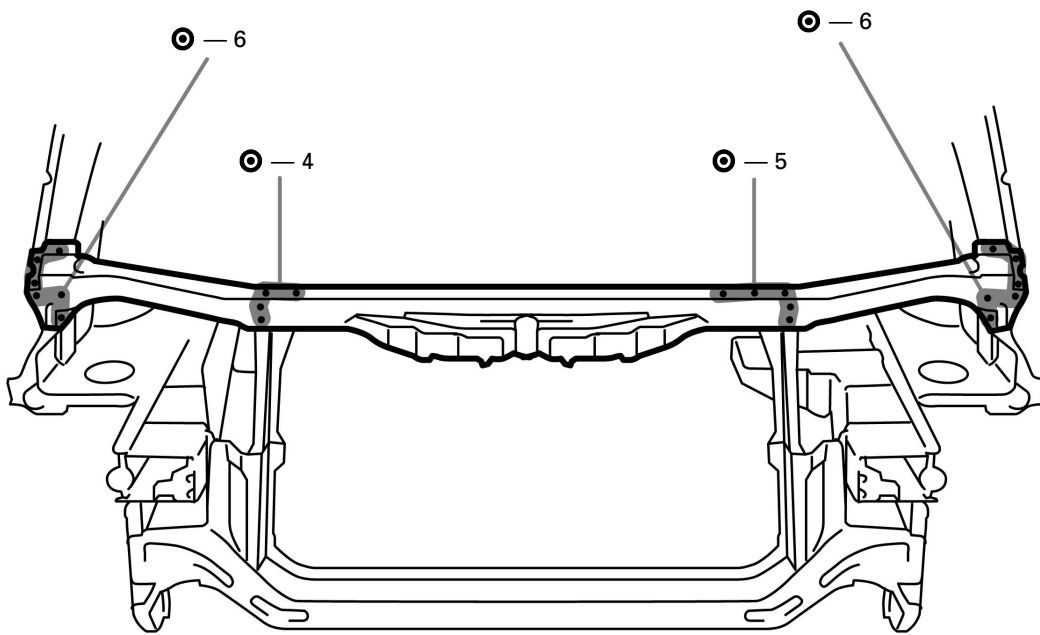
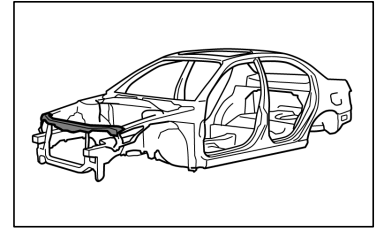


BODY PANEL REPLACEMENT

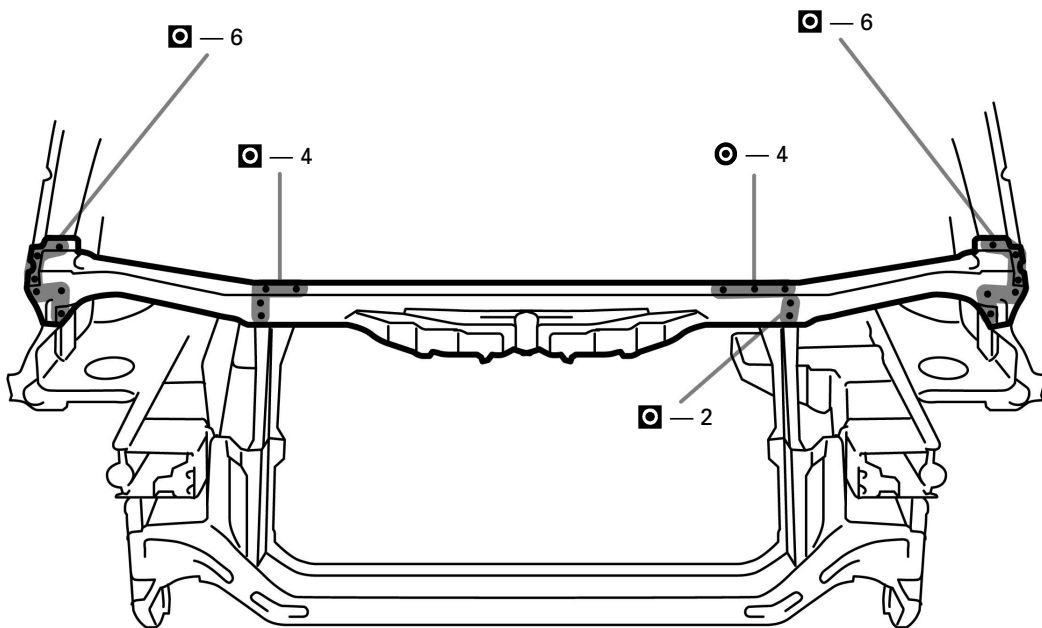
	Page
RADIATOR UPPER SUPPORT (ASSY)	RE-2
RADIATOR SIDE SUPPORT (ASSY)	RE-4
FRONT CROSSMEMBER (ASSY)	RE-6
RADIATOR SUPPORT (ASSY)	RE-8
FRONT FENDER FRONT APRON (ASSY)	RE-10
COWL TOP SIDE PANEL (ASSY)	RE-12
COWL TOP SIDE REINFORCEMENT (ASSY)	RE-14
FRONT FENDER APRON (ASSY)	RE-16
FRONT SIDE MEMBER (CUT-P)	
Right Side	RE-18
Left Side	RE-21
FRONT SIDE MEMBER (ASSY)	RE-24
FRONT BODY PILLER (CUT)	RE-26
CENTER BODY PILLER (CUT)	RE-31
FRONT DOOR OUTER PANEL (ASSY)	RE-34
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ROCKER OUTER PANEL (CUT)	RE-38
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QUARTER WHEEL HOUSING OUTER PANEL (ASSY)	
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BODY LOWER BACK PANEL (ASSY)	RE-70
ROOF SIDE INNER REAR PANEL (ASSY)	
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REAR FLOOR INNER REAR CROSSMEMBER (CUT-H) ...	RE-80
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REAR FLOOR NO.2 CROSSMEMBER (ASSY)	RE-96
REAR FLOOR SIDE MEMBER (ASSY)	RE-98
ROOF PANEL (ASSY)	RE-102

RADIATOR UPPER SUPPORT (ASSY)

REMOVAL



INSTALLATION

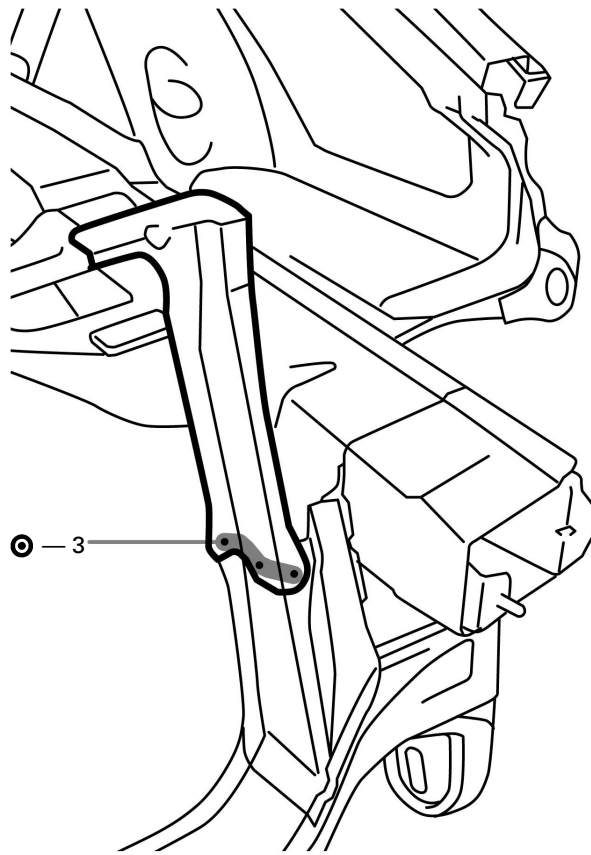
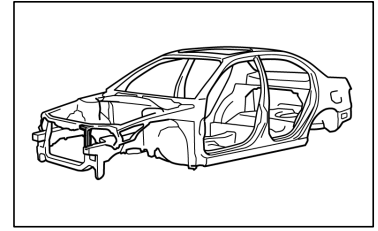


1. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.

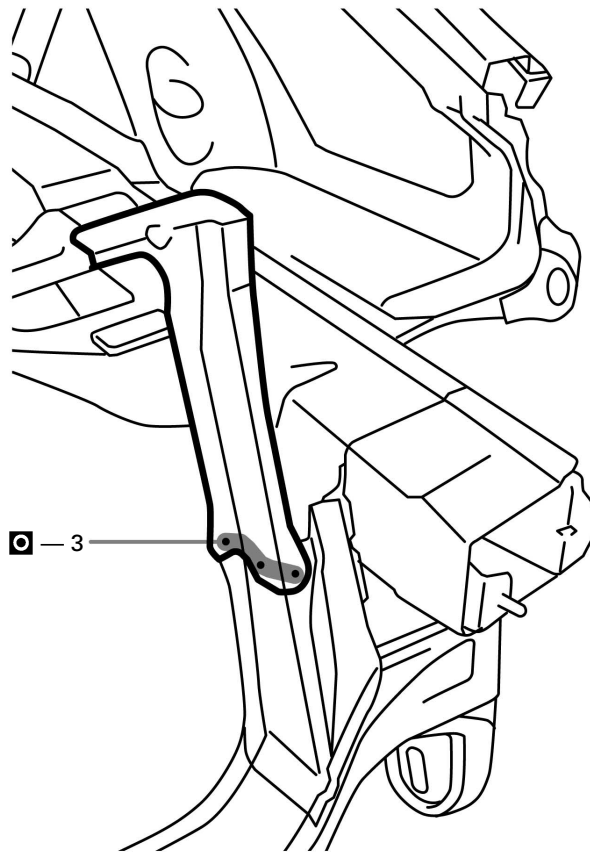
HINT: First install the hood lock support.

RADIATOR SIDE SUPPORT (ASSY)

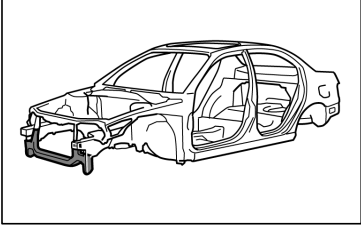
REMOVAL (With the radiator upper support removed.)



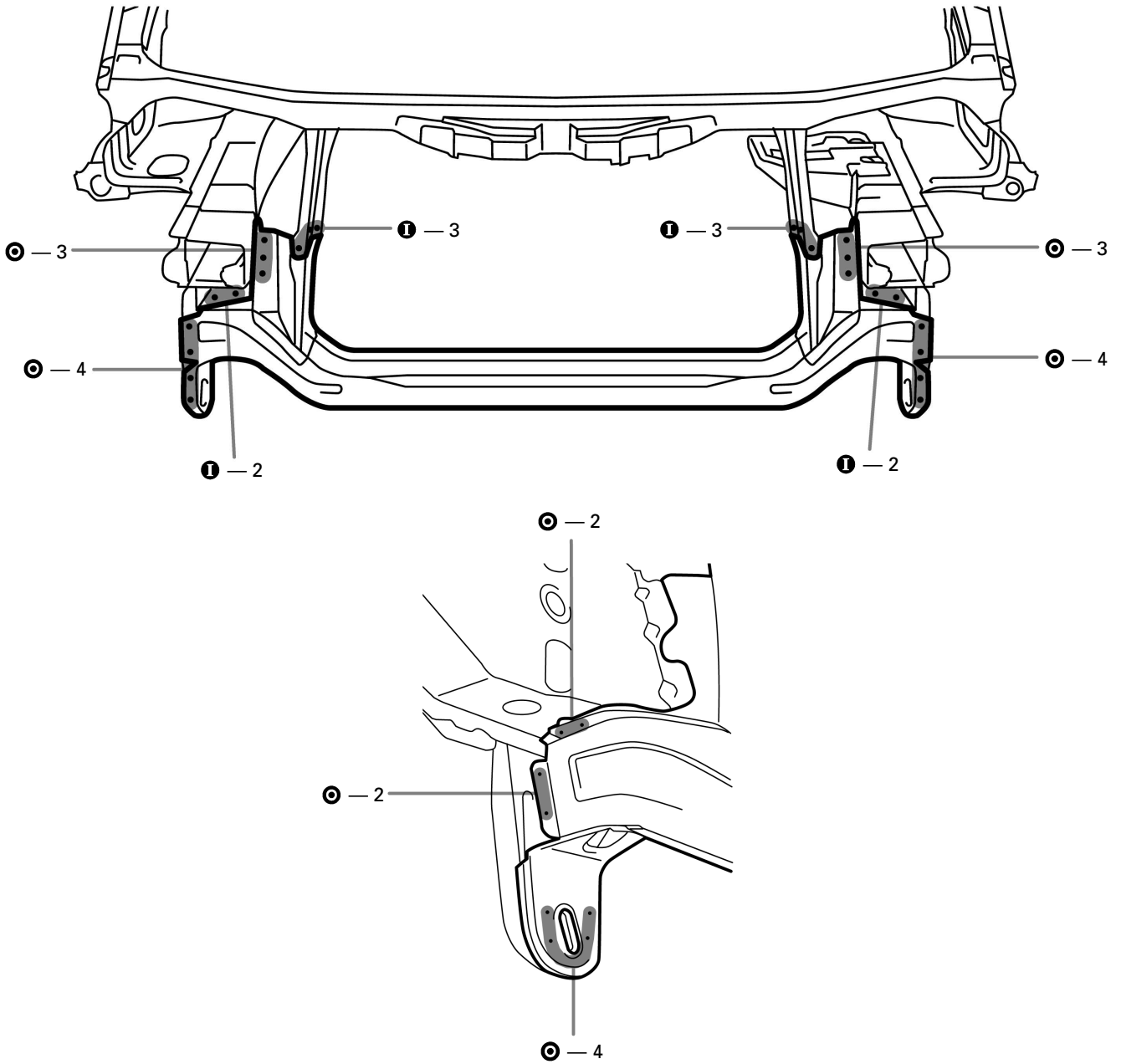
INSTALLATION



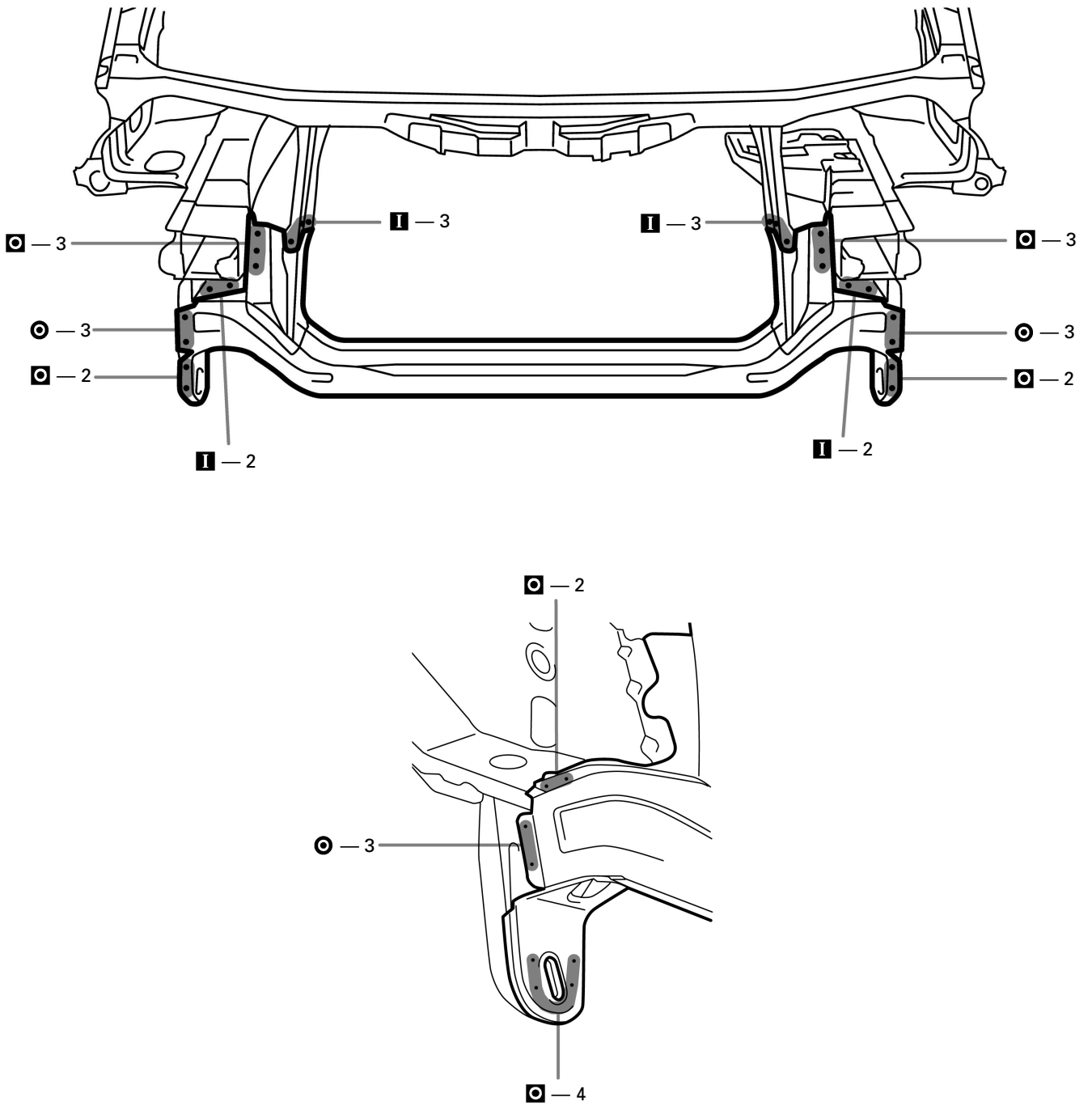
FRONT CROSSMEMBER (ASSY)



REMOVAL

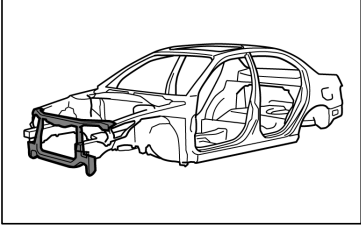


INSTALLATION

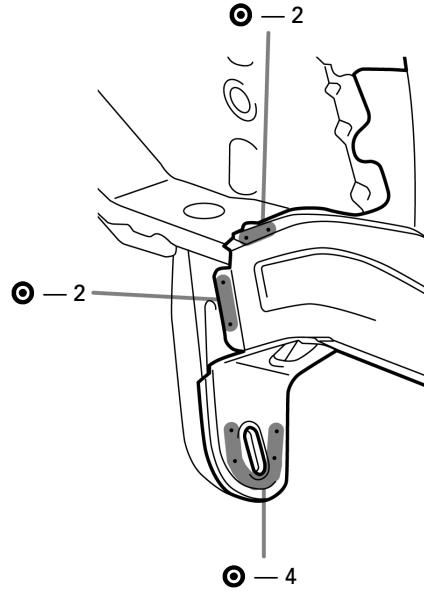
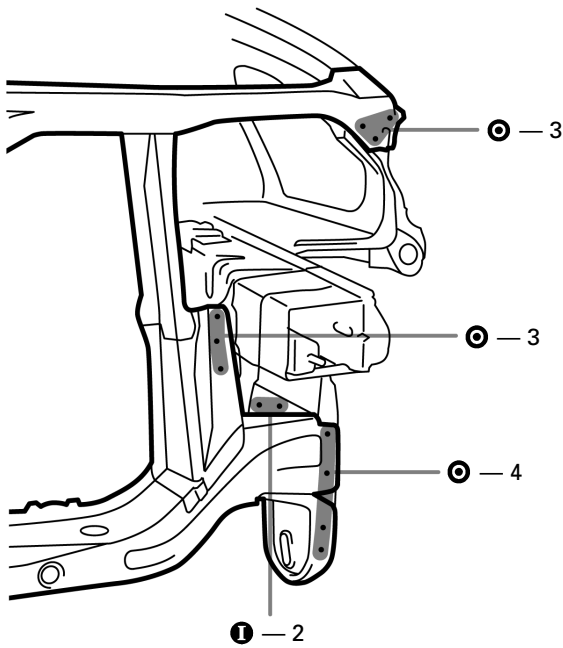
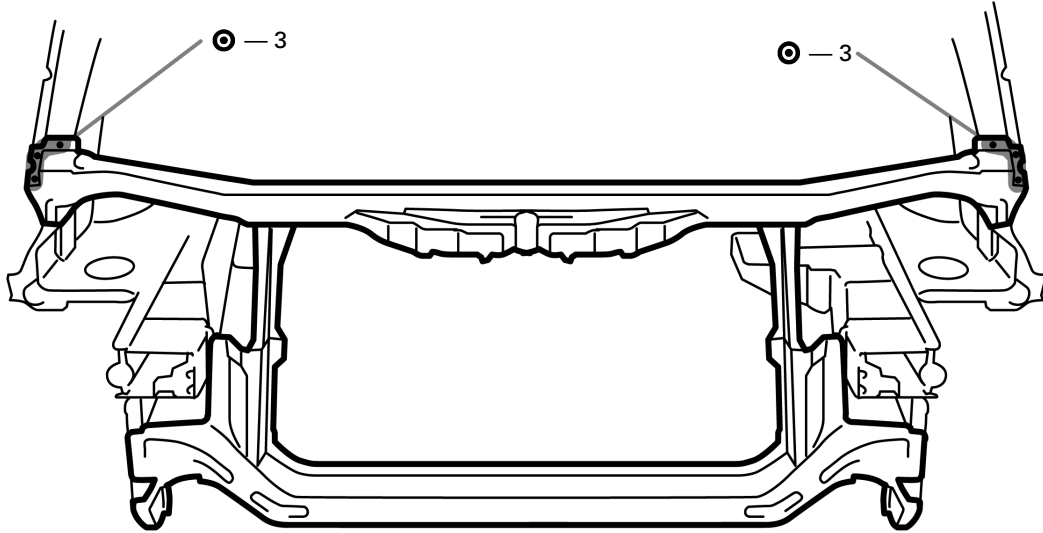


1. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.

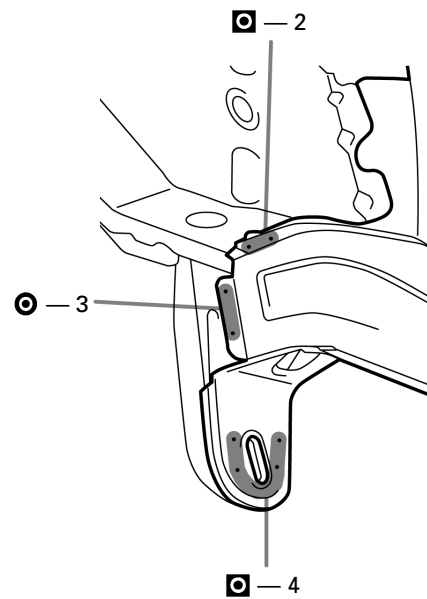
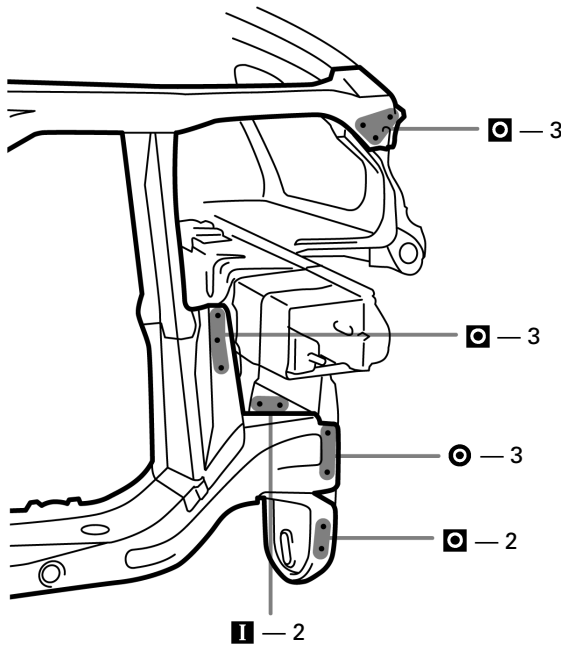
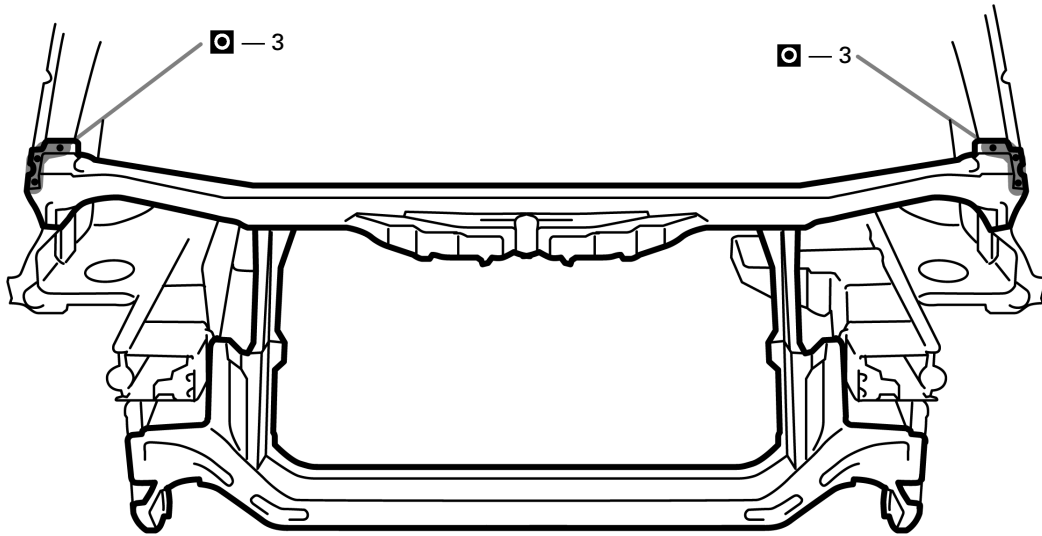
RADIATOR SUPPORT (ASSY)



REMOVAL

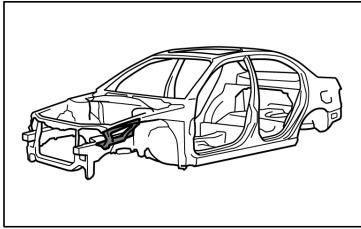


INSTALLATION



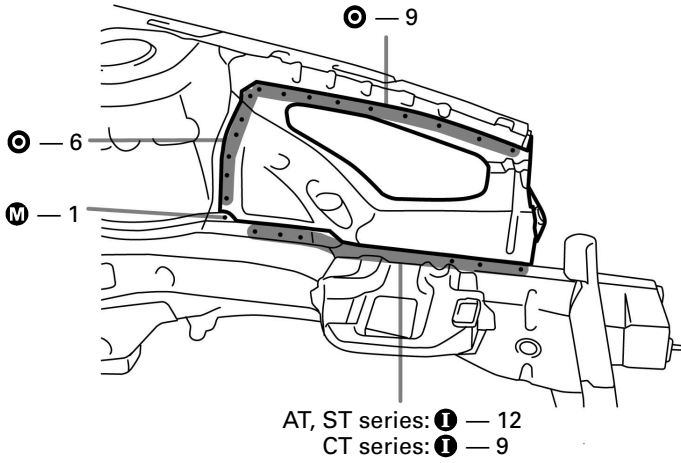
1. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.

FRONT FENDER FRONT APRON (ASSY)

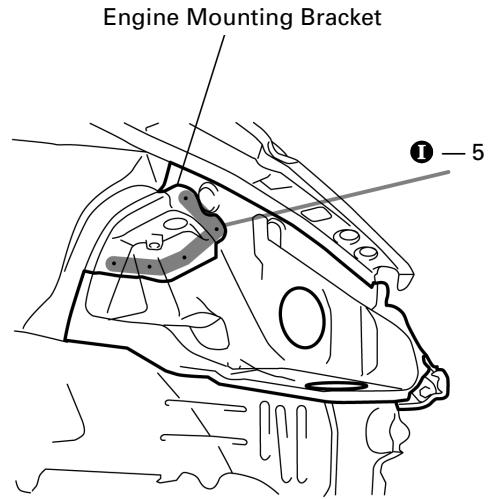


REMOVAL (With the radiator upper support removed.)

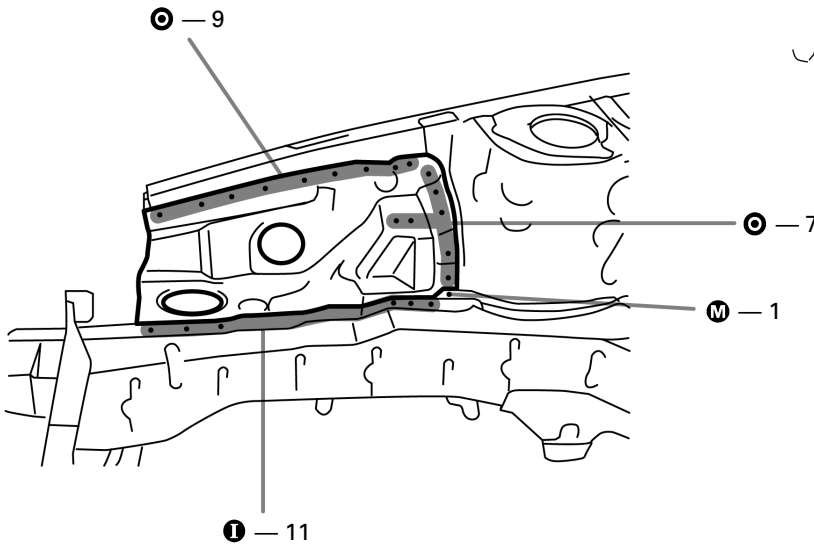
[LH]



[RH]

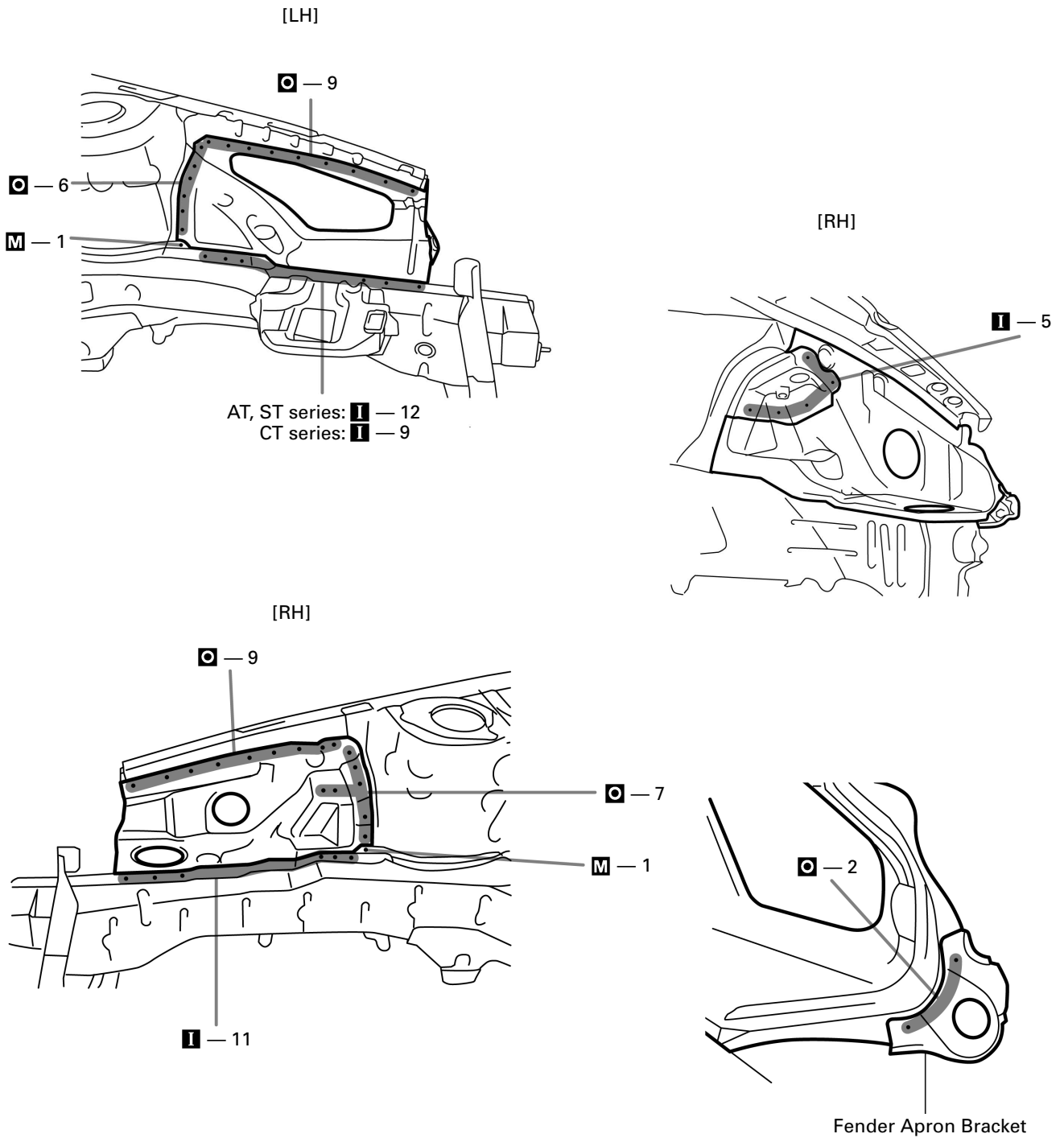


[RH]



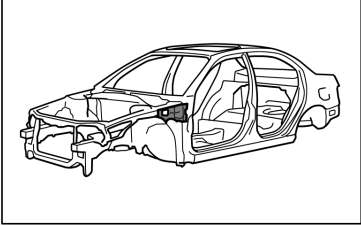
1. Leave the engine mounting bracket to the vehicle side and remove the front fender front apron.

INSTALLATION

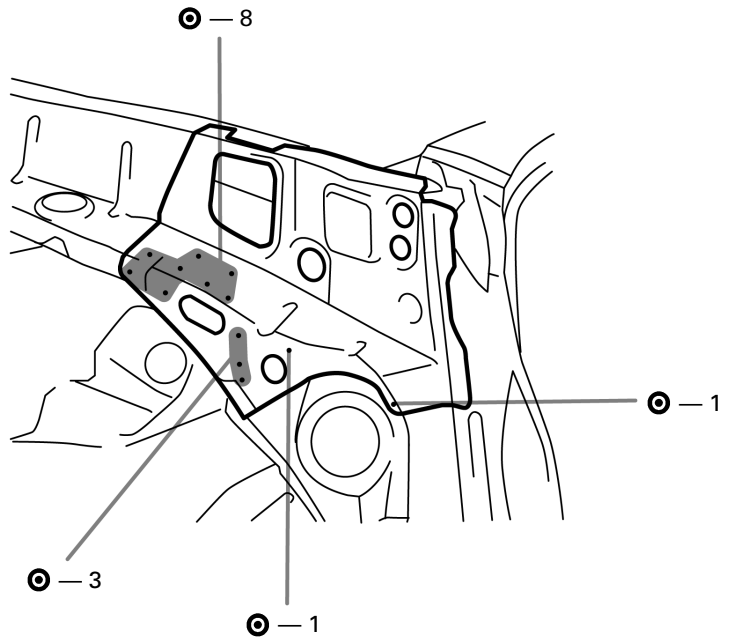
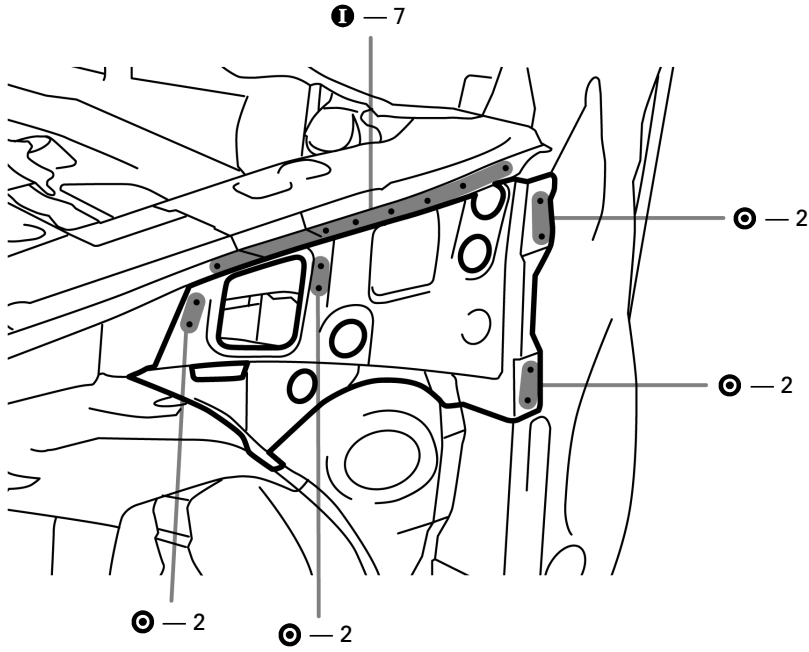


1. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.

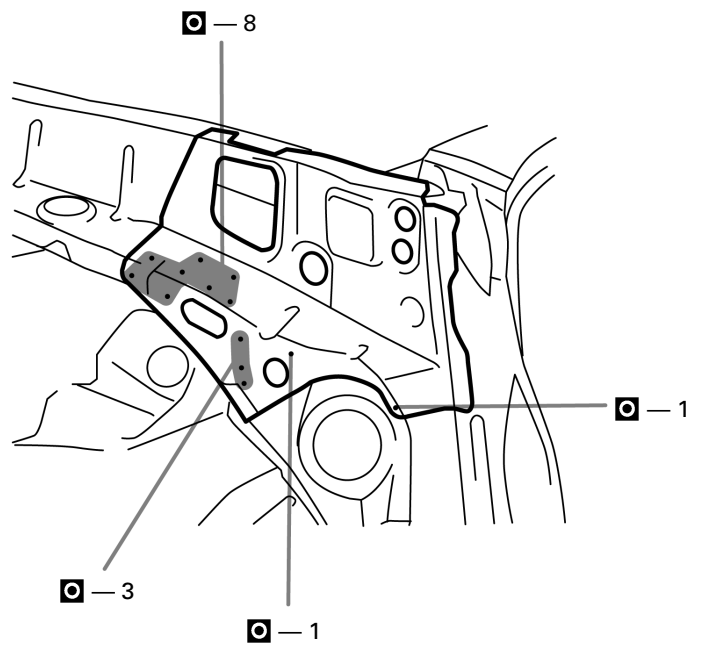
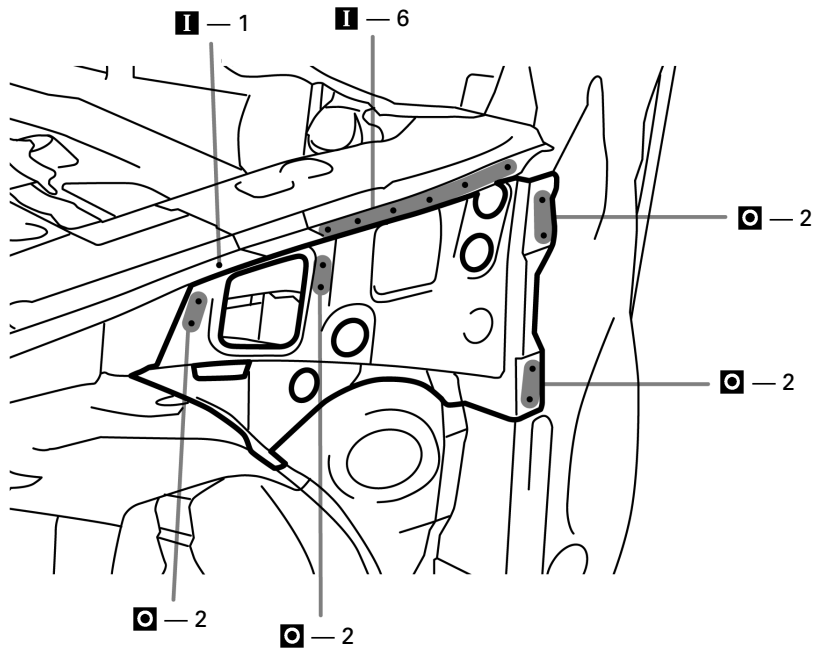
COWL TOP SIDE PANEL (ASSY)



REMOVAL

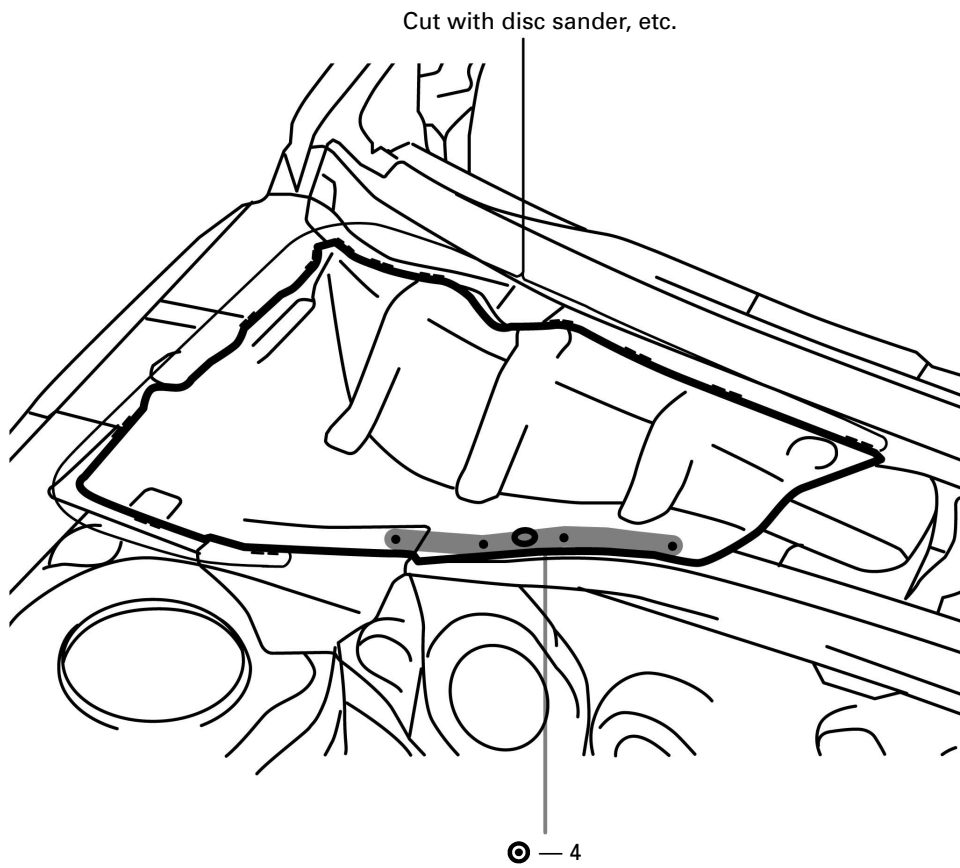
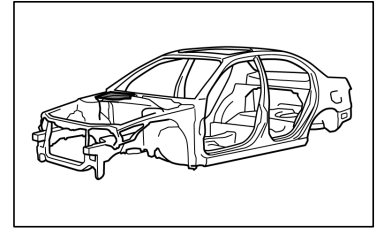


INSTALLATION



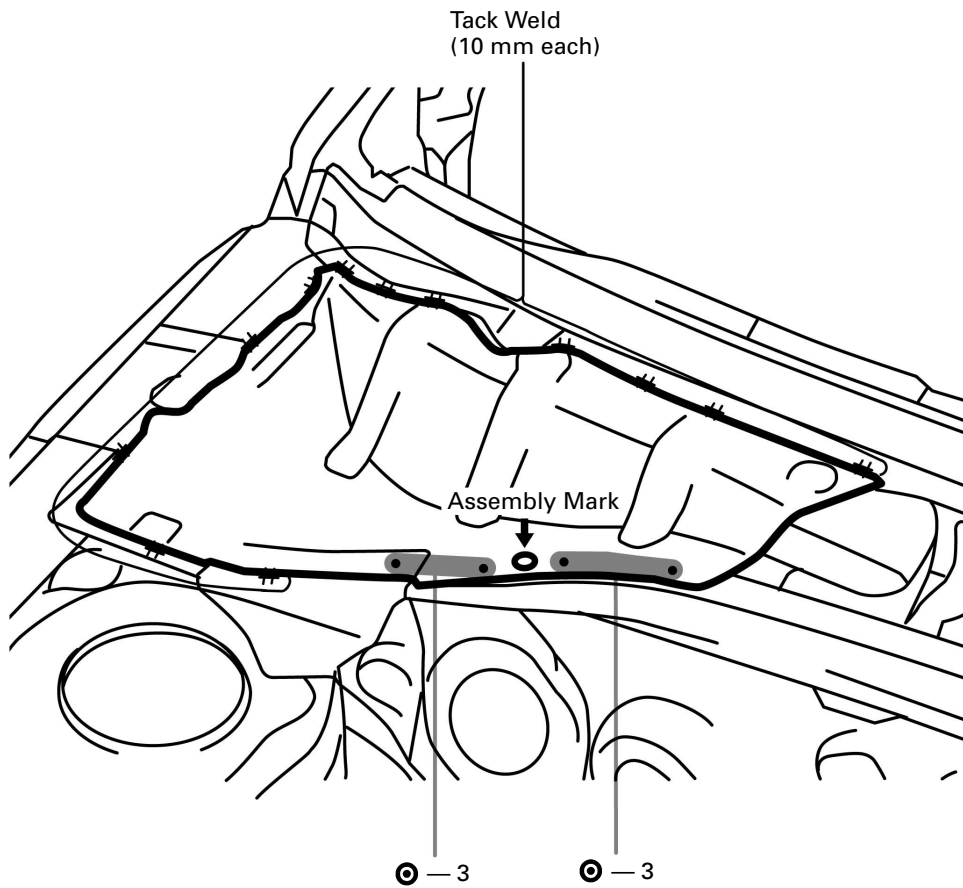
COWL TOP SIDE REINFORCEMENT (ASSY)

REMOVAL



④ — 4

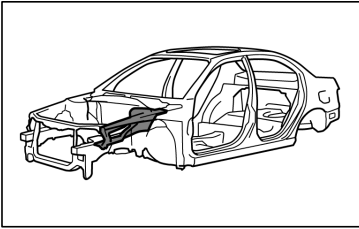
INSTALLATION



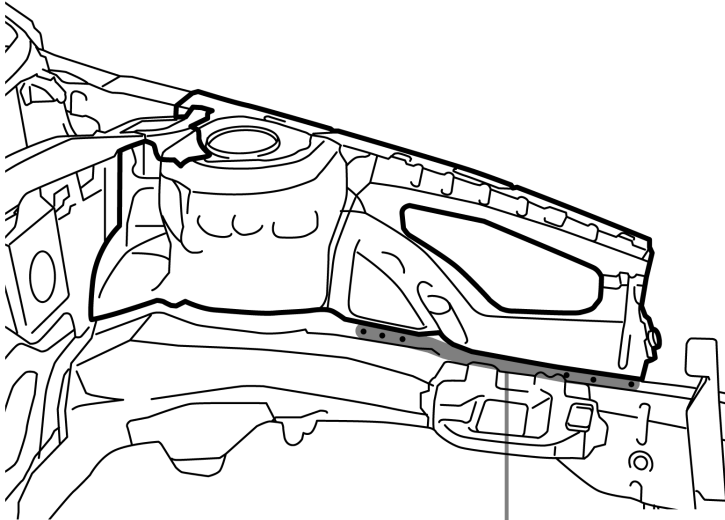
mm	in.
10	0.39

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

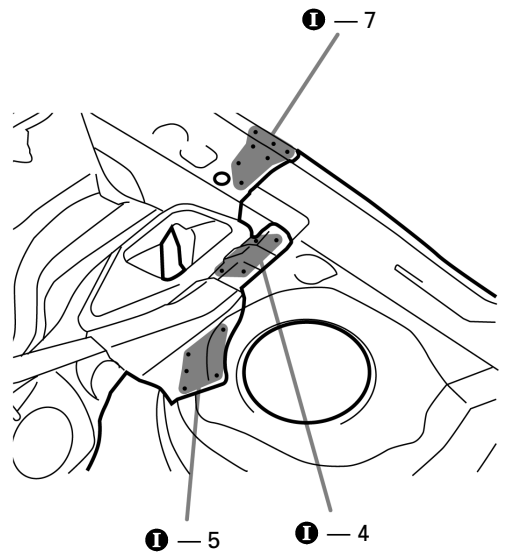
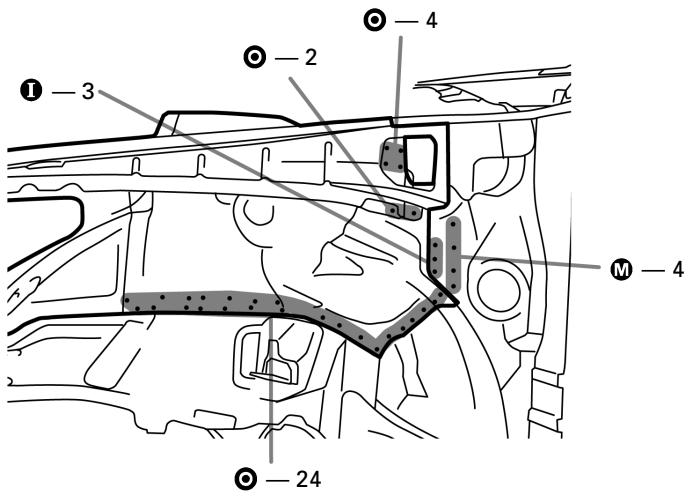
FRONT FENDER APRON (ASSY)



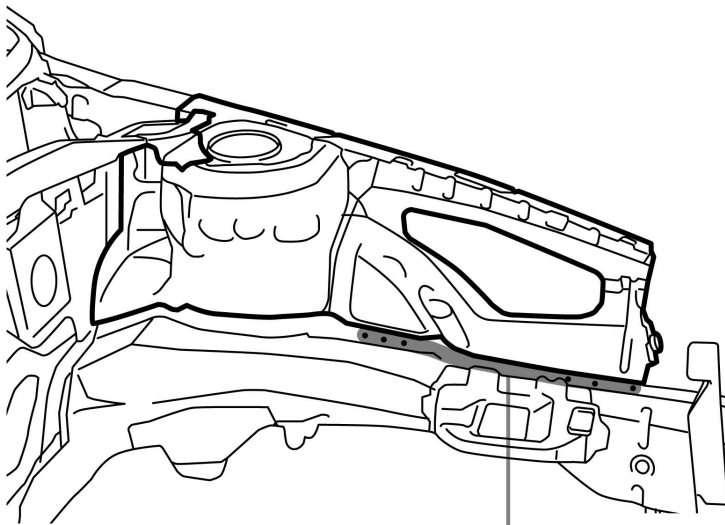
REMOVAL (With the radiator upper support, cowl top side panel and cowl top side reinforcement removed.)



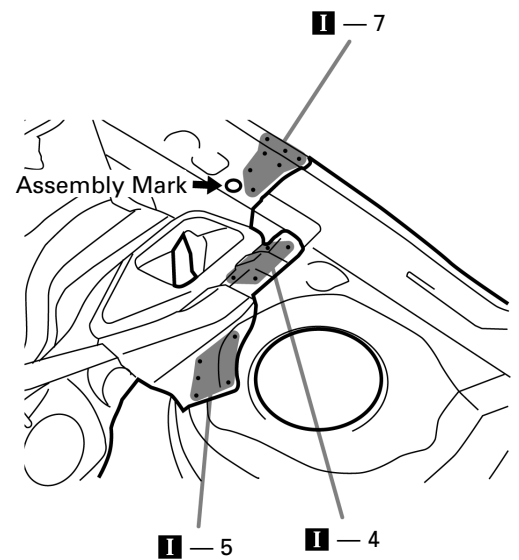
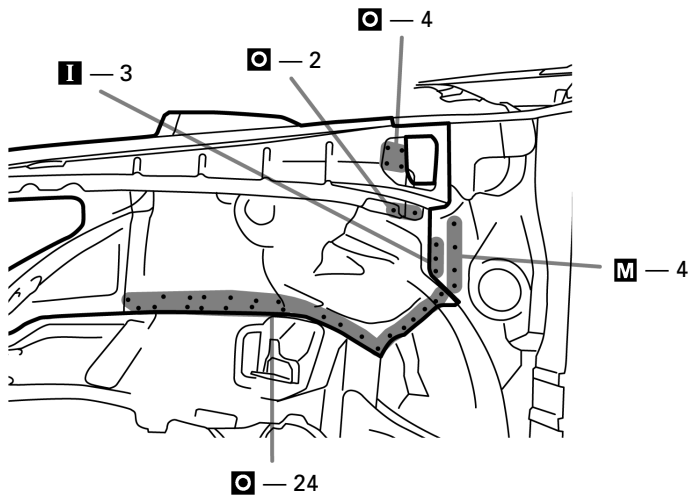
LH (AT, ST series): **I** - 12
LH (CT series): **I** - 9
RH: **I** - 11



INSTALLATION



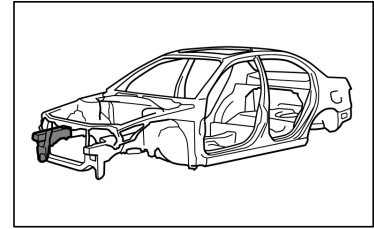
LH (AT, ST series): **I** — 12
 LH (CT series): **I** — 9
 RH: **I** — 11



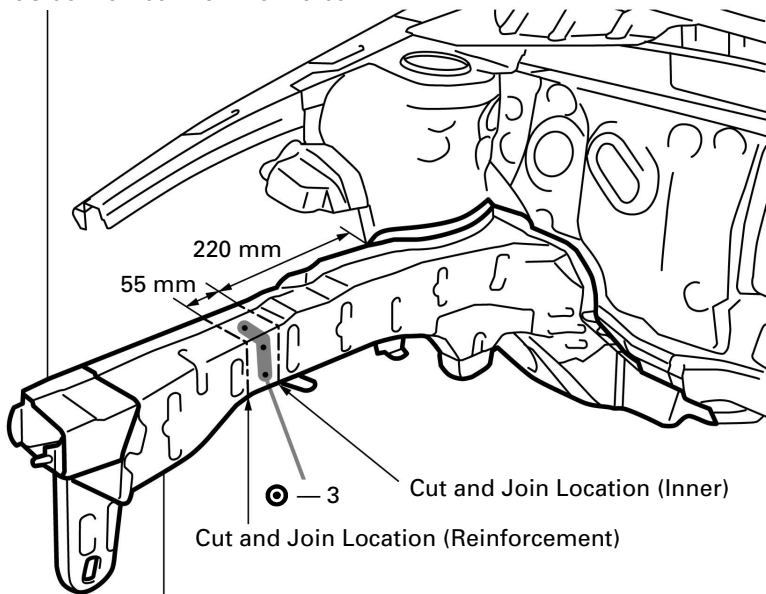
1. When temporarily installing the new parts, determine the installation position by the assembly mark.
2. Measurements must be accurate with the body dimension diagram, as this affects the front wheel alignment.
3. Temporarily install the front fender and hood, and check the fit.

FRONT SIDE MEMBER (CUT-P): RH

REMOVAL (With the radiator support and front fender front apron removed.)

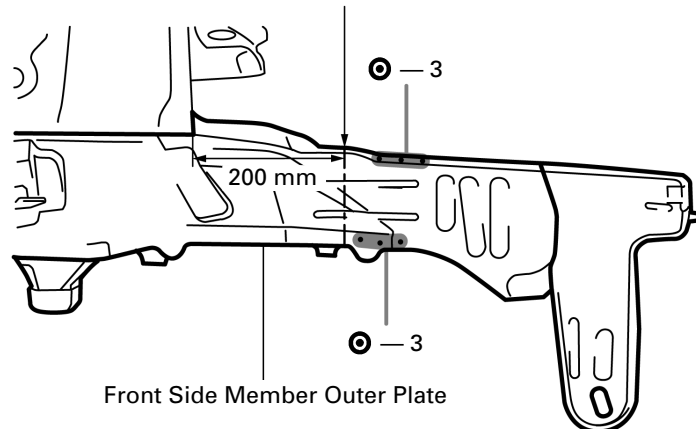


Front Side Member No.2 Reinforce



Front Side Member

Cut and Join Location

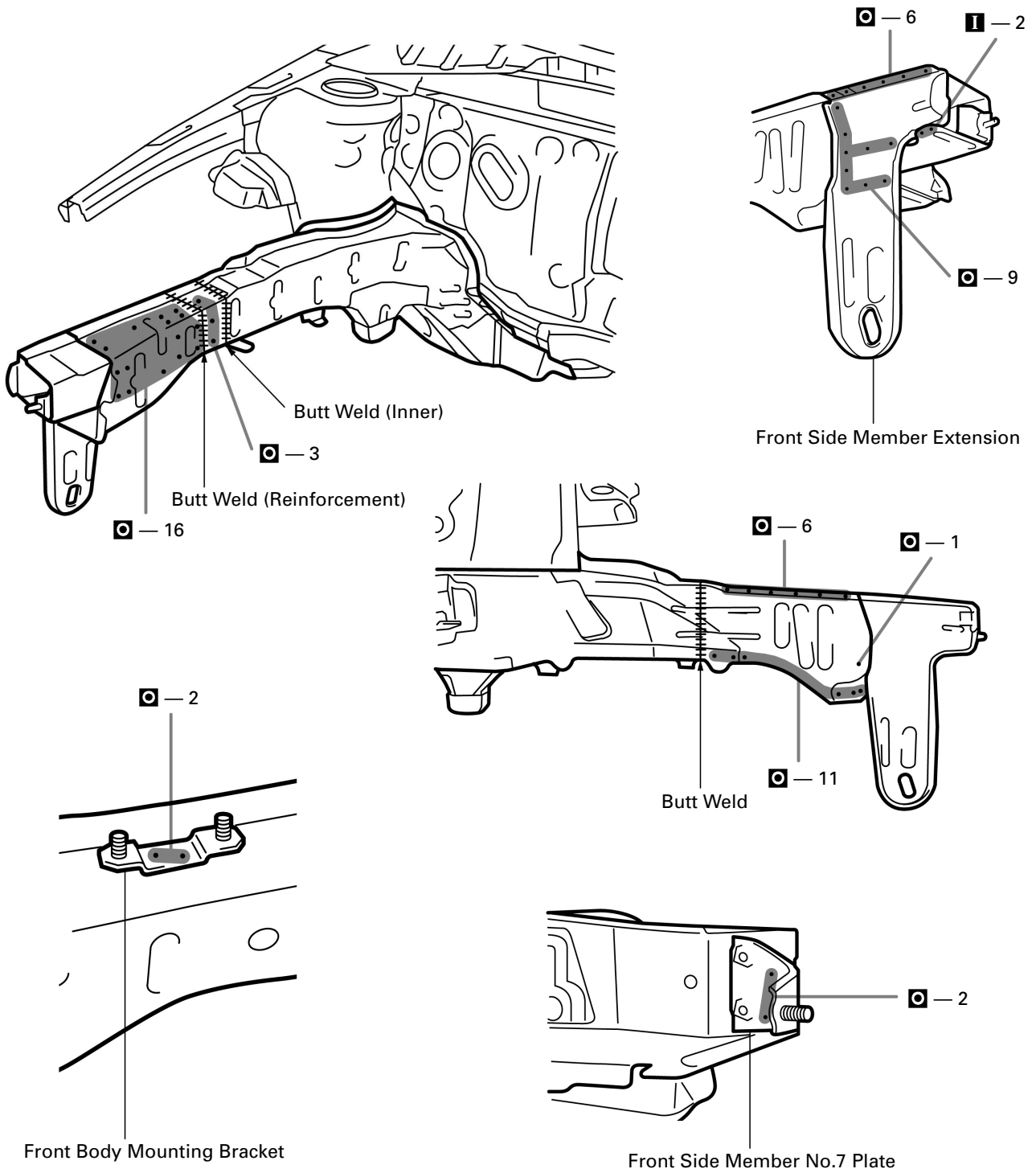


Front Side Member Outer Plate

mm	in.
55	2.17
200	7.87
220	8.66

1. Cut and join the parts at the locations as shown above.
2. Shift the cut and join location of the front side member, front side member No.2 reinforce and front side member outer plate.

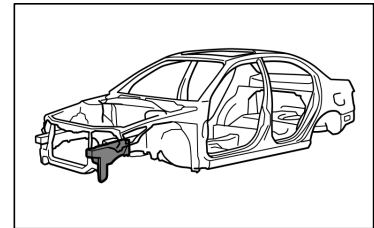
INSTALLATION



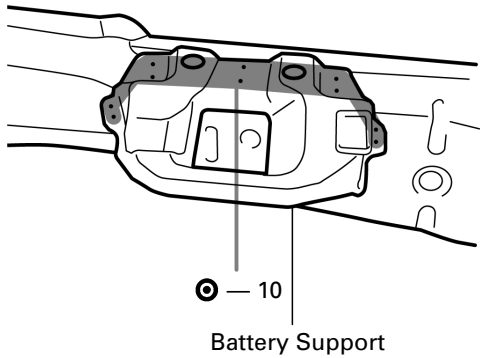
1. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.

FRONT SIDE MEMBER (CUT-P): LH

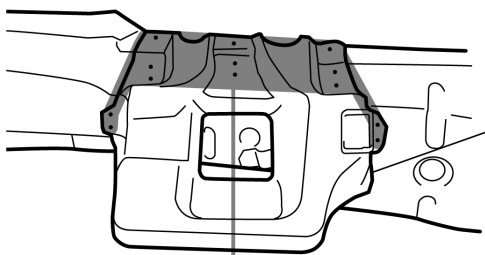
REMOVAL (With the radiator support and front fender front apron removed.)



[AT, ST series]

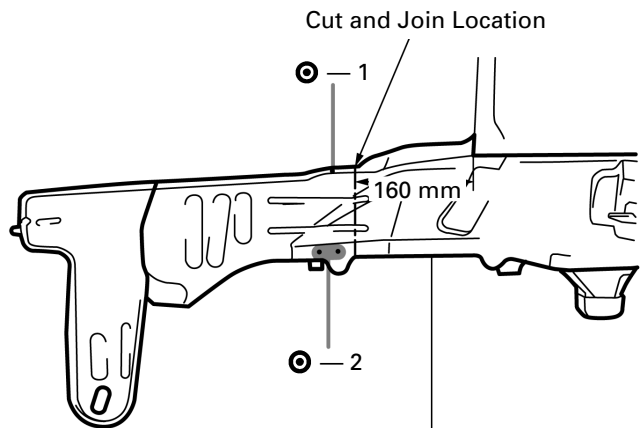
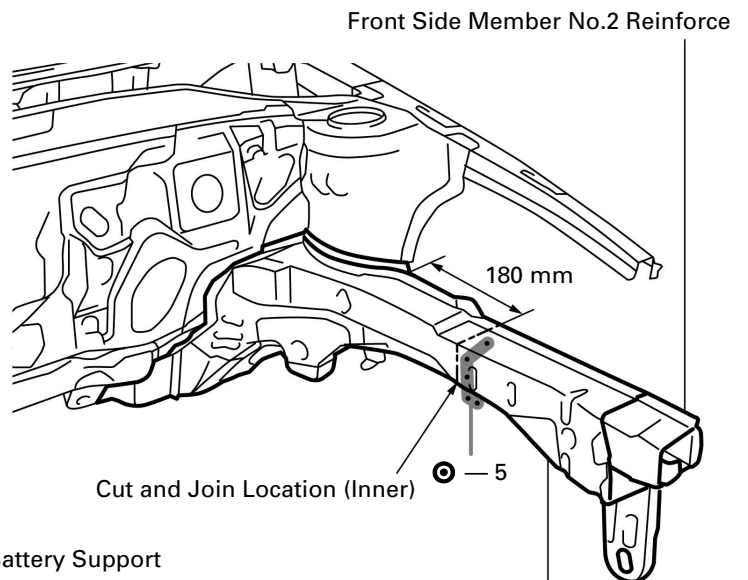
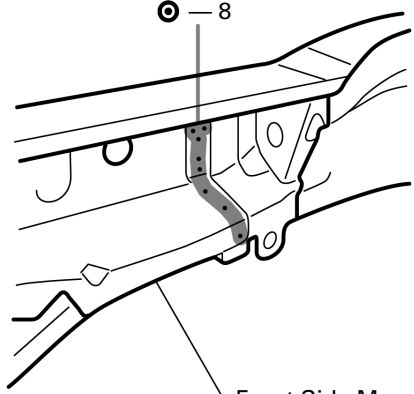


[CT series]



● - 13

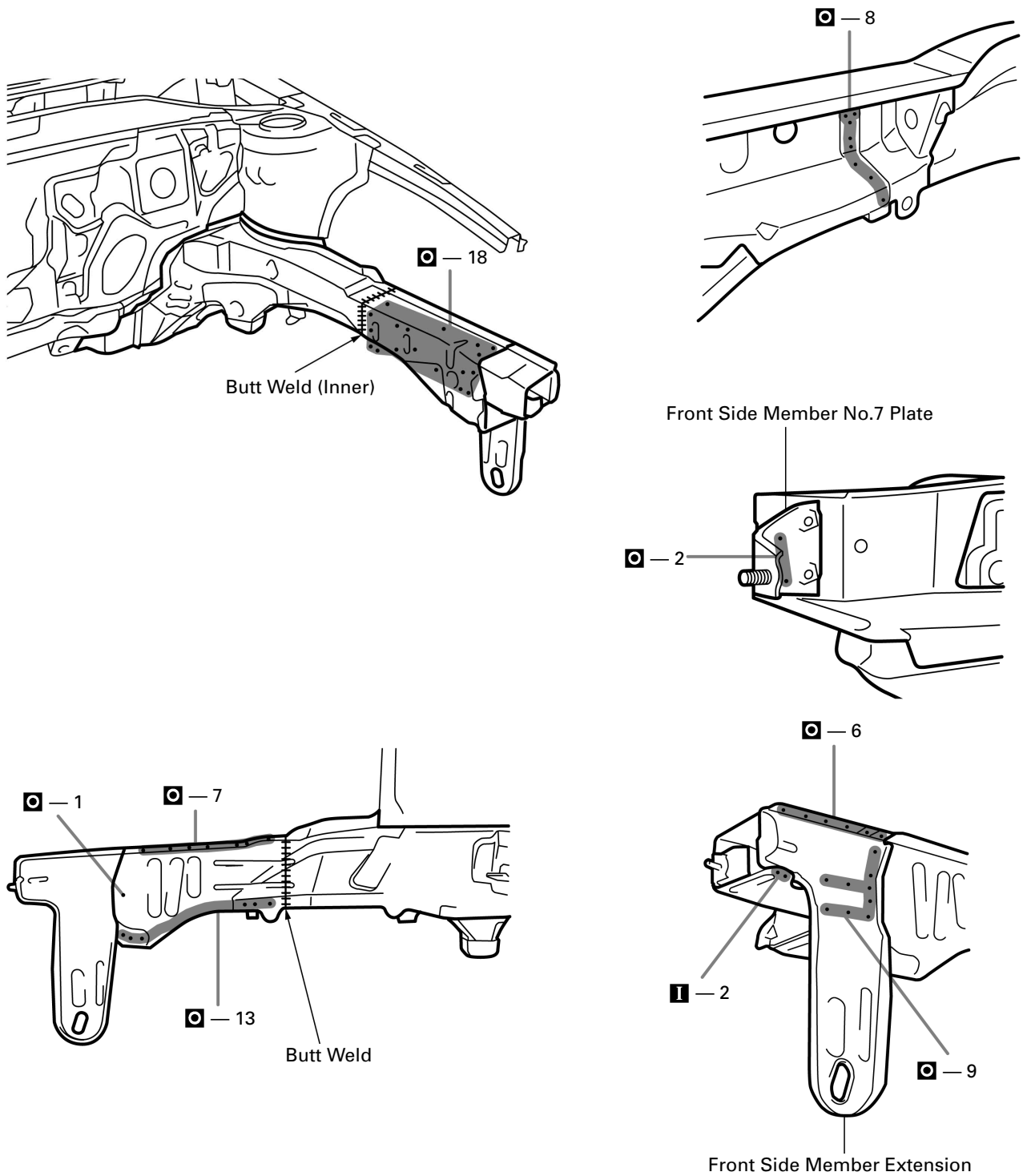
● - 8



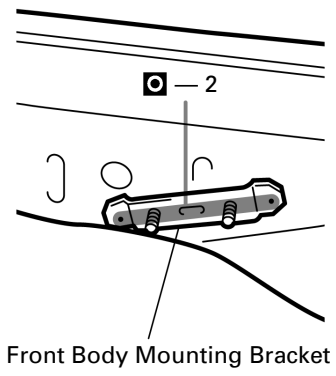
mm	in.
160	6.30
180	7.09

1. After removing the battery support, cut and join the parts at the locations as shown above.
2. Shift the cut and join location of the front side member and front side member outer plate.
3. Remove the front side member No.2 reinforcement from the front side member No.2 reinforcement.

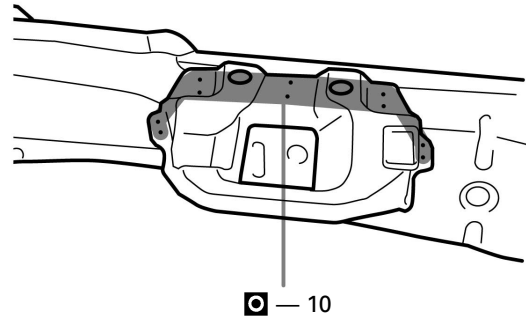
INSTALLATION



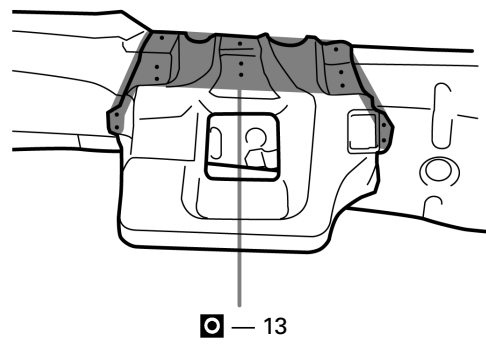
1. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.



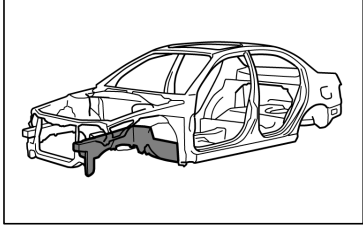
[AT, ST series]



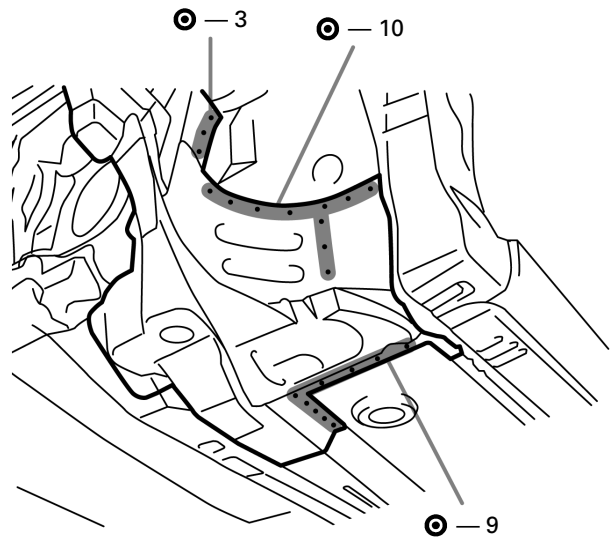
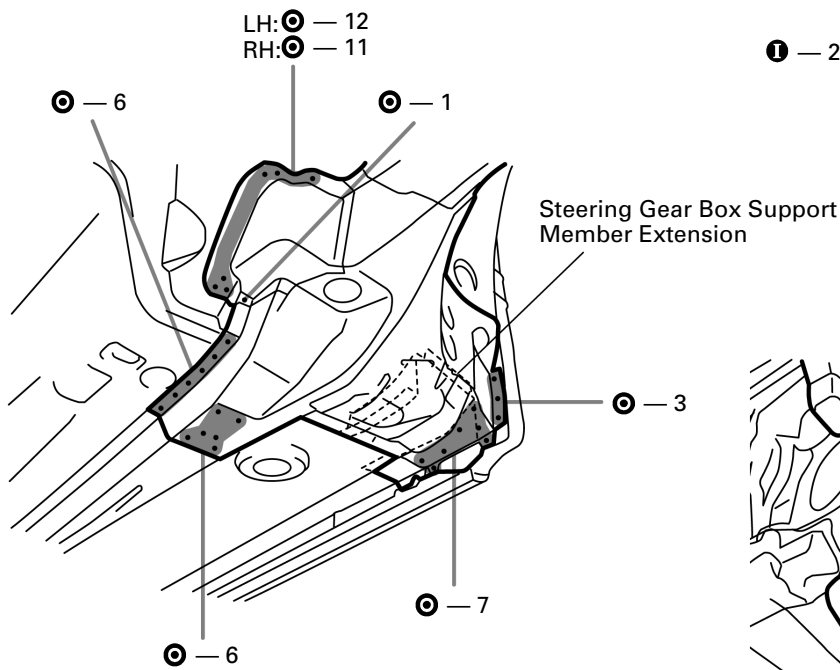
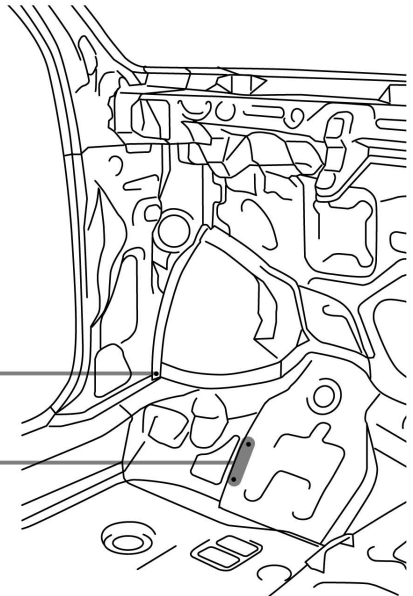
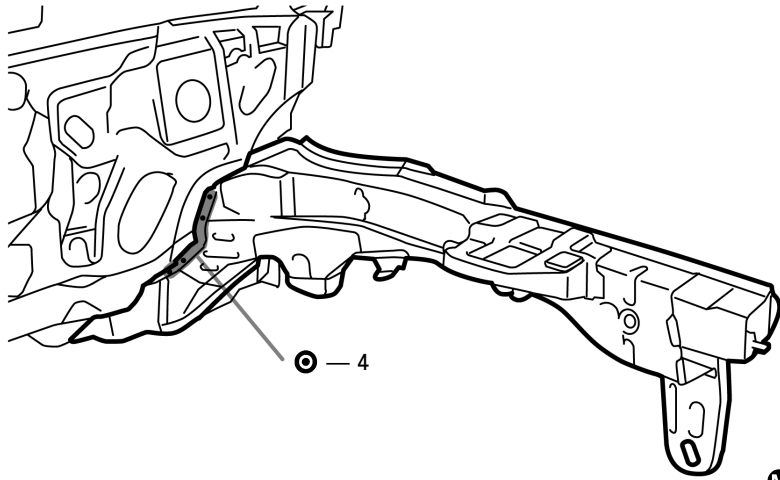
[CT series]



FRONT SIDE MEMBER (ASSY)

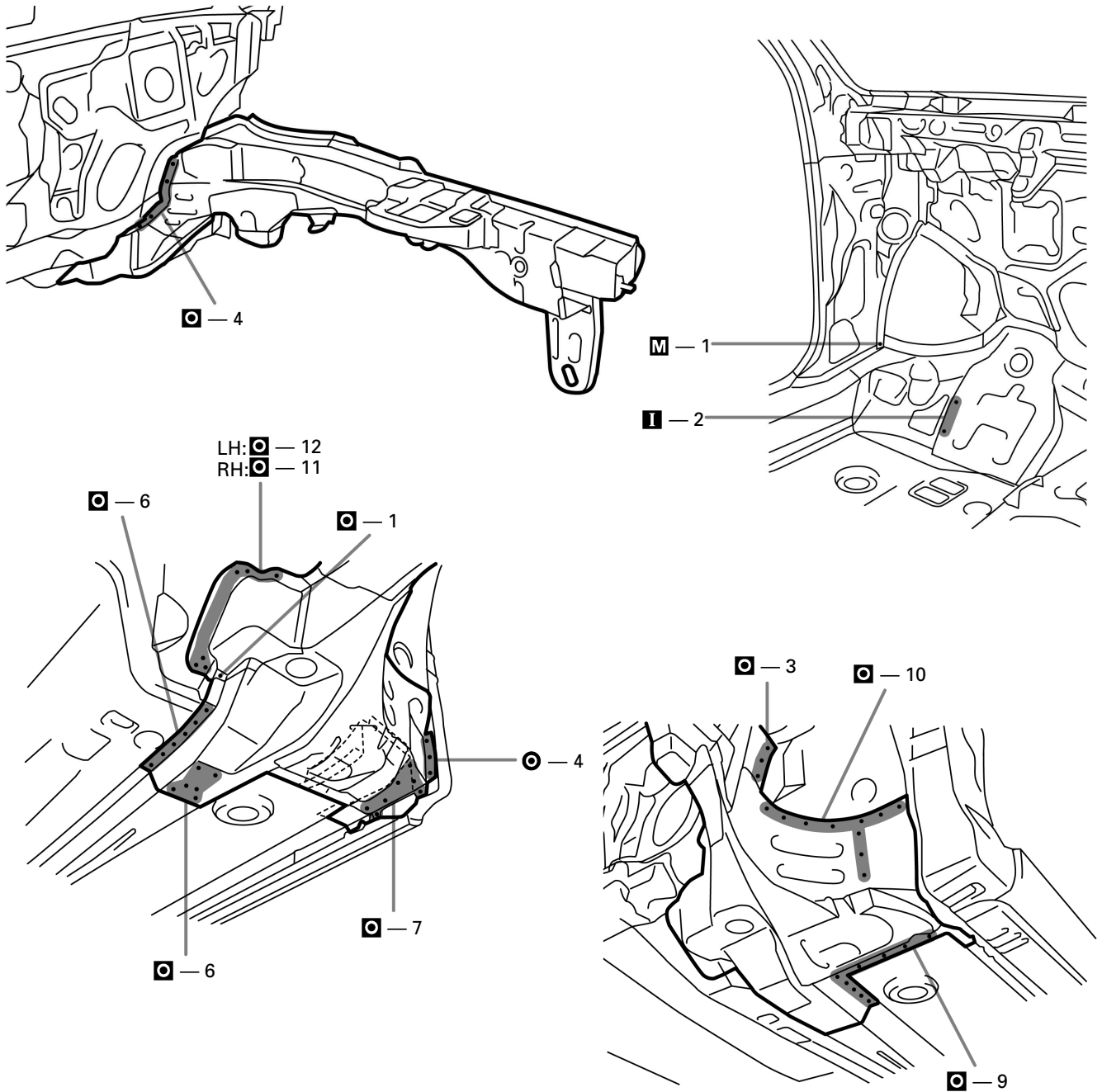


REMOVAL (With the radiator support and front fender apron removed.)



1. Leave the steering gear box support member extension to the vehicle side and remove the front side member.

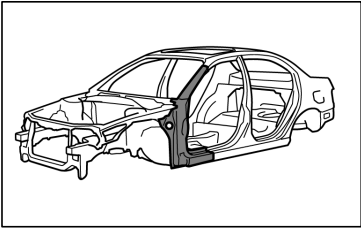
INSTALLATION



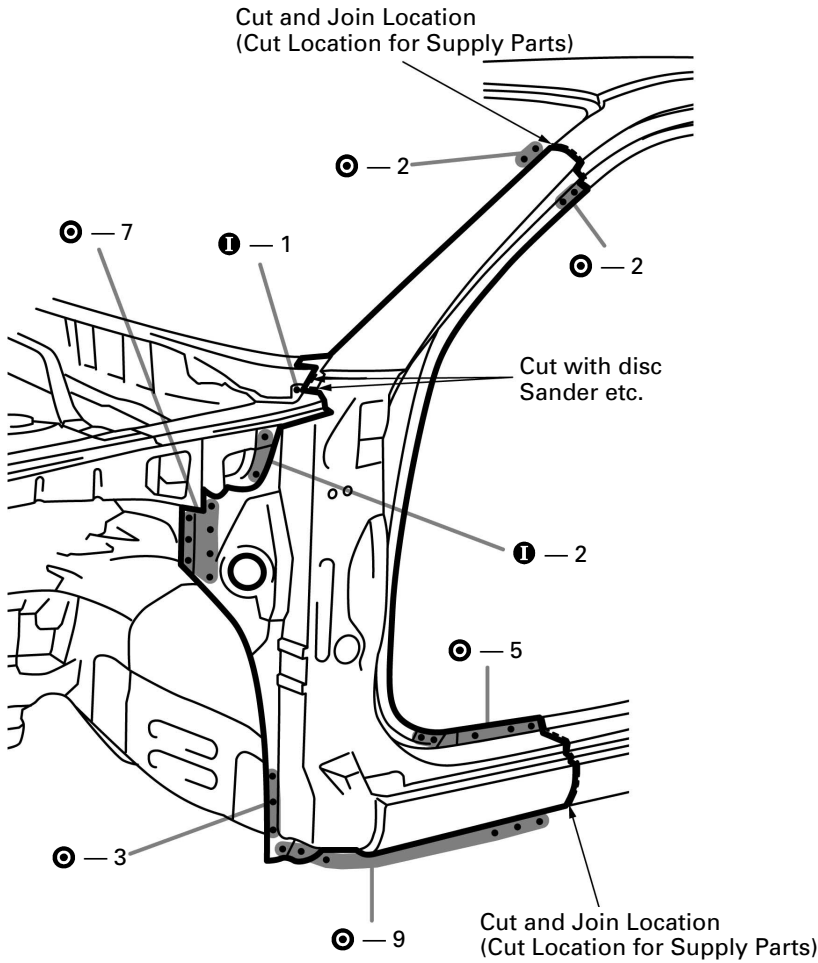
1. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.

HINT: Make sure each measurement is correct, as this parts affects the front wheel alignment.

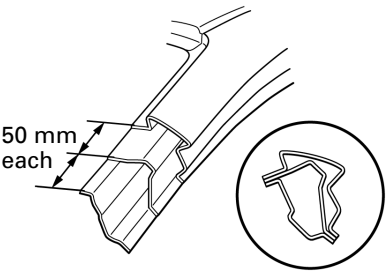
FRONT BODY PILLAR (CUT)



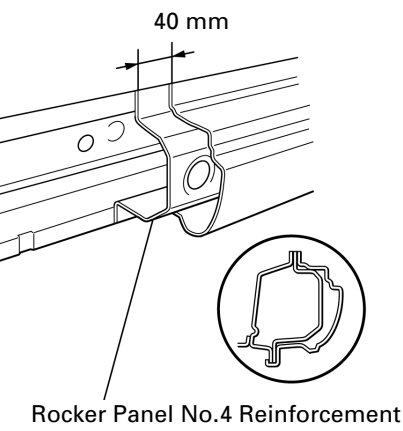
REMOVAL (With the cowl top side panel and cowl top side reinforcement removed.)



[Cut and Join Location]

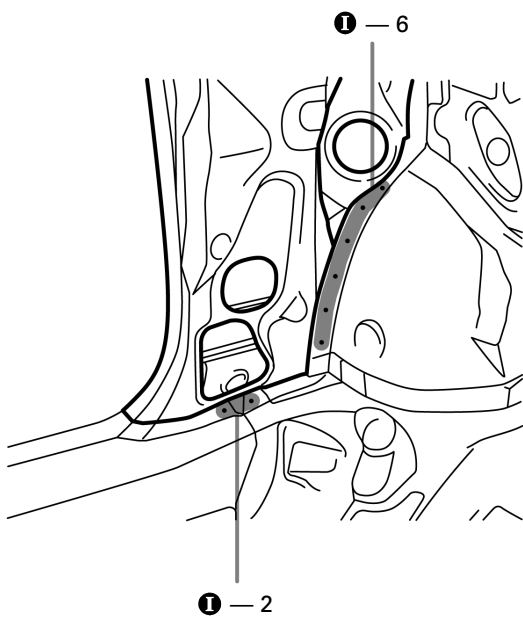
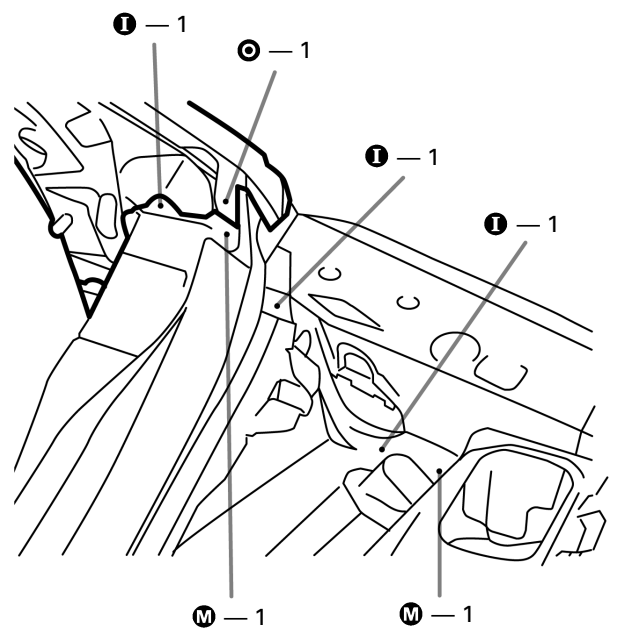
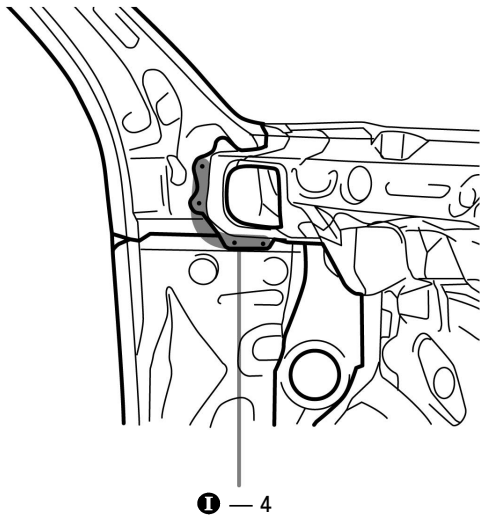


[Cut and Join Location]

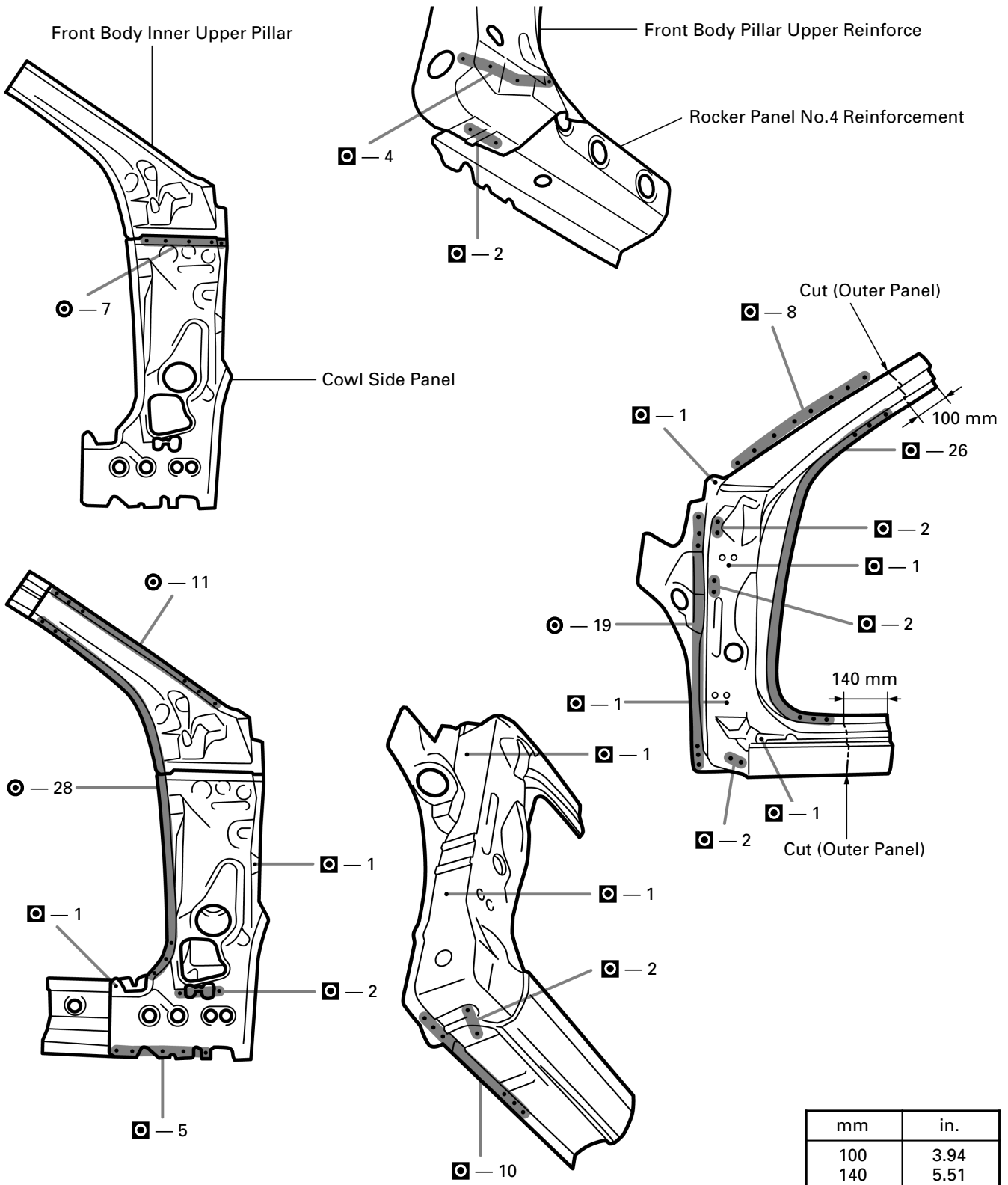


mm	in.
40	1.60
50	1.97

1. Cut and join the parts at the locations as shown above.
2. Shift the each cut and join locations of the outer pillar, reinforcement and inner pillar.
3. Shift the each cut and join locations of the outer panel and rocker panel No.4 reinforcement.

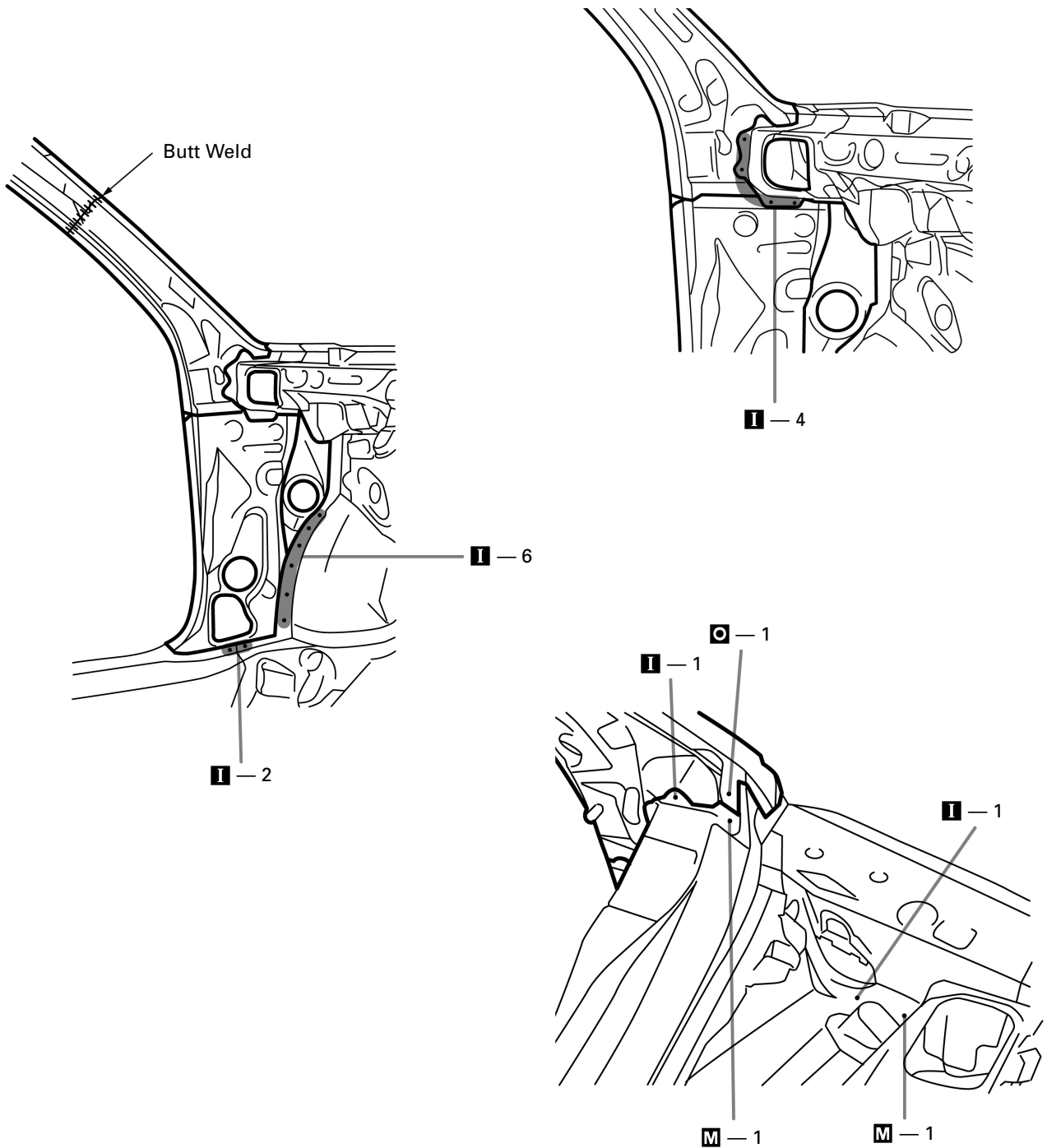


INSTALLATION



1. Cut a width of 100 mm (3.94 in.) at the top of the outer pillar and a 140 mm (5.51 in.) at the rocker.
2. Before temporarily installing the new parts, weld the front body inner upper pillar, cowl side panel, front body pillar upper reinforce, rocker panel No.4 reinforcement and outer panel with standard points.

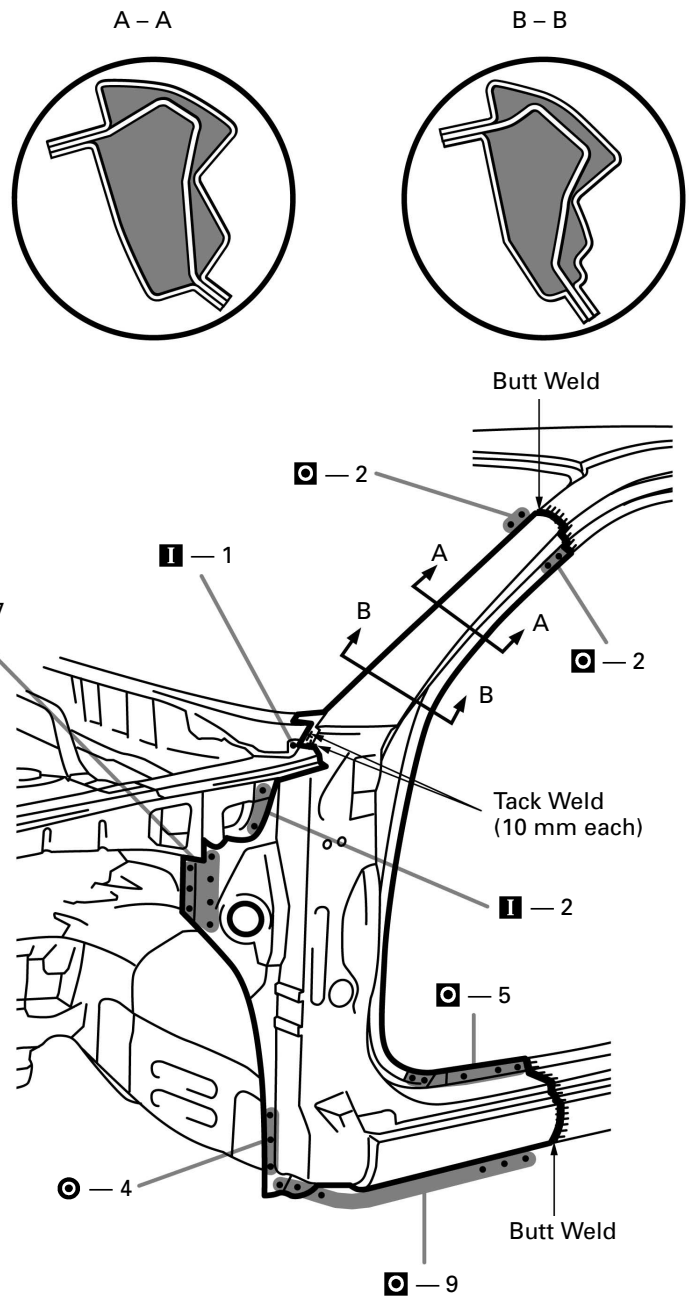
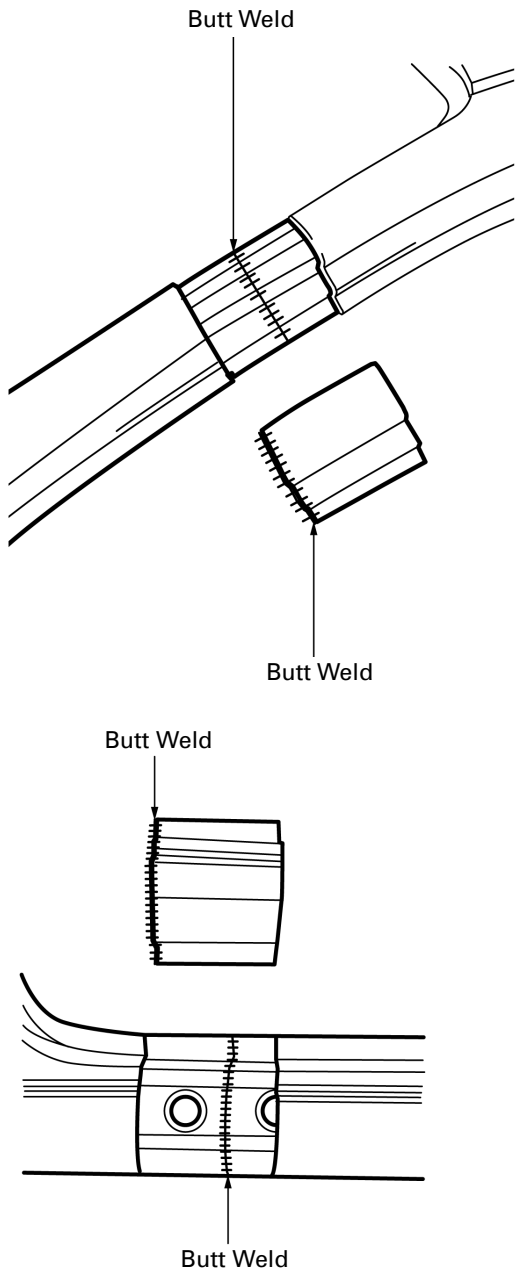
(Continued on Next Page)



3. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.
4. Before welding the new parts, check the fit of the front door, front fender and windshield glass.

(Cont'd)

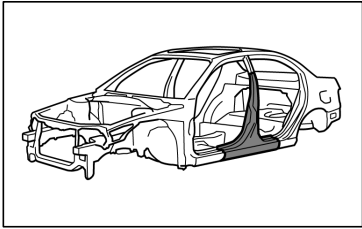
[Foamed Material Application Areas]



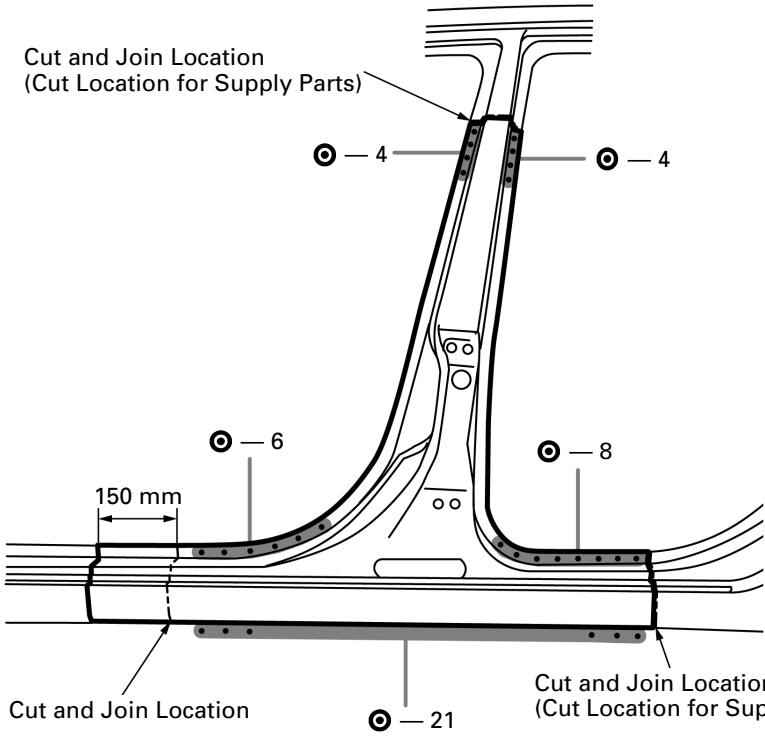
mm	in.
10	0.39

- At the front pillar's cut and join location, install the outer panel after butt welding the front pillar reinforcement.
- At the rocker's cut and join location, install the outer panel after butt welding the rocker panel No.4 reinforcement.

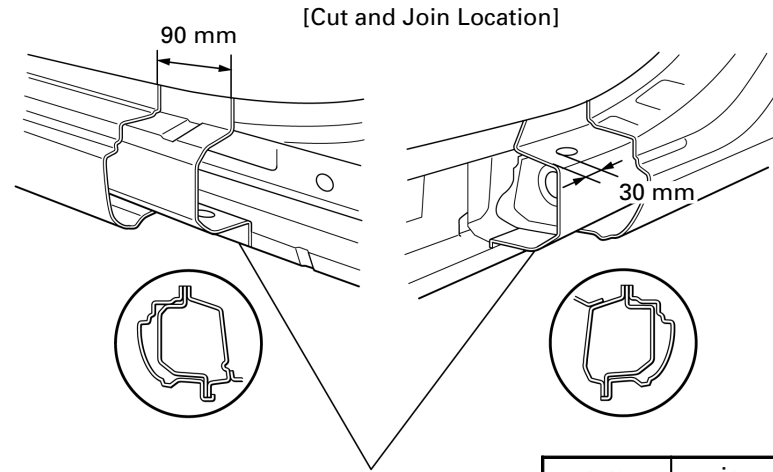
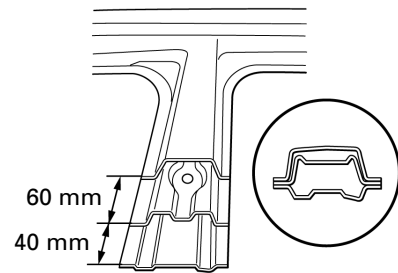
CENTER BODY PILLAR (CUT)



REMOVAL

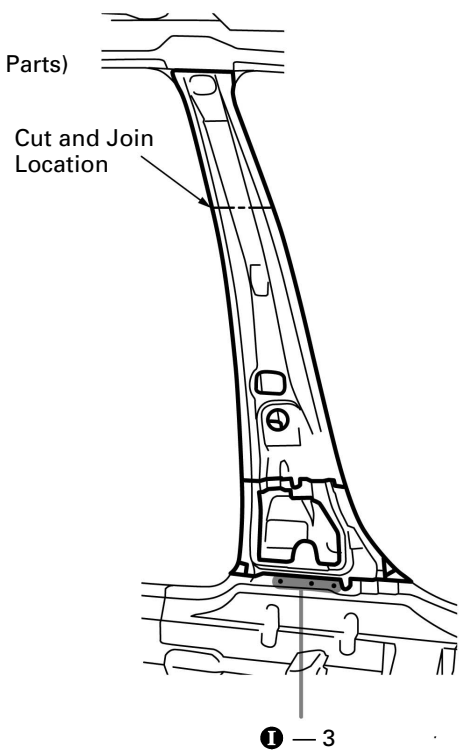


[Cut and Join Location]



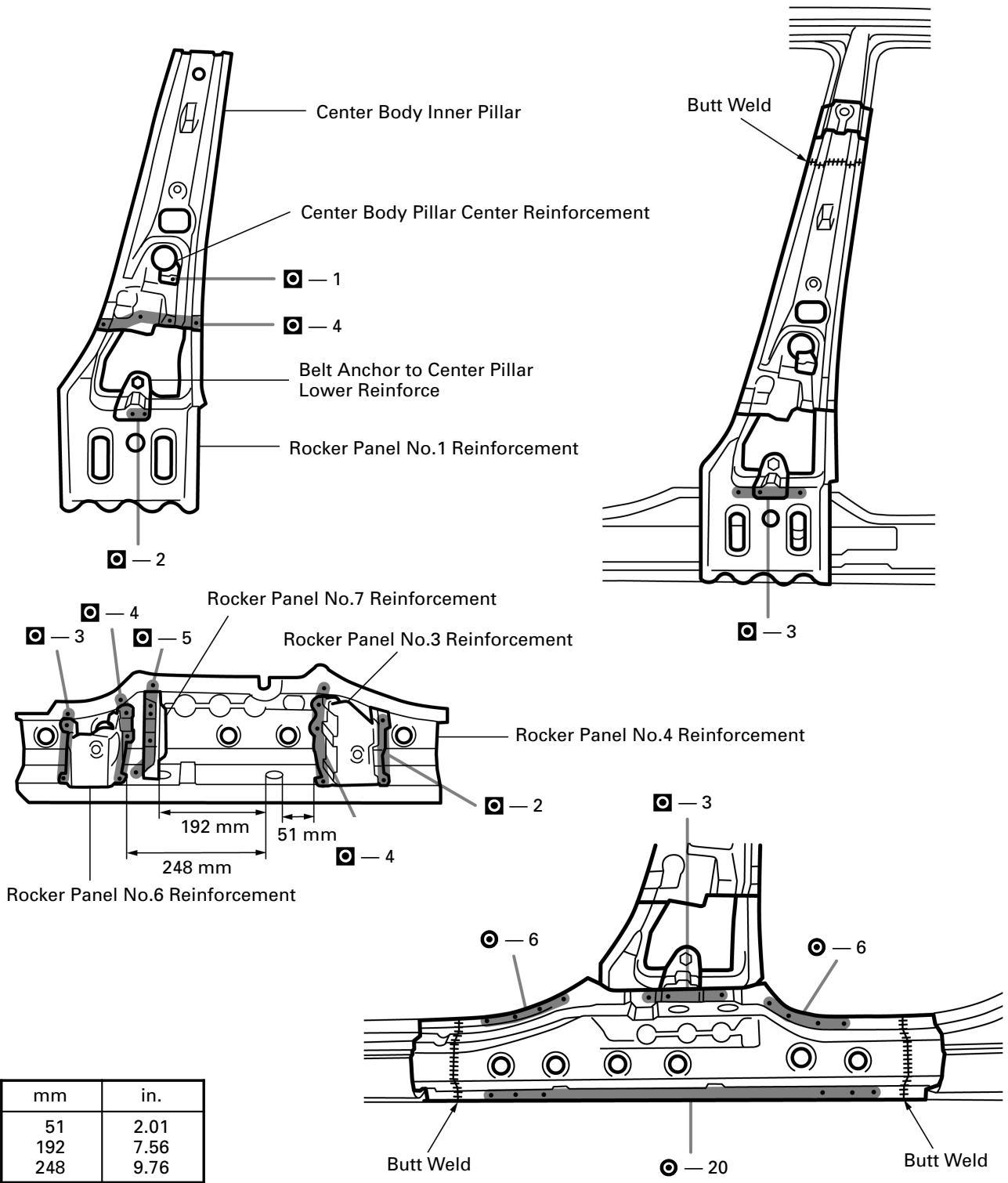
Rocker Panel No.4 Reinforcement

mm	in.
30	1.18
40	1.57
60	2.36
90	3.54
150	5.91



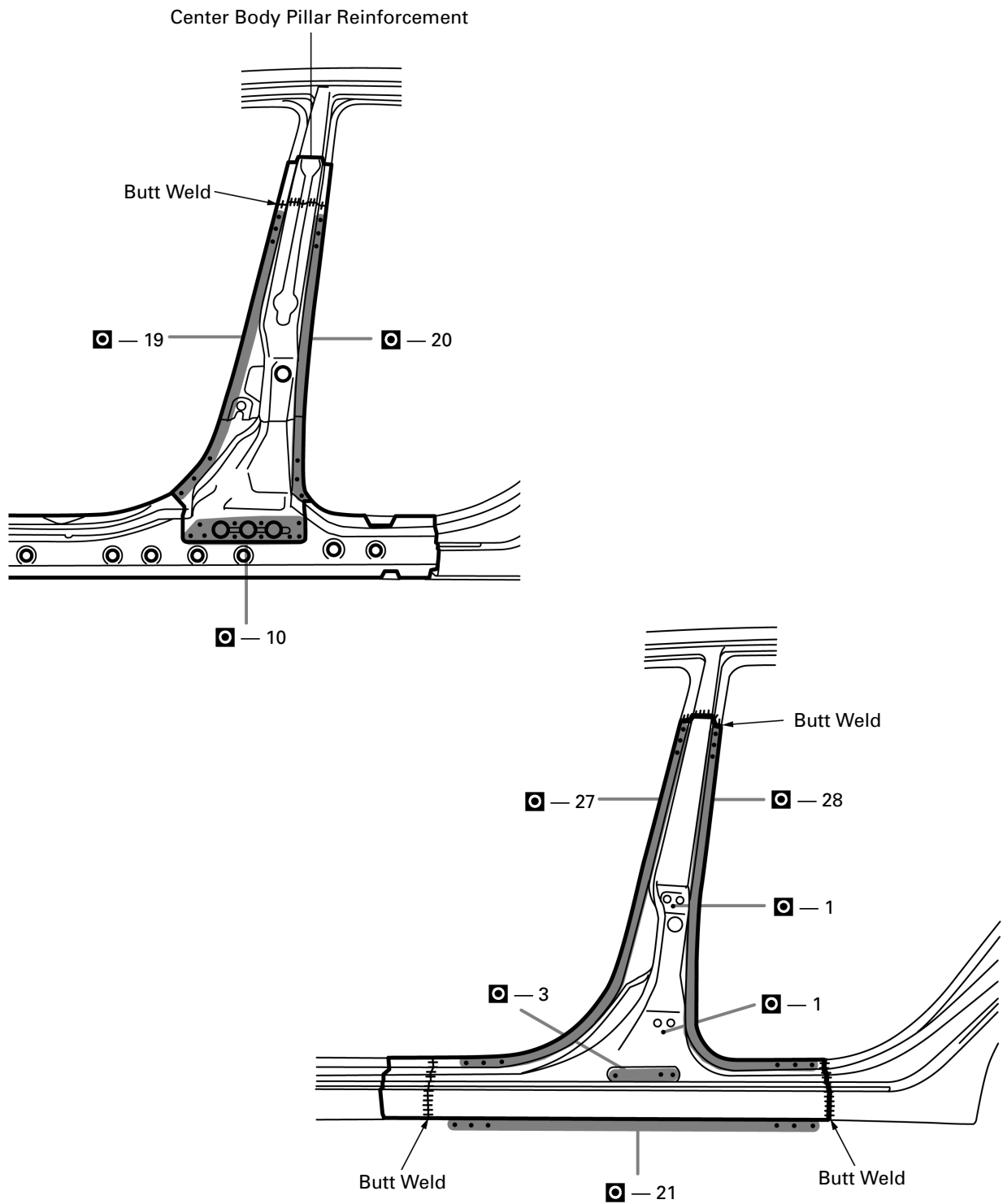
1. Cut and join the parts at the locations as shown above.
2. Shift the each cut and join locations of the center outer pillar, reinforcement and inner pillar.
3. Shift the each cut and join locations of the rocker outer and rocker panel No.4 reinforcement.

INSTALLATION

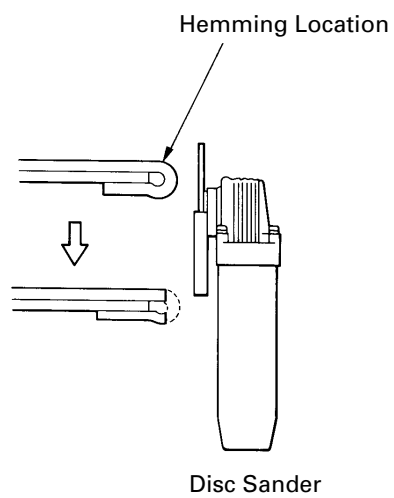
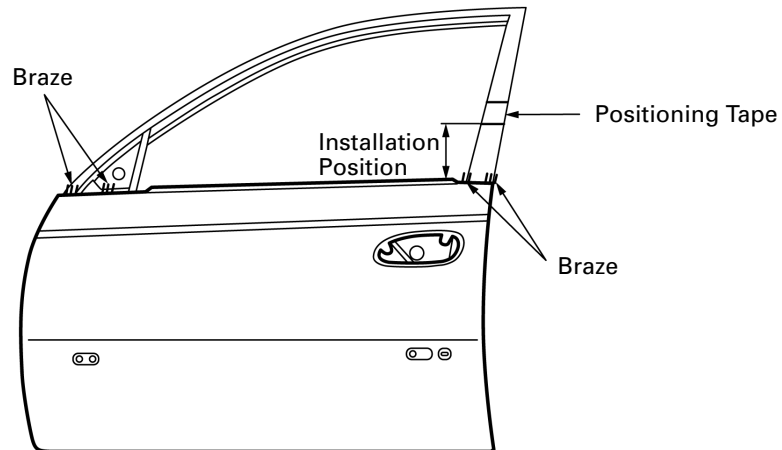
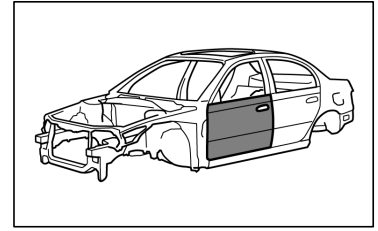


mm	in.
51	2.01
192	7.56
248	9.76

1. Before temporarily installing the new parts, weld the center body inner pillar, center body pillar center reinforcement, belt anchor to center pillar lower reinforce, rocker panel No.1 reinforcement, rocker panel No.4 reinforcement, rocker panel No.3 reinforcement, rocker panel No.7 reinforcement and rocker panel No.6 reinforcement with standard points.
2. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.

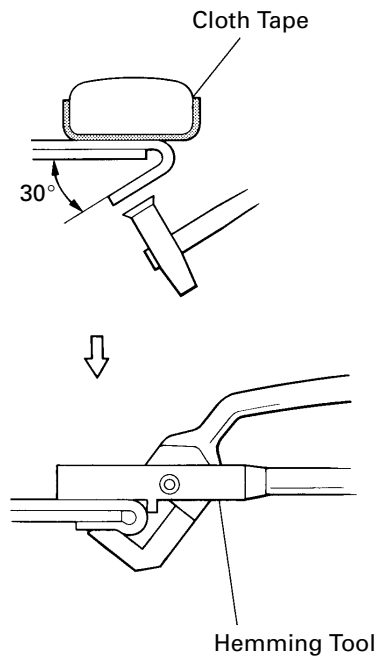
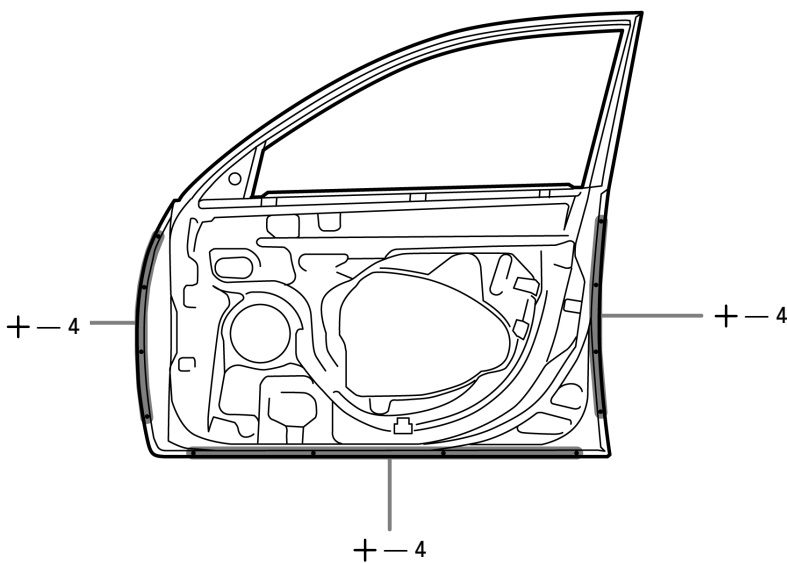
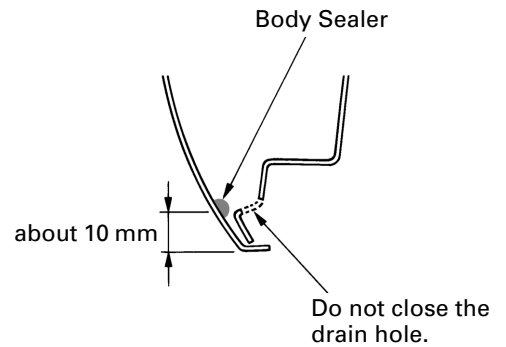
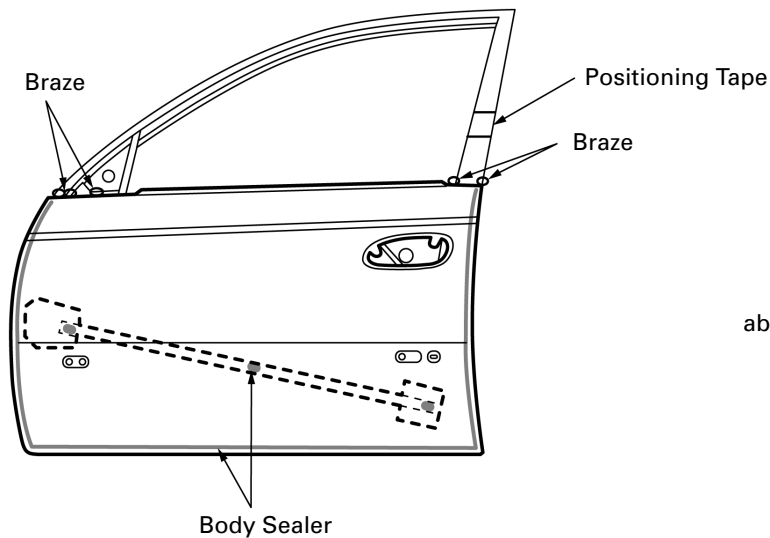


3. Before welding the new parts, check the fit of the front door and rear door.

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.

INSTALLATION



mm	in.
10	0.39

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

HINT:

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

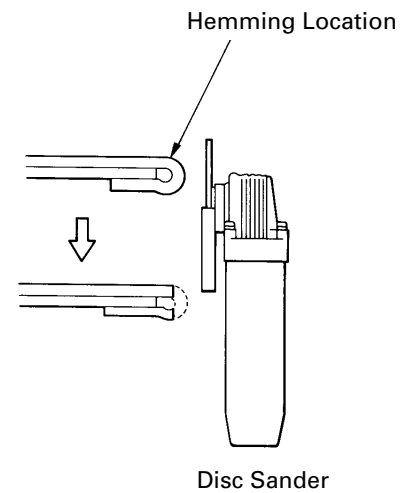
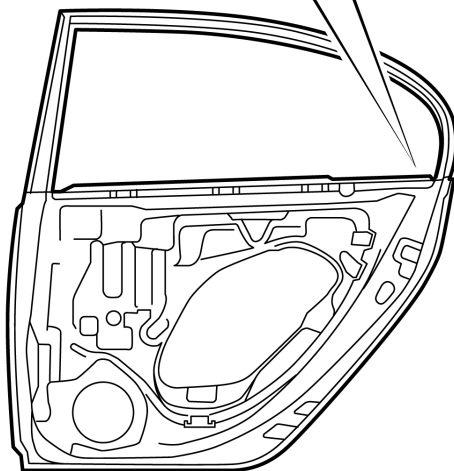
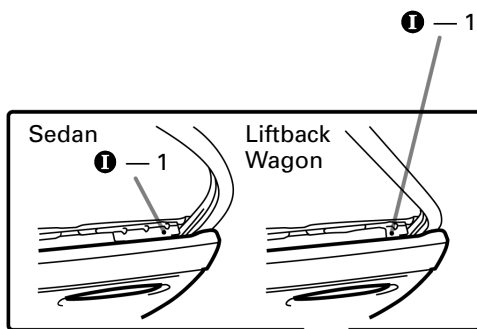
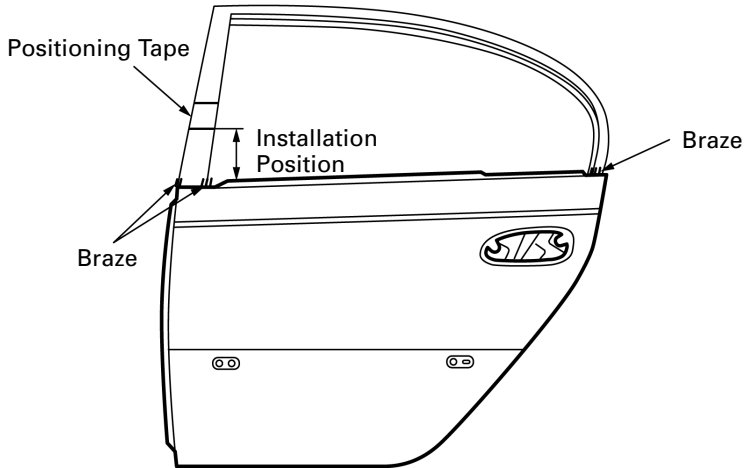
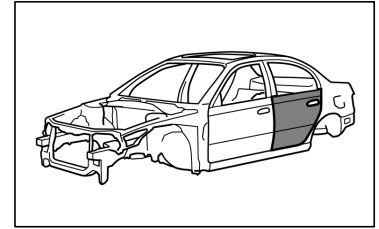
2. Bend the flange hem about 30° with a hammer and dolly, then fasten tightly with a hemming tool.

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.

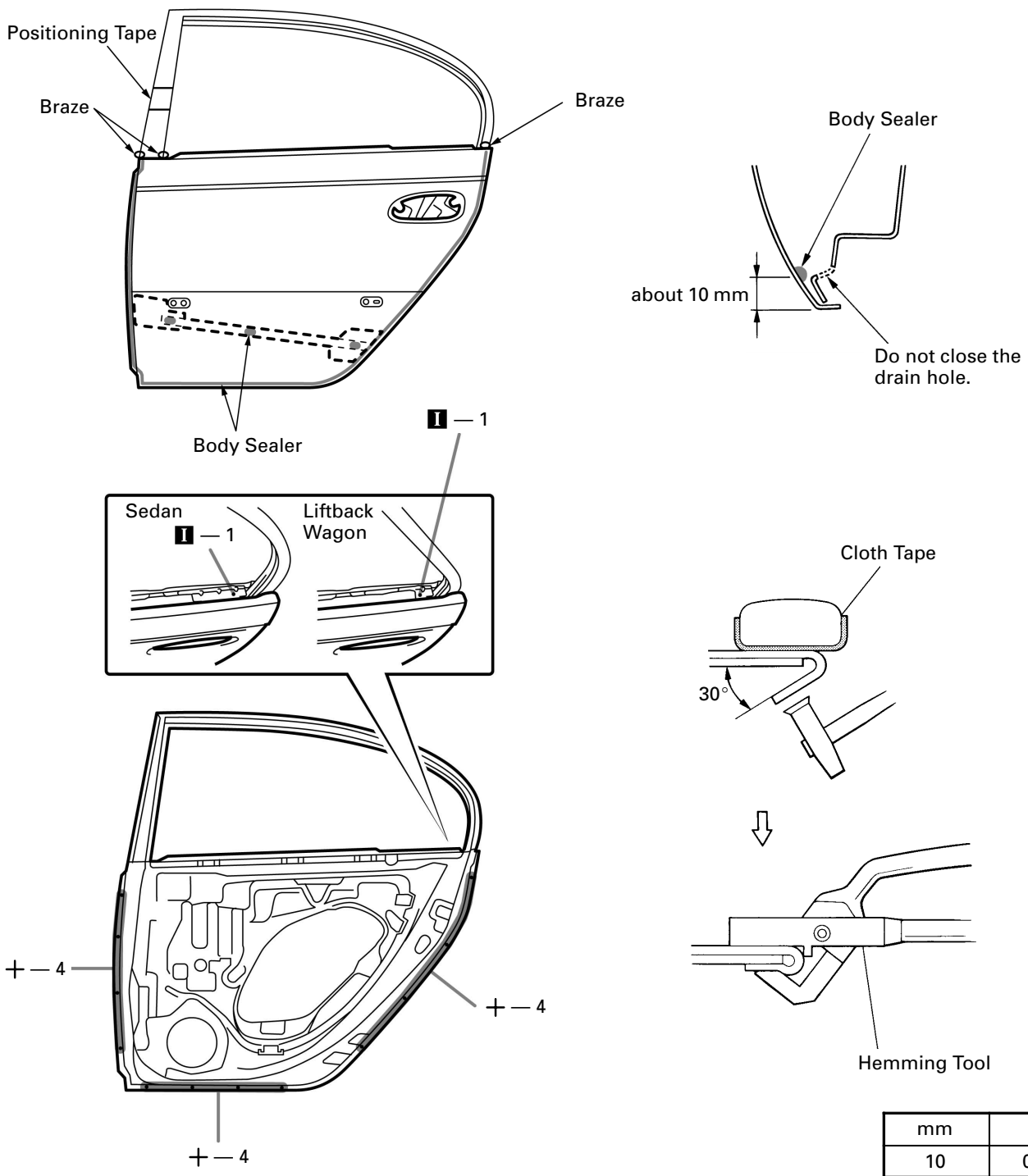
REAR DOOR OUTER PANEL (ASSY)

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.

INSTALLATION



mm	in.
10	0.39

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

HINT:

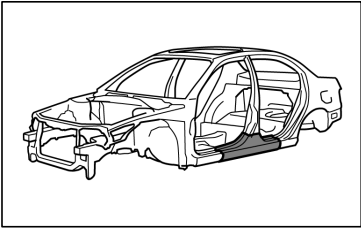
- 1) Apply just enough sealer for the side impact beam to touch the new panel. Apply sealer evenly around the flange area, about 10 mm (0.39 in.) from the edge, as shown.
- 2) For other sealing points, refer to Section AR.

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.

ROCKER OUTER PANEL (CUT)

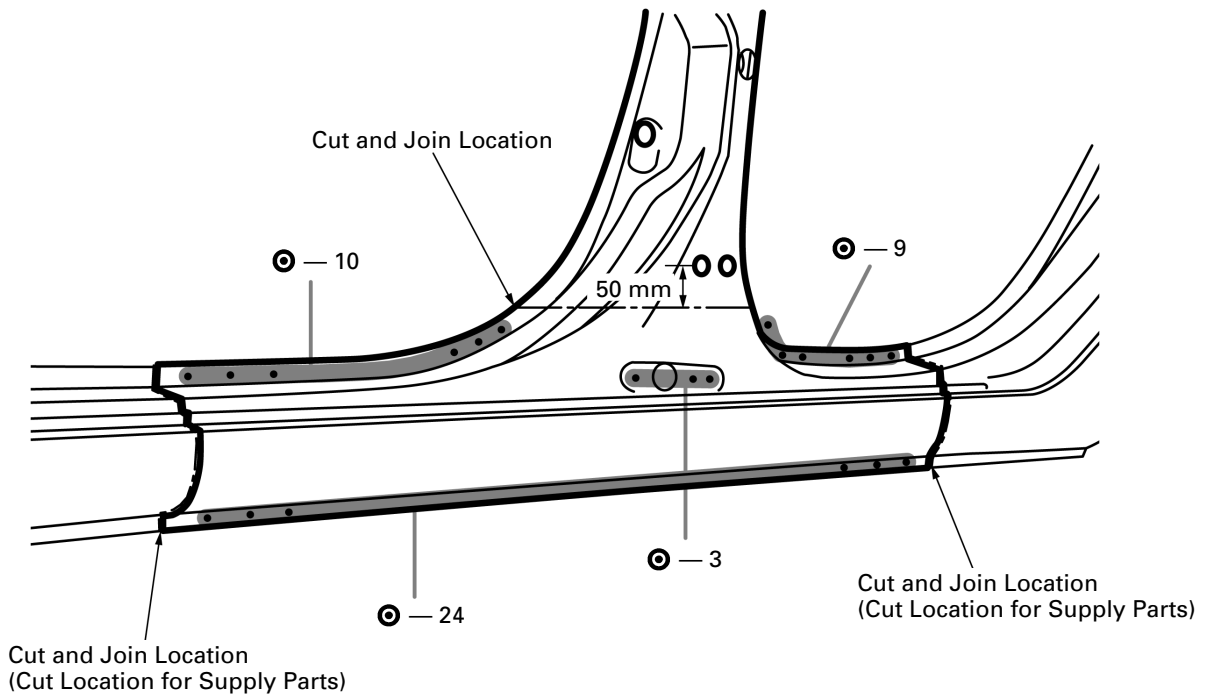
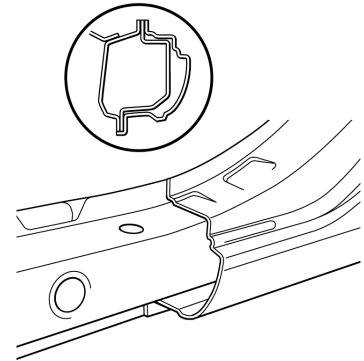
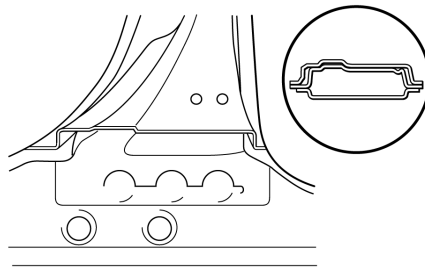
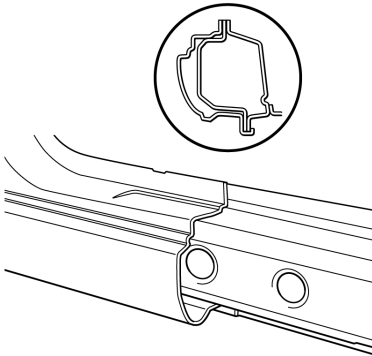


REMOVAL

[Cut and Join Location]

[Cut and Join Location]

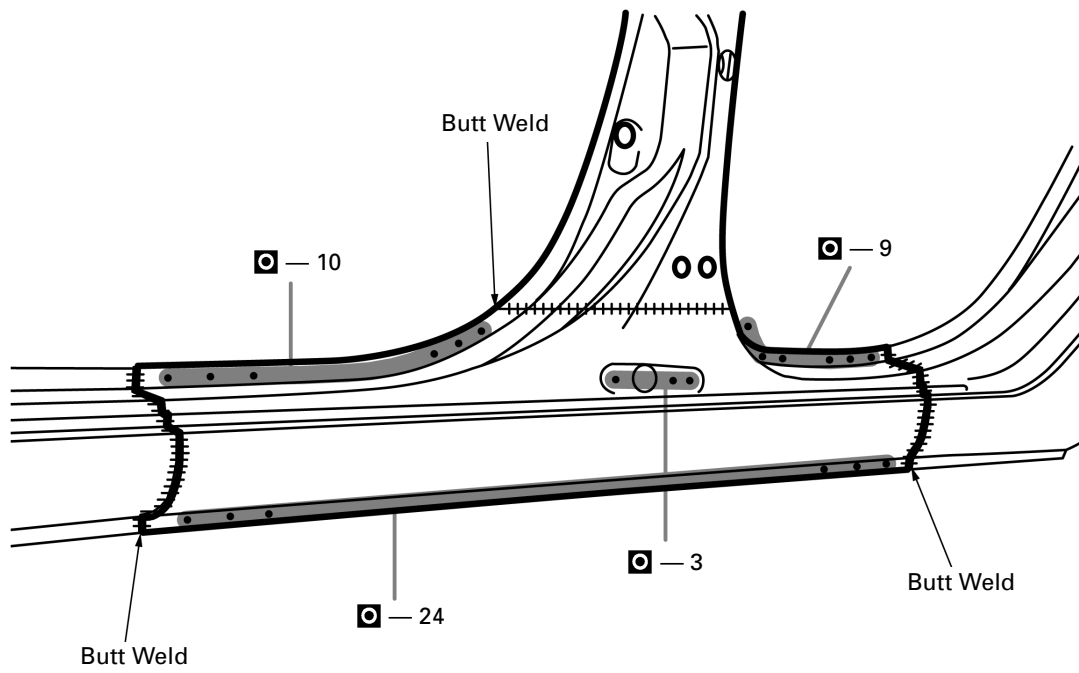
[Cut and Join Location]



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

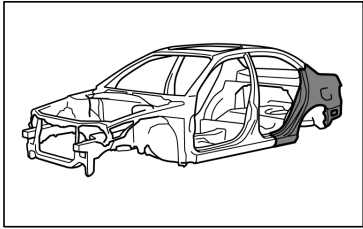
mm	in.
50	1.97

INSTALLATION

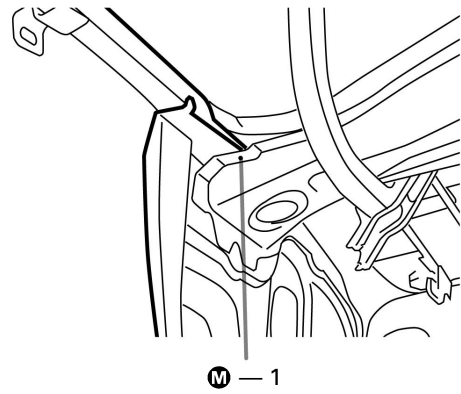
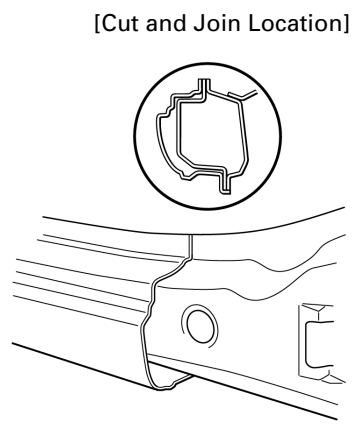
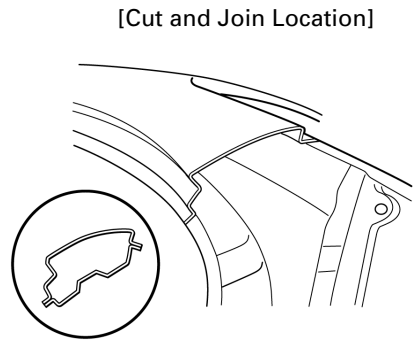
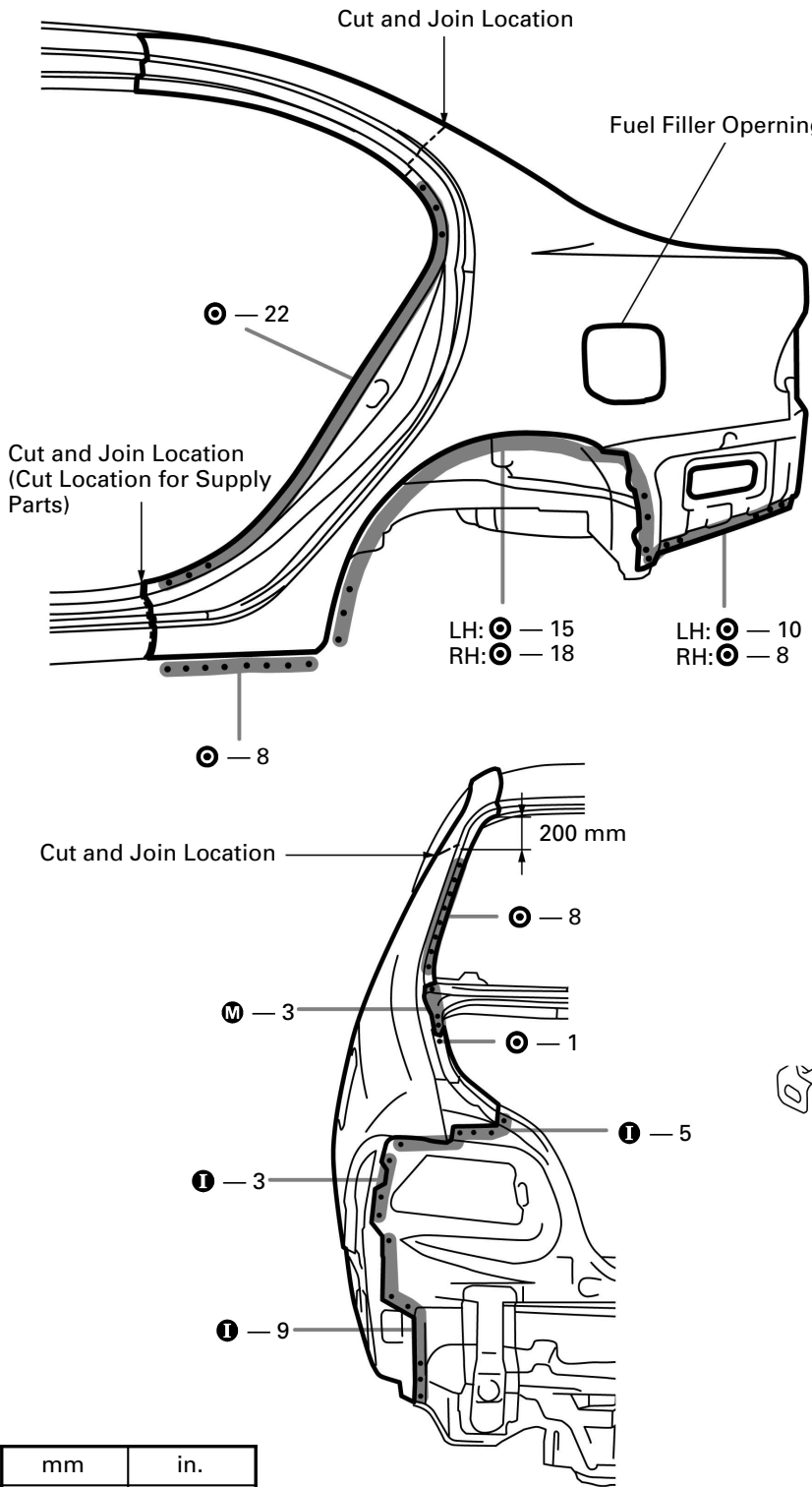


1. Temporarily installing the new parts, check the fit of the front door and rear door.

QUARTER PANEL (CUT): Sedan



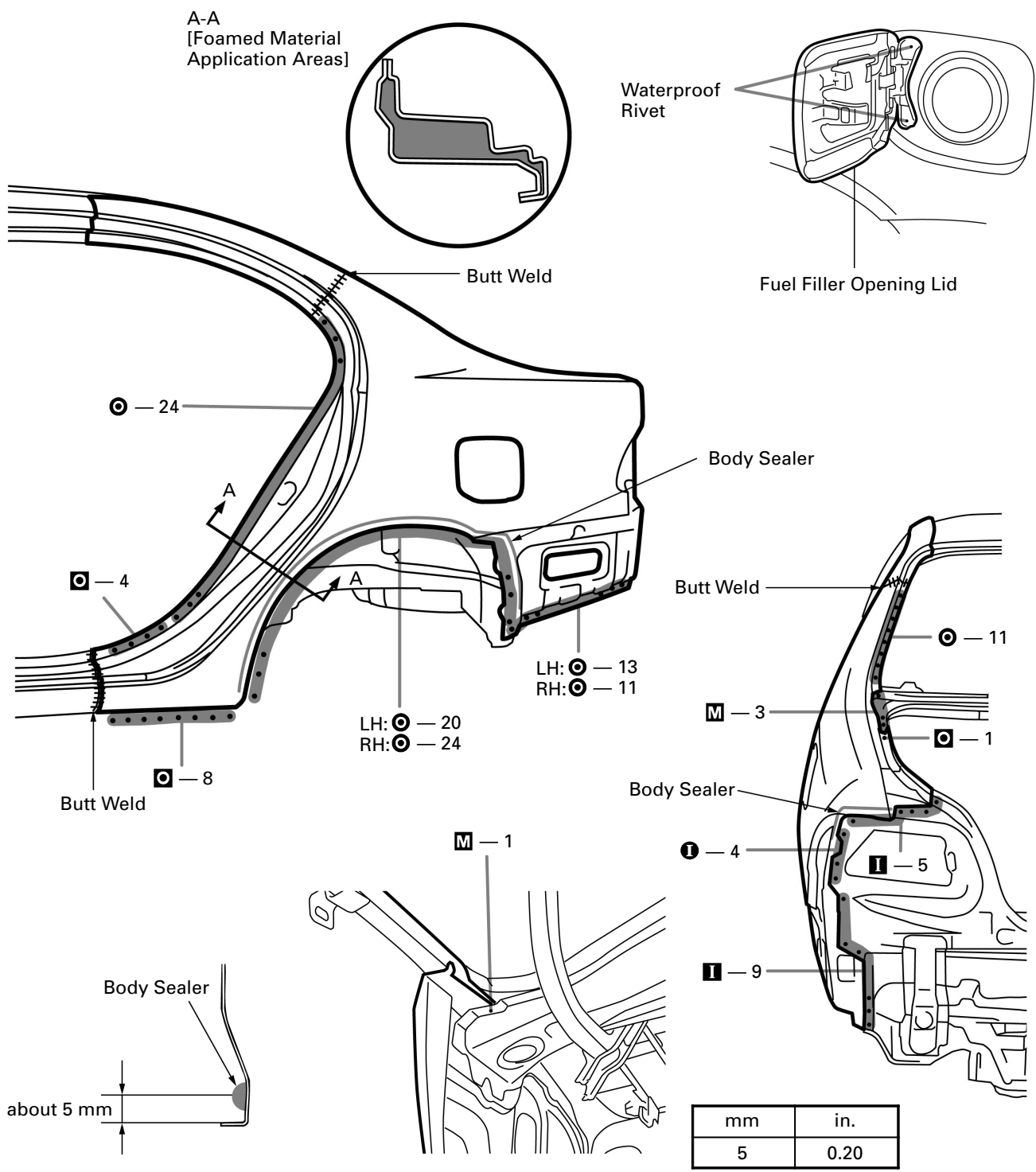
REMOVAL



mm	in.
200	7.87

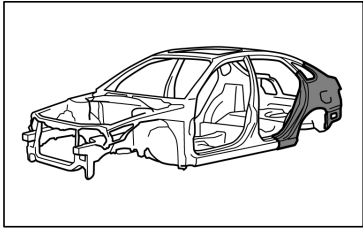
1. Cut and join the parts at the locations as shown above.
2. Replace the fuel filler opening lid at the same time as the quarter panel.

INSTALLATION

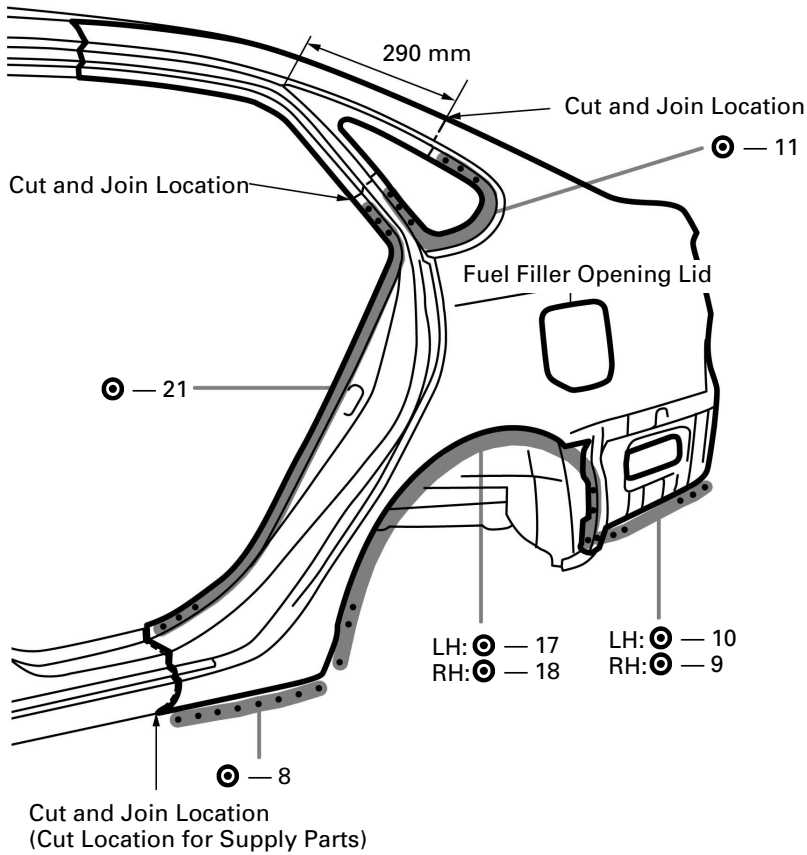


1. Before temporarily installing the new parts, apply body sealer to the wheel arch.
- HINT:
- 1) Apply body sealer about 5 mm (0.20 in.) from the flange, avoiding any oozing.
 - 2) Apply sealer evenly, about 3 - 4 mm (0.12 - 0.16 in.) in diameter.
 - 3) For other sealing points, refer to section AR.
2. Temporarily install the new parts and check the fit of the rear door, luggage compartment door and rear combination light.
 3. After installing the new parts, apply foamed materials.
 4. Attach the fuel filler opening lid by rivets to the quarter panel.
- HINT:
- 1) Use waterproof rivets.
 - 2) Refer to the introduction when installation rivets.

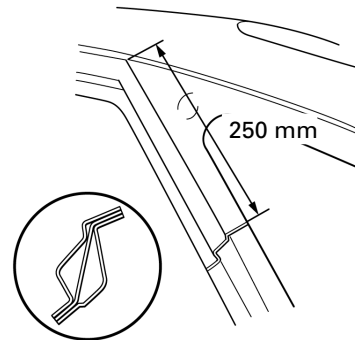
QUARTER PANEL (CUT): Liftback



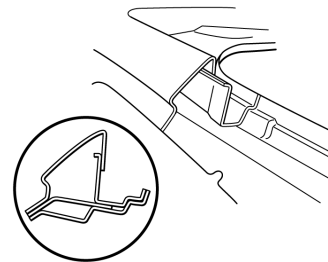
REMOVAL



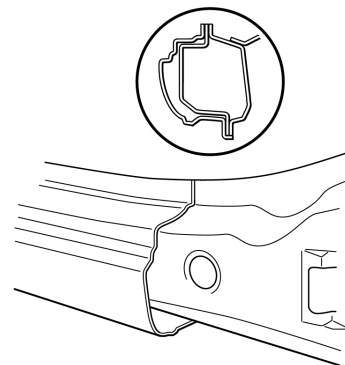
[Cut and Join Location]



[Cut and Join Location]

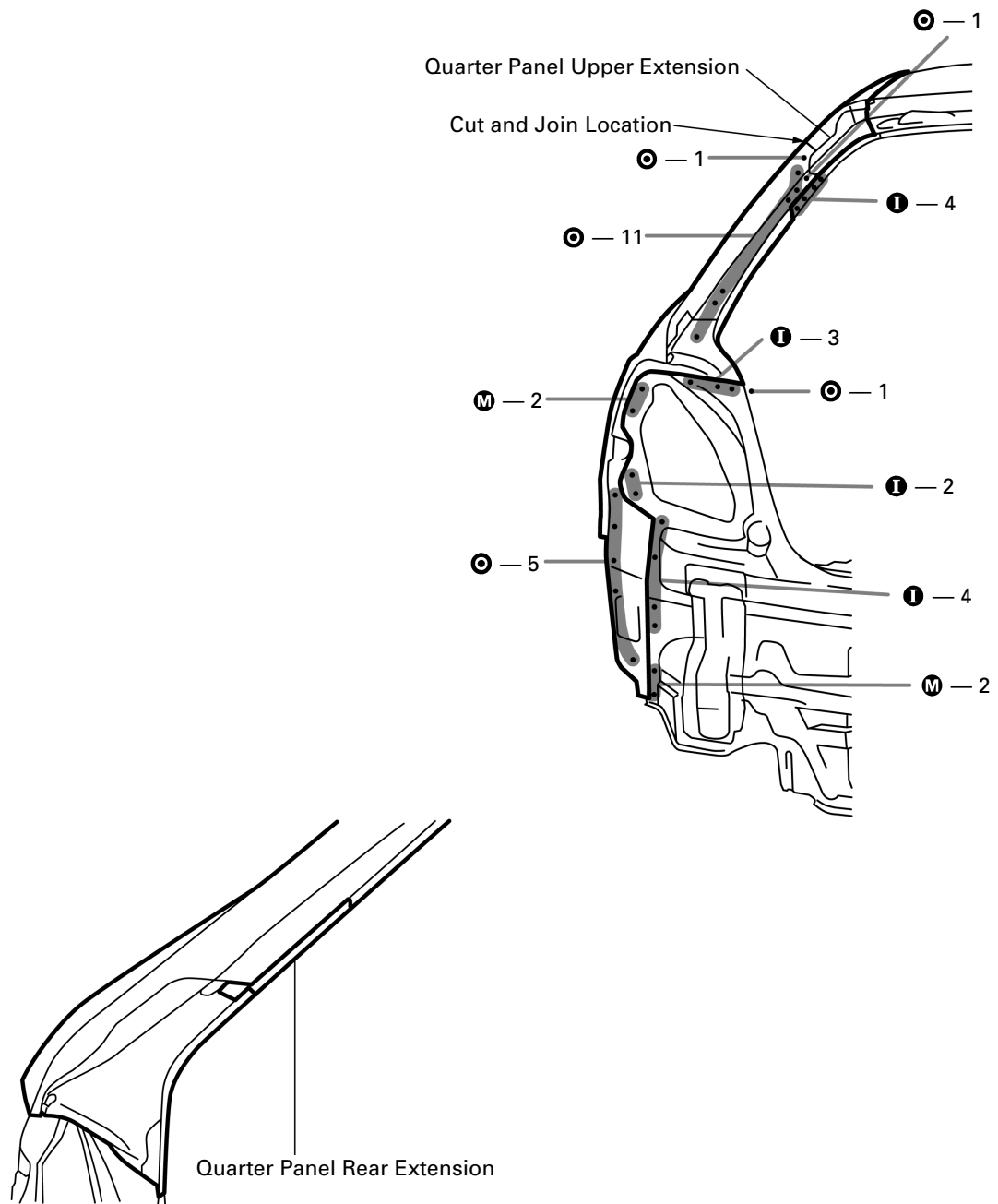


[Cut and Join Location]



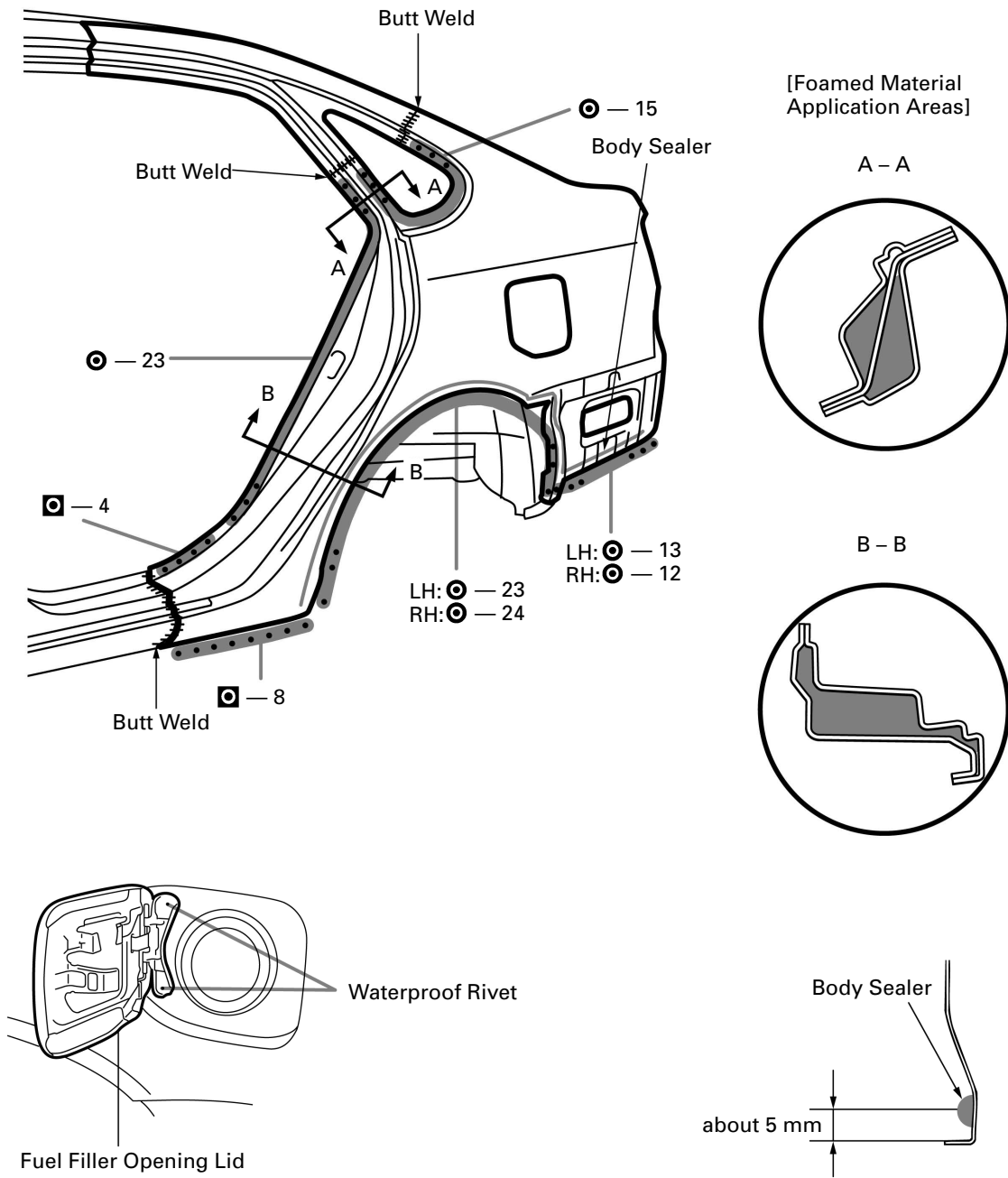
mm	in.
250	9.84
290	11.42

1. Cut and join the parts at the locations as shown above.
2. Replace the fuel filler opening lid at the same time as the quarter panel.



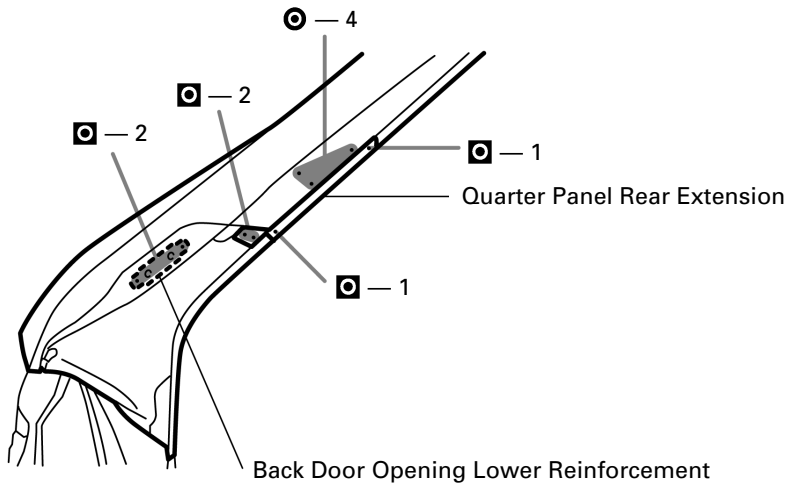
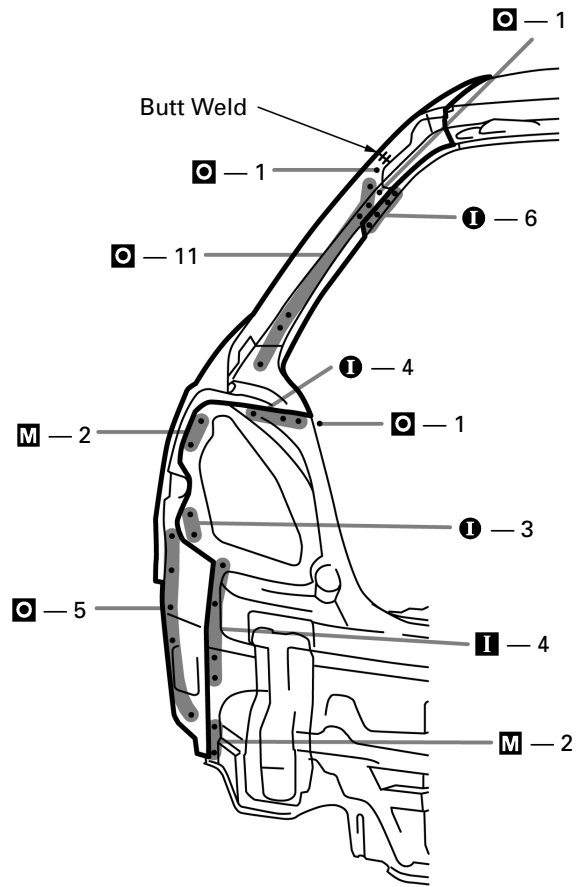
3. Replace the quarter panel rear extension at the same time as the quarter panel.
4. Leave the quarter panel upper extension to the vehicle side and remove the quarter panel.

INSTALLATION



mm	in.
5	0.20

1. Before temporarily installing the new parts, apply body sealer to the wheel arch.
 2. Before temporarily installing the new parts, weld the quarter panel rear extension and back door opening lower reinforcement with standard points.
 3. 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 (0.20 in.) from the flange, avoiding any oozing.
 - 2) Apply sealer evenly, about 3 – 4 mm (0.12 – 0.16 in.) in diameter.
 - 3) For other sealing points, refer to section AR.



4. After installing the new parts, apply foamed materials.

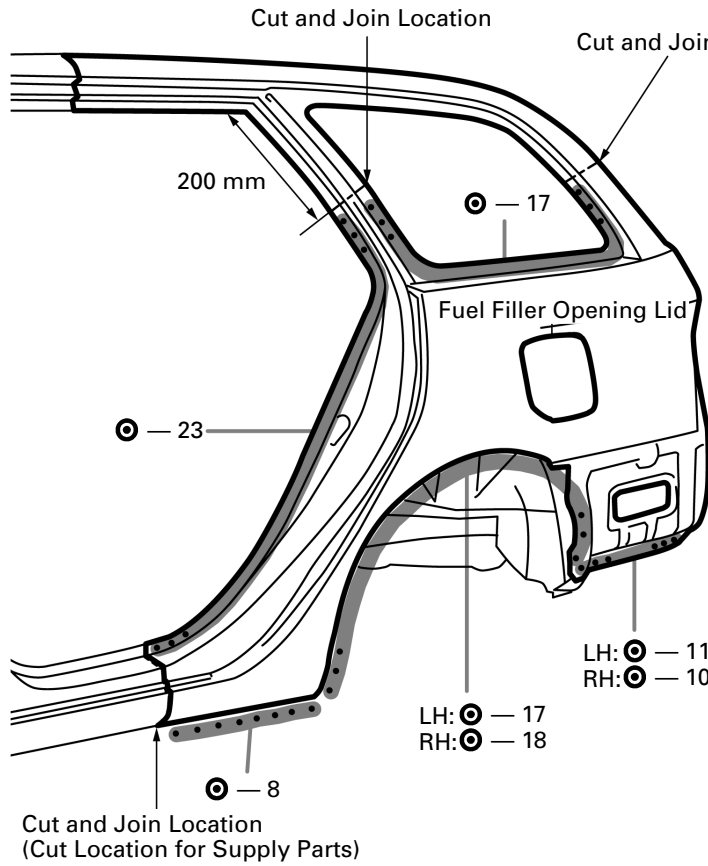
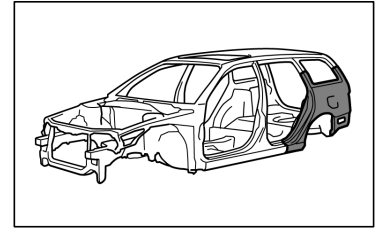
5. Attach the fuel filler opening lid by rivets to the quarter panel.

HINT:

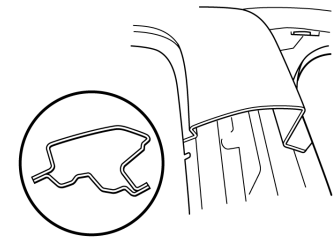
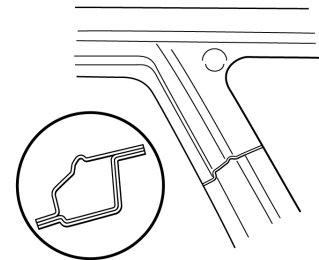
- 1) Use waterproof rivets.
- 2) Refer to the introduction when installation rivets.

QUARTER PANEL (CUT): Wagon

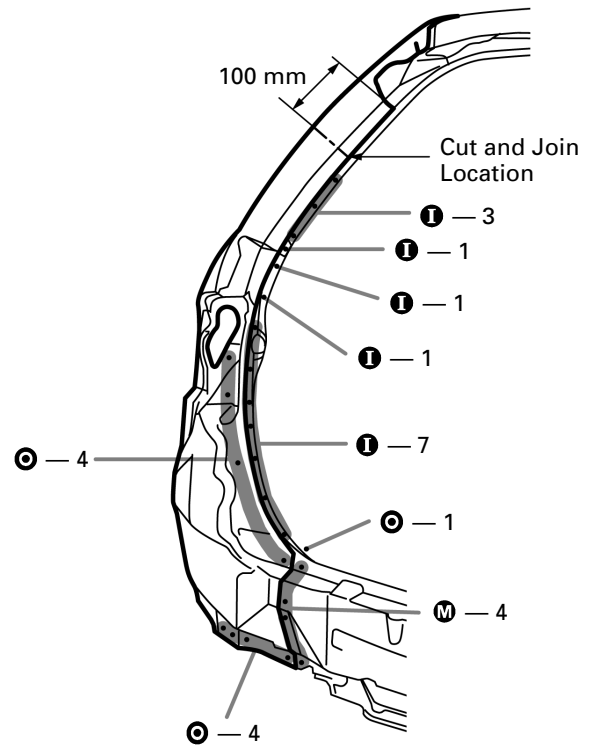
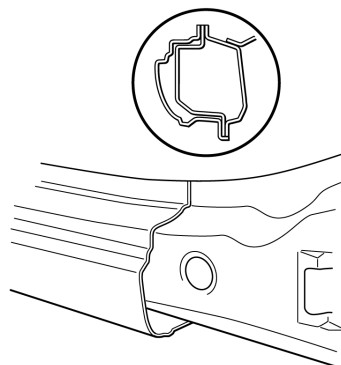
REMOVAL



[Cut and Join Location]



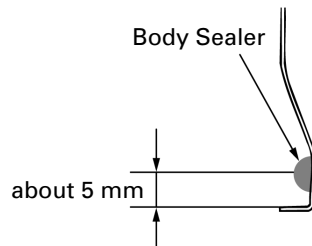
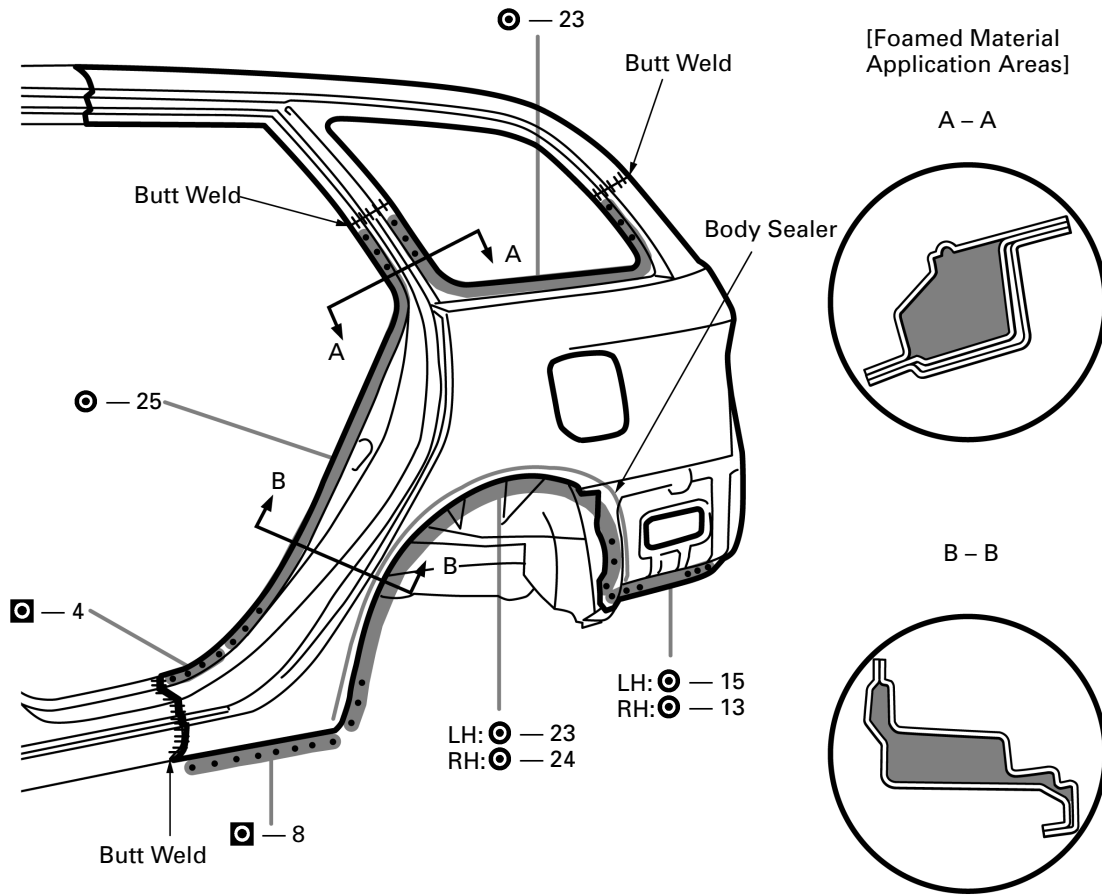
[Cut and Join Location]



mm	in.
100	3.94
200	7.87

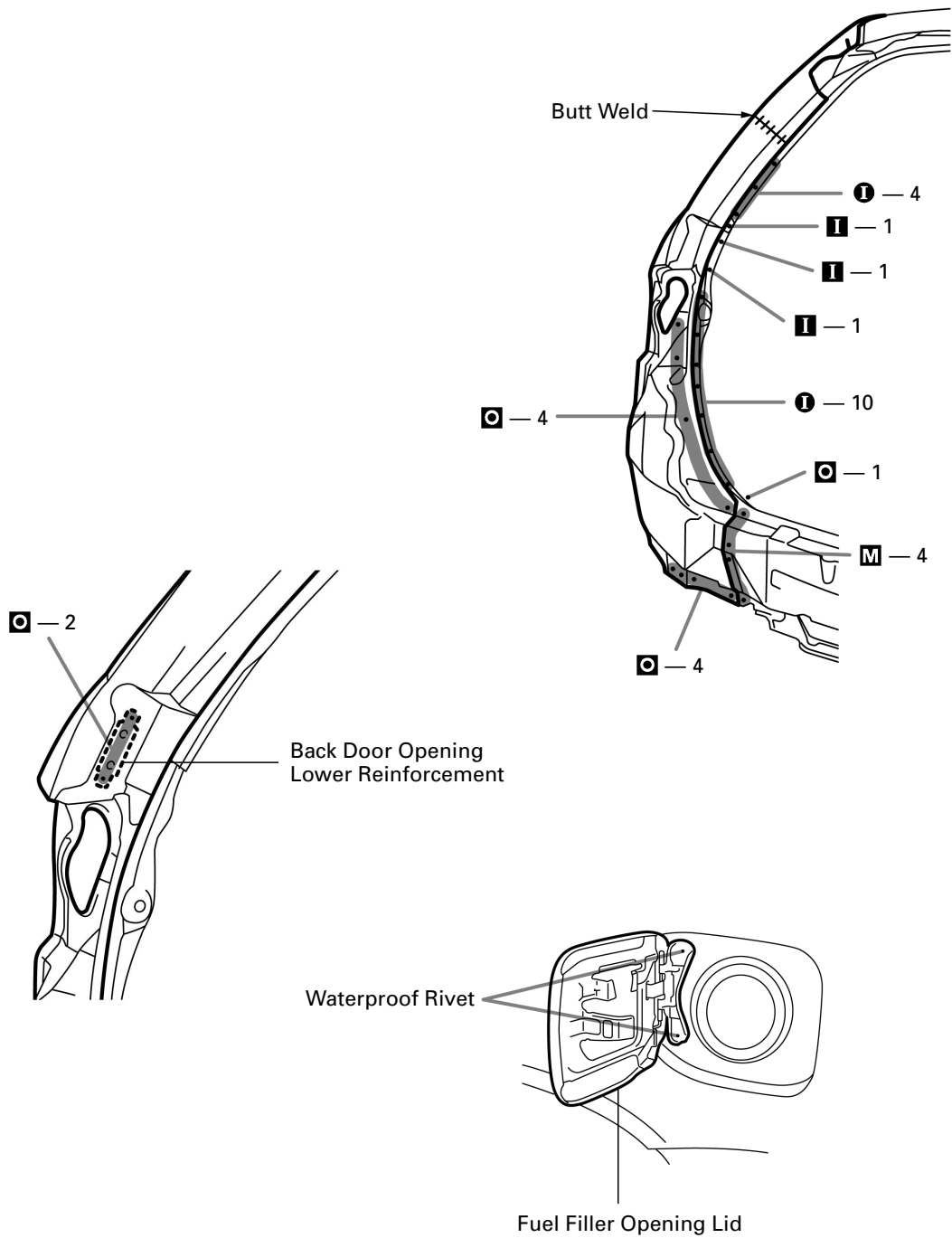
1. Cut and join the parts at the locations as shown above.
2. Replace the fuel filler opening lid at the same time as the quarter panel.

INSTALLATION



mm	in.
5	0.20

1. Before temporarily installing the new parts, apply body sealer to the wheel arch.
 2. Before temporarily installing the new parts, weld the back door opening lower reinforcement with standard points.
 3. 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 (0.20 in.) from the flange, avoiding any oozing.
 - 2) Apply sealer evenly, about 3 – 4 mm (0.12 – 0.16 in.) in diameter.
 - 3) For other sealing points, refer to section AR.

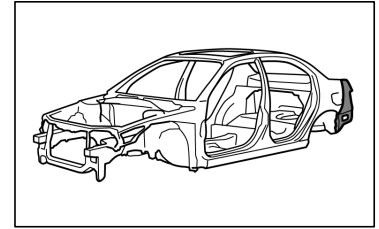
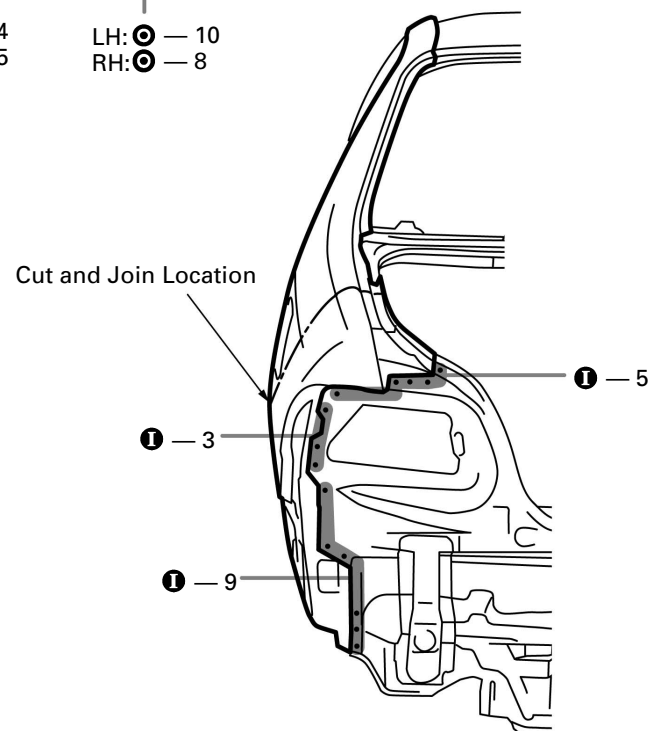
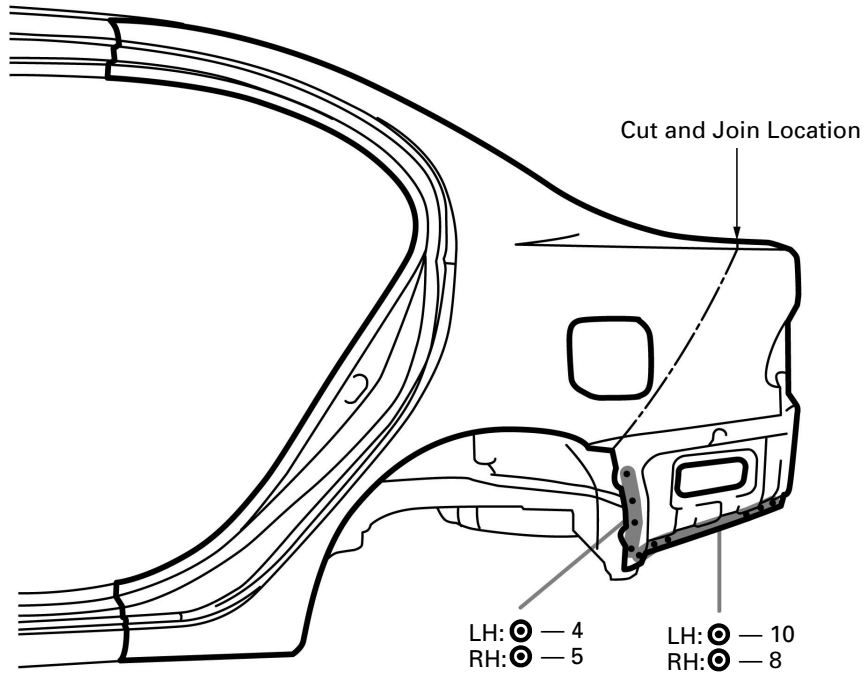


4. After installing the new parts, apply foamed materials.

5. Attach the fuel filler opening lid by rivets to the quarter panel.

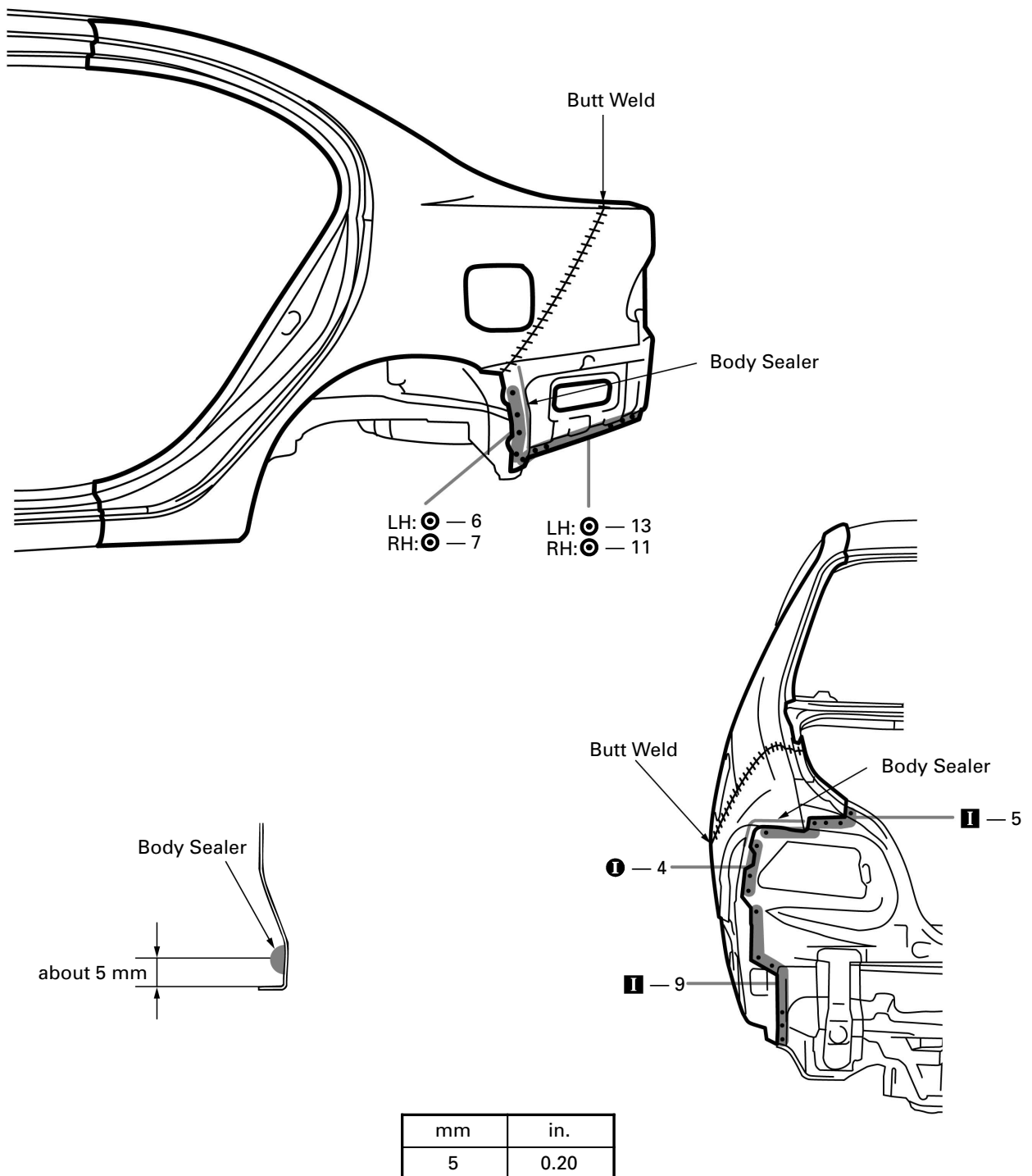
HINT:

- 1) Use waterproof rivets.
- 2) Refer to the introduction when installation rivets.

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

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

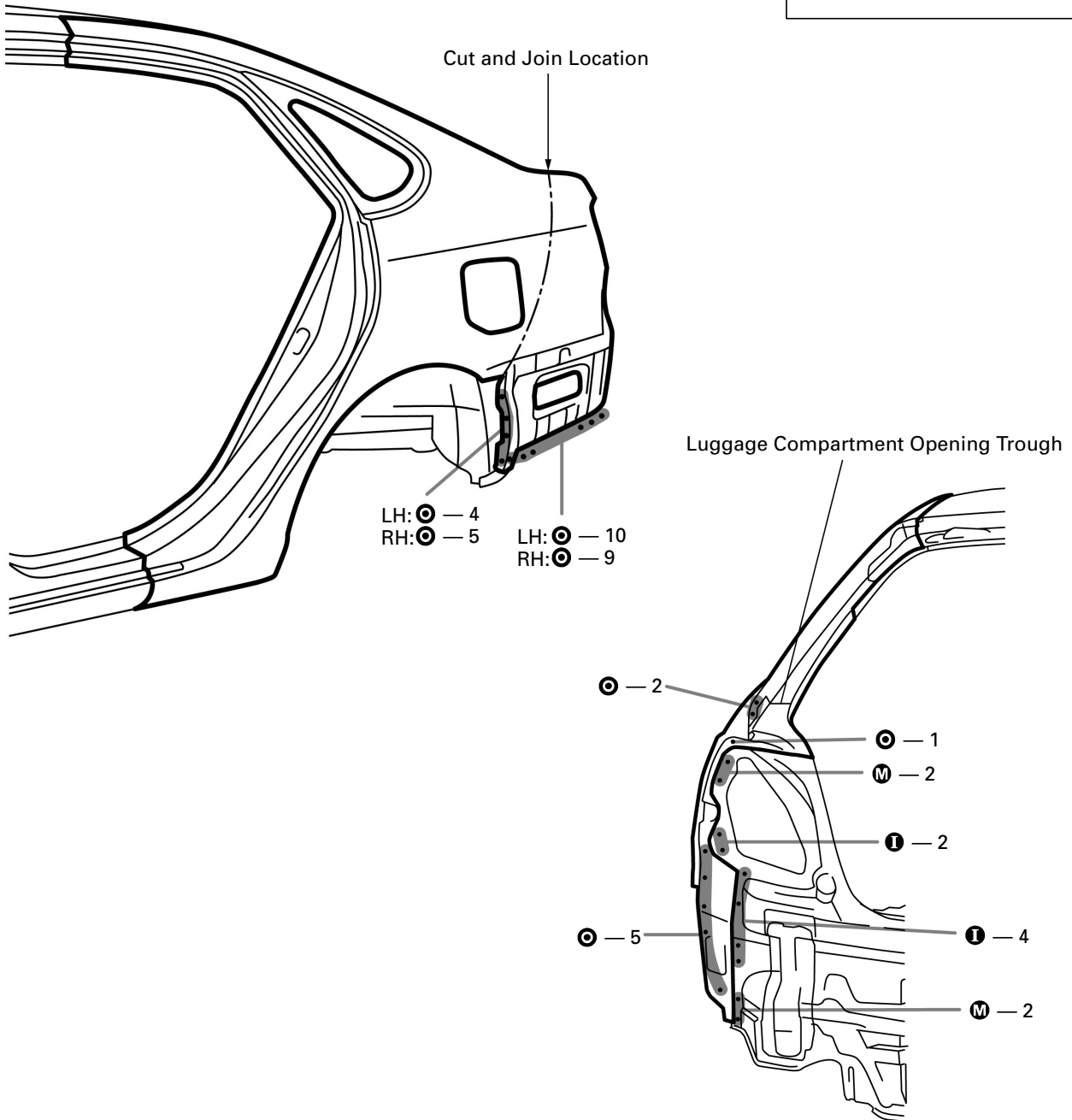
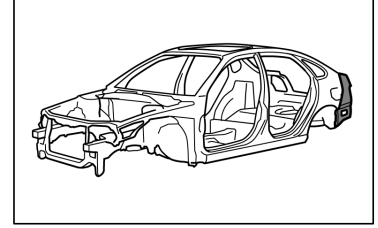
INSTALLATION



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 luggage compartment door and rear combination light.
- HINT:**
- 1) Apply body sealer about 5 mm (0.20 in.) from the flange, avoiding any oozing.
 - 2) Apply sealer evenly, about 3 – 4 mm (0.12 – 0.16 in.) in diameter.
 - 3) For other sealing points, refer to section AR.

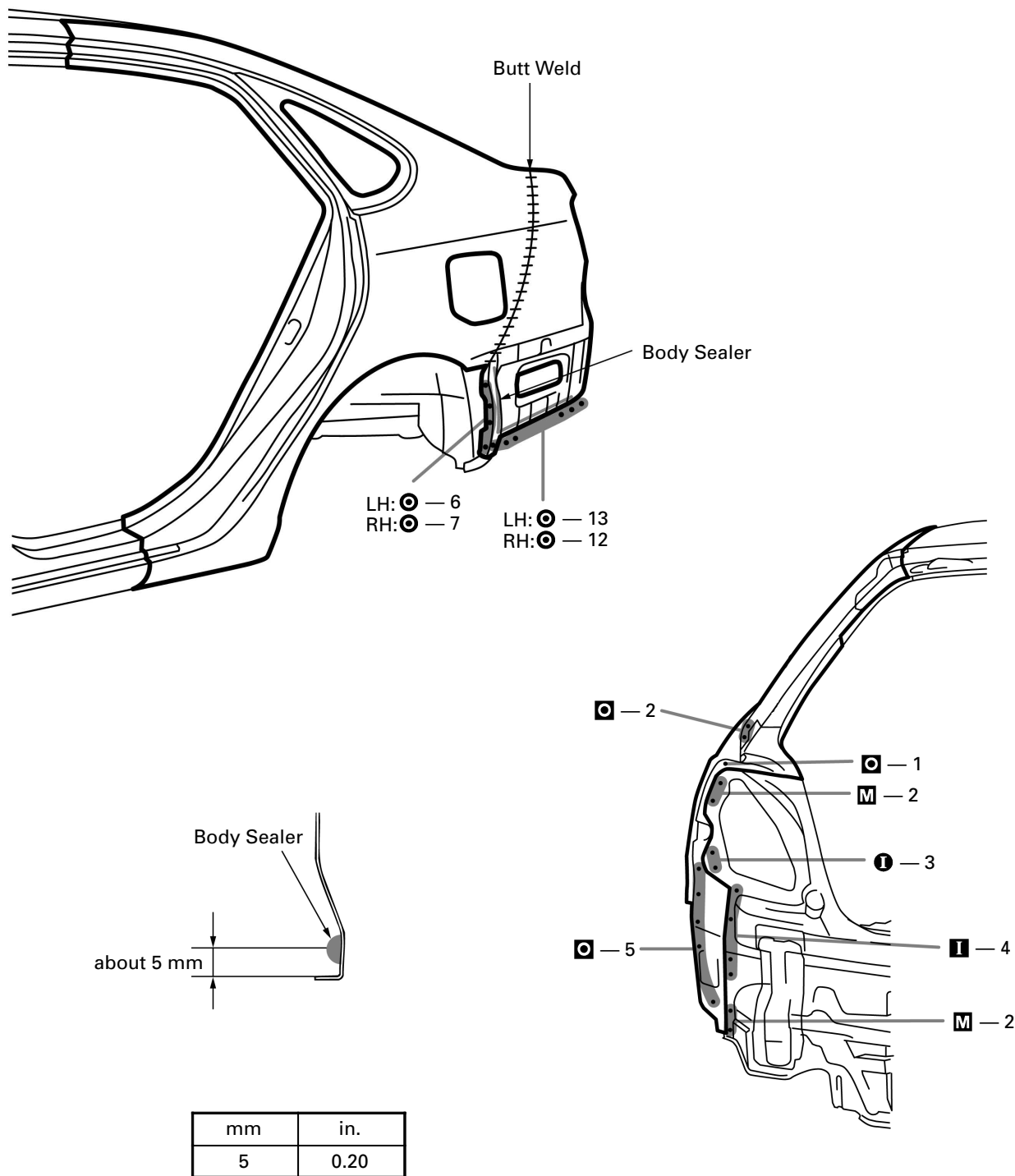
QUARTER PANEL (CUT-P): Liftback

REMOVAL



1. Cut and join the parts at the location as shown above.
2. Leave the luggage compartment opening trough to the vehicle side and remove the quarter panel.

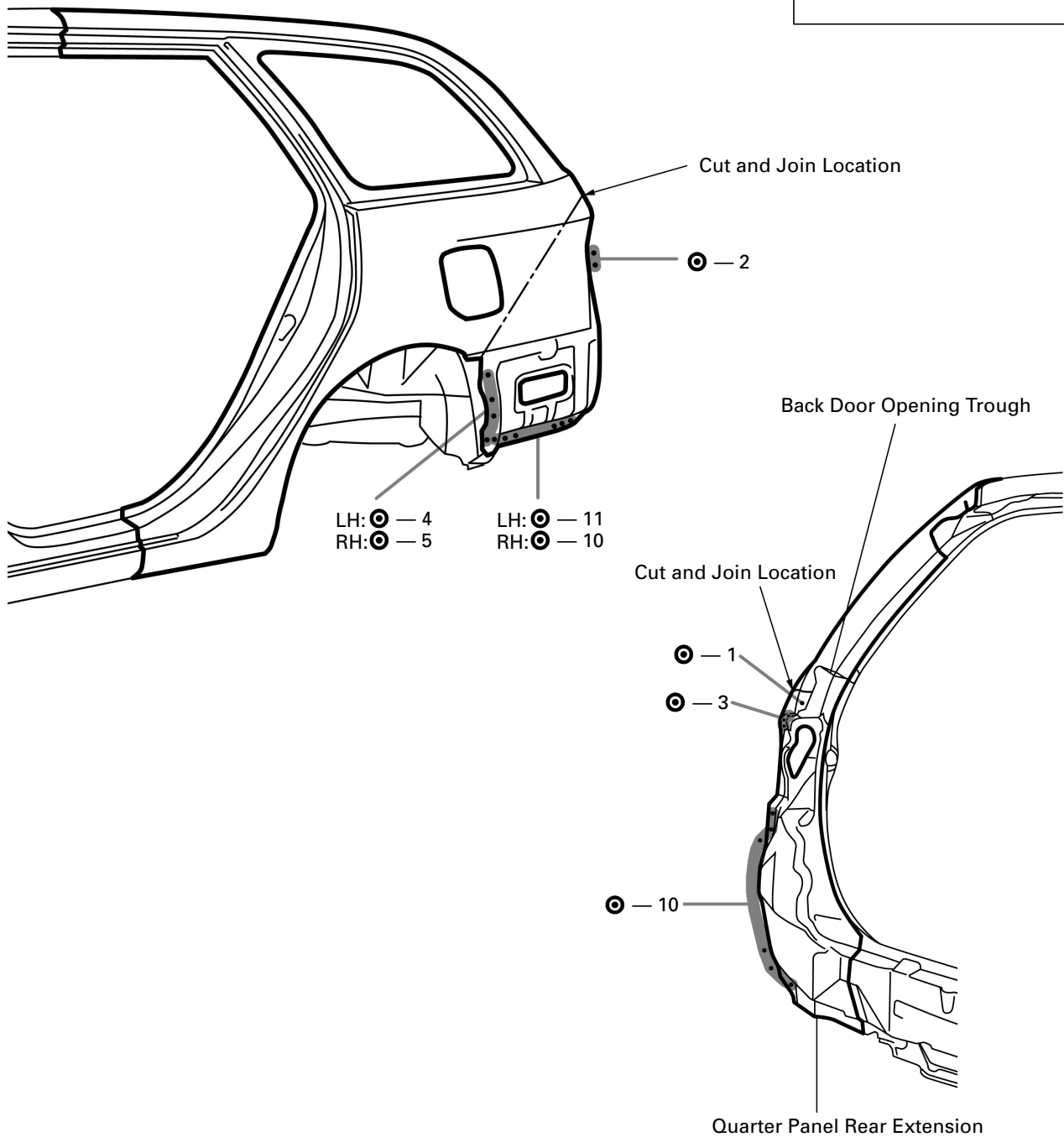
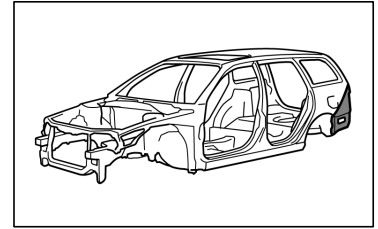
INSTALLATION



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 back door and rear combination light.
- HINT:**
- 1) Apply body sealer about 5 mm (0.20 in.) from the flange, avoiding any oozing.
 - 2) Apply sealer evenly, about 3 – 4 mm (0.12 – 0.16 in.) in diameter.
 - 3) For other sealing points, refer to section AR.

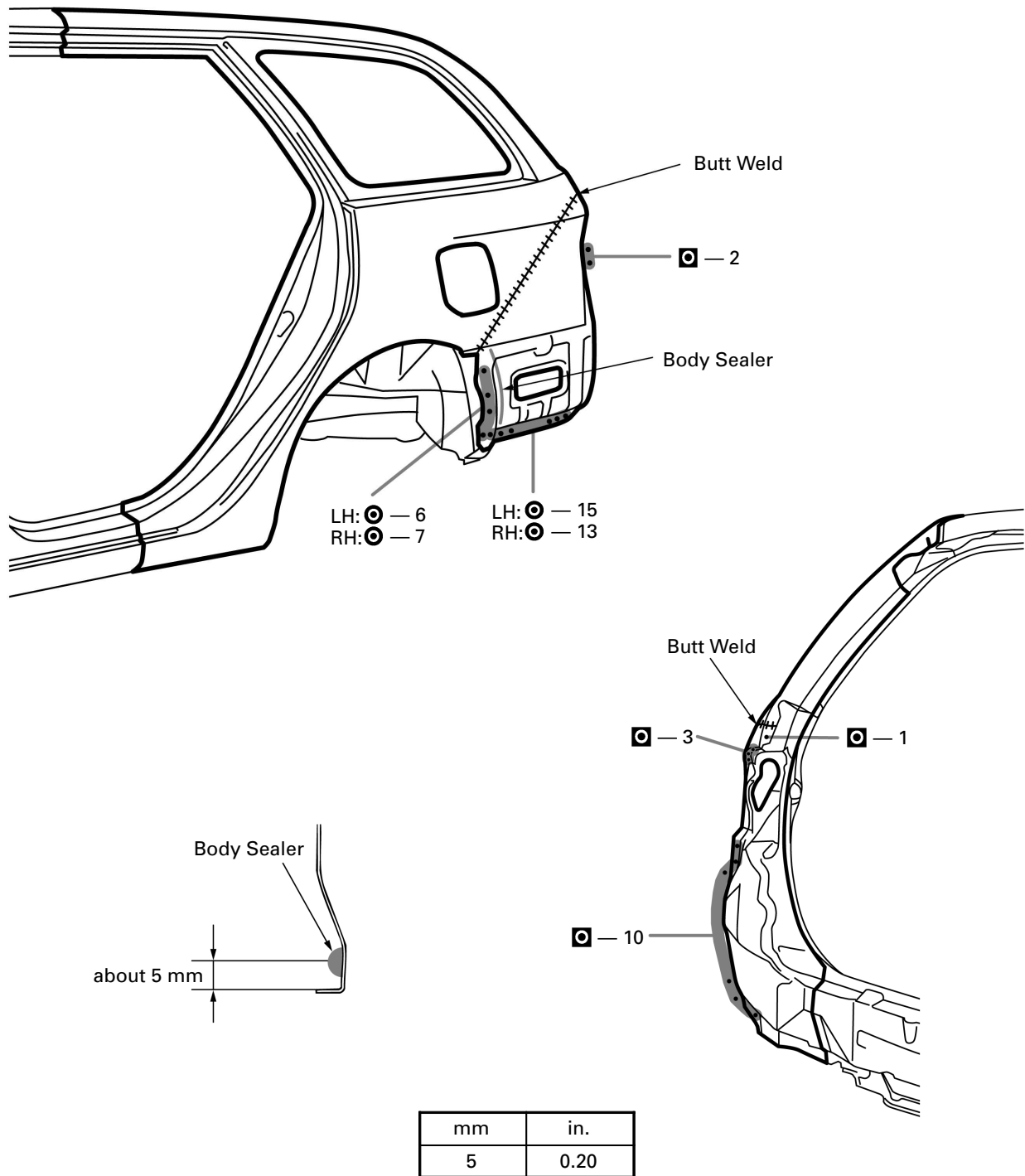
QUARTER PANEL (CUT-P): Wagon

REMOVAL



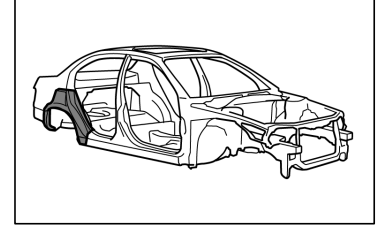
1. Cut and join the parts at the location as shown above.
2. Leave the back door opening trough and quarter panel rear extension to the vehicle side and remove the quarter panel.

INSTALLATION

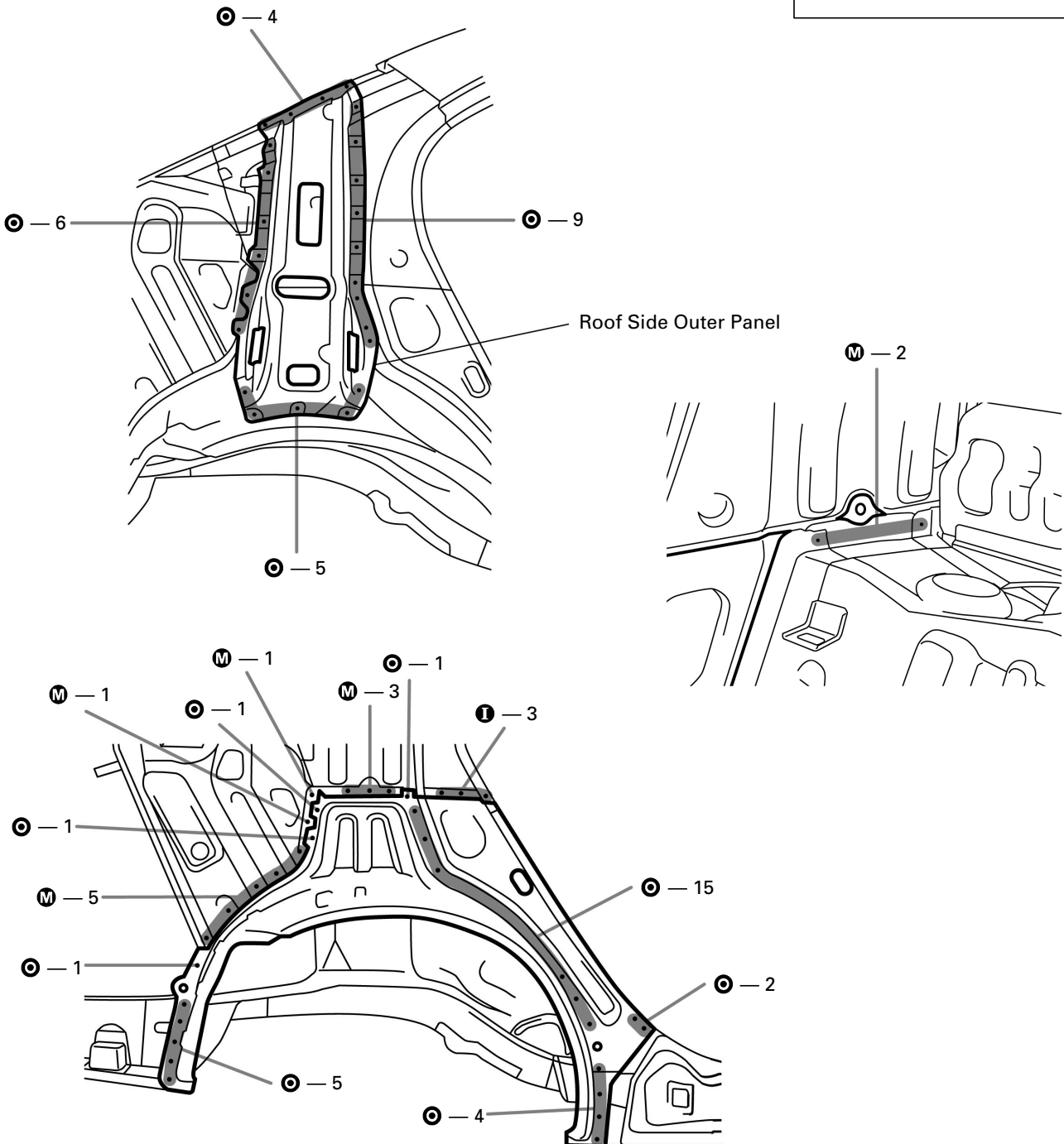


1. Before temporarily installing the new parts, apply body sealer to the wheel arch.
 2. Temporarily install the new parts and check the fit of the back door and rear combination light.
- HINT:**
- 1) Apply body sealer about 5 mm (0.20 in.) from the flange, avoiding any oozing.
 - 2) Apply sealer evenly,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

QUARTER WHEEL HOUSING OUTER PANEL (ASSY): Sedan RH

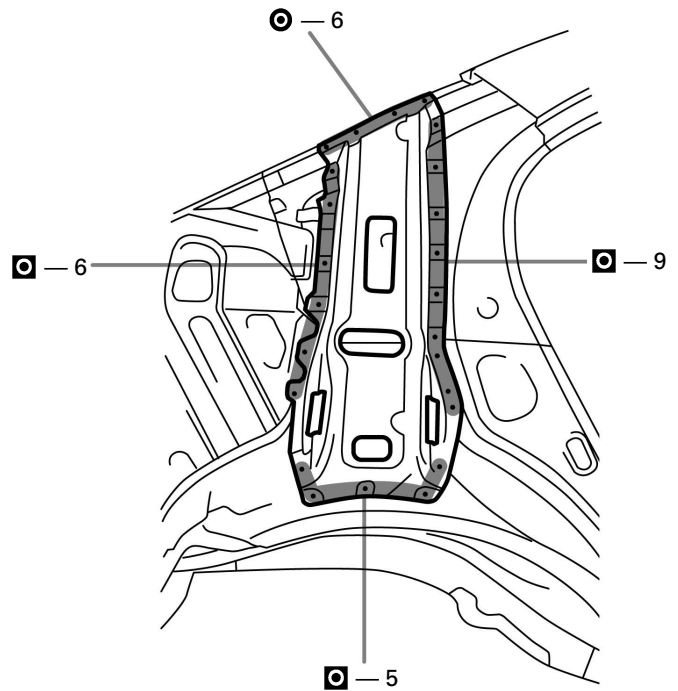
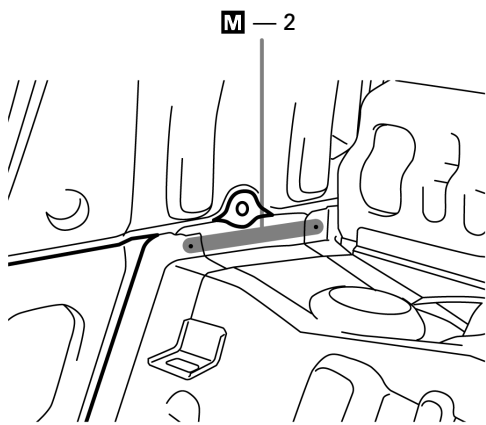
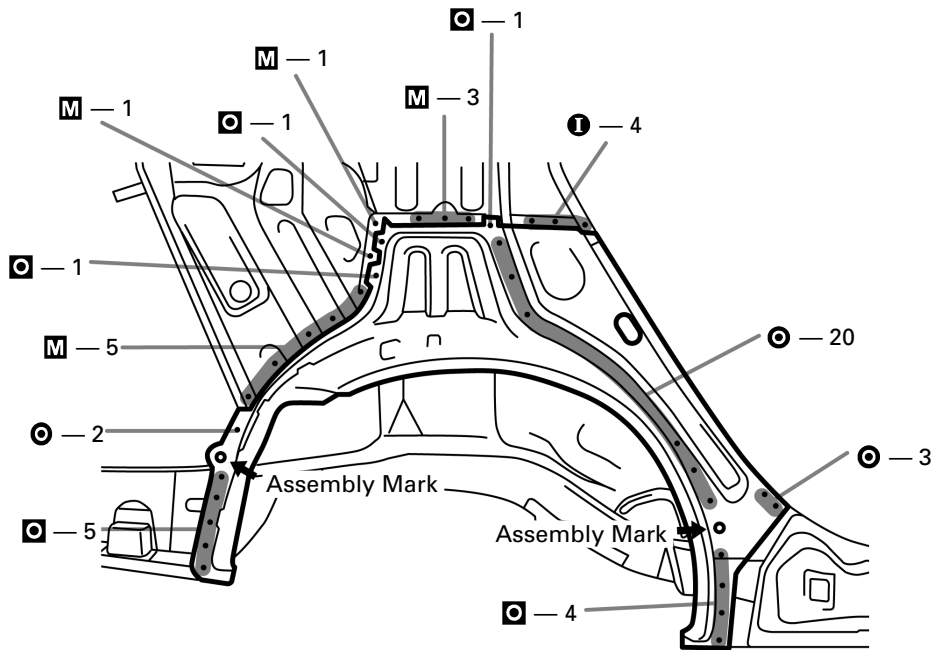


REMOVAL (With the quarter panel removed.)



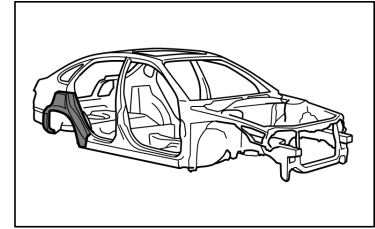
1. After removing the roof side outer panel, remove the quarter wheel housing outer panel.

INSTALLATION

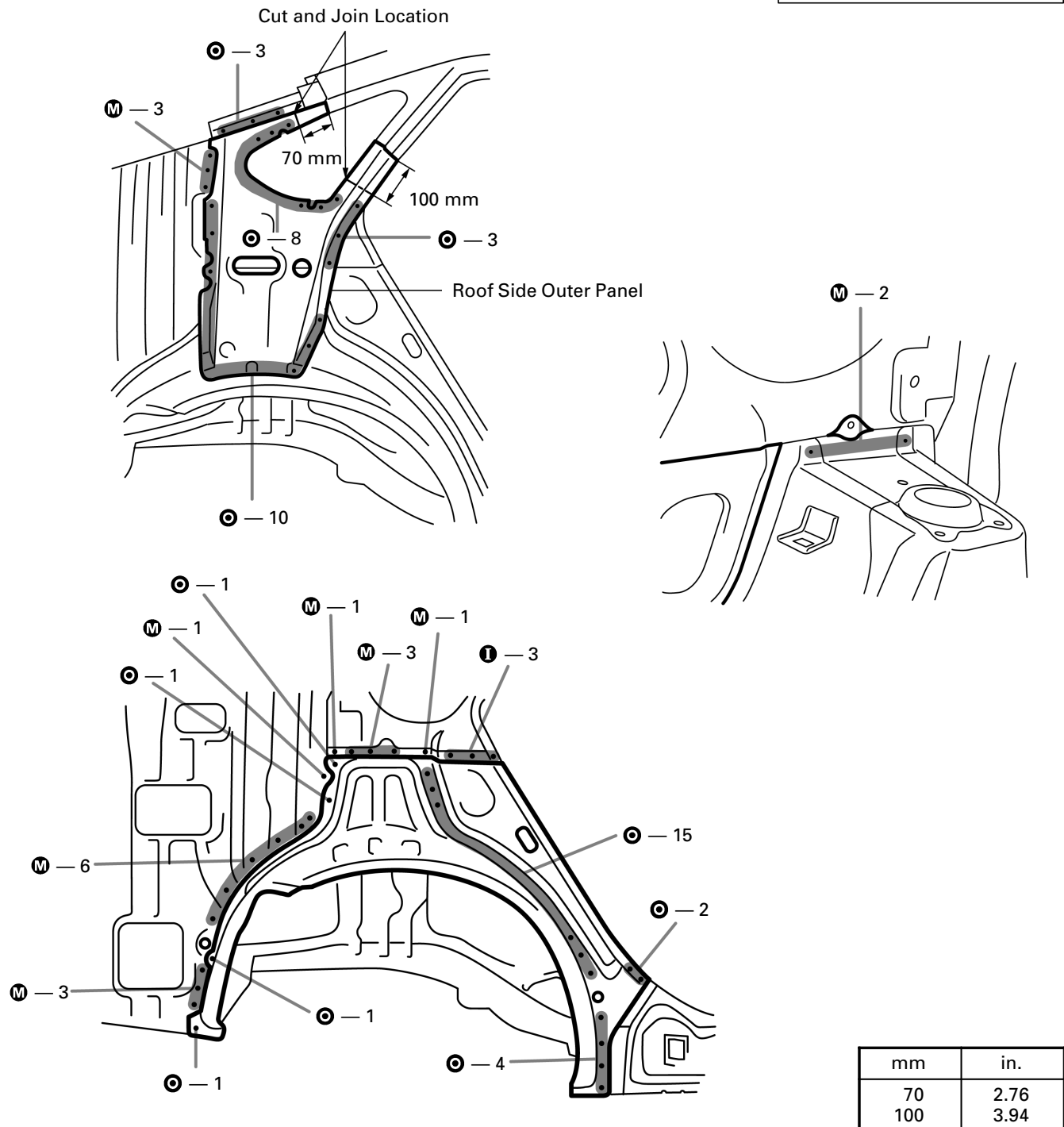


1. Determine the position of the new parts by the assembly marks of the inner and outer panels.
2. Before welding the new parts, temporarily install the quarter panel and check the fit.

QUARTER WHEEL HOUSING OUTER PANEL (ASSY): Liftback RH

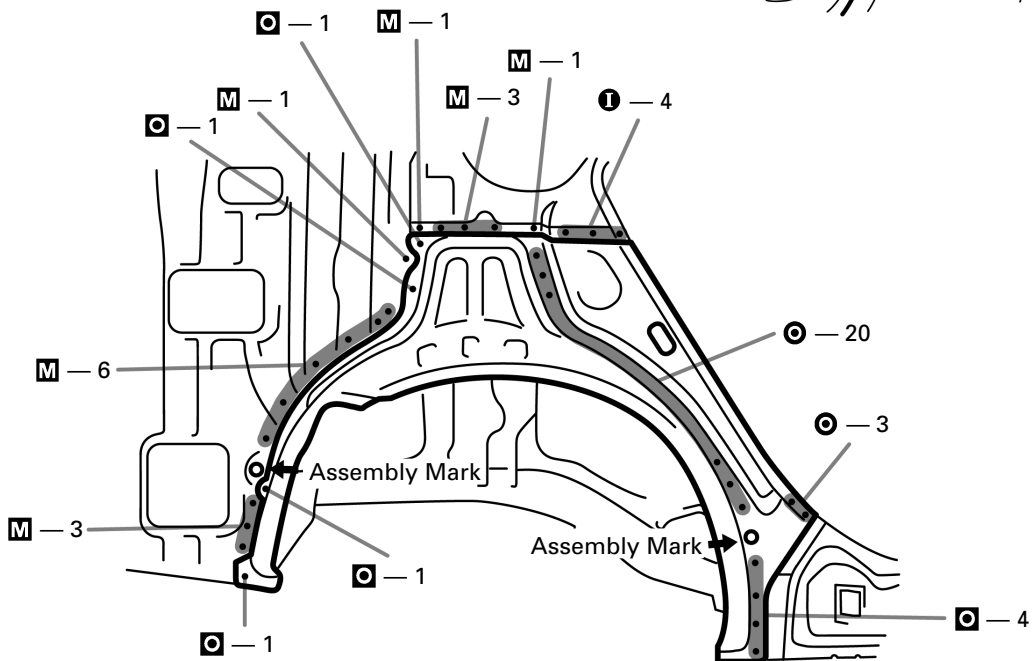
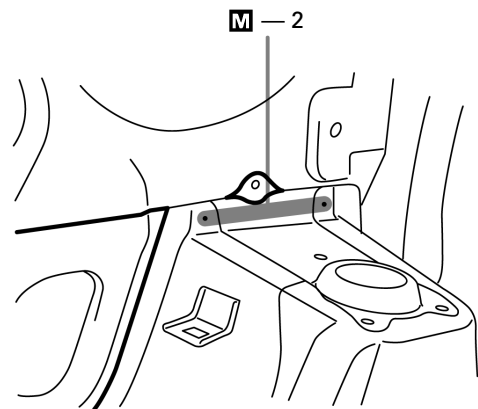
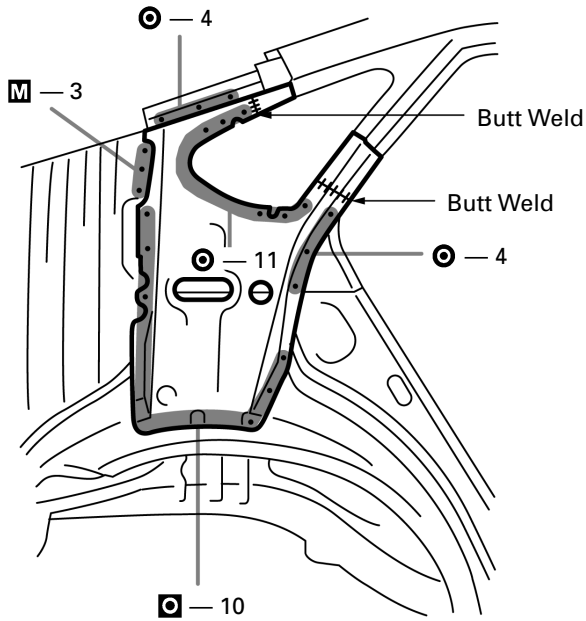


REMOVAL (With the quarter panel removed.)



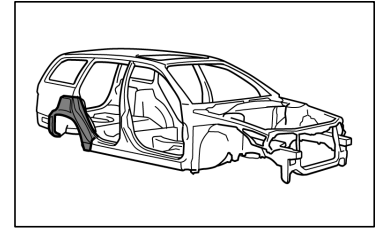
1. Cut the roof side outer panel at the location shown in the above figure and remove the quarter wheel housing outer panel.

INSTALLATION

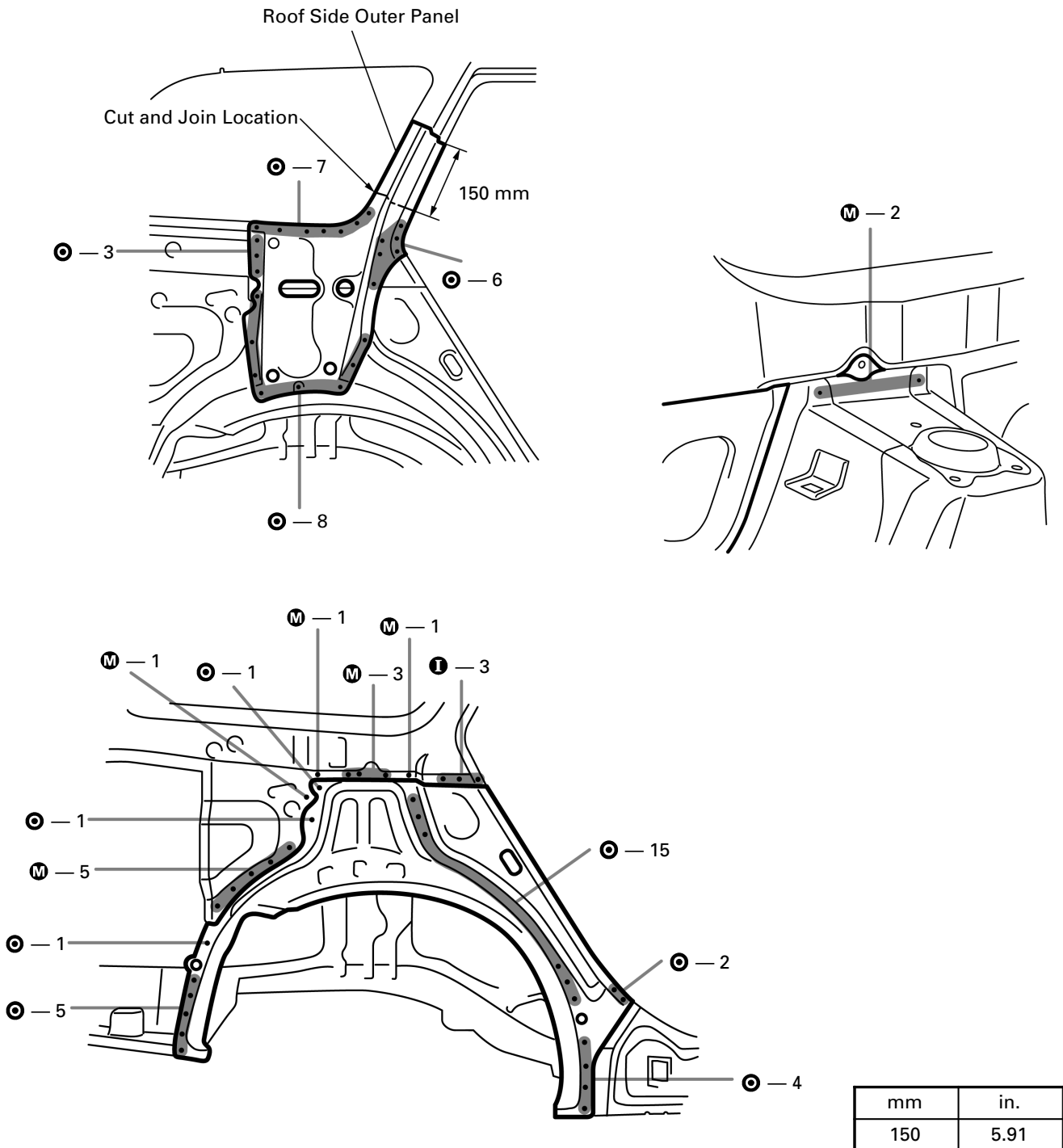


1. Determine the position of the new parts by the assembly marks of the inner and outer panels.
2. Before welding the new parts, temporarily install the quarter panel and check the fit.

QUARTER WHEEL HOUSING OUTER PANEL (ASSY): Wagon RH

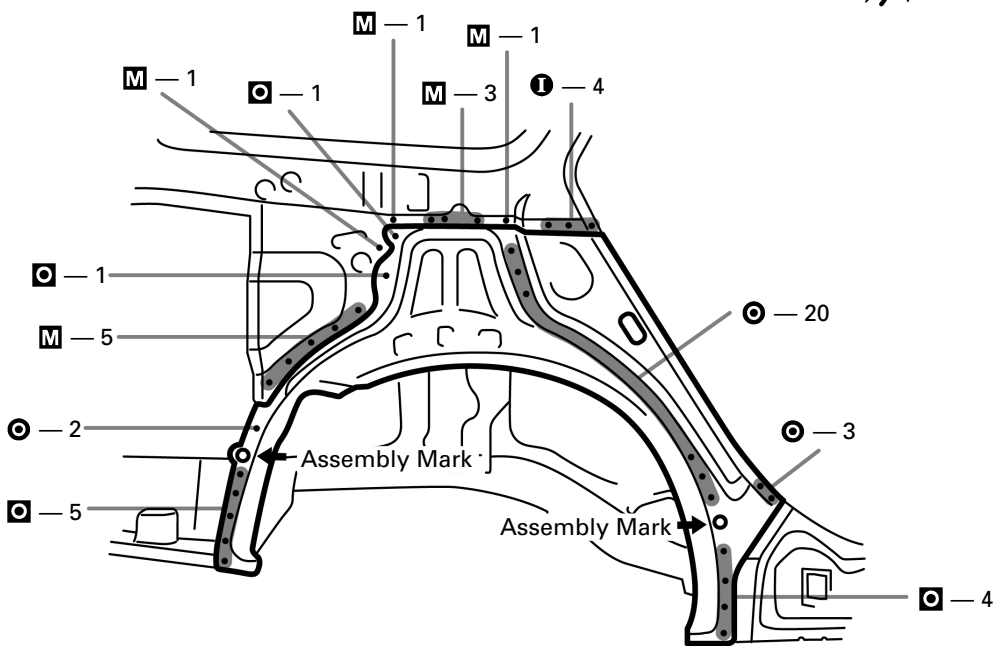
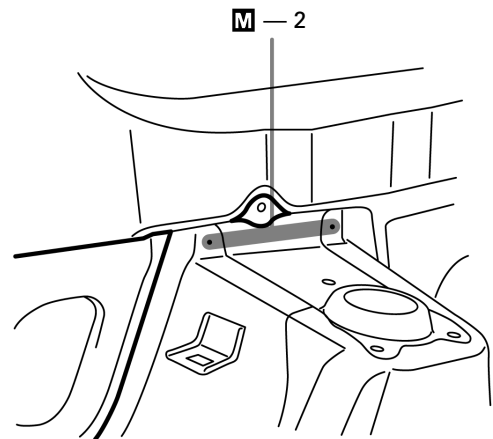
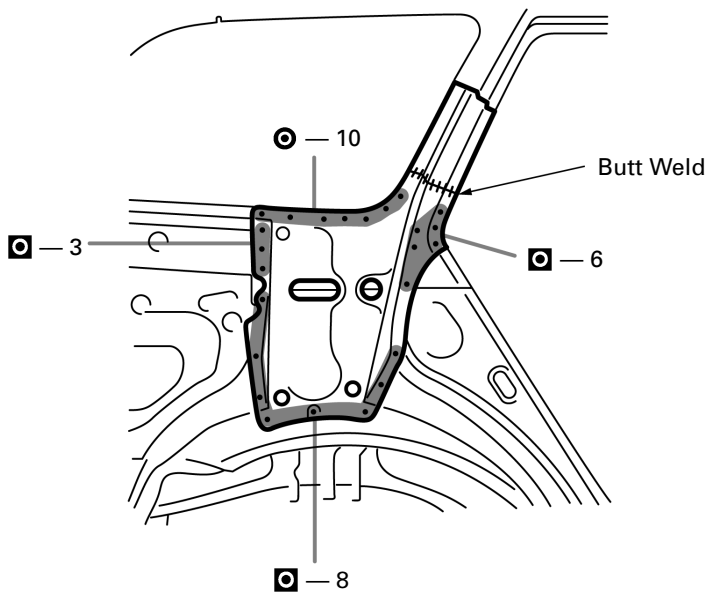


REMOVAL (With the quarter panel removed.)



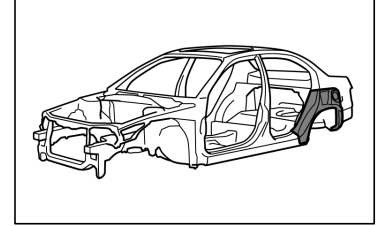
1. Cut the roof side outer panel at the location shown in the above figure and remove the quarter wheel housing outer panel.

INSTALLATION

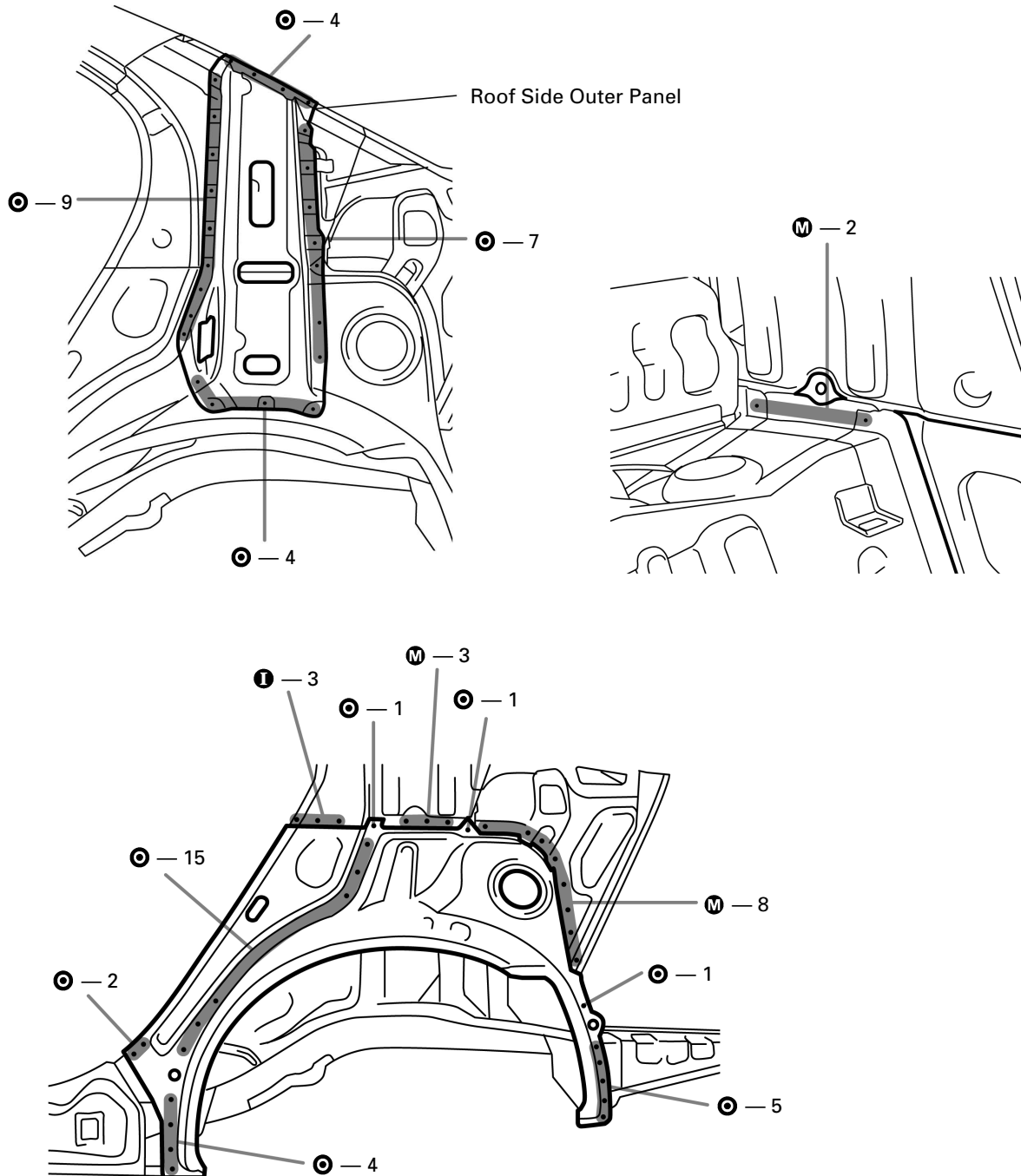


1. Determine the position of the new parts by the assembly marks of the inner and outer panels.
2. Before welding the new parts, temporarily install the quarter panel and check the fit.

QUARTER WHEEL HOUSING OUTER PANEL (ASSY): Sedan LH

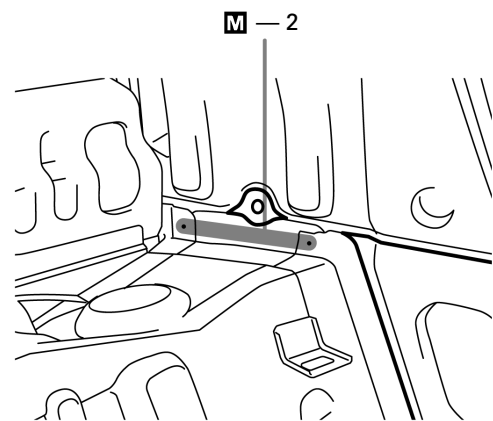
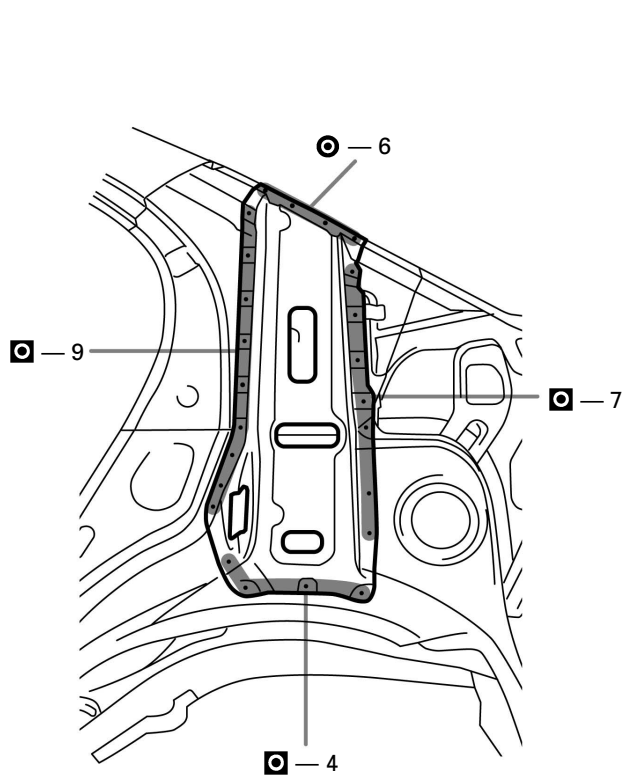
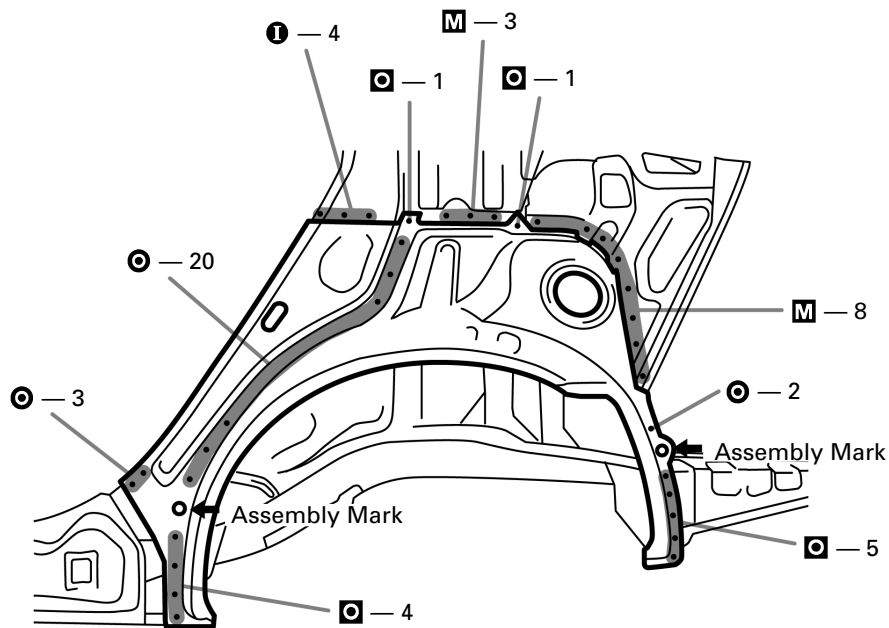


REMOVAL (With the quarter panel removed.)



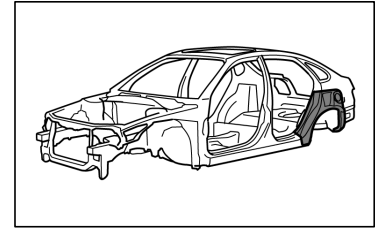
1. After removing the roof side outer panel, remove the quarter wheel housing outer panel.

INSTALLATION

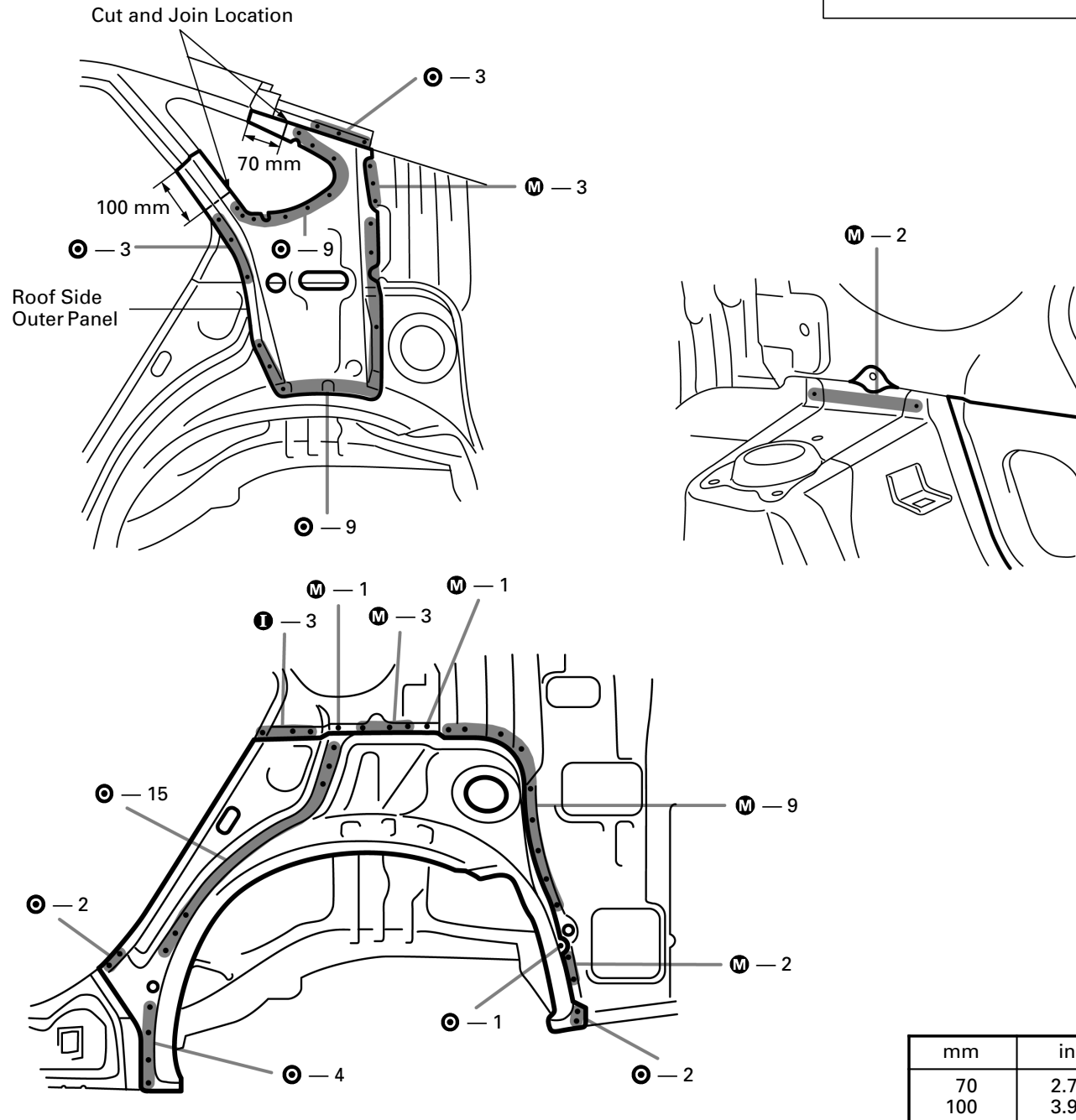


1. Determine the position of the new parts by the assembly marks of the inner and outer panels.
2. Before welding the new parts, temporarily install the quarter panel and check the fit.

QUARTER WHEEL HOUSING OUTER PANEL (ASSY): Liftback LH

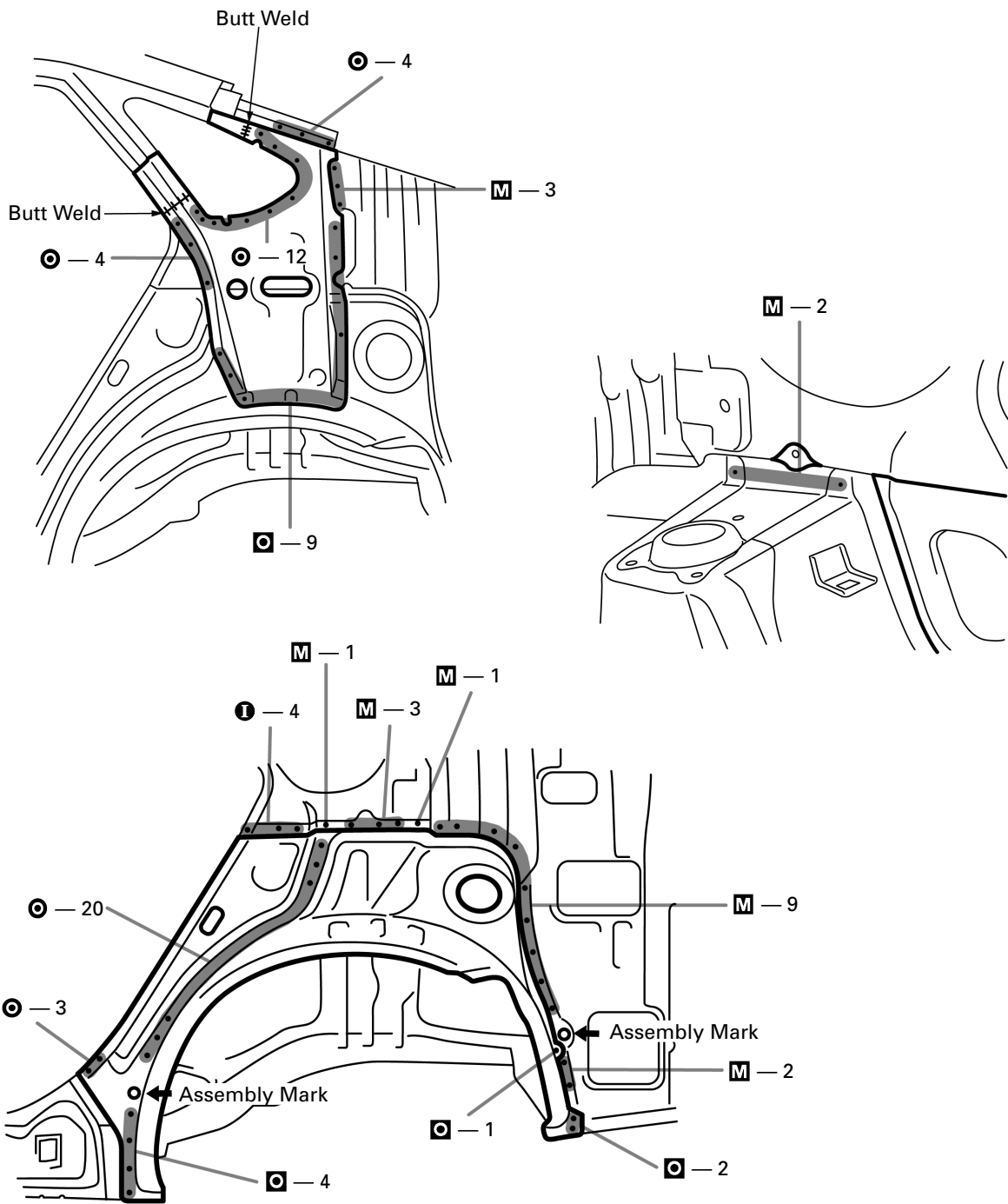


REMOVAL (With the quarter panel removed.)



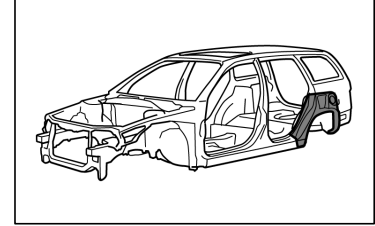
1. Cut the roof side outer panel at the location shown in the above figure and remove the quarter wheel housing outer panel.

INSTALLATION

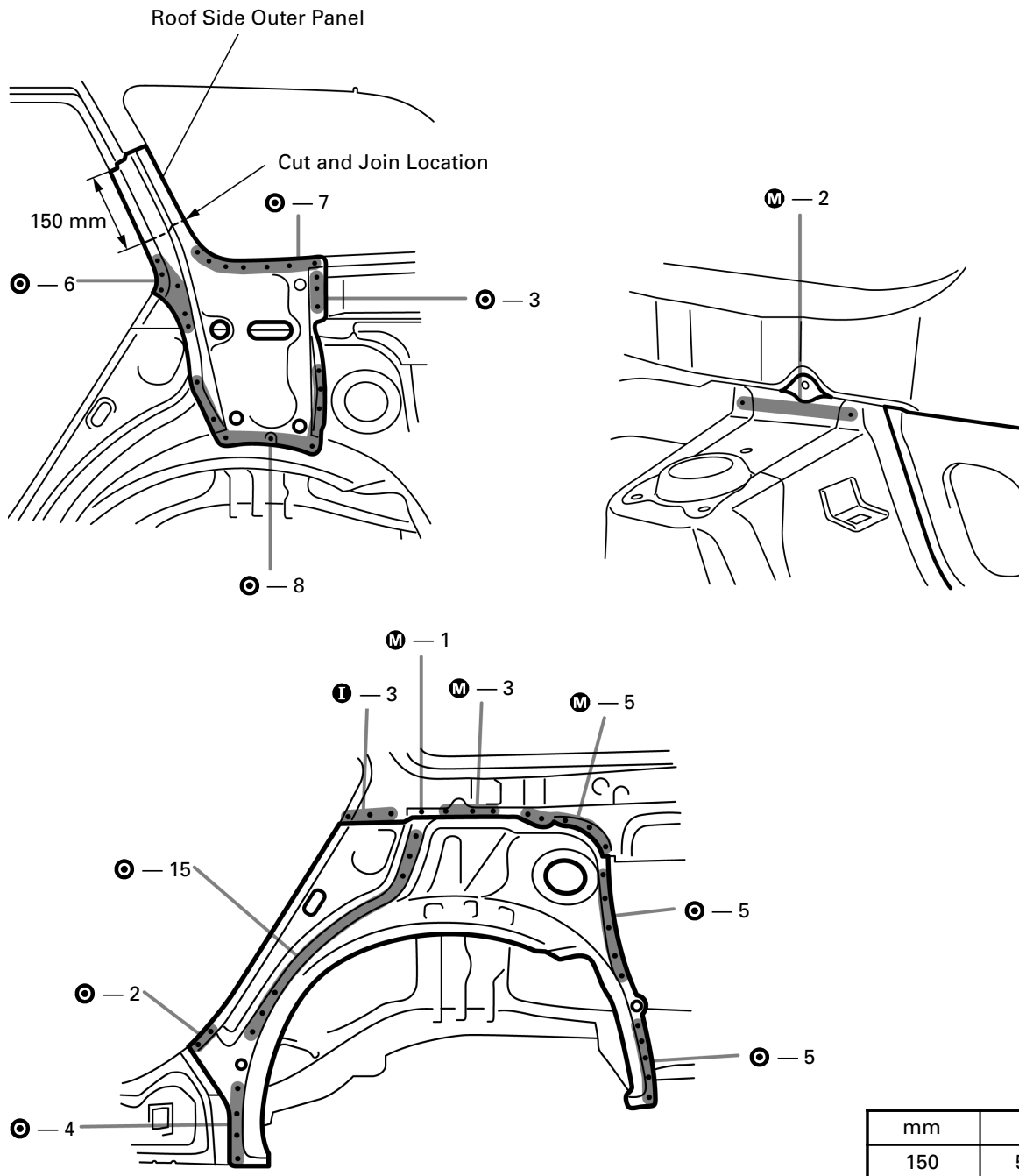


1. Determine the position of the new parts by the assembly marks of the inner and outer panels.
2. Before welding the new parts, temporarily install the quarter panel and check the fit.

QUARTER WHEEL HOUSING OUTER PANEL (ASSY): Wagon LH

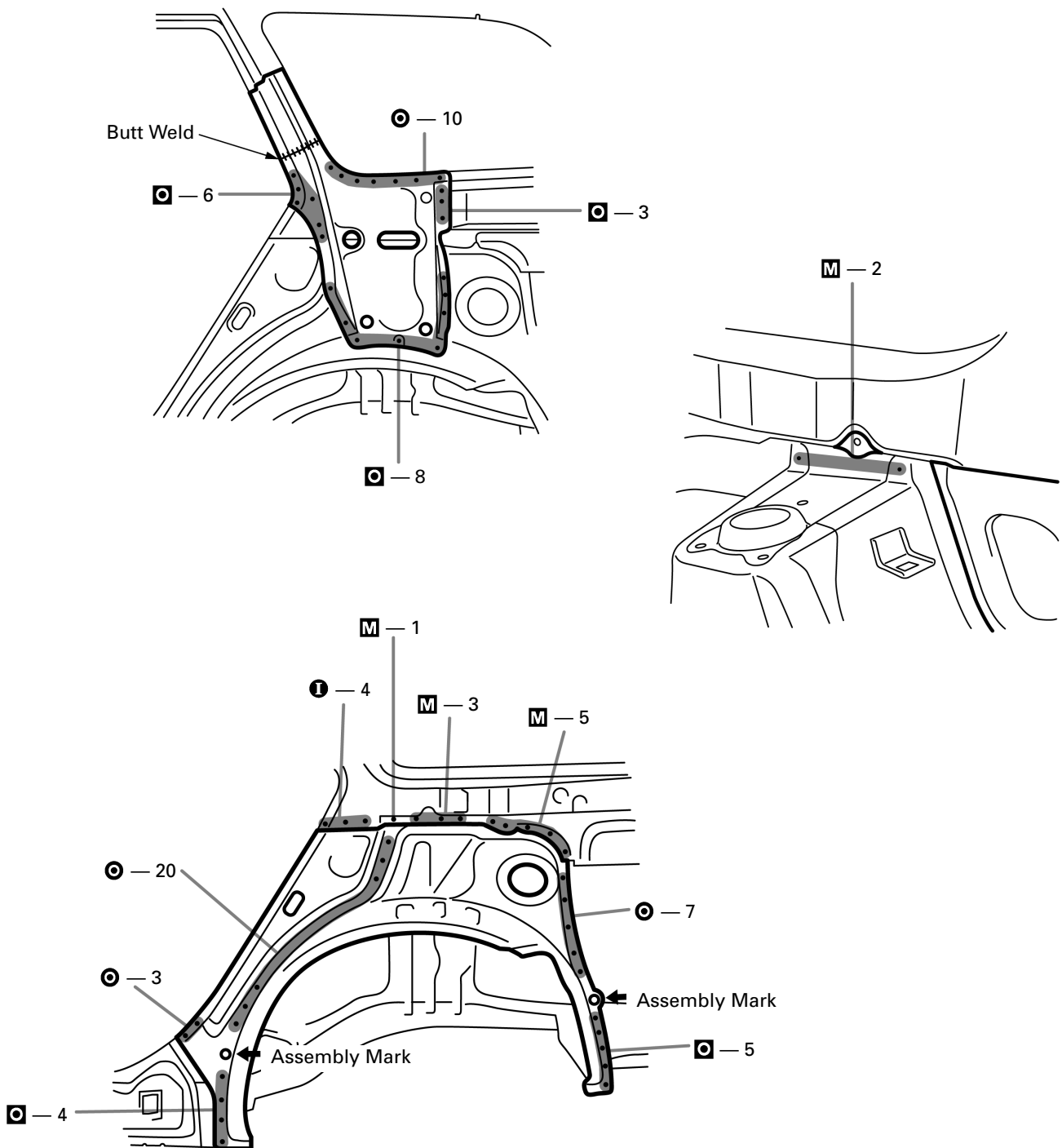


REMOVAL (With the quarter panel removed.)



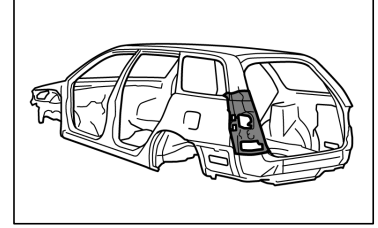
1. Cut the roof side outer panel at the location shown in the above figure and remove the quarter wheel housing outer panel.

INSTALLATION

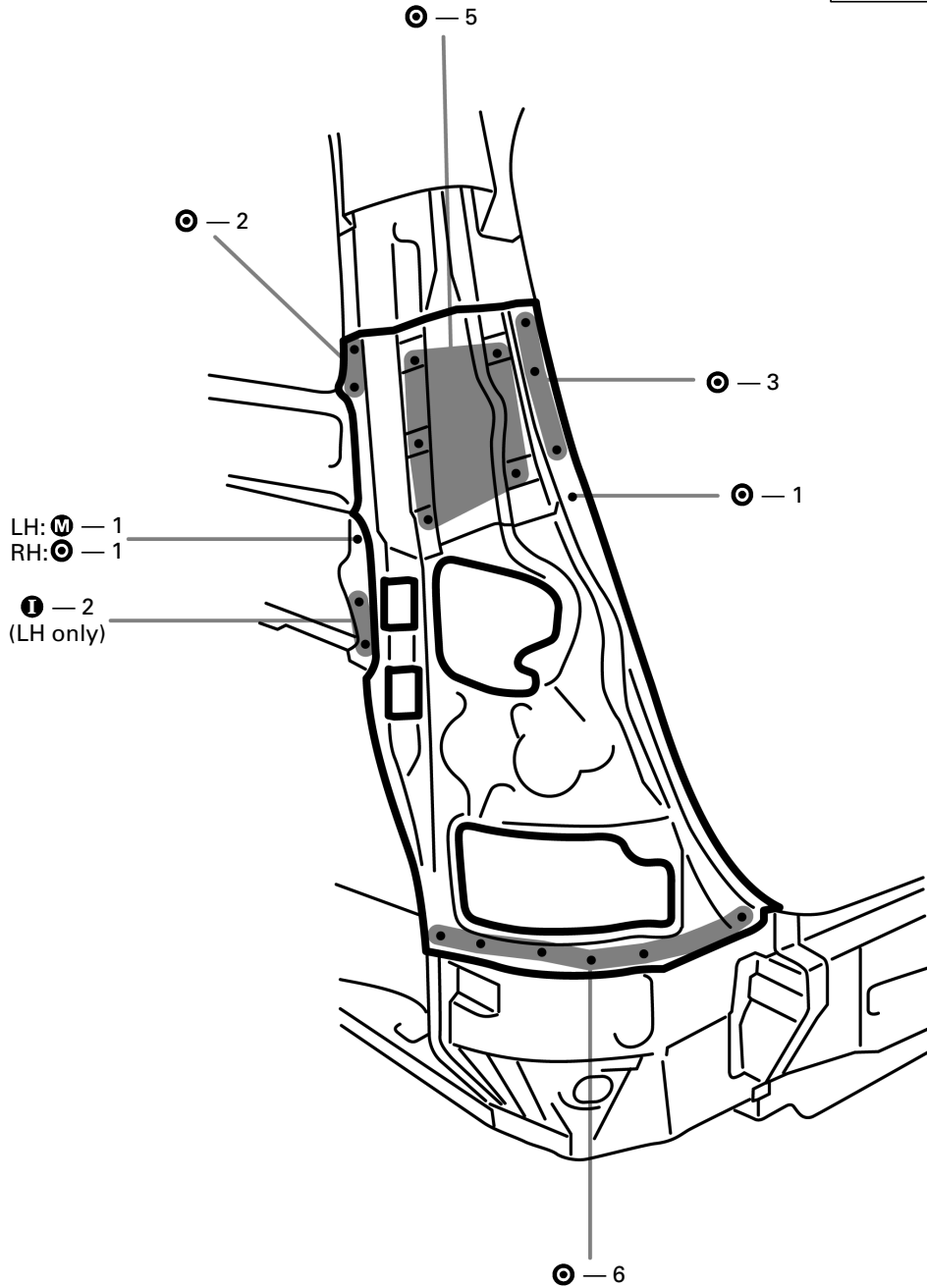


1. Determine the position of the new parts by the assembly marks of the inner and outer panels.
2. Before welding the new parts, temporarily install the quarter panel and check the fit.

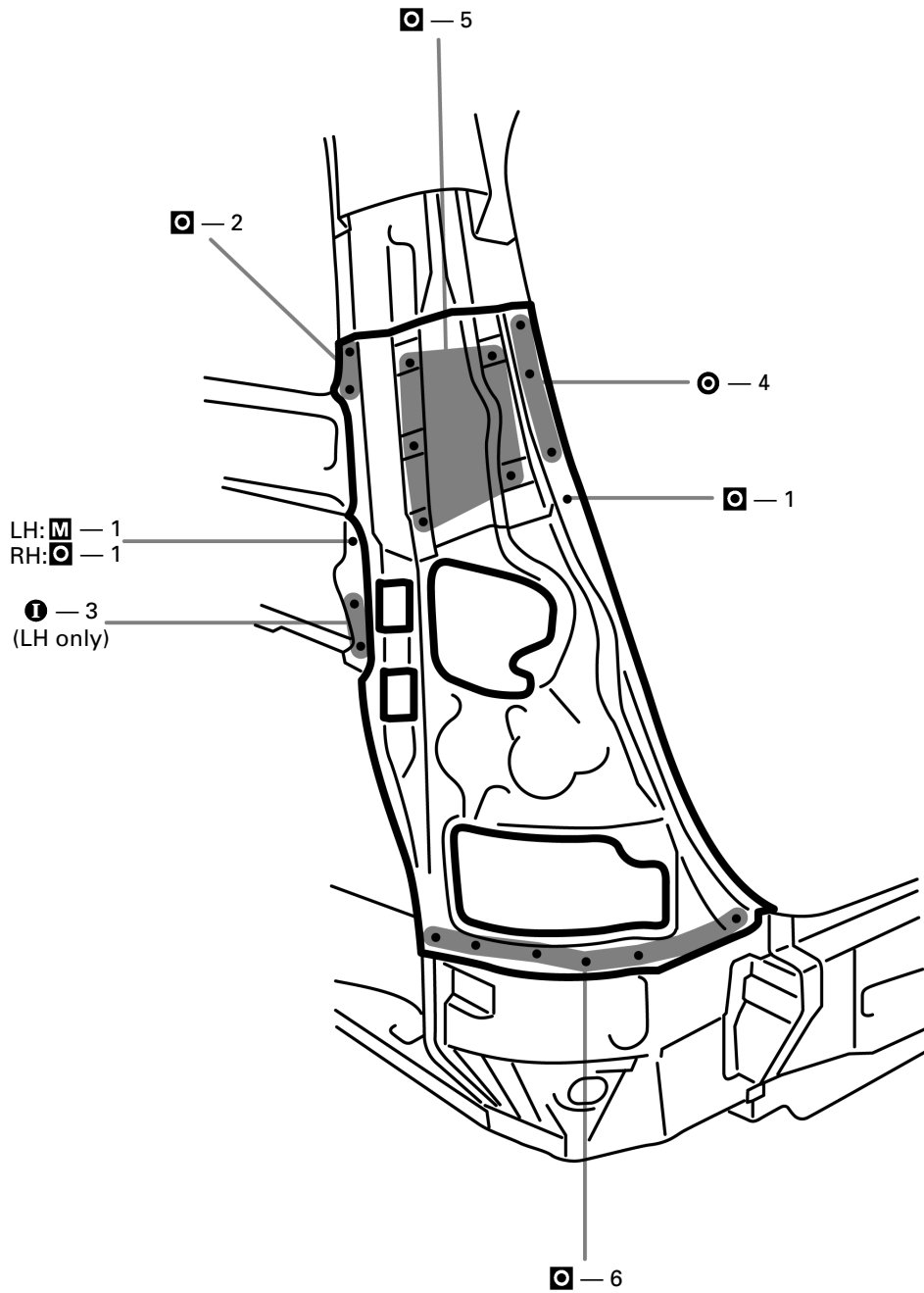
**BACK DOOR OPENING REINFORCEMENT
(ASSY): Wagon**



REMOVAL (With the quarter panel removed.)

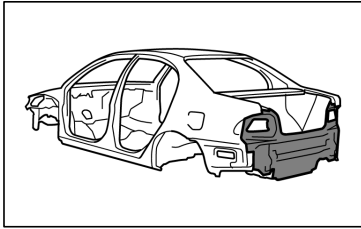


INSTALLATION

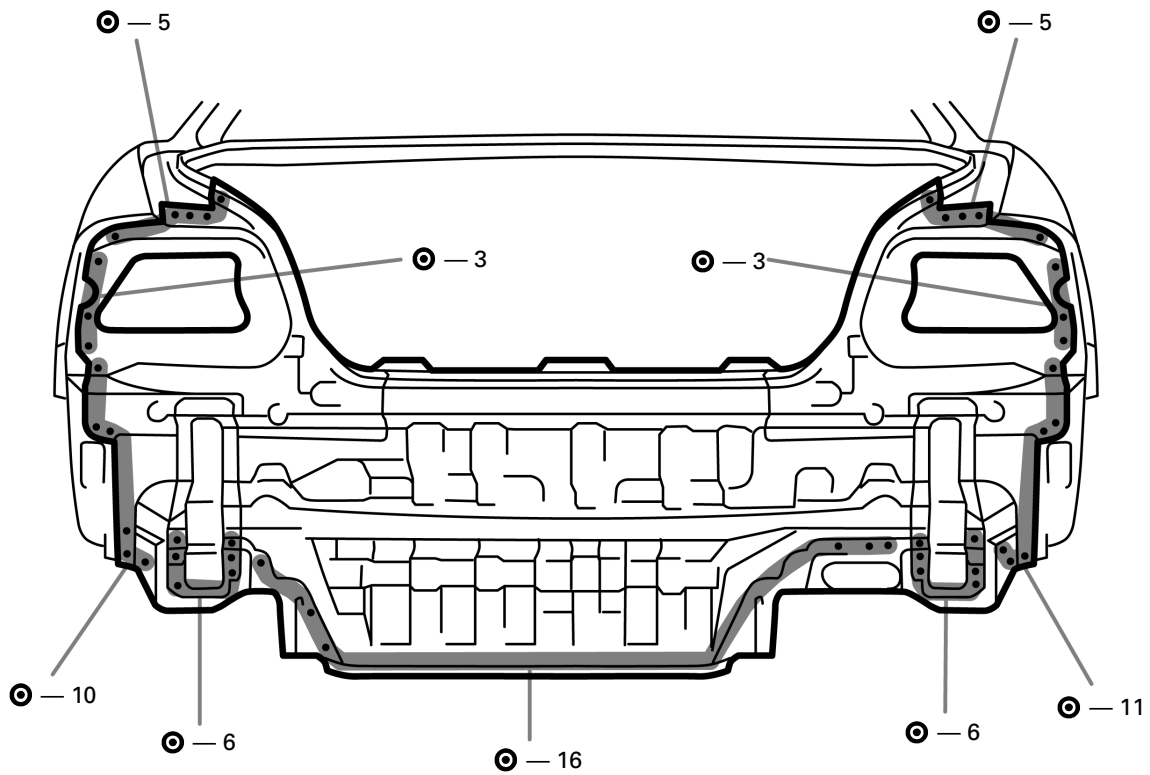


1. Before welding the new parts, temporarily install the quarter panel and check the fit.

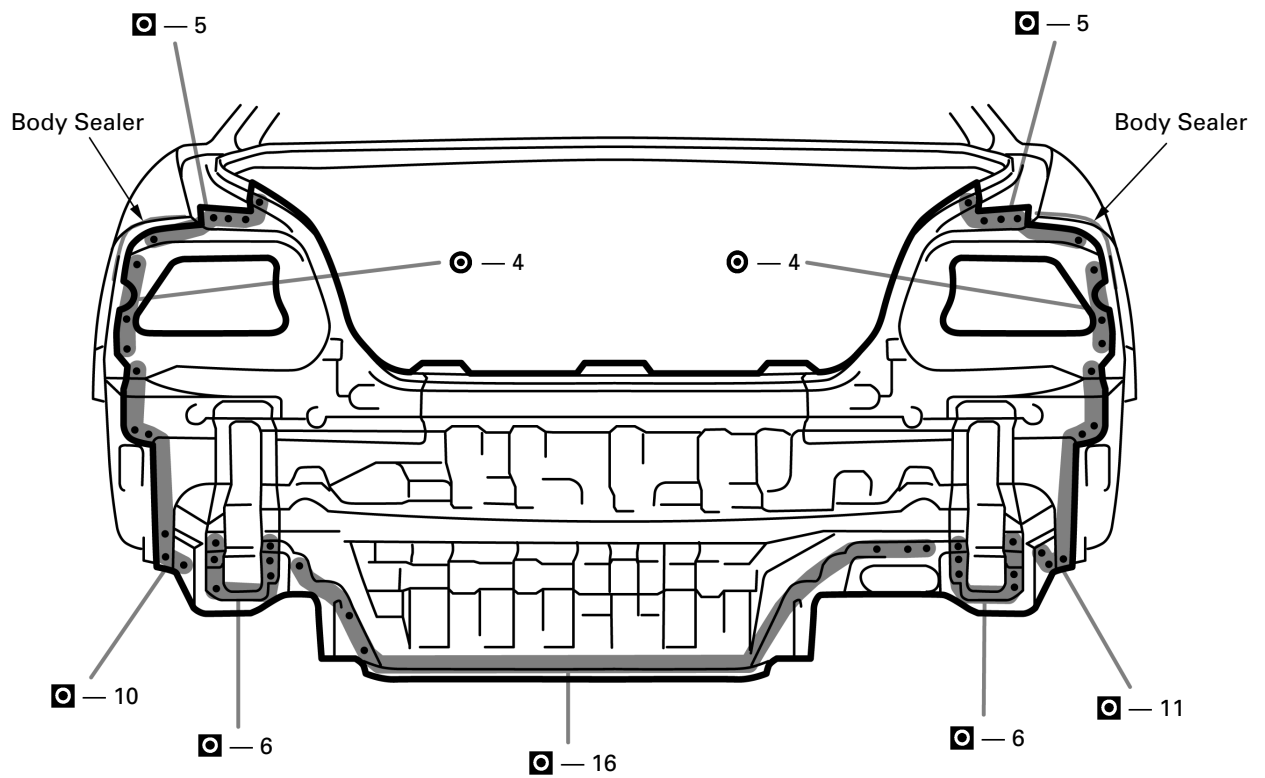
BODY LOWER BACK PANEL (ASSY): Sedan



REMOVAL



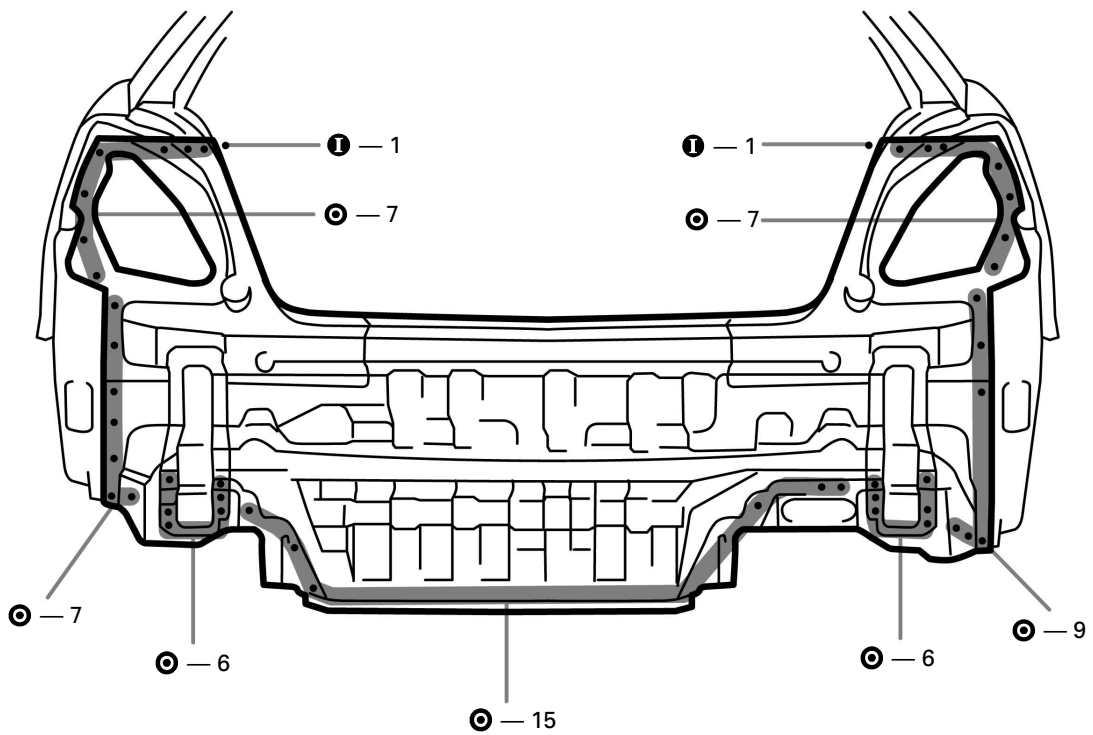
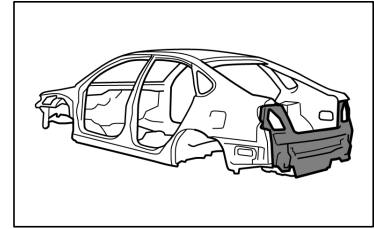
INSTALLATION



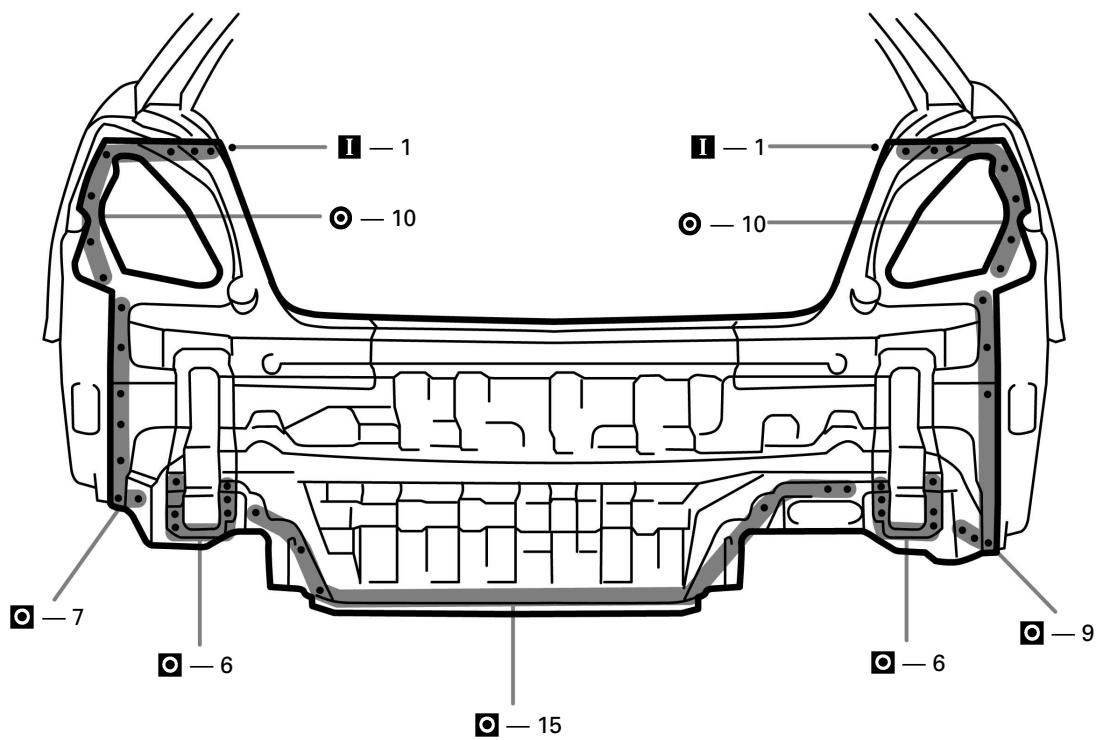
1. Temporarily install the new parts and check the fit of the luggage compartment door and rear combination light.

BODY LOWER BACK PANEL (ASSY): Liftback

REMOVAL

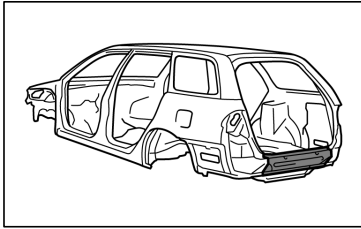


INSTALLATION

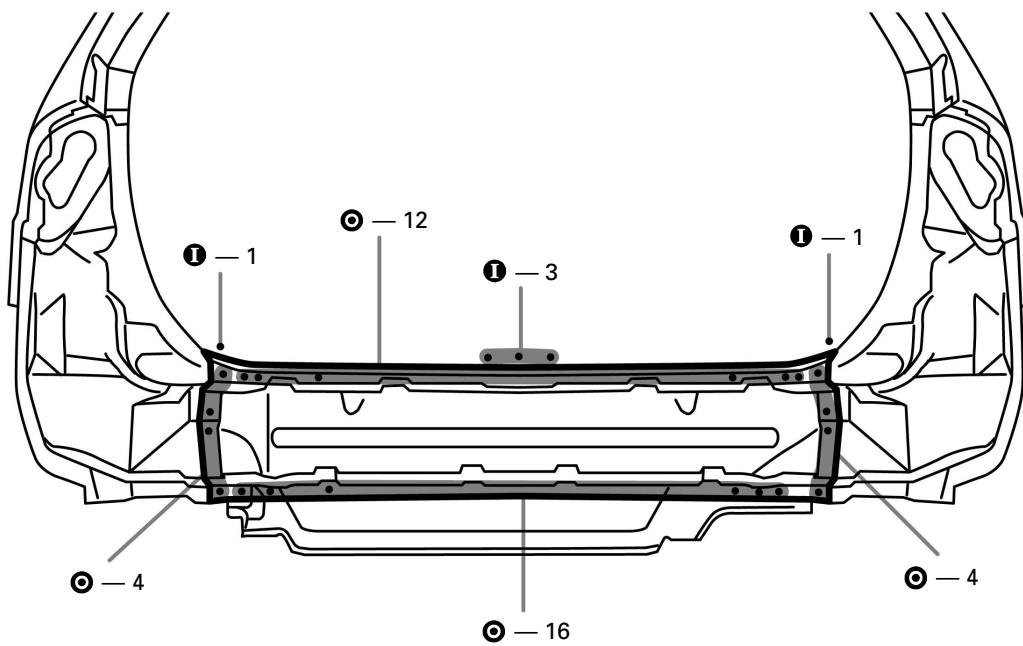


1. Temporarily install the new parts and check the fit of the back door and rear combination light.

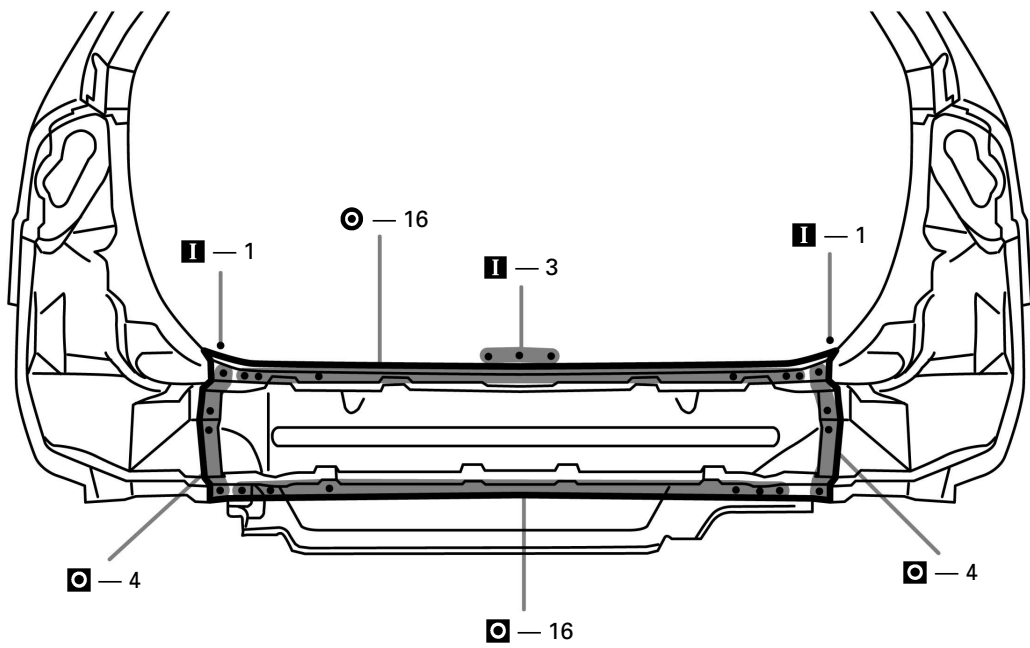
BODY LOWER BACK PANEL (ASSY): Wagon



REMOVAL

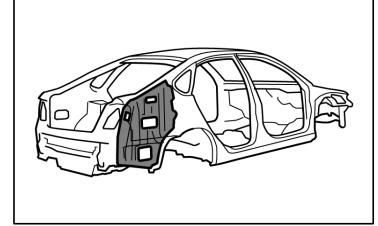


INSTALLATION

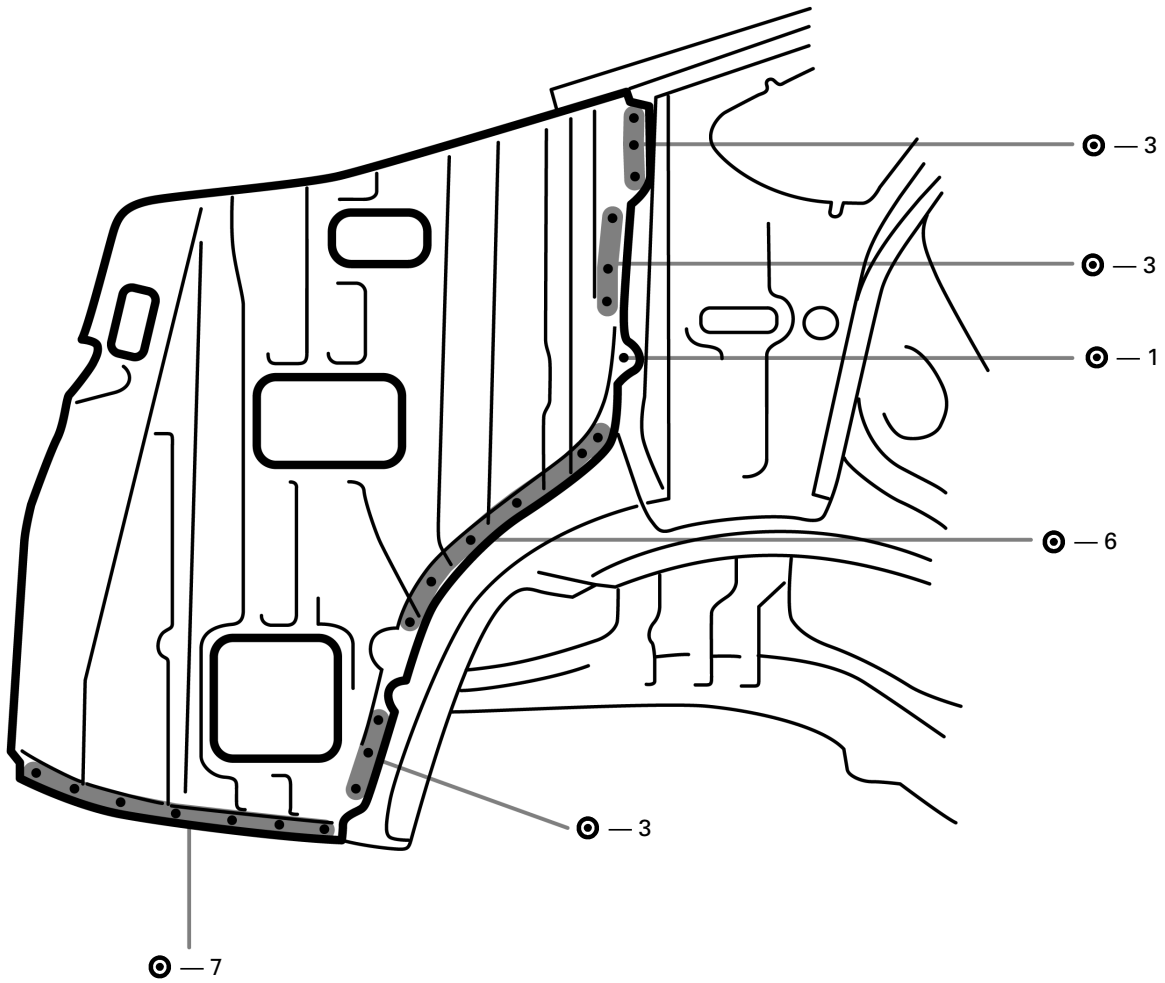


1. Temporarily install the new parts and check the fit of the back door.

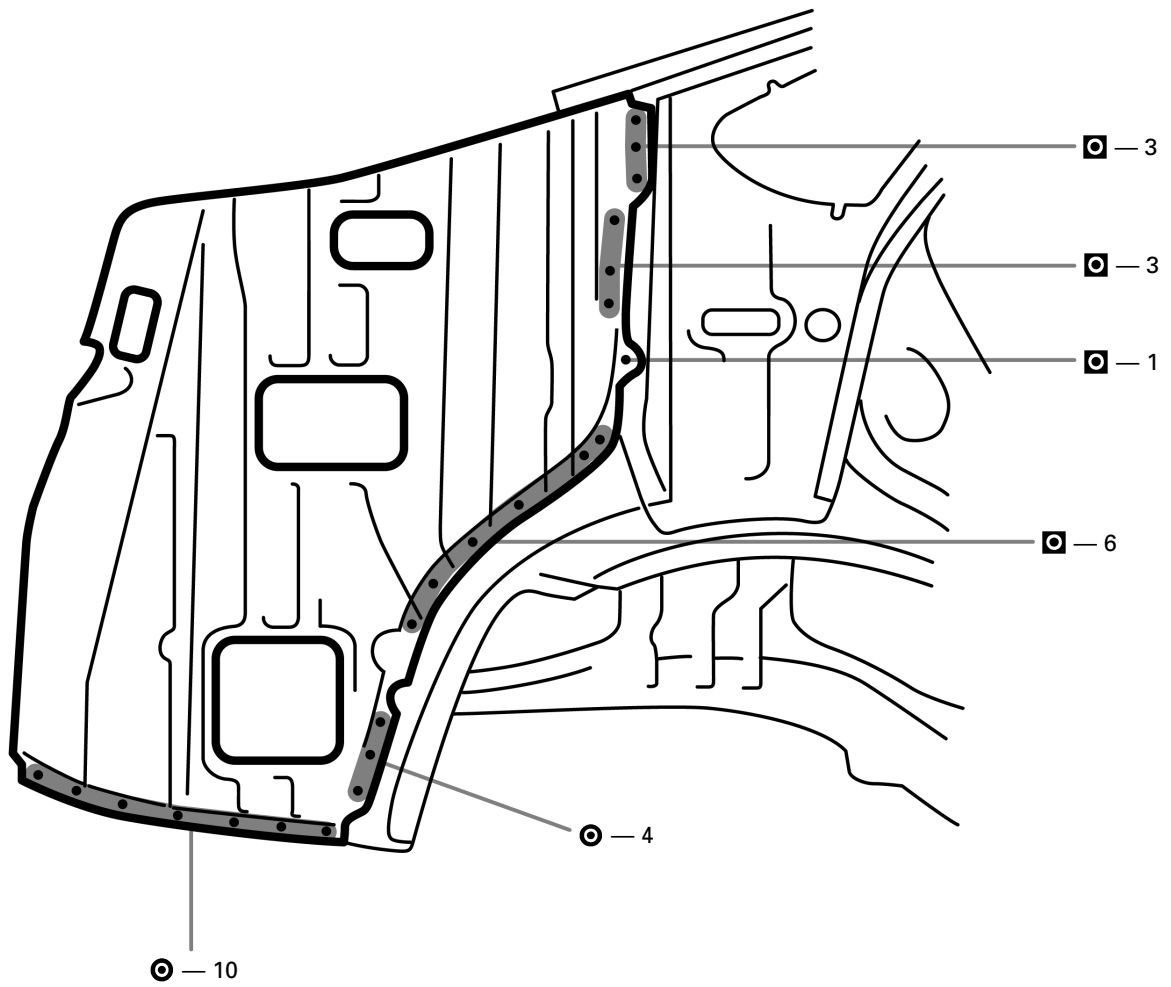
**ROOF SIDE INNER REAR PANEL (ASSY):
Liftback RH**



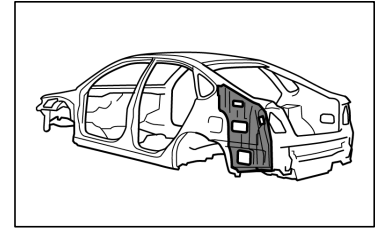
REMOVAL (With the quarter panel and body lower back panel removed.)



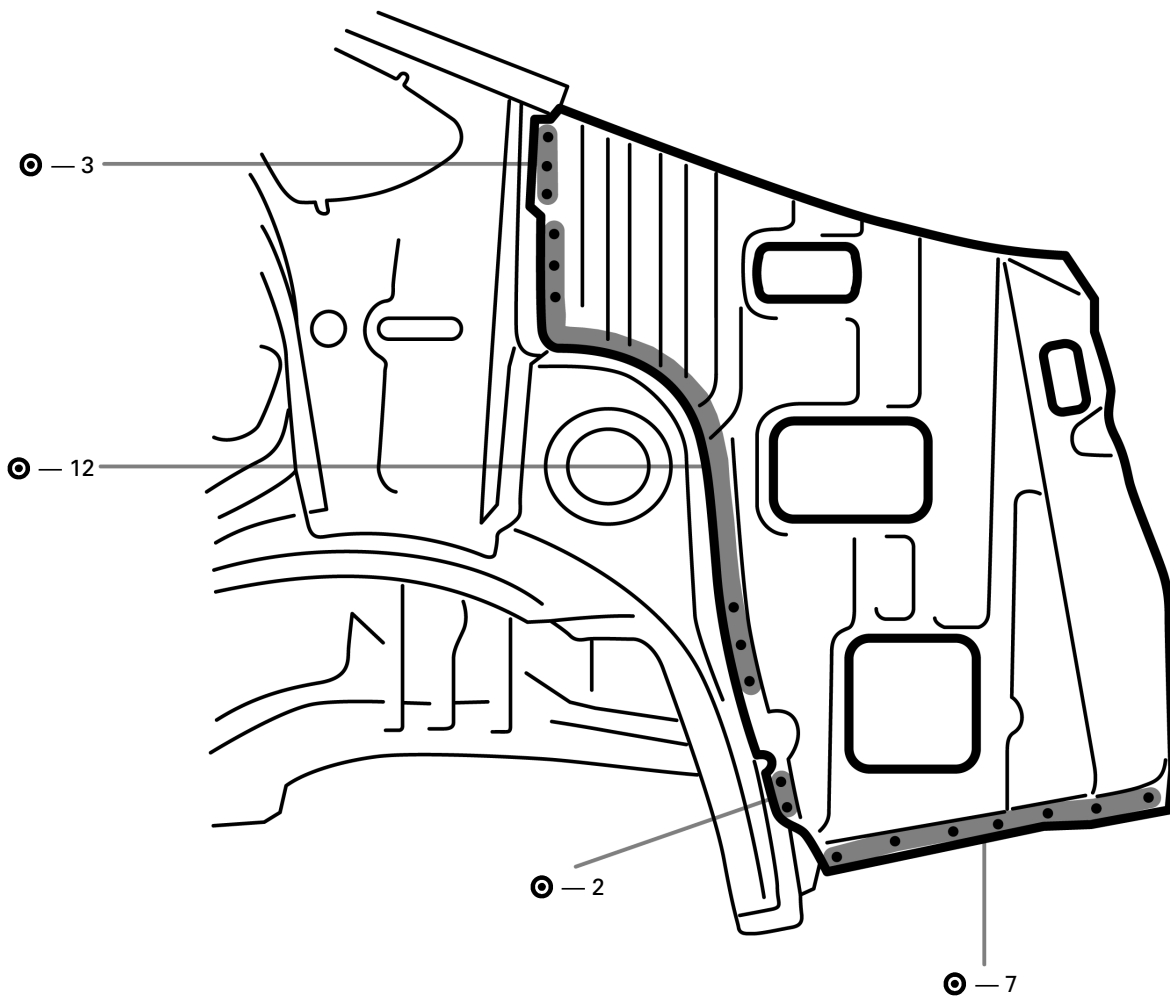
INSTALLATION



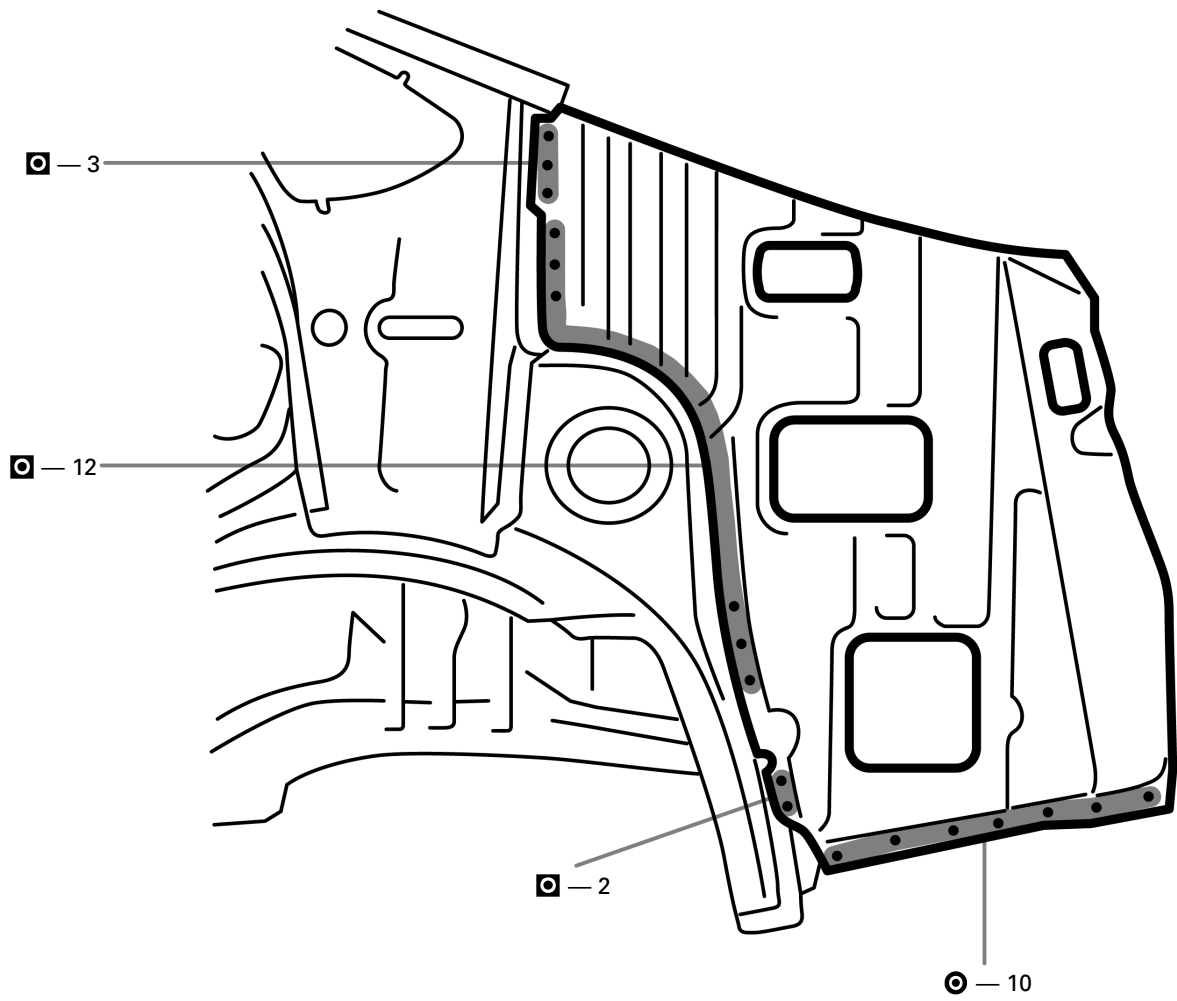
**ROOF SIDE INNER REAR PANEL (ASSY):
Liftback LH**

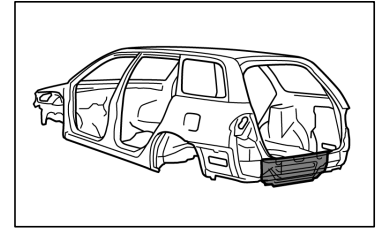
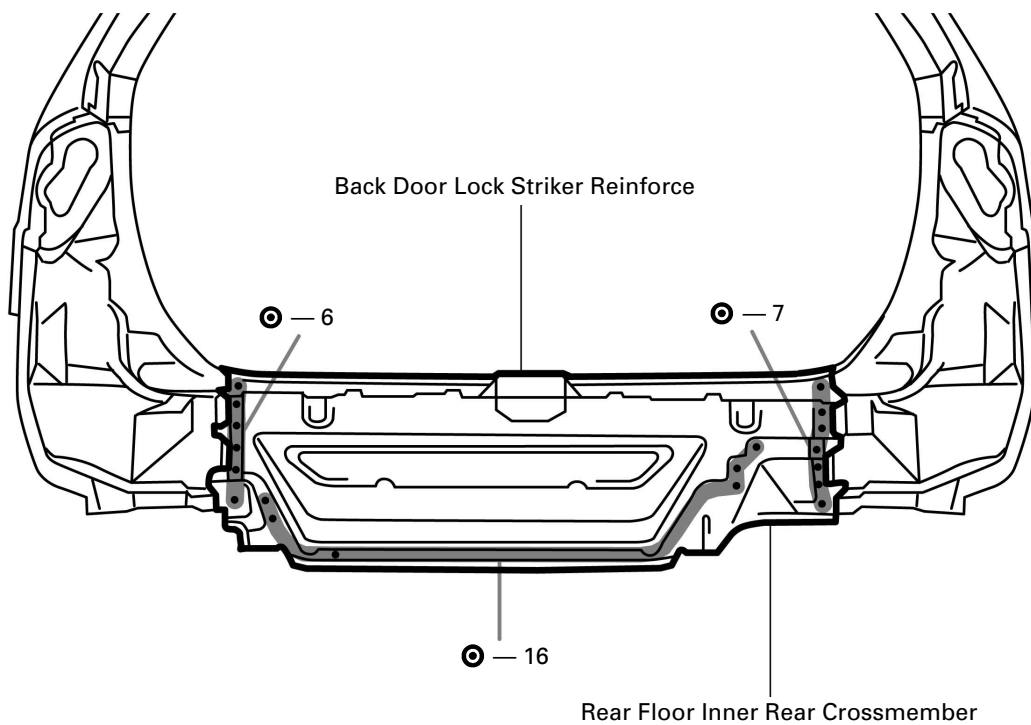


REMOVAL (With the quarter panel and body lower back panel removed.)

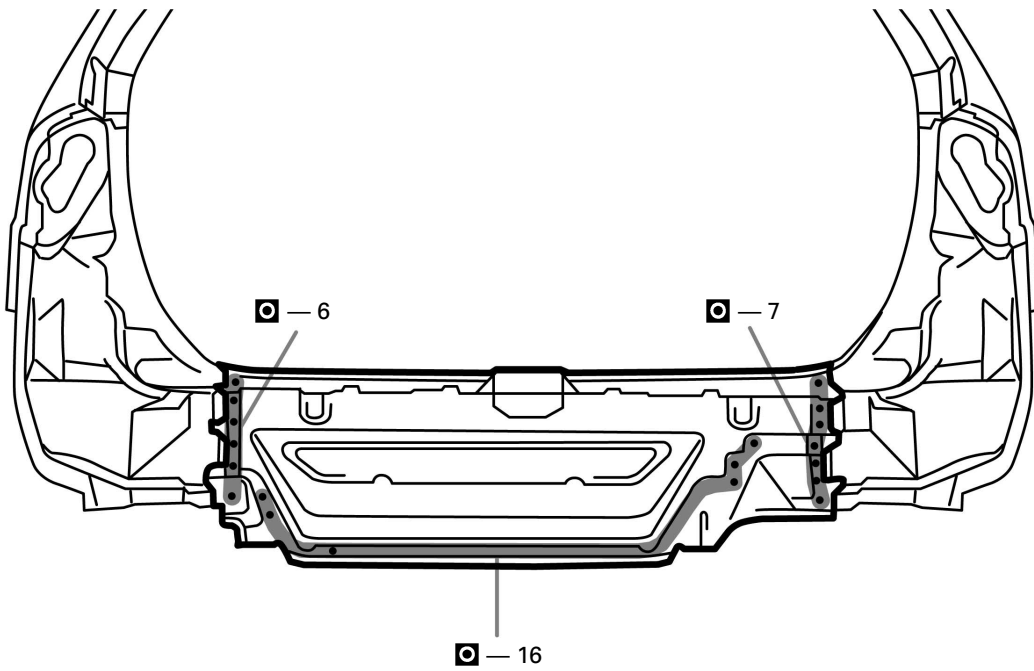


INSTALLATION



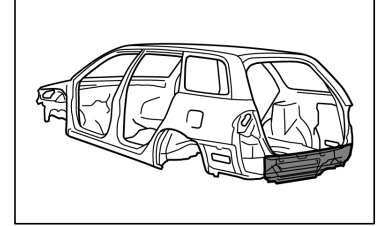
**REAR FLOOR INNER REAR CROSSMEMBER
(CUT-H): Wagon****REMOVAL (With the body lower back panel removed.)**

1. Remove the back door lock striker reinforce and rear floor inner rear crossmember.

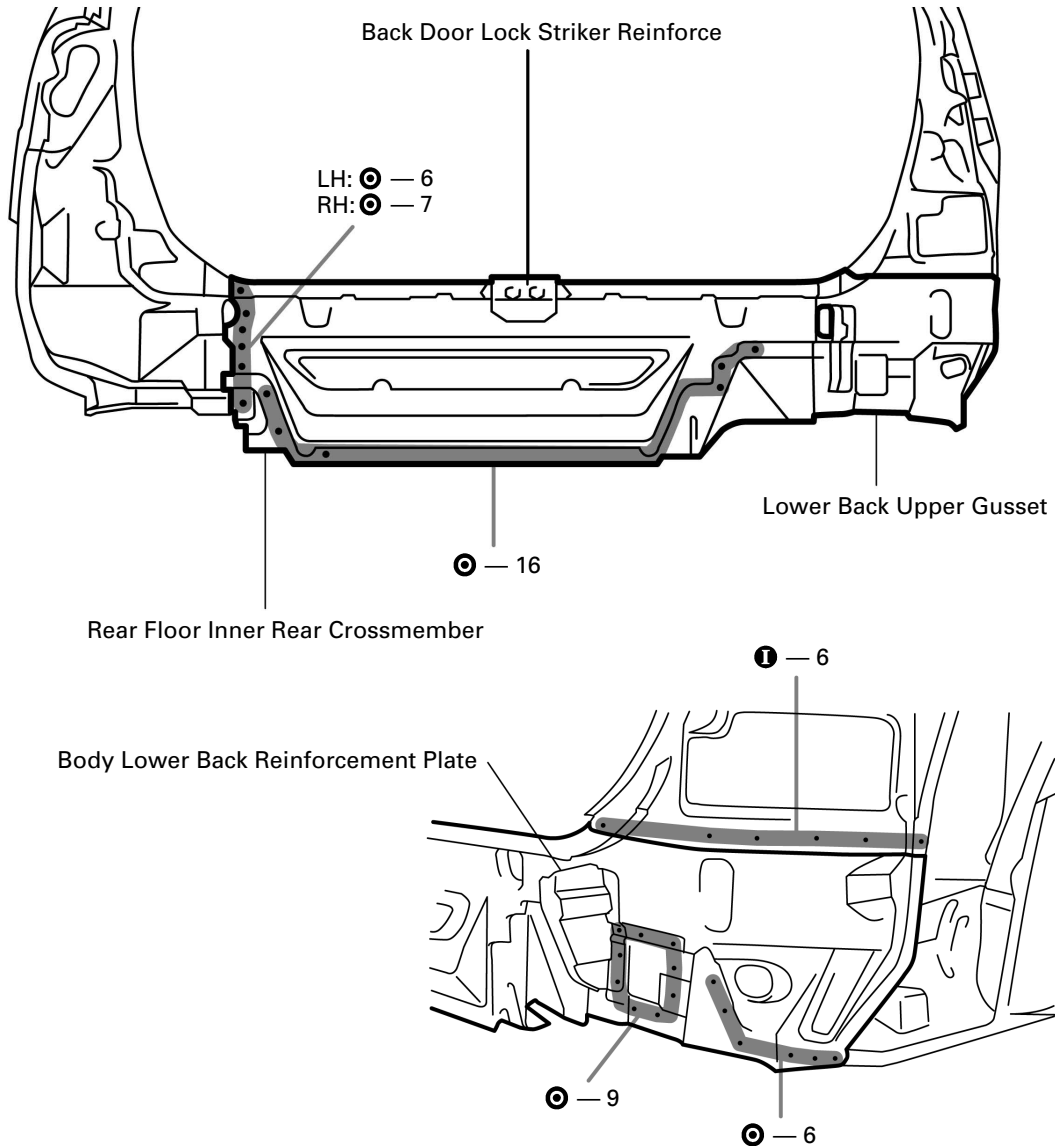
INSTALLATION

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

REAR FLOOR INNER REAR CROSSMEMBER (CUT): Wagon

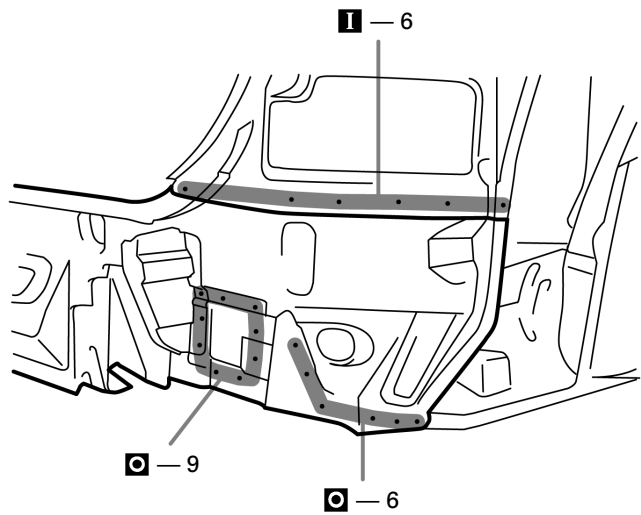
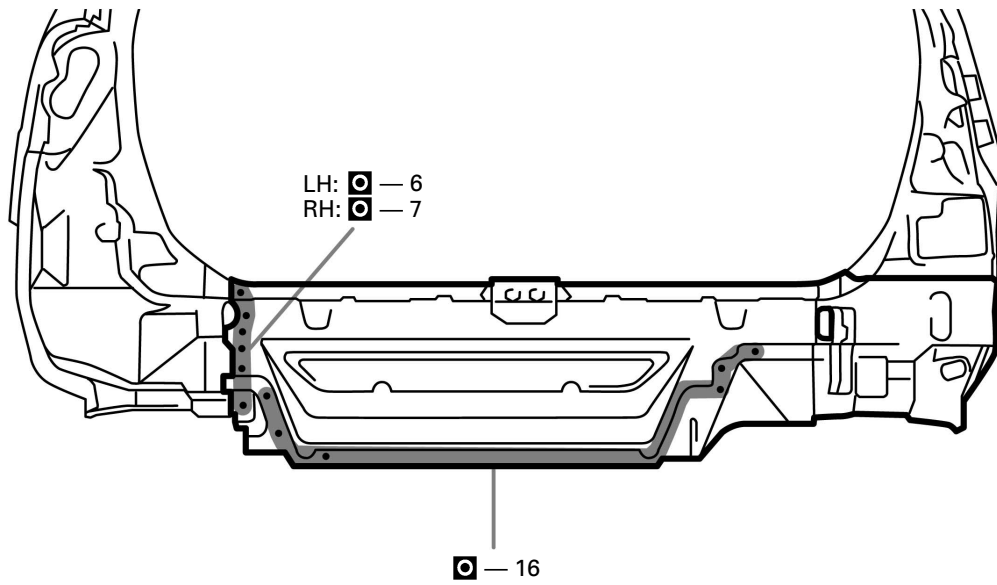


REMOVAL (With the quarter panel and body lower back panel removed.)



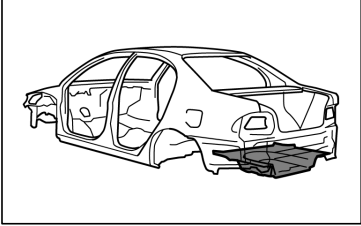
1. Remove the back door lock striker reinforce, rear floor inner rear crossmember, lower back upper gusset and body lower back reinforcement plate.

INSTALLATION

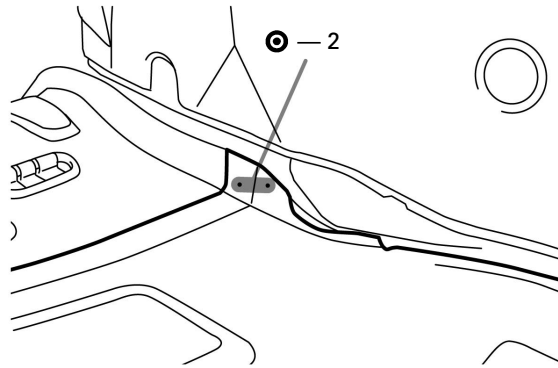
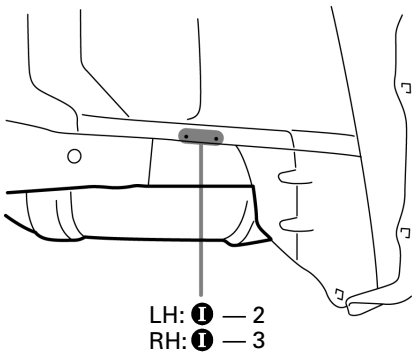
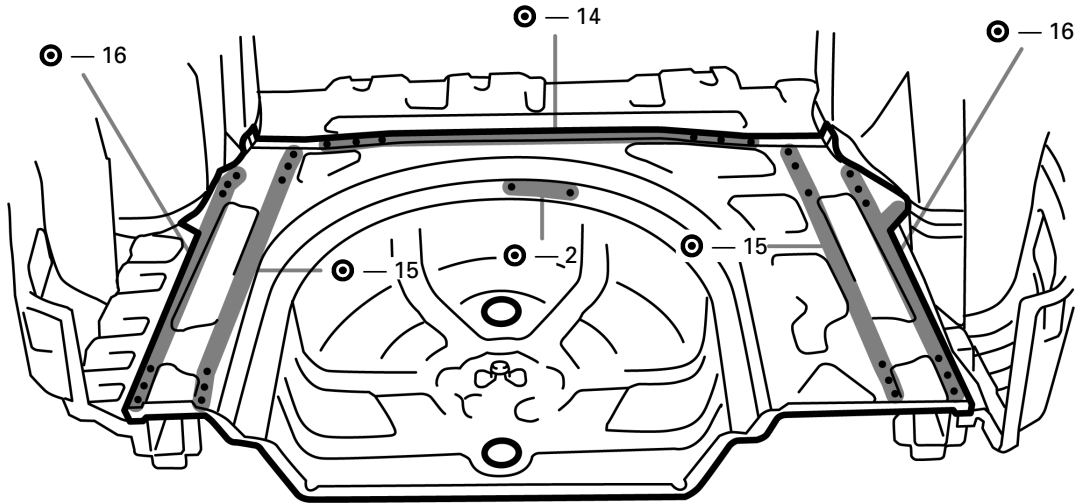


1. Before welding the new parts, temporarily install the quarter panel and body lower back panel and check the fit.

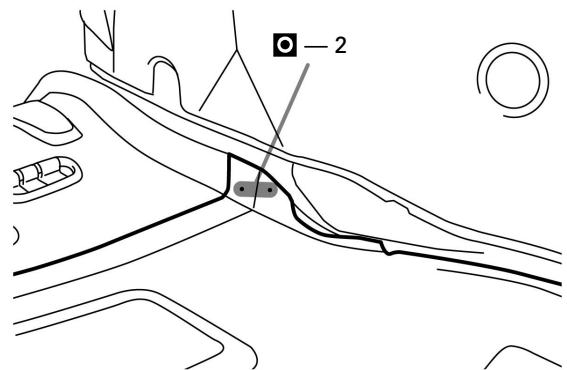
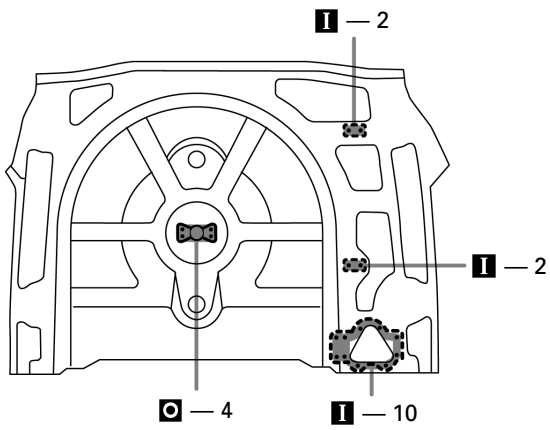
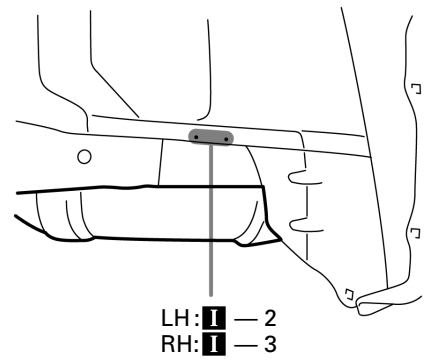
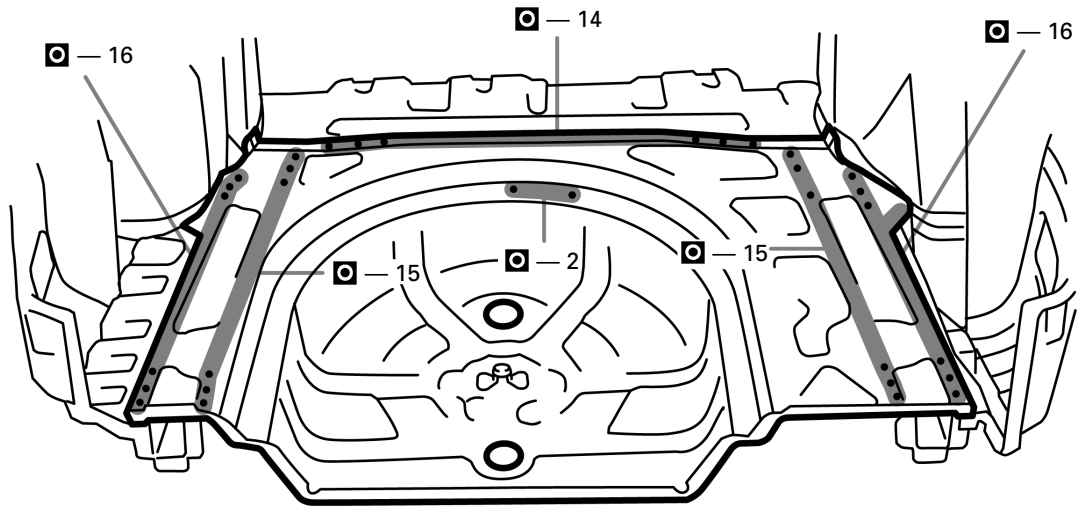
REAR FLOOR PAN (ASSY): Sedan, Liftback



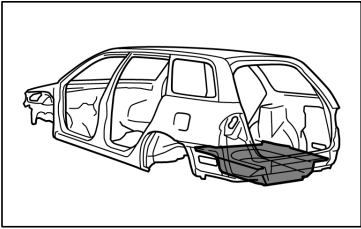
REMOVAL (With the body lower back panel removed.)



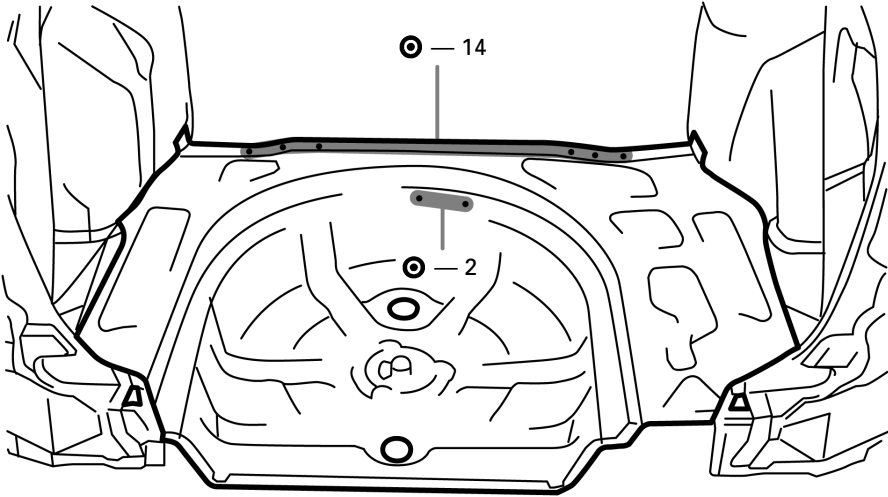
INSTALLATION



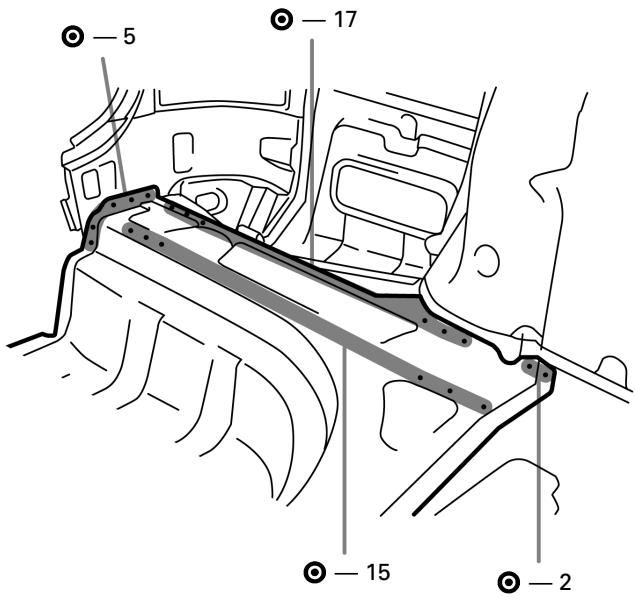
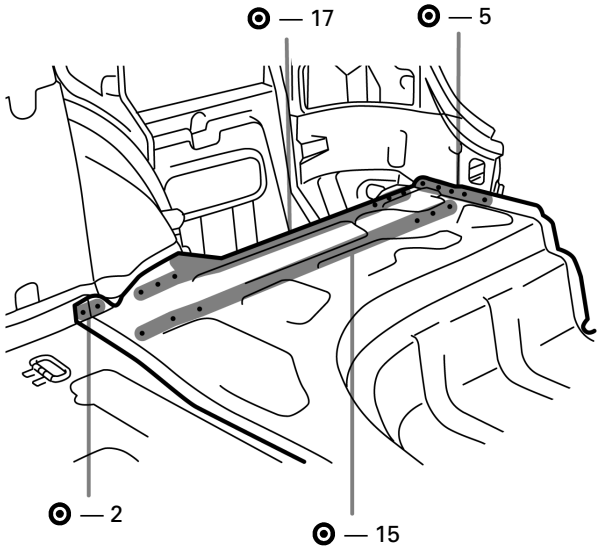
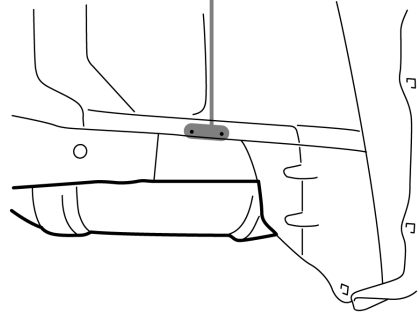
REAR FLOOR PAN (ASSY): Wagon



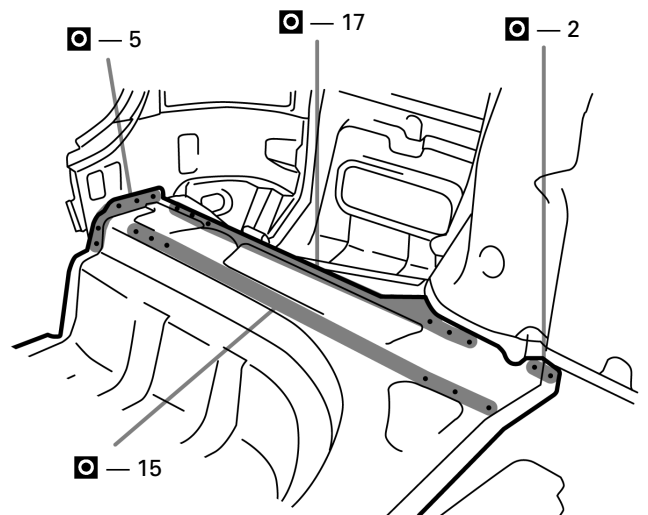
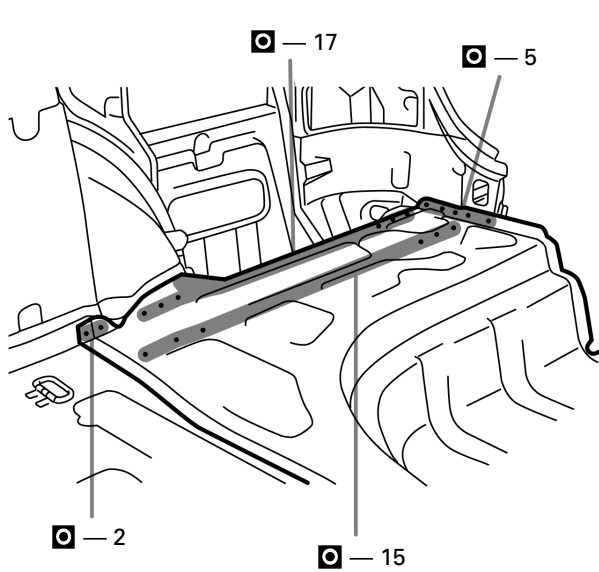
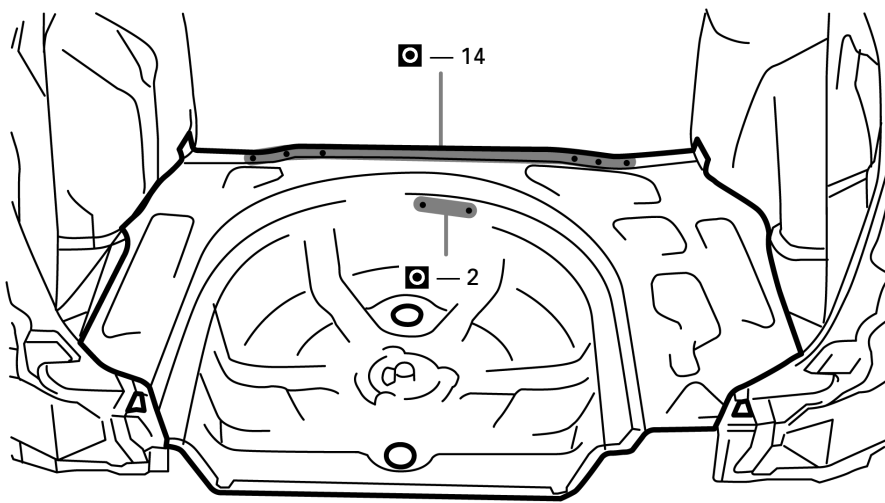
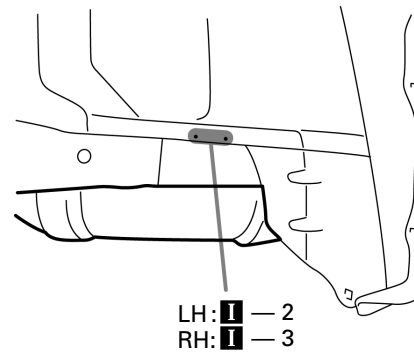
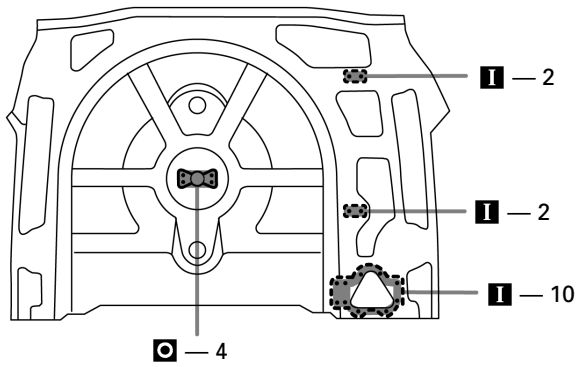
REMOVAL (With the rear floor inner rear crossmember removed.)



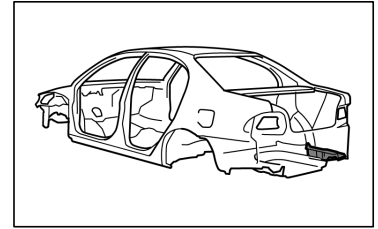
LH: 1 - 2
RH: 1 - 3



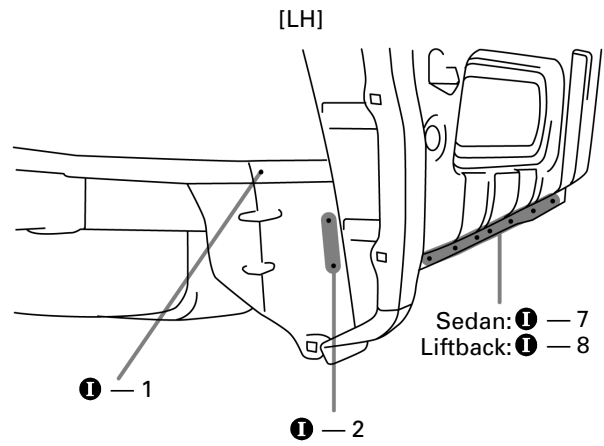
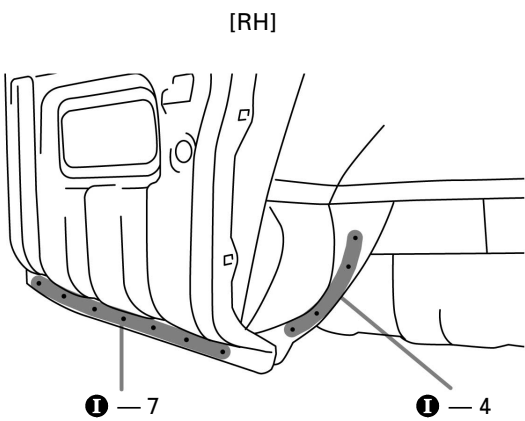
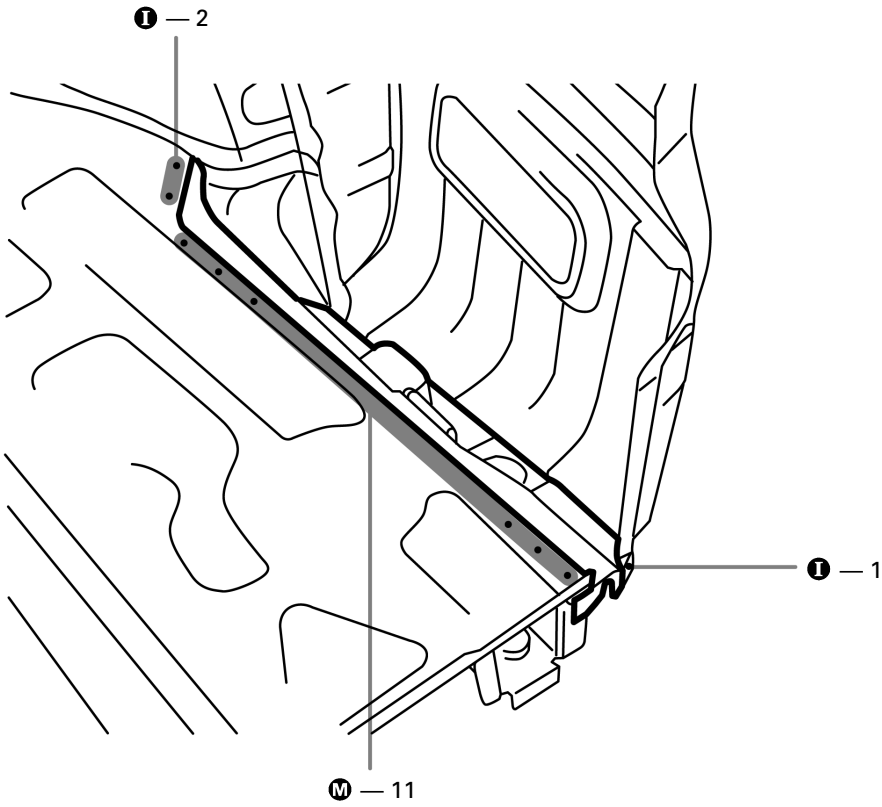
INSTALLATION



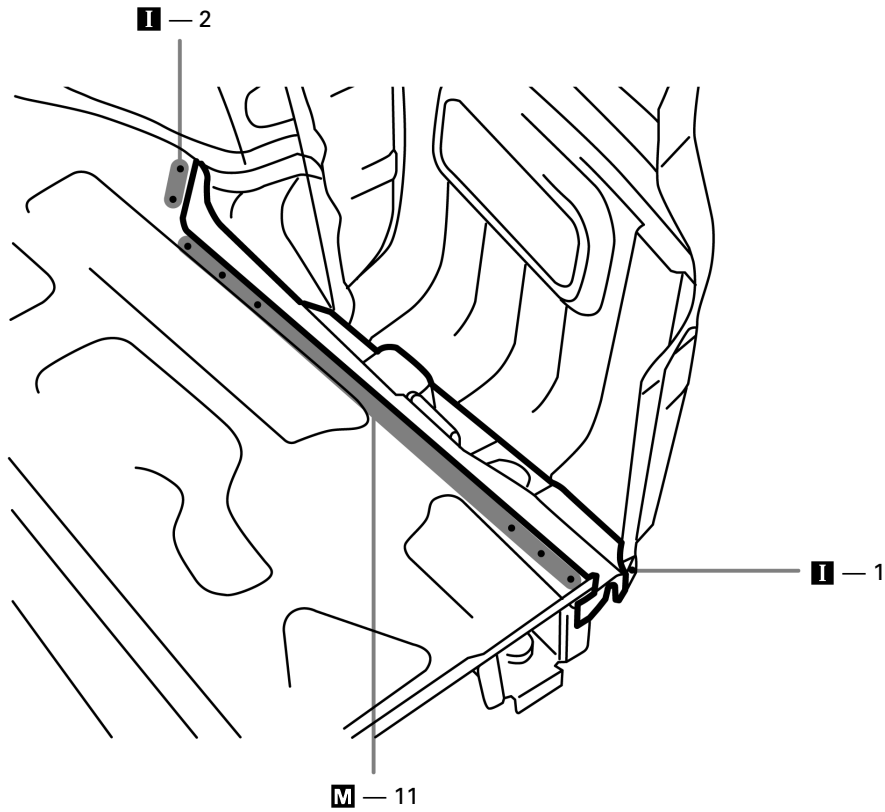
**REAR FLOOR SIDE PANEL (ASSY):
Sedan, Liftback**



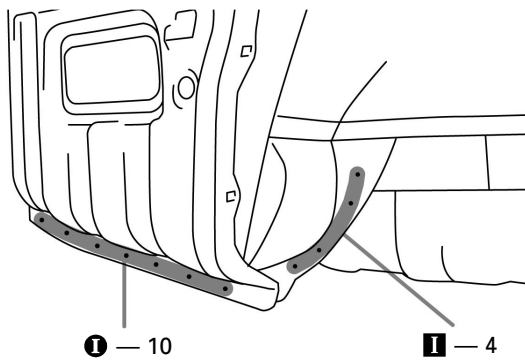
REMOVAL (With the body lower back panel removed.)



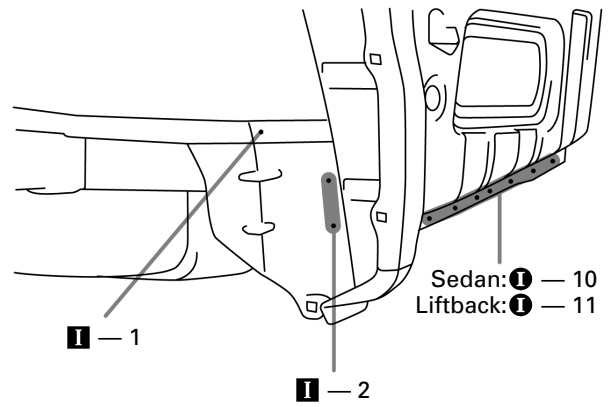
INSTALLATION



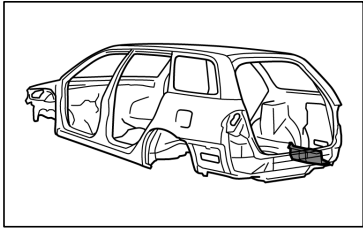
[RH]



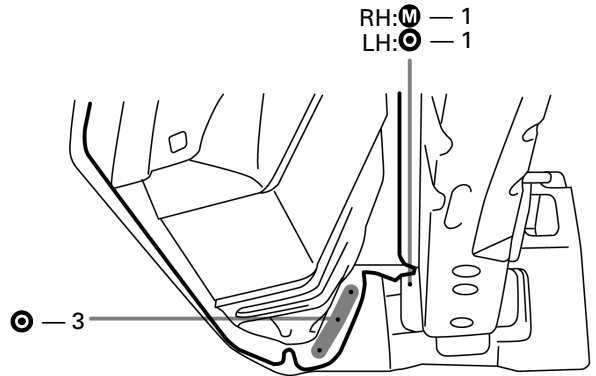
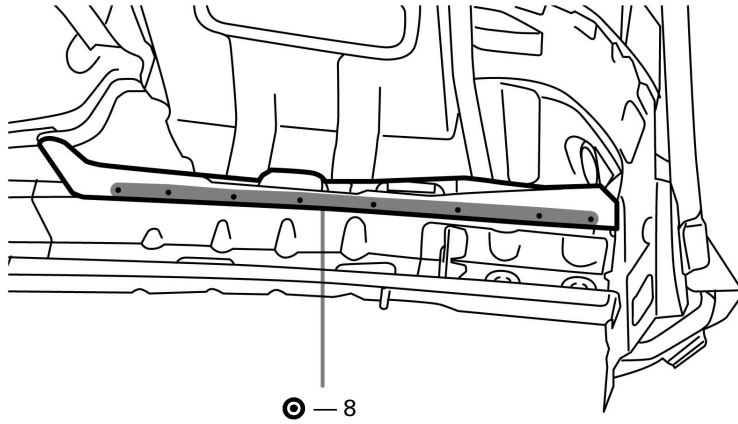
[LH]



REAR FLOOR SIDE PANEL (ASSY): Wagon

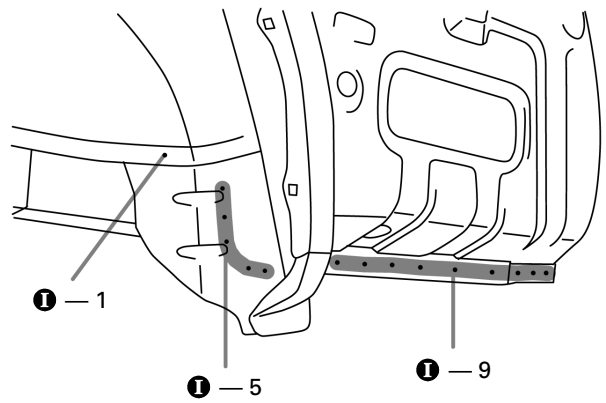
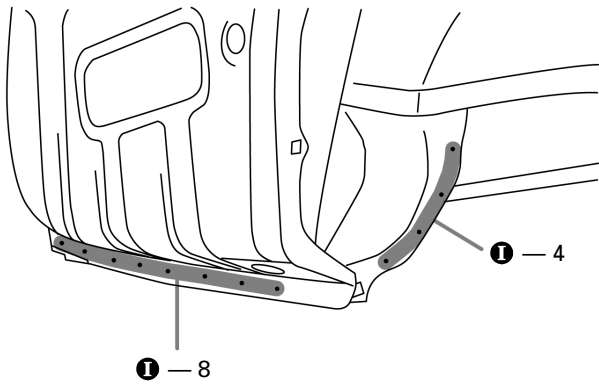


REMOVAL (With the rear floor pan removed.)

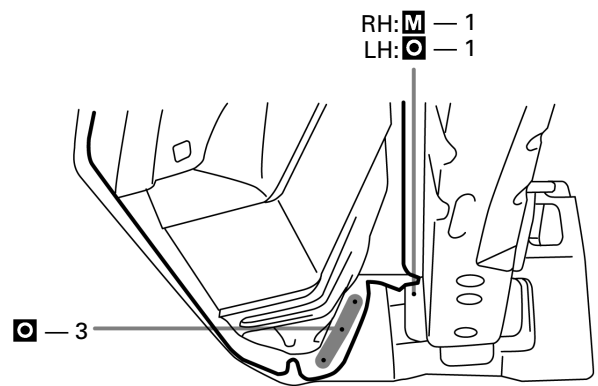
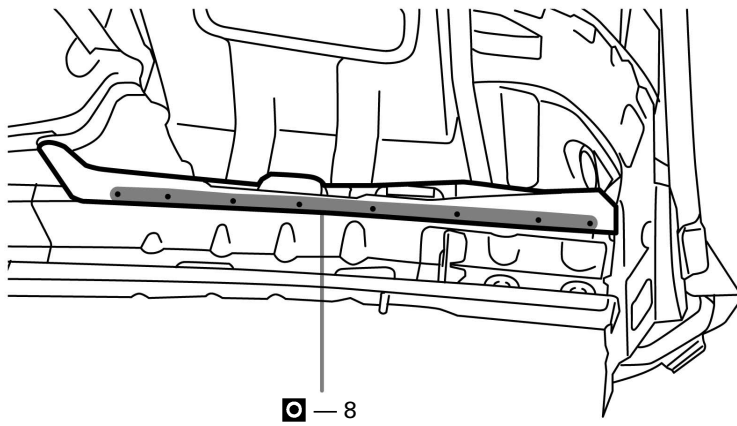


[RH]

[LH]

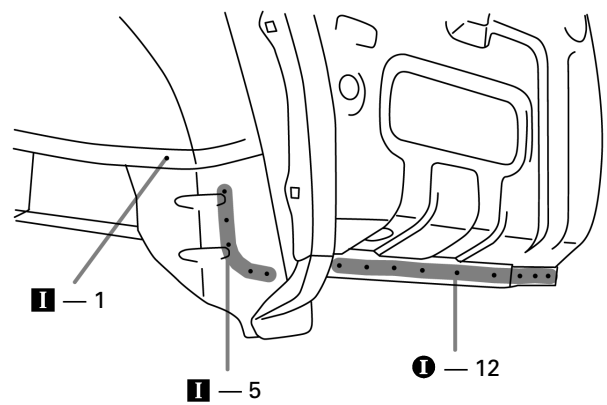
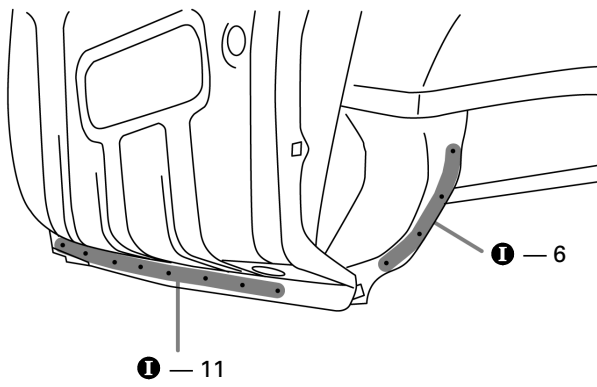


INSTALLATION

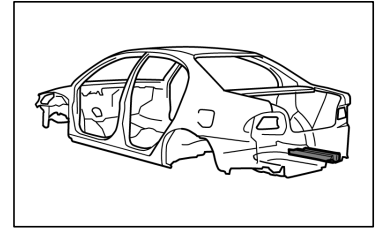


[RH]

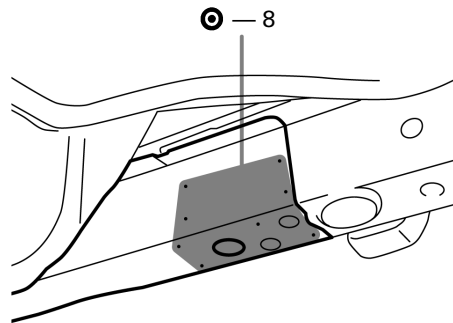
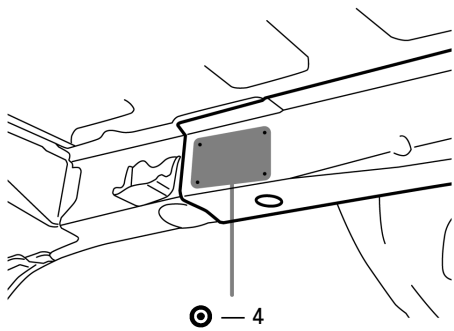
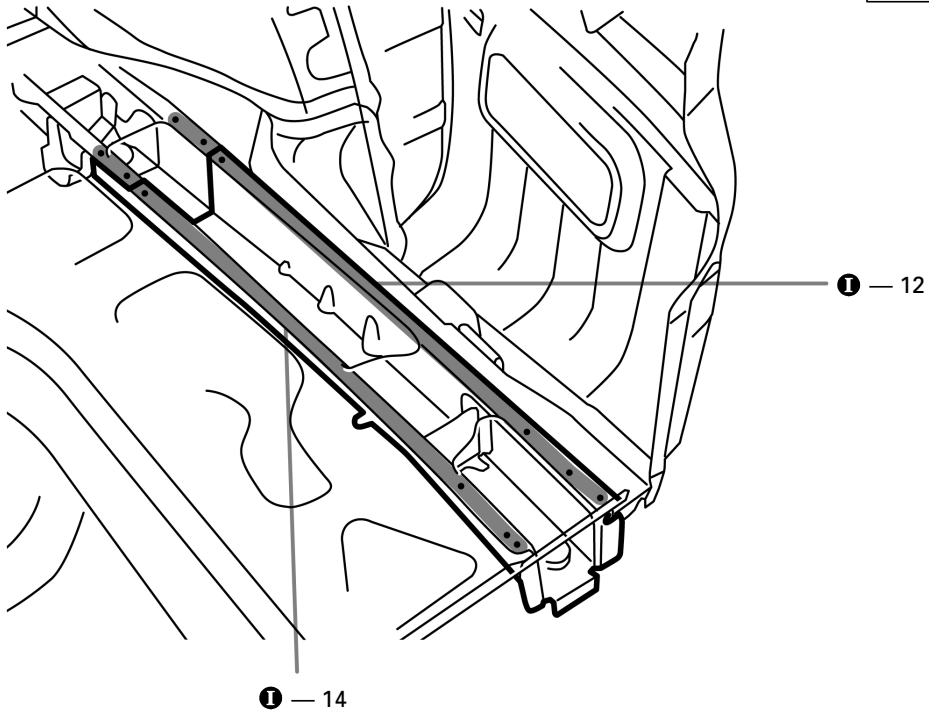
[LH]



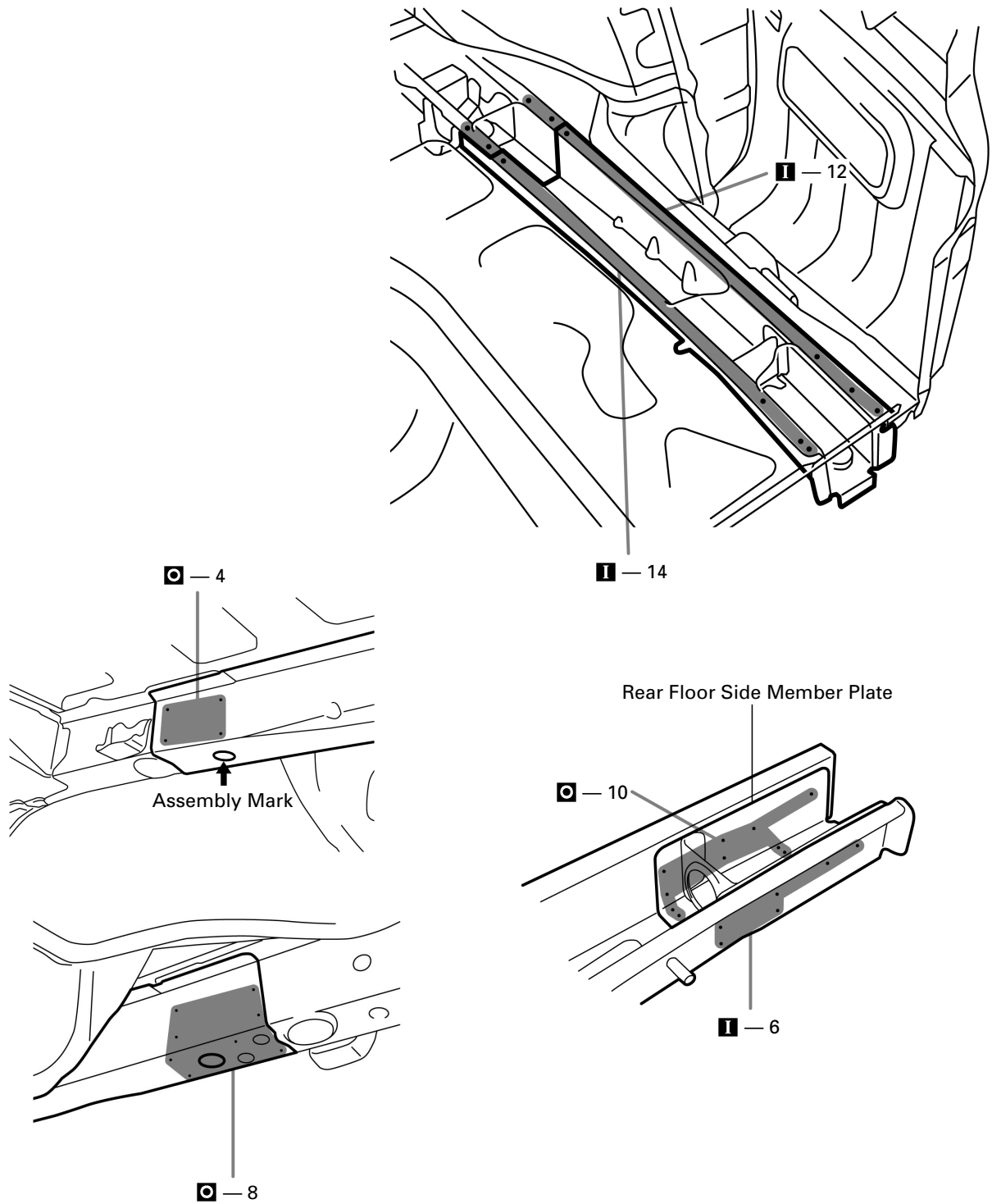
**REAR FLOOR SIDE REAR MEMBER (ASSY):
Sedan, Liftback**



REMOVAL (With the body lower back panel removed.)

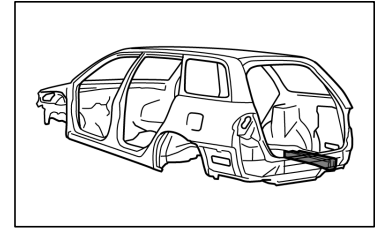


INSTALLATION

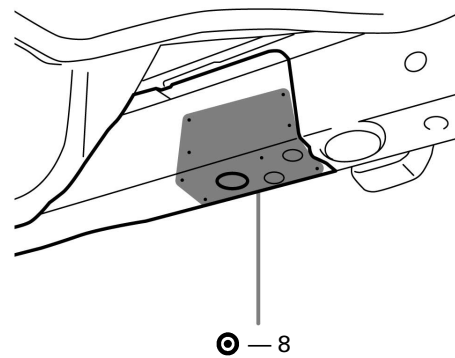
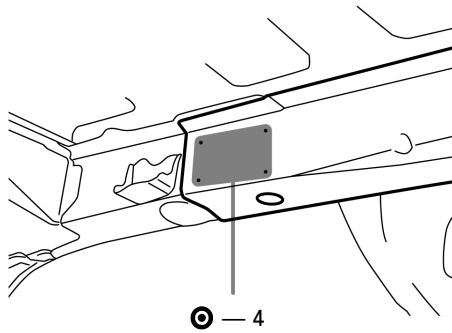
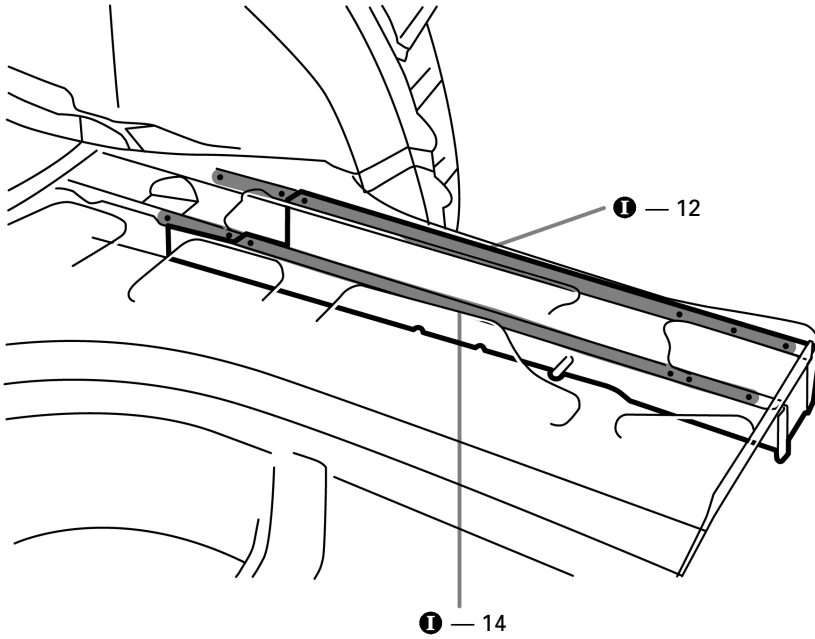


1. When temporarily installing the new parts, determine the installation position by the assembly mark. Then, measure each part in accordance with the body dimension diagram.
2. Weld the rear floor side member plate to the rear floor side rear member.

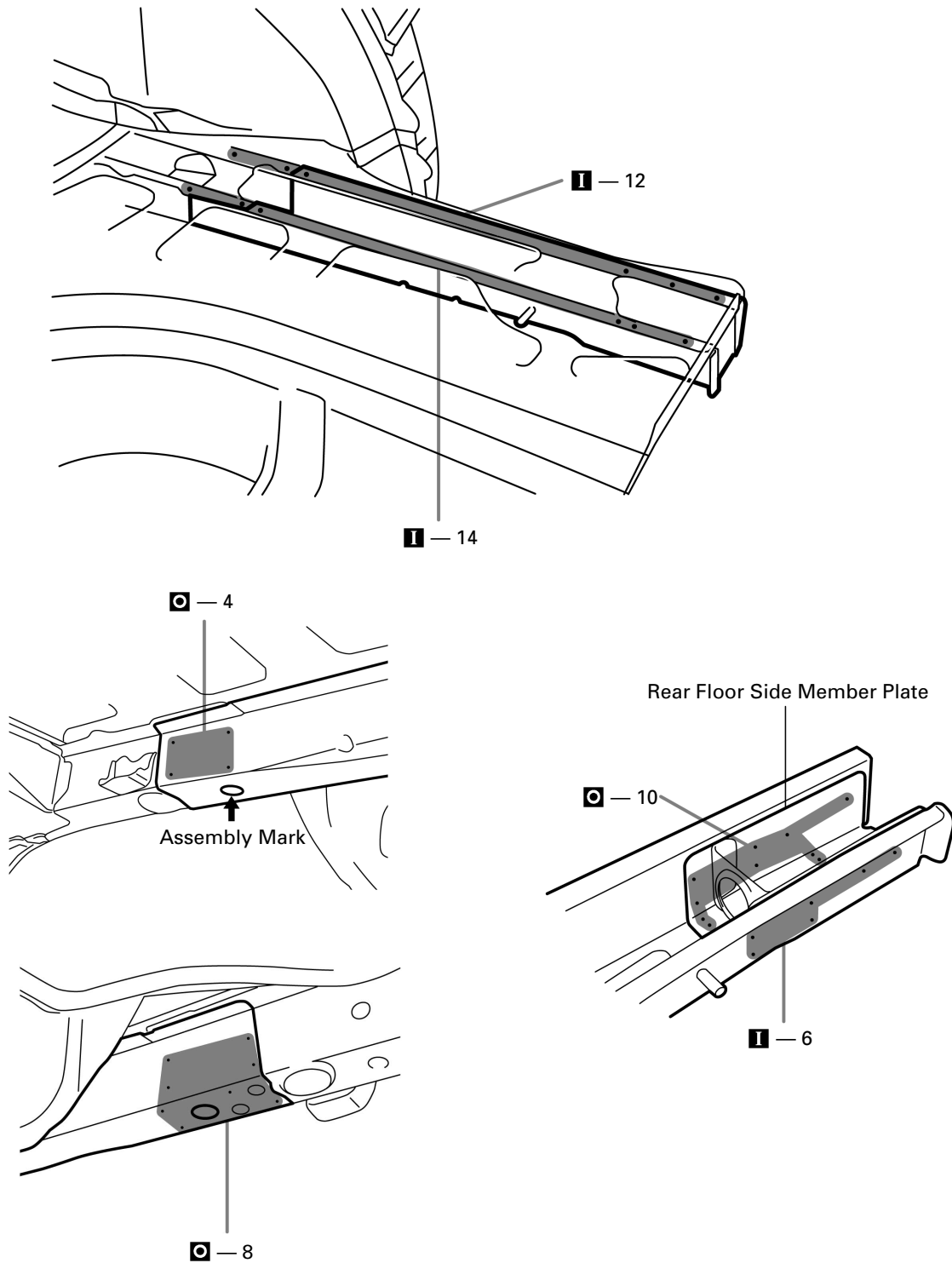
**REAR FLOOR SIDE REAR MEMBER (ASSY):
Wagon**



REMOVAL (With the rear floor inner rear crossmember removed.)

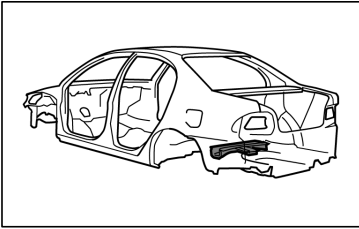


INSTALLATION

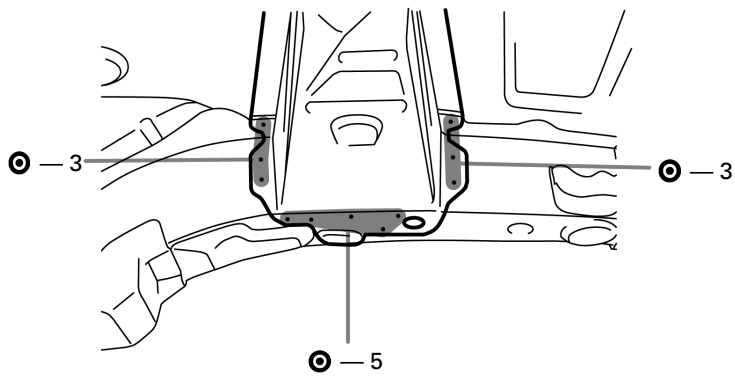
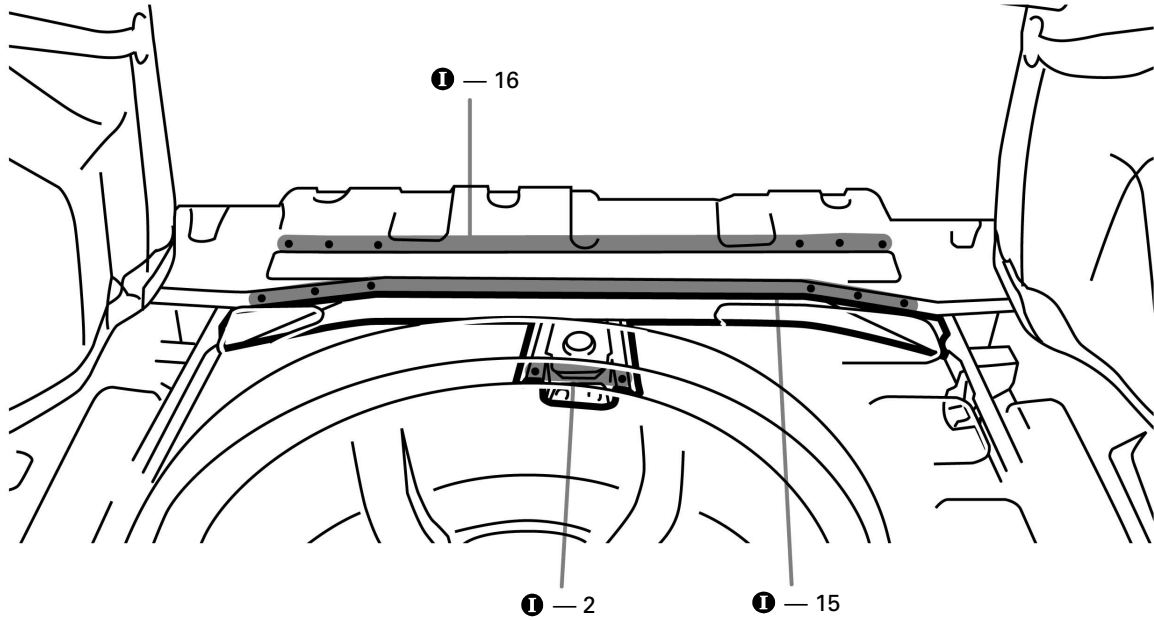


1. When temporarily installing the new parts, determine the installation position by the assembly mark. Then, measure each part in accordance with the body dimension diagram.
2. Weld the rear floor side member plate to the rear floor side rear member.

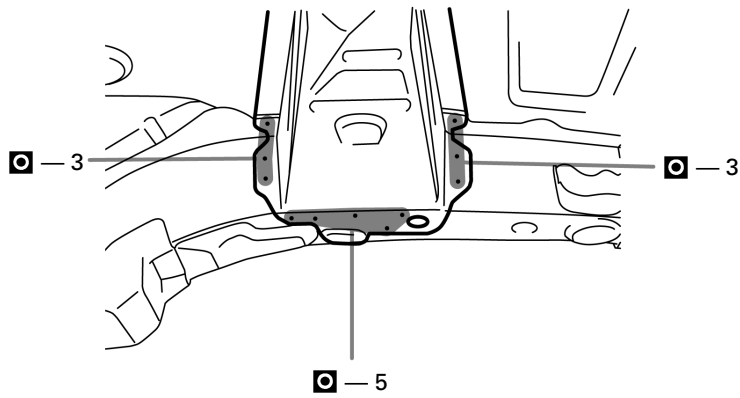
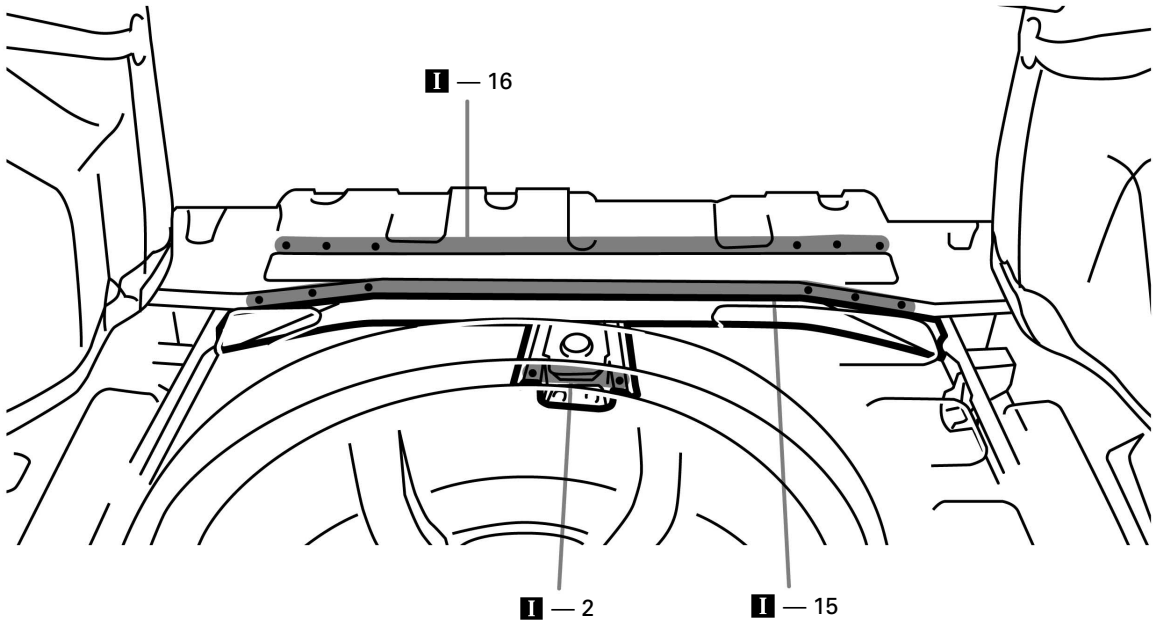
REAR FLOOR No.2 CROSSMEMBER (ASSY)



REMOVAL

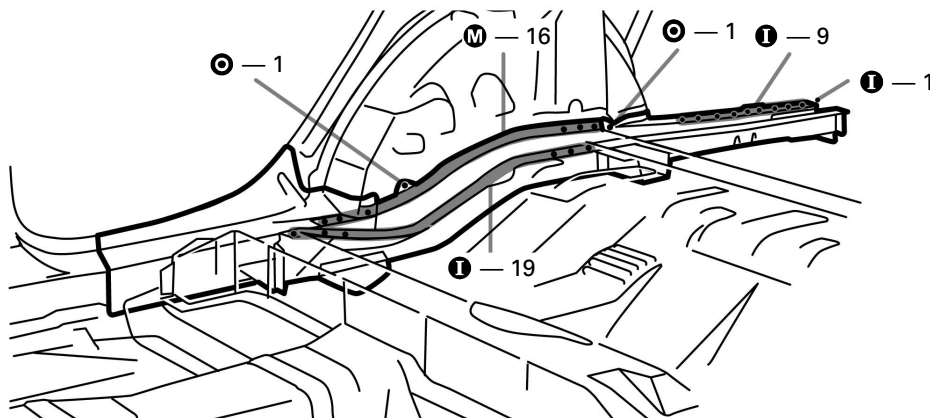
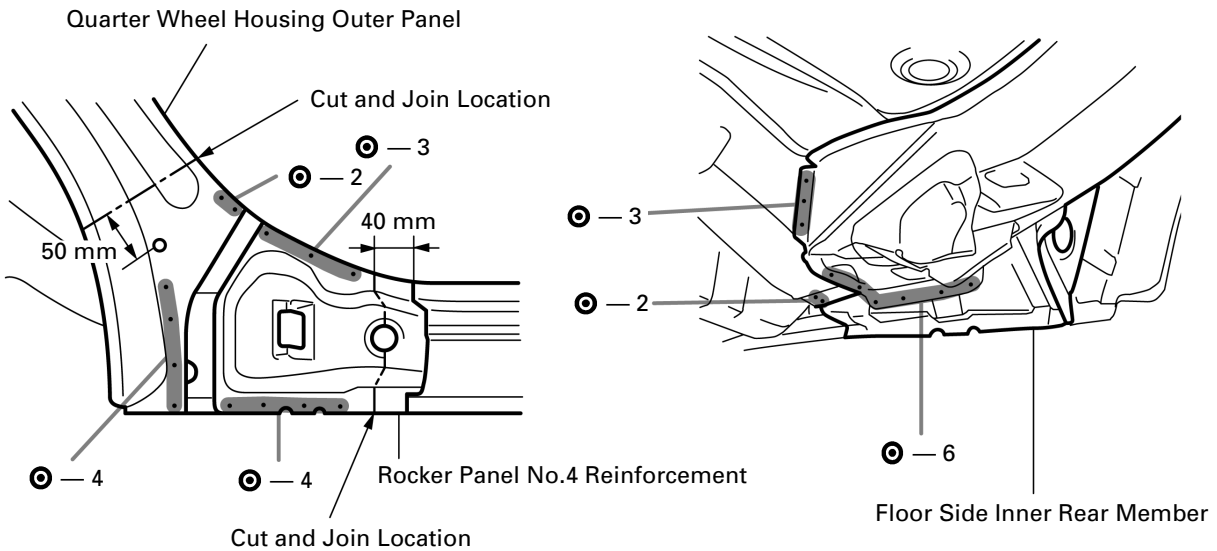
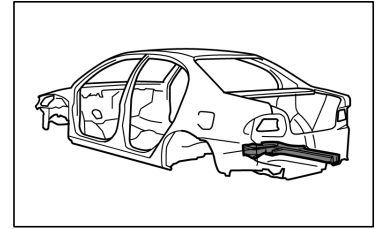


INSTALLATION



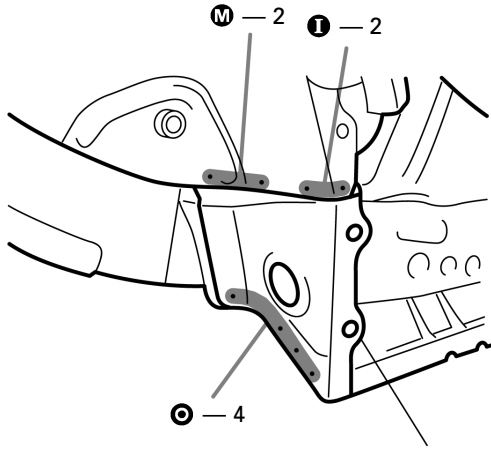
REAR FLOOR SIDE MEMBER (ASSY)

REMOVAL (With the quarter panel, rear floor pan and rear floor No.2 crossmember removed.)

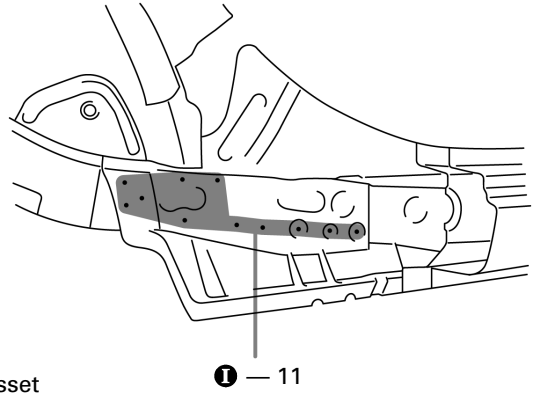


mm	in.
40	1.57
50	1.97

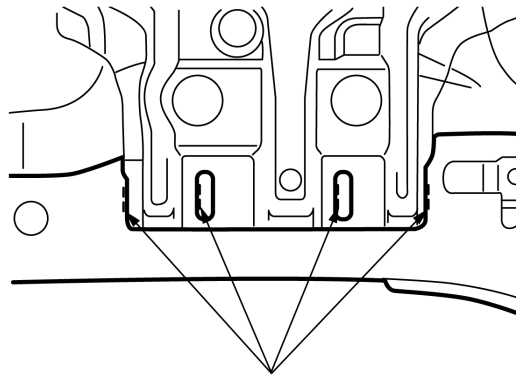
1. Splice the rocker panel No.4 reinforcement rear and the quarter wheel housing outer panel at the locations illustrated above, and remove the quarter wheel housing front gusset.
2. Leave the floor side inner rear member to the vehicle side and remove the rear floor side member.



Quarter Wheel House Front Gusset

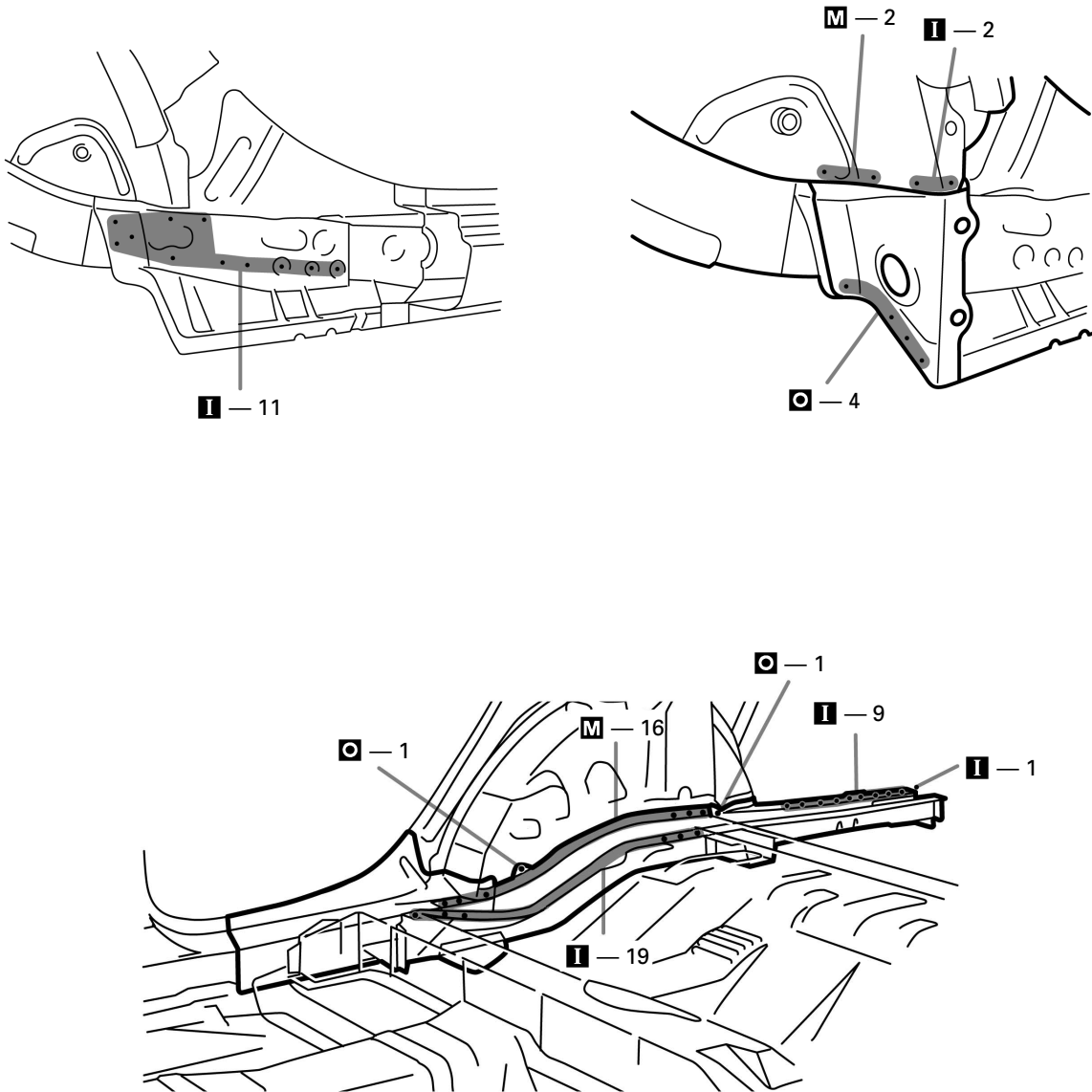


[Liftback, Wagon]

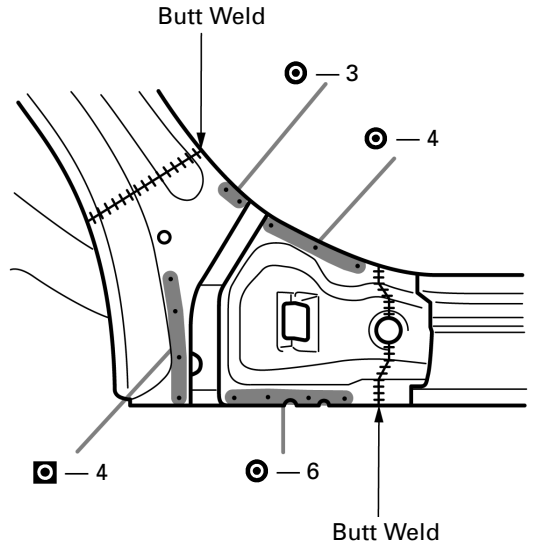
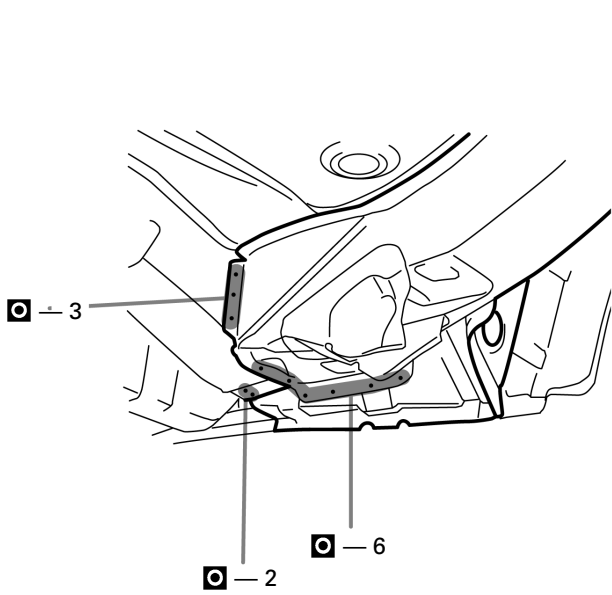


Cut with disc sander, etc.

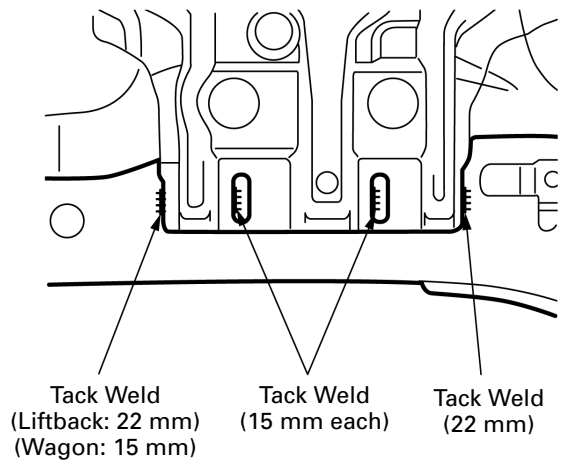
INSTALLATION



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



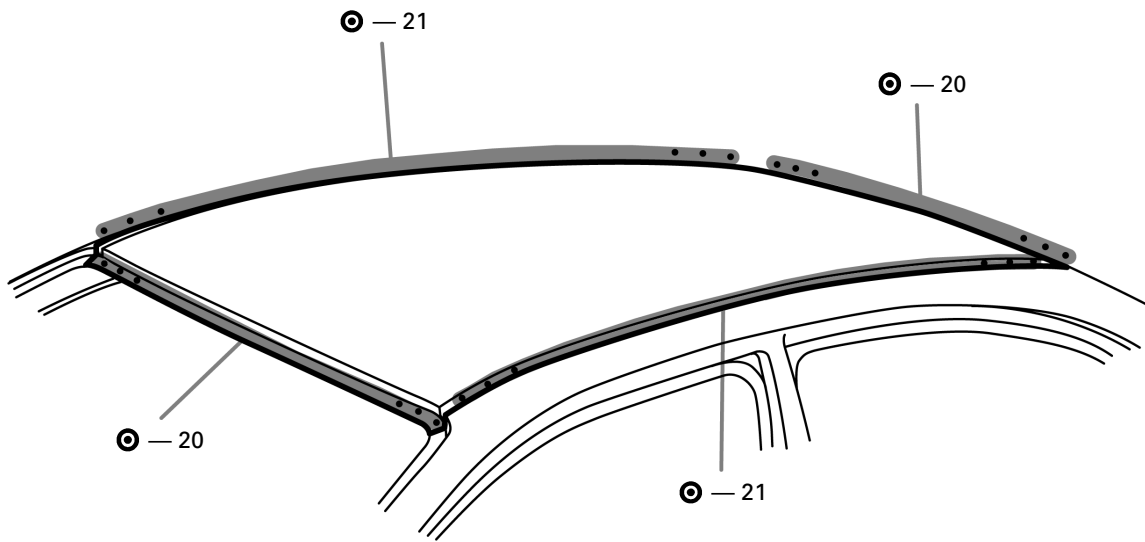
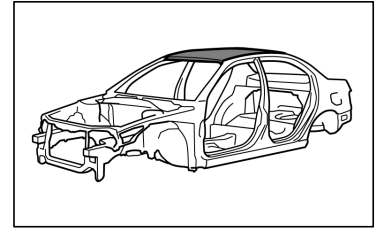
[Liftback, Wagon]



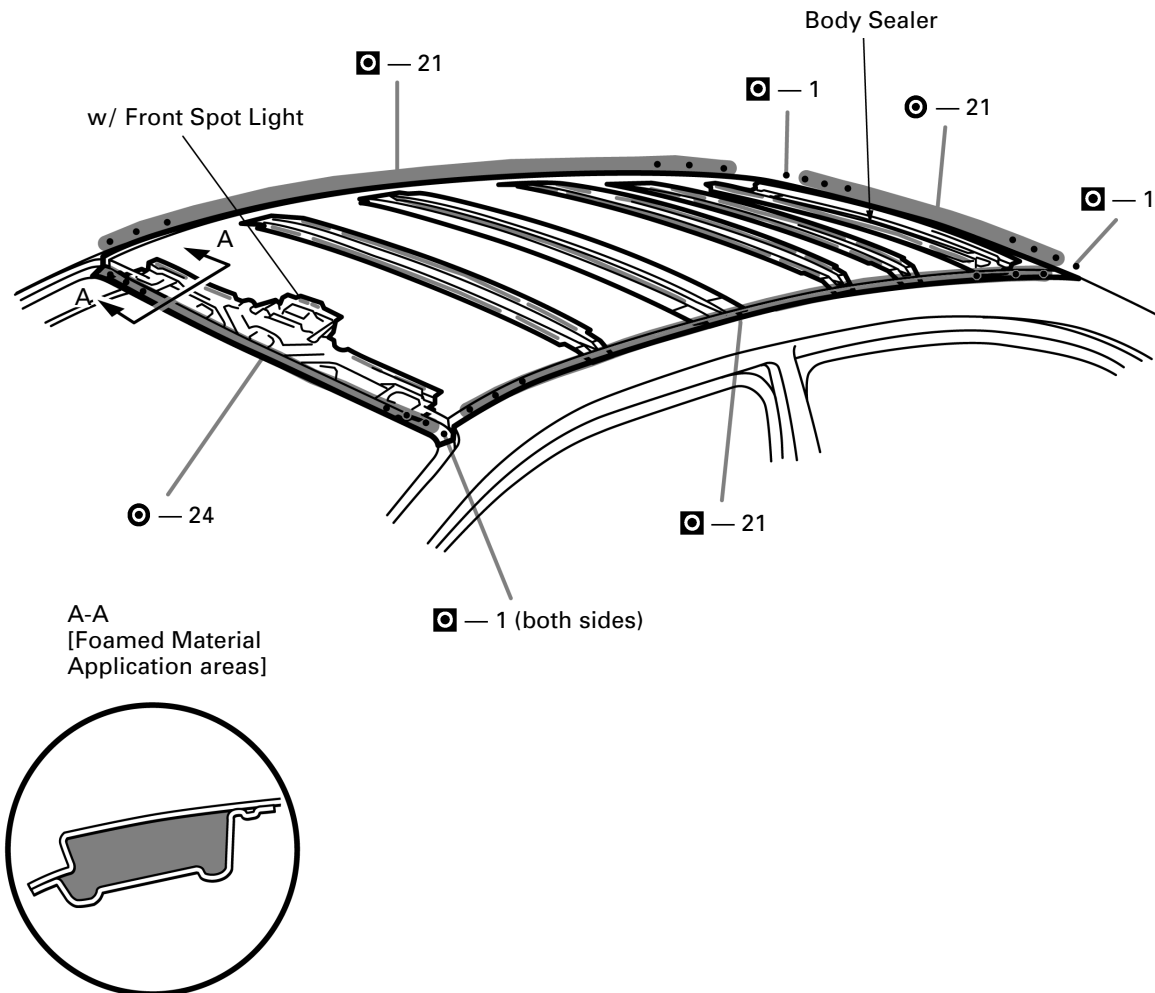
mm	in.
15	0.59
22	0.87

ROOF PANEL (ASSY): Sedan w/o Sun Roof

REMOVAL



INSTALLATION

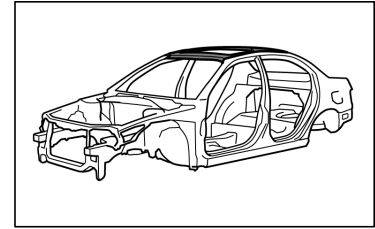


1. Before temporarily installing the new parts, apply body sealer to the windshield header panel, roof panel reinforcement and back window upper frame.
2. Apply foamed material to the windshield header panel.

HINT:

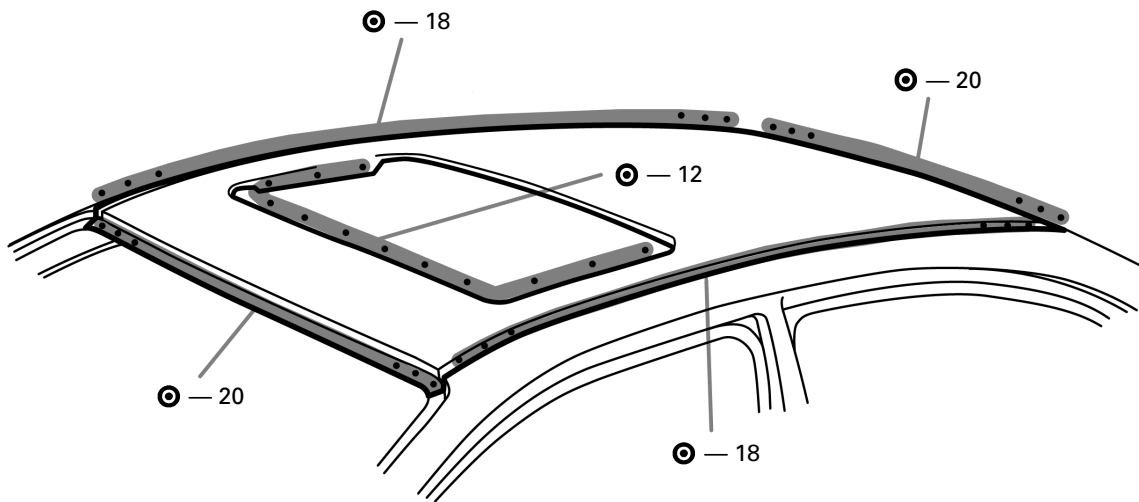
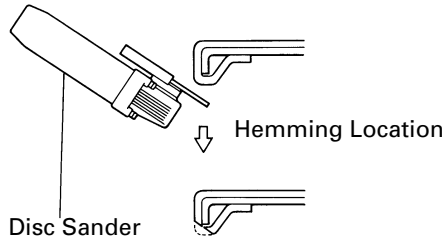
- 1) Apply just enough sealer for the new parts to make contact.
- 2) For other sealing points, refer to section AR.

ROOF PANEL (ASSY): Sedan w/ Sun Roof

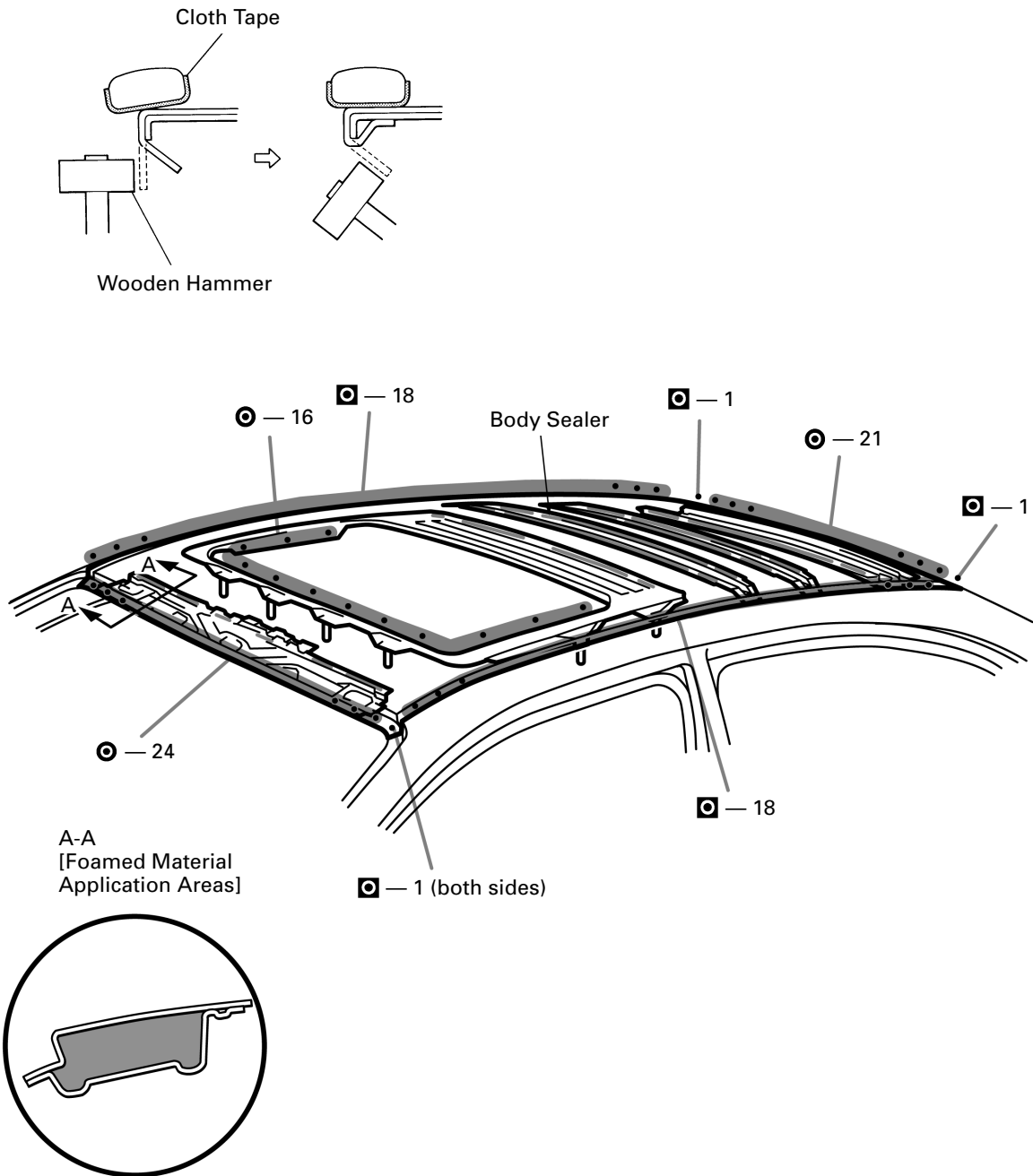


REMOVAL

[If reusing the roof panel reinforcement]



INSTALLATION



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

HINT:

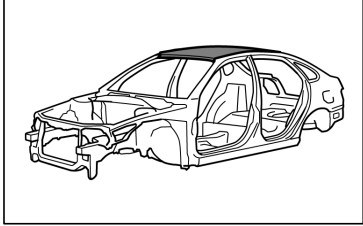
- 1) Apply just enough sealer for the new parts to make contact.
- 2) For other sealing points, refer to section AR.

2. Bend the flange hem with a wooden hammer and dolly.

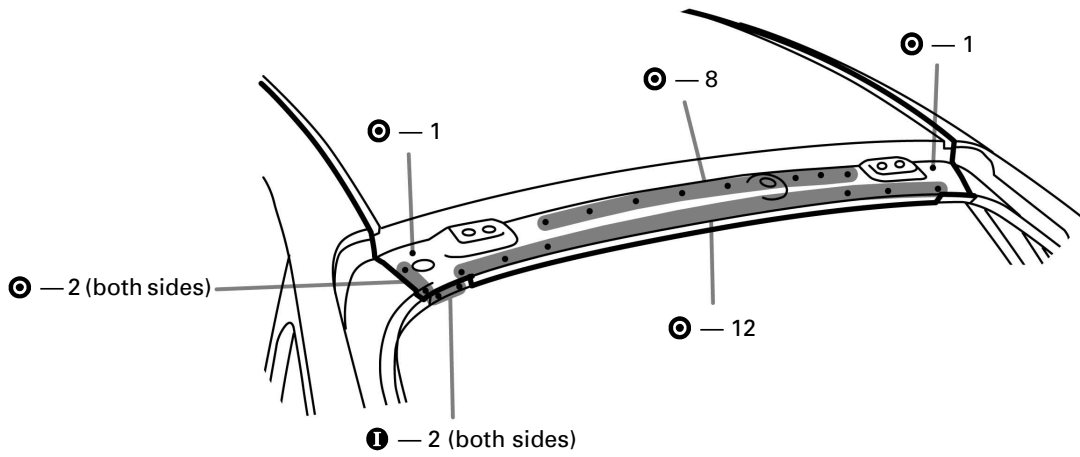
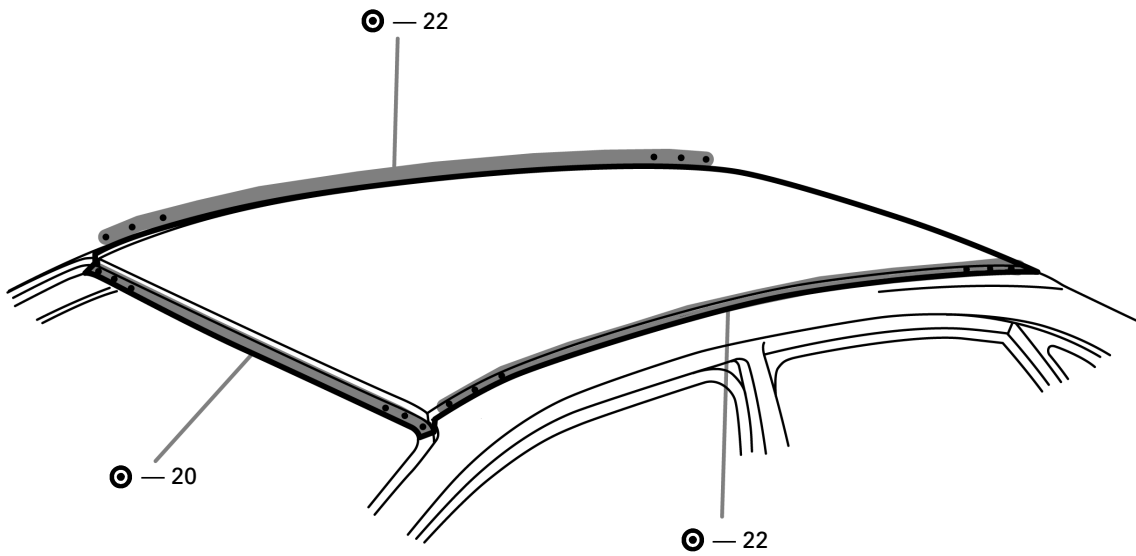
HINT: Perform hemming three steps, being careful not to warp the panel.

3. Apply foamed material to the windshield header panel.

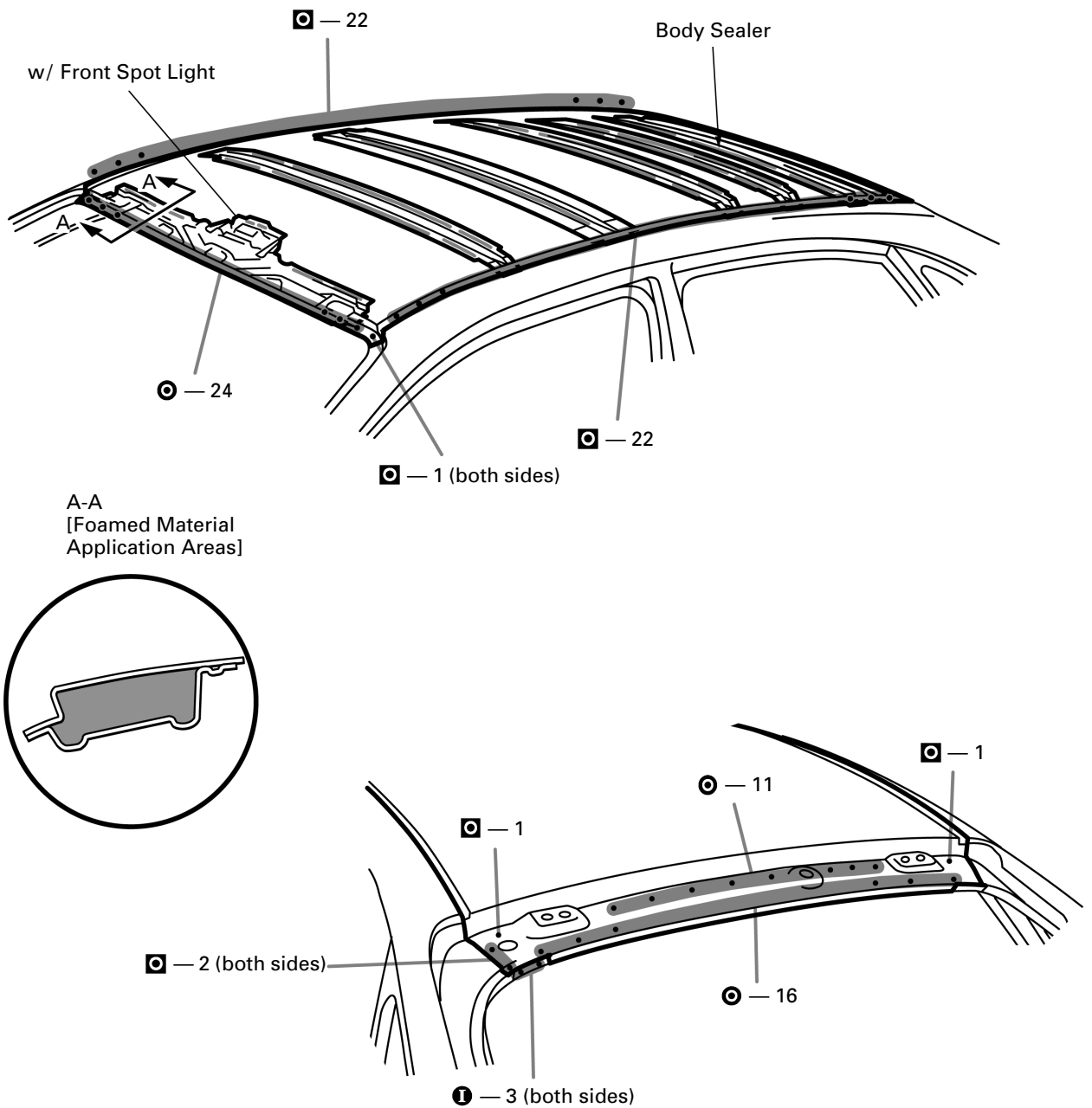
ROOF PANEL (ASSY): Liftback w/o Sun Roof



REMOVAL



INSTALLATION



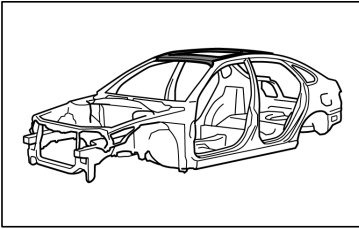
1. Before temporarily installing the new parts, apply body sealer to the windshield header panel, roof panel reinforcement and back door opening frame.

2. Apply foamed material to the windshield header panel.

HINT:

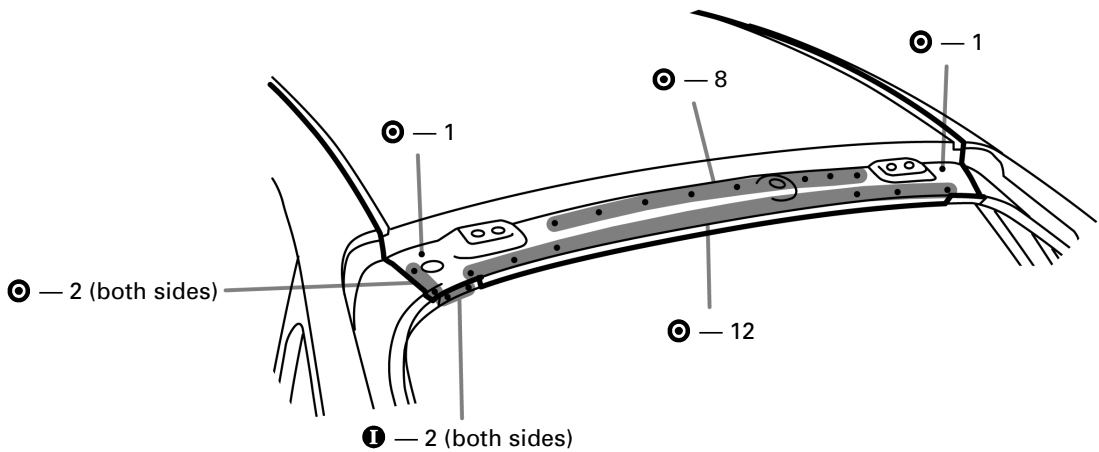
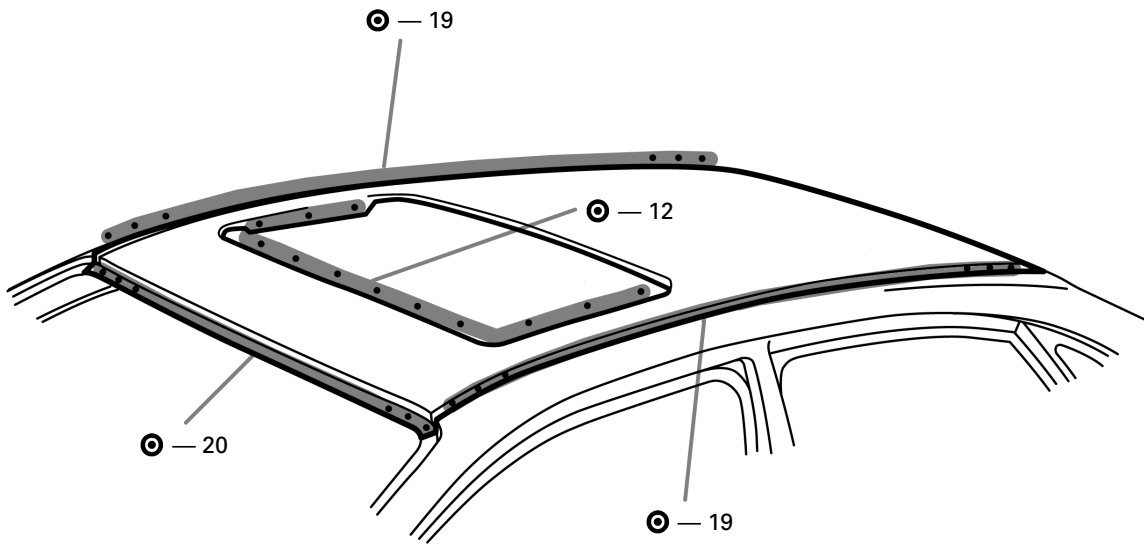
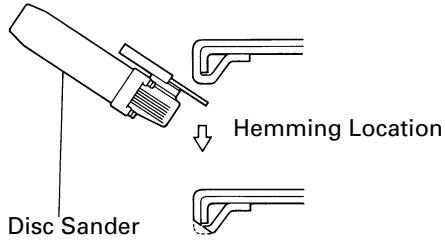
- 1) Apply just enough sealer for the new parts to make contact.
- 2) For other sealing points, refer to section AR.

ROOF PANEL (ASSY): Liftback w/ Sun Roof

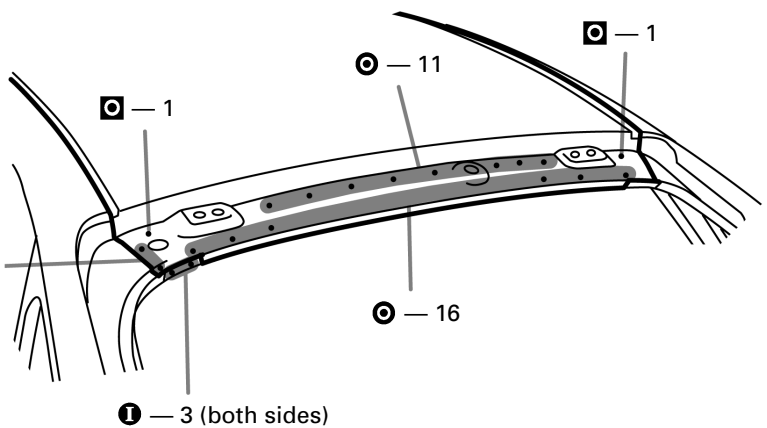
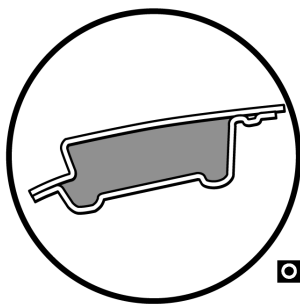
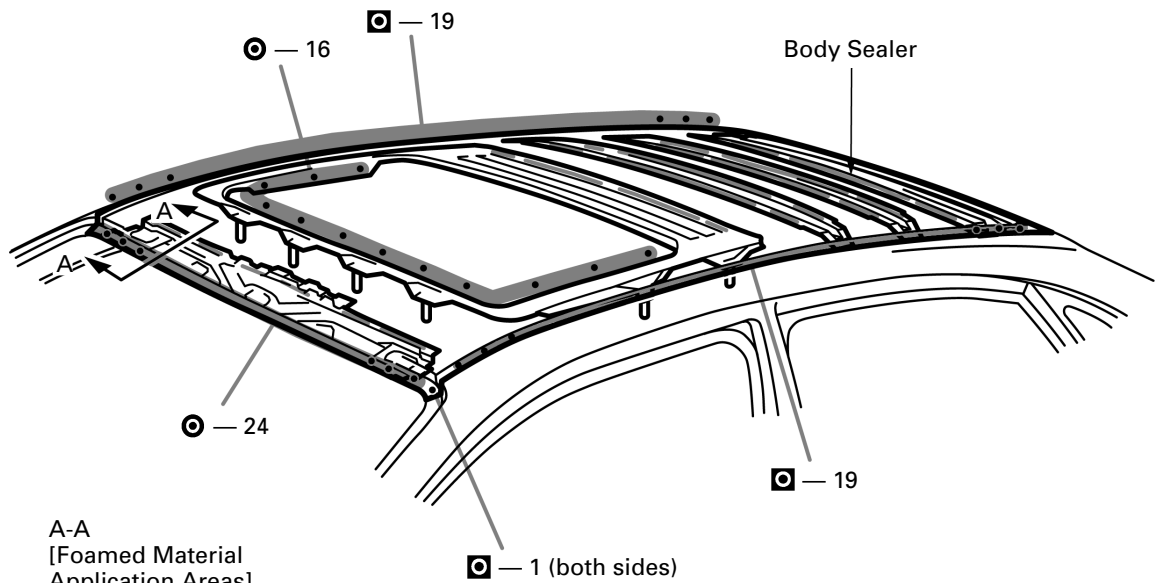
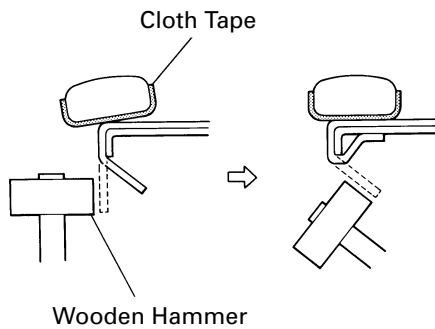


REMOVAL

[If reusing the roof panel reinforcement]



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:

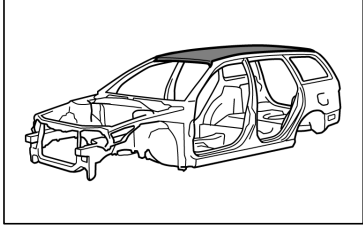
- 1) Apply just enough sealer for the new parts to make contact.
- 2) For other sealing points, refer to section AR.

2. Bend the flange hem with a wooden hammer and dolly.

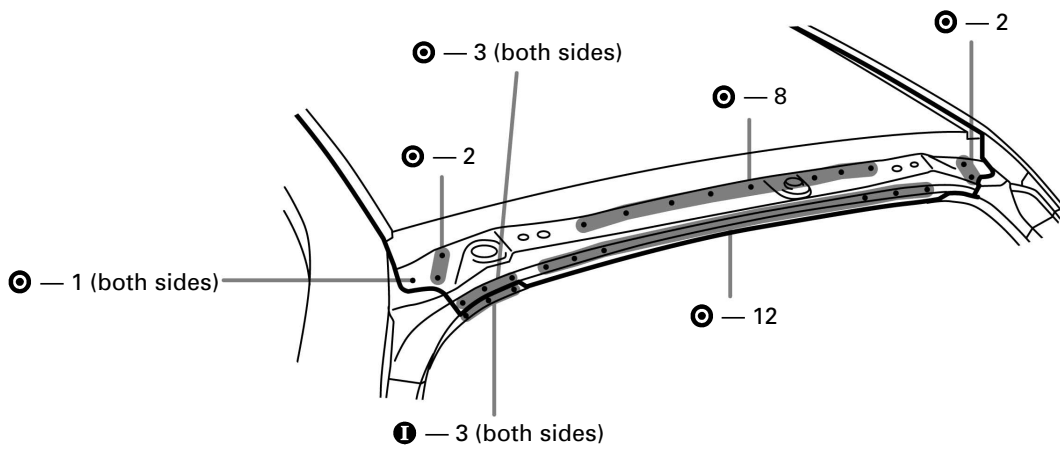
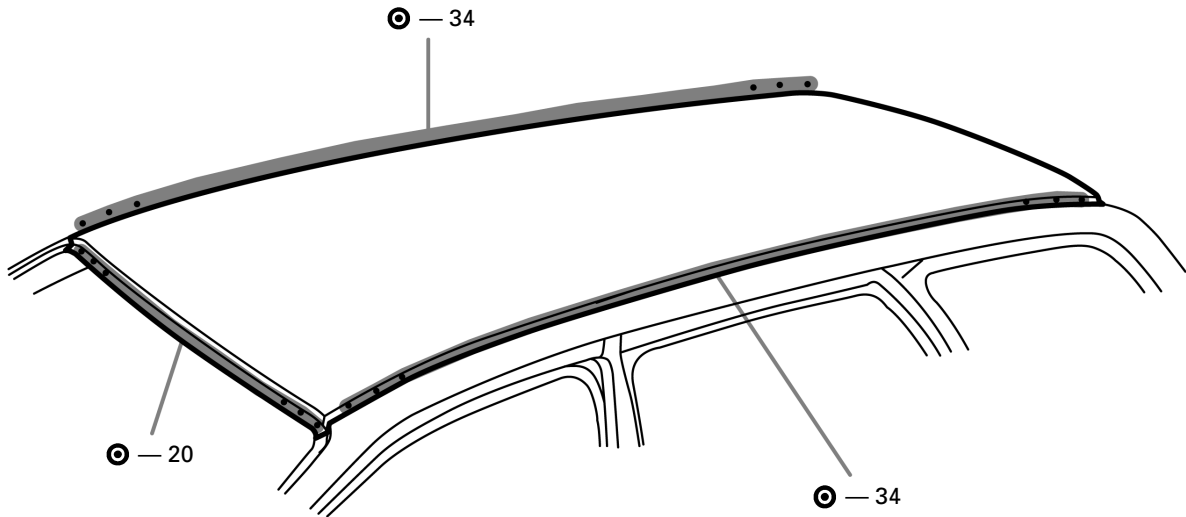
HINT: Perform hemming three steps, being careful not to warp the panel.

3. Apply foamed material to the windshield header panel.

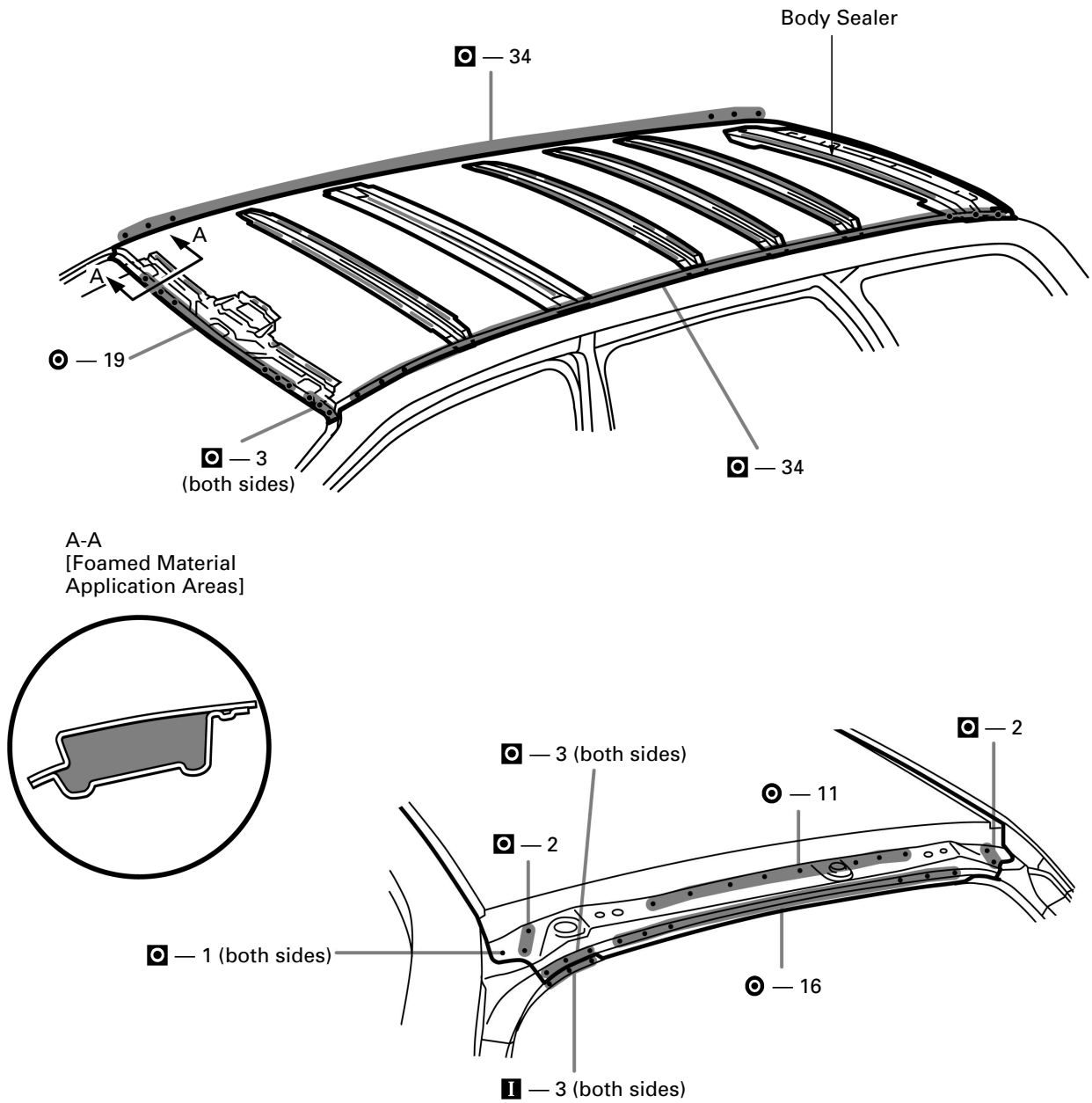
ROOF PANEL (ASSY): Wagon w/o Sun Roof



REMOVAL



INSTALLATION



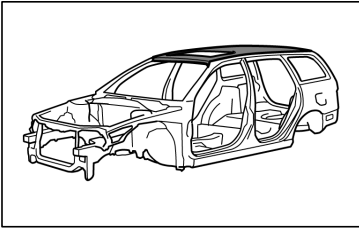
A-A
[Foamed Material
Application Areas]

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

HINT:

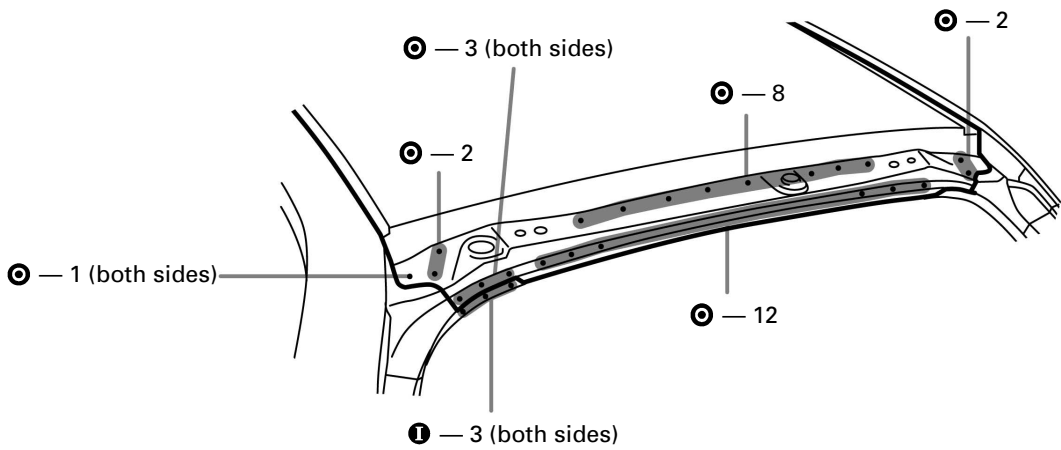
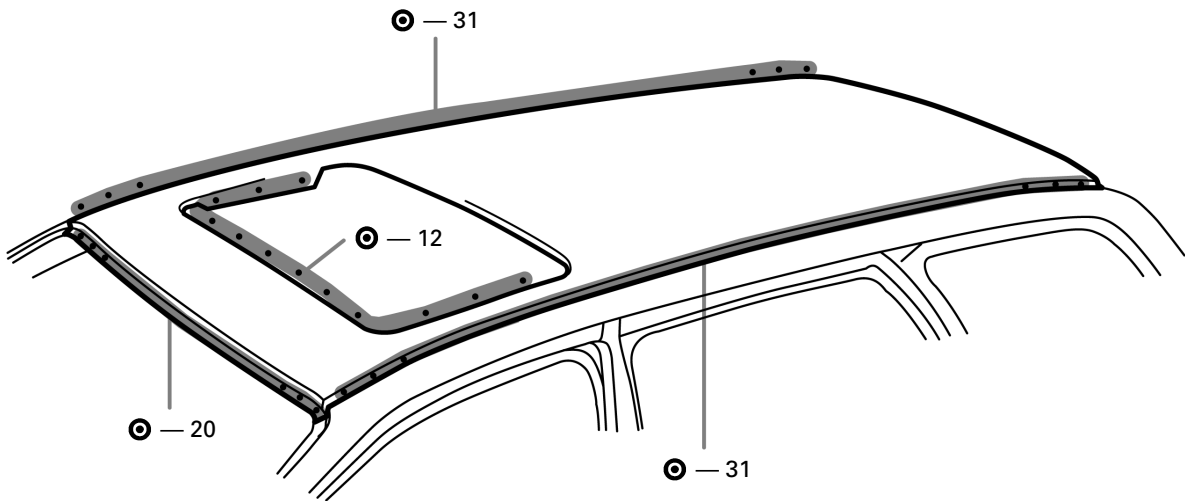
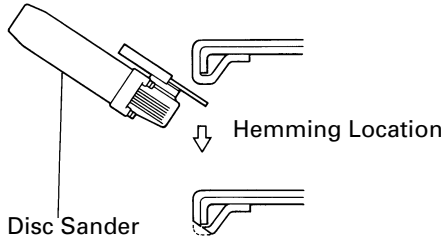
- 1) Apply just enough sealer for the new parts to make contact.
- 2) For other sealing points, refer to section AR.

ROOF PANEL (ASSY): Wagon w/ Sun Roof

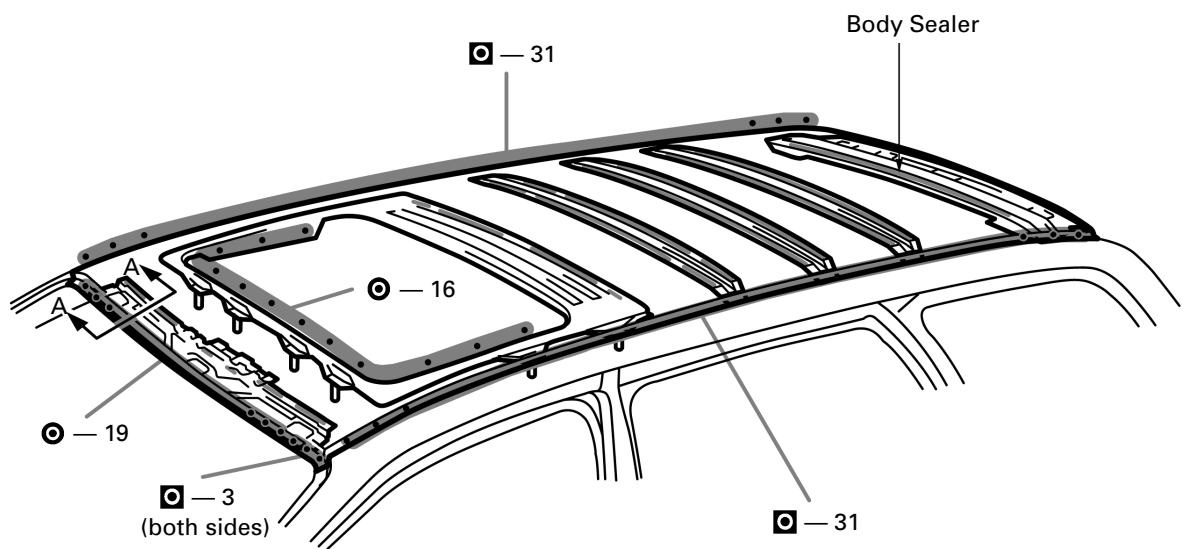
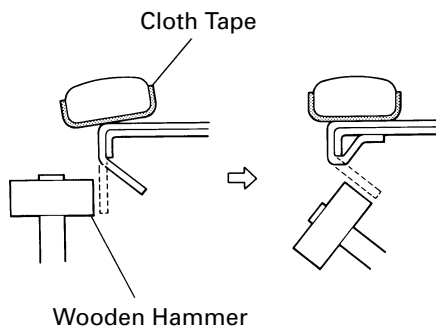


REMOVAL

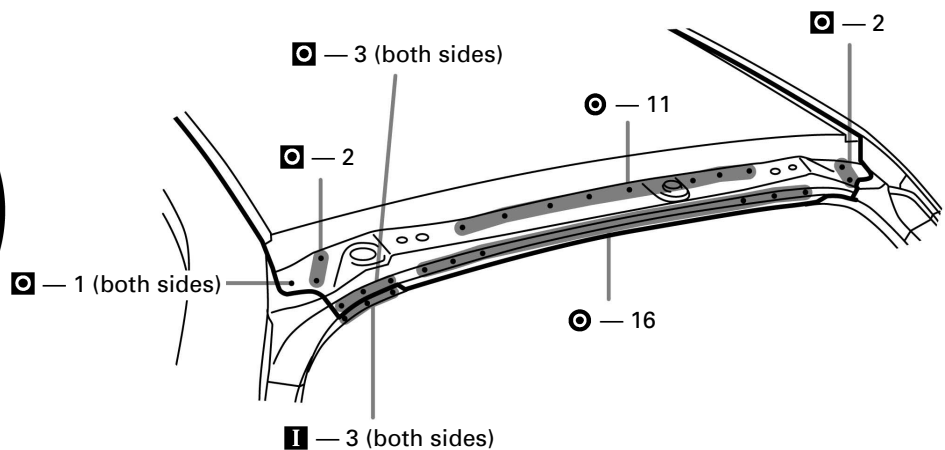
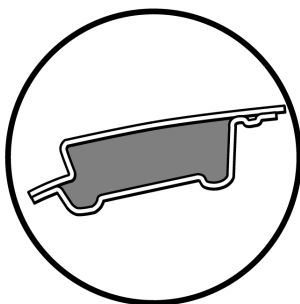
[If reusing the roof panel reinforcement]



INSTALLATION



A-A
[Foamed Material
Application Areas]



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. Bend the flange hem with a wooden hammer and dolly.

HINT: Perform hemming three steps, being careful not to warp the panel.

3. Apply foamed material to the windshield header panel.

- MEMO -
