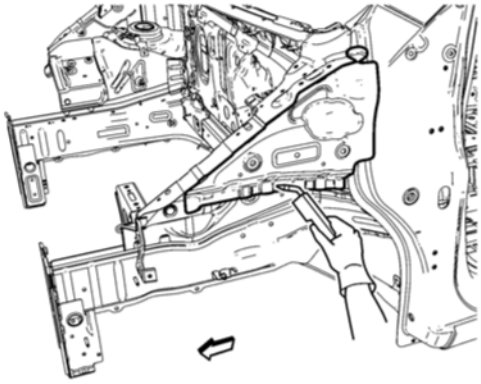
Installation Procedure

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1. Click here for full size
2. Drill 8 mm (516 in) for plug welding along the edges of the front compartment upper side rail as noted from the original panel.
3. Clean and prepare the attaching surfaces for welding.
4. Position the front compartment upper side rail on the vehicle.
5. Verify the fit of the front compartment upper side rail.
6. Clamp the front compartment upper side rail into position.

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7. Click here for full size
8. Note:

   Plug weld factory slots in the front hinge pillar body area (1) as noted from the original panel.

9. Plug weld accordingly.
10. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.
11. Paint the repaired area. Refer to Basecoat/Clearcoat Paint Systems.
12. Install all related panels and components.

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13. Connect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.
14. Enable the SIR system. Refer to SIR Disabling and Enabling.

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1. **BODY REPAIR**
2. COLLISION REPAIR
3. REPAIR INSTRUCTIONS
4.

Front Hinge Pillar Body Sectioning

Removal Procedure

1. Warning**:**

   Refer to Approved Equipment for Collision Repair Warning.

2. Warning**:**

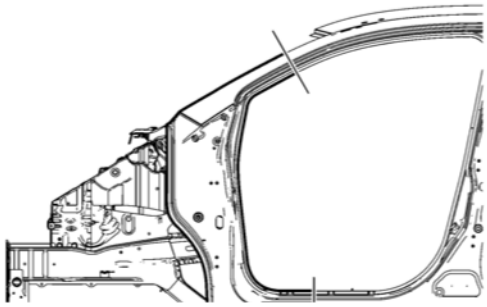
   Refer to Collision Sectioning Warning.

3. Warning**:**

   Refer to Glass and Sheet Metal Handling Warning.

4. Disable the SIR system. Refer to SIR Disabling and Enabling.
5. Disconnect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.
6. Remove all the related panels and components.
7. Visually inspect the damage. Repair as much of the damage as possible.
8. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.

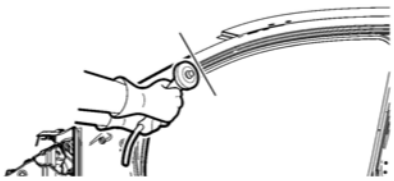
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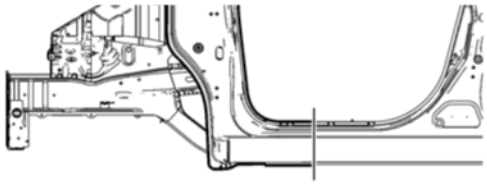


9. Click here for full size

10. Create cut lines on the front hinge pillar body.



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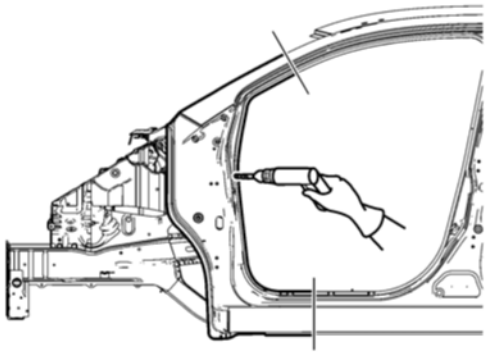


11. [Click here for full size]
12. Note:

    Do not damage any inner panels or reinforcements.

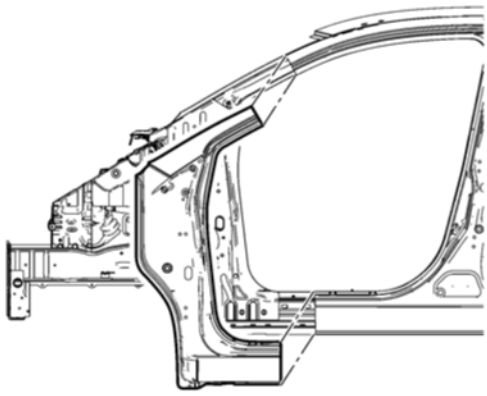
13. Cut the panel where sectioning is to be performed.

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14. Click here for full size
15. Locate and mark all the necessary factory welds of the front hinge pillar body.
16. Drill all the factory welds. Note the number and location of welds for installation of the service assembly.

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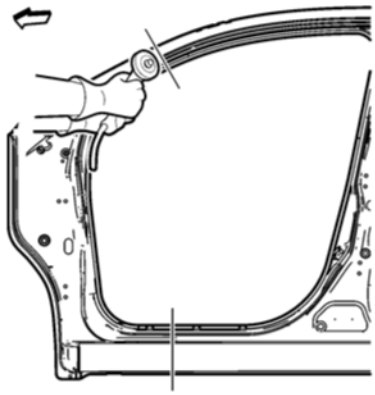


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17. Click here for full size

18. Remove the damaged front hinge pillar body.

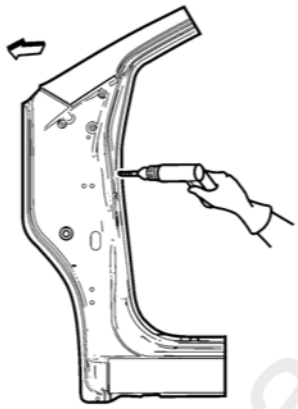
Installation Procedure



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1. Click here for full size
2. Cut the front hinge pillar body in corresponding locations to fit the remaining original panel. The sectioning joint should be trimmed to allow a gap of one-and-one-half-times the metal thickness at the sectioning joint.
3. Create a 50â€‰mm (2â€‰in) backing plate from the unused portion of the service part.
4. Drill 8â€‰mm (5/16â€‰in) along the sectioning cut on the remaining original part. Locate these holes 13â€‰mm (1/2â€‰in) from the edge of part and spaced 40â€‰mm (11/2â€‰in) apart.
5. Prepare all mating surfaces as necessary.
6. Fit the backing plates halfway into the sectioning joints, clamp in place and plug weld to the vehicle.

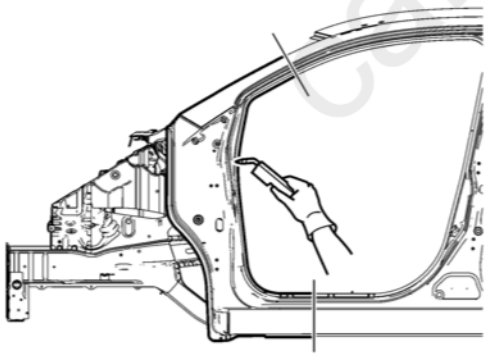
7. Align the front hinge pillar body.



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8. Click here for full size
9. Drill 8â€‰mm (5/16â€‰in) for plug welding along the edges of the front hinge pillar body as noted from the original panel.
10. Clean and prepare the attaching surfaces for welding.
11. Position the front hinge pillar body on the vehicle.
12. Verify the fit of the front hinge pillar body.
13. Clamp the front hinge pillar body into position.

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14. Click here for full size

15. Plug the weld accordingly.

16. To create a solid weld with minimum heat distortion, make 25â€‰mm (1â€‰in) stitch welds along the seam with 25â€‰mm (1â€‰in) gaps between them. Then go back and complete the stitch weld.

17. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.

18. Paint the repaired area. Refer to Basecoat/Clearcoat Paint Systems.

19. Install all the related panels and components.

20. Connect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.

21. Enable the SIR system. Refer to SIR Disabling and Enabling.

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1. BODY REPAIR
2. COLLISION REPAIR
3. REPAIR INSTRUCTIONS
4.

Body Hinge Pillar Lower Reinforcement Replacement

Removal Procedure

1. Warning:

   Refer to Approved Equipment for Collision Repair Warning.

2. Warning:

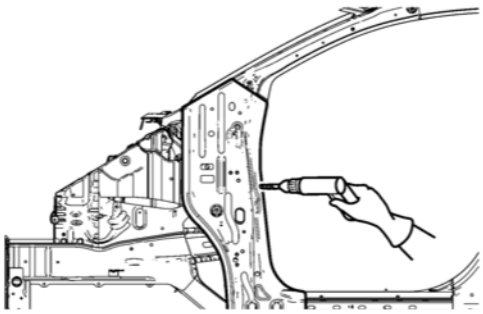
   Refer to Collision Sectioning Warning.

3. Warning:

   Refer to Glass and Sheet Metal Handling Warning.

4. Disable the SIR system. Refer to SIR Disabling and Enabling.
5. Disconnect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.
6. Remove all related panels and components.
7. Visually inspect the damage. Repair as much of the damage as possible.
8. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.

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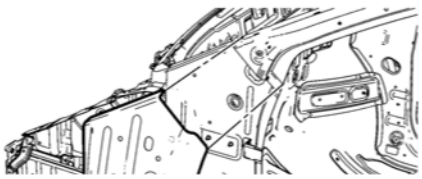


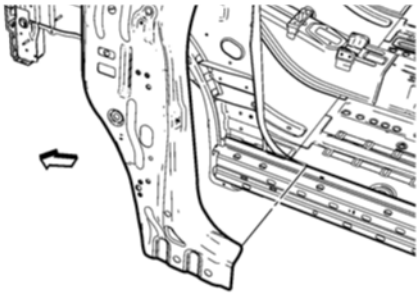
9. [Click here for full size]

10. Locate and mark all the necessary factory welds and weld seams of the front hinge pillar body.

11. Drill all factory welds. Note the number and location of welds for installation of the service assembly.

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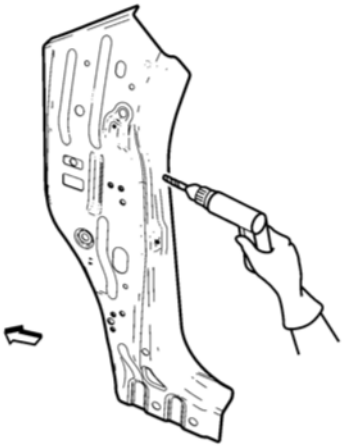


12. Click here for full size
13. Remove the damaged front hinge pillar body reinforcement.

Installation Procedure

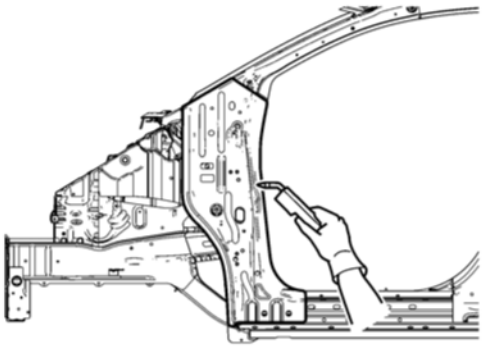
1. Prepare all mating surfaces as necessary.
2. Align the front hinge pillar body reinforcement.

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3. Click here for full size
4. Drill 8â€‰mm (5/16â€‰in) for plug welding along the edges of the front hinge pillar body as noted from the original panel.
5. Clean and prepare the attaching surfaces for welding.
6. Position the front hinge pillar body reinforcement on the vehicle.
7. Verify the fit of the front hinge pillar body reinforcement.
8. Clamp the front hinge pillar body reinforcement into position.



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9. Click here for full size
10. Plug weld accordingly.
11. To create a solid weld with minimum heat distortion, make 25â€‰mm (1â€‰in) stitch welds along the seam with 25â€‰mm (1â€‰in) gaps between them. Then go back and complete the stitch weld.
12. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.
13. Paint the repaired area. Refer to Basecoat/Clearcoat Paint Systems.

14. Install all related panels and components.
15. Connect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.
16. Enable the SIR system. Refer to SIR Disabling and Enabling.

Related Part Information

Part Name	Catalog Name	Part Code
Body Hinge Pillar Lower Reinforcement	REINFORCEMENT,BODY H/PLR LWR	1110A
Body Hinge Pillar Lower Reinforcement	REINFORCEMENT,BODY H/PLR LWR	1110B

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1. **BODY REPAIR**
2. COLLISION REPAIR
3. REPAIR INSTRUCTIONS
4.

Roof Outer Panel Replacement

Removal Procedure

1. Warning**:**

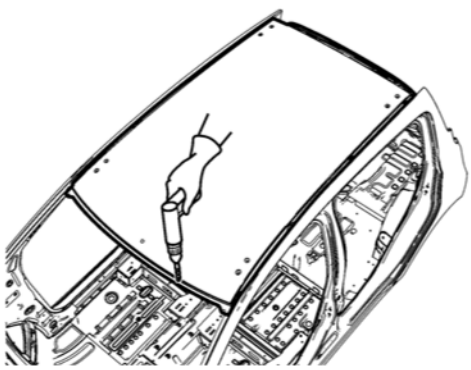
   Refer to Approved Equipment for Collision Repair Warning.

2. Warning**:**

   Refer to Glass and Sheet Metal Handling Warning.

3. Disable the SIR system. Refer to SIR Disabling and Enabling.
4. Disconnect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.
5. Remove all related panels and components.
6. Visually inspect the damage. Repair as much of the damage as possible.
7. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.
8. Locate and mark all factory welds.

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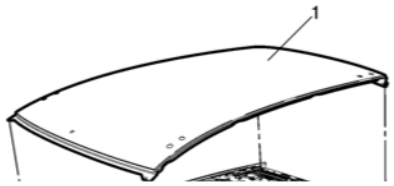


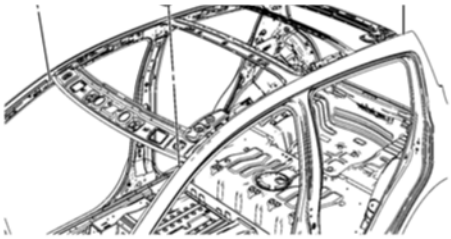
9. Click here for full size

10. Drill all factory welds. Note the number and location of welds for installation of the service assembly.

11. Cut the adhesive with an appropriate tool.

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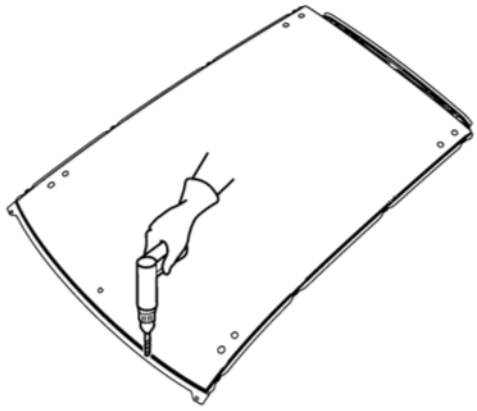




12. Click here for full size
13. Remove the damaged roof panelâ€‰(1).

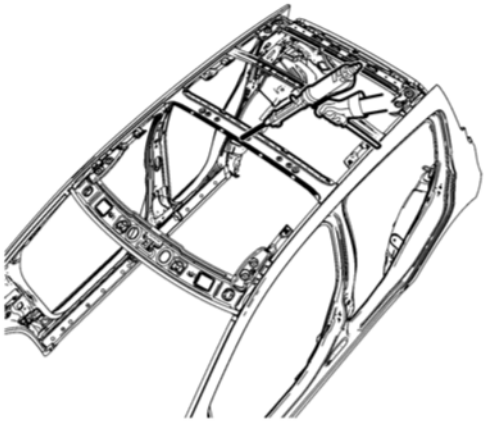
Installation Procedure

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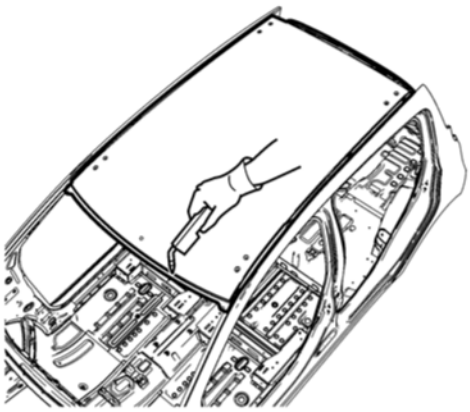
1. Click here for full size
2. Drill 8â€‰mm (5/16â€‰in) for plug welding along the edges of the service panel as noted from the original panel.
3. Clean and prepare the attaching surfaces for welding.

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4. Click here for full size
5. Apply one-part windshield urethane adhesive as noted from the original panel.
6. Position the roof panel on the vehicle.
7. Verify the fit of the panel.
8. Clamp the panel into position.

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9. Click here for full size
10. Plug weld accordingly.
11. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.
12. Paint the repaired area. Refer to Basecoat/Clearcoat Paint Systems.
13. Install all related panels and components.
14. Connect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.

15. Enable the SIR system. Refer to SIR Disabling and Enabling.

Related Part Information

Part Name	Catalog Name	Part Code
Roof Outer Panel	PANEL,RF OTR	1500A
Roof Outer Panel	PANEL,RF OTR	1550A
Roof Outer Panel	PANEL,RF OTR (BLANK)	1550B
Roof Outer Panel	PANEL,RF OTR	SS121

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1. **BODY REPAIR**
2. COLLISION REPAIR
3. REPAIR INSTRUCTIONS
4.

Roof Front Header Panel Replacement

Removal Procedure

1. Warning**:**

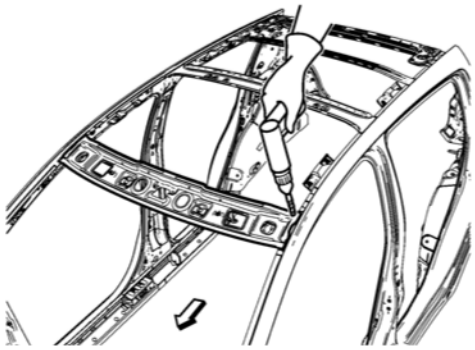
   Refer to Approved Equipment for Collision Repair Warning.

2. Warning**:**

   Refer to Glass and Sheet Metal Handling Warning.

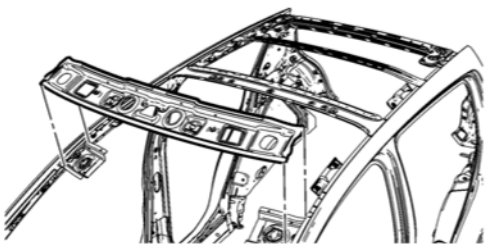
3. Disable the SIR system. Refer to SIR Disabling and Enabling.
4. Disconnect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.
5. Remove all related panels and components.
6. Visually inspect the damage. Repair as much of the damage as possible.
7. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.
8. Locate and mark all factory welds.

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9. Click here for full size

10. Drill all factory welds. Note the number and location of welds for installation of the service assembly.



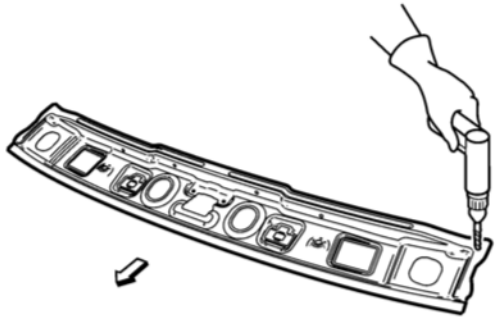
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11. Click here for full size
12. Remove the damaged roof front header panel.

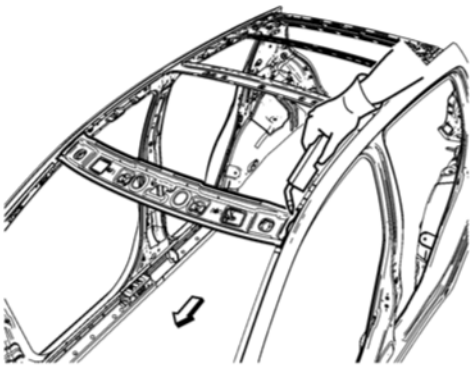
Installation Procedure

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1. Click here for full size
2. Drill 8â€‰mm (5/16â€‰in) for plug welding along the edges of the service panel as noted from the original panel.
3. Clean and prepare the attaching surfaces for welding.
4. Position the roof front header panel.
5. Verify the fit of the panel.
6. Clamp the panel into position.

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7. Click here for full size
8. Plug weld accordingly.
9. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.
10. Paint the repaired area. Refer to Basecoat/Clearcoat Paint Systems.
11. Install all related panels and components.
12. Connect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.
13. Enable the SIR system. Refer to SIR Disabling and Enabling.

Related Part Information

Part Name	Catalog Name	Part Code

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Part Name	Catalog Name	Part Code
Roof Front Header Panel	PANEL,RF FRT HDR	1849Z
Roof Front Header Panel	PANEL,RF FRT HDR	1850A
Roof Front Header Panel	PANEL,RF FRT HDR	0700A
Roof Front Header Panel	PANEL,RF FRT HDR	0700B

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1. **BODY REPAIR**
2. COLLISION REPAIR
3. REPAIR INSTRUCTIONS
4.

Roof Rear Header Panel Replacement

Removal Procedure

1. Warning**:**

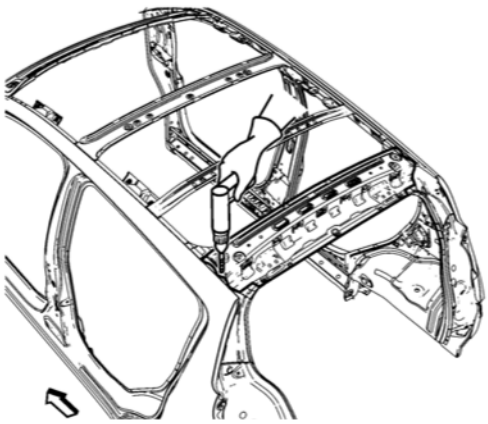
   Refer to Approved Equipment for Collision Repair Warning.

2. Warning**:**

   Refer to Glass and Sheet Metal Handling Warning.

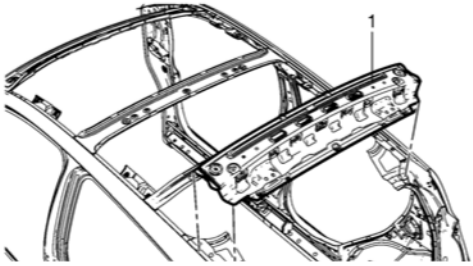
3. Disable the SIR system. Refer to SIR Disabling and Enabling.
4. Disconnect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.
5. Remove all related panels and components.
6. Visually inspect the damage. Repair as much of the damage as possible.
7. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.
8. Locate and mark all factory welds.

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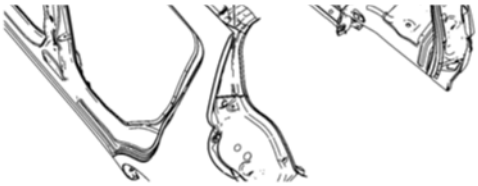


9. Click here for full size

10. Drill all factory welds. Note the number and location of welds for installation of the service assembly.



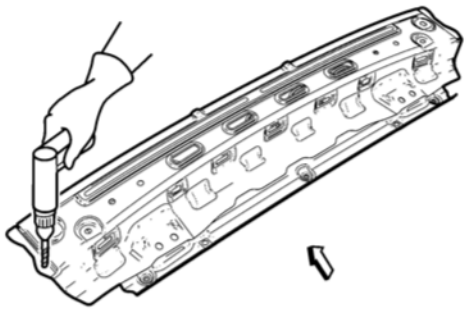
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11. Click here for full size
12. Remove the damaged rear header panelâ€‰(1).

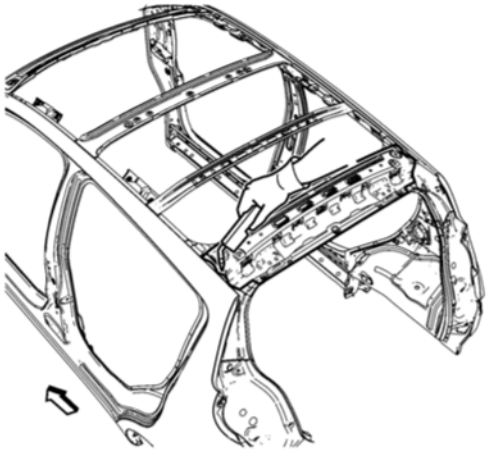
Installation Procedure

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1. Click here for full size
2. Drill 8â€‰mm (5/16â€‰in) for plug welding along the edges of the service panel as noted from the original panel.
3. Clean and prepare the attaching surfaces for welding.
4. Position the roof rear header panel.
5. Verify the fit of the panel.
6. Clamp the panel into position.

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7. Click here for full size
8. Plug weld accordingly.
9. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.
10. Paint the repaired area. Refer to Basecoat/Clearcoat Paint Systems.
11. Install all related panels and components.
12. Connect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.
13. Enable the SIR system. Refer to SIR Disabling and Enabling.

Related Part Information

Part Name	Catalog Name	Part Code

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Part Name	Catalog Name	Part Code
Roof Rear Header Panel	PANEL,RF RR HDR	2200A
Roof Rear Header Panel	PANEL,RF RR HDR	2250A
Roof Rear Header Panel	PANEL,RF RR HDR	1300A
Roof Rear Header Panel	PANEL,RF RR HDR	1300B

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1. **BODY REPAIR**
2. COLLISION REPAIR
3. REPAIR INSTRUCTIONS
4.

Rocker Inner Panel Replacement

Removal Procedure

1. Warning**:**

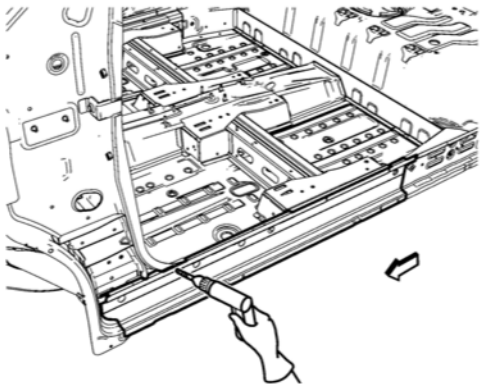
   Refer to Approved Equipment for Collision Repair Warning.

2. Warning**:**

   Refer to Glass and Sheet Metal Handling Warning.

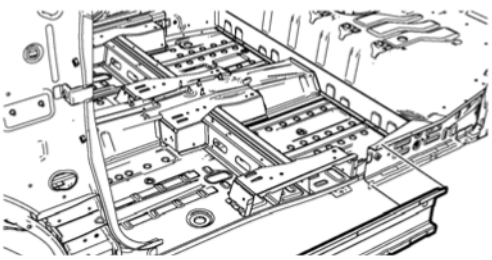
3. Disable the SIR system. Refer to SIR Disabling and Enabling.
4. Disconnect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.
5. Remove all related panels and components.
6. Visually inspect the damage. Repair as much of the damage as possible.
7. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.
8. Locate and mark all factory welds.

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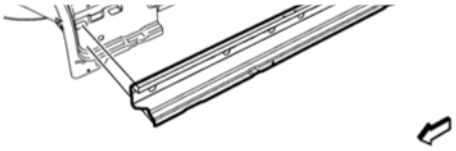


9. Click here for full size

10. Drill all factory welds. Note the number and location of welds for installation of the service assembly.



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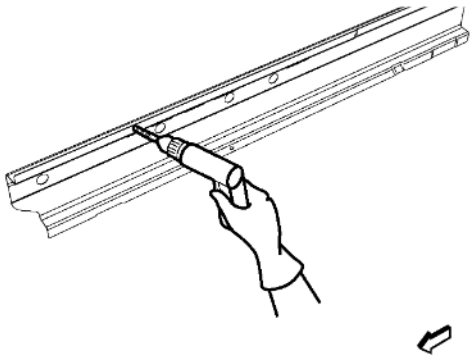


11. Click here for full size
12. Remove the damaged rocker inner panel.

Installation Procedure

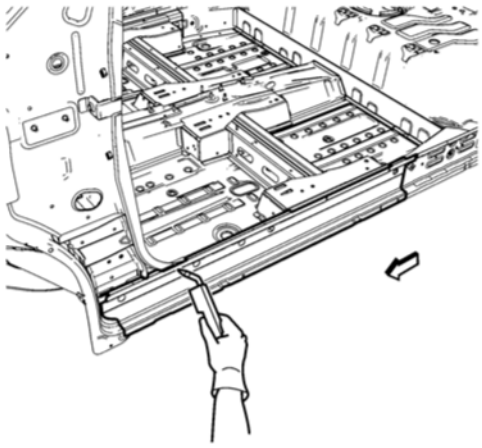
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1. Click here for full size
2. Drill 8â€‰mm (5/16â€‰in) for plug welding along the edges of the service panel as noted from the original panel.
3. Clean and prepare the attaching surfaces for welding.
4. Position the rocker inner panel.
5. Verify the fit of the panel.
6. Clamp the panel into position.

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7. Click here for full size
8. Plug the weld accordingly.
9. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.
10. Paint the repaired area. Refer to Basecoat/Clearcoat Paint Systems.
11. Install all related panels and components.
12. Connect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.
13. Enable the SIR system. Refer to SIR Disabling and Enabling.

Related Part Information

Part Name	Catalog Name	Part Code

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Part Name	Catalog Name	Part Code
Rocker Inner Panel	PANEL,RKR INR	3199C
Rocker Inner Panel	PANEL,RKR INR	3200A
Rocker Inner Panel	PANEL KIT,RKR INR	3109Z
Rocker Inner Panel	PANEL,RKR INR	3110A
Rocker Inner Panel	PANEL,RKR INR	3110B
Rocker Inner Panel	PANEL,RKR INR (BLANK)	3110C

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1. **BODY REPAIR**
2. COLLISION REPAIR
3. REPAIR INSTRUCTIONS
4.

Body Lock Pillar Outer Panel Sectioning

Removal Procedure

1. Warning**:**

   Refer to Approved Equipment for Collision Repair Warning

2. Warning**:**

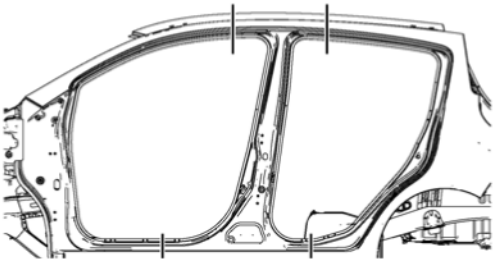
   Refer to Collision Sectioning Warning

3. Warning**:**

   Refer to Glass and Sheet Metal Handling Warning

4. Disable the SIR system. Refer to SIR Disabling and Enabling.
5. Disconnect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.
6. Remove all related panels and components.
7. Visually inspect the damage. Repair as much of the damage as possible.
8. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.

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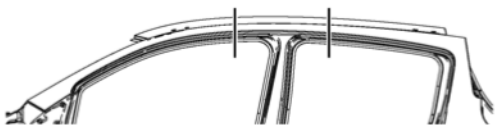


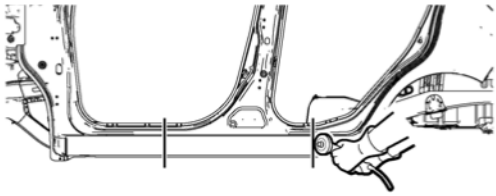


9. Click here for full size

10. Create cut lines on the body lock pillar outer panel.

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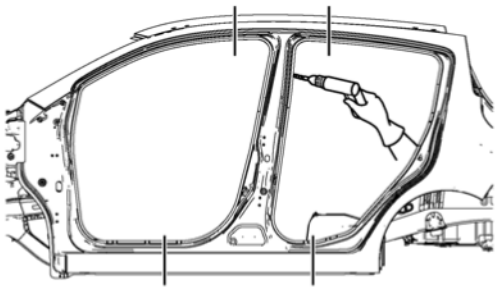


11. Click here for full size
12. Note:

    Do not damage any inner panels or reinforcements.

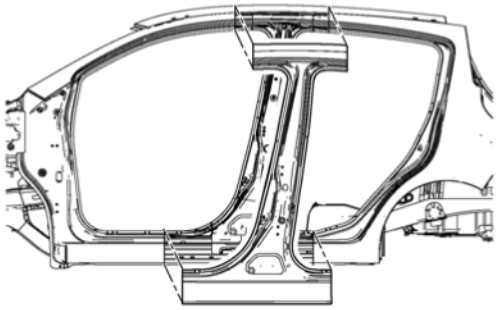
13. Cut the panel where sectioning is to be performed.

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14. Click here for full size
15. Locate and mark all the necessary factory welds of the body lock pillar outer panel.
16. Drill all factory welds. Note the number and location of welds for installation of the service assembly.

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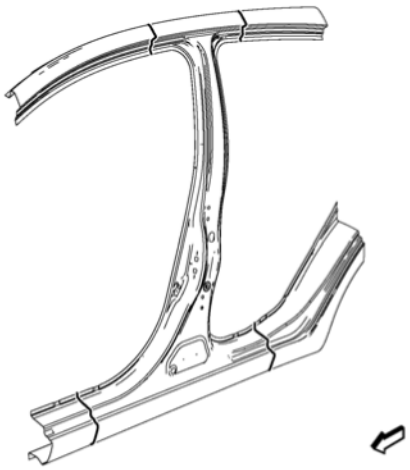


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17. Click here for full size

18. Remove the damaged body lock pillar outer panel.

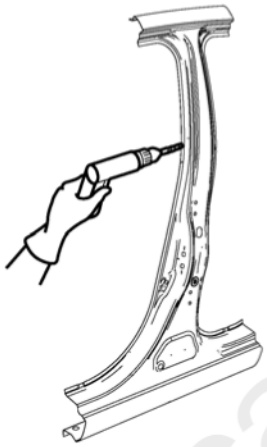
Installation Procedure



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1. Click here for full size
2. Cut the body lock pillar outer panel in corresponding locations to fit the remaining original panel. The sectioning joint should be trimmed to allow a gap of one-and-one-half-times the metal thickness at the sectioning joint.
3. Create a 50â€‰mm (2â€‰in) backing plate from the unused portion of the service part.
4. Drill a 8â€‰mm (5/16â€‰in) along the sectioning cut on the remaining original part. Locate these holes 13â€‰mm (1/2â€‰in) from the edge of part and spaced 40â€‰mm (1â€‰1/2â€‰in) apart.
5. Prepare all mating surfaces as necessary.
6. Fit the backing plates halfway into the sectioning joints, clamp in place and plug weld to the vehicle.

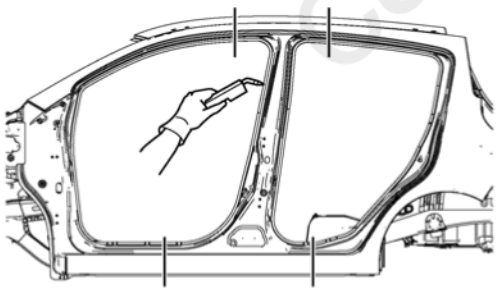
7. Align the body lock pillar outer panel.



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8. Click here for full size
9. Drill a 8â€‰mm (5/16â€‰in) for plug welding along the edges of the body lock pillar outer panel as noted from the original panel.
10. Clean and prepare the attaching surfaces for welding.
11. Position the body lock pillar outer panel on the vehicle.
12. Verify the fit of the body lock pillar outer panel.
13. Clamp the body lock pillar outer panel into position.

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14. Click here for full size

15. Plug the weld accordingly.

16. To create a solid weld with minimum heat distortion, make a 25â€‰mm (1â€‰in) stitch welds along the seam with 25â€‰mm (1â€‰in) gaps between them. Then go back and complete the stitch weld.

17. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.

18. Paint the repaired area. Refer to Basecoat/Clearcoat Paint Systems.

19. Install all related panels and components.

20. Connect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.

21. Enable the SIR system. Refer to SIR Disabling and Enabling.

Related Part Information

Part Name	Catalog Name	Part Code
Body Lock Pillar Outer Panel	PANEL,BODY L/PLR OTR	9035A
Body Lock Pillar Outer Panel	PANEL,BODY L/PLR OTR	9035B
Body Lock Pillar Outer Panel	PANEL KIT,BODY L/PLR OTR	1698A
Body Lock Pillar Outer Panel	PANEL,BODY L/PLR OTR	1700A
Body Lock Pillar Outer Panel	PANEL,BODY L/PLR OTR	1700B

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1. **BODY REPAIR**
2. COLLISION REPAIR
3. REPAIR INSTRUCTIONS
4.

Body Lock Pillar Outer Panel Reinforcement Replacement

Removal Procedure

1. Warning**:**

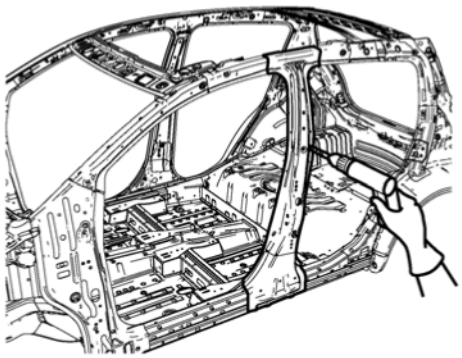
   Refer to Approved Equipment for Collision Repair Warning.

2. Warning**:**

   Refer to Glass and Sheet Metal Handling Warning.

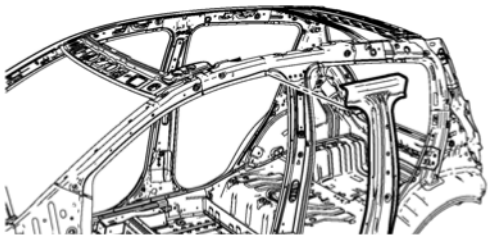
3. Disable the SIR system. Refer to SIR Disabling and Enabling.
4. Disconnect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.
5. Remove all related panels and components.
6. Visually inspect the damage. Repair as much of the damage as possible.
7. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.

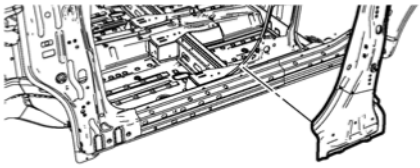
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8. Click here for full size
9. Locate and mark all the necessary factory welds of the body lock pillar outer panel reinforcement.
10. Drill all factory welds. Note the number and location of welds for installation of the service assembly.

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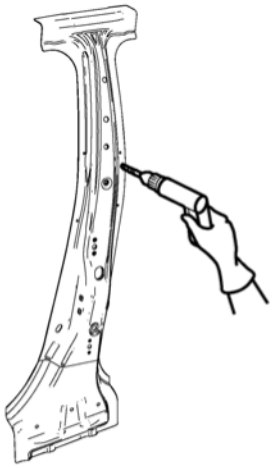


11. Click here for full size
12. Remove the damaged body lock pillar outer panel reinforcement.

Installation Procedure

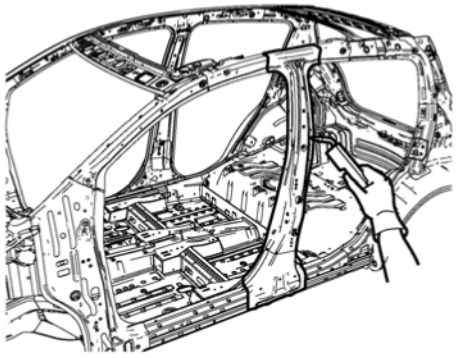
1. Prepare all mating surfaces as necessary.
2. Align the body lock pillar outer panel reinforcement.

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3. Click here for full size
4. Drill a 8â€‰mm (5/16â€‰in) for plug welding along the edges of the body lock pillar outer panel reinforcement as noted from the original panel.
5. Clean and prepare the attaching surfaces for welding.
6. Position the body lock pillar outer panel reinforcement on the vehicle.
7. Verify the fit of the body lock pillar outer panel reinforcement.
8. Clamp the body lock pillar outer panel reinforcement into position.

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9. Click here for full size
10. Plug the weld accordingly.
11. To create a solid weld with minimum heat distortion, make a 25â€‰mm (1â€‰in) stitch welds along the seam with a 25â€‰mm (1â€‰in) gaps between them. Then go back and complete the stitch weld.
12. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.
13. Paint the repaired area. Refer to Basecoat/Clearcoat Paint Systems.

14. Install all related panels and components.
15. Connect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.
16. Enable the SIR system. Refer to SIR Disabling and Enabling.

Related Part Information

Part Name	Catalog Name	Part Code
Body Lock Pillar Outer Panel Reinforcement	REINFORCEMENT,BODY L/PLR OTR PNL	1725A

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1. **BODY REPAIR**
2. COLLISION REPAIR
3. REPAIR INSTRUCTIONS
4.

Body Lock Pillar Inner Panel Replacement

Removal Procedure

1. Warning**:**

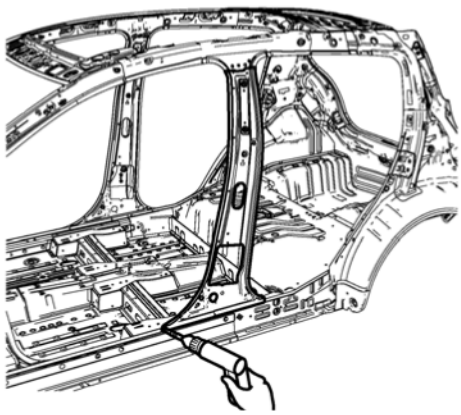
   Refer to Approved Equipment for Collision Repair Warning.

2. Warning**:**

   Refer to Glass and Sheet Metal Handling Warning.

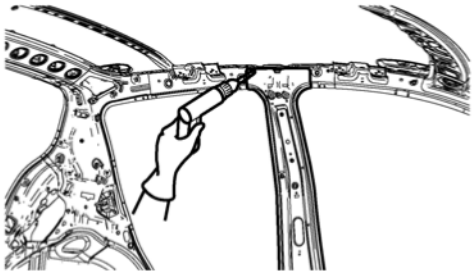
3. Disable the SIR system. Refer to SIR Disabling and Enabling.
4. Disconnect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.
5. Remove all related panels and components.
6. Visually inspect the damage. Repair as much of the damage as possible.
7. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.
8. Locate and mark all factory welds.

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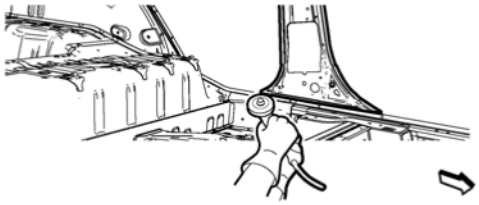


9. Click here for full size

10. Drill all factory lower welds . Note the number and location of welds for installation of the service assembly.



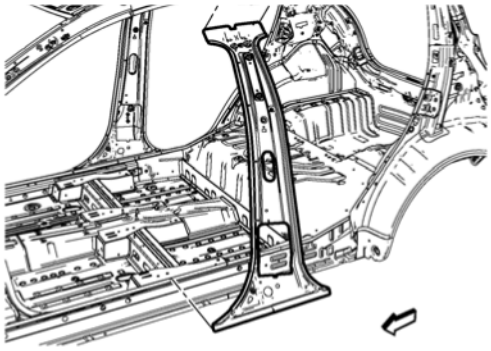
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11. Click here for full size
12. Drill all factory upper welds . Note the number and location of welds for installation of the service assembly.
13. Grind the factory weld seams lower.

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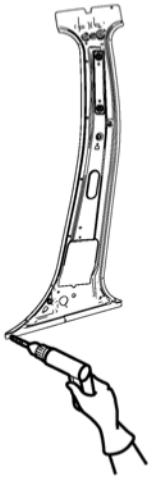




14. Click here for full size
15. Remove the damaged body lock pillar inner panel.

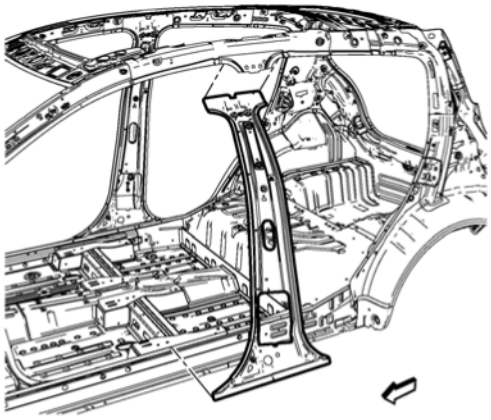
Installation Procedure

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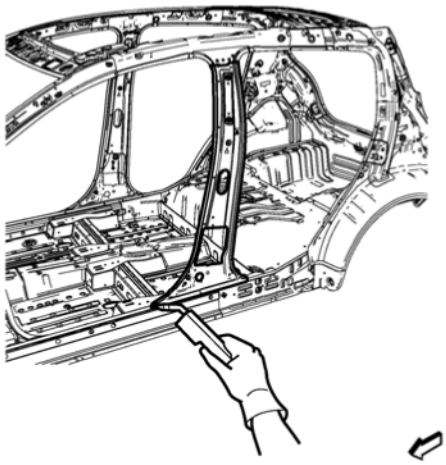
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1. Click here for full size
2. Drill a 8â€‰mm (5/16â€‰in) for plug welding along the edges of the service panel as noted from the original panel.
3. Clean and prepare the attaching surfaces for welding.



4. Click here for full size
5. Position the body lock pillar inner panel on the vehicle.
6. Verify the fit of the panel.
7. Clamp the body lock pillar inner panel into position.

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8. Click here for full size
9. Plug the weld accordingly body lock pillar inner panel upper and lower.
10. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.
11. Paint the repaired area. Refer to Basecoat/Clearcoat Paint Systems.

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12. Install all related panels and components.
13. Connect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.
14. Enable the SIR system. Refer to SIR Disabling and Enabling.

Related Part Information

Part Name	Catalog Name	Part Code
Body Lock Pillar Inner Panel	PANEL,BODY L/PLR INR	9024A
Body Lock Pillar Inner Panel	PANEL,BODY L/PLR INR	9024B
Body Lock Pillar Inner Panel	PANEL,BODY L/PLR INR	1500A
Body Lock Pillar Inner Panel	PANEL,BODY L/PLR INR	1500B

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1. **BODY REPAIR**
2. COLLISION REPAIR
3. REPAIR INSTRUCTIONS
4.

Rocker Outer Panel Sectioning

Removal Procedure

1. Warning**:**

   Refer to Approved Equipment for Collision Repair Warning.

2. Warning**:**

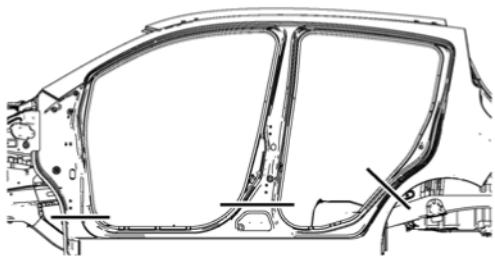
   Refer to Collision Sectioning Warning.

3. Warning**:**

   Refer to Glass and Sheet Metal Handling Warning.

4. Disable the SIR system. Refer to SIR Disabling and Enabling.
5. Disconnect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.
6. Remove all related panels and components.
7. Visually inspect the damage. Repair as much of the damage as possible.
8. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.

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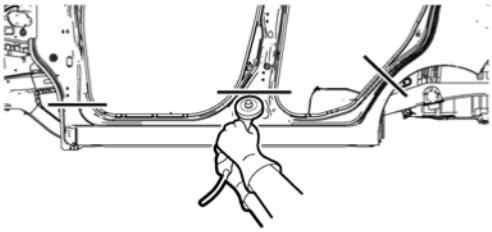


9. Click here for full size

10. Create cut lines on the rocker outer panel.

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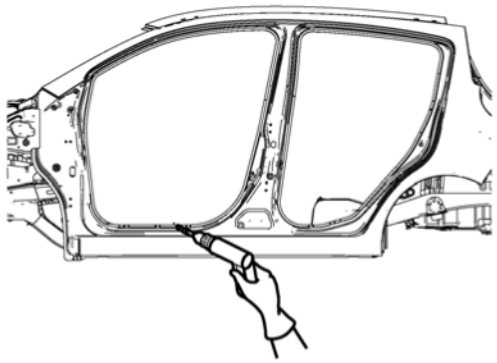


11. Click here for full size
12. Note:

    Do not damage any inner panels or reinforcements.

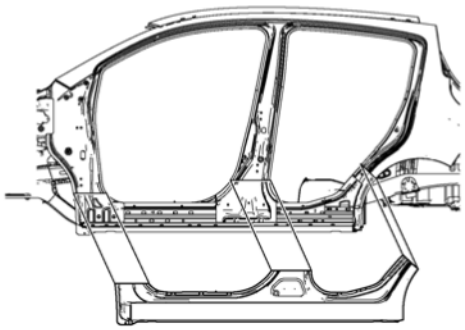
13. Cut the panel where sectioning is to be performed.

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14. Click here for full size
15. Locate and mark all the necessary factory welds of the rocker outer panel.
16. Drill all factory welds. Note the number and location of welds for installation of the service assembly.

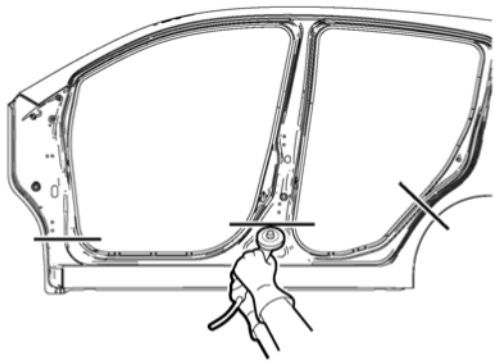
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17. Click here for full size
18. Remove the damaged rocker outer panel.

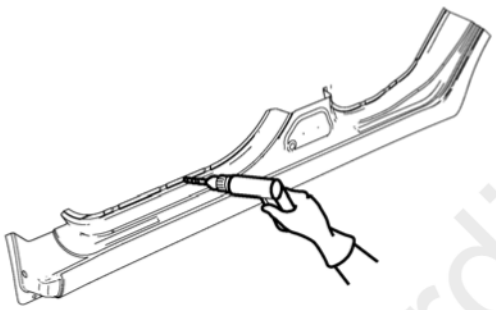
Installation Procedure



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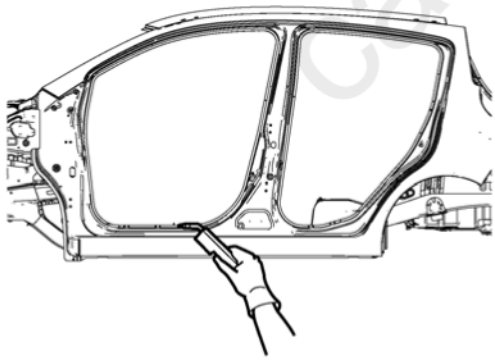
1. Click here for full size
2. Cut the rocker outer panel in corresponding locations to fit the remaining original panel. The sectioning joint should be trimmed to allow a gap of one-and-one-half-times the metal thickness at the sectioning joint.
3. Create a 50â€‰mm (2â€‰in) backing plate from the unused portion of the service part.
4. Drill a 8â€‰mm (5/16â€‰in) along the sectioning cut on the remaining original part. Locate these holes 13â€‰mm (1/2â€‰in) from the edge of part and spaced 40â€‰ mm (1â€‰1/2â€‰ in) apart.
5. Prepare all mating surfaces as necessary.
6. Fit the backing plates halfway into the sectioning joints, clamp in place and plug weld to the vehicle.

7. Align the rocker outer panel.



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8. Click here for full size
9. Drill a 8â€‰mm (5/16â€‰in) for plug welding along the edges of the rocker outer panel as noted from the original panel.
10. Clean and prepare the attaching surfaces for welding.
11. Position the rocker outer panel on the vehicle.
12. Verify the fit of the rocker outer panel.
13. Clamp the rocker outer panel into position.



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14.
    Click here for full size
15. Plug the weld accordingly.
16. To create a solid weld with minimum heat distortion, make a 25â€‰mm (1â€‰in) stitch weld along the seam with 25â€‰mm (1â€‰in) gaps between them. Then go back and complete the stitch weld.
17. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.
18. Paint the repaired area. Refer to Basecoat/Clearcoat Paint Systems.
19. Install all related panels and components.
20. Connect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.
21. Enable the SIR system. Refer to SIR Disabling and Enabling.

Related Part Information

Part Name	Catalog Name	Part Code
Rocker Outer Panel	PANEL,RKR OTR	3255A
Rocker Outer Panel	PANEL,RKR OTR	3255B
Rocker Outer Panel	PANEL KIT,RKR OTR	3129Z
Rocker Outer Panel	PANEL,RKR OTR	3130A
Rocker Outer Panel	PANEL,RKR OTR	3130B
Rocker Outer Panel	PANEL,RKR OTR	3118A
Rocker Outer Panel	PANEL,RKR OTR	3118B

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1. **BODY REPAIR**
2. COLLISION REPAIR
3. REPAIR INSTRUCTIONS
4.

Body Side Outer Panel Reinforcement Replacement

Removal Procedure

1. Warning**:**

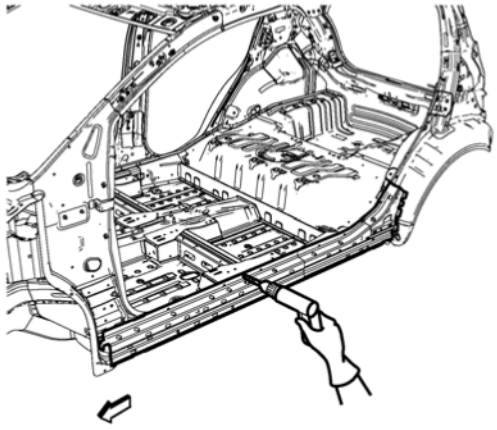
   Refer to Approved Equipment for Collision Repair Warning.

2. Warning**:**

   Refer to Glass and Sheet Metal Handling Warning.

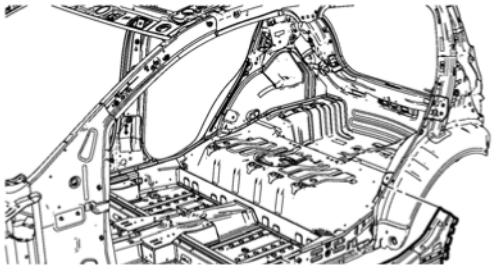
3. Disable the SIR system. Refer to SIR Disabling and Enabling.
4. Disconnect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.
5. Remove all related panels and components.
6. Visually inspect the damage. Repair as much of the damage as possible.
7. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.

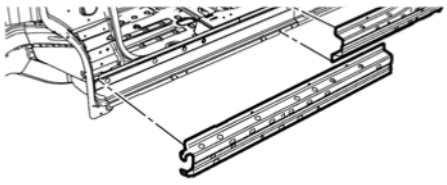
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8. Click here for full size
9. Locate and mark all the necessary factory welds of the body side outer panel reinforcement.
10. Drill all factory welds. Note the number and location of welds for installation of the service assembly.

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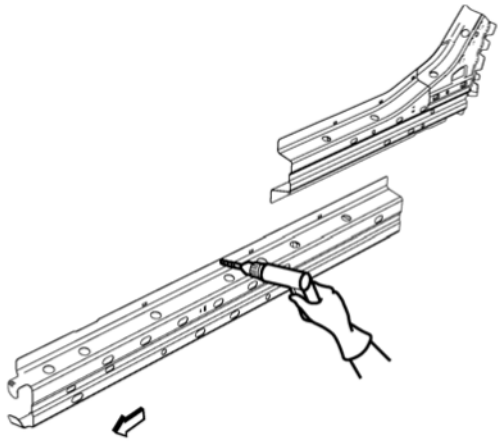


11. Click here for full size
12. Remove the damaged body side outer panel reinforcement.

Installation Procedure

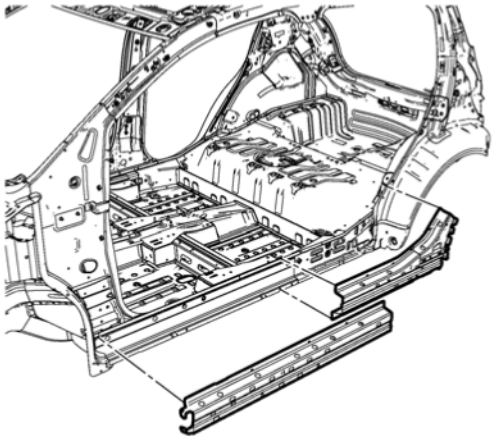
1. Align the body side outer panel reinforcement.

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2. Click here for full size
3. Drill a 8â€‰mm (5/16â€‰in) for plug welding along the edges of the body side outer panel reinforcement as noted from the original panel.
4. Clean and prepare the attaching surfaces for welding.

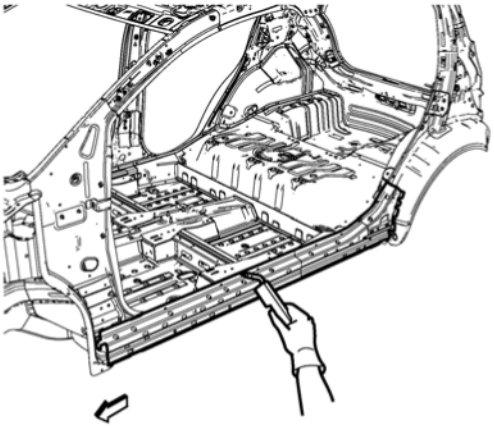
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5. [Click here for full size]

6. Position the body side outer panel reinforcement on the vehicle.
7. Verify the fit of the body side outer panel reinforcement.
8. Clamp the body side outer panel reinforcement into position.

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9. Click here for full size
10. Plug the weld accordingly.
11. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.
12. Paint the repaired area. Refer to Basecoat/Clearcoat Paint Systems.
13. Install all related panels and components.
14. Connect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.

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15. Enable the SIR system. Refer to SIR Disabling and Enabling.

Related Part Information

Part Name	Catalog Name	Part Code
Body Side Outer Panel Reinforcement	REINFORCEMENT,BODY SI OTR PNL	1825A
Body Side Outer Panel Reinforcement	REINFORCEMENT,BODY SI OTR PNL	1850A
Body Side Outer Panel Reinforcement	REINFORCEMENT,BODY SI OTR PNL	1955A
Body Side Outer Panel Reinforcement	REINFORCEMENT,BODY SI OTR PNL	1955B

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1. **BODY REPAIR**
2. COLLISION REPAIR
3. REPAIR INSTRUCTIONS
4.

Rear Compartment Floor Panel Replacement

Removal Procedure

1. Warning**:**

   Refer to Approved Equipment for Collision Repair Warning.

2. Warning**:**

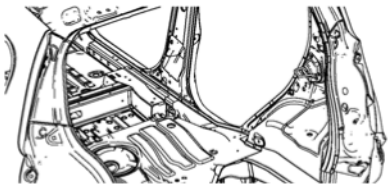
   Refer to Glass and Sheet Metal Handling Warning.

3. Disable the SIR system. Refer to SIR Disabling and Enabling.
4. Disconnect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.
5. Remove all related panels and components.
6. Visually inspect the damage. Repair as much of the damage as possible.
7. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.

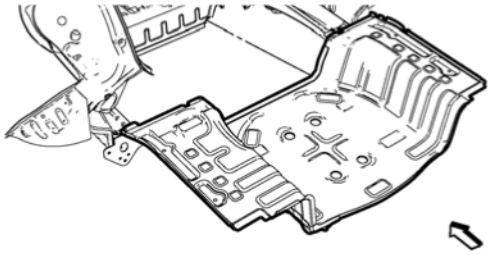
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8. Click here for full size
9. Locate and mark all the necessary factory welds of the rear compartment floor panel.
10. Note the number and location of weld studs for installation of the service assembly.
11. Drill all factory welds. Note the number and location of welds for installation of the service assembly.



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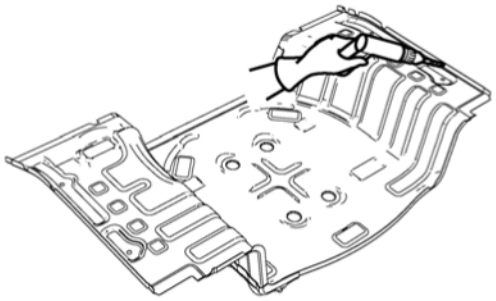


12. Click here for full size
13. Remove the damaged rear compartment floor panel.

Installation Procedure

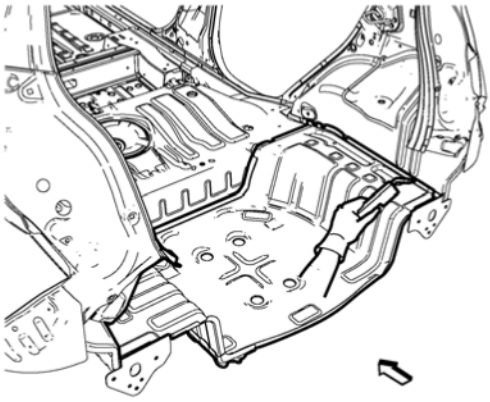
1. Align the rear compartment floor panel.

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2. Click here for full size
3. Drill a 8â€‰mm (5/16â€‰in) for plug welding along the edges of the rear compartment floor panel as noted from the original panel.
4. Clean and prepare the attaching surfaces for welding.
5. Position the rear compartment floor panel on the vehicle.
6. Verify the fit of the rear compartment floor panel.
7. Clamp the rear compartment floor panel into position.

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8. Click here for full size
9. Plug the weld accordingly.
10. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.
11. Paint the repaired area. Refer to Basecoat/Clearcoat Paint Systems.
12. Install all related panels and components.
13. Connect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.
14. Enable the SIR system. Refer to SIR Disabling and Enabling.

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1. **BODY REPAIR**
2. COLLISION REPAIR
3. REPAIR INSTRUCTIONS
4.

Quarter Outer Panel Sectioning

Special Tools

- *BO-6392* Flanging Tool Kit
- *BO-6396* Bonding Pliers

For equivalent regional tools, refer to Special Tools.

Removal Procedure

1. Warning:

   Refer to Approved Equipment for Collision Repair Warning.

2. Warning:

   Refer to Collision Sectioning Warning.

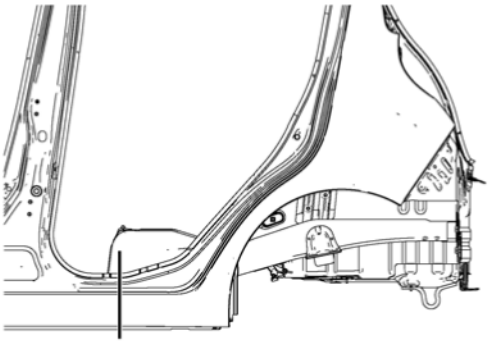
3. Warning:

   Refer to Glass and Sheet Metal Handling Warning.

4. Disable the SIR system. Refer to SIR Disabling and Enabling.
5. Disconnect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.
6. Remove all related panels and components.
7. Visually inspect the damage. Repair as much of the damage as possible.
8. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.

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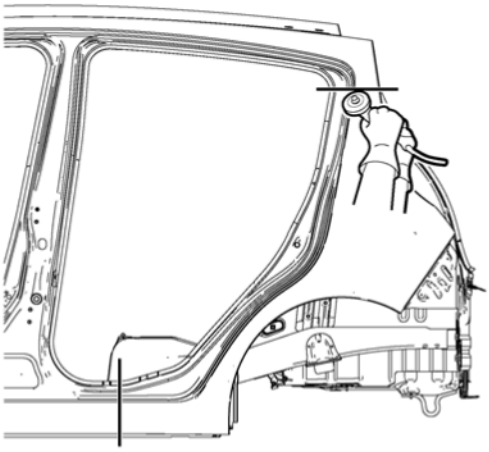




9. [Click here for full size]

10. Create cut lines on the quarter outer panel.

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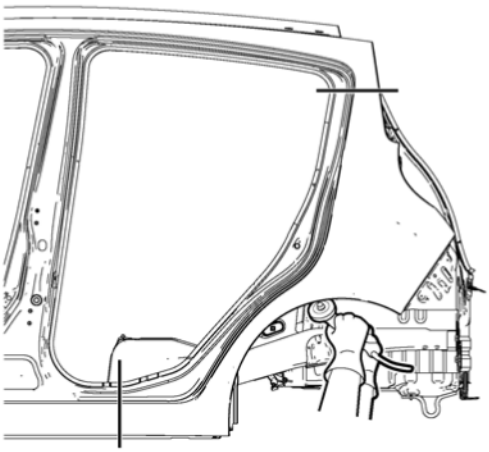


11. [Click here for full size]
12. Note**:**

    Do not damage any inner panels or reinforcements.

13. Cut the panel where sectioning is to be performed.

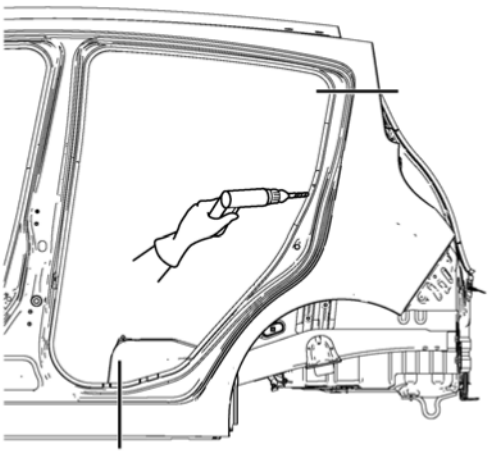
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14. [Click here for full size]

15. Open the wheelhouse flanging.

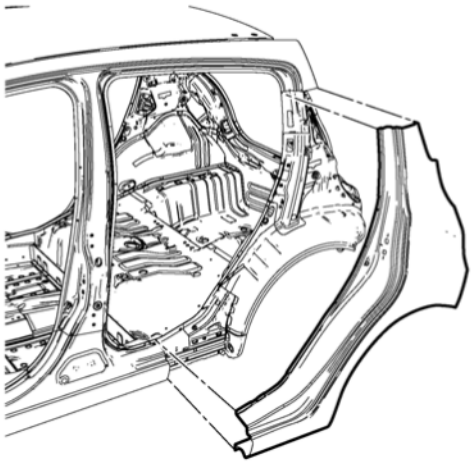


16. [Click here for full size]

17. Locate and mark all the necessary factory welds of the quarter outer panel.

18. Drill all factory welds. Note the number and location of welds for installation of the service assembly.

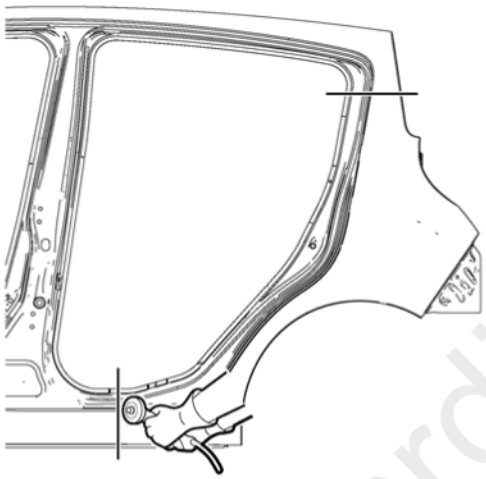
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19. Click here for full size
20. Remove the damaged quarter outer panel.

Installation Procedure



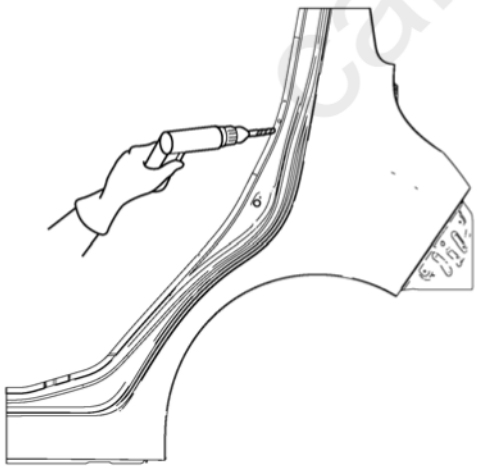
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1.

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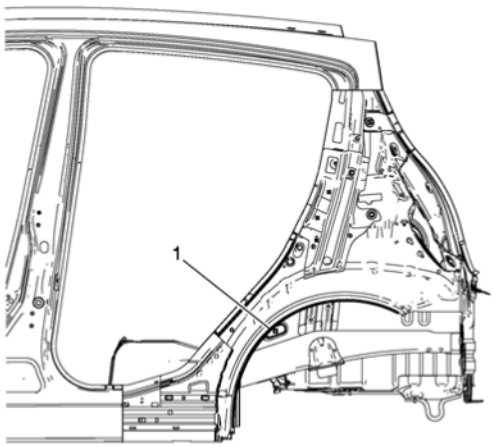
2. Cut the quarter outer panel in corresponding locations to fit the remaining original panel. The sectioning joint should be trimmed to allow a gap of one-and-one-half-times the metal thickness at the sectioning joint.
3. Create a 50â€‰mm (2â€‰in) backing plate from the unused portion of the service part.
4. Drill a 8â€‰mm (5/16â€‰in) along the sectioning cut on the remaining original part. Locate these holes 13â€‰mm (1/2â€‰in) from the edge of part and spaced 40â€‰mm (1â€‰1/2â€‰in) apart.
5. Prepare all mating surfaces as necessary.
6. Fit the backing plates halfway into the sectioning joints, clamp in place and plug weld to the vehicle.
7. Align the quarter outer panel.

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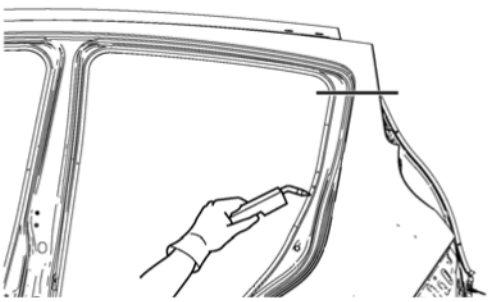
8. Click here for full size
9. Drill a 8â€‰mm (5/16â€‰in) for plug welding along the edges of the quarter outer panel as noted from the original panel.
10. Clean and prepare the attaching surfaces for welding.

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11. Click here for full size
12. Apply structural adhesiveâ€‰(1) as noted from the original panel.
13. Position the quarter outer panel on the vehicle.
14. Verify the fit of the quarter outer panel.
15. Clamp the quarter outer panel into position.

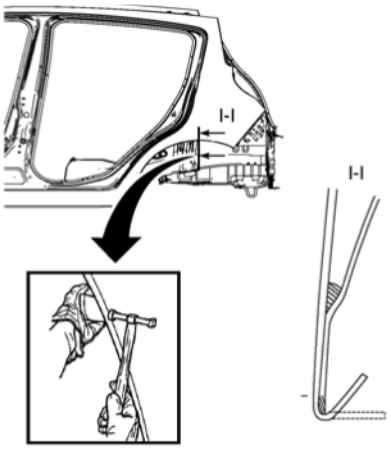
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16. Click here for full size
17. Plug the weld accordingly.
18. To create a solid weld with minimum heat distortion, make 25â€‰mm (1â€‰in) stitch welds along the seam with 25â€‰mm (1â€‰in) gaps between them. Then go back and complete the stitch weld.
19. Pre-flang the flange with *BO-6396* pliers and *BO-6392* tool kit.

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20. Click here for full size
21. Finish closing the wheelhouse flanging.
22. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.
23. Paint the repaired area. Refer to Basecoat/Clearcoat Paint Systems.
24. Install all related panels and components.
25. Connect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.
26. Enable the SIR system. Refer to SIR Disabling and Enabling.

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1. **BODY REPAIR**
2. COLLISION REPAIR
3. REPAIR INSTRUCTIONS
4.

Quarter Inner Panel Replacement (4NB)

Removal Procedure

1. Warning:

   Refer to Approved Equipment for Collision Repair Warning.

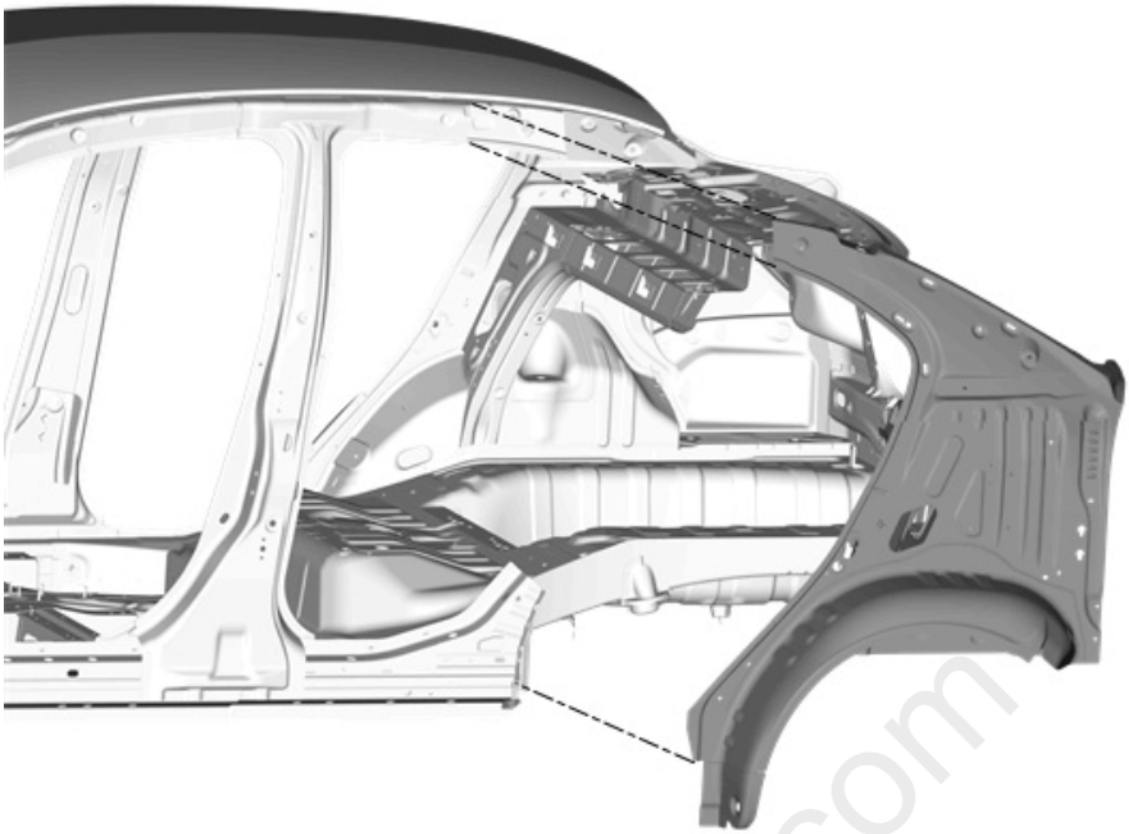
2. Warning:

   Refer to Glass and Sheet Metal Handling Warning.

3. Disable the SIR system. Refer to SIR Disabling and Enabling.
4. Disconnect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.
5. Remove all related panels and components.
6. Visually inspect the damage. Repair as much of the damage as possible.
7. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.
8. 

   Click here for full size

9. Locate and mark all factory welds.
10. Drill all factory welds. Note the number and location of welds for installation of the service assembly.
11.



Click here for full size

12. Remove the damaged quarter inner panel.

Installation Procedure

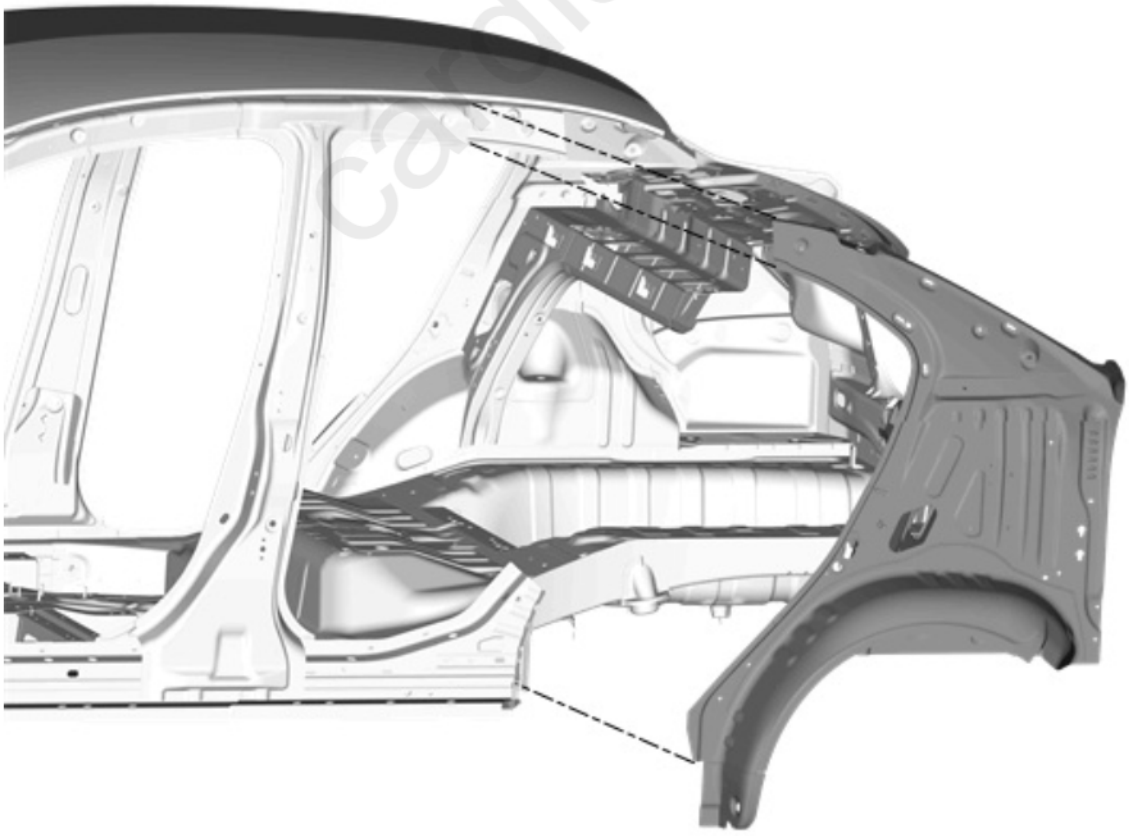
1. Align the quarter inner panel.
2.

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3. Drill a 8â€‰mm (5/16â€‰in) for plug welding along the edges of the service panel as noted from the original panel.
4. Clean and prepare the attaching surfaces for welding.
5.



Click here for full size

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6. Position the quarter inner panel.
7. Verify the fit of the panel.
8. Clamp the panel into position.
9. 

   Click here for full size
10. Plug weld accordingly.
11. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.
12. Paint the repaired area. Refer to Basecoat/Clearcoat Paint Systems.
13. Install all related panels and components.
14. Connect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.
15. Enable the SIR system. Refer to SIR Disabling and Enabling.

Related Part Information

Part Name	Catalog Name	Part Code
Quarter Inner Panel	PANEL,QTR INR	8430A
Quarter Inner Panel	PANEL,QTR INR	8430B
Quarter Inner Panel	PANEL,QTR INR(BLANK)	8430C
Quarter Inner Panel	PANEL KIT,QTR INR	2549Z
Quarter Inner Panel	PANEL,QTR INR	2550A
Quarter Inner Panel	PANEL,QTR INR	2550B
Quarter Inner Panel	PANEL,QTR INR (BLANK)	2550C

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1. **BODY REPAIR**
2. COLLISION REPAIR
3. REPAIR INSTRUCTIONS
4.

Quarter Inner Panel Replacement

Removal Procedure

1. Warning**:**

   Refer to Approved Equipment for Collision Repair Warning.

2. Warning**:**

   Refer to Glass and Sheet Metal Handling Warning.

3. Disable the SIR system. Refer to SIR Disabling and Enabling.

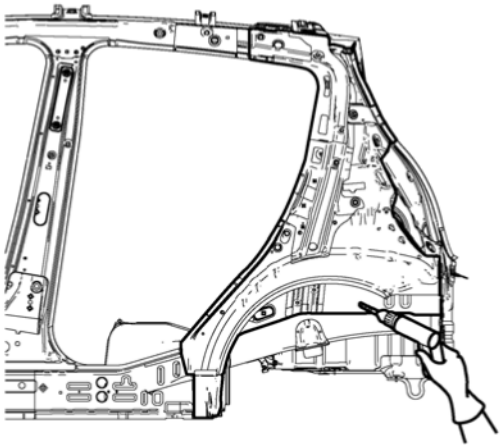
4. Disconnect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.

5. Remove all related panels and components.

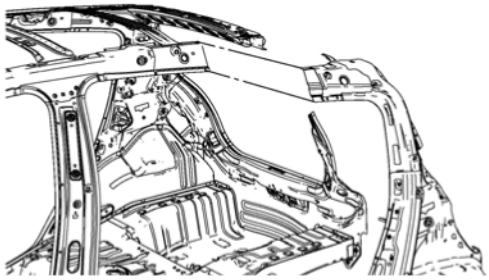
6. Visually inspect the damage. Repair as much of the damage as possible.

7. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.

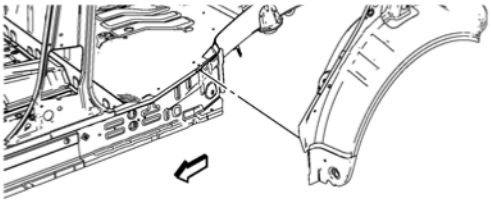
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8. Click here for full size
9. Locate and mark all factory welds.
10. Drill all factory welds. Note the number and location of welds for installation of the service assembly.



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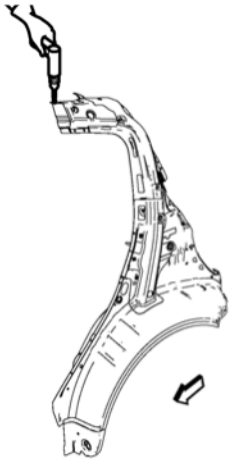


11. Click here for full size
12. Remove the damaged quarter inner panel.

Installation Procedure

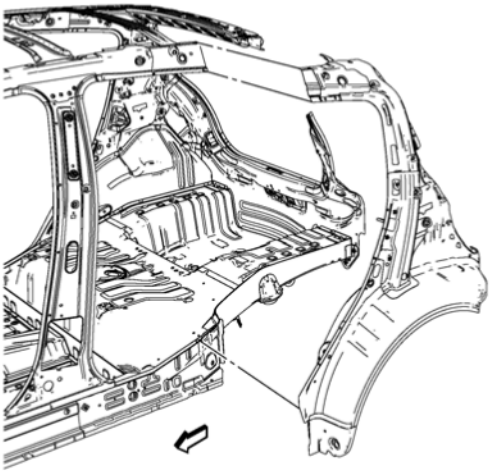
1. Align the quarter inner panel.

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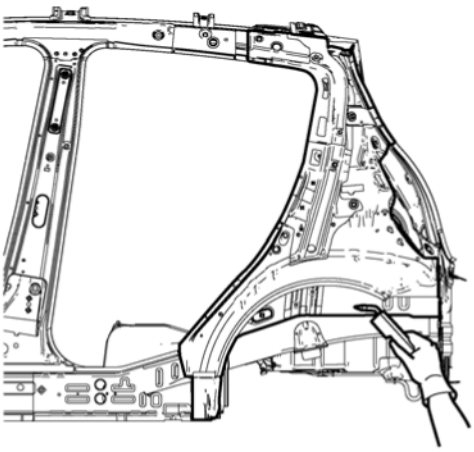
2. Click here for full size
3. Drill a 8â€‰mm (5/16â€‰in) for plug welding along the edges of the service panel as noted from the original panel.
4. Clean and prepare the attaching surfaces for welding.

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5. Click here for full size
6. Position the quarter inner panel.
7. Verify the fit of the panel.
8. Clamp the panel into position.

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9. Click here for full size
10. Plug weld accordingly.
11. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.
12. Paint the repaired area. Refer to Basecoat/Clearcoat Paint Systems.
13. Install all related panels and components.
14. Connect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.

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15. Enable the SIR system. Refer to SIR Disabling and Enabling.

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1. **BODY REPAIR**
2. COLLISION REPAIR
3. REPAIR INSTRUCTIONS
4.

Rear Rail Sectioning

Removal Procedure

1. Warning**:**

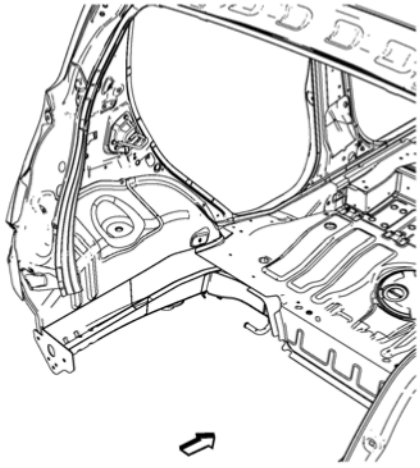
   Refer to Approved Equipment for Collision Repair Warning.

2. Warning**:**

   Refer to Glass and Sheet Metal Handling Warning.

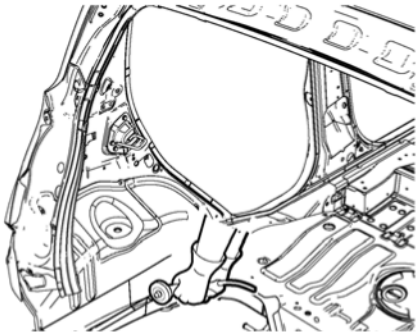
3. Disable the SIR system. Refer to SIR Disabling and Enabling.
4. Disconnect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.
5. Remove all related panels and components.
6. Visually inspect the damage. Repair as much of the damage as possible.
7. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.

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8. Click here for full size

9. Create cut lines on the rear side rail.



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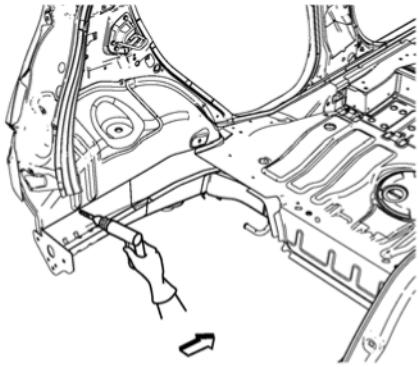
10. Click here for full size
11. Note**:**

    Do not damage any other panels or reinforcements.

12. Cut the panel where sectioning is to be performed.

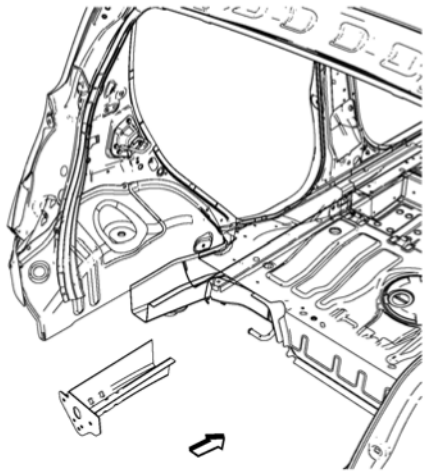


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13. Click here for full size
14. Locate and mark all the necessary factory welds of the rear side rail.
15. Drill all factory welds. Note the number and location of welds for installation of the service assembly.

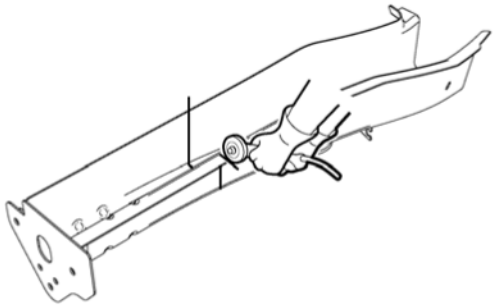
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16. Click here for full size
17. Remove the damaged rear side rail.

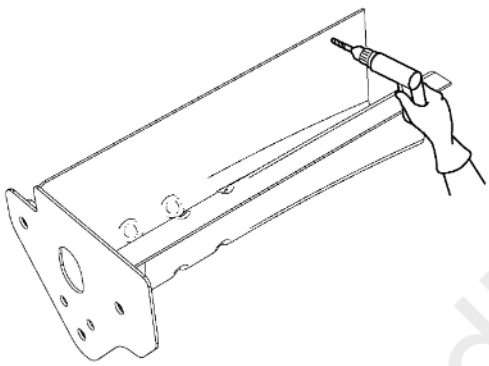
Installation Procedure

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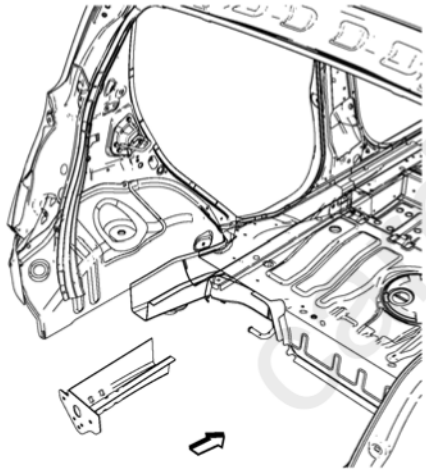
1. Click here for full size
2. Cut the rear side rail in corresponding locations to fit the remaining original panel. The sectioning joint should be trimmed to allow a gap of one-and-one-half-times the metal thickness at the sectioning joint.
3. Create a 50â€‰mm (2â€‰in) backing plate from the unused portion of the service part.
4. Drill 8â€‰mm (5/16â€‰in) along the sectioning cut on the remaining original part. Locate these holes 13â€‰mm (1/2â€‰in) from the edge of part and spaced 40â€‰mm (1â€‰1/2â€‰in) apart.
5. Prepare all mating surfaces as necessary.
6. Fit the backing plates halfway into the sectioning joints, clamp in place and plug weld to the vehicle.
7. Align the rear side rail.



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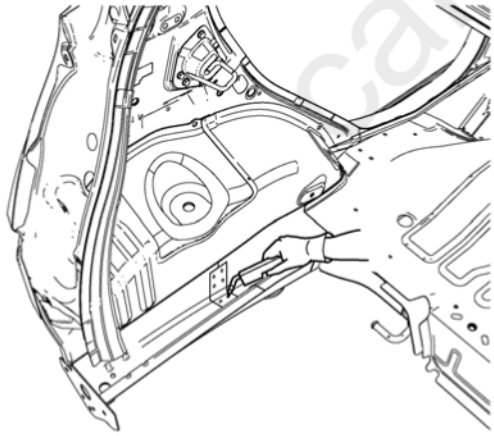
9. Drill 8â€‰mm (5/16â€‰in) for plug welding along the edges of the rear side rail as noted from the original panel.
10. Clean and prepare the attaching surfaces for welding.



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11. Click here for full size

12. Position the rear side rail on the vehicle.
13. Verify the fit of the rear side rail.
14. Clamp the rear side rail into position.



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15. Click here for full size

16. Plug the weld accordingly.

17. To create a solid weld with minimum heat distortion, make a 25â€‰mm (1â€‰in) stitch weld along the seam with 25â€‰mm (1â€‰in) gaps between them. Then go back and complete the stitch weld.

18. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.

19. Paint the repaired area. Refer to Basecoat/Clearcoat Paint Systems.

20. Install all related panels and components.

21. Connect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.

22. Enable the SIR system. Refer to SIR Disabling and Enabling.

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1. **BODY REPAIR**
2. COLLISION REPAIR
3. REPAIR INSTRUCTIONS
4.

Rear End Panel Replacement

Removal Procedure

1. Warning**:**

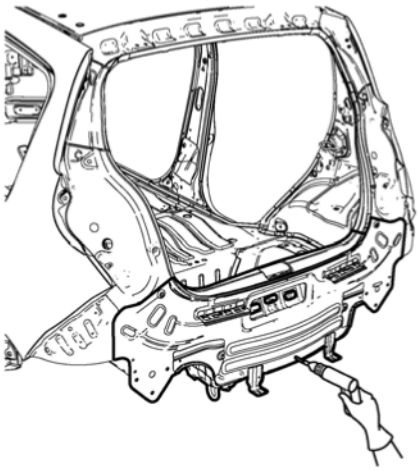
   Refer to Approved Equipment for Collision Repair Warning.

2. Warning**:**

   Refer to Glass and Sheet Metal Handling Warning.

3. Disable the SIR system. Refer to SIR Disabling and Enabling.
4. Disconnect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.
5. Remove all related panels and components.
6. Visually inspect the damage. Repair as much of the damage as possible.
7. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.

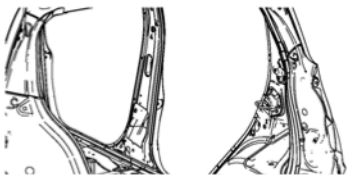
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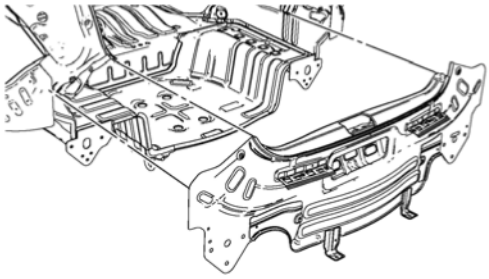
8. Click here for full size
9. Note:

   Note the number and location of welds for installation of the service assembly.

10. Locate and mark all the necessary factory welds of the body rear end panel.
11. Drill all factory welds.



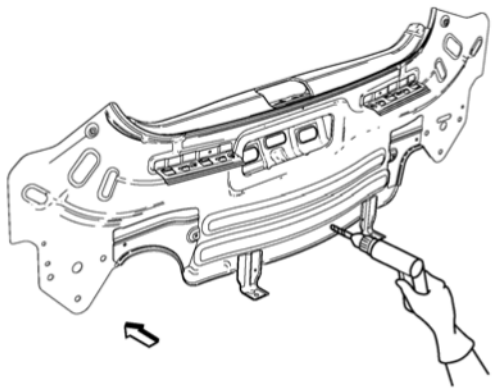
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12. Click here for full size
13. Remove the body rear end panel.

Installation Procedure

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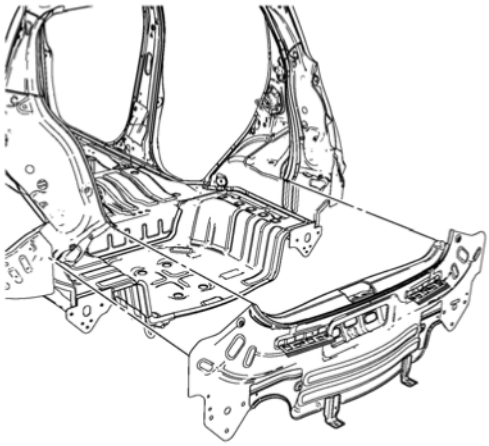


1. Click here for full size
2. Note:

   If the location of the original plug weld holes can not be determined, space the plug weld holes every 40â€‰mm (1â€‰1/2 in).

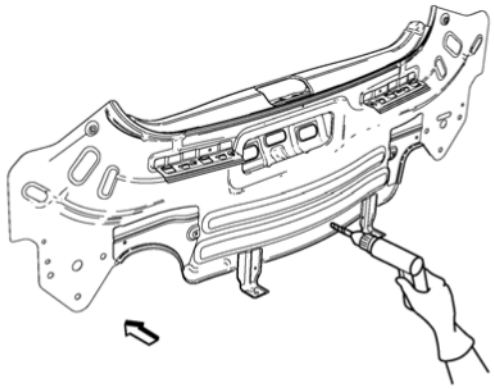
3. Drill 8â€‰mm (5/16â€‰in) for plug welding along the edges of the body rear end panel as noted from the original panel.
4. Clean and prepare the attaching surfaces for welding.

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5. Click here for full size
6. Position the body rear end panel on the vehicle.
7. Verify the fit of the body rear end panel.
8. Clamp the body rear end panel into position.

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9. Click here for full size
10. Plug the weld accordingly.
11. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.
12. Paint the repaired area. Refer to Basecoat/Clearcoat Paint Systems.

13. Install all related panels and components.
14. Connect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.
15. Enable the SIR system. Refer to SIR Disabling and Enabling.

Related Part Information

Part Name	Catalog Name	Part Code
Rear End Panel	PANEL,R/END	8200A
Rear End Panel	PANEL,R/END	8200B
Rear End Panel	PANEL,R/END(BLANK)	8200E
Rear End Panel	PANEL,R/END	5200A
Rear End Panel	PANEL,R/END	5200B
Rear End Panel	PANEL,R/END (BLANK)	5200X
Rear End Panel	PANEL,R/END	SS123

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1. **BODY REPAIR**
2. COLLISION REPAIR
3. REPAIR INSTRUCTIONS
4.

Tail Lamp Pocket Replacement (4NB)

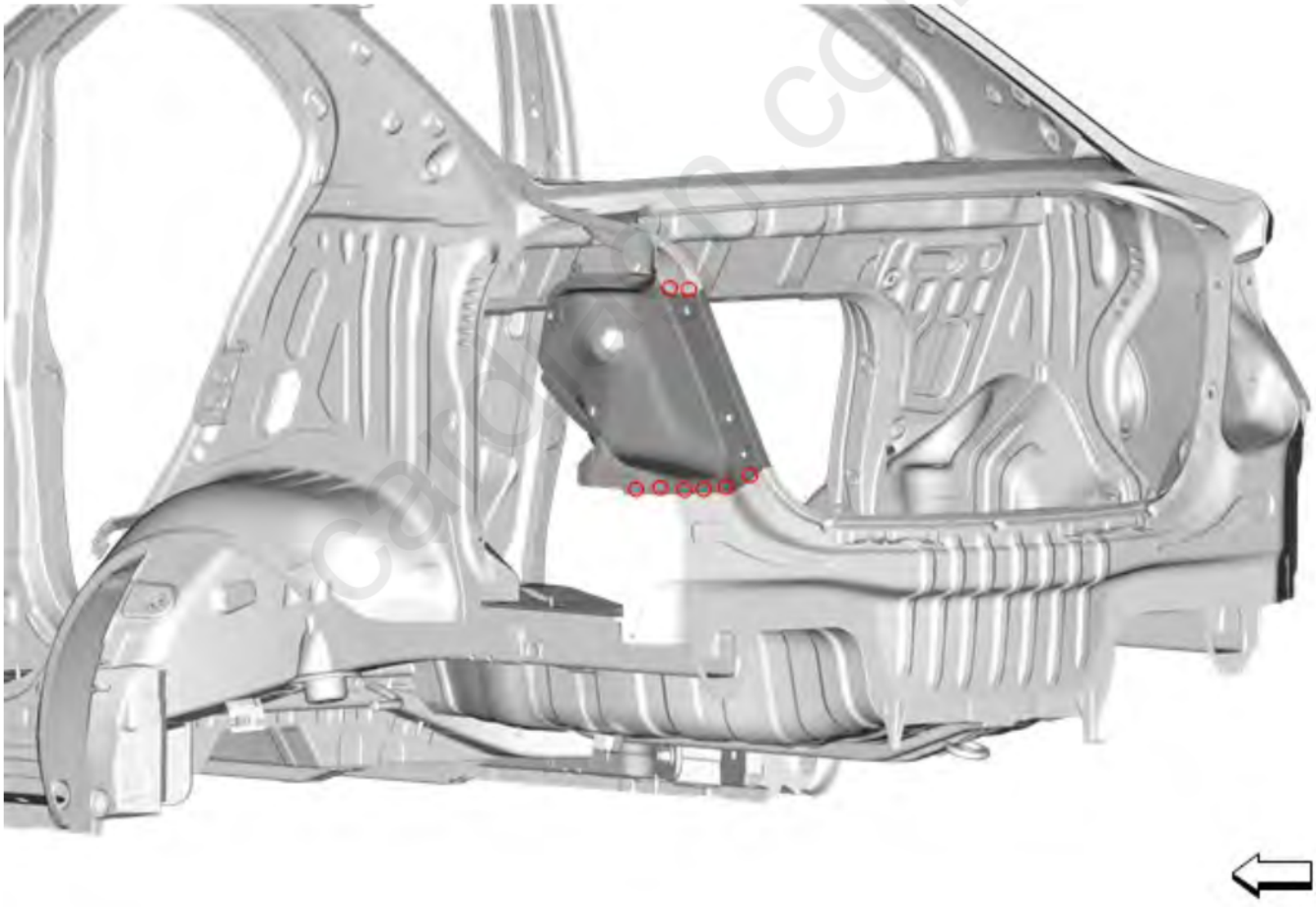
Removal Procedure

1. Warning:

   Refer to Approved Equipment for Collision Repair Warning.

2. Warning:

   Refer to Glass and Sheet Metal Handling Warning.

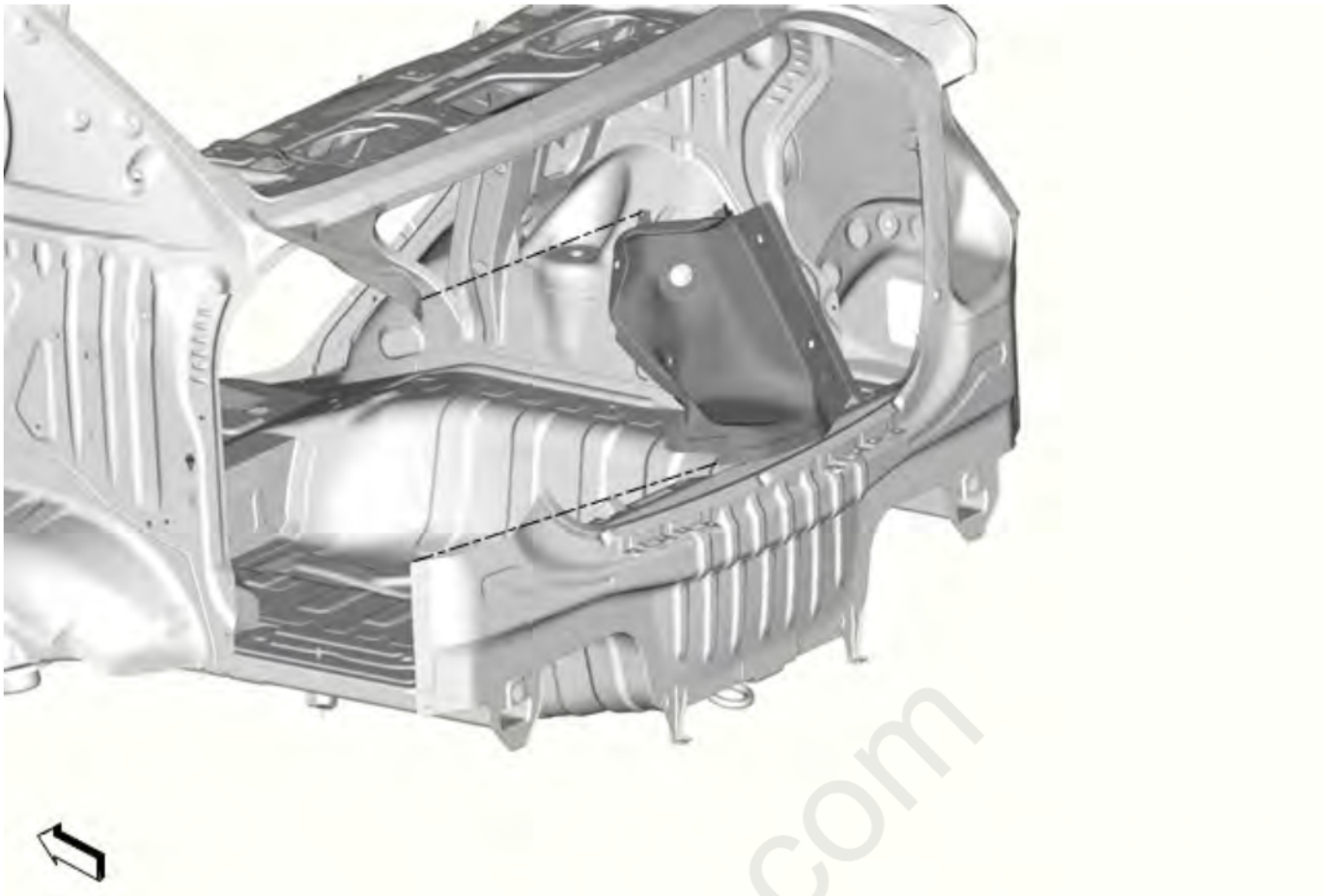
3. Disable the SIR system. Refer to SIR Disabling and Enabling.
4. Disconnect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.
5. Remove all related panels and components.
6. Visually inspect the damage. Repair as much of the damage as possible.
7. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.
8. Locate and mark all factory welds.
9. 

   Click here for full size

10. Locate and mark all the necessary factory welds of the body rear end panel.
11. Note:

    Note the number and location of welds for installation of the service assembly.

12. Drill all factory welds.
13.



Click here for full size

14. Remove the tail lamp pocket.

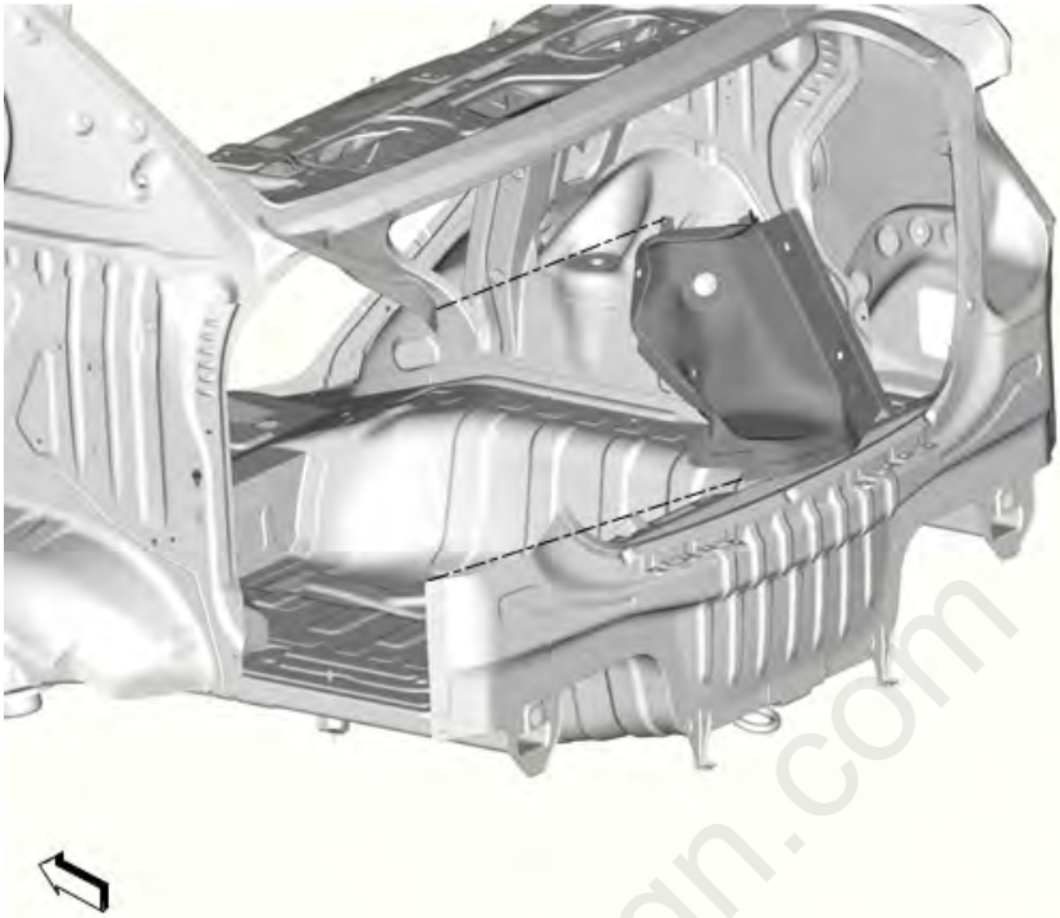
Installation Procedure

1.



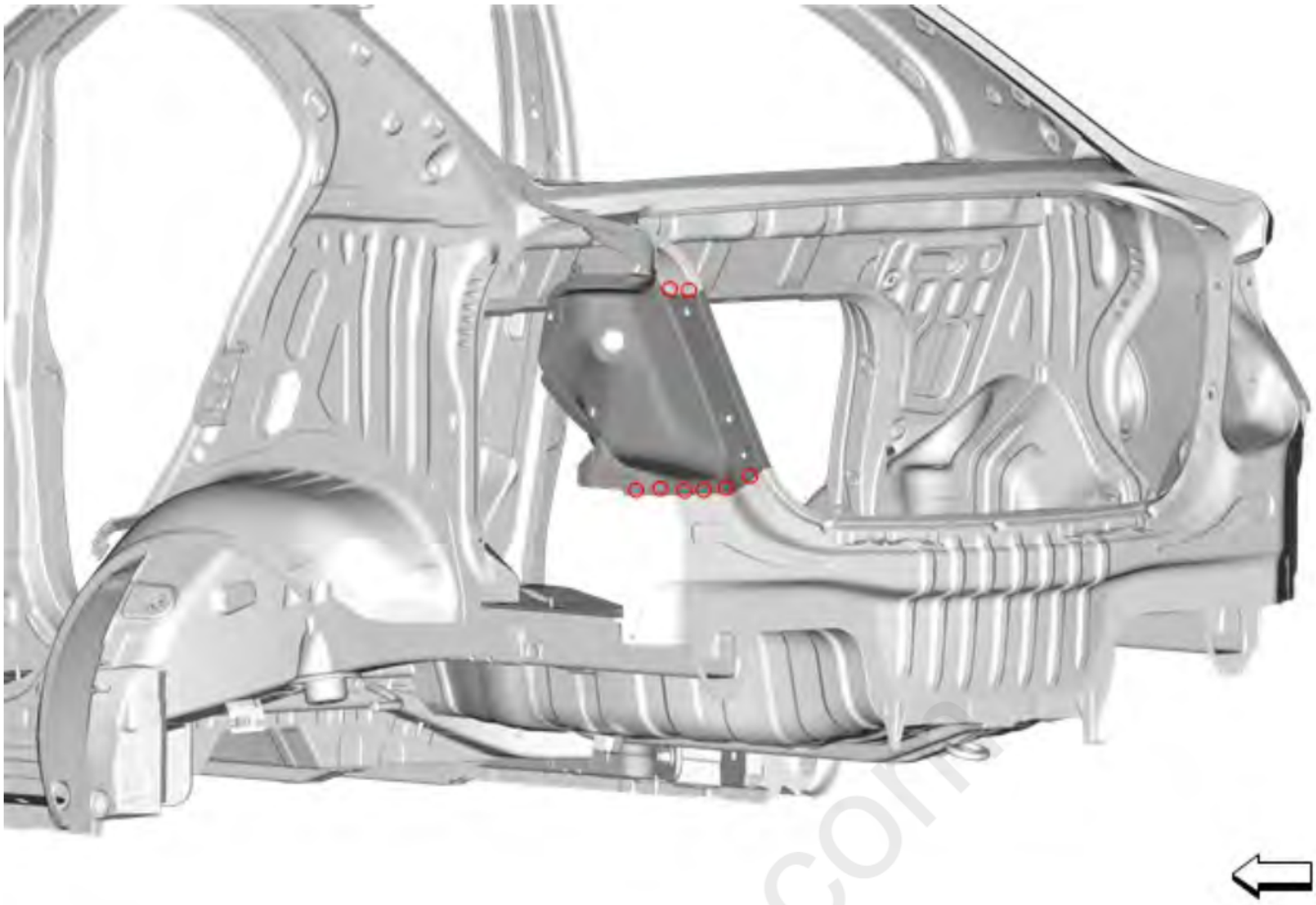
Click here for full size

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2. Drill 8â€‰mm (5/16â€‰in) for plug welding along the edges of the tail lamp pocket as noted from the original panel.
3. Clean and prepare the attaching surfaces for welding.
4. 

   Click here for full size
5. Position the tail lamp pocket on the vehicle.
6. Verify the fit of the tail lamp pocket.
7. Clamp the tail lamp pocket into position.
8.

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Click here for full size

9. Plug the weld accordingly.
10. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.
11. Paint the repaired area. Refer to Basecoat/Clearcoat Paint Systems.
12. Install all related panels and components.
13. Connect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.
14. Enable the SIR system. Refer to SIR Disabling and Enabling.

Related Part Information

Part Name	Catalog Name	Part Code
Tail Lamp Pocket	POCKET,T/LP	0310A
Tail Lamp Pocket	POCKET,T/LP	0310B

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1. **BODY REPAIR**
2. COLLISION REPAIR
3. REPAIR INSTRUCTIONS
4.

Tail Lamp Pocket Replacement

Removal Procedure

1. Warning**:**

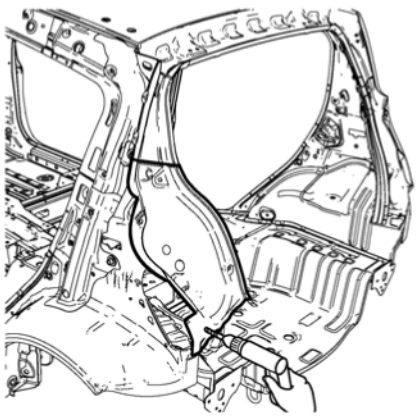
   Refer to Approved Equipment for Collision Repair Warning.

2. Warning**:**

   Refer to Glass and Sheet Metal Handling Warning.

3. Disable the SIR system. Refer to SIR Disabling and Enabling.
4. Disconnect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.
5. Remove all related panels and components.
6. Visually inspect the damage. Repair as much of the damage as possible.
7. Remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.
8. Locate and mark all factory welds.

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9. Click here for full size

10. Locate and mark all the necessary factory welds of the body rear end panel.

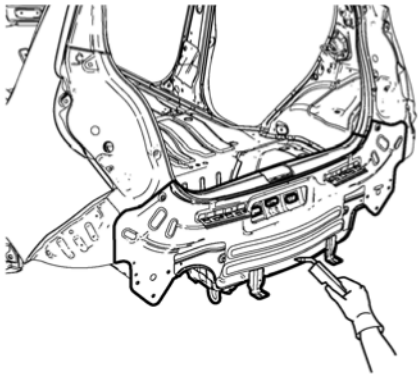
11. Note:

    Note the number and location of welds for installation of the service assembly.

12. Drill all factory welds.

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13. Click here for full size
14. Remove the tail lamp pocket.

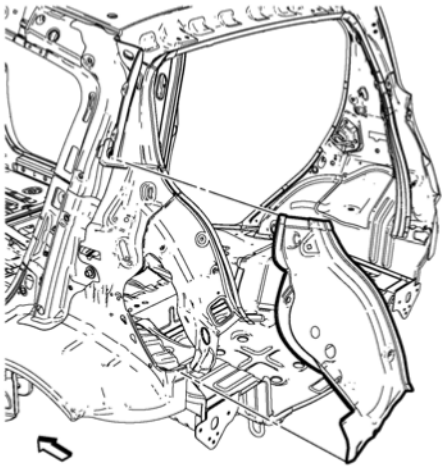
Installation Procedure

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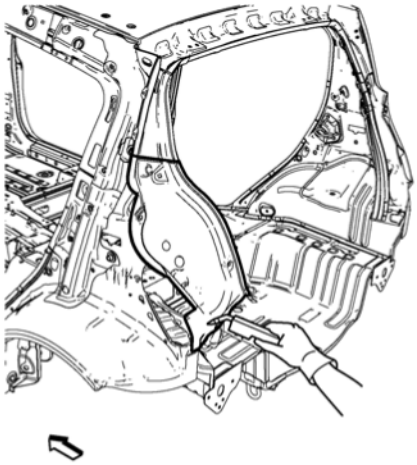
1. Click here for full size
2. Drill 8â€‰mm (5/16â€‰in) for plug welding along the edges of the tail lamp pocket as noted from the original panel.
3. Clean and prepare the attaching surfaces for welding.



4. [Click here for full size]

5. Position the tail lamp pocket on the vehicle.
6. Verify the fit of the tail lamp pocket.
7. Clamp the tail lamp pocket into position.

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8. Click here for full size
9. Plug the weld accordingly.
10. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to Anti-Corrosion Treatment and Repair.
11. Paint the repaired area. Refer to Basecoat/Clearcoat Paint Systems.

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12. Install all related panels and components.
13. Connect the negative battery cable. Refer to Battery Negative Cable Disconnection and Connection.
14. Enable the SIR system. Refer to SIR Disabling and Enabling.

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Specifications

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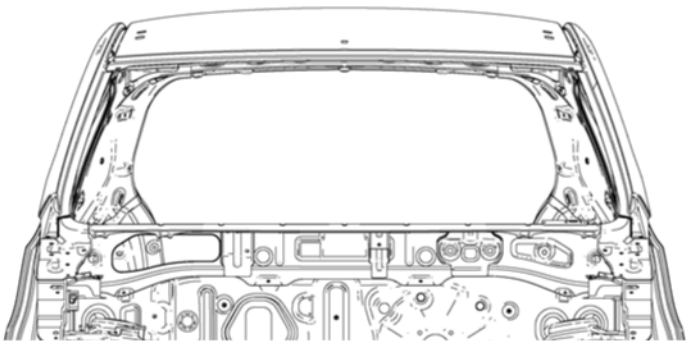
1. **BODY REPAIR**
2. COLLISION REPAIR
3. SPECIFICATIONS
4.

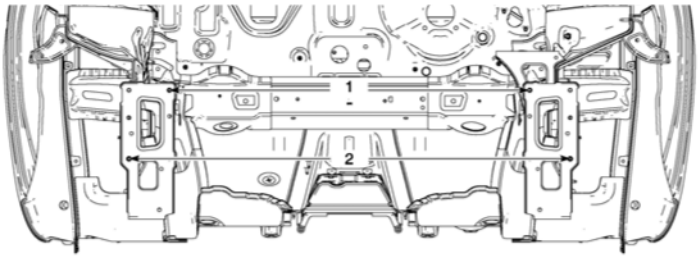
Dimensions - Body (4NB)

Point-to-point measurements are for reference only. All measurements are given in millimeters. Use these measurements for diagnosing and estimating. Point-to-point measurements are duplicated with tram bar pointers set at equal lengths. All die marks, holes, slots, and fasteners are measured to the center. All dimensions are symmetrical unless otherwise specified

Point-to-Point Measurements

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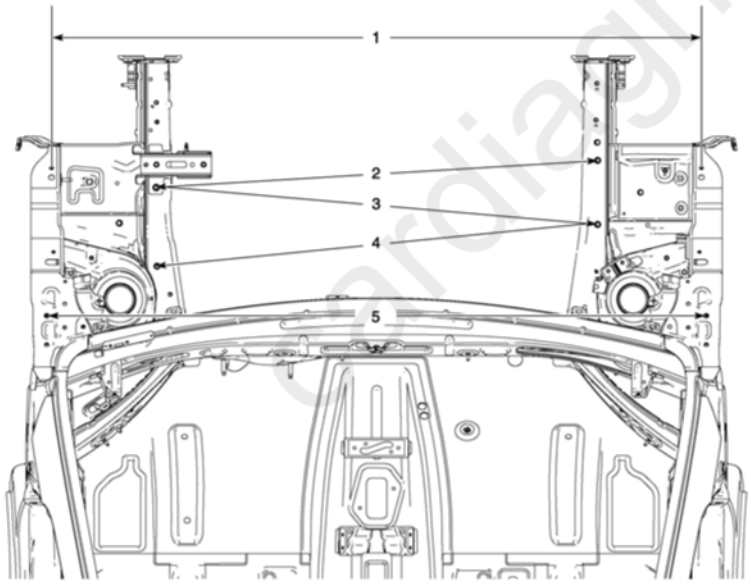




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- (1) 833â€‰mm
- (2) 1020â€‰mm

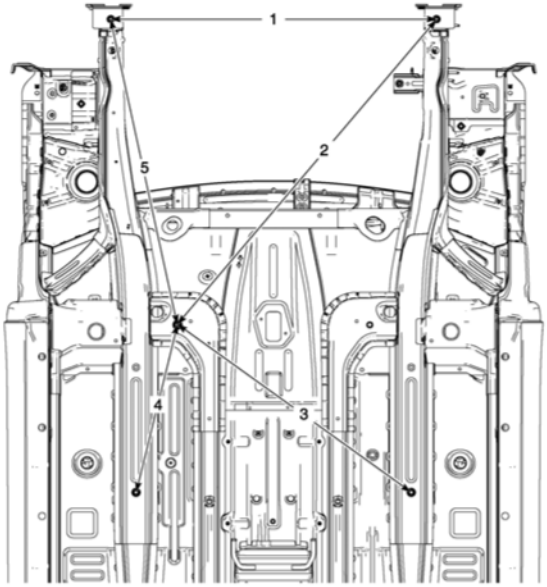


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- (1) 1334â€‰mm
- (2) 908â€‰mm
- (3) 909â€‰mm
- (4) 908â€‰mm
- (5) 1354â€‰mm

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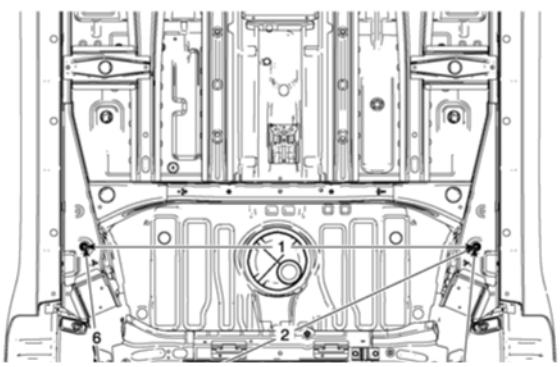


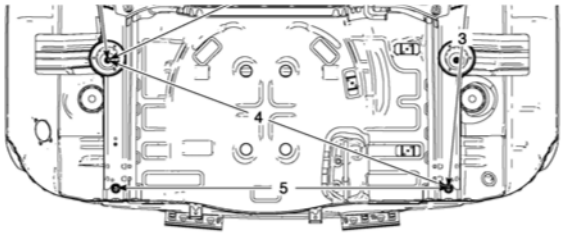
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- (1) 918â€‰mm
- (2) 1131â€‰mm
- (3) 812â€‰mm
- (4) 488â€‰mm
- (5) 884â€‰mm

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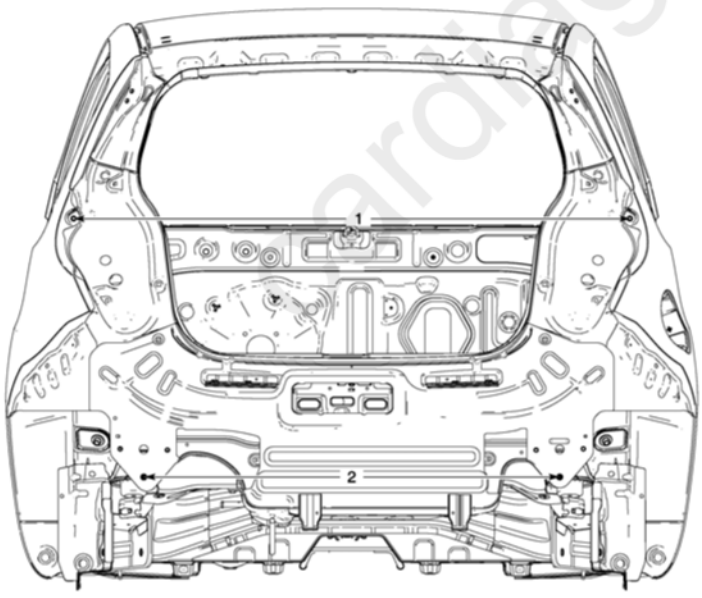




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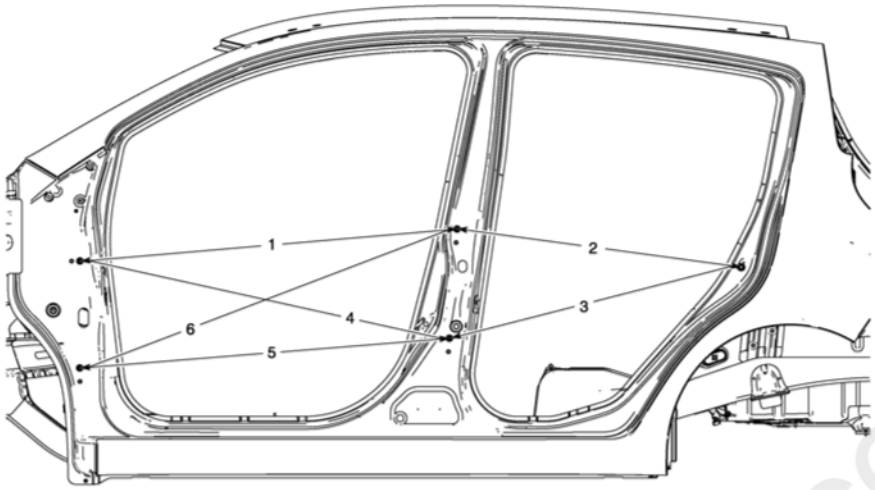
- (1) 1132â€‰mm
- (2) 1191â€‰mm
- (3) 904â€‰mm
- (4) 1053â€‰mm
- (5) 960â€‰mm
- (6) 528â€‰mm


1
2

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- (1) 1284â€‰mm
- (2) 910â€‰mm

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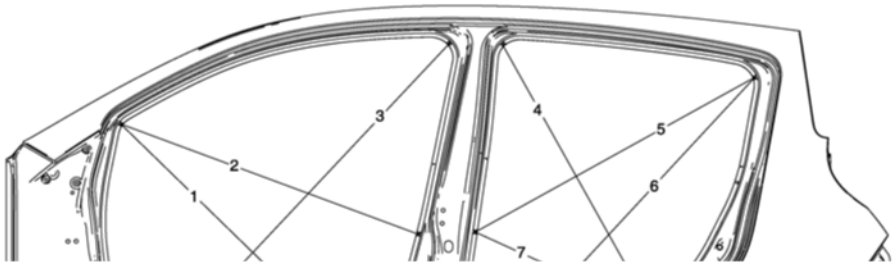


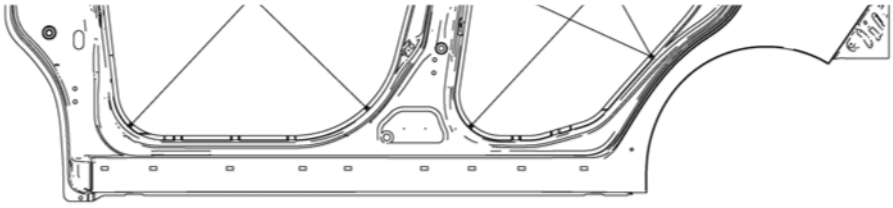
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- (1) 1060â€‰mm
- (2) 805â€‰mm
- (3) 843â€‰mm
- (4) 1058â€‰mm
- (5) 1039â€‰mm
- (6) 1127â€‰mm

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- (1) 981â€‰mm
- (2) 916â€‰mm
- (3) 1338â€‰mm
- (4) 896â€‰mm
- (5) 927â€‰mm
- (6) 1199â€‰mm
- (7) 563â€‰mm

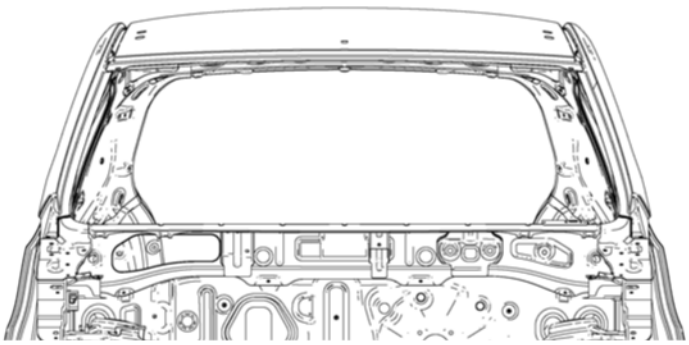
1. **BODY REPAIR**
2. COLLISION REPAIR
3. SPECIFICATIONS
4.

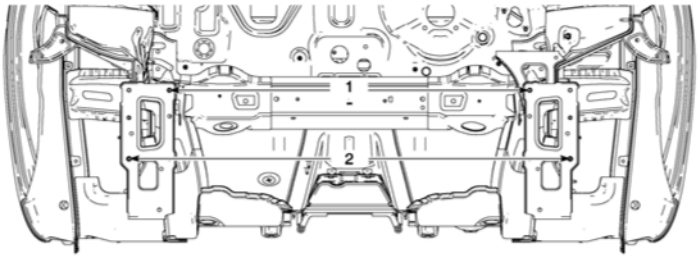
Dimensions - Body

Point-to-point measurements are for reference only. All measurements are given in millimeters. Use these measurements for diagnosing and estimating. Point-to-point measurements are duplicated with tram bar pointers set at equal lengths. All die marks, holes, slots, and fasteners are measured to the center. All dimensions are symmetrical unless otherwise specified

Point-to-Point Measurements

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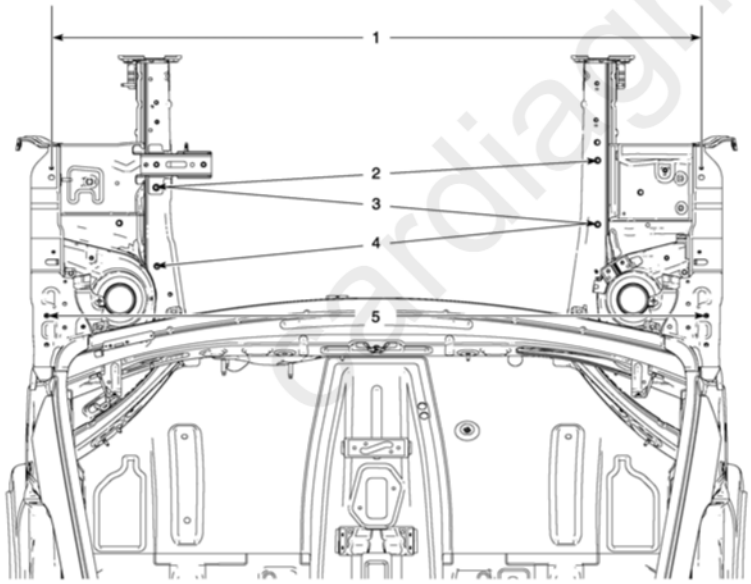




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- (1) 833â€‰mm
- (2) 1020â€‰mm

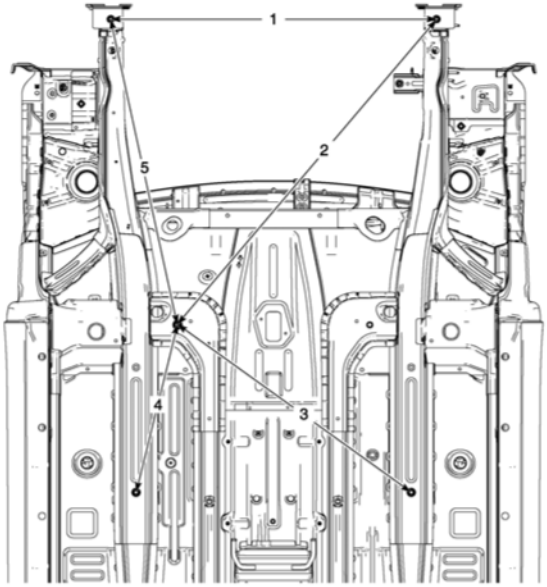


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- (1) 1334â€‰mm
- (2) 908â€‰mm
- (3) 909â€‰mm
- (4) 908â€‰mm
- (5) 1354â€‰mm

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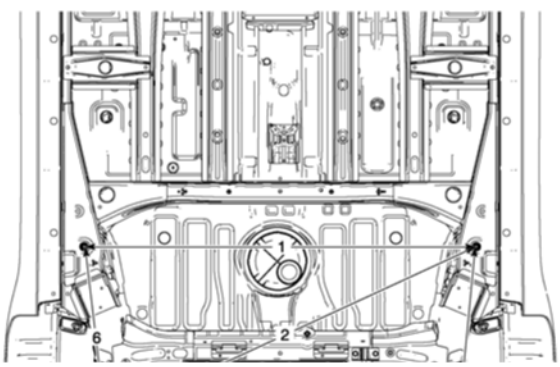


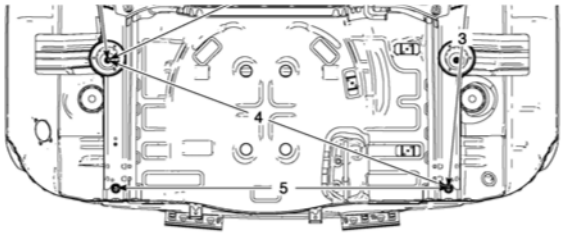
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- (3) 812â€‰mm
- (4) 488â€‰mm
- (5) 884â€‰mm

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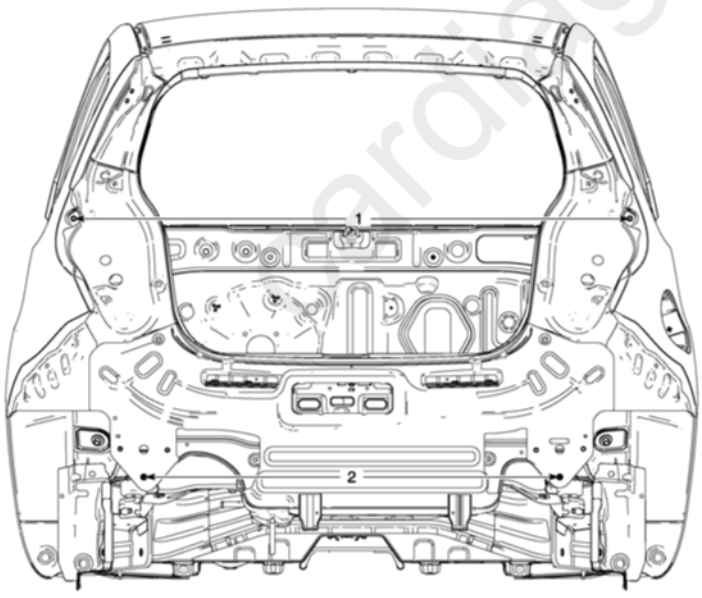




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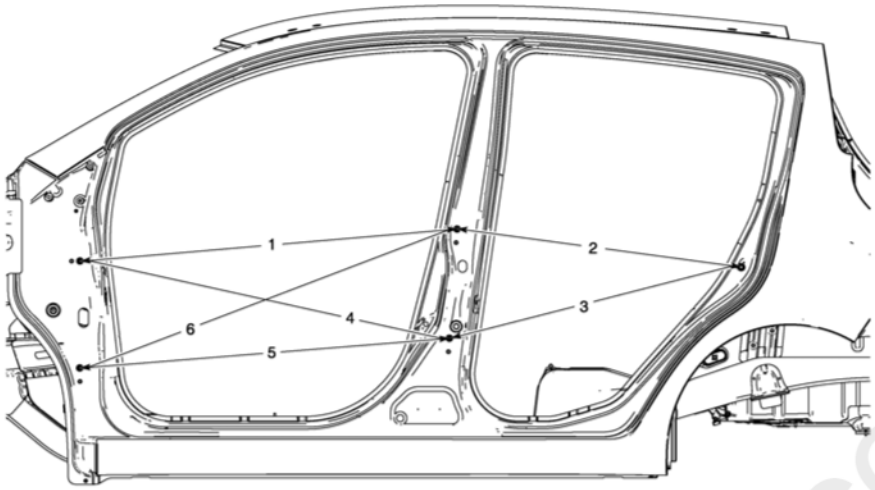
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- (1) 1284â€‰mm
- (2) 910â€‰mm

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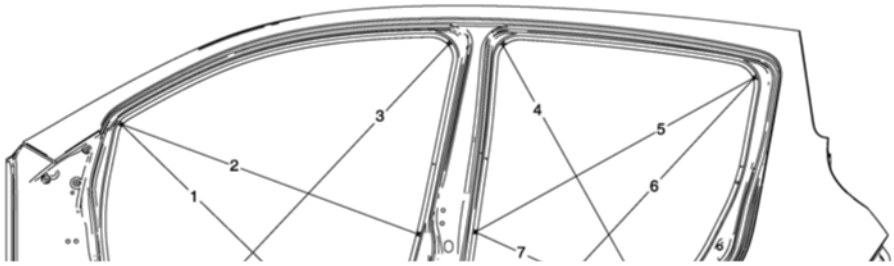


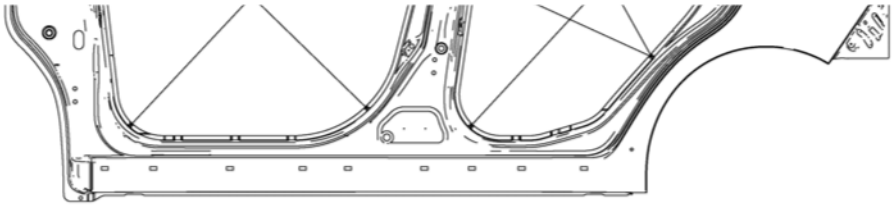
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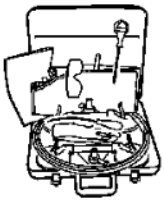
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- (4) 896â€‰mm
- (5) 927â€‰mm
- (6) 1199â€‰mm
- (7) 563â€‰mm

Special Tools and Equipment

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1. **BODY REPAIR**
2. COLLISION REPAIR
3. SPECIAL TOOLS AND EQUIPMENT
4.

Special Tools

Illustration	Tool Number/ Description
 Click here for full size	BO-6392 MKM-6392 Flanging Tool Kit
 Click here for full size	BO-6396 KM-6396 Bonding Pliers
 Click here for full size	BO-642-A MKM-642-A Telescope Measuring Instrument

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