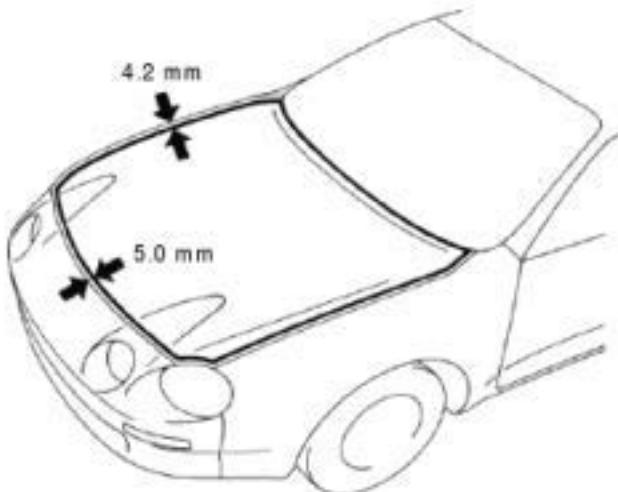
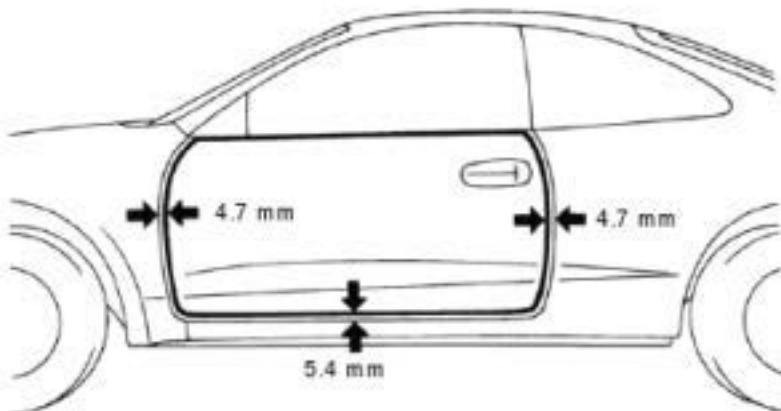


FIT STANDARDS

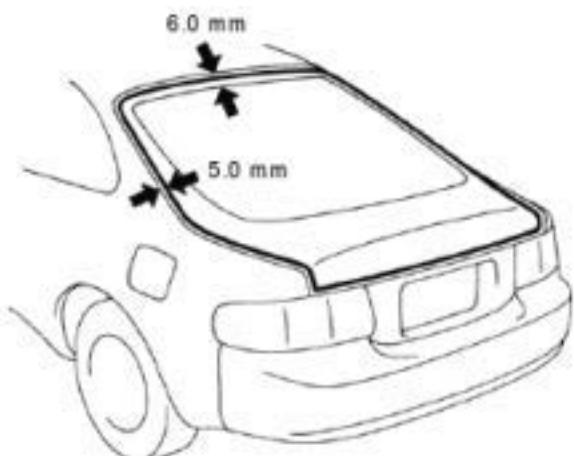
After doors and the engine hood are installed, be sure to perform fit adjustment to prevent abnormal wind noise and ensure a good appearance.



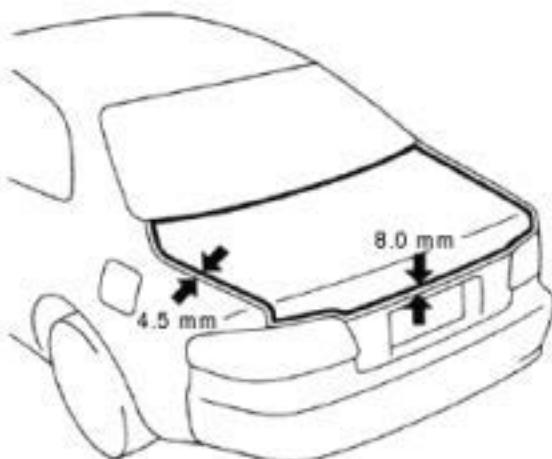
mm	in.
4.2	0.165
4.5	0.177
4.7	0.185
5.0	0.197
5.4	0.213
6.0	0.236
8.0	0.315



Liftback



Coupe



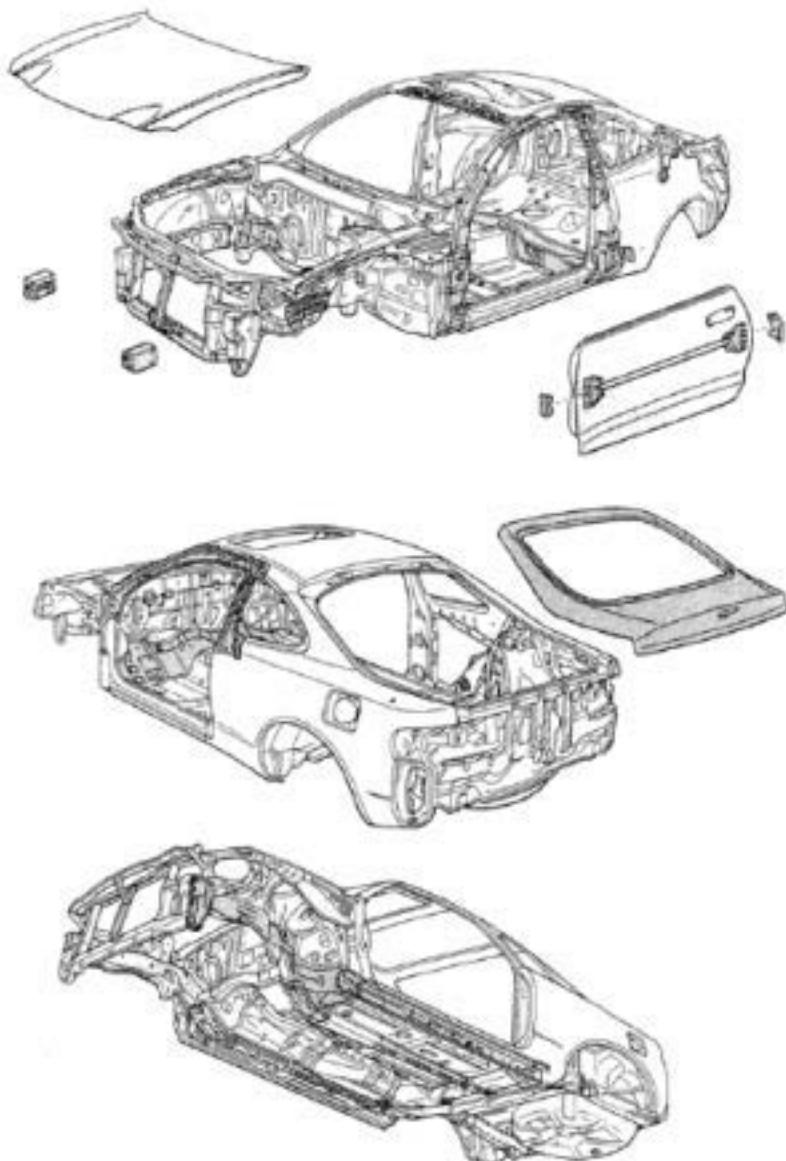
HIGH-STRENGTH STEEL (HSS) PARTS

Generally, High-Strength Steel (HSS) is that which has an intensity value of at 35 kgf/mm² (343 MPa), and distinguished from mild steel.

The handling of HSS is the same as for mild steel, but the following should be observed.

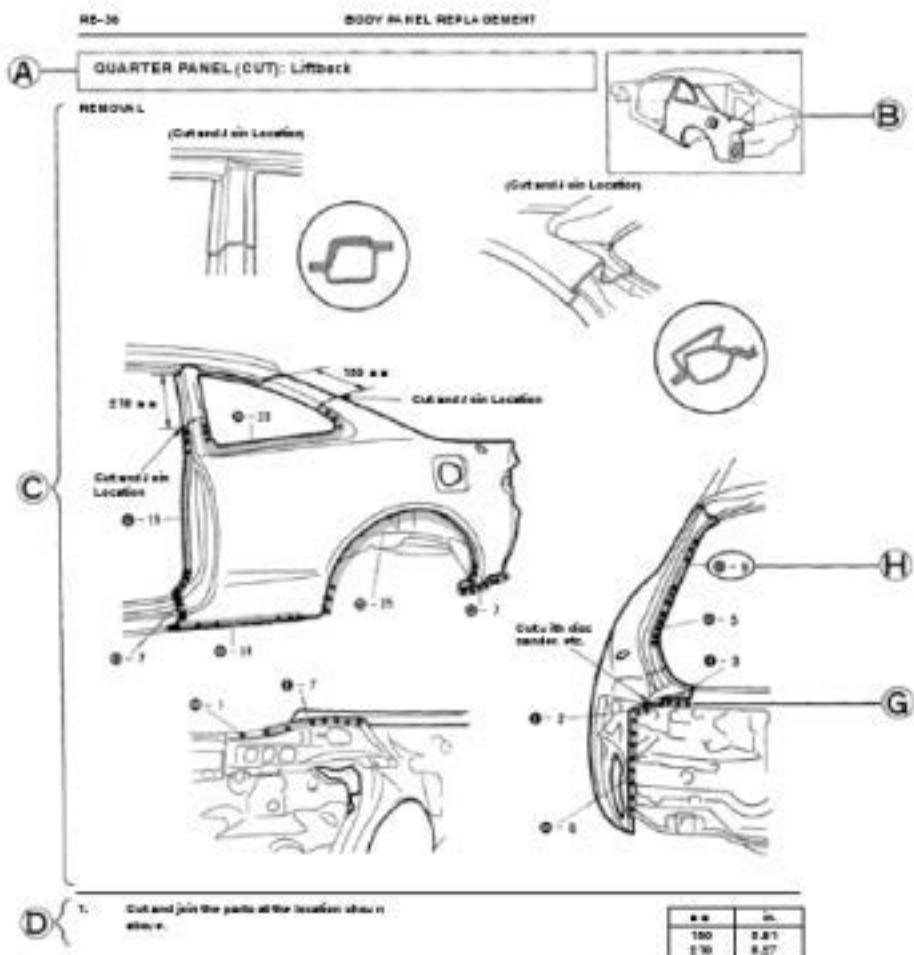
1. **Panel Hammering:** Because HSS is thinner than mild steel, care should be taken to avoid warping during hammering operations.
2. **Removing Spot Welds:** Because HSS is tougher than mild steel, damage will occur more easily to a regular drill. Therefore, an HSS Spot Cutter is recommended. Also, use a high-torque drill at low speed, and supply grinding oil to the drill during use.
3. **Panel Welding:** Panel welding procedures for HSS are exactly the same as for mild steel. Plug welding should be done with MIG (Metal Inert Gas) welder. Do not gas weld or braze panels at areas other than specified.

 : High-Strength Steel



HOW TO USE THIS MANUAL

Each repair method description provided in Section RE of this manual comprises two pages, divided into 2 blocks (REMOVAL AND INSTALLATION) and includes illustrations to facilitate body repair.



A : REPLACEMENT PARTS AND METHOD

QUARTER PANEL (CUT)

- Replacement method
 - (ASSY) Assembly replacement
 - (CUT) Major cutting (less than 1/2 of parts used)
 - (CUT-H) Half cutting (about 1/2 of parts used)
 - (CUT-P) Partial cutting (most of parts used)
 - Replacement Parts

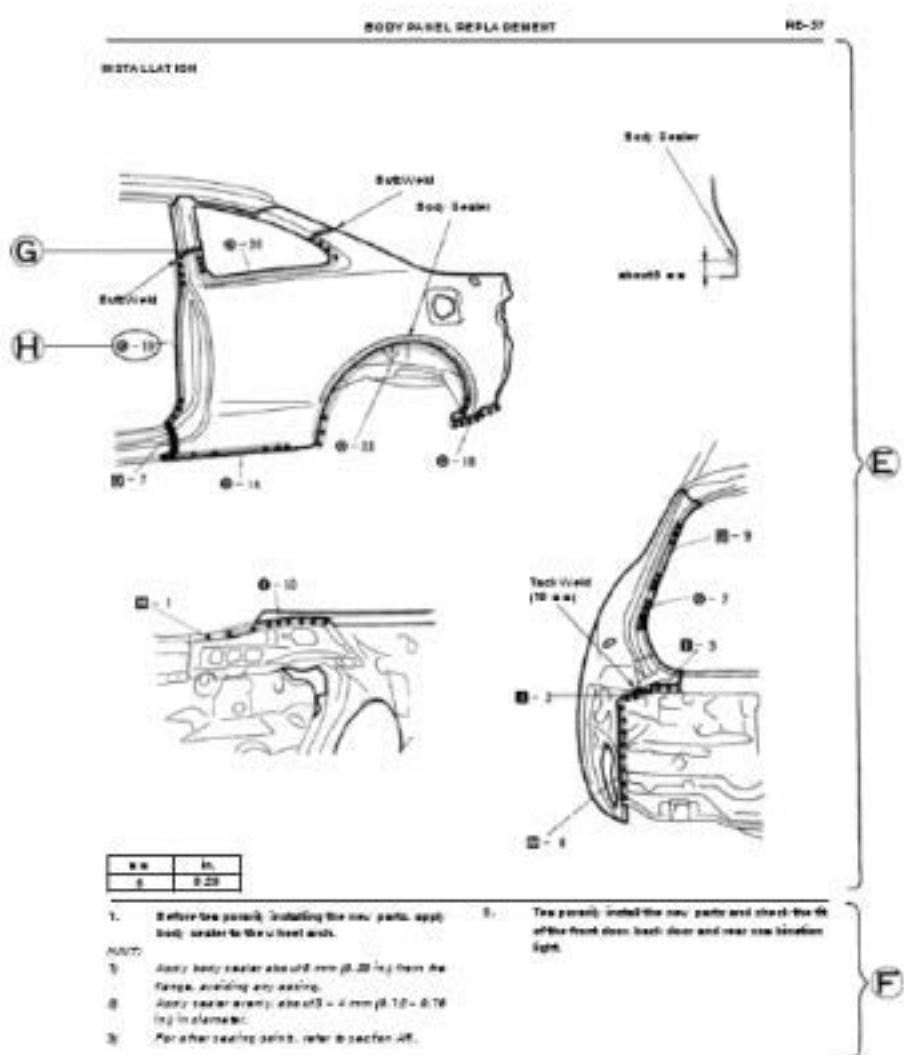
PARTS LOCATION

C : REMOVAL DIAGRAM

Describes in detail removal of the damaged parts involving repair by cutting.

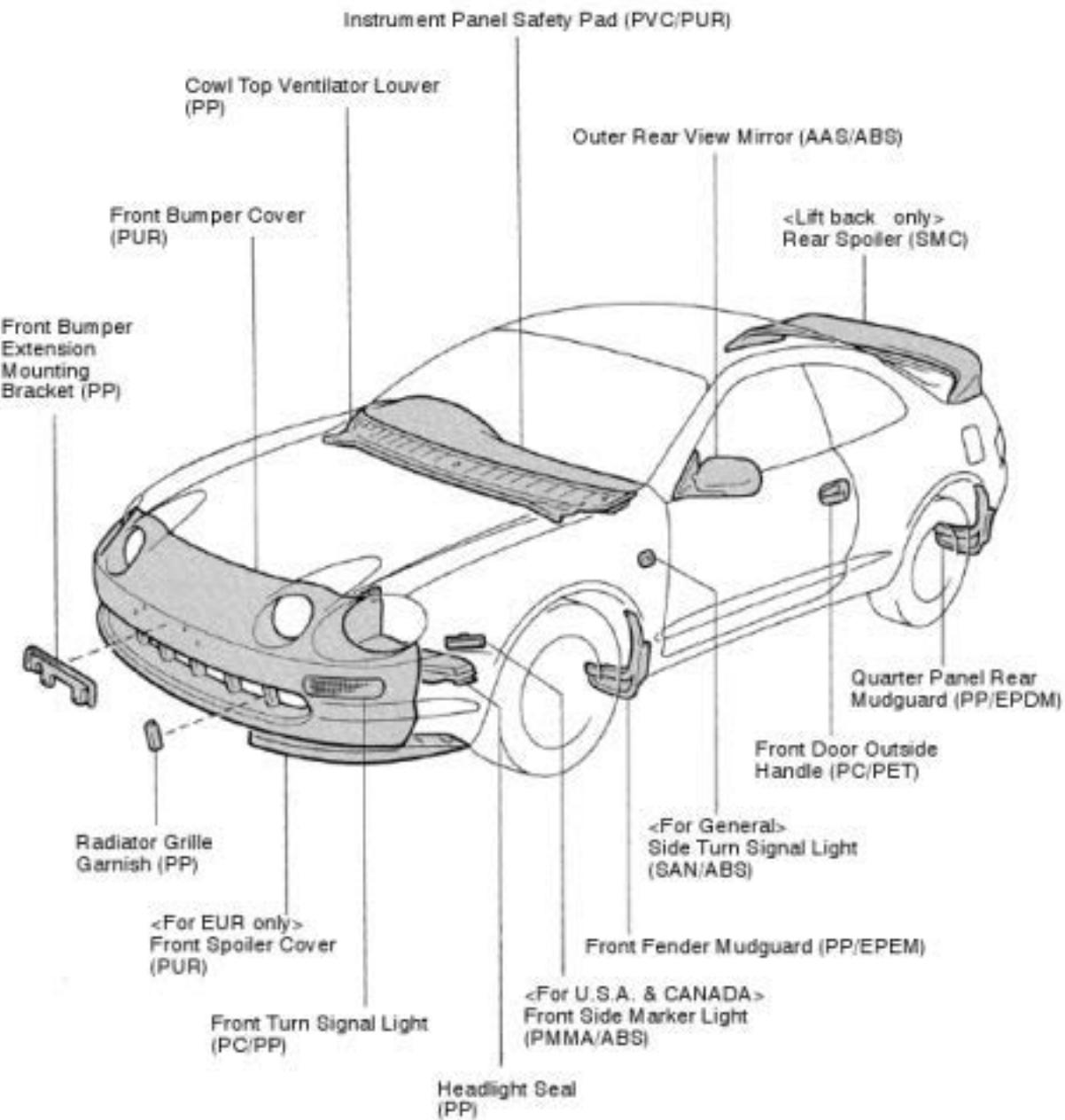
D : REMOVAL GUIDE

Provides additional information to more efficiently help you perform the removal.



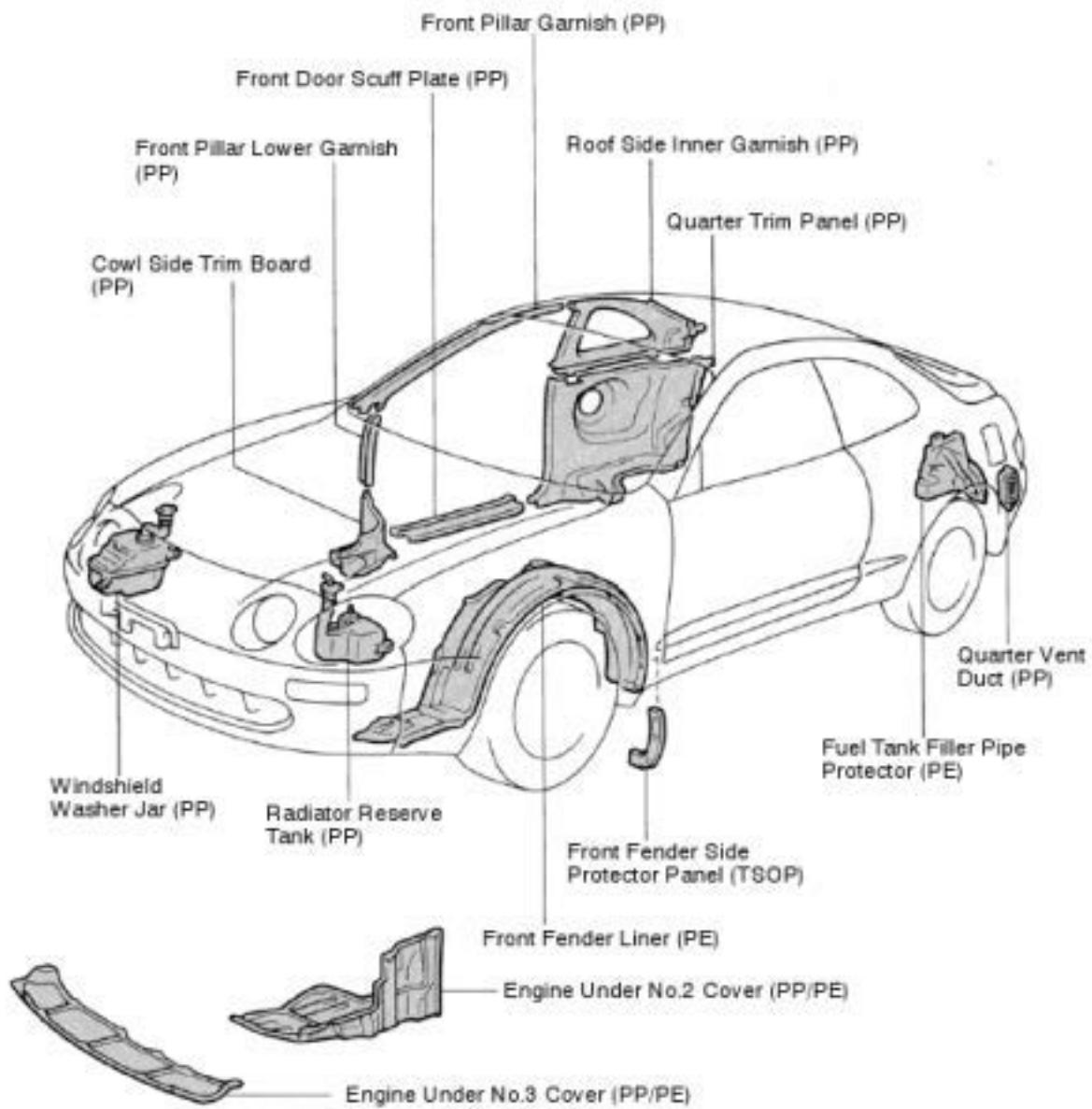
- E : INSTALLATION DIAGRAM**
Describes in detail installation of the new parts involving repair by welding and/or cutting, but excluding painting.
 - F : INSTALLATION GUIDE**
Provides additional information to more efficiently help you perform the installation.
 - G : SYMBOLS**
See page [IN-4](#).
 - H : ILLUSTRATION OF WELD POINTS**
Weld method and panel position symbols.
See page [IN-5](#).

LOCATION OF PLASTIC BODY PARTS



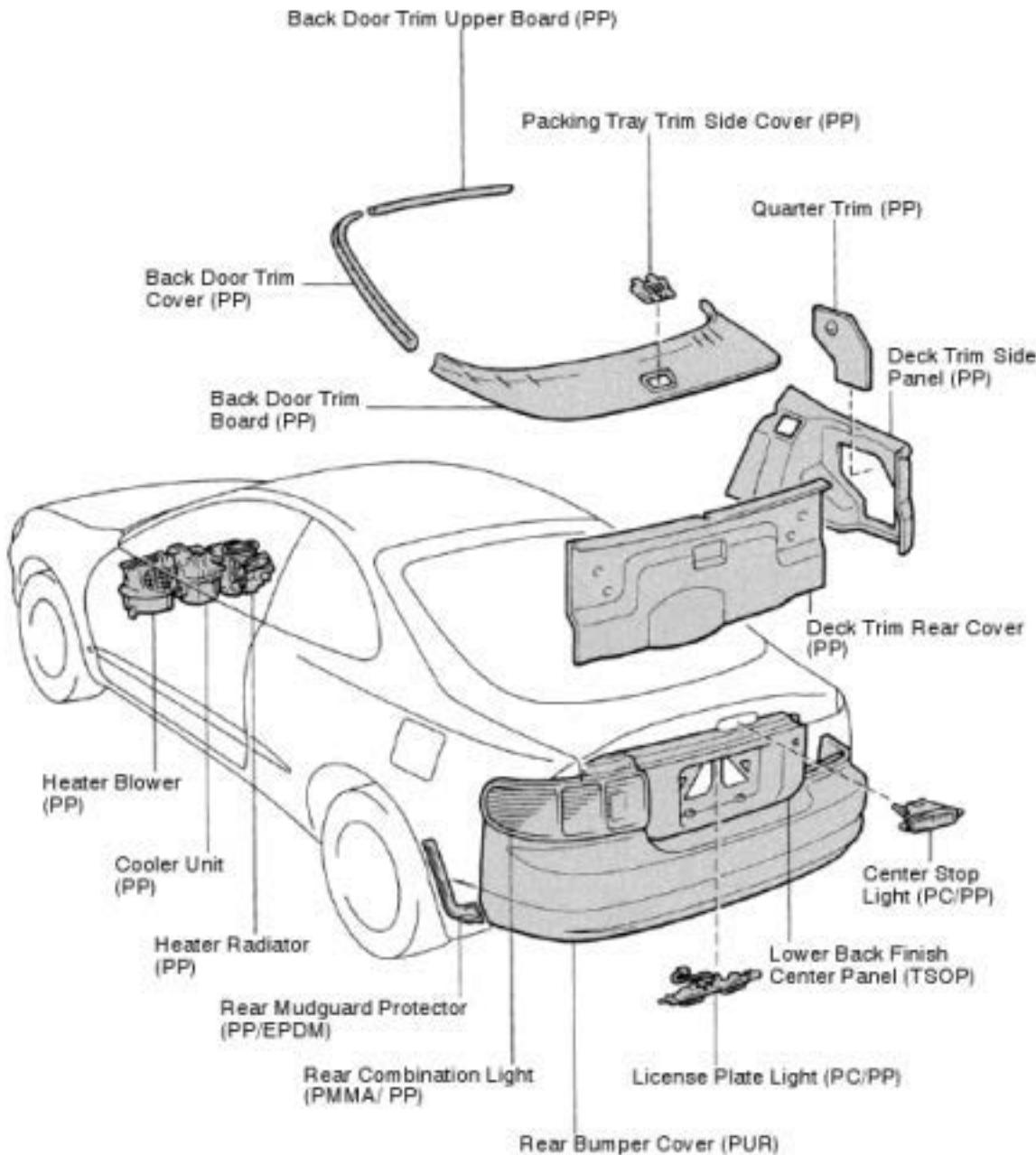
HINT:

- Resin material differs with model.
- / Made up of 2 or more kinds of materials.

**HINT:**

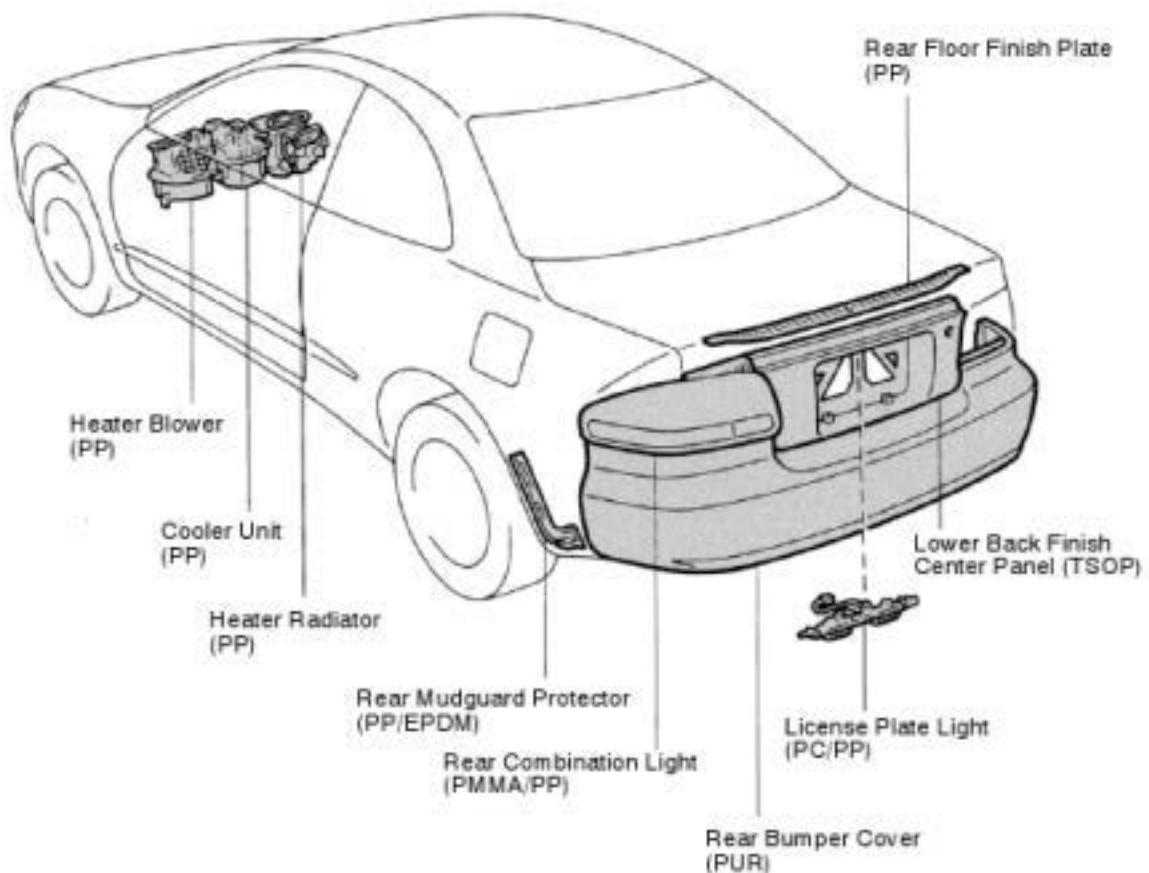
- Resin material differs with model.
- / Made up of 2 or more kinds of materials.

Liftback

**HINT:**

- Resin material differs with model.
- / Made up of 2 or more kinds of materials.

Coupe



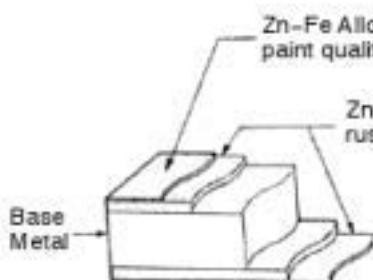
HINT:

- Resin material differs with model.
- / Made up of 2 or more kinds of materials.

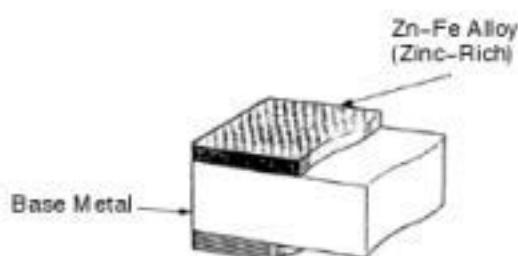
RUST-RESISTANT SHEET STEEL PARTS

Rust-Resistant Sheet Steel have zinc, tin or aluminum etc. plating over the base metal surface in order to improve the corrosion resistance of the sheet metal. For the vehicle's body panels, galvannealed sheet steel is widely used.

Body panel on TOYOTA models are made of two different galvannealed sheet steel. The ordinary galvannealed sheet steel has a zinc-iron alloy plating over the base metal surface. Zinc-iron alloy double-layer galvannealed sheet steel has zinc-iron alloy plating on both the outside and the back surface, plus a further iron-rich zinc-iron alloy plating which has good paint adhesion. These two galvannealed sheet steels are used selectively according to need.



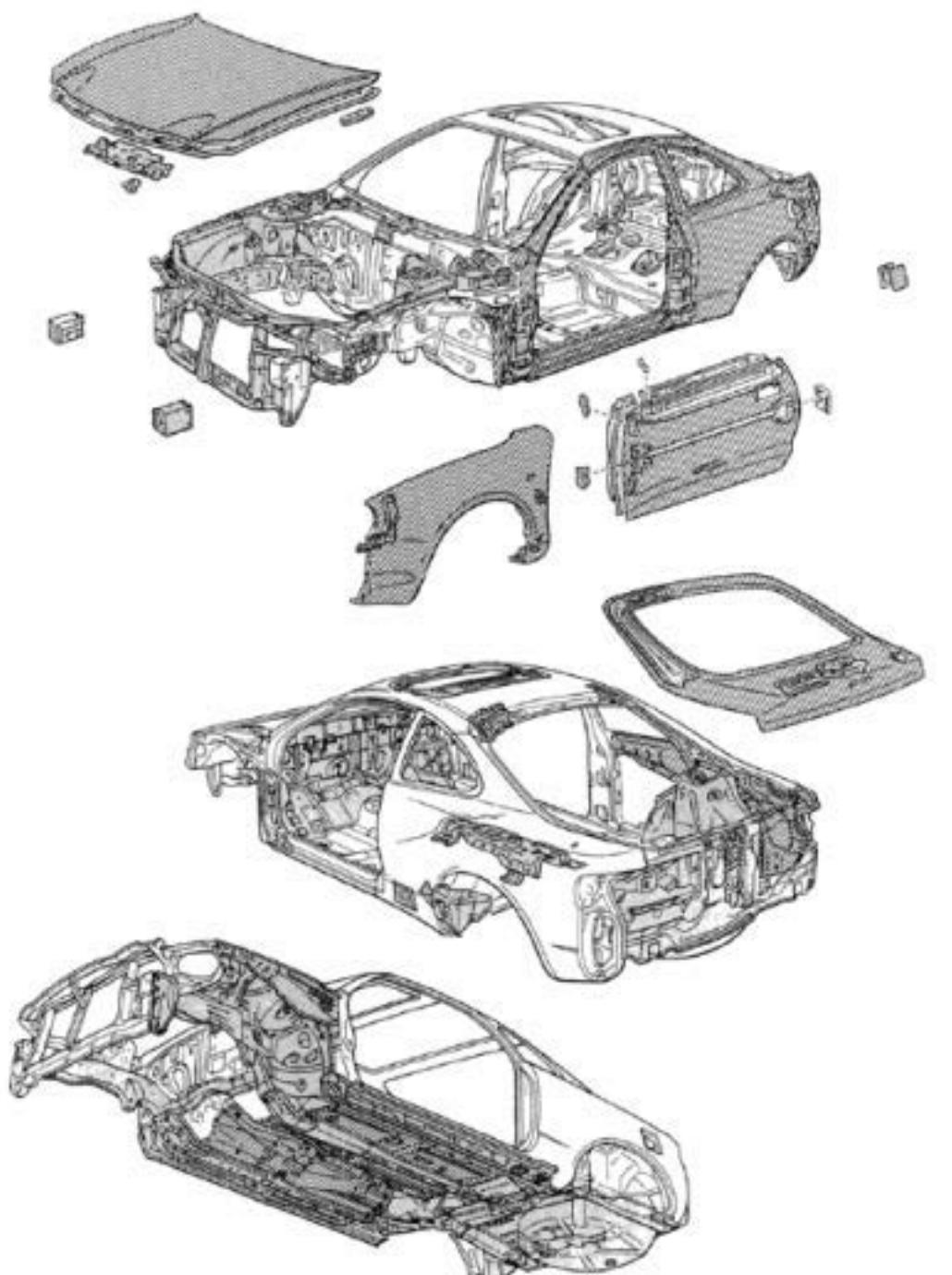
Excelite II



Galvannealed Sheet Steel

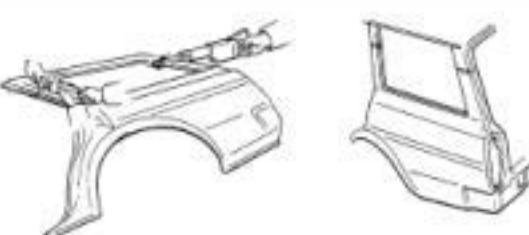
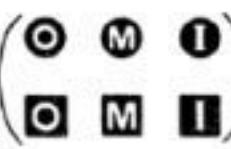
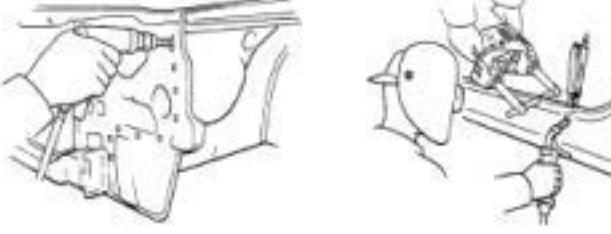
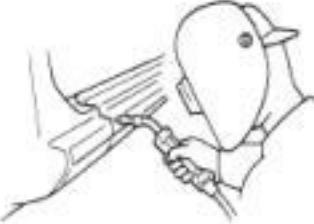
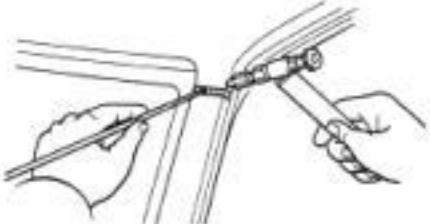
The handling of Rust-Resistant Sheet Steel is the same as for ordinary sheet steel, but the following should be observed.

1. Panel Welding: The paint as well as the zinc portion must be removed completely from the welding area to guarantee good welding integrity.
2. Anti-Rust Treatment: Since the zinc plating is lost after welding, anti-rust treatment of the welded area must be thoroughly performed (refer to section AR).



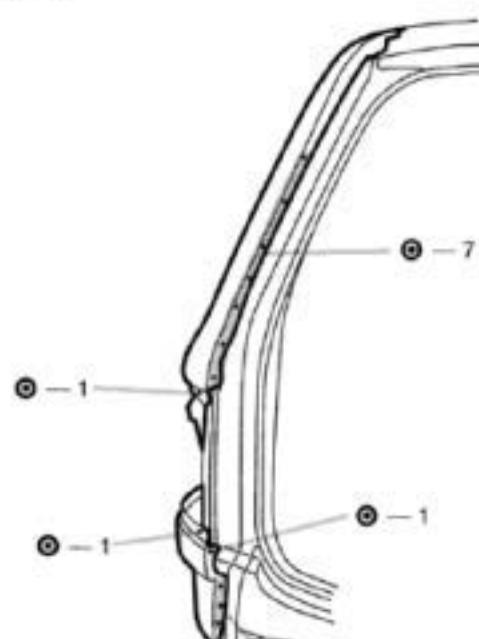
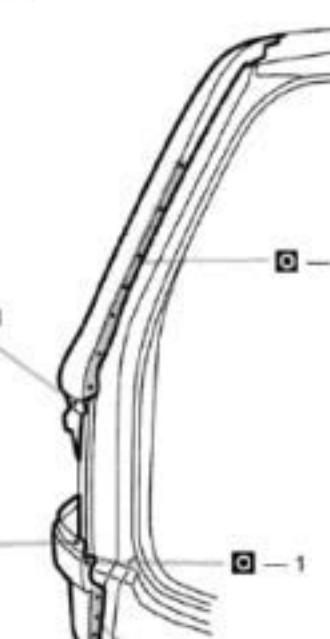
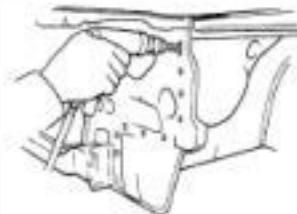
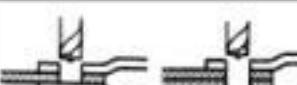
SYMBOLS

The following symbols are used in the Welding Diagrams in Section RE of this manual to indicate cutting areas and the types of weld required.

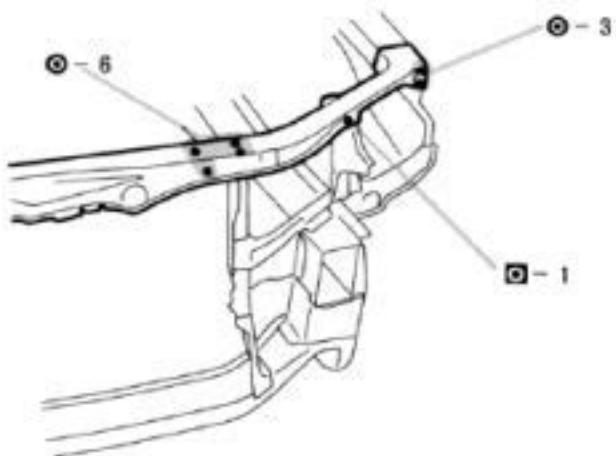
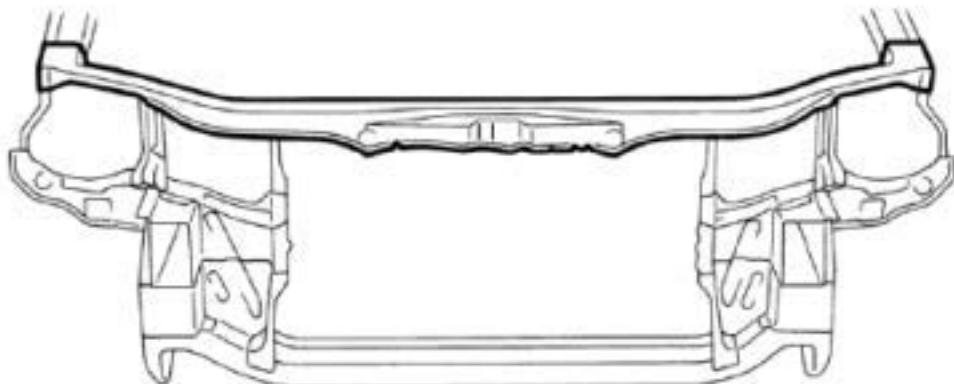
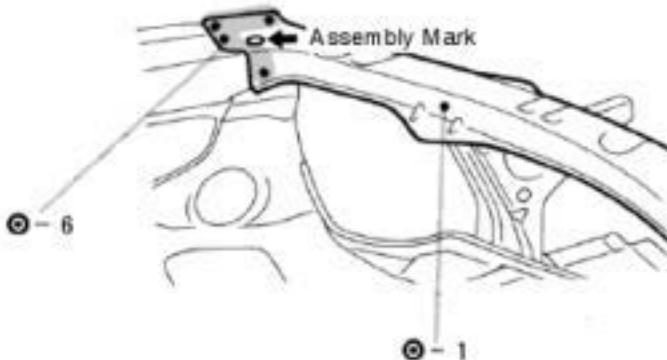
SYMBOLS	MEANING	ILLUSTRATION
— — — — —	SAW CUT OR ROUGH CUT	
	REMOVE BRAZE	
 	WELD POINTS SPOT WELD OR MIG PLUG WELD <small>(See page IN-5)</small>	
~~~~~	CONTINUOUS MIG WELD (BUTT WELD OR TACK WELD)	
○○○○○○○	BRAZE	
██████████	BODY SEALER	

## Illustration of Weld Point Symbols

### EXAMPLE:

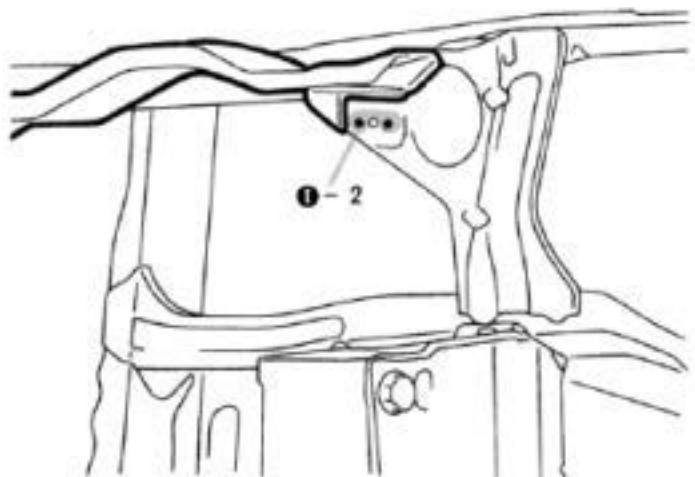
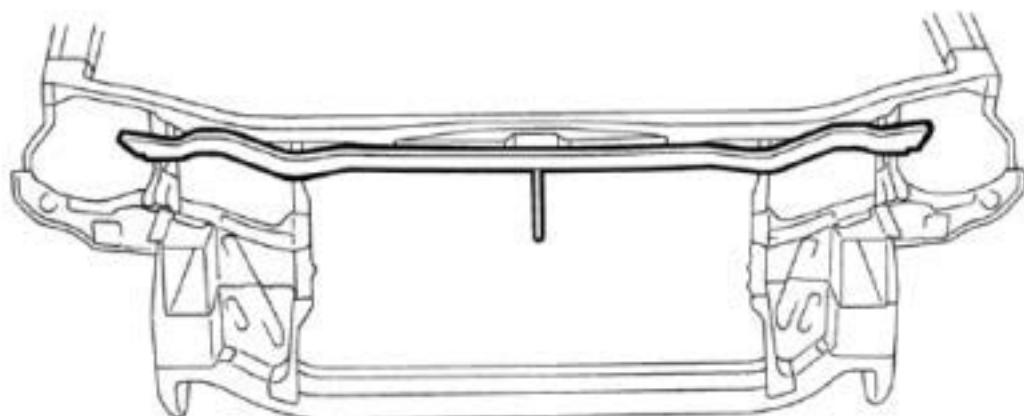
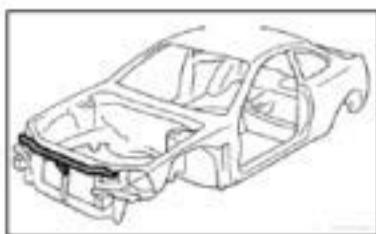
REMOVAL		INSTALLATION	
			
Remove weld point and panel position		Weld method and panel position	
SYMBOL	MEANING	ILLUSTRATION	SYMBOL
○	Remove Weld Points		○
M			M
I			I
○	(Outside)		○
M			M
I			I
○	(Middle)		○
M			M
I			I
○	(Inside)		+
HINT: Panel position symbols are as seen from the working posture.		Spot MIG Weld	

## INSTALLATION



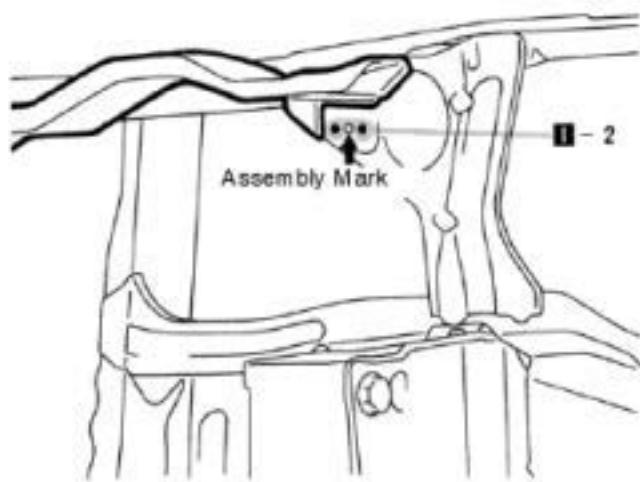
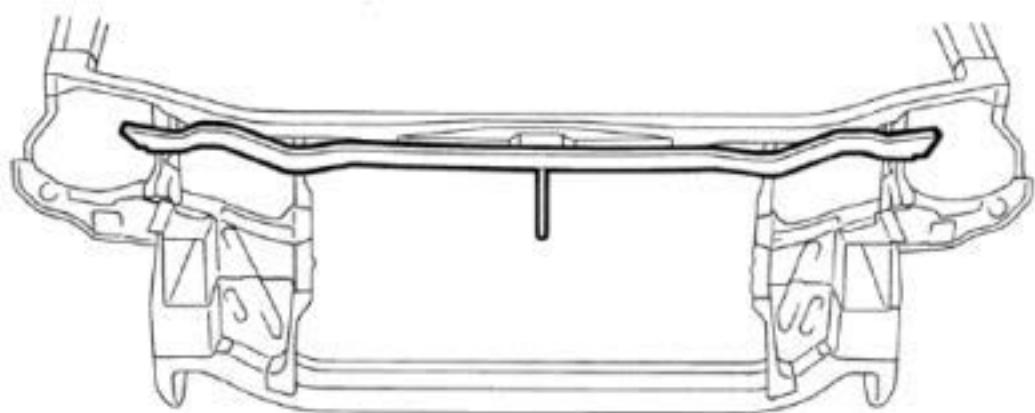
1. When temporarily installing the new parts, determine the installation position by the assembly mark. Then, measure each part in accordance with the body dimension diagram.

*HINT: First install the hood lock support.*

**RADIATOR UPPER FRONT SUPPORT (ASSY)****REMOVAL**

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## INSTALLATION



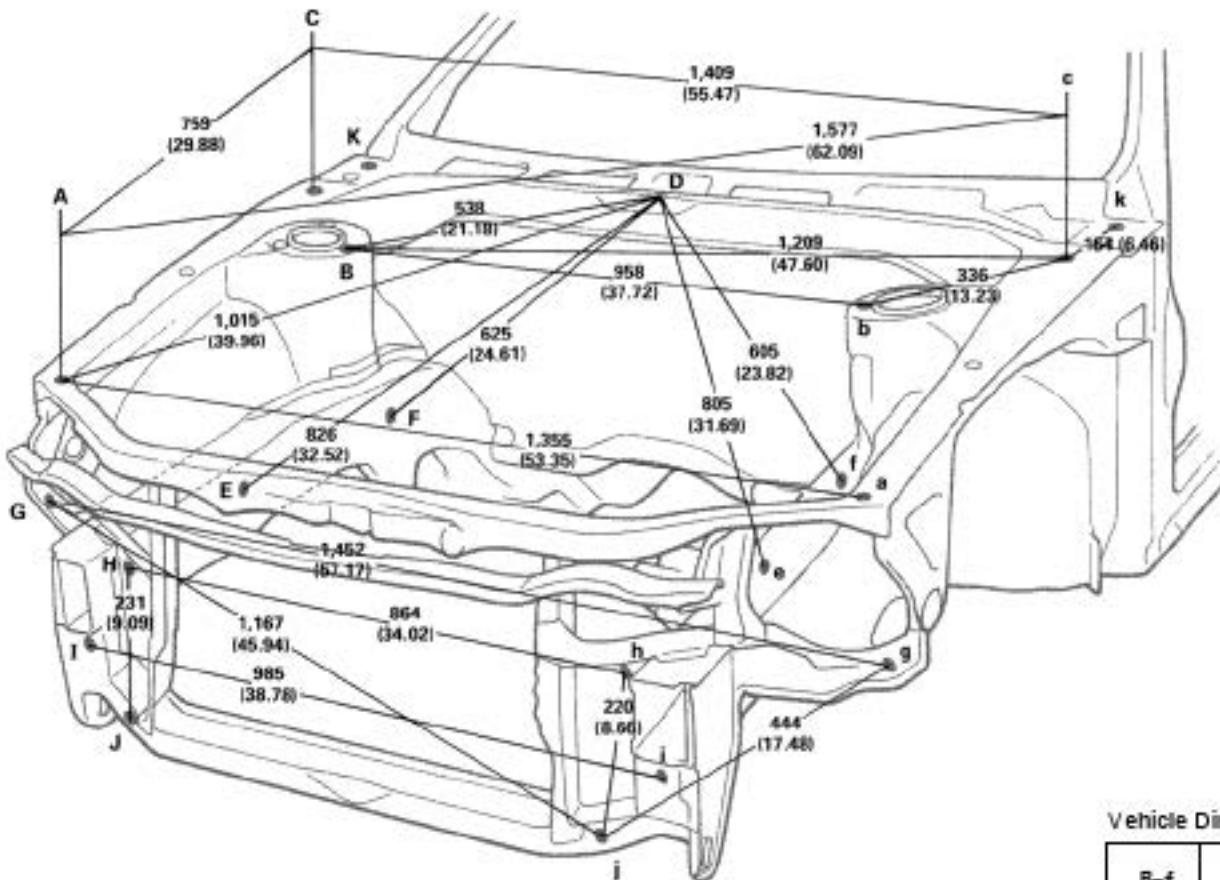
1. When temporarily installing the new parts, determine the installation position by the assembly mark.

*HINT: First install the hood lock support.*

# BODY DIMENSION DRAWINGS

## ENGINE COMPARTMENT

(Three-Dimensional Distance)



Vehicle Dimensions Left ↔ Right

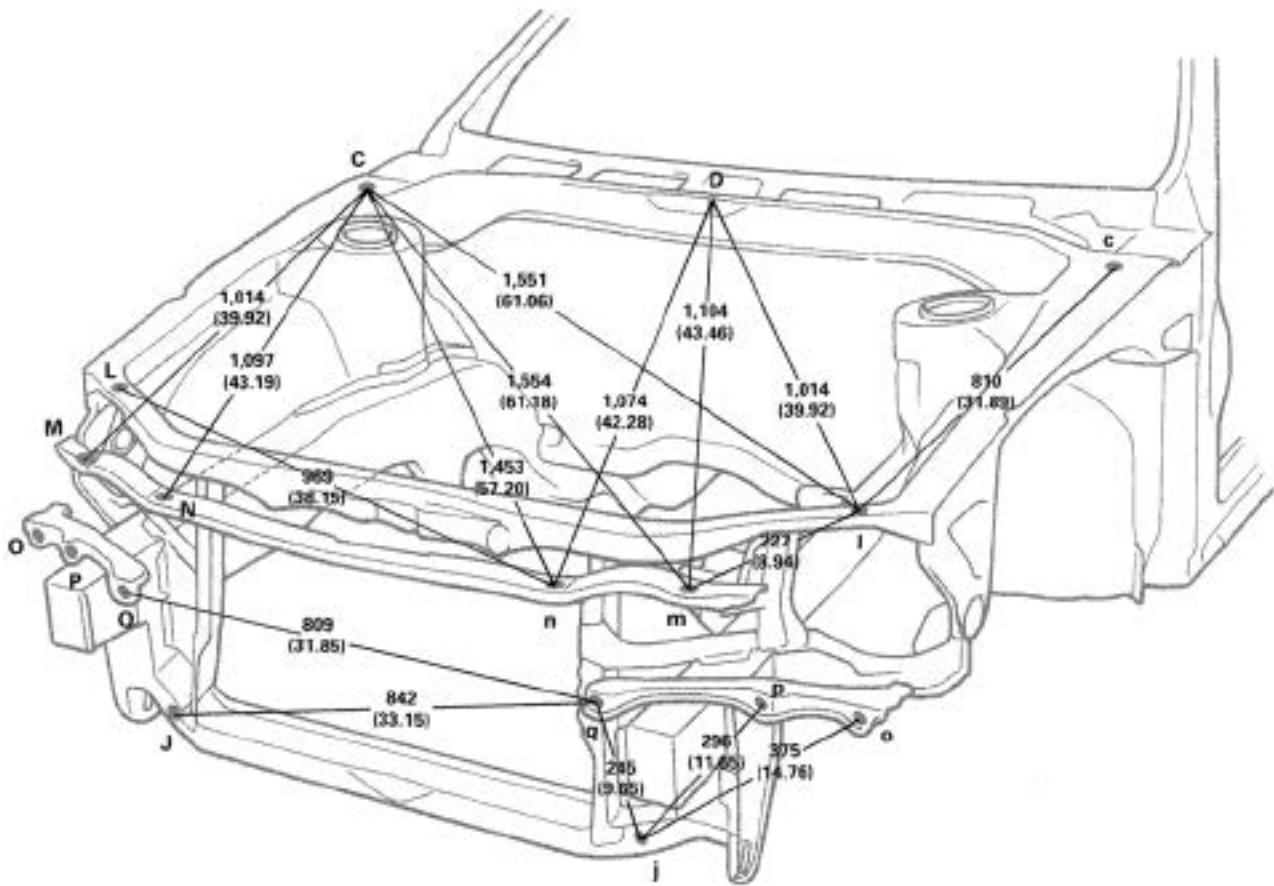
B-f	b-F	H-j	h-J
957 (37.88)	989 (38.15)	875 (34.45)	849 (33.43)

mm (in.)

Symbol	Name	Hole dia.	Symbol	Name	Hole dia.
A, a	Front fender installation nut	6 (0.24) nut	f	Front side member working hole	18 (0.71)
B, b	Front spring support hole - inner	11 (0.43)	G, g	Front fender installation nut	6 (0.24) nut
C, c	Front fender installation nut	6 (0.24) nut	H, h	Radiator support standard hole	10 (0.39)
D	Cowl top panel center mark	—	I, i	Front side member gusset standard hole	10 (0.39)
E	Front side member standard hole	18 (0.71)	J, j	Sub-radiator installation nut	6 (0.24) nut
e	Battery clamp bolt installation hole	10 (0.39)	K, k	Hood hinge installation nut - rear	8 (0.31) nut
F	Front side member standard hole	18 (0.71)	—	—	—

## ENGINE COMPARTMENT (Cont'd)

(Three-Dimensional Distance)

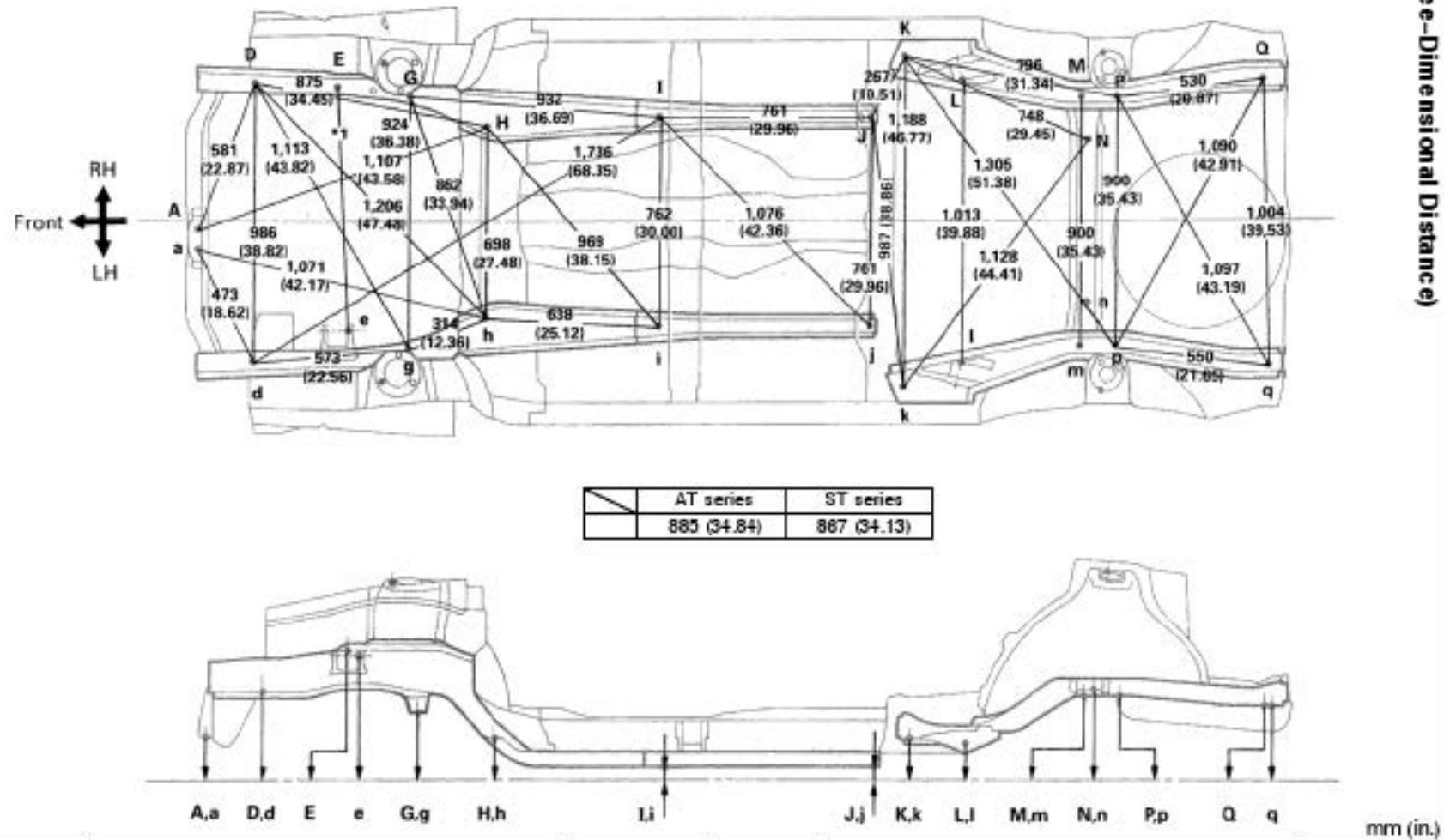


HINT: For symbols, capital letters indicate right side of vehicle,  
small letters indicate left side of vehicle (Seen from rear.)

Symbol	Name	Hole dia.	Symbol	Name	Hole dia.
C, o	Front fender installation nut	6 (0.24) nut	N, n	Headlight installation nut	6 (0.24) nut
D	Cowl top panel center mark	—	O, o	Headlight installation nut	6 (0.24) nut
J, j	Sub-radiator installation nut	6 (0.24) nut	P, p	Headlight installation nut	6 (0.24) nut
L, I	Headlight installation nut	6 (0.24) nut	Q, q	Headlight installation nut	6 (0.24) nut
M, m	Headlight installation nut	6 (0.24) nut	—	—	—

UNDER BODY

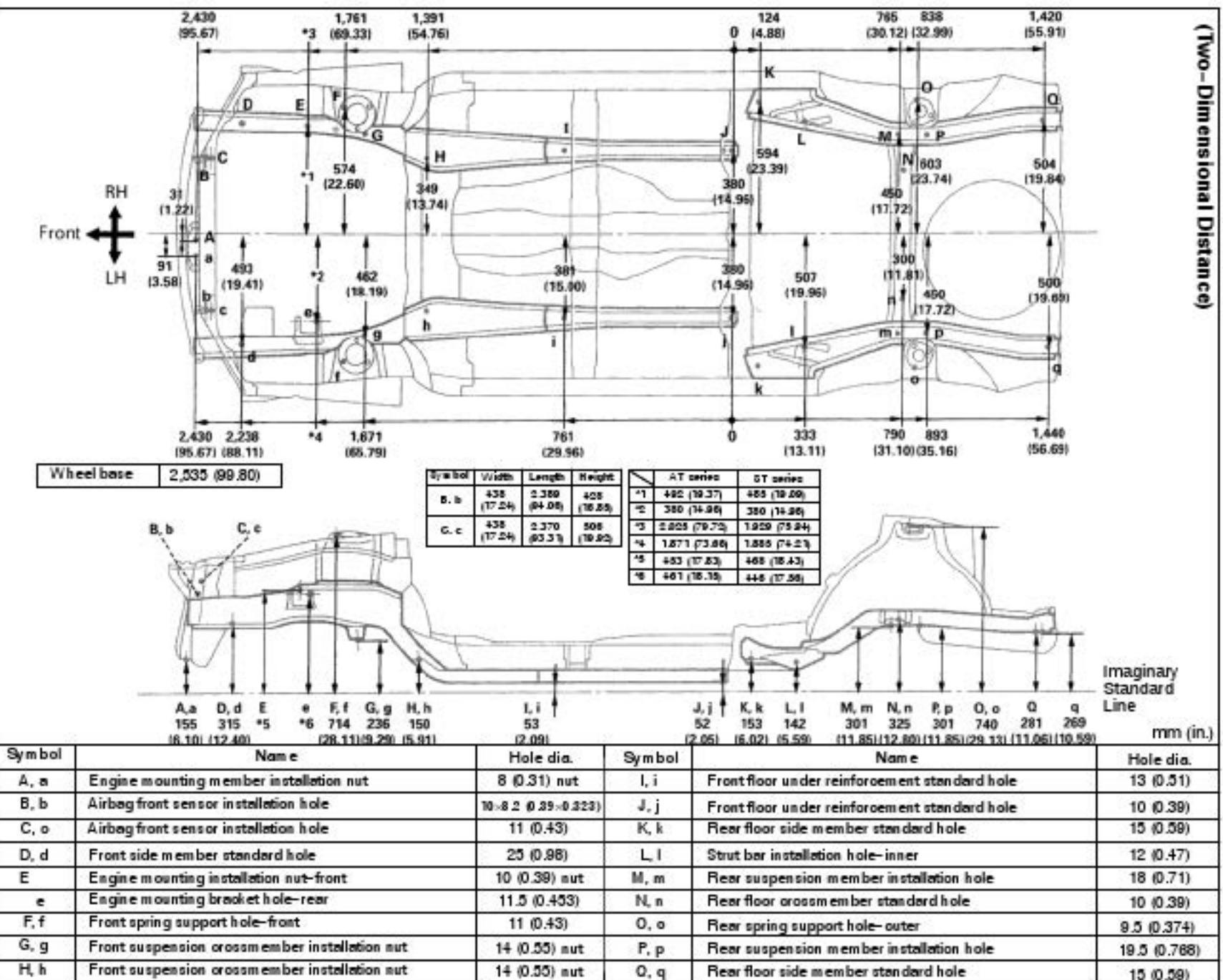
(Three-Dimensional Distance)



Symbol	Name	Hole dia.	Symbol	Name	Hole dia.
A, a	Engine mounting member installation nut	8 (0.31) nut	J, j	Front floor under reinforcement standard hole	10 (0.39)
D, d	Front side member standard hole	25 (0.98)	K, k	Rear floor side member standard hole	15 (0.59)
E	Engine mounting installation nut-front	10 (0.39) nut	L, l	Strut bar installation hole-inner	12 (0.47)
e	Engine mounting bracket hole-rear	11.5 (0.453)	M, m	Rear suspension member installation hole	18 (0.71)
G, g	Front suspension crossmember installation nut	14 (0.55) nut	N, n	Rear floor crossmember standard hole	10 (0.39)
H, h	Front suspension crossmember installation nut	14 (0.55) nut	P, p	Rear suspension member installation hole	19.5 (0.768)
I, i	Front floor under reinforcement standard hole	13 (0.51)	Q, q	Rear floor side member standard hole	15 (0.59)

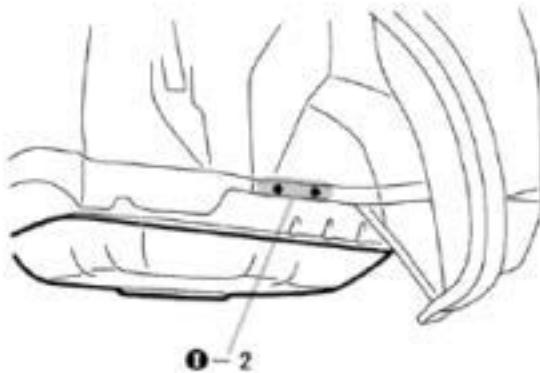
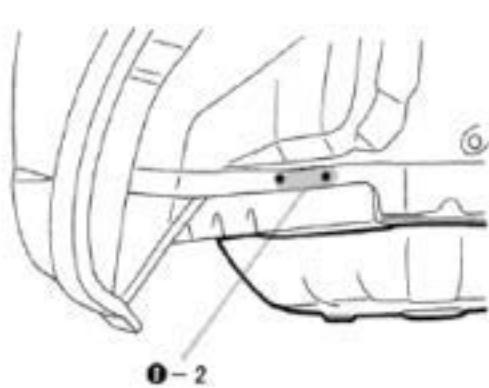
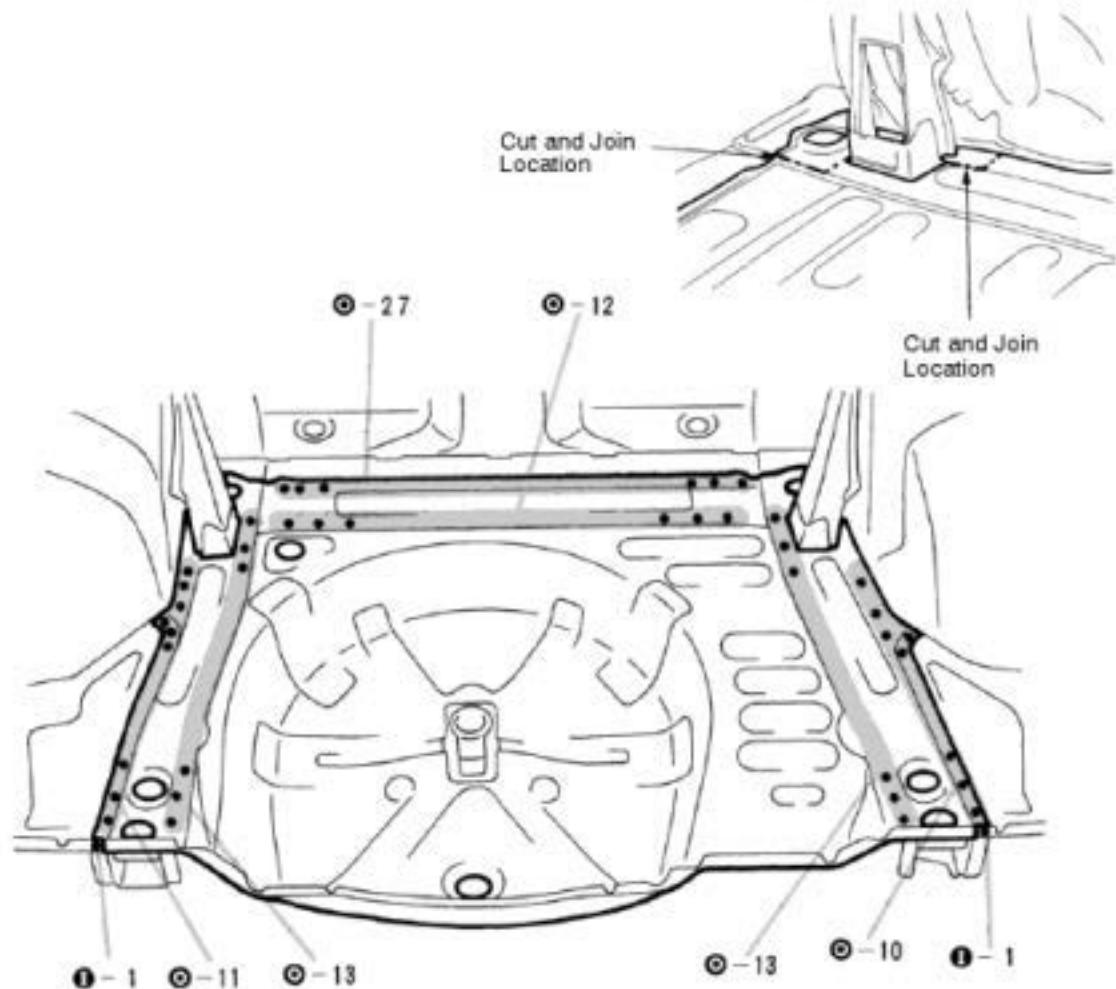
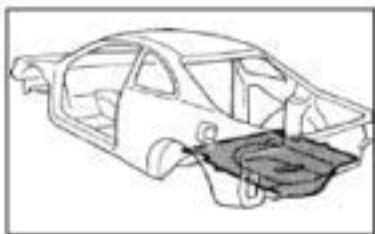
## UNDER BODY (Cont'd)

### (Two-Dimensional Distance)



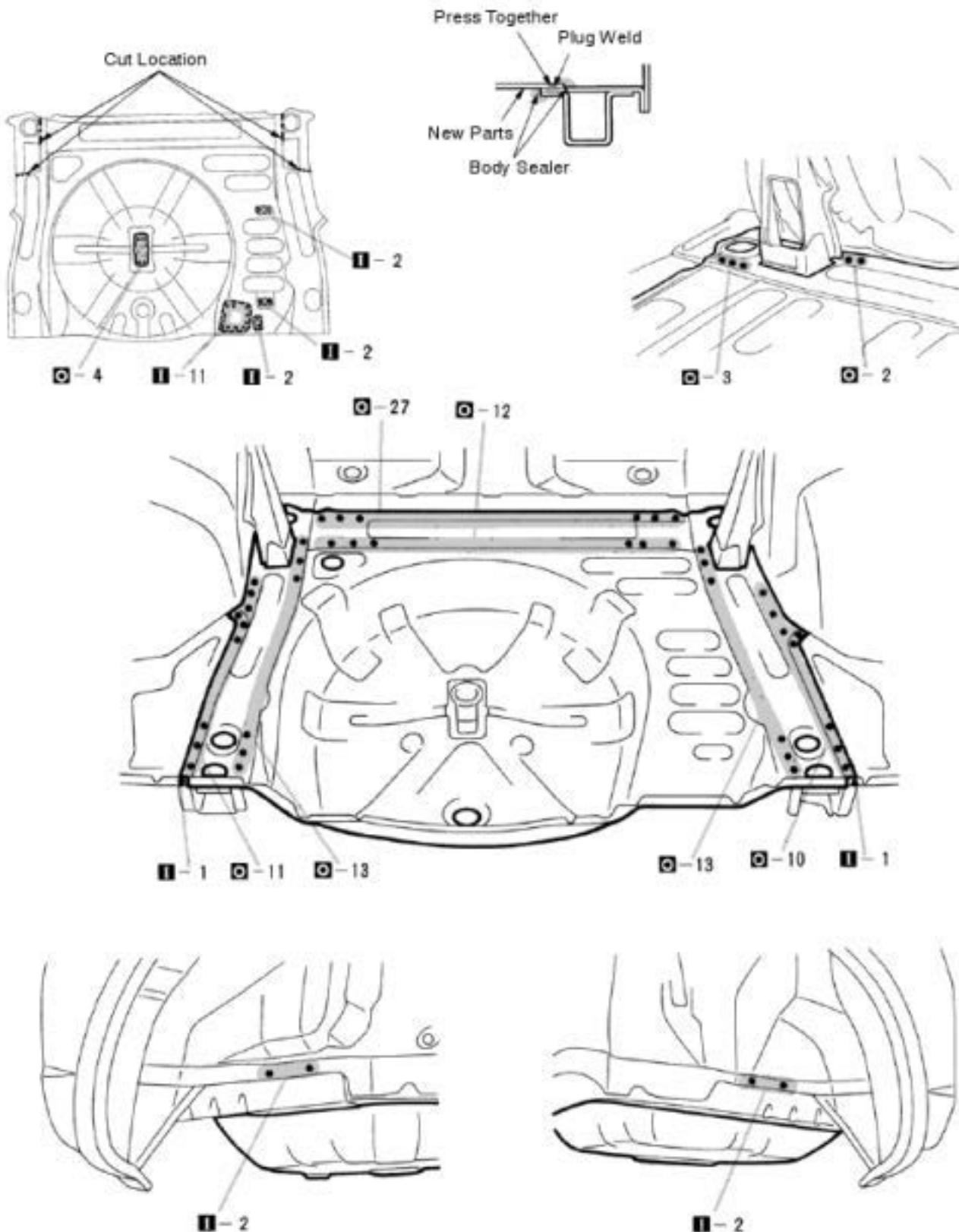
**REAR FLOOR PAN (ASSY)**

REMOVAL (With the body lower back panel removed.)



1. Cut the parts at the location shown above.
2. Avoid cutting or damaging the rear floor side member and rear floor No. 2 crossmember when rough cutting.

## INSTALLATION



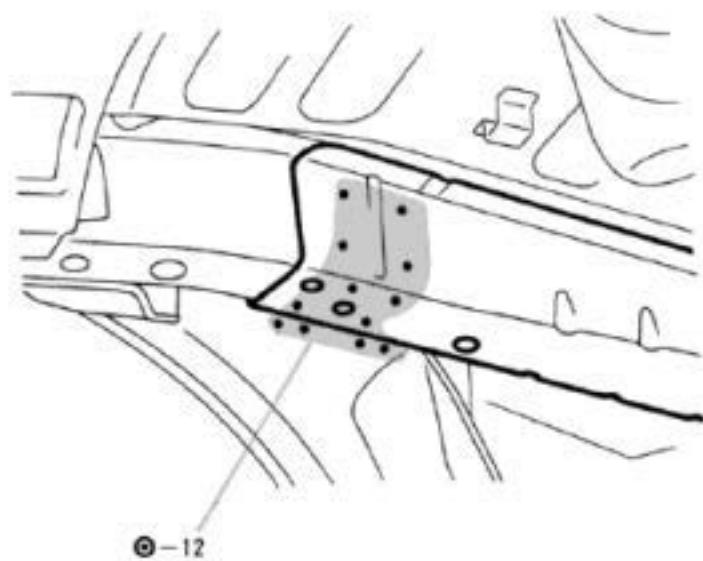
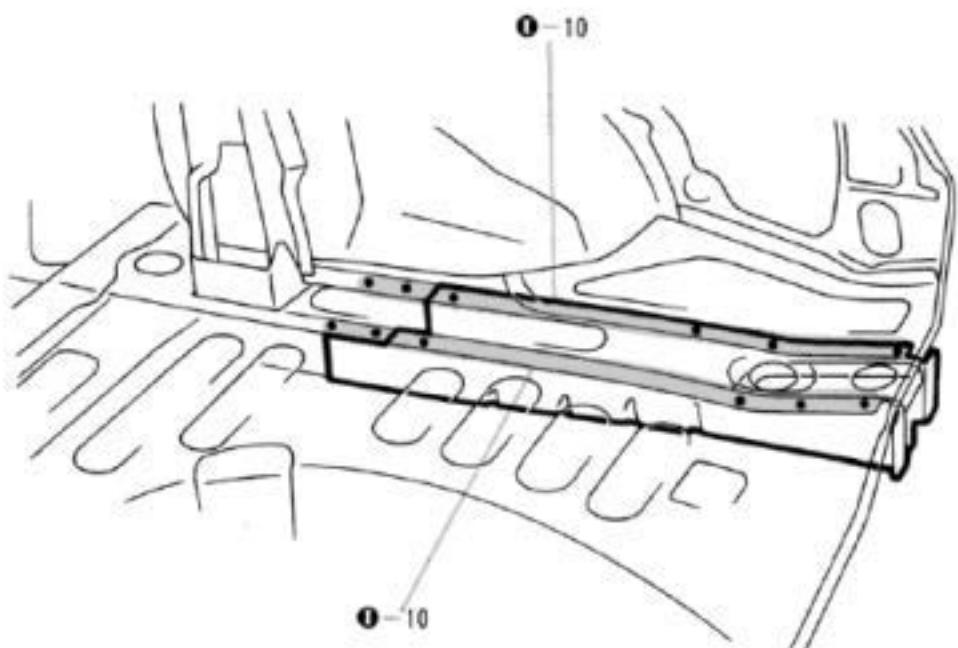
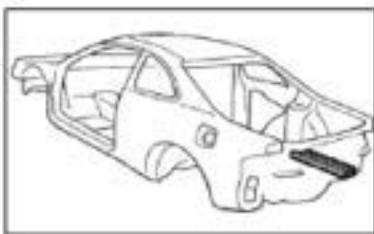
1. Cut new parts at the location shown above.

2. Plug weld the overlapping portion of the new parts.

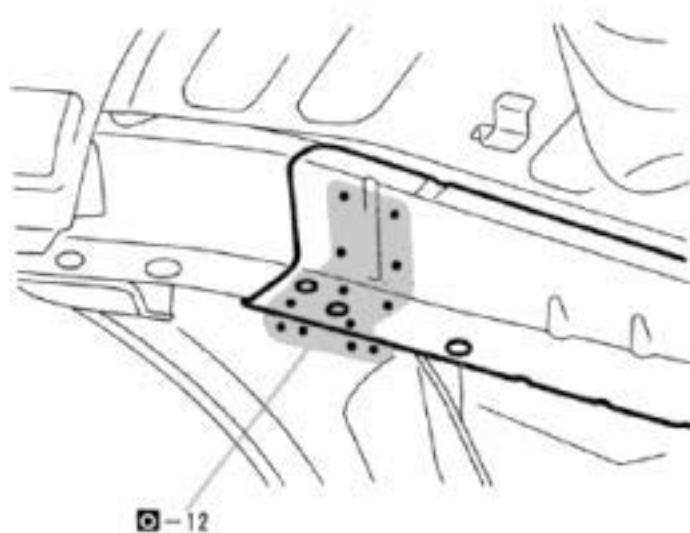
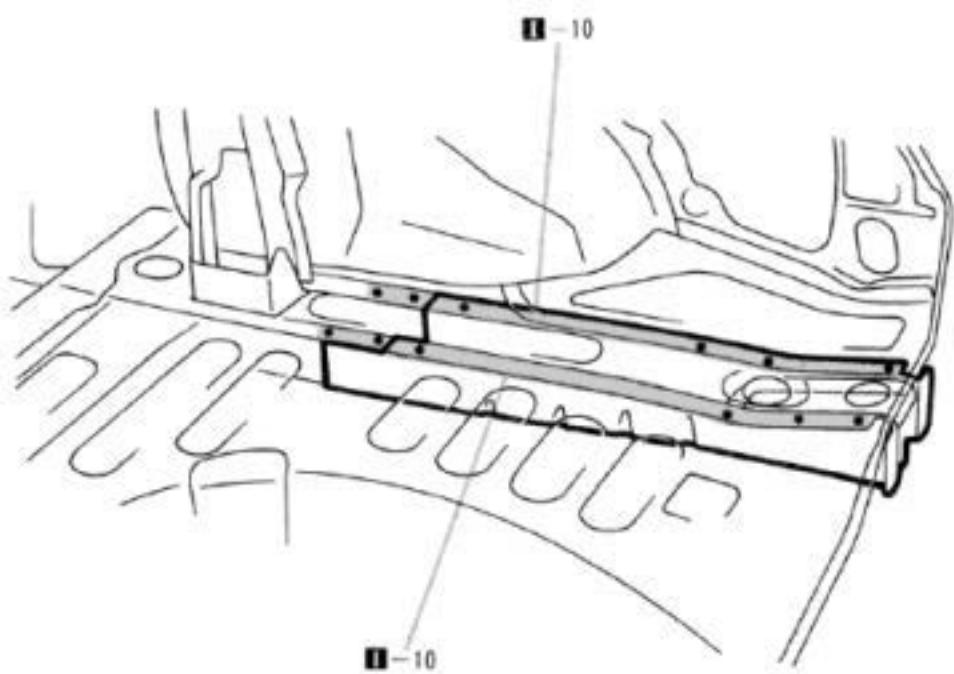
*HINT: Make sure the panels to be welded are clamped and properly aligned before welding.*

**REAR FLOOR SIDE REAR MEMBER (ASSY)**

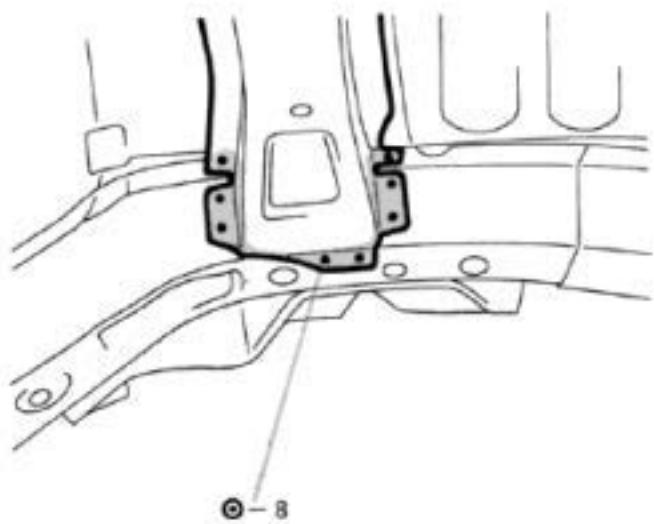
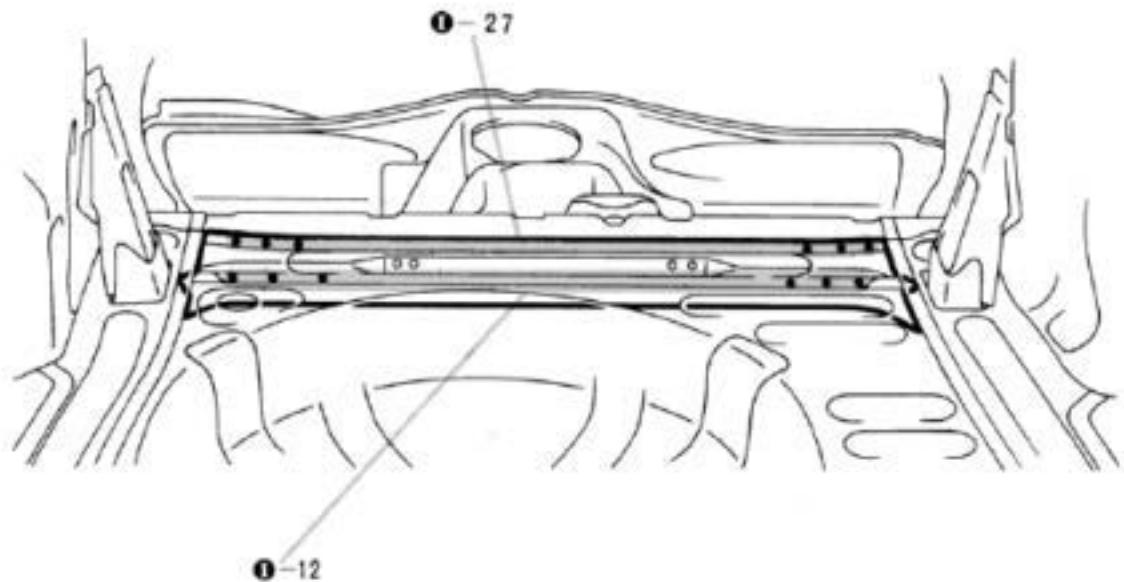
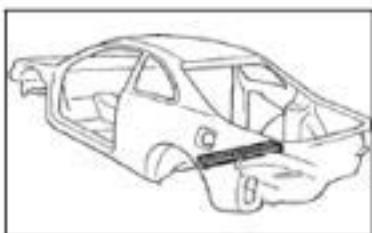
REMOVAL (With the body lower back panel removed.)

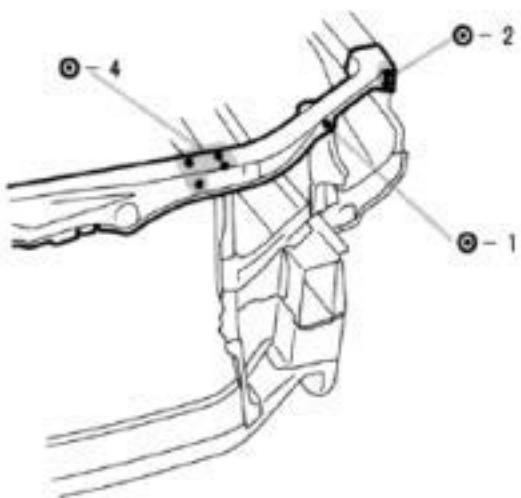
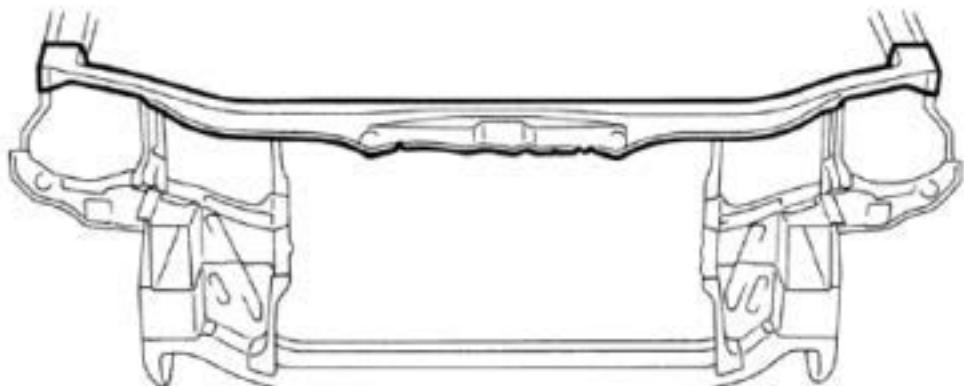
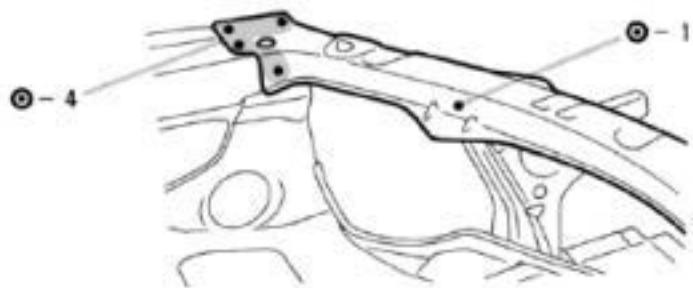
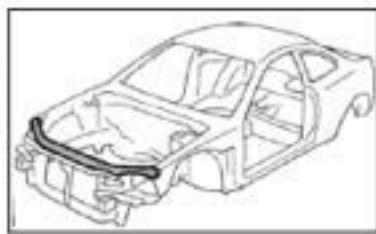


## INSTALLATION

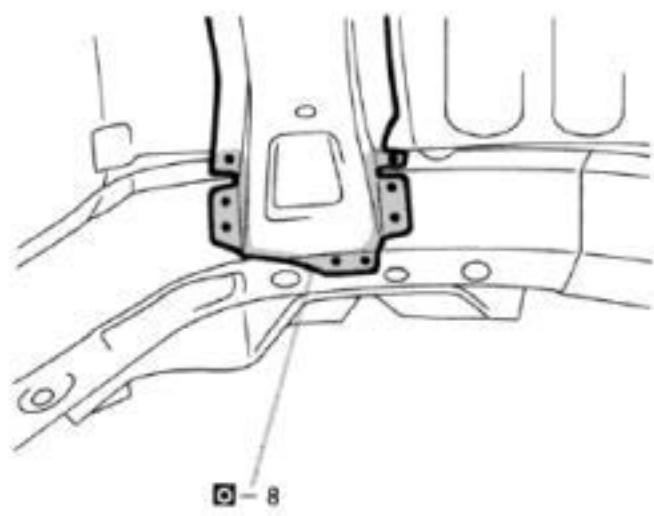
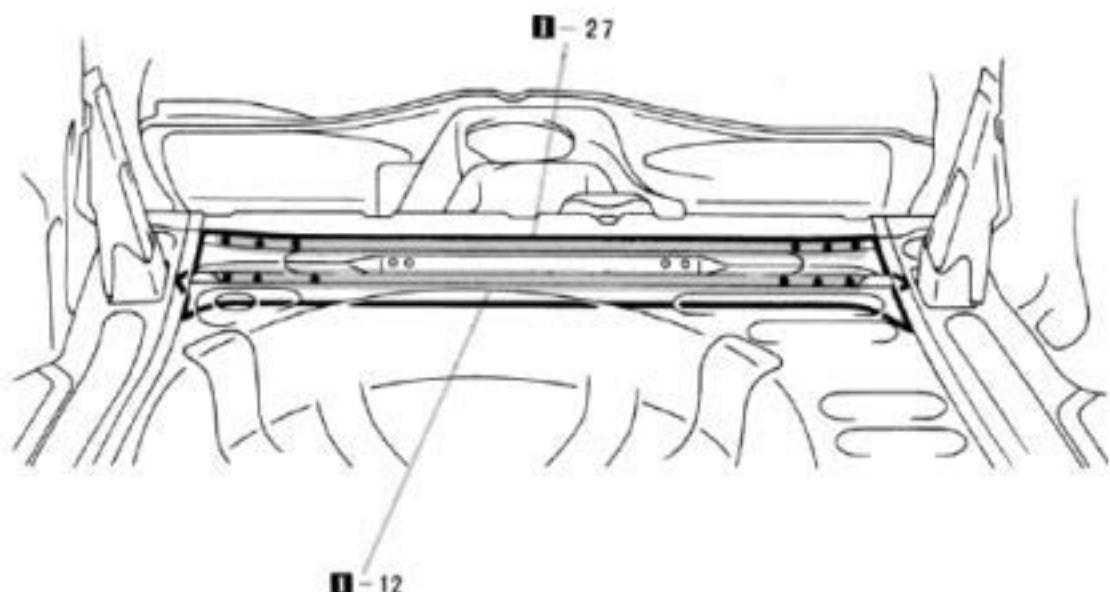


- 
1. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.

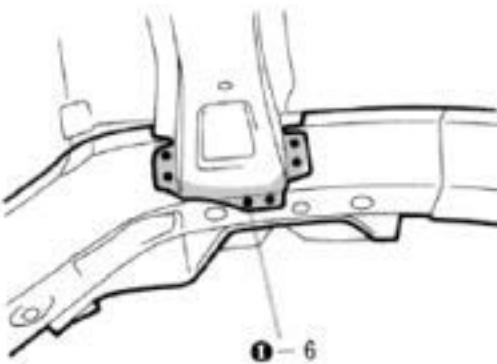
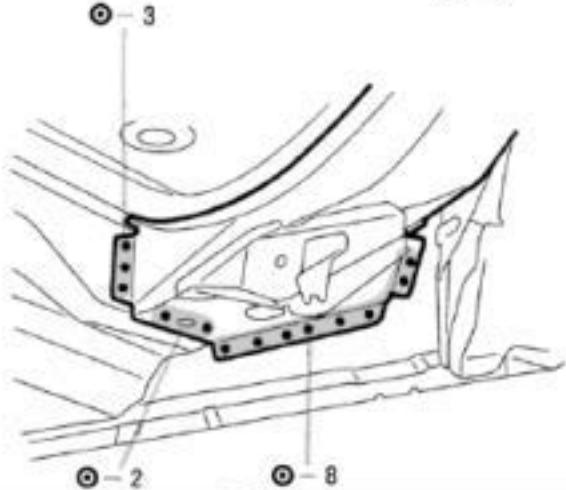
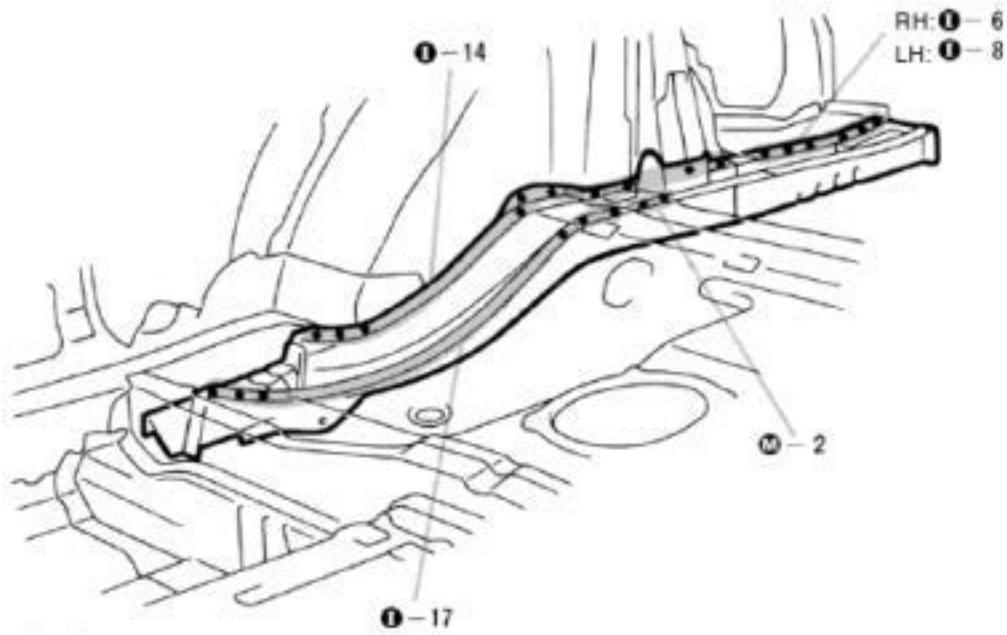
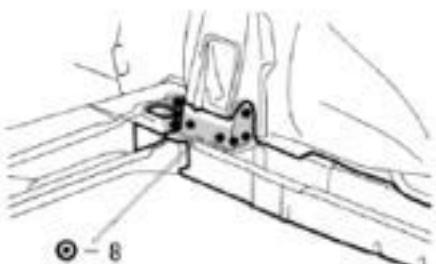
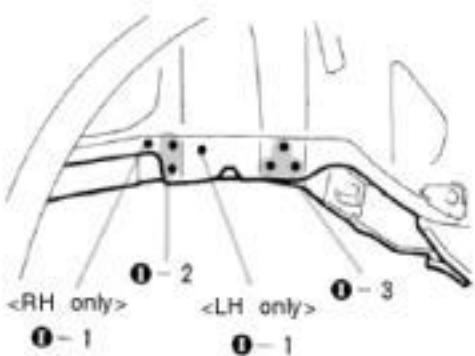
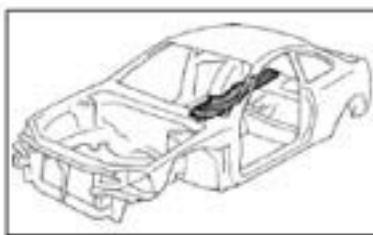
**REAR FLOOR NO. 2 CROSMEMBER (ASSY)****REMOVAL**

**RADIATOR UPPER SUPPORT (ASSY)****REMOVAL (With the radiator upper front support removed.)**

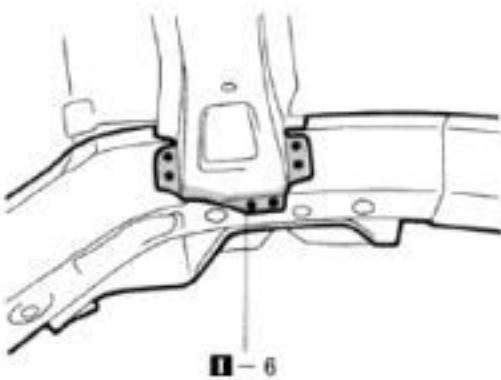
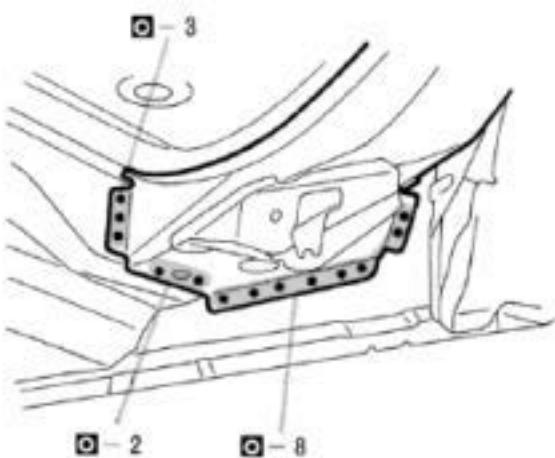
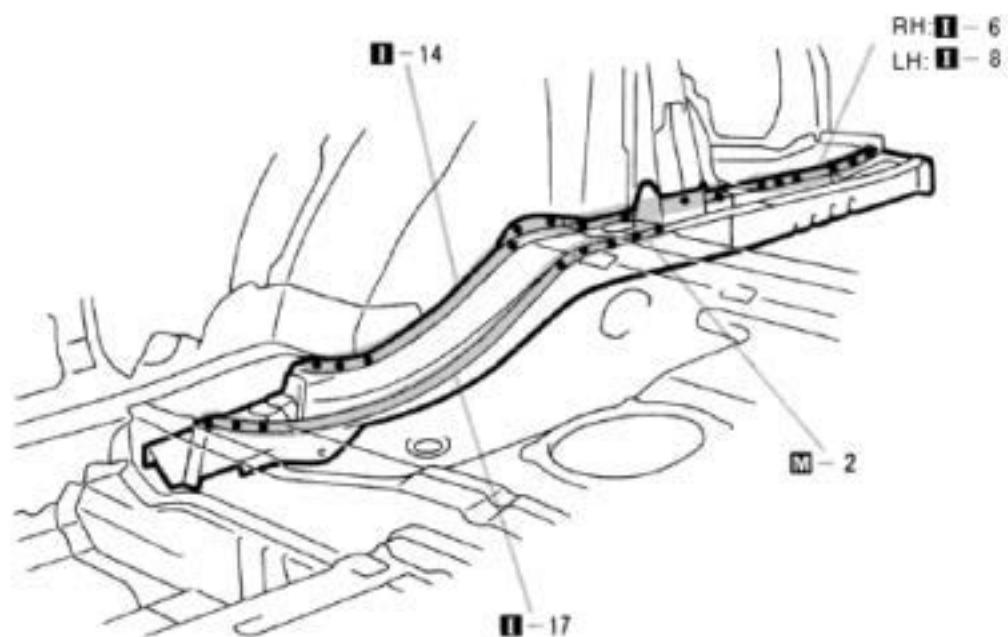
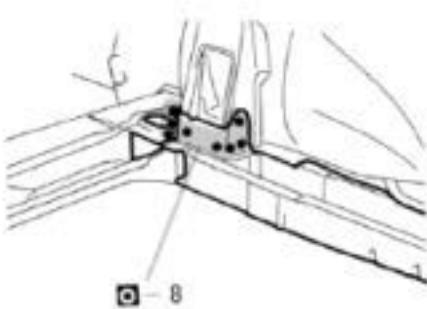
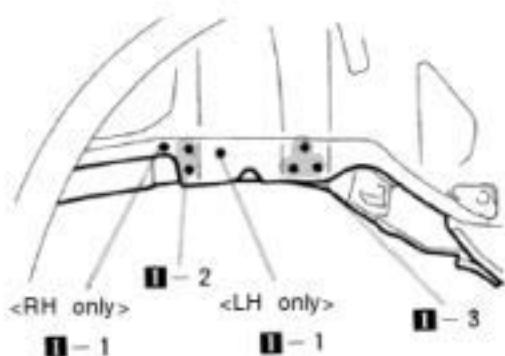
## INSTALLATION



- 
1. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.

**REAR FLOOR SIDE MEMBER (ASSY)****REMOVAL**

## INSTALLATION



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