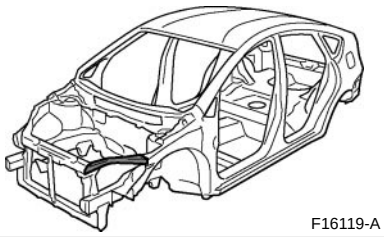
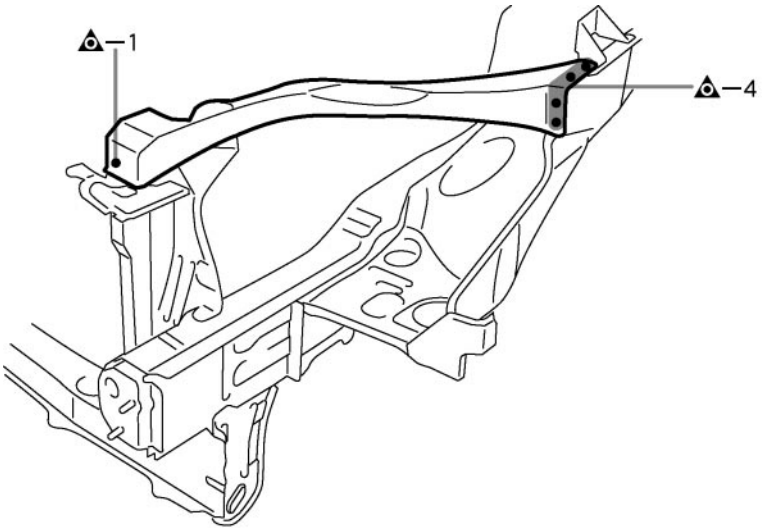
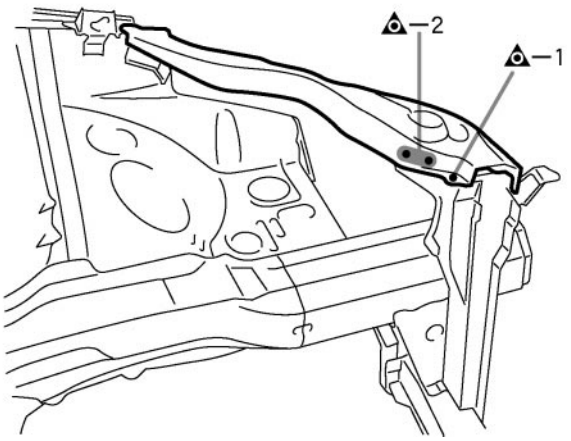
RADIATOR UPPER SUPPORT (ASSY)


F16119-A

REPLACEMENT

REMOVAL

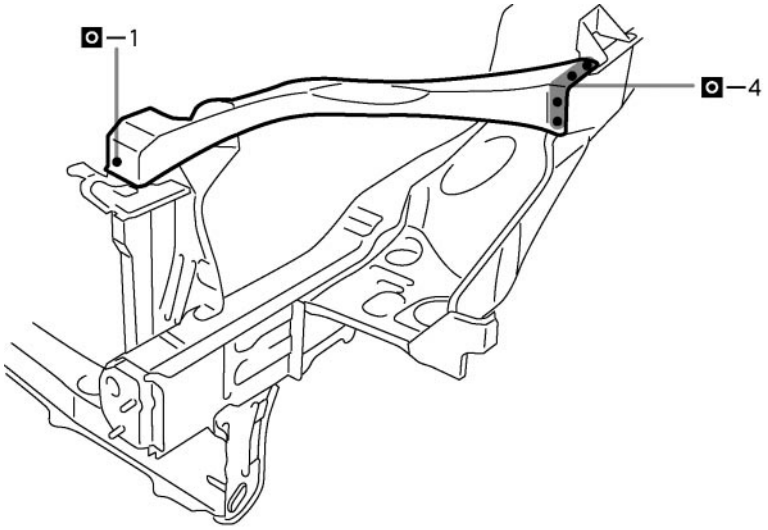


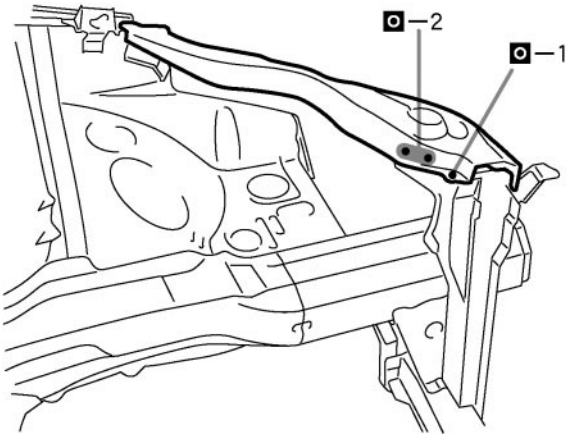


F16119

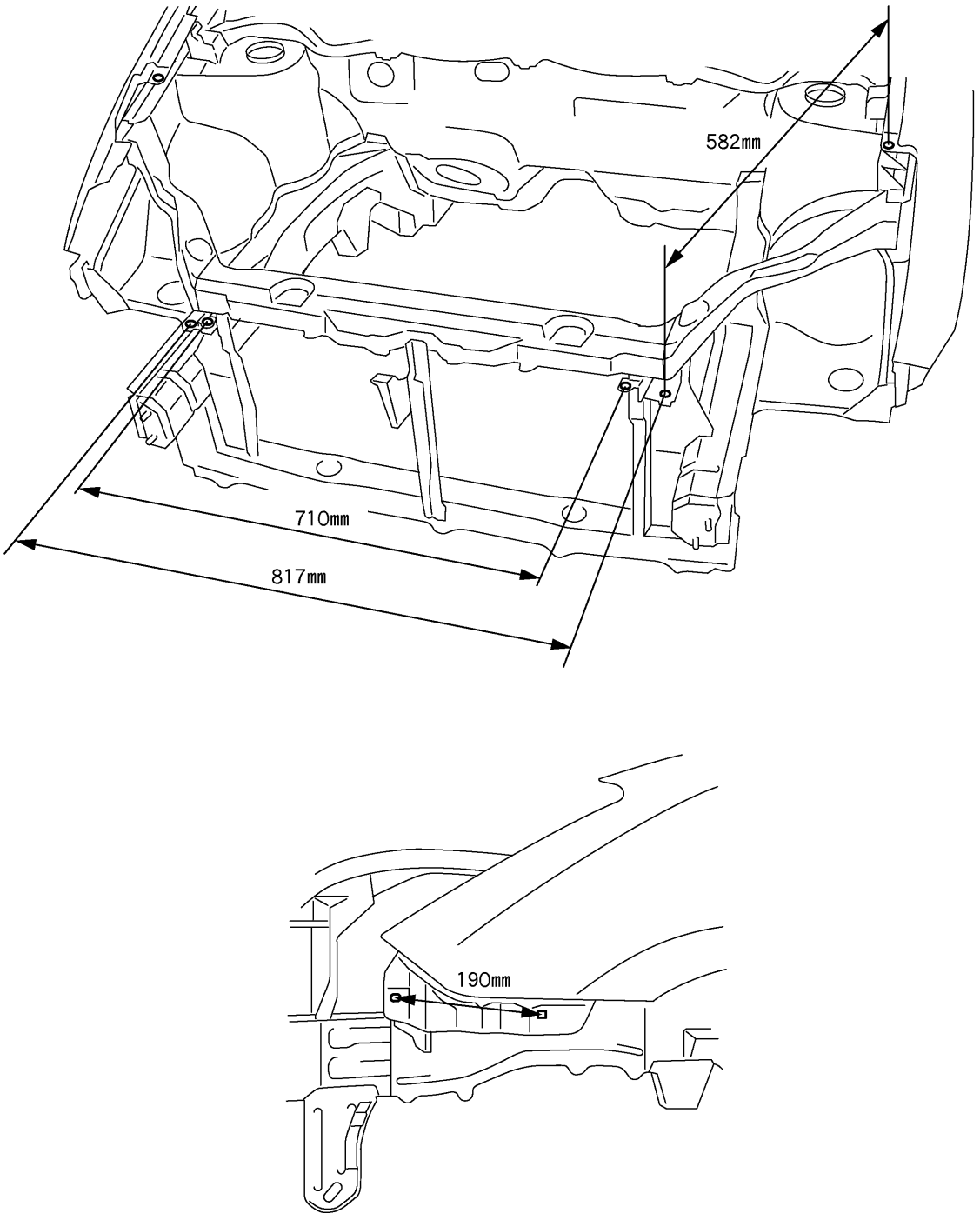
INSTALLATION

- 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)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.





F16120



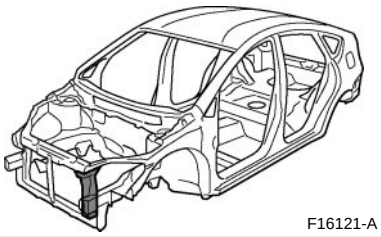
F16133

POINT

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

190mm (7.48in.) 582mm (22.91in.) 710mm (27.95in.) 817mm (32.17in.)

RADIATOR SIDE SUPPORT (ASSY)

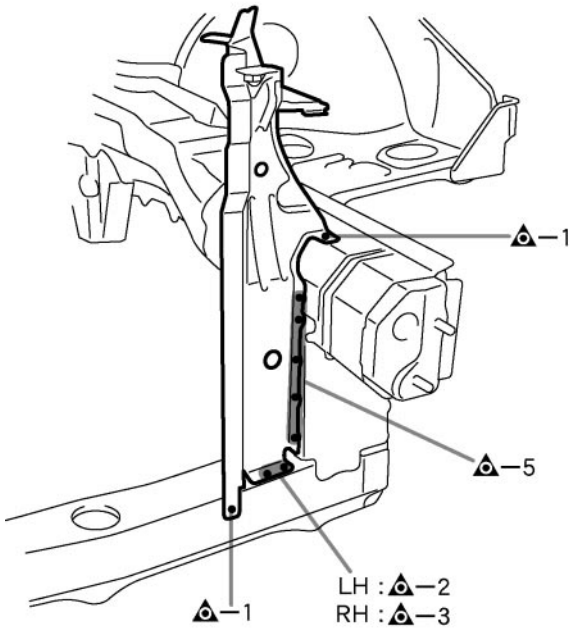

F16121-A

REPLACEMENT

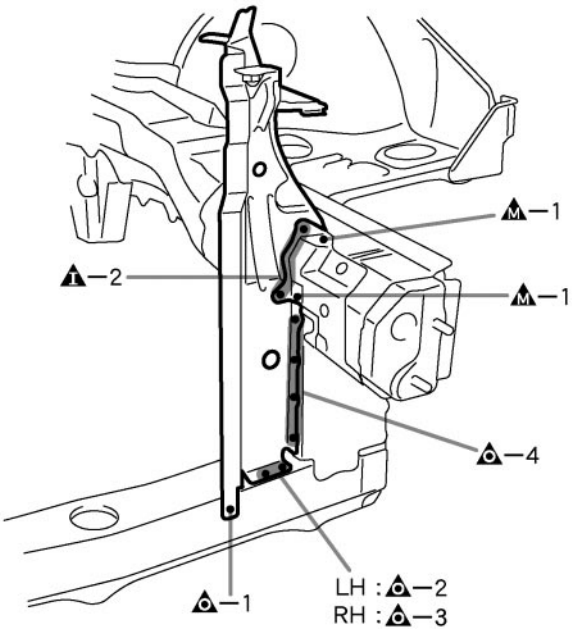
With the radiator upper support removed.

REMOVAL

〔RHD〕



〔LHD〕

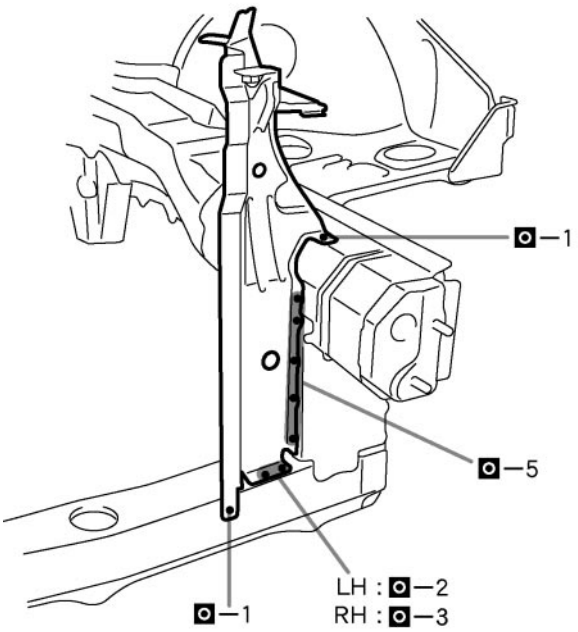


F16123

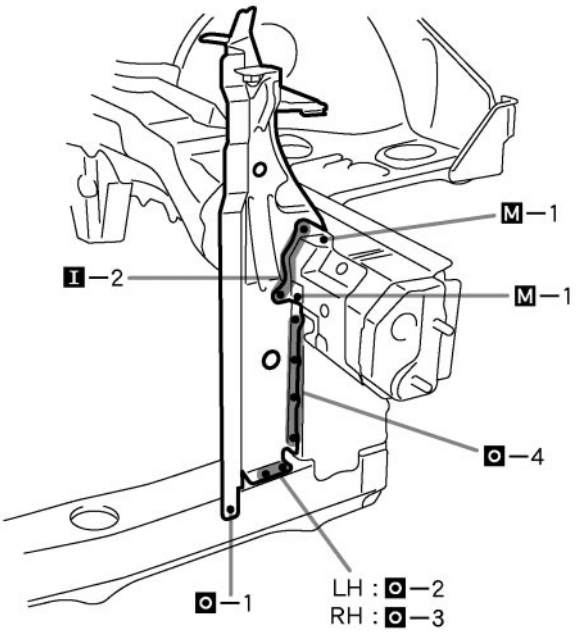
INSTALLATION

- 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)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.

〔RHD〕

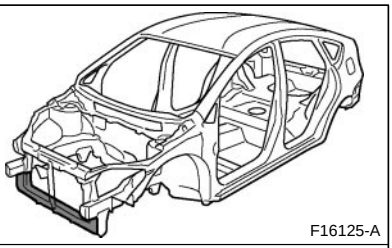


〔LHD〕



F16124

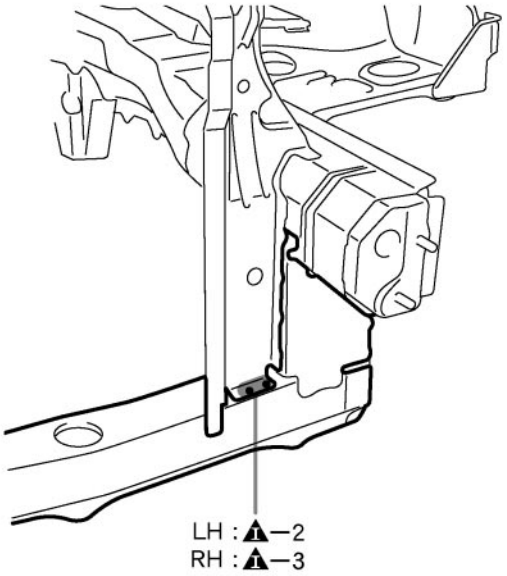
FRONT CROSSMEMBER (ASSY)

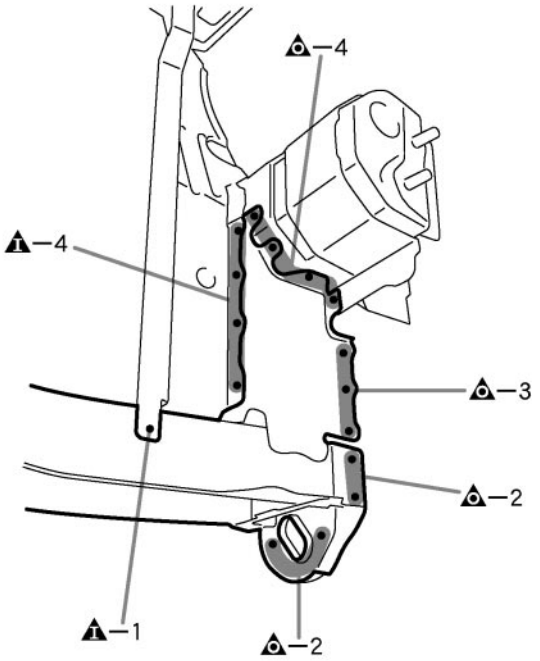

F16125-A

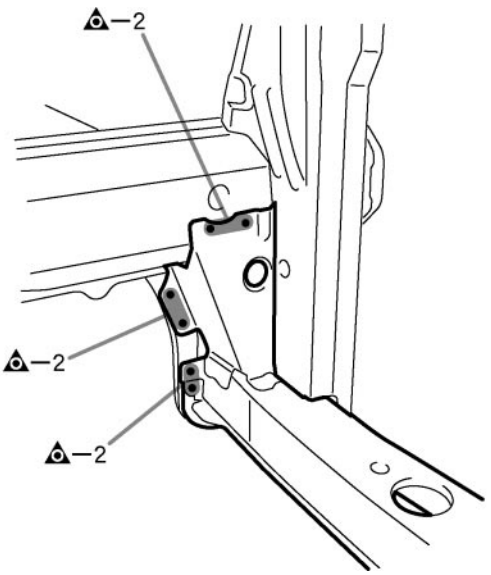
REPLACEMENT

REMOVAL

〔RHD〕

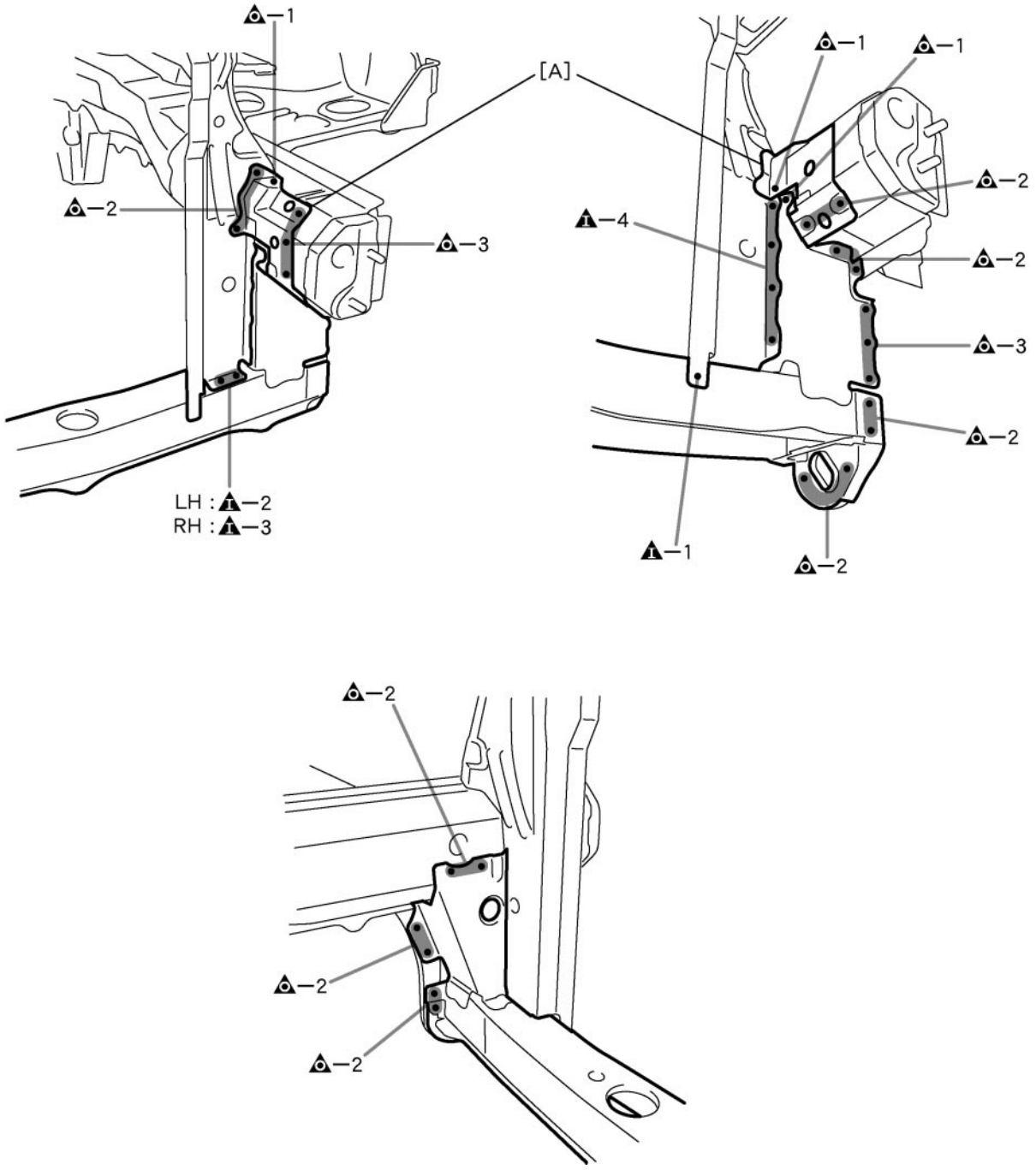






F16125

〔LHD〕



F16126

POINT

1 Remove the [A] at the same time.

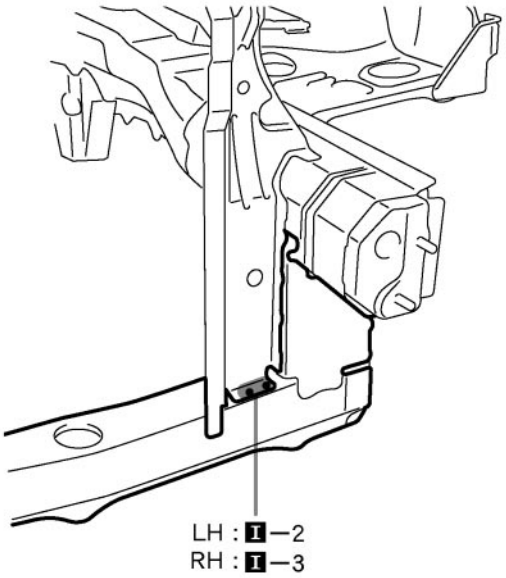
PART NAME

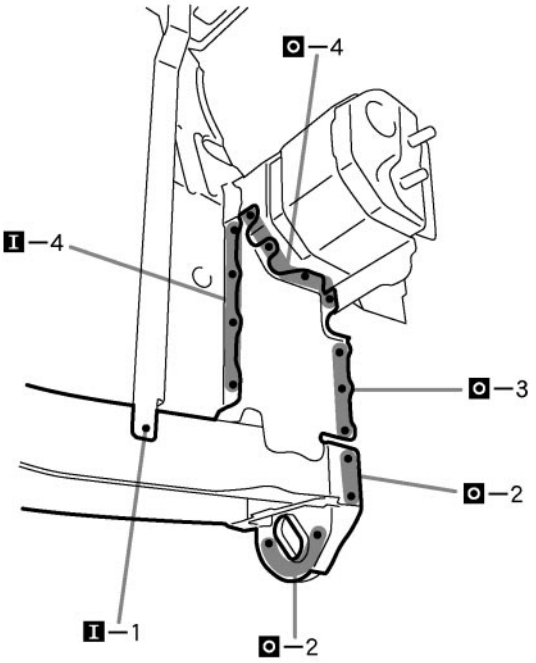
[A] Front Sidemember Support

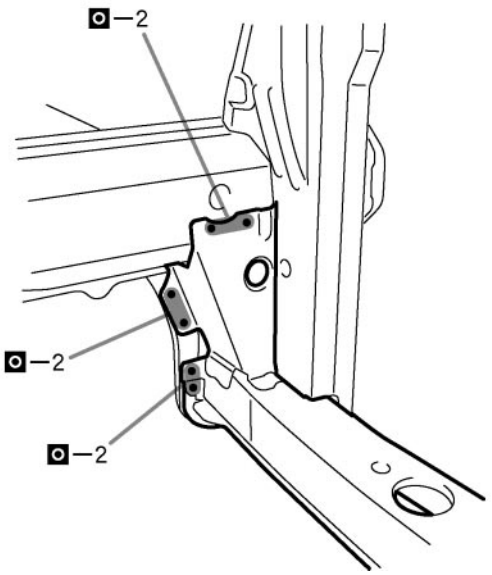
INSTALLATION

- 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)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.

〔RHD〕

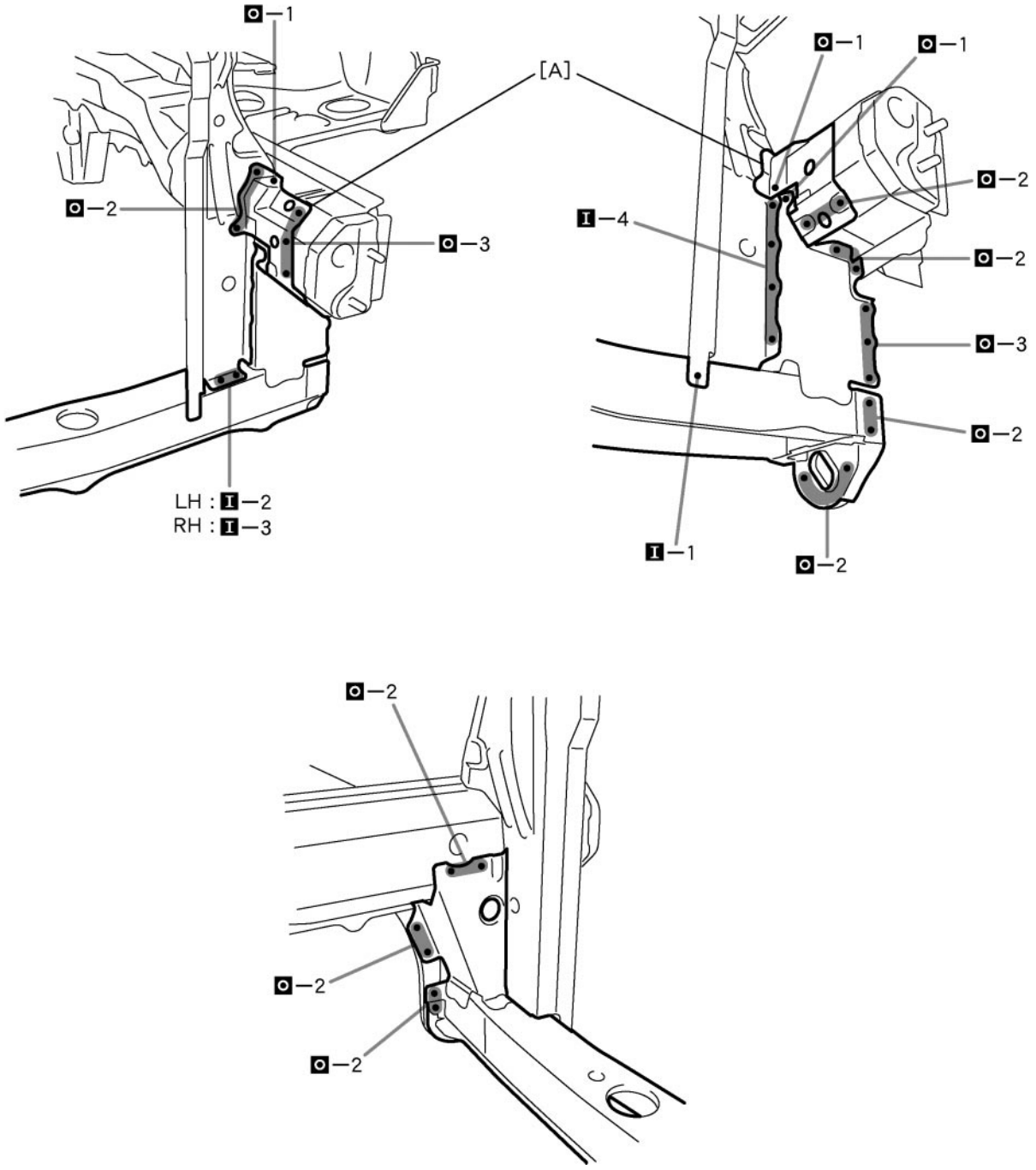






F16127

〔LHD〕

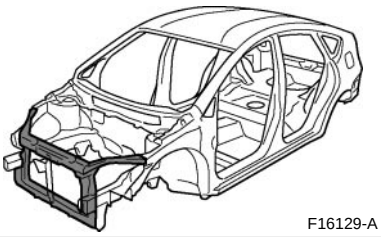


F16128

PART NAME

[A] Front Sidemember Support

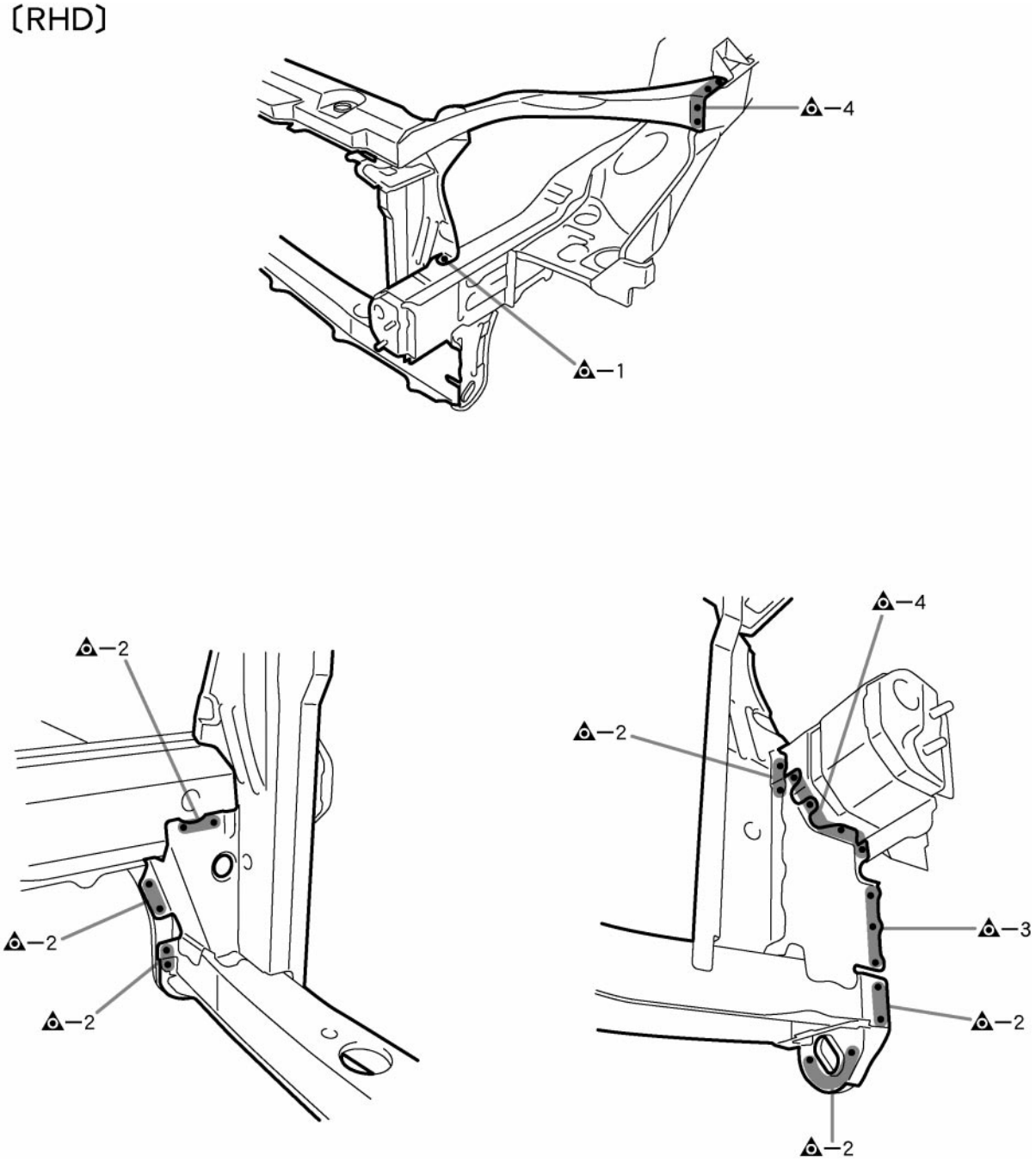
RADIATOR SUPPORT (ASSY)


F16129-A

REPLACEMENT

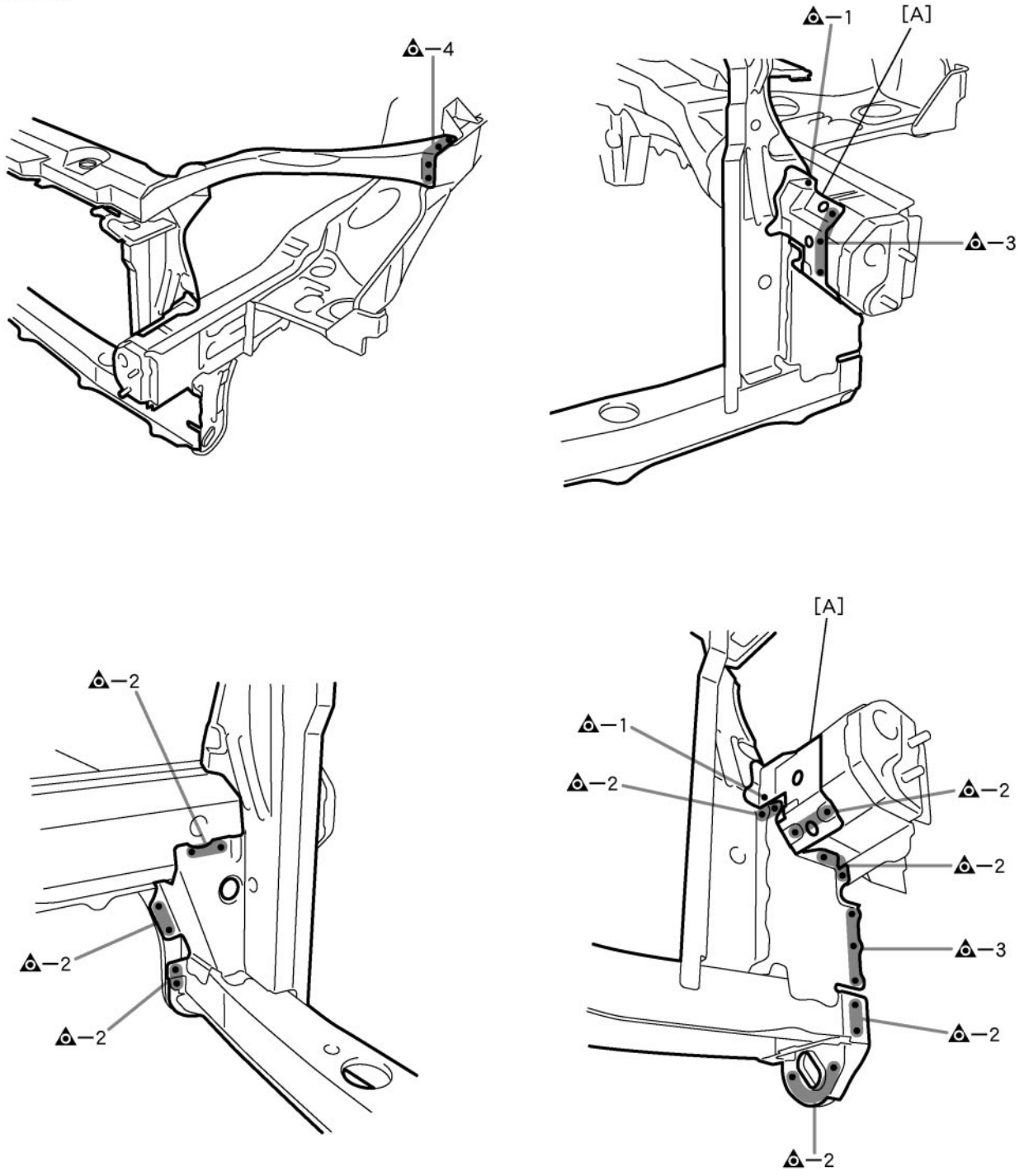
REMOVAL

〔RHD〕



F16129

〔LHD〕



POINT

1 Remove the [A] at the same time.

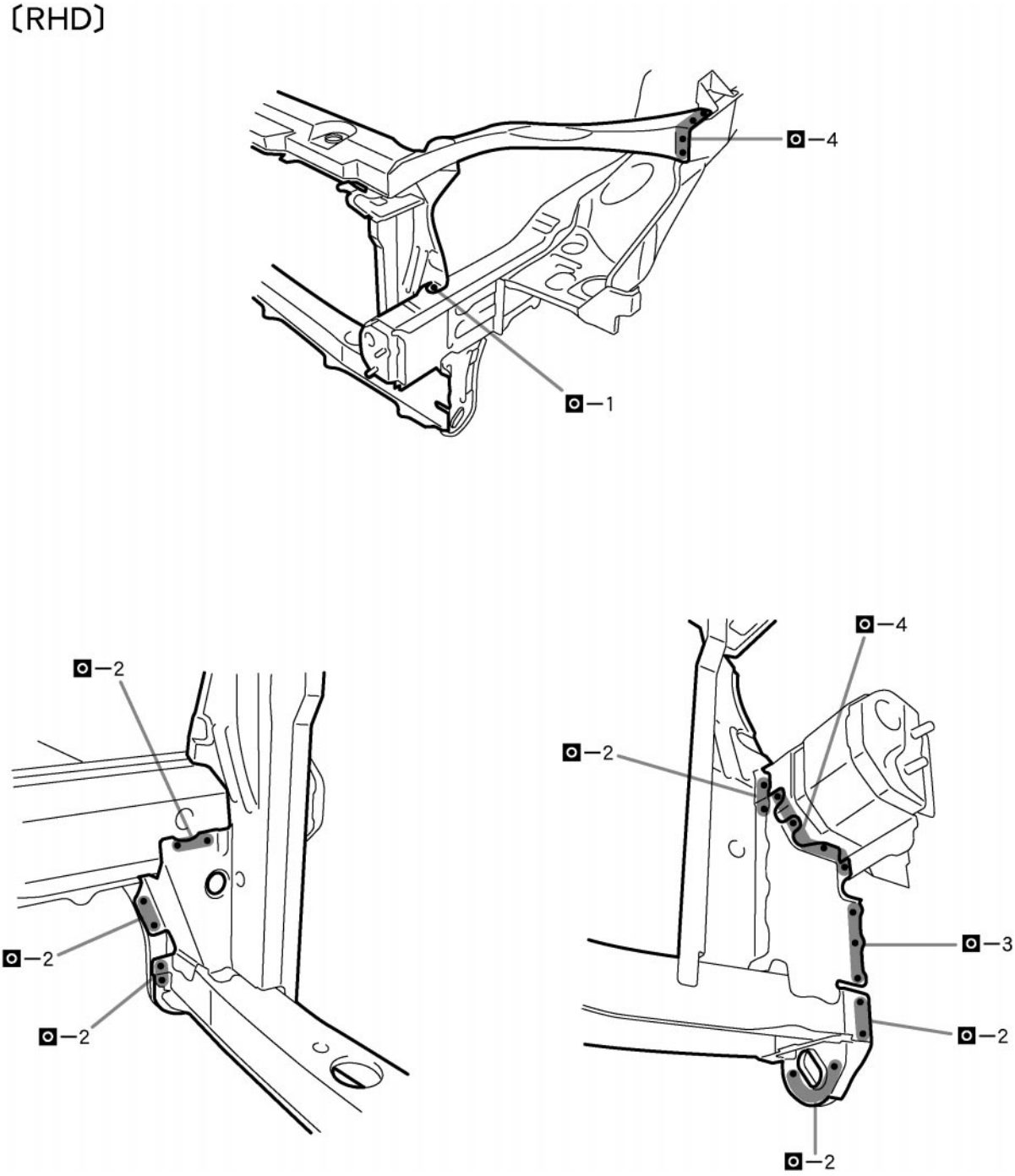
PART NAME

[A] Front Sidemember Support

INSTALLATION

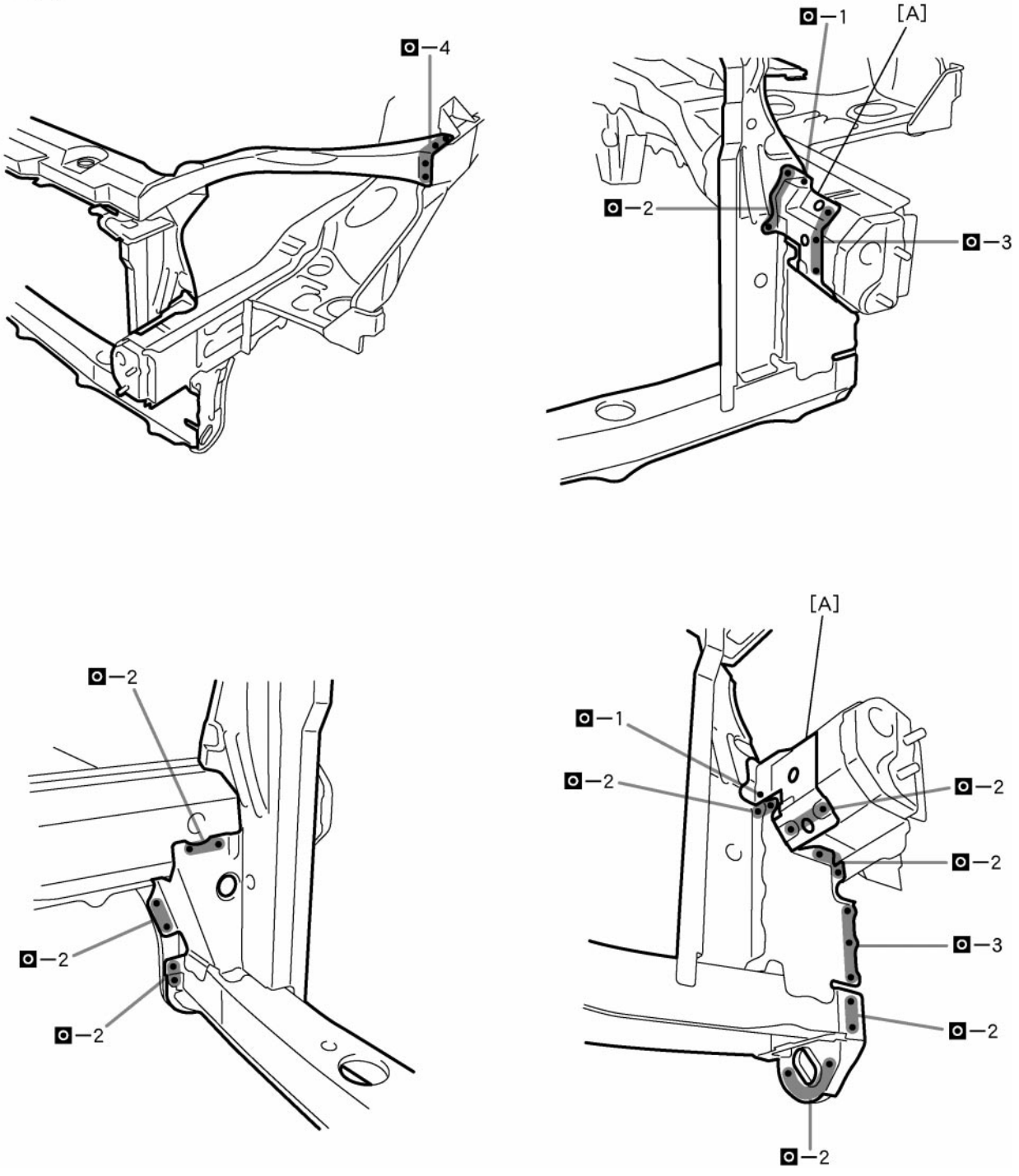
- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.

〔RHD〕



F16131

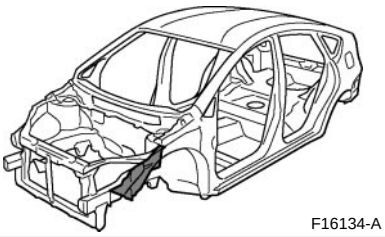
〔LHD〕



F16132

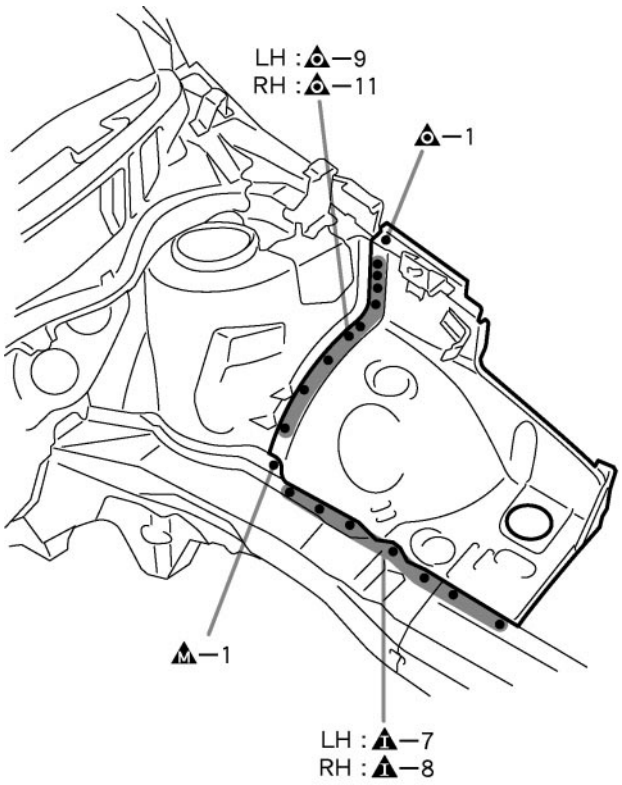
PART NAME
[A] Front Sidemember Support

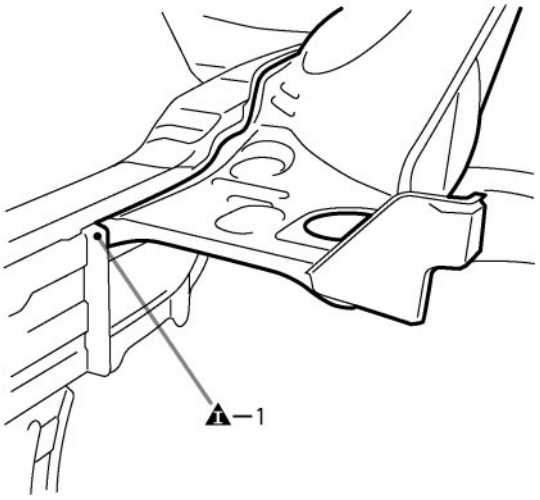
FRONT FENDER APRON FRONT WITH SUPPORT (ASSY)


F16134-A

REPLACEMENT
With the radiator upper support removed.

REMOVAL

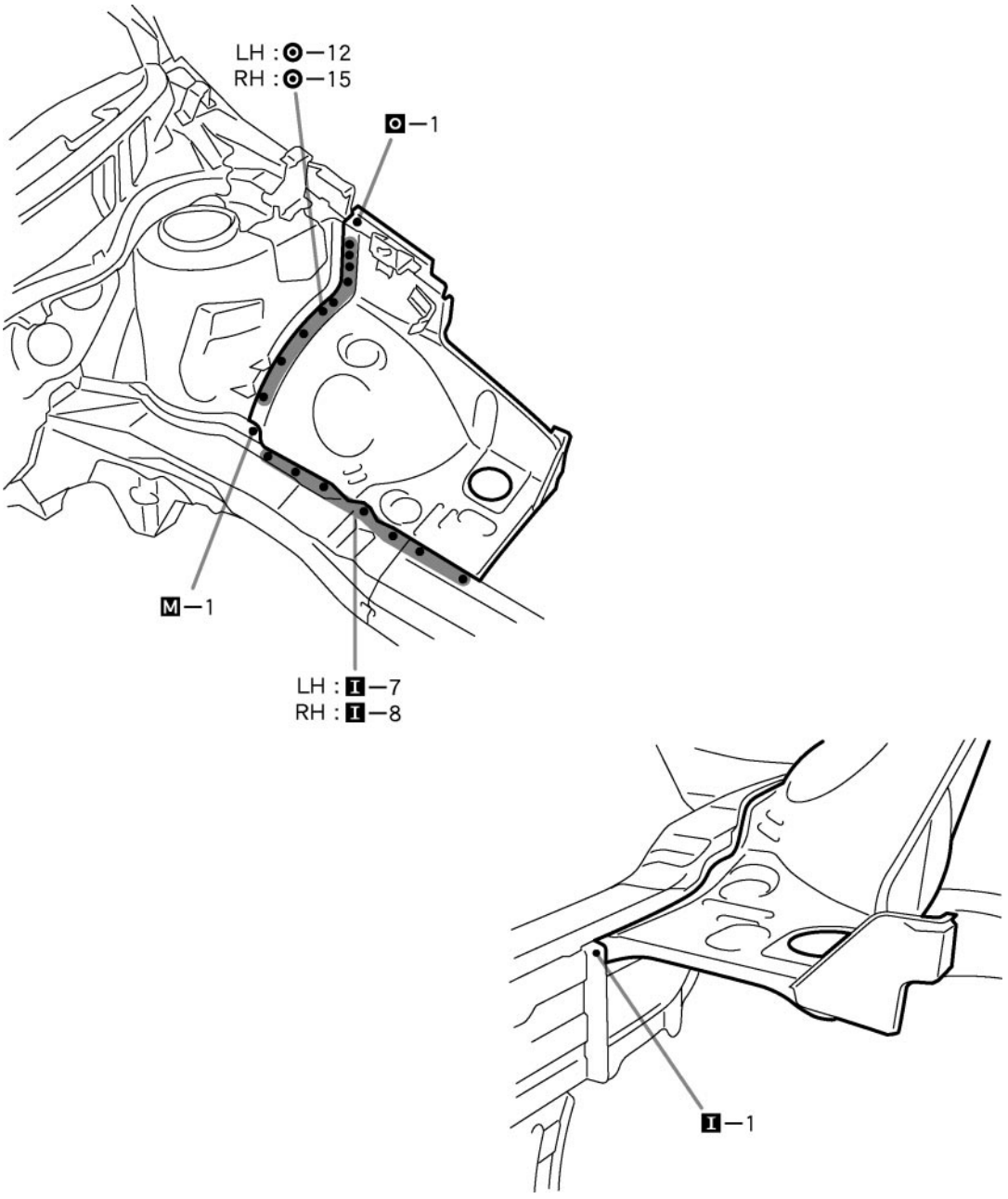




F16134

INSTALLATION

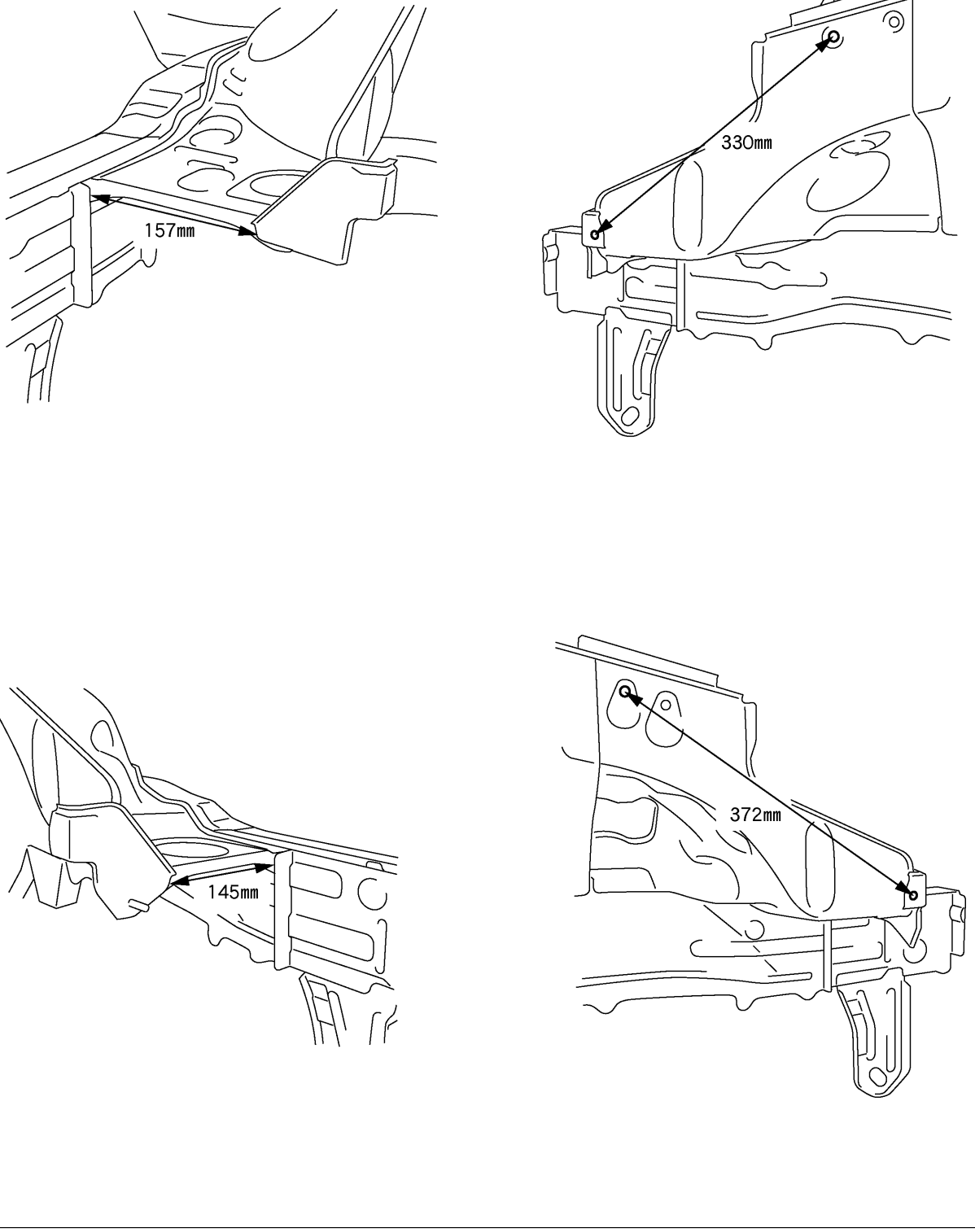
- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



F16135

POINT

1 Inspect the fitting of the front fender and hood, etc., before welding, since this affects the appearance of the finish.



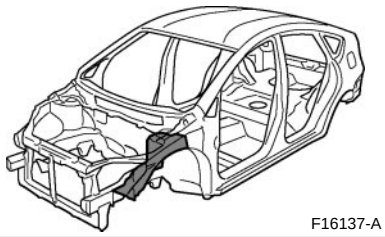
F16136

POINT

1 These values are reference values.

145mm (5.71in.) 157mm (6.18in.) 330mm (12.99in.) 372mm (14.65in.)

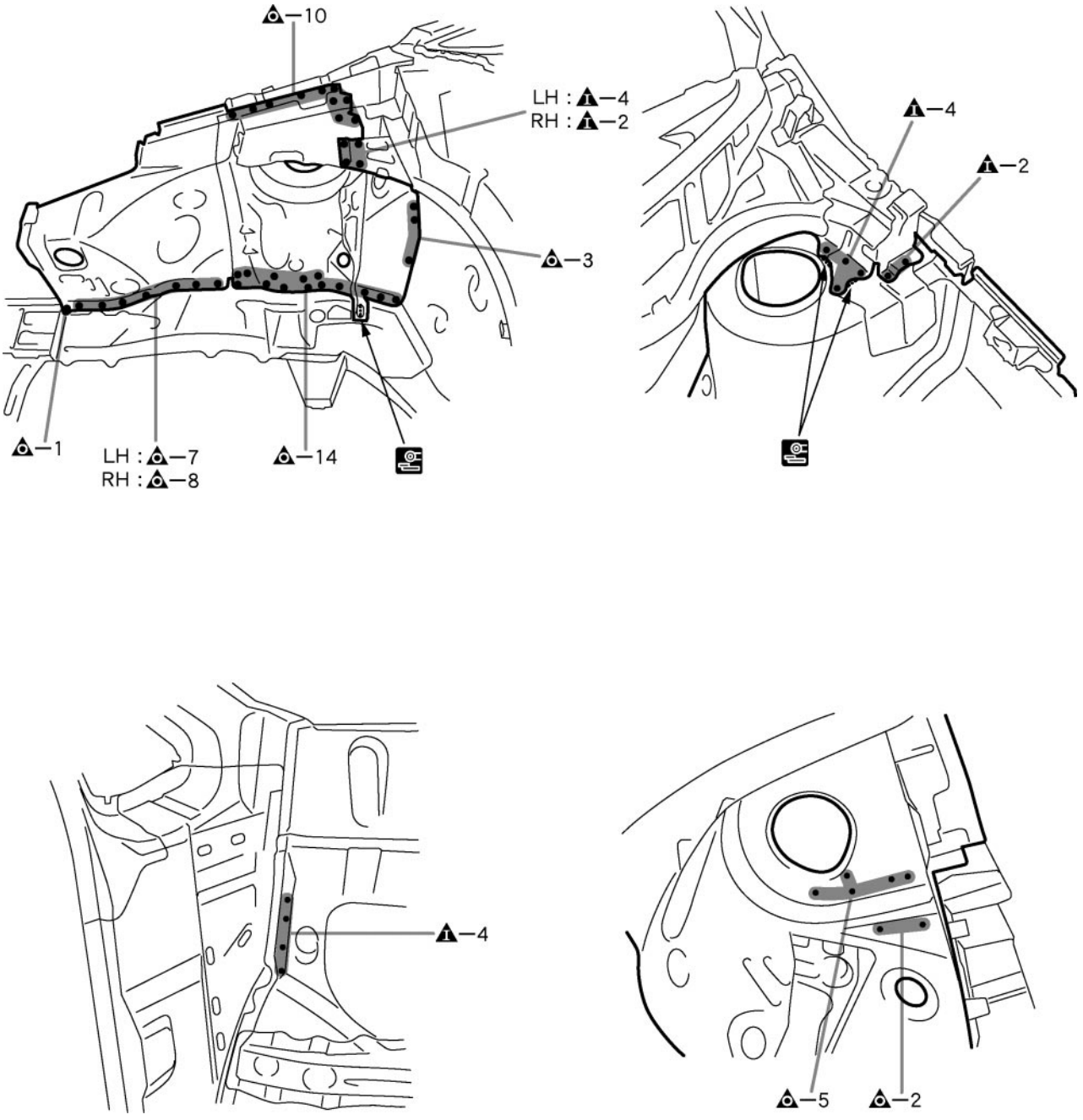
FRONT FENDER APPON (ASSY)


F16137-A

REPLACEMENT

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

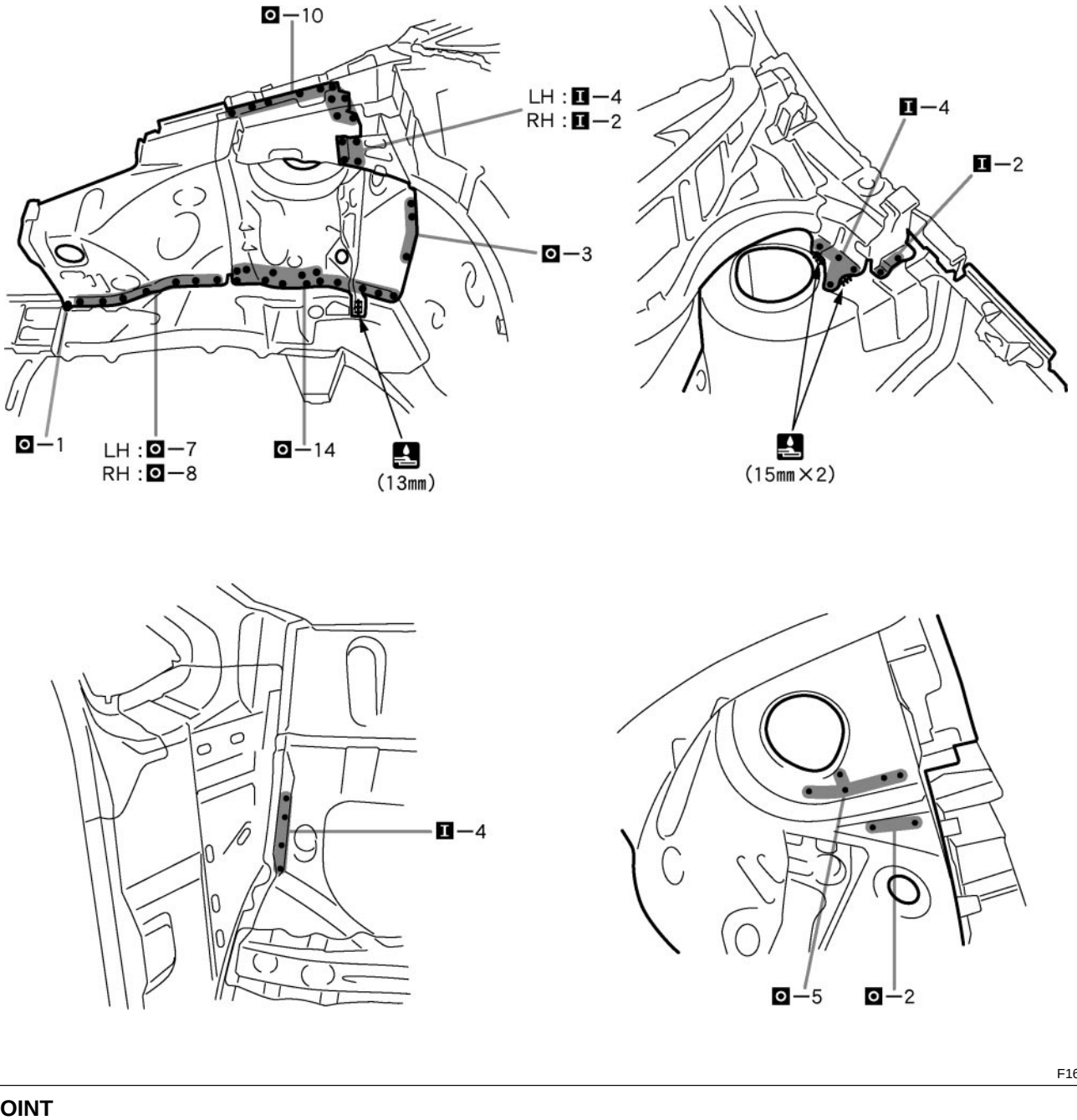
REMOVAL



F16137

INSTALLATION

- 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)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



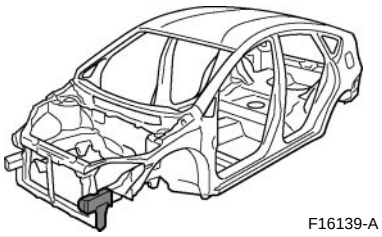
F16138

POINT

1 Make sure each measurement is correct, as this parts affects the front wheel alignment.
2 Inspect the fitting of the front fender and hood, etc., before welding, since this affects the appearance of the finish.

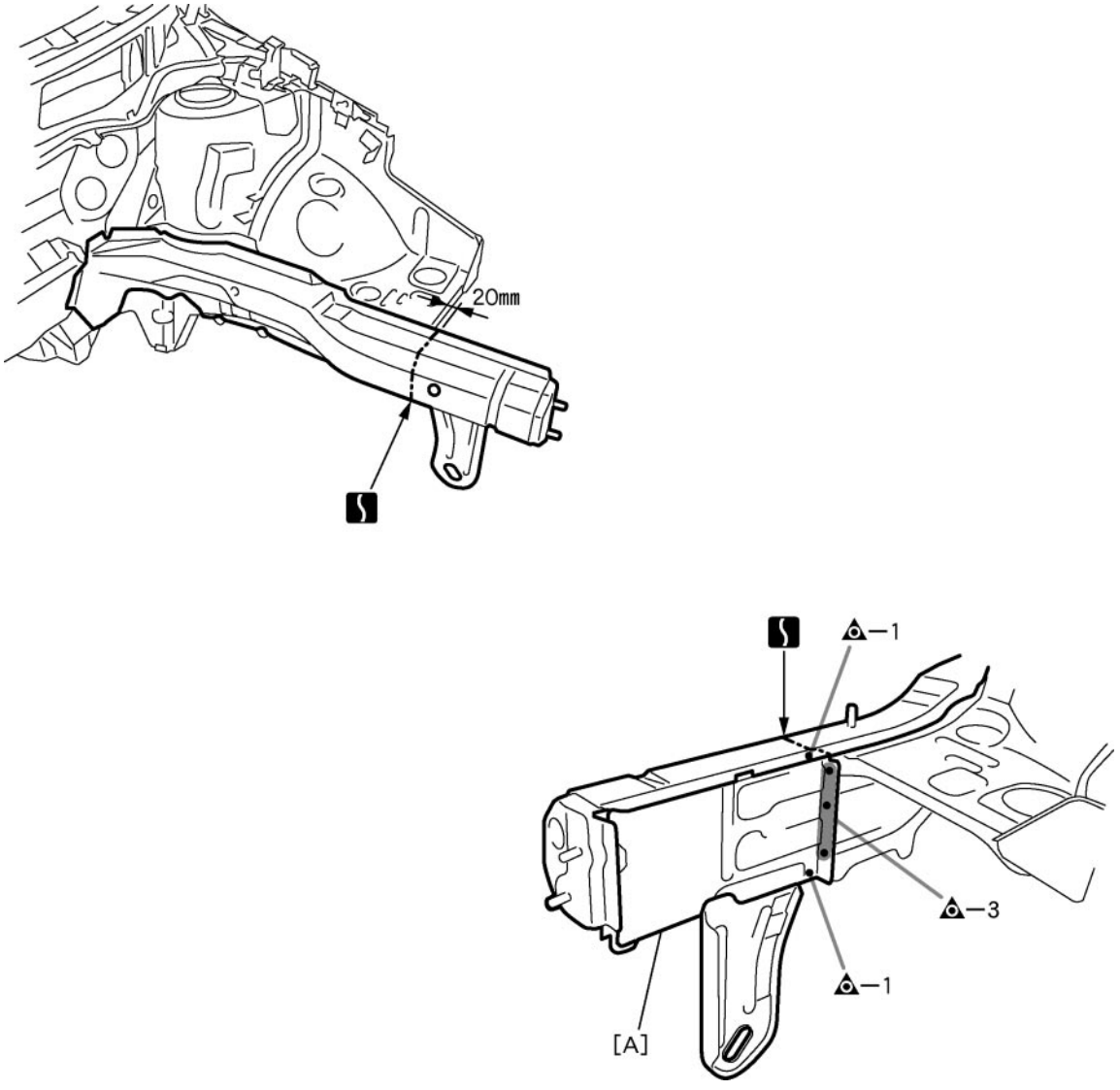
13mm (0.51in.) 15mm (0.59in.)

FRONT SIDE MEMBER (CUT-P)


F16139-A

REPLACEMENT
With the radiator side support and front crossmember removed.

REMOVAL



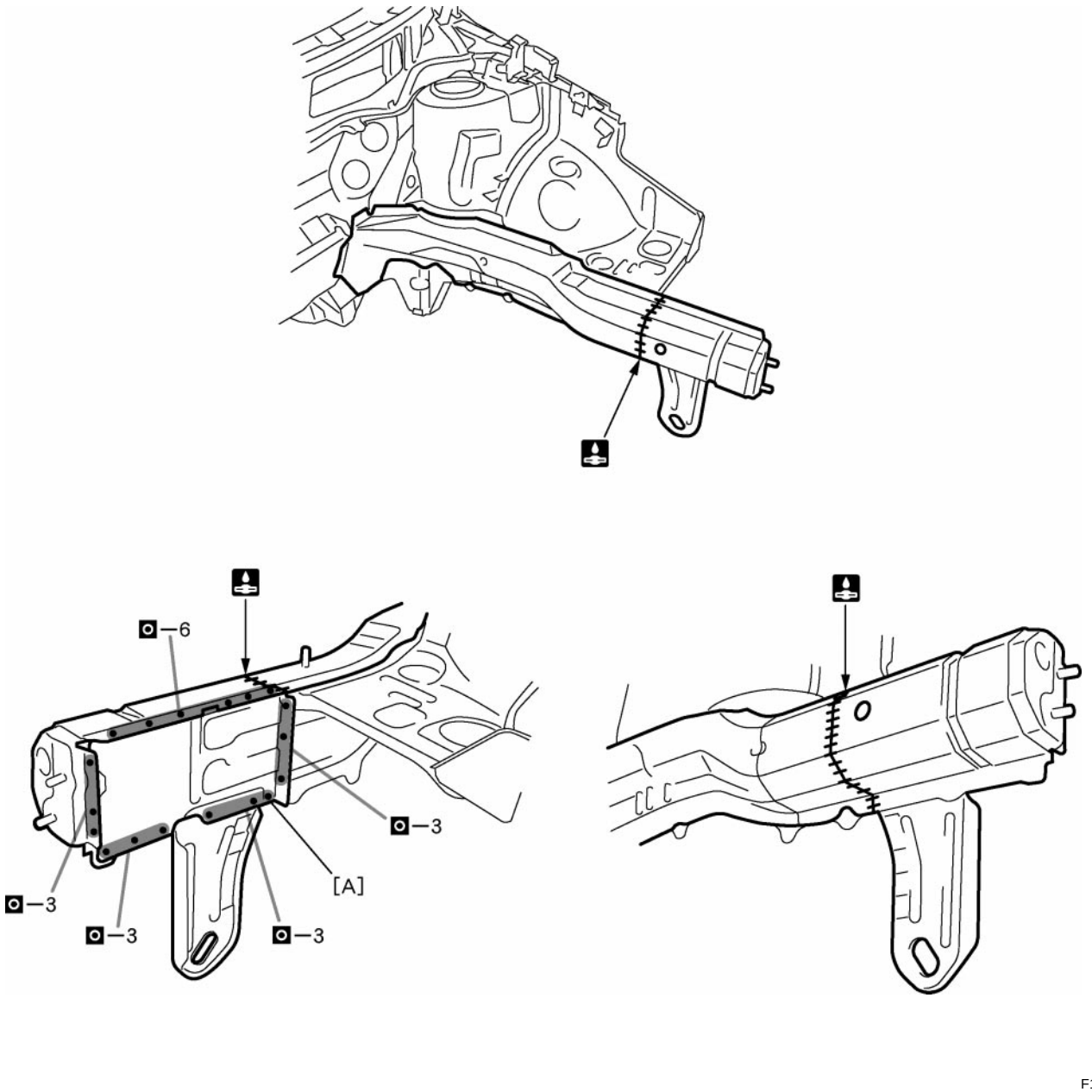
F16139

POINT
1 Rmove the [A] at the same time.

PART NAME
[A] Front Sidememeber Extension
20mm (0.79in.)

INSTALLATION

- 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)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.

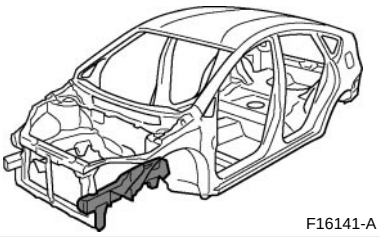


F16140

PART NAME

[A] Front Sidememeber Extension

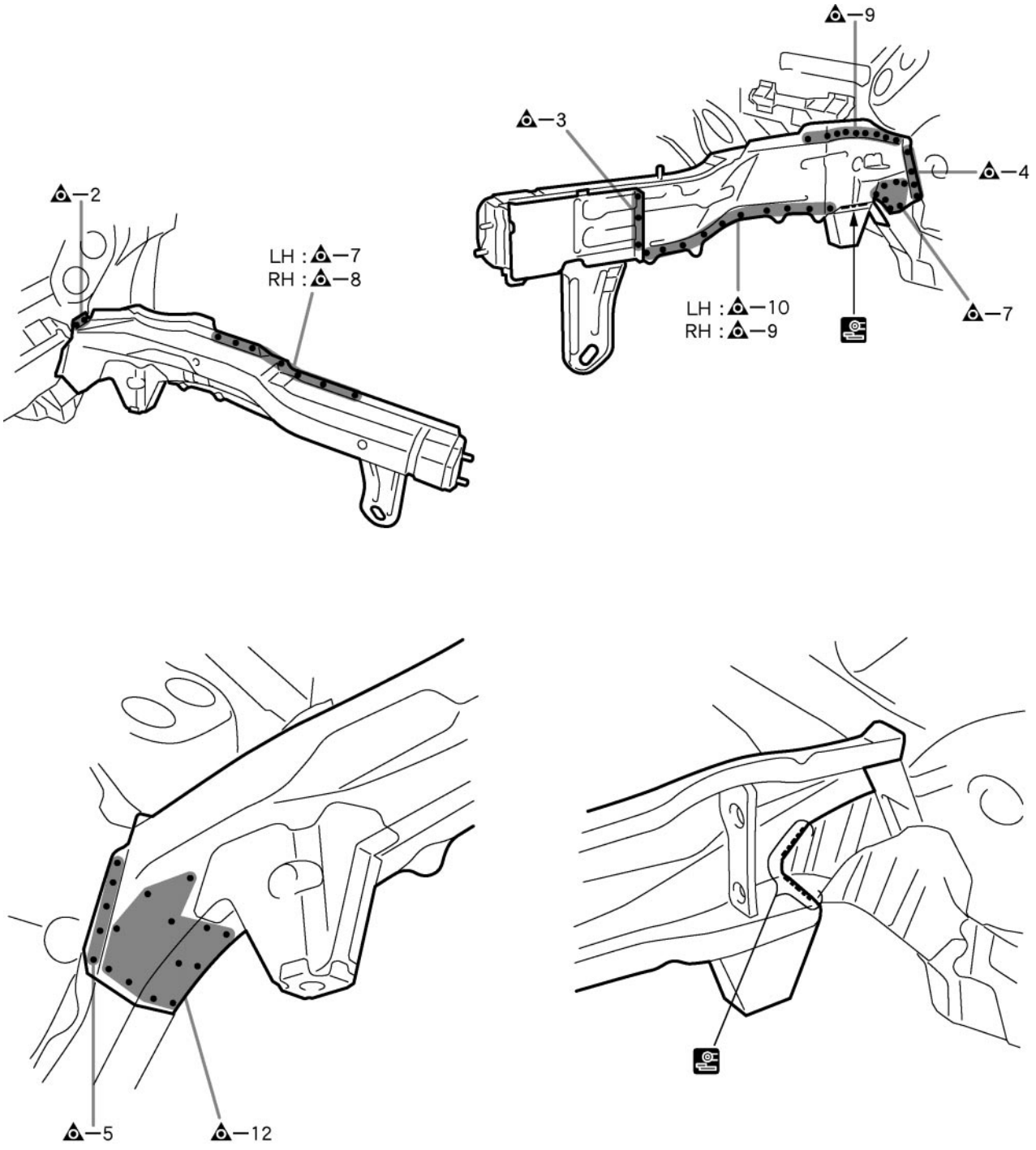
FRONT SIDE MEMBER (ASSY)


F16141-A

REPLACEMENT

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

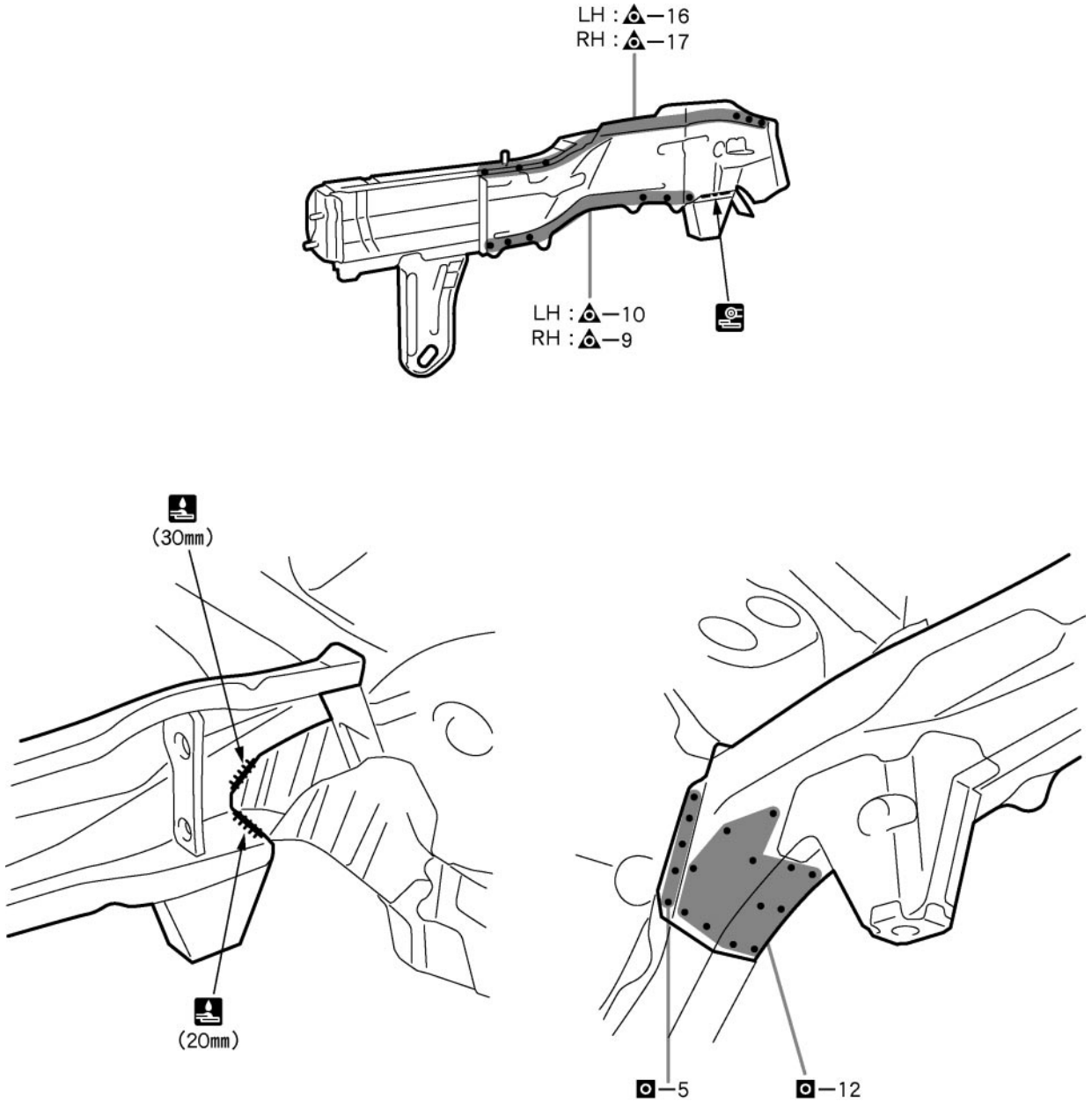
REMOVAL



F16141

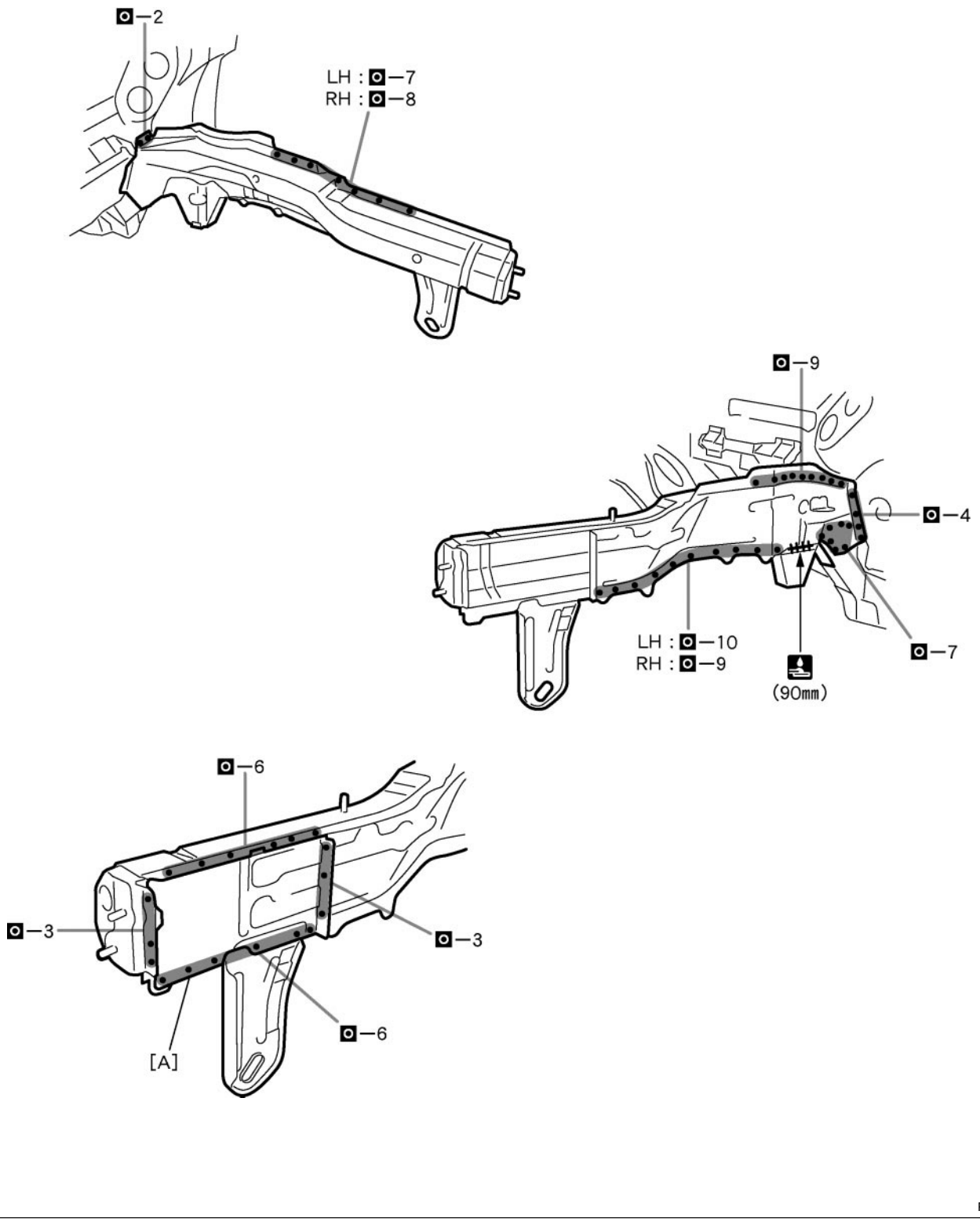
INSTALLATION

- 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)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



F16142

20mm (0.79in.) 30mm (1.18in.)



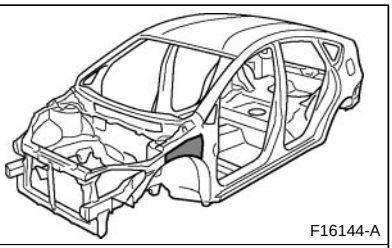
POINT

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

PART NAME

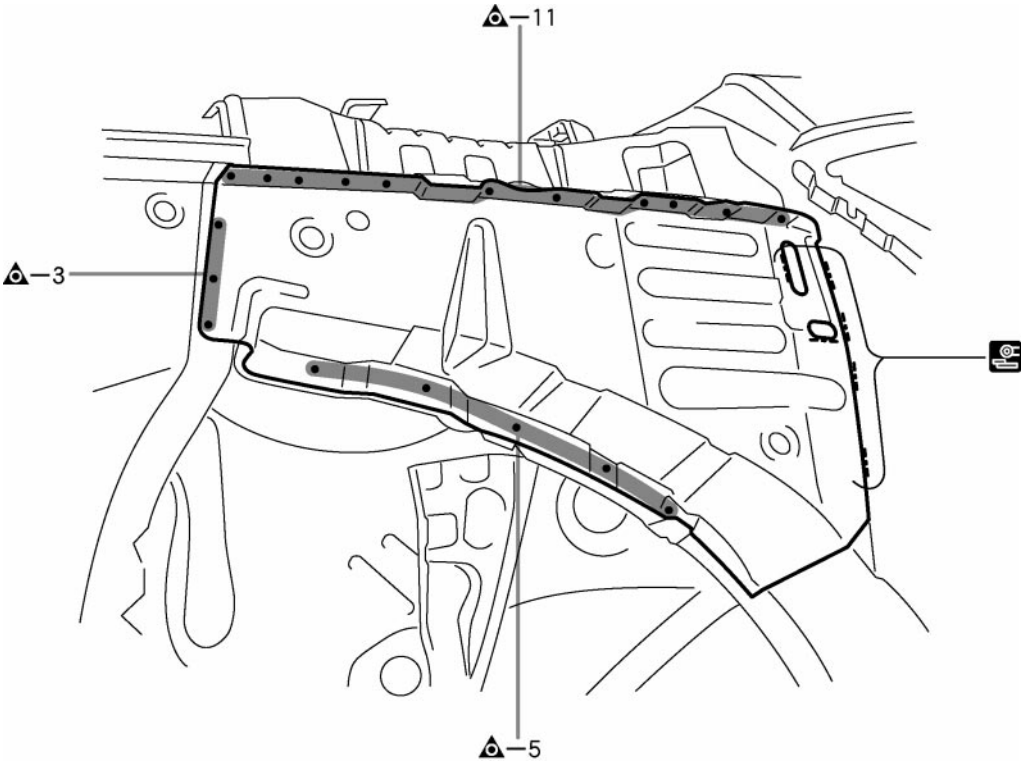
[A] Front Sidemember Extension
90mm (3.54in.)

COWL TOP SIDE PANEL (ASSY)

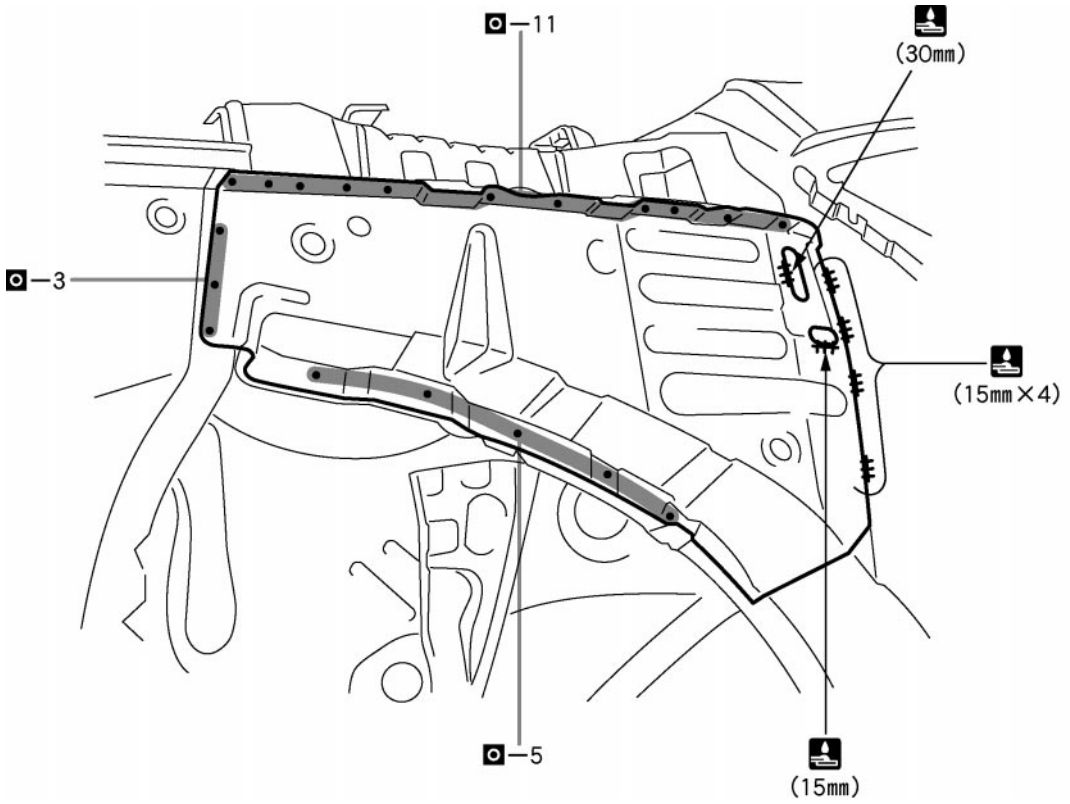

F16144-A

REPLACEMENT

REMOVAL



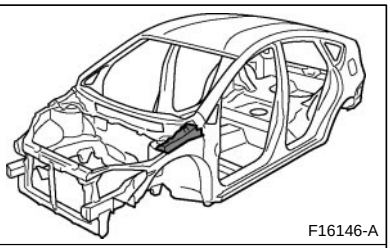
F16144



F16145

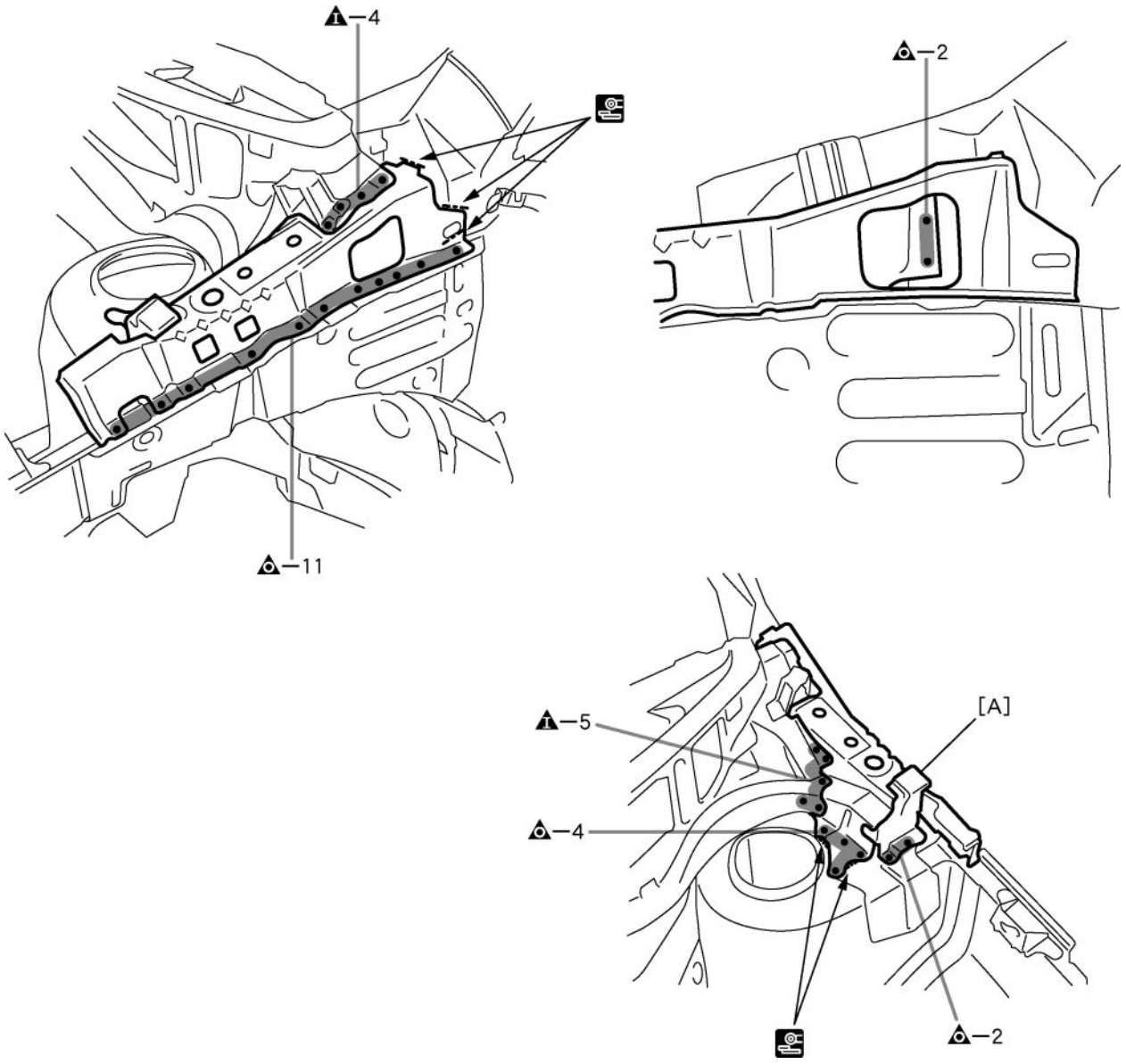
15mm (0.59in.) 30mm (1.18in.)

COWL TOP INNER SIDE PANEL (ASSY)


F16146-A

REPLACEMENT

REMOVAL



F16146

POINT

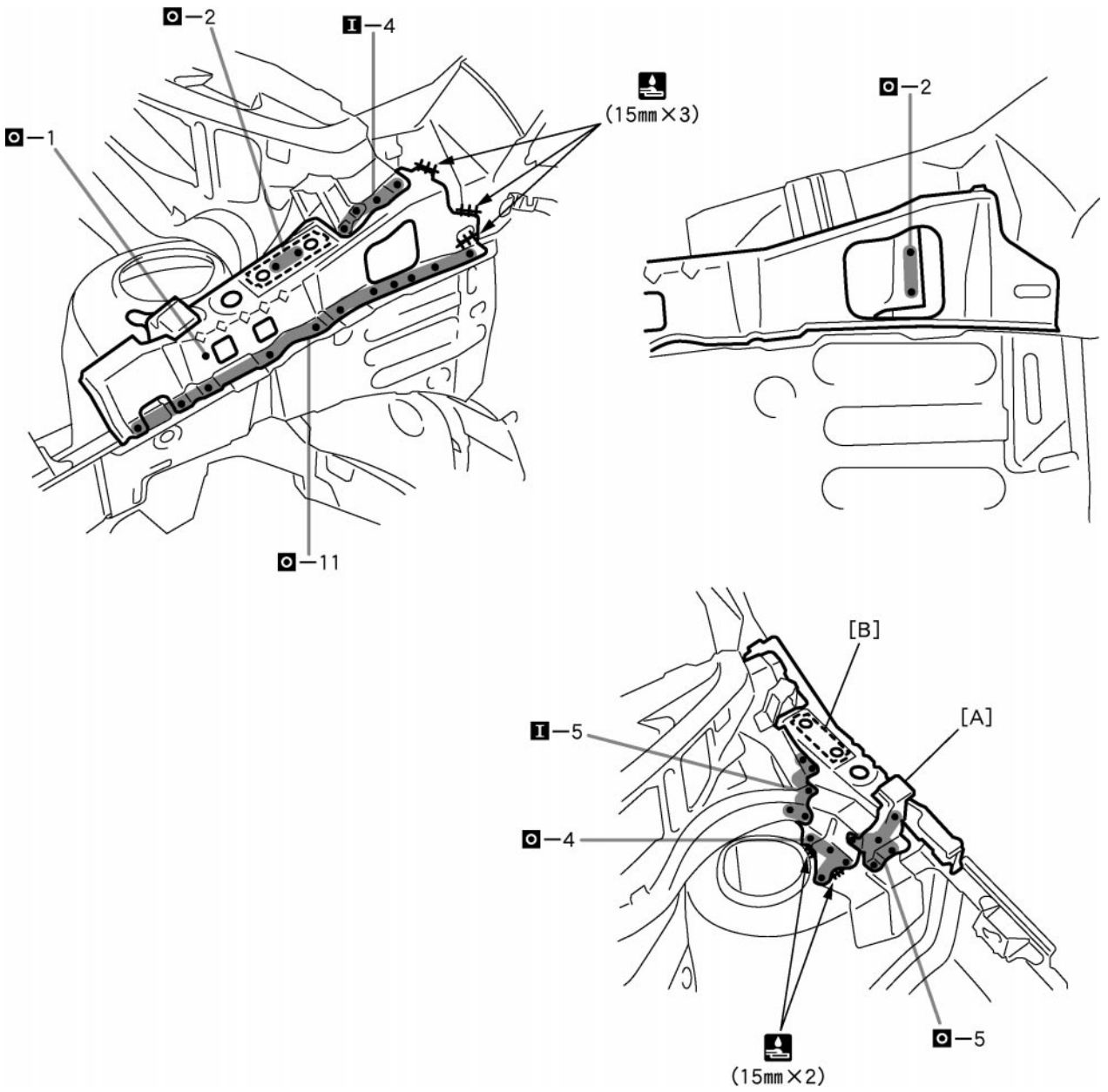
1 Remove the [A] the same time.

PART NAME

[A] Front Apron To Cowl Sidemember Plate

INSTALLATION

- 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)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



F16147

POINT

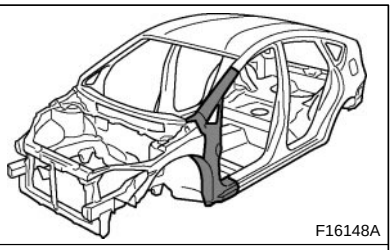
1 Inspect the fitting of the front fender and hood, etc., before welding, since this affects the appearance of the finish.

PART NAME

[A] Front Apron To Cowl Sidemember Plate [B] Hood Damper Mounting Bracket

15mm (0.59in.)

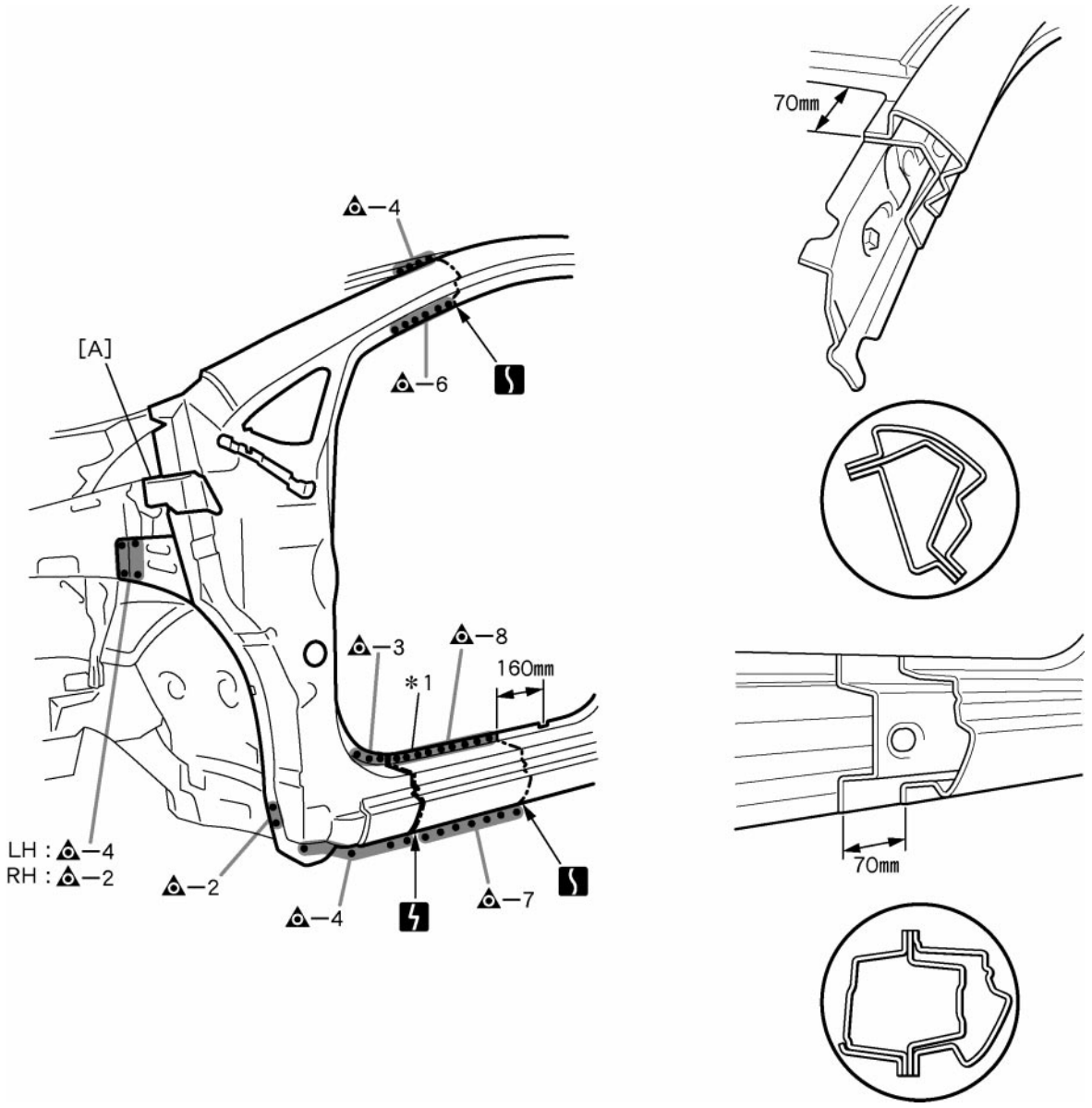
FRONT BODY PILLAR (CUT)


F16148A

REPLACEMENT

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

REMOVAL



F16148

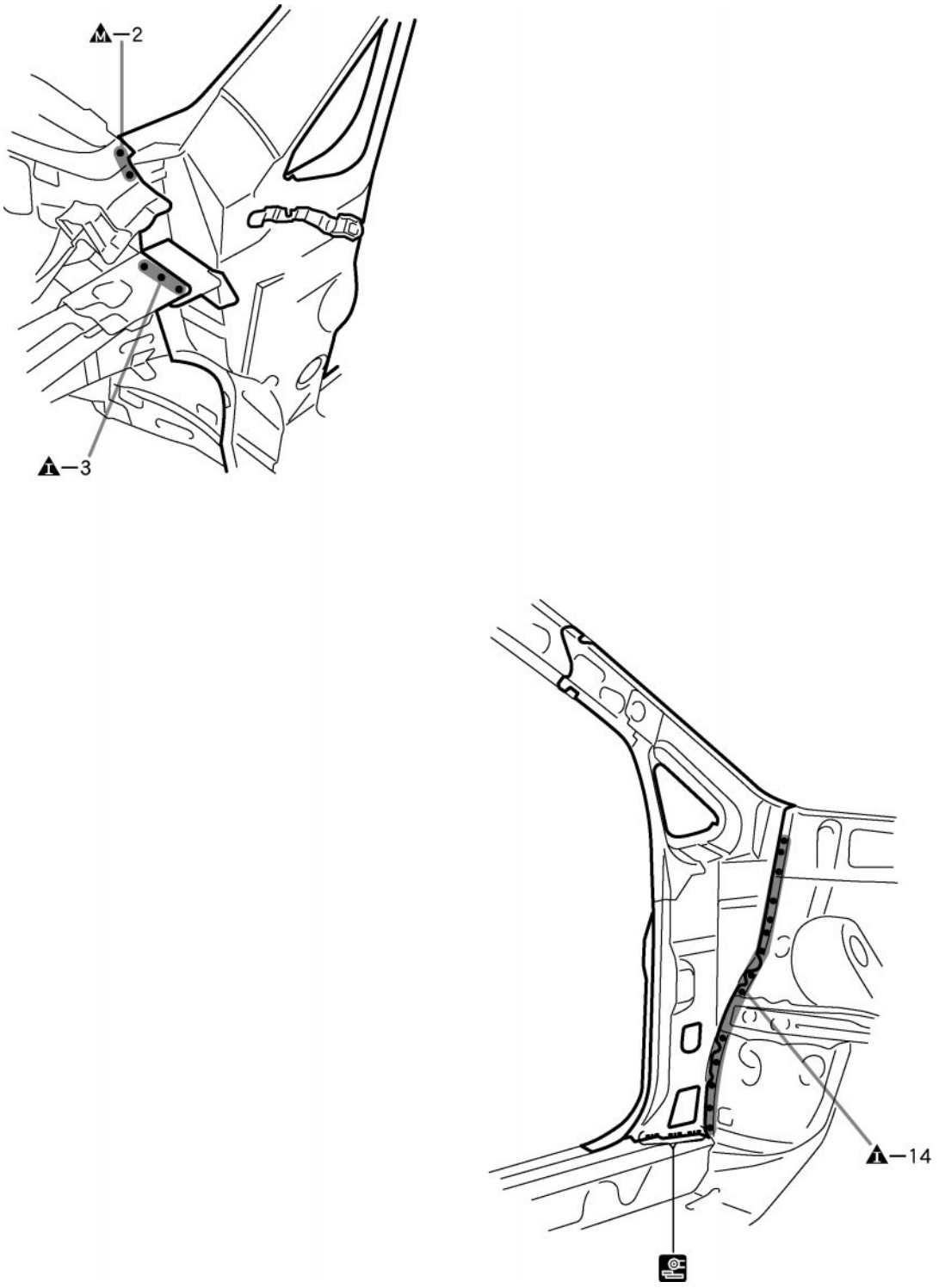
POINT

1 *1 : This part of the outer panel is reused, because the rocker panel section is cut off at the rear position behind the supplied parts cut position of the outer panel.
2 Replace the [A] at the same time.

PART NAME

[A] Cowl Top Side Reinforcement

70mm (2.76in.) 160mm (6.30in.)



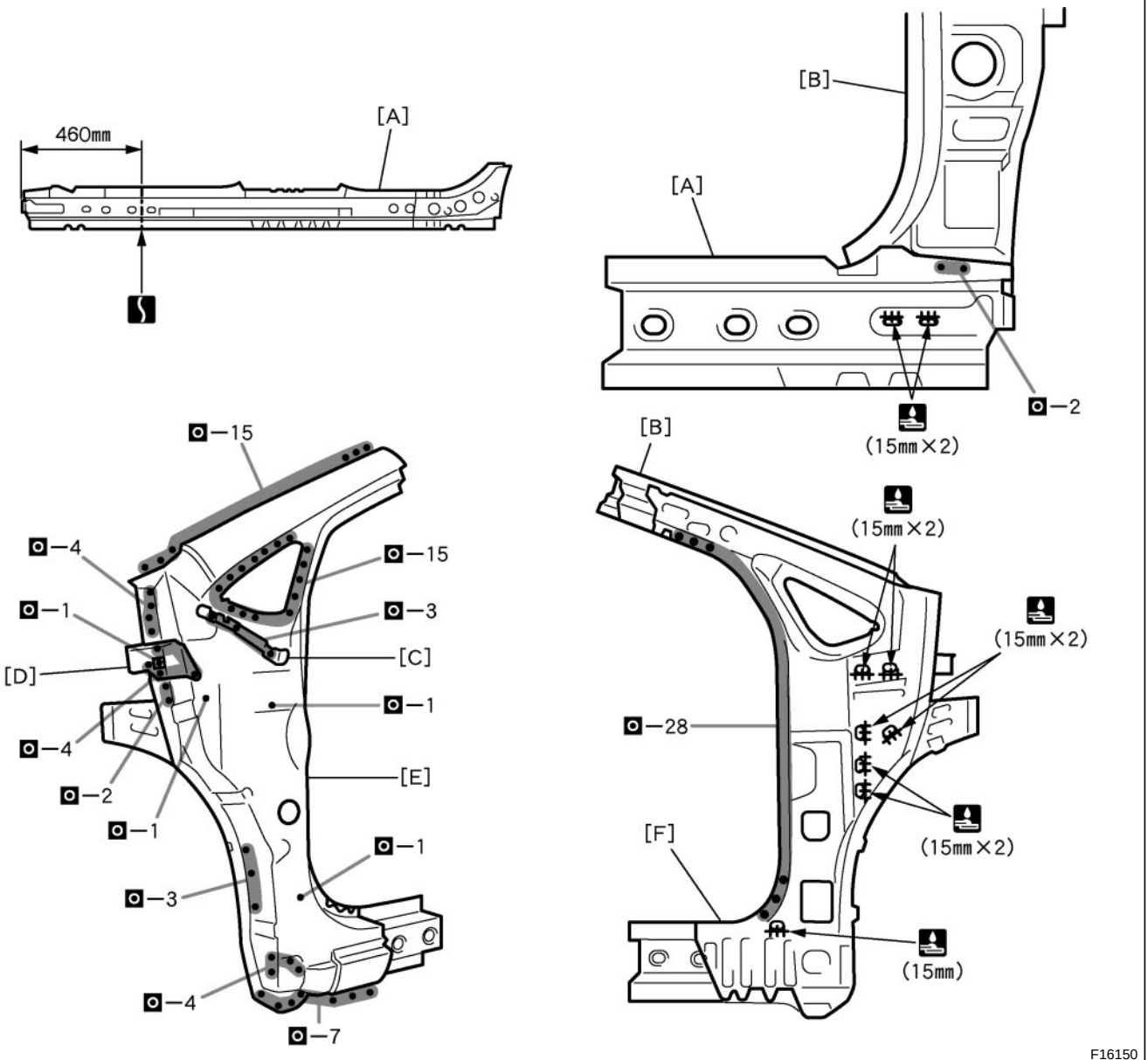
F16149

POINT

1 Remove the remaining foamed from the vehicles side.

INSTALLATION

- 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)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



F16150

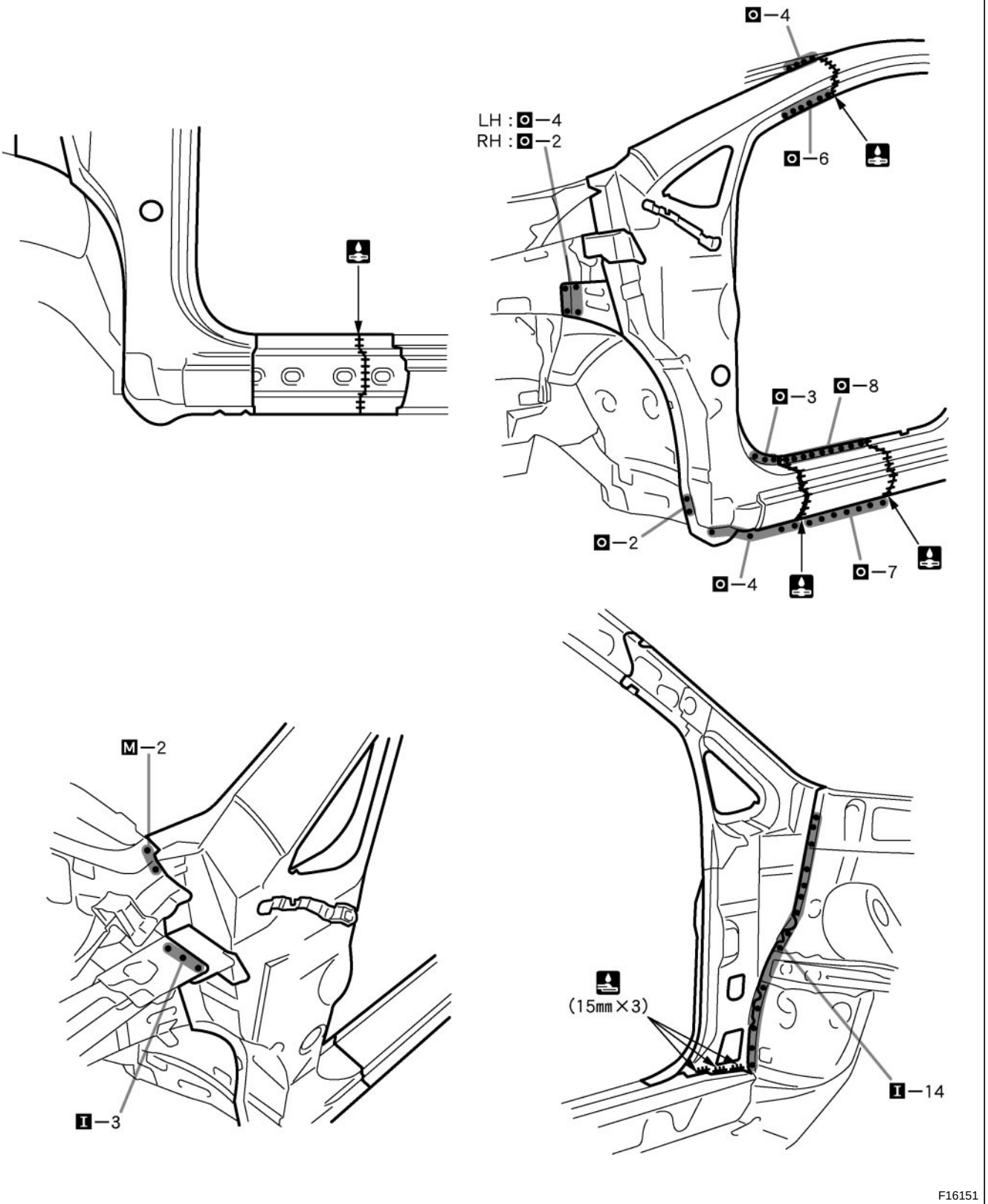
POINT

1 Before temporarily installing the new parts, weld the [A], [B], [C], [D], [E], and [F] with standard points.

PART NAME

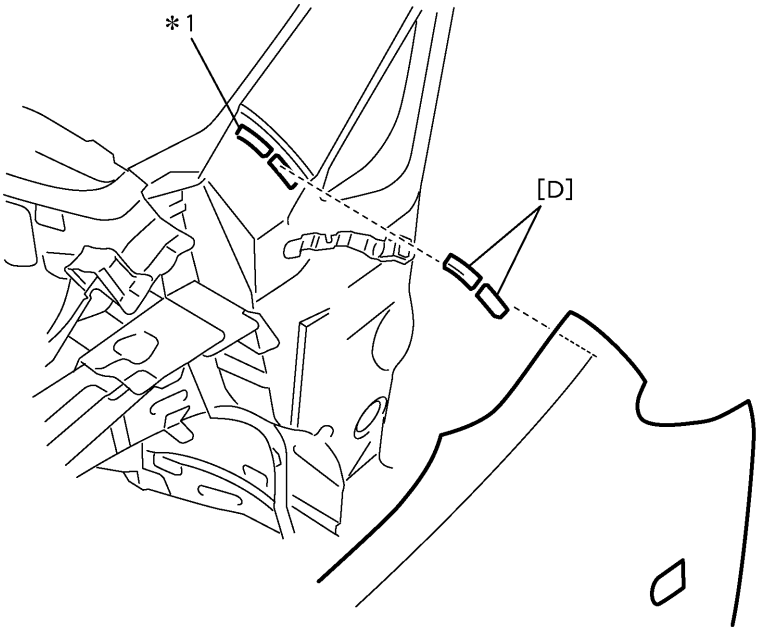
[A] Rocker Outer Reinforcement [B] Front Body Pillar Lower Reinforcement
[C] Front Fender Rear No, 2 Bracket [D] Cowl Top Side Reinforcement [E] Outer Pillar
[F] Front Body Upper Inner Pillar

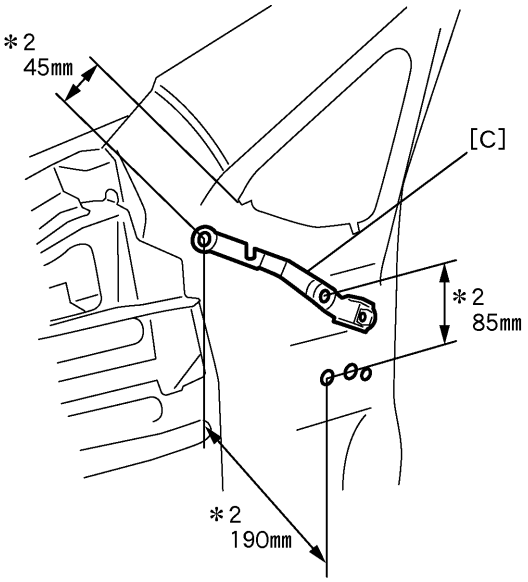
460mm (18.11in.) 15mm (0.59in.)



POINT

1 Inspect the fitting of the front door, front fender and windshield glass, etc., before welding, since this affects the appearance of the finish.





POINT

1 *1: Area where [D] is to be installed. *2: Reference value

2 Place the front fender. For installation of [D], measure the distance between the front fender and *1. Select a thickness of [D] from 7mm, 7.5mm and 8mm.

3 Fit the front fender, pushing down the attached [D], and checking that it does not rattle.

HINT:

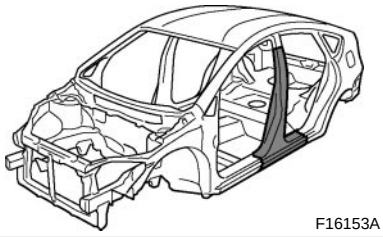
1) If having wobbles, change the [D] to the thicker one. Also, check the alignment of the front fender again.

PART NAME

[C] Front Fender Rear No.2 Bracket [D] Front Fender Spacer

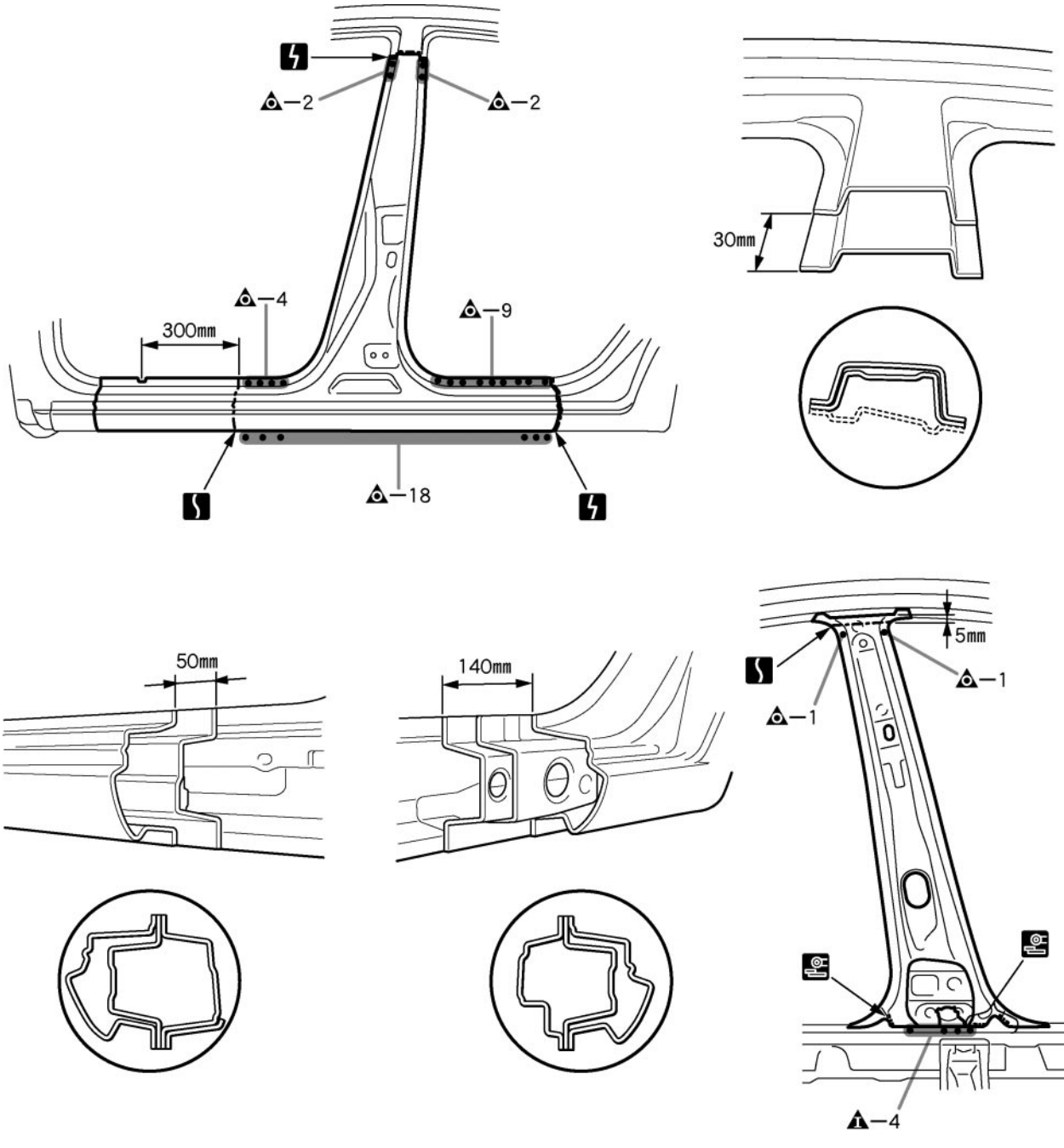
7mm (0.28in.) 7.5mm (0.30in.) 8mm (0.31in.) 45mm (1.77in.) 85mm (3.35in.) 190mm (7.48in.)

CENTER BODY PILLAR (CUT)


F16153A

REPLACEMENT

REMOVAL

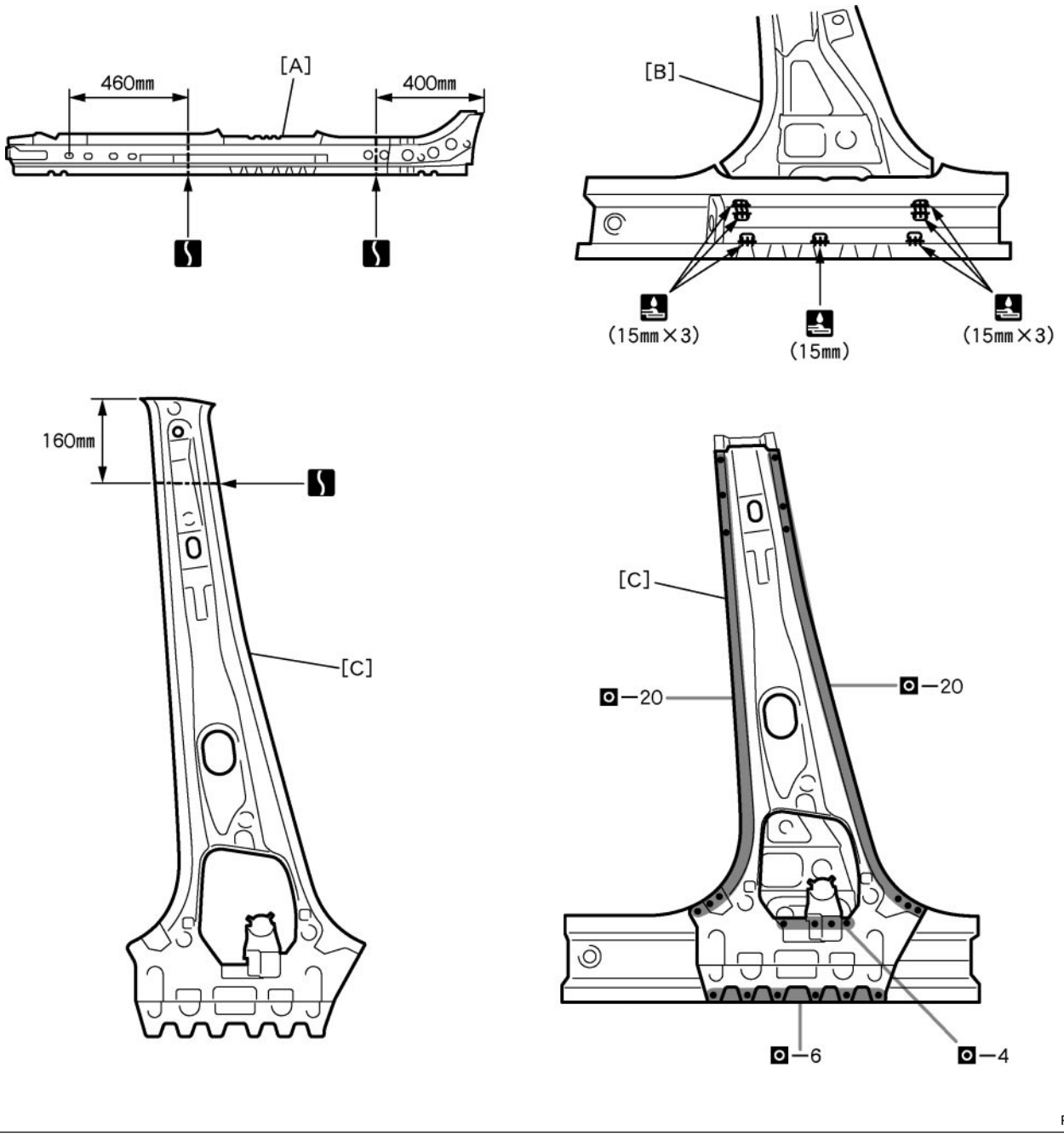


F16153

5mm (0.20in.) 30mm (1.18in.) 50mm (1.97in.) 140mm (5.51in.) 300mm (11.81in.)

INSTALLATION

- 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)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



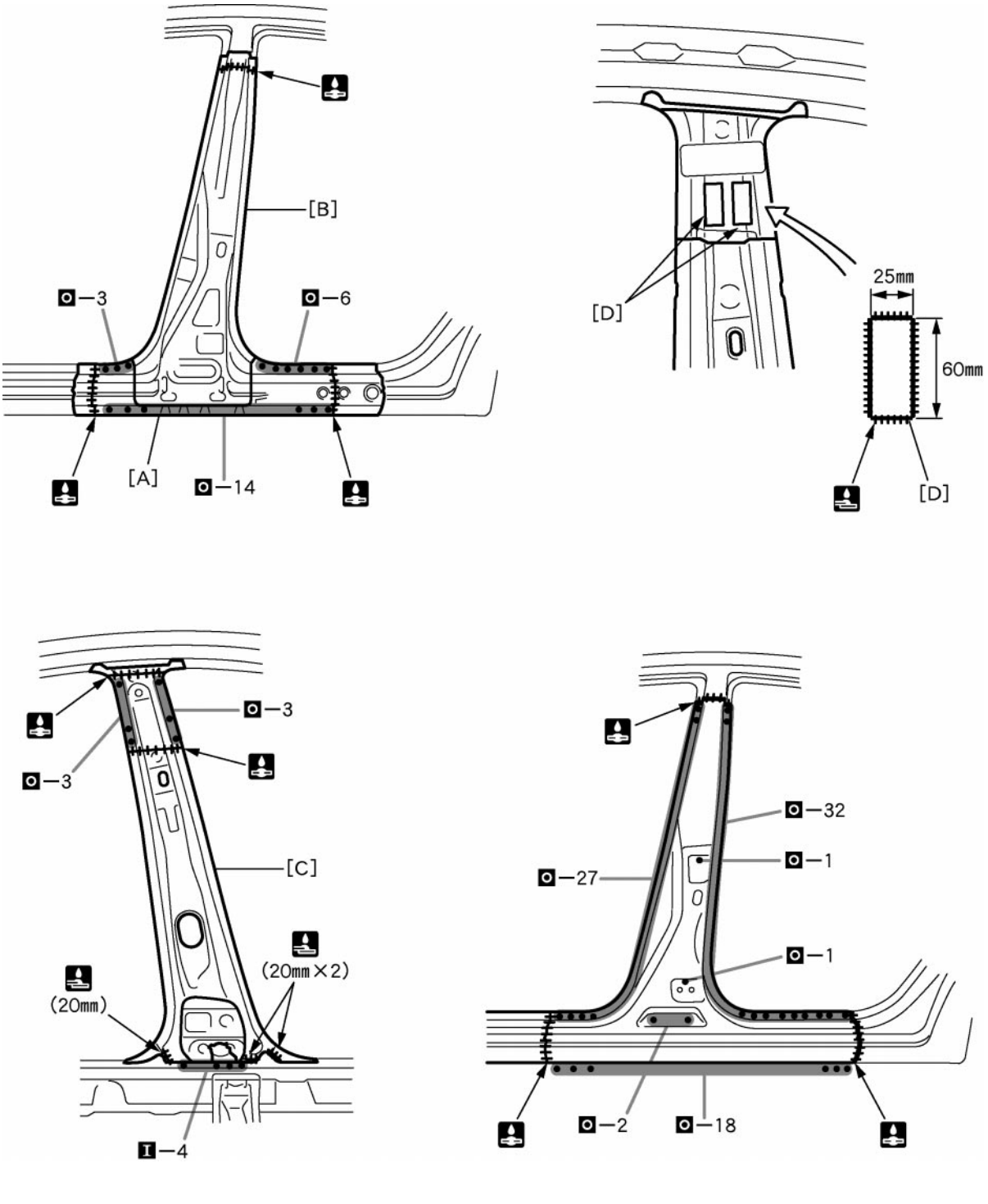
POINT

1 Before temporarily installing the new parts, weld the [A], [B], and [C] with standard points.

PART NAME

[A] Rocker Outer Reinforcement [B] Center Body Pillar Reinforcement [C] Center Body Inner Pillar

15mm (0.59in.) 160mm (6.30in.) 400mm (15.75in.) 460mm (18.11in.)



F16155

POINT

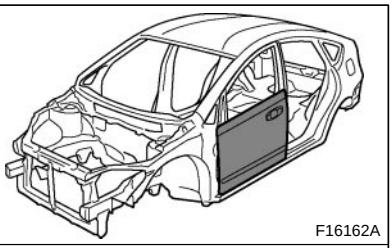
1 Inspect the fitting of the front door and rear door, etc., before welding, since this affects the appearace of the finish.
2 Weld the [D] from inside of the butted portion.
Hint:
1) Make the [D] from the remainder of new parts.
3 After welding the reinforcement to the vehicle, install the outer pillar.

PART NAME

[A] Rocker Outer Reinforcement [B] Center Body Pillar Reinforcement [C] Center Body Inner Pillar
[D] Stiffener

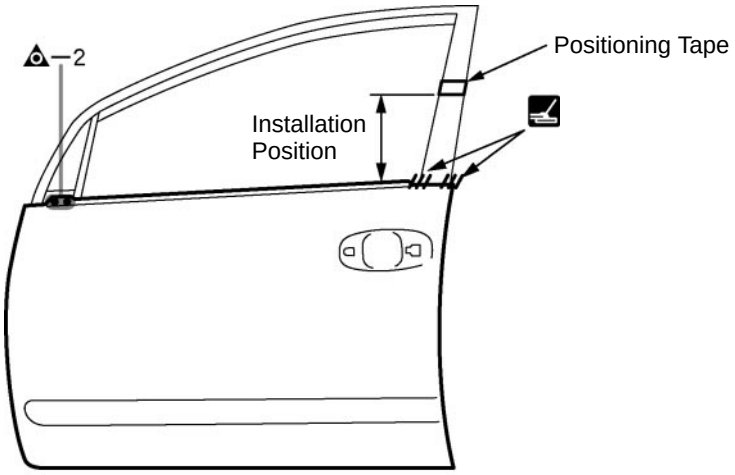
20mm (0.79in.) 25mm (0.98in.) 60mm (2.36in.)

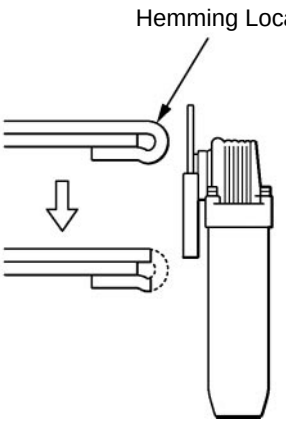
FRONT DOOR OUTER PANEL (ASSY)


F16162A

REPLACEMENT

REMOVAL





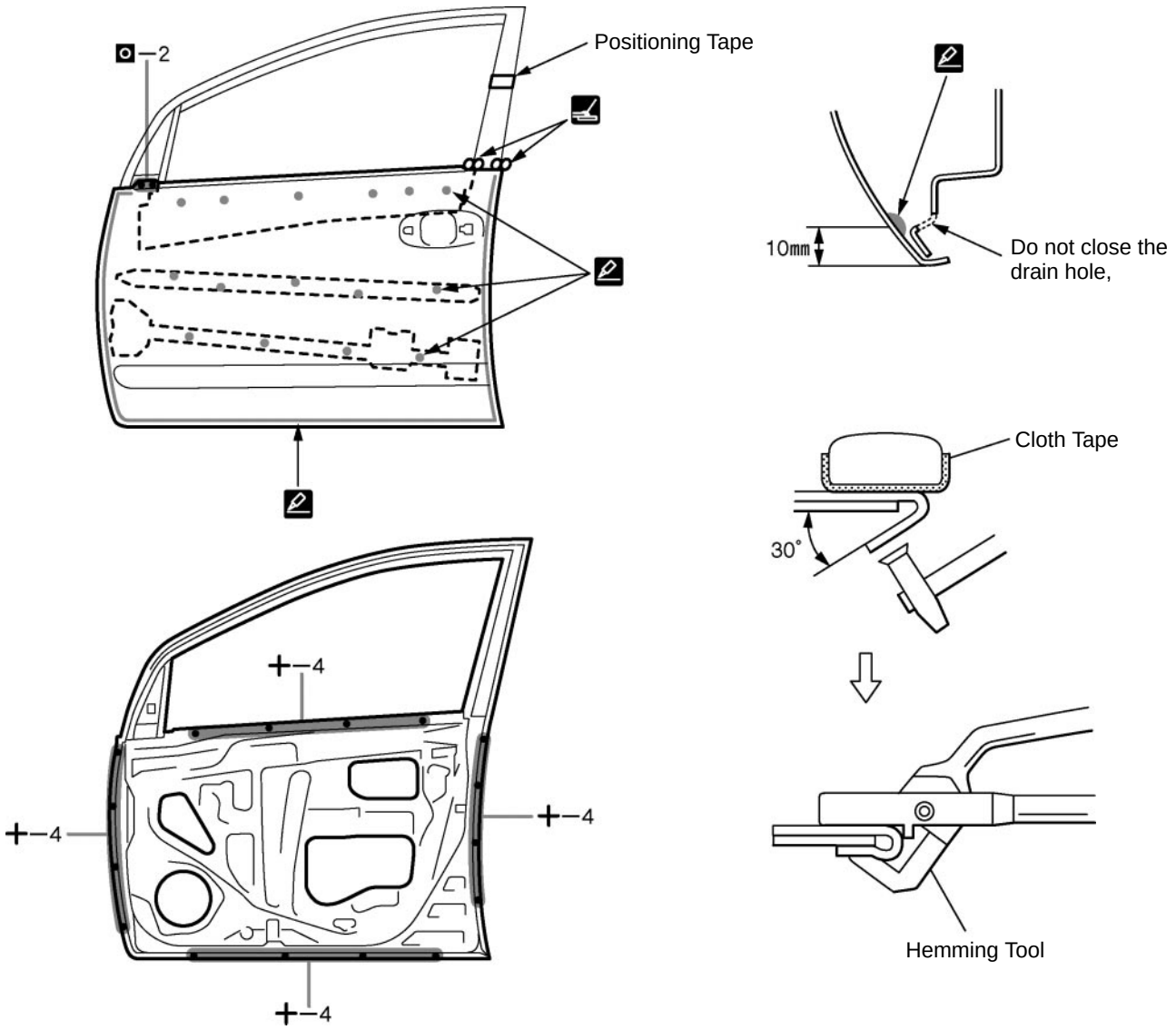
F16162

POINT

1 Before removing the outer panel, make the installation position with a tape.
2 After grinding off the hemming location, remove the outer panel.

INSTALLATION

- 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)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.

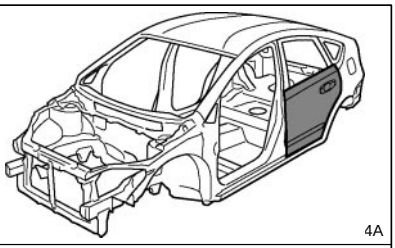


POINT

1 Before temporarily installing the new parts, apply body sealer to the reinforcement, side impact protection beam and back side of the new parts.
HINT:
1) Apply sealer evenly about 10mm (0.39in.) from the flange and 3mm (0.12in.) in diameter to the outer panel and apply just enough sealer for the reinforcement and side impact protection beam to make contact.

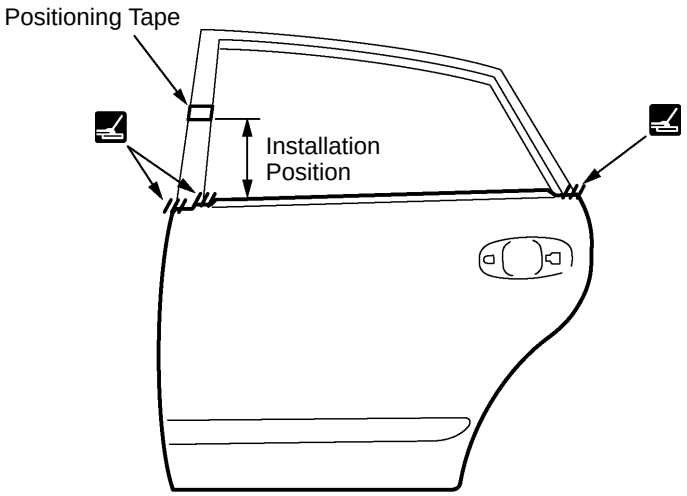
2 Bend the flange hem about 30° with a hammer and dolly, then fasten tightly with a hemming tool.
HINT:
1) Perform hemming in three steps, being careful not to warp the panel.
2) If a hemming tool cannot be used, hem with a hammer and dolly.

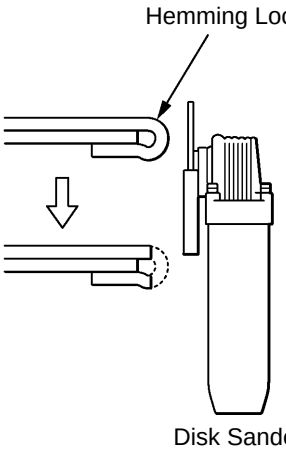
REAR DOOR OUTER PANEL (ASSY)


4A

REPLACEMENT

REMOVAL





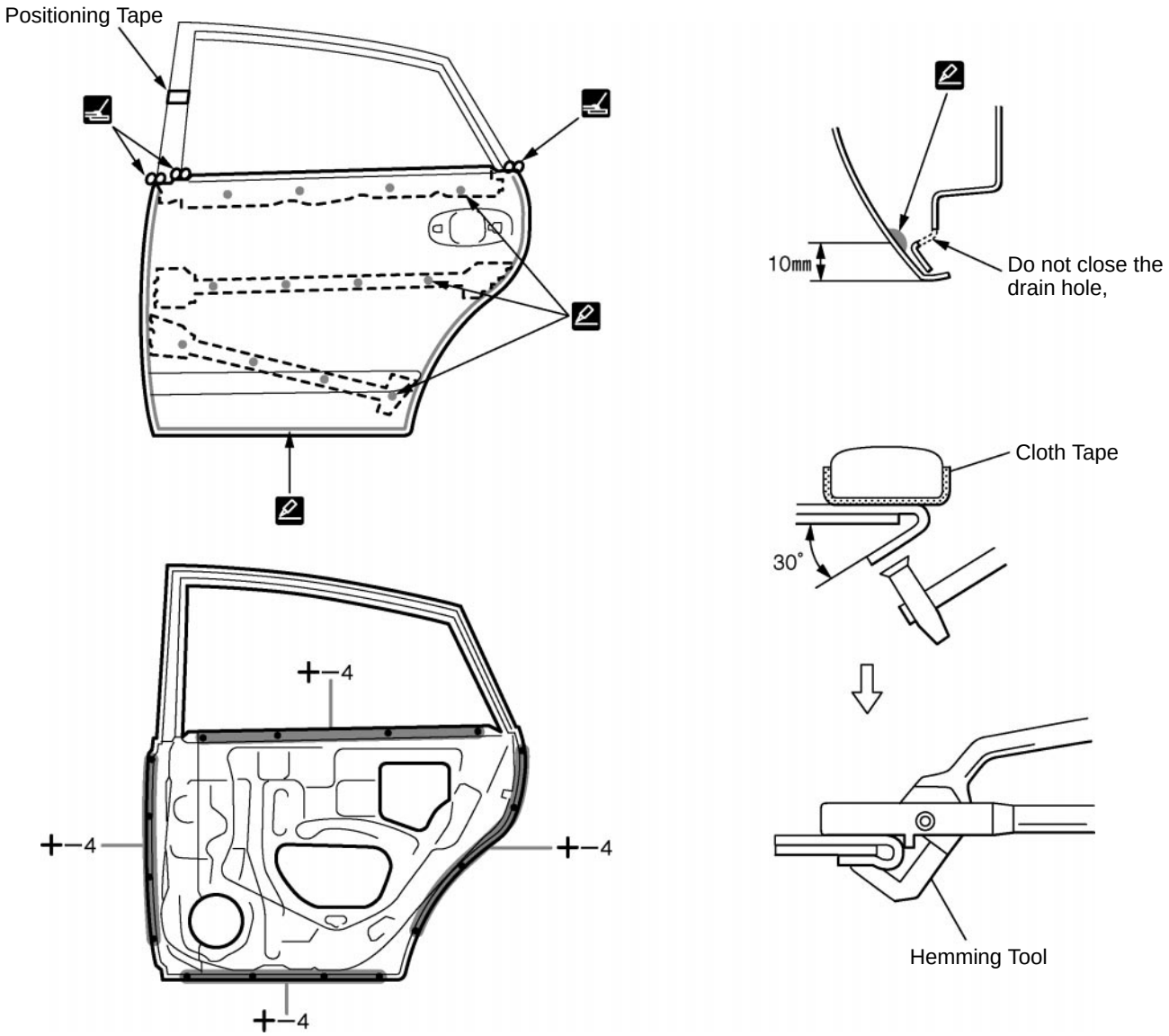
F16164

POINT

1 Before removing the outer panel, make the installation position with a tape.
2 After grinding off the hemming location, remove the outer panel.

INSTALLATION

- 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)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



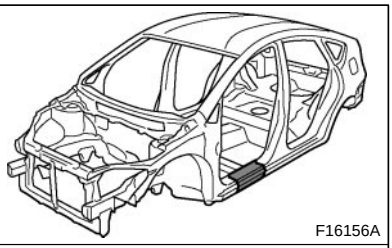
F16165

POINT

1 Before temporarily installing the new parts, apply body sealer to the reinforcement, side impact protection beam and back side of the new parts.
HINT:
1) Apply sealer evenly about 10mm (0.39in.) from the flange and 3mm (0.12in.) in diameter to the outer panel and apply just enough sealer for the reinforcement and side impact protection beam to make contact.

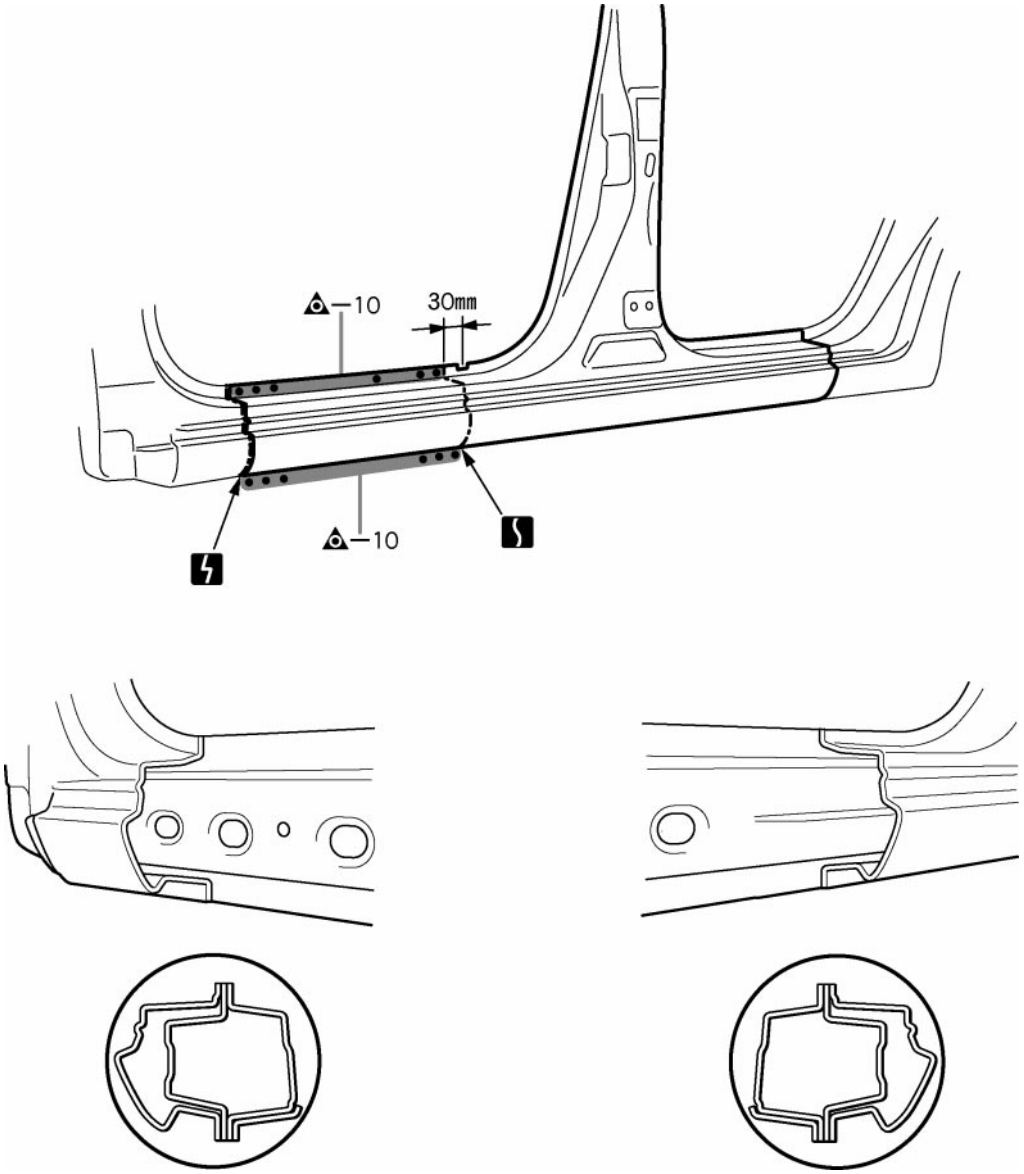
2 Bend the flange hem about 30° with a hammer and dolly, then fasten tightly with a hemming tool.
HINT:
1) Perform hemming in three steps, being careful not to warp the panel.
2) If a hemming tool cannot be used, hem with a hammer and dolly.

ROCKER OUTER PANEL (CUT-H)


F16156A

REPLACEMENT

REMOVAL

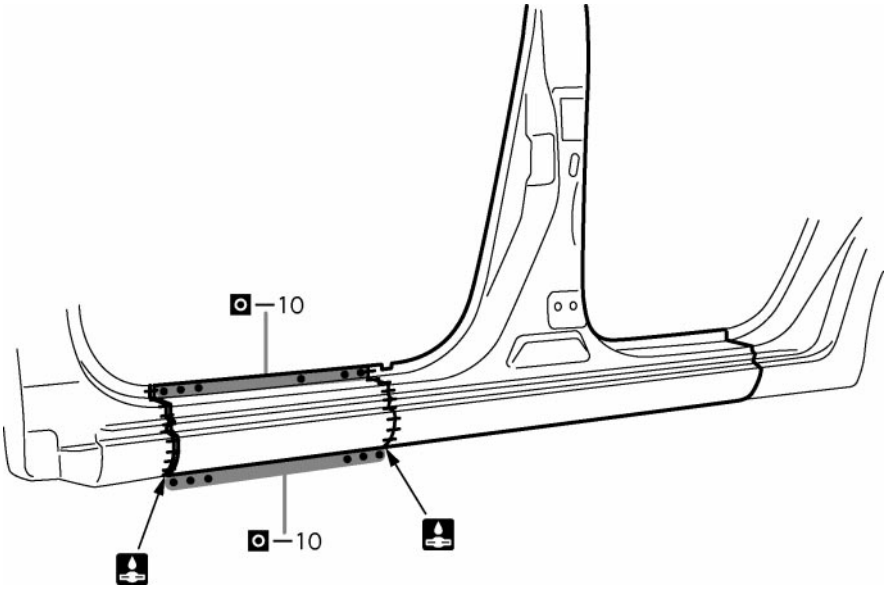


F16156

30mm (1.18in.)

INSTALLATION

- 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)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.

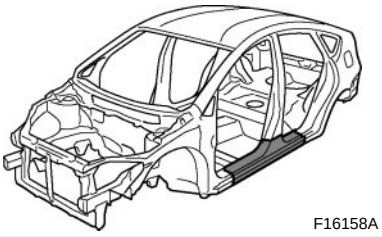


F16157

POINT

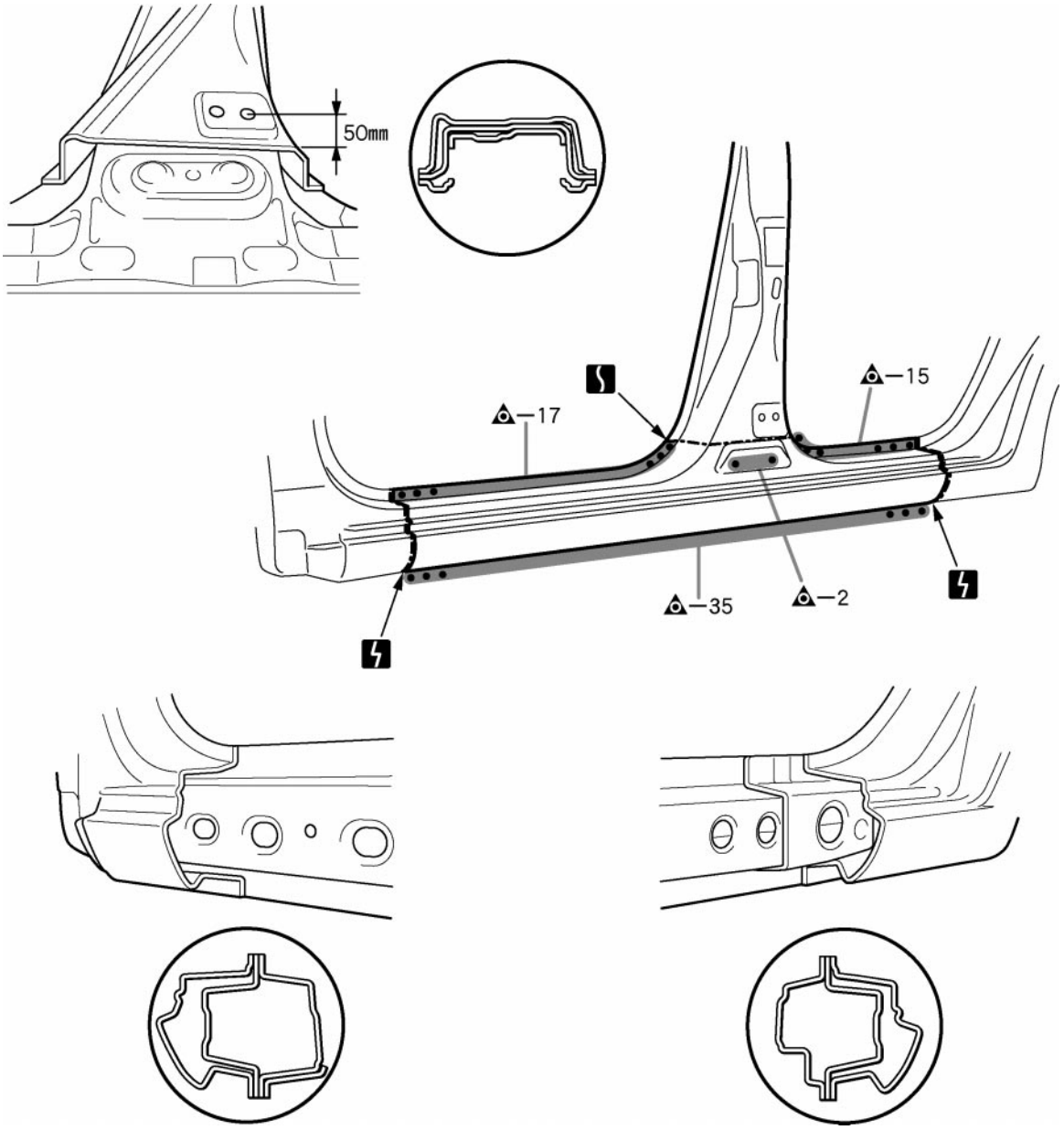
1 Inspect the fitting of the front door, etc., before welding, since this affects the appearance of the finish.

ROCKER OUTER PANEL (CUT)


F16158A

REPLACEMENT

REMOVAL

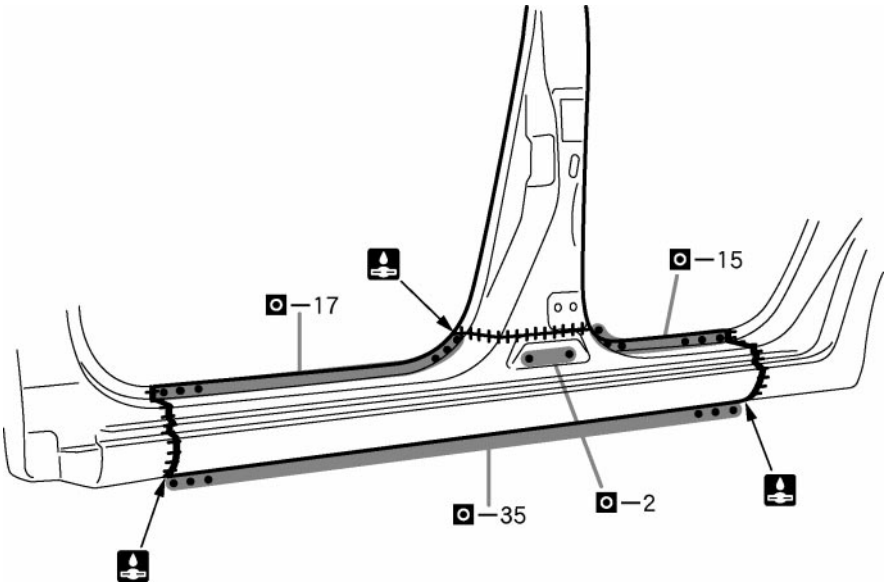


F16158

50mm (1.97in.)

INSTALLATION

- 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)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.

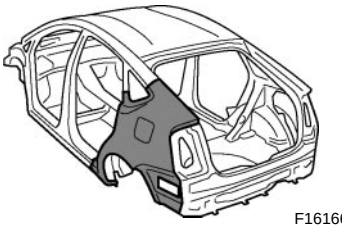


F16159

POINT

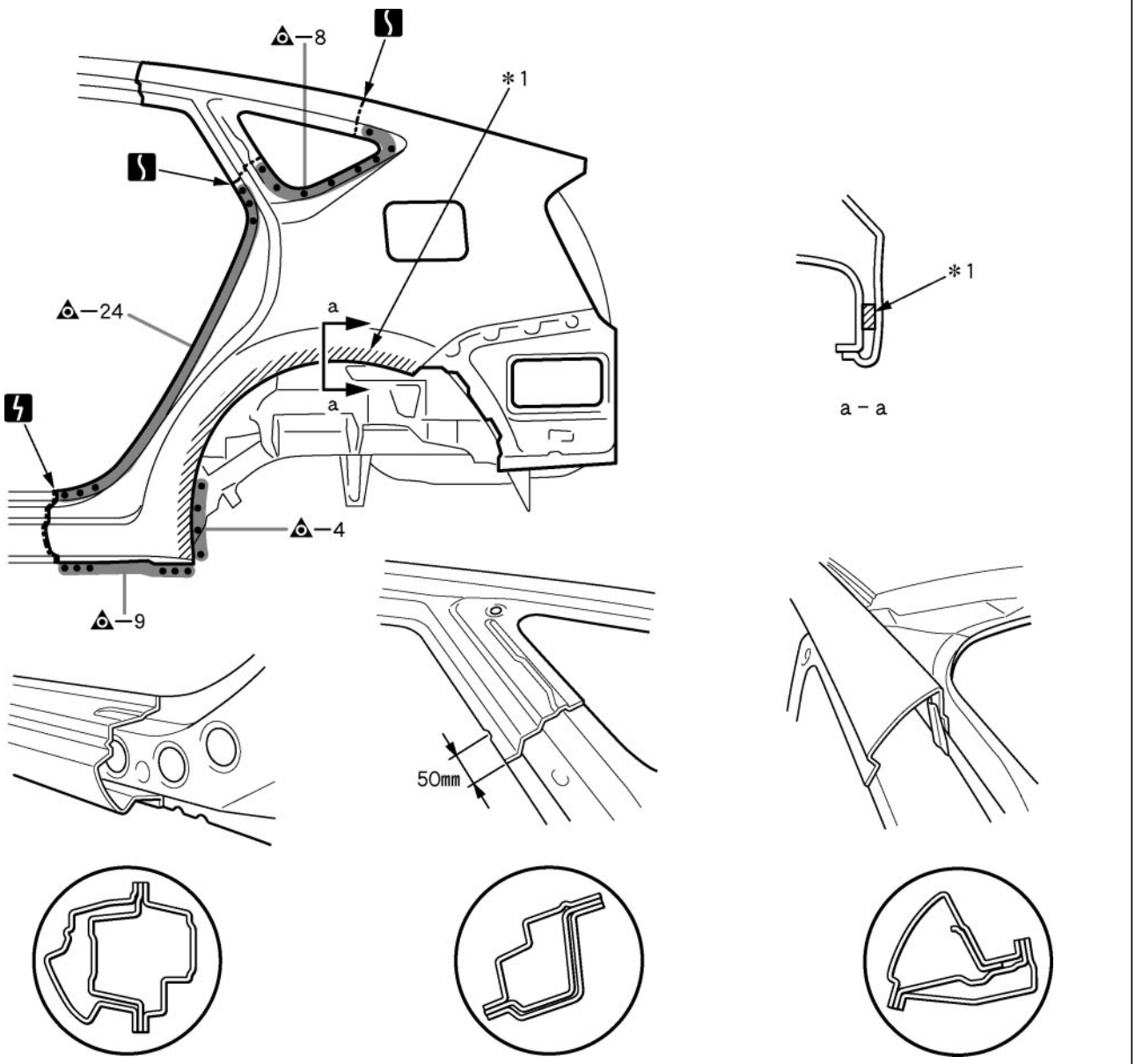
1 Inspect the fitting of the front door and rear door, etc., before welding, since this affects the appearance of the finish.

QUARTER PANEL (CUT)


F16166A

REPLACEMENT

REMOVAL



F16166

POINT

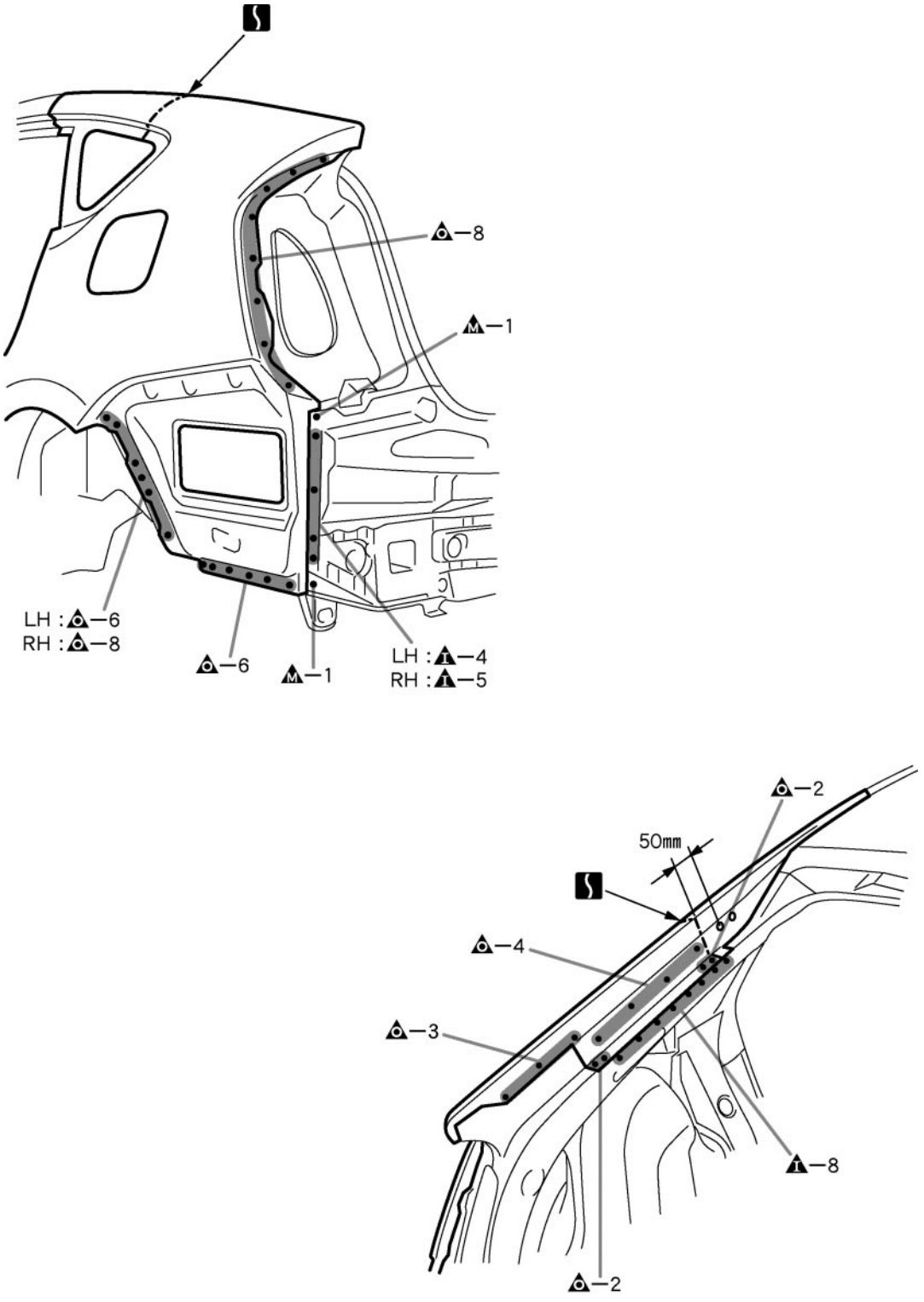
1 *1 in illustration above indicates where the adhesive is.

2 Roughly cut open the wheel arch of the panel so that the adhesive can be reached. Cut through the adhesive with a cut chisel to remove the panel.

HINT:

1) If the cut chisel cannot reach the adhesive, heat the adhesive with a heat gun, oxygen burner or acetylene burner. When heating, do not deform the quarter wheel housing outer panel.

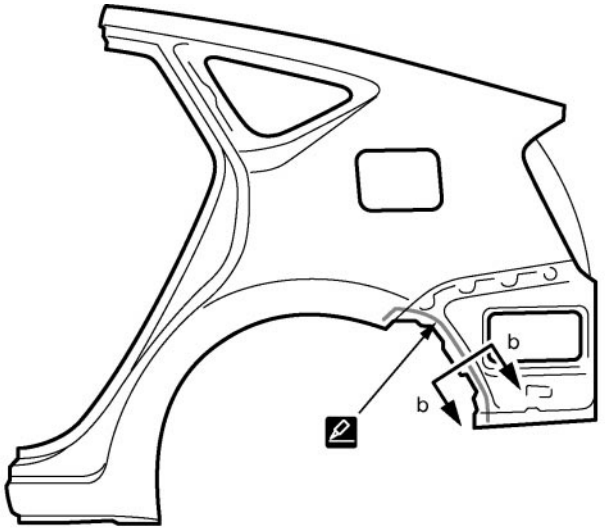
50mm (1.97in.)

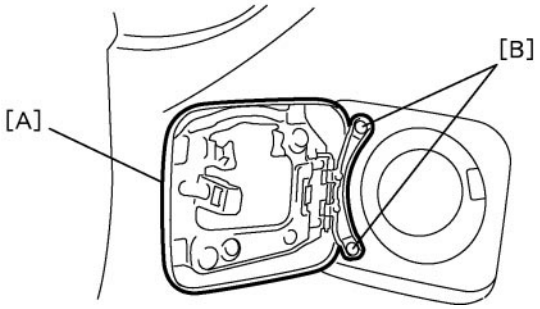


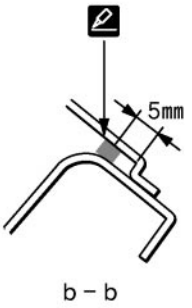
50mm (1.97in.)

INSTALLATION

- 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)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.







F16168

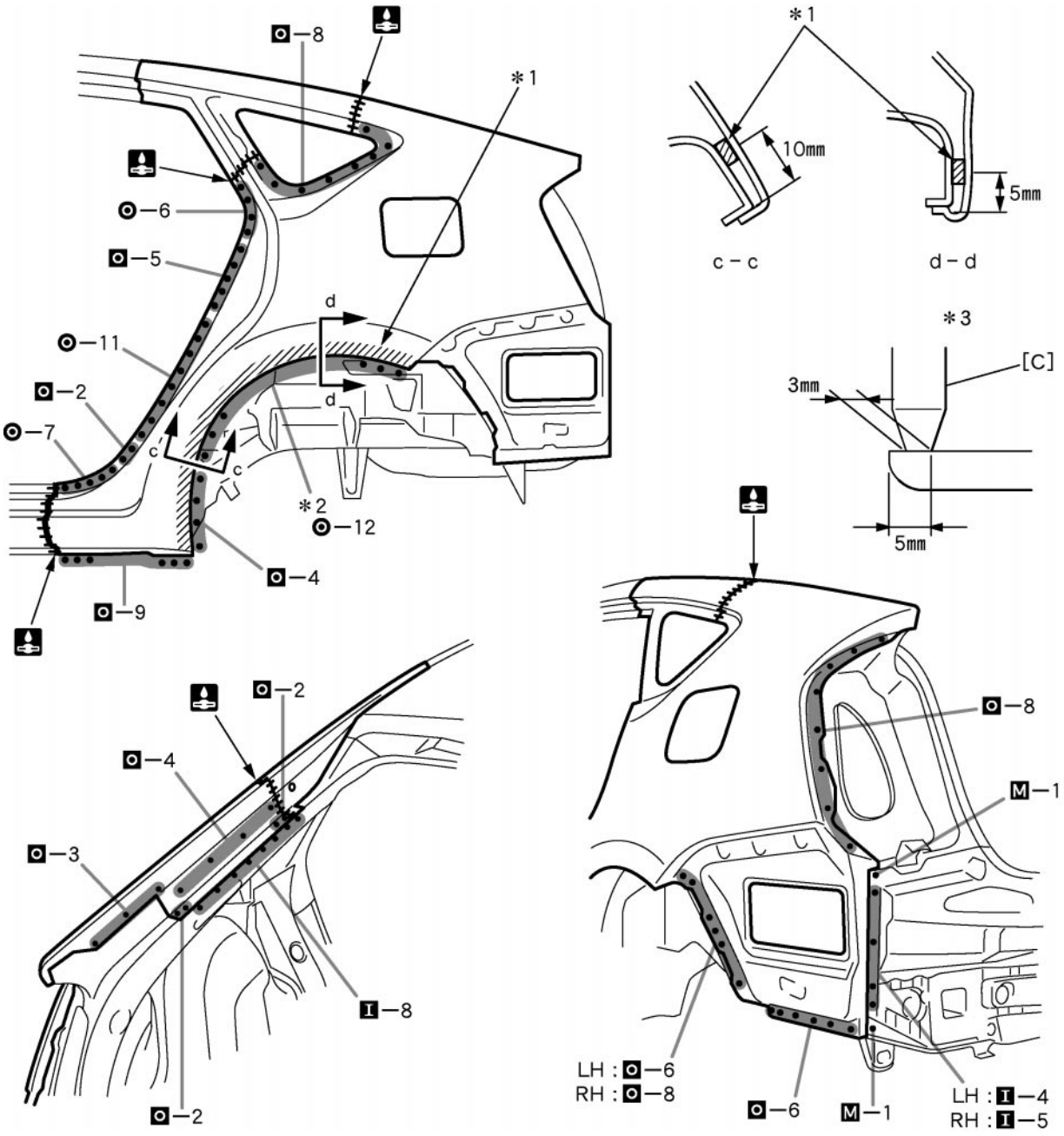
POINT

1 Before temporarily installing the new parts, apply body sealer to the wheel arch.
HINT:
1) Apply body sealer about 5mm (0.20in.) from the flange, avoiding any oozing.
2) Apply sealer evenly, about 3 - 4mm (0.12 - 0.16in.) in diameter.

2 Inspect the fitting of the rear door, back door and rear combination light, etc., before welding, since this affects the appearance of the finish.

PART NAME

[A] Fuel Filler Opening Lid [B] Waterproof Rivets



F16169

POINT

1 Apply adhesive (3M™ Automix™ Panel Bonding Adhesive 08115) to the area indicated by *1 in illustration.
HINT:
1) Apply enough adhesive for the panels to sick to each other.

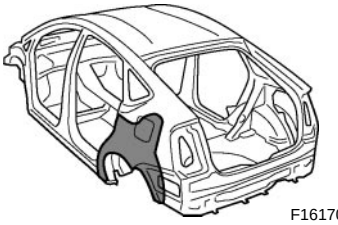
2 Perform spot-welding on the flange indicated by *2 in the illustration. Modify / cut the spot tip as shown in the illustration (*3) so that it can fit into the narrow flange.

PART NAME

[C] Spot Tip

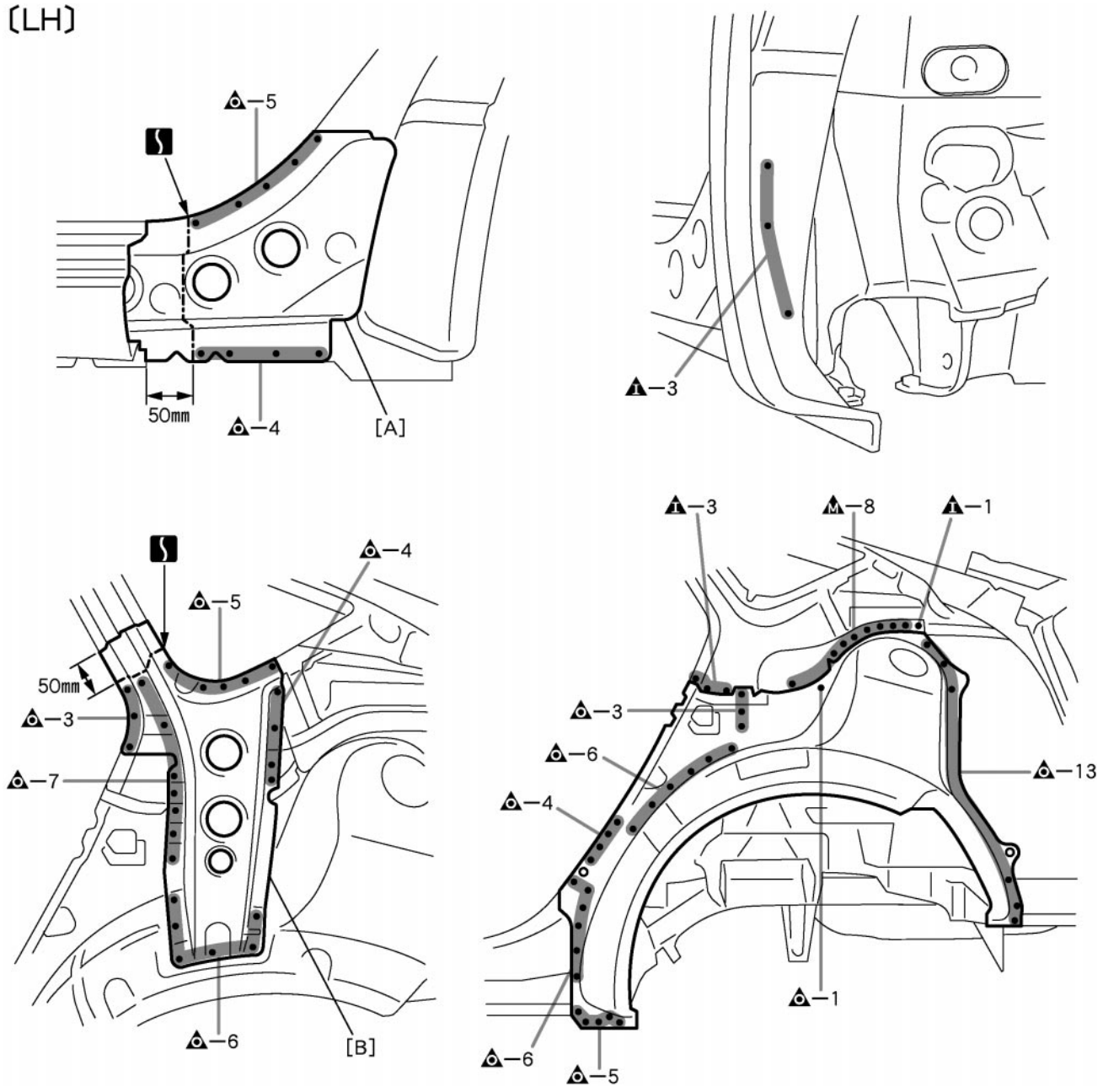
3mm (0.12in.) 5mm (0.20in.) 10mm (0.39in.)

QUARTER WHEEL HOUSING OUTER PANEL (ASSY)


F16170A

REPLACEMENT
With the quarter panel removed.

REMOVAL

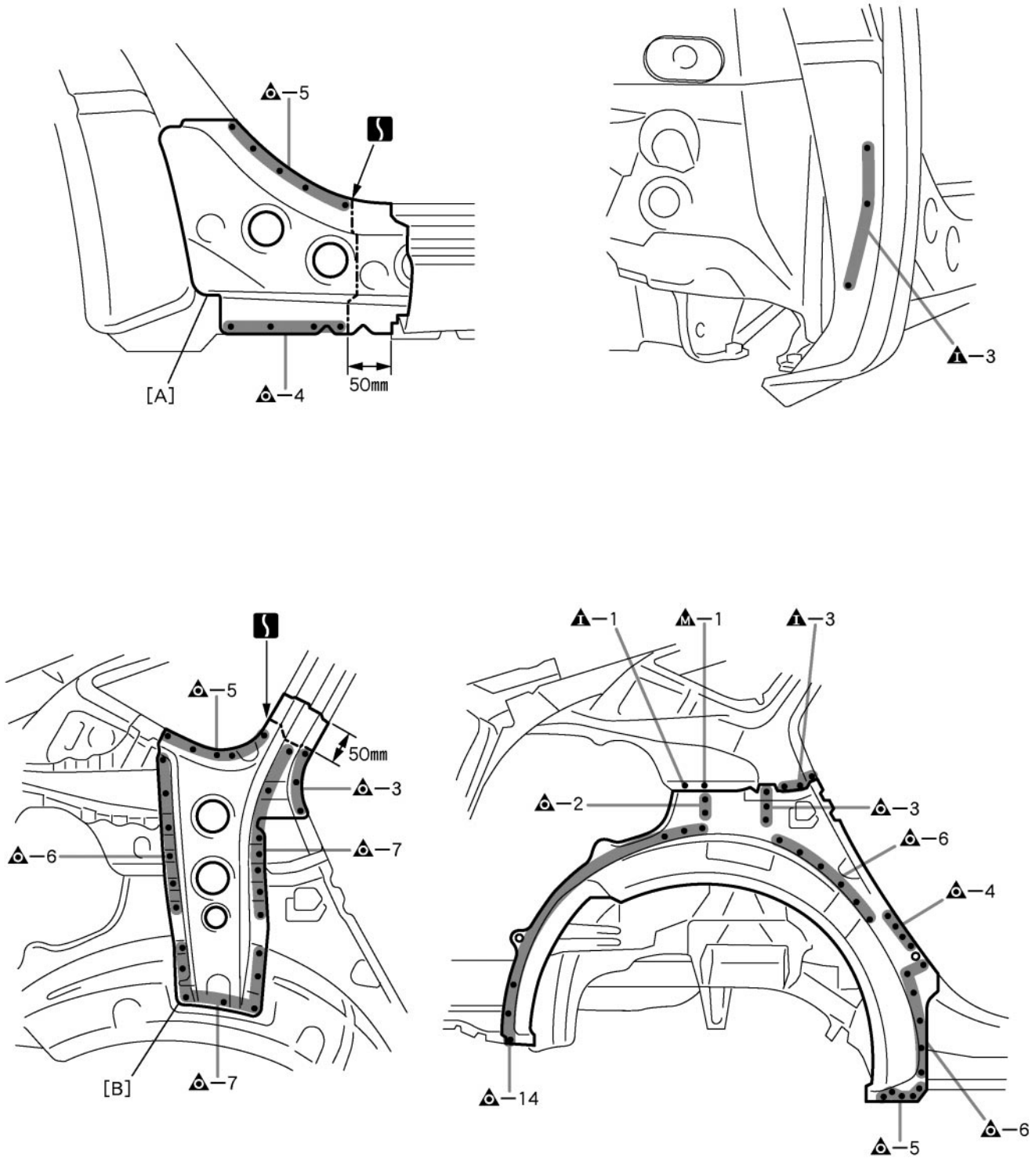


F16170

POINT
1 After removing the [A] and [B], remove the quarter wheel housing panel.

PART NAME
[A] Rocker Outer Reinforcement [B] Roof Side Outer Panel
50mm (1.97in.)

〔RH〕



F16171

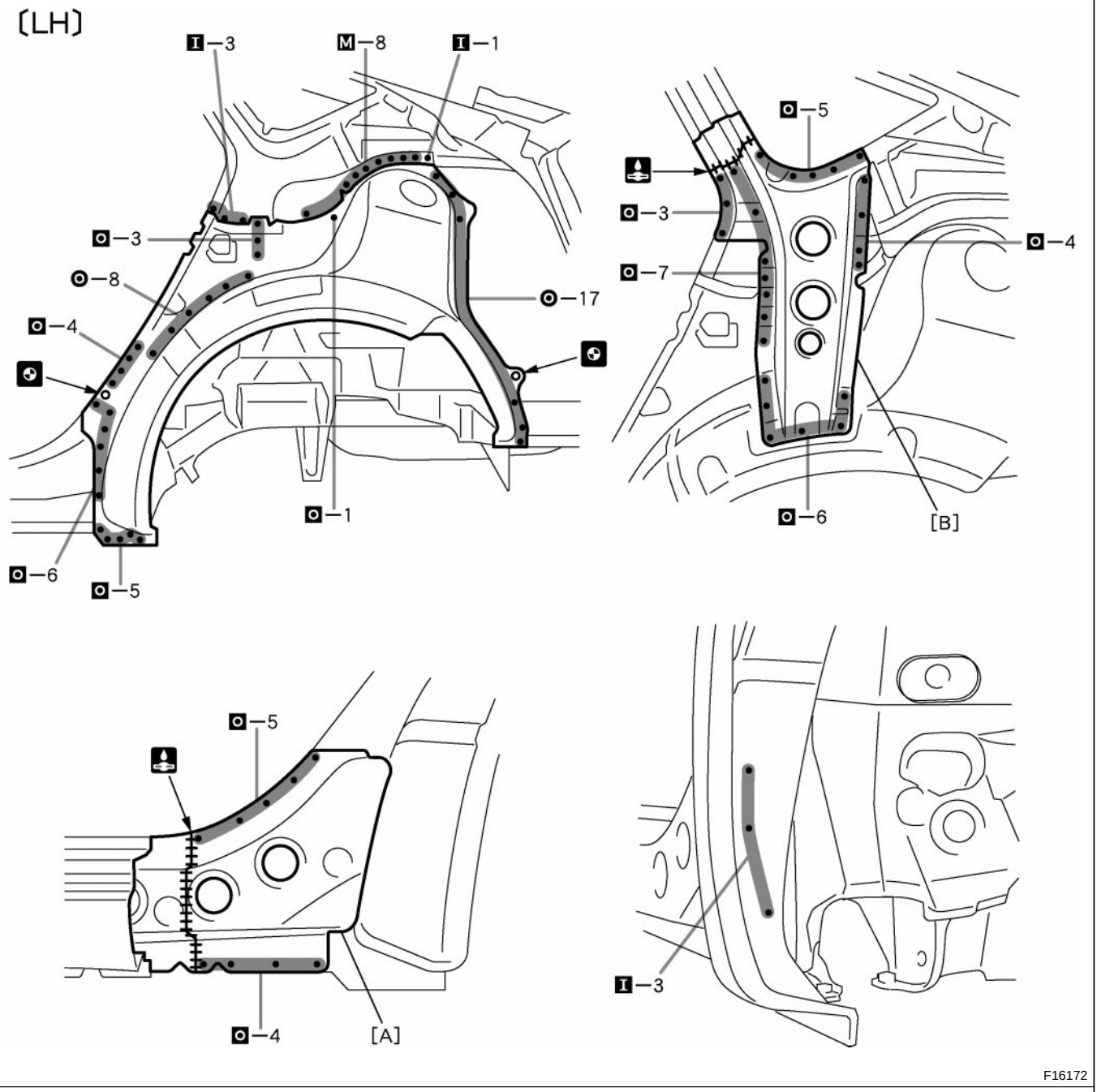
PART NAME

[A] Rocker Outer Reinforcement [B] Roof Side Outer Panel

50mm (1.97in.)

INSTALLATION

- 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)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



F16172

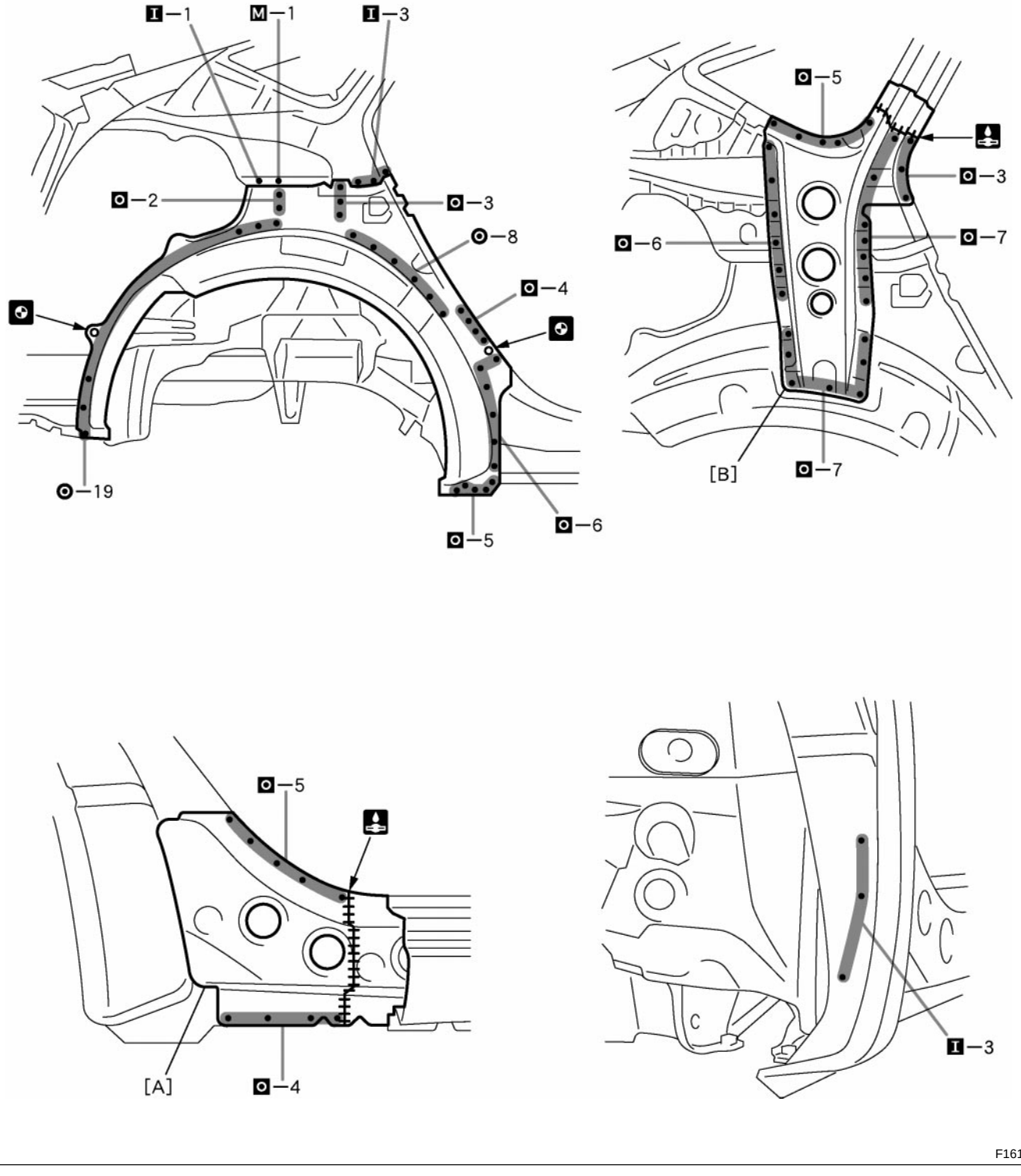
POINT

1 After welding the new parts to the vehicle, install the [A] and [B].

PART NAME

[A] Rocker Outer Reinforcement [B] Roof Side Outer Panel

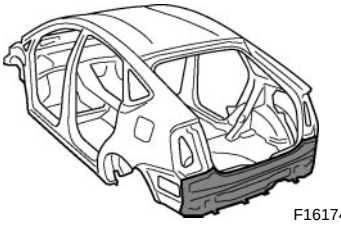
〔RH〕



PART NAME

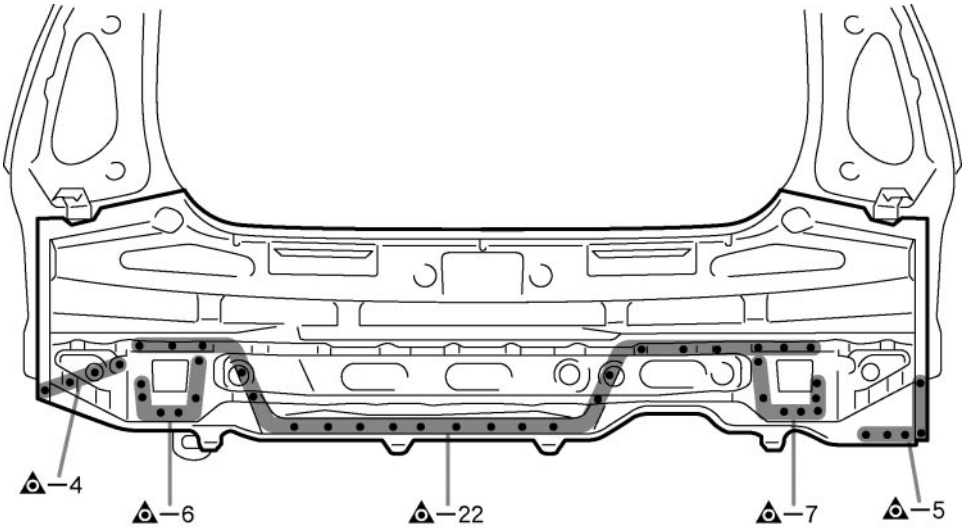
[A] Rocker Outer Reinforcement [B] Roof Side Outer Panel

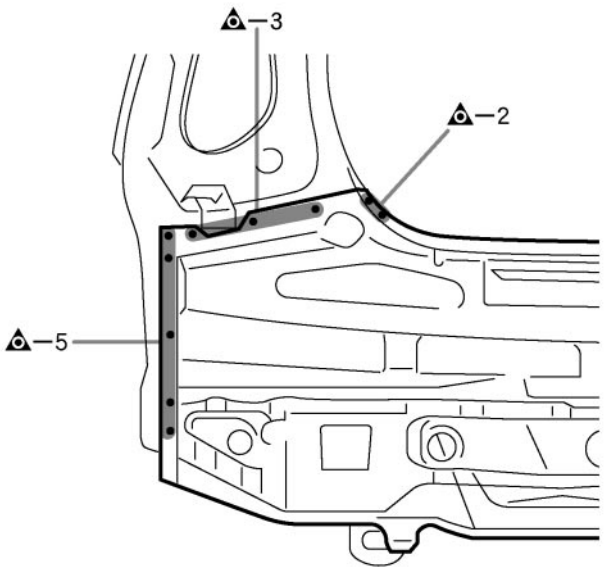
BODY LOWER BACK PANEL (ASSY)


F16174A

REPLACEMENT

REMOVAL

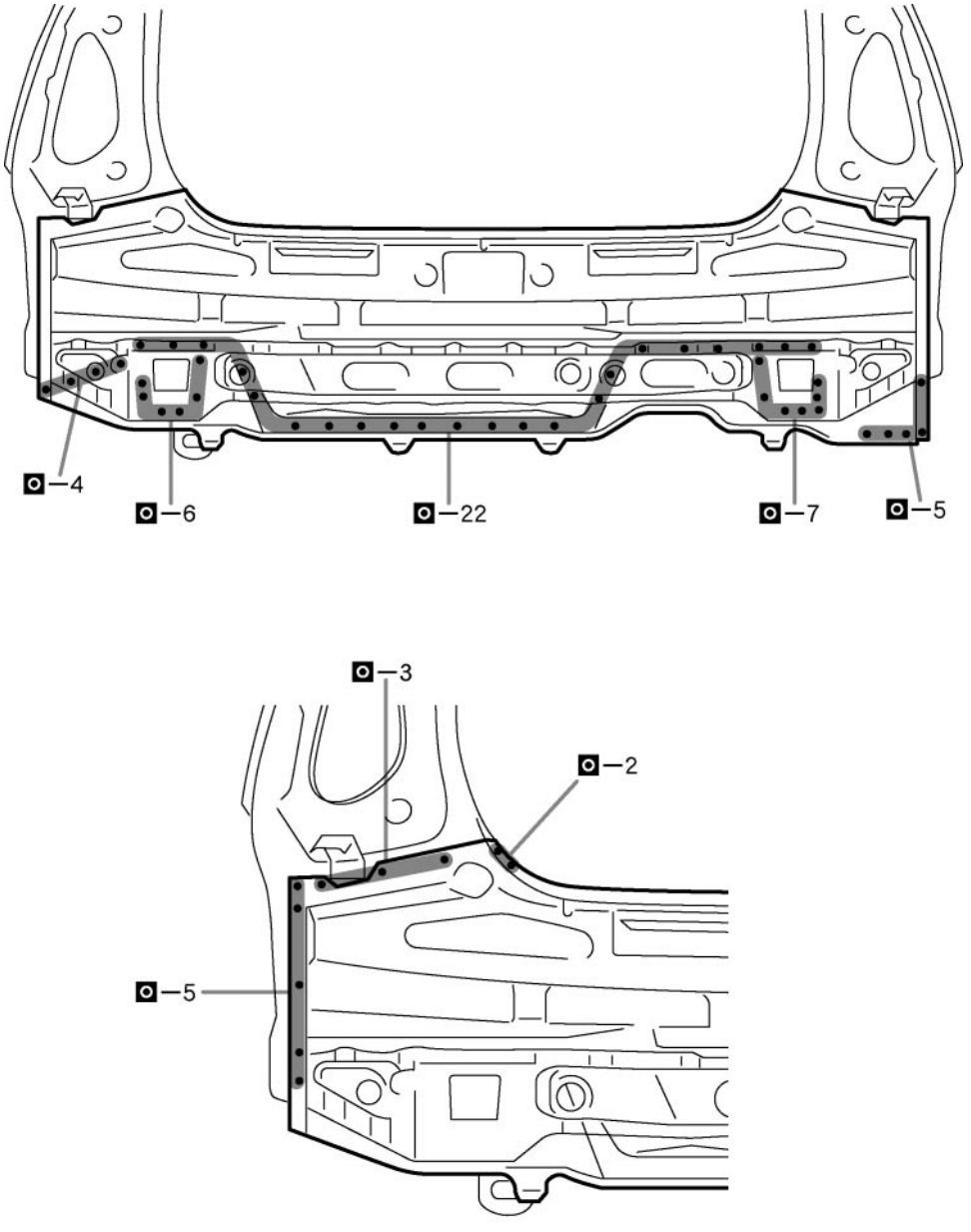




F16192

INSTALLATION

- 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)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.

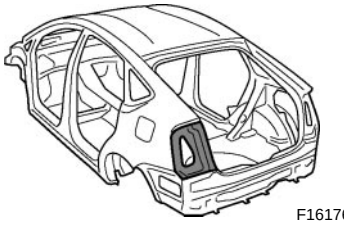


F16193

POINT

1 Inspect the fitting of the back door and rear combination light, etc., before welding, since this affects the appearance of the finish.

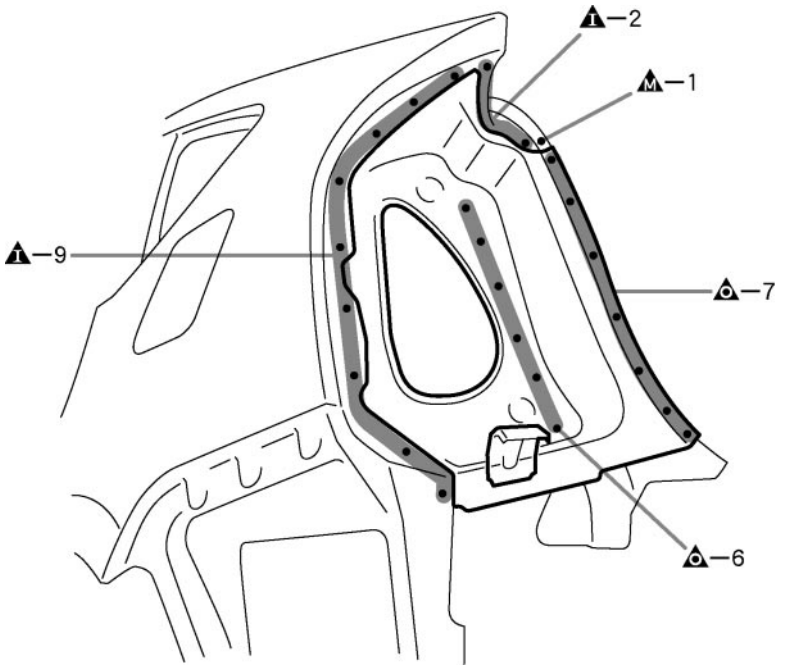
BACK DOOR OPENING TROUGH (ASSY)


F16176A

REPLACEMENT

With the body lower back panel removed.

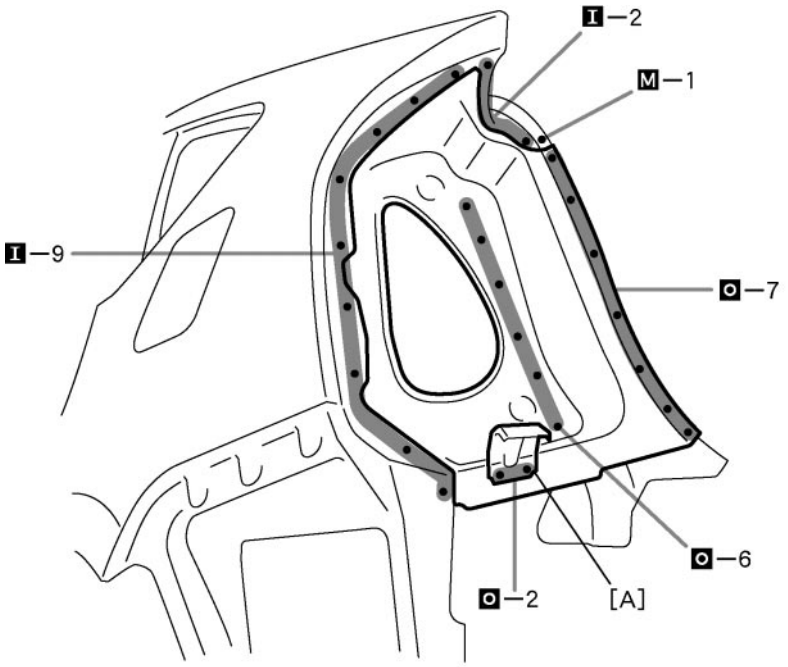
REMOVAL

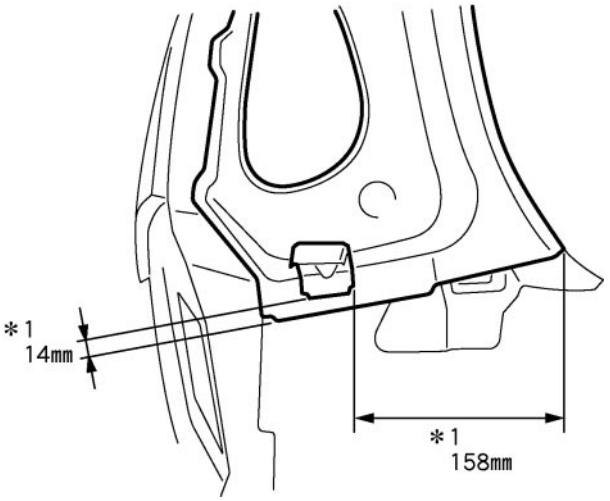


F16176

INSTALLATION

- 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)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.





F16177

POINT

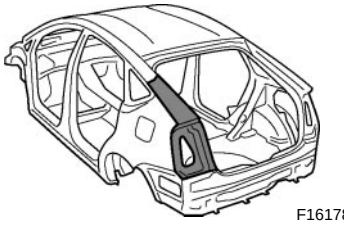
1 *1 : Reference value.
2 Inspect the fitting of the rear combination light, etc., before welding, since this affects the appearance of the finish.

PART NAME

[A] Rear Bumper Arm Bracket

14mm (0.55in.) 158mm (6.22in.)

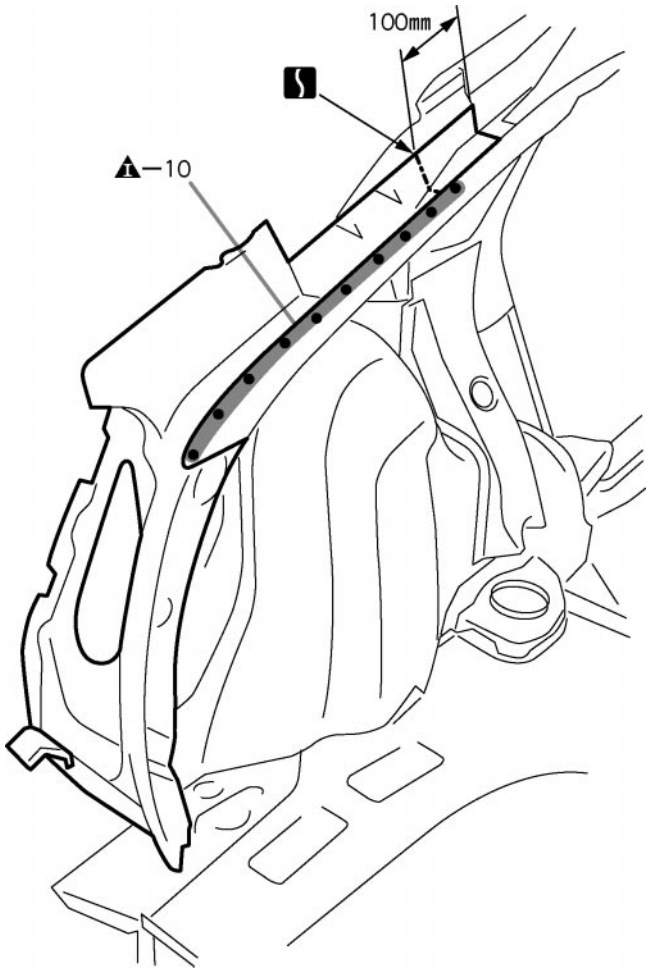
ROOF SIDE INNER REINFORCEMENT (CUT)


F16178A

REPLACEMENT

With the quarter panel, body lower back panel removed.

REMOVAL

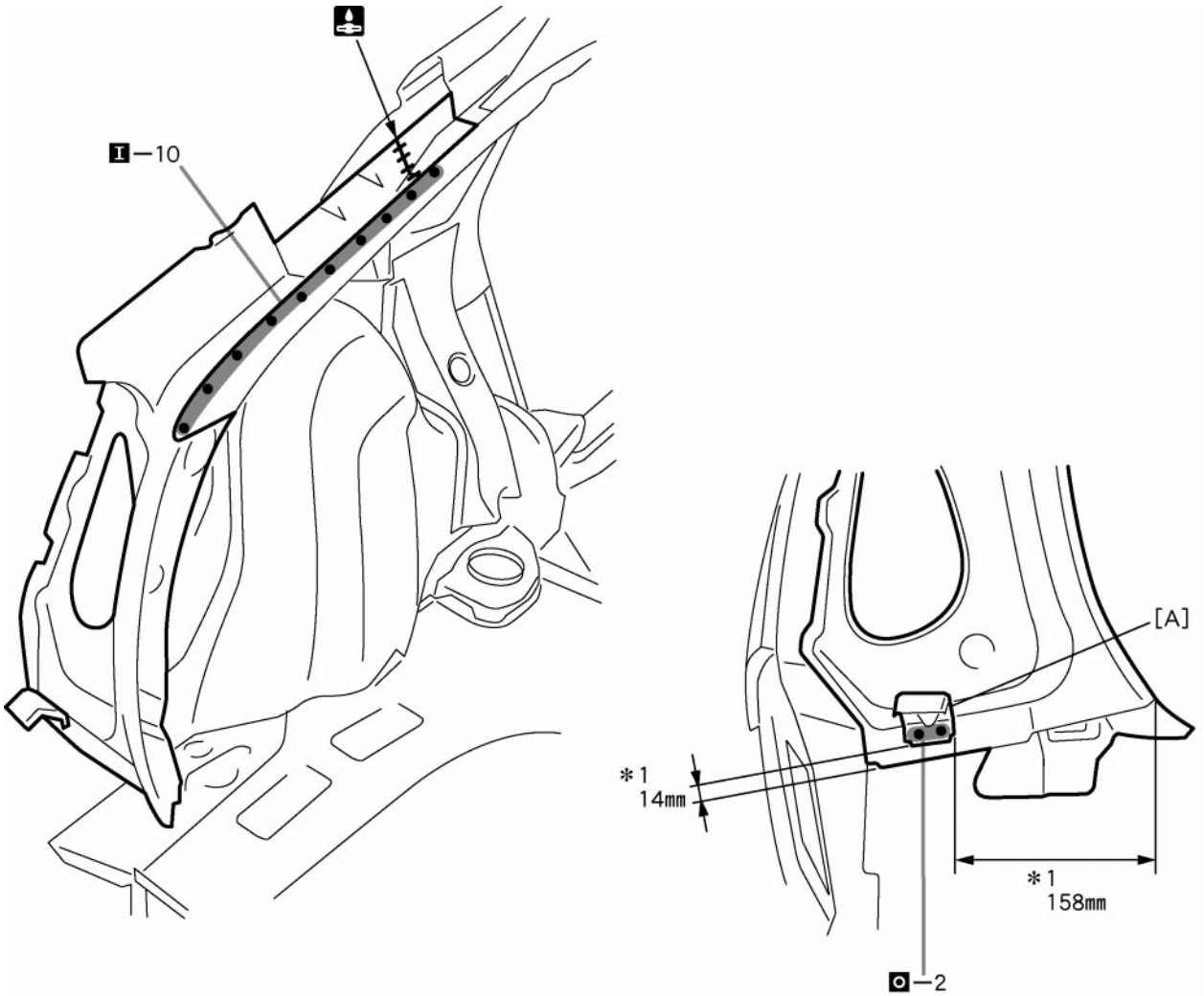


F16178

100mm (3.94in.)

INSTALLATION

- 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)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



F16179-b

POINT

1 *1: Reference value

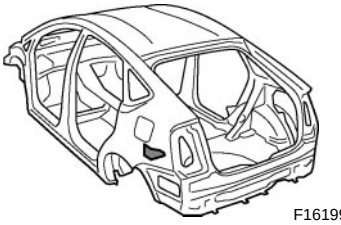
2 Inspect the fitting of the rear combination light, etc., before welding, since this affects the appearance of the finish.

PART NAME

[A] Rear Bumper Arm Bracket

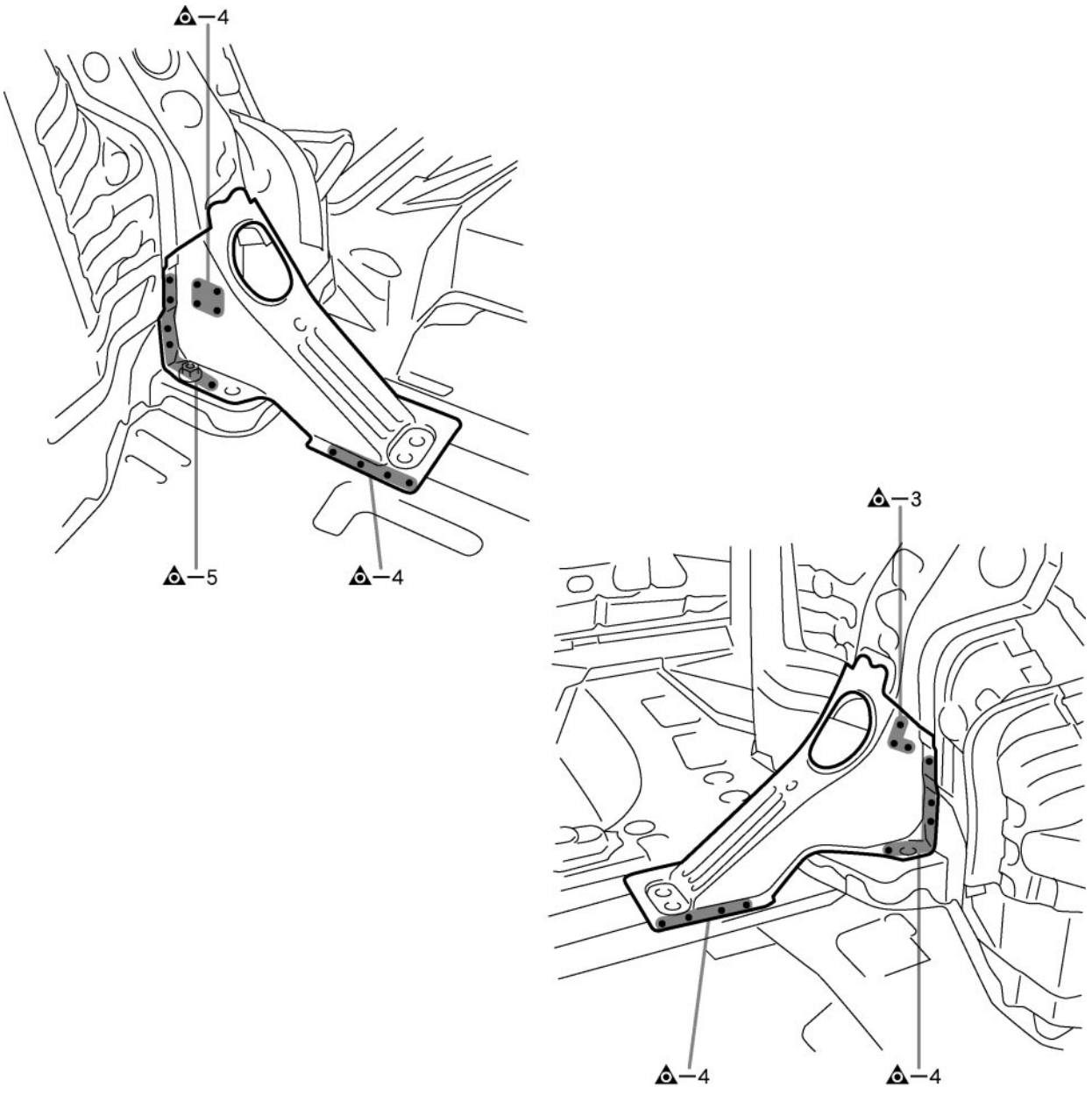
14mm (0.55in.) 158mm (6.22in.)

REAR ABSORBER MOUNTING NO.1 BRACKET (ASSY)


F16199A

REPLACEMENT

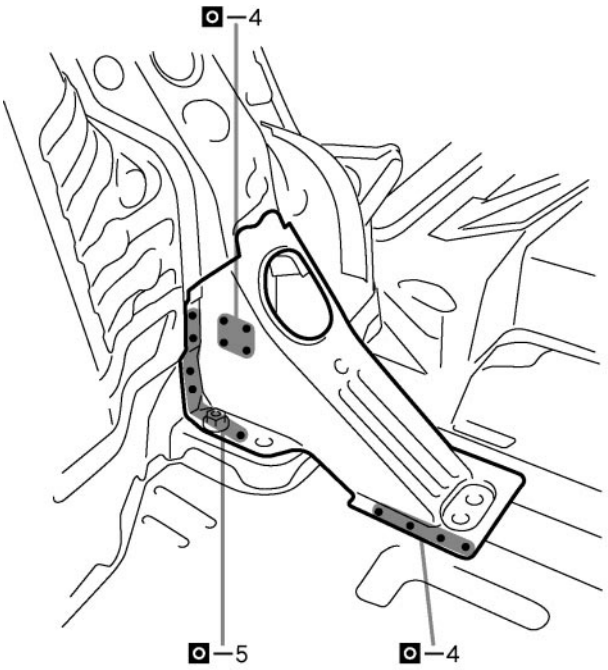
REMOVAL

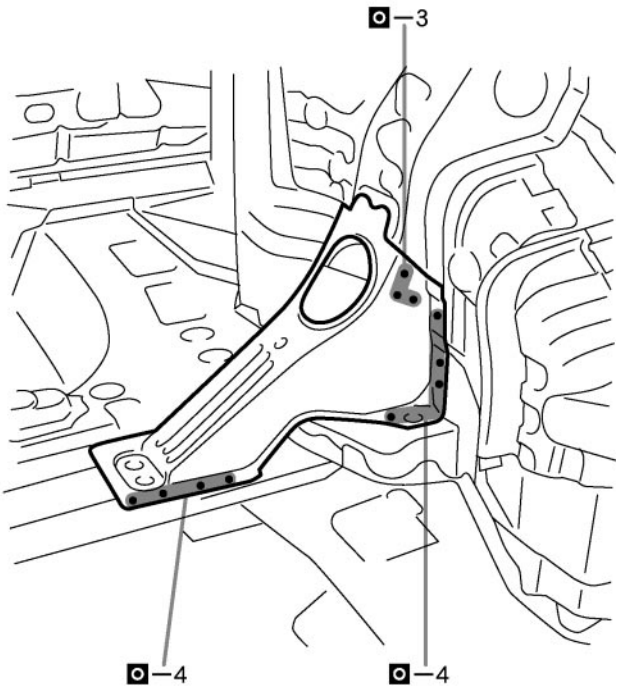


F16180

INSTALLATION

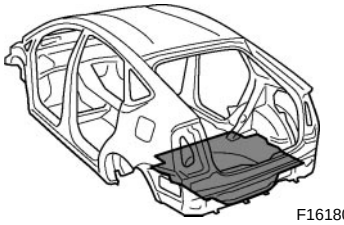
- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.





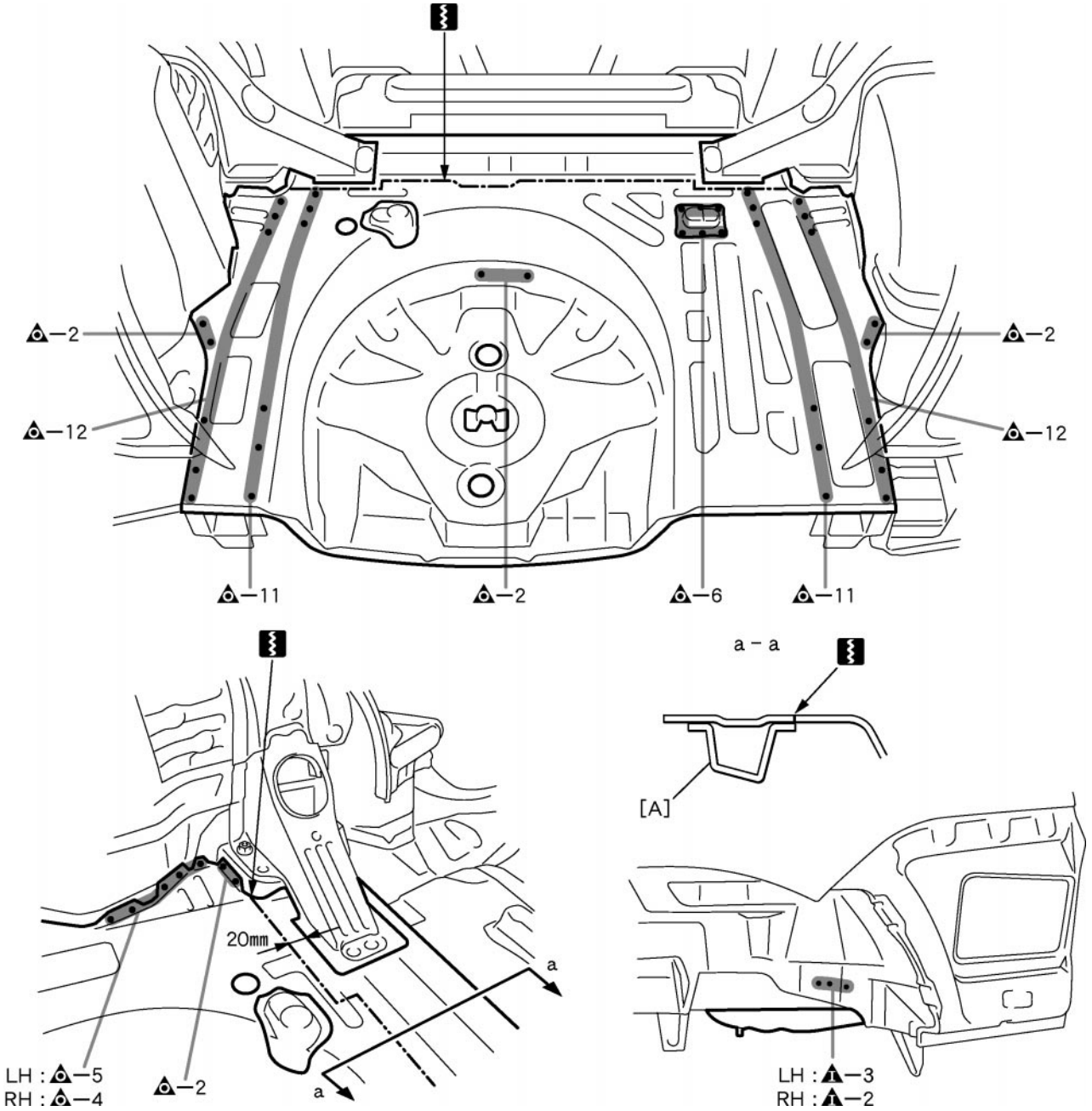
F16199

REAR FLOOR PAN (CUT)


F16180A

REPLACEMENT
With the body lower back panel removed.

REMOVAL



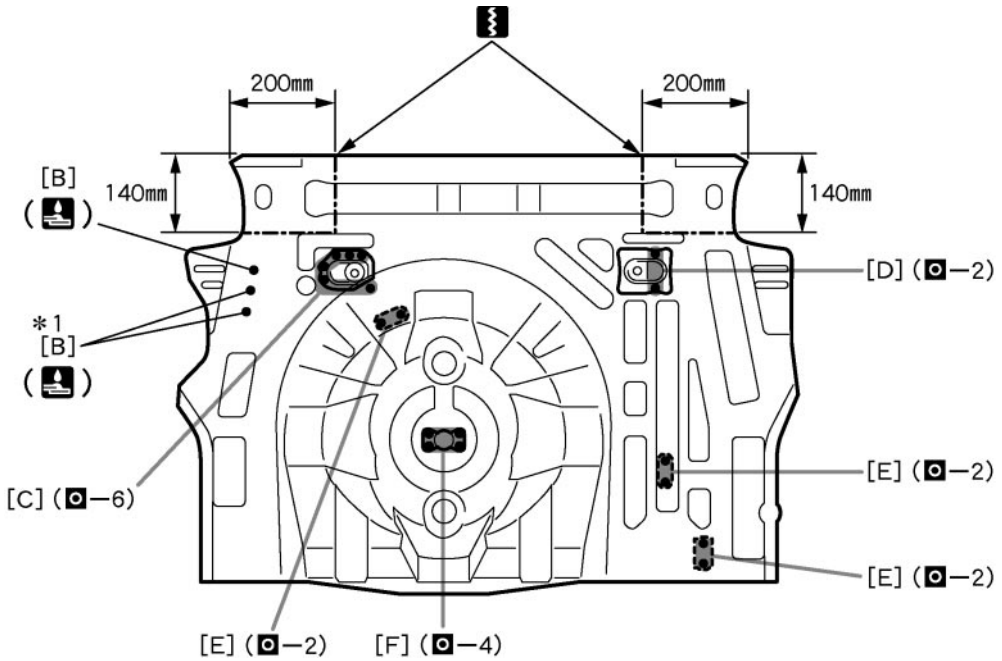
F16200

PART NAME
[A] Rear Floor No.2 Crossmember

20mm (0.79in.)

INSTALLATION

- 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)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



F12095

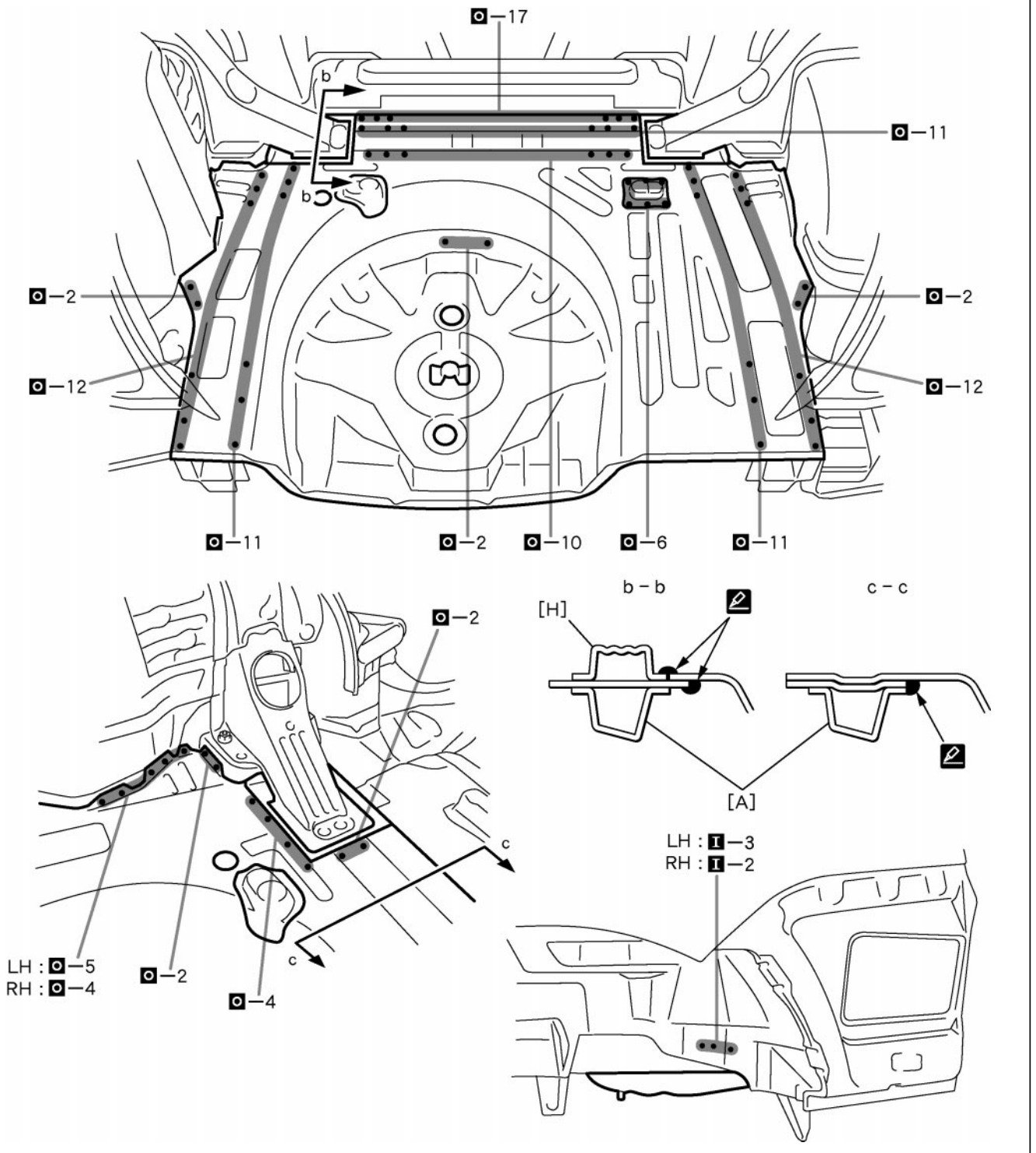
POINT

1 Attach of the [B] to center of the bearing surface.
2 *1: w/smart entry system

PART NAME

[B] Weld Bolt [C] Rear Floor Mounting No.2 LH Bracket
[D] Rear Floor Mounting No.2 RH Bracket [E] Fuel Tube No.3 Bracket
[F] Spare Wheel Clamp Bracket

140mm (5.51in.) 200mm (7.87in.)



POINT

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

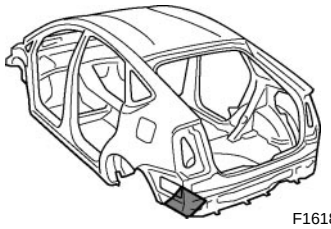
HINT:

1) Confirm that the panels are securely welded together.

PART NAME

[A] Rear Floor No.2 Crossmember [H] Rear Absorber Mounting No.1 Bracket

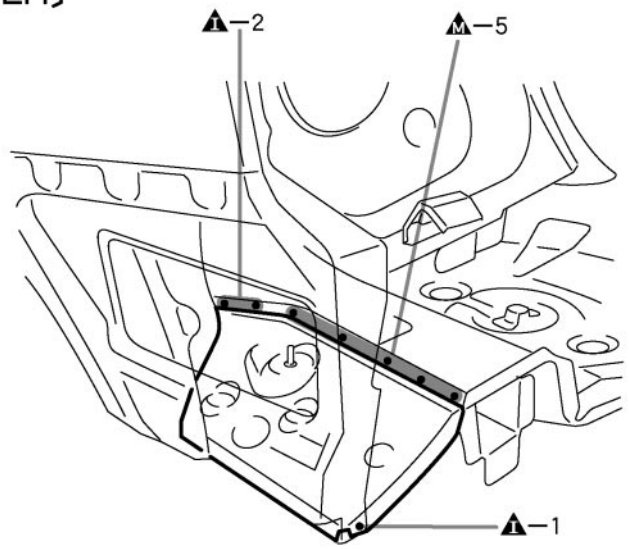
REAR FLOOR SIDE PANEL (ASSY)

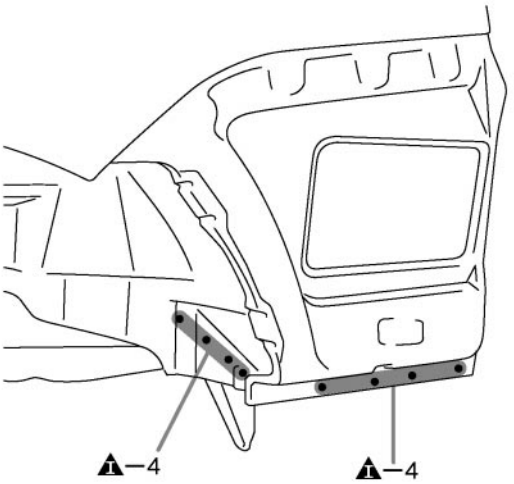

F16184A

REPLACEMENT
With the body lower back panel removed.

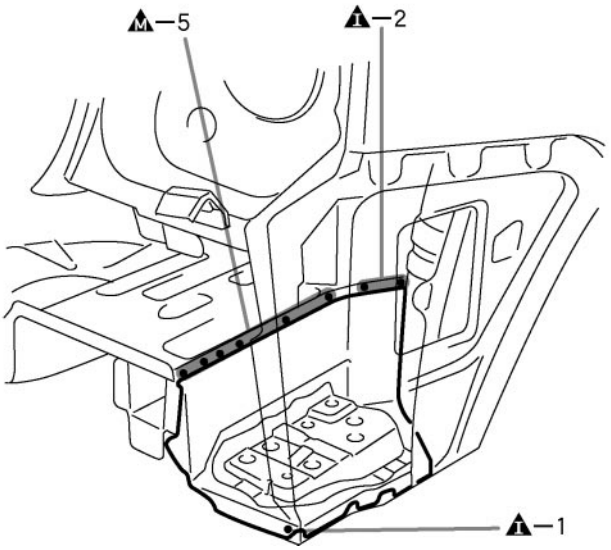
REMOVAL

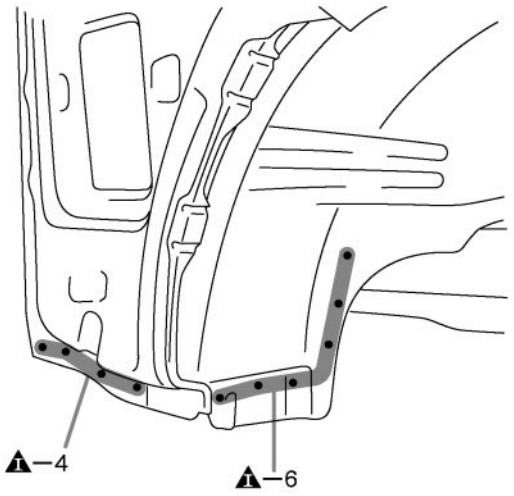
〔LH〕





〔RH〕

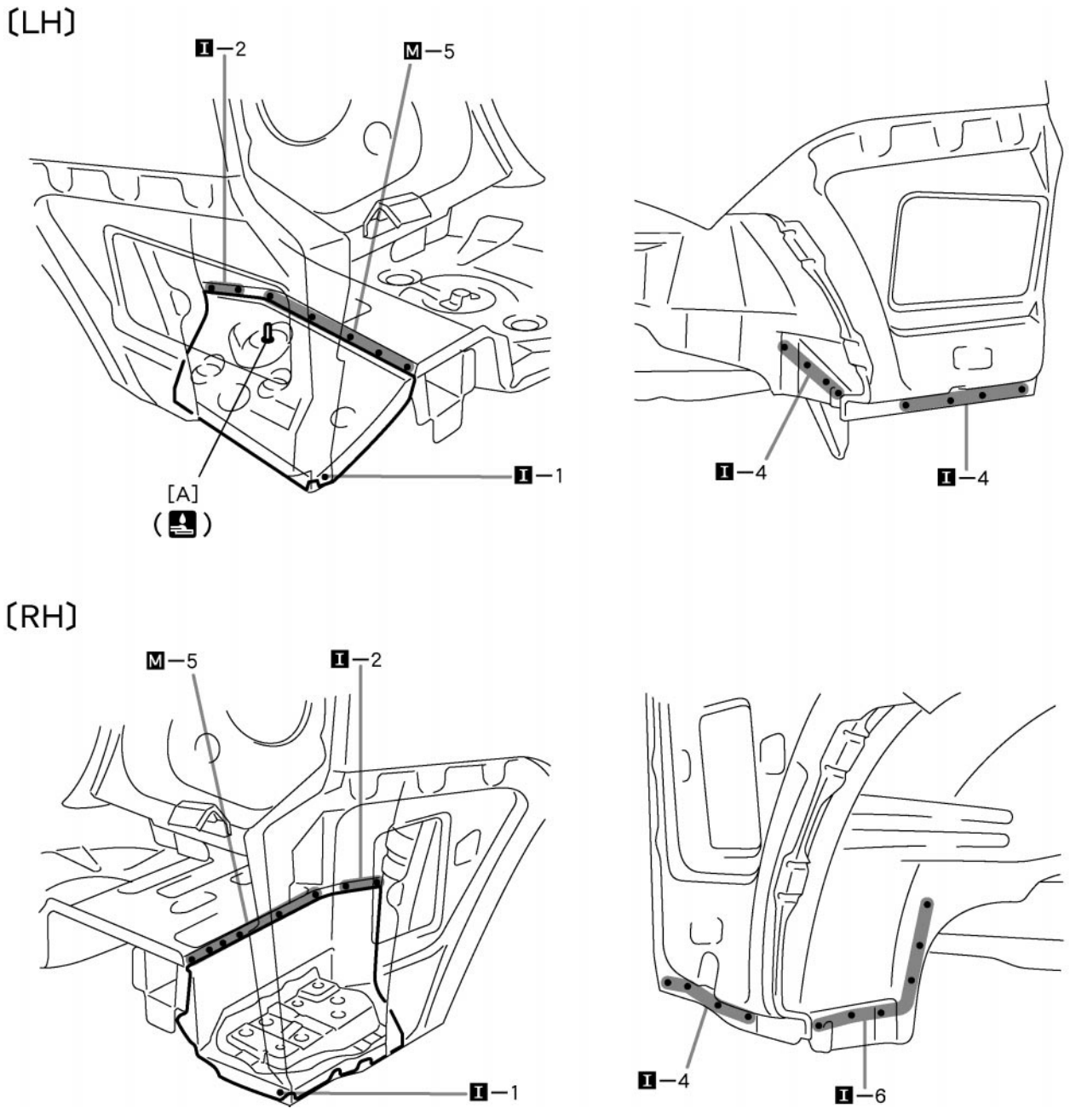




F16184

INSTALLATION

- 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)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



F16185

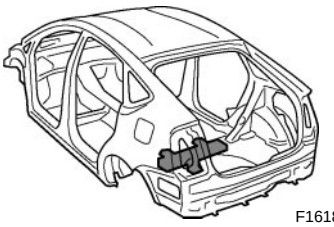
POINT

1 Attach of the [A] to center of the bearing surface.

PART NAME

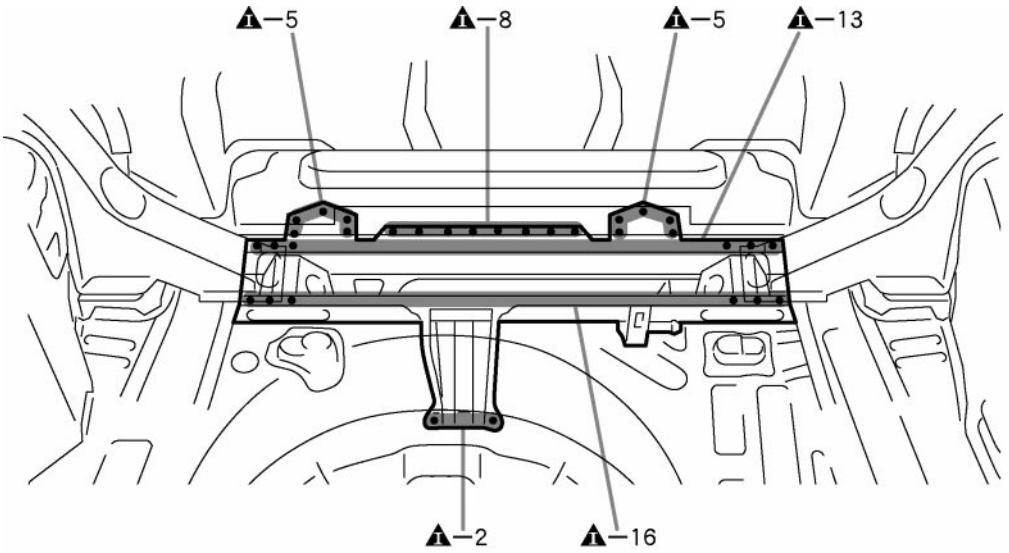
[A] Weld Bolt

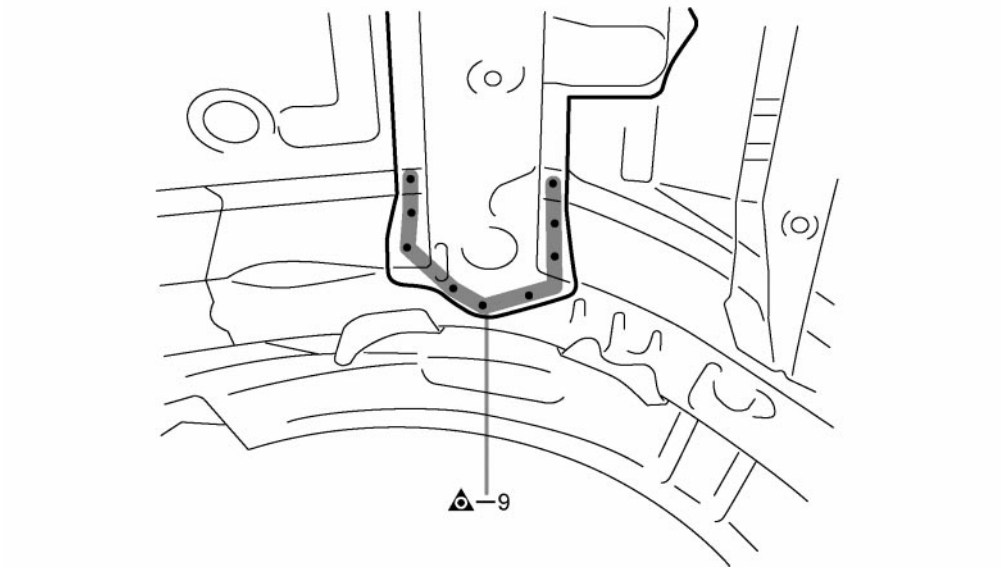
REAR FLOOR NO.2 CROSSMEMBER (ASSY)


F16186A

REPLACEMENT

REMOVAL

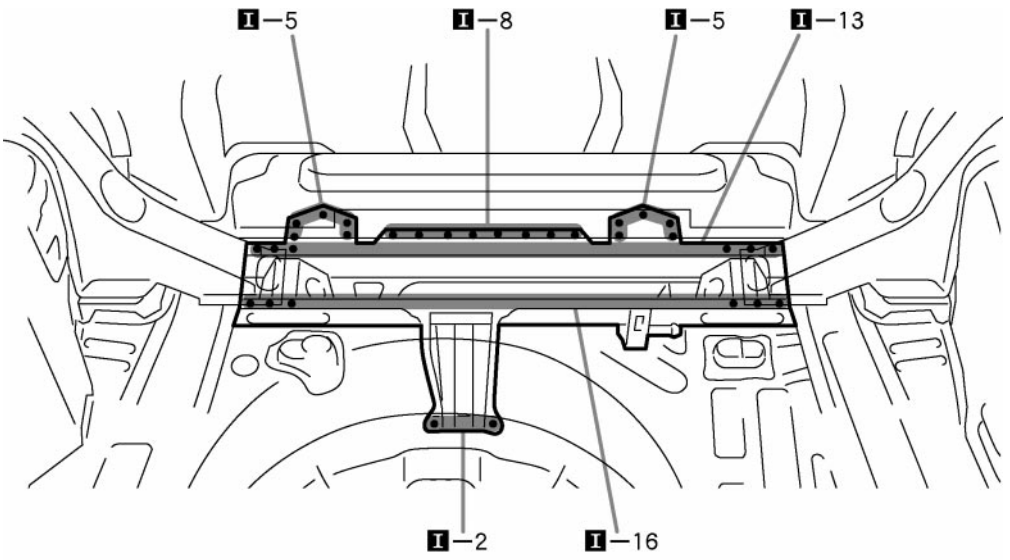


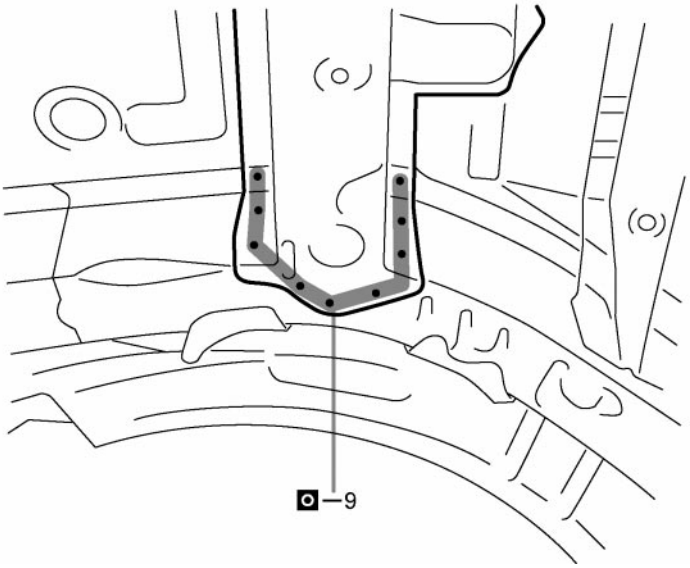


F16186

INSTALLATION

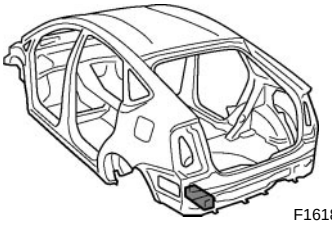
- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.





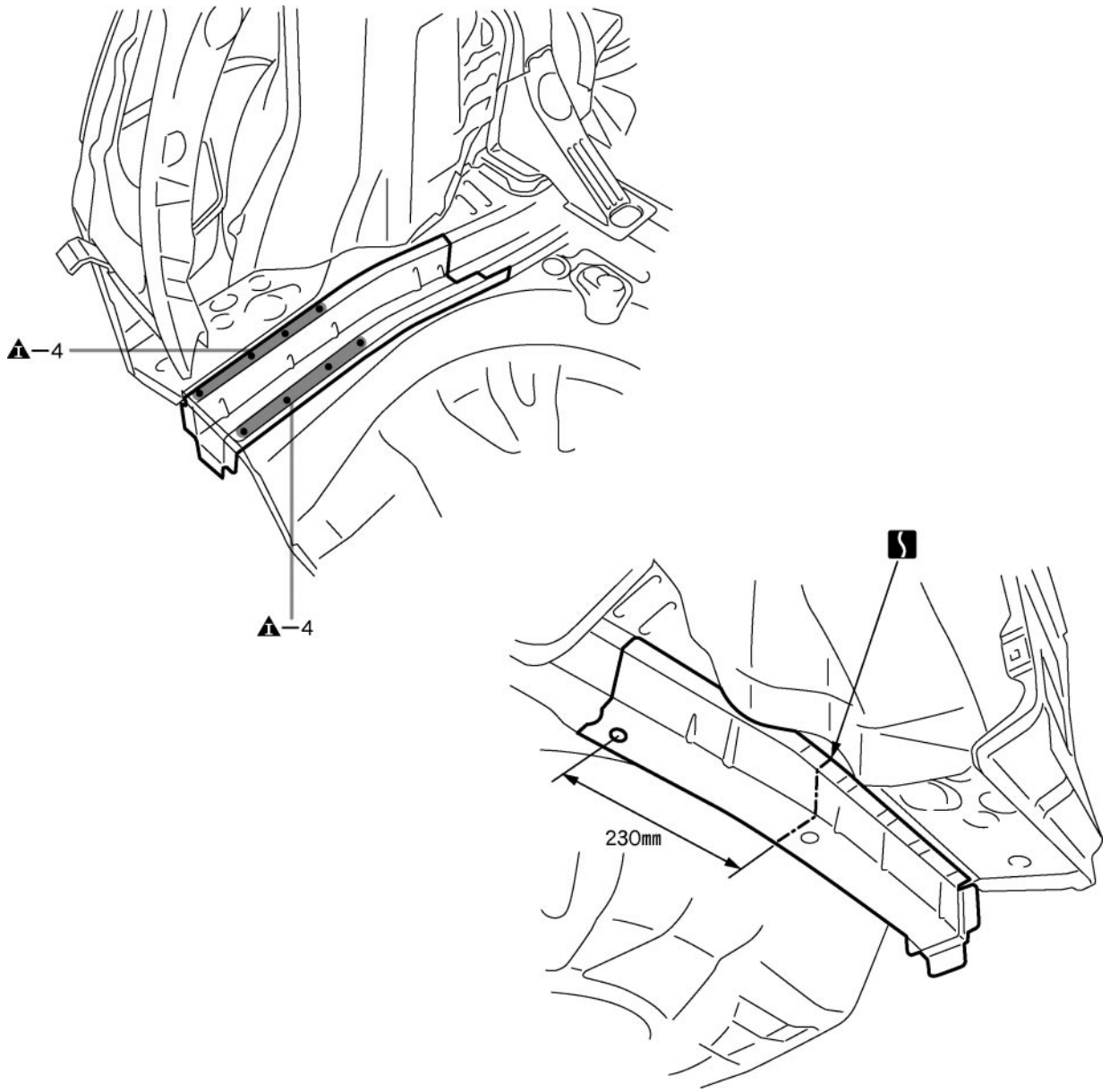
F16187

REAR FLOOR SIDE REAR MEMBER (CUT-H)


F16188A

REPLACEMENT
With the body lower back panel removed.

REMOVAL

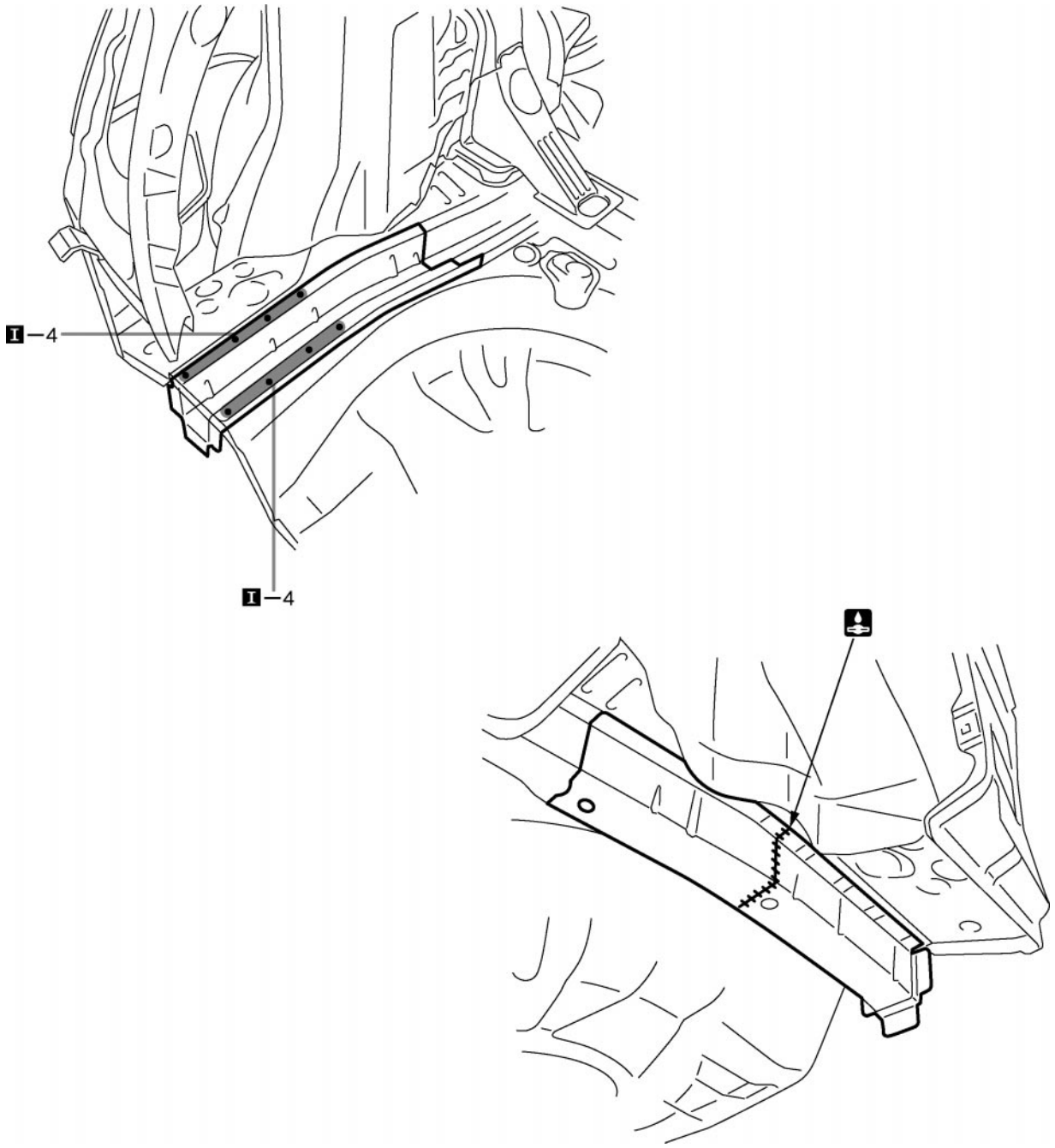


F16194

230mm (9.06in.)

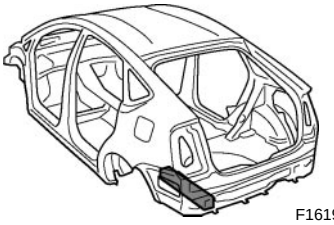
INSTALLATION

- 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)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.



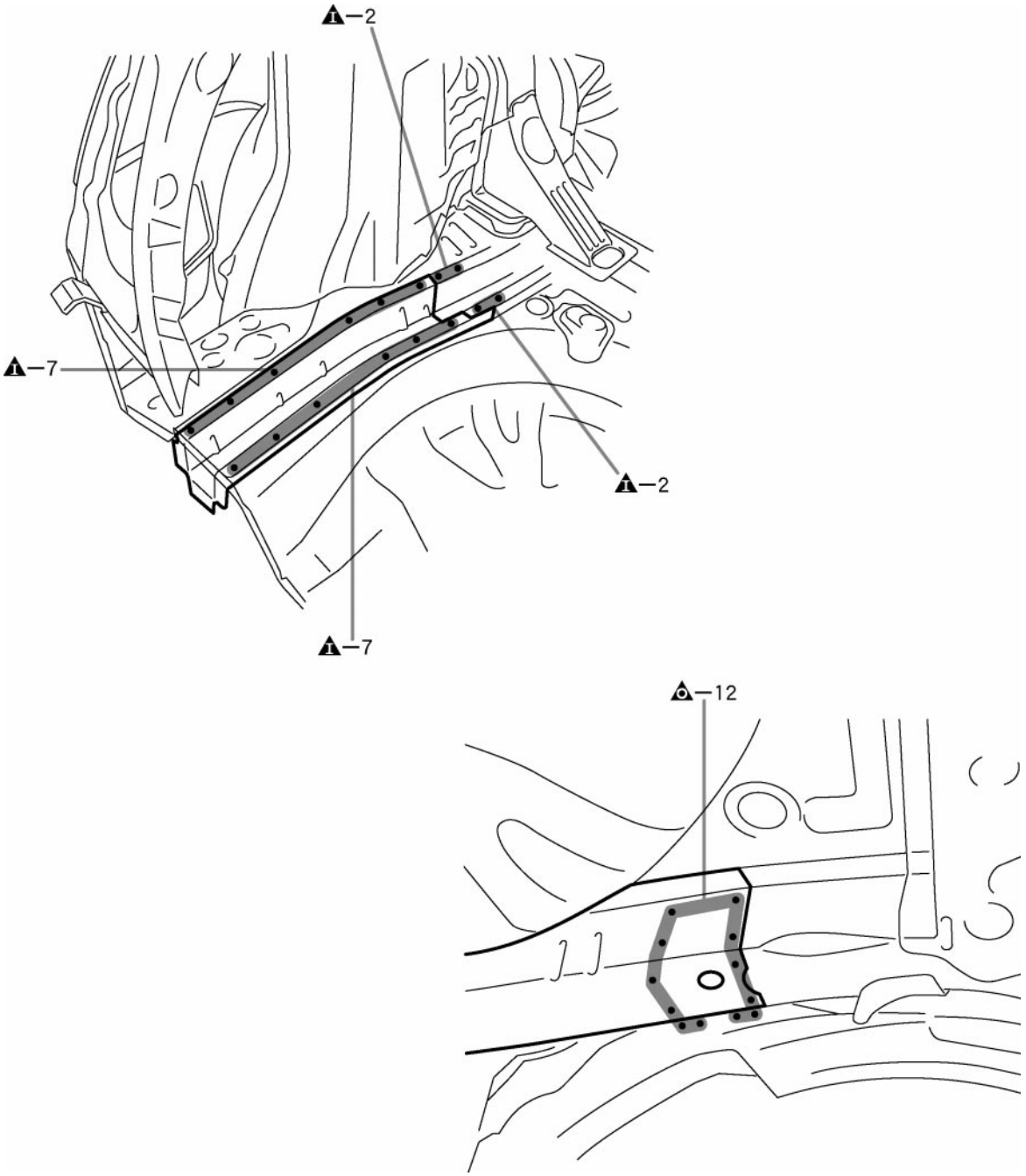
F16195

REAR FLOOR SIDE REAR MEMBER (ASSY)


F16190A

REPLACEMENT
With the body lower back panel removed.

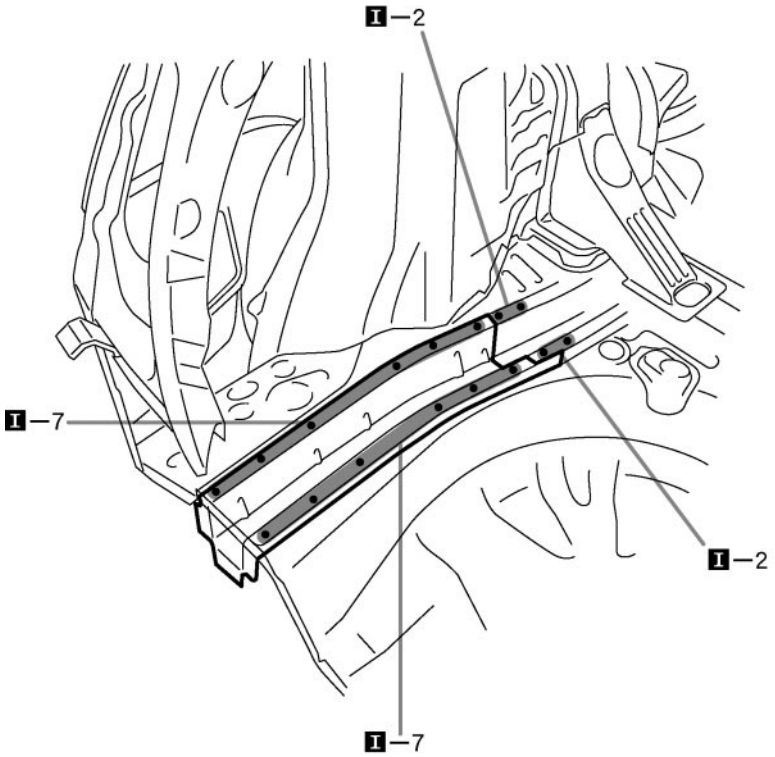
REMOVAL

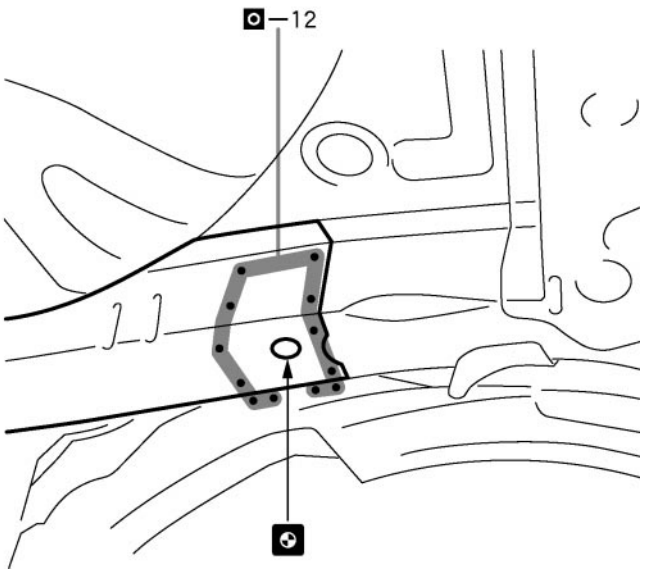


F16196

INSTALLATION

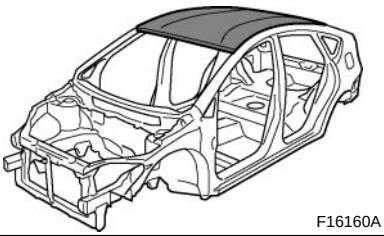
- Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.





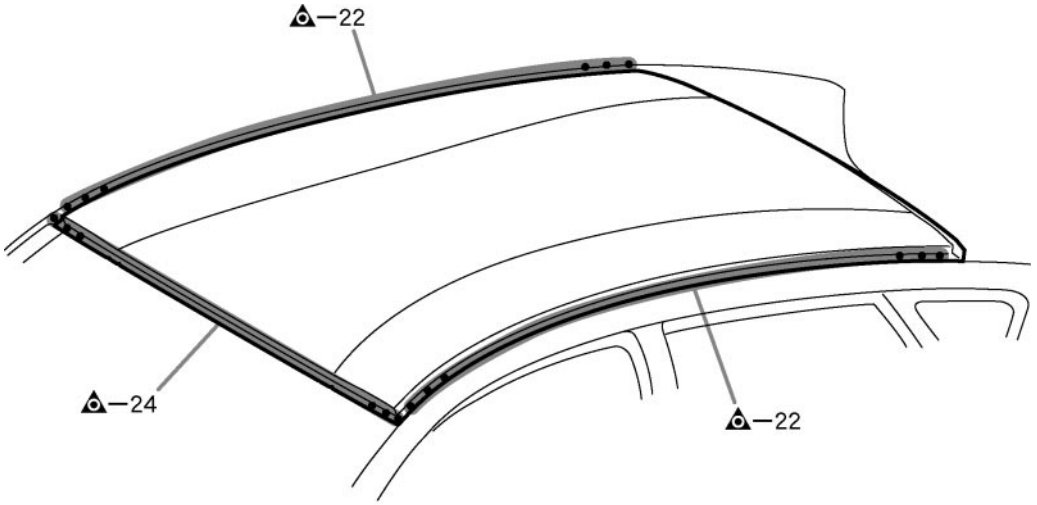
F16197

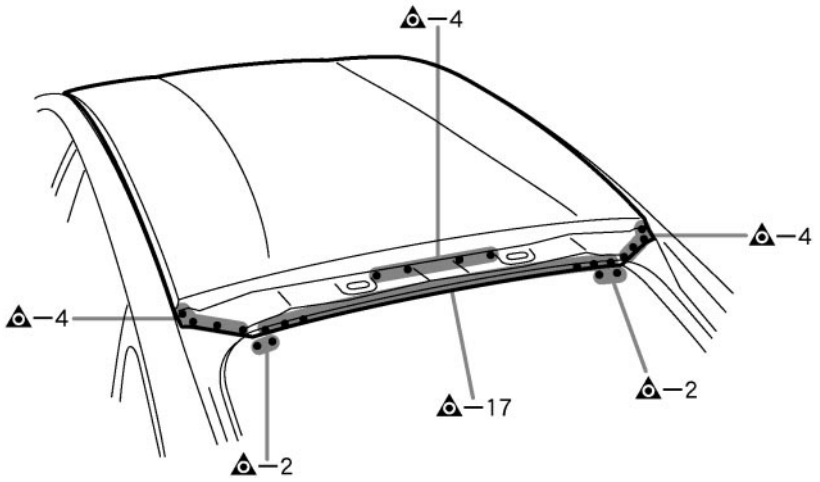
ROOF PANEL (ASSY)


F16160A

REPLACEMENT

REMOVAL

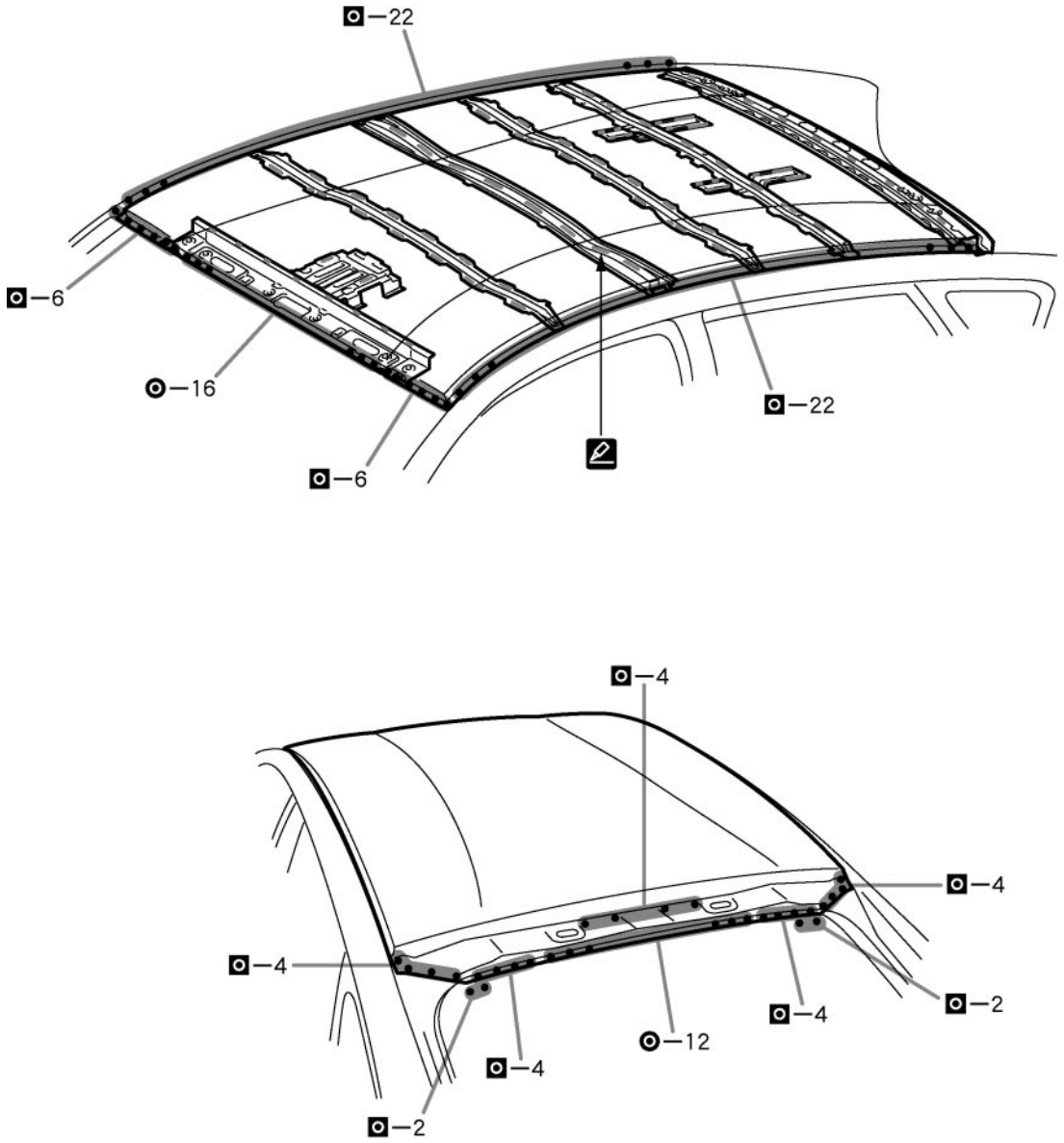




F16160

INSTALLATION

- 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)
- Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- After welding, apply the polyurethane foam to the corresponding parts.
- After welding, apply body sealer and under-coating to the corresponding parts.
- After applying the top coat layer, apply anti-rust agent to the inside of the necked section structural weld spots.

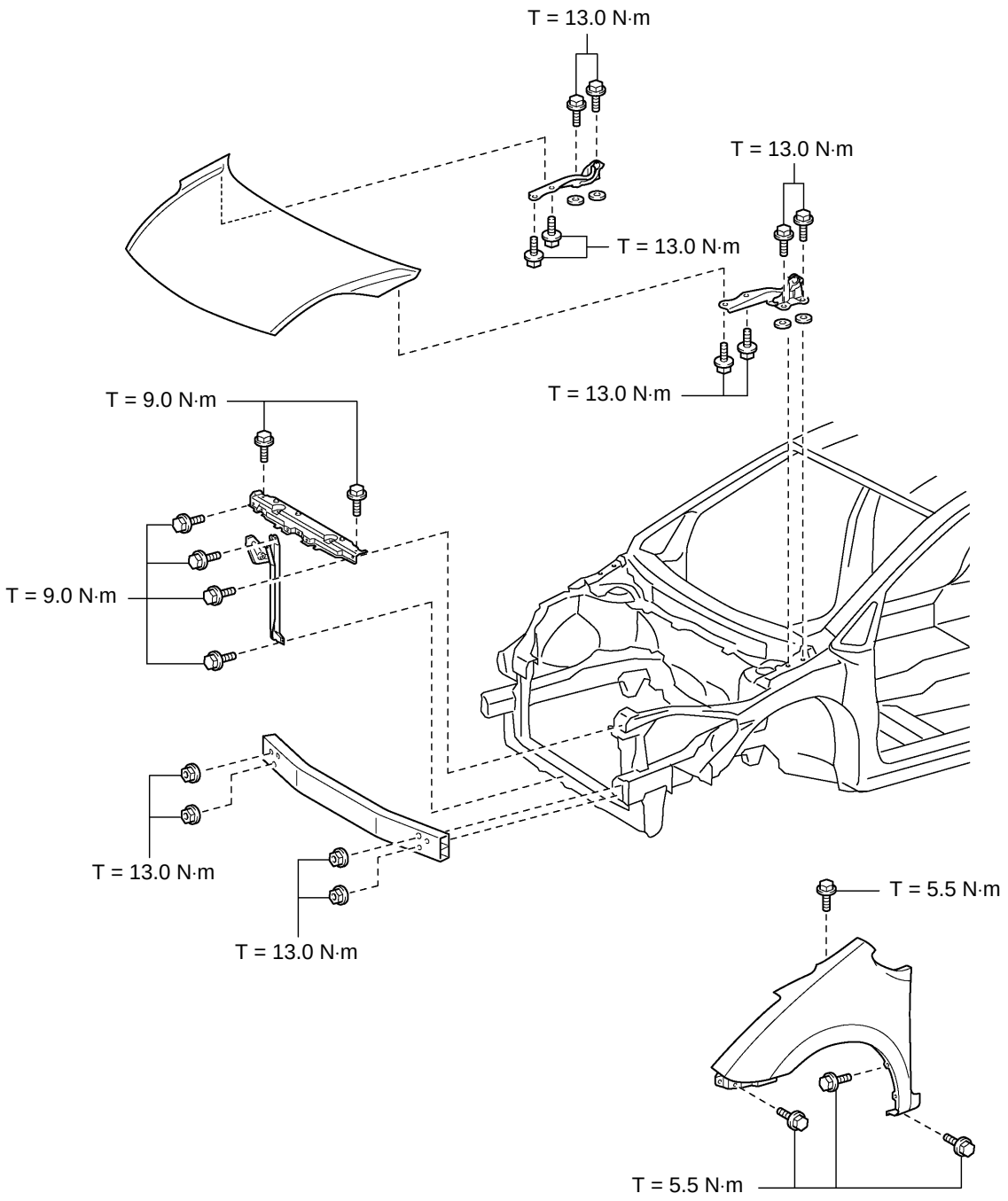


F16161

POINT

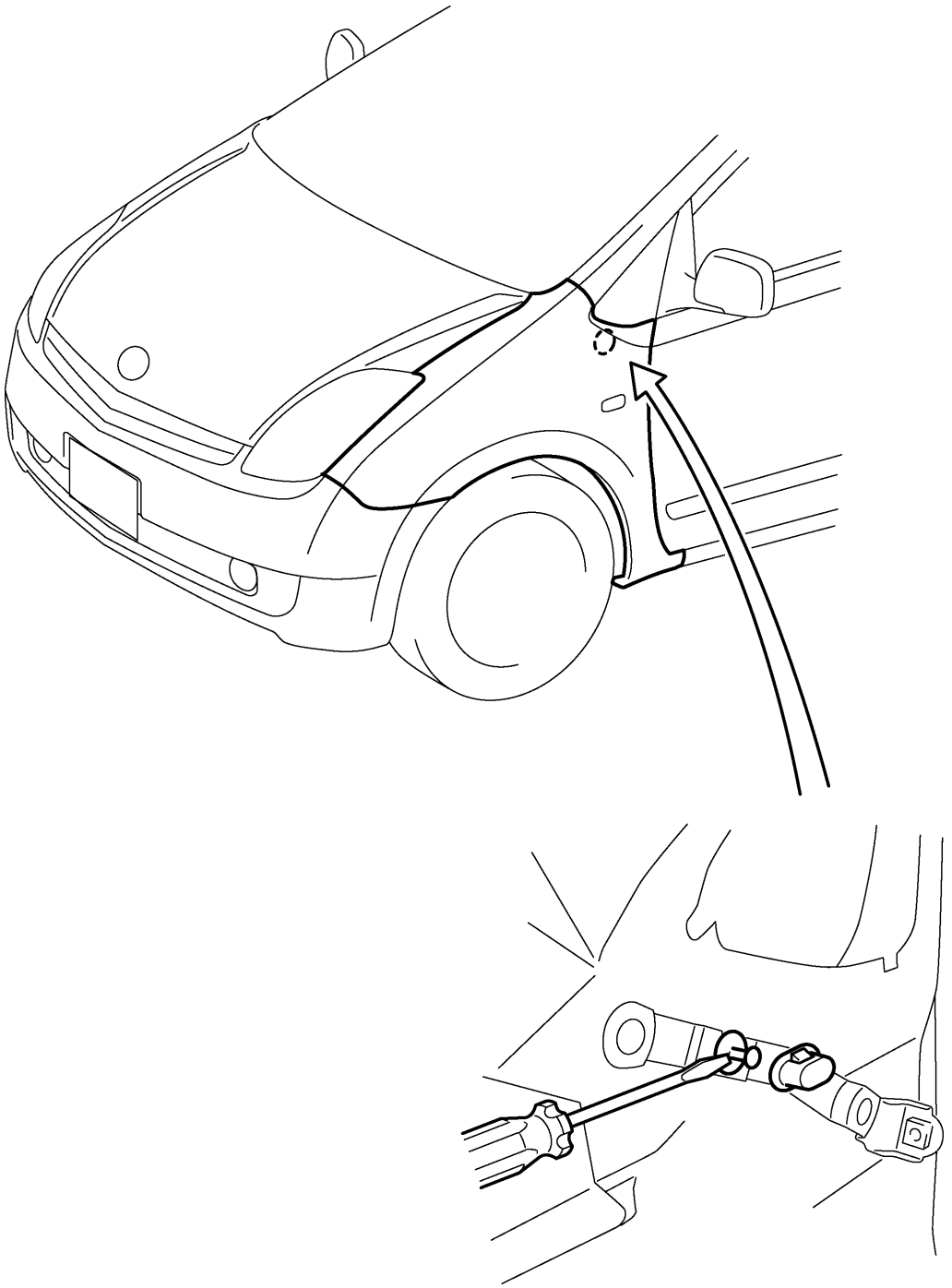
1 Before temporarily installing the new parts, apply body sealer to the windshield header panel, roof panel reinforcement and back window frame.
HINT:
1) Apply just enough sealer for the new parts to make contact.

OUTER PANEL INSTALLATION TORQUE



F16111

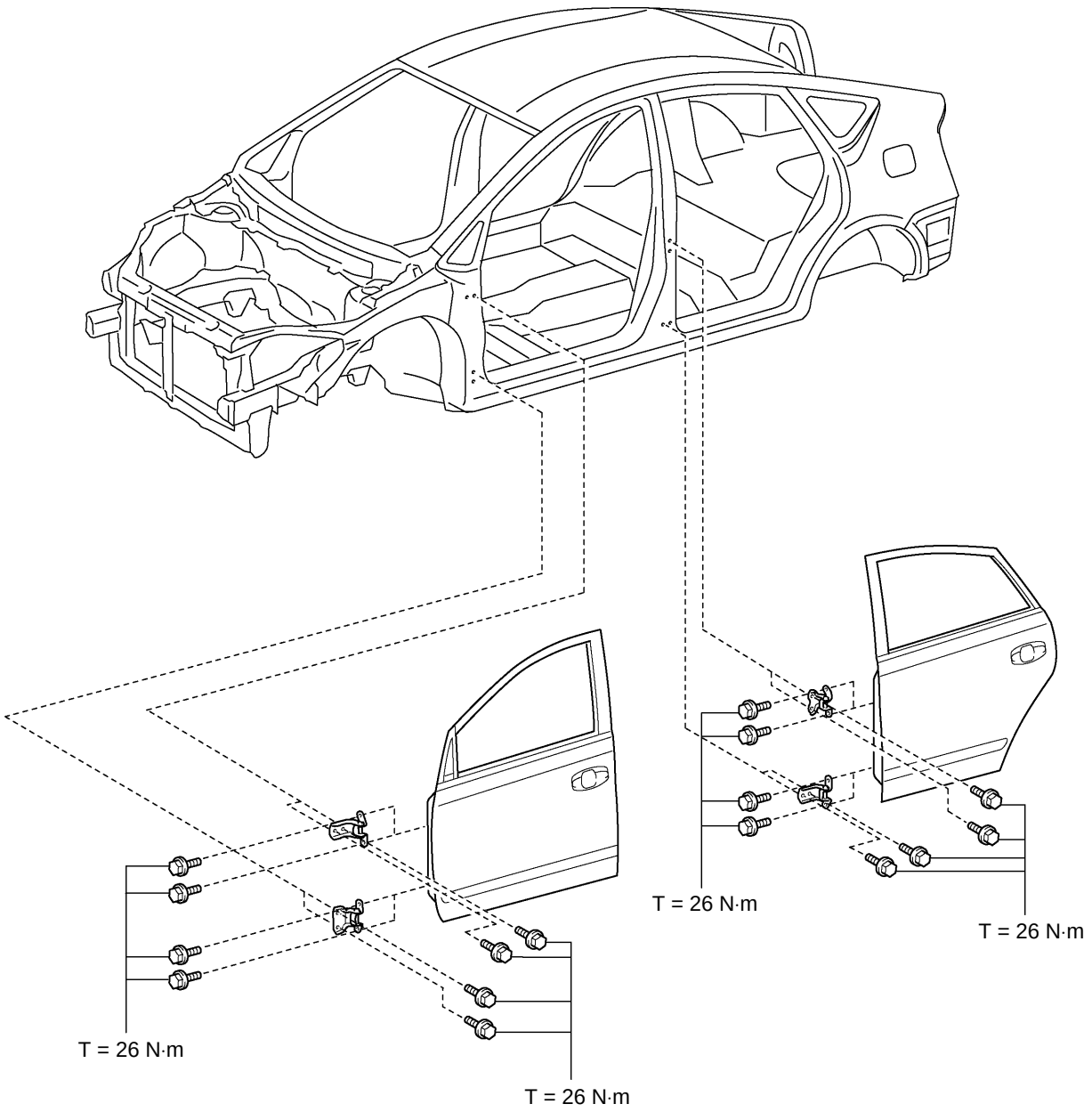
5.5 N·m (56 kgf·cm, 4 ft-lb)	9.0 N·m (92 kgf·cm, 7 ft-lb)	13.0 N·m (133 kgf·cm, 10 ft-lb)



F16198

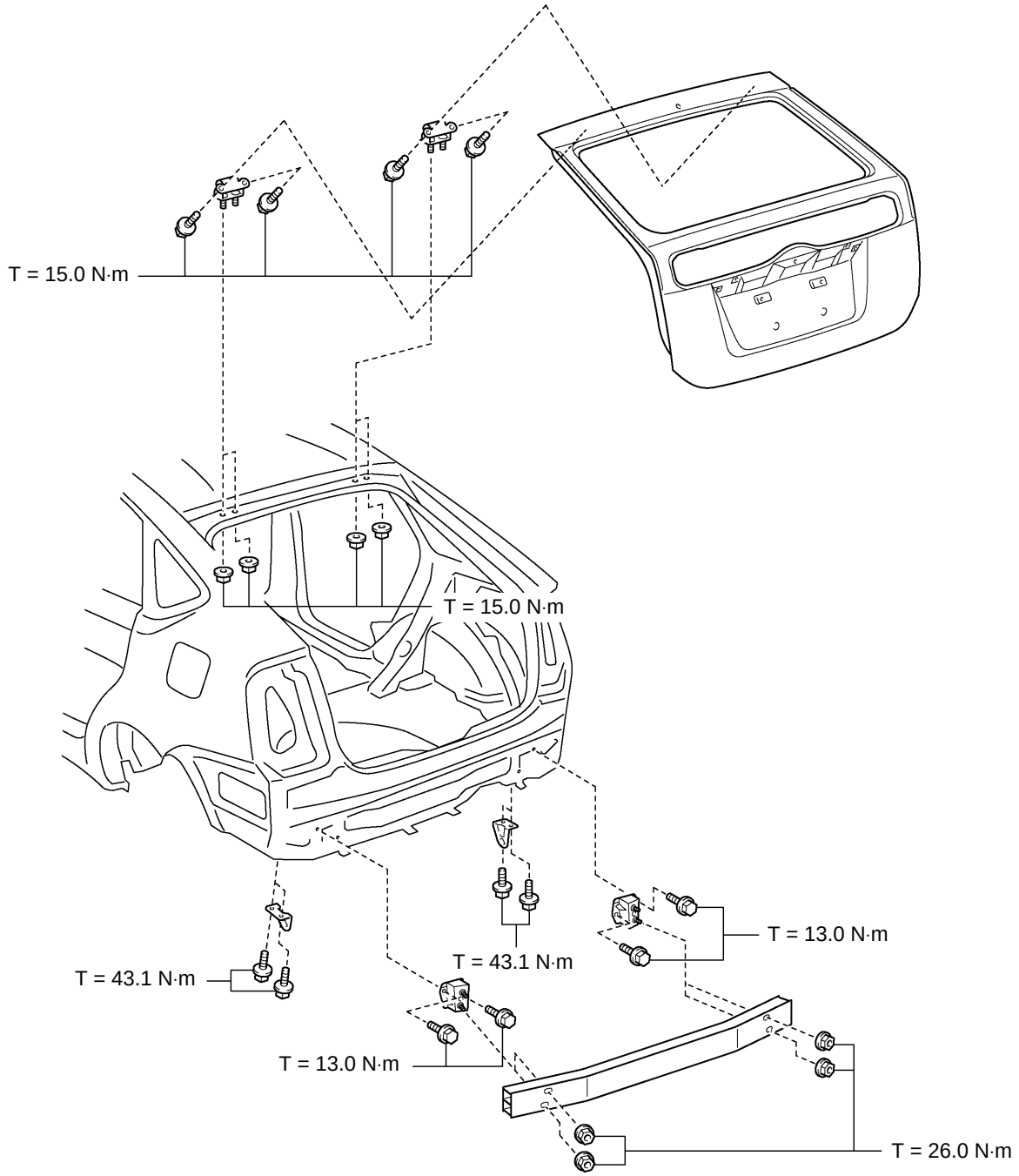
POINT

1 From the fender liner side, use a screwdriver to disengage and remove the clip. Remove the front fender.



F16112

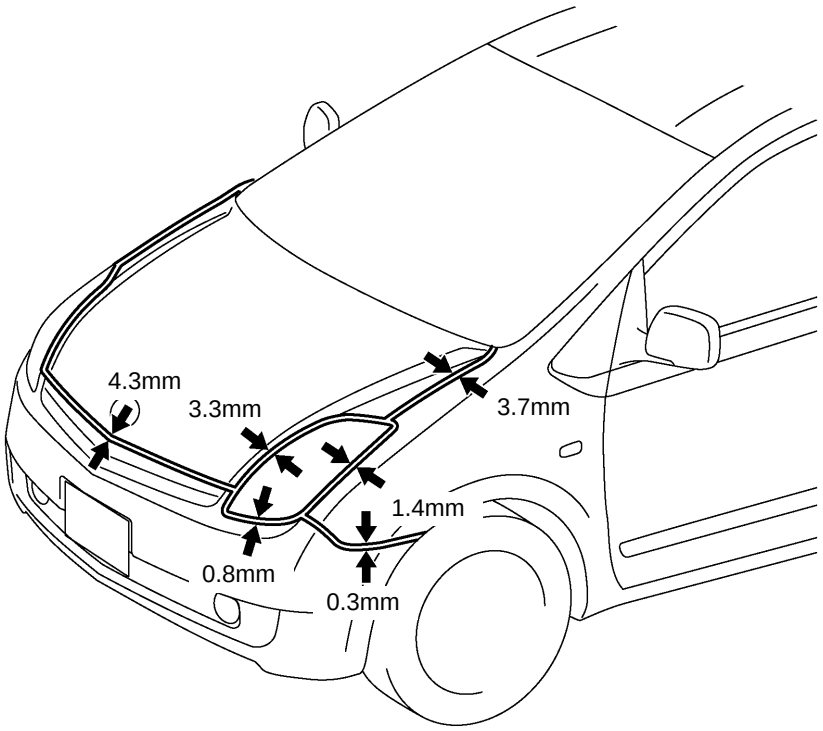
26.0 N·m (265 kgf·cm, 19 ft-lb)	—	—

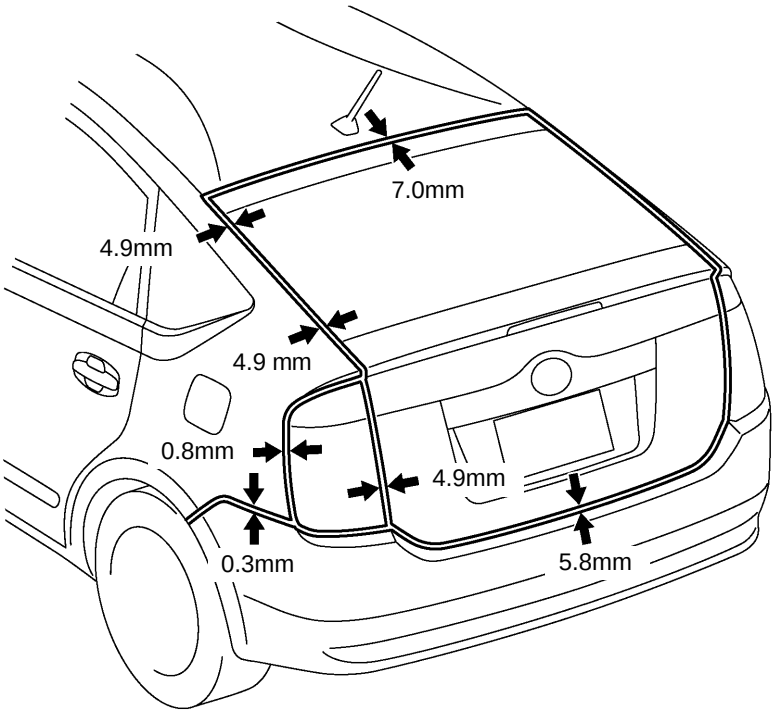


F16114

11.5 N·m (117 kgf·cm, 8 ft-lb)	13.0 N·m (133 kgf·cm, 10 ft-lb)	15.0 N·m (153 kgf·cm, 11ft-lb)
26.0 N·m (265 kgf·cm, 19 ft-lb)	43.1 N·m (439 kgf·cm, 32 ft-lb)	—

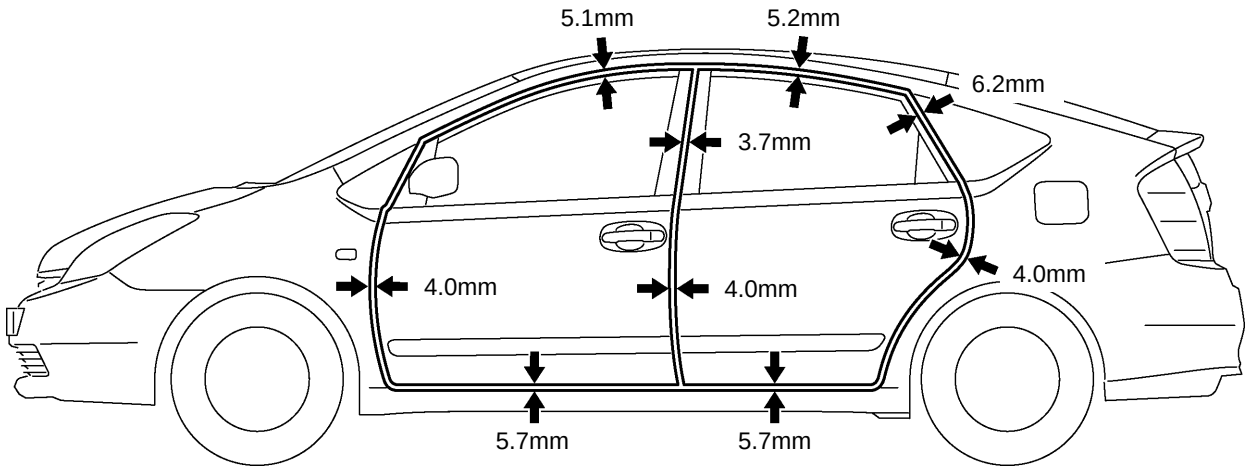
FIT STANDARDS





F16115

0.3mm (0.01in.)	0.8mm (0.03in.)	1.4mm (0.06in.)
3.3mm (0.13in.)	3.7mm (0.15in.)	4.3mm (0.17in.)
4.9mm (0.19in.)	5.8mm (0.23in.)	7.0mm (0.28in.)



F16116

3.7mm (0.15in.)	4.0mm (0.16in.)	5.1mm (0.20in.)
5.2mm (0.20in.)	5.7mm (0.22in.)	—