HOW TO USE THIS MANUAL

1. BODY PANEL REPLACEMENT IN THIS MANUAL

BODY PANEL REPLACEMENT BP-34

Ⓐ **QUARTER PANEL (CUT)**

Ⓑ 

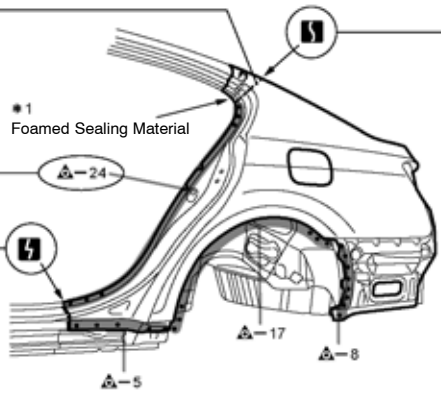
With the body lower back panel removed. Ⓒ

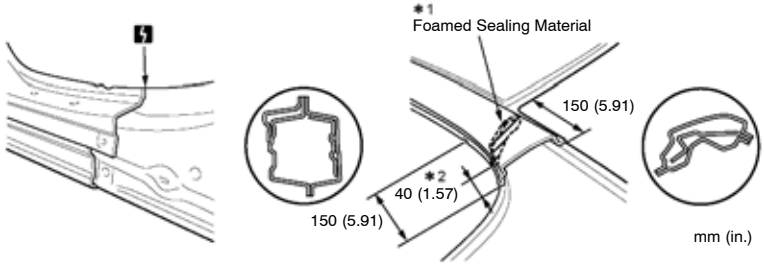
Symbol meaning Ⓓ

▲1 ▲2 ▲3 : Remove Weld Points ▲4 : Cut and Join Location

▲5 : Cut Location for Supply Parts

REMOVAL

Ⓗ 



REMOVAL POINT

Ⓕ 1 Remove the fuel filler opening lid at the same time.

Ⓐ REPLACEMENT PARTS
QUARTER PANEL (CUT)
- Replacement method
  (ASSY)...Assembly replacement
  (CUT)...Major cutting (less than 1/2 of part used)
  (CUT-H)...Half cutting (about 1/2 of part used)
  (CUT-P)...Partial cutting (most of part used)
- Replacement part

Ⓑ PART LOCATION

Ⓒ REMOVAL AND INSTALLATION CONDITIONS

Ⓓ SYMBOL MEANING

Ⓔ REMOVAL DIAGRAM

Ⓕ REMOVAL GUIDE

Ⓖ WELDING EXPLANATION (See page IN-36)

Ⓗ SYMBOLS (See page IN-34)

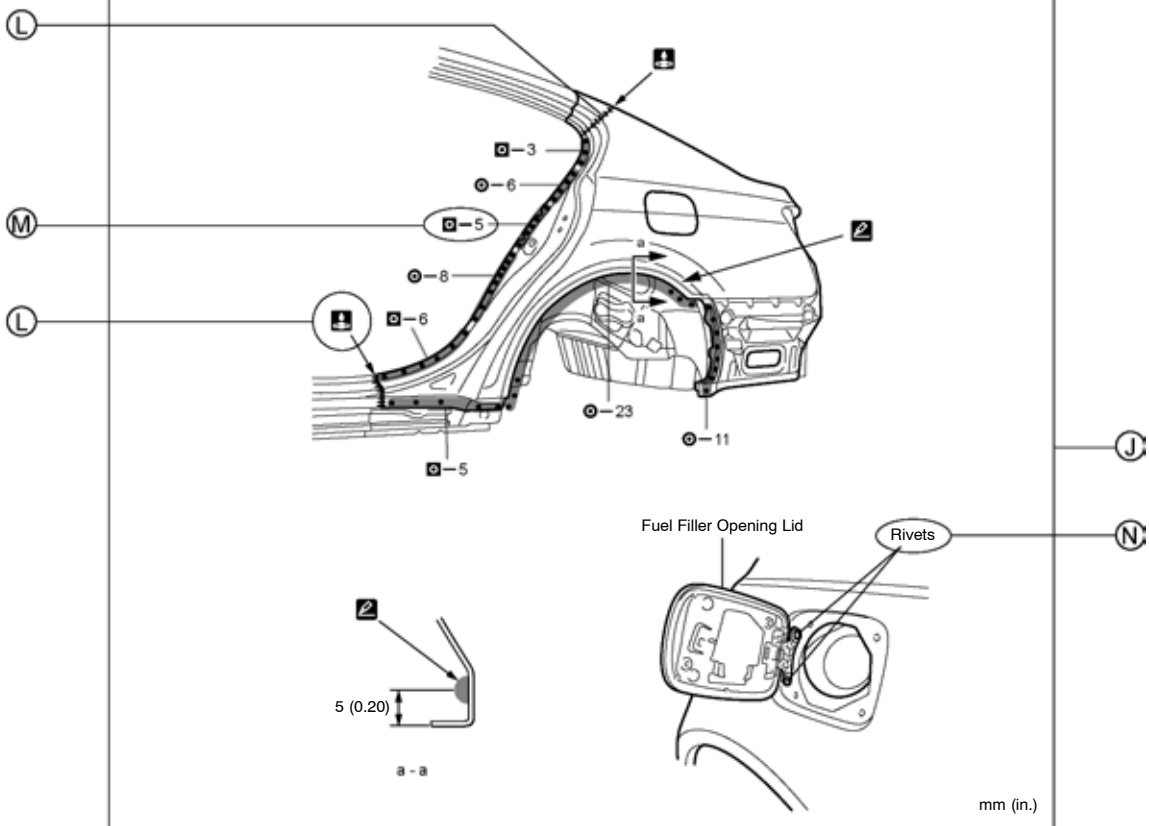
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BP-36 BODY PANEL REPLACEMENT

Symbol meaning

: Spot Weld : Plug Weld : Butt Weld : Body Sealer

INSTALLATION



INSTALLATION POINT

1 Inspect the fitting of the related parts around the new parts before welding.
This affects the appearance of the finish.

2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)

3 Before temporarily installing the new parts, apply body sealer to the wheel arch.
HINT:
- *Apply body sealer evenly about 5 mm (0.20 in.) from the flange, avoiding any oozing.*
- *Apply body sealer evenly, about 3 – 4 mm (0.12 – 0.16 in.) in diameter.*

Ⓘ SYMBOL MEANING

Ⓙ INSTALLATION DIAGRAM

Ⓚ INSTALLATION GUIDE

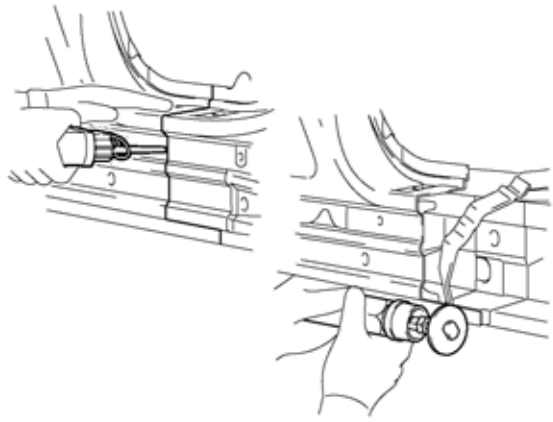
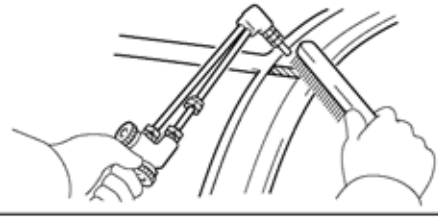
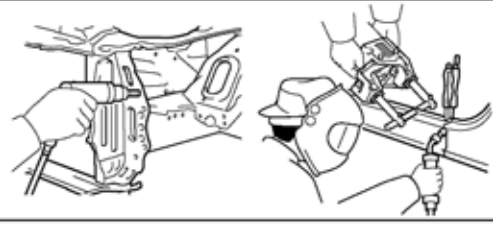
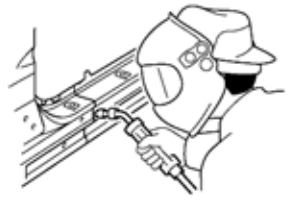
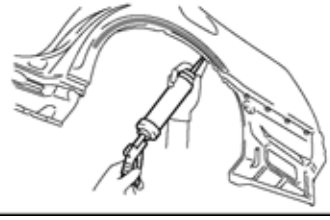
Ⓛ SYMBOLS (See page IN-34)

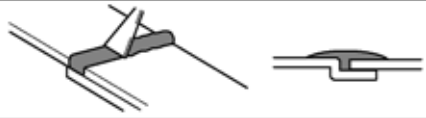
Ⓜ WELDING EXPLANATION (See page IN-36)

Ⓝ PART NAME

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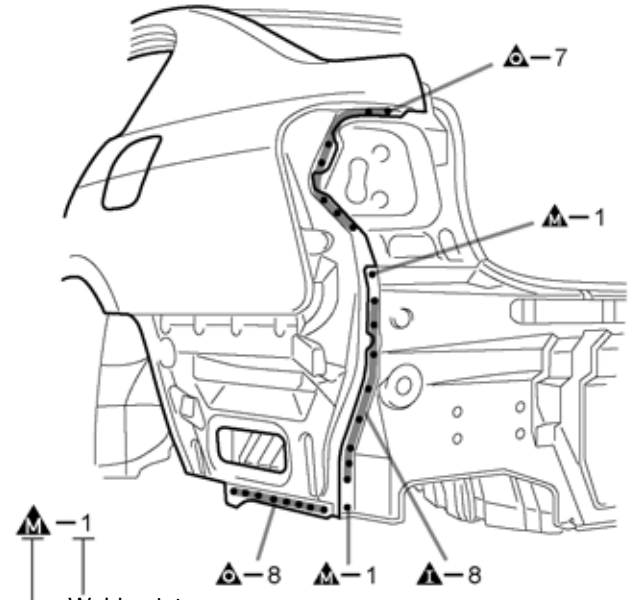
2. SYMBOLS

REPAIR AREA INDICATOR SYMBOLS		REPAIR METHOD INDICATOR SYMBOLS		ILLUSTRATION
	CUT		CUT AND JOIN LOCATION (SAW CUT)	
			CUT AND JOIN LOCATION (Cut Location for Supply Parts)	
			CUT LOCATION	
			CUT WITH DISC SANDER ETC.	
	BRAZE		BRAZING OR ARC BRAZING FOR REMOVAL	
	BRAZE		BRAZE	
	WELD POINTS	—	SPOT WELD OR PLUG WELD (refer to “ILLUSTRATION OF WELD POINT SYMBOLS”)	
	WELDING		BUTT WELD	
			FILLET WELD	
	BODY SEALER		BODY SEALER	 F31237

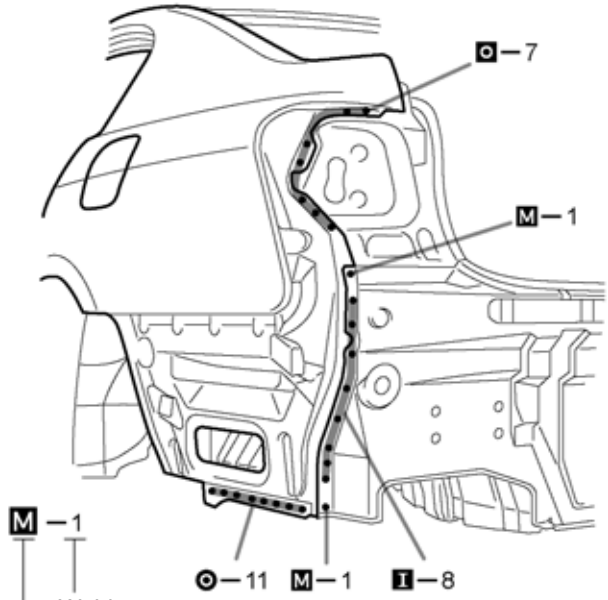
REPAIR AREA INDICATOR SYMBOLS		REPAIR METHOD INDICATOR SYMBOLS		ILLUSTRATION
—	ASSEMBLY MARK	⊕	STANDARD HOLE FOR INSTALLATION	—
++++++++++	BODY SEALER	—	FLAT FINISHING	
———			NO FLAT FINISHING	 F31238

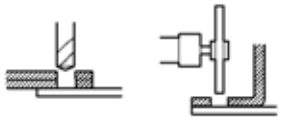
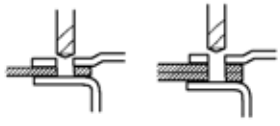
3. ILLUSTRATION OF WELD POINT SYMBOLS

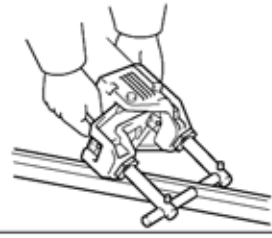
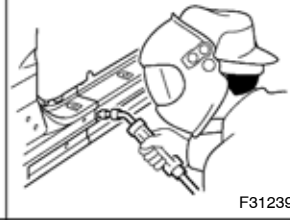
REMOVAL



INSTALLATION



SYMBOLS	MEANING	ILLUSTRATION
▲	Remove Weld Points	
O	Position of Panel Being Replaced is on Outside	
M	Position of Panel Being Replaced is in Center	
I	Position of Panel Being Replaced is on Inside	

SYMBOLS	MEANING	ILLUSTRATION
●	Spot Welding	
■	Plug Welding	
+	Spot MIG Welding	

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