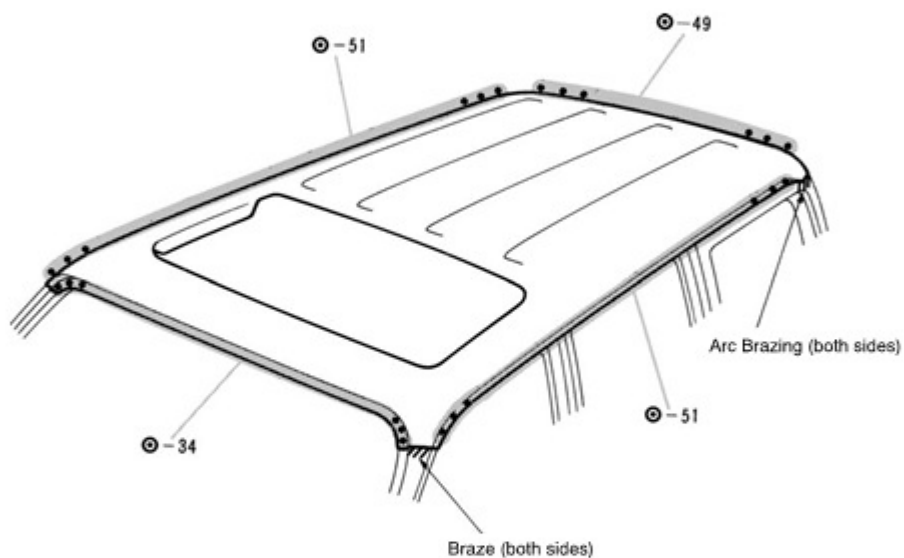
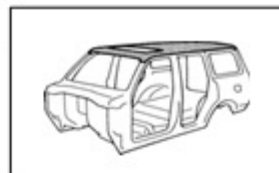


RE-36

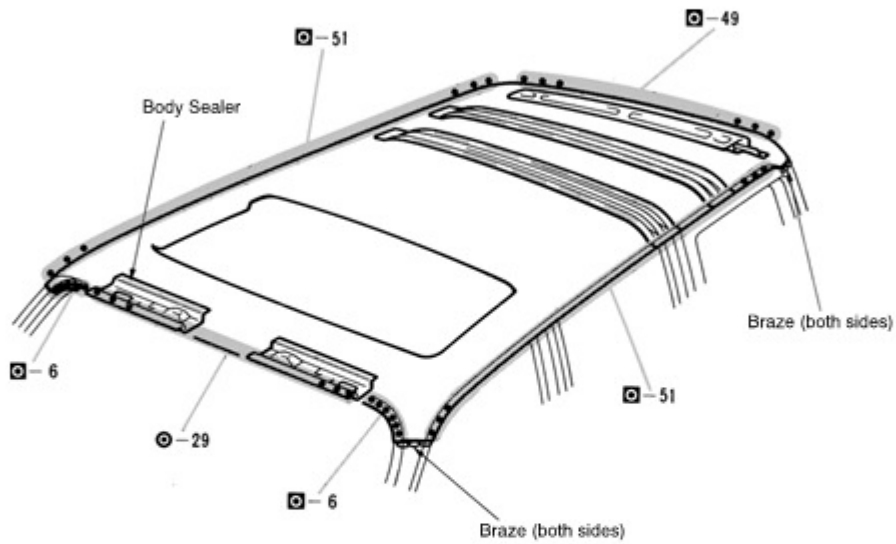
BODY PANEL REPLACEMENT

ROOF PANEL (ASSY): Moon Roof**REMOVAL**

1. Heat the brazed area of the front body pillar and scrape off the brazing with a wire brush.

HINT: Be careful not to overheat the front body pillar.

2. Grind off the roof panel tip at the quarter panel arc brazing connection with a cut grinder.

INSTALLATION

-
1. Before temporarily installing the new parts, apply body sealer to the windshield header panel, roof panel reinforcement and back door opening frame.

HINT:

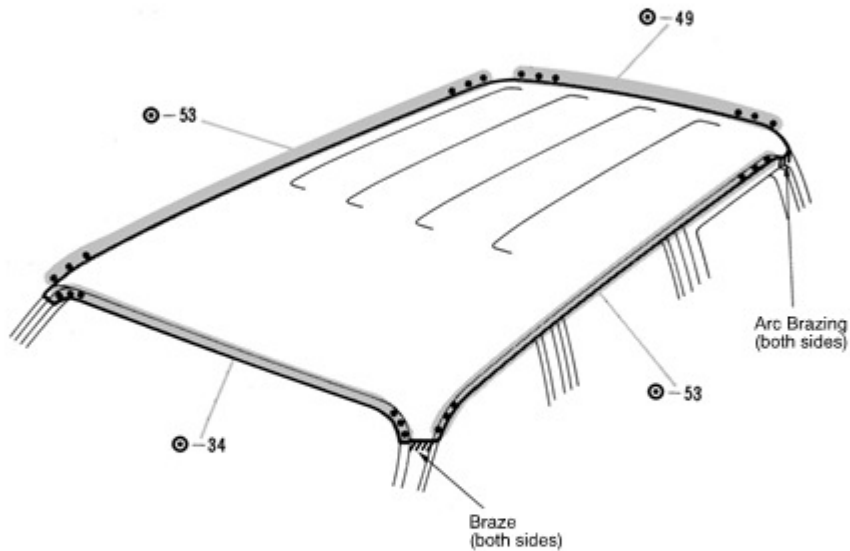
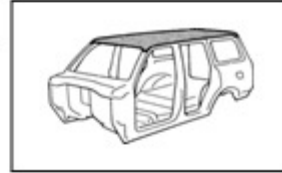
- 1) Apply just enough sealer for the new parts to make contact.
- 2) For other sealing points, refer to Section AR.

2. Braze the front body pillar and quarter panel connection.

HINT: Before performing these operations, place a wet rag on the roof panel to protect it from damage.

RE-34

BODY PANEL REPLACEMENT

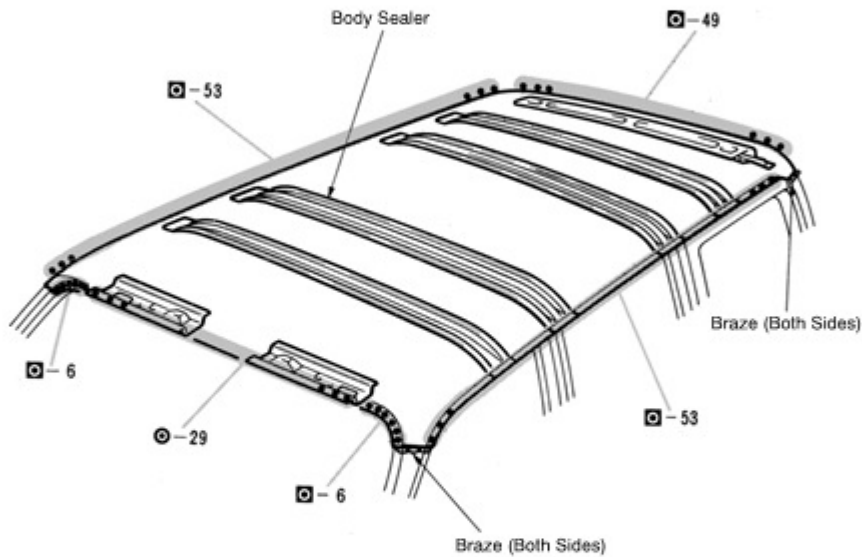
ROOF PANEL (ASSY): Normal Roof**REMOVAL**

1. Heat the brazed area of the front body pillar and scrape off the brazing with a wire brush.

HINT: Be careful not to overheat the front body pillar.

2. Grind off the roof panel tip at the quarter panel are brazing connection with a cut grinder.

INSTALLATION



-
1. Before temporarily installing the new parts, apply body sealer to the windshield header panel, roof panel reinforcement and back door opening frame.

HINT:

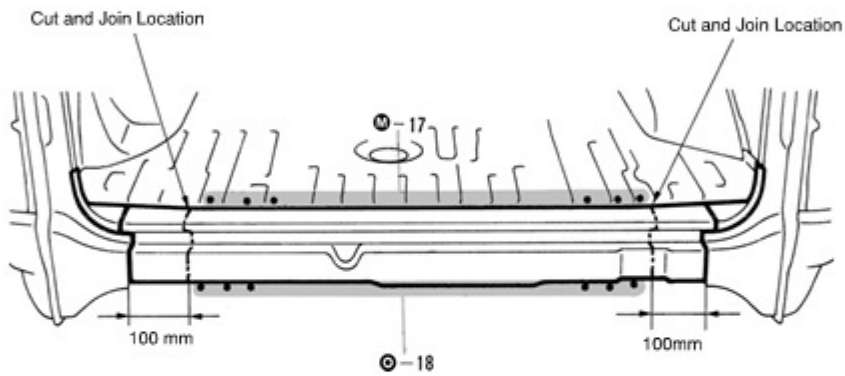
- 1) Apply just enough sealer for the new parts to make contact.
- 2) For other sealing points, refer to Section AR.

2. Braze the front body pillar and quarter panel connection.

HINT: Before performing these operations, place a wet rag on the roof panel to protect it from damage.

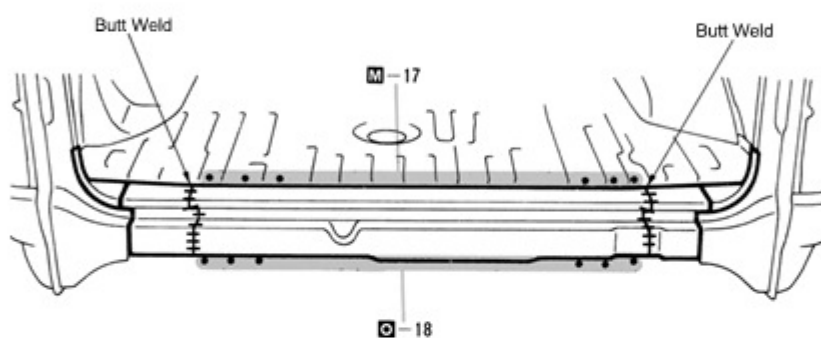
RE-24

BODY PANEL REPLACEMENT

BODY LOWER BACK PANEL (CUT)**REMOVAL**

mm	in
100	3.94

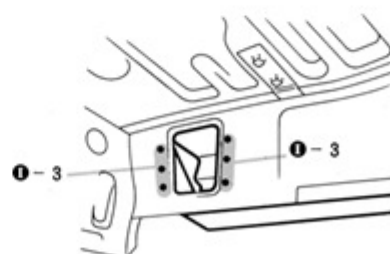
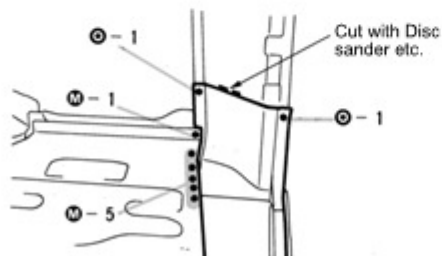
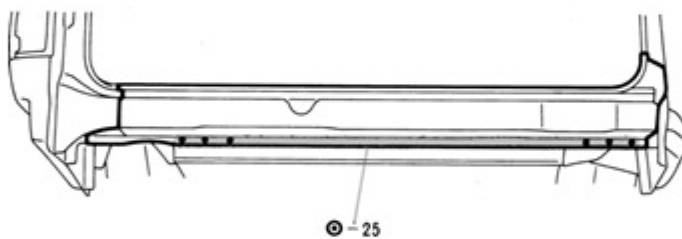
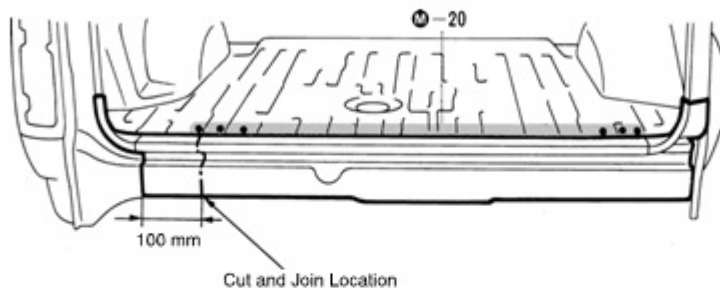
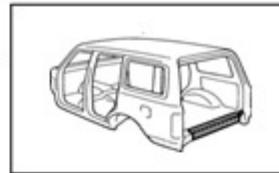
1. Cut and join the parts at the location shown above.

INSTALLATION

-
1. Temporarily installing the new parts, check the fit of the back door.

RE-26

BODY PANEL REPLACEMENT

BODY LOWER BACK PANEL (CUT)**REMOVAL (With the quarter panel extension removed.)**

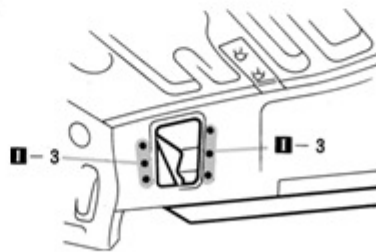
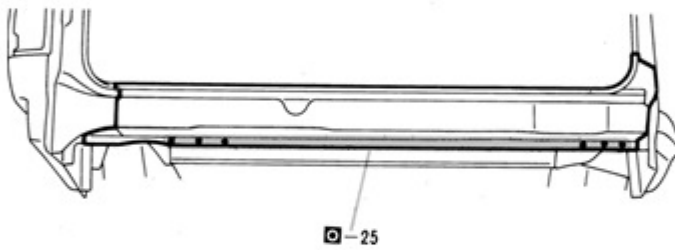
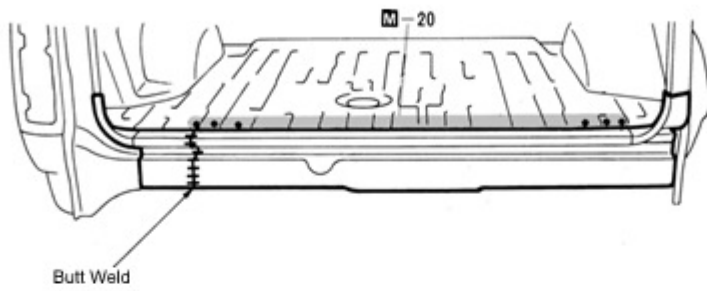
mm	in
100	3.94

1. Cut and join the parts at the location shown above.

BODY PANEL REPLACEMENT

RE-27

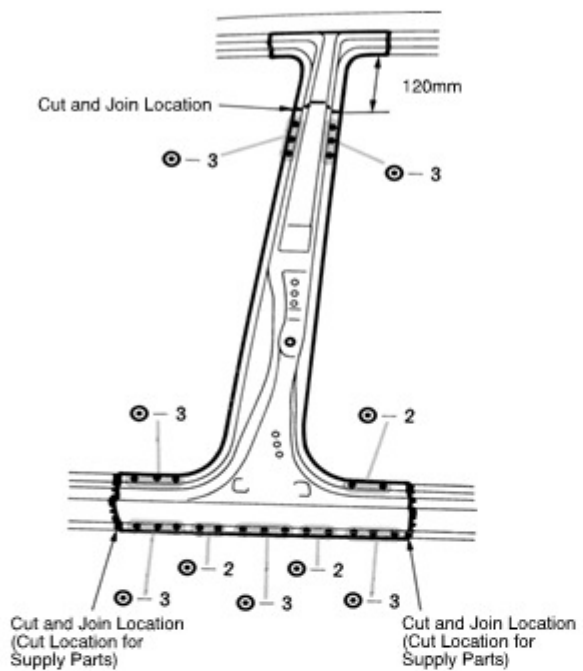
INSTALLATION



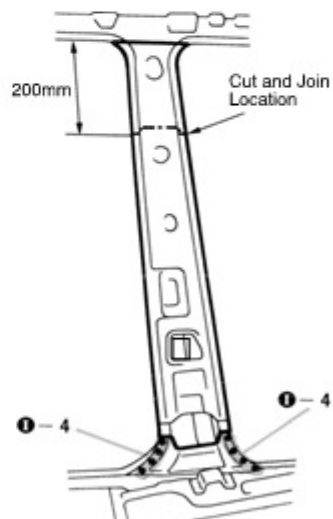
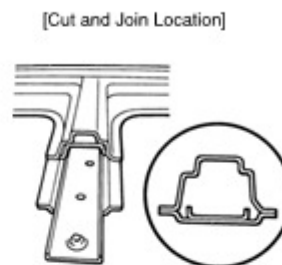
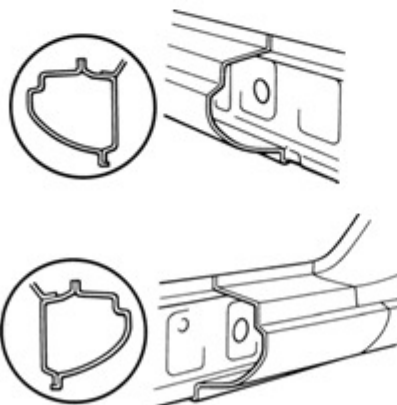
mm	in
20	0.79

RE-6

BODY PANEL REPLACEMENT

CENTER BODY PILLAR (CUT)**REMOVAL**

[Cut and Join Location]



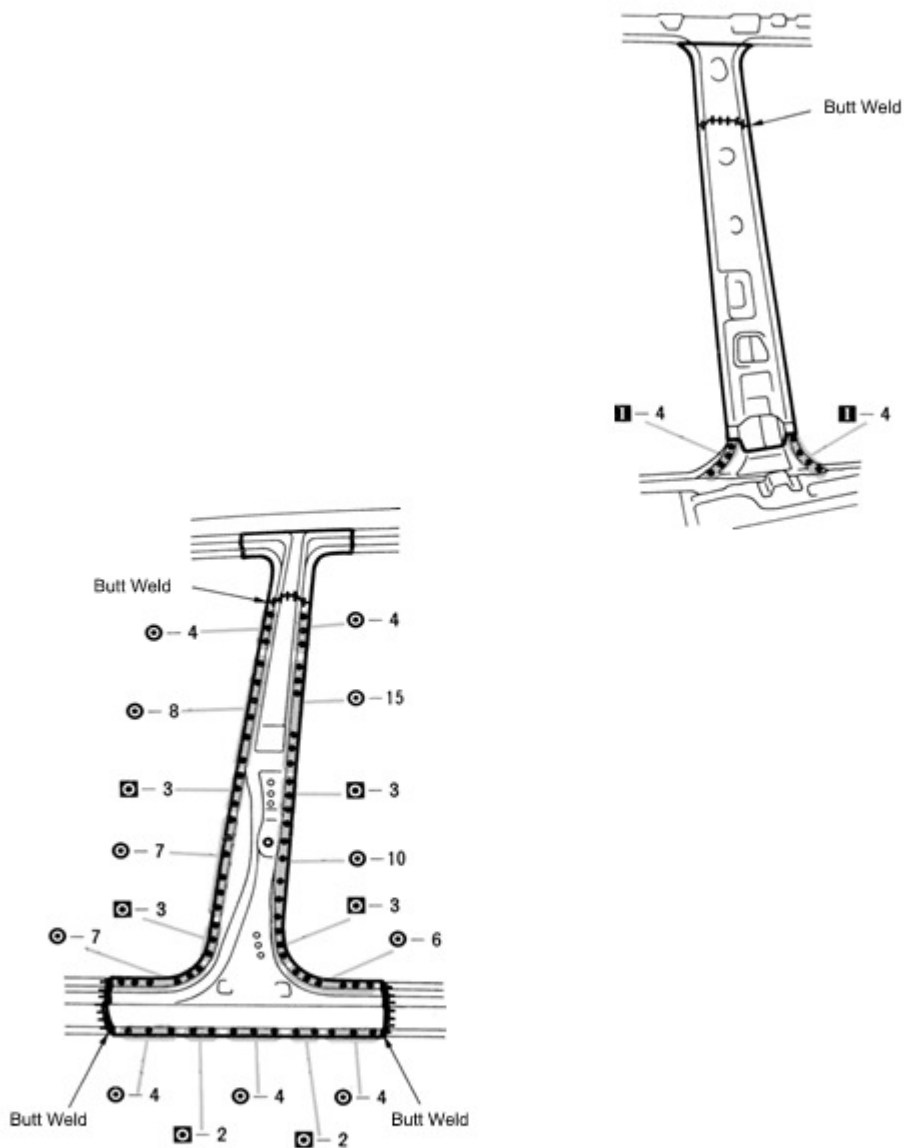
mm	in
120	4.72
200	7.87

1. Cut and join the parts at the location as shown above.

BODY PANEL REPLACEMENT

RE-7

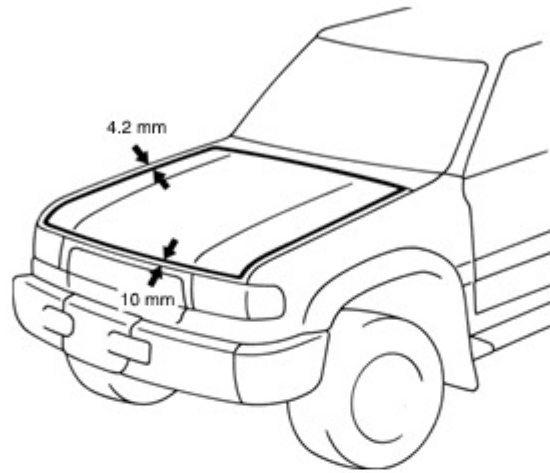
INSTALLATION



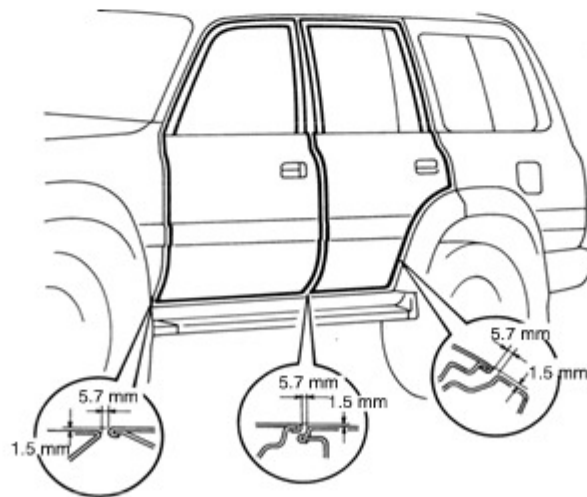
1. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.
2. Temporarily install the new parts and check the fit of the front door and rear door.

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.

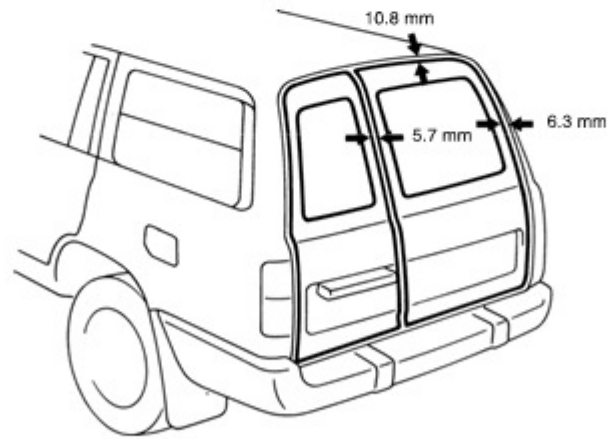
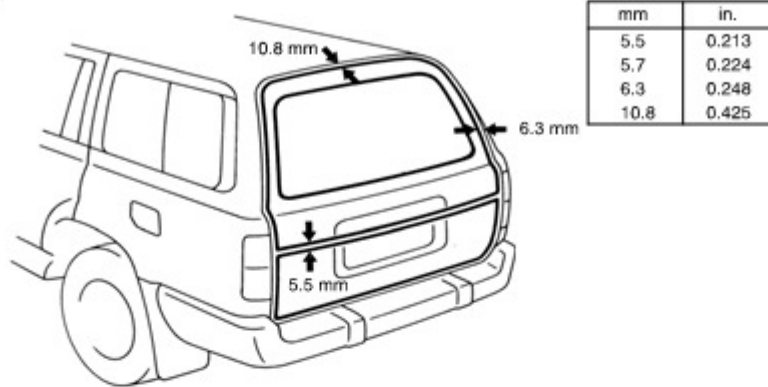


mm	in.
1.5	0.059
4.2	0.165
5.7	0.224
10	0.39



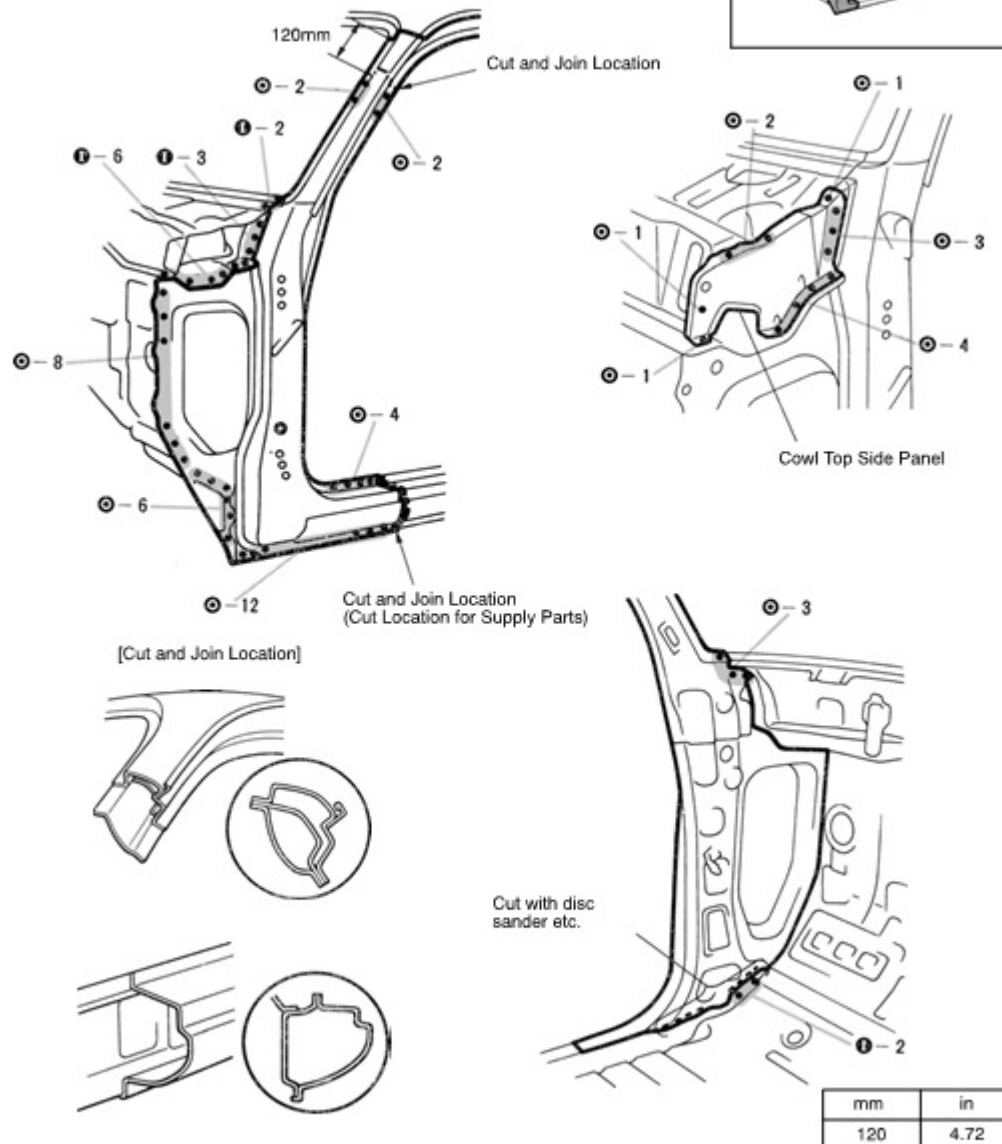
APPENDIX

AP-3



RE-2

BODY PANEL REPLACEMENT

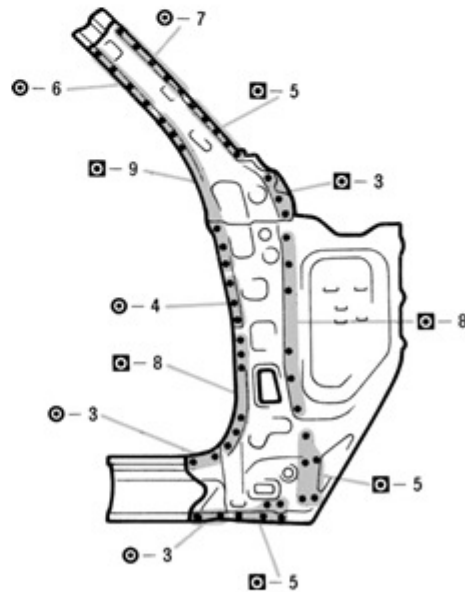
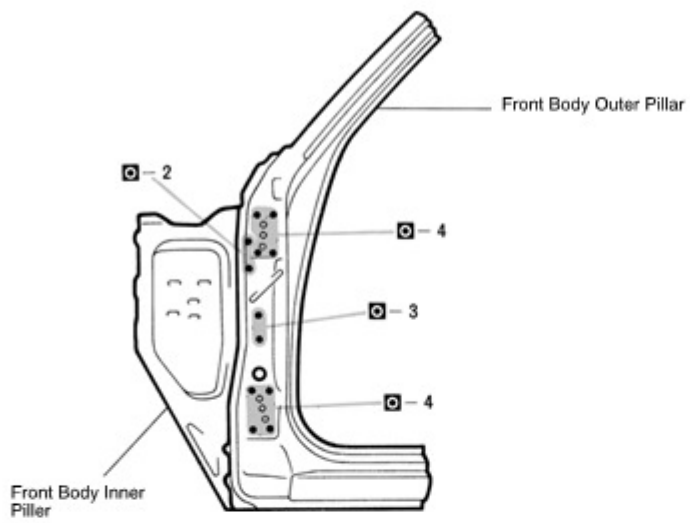
FRONT BODY PILLAR (CUT)**REMOVAL**

1. Cut and join the parts at the locations shown above.
2. After removing the cowl top side panel remove the front body pillar.

BODY PANEL REPLACEMENT

RE-3

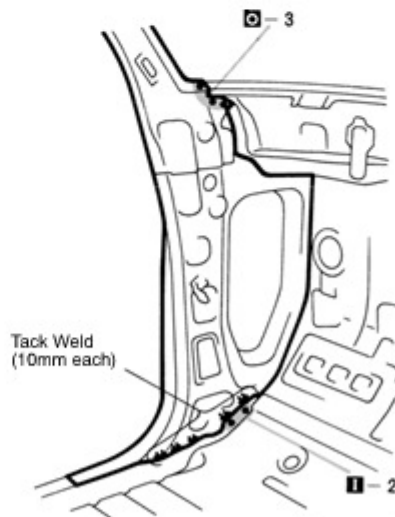
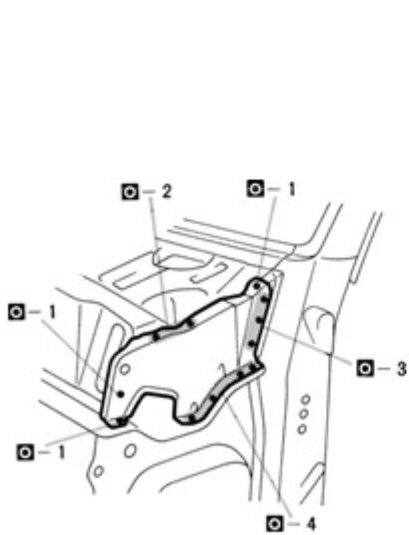
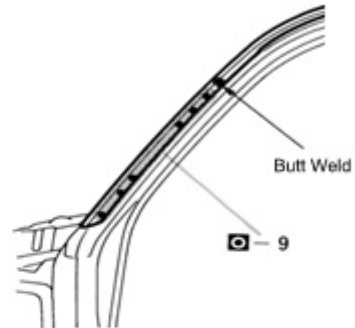
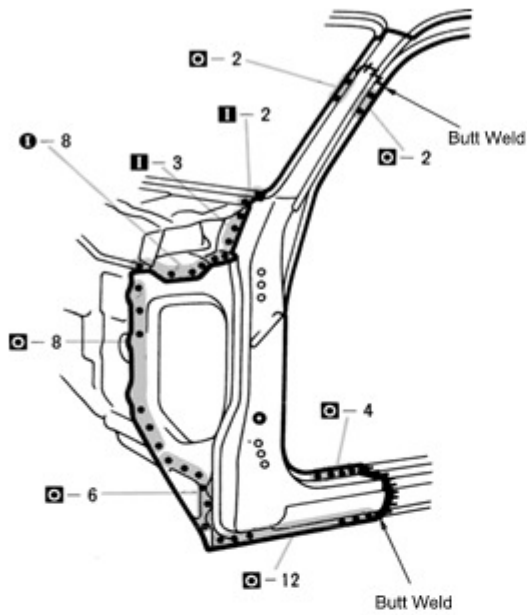
INSTALLATION (Continued on Next Page)



RE-4

BODY PANEL REPLACEMENT

INSTALLATION (Cont'd)



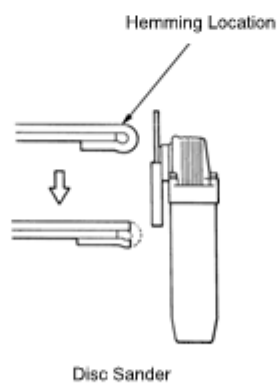
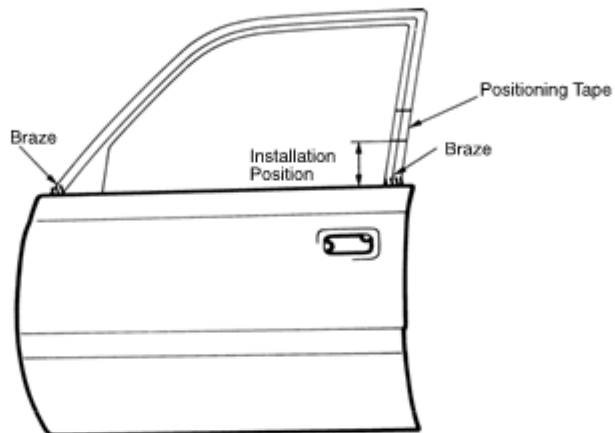
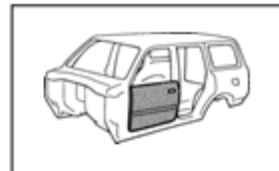
mm	in
10	0.39

-MEMO-

RE-5

RE-8

BODY PANEL REPLACEMENT

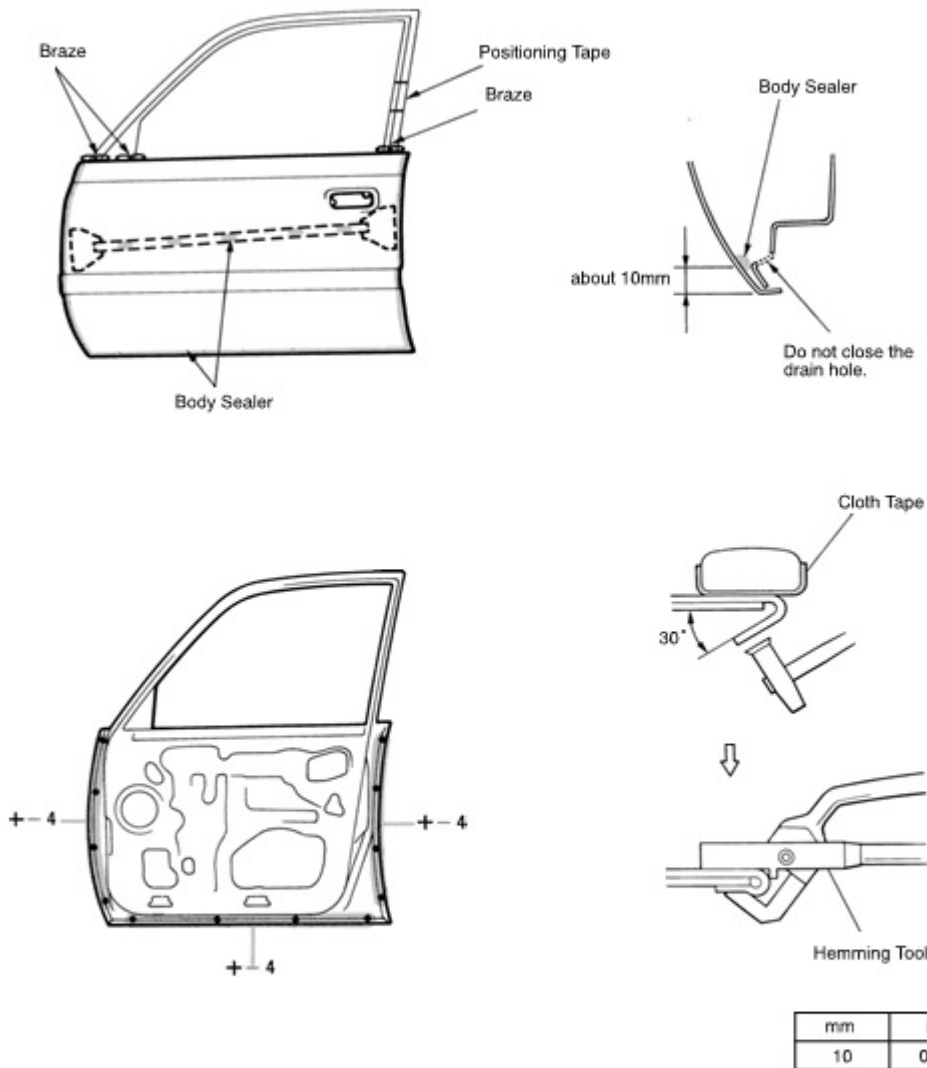
FRONT DOOR OUTER PANEL (ASSY)**REMOVAL**

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

BODY PANEL REPLACEMENT

RE-9

INSTALLATION



1. Before temporarily installing the new parts, apply body sealer to the side impact protection beam and back side of the new parts.

HINT:

- 1) Apply just enough sealer for the reinforcement and side impact beam to touch the new panel. Apply sealer evenly around the flange area, about 10mm (0.39in.) from the edge, as shown.
- 2) For other sealing points, refer to section AR.

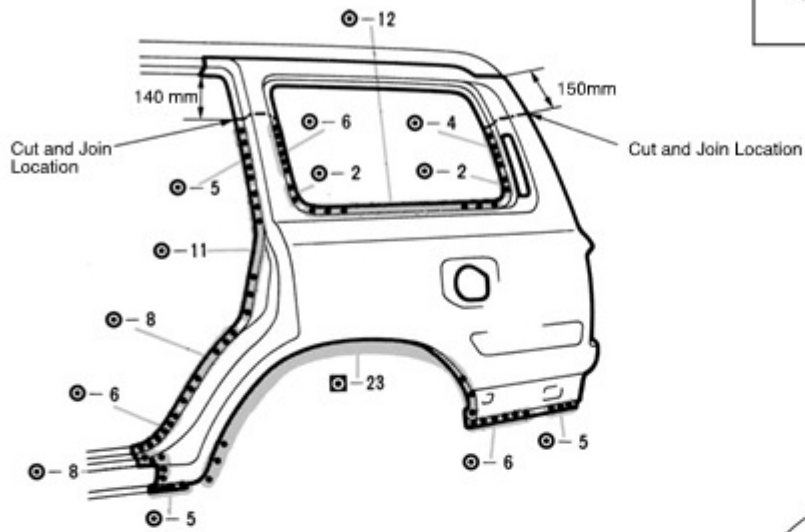
2. Bend the flange hem about 30° with a hammer and dolly, then fasten tightly with a hemming tool.

HINT:

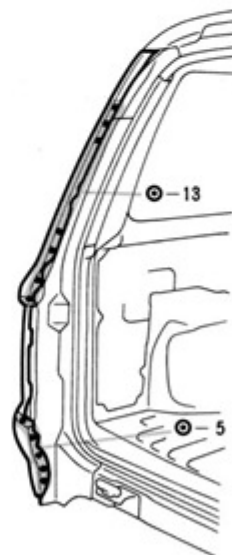
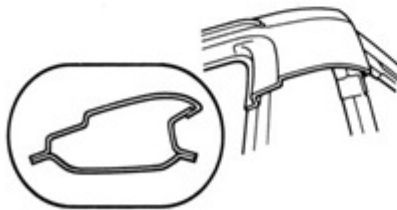
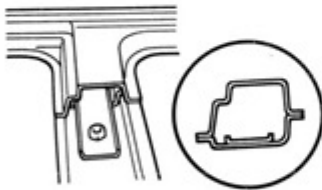
- 1) Perform hemming in three steps, being careful not to warp the panel.
- 2) If a hemming tool cannot be used, hem with a hammer and dolly.

RE-14

BODY PANEL REPLACEMENT

QUARTER PANEL (CUT)**REMOVAL**

Cut and Join Location



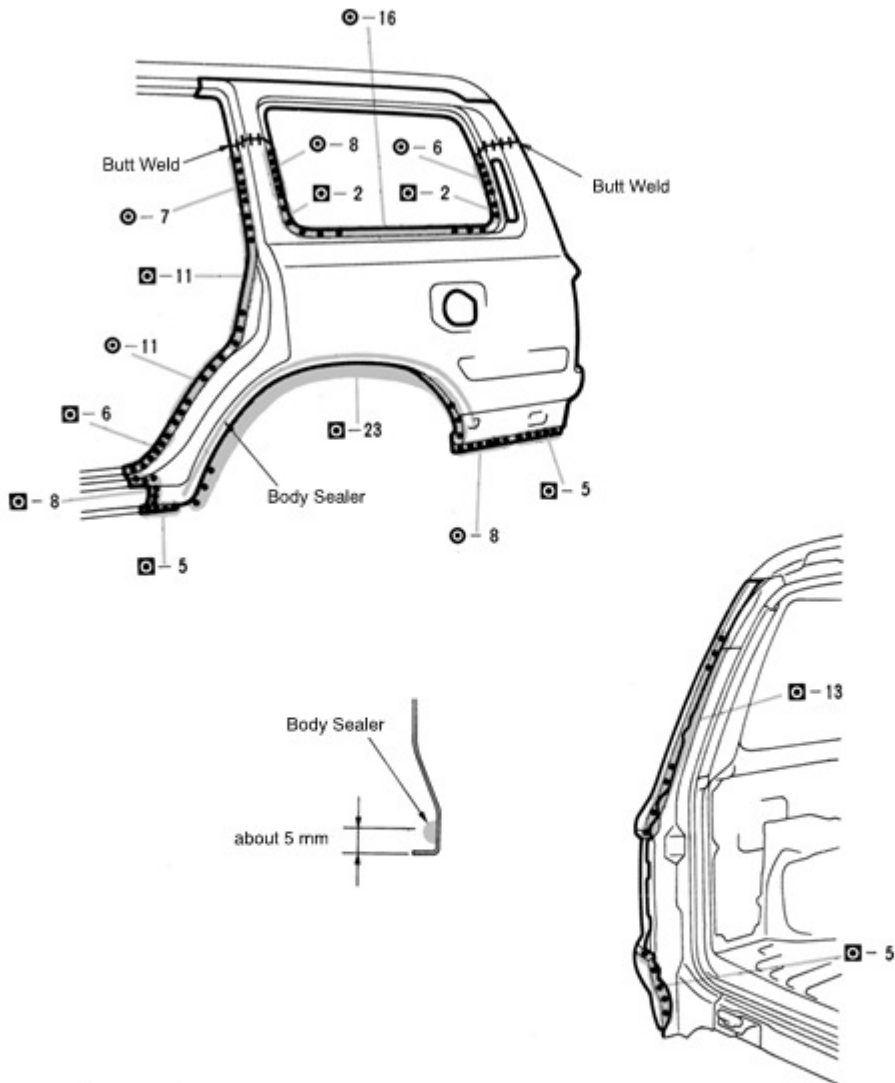
mm	in.
140	5.51
150	5.90

1. Cut and join the parts at the location shown above.

BODY PANEL REPLACEMENT

RE-15

INSTALLATION

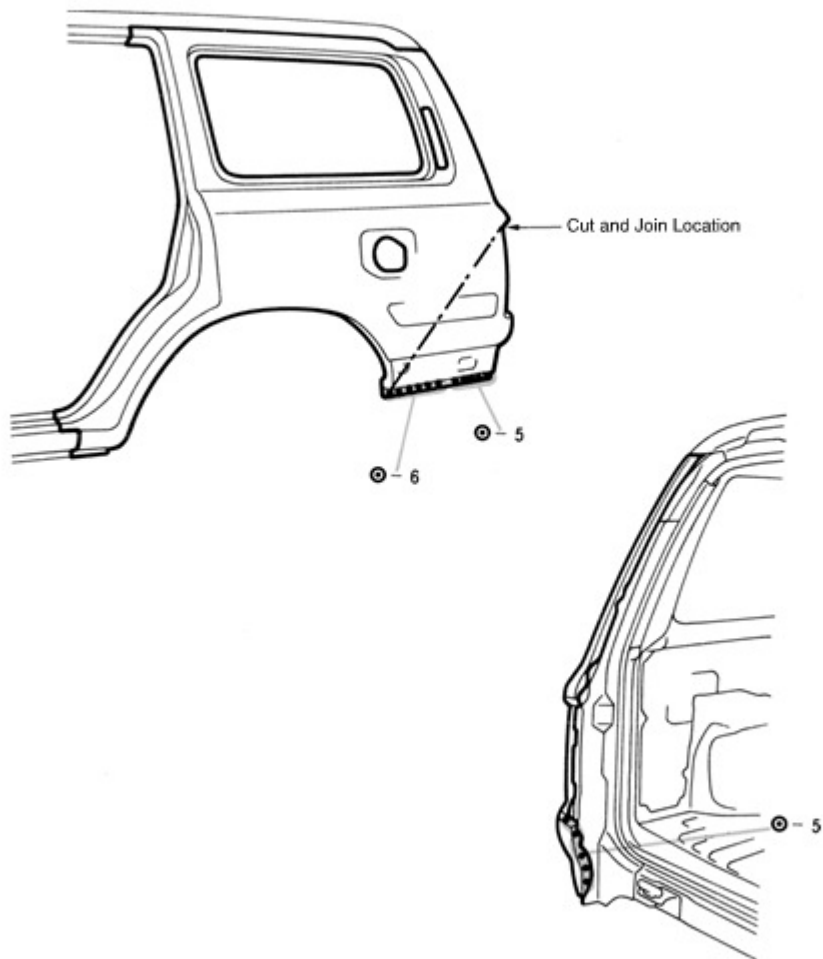
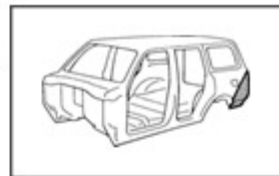


mm	in.
5	0.20

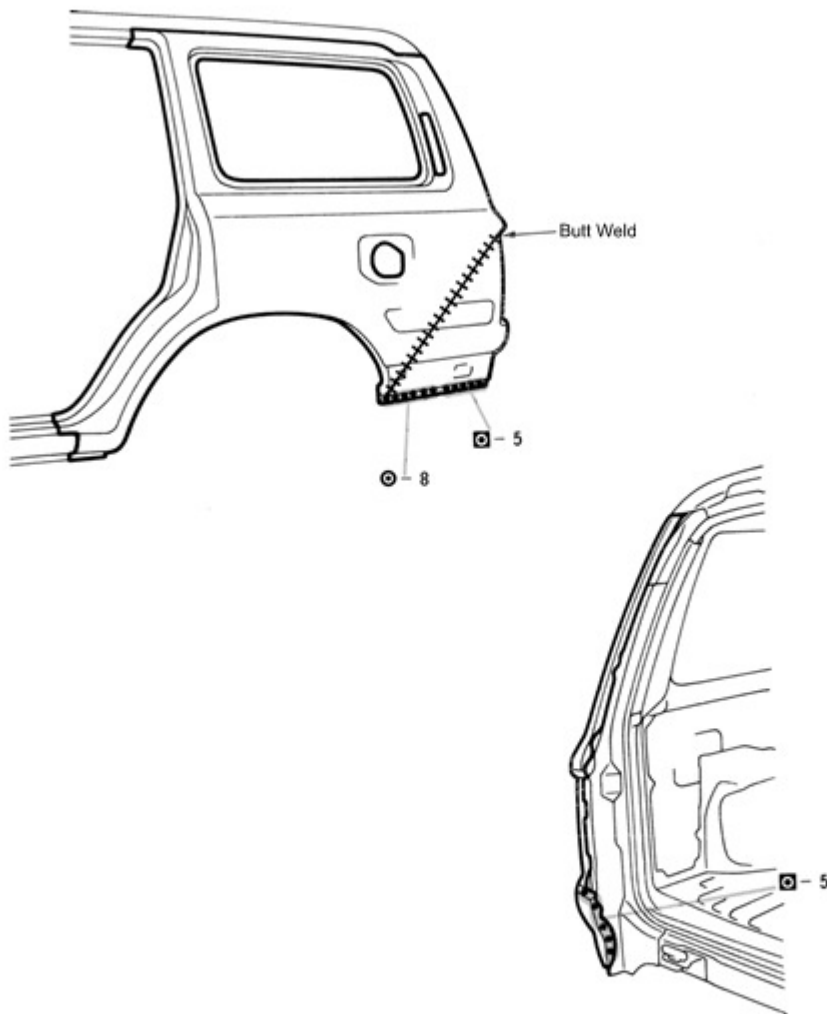
1. Before temporarily installing the new parts, apply body sealer to the wheel arch.
 2. Temporarily install the new parts and check the fit of the rear door, back door and rear combination light.
- HINT:**
- 1) Apply body sealer about 5 mm (0.20in.) from the flange, avoiding any oozing.
 - 2) Apply sealer evenly, about 3 – 4 mm (0.12 – 0.16in.) in diameter.
 - 3) For other sealing points, refer to section AR.

RE-16

BODY PANEL REPLACEMENT

QUARTER PANEL (CUT-P)**REMOVAL**

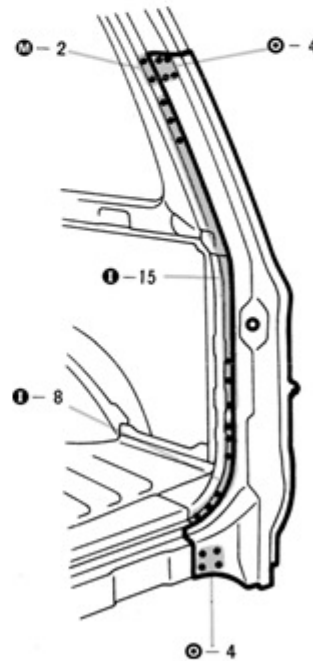
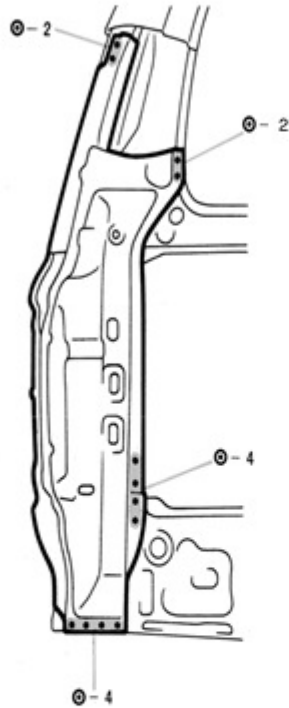
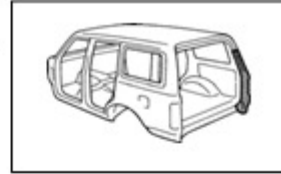
1. Cut and join the parts at the locations shown above.

INSTALLATION

1. Temporarily install the new parts and check the fit of the back door and rear combination light.

RE-22

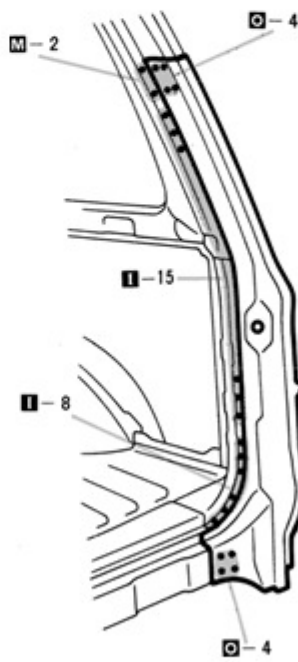
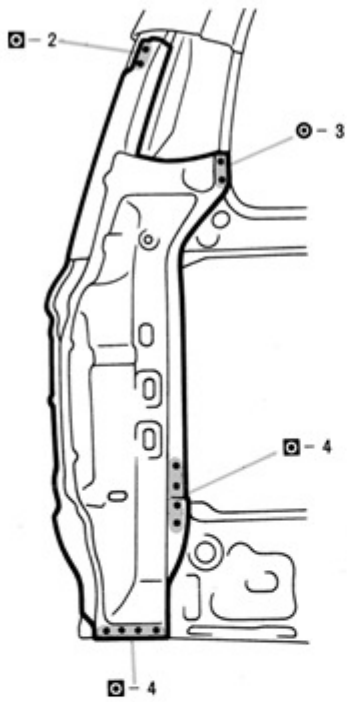
BODY PANEL REPLACEMENT

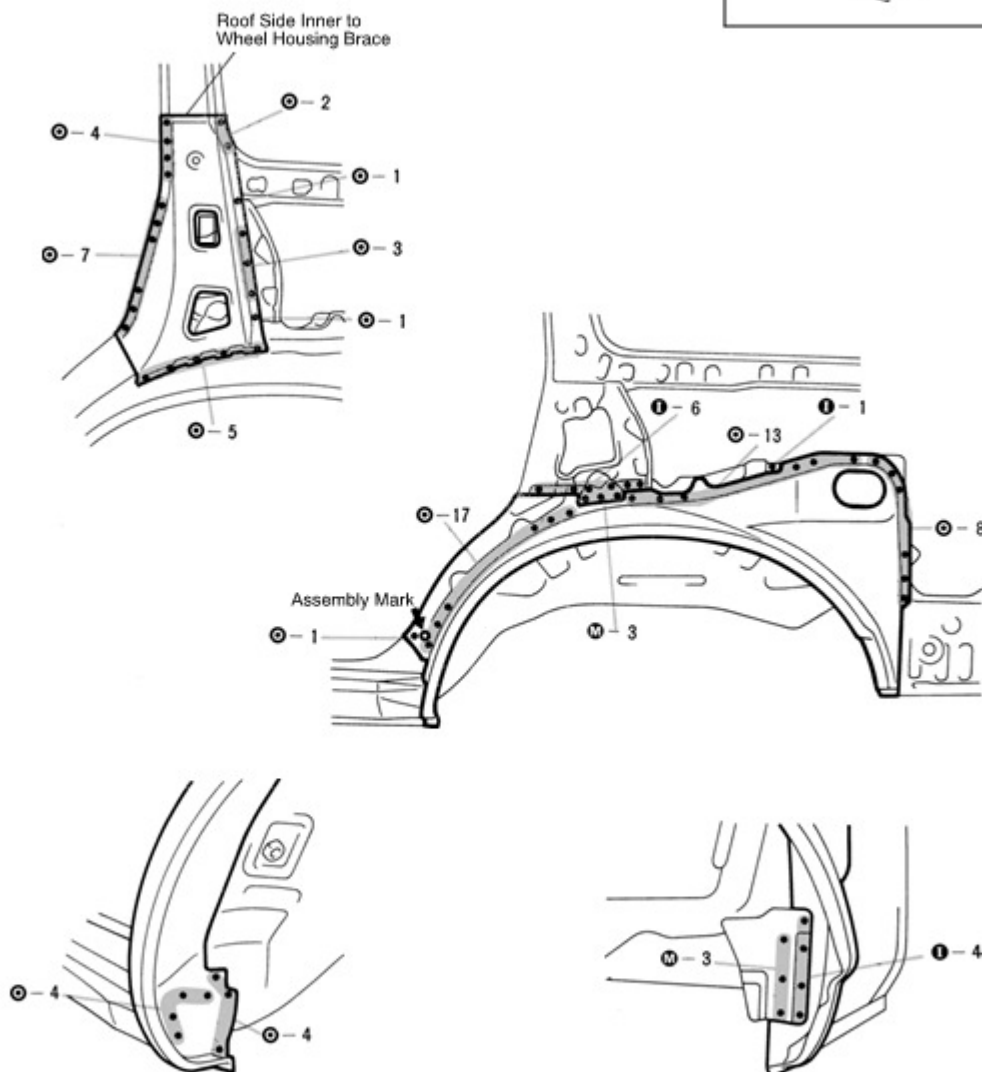
QUARTER PANEL EXTENSION (ASSY)**REMOVAL (With the quarter panel removed.)**

BODY PANEL REPLACEMENT

RE-23

INSTALLATION



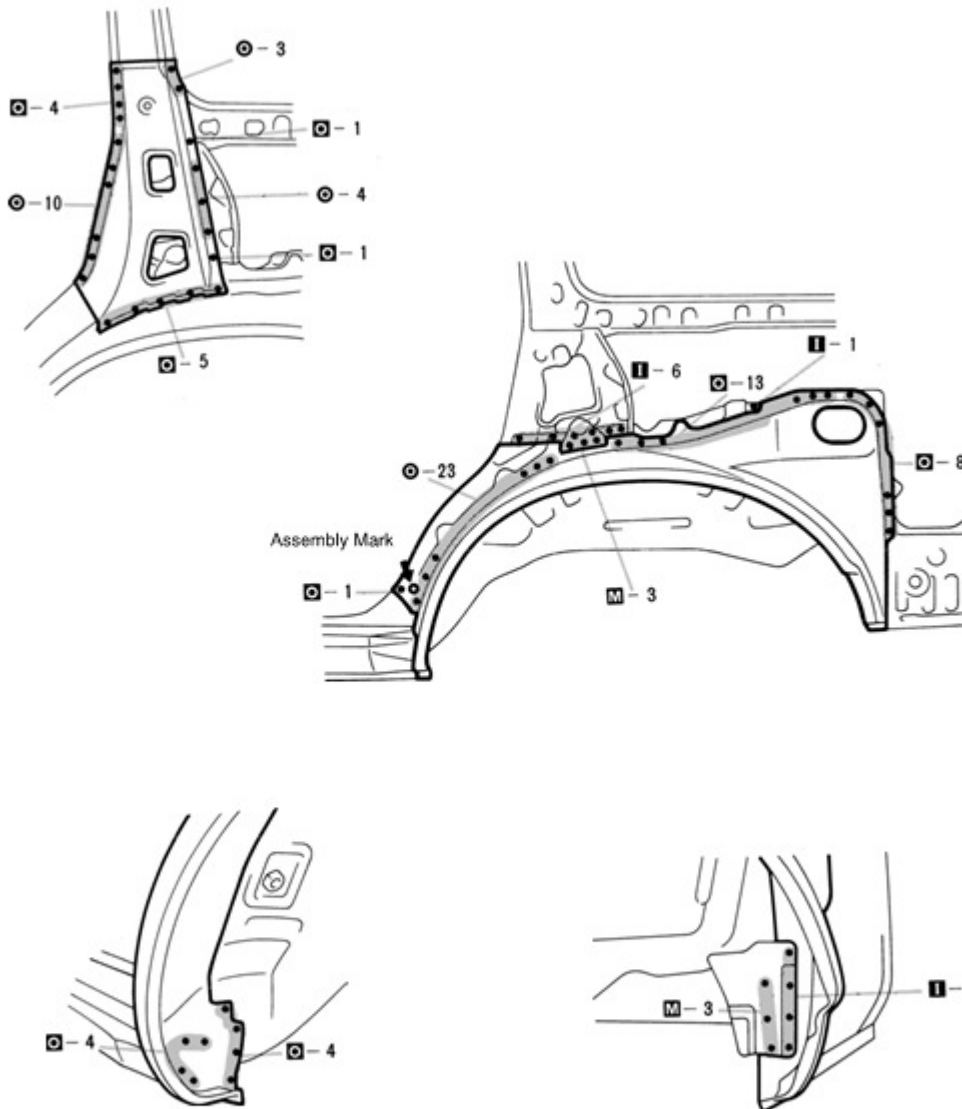
QUARTER WHEEL HOUSING OUTER PANEL (ASSY): Left Side**REMOVAL (With the quarter panel removed.)**

1. After removing the roof side inner to wheel housing brace, remove the quarter wheel housing outer panel.

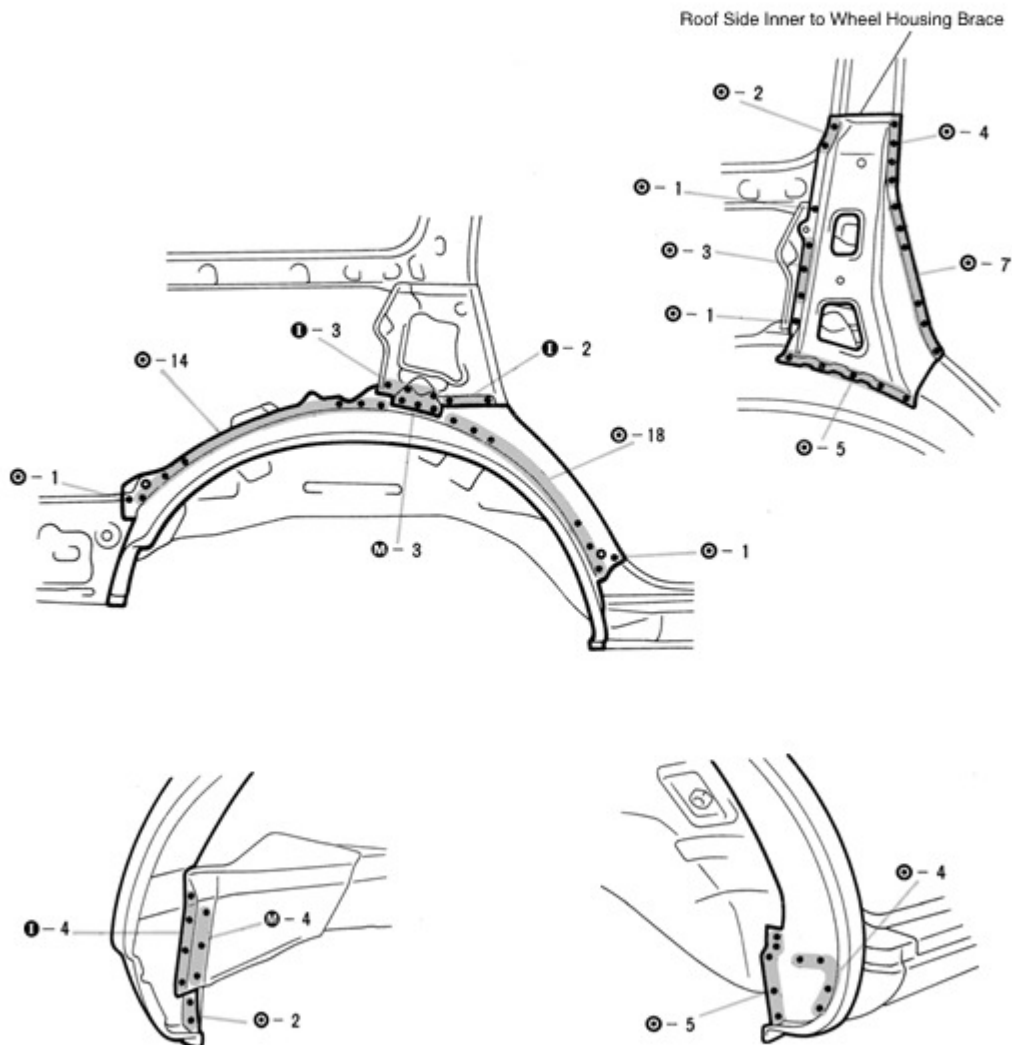
BODY PANEL REPLACEMENT

RE-21

INSTALLATION

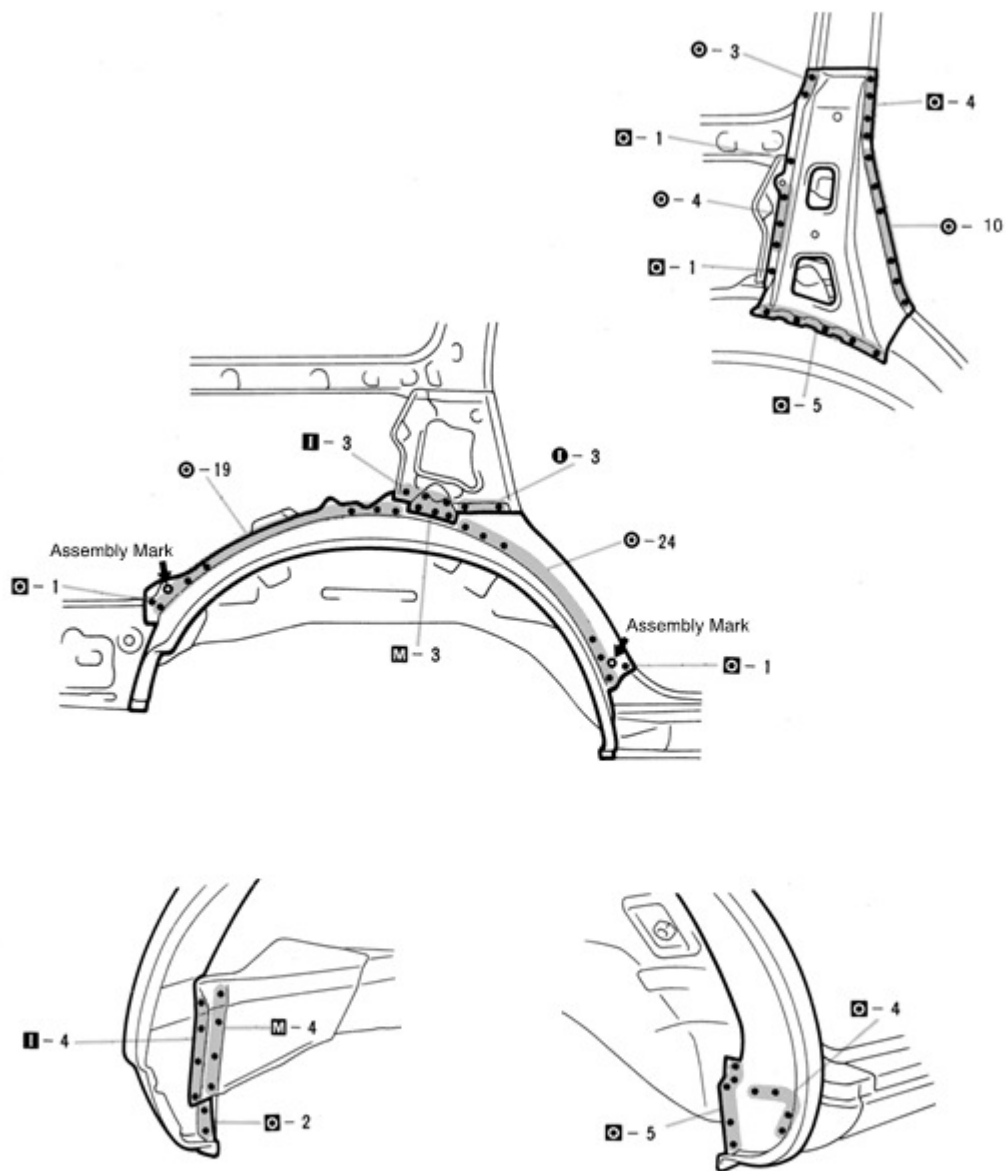


1. Determine the position of the new parts by the assembly marks of the inner and outer panels.
2. Before welding the new parts, temporarily install the quarter panel and check the fit.

**QUARTER WHEEL HOUSING OUTER PANEL
(ASSY): Right Side****REMOVAL (With the quarter panel removed.)**

1. After removing the roof side inner to wheel housing brace, remove the quarter wheel housing outer panel.

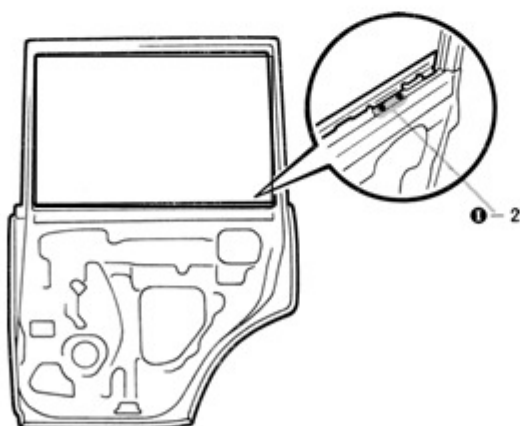
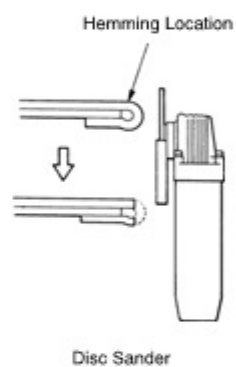
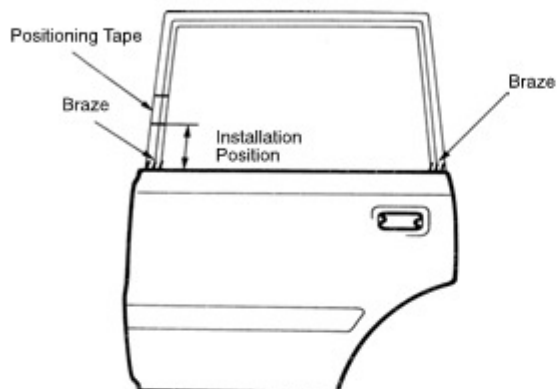
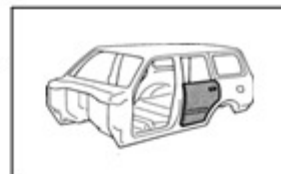
INSTALLATION



1. Determine the position of the new parts by the assembly marks of the inner and outer panels.
2. Before welding the new parts, temporarily install the quarter panel and check the fit.

RE-10

BODY PANEL REPLACEMENT

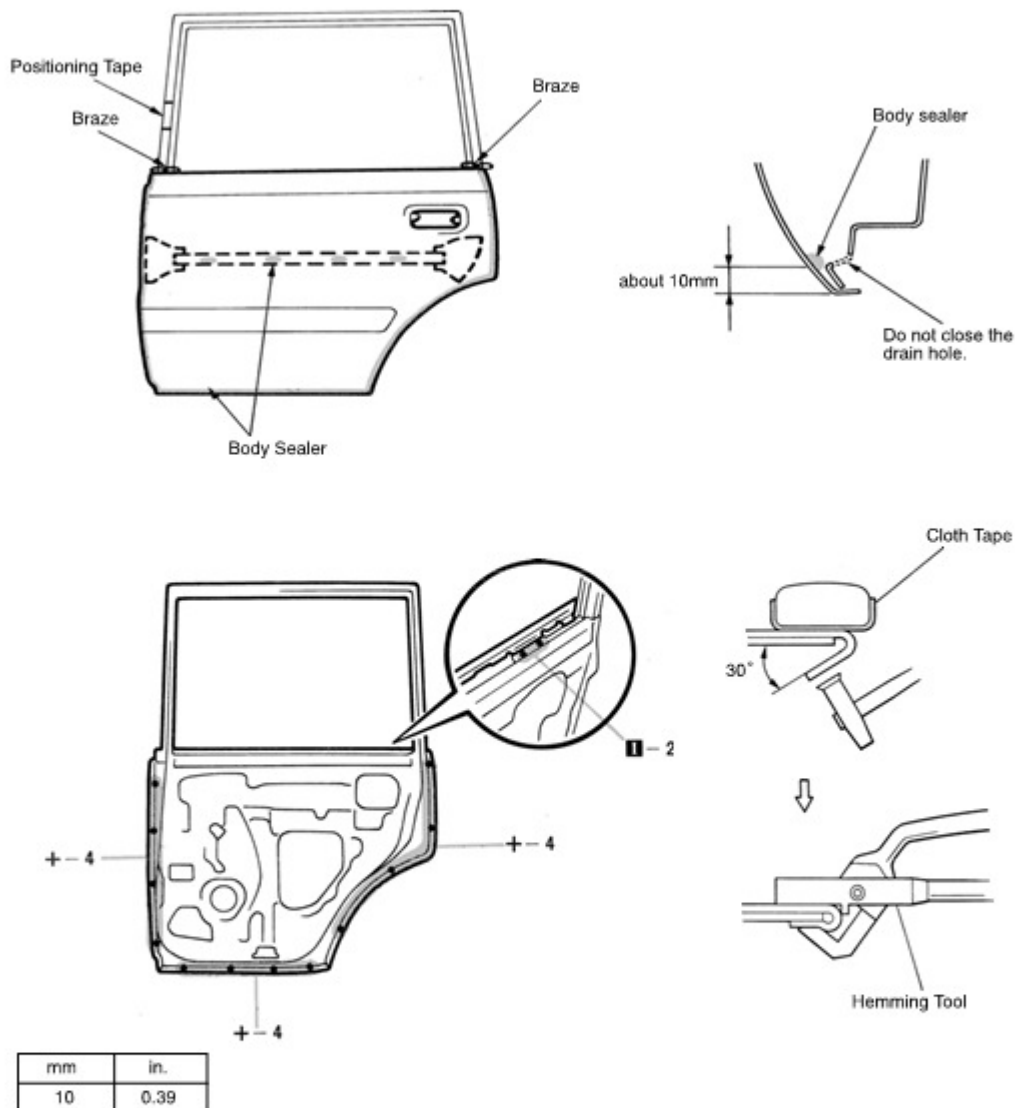
REAR DOOR OUTER PANEL (ASSY)**REMOVAL**

1. Before removing the outer panel, make the installation position with a tape.
2. Grind out the hemming location and remove the outer panel.

BODY PANEL REPLACEMENT

RE-11

INSTALLATION



1. Before temporarily installing the new parts, apply body sealer to the side impact protection beam and back side of the new parts.

HINT:

- 1) Apply sealer evenly about 10mm (0.39in.) from the flange and 3mm (0.12in.) in diameter to the outer panel and apply just enough sealer for the side impact protection beam to make contact.
- 2) For other sealing points, refer to section AR.

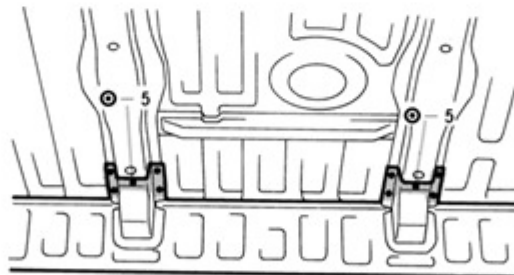
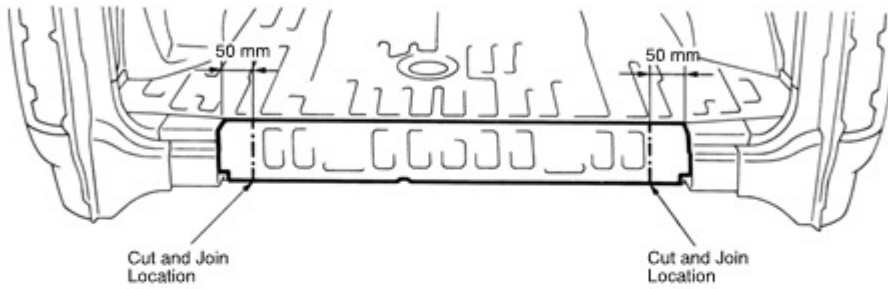
2. Bend the flange hem about 30° with a hammer and dolly, then fasten tightly with a hemming tool.

HINT:

- 1) Perform hemming in three steps, being careful not to warp the panel.
- 2) If a hemming tool cannot be used, hem with a hammer and dolly.

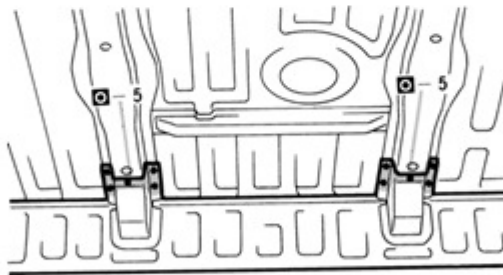
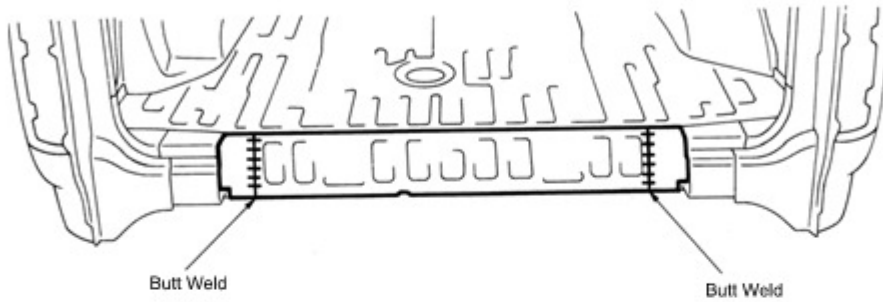
RE-28

BODY PANEL REPLACEMENT

REAR FLOOR INNER CROSSMEMBER (CUT)**REMOVAL (With the body lower back panel removed.)**

mm	in
50	1.97

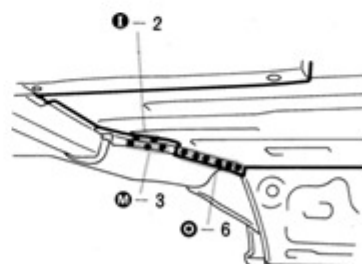
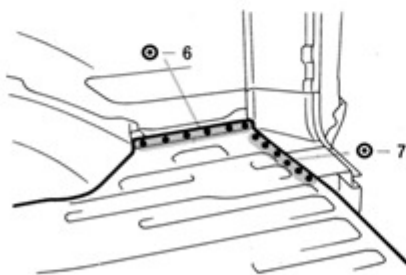
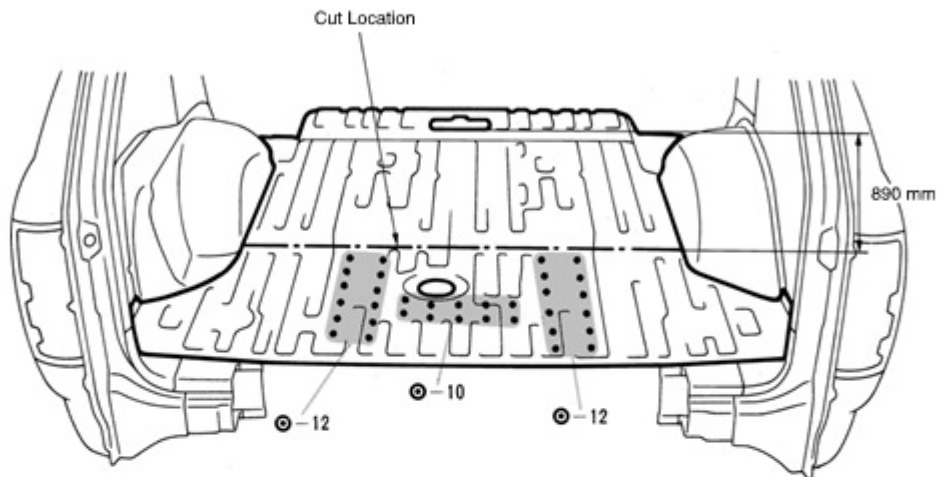
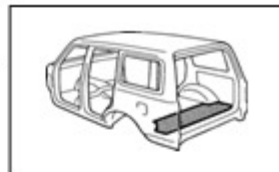
1. Cut and join the parts at the location shown above.

INSTALLATION

1. Before welding the new parts, temporarily install the body lower back panel and check the fit.

RE-30

BODY PANEL REPLACEMENT

REAR FLOOR PAN (ASSY)**REMOVAL (With the rear floor inner crossmember removed.)**

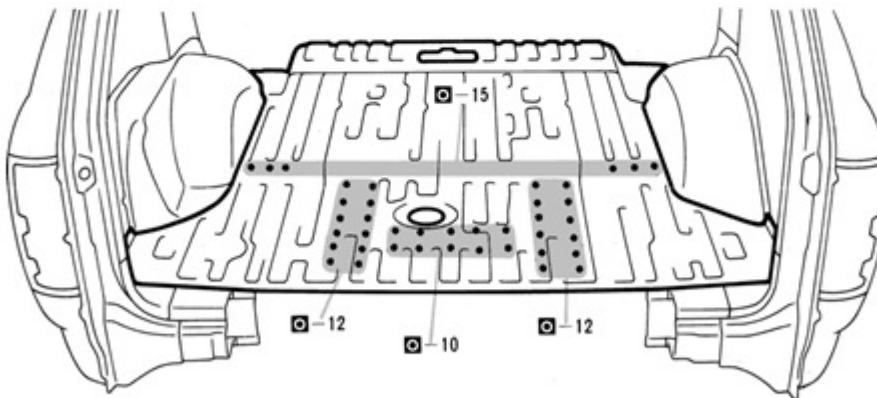
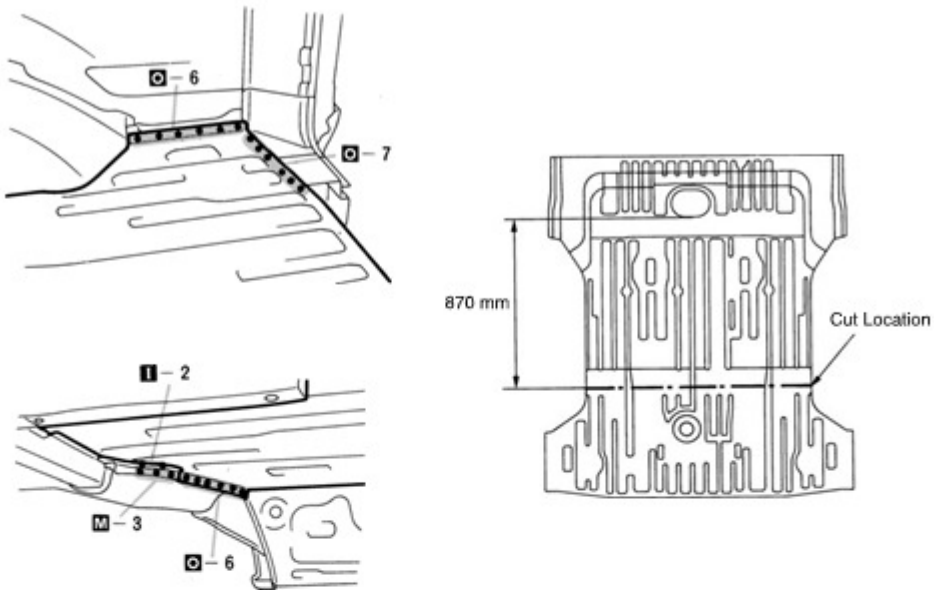
mm	in
890	35.04

1. Cut the parts at the location shown above.

BODY PANEL REPLACEMENT

RE-31

INSTALLATION



mm	in
870	34.25

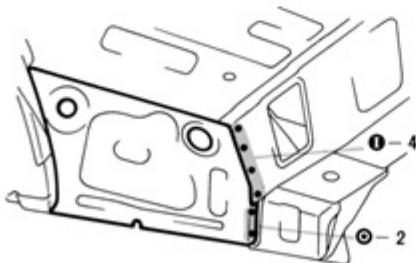
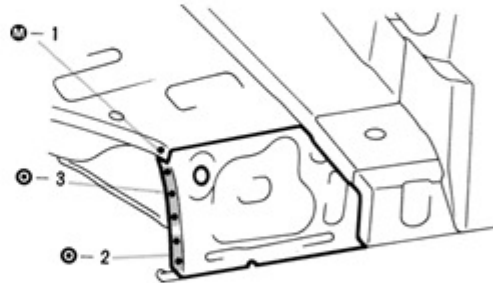
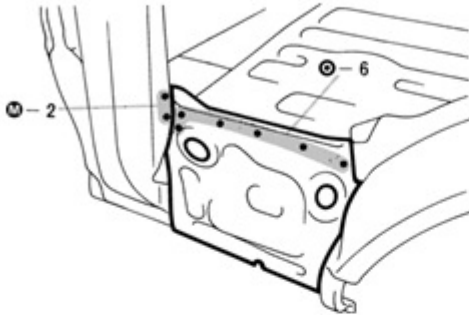
1. Cut the new parts at the location shown above.
2. Plug weld the overlapping portion of the new parts.

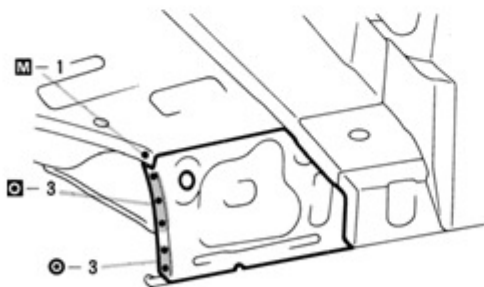
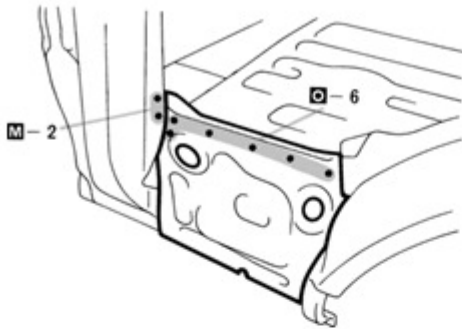
HINT: Be sure the portion to be welded are aligned and not loose.

3. Coat the overlapping opening portion from the both sides with body sealer.

RE-32

BODY PANEL REPLACEMENT

REAR FLOOR SIDE PANEL**REMOVAL (With the quarter panel removed.)**

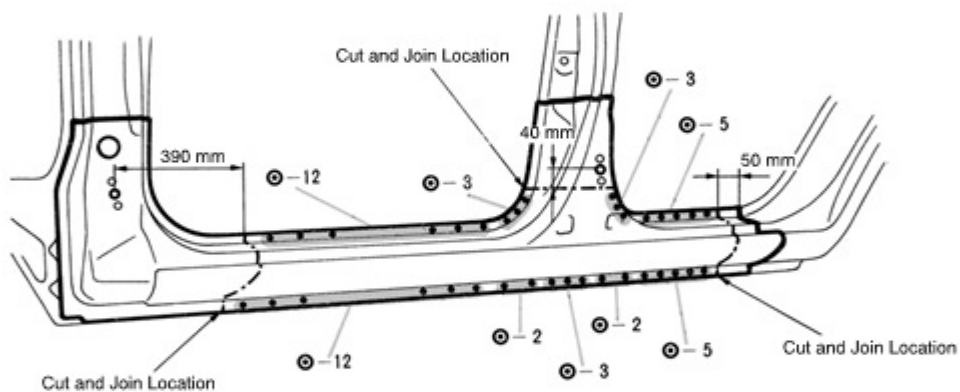
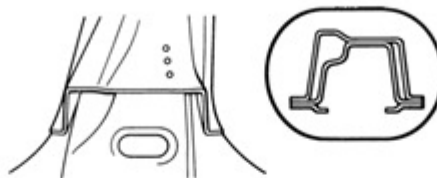
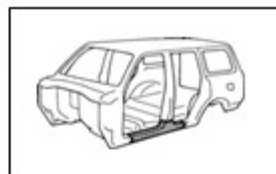
INSTALLATION

RE-12

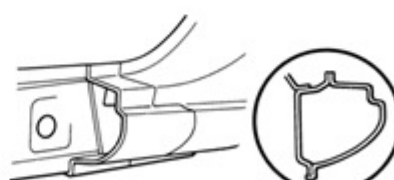
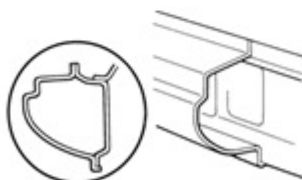
BODY PANEL REPLACEMENT

ROCKER OUTER PANEL (CUT)**REMOVAL**

[Cut and Join Location]

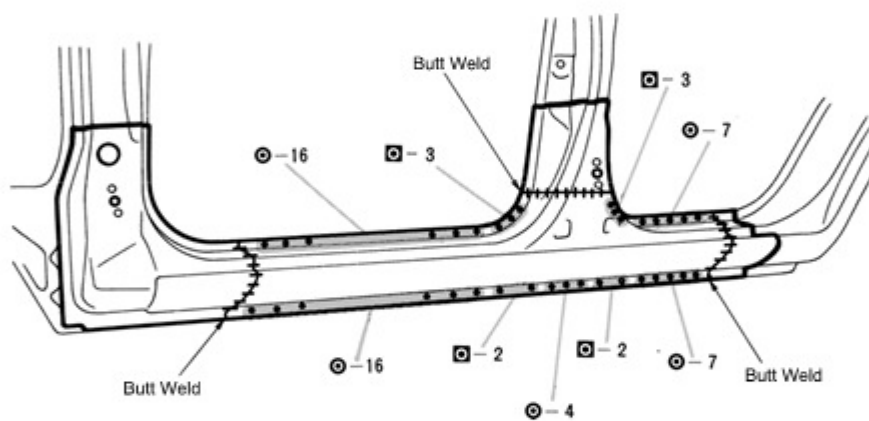


[Cut and Join Location]



mm	in.
40	1.57
50	1.96
390	15.35

1. Cut and join the parts at the location shown above.

INSTALLATION

1. Temporarily install the new parts and check the fit of the front door and rear door.