

# 3 WELDED PANEL REPLACEMENT

3

EXPLANATION OF MANUAL CONTENTS .....	3-2
HEADLAMP HOUSING.....	3-4
FRONT END UPPER BAR .....	3-5
FRONT END CROSSMEMBER .....	3-6
FENDER SHIELD .....	3-7
COWL TOP PANEL .....	3-13
FRONT PILLAR.....	3-15
SIDE SILL, OUTER .....	3-18
CENTER PILLAR.....	3-20
QUARTER PANEL, OUTER .....	3-22
REAR PILLAR, OUTER .....	3-24
REAR END PANEL.....	3-26
REAR FLOOR PAN .....	3-27
REAR FLOOR CROSSMEMBER, LOWER.....	3-30
REAR FLOOR SIDEMEMBER .....	3-31
ROOF PANEL .....	3-34
QUARTER PANEL, INNER, LOWER.....	3-38
REAR WHEELHOUSE, INNER.....	3-40
FRONT DOOR OUTER PANEL.....	3-42

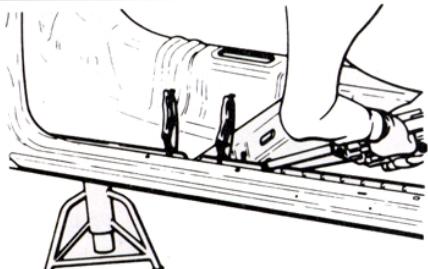
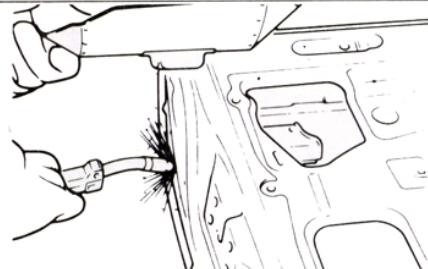
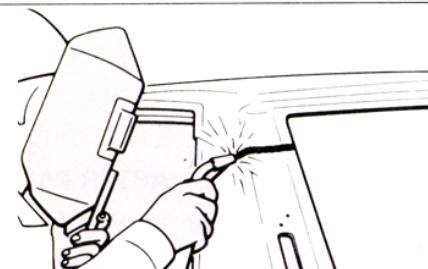
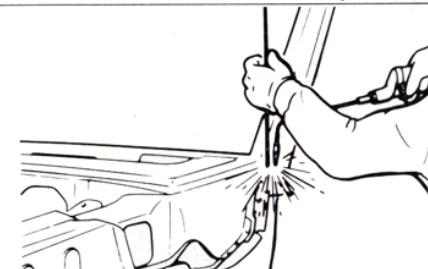
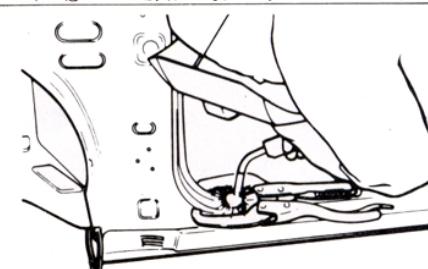
# WELDED PANEL REPLACEMENT

## EXPLANATION OF MANUAL CONTENTS

The basic parts supply units of the body structure are the weld-mounted outer panels. Herein are explained the procedures for replacement of these panels.

### SYMBOLS

The various operations for panel replacement are designated by the following symbols.

Symbol	Operation description	Illustration
● ● ● ●	Spot welding	 18YU11
++ + +	MIG spot welding	 18YV17
=====	MIG arc welding (continuous)	 18YU18
oooooo	Braze welding	 18YV99
■ ■ ■ ■	MIG plug welding	 18YU29
■ ■ ■ ■		

- indicates two panels to be welded
- indicates three panels to be welded

## EXPLANATION OF WELDED PANEL REPLACEMENT

The replacement parts to be used in the welded panel replacement are indicated here:

- "ASSEMBLY" indicates that the assembly part (for example, **A**) is to be used without alteration.
- "CUT" indicates that the replacement panel (for example, **A**) is to be cut into easy-to-use sections and then used for replacement.
- "PART" indicates that only the damaged section of the assembly part (for example, **A**) is to be replaced by a section of the replacement panel.

Note that, in "CUT" and "PART" replacement, the location of the cutting must be selected carefully, considering both the construction of the vehicle and the level of strength following repairs.

Shows the part names keyed by symbols in the illustration.

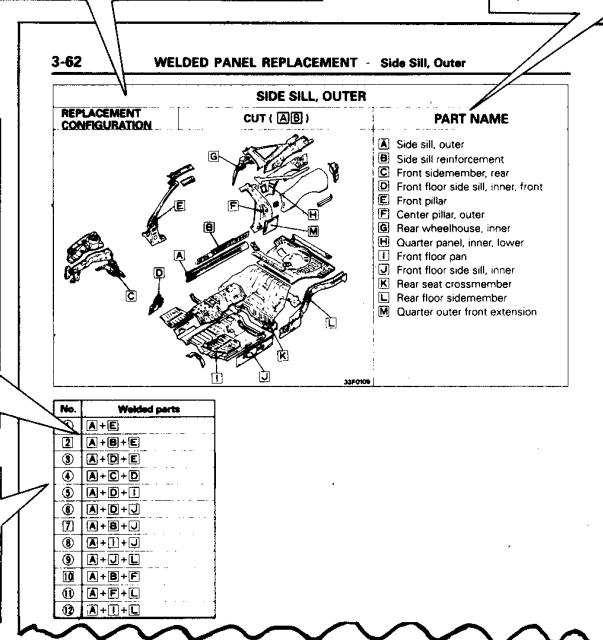
The welded components are indicated by using the designations given in the illustration.

For example, "**A** + **B**" indicates that component **A** and component **B** shown in the illustration are welded together.

★ This mark is used to indicate the weld of a part which is especially important to the vehicle body from a structural viewpoint: therefore, the weld must be made securely.

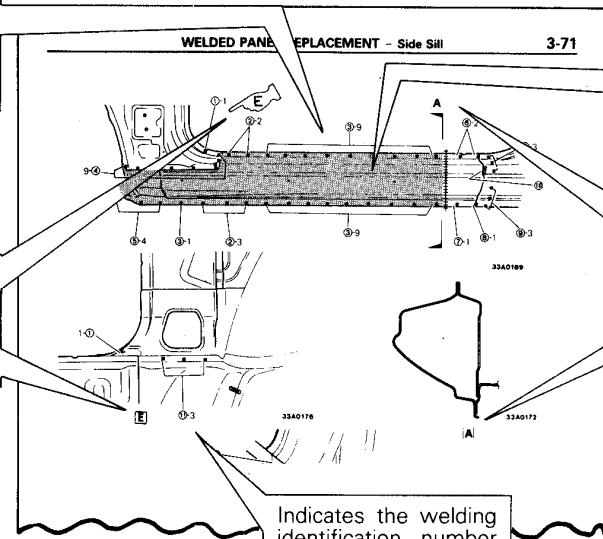
The weld point classification numbers are indicated:

- indicates one panel to be replaced.
- indicates two (or more) panels to be replaced.



3

For weld points (flange parts, etc.) on the same surface, only weld points at both ends are indicated; weld points between those end weld points are omitted.



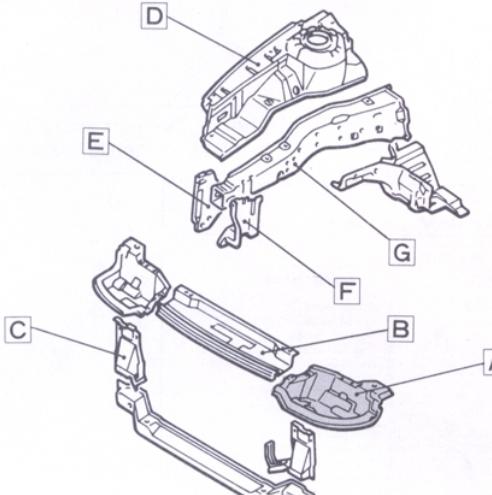
Parts indicated by a light black colour are panels to be replaced.

Indicates a view as seen from the direction of the finger.

"→" indicates that the view as seen from the direction of "→" is shown in figure [E].

Indicates cross section and its position. If arrow (→) is directed from rear to front in drawing, cross section viewed from front side of drawing is shown at [A].

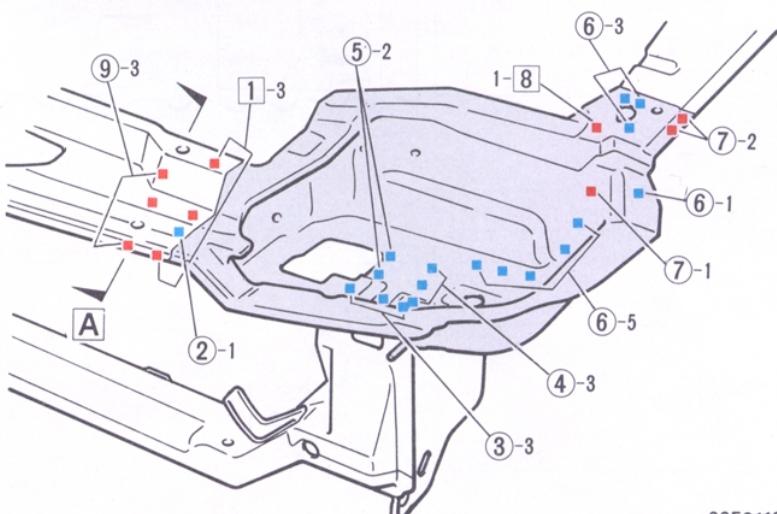
## HEADLAMP HOUSING

REPLACEMENT CONFIGURATION	ASSEMBLY ( A )	PART NAME
		<p> <b>A</b> Headlamp housing  <b>B</b> Front end upper bar  <b>C</b> Front end crossmember brace  <b>D</b> Front wheelhouse, inner  <b>E</b> Front end gusset, outer  <b>F</b> Front end gusset, inner  <b>G</b> Front sidemember     </p>

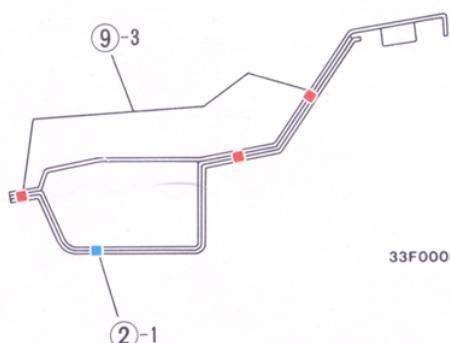
31F0031

No.	Welded parts
①	A + B
②	A + B
③	A + C
④	A + E
⑤	A + G
⑥	A + D
⑦	A + D
⑧	A + D
⑨	A + B

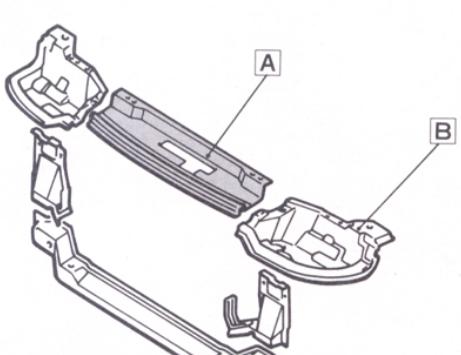
## REPAIR WELDS



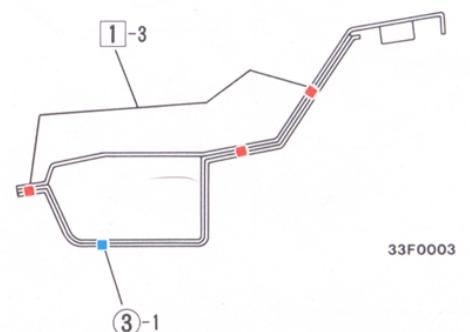
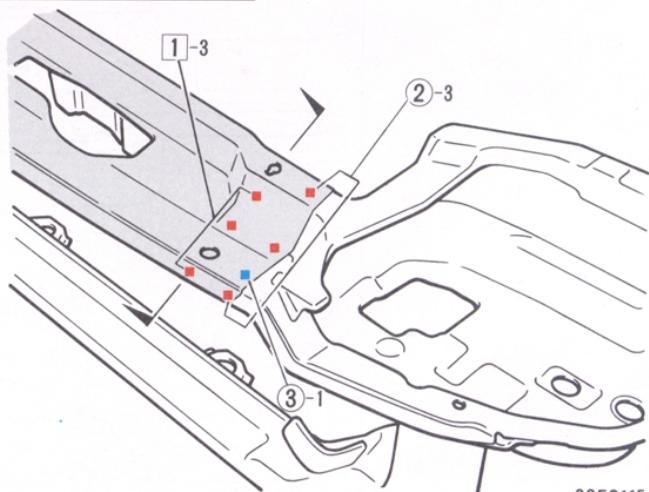
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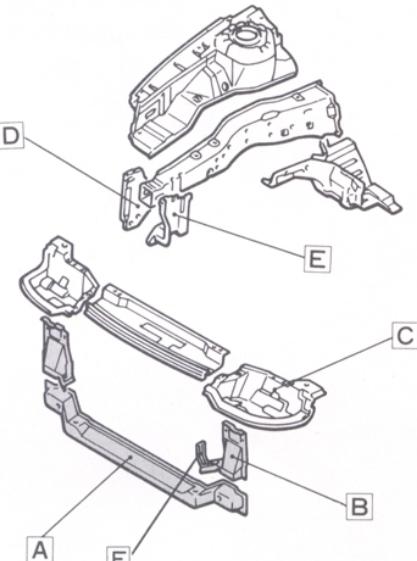
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FRONT END UPPER BAR		
REPLACEMENT CONFIGURATION	ASSEMBLY ( A )	PART NAME
		<b>A</b> Front end upper bar <b>B</b> Headlamp housing

## REPAIR WELDS

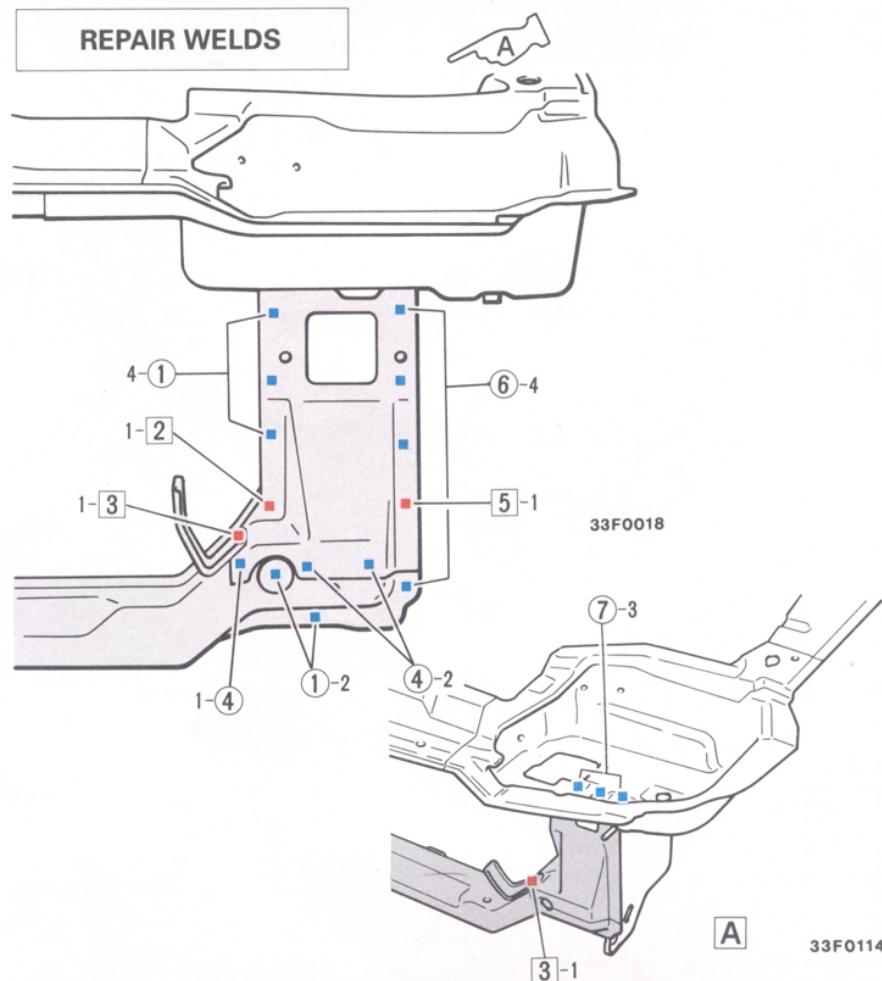


## FRONT END CROSMEMBER

REPLACEMENT CONFIGURATION	ASSEMBLY (A B F)	PART NAME
		<p><b>A</b> Front end crossmember  <b>B</b> Front end crossmember brace  <b>C</b> Headlamp housing  <b>D</b> Front end gusset, outer  <b>E</b> Front end gusset, inner  <b>F</b> Air guide bracket</p>

31F0031

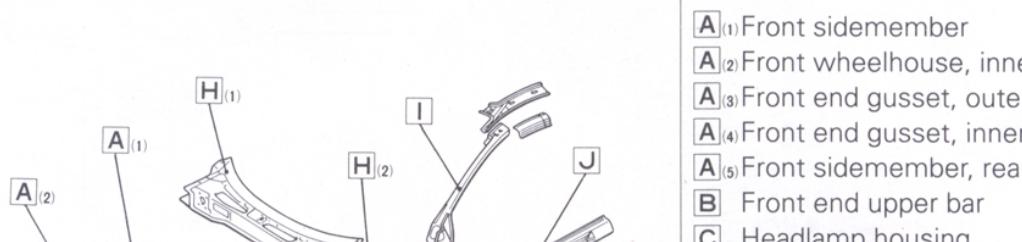
No.	Welded parts
①	B + E
②	A + B + E
③	A + B + F
④	A + B
⑤	A + B + D
⑥	B + D
⑦	B + C



A

33F0114

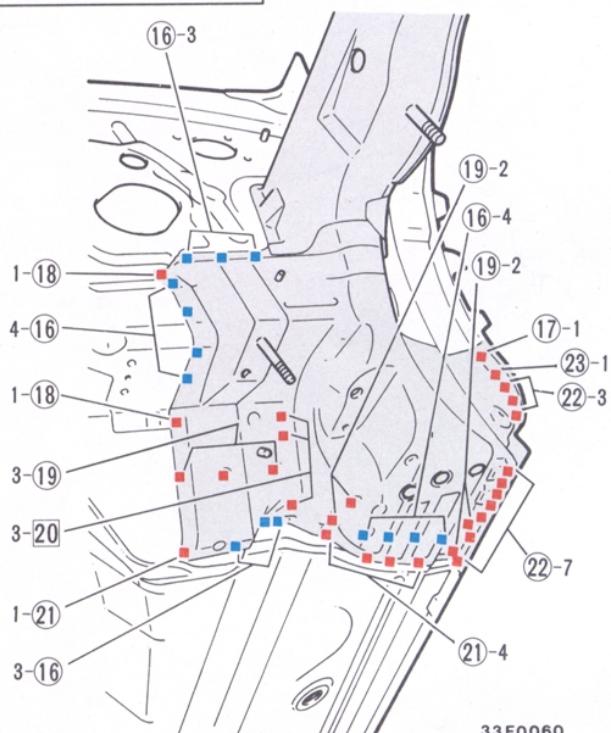
## FENDER SHIELD (ASSEMBLY)

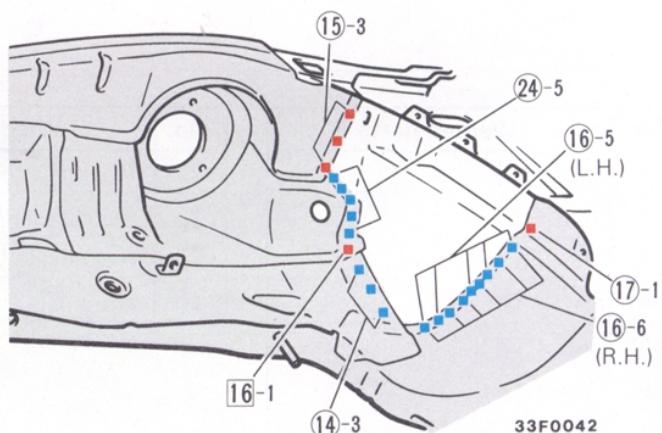
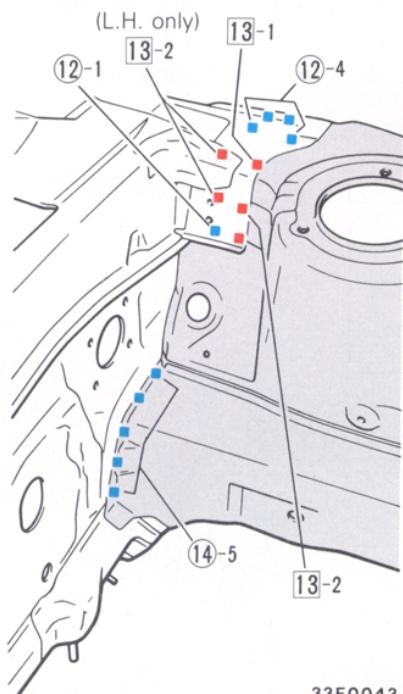
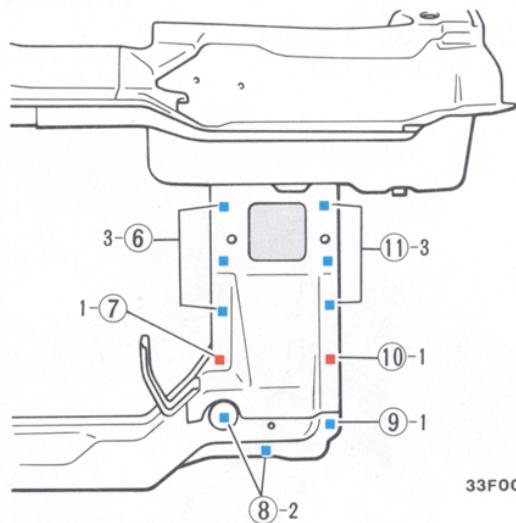
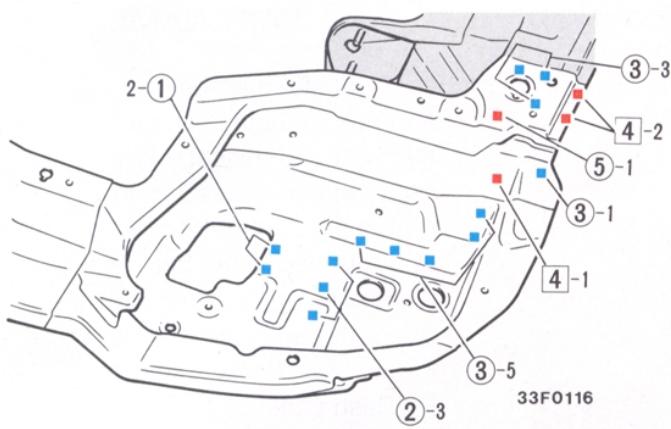
REPLACEMENT CONFIGURATION	ASSEMBLY (A <sub>(1)</sub> —A <sub>(5)</sub> )	PART NAME
		<p>A<sub>(1)</sub>Front sidemember  A<sub>(2)</sub>Front wheelhouse, inner  A<sub>(3)</sub>Front end gusset, outer  A<sub>(4)</sub>Front end gusset, inner  A<sub>(5)</sub>Front sidemember, rear  B Front end upper bar  C Headlamp housing  D Front end crossmember brace  E Front end crossmember  F Dash panel  G Front floor side sill, inner, front  H<sub>(1)</sub>Cowl top panel  H<sub>(2)</sub>Front upper frame extension  I Front pillar  J Front floor side sill, outer  K Front floor pan  L Front floor upper plate</p>

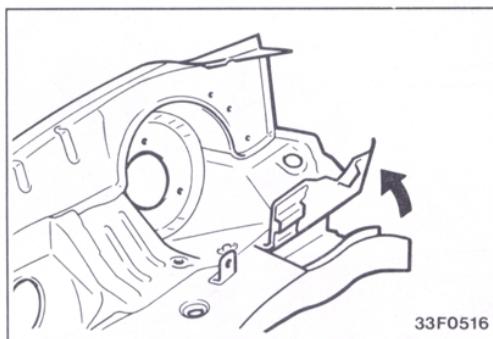
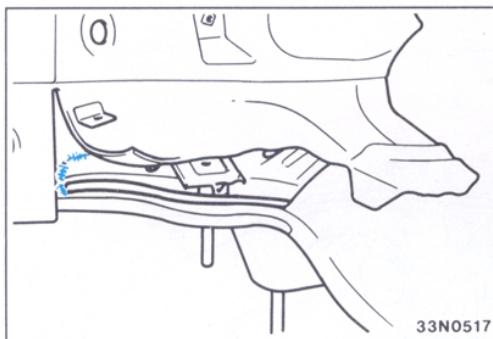
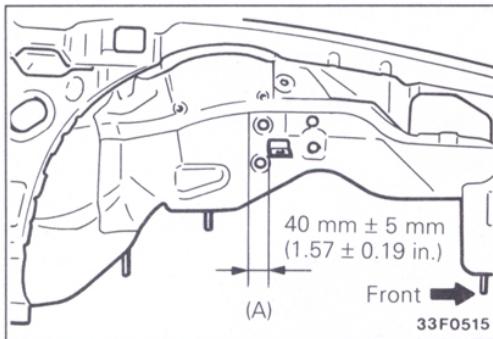
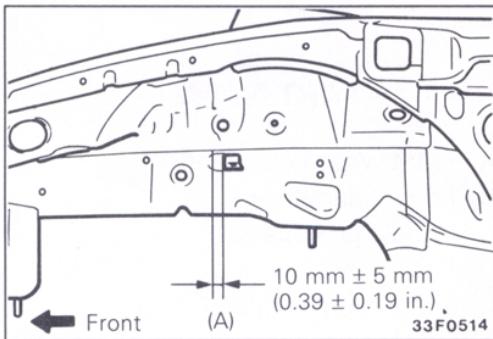
No.	Welded parts
①	$A_{(1)} + C$
②	$A_{(3)} + C$
③	$A_{(2)} + C$
④	$A_{(2)} + C$
⑤	$A_{(2)} + C$
⑥	$A_{(4)} + D$
⑦	$A_{(4)} + D + E$
⑧	$A_{(4)} + E$
⑨	$A_{(3)} + E$
⑩	$A_{(3)} + D + E$
⑪	$A_{(3)} + D$
⑫	$A_{(2)} + H_{(2)}$
⑬	$A_{(2)} + H_{(2)}$
⑭	$A_{(1)} + F$
⑮	$A_{(2)} + F + H_{(1)}$
⑯	$A_{(1)} + A_{(2)} + F$
⑰	$A_{(5)} + F$
⑱	$A_{(5)} + F$
⑲	$A_{(5)} + F + L$
⑳	$A_{(5)} + F$

No.	Welded parts
21	A <sub>(5)</sub> + F + K
22	A <sub>(5)</sub> + G + J
23	A <sub>(5)</sub> + G + I
24	A <sub>(2)</sub> + F

## REPAIR WELDS







## NOTES WITH REGARD TO REPAIR WORK

If damage does not extend to the front sidemember (rear), to shorten the repair time, part replacement that the front sidemember (rear) is remained to the body side is recommended.

### REMOVAL

(1) (Left side): Cut the front sidemember (outer) and front sidemember reinforcement (outer) at the illustrated location.  $10 \text{ mm} \pm 5 \text{ mm}$  ( $0.39 \pm 0.19 \text{ in.}$ ) forward from the brake hose bracket end (A).

(Right side): Cut only the front sidemember (outer).  $40 \text{ mm} \pm 5 \text{ mm}$  ( $1.57 \pm 0.19 \text{ in.}$ ) backward from the brake hose bracket end (A).

(2) In order to cut and separate the MIG arc welds between the front sidemember (inner) and front sidemember reinforcement (rear), bend the cut front sidemember (outer) upward as shown in the illustration.

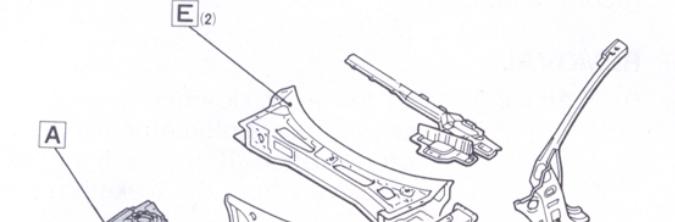
### INSTALLATION

Install the new front sidemember (outer) onto the body with illustrated portion bent upward.

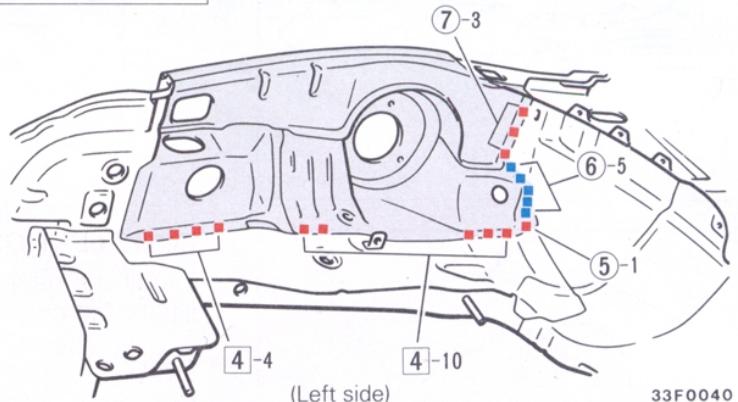
#### NOTE

Cut the left and right front sidemembers (outer) exactly at the same location as done in the removal step.

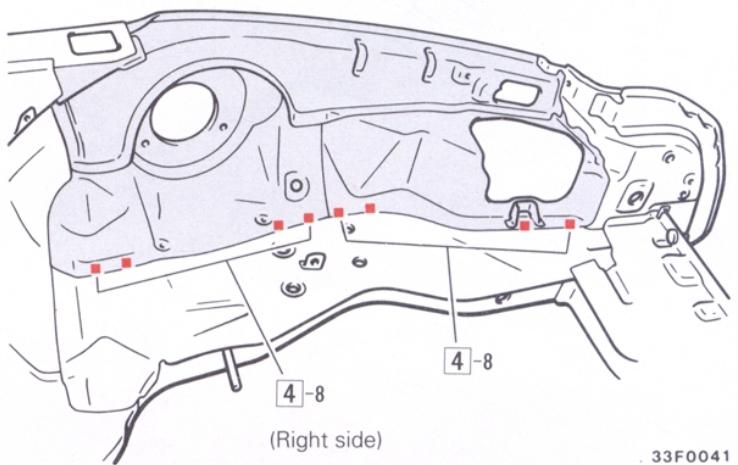
## FENDER SHIELD (PART)

REPLACEMENT CONFIGURATION	PART ( A )	PART NAME
		<p> <b>A</b> Front wheelhouse, inner  <b>B</b> Front sidemember  <b>C</b> Headlamp housing  <b>D</b> Dash panel  <b>E</b><sub>(1)</sub>Front upper frame extension  <b>E</b><sub>(2)</sub>Cowl top panel  <b>F</b> Front pillar     </p>

## REPAIR WELDS

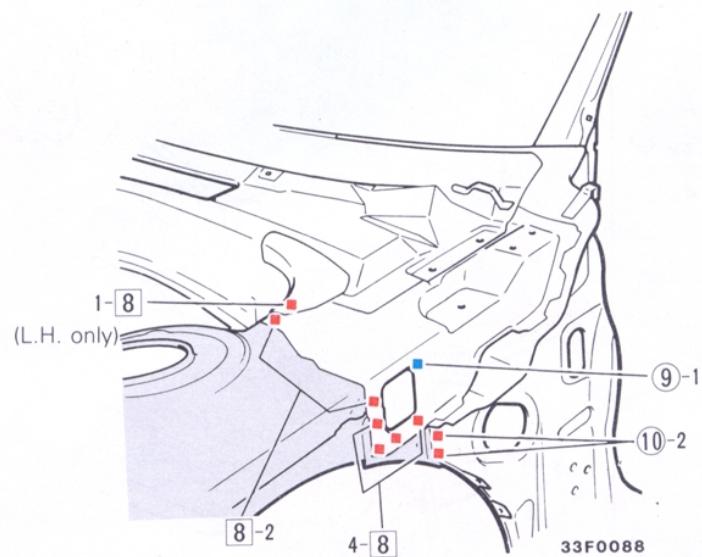
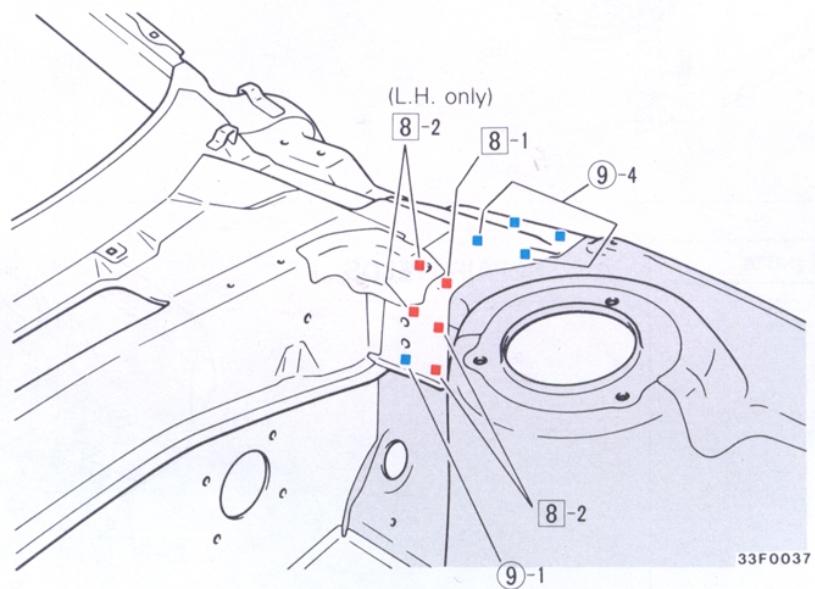
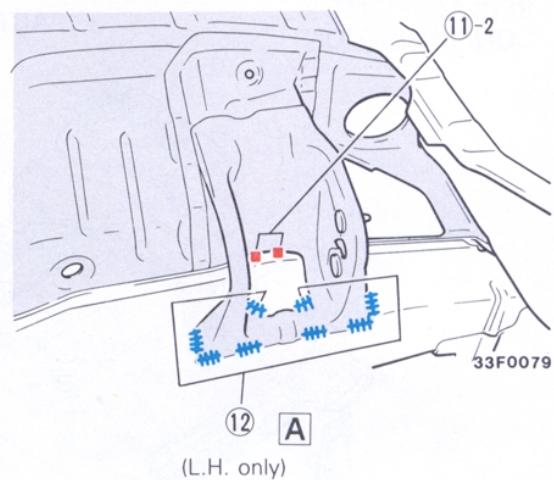
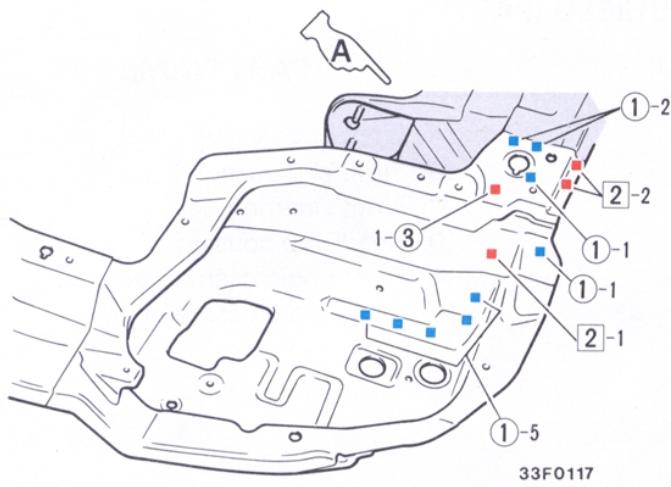


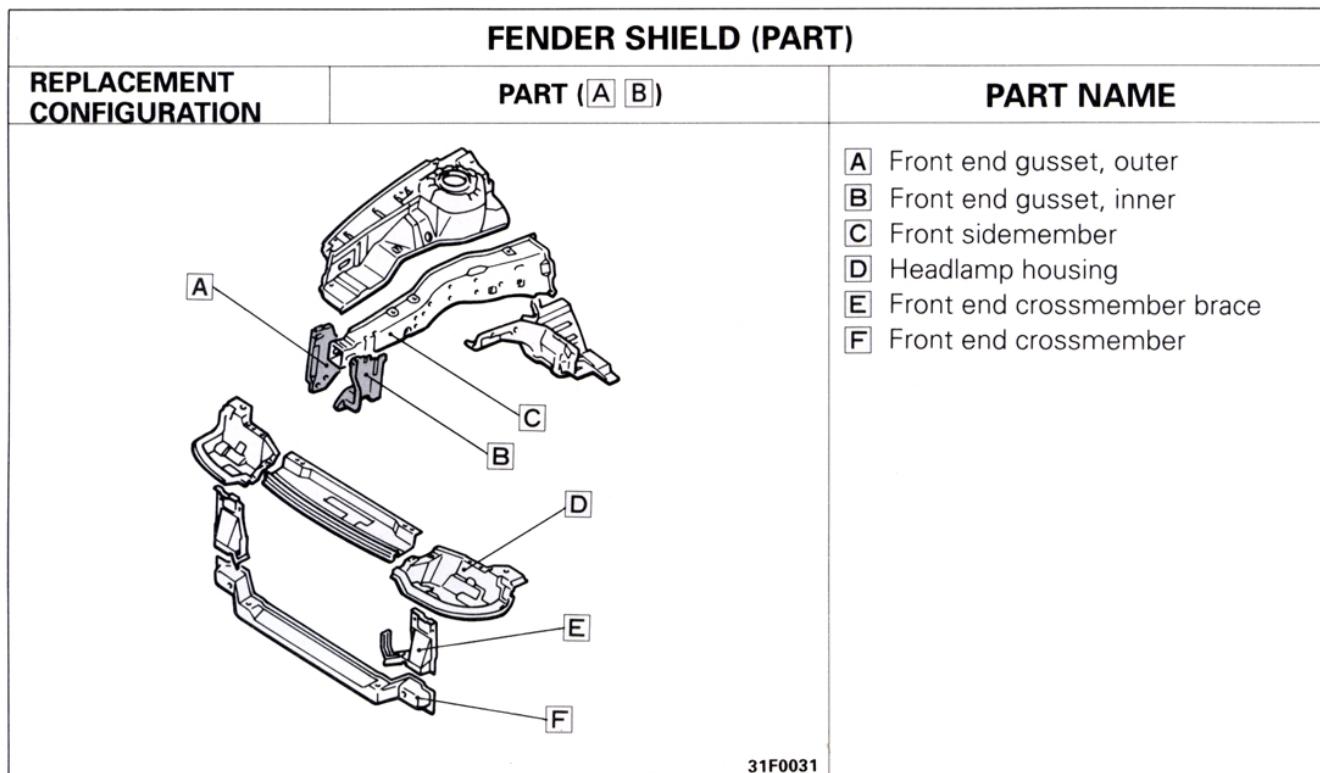
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(Right side)

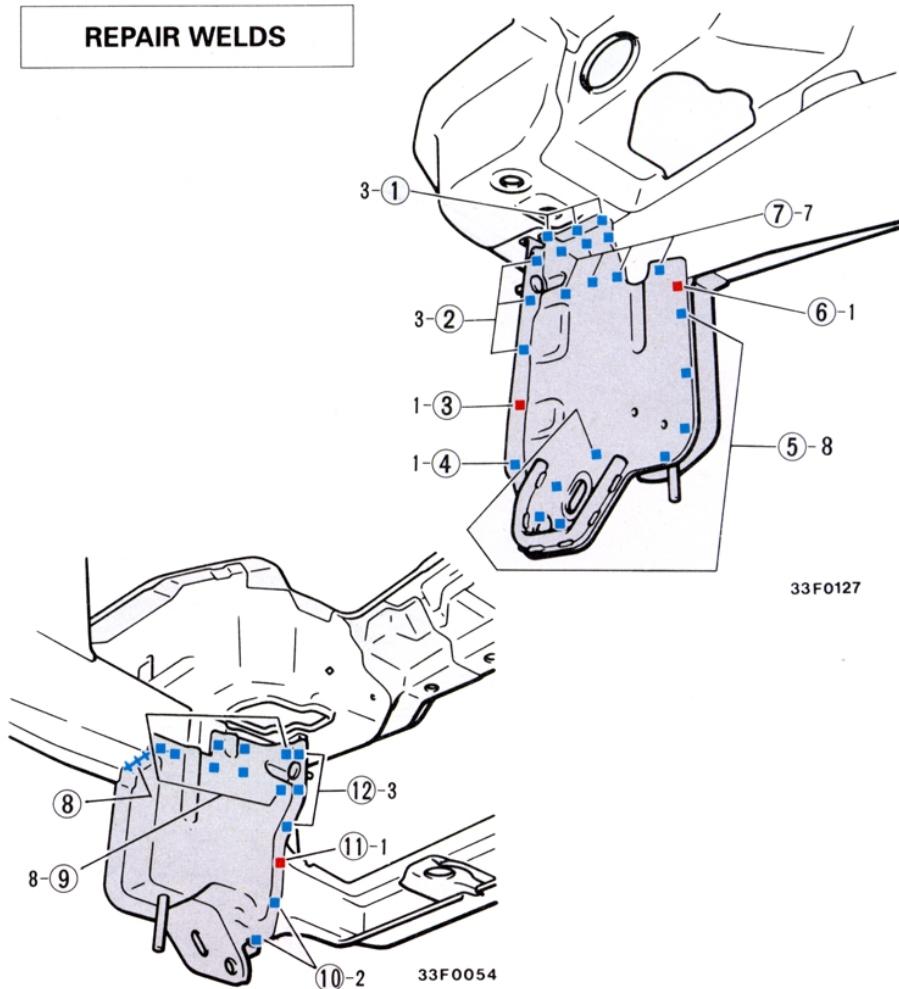
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No.	Welded parts
①	A + D
②	A + E
③	A + E + F
④	A + F
⑤	A + B
⑥	A + C
⑦	A + C
⑧	B + C
⑨	B + C
⑩	B + F
⑪	B + E + F
⑫	B + E

**REPAIR WELDS**



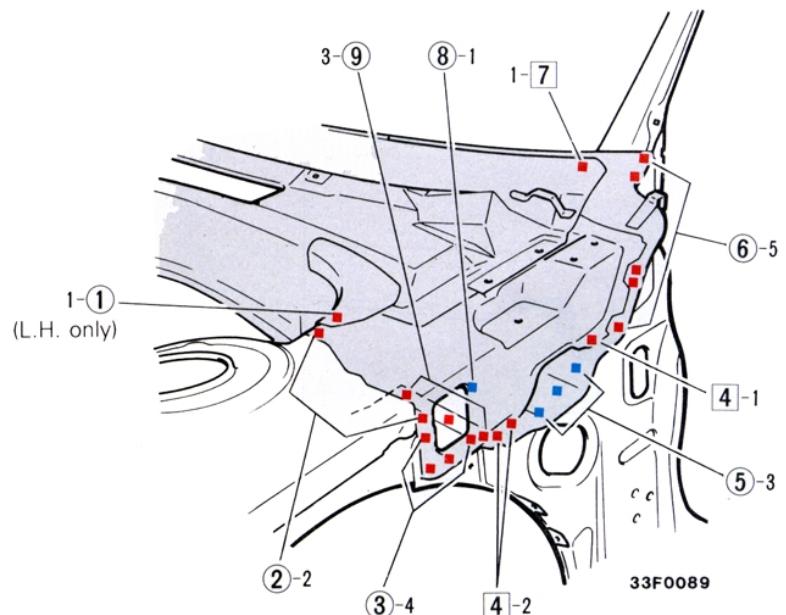
## COWL TOP PANEL

REPLACEMENT CONFIGURATION	ASSEMBLY ( $A_{(1)}$ , $A_{(2)}$ , $A_{(3)}$ )	PART NAME
		$A_{(1)}$ Cowl top panel $A_{(2)}$ Front deck crossmember $A_{(3)}$ Front upper frame extension $B$ Front pillar $C$ Front wheelhouse, inner $D$ Dash panel

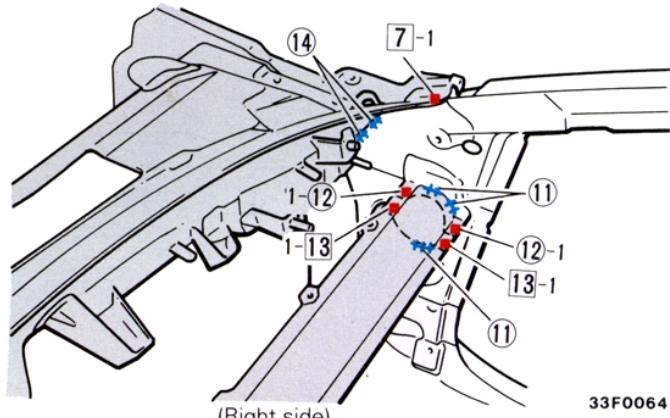
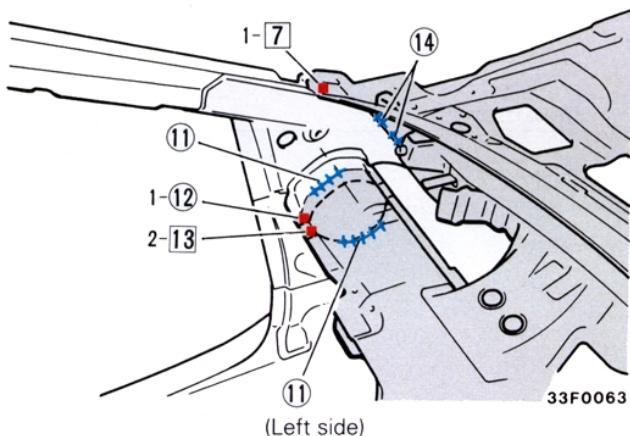
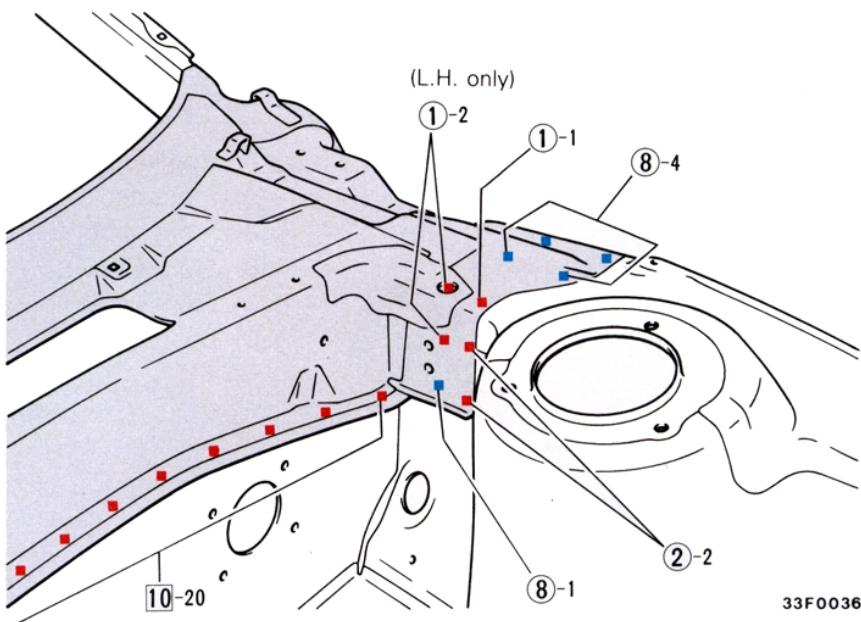
31F0031

No.	Welded parts
①	$A_{(3)} + C$
②	$A_{(3)} + C$
③	$A_{(3)} + C$
④	$A_{(1)} + A_{(3)} + B$
⑤	$A_{(1)} + B$
⑥	$A_{(1)} + B$
⑦	$A_{(1)} + B$
⑧	$A_{(3)} + C$
⑨	$A_{(1)} + C + D$
⑩	$A_{(1)} + D$
⑪	$A_{(2)} + B$
⑫	$A_{(2)} + B$
⑬	$A_{(2)} + B$
⑭	$A_{(1)} + B$

## REPAIR WELDS

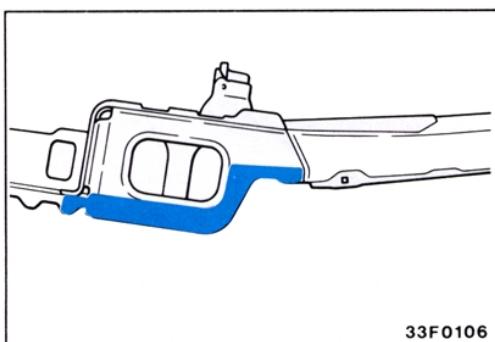


33F0089

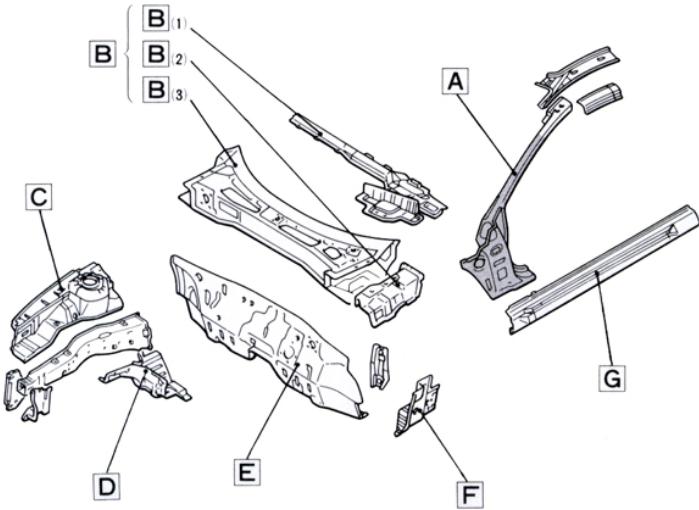


### INSTALLATION

- 1) Apply a coating of body sealant to the front pillar at the body side where shown in the illustration.



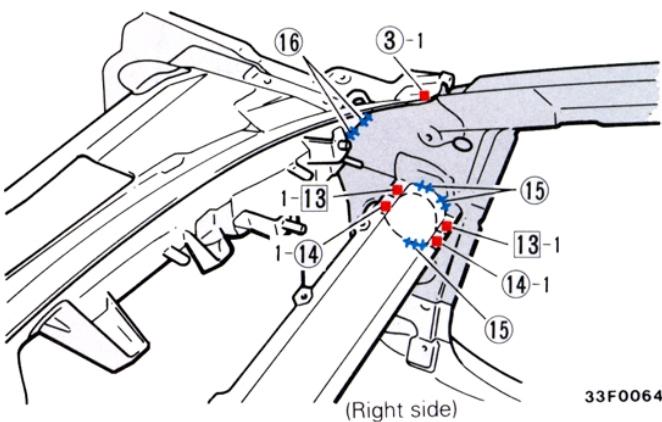
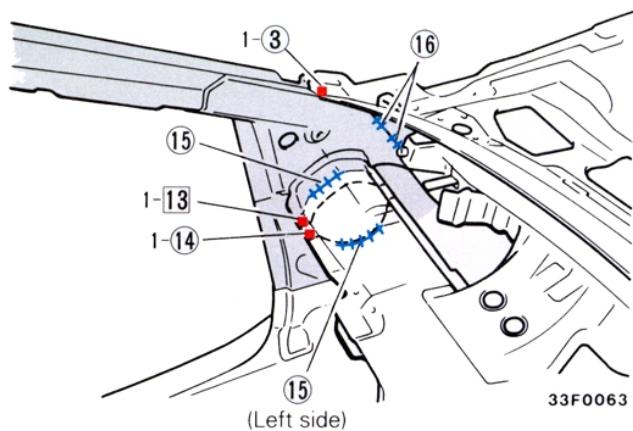
## FRONT PILLAR

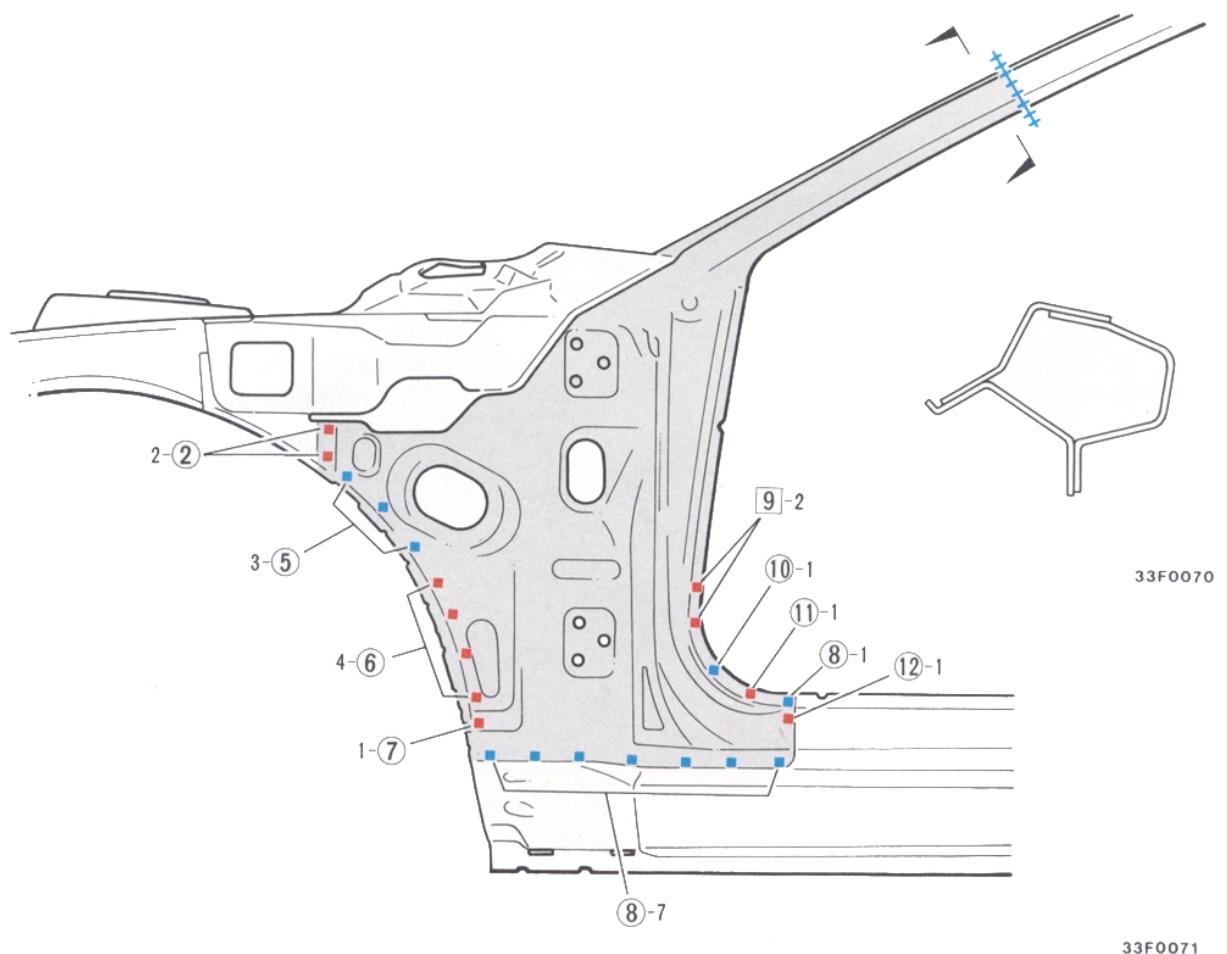
REPLACEMENT CONFIGURATION	CUT (A)	PART NAME
		<p><b>A</b> Front pillar  <b>B</b><sub>1</sub> Front deck crossmember  <b>B</b><sub>2</sub> Front upper frame extension  <b>B</b><sub>3</sub> Cowl top panel  <b>C</b> Front wheelhouse, inner  <b>D</b> Front sidemember, rear  <b>E</b> Dash panel  <b>F</b> Front floor side sill, inner, front  <b>G</b> Front floor side sill, outer</p>

31F0031

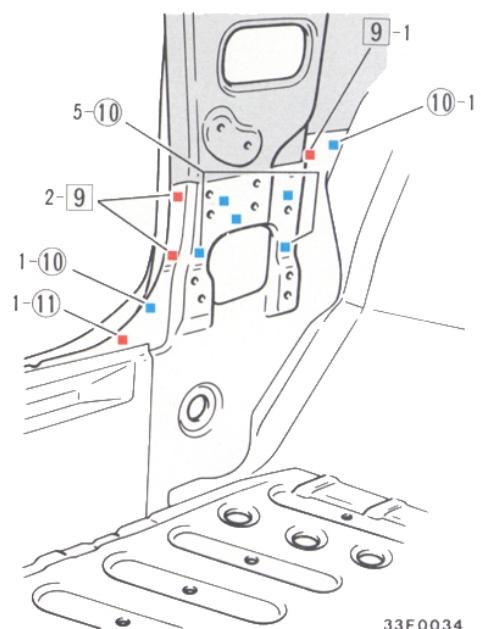
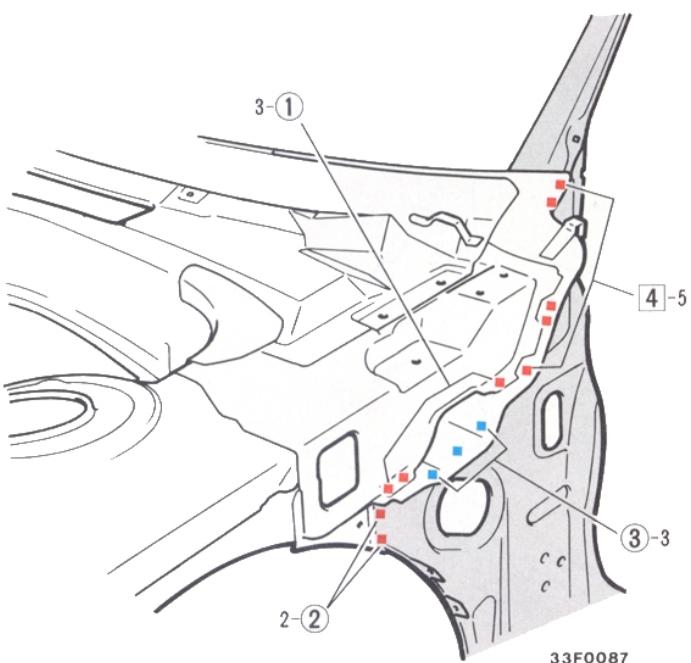
No.	Welded parts
①	<b>A</b> + <b>B</b> <sub>(2)</sub> + <b>B</b> <sub>(3)</sub>
②	<b>A</b> + <b>C</b> + <b>E</b>
③	<b>A</b> + <b>B</b> <sub>(3)</sub>
④	<b>A</b> + <b>B</b> <sub>(3)</sub>
⑤	<b>A</b> + <b>E</b>
⑥	<b>A</b> + <b>E</b> + <b>F</b>
⑦	<b>A</b> + <b>D</b> + <b>F</b>
⑧	<b>A</b> + <b>G</b>
⑨	<b>A</b> + <b>F</b>
⑩	<b>A</b> + <b>F</b>
⑪	<b>A</b> + <b>F</b> + <b>G</b>
⑫	<b>A</b> + <b>G</b>
⑬	<b>A</b> + <b>B</b> <sub>(1)</sub>
⑭	<b>A</b> + <b>B</b> <sub>(1)</sub>
⑮	<b>A</b> + <b>B</b> <sub>(1)</sub>
⑯	<b>A</b> + <b>B</b> <sub>(3)</sub>

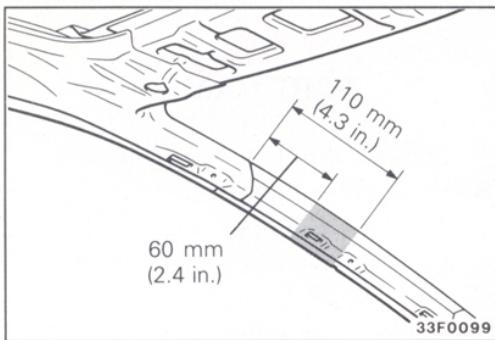
## REPAIR WELDS





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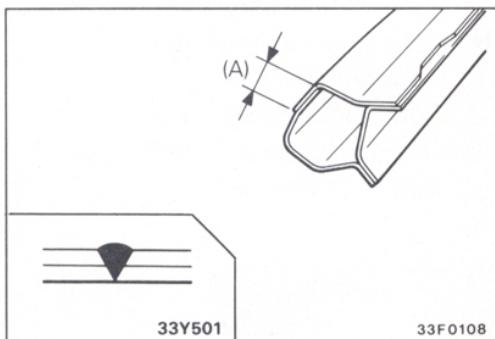


## NOTES WITH REGARD TO REPAIR WORK REMOVAL

- Cut the front pillar at a position 60 – 110 mm (2.4 – 4.3 in.) down from the end of the panel of the side roof rail (inner).

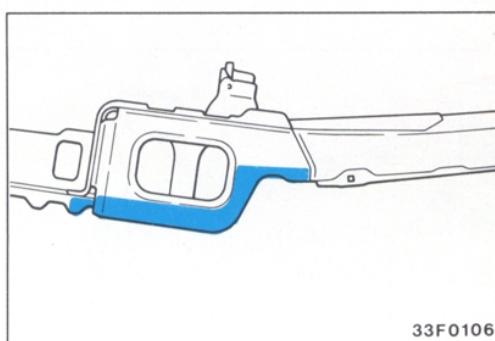
### Caution

**Because the pillar will be butt-welding, make the cut at a right angle to the pillar.**

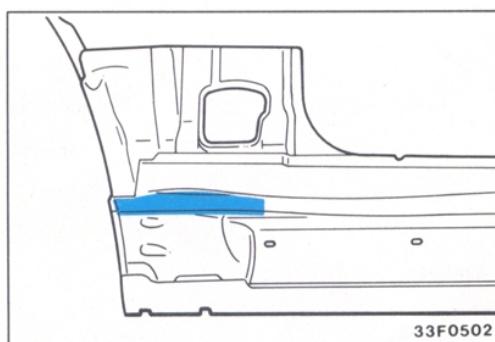


## INSTALLATION

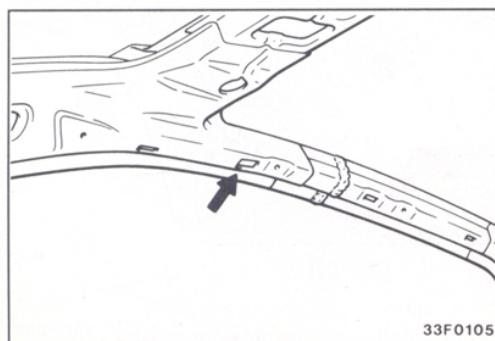
- When making the butt weld at (A) in the illustration, two panels are welded at the same time, and for that reason the panel overlapping part should be abraded to form a "V" shape in order to facilitate the "melt" during welding.



- Apply a coating of body sealant to both the new part and the body side where shown in the illustration.



- Use the front pillar trim mounting hole to spray an ample amount of corrosion-prevention agent onto the inside of the butt-welded joints.



## SIDE SILL, OUTER

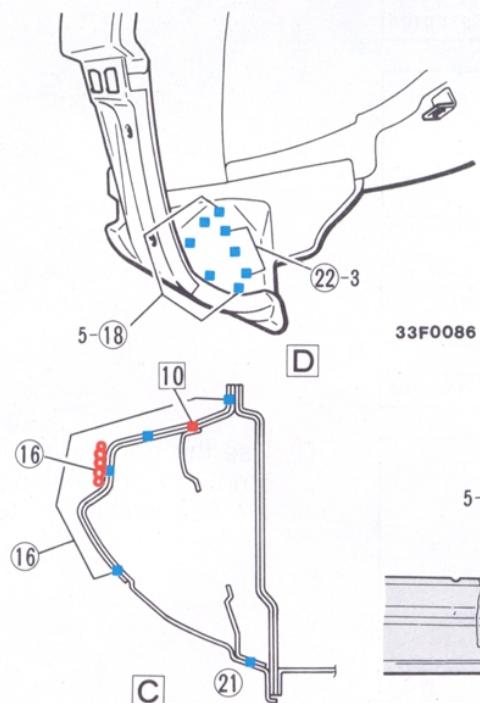
REPLACEMENT CONFIGURATION	CUT ( A B )	PART NAME
		<p>A Side sill, outer      B Side sill reinforcement      C Front sidemember, rear      D Front floor side sill, inner, front      E Front pillar      F Center pillar, outer      G Rear wheelhouse, inner      H Quarter panel, inner, lower      I Front floor pan      J Front floor side sill, inner      K Rear seat crossmember      L Rear floor sidemember</p>

33F0111

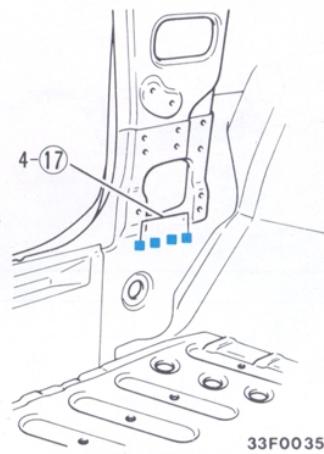
No.	Welded parts
①	A + E
②	A + B + E
③	A + D + E
④	A + C + D
⑤	A + D + I
⑥	A + D + J
⑦	A + B + J
⑧	A + I + J
⑨	A + J + L
⑩	A + B + F
⑪	A + F + L
⑫	A + I + L
⑬	A + K + L
⑭	A + L
⑮	A + L
⑯	A + F
⑰	A + D
⑱	A + G
⑲	A + G + H
⑳	A + H + L
㉑	A + B

No.	Welded parts
㉒	B + G

## REPAIR WELDS

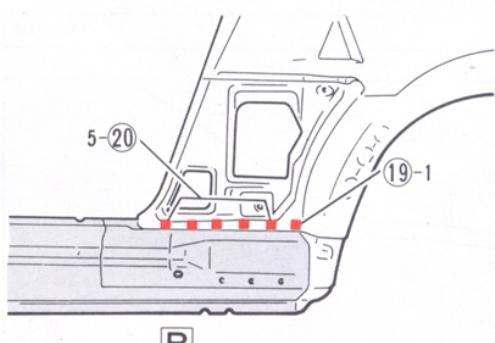


33F0086



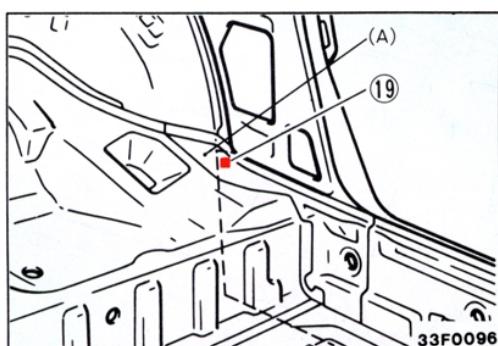
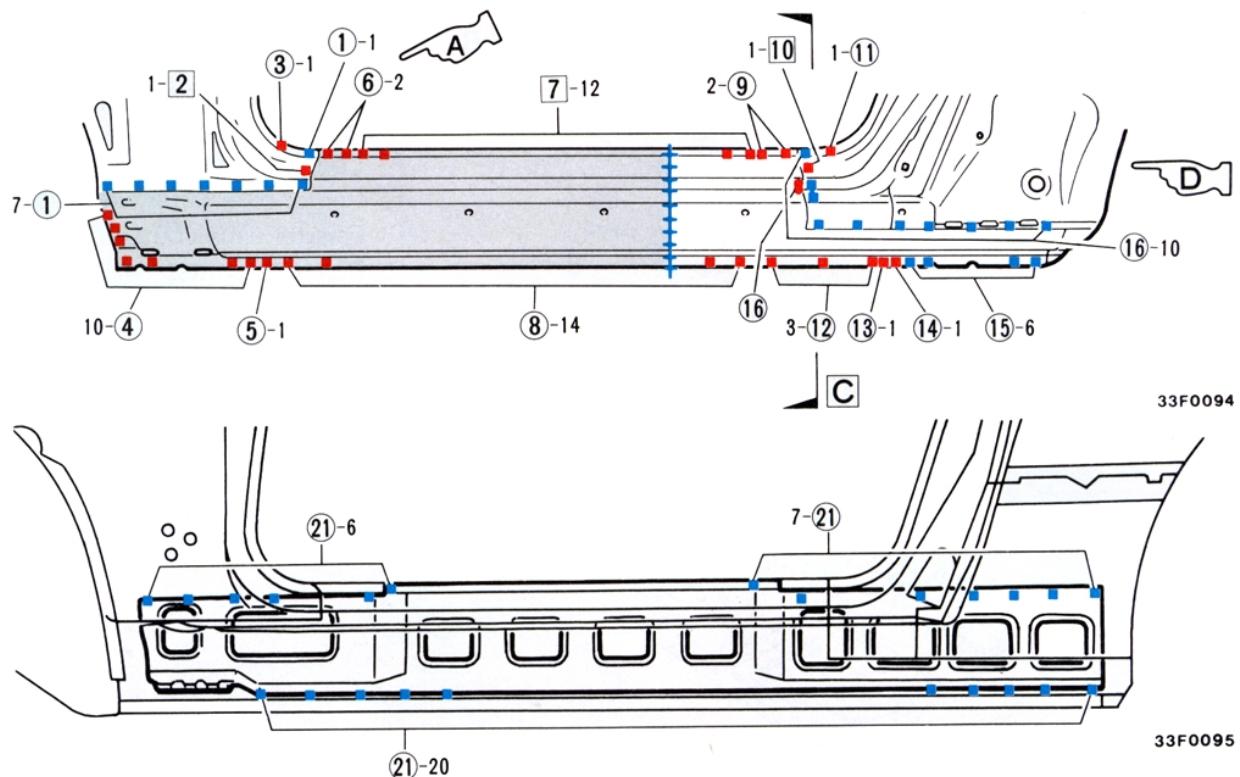
A

33F0086



B

(Illustration shows the center pillar outer panel in the removed condition) 33F0068

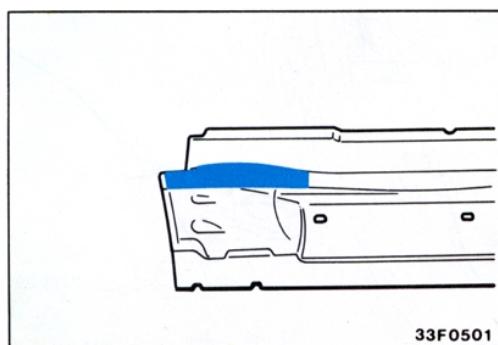


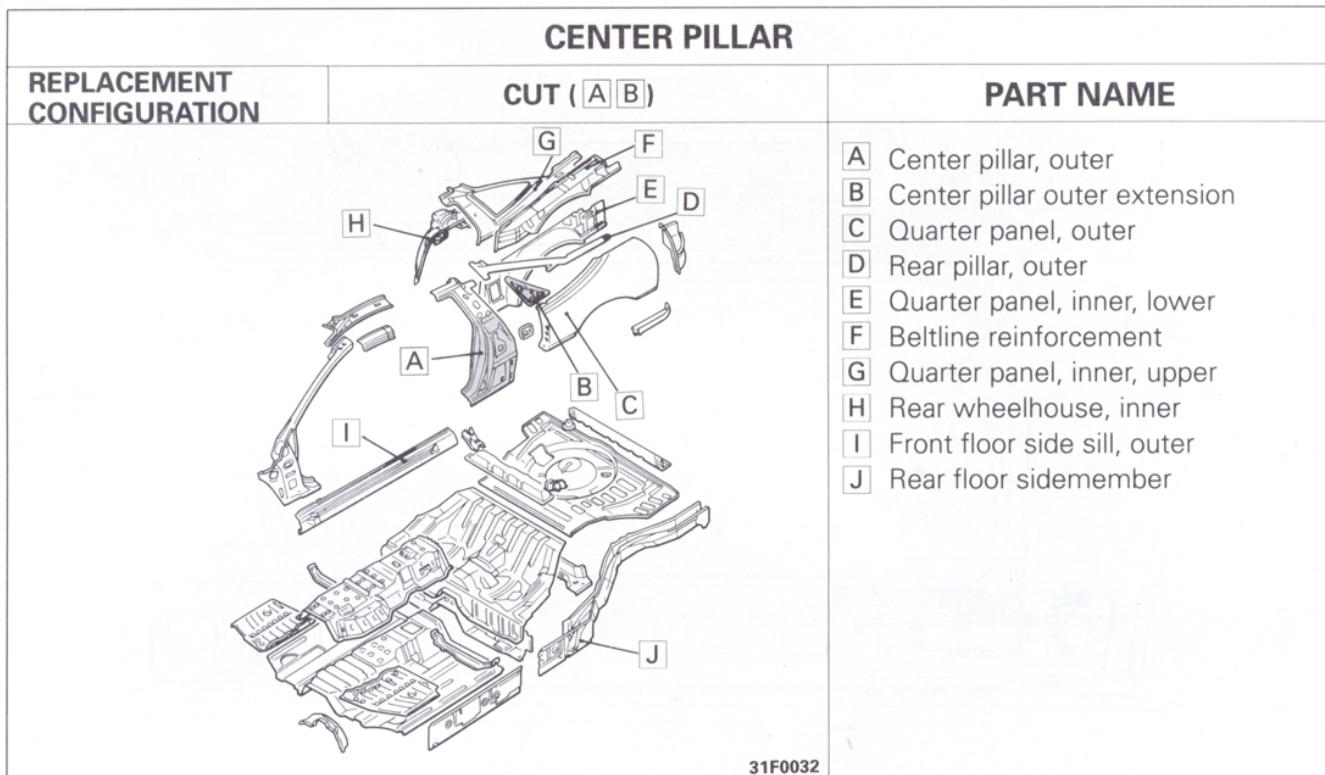
## NOTES WITH REGARD TO REPAIR WORK REMOVAL

- Because the welded point 19 is located under the panel (A) and cannot detect it directly, remove the center pillar at first and cut the spot weld from vehicle outside.

## INSTALLATION

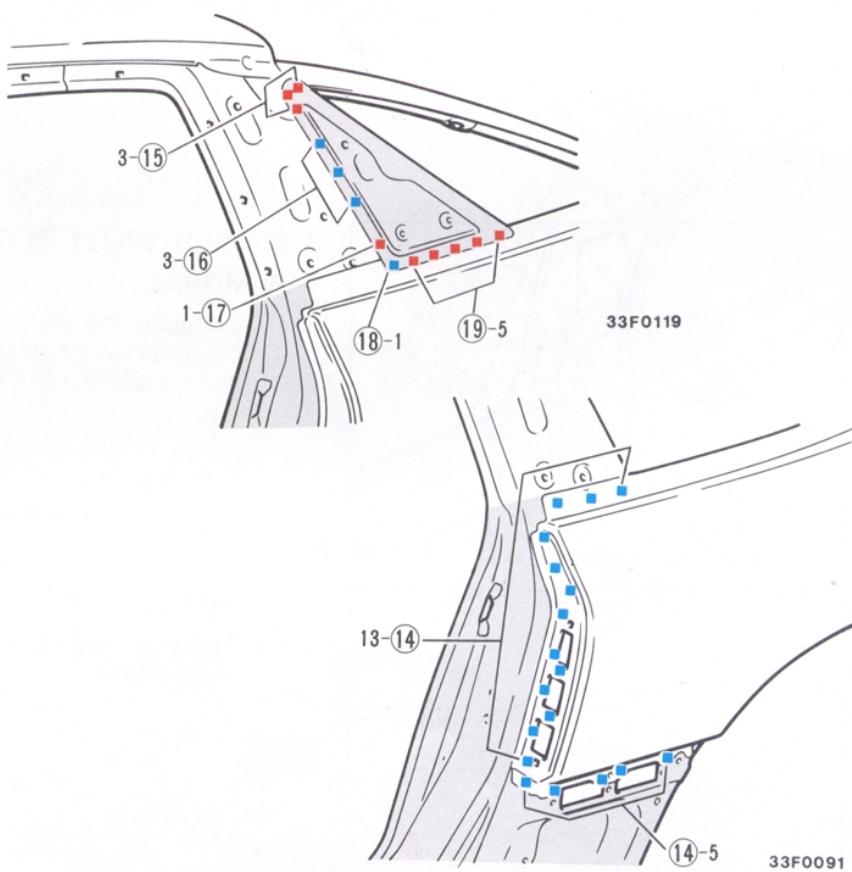
- Apply a coating of body sealant where shown in the illustration.

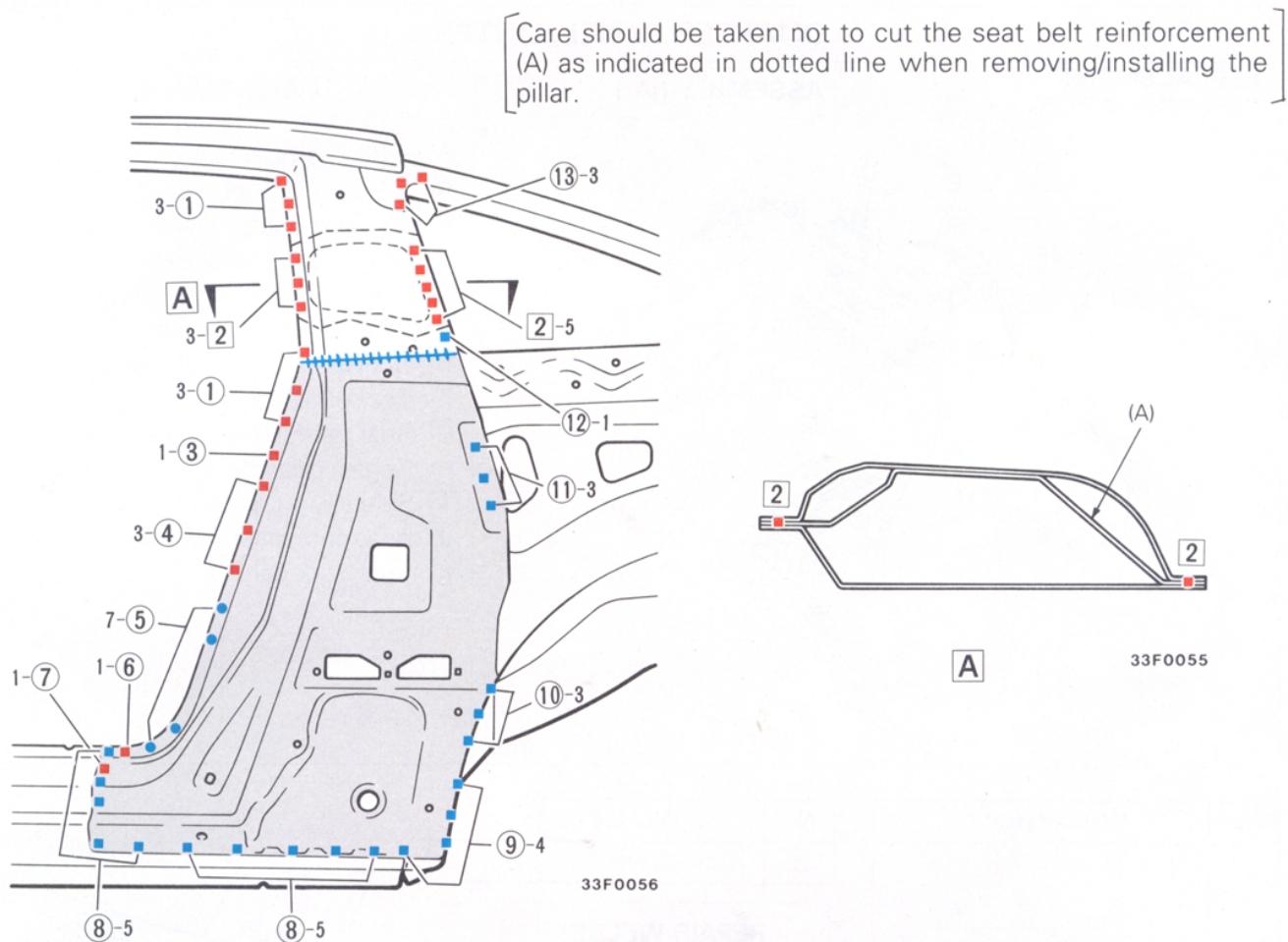




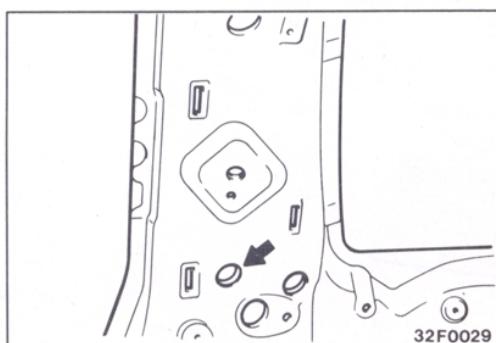
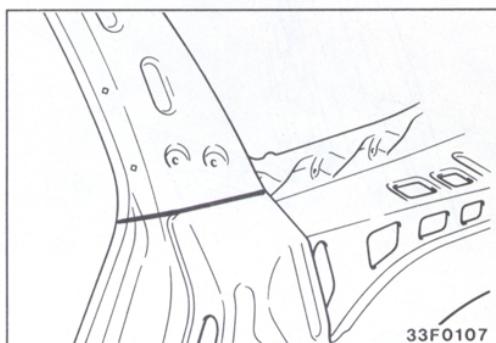
No.	Welded parts
①	A + G
②	A + G
③	A + F + G
④	A + E + F
⑤	A + E
⑥	A + I + J
⑦	A + I
⑧	A + I
⑨	A + H
⑩	A + E
⑪	A + F
⑫	A + G
⑬	A + D + G
⑭	A + C
⑮	A + B + D
⑯	A + B
⑰	A + B + G
⑱	B + C
⑲	B + C + G

**REPAIR WELDS**





(Illustration shows the quarter outer panel in the removed condition.)



## NOTES WITH REGARD TO REPAIR WORK REMOVAL

- Cut only the center pillar outer panel at the illustrated location, taking care not to cut the garnish mounting hole.

## INSTALLATION

- Apply a liberal amount of corrosion-prevention agent (using the hole indicated in the illustration) to the butt-weld locations.

## QUARTER PANEL, OUTER

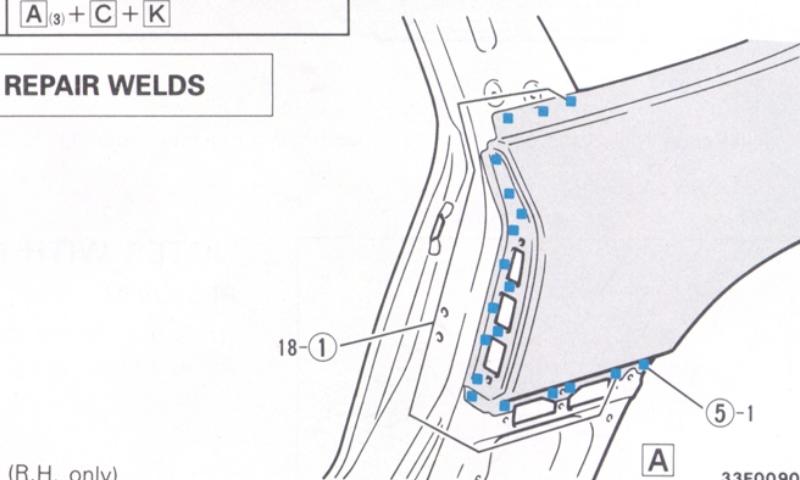
REPLACEMENT CONFIGURATION	ASSEMBLY (A)	PART NAME
		<p>A (1) Rear lamp housing  A (2) Quarter panel, outer  A (3) Quarter outer lower extension  B Center pillar outer extension  C Quarter panel, inner, lower  D Beltline reinforcement  E Quarter panel, inner, upper  F Rear pillar, outer  G Rear wheelhouse, inner  H Center pillar, outer  I Side sill, outer  J Rear end panel  K Rear floor pan</p>

31F0032

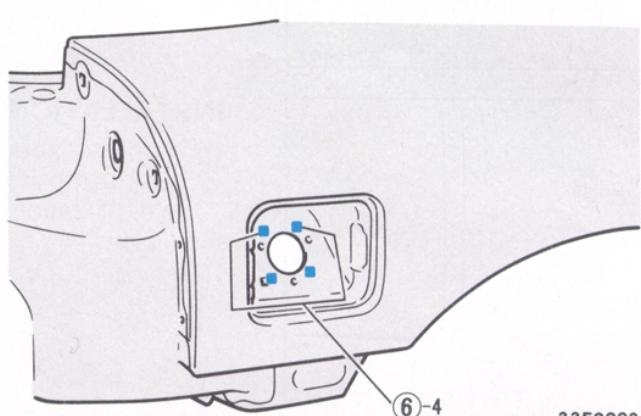
No.	Welded parts
①	A <sub>(2)</sub> + H
②	A <sub>(2)</sub> + E
③	A <sub>(2)</sub> + E + F
④	A <sub>(2)</sub> + F
⑤	A <sub>(2)</sub> + C
⑥	A <sub>(3)</sub> + C
⑦	A <sub>(2)</sub> + C
⑧	A <sub>(1)</sub> + A <sub>(2)</sub>
⑨	A <sub>(1)</sub> + A <sub>(2)</sub> + A <sub>(3)</sub>
⑩	A <sub>(2)</sub> + B
⑪	A <sub>(2)</sub> + B + E
⑫	A <sub>(1)</sub> + F
⑬	A <sub>(1)</sub> + F + J
⑭	A <sub>(1)</sub> + C + D
⑮	A <sub>(1)</sub> + J
⑯	A <sub>(1)</sub> + K
⑰	A <sub>(1)</sub> + C + K
⑱	A <sub>(1)</sub> + C
⑲	A <sub>(1)</sub> + A <sub>(3)</sub>
⑳	A <sub>(2)</sub> + A <sub>(3)</sub>
㉑	A <sub>(2)</sub> + A <sub>(3)</sub> + C

No.	Welded parts
㉒	A <sub>(3)</sub> + C + K

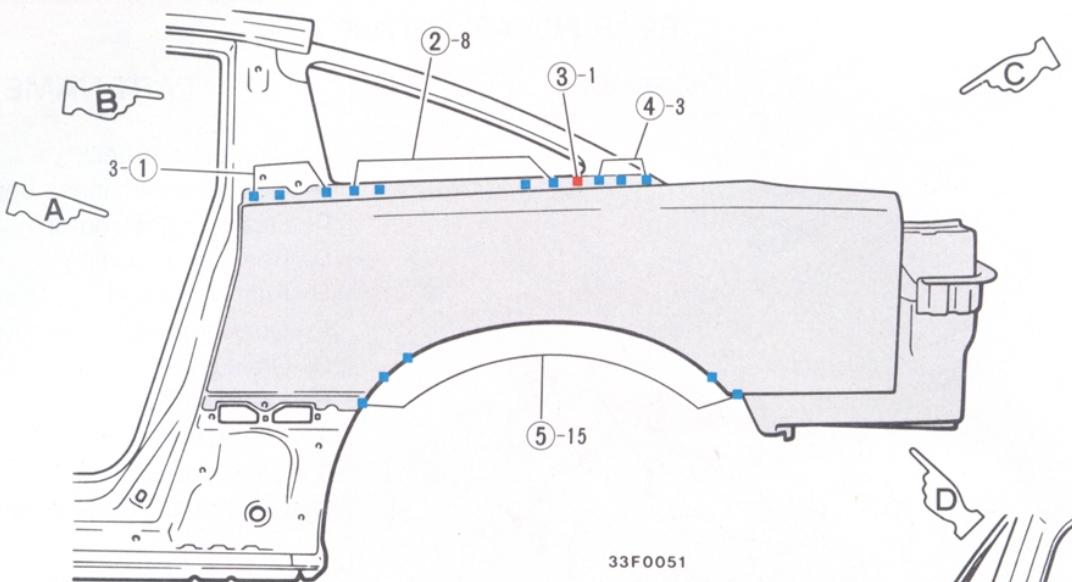
## REPAIR WELDS



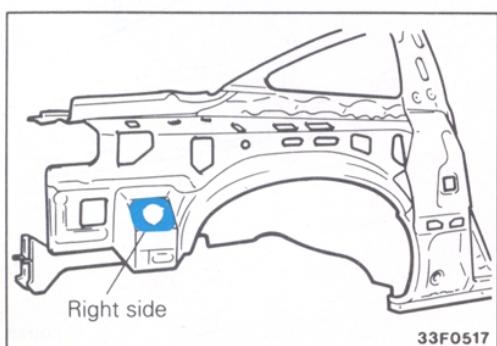
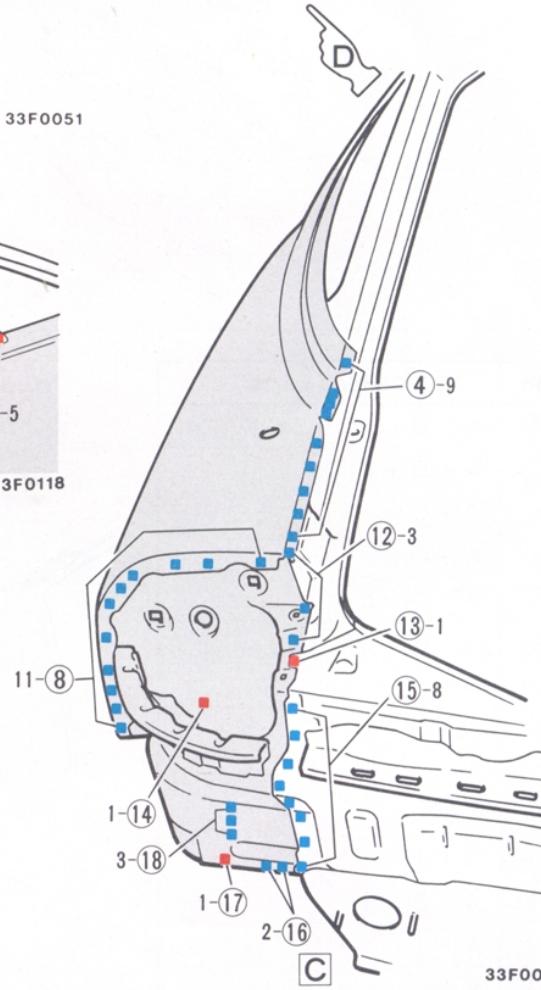
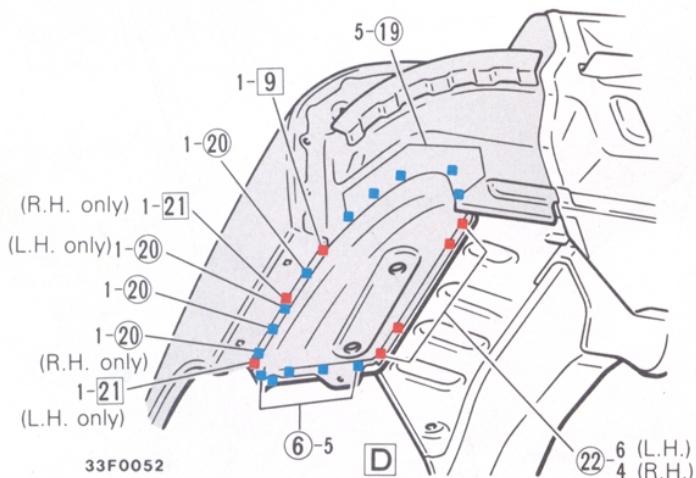
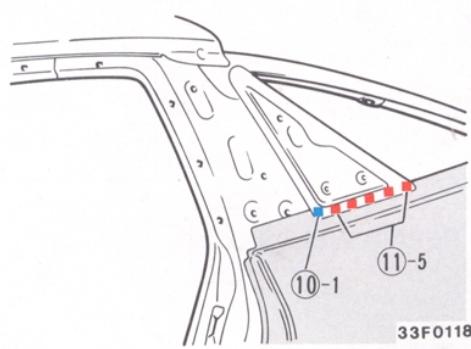
33F0090



33F0092



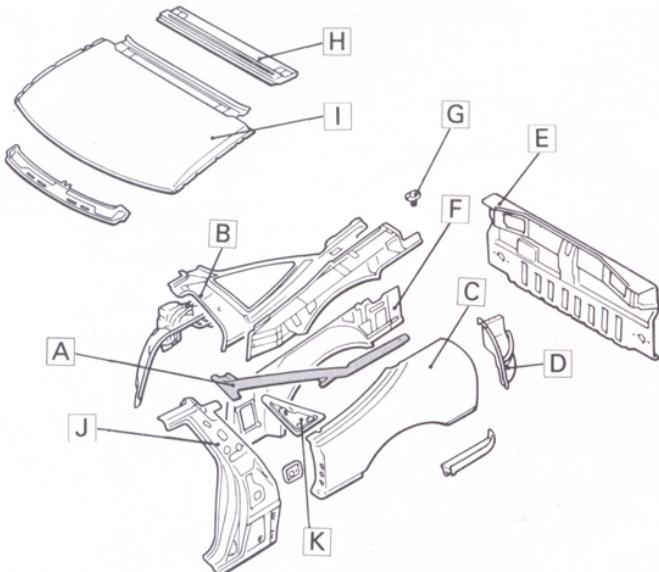
(Illustration shows the center pillar outer extension in the removed condition)



## NOTES WITH REGARD TO REPAIR WORK INSTALLATION

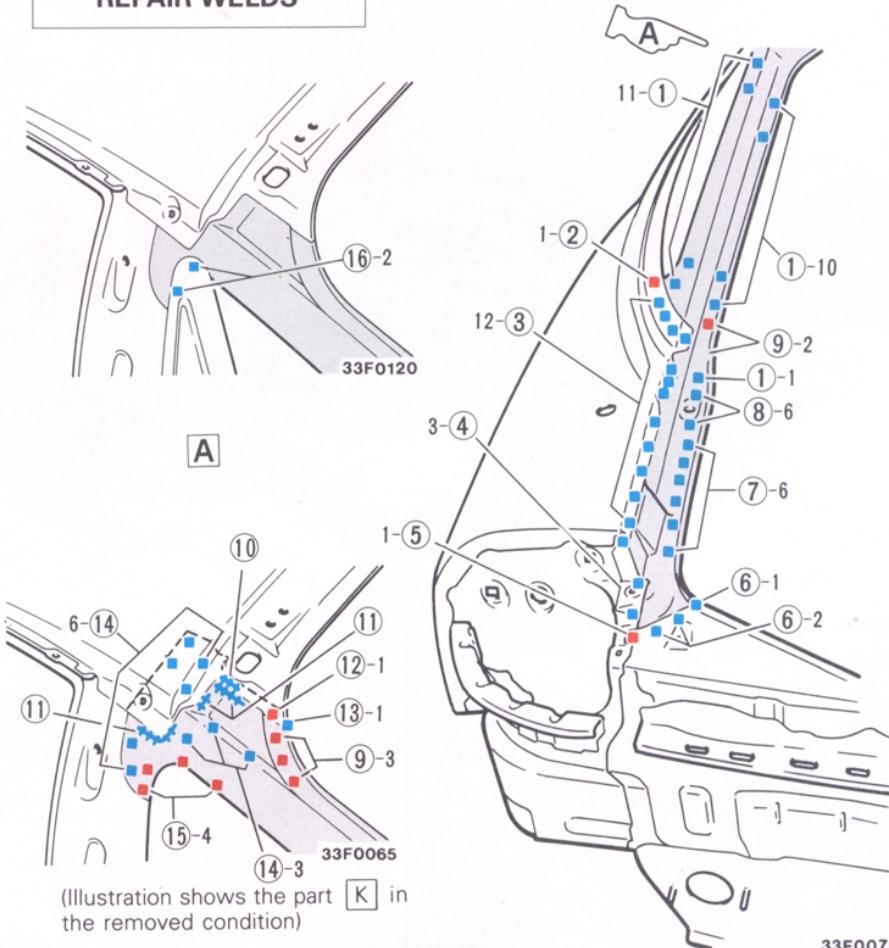
- 1) Apply a coating of body sealant at the body side where shown in the illustration.

## REAR PILLAR, OUTER

REPLACEMENT CONFIGURATION	ASSEMBLY ( A )	PART NAME
		<p>A Rear pillar, outer      B Quarter panel, inner, upper      C Quarter panel, outer      D Rear lamp housing      E Rear end panel      F Quarter panel, inner, lower      G Drain pipe      H Rear roof rail      I Roof panel      J Center pillar, outer      K Center pillar outer extension</p>

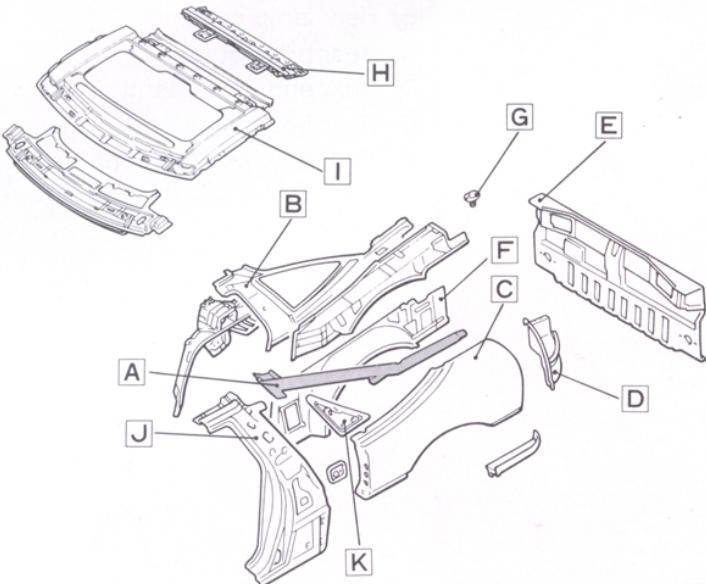
No.	Welded parts
①	A + B
②	A + B + C
③	A + C
④	A + D
⑤	A + D + E
⑥	A + E
⑦	A + F
⑧	A + G
⑨	A + B
⑩	A + H
⑪	A + I
⑫	A + B + I
⑬	A + I
⑭	A + J
⑮	A + B + J
⑯	A + K

## REPAIR WELDS



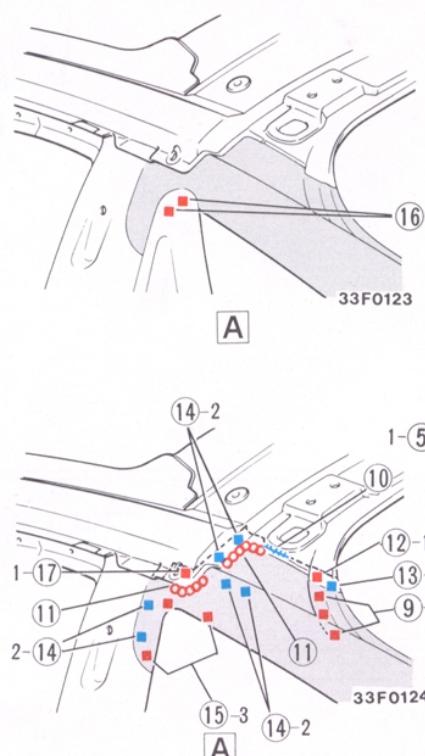
33F0076

## REAR PILLAR, OUTER (MODELS WITH SUNROOF)

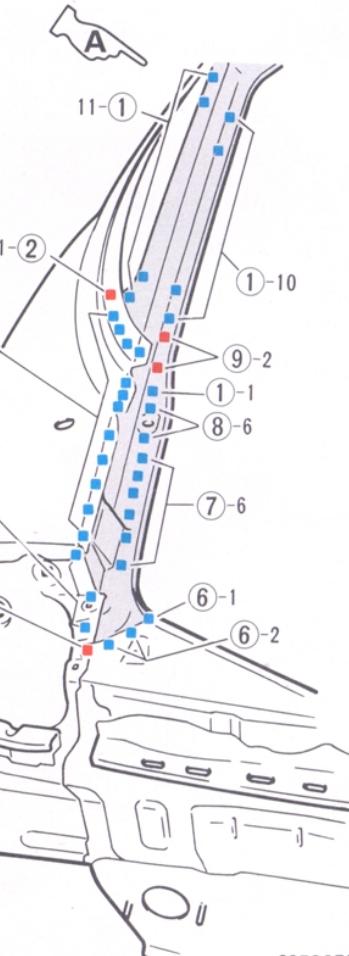
REPLACEMENT CONFIGURATION	ASSEMBLY (A)	PART NAME
	 <p>33F0518</p>	<p>A Rear pillar, outer      B Quarter panel, inner, upper      C Quarter panel, outer      D Rear lamp housing      E Rear end panel      F Quarter panel, inner, lower      G Drain pipe      H Rear roof rail      I Roof panel      J Center pillar, outer      K Center pillar outer extension</p>

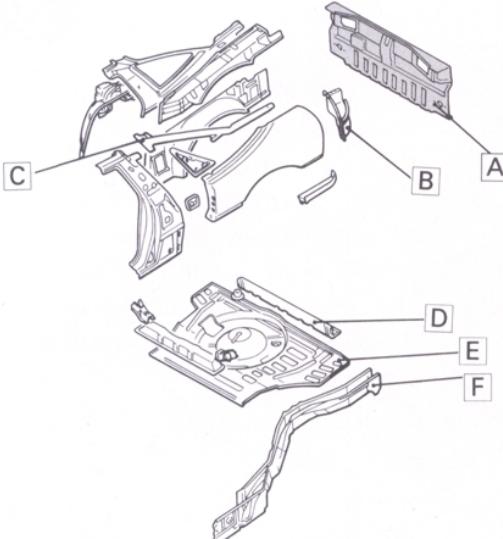
No.	Welded parts
①	A + B
②	A + B + C
③	A + C
④	A + D
⑤	A + D + E
⑥	A + E
⑦	A + F
⑧	A + G
⑨	A + B
⑩	A + H
⑪	A + I
⑫	A + B + I
⑬	A + I
⑭	A + J
⑮	A + B + J
⑯	A + B + J + K
⑰	A + J

## REPAIR WELDS



(Illustration shows the part K in the removed condition)

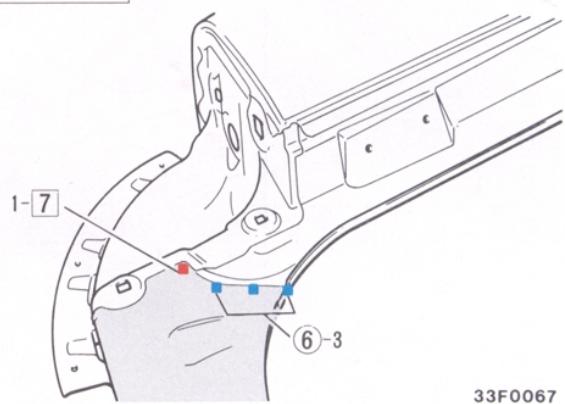


REPLACEMENT CONFIGURATION	ASSEMBLY (A)	PART NAME
		<p> <b>A</b> Rear end panel  <b>B</b> Rear lamp housing  <b>C</b> Rear pillar, outer  <b>D</b> Rear end crossmember  <b>E</b> Rear floor pan  <b>F</b> Rear-floor sidemember     </p>

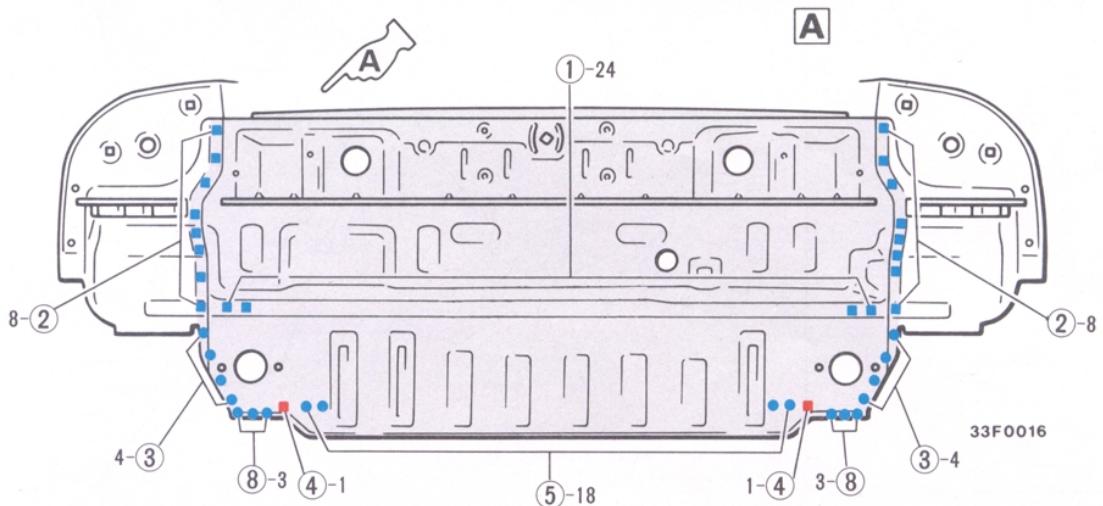
31F0032

No.	Welded parts
①	<b>A</b> + <b>H</b>
②	<b>A</b> + <b>B</b>
③	<b>A</b> + <b>I</b>
④	<b>A</b> + <b>G</b> + <b>I</b>
⑤	<b>A</b> + <b>G</b>
⑥	<b>A</b> + <b>D</b>
⑦	<b>A</b> + <b>B</b> + <b>D</b>
⑧	<b>A</b> + <b>F</b>

### REPAIR WELDS

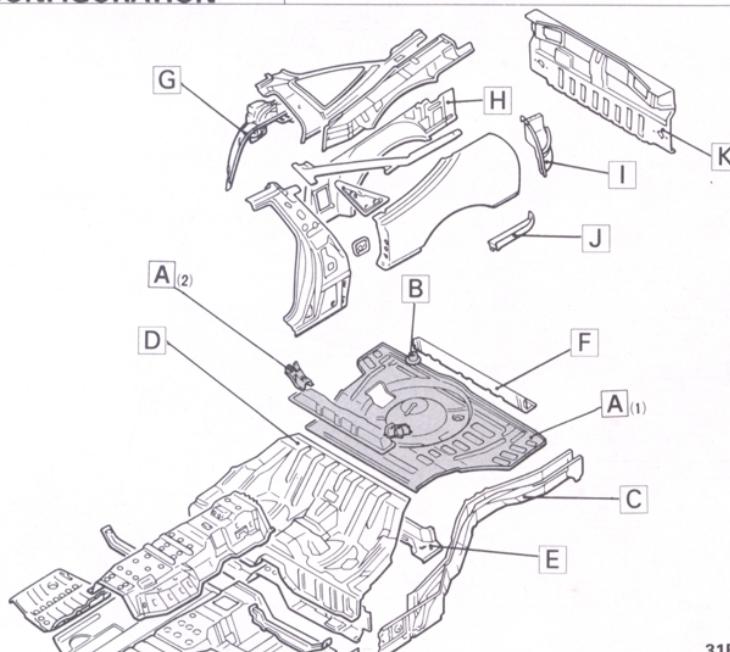


33F0067



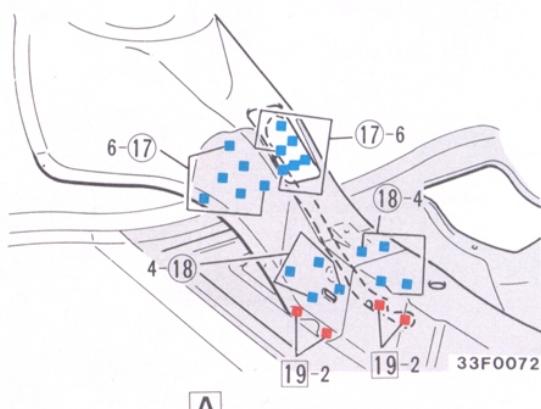
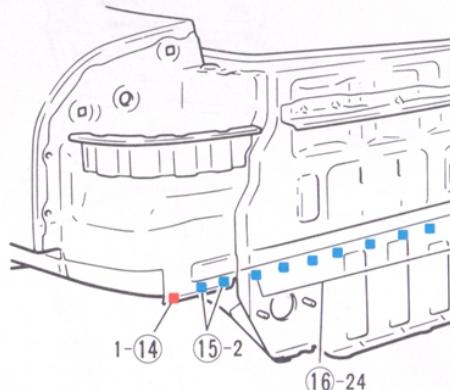
33F0016

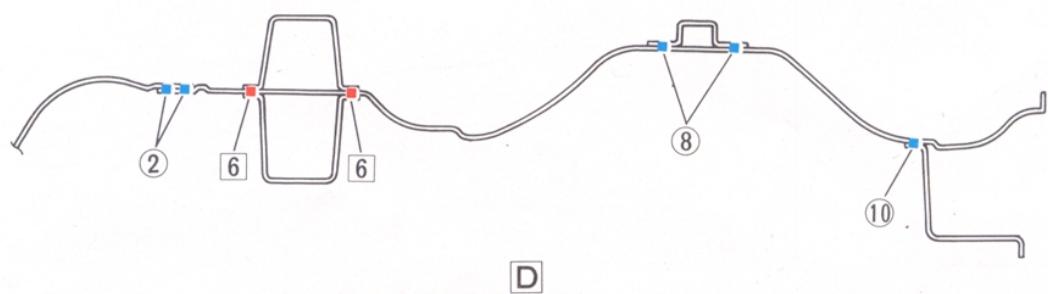
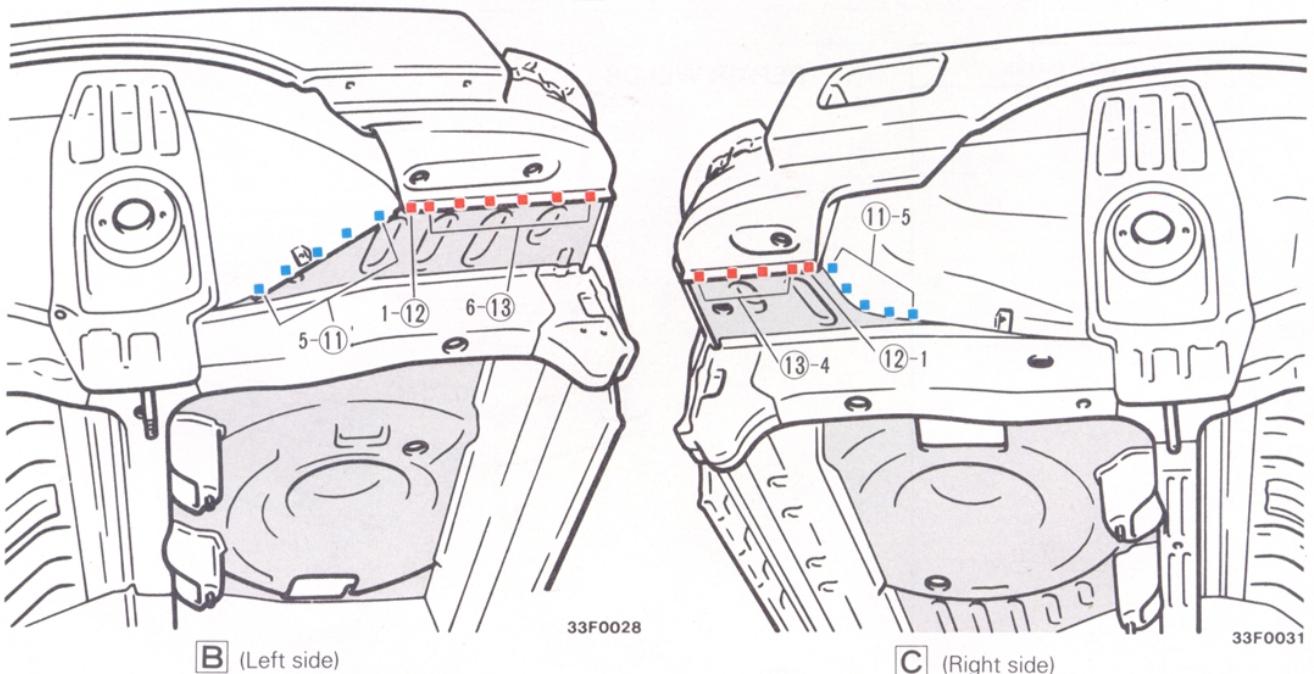
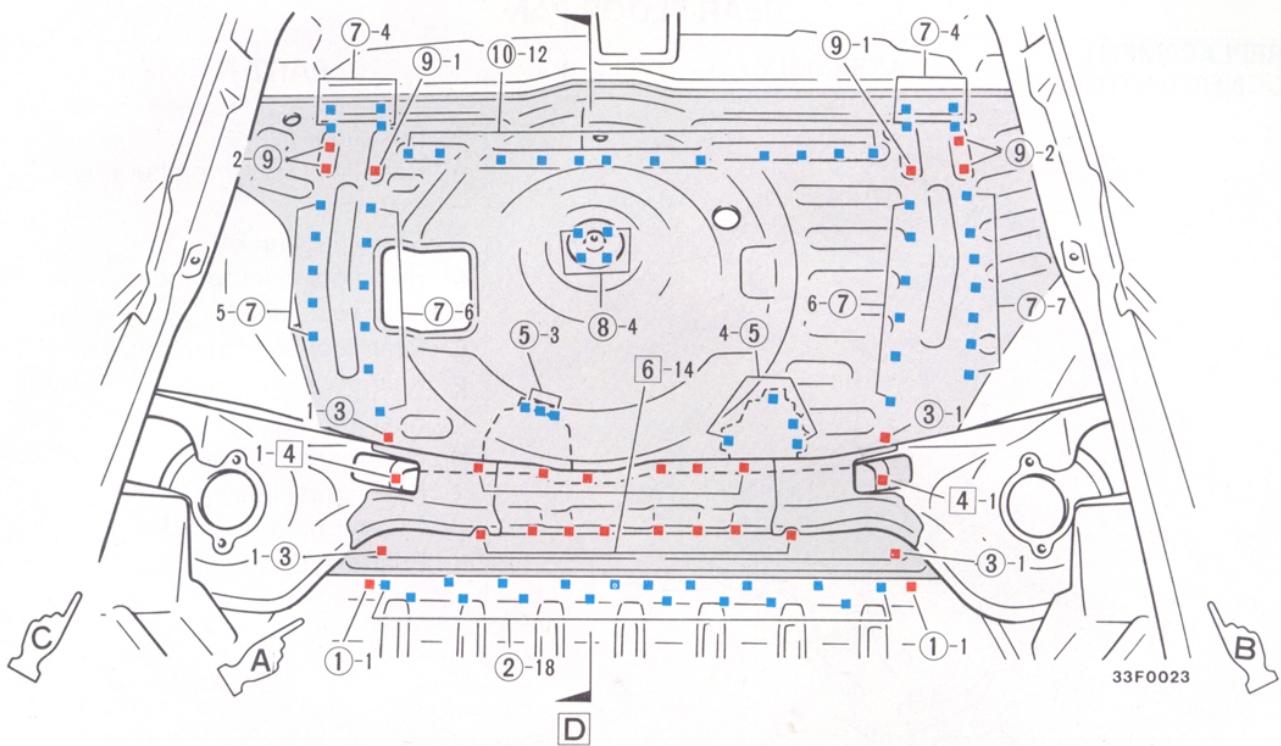
## REAR FLOOR PAN

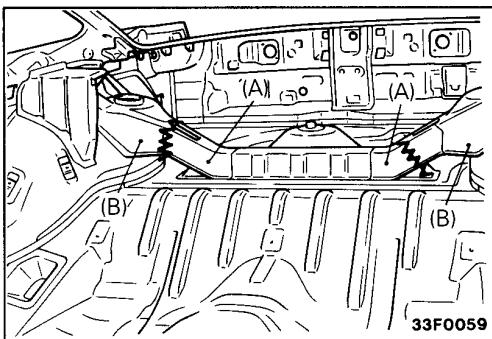
REPLACEMENT CONFIGURATION	ASSEMBLY ( A <sub>(1)</sub> A <sub>(2)</sub> B )	PART NAME
	 <p>31F0032</p>	<p><b>A<sub>(1)</sub></b> Rear floor pan  <b>A<sub>(2)</sub></b> Rear floor crossmember upper extension  <b>B</b> Spare tire bracket  <b>C</b> Rear floor sidemember  <b>D</b> Rear seat pan  <b>E</b> Rear floor crossmember, lower  <b>F</b> Rear end crossmember  <b>G</b> Rear wheelhouse, inner  <b>H</b> Quarter panel, inner, lower  <b>I</b> Rear lamp housing  <b>J</b> Quarter outer extension, lower  <b>K</b> Rear end panel</p>

No.	Welded parts	
①	A <sub>(1)</sub> + C + D	
②	A <sub>(1)</sub> + D	
③	A <sub>(1)</sub> + C + E	
④	A <sub>(1)</sub> + C	
⑤	A <sub>(1)</sub> + E	★
⑥	A <sub>(1)</sub> + E	
⑦	A <sub>(1)</sub> + C	
⑧	A <sub>(1)</sub> + B	
⑨	A <sub>(1)</sub> + C	
⑩	A <sub>(1)</sub> + F	
⑪	A <sub>(1)</sub> + G	
⑫	A <sub>(1)</sub> + G + H	
⑬	A <sub>(1)</sub> + H + J	
⑭	A <sub>(1)</sub> + H + I	
⑮	A <sub>(1)</sub> + I	
⑯	A <sub>(1)</sub> + K	
⑰	A <sub>(2)</sub> + G	
⑱	A <sub>(1)</sub> + A <sub>(2)</sub>	
⑲	A <sub>(1)</sub> + A <sub>(2)</sub>	

## REPAIR WELDS







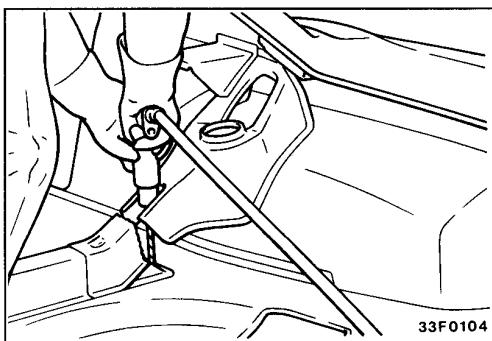
## NOTES WITH REGARD TO REPAIR WORK

### REMOVAL

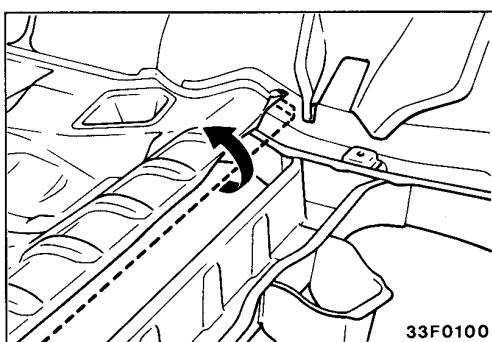
- (1) In order to facilitate the cutting and removal of spot-welded places, cut only the rear floor crossmember upper extension (A) at the illustrated locations.

#### Caution

**Do not cut the shelf corner braces (B) at the body side.**



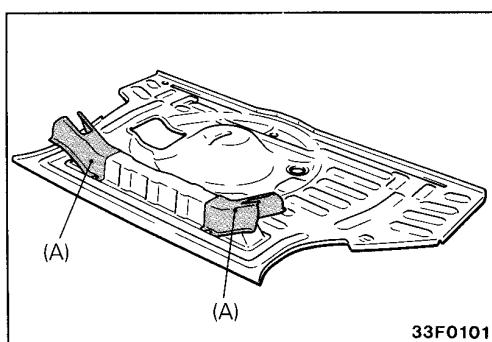
- (2) Cut the spot-welded place **4** with a drill through the clearance at the shelf corner brace.



- (3) In order to facilitate the removal and installation of the rear floor pan, bend the end of the rear seat pan upward as shown in the illustration.

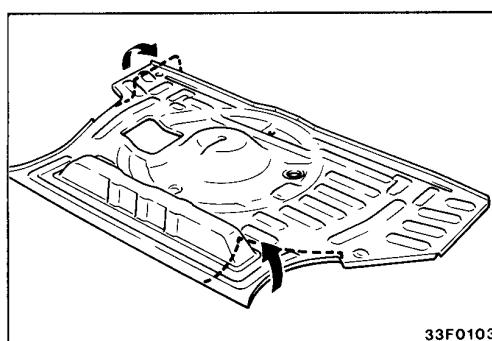
#### Caution

**Bend the rear seat pan the minimum necessary only.**



## INSTALLATION

- (1) Remove the rear floor crossmember upper extensions (A) from the new part before installing the new rear floor pan onto the body. Install the parts (A) to the rear floor pan after installing the rear floor pan onto the body.

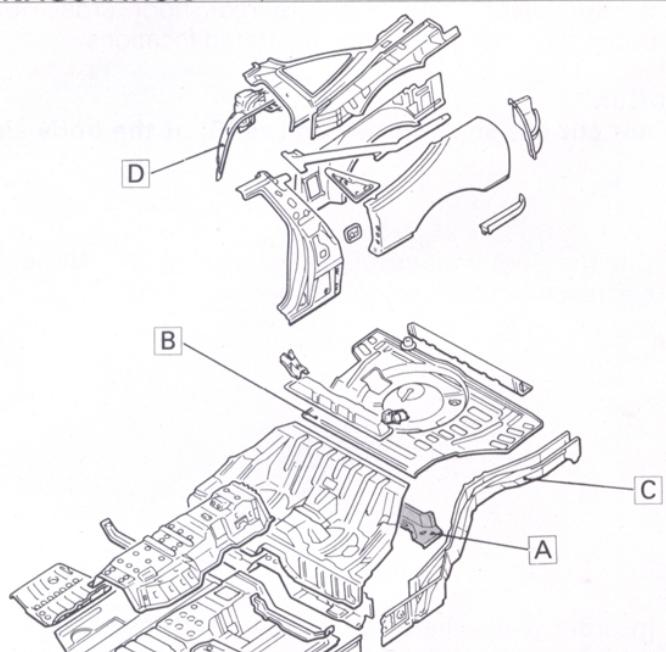


- (2) In order to facilitate the installation of the new part, bend the illustrated part upward as shown in the illustration.

#### Caution

**Bend the new part the minimum necessary only.**

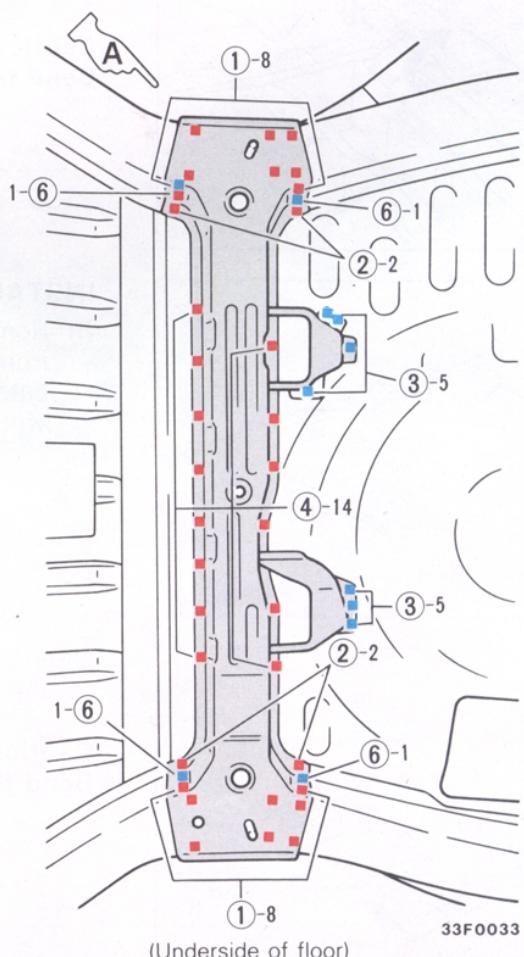
REAR FLOOR CROSSMEMBER, LOWER

REPLACEMENT CONFIGURATION	ASSEMBLY (A)	PART NAME
		<p>A Rear floor crossmember, lower      B Rear floor pan      C Rear floor sidewall      D Rear wheelhouse, inner</p>

31F0032

No.	Welded parts
①	[A + C]
②	[A + B + C]
③	[A + B]
④	[A + B]
⑤	[A + D]
⑥	[A + C]

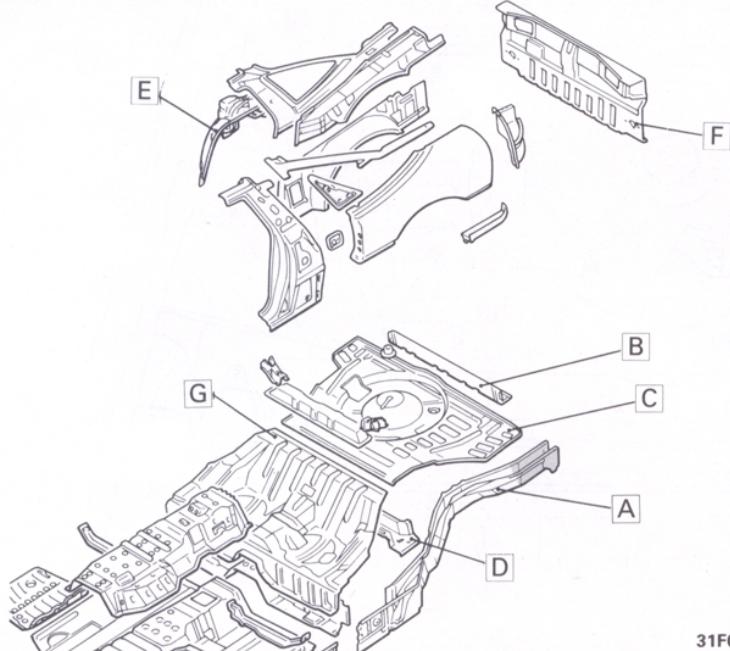
33F0044



33F0033

(Underside of floor)

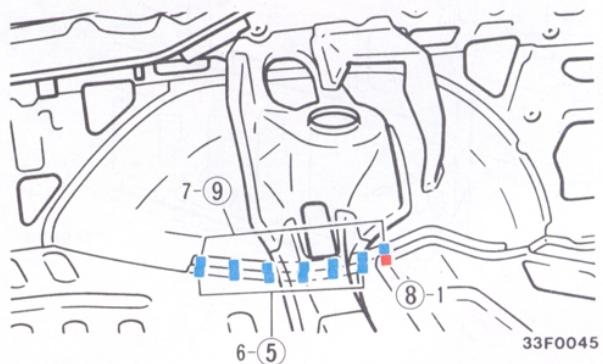
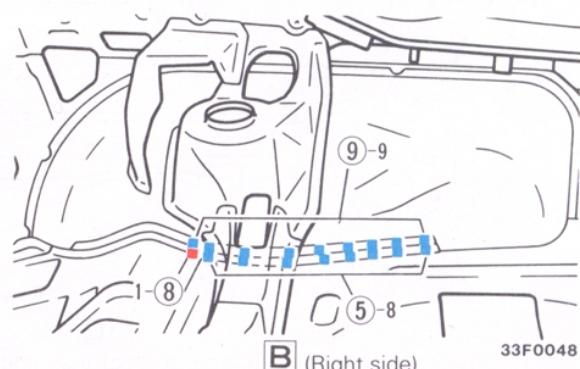
## REAR FLOOR SIDEMEMBER

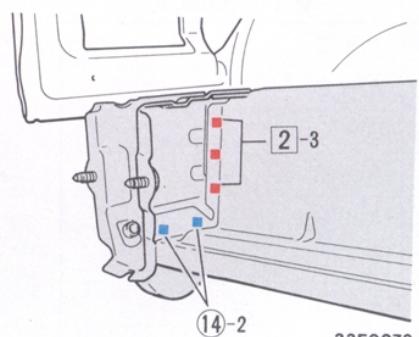
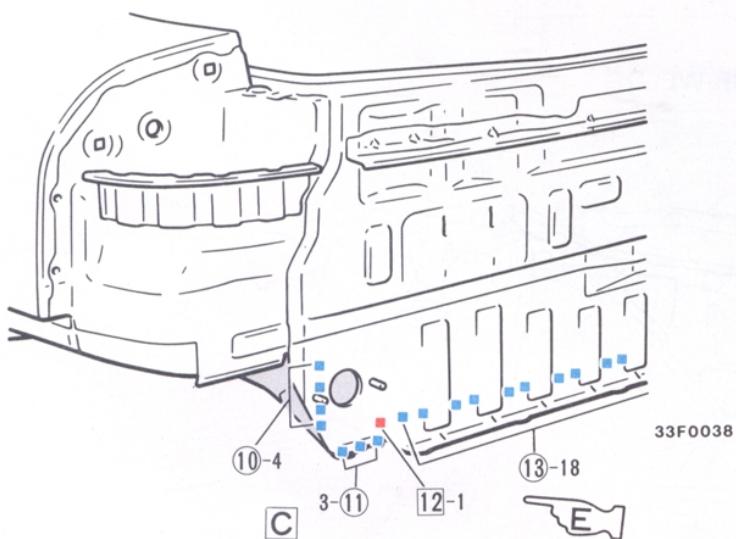
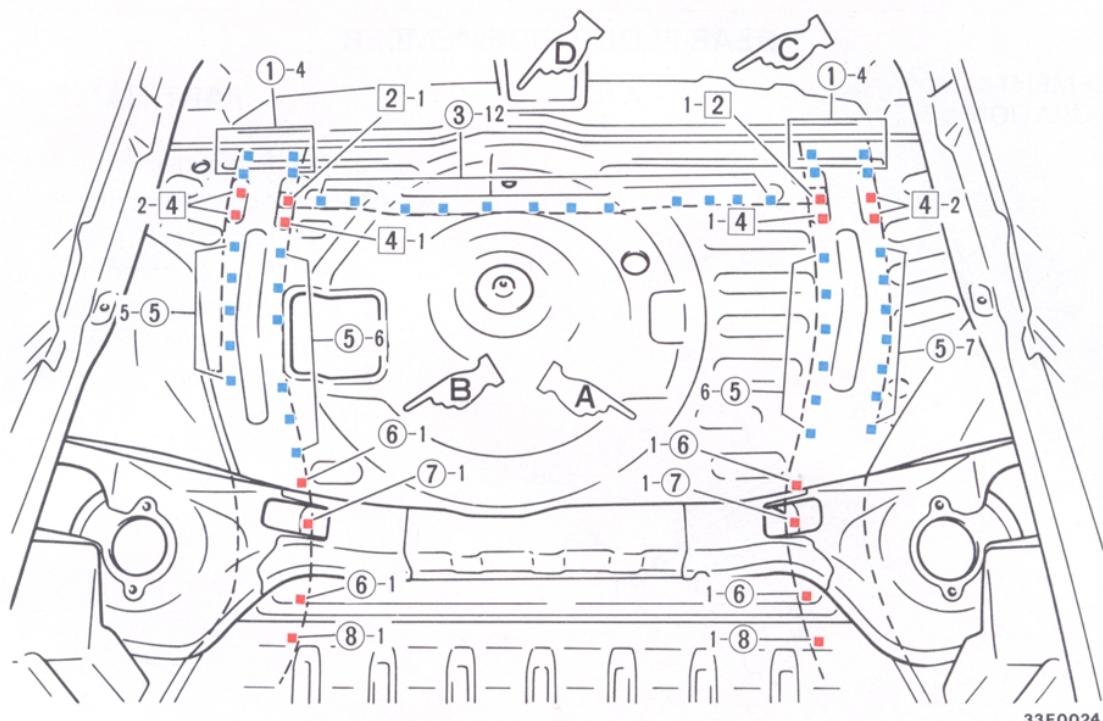
REPLACEMENT CONFIGURATION	CUT ( A B )	PART NAME
		<p> <b>A</b> Rear floor sidemember  <b>B</b> Rear end crossmember  <b>C</b> Rear floor pan  <b>D</b> Rear floor crossmember, lower  <b>E</b> Rear wheelhouse, inner  <b>F</b> Rear end panel  <b>G</b> Rear seat pan     </p>

31F0032

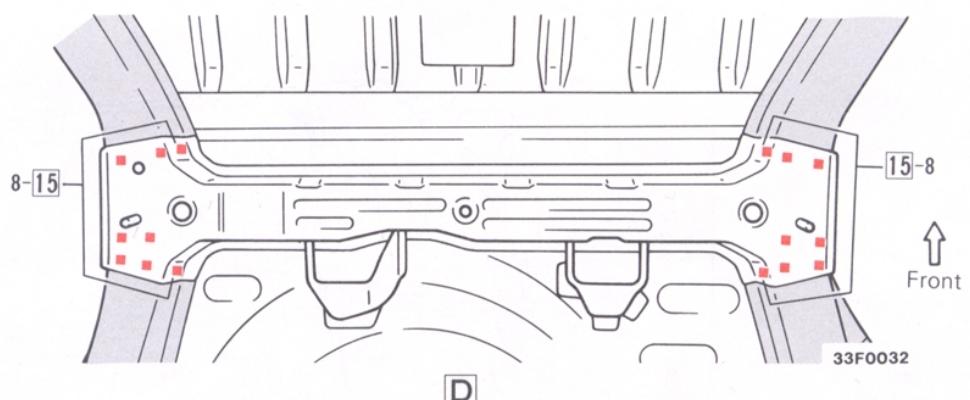
No.	Welded parts
①	<input type="checkbox"/> A + <input type="checkbox"/> C
②	<input type="checkbox"/> A + <input type="checkbox"/> B
③	<input type="checkbox"/> B + <input type="checkbox"/> C
④	<input type="checkbox"/> A + <input type="checkbox"/> C
⑤	<input type="checkbox"/> A + <input type="checkbox"/> C
⑥	<input type="checkbox"/> A + <input type="checkbox"/> C + <input type="checkbox"/> D
⑦	<input type="checkbox"/> A + <input type="checkbox"/> C
⑧	<input type="checkbox"/> A + <input type="checkbox"/> C + <input type="checkbox"/> G
⑨	<input type="checkbox"/> A + <input type="checkbox"/> E
⑩	<input type="checkbox"/> A + <input type="checkbox"/> F
⑪	<input type="checkbox"/> A + <input type="checkbox"/> F
⑫	<input type="checkbox"/> A + <input type="checkbox"/> B + <input type="checkbox"/> F
⑬	<input type="checkbox"/> B + <input type="checkbox"/> F
⑭	<input type="checkbox"/> A + <input type="checkbox"/> B
⑮	<input type="checkbox"/> A + <input type="checkbox"/> D

## REPAIR WELDS

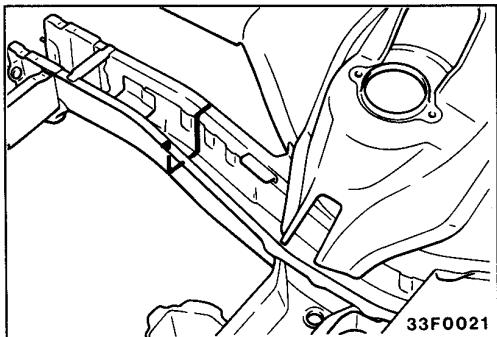
**A** (Left side)**B** (Right side)



(Illustration shows the rear end panel in the removed condition.)

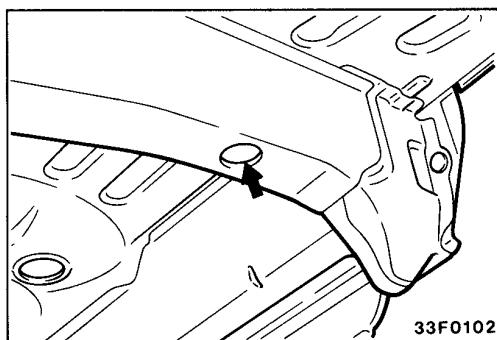
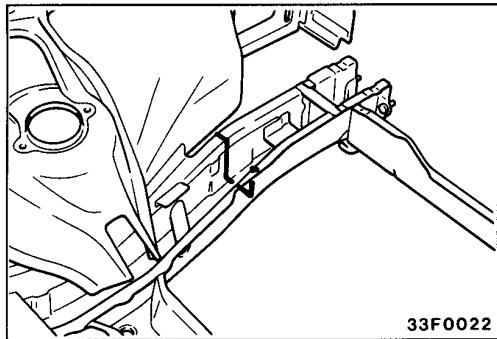


(Center part of floor underside)



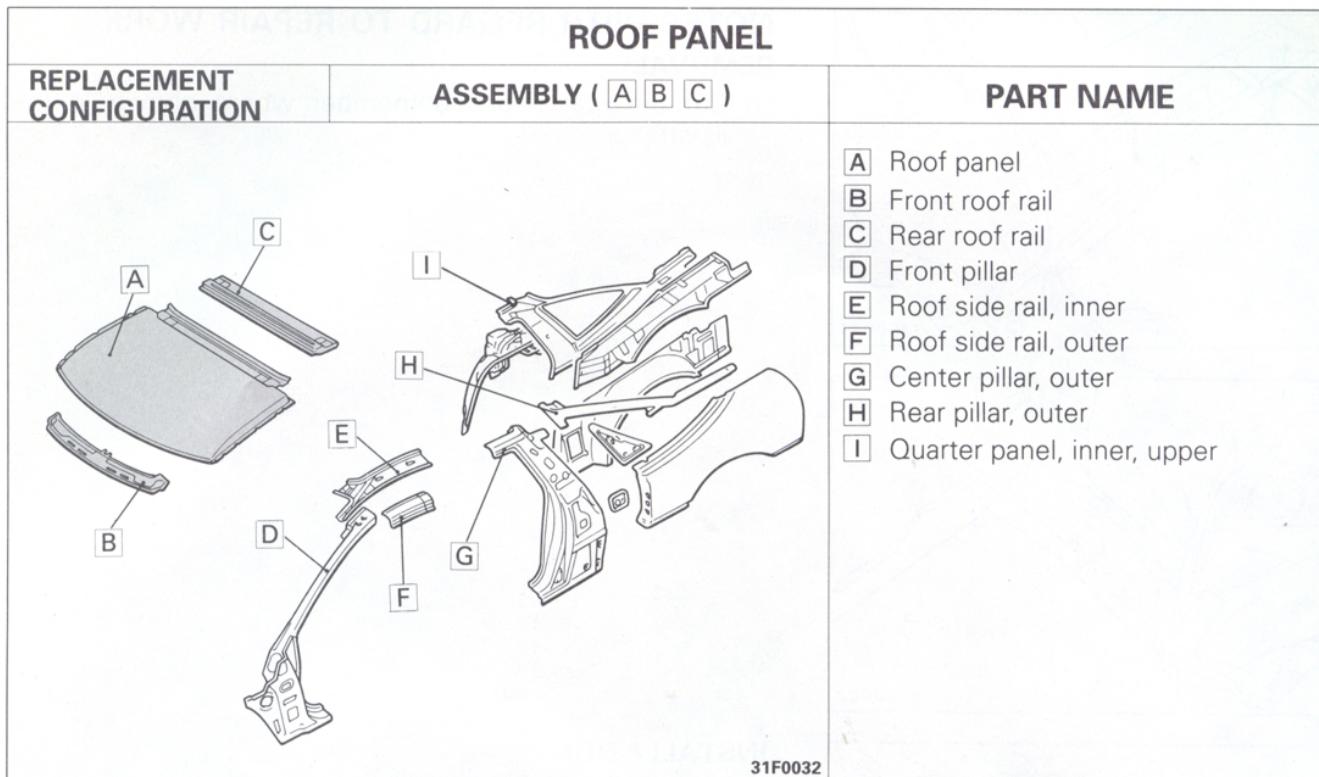
## NOTES WITH REGARD TO REPAIR WORK REMOVAL

- (1) Cut the rear floor sidemember where shown in the illustration.



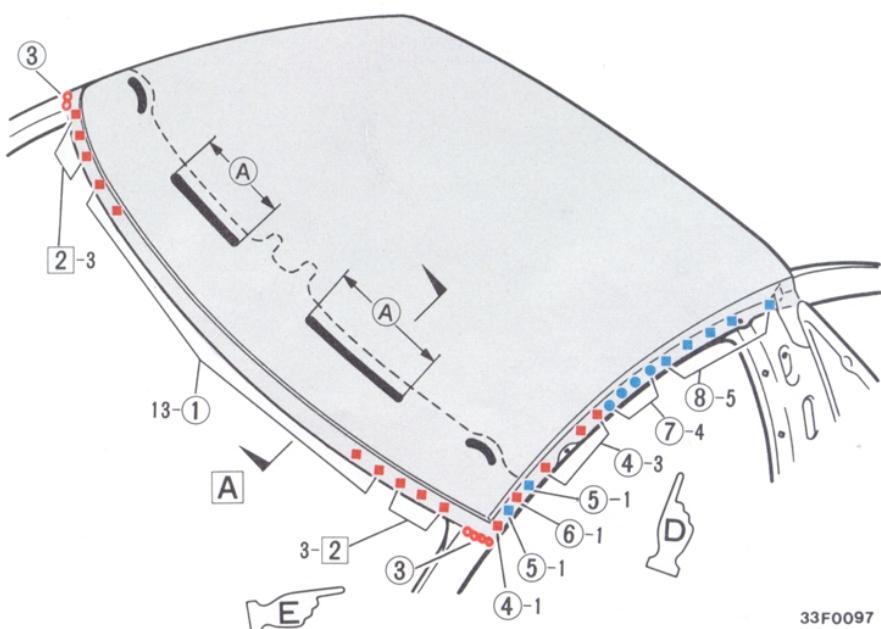
## INSTALLATION

- (1) Butt-weld the new part.  
Make the butt-welding securely from both sides (inner and outer) of the sidemember.
- (2) Apply a liberal amount of corrosion-prevention agent (using the hole indicated in the illustration) to the butt-weld locations.



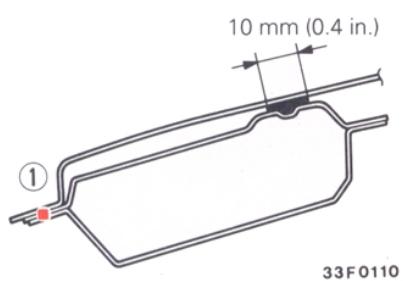
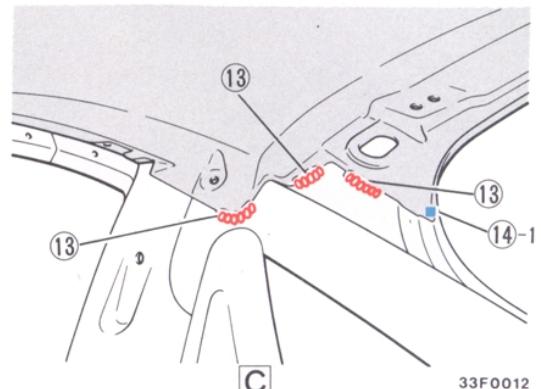
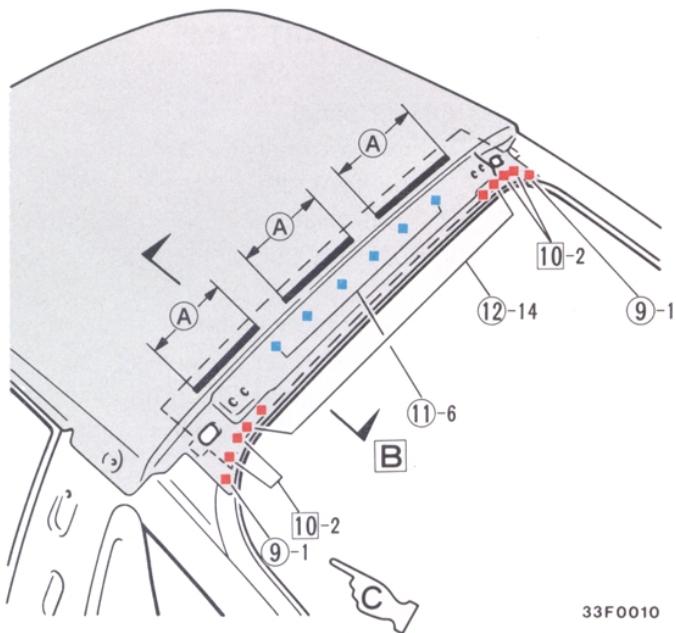
No.	Welded parts
①	A + B
②	A + B + E
③	A + D
④	A + D
⑤	A + B
⑥	B + D
⑦	A + F
⑧	A + G
⑨	A + H + I
⑩	A + C + I
⑪	A + C
⑫	A + C
⑬	A + H
⑭	A + H
⑮	C + I
⑯	C + H
⑰	C + G
⑱	B + E

**REPAIR WELDS**

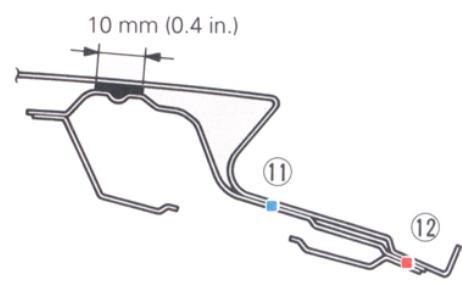


Ⓐ : 200 mm (7.9 in.)

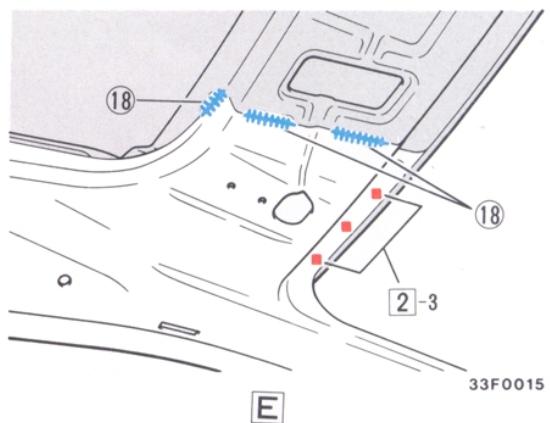
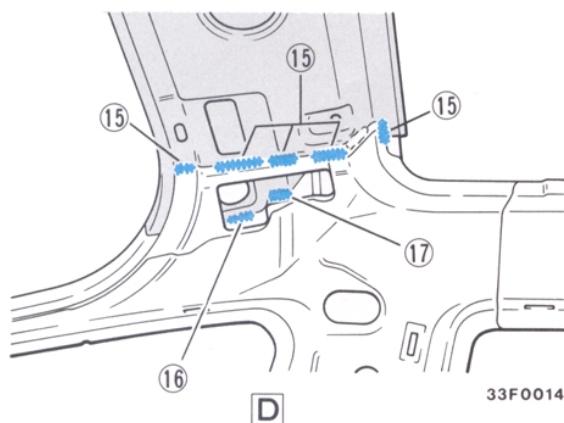
■ : Adhesive



A

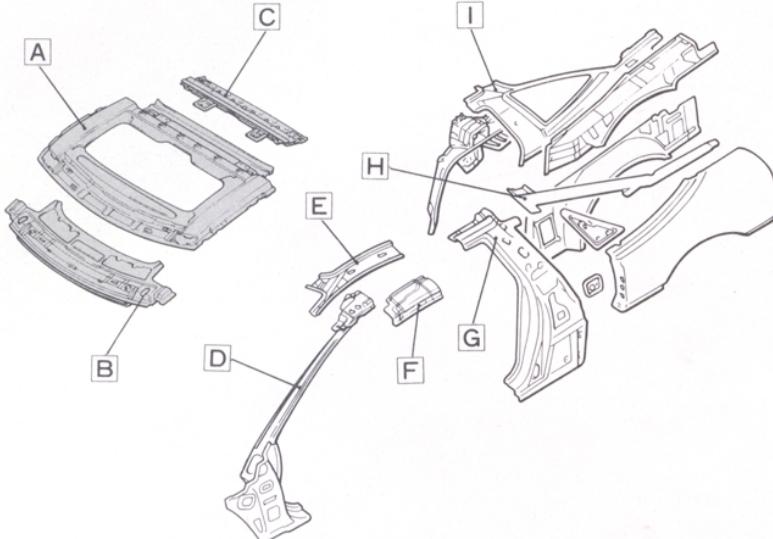


B



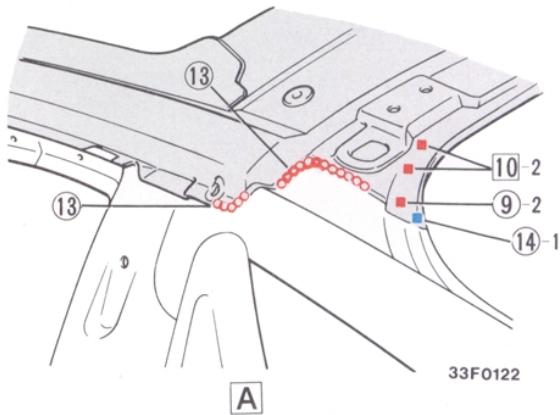
E

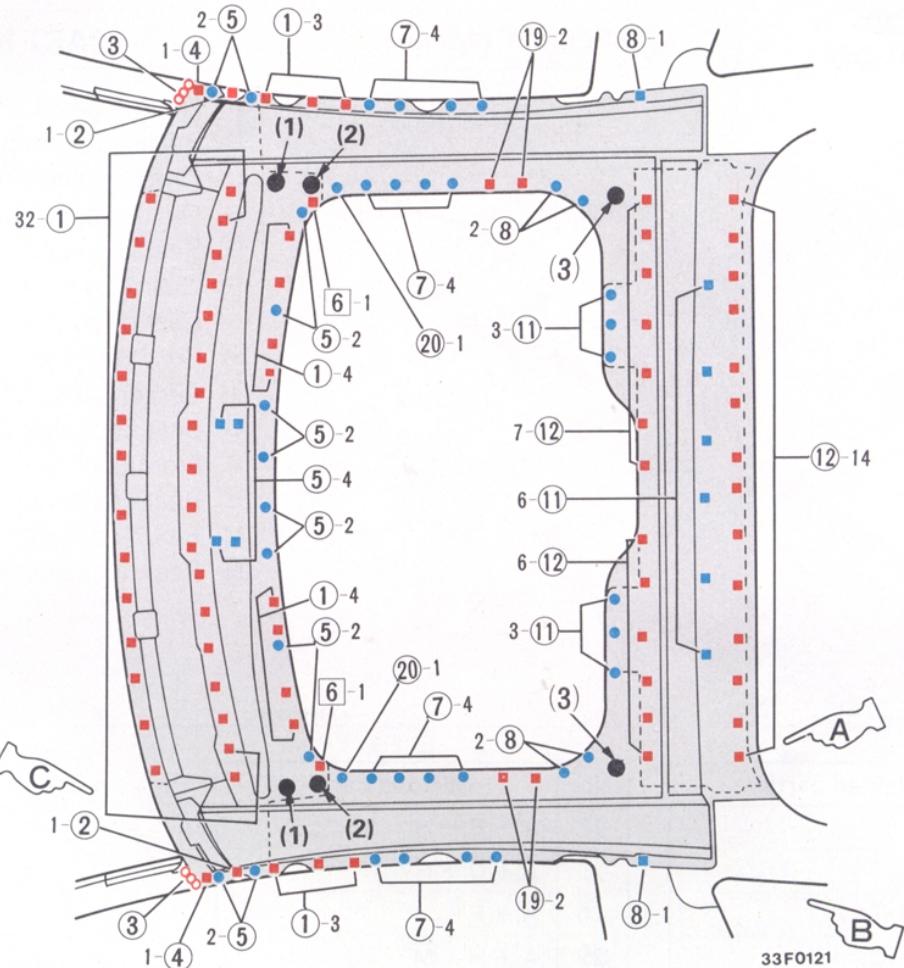
## ROOF PANEL (MODELS WITH SUNROOF)

REPLACEMENT CONFIGURATION	ASSEMBLY ( A B C )	PART NAME
		<p> <b>A</b> Roof panel  <b>B</b> Front roof rail  <b>C</b> Rear roof rail  <b>D</b> Front pillar  <b>E</b> Roof side rail, inner  <b>F</b> Roof side rail, outer  <b>G</b> Center pillar, outer  <b>H</b> Rear pillar, outer  <b>I</b> Quarter panel, inner, upper     </p>

No.	Welded parts
①	<b>A</b> + <b>B</b>
②	<b>B</b> + <b>D</b>
③	<b>A</b> + <b>D</b>
④	<b>A</b> + <b>D</b>
⑤	<b>A</b> + <b>B</b>
⑥	<b>A</b> + <b>B</b> + <b>D</b>
⑦	<b>A</b> + <b>F</b>
⑧	<b>A</b> + <b>G</b>
⑨	<b>A</b> + <b>H</b> + <b>I</b>
⑩	<b>A</b> + <b>C</b> + <b>I</b>
⑪	<b>A</b> + <b>C</b>
⑫	<b>A</b> + <b>C</b>
⑬	<b>A</b> + <b>H</b>
⑭	<b>A</b> + <b>H</b>
⑮	<b>C</b> + <b>I</b>
⑯	<b>C</b> + <b>H</b>
⑰	<b>C</b> + <b>G</b>
⑱	<b>B</b> + <b>E</b>
⑲	<b>A</b> + <b>F</b> + <b>G</b>
⑳	<b>A</b> + <b>D</b>
㉑	<b>A</b> + <b>B</b> + <b>E</b>

## REPAIR WELDS

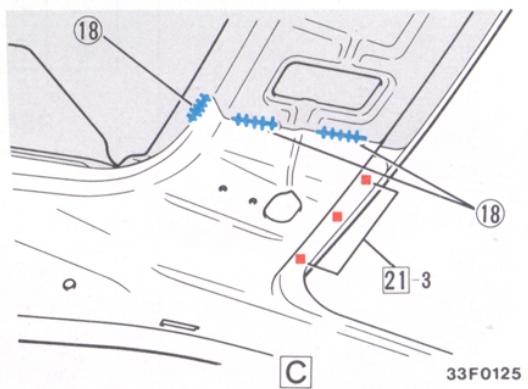




33F0121



33F0126

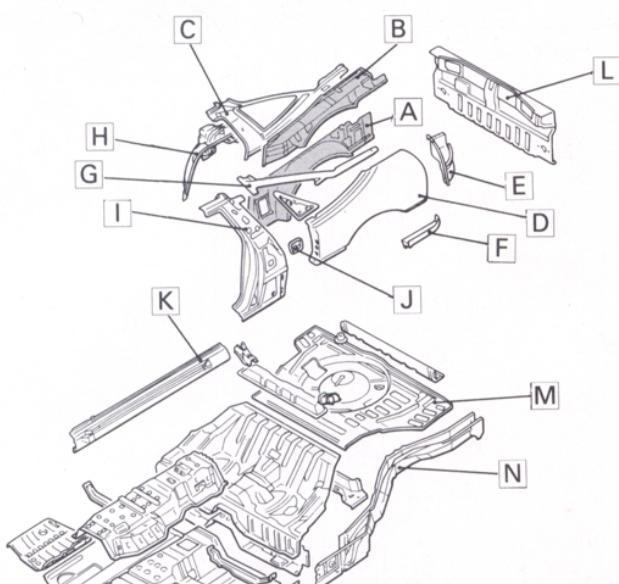


33F0125

■ : Adhesive

- (1) Between the front roof rail **B** and the front pillar **D**  
 (2) Between the roof panel **A** and the front roof rail **B**  
 (3) Between the roof panel **A** and the center pillar outer **G**
- } Apply adhesive more than 20 mm (0.7 in.) in diameter.

## QUARTER PANEL, INNER, LOWER

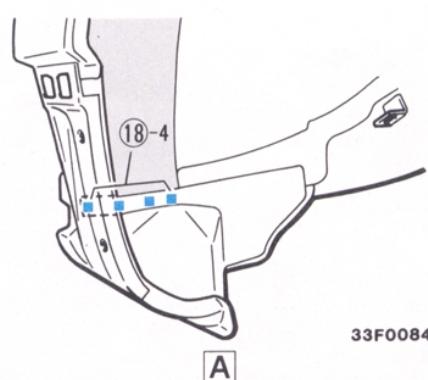
REPLACEMENT CONFIGURATION	ASSEMBLY ( A B )	PART NAME
		<p><b>A</b> Quarter panel, inner, lower  <b>B</b> Beltline reinforcement  <b>C</b> Quarter panel, inner, upper  <b>D</b> Quarter panel, outer  <b>E</b> Rear lamp housing  <b>F</b> Quarter outer extension, lower  <b>G</b> Rear pillar, outer  <b>H</b> Rear wheelhouse, inner  <b>I</b> Center pillar, outer  <b>J</b> Seat belt reinforcement  <b>K</b> Front floor side sill, outer  <b>L</b> Rear end panel  <b>M</b> Rear floor pan  <b>N</b> Rear floor sidemember</p>

31F0032

No.	Welded parts
①	B+C
②	B+I
③	B+C+I
④	A+B+C
⑤	A+B+I
⑥	A+B
⑦	B+C
⑧	B+C+H
⑨	B+C+H
⑩	A+B
⑪	A+C
⑫	A+C
⑬	A+J
⑭	A+I
⑮	A+K+N
⑯	A+H+K
⑰	A+H+N
⑱	A+H
⑲	A+C+H
⑳	A+E
㉑	A+D

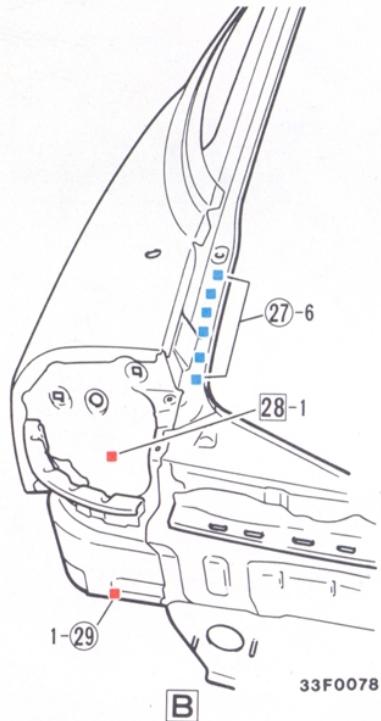
No.	Welded parts
㉒	A+B+H
㉓	A+D+F
㉔	A+F
㉕	A+H+M
㉖	A+F+M
㉗	A+G
㉘	A+B+E
㉙	A+E+M

## REPAIR WELDS



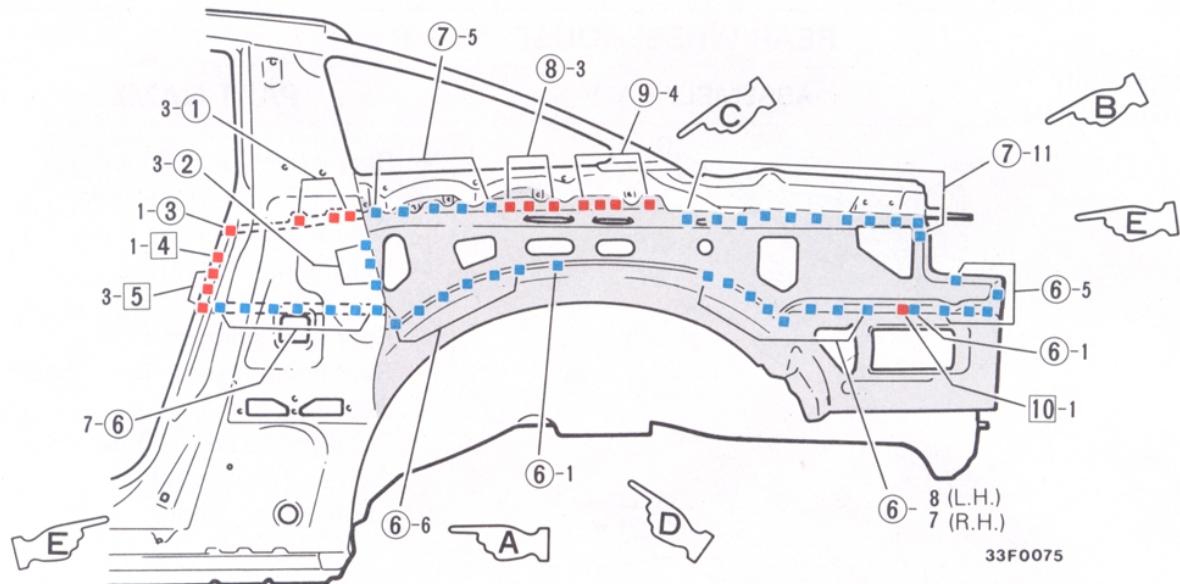
33F0084

A

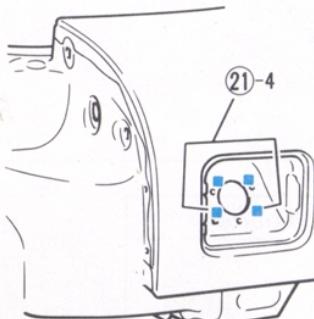
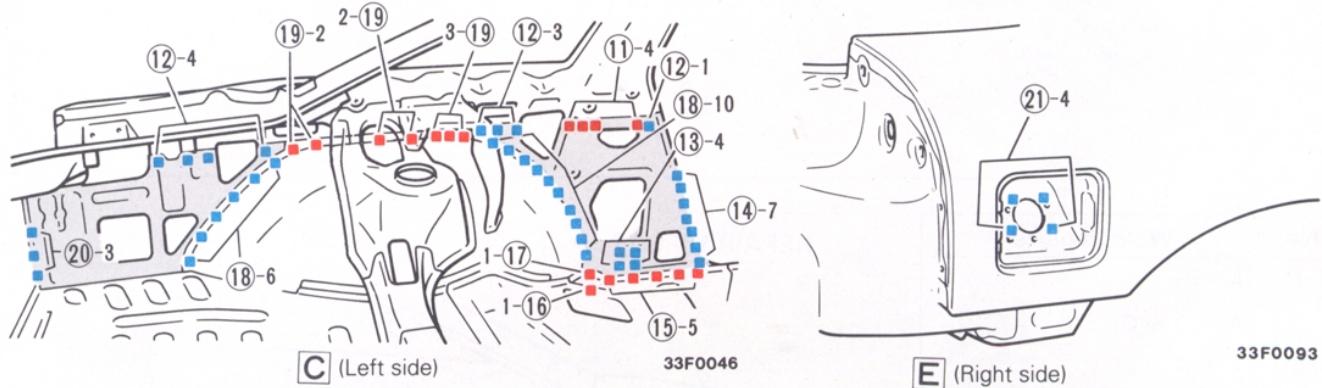


33F0078

B

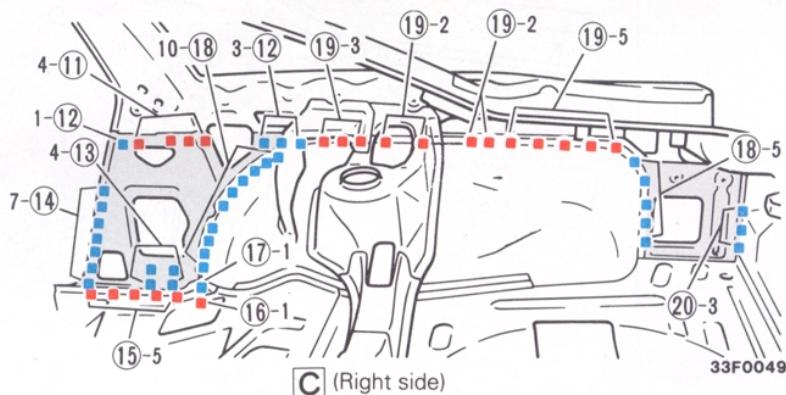


33F0075

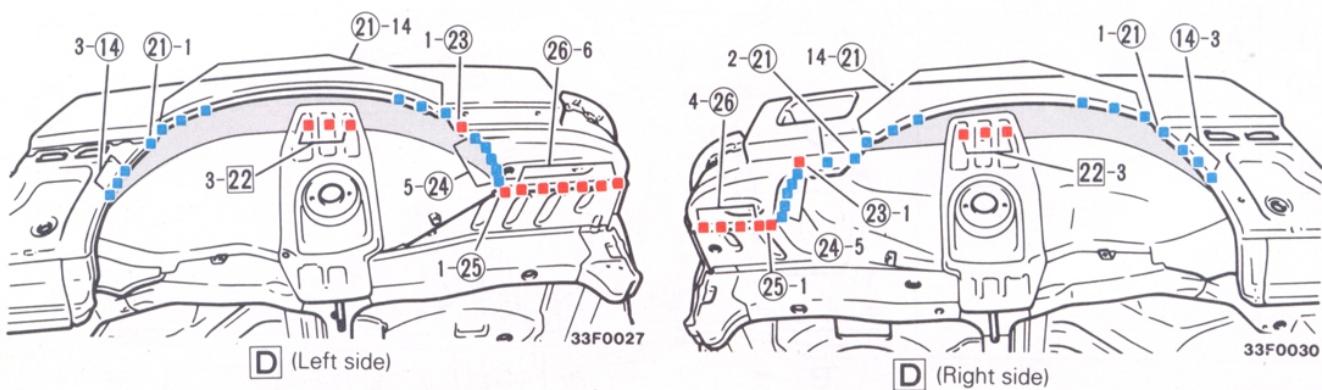


33F0046

E (Right side)



33F0049



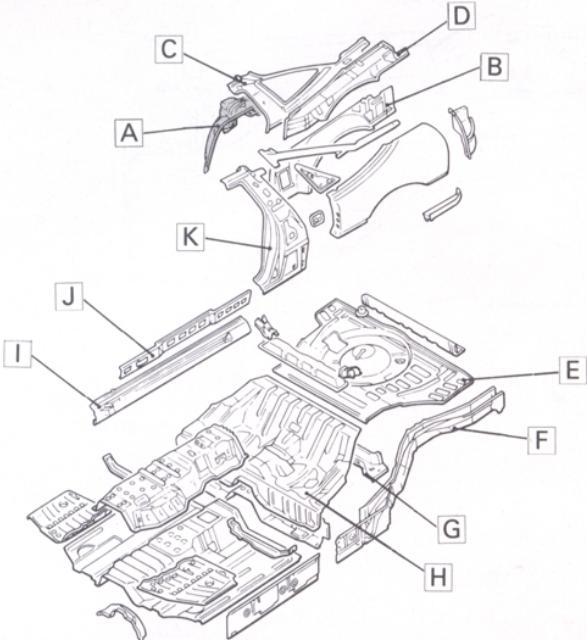
33F0027

D (Left side)

33F0030

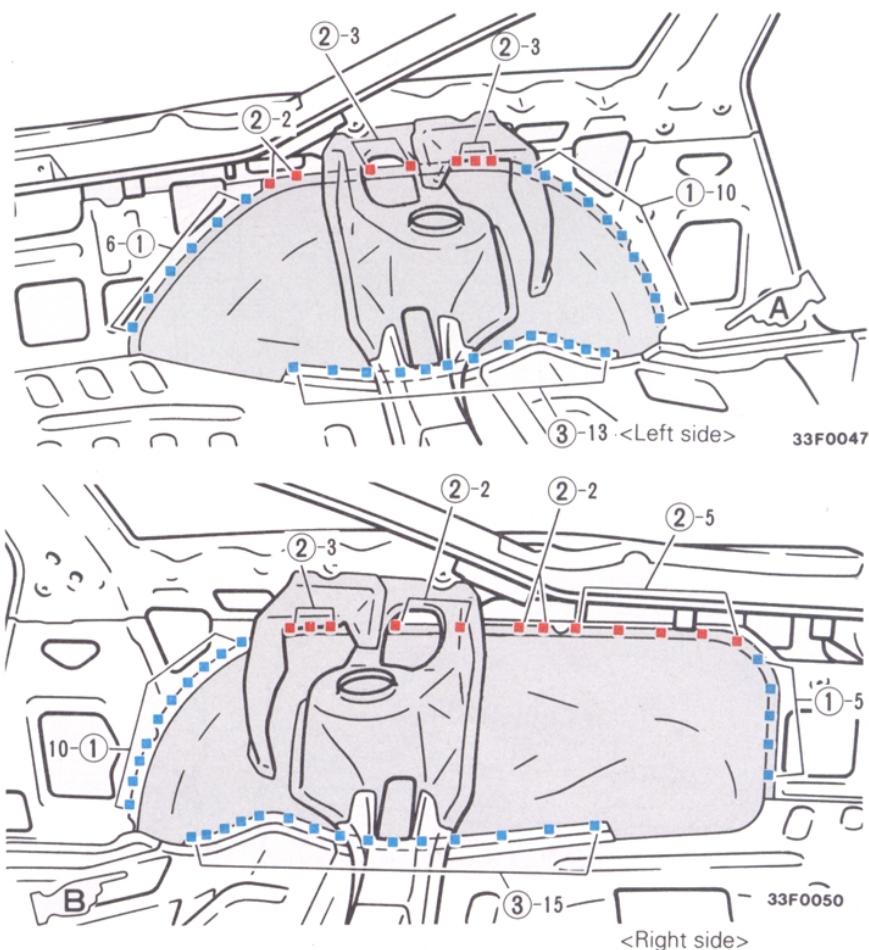
D (Right side)

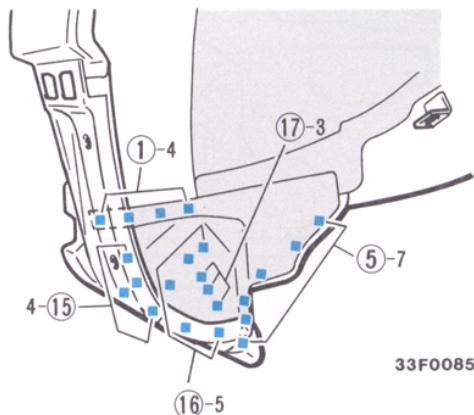
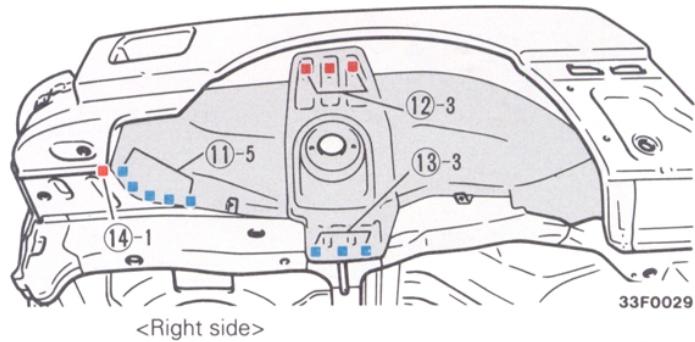
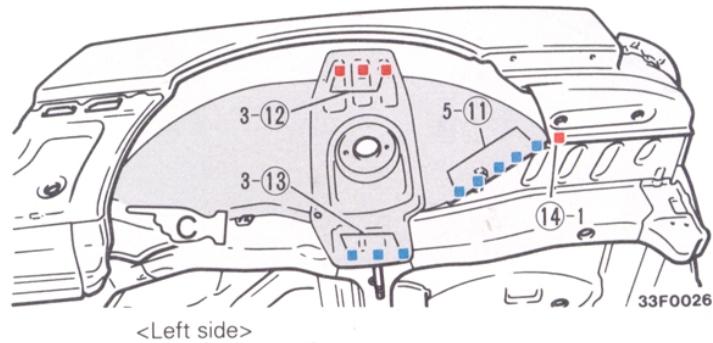
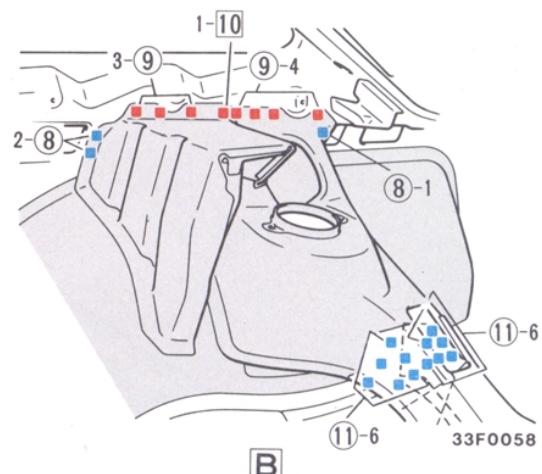
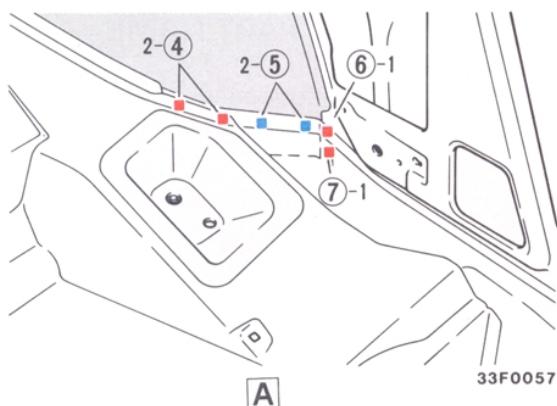
## REAR WHEELHOUSE, INNER

REPLACEMENT CONFIGURATION	ASSEMBLY (A)	PART NAME
	 33F0111	<b>A</b> Rear wheelhouse, inner <b>B</b> Quarter panel, inner, lower <b>C</b> Quarter panel, inner, upper <b>D</b> Beltline reinforcement <b>E</b> Rear floor pan <b>F</b> Rear floor sidemember <b>G</b> Rear floor crossmember, lower <b>H</b> Rear seat pan <b>I</b> Front floor side sill, outer <b>J</b> Side sill reinforcement <b>K</b> Center pillar, outer

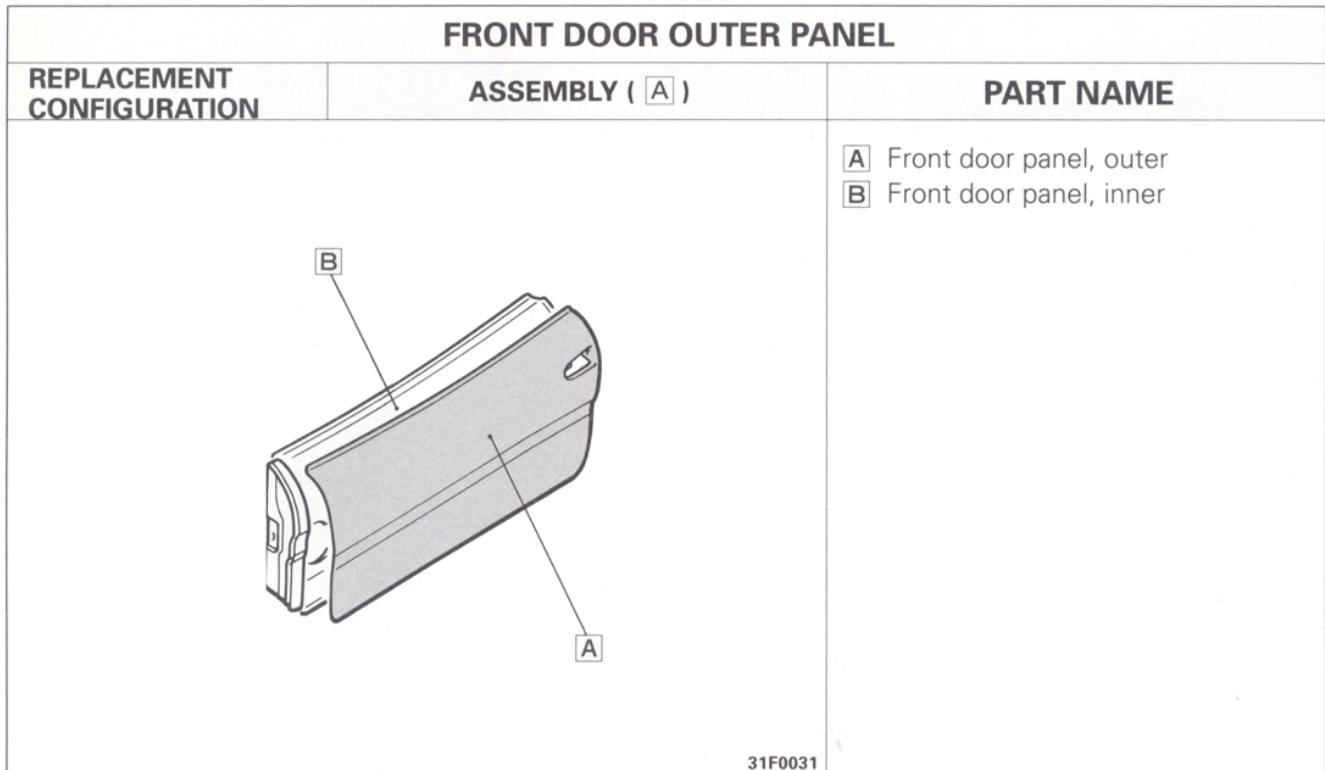
No.	Welded parts
①	A + B
②	A + B + C
③	A + F
④	A + F + H
⑤	A + F
⑥	A + B + F
⑦	A + B + I
⑧	A + C
⑨	A + C + D
⑩	A + C
⑪	A + E
⑫	A + B + D
⑬	A + G
⑭	A + B + E
⑮	A + K
⑯	A + I
⑰	A + J

## REPAIR WELDS



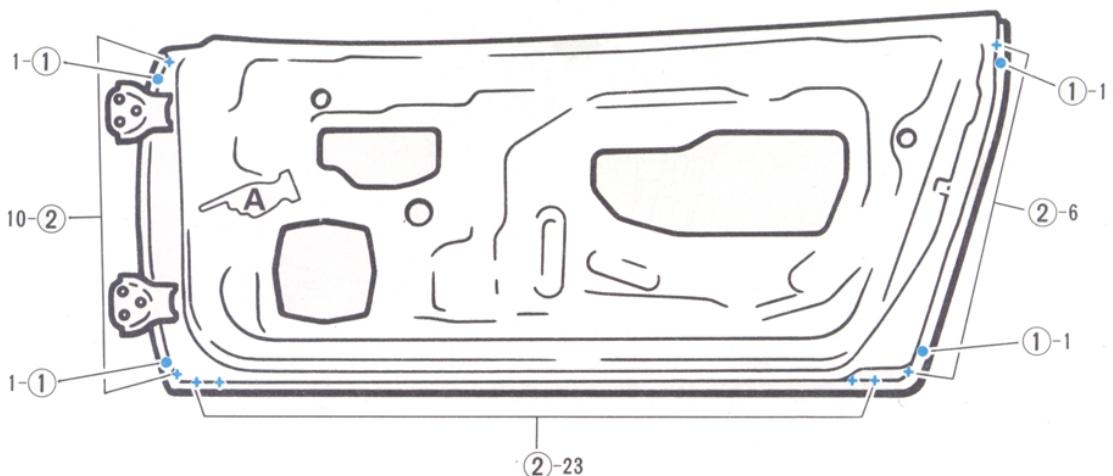


C



No.	Welded parts
①	<b>A+B</b>
②	<b>A+B</b>

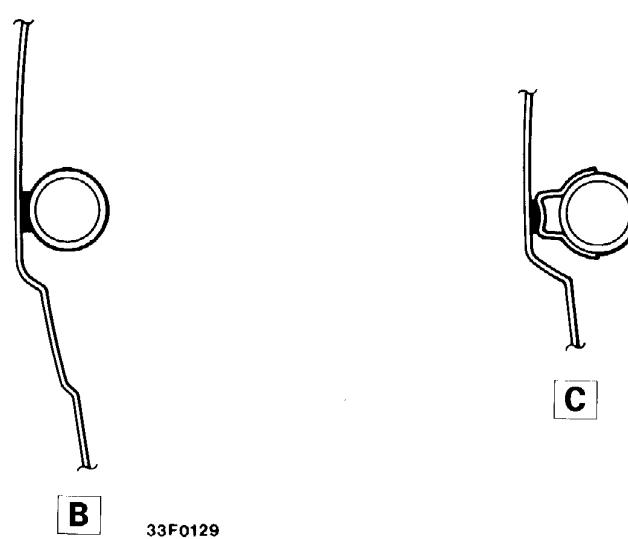
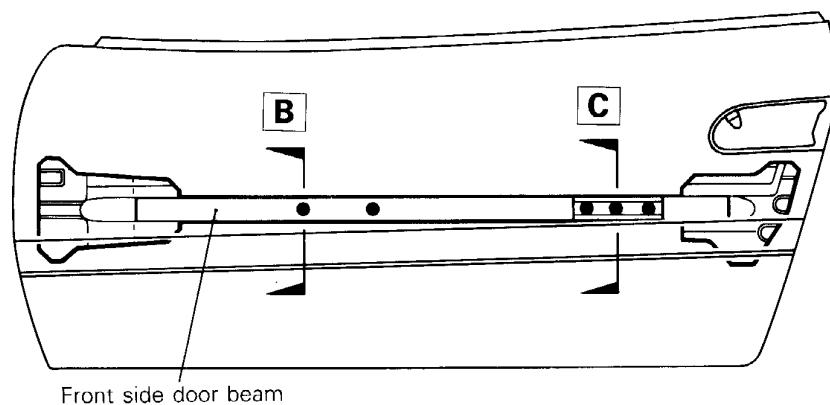
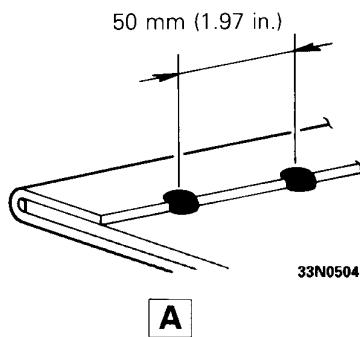
## REPAIR WELDS



## NOTES

- (1) The weld points ① show the manufacturer's joints (unnecessary when repairing).
- (2) After hemming the door outer panel, MIG spot weld the flange overlap section at a pitch of approx. 50 mm (1.97 in.) (weld point ②).

33F0025



33F0129

33F0128

■ : Adhesive

Adhesive	Type
	Chloroprene-base drying sealant