

# 3

# WELDED PANEL REPLACEMENT

EXPLANATION OF MANUAL CONTENTS .....	3-2
WELDING POINTS AND WELDING PROCEDURE	
NOTES WITH REGARD TO REPAIR WORK	
HEADLAMP SUPPORT (ASSEMBLY) ...	3-4
HEADLAMP SUPPORT (PART) .....	3-6
FRONT END UPPER BAR .....	3-8
FRONT FENDER SHIELD .....	3-10
FENDER SHIELD ASSEMBLY .....	3-12
FRONT DECK .....	3-14
FRONT PILLAR .....	3-16
SIDE SILL .....	3-18
QUARTER PANEL, OUTER .....	3-20
REAR END PANEL <2WD> .....	3-24
REAR END PANEL <4WD> .....	3-26
REAR FLOOR PAN <2WD> .....	3-28
REAR FLOOR PAN <4WD> .....	3-30
REAR END CROSMEMBER <4WD> .....	3-32

REAR FLOOR SIDEMEMBER <2WD> .....	3-24	77
REAR FLOOR SIDEMEMBER <4WD> .....	3-38	77
ROOF PANEL .....	3-42	77
ROOF PANEL (WITH SUNROOF) ....	3-44	77
FRONT DOOR OUTER PANEL .....	3-46	78
DASH PANEL .....	3-48	—
FRONT FLOOR PAN <2WD> .....	3-50	—
FRONT FLOOR PAN <4WD> .....	3-52	—
REAR SEAT PAN <2WD> .....	3-54	—
REAR SEAT PAN <4WD> .....	3-56	—
LATERAL ROD BRACKET<2WD> ..	3-58	—
REAR FLOOR CROSMEMBER <4WD> .....	3-60	—
QUARTER PANEL, INNER .....	3-62	—
REAR WHEELHOUSE, INNER .....	3-64	—
CENTER PILLAR .....	3-66	—
REAR PILLAR .....	3-68	—

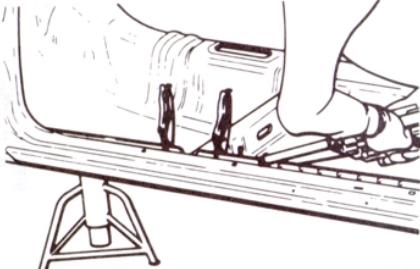
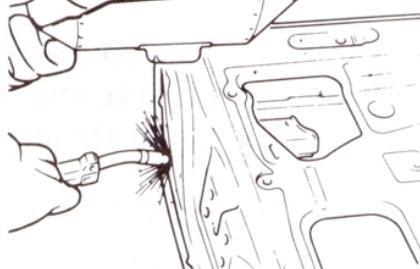
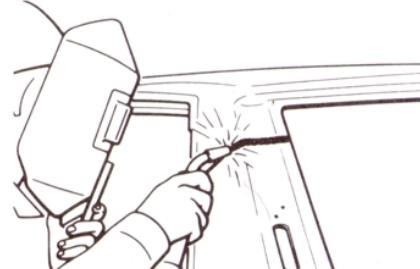
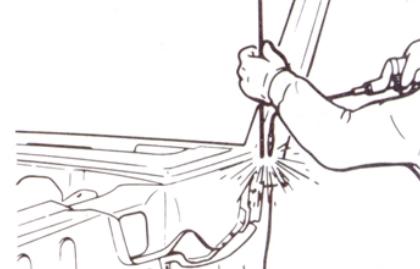
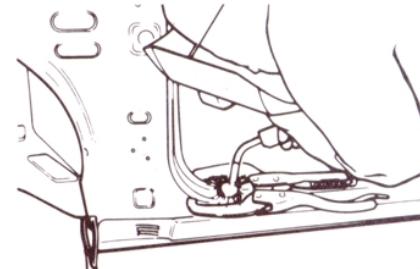
# WELDED PANEL REPLACEMENT

## 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
○○○○○○○○	Braze welding	 18YV09
■ ■ ■ ■	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.

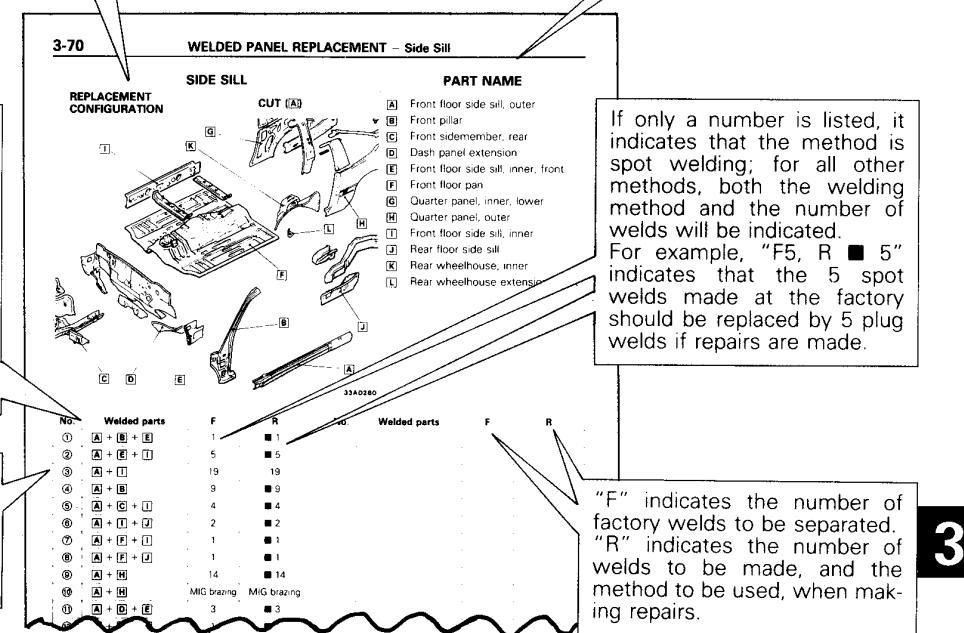
Shows the part names keyed by symbols in the illustration.

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.

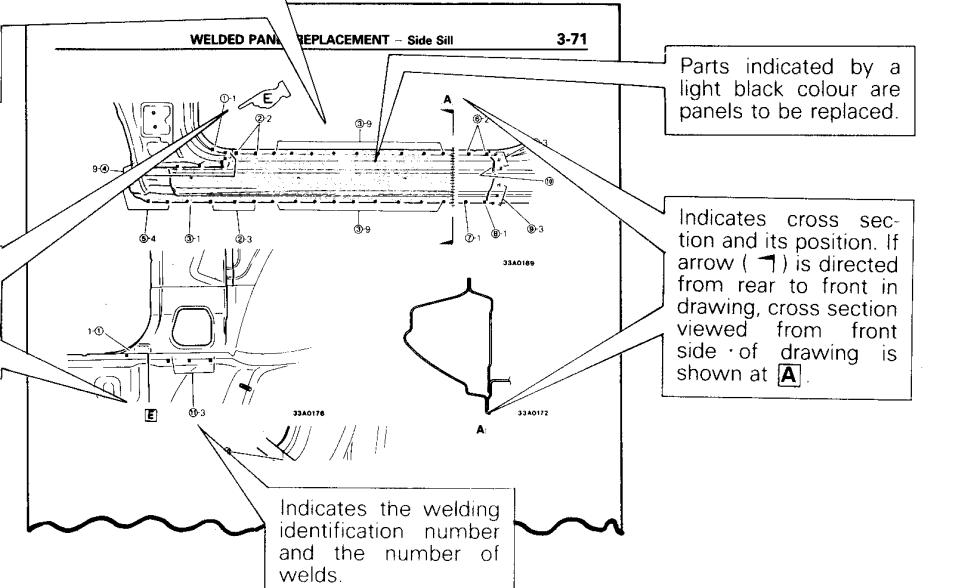
★ This mark is used to indicate the weld of a part which is especially important to the vehicle body from a structural viewpoint: therefore, the weld must be made securely.

The weld point classification numbers are indicated:  
 indicates one panel to be replaced.  
 indicates two (or more) panels to be replaced.



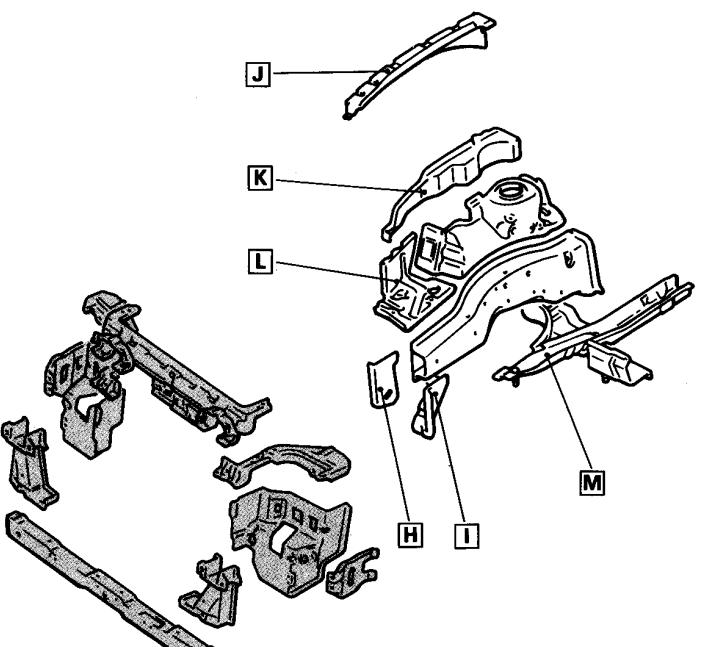
For weld points (flange parts, etc.) on the same surface, only weld points at both ends are indicated; weld points between those end weld points are omitted.

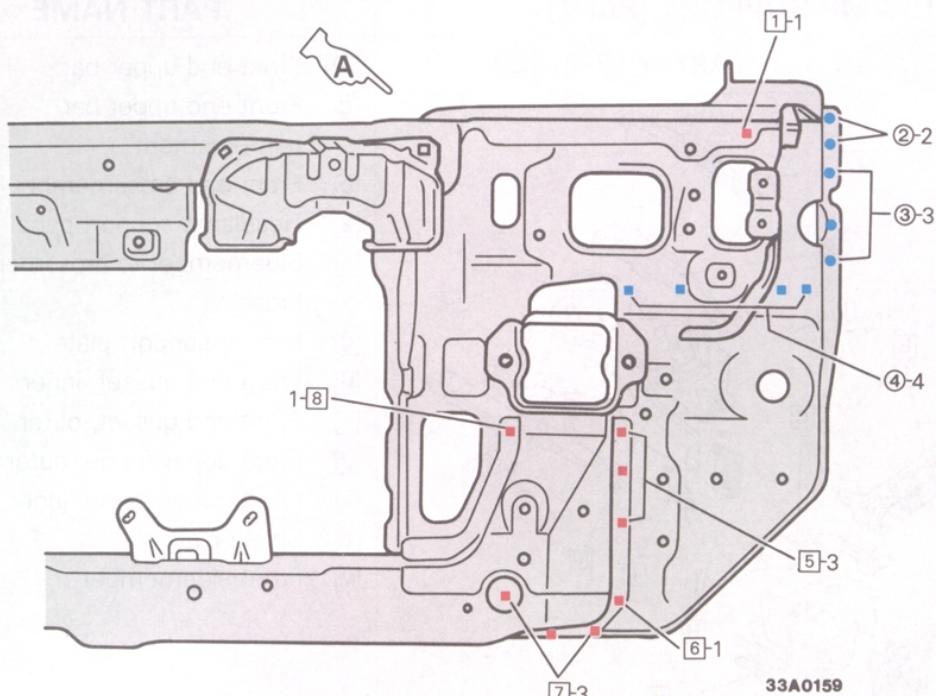
Indicates a view as seen from the direction of the finger.  
 " " indicates that the view as seen from the direction of " " is shown in figure **E**.



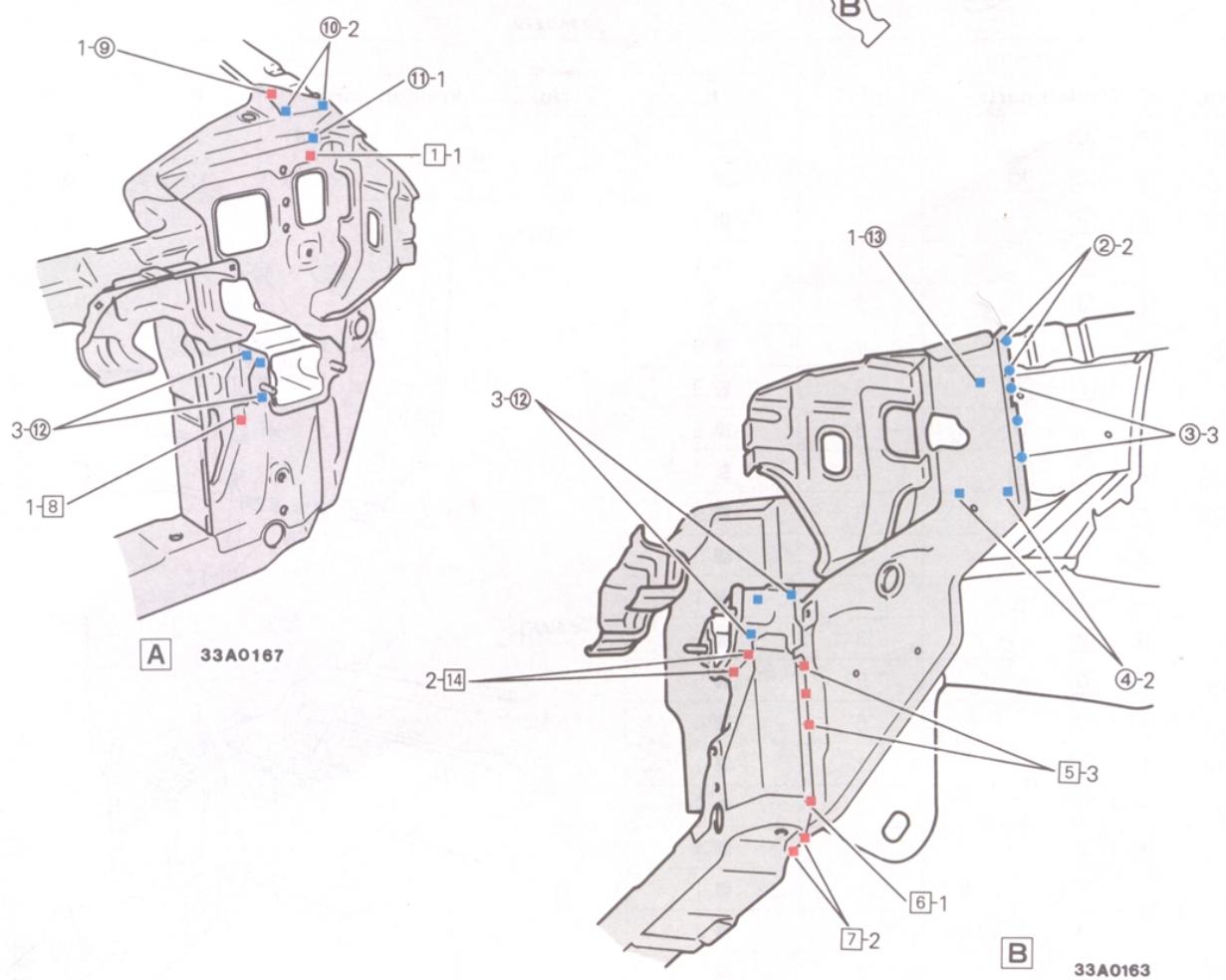
## NOTES WITH REGARD TO REPAIR WORK

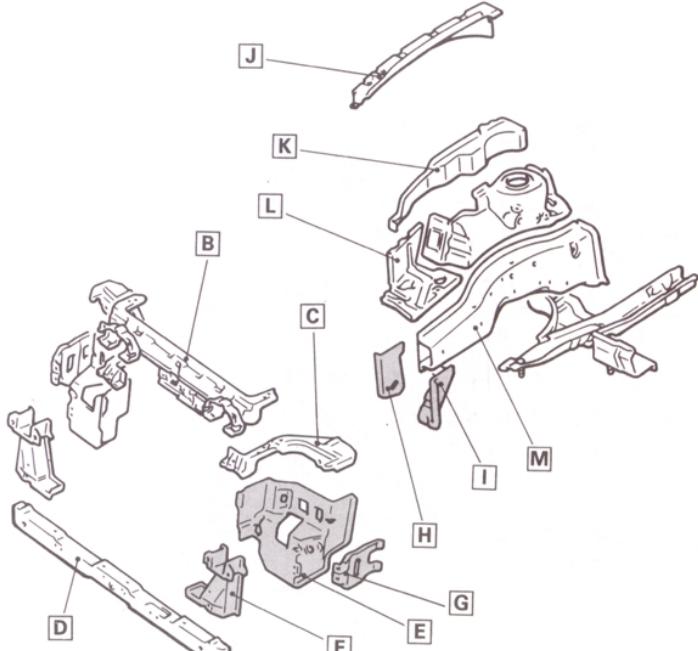
Notes with regard to repair work are given at the end of the "Welded Panel Replacement."

HEADLAMP SUPPORT (ASSEMBLY)		PART NAME
REPLACEMENT CONFIGURATION	ASSEMBLY (A)	
	 <p>ASSEMBLY (A) components labeled:</p> <ul style="list-style-type: none"> <li>J: Headlamp support</li> <li>H: Front end gusset, inner</li> <li>I: Front end gusset, outer</li> <li>J: Front upper frame, outer</li> <li>K: Front upper frame, inner</li> <li>L: Shield plate</li> <li>M: Front sidemember</li> </ul>	<p><b>A</b> Headlamp support</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>



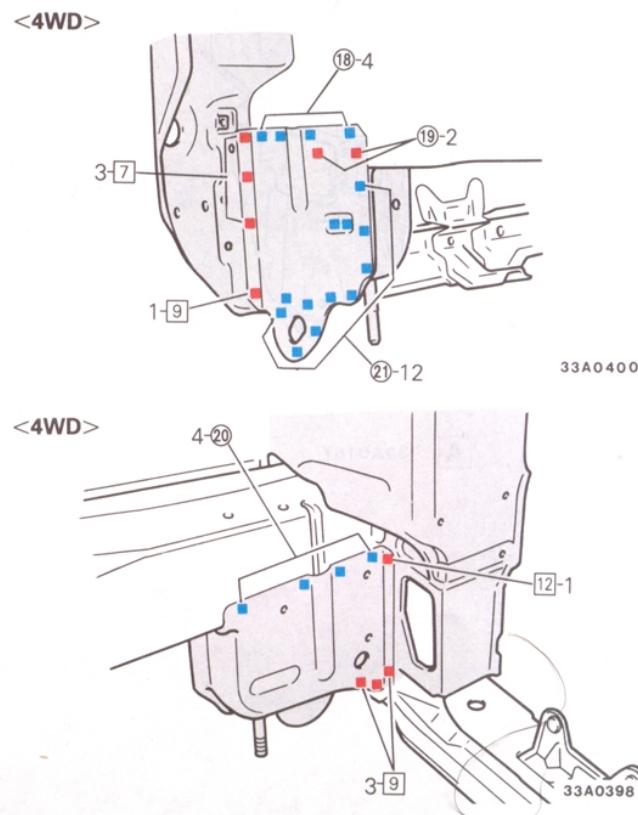
3

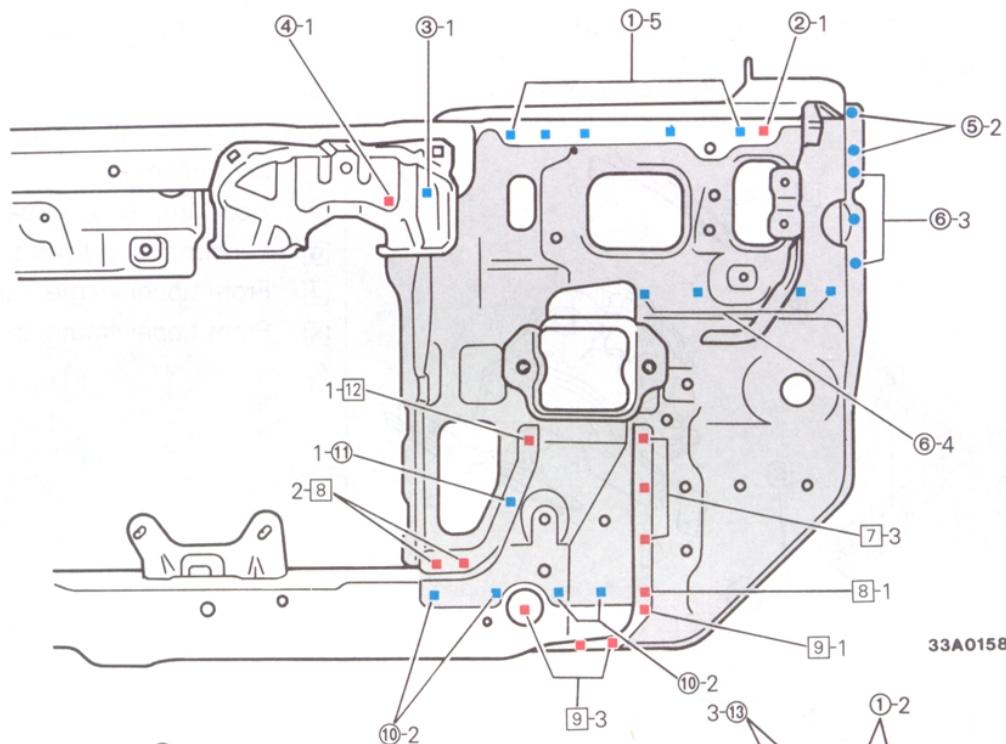


HEADLAMP SUPPORT (PART)		PART NAME
REPLACEMENT CONFIGURATION	PART (E F G H I)	
	 <p>33A0279</p>	<p><b>B</b> Front end upper bar  <b>C</b> Front end upper bar reinforcement  <b>D</b> Front end crossmember  <b>E</b> Headlamp support panel  <b>F</b> Sidemember to crossmember brace  <b>G</b> Fender support plate  <b>H</b> Front end gusset, inner  <b>I</b> Front end gusset, outer  <b>J</b> Front upper frame, outer  <b>K</b> Front upper frame, inner  <b>L</b> Shield plate  <b>M</b> Front sidemember       </p>

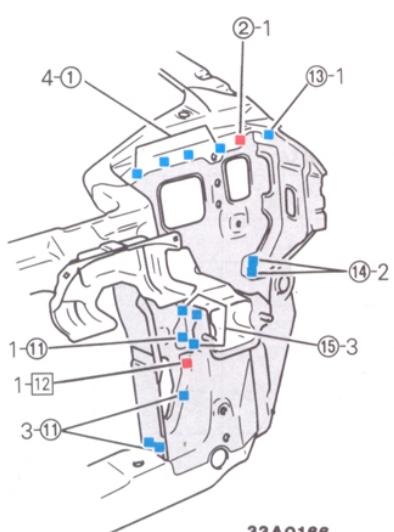
No.	Welded parts	F	R
①	<b>E</b> + <b>C</b>	7	7
②	<b>E</b> + <b>C</b> + <b>K</b>	1	■ 1
③	<b>E</b> + <b>B</b>	1	■ 1
④	<b>E</b> + <b>B</b>	1	■ 1
⑤	<b>E</b> + <b>J</b>	2	2
⑥	<b>E</b> + <b>L</b>	9	■ 9
⑦	<b>E</b> + <b>F</b> + <b>I</b>	3	■ 3
⑧	<b>E</b> + <b>I</b> + <b>D</b>	3	■ 3
⑨	<b>E</b> + <b>H</b> + <b>D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

No.	Welded parts	F	R
㉑	<b>H</b> + <b>I</b>	2WD 7	■ 7
㉑	<b>H</b> + <b>I</b>	4WD 12	■ 12

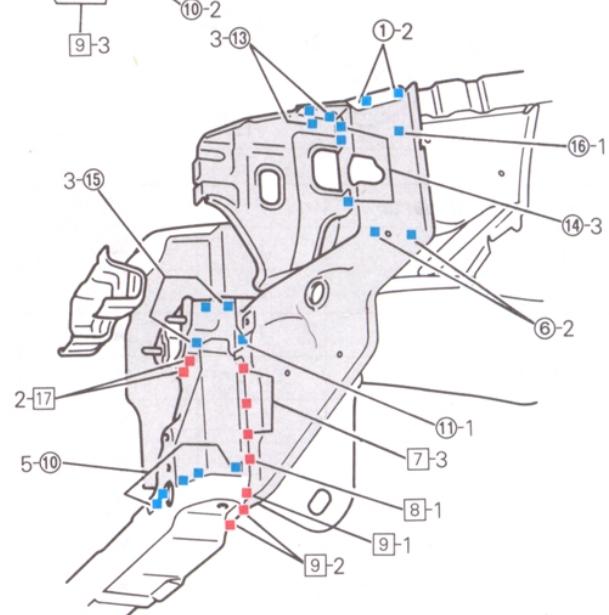




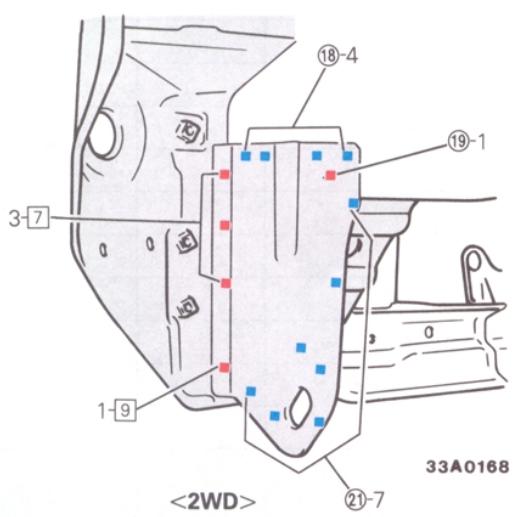
33A0158



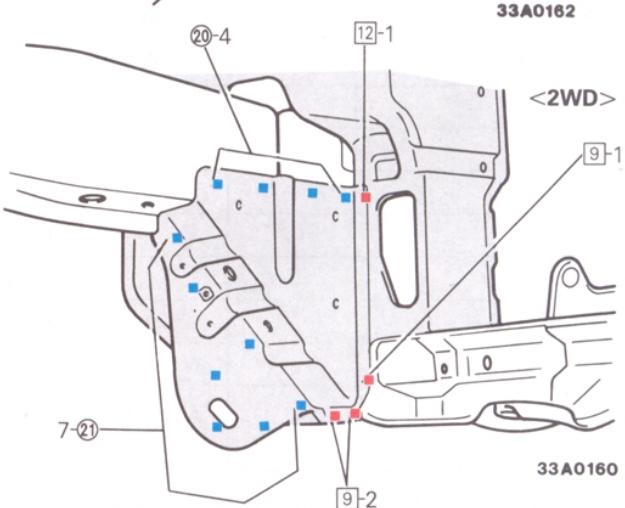
33A0166



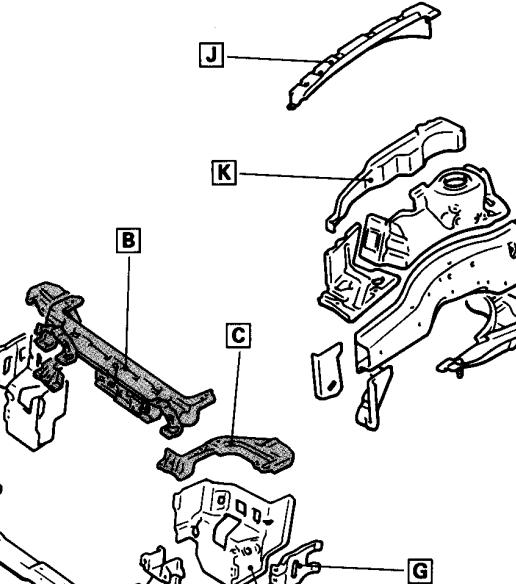
33A0162

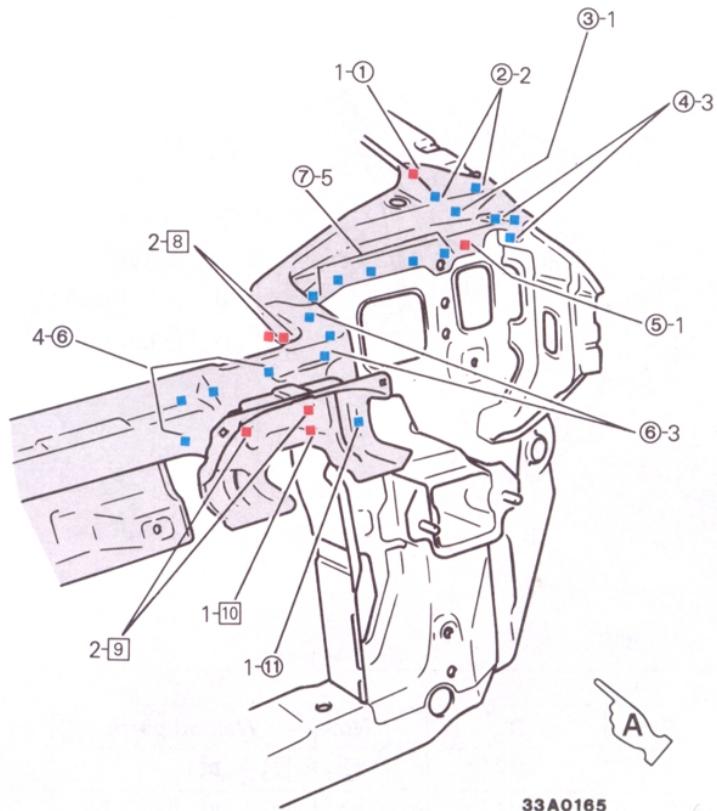


33A0168

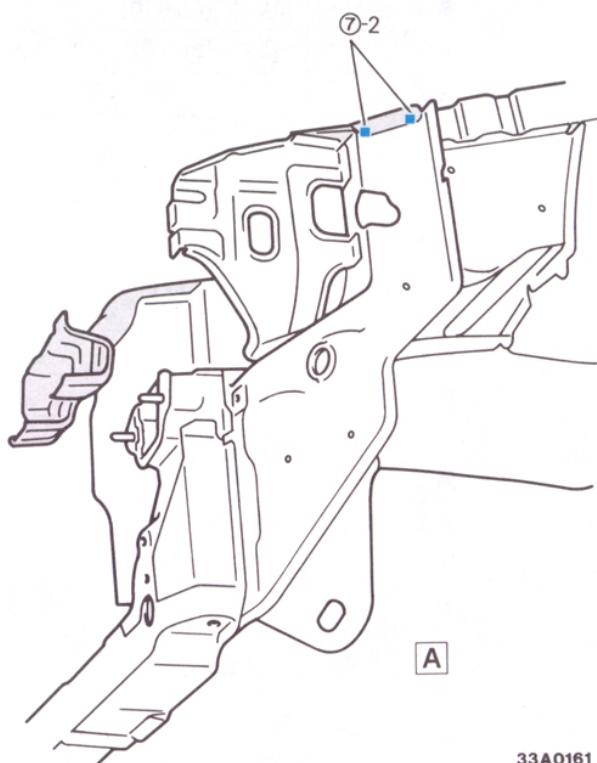


33A0160

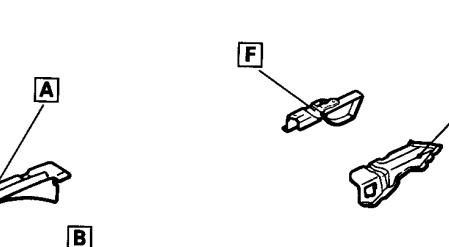
FRONT END UPPER BAR	PART NAME
REPLACEMENT CONFIGURATION	ASSEMBLY (B C)
	<p><b>B</b> Front end upper bar</p> <p><b>C</b> Front end upper bar reinforcement</p> <p><b>E</b> Headlamp support panel</p> <p><b>G</b> Fender support plate</p> <p><b>J</b> Front upper frame, outer</p> <p><b>K</b> Front upper frame, inner</p>



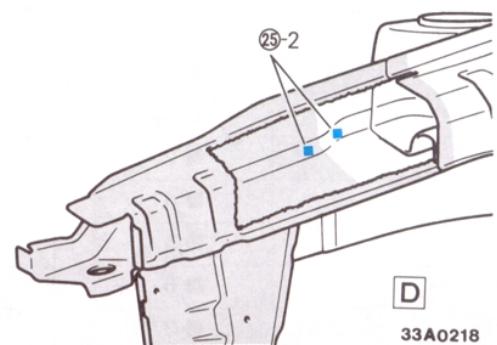
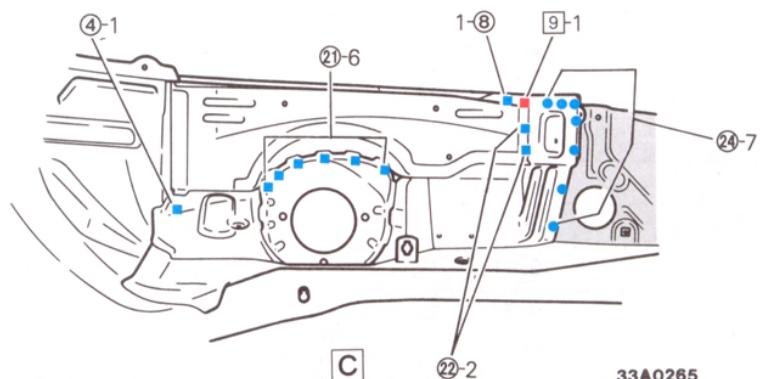
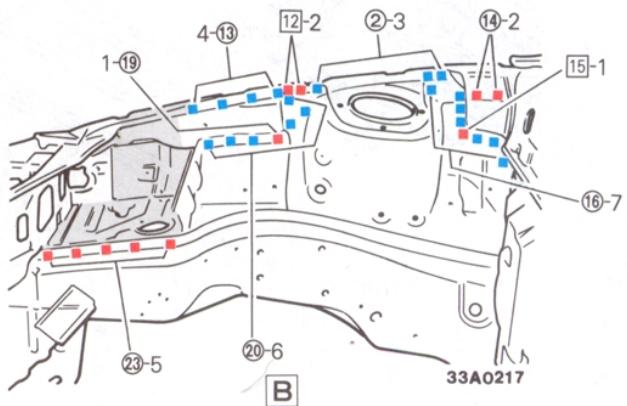
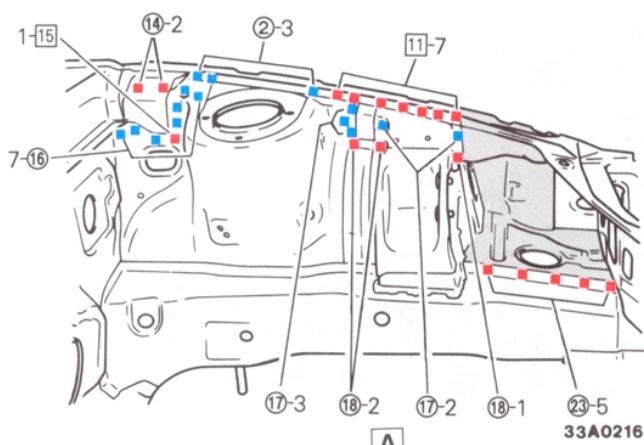
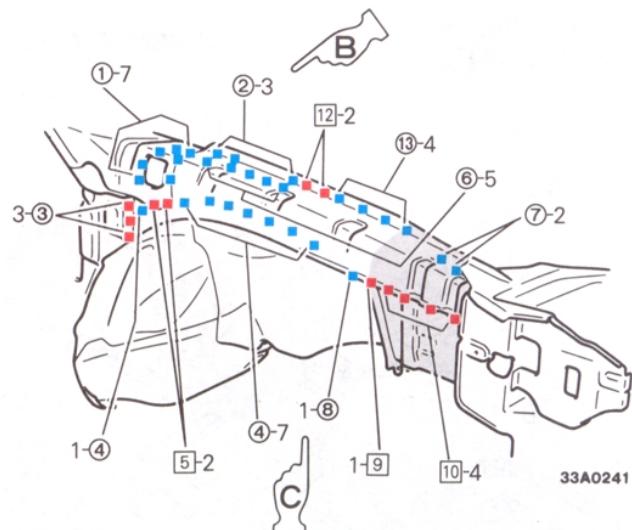
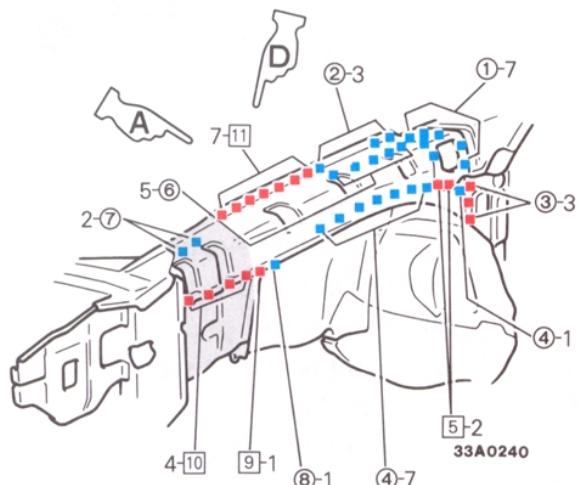
33A0165

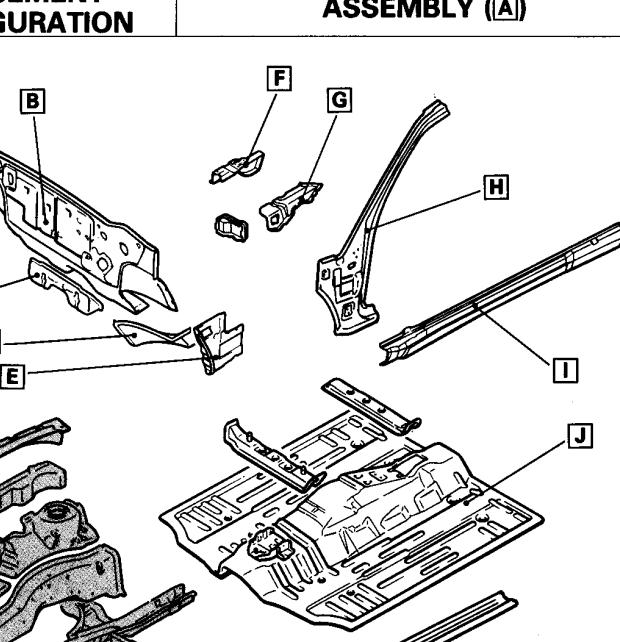


33A0161

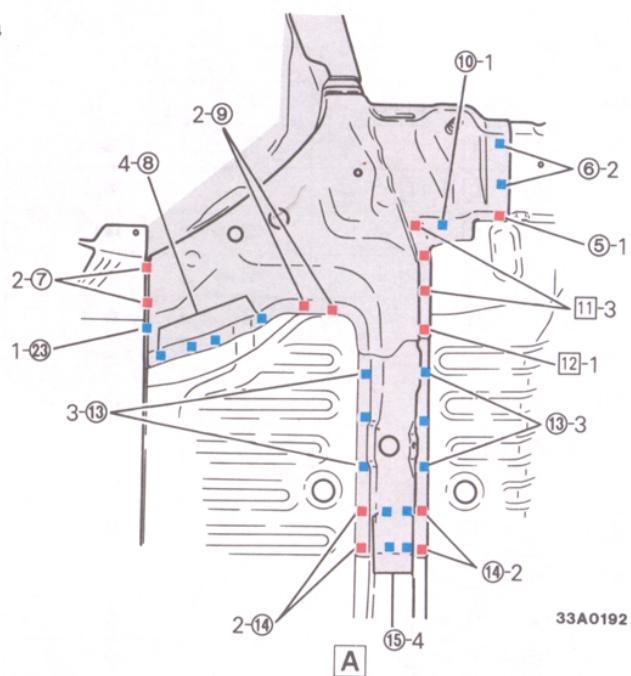
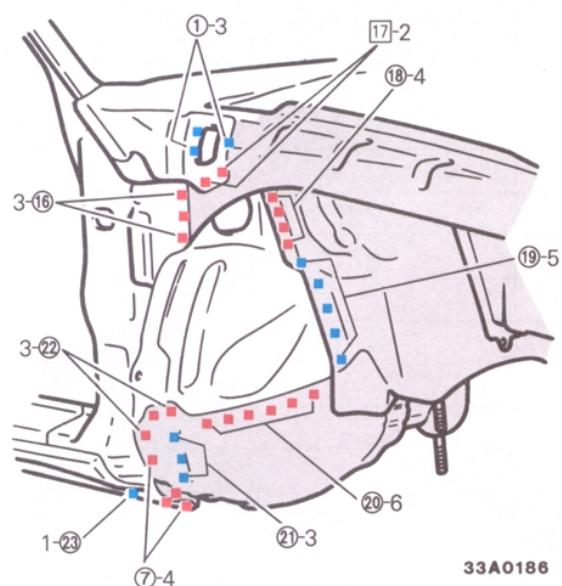
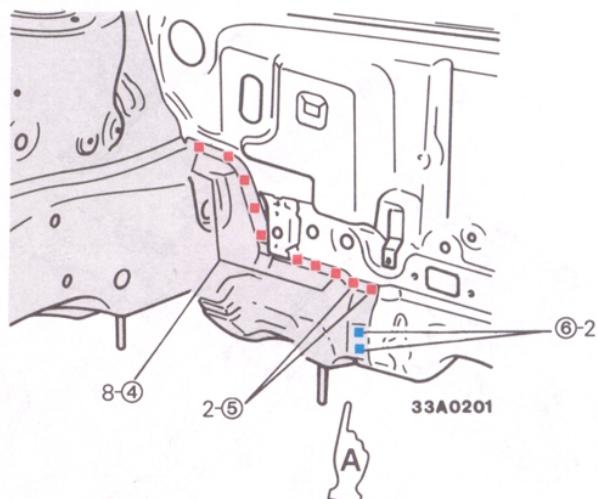
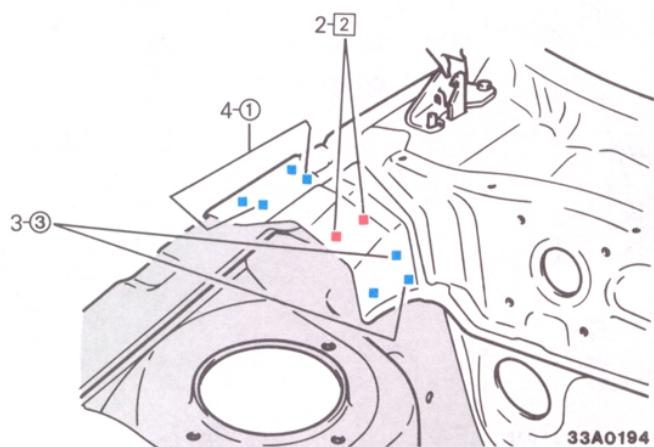
FRONT FENDER SHIELD	PART NAME
REPLACEMENT CONFIGURATION	CUT (A B C)
	<p><b>CUT (A B C)</b></p> <ul style="list-style-type: none"> <li><b>A</b> Front upper frame, outer</li> <li><b>B</b> Front upper frame, inner</li> <li><b>C</b> Shield plate</li> <li><b>D</b> Front fender shield</li> <li><b>E</b> Front sidemember</li> <li><b>F</b> Front upper frame extension, inner</li> <li><b>G</b> Front upper frame extension, outer</li> <li><b>H</b> Front pillar</li> <li><b>I</b> Dash panel</li> </ul>

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

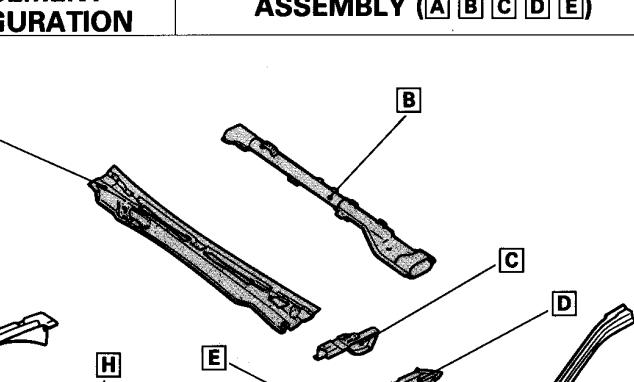


FENDER SHIELD ASSEMBLY		PART NAME
REPLACEMENT CONFIGURATION	ASSEMBLY (A)	
		
		<b>A</b> Fender shield
		<b>B</b> Dash panel
		<b>C</b> Dash panel crossmember
		<b>D</b> Dash panel extension
		<b>E</b> Front floor side sill, inner, front
		<b>F</b> Upper frame extension, inner
		<b>G</b> Upper frame extension,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

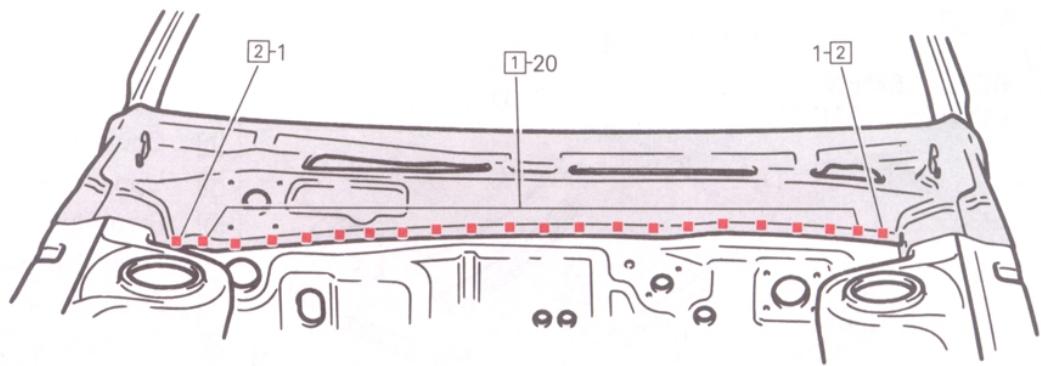
No.	Welded parts	F	R
①	[A] + [G]	7	■ 7
②	[A] + [F]	2	■ 2
③	[A] + [F]	3	■ 3
④	[A] + [B]	8	■ 8
⑤	[A] + [B] + [C]	3	■ 3
⑥	[A] + [C]	4	■ 4
⑦	[A] + [E] + [I]	4	■ 4
⑧	[A] + [D]	4	■ 4
⑨	[A] + [D] + [J]	2	■ 2
⑩	[A] + [B]	1	■ 1
⑪	[A] + [B]	3	■ 3
⑫	[A] + [J]	1	■ 1
⑬	[A] + [J]	6	■ 6
⑭	[A] + [J] + [K]	4	■ 4
⑮	[A]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



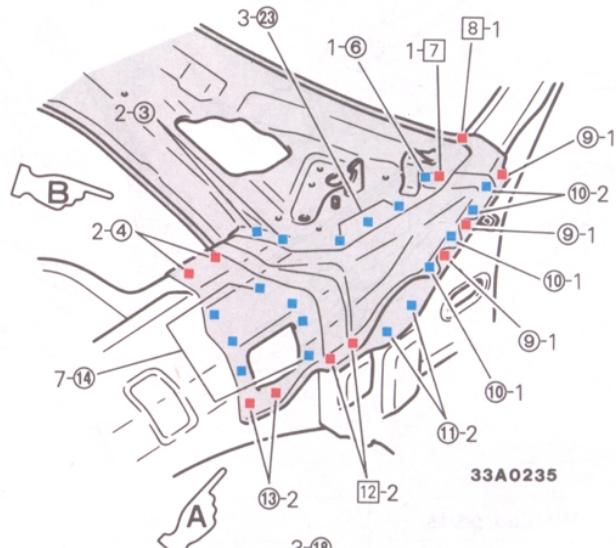
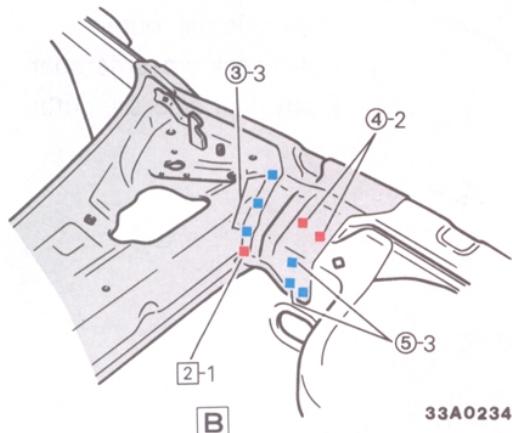
NOTE: Refer to P.3-4 for information concerning welding points with headlamp support.

FRONT DECK		PART NAME
REPLACEMENT CONFIGURATION	ASSEMBLY (A B C D E)	
		<p><b>A</b> Cowl top panel  <b>B</b> Front deck crossmember  <b>C</b> Upper frame inner extension  <b>D</b> Upper frame outer extension  <b>E</b> Upper frame silencer  <b>F</b> Front upper frame, outer  <b>G</b> Front upper frame, inner  <b>H</b> Strut house panel  <b>I</b> Dash panel  <b>J</b> Front pillar     </p>

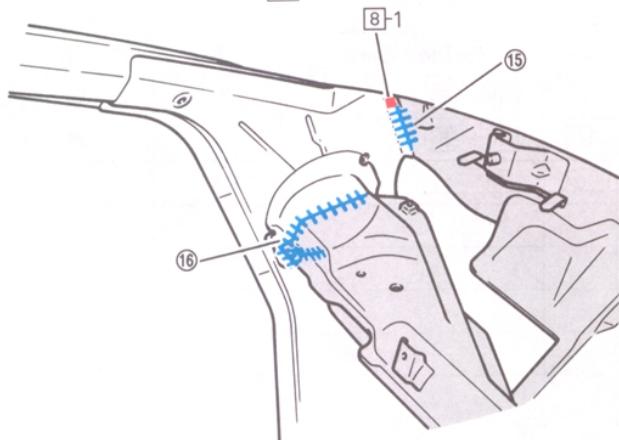
No.	Welded parts	F	R
①	[A] + [I]	20	■ 20
②	[A] + [C] + [I]	1	■ 1
③	[A] + [C]	3	■ 3
④	[C] + [F] + [H]	2	■ 2
⑤	[C] + [H]	3	■ 3
⑥	[A] + [D]	1	■ 1
⑦	[A] + [D]	1	■ 1
⑧	[A] + [J]	1	■ 1
⑨	[A] + [J]	3	■ 3
⑩	[A] + [D]	4	■ 4
⑪	[A] + [J]	2	■ 2
⑫	[A] + [D] + [J]	2	■ 2
⑬	[D] + [F] + [G]	2	■ 2
⑭	[D] + [F]	7	■ 7
⑮	[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



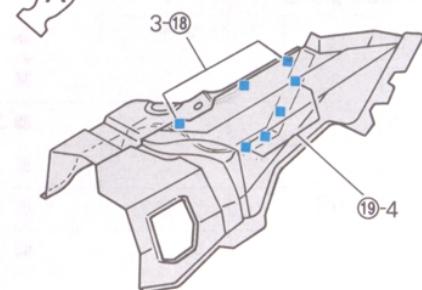
A0242



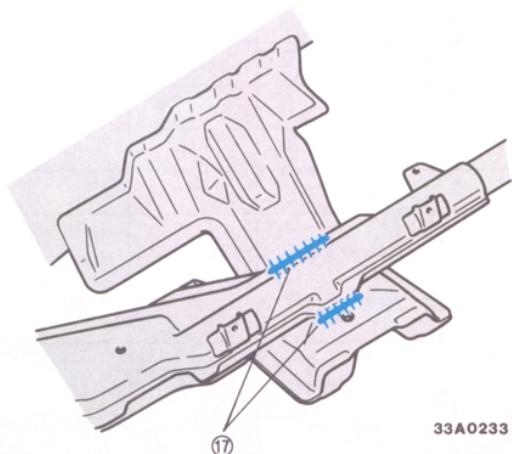
33A0235



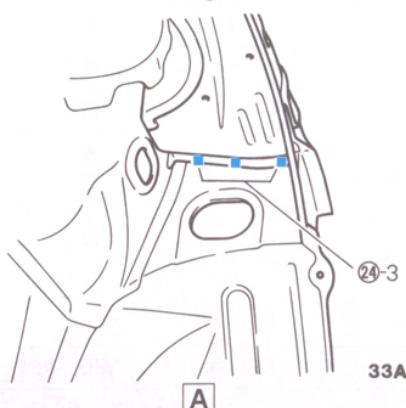
33A0184



33A0207



33A0233



33A0231

**FRONT PILLAR**

**REPLACEMENT CONFIGURATION**

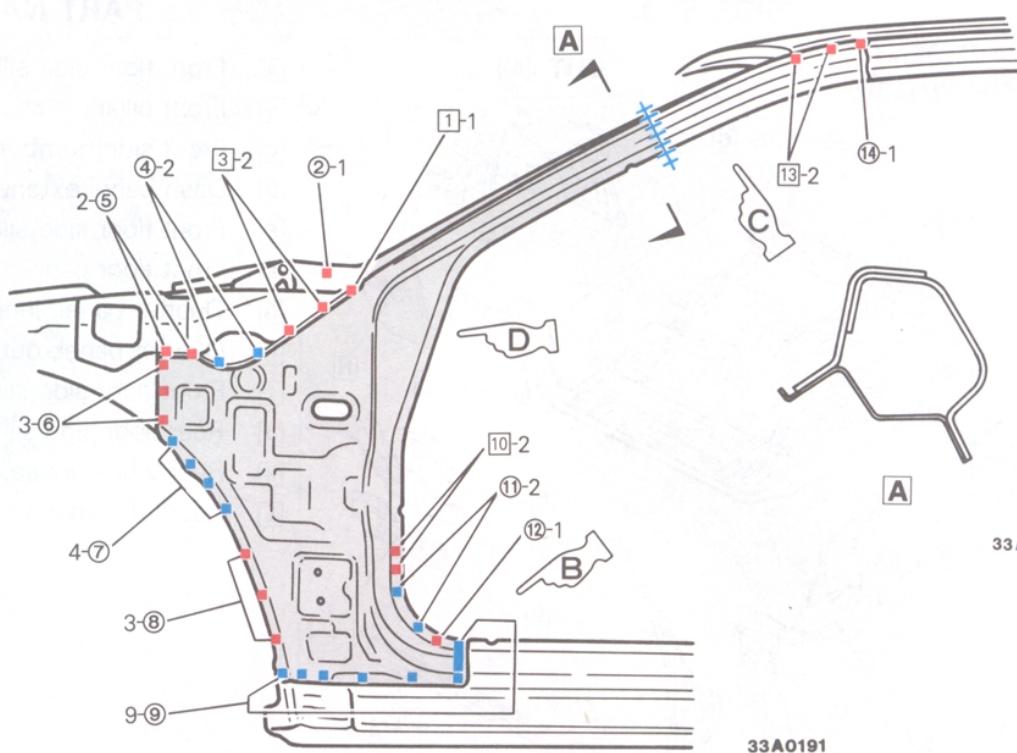
**CUT (A)**

**PART NAME**

- A** Front pillar
- B** Cowl top panel
- C** Upper frame extension, outer
- D** Front upper frame, outer
- E** Front floor side sill, inner, front
- F** Dash panel
- G** Roof panel
- H** Roof side rail, inner
- I** Roof side rail, outer
- J** Front deck crossmember
- K** Front floor side sill, outer

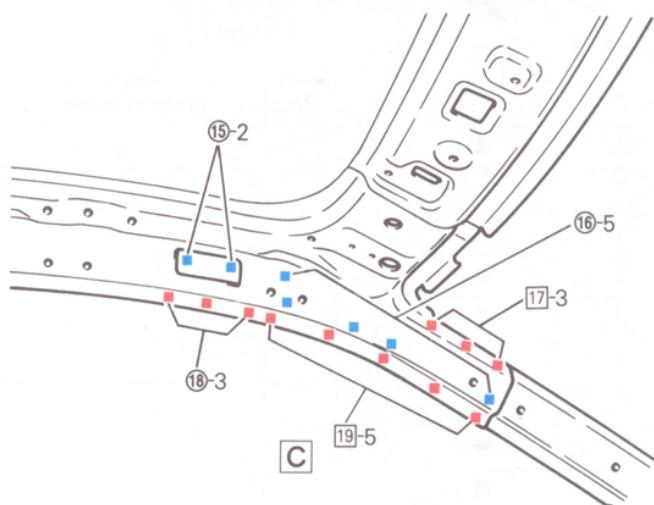
33A0281

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

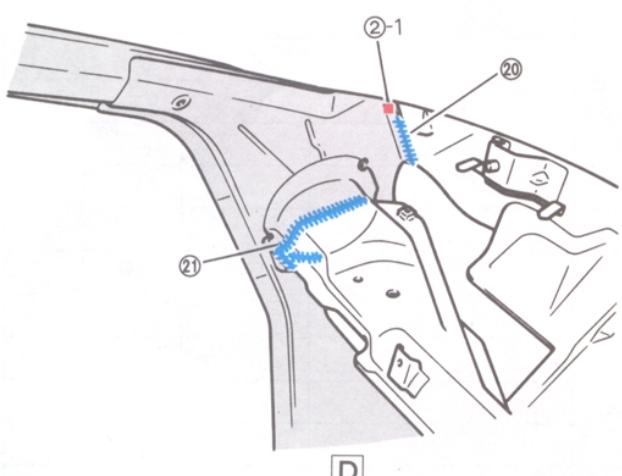


33A0171

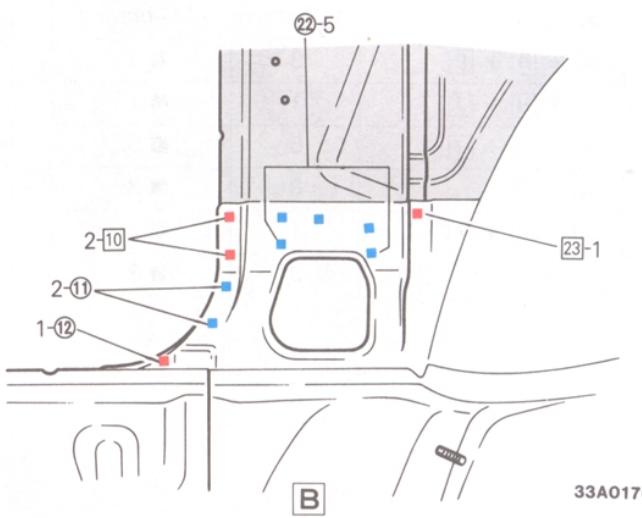
33A0191



33A0188

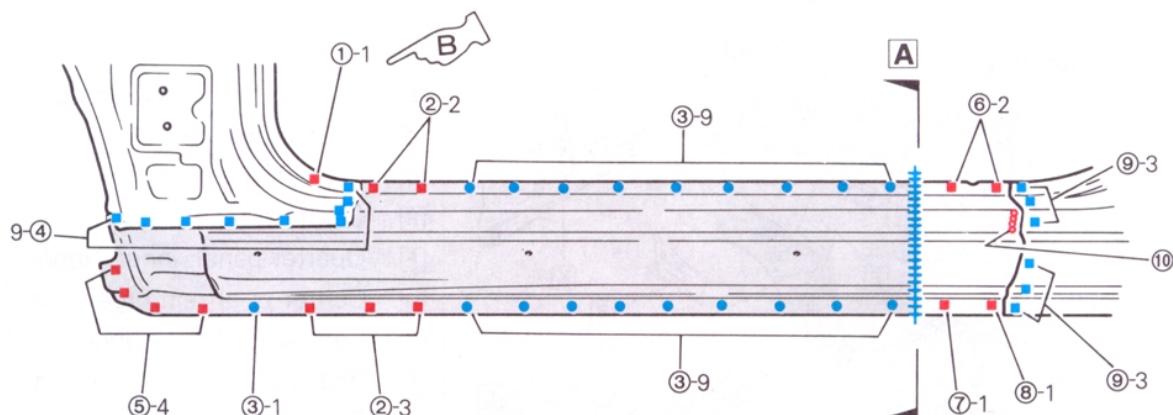


33A0184

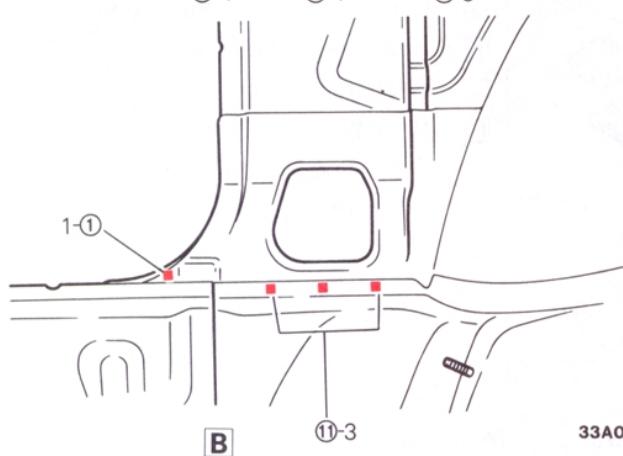


33A0176

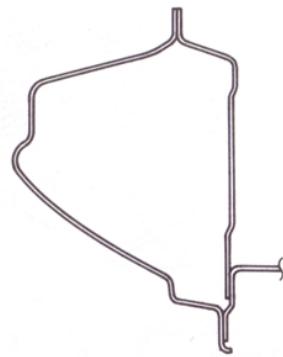




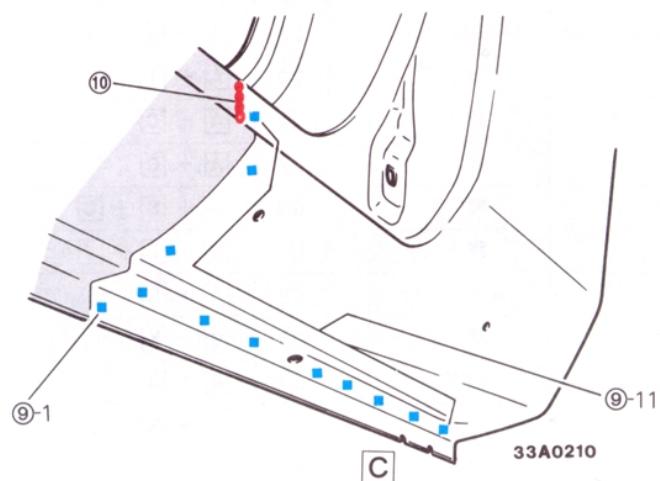
33A0189



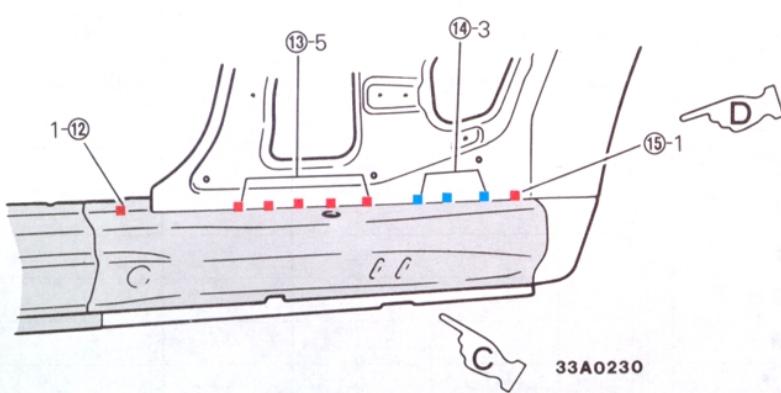
33A0176



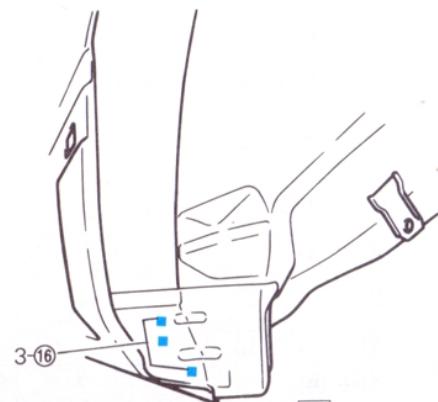
33A0172



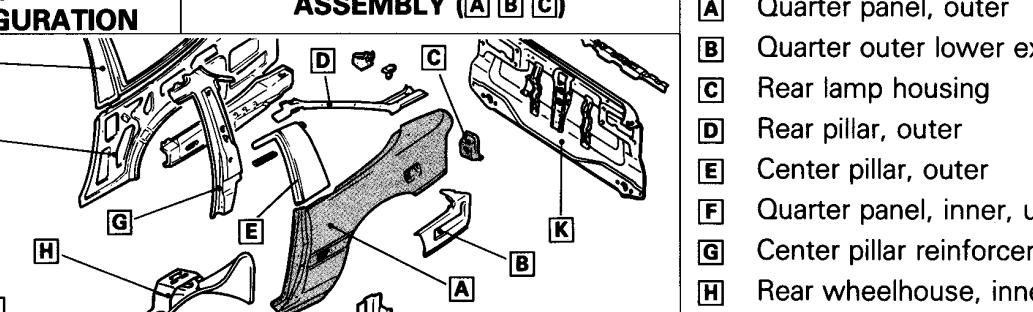
33A0210



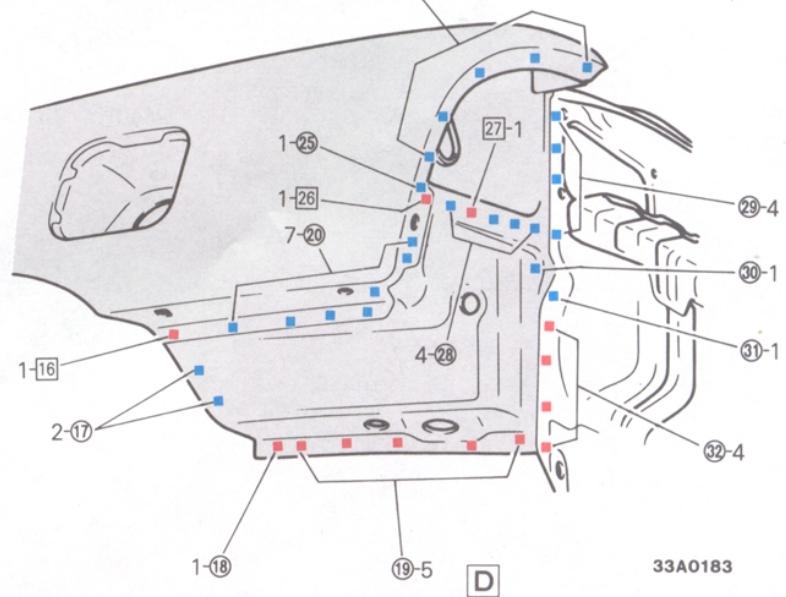
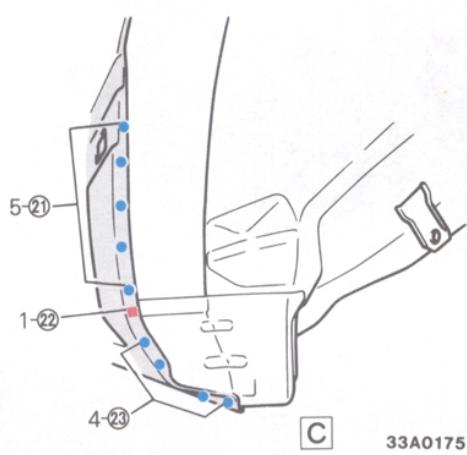
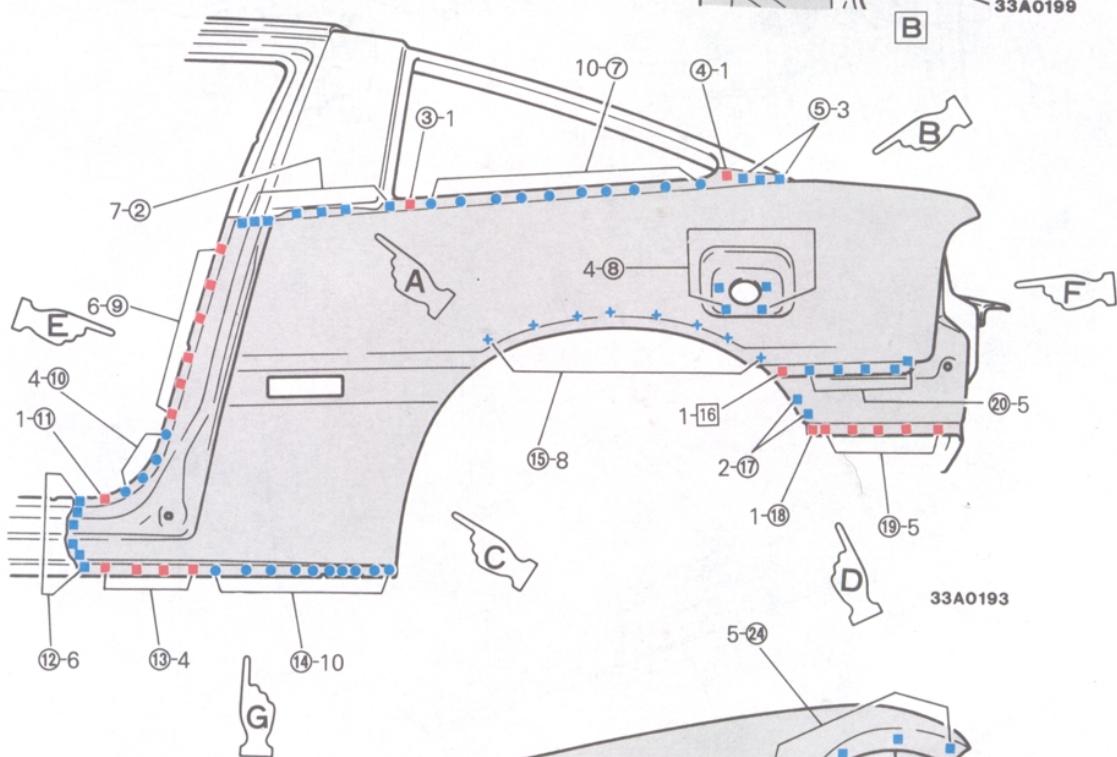
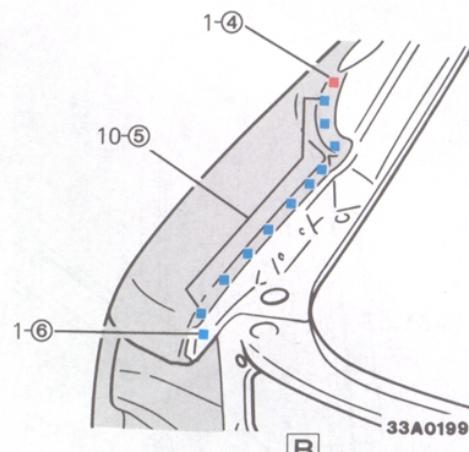
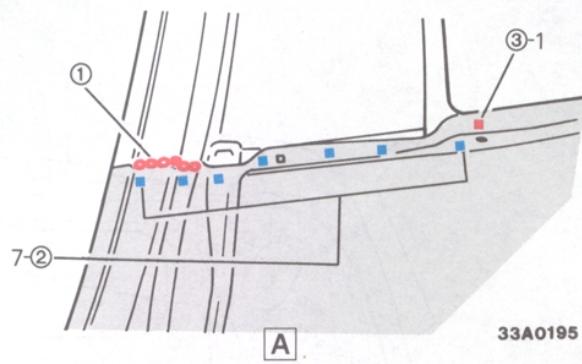
33A0230

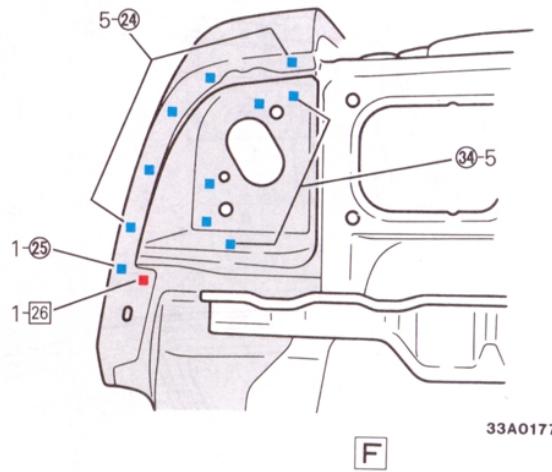
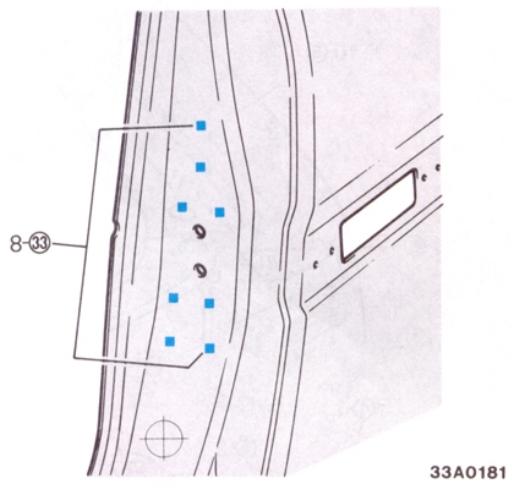


33A0209

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

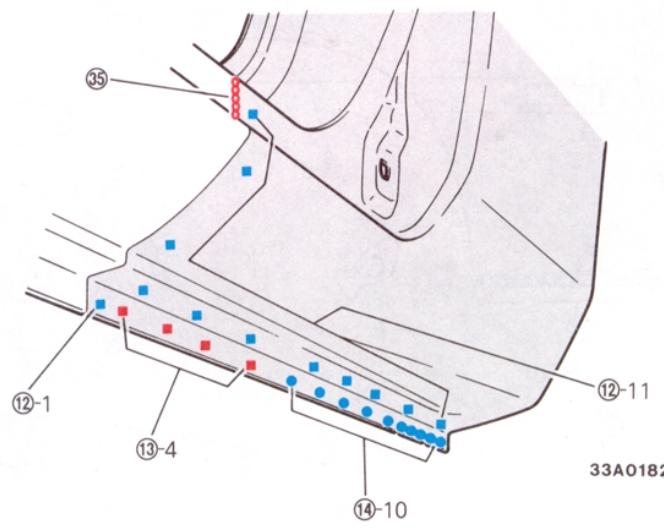
No.	Welded parts	F	R
①	[A] + [E]	MIG brazing	MIG brazing
②	[A] + [E]	7	■ 7
③	[A] + [E] + [F]	1	■ 1
④	[A] + [D] + [F]	1	■ 1
⑤	[A] + [D]	10	■ 10
⑥	[C] + [D]	1	■ 1
⑦	[A] + [F]	10	10
⑧	[A] + [J]	L.H.	4
⑨	[A] + [G] + [J]	6	■ 6
⑩	[A] + [J]	4	4
⑪	[A] + [M] + [N]	1	■ 1
⑫	[A] + [N]	14	■ 14
⑬	[A] + [M] + [O]	4	■ 4
⑭	[A] + [M]	10	10
⑮	[A] + [J]	—	8 MIG spot
⑯	[A] + [B] + [J]	1	■ 1
⑰	[B] + [J]	2	■ 2
⑱	[B] + [H] + [J]	1	■ 1
⑲	[B] + [J] + [L]	5	■ 5
⑳	[A] + [B]	7	■ 7
㉑	[A] + [J]	5	5





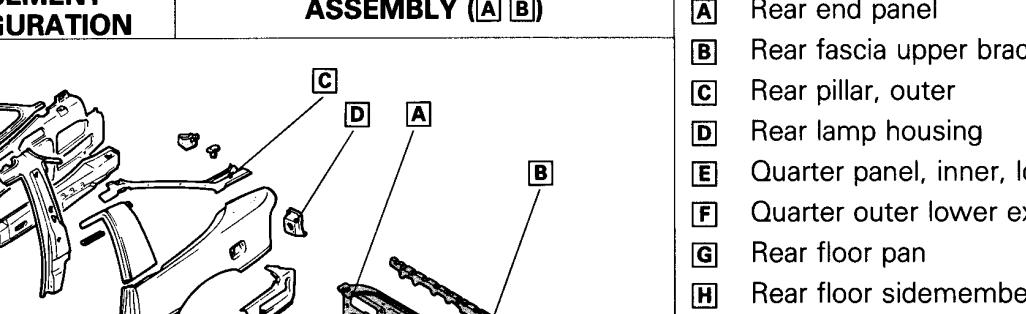
E

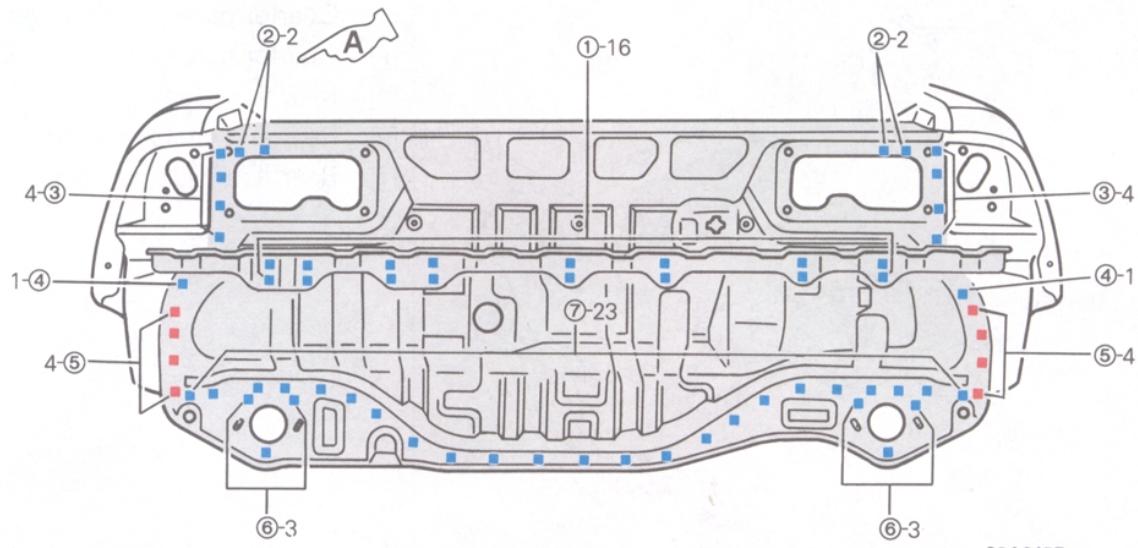
F



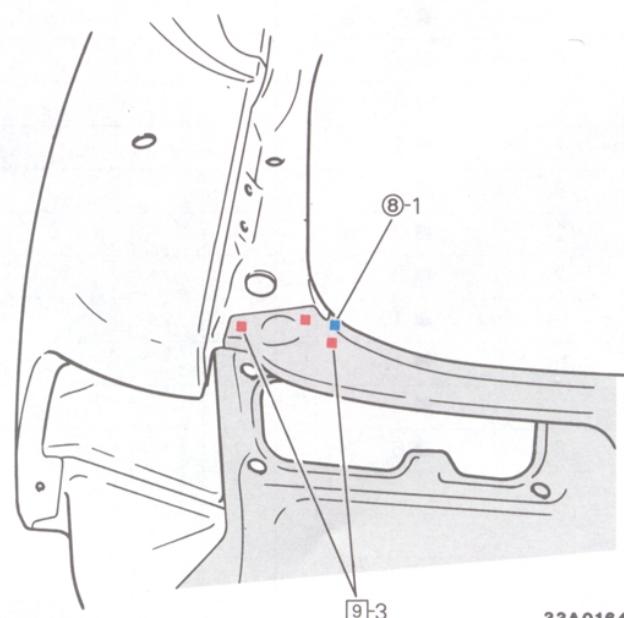
G

**NOTES**

REAR END PANEL <2WD>		PART NAME
REPLACEMENT CONFIGURATION	ASSEMBLY (A B)	
	 <p>The diagram illustrates the exploded view of the rear end panel assembly. The parts are labeled as follows:</p> <ul style="list-style-type: none"> <li><b>A:</b> Rear end panel</li> <li><b>B:</b> Rear fascia upper bracket</li> <li><b>C:</b> Rear pillar, outer</li> <li><b>D:</b> Rear lamp housing</li> <li><b>E:</b> Quarter panel, inner, lower</li> <li><b>F:</b> Quarter outer lower extension</li> <li><b>G:</b> Rear floor pan</li> <li><b>H:</b> Rear floor sidemember</li> </ul>	<p><b>A:</b> Rear end panel</p> <p><b>B:</b> Rear fascia upper bracket</p> <p><b>C:</b> Rear pillar, outer</p> <p><b>D:</b> Rear lamp housing</p> <p><b>E:</b> Quarter panel, inner, lower</p> <p><b>F:</b> Quarter outer lower extension</p> <p><b>G:</b> Rear floor pan</p> <p><b>H:</b> Rear floor sidemember</p>



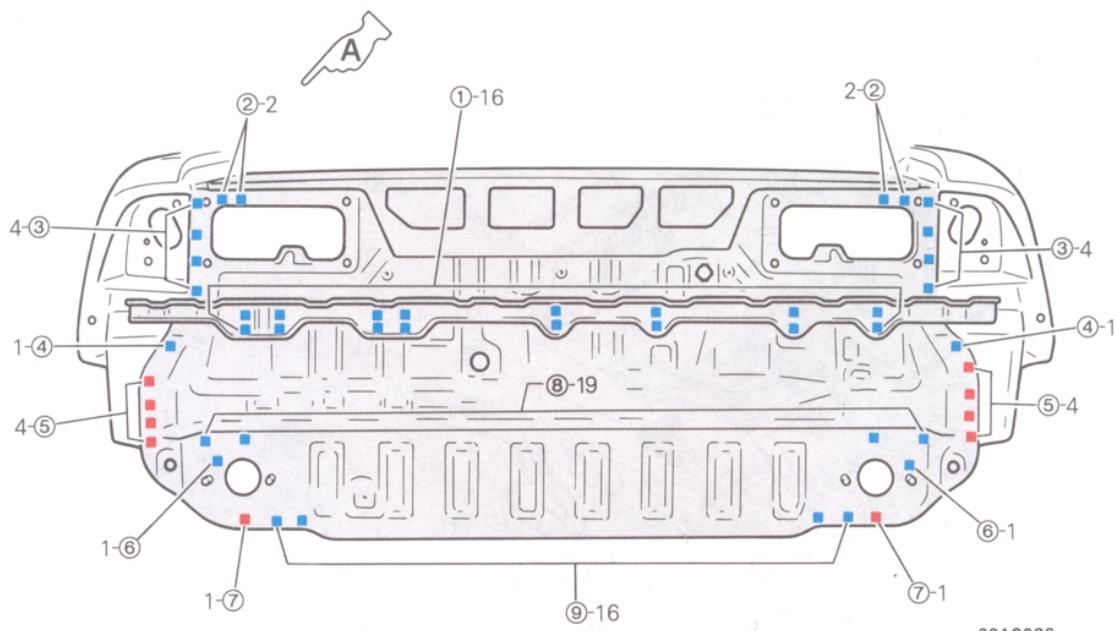
33A0157



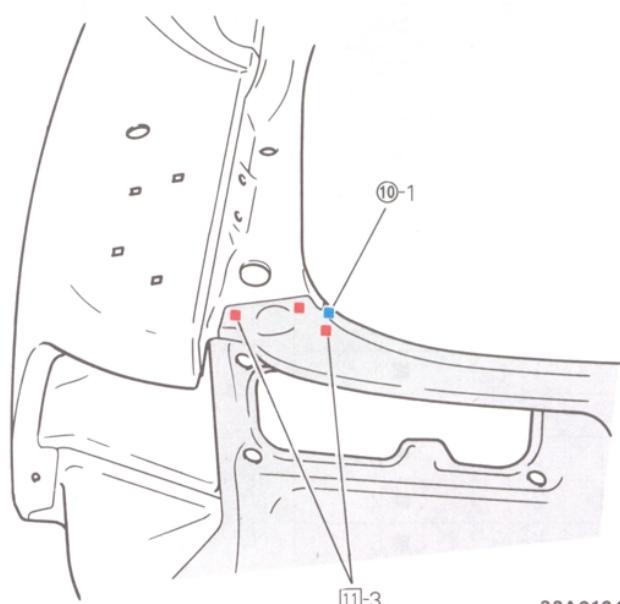
33A0164

A

REAR END PANEL <4WD>		PART NAME
REPLACEMENT CONFIGURATION	ASSEMBLY (A B)	
		<b>A</b> Rear end panel
		<b>B</b> Rear fascia upper bracket
		<b>C</b> Rear pillar, outer
		<b>D</b> Rear lamp housing
		<b>E</b> Quarter panel, inner, lower
		<b>F</b> Quarter outer lower extension
		<b>G</b> Rear floor pan
		<b>H</b> Rear end crossmember
		<b>I</b> Rear floor sidemember



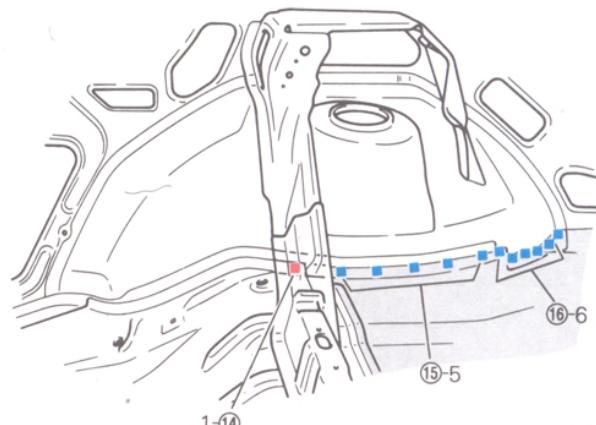
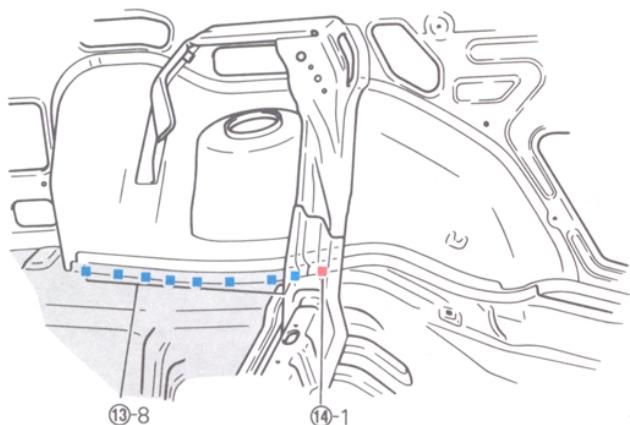
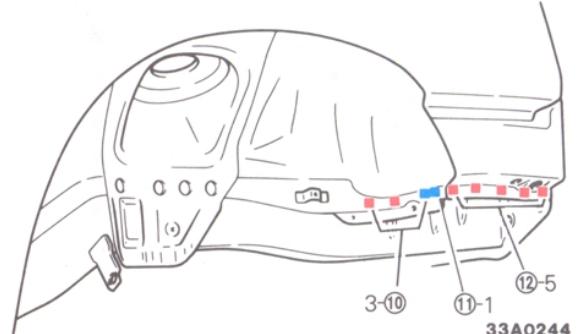
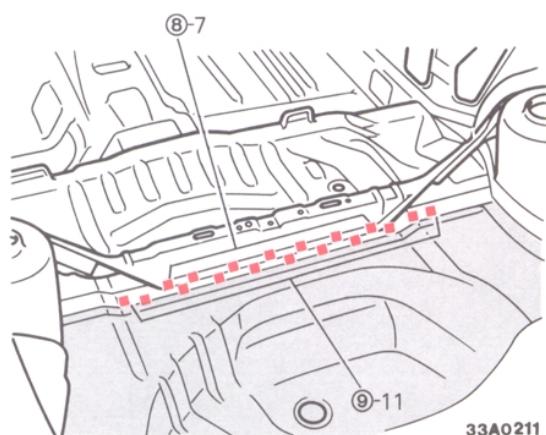
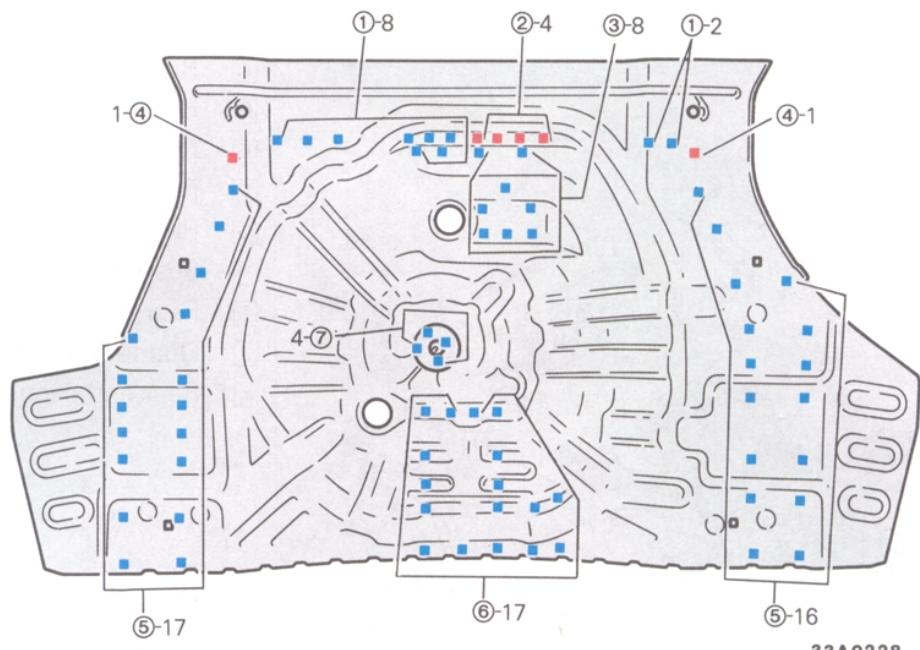
33A0386



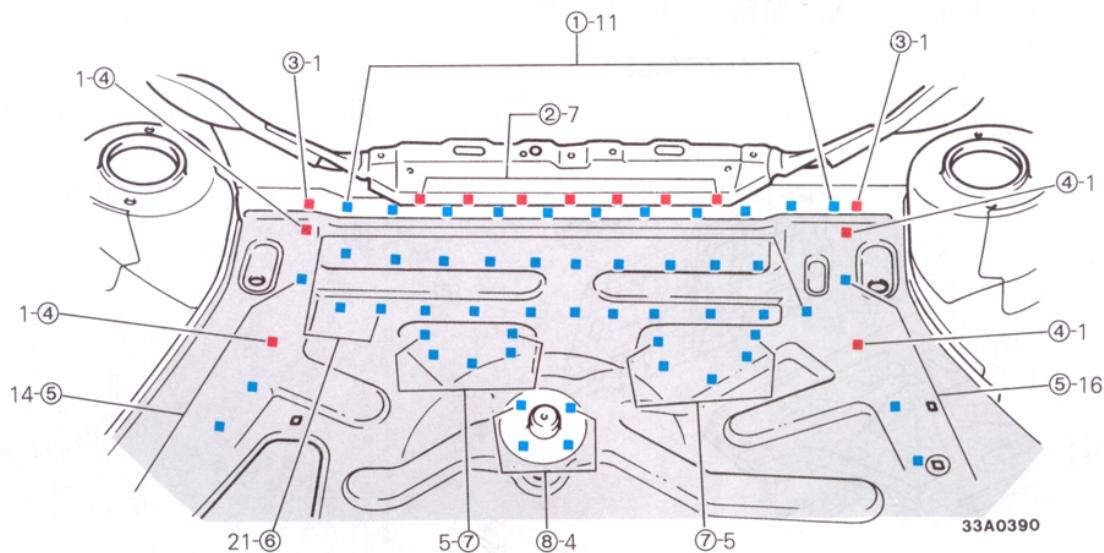
33A0164

A

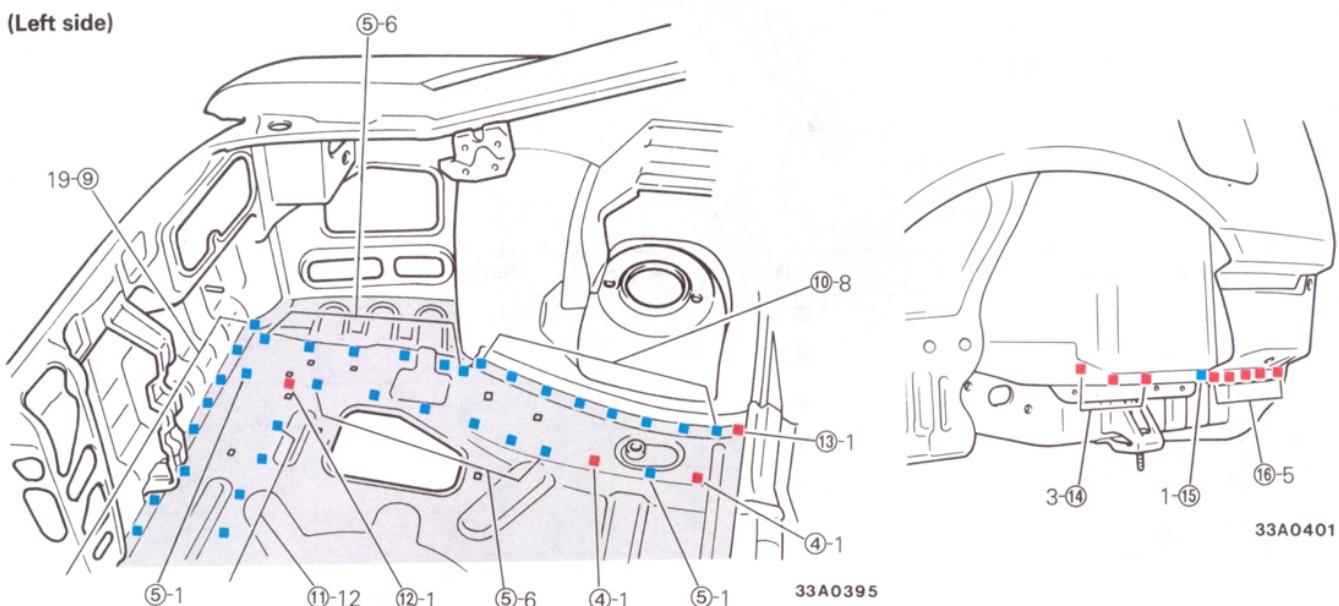




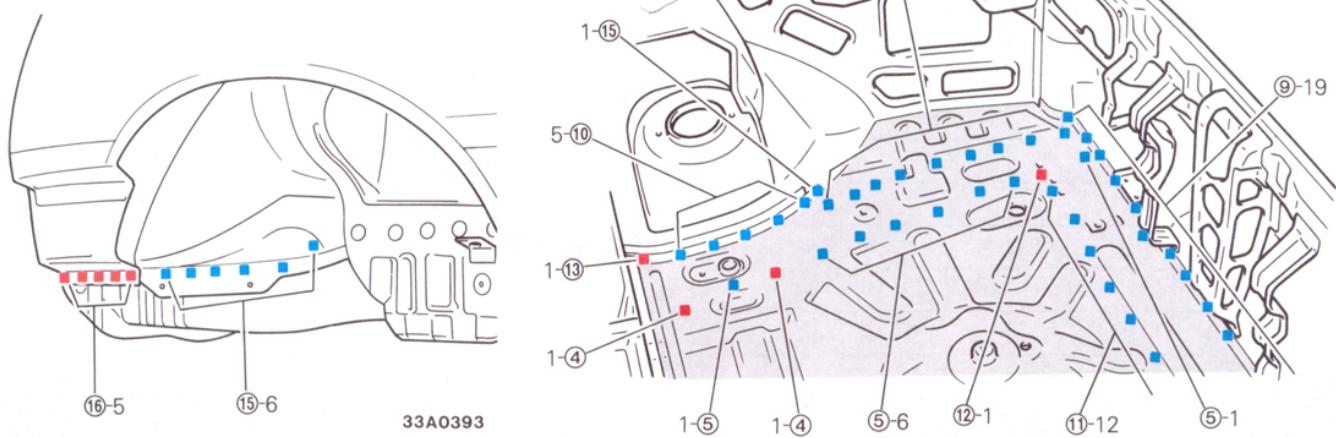
REAR FLOOR PAN <4WD>		PART NAME
REPLACEMENT CONFIGURATION	ASSEMBLY (A)	
		<b>A</b> Rear floor pan
		<b>B</b> Quarter panel, inner, lower
		<b>C</b> Rear wheelhouse, inner
		<b>D</b> Rear floor crossmember, upper
		<b>E</b> Rear seat pan
		<b>F</b> Rear floor crossmember, lower
		<b>G</b> Rear floor sidemember
		<b>H</b> Spare tire bracket
		<b>I</b> Rear end crossmember
		<b>J</b> Quarter outer lower extension
		<b>K</b> Rear end panel



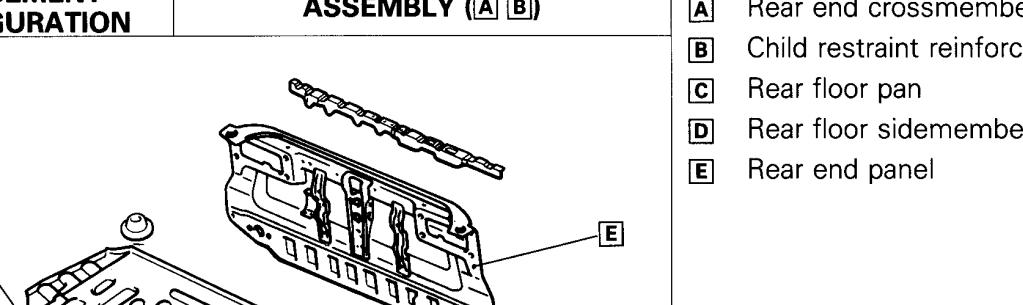
(Left side)

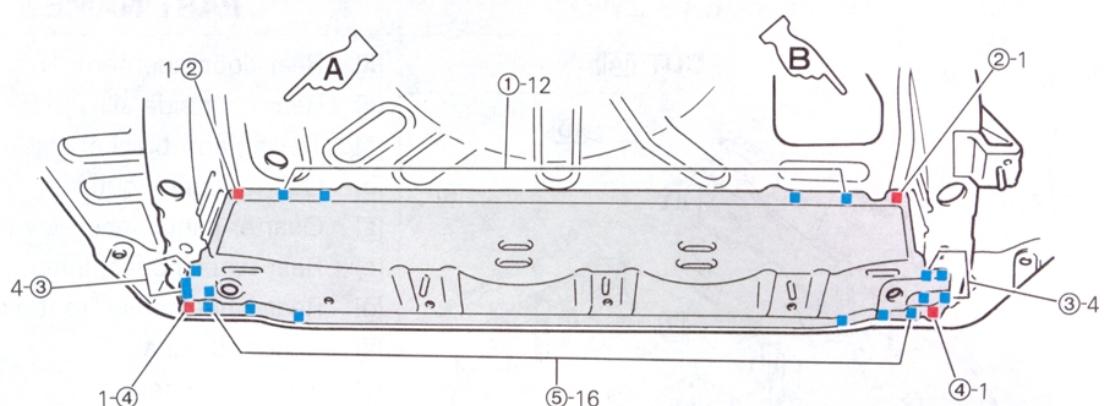


(Right side)

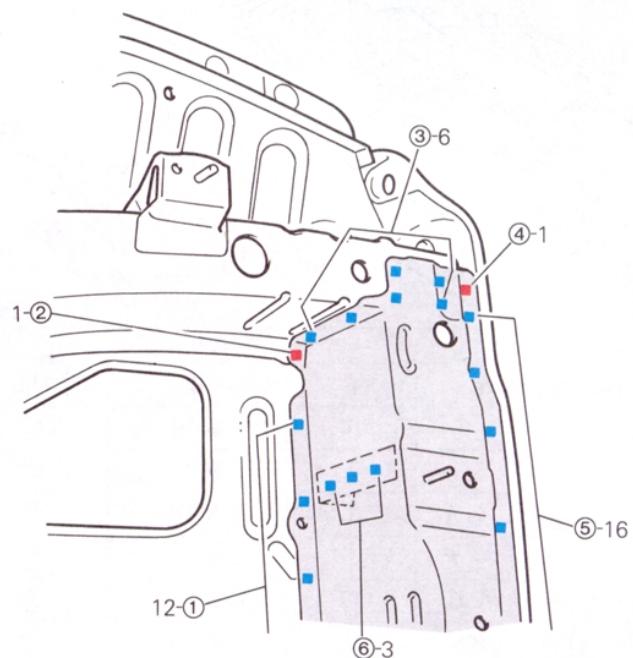


33A0392

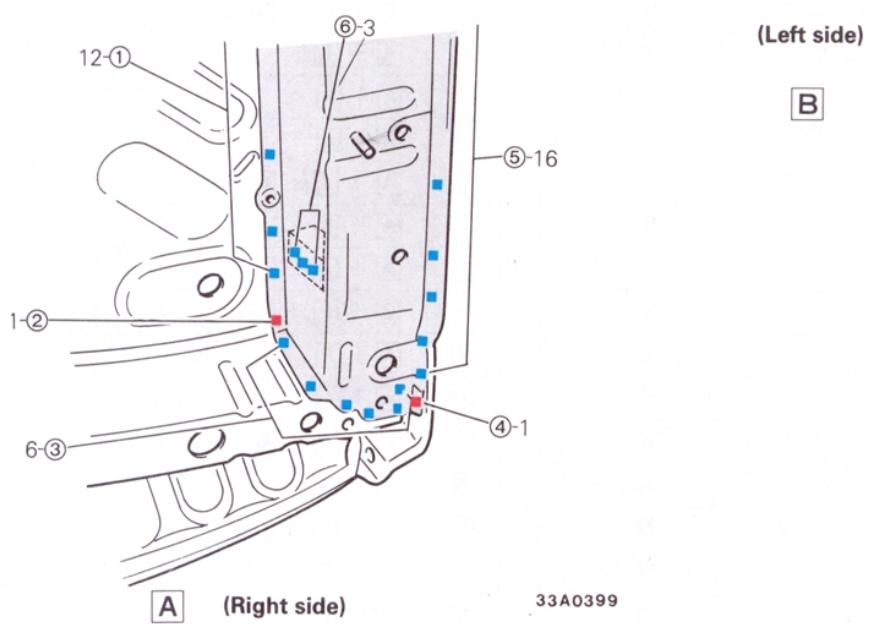
REAR END CROSSMEMBER <4WD>		PART NAME
REPLACEMENT CONFIGURATION	ASSEMBLY (A B)	
		<b>A</b> Rear end crossmember <b>B</b> Child restraint reinforcement <b>C</b> Rear floor pan <b>D</b> Rear floor sidemember <b>E</b> Rear end panel



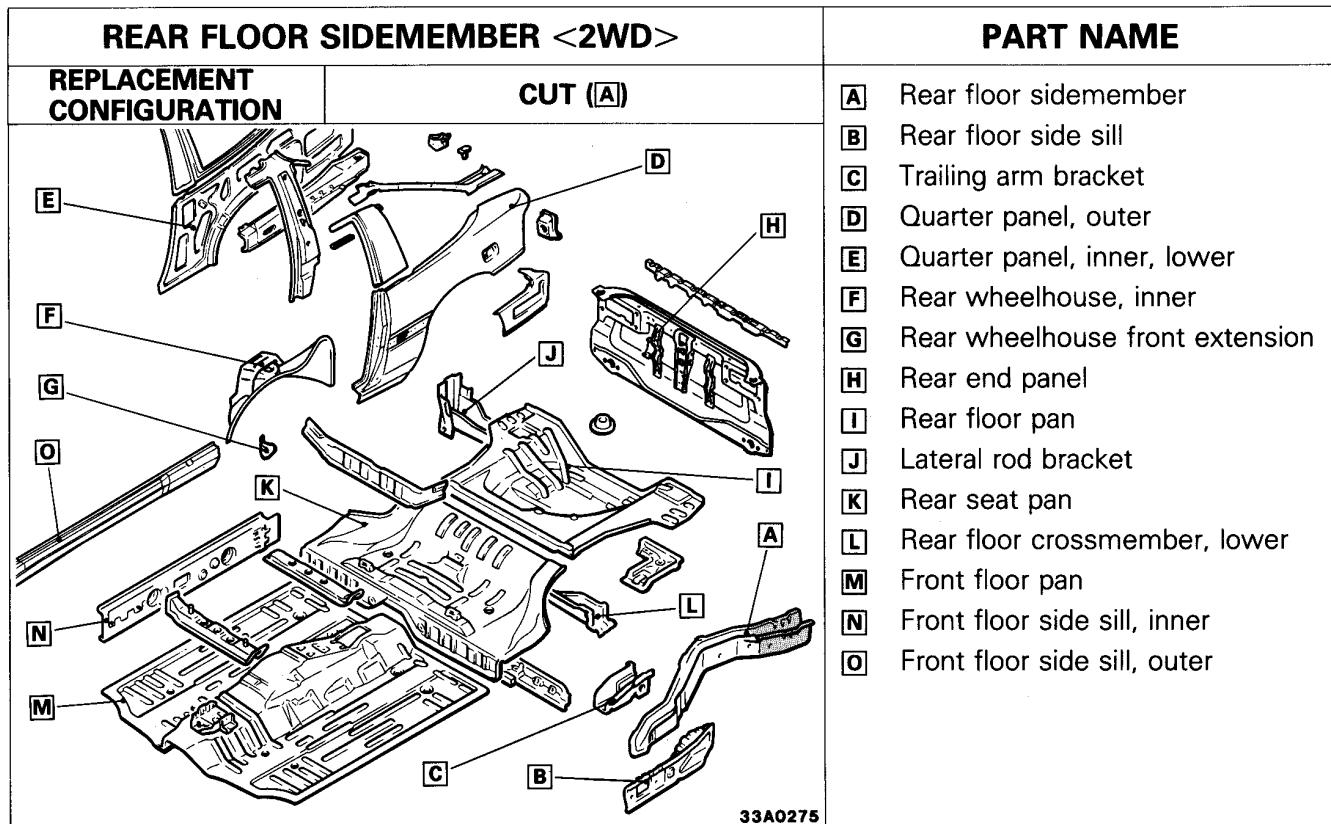
33A0396



33A0383



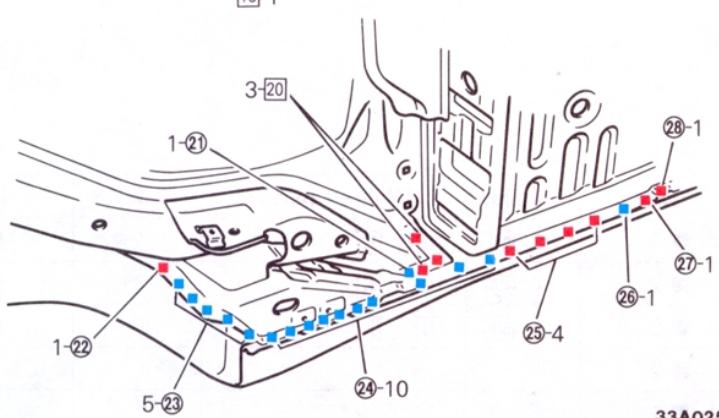
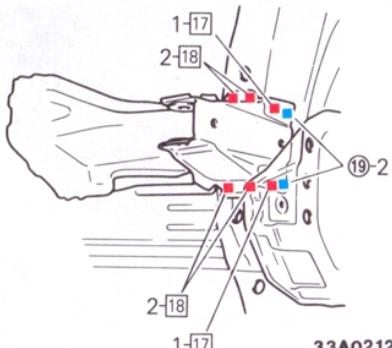
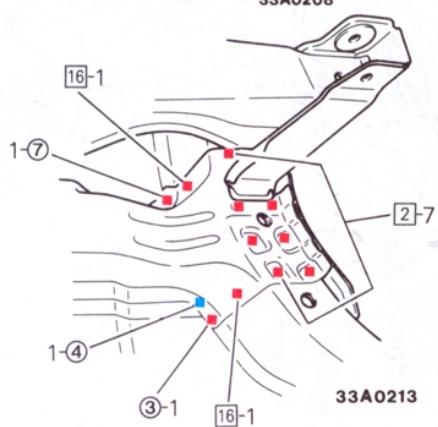
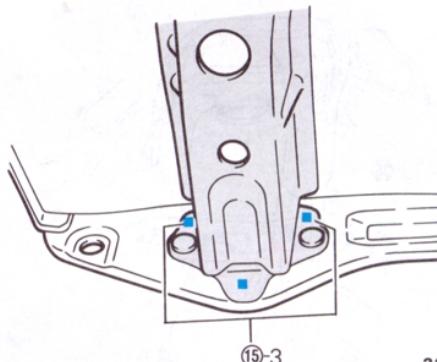
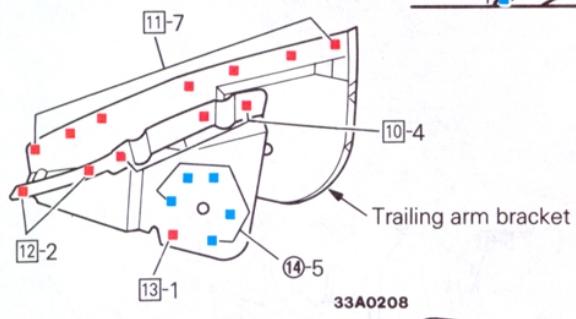
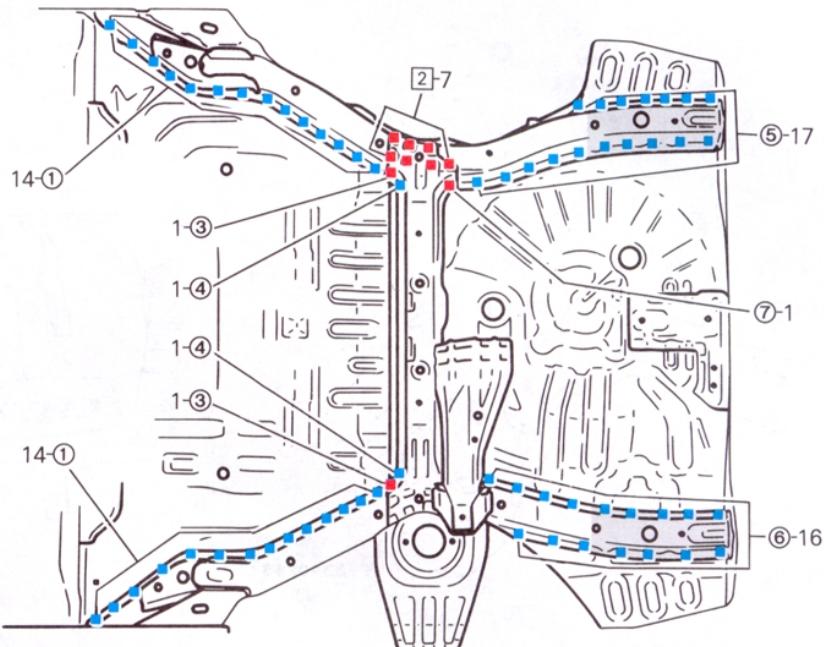
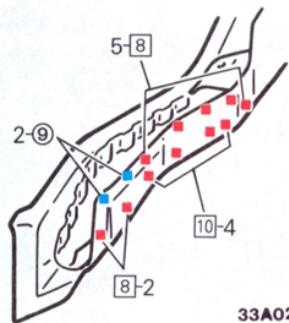
33A0399

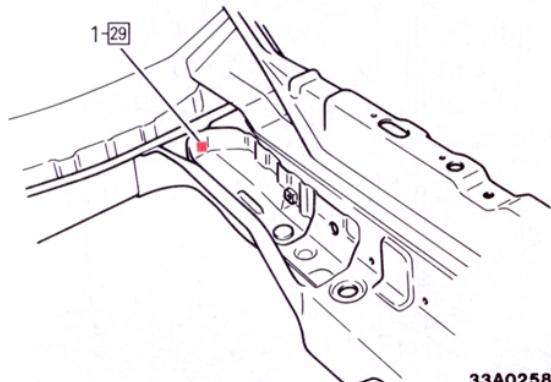


No.	Welded parts	F	R
①	<b>A</b> + <b>K</b>	14	■ 14
②	<b>A</b> + <b>L</b>	7	■ 7
③	<b>A</b> + <b>K</b> + <b>L</b> ★	1	■ 1
④	<b>A</b> + <b>L</b> ★	1	■ 1
⑤	<b>A</b> + <b>I</b> L.H.	17	■ 17
⑥	<b>A</b> + <b>I</b> R.H.	16	■ 16
⑦	<b>A</b> + <b>I</b> + <b>L</b> ★	1	■ 1
⑧	<b>A</b> + <b>B</b>	7	■ 7
⑨	<b>A</b> + <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

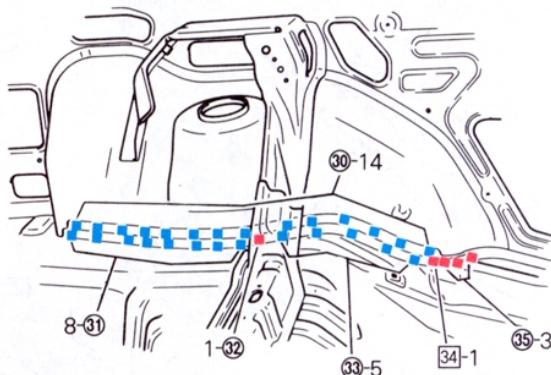
No.	Welded parts	F	R
㉒	<b>B</b> + <b>F</b> + <b>G</b>	1	■ 1
㉓	<b>B</b> + <b>G</b>	5	■ 5
㉔	<b>B</b> + <b>D</b>	10	■ 10
㉕	<b>B</b> + <b>D</b> + <b>M</b>	4	■ 4
㉖	<b>B</b> + <b>M</b>	1	■ 1
㉗	<b>B</b> + <b>M</b> + <b>O</b>	1	■ 1
㉘	<b>B</b> + <b>M</b> + <b>N</b>	1	■ 1
㉙	<b>A</b> + <b>L</b>	1	■ 1
㉚	<b>A</b> + <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
㉟	<b>A</b> + <b>F</b> R.H.	12	■ 12
㉟	<b>A</b> + <b>I</b> R.H.	5	■ 5
㉟	<b>B</b> + <b>N</b> + <b>O</b>	2	■ 2
㉟	<b>B</b> + <b>N</b>	6	■ 6
㉟	<b>B</b> + <b>D</b> + <b>O</b>	1	■ 1
㉟	<b>B</b> + <b>E</b> + <b>O</b>	5	■ 5
㉟	<b>B</b> + <b>E</b>	3	■ 3

## Sidemember end

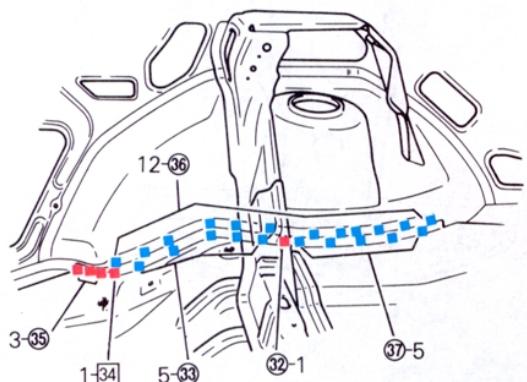




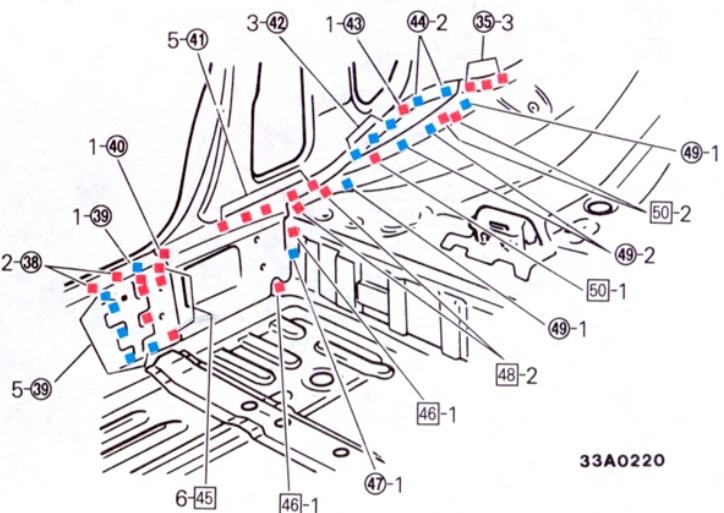
33A0258



33A0249



33A0262

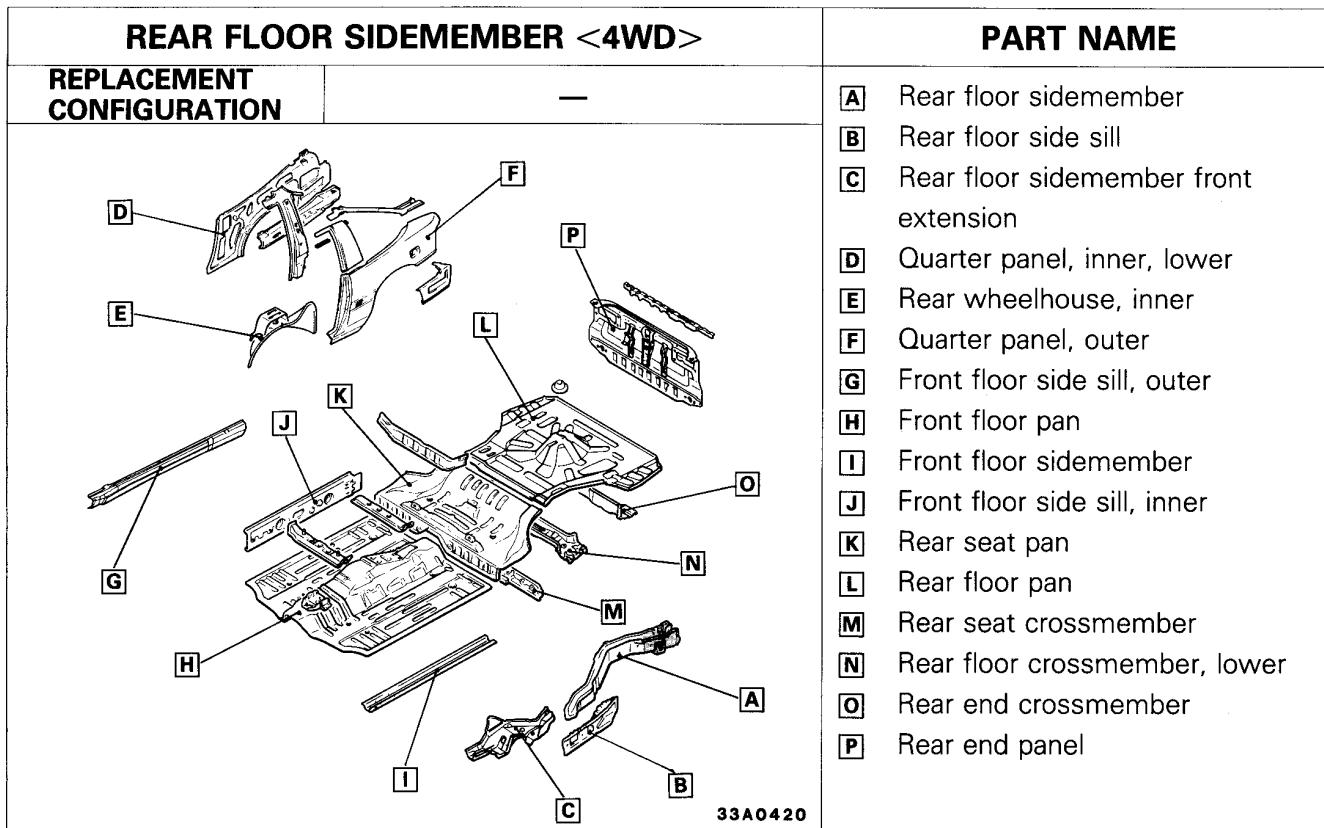


33A0220

No.	Welded parts	F	R
43	<b>B</b> + <b>F</b> + <b>E</b>	1	■ 1
44	<b>B</b> + <b>F</b>	2	■ 2
45	<b>B</b> + <b>N</b>	6	■ 6
46	<b>A</b> + <b>K</b>	2	■ 2
47	<b>A</b> + <b>K</b>	1	■ 1

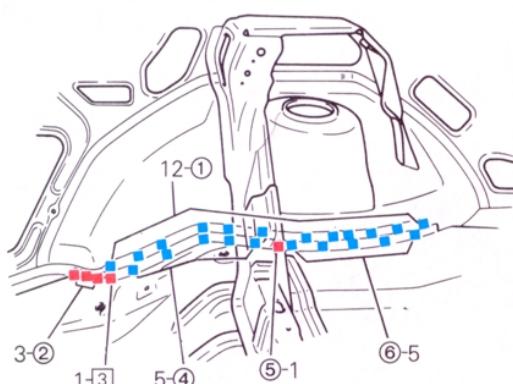
No.	Welded parts	F	R
48	<b>B</b> + <b>K</b>	2	■ 2
49	<b>B</b> + <b>K</b>	4	■ 4
50	<b>B</b> + <b>K</b>	3	■ 3

**NOTES**

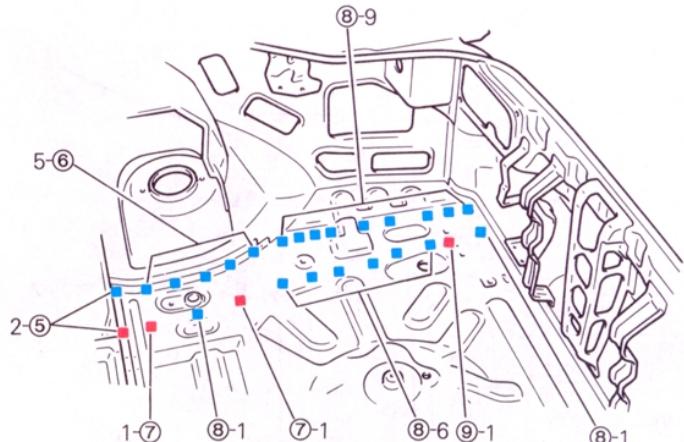


No.	Welded parts	F	R
①	<b>A</b> + <b>E</b> Left side	14	■ 14
	Right side	12	■ 12
②	<b>B</b> + <b>E</b> + <b>K</b>	3	■ 3
③	<b>A</b> + <b>B</b> + <b>K</b>	1	■ 1
④	<b>A</b> + <b>K</b>	5	■ 5
⑤	<b>A</b> + <b>K</b> + <b>L</b>	1	■ 1
⑥	<b>A</b> + <b>L</b> Left side	8	■ 8
	Right side	5	■ 5
⑦	<b>A</b> + <b>L</b>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

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

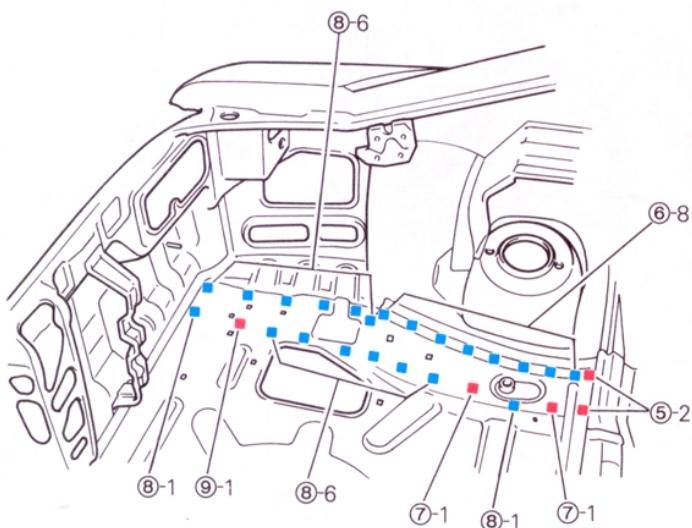


33A0262

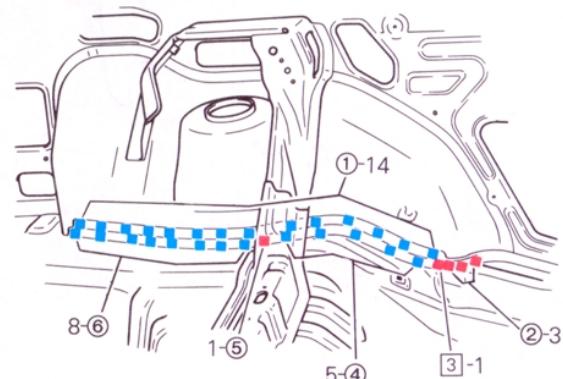


33A0391

(Right Side)



33A0394



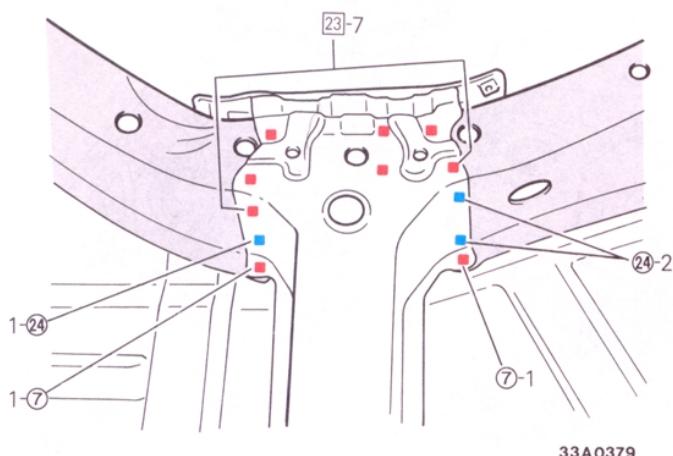
33A0249

(Left Side)

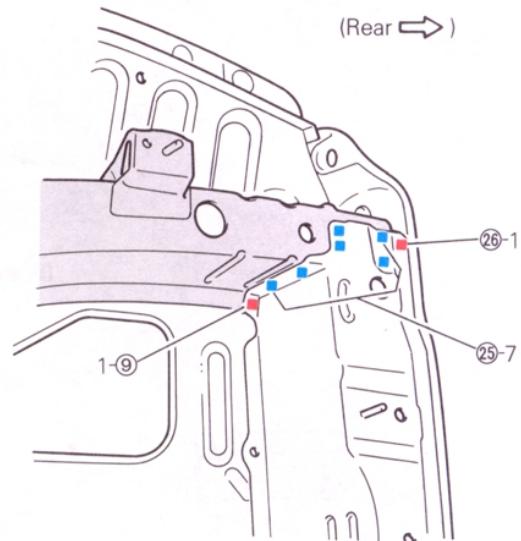
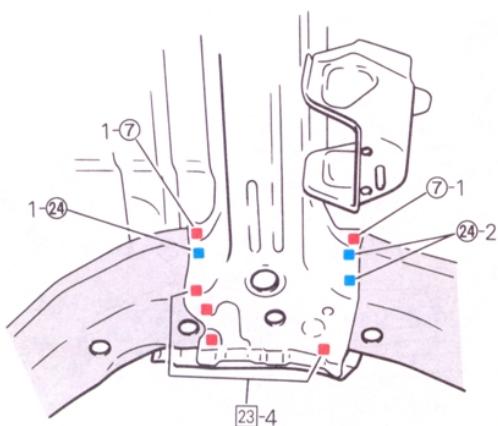
No.	Welded parts	F	R
39	[B] + [F] + [M]	1	■ 1
40	[A] + [B] + [F]	2	■ 2
41	[A] + [B]	1	■ 1

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

(Left side)

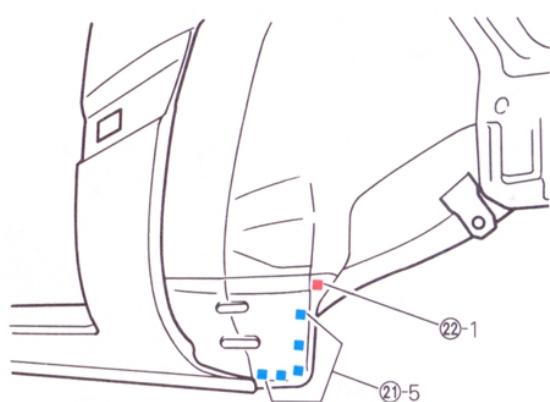
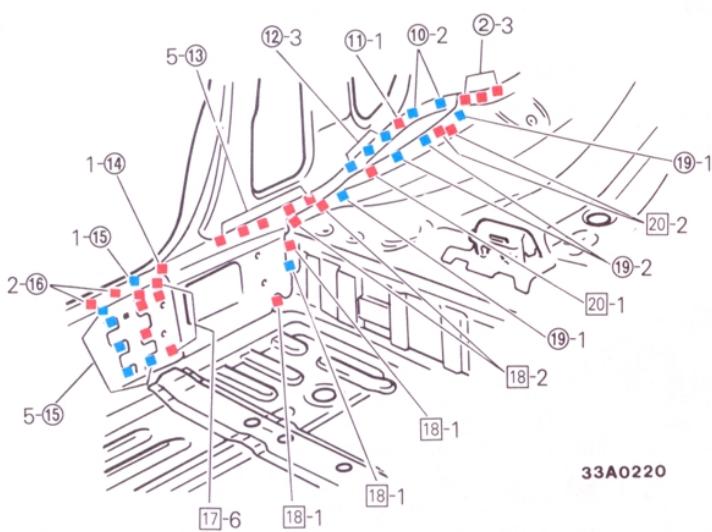


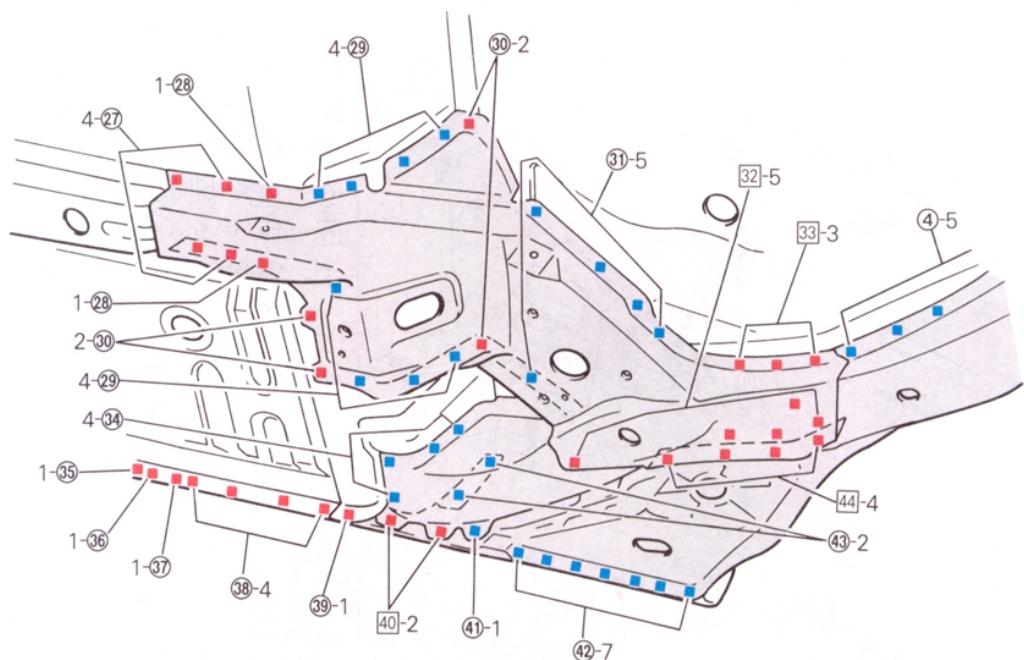
(&lt; Front)



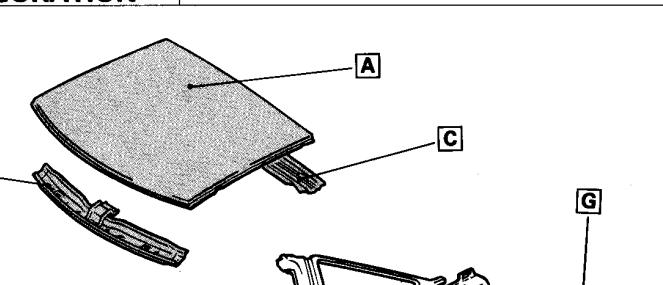
(Left side)

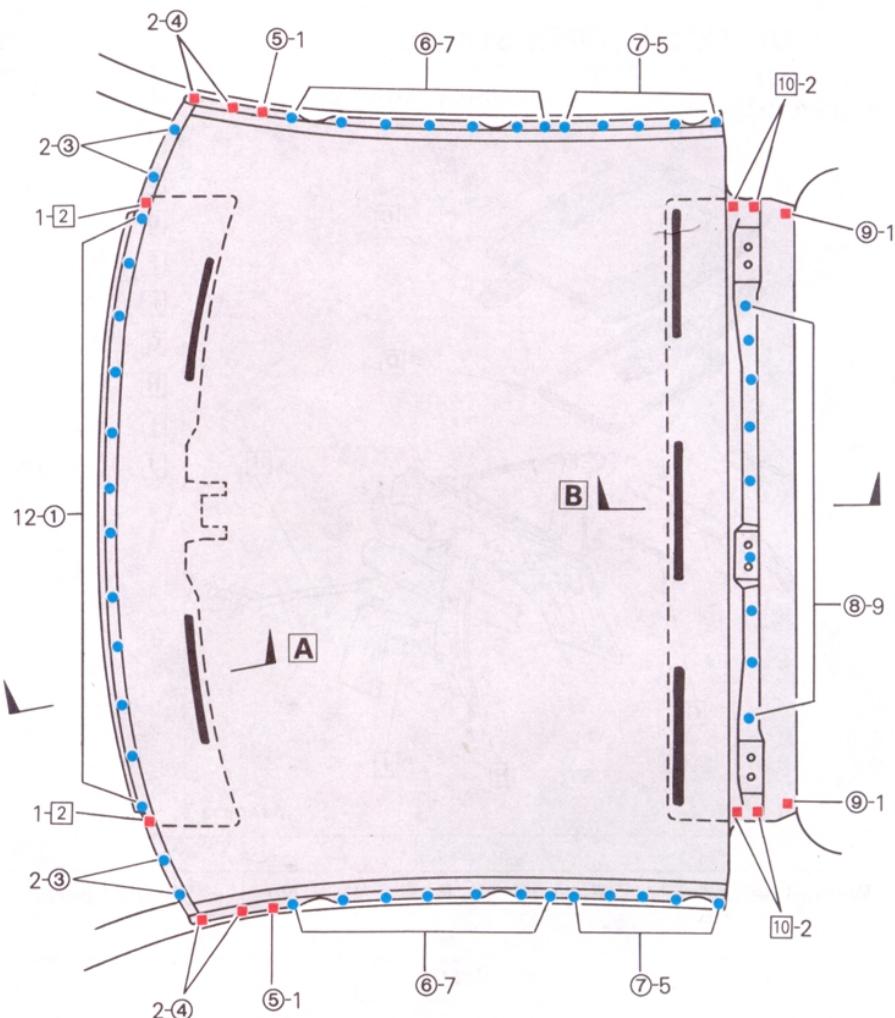
(Right side)





33A0402

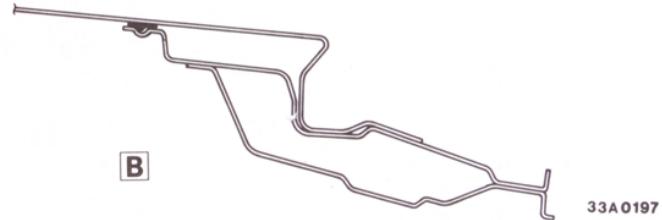
REPLACEMENT CONFIGURATION	ASSEMBLY (A B C)	PART NAME
	ASSEMBLY (A B C)	<p><b>A</b> Roof panel</p> <p><b>B</b> Roof front rail</p> <p><b>C</b> Roof rear rail</p> <p><b>D</b> Roof side rail, inner</p> <p><b>E</b> Roof side rail, outer</p> <p><b>F</b> Front pillar</p> <p><b>G</b> Rear pillar, outer</p> <p><b>H</b> Roof drip channel extension</p> <p><b>I</b> Center pillar reinforcement</p>



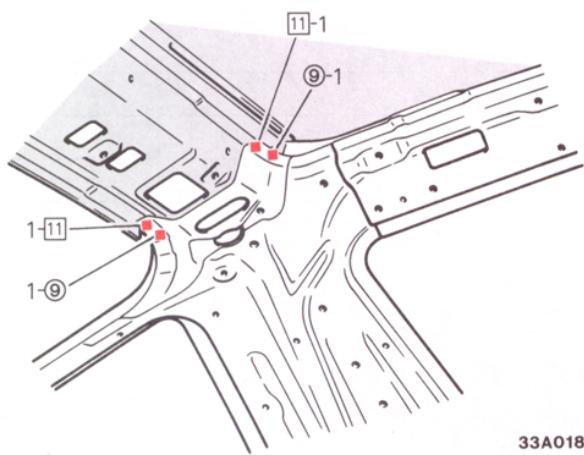
33A0196



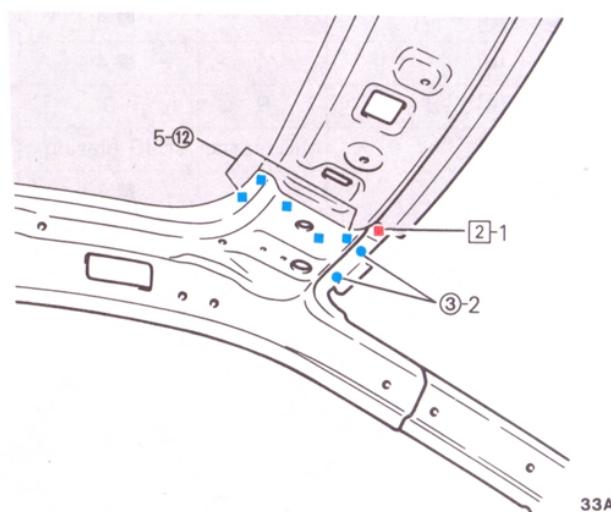
33A0198



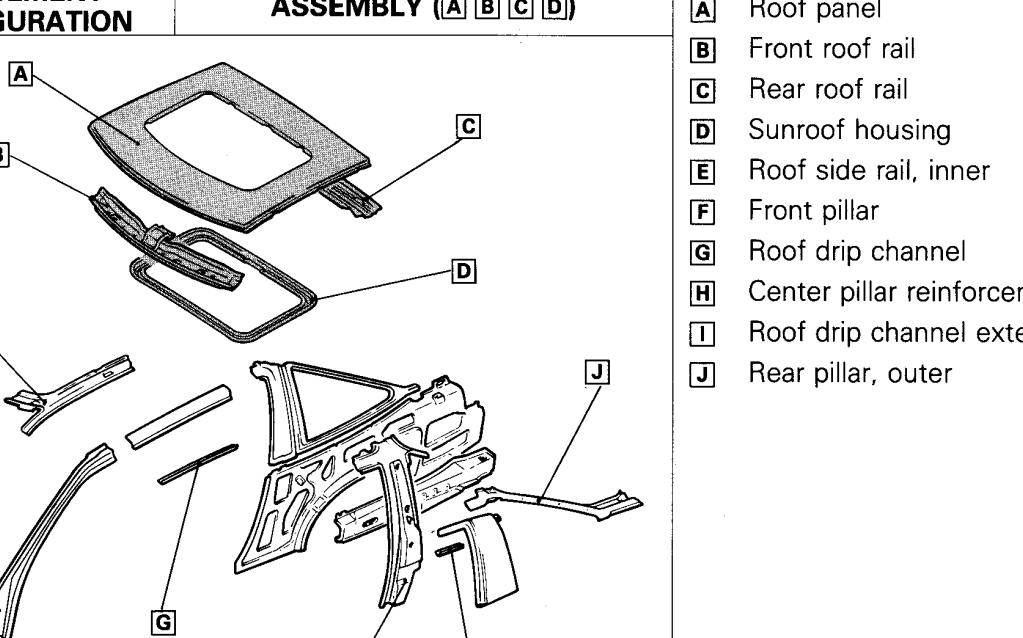
33A0197

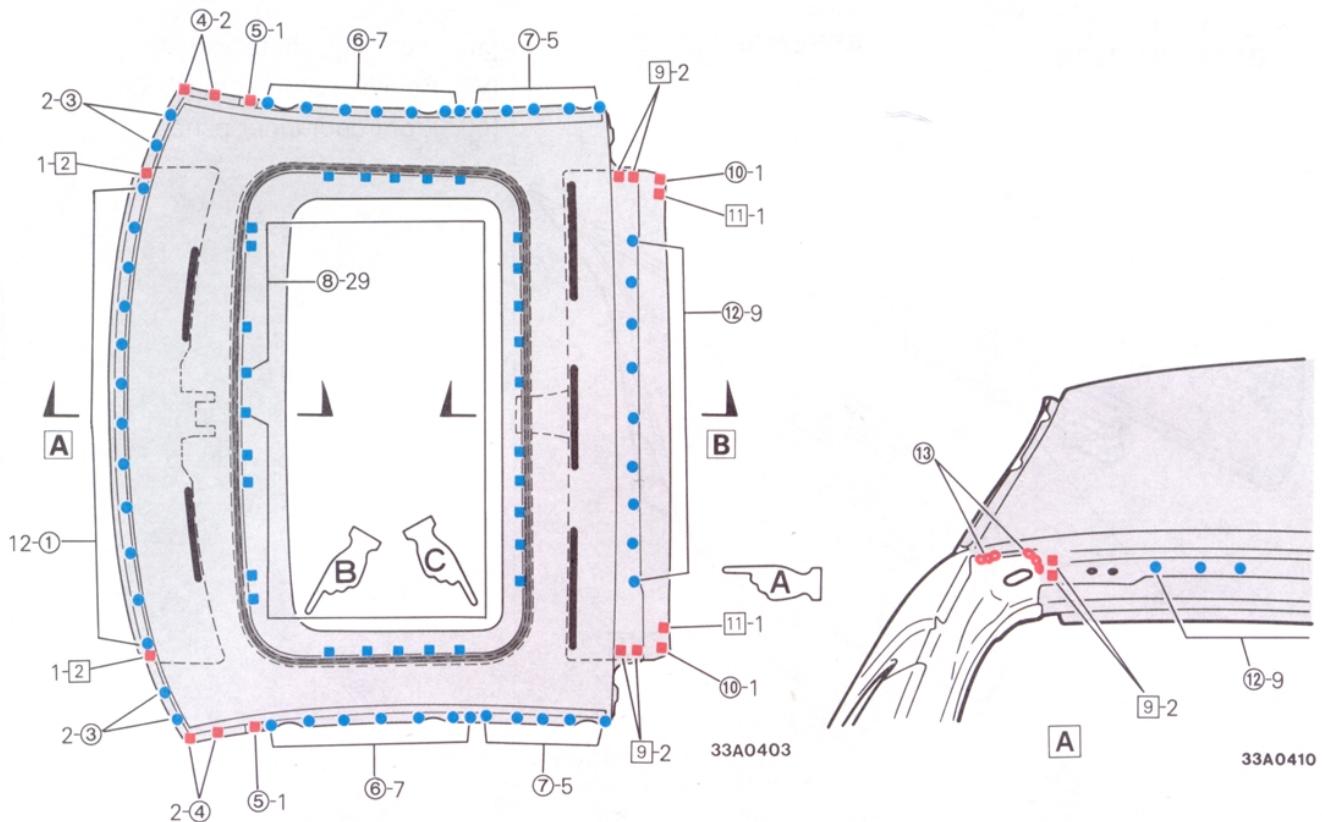


33A0180



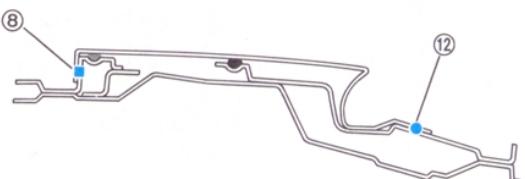
33A0188

ROOF PANEL (WITH SUNROOF)		PART NAME
REPLACEMENT CONFIGURATION	ASSEMBLY (A B C D)	
	ASSEMBLY (A B C D)	<p><b>A</b> Roof panel</p> <p><b>B</b> Front roof rail</p> <p><b>C</b> Rear roof rail</p> <p><b>D</b> Sunroof housing</p> <p><b>E</b> Roof side rail, inner</p> <p><b>F</b> Front pillar</p> <p><b>G</b> Roof drip channel</p> <p><b>H</b> Center pillar reinforcement, upper</p> <p><b>I</b> Roof drip channel extension</p> <p><b>J</b> Rear pillar, outer</p>



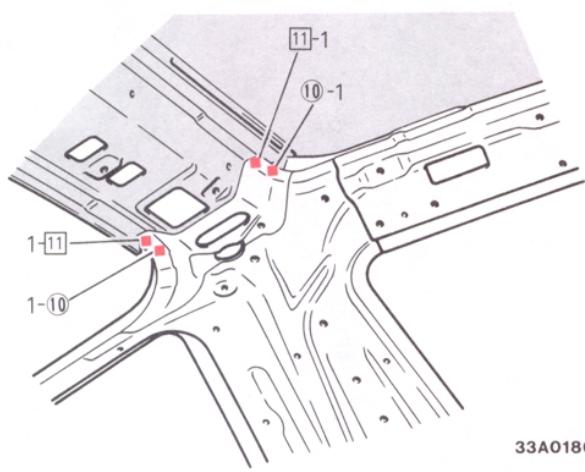
A

33A0406

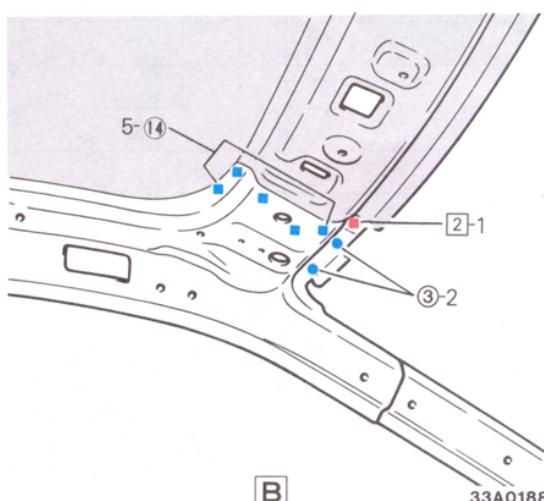


B

33A0407

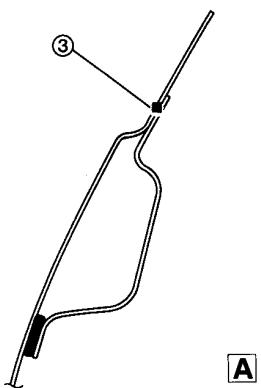


33A0180

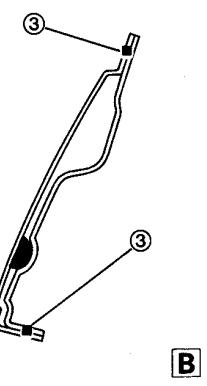


33A0188

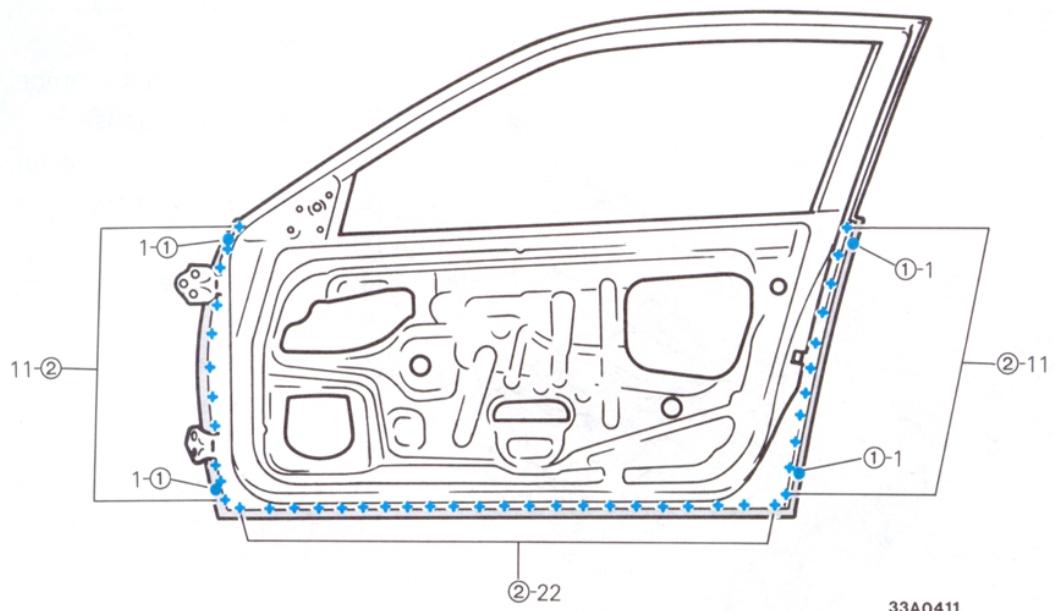
REPLACEMENT CONFIGURATION	ASSEMBLY (A)	PART NAME
	<p>The diagram illustrates the front door outer panel assembly (A). It features a long, thin beltline reinforcement (B) at the top, which is secured to the inner panel (C) below. The inner panel (C) is a larger, L-shaped component with various cutouts and mounting points. Callouts A, B, and C point to these respective parts.</p>	<p><b>A</b> Front door outer panel  <b>B</b> Beltline reinforcement, outer  <b>C</b> Front door inner panel</p>



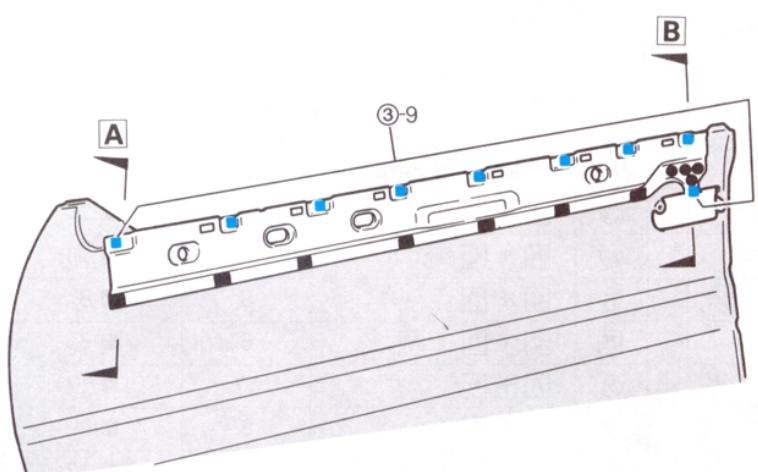
33A0405



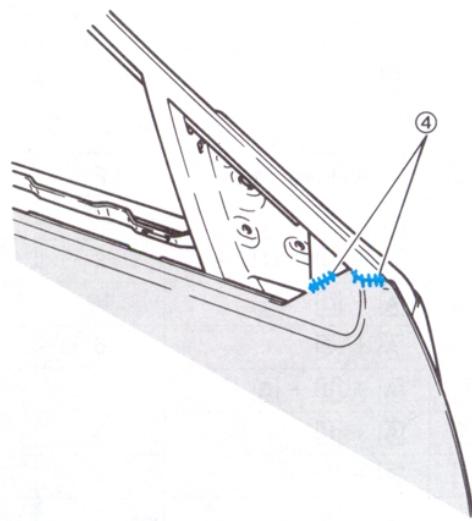
33A0404



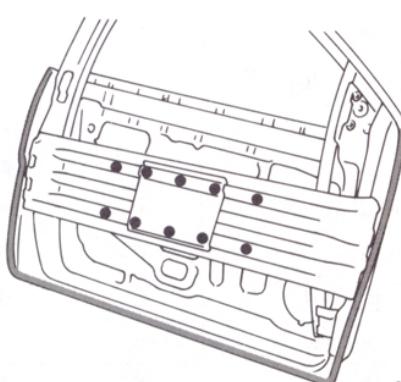
33A0411



33A0381

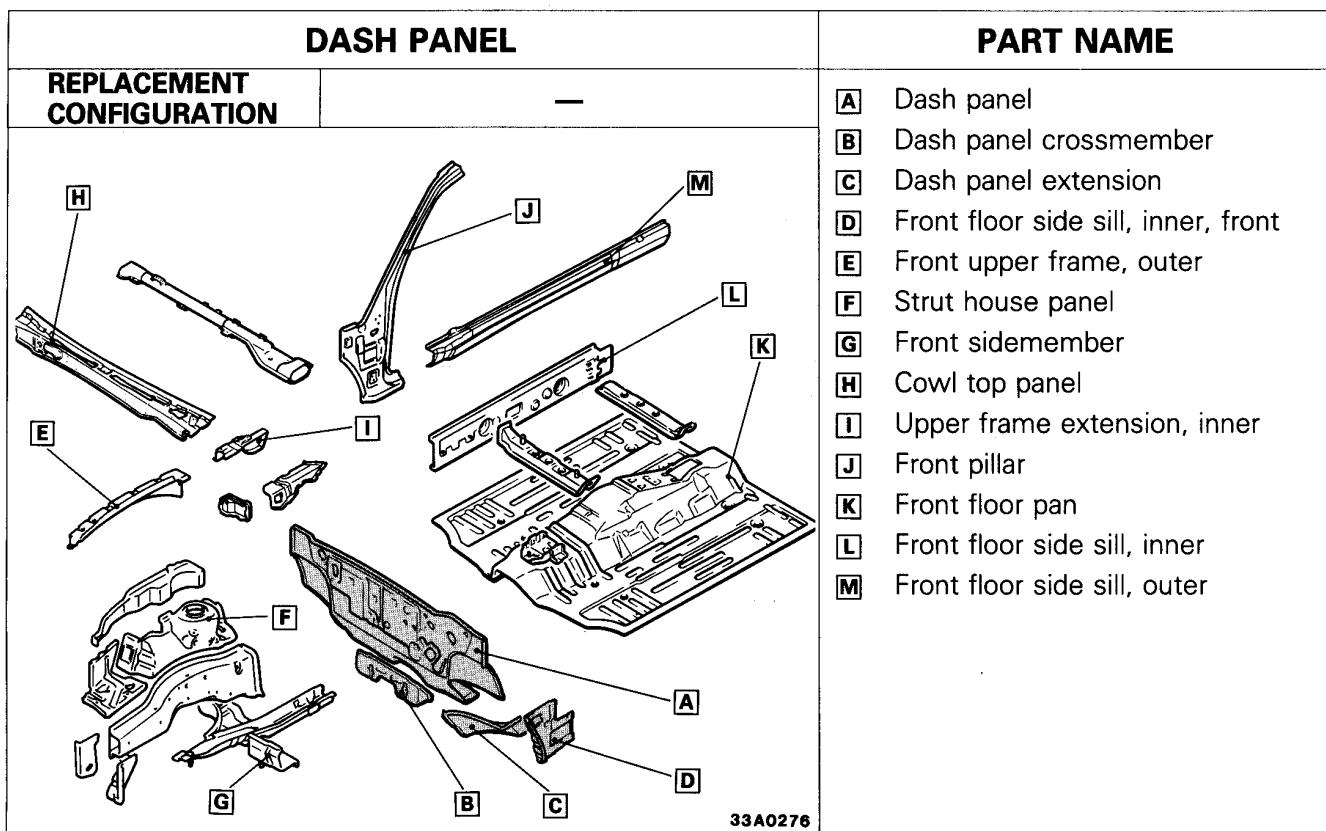


33A0179



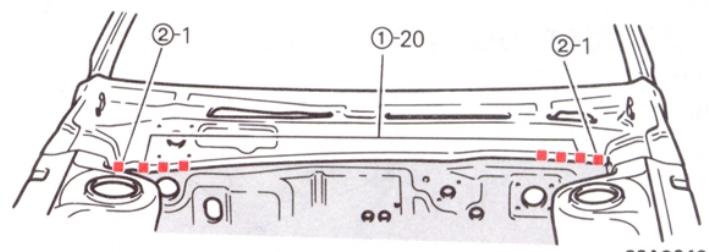
33A0408

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

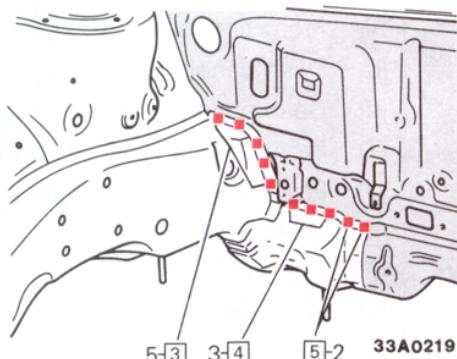


No.	Welded parts	F	R
①	<b>A</b> + <b>H</b>	20	■ 20
②	<b>A</b> + <b>H</b> + <b>I</b>	2	■ 2
③	<b>A</b> + <b>G</b>	10	■ 10
④	<b>A</b> + <b>G</b>	6	■ 6
⑤	<b>A</b> + <b>B</b> + <b>G</b>	6	■ 6
⑥	<b>A</b> + <b>H</b>	3	■ 3
⑦	<b>A</b> + <b>F</b>	8	■ 8
⑧	<b>A</b> + <b>F</b>	2	■ 2
⑨	<b>D</b> + <b>J</b>	2	■ 2
⑩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

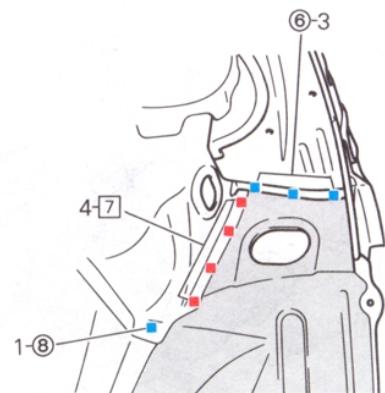
No.	Welded parts	F	R
㉒	<b>A</b> + <b>G</b>	2	■ 2
㉓	<b>A</b> + <b>C</b>	16	■ 16
㉔	<b>C</b> + <b>D</b>	8	■ 8
㉕	<b>C</b> + <b>D</b> + <b>M</b>	6	■ 6
㉖	<b>A</b> + <b>K</b>	17	■ 17
㉗	<b>A</b> + <b>G</b>	8	■ 8
㉘	<b>A</b> + <b>C</b> + <b>G</b>	12	■ 12
㉙	<b>D</b> + <b>G</b>	6	■ 6
㉚	<b>D</b> + <b>L</b> + <b>M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



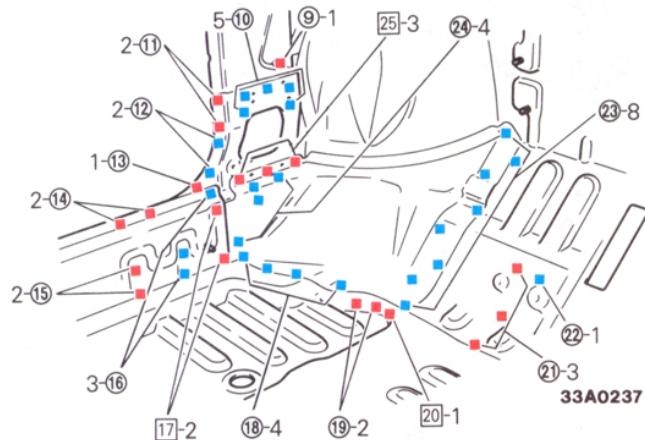
33A0243



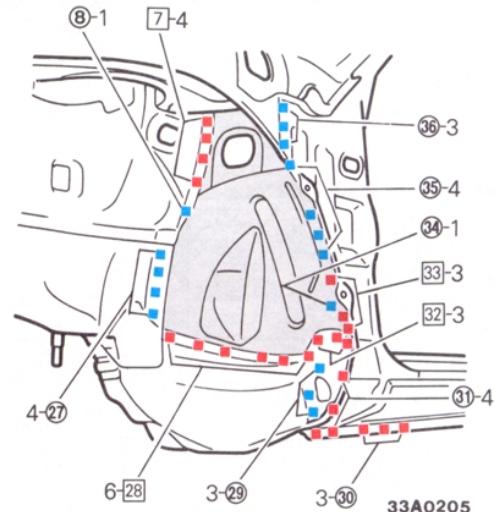
33A0219



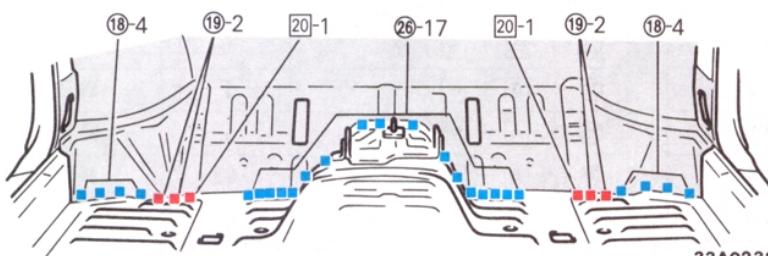
33A0232



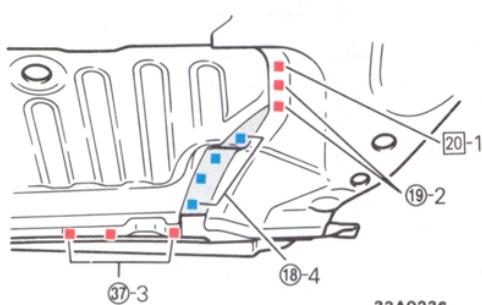
33A0237



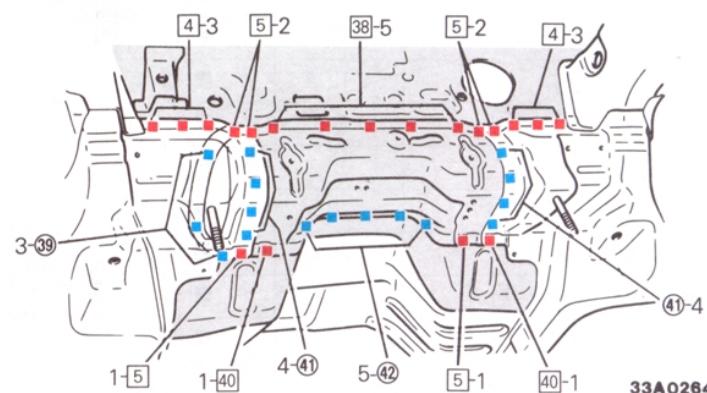
33A0205



33A0238



33A0236

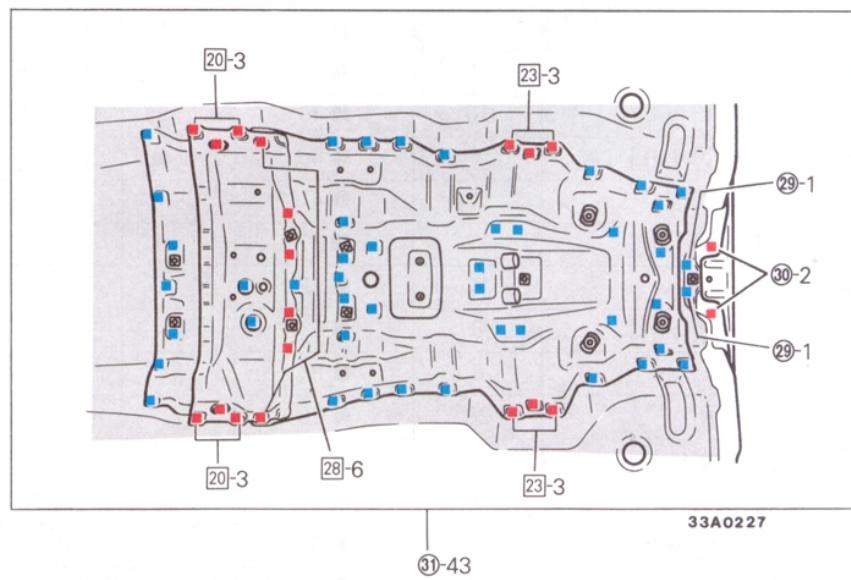
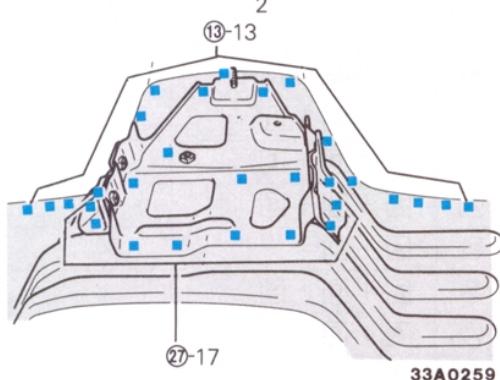
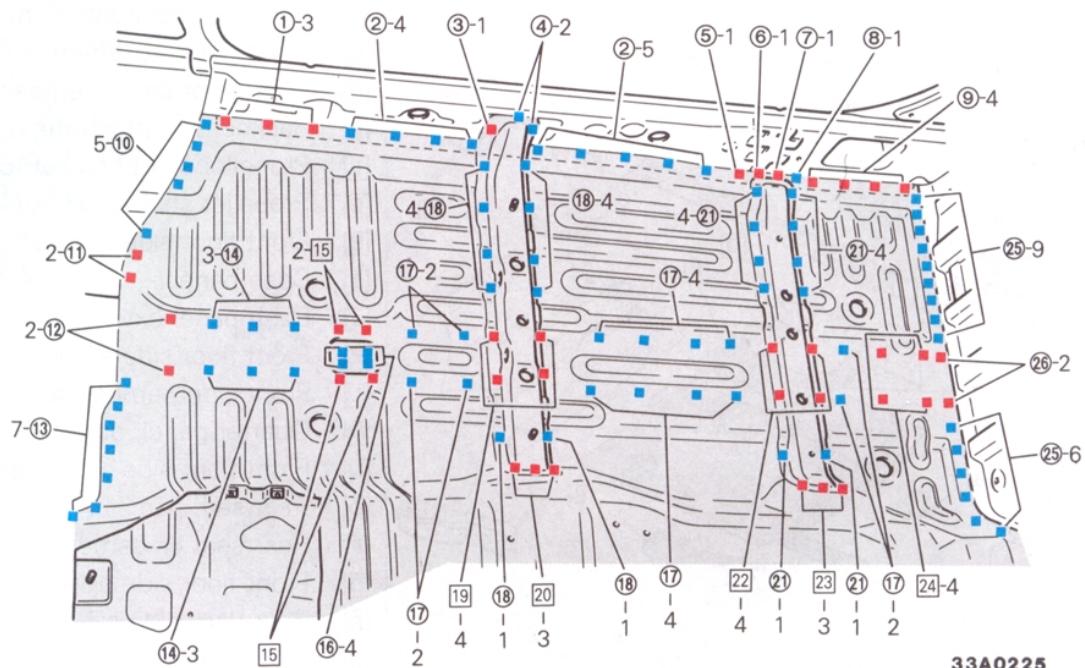


33A0284

The diagram illustrates the exploded view of the front floor pan assembly for a 2WD vehicle. The components are labeled as follows:

- FRONT FLOOR PAN <2WD>**
- REPLACEMENT CONFIGURATION**
- PART NAME**
- Front floor pan**
- Backbone reinforcement, front**
- Front floor crossmember, front**
- Front floor crossmember, rear**
- Backbone reinforcement, rear**
- Front floor sidemember**
- Dash panel**
- Dash panel extension**
- Front floor side sill, inner, front**
- Front sidemember, rear**
- Quarter panel, outer**
- Front floor side sill, outer**
- Rear seat pan**
- Rear seat crossmember**
- Front floor side sill, inner**
- Rear floor side sill**
- Sidemember rear floor extension**

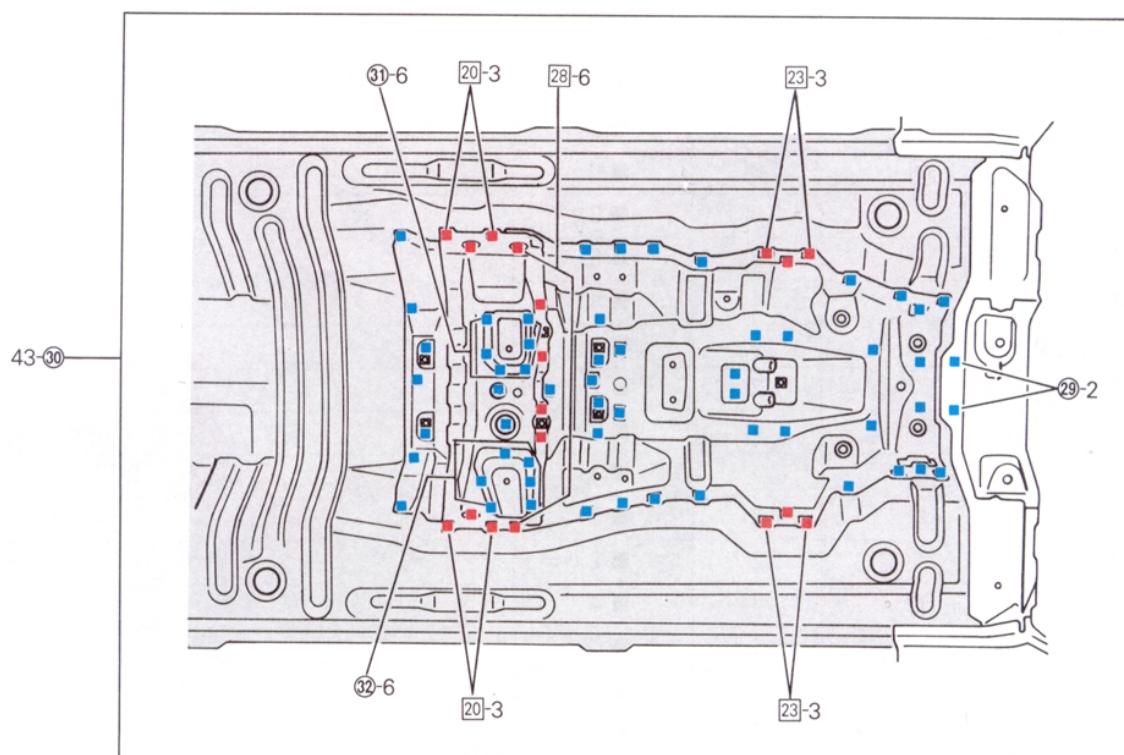
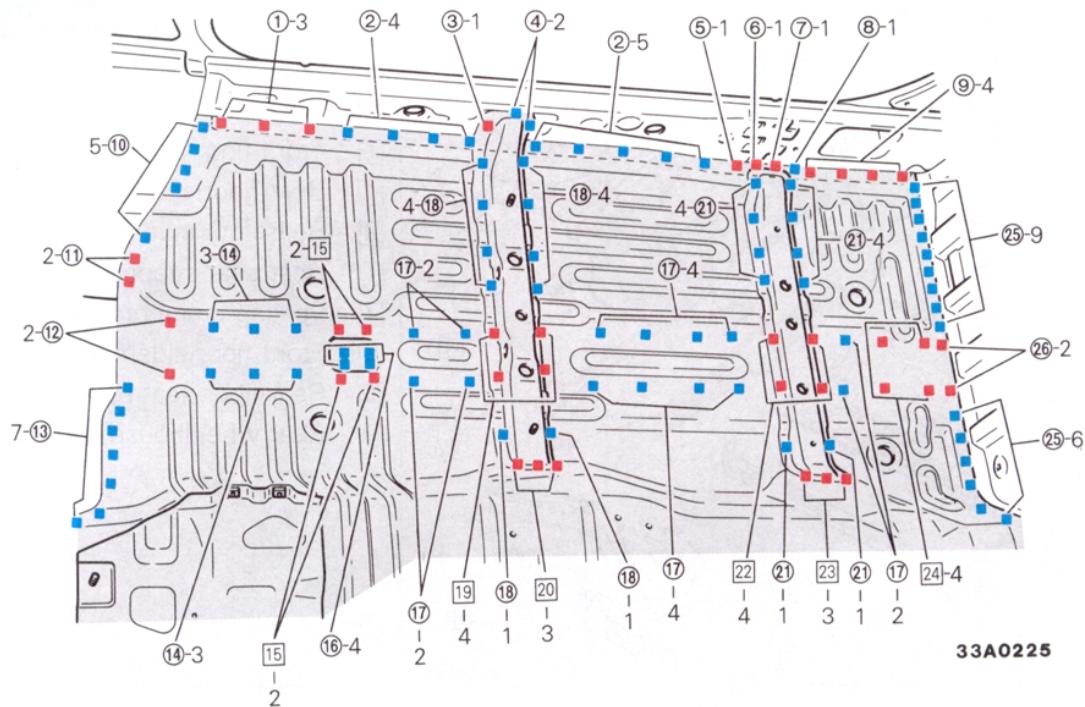
No.	Welded parts	F	R
①	[A] + [I] + [O]	6	■ 6
②	[A] + [O]	18	■ 18
③	[C] + [O]	2	■ 2
④	[C] + [O]	4	■ 4
⑤	[A] + [L] + [O]	2	■ 2
⑥	[A] + [O] + [P]	2	■ 2
⑦	[A] + [L] + [P]	2	■ 2
⑧	[A] + [P]	2	■ 2
⑨	[A] + [K] + [P]	8	■ 8
⑩	[A] + [J]	10	■ 10
⑪	[A] + [H] + [J]	4	■ 4
⑫	[A] + [J]	4	■ 4
⑬	[A] + [G]	17	■ 17
⑭	[A]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



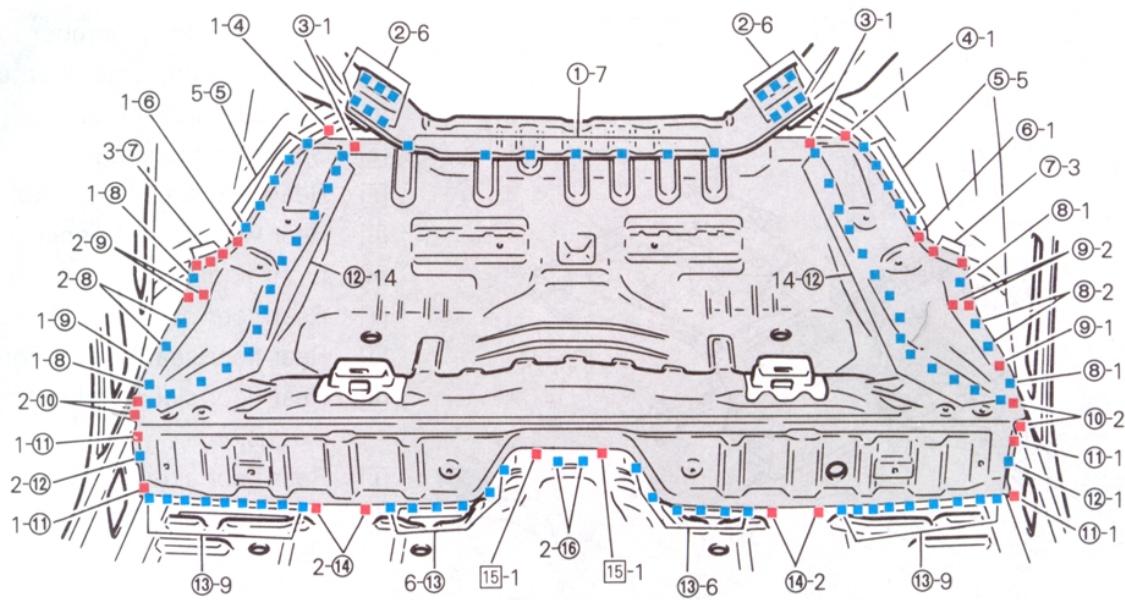
The diagram illustrates the exploded view of the front floor pan assembly for a 4WD vehicle. It shows the following components:

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

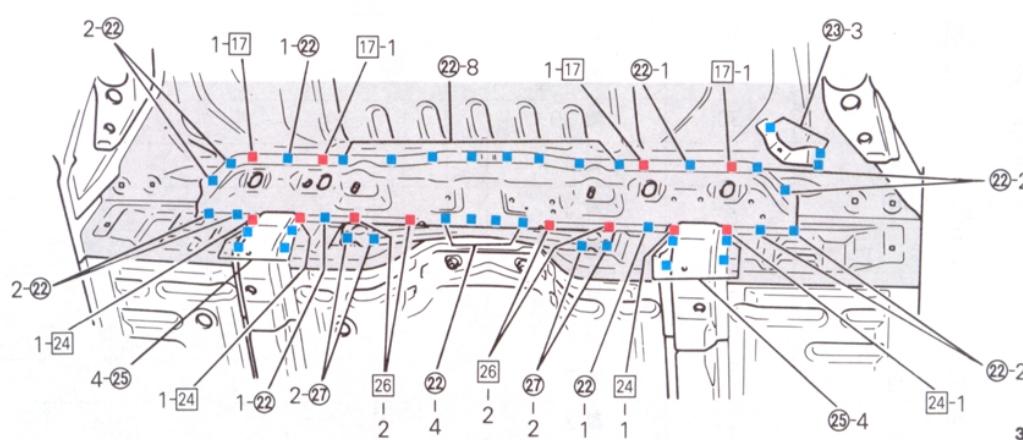
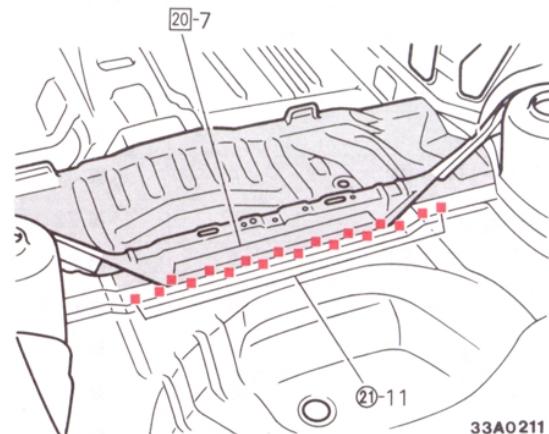
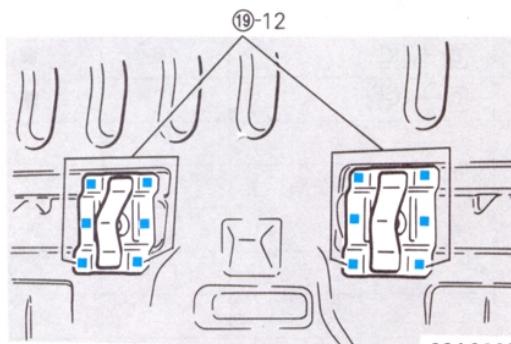
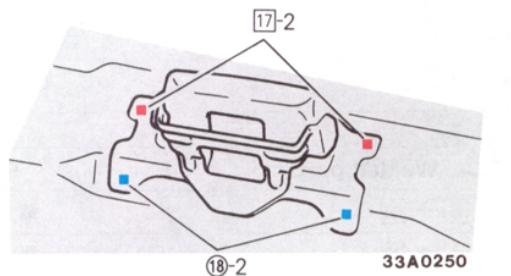
No.	Welded parts	F	R
①	[A] + [K] + [Q]	6	■ 6
②	[A] + [Q]	18	■ 18
③	[C] + [Q]	2	■ 2
④	[C] + [Q]	4	■ 4
⑤	[A] + [N] + [Q]	2	■ 2
⑥	[A] + [Q] + [R]	2	■ 2
⑦	[A] + [N] + [R]	2	■ 2
⑧	[A] + [R]	2	■ 2
⑨	[A] + [M] + [R]	8	■ 8
⑩	[A] + [L]	10	■ 10
⑪	[A] + [J] + [L]	4	■ 4
⑫	[A] + [L]	4	■ 4
⑬	[A] + [I]	17	■ 17
⑭	[A] + [L]	12	■ 12
⑮	[A] + [H] + [L]	8	■ 8
⑯	[F] + [L]	8	■ 8
⑰	[A] + [H]	28	■ 28
⑱	[A] + [C]	20	■ 20
⑲	[A] + [C] + [H]	8	■ 8
⑳	[A] + [C] + [E]	6	■ 6
㉑	[A] + [D]	20	■ 20



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



33A0224



33A0223

**REPLACEMENT CONFIGURATION**

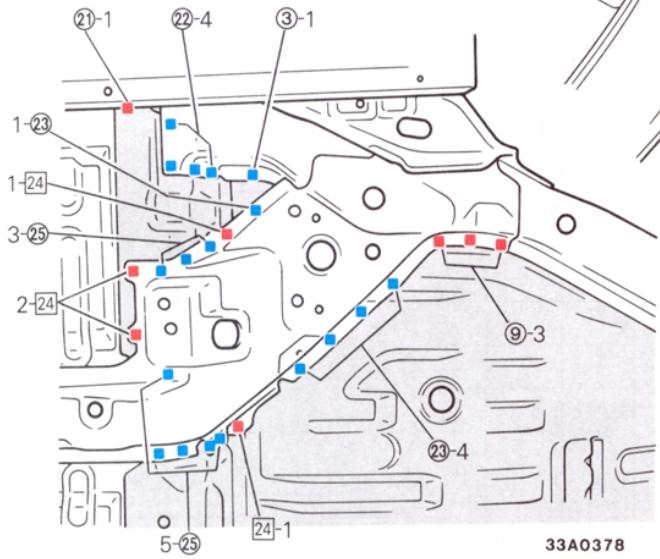
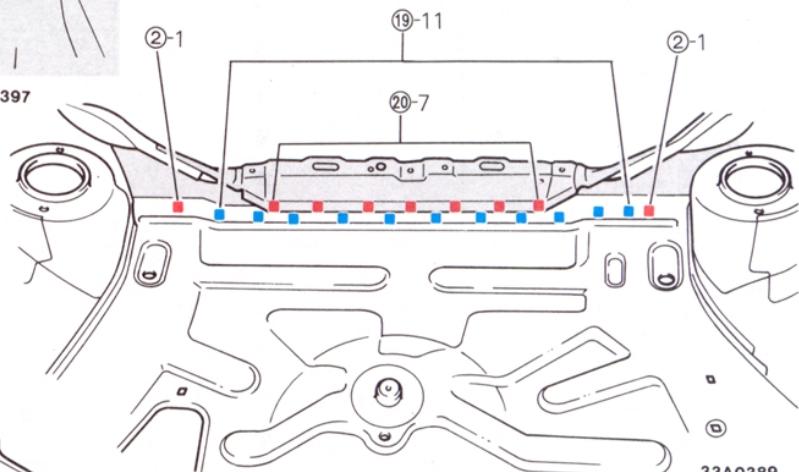
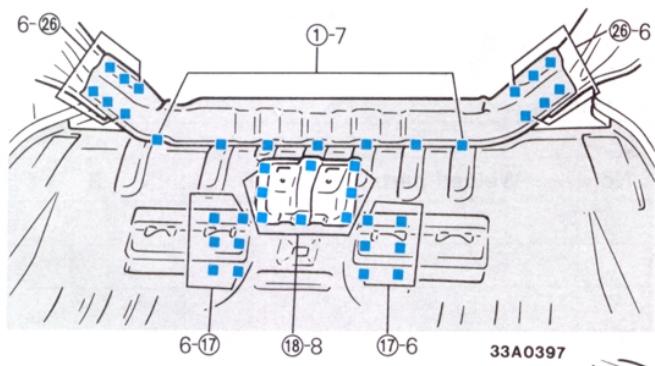
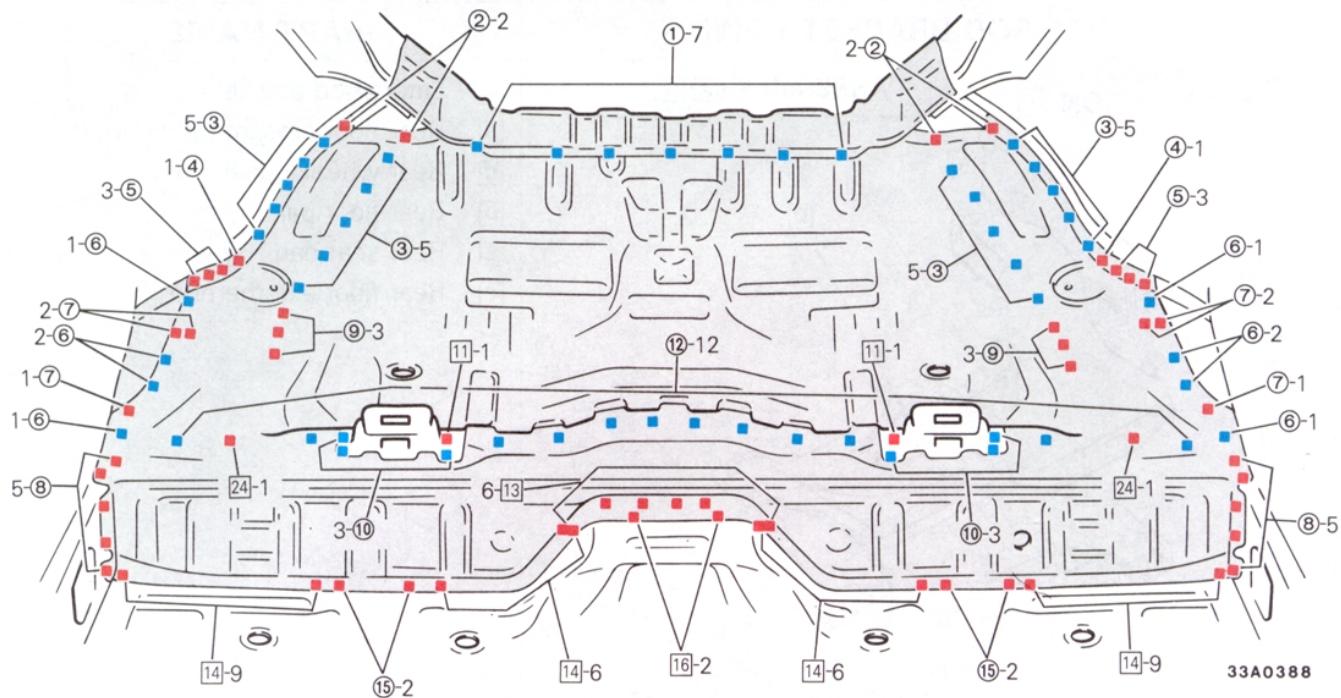
—

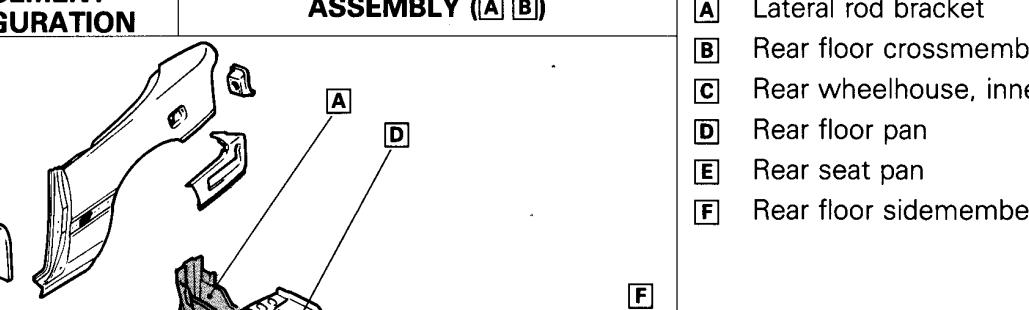
**PART NAME**

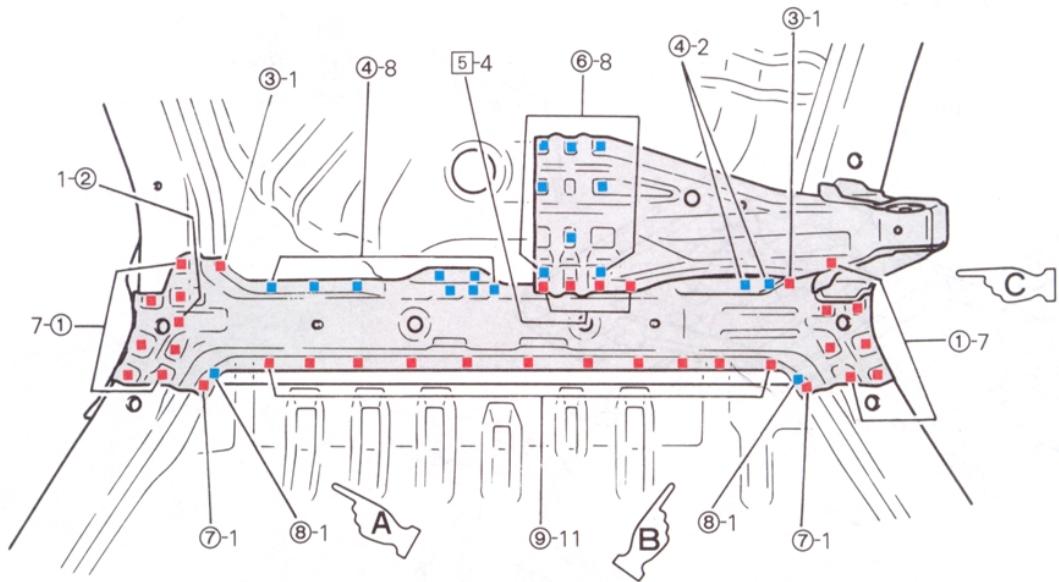
<b>A</b>	Rear seat pan
<b>B</b>	Rear seat crossmember
<b>C</b>	Rear floor crossmember, upper
<b>D</b>	Quarter panel, outer
<b>E</b>	Sprit seat bracket
<b>F</b>	Rear seat support bracket
<b>G</b>	Rear wheelhouse, inner
<b>H</b>	Front floor pan
<b>I</b>	Rear floor pan
<b>J</b>	Rear floor seat belt reinforcement
<b>K</b>	Rear floor sidemember front extension
<b>L</b>	Rear floor side sill
<b>M</b>	Rear floor sidemember

33A0414

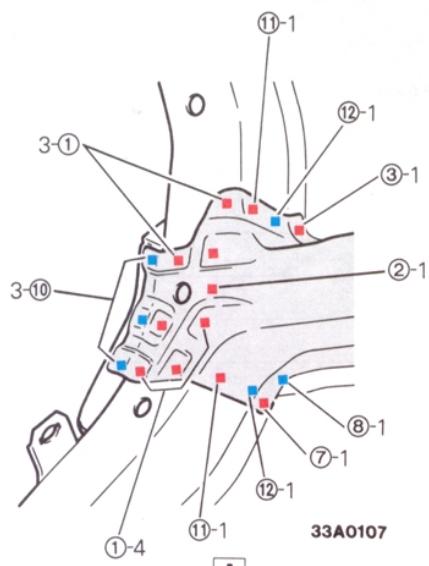
No.	Welded parts	F	R
①	[A] + [C]	7	■ 7
②	[A] + [I] + [M]	4	■ 4
③	[A] + [M]	22	■ 22
④	[A] + [L] + [M]	2	■ 2
⑤	[A] + [G] + [L]	6	■ 6
⑥	[A] + [L]	8	■ 8
⑦	[A] + [L]	6	■ 6
⑧	[A] + [L]	10	■ 10
⑨	[A] + [K] + [M]	6	■ 6
⑩	[A] + [F] ★	6	■ 6
⑪	[A] + [B] + [F]	2	■ 2
⑫	[A] + [B]	12	■ 12
⑬	[A] + [B]	6	■ 6
⑭	[A] +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



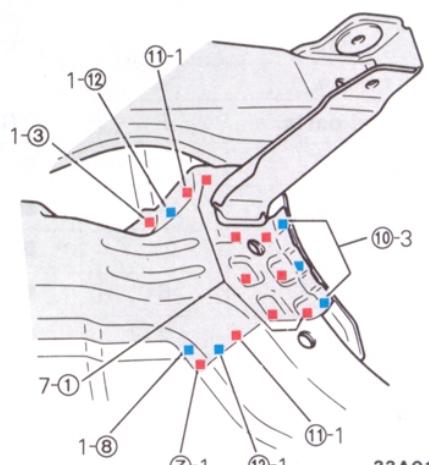
LATERAL ROD BRACKET <2WD>		PART NAME
REPLACEMENT CONFIGURATION	ASSEMBLY (A B)	
		<p><b>A</b> Lateral rod bracket</p> <p><b>B</b> Rear floor crossmember, lower</p> <p><b>C</b> Rear wheelhouse, inner</p> <p><b>D</b> Rear floor pan</p> <p><b>E</b> Rear seat pan</p> <p><b>F</b> Rear floor sidemember</p>



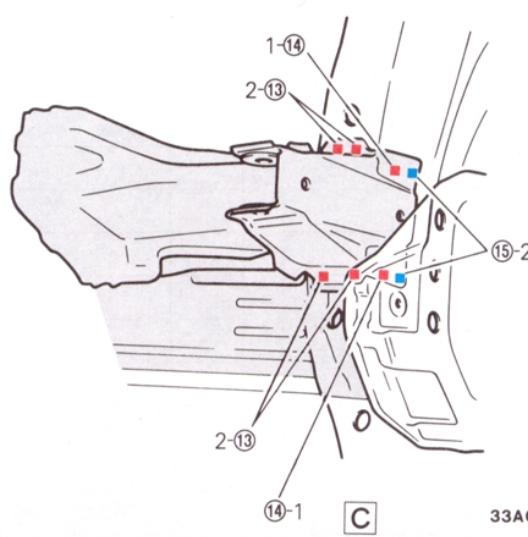
33A0190



33A0107



33A0185



33A0187

**REAR FLOOR CROSMEMBER <4WD>**

**REPLACEMENT CONFIGURATION**

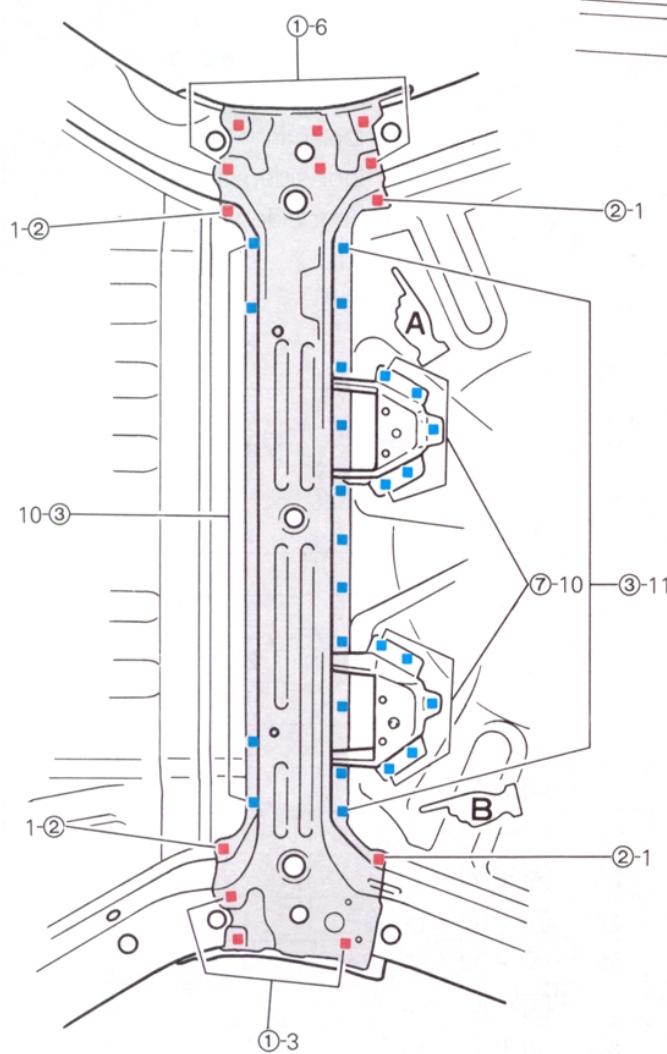
**ASSEMBLY (A)**

**PART NAME**

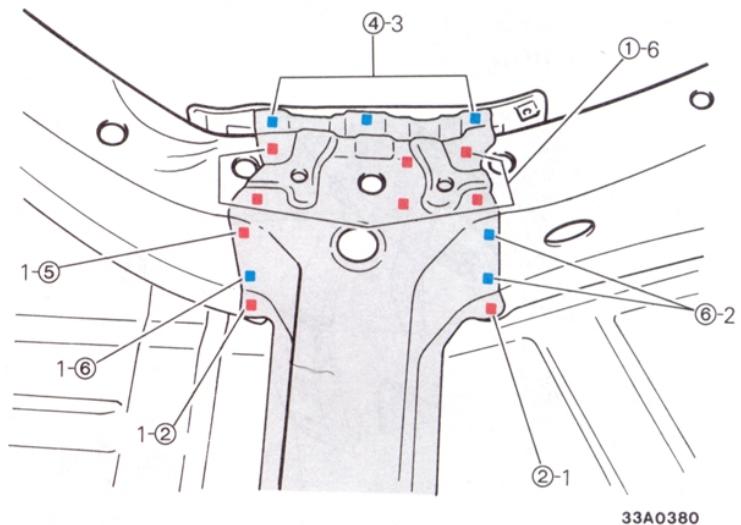
- A** Rear floor crossmember
- B** Rear floor pan
- C** Rear wheelhouse, inner
- D** Rear floor sidemember

33A0416

(Front) ←

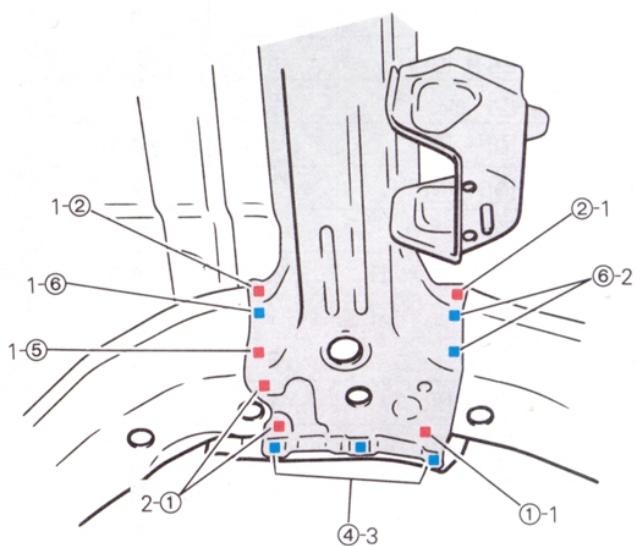


➡ (Rear)



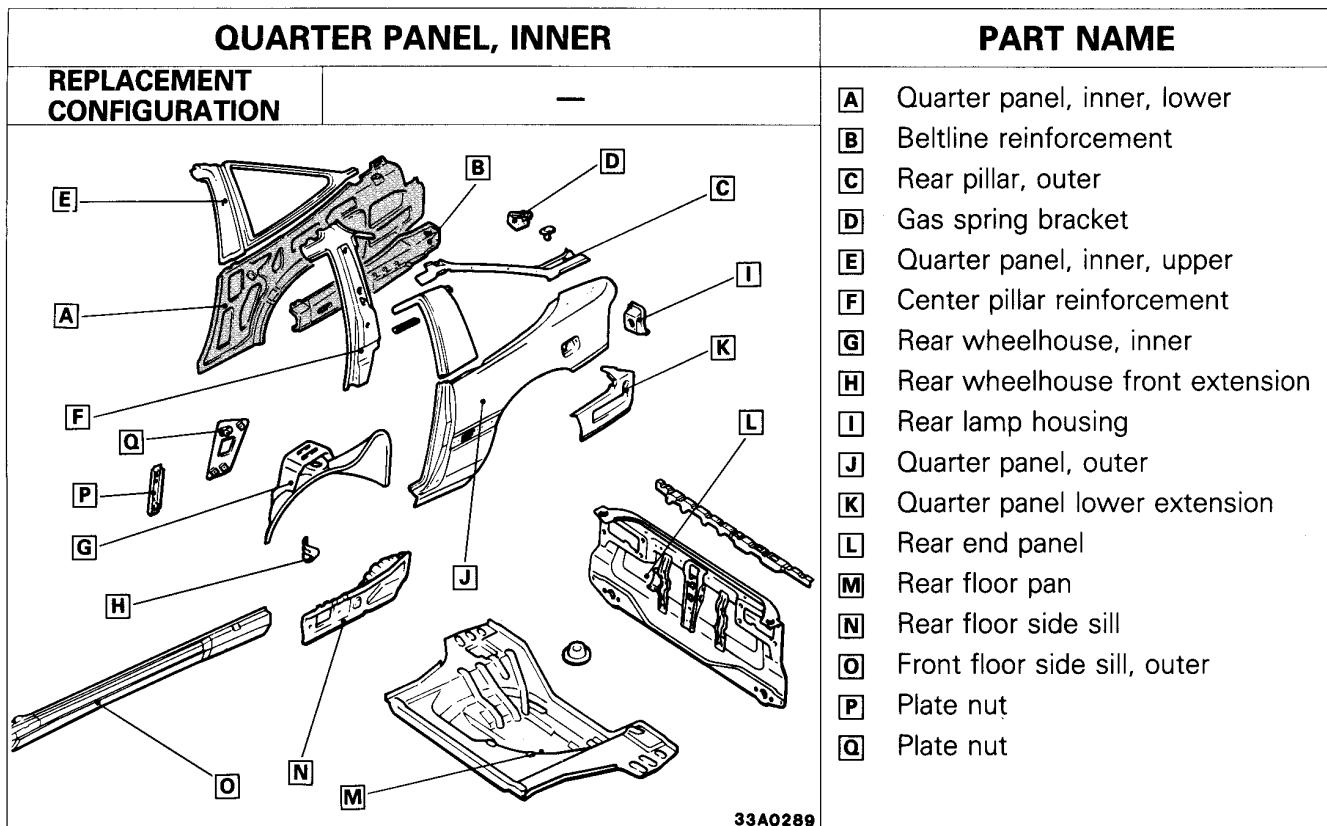
(Left side)

A



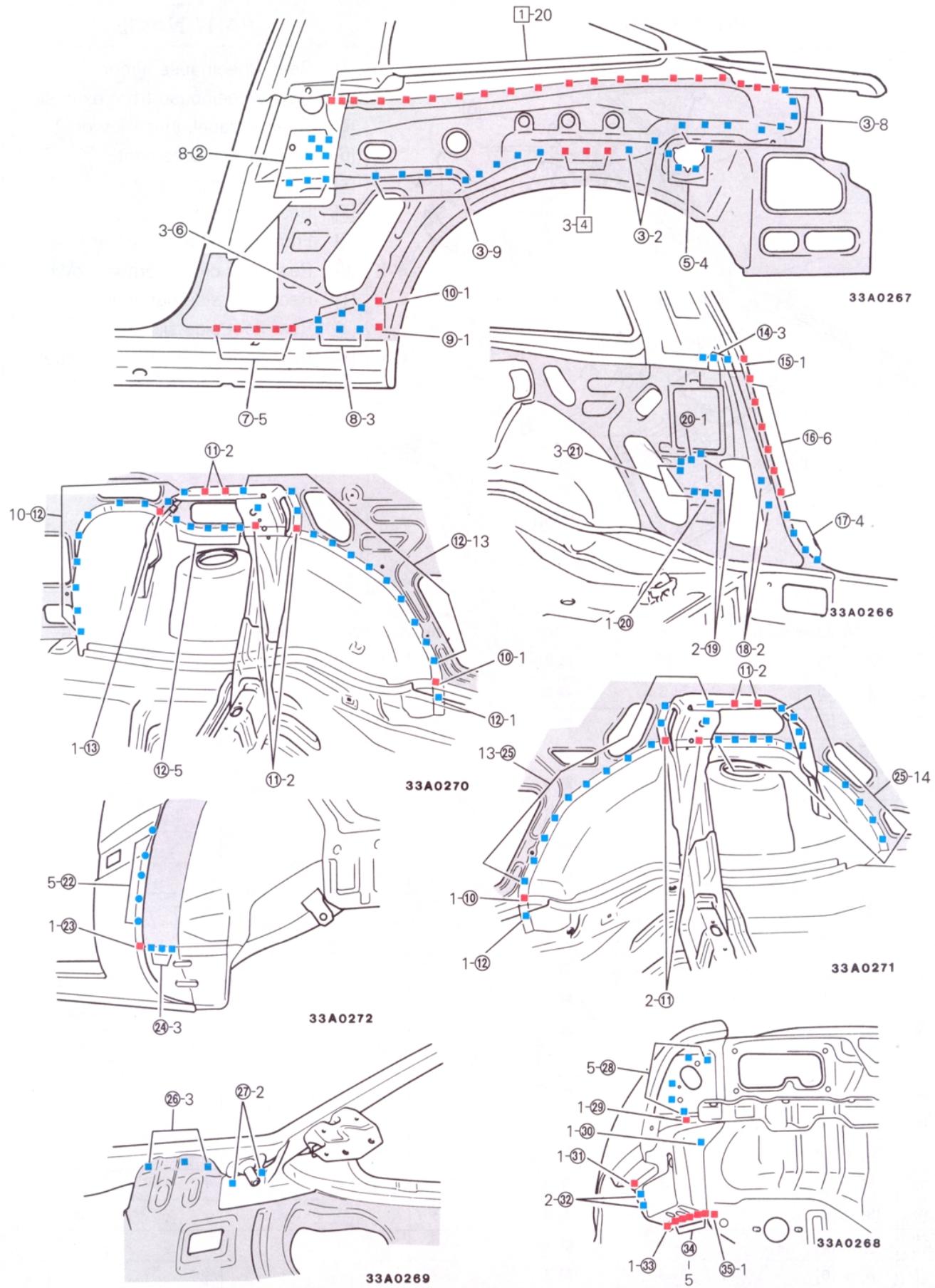
(Right side)

B



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.	19	■ 19
	R.H.	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

No.	Welded parts	F	R
㉑	<b>A</b> + <b>Q</b> L.H. ★	3	■ 3
㉒	<b>A</b> + <b>J</b>	5	■ 5
㉓	<b>A</b> + <b>H</b> + <b>J</b>	1	■ 1
㉔	<b>A</b> + <b>H</b>	3	■ 3
㉕	<b>A</b> + <b>G</b> R.H.	28	■ 28
㉖	<b>A</b> + <b>C</b>	3	■ 3
㉗	<b>A</b> + <b>E</b>	2	■ 2
㉘	<b>A</b> + <b>I</b>	5	■ 5
㉙	<b>A</b> + <b>I</b> + <b>K</b>	1	■ 1
㉚	<b>A</b> + <b>K</b>	1	■ 1
㉛	<b>A</b> + <b>J</b> + <b>K</b>	1	■ 1
㉜	<b>A</b> + <b>K</b>	2	■ 2
㉝	<b>A</b> + <b>G</b>	1	■ 1
㉞	<b>A</b> + <b>K</b> + <b>M</b>	5	■ 5
㉟	<b>A</b> + <b>K</b> + <b>L</b>	1	■ 1

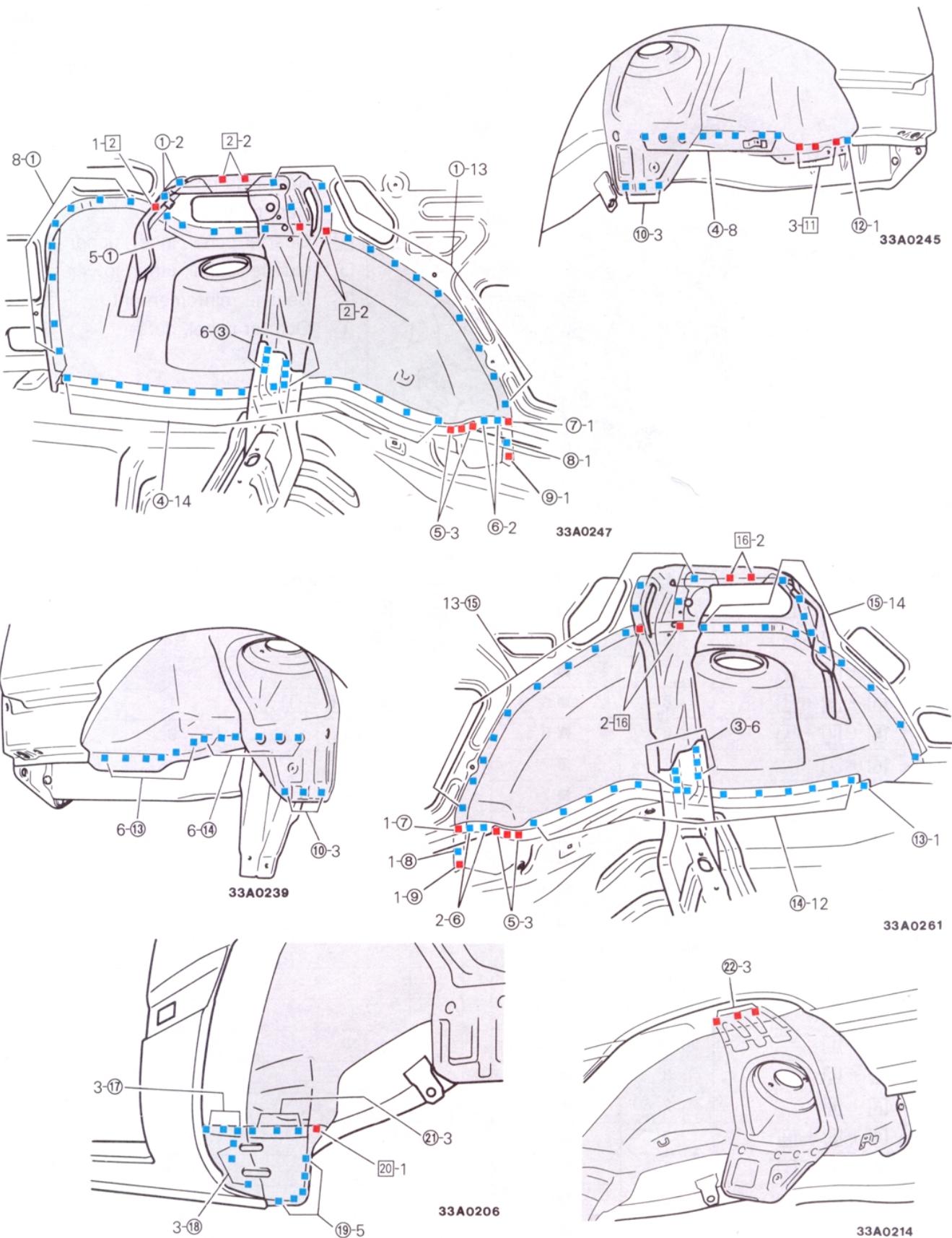


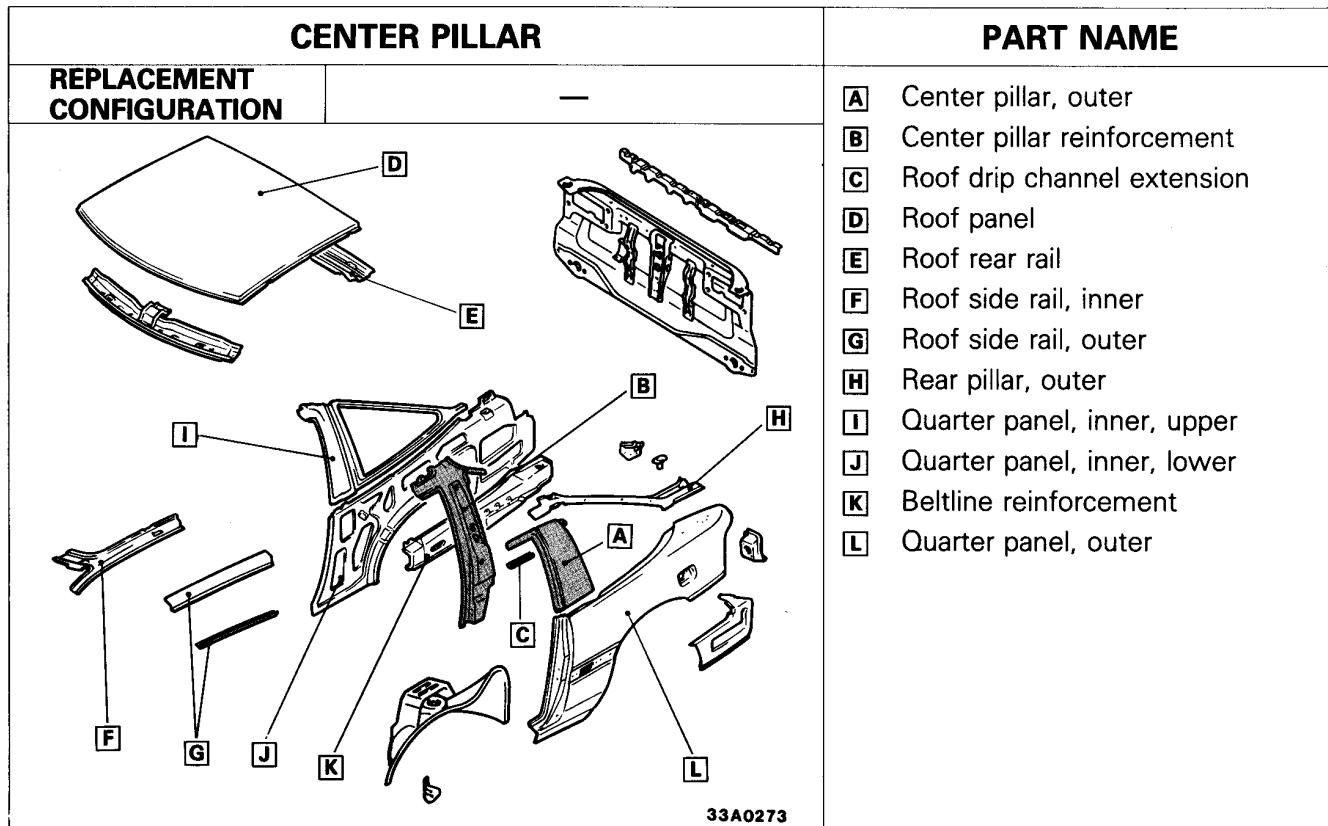
**REPLACEMENT CONFIGURATION**

**PART NAME**

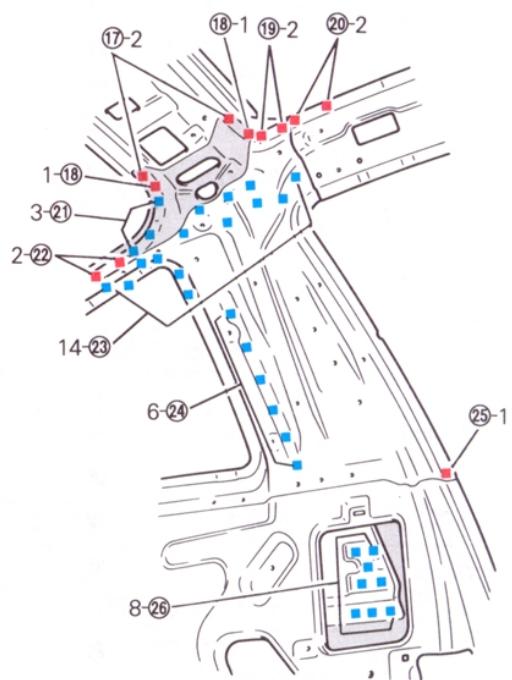
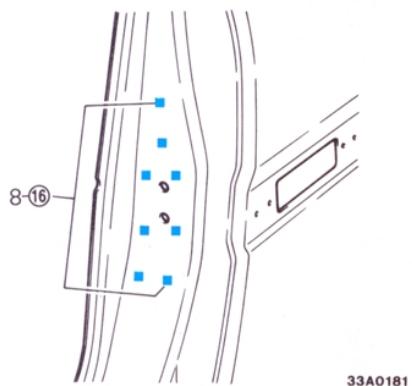
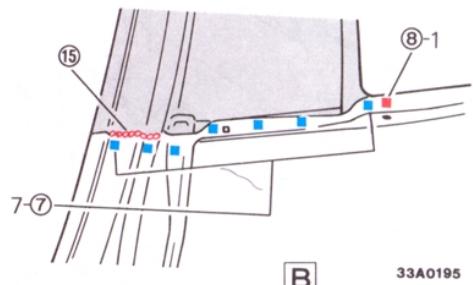
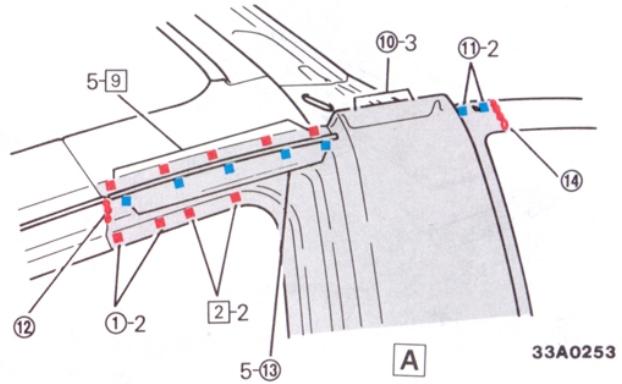
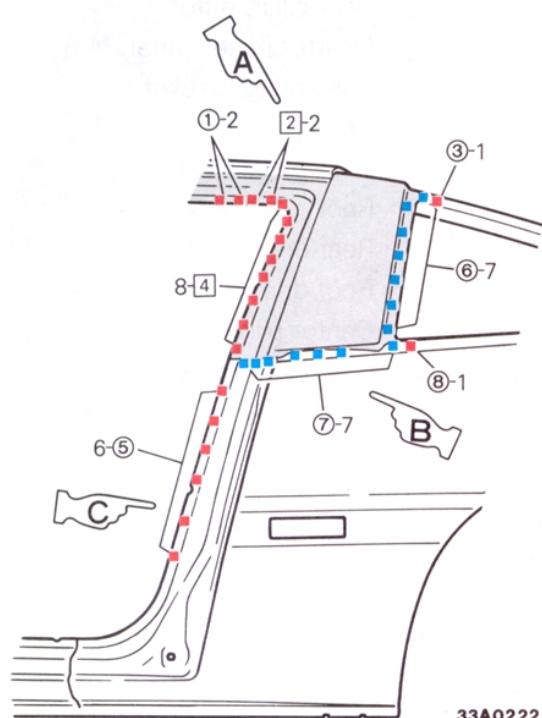
<b>A</b>	Rear wheelhouse, inner
<b>B</b>	Rear wheelhouse front extension
<b>C</b>	Quarter panel, inner, lower
<b>D</b>	Beltline reinforcement
<b>E</b>	Rear seat pan
<b>F</b>	Rear floor pan
<b>G</b>	Front floor side sill, outer
<b>H</b>	Rear floor crossmember, lower
<b>I</b>	Rear floor sidemember
<b>J</b>	Rear floor side sill
<b>K</b>	Rear floor crossmember, upper

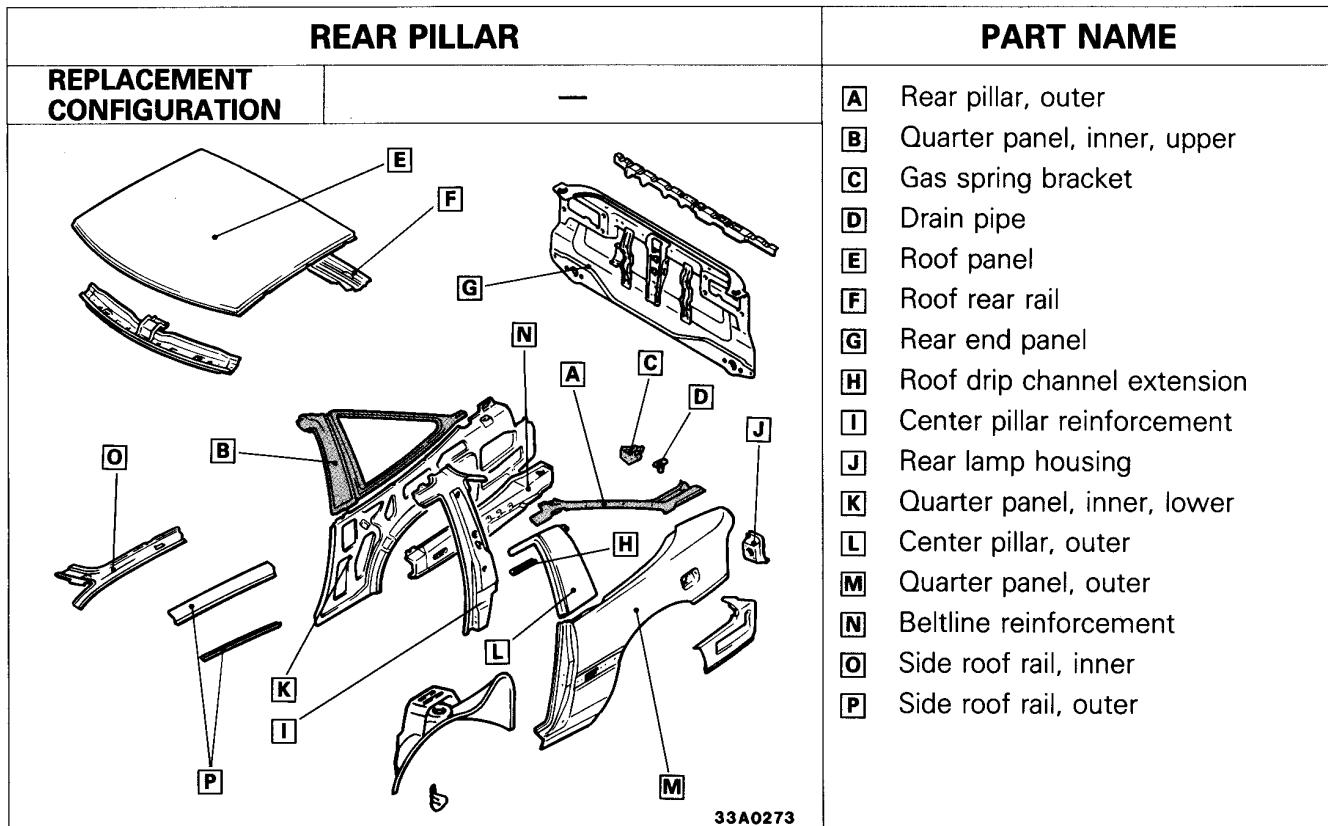
No.	Welded parts	F	R
①	[A] + [C] L.H.	28	■ 28
②	[A] + [C] L.H.	5	■ 5
③	[A] + [K]	6	■ 6
④	[A] + [I] L.H.	14	■ 14
⑤	[A] + [E] + [J]	3	■ 3
⑥	[A] + [J]	2	■ 2
⑦	[A] + [C] + [J]	1	■ 1
⑧	[A] + [C]	1	■ 1
⑨	[A] + [C] + [J]	1	■ 1
⑩	[A] + [H]	3	■ 3
⑪	[A] + [F] L.H.	3	■ 3
⑫	[A] + [F] L.H.	1	■ 1
⑬	[A] + [F] R.H.	6	■ 6
⑭	[A] + [I] R.H.	12	■ 12
⑮	[A] + [C] R.H.	27	■ 27
⑯	[A] + [C] R.H.	4	■ 4
⑰	[B] + [C]	3	■ 3
⑱	[B] + [G]	3	■ 3
⑲	[B] + [J]	5	■ 5
⑳	[A] + [B] + [J]	1	■ 1
㉑	[A] + [B]	3	■ 3



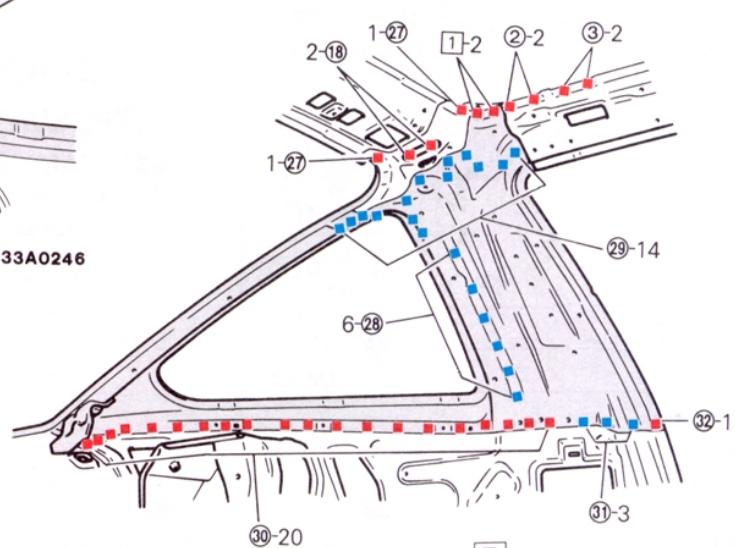
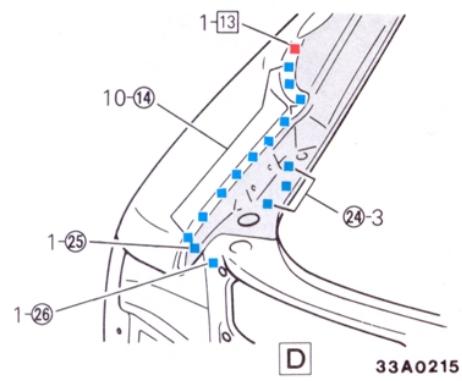
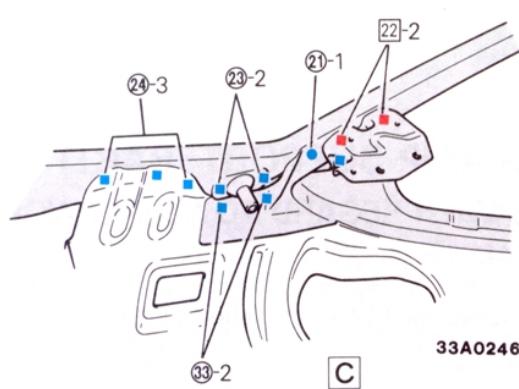
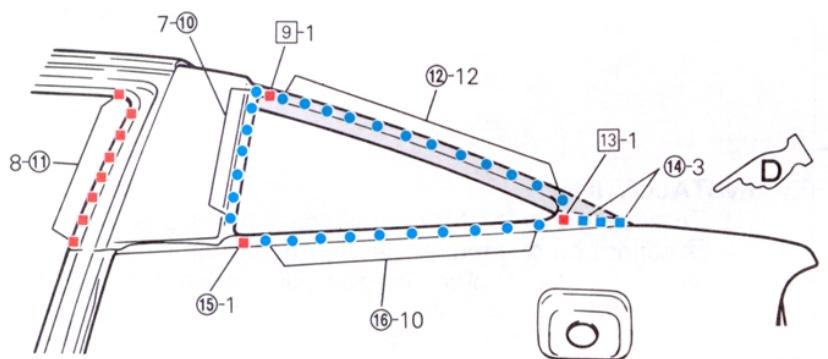
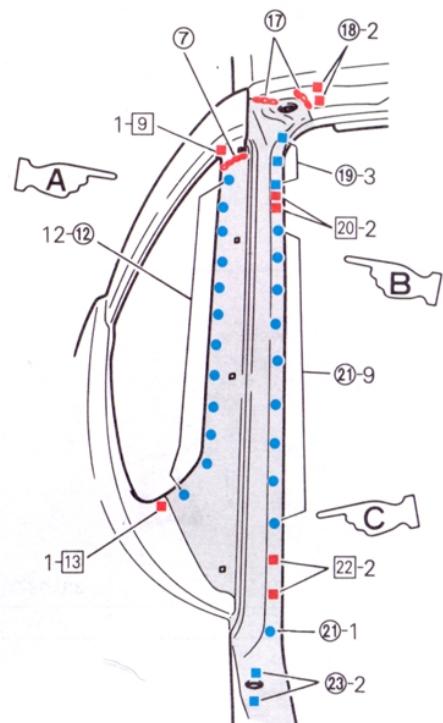
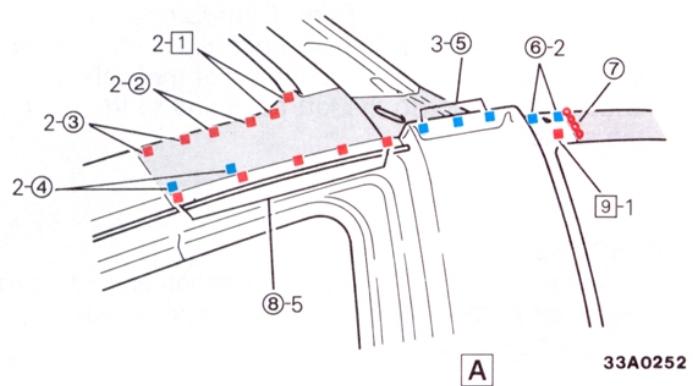


No.	Welded parts	F	R
①	[A] + [F] + [G]	2	■ 2
②	[A] + [B] + [F]	2	■ 2
③	[A] + [H] + [I]	1	■ 1
④	[A] + [B] + [I]	8	■ 8
⑤	[B] + [J] + [L]	6	■ 6
⑥	[A] + [I]	7	■ 7
⑦	[A] + [L]	7	■ 7
⑧	[A] + [I] + [L]	1	■ 1
⑨	[A] + [C] + [H]	5	■ 5
⑩	[A] + [H]	3	■ 3
⑪	[A] + [H]	2	■ 2
⑫	[A] + [G]	MIG brazing	MIG brazing
⑬	[C]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





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



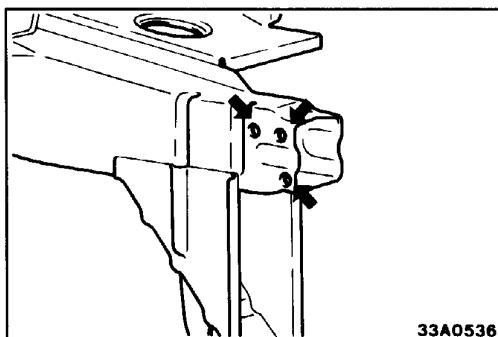
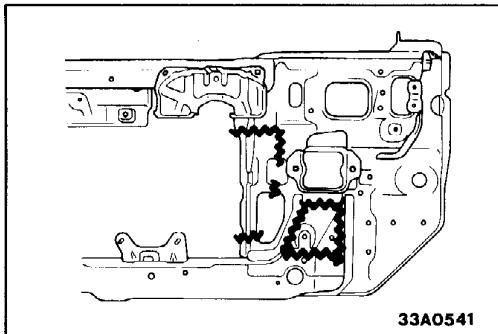
## HEADLAMP SUPPORT (ASSEMBLY)

### 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

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



### INSTALLATION

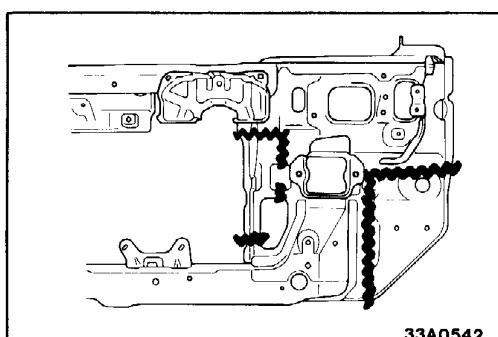
- Because the holes for plug welding of weld points 8 and 12 cannot be opened for new parts, the opening should be made where shown in the illustration of the front sidemember.

## HEADLAMP SUPPORT (PART)

### NOTES WITH REGARD TO REPAIR WORK

#### REMOVAL

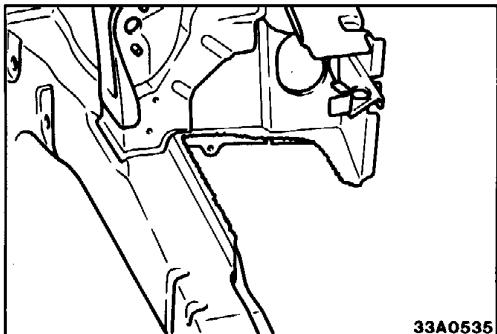
- The locations shown in the illustration should be rough cut in order to facilitate separation of spot welds.



## FRONT FENDER SHIELD

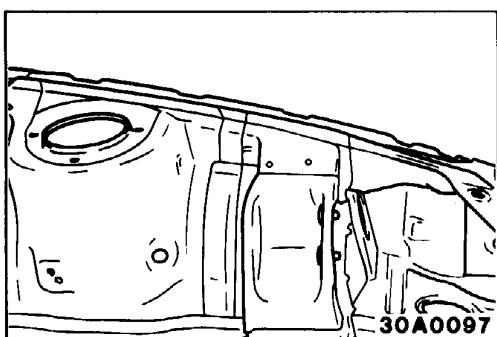
### NOTES WITH REGARD TO REPAIR WORK

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

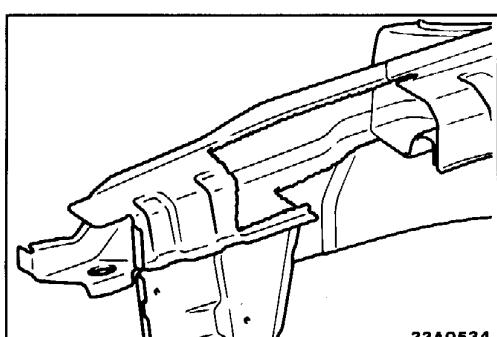


#### REMOVAL

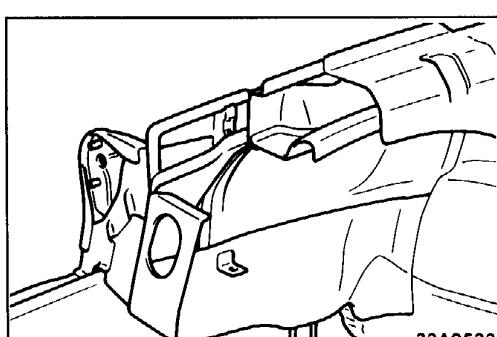
- (1) The shield plate should be rough cut in order to facilitate separation of spot welds.



- (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 ⑤.

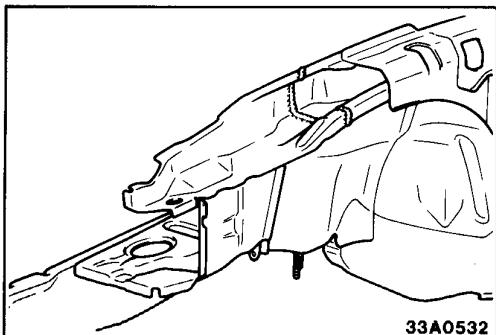


#### INSTALLATION

- (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.

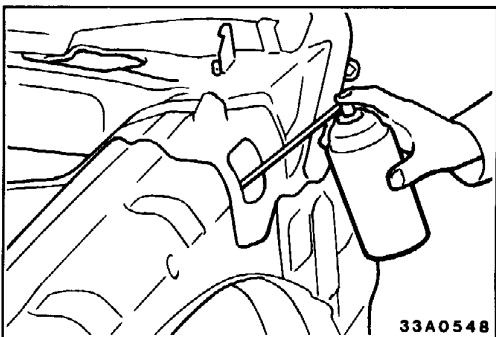


33A0532

- (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.

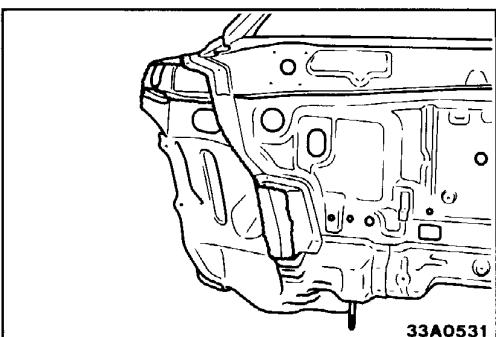
**Caution**

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



33A0548

- (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.



33A0531

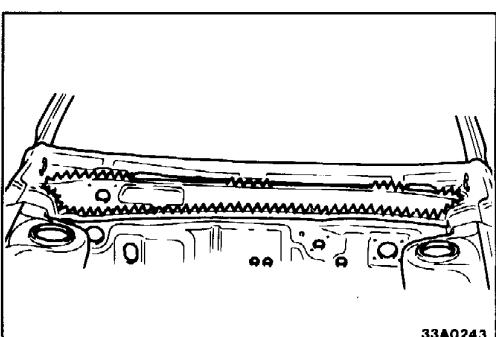
## FENDER SHIELD ASSEMBLY NOTES WITH REGARD TO REPAIR WORK

### 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.**

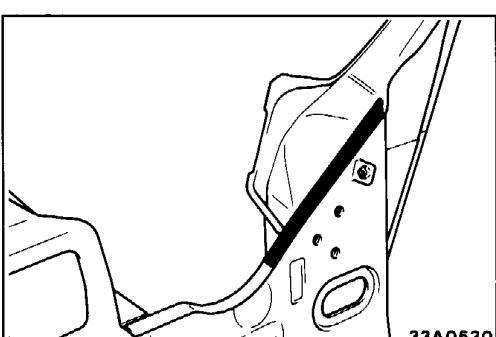


33A0243

## 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.



33A0530

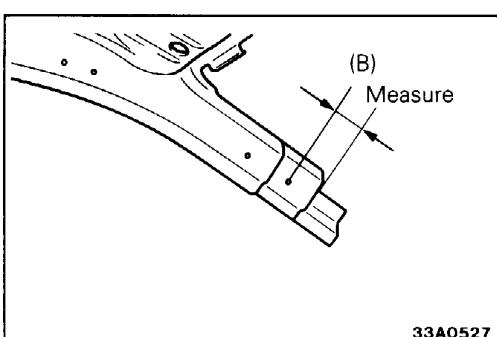
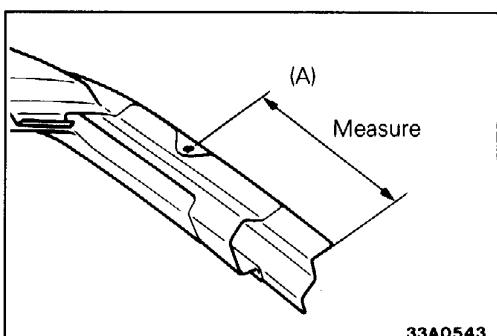
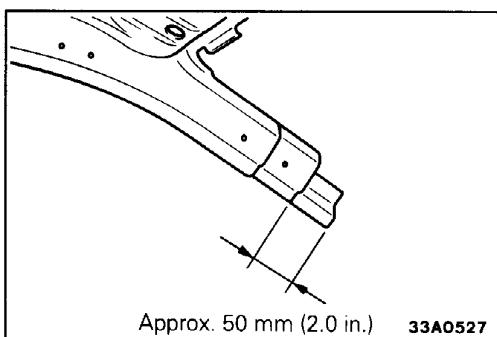
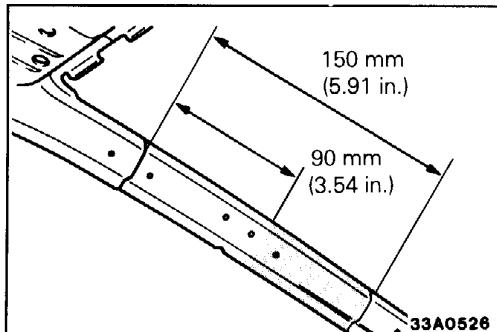
### INSTALLATION

- (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.

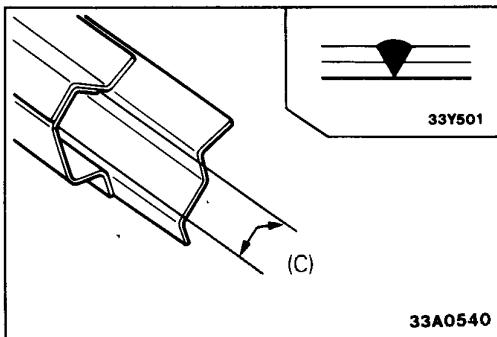
### INSTALLATION

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

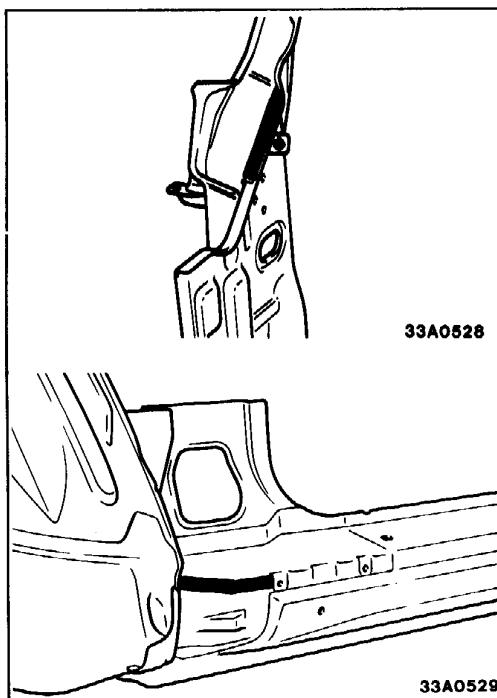
#### NOTE

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

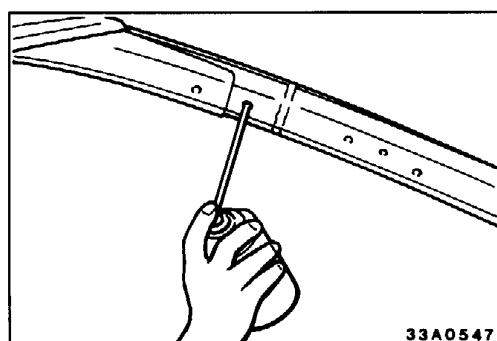
For the inner panel side, use the front pillar trim installation hole (B).



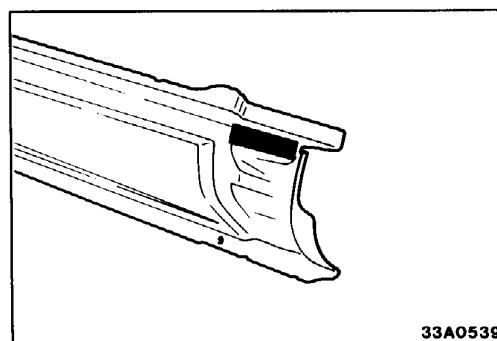
(2) When butt-welding the part indicated by (C) in the illustration, cut the overlap part of the panel in a V shape so that bolt panels can be welded together, assuring better penetration during welding.



(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.

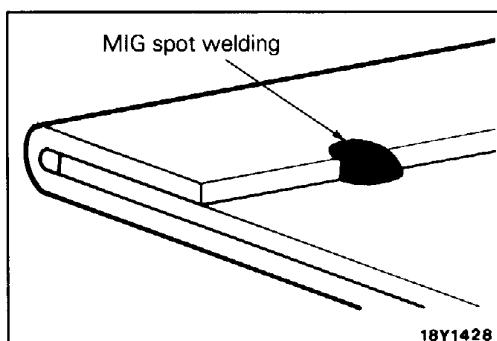
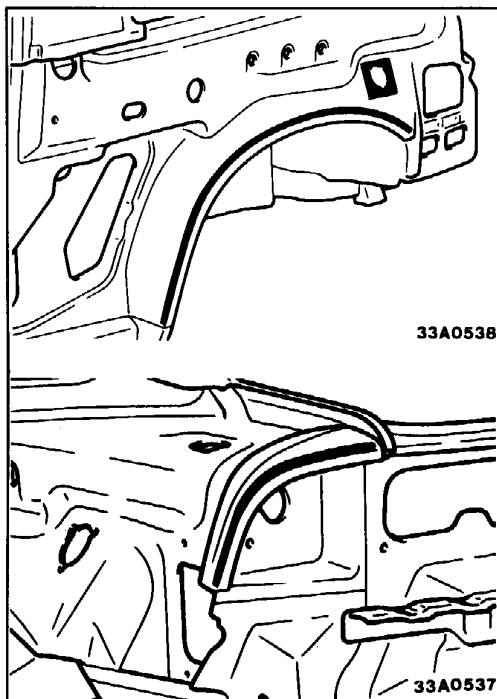
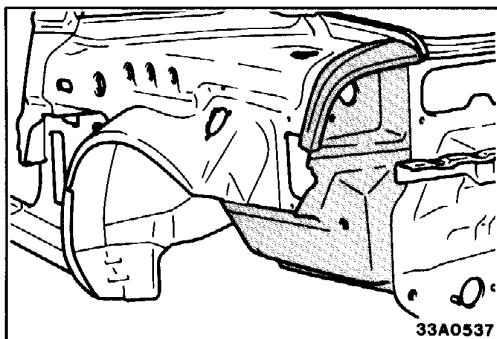
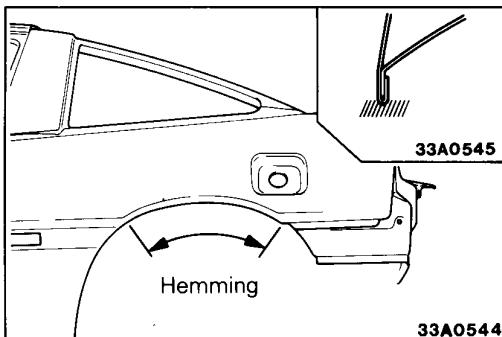


## SIDE SILL

### 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 ⑬, 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

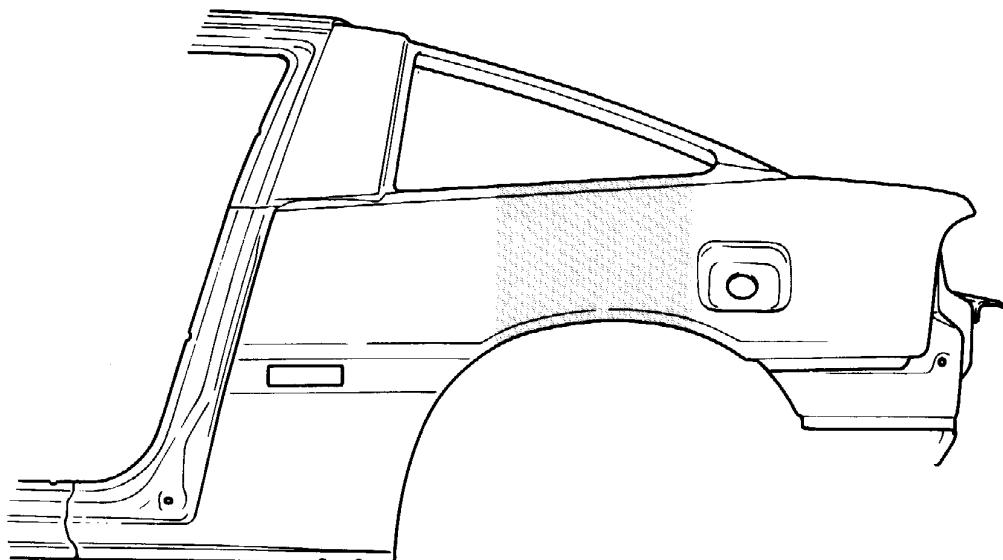
- (1) First install the rear lamp housing and quarter outer lower extension to the body, and then install the quarter panel (outer).
- (2) Apply a coating of silicon rubber sealer at the body side where shown in the illustration.
- (3) After completion of hemming, make MIG spot welds at the edge of the flange of the quarter panel (outer), at intervals of approximately 50 mm (1.97 in.). (Weld point: ⑯)

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

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

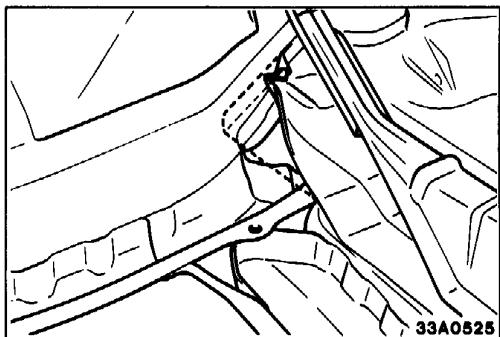
**Caution**

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



33A0193

 : Range within which cutting is possible



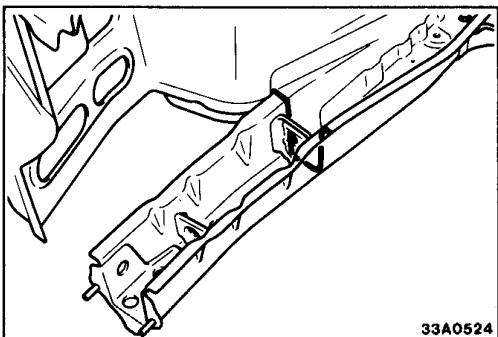
### REAR FLOOR PAN

#### 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.



33A0524

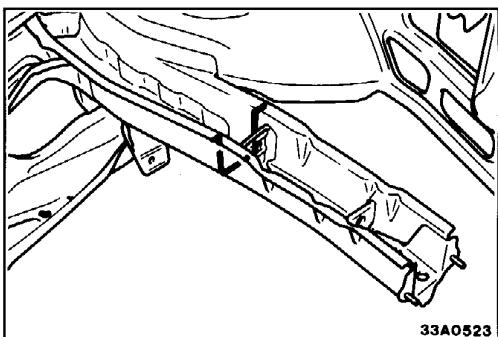
## REAR FLOOR SIDEMEMBER

### NOTES WITH REGARD TO REPAIR WORK

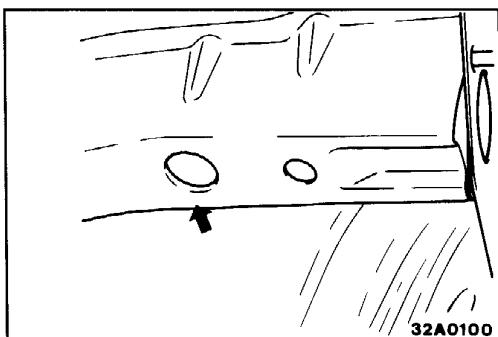
- Cut the rear floor sidemember where shown in the illustration.

#### 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.



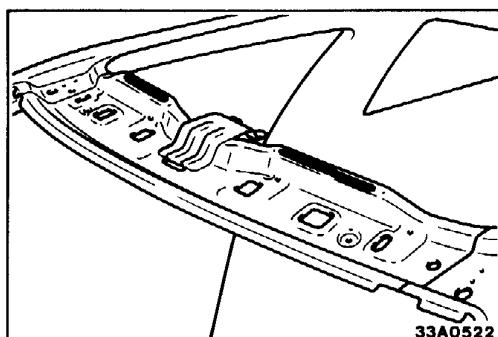
33A0523



32A0100

### 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.



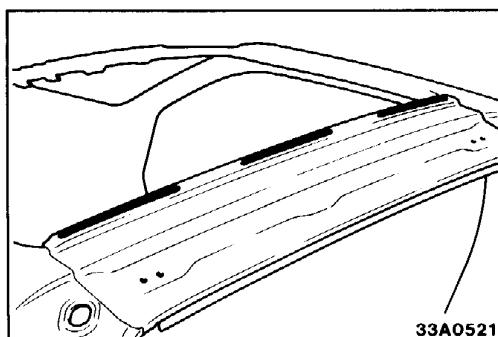
33A0522

## ROOF PANEL

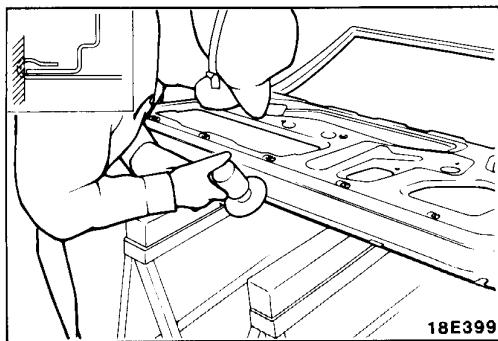
### NOTES WITH REGARD TO REPAIR WORK

#### INSTALLATION

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



33A0521



## 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

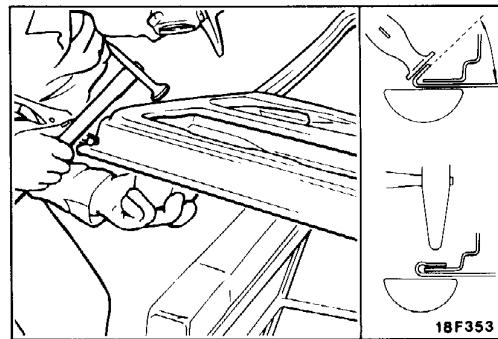
- (1) Use an air grinder to grind off the hemming edge of the perimeter of the outer panel.

### INSTALLATION

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

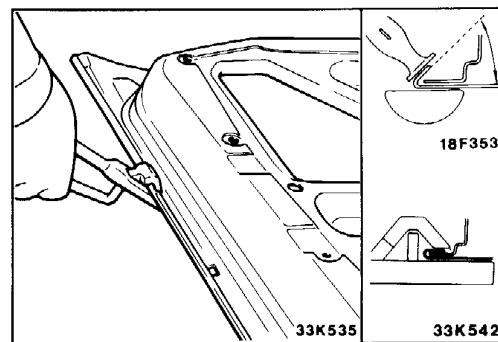
#### Caution

- 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.