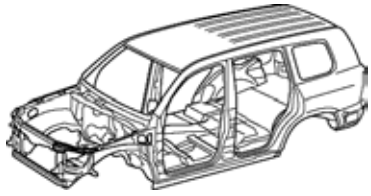
RADIATOR UPPER SUPPORT (ASSY)



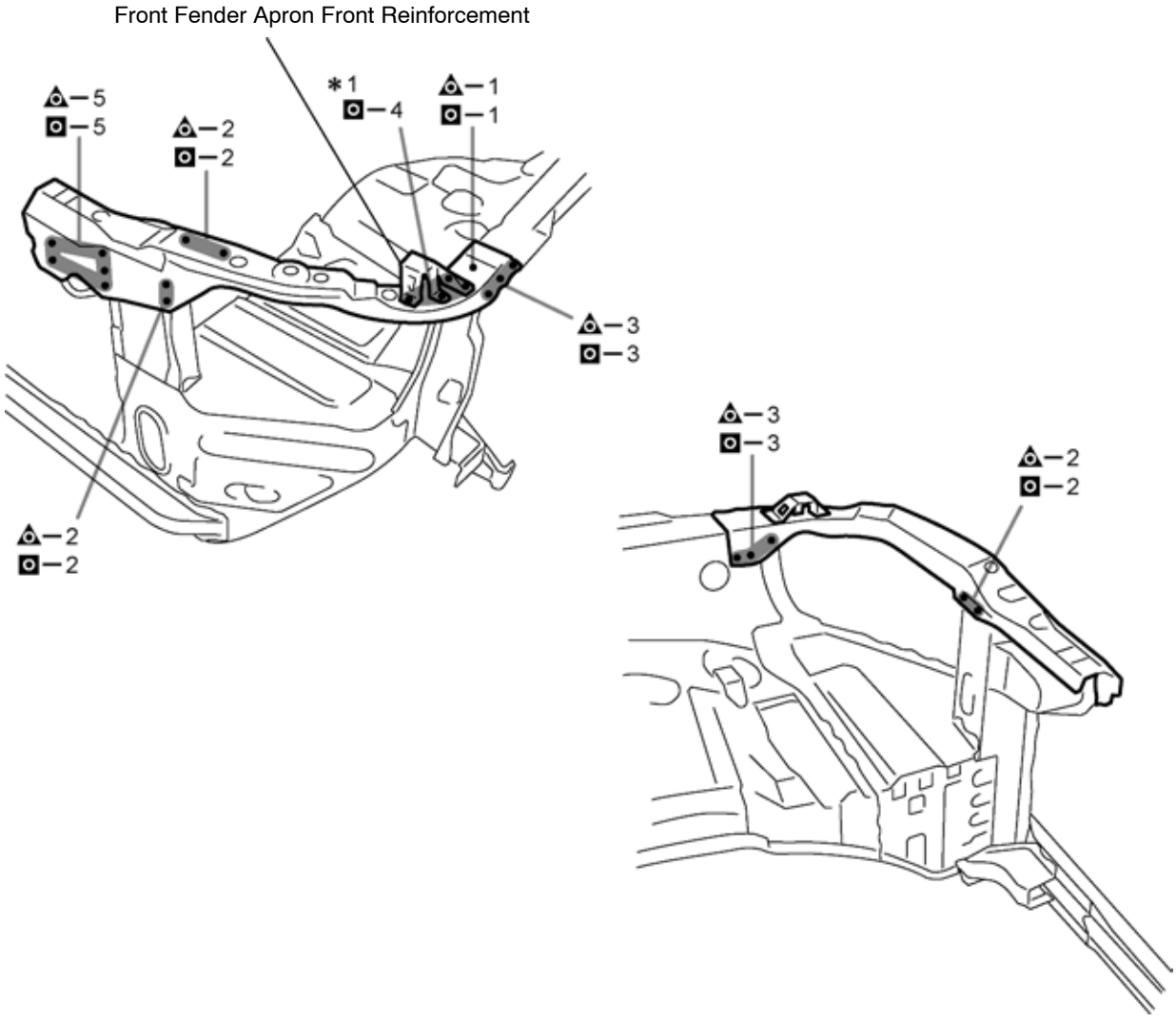
F29201A

Symbol meaning

REMOVAL	: Remove Weld Points
INSTALLATION	: Plug Weld

F29201B

REMOVAL·INSTALLATION

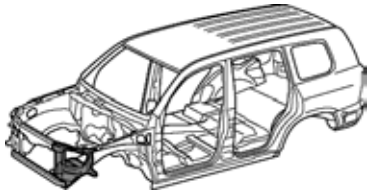


F29201

INSTALLATION POINT

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

RADIATOR SIDE SUPPORT (ASSY)



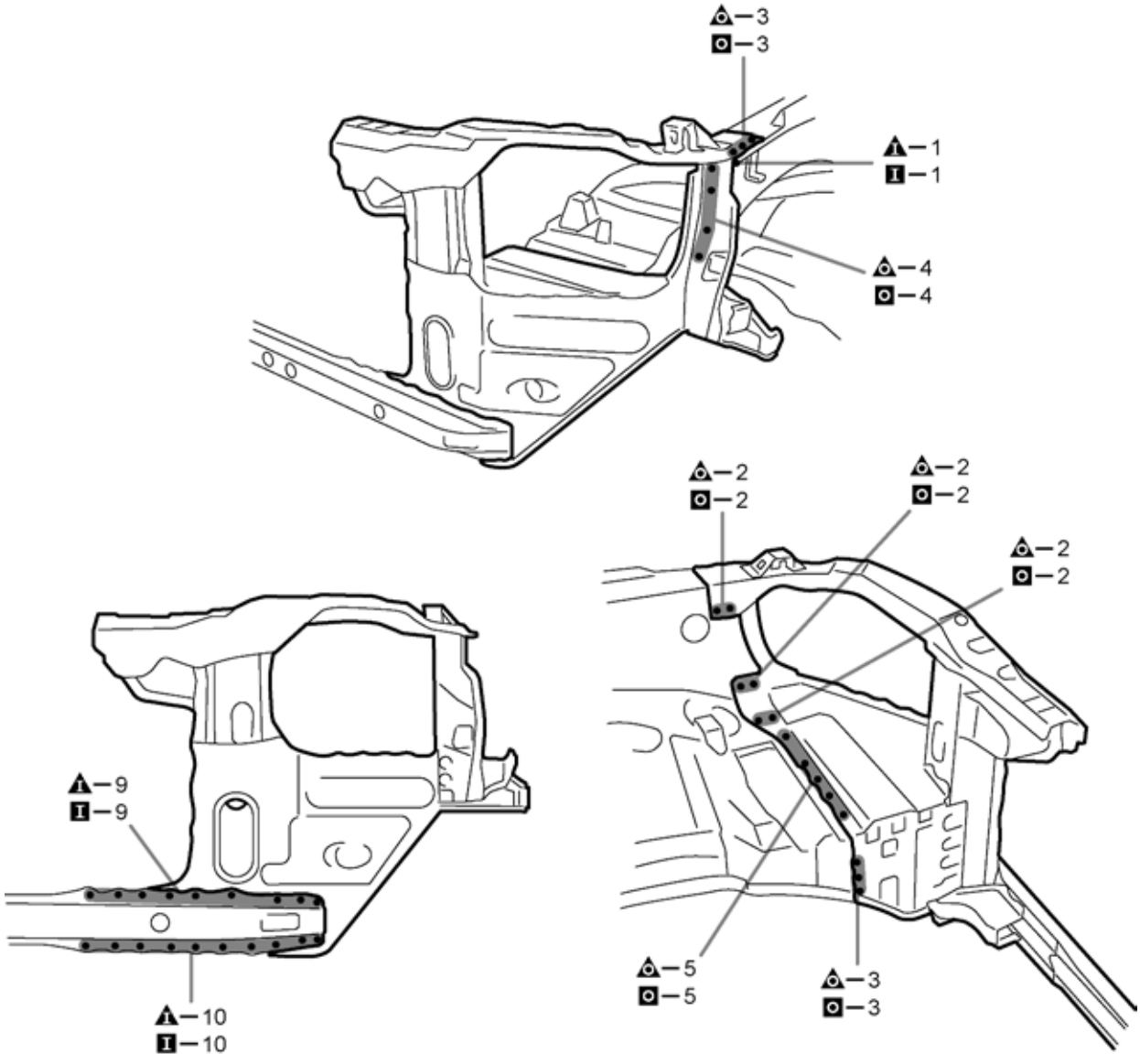
F29202A

Symbol meaning

REMOVAL	▲ ▲ : Remove Weld Points
INSTALLATION	● ■ : Plug Weld

F29202B

REMOVAL·INSTALLATION

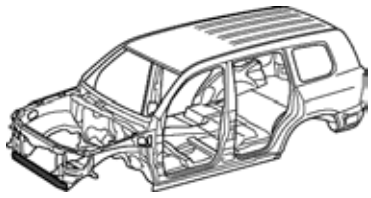


F29202

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.

FRONT CROSSMEMBER (ASSY)



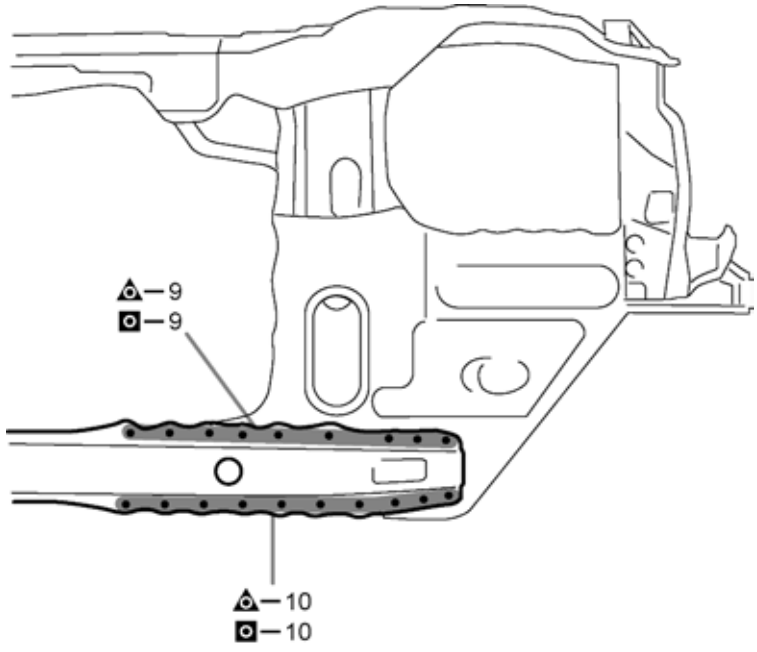
F29203A

Symbol meaning

REMOVAL	: Remove Weld Points
INSTALLATION	: Plug Weld

F29203B

REMOVAL·INSTALLATION



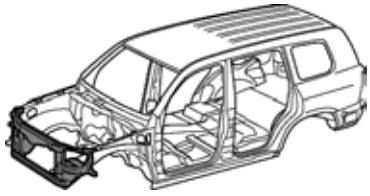
F29203

INSTALLATION POINT

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

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

RADIATOR SUPPORT (ASSY)



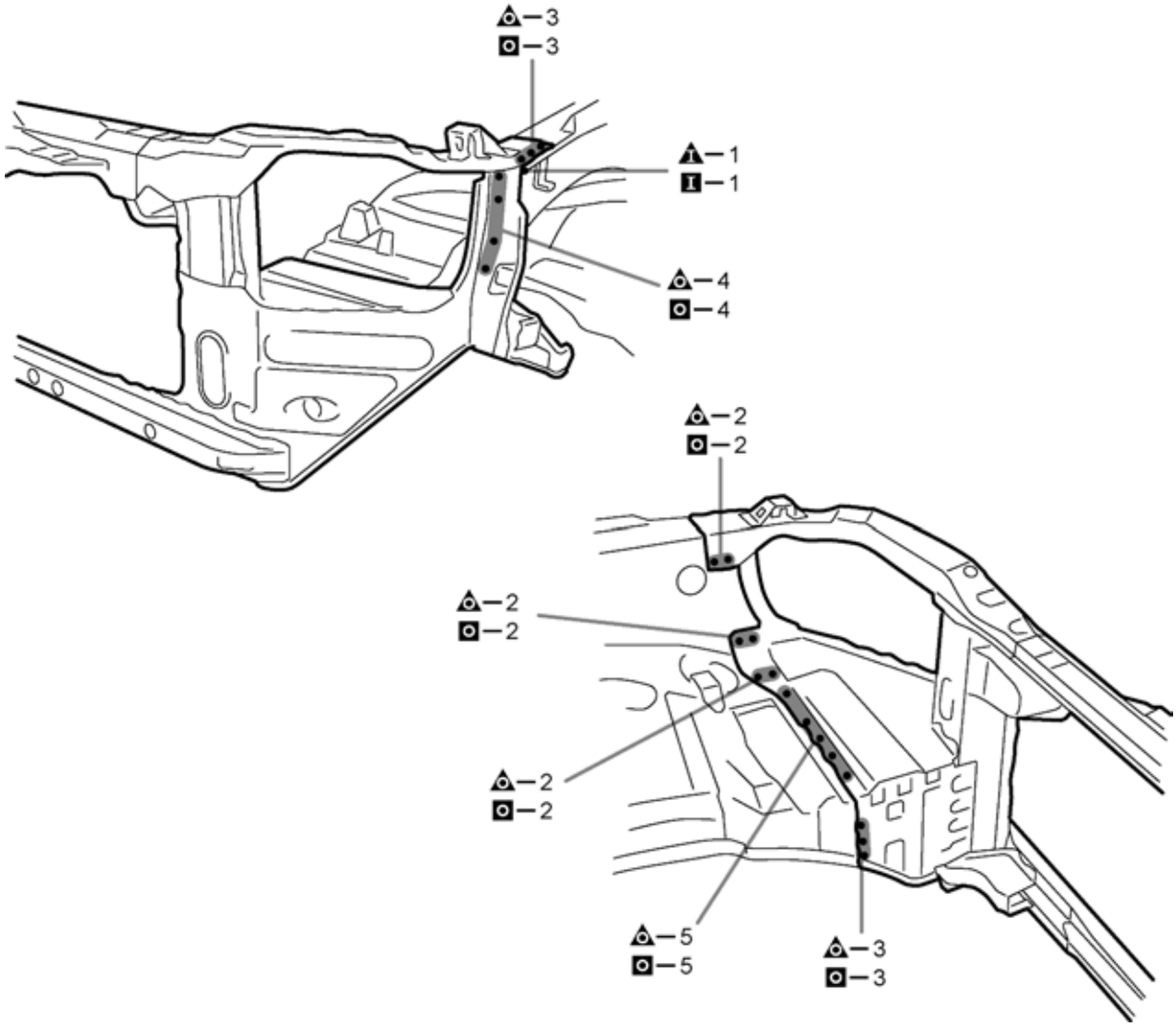
F29204A

Symbol meaning

REMOVAL	: Remove Weld Points
INSTALLATION	: Plug Weld

F29204B

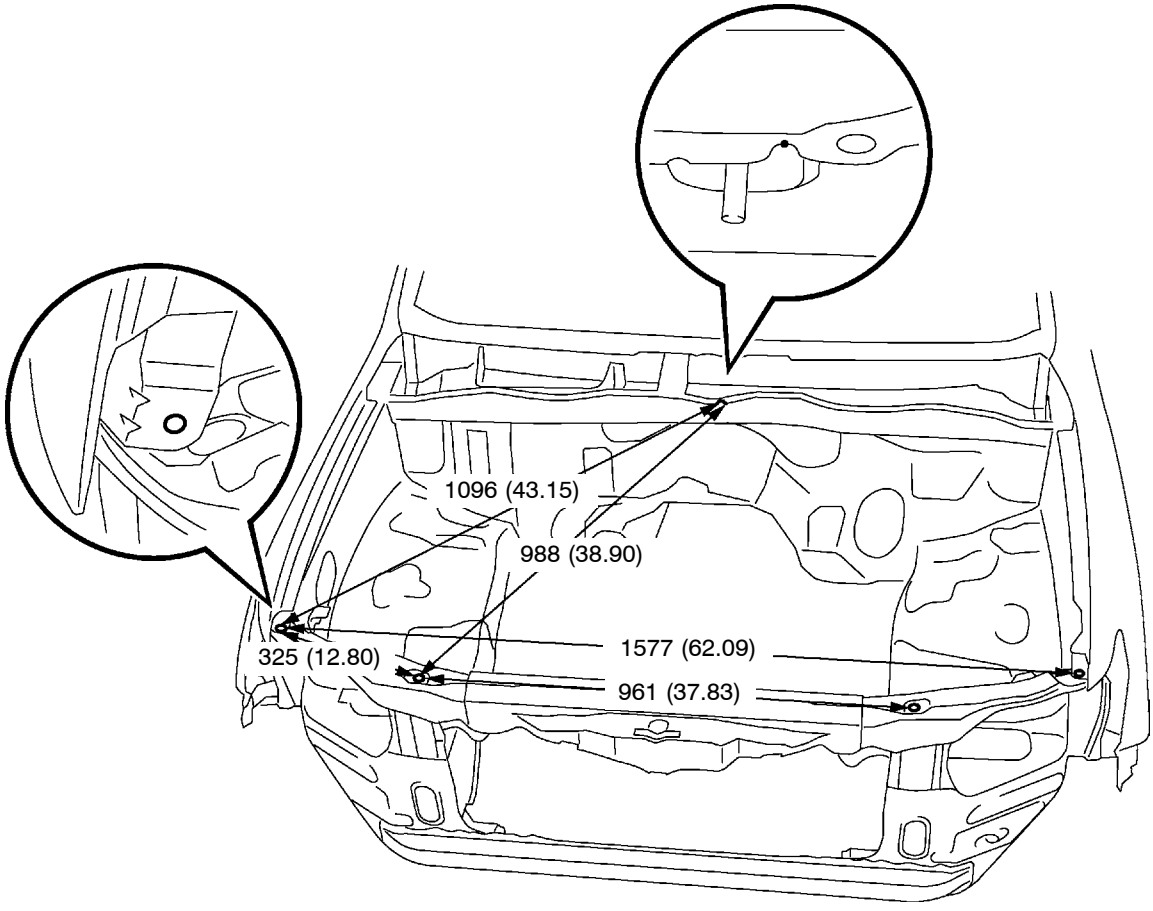
REMOVAL·INSTALLATION



F29204

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.



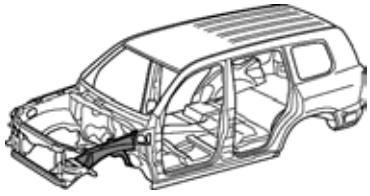
mm (in.)

F29205

INSTALLATION POINT

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

FRONT FENDER APRON (ASSY)



F29206A

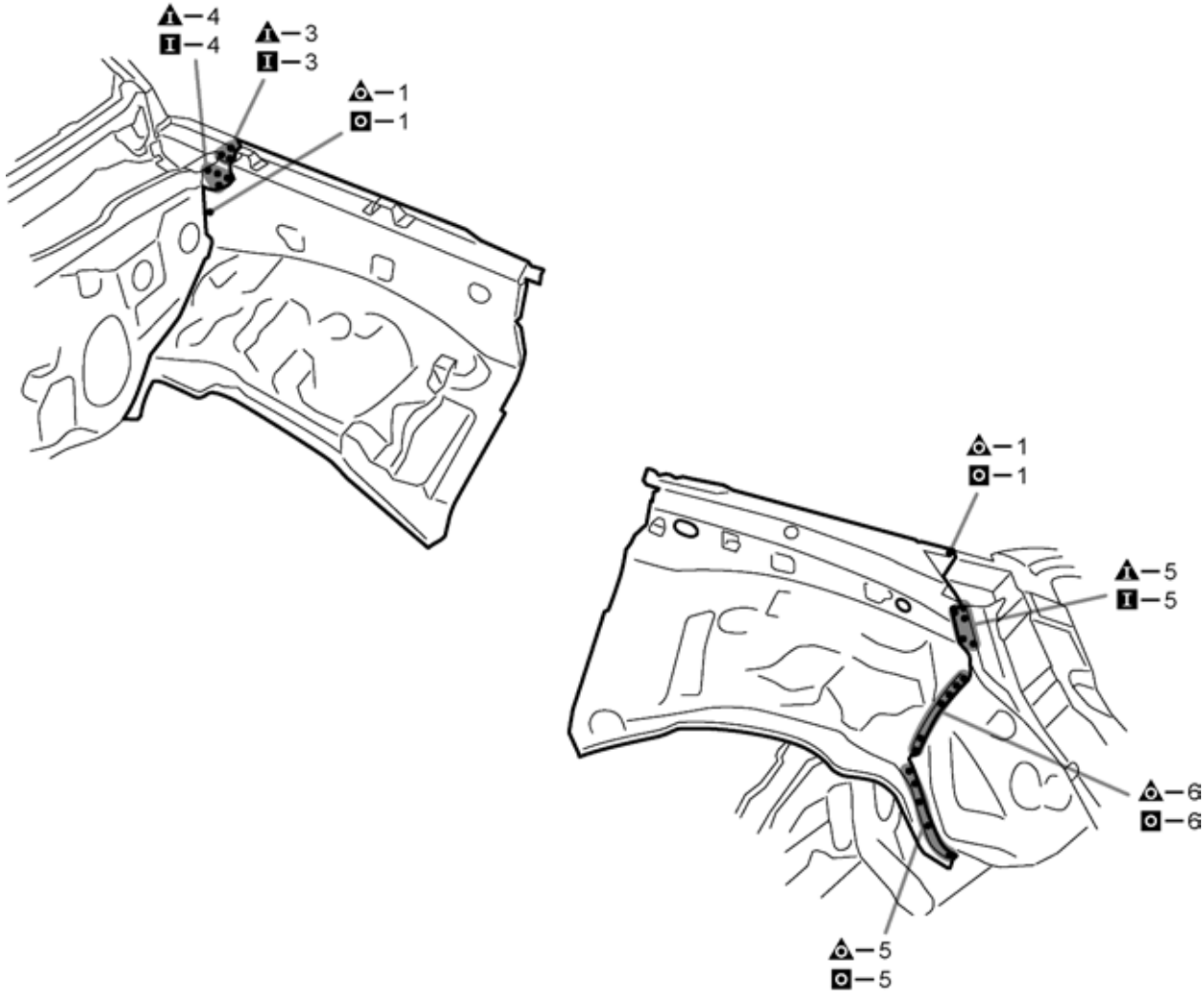
With the radiator side support and cowl top side panel removed.

Symbol meaning

REMOVAL	A A : Remove Weld Points
INSTALLATION	O I : Plug Weld

F29206B

REMOVAL·INSTALLATION

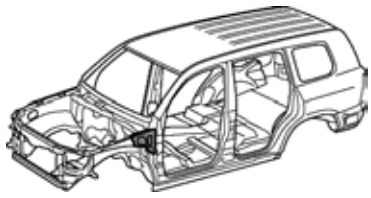


F29206

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.

COWL TOP SIDE PANEL (ASSY)



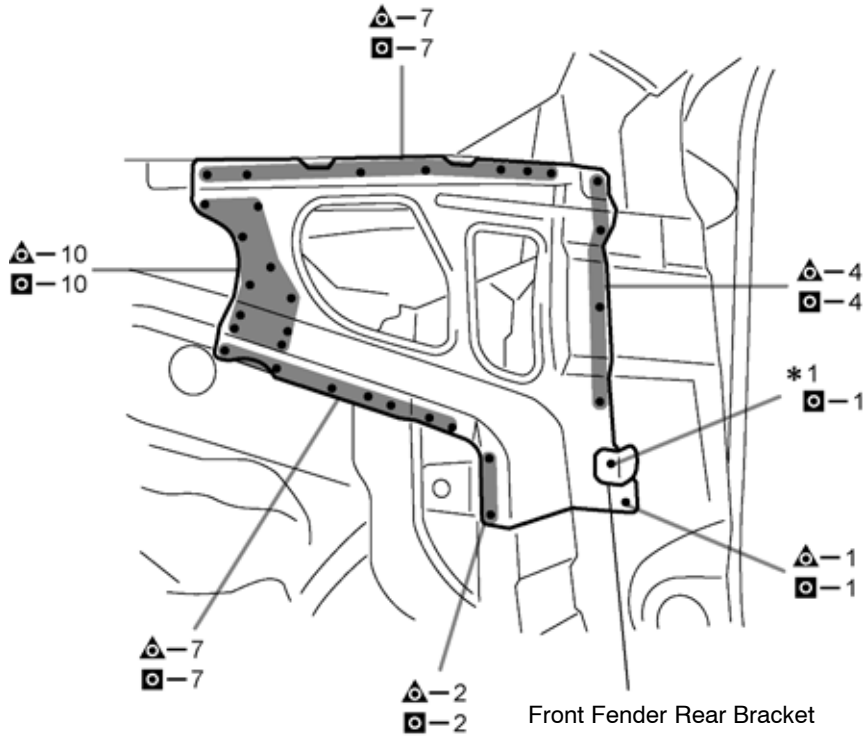
F29207A

Symbol meaning

REMOVAL	: Remove Weld Points
INSTALLATION	: Plug Weld

F29207B

REMOVAL·INSTALLATION

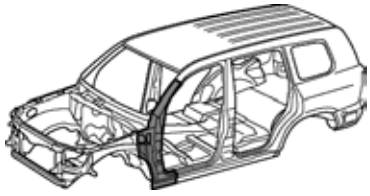


F29207

INSTALLATION POINT

1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
2 *1 is only for installation.
3 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)



F29208A

With the cowl top side panel removed.

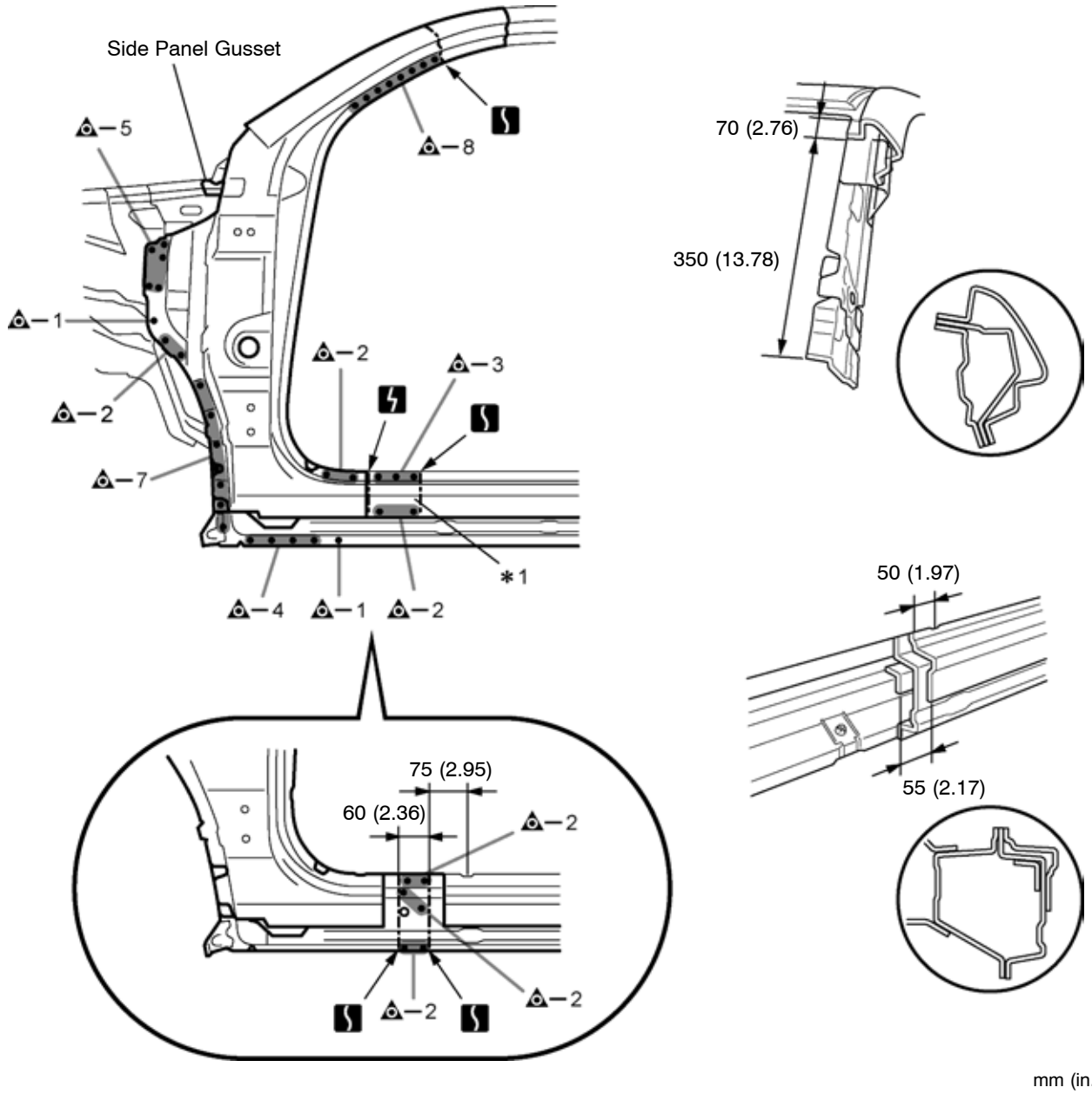
Symbol meaning

: Remove Weld Points : Cut and Join Location

: Cut Location for Supply Parts

F29208B

REMOVAL

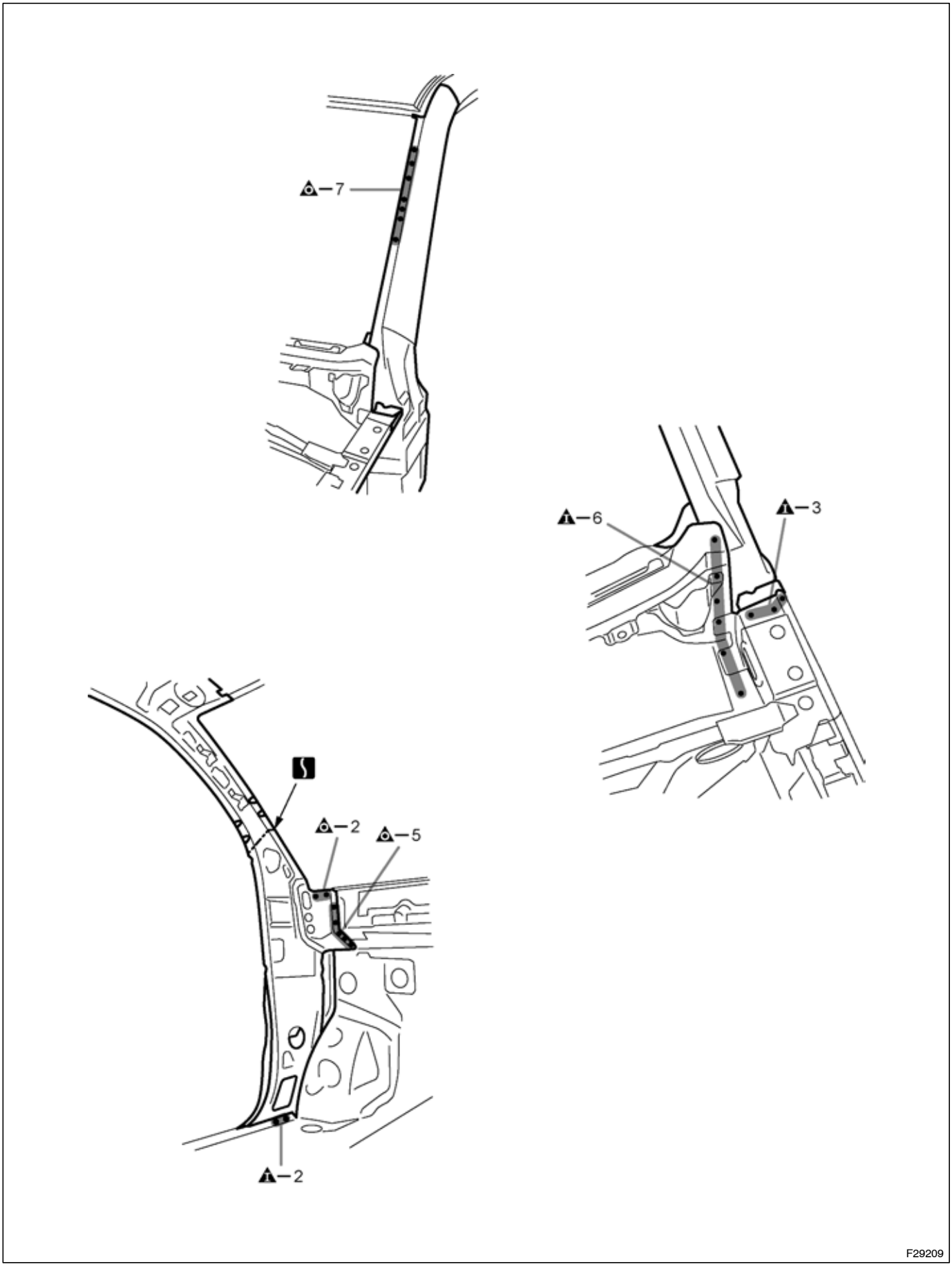


F29208

REMOVAL POINT

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

2 Remove the side panel gusset at the same time.


7
6
3
2
5
2
F29209

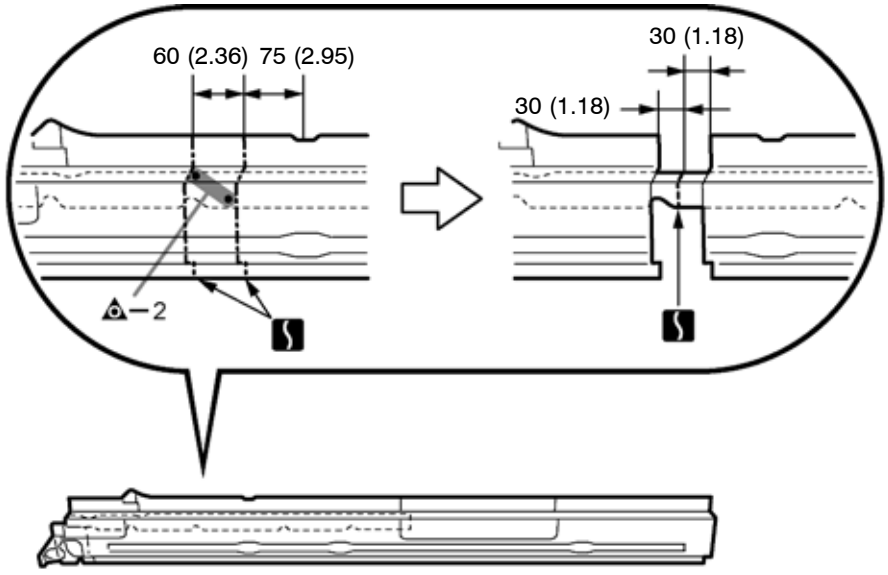
Symbol meaning

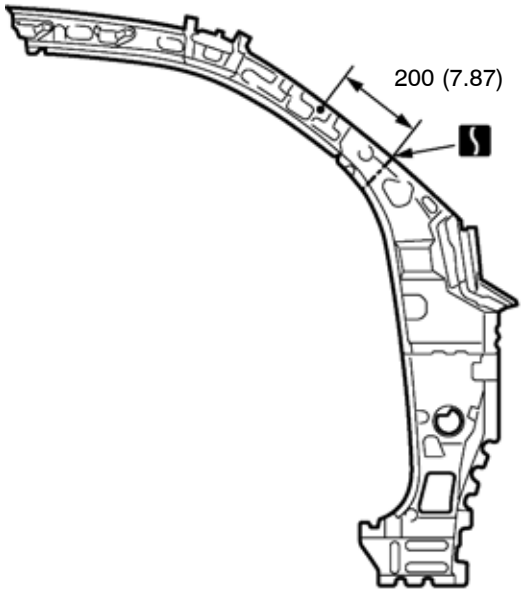
: Remove Weld Points : Spot Weld : Plug Weld : Cut and Join Location

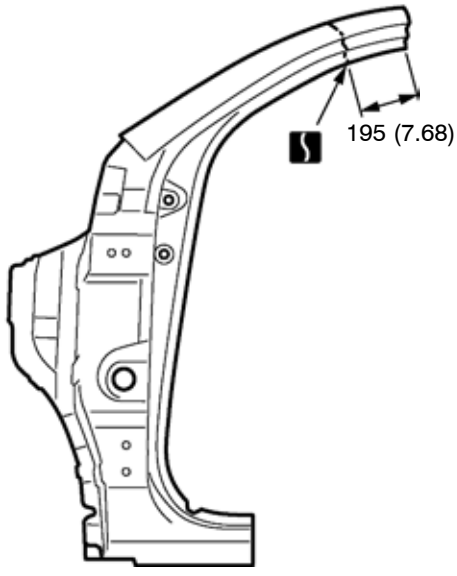
: Butt Weld : Body Sealer

F29210B

INSTALLATION

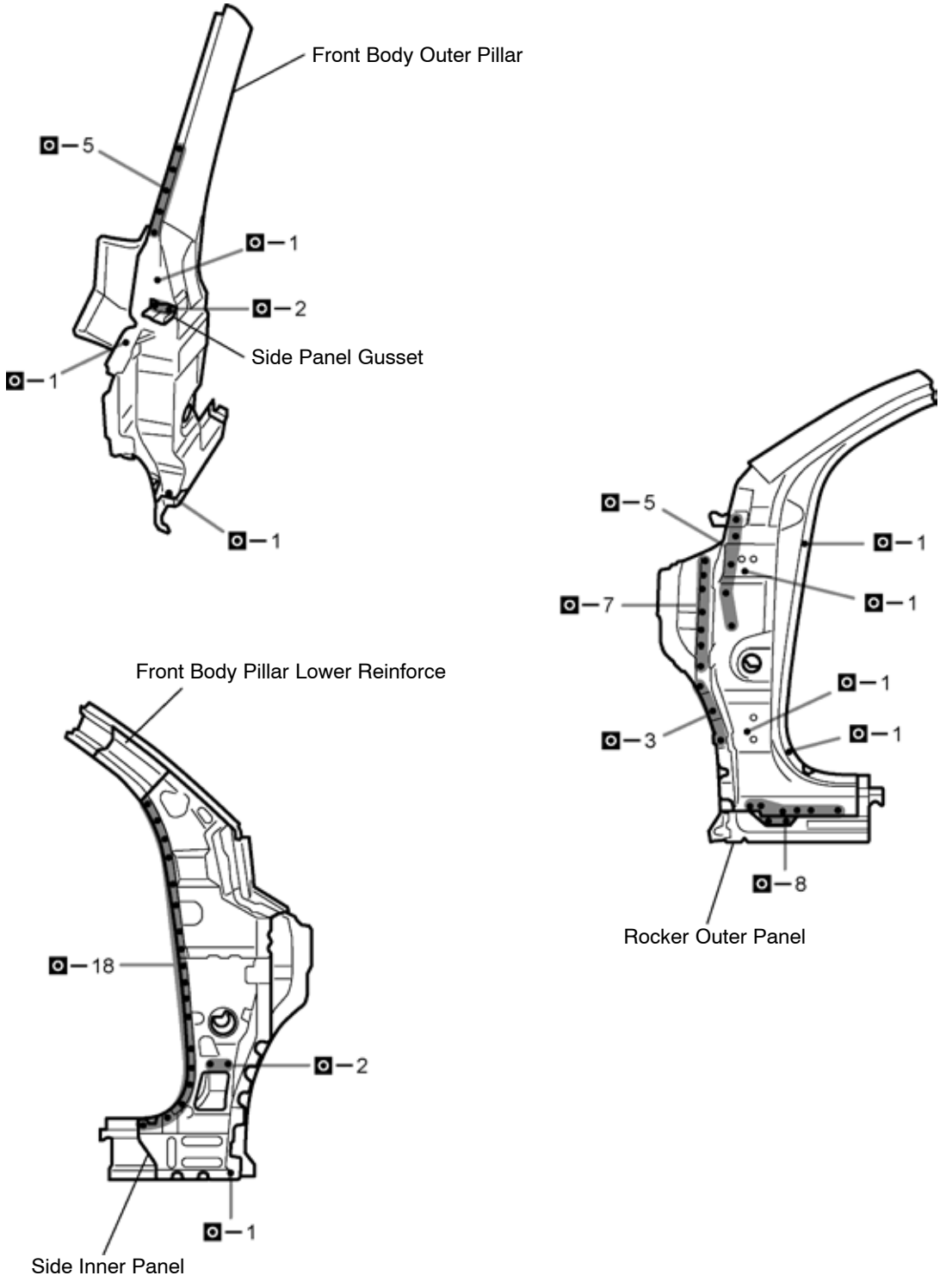






mm (in.)

F29210



F29211

INSTALLATION POINT

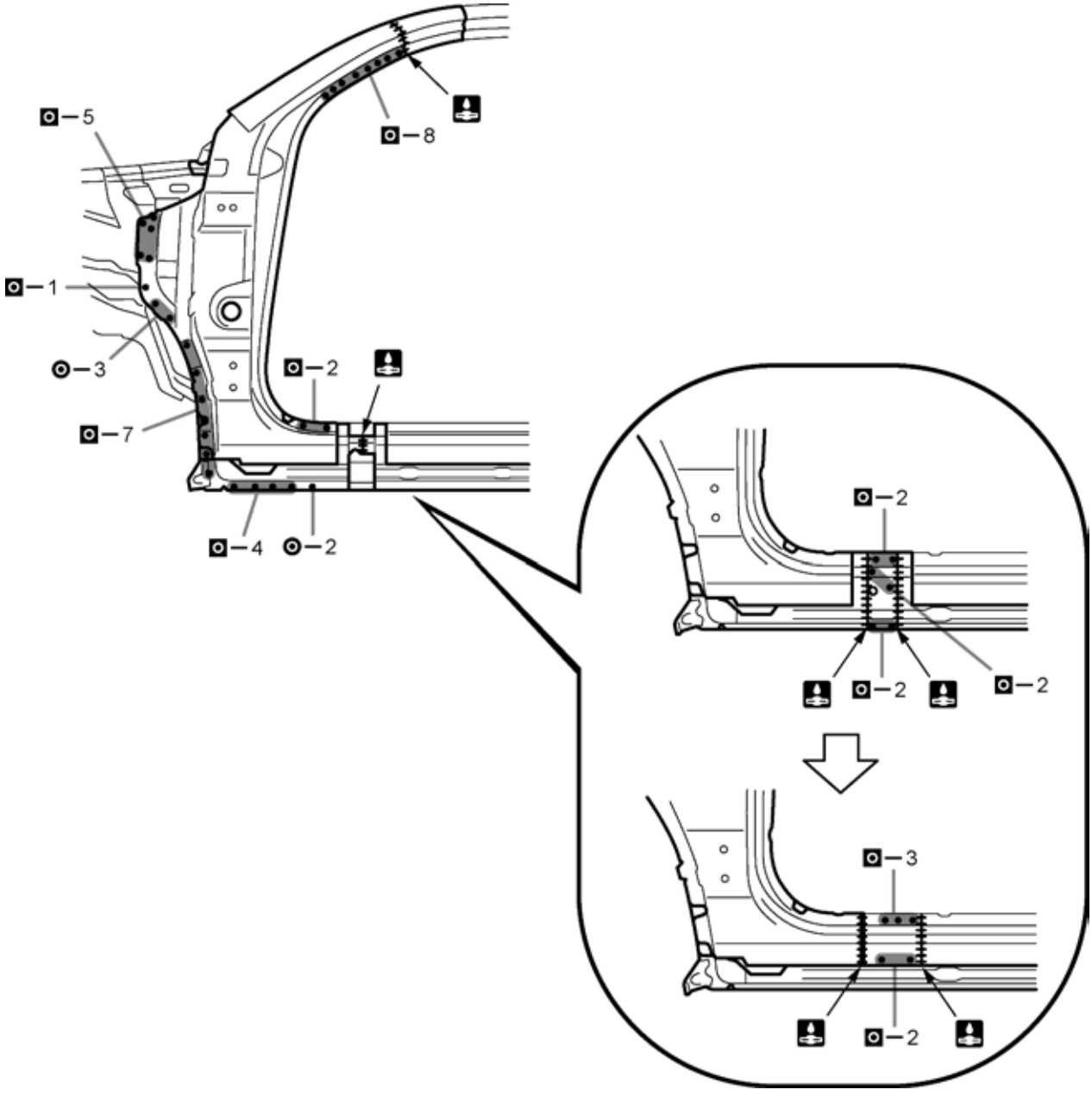
1 Before temporarily installing the new parts, weld the rocker outer panel, front body pillar lower reinforce, side inner panel, front body outer pillar and side panel gusset with the standard number of welding points.

Symbol meaning

: Remove Weld Points : Spot Weld : Plug Weld : Cut and Join Location

: Butt Weld : Body Sealer

F29210B

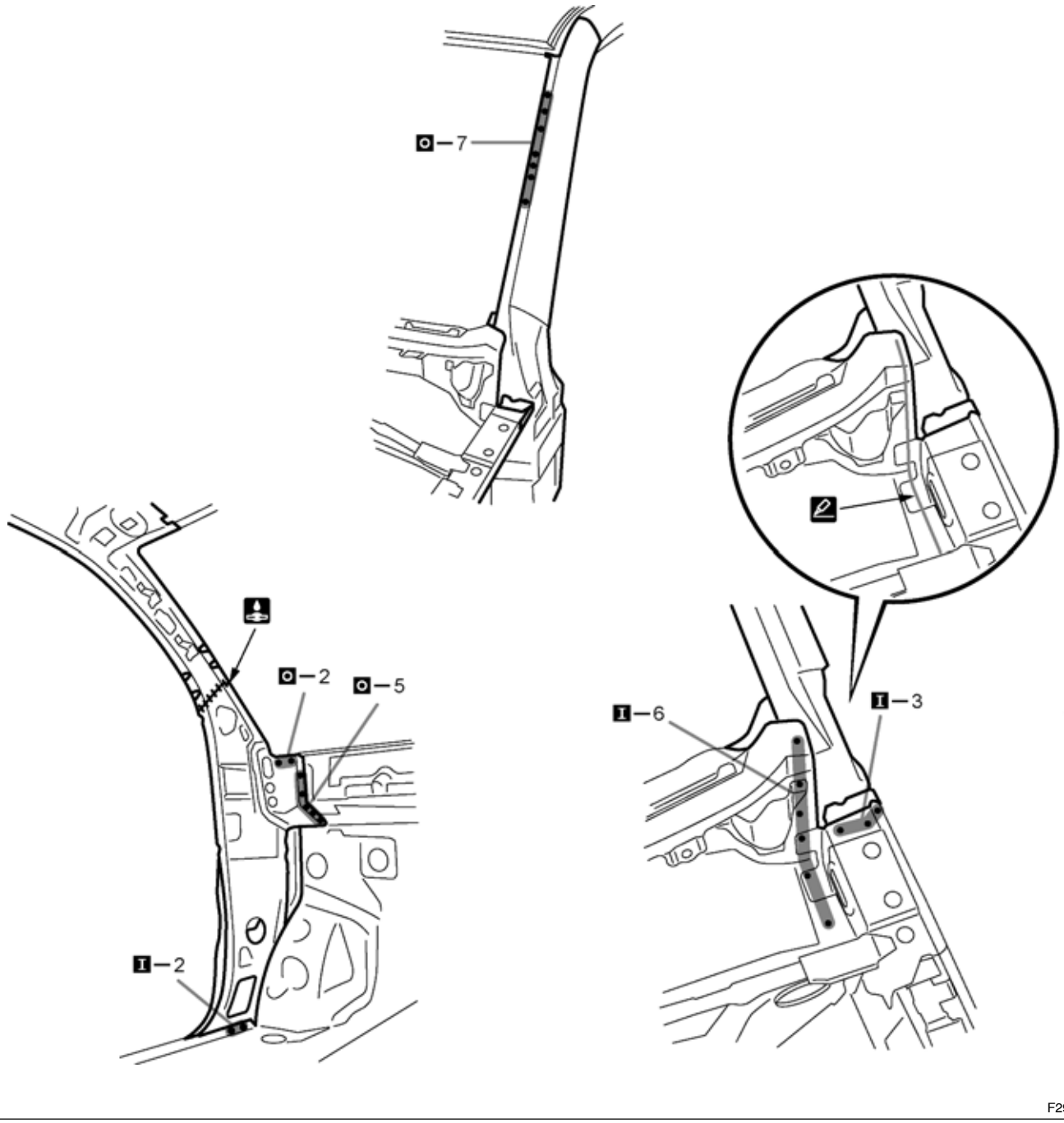


F29212

INSTALLATION POINT

1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.

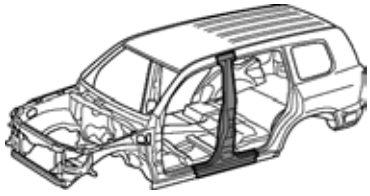
2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)



INSTALLATION POINT

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

CENTER BODY PILLAR (CUT)



F29214A

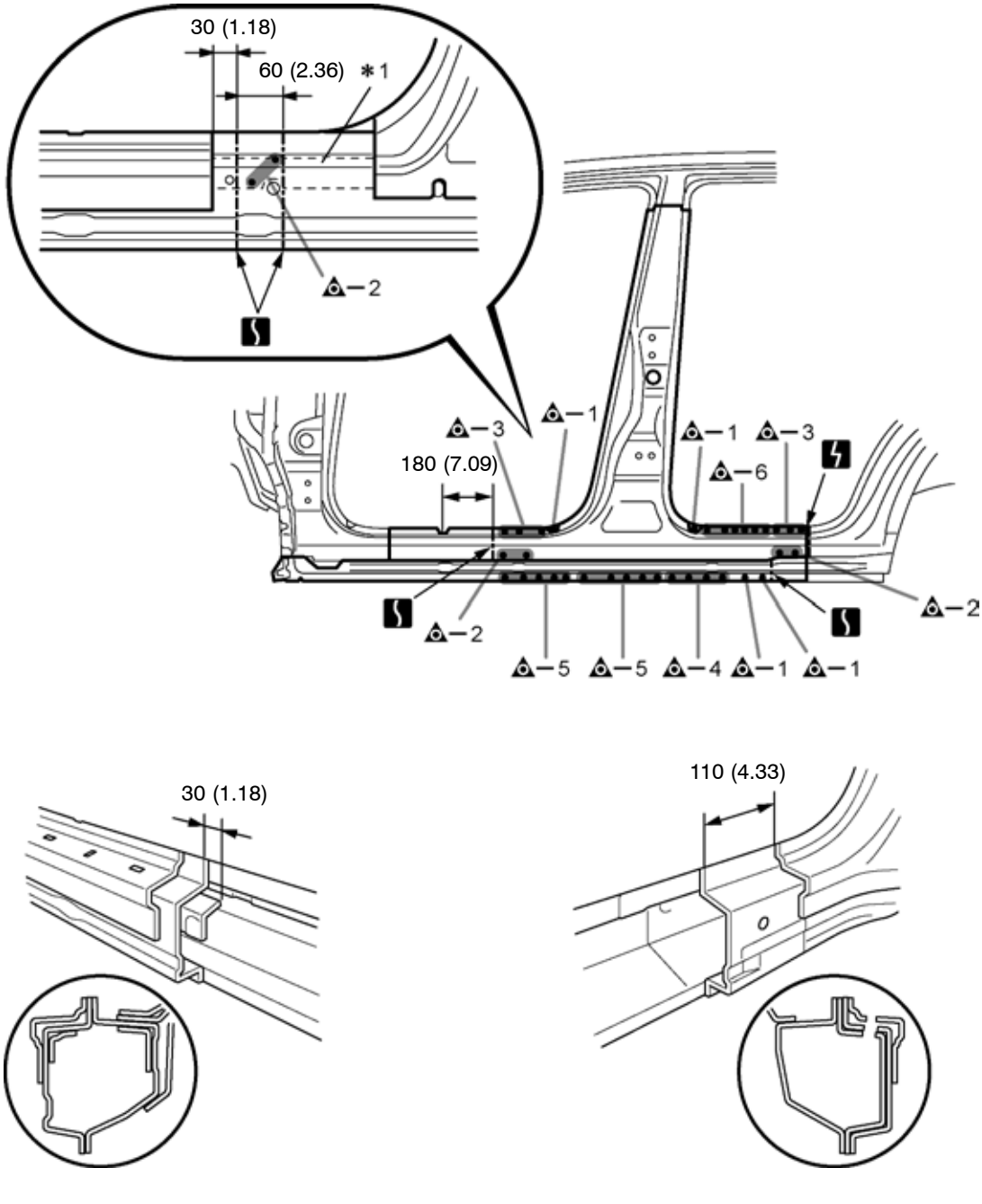
Symbol meaning

: Remove Weld Points : Cut and Join Location

: Cut Location for Supply Parts

F29214B

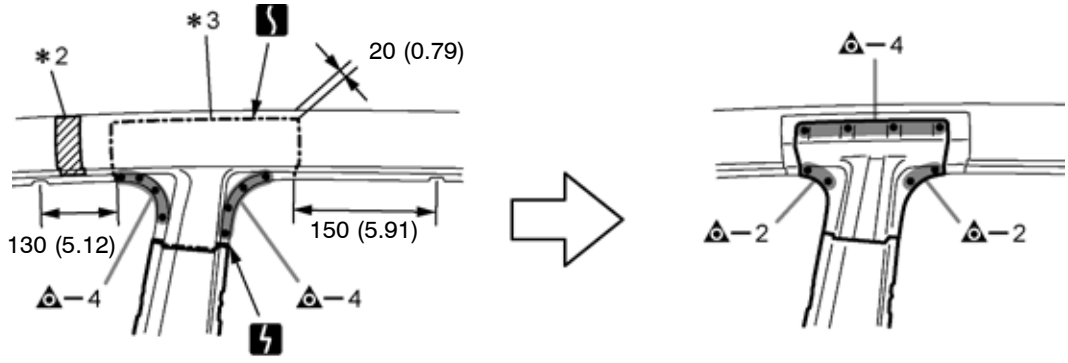
REMOVAL

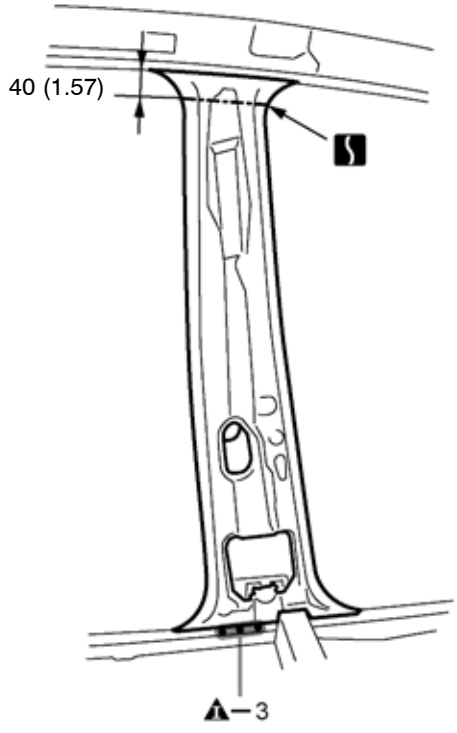


F29214

REMOVAL POINT

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





mm (in.)

F29215

REMOVAL POINT

1 *2 indicates the location of the foamed sealing material. Be careful when cutting as the foamed sealing material is located near the cutting position.

2 *3 is reused.

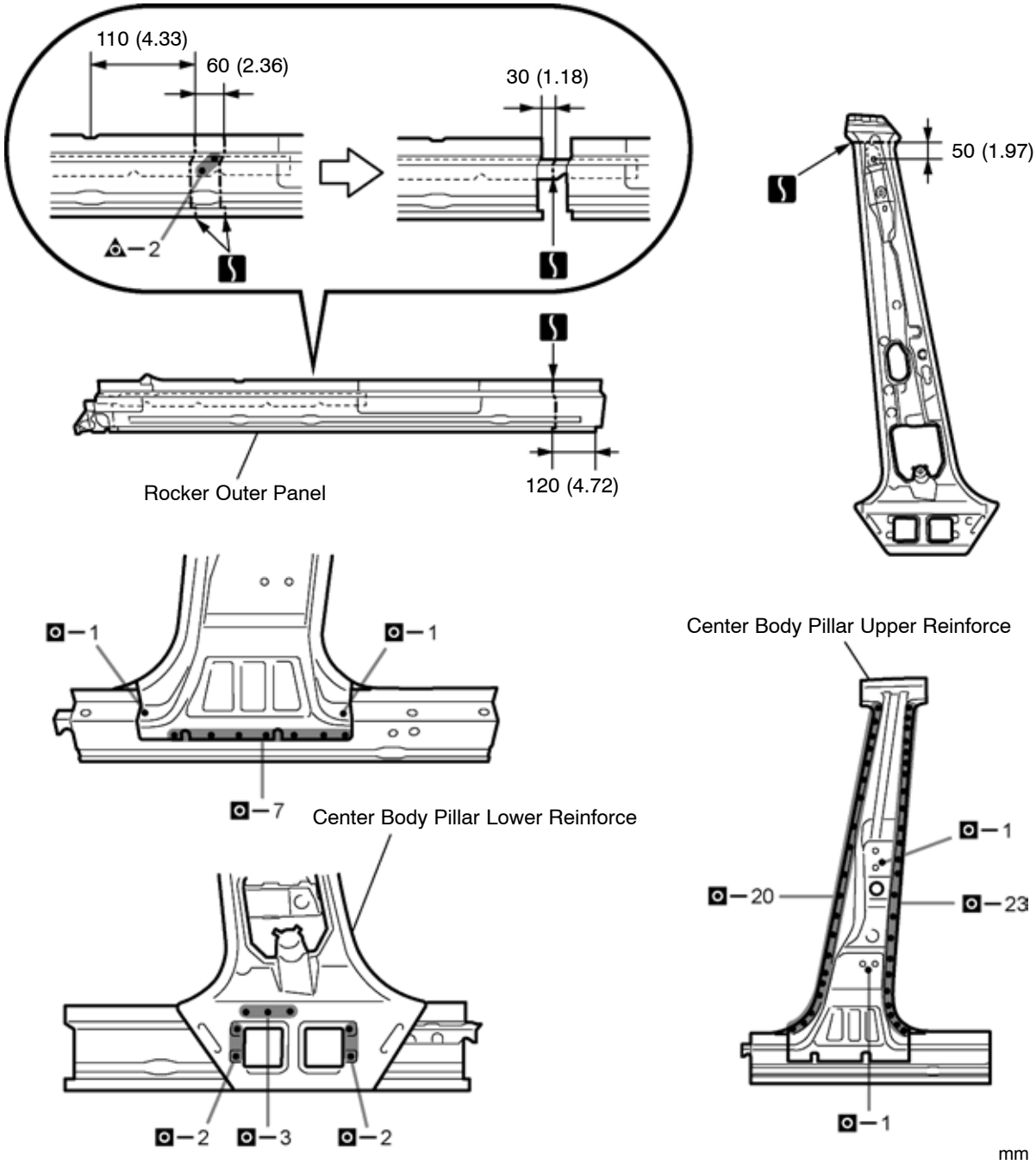
Symbol meaning

: Remove Weld Points : Spot Weld : Plug Weld : Cut and Join Location

: Butt Weld

F29216B

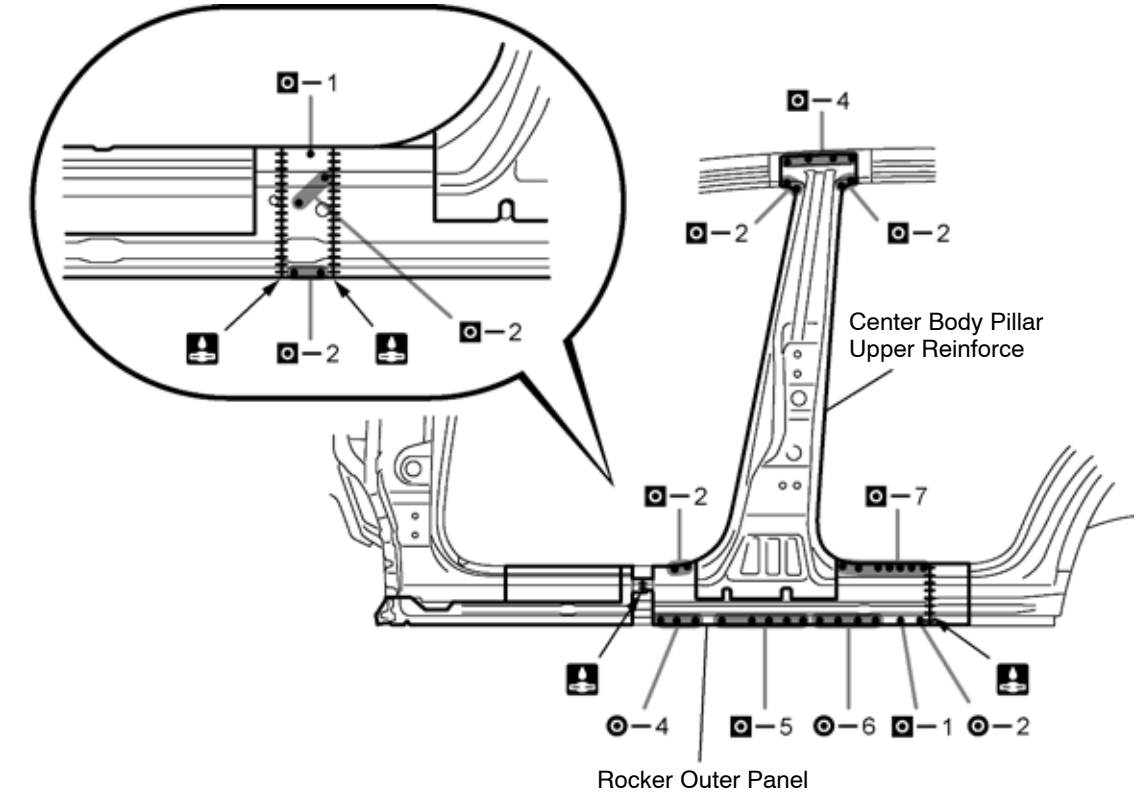
INSTALLATION

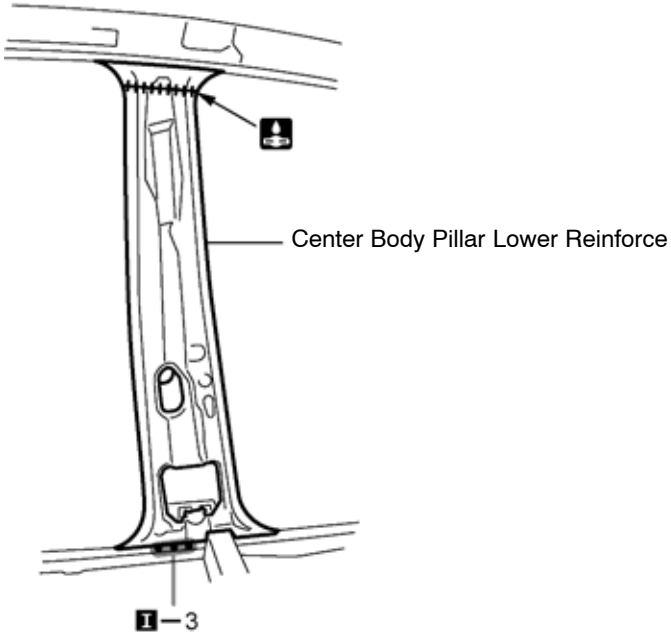


F29216

INSTALLATION POINT

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





F29217

INSTALLATION POINT

1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.

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

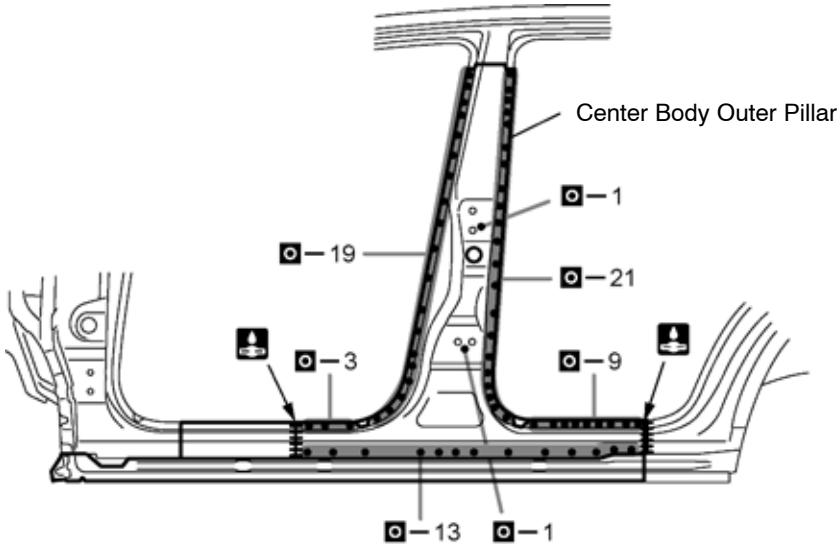
3 After welding the rocker outer panel, center body pillar upper reinforce and center body pillar lower reinforce to the vehicle side, install the center body outer pillar.

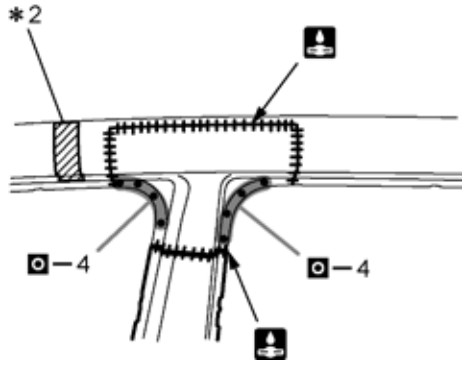
Symbol meaning

: Remove Weld Points : Spot Weld : Plug Weld : Cut and Join Location

: Butt Weld

F29216B



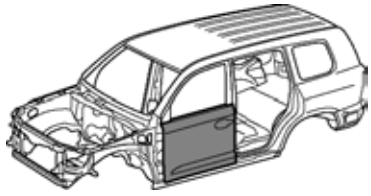


F29218

INSTALLATION POINT

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

FRONT DOOR OUTER PANEL (ASSY)



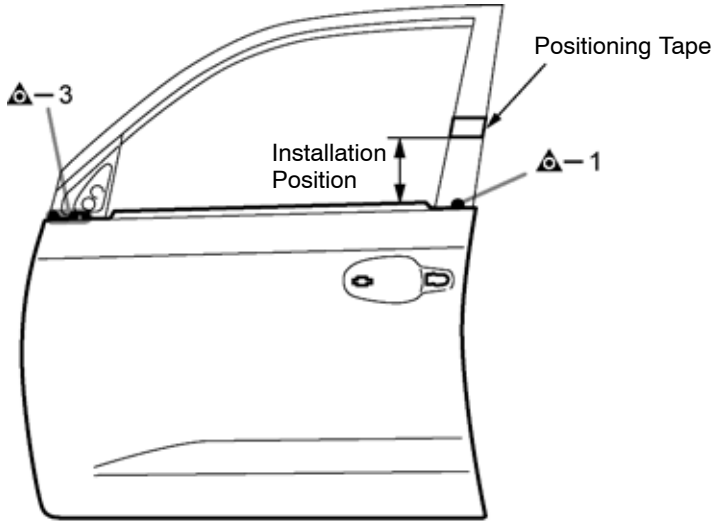
F29219A

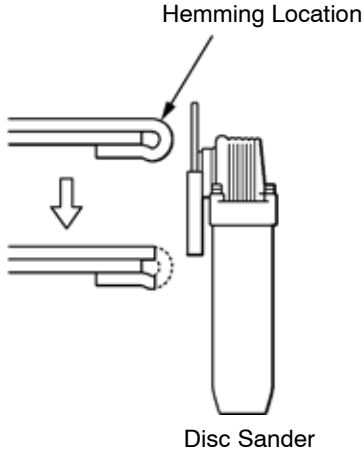
Symbol meaning

: Remove Weld Points

F29219B

REMOVAL





F29219

REMOVAL POINT

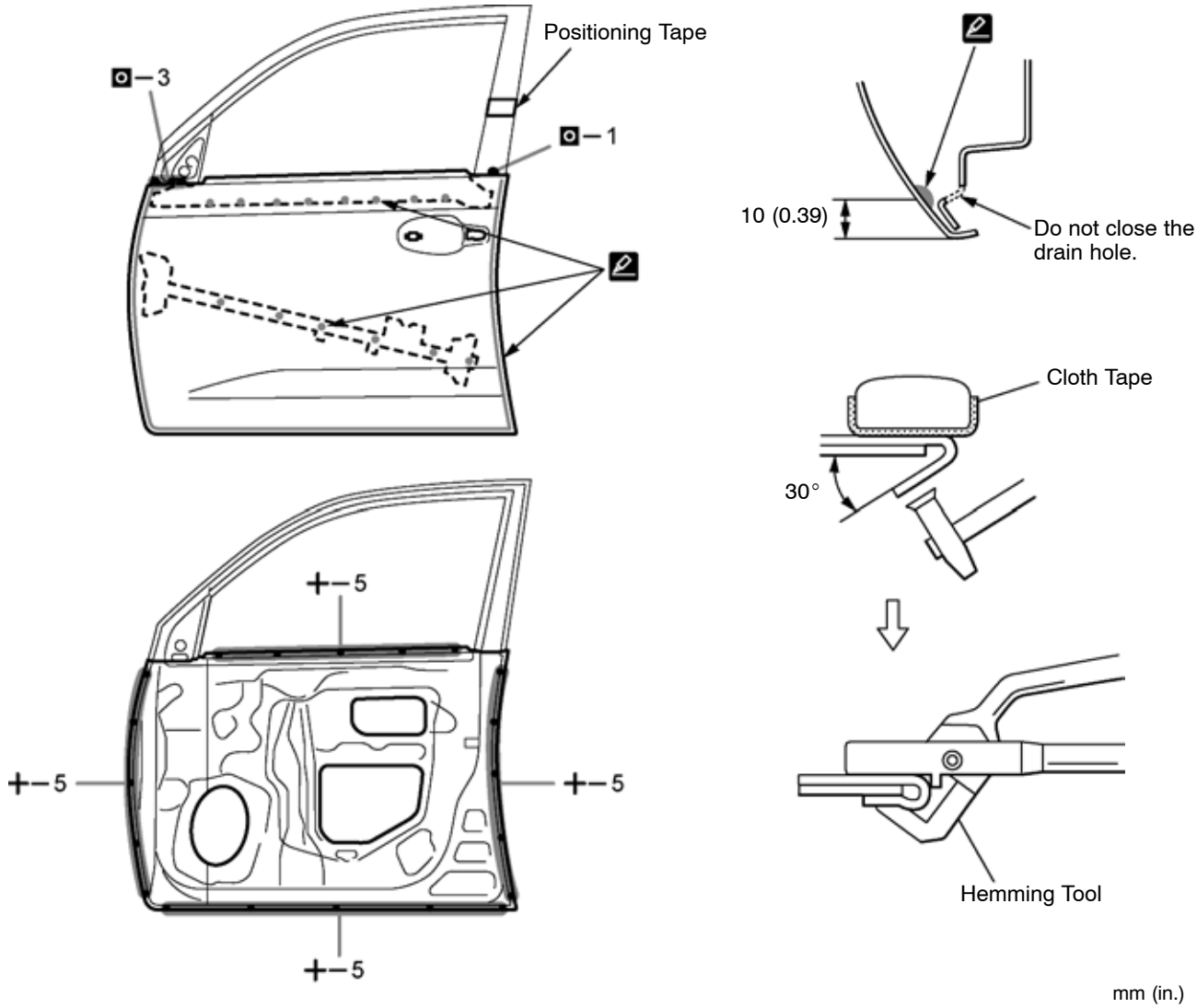
1 Before removing the outer panel, mark the installation position with tape.
2 Before removing the outer panel, establish its exact position in relation to the window frame using a reference marker, etc.
3 After grinding off the hemming location, remove the outer panel.

Symbol meaning

: Plug Weld + : Spot MIG Weld : Body Sealer

F29220B

INSTALLATION



F29220

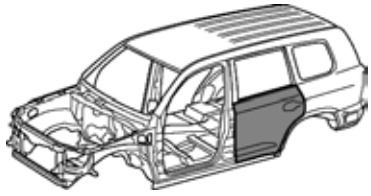
INSTALLATION POINT

1 Before temporarily installing the new parts, apply body sealer to the reinforcement, side impact protection beam and backside of the new parts.
HINT:
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 hammer and dolly. Then, fasten tightly with a hemming tool.
HINT:
- *Perform hemming in three steps, being careful not to warp the panel.*
- *If a hemming tool cannot be used, hem with a hammer and dolly.*

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)



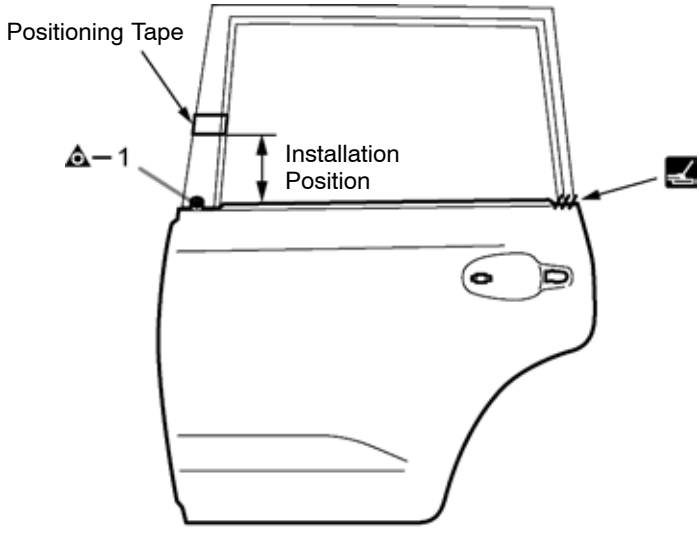
F29221A

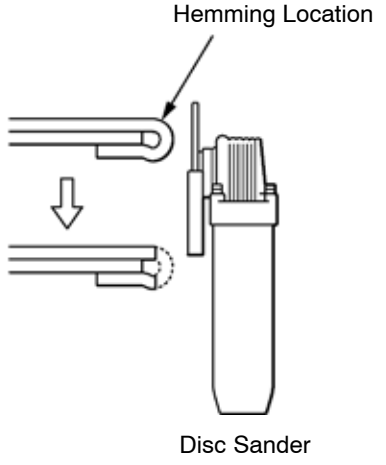
Symbol meaning

: Remove Weld Points : Braze

F29221B

REMOVAL





F29221

REMOVAL POINT

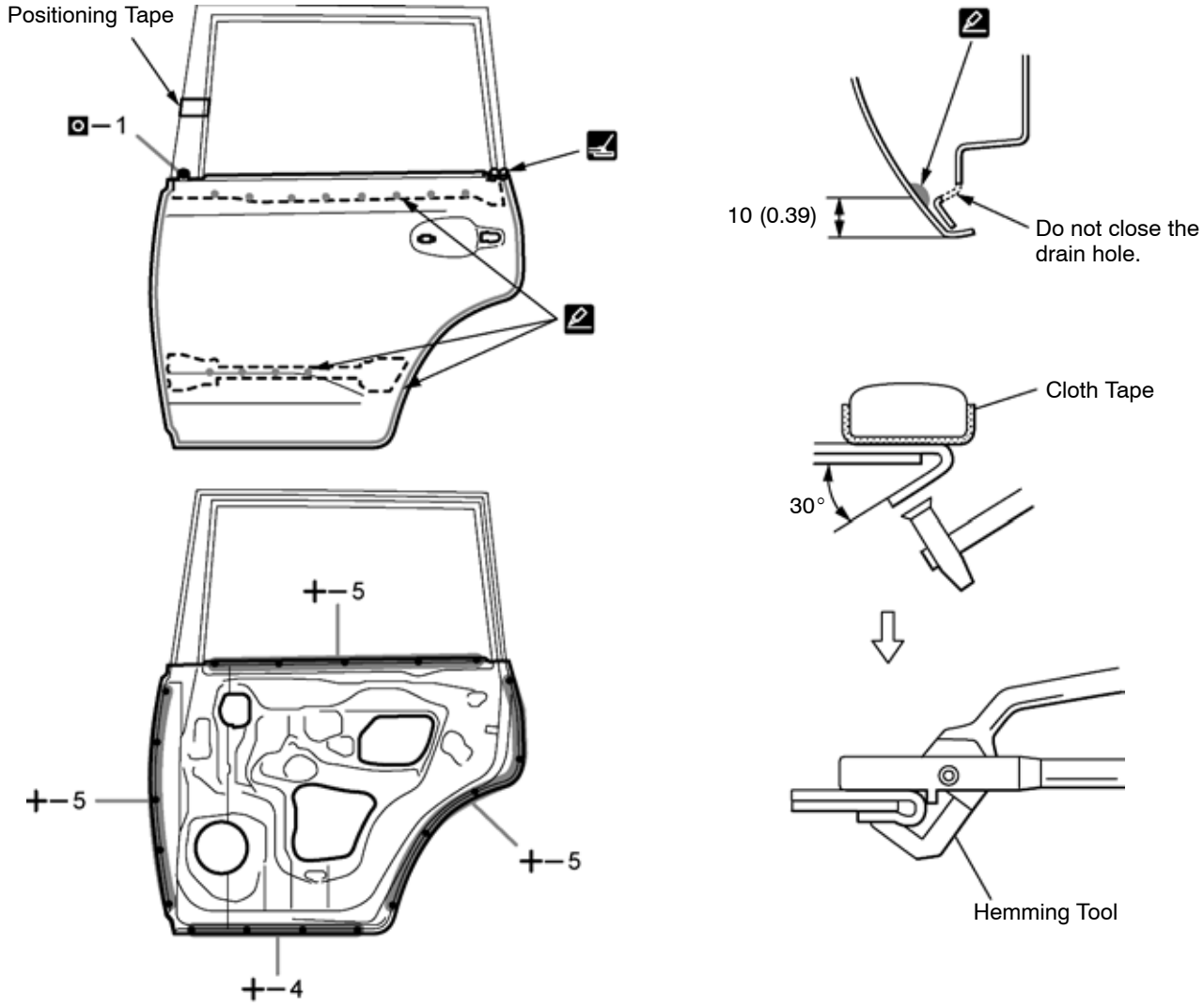
1 Before removing the outer panel, mark the installation position with tape.
2 Before removing the outer panel, establish its exact position in relation to the window frame using a reference marker, etc.
3 After grinding off the hemming location, remove the outer panel.

Symbol meaning

: Plug Weld : Braze : Spot MIG Weld : Body Sealer

F29222B

INSTALLATION



F29222

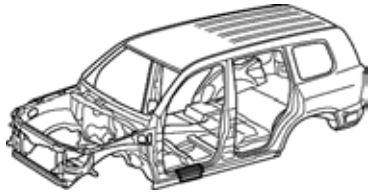
INSTALLATION POINT

1 Before temporarily installing the new parts, apply body sealer to the reinforcement, side impact protection beam and backside of the new parts.
HINT:
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 hammer and dolly. Then, fasten tightly with a hemming tool.
HINT:
- *Perform hemming in three steps, being careful not to warp the panel.*
- *If a hemming tool cannot be used, hem with a hammer and dolly.*

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)



F29223A

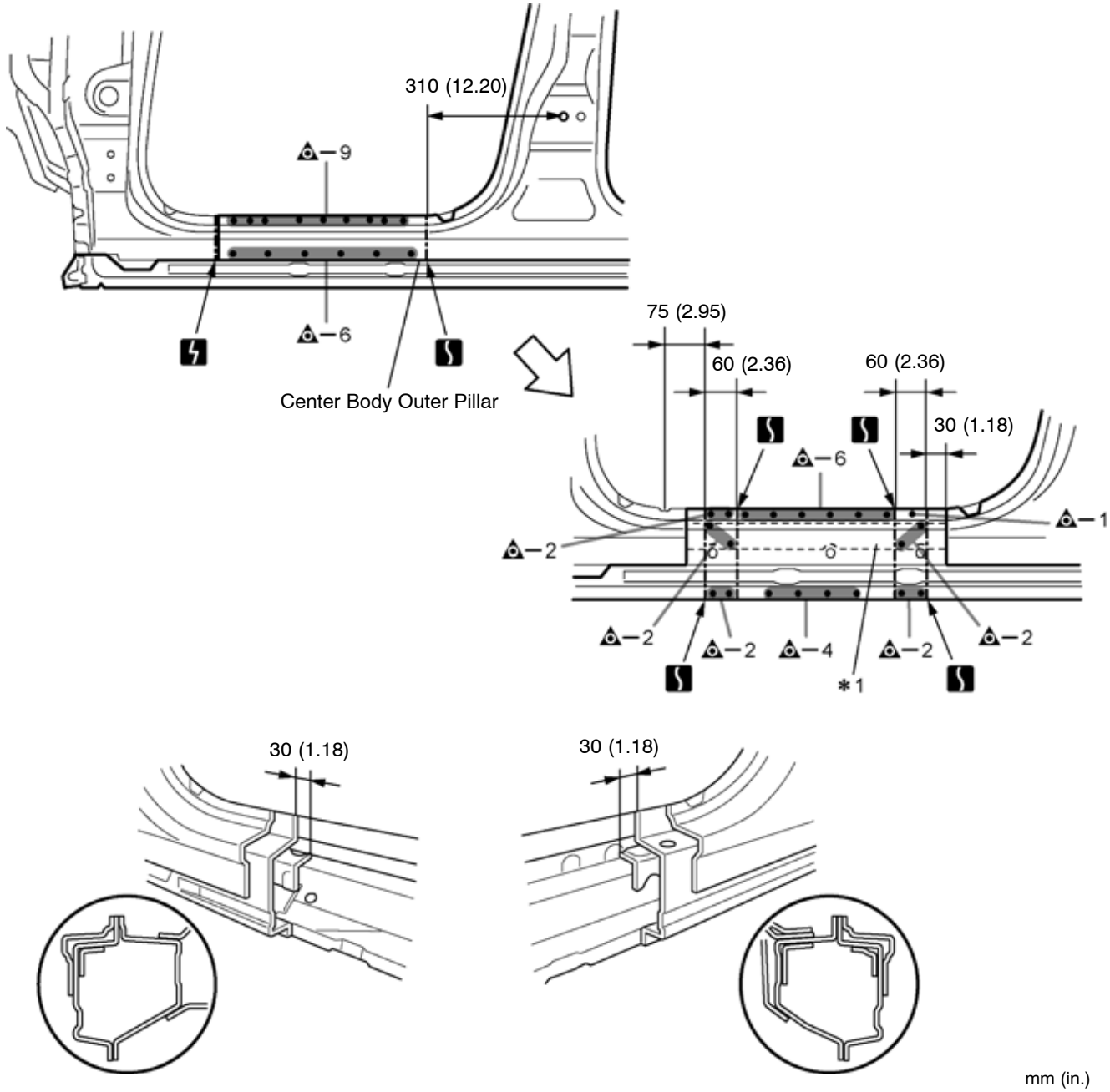
Symbol meaning

: Remove Weld Points : Cut and Join Location

: Cut Location for Supply Parts

F29223B

REMOVAL



mm (in.)

F29223

REMOVAL POINT

1 After removing the center body outer pillar, remove the rocker outer panel.

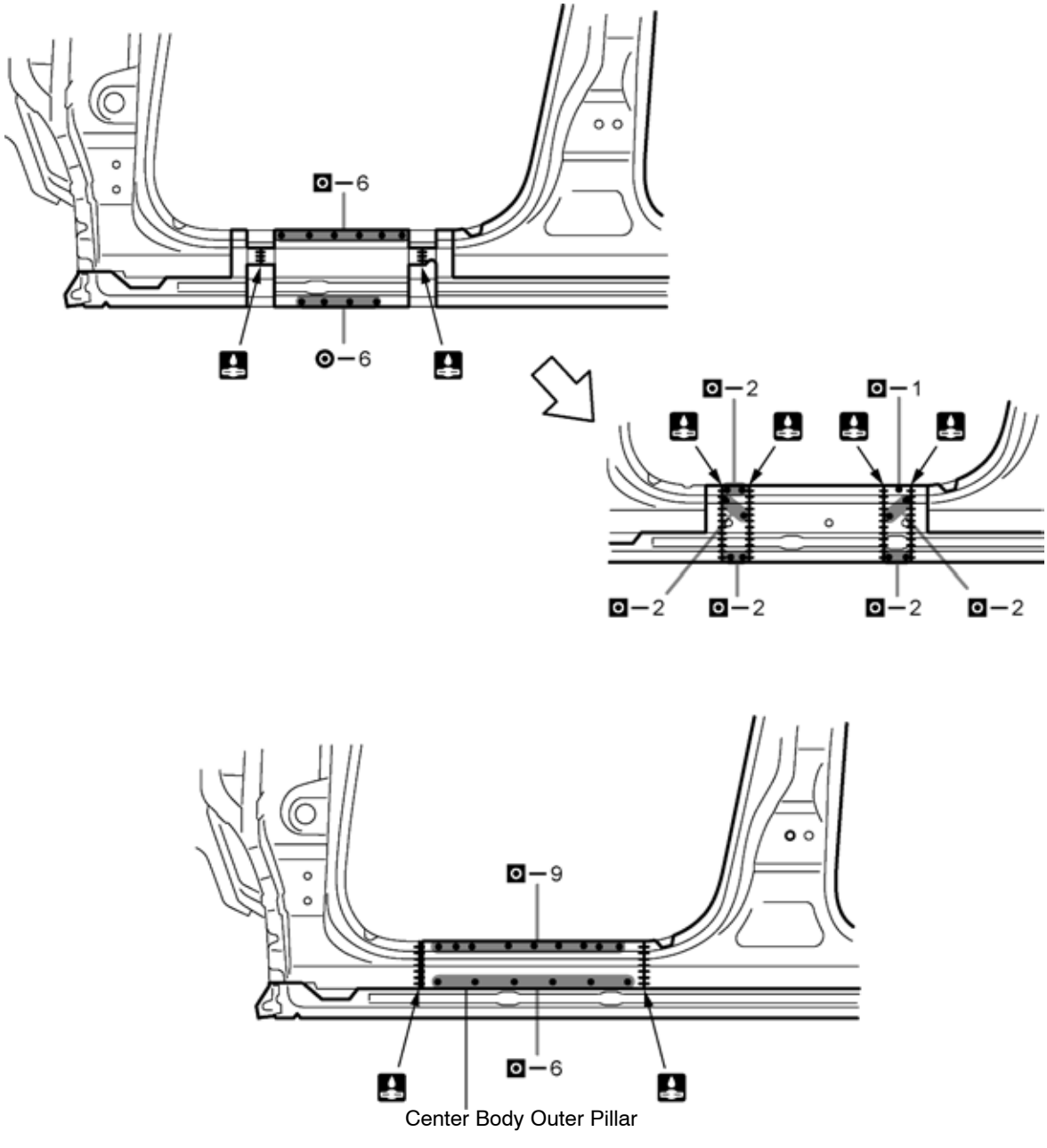
2 Carefully cut the rocker outer panel so not to damage *1

Symbol meaning

: Spot Weld : Plug Weld : Butt Weld

F29224B

INSTALLATION

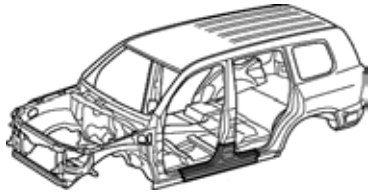


F29224

INSTALLATION POINT

1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
2 After welding the rocker outer panel to the vehicle side, install the center body outer pillar.
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.

ROCKER OUTER PANEL (CUT)



F29225A

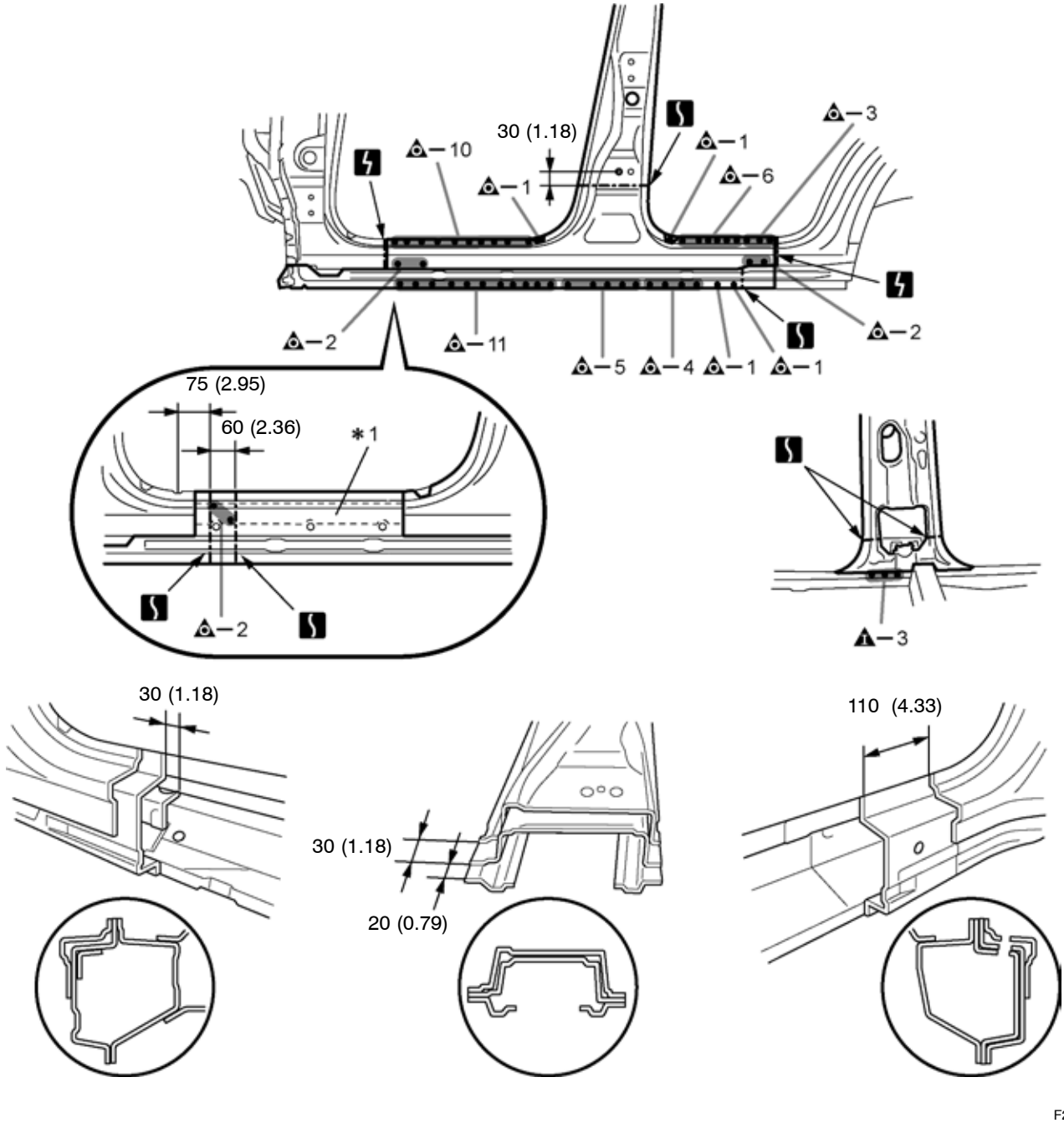
Symbol meaning

: Remove Weld Points : Cut and Join Location

: Cut Location for Supply Parts

F29225B

REMOVAL



F29225

REMOVAL POINT

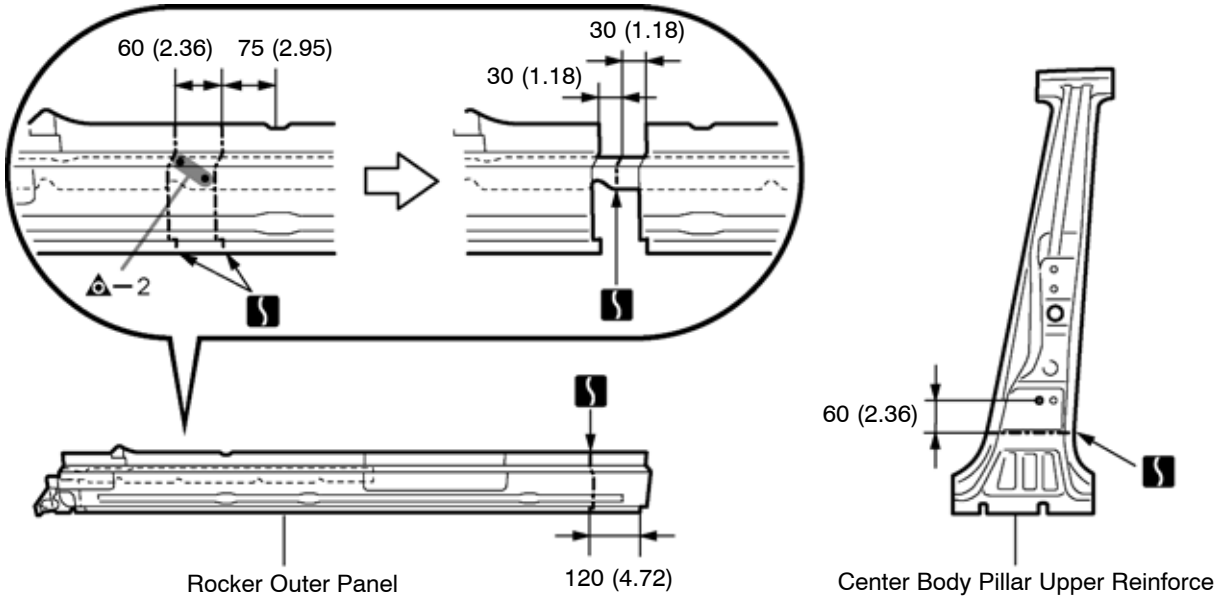
1 Carefully cut the rocker outer panel so not to damage *1.

Symbol meaning

: Remove Weld Points : Spot Weld : Plug Weld : Cut and Join Location : Butt Weld

F29226B

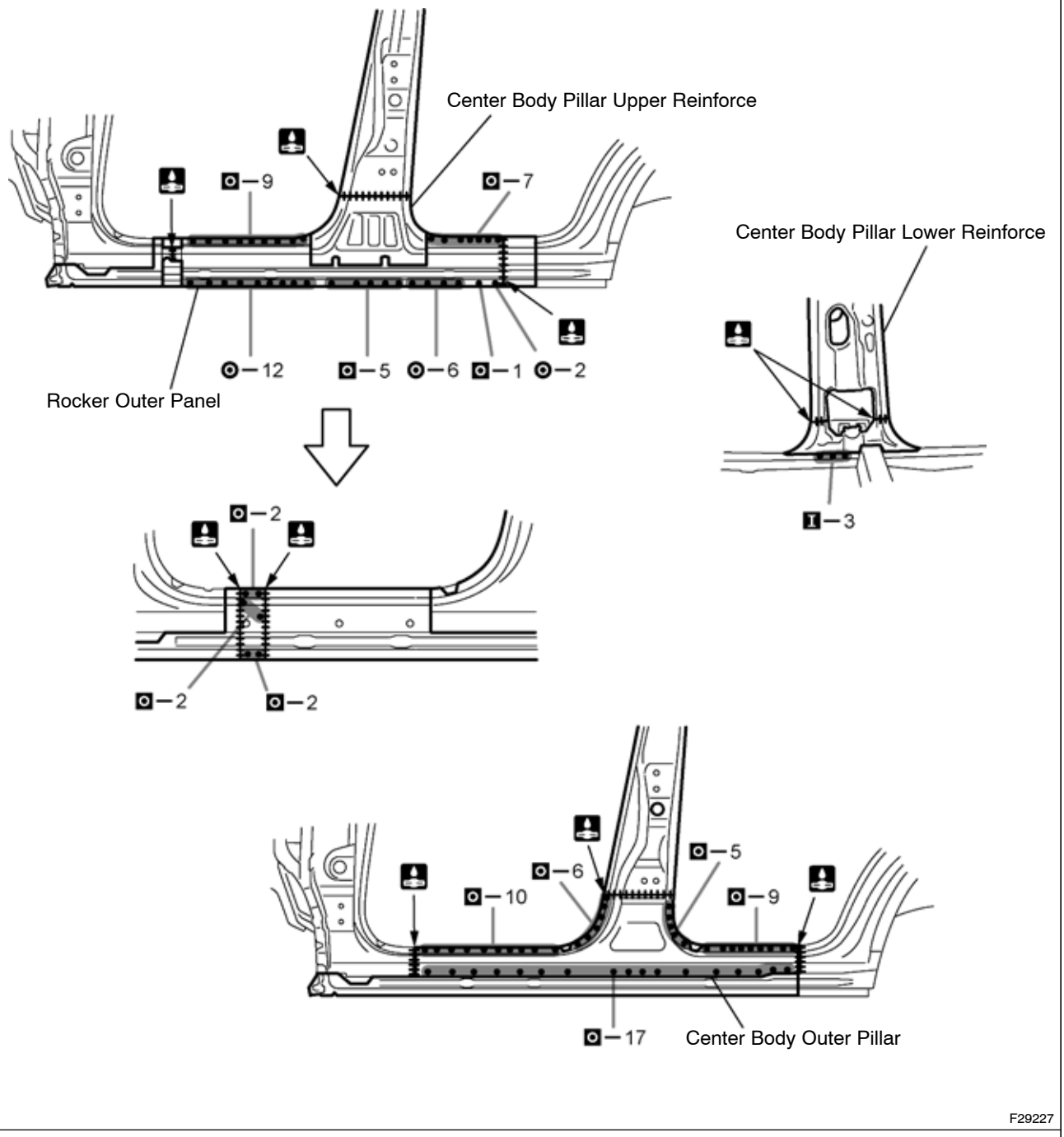
INSTALLATION



F29226

INSTALLATION POINT

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



INSTALLATION POINT

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

ROCKER PANEL NO. 3 REINFORCEMENT (CUT)



F29228A

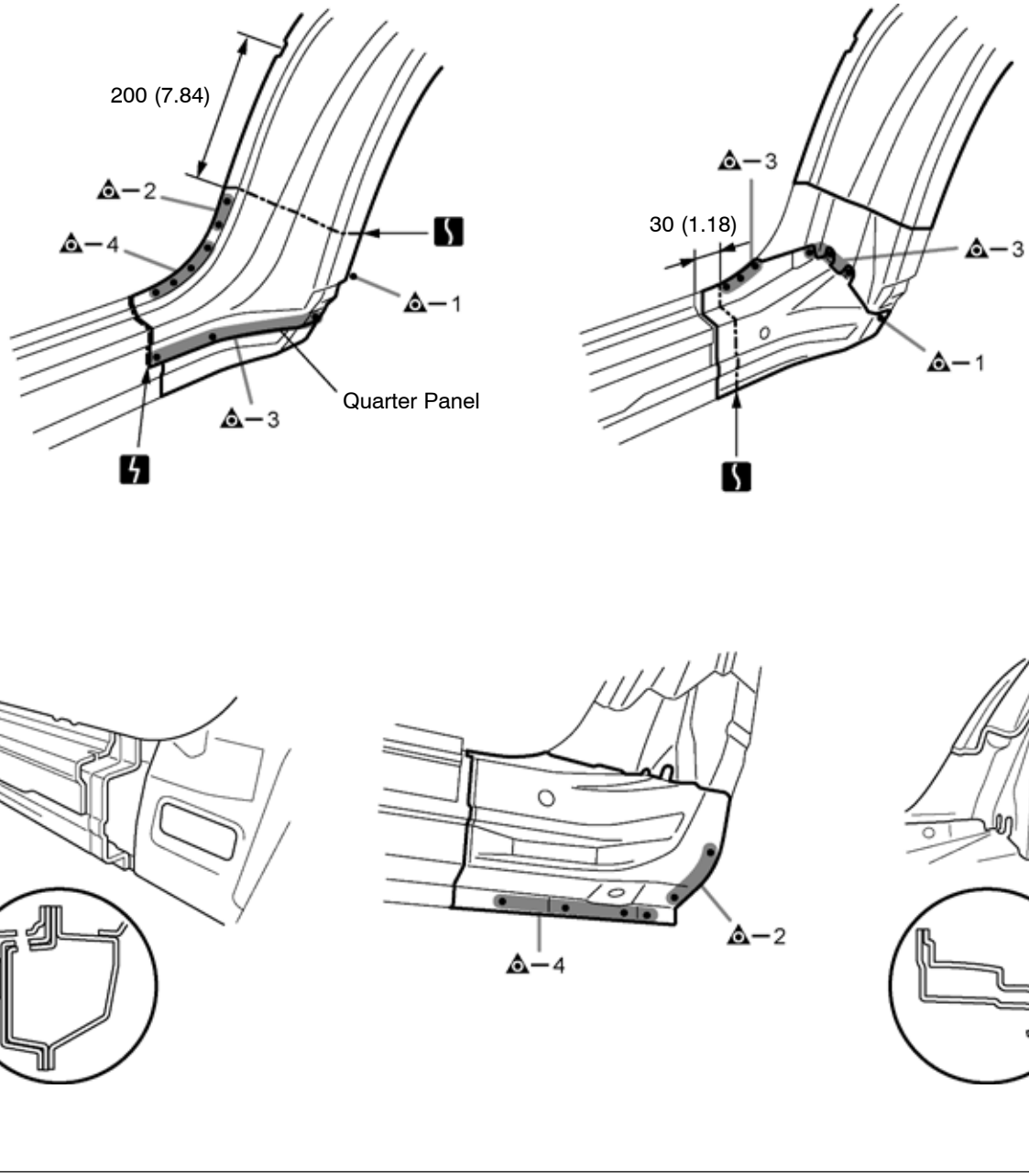
Symbol meaning

: Remove Weld Points : Cut and Join Location

: Cut Location for Supply Parts

F29228B

REMOVAL



F29228

REMOVAL POINT

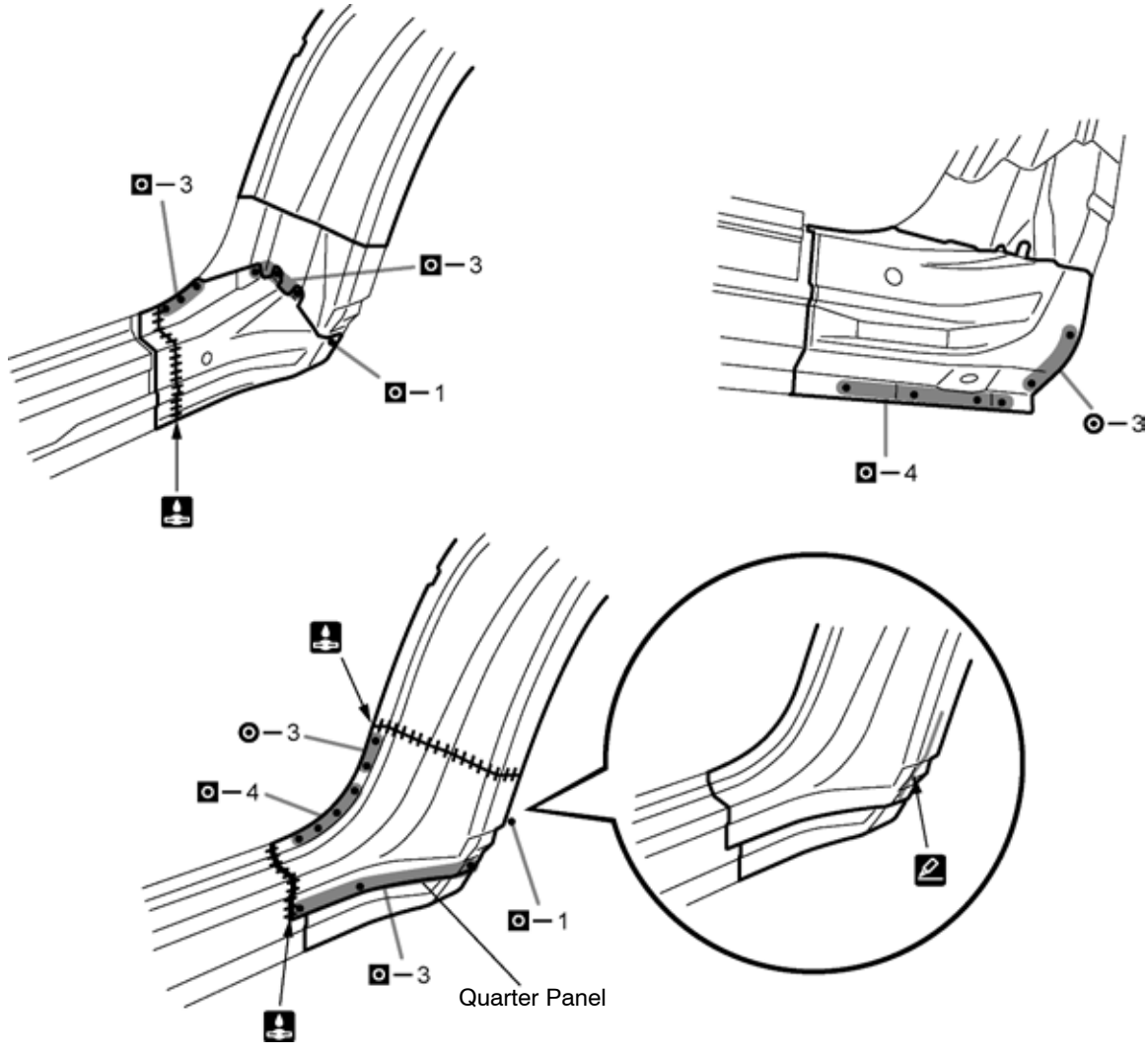
1 After removing the quarter panel, remove the rocker panel No. 3 reinforcement.

Symbol meaning

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

F29229B

INSTALLATION

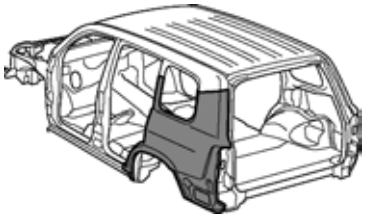


F29229

INSTALLATION POINT

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

QUARTER PANEL (ASSY)



F29230A

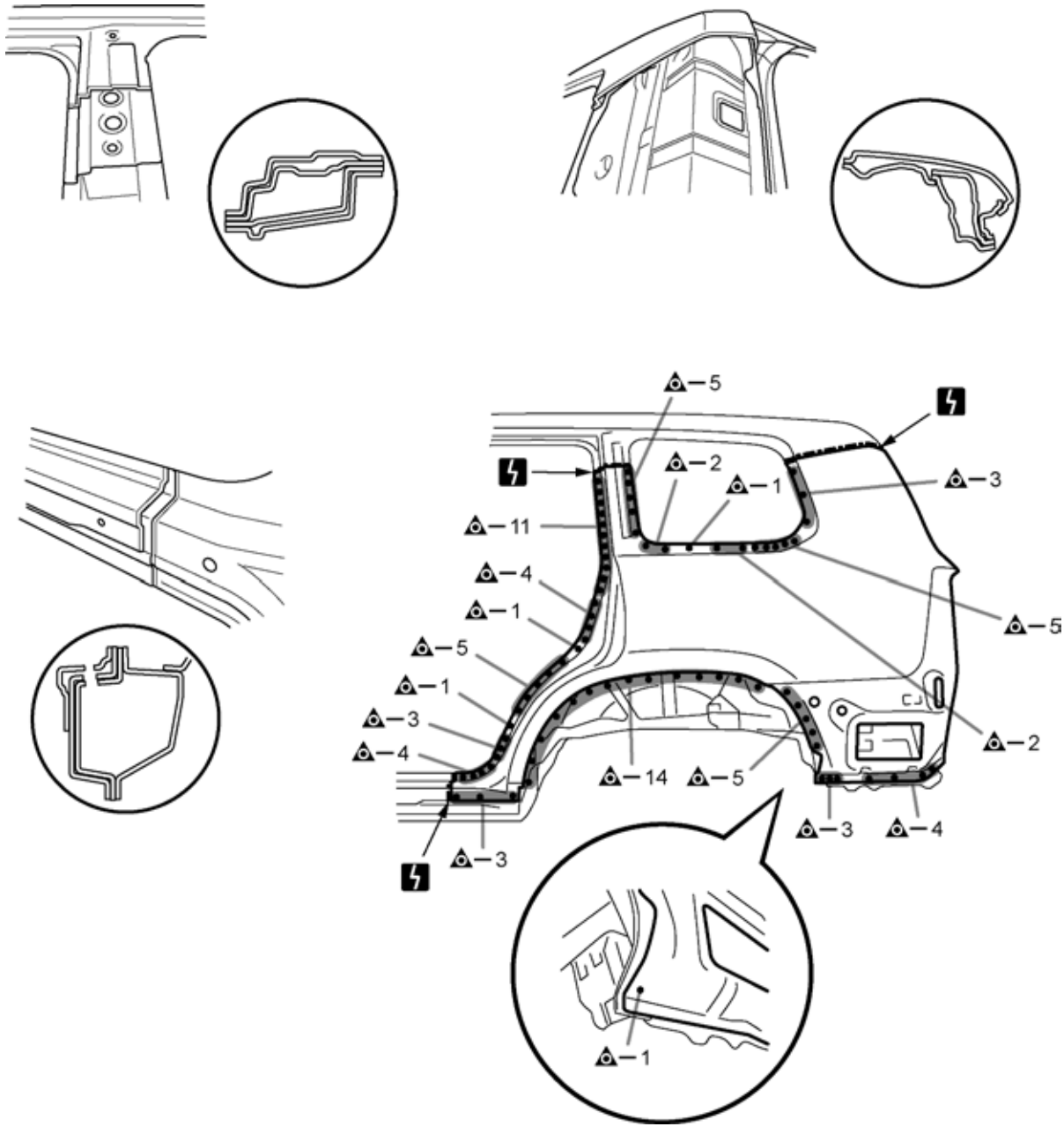
Symbol meaning

: Remove Weld Points : Cut with Disc Sander etc.

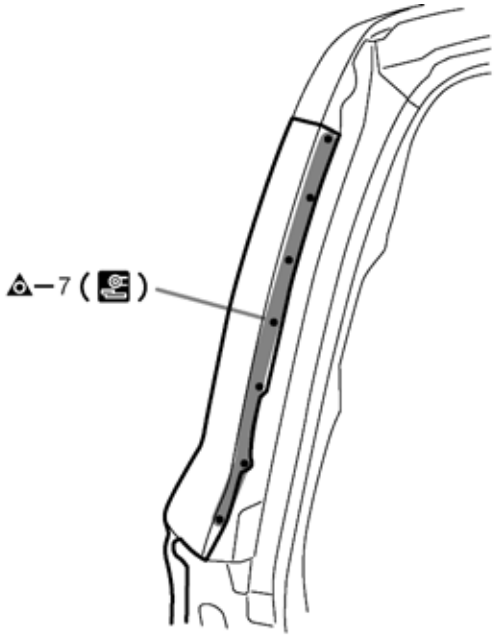
: Cut Location for Supply Parts

F29230B

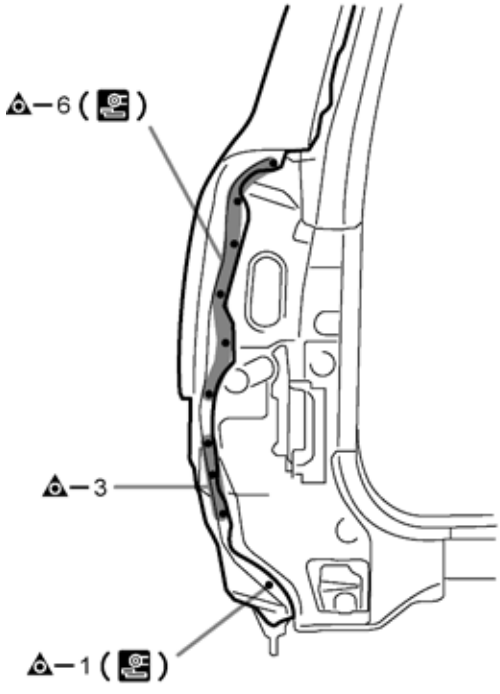
REMOVAL



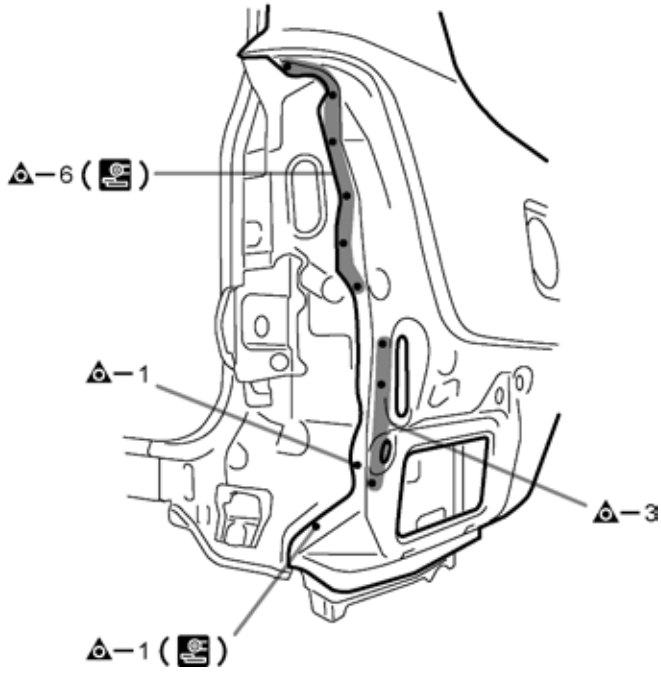
F29230



[LH]



[RH]



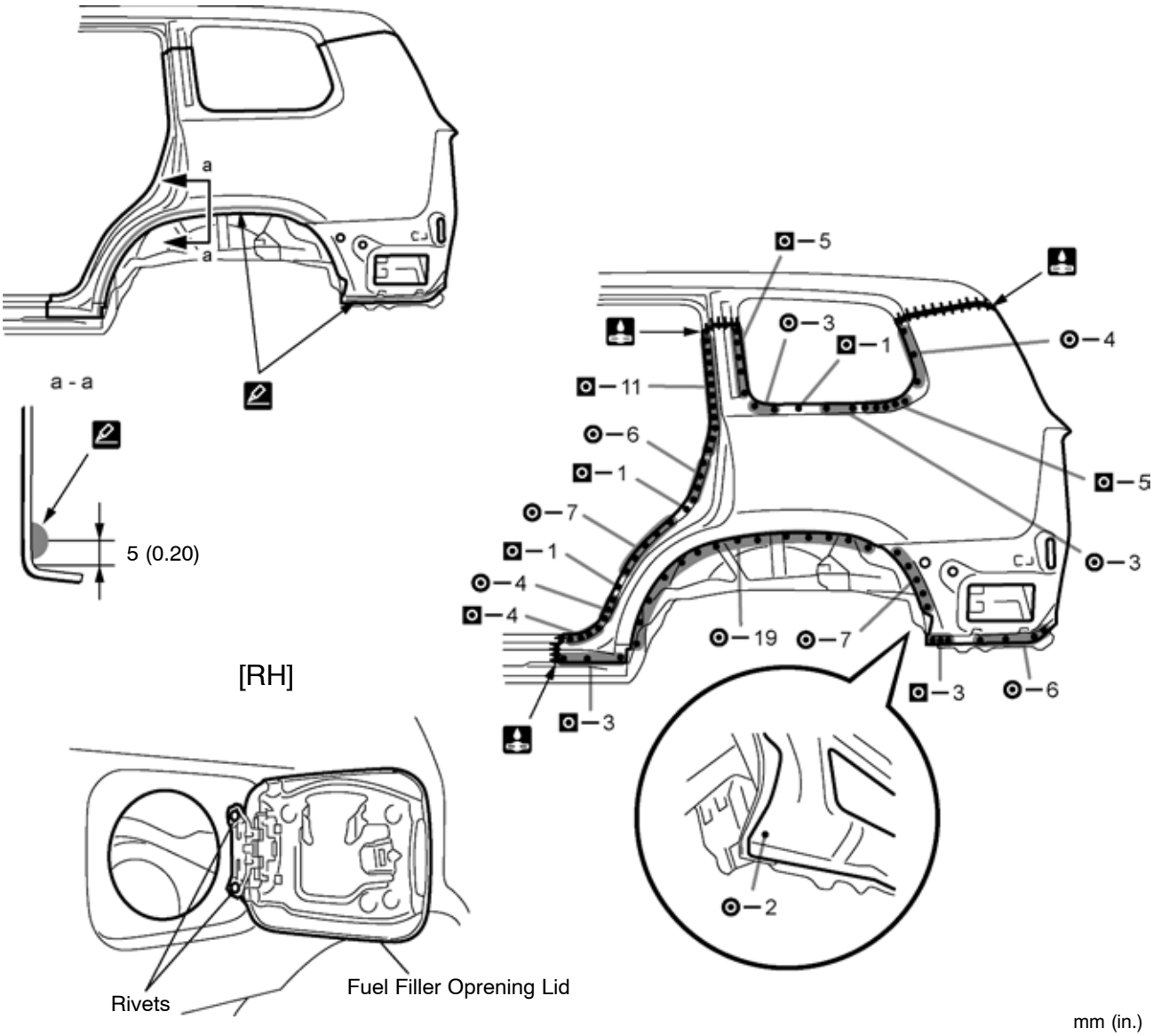
F29231

Symbol meaning

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

F29232B

INSTALLATION



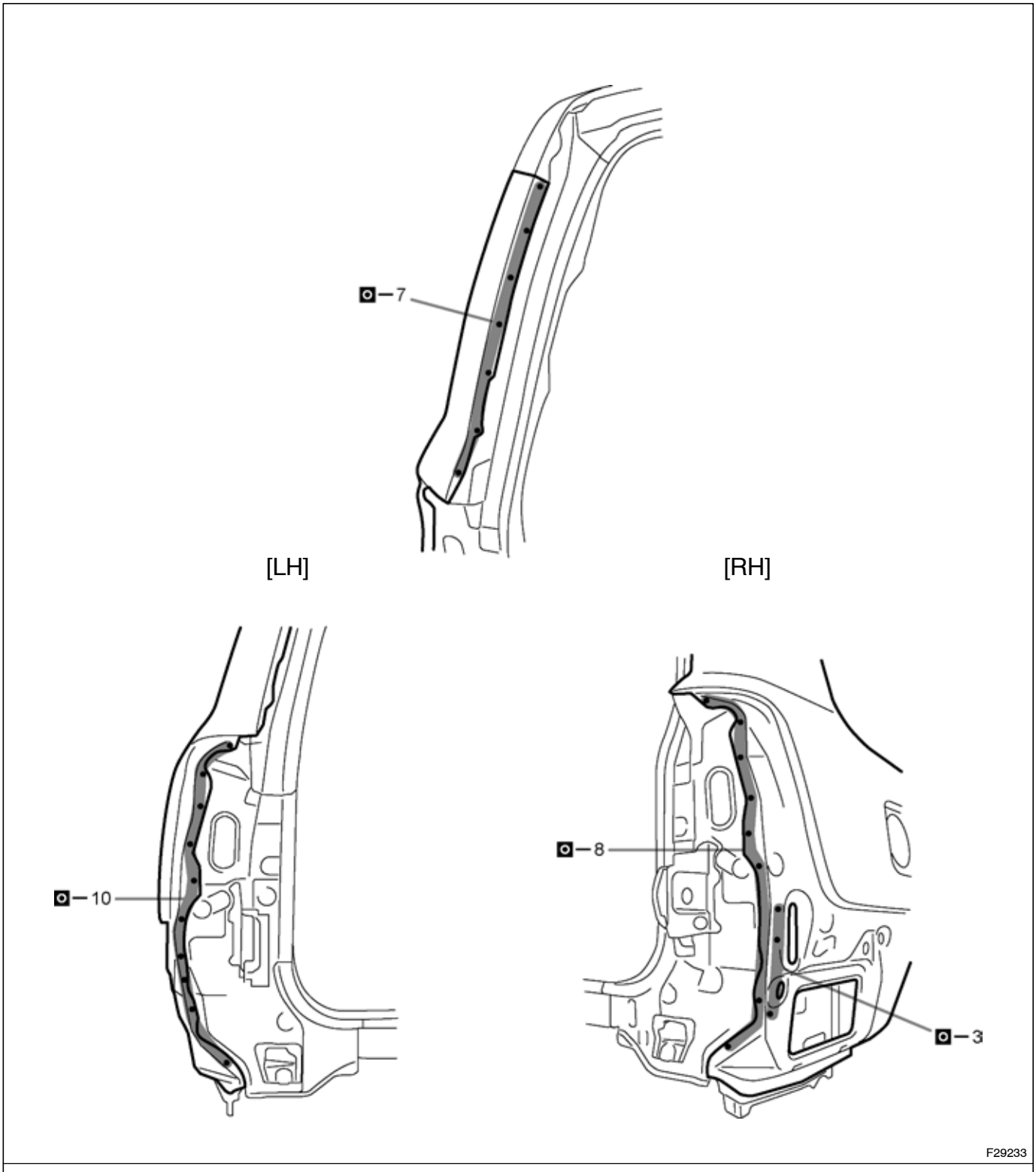
F29232

INSTALLATION POINT

1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.

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

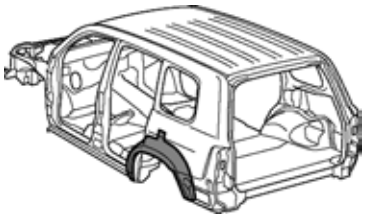
3 Before installing a new part, apply body sealer.
HINT:
- *Apply body sealer evenly about 5 mm (0.20 in.) from the flange, avoiding any oozing.*
- *Apply sealer evenly, about 3 – 4 mm (0.12 – 0.16 in.) in diameter.*



INSTALLATION POINT

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

QUARTER WHEEL HOUSING OUTER PANEL (ASSY)



F29234A

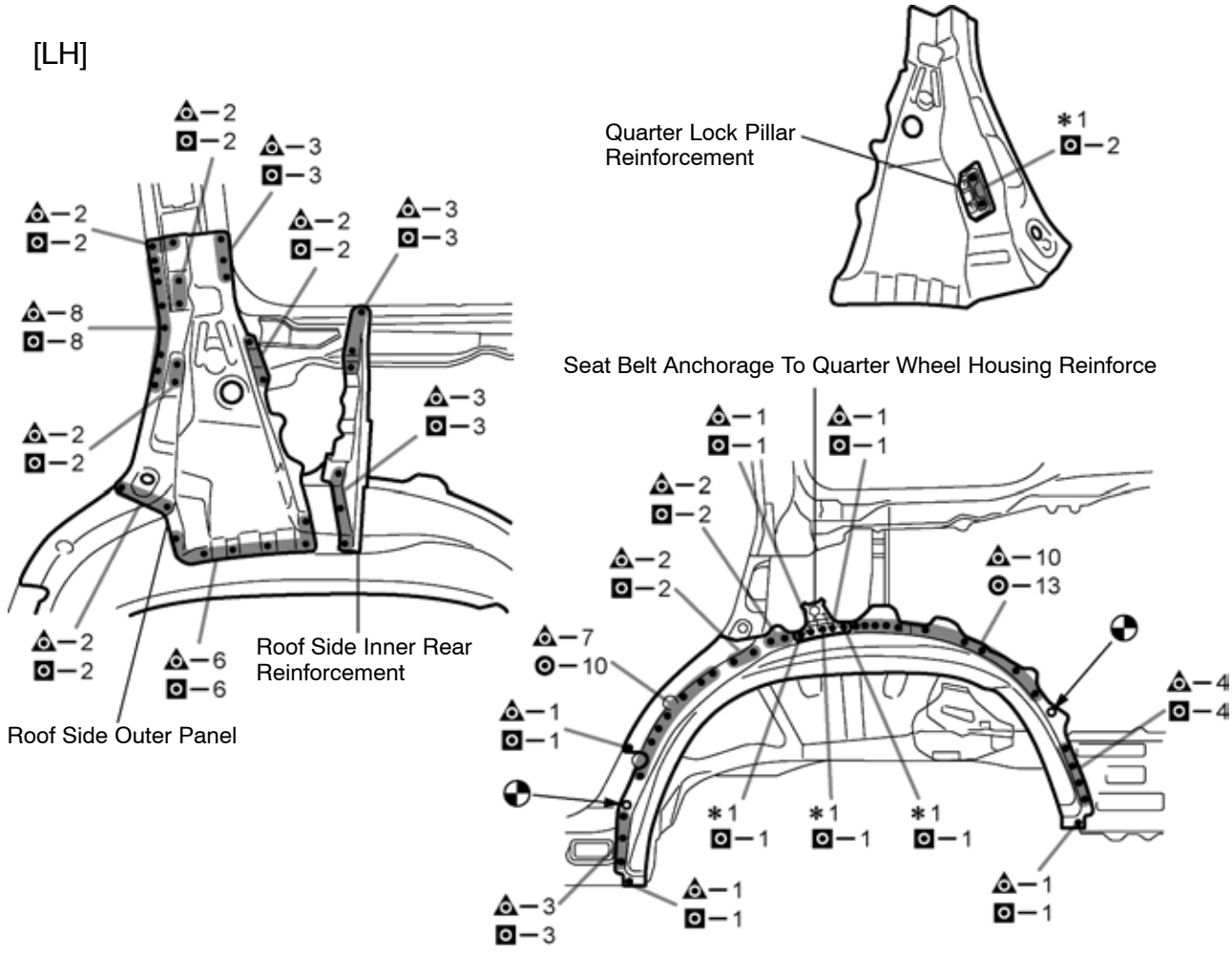
With the rocker panel No. 3 reinforcement and quarter panel removed.

Symbol meaning

REMOVAL	◬ : Remove Weld Points	
INSTALLATION	⊙ : Spot Weld	◘ : Plug Weld

F29234B

REMOVAL·INSTALLATION



F29234

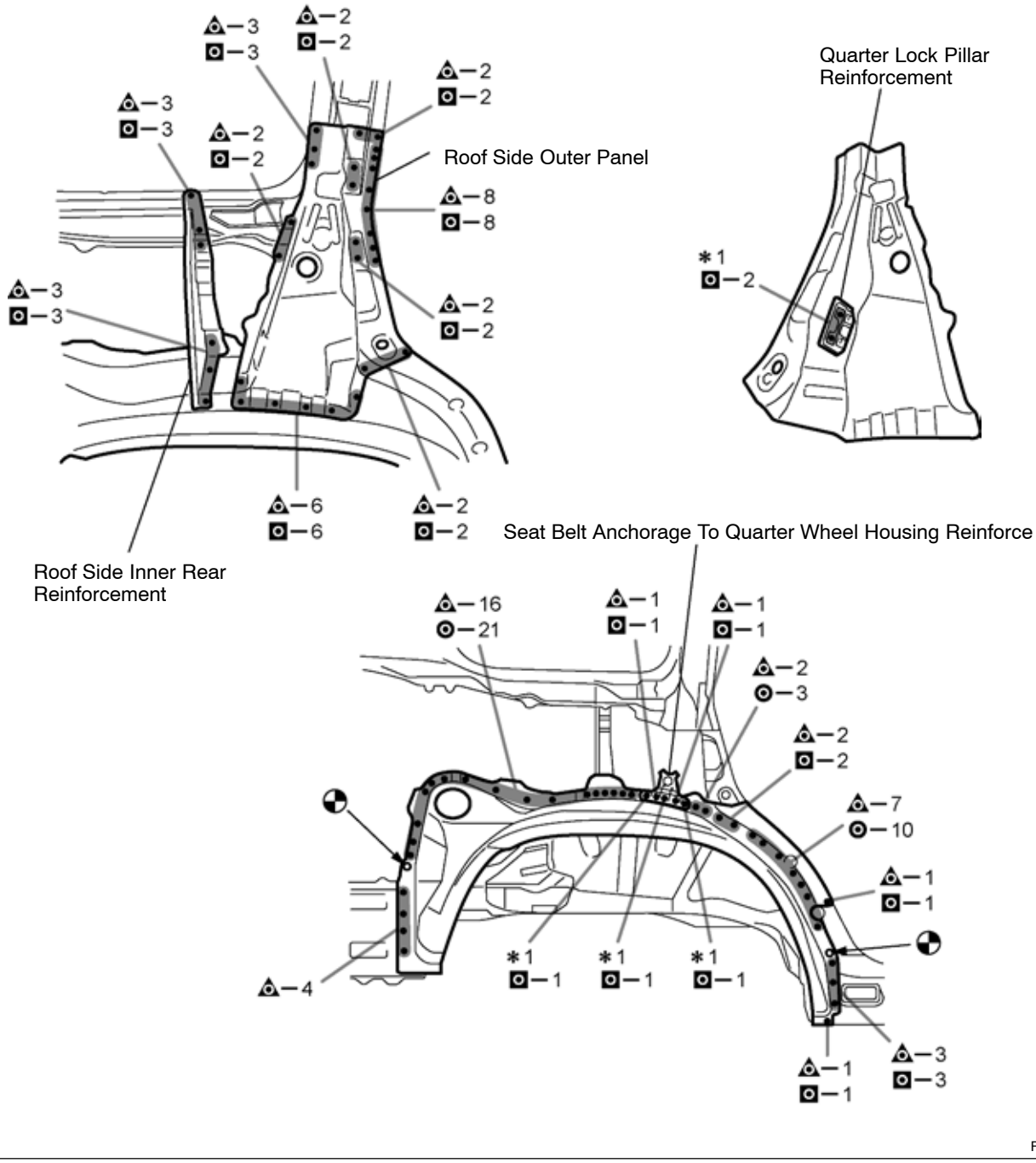
REMOVAL POINT

1 After removing the roof side outer panel and roof side inner rear reinforcement, remove the quarter wheel housing outer panel.
2 Remove the seat belt anchorage to quarter wheel housing reinforce at the same time.

INSTALLATION POINT

1 For positioning of the new parts, align the installation standard holes of the outer panel and the inner panel.
2 *1 is only for installation.
3 After welding the quarter wheel housing outer panel to the vehicle side, install the roof side outer panel and roof side inner rear reinforcement.
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.

[RH]



REMOVAL POINT

1 After removing the roof side outer panel and roof side inner rear reinforcement, remove the quarter wheel housing outer panel.
2 Remove the seat belt anchorage to quarter wheel housing reinforce at the same time.

INSTALLATION POINT

1 For positioning of the new parts, align the installation standard holes of the outer panel and the inner panel.
2 *1 is only for installation.
3 After welding the quarter wheel housing outer panel to the vehicle side, install the roof side outer panel and roof side inner rear reinforcement.
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.

QUARTER PANEL FRONT EXTENSION (ASSY)



F29236A

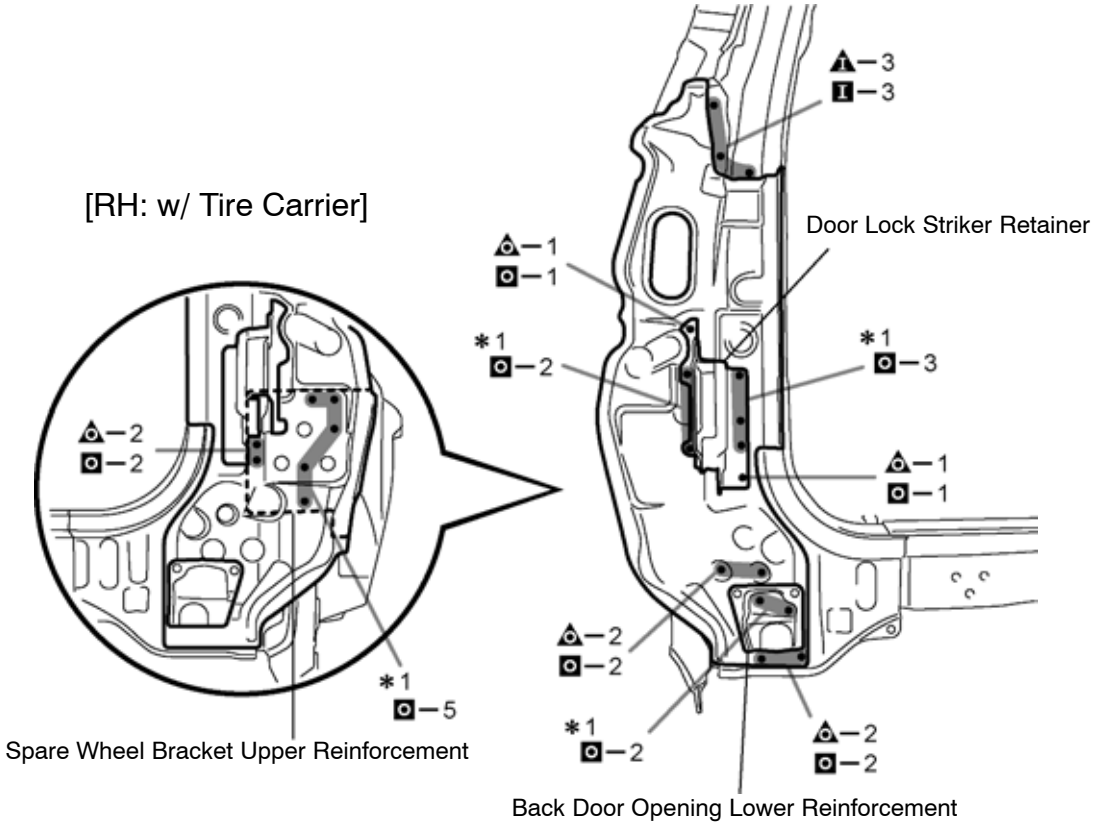
With the quarter panel removed.

Symbol meaning

REMOVAL	: Remove Weld Points
INSTALLATION	: Plug Weld

F29236B

REMOVAL·INSTALLATION



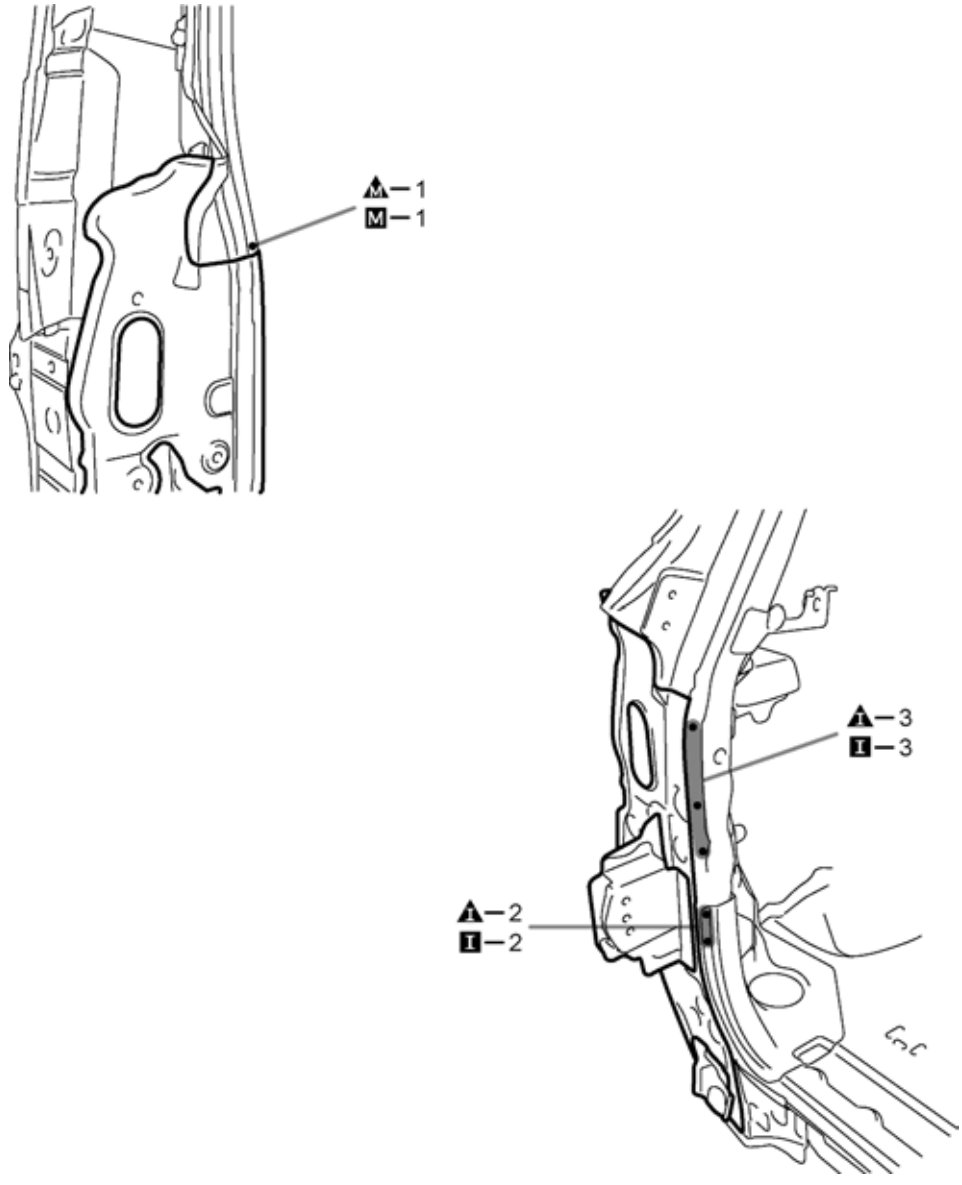
F29236

REMOVAL POINT

1 Remove the door lock striker retainer and spare wheel bracket upper reinforcement at the same time.

INSTALLATION POINT

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

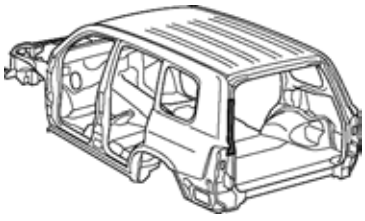


F29237

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.

BACK DOOR OPENING UPPER REINFORCEMENT (CUT)



F29238A

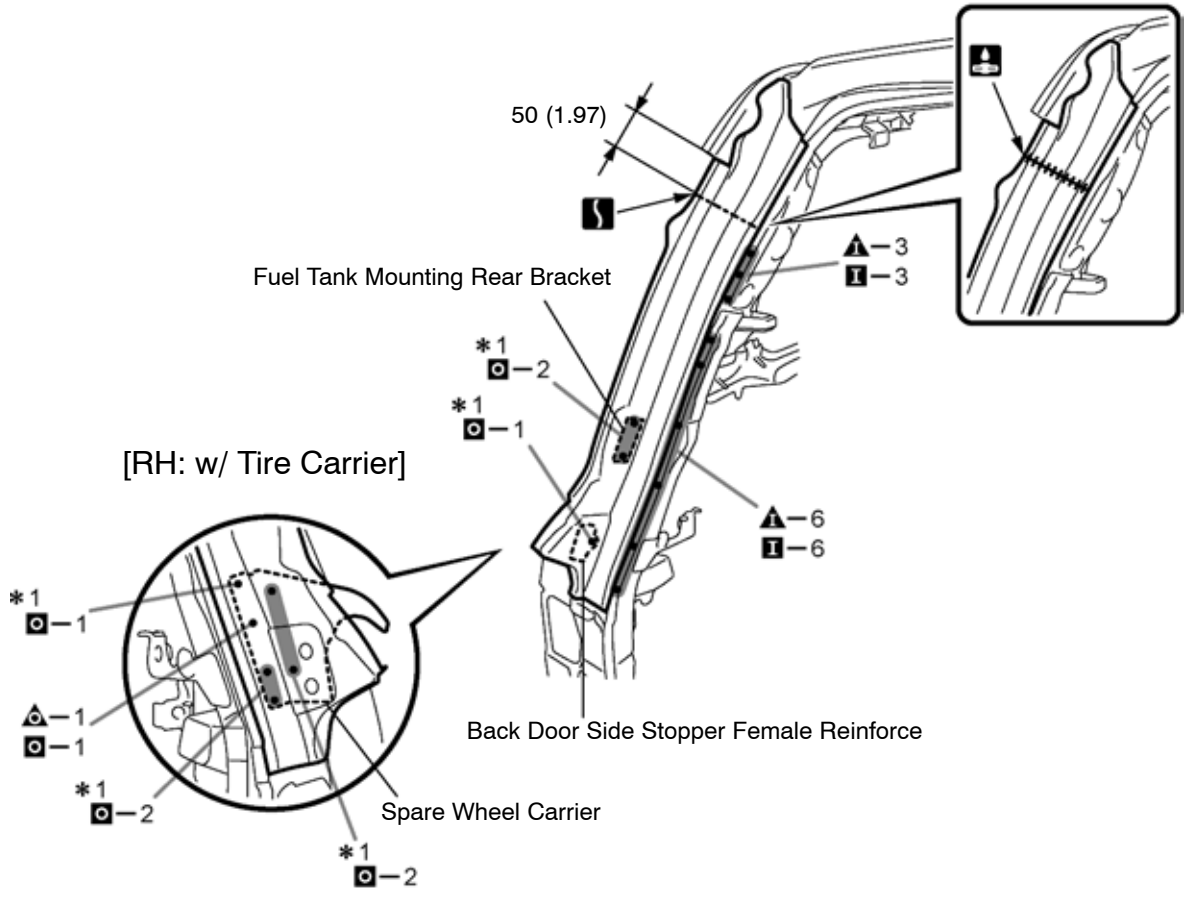
With the quarter panel front extension removed.

Symbol meaning

REMOVAL	▲ : Remove Weld Points	: Cut and Join Location
INSTALLATION	○ I : Plug Weld	: Butt Weld

F29238B

REMOVAL·INSTALLATION



mm (in.)

F29238

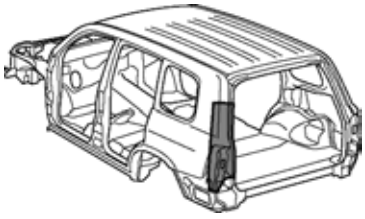
REMOVAL POINT

1 Remove the spare wheel carrier at the same time.

INSTALLATION POINT

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

QUARTER PANEL REINFORCEMENT (CUT)



F29239A

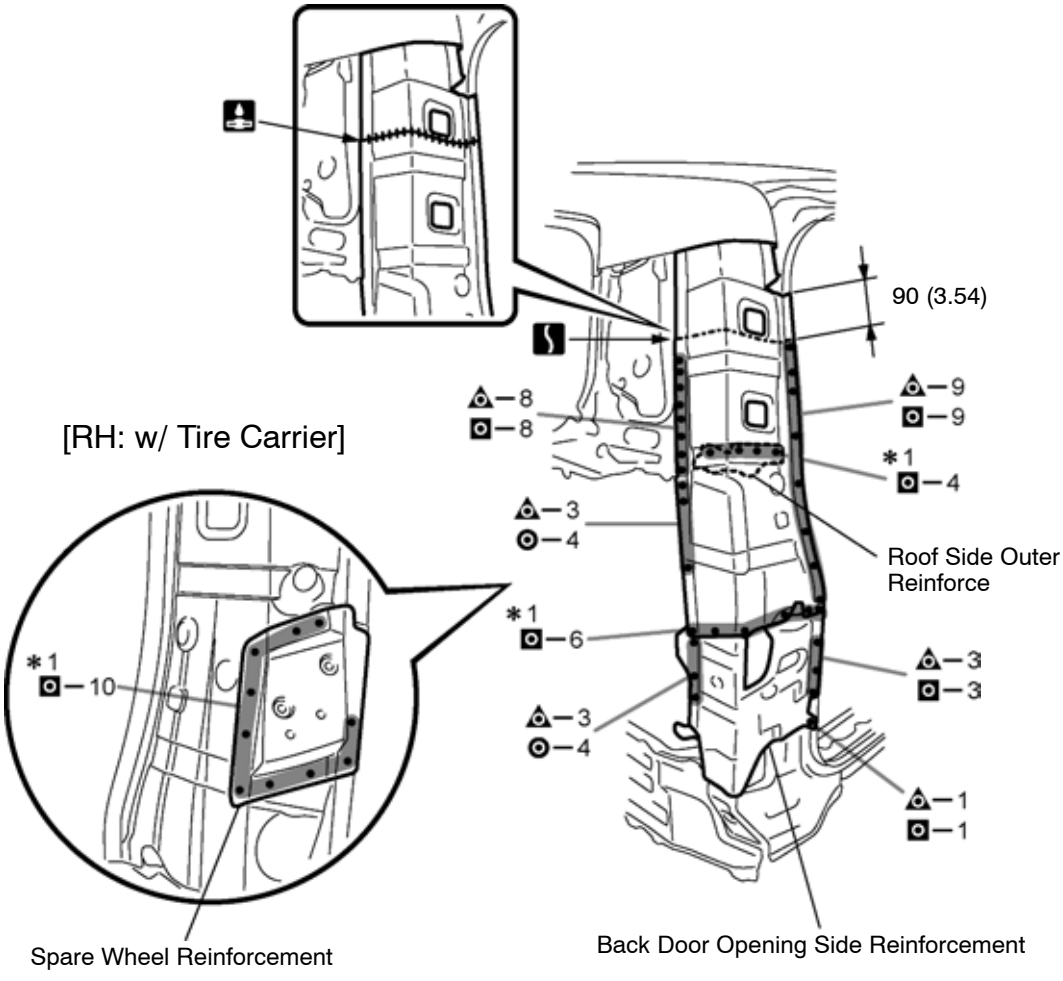
With the back door opening upper reinforcement removed.

Symbol meaning

REMOVAL	: Remove Weld Points	: Cut and Join Location	
INSTALLATION	: Spot Weld	: Plug Weld	: Butt Weld

F29239B

REMOVAL·INSTALLATION



mm (in.)

F29239

REMOVAL POINT

1 Remove the roof side outer reinforce, back door opening side reinforcement and spare wheel reinforcement at the same time.

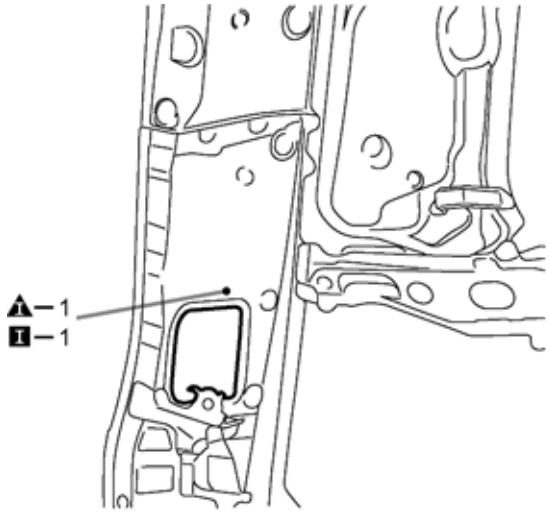
INSTALLATION POINT

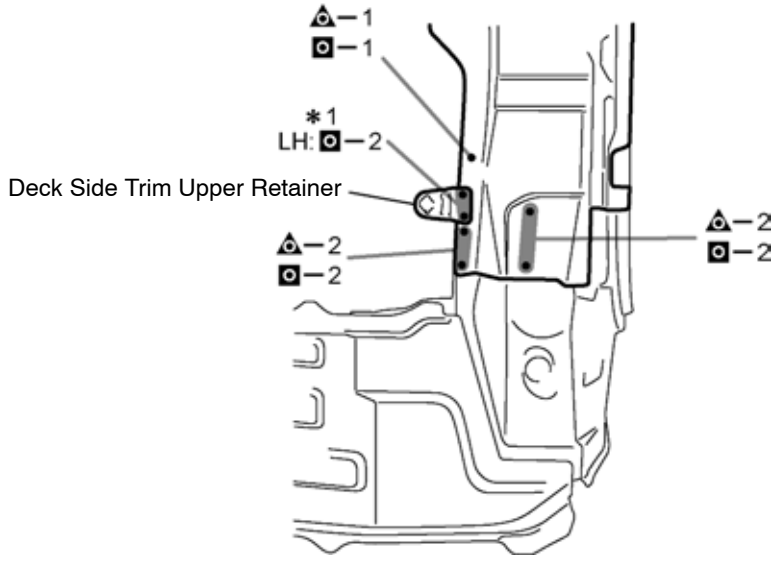
1 *1 is only for installation.

Symbol meaning

REMOVAL	: Remove Weld Points	: Cut and Join Location
INSTALLATION	: Spot Weld : Plug Weld	: Butt Weld

F29239B





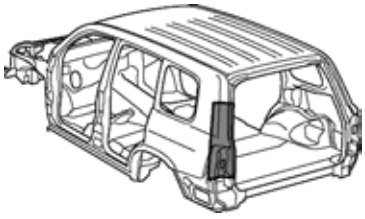
F29240

INSTALLATION POINT

1 *1 is only for installation.

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

ROOF SIDE INNER REAR PANEL (ASSY)



F29241A

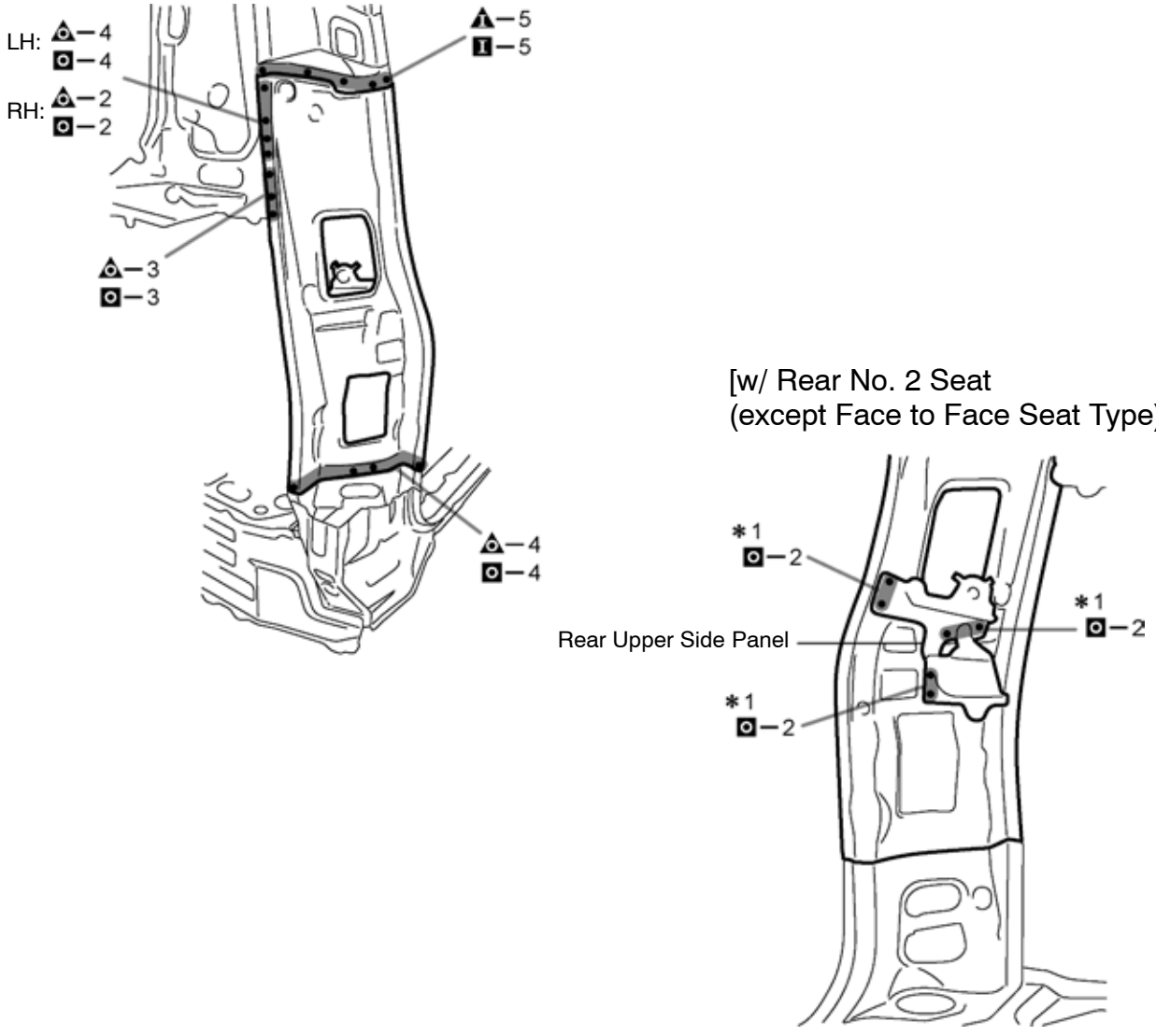
With the quarter panel reinforcement removed.

Symbol meaning

REMOVAL	: Remove Weld Points
INSTALLATION	: Plug Weld

F29241B

REMOVAL·INSTALLATION

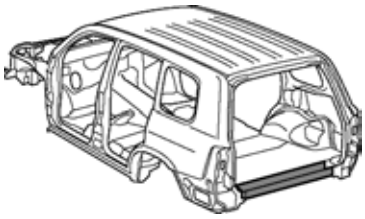


F29241

INSTALLATION POINT

1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
2 *1 is only for installation.
3 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

BODY LOWER BACK PANEL (CUT)



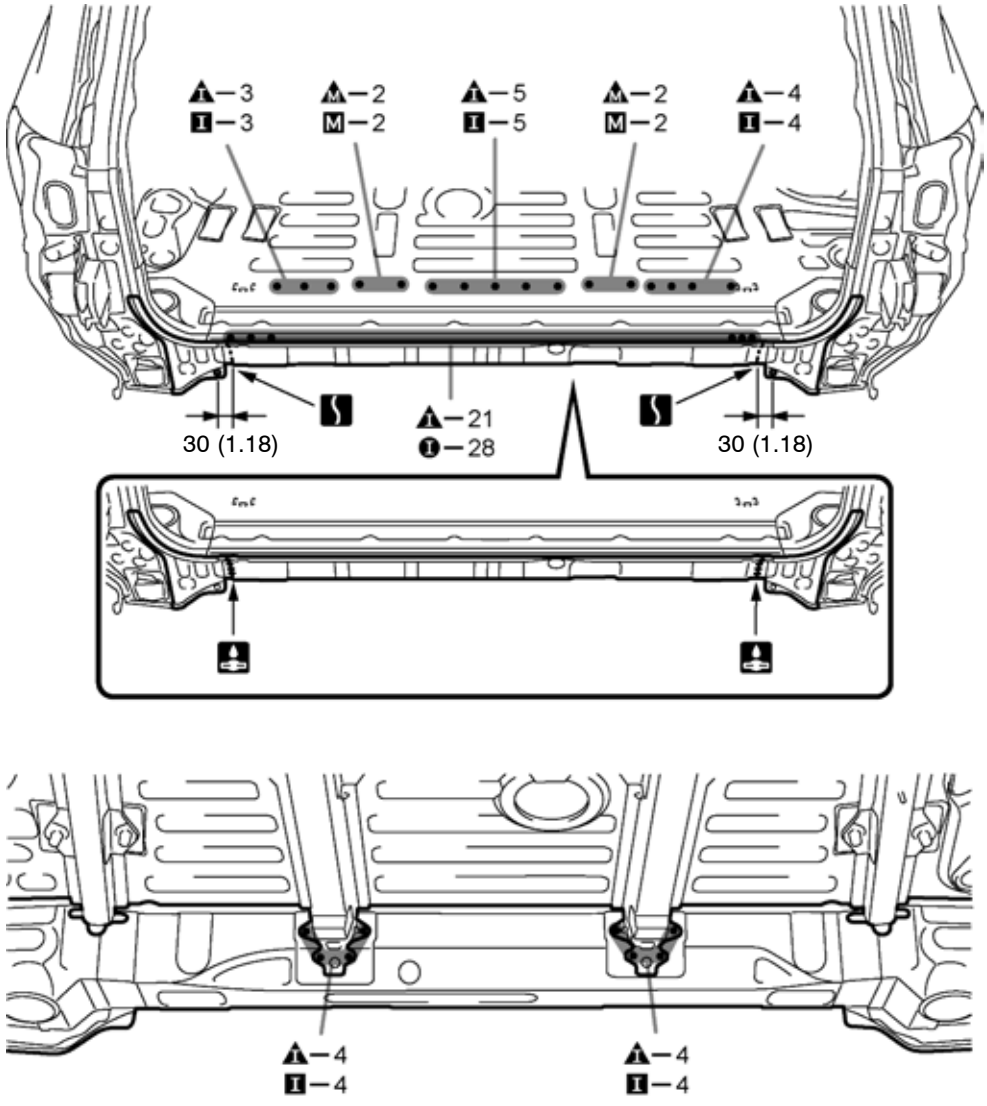
F29242A

Symbol meaning

REMOVAL	: Remove Weld Points	: Cut and Join Location
INSTALLATION	: Spot Weld : Plug Weld	: Butt Weld

F29242B

REMOVAL·INSTALLATION



mm (in.)

F29242

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 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.

BODY LOWER BACK PANEL (ASSY)



F29243A

With the quarter panel front extension removed.

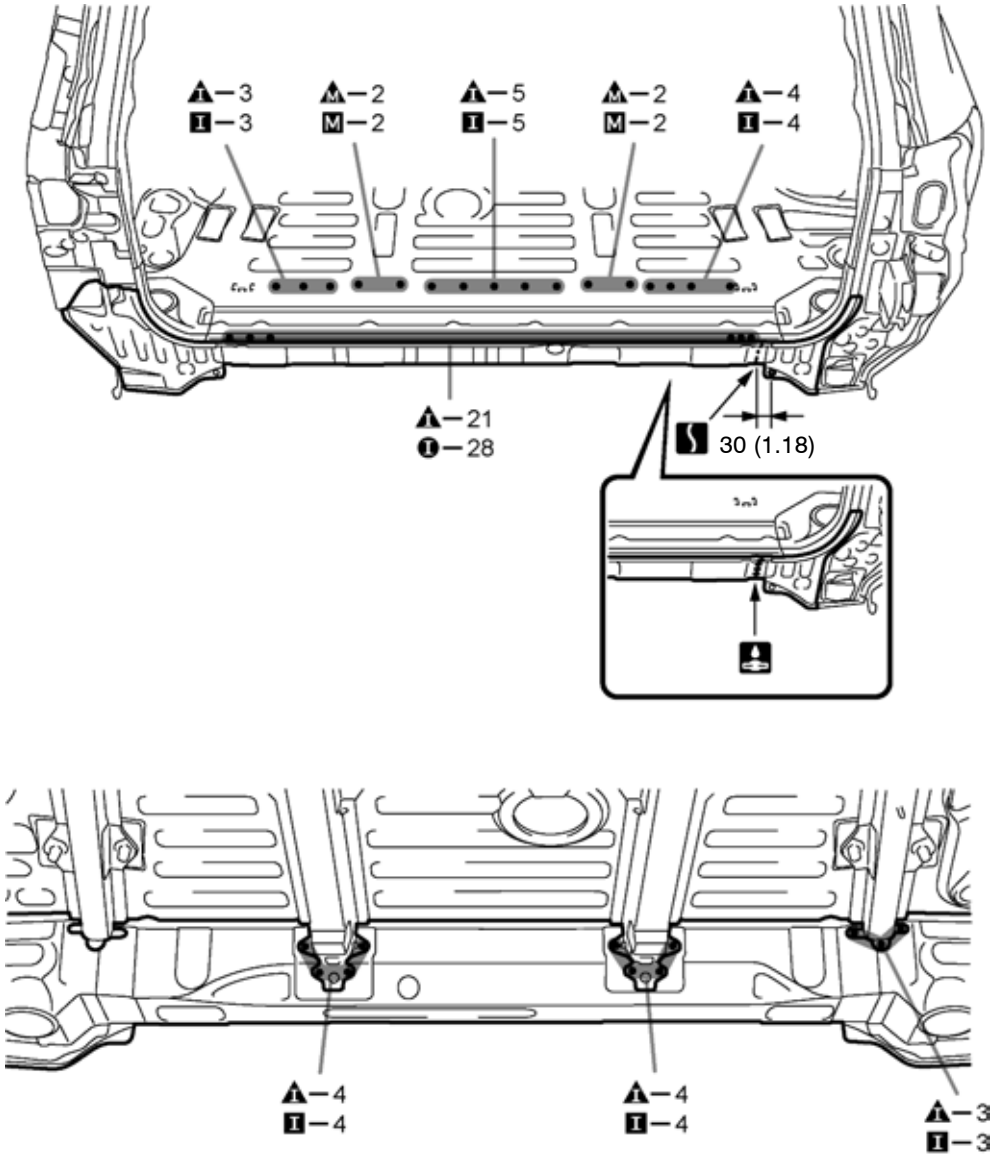
Symbol meaning

REMOVAL : Remove Weld Points : Cut and Join Location

INSTALLATION : Spot Weld : Plug Weld : Butt Weld

F29243B

REMOVAL·INSTALLATION



F29243

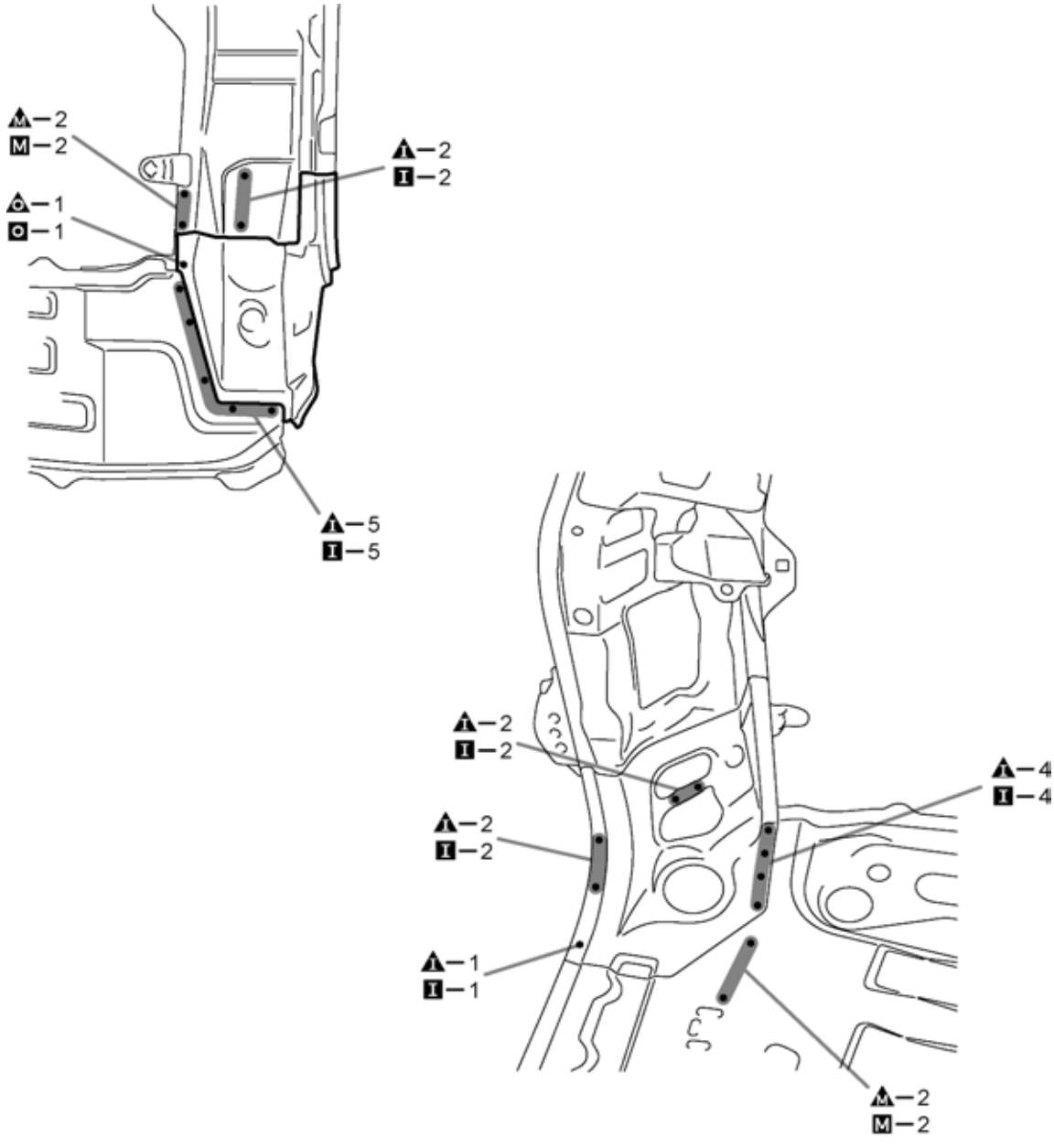
INSTALLATION POINT

1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.

Symbol meaning

REMOVAL	A M A : Remove Weld Points	: Cut and Join Location
INSTALLATION	T : Spot Weld	O M I : Plug Weld : Butt Weld

F29243B



F29244

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.

REAR FLOOR SIDE PANEL (ASSY)



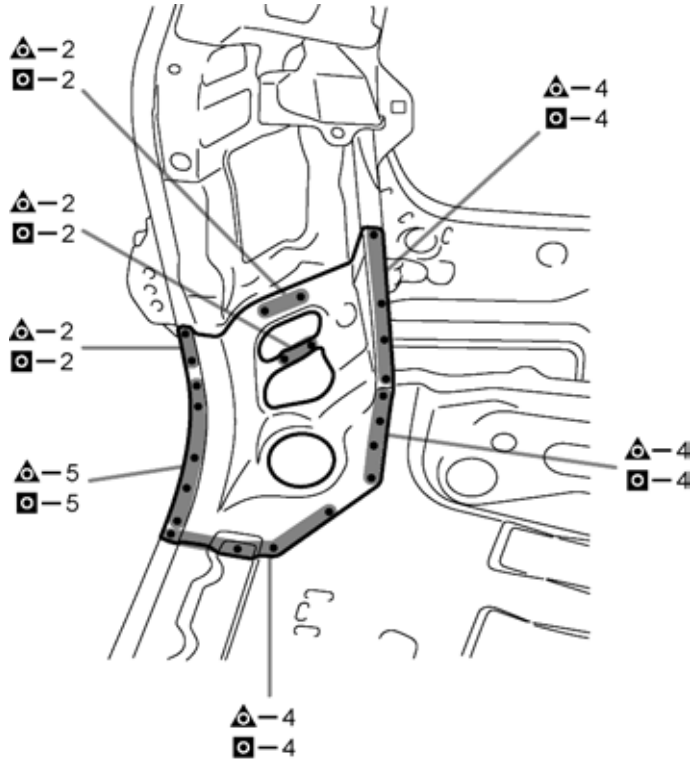
F29245A

Symbol meaning

REMOVAL	▲ : Remove Weld Points
INSTALLATION	● : Plug Weld

F29245B

REMOVAL·INSTALLATION

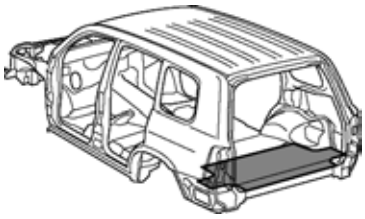


F29245

INSTALLATION POINT

1 After welding, apply body sealer 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 (CUT)



F29246A

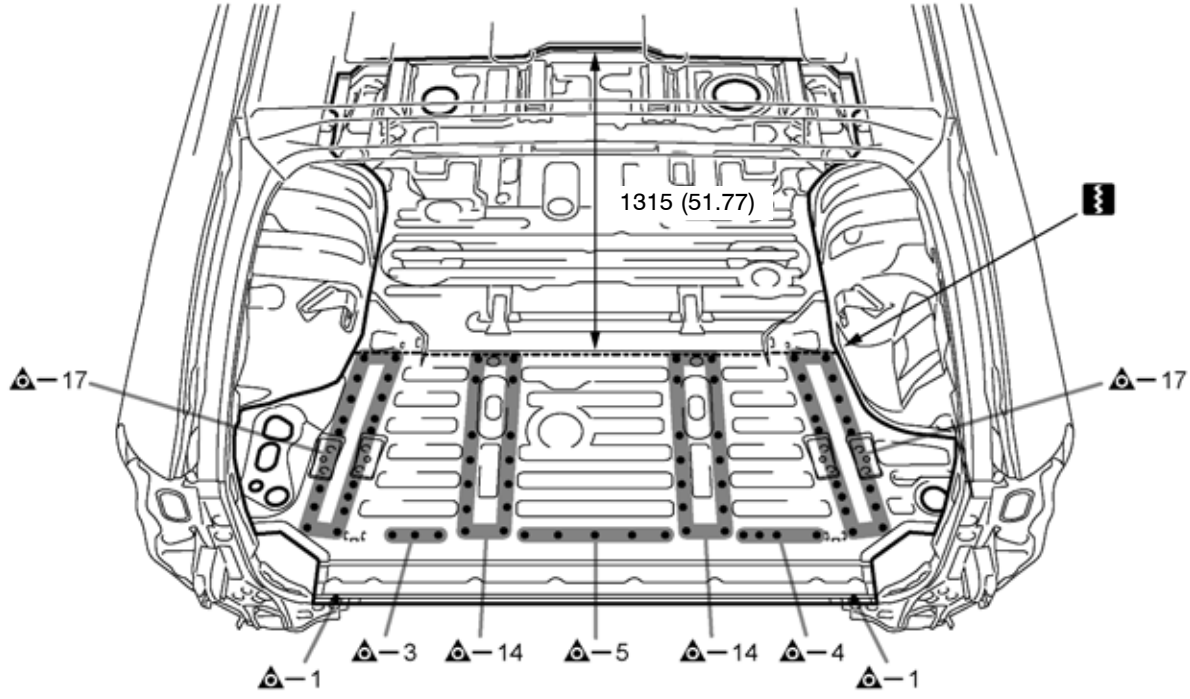
With the body lower back panel and rear foor side panel removed.

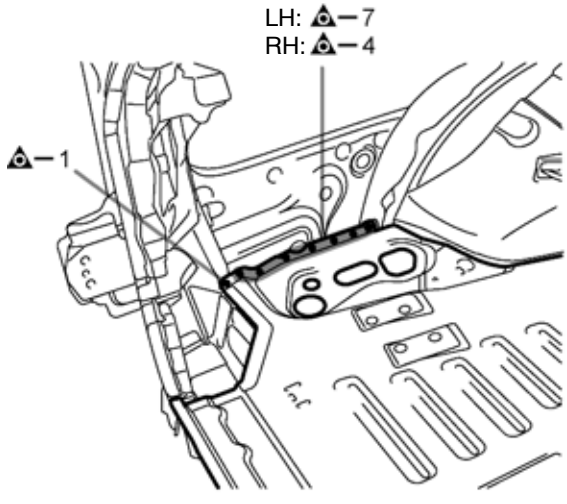
Symbol meaning

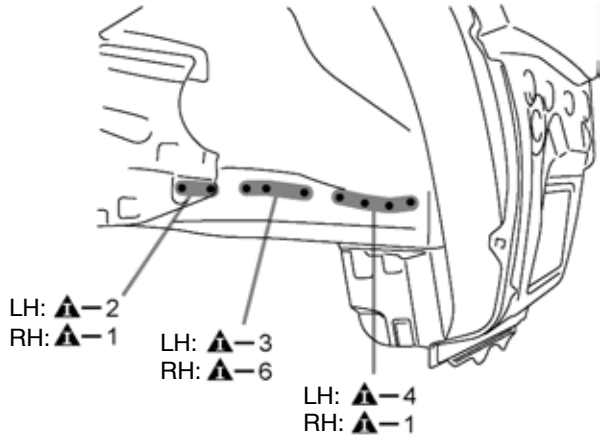
: Remove Weld Points : Cut Location

F29246B

REMOVAL







mm (in.)

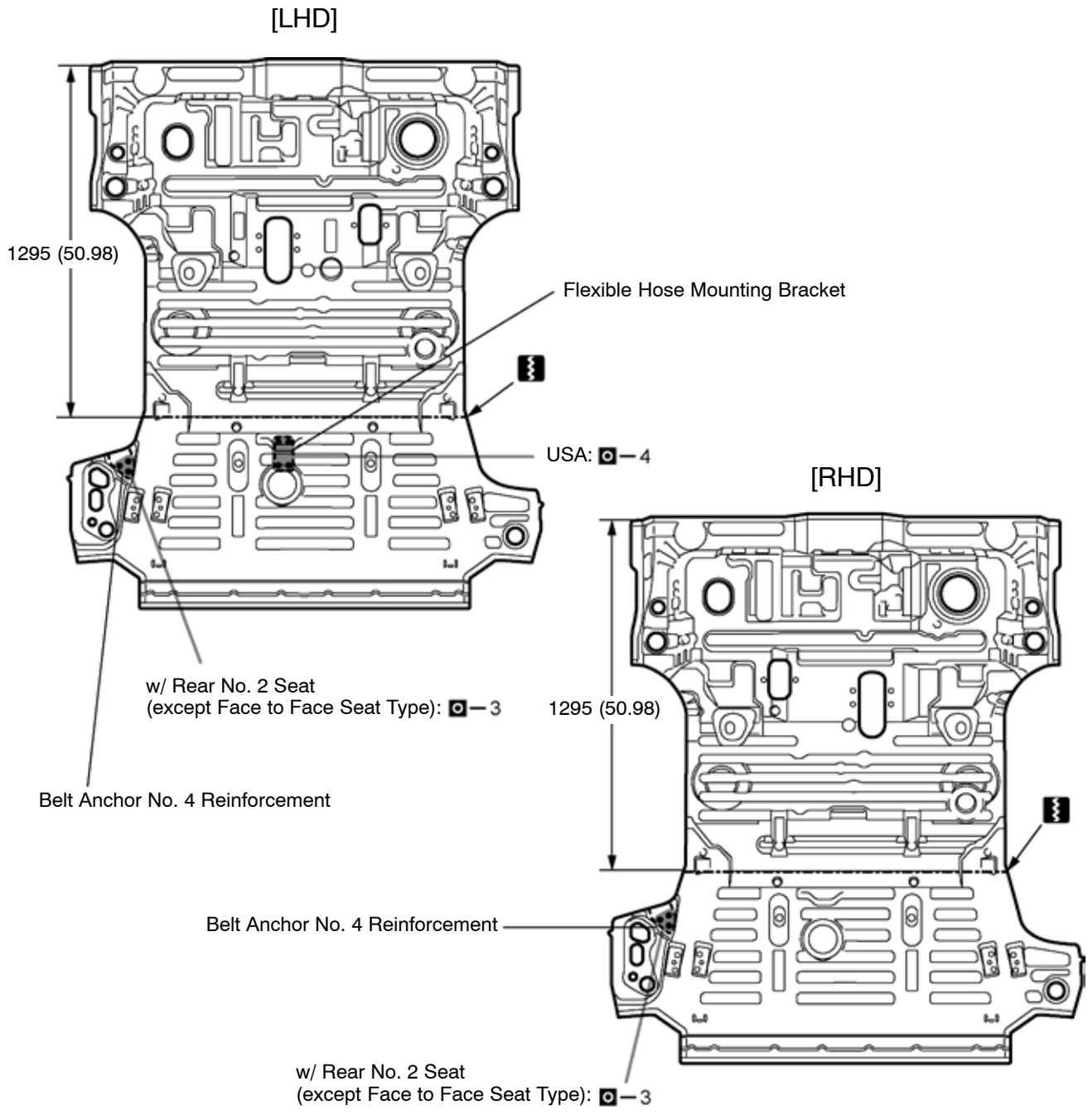
F29246

Symbol meaning

: Plug Weld : Cut Location : Body Sealer

F29247B

INSTALLATION



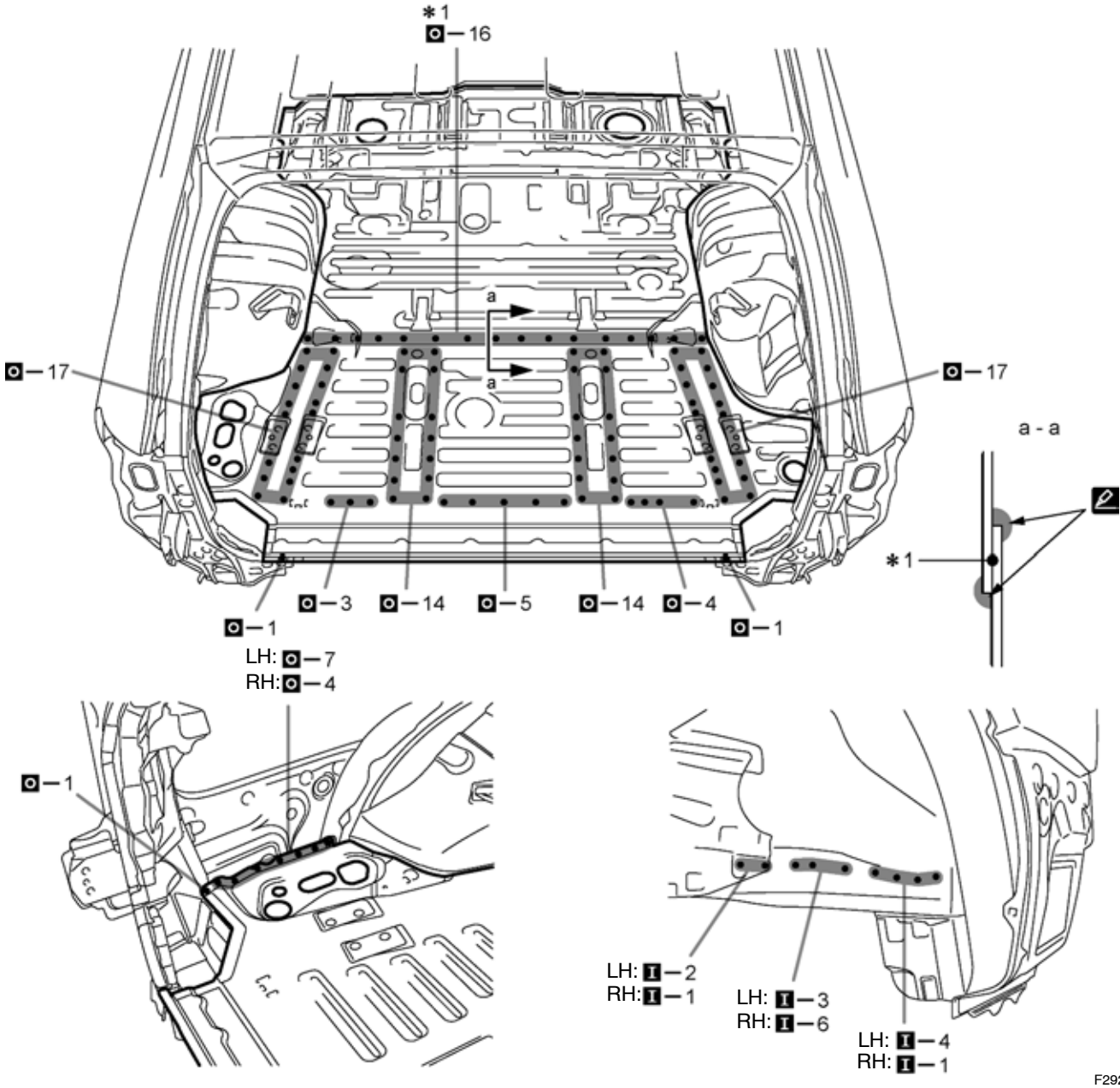
INSTALLATION POINT

1 Cut the new part so that it overlaps the previous cut location by approximately 20 mm (0.79 in).
2 Before temporarily installing the new parts, weld the belt anchor No. 4 reinforcement and flexible hose mounting bracket with the standard number of welding points.

Symbol meaning

: Plug Weld : Cut Location : Body Sealer

F29247B



F29248

INSTALLATION POINT

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

2 *1: Perform plug-welding in the area where the panel are overlapped. Apply body sealer to both sides of each panel.

HINT:

- *Confirm that the panels are securely welded together.*
- *Apply sealer in an even, continuous bead.*

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 REAR EXTENSION (ASSY)



F29249A

With the quarter panel removed.

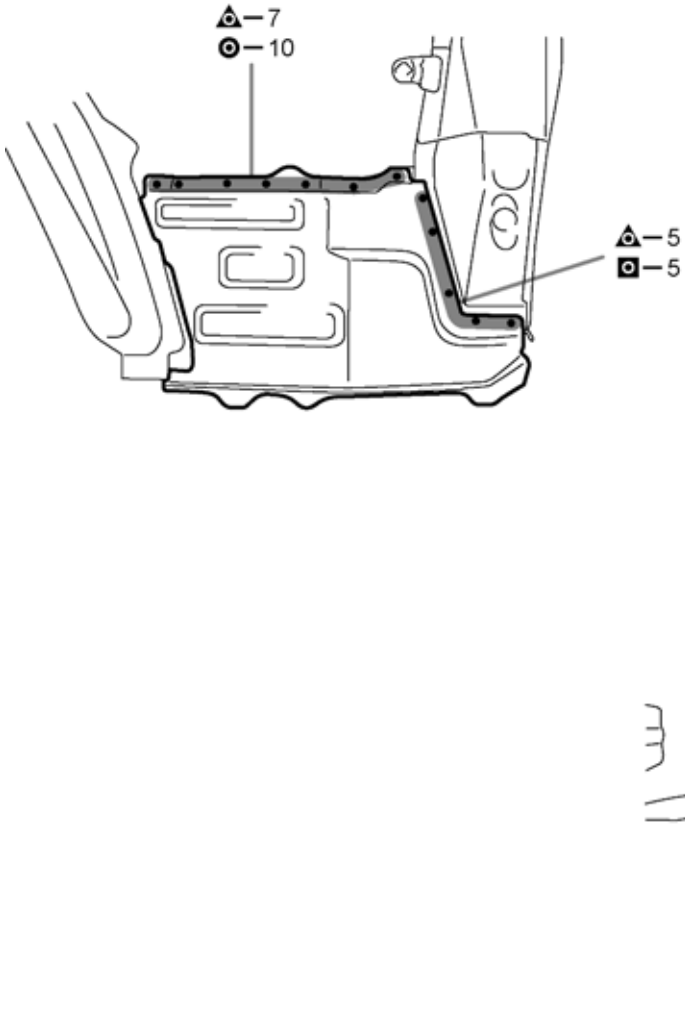
Symbol meaning

REMOVAL	▲ ▲ : Remove Weld Points
INSTALLATION	● ❶ : Spot Weld ■ ❶ : Plug Weld

F29249B

REMOVAL·INSTALLATION

[LH]



F29249

INSTALLATION POINT

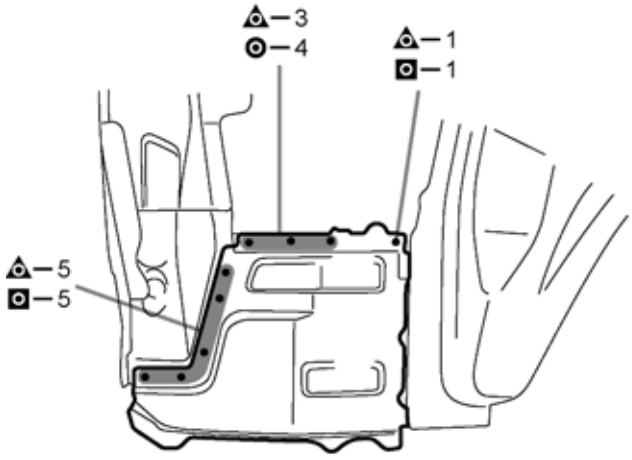
1 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
2 After welding, apply undercoating to the corresponding parts. (See the paint·coating)
3 After applying the top coat, apply anti-rust agent to the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

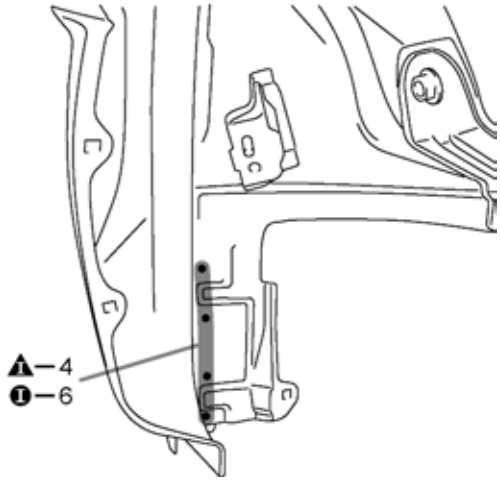
Symbol meaning

REMOVAL	: Remove Weld Points
INSTALLATION	: Spot Weld : Plug Weld

F29249B

[RH]



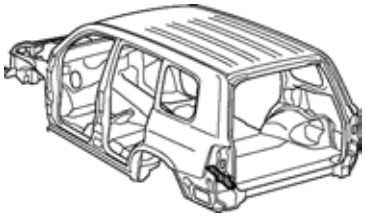


F29250

INSTALLATION POINT

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

REAR FLOOR SIDE MEMBER (ASSY)



F29251A

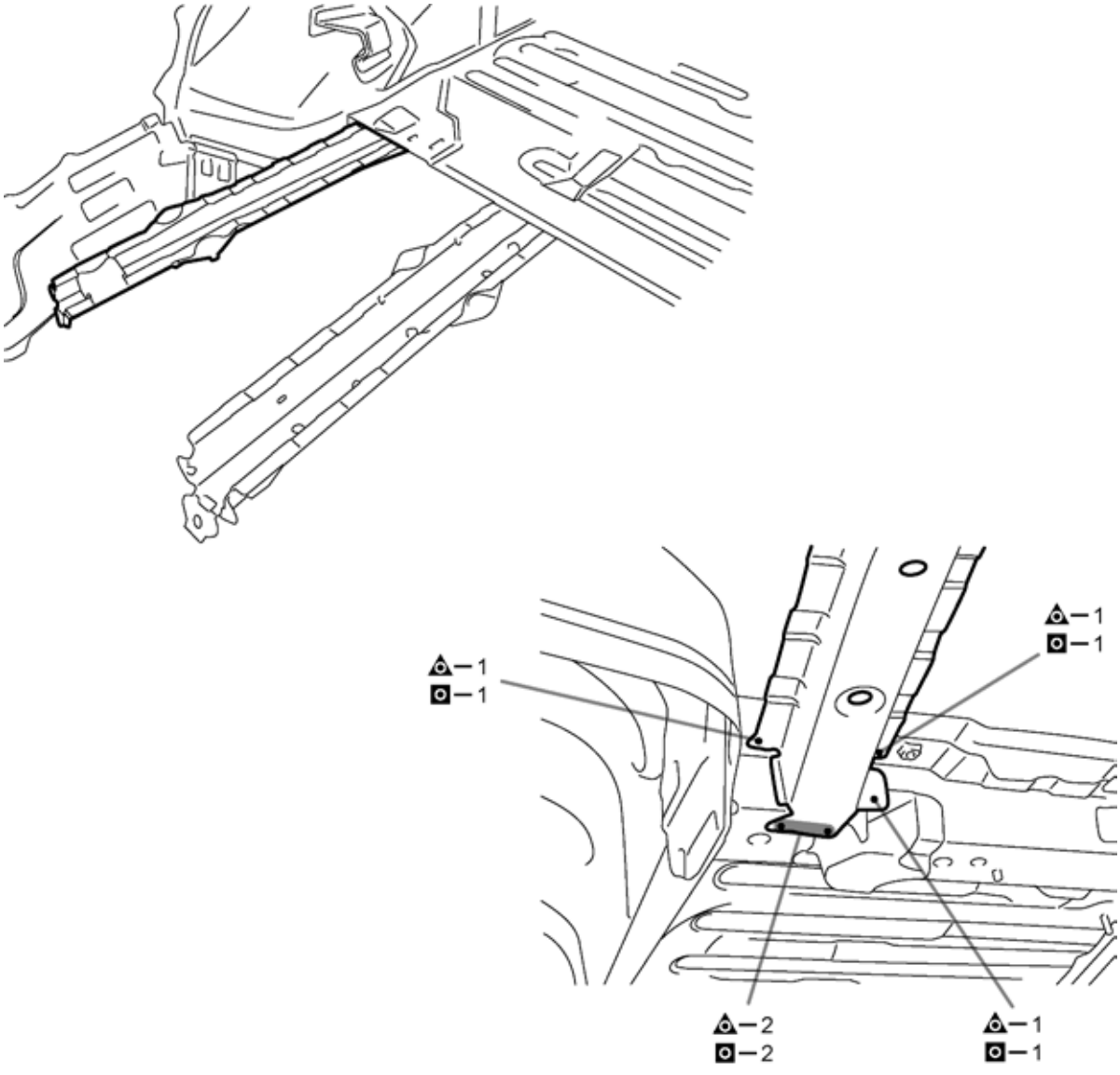
With the rear floor pan removed.

Symbol meaning

REMOVAL	: Remove Weld Points
INSTALLATION	: Plug Weld

F29251B

REMOVAL·INSTALLATION



F29251

INSTALLATION POINT

1 After welding, apply 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 NO. 5 CROSSMEMBER (ASSY)



F29252A

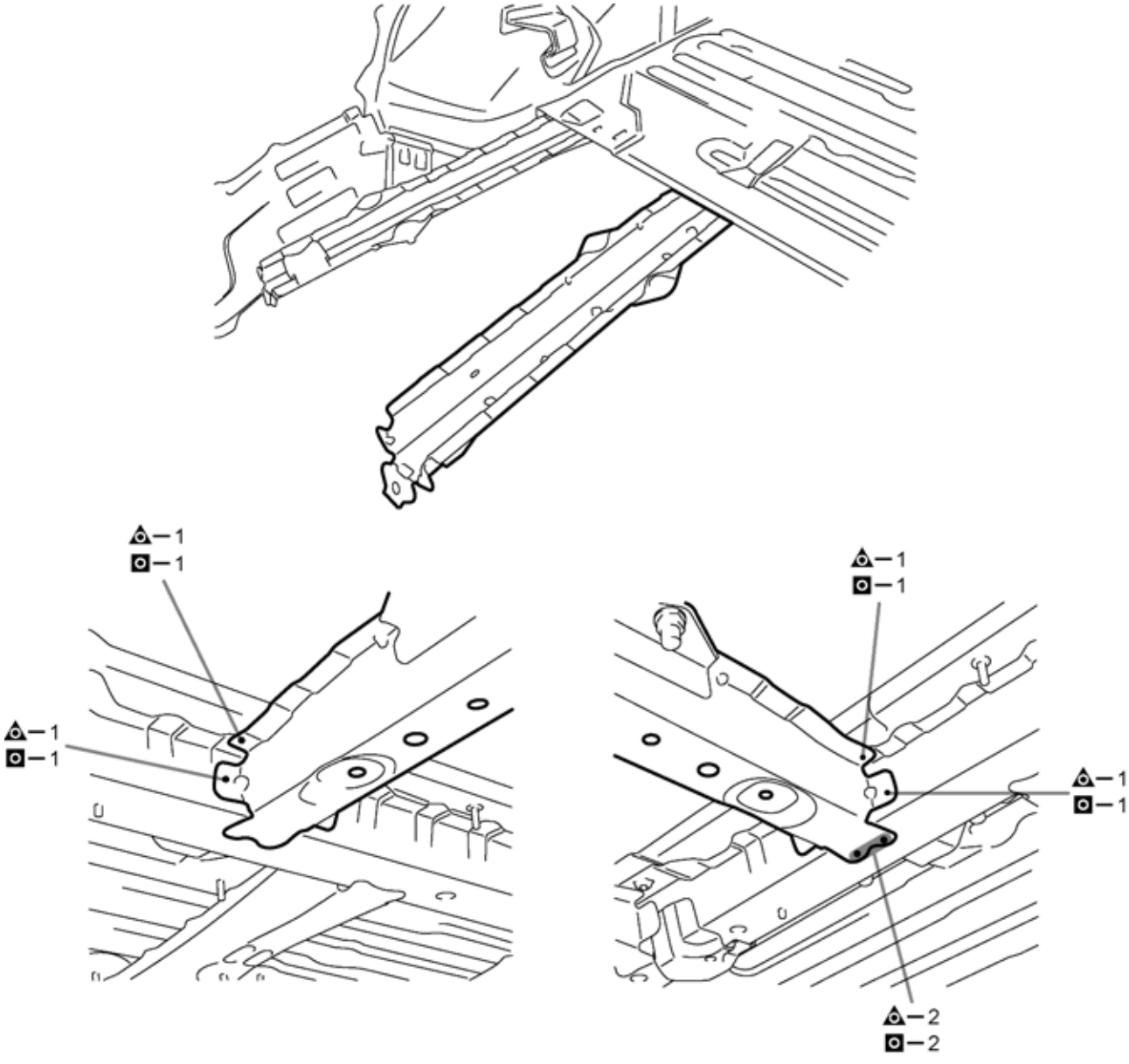
With the rear floor pan removed.

Symbol meaning

REMOVAL	: Remove Weld Points
INSTALLATION	: Plug Weld

F29252B

REMOVAL·INSTALLATION



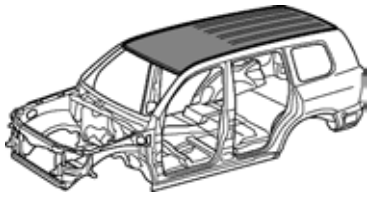
F29252

INSTALLATION POINT

1 After welding, apply 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.

ROOF PANEL (ASSY): Normal Roof



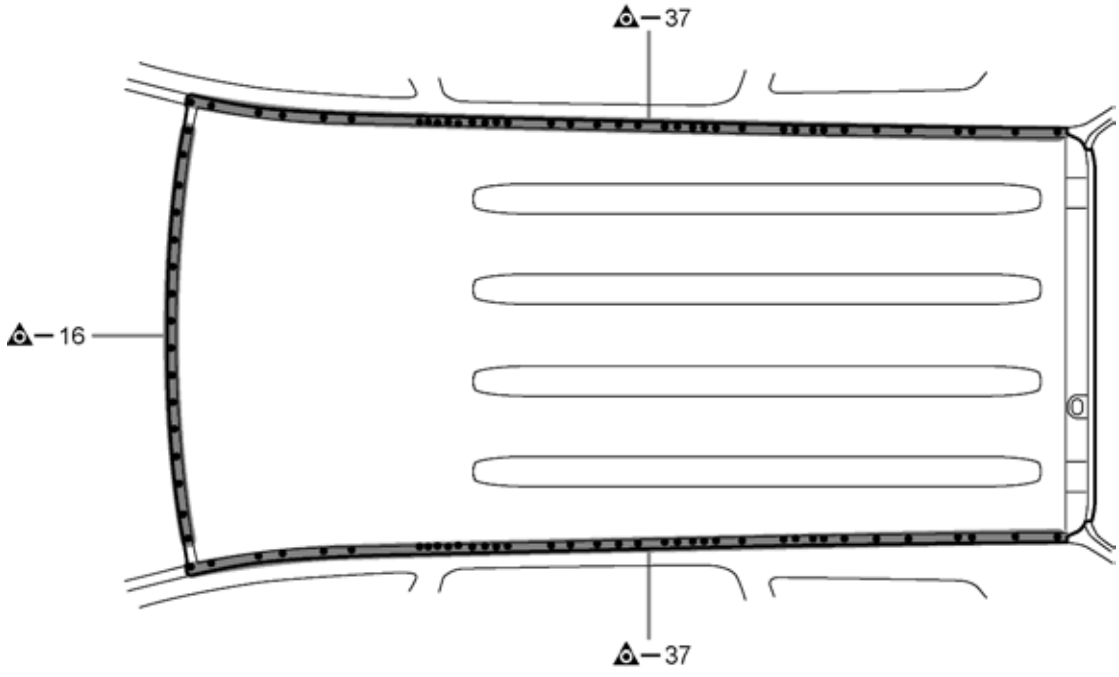
F29253A

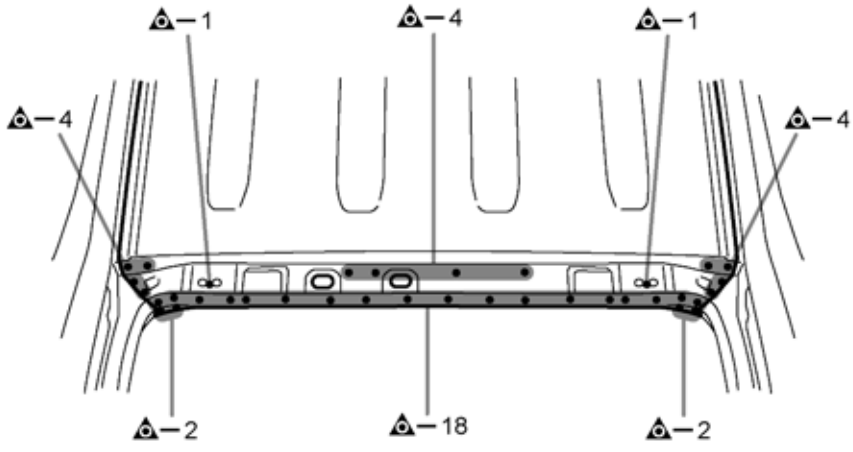
Symbol meaning

: Remove Weld Points

F29253B

REMOVAL





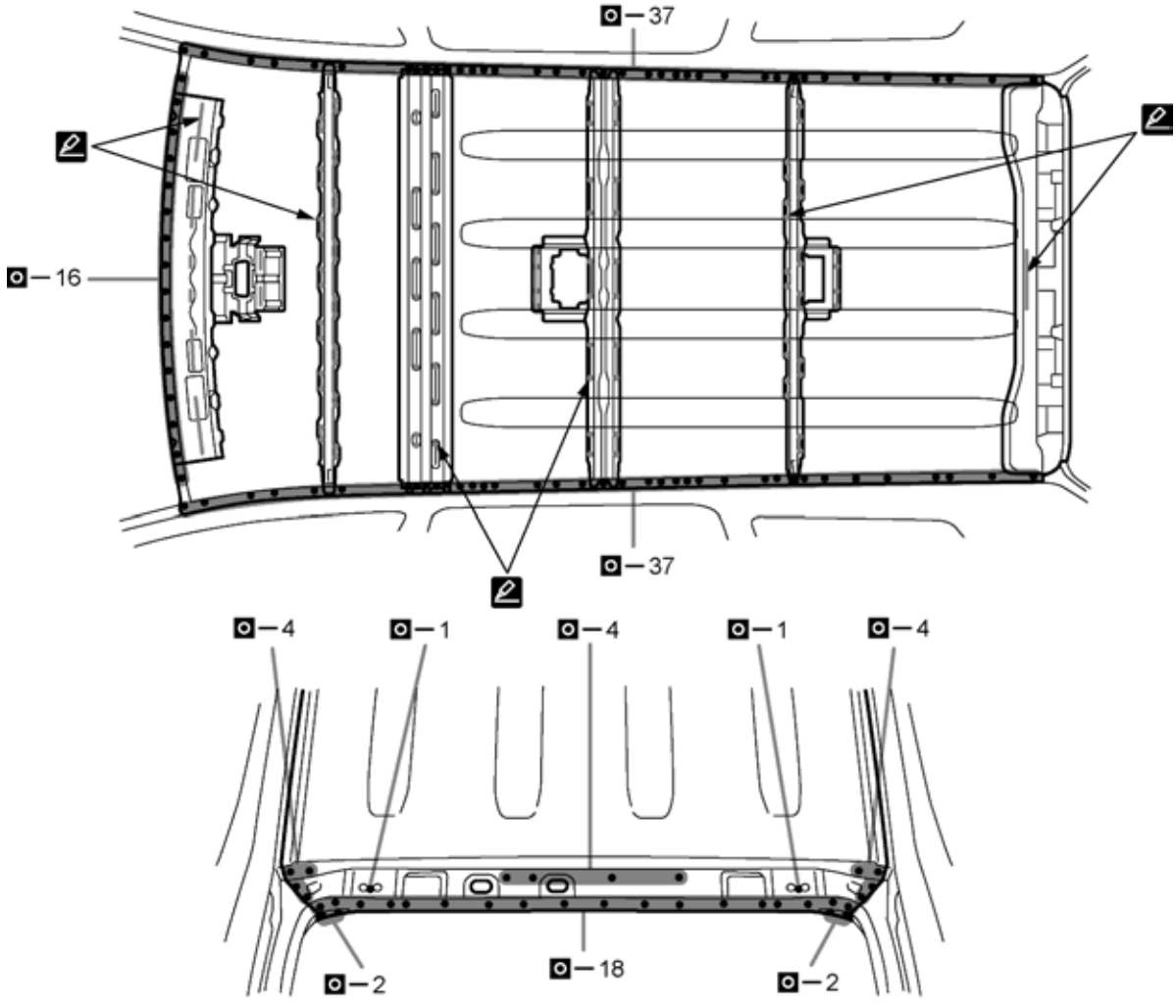
F29253

Symbol meaning

: Plug Weld : Body Sealer

F29254B

INSTALLATION

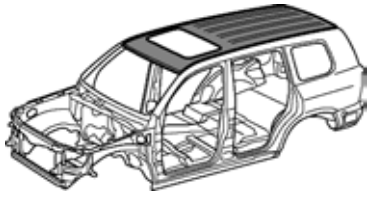


F29254

INSTALLATION POINT

1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
3 After the roof panel reinforcement is welded to the new parts, install the roof panel to the vehicle side.
4 Before temporarily installing the new parts, apply body sealer to the windshield header panel, roof panel reinforcement and back door opening frame.
HINT:
Apply just enough sealer for the new parts to make contact.
5 After welding, apply the foamed sealing material to the corresponding parts. (See the paint·coating)
6 After welding, apply body sealer to the corresponding parts. (See the paint·coating)
7 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

ROOF PANEL (ASSY): Moon Roof



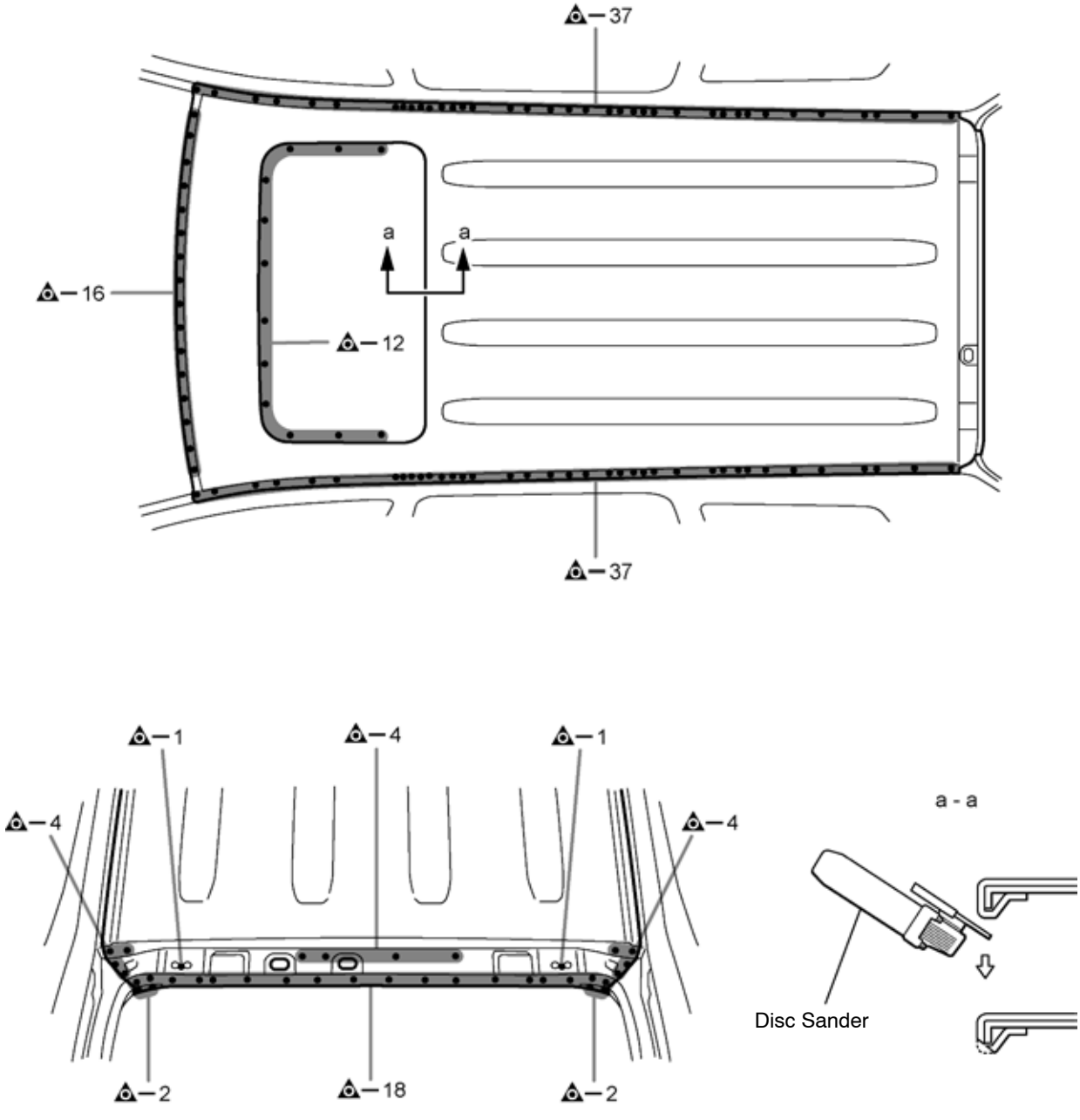
F29255A

Symbol meaning

: Remove Weld Points

F29255B

REMOVAL



F29255

REMOVAL POINT

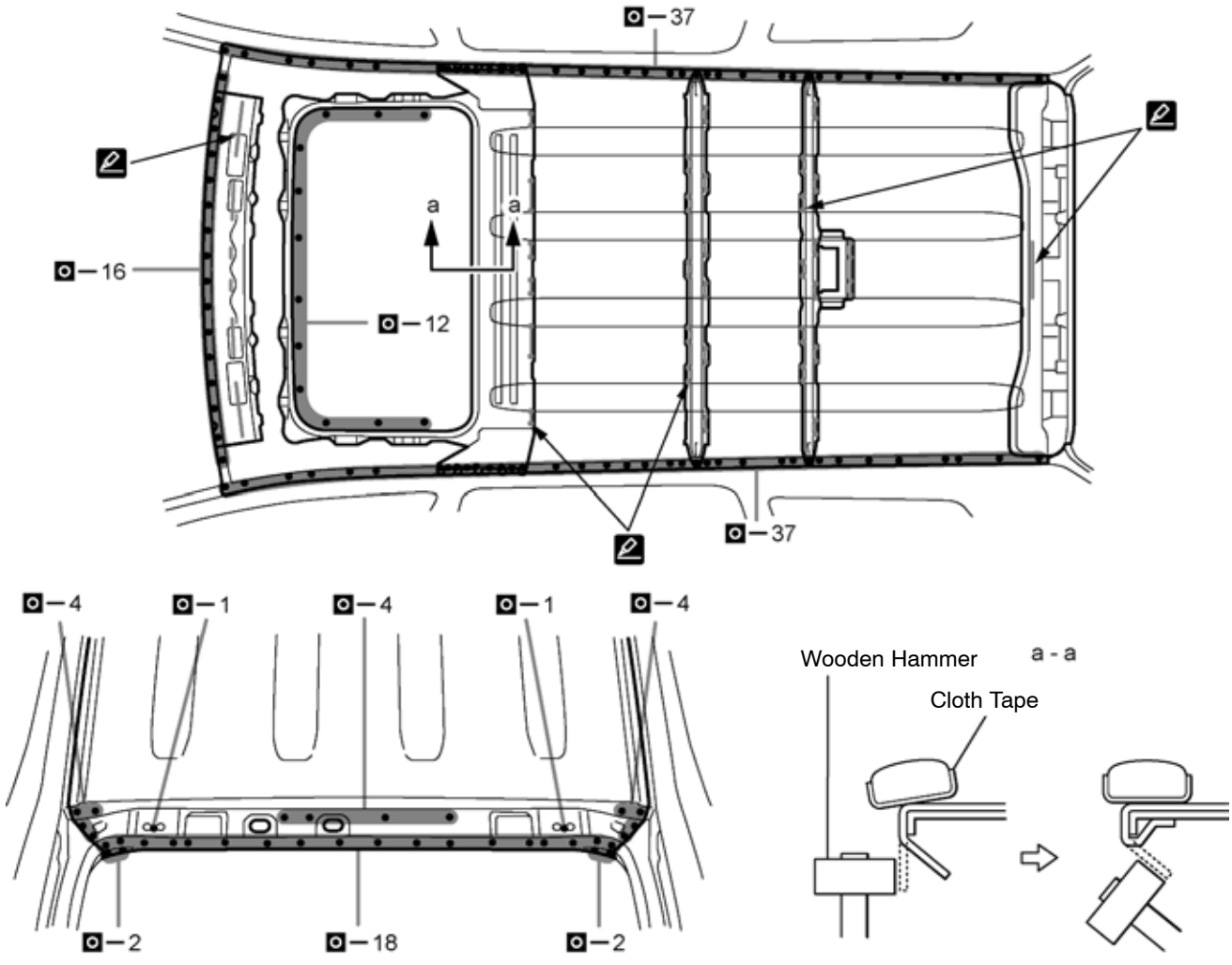
1 If reusing the roof panel reinforcement, trim the hemming location using a disc sander, etc.

Symbol meaning

: Plug Weld : Body Sealer

F29256B

INSTALLATION

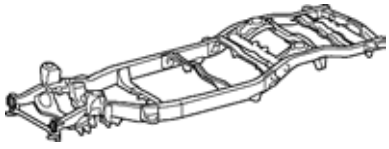


F29256

INSTALLATION POINT

1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
3 After the roof panel reinforcement is welded to the new parts, install the roof panel to the vehicle side.
4 Before temporarily installing the new parts, apply body sealer to the windshield header panel, roof panel reinforcement and back door opening frame.
HINT:
Apply just enough sealer for the new parts to make contact.
5 After welding, apply body sealer to the corresponding parts. (See the paint·coating)
6 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

FRAME SIDE RAIL PLATE (ASSY): w/o Winch



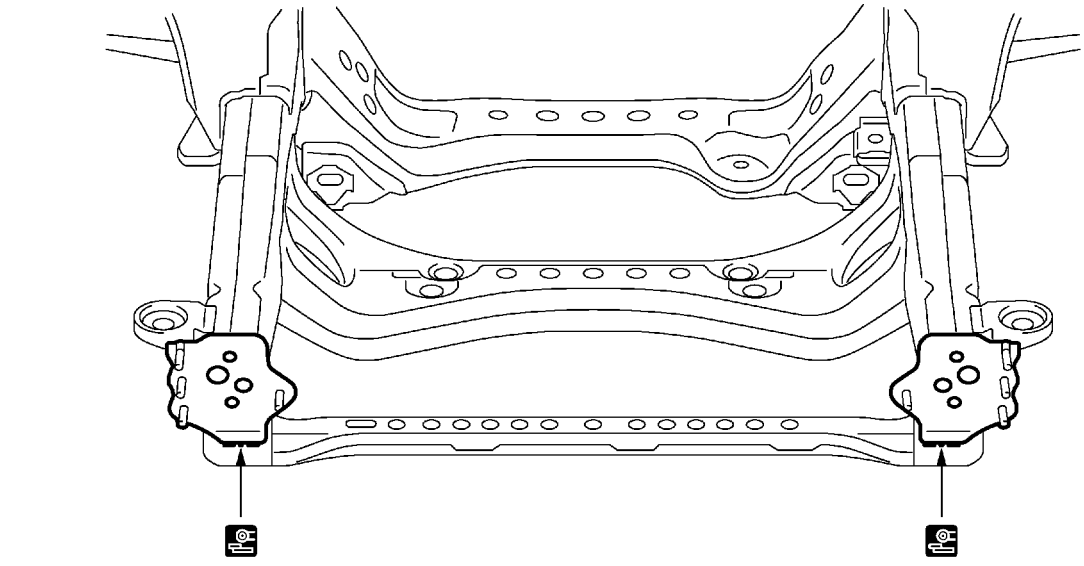
F29257A

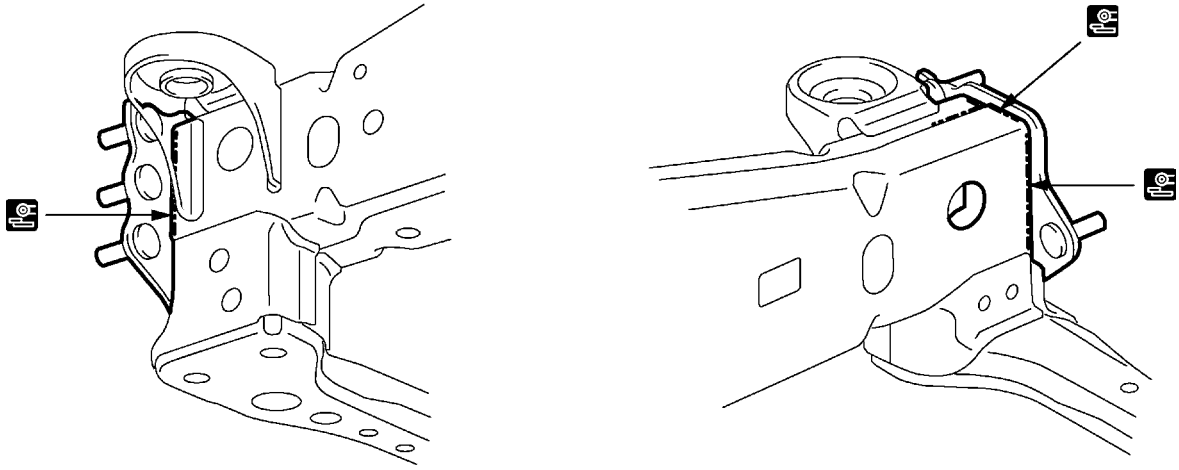
Symbol meaning

: Cut with Disc Sander etc.

F29257B

REMOVAL





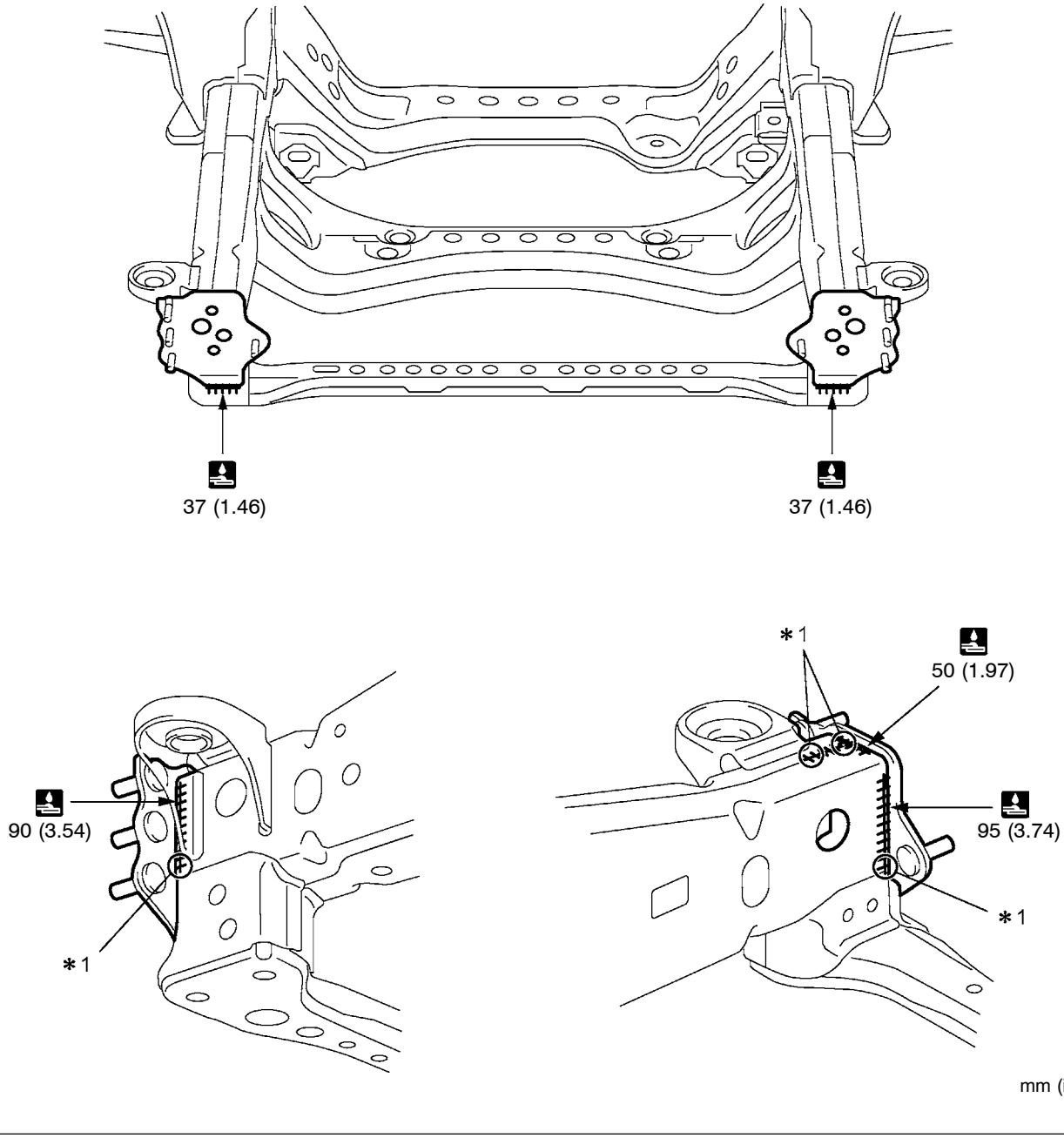
F29257

Symbol meaning

: Fillet Weld

F29258B

INSTALLATION

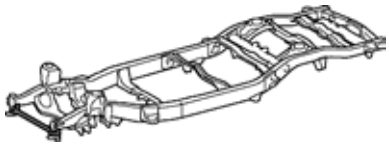


F29258

INSTALLATION POINT

1 Make sure that proper welding can be performed by setting up the welding conditions as necessary before performing work.
2 Make sure that the welding bead at *1 is overlapped.
3 To prevent heat deformation, weld the right and left side of each part before continuing to the next part.
4 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

FRAME AUXILIARY CROSSMEMBER (ASSY): w/o Winch



F29259A

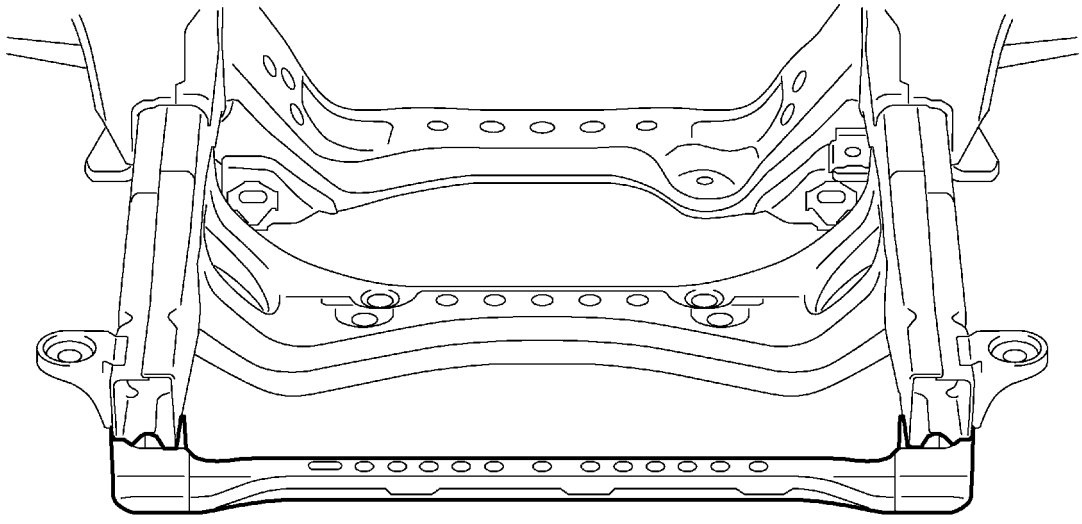
With the frame side rail plate removed.

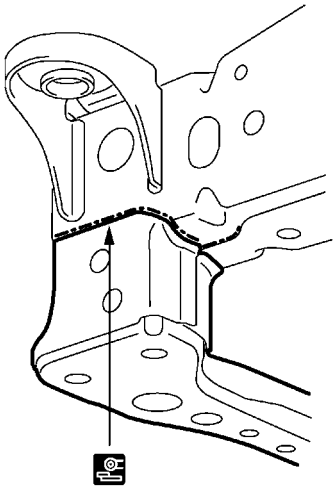
Symbol meaning

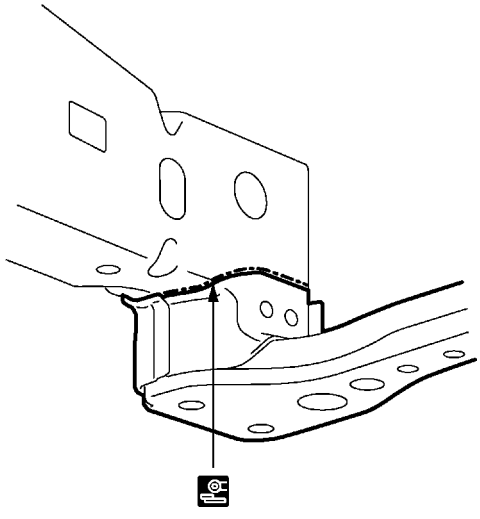
: Cut with Disc Sander etc.

F29259B

REMOVAL







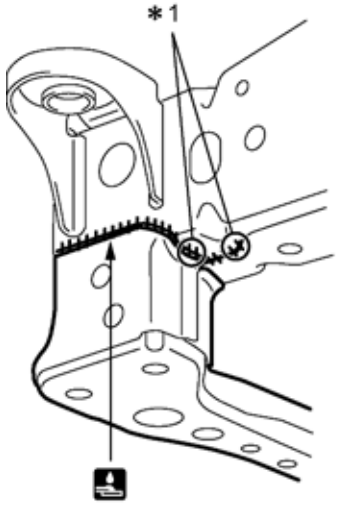
F29259

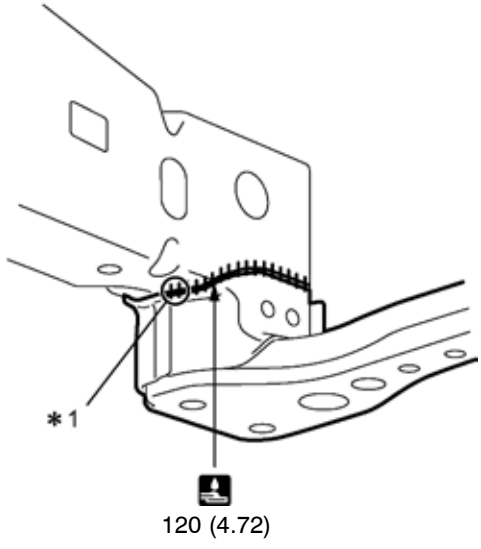
Symbol meaning

: Fillet Weld

F29260B

INSTALLATION



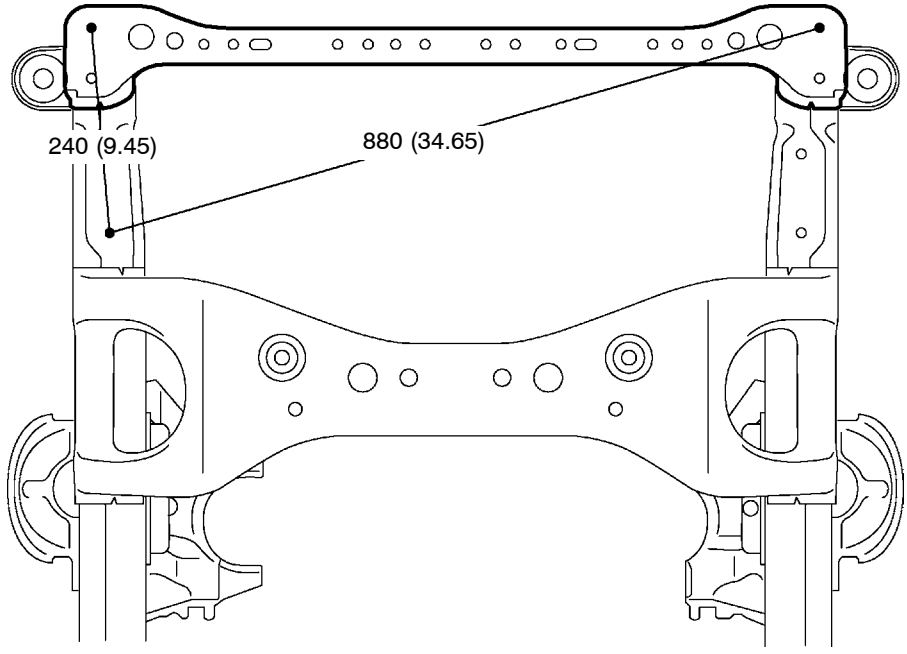


mm (in.)

F29260

INSTALLATION POINT

1 Make sure that proper welding can be performed by setting up the welding conditions as necessary before performing work.
2 Make sure that the welding bead at *1 is overlapped.
3 To prevent heat deformation, weld the right and left side of each part before continuing to the next part.
4 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

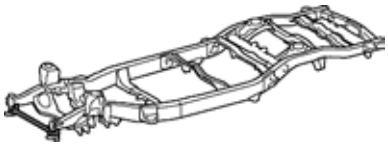


F29261

INSTALLATION POINT

1 These values are reference values.

FRAME AUXILIARY CROSSMEMBER (ASSY): w/ Winch



F29262A

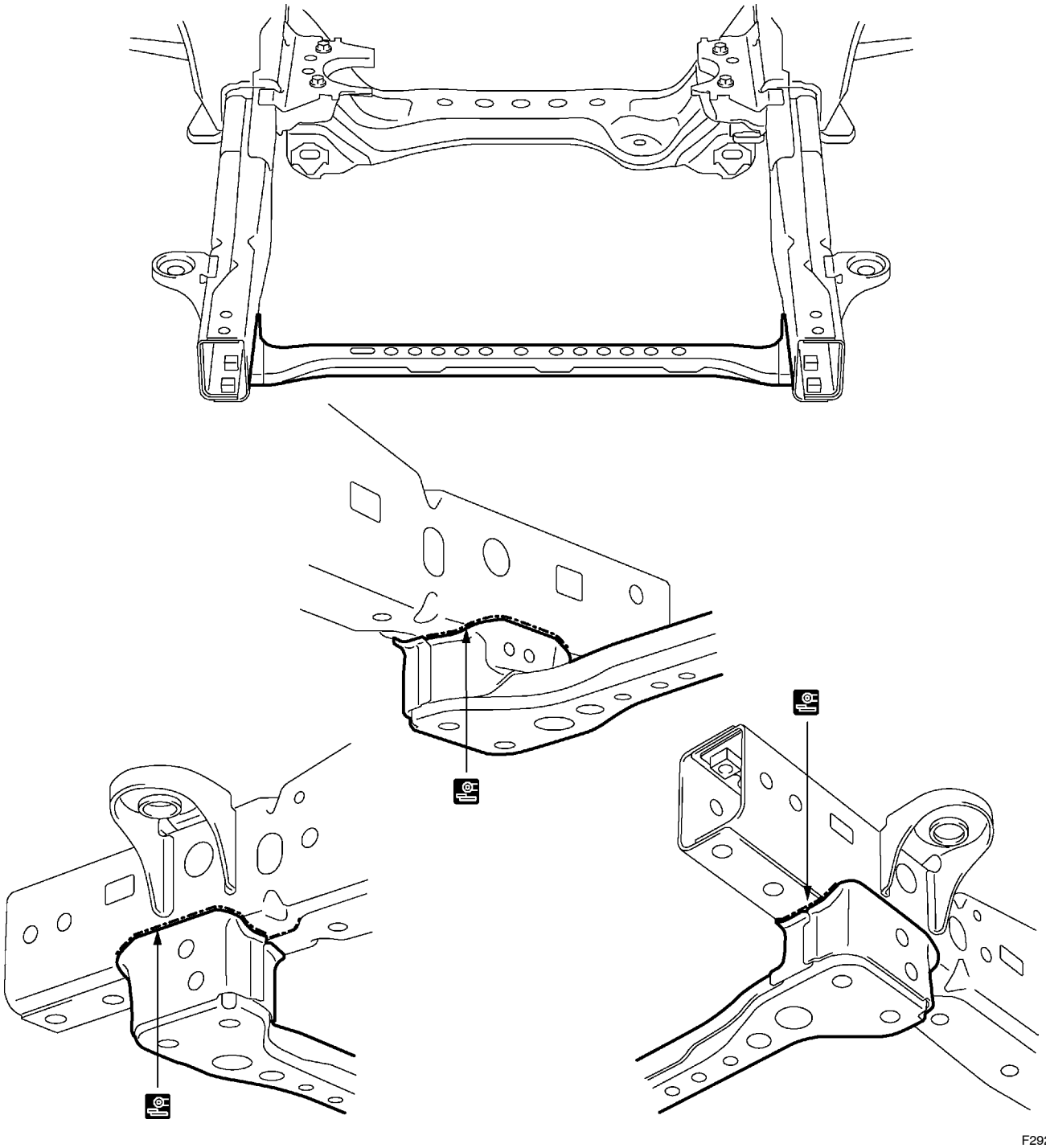
With the frame side rail plate removed.

Symbol meaning

: Cut with Disc Sander etc.

F29262B

REMOVAL



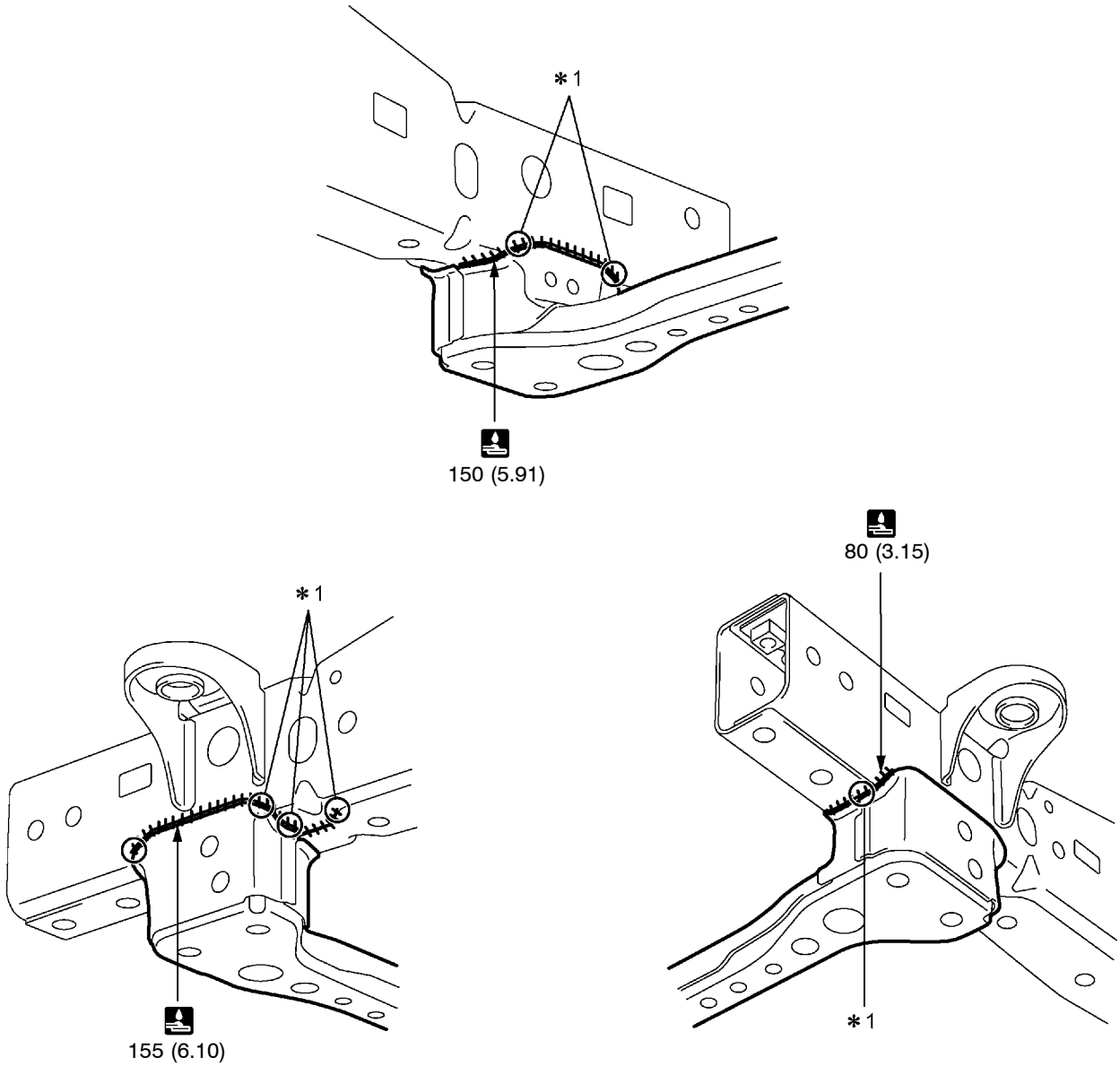
F29262

Symbol meaning

: Fillet Weld

F29263B

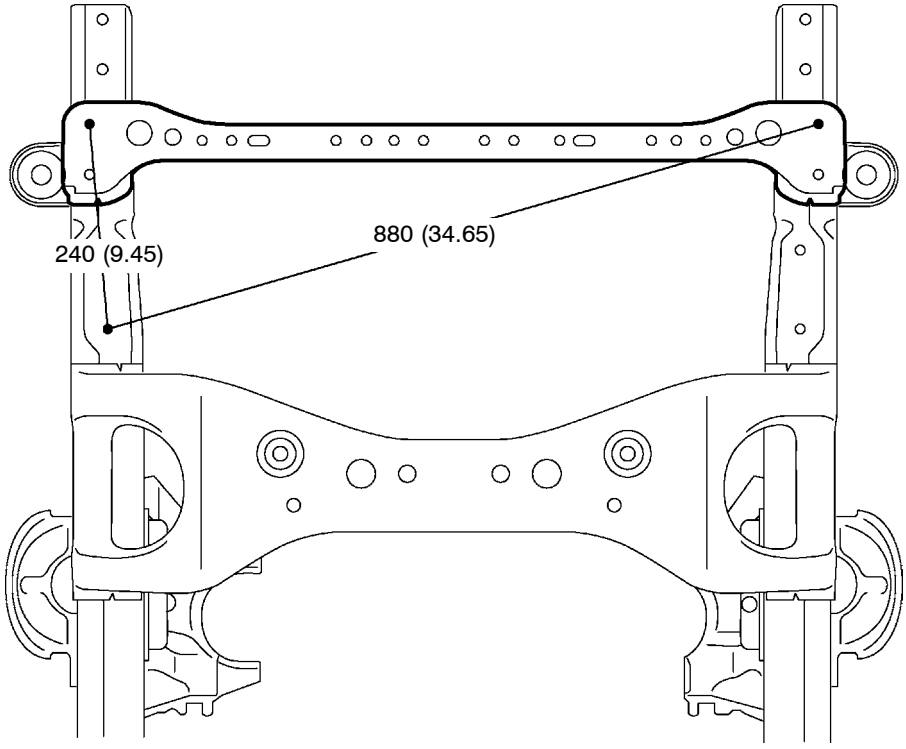
INSTALLATION



F29263

INSTALLATION POINT

1 Make sure that proper welding can be performed by setting up the welding conditions as necessary before performing work.
2 Make sure that the welding bead at *1 is overlapped.
3 To prevent heat deformation, weld the right and left side of each part before continuing to the next part.
4 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

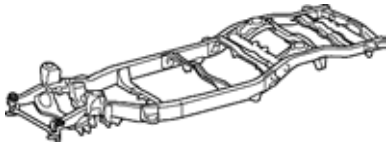


F29264

INSTALLATION POINT

1 These values are reference values.

CAB MOUNTING NO. 1 BRACKET (ASSY)



F29265A

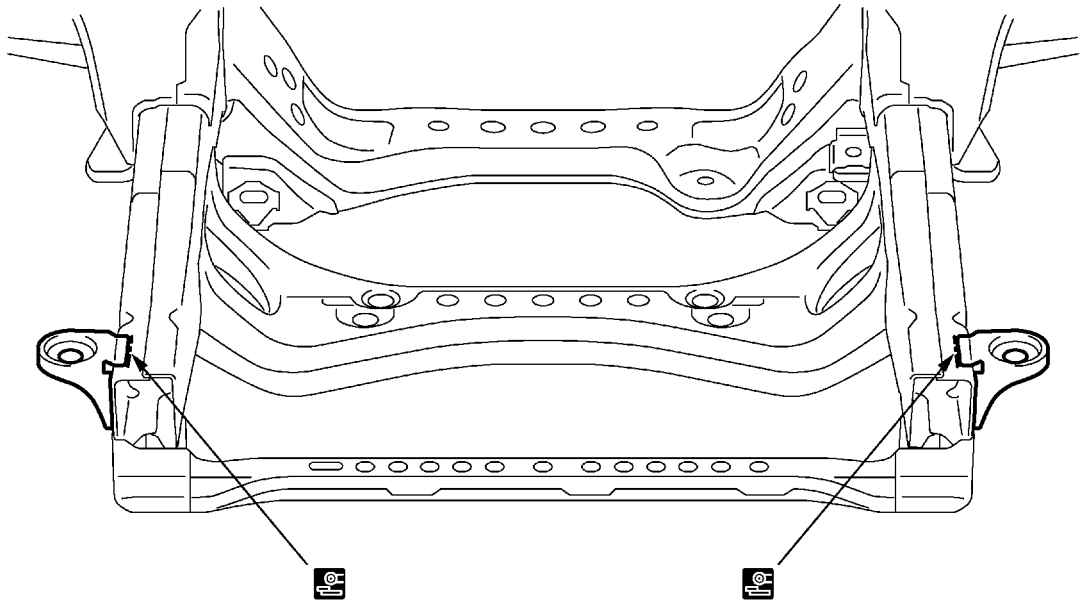
With the frame side rail plate removed.

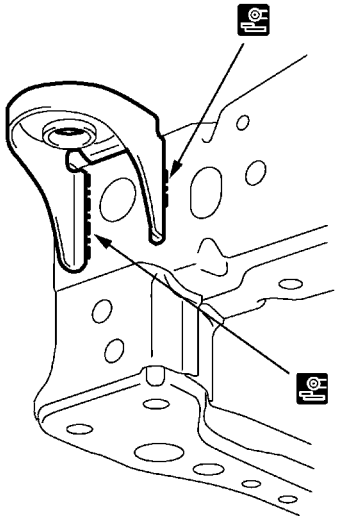
Symbol meaning

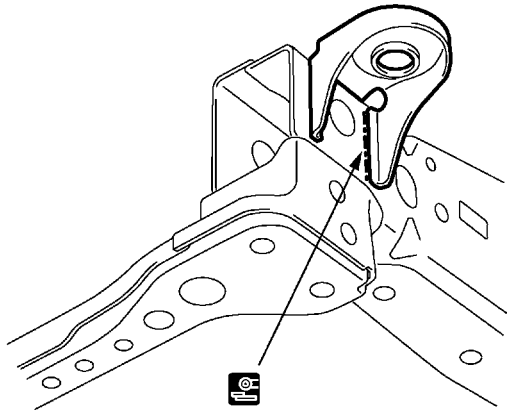
: Cut with Disc Sander etc.

F29265B

REMOVAL







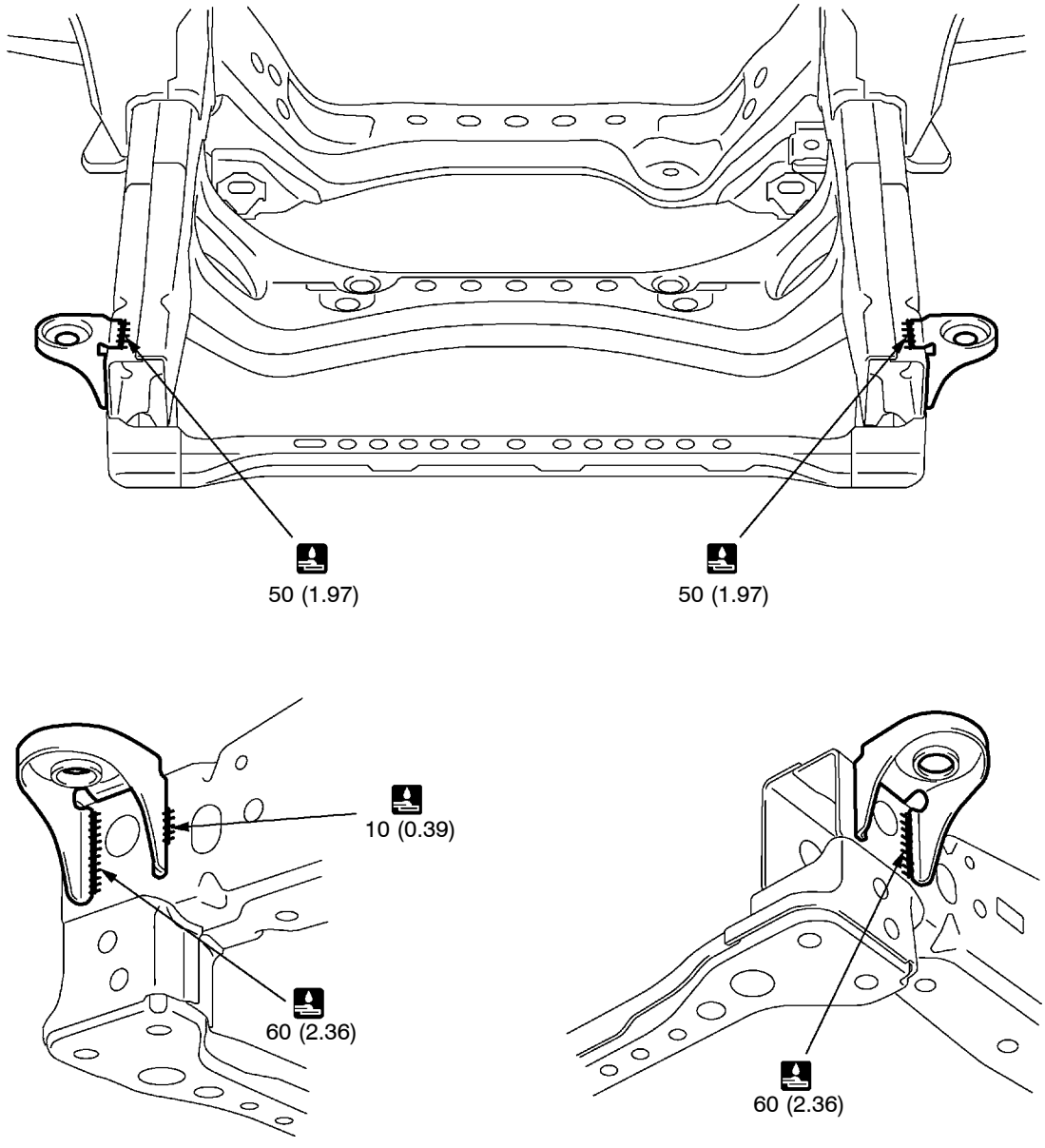
F29265

Symbol meaning

: Fillet Weld

F29266B

INSTALLATION



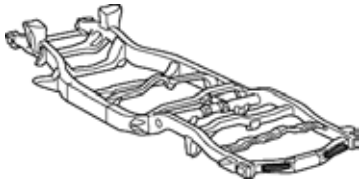
mm (in.)

F29266

INSTALLATION POINT

1 Make sure that proper welding can be performed by setting up the welding conditions as necessary before performing work.
2 Before installing the cab mounting No. 1 brackets, set the cab (upper body) on the vehicle frame and confirm the cab mounting No. 1 brackets' installation positions.
3 To prevent heat deformation, weld the right and left side of each part before continuing to the next part.
4 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

FRAME REAR BUMPER REINFORCEMENT (ASSY): w/ Towing Hitch



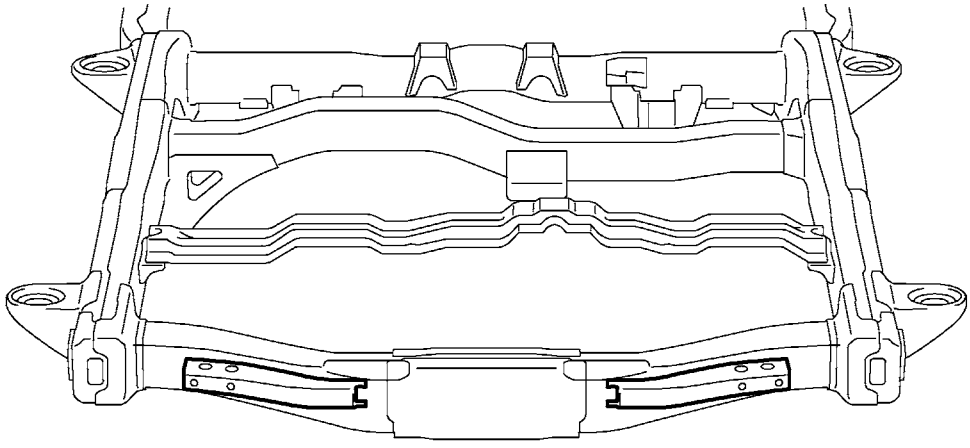
F29267A

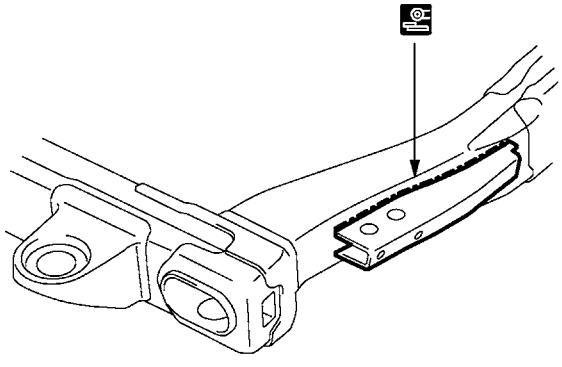
Symbol meaning

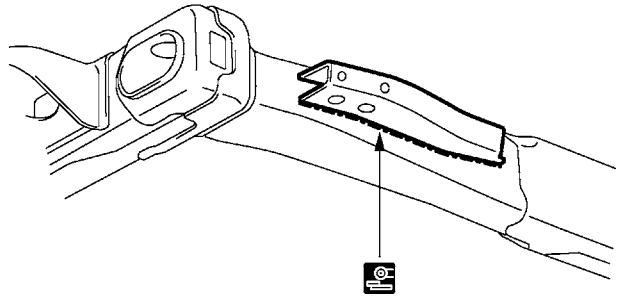
: Cut with Disc Sander etc.

F29267B

REMOVAL







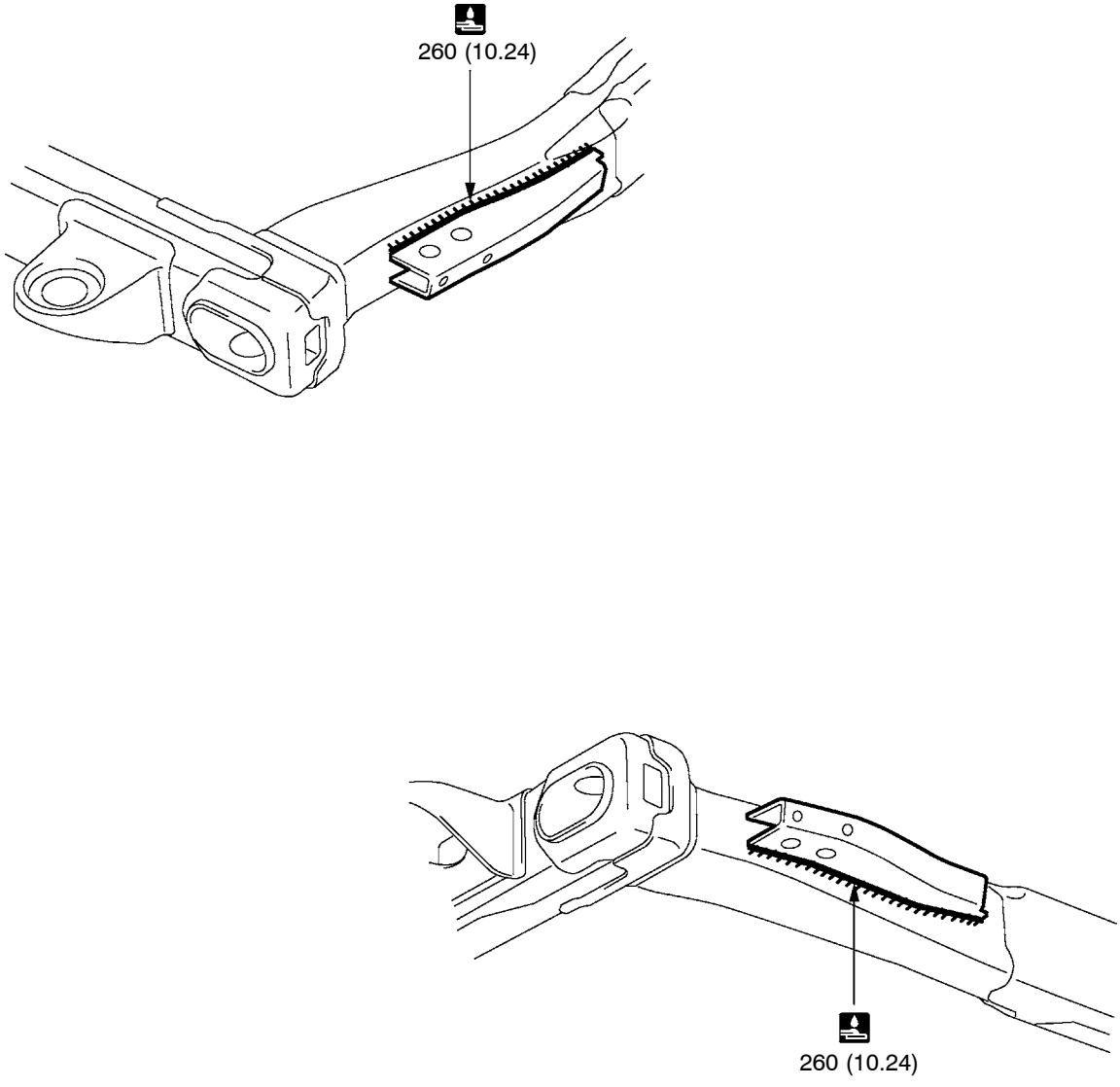
F29267

Symbol meaning

: Fillet Weld

F29268B

INSTALLATION



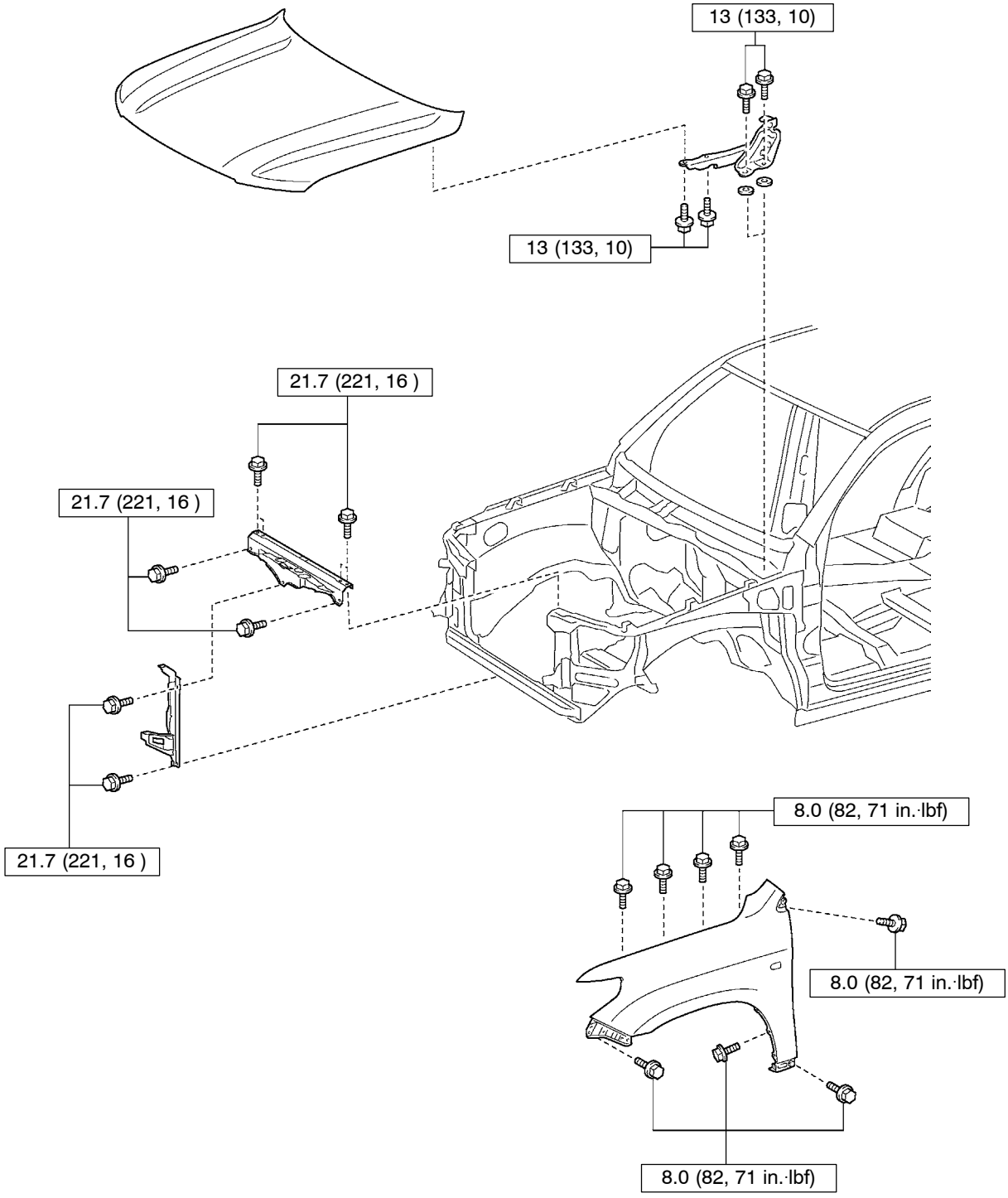
mm (in.)

F29268

INSTALLATION POINT

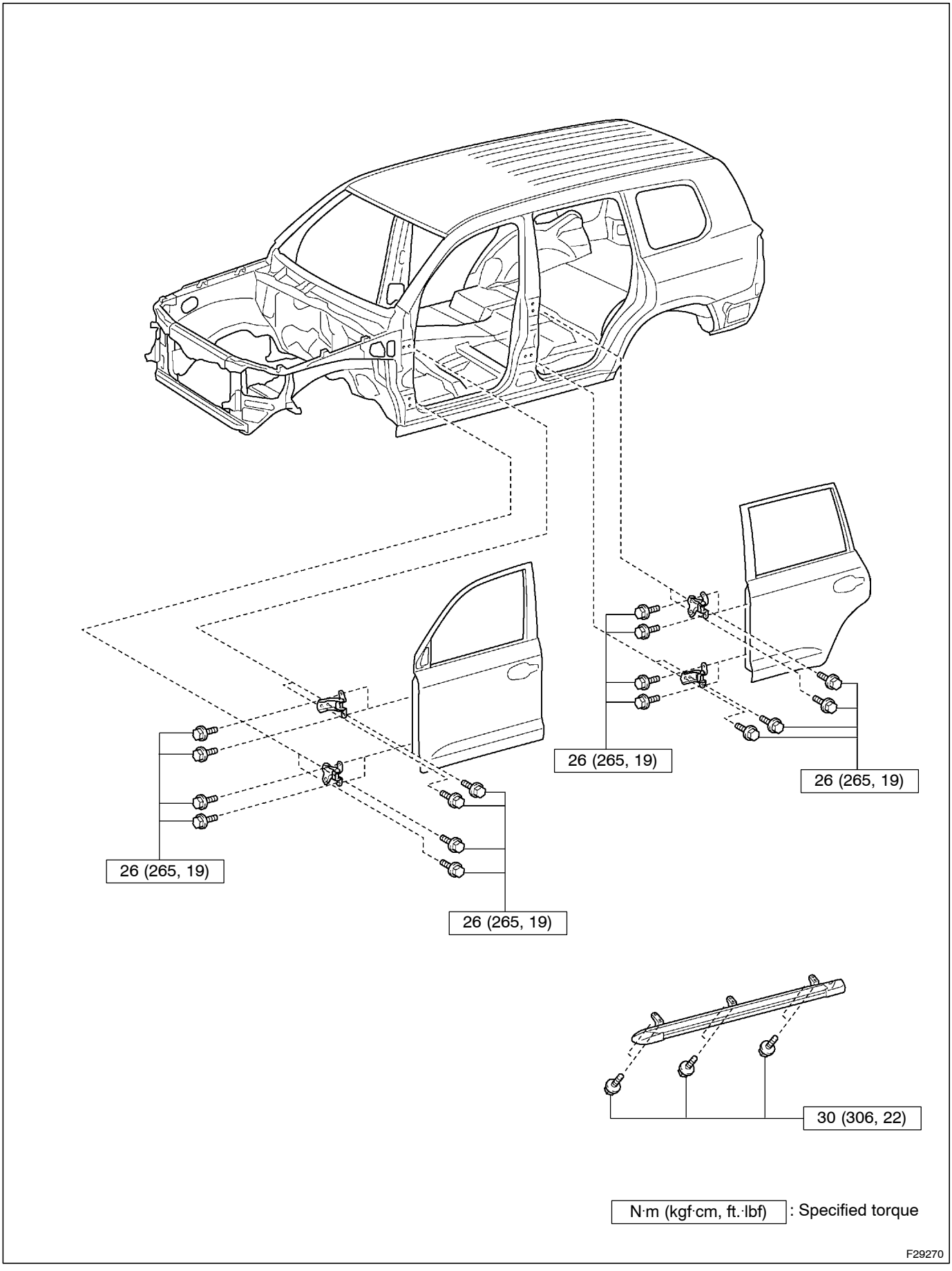
1 Make sure that proper welding can be performed by setting up the welding conditions as necessary before performing work.
2 To prevent heat deformation, weld the right and left side of each part before continuing to the next part.
3 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

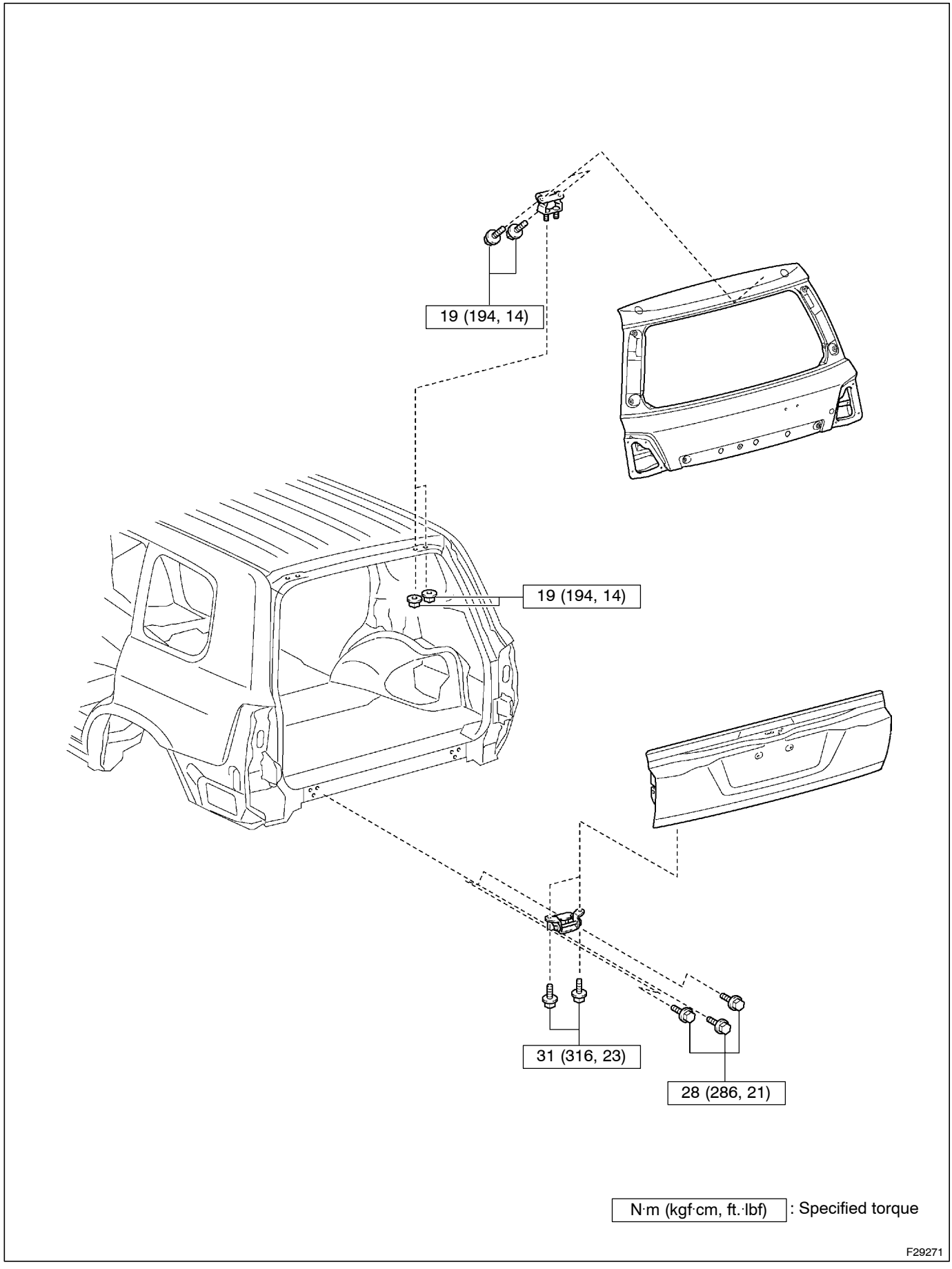
OUTER PANEL INSTALLATION TORQUE

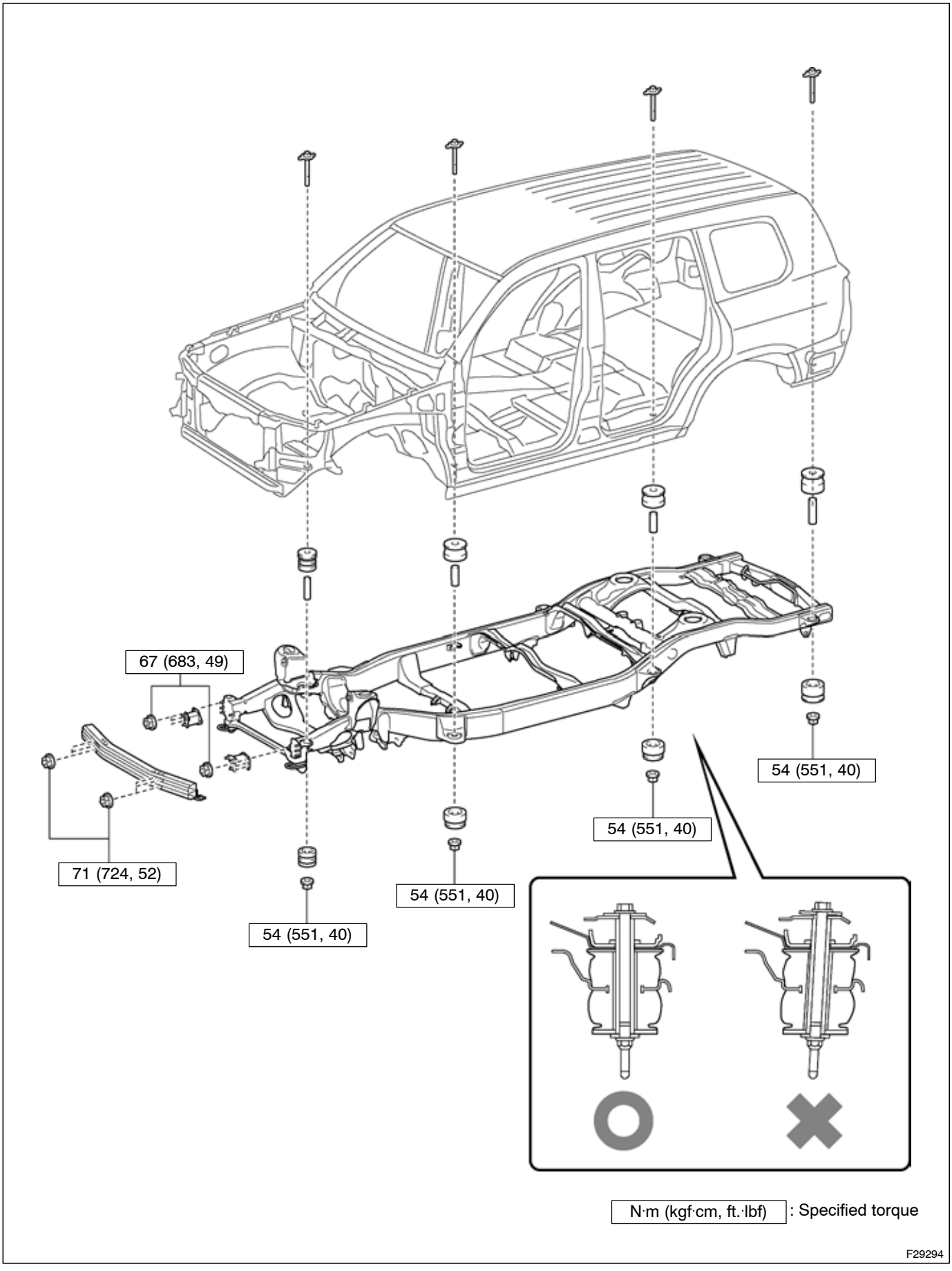


N·m (kgf·cm, ft.·lbf) : Specified torque

F29269

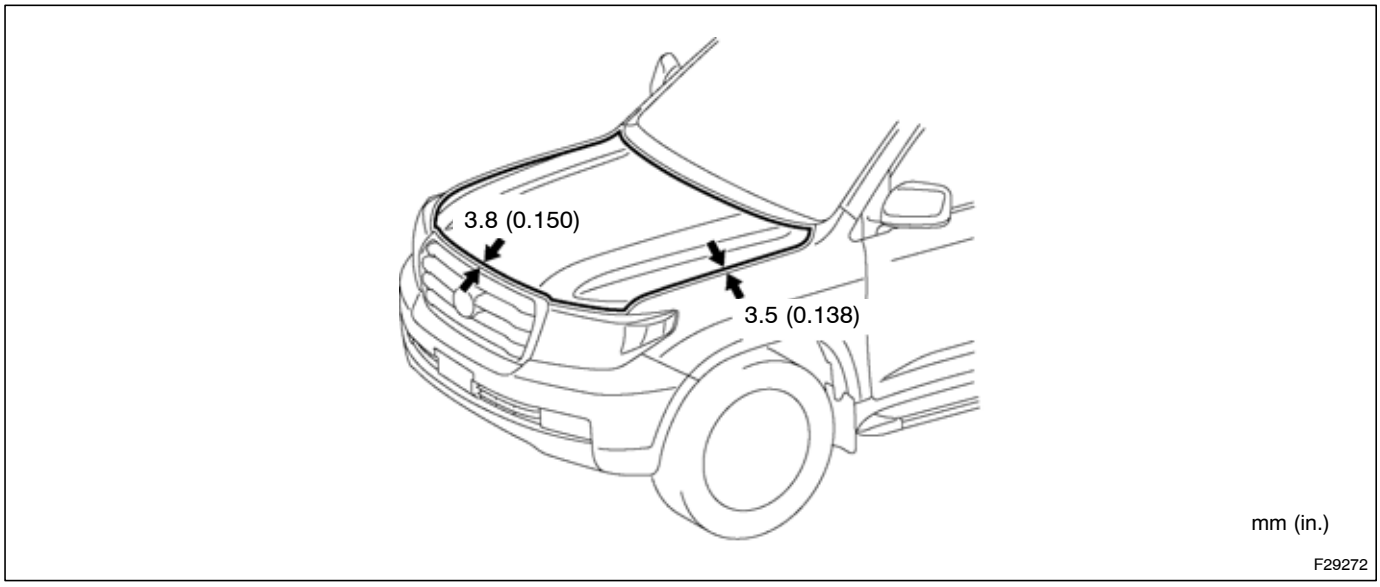

26 (265, 19)
26 (265, 19)
26 (265, 19)
26 (265, 19)
30 (306, 22)
N·m (kgf·cm, ft.·lbf) : Specified torque
F29270


19 (194, 14)
19 (194, 14)
31 (316, 23)
28 (286, 21)
N·m (kgf·cm, ft.·lbf) : Specified torque
F29271


67 (683, 49)
71 (724, 52)
54 (551, 40)
54 (551, 40)
54 (551, 40)
54 (551, 40)
54 (551, 40)
N·m (kgf·cm, ft.·lbf) : Specified torque
F29294

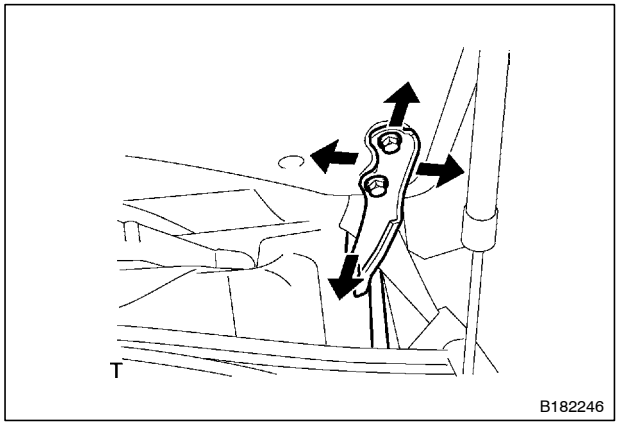
FIT STANDARD/ADJUSTMENT METHOD/TORQUE SPECIFICATION

1. 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.



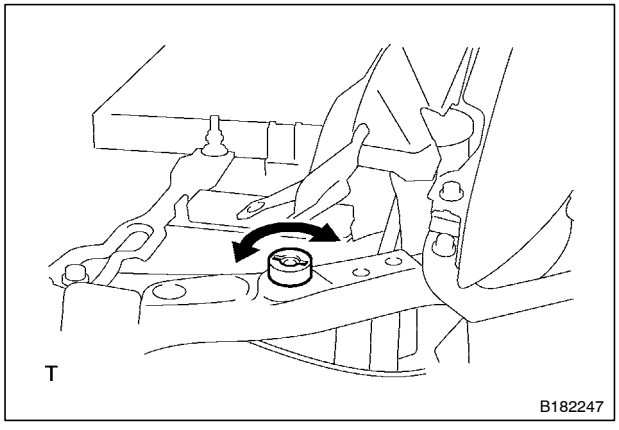
(a) Adjust the hood position.

(1) Loosen the 4 hinge bolts of the hood.

(2) Move the hood and adjust the clearance between the hood and front fender.

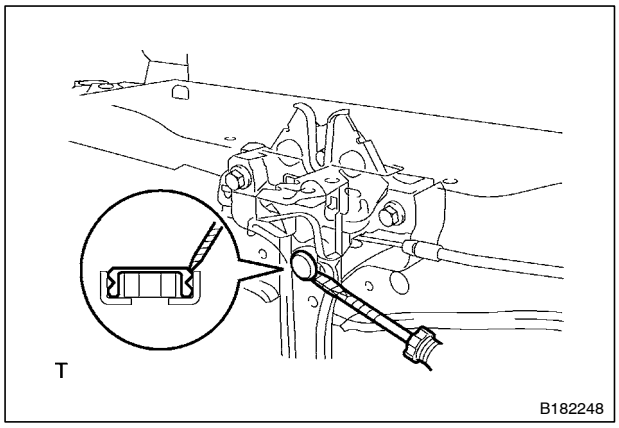
(3) Tighten the 4 hinge bolts of the hood after the adjustment.

Torque:
13 N·m (133 kgf·cm, 10 ft.·lbf)



(4) Adjust the cushion rubber so that the height of the hood and fender are aligned.

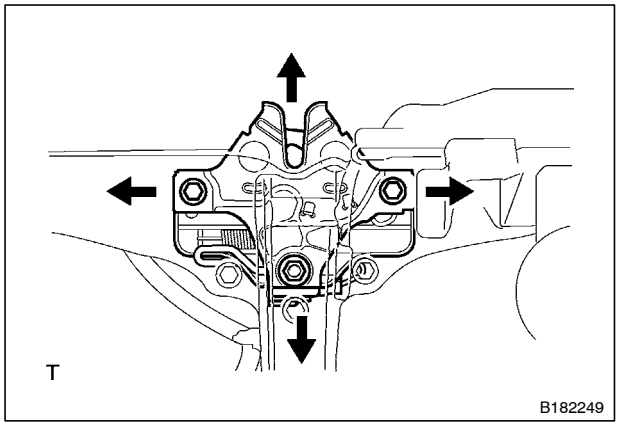
HINT:
Raise or lower the hood front end by turning the cushion rubber.



(b) Adjust the hood lock.

(1) Using a screwdriver, remove the hood lock nut cap as shown in the illustration.

HINT:
Tape the screwdriver tip before use.



(2) Loosen the 2 bolts and hood lock nut.

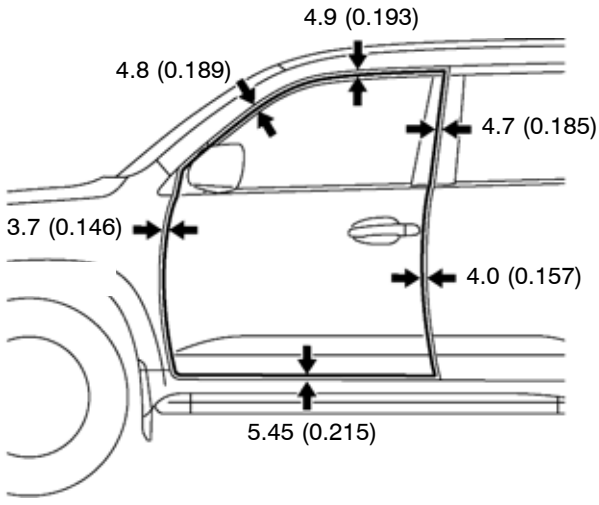
(3) Adjust the hood lock position so that the striker can enter it smoothly.

(4) Tighten the bolts and nut after the adjustment.

Torque:
5.5 N·m (56 kgf·cm, 49 in.·lbf)

(5) Install a new cap.

2. FRONT DOOR



HINT:

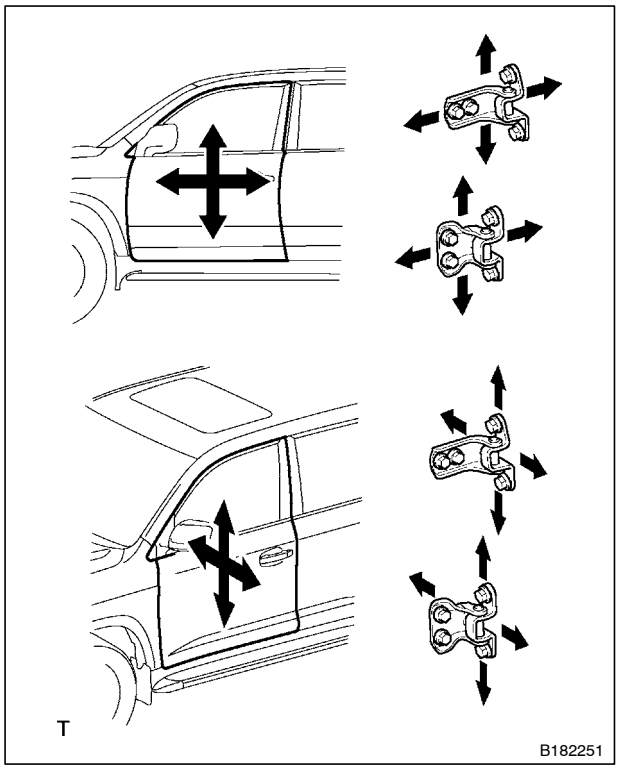
- *Before adjusting the door position for vehicles equipped with side airbags and curtain shield airbags, be sure to disconnect the cable from the negative (–) battery terminal.*
- *Use the same procedures for the RH side and LH side.*
- *The procedures listed below are for the LH side.*
- *Centering bolts are used to mount the door hinge to the vehicle body and door. The door cannot be adjusted with the centering bolts installed on. Substitute the centering bolts with standard bolts (with washers) when making adjustments.*

(a) Disconnect the cable from the negative (–) battery terminal.

CAUTION:
Wait at least 90 seconds after disconnecting the cable from the negative (–) battery terminal to disable the SRS system.

NOTICE:

- **After the engine switch is turned off, the navigation system requires approximately 90 seconds to record various types of memory and settings. As a result, after turning the engine switch off, wait 90 seconds or more before disconnecting the cable from the negative (–) battery terminal.**
- **When disconnecting the cable some systems need to be initialized after the cable is reconnected.**



(b) Using SST, loosen the body hinge bolts and adjust the door position.

SST
09812-00010

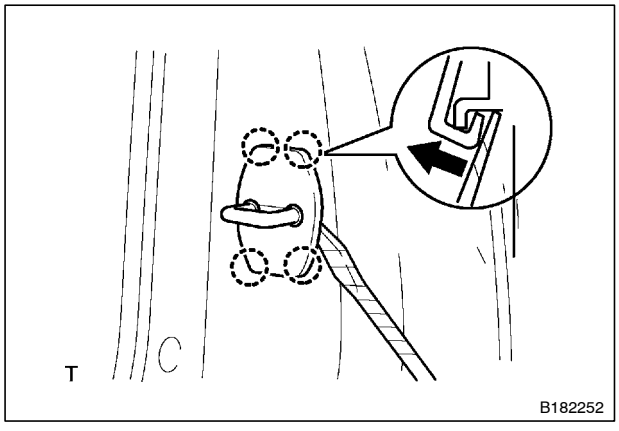
(c) Using SST, tighten the body hinge bolts after the adjustment.

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

(d) Loosen the door hinge bolts and adjust the door position.

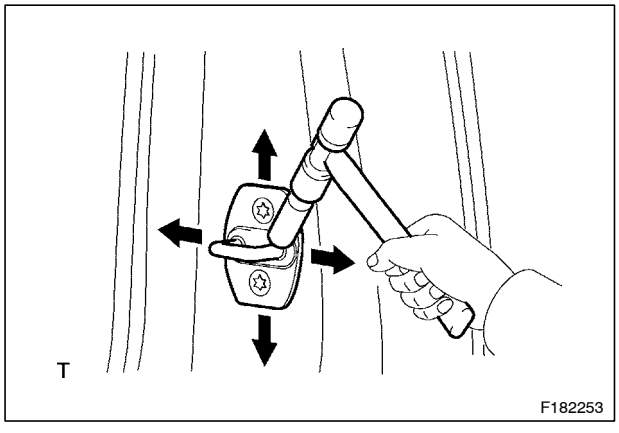
(e) Tighten the door hinge bolts after the adjustment.

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



(f) Using a screwdriver, detach the 4 claws and remove the cover.

HINT:
Tape the screwdriver tip before use.



(g) Using a T40 “TORX” socket, adjust the striker position by slightly loosening the striker mounting screws and hitting the striker with a plastic-faced hammer.

(h) Using a T40 “TORX” socket, tighten the striker mounting screws after the adjustment.

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

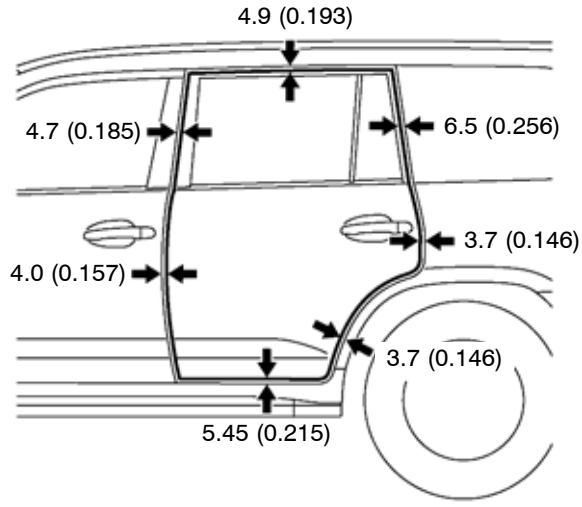
(i) Attach the 4 claws to install the cover.

(j) Connect the cable to the negative (–) battery terminal.

NOTICE:
When disconnecting the cable, some systems need to be initialized after the cable is reconnected.

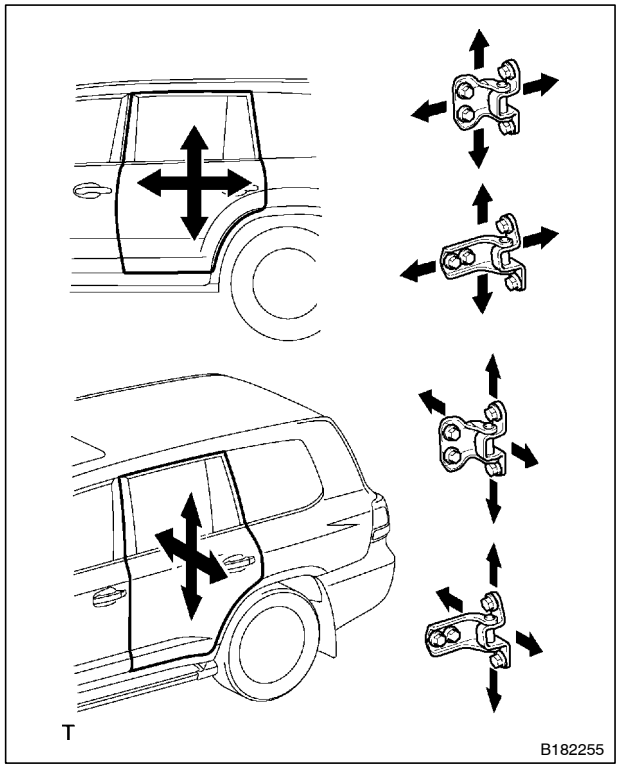
(k) Check the SRS warning light.

3. REAR DOOR



HINT:

- *Before adjusting the door position for vehicles equipped with side airbags and curtain shield airbags, be sure to disconnect the cable from the negative (–) battery terminal.*
- *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) Loosen the body hinge bolts and adjust the door position.

SST
09812-00010

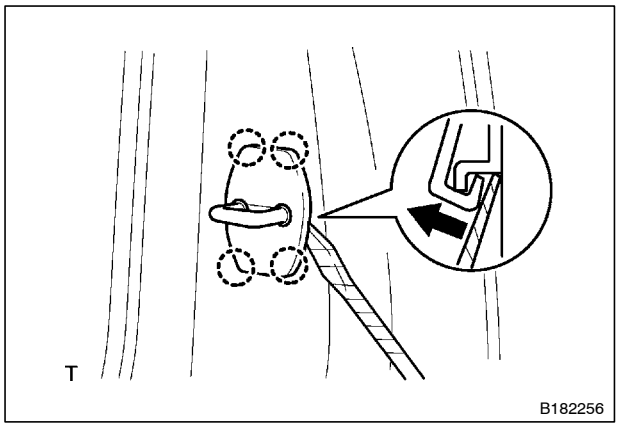
(b) Tighten the body hinge bolts after the adjustment.

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

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

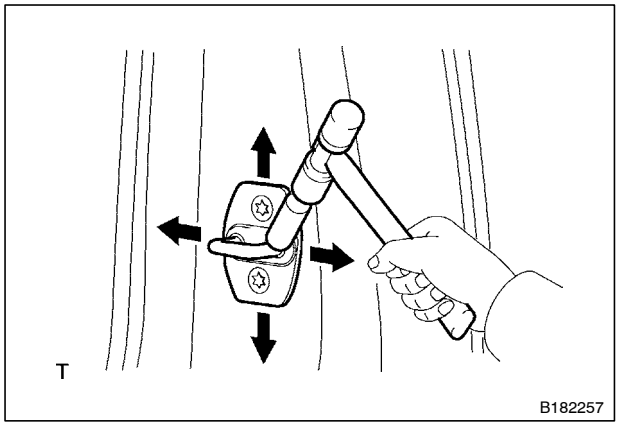
(d) Tighten the door hinge bolts after the adjustment.

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



(e) Using a screwdriver, detach the 4 claws and remove the cover.

HINT:
Tape the screwdriver tip before use.



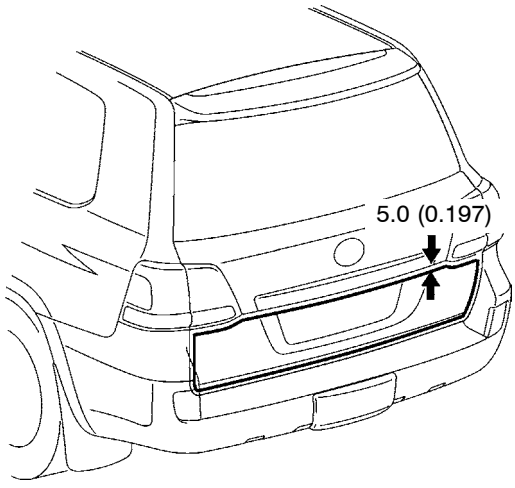
(f) Using a T40 “TORX” socket, adjust the striker position by slightly loosening the striker mounting screws and hitting the striker with a plastic-faced hammer.

(g) Using a T40 “TORX” socket, tighten the striker mounting screws after the adjustment.

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

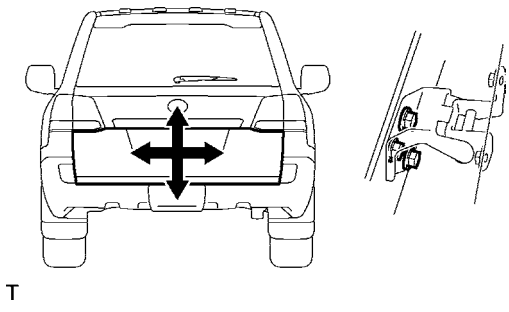
(h) Attach the 4 claws to install the cover.

4. TAIL GATE PANEL SUB-ASSEMBLY (for USA, Canada)



mm (in.)

F29275



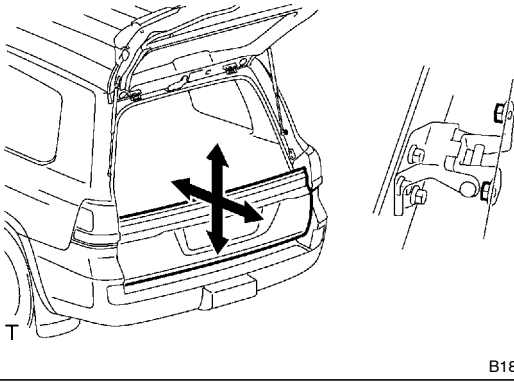
B189862

(a) Loosen the hinge bolts.

(b) Adjust the tail gate by moving it up and down and left and right so that the dimensions are within the specified range.

(c) Tighten the hinge bolts.

Torque:
28 N·m (286 kgf·cm, 21 ft.·lbf)



B189861

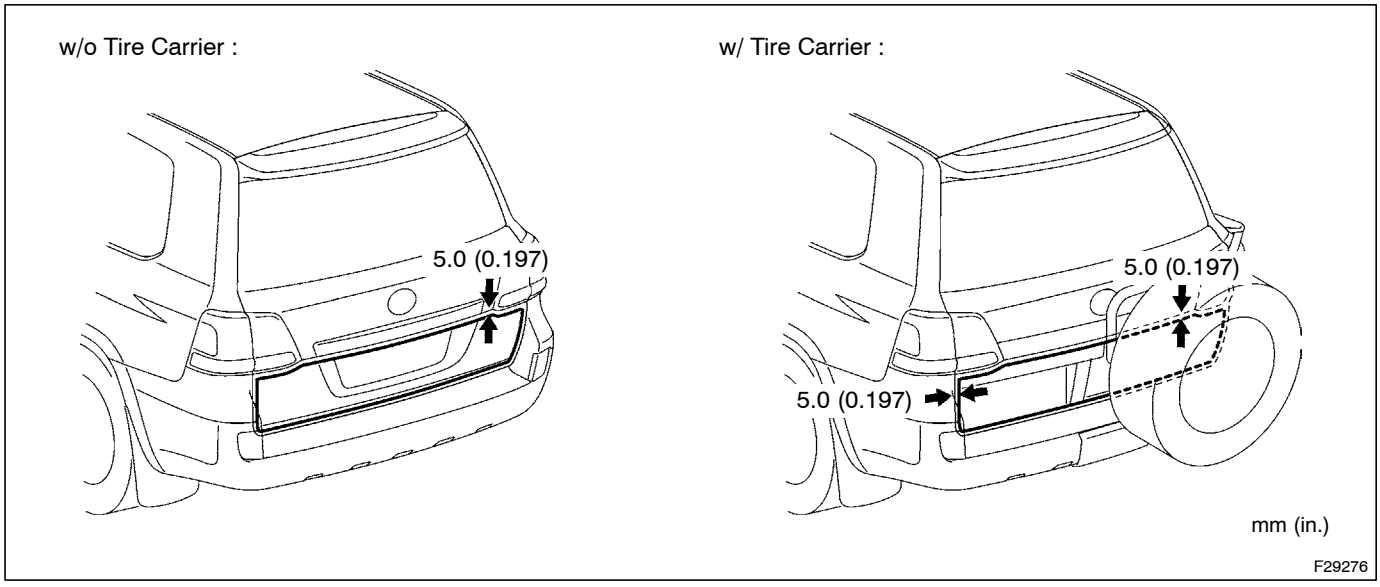
(d) Loosen the hinge bolts.

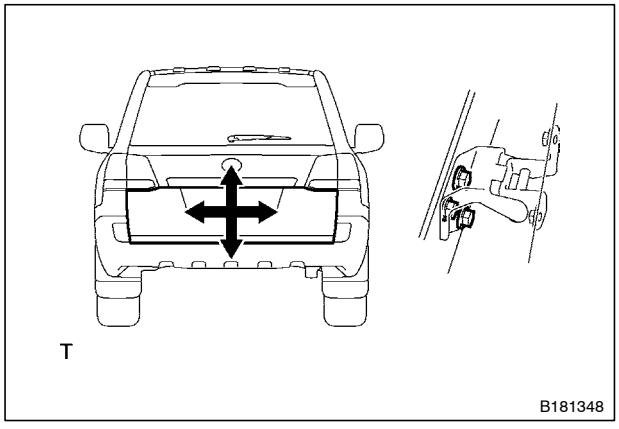
(e) Adjust the tail gate by moving it up and down and forward and backward so that the dimensions are within the specified range.

(f) Tighten the hinge bolts.

Torque:
31 N·m (316 kgf·cm, 23 ft.·lbf)

5. TAIL GATE PANEL SUB-ASSEMBLY (for Except USA, Canada)



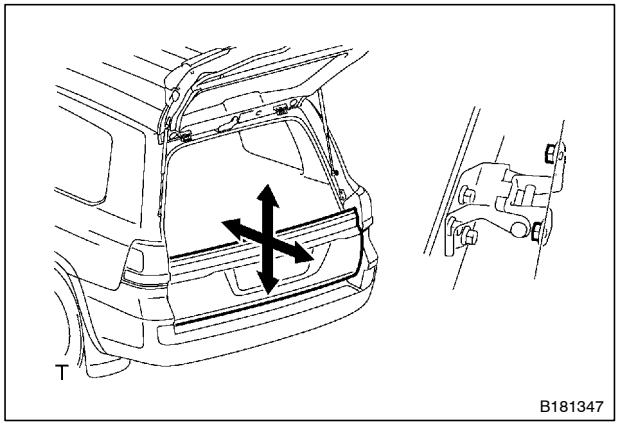


(a) Loosen the hinge bolts.

(b) Adjust the tail gate by moving it up and down and left and right so that the dimensions are within the specified range.

(c) Tighten the hinge bolts.

Torque:
28 N·m (286 kgf·cm, 21 ft.·lbf)



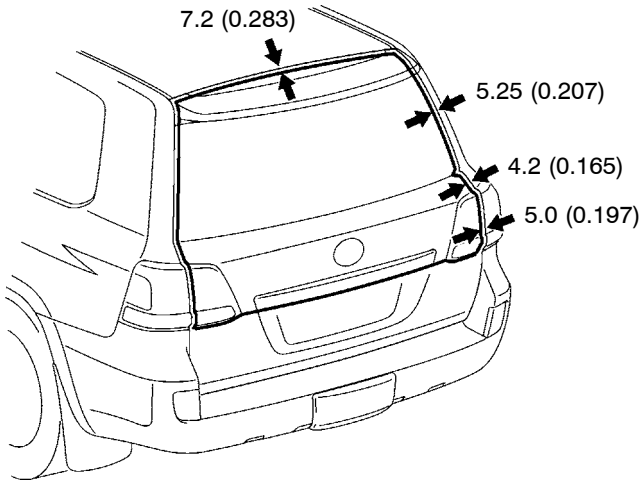
(d) Loosen the hinge bolts.

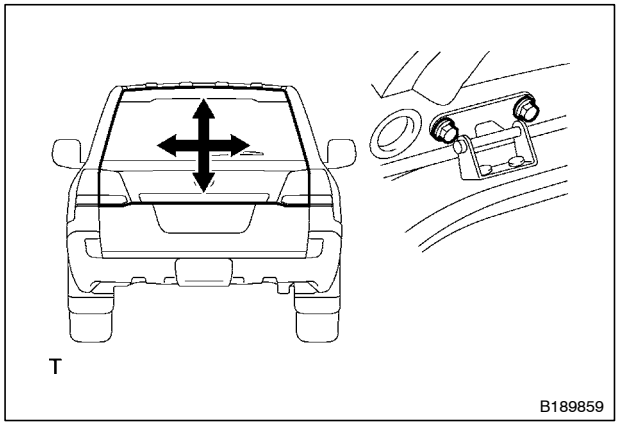
(e) Adjust the tail gate by moving it up and down and forward and backward so that the dimensions are within the specified range.

(f) Tighten the hinge bolts.

Torque:
31 N·m (316 kgf·cm, 23 ft.·lbf)

6. BACK DOOR PANEL SUB-ASSEMBLY (for USA, Canada)





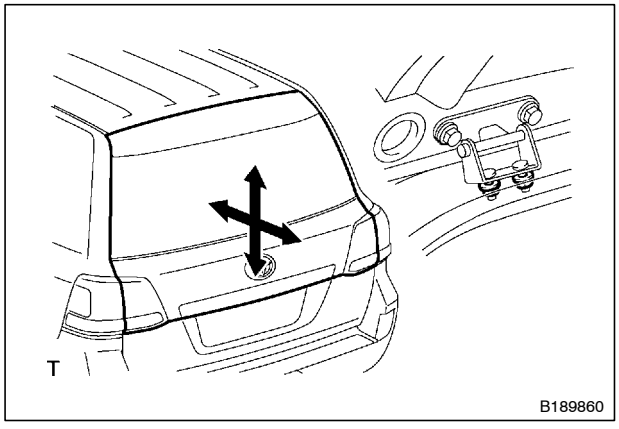
(a) Loosen the hinge bolts.

(b) Adjust the back door by moving it up and down and left and right so that the dimensions are within the specified range.

(c) Tighten the hinge bolts.

Torque:
19 N·m (194 kgf·cm, 14 ft.·lbf)

(d) Detach the rear seat belt anchor cover.



(e) Loosen the hinge nuts.

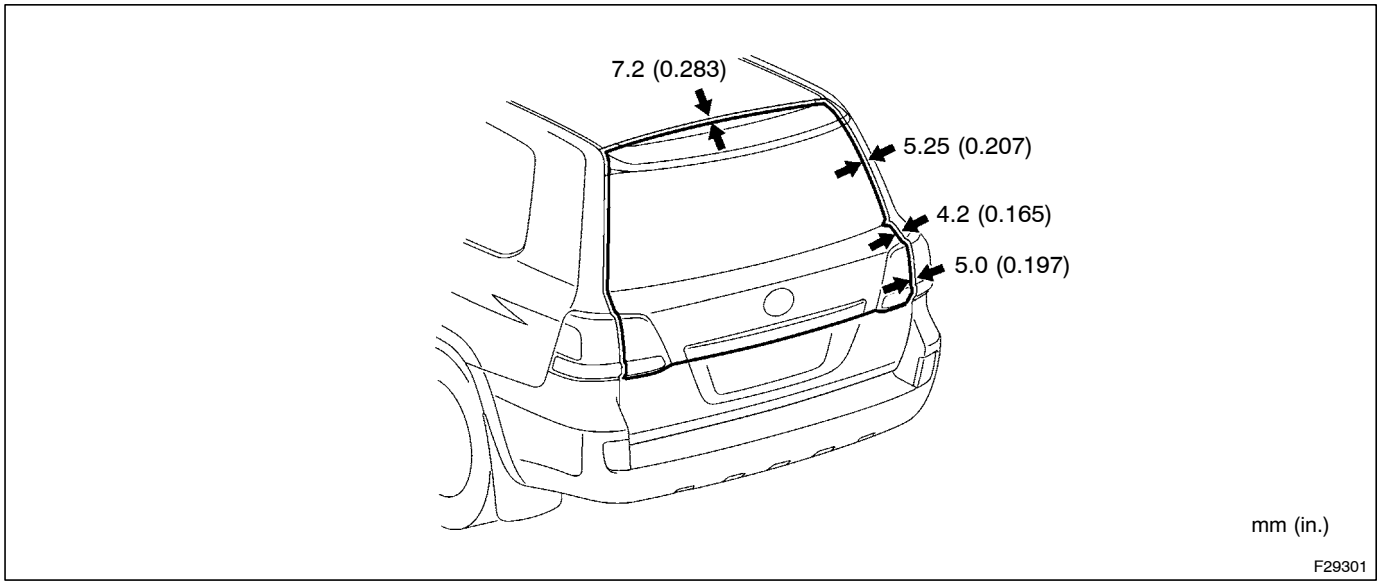
(f) Adjust the back door by moving it up and down and forward and backward so that the dimensions are within the specified range.

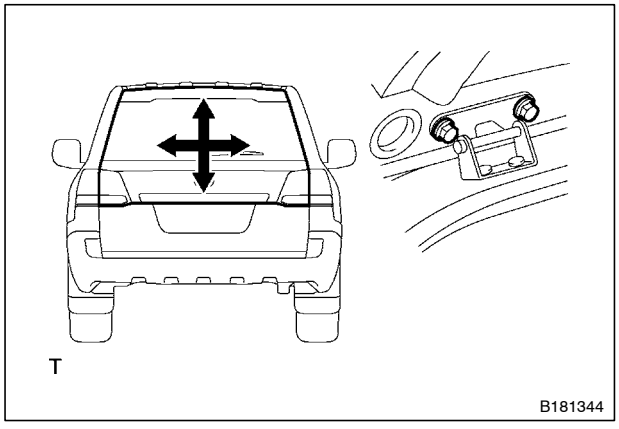
(g) Tighten the hinge nuts.

Torque:
19 N·m (194 kgf·cm, 14 ft.·lbf)

(h) Attach the rear seat belt anchor cover.

7. BACK DOOR PANEL SUB-ASSEMBLY (for Except USA, Canada)



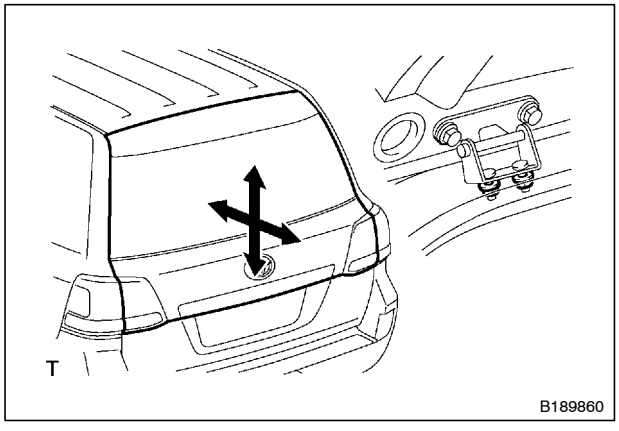


(a) Loosen the hinge bolts.

(b) Adjust the back door by moving it up and down and left and right so that the dimensions are within the specified range.

(c) Tighten the hinge bolts.

Torque:
19 N·m (194 kgf·cm, 14 ft.·lbf)



(d) for 3 Occupant Seat Type Rear No. 2 Seat:
(1) Detach the seat belt anchor cover.

(e) Loosen the hinge nuts.

(f) Adjust the back door by moving it up and down and forward and backward so that the dimensions are within the specified range.

(g) Tighten the hinge nuts.

Torque:
19 N·m (194 kgf·cm, 14 ft.·lbf)

(h) for 3 Occupant Seat Type Rear No. 2 Seat:
(1) Attach the seat belt anchor cover.

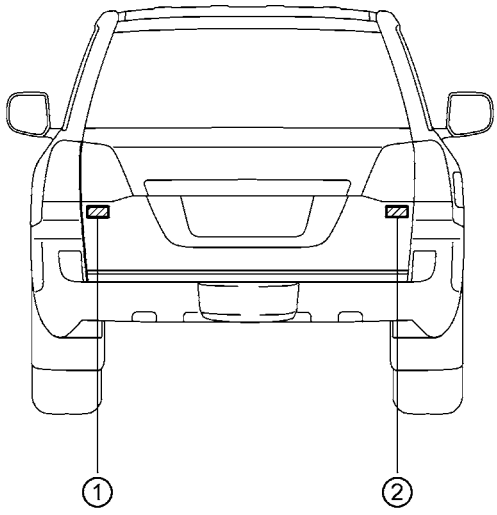
NAME PLATE APPLICATION PROCEDURE

1 Heat the double-sided tape remaining on the body with an infrared lamp or equivalent.
HINT:
Heat the tape to 40 to 60°C for approximately 1 to 2 minutes.

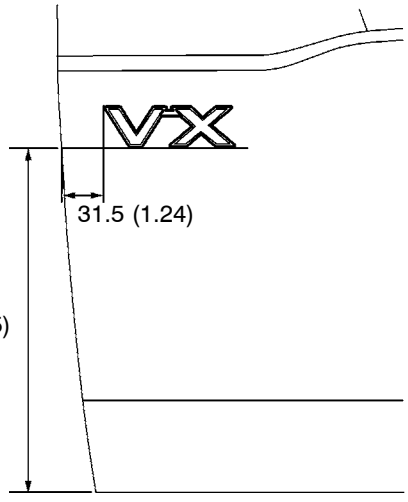
2 Wipe off the remaining double-sided tape using a clean cloth or equivalent.
HINT:
If a name plate is installed without thoroughly removing the remaining double-sided tape from the body, the name plate will not adhere properly. Make sure to thoroughly wipe off the double-sided tape.

3 After cleaning the installation area of the body with degreasing agent, attach the name plate to the position shown in the illustration.
HINT:
The working environment should be 20°C when installing the name plate. If the working environment is below 20°C, heat the installation area of the body to 20 to 30°C and then install the name plate.

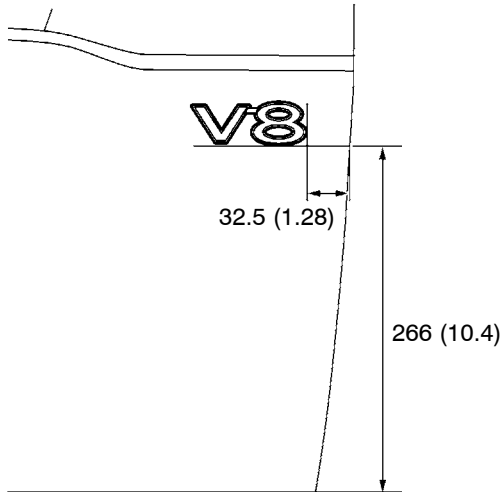
[USA, Canada]



① REAR NO. 3 BODY NAME PLATE



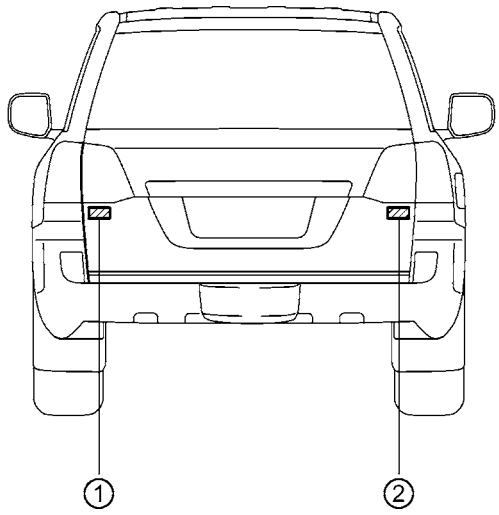
② NO. 5 BACK DOOR NAME PLATE



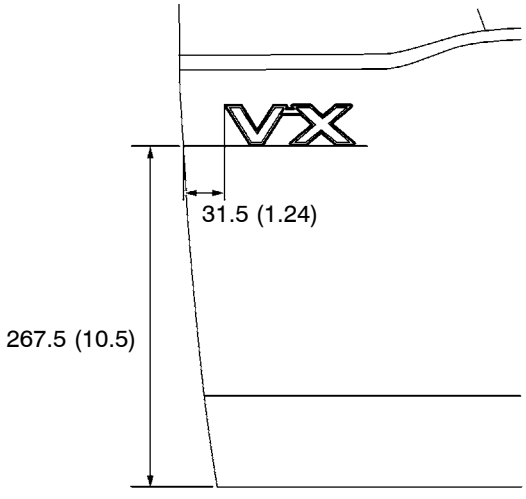
mm (in.)

F29295

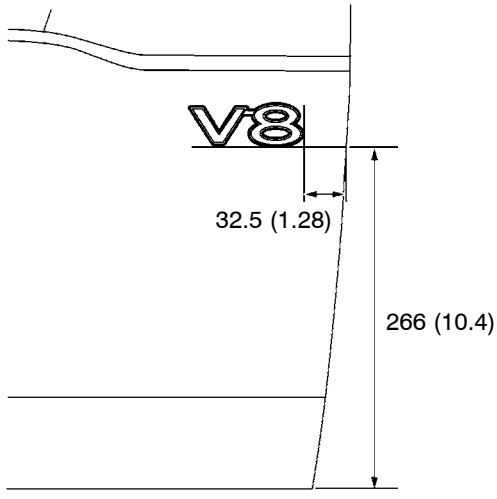
[Except USA, Canada]
for Type A:



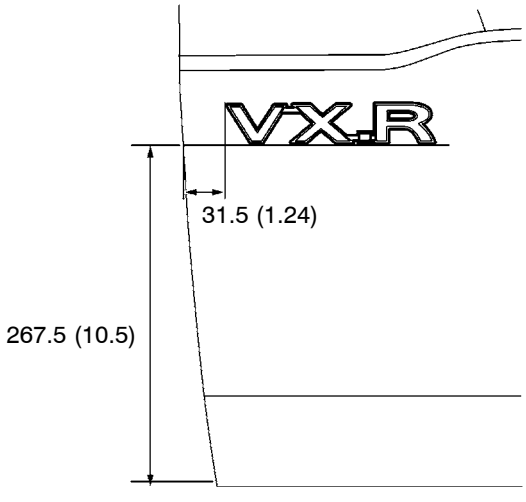
① REAR NO. 3 BODY NAME PLATE



② NO. 5 BACK DOOR NAME PLATE



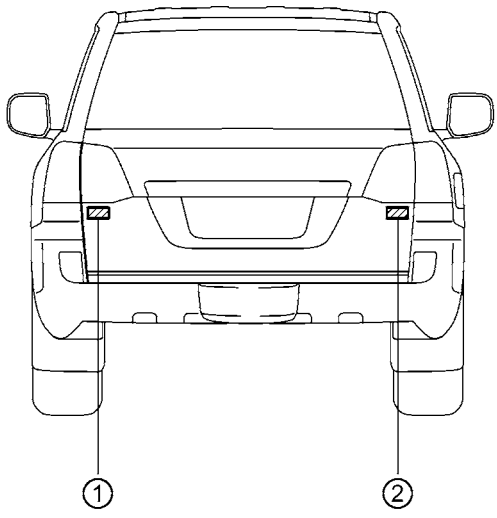
① REAR NO. 3 BODY NAME PLATE



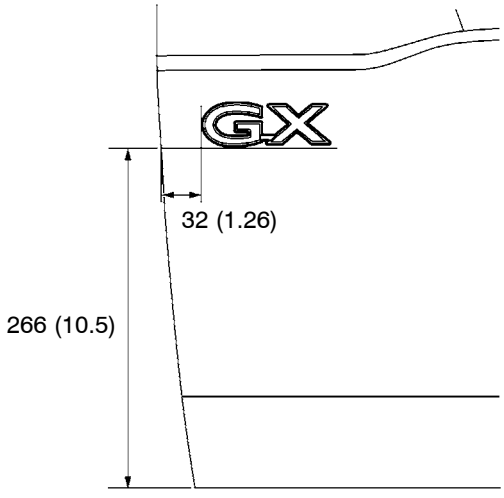
mm (in.)

F29296

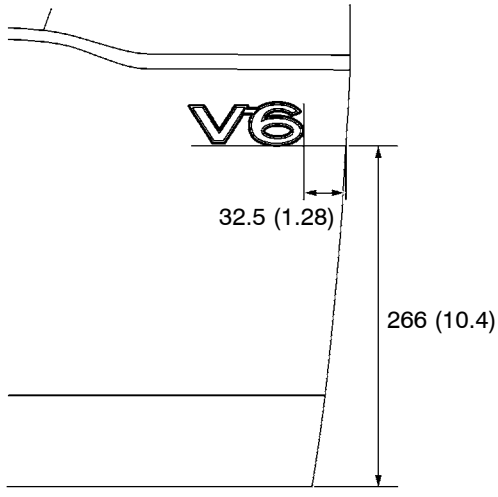
[Except USA, Canada]
for Type B:



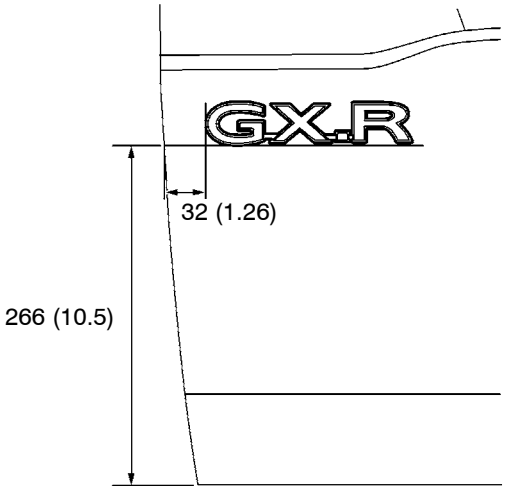
① REAR NO. 3 BODY NAME PLATE



② NO. 5 BACK DOOR NAME PLATE



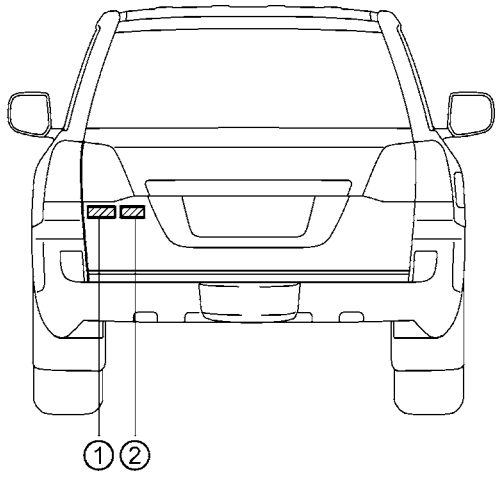
① REAR NO. 3 BODY NAME PLATE



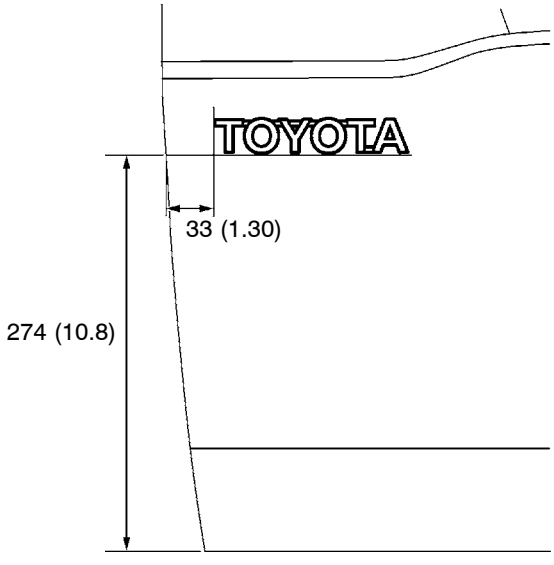
mm (in.)

F29297

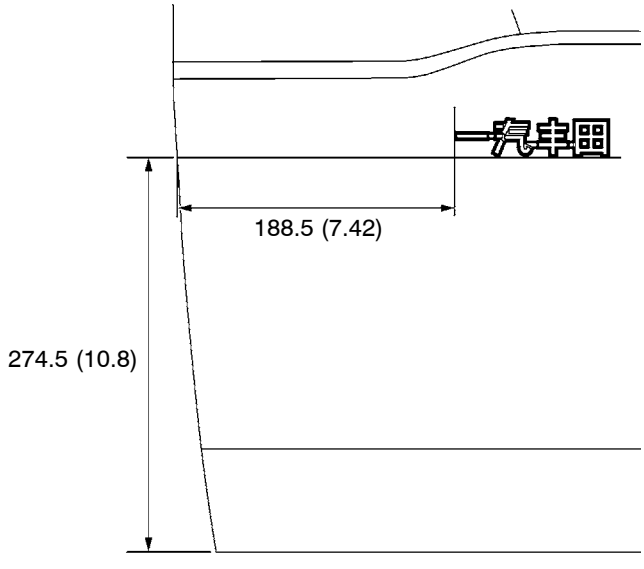
[Except USA, Canada]
for Type C:



① BACK DOOR NAME PLATE



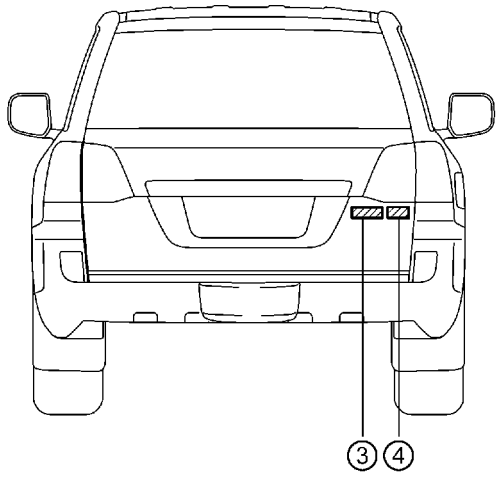
② NO. 6 LUGGAGE COMPARTMENT DOOR NAME PLATE



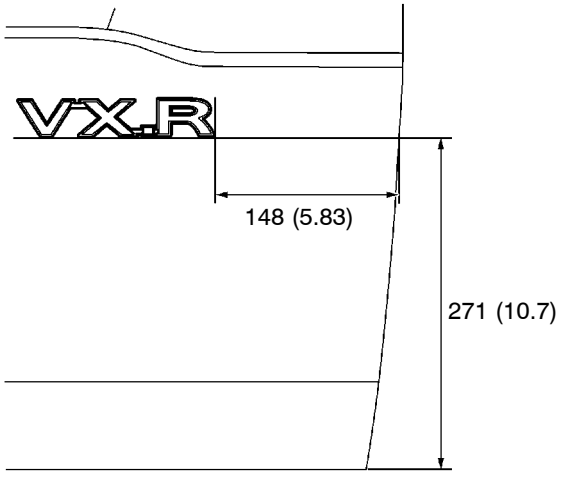
mm (in.)

F29298

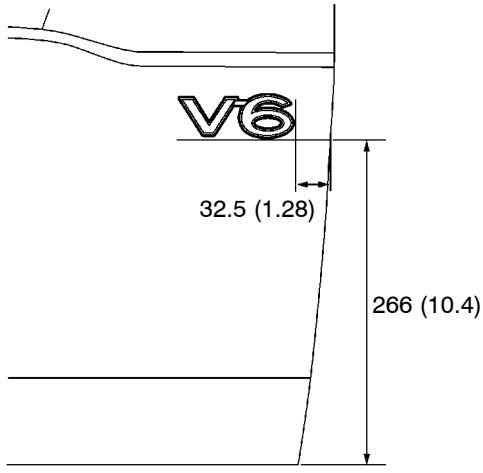
[Except USA, Canada]
for Type C:



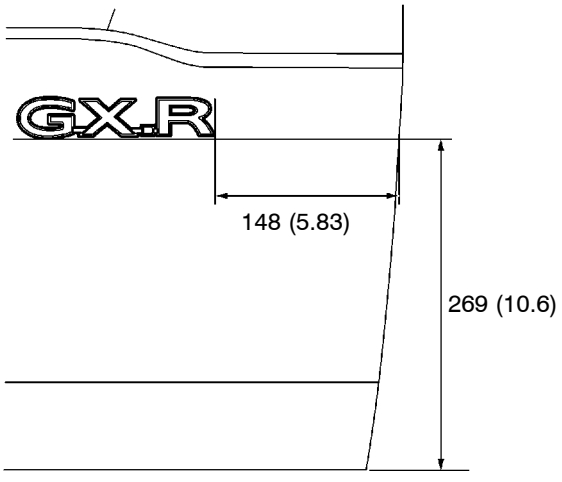
③ REAR NO. 3 BODY NAME PLATE



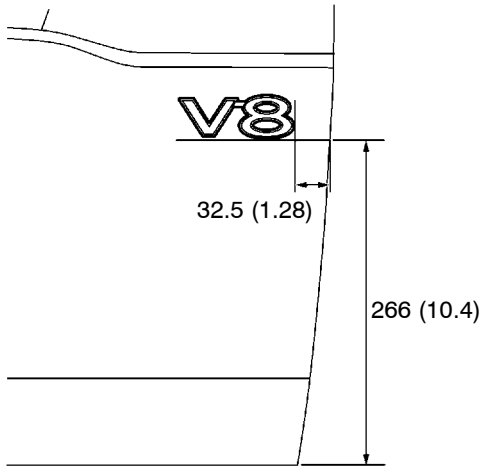
④ NO. 5 BACK DOOR NAME PLATE



③ REAR NO. 3 BODY NAME PLATE



④ NO. 5 BACK DOOR NAME PLATE

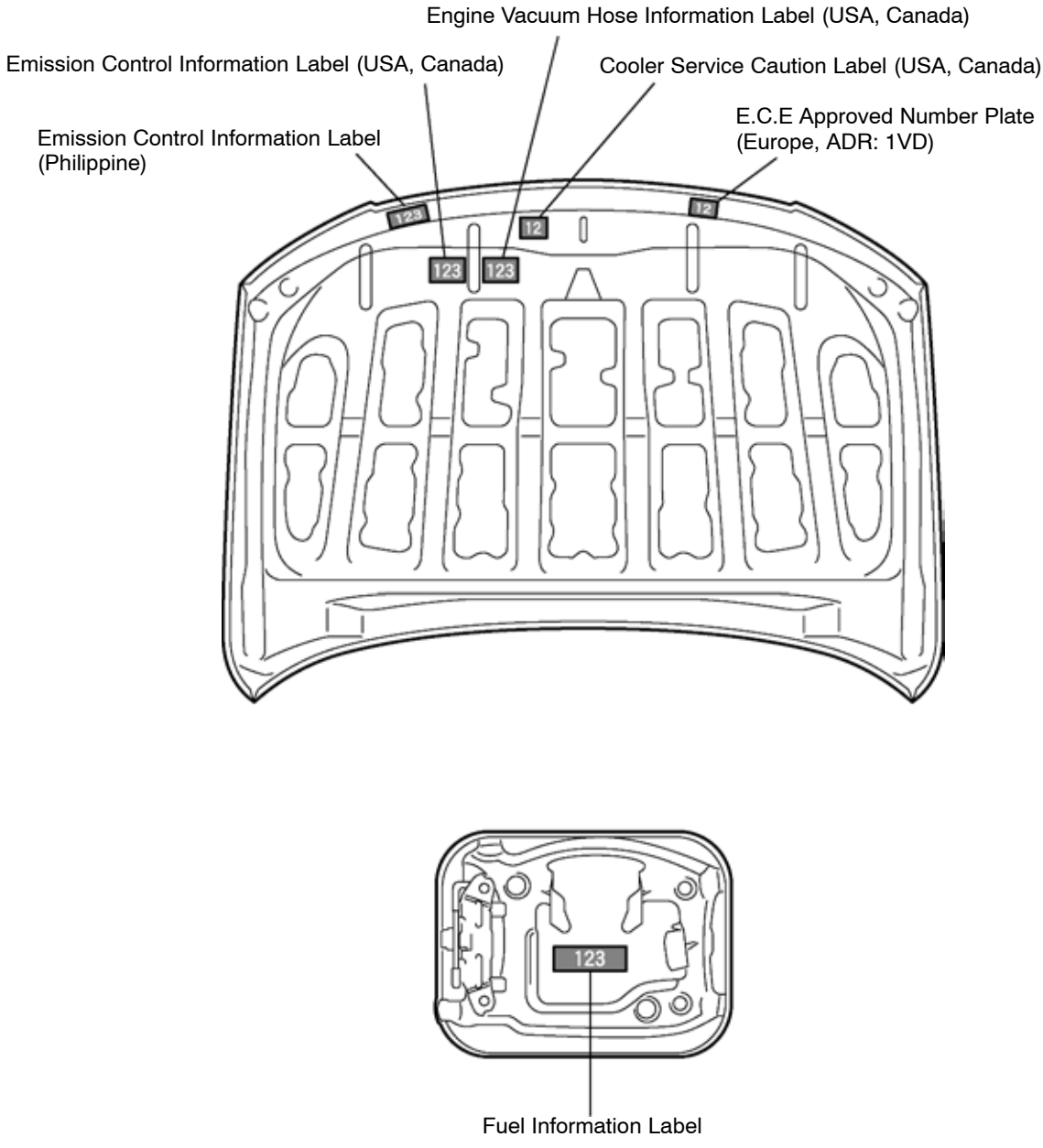


mm (in.)

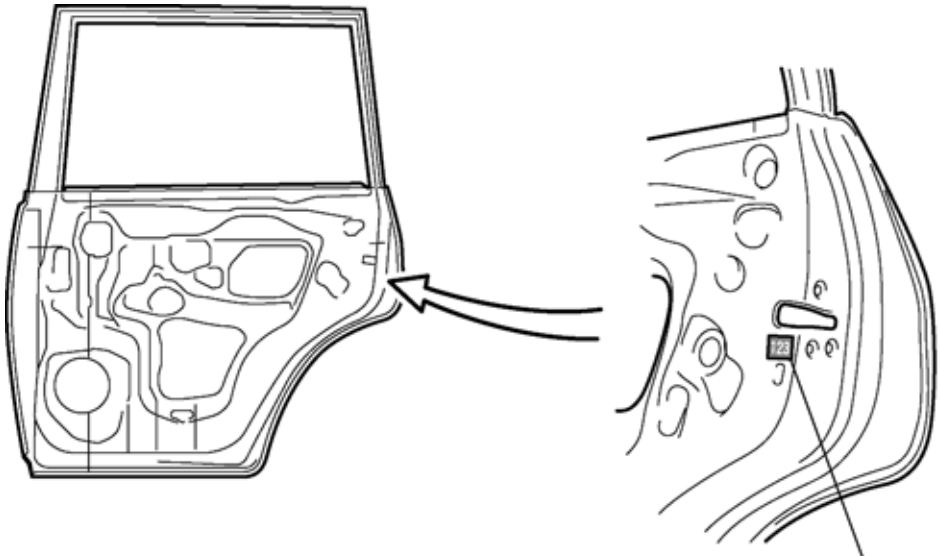
F29299

CAUTION LABEL ATTACHMENT POSITION

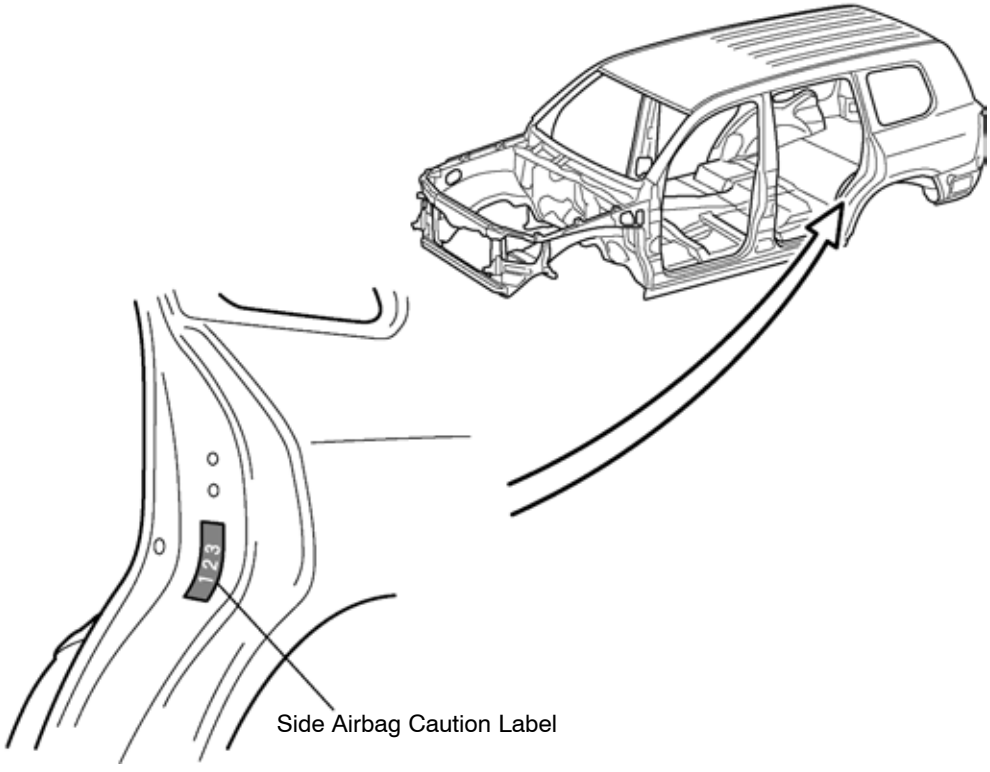
1 After using a degreasing agent to clean the surfaces of the body where the caution labels will be attached, attach the caution labels to the positions shown in the illustration.
HINT:
- *Attach each caution label with its orientation the same as the numbers shown in the illustration.*
- *Make sure the caution label is not attached over a spot weld.*
- *When attaching the caution label, make sure not to touch the label's adhesive surface.*
- *To prevent the edges of the caution label from peeling, apply extra pressure to the label's periphery.*
- *If the work area's temperature is 5°C or less, the caution label's adhesive will deteriorate. It is recommended that you heat the label to 20 to 40°C.*



F29277



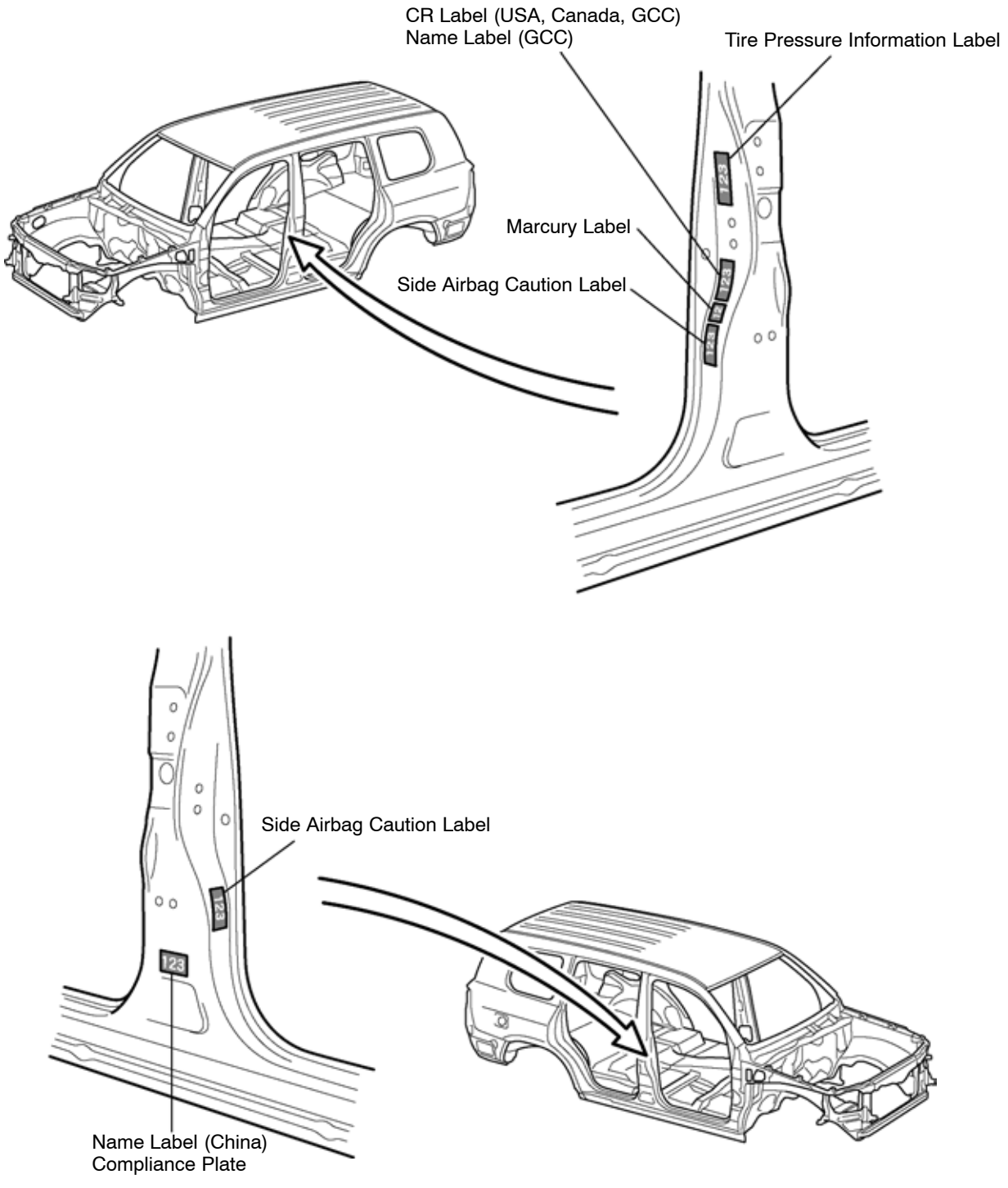
Child Protect Lock Caution Plate



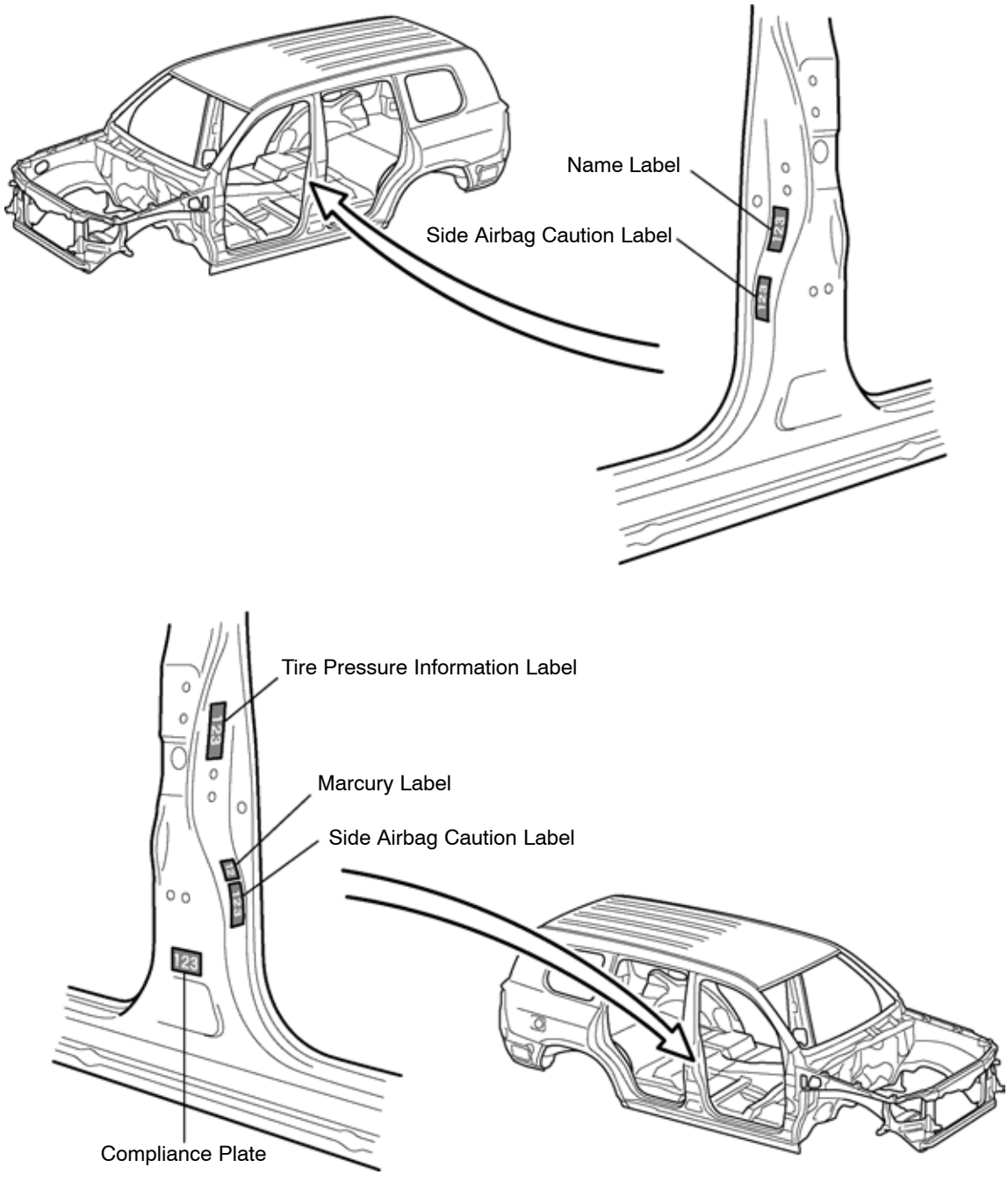
Side Airbag Caution Label

F29278

[LHD]


CR Label (USA, Canada, GCC)
Name Label (GCC)
Tire Pressure Information Label
Marcury Label
Side Airbag Caution Label
Side Airbag Caution Label
Name Label (China)
Compliance Plate
F29279

[RHD]


Name Label
Side Airbag Caution Label
Tire Pressure Information Label
Marcury Label
Side Airbag Caution Label
Compliance Plate
F29280