

SECTION **BRM**  
BODY REPAIR

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# BODY EXTERIOR PAINT COLOR

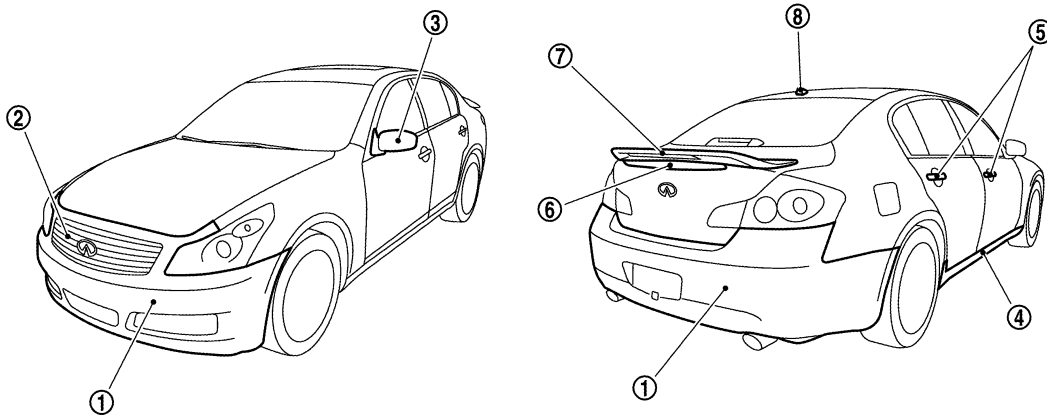
< FEATURES OF NEW MODEL >

## FEATURES OF NEW MODEL

### BODY EXTERIOR PAINT COLOR

#### Body Exterior Paint Color

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| Component |                         | Color code      | BA51       | BB30 | BKH3  | BK23   | BK32             | BK51 | BK52 | BQX1  |
|-----------|-------------------------|-----------------|------------|------|-------|--------|------------------|------|------|-------|
|           |                         | Description     | Red        | Blue | Black | Silver | Yellowish Silver | Gray | Gray | White |
|           |                         | Paint type      | 3P         | M    | 2S    | M      | TM               | M    | PM   | 3P    |
|           |                         | Hard clear coat | ×          | ×    | ×     | -      | -                | -    | ×    | -     |
| 1         | Bumper fascia           | Body color      | BA51       | BB30 | BKH3  | BK23   | BK32             | BK51 | BK52 | BQX1  |
| 2         | Front grille            | Chromium-plate  | Cr         | Cr   | Cr    | Cr     | Cr               | Cr   | Cr   | Cr    |
| 3         | Door outside mirror     | Cover           | Body color | BA51 | BB30  | BKH3   | BK23             | BK32 | BK51 | BK52  |
| 4         | Center mudguard         | Body color      | BA51       | BB30 | BKH3  | BK23   | BK32             | BK51 | BK52 | BQX1  |
| 5         | Door outside handle     | Body color      | BA51       | BB30 | BKH3  | BK23   | BK32             | BK51 | BK52 | BQX1  |
| 6         | Trunk lid finisher      | Chromium-plate  | Cr         | Cr   | Cr    | Cr     | Cr               | Cr   | Cr   | Cr    |
| 7         | Rear spoiler            | Body color      | BA51       | BB30 | BKH3  | BK23   | BK32             | BK51 | BK52 | BQX1  |
| 8         | Satellite radio antenna | Body color      | BA51       | BB30 | BKH3  | BK23   | BK32             | BK51 | BK52 | BQX1  |

2S: Solid + Clear, M: Metallic, 2P: 2-Coat pearl, 3P: 3-Coat pearl, FPM: Iron oxide pearl, RPM: Multi flex color  
 TM: Micro titanium metallic, PM: Pearl metallic

# HANDLING PRECAUTIONS

< PRECAUTION >

## PRECAUTION

### HANDLING PRECAUTIONS

#### Precautions For Plastics

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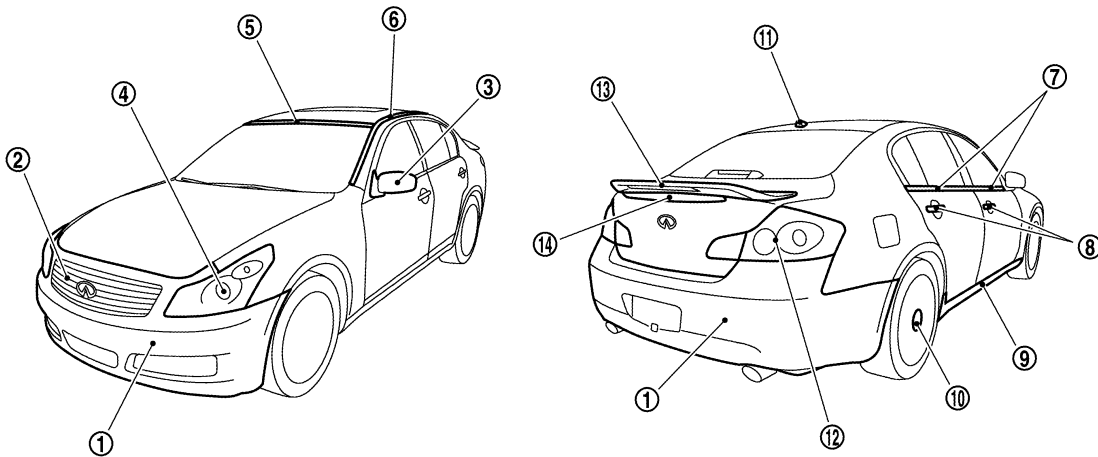
| Abbreviation | Material name                               | Heatresisting temperature °C (°F) | Resistance to gasoline and solvents   | Other cautions                     |
|--------------|---|-----------------------------------|---|------------------------------------|
| PE           | Polyethylene                                | 60 (140)                          | Gasoline and most solvents are harmless if applied for a very short time (wipe up quickly). | Flammable                          |
| PVC          | Poly Vinyl Chloride                         | 80 (176)                          | Same as above.  | Poison gas is emitted when burned. |
| EPM/EPDM     | Ethylene Propylene (Diene) copolymer        | 80 (176)                          | Same as above.  | Flammable                          |
| TPO          | Thermoplastic Olefine                       | 80 (176)                          | Same as above.  | Flammable                          |
| PP           | Polypropylene                               | 90 (194)                          | Same as above.  | Flammable, avoid battery acid.     |
| UP           | Unsaturated Polyester                       | 90 (194)                          | Same as above.  | Flammable                          |
| PS           | Polystyrene                                 | 80 (176)                          | Avoid solvents.   | Flammable                          |
| ABS          | Acrylonitrile Butadiene Styrene             | 80 (176)                          | Avoid gasoline and solvents.  |                                    |
| PMMA         | Poly Methyl Methacrylate                    | 85 (185)                          | Same as above.  |                                    |
| AAS          | Acrylonitrile Acrylic Styrene               | 85 (185)                          | Same as above.  |                                    |
| EVAC         | Ethylene Vinyl Acetate                      | 90 (194)                          | Same as above.  |                                    |
| ASA          | Acrylonitrile Styrene Acrylate              | 100 (212)                         | Same as above.  | Flammable                          |
| PPE          | Poly Phenylene Ether                        | 110 (230)                         | Same as above.  |                                    |
| PC           | Polycarbonate                               | 120 (248)                         | Same as above.  |                                    |
| PAR          | Polyarylate                                 | 180 (356)                         | Same as above.  |                                    |
| PUR          | Polyurethane                                | 90 (194)                          | Same as above.  |                                    |
| TPU          | Thermoplastic Urethane                      | 110 (230)                         | Same as above.  |                                    |
| POM          | Poly Oxymethylene                           | 120 (248)                         | Same as above.  | Avoid battery acid.                |
| PBT+PC       | Poly Butylene Terephthalate + Polycarbonate | 120 (248)                         | Same as above.  | Flammable                          |
| PA           | Polyamide                                   | 140 (284)                         | Same as above.  | Avoid immersing in water.          |
| PBT          | Poly Butylene Terephthalate                 | 140 (284)                         | Same as above.  |                                    |
| PET          | Polyester                                   | 180 (356)                         | Same as above.  |                                    |
| PEI          | Polyetherimide                              | 200 (392)                         | Same as above.  |                                    |

1. When repairing and painting a portion of the body adjacent to plastic parts, consider their characteristics (influence of heat and solvent) and remove them if necessary or take suitable measures to protect them.
2. Plastic parts should be repaired and painted using methods suiting the materials' characteristics.

# HANDLING PRECAUTIONS

< PRECAUTION >

## LOCATION OF PLASTIC PARTS

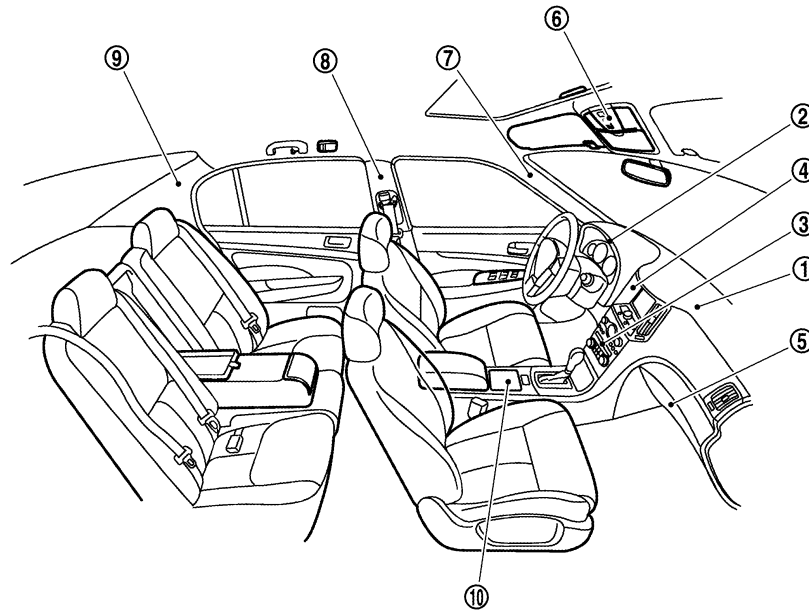


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| Component |                      | Material        | Component        |                                   | Material                |                                     |
|-----------|----------------------|-----------------|------------------|-----------------------------------|-------------------------|-------------------------------------|
| 1         | Bumper fascia        | PP              | 8                | Door outside handle               | PC + PET                |                                     |
| 2         | Front grille         | ABS             | 9                | Center mudguard                   | PP                      |                                     |
| 3         | Door outside mirror  | Cover           | ABS              | 10                                | Wheel disk cap          | PC + ABS                            |
|           |                      | Housing         | AAS              | 11                                | Satellite radio antenna | ASA + PC                            |
|           |                      | Base            | PA + Glass fiber |                                   | 12                      | Rear combination lamp (Rear Fender) |
| 4         | Head lamp            | Lens            | PC               | Housing                           |                         | ABS                                 |
|           |                      | Housing         | PP               | Rear combination lamp (Trunk lid) |                         | Lens                                |
| 5         | Windshield molding   | TPO             | Housing          |                                   |                         | PC + ASA                            |
| 6         | Roof side molding    | PVC + Stainless | 13               | Rear spoiler                      | UP + Glass fiber        |                                     |
| 7         | Door outside molding | PVC + Stainless | 14               | Trunk lid finisher                | ABS                     |                                     |

# HANDLING PRECAUTIONS

< PRECAUTION >



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| Component |                  | Material          |          | Component |                       | Material |     |
|-----------|------------------|-------------------|----------|-----------|-----------------------|----------|-----|
| 1         | Instrument panel | Core              | PP       | 5         | Glove box             | Core     | ABS |
|           |                  | Pad               | PUR      |           |                       | Pad      | PUR |
|           |                  | Skin              | TPU      |           |                       | Skin     | PVC |
| 2         | Cluster lid A    | Upper             | ABS      | 6         | Map lamp              | Lens     | PC  |
|           |                  | Lower             | PP       |           |                       | Housing  | PP  |
| 3         | Cluster lid C    | Standard finisher | ABS      | 7         | Front pillar garnish  | PP       |     |
|           |                  | Wood finisher     | PC + ABS | 8         | Center pillar garnish | PP       |     |
|           |                  |                   |          | 9         | Rear pillar finisher  | PP       |     |
| 4         | Cluster lid D    | PC + ABS          |          | 10        | Console body          | PP + PVC |     |

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# BODY COMPONENT PARTS

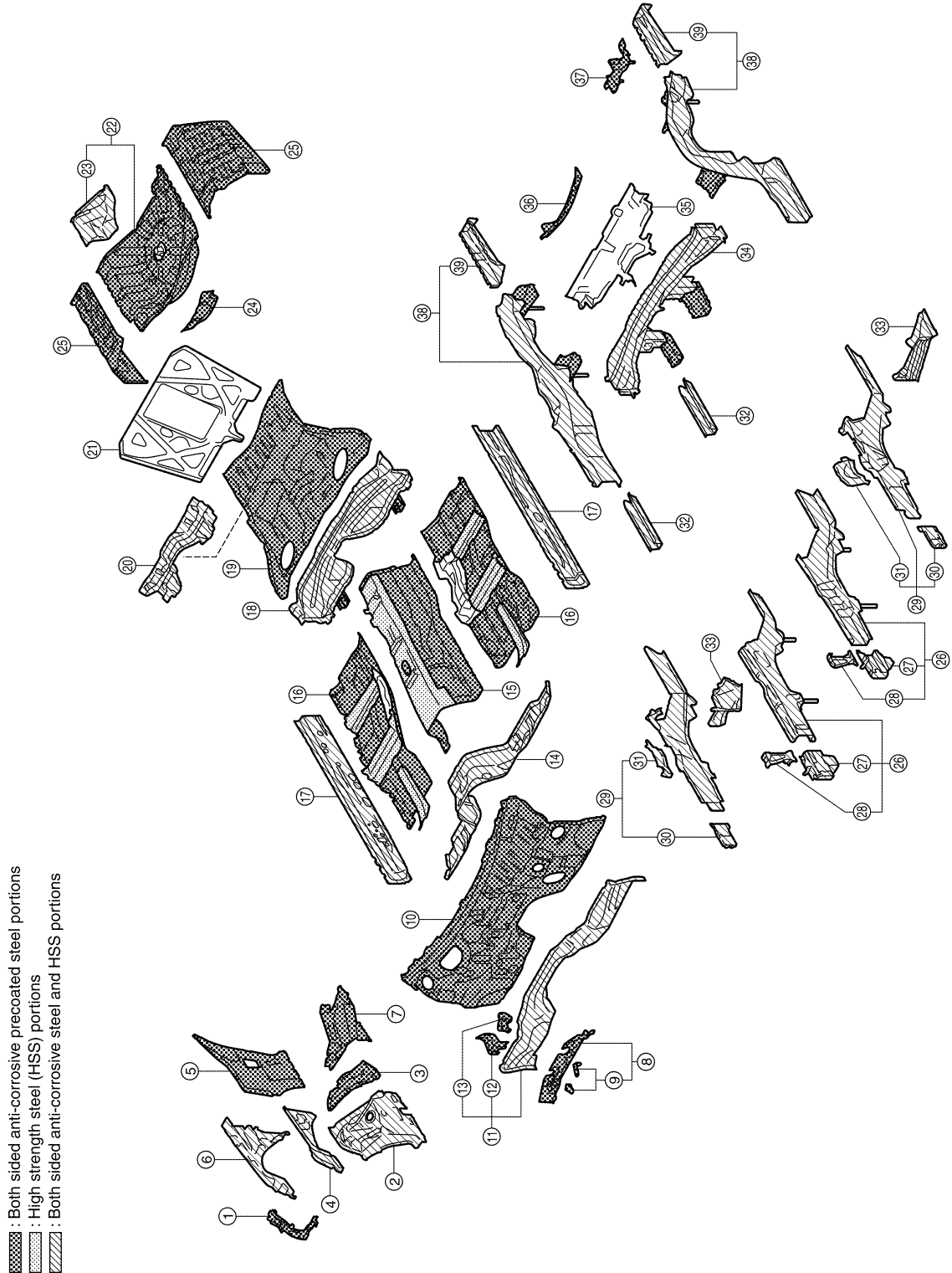
< REMOVAL AND INSTALLATION >

## REMOVAL AND INSTALLATION

### BODY COMPONENT PARTS

#### Underbody Component Parts

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# BODY COMPONENT PARTS

## < REMOVAL AND INSTALLATION >

|  |   |  |   |
|--|---|--|---|
| 1. Radiator core support assembly (RH&LH)  | 2. Front strut housing (RH&LH)                | 3. Lower rear hoodledge (RH&LH)                  | A |
| 4. Upper front hoodledge (RH&LH)           | 5. Upper rear hoodledge (RH&LH)               | 6. Hoodledge reinforcement (RH&LH)               |   |
| 7. Upper side cowl top (RH&LH)             | 8. Upper front cowl top assembly              | 9. Cowl top bracket                              | B |
| 10. Upper dash                             | 11. Lower dash crossmember assembly           | 12. Lower outer battery support bracket          |   |
| 13. Lower battery support bracket          | 14. Lower dash                                | 15. Center front floor                           |   |
| 16. Front floor                            | 17. Inner sill                                | 18. Rear seat crossmember reinforcement assembly | C |
| 19. Rear floor front                       | 20. Rear floor seat belt anchor reinforcement | 21. Rear seat back support                       |   |
| 22. Rear floor rear                        | 23. Rear tie down hook                        | 24. Differential mounting bracket assembly       | D |
| 25. Rear floor side                        | 26. Front side member assembly                | 27. Front side member front extension            |   |
| 28. Front side member connector assembly   | 29. Front side member closing plate assembly  | 30. Front side member front closing plate        | E |
| 31. Front side member center closing plate | 32. Front side member rear extension          | 33. Front side member outrigger assembly         | F |
| 34. Rear seat crossmember                  | 35. 2nd rear crossmember                      | 36. Rear crossmember                             |   |
| 37. Muffler mounting bracket assembly      | 38. Rear side member assembly                 | 39. Rear side member extension                   | G |

## Body Component Parts

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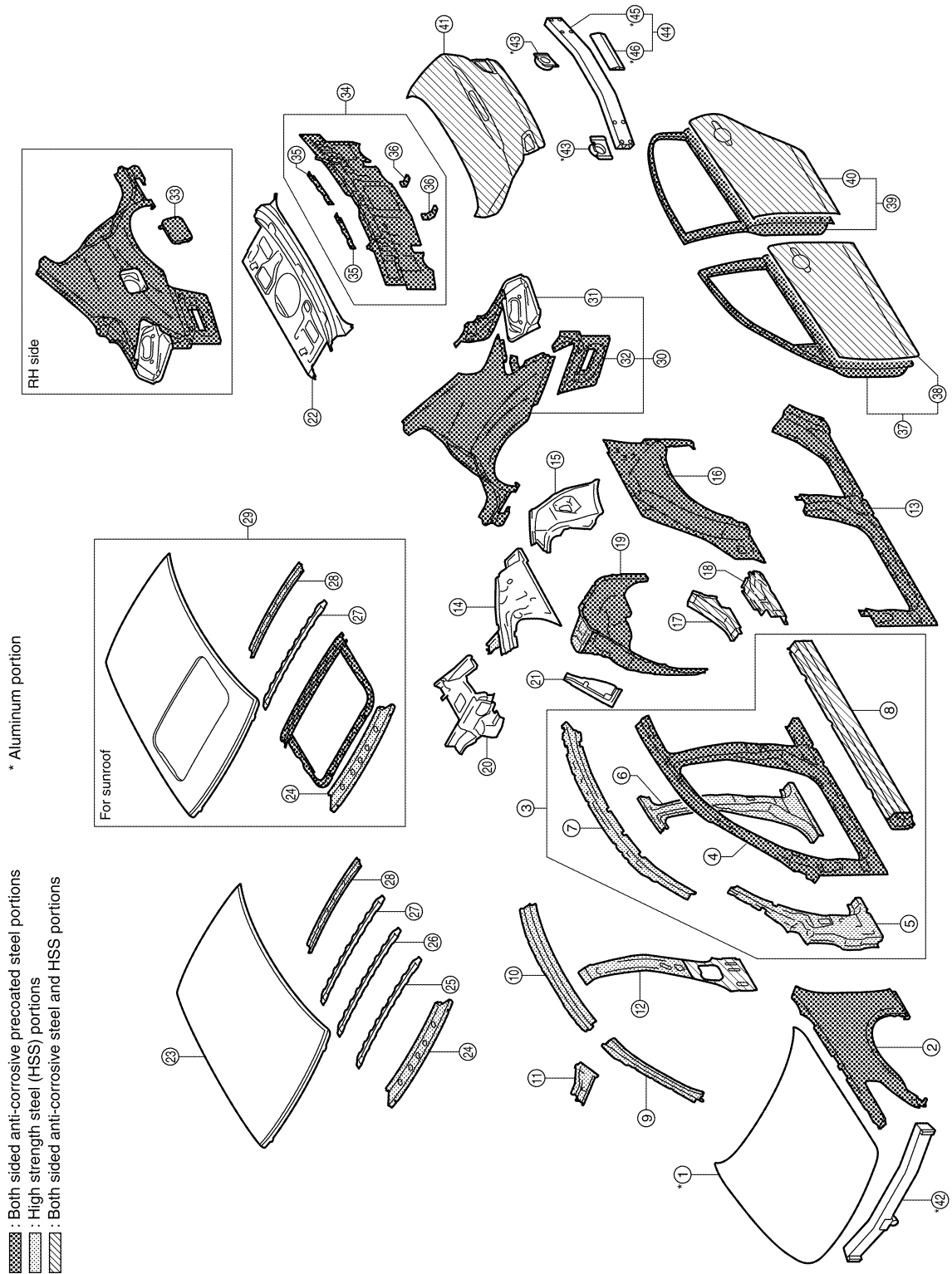
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# BODY COMPONENT PARTS

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- |   |                                     |   |
|---|-------------------------------------|---|
| 1. Hood                                       | 2. Front fender (RH&LH)             | 3. Side body assembly (RH&LH)               |
| 4. Outer front side body (RH&LH)              | 5. Front pillar brace (RH&LH)       | 6. Center pillar reinforcement (RH&LH)      |
| 7. Outer side roof rail reinforcement (RH&LH) | 8. Outer sill reinforcement (RH&LH) | 9. Inner roof rail reinforcement (RH&LH)    |
| 10. Inner side roof rail (RH&LH)              | 11. Front roof rail brace (RH&LH)   | 12. Inner center pillar (RH&LH)             |
| 13. Outer sill (RH&LH)                        | 14. Inner rear pillar (RH&LH)       | 15. Inner rear pillar reinforcement (RH&LH) |



# BODY COMPONENT PARTS

## < REMOVAL AND INSTALLATION >

|                                    |   |   |     |
|------------------------------------|---|---|-----|
| 16. Outer rear wheelhouse (RH&LH)  | 17. Upper outer rear wheelhouse extension (RH&LH)   | 18. Lower outer rear wheelhouse extension (RH&LH) | A   |
| 19. Inner rear wheelhouse (RH&LH)  | 20. Side parcel shelf (RH&LH)                       | 21. Seat back support (RH&LH)                     |     |
| 22. Parcel shelf with rear waist   | 23. Roof  | 24. Front roof rail                               | B   |
| 25. Roof bow No. 1                 | 26. Roof bow No. 2                                  | 27. Roof bow No. 3                                | B   |
| 28. Rear roof rail                 | 29. Roof assembly                                   | 30. Rear fender assembly (RH&LH)                  |     |
| 31. Tail pillar assembly (RH&LH)   | 32. Rear fender extension (RH&LH)                   | 33. Fuel filler lid                               |     |
| 34. Rear panel assembly            | 35. Rear bumper bracket                             | 36. Rear side bumper bracket                      | C   |
| 37. Front door assembly (RH&LH)    | 38. Outer front door panel (RH&LH)                  | 39. Rear door assembly (RH&LH)                    |     |
| 40. Outer rear door panel (RH&LH)  | 41. Trunk lid                                       | 42. Inner center front bumper reinforcement       | D   |
| 43. Rear bumper stay               | 44. Inner center rear bumper reinforcement assembly | 45. Center rear bumper reinforcement              | D   |
| 46. Rear bumper overrider assembly |   |   | E   |
|                                    |   |   | F   |
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# CORROSION PROTECTION

< REMOVAL AND INSTALLATION >

## CORROSION PROTECTION

### Description

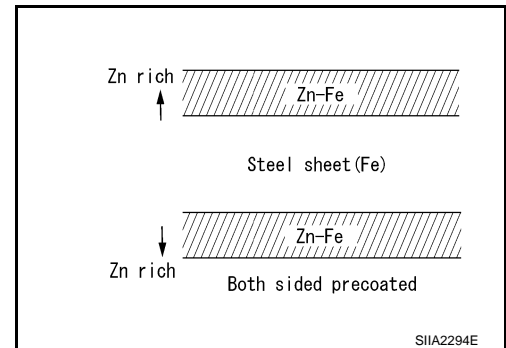
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To provide improved corrosion prevention, the following anti-corrosive measures have been implemented in NISSAN production plants. When repairing or replacing body panels, it is necessary to use the same anti-corrosive measures.

#### Anti-Corrosive Precoated Steel (Galvannealed Steel)

To improve repairability and corrosion resistance, a new type of anti-corrosive precoated steel sheet has been adopted replacing conventional zinc-coated steel sheet.

Galvannealed steel is electroplated and heated to form Zinc-iron alloy, which provides excellent and long term corrosion resistance with cationic electrodeposition primer.



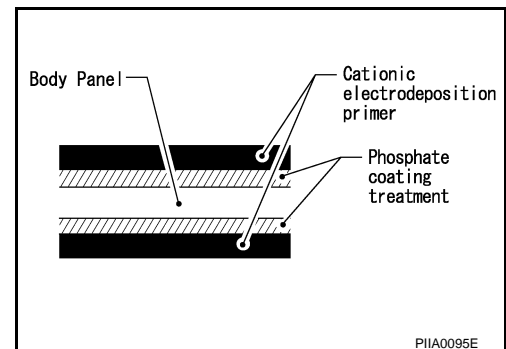
Nissan Genuine Service Parts are fabricated from galvannealed steel. Therefore, it is recommended that GENUINE NISSAN PARTS or equivalent be used for panel replacement to maintain the anti-corrosive performance built into the vehicle at the factory.

#### Phosphate Coating Treatment and Cationic Electrodeposition Primer

A phosphate coating treatment and a cationic electrodeposition primer, which provide excellent corrosion protection, are employed on all body components.

#### **CAUTION:**

**Confine paint removal during welding operations to an absolute minimum.**



Nissan Genuine Service Parts are also treated in the same manner. Therefore, it is recommended that GENUINE NISSAN PARTS or an equivalent be used for panel replacement to maintain anti-corrosive performance built into the vehicle at the factory.

### Undercoating

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The underside of the floor and wheelhouse are undercoated to prevent rust, vibration, noise and stone chipping. Therefore, when such a panel is replaced or repaired, apply undercoating to that part. Use an undercoating which is rust preventive, soundproof, vibration-proof, shock-resistant, adhesive, and durable.


#### Precautions in Undercoating


1. Do not apply undercoating to any place unless specified (such as the areas above the muffler and three way catalyst which are subjected to heat).
2. Do not undercoat the exhaust pipe or other parts which become hot.
3. Do not undercoat rotating parts.
4. Apply bitumen wax after applying undercoating.

# CORROSION PROTECTION

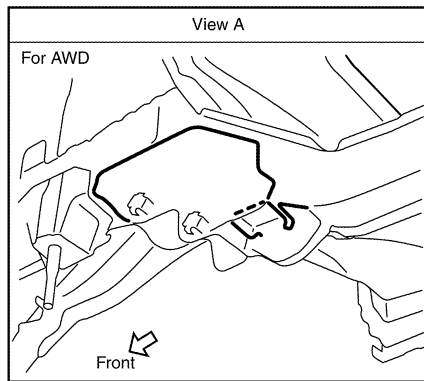
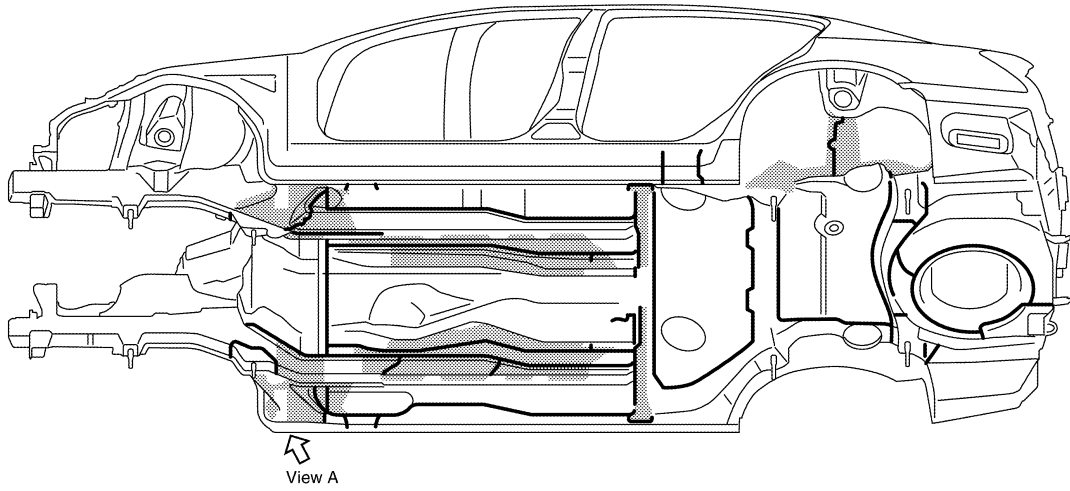
## < REMOVAL AND INSTALLATION >

5. After putting seal on the vehicle, put undercoating on it.

 : Indicates undercoated portions.

 : Indicates sealed portions.

(This figure shows 2WD)



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# BODY SEALING

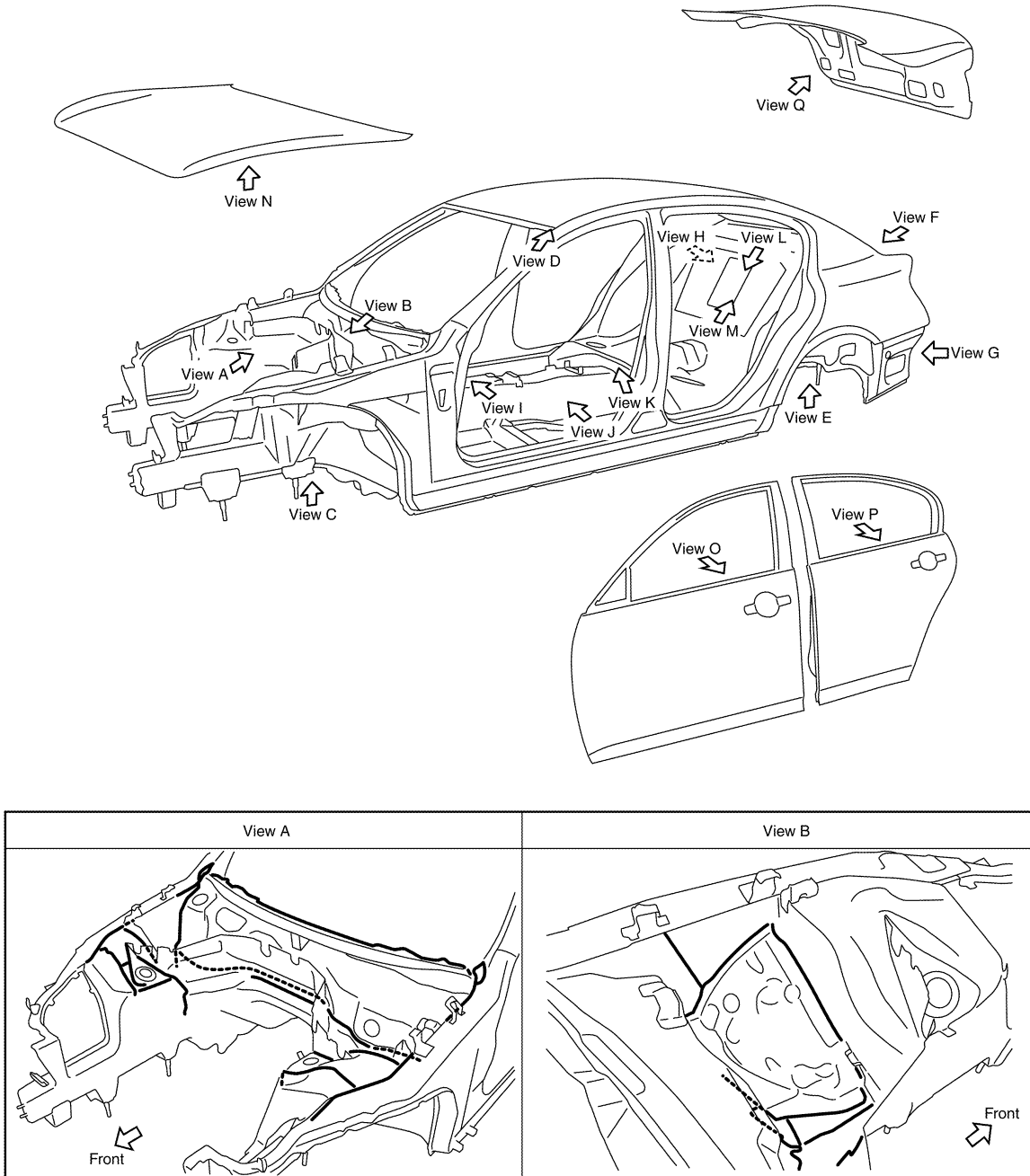
< REMOVAL AND INSTALLATION >

## BODY SEALING

### Description

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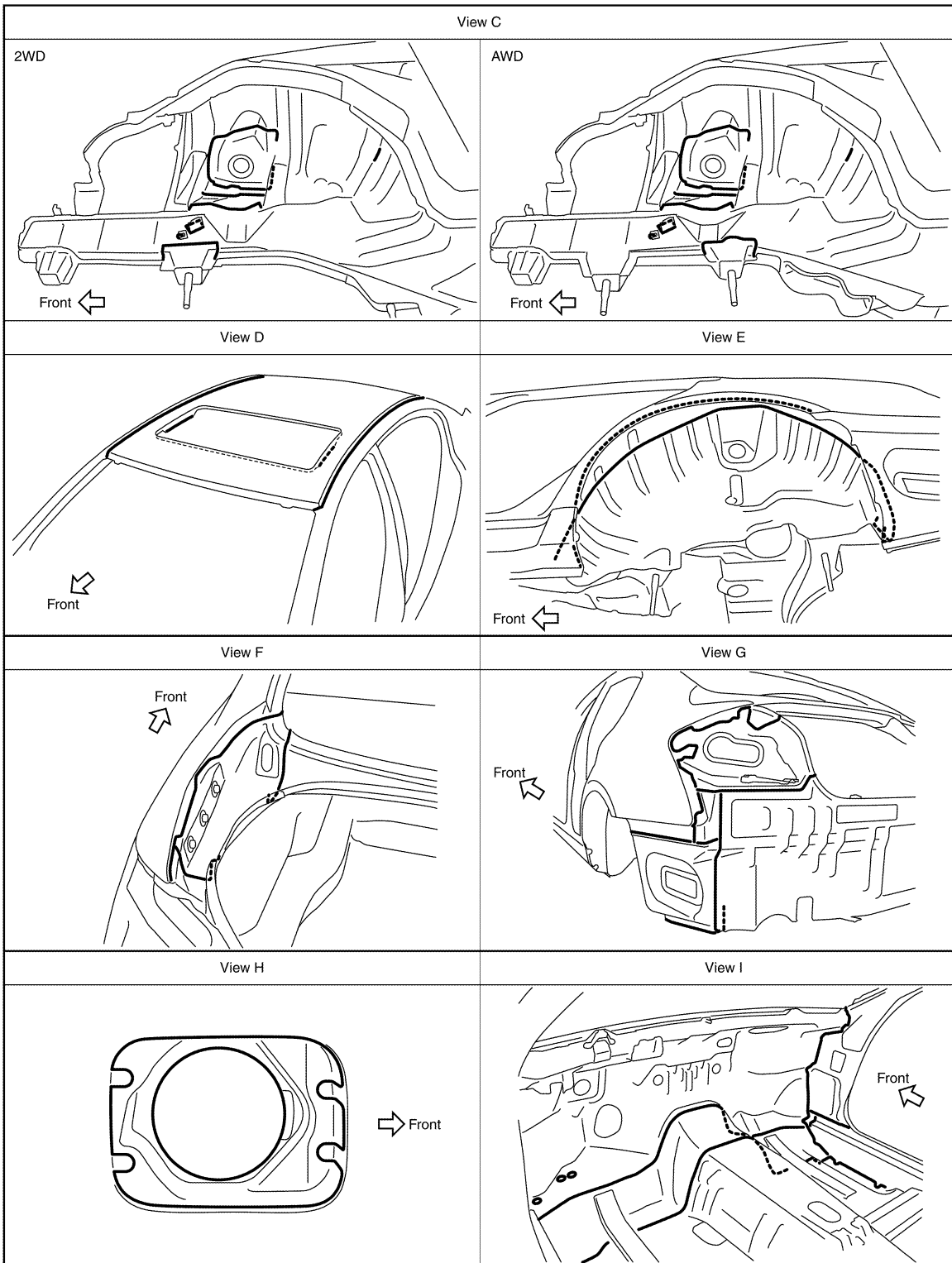
The following figure shows the areas which are sealed at the factory. Sealant which has been applied to these areas should be smooth and free from cuts or gaps. Care should be taken not to apply an excess amount of sealant and not to allow other unaffected parts to come into contact with the sealant.



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# BODY SEALING

## < REMOVAL AND INSTALLATION >



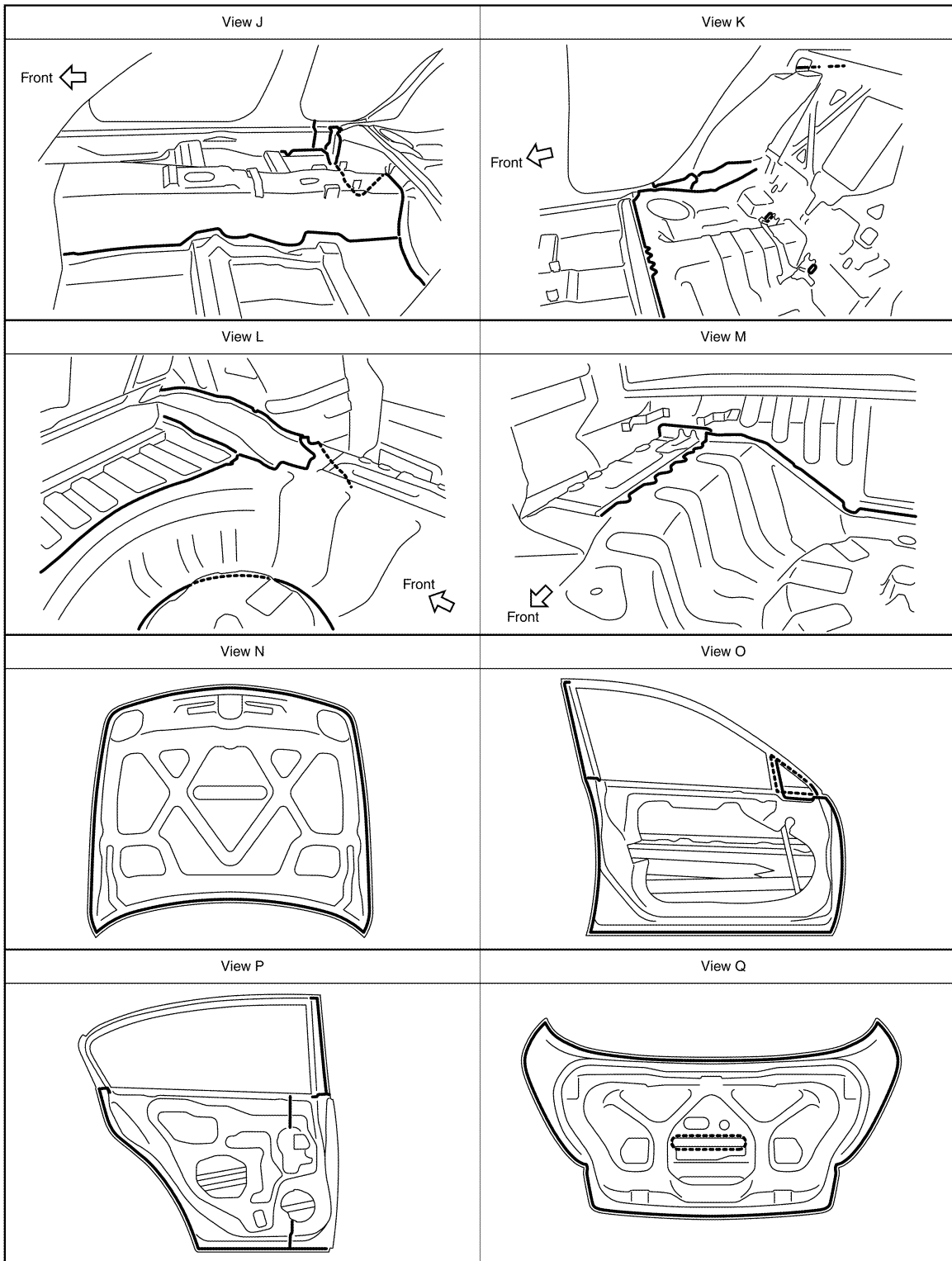
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# BODY SEALING

## < REMOVAL AND INSTALLATION >



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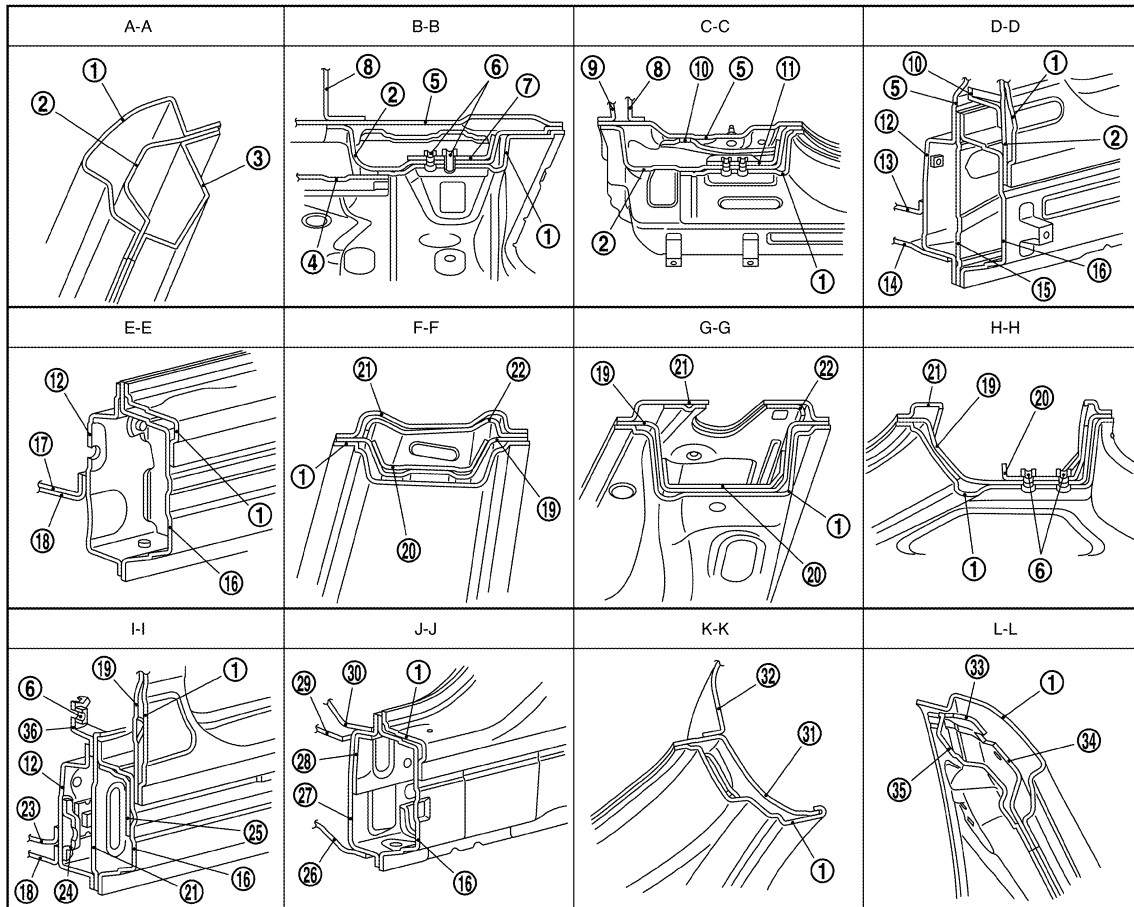
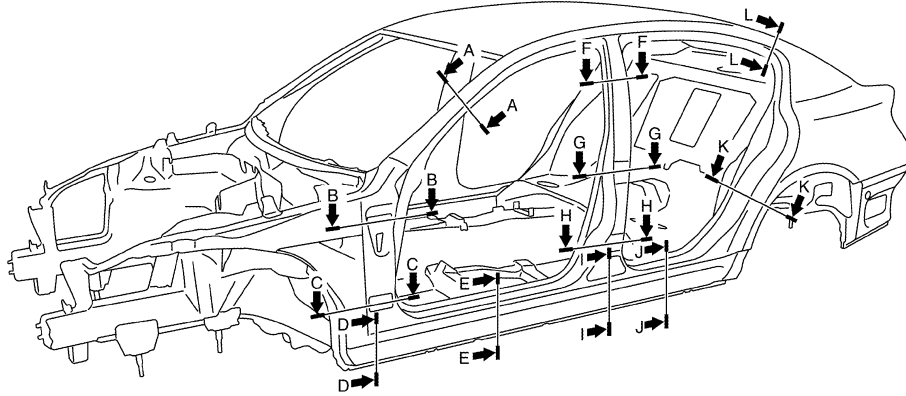
# BODY CONSTRUCTION

< REMOVAL AND INSTALLATION >

## BODY CONSTRUCTION

### Body Construction

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# BODY CONSTRUCTION

## < REMOVAL AND INSTALLATION >

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|    |                                      |    |   |    |   |
|----|--------------------------------------|----|---|----|---|
| 1  | Outer side body                      | 2  | Front pillar hinge brace                  | 3  | Inner front side roof rail                |
| 4  | Hoodledge reinforcement              | 5  | Upper rear hoodledge                      | 6  | Nut                                       |
| 7  | Upper hinge plate                    | 8  | Upper dash                                | 9  | Lower dash crossmember                    |
| 10 | Lower front pillar gusset            | 11 | Lower hinge plate                         | 12 | Inner sill                                |
| 13 | Lower dash                           | 14 | Front side member outrigger               | 15 | Lower front pillar reinforcement          |
| 16 | Outer sill reinforcement             | 17 | 2nd crossmember                           | 18 | Front floor                               |
| 19 | Center pillar reinforcement          | 20 | Center pillar seat belt reinforcement     | 21 | Upper inner center pillar                 |
| 22 | Center pillar seat belt anchor       | 23 | 3rd crossmember                           | 24 | Inner center sill reinforcement           |
| 25 | Outer center sill reinforcement      | 26 | Rear seat crossmember                     | 27 | Rear side member front                    |
| 28 | Rear side member front reinforcement | 29 | Lower rear seat crossmember reinforcement | 30 | Upper rear seat crossmember reinforcement |
| 31 | Outer rear wheelhouse                | 32 | Inner rear wheelhouse                     | 33 | Side roof rail reinforcement              |
| 34 | Inner rear pillar reinforcement      | 35 | Inner rear pillar                         | 36 | Seat belt anchor bracket                  |



# BODY ALIGNMENT

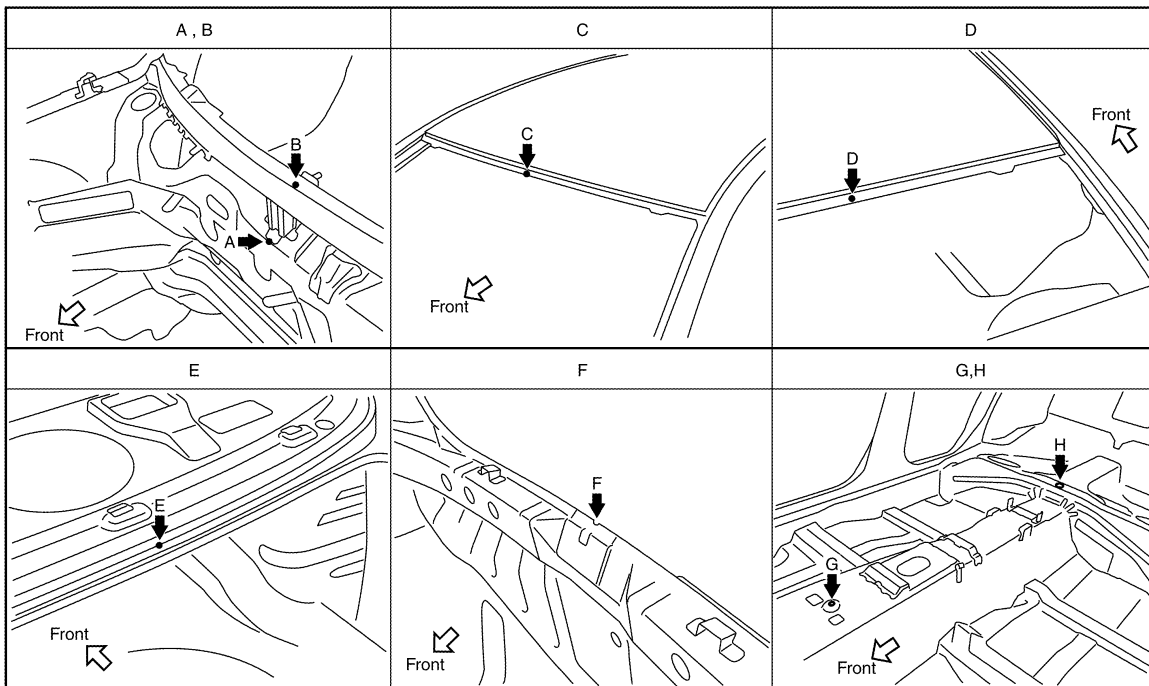
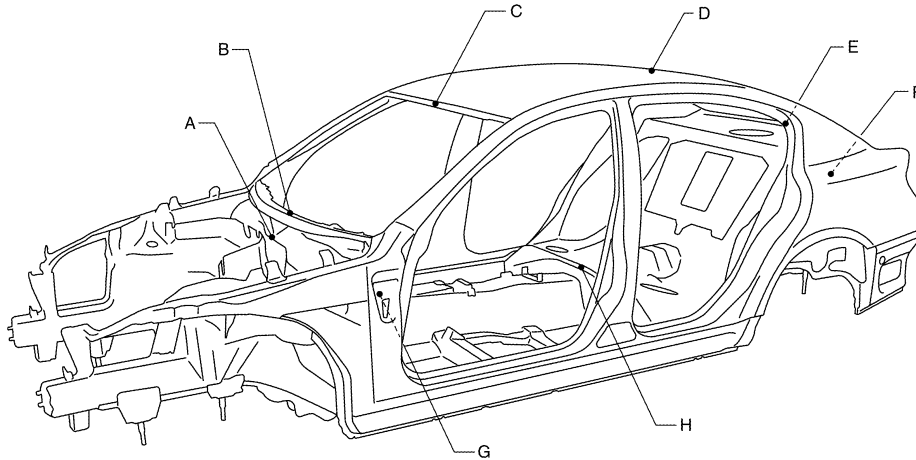
< REMOVAL AND INSTALLATION >

## BODY ALIGNMENT

### Body Center Marks

INFOID:000000000961828

A mark has been placed on each part of the body to indicate the vehicle center. When repairing parts damaged by an accident which might affect the vehicle frame (members, pillars, etc.), more accurate and effective repair will be possible by using these marks together with body alignment specifications.



JSKIA0012GB

Unit: mm (in)

| Points | Portion          | Marks                  |
|--------|------------------|------------------------|
| A, B   | Upper dash       | Embossment             |
| C      | Front roof       | Embossment             |
| D      | Rear roof        | Embossment             |
| E      | Rear waist panel | Embossment             |
| F      | Rear panel       | Indent                 |
| G      | Front floor      | Hole 14×12 (0.55×0.47) |
| H      | Rear floor       | Hole φ6 (0.24)         |

# BODY ALIGNMENT

< REMOVAL AND INSTALLATION >

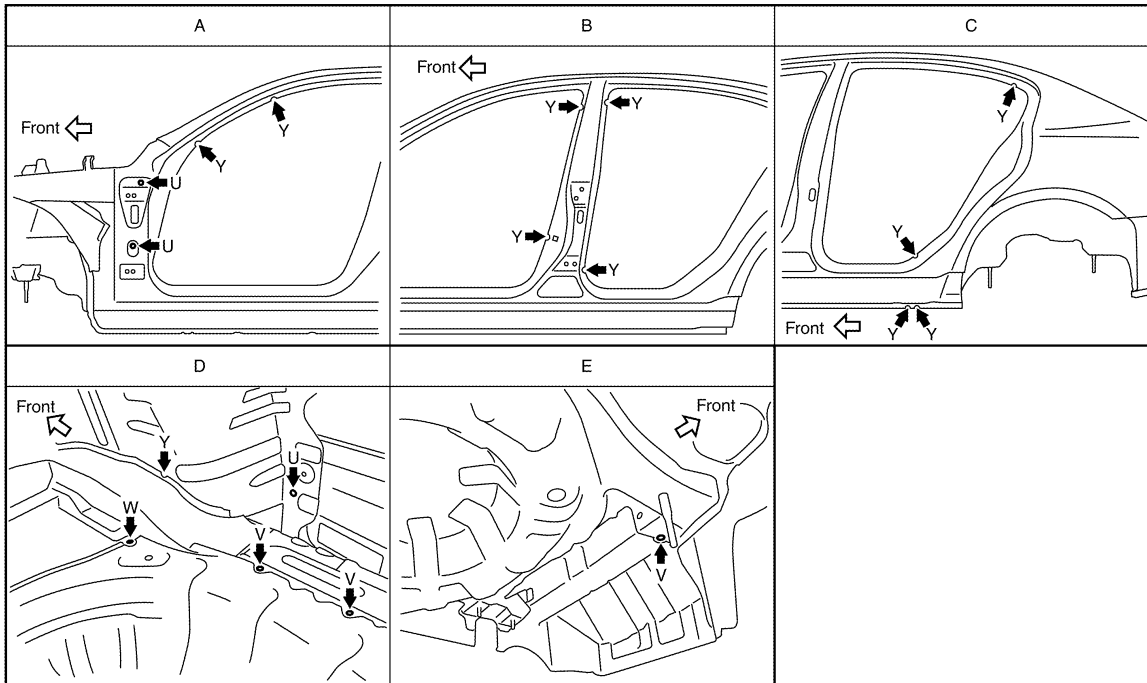
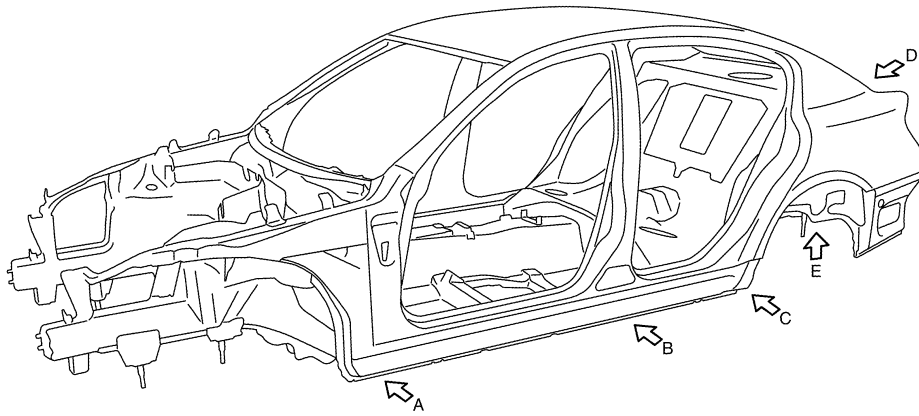
## Panel Parts Matching Marks

INFOID:000000000961829

A mark has been placed on each body panel to indicate the parts matching positions. When repairing parts damaged by an accident which might affect the vehicle structure (members, pillars, etc.), more accurate and effective repair will be possible by using these marks together with body alignment specifications.



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JSKIA0014GB

## Description

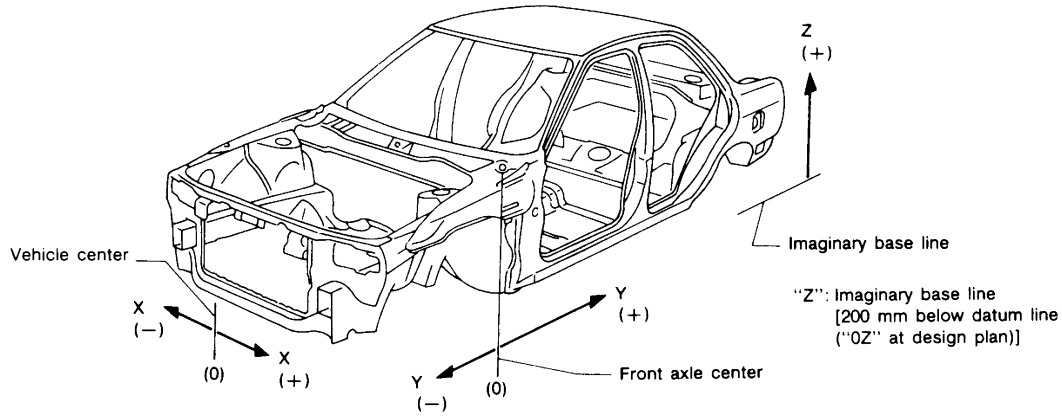
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- All dimensions indicated in the figures are actual.
- When using a tracking gauge, adjust both pointers to equal length. Then check the pointers and gauge itself to make sure there is no free play.

# BODY ALIGNMENT

## < REMOVAL AND INSTALLATION >

- When a measuring tape is used, check to be sure there is no elongation, twisting or bending.
- Measurements should be taken at the center of the mounting holes.
- An asterisk (\*) following the value at the measuring point indicates that the measuring point on the other side is symmetrically the same value.
- The coordinates of the measurement points are the distances measured from the standard line of "X", "Y" and "Z".



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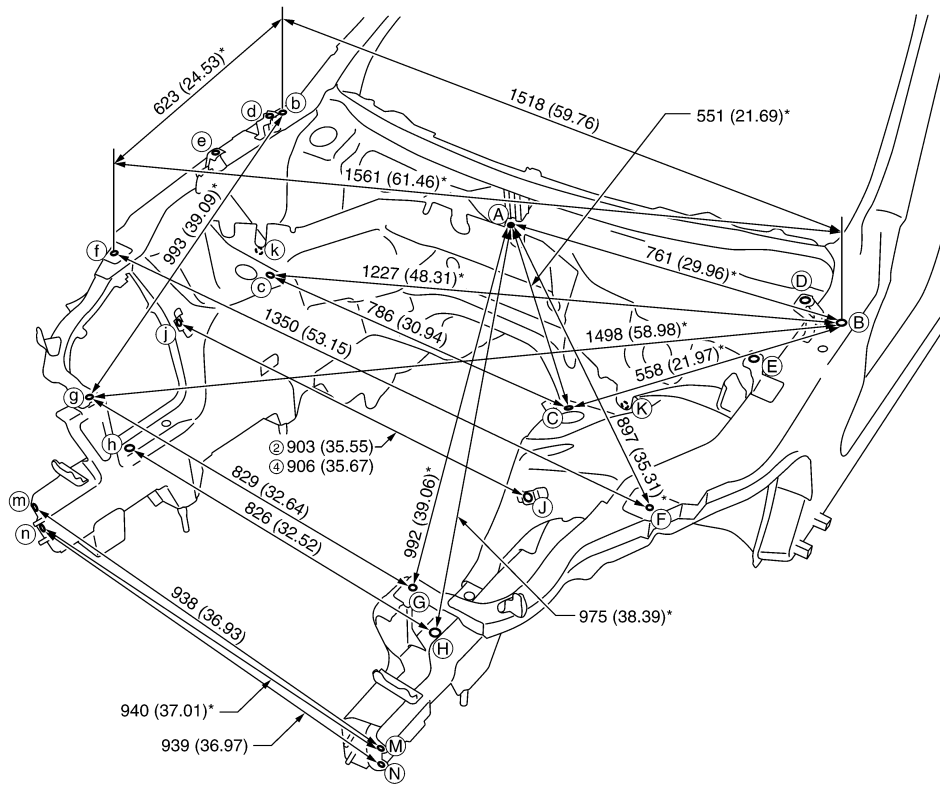
## Engine Compartment

### Measurement

Figures marked with a (\*) indicate symmetrically identical dimensions on both right and left hand of the vehicle.

②: 2WD    ④: AWD

Unit : mm (in)



JSKIA0015GB

«Engine room»

A  
B  
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L  
M  
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O  
P

BRM

# BODY ALIGNMENT

## < REMOVAL AND INSTALLATION >

Unit: mm (in)

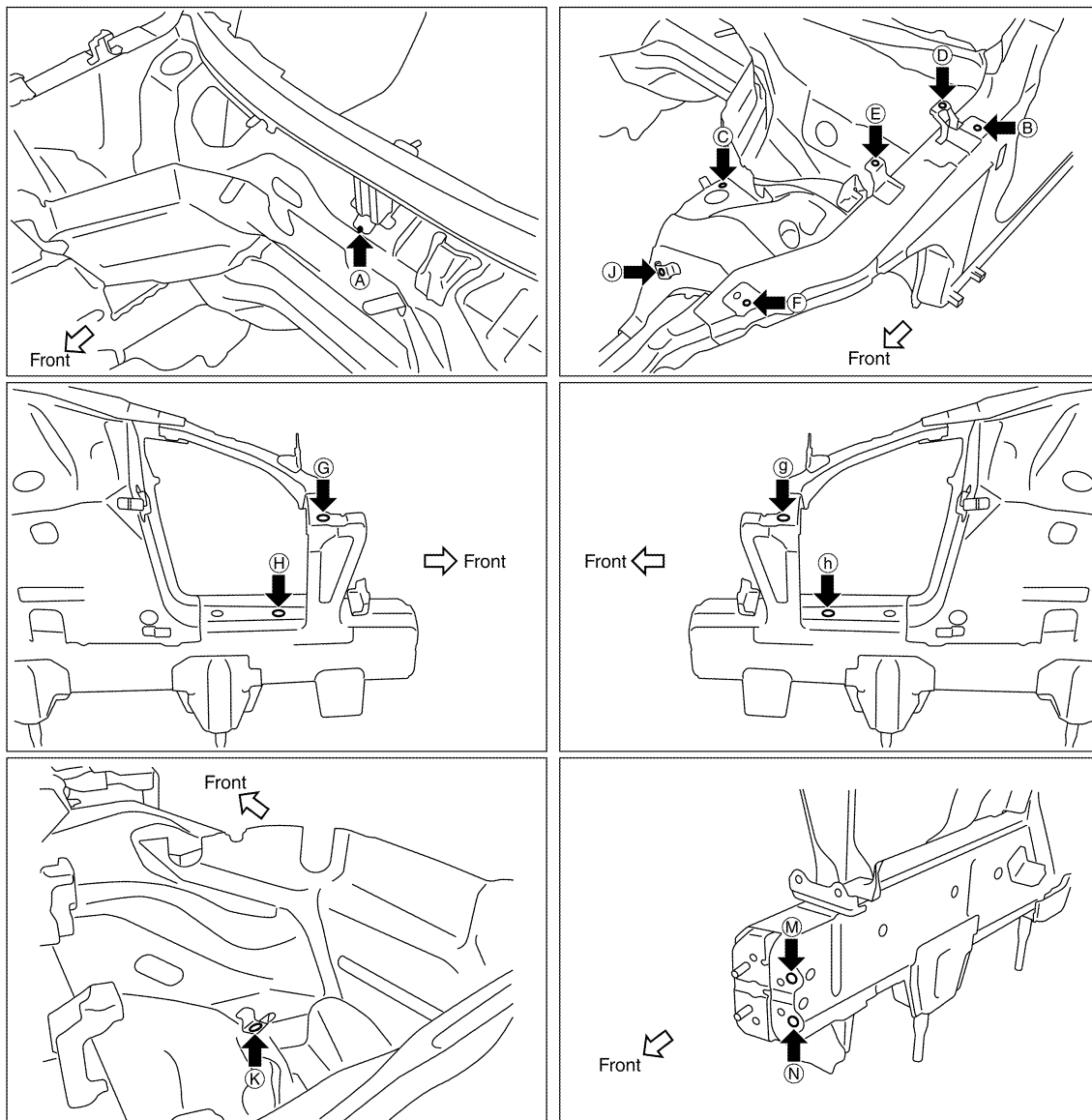
| Point | Dimension    | Memo | Point | Dimension     | Memo | Point | Dimension    | Memo | Point | Dimension    | Memo |
|-------|--------------|------|-------|---------------|------|-------|--------------|------|-------|--------------|------|
| A - B | 761 (29.96)* |      | B - C | 558 (21.97)*  |      | C - c | 786 (30.94)  |      | M - m | 938 (36.93)  |      |
| A - C | 551 (21.69)* |      | B - c | 1227 (48.31)* |      | F - f | 1350 (53.15) |      | M - n | 940 (37.01)* |      |
| A - F | 897 (35.31)* |      | B - f | 1561 (61.46)* |      | G - g | 829 (32.64)  |      | N - n | 939 (36.97)  |      |
| A - G | 992 (39.06)* |      | b - f | 623 (24.53)*  |      | H - h | 826 (32.52)  |      |       |              |      |
| A - H | 975 (38.39)* |      | B - g | 1498 (58.98)* |      | J - j | 903 (35.55)  | 2WD  |       |              |      |
| B - b | 1518 (59.76) |      | b - g | 993 (39.09)*  |      | J - j | 906 (35.67)  | AWD  |       |              |      |

«The others»

Unit: mm (in)

| Point | Dimension    | Memo | Point | Dimension    | Memo | Point | Dimension    | Memo | Point | Dimension   | Memo |
|-------|--------------|------|-------|--------------|------|-------|--------------|------|-------|-------------|------|
| A - D | 706 (27.80)* |      | C - j | 875 (34.45)* | 2WD  | D - d | 1393 (54.84) |      | K - k | 903 (35.55) | 2WD  |
| A - E | 734 (28.90)* |      | C - j | 878 (34.57)* | AWD  | E - e | 1374 (54.09) |      | K - k | 906 (35.67) | AWD  |

### Measurement Points



JSKIA0016GB

# BODY ALIGNMENT

## < REMOVAL AND INSTALLATION >

Unit: mm (in)

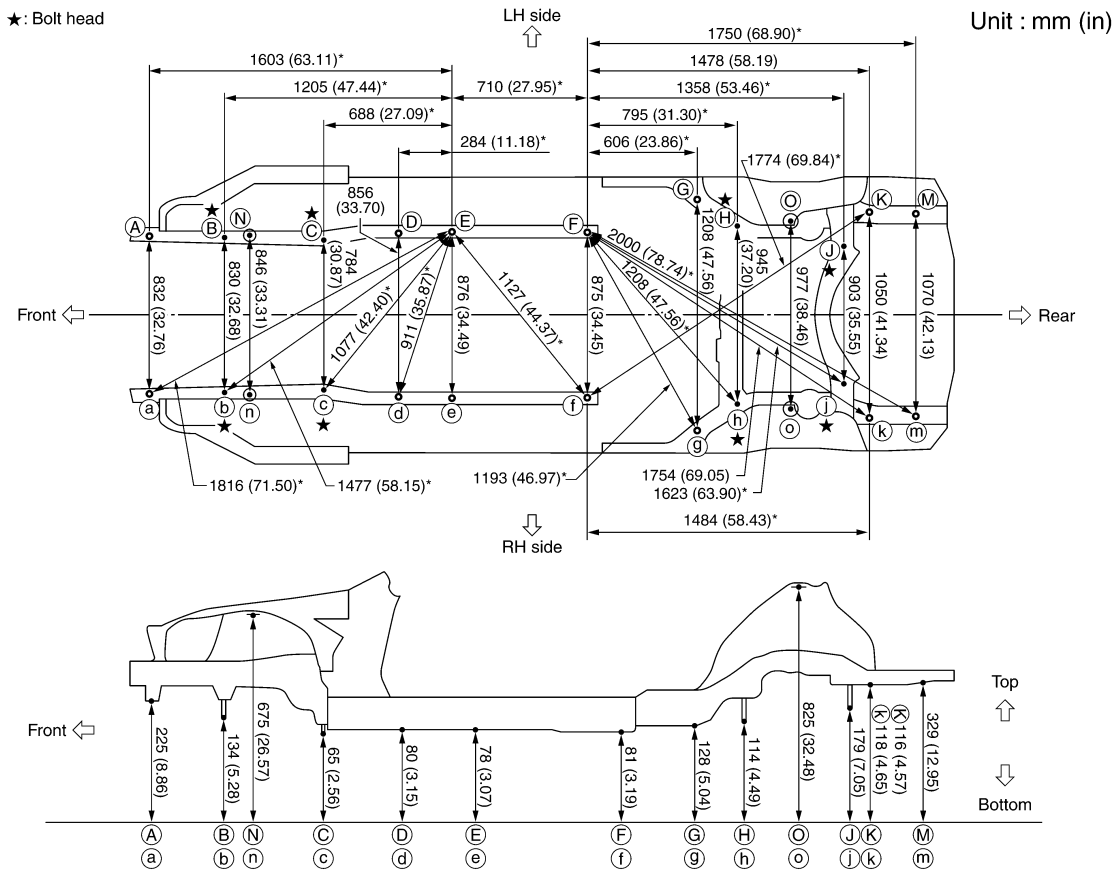
| Point      | Material   | Point      | Material  |
|------------|--|------------|---|
| A          | Upper dash positioning mark enter of center positioning mark | G, g       | Radiator core support hole center $\phi$ 6 (0.24)         |
| B          | Hood hinge installing hole center $\phi$ 12 (0.47)           | H, h       | Front side member hole center $\phi$ 20 (0.79)            |
| C, c       | Front strut installing hole center $\phi$ 11 (0.43)          | J, j, K, k | Nut holder hole center $\phi$ 16 (0.63)                   |
| D, d, E, e | Front fender installing hole center $\phi$ 7 (0.28)          | M, m, N, n | Front bumper stay installing hole center $\phi$ 11 (0.43) |
| F, f       | Cowl cover installing hole center $\phi$ 6 (0.24)            |            |   |

## Underbody

INFOID:000000000961832

### Measurement (2WD)

Figures marked with a (\*) indicate symmetrically identical dimensions on both right and left hand of the vehicle.



JSKIA0017GB

Unit: mm (in)

| Point | Dimension     | Memo | Point | Dimension    | Memo | Point | Dimension     | Memo | Point | Dimension     | Memo |
|-------|---------------|------|-------|--------------|------|-------|---------------|------|-------|---------------|------|
| E - A | 1603 (63.11)* |      | E - D | 284 (11.18)* |      | F - H | 795 (31.30)*  |      | f - k | 1484 (58.43)  |      |
| E - B | 1205 (47.44)* |      | E - F | 710 (27.95)* |      | F - J | 1358 (53.46)* |      | F - M | 1750 (68.90)* |      |
| E - C | 688 (27.09)*  |      | F - G | 606 (23.86)* |      | F - K | 1478 (58.19)  |      |       |               |      |

Unit: mm (in)

| Point | Dimension   | Memo | Point | Dimension    | Memo | Point | Dimension    | Memo | Point | Dimension    | Memo |
|-------|-------------|------|-------|--------------|------|-------|--------------|------|-------|--------------|------|
| A - a | 832 (32.76) |      | D - d | 856 (33.70)  |      | H - h | 945 (37.20)  |      | M - m | 1070 (42.13) |      |
| B - b | 830 (32.68) |      | E - e | 876 (34.49)  |      | O - o | 977 (38.46)  |      |       |              |      |
| N - n | 846 (33.31) |      | F - f | 875 (34.45)  |      | J - j | 903 (35.55)  |      |       |              |      |
| C - c | 784 (30.87) |      | G - g | 1208 (47.56) |      | K - k | 1050 (41.34) |      |       |              |      |

# BODY ALIGNMENT

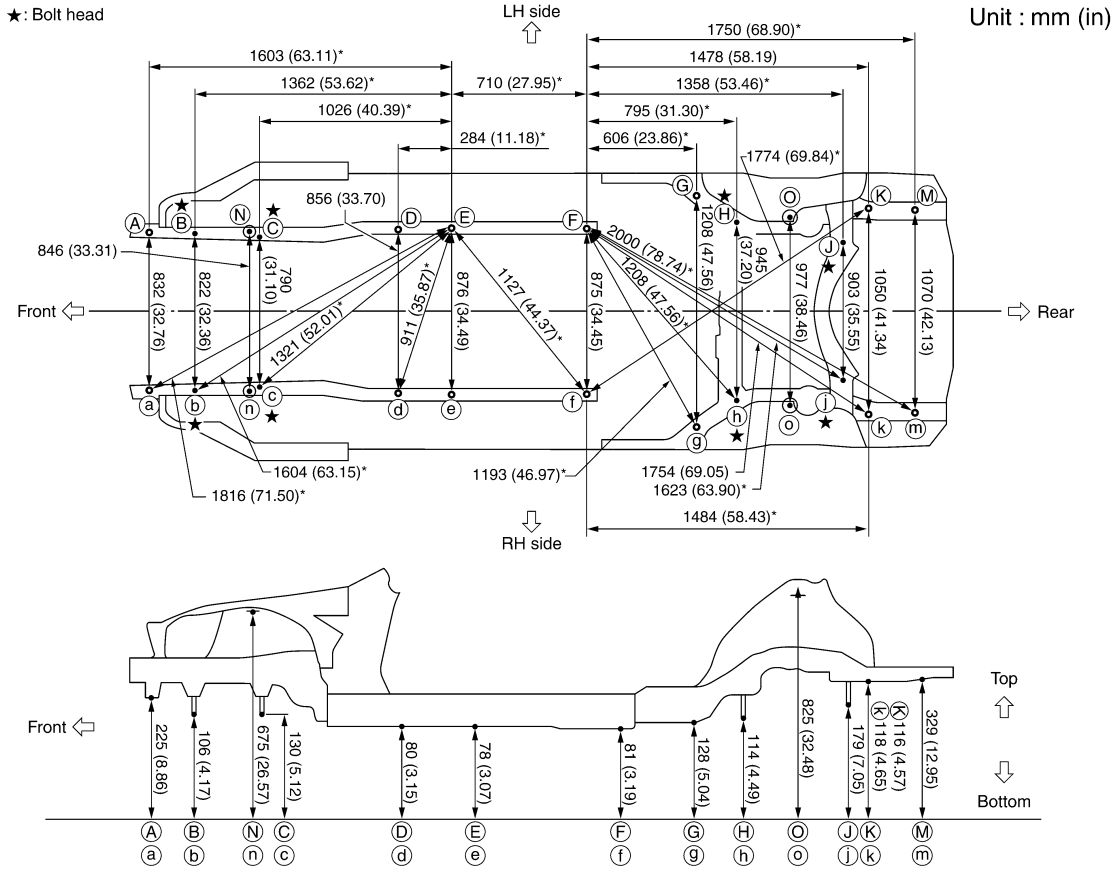
## < REMOVAL AND INSTALLATION >

Unit: mm (in)

| Point | Dimension     | Memo | Point | Dimension     | Memo | Point | Dimension     | Memo | Point | Dimension     | Memo |
|-------|---------------|------|-------|---------------|------|-------|---------------|------|-------|---------------|------|
| E - a | 1816 (71.50)* |      | E - d | 911 (35.87)*  |      | F - h | 1208 (47.56)* |      | f - K | 1774 (69.84)  |      |
| E - b | 1477 (58.15)* |      | E - f | 1127 (44.37)* |      | F - j | 1623 (63.90)* |      | F - m | 2000 (78.74)* |      |
| E - c | 1077 (42.40)* |      | F - g | 1193 (46.97)* |      | F - k | 1754 (69.05)  |      |       |               |      |

### Measurement (AWD)

Figures marked with a (\*) indicate symmetrically identical dimensions on both right and left hand of the vehicle.



JSKIA0048GB

Unit: mm (in)

| Point | Dimension     | Memo | Point | Dimension    | Memo | Point | Dimension     | Memo | Point | Dimension     | Memo |
|-------|---------------|------|-------|--------------|------|-------|---------------|------|-------|---------------|------|
| E - A | 1603 (63.11)* |      | E - D | 284 (11.18)* |      | F - H | 795 (31.30)*  |      | f - k | 1484 (58.43)  |      |
| E - B | 1362 (53.62)* |      | E - F | 710 (27.95)* |      | F - J | 1358 (53.46)* |      | F - M | 1750 (68.90)* |      |
| E - C | 1026 (40.39)* |      | F - G | 606 (23.86)* |      | F - K | 1478 (58.19)  |      |       |               |      |

Unit: mm (in)

| Point | Dimension   | Memo | Point | Dimension    | Memo | Point | Dimension    | Memo | Point | Dimension    | Memo |
|-------|-------------|------|-------|--------------|------|-------|--------------|------|-------|--------------|------|
| A - a | 832 (32.76) |      | D - d | 856 (33.70)  |      | H - h | 945 (37.20)  |      | M - m | 1070 (42.13) |      |
| B - b | 822 (32.36) |      | E - e | 876 (34.49)  |      | O - o | 977 (38.46)  |      |       |              |      |
| C - c | 790 (31.10) |      | F - f | 875 (34.45)  |      | J - j | 903 (35.55)  |      |       |              |      |
| N - n | 846 (33.31) |      | G - g | 1208 (47.56) |      | K - k | 1050 (41.34) |      |       |              |      |

Unit: mm (in)

| Point | Dimension     | Memo | Point | Dimension     | Memo | Point | Dimension     | Memo | Point | Dimension     | Memo |
|-------|---------------|------|-------|---------------|------|-------|---------------|------|-------|---------------|------|
| E - a | 1816 (71.50)* |      | E - d | 911 (35.87)*  |      | F - h | 1208 (47.56)* |      | f - K | 1774 (69.84)  |      |
| E - b | 1604 (63.15)* |      | E - f | 1127 (44.37)* |      | F - j | 1623 (63.90)* |      | F - m | 2000 (78.74)* |      |
| E - c | 1321 (52.01)* |      | F - g | 1193 (46.97)* |      | F - k | 1754 (69.05)  |      |       |               |      |

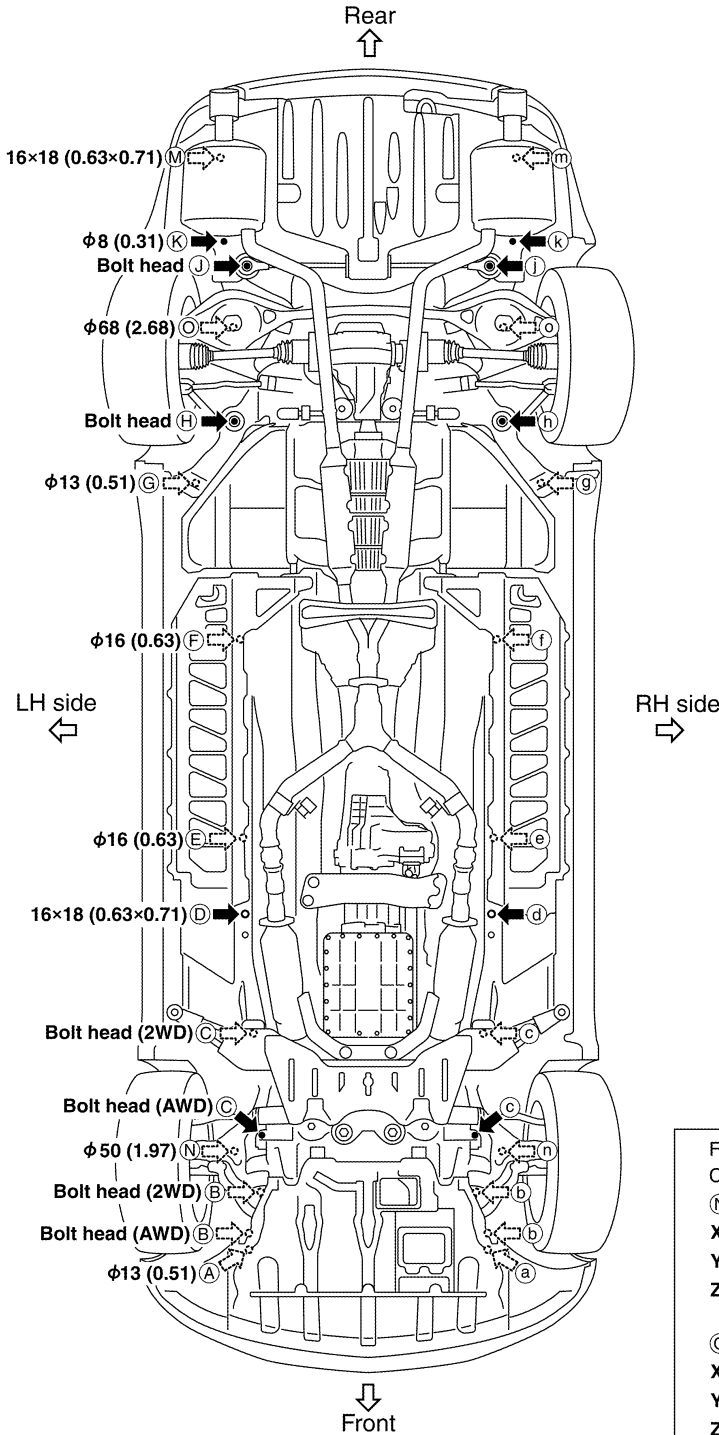
# BODY ALIGNMENT

< REMOVAL AND INSTALLATION >

## Measurement Points

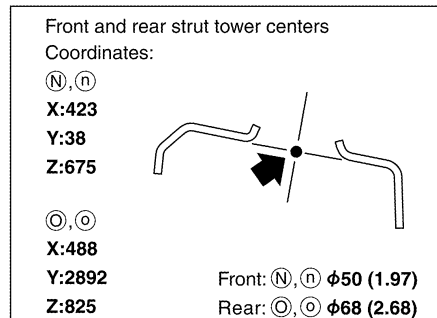
As viewed from underside.

Unit : mm (in)



Coordinates:

|            |        |
|------------|--------|
| (A, a)     | (G, g) |
| X:416      | X:604  |
| Y:-496     | Y:2391 |
| Z:225      | Z:128  |
| (B, b) AWD | (H, h) |
| X:411      | X:473  |
| Y:-261     | Y:2604 |
| Z:106      | Z:114  |
| (B, b) 2WD | (J, j) |
| X:415      | X:452  |
| Y:-104     | Y:3164 |
| Z:134      | Z:179  |
| (C, c) AWD | (K)    |
| X:395      | X:550  |
| Y:76       | Y:3265 |
| Z:130      | Z:116  |
| (C, c) 2WD | (k)    |
| X:392      | X:-500 |
| Y:414      | Y:3273 |
| Z:65       | Z:118  |
| (D, d)     | (M, m) |
| X:428      | X:535  |
| Y:817      | Y:3540 |
| Z:80       | Z:329  |
| (E, e)     |        |
| X:438      |        |
| Y:1100     |        |
| Z:78       |        |
| (F, f)     |        |
| X:438      |        |
| Y:1810     |        |
| Z:81       |        |



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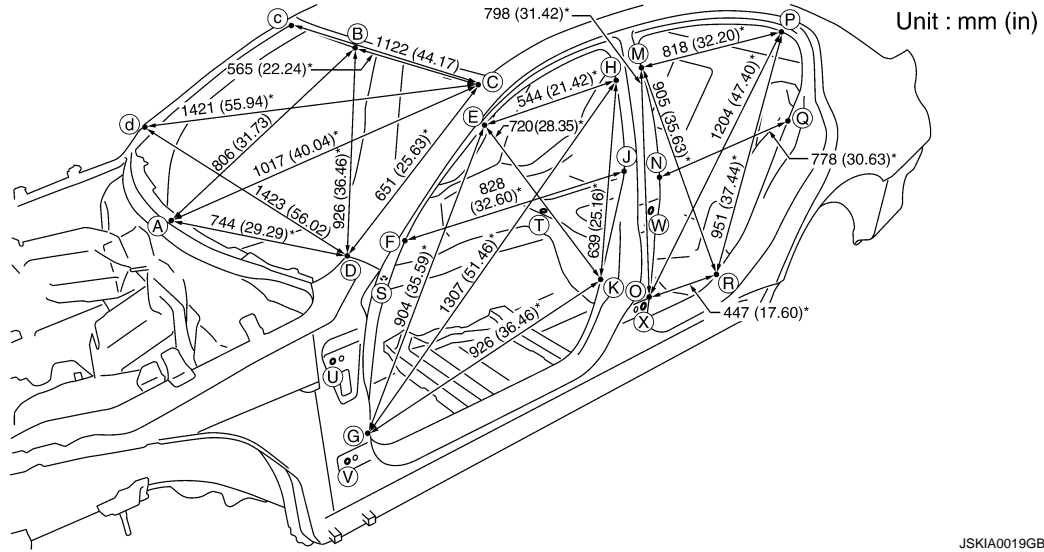
## Passenger Compartment

### Measurement

Figures marked with a (\*) indicates symmetrically identical dimensions on both right and left hand of the vehicle.

# BODY ALIGNMENT

## < REMOVAL AND INSTALLATION >



### «Front window opening»

Unit: mm (in)

| Point | Dimension     | Memo | Point | Dimension    | Memo | Point | Dimension     | Memo |
|-------|---------------|------|-------|--------------|------|-------|---------------|------|
| A - B | 806 (31.73)   |      | B - c | 565 (22.24)* |      | C - D | 651 (25.63)*  |      |
| A - C | 1017 (40.04)* |      | B - D | 926 (36.46)* |      | C - d | 1421 (55.94)* |      |
| A - D | 744 (29.29)*  |      | C - c | 1122 (44.17) |      | D - d | 1423 (56.02)  |      |

### «Front door opening»

Unit: mm (in)

| Point | Dimension    | Memo | Point | Dimension    | Memo | Point | Dimension     | Memo | Point | Dimension    | Memo |
|-------|--------------|------|-------|--------------|------|-------|---------------|------|-------|--------------|------|
| E - G | 904 (35.59)* |      | E - K | 720 (28.35)* |      | G - H | 1307 (51.46)* |      | H - K | 639 (25.16)* |      |
| E - H | 544 (21.42)* |      | F - J | 828 (32.60)* |      | G - K | 926 (36.46)*  |      |       |              |      |

### «Rear door opening»

Unit: mm (in)

| Point | Dimension    | Memo | Point | Dimension    | Memo | Point | Dimension     | Memo | Point | Dimension    | Memo |
|-------|--------------|------|-------|--------------|------|-------|---------------|------|-------|--------------|------|
| M - O | 798 (31.42)* |      | M - R | 905 (35.63)* |      | O - P | 1204 (47.40)* |      | P - R | 951 (37.44)* |      |
| M - P | 818 (32.20)* |      | N - Q | 778 (30.63)* |      | O - R | 447 (17.60)*  |      |       |              |      |

### «The others»

Unit: mm (in)

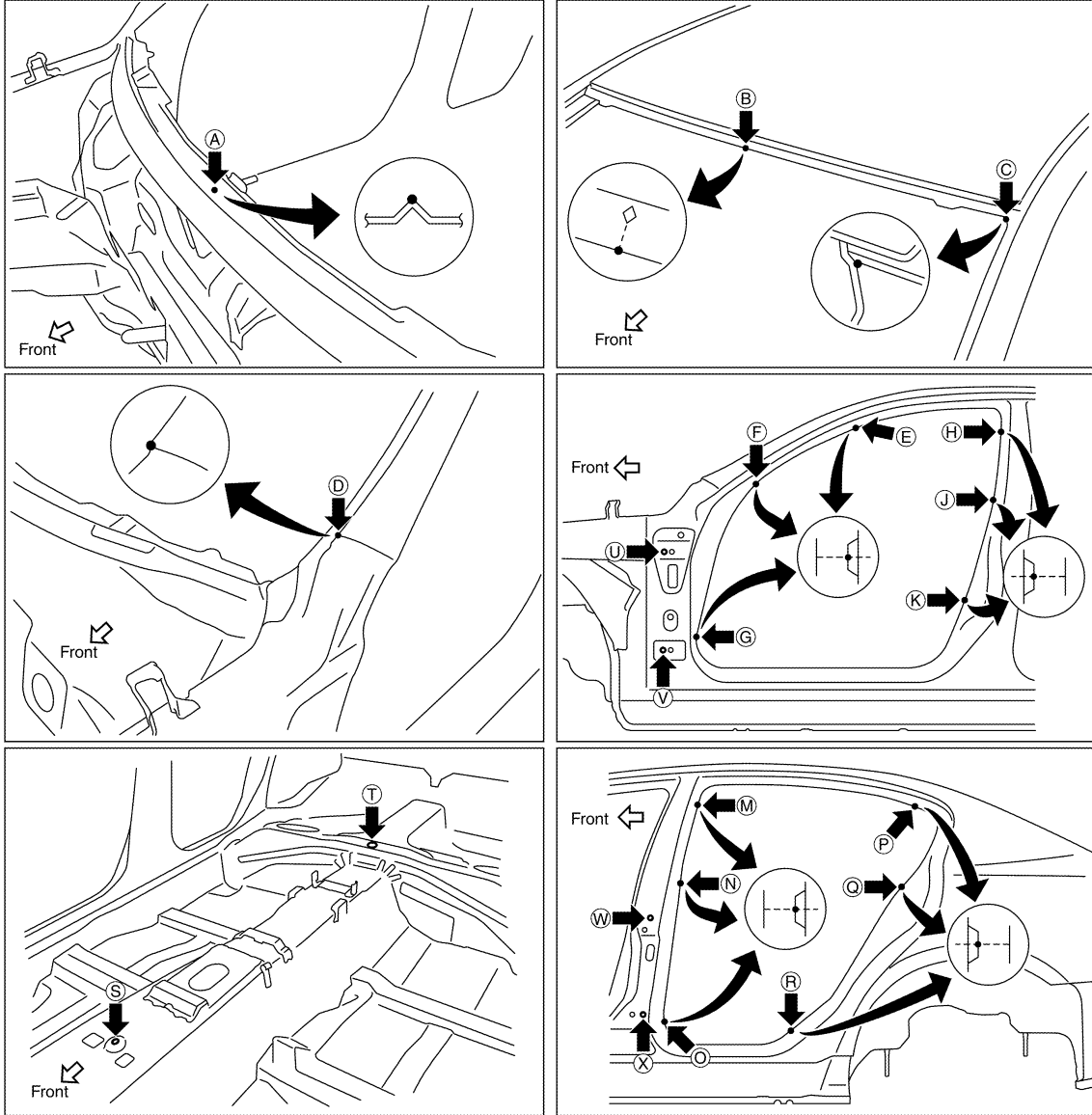
| Point | Dimension     | Memo | Point | Dimension     | Memo | Point | Dimension     | Memo | Point | Dimension     | Memo |
|-------|---------------|------|-------|---------------|------|-------|---------------|------|-------|---------------|------|
| E - e | 1249 (49.17)  |      | J - j | 1446 (56.93)  |      | P - r | 1627 (64.05)* |      | T - O | 766 (30.16)*  |      |
| E - g | 1622 (63.86)* |      | K - k | 1456 (57.32)  |      | Q - q | 1398 (55.04)  |      | T - P | 1167 (45.94)* |      |
| E - h | 1359 (53.50)* |      | M - m | 1216 (47.87)  |      | R - r | 1451 (57.13)  |      | T - Q | 1020 (40.16)* |      |
| E - k | 1529 (60.20)* |      | M - p | 1459 (57.44)* |      | S - E | 1006 (39.61)* |      | T - R | 756 (29.76)*  |      |
| F - f | 1414 (55.67)* |      | M - r | 1608 (63.31)* |      | S - F | 863 (33.98)*  |      | U - W | 1181 (46.50)* |      |
| F - j | 1652 (65.04)* |      | N - n | 1444 (56.85)  |      | S - G | 751 (29.57)*  |      | U - X | 1176 (46.30)* |      |
| G - g | 1452 (57.17)  |      | N - q | 1620 (63.78)* |      | S - H | 1299 (51.14)* |      | V - W | 1239 (48.78)* |      |
| G - h | 1874 (73.78)* |      | O - o | 1450 (57.09)  |      | S - J | 1187 (46.73)* |      | V - X | 1147 (45.16)* |      |
| G - k | 1724 (67.87)* |      | O - p | 1786 (70.31)* |      | S - K | 1033 (40.67)* |      |       |               |      |
| H - h | 1242 (48.90)  |      | O - r | 1518 (59.76)* |      | T - M | 981 (38.62)*  |      |       |               |      |
| H - k | 1489 (58.62)* |      | P - p | 1200 (47.24)  |      | T - N | 874 (34.41)*  |      |       |               |      |

## Measurement Points



# BODY ALIGNMENT

## < REMOVAL AND INSTALLATION >



A  
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Unit: mm (in)

| Point            | Material   | Point                              | Material   |
|------------------|--|------------------------------------|--|
| A                | Upper dash crossmember flange end of center positioning mark | H, h, J, j, K, k, M, m, N, n, O, o | Center pillar indent   |
| B                | Roof flange end of center positioning mark                   | P, p, Q, q, R, r                   | Rear fender indent   |
| C, c             | Front pillar joggle  | S                                  | Trans control reinforcement hole center of center positioning mark 14×12 (0.55×0.47)               |
| D, d             | Body side outer corner                                       | T                                  | Rear seat cross member reinforcement hole center of center positioning mark φ6 (0.24)              |
| E, e, F, f, G, g | Front pillar indent  | U, u, V, v, W, w, X, x             | Door hinge installing hole center<br>U, u, X, x: φ12 (0.47)<br>V, v: φ14 (0.55)<br>W, w: φ9 (0.35) |

Rear Body

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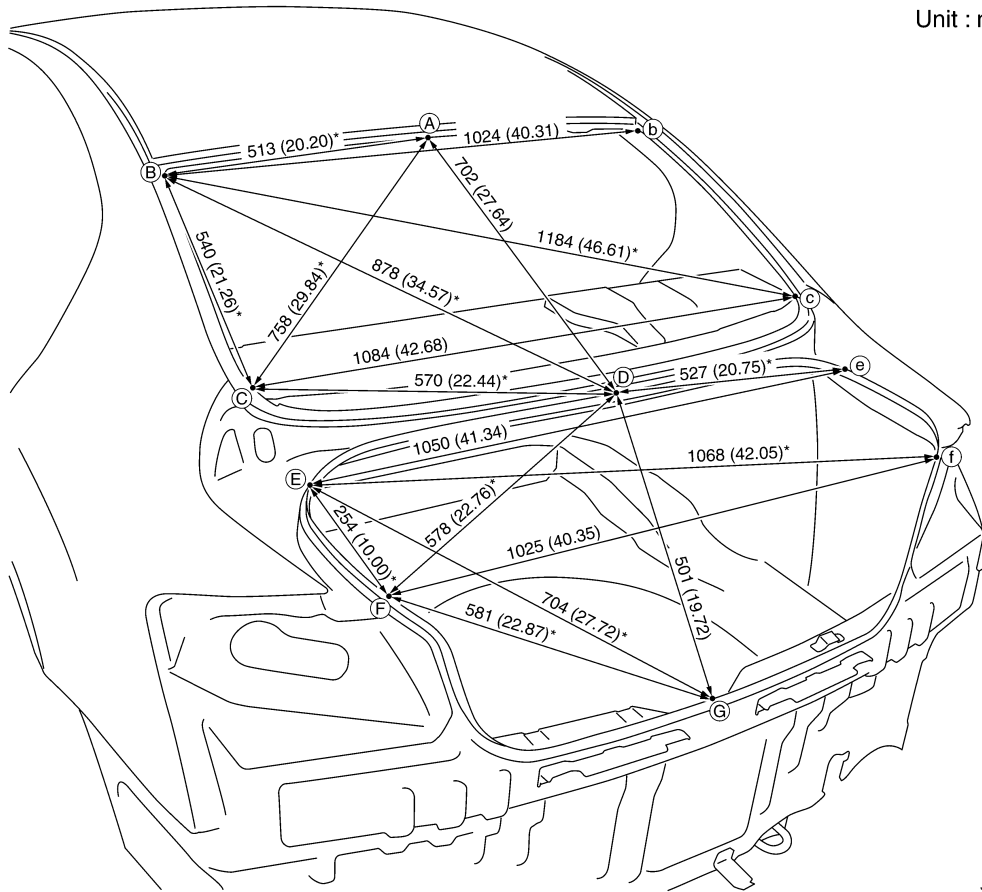
Measurement

# BODY ALIGNMENT

## < REMOVAL AND INSTALLATION >

Figures marked with a (\*) indicate symmetrically identical dimensions on both right and left hand of the vehicle.

Unit : mm (in)



JSKIA0021GB

«Rear window opening»

Unit: mm (in)

| Point | Dimension    | Memo | Point | Dimension     | Memo | Point | Dimension    | Memo |
|-------|--------------|------|-------|---------------|------|-------|--------------|------|
| A - B | 513 (20.20)* |      | B - b | 1024 (40.31)  |      | B - D | 878 (34.57)* |      |
| A - C | 758 (29.84)* |      | B - C | 540 (21.26)*  |      | C - c | 1084 (42.68) |      |
| A - D | 702 (27.64)  |      | B - c | 1184 (46.61)* |      | C - D | 570 (22.44)* |      |

«Trunk room opening»

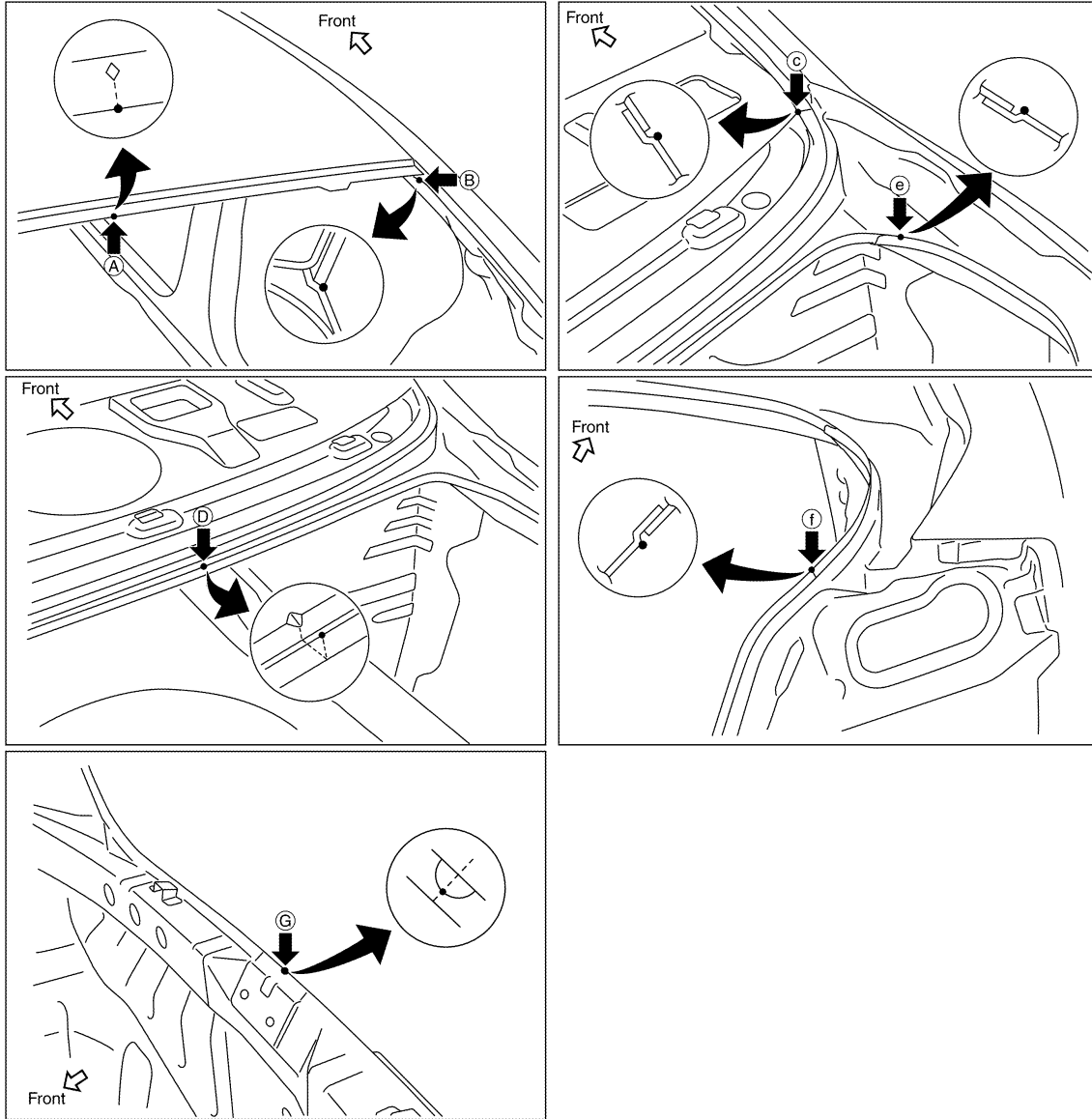
Unit: mm (in)

| Point | Dimension    | Memo | Point | Dimension     | Memo | Point | Dimension    | Memo |
|-------|--------------|------|-------|---------------|------|-------|--------------|------|
| D - e | 527 (20.75)* |      | E - e | 1050 (41.34)  |      | E - G | 704 (27.72)* |      |
| D - F | 578 (22.76)* |      | E - F | 254 (10.00)*  |      | F - f | 1025 (40.35) |      |
| D - G | 501 (19.72)  |      | E - f | 1068 (42.05)* |      | F - G | 581 (22.87)* |      |

Measurement Points

# BODY ALIGNMENT

## < REMOVAL AND INSTALLATION >



JSKIA0022GB

| Point | Material   | Point | Material                               |
|-------|--|-------|--|
| A     | Roof flange end of center positioning mark       | E, e  | Rear fender corner extension joggle    |
| B, b  | Rear fender joggle                               | F, f  | Rear combination lamp base joggle      |
| C, c  | Rear fender extension joggle                     | G     | Rear panel flange end of center indent |
| D     | Rear waist flange end of center positioning mark |       |  |

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BRM

# REPAIRING HIGH STRENGTH STEEL

< REMOVAL AND INSTALLATION >

## REPAIRING HIGH STRENGTH STEEL

### High Strength Steel (HSS)

INFOID:000000000961835

High strength steel is used for body panels in order to reduce vehicle weight.

Accordingly, precautions in repairing automotive bodies made of high strength steel are described below:

| Tensile strength  | Nissan/Infiniti designation | Major applicable parts  |
|---|-----------------------------|---|
| 373 N/mm <sup>2</sup><br>(38 kg/mm <sup>2</sup> , 54 klb/sq in)                     | SP130                       | <ul style="list-style-type: none"> <li>• Front &amp; rear side member assembly</li> <li>• Front side member closing plate assembly</li> <li>• Hoodledge assembly</li> <li>• Lower dash assembly</li> <li>• Rear seat crossmember</li> <li>• Other reinforcements</li> </ul> |
| 785 - 1350 N/mm <sup>2</sup><br>(80 - 138 kg/mm <sup>2</sup> , 114 - 196 klb/sq in) | SP150                       | <ul style="list-style-type: none"> <li>• Center pillar reinforcement (Component part)</li> <li>• Outer side roof rail reinforcement (Component part)</li> </ul>   |

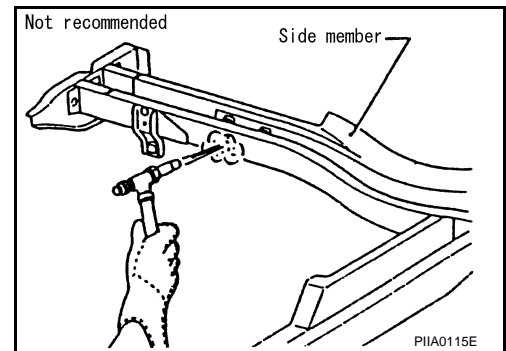
SP130 is the most commonly used HSS.

SP150 HSS is used only on parts that require much more strength.

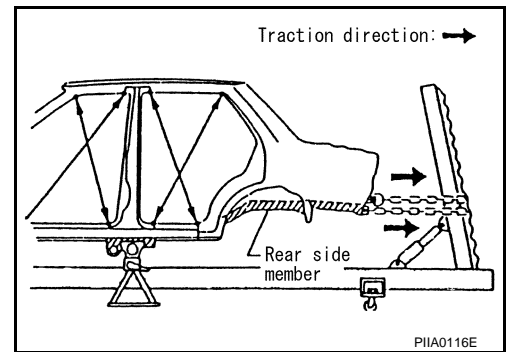
Read the following precautions when repairing HSS:

1. Additional points to consider

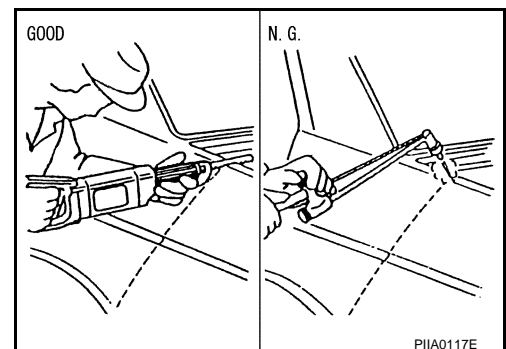
- The repair of reinforcements (such as side members) by heating is not recommended since it may weaken the component. When heating is unavoidable, do not heat HSS parts above 550°C (1,022°F). Verify heating temperature with a thermometer. (Crayon-type and other similar type thermometer are appropriate.)



- When straightening body panels, use caution in pulling any HSS panel. Because HSS is very strong, pulling may cause deformation in adjacent portions of the body. In this case, increase the number of measuring points, and carefully pull the HSS panel.



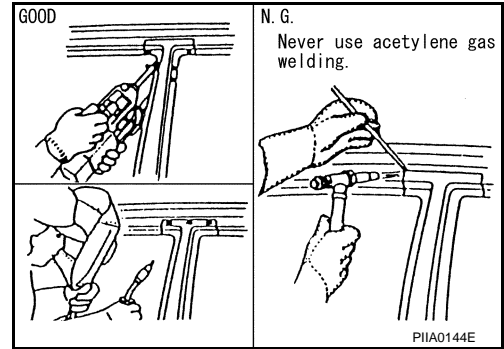
- When cutting HSS panels, avoid gas (torch) cutting if possible. Instead, use a saw to avoid weakening surrounding areas due to heat. If gas (torch) cutting is unavoidable, allow a minimum margin of 50 mm (1.97in).



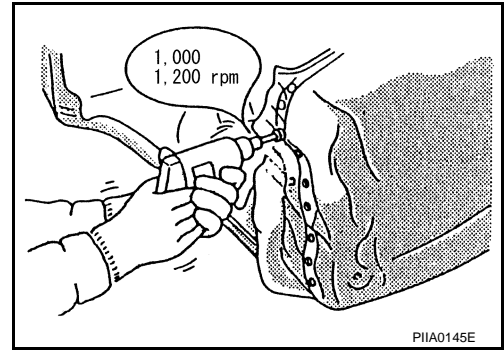
# REPAIRING HIGH STRENGTH STEEL

## < REMOVAL AND INSTALLATION >

- When welding HSS panels, use spot welding whenever possible in order to minimize weakening surrounding areas due to heat. If spot welding is impossible, use MIG. welding. Do not use gas (torch) for welding because it is inferior in welding strength.



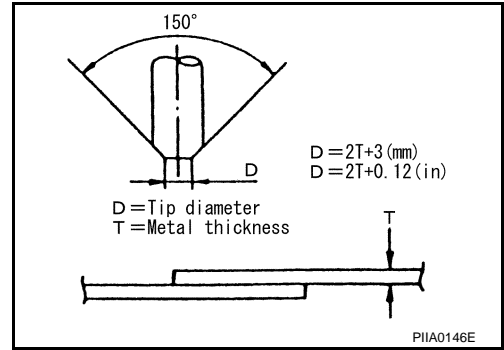
- The spot weld on HSS panels is harder than that of an ordinary steel panel. Therefore, when cutting spot welds on a HSS panel, use a low speed high torque drill (1,000 to 1,200 rpm) to increase drill bit durability and facilitate the operation.



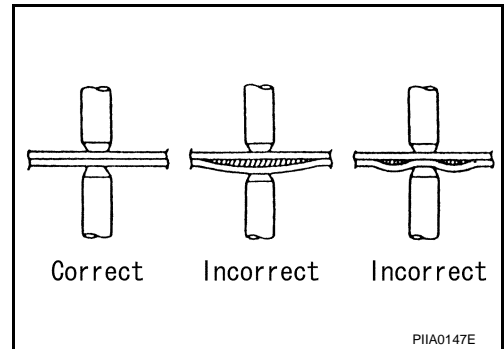
### 2. Precautions in spot welding HSS

This work should be performed under standard working conditions. Always note the following when spot welding HSS:

- The electrode tip diameter must be sized properly according to the metal thickness.



- The panel surfaces must fit flush to each other, leaving no gaps.



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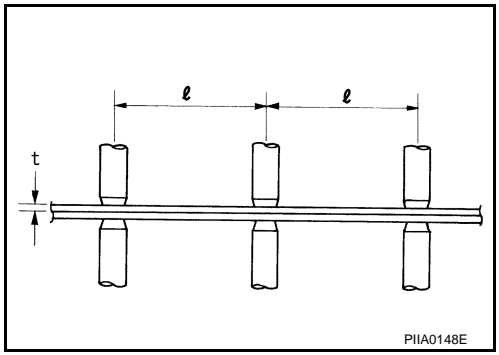
# REPAIRING HIGH STRENGTH STEEL

## < REMOVAL AND INSTALLATION >

- Follow the specifications for the proper welding pitch.

Unit: mm (in)

| Thickness (t) | Minimum pitch (l) |
|---------------|-------------------|
| 0.6 (0.024)   | 10 (0.39) or over |
| 0.8 (0.031)   | 12 (0.47) or over |
| 1.0 (0.039)   | 18 (0.71) or over |
| 1.2 (0.047)   | 20 (0.79) or over |
| 1.6 (0.063)   | 27 (1.06) or over |
| 1.8 (0.071)   | 31 (1.22) or over |



# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

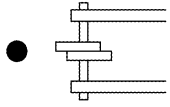
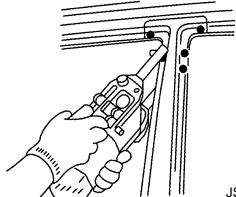
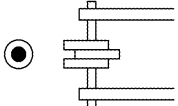
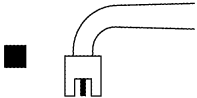


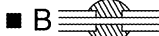
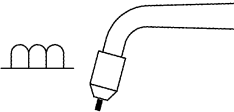
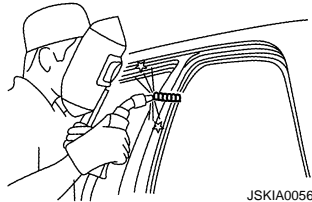
## REPLACEMENT OPERATIONS

### Description

INFOID:000000000961836

- This section is prepared for technicians who have attained a high level of skill and experience in repairing collision-damaged vehicles and also use modern service tools and equipment. Persons unfamiliar with body repair techniques should not attempt to repair collision-damaged vehicles by using this section.
- Technicians are also encouraged to read Body Repair Manual (Fundamentals) in order to ensure that the original functions and quality of the vehicle can be maintained. The Body Repair Manual (Fundamentals) contains additional information, including cautions and warning, that are not including in this manual. Technicians should refer to both manuals to ensure proper repairs.
- Please note that these information are prepared for worldwide usage, and as such, certain procedures might not apply in some regions or countries.

The symbols used in this section for welding operations are shown below.

| Symbol marks   | Description                |   |
|--|----------------------------|---|
|  <p data-bbox="427 844 511 863">JSKIA0049ZZ</p>     | 2-spot welds               |  <p data-bbox="1312 970 1396 989">JSKIA0053ZZ</p>  |
|  <p data-bbox="427 1094 511 1113">JSKIA0050ZZ</p>  | 3-spot welds               |   |
|  <p data-bbox="427 1472 511 1491">JSKIA0051ZZ</p> | MIG plug weld              |  <p data-bbox="1312 1348 1396 1367">JSKIA0054ZZ</p> <p data-bbox="1008 1381 1317 1409">For 3 panels plug weld method</p> <div style="display: flex; flex-direction: column; align-items: center;"> <div data-bbox="1143 1440 1300 1476">  <p data-bbox="1166 1451 1187 1472">A</p> </div> <div data-bbox="1143 1535 1300 1570">  <p data-bbox="1166 1545 1187 1566">B</p> </div> </div> <p data-bbox="1312 1598 1396 1617">JSKIA0055ZZ</p> |
|  <p data-bbox="427 1850 511 1869">JSKIA0052ZZ</p> | MIG seam weld / Point weld |  <p data-bbox="1312 1850 1396 1869">JSKIA0056ZZ</p>  |

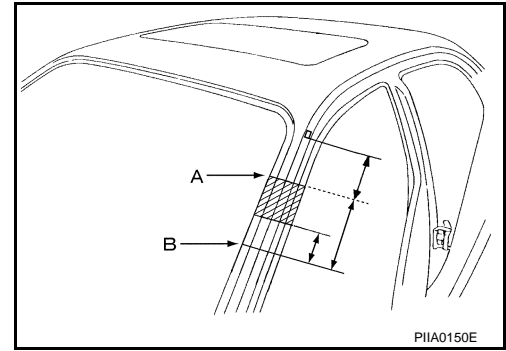
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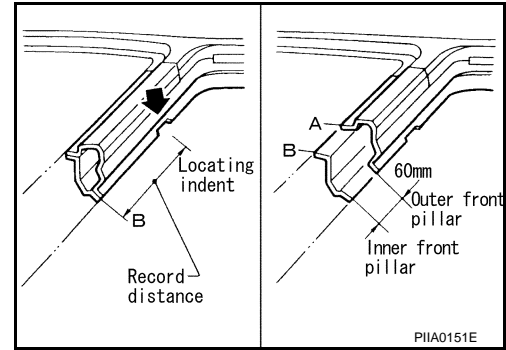
# REPLACEMENT OPERATIONS

## < REMOVAL AND INSTALLATION >

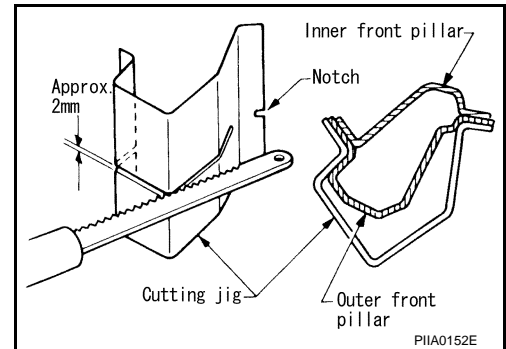
- Front pillar butt joint can be determined anywhere within shaded area as shown in the figure. The best location for the butt joint is at position A due to the construction of the vehicle. Refer to the front pillar section.



- Determine cutting position and record distance from the locating indent. Use this distance when cutting the service part. Cut outer front pillar over 60 mm (2.36 in) above inner front pillar cut position.

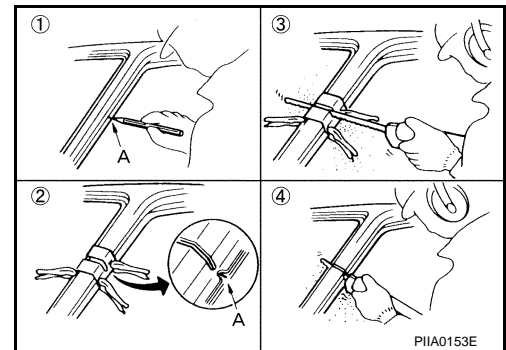


- Prepare a cutting jig to make outer pillar easier to cut. Also, this will permit service part to be accurately cut at joint position.



- An example of cutting operation using a cutting jig is as follows.

1. Mark cutting lines.  
A: Cut position of outer pillar  
B: Cut position of inner pillar
2. Align cutting line with notch on jig. Clamp jig to pillar.
3. Cut outer pillar along groove of jig (at position A).
4. Remove jig and cut remaining portions.
5. Cut inner pillar at position B in same manner.



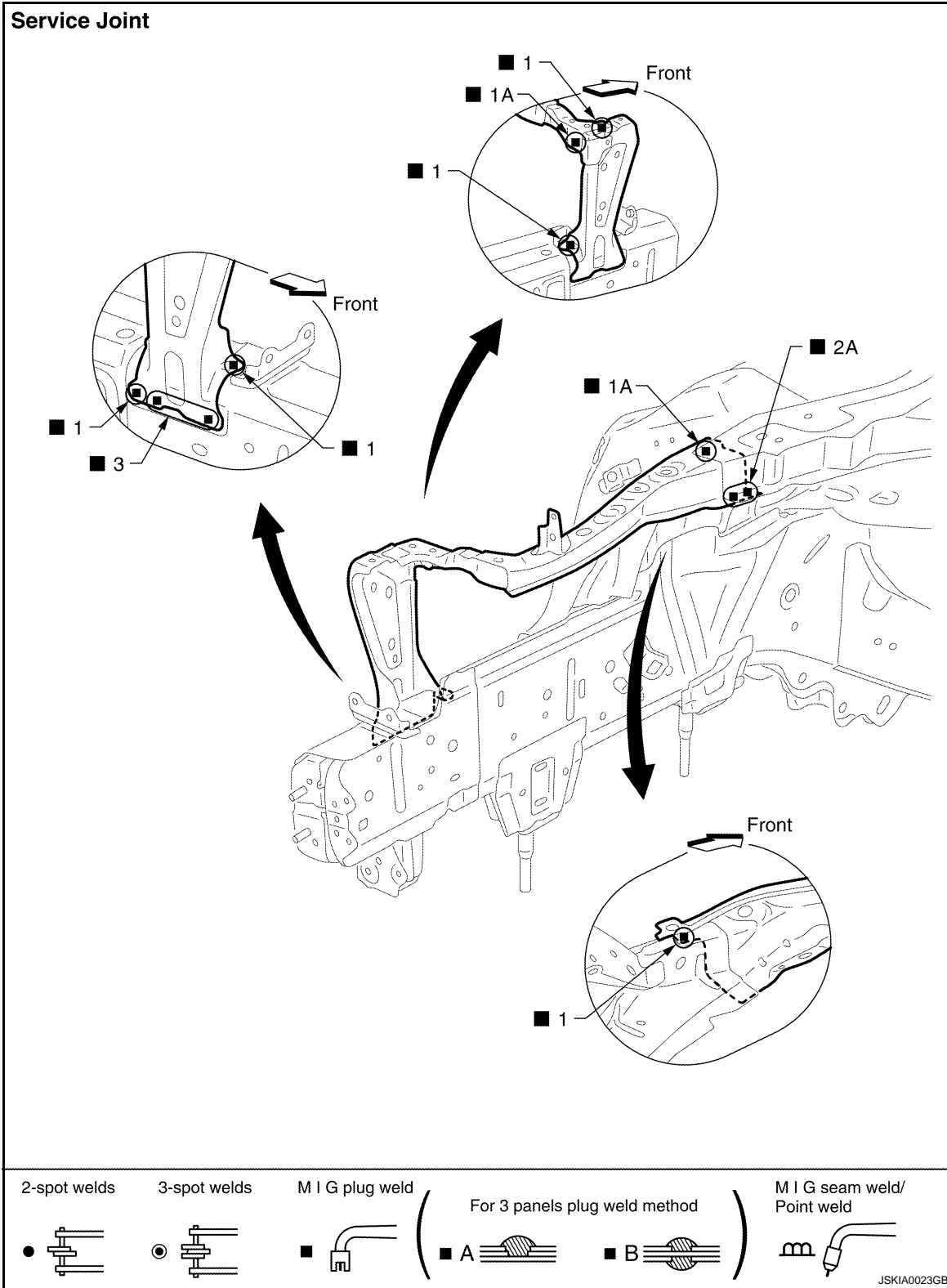
## Radiator Core Support

INFOID:000000000961837



# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >



Change parts

- Radiator core support assembly (LH)
- Front side member connector assembly (LH)

Hoodledge

INFOID:000000000961838

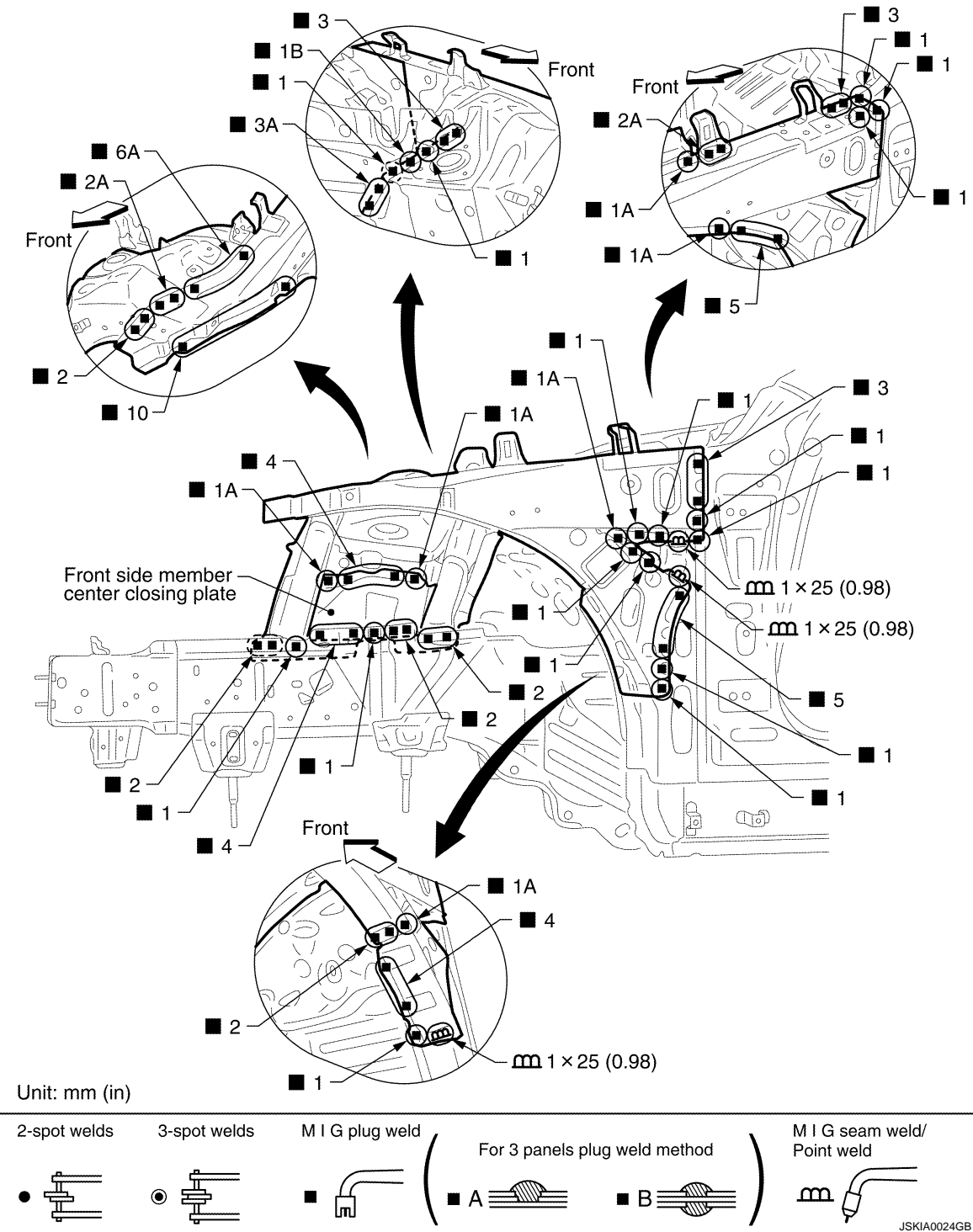
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# REPLACEMENT OPERATIONS

## < REMOVAL AND INSTALLATION >

### Service Joint

Remove the front side member center closing plate (reusable).

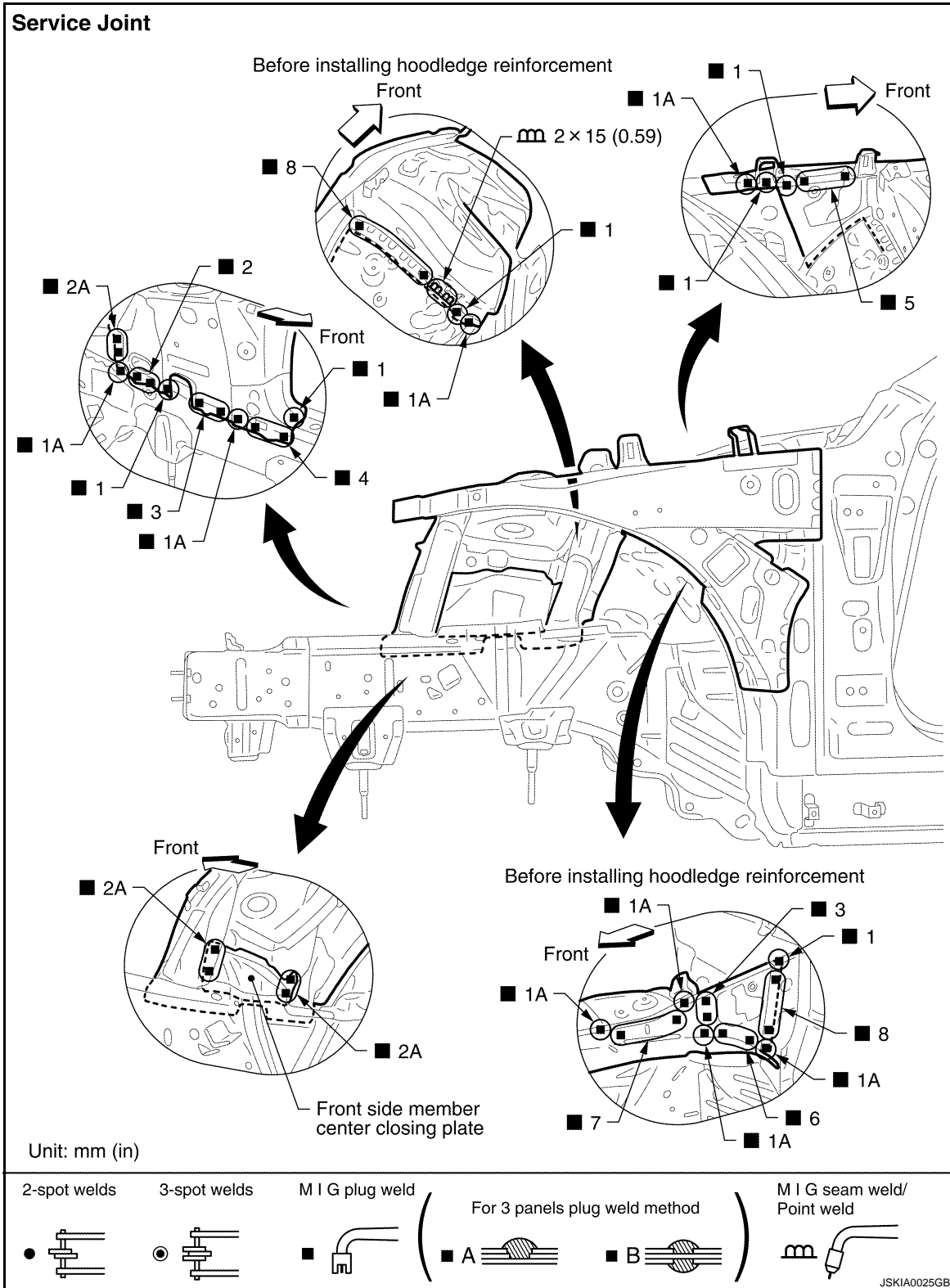


#### Change parts

- Front strut housing (LH)
- Upper front hoodledge (LH)
- Hoodledge reinforcement (LH)

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >



## Front Side Member (2WD)

Work after radiator core support and hoodledge have been removed.

INFOID:000000000961839

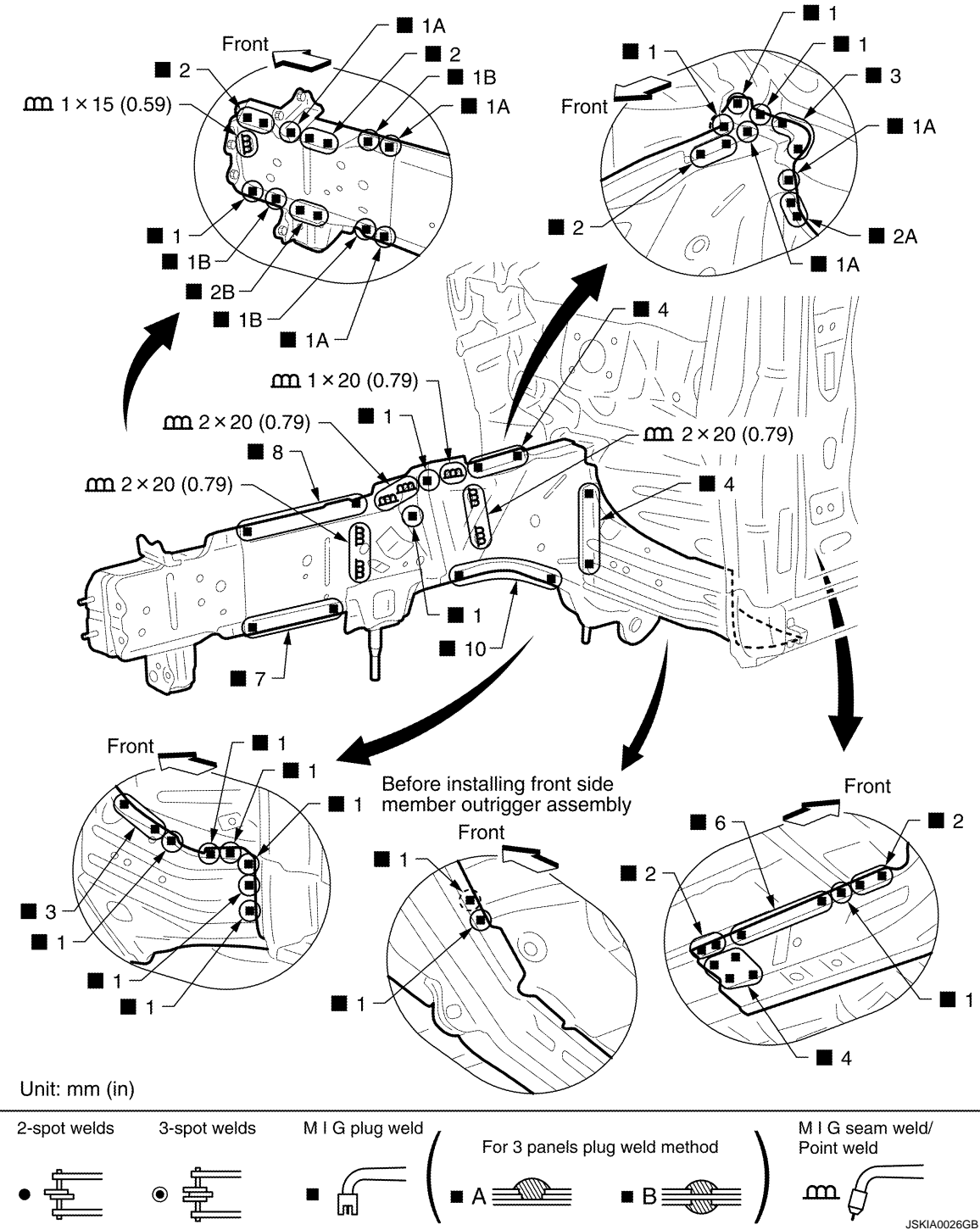
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# REPLACEMENT OPERATIONS

## < REMOVAL AND INSTALLATION >

### Service Joint

Assemble the hoodledge and check the fitting according to Body Alignment before replacing the front side member center closing plate.

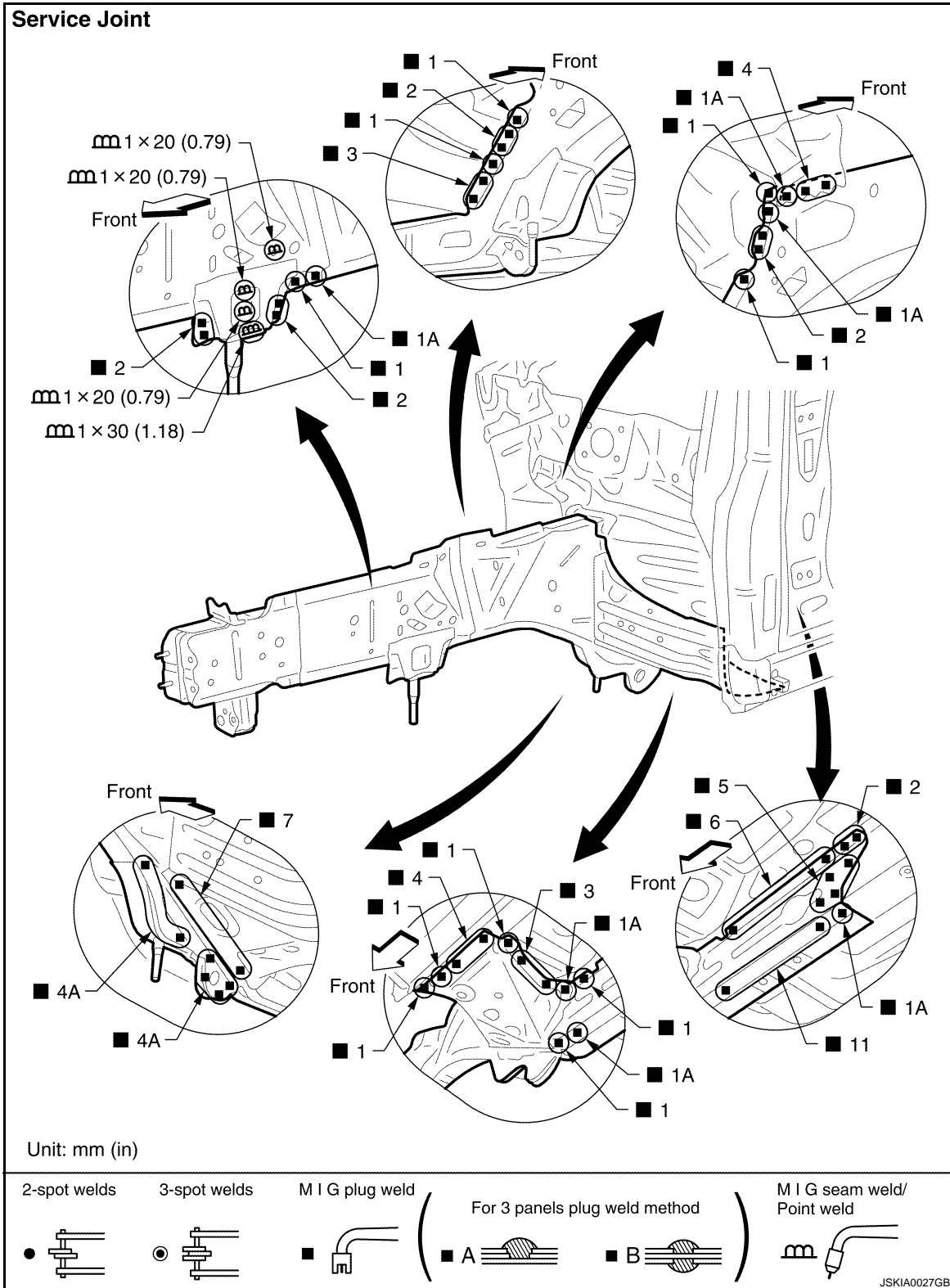


#### Change parts

- Front side member assembly (LH)
- Front side member closing plate assembly (LH)
- Front side member outrigger assembly (LH)

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >



## Front Side Member (AWD)

INFOID:000000000961840

Work after radiator core support and hoodledge have been removed.

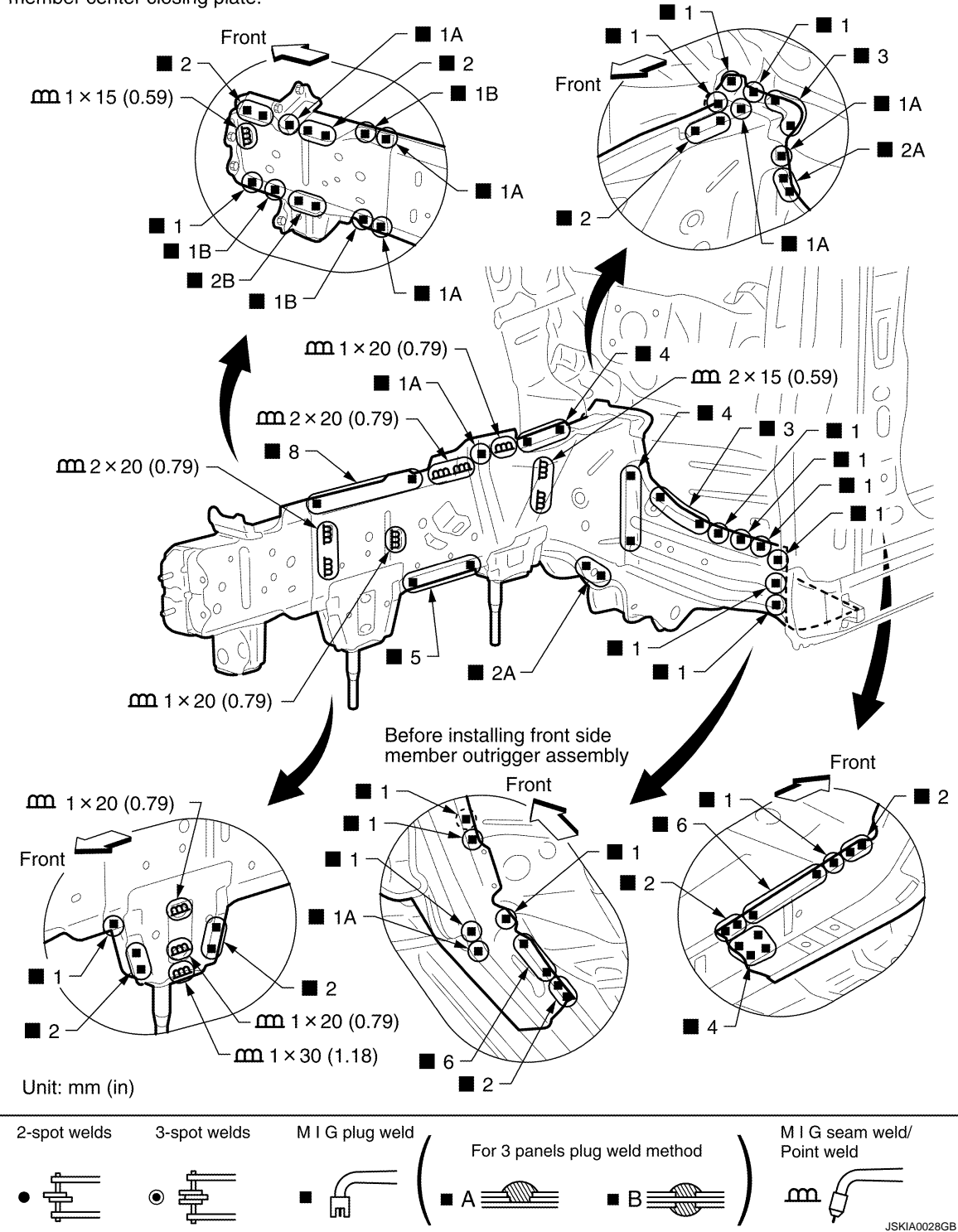
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# REPLACEMENT OPERATIONS

## < REMOVAL AND INSTALLATION >

### Service Joint

Assemble the hoodledge and check the fitting according to Body Alignment before replacing the front side member center closing plate.

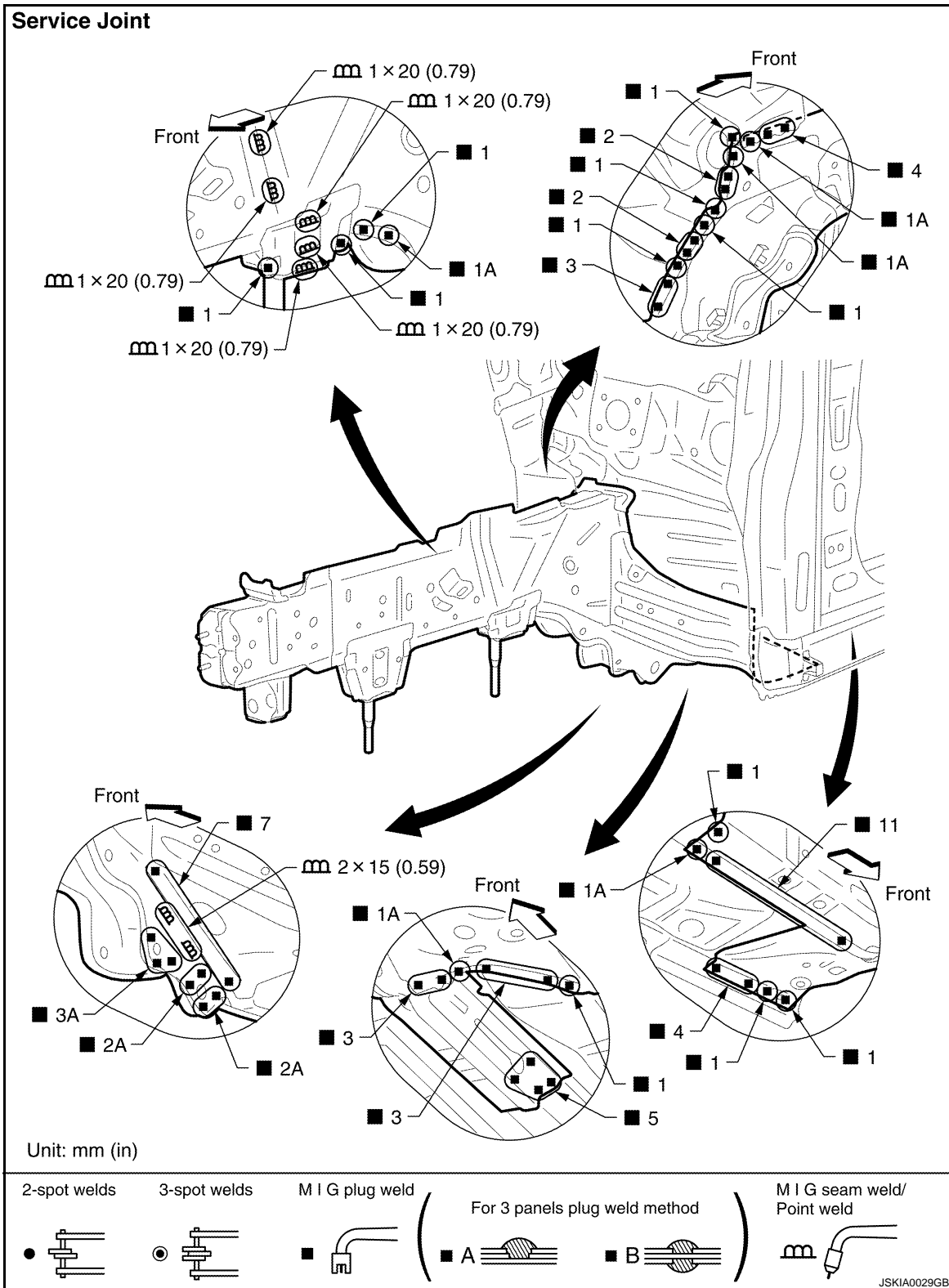


#### Change parts

- Front side member assembly (LH)
- Front side member closing plate assembly (LH)
- Front side member outrigger assembly (LH)

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >



## Front Side Member (Partial Replacement)

Work after radiator core support has been removed.

INFOID:000000000961841

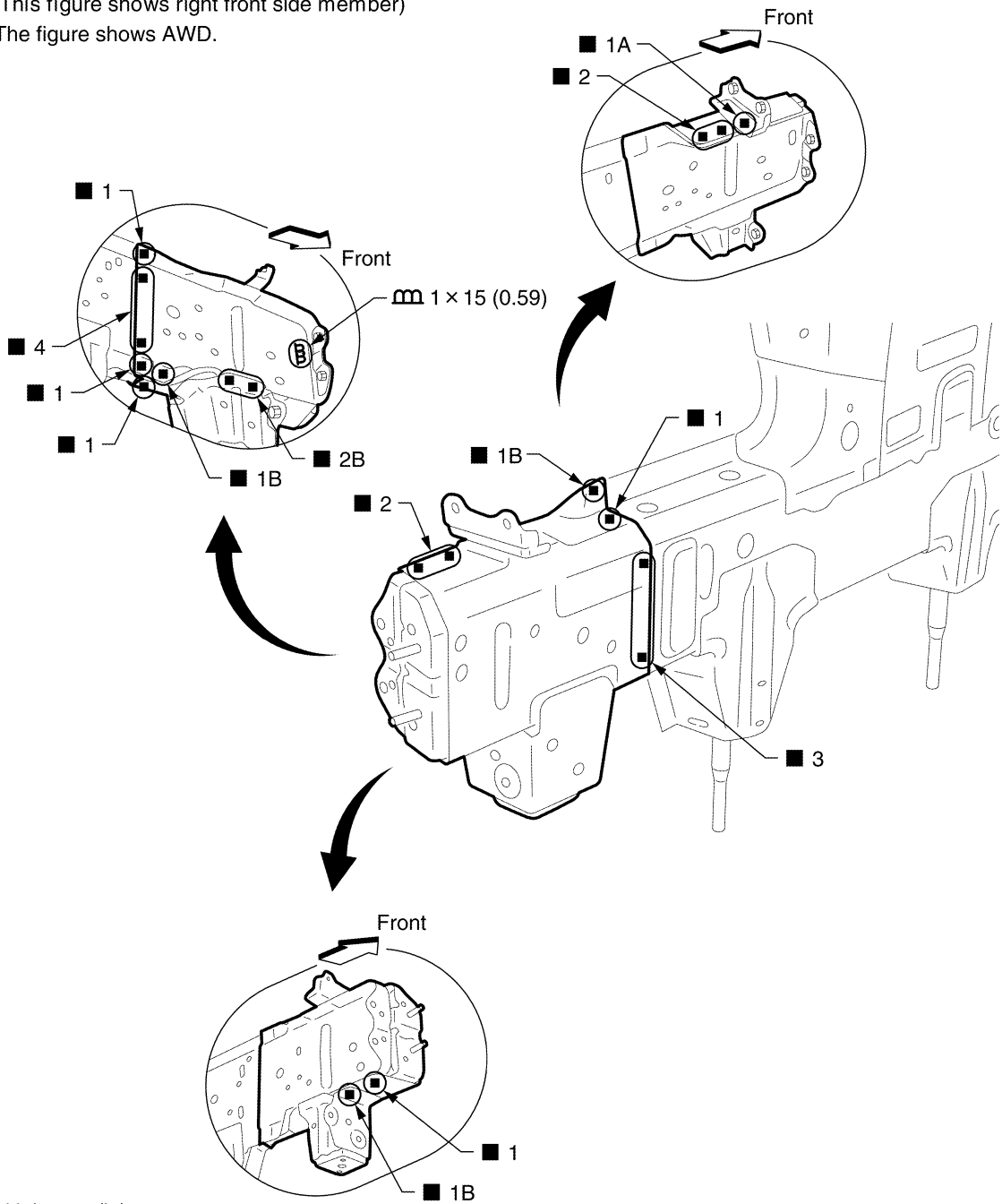
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# REPLACEMENT OPERATIONS

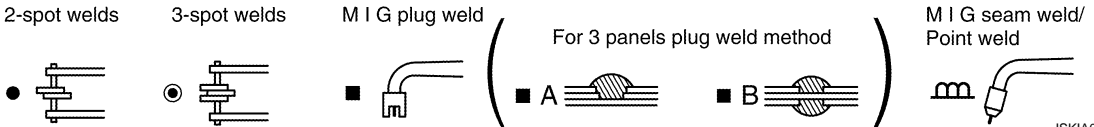
## < REMOVAL AND INSTALLATION >

### Service Joint

(This figure shows right front side member)  
The figure shows AWD.



Unit: mm (in)



JSKIA0030GB

Change parts

- Front side member front extension (RH)
- Front side member front closing plate (RH)

### Front Pillar

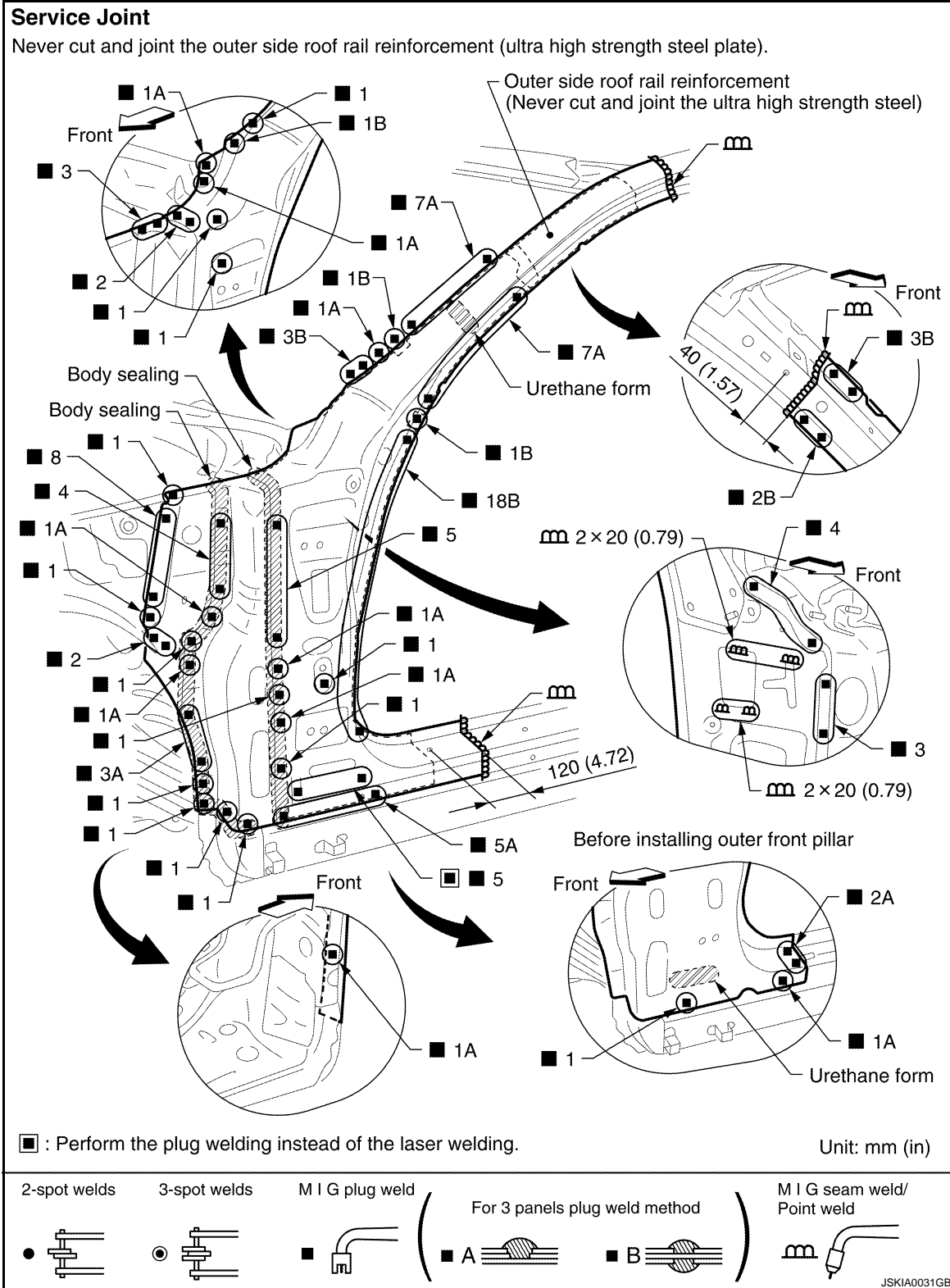
INFOID:000000000961842

Work after hoodledge reinforcement and roof have been removed.



# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >



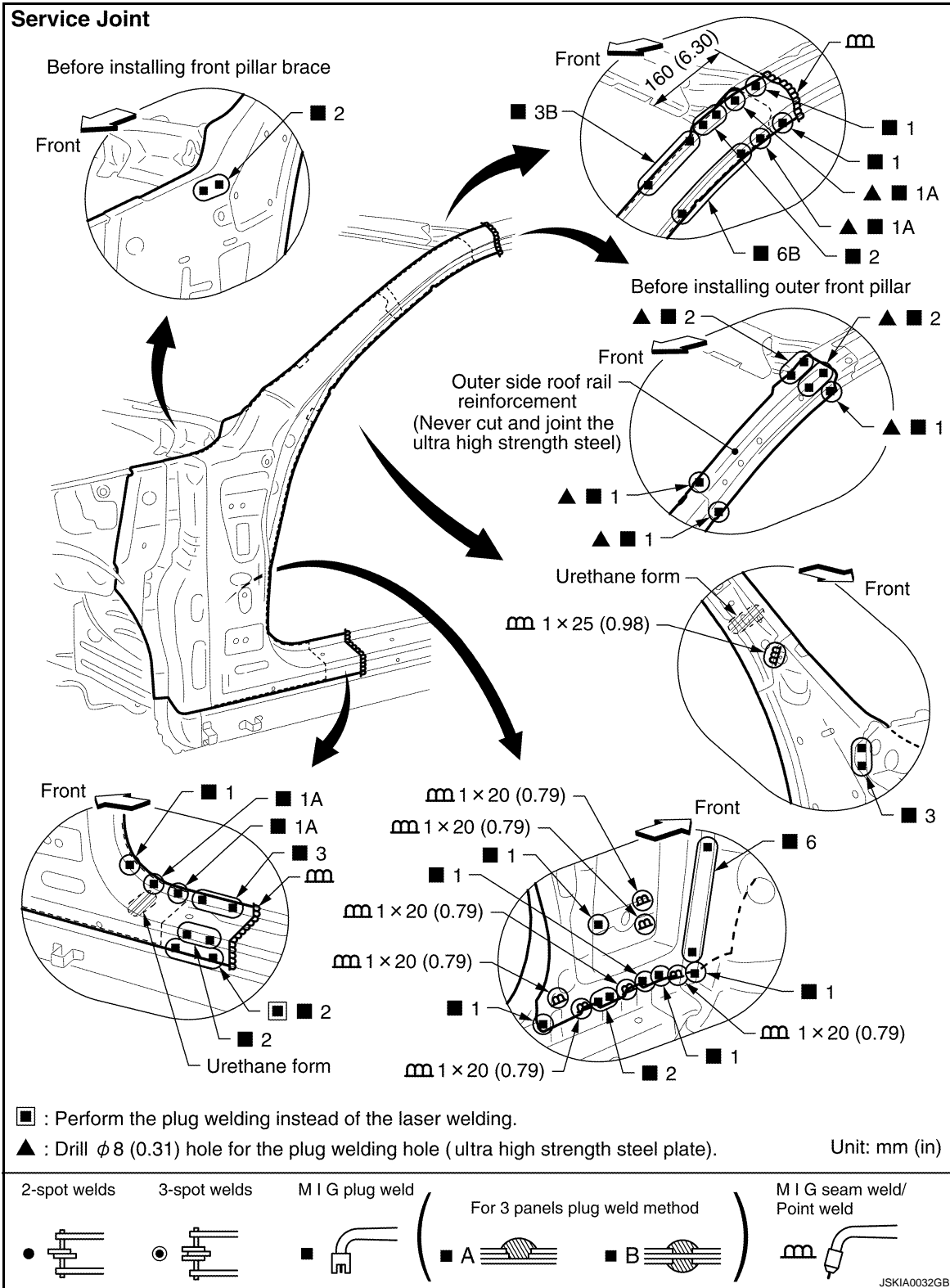
**Change parts**

- Outer front side body (LH)
- Front pillar brace (LH)
- Upper rear hoodledge (LH)
- Outer side roof rail reinforcement (LH)
- Inner roof rail reinforcement (LH)

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# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >



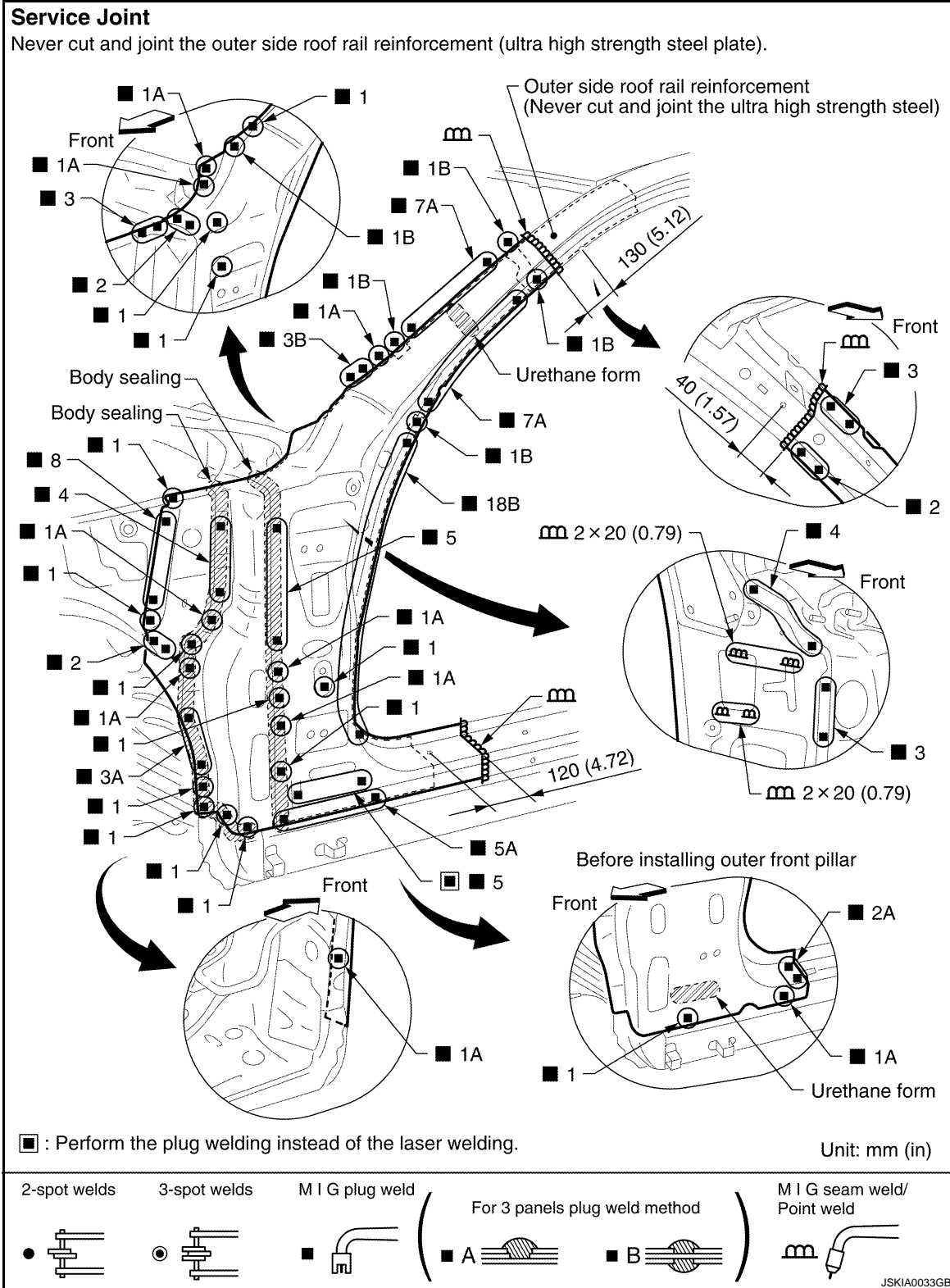
## Front Pillar (Partial Replacement)

INFOID:000000000961843

Work after hoodledge reinforcement has been removed.

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >



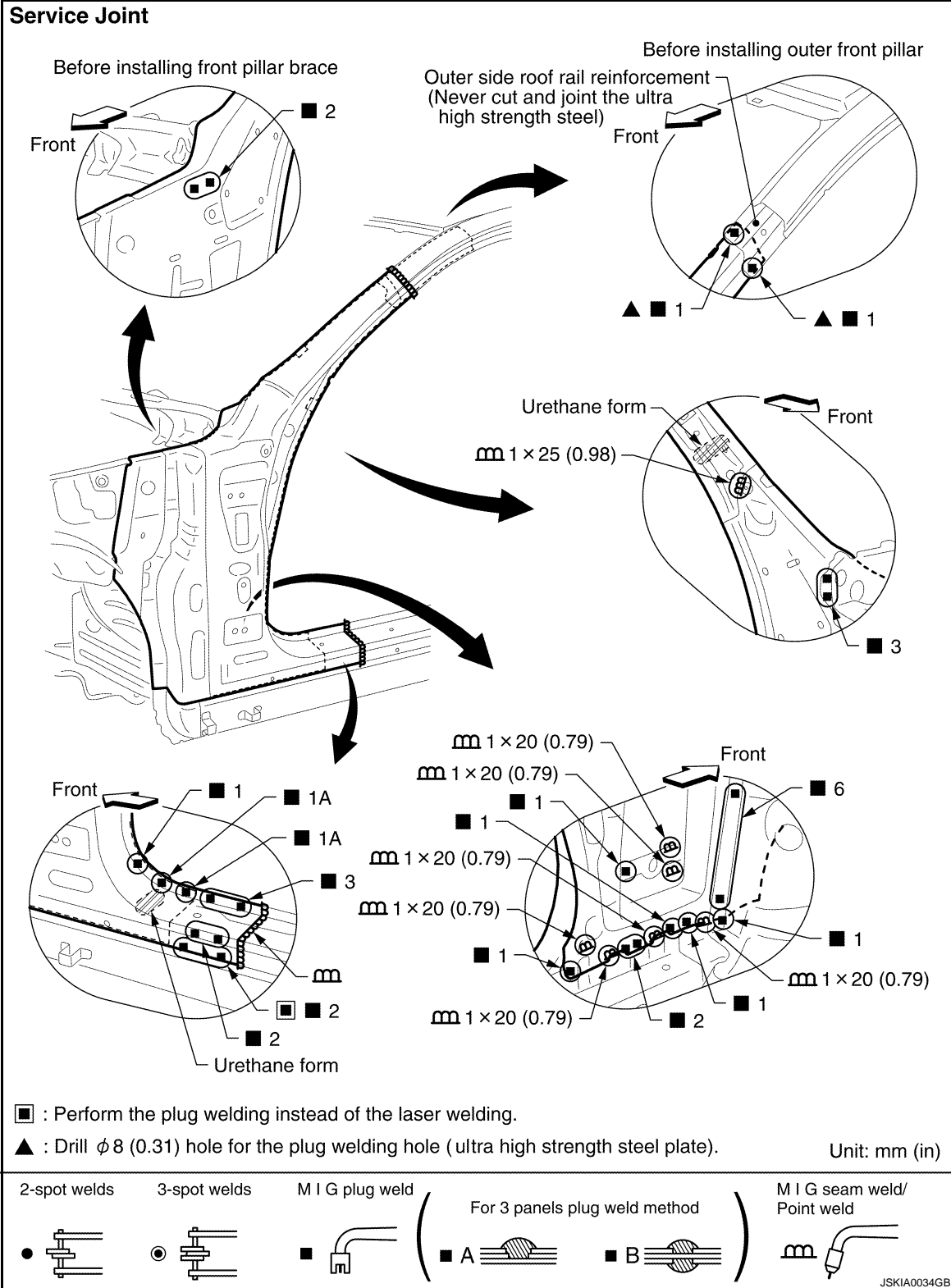
**Change parts**

- Outer front side body (LH)
- Front pillar brace (LH)
- Upper rear hoodledge (LH)
- Outer side roof rail reinforcement (LH)
- Inner roof rail reinforcement (LH)

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# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >



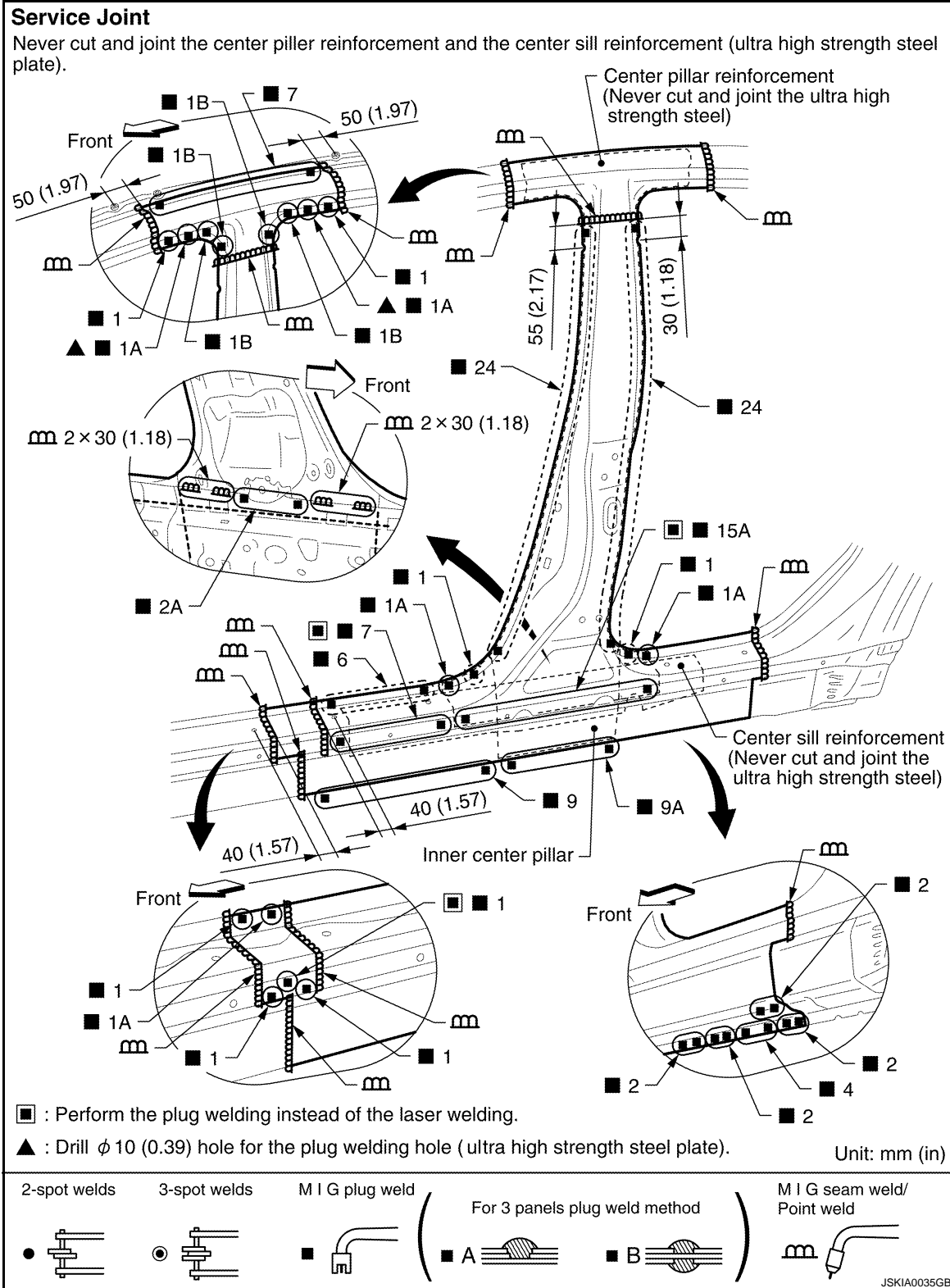
## Center Pillar

INFOID:000000000961844

Work after roof has been removed.

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >



Change parts

● Side body assembly (LH)

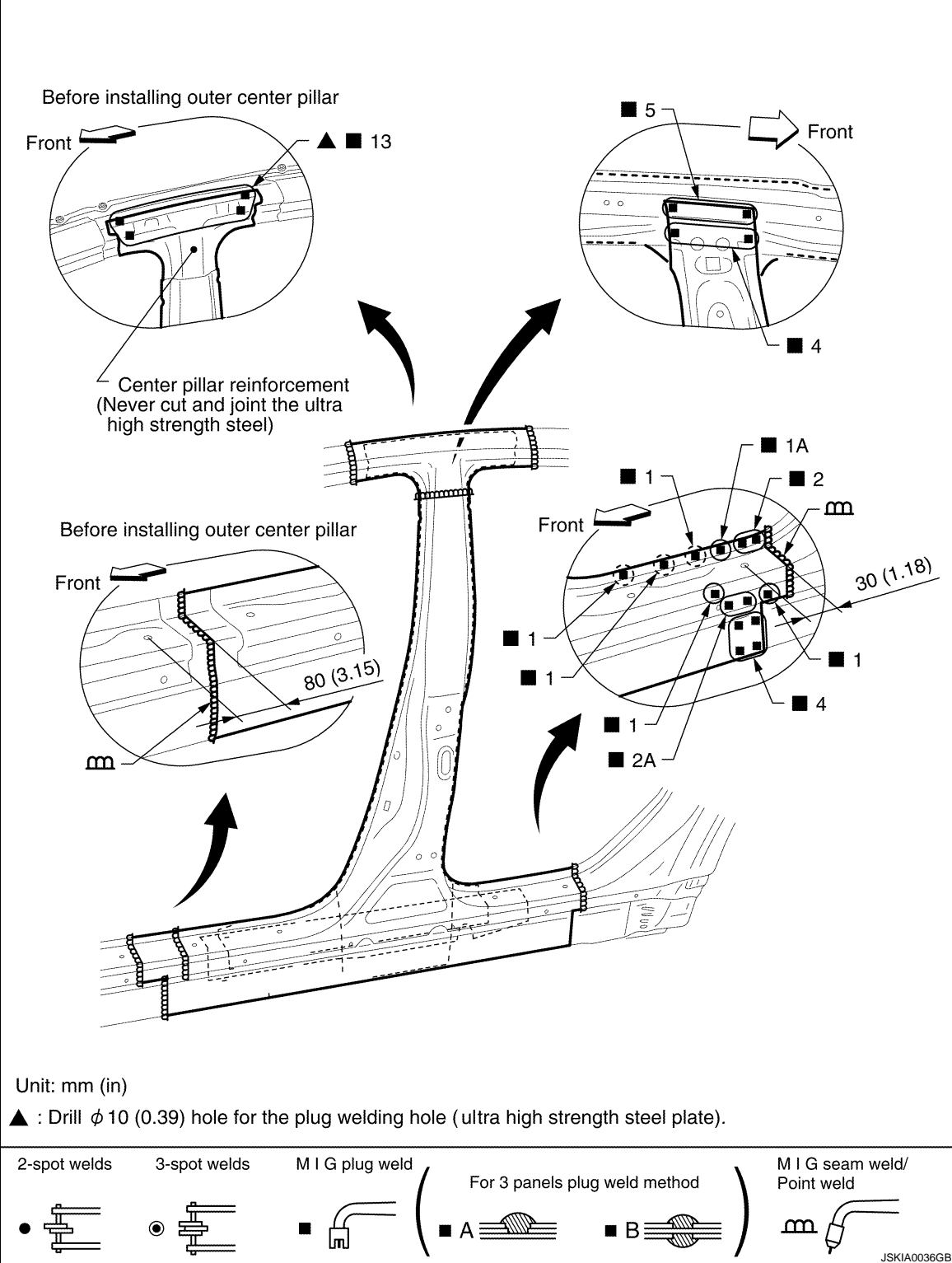
● Inner center pillar (LH)

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# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

## Service Joint



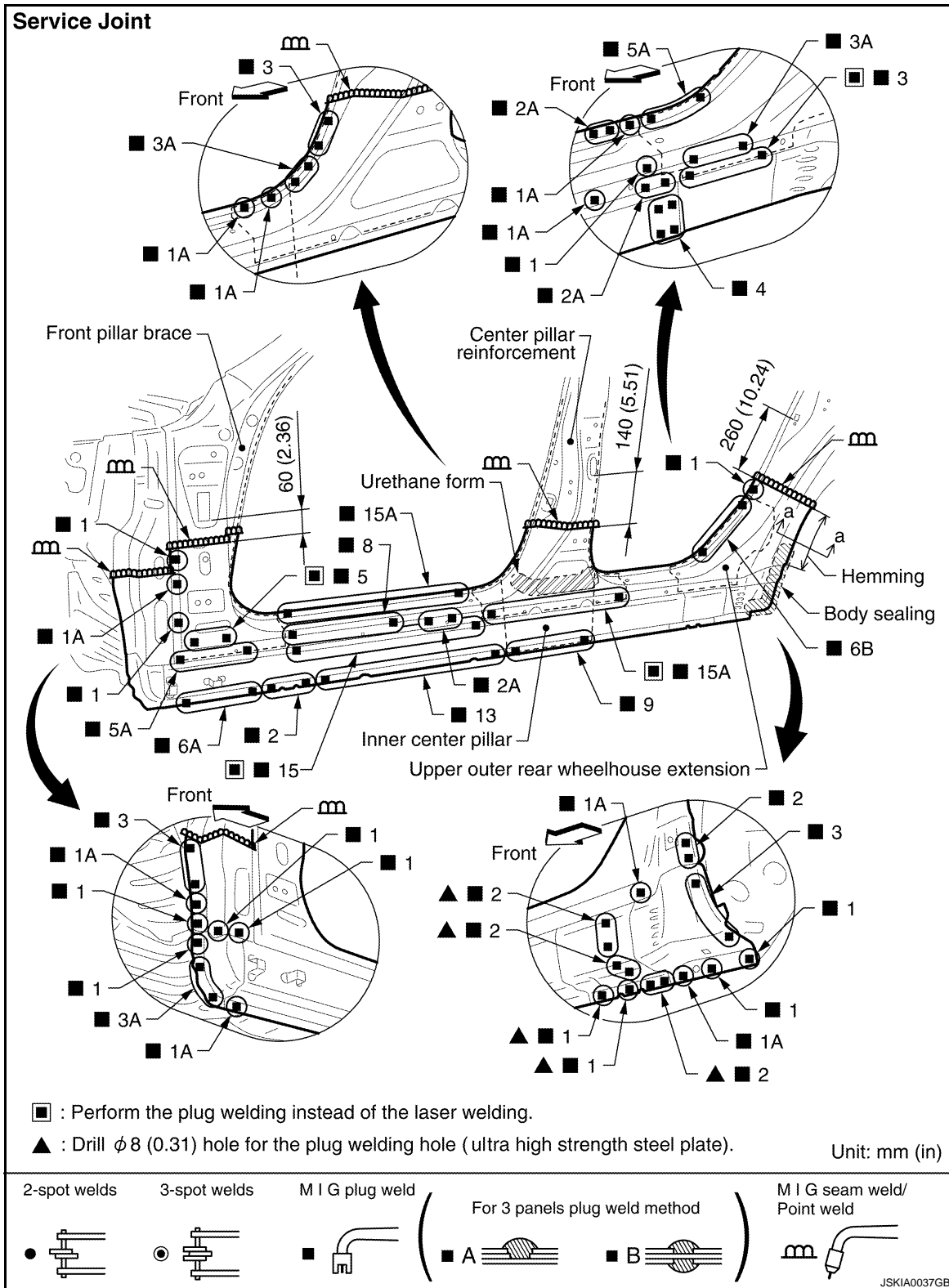
## Outer Sill

INFOID:000000000961845

Work after hoodledge reinforcement has been removed.

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >



**Change parts**

- Outer sill (LH)
- Outer sill reinforcement (LH)
- Upper outer rear wheelhouse extension (LH)
- Front pillar brace (LH)
- Center pillar reinforcement (LH)
- Lower outer rear wheelhouse extension (LH)

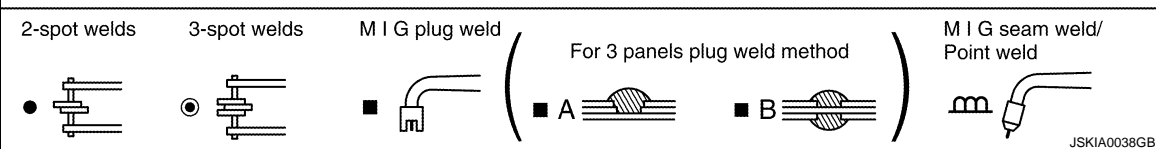
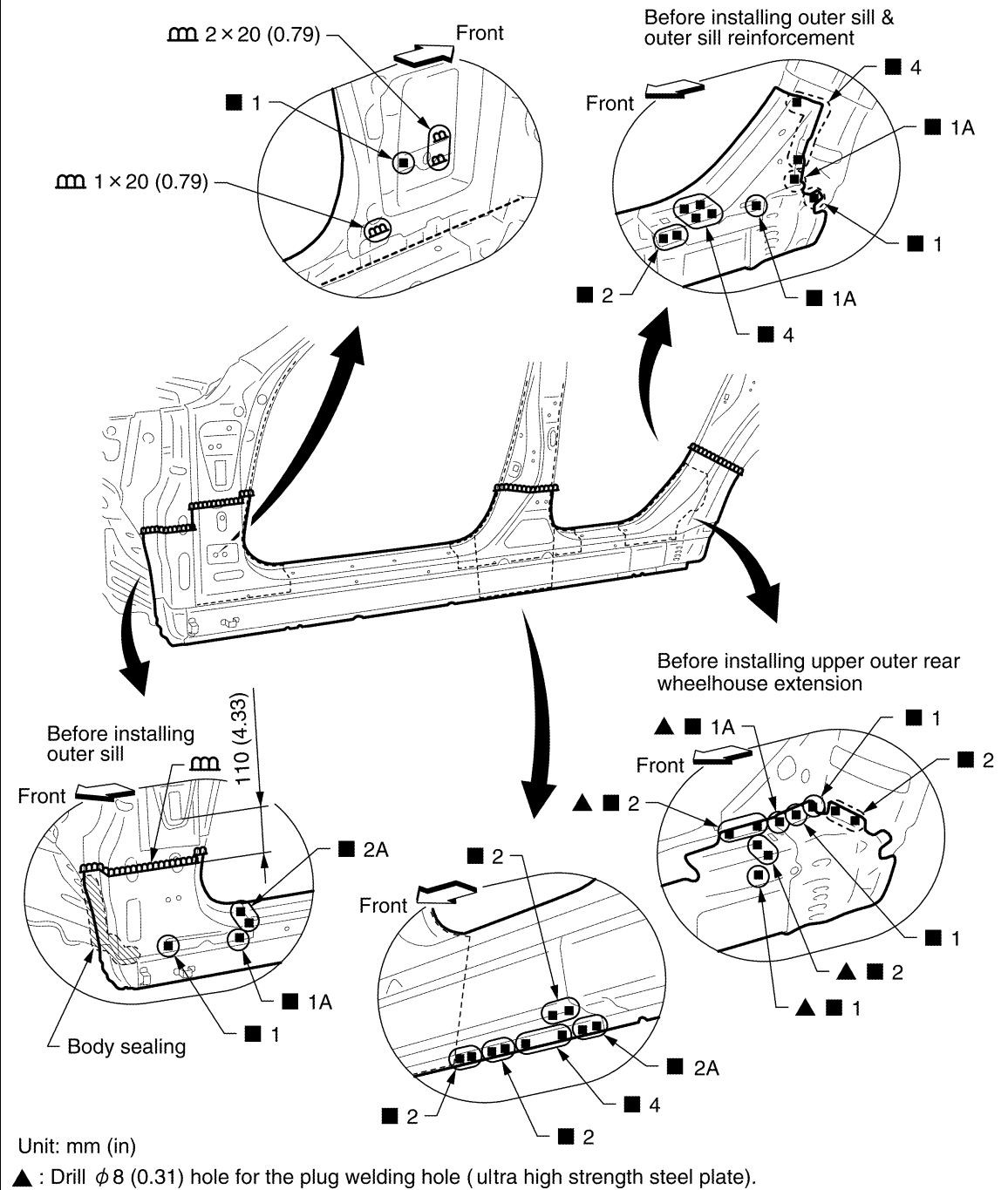
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# REPLACEMENT OPERATIONS

## < REMOVAL AND INSTALLATION >

### Service Joint

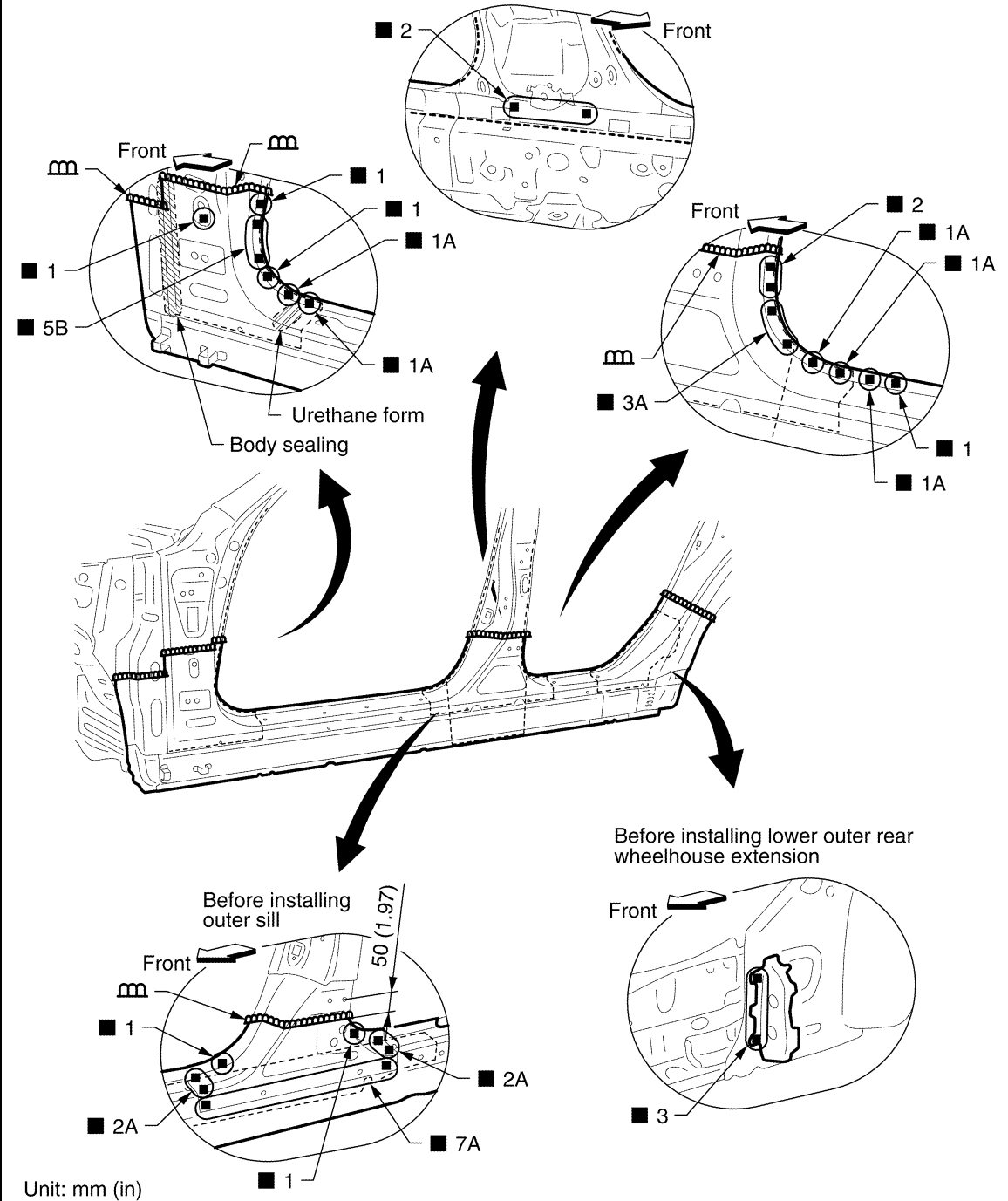




# REPLACEMENT OPERATIONS

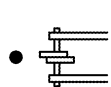
< REMOVAL AND INSTALLATION >

## Service Joint

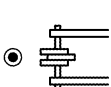


Unit: mm (in)

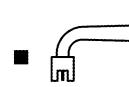
2-spot welds



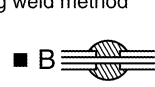
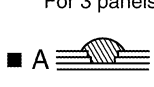
3-spot welds



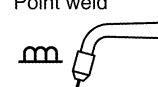
M I G plug weld



For 3 panels plug weld method



M I G seam weld/  
Point weld



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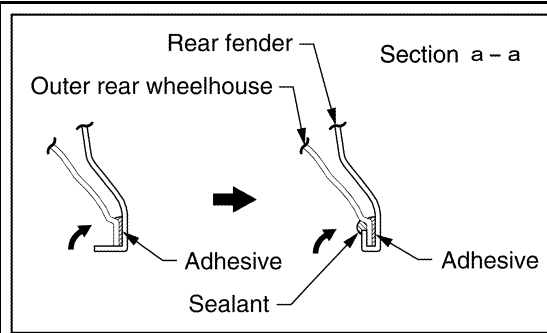
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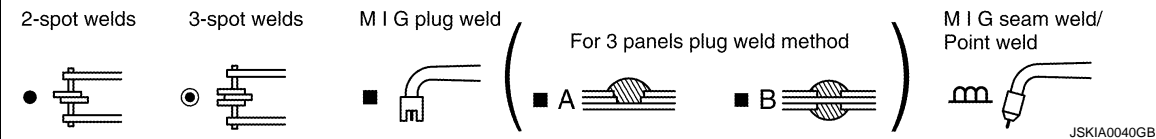
# REPLACEMENT OPERATIONS

## < REMOVAL AND INSTALLATION >



### INSTALLATION NOTES

- Apply the adhesive to the flange of wheel arch and hem it.
- Seal up the area around the hemmed end of the flange.
- Refer to "Rear fender hemming process".



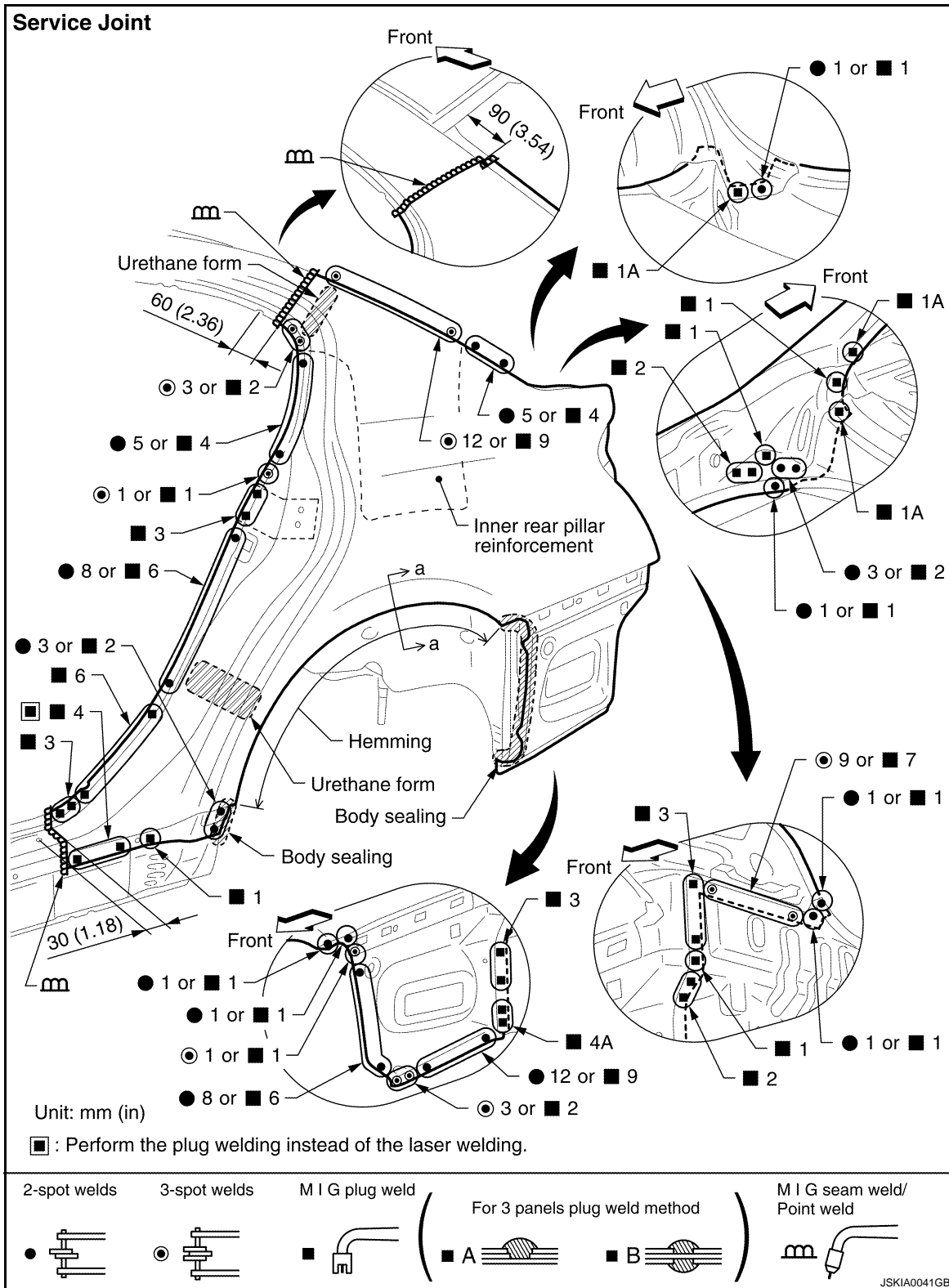
JSKIA0040GB

Rear Fender

INFOID:000000000961846

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >



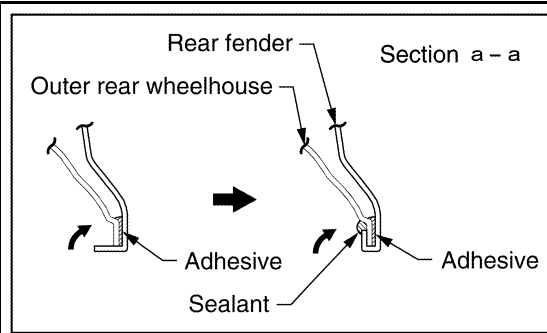
Change parts

- Rear fender assembly (LH)

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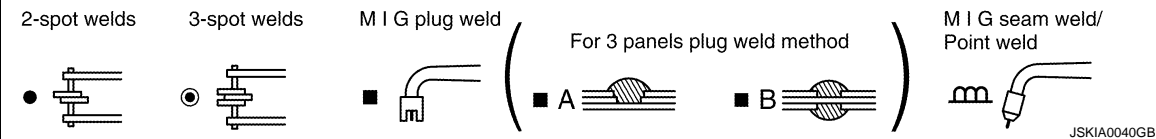
# REPLACEMENT OPERATIONS

## < REMOVAL AND INSTALLATION >



### INSTALLATION NOTES

- Apply the adhesive to the flange of wheel arch and hem it.
- Seal up the area around the hemmed end of the flange.
- Refer to "Rear fender hemming process".



### Outer Wheelhouse

INFOID:000000000961847

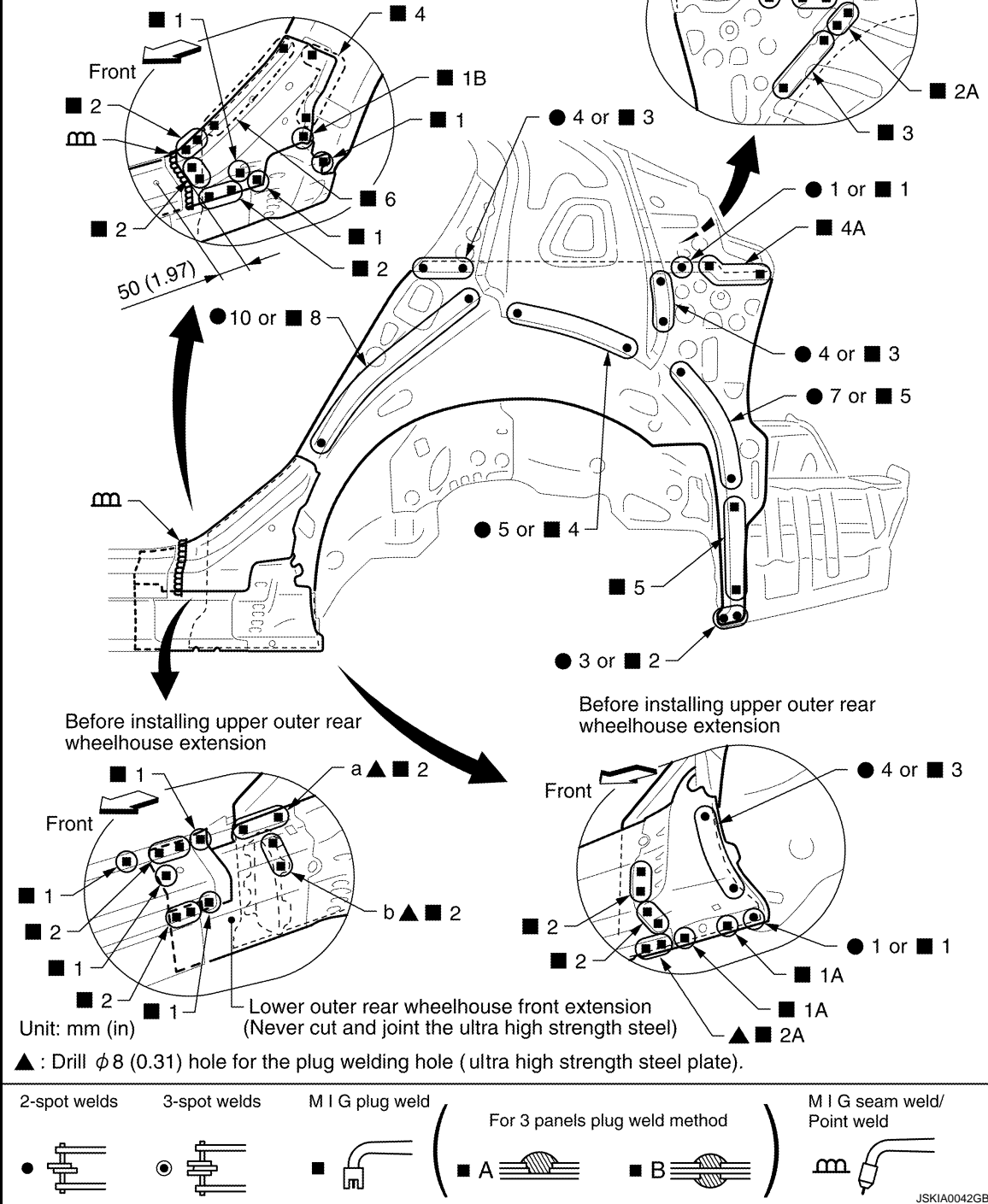
Work after rear fender has been removed.

# REPLACEMENT OPERATIONS

## < REMOVAL AND INSTALLATION >

### Service Joint

Refer to "REMOVAL" for accurate hidden welding point repair procedure.  
 Check the panel combination and structure.  
 Never cut and joint the lower outer rear wheelhouse front extension  
 (ultra high strength steel plate).



### Change parts

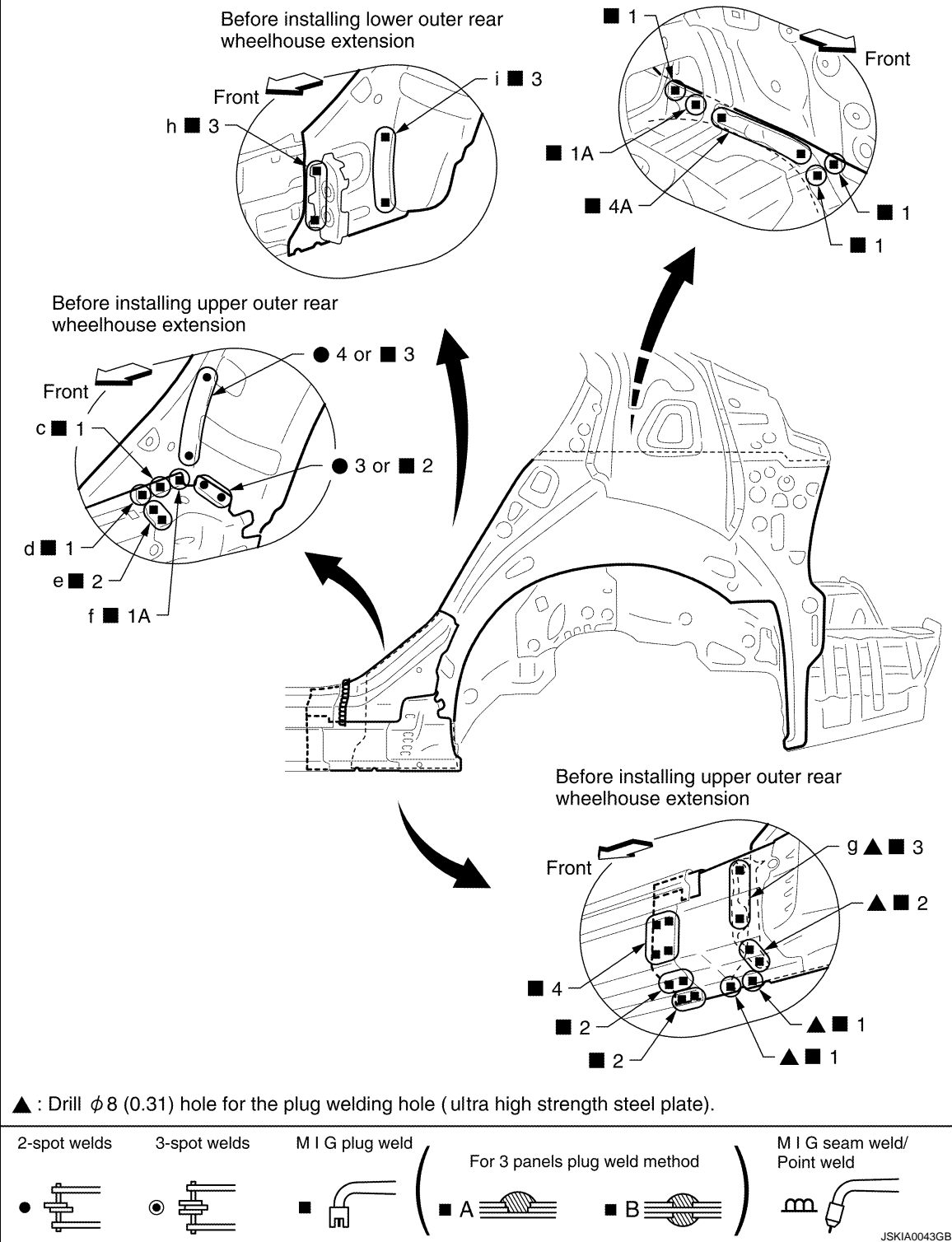
- Outer rear wheelhouse (LH)
- Lower outer rear wheelhouse extension (LH)
- Upper outer rear wheelhouse extension (LH)

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# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

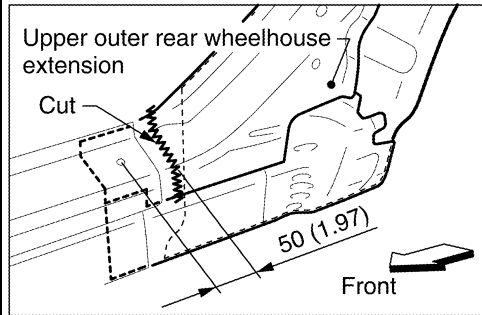
## Service Joint



# REPLACEMENT OPERATIONS

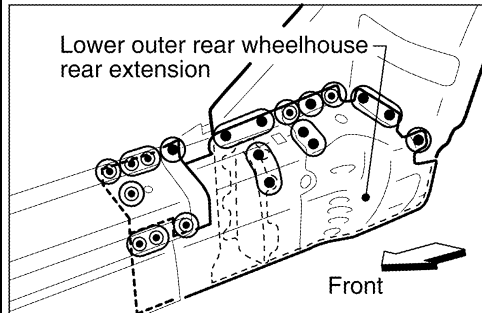
## < REMOVAL AND INSTALLATION >

### Service Joint

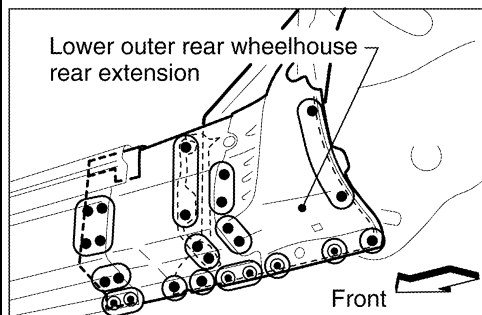


#### 【REMOVAL】

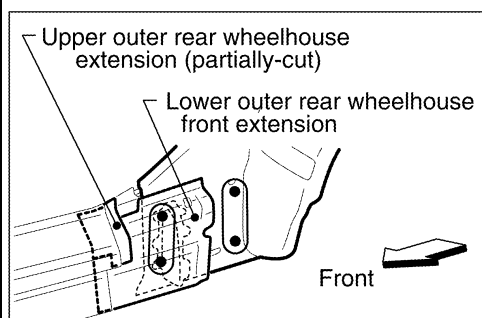
- Reuse the upper outer rear wheelhouse extension and the lower outer rear wheelhouse extension.
- Cut the upper outer rear wheelhouse extension as shown in the figure for removing the hidden welding point (a,b,c,d,e,f,g).



- Cut the lower outer rear wheelhouse rear extension as shown in the figure for removing the hidden welding point (h,i).



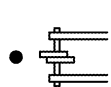
- Remove the welding point as shown in the figure.



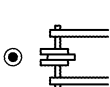
- Pull out the attached (partially-cut) upper outer rear wheelhouse extension and the lower outer rear wheelhouse front extension after removing the lower outer rear wheelhouse rear extension.
- Remove the welding point (h) of the outer rear wheelhouse bias and the outer rear wheelhouse.
- Remove the welding point (i) of the outer rear wheelhouse and the inner rear wheelhouse.

Unit: mm (in)

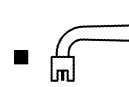
2-spot welds



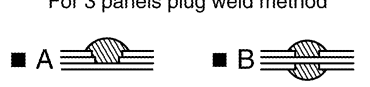
3-spot welds



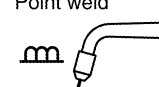
M I G plug weld



For 3 panels plug weld method



M I G seam weld/  
Point weld



JSKIA0044GB

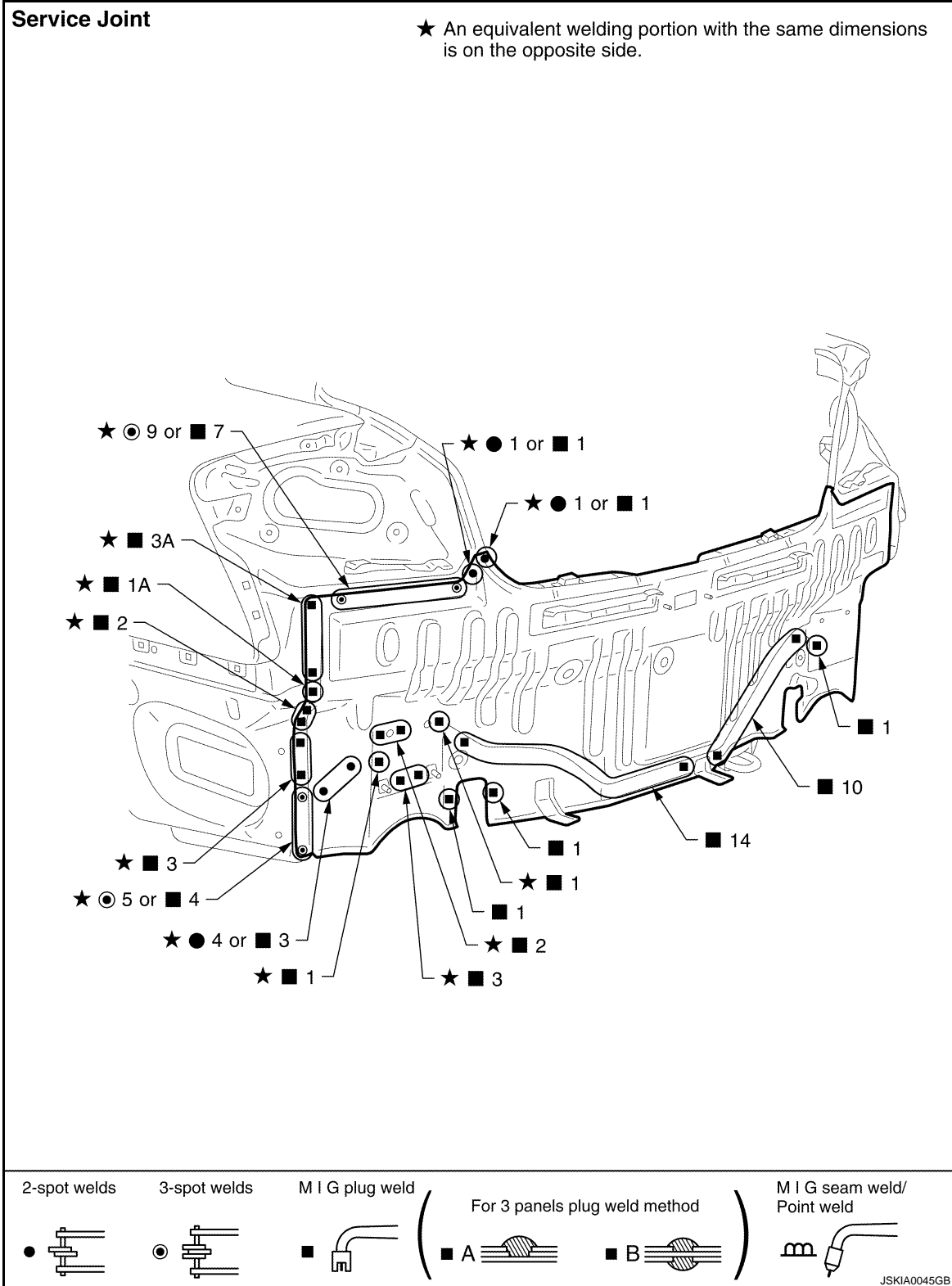
Rear Panel

INFOID:000000000961848

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# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >



Change parts

- Rear panel assembly

## Rear Floor Rear

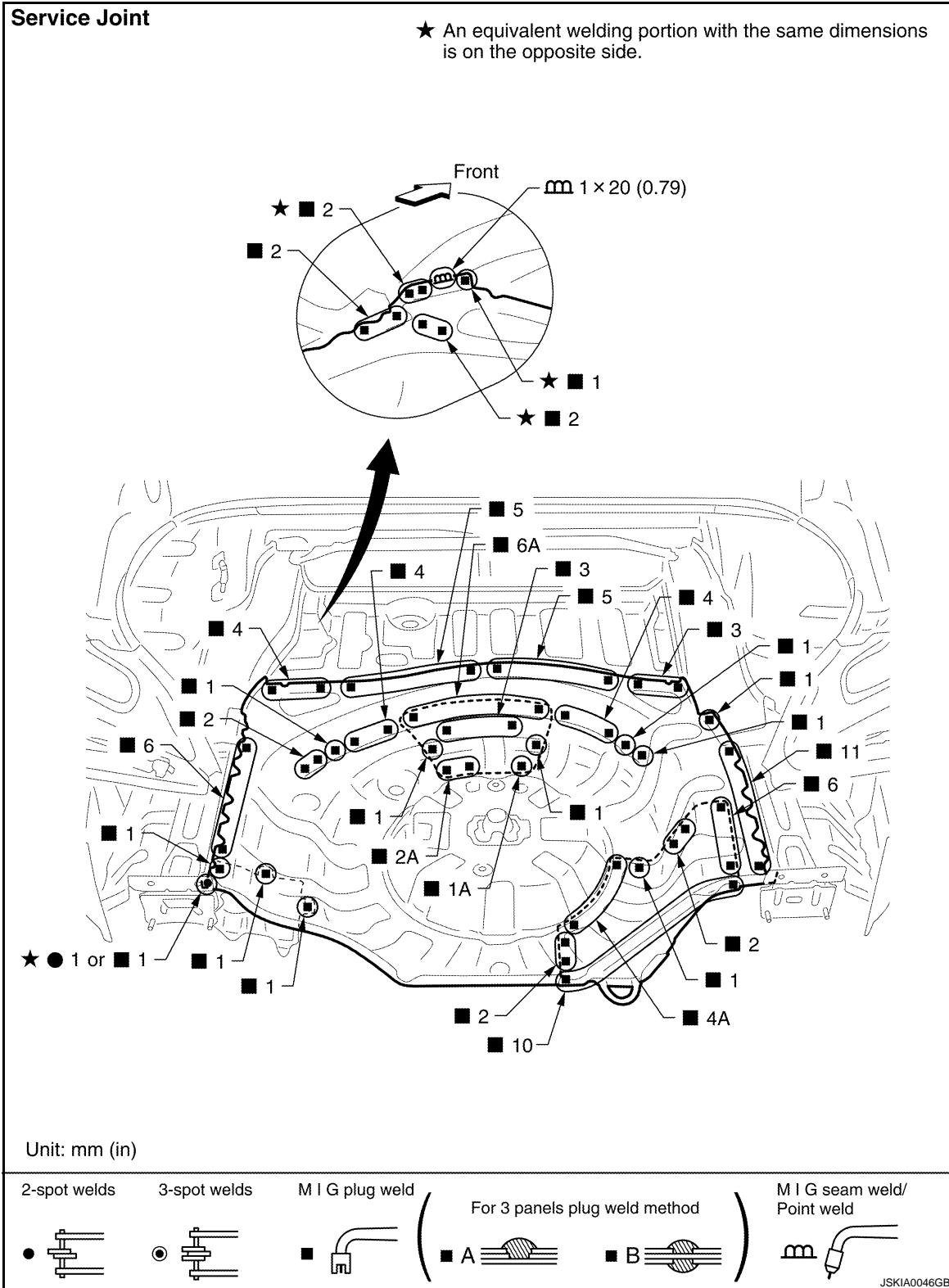
INFOID:000000000961849

Work after rear panel has been removed.



# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >



Change parts

- Rear floor rear
- Differential mounting bracket assembly

## Rear Side Member Extension

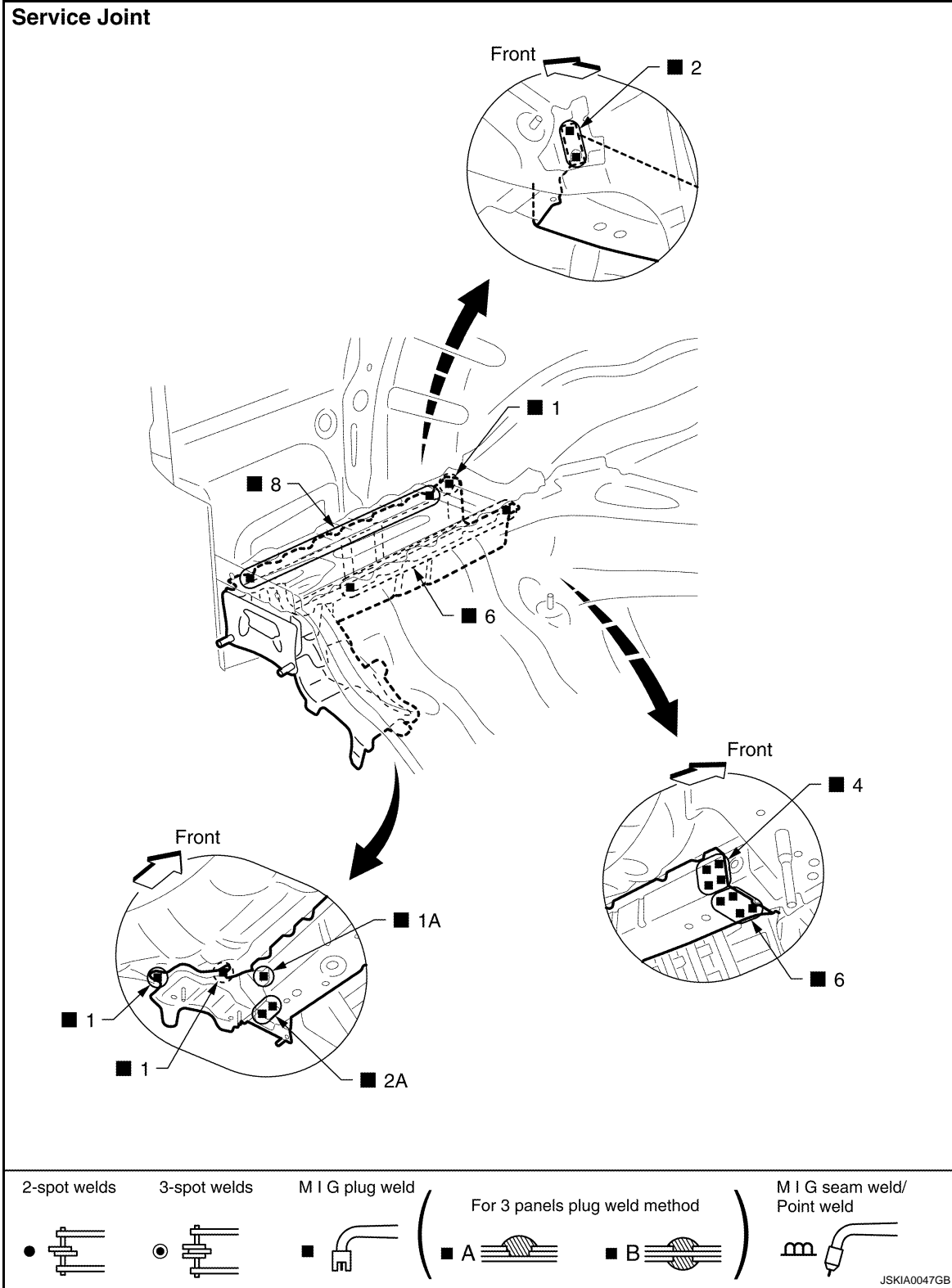
INFOID:000000000961850

Work after rear panel has been removed.

A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
BRM  
L  
M  
N  
O  
P

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >



Change parts

- Rear side member extension (LH)
- Muffler mounting bracket assembly