

RADIATOR UPPER SUPPORT (ASSY)



F24651A

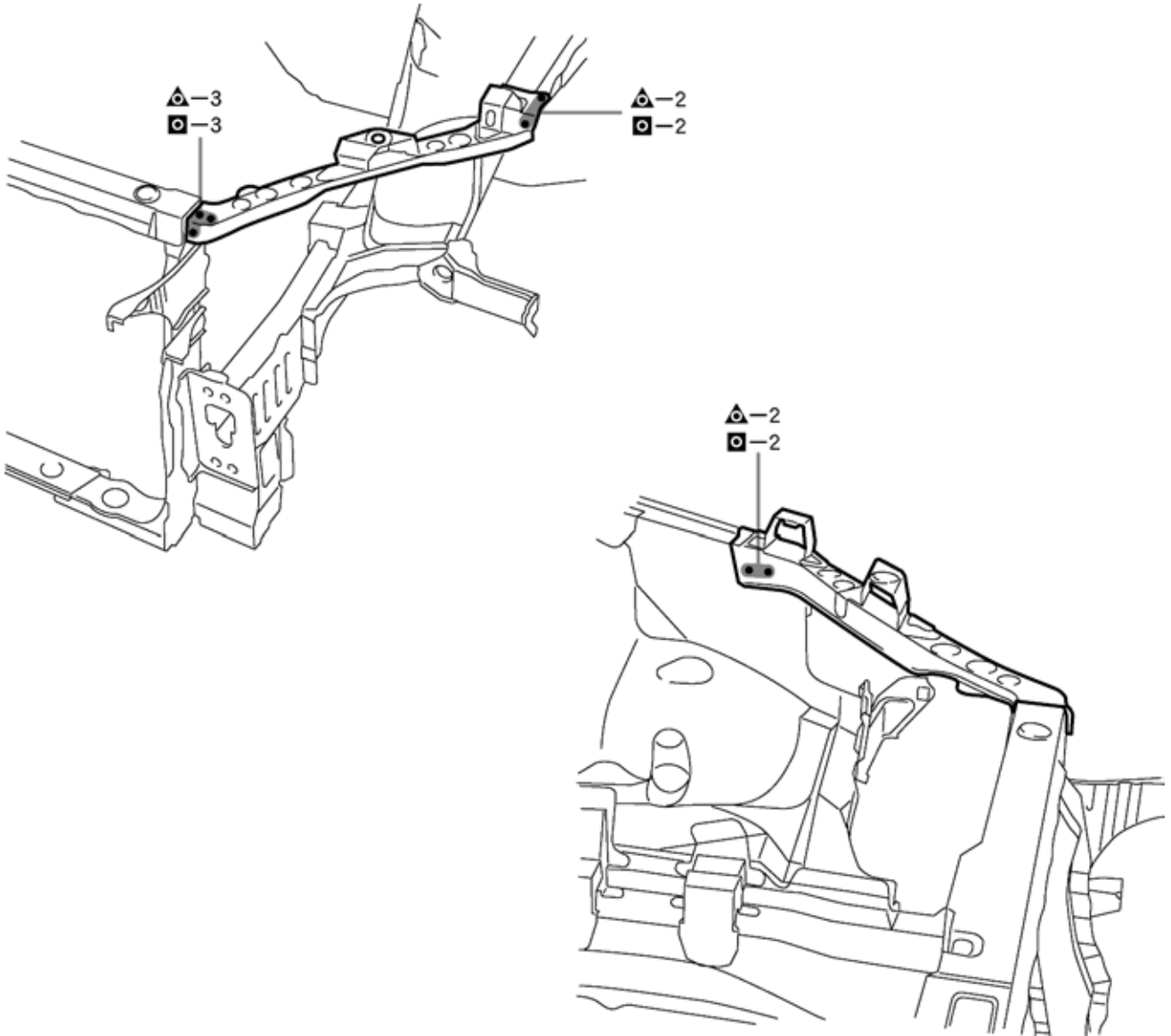
Symbol meaning

REMOVAL  : Remove Weld Points

INSTALLATION  : MIG Plug Weld

F24651B

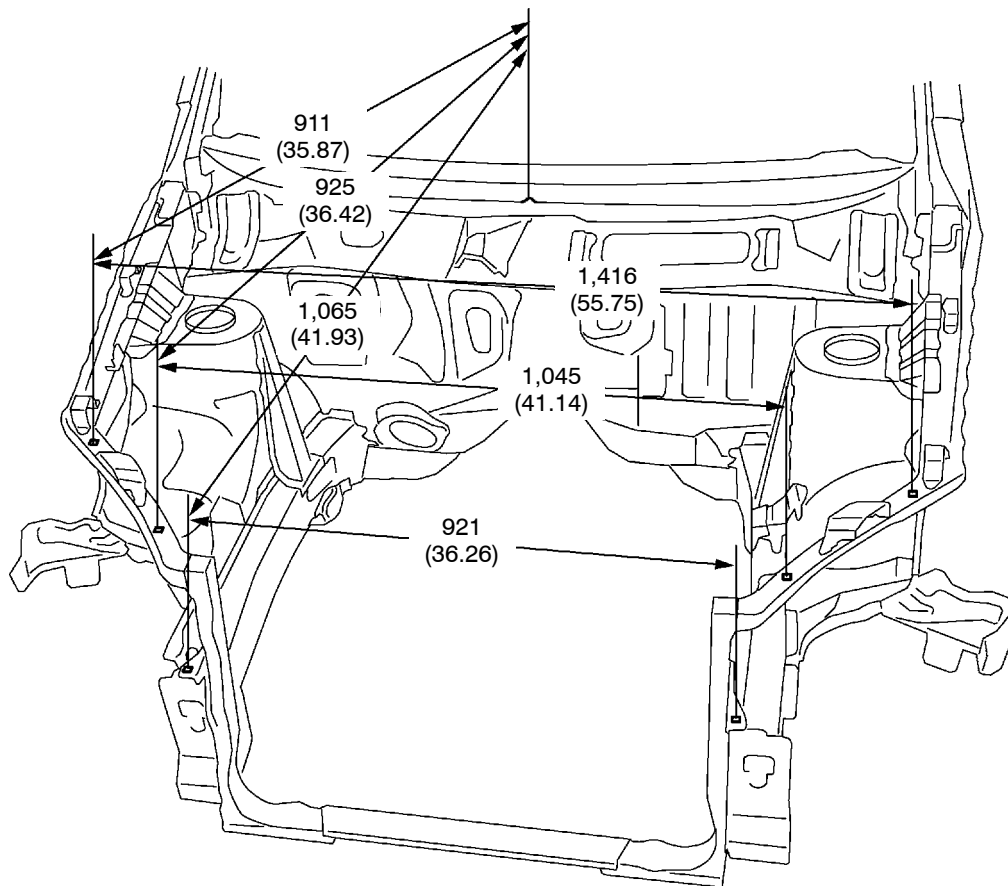
REMOVAL·INSTALLATION



F24651

INSTALLATION POINT

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



mm (in.)

F24652

INSTALLATION POINT

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

RADIATOR SIDE SUPPORT (ASSY)



F24653A

With the radiator upper support removed.

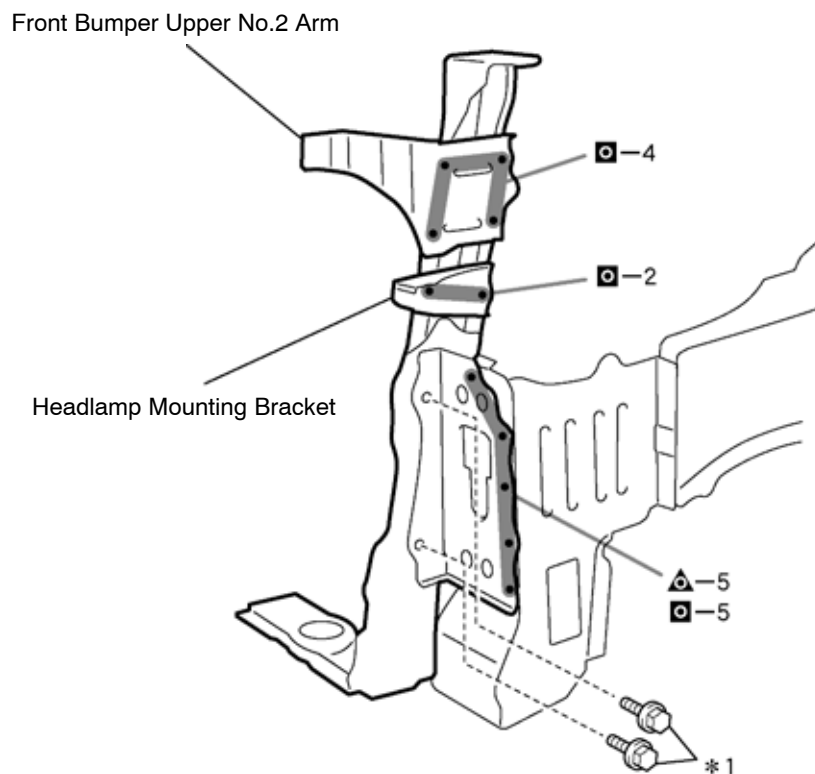
Symbol meaning

REMOVAL  : Remove Weld Points

INSTALLATION  : MIG Plug Weld

F24653B

REMOVAL·INSTALLATION



F24653

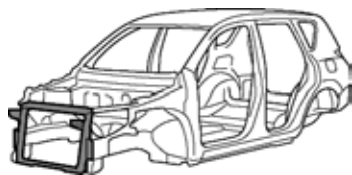
REMOVAL POINT

1 *1: Bolt

INSTALLATION POINT

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

RADIATOR SUPPORT (ASSY)



F24654A

With the radiator upper support removed.

Symbol meaning

REMOVAL

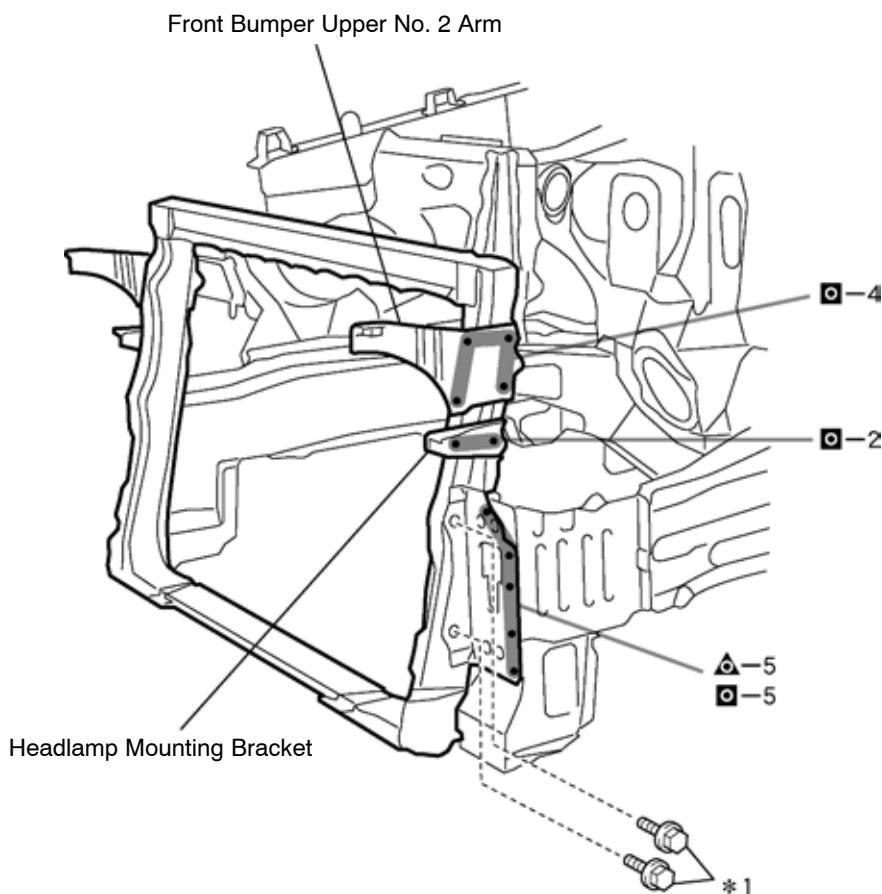
△ : Remove Weld Points

INSTALLATION

◻ : MIG Plug Weld

F24654B

REMOVAL-INSTALLATION



F24654

REMOVAL POINT

1 *1: Bolt

INSTALLATION POINT

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

FRONT FENDER APRON FRONT EXTENSION (ASSY)



F24655A

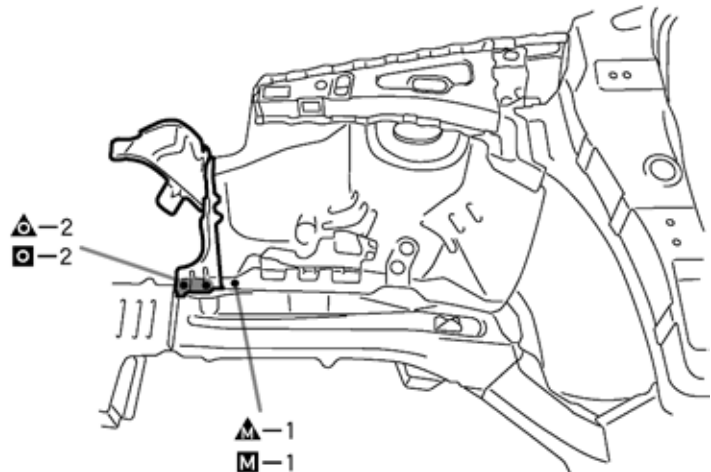
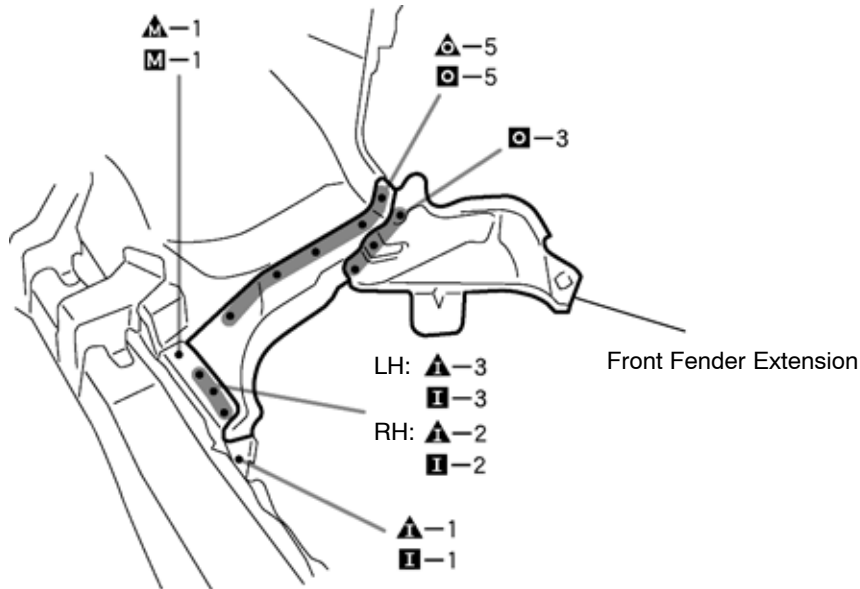
Symbol meaning

REMOVAL : Remove Weld Points

INSTALLATION : MIG Plug Weld

F24655B

REMOVAL·INSTALLATION

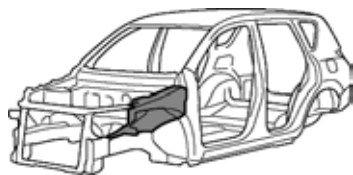


F24655

INSTALLATION POINT

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

FRONT FENDER APRON (ASSY)



F24656A

With the radiator support and cowl top side panel removed.

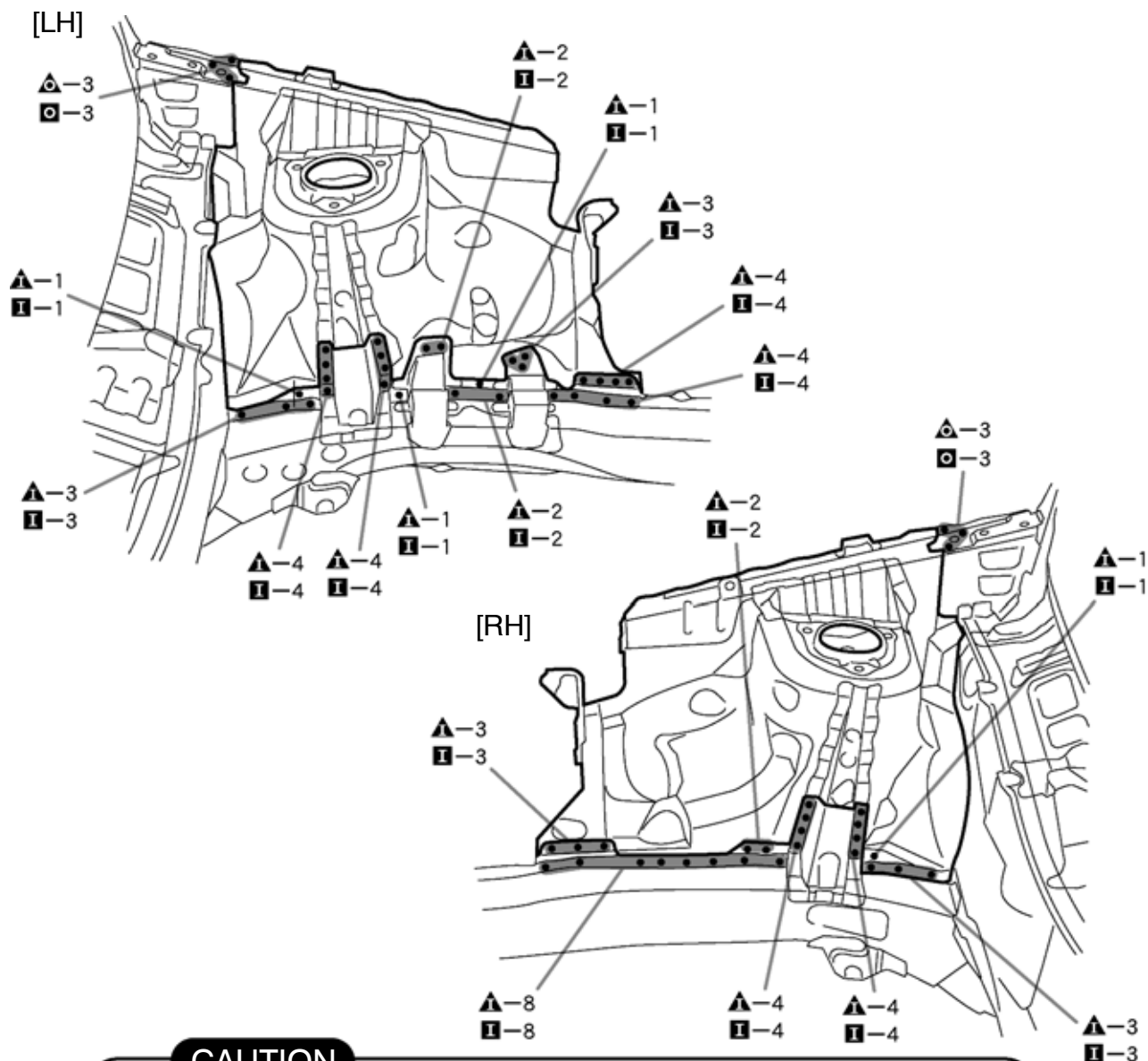
Symbol meaning

REMOVAL : Remove Weld Points

INSTALLATION : MIG Plug Weld

F24656B

REMOVAL-INSTALLATION



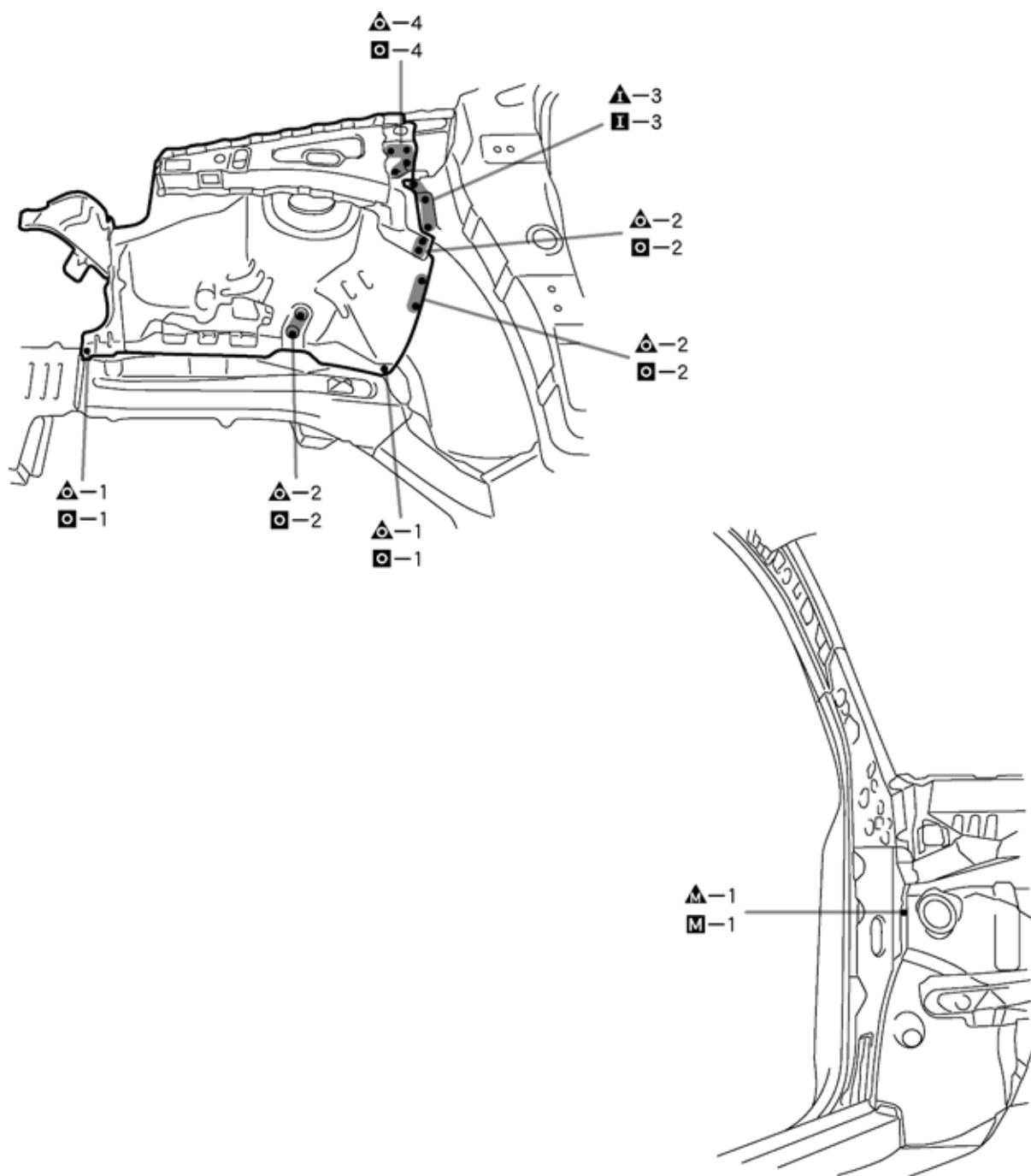
CAUTION

Make sure each measurement is correct, as this part affects the front wheel alignment.

F24656

INSTALLATION POINT

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



F24657

INSTALLATION POINT

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

FRONT SIDE MEMBER (CUT-P)



F24658A

With the radiator support removed.

Symbol meaning

▲ : Remove Weld Points

■ : Cut and Join Location

F24658B

REMOVAL

[LH]

Front Side Member Extension

Front side Member No. 2 Plate

250
(9.84)

10
(0.39)

65
(2.56)

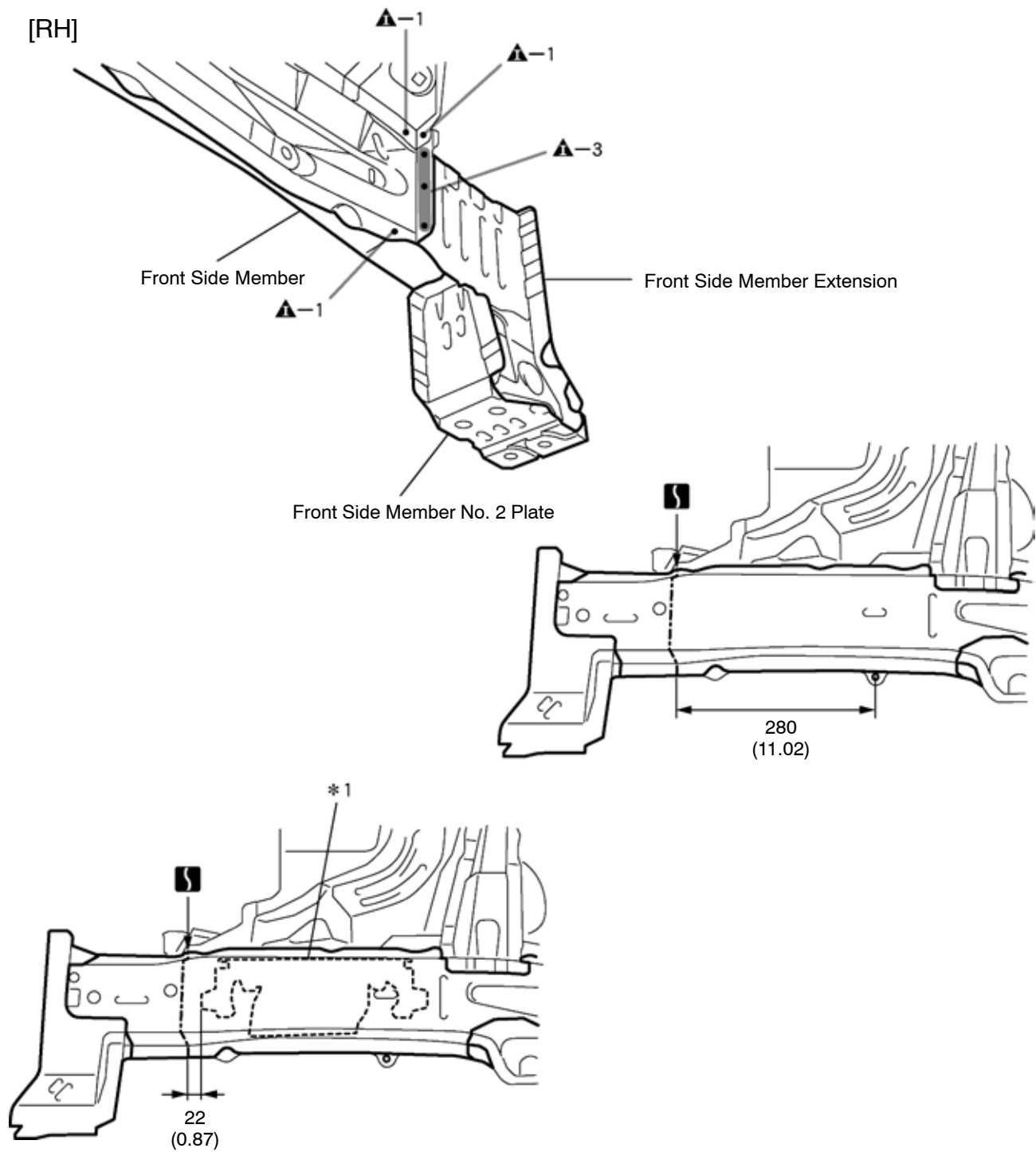
mm (in.)

F24658

REMOVAL POINT

- 1 Remove the front side member extension and front side member No. 2 plate at the same time.
- 2 *1: Take care not to damage the internal reinforcement.

[RH]



mm (in.)

F24659

REMOVAL POINT

- 1 Remove the front side member extension and front side member No. 2 plate at the same time.
- 2 *1: Take care not to damage the internal reinforcement.

Symbol meaning



 : MIG Plug Weld



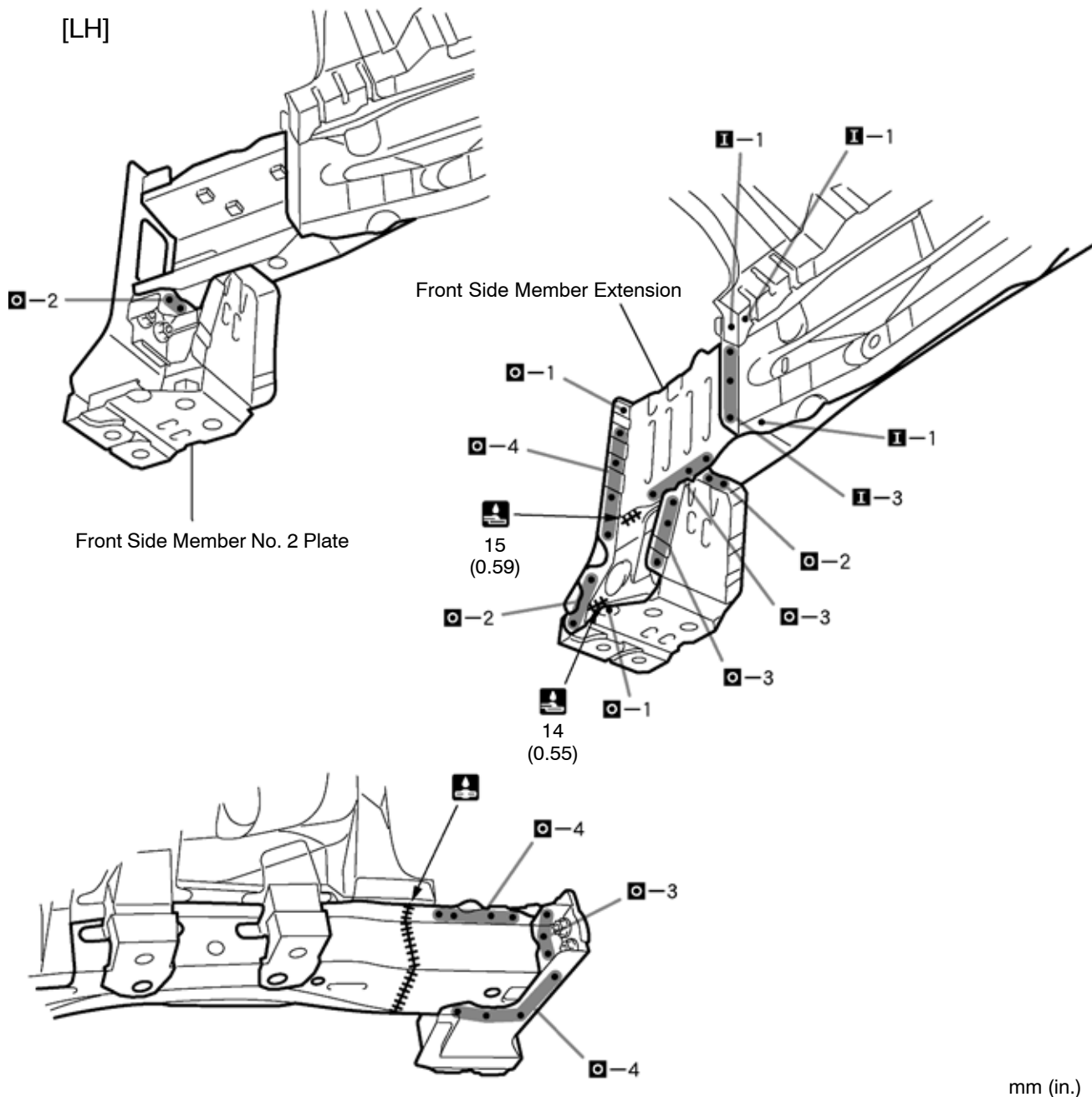
: Tack Weld



: Butt Weld

F24660B

INSTALLATION

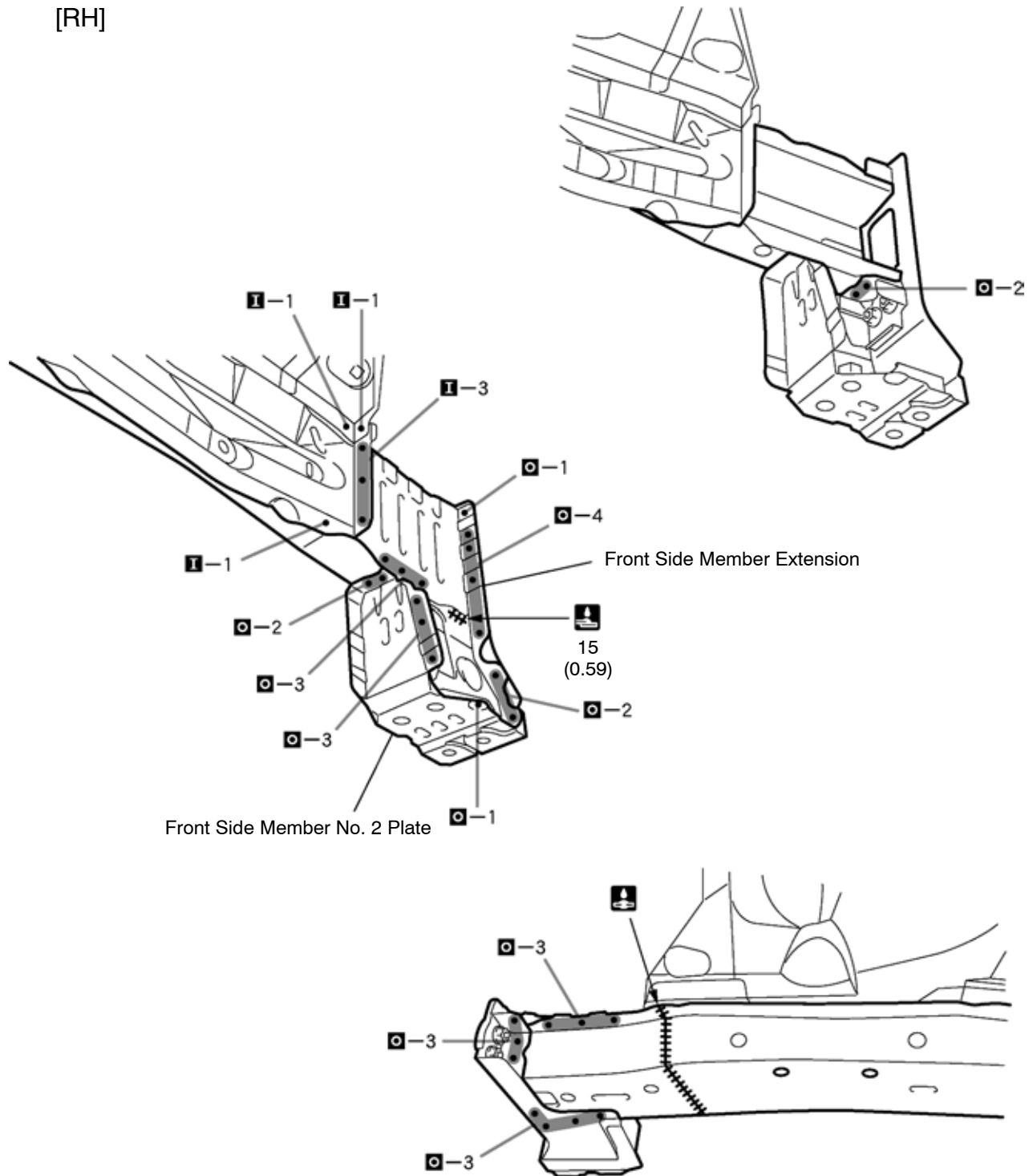


F24660

INSTALLATION POINT

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

[RH]



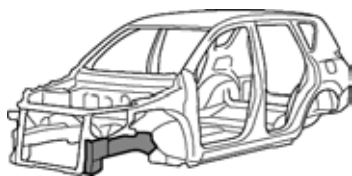
mm (in.)

F24661

INSTALLATION POINT

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

FRONT SIDE MEMBER (CUT-H)



F24662A

With the radiator support and front fender apron removed.

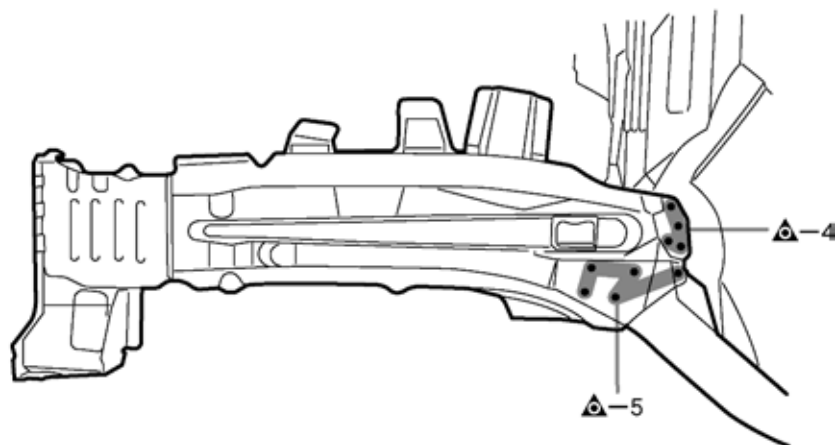
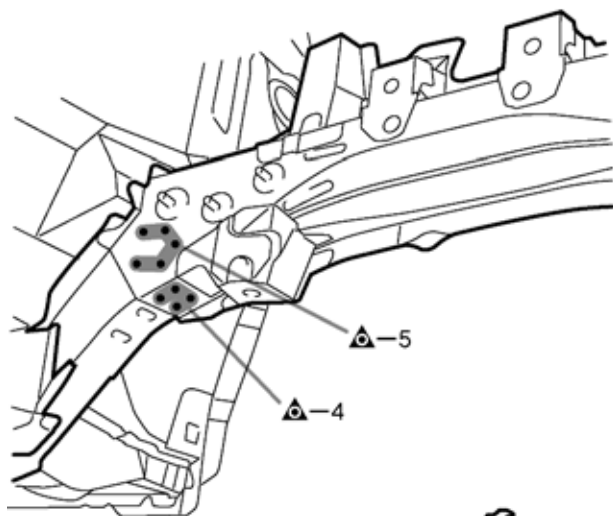
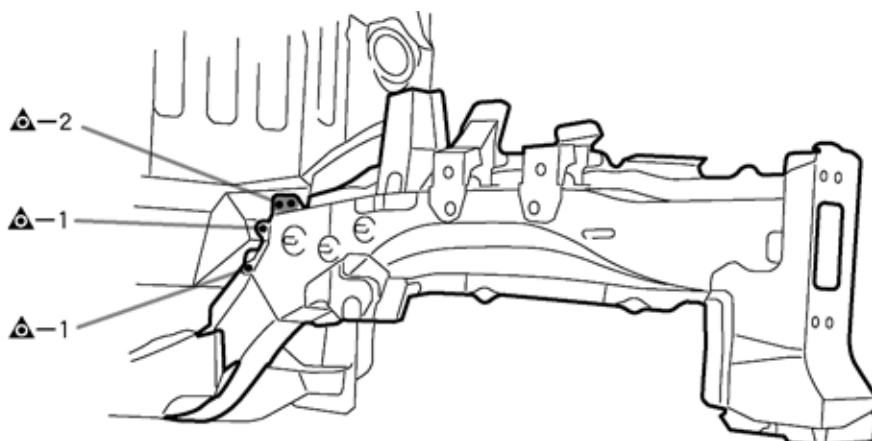
Symbol meaning

△ : Remove Weld Points

F24662B

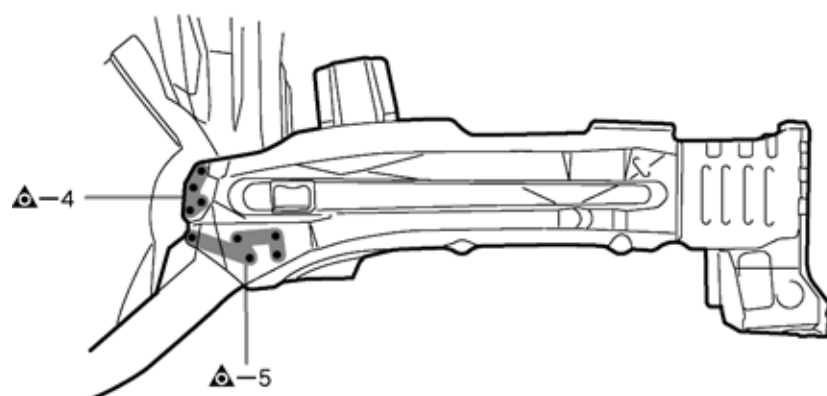
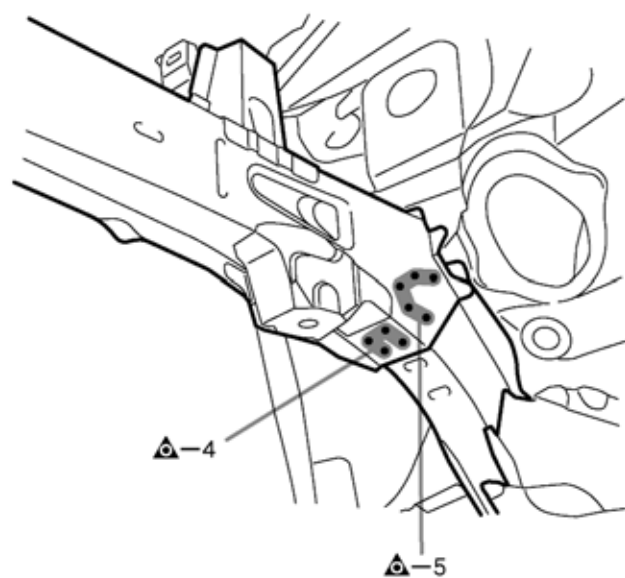
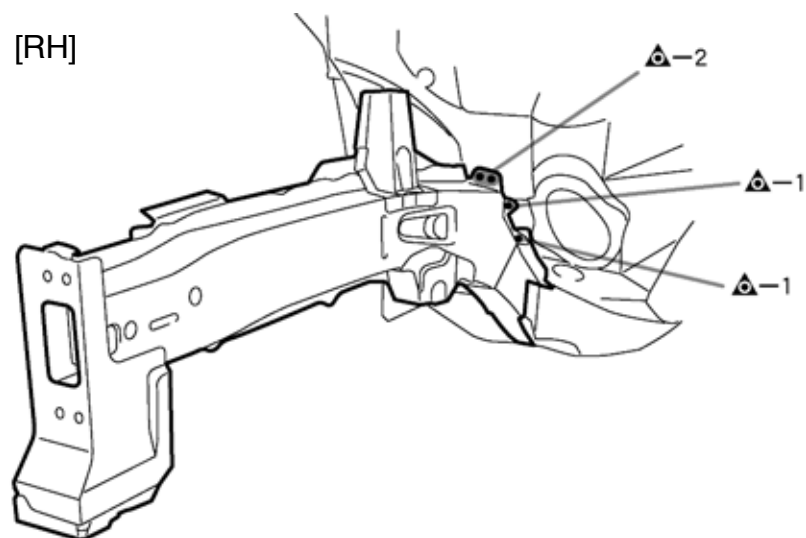
REMOVAL

[LH]



F24462

[RH]



Symbol meaning

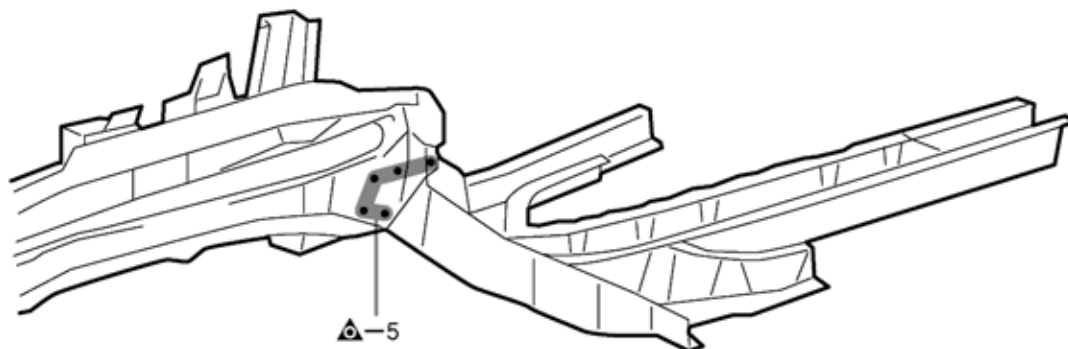
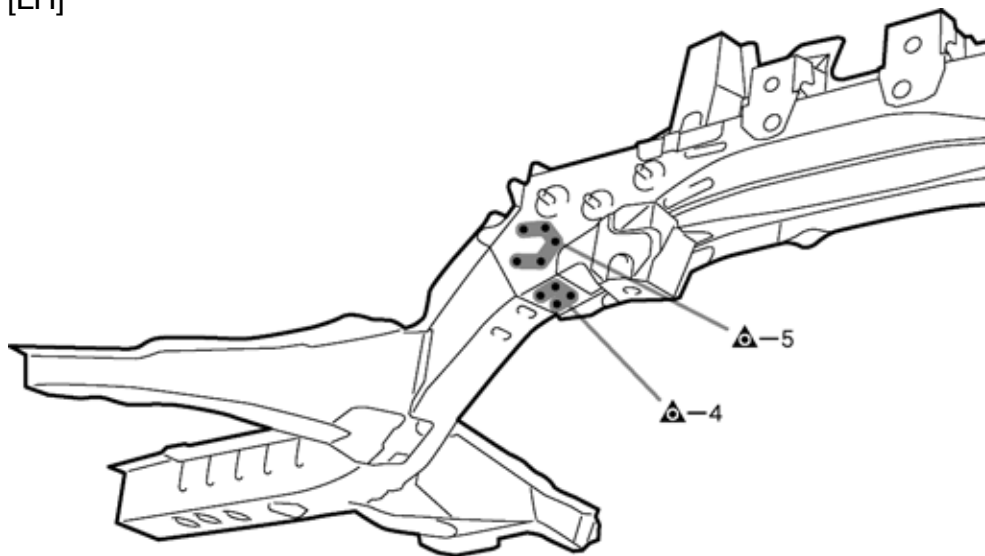
△ : Remove Weld Pints

◻ : MIG Plug Weld

F24664B

INSTALLATION

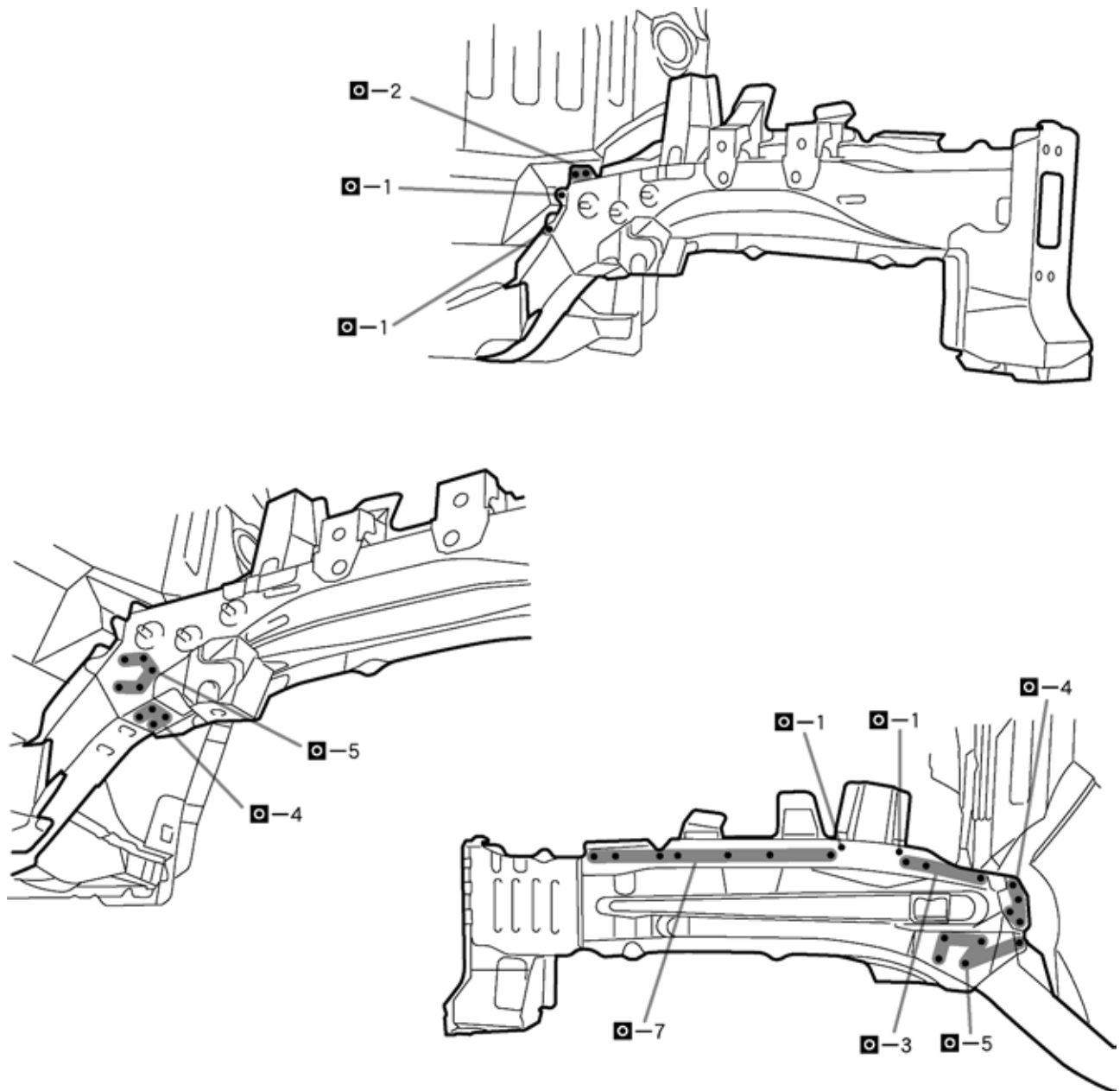
[LH]



F24664

INSTALLATION POINT

- 1 Remove the front part from a new front side member.



CAUTION

Make sure each measurement is correct, as this part affect the front wheel alignment.

F24665

INSTALLATION POINT

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

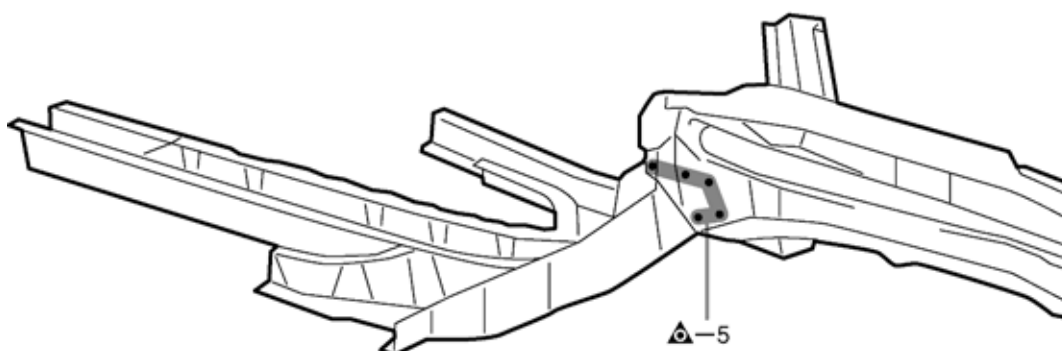
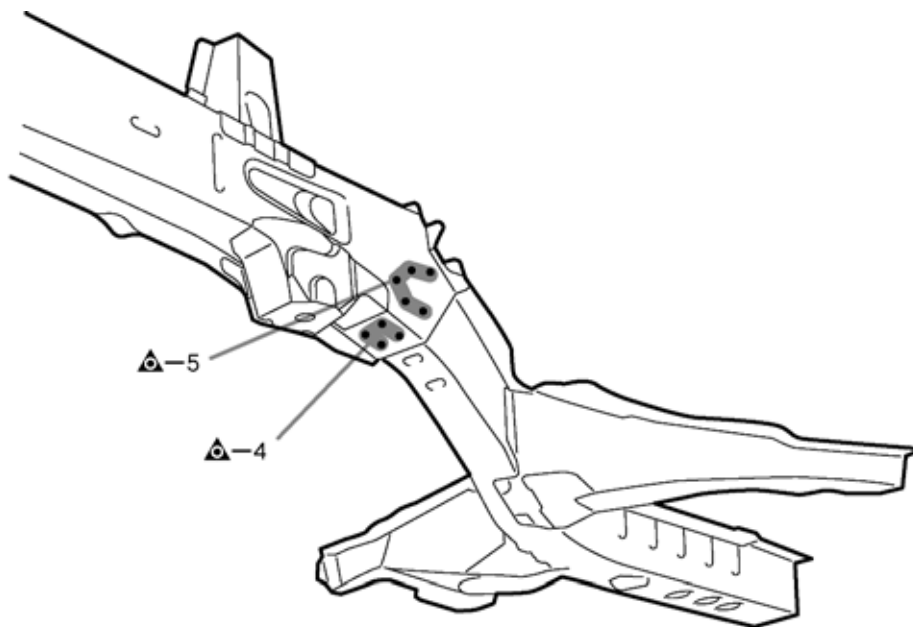
Symbol meaning

△ : Remove Weld Pints

◻ : MIG Plug Weld

F24666B

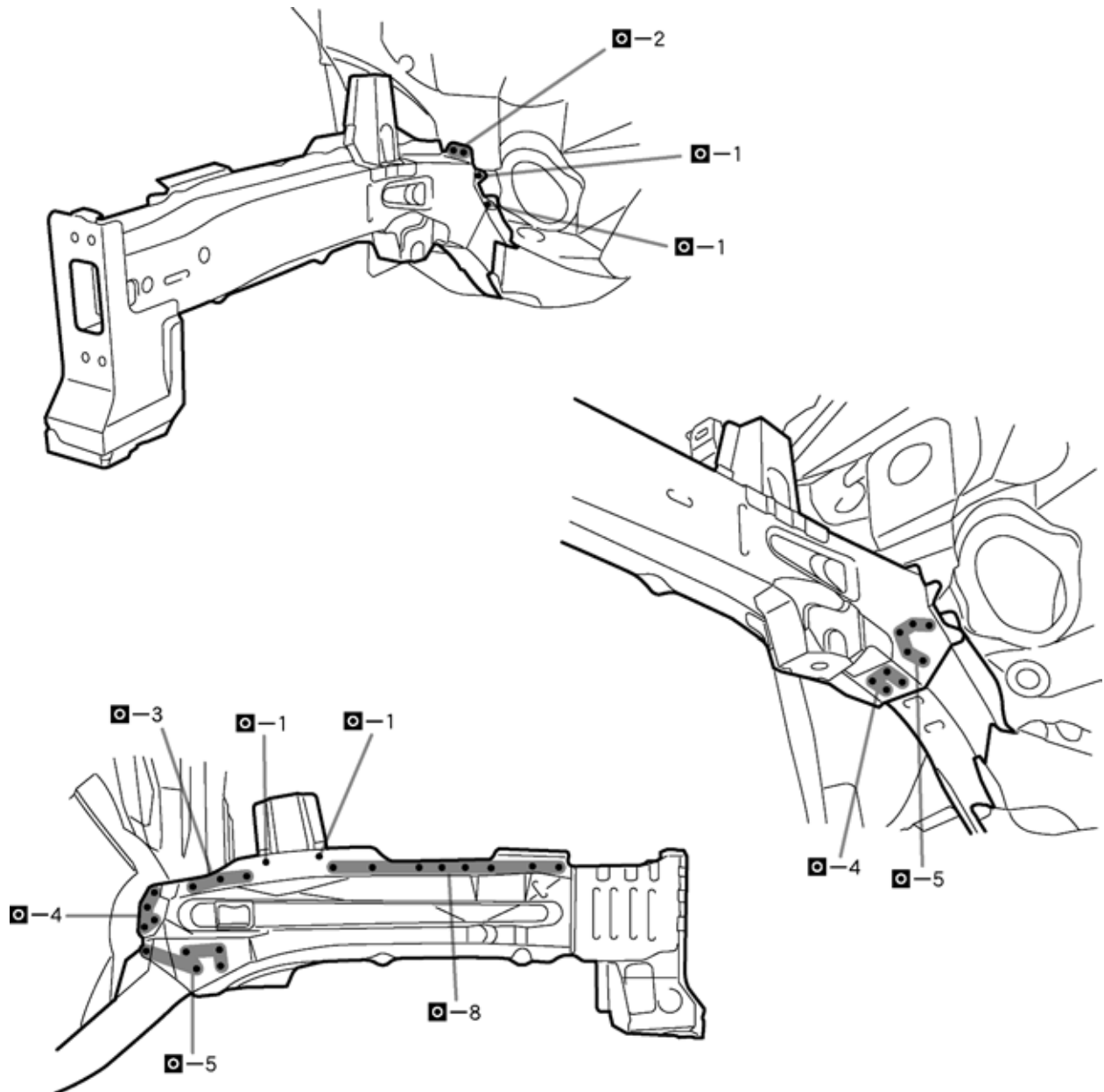
[RH]



F24666

INSTALLATION POINT

- 1 Remove the front part form a new front side member.



CAUTION

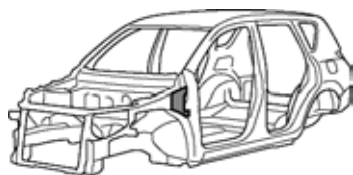
Make sure each measurement is correct, as this part affect the front wheel alignment.

F24667

INSTALLATION POINT

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

COWL TOP SIDE PANEL (ASSY)



F24668A

Symbol meaning

REMOVAL

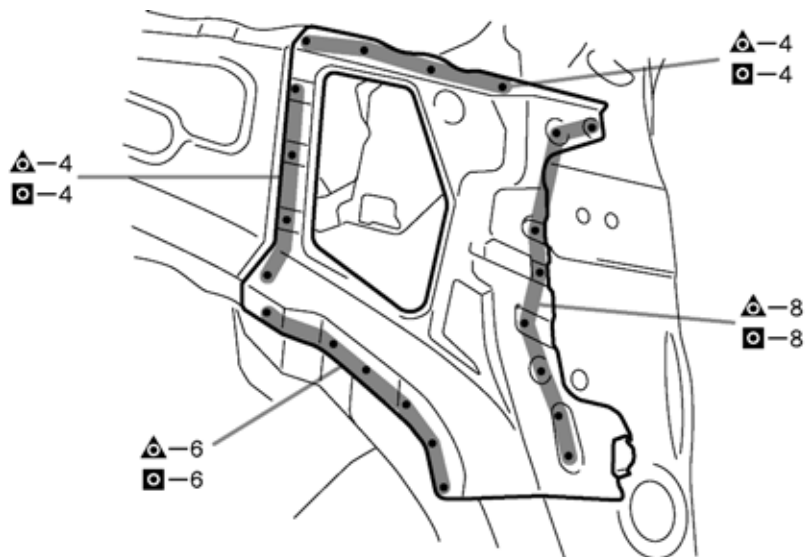
△ : Remove Weld Points

INSTALLATION

◻ : MIG Plug Weld

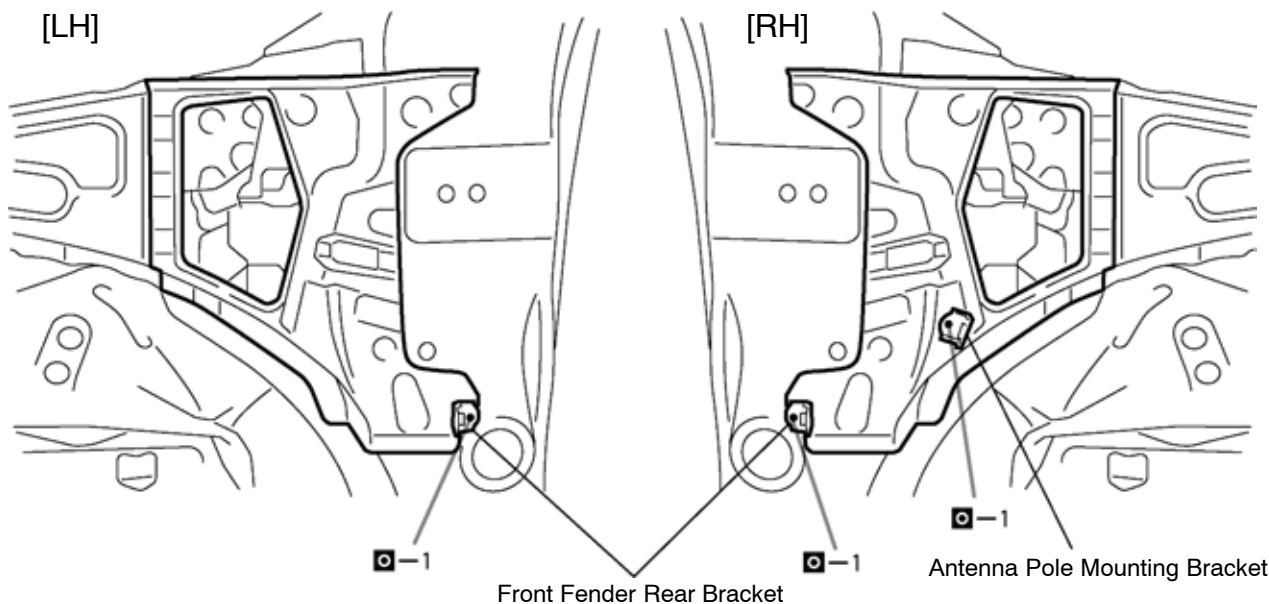
F24668B

REMOVAL-INSTALLATION



[LH]

[RH]



Front Fender Rear Bracket

Antenna Pole Mounting Bracket

F24668

INSTALLATION POINT

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

COWL TOP SIDE UPPER PANEL (ASSY)



F24669A

Symbol meaning

REMOVAL

△ : Remove Weld Points



: Cut with disc sander, etc

INSTALLATION

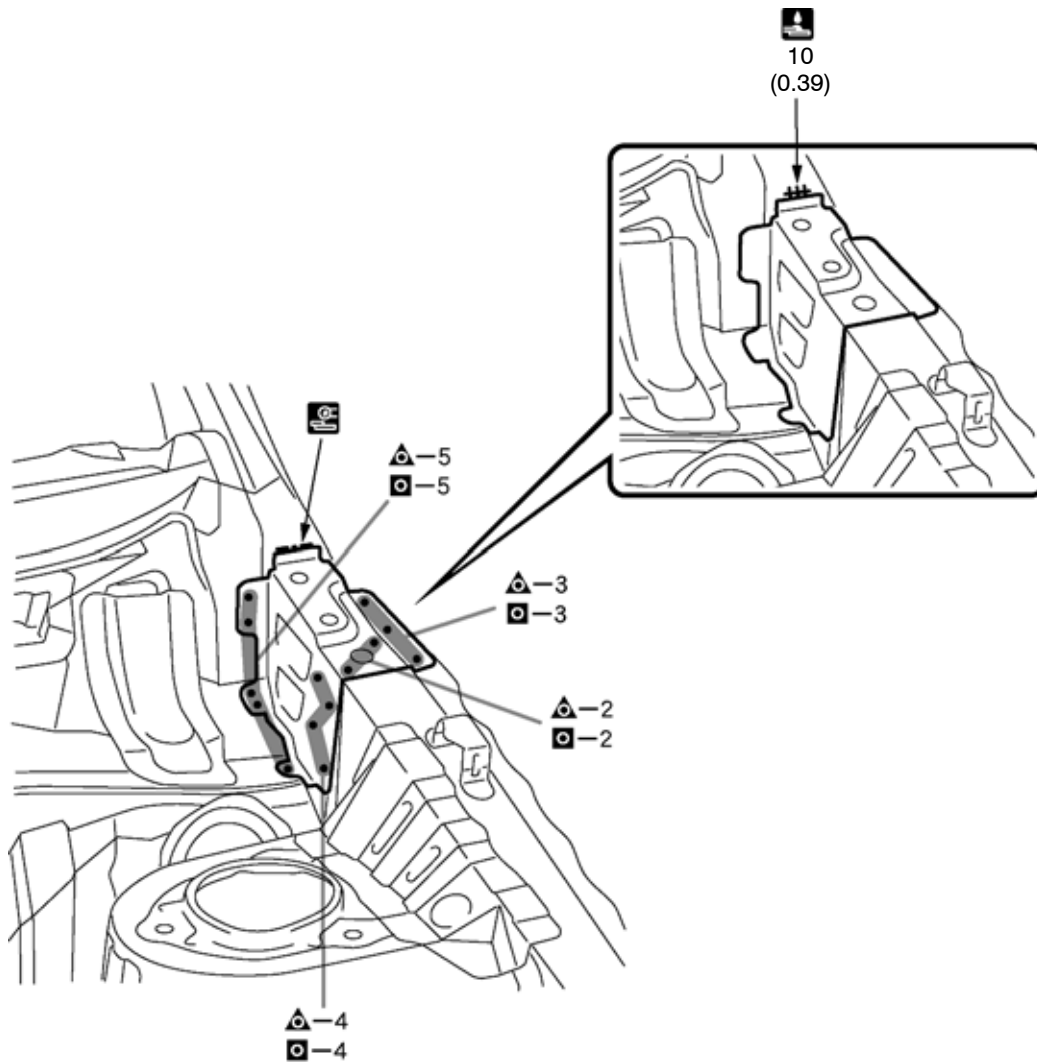
◻ : MIG Plug Weld



: Tack Weld

F24669B

REMOVAL-INSTALLATION



mm (in.)

F24669

INSTALLATION POINT

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

FRONT BODY PILLAR (CUT)



F24670A

With the cowl top side panel and cowl top side upper panel removed.

Symbol meaning

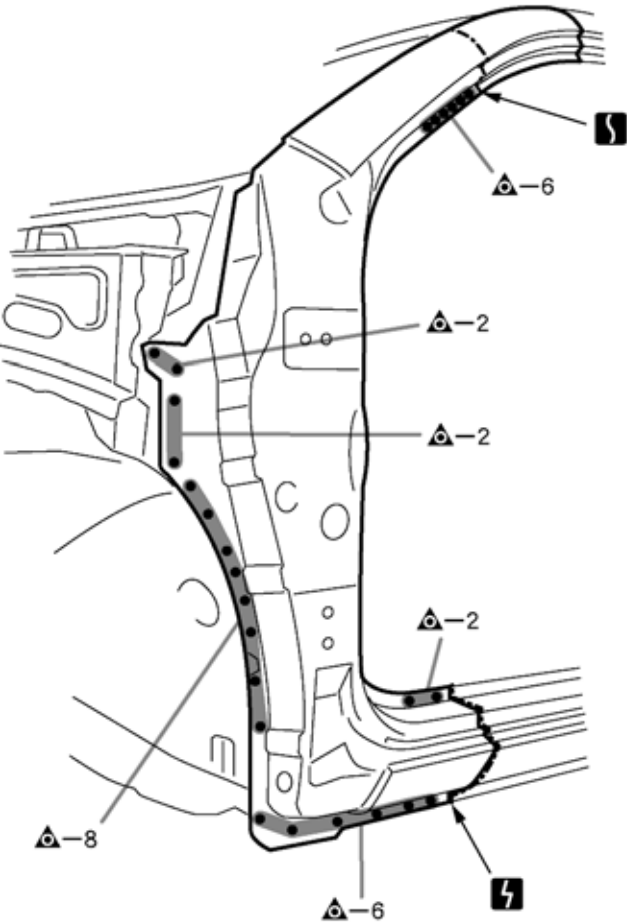
   : Remove Weld Points

 : Cut and join Location

 : Cut Location for supply parts

F24670B

REMOVAL



 -6

 -2

 -2

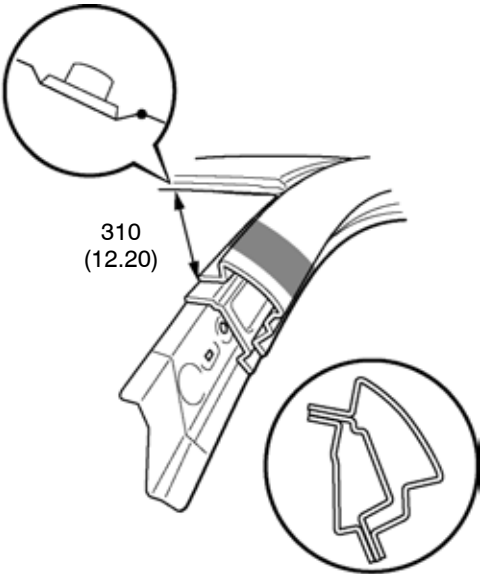
 -2

 -8

 -6

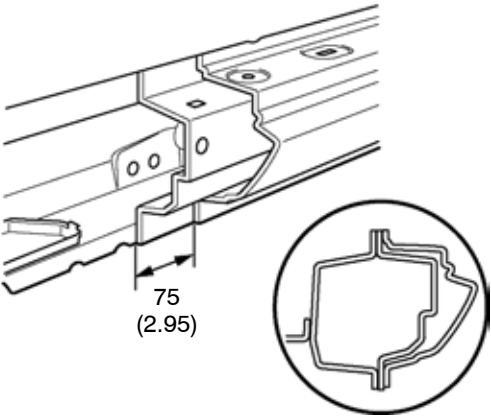






310
(12.20)



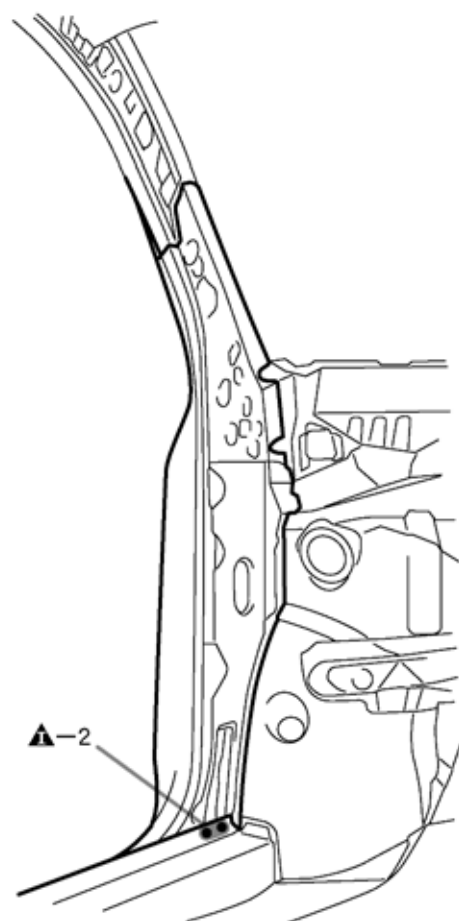
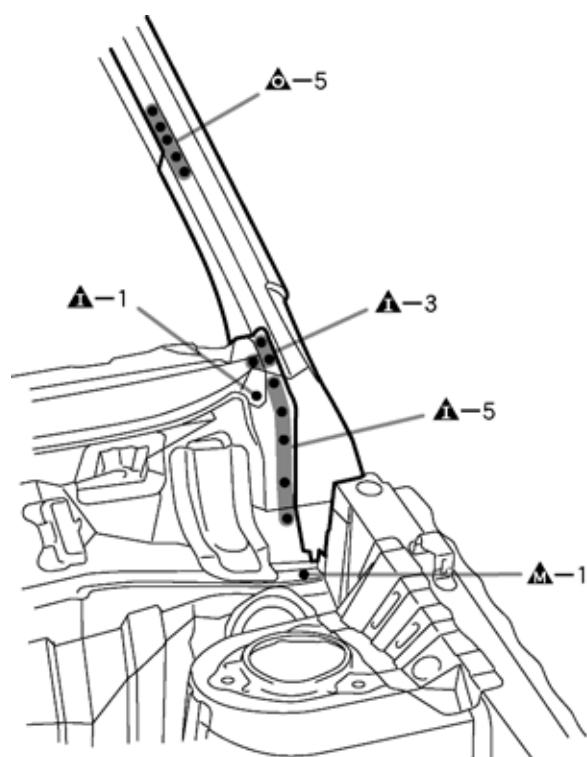


75
(2.95)



mm (in.)

F24670



Symbol meaning



: Cut and join Location



M I : MIG Plug Weld



: Spot Weld



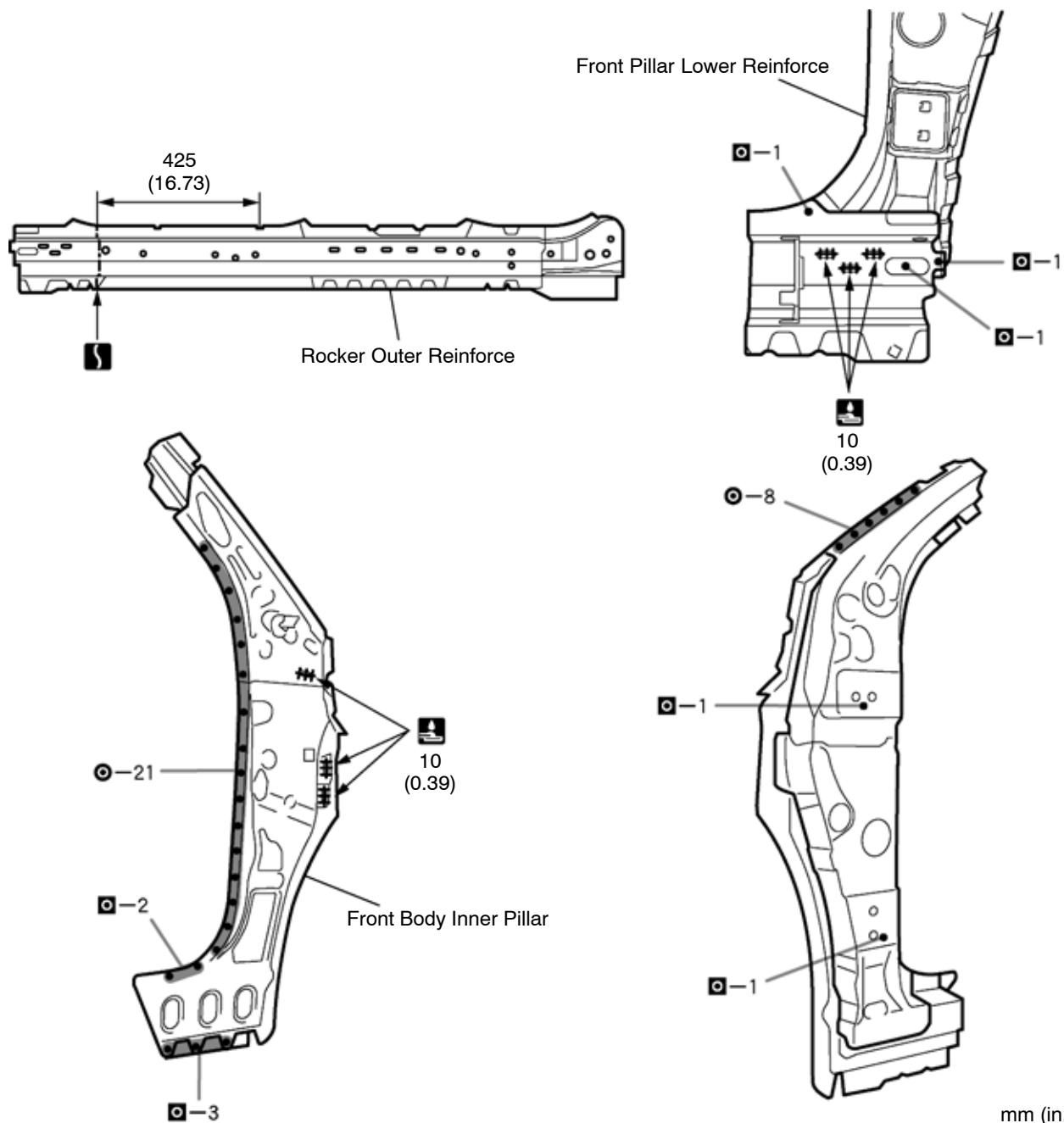
: Tack Weld



: Butt Weld

F24672B

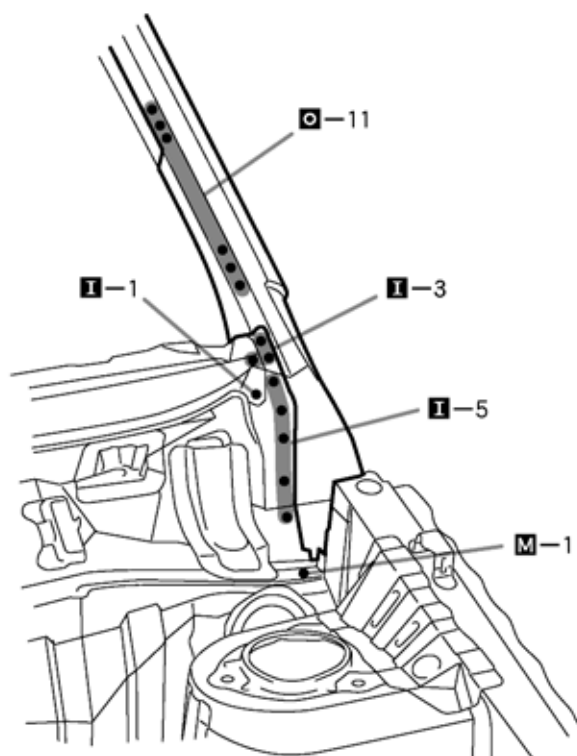
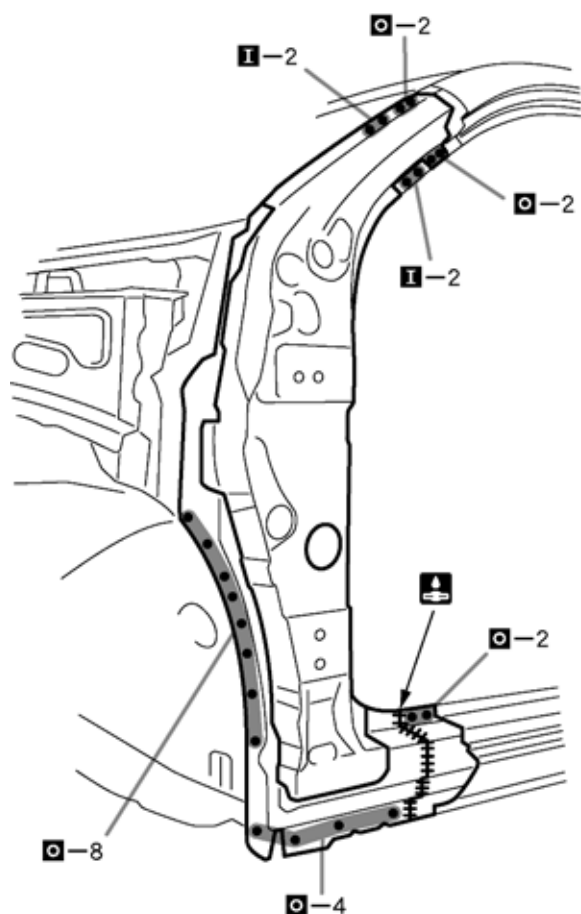
INSTALLATION



F24672

INSTALLATION POINT

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



F24673

INSTALLATION POINT

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

Symbol meaning



: Cut and join Location



: MIG Plug Weld



: Spot Weld

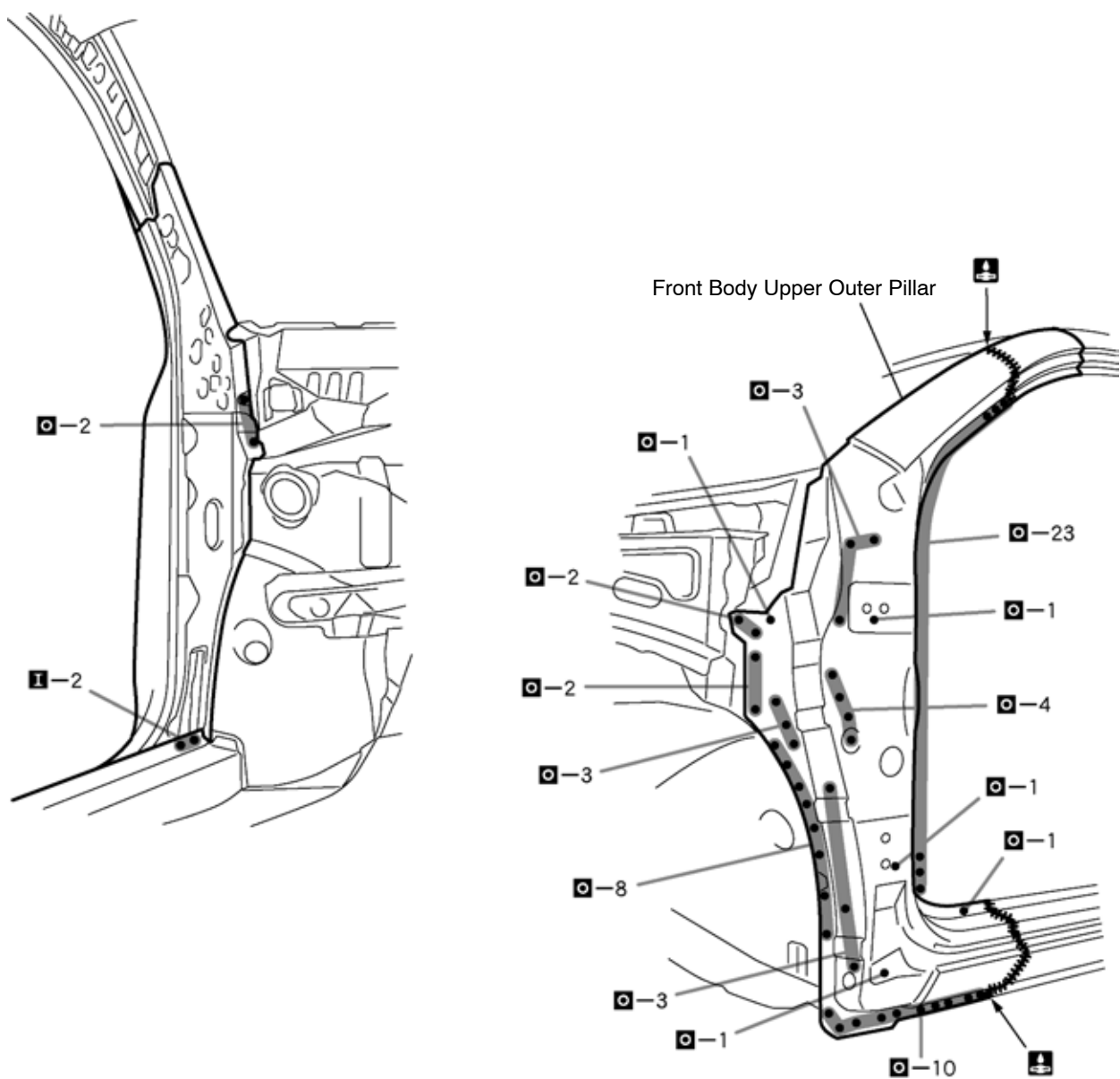


: Tack Weld



: Butt Weld

F24674B



F24674

INSTALLATION POINT

- 1 After welding the rocker outer reinforce, front pillar lower reinforcement and front body inner pillar to the vehicle side, install the front body upper outer pillar.
- 2 After welding, apply the polyurethane foam to the corresponding parts. (See the paint-coating)
- 3 After welding, apply body sealer and undercoating to the corresponding parts. (See the paint-coating)
- 4 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

CENTER BODY PILLAR (CUT): Short Body



F24675A

Symbol meaning

△ △ : Remove Weld Points

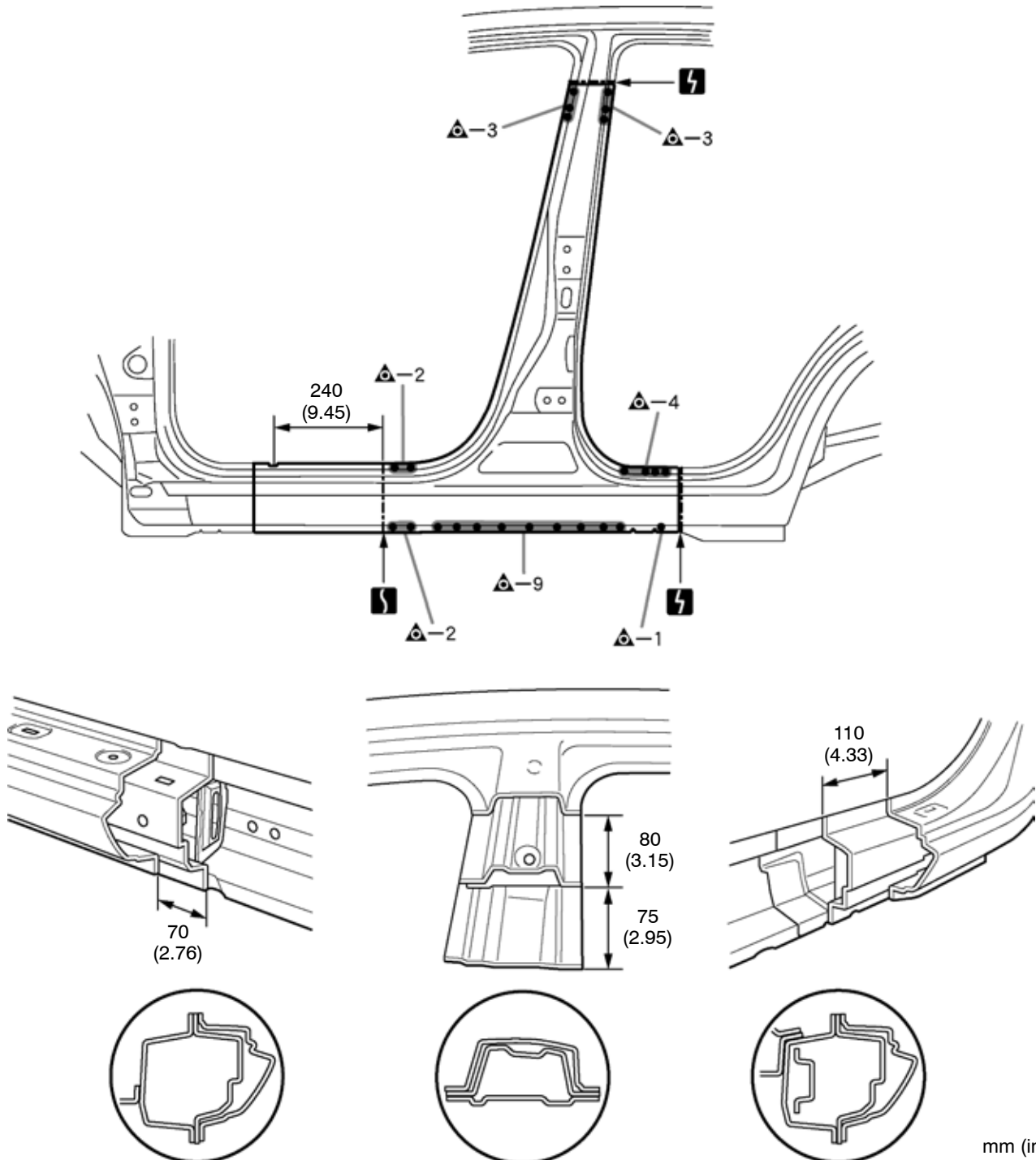
⌋ : Cut and join Location

⚡ : Cut Location for Supply parts

⊙ : Cut with disc sander, etc.

F24675B

REMOVAL



mm (in.)

F24675

Symbol meaning

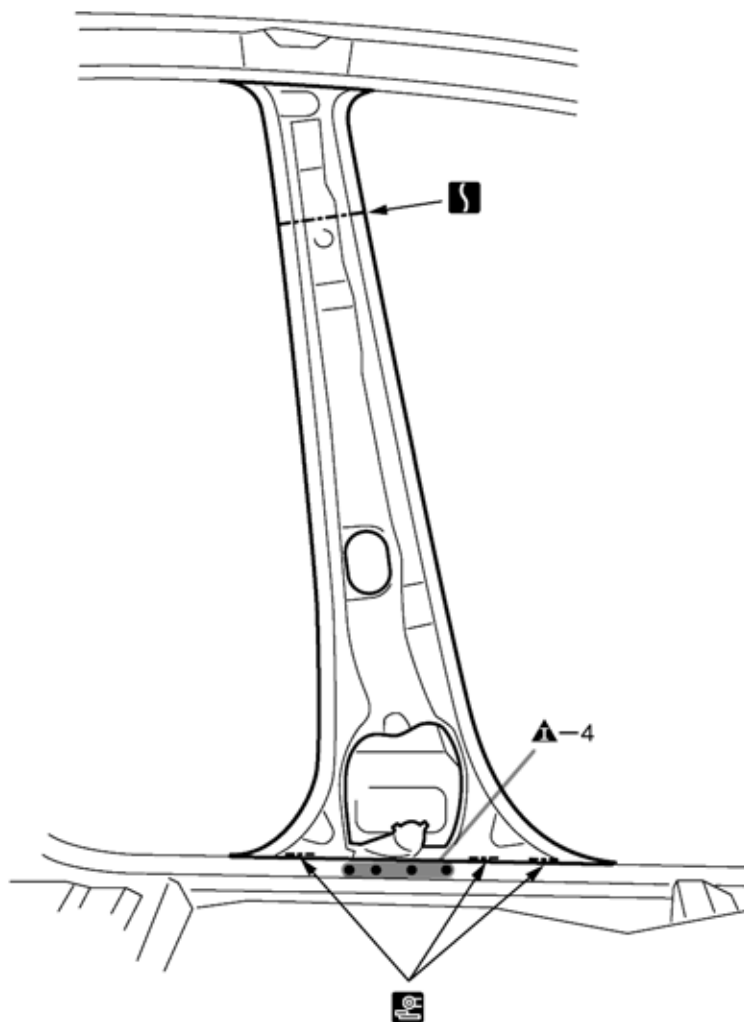
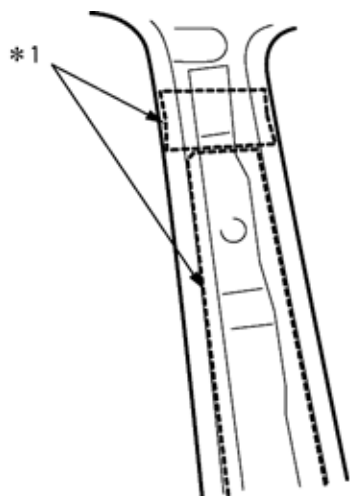
⚠ : Remove Weld Points

✂ : Cut and join Location

⚡ : Cut Location for Supply parts

⊙ : Cut with disc sander, etc.

F24676B



F24676

REMOVAL POINT

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

Symbol meaning



: Cut and join Location



: MIG Plug Weld



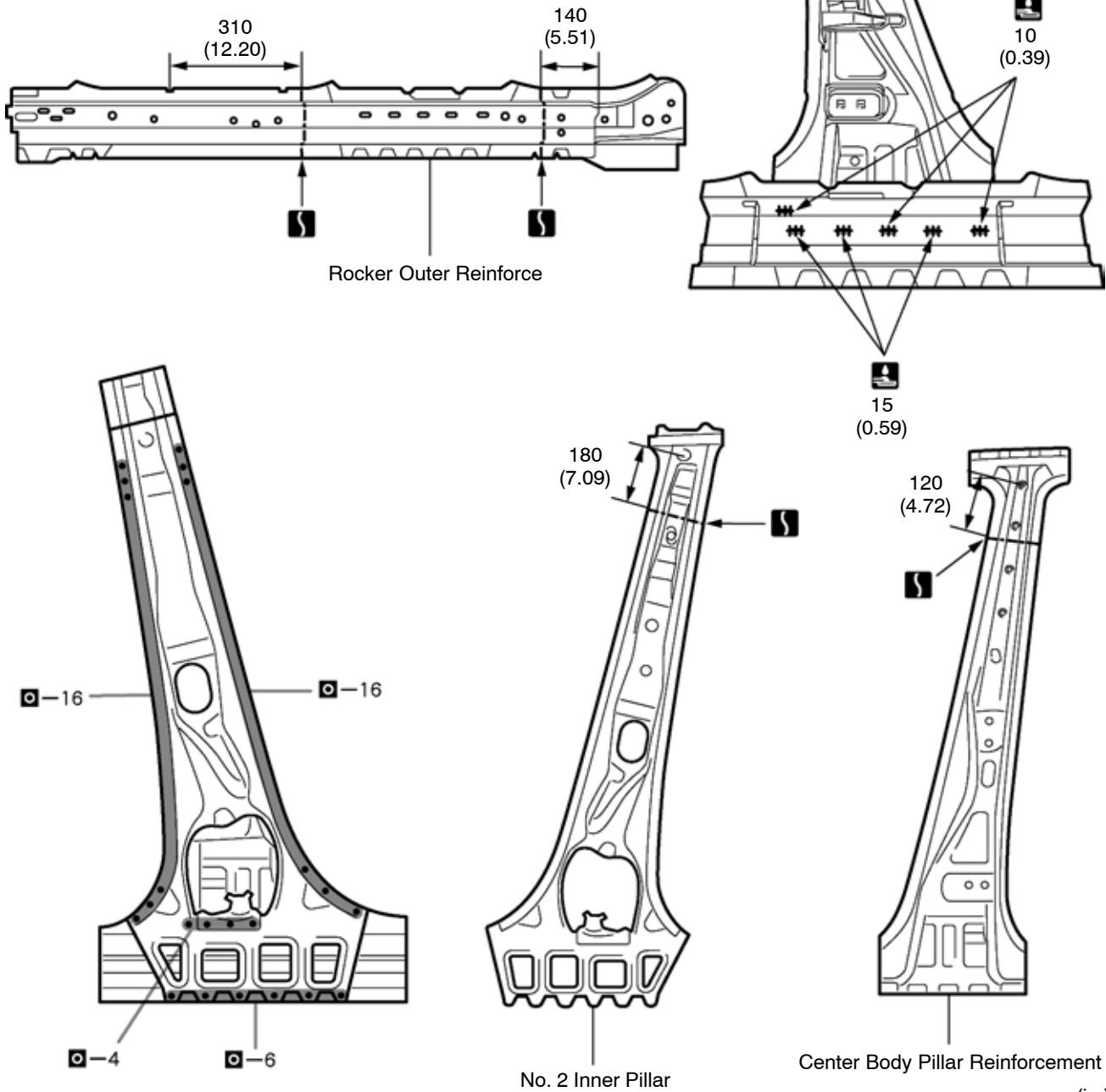
: Tack Weld



: Butt Weld

F24677B

INSTALLATION



F24677

INSTALLATION POINT

- 1 Before temporarily installing the new parts, weld the rocker outer reinforce, center body pillar reinforcement and No. 2 inner pillar with the standard number of welding points.

Symbol meaning



: Cut and join Location



: MIG Plug Weld

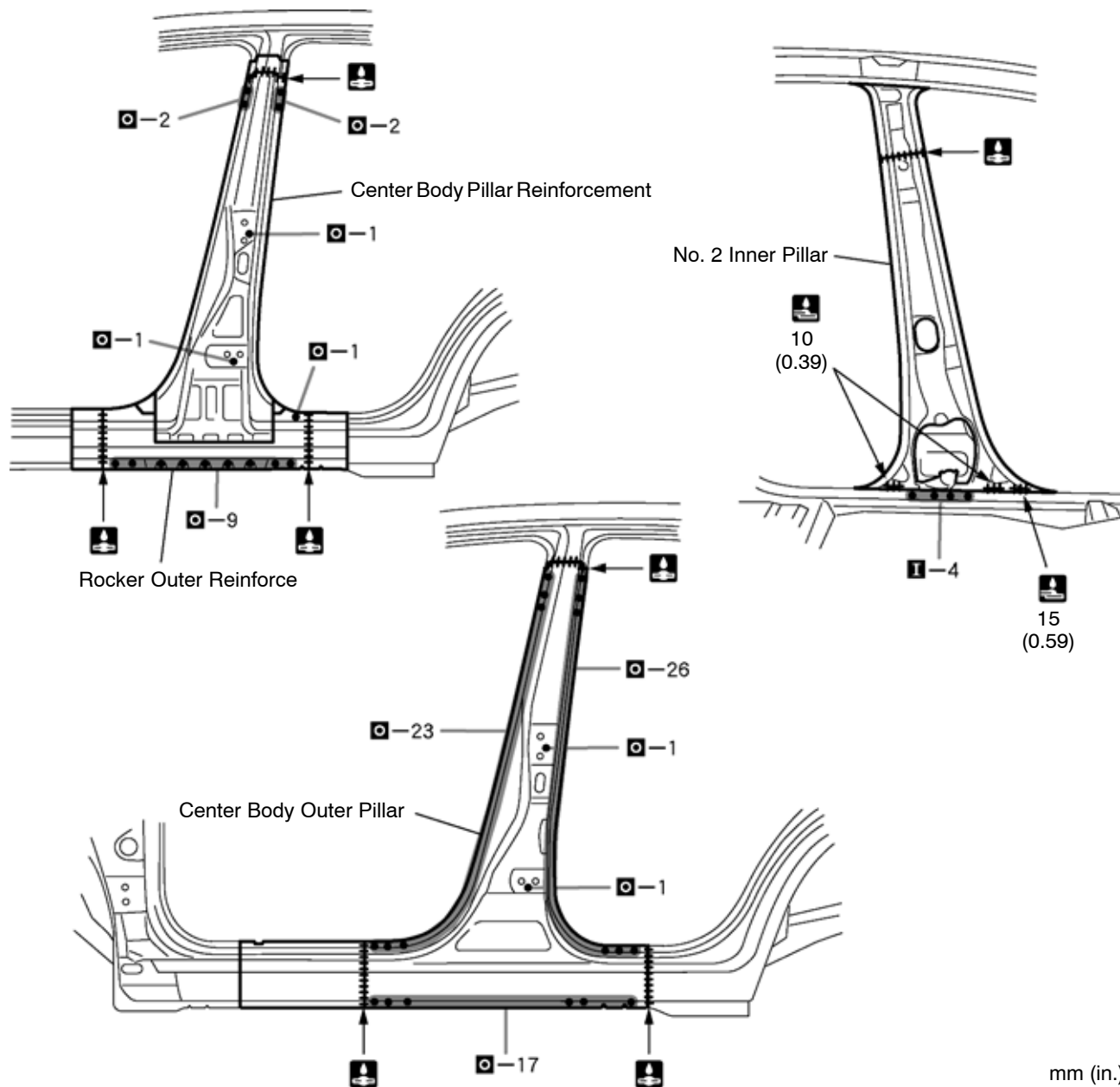


: Tack Weld



: Butt Weld

F24678B



F24678B

INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 After welding, apply the polyurethane foam to the corresponding parts. (See the paint-coating)
- 4 After welding, apply body sealer and undercoating to the corresponding parts. (See the paint-coating)
- 5 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.
- 6 After welding, the rocker outer reinforce, center body pillar reinforcement and No. 2 inner pillar to the vehicle side, install the center body outer pillar.

CENTER BODY PILLAR (CUT): Long Body



F24679A

Symbol meaning

△△ : Remove Weld Points

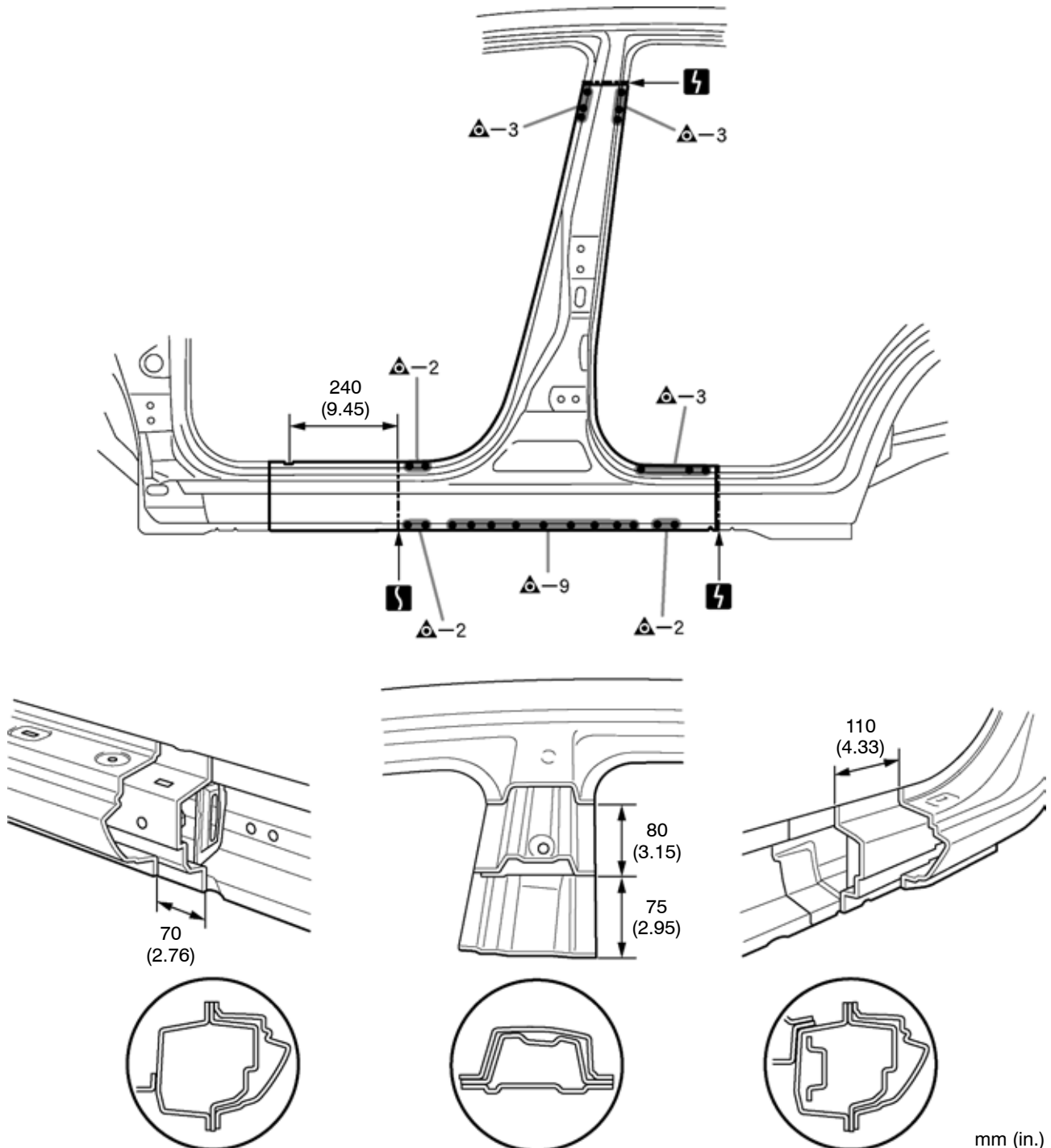
⌋ : Cut and join Location

⚡ : Cut Location for Supply parts

⊙ : Cut with disc sander, etc.

F24679A

REMOVAL



mm (in.)

F24679

Symbol meaning

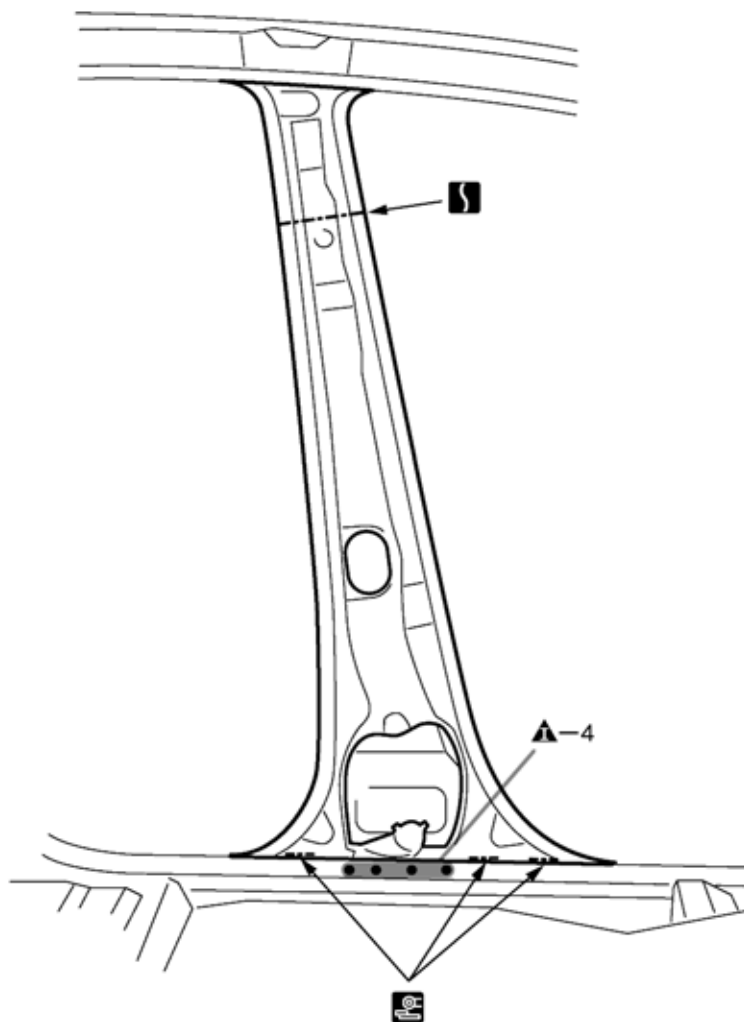
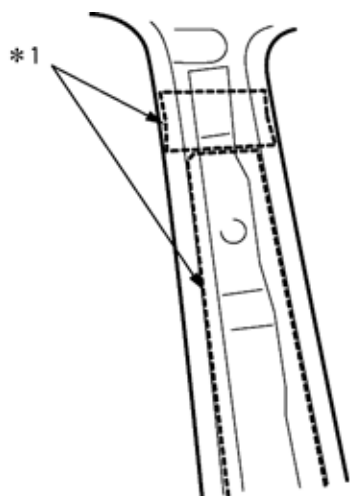
⚠ ⚠ : Remove Weld Points

✂ : Cut and join Location

⚡ : Cut Location for Supply parts

⊙ : Cut with disc sander, etc.

F24680B



F24680

REMOVAL POINT

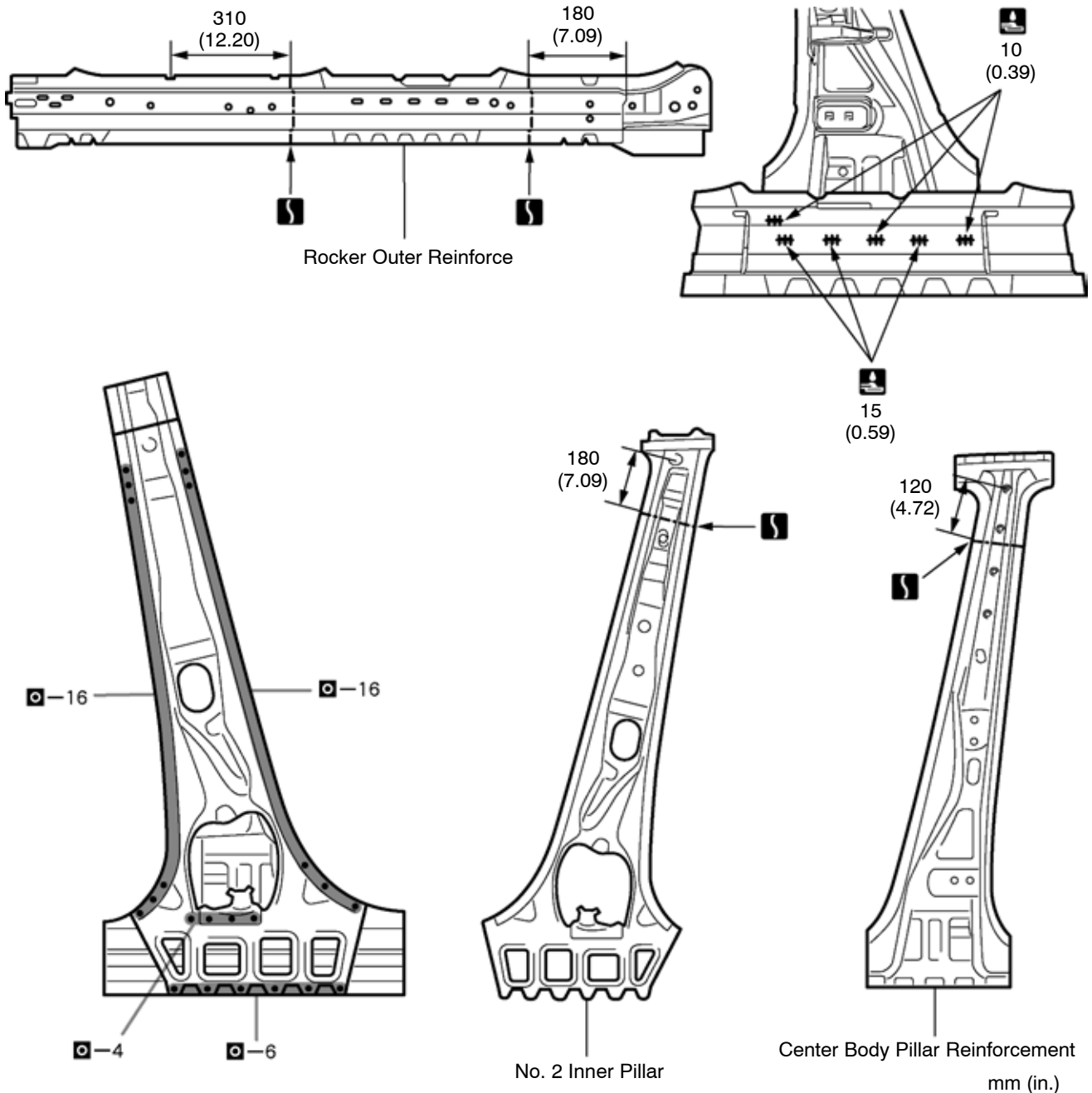
1 *1: Take care not to damage the internal reinforcement.

Symbol meaning

 : Cut and join Location
  : MIG Plug Weld
  : Tack Weld
  : Butt Weld

F24681B

INSTALLATION



F24681

INSTALLATION POINT

- 1 Before temporarily installing the new parts, weld the rocker outer reinforce, center body pillar reinforcement and No. 2 inner pillar with the standard number of welding points.

Symbol meaning



: Cut and join Location



: MIG Plug Weld

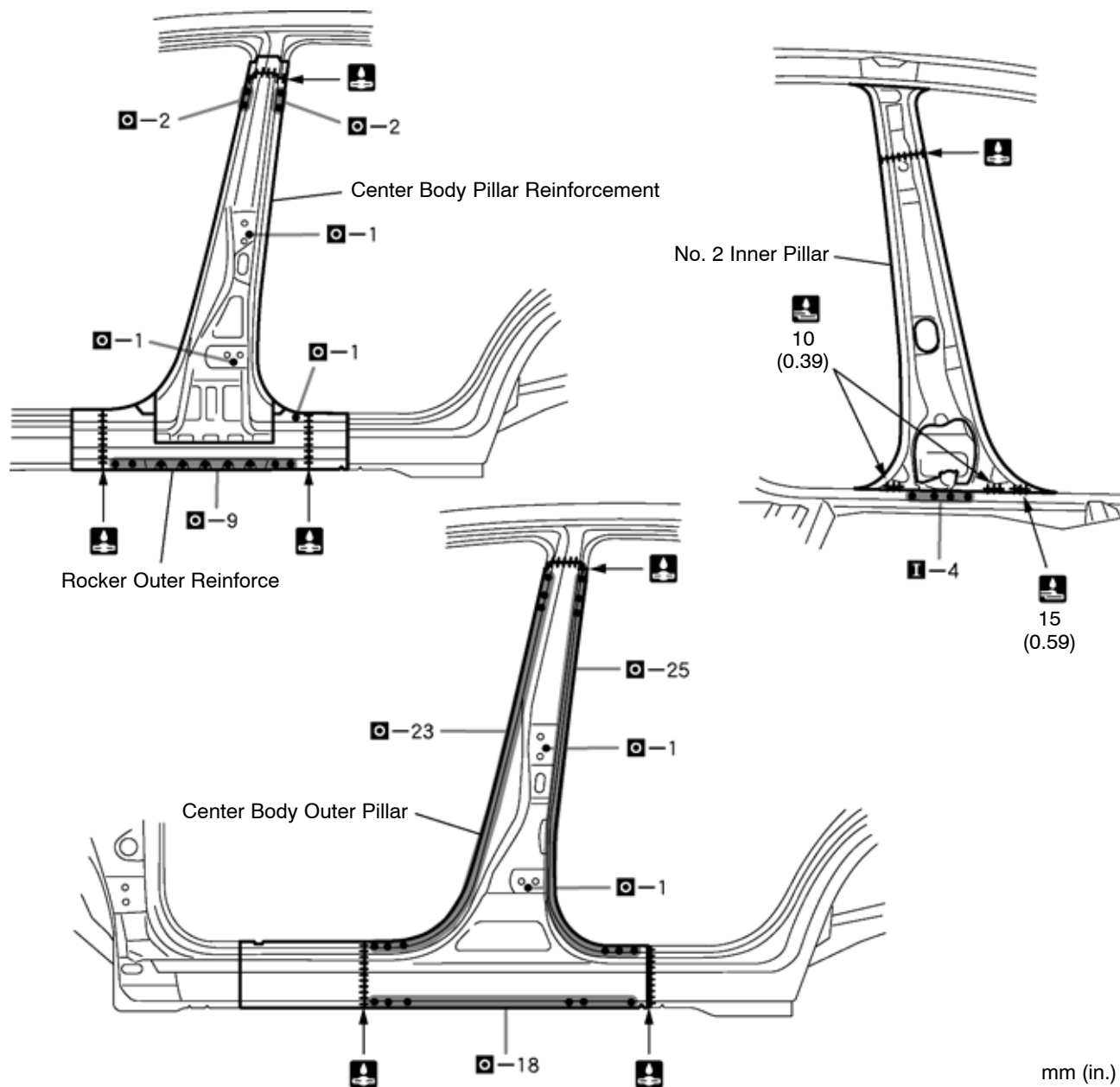


: Tack Weld



: Butt Weld

F24682B

**INSTALLATION POINT**

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 After welding, apply the polyurethane foam to the corresponding parts. (See the paint-coating)
- 4 After welding, apply body sealer and undercoating to the corresponding parts. (See the paint-coating)
- 5 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.
- 6 After welding, the rocker outer reinforce, center body pillar reinforcement and No. 2 inner pillar to the vehicle side, install the center body outer pillar.

FRONT DOOR OUTER PANEL (ASSY)



F24683A

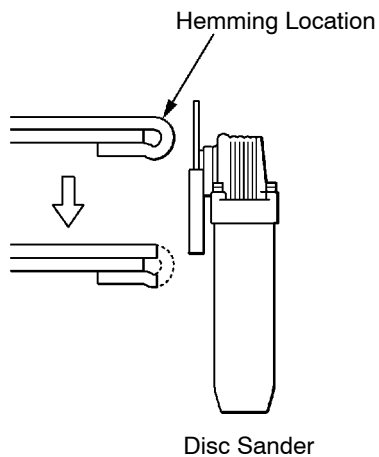
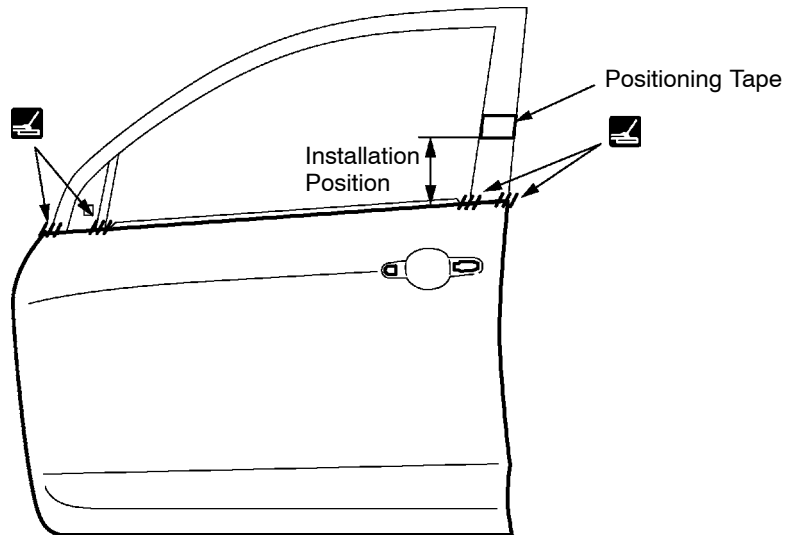
Symbol meaning

+ : Spot MIG Weld

 : Body Sealer

F24683B

REMOVAL



F24683

REMOVAL POINT

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

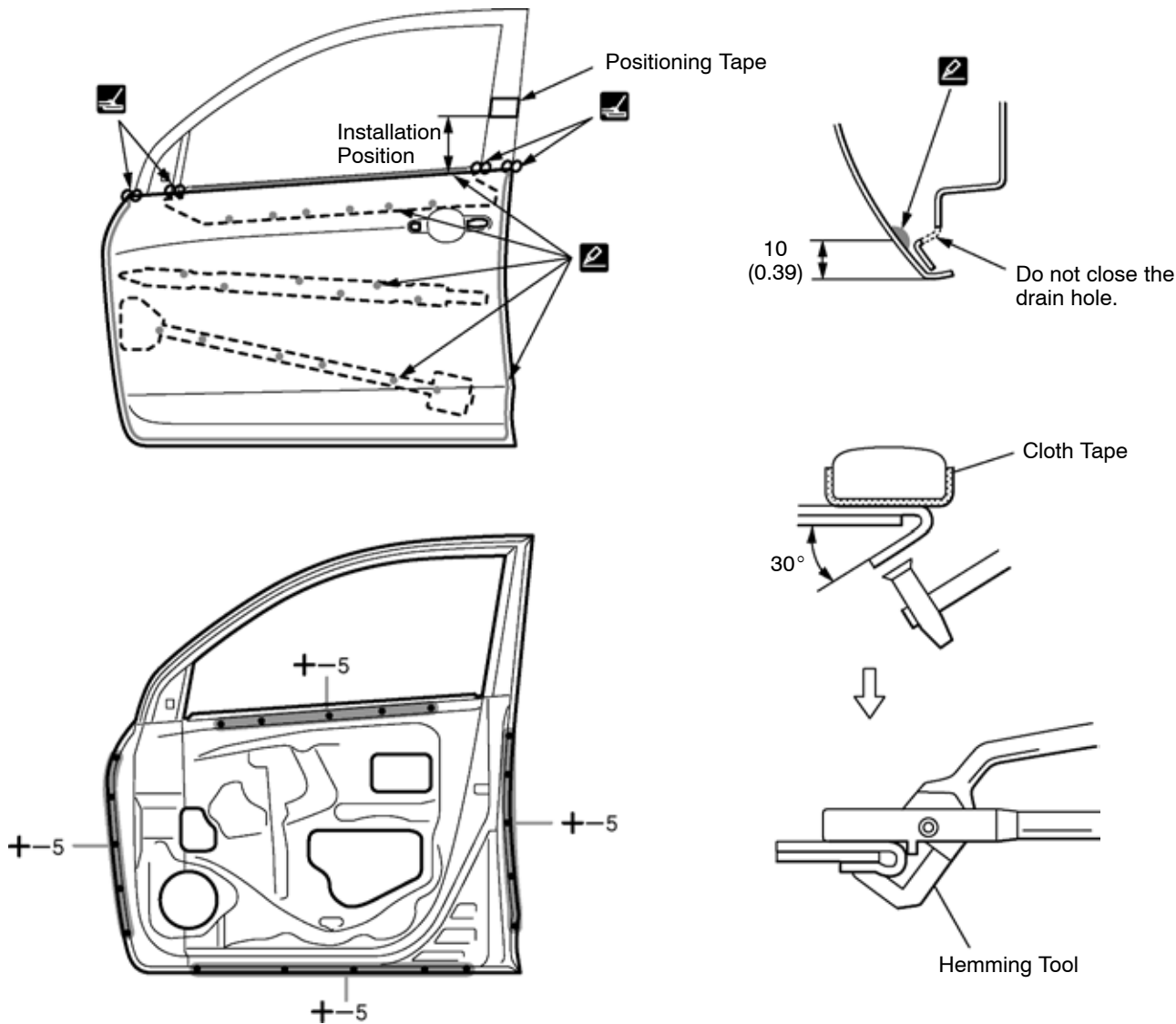
Symbol meaning

+ : Spot MIG Weld

⌒ : Body Sealer

F24684B

INSTALLATION



mm (in.)

F24684

INSTALLATION POINT

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

HINT:

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

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

HINT:

1) Perform hemming in three steps, being careful not to warp the panel.

2) If a hemming tool cannot be used, hem with a hammer and dolly.

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

REAR DOOR OUTER PANEL (ASSY): Short Body



F24685A

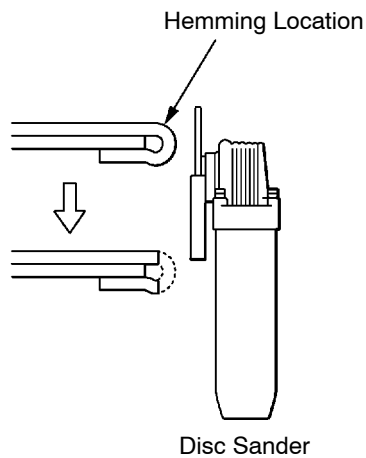
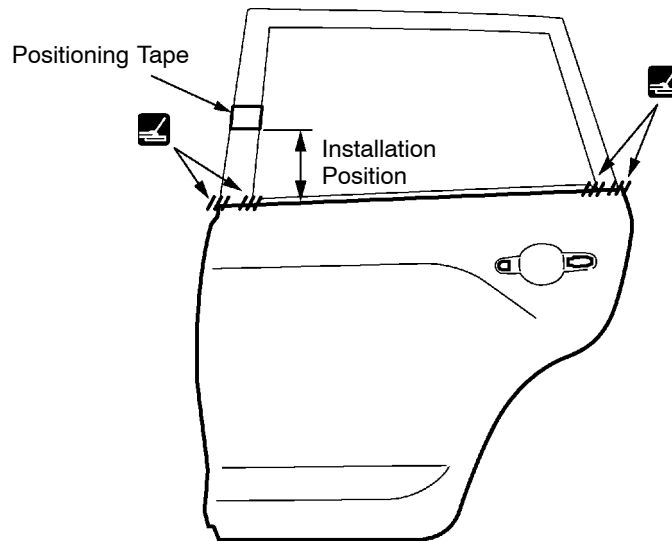
Symbol meaning

+ : Spot MIG Weld

 : Body Sealer

F24685B

REMOVAL



F24685

REMOVAL POINT

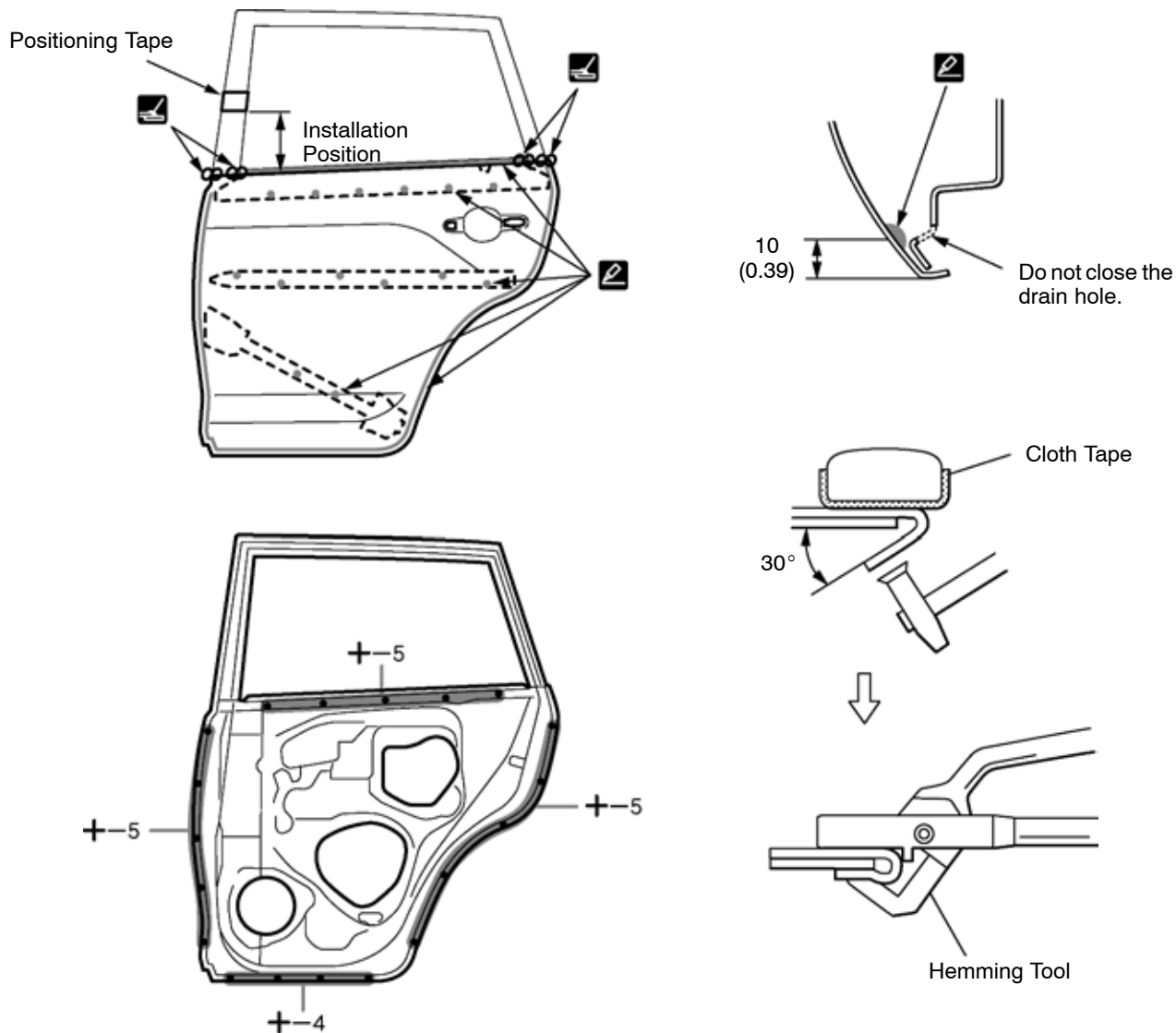
- 1 Before removing the outer panel, mark the installation position with tape.
- 2 Before removing the outer panel, establish its exact position in relation to the window frame using a reference marker, etc.
- 3 After grinding off the hemming location, remove the outer panel.

Symbol meaning

⊕ : Spot MIG Weld  : Body Sealer

F24686B

INSTALLATION



mm (in.)

F24686

INSTALLATION POINT

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

HINT:

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

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

HINT:

1) Perform hemming in three steps, being careful not to warp the panel.

2) If a hemming tool cannot be used, hem with a hammer and dolly.

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

REAR DOOR OUTER PANEL (ASSY): Long Body



F24687A

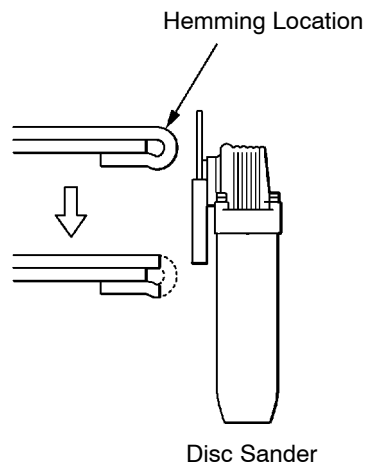
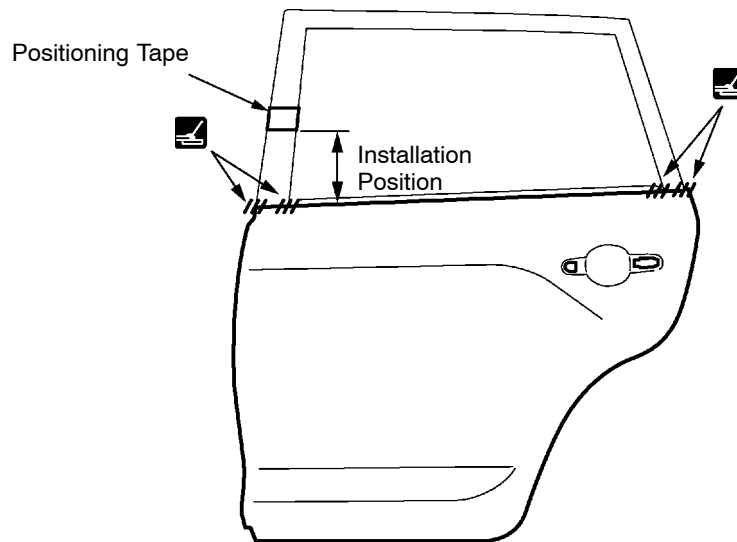
Symbol meaning

+ : Spot MIG Weld

 : Body Sealer

F24687B

REMOVAL



F24687

REMOVAL POINT

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

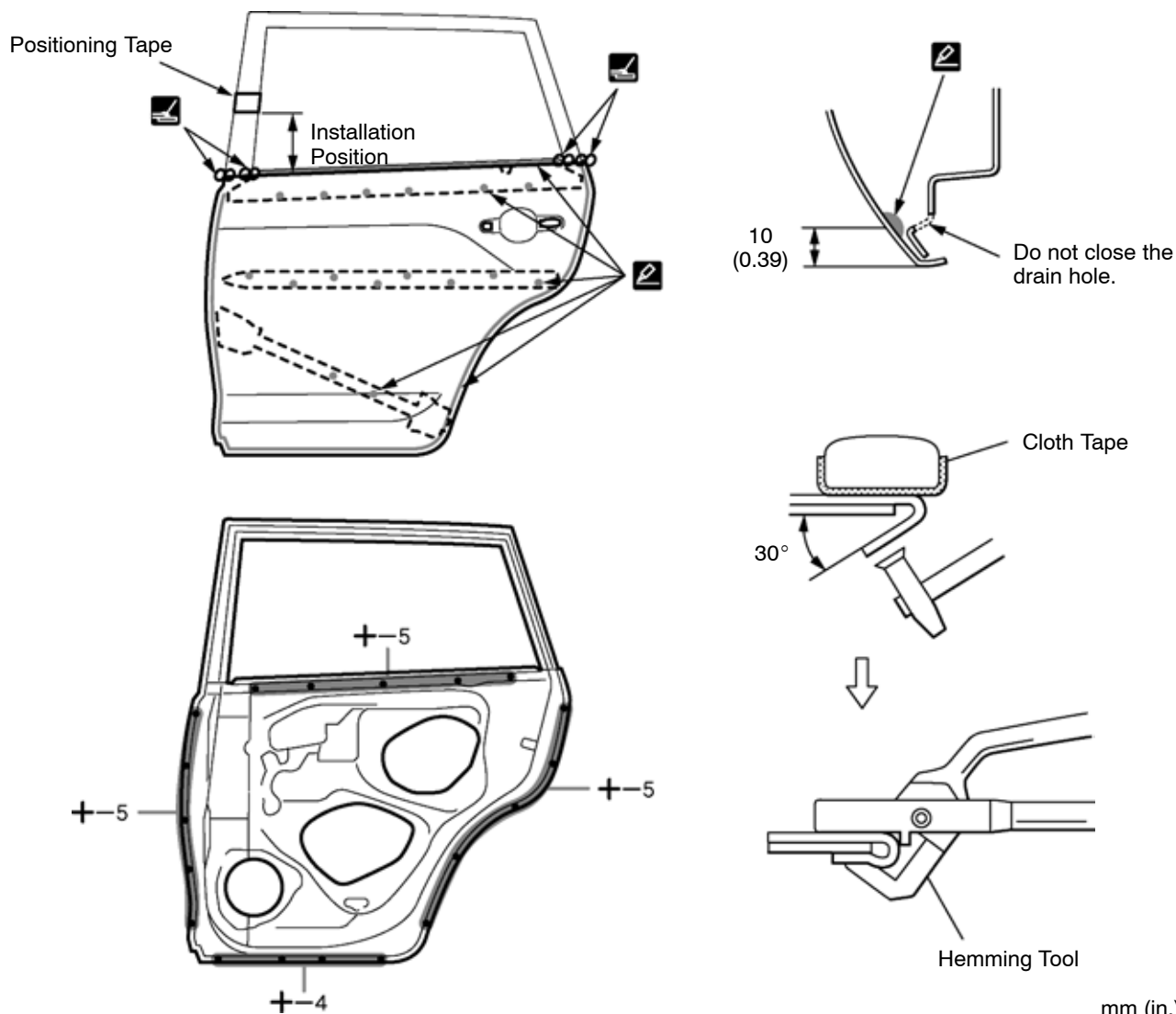
Symbol meaning

+ : Spot MIG Weld

[Symbol] : Body Sealer

F24688B

INSTALLATION



F24688B

INSTALLATION POINT

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

HINT:

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

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

HINT:

1) Perform hemming in three steps, being careful not to warp the panel.

2) If a hemming tool cannot be used, hem with a hammer and dolly.

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

ROCKER OUTER PANEL (CUT-P)



F24689A

Symbol meaning

REMOVAL

△ : Remove Weld Points

INSTALLATION

□ : MIG Plug Weld

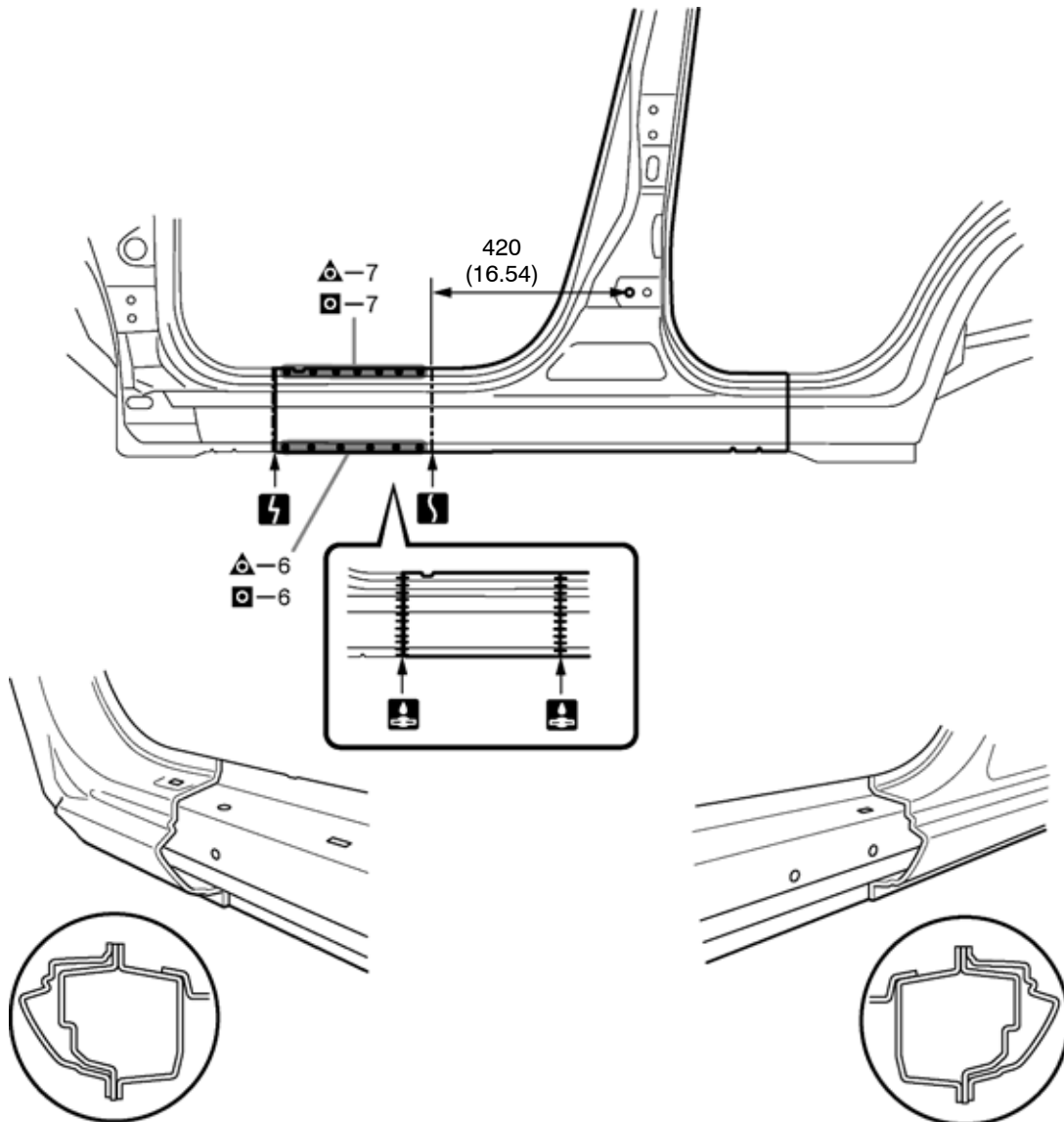
⚡ : Cut and Join Location

⚡ : Cut Location for Supply Parts

⚡ : Butt Weld

F24689B

REMOVAL·INSTALLATION



mm (in.)

F24689

INSTALLATION POINT

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

ROCKER OUTER PANEL (CUT): Short Body



F24690A

Symbol meaning

REMOVAL

△ : Remove Weld Points

INSTALLATION

⊙ : MIG Plug Weld

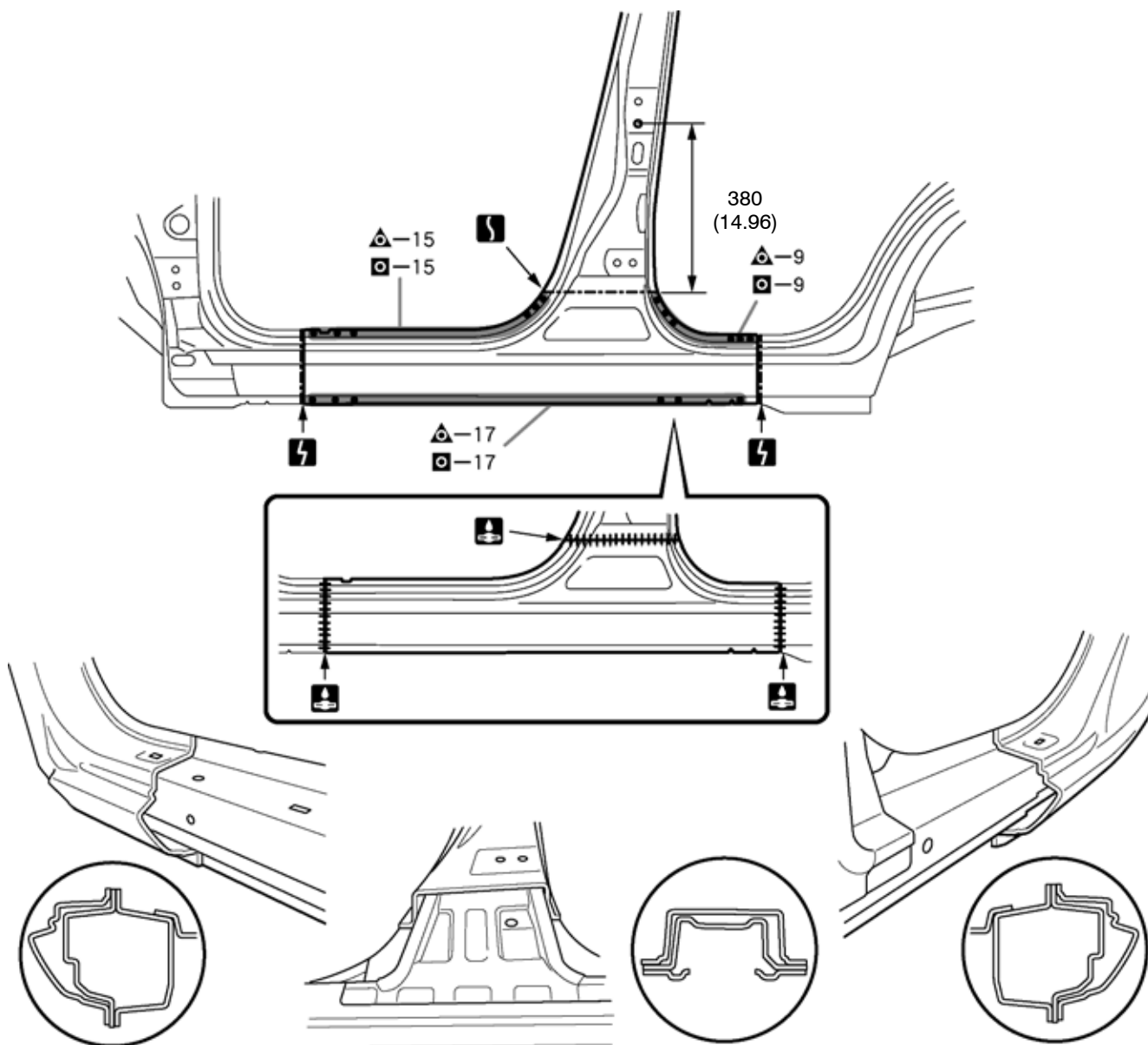
⌋ : Cut and Join Location

⚡ : Cut Location for Supply Parts

⌋ : Butt Weld

F24690B

REMOVAL-INSTALLATION



F24690

INSTALLATION POINT

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

ROCKER OUTER PANEL (CUT-P): Long Body



F24691A

Symbol meaning

REMOVAL

△ : Remove Weld Points

INSTALLATION

⊙ : MIG Plug Weld

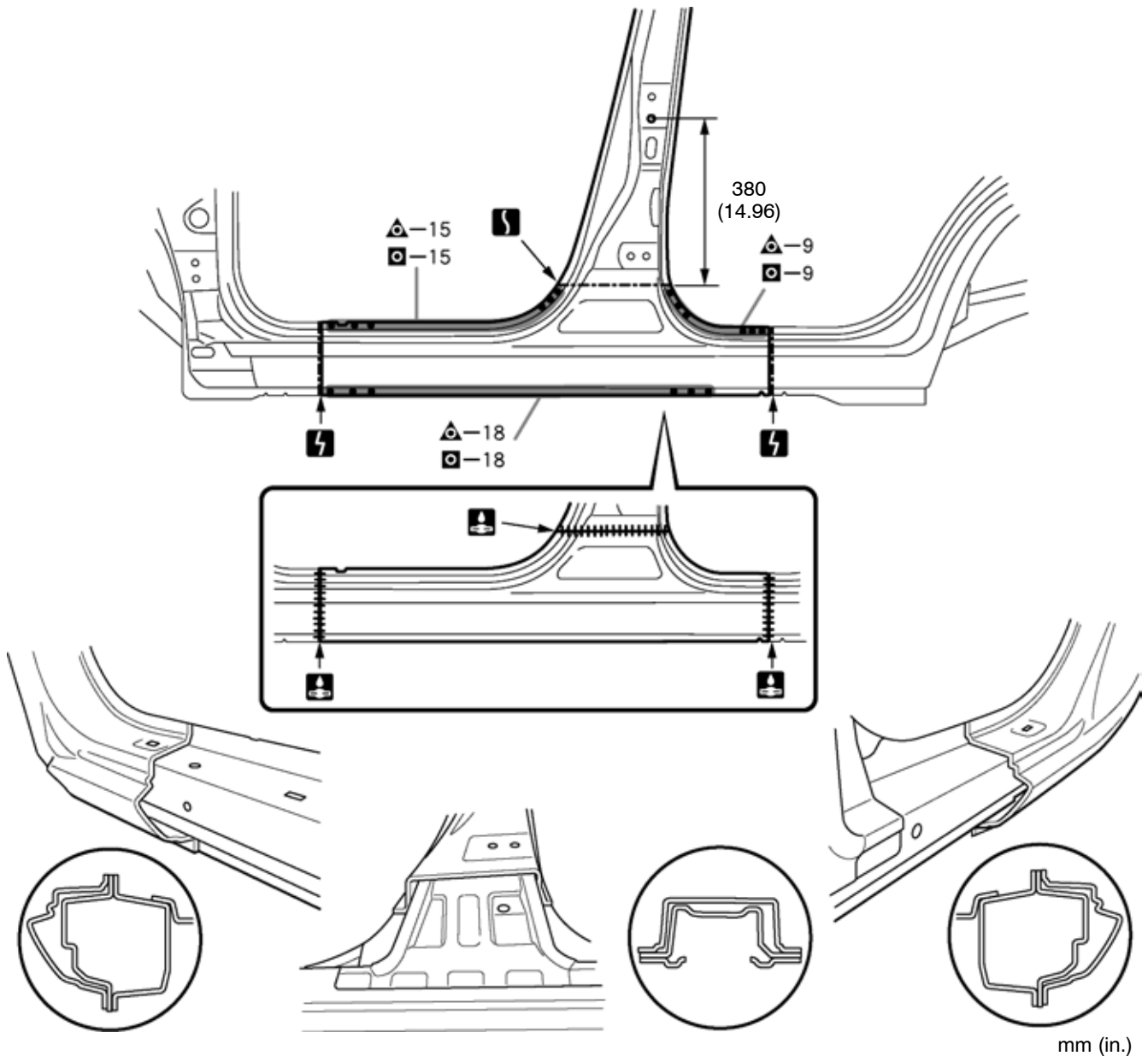
⌋ : Cut and Join Location

⚡ : Cut Location for Supply Parts

⌋ : Butt Weld

F24691B

REMOVAL·INSTALLATION



mm (in.)

F24691

INSTALLATION POINT

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

QUARTER PANEL (CUT): Short Body



F24692A

Symbol meaning

△ : Remove Weld Points

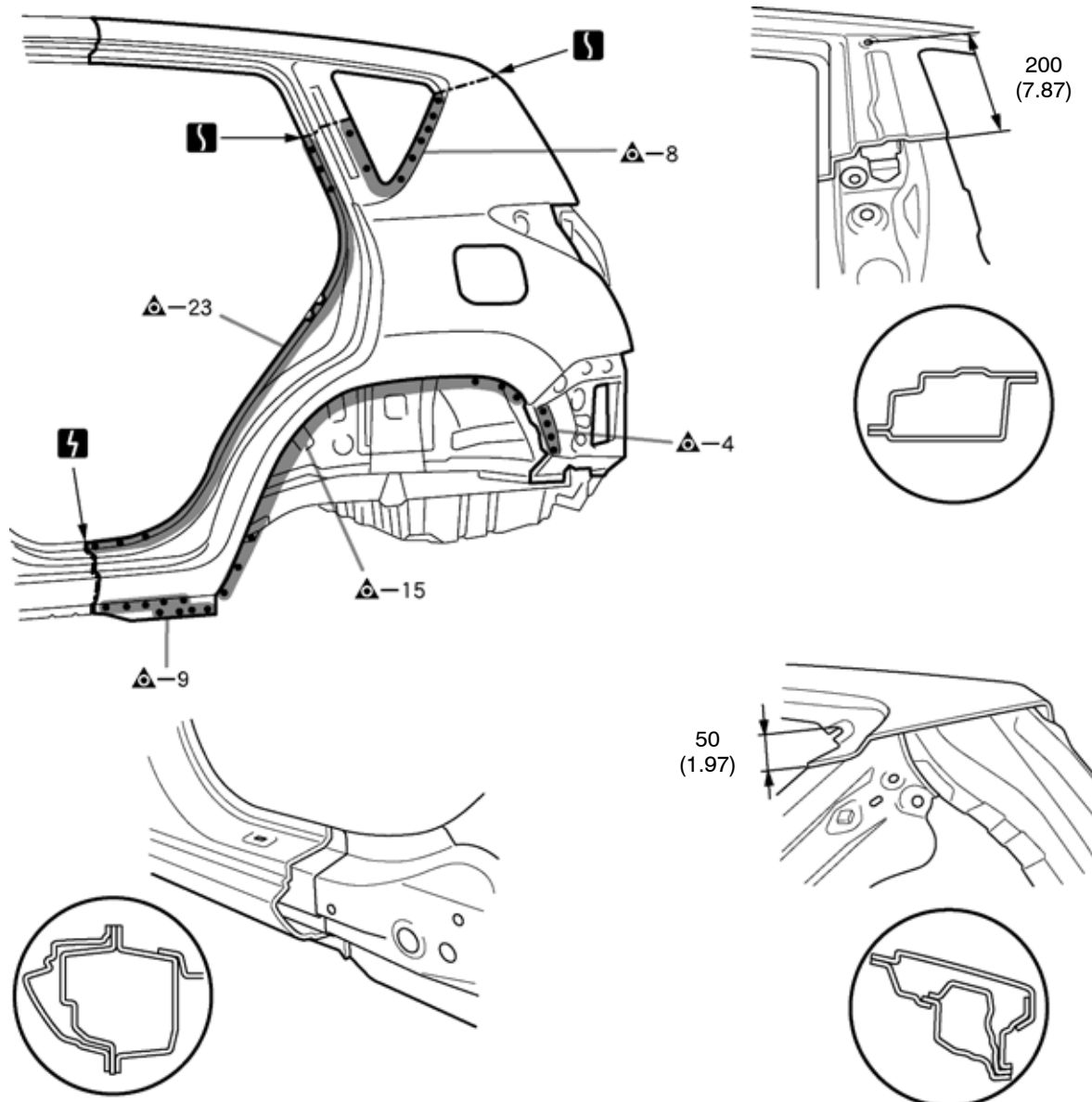
⊙ : Cut with disc sander, etc.

⌋ : Cut and Join Location

⚡ : Cut Location for Supply Parts

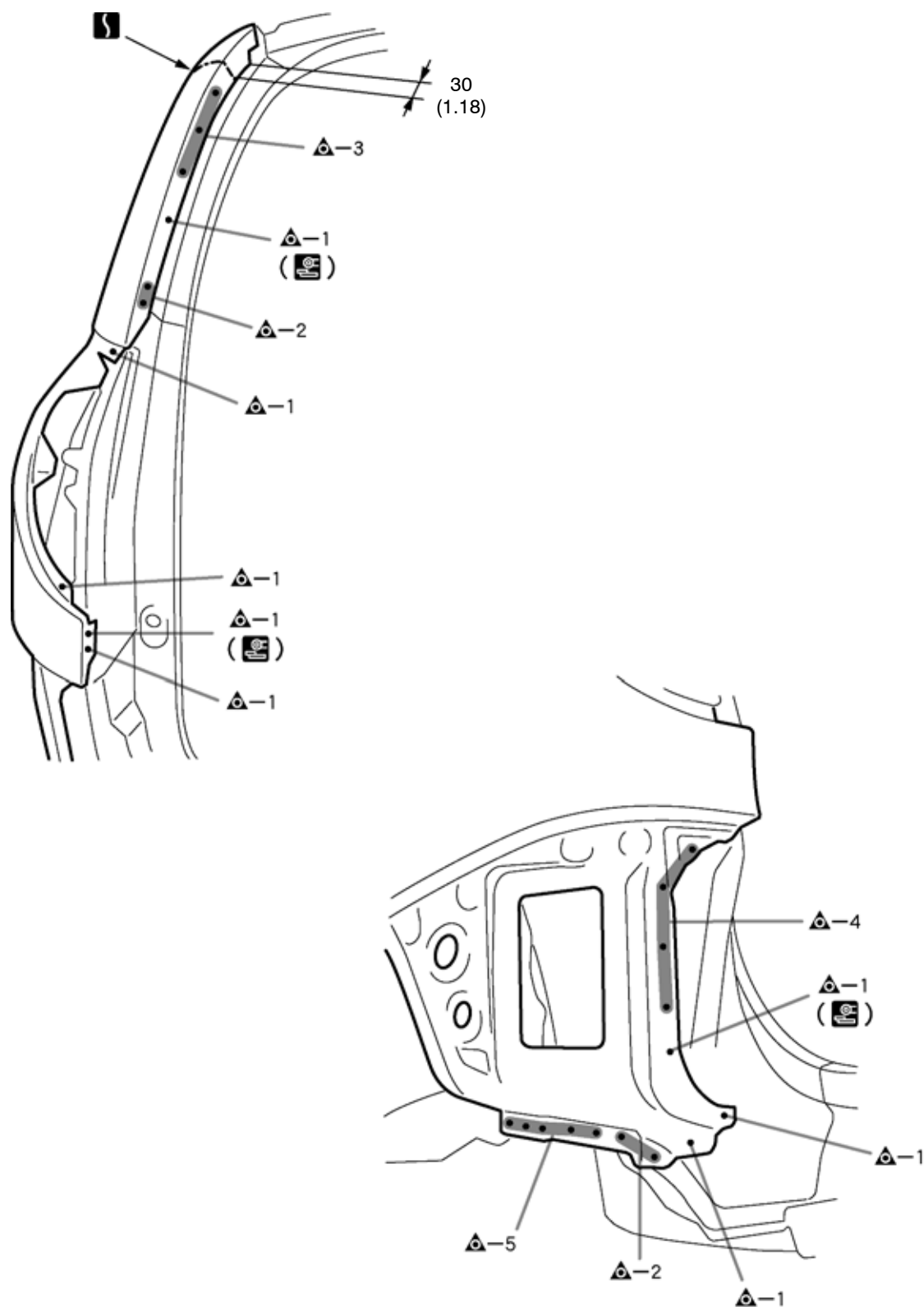
F24692B

REMOVAL



mm (in.)

F24692



mm (in.)

F24693

Symbol meaning

 : MIG Plug Weld

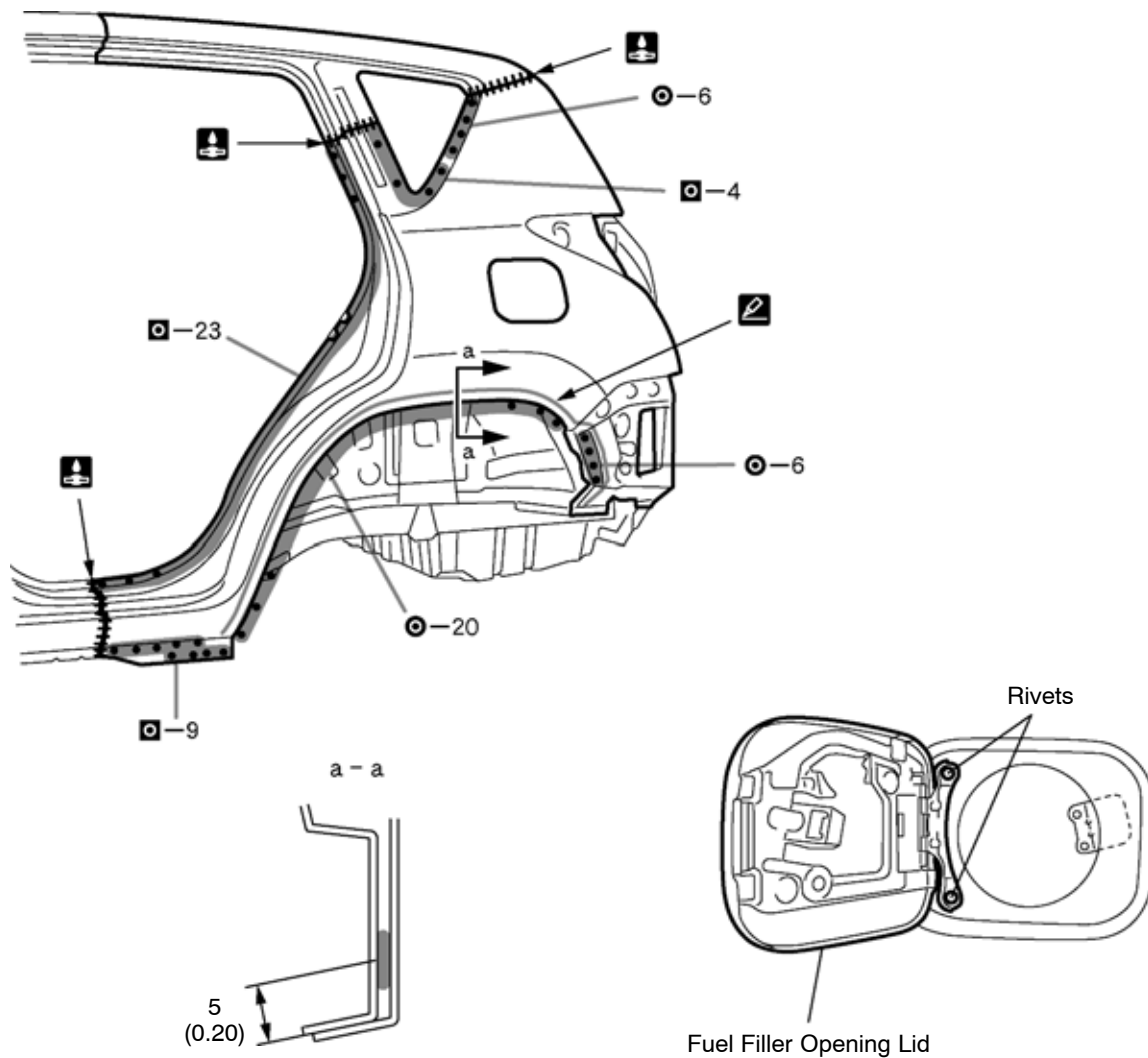
 : Spot Weld

 : Butt Weld

 : Body Sealer

F24694B

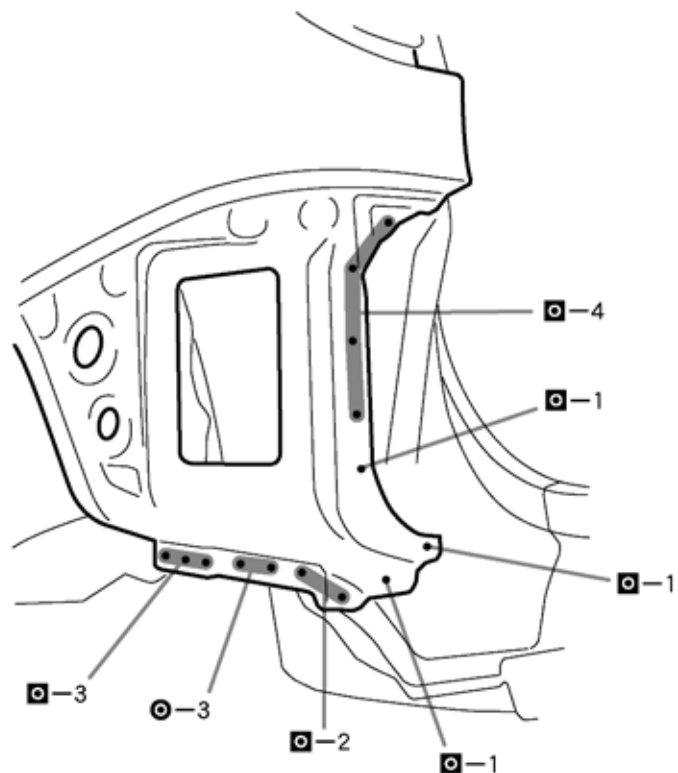
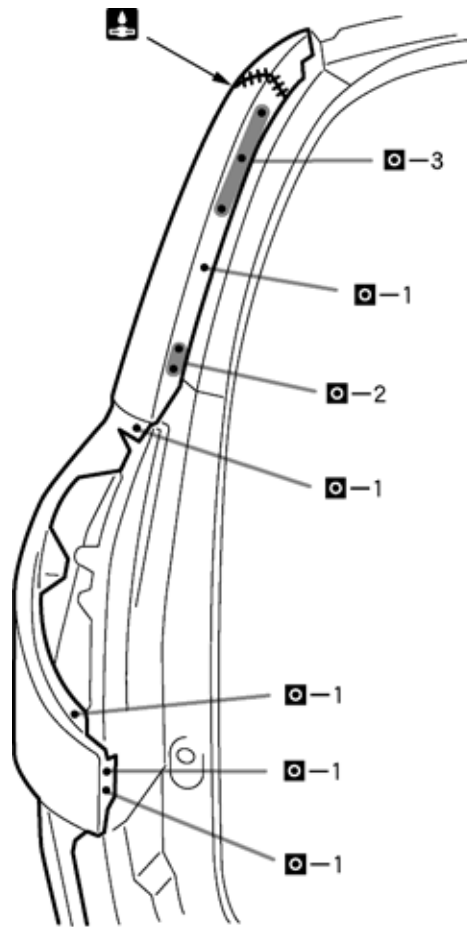
INSTALLATION



F24694

INSTALLATION POINT

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



F24695

INSTALLATION POINT

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

QUARTER PANEL (CUT): Long Body



F24696A

Symbol meaning

△ : Remove Weld Points

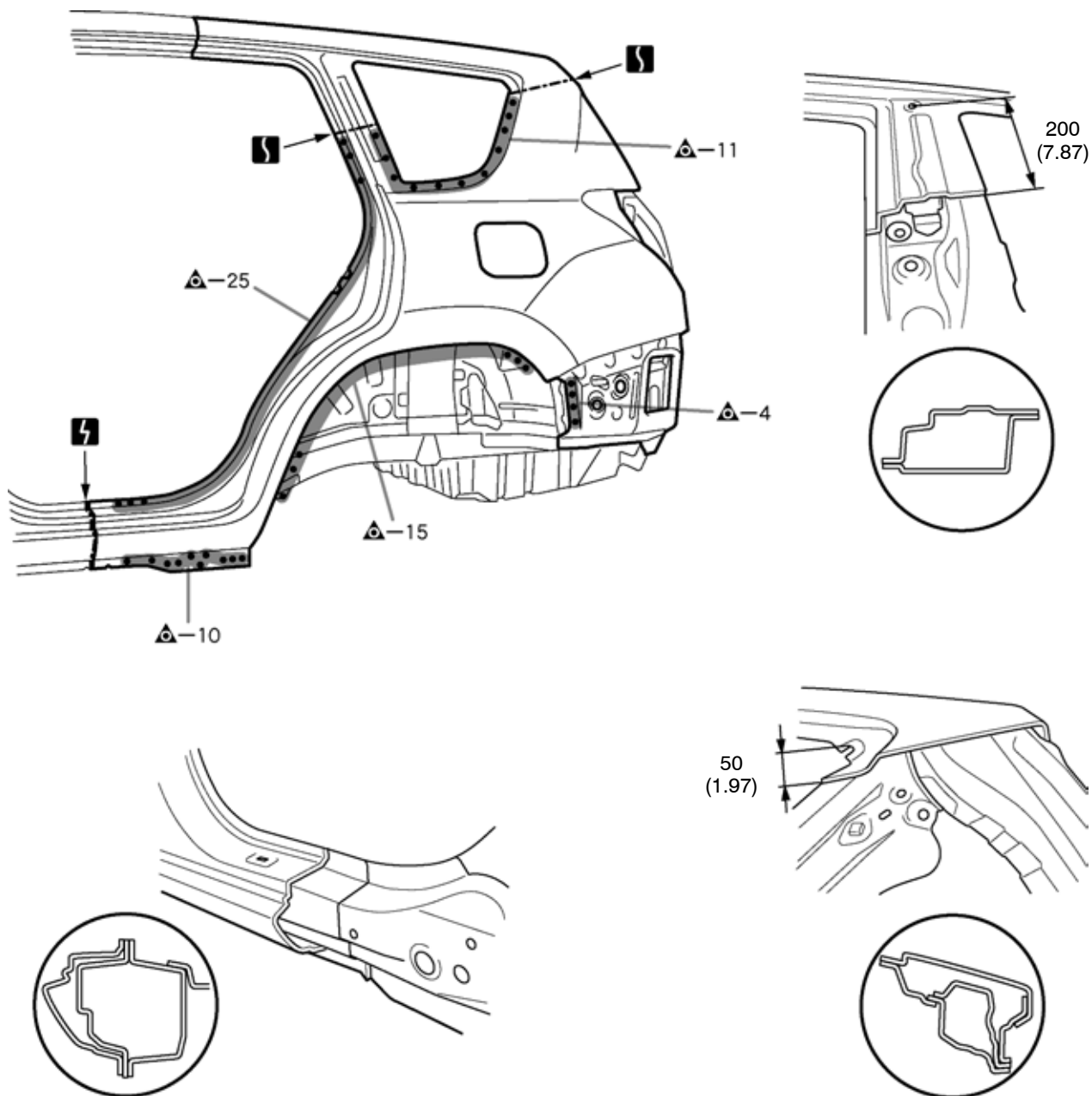
⌋ : Cut and Join Location

⊙ : Cut with disc sander, etc.

⚡ : Cut Location for Supply Parts

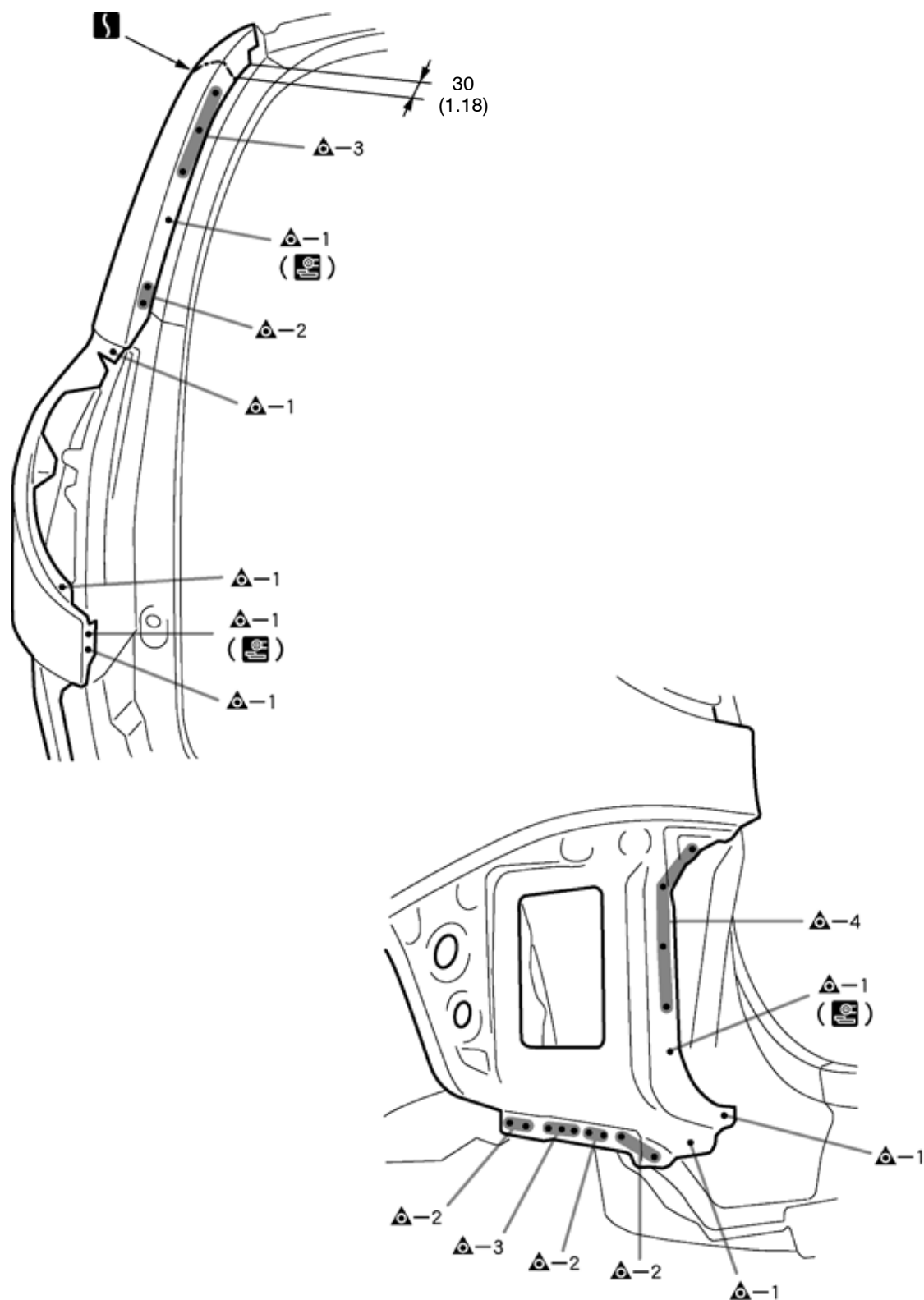
F24696B

REMOVAL



mm (in.)

F24696



mm (in.)

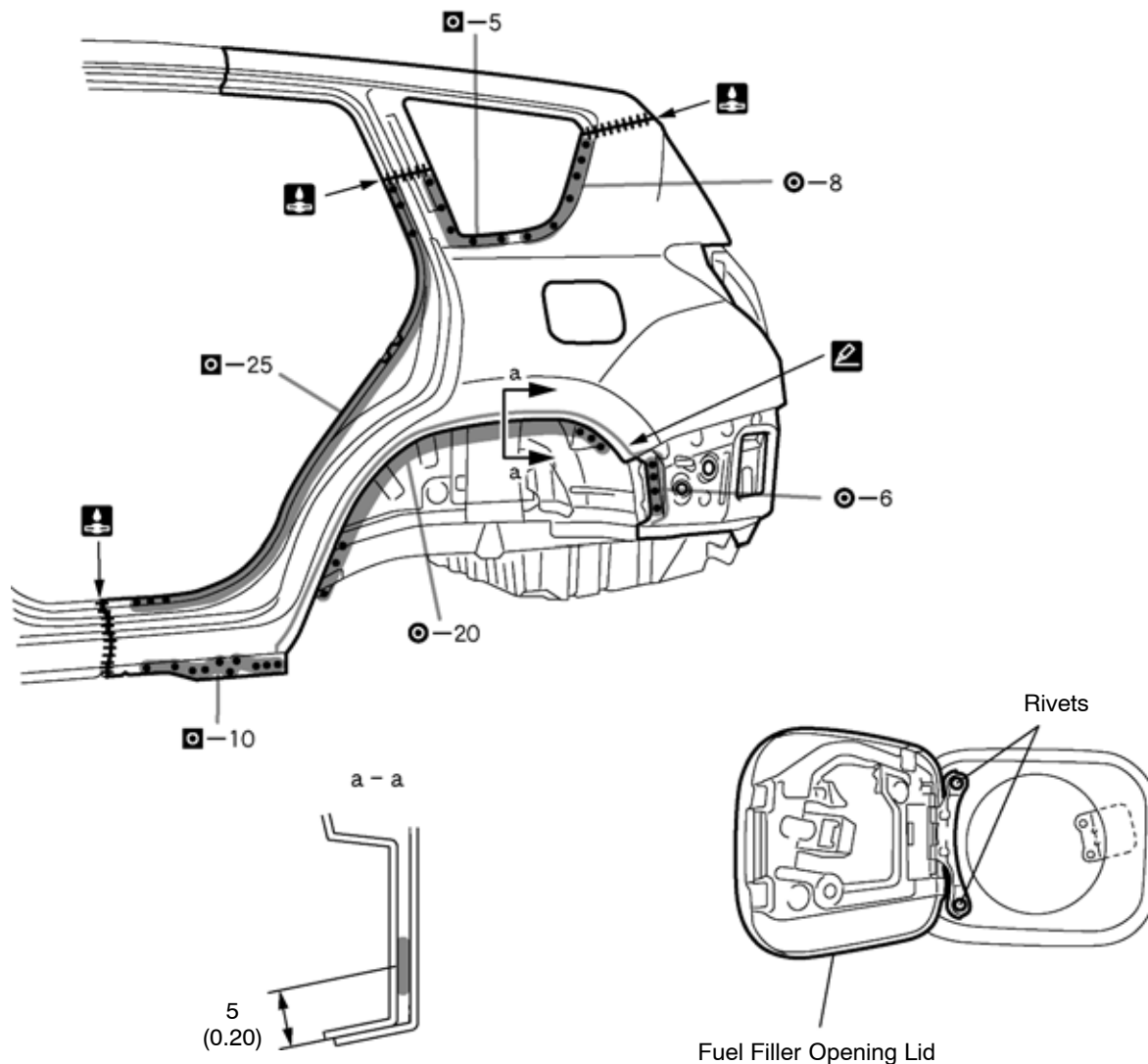
F24697

Symbol meaning

 : MIG Plug Weld
  : Spot Weld
  : Butt Weld
  : Body Sealer

F24698B

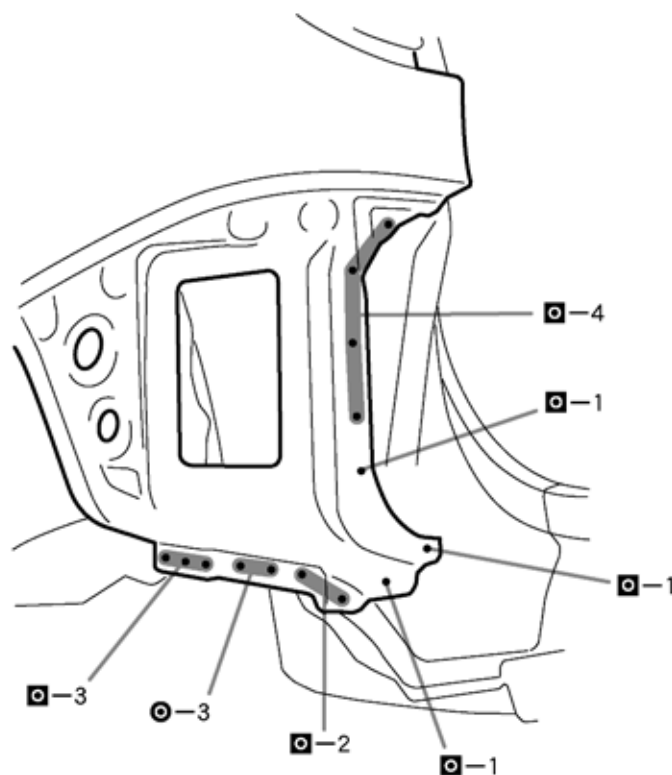
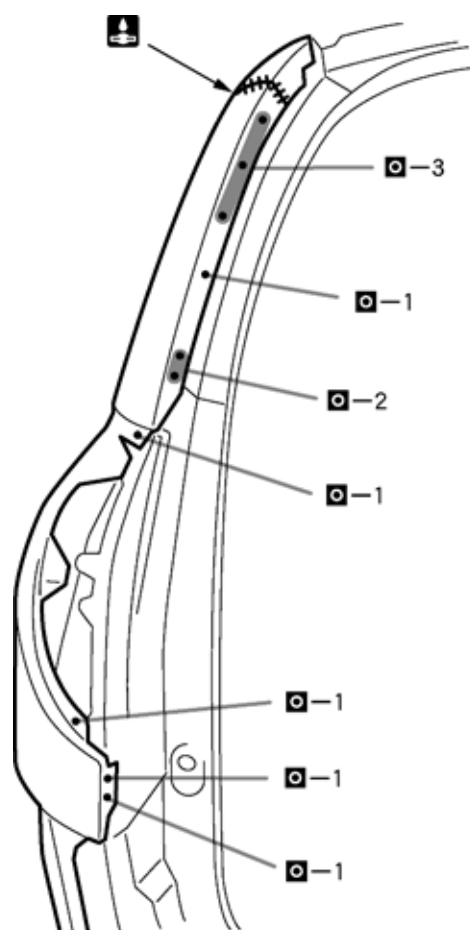
INSTALLATION



F24698

INSTALLATION POINT

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



F24699

INSTALLATION POINT

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

QUARTER WHEEL HOUSING OUTER PANEL (ASSY): Short Body



F24700A

With the quarter panel removed.

Symbol meaning

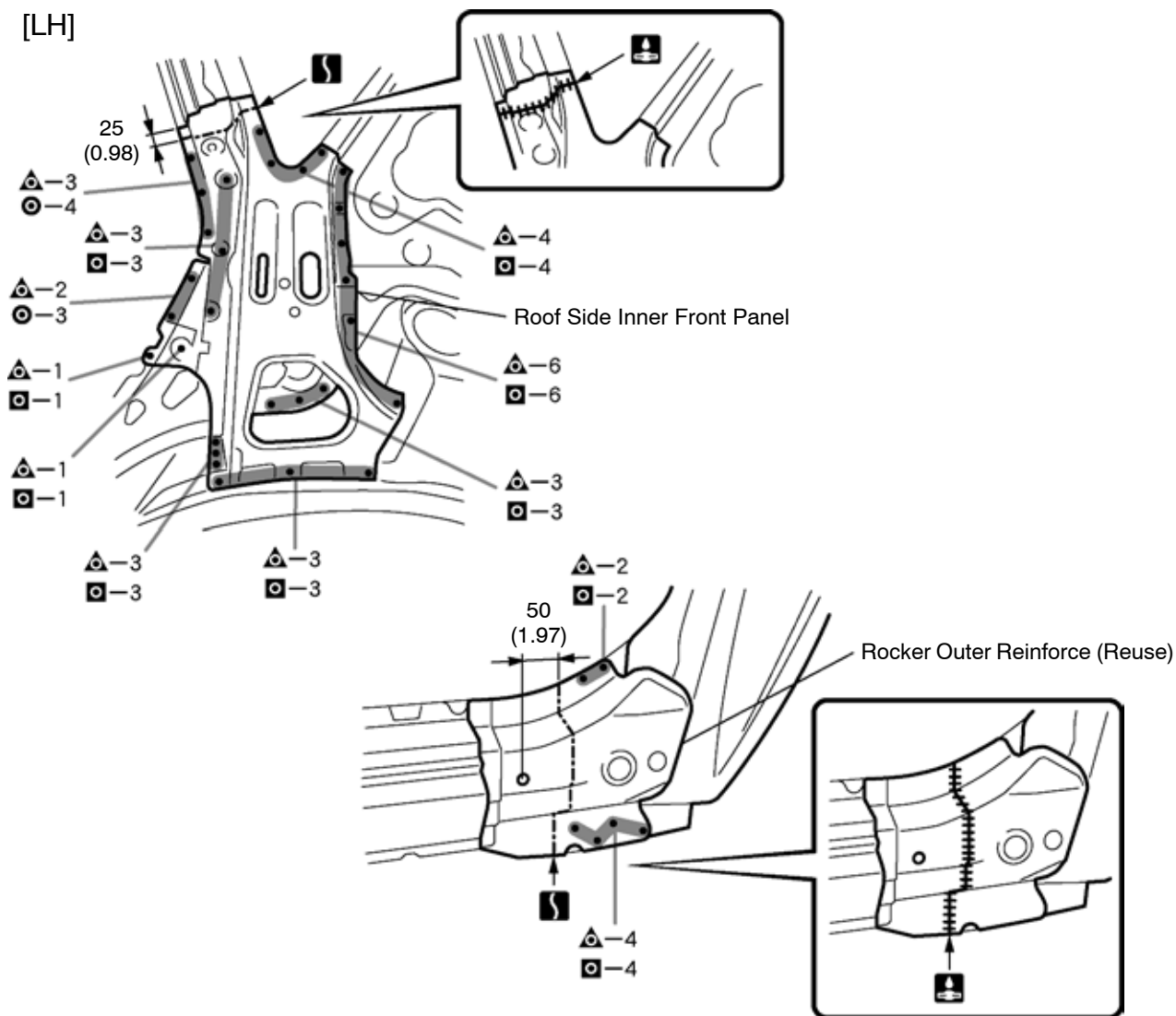
REMOVAL : Remove Weld Points : Cut and Join Location

INSTALLATION : MIG Plug Weld : Spot Weld : Butt Weld

F24700B

REMOVAL-INSTALLATION

[LH]



mm (in.)

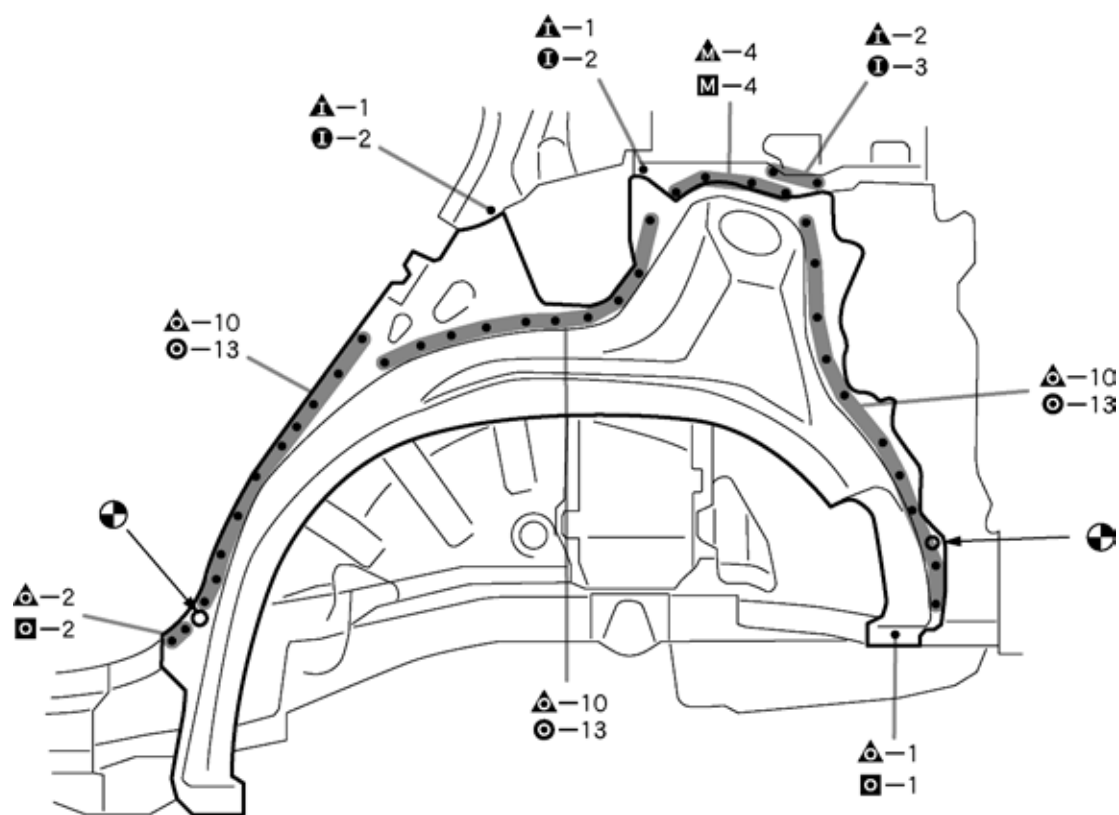
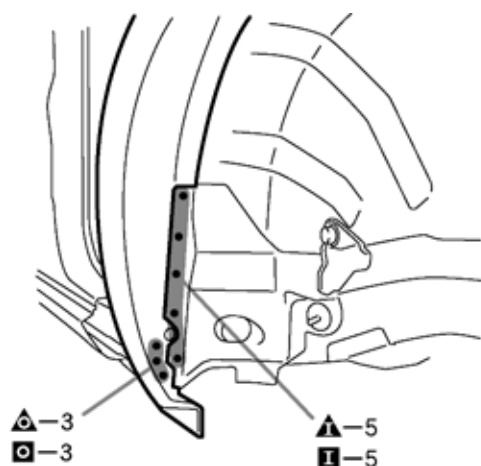
F24700

REMOVAL POINT

- 1 After removing the roof side inner front panel and rocker outer reinforce, remove the quarter wheel housing outer panel.

INSTALLATION POINT

- 1 After welding the quarter wheel housing outer panel to the vehicle side, install the roof side inner front panel and rocker outer reinforce.



F24701

INSTALLATION POINT

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

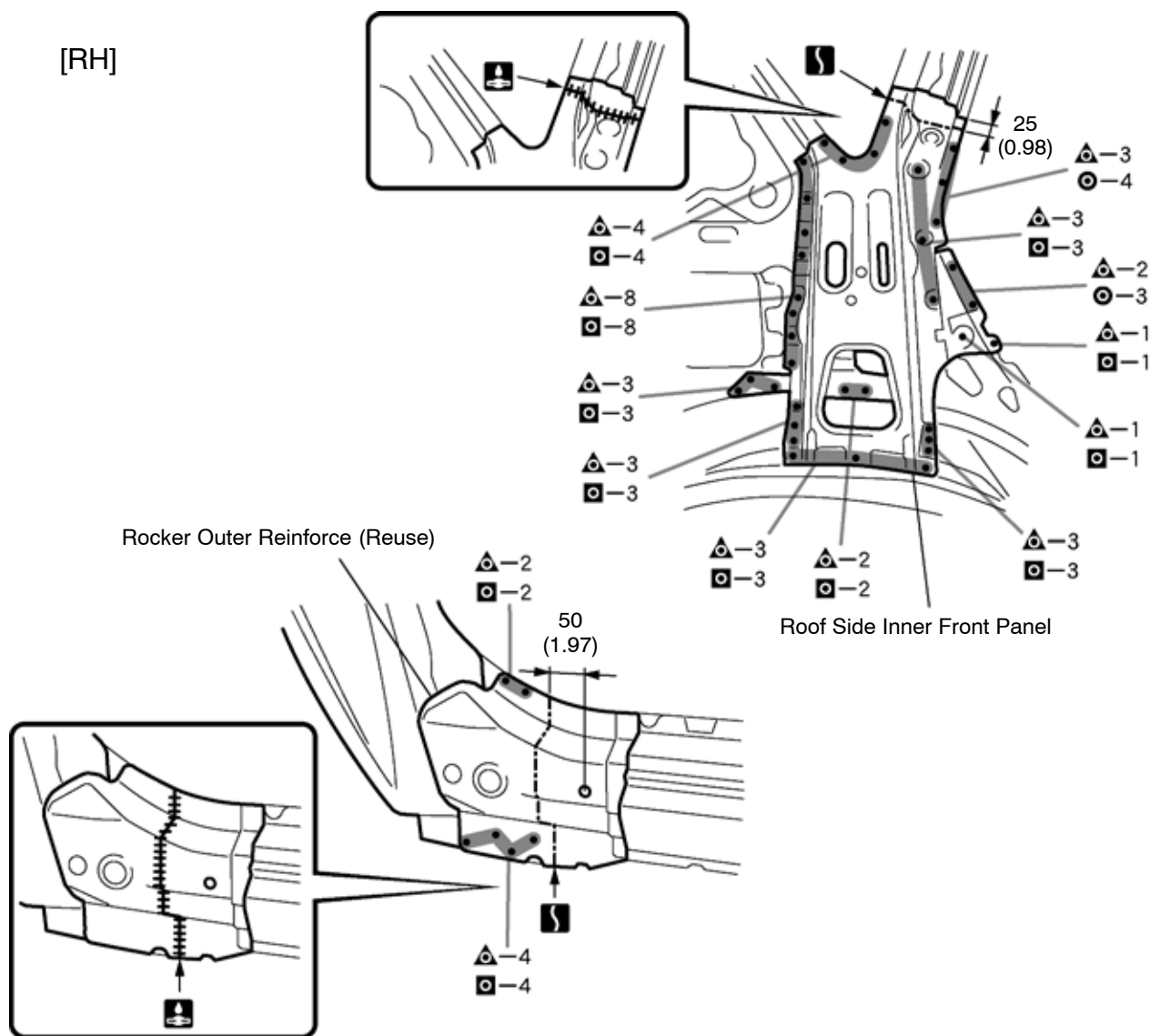
Symbol meaning

REMOVAL  : Remove Weld Points  : Cut and Join Location

INSTALLATION    : MIG Plug Weld   : Spot Weld  : Butt Weld

F24702B

[RH]



mm (in.)

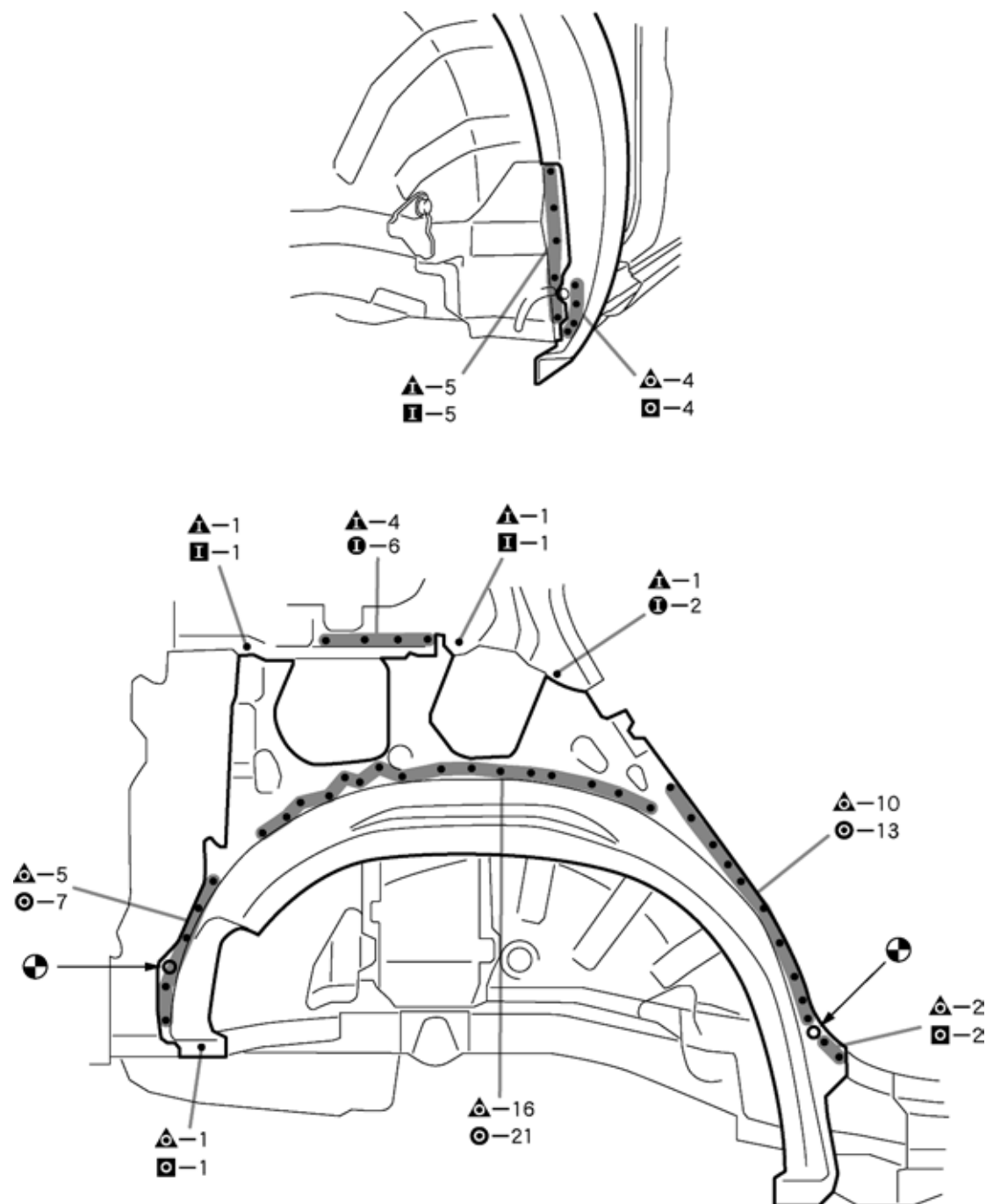
F24702

REMOVAL POINT

- 1 After removing the roof side inner front panel and rocker outer reinforce, remove the quarter wheel housing outer panel.

INSTALLATION POINT

- 1 After welding the quarter wheel housing outer panel to the vehicle side, install the roof side inner front panel and rocker outer reinforce.



F24703

INSTALLATION POINT

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

QUARTER WHEEL HOUSING OUTER PANEL (ASSY): Long Body



F24704A

With the quarter panel removed.

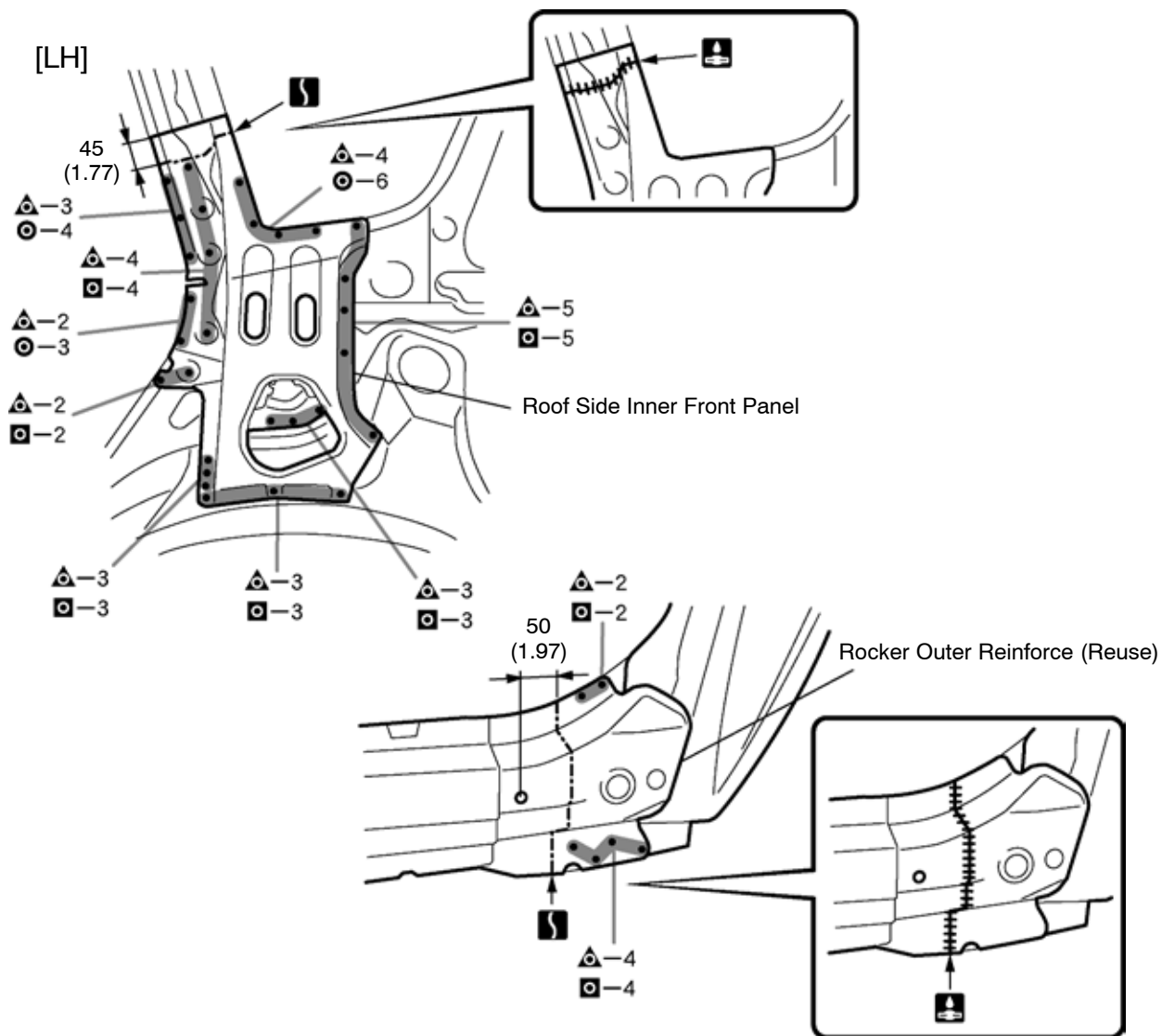
Symbol meaning

REMOVAL : Remove Weld Points : Cut and Join Location

INSTALLATION : MIG Plug Weld : Spot Weld : Butt Weld

F24704B

REMOVAL-INSTALLATION



mm (in.)

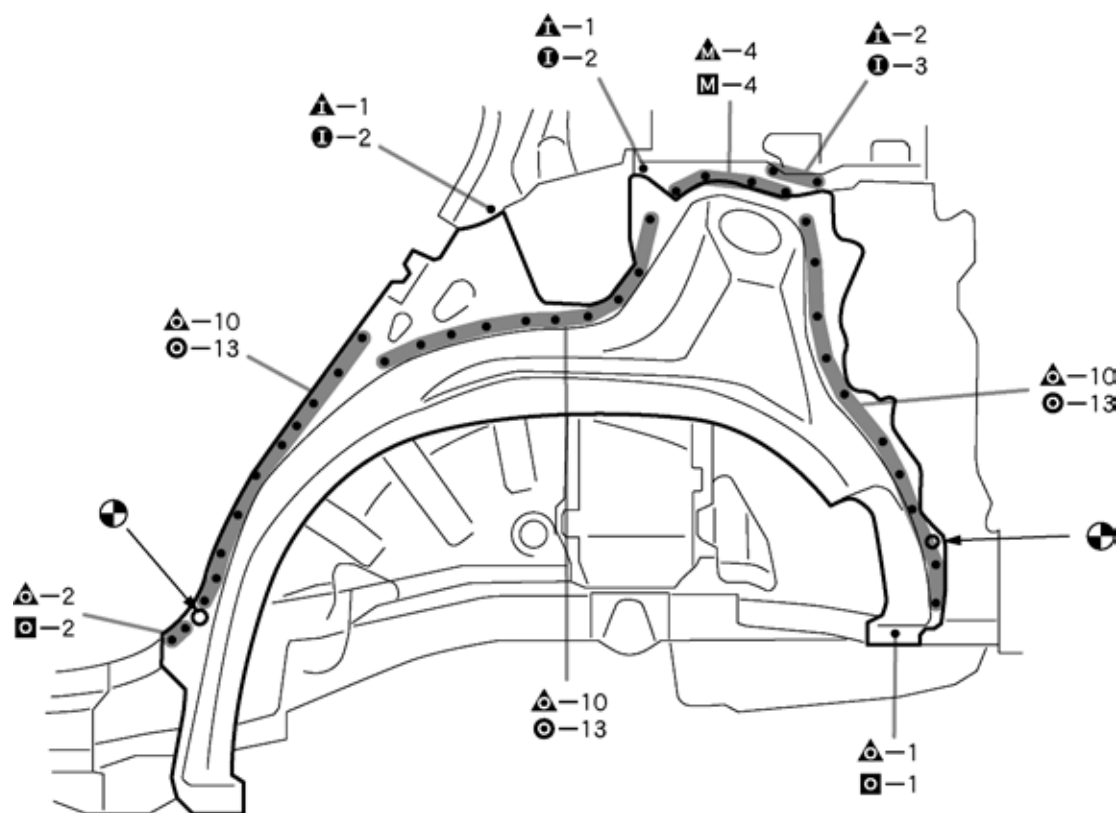
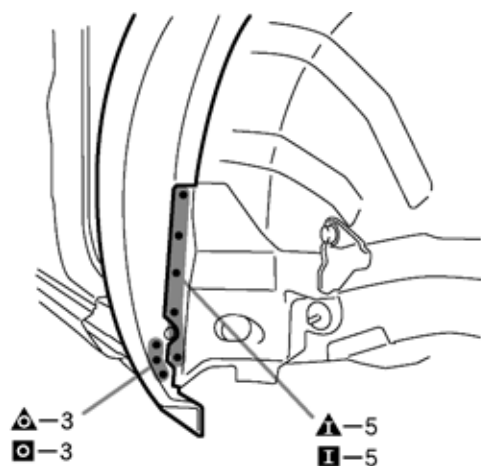
F24704

REMOVAL POINT

- 1 After removing the roof side inner front panel and rocker outer reinforce, remove the quarter wheel housing outer panel.

INSTALLATION POINT

- 1 After welding the quarter wheel housing outer panel to the vehicle side, install the roof side inner front panel and rocker outer reinforce.



F24705

INSTALLATION POINT

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

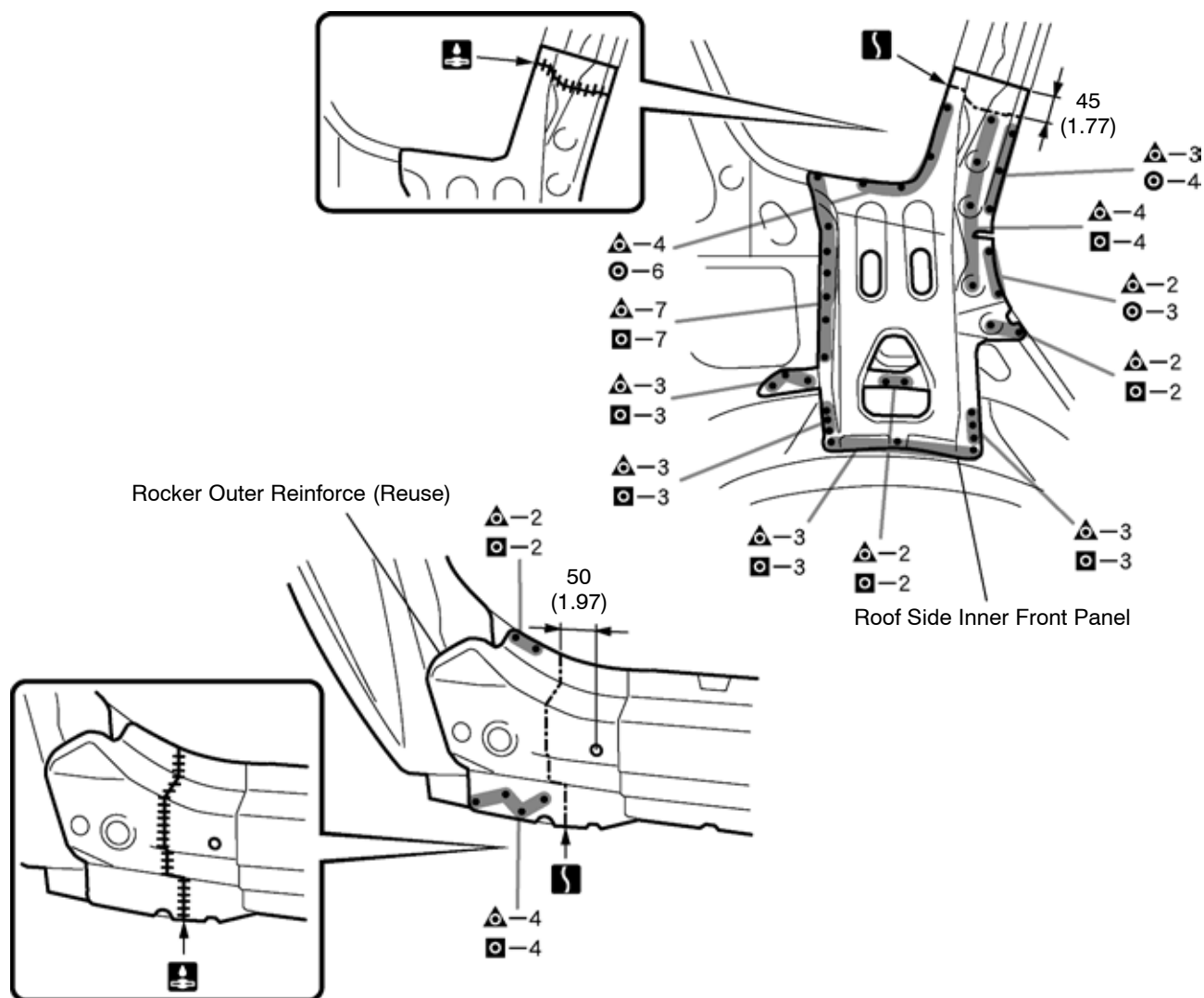
Symbol meaning

REMOVAL    : Remove Weld Points  : Cut and Join Location

INSTALLATION    : MIG Plug Weld   : Spot Weld  : Butt Weld

F24706B

[RH]



mm (in.)

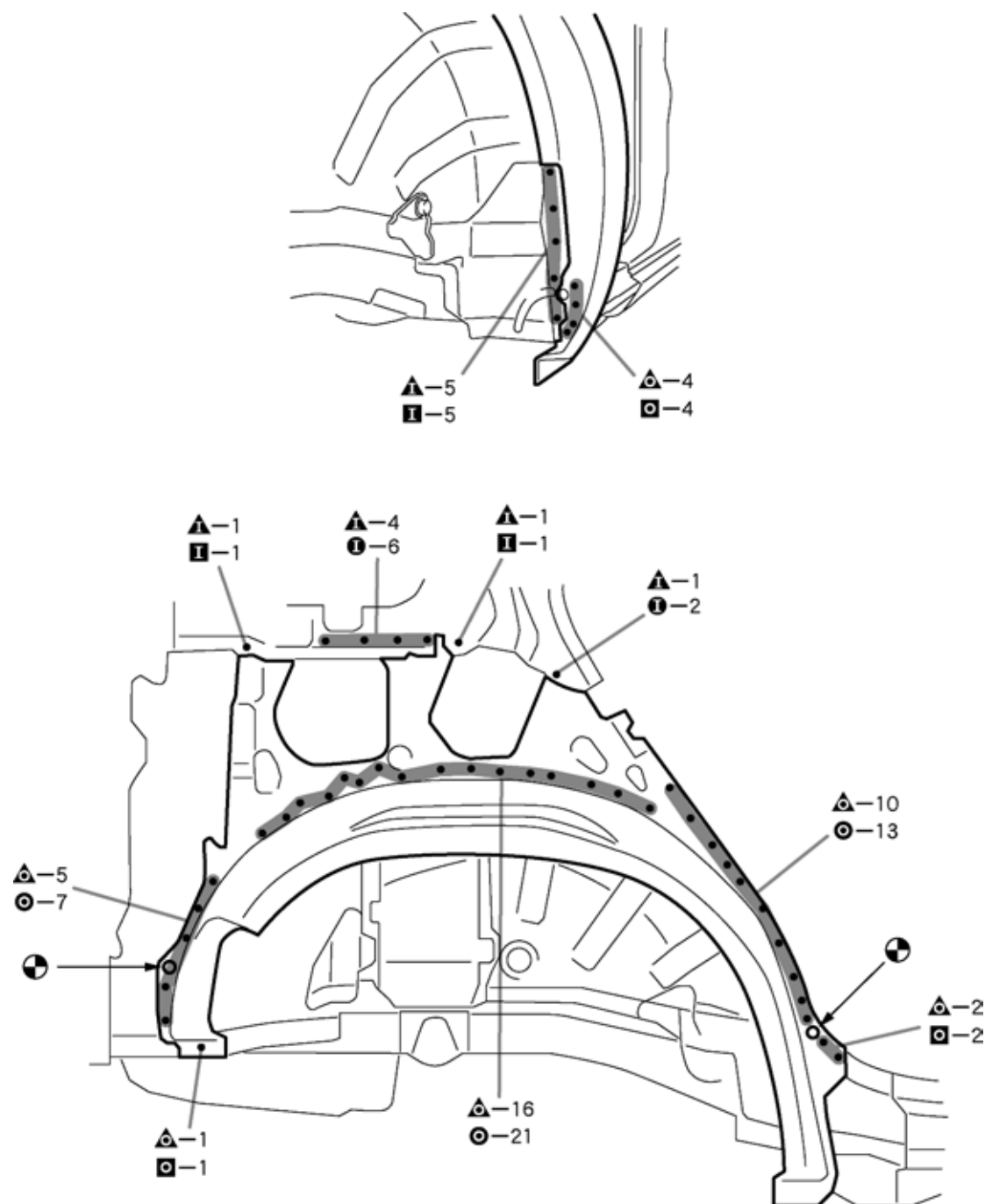
F24706B

REMOVAL POINT

- 1 After removing the roof side inner front panel and rocker outer reinforce, remove the quarter wheel housing outer panel.

INSTALLATION POINT

- 1 After welding the quarter wheel housing outer panel to the vehicle side, install the roof side inner front panel and rocker outer reinforce.



F24707

INSTALLATION POINT

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

BODY LOWER BACK OUTER PANEL (ASSY)



F24708A

Symbol meaning

REMOVAL

△ : Remove Weld Points

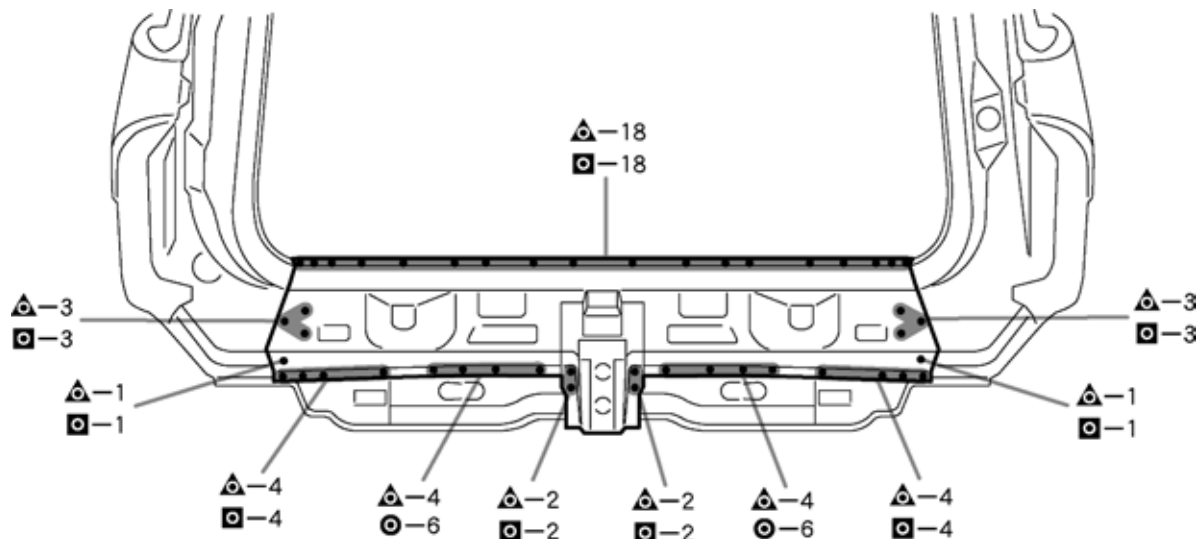
INSTALLATION

◻ : MIG Plug Weld

○ : Spot Weld

F24708B

REMOVAL-INSTALLATION



F24708

INSTALLATION POINT

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

BODY LOWER BACK INNER PANEL (CUT-H)



F24709A

With the body lower back outer panel removed.

Symbol meaning

REMOVAL

▲ ▲ ▲ : Remove Weld Points

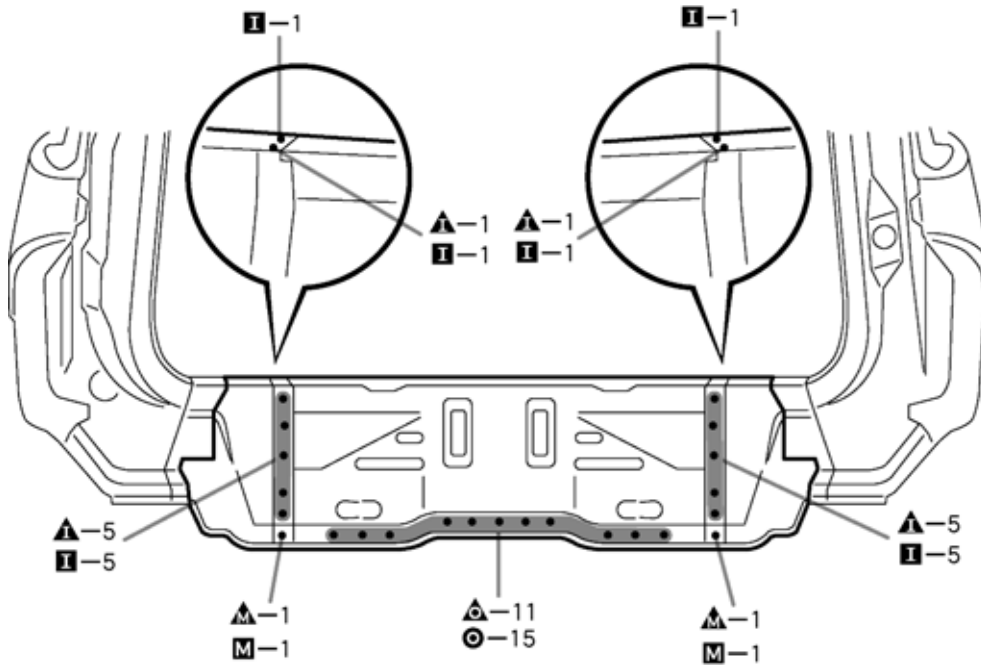
INSTALLATION

■ ■ : MIG Plug Weld

● : Spot Weld

F24709B

REMOVAL-INSTALLATION



F24709

INSTALLATION POINT

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

BODY LOWER BACK INNER PANEL (CUT)



F24710A

With the body lower back outer panel and quarter inner lower panel removed.

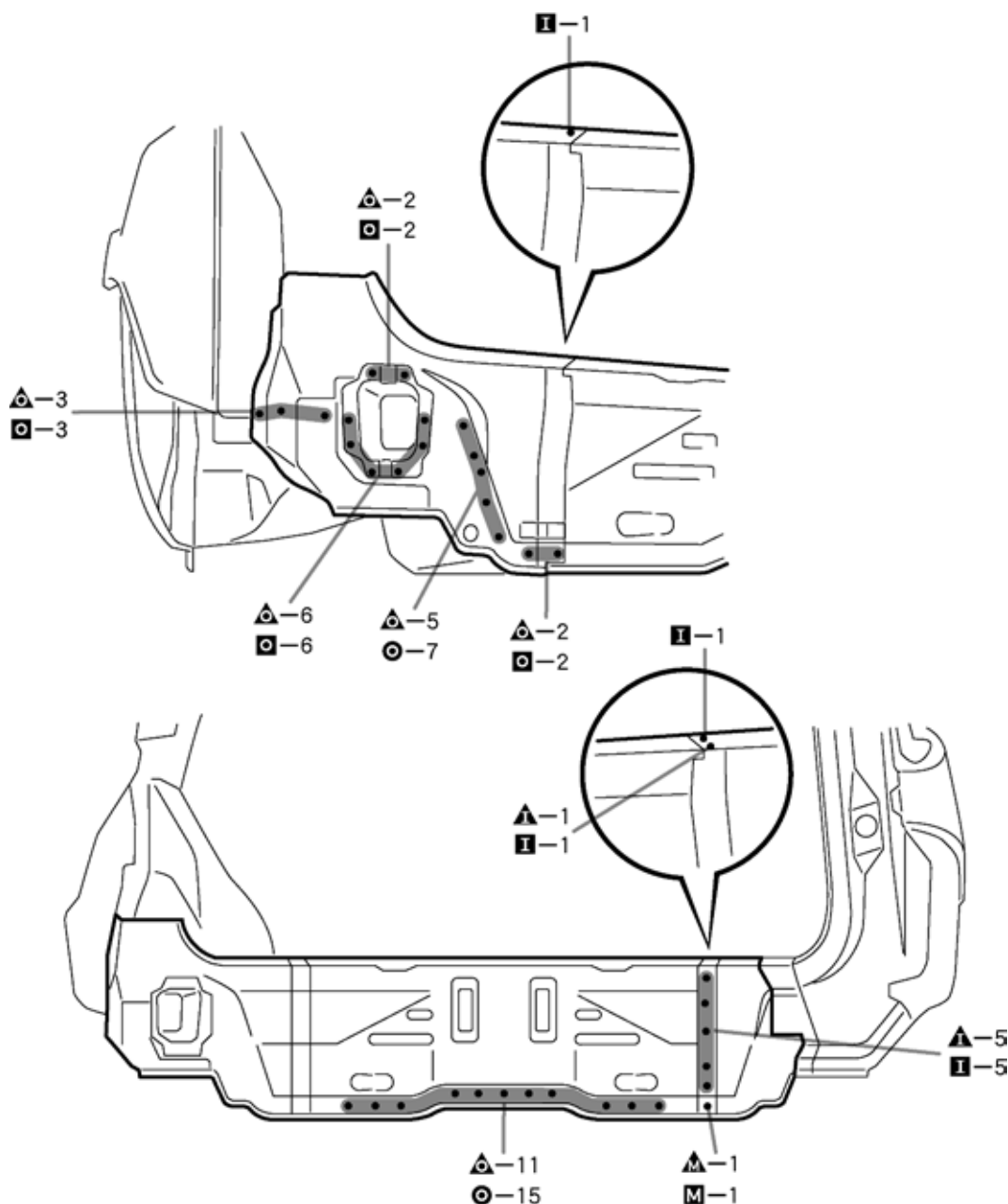
Symbol meaning

REMOVAL : Remove Weld Points

INSTALLATION : MIG Plug Weld : Spot Weld

F24710B

REMOVAL-INSTALLATION



F24710

INSTALLATION POINT

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

BACK DOOR OPENING TROUGH (ASSY)



F24711A

With the quarter panel and body lower back outer panel removed.

Symbol meaning

▲ ▲ : Remove Weld Points

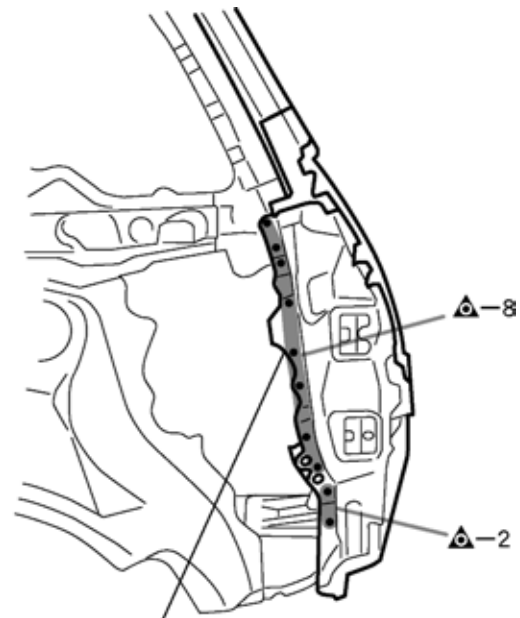
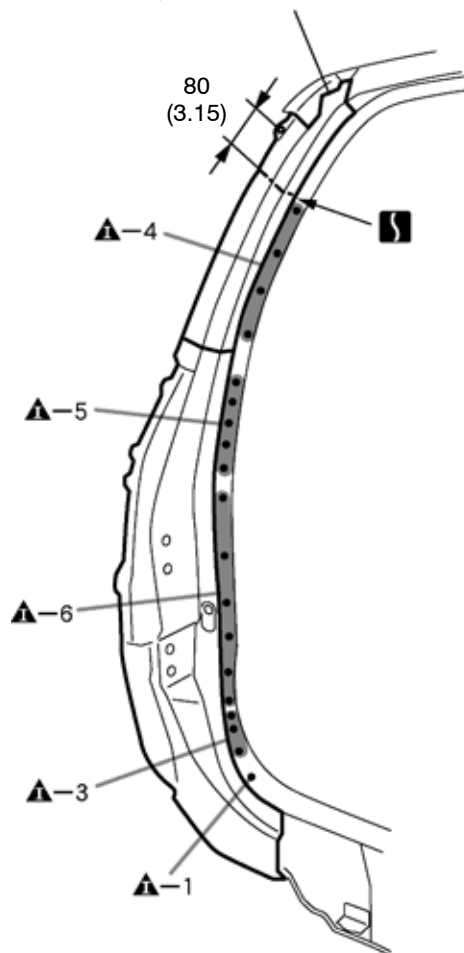
⌋ : Cut and Join Location

F24711B

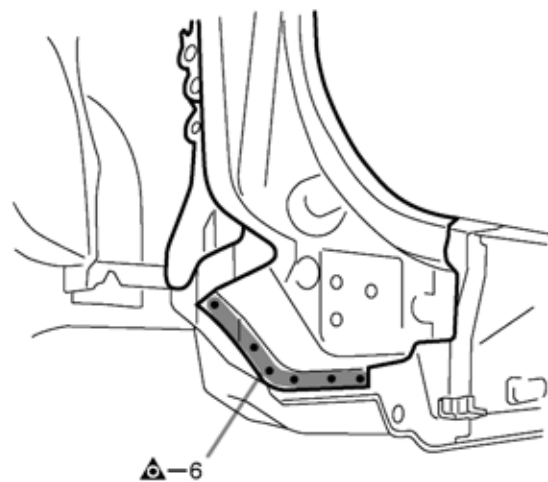
REMOVAL

[LH]

Quarter Panel Rear Extension



Back Door Opening Side Reinforcement



mm (in.)

F24711

REMOVAL POINT

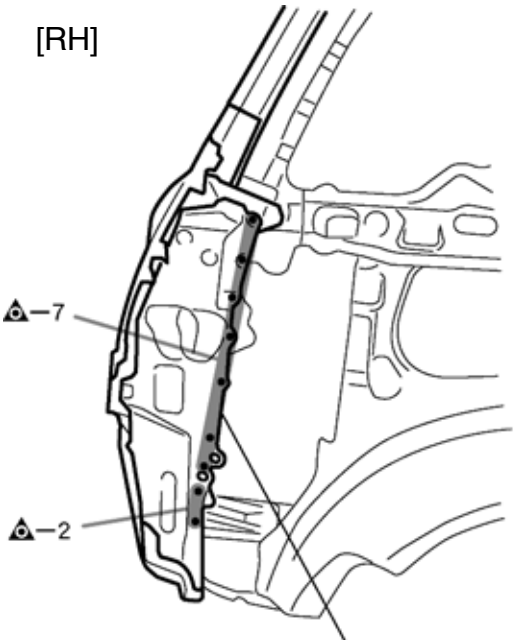
- 1 Remove the back door opening side reinforcement and quarter panel rear reinforcement at the same time.

Symbol meaning

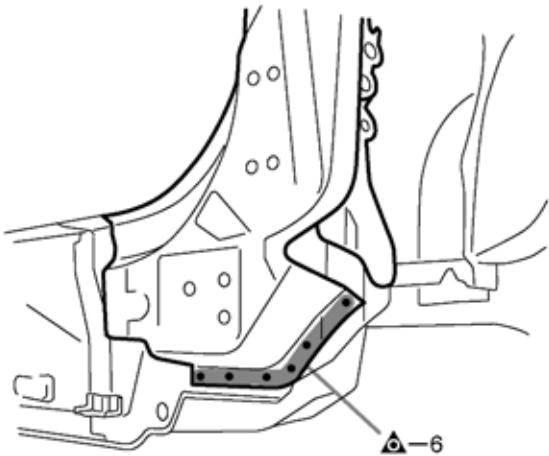
  : Remove Weld Points  : Cut and Join Location

F24712B

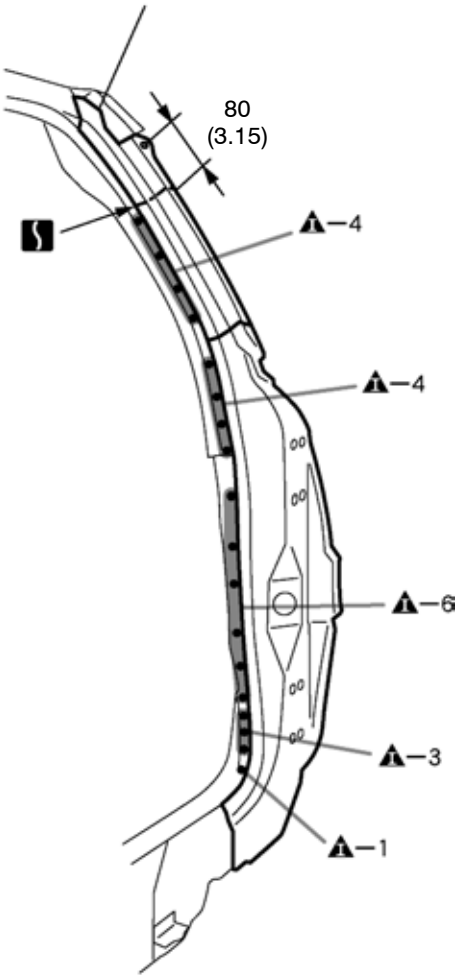
[RH]



Back Door Opening Side Reinforcement



Quarter Panel Rear Extension



mm (in.)

F24712

REMOVAL POINT

- 1 Remove the back door opening side reinforcement and quarter panel rear reinforcement at the same time.

Symbol meaning



: Cut and Join Location



: MIG Plug Weld

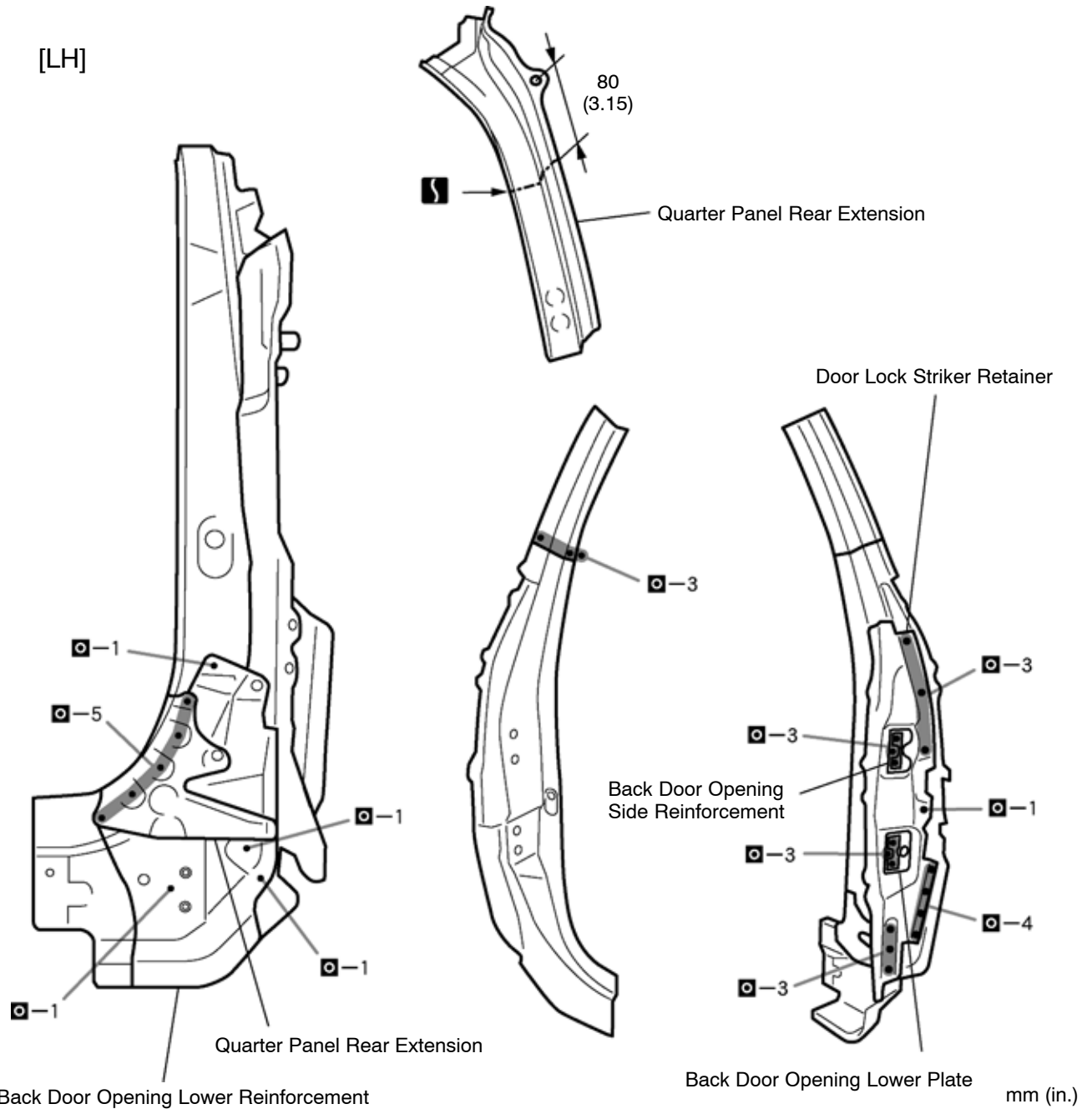


: Butt Weld

F24713B

INSTALLATION

[LH]



F24713

INSTALLATION POINT

- 1 Before temporarily installing the new parts, weld the back door opening lower reinforcement, quarter panel rear lower extension, quarter panel rear extension, back door opening side reinforcement, door lock striker retainer and back door opening lower plate with the standard number of welding points.

Symbol meaning



: Cut and Join Location

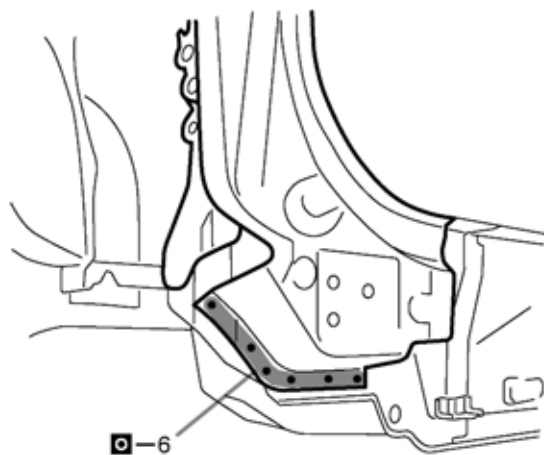
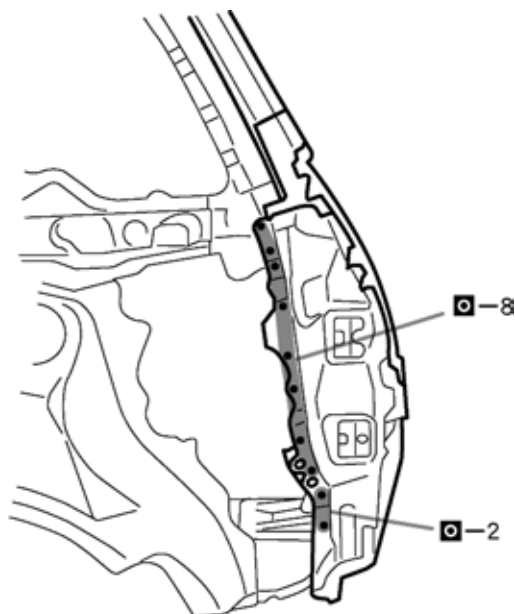
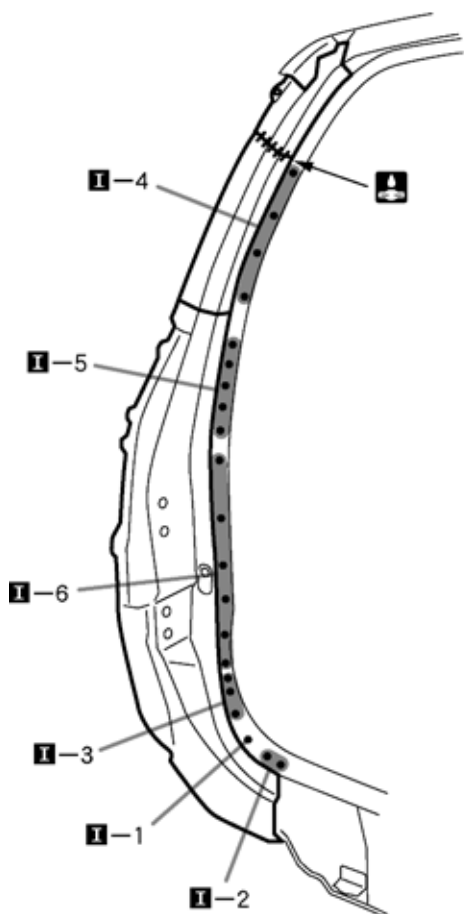


: MIG Plug Weld



: Butt Weld

F24714B



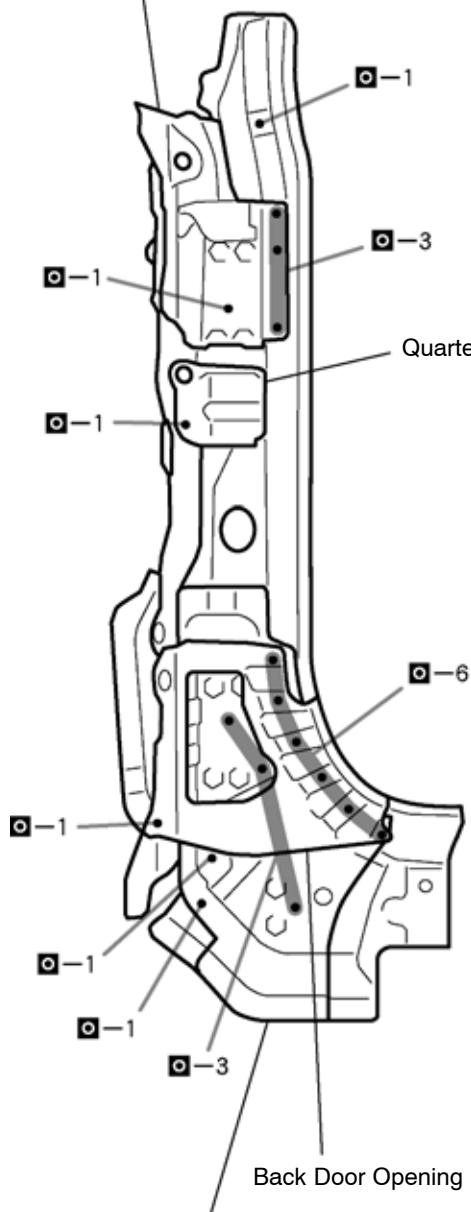
F24714

INSTALLATION POINT

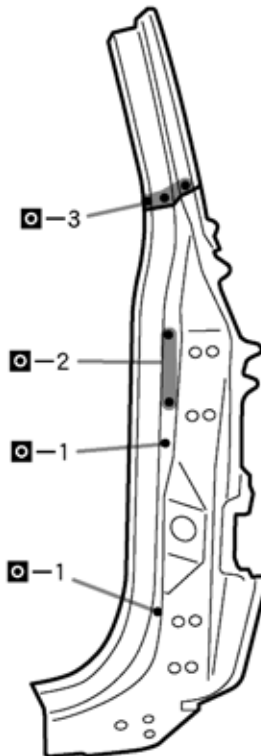
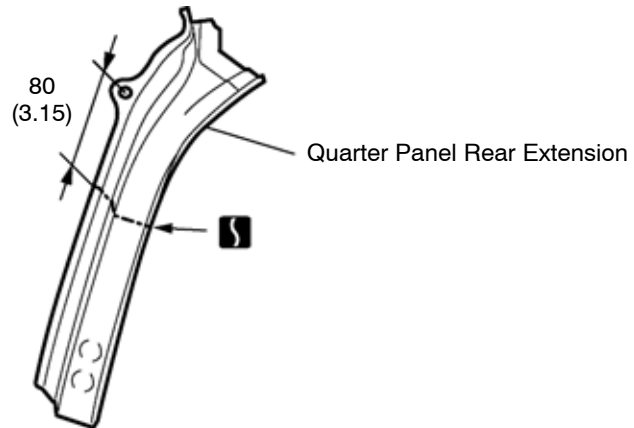
- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 After welding,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

[RH]

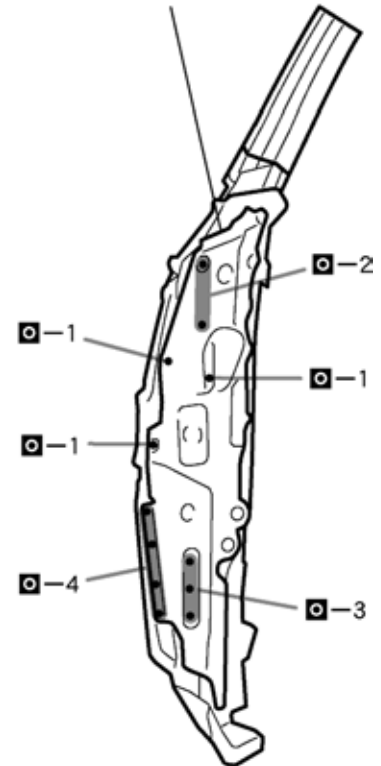
Back Door Opening Side Reinforce



Back Door Lower Hinge Retainer



Back Door Opening Side Reinforcement



mm (in.)

F24715

INSTALLATION POINT

- 1 Before temporarily installing the new parts, weld the back door opening side reinforce, quarter inner panel reinforcement, back door lower hinge retainer, back door opening lower reinforcement, quarter panel rear extension and back door opening side reinforcement with the standard number of welding points.

Symbol meaning



: Cut and Join Location

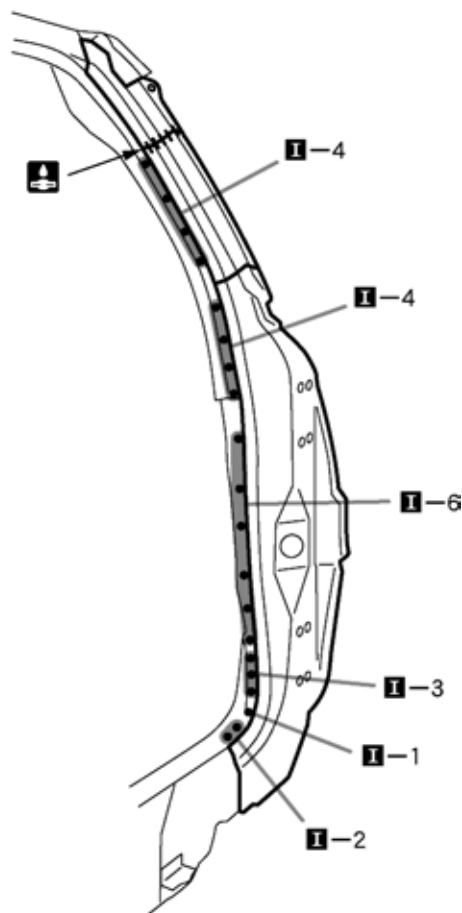
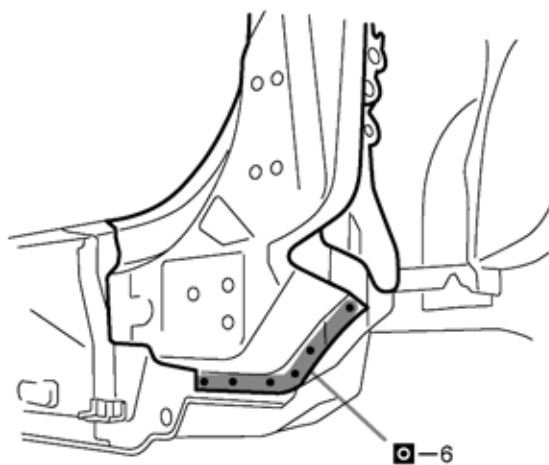
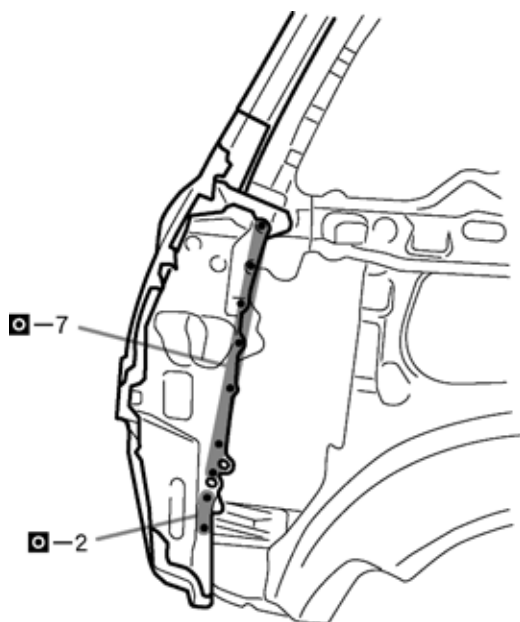


1 : MIG Plug Weld



: Butt Weld

F24716B



F24716

INSTALLATION POINT

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

QUARTER INNER LOWER PANEL (ASSY)



F24717A

With the back door opening trough removed.

Symbol meaning

REMOVAL

△ : Remove Weld Points

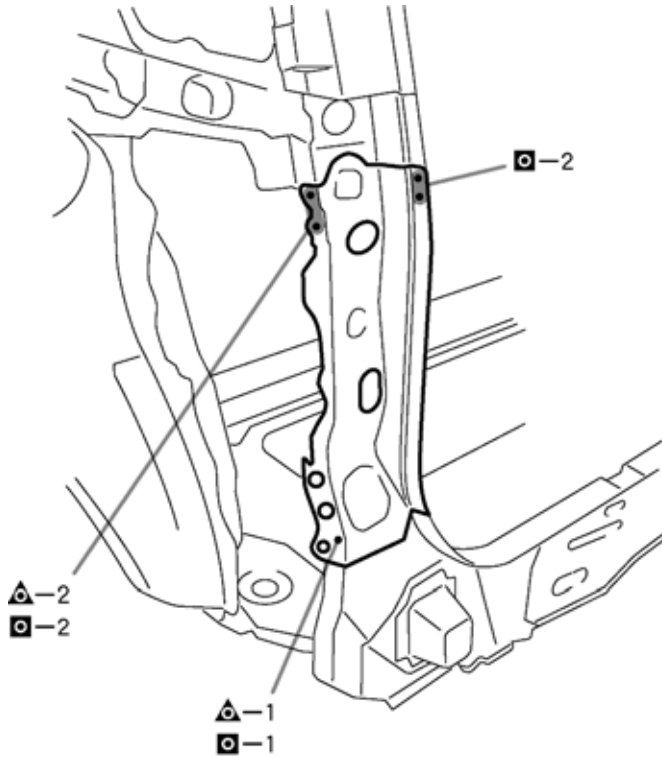
INSTALLATION

◻ : MIG Plug Weld

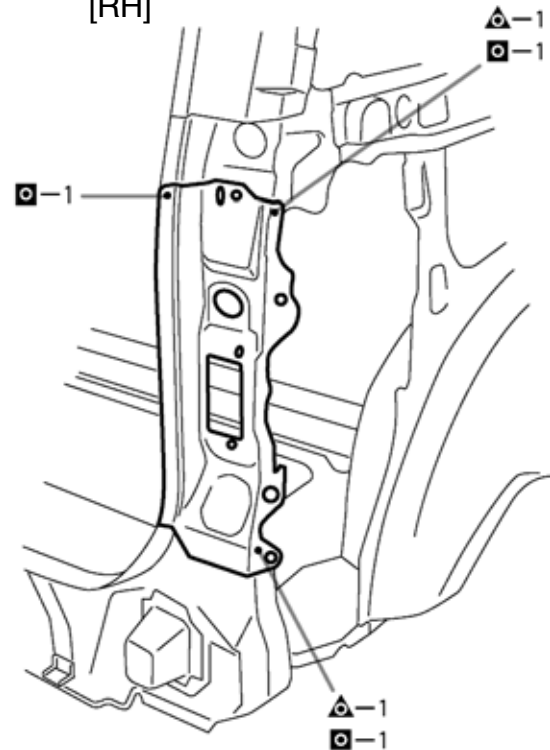
F24717B

REMOVAL-INSTALLATION

[LH]



[RH]



F24717

INSTALLATION POINT

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

REAR FLOOR PAN (ASSY): Short Body



F24718A

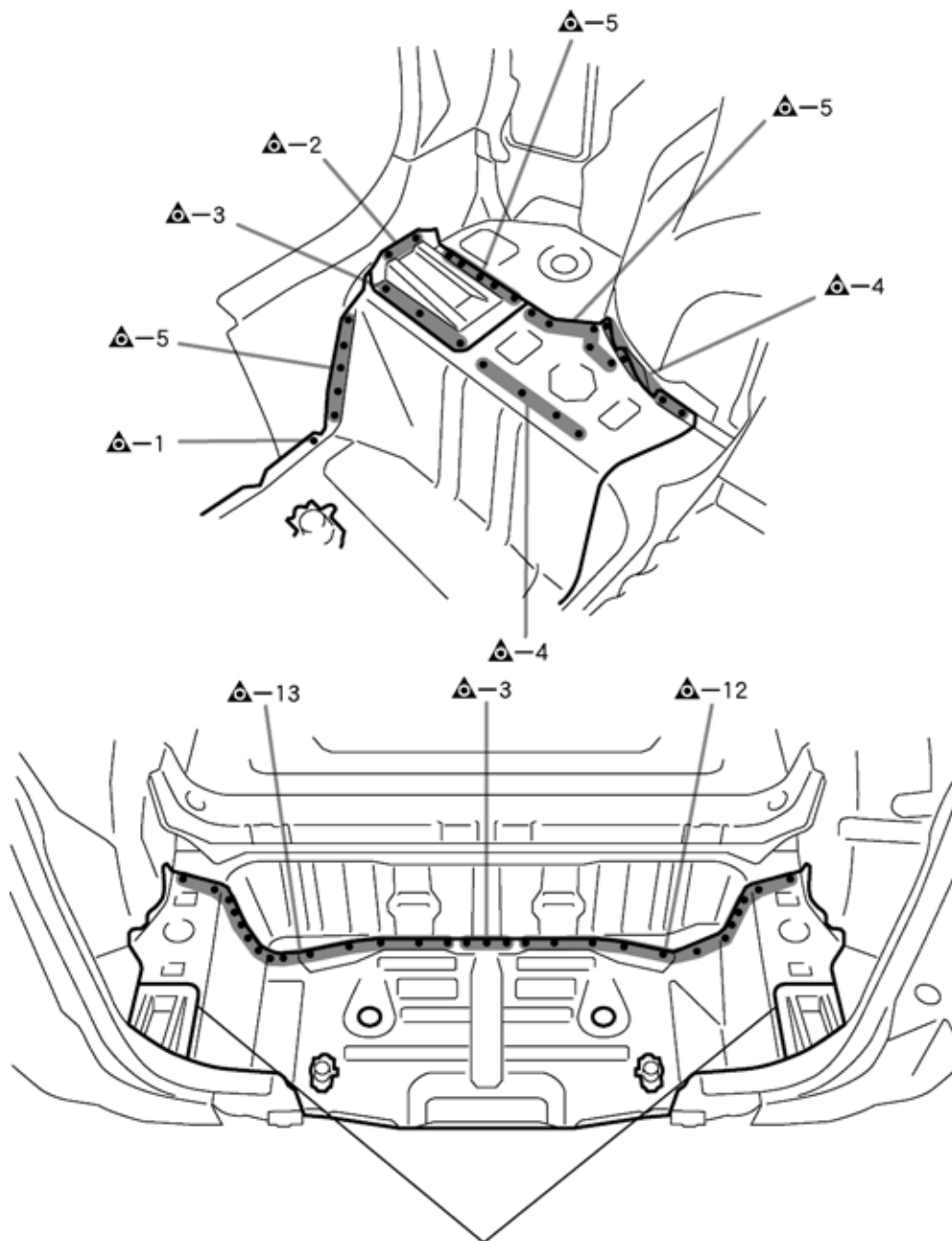
With the body lower back inner panel removed.

Symbol meaning

△ : Remove Weld Points

F24718B

REMOVAL



Rear Floor Panel No. 2 Reinforcement

F24718

REMOVAL POINT

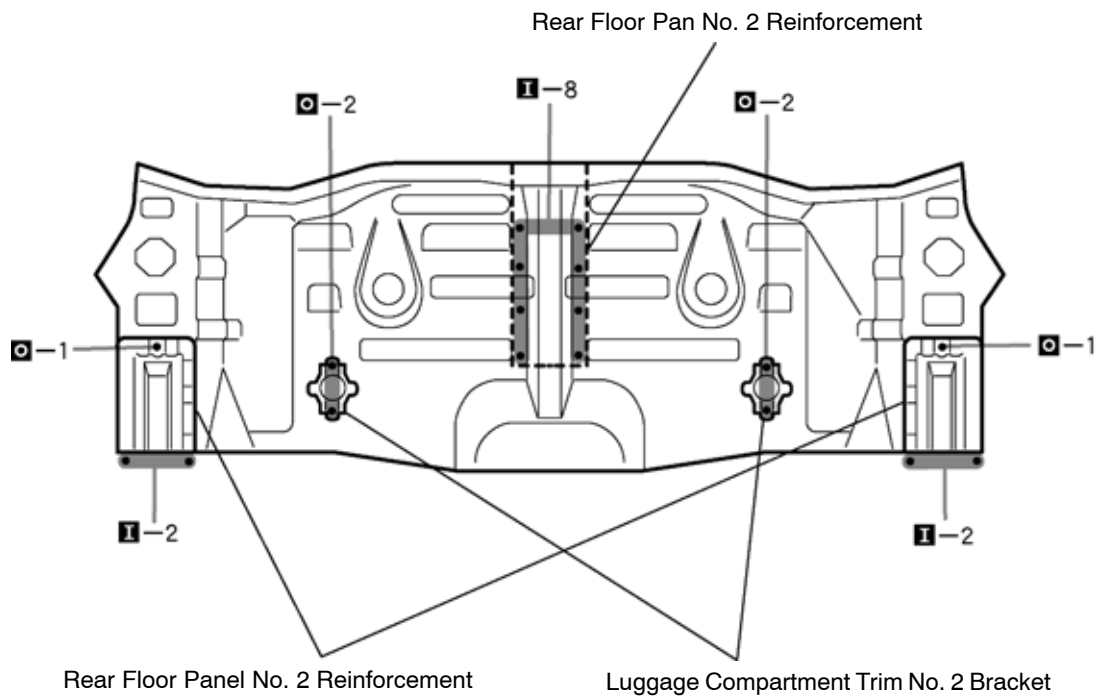
- 1 Remove the rear floor panel No. 2 reinforcement at the same time.

Symbol meaning

⊙ I : MIG Plug Weld

F24719B

INSTALLATION



F24719

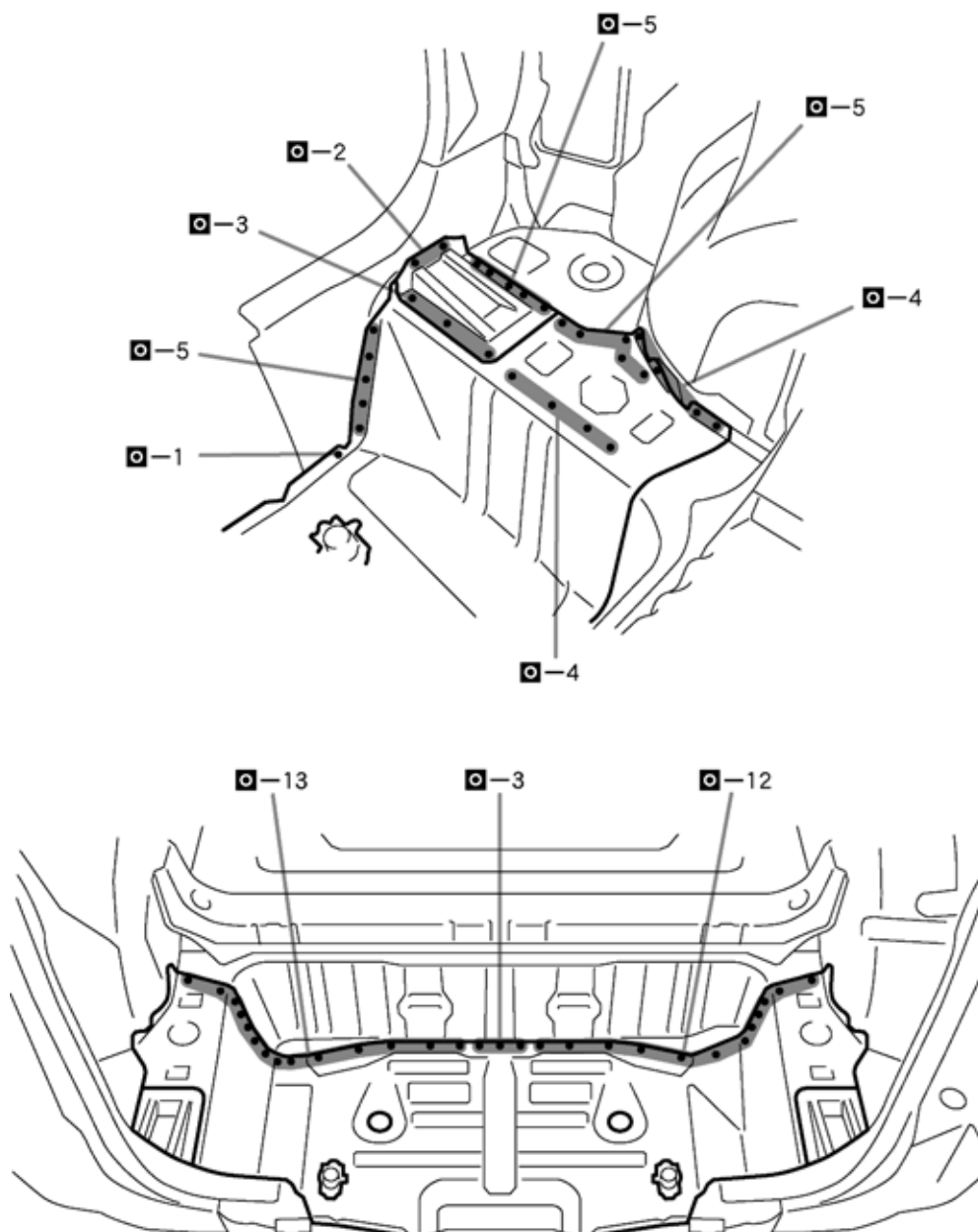
INSTALLATION POINT

- 1 Before temporarily installing the new parts, weld the rear floor panel No. 2 reinforcement, luggage compartment trim No. 2 bracket and rear floor pan No. 2 reinforcement with the standard number of welding points.

Symbol meaning

◻ I : MIG Plug Weld

F24720B



F24720

INSTALLATION POINT

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

REAR FLOOR PAN (ASSY): Long Body



F24721A

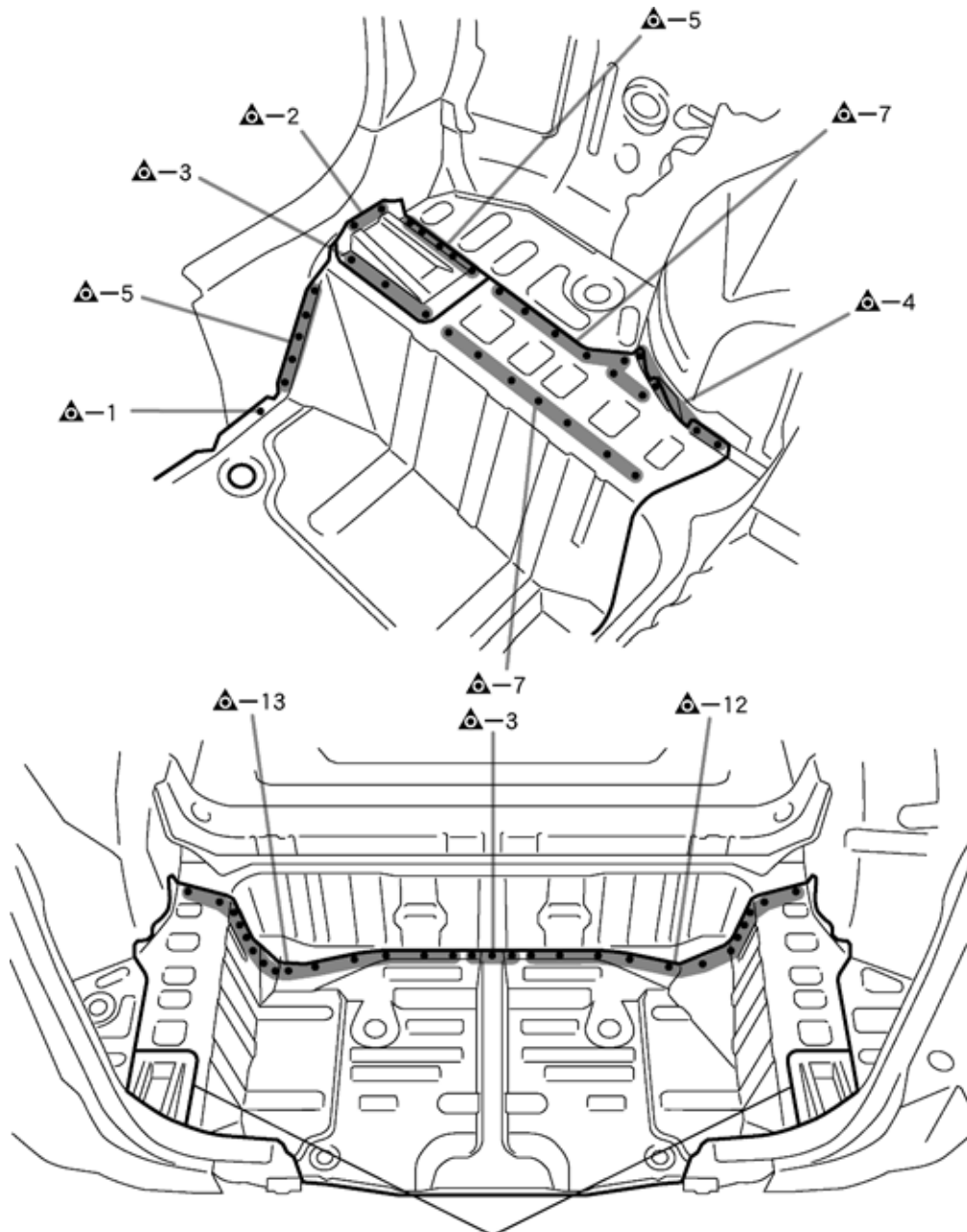
With the body lower back inner panel removed.

Symbol meaning

△ : Remove Weld Points

F24721B

REMOVAL



Rear Floor Panel No. 2 Reinforcement

F24721

REMOVAL POINT

- 1 Remove the rear floor panel No. 2 reinforcement at the same time.

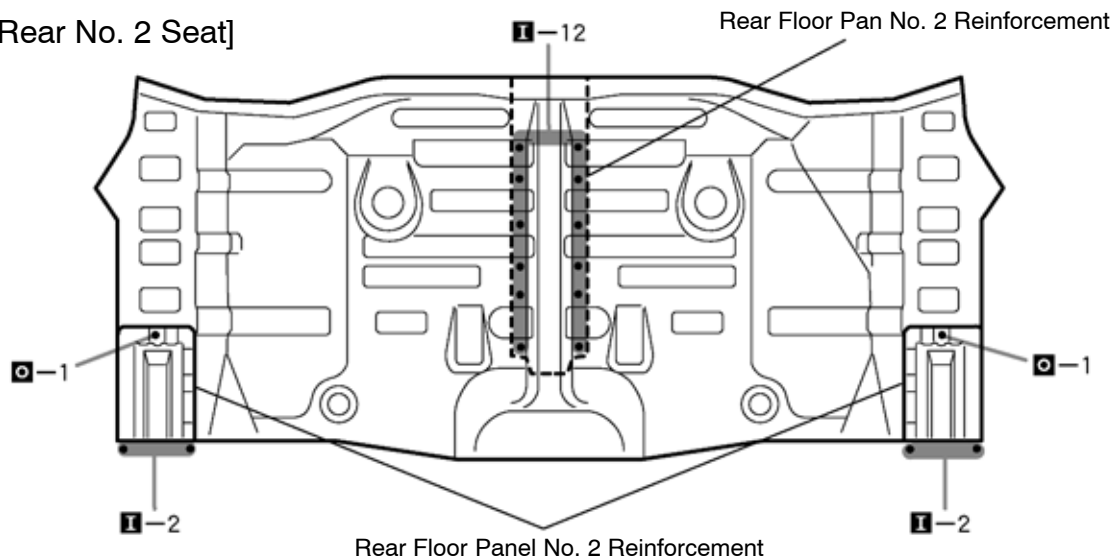
Symbol meaning

⊙ I : MIG Plug Weld

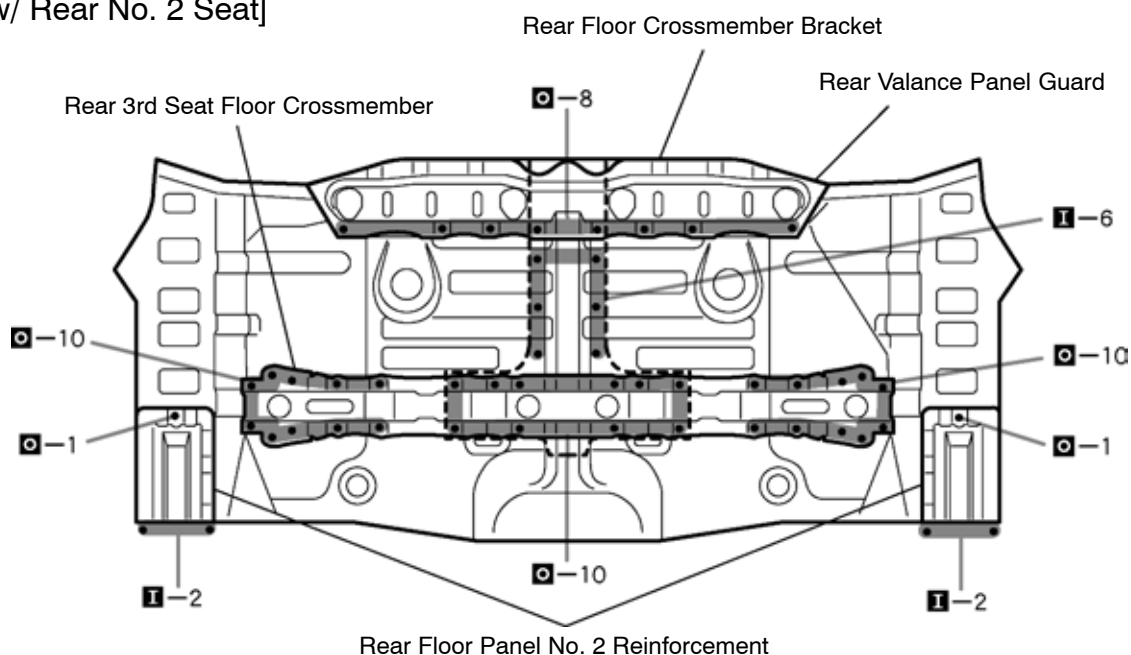
F24722B

INSTALLATION

[w/o Rear No. 2 Seat]



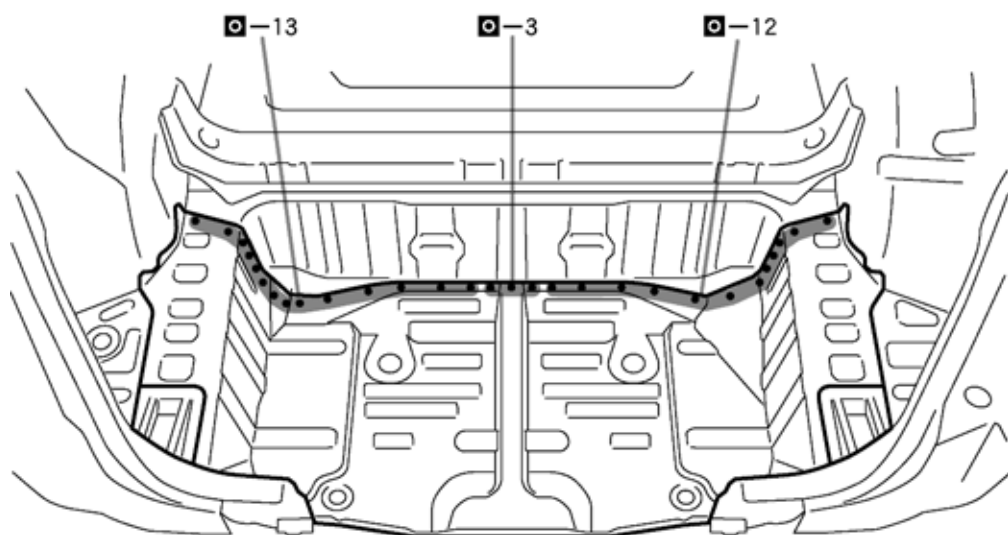
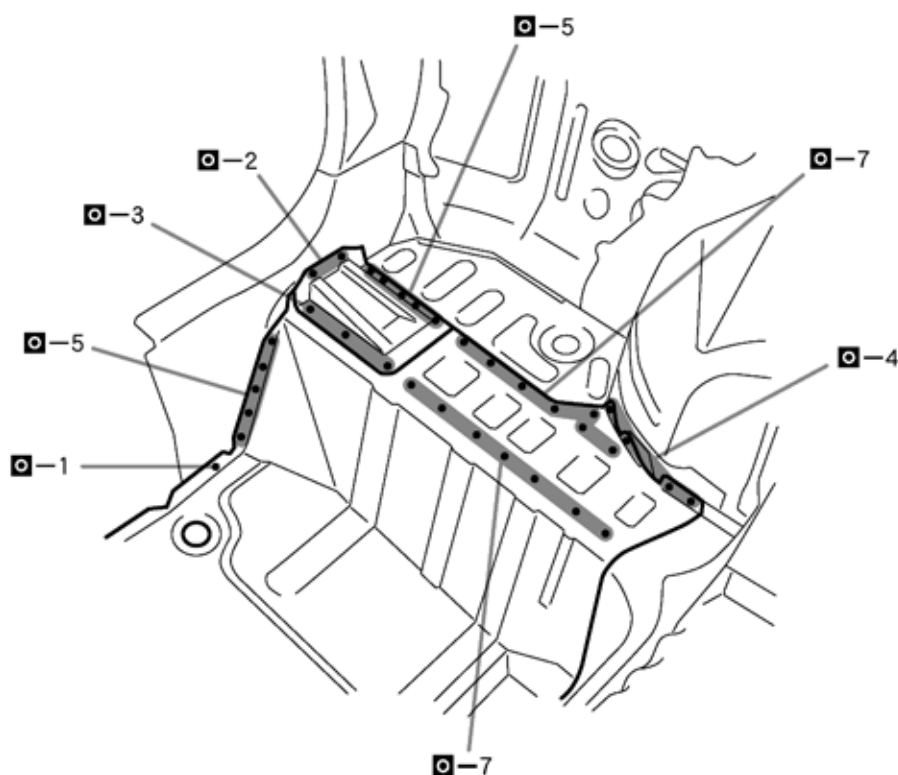
[w/ Rear No. 2 Seat]



F24722

INSTALLATION POINT

- 1 Before temporarily installing the new parts, weld the rear floor panel No. 2 reinforcement, rear valance panel guard, rear floor crossmember bracket and 3rd seat floor crossmember with the standard number of welding points.



F24723

INSTALLATION POINT

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

SIDE MEMBER TO FLOOR REINFORCE (ASSY)



F24724A

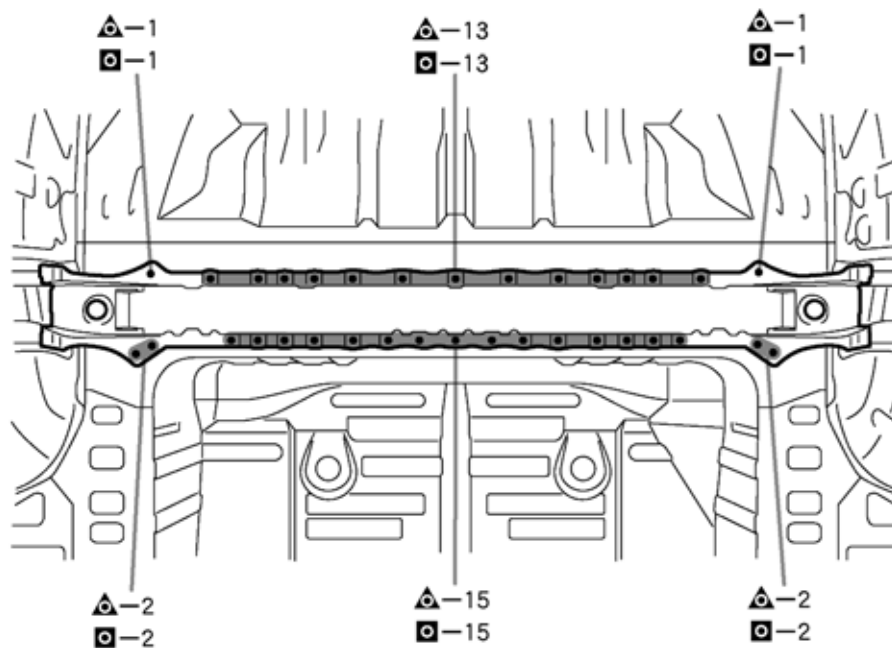
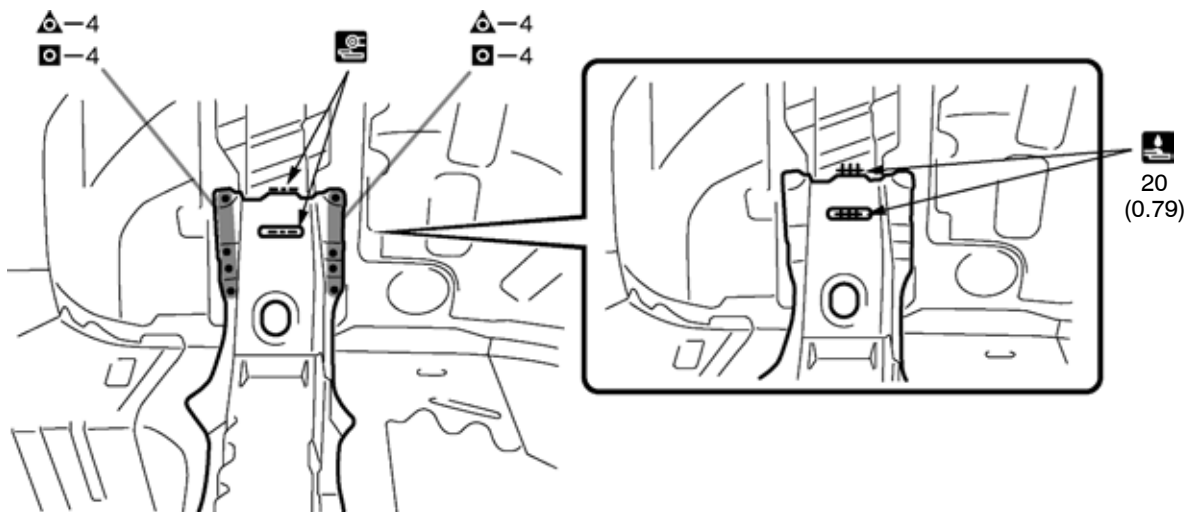
Symbol meaning

REMOVAL  : Remove Weld Points  : Cut with disc sander, etc.

INSTALLATION  : MIG Plug Weld  : Tack Weld

F24724B

REMOVAL-INSTALLATION



mm (in.)

F24724

INSTALLATION POINT

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

Symbol meaning

INSTALLATION  **M I** : MIG Plug Weld

F24725B

INSTALLATION POINT

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

REAR FLOOR CROSSMEMBER NO. 3 (ASSY)



F24726A

With the rear floor side panel front extension removed.

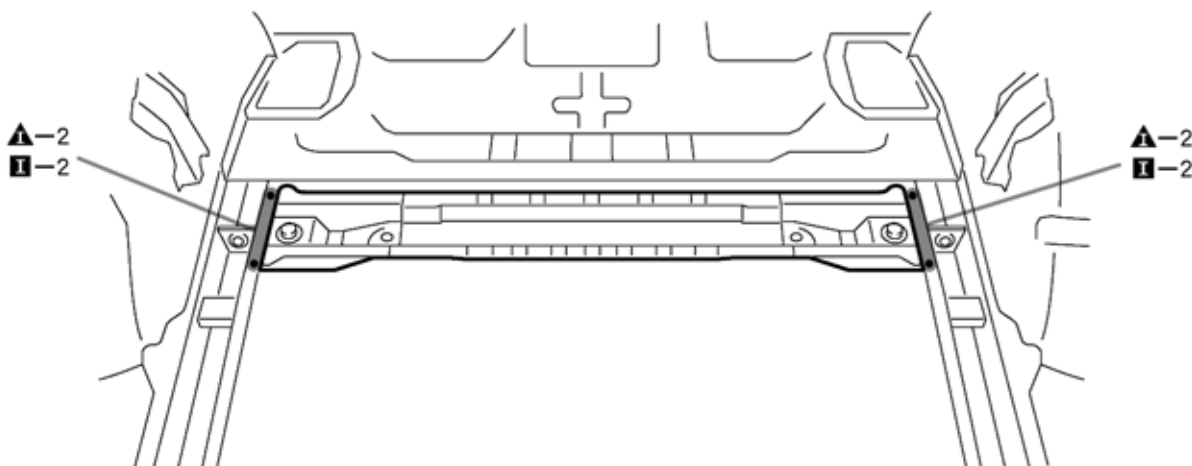
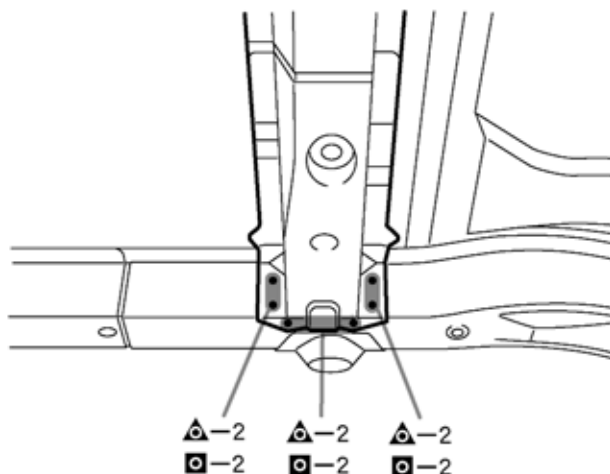
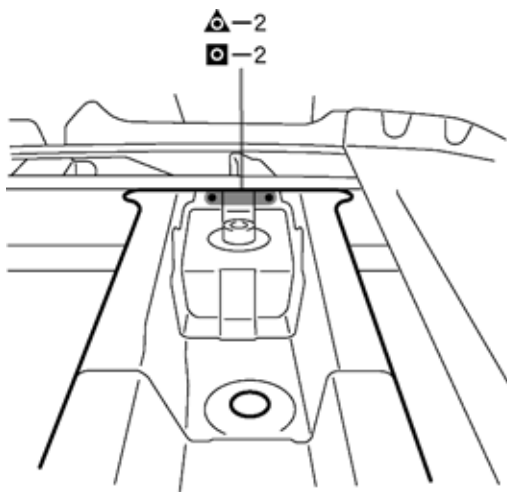
Symbol meaning

REMOVAL : Remove Weld Points

INSTALLATION : MIG Plug Weld

F24726B

REMOVAL-INSTALLATION



F24726

INSTALLATION POINT

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

REAR FLOOR SIDE PANEL (ASSY): Short Body



F24727A

With the body lower back inner panel removed.

Symbol meaning

REMOVAL

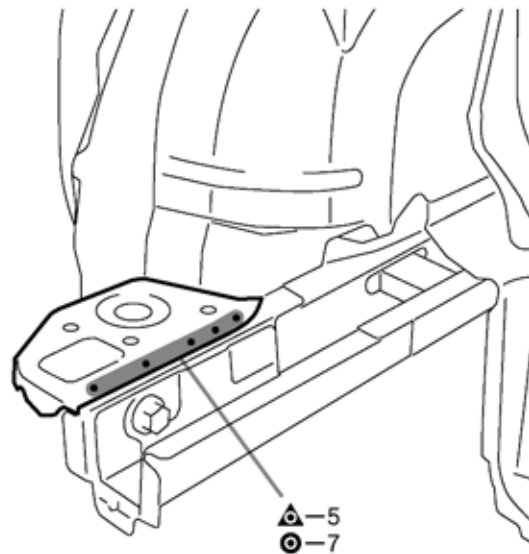
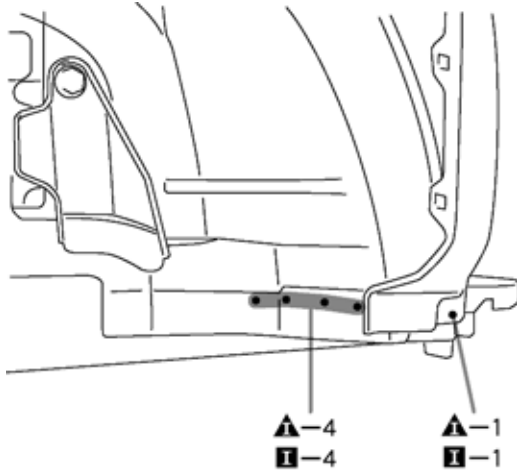
▲ ▲ : Remove Weld Points

INSTALLATION

■ : MIG Plug Weld ● : Spot Weld

F24727B

REMOVAL·INSTALLATION



F24727

INSTALLATION POINT

- 1 After welding, apply body sealer and undercoating to the corresponding parts. (See the paint-coating)

REAR FLOOR SIDE PANEL (ASSY): Long Body



F24728A

With the body lower back inner panel removed.

Symbol meaning

REMOVAL

▲ ▲ : Remove Weld Points

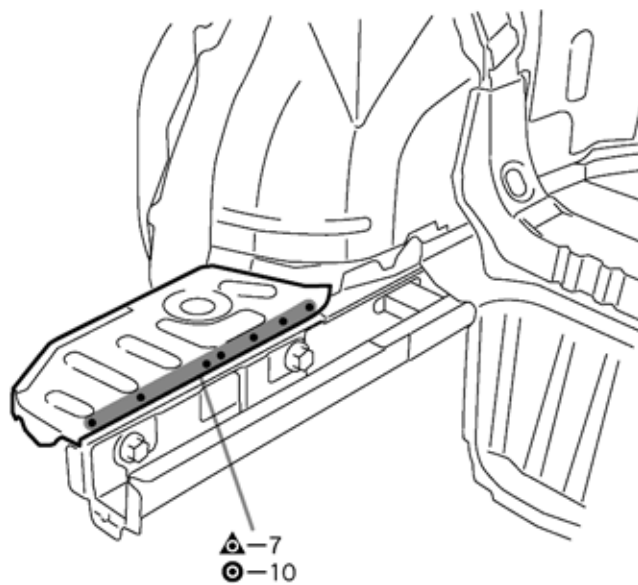
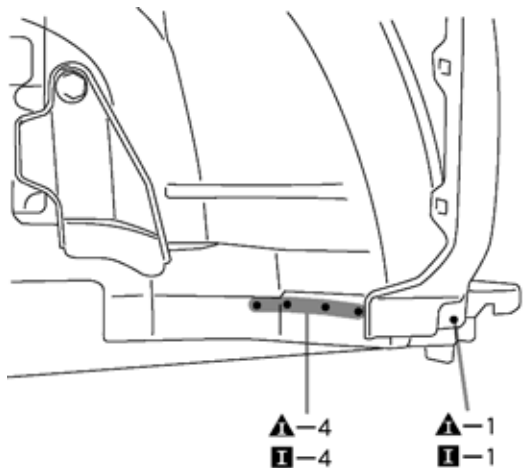
INSTALLATION

■ : MIG Plug Weld

● : Spot Weld

F24728B

REMOVAL-INSTALLATION



F24728

INSTALLATION POINT

- 1 After welding, apply body sealer and undercoating to the corresponding parts. (See the paint-coating)

REAR FLOOR SIDE REAR MEMBER (ASSY): Short Body



F24729A

With the body lower back inner panel and rear floor pan removed.

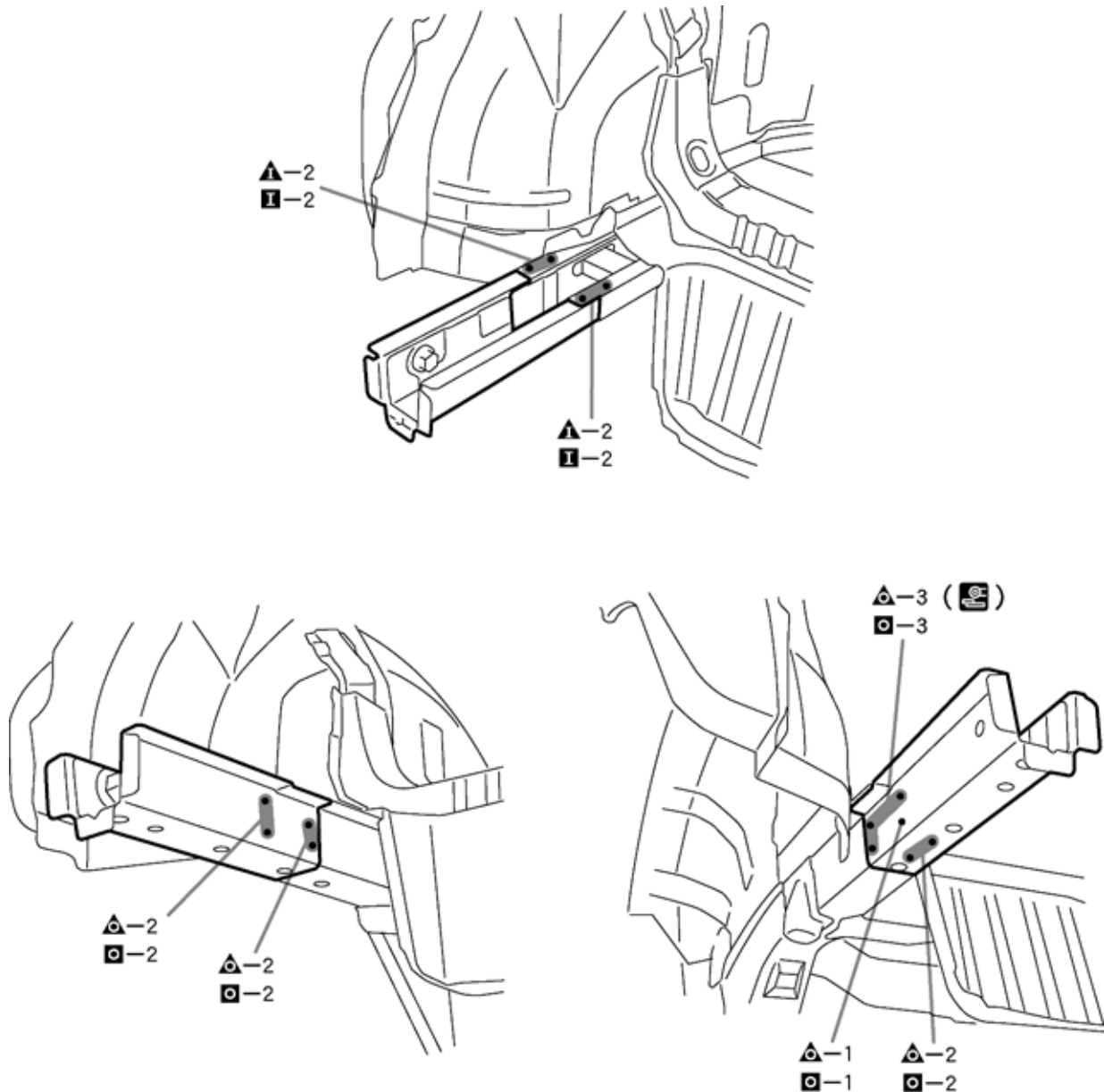
Symbol meaning

REMOVAL   : Remove Weld Points  : Cut with disc sander, etc.

INSTALLATION   : MIG Plug Weld

F24729B

REMOVAL-INSTALLATION



F24729

INSTALLATION POINT

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

REAR FLOOR SIDE REAR MEMBER (ASSY): Long Body



F24730A

With the body lower back inner panel and rear floor pan removed.

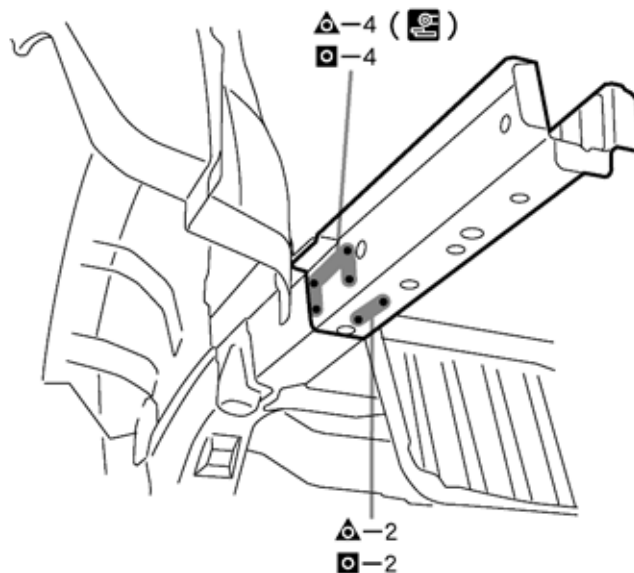
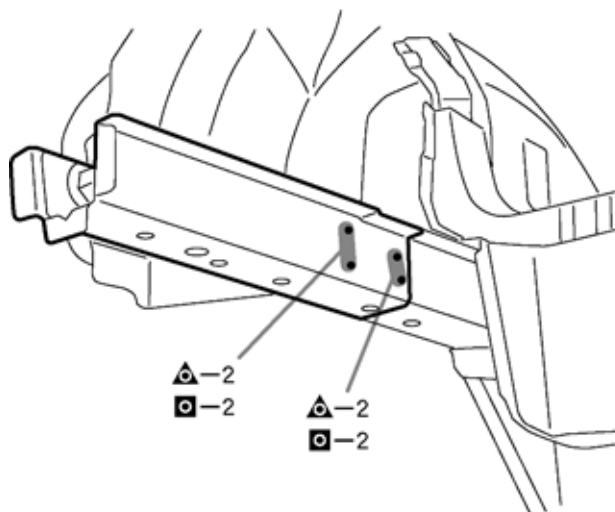
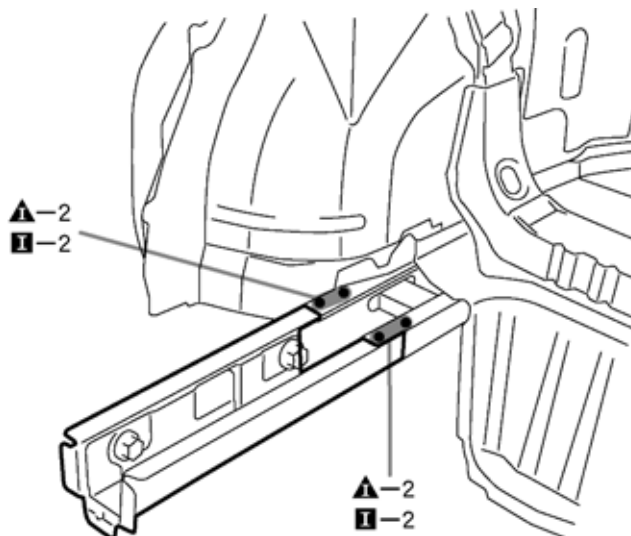
Symbol meaning

REMOVAL   : Remove Weld Points  : Cut with disc sander, etc.

INSTALLATION   : MIG Plug Weld

F24730B

REMOVAL-INSTALLATION



F24730

INSTALLATION POINT

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

ROOF PANEL (ASSY): w/o Sliding Roof (Short Body)



F24731A

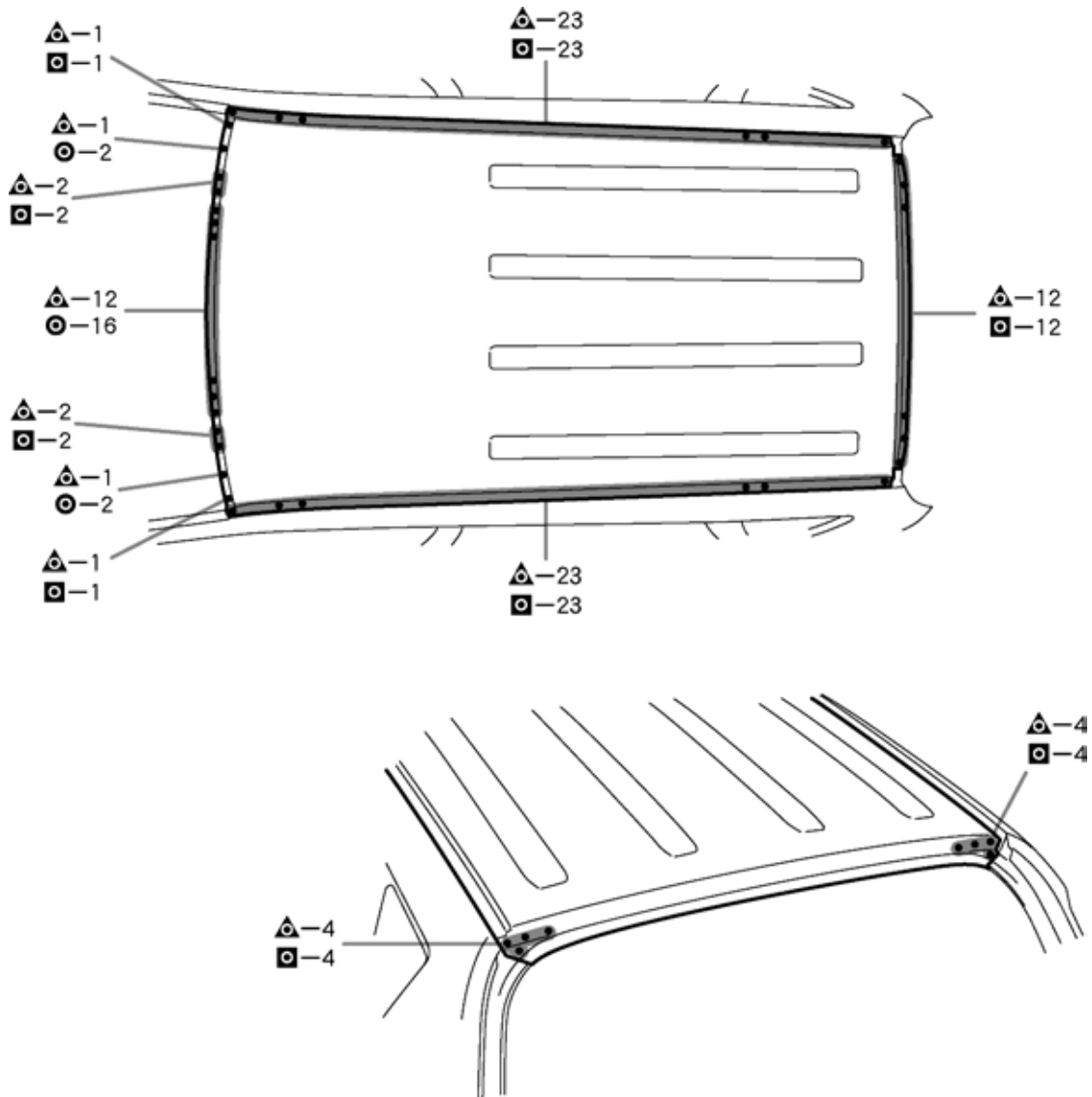
Symbol meaning

REMOVAL  : Remove Weld Points

INSTALLATION  : MIG Plug Weld  : Spot Weld  : Body Sealer

F24731B

REMOVAL-INSTALLATION



F24731

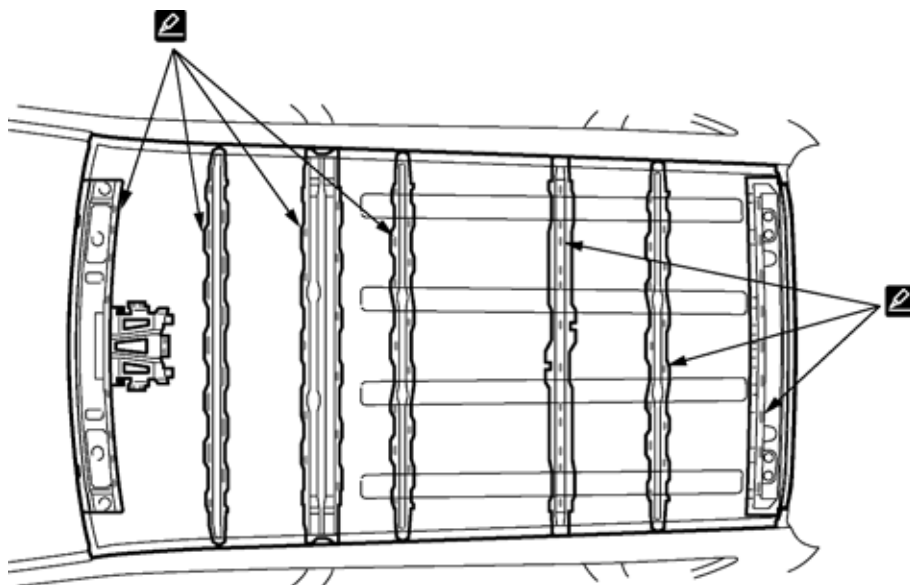
INSTALLATION POINT

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

Symbol meaning

REMOVAL  : Remove Weld PointsINSTALLATION  : MIG Plug Weld  : Spot Weld  : Body Sealer

F24732B



F24732

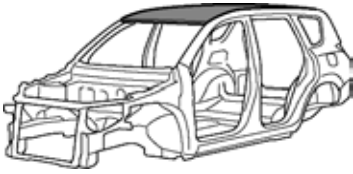
INSTALLATION POINT

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

HINT:

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

ROOF PANEL (ASSY): w/o Sliding Roof (Long Body)



F24733A

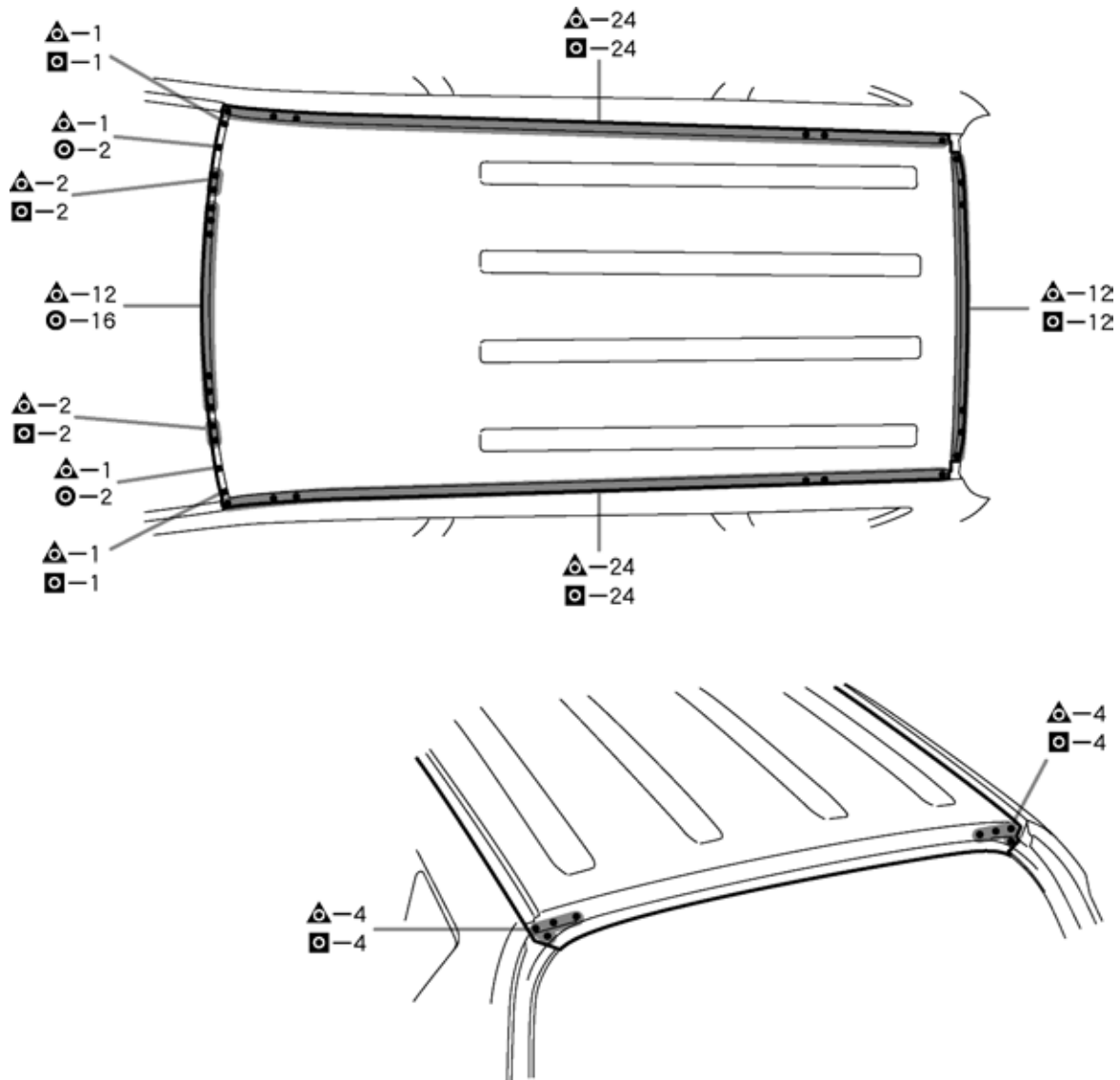
Symbol meaning

REMOVAL : Remove Weld Points

INSTALLATION : MIG Plug Weld : Spot Weld : Body Sealer

F24733B

REMOVAL-INSTALLATION



F24733

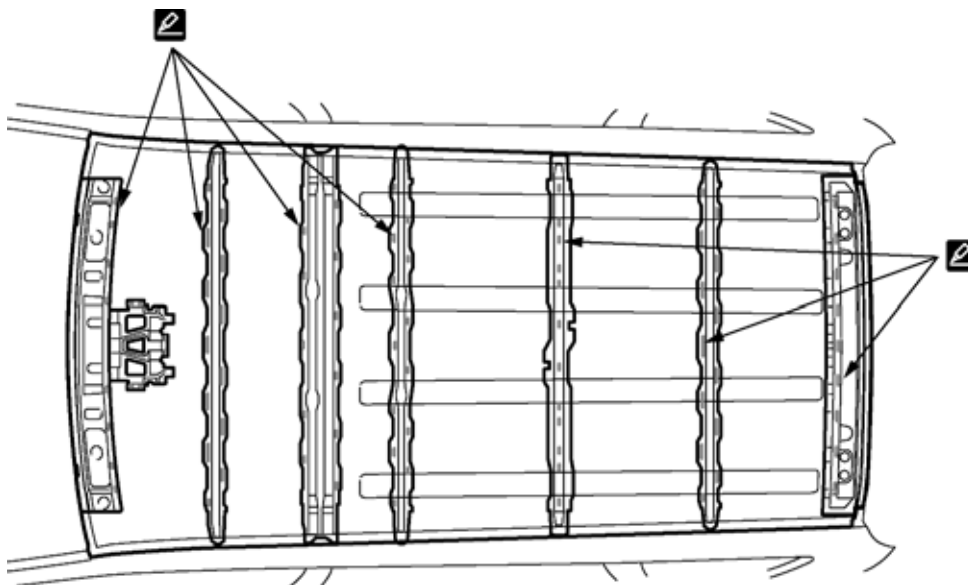
INSTALLATION POINT

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

Symbol meaning

REMOVAL  : Remove Weld PointsINSTALLATION  : MIG Plug Weld  : Spot Weld  : Body Sealer

F24734B



F24734

INSTALLATION POINT

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

HINT:

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

ROOF PANEL (ASSY): w/ Sliding Roof (Short Body)



F24735A

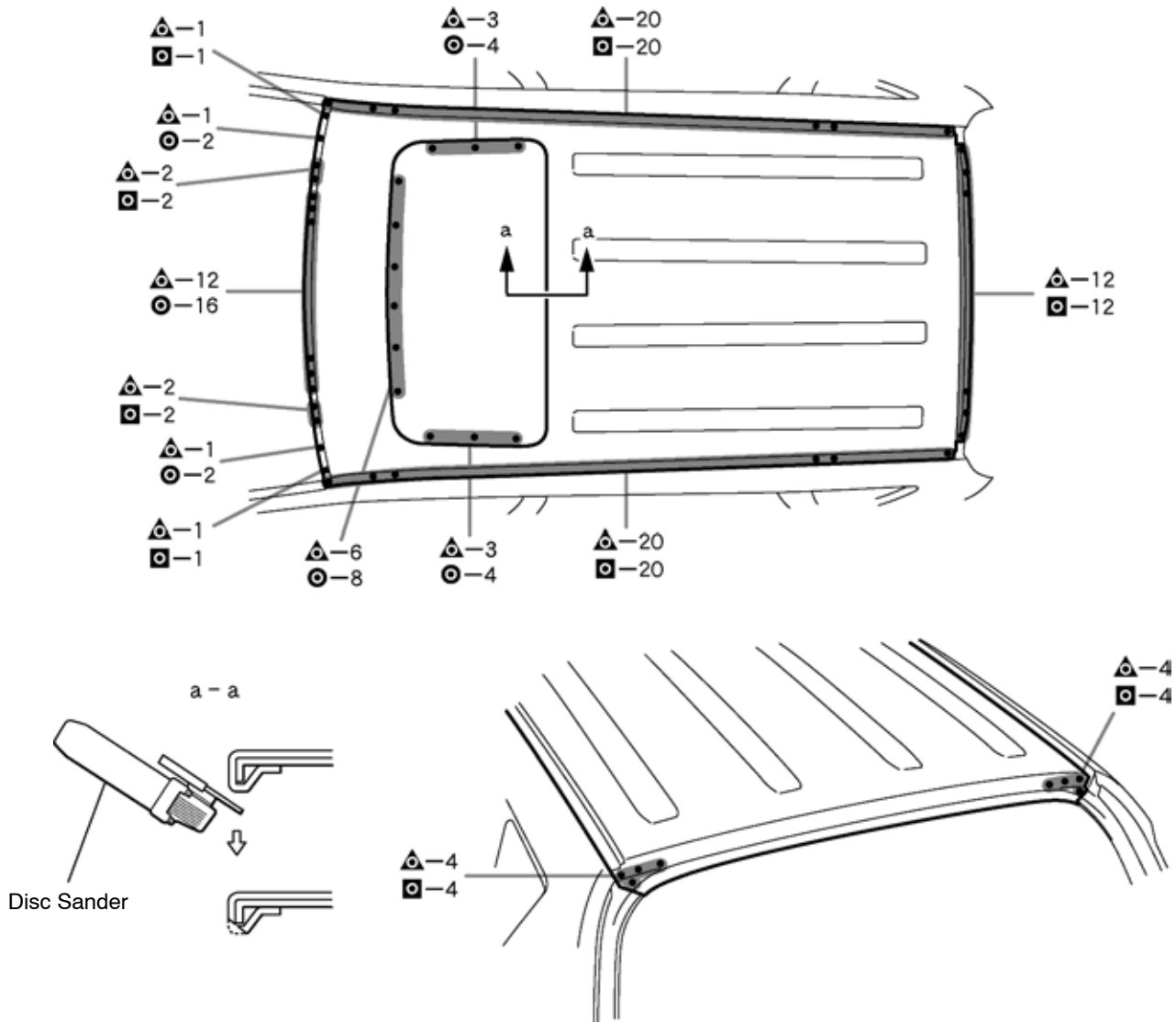
Symbol meaning

REMOVAL : Remove Weld Points

INSTALLATION : MIG Plug Weld : Spot Weld : Body Sealer

F24735B

REMOVAL·INSTALLATION



F24735

REMOVAL POINT

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

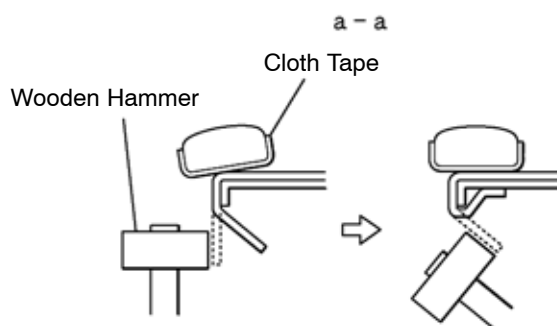
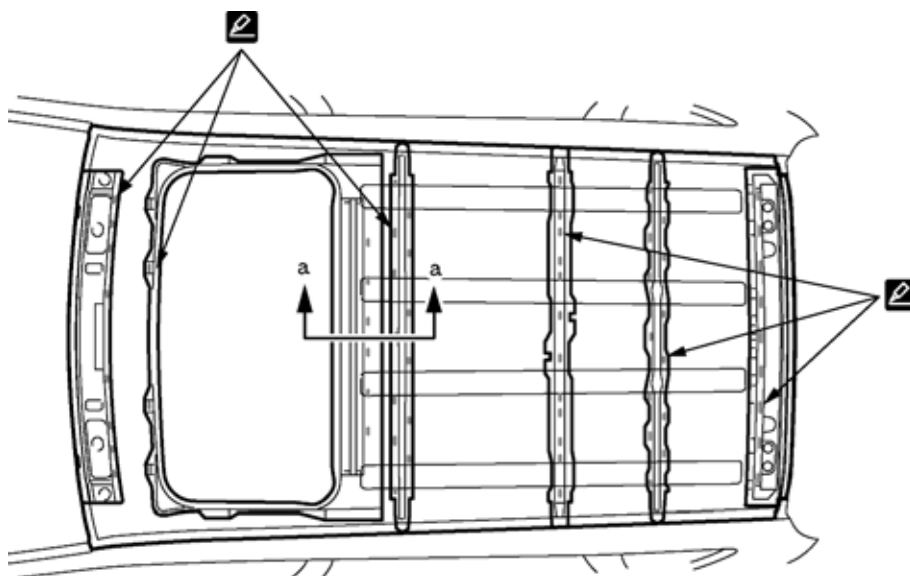
INSTALLATION POINT

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

Symbol meaning

REMOVAL  : Remove Weld PointsINSTALLATION  : MIG Plug Weld  : Spot Weld  : Body Sealer

F24736B



F24736

INSTALLATION POINT

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

HINT:

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

- 2 Bend the flange hem with a wooden hammer and dolly.

HINT:

- 1) Perform hemming three steps, being careful not to warp the panel.

ROOF PANEL (ASSY): w/ Sliding Roof (Long Body)



F24737A

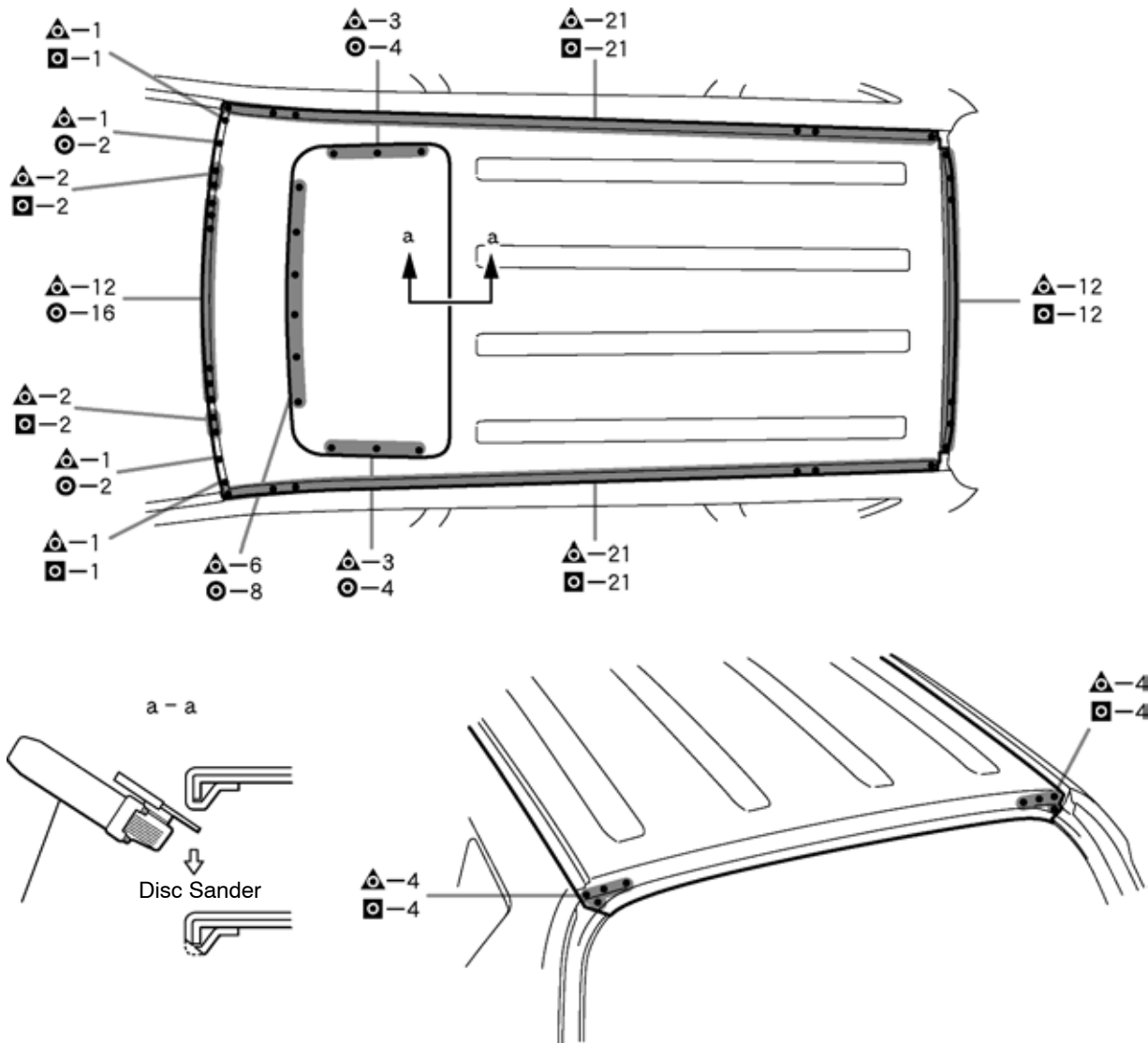
Symbol meaning

REMOVAL  : Remove Weld Points

INSTALLATION  : MIG Plug Weld  : Spot Weld  : Body Sealer

F24737B

REMOVAL-INSTALLATION



F24737

REMOVAL POINT

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

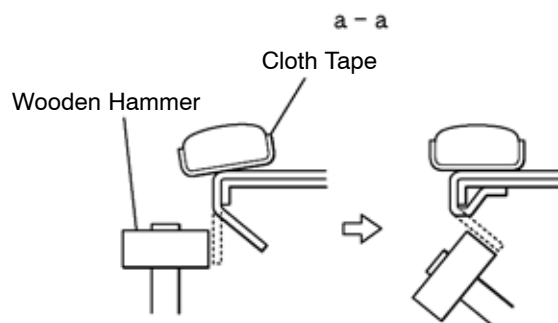
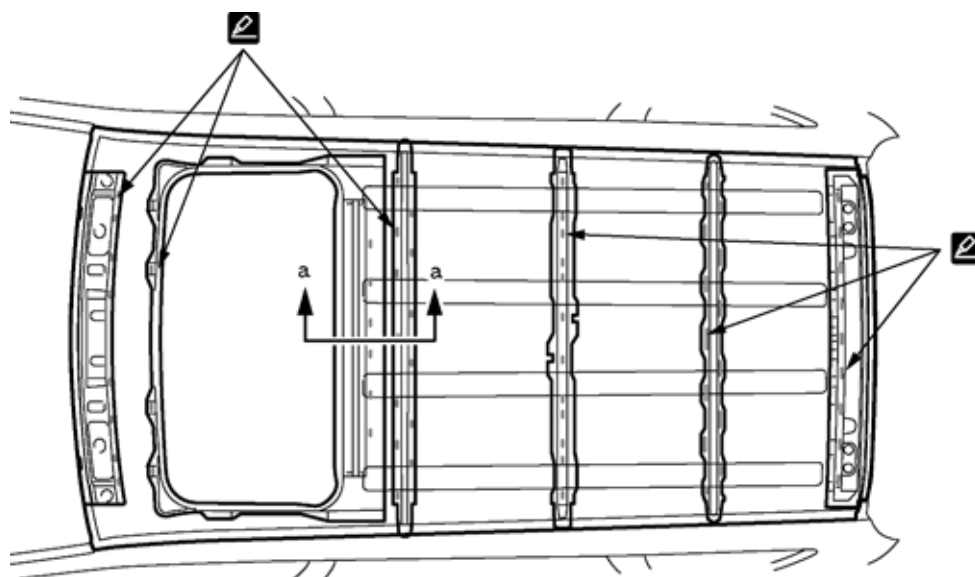
INSTALLATION POINT

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

Symbol meaning

REMOVAL  : Remove Weld PointsINSTALLATION  : MIG Plug Weld  : Spot Weld  : Body Sealer

F24738B



F24738

INSTALLATION POINT

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

HINT:

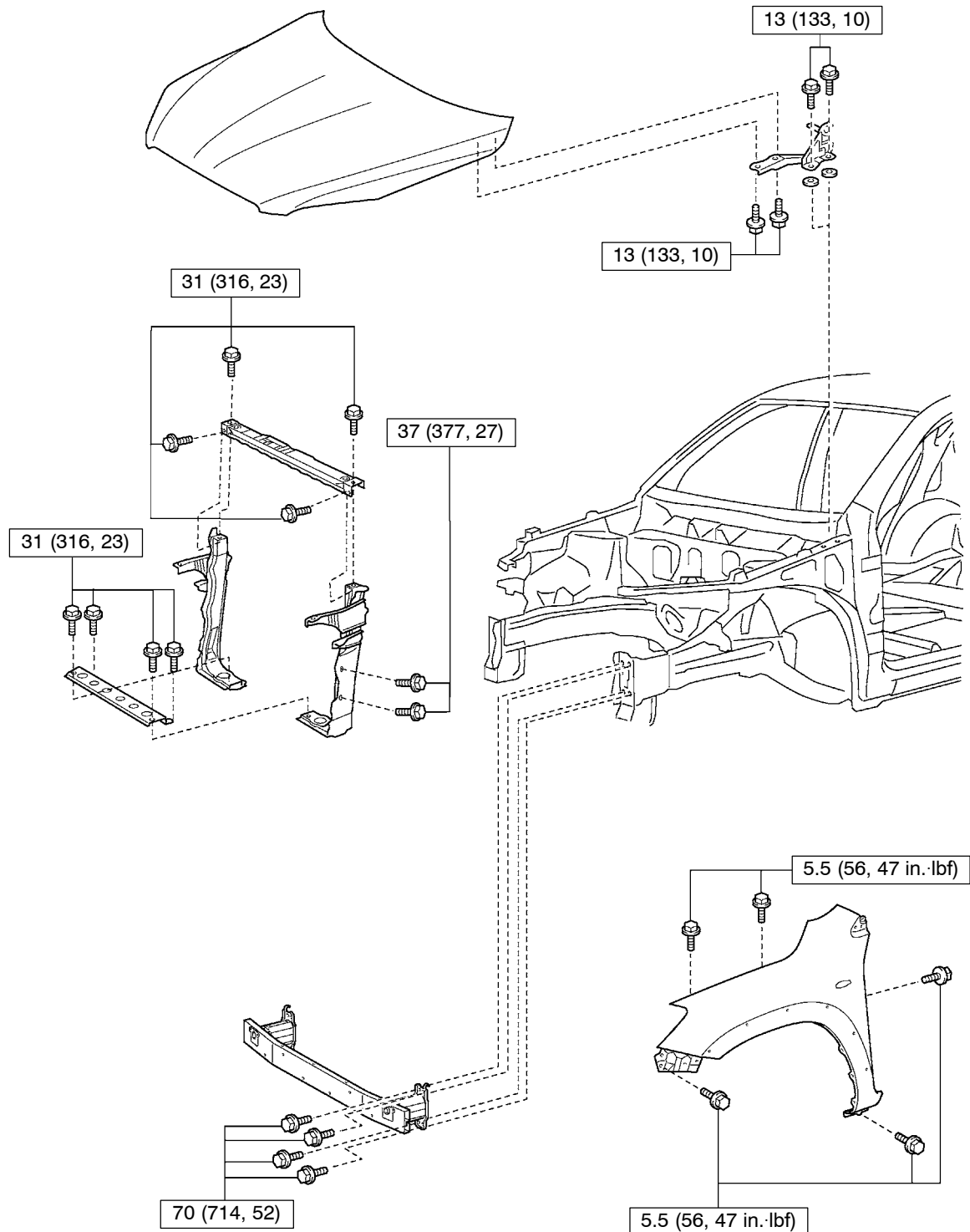
- 1) Apply just enough sealer for the new parts to make contact.

- 2 Bend the flange hem with a wooden hammer and dolly.

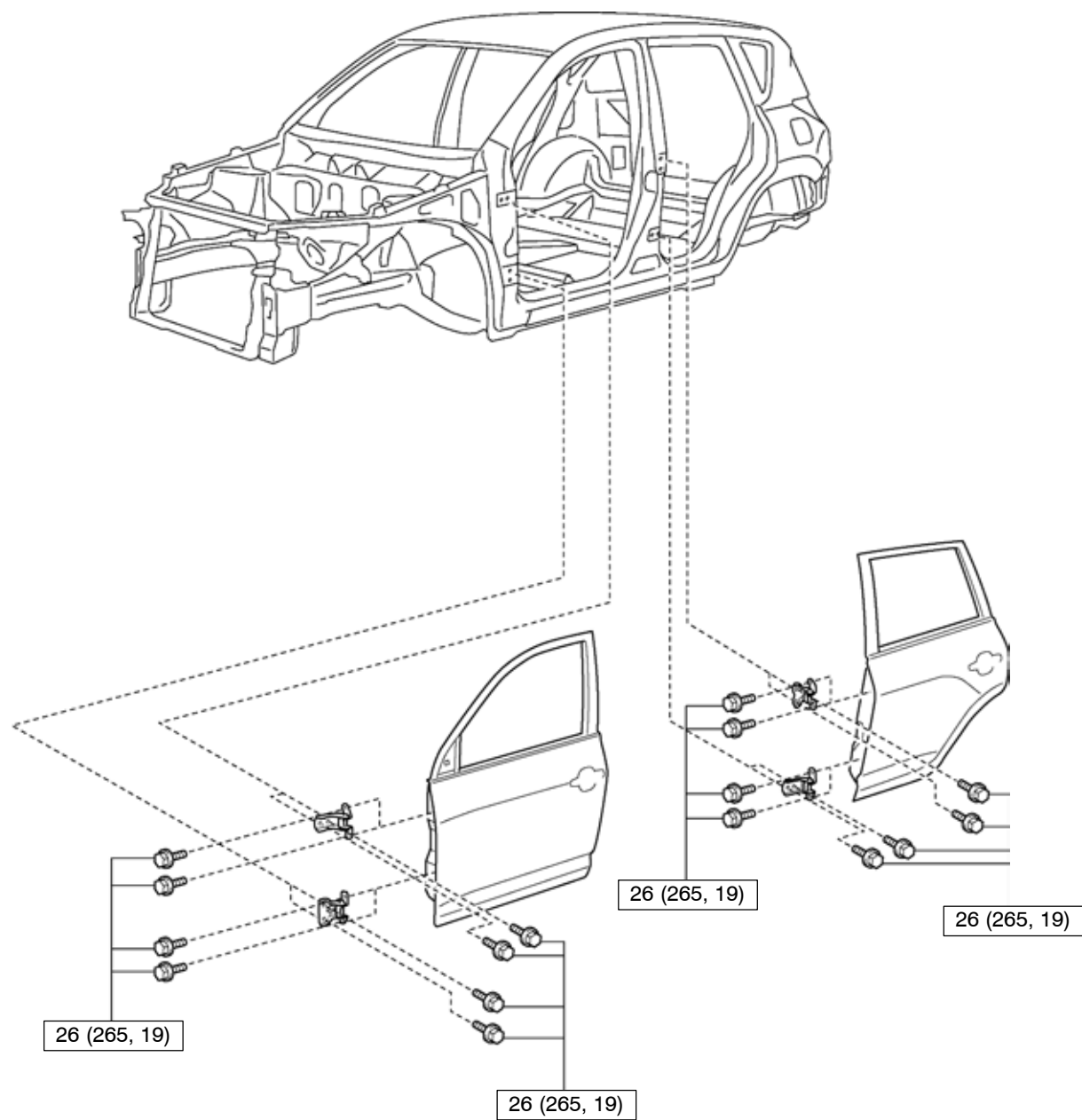
HINT:

- 1) Perform hemming three steps, being careful not to warp the panel.

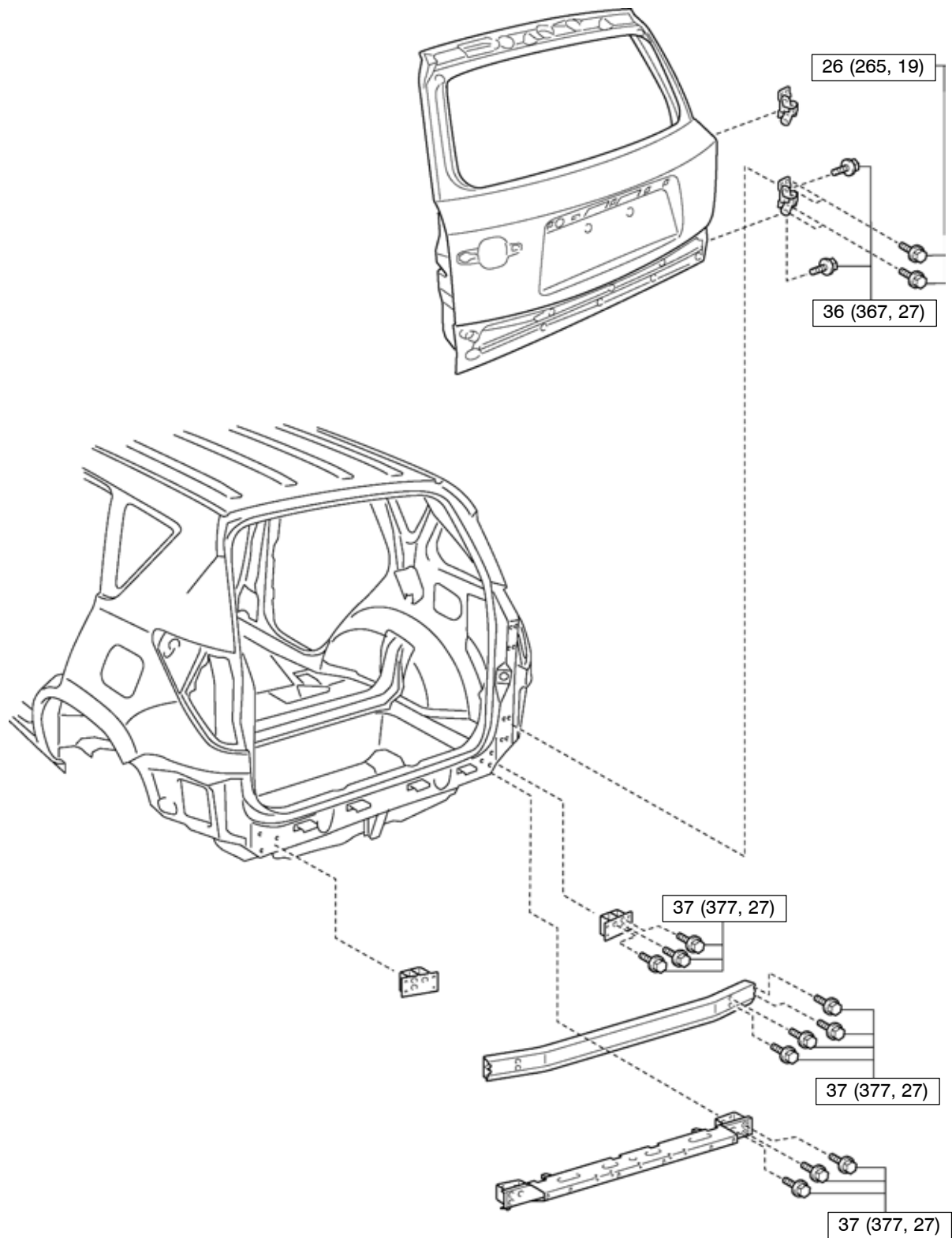
OUTER PANEL INSTALLATION TORQUE



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



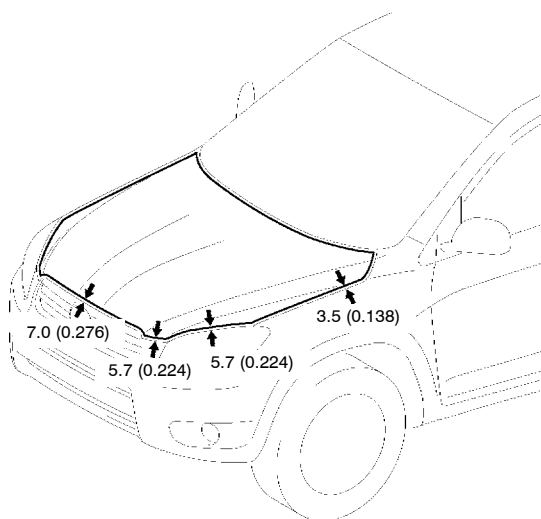
N·m (kgf·cm, ft·lbf) : Specified torque



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

FIT STANDARD/ADJUSTMENT METHOD/TORQUE SPECIFICATION

HOOD SUB-ASSEMBLY



mm (in.)

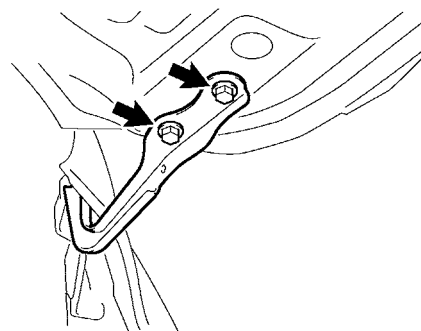
F24760

1. ADJUST HOOD SUB-ASSEMBLY

HINT:

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

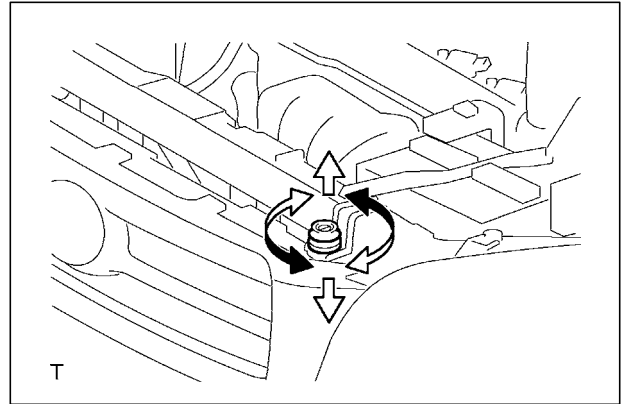
- a. Adjust the hood's position.
 - i. Loosen the hood's 4 hinge bolts.

for LH Side

- ii. Move the hood and adjust the clearance between the hood and front fender. Make sure that the clearance is within the standard range.
 - iii. Tighten the hood's 4 hinge bolts after the adjustment.

Torque:**13 N·m {133 kgf·cm, 10 ft·lbf}**

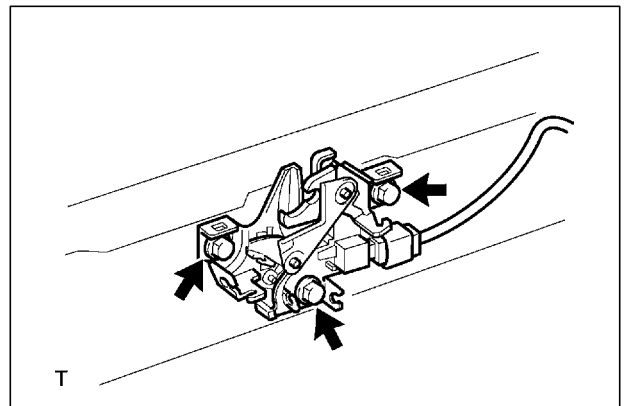
- b. Adjust the cushion rubber so that the height of the hood and fender are aligned.



- i. Raise or lower the hood's front end by turning the cushion rubber. Make sure that the clearance is within standard range.

- c. Adjust the hood lock.

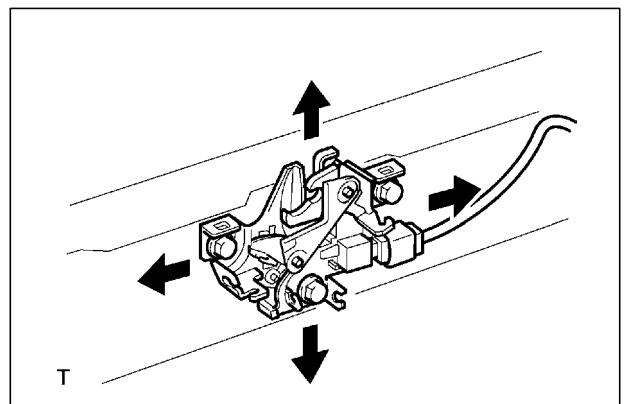
- i. Loosen the 3 bolts.



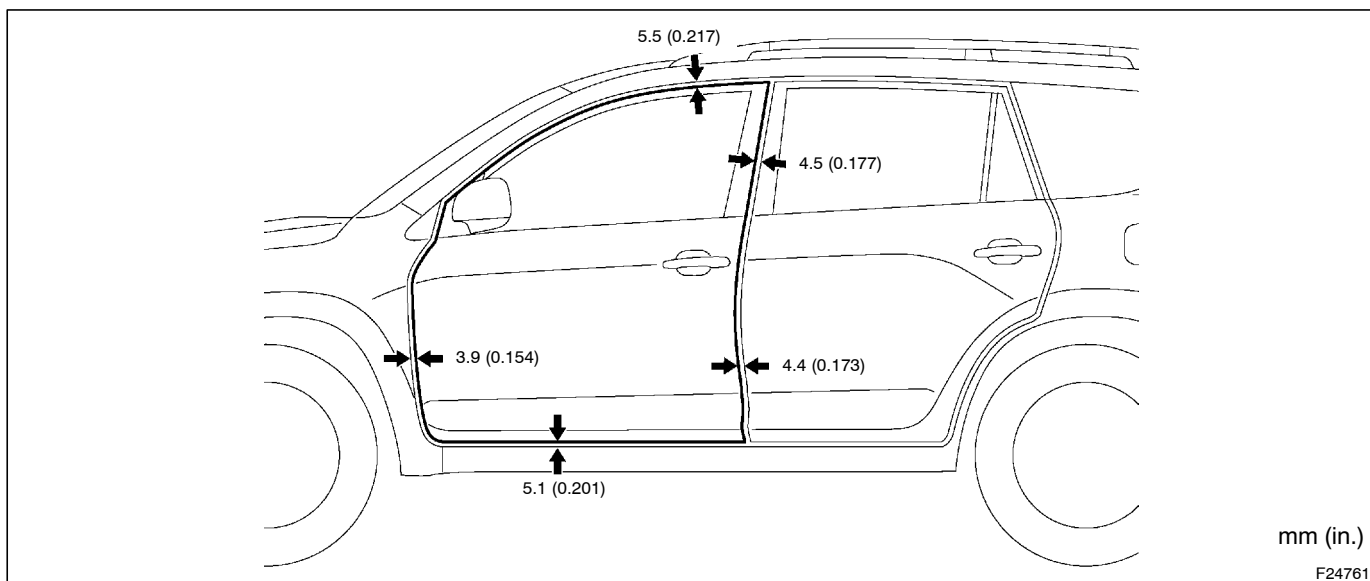
- ii. Adjust the hood lock position so that the striker can enter it smoothly.

- iii. Tighten the 3 bolts after the adjustment.

Torque:
8.0 N·m {82 kgf·cm, 71 in.-lbf}



FRONT DOOR PANEL SUB-ASSEMBLY



1. DISCONNECT CABLE FROM NEGATIVE BATTERY TERMINAL

CAUTION:

Wait at least 90 seconds after disconnecting the cable from the negative (-) battery terminal to prevent airbag and seat belt pretensioner activation.

2. ADJUST FRONT DOOR PANEL SUB-ASSEMBLY LH

HINT:

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

- a. Using SST, loosen the body's hinge bolts and adjust the door's position.

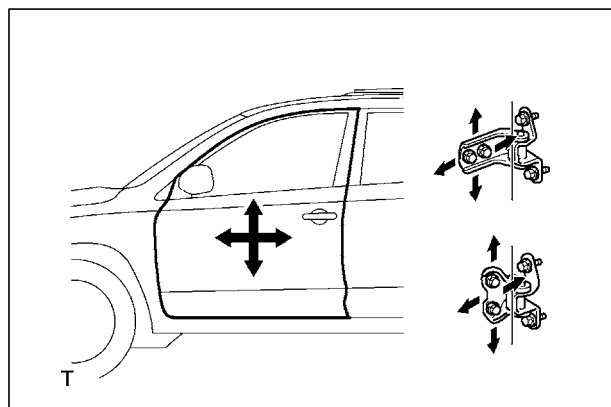
SST

09812-00010

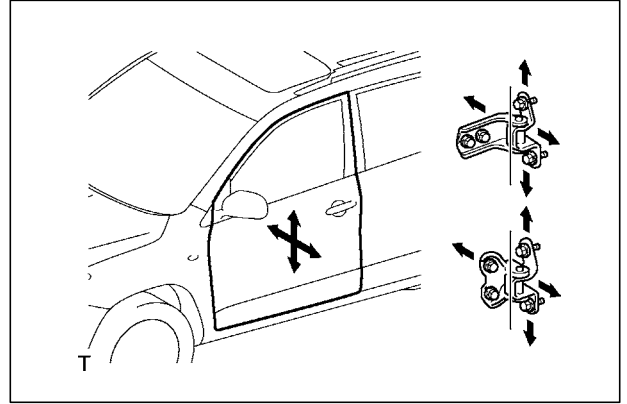
- b. Tighten the body's hinge bolts after the adjustment.

Torque:

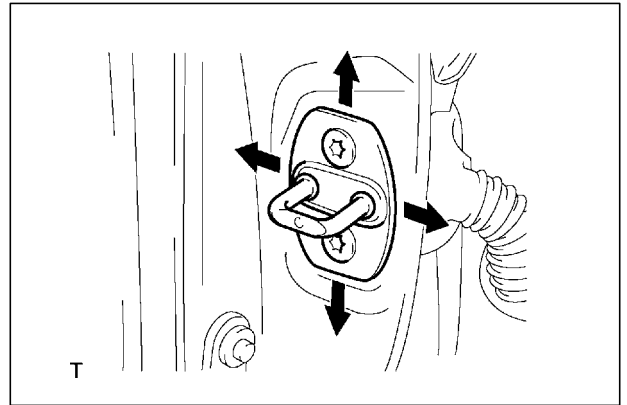
26 N·m {265 kgf·cm, 19 ft·lbf}



- c. Loosen the door's hinge bolts and adjust the door's position.
- d. Tighten the door's hinge bolts after the adjustment.

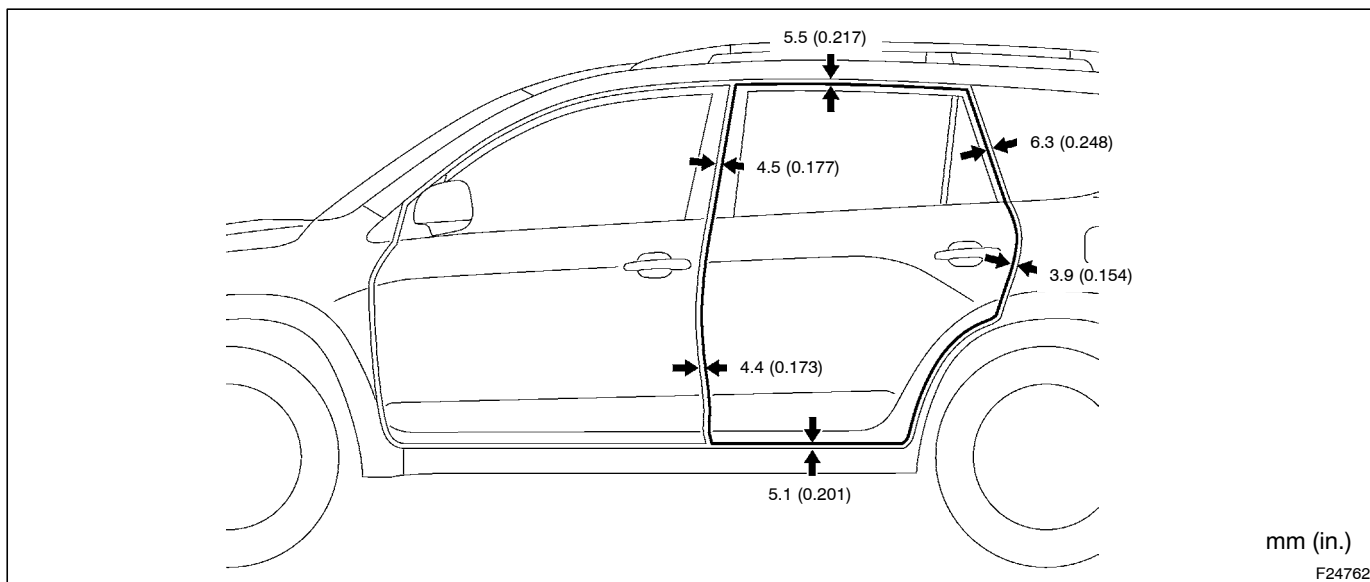
Torque:**26 N·m {265 kgf·cm, 19ft.·lbf}**

- e. Using a T40 “torx” socket, adjust the striker position by slightly loosening the striker mounting screws and then hitting the striker with a plastic-faced hammer.
- f. Using a T40 “torx” socket, tighten the striker mounting screws after the adjustment.

Torque:**23 N·m {235 kgf·cm, 17 ft.·lbf}**

3. CONNECT CABLE TO NEGATIVE BATTERY TERMINAL

REAR DOOR PANEL SUB-ASSEMBLY



1. DISCONNECT CABLE FROM NEGATIVE BATTERY TERMINAL

CAUTION:

Wait at least 90 seconds after disconnecting the cable from the negative (-) battery terminal to prevent airbag and seat belt pretensioner activation.

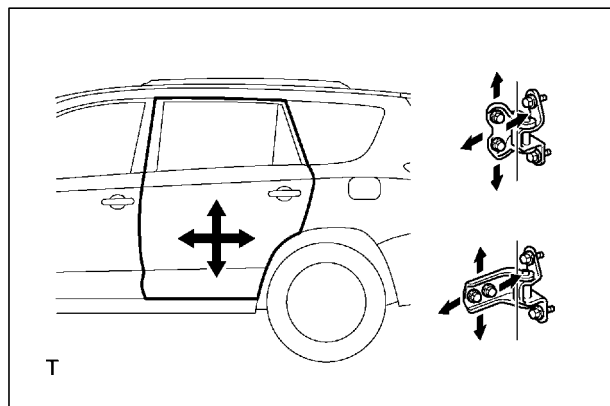
2. ADJUST REAR DOOR PANEL SUB-ASSEMBLY LH

HINT:

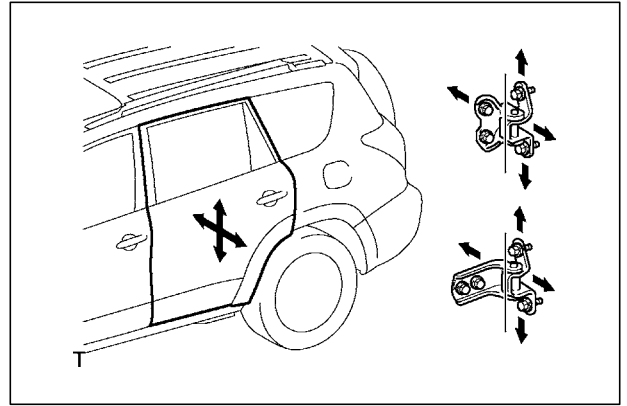
- Use the same procedures for the RH side and LH side.
 - The procedures listed below are for the LH side.
 - Centering bolts are used to mount the door hinge to the vehicle body and door. The door cannot be adjusted with the centering bolts on. Substitute the centering bolts with standard bolts (with washers) when making adjustments.
- Loosen the body's hinge bolts and adjust the door's position.
 - Tighten the body's hinge bolts after the adjustment.

Torque:

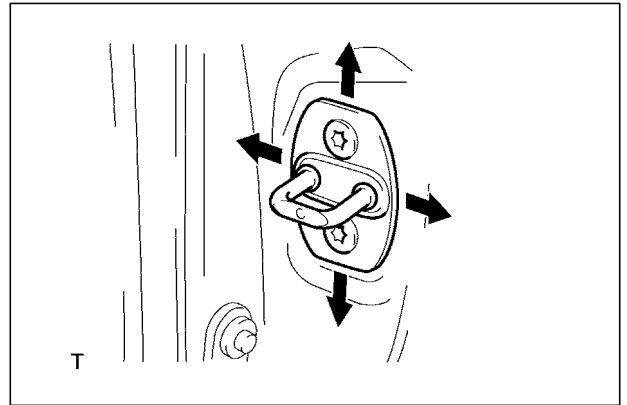
26 N·m {265 kgf·cm, 19 ft·lb}



- c. Loosen the door's hinge bolts and adjust the door's position.
- d. Tighten the door's hinge bolts after the adjustment.

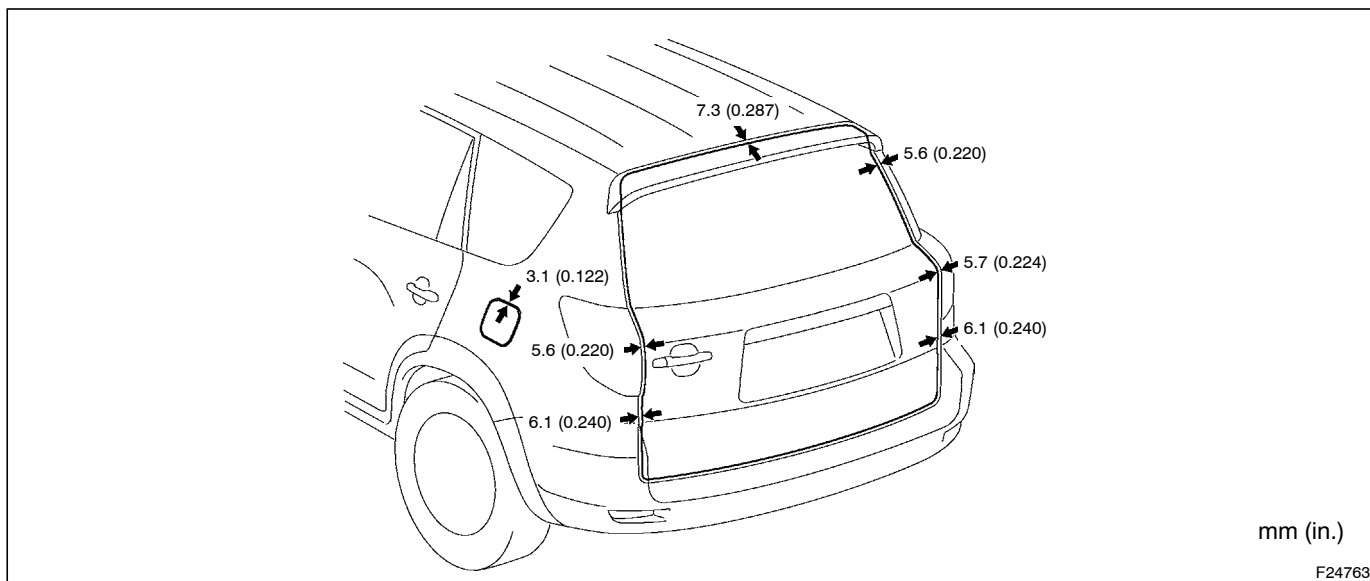
Torque:**26 N·m {265 kgf·cm, 19 ft·lbf}**

- e. Using a T40 "torx" socket, adjust the striker position by slightly loosening the striker mounting screws and then hitting the striker with a plastic-faced hammer.
- f. Using a T30 "torx" socket, tighten the striker mounting screws after the adjustment.

Torque:**23 N·m {235 kgf·cm, 17 ft·lbf}**

3. CONNECT CABLE TO NEGATIVE BATTERY TERMINAL

BACK DOOR



1. ADJUST BACK DOOR

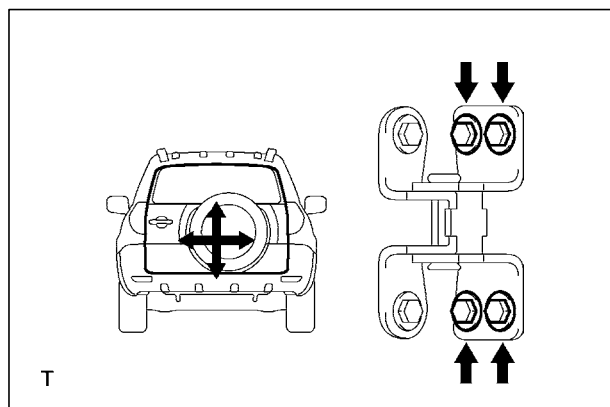
HINT:

Centering bolts are used to mount the door hinge to the vehicle body and door. The door cannot be adjusted with the centering bolts on. Substitute the centering bolts with standard bolts (with washers) when making adjustments.

- Loosen the body's hinge bolts and adjust the door's position.
- Tighten the body's hinge bolts after the adjustment.

Torque:

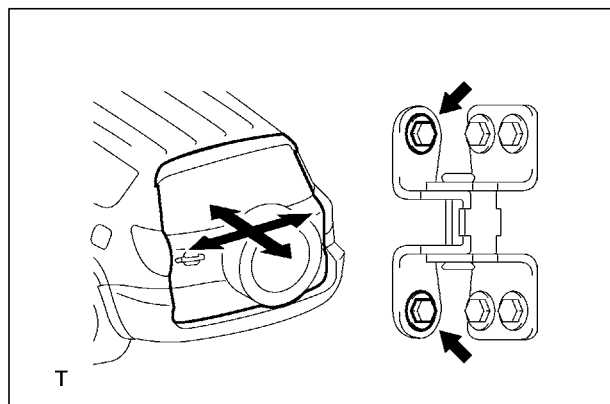
26 N·m {265 kgf·cm, 19 ft·lbf}



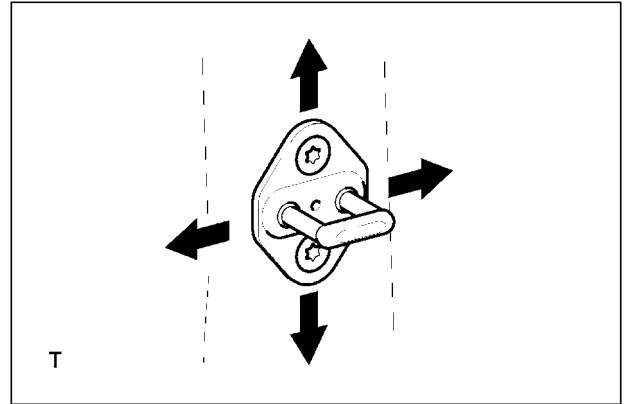
- Loosen the door's hinge bolts and adjust the door's position.
- Tighten the door's hinge bolts after the adjustment.

Torque:

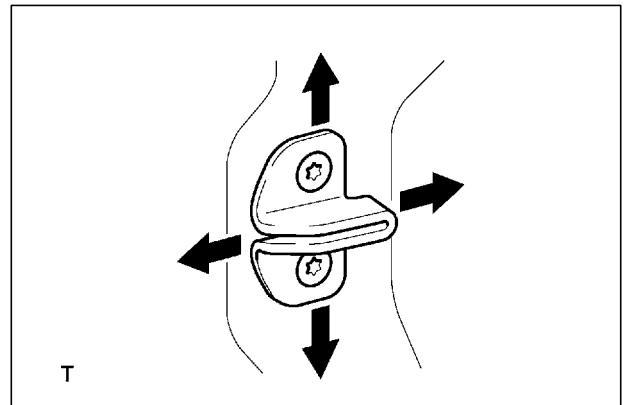
36 N·m {367 kgf·cm, 27 ft·lbf}



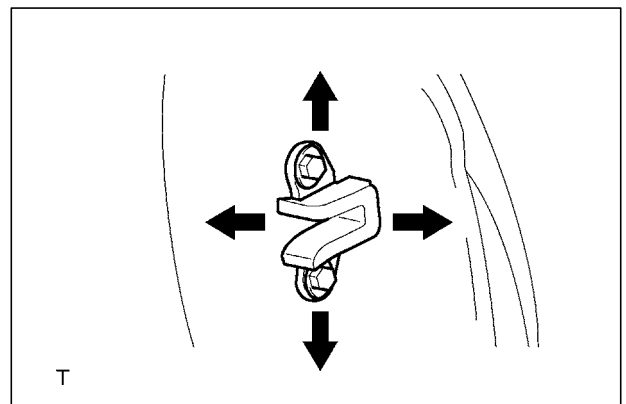
- e. Using a T40 “torx” socket, adjust the striker position by slightly loosening the striker mounting screws and then hitting the striker with a plastic-faced hammer.
- f. Using a T40 “torx” socket, tighten the striker mounting screws after the adjustment.

Torque:**23 N·m {235 kgf·cm, 17 ft·lbf}**

- g. Using a T30 “torx” socket, adjust the side male stopper position by slightly loosening the stopper mounting screws and then hitting the stopper with a plastic-faced hammer.
- h. Using a T30 “torx” socket, tighten the side male stopper mounting screws after the adjustment.



- i. Loosen the side female stopper bolts and adjust the door's position.
- j. Tighten the side female stopper bolts after the adjustment.



NAME PLATE APPLICATION PROCEDURE

- (a) Heat the double-sided tape remaining on the body with an infrared lamp or equivalent.

HINT:

Heat the tape to 40 to 60°C for approximately 1 to 2 minutes.

- (b) Wipe off the remaining double-sided tape using a clean cloth or equivalent.

CAUTION:

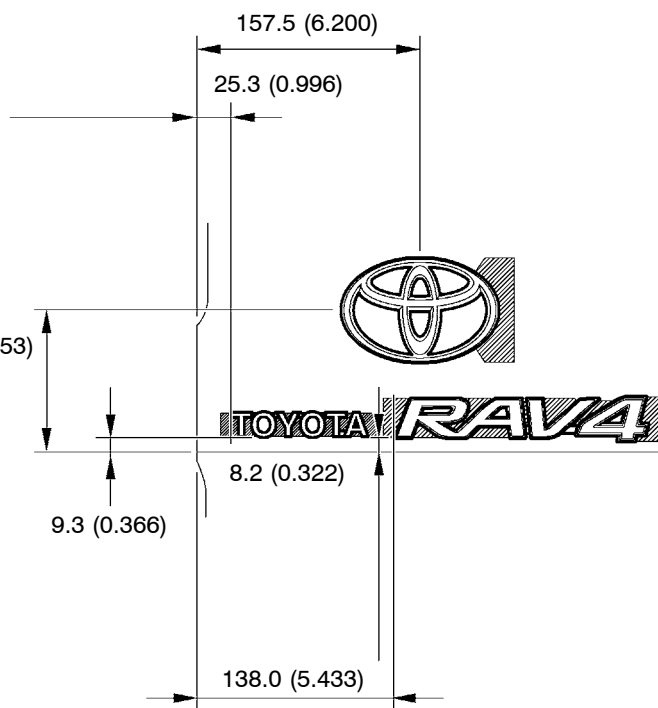
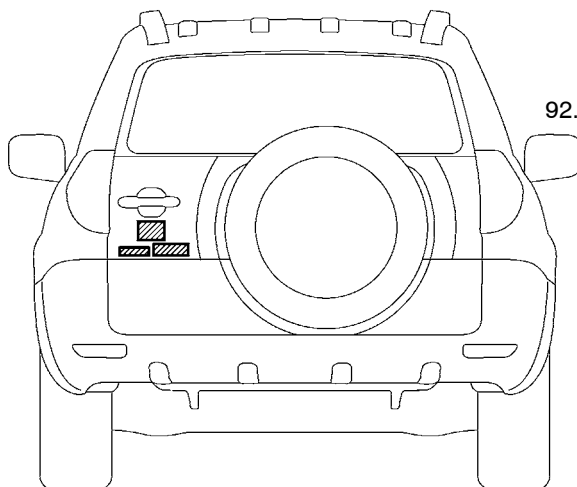
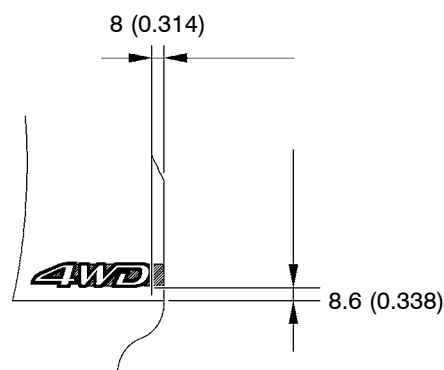
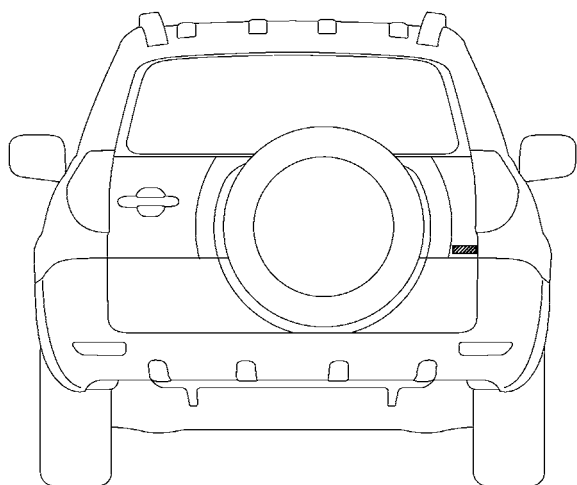
If a name plate is installed without thoroughly removing the remaining double-sided tape from the body, the name plate will not adhere properly. Make sure to thoroughly removing the double-sided tape.

- (c) After cleaning the installation area of the body with degreasing agent, attach the name plate to the position shown in the illustration.

CAUTION:

The working environment should be 20°C when installing the name plate. If the working environment is below 20°C, heat the installation area of the body to 20 to 30°C and then install the name plate.

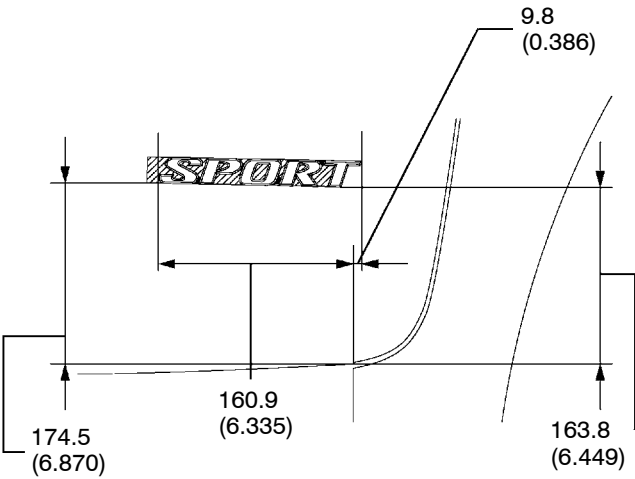
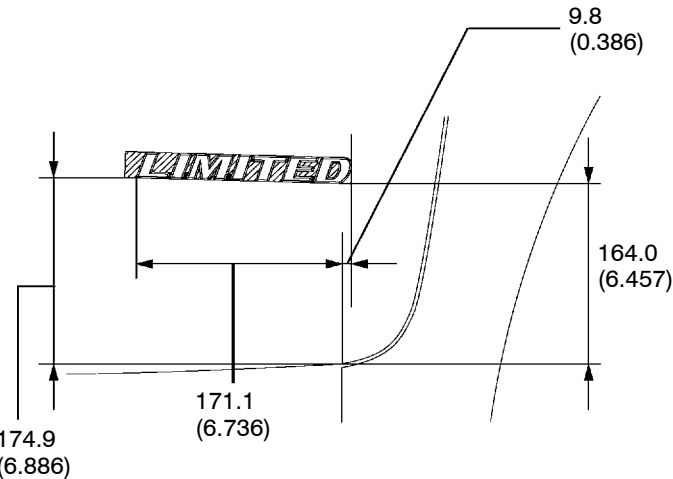
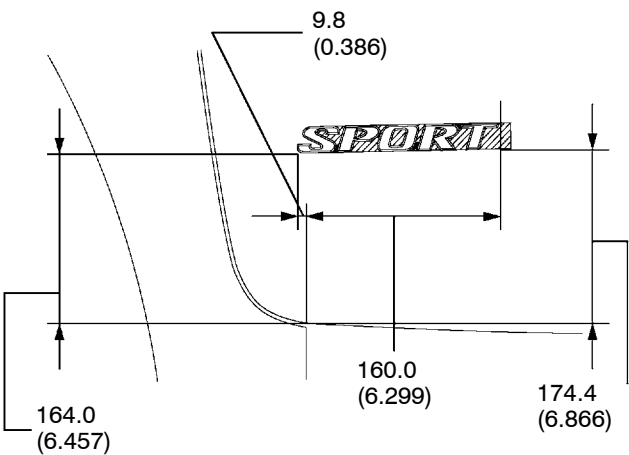
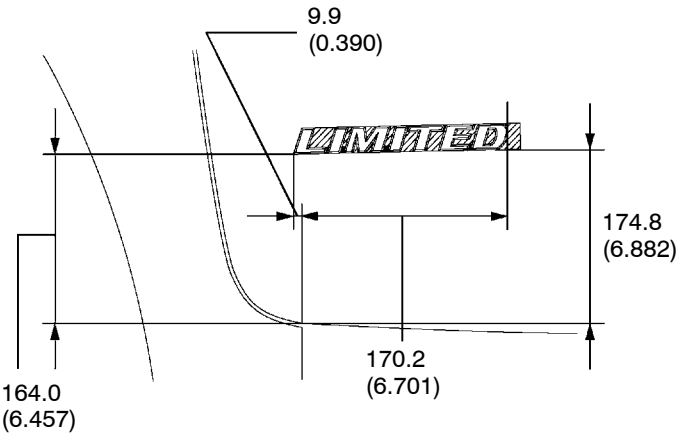
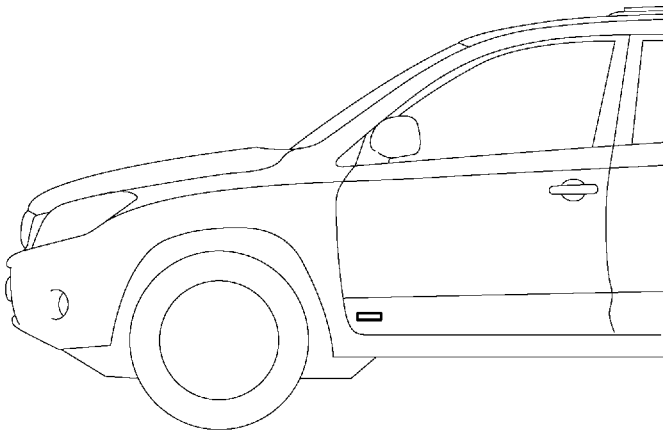
[USA, CANADA]



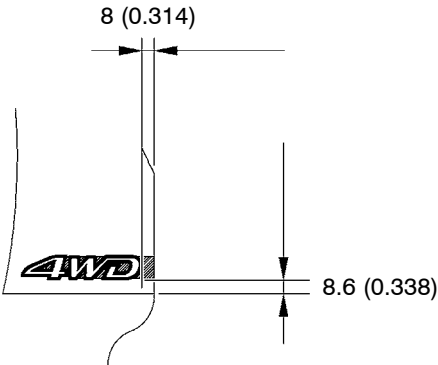
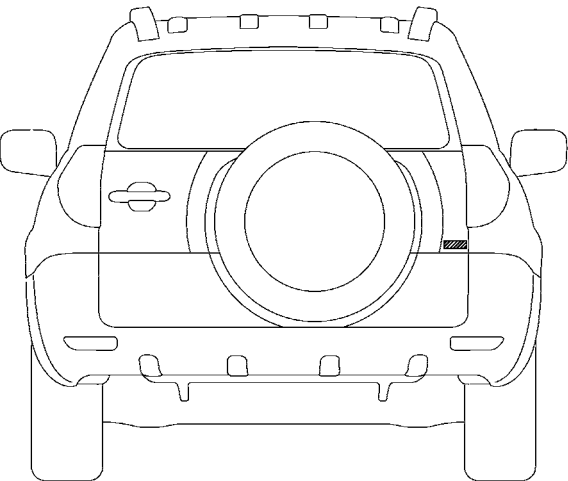
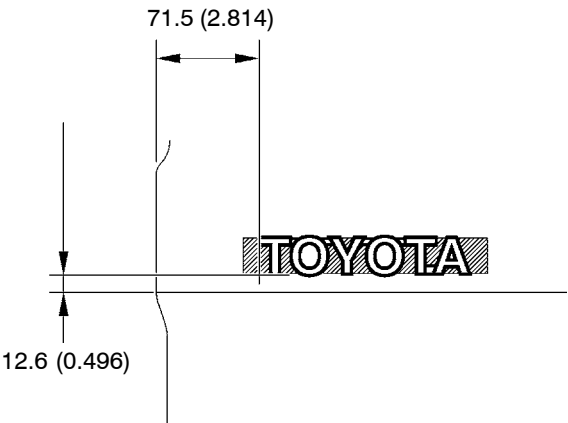
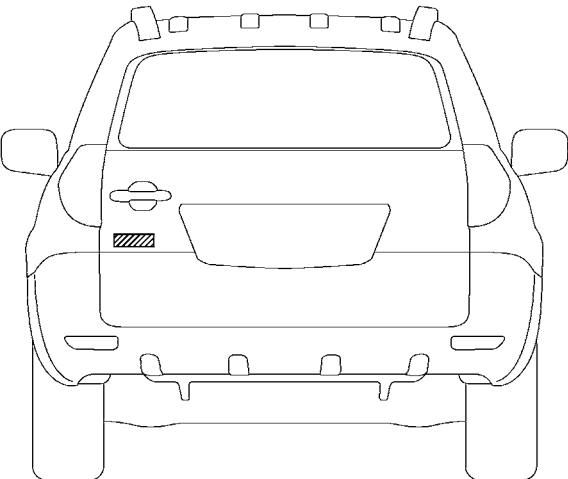
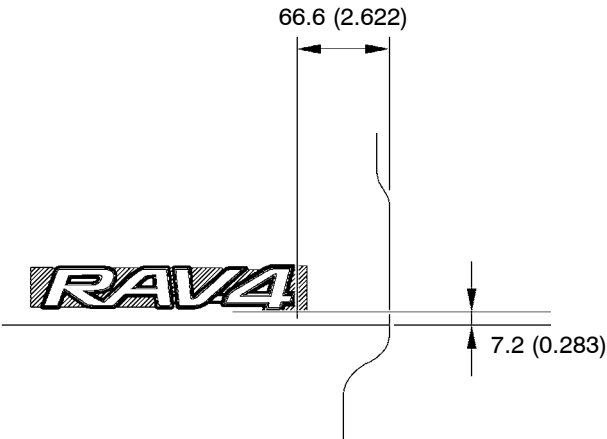
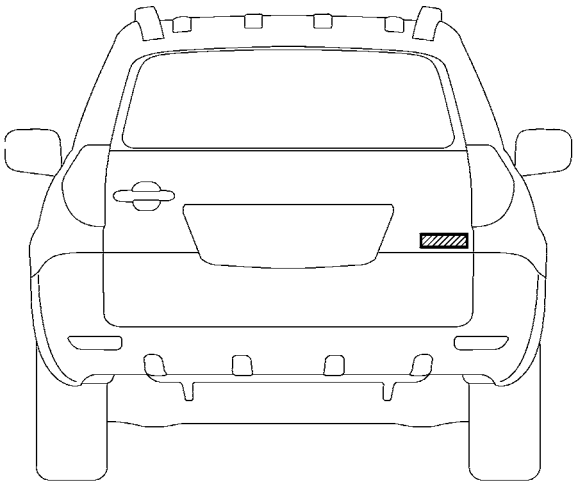
mm (in.)

F24764

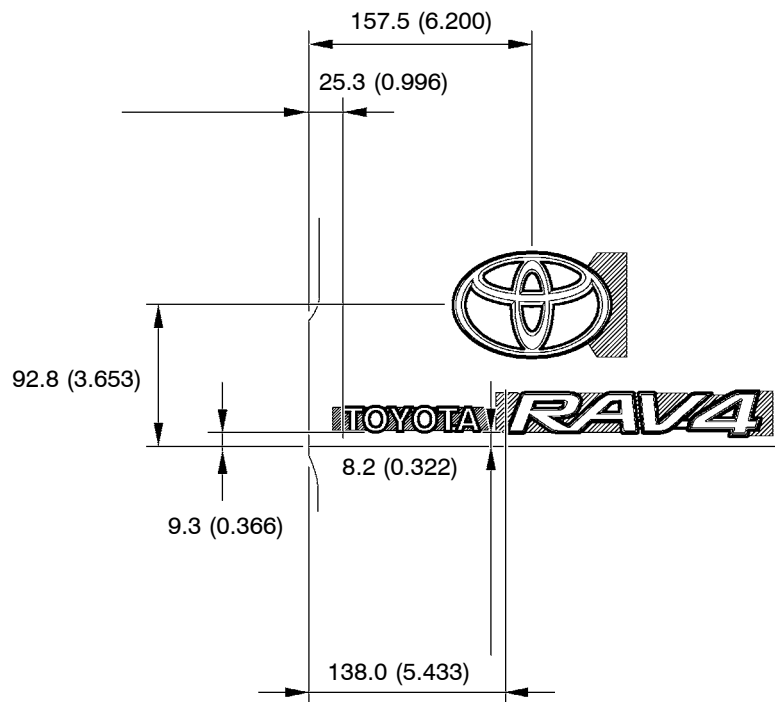
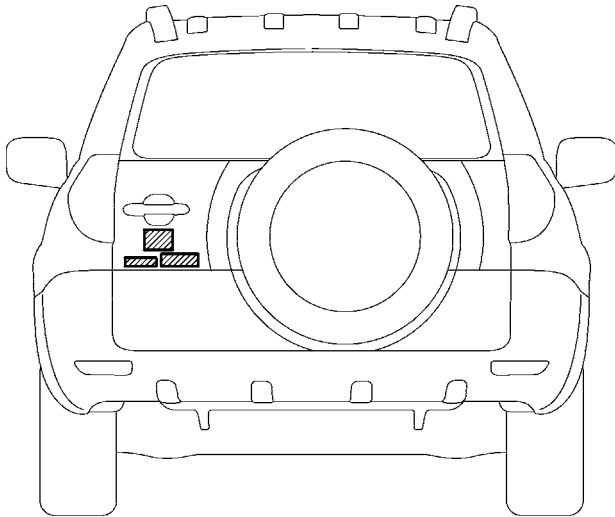
[USA, CANADA]



[GENERAL, EXPORT]



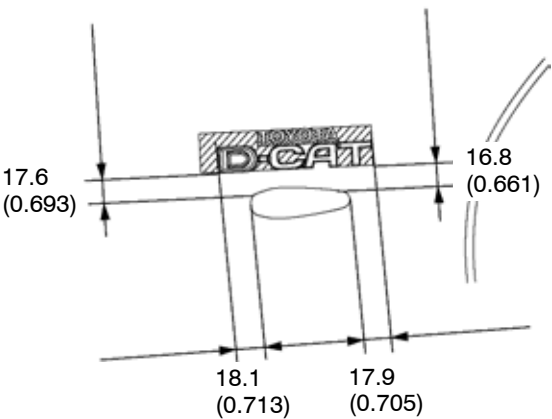
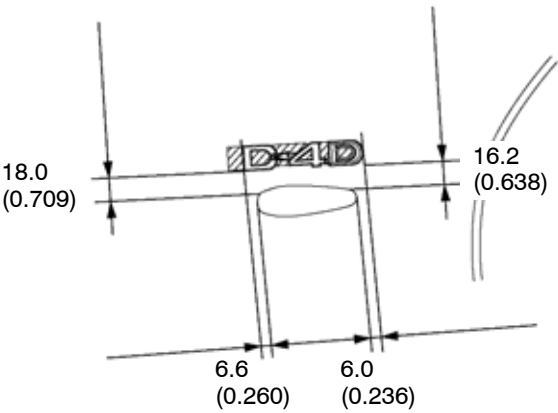
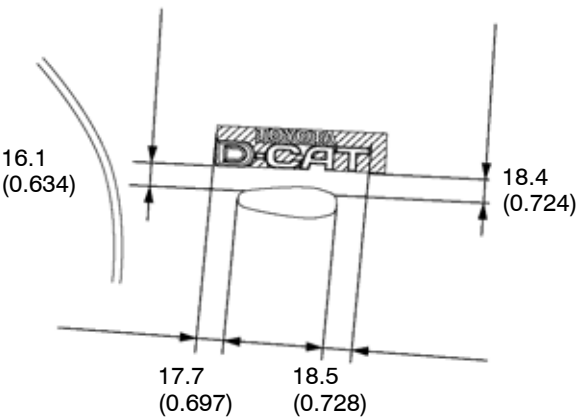
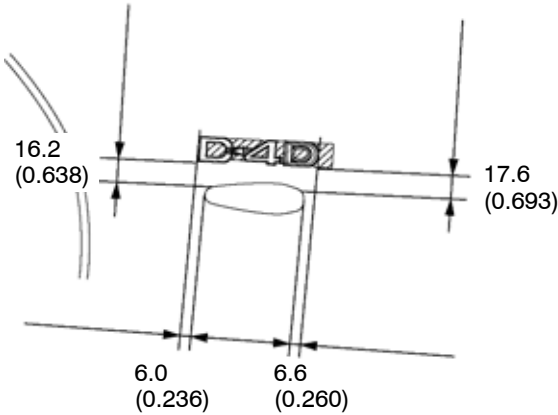
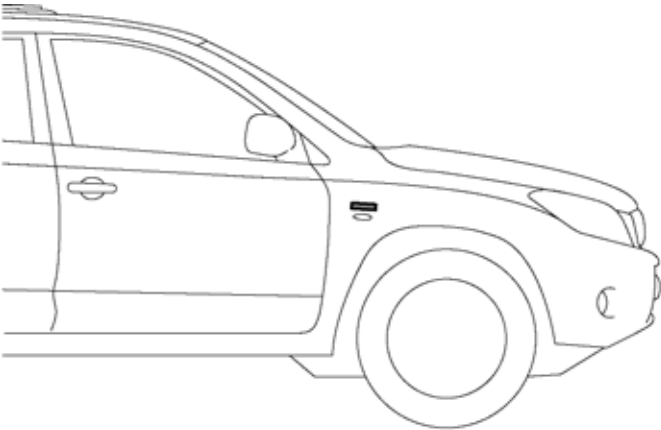
[GENERAL, EXPORT]



mm (in.)

F24766

[GENERAL, EXPORT]



mm (in.)

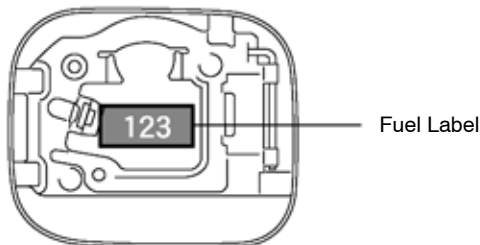
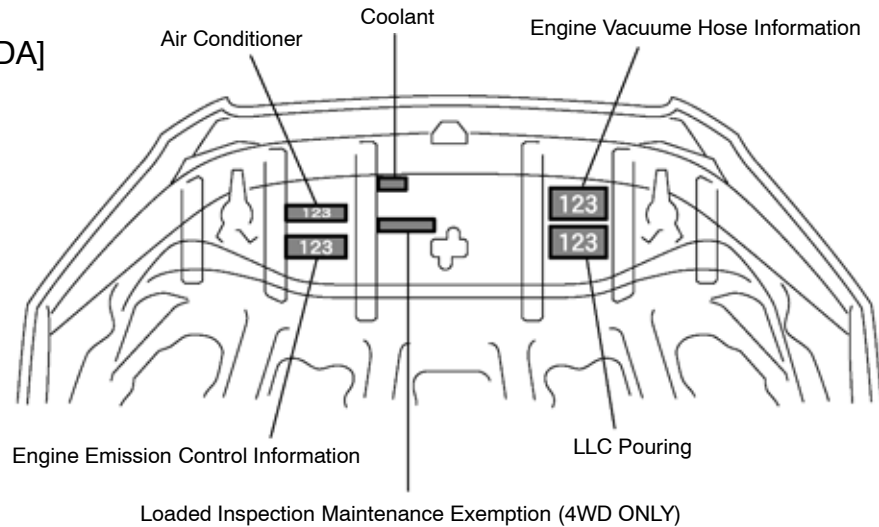
CAUTION LABEL ATTACHMENT POSITION

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

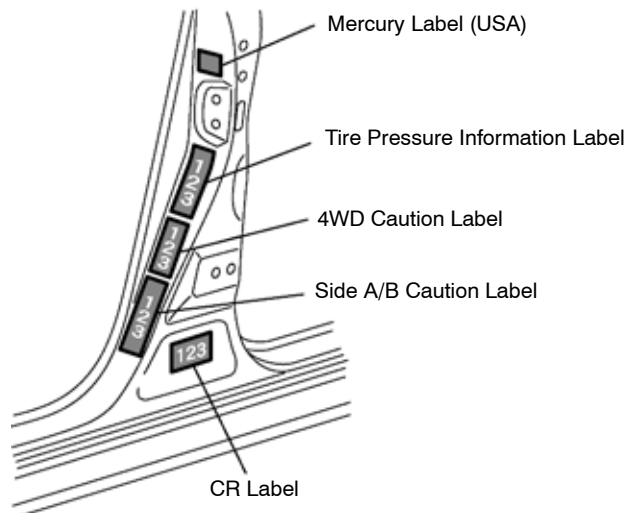
CAUTION:

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

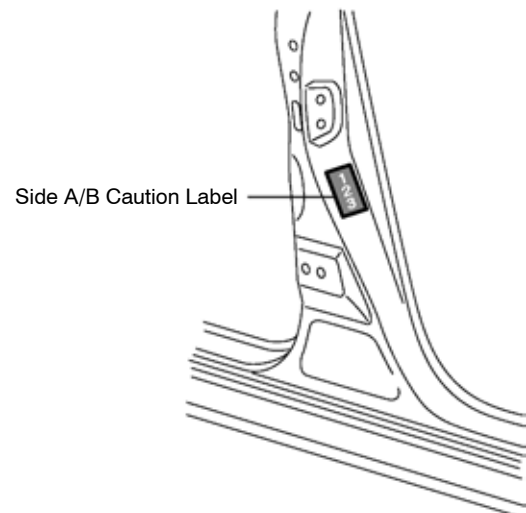
[USA, CANADA]



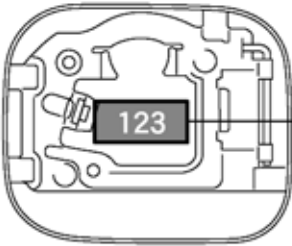
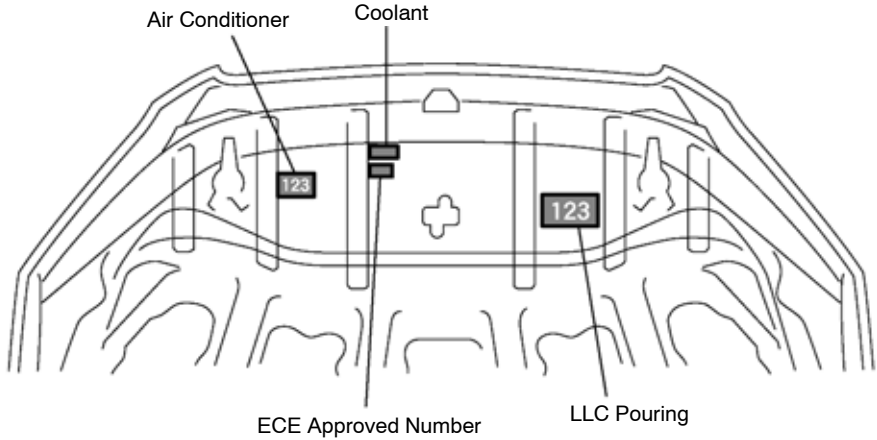
[LH]



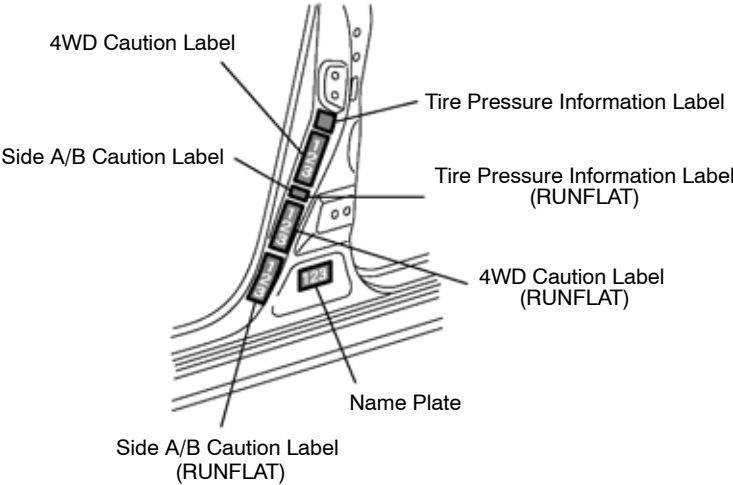
[RH]



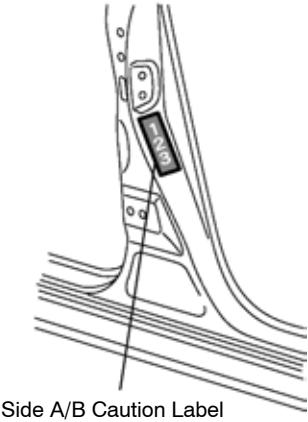
[EUROPE]



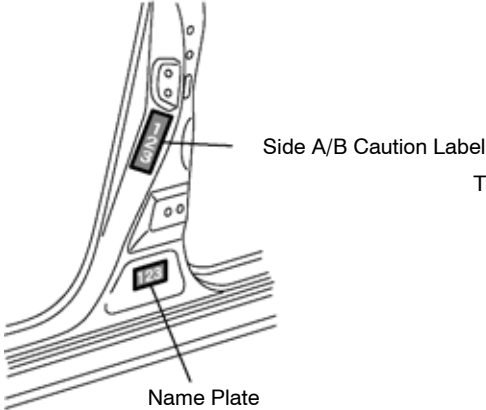
[LHD, LH]



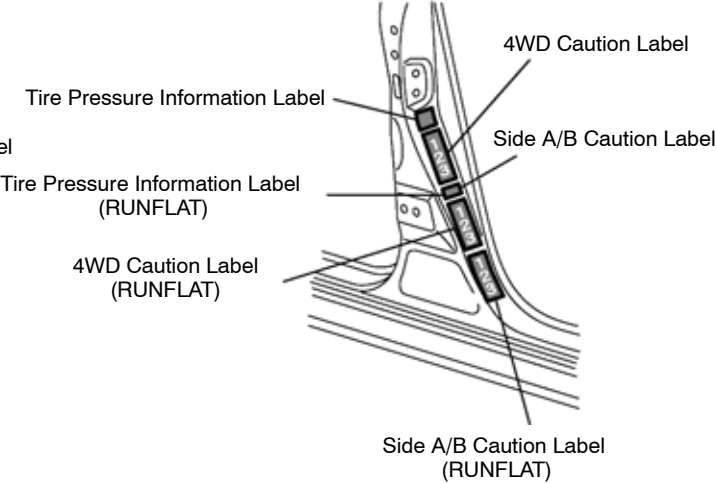
[LHD, RH]



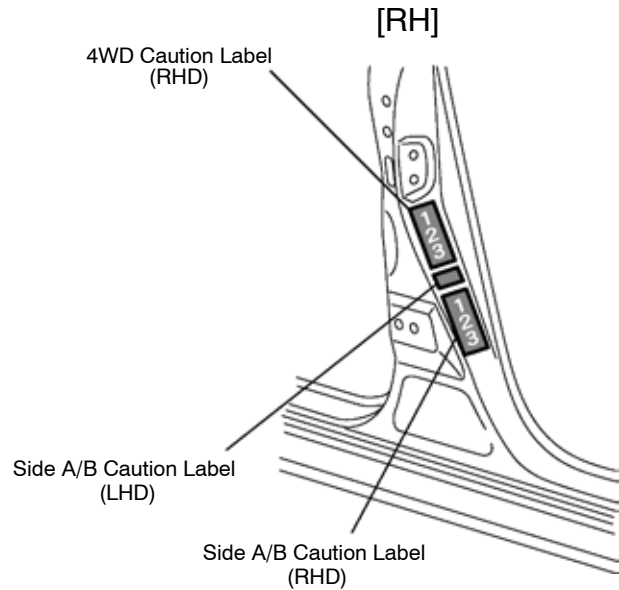
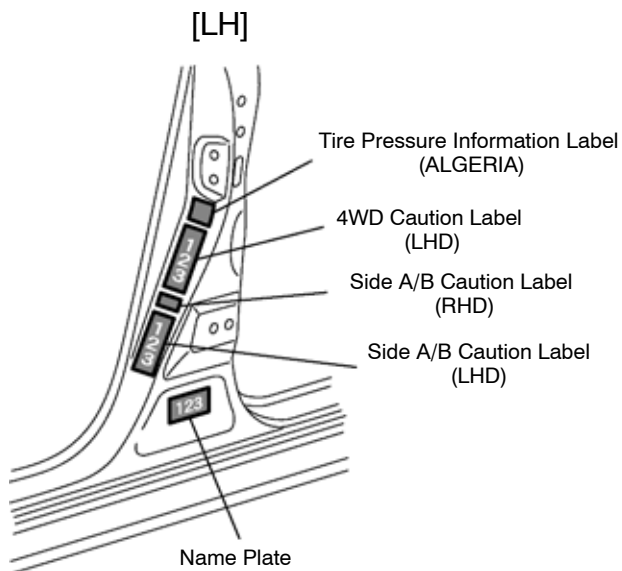
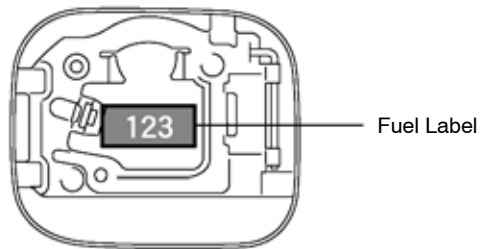
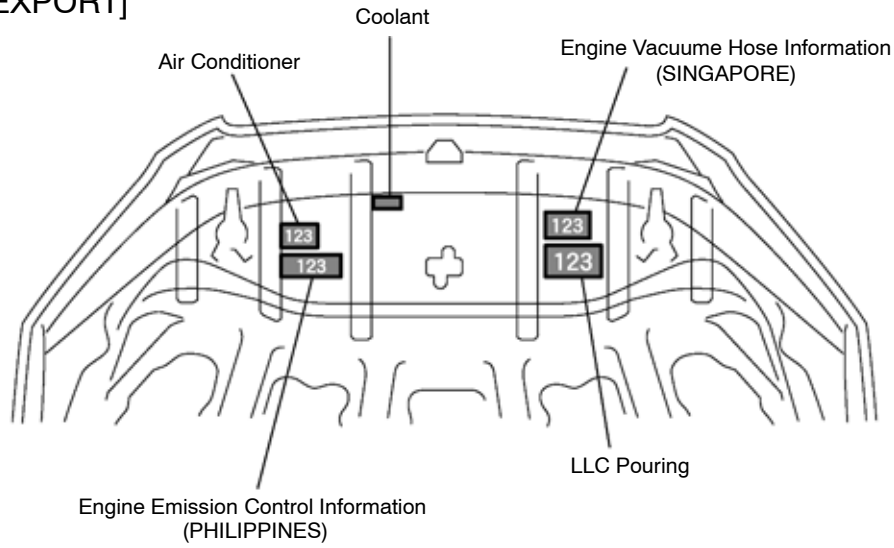
[RHD, LH]

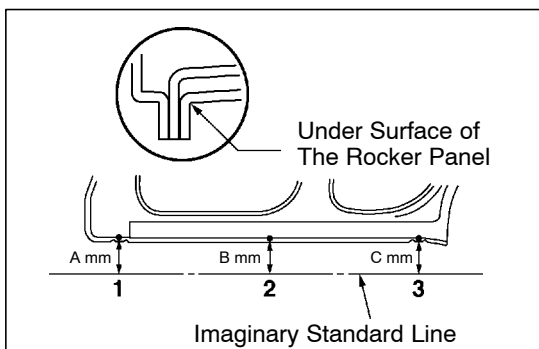
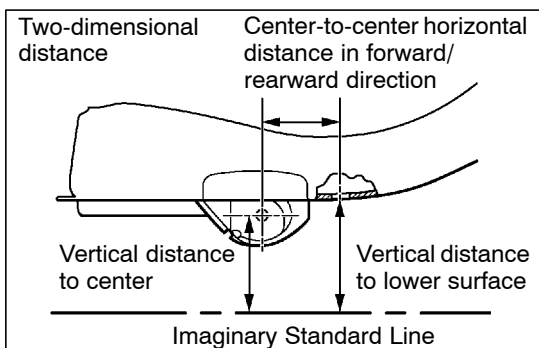
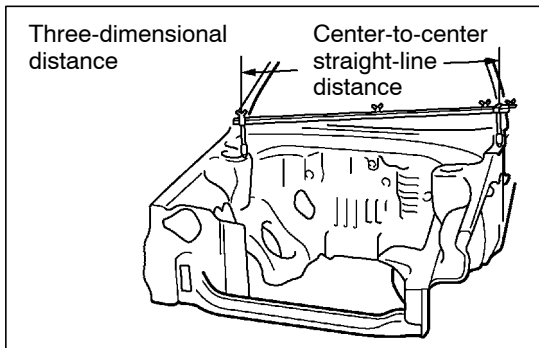


[RHD, RH]



[GENERAL EXPORT]



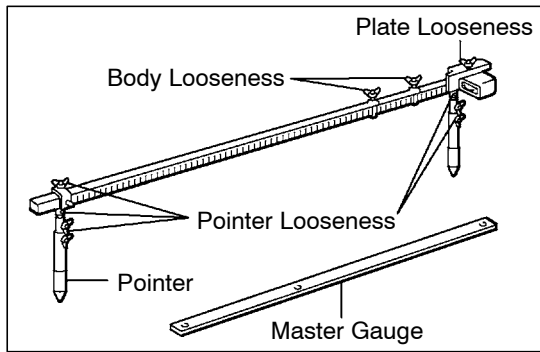


GENERAL INFORMATION

1. BASIC DIMENSIONS

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

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

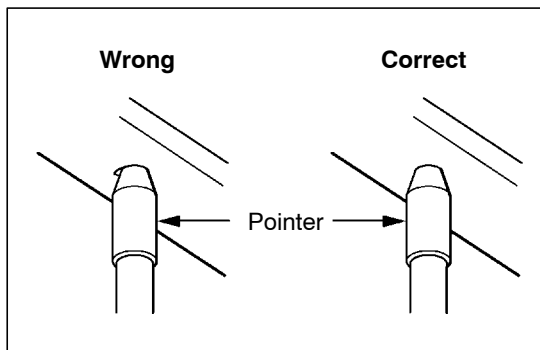


2. MEASURING

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

HINT:

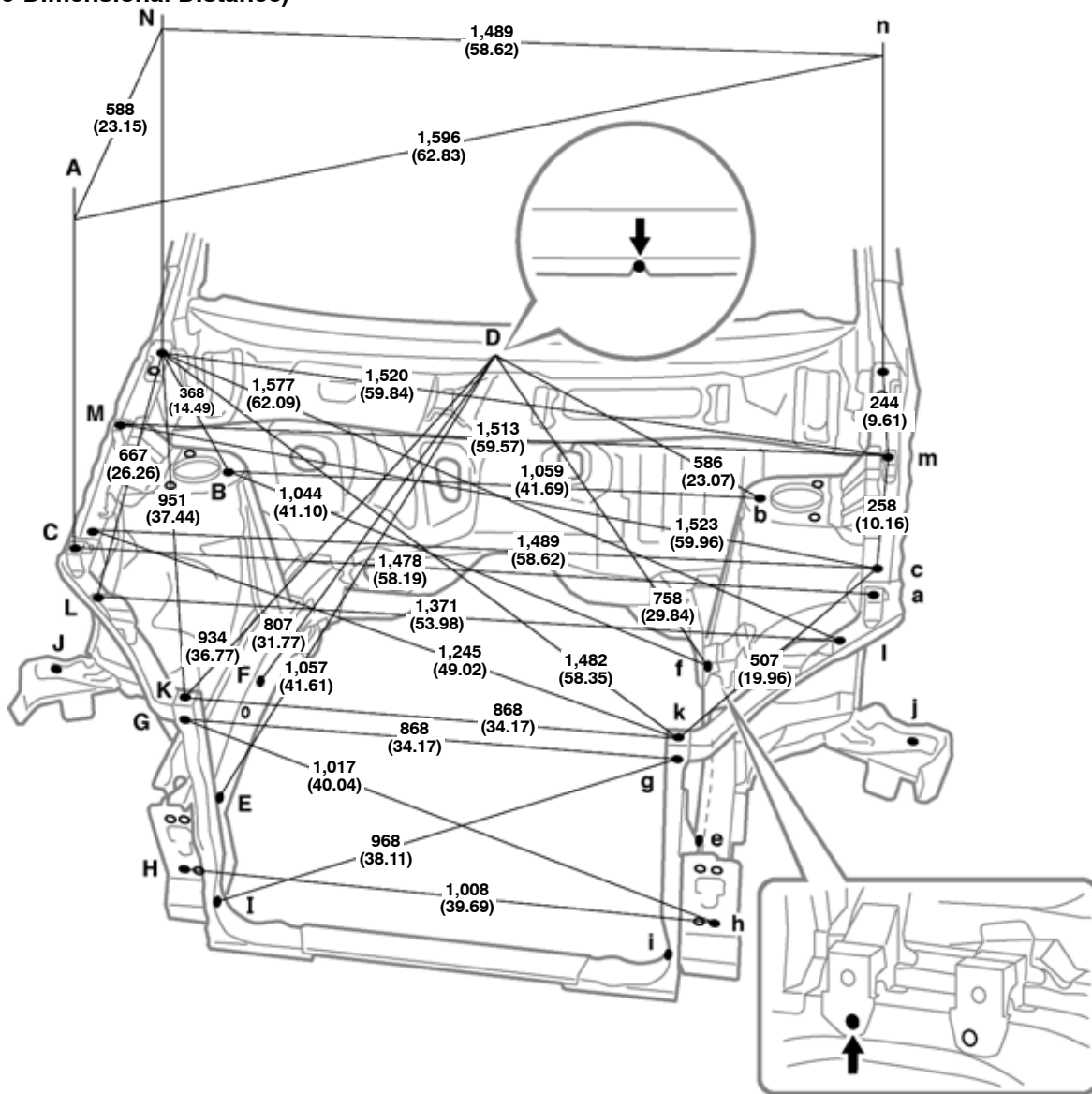
- 1) *The height of the left and right pointers must be equal.*
 - 2) *Always calibrate the tracking gauge before measuring or after adjusting the pointer height.*
 - 3) *Take care not to drop the tracking gauge or otherwise shock it.*
 - 4) *Confirm that the pointers are securely in the holes.*
- (c)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



BODY DIMENSION DRAWINGS

ENGINE COMPARTMENT

(Three-Dimensional Distance)



Vehicle Dimensions

A-M or a-m	A-m or a-M	b-F	J-j
345 (13.58)	1,534 (60.39)	1,071 (42.17)	1,596 (62.83)

Height from Imaginary Standard Line

A, a	H, h	K, k	N, n
770 (30.31)	265 (10.43)	691 (27.20)	841 (33.11)

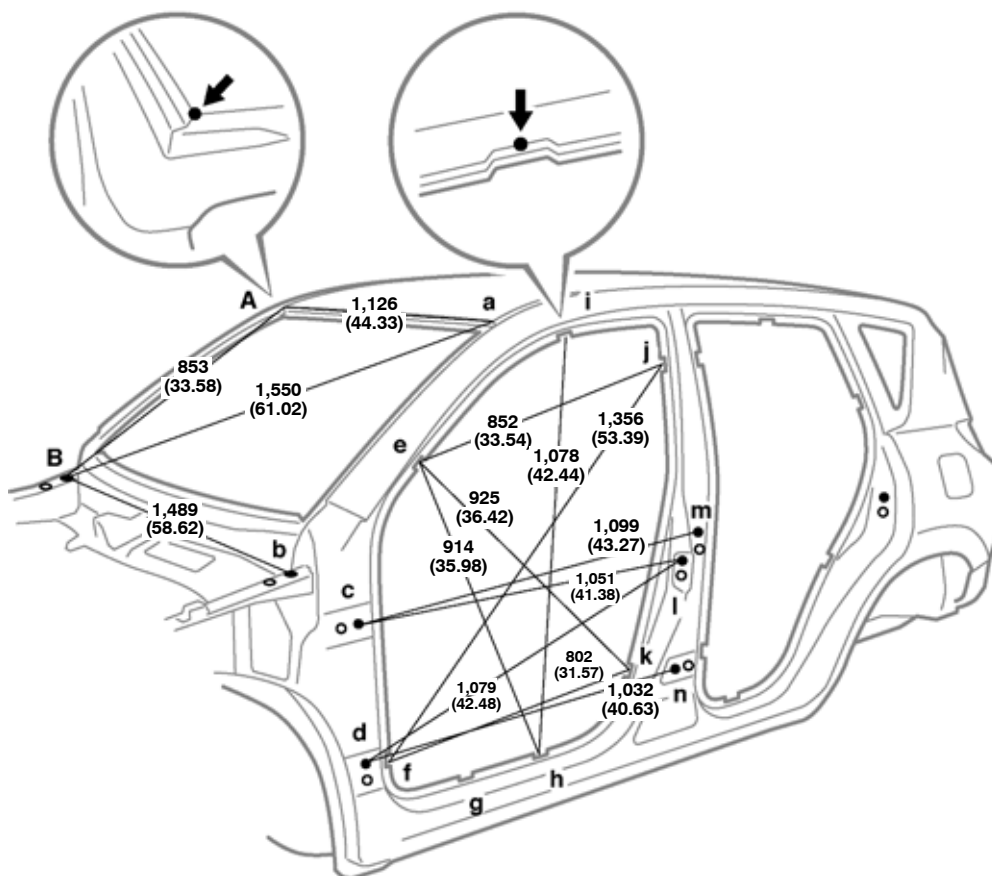
HINT: For symbols, capital letters indicate right side of vehicle, small letters indicate left side of vehicle (seen from rear).

mm (in.)

Symbol	Name	Hole dia.			
A, a	Front fender installation nut	M6 (0.24)	G, g	Radiator upper support installation nut	M8 (0.31)
B, b	Front spring support hole-inner	ø12.5 (0.492)	H, h	Front bumper reinforcement installation nut	M10 (0.39)
C, c	Front apron to cowl side member standard hole	ø13 (0.51)	I, i	Radiator side support standard hole	ø 12 (0.47)
D	Cowl panel center mark	—	J, j	Front fender extension standard hole	ø 10 (0.39)
E, e	Front side member standard hole	ø18 (0.71)	K, k	Radiator upper support installation nut	M8 (0.31)
F	Front side member standard hole	ø16 (0.63)	L, l	Radiator upper support standard hole	ø 10 (0.39)
f	Engine mounting bracket installation nut	M12 (0.47)	M, m	Front fender installation nut	M6 (0.24)
			N, n	Hood hinge installation nut	M8 (0.31)

BODY OPENING AREAS (Side View: Front)

(Three-Dimensional Distance)



Vehicle Dimensions

E-e	F-f	G-g	H-h	I-i	J-j	K-k	L-l
1,365 (53.74)	1,478 (58.19)	1,478 (58.19)	1,479 (58.23)	1,201 (47.28)	1,272 (50.08)	1,479 (58.23)	1,585 (62.40)

E-f or e-F	E-h or e-H	E-j or e-J	F-j or f-J	F-k or f-K	H-i or h-I	J-k or j-K
1,604 (63.15)	1,689 (66.50)	1,569 (61.77)	1,928 (75.91)	1,682 (66.22)	1,714 (67.48)	1,634 (64.33)

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

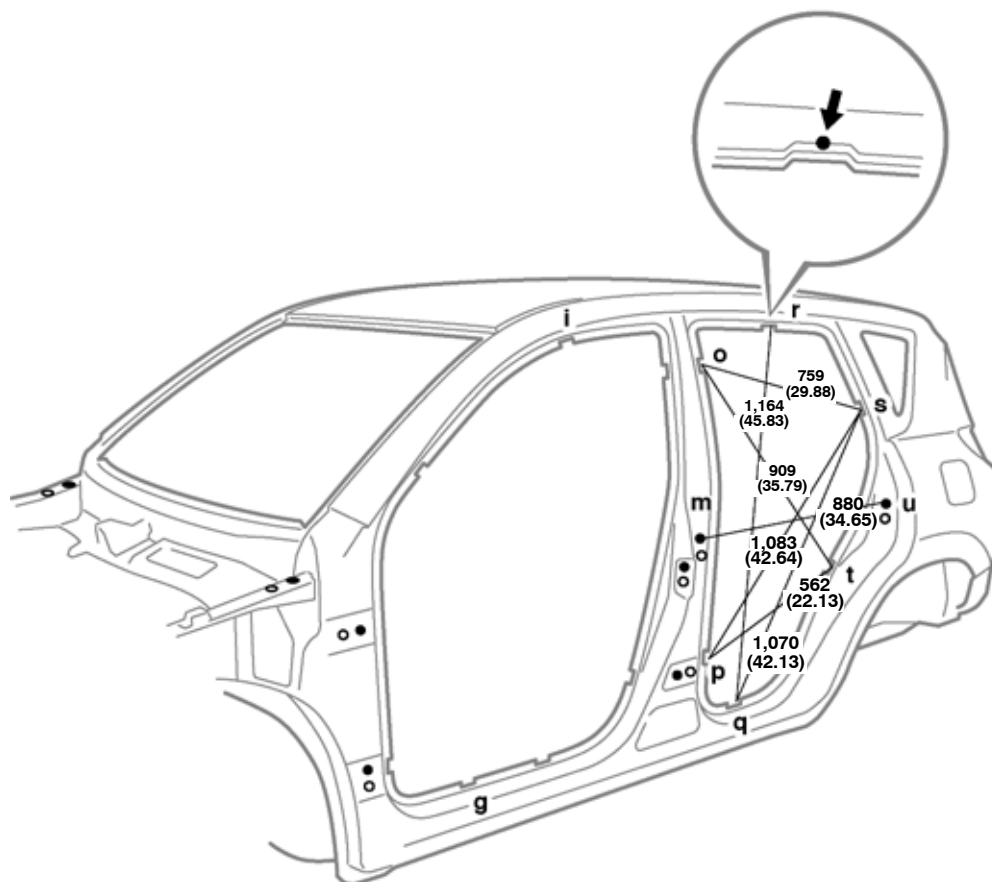
mm (in.)

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

BODY OPENING AREAS (Side View: Rear)

Short Body

(Three-Dimensional Distance)



Vehicle Dimensions

O-o	P-p	Q-q	R-r	S-s	T-t	U-u
1,272 (50.08)	1,474 (58.03)	1,542 (60.71)	1,169 (46.02)	1,356 (53.39)	1,487 (58.54)	1,597 (62.87)

G-q or g-Q	I-r or i-R	O-s or o-S	O-t or o-T	P-t or p-T	Q-r or q-R	S-t or s-T
1,782 (70.16)	1,446 (56.93)	1,517 (59.72)	1,648 (64.88)	1,584 (62.36)	1,777 (69.96)	1,570 (61.81)

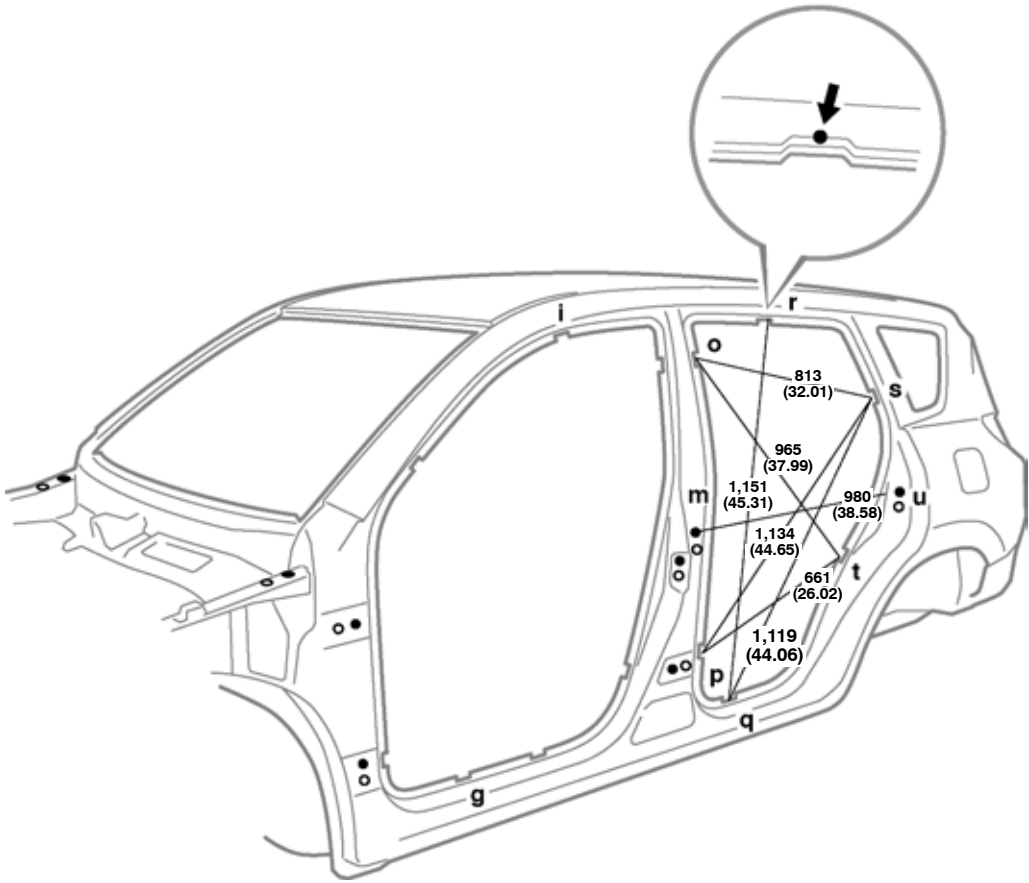
HINT: For symbols, capital letters indicate right side of vehicle, small letters indicate left side of vehicle (seen from rear).

mm (in.)

Symbol	Name	Hole dia.	Q, q	Rocker panel assembly mark	—
G, g	Rocker panel assembly mark	—	R, r	Roof side rail assembly mark	—
I, i	Roof side rail assembly mark	—	S, s	Quarter panel assembly mark	—
M, m	Rear door hinge installation nut	M8 (0.31)	T, t	Quarter panel assembly mark	—
O, o	Center body pillar assembly mark	—	U, u	Rear door lock striker installation nut	M8 (0.31)
P, p	Center body pillar assembly mark	—	—	—	—

BODY OPENING AREAS (Side View: Rear)
Long Body

(Three-Dimensional Distance)



Vehicle Dimensions

O-o	P-p	Q-q	R-r	S-s	T-t	U-u
1,272 (50.08)	1,474 (58.03)	1,479 (58.23)	1,169 (46.02)	1,353 (53.27)	1,487 (58.54)	1,597 (62.87)

G-q or g-Q	I-r or i-R	O-s or o-S	O-t or o-T	P-t or p-T	Q-r or q-R	S-t or s-T
1,736 (68.35)	1,447 (56.97)	1,544 (60.79)	1,680 (66.14)	1,621 (63.82)	1,747 (68.78)	1,566 (61.65)

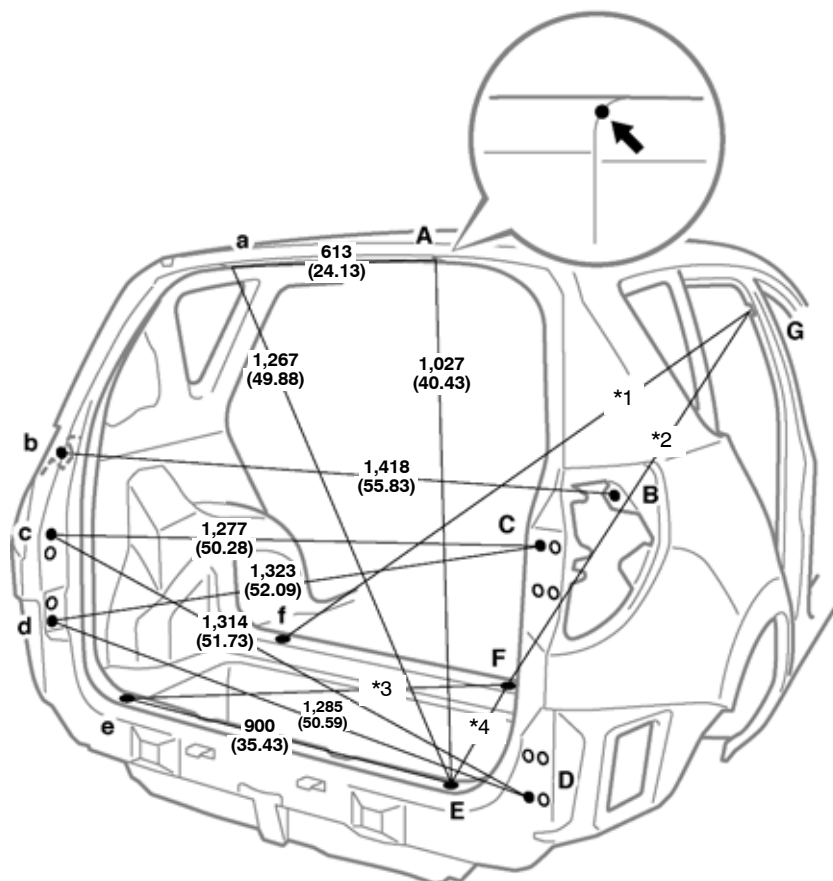
HINT: For symbols, capital letters indicate right side of vehicle, small letters indicate left side of vehicle (seen from rear).

mm (in.)

Symbol	Name	Hole dia.	Q, q	Rocker panel assembly mark	—
G, g	Rocker panel assembly mark	—	R, r	Roof side rail assembly mark	—
I, i	Roof side rail assembly mark	—	S, s	Quarter panel assembly mark	—
M, m	Rear door hinge installation nut	M8 (0.31)	T, t	Quarter panel assembly mark	—
O, o	Center body pillar assembly mark	—	U, u	Rear door lock striker installation nut	M8 (0.31)
P, p	Center body pillar assembly mark	—	—	—	—

BODY OPENING AREAS (Rear View)

(Three-Dimensional Distance)



	Short Body	Long Body
*1	1,632 (64.25)	1,694 (66.69)
*2	1,341 (52.80)	1,416 (55.75)
*3	962 (37.87)	1,028 (40.47)
*4	560 (22.05)	667 (26.26)

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

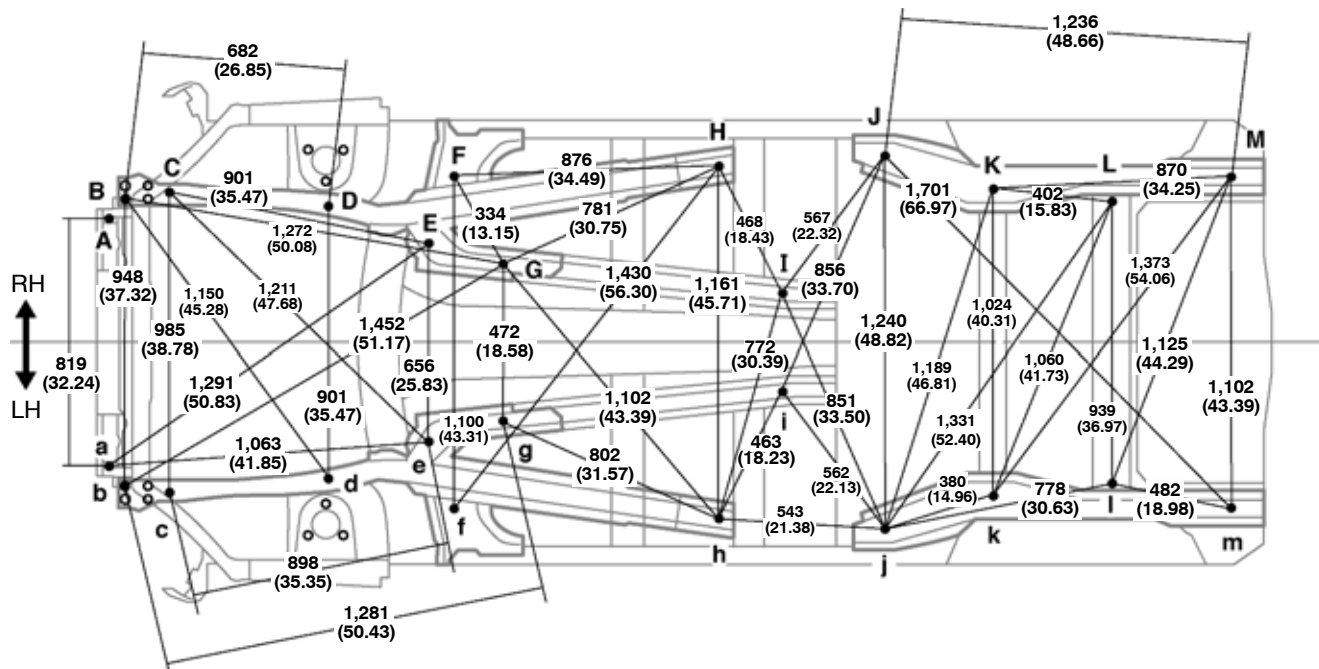
mm (in.)

Symbol	Name	Hole dia.	D	Back door hinge installation nut	M8 (0.31)
A, a	Roof side inner reinforcement corner	—	d	Back door lock striker installation nut	M8 (0.31)
B, b	Quarter panel standard hole	ø 13 (0.51)	E, e	Rear finish plate installation hole	ø 8.5 (0.335)
C	Back door hinge installation nut	M8 (0.31)	F, f	Rear floor crossmember No.1 standard hole	ø 13 (0.51)
c	Back door lock striker installation nut	M8 (0.31)	G, g	Center body pillar assembly mark	—

UNDER BODY

Short Body

(Three-Dimensional Distance)

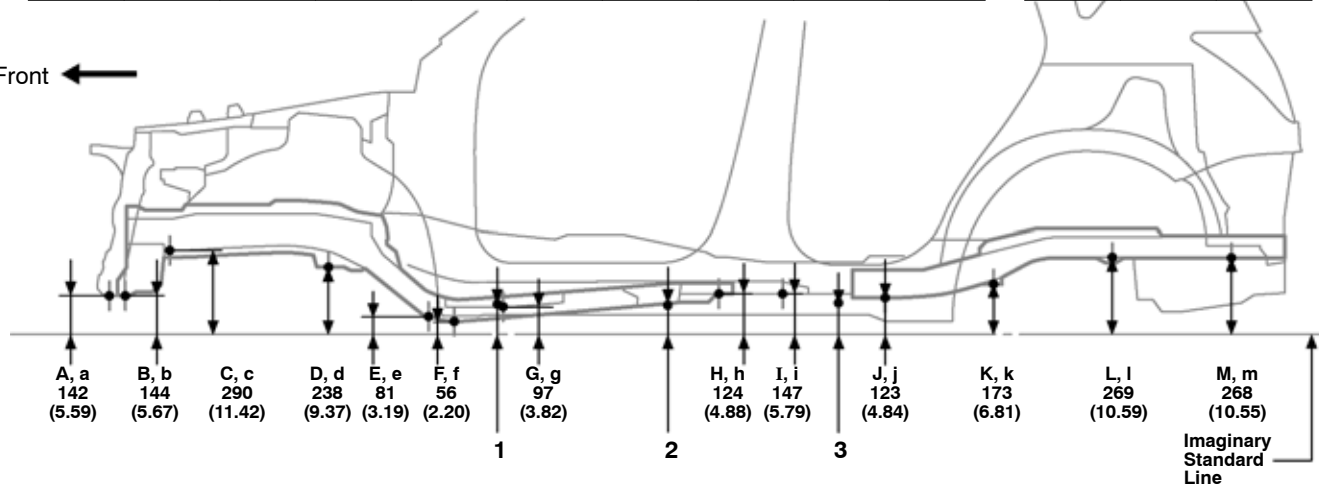


Vehicle Dimensions

b-D	b-d	c-E	F-g	f-G	f-g	g-H	H-i	H-j or h-J	I-i
1,147 (45.16)	682 (26.85)	1,201 (47.28)	780 (30.71)	827 (32.56)	377 (14.84)	1,066 (41.97)	777 (30.59)	1,317 (51.85)	330 (12.99)

1	2	3
99 (3.90)	100 (3.94)	100 (3.94)

Front ←



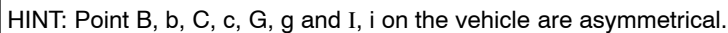
HINT: Point B, b, C, c, G, g and I, i on the vehicle are asymmetrical.

mm (in.)

Symbol	Name	Hole dia.	G, g	Front side member standard hole	ø23 (0.91)
A, a	Front body mounting reinforcement standard hole	ø13 (0.51)	H, h	Front floor under reinforcement standard hole	ø18 (0.71)
B, b	Front crossmember installation nut	M12 (0.47)	I, i	Front floor reinforcement No.3 standard hole	ø15 (0.59)
C, c	Front side member standard hole	ø18 (0.71)	J, j	Rear floor side member standard hole	ø18 (0.71)
D, d	Front suspension member installation nut	M14 (0.55)	K, k	Rear suspension member installation nut	M14 (0.55)
E, e	Front suspension member installation nut	M14 (0.55)	L, l	Rear suspension member installation nut	M14 (0.55)
F, f	Torque box front standard hole	ø25 (0.98)	M, m	Rear floor side member standard hole	ø18 (0.71)

Long Body

b-D	b-d	c-E	F-g	f-G	f-g	g-H	H-i	H-j or h-J	I-i	1	2	3
1,147 (45.16)	682 (26.85)	1,201 (47.28)	780 (30.71)	827 (32.56)	377 (14.84)	1,066 (41.97)	777 (30.59)	1,361 (53.58)	330 (12.99)	99 (3.90)	100 (3.94)	100 (3.94)

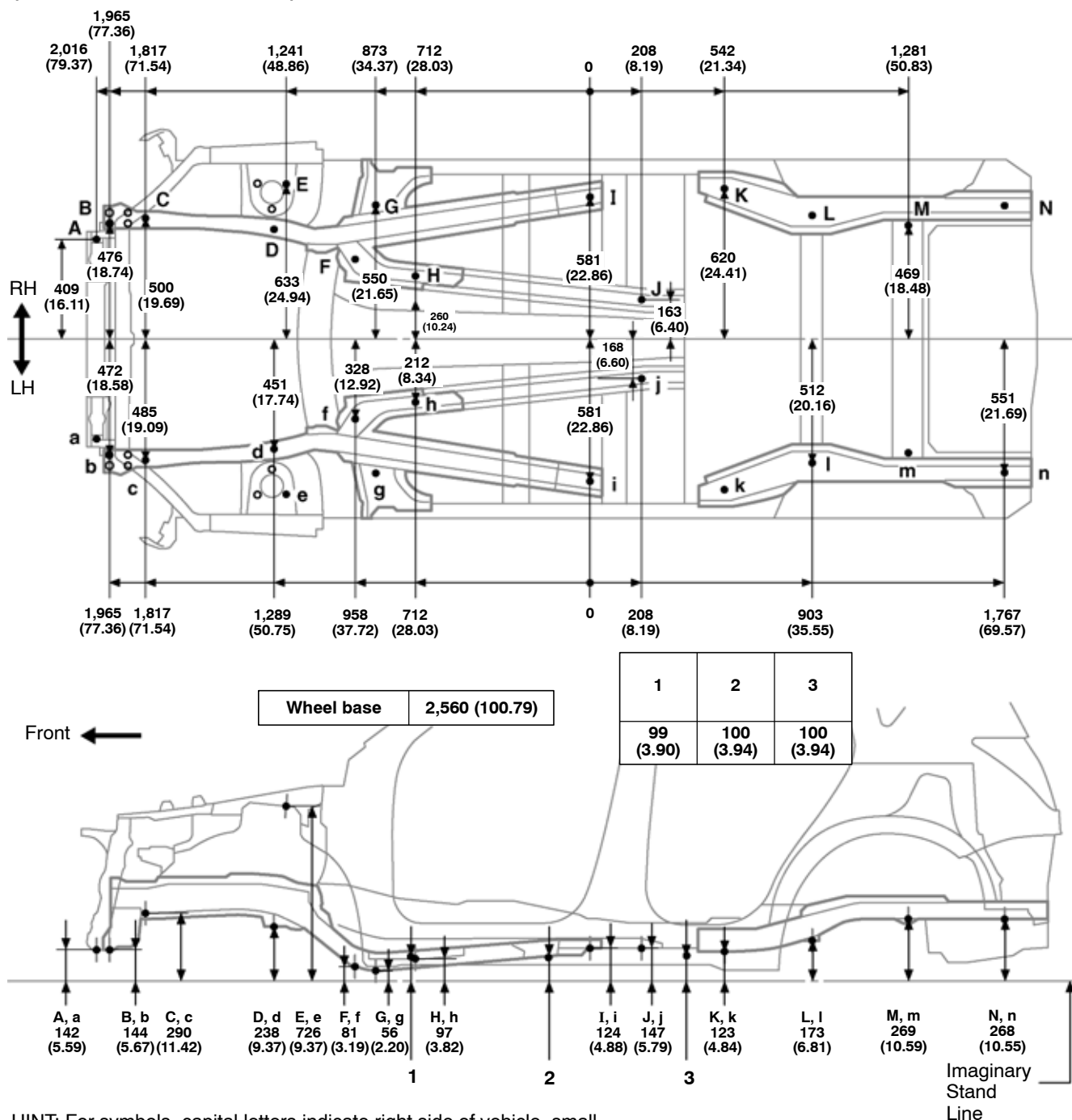


Symbol	Name	Hole dia.	G, g	Front side member standard hole	ø23 (0.91)
A, a	Front body mounting reinforcement standard hole	ø13 (0.51)	H, h	Front floor under reinforcement standard hole	ø18 (0.71)
B, b	Front crossmember installation nut	M12 (0.47)	I, i	Front floor reinforcement No.3 standard hole	ø15 (0.59)
C, c	Front side member standard hole	ø18 (0.71)	J, j	Rear floor side member standard hole	ø18 (0.71)
D, d	Front suspension member installation nut	M14 (0.55)	K, k	Rear suspension member installation nut	M14 (0.55)
E, e	Front suspension member installation nut	M14 (0.55)	L, l	Rear suspension member installation nut	M14 (0.55)
F, f	Torque box front standard hole	ø25 (0.98)	M, m	Rear floor side member standard hole	ø18 (0.71)

UNDER BODY

Short Body: 2WD

(Two-Dimensional Distance)



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

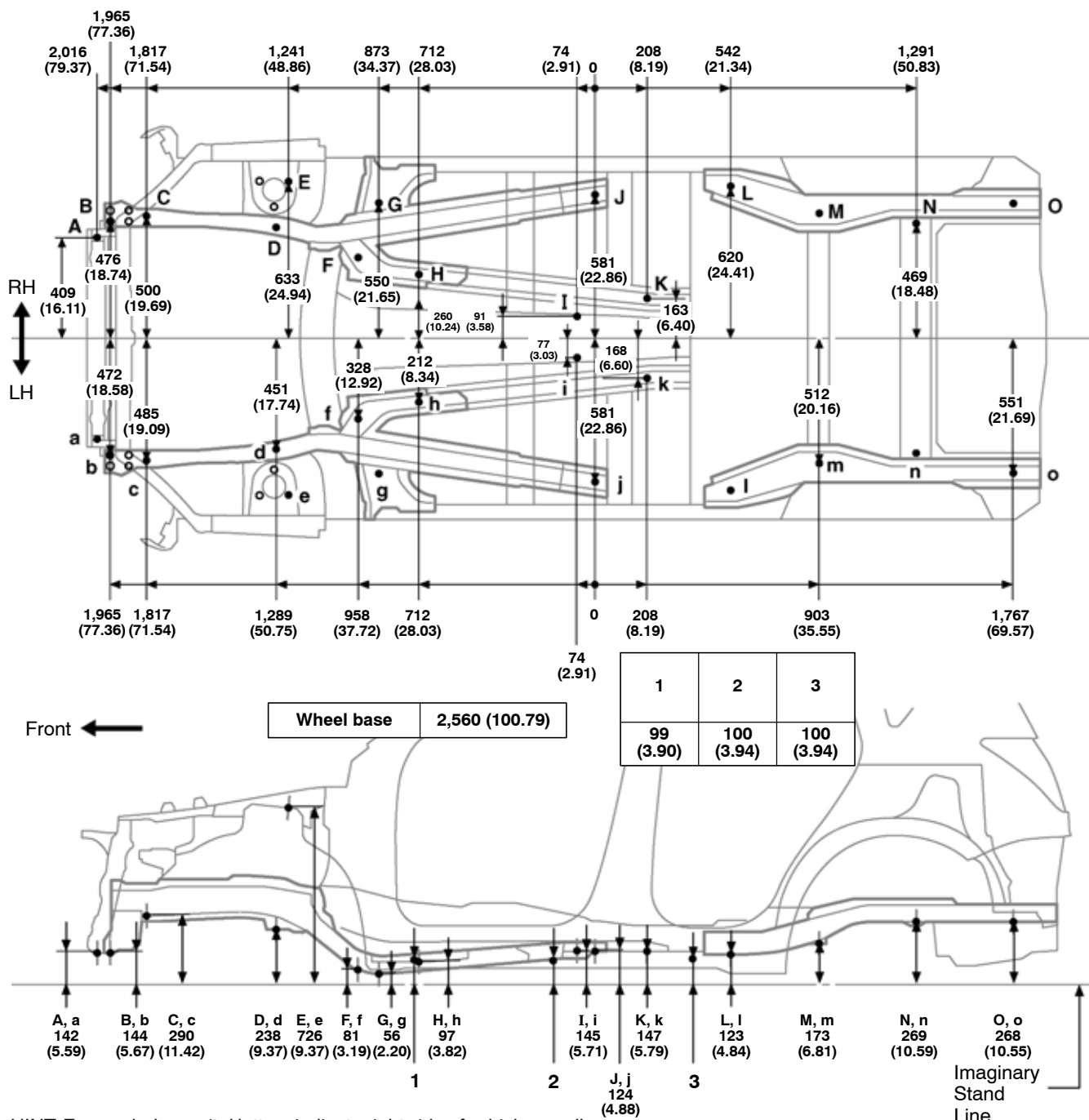
mm (in.)

Symbol	Name	Hole dia.	H, h	Front side member standard hole	ø23 (0.91)
A, a	Front body mounting reinforcement standard hole	ø13 (0.51)	I, i	Front floor under reinforcement standard hole	ø18 (0.71)
B, b	Front crossmember installation nut	M12 (0.47)	J, j	Front floor reinforcement No. 3 standard hole	ø15 (0.59)
C, c	Front side member standard hole	ø18 (0.71)	K, k	Rear floor side member standard hole	ø18 (0.71)
D, d	Front suspension member installation nut	14 (0.55)	L, l	Rear suspension member installation nut	M14 (0.55)
E, e	Front spring support hole inner rear	ø12.5 (0.492)	M, m	Rear suspension member installation nut	M14 (0.55)
F, f	Front suspension member installation nut	M14 (0.55)	N, n	Rear floor side member standard hole	ø18 (0.71)
G, g	Torque box front standard hole	ø25 (0.98)	—	—	—

UNDER BODY

Short Body: 4WD

(Two-Dimensional Distance)

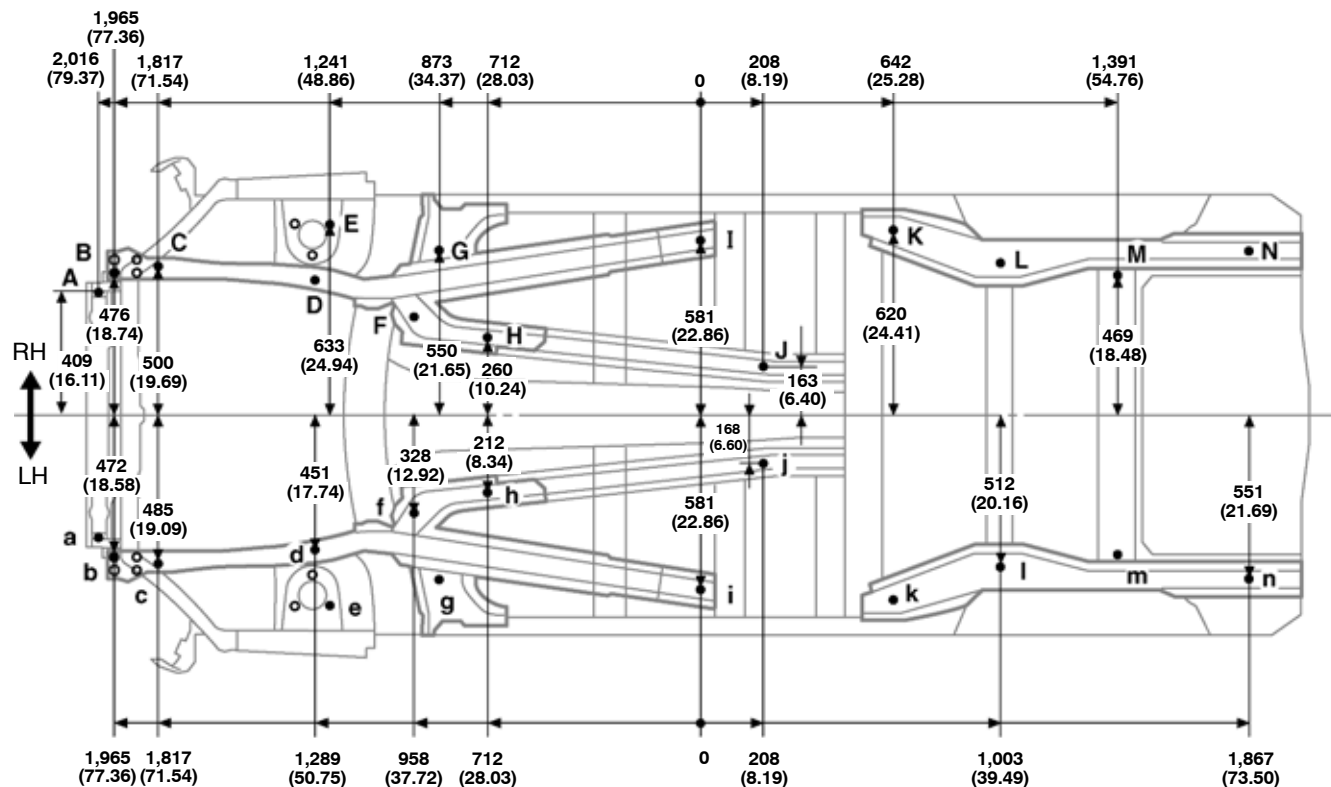


Symbol	Name	Hole dia.	H, h	Front side member standard hole	ø23 (0.91)
A, a	Front body mounting reinforcement standard hole	ø13 (0.51)	I, i	Propeller shaft center support bearing installation nut	M10 (0.39)
B, b	Front crossmember installation nut	M12 (0.47)	J, j	Front floor under reinforcement standard hole	ø18 (0.71)
C, c	Front side member standard hole	ø18 (0.71)	K, k	Front floor reinforcement No. 3 standard hole	ø15 (0.59)
D, d	Front suspension member installation nut	M14 (0.55)	L, l	Rear floor side member standard hole	ø18 (0.71)
E, e	Front spring support hole inner rear	ø12.5 (0.492)	M, m	Rear suspension member installation nut	M14 (0.55)
F, f	Front suspension member installation nut	M14 (0.55)	N, n	Rear suspension member installation nut	M14 (0.55)
G, g	Torque box front standard hole	ø25 (0.98)	O, o	Rear floor side member standard hole	ø18 (0.71)

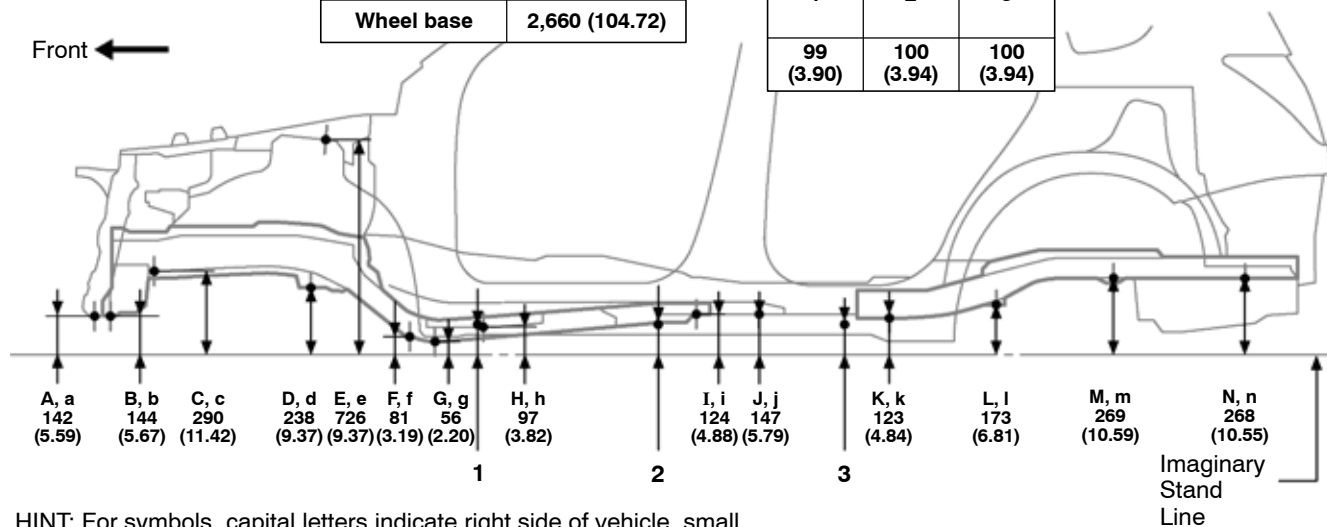
UNDER BODY

Long Body: 2WD

(Two-Dimensional Distance)



Front ←



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

Imaginary Stand Line

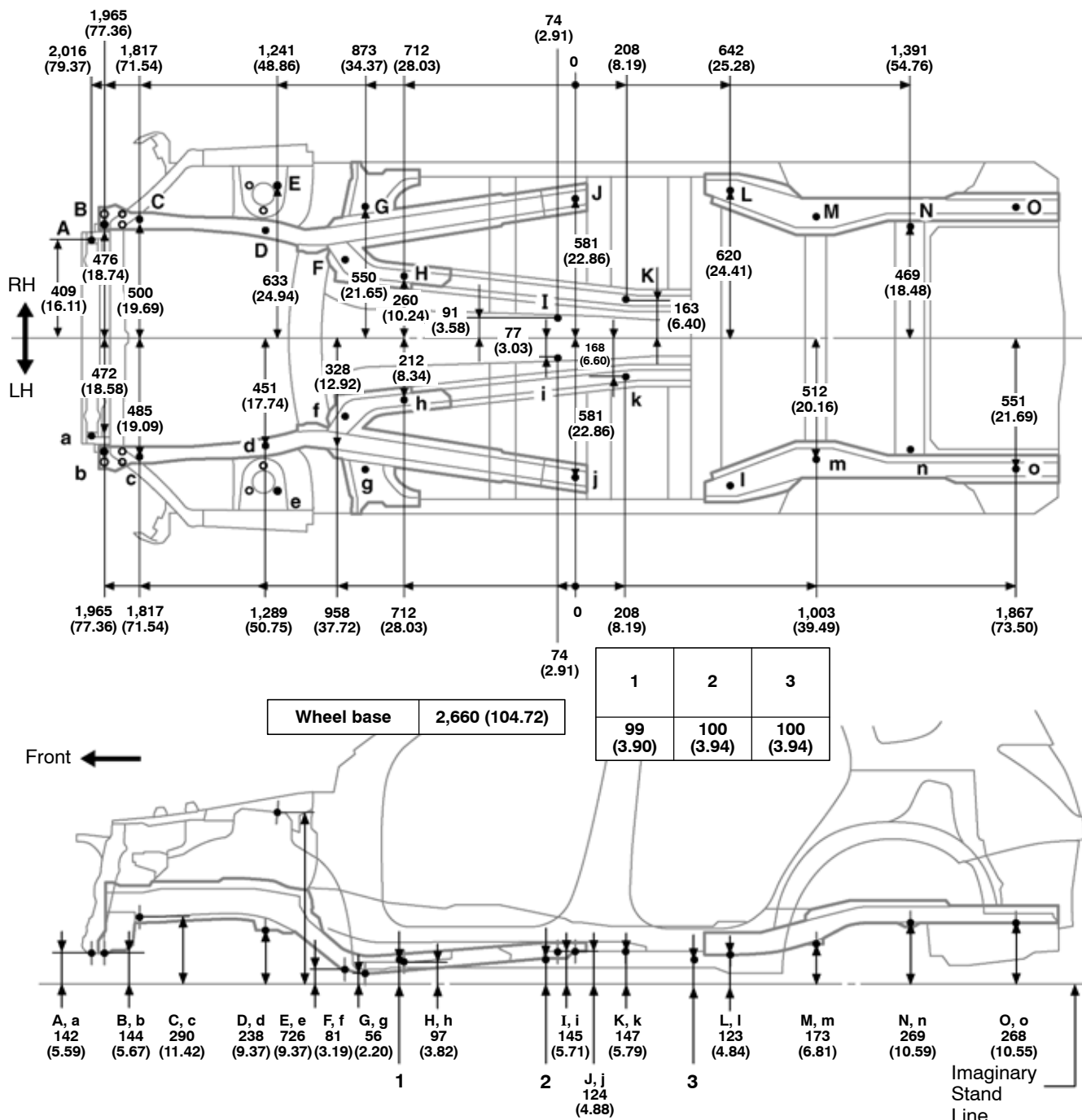
mm (in.)

Symbol	Name	Hole dia.	H, h	Front side member standard hole	ø23 (0.91)
A, a	Front body mounting reinforcement standard hole	ø13 (0.51)	I, i	Front floor under reinforcement standard hole	ø18 (0.71)
B, b	Front crossmember installation nut	M12 (0.47)	J, j	Front floor reinforcement No. 3 standard hole	ø15 (0.59)
C, c	Front side member standard hole	ø18 (0.71)	K, k	Rear floor side member standard hole	ø18 (0.71)
D, d	Front suspension member installation nut	M14 (0.55)	L, l	Rear suspension member installation nut	M14 (0.55)
E, e	Front spring support hole inner rear	ø12.5 (0.492)	M, m	Rear suspension member installation nut	M14 (0.55)
F, f	Front suspension member installation nut	M14 (0.55)	N, n	Rear floor side member standard hole	ø18 (0.71)
G, g	Torque box front standard hole	ø25 (0.98)	—	—	—

UNDER BODY

Long Body: 4WD

(Two-Dimensional Distance)



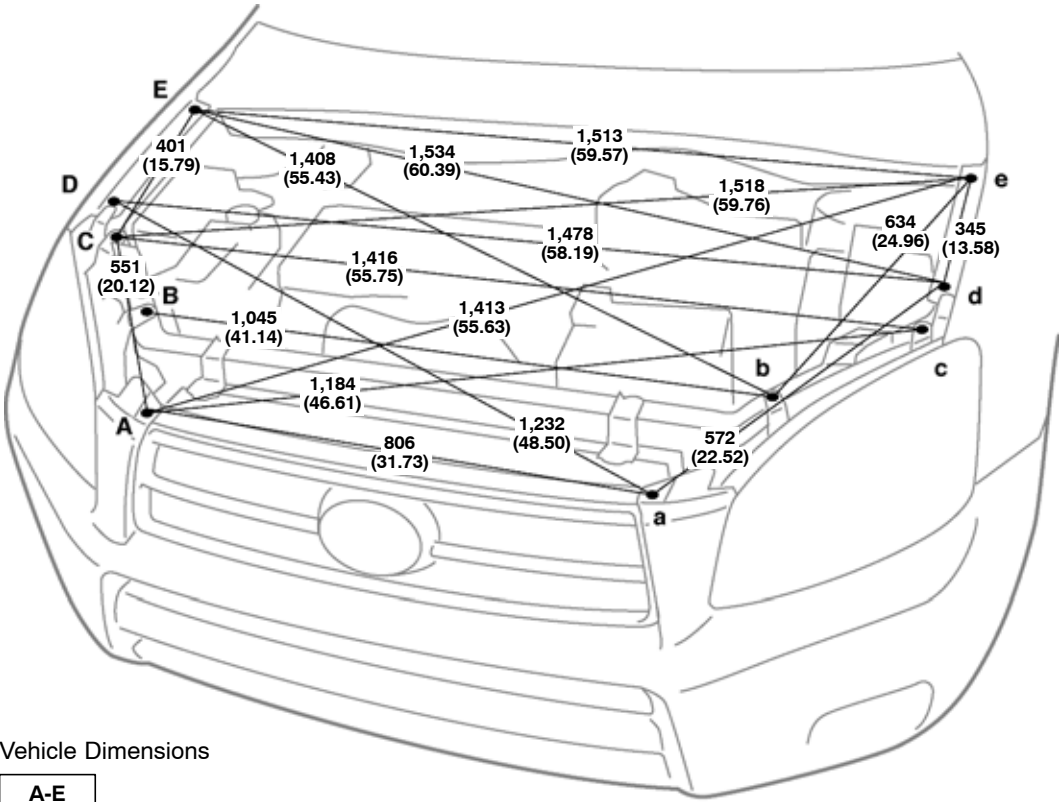
HINT: For symbols, capital letters indicate right side of vehicle, small letters indicate left side of vehicle (seen from rear).

mm (in.)

Symbol	Name	Hole dia.	H, h	Front side member standard hole	ø23 (0.91)
A, a	Front body mounting reinforcement standard hole	ø13 (0.51)	I, i	Propeller shaft center support bearing installation nut	M10 (0.39)
B, b	Front crossmember installation nut	M12 (0.47)	J, j	Front floor under reinforcement standard hole	ø18 (0.71)
C, c	Front side member standard hole	ø18 (0.71)	K, k	Front floor reinforcement No. 3 standard hole	ø15 (0.59)
D, d	Front suspension member installation nut	M14 (0.55)	L, l	Rear floor side member standard hole	ø18 (0.71)
E, e	Front spring support hole inner rear	ø12.5 (0.492)	M, m	Rear suspension member installation nut	M14 (0.55)
F, f	Front suspension member installation nut	M14 (0.55)	N, n	Rear suspension member installation nut	M14 (0.55)
G, g	Torque box front standard hole	ø25 (0.98)	O, o	Rear floor side member standard hole	ø18 (0.71)

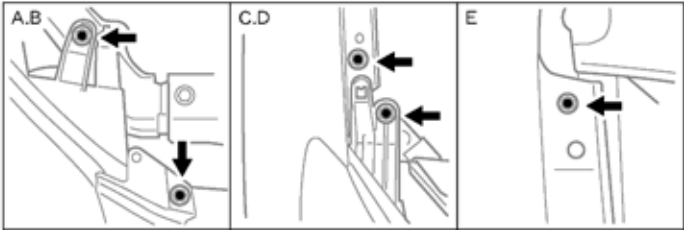
REFERENCE VALUE
ENGINE COMPARTMENT

(Three-Dimensional Distance)



Vehicle Dimensions

A-E or a-e
881 (34.69)



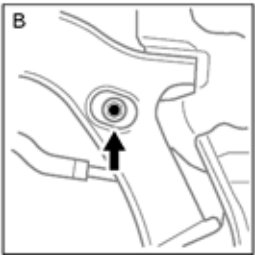
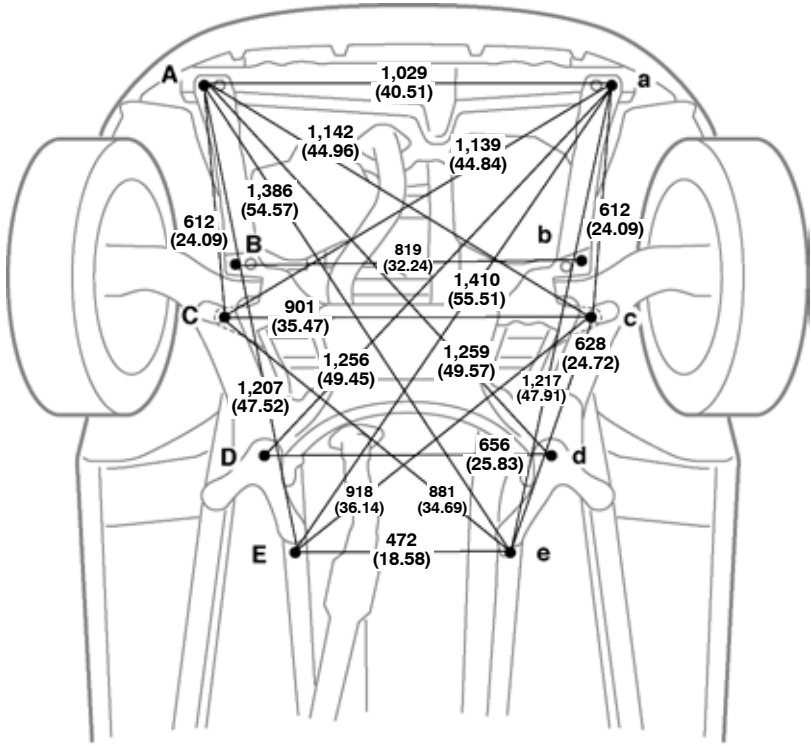
HINT: These values are actual measurements made on model.
Use these reference values.

mm (in.)

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

UNDER BODY

(Three-Dimensional Distance)



Vehicle Dimensions

A-D	a-d	B-E	b-e	B-e	b-E
952 (37.48)	951 (37.44)	722 (28.43)	750 (29.53)	940 (37.01)	986 (38.82)

HINT: These values are actual measurements made on model.
 Use these reference values.

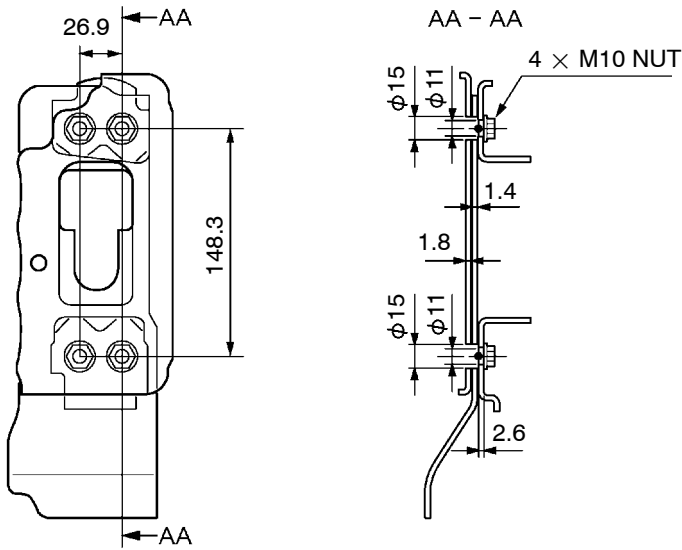
mm (in.)

Symbol	Name	Hole dia.	C, c	Front suspension crossmember installation bolt	—
A, a	Front suspension member reinforcement installation bolt	—	D, d	Front suspension crossmember installation bolt	—
B, b	Front suspension member reinforcement installation bolt	—	E, e	Front side member standard hole	ø23 (0.91)

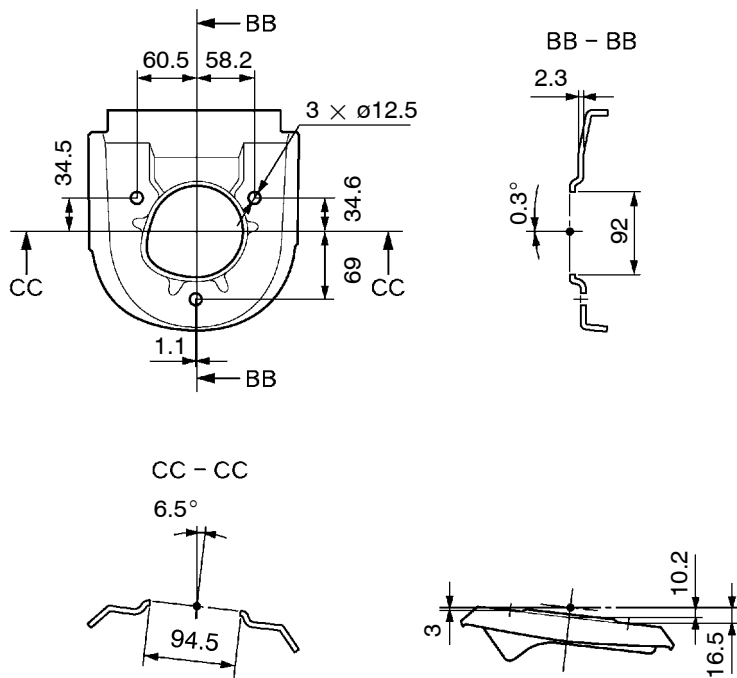
UNDER BODY

(Two-Dimentional Distance)

Front bumper reinforcement



Front spring support



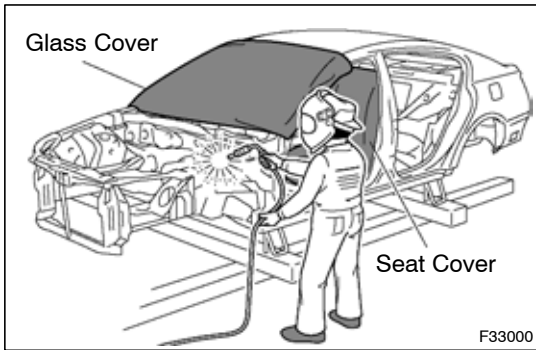
PRECAUTION

GENERAL REPAIR INSTRUCTIONS

1. WORK PRECAUTIONS

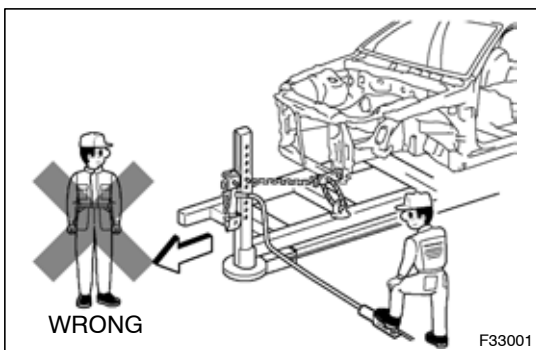
(a) VEHICLE PROTECTION

- (1) When welding, protect the painted surfaces, windows, seats and carpet with heat resistant, fireproof covers.

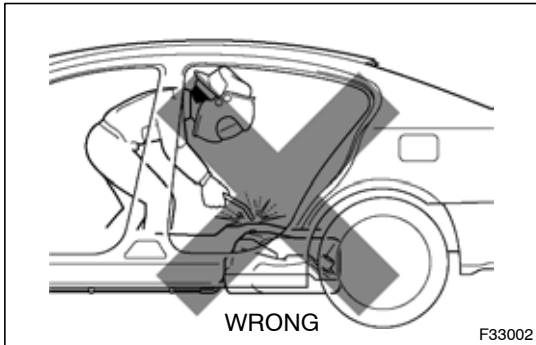


(b) SAFETY

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

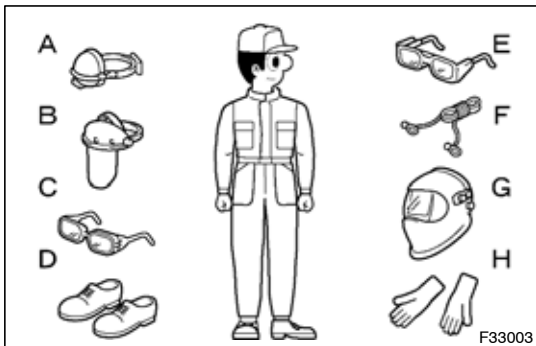


- (2) Before performing repair work, check for fuel leaks. If a leak is found, be sure to close the opening completely.
- (3) If it is necessary to use a flame in the area of the fuel tank, first remove the tank and plug the fuel line.



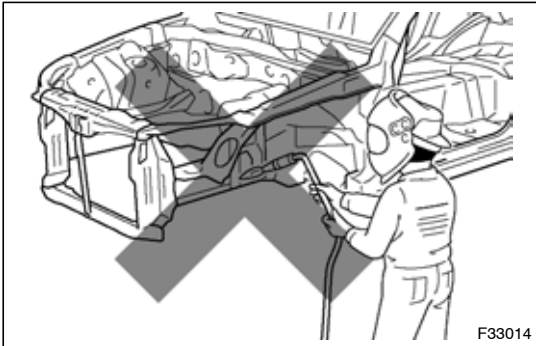
(c) SAFETY WORK CLOTHES

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



Code	Name
A	Dust-Prevention Mask
B	Face Protector
C	Eye Protector
D	Safety Shoes
E	Welder's Glasses
F	Ear Plugs
G	Head Protector
H	Welder's Gloves

PRECAUTIONS FOR REPAIRING BODY STRUCTURE PANELS



1. HEAT REPAIR FOR BODY STRUCTURE PANELS

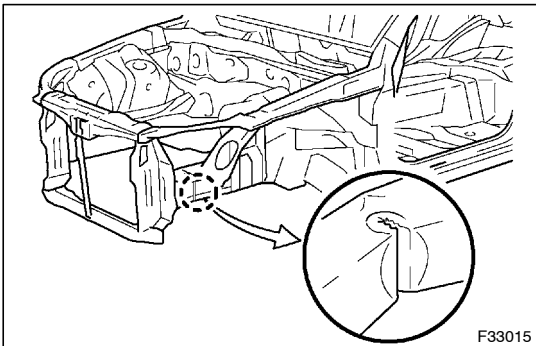
Toyota prohibits the use of the heat repair method on body structure panels when repairing a vehicle damaged in a collision.

Panels that have high strength and rigidity, as well as a long life span for the automobile body are in high demand.

At Toyota, in order to fulfill these requirements, we use high tensile strength steel sheets and rust preventive steel sheets on the body. High tensile steel sheets are made with alloy additives and a special heat treatment in order to improve their strength.

To prevent the occurrence of rust for a long period of time, the surface of the steel is coated with a zinc alloy.

If body structure parts are heat repaired with an acetylene torch or other heating source, the crystalline organization of the steel sheet will change and their strength of the steel sheet will be reduced. The ability of the body to resist rust is significantly lowered as well since the rust resistant zinc coating is destroyed by heat and the steel sheet surface is oxidized.

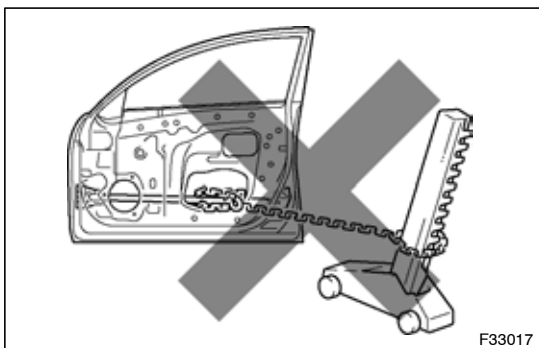
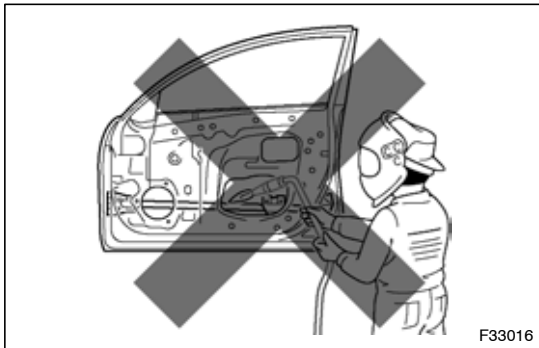


2. STRUCTURE PANEL KINKS

A sharp deformation angle on a panel that cannot be returned to its original shape by pulling or hammering is called a kink.

Structural parts are designed to perform in their original shape. If parts are deformed in an accident, or if the deformed parts are repaired and reused, the parts may be unable to perform as intended.

It is necessary to replace the part where the kink has occurred.



3. IMPACT BEAM REPAIR

The impact beam and bracket are necessary and important parts that help reduce the probability of injury to passengers in side collisions.

For impact beams, we use special high tensile strength steel.

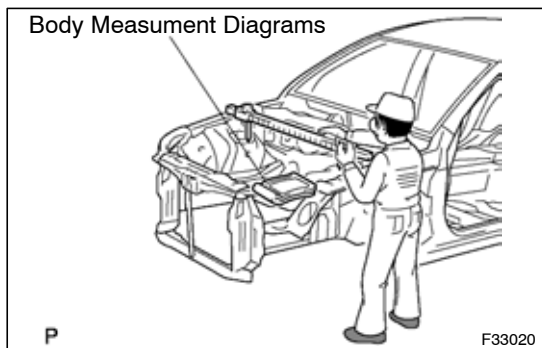
The high tensile strength steel maintains its special crystal-line organization by heat treatment or alloy additives.

Structural parts are designed to perform in their original shape. If parts are deformed in an accident, or if the deformed parts are repaired and reused, the parts may be unable to perform as intended.

If the impact beam or bracket is damaged, replace the door assembly that has the damaged beam.

Also, the bumper reinforcement is a necessary and important part that helps reduce the probability of injury to passengers in front collisions, and for the same reasons explained above, should be replaced if damaged.

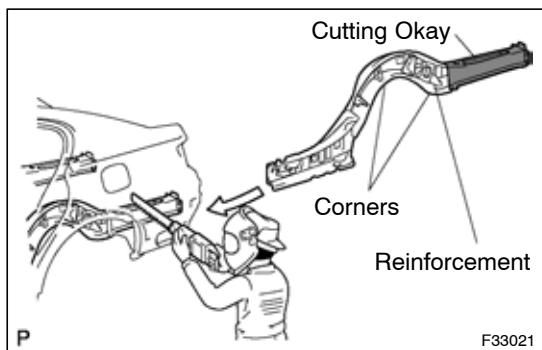
PROPER AND EFFICIENT WORK PROCEDURES



1. REMOVAL

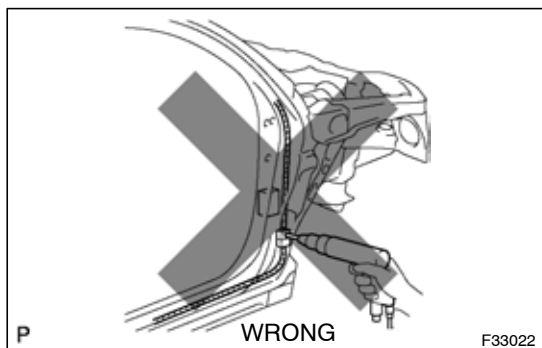
(a) PRE-REMOVAL MEASURING

- (1) Before removal or cutting operations, take measurements in accordance with the dimensions diagram. Always use a puller to straighten a damaged body or frame.



(b) CUTTING AREA

- (1) Always cut in a straight line and avoid cutting reinforced areas.



(c) PRECAUTIONS FOR DRILLING OR CUTTING

- (1) Check behind any area to be drilled or cut to ensure that there are no hoses, wires, etc., that may be damaged.

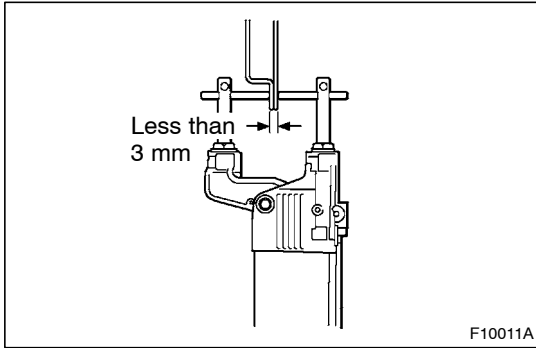
HINT: See "Handling Precautions on Related Components" on [page IN-15](#).



(d) REMOVAL OF ADJACENT COMPONENTS

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

HINT: See "Handling Precautions on Related Components" on [page IN-15](#).

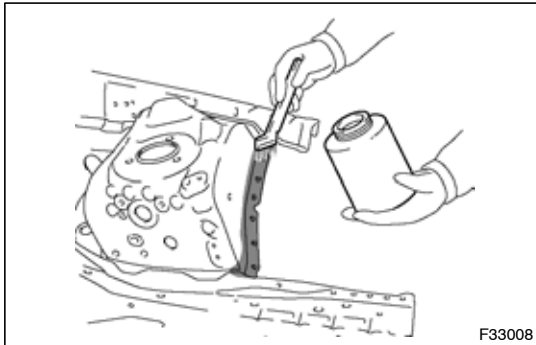


2. PREPARATION FOR INSTALLATION

(a) SPOT WELD POINTS

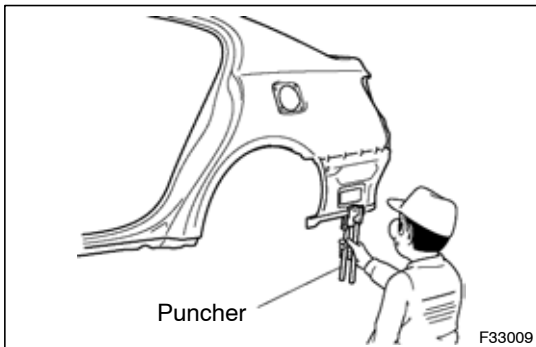
- (1) When welding panels with a combined thickness of over 3 mm (0.12 in.), use a MIG (Metal Inert Gas) welder for plug welding.

HINT: Spot welding does not provide sufficient durability for panels with a combined thickness of over 3 mm (0.12 in.)



(b) APPLICATION OF WELD-THROUGH PRIMER (SPOT SEALER)

- (1) Remove the paint from the portion of the new parts and body to be welded, and apply weld-through primer.



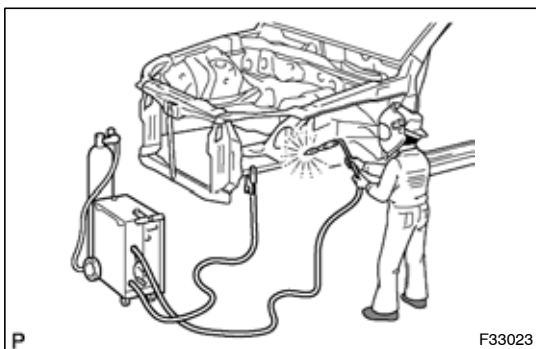
(c) MAKING HOLES FOR PLUG WELDING

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

REFERENCE:

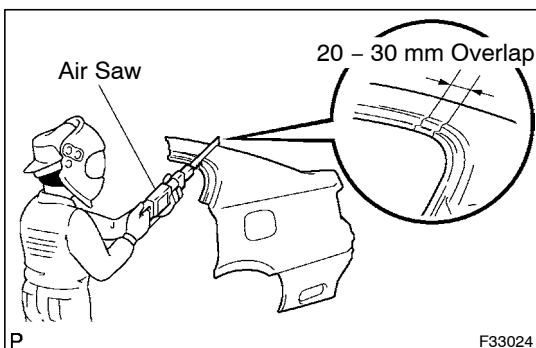
mm (in.)

Thickness of welded portion	Size of plug hole
1.0 (0.04) under	ø 5 (0.20) over
1.0 (0.04) – 1.6 (0.06)	ø 6.5 (0.26) over
1.7 (0.07) – 2.3 (0.09)	ø 8 (0.31) over
2.4 (0.09) over	ø 10 (0.39) over



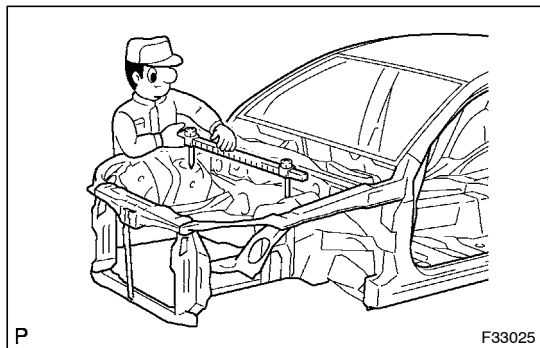
(d) SAFETY PRECAUTIONS FOR ELECTRICAL COMPONENTS

- (1) When welding, there is a danger that electrical components will be damaged by the electrical current flowing through the body.
- (2) Before starting work, disconnect the negative terminal of the battery and ground the welder near the welding location of the body.



(e) ROUGH CUTTING OF JOINTS

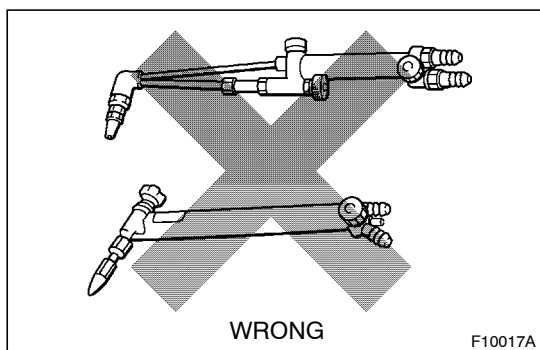
- (1) For joint areas, rough cut the new parts, leaving 20 – 30 mm (0.79 – 1.18 in.) of overlap.



3. INSTALLATION

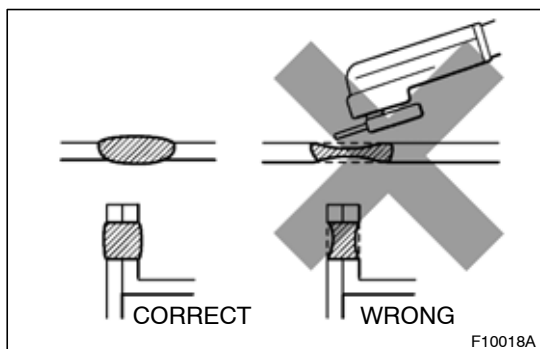
(a) PRE-WELDING MEASUREMENTS

- (1) Always take measurements before installing underbody or engine components to ensure correct assembly. After installation, confirm proper fit.



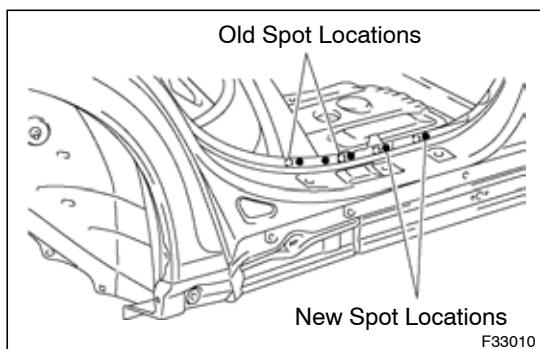
(b) WELDING PRECAUTIONS

- (1) The number of welding spots should be as follows.
Spot weld: 1.3 X No. of manufacturer's spots.
Plug weld: More than No. of manufacturer's plugs.
- (2) Plug welding should be done with a MIG (Metal Inert Gas) welder. Do not gas weld or braze panels at areas other than where specified.



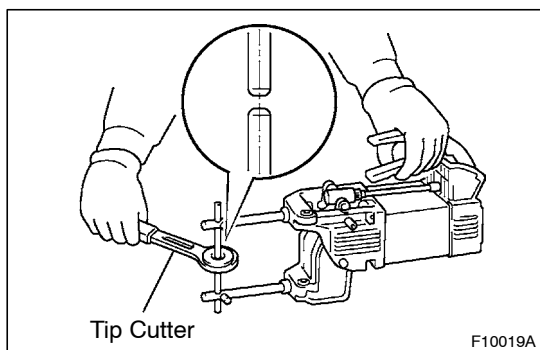
(c) POST-WELDING REFINISHING

- (1) Always check the welded spots to ensure that they are secure.
- (2) When smoothing out the weld spots with a disc grinder, be careful not to grind off too much as this will weaken the weld.



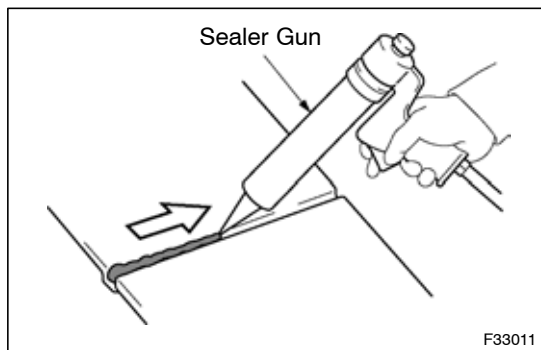
(d) SPOT WELD LOCATIONS

- (1) Avoid welding over previously welded areas.



(e) SPOT WELDING PRECAUTIONS

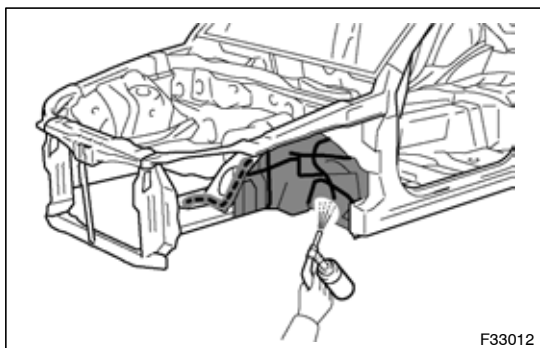
- (1) The shape of the tip point of the spot welder significantly affects the strength of the weld. Therefore, maintain the tip point in the proper shape, and allow it to cool after every five or six spots.
- (2) Completely remove the paint from the areas to be spot welded, including the seams and the surfaces that come in contact with the welding tip.
- (3) Use a sander to remove any burrs that are created during spot welding.



4. ANTI-RUST TREATMENT AFTER INSTALLATION (BEFORE PAINTING PROCESS)

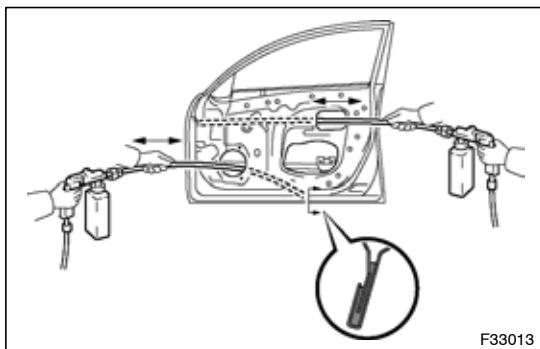
(a) BODY SEALER APPLICATION

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



(b) UNDERCOAT APPLICATION

- (1) To prevent corrosion and protect the body from damage by flying stones, always apply sufficient under coating to the bottom surface of the under body and inside of the wheel housings.



5. ANTI-RUST TREATMENT AFTER INSTALLATION (AFTER PAINTING PROCESS)

(a) ANTI-RUST AGENT (WAX) APPLICATION

- (1) To preserve impossible to paint areas from corrosion, always apply sufficient anti-rust agent (wax) to the inside of the hemming areas of the doors and hood, and around the hinges, or the welded surfaces inside the box-shaped cross sections of the side members, body pillars, etc.

6. ANTI-RUST TREATMENT BY PAINTING

REFERENCE:

Painting prevents corrosion and protects the sheet metal from damage. In this section, anti-chipping paint only for anti-corrosion purposes is described.

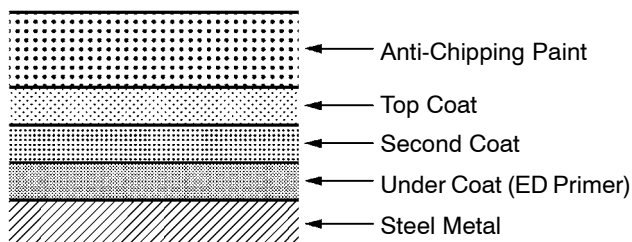
(a) ANTI-CHIPPING PAINT

- (1) To prevent corrosion and protect the body from damage by flying stones, etc., apply anti-chipping paint to the rocker panel, wheel arch areas, balance panel, etc.

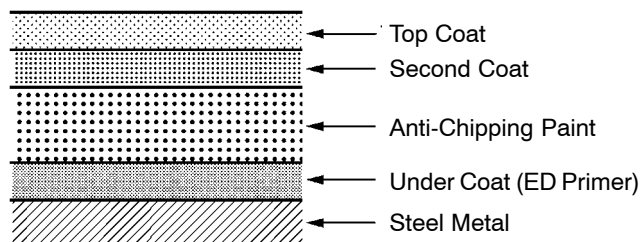
HINT:

Depending on the model or the application area, there are cases where the application of anti-chipping paint is necessary before the second coat or after the top coat.

- Apply the anti-chipping paint after the top coat.



- Apply the anti-chipping paint before the second coat.



F10024A

HANDLING PRECAUTIONS ON RELATED COMPONENTS

1. BRAKE SYSTEM

The brake system is one of the most important safety components. Always follow the directions and notes given in the brake section of the repair manual for the relevant model year when handling brake system parts.

NOTICE: When repairing the brake master cylinder or TRAC system, bleed the air out of the TRAC system.

2. DRIVE TRAIN AND CHASSIS

The drive train and chassis are components that can have great effects on the running performance and vibration resistance of the vehicle. After installing components in the sections listed in the table below, perform alignments to ensure correct mounting angles and dimensions. Body repair must be particularly accurate to ensure correct alignment.

HINT: Correct procedures and special tools are required for alignment. Always follow the directions given in the repair manual for the relevant model year during alignment and in section DI of this section.

Component to be aligned	Section of repair manual for relevant model
Front Wheels	Front Suspension section
Rear Wheels	Rear Suspension section
Propeller Shaft	Propeller Shaft section

3. COMPONENTS ADJACENT TO THE BODY PANELS

Various types of component parts are mounted directly on or adjacently to the body panels. Strictly observe the following precautions to prevent damaging these components and the body panels during handling.

- Before repairing the body panels, remove their components or apply protective covers over the components.
- Before prying components off using a screwdriver or a scraper, etc., attach protective tape to the tool tip or blade to prevent damaging the components and the body paint.
- Before removing components from the outer surface of the body, attach protective tape to the body to ensure no damage to painted areas.

HINT: Apply touch-up paint to any damaged paint surfaces.

- Before drilling or cutting sections, make sure that there are no wires, etc., on the reverse side.

4. ECU (ELECTRONIC CONTROL UNIT)

Many ECUs are mounted in this vehicle.

Take the following precautions during body repair to prevent damage to the ECUs.

- Before starting electric welding operations, disconnect the negative (–) terminal cable from the battery.

When the negative (–) terminal cable is disconnected from the battery, the memory of the clock and audio systems will be erased. So, before starting work, make a record of the contents memorized by each memory system. Then when work is finished, reset the clock and audio systems as before.

When the vehicle has tilt and telescopic steering, power seats and outside rear view mirrors, which are all equipped with a memory function, it is not possible to make a record of the memory contents.

When the operation is finished, it will be necessary to explain this fact to the customer, and request the customer to adjust the features and reset the memory.

- Do not expose the ECUs to ambient temperatures above 80°C (176°F).

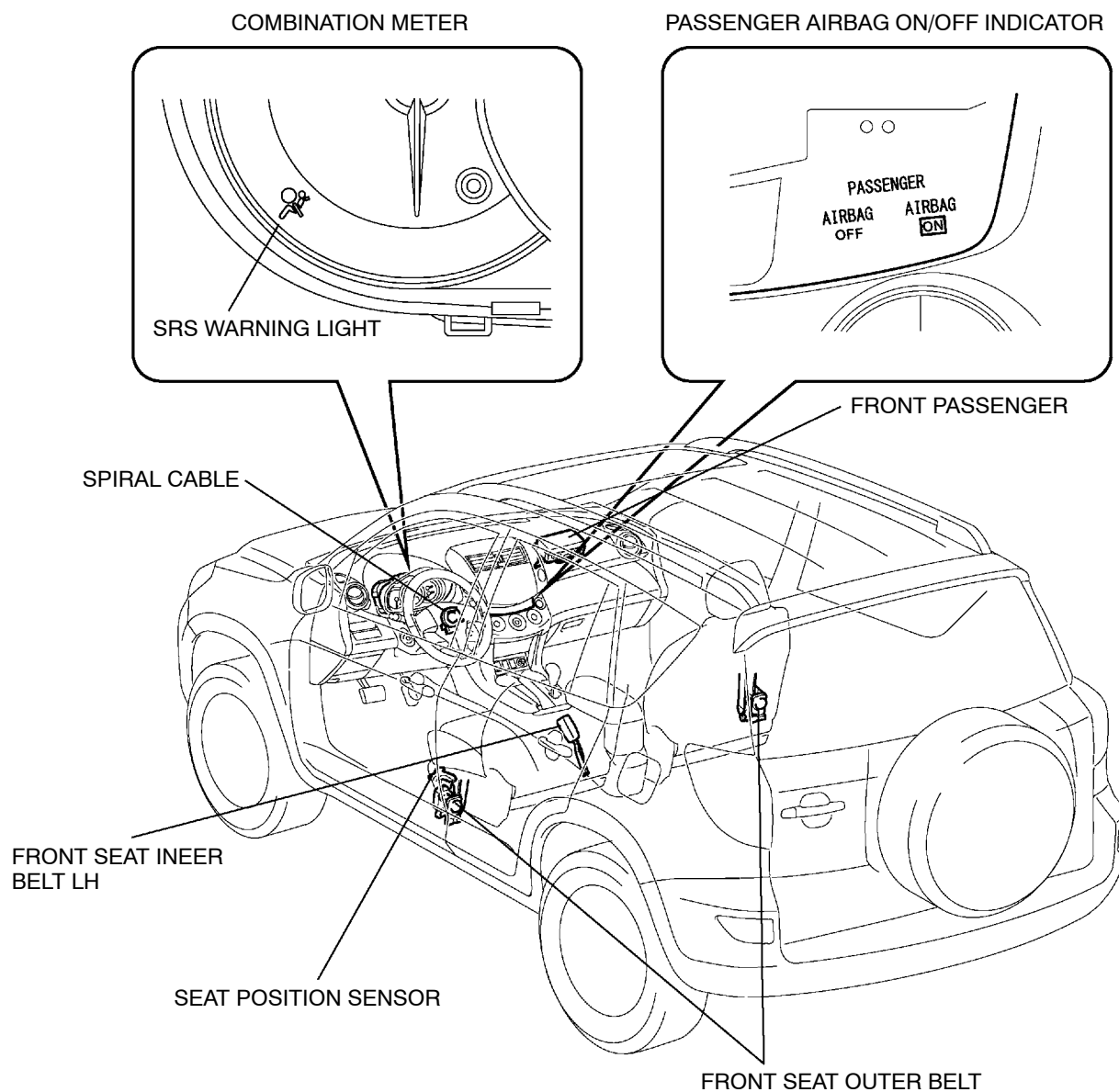
NOTICE: Since it is possible that the ambient temperature may reach 80°C (176°F) or more, remove the ECUs from the vehicle before starting work.

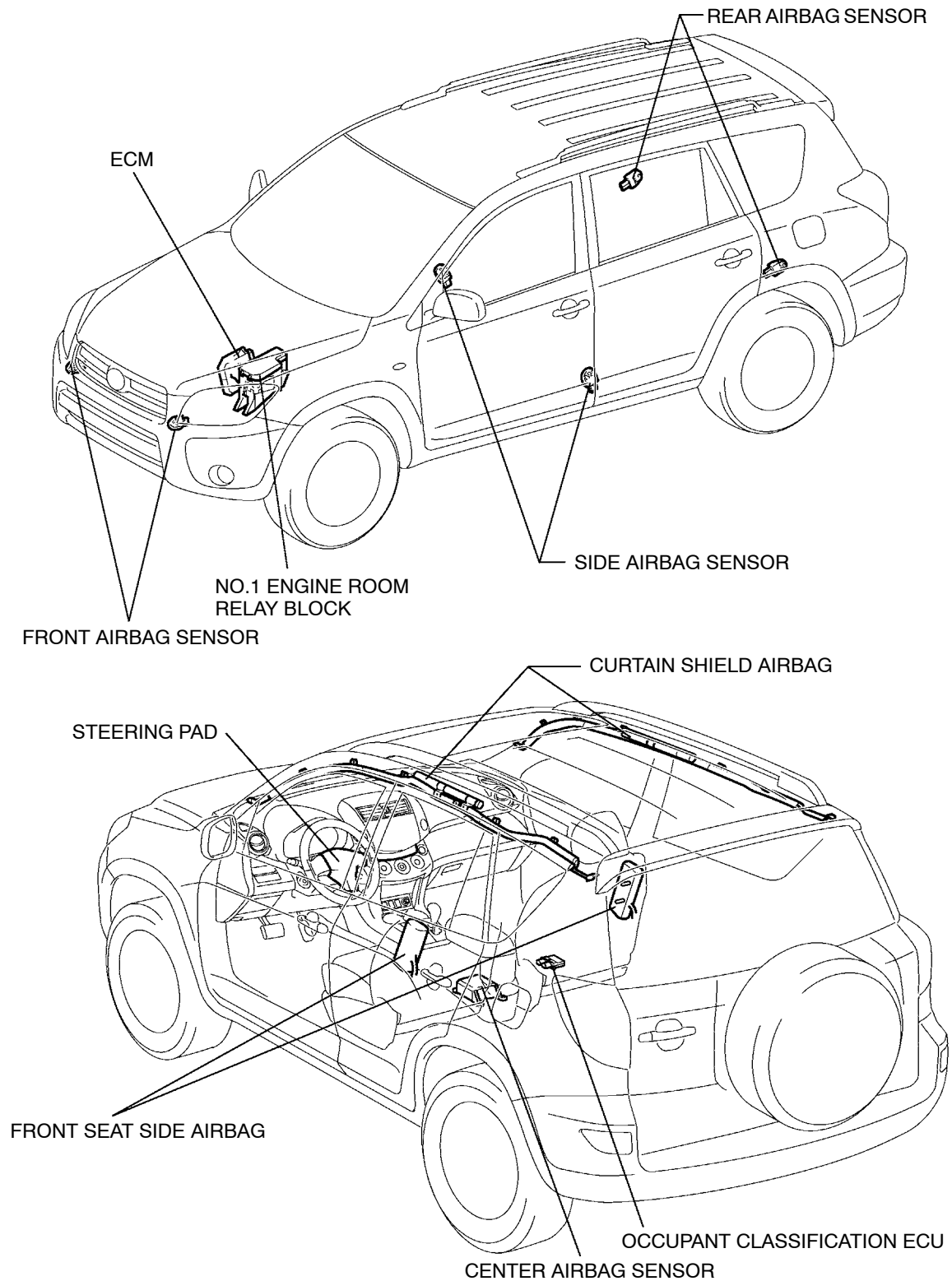
- Be careful not to drop the ECUs and not to apply physical shocks to them.

DAMAGED VEHICLE DISPOSAL PRECAUTION (SRS AIRBAG SYSTEM)

For SRS airbag system adjustment methods, refer to the TOYOTA Repair Manual.

- (1) When using an electric welder, first remove all airbags and the seat belt pretensioner.
- (2) If impacts are likely to occur to the front airbag sensor, side airbag sensor, rear airbag sensor or seat position sensor, remove each sensor as necessary beforehand.
- (3) Do not allow the front airbag sensor, side airbag sensor, rear airbag sensor or seat position sensor to become heated to high temperatures.



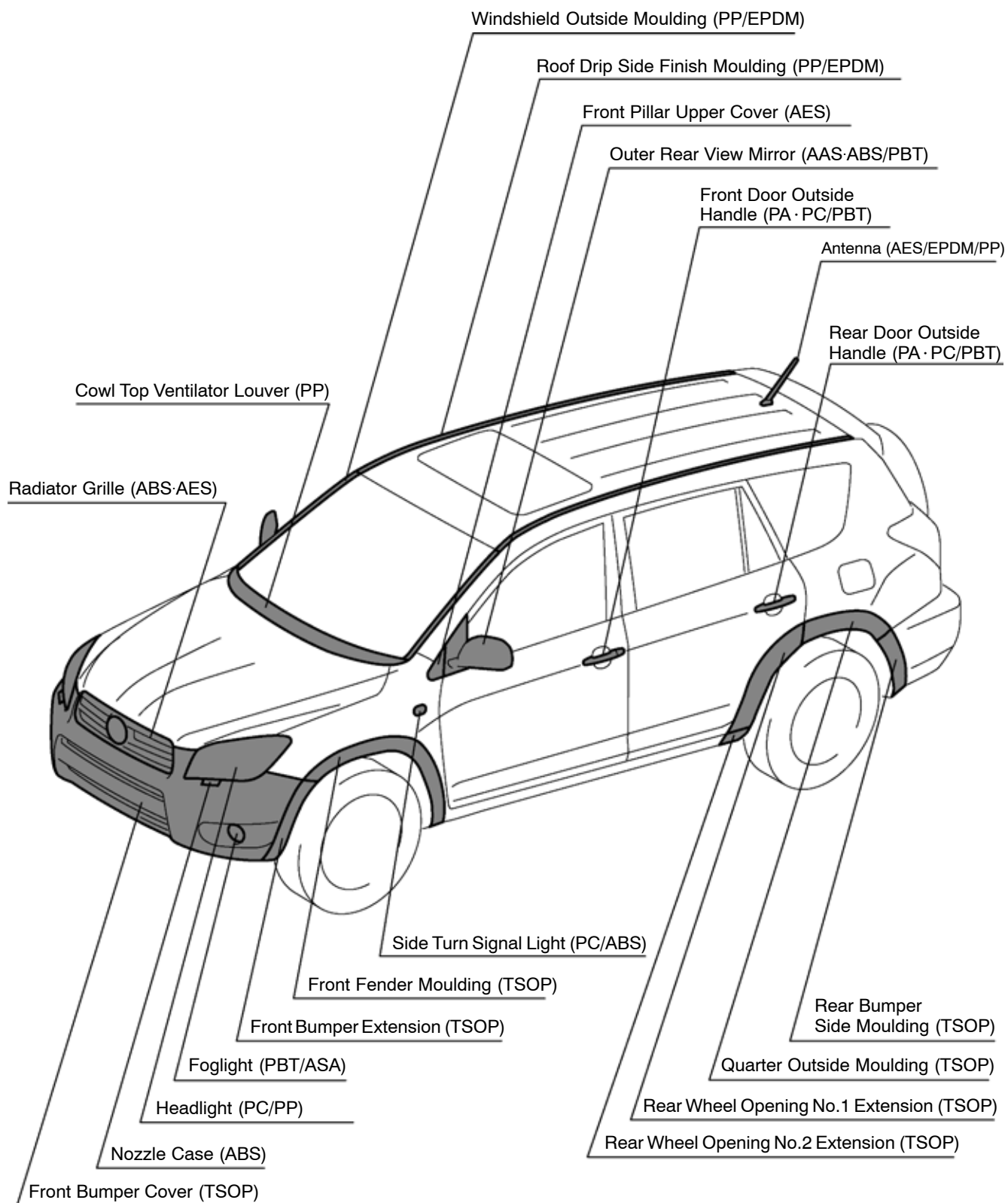


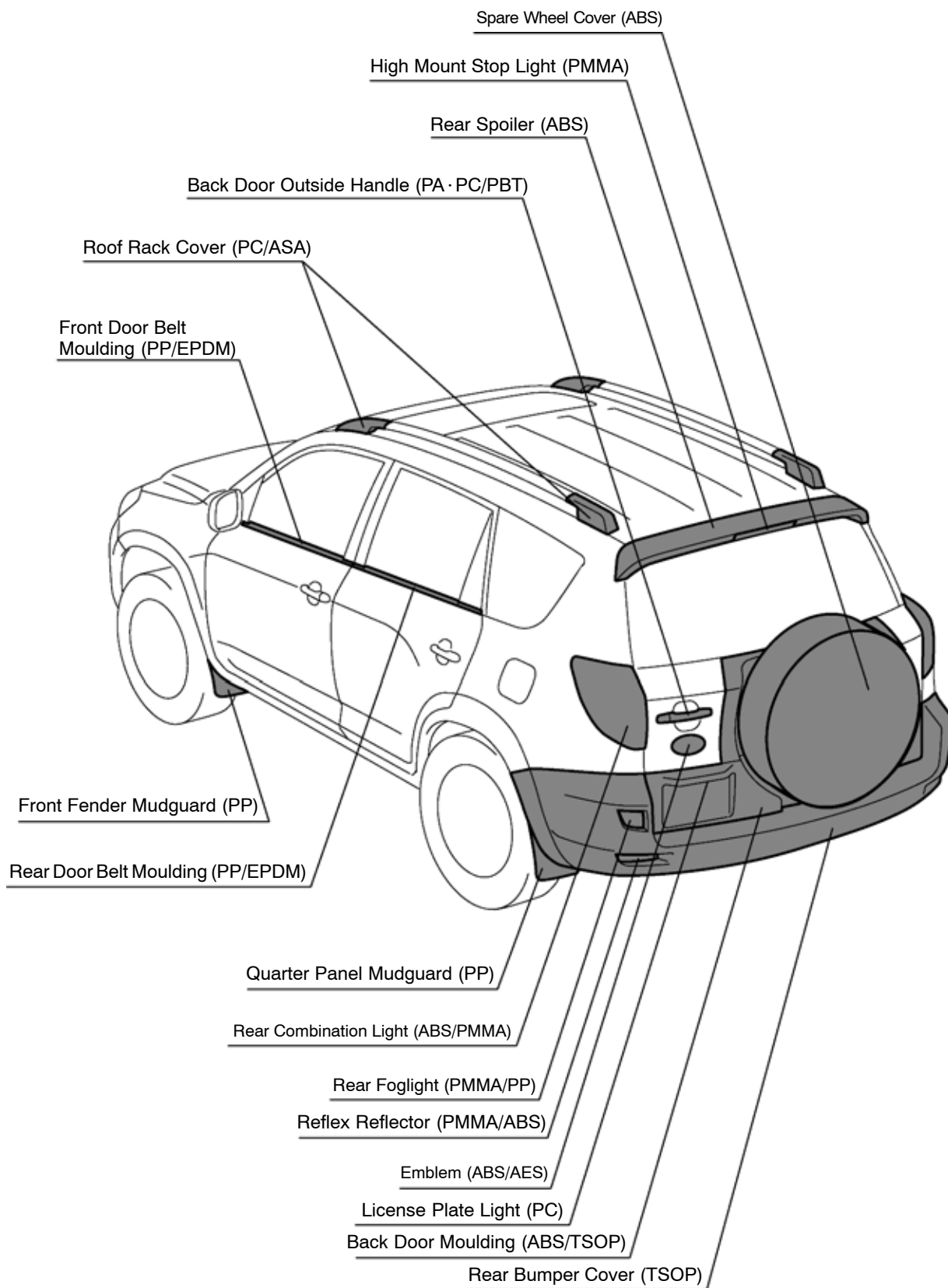
HANDLING PRECAUTIONS OF PLASTIC BODY PARTS

1. The repair procedure for plastic body parts must conform with the type of plastic material.
2. Plastic body parts are identified by the codes in the following table.
3. When repairing metal body parts adjoining plastic body parts (by brazing, frame cutting, welding, painting etc.), consideration must be given to the properties of the plastic.

Code	Material name	Heat* resistant temperature limit °C (°F)	Resistance to alcohol or gasoline	Notes
AAS	Acrylonitrile Acrylic Styrene	80 (176)	Alcohol is harmless if applied only for short time in small amounts (e.g., quick wiping to remove grease).	Avoid gasoline and organic or aromatic solvents.
ABS	Acrylonitrile Butadiene Styrene	80 (176)	Alcohol is harmless if applied only for short time in small amounts (e.g., quick wiping to remove grease).	Avoid gasoline and organic or aromatic solvents.
AES	Acrylonitrile Ethylene Styrene	80 (176)	Alcohol is harmless if applied only for short time in small amounts (e.g., quick wiping to remove grease).	Avoid gasoline and organic or aromatic solvents.
ASA	Acrylonitrile Styrene Acrylate	80 (176)	Alcohol is harmless if applied only for short time in small amounts (e.g., quick wiping to remove grease).	Avoid gasoline and organic or aromatic solvents.
EPDM	Ethylene Propylene	100 (212)	Alcohol is harmless. Gasoline is harmless if applied only for short time in small amounts.	Most solvents are harmless but avoid dipping in gasoline, solvents, etc.
PA	Polyamide (Nylon)	80 (176)	Alcohol and gasoline are harmless.	Avoid battery acid.
PBT	Polybutylene Terephthalate	160 (320)	Alcohol and gasoline are harmless.	Most solvents are harmless.
PC	Polycarbonate	120 (248)	Alcohol is harmless.	Avoid gasoline, brake fluid, wax, wax removers and organic solvents. Avoid alkali.
PP	Polypropylene	80 (176)	Alcohol and gasoline are harmless.	Most solvents are harmless.
PMMA	Polymethyl Methacrylate	80 (176)	Alcohol is harmless if applied only for short time in small amounts.	Avoid dipping or immersing in alcohol, gasoline, solvents, etc.
TSOP	TOYOTA Super Olefine Polymer	80 (176)	Alcohol and gasoline are harmless.	Most solvents are harmless.

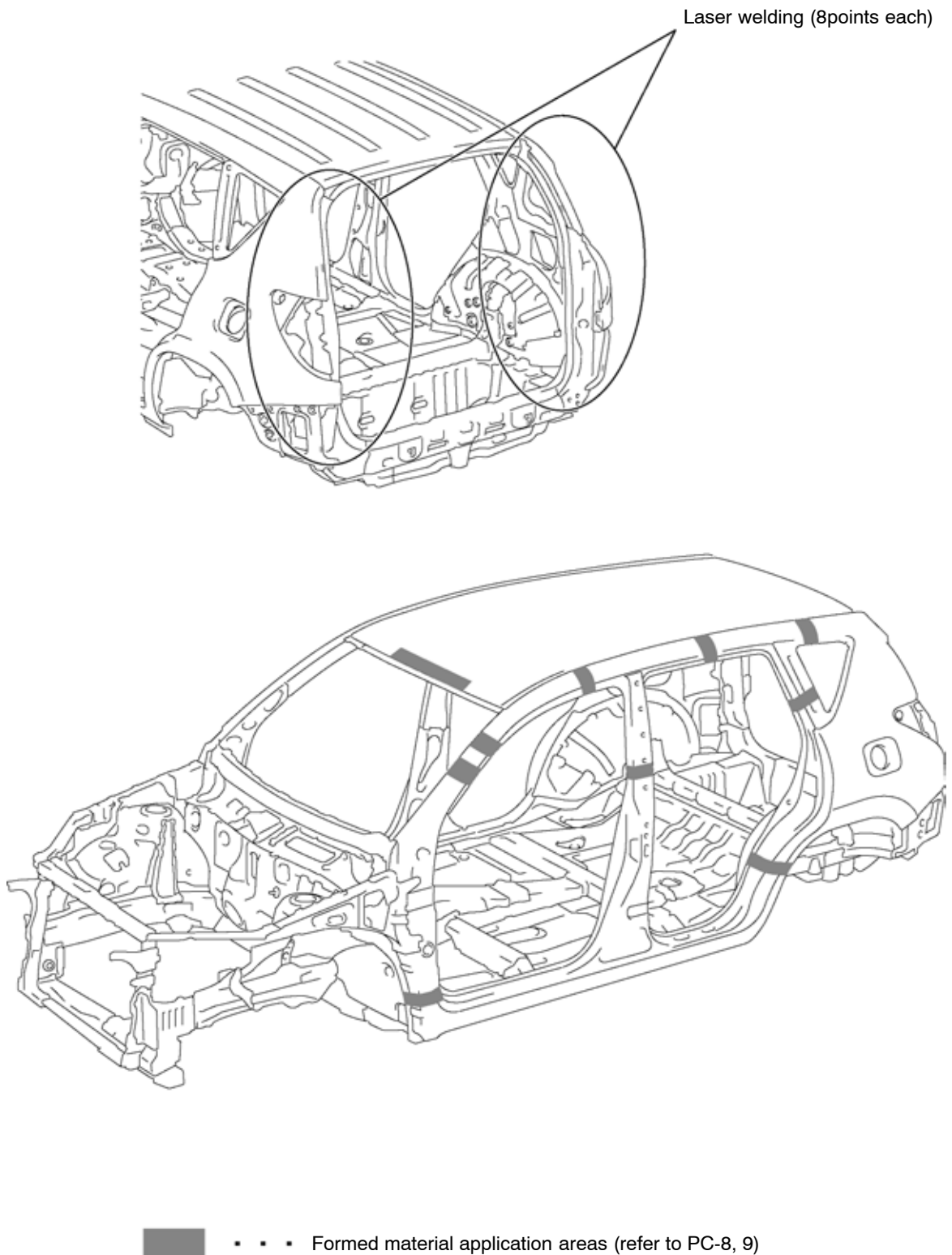
*Temperatures higher than those listed here may result in material deformation during repair.



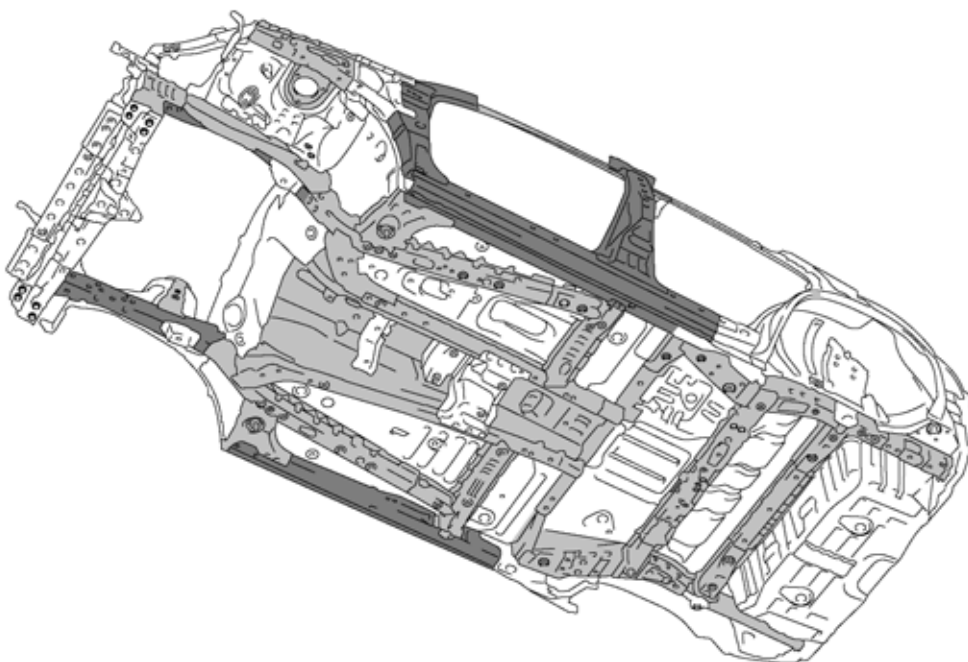
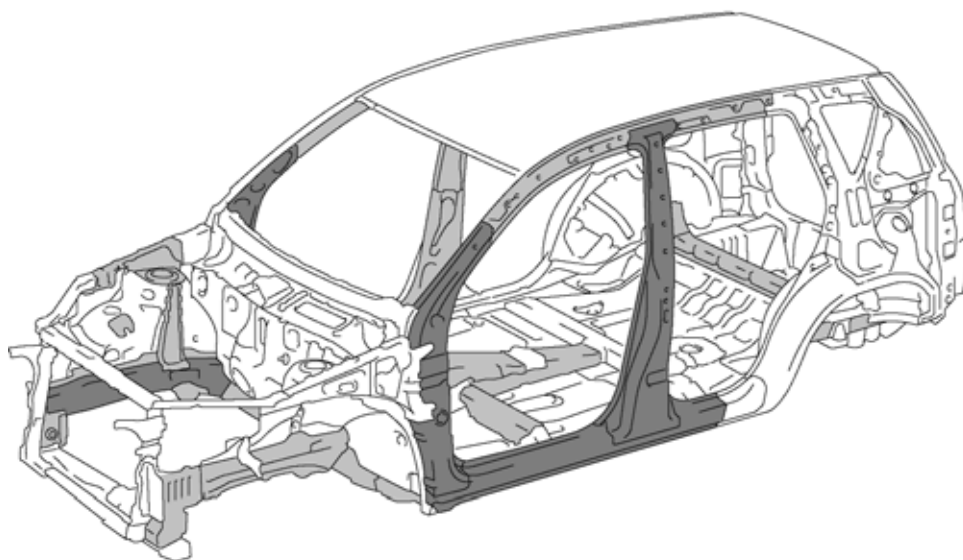


ABOUT THIS VEHICLE

1. STRUCTUAL OUTLINE



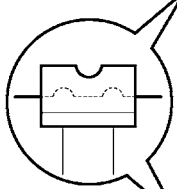
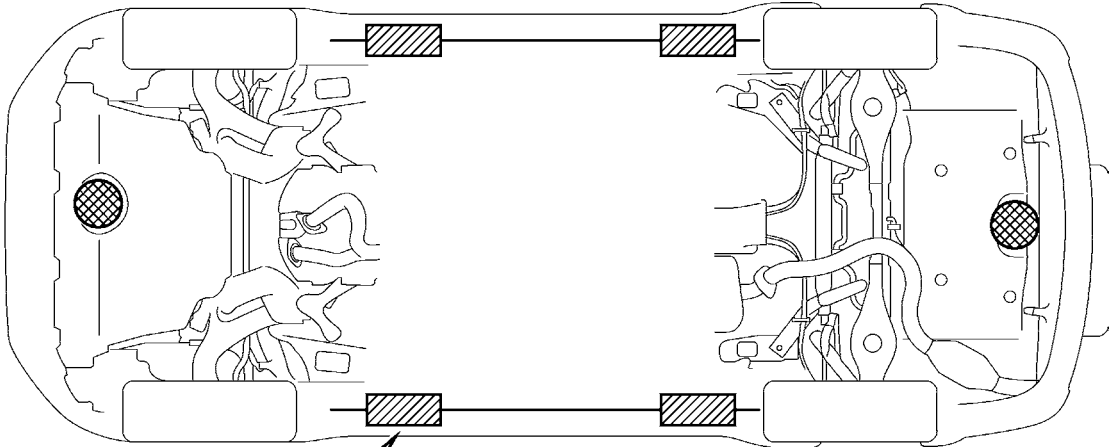
- ... 590Mpa High strength steel
- ... 440Mpa High strength steel



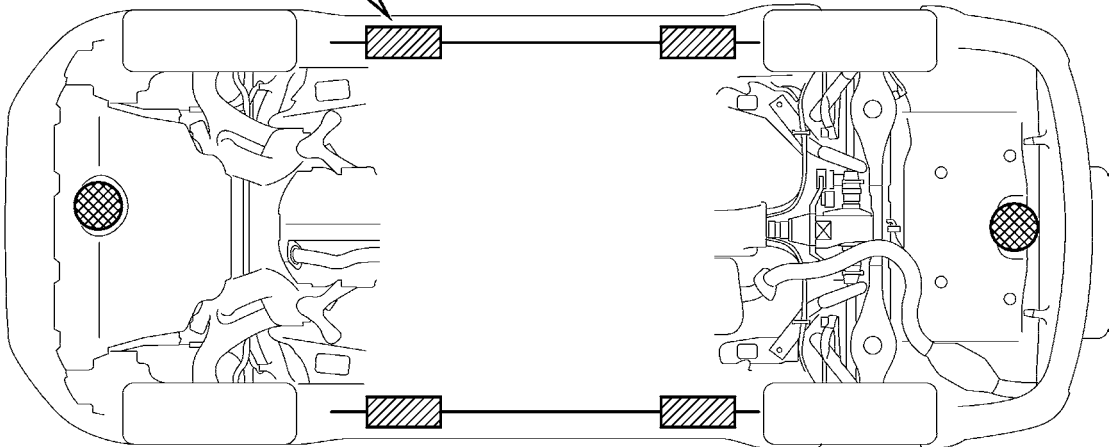
NOTICE ABOUT VEHICLE CONDITION WHEN JACKING UP VEHICLE

1. NOTICE FOR USING JACK AND SAFETY STAND

2WD



4WD



JACK POSITION

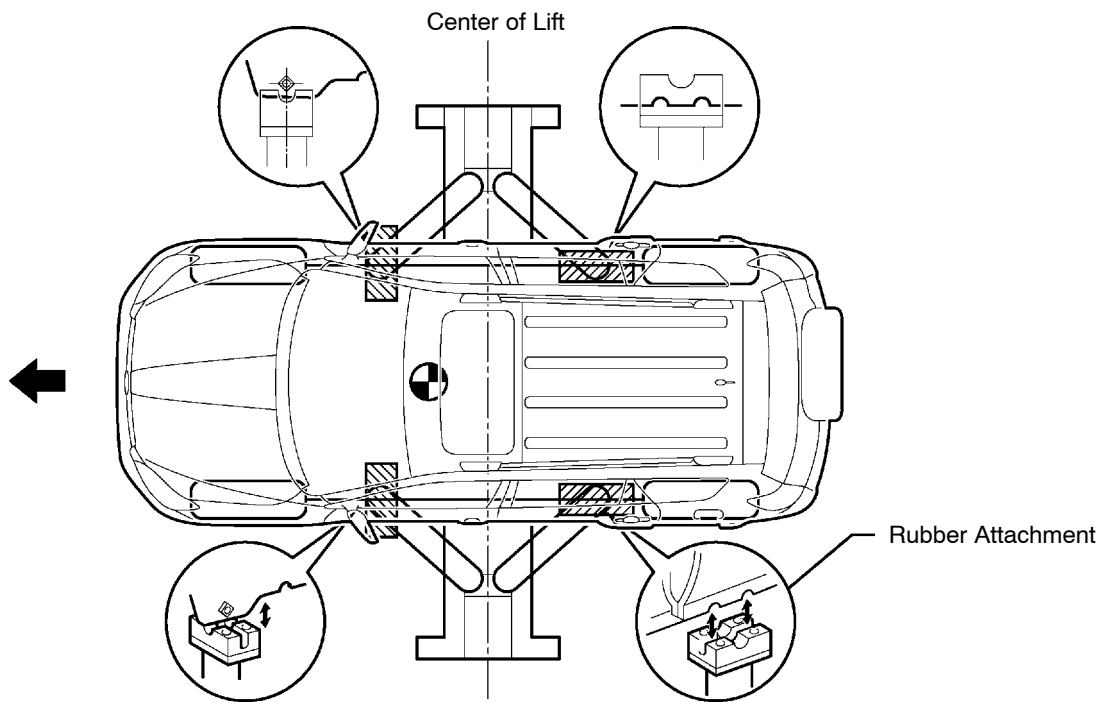
Front: Engine under cover
Rear: Body lower back panel



SUPPORT POSITION

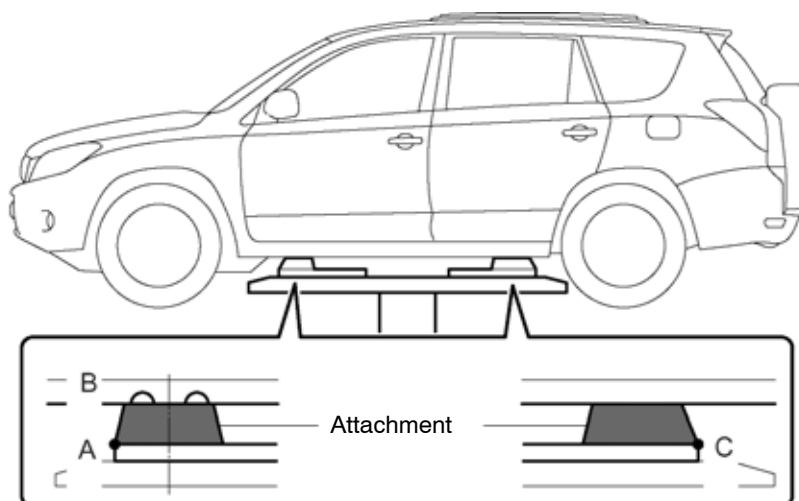
Safety stand and swing arm type lift

2. NOTICE FOR USING SWING ARM TYPE LIFT



D100925

3. NOTICE FOR USING PLATE TYPE LIFT



HINT:

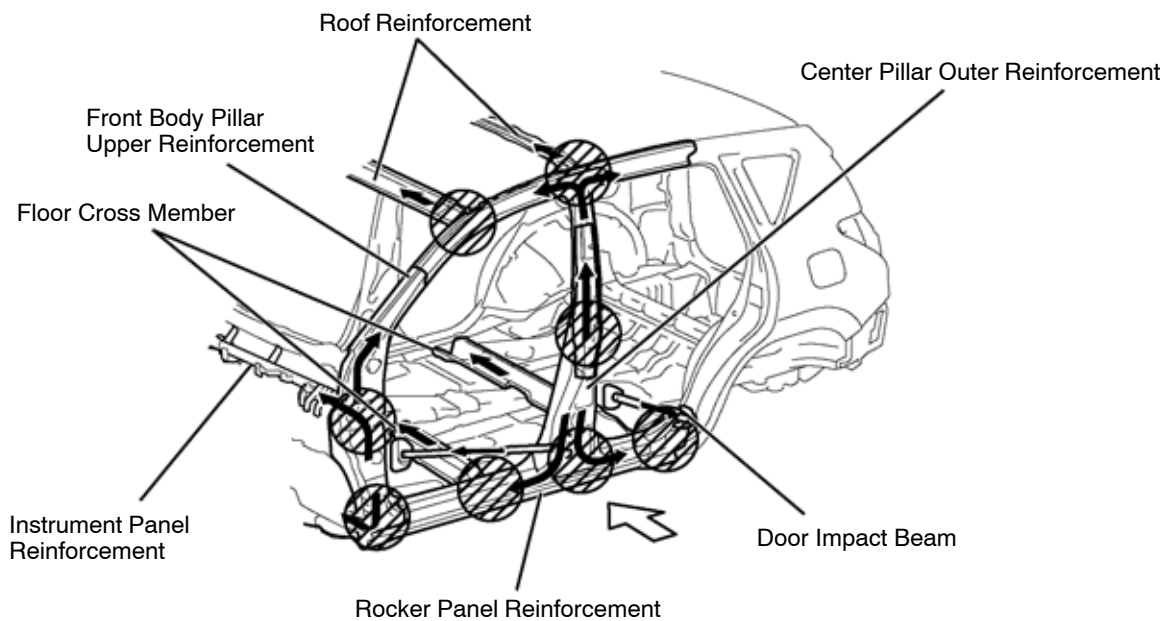
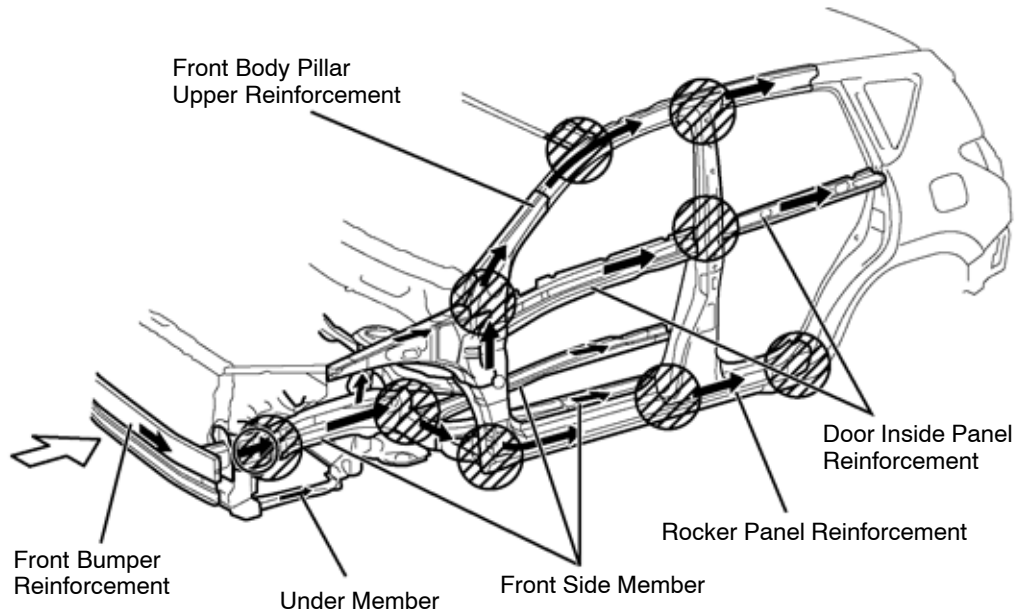
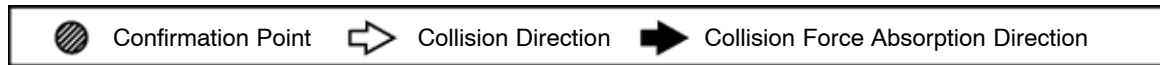
Right and left set position

Place the vehicle over the center of the lift.

Front and rear set position

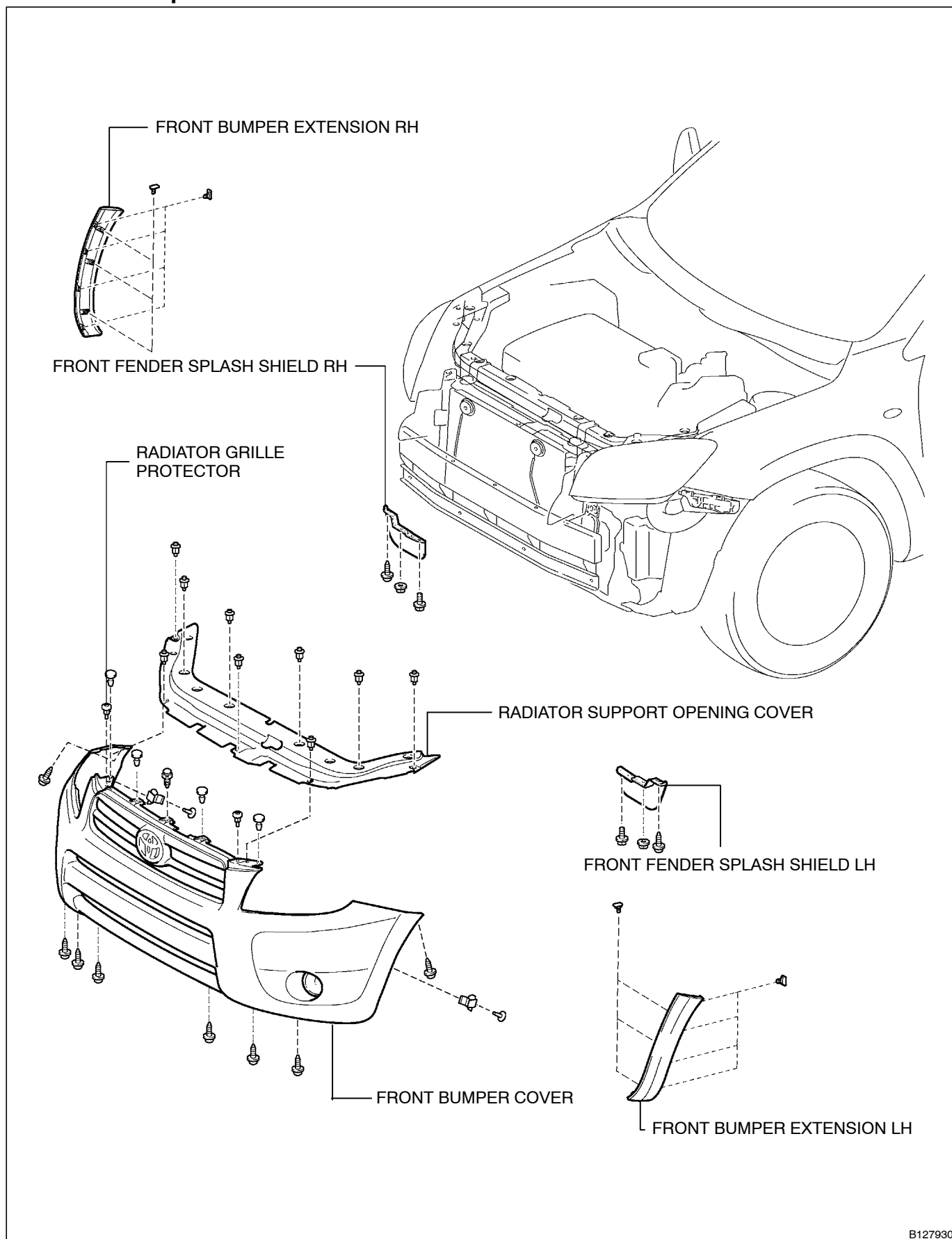
Place the attachments at the ends of the rubber plate surface, under the vehicle lift pad (A and C in the illustration). Raise the plate slightly and reposition the vehicle so the top of the attachment (B in the illustration) is aligned with the front side notch in the vehicle rocker flange.

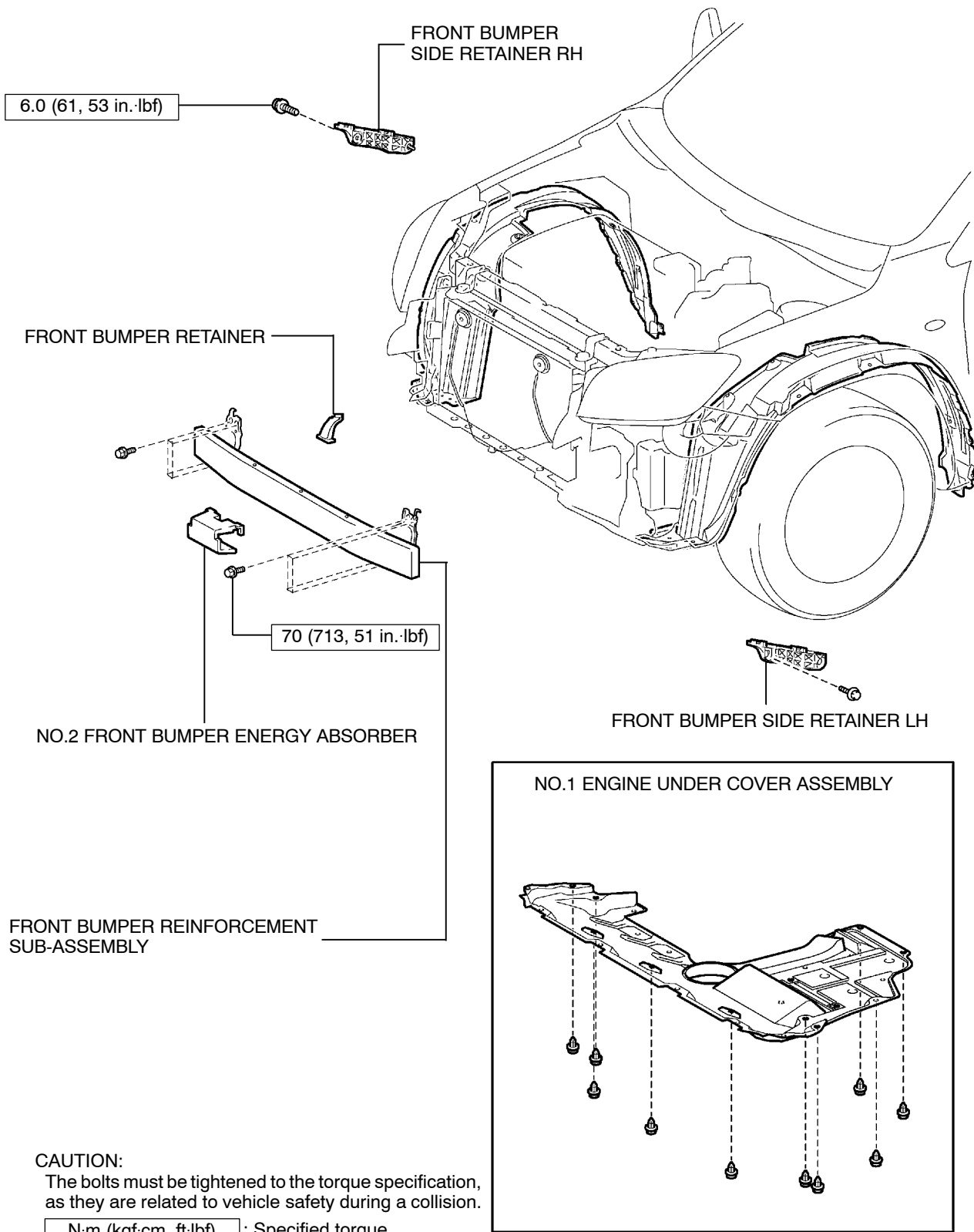
DAMAGE DIAGNOSIS



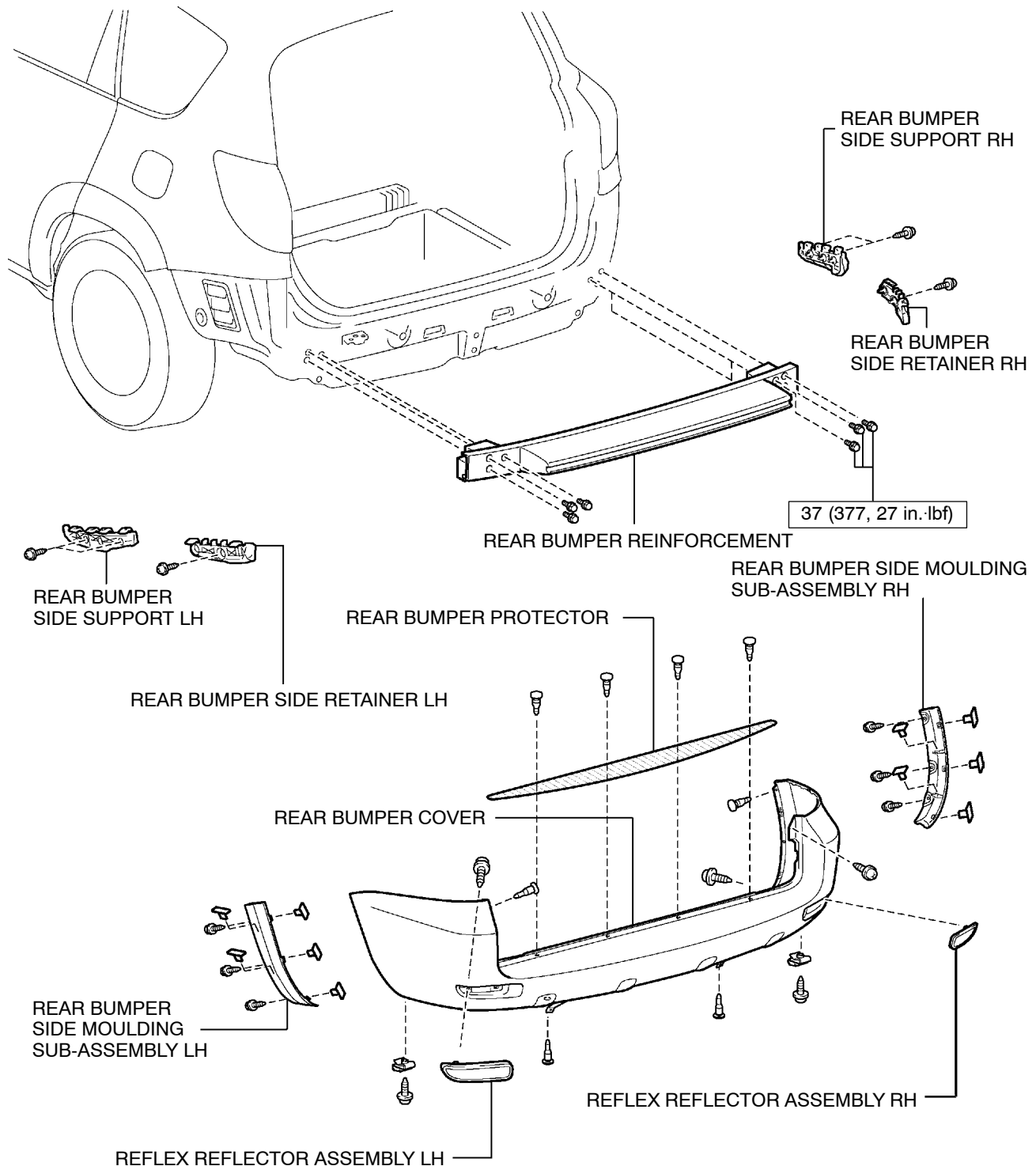
COMPONENTS

1. Front bumper





2. Rear bumper

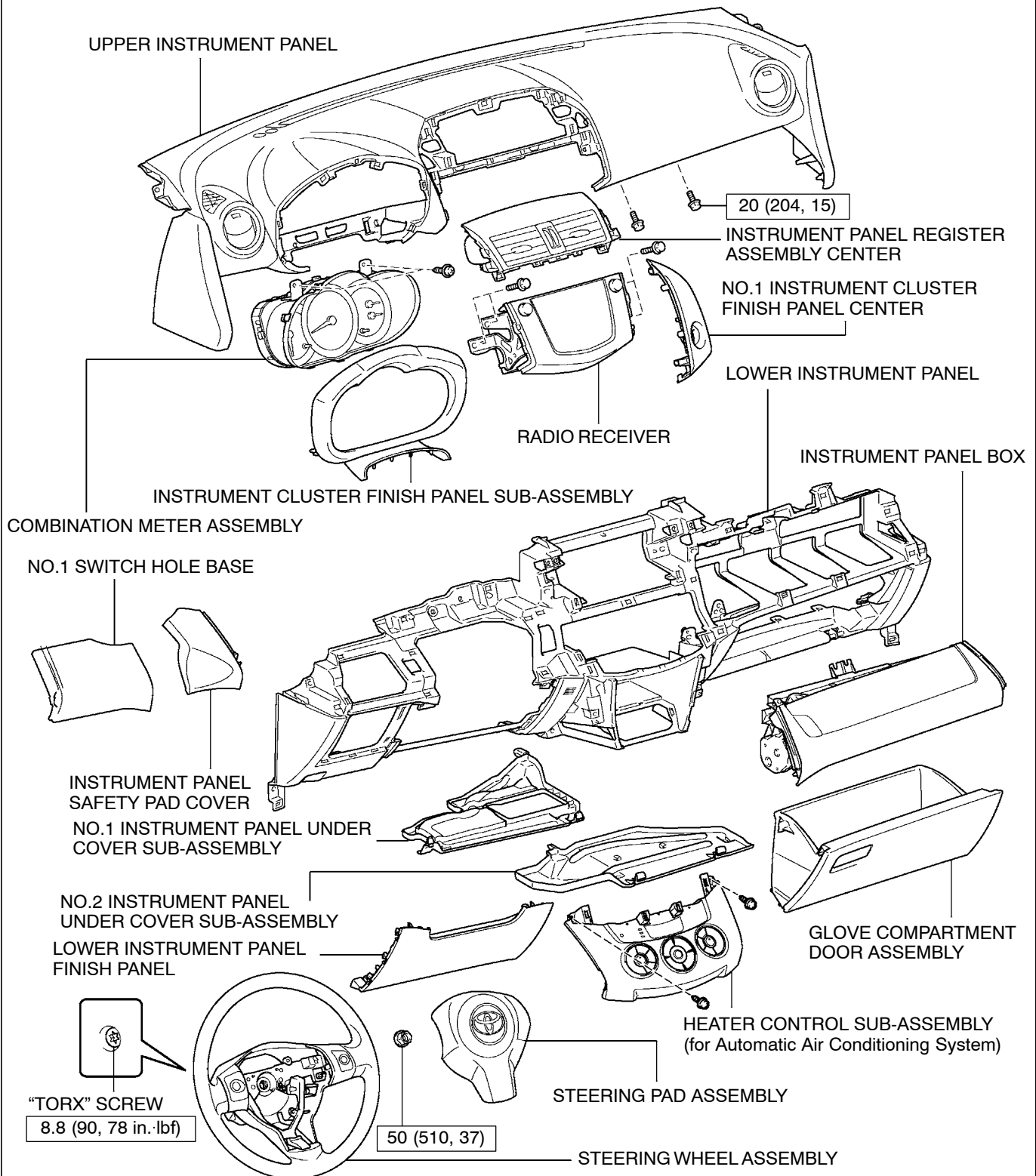


CAUTION:

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

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

3. Instrument panel

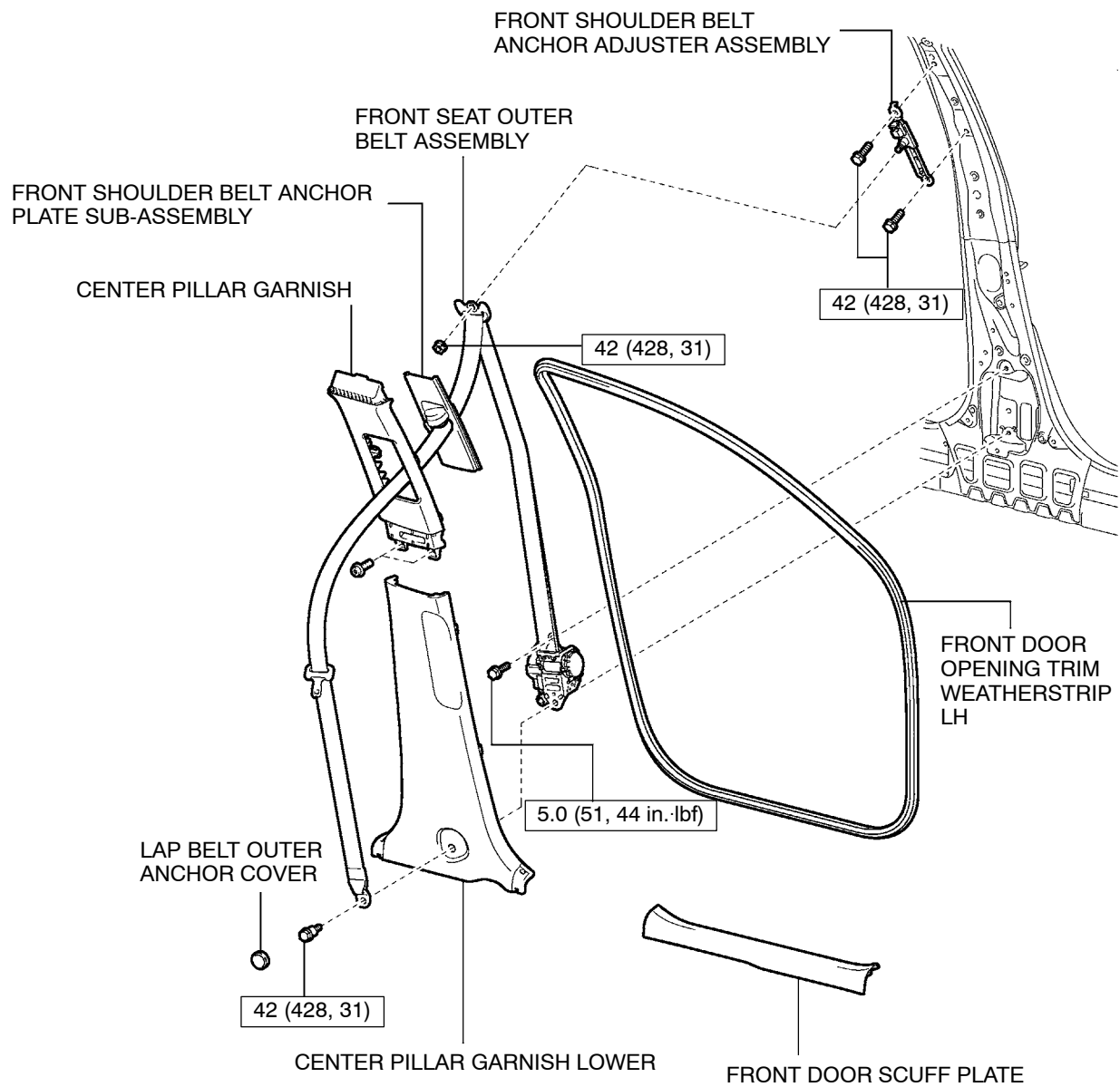


CAUTION:

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

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

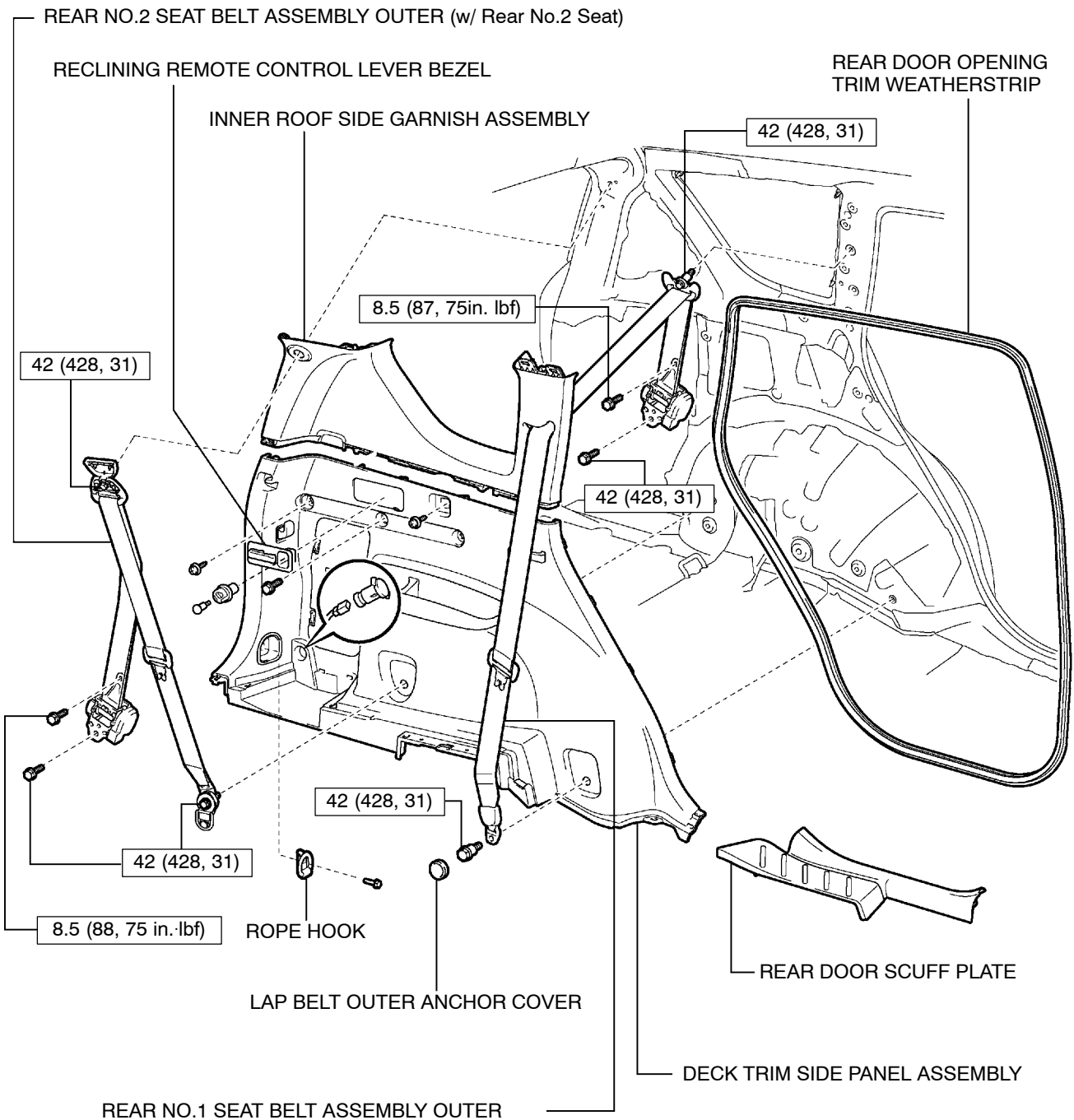
4. Interior trim



CAUTION:

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

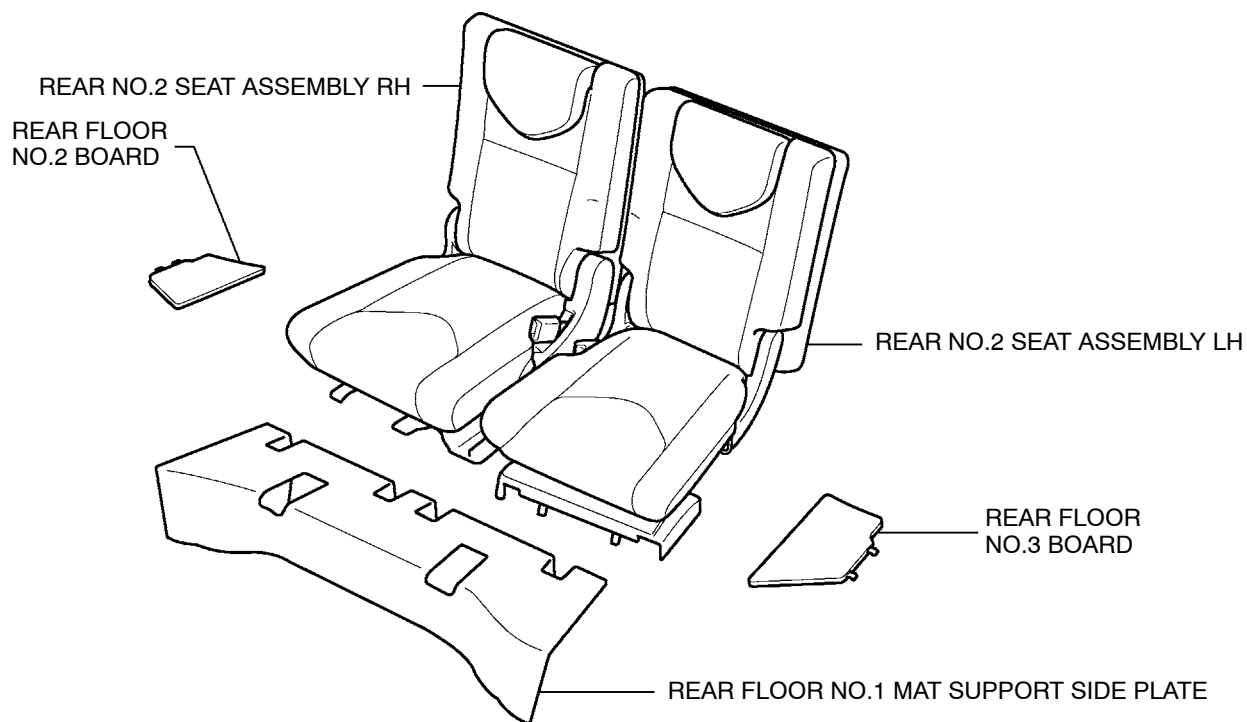
N·m (kgf·cm, ft·lbf) : Specified torque

**CAUTION:**

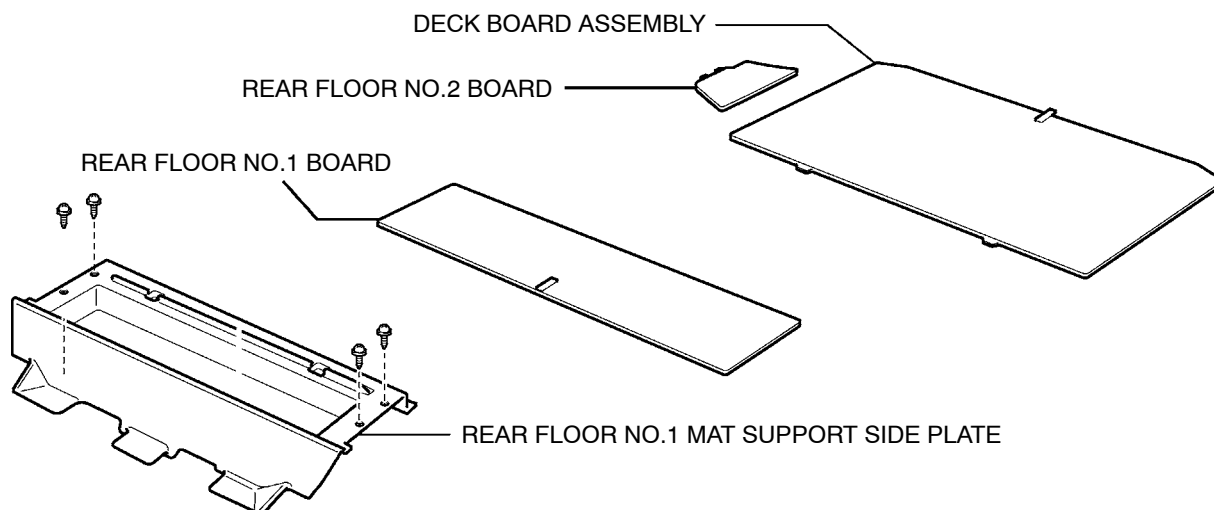
The bolts must be tightened to the torque specification, as they are related to vehicle safety during a collision.

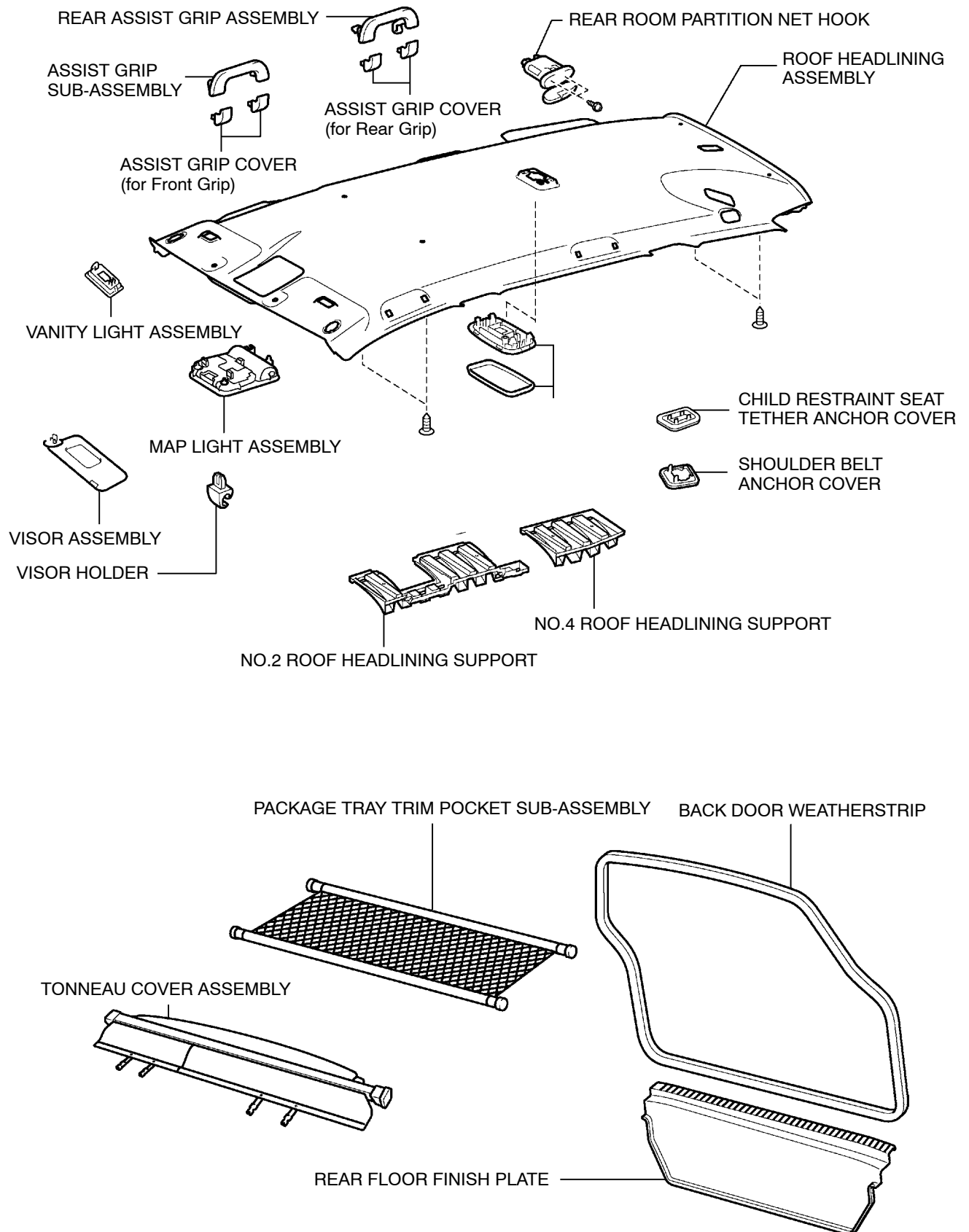
N·m (kgf·cm, ft·lbf) : Specified torque

w/ Rear No.2 Seat

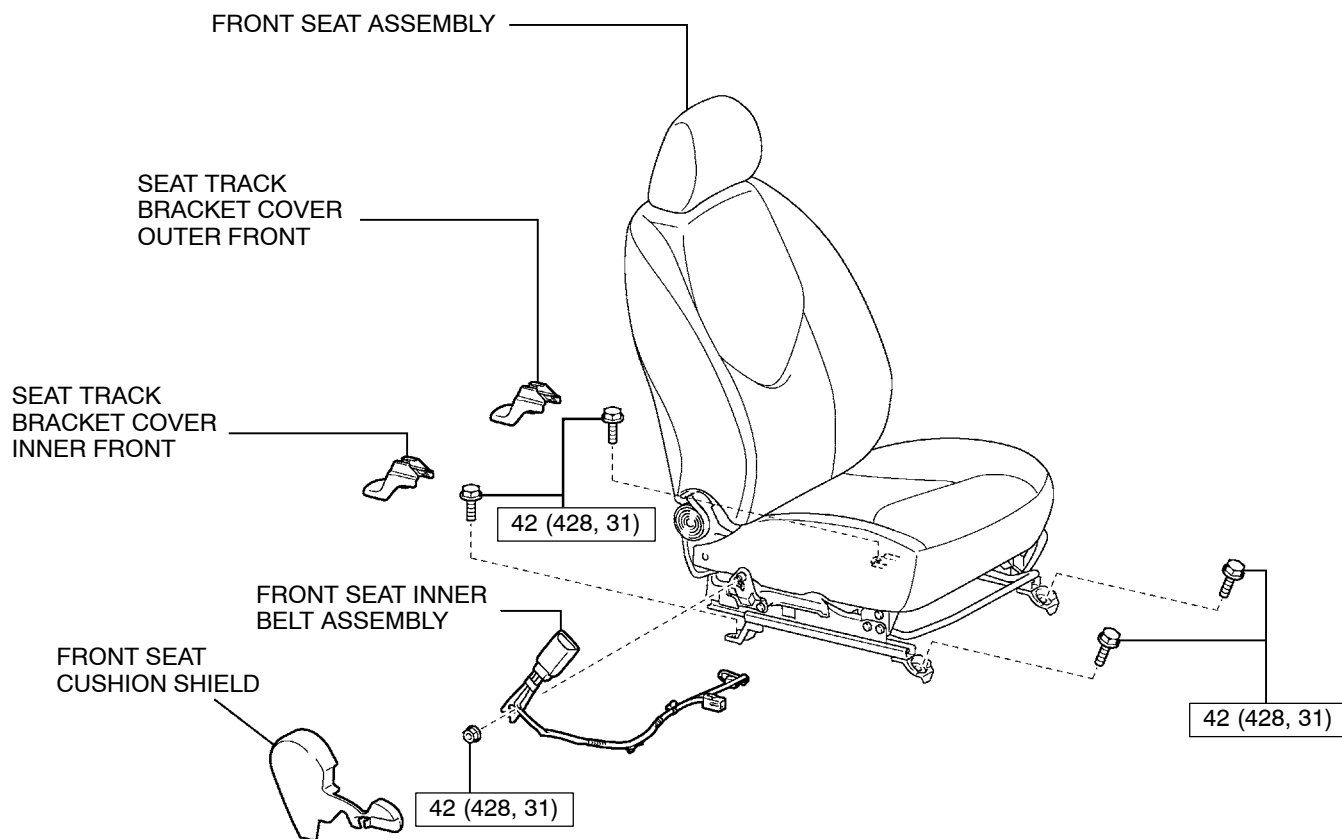


w/o Rear No.2 Seat





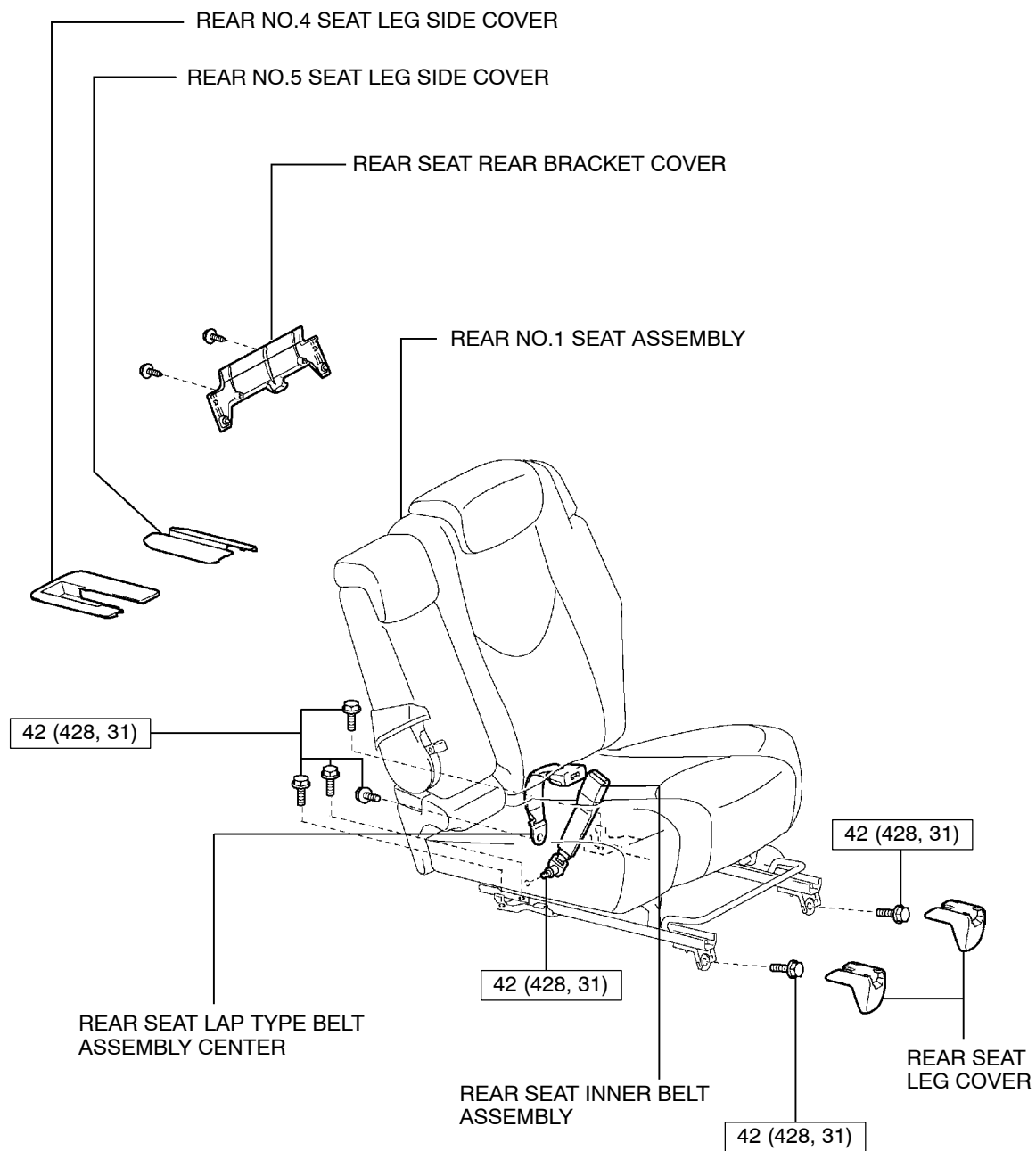
5. Front seat

**CAUTION:**

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

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

6. Rear seat

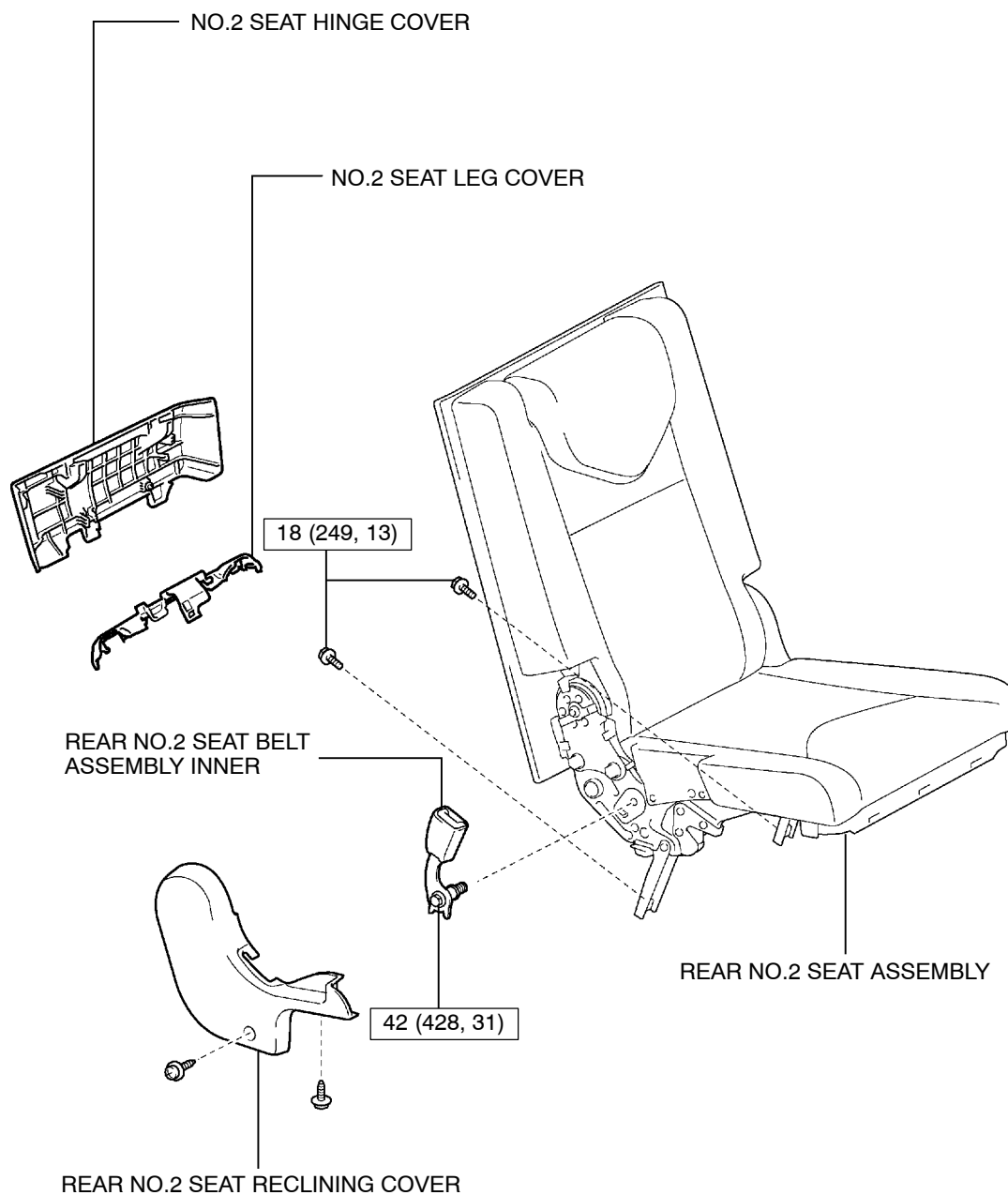


CAUTION:

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

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

w/ Rear No.2 Seat



CAUTION:

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

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

WHEEL ALIGNMENT STANDARD

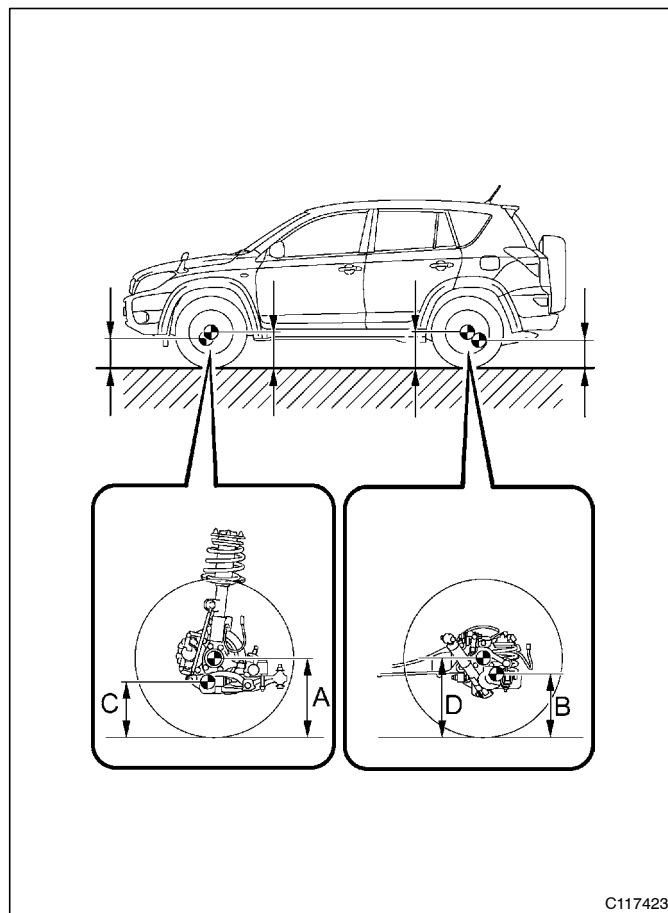
1. FRONT WHEEL ALIGNMENT

Standard vehicle height (unloaded vehicle):

Tire Size	Front C – A	Rear D – B
215/70R16* ¹	89 mm (3.50 in.)	57 mm (2.24 in.)* ² 59 mm (2.32 in.)* ⁴
225/65R17 235/55R18	97 mm (3.82 in.)	67 mm (2.64 in.)* ⁴ 65 mm (2.56 in.)* ³ 54 mm (2.13 in.)* ⁵
Australia	87 mm (3.43 in.)	55 mm (2.17 in.)

HINT:

- *¹: USA, Canada and Europe only
- *²: USA and Canada only
- *³: other
- *⁴: Europe only
- *⁵: w/ 3rd seat.
- If the vehicle height is not as specified, press down on the vehicle several times to stabilize the suspension. Then measure the vehicle height again.



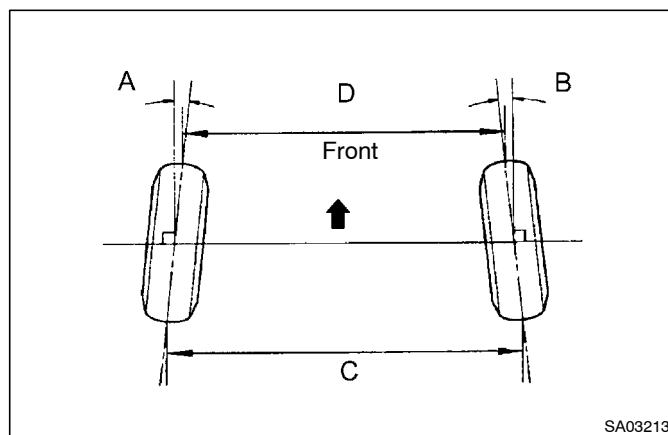
C117423

Standard toe-in (unloaded vehicle):

Tire Size	Front A + B Rear C – D
215/70R16* ¹ 225/65R17 235/55R18	A + B: 0°05' + -10' (0.08° + -0.16°) C – D: 1.0 + -2.0 mm (0.04 + -0.08 in.)

HINT:

- *¹: USA, Canada and Europe only



SA03213

Standard wheel angle (unloaded vehicle):

Tire Size	Inside Wheel Angle	Outside Wheel Angle (Reference)
215/70R16*1	38°55' (36°55' to 40°55') (38.9° (36.9° to 40.9°))	32°20' (32.3°)
225/65R17*2	35°50' (33°55' to 37°55') (35.8° (33.8° to 37.9°))	30°20' (32.3°)
225/65R17*3	38°44' (36°44' to 40°44') (38.7° (36.7° to 40.7°))	32°13' (30.2°)
235/55R18	35°50' (33°55' to 37°55') (35.8° (33.8° to 37.9°))	30°29' (30.5°)
Australia	38°58' (36°58' to 40°58') (39.0° (37.0° to 41.0°))	32°22' (32.4°)

HINT:

- *1: USA, Canada and Europe only
- *2: USA and Canada only
- *3: Europe and other

Standard camber inclination (unloaded vehicle):

Tire Size	Camber Inclination
215/70R16*	-0°08' + -45' (-0.13° + -0.75°)
225/65R17 235/55R18	-0°11' + -45' (-0.18° + -0.75°)
Australia	-0°07' + -45' (-0.12° + -0.75°)

HINT:

- *: USA, Canada and Europe only

Standard caster inclination (unloaded vehicle):

Tire Size	Caster Inclination
215/70R16*1	5°43' + -45' (5.72° + -0.75°)
215/70R16*2	5°41' + -45' (5.68° + -0.75°)
225/65R17*1 235/55R18*1	5°50' + -45' (5.83° + -0.75°)
225/65R17*3 235/55R18*3	5°47' + -45' (5.78° + -0.75°)
225/65R17*4	5°37' + -45' (5.62° + -0.75°)
Australia	5°42' + -45' (5.70° + -0.75°)

HINT:

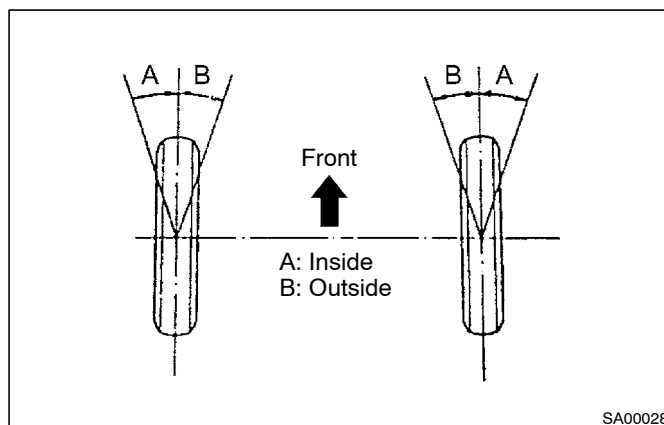
- *1: USA and Canada only
- *2: Europe only
- *3: Except USA and Canada
- *4: w/ 3rd seat

Standard steering axis inclination (unloaded vehicle):

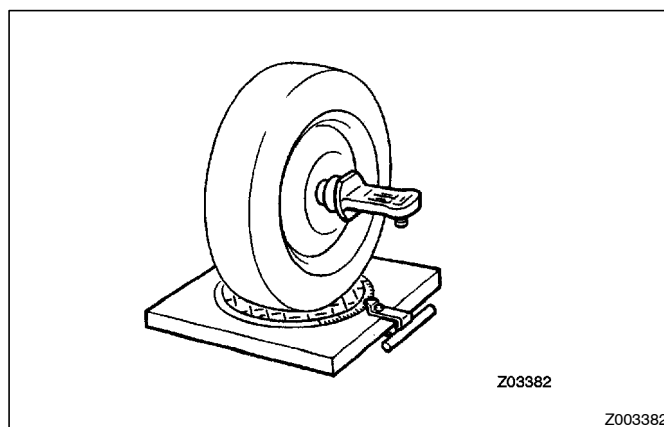
Tire Size	Steering Axis Inclination
215/70R16*1	11°16' + -30' (11.27° + -0.50°)
215/70R16*2	11°16' + -45' (11.27° + -0.75°)
225/65R17*1 235/55R18*1	11°26' + -30' (11.43° + -0.50°)
225/65R17*3 235/55R18*3	11°26' + -45' (11.44° + -0.75°)
225/65R17*4	11°14' + -30' (11.23° + -0.50°)
Australia	11°14' + -45' (11.23° + -0.75°)

HINT:

- *1: USA and Canada only
- *2: Europe only
- *3: Except USA and Canada
- *4: w/ 3rd seat



SA00028



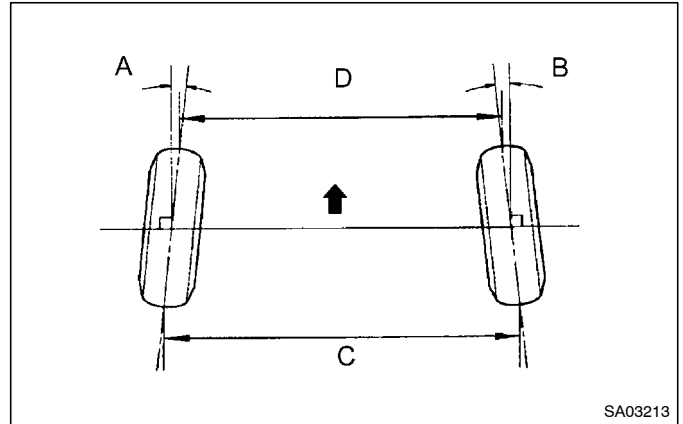
Z03382

Z003382

2. REAR WHEEL ALIGNMENT

Standard toe-in:

Item	Specified Condition
Toe-in (total)	A + B: $0^{\circ}11' + -10'$ ($0.18^{\circ} + -0.17^{\circ}$) C - D: $2.3 + -2$ mm ($0.09 + -0.08$ in.)



Standard camber:

Item	Specified Condition	
Camber Right-left error	Tire Size: 215/70R16*1	$-0^{\circ}55' + -45'$ ($-0.92 + -0.75^{\circ}$) 30' 30' (0.5°) or less
	Tire Size: 215/70R16*2	$0^{\circ}58' + -45'$ ($0.97^{\circ} + -0.75^{\circ}$) 45' (0.75°) or less
	Tire Size: 225/65R17*1 Tire Size: 235/55R18*1	$-1^{\circ}04' + -45'$ ($-1.07 + -0.75^{\circ}$) 30' 30' (0.5°) or less
	Tire Size: 225/65R17*3 Tire Size: 235/55R18*3	$1^{\circ}07' + -45'$ ($-1.12^{\circ} + -0.75^{\circ}$) 45' (0.75°) or less
	Tire Size: 225/65R17*4	$-0^{\circ}52' + -45'$ ($-0.87 + -0.75^{\circ}$) 30' 30' (0.5°) or less
	Australia	$-0^{\circ}52' + -45'$ ($0.87^{\circ} + -0.75^{\circ}$) 45' (0.75°) or less

HINT:

- *1: USA and Canada only
- *2: Europe only
- *3: Except USA and Canada
- *4: w/ 3rd seat

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

HOW TO USE THIS MANUAL

1. BODY PANEL REPLACEMENT THIS MANUAL

BP-36

BODY PANEL REPLACEMENT

SYMBOLS

1

M

: Mig Plug Weld

2

: Body Sealer

: Spot Weld

: Butt Weld

INSTALLATION

3

6

5

8

6

5

23

11

5

5 mm

a - a

Fuel Filler Opening Lid

Rivets

POINT

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

HINT

1) Apply body sealer evenly (about 5 mm (0.20 in.) from the flange, avoiding any pozing.

2) Apply sealer evenly, about 3 - 4 mm (0.12 - 0.16 in.) in diameter.

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

3. After welding, apply body sealer and undercoating to the corresponding parts.

① SYMBOLS

② INSTALLATION DIAGRAM

③ INSTALLATION GUIDE

④ SYMBOLS (See page IN-36)

⑤ INSTALLATION OF WELD POINTS (See page IN-38)

⑥ PART NAME

Describes in detail the installation to the new parts involving repair by welding and/or cutting, but excluding painting.

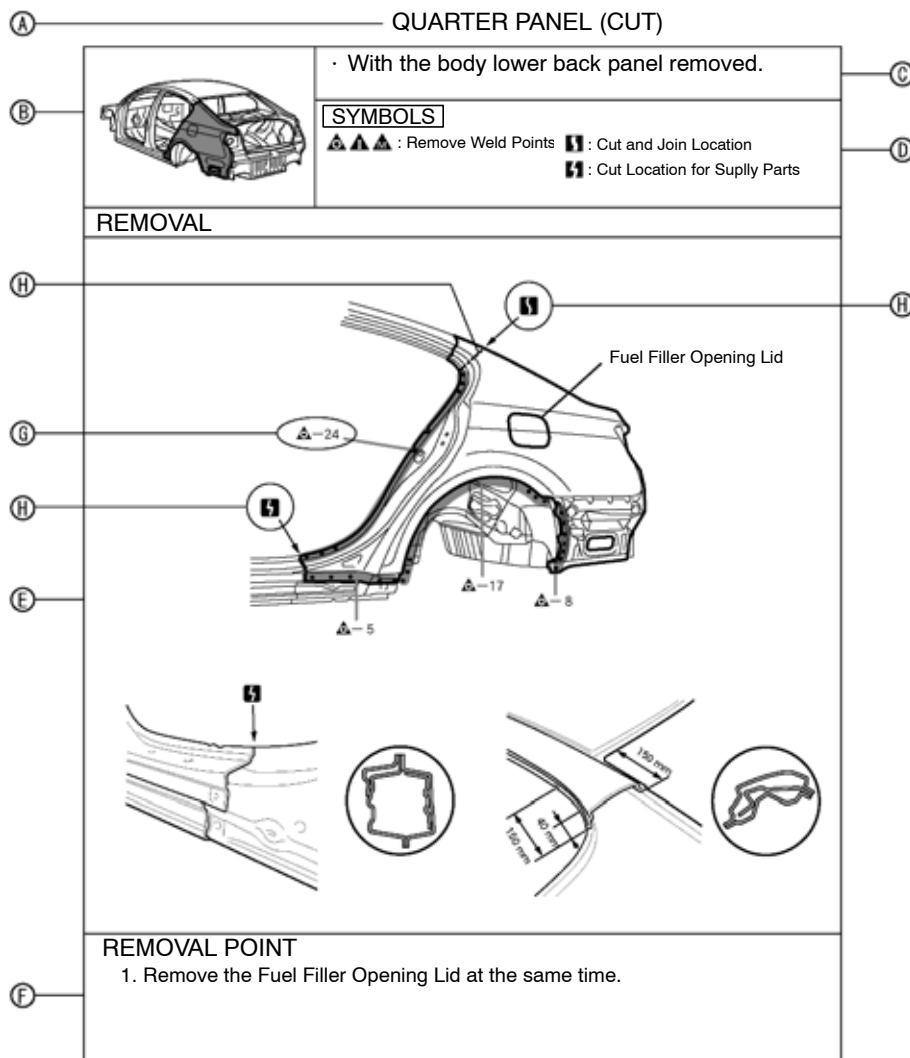
Provides additional information to more efficiently help you perform the installation.

Weld method and panel position symbols

F33026

BODY PANEL REPLACEMENT

BP-34



REPLACEMENT PART AND METHOD
QUARTER PANEL (CUT)

Replacement method
 (ASSY)...Assembly replacement
 (CUT)...Major cutting (less than 1/2 of part used)
 (CUT-H)...Half cutting (about 1/2 of part used)
 (CUT-P)...Partial cutting (most of part used)
 Replacement part

INSTALLATION OF WELD POINTS
 Weld method and panel position
 symbols[[See page \[N-38\]](#)]

SYMBOLS[[See page \[N-36\]](#)]

PART LOCATION

REMOVAL CONDITIONS

SYMBOLS

REMOVAL DIAGRAM

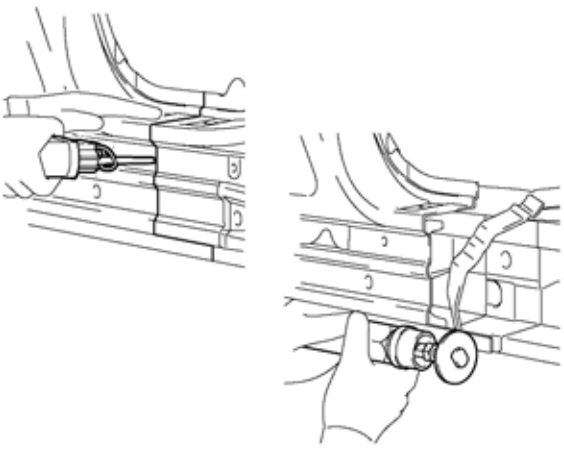
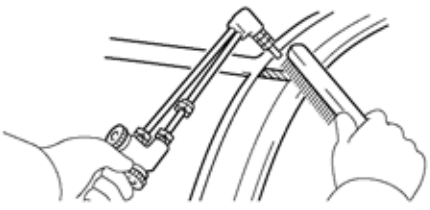
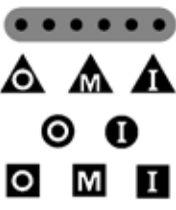
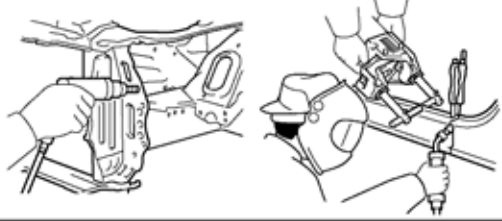
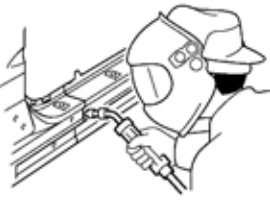
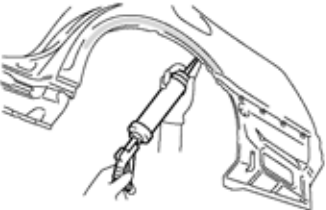
Describes in detail the removal of the damaged part involving repair by cutting.

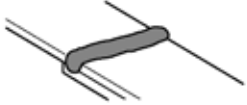
REMOVAL GUIDE

Provides additional information to more efficiently help you perform the removal.

2. SYMBOLS

The following symbols are used in the welding diagrams in section BP of this manual to indicate cutting areas and the types of weld required.

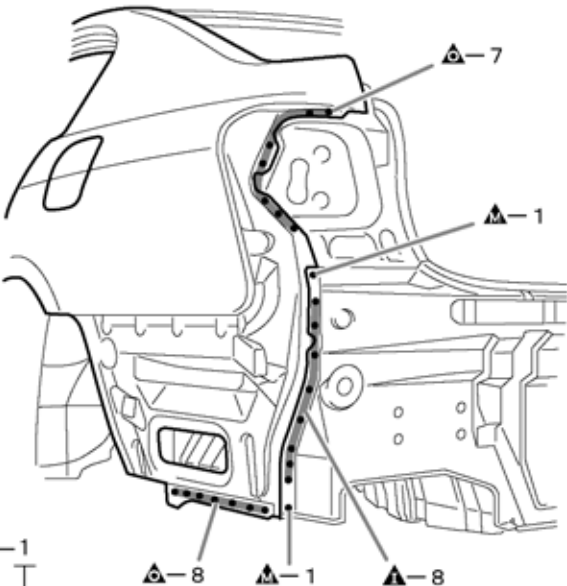
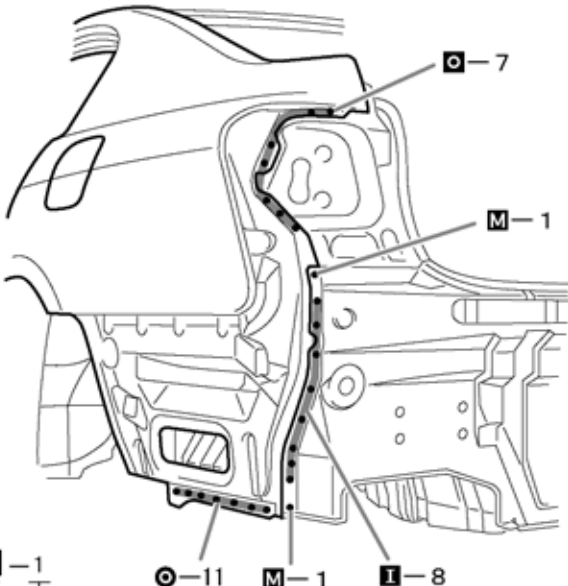
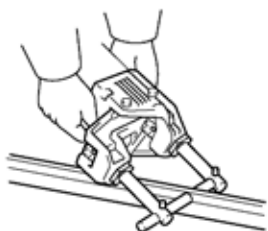
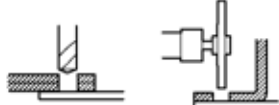
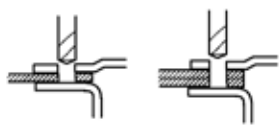
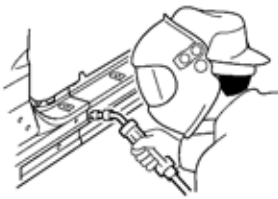
SYMBOLS	MEANING	SYMBOLS	MEANING	ILLUSTRATION
-----	CUT		CUT AND JOIN LOCATION (Saw Cut)	
			CUT AND JOIN LOCATION (Cut Location for Supply Parts)	
			CUT LOCATION	
			CUT WITH DISC SANDER ETC.	
////	BRAZE		BRAZE (Removal)	
oooo	BRAZE		BRAZE (Installation)	
	WELD POINTS	—	SPOT WELD OR MIG PLUG WELD	
+++	WELDING	 	CONTINUOUS MIG WELD (BUTT WELD) CONTINUOUS MIG WELD (TACK WELD)	
	SEALER		BODY SEALER	

SYMBOLS	MEANING	SYMBOLS	MEANING	ILLUSTRATION
—			Assembly Mark	—
	—	—	BODY SEALER (Flat Finishing)	 
	—		BODY SEALER (Flat Finishing)	 

F33005

3. ILLUSTRATION OF WELD POINT SYMBOLS

EXAMPLE:

REMOVAL			INSTALLATION		
 Weld points Remove weld point and panel position			 Weld points Remove weld point and panel position		
SYMBOLS	MEANING	ILLUSTRATION	SYMBOLS	MEANING	ILLUSTRATION
▲	Remove Weld Points		●	Spot Weld	
○	(Outside)		■	MIG Plug Weld	
M	(Middle)				
I	(Inside)		+	Spot MIG Weld	

ABBREVIATIONS USED IN THIS MANUAL

For convenience, the following abbreviations are used in this manual.

ABS	Antilock Brake System
A/C	Air Conditioner
assy	assembly
ECT	Electronic Controlled Transmission
ECU	Electronic Control Unit
e.g.	Exempli Gratia (for Example)
Ex.	Except
FWD	Front Wheel Drive Vehicles
2WD	Two Wheel Drive Vehicles
4WD	Four Wheel Drive Vehicles
in.	inch
LH	Left-hand
LHD	Left-hand Drive
MIG	Metal Inert Gas
M/Y	Model Year
PPS	Progressive Power Steering
RH	Right-hand
RHD	Right-hand Drive
SRS	Supplemental Restraint System
SSM	Special Service Materials
w/	with
w/o	without

BODY PANEL SEALING AREAS

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

HINT:

- 1) Apply degreasing agent to a clean cloth and clean the sealer application areas.
- 2) After removing the applied spot sealer from the sealer application areas using thinner or equivalent, rustproof the areas by applying primer or equivalent. Then apply body sealer.
- 3) If sealer is applied to an area that is not specified, apply degreasing agent to a clean cloth and clean off the sealer immediately.



Flat Finishing



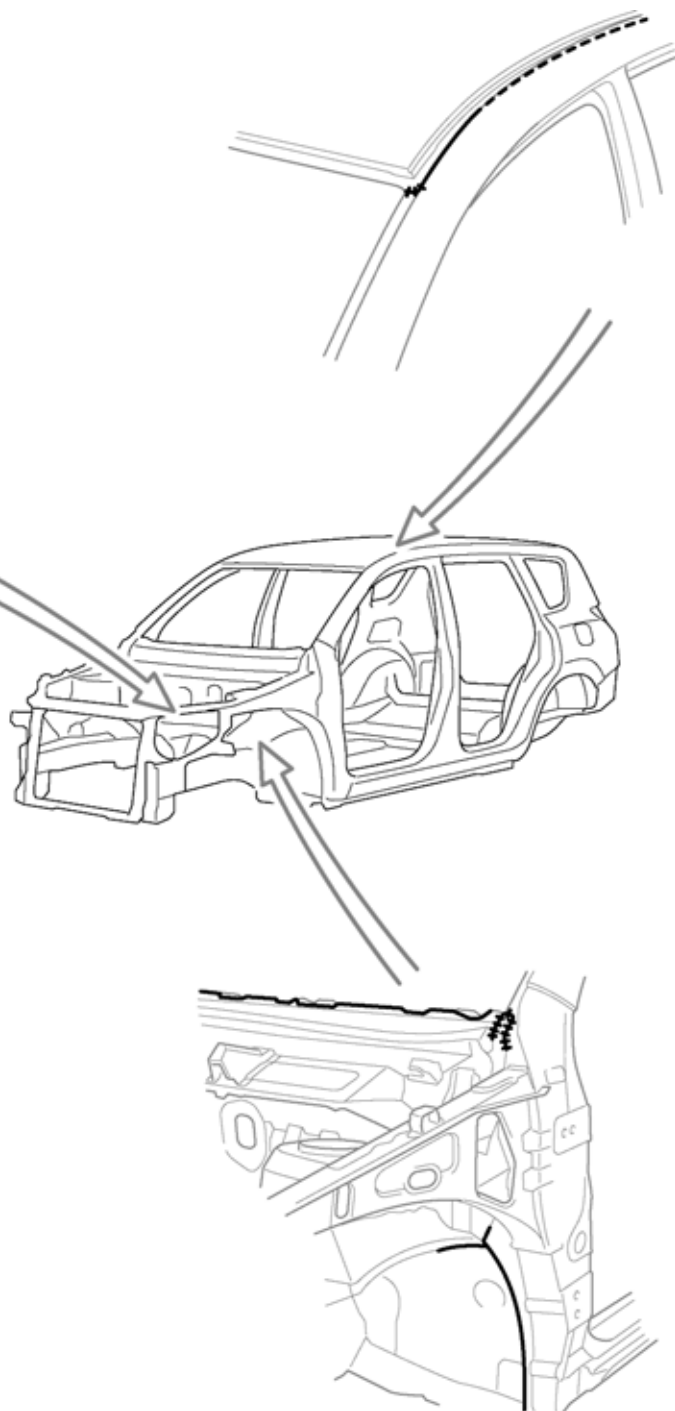
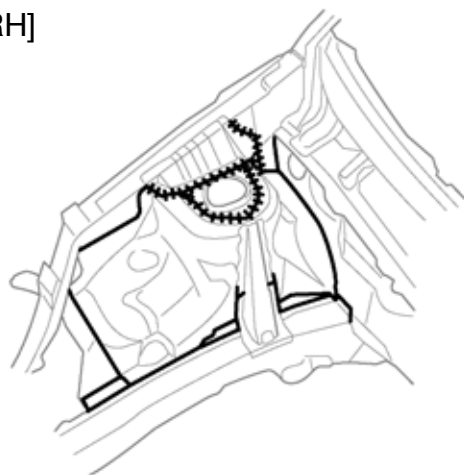
No Flat Finishing

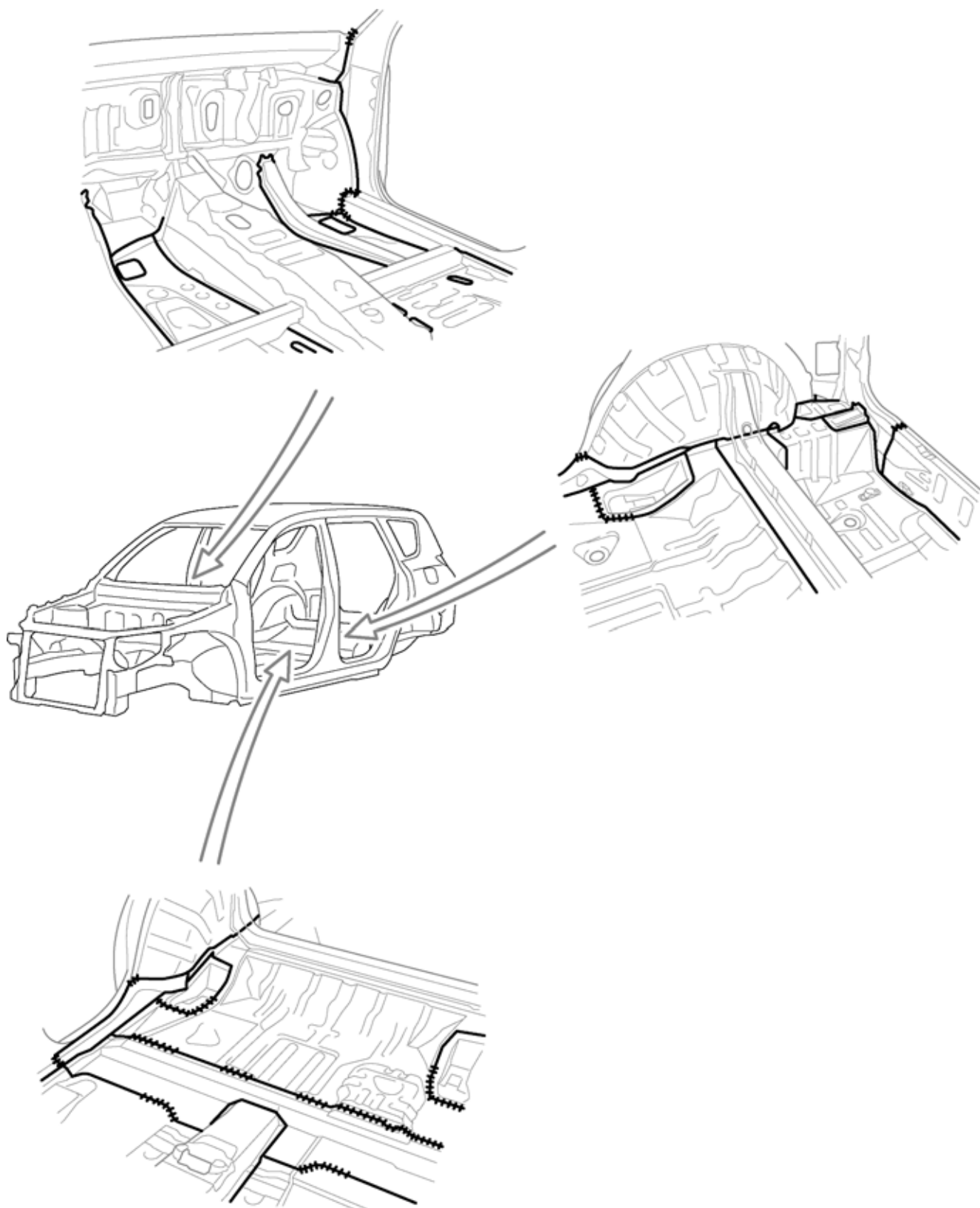
1. ENGINE COMPARTMENT

[LH]

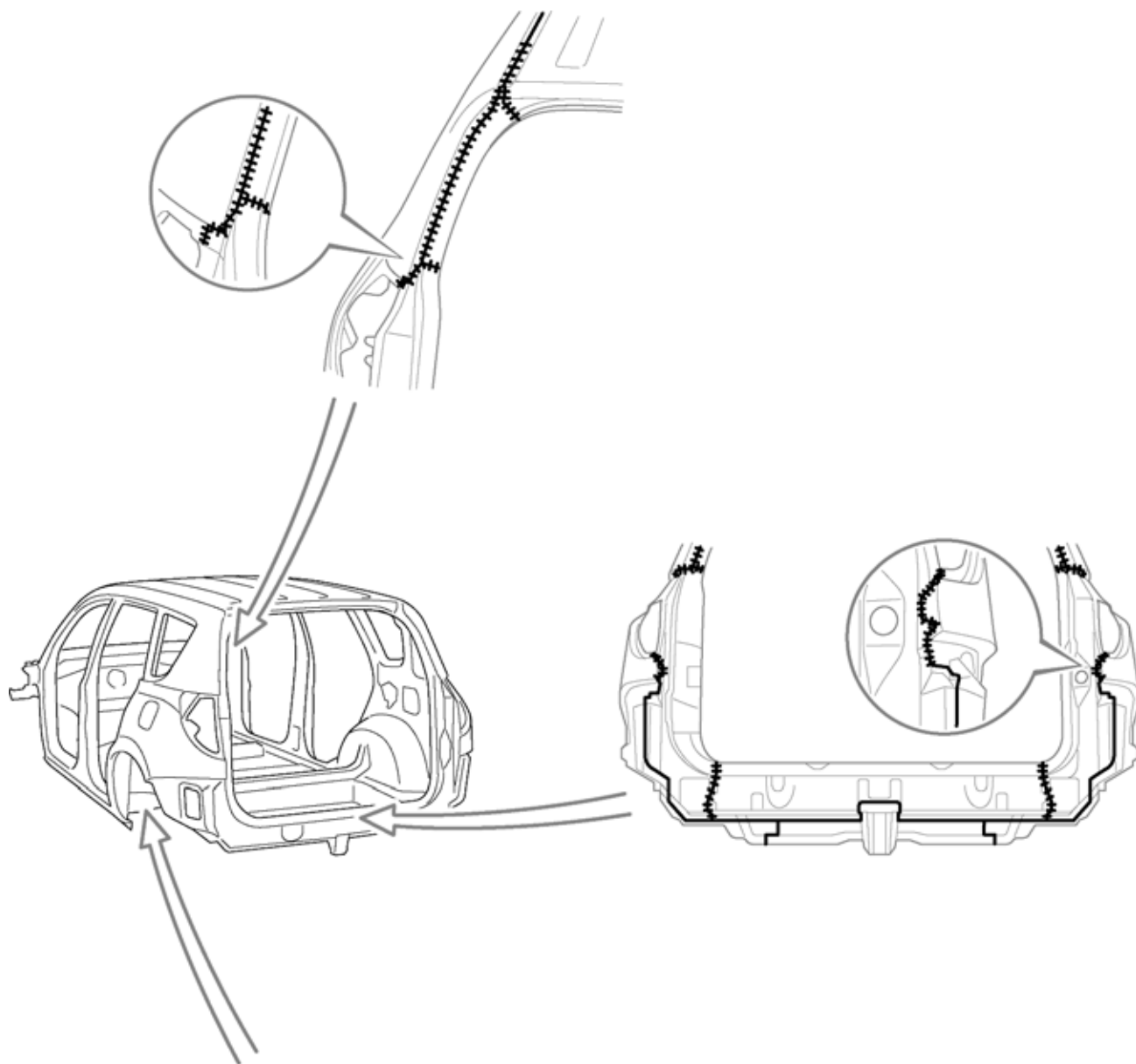


[RH]

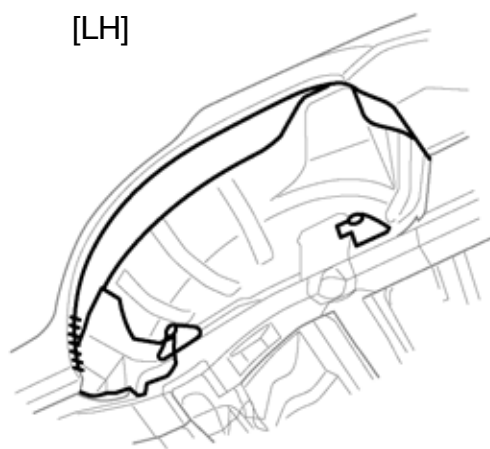


2. INSIDE

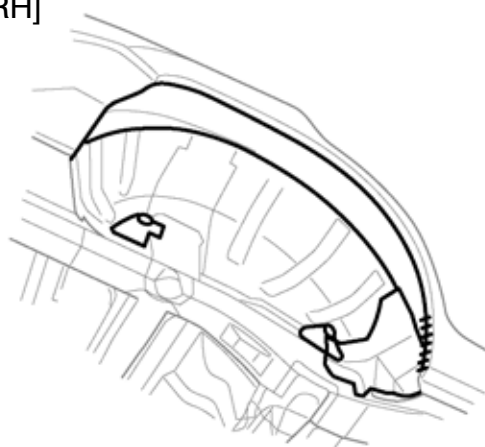
3. OUTSIDE



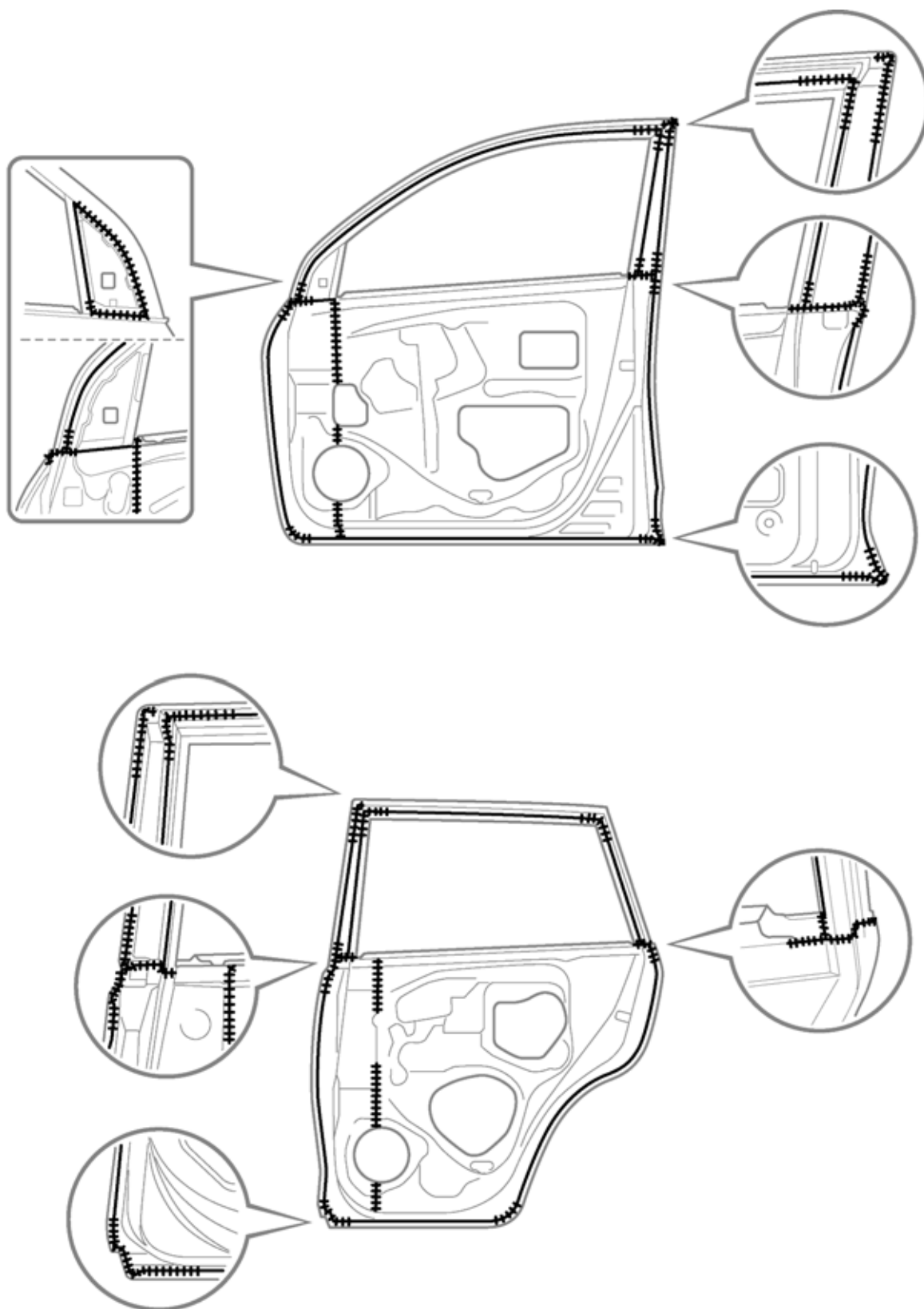
[LH]

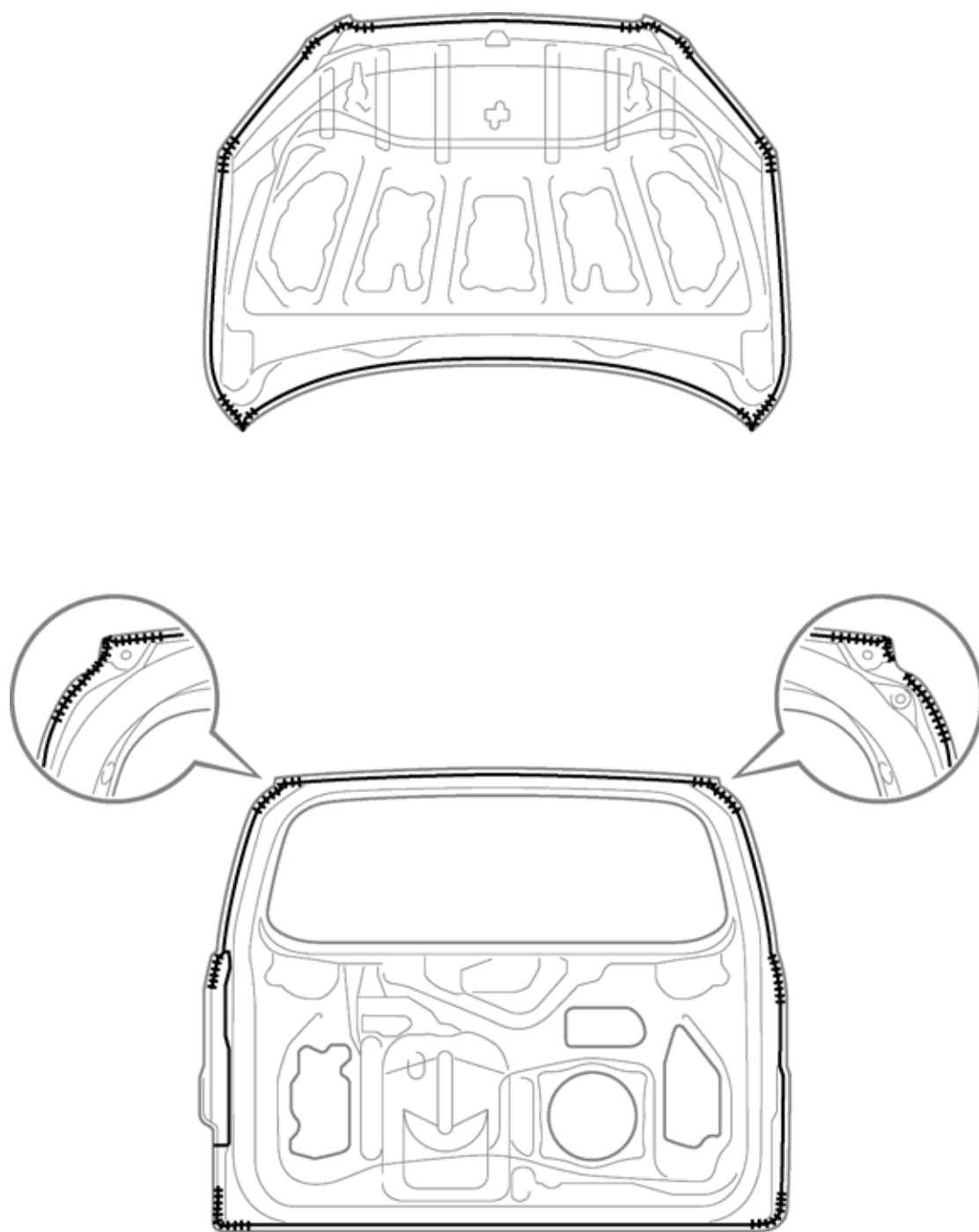


[RH]



4. DOOR PARTS





BODY PANEL UNDERCOATING AREAS

Apply PASTAR UWE or PASTAR UC to the chassis, floor underside, sheet metal fitting weld points of the body, and inside of the wheel housing to prevent rust and noise, as well protect the body from flying rocks.

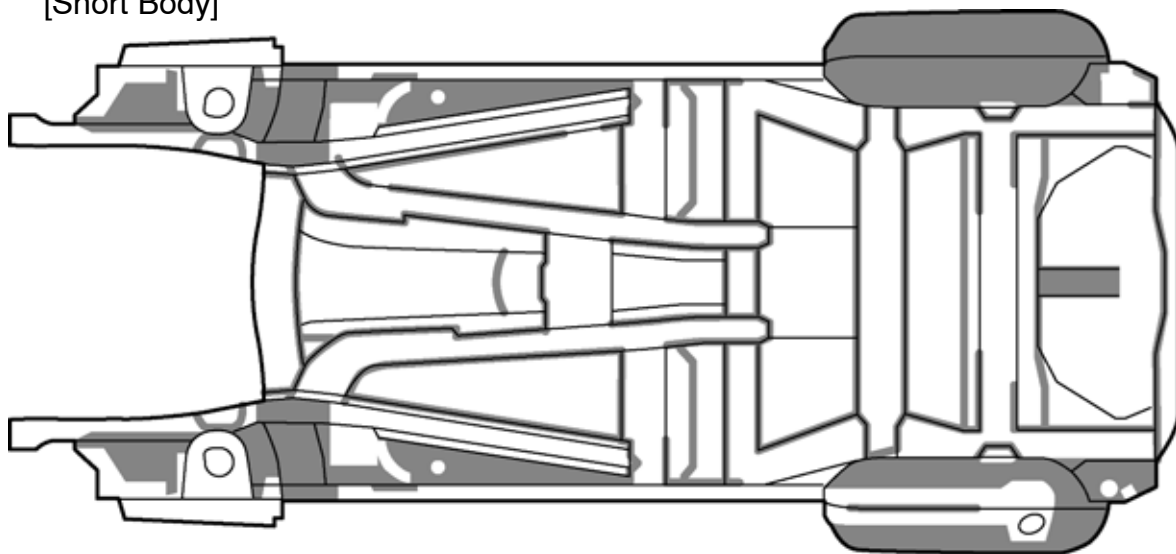
CAUTION:

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

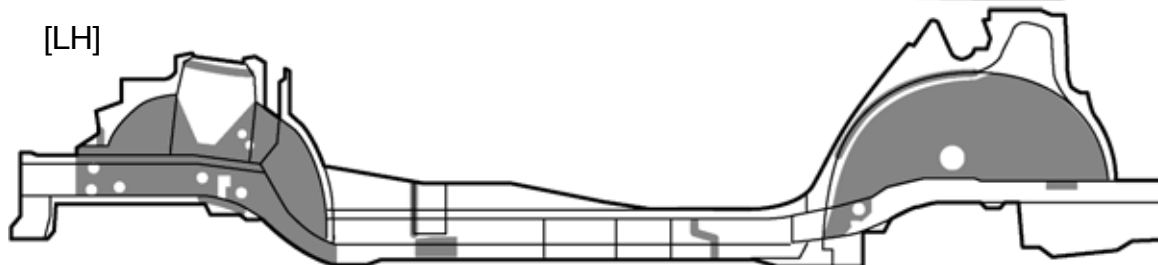
HINT:

- 1) *Parts coated using the PASTAR UWE should be left until dry to the touch in a 25°C environment for 60 to 75 minutes. Parts coated using PASTAR UC should be left until dry to the touch in a 25°C environment for 15 to 30 minutes.*
- 2) *If using a PASTAR gun, one spray applies a 0.5 mm thick coating.*
- 3) *PASTAR UWE: Part number V9240-0025*
PASTAR UC: Spray type: Part number V9240-0008
Aerosol type: Part number V9240-0021

[Short Body]



[LH]



[RH]

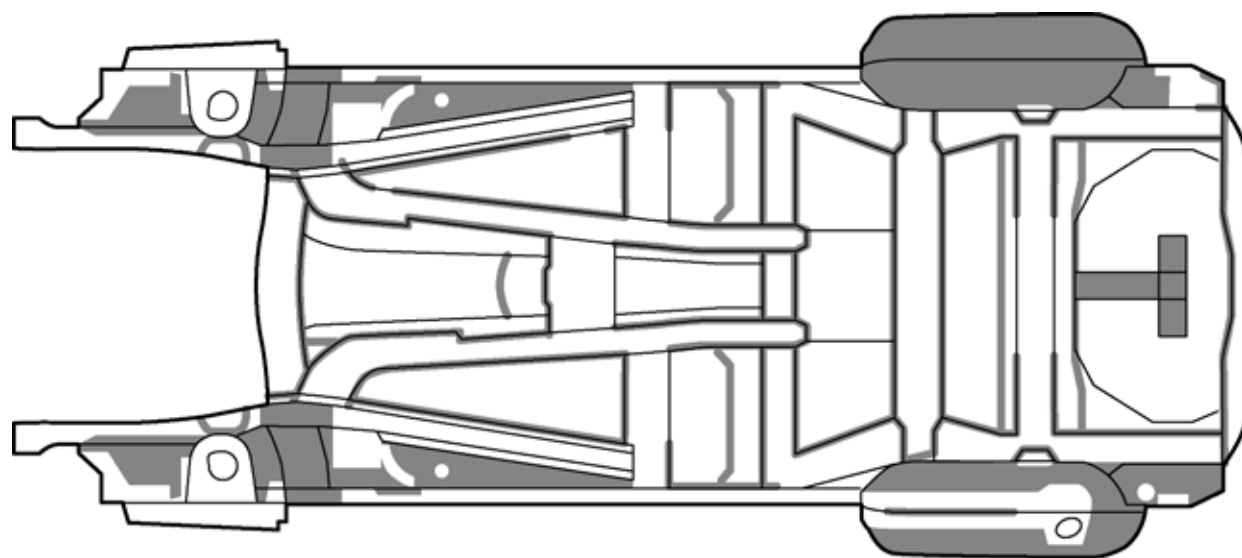


F24750

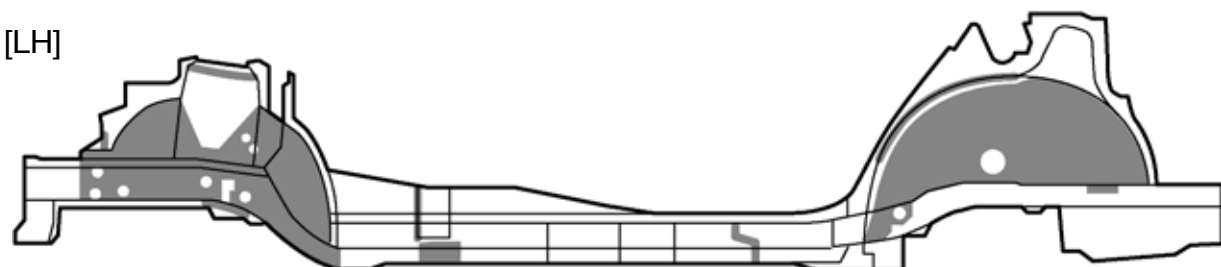
REFERENCE

The undercoating should be applied according to the specifications for your country while referring to the notes above.

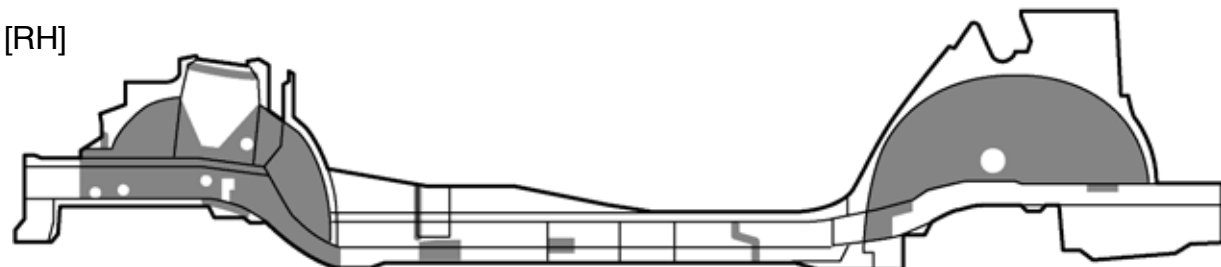
[Long Body]



[LH]



[RH]



F24751

REFERENCE

The undercoating should be applied according to the specifications for your country while referring to the notes above.

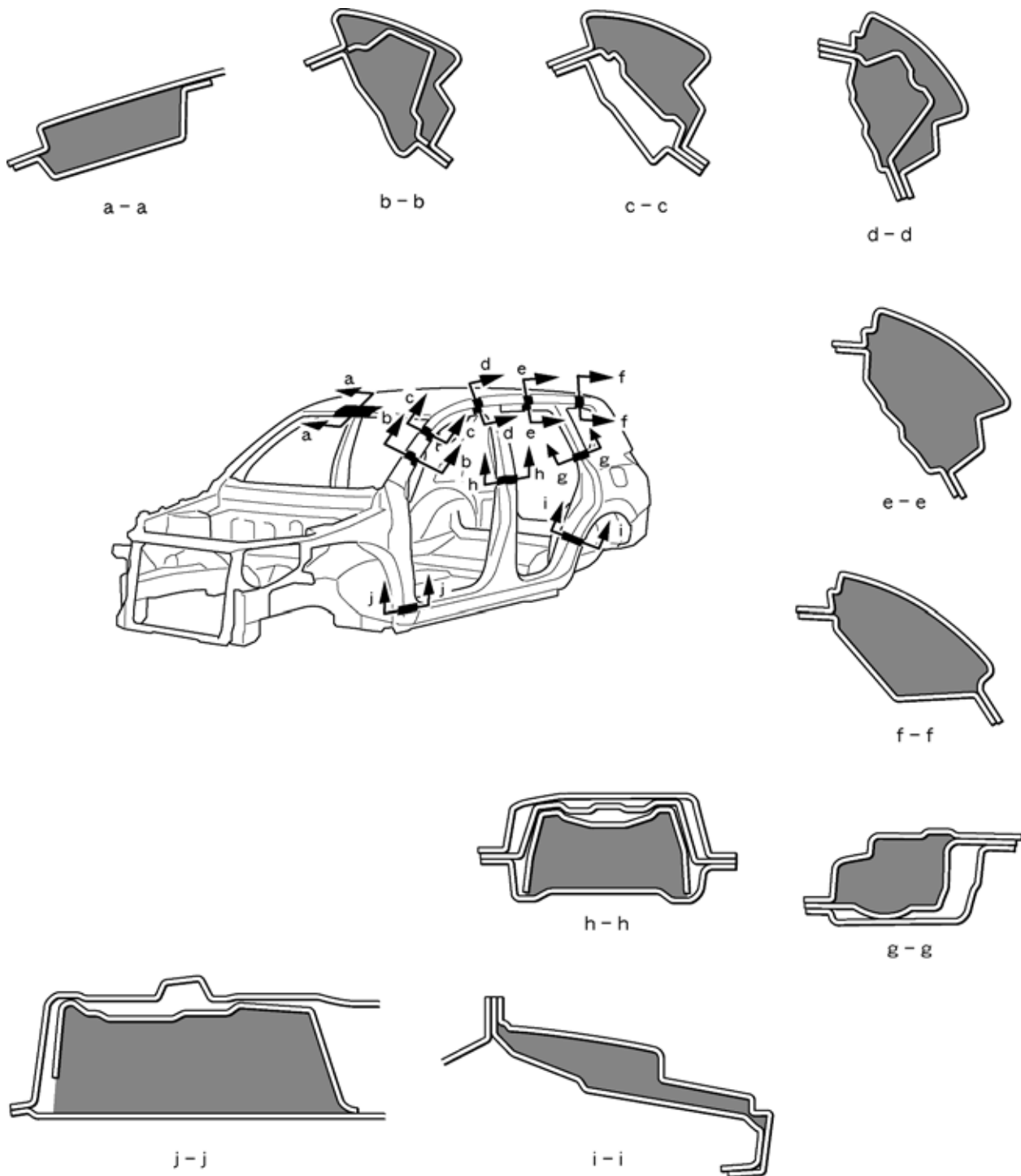
FOAMED MATERIAL APPLICATION AREAS

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

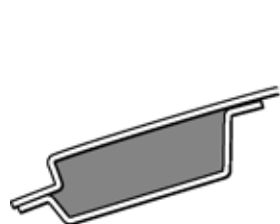
CAUTION:

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

[Short Body]



[Long Body]



a - a



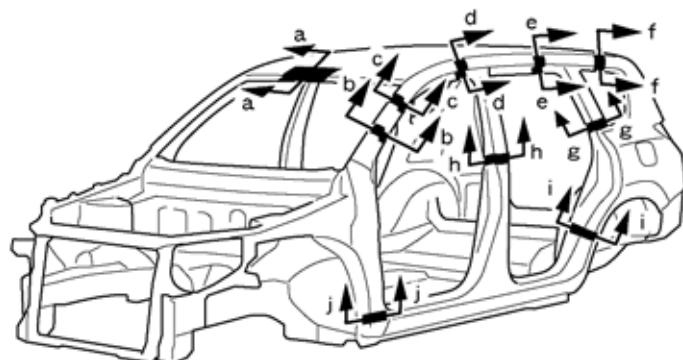
b - b



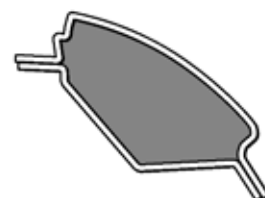
c - c



d - d



e - e



f - f



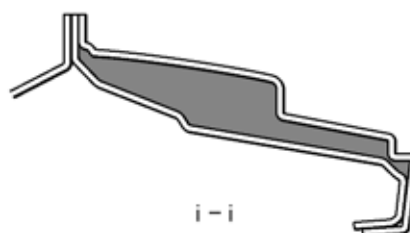
h - h



g - g



j - j



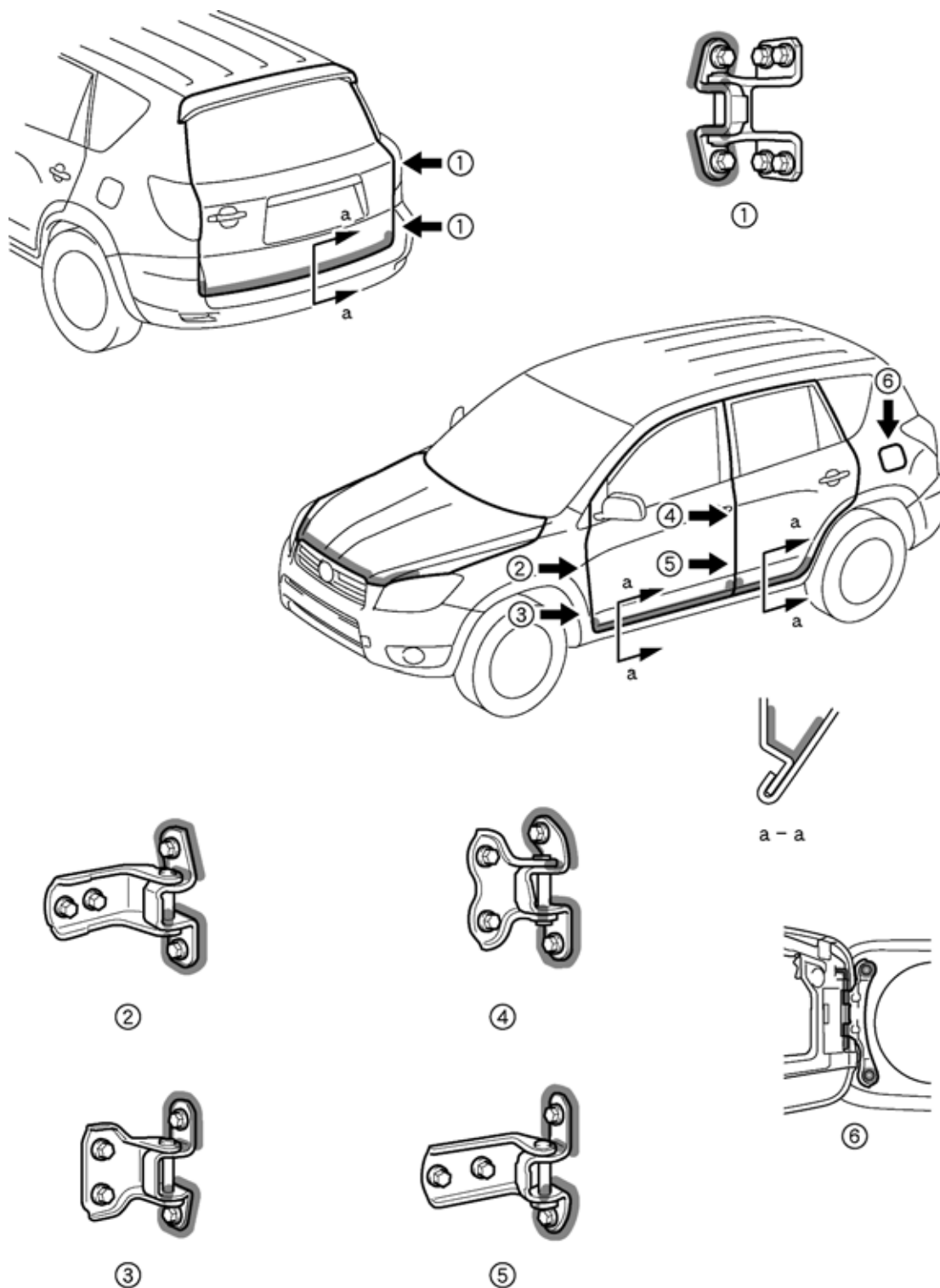
i - i

BODY PANEL ANTI-RUST AGENT (WAX) APPLICATION AREAS

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

HINT:

- 1) If RUSTOP is applied to an area that is not specified, apply degreasing agent to a clean cloth and clean off the RUSTOP immediately.



SILENCER SHEET INSTALLATION AREAS

Substitute silencer sheets for the laminate coat application areas.

[Short Body]

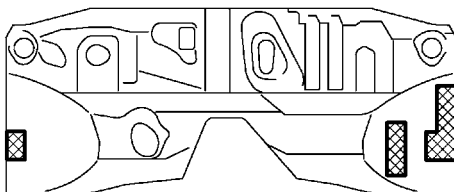
Thickness of Silencer Sheet mm (in.)

 2.0 (0.079)

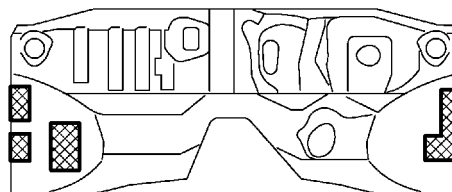
 4.0 (0.157)



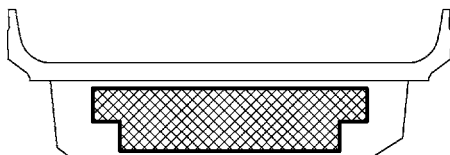
[LHD]



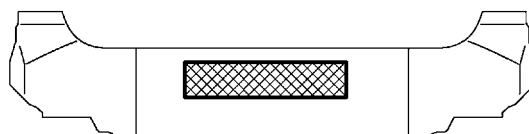
[RHD]



[FRONT]



[REAR]

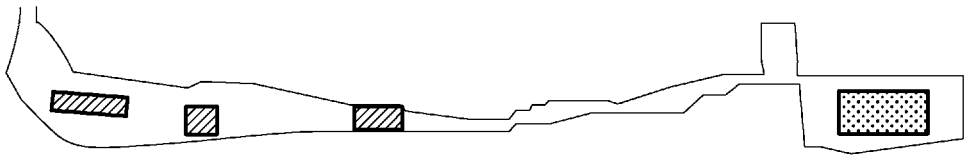
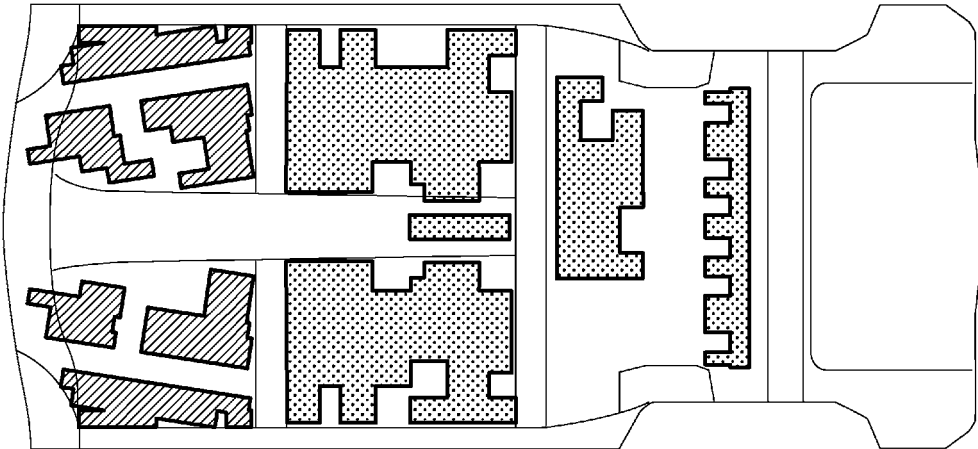


Substitute silencer sheets for the laminate coat application areas.

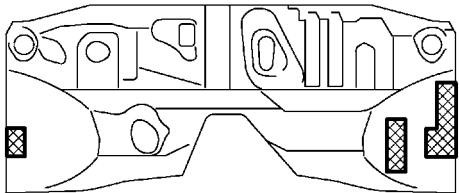
[Long Body w/o Rear No. 2 Seat]

Thickness of Silencer Sheet mm (in.)

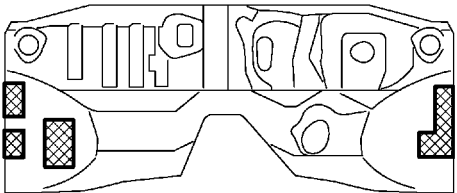
-  1.5 (0.059)
-  2.0 (0.079)
-  3.0 (0.118)



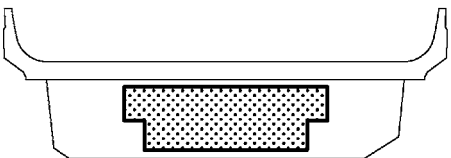
[LHD]



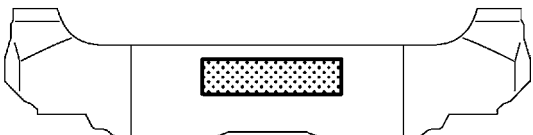
[RHD]



[FRONT]



[REAR]

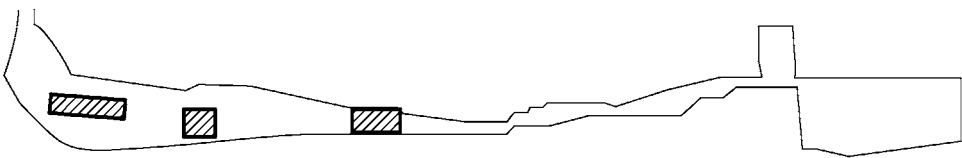
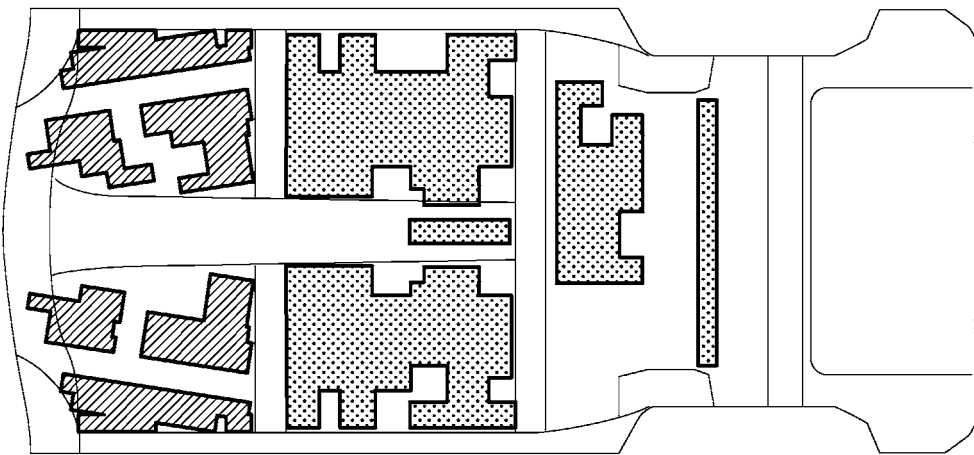


Substitute silencer sheets for the laminate coat application areas.

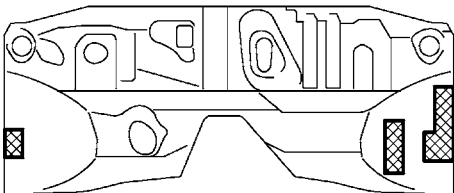
[Long Body w/ Rear No. 2 Seat]

Thickness of Silencer Sheet mm (in.)

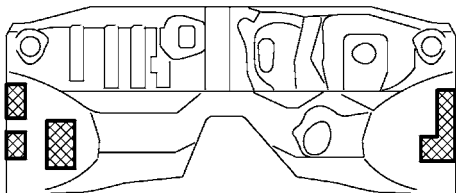
-  1.5 (0.059)
-  2.0 (0.079)
-  3.0 (0.118)



[LHD]



[RHD]



BODY PANEL ANTI-CHIPPING PAINT APPLICATION AREAS

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

CAUTION:

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

