

# 3

## WELDED PANEL REPLACEMENT

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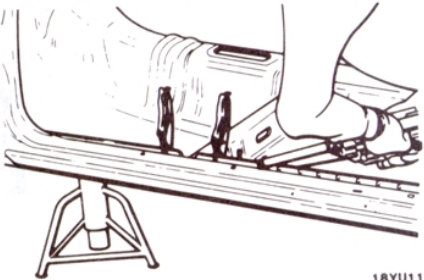





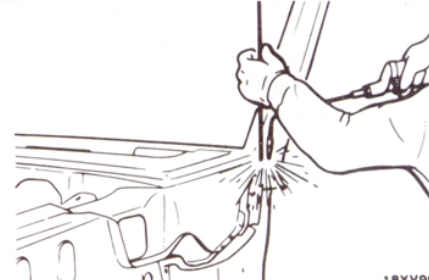




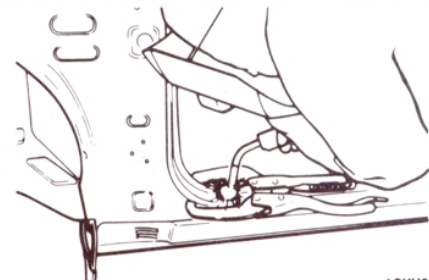
## WELDED PANEL REPLACEMENT

### 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	
	MIG spot welding	
	MIG arc welding (continuous)	
	Braze welding	
 	MIG plug welding  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.

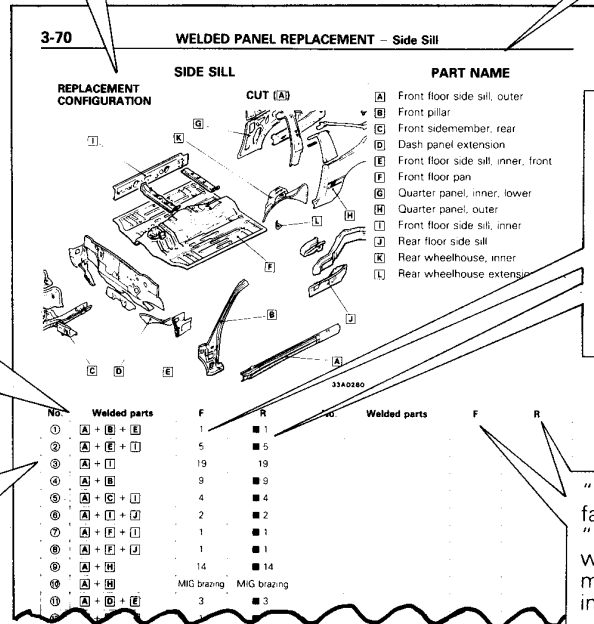
The welded components are indicated by using the designations given in the illustration.

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.

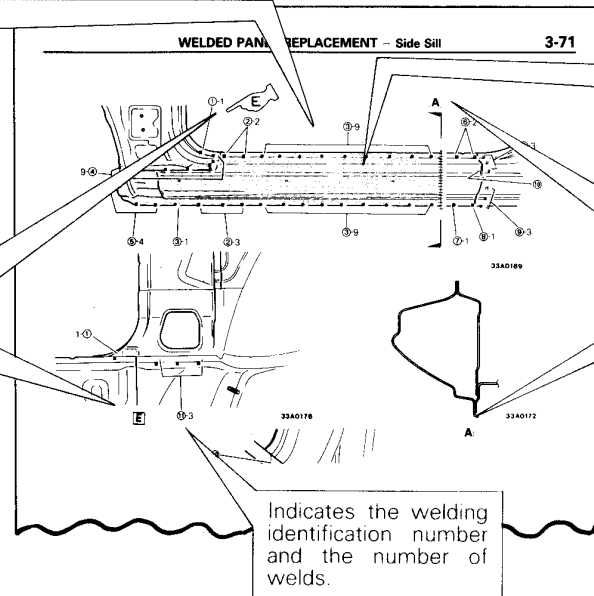


If only a number is listed, it indicates that the method is spot welding; for all other methods, both the welding method and the number of welds will be indicated. For example, “F5, R 5” indicates that the 5 spot welds made at the factory should be replaced by 5 plug welds if repairs are made.

“F” indicates the number of factory welds to be separated. “R” indicates the number of welds to be made, and the method to be used, when making repairs.

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.

Indicates a view as seen from the direction of the finger. “[E]” indicates that the view as seen from the direction of “[E]” is shown in figure [E].



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

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].

Indicates the welding identification number and the number of welds.

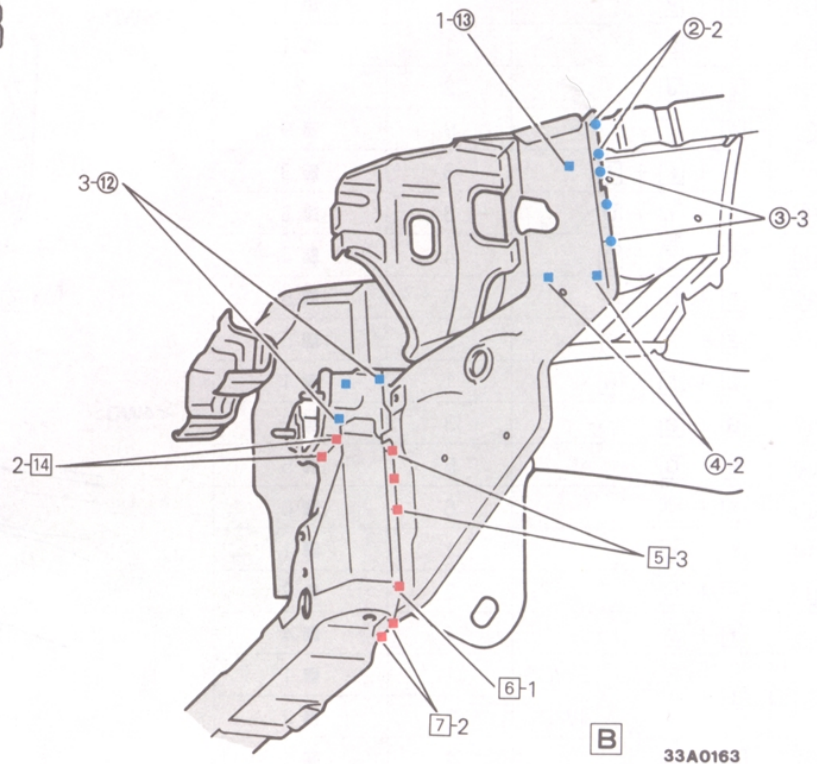
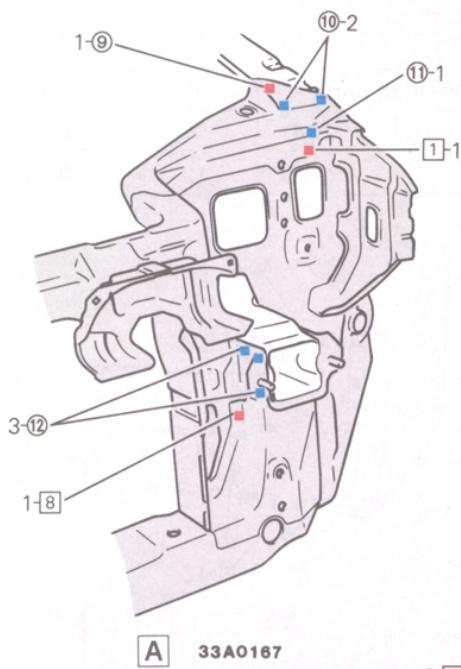
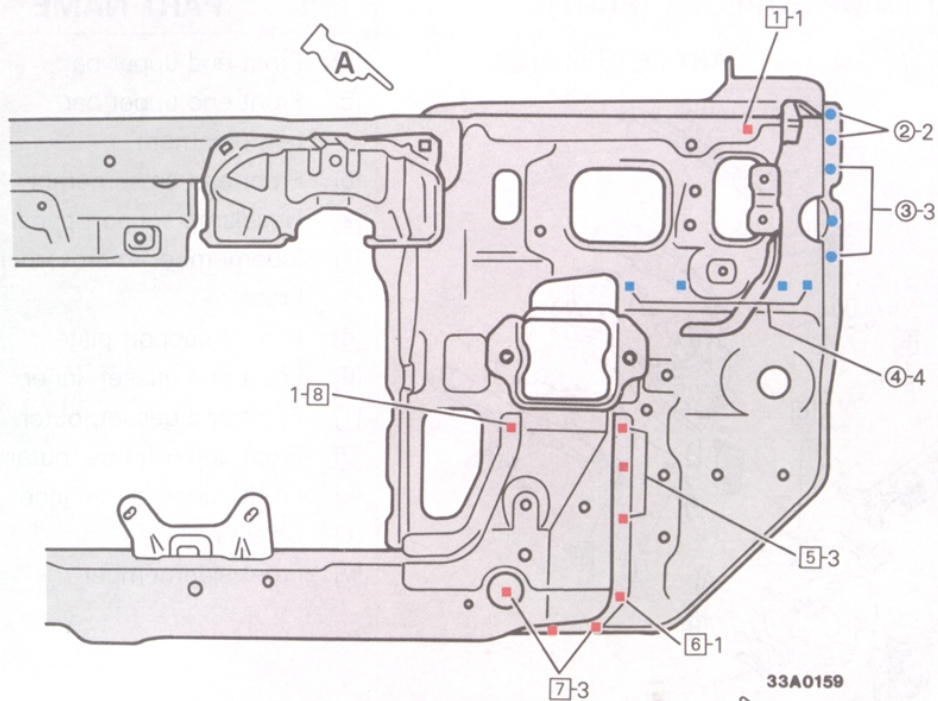
## NOTES WITH REGARD TO REPAIR WORK

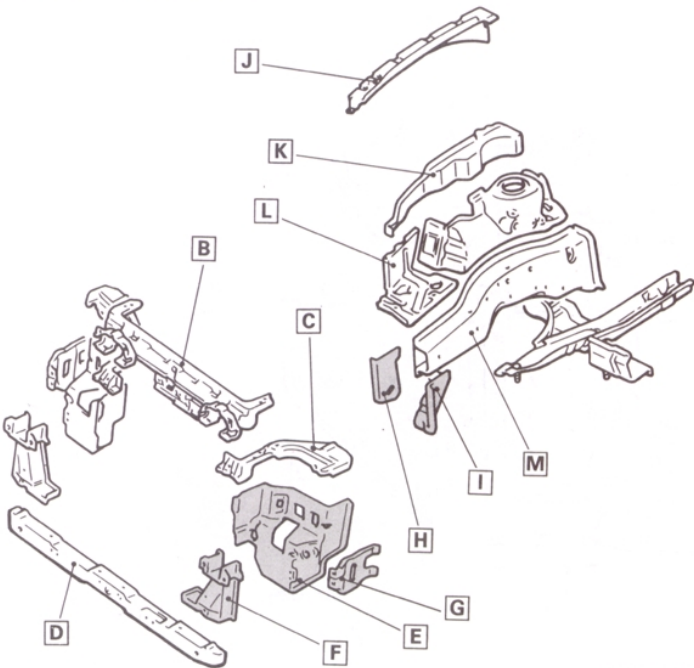
Notes with regard to repair work are given at the end of the “Welded Panel Replacement.”

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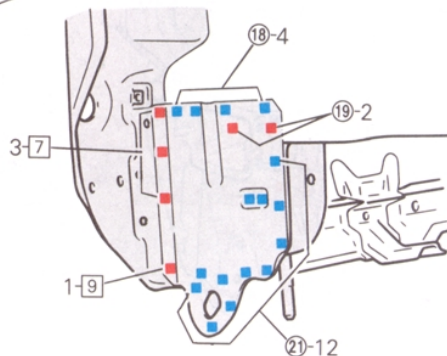
HEADLAMP SUPPORT (PART)		PART NAME
REPLACEMENT CONFIGURATION	PART (E F G H I)	
		<p><b>B</b> Front end upper bar</p> <p><b>C</b> Front end upper bar reinforcement</p> <p><b>D</b> Front end crossmember</p> <p><b>E</b> Headlamp support panel</p> <p><b>F</b> Sidemember to crossmember brace</p> <p><b>G</b> Fender support plate</p> <p><b>H</b> Front end gusset, inner</p> <p><b>I</b> Front end gusset, outer</p> <p><b>J</b> Front upper frame, outer</p> <p><b>K</b> Front upper frame, inner</p> <p><b>L</b> Shield plate</p> <p><b>M</b> Front sidemember</p>

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

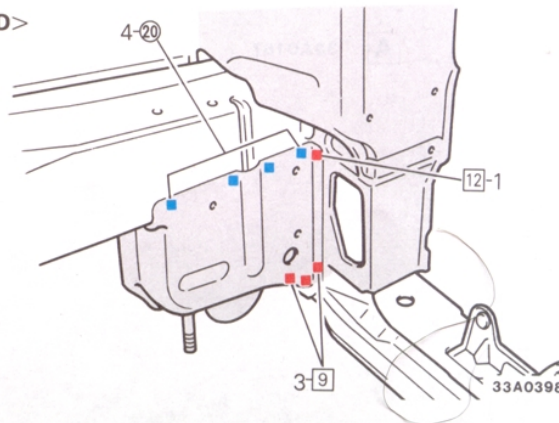
No.	Welded parts	F	R
⑳	H + I	2WD	7
		4WD	■ 12

&lt;4WD&gt;



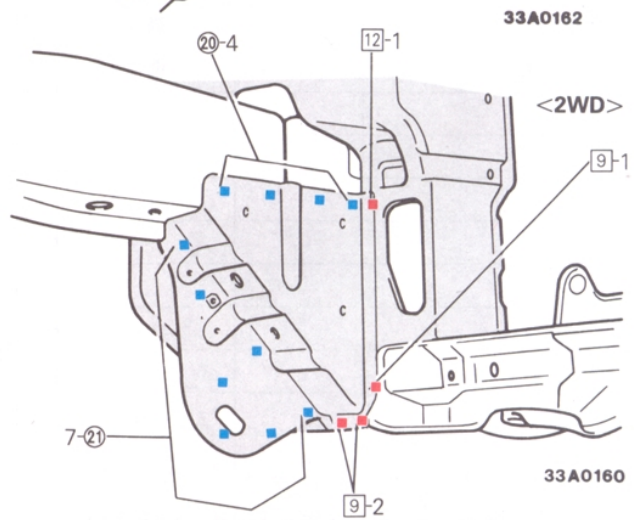
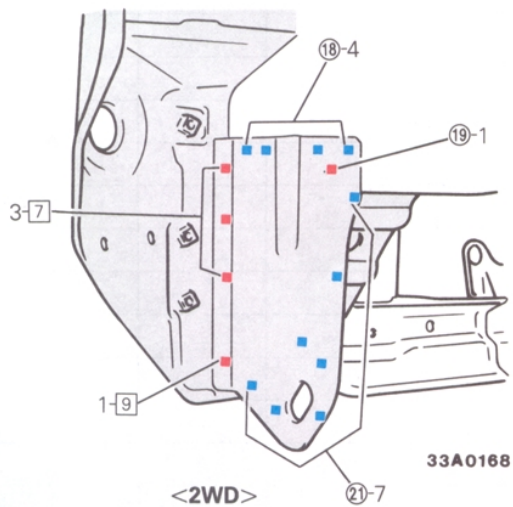
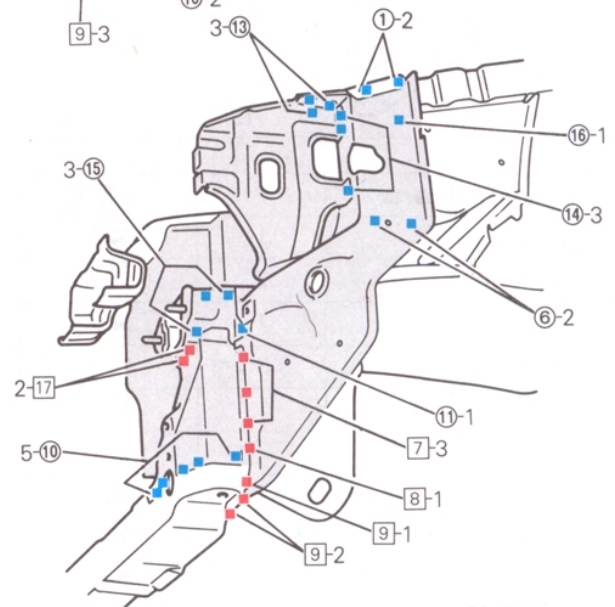
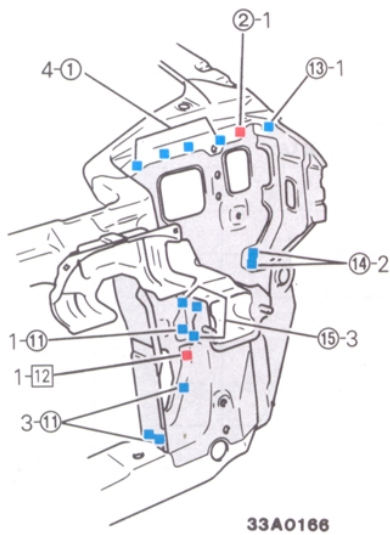
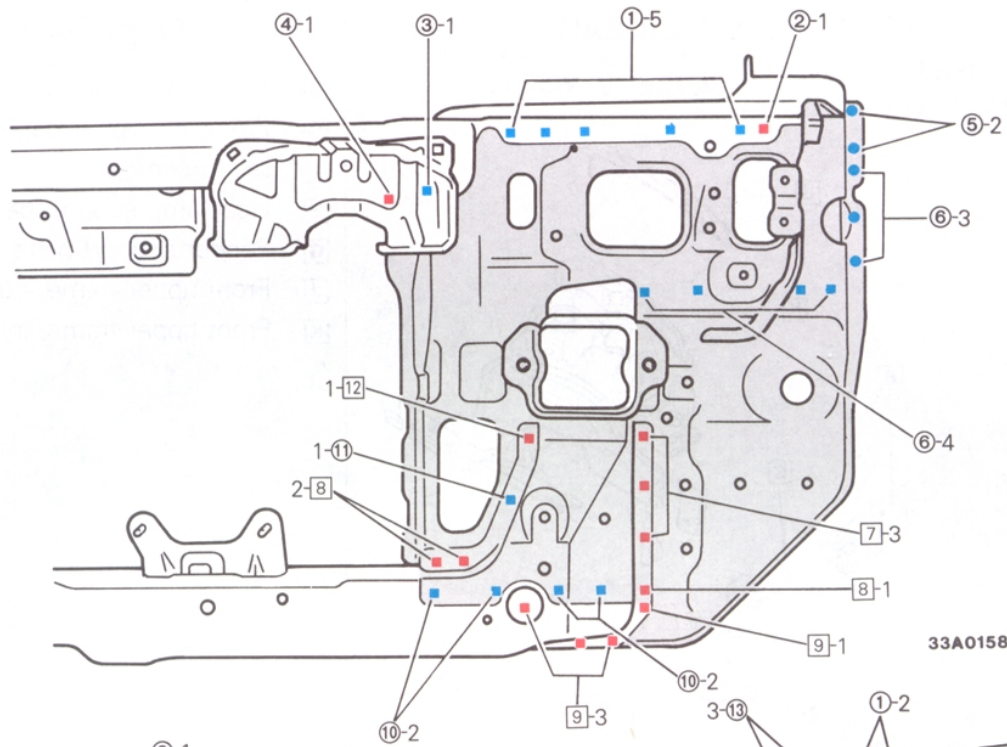
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&lt;4WD&gt;



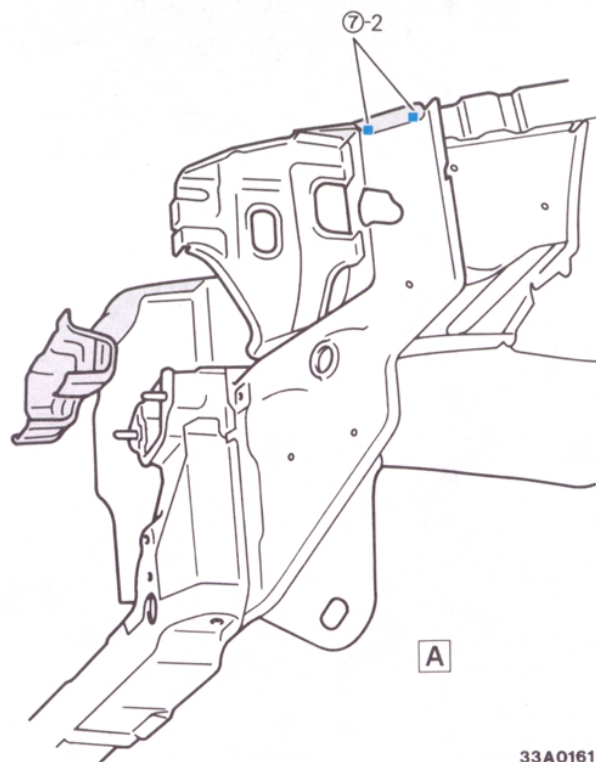
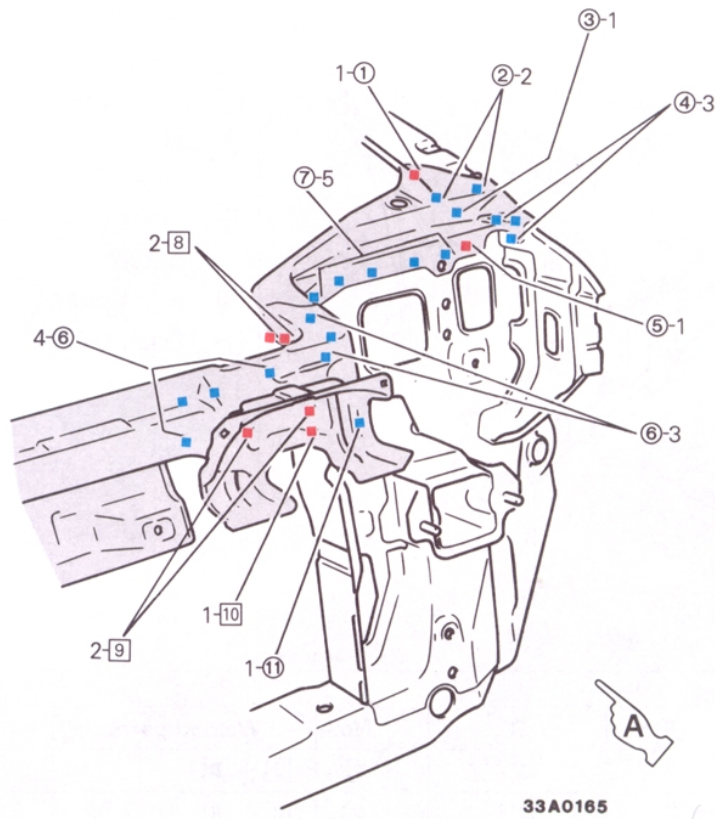
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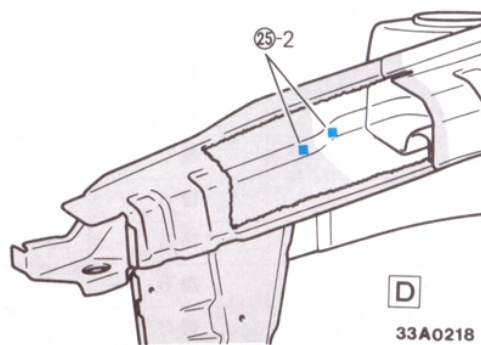
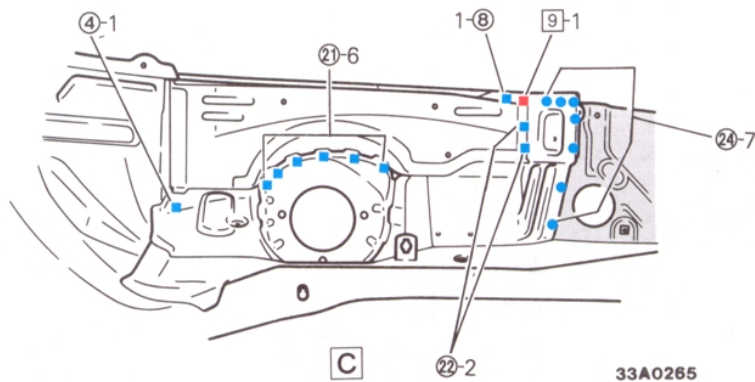
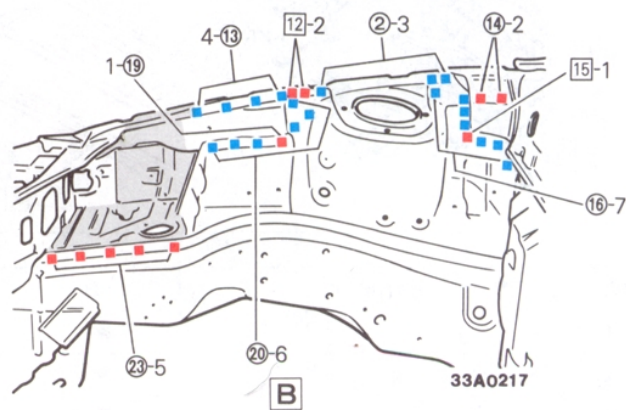
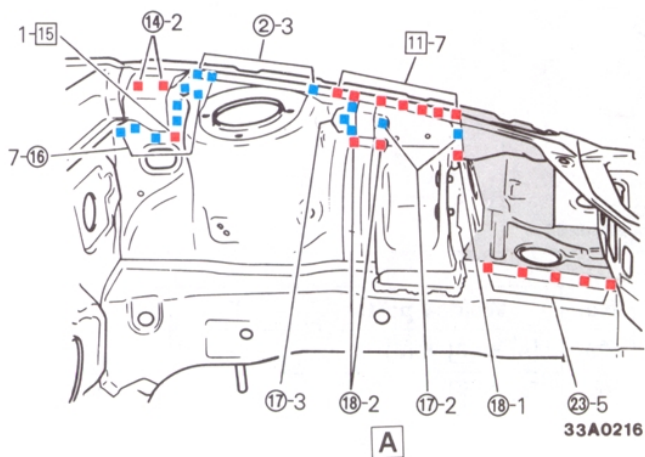
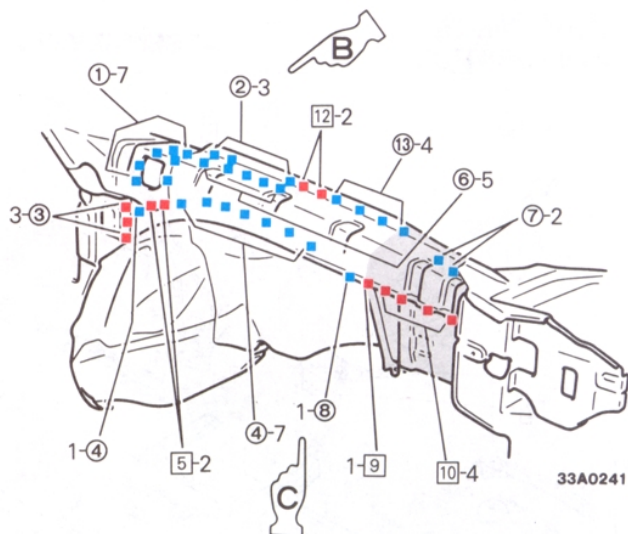
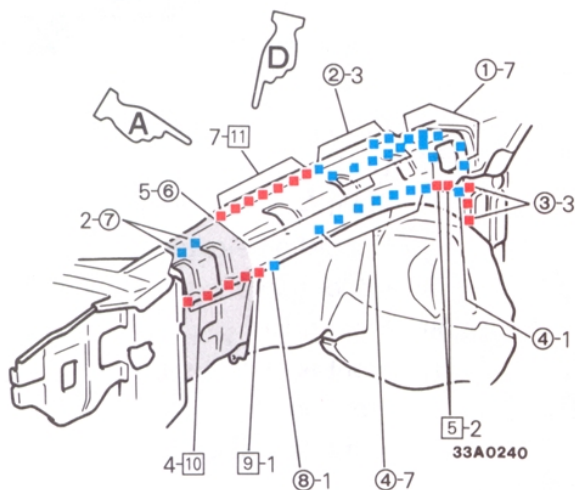
FRONT FENDER SHIELD		PART NAME
REPLACEMENT CONFIGURATION	CUT (A B C)	
		<p><b>A</b> Front upper frame, outer</p> <p><b>B</b> Front upper frame, inner</p> <p><b>C</b> Shield plate</p> <p><b>D</b> Front fender shield</p> <p><b>E</b> Front sidemember</p> <p><b>F</b> Front upper frame extension, inner</p> <p><b>G</b> Front upper frame extension, outer</p> <p><b>H</b> Front pillar</p> <p><b>I</b> Dash panel</p>

33A0284

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

[illegible]



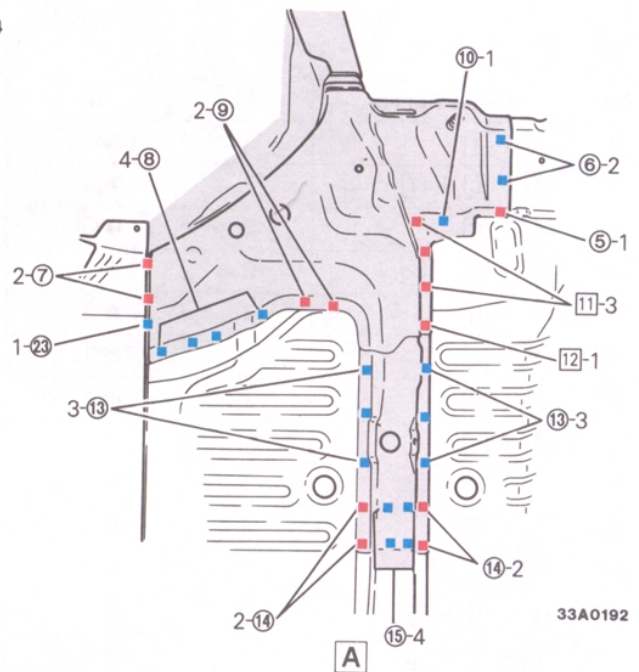
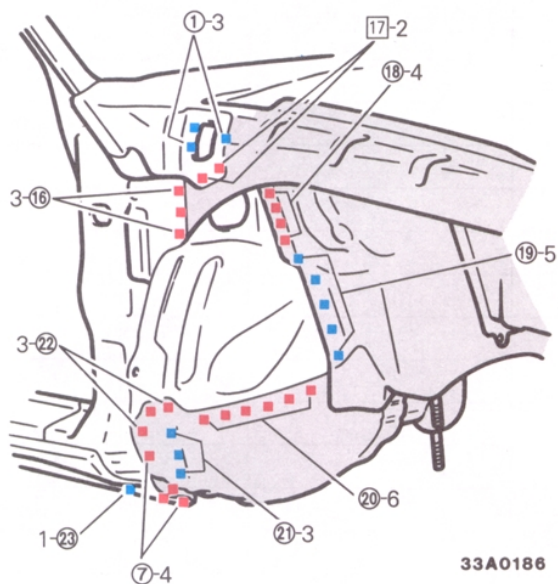
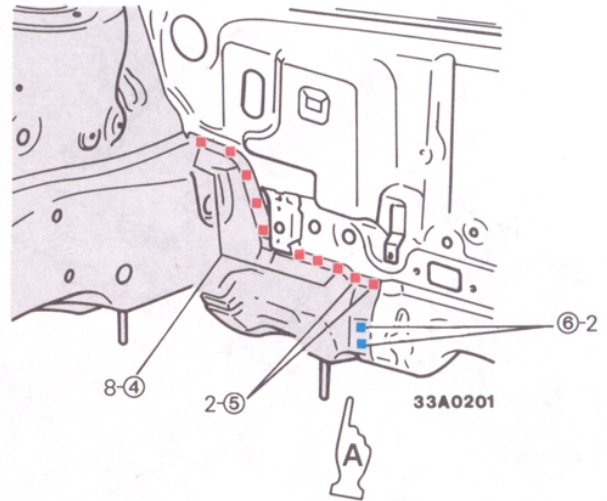
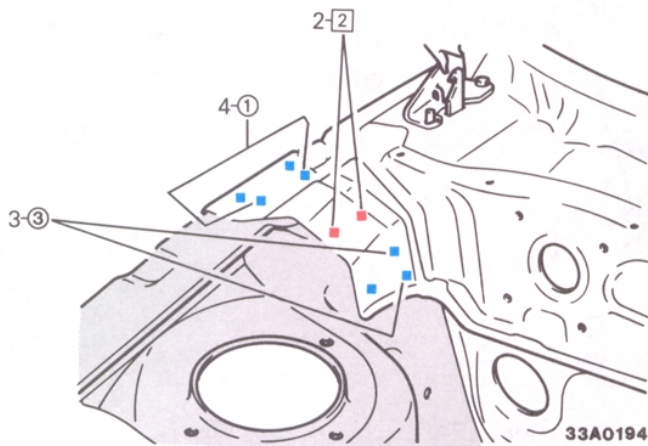


FENDER SHIELD ASSEMBLY		PART NAME
REPLACEMENT CONFIGURATION	ASSEMBLY (A)	
		<p><b>A</b> Fender shield</p> <p><b>B</b> Dash panel</p> <p><b>C</b> Dash panel crossmember</p> <p><b>D</b> Dash panel extension</p> <p><b>E</b> Front floor side sill, inner, front</p> <p><b>F</b> Upper frame extension, inner</p> <p><b>G</b> Upper frame extension, outer</p> <p><b>H</b> Front pillar</p> <p><b>I</b> Front floor side sill, outer</p> <p><b>J</b> Front floor pan</p> <p><b>K</b> Front floor sidemember</p>
		33A0285

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

[illegible]





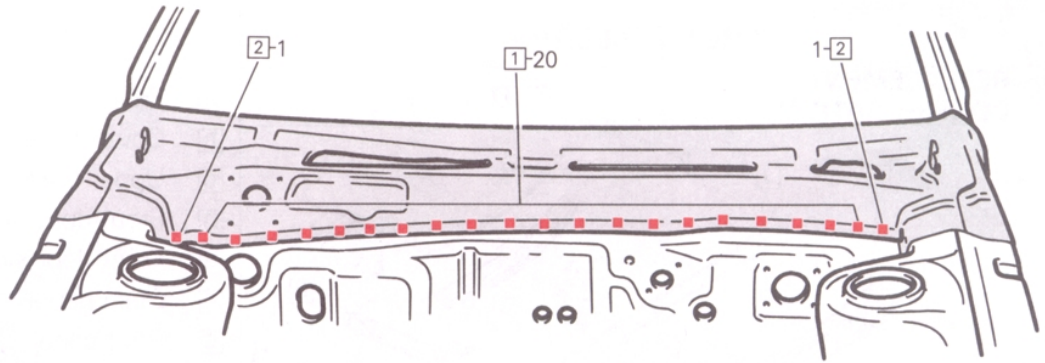
NOTE: Refer to P.3-4 for information concerning welding points with headlamp support.

FRONT DECK		PART NAME
REPLACEMENT CONFIGURATION	ASSEMBLY (A B C D E)	
<p>The diagram shows an exploded view of the front deck assembly. Components are labeled as follows: A (Cowl top panel), B (Front deck crossmember), C (Upper frame inner extension), D (Upper frame outer extension), E (Upper frame silencer), F (Front upper frame, outer), G (Front upper frame, inner), H (Strut house panel), I (Dash panel), and J (Front pillar). The parts are arranged to show their relative positions and how they fit together.</p>		<p><b>A</b> Cowl top panel</p> <p><b>B</b> Front deck crossmember</p> <p><b>C</b> Upper frame inner extension</p> <p><b>D</b> Upper frame outer extension</p> <p><b>E</b> Upper frame silencer</p> <p><b>F</b> Front upper frame, outer</p> <p><b>G</b> Front upper frame, inner</p> <p><b>H</b> Strut house panel</p> <p><b>I</b> Dash panel</p> <p><b>J</b> Front pillar</p>

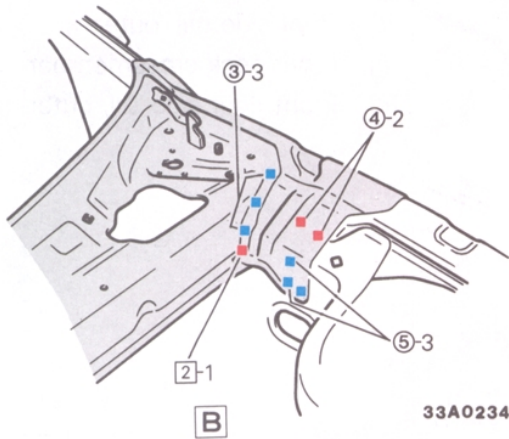
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No.	Welded parts	F	R
1	A + I	20	■ 20
2	A + C + I	1	■ 1
③	A + C	3	■ 3
④	C + F + H	2	■ 2
⑤	C + H	3	■ 3
⑥	A + D	1	■ 1
7	A + D	1	■ 1
8	A + J	1	■ 1
⑨	A + J	3	■ 3
⑩	A + D	4	■ 4
11	A + J	2	■ 2
12	A + D + J	2	■ 2
⑬	D + F + G	2	■ 2
14	D + F	7	■ 7
15	A + J	MIG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

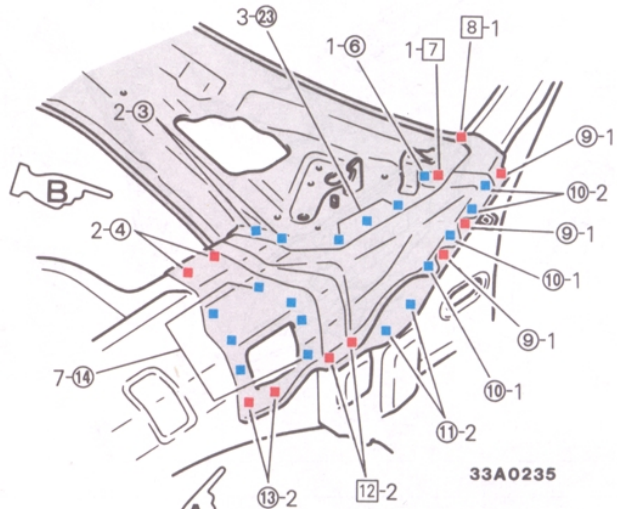
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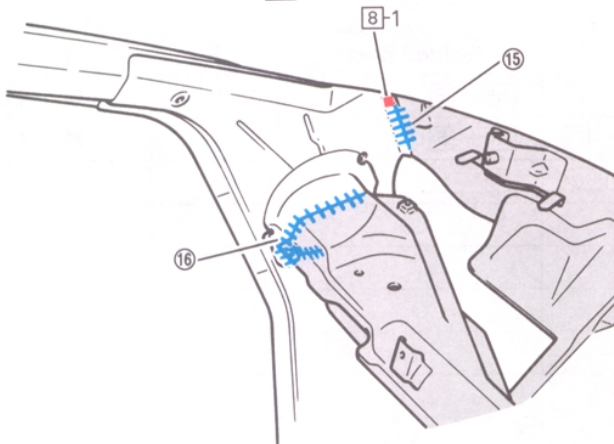
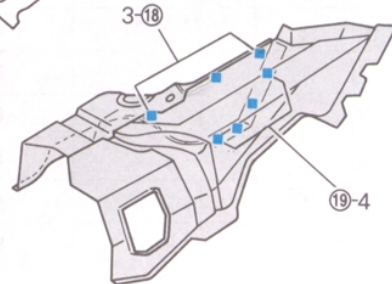
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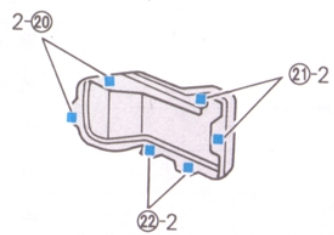
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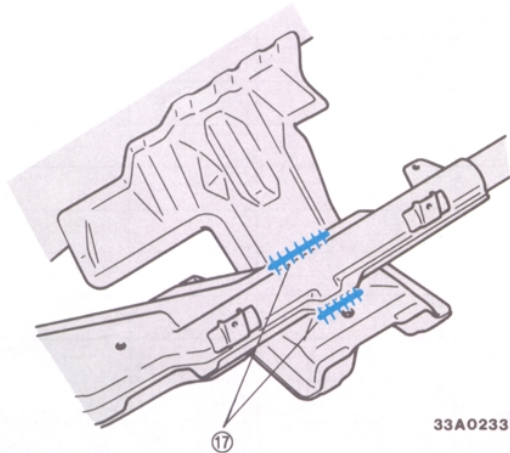
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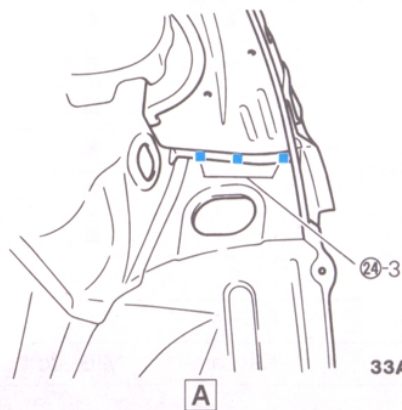
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33A0207



33A0233



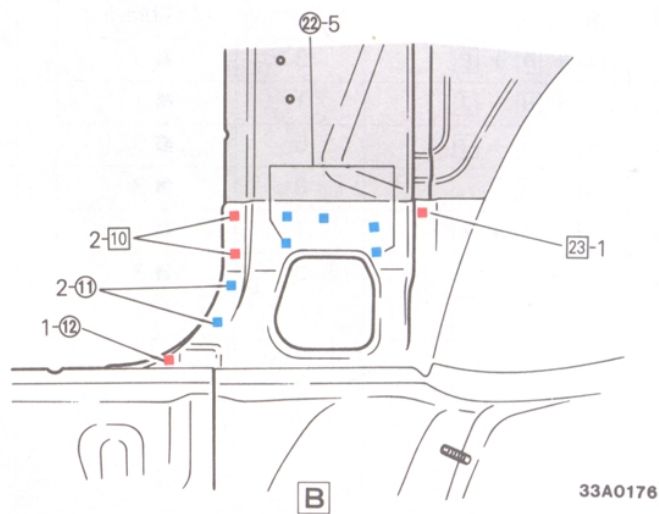
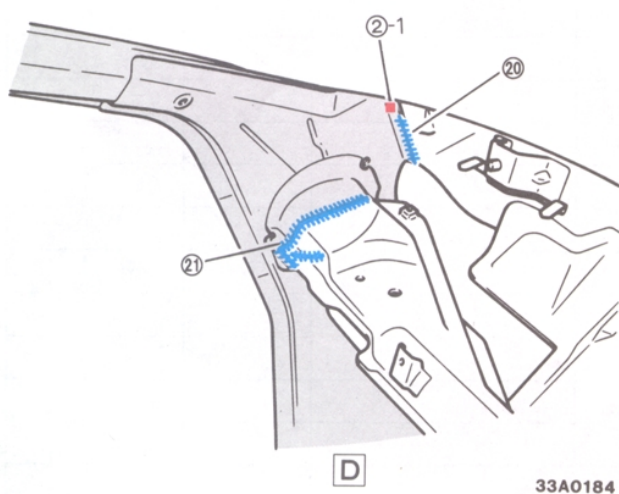
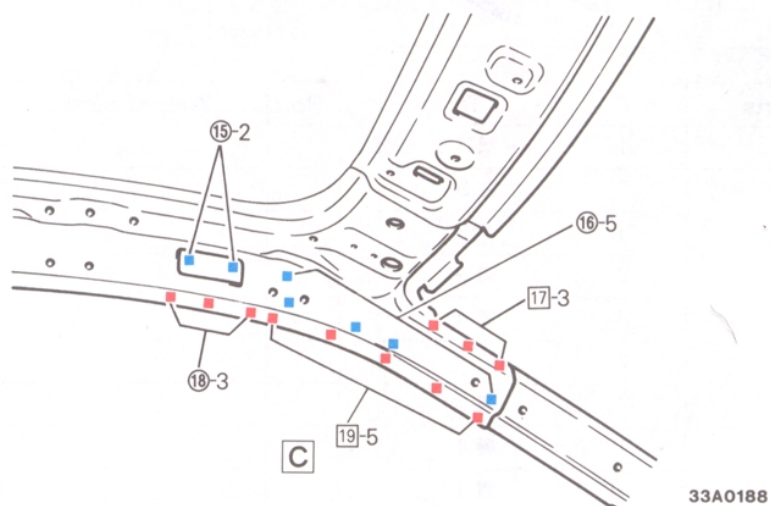
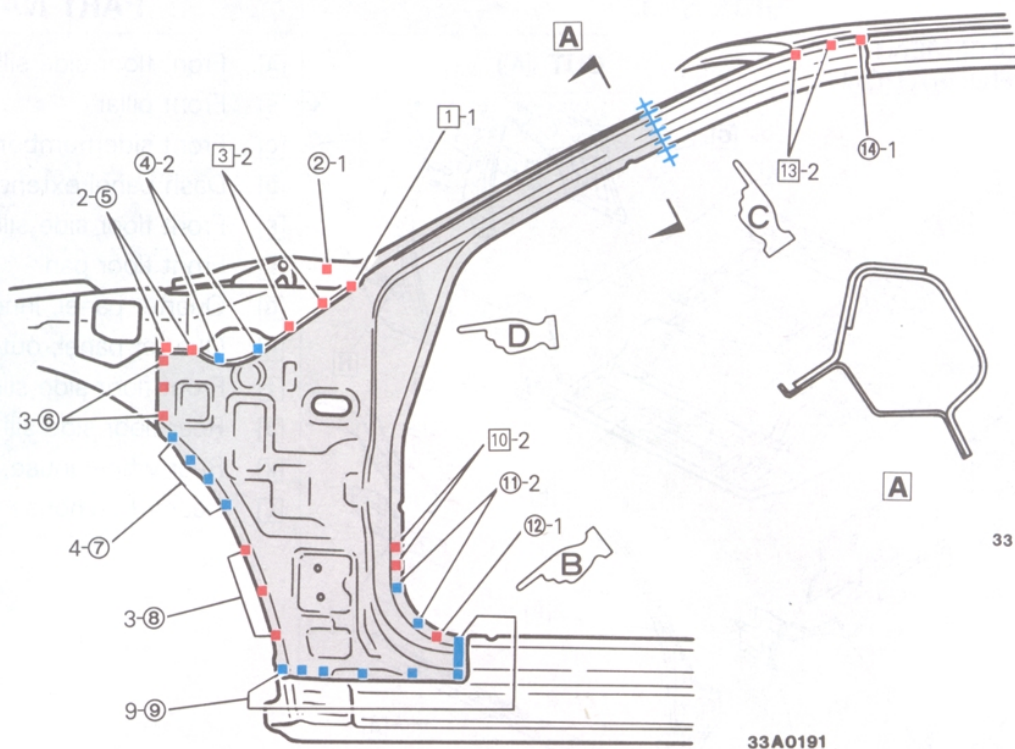
33A0231

FRONT PILLAR		PART NAME
REPLACEMENT CONFIGURATION	CUT (A)	
<p>The diagram shows an exploded view of the front pillar assembly. Part A is the front pillar itself. Other parts include the cowl top panel (B), upper frame extension (C), front upper frame (D), front floor side sill (E), dash panel (F), roof panel (G), roof side rails (H and I), front deck crossmember (J), and another front floor side sill (K). The diagram illustrates how these components fit together to form the front pillar structure.</p>		<p><b>A</b> Front pillar</p> <p><b>B</b> Cowl top panel</p> <p><b>C</b> Upper frame extension, outer</p> <p><b>D</b> Front upper frame, outer</p> <p><b>E</b> Front floor side sill, inner, front</p> <p><b>F</b> Dash panel</p> <p><b>G</b> Roof panel</p> <p><b>H</b> Roof side rail, inner</p> <p><b>I</b> Roof side rail, outer</p> <p><b>J</b> Front deck crossmember</p> <p><b>K</b> Front floor side sill, outer</p>

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

[illegible]



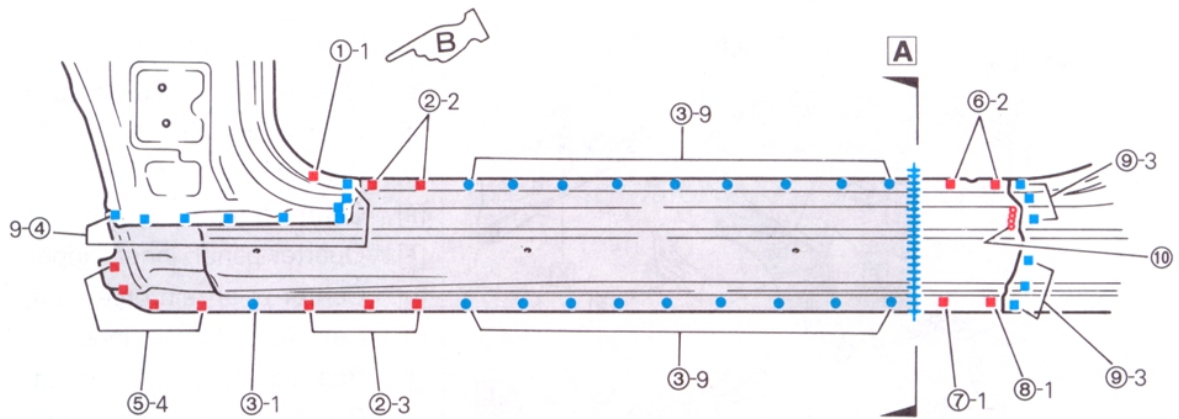


SIDE SILL		PART NAME
REPLACEMENT CONFIGURATION	CUT (A)	
		<p><b>A</b> Front floor side sill, outer</p> <p><b>B</b> Front pillar</p> <p><b>C</b> Front sidemember, rear</p> <p><b>D</b> Dash panel extension</p> <p><b>E</b> Front floor side sill, inner, front</p> <p><b>F</b> Front floor pan</p> <p><b>G</b>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

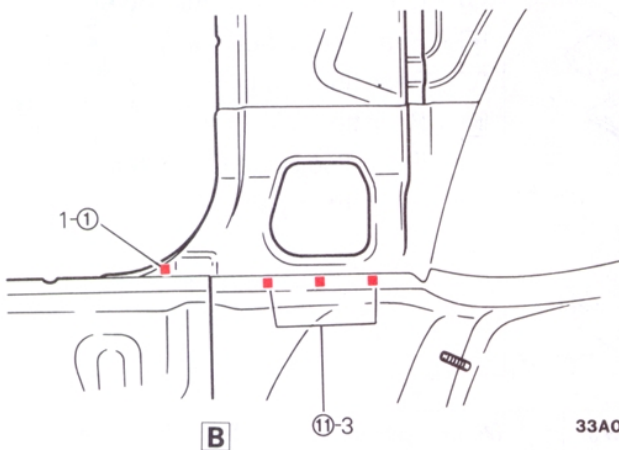
33A0280

No.	Welded parts	F	R
①	<b>A</b> + <b>B</b> + <b>E</b>	1	■ 1
②	<b>A</b> + <b>E</b> + <b>I</b>	5	■ 5
③	<b>A</b> + <b>I</b>	19	19
④	<b>A</b> + <b>B</b>	9	■ 9
⑤	<b>A</b> + <b>C</b> + <b>I</b>	4	■ 4
⑥	<b>A</b> + <b>I</b> + <b>J</b>	2	■ 2
⑦	<b>A</b> + <b>F</b> + <b>I</b>	1	■ 1
⑧	<b>A</b> + <b>F</b> + <b>J</b>	1	■ 1
⑨	<b>A</b> + <b>H</b>	14	■ 14
⑩	<b>A</b> + <b>H</b>	MIG brazing	MIG brazing
⑪	<b>A</b> + <b>D</b> + <b>E</b>	3	■ 3
⑫	<b>A</b> + <b>H</b> + <b>J</b>	1	■ 1
⑬	<b>A</b> + <b>G</b> + <b>J</b>	5	■ 5
⑭	<b>A</b> + <b>G</b>	3	■ 3
⑮	<b>A</b> + <b>G</b> + <b>K</b>	1	■ 1
⑯	<b>A</b> + <b>L</b>	3	■ 3

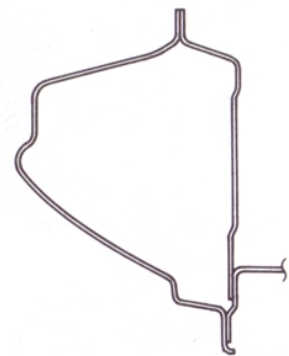
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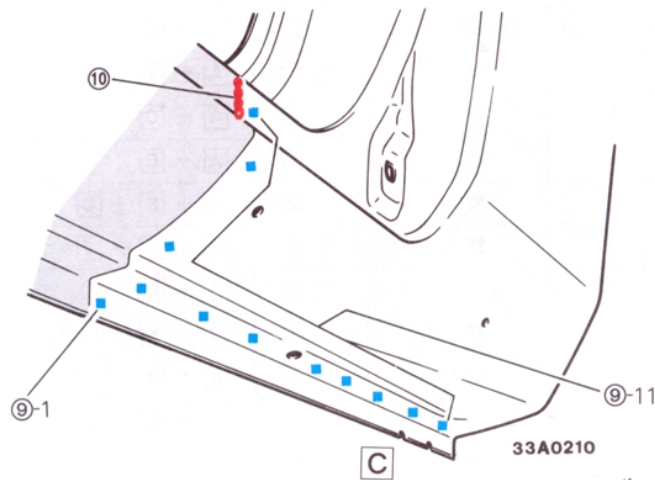
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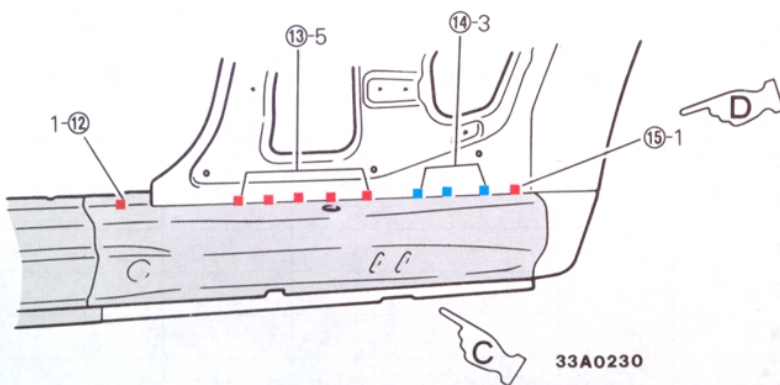
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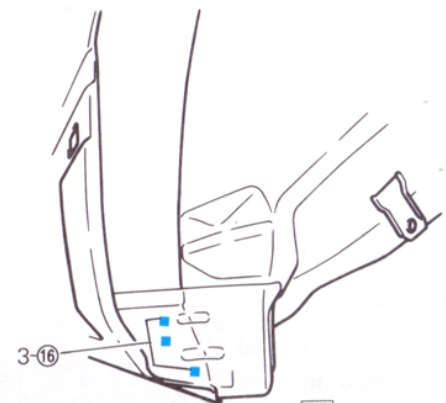
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33A0210



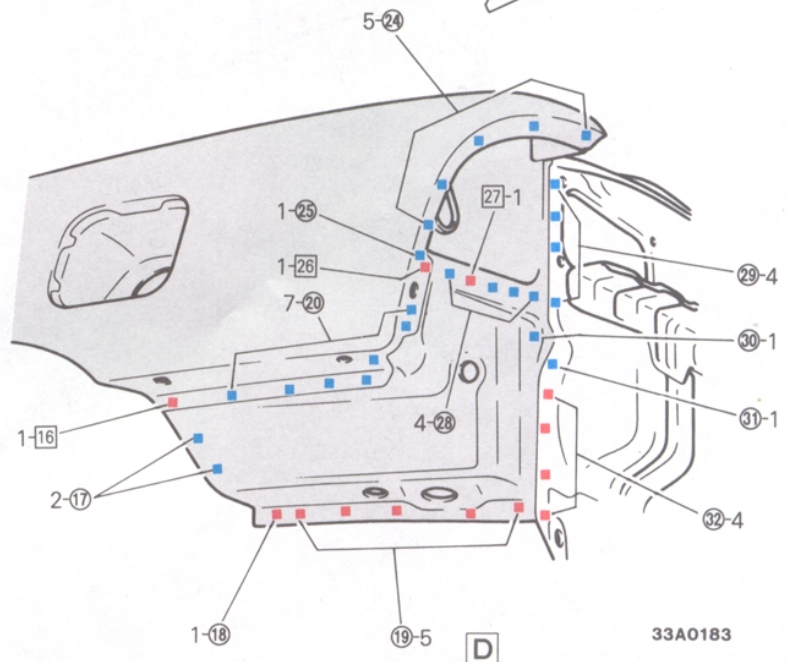
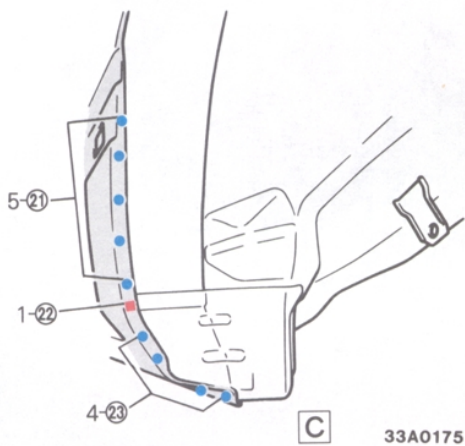
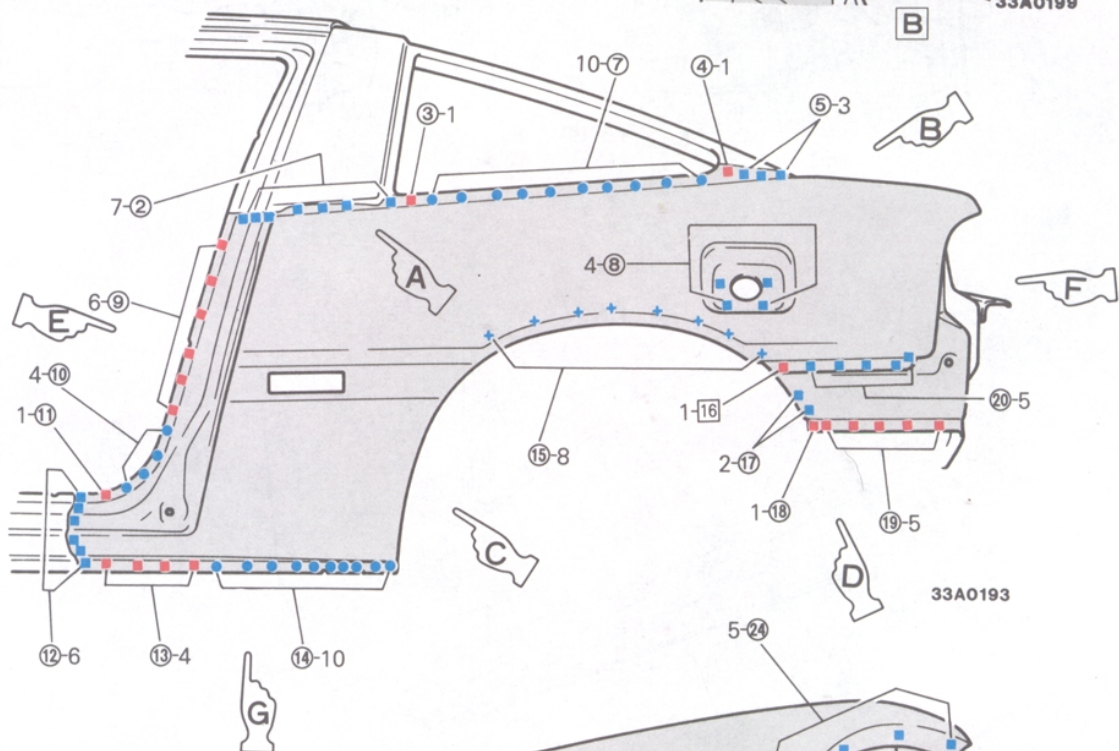
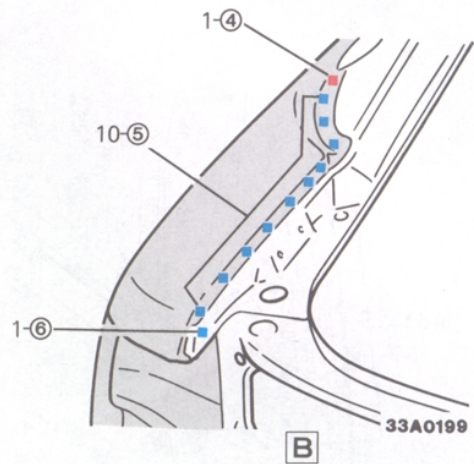
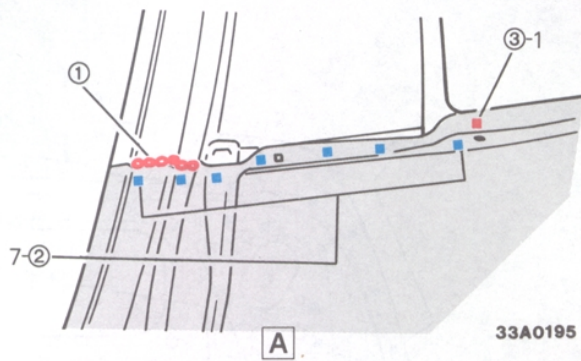
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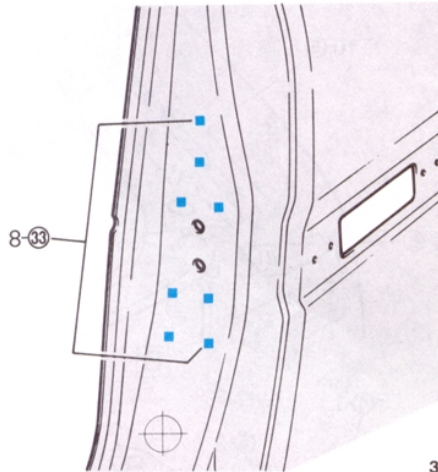


33A0209

33A0287[illegible]

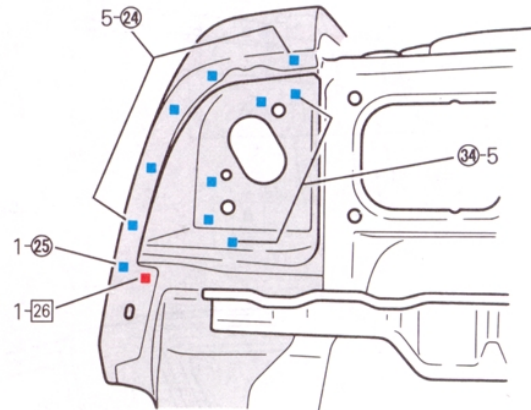






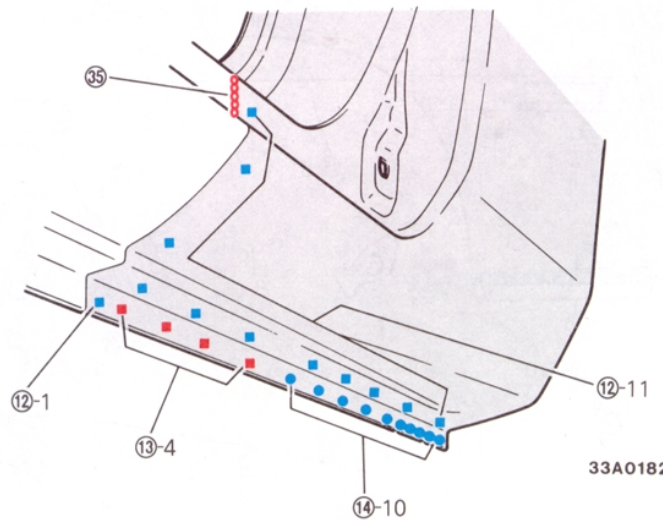
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E



33A0177

F



33A0182

G

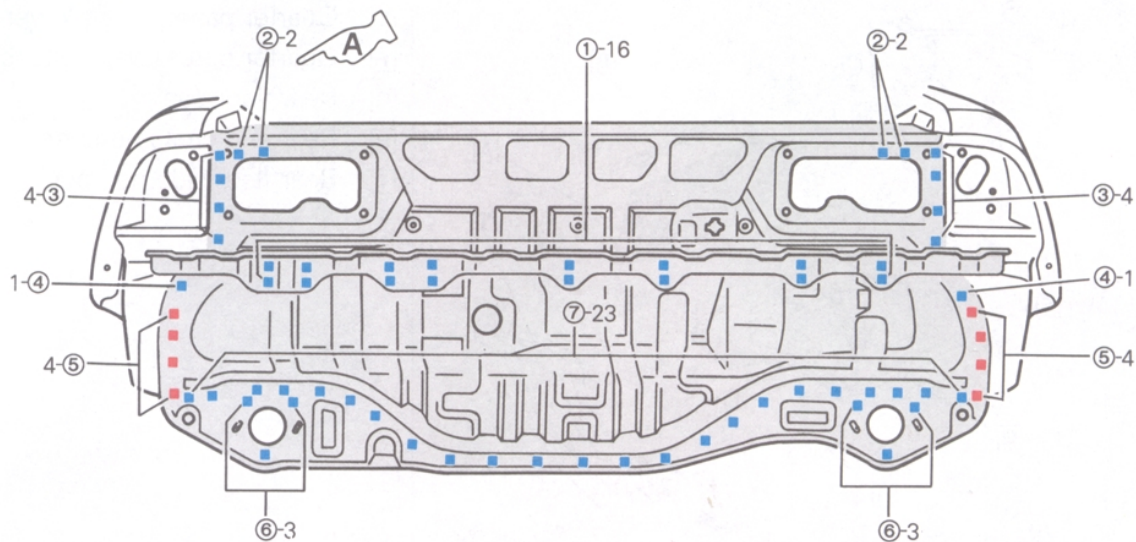
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**NOTES**

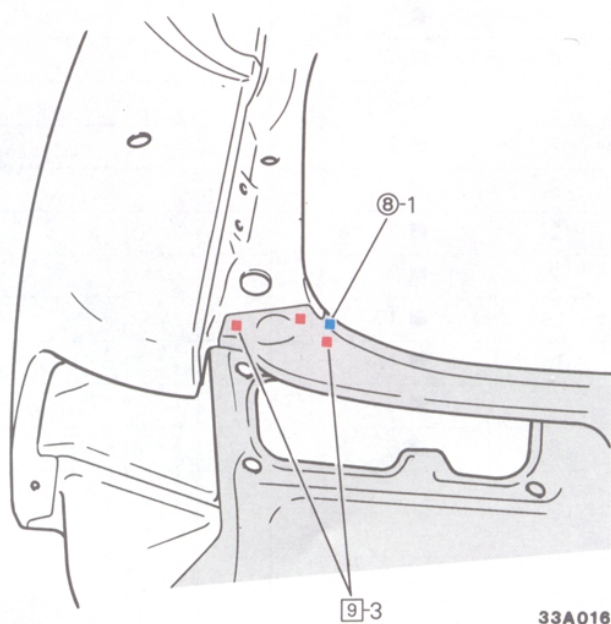
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[illegible]





33A0157

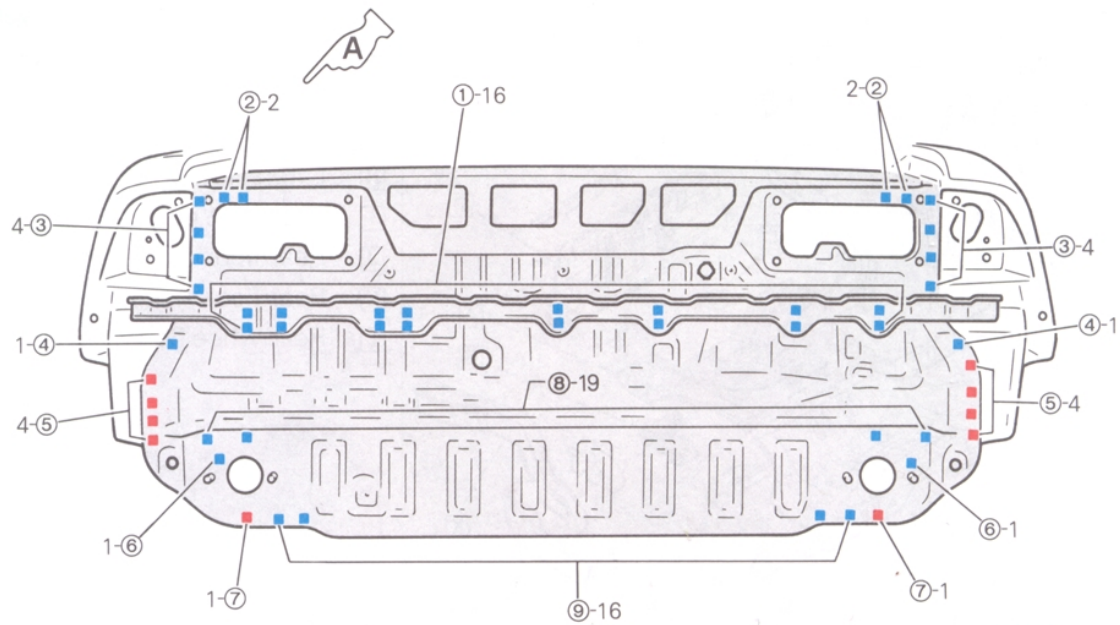


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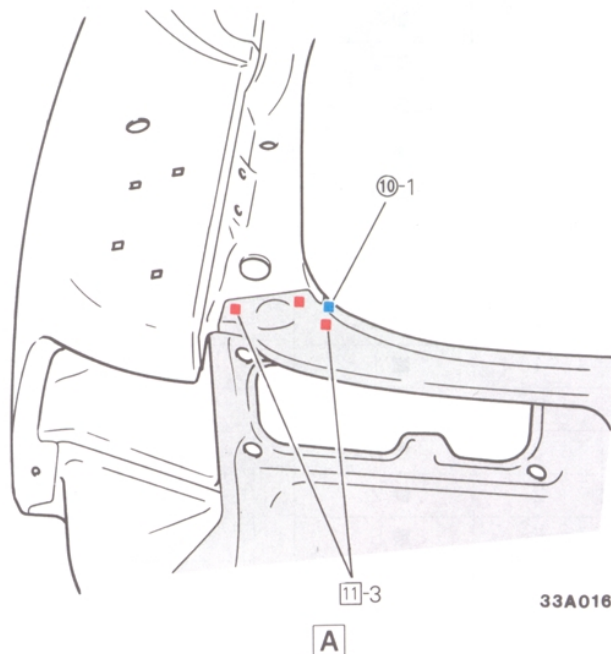
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**33A0419**

[illegible]



33A0386

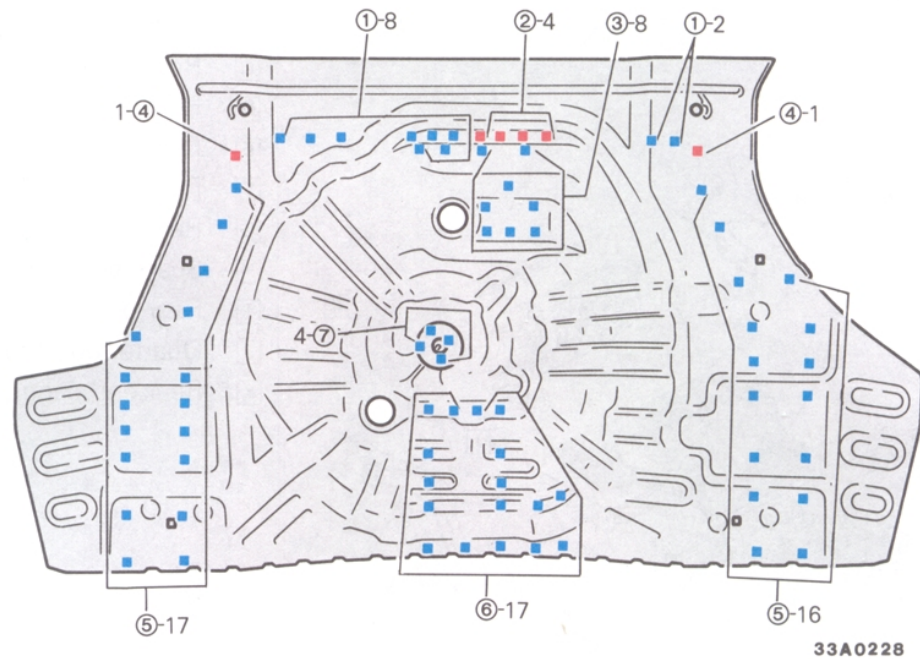


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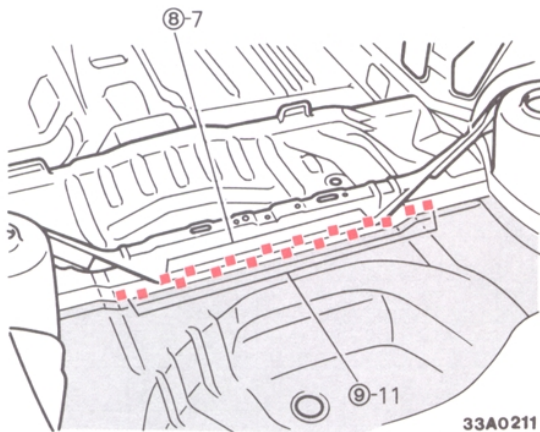
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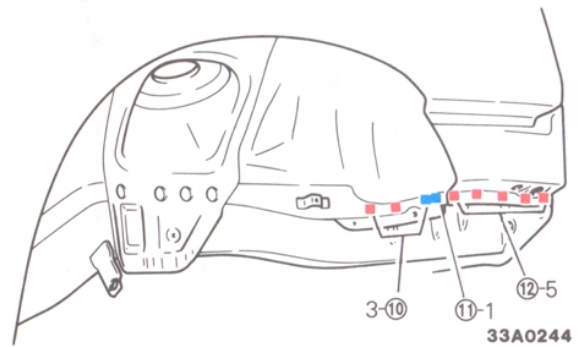




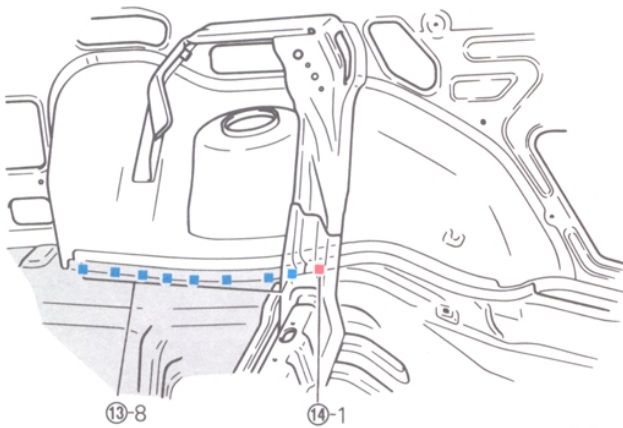
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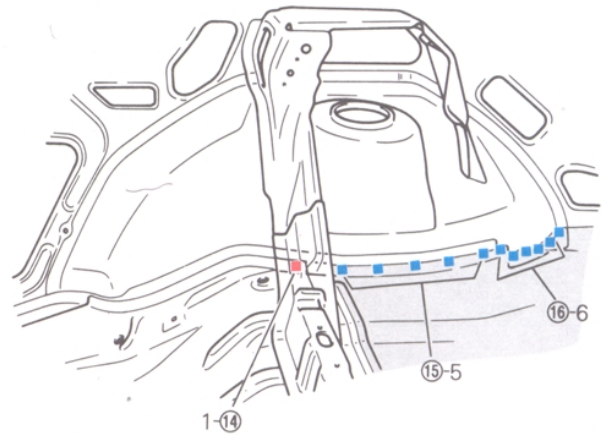
33A0211



33A0244



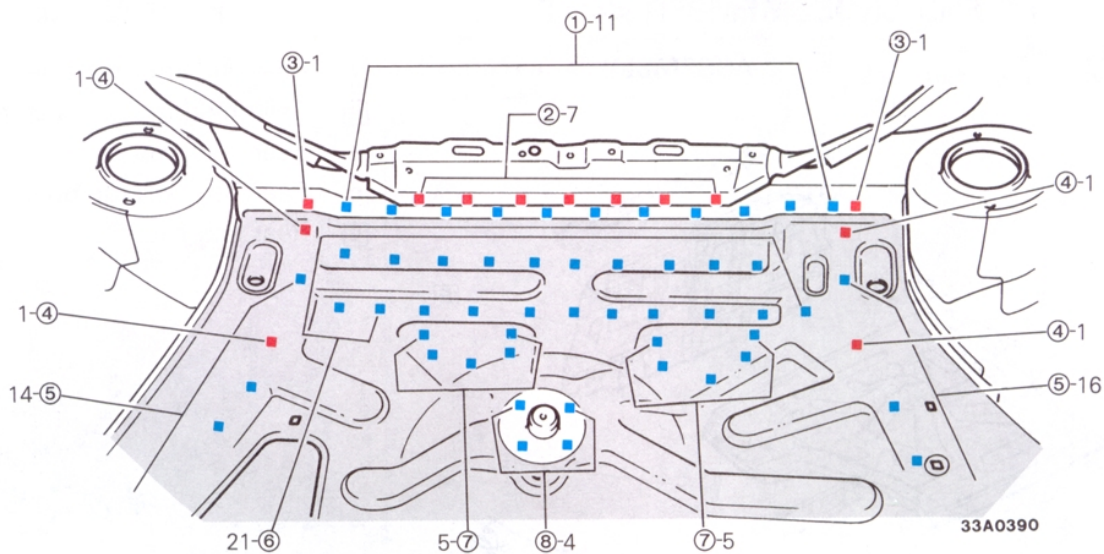
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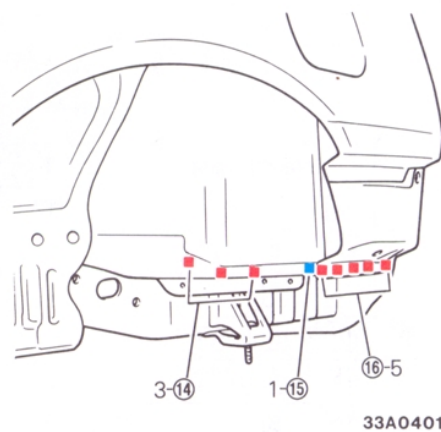
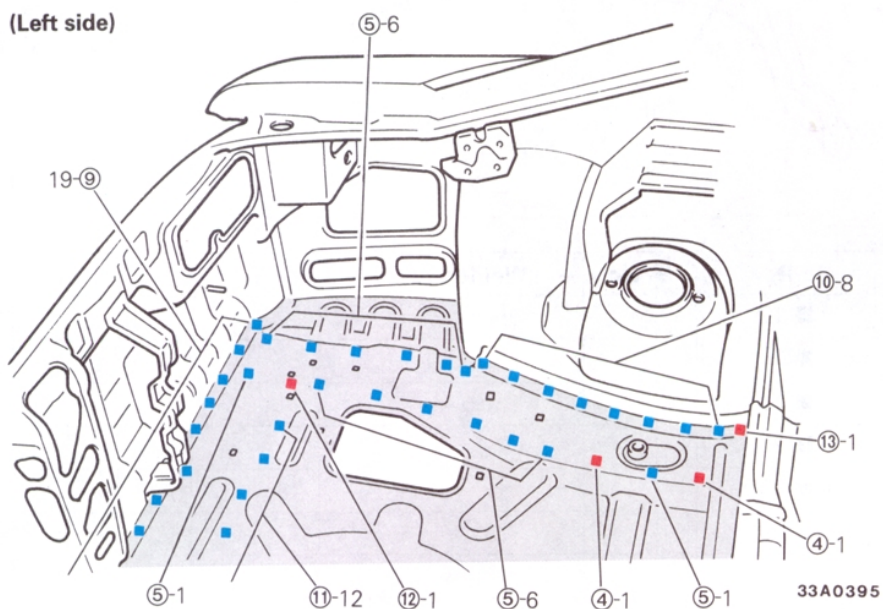
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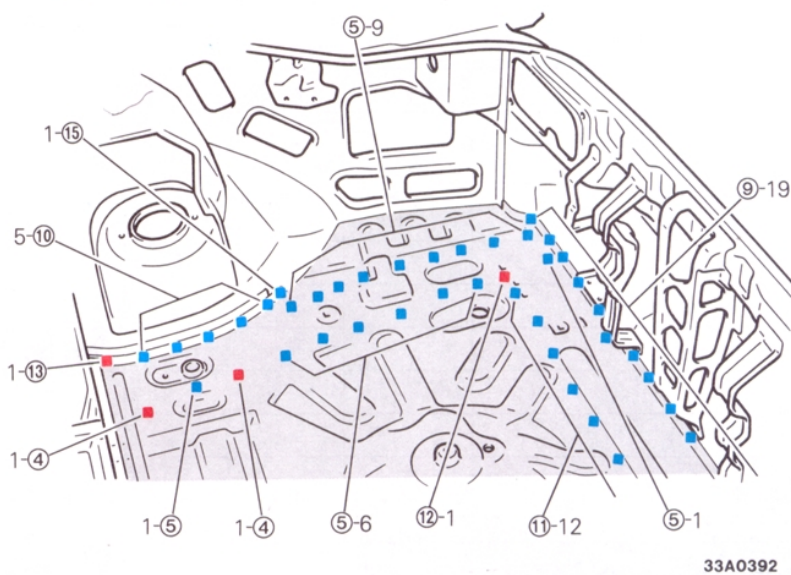
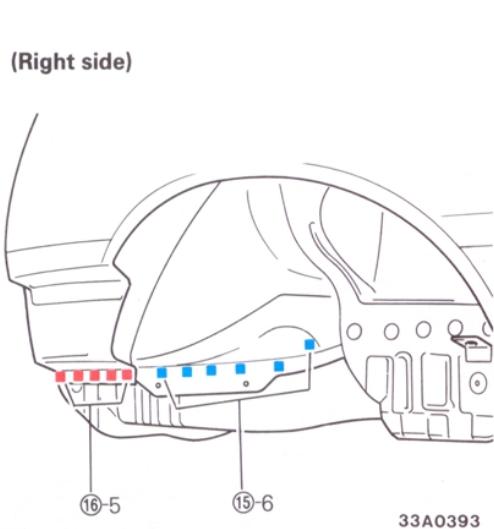
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(Left side)



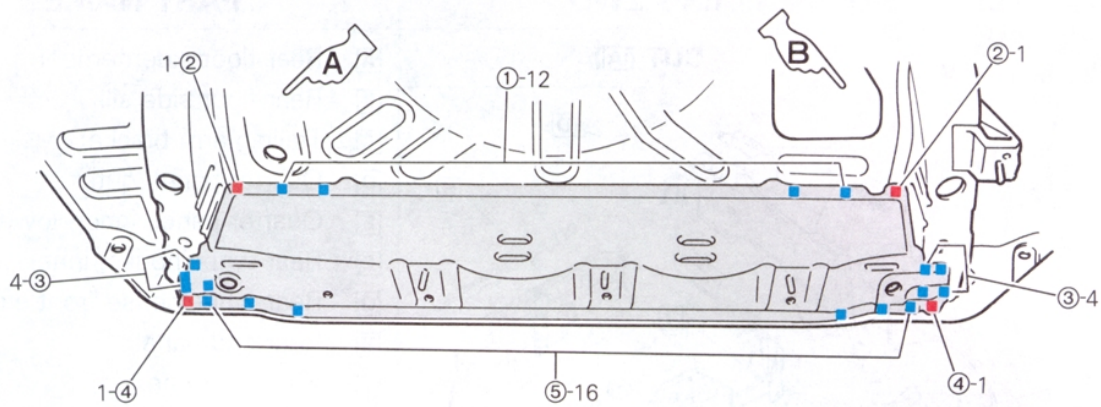
(Right side)



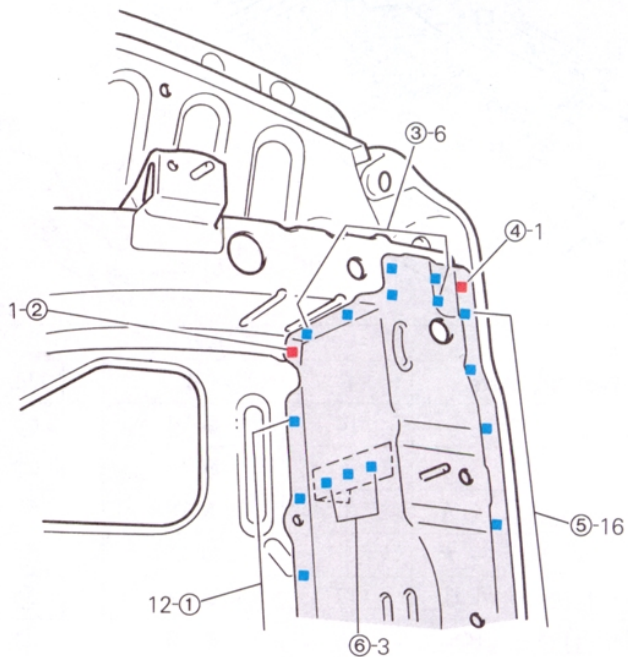
REAR END CROSSMEMBER <4WD>		PART NAME
REPLACEMENT CONFIGURATION	ASSEMBLY (A) (B)	<p>(A) Rear end crossmember</p> <p>(B) Child restraint reinforcement</p> <p>(C) Rear floor pan</p> <p>(D) Rear floor sidemember</p> <p>(E) Rear end panel</p>
33A0418		

[illegible][illegible]





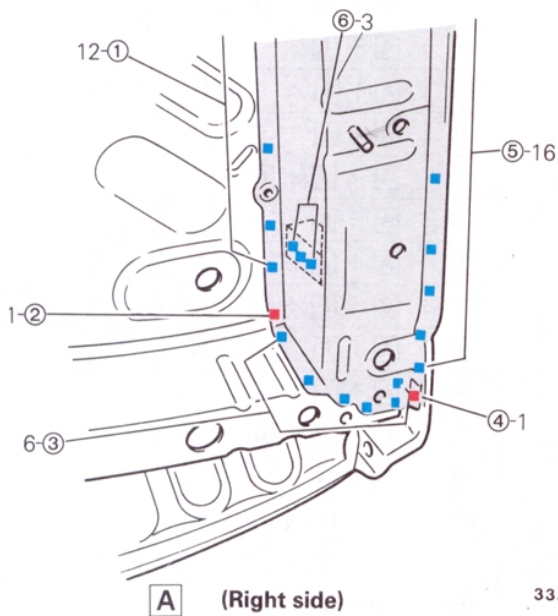
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33A0383

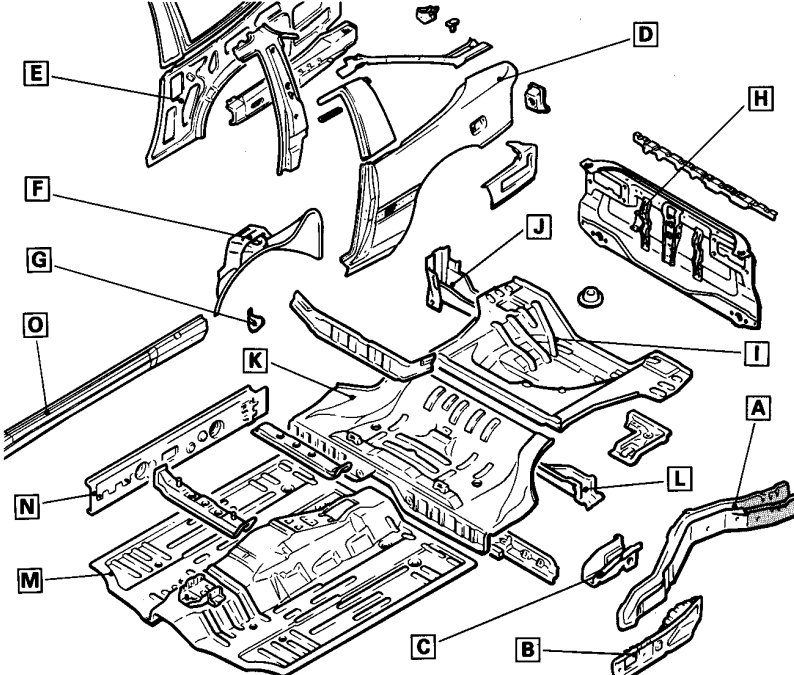
(Left side)

**B**



**A** (Right side)

33A0399

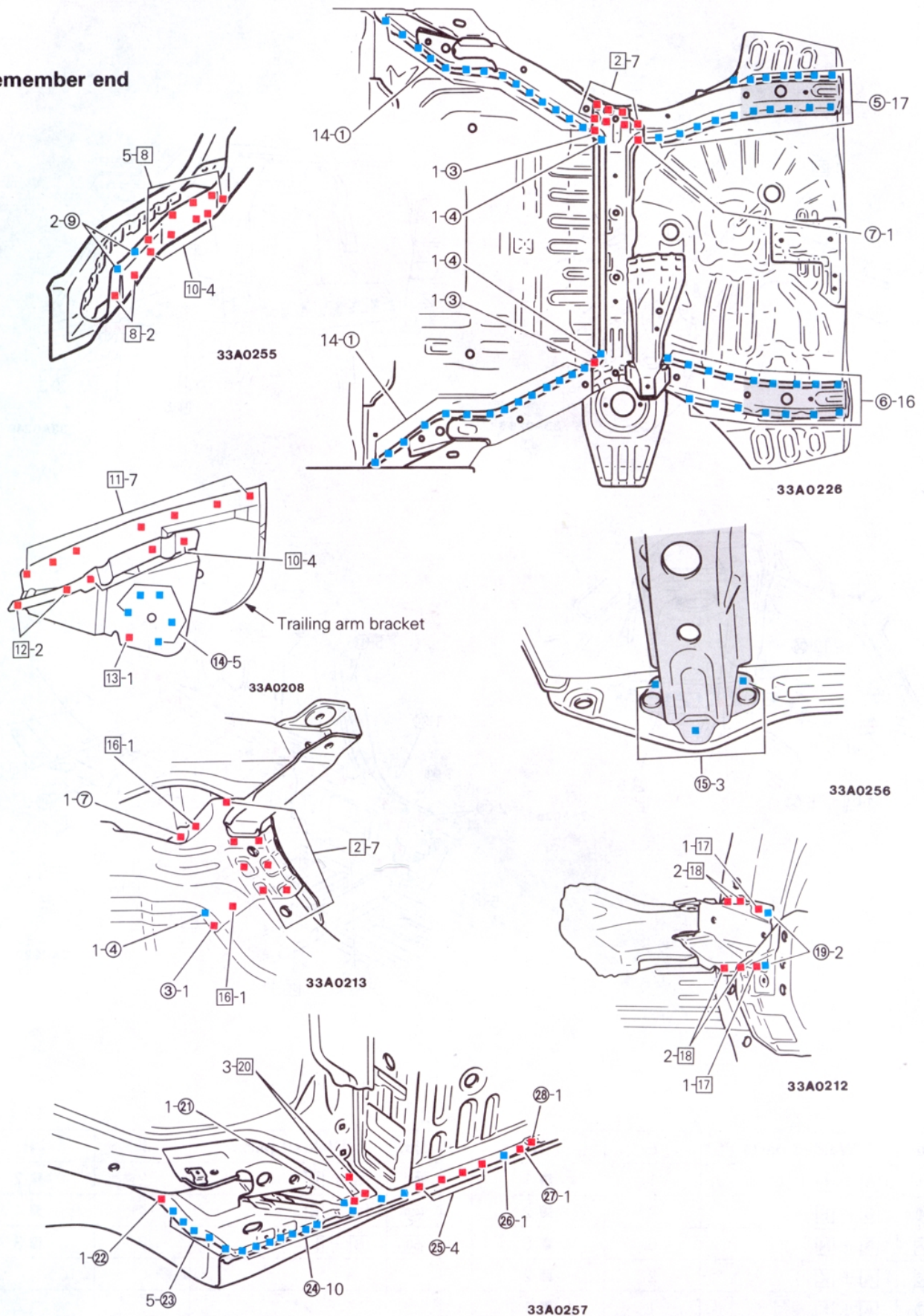
REAR FLOOR SIDEMEMBER <2WD>		PART NAME
REPLACEMENT CONFIGURATION	CUT (A)	
		<b>A</b> Rear floor sidemember <b>B</b> Rear floor side sill <b>C</b> Trailing arm bracket <b>D</b> Quarter panel, outer <b>E</b> Quarter panel, inner, lower <b>F</b> Rear wheelhouse, inner <b>G</b> Rear wheelhouse front extension <b>H</b> Rear end panel <b>I</b> Rear floor pan <b>J</b> Lateral rod bracket <b>K</b> Rear seat pan <b>L</b> Rear floor crossmember, lower <b>M</b> Front floor pan <b>N</b> Front floor side sill, inner <b>O</b> Front floor side sill, outer

33A0275

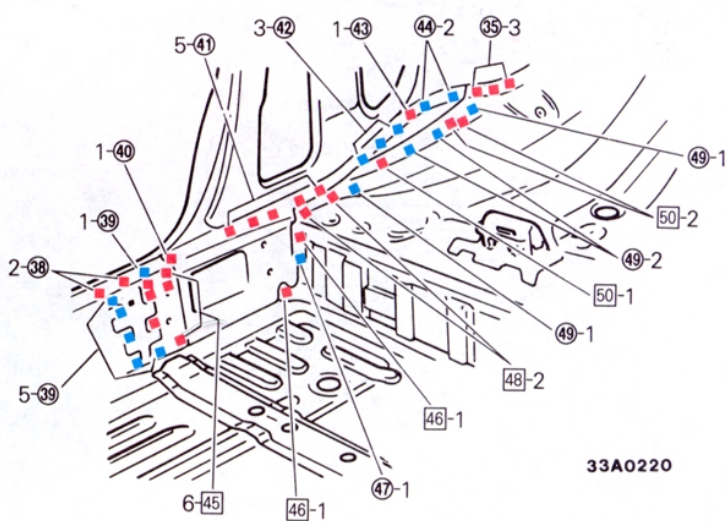
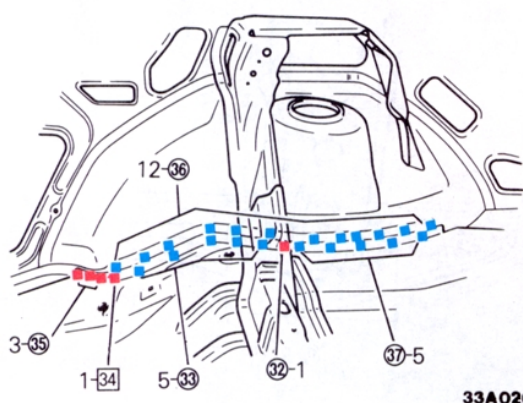
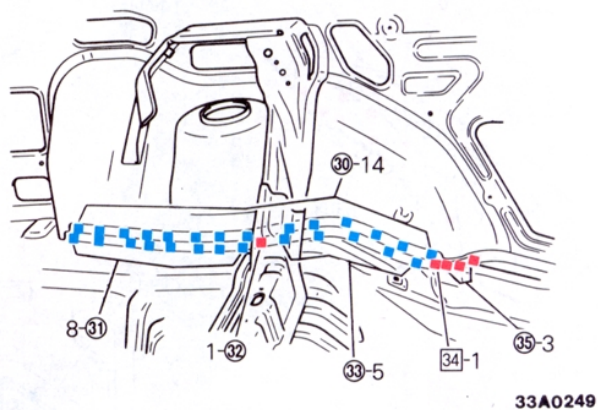
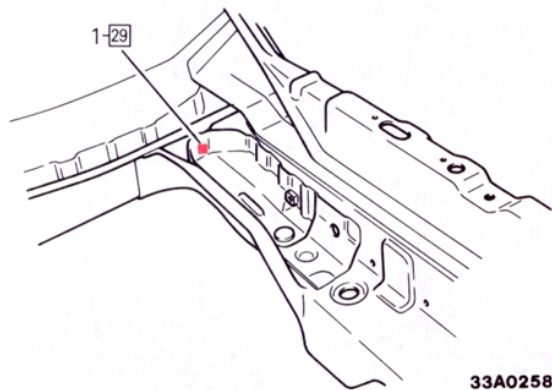
No.	Welded parts	F	R
①	<b>A</b> + <b>K</b>	14	■ 14
②	<b>A</b> + <b>L</b>	7	■ 7
③	<b>A</b> + <b>K</b> + <b>L</b> ★	1	■ 1
④	<b>A</b> + <b>L</b> ★	1	■ 1
⑤	<b>A</b> + <b>I</b> L.H.	17	■ 17
⑥	<b>A</b> + <b>I</b> R.H.	16	■ 16
⑦	<b>A</b> + <b>I</b> + <b>L</b> ★	1	■ 1
⑧	<b>A</b> + <b>B</b>	7	■ 7
⑨	<b>A</b> +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

No.	Welded parts	F	R
㉒	<b>B</b> + <b>F</b> + <b>G</b>	1	■ 1
㉓	<b>B</b> + <b>G</b>	5	■ 5
㉔	<b>B</b> + <b>D</b>	10	■ 10
㉕	<b>B</b> + <b>D</b> + <b>M</b>	4	■ 4
㉖	<b>B</b> + <b>M</b>	1	■ 1
㉗	<b>B</b> + <b>M</b> + <b>O</b>	1	■ 1
㉘	<b>B</b> + <b>M</b> + <b>N</b>	1	■ 1
㉙	<b>A</b> + <b>L</b>	1	■ 1
㉚	<b>A</b> + <b>F</b> L.H.	14	■ 14
㉛	<b>A</b> + <b>I</b> L.H.	8	■ 8
㉜	<b>A</b> + <b>I</b> + <b>K</b>	1	■ 1
㉝	<b>A</b> + <b>K</b>	5	■ 5
㉞	<b>A</b> + <b>B</b> + <b>K</b>	1	■ 1
㉟	<b>B</b> + <b>F</b> + <b>K</b>	3	■ 3
㊱	<b>A</b> + <b>F</b> R.H.	12	■ 12
㊲	<b>A</b> + <b>I</b> R.H.	5	■ 5
㊳	<b>B</b> + <b>N</b> + <b>O</b>	2	■ 2
㊴	<b>B</b> + <b>N</b>	6	■ 6
㊵	<b>B</b> + <b>D</b> + <b>O</b>	1	■ 1
㊶	<b>B</b> + <b>E</b> + <b>O</b>	5	■ 5
㊷	<b>B</b> + <b>E</b>	3	■ 3

Sidemember end





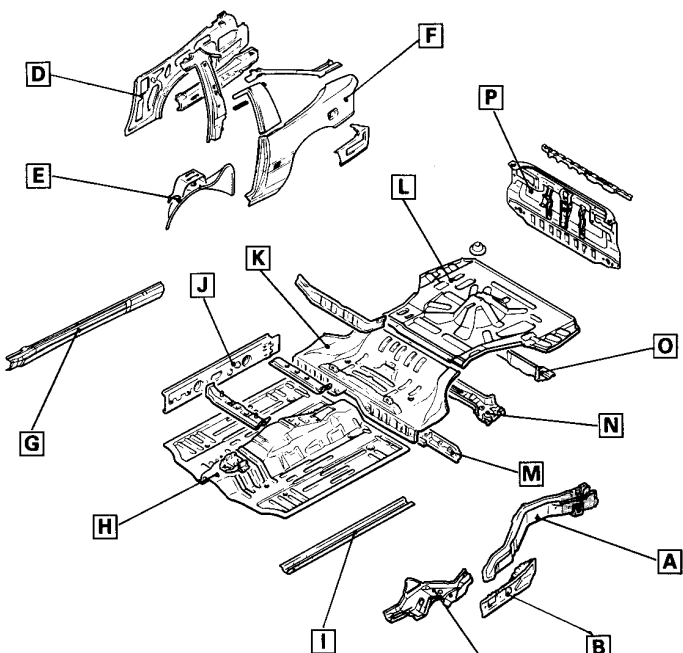


No.	Welded parts	F	R
④③	[B] + [F] + [E]	1	■ 1
④④	[B] + [F]	2	■ 2
④⑤	[B] + [N]	6	■ 6
④⑥	[A] + [K]	2	■ 2
④⑦	[A] + [K]	1	■ 1

No.	Welded parts	F	R
④⑧	[B] + [K]	2	■ 2
④⑨	[B] + [K]	4	■ 4
⑤⑩	[B] + [K]	3	■ 3

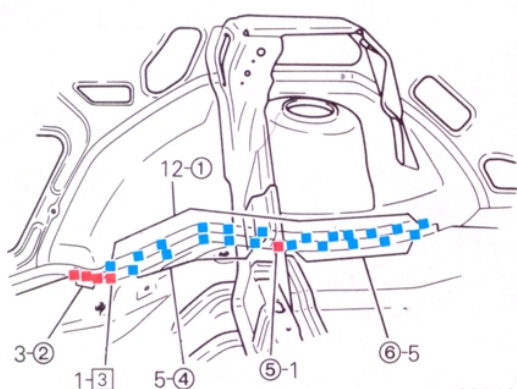


**NOTES**

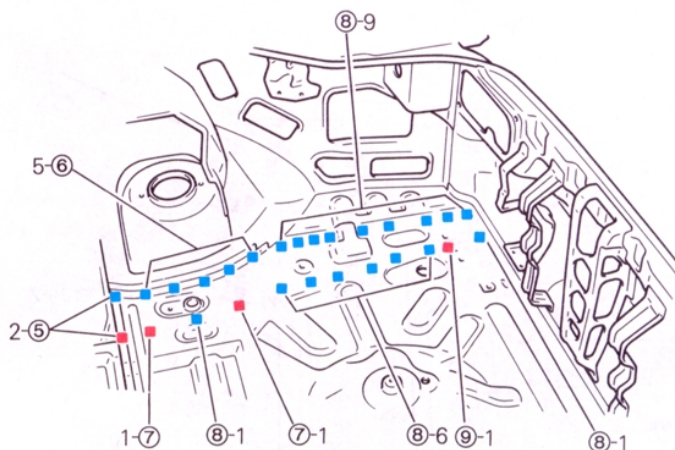
REAR FLOOR SIDEMEMBER <4WD>		PART NAME
REPLACEMENT CONFIGURATION	—	
		<p><b>A</b> Rear floor sidemember</p> <p><b>B</b> Rear floor side sill</p> <p><b>C</b> Rear floor sidemember front extension</p> <p><b>D</b> Quarter panel, inner, lower</p> <p><b>E</b> Rear wheelhouse, inner</p> <p><b>F</b> Quarter panel, outer</p> <p><b>G</b> Front floor side sill, outer</p> <p><b>H</b> Front floor pan</p> <p><b>I</b> Front floor sidemember</p> <p><b>J</b> Front floor side sill, inner</p> <p><b>K</b> Rear seat pan</p> <p><b>L</b> Rear floor pan</p> <p><b>M</b> Rear seat crossmember</p> <p><b>N</b> Rear floor crossmember, lower</p> <p><b>O</b> Rear end crossmember</p> <p><b>P</b> Rear end panel</p>

No.	Welded parts	F	R
①	Left side <b>A + E</b>	14	■ 14
	Right side	12	■ 12
②	<b>B + E + K</b>	3	■ 3
③	<b>A + B + K</b>	1	■ 1
④	<b>A + K</b>	5	■ 5
⑤	Left side <b>A + L</b>	8	■ 8
	Right side	5	■ 5
⑦	<b>A + L + N</b>	2	■ 2
⑧	Left side <b>A + L</b>	14	■ 14
	Right side	17	■ 17
⑨	<b>A + L + P</b>	1	■ 1
⑩	<b>B + E</b>	2	■ 2
⑪	<b>B + D + E</b>	1	■ 1
⑫	<b>B + D</b>	3	■ 3
⑬	<b>B + D + G</b>	5	■ 5
⑭	<b>B + F + G</b>	1	■ 1
⑮	<b>B + J</b>	6	■ 6
⑯	<b>B + G + J</b>	2	■ 2
⑰	<b>B + J</b>	6	■ 6
⑱	<b>B + K</b>	5	■ 5

No.	Welded parts	F	R
⑲	<b>B + K</b>	4	■ 4
⑳	<b>B + K</b>	3	■ 3
㉑	<b>B + E</b>	5	■ 5
㉒	<b>B + E</b>	1	■ 1
㉓	Left side <b>A + N</b>	7	■ 7
	Right side	4	■ 4
㉔	<b>A + N</b>	3	■ 3
㉕	<b>A + O</b>	7	■ 7
㉖	<b>A + O + P</b>	1	■ 1
㉗	<b>C + H + I</b>	4	■ 4
㉘	<b>C + H + K</b>	2	■ 2
㉙	<b>C + M</b>	8	■ 8
㉚	<b>C + K + M</b>	4	■ 4
㉛	<b>C + K</b>	5	■ 5
㉜	<b>A + C</b>	5	■ 5
㉝	<b>A + C + K</b>	3	■ 3
㉞	<b>A + M</b>	4	■ 4
㉟	<b>B + H + J</b>	1	■ 1
㊱	<b>B + G + H</b>	1	■ 1
㊲	<b>B + H</b>	1	■ 1
㊳	<b>B + F + H</b>	4	■ 4

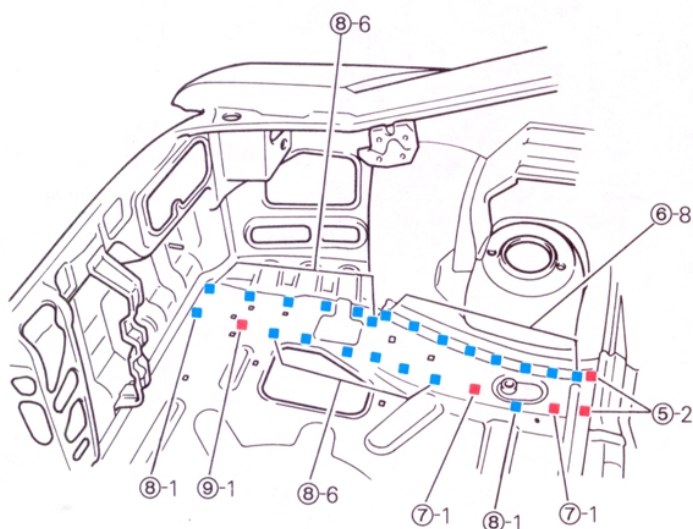


33A0262

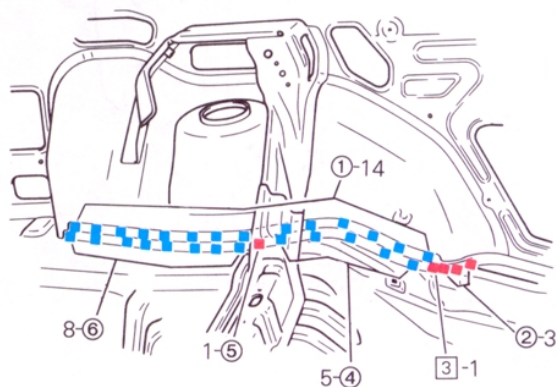


33A0391

(Right Side)



33A0394



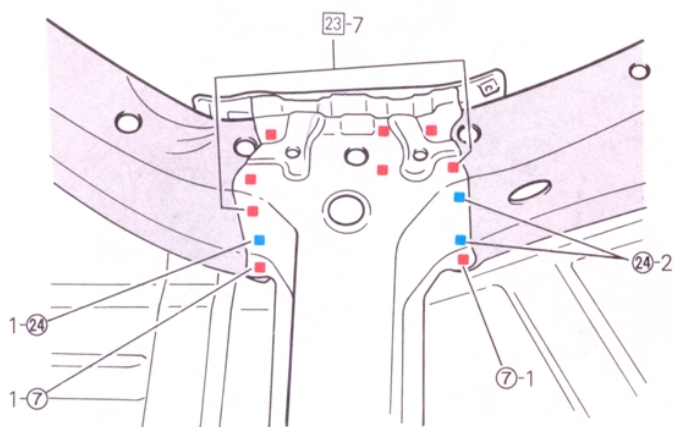
33A0249

(Left Side)

No.	Welded parts	F	R
③⑨	[B] + [F] + [M]	1	■ 1
④⑩	[A] + [B] + [F]	2	■ 2
④⑪	[A] + [B]	1	■ 1

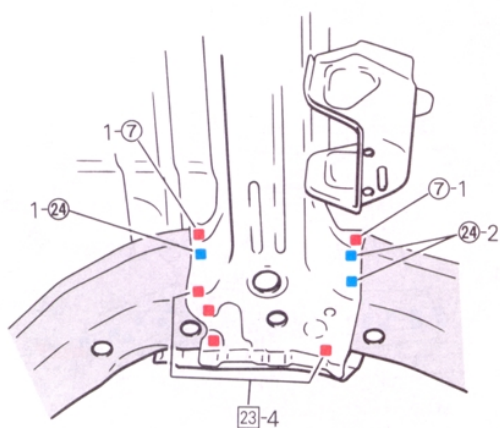
No.	Welded parts	F	R
④②	[B] + [F]	7	■ 7
④③	[B] + [M]	2	■ 2
④④	[A] + [B] + [C]	4	■ 4

(Left side)



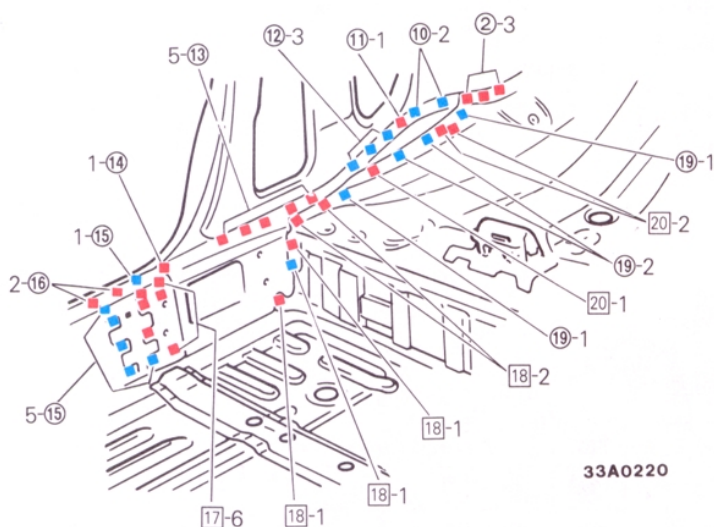
33A0379

(Front)



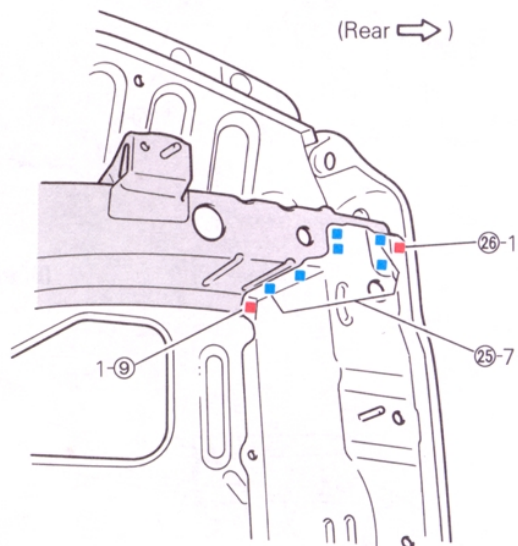
33A0384

(Right side)



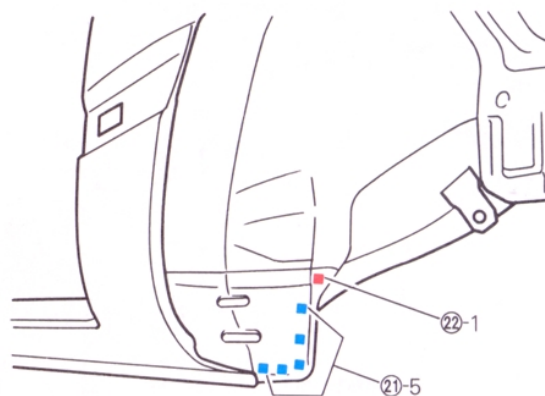
33A0220

(Rear)

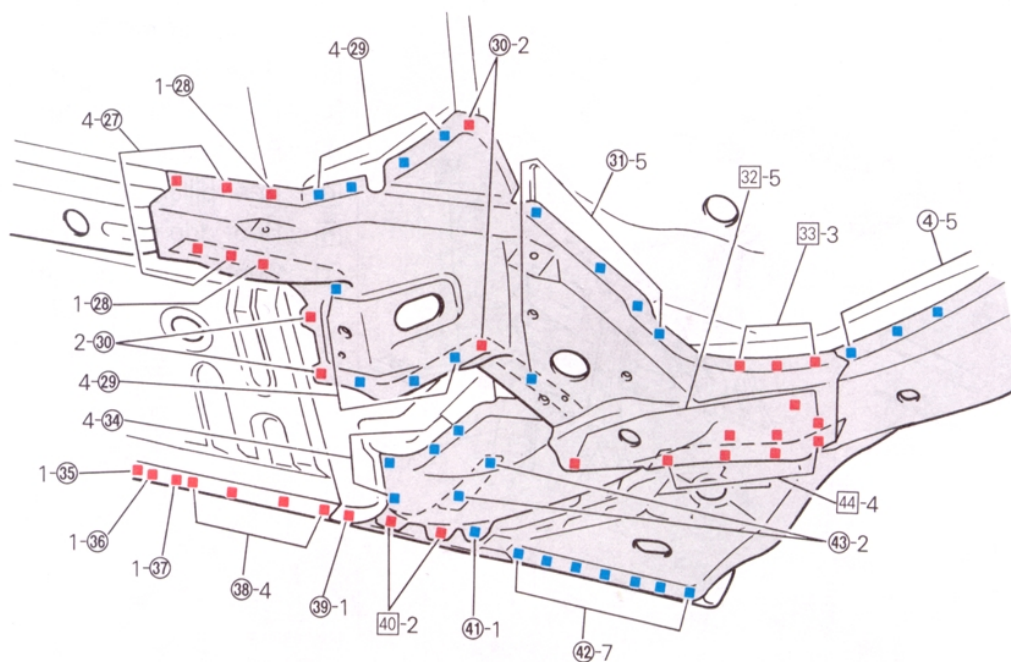


33A0382

(Left side)



33A0409

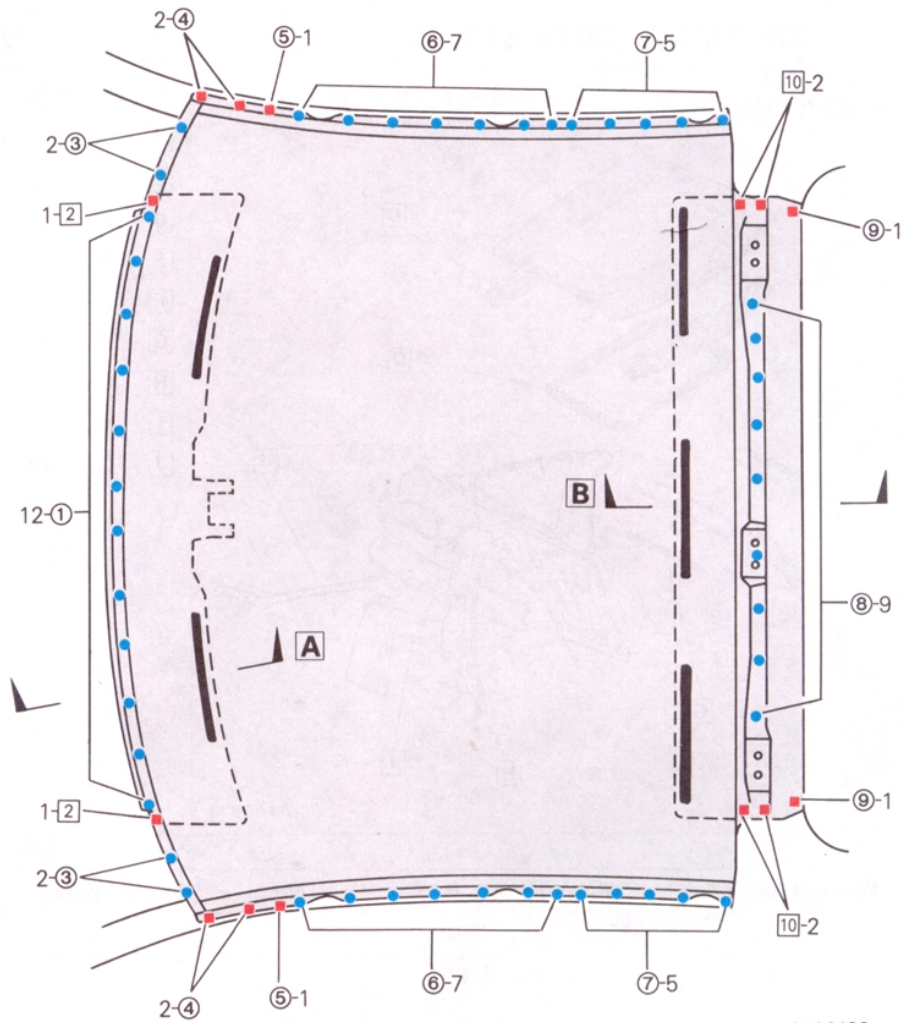


33A0402

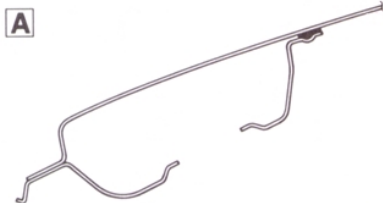


**33A0283**

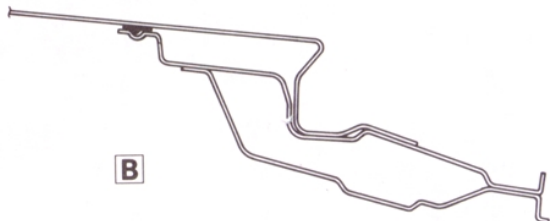
[illegible]



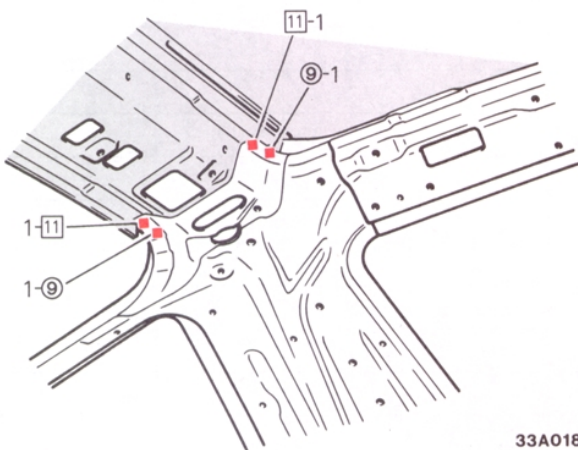
33A0196



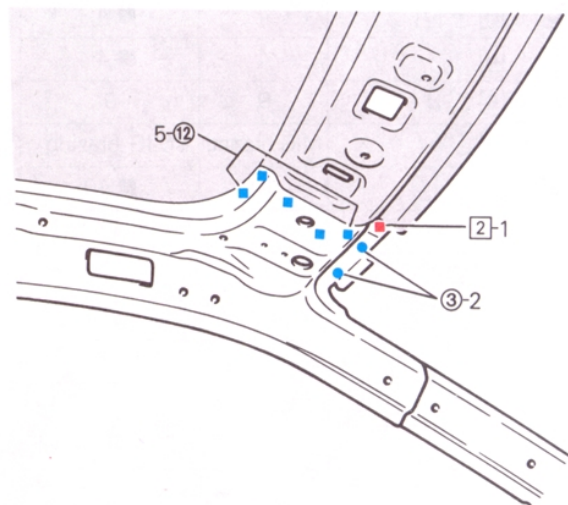
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33A0197



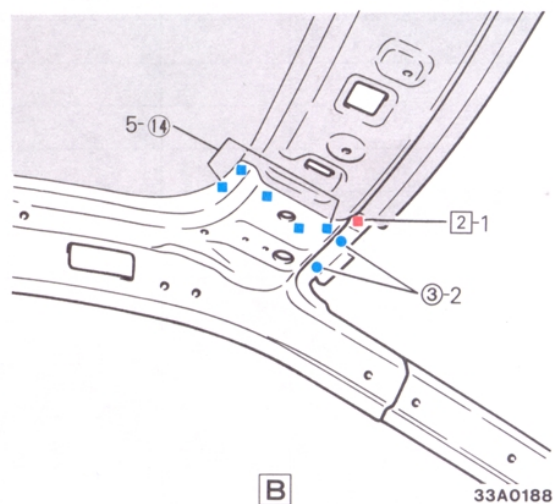
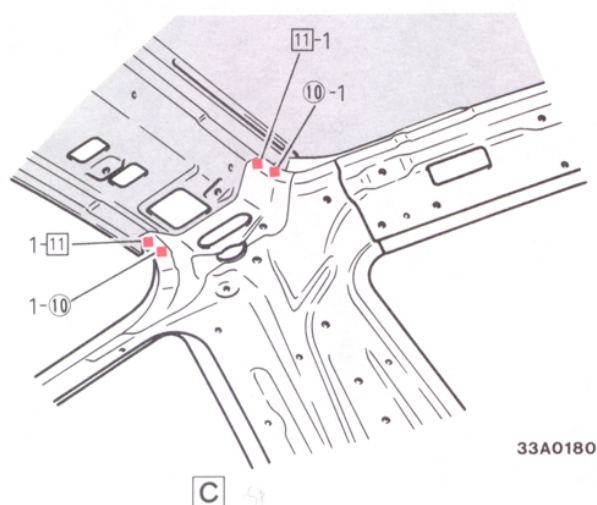
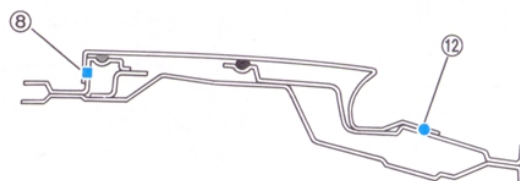
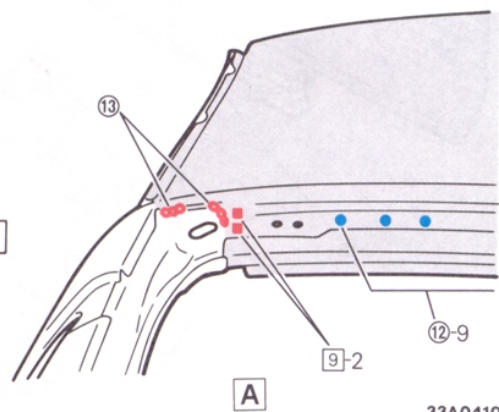
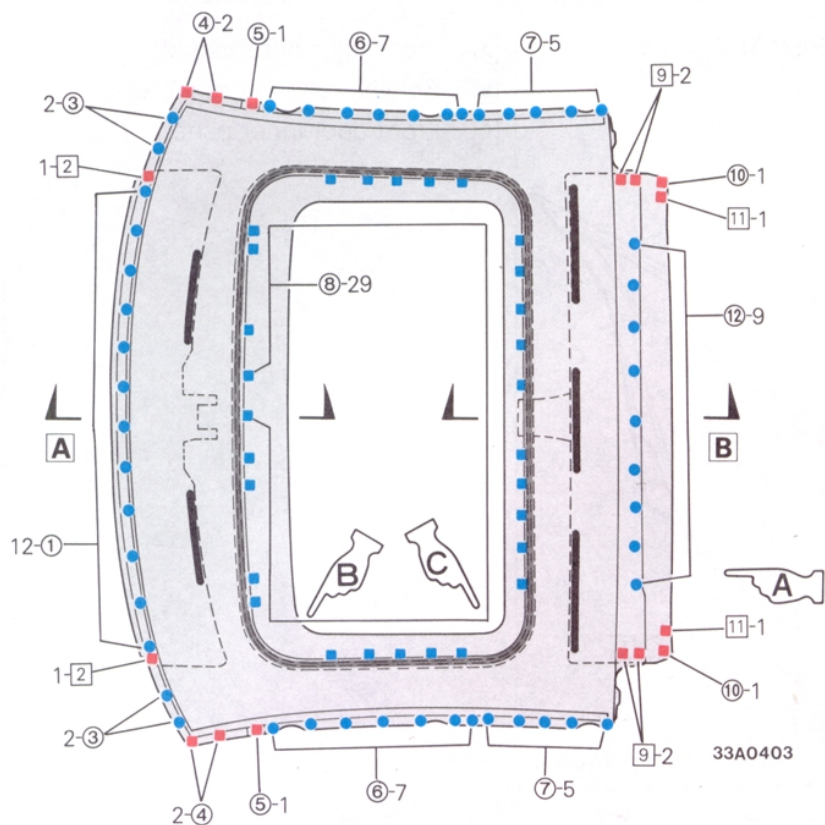
33A0180



33A0188

**33A0413**

[illegible]

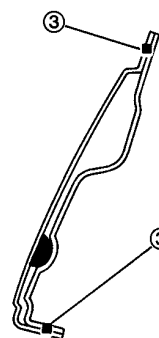


**33A0415**

A diagram showing a road layout. A main road runs diagonally from the bottom left towards the top right. A side road branches off to the right from the main road. At the junction, there is a small black square. A callout line with the number '3' inside a circle points to this square. Further down the main road, there is another black rectangular feature.

**A**

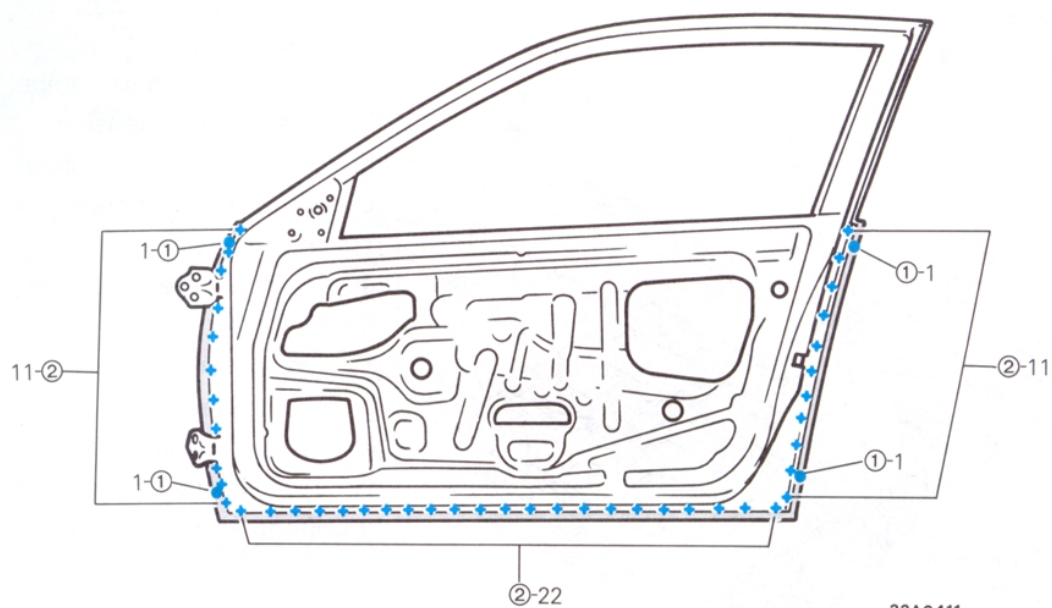
**33A0405**



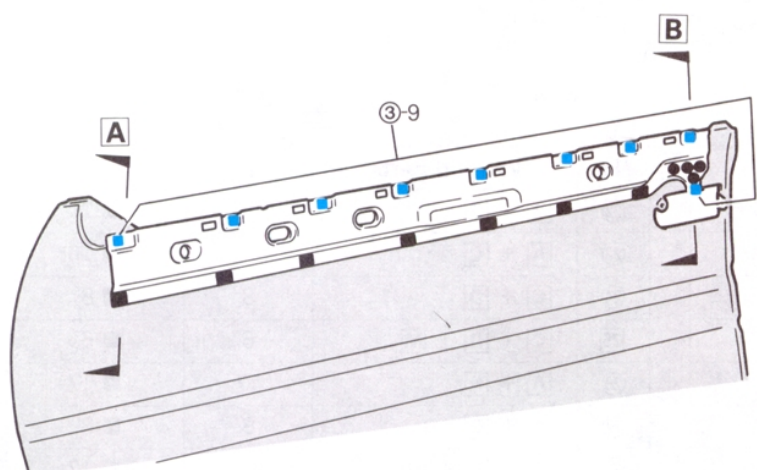
**B**

**33A0404**

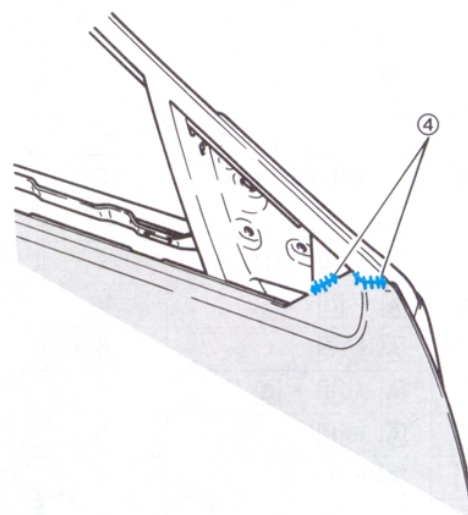




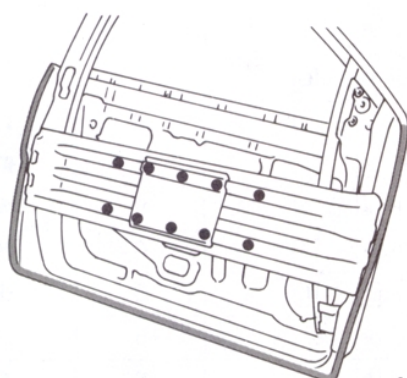
33A0411



33A0381

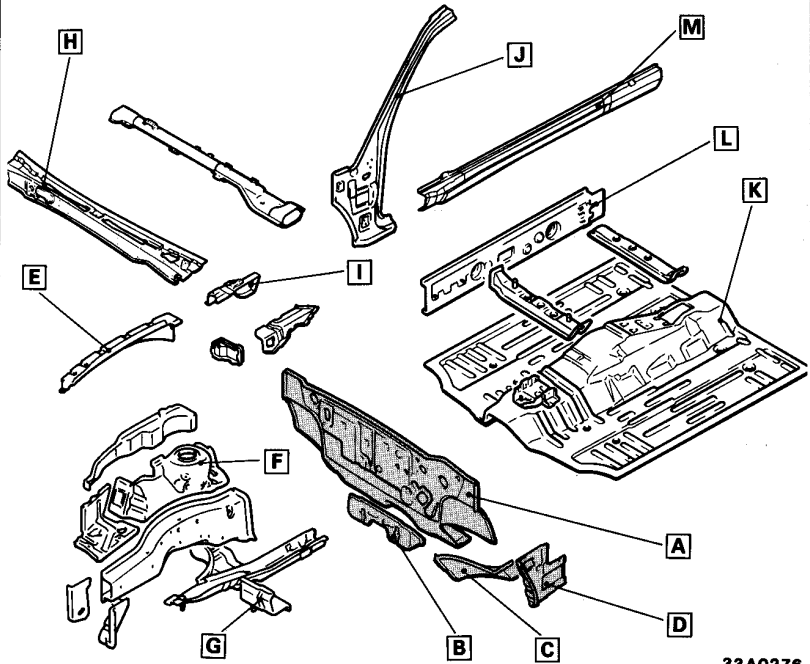


33A0179



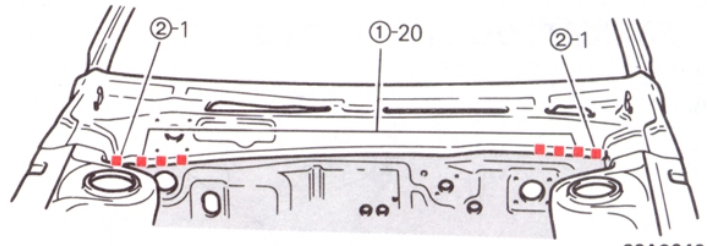
33A0408

■ : Silicon rubber sealer  
 ■ : Moisture cured Urethane Adhesive  
 [Type: \*Urethane E  
 \*EESEX SPECIALITY PRODUCTS Inc.]

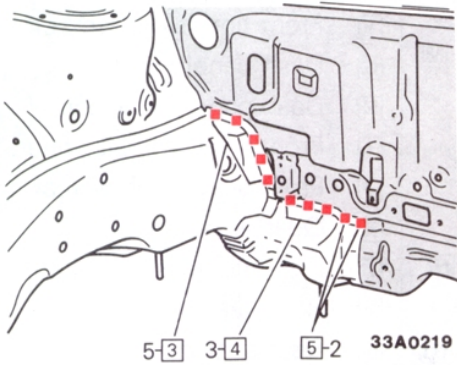
DASH PANEL		PART NAME
REPLACEMENT CONFIGURATION	—	
		<p><b>A</b> Dash panel</p> <p><b>B</b> Dash panel crossmember</p> <p><b>C</b> Dash panel extension</p> <p><b>D</b> Front floor side sill, inner, front</p> <p><b>E</b> Front upper frame, outer</p> <p><b>F</b> Strut house panel</p> <p><b>G</b> Front sidemember</p> <p><b>H</b> Cowl top panel</p> <p><b>I</b> Upper frame extension, inner</p> <p><b>J</b> Front pillar</p> <p><b>K</b> Front floor pan</p> <p><b>L</b> Front floor side sill, inner</p> <p><b>M</b> Front floor side sill, outer</p>
33A0276		

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

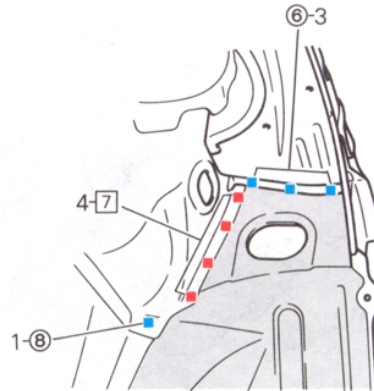
No.	Welded parts	F	R
㉒	<b>A + G</b>	2	■ 2
㉓	<b>A + C</b>	16	■ 16
㉔	<b>C + D</b>	8	■ 8
㉕	<b>C + D + M</b>	6	■ 6
㉖	<b>A + K</b>	17	■ 17
㉗	<b>A + G</b>	8	■ 8
㉘	<b>A + C + G</b>	12	■ 12
㉙	<b>D + G</b>	6	■ 6
㉚	<b>D + L + M</b>	6	■ 6
㉛	<b>D + G + M</b>	8	■ 8
㉜	<b>A + D + G</b>	6	■ 6
㉝	<b>A + D + J</b>	6	■ 6
㉞	<b>A + D</b>	2	■ 2
㉟	<b>A + J</b>	8	■ 8
㊱	<b>A + E + J</b>	6	■ 6
㊲	<b>D + K + L</b>	6	■ 6
㊳	<b>A + B</b>	5	■ 5
㊴	<b>A + B</b>	6	■ 6
㊵	<b>A + B</b>	2	■ 2
㊶	<b>B + G</b>	8	■ 8
㊷	<b>A + B</b>	5	■ 5



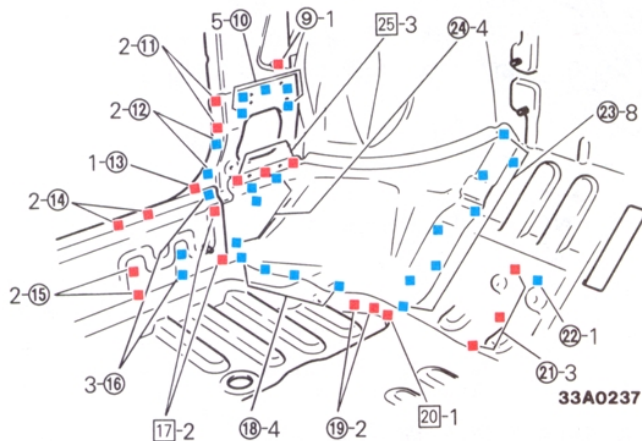
33A0243



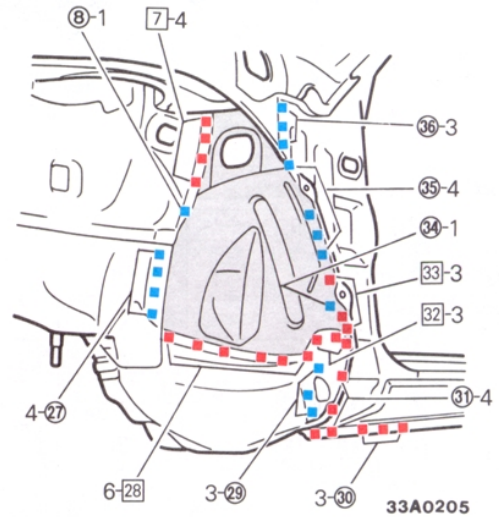
33A0219



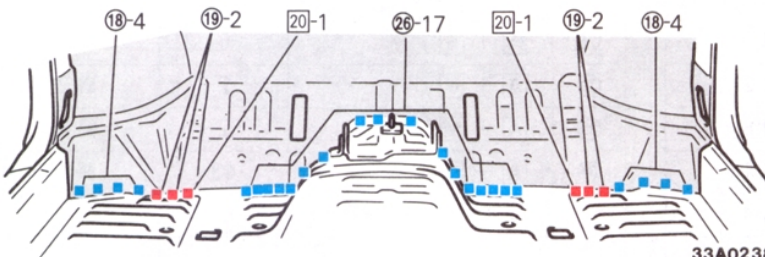
33A0232



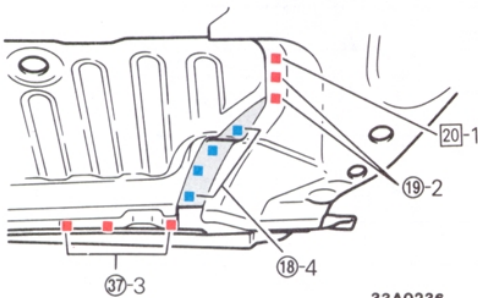
33A0237



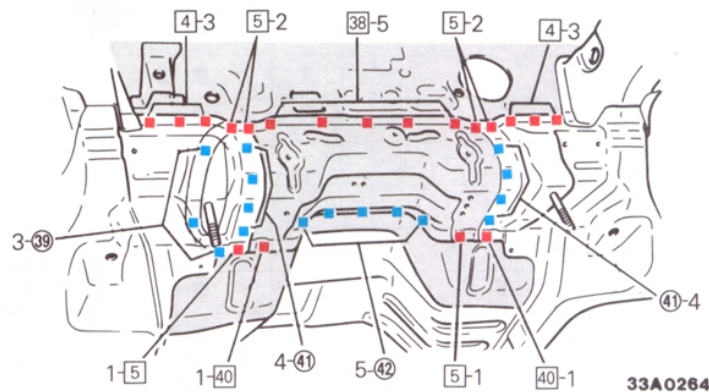
33A0205



33A0238



33A0236

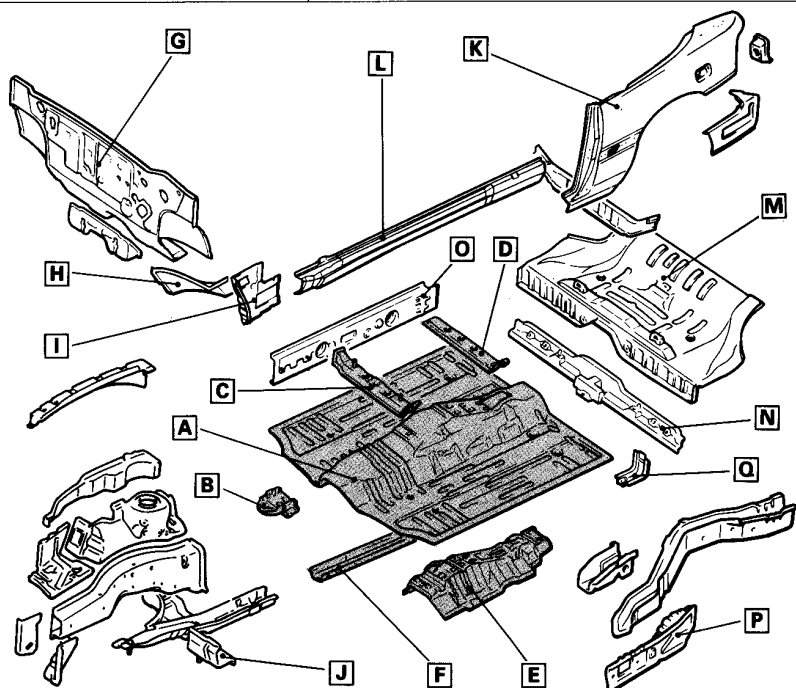


33A0264

## FRONT FLOOR PAN <2WD>

**PART NAME**

## REPLACEMENT CONFIGURATION



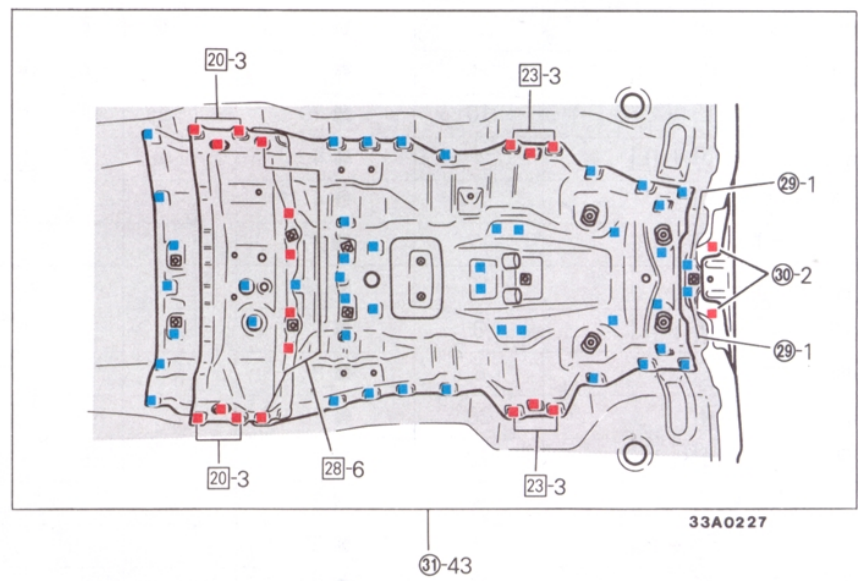
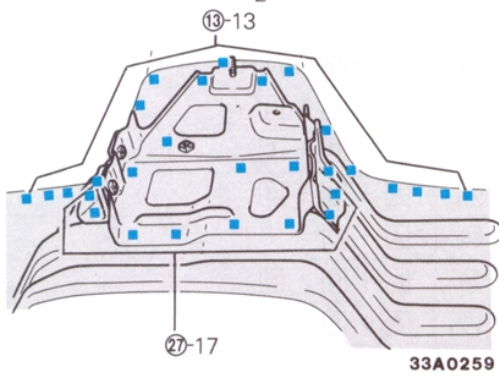
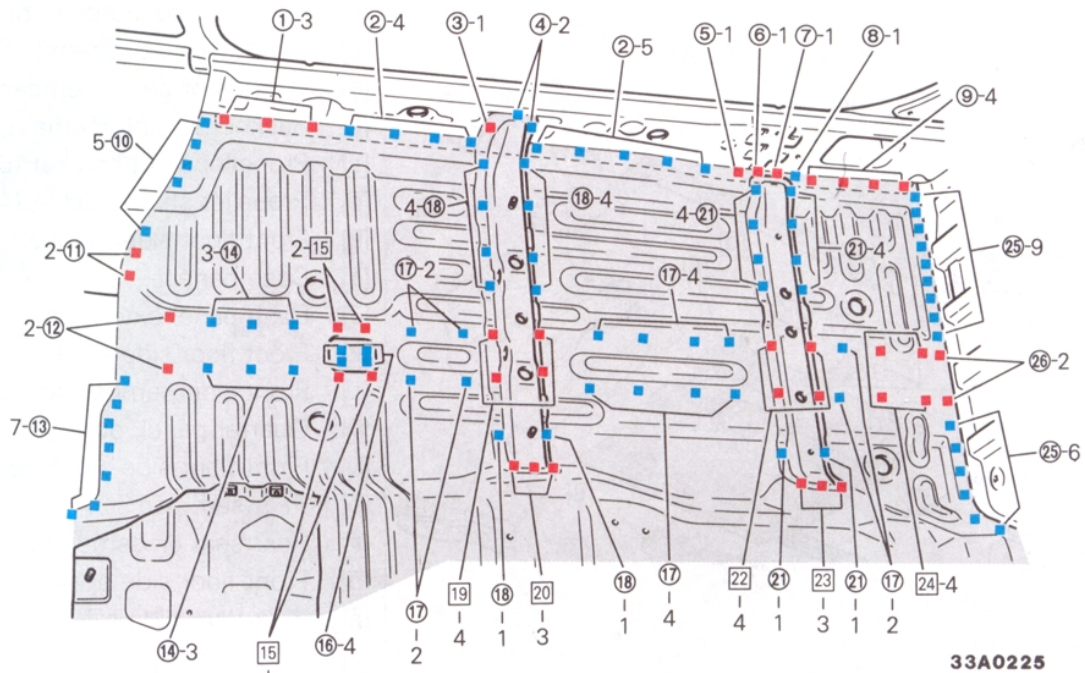
33A0277

- A** Front floor pan
- B** Backbone reinforcement, front
- C** Front floor crossmember, front
- D** Front floor crossmember, rear
- E** Backbone reinforcement, rear
- F** Front floor sidemember
- G** Dash panel
- H** Dash panel extension
- I** Front floor side sill, inner, front
- J** Front sidemember, rear
- K** Quarter panel, outer
- L** Front floor side sill, outer
- M** Rear seat pan
- N** Rear seat crossmember
- O** Front floor side sill, inner
- P** Rear floor side sill
- Q** Sidemember rear floor extension

No.	Welded parts	F	R
①	<b>A + I + O</b>	6	■ 6
②	<b>A + O</b>	18	■ 18
③	<b>C + O</b>	2	■ 2
④	<b>C + O</b>	4	■ 4
⑤	<b>A + L + O</b>	2	■ 2
⑥	<b>A + O + P</b>	2	■ 2
⑦	<b>A + L + P</b>	2	■ 2
⑧	<b>A + P</b>	2	■ 2
⑨	<b>A + K + P</b>	8	■ 8
⑩	<b>A + J</b>	10	■ 10
⑪	<b>A + H + J</b>	4	■ 4
⑫	<b>A + J</b>	4	■ 4
⑬	<b>A + G</b>	17	■ 17
⑭	<b>A + J</b>	12	■ 12
⑮	<b>A + F + J</b>	8	■ 8
⑯	<b>F + J</b>	8	■ 8
⑰	<b>A + F</b>	28	■ 28
⑱	<b>A + C</b>	20	■ 20
⑲	<b>A + C + F</b>	8	■ 8
⑳	<b>A + C + E</b>	6	■ 6
㉑	<b>A + D</b>	20	■ 20

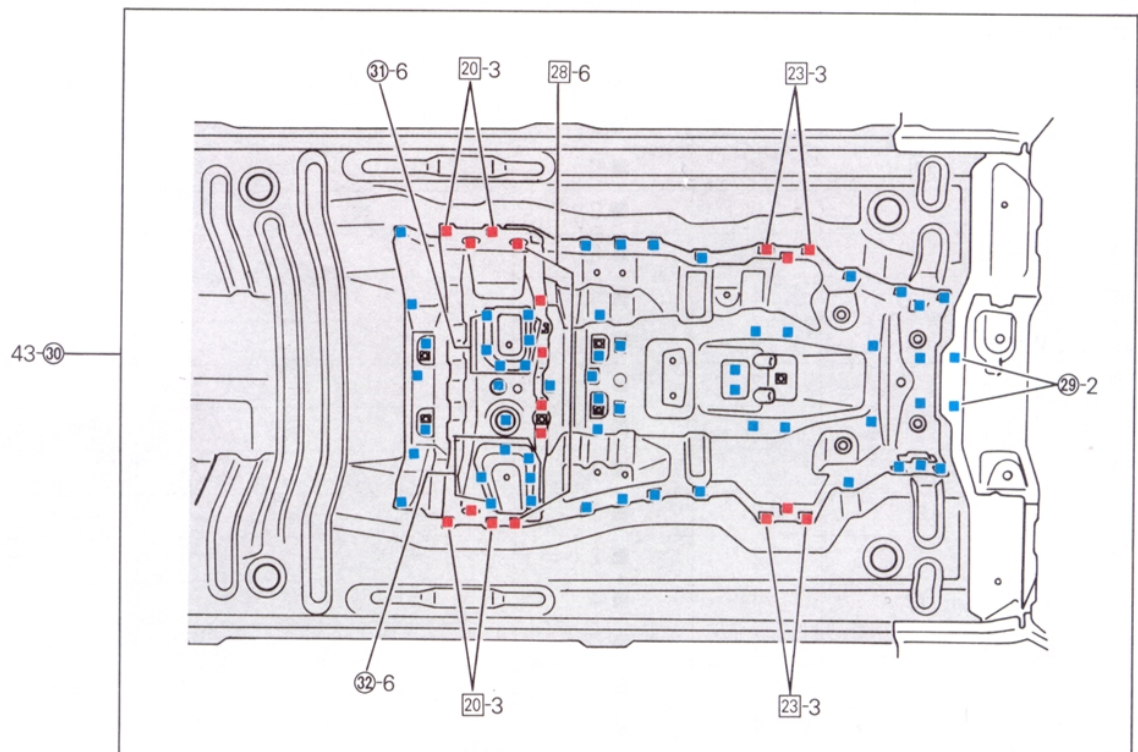
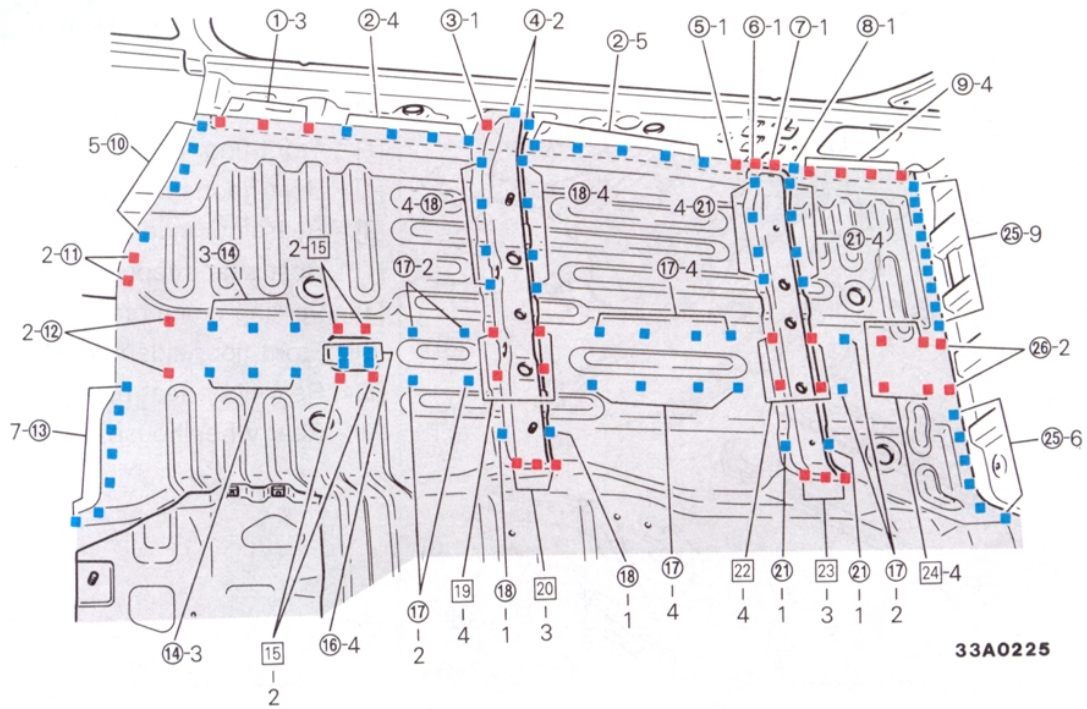
[illegible]





**33A0417**

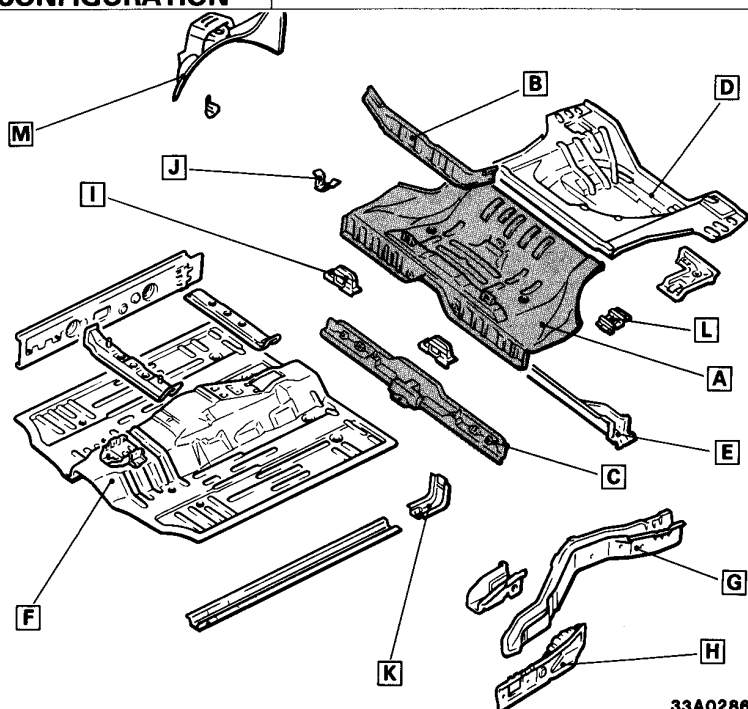
[illegible]



## REAR SEAT PAN <2WD>

## PART NAME

## REPLACEMENT CONFIGURATION



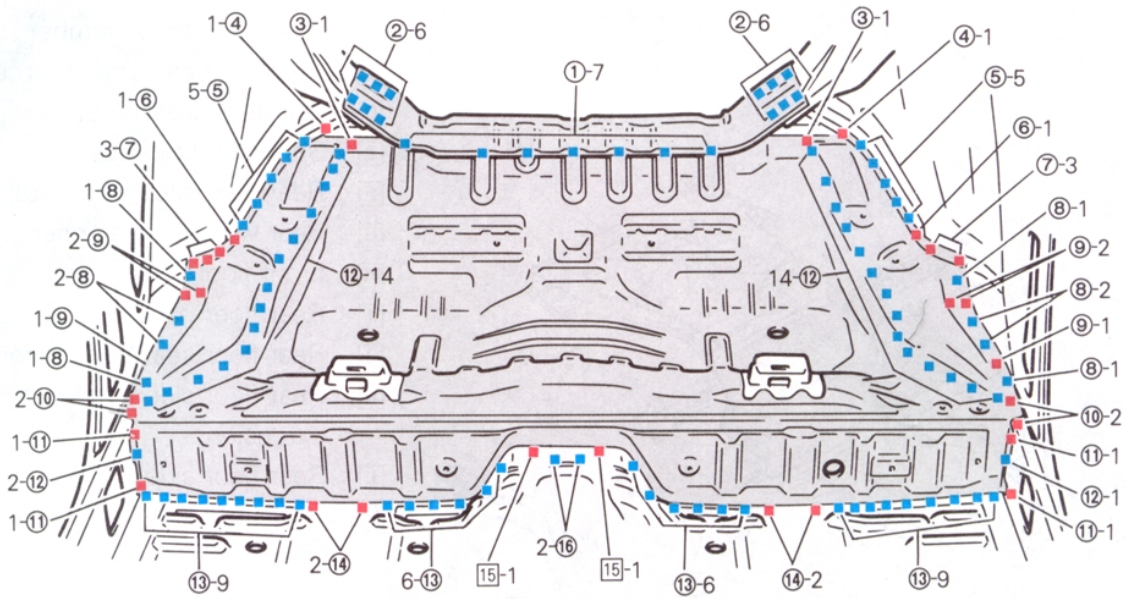
**33A0286**

- A** Rear seat pan
- B** Rear floor crossmember, upper
- C** Rear seat crossmember
- D** Rear floor pan
- E** Rear floor crossmember, lower
- F** Front floor pan
- G** Rear floor sidemember
- H** Rear floor side sill
- I** Rear seat support bracket
- J** Parking brake bracket
- K** Front floor sidemember extension
- L** Rear floor seat belt reinforcement
- M** Rear wheelhouse, inner

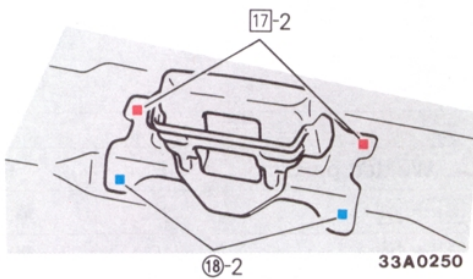
No.	Welded parts	F	R
①	<b>A</b> + <b>B</b>	7	■ 7
②	<b>B</b> + <b>M</b>	12	■ 12
③	<b>A</b> + <b>D</b> + <b>E</b> ★	2	■ 2
④	<b>A</b> + <b>D</b> + <b>G</b>	2	■ 2
⑤	<b>A</b> + <b>G</b>	10	■ 10
⑥	<b>A</b> + <b>G</b> + <b>H</b>	2	■ 2
⑦	<b>A</b> + <b>H</b> + <b>M</b>	6	■ 6
⑧	<b>A</b> + <b>H</b>	8	■ 8
⑨	<b>A</b> + <b>H</b>	6	■ 6
⑩	<b>A</b> + <b>H</b>	4	■ 4
⑪	<b>A</b> + <b>H</b>	4	■ 4
⑫	<b>A</b> + <b>H</b>	2	■ 2
⑬	<b>A</b> + <b>F</b>	30	■ 30
⑭	<b>A</b> + <b>F</b> + <b>K</b>	4	■ 4
⑮	<b>A</b> + <b>C</b> + <b>F</b>	2	■ 2
⑯	<b>C</b> + <b>F</b>	2	■ 2
⑰	<b>A</b> + <b>C</b> + <b>I</b>	4	■ 4
⑱	<b>A</b> + <b>I</b>	4	■ 4
⑲	<b>A</b> + <b>L</b>	12	■ 12
⑳	<b>A</b> + <b>B</b> + <b>D</b> ★	7	■ 7
㉑	<b>A</b> + <b>B</b> + <b>E</b> ★	11	■ 11

[illegible]

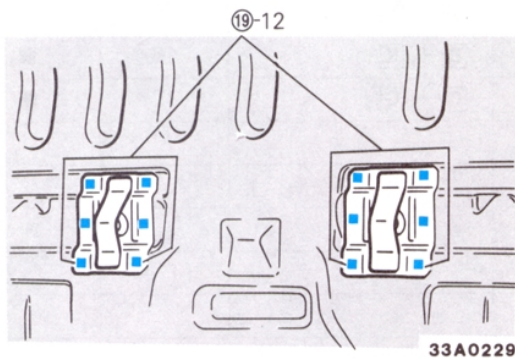




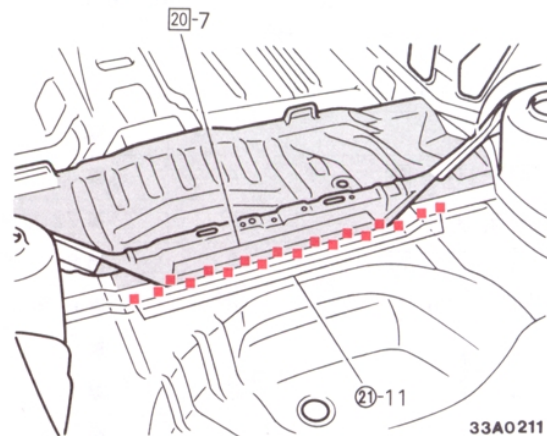
33A0224



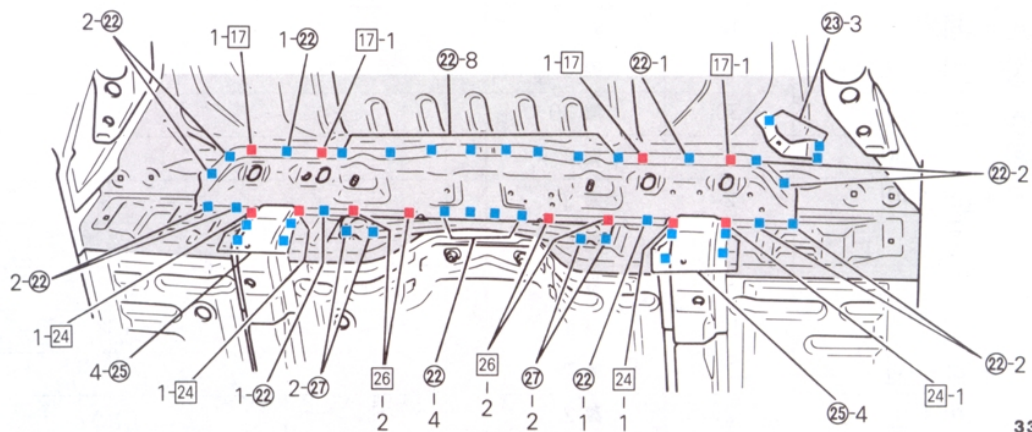
33A0250



33A0229



33A0211

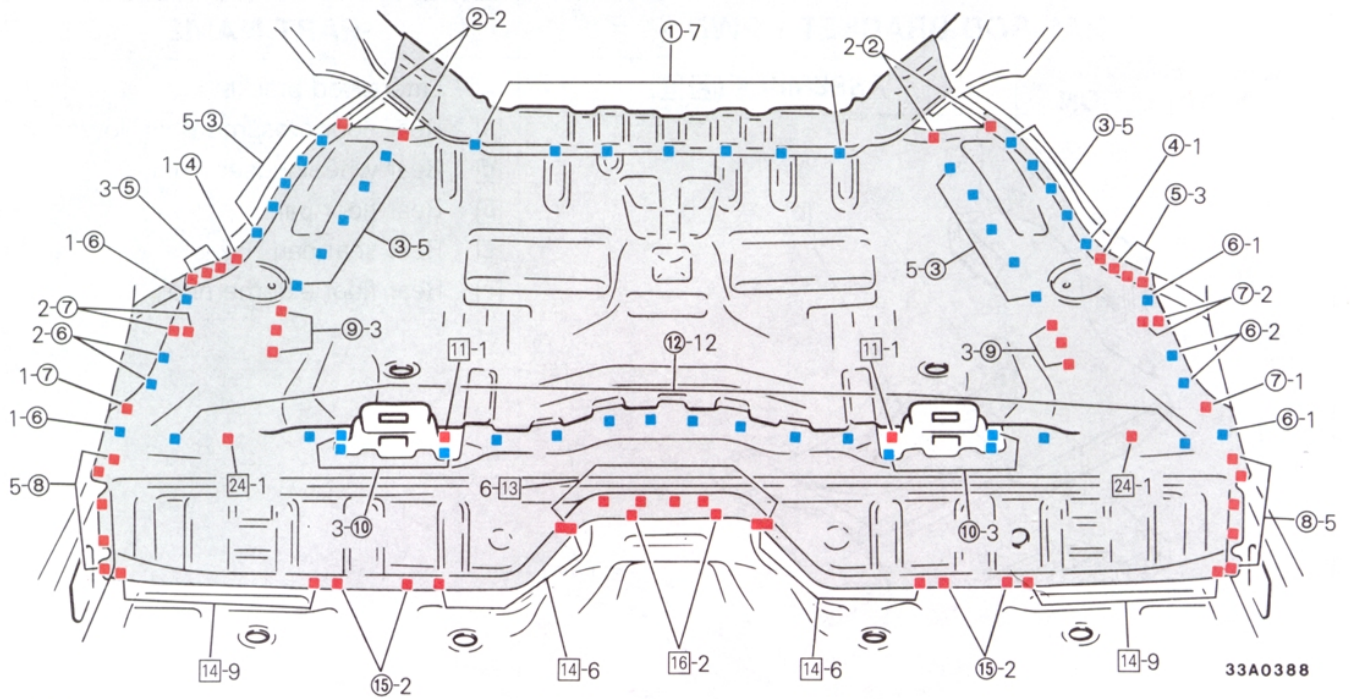


33A0223

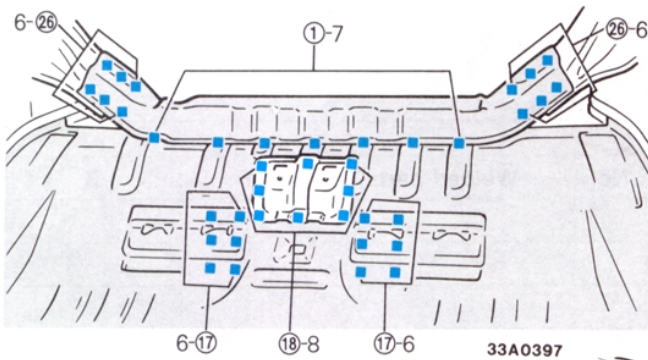
No.	Welded parts	F	R
①	<b>A</b> + <b>C</b>	7	■ 7
②	<b>A</b> + <b>I</b> + <b>M</b>	4	■ 4
③	<b>A</b> + <b>M</b>	22	■ 22
④	<b>A</b> + <b>L</b> + <b>M</b>	2	■ 2
⑤	<b>A</b> + <b>G</b> + <b>L</b>	6	■ 6
⑥	<b>A</b> + <b>L</b>	8	■ 8
⑦	<b>A</b> + <b>L</b>	6	■ 6
⑧	<b>A</b> + <b>L</b>	10	■ 10
⑨	<b>A</b> + <b>K</b> + <b>M</b>	6	■ 6
⑩	<b>A</b> + <b>F</b> ★	6	■ 6
⑪	<b>A</b> + <b>B</b> + <b>F</b>	2	■ 2
⑫	<b>A</b> + <b>B</b>	12	■ 12
⑬	<b>A</b> + <b>B</b>	6	■ 6
⑭	<b>A</b> + <b>B</b> + <b>H</b>	30	■ 30
⑮	<b>A</b> + <b>H</b> + <b>K</b>	4	■ 4
⑯	<b>A</b> + <b>B</b> + <b>H</b>	2	■ 2
⑰	<b>A</b> + <b>J</b> ★	12	■ 12
⑱	<b>A</b> + <b>E</b>	8	■ 8
⑲	<b>A</b> + <b>I</b>	11	■ 11
⑳	<b>A</b> + <b>C</b> + <b>I</b> ★	7	■ 7
㉑	<b>B</b> + <b>D</b> + <b>L</b>	2	■ 2

[illegible]

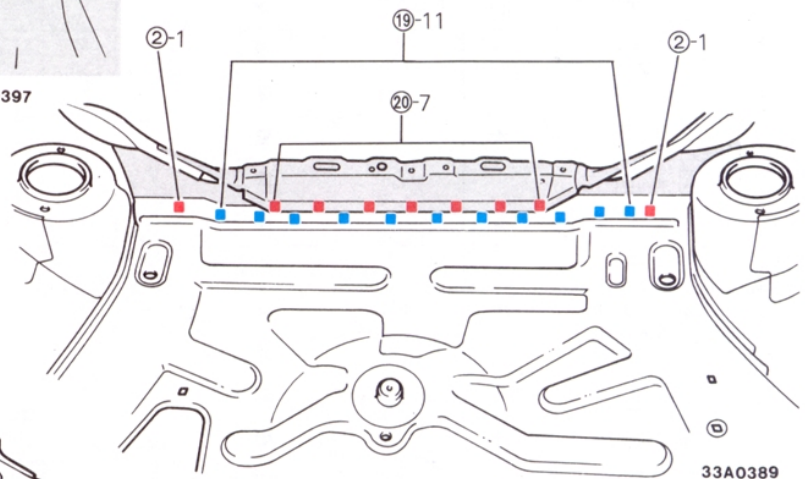




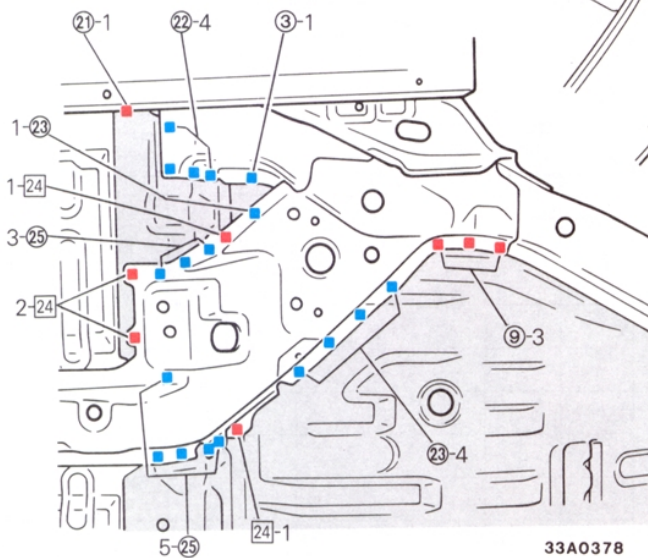
33A0388



33A0397



33A0389

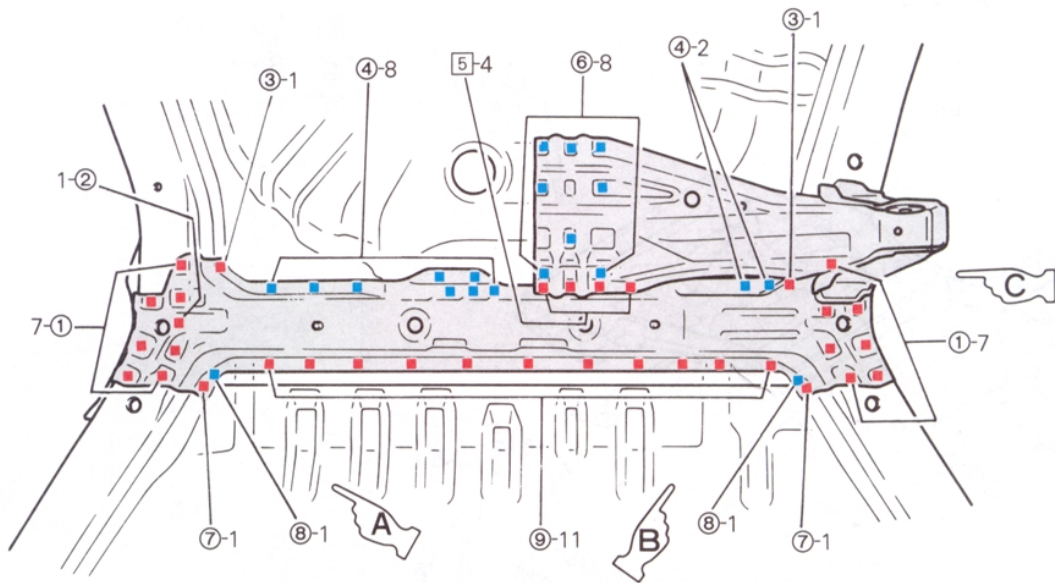


33A0378

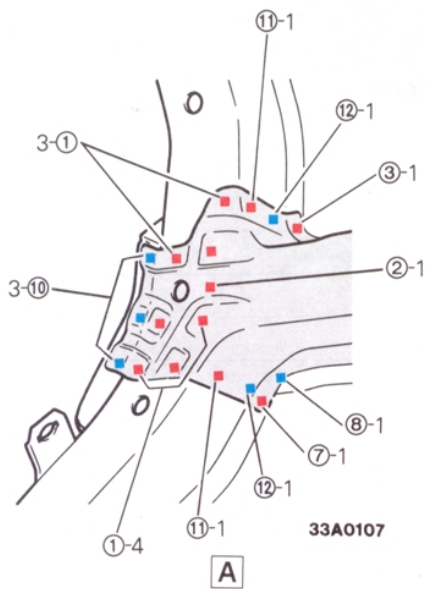
**33A0278**

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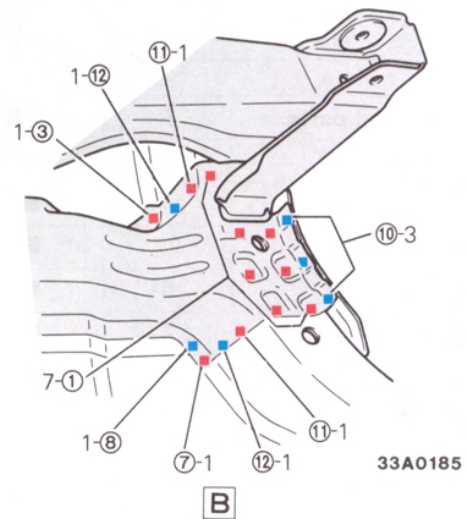




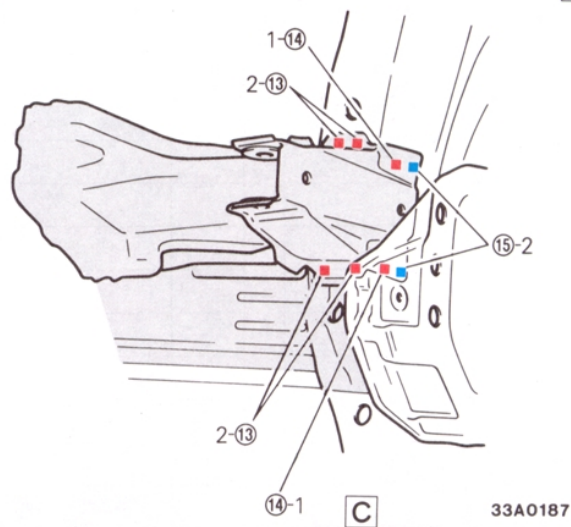
33A0190



33A0107



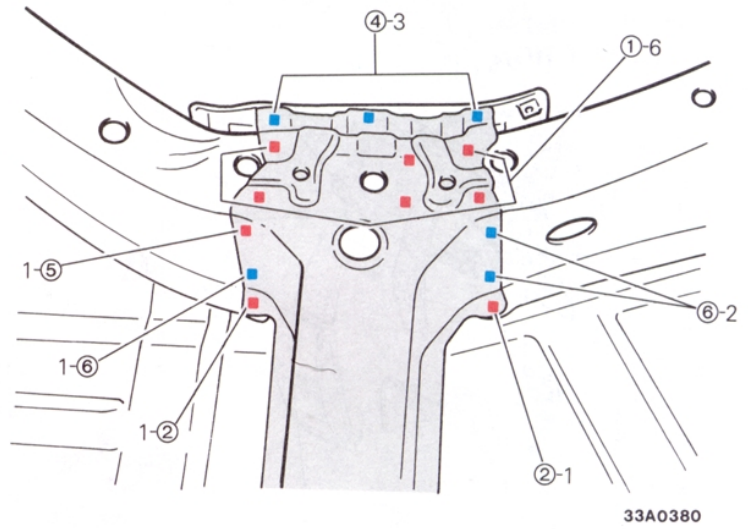
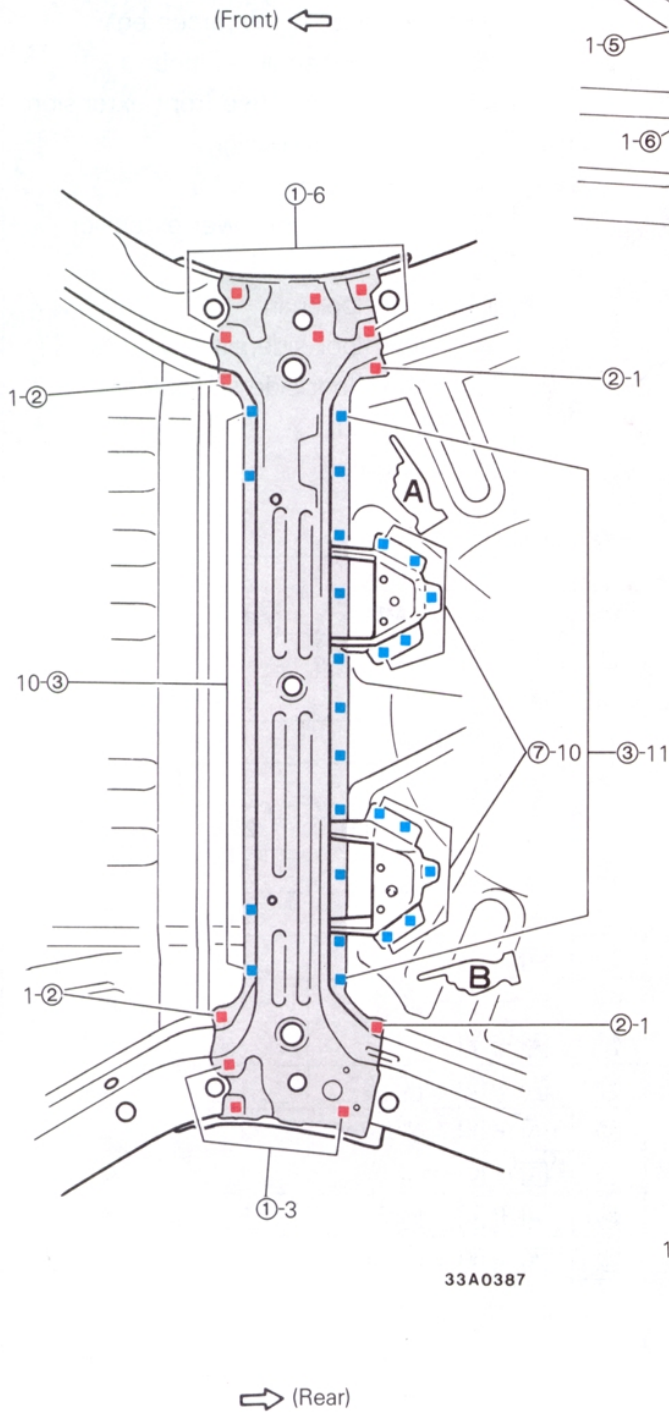
33A0185



33A0187

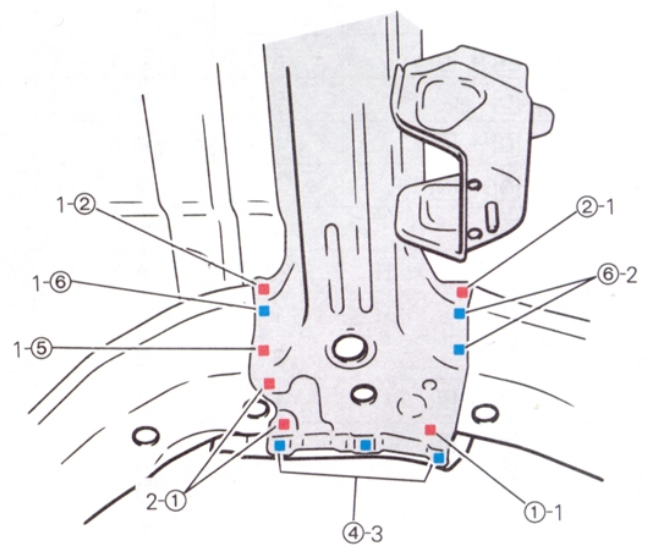
REAR FLOOR CROSSMEMBER <4WD>		PART NAME
REPLACEMENT CONFIGURATION	ASSEMBLY (A)	<p><b>A</b> Rear floor crossmember</p> <p><b>B</b> Rear floor pan</p> <p><b>C</b> Rear wheelhouse, inner</p> <p><b>D</b> Rear floor sidemember</p>
33A0416		

[illegible][illegible]



(Left side)

A



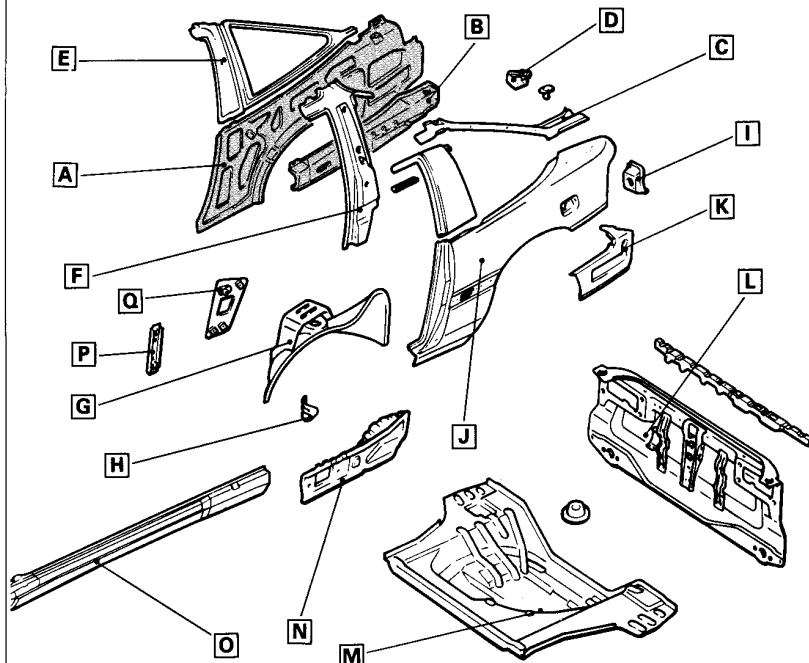
(Right side)

B

**QUARTER PANEL, INNER**

## PART NAME

## REPLACEMENT CONFIGURATION



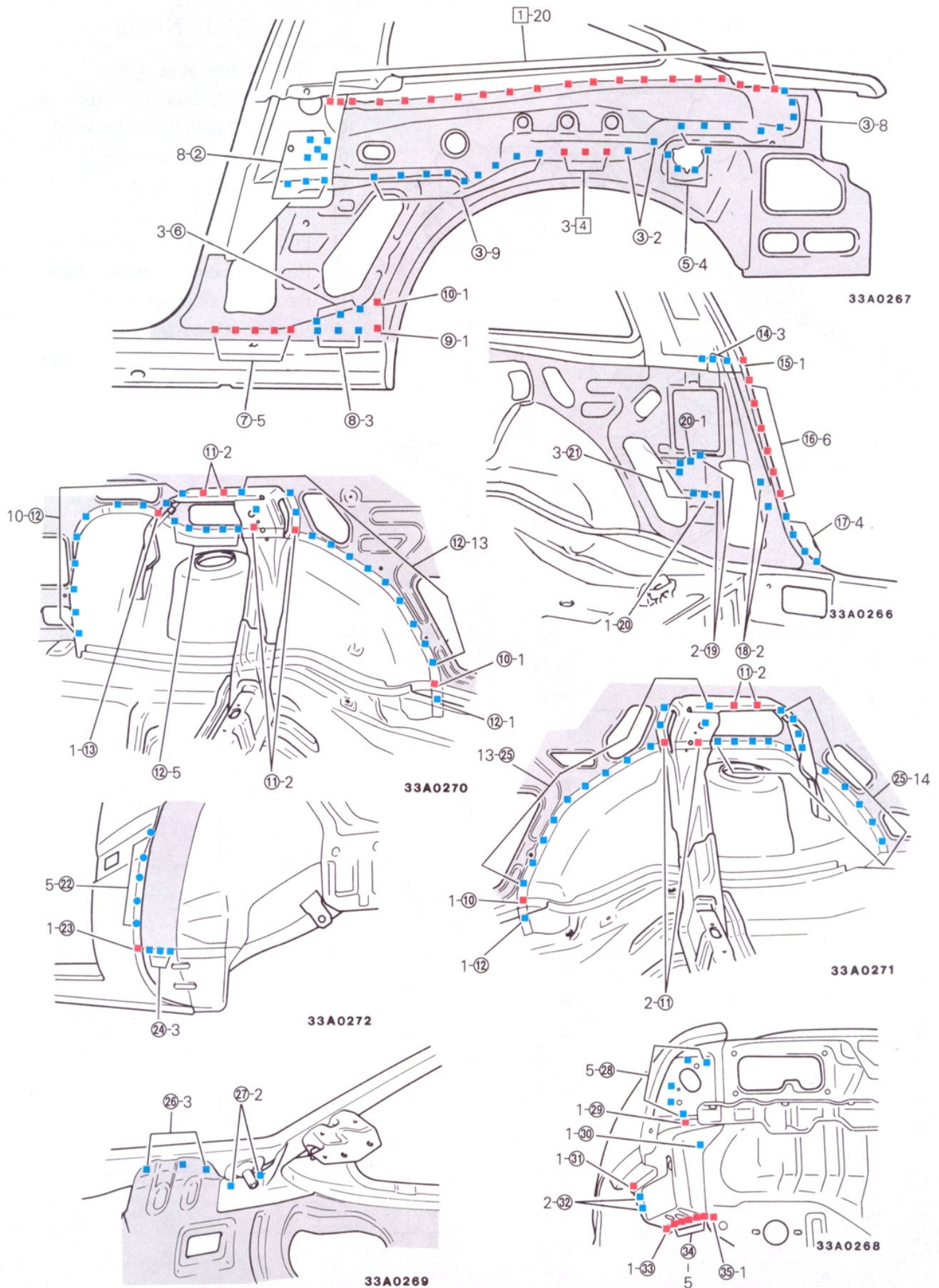
**33A0289**

- A** Quarter panel, inner, lower
- B** Beltline reinforcement
- C** Rear pillar, outer
- D** Gas spring bracket
- E** Quarter panel, inner, upper
- F** Center pillar reinforcement
- G** Rear wheelhouse, inner
- H** Rear wheelhouse front extension
- I** Rear lamp housing
- J** Quarter panel, outer
- K** Quarter panel lower extension
- L** Rear end panel
- M** Rear floor pan
- N** Rear floor side sill
- O** Front floor side sill, outer
- P** Plate nut
- Q** Plate nut

No.	Welded parts	F	R
①	<b>A</b> + <b>B</b> + <b>E</b>	20	■ 20
②	<b>B</b> + <b>F</b>	8	■ 8
③	<b>A</b> + <b>B</b> L.H. R.H.	19	■ 19
		21	■ 21
④	<b>A</b> + <b>B</b> + <b>G</b>	3	■ 3
⑤	<b>A</b> + <b>J</b> L.H.	4	■ 4
⑥	<b>A</b> + <b>N</b>	3	■ 3
⑦	<b>A</b> + <b>N</b> + <b>O</b>	5	■ 5
⑧	<b>A</b> + <b>O</b>	3	■ 3
⑨	<b>A</b> + <b>G</b> + <b>O</b>	1	■ 1
⑩	<b>A</b> + <b>G</b> + <b>N</b>	1	■ 1
⑪	<b>A</b> + <b>G</b>	4	■ 4
⑫	<b>A</b> + <b>G</b> L.H.	29	■ 29
⑬	<b>A</b> + <b>G</b> L.H.	1	■ 1
⑭	<b>A</b> + <b>E</b>	3	■ 3
⑮	<b>A</b> + <b>E</b> + <b>F</b>	1	■ 1
⑯	<b>A</b> + <b>F</b> + <b>J</b>	6	■ 6
⑰	<b>A</b> + <b>J</b>	4	■ 4
⑱	<b>A</b> + <b>P</b> ★	2	■ 2
⑲	<b>A</b> + <b>Q</b> ★	2	■ 2
⑳	<b>A</b> + <b>Q</b> R.H. ★	2	■ 2

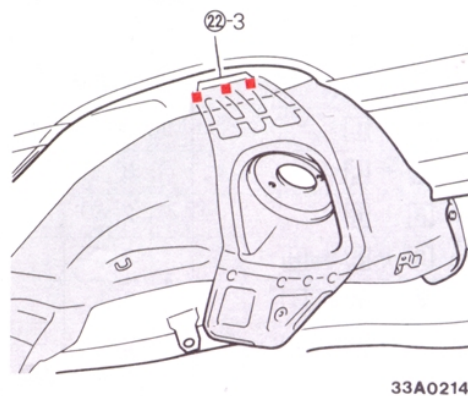
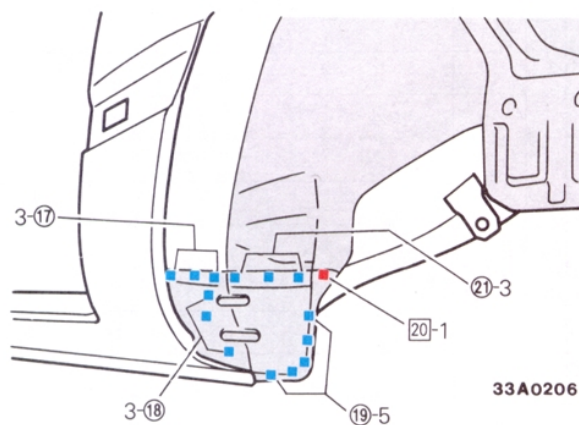
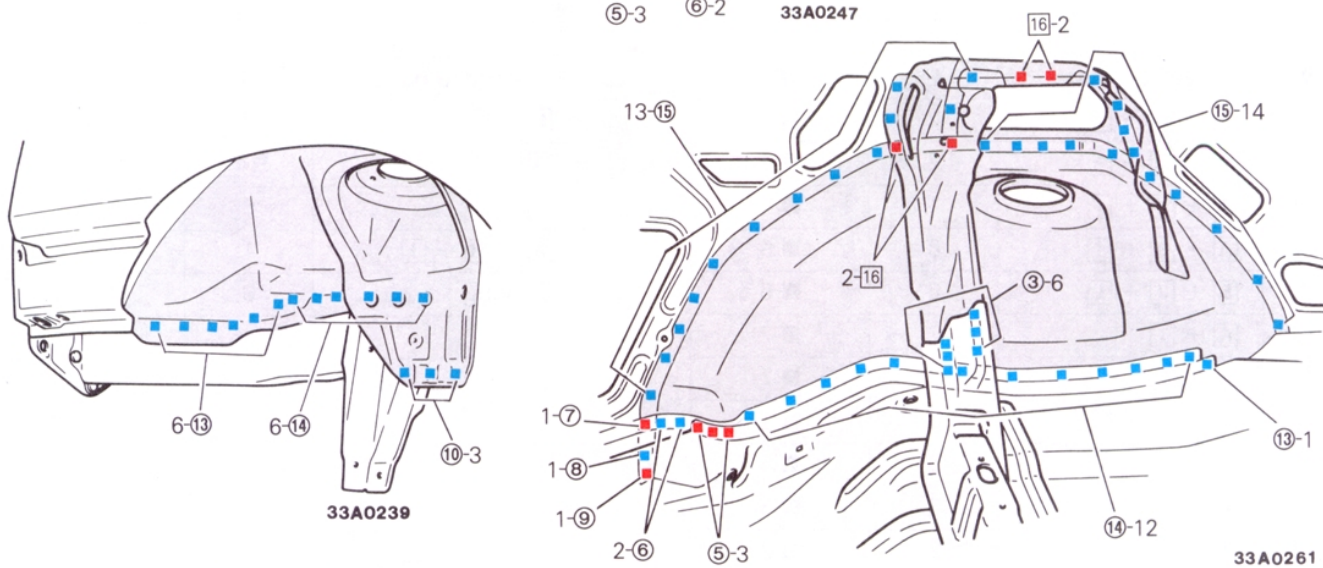
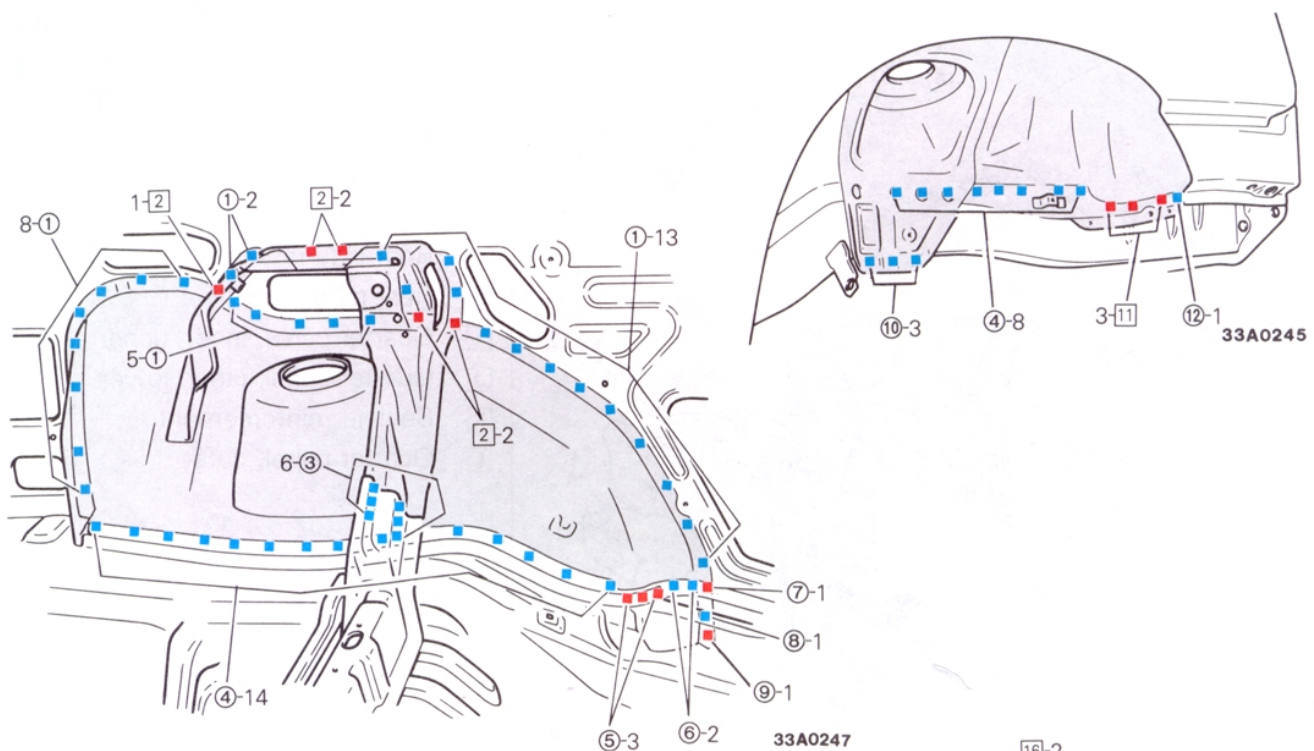
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33A0206

33A0214

33A0261

33A0239

33A0247

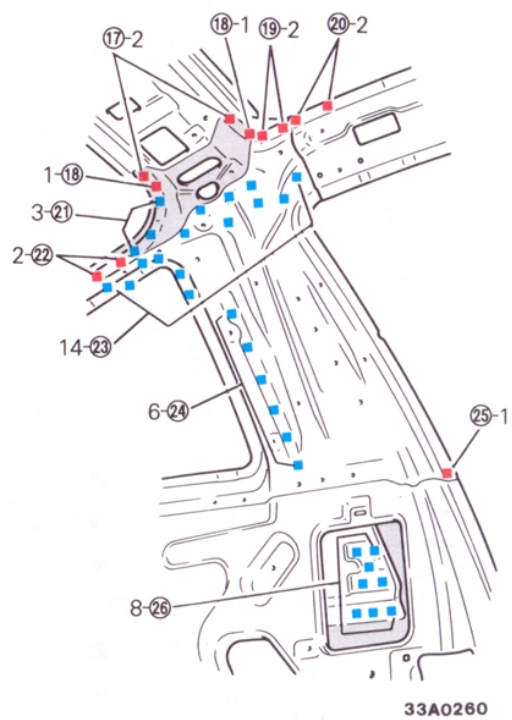
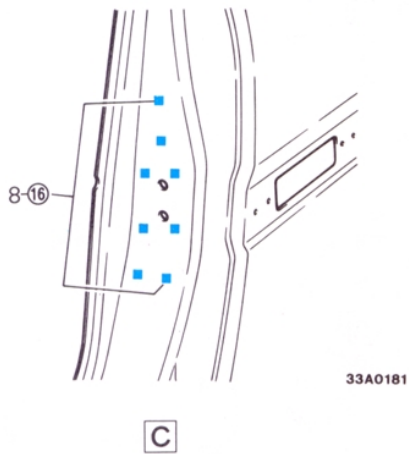
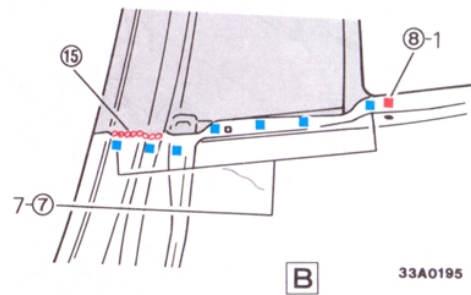
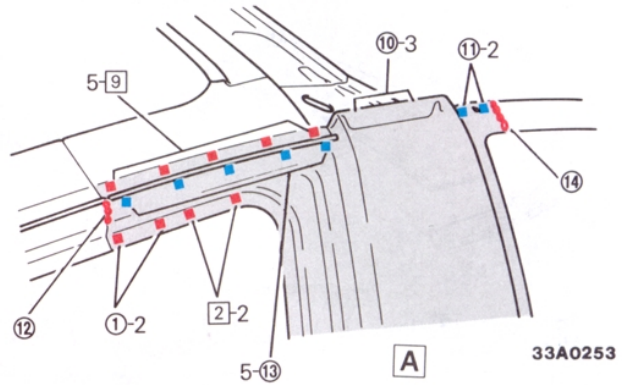
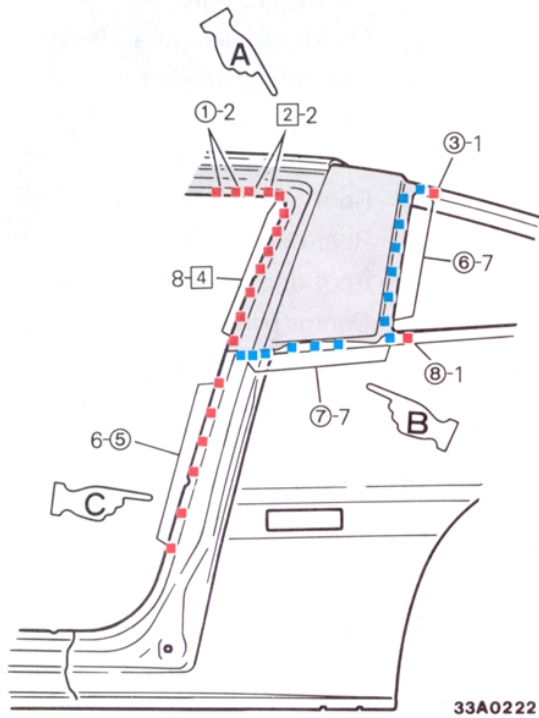
33A0245

CENTER PILLAR		PART NAME
REPLACEMENT CONFIGURATION	—	
<p>The diagram illustrates the assembly of the center pillar. Components include: A (Center pillar, outer), B (Center pillar reinforcement), C (Roof drip channel extension), D (Roof panel), E (Roof rear rail), F (Roof side rail, inner), G (Roof side rail, outer), H (Rear pillar, outer), I (Quarter panel, inner, upper), J (Quarter panel, inner, lower), K (Beltline reinforcement), and L (Quarter panel, outer). The diagram shows how these parts fit together to form the structural pillar and its surrounding panels.</p>		<p><b>A</b> Center pillar, outer</p> <p><b>B</b> Center pillar reinforcement</p> <p><b>C</b> Roof drip channel extension</p> <p><b>D</b> Roof panel</p> <p><b>E</b> Roof rear rail</p> <p><b>F</b> Roof side rail, inner</p> <p><b>G</b> Roof side rail, outer</p> <p><b>H</b> Rear pillar, outer</p> <p><b>I</b> Quarter panel, inner, upper</p> <p><b>J</b> Quarter panel, inner, lower</p> <p><b>K</b> Beltline reinforcement</p> <p><b>L</b> Quarter panel, outer</p>
		33A0273

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

[illegible]

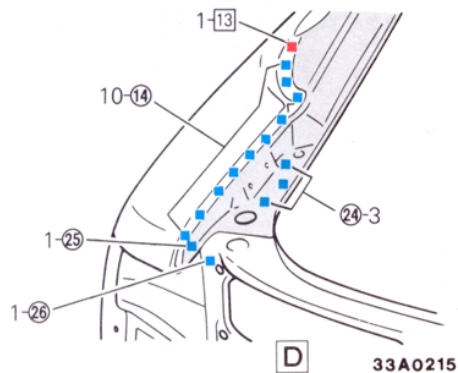
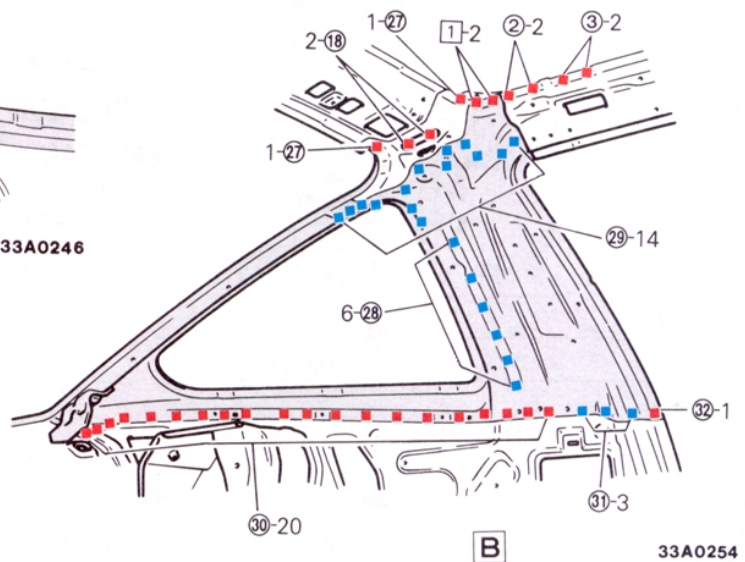
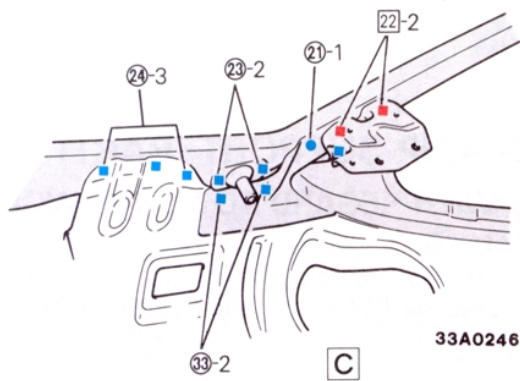
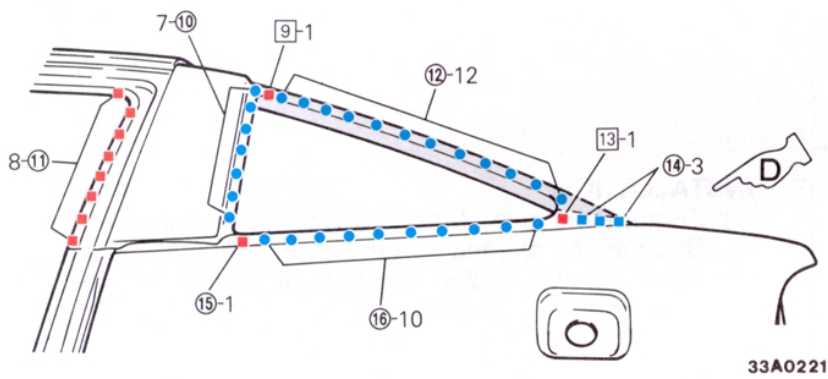
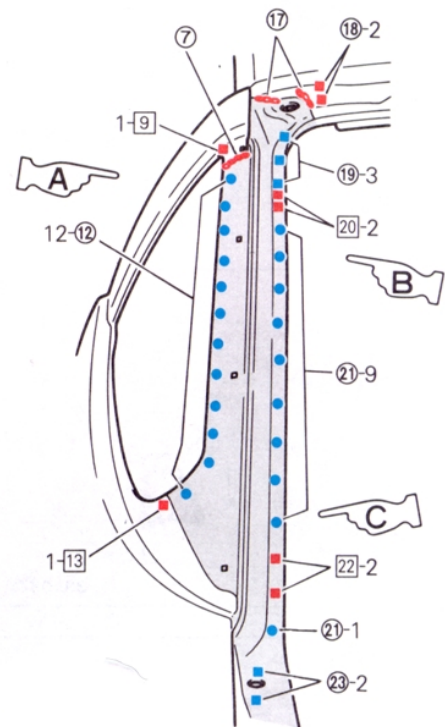
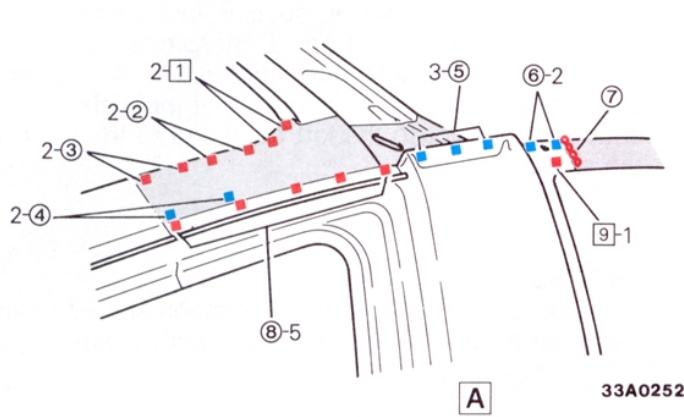




REAR PILLAR		PART NAME
REPLACEMENT CONFIGURATION		
<p>The diagram illustrates the rear pillar assembly with the following components labeled:</p> <ul style="list-style-type: none"> <li><b>A</b>: Rear pillar, outer</li> <li><b>B</b>: Quarter panel, inner, upper</li> <li><b>C</b>: Gas spring bracket</li> <li><b>D</b>: Drain pipe</li> <li><b>E</b>: Roof panel</li> <li><b>F</b>: Roof rear rail</li> <li><b>G</b>: Rear end panel</li> <li><b>H</b>: Roof drip channel extension</li> <li><b>I</b>: Center pillar reinforcement</li> <li><b>J</b>: Rear lamp housing</li> <li><b>K</b>: Quarter panel, inner, lower</li> <li><b>L</b>: Center pillar, outer</li> <li><b>M</b>: Quarter panel, outer</li> <li><b>N</b>: Beltline reinforcement</li> <li><b>O</b>: Side roof rail, inner</li> <li><b>P</b>: Side roof rail, outer</li> </ul>		<ul style="list-style-type: none"> <li><b>A</b> Rear pillar, outer</li> <li><b>B</b> Quarter panel, inner, upper</li> <li><b>C</b> Gas spring bracket</li> <li><b>D</b> Drain pipe</li> <li><b>E</b> Roof panel</li> <li><b>F</b> Roof rear rail</li> <li><b>G</b> Rear end panel</li> <li><b>H</b> Roof drip channel extension</li> <li><b>I</b> Center pillar reinforcement</li> <li><b>J</b> Rear lamp housing</li> <li><b>K</b> Quarter panel, inner, lower</li> <li><b>L</b> Center pillar, outer</li> <li><b>M</b> Quarter panel, outer</li> <li><b>N</b> Beltline reinforcement</li> <li><b>O</b> Side roof rail, inner</li> <li><b>P</b> Side roof rail, outer</li> </ul>

No.	Welded parts	F	R
①	<b>A + B + I</b>	2	■ 2
②	<b>A + I + O</b>	2	■ 2
③	<b>A + O + P</b>	2	■ 2
④	<b>A + P</b>	2	■ 2
⑤	<b>A + L</b>	3	■ 3
⑥	<b>A + L</b>	2	■ 2
⑦	<b>A + L</b>	MIG brazing	MIG brazing
⑧	<b>A + H + L</b>	5	■ 5
⑨	<b>A + B + L</b>	1	■ 1
⑩	<b>B + L</b>	7	■ 7
⑪	<b>B + I + L</b>	8	■ 8
⑫	<b>A + B</b>	12	■ 12
⑬	<b>A + B + M</b>	1	■ 1
⑭	<b>A + M</b>	10	■ 10
⑮	<b>B + L + M</b>	1	■ 1
⑯	<b>B + M</b>	10	■ 10
⑰	<b>A + E</b>	MIG brazing	MIG brazing
⑱	<b>A + E + F</b>	2	■ 2
⑲	<b>A + I</b>	3	■ 3
⑳	<b>A + B + I</b>	2	■ 2
㉑	<b>A + B</b>	10	■ 10

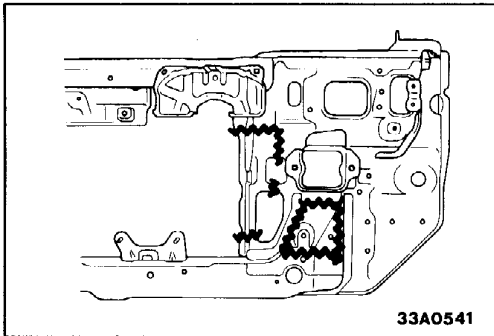
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## HEADLAMP SUPPORT (ASSEMBLY)

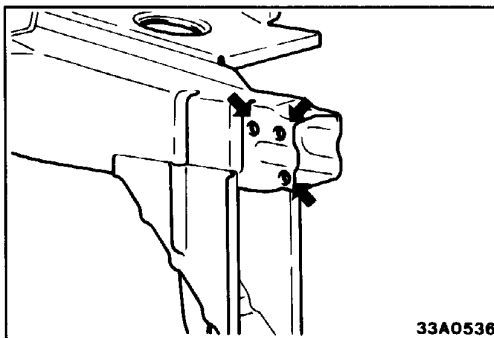
### NOTES WITH REGARD TO REPAIR WORK

- For points which have no specific instructions with regard to measurements in "Body Dimensions", determine two points on the headlamp support which are positioned symmetrically, and then confirm that the distances from the body center point to the left point and to the right point are the same.



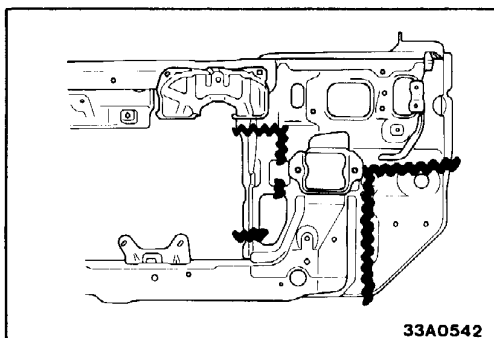
### REMOVAL

- (1) The locations shown in the illustration should be rough cut in order to facilitate separation of spot welds.



### INSTALLATION

- (1) Because the holes for plug welding of weld points ⑧ and ⑫ cannot be opened for new parts, the opening should be made where shown in the illustration of the front sidemember.



## HEADLAMP SUPPORT (PART)

### NOTES WITH REGARD TO REPAIR WORK

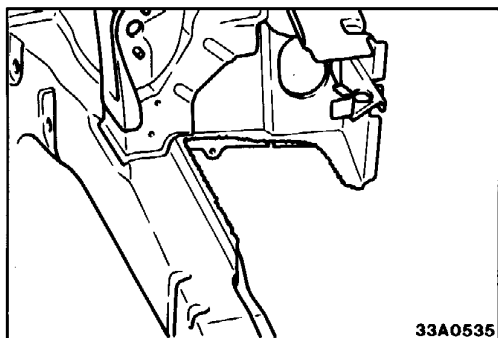
#### REMOVAL

- (1) The locations shown in the illustration should be rough cut in order to facilitate separation of spot welds.

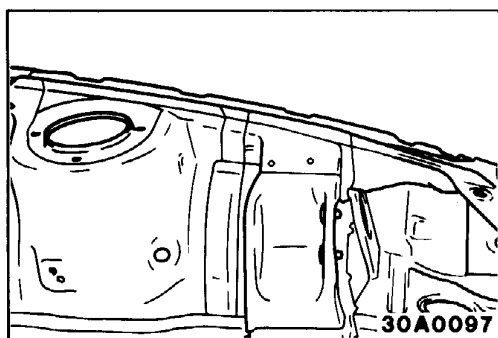


**FRONT FENDER SHIELD****NOTES WITH REGARD TO REPAIR WORK**

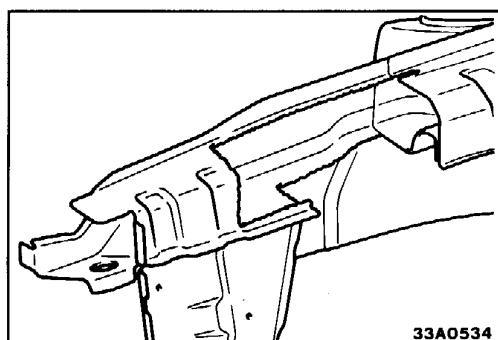
- The front upper frame (outer) and front upper frame (inner) should be butt-welded separately at the different position.

**REMOVAL**

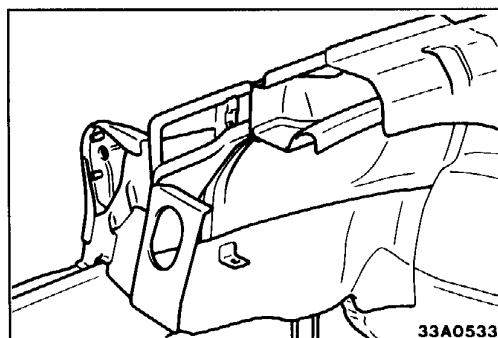
- (1) The shield plate should be rough cut in order to facilitate separation of spot welds.



- (2) Cut the front upper frame (outer) and front upper frame (inner) where shown in the illustration.



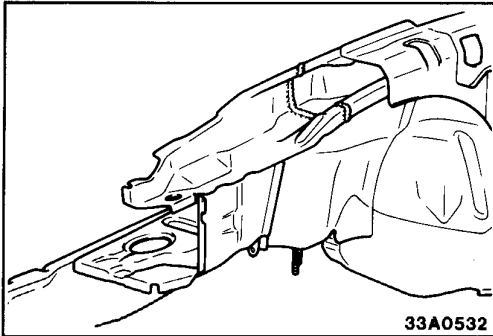
- (3) Rough-cut the front upper frame (outer) and front upper frame (inner) where shown in the illustration in order to separate weld point 25.

**INSTALLATION**

- (1) Rough-cut the new front upper frame (outer), leaving a margin for overlap.
- (2) Temporarily mount the rough-cut new front upper frame (outer) to the body, and then cut the two pieces (overlap with panel) together.

**Caution**

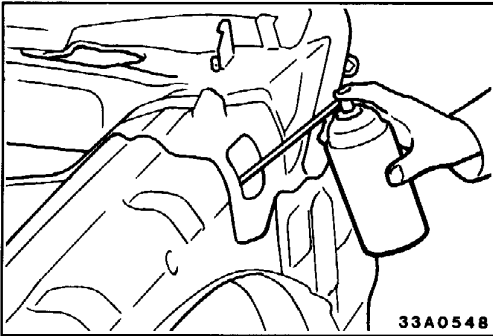
- Do not cut at the bead.



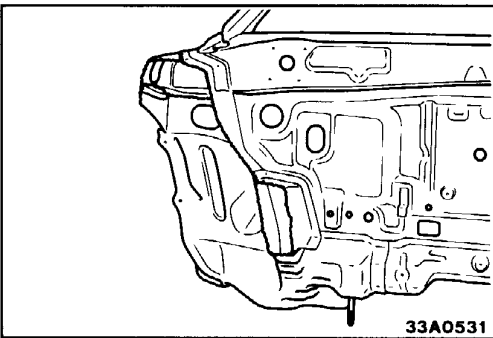
- (3) Cut the new front upper frame (inner), using the cut-out position at the body side as a reference.
- (4) First, install the front upper frame (inner) and the shield plate to the body, and weld.

**Caution**

- Weld point ②⑤ should be welded before installation of the front upper frame (outer).



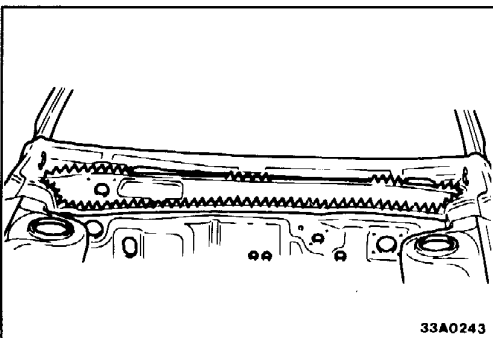
- (5) Then install the front upper frame (outer) to the body, and weld.
- (6) Apply a liberal amount of corrosion-prevention agent (using the hole indicated in the illustration) to the butt-weld locations.

**FENDER SHIELD ASSEMBLY****NOTES WITH REGARD TO REPAIR WORK****REMOVAL**

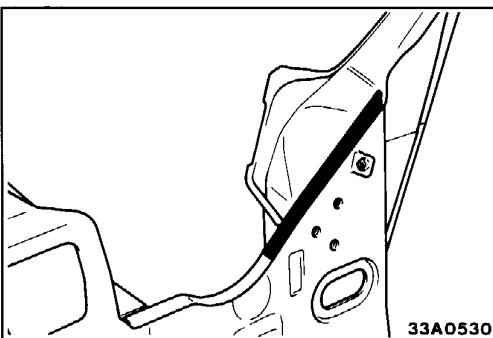
- (1) The locations shown in the illustration should be rough cut in order to facilitate separation of spot welds.

**Caution**

- Take care, when rough cutting, not to damage the dash panel, upper frame extension, etc.

**FRONT DECK****NOTES WITH REGARD TO REPAIR WORK****REMOVAL**

- (1) The locations shown in the illustration should be rough cut in order to facilitate separation of spot welds to the dash panel.

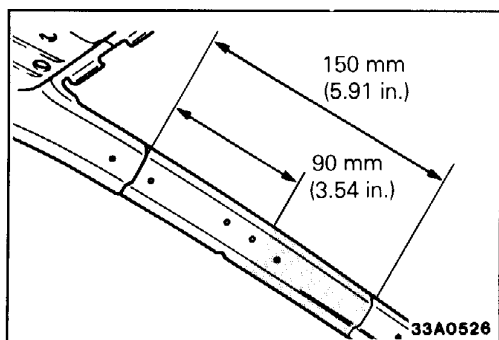
**INSTALLATION**

- (1) Apply a coating of silicon rubber sealer at the body side where shown in the illustration.

## FRONT PILLAR

### NOTES WITH REGARD TO REPAIR WORK

- When cutting the pillar, support the roof (by using portable power equipment, etc.) so that the roof does not sag.

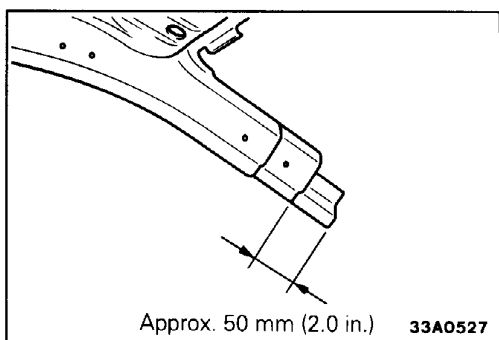


### REMOVAL

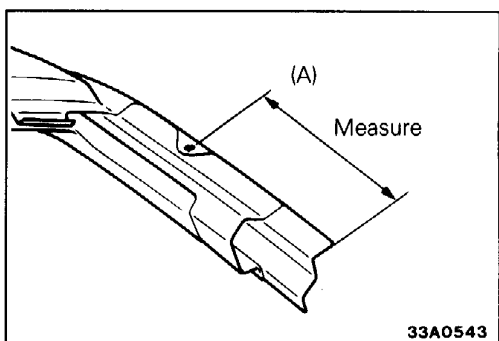
- (1) Cut the front pillar at a position 90 - 150 mm (3.54 - 5.91 in.) down from the end of the panel of the side roof rail (inner).

#### Caution

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



- (2) Cut only the front pillar (inner) and front pillar (inner upper) of the body side pillar approximately 50 mm (1.97 in.) upward from the cut-out.

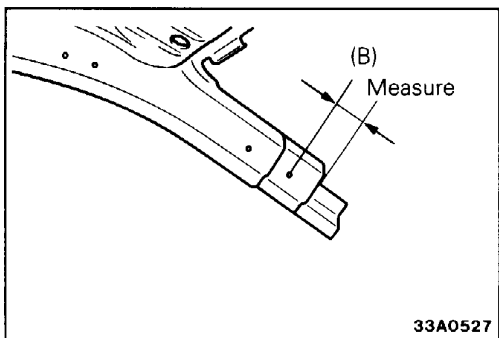


### INSTALLATION

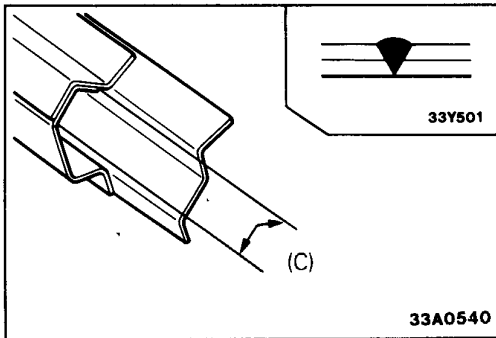
- (1) Measure the cut position of the body side pillar and make a mark on the new front pillar.

#### NOTE

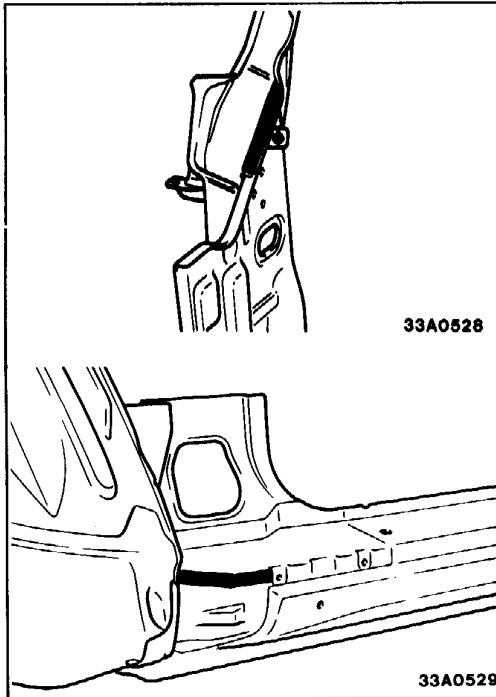
For the outer panel, use the drip moulding installation hole (A).



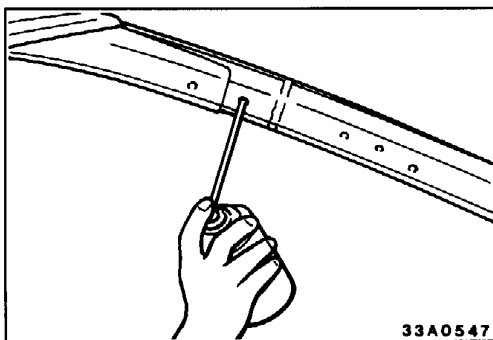
For the inner panel side, use the front pillar trim installation hole (B).



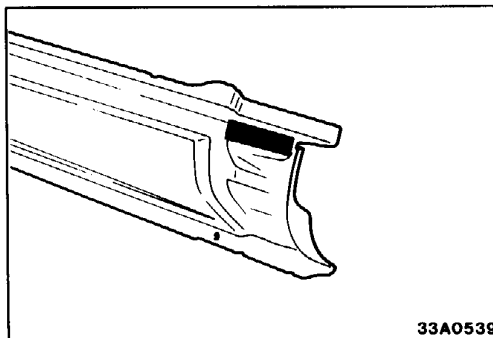
- (2) When butt-welding the part indicated by (C) in the illustration, cut the overlap part of the panel in a V shape so that bolt panels can be welded together, assuring better penetration during welding.



- (3) Apply a coating of silicon rubber sealer where shown in the illustration.



- (4) Apply a liberal amount of corrosion-prevention agent (using the front pillar trim installation hole) to the butt-weld locations.



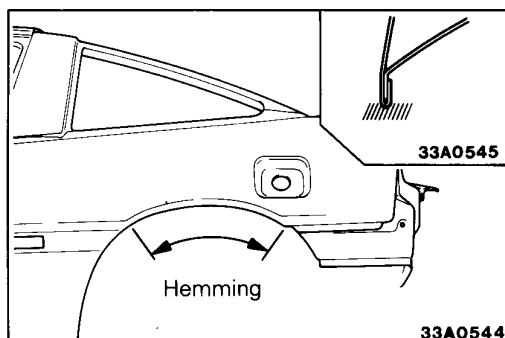
## SIDE SILL

### NOTES WITH REGARD TO REPAIR WORK

#### INSTALLATION

- (1) Apply a coating of silicon rubber sealer where shown in the illustration.





## QUARTER PANEL, OUTER

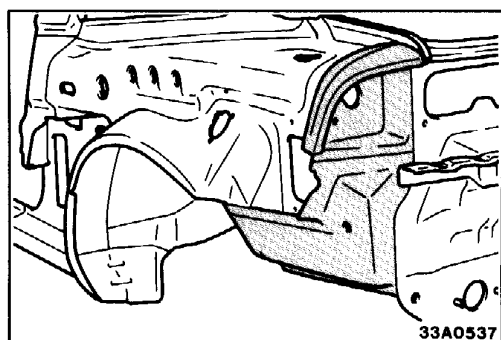
### NOTES WITH REGARD TO REPAIR WORK

#### REMOVAL

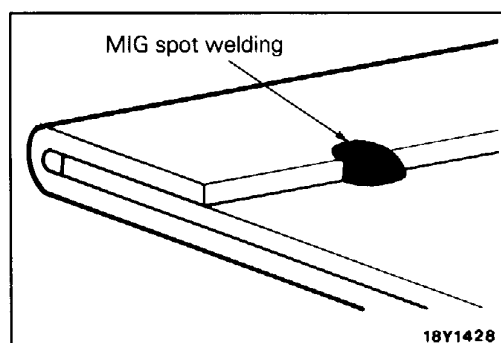
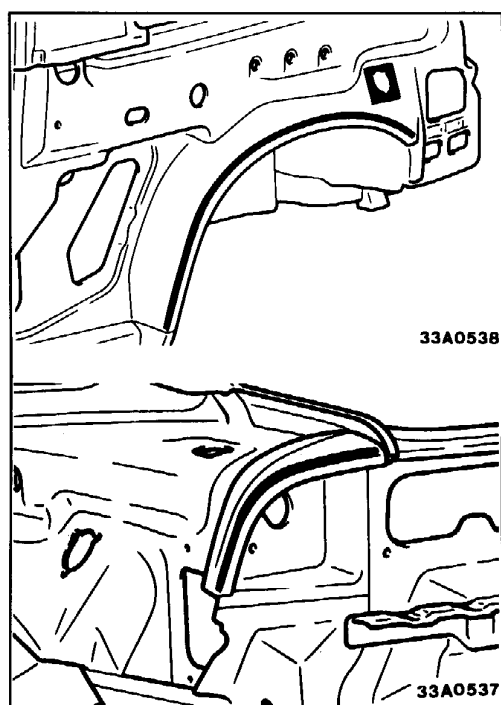
- (1) Be sure to cut weld point ③③, because it's difficult to find because of the finish after welding.
- (2) Because there is hemming at the wheel arch where shown in the illustration, grind away the bent part by using a grinder.

#### INSTALLATION

- (1) First install the rear lamp housing and quarter outer lower extension to the body, and then install the quarter panel (outer).



- (2) Apply a coating of silicon rubber sealer at the body side where shown in the illustration.



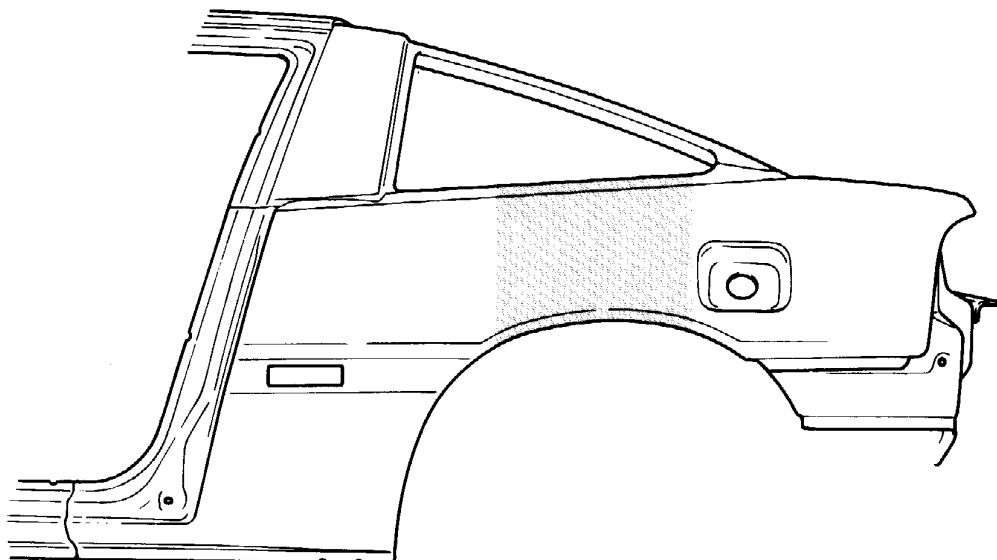
- (3) After completion of hemming, make MIG spot welds at the edge of the flange of the quarter panel (outer), at intervals of approximately 50 mm (1.97 in.). (Weld point: ⑮)

## 3-76 WELDED PANEL REPLACEMENT – Quarter Panel, Outer/Rear Floor Pan

Reference: Depending upon the scope of the damage, the part may be replaced.

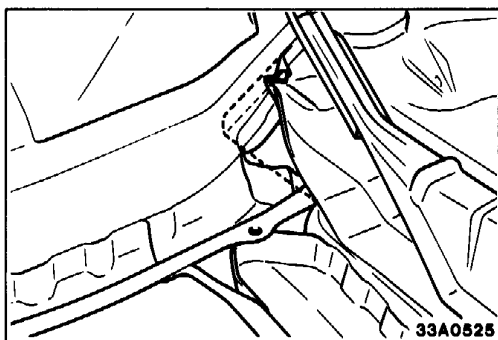
### Caution

- Avoid the installation holes for the rear spoiler, etc.



33A0193

 : Range within which cutting is possible



33A0525

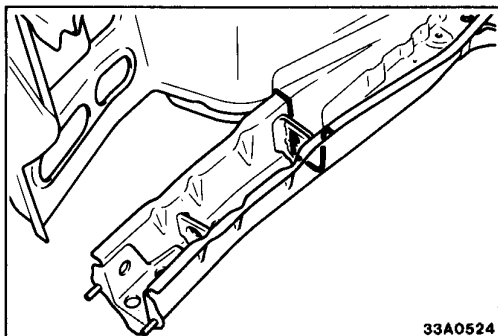
## REAR FLOOR PAN

### NOTES WITH REGARD TO REPAIR WORK

- In order to facilitate the removal and installation of the rear floor pan, bend both ends of the rear seat pan as shown in the illustration.

### Caution

- Bend the rear seat pan the minimum necessary only.



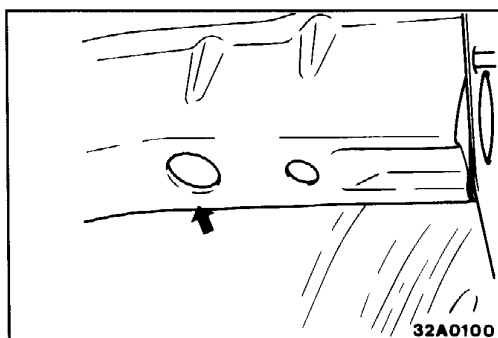
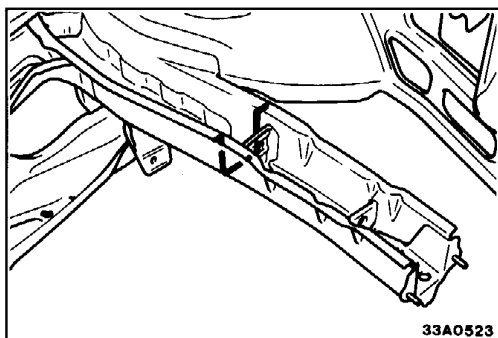
## REAR FLOOR SIDEMEMBER

### NOTES WITH REGARD TO REPAIR WORK

- Cut the rear floor sidemember where shown in the illustration.

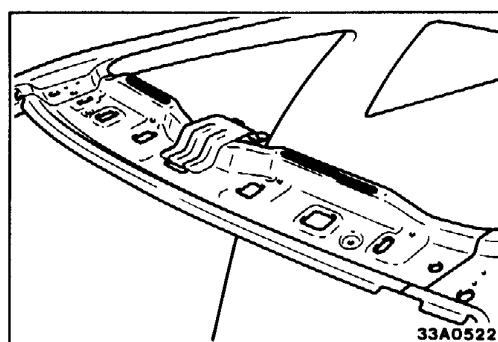
#### NOTE

If the cut is made at a place where there is a reinforcement, make the butt-welding from both sides (inner and outer) of the sidemember.



### INSTALLATION

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

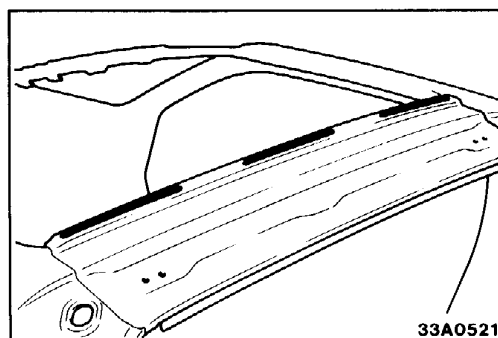


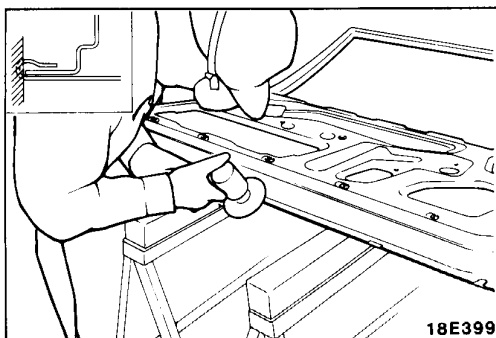
## ROOF PANEL

### NOTES WITH REGARD TO REPAIR WORK

#### INSTALLATION

- (1) Apply a coating of silicon rubber sealer where shown in the illustration.





## FRONT DOOR OUTER PANEL

### NOTES WITH REGARD TO REPAIR WORK

- Do the welding of the outer panel and the inner panel by making MIG spot welds to the bent flange part of the outer panel at intervals of approximately 50 mm (2 in.).

### REMOVAL

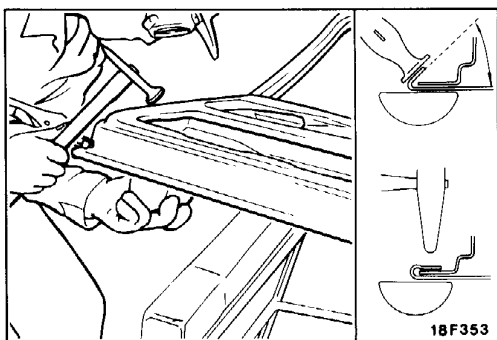
- (1) Use an air grinder to grind off the hemming edge of the perimeter of the outer panel.

### INSTALLATION

- (1) Install the outer panel to the inner panel.

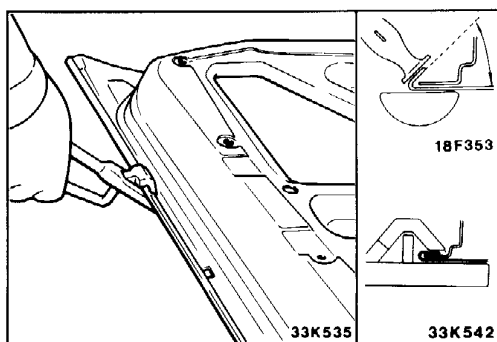
#### Caution

- **Clamp backings onto the outside of the outer panel in order to prevent scratching it.**



- (2) Using either a hammer and dolly or a hammer and hemming tool, do the hemming work for the entire circumference of the outer panel.

- Using a hammer and dolly.



- Using a hammer and hemming tool

#### NOTE

Do the hemming work by folding the edge in two stages. When completed, the outer perimeter edge should be well rounded.