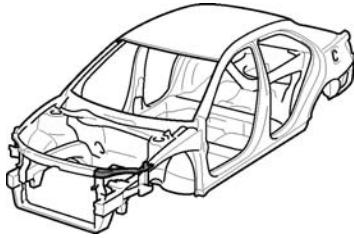


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# BODY PANEL REPLACEMENT

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## RADIATOR UPPER SUPPORT (ASSY)



F25701A

### Symbol meaning

REMOVAL

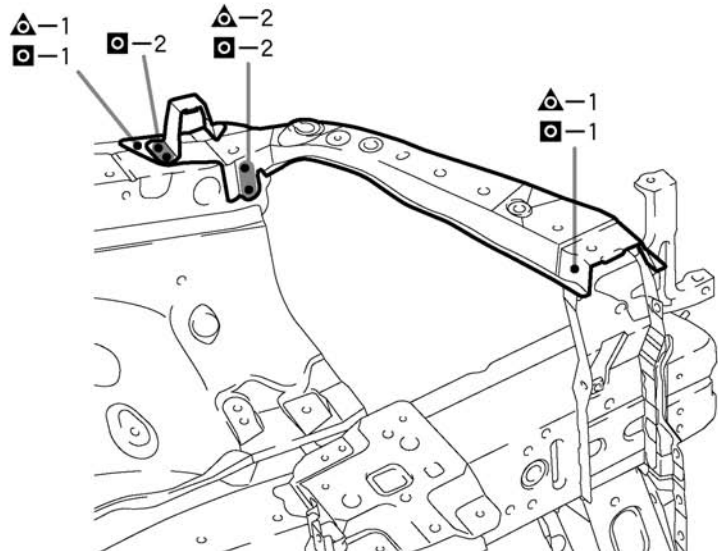
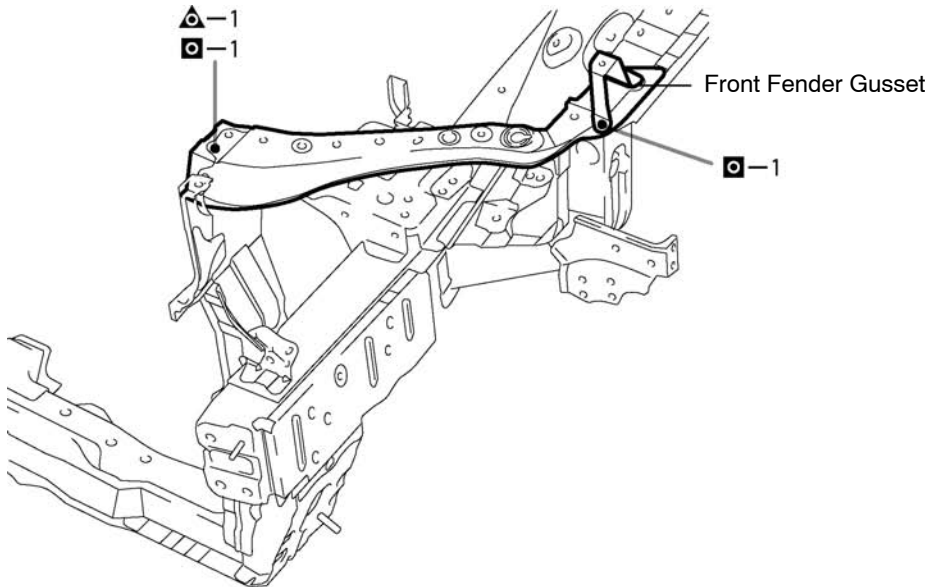
△ : Remove Weld Points

INSTALLATION

◻ : MIG Plug Weld

F25701B

### REMOVAL-INSTALLATION

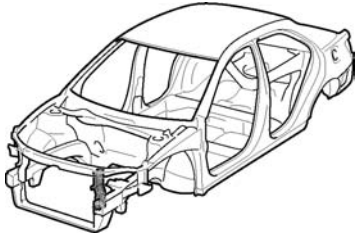


F25701

### 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 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

# RADIATOR SUPPORT UPPER BRACE (ASSY)



F25702A

With the radiator upper support removed.

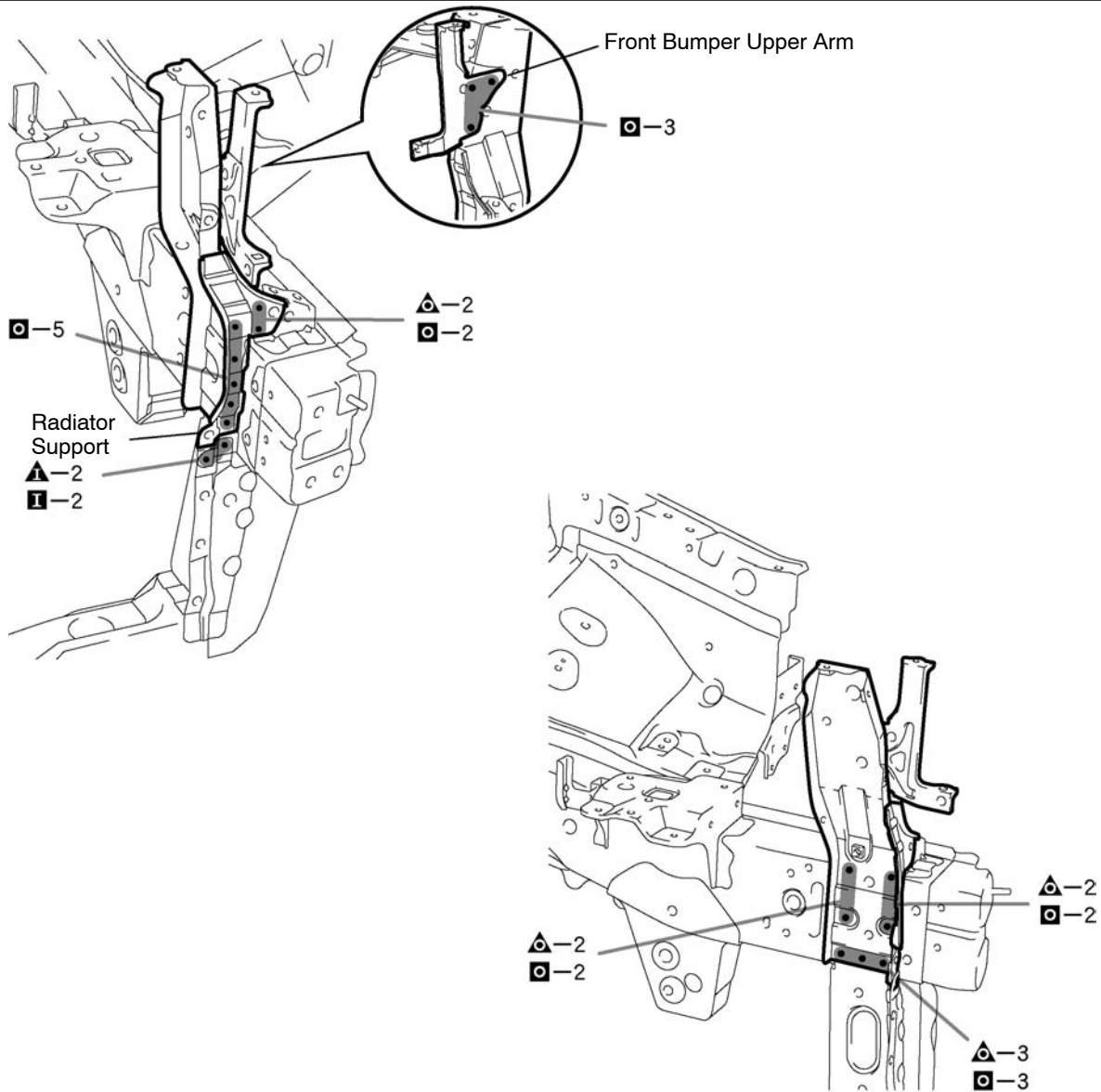
## Symbol meaning

REMOVAL        : Remove Weld Points

INSTALLATION        : MIG Plug Weld

F25702B

## REMOVAL-INSTALLATION



F25702

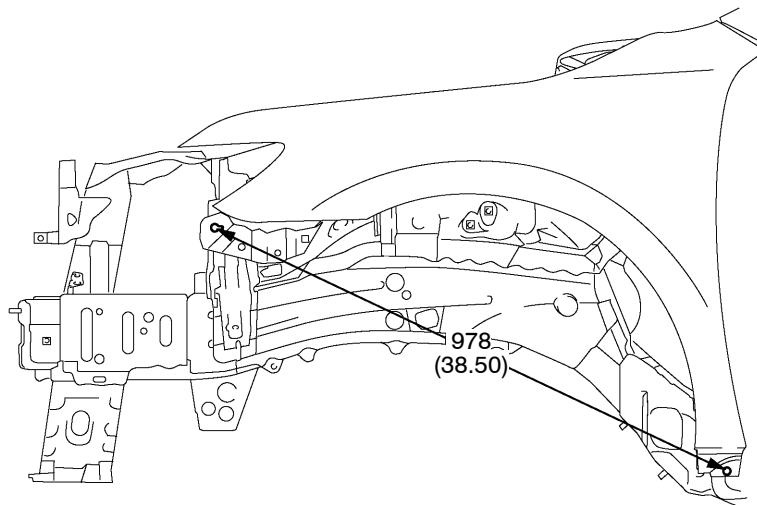
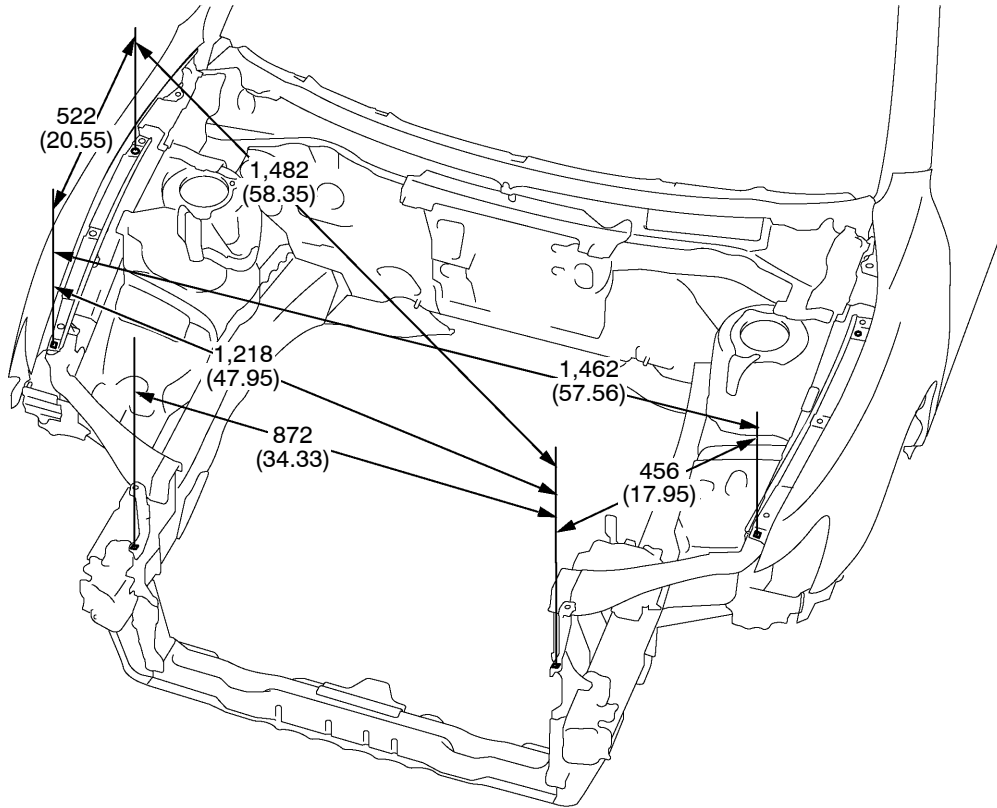
### REMOVAL POINT

- 1 Remove the radiator upper support at the same time.

### 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 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

[for 2AZ-FE]



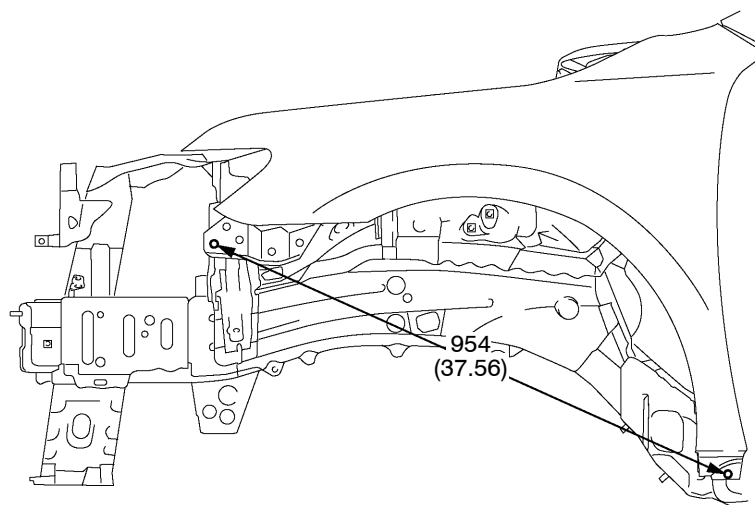
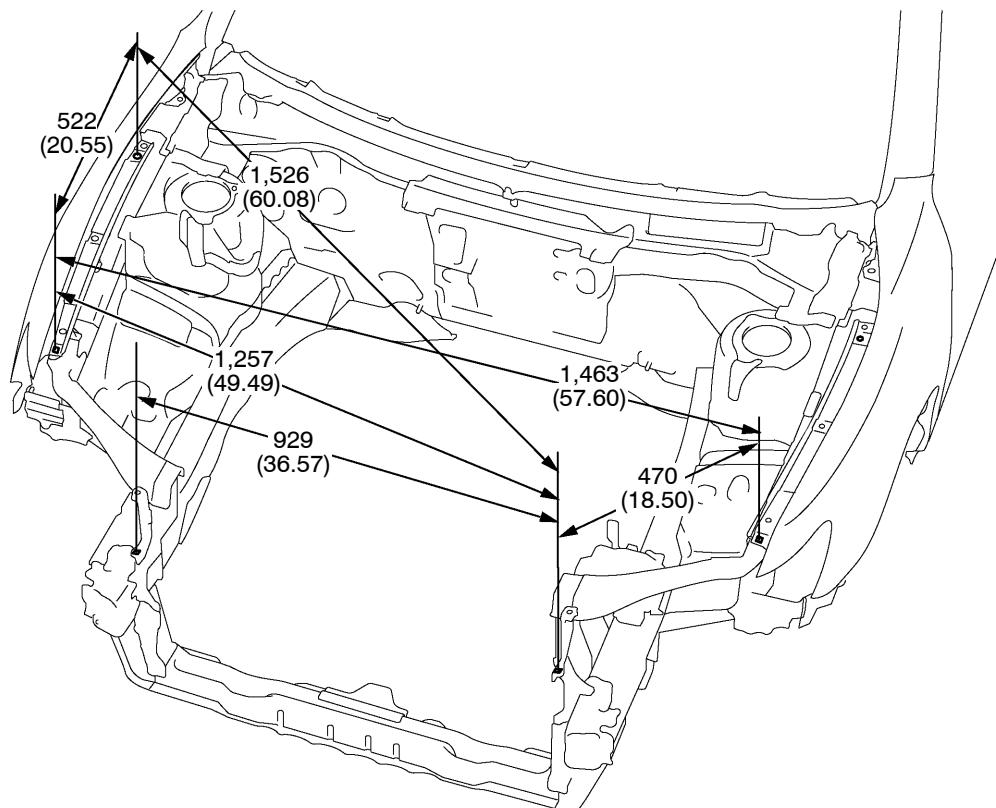
mm (in.)

F25704

# INSTALLATION POINT

- 1 Measure the dimensions before installing the headlights.
- 2 These values are reference values.

[for 2GR-FE]



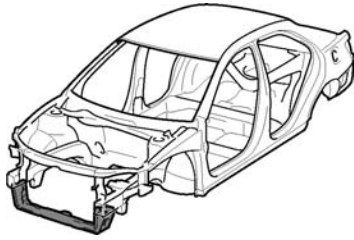
mm (in.)

F26101

**INSTALLATION POINT**

- 1 Measure the dimensions before installing the headlights.
- 2 These values are reference values.

# FRONT CROSSMEMBER (ASSY)



F25705A

## Symbol meaning

### REMOVAL

△ △ △ : Remove Weld Points

☐ : Cut with disc sander, etc.

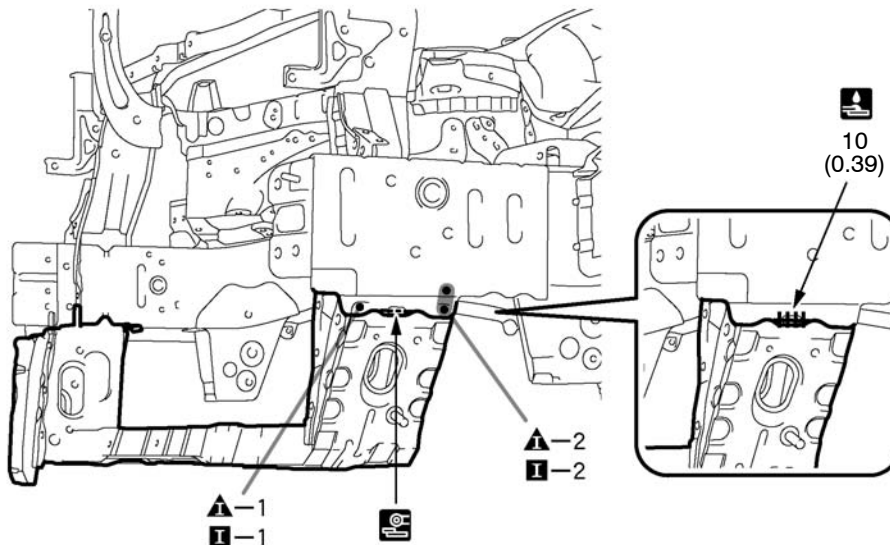
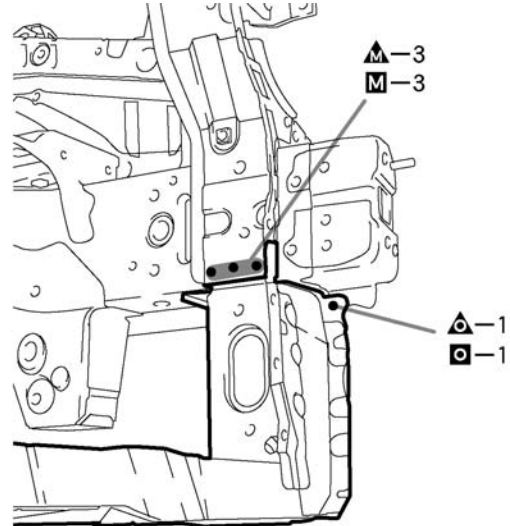
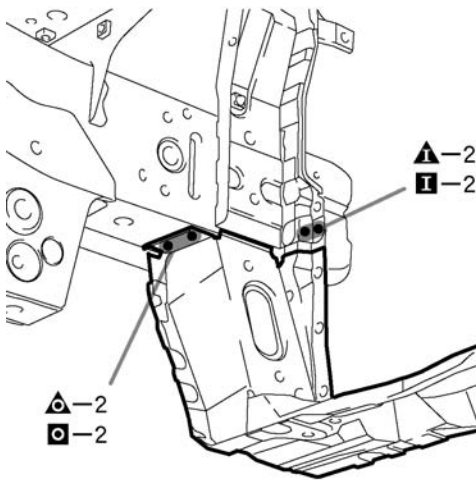
### INSTALLATION

○ M I : MIG Plug Weld

☐ : Tack Weld

F25705B

## REMOVAL-INSTALLATION



mm (in.)

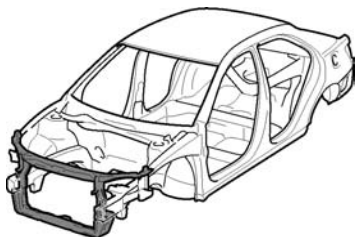
F25705

## 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 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.



# RADIATOR SUPPORT (ASSY)



F25706A

## Symbol meaning

REMOVAL

△ △ : Remove Weld Points

✂ : Cut with disc sander, etc.

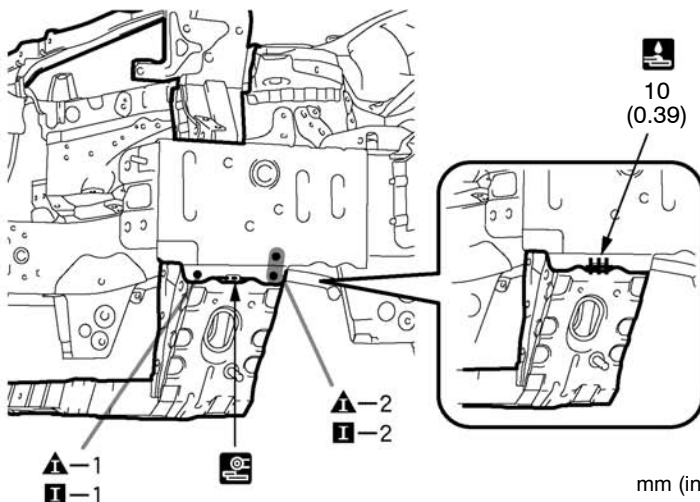
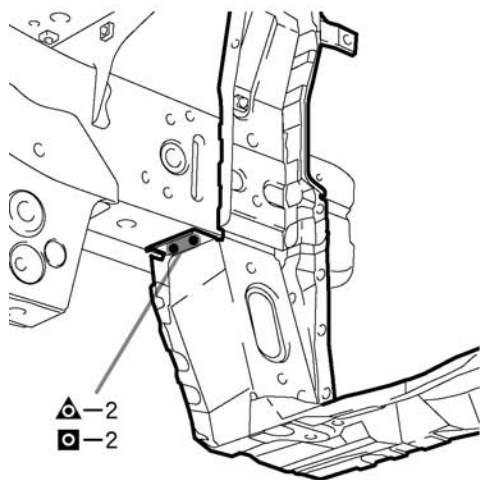
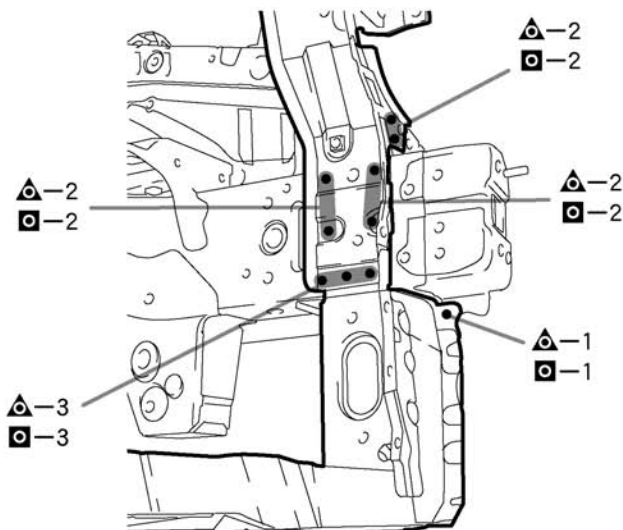
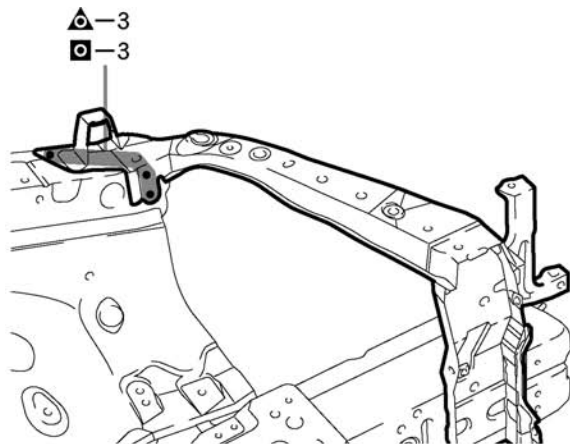
INSTALLATION

□ T : MIG Plug Weld

⚡ : Tack Weld

F25706B

## REMOVAL-INSTALLATION



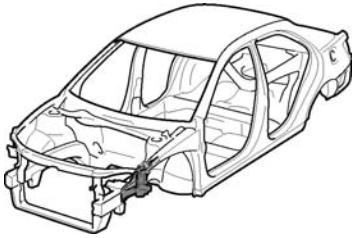
mm (in.)

F25706

## 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 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

## FRONT FENDER FRONT APRON (ASSY)



F25707A

With the radiator support removed.

### Symbol meaning

#### REMOVAL



△ △ △ : Remove Weld Points



○ : Cut with disc sander, etc.

#### INSTALLATION



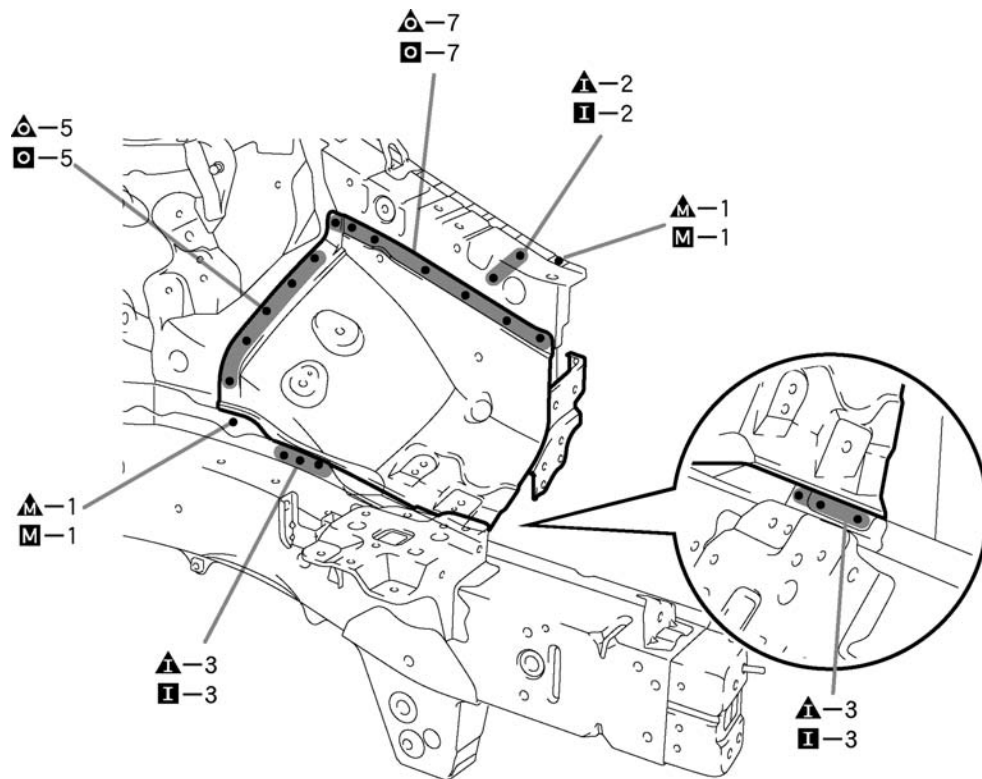
○ M I : MIG Plug Weld



△ : Tack Weld

F25707B

### REMOVAL·INSTALLATION

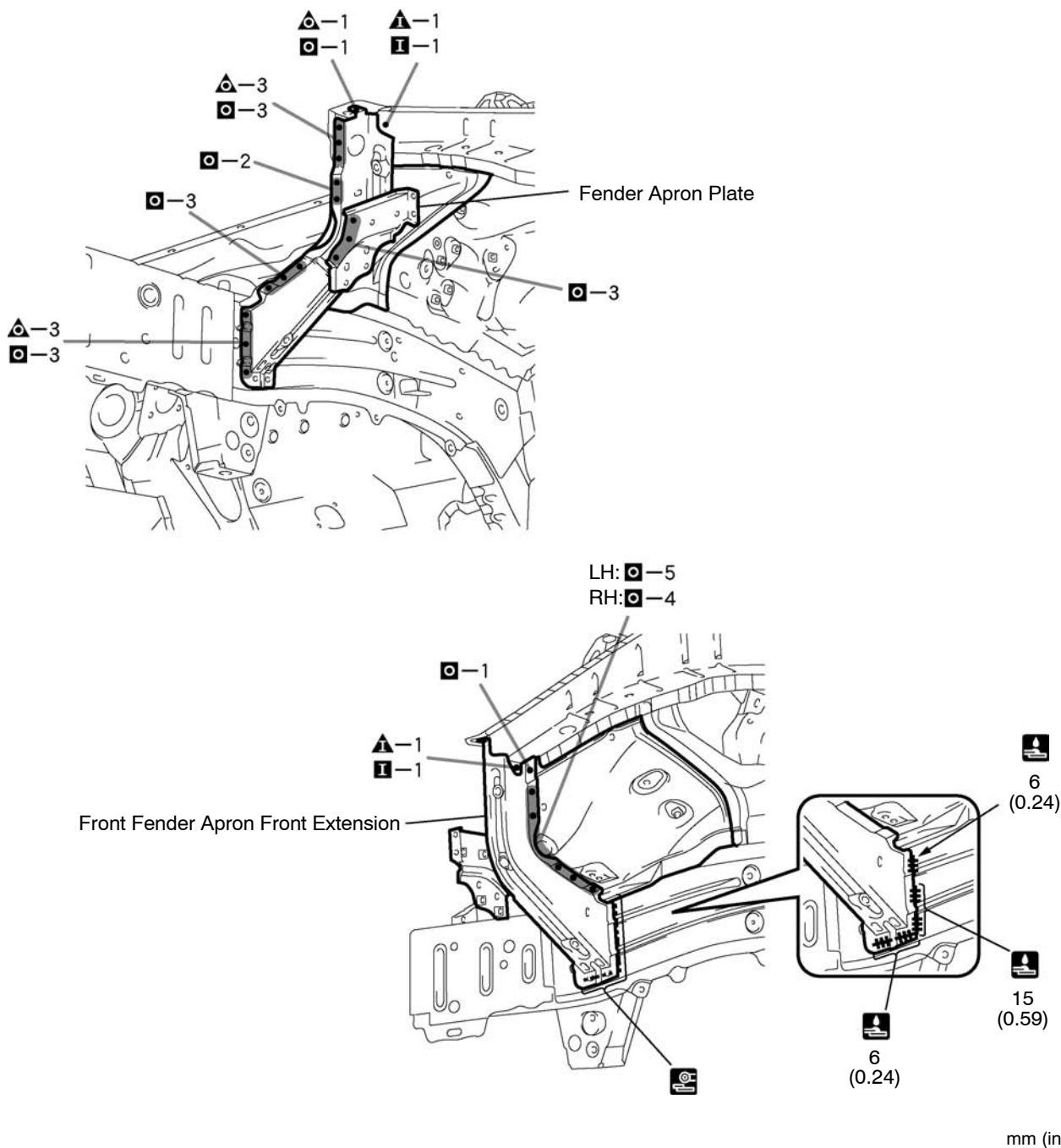


F25707

### 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](#))





F25708

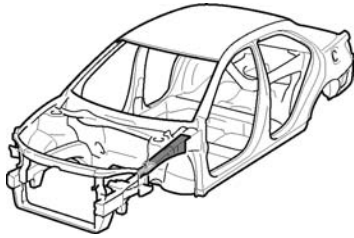
**REMOVAL POINT**

- 1 Remove the front fender apron front extension at the same time.

**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 After welding, apply body sealer and undercoating to the corresponding parts. ([See the paint coating](#))
- 4 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

## FRONT APRON TO COWL SIDE UPPER MEMBER (ASSY)



F25709A

With the front fender front apron and front body pillar lower gusset removed.

### Symbol meaning

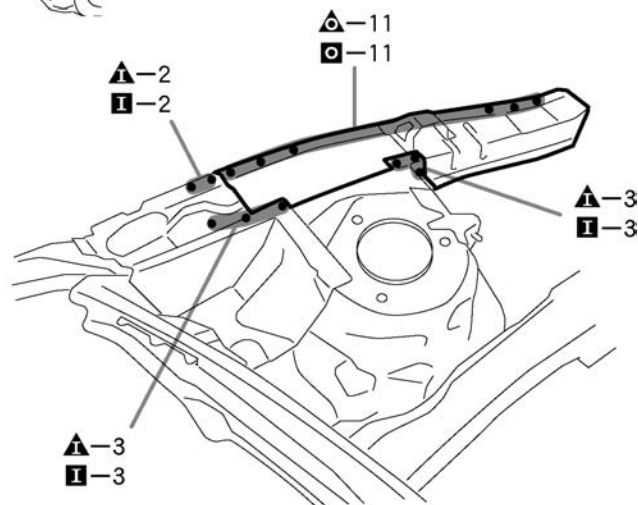
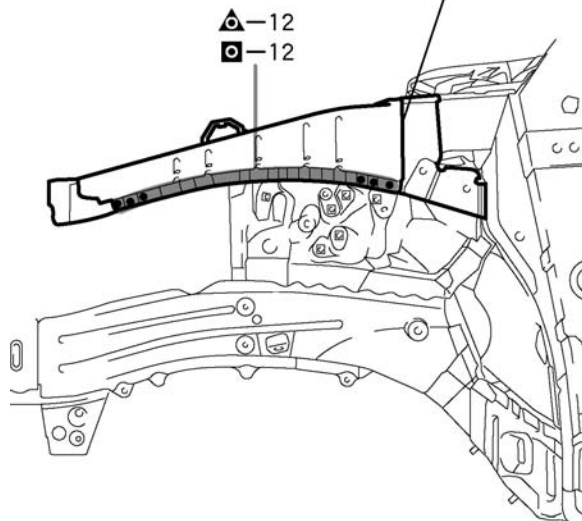
REMOVAL      : Remove Weld Points

INSTALLATION      : MIG Plug Weld

F25709B

### REMOVAL-INSTALLATION

Front Apron To Cowl Side Lower Front Member



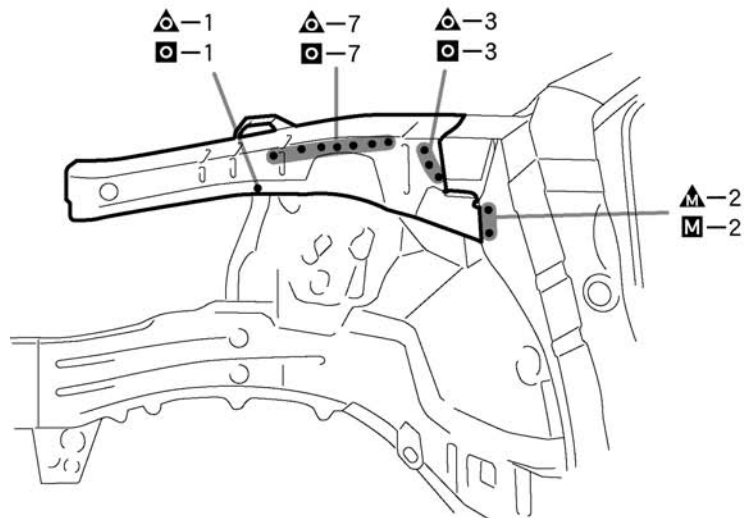
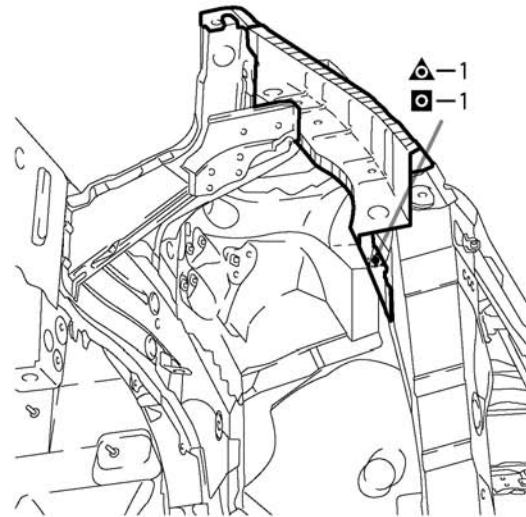
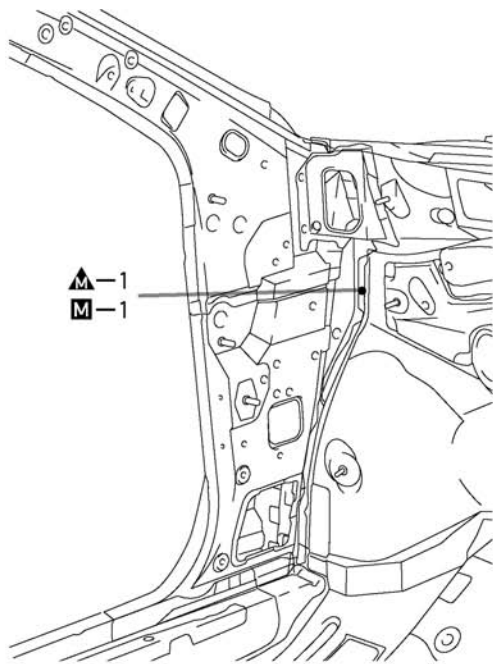
F25709

### REMOVAL POINT

- 1 After removing the front apron to cowl side lower front member, remove the front apron to cowl side upper member.

### 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 After welding the to the front apron to cowl side upper member vehicle side, install the front apron to cowl side lower front member.

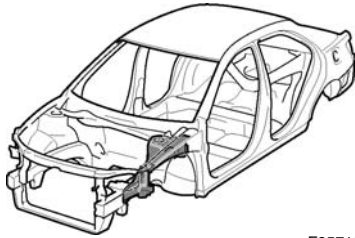


F25805

### 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 After welding, apply body sealer and undercoating to the corresponding parts. ([See the paint coating](#))
- 4 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

## FRONT FENDER APRON (ASSY)



F25710A

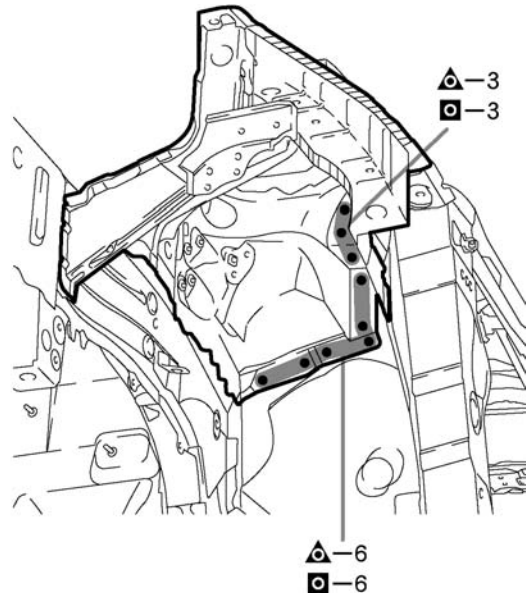
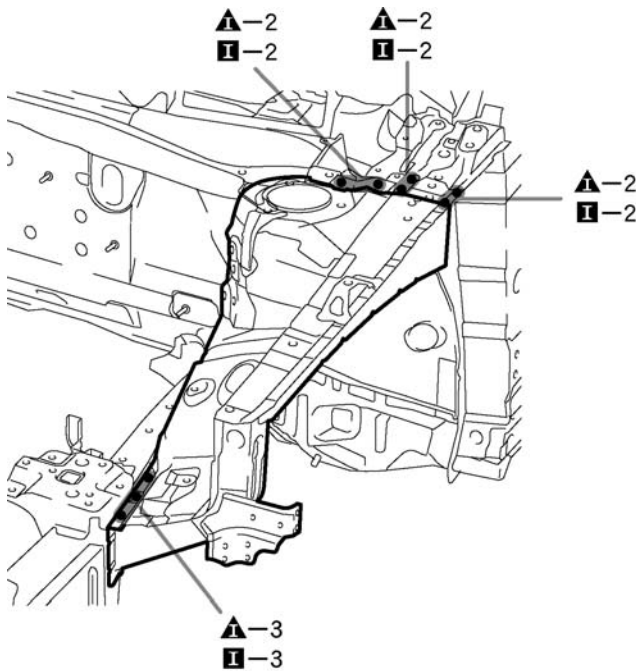
With the radiator support and front body pillar lower gusset removed.

### Symbol meaning

REMOVAL      : Remove Weld Points      : Cut with disc sander, etc.  
 INSTALLATION      : MIG Plug Weld      : Tack Weld

F25710B

### REMOVAL·INSTALLATION



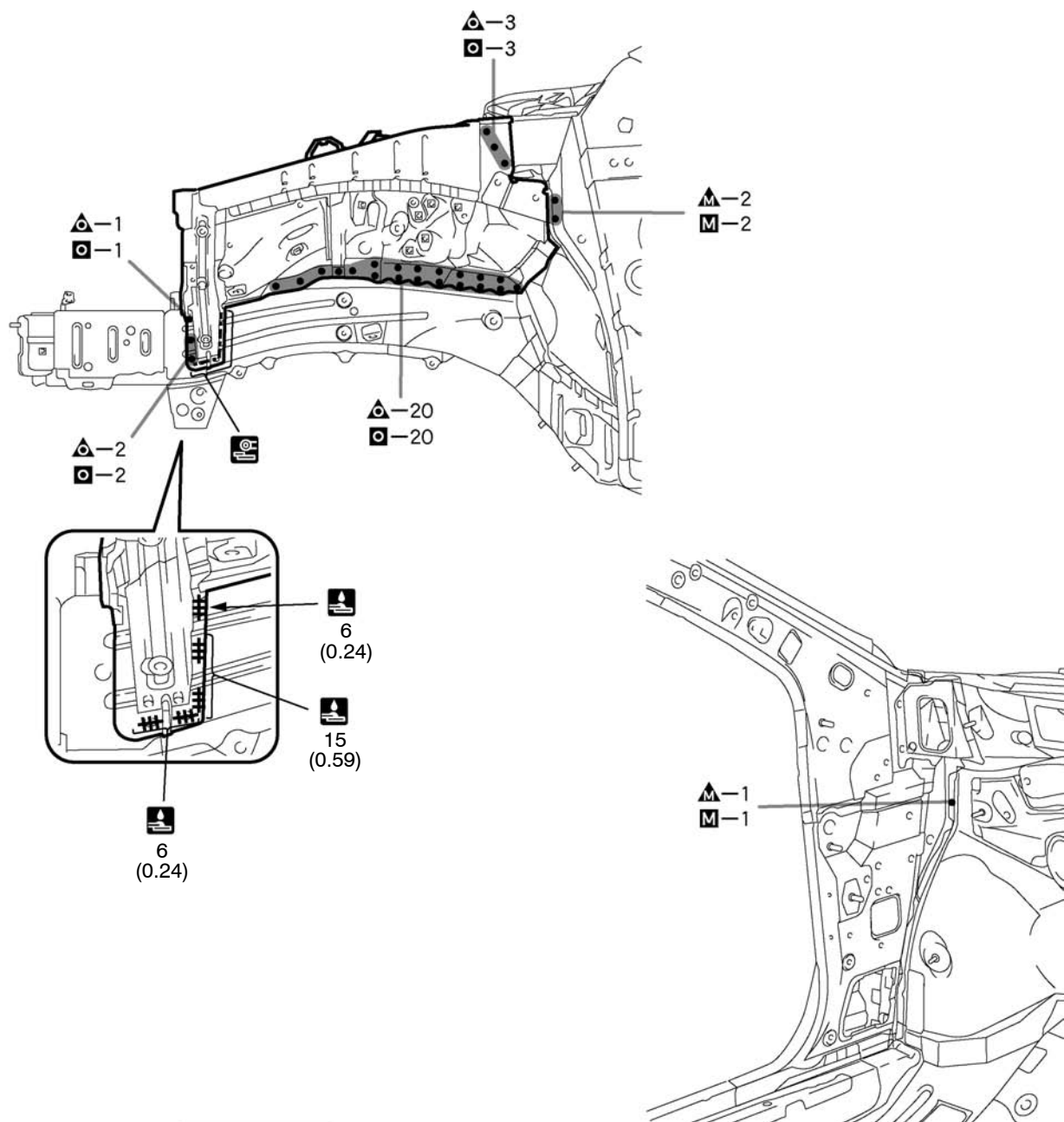
### CAUTION

Make sure to attach correctly in accordance with the body dimension diagram as this part affects the front wheel alignment.

F25710

### 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](#))

**CAUTION**

Make sure to attach correctly in accordance with the body dimension diagram as this part affects the front wheel alignment.

mm (in.)

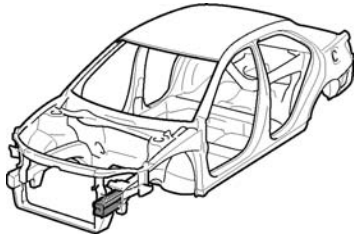
F25711

**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 After welding, apply body sealer and undercoating to the corresponding parts. ([See the paint coating](#))
- 4 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.



# FRONT SIDE MEMBER (CUT-P)



F25712A

With the radiator support removed.

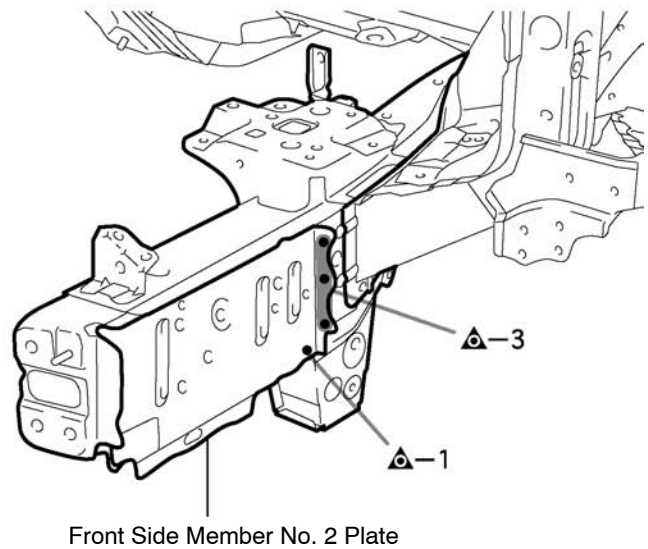
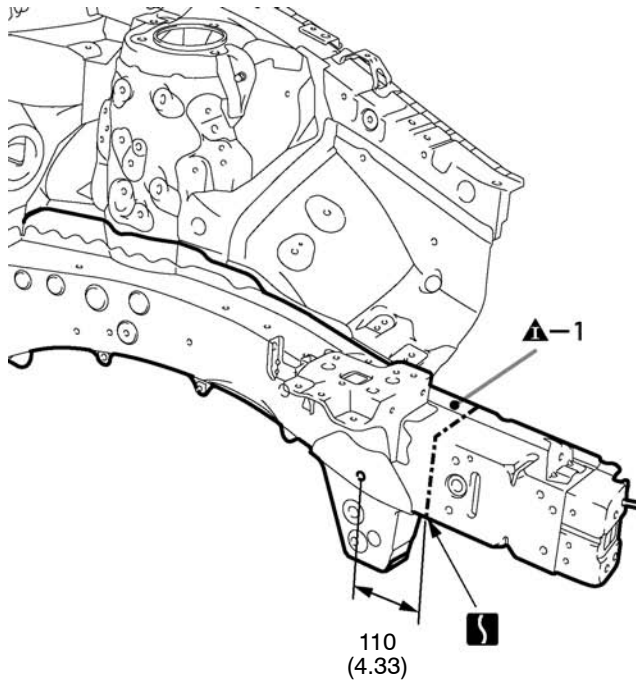
Symbol meaning

▲▲ : Remove Weld Points

■ : Cut and Join Location

F25712B

## REMOVAL



Front Side Member No. 2 Plate

mm (in.)

F26351

## REMOVAL POINT

- 1 Remove the front side member No. 2 plate at the same time.



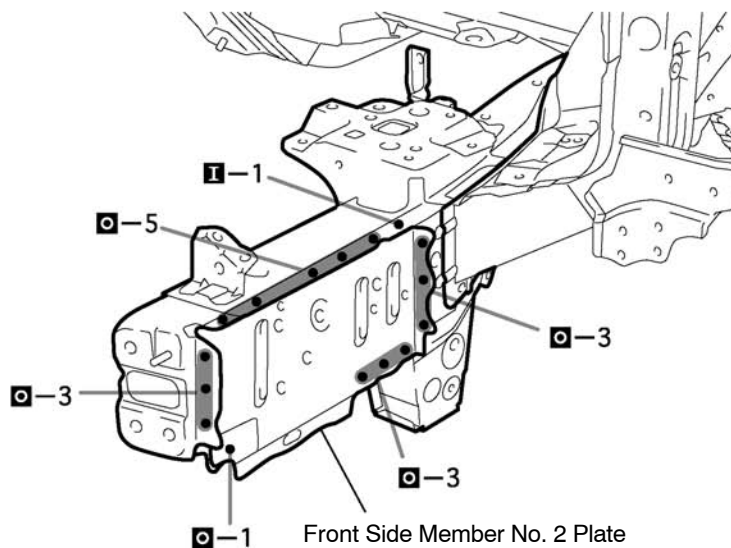
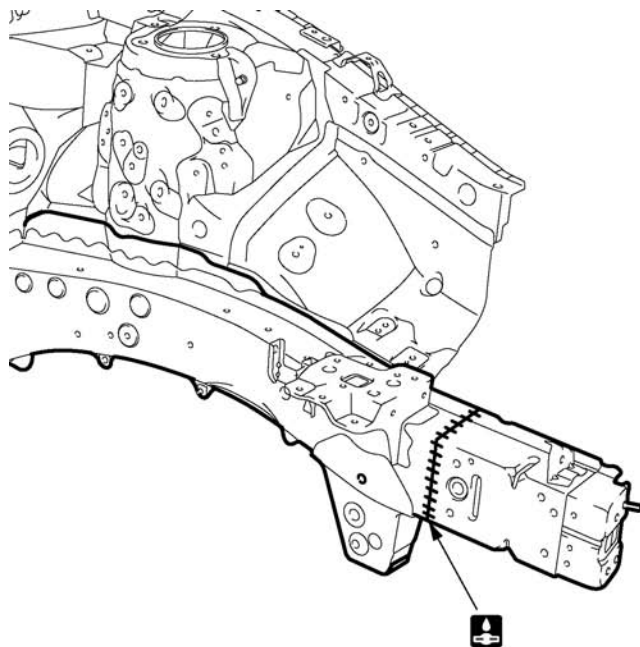
## Symbol meaning

 : MIG Plug Weld

 : Butt Weld

F25713B

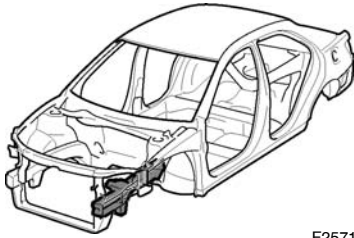
## INSTALLATION



F26352

## INSTALLATION POINT

- 1 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](#))
- 2 After welding, apply undercoating to the corresponding parts. ([See the paint-coating](#))
- 3 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

**FRONT SIDE MEMBER (CUT-H)**

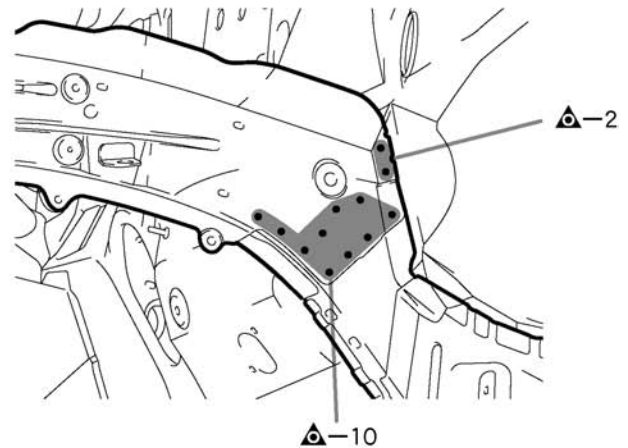
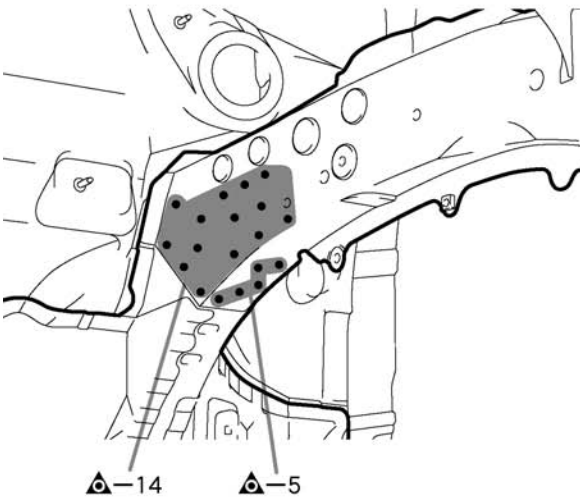
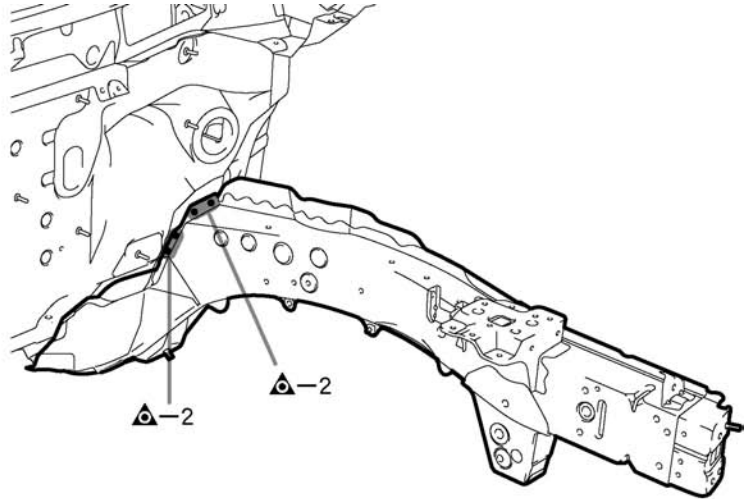
F25716A

With the front fender apron removed.

**Symbol meaning**

▲ : Remove Weld Points

F25716B

**REMOVAL**

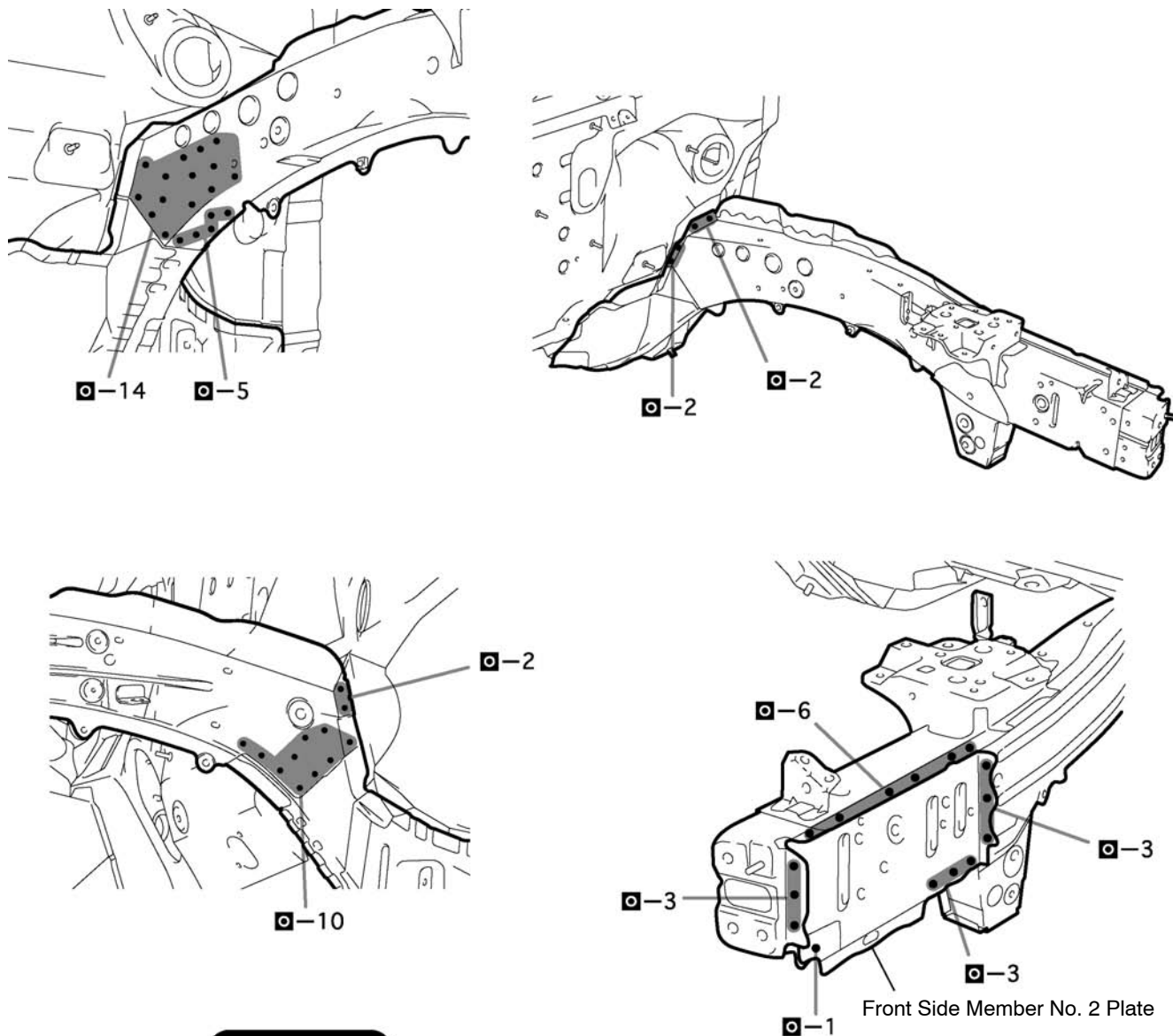
F25716

## Symbol meaning

◻ : MIG Plug Weld

F25718B

## INSTALLATION

**CAUTION**

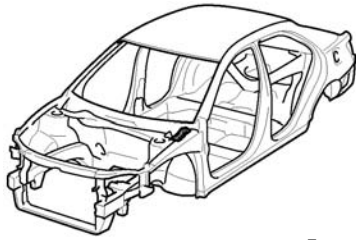
Make sure to attach correctly in accordance with the body dimension diagram as this part affects the front wheel alignment.

F26451

**INSTALLATION POINT**

- 1 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](#))
- 2 After welding, apply body sealer and undercoating to the corresponding parts. ([See the paint coating](#))
- 3 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

## COWL TOP SIDE REINFORCEMENT (ASSY)



F25720A

### Symbol meaning

REMOVAL



: Cut with disc sander, etc.

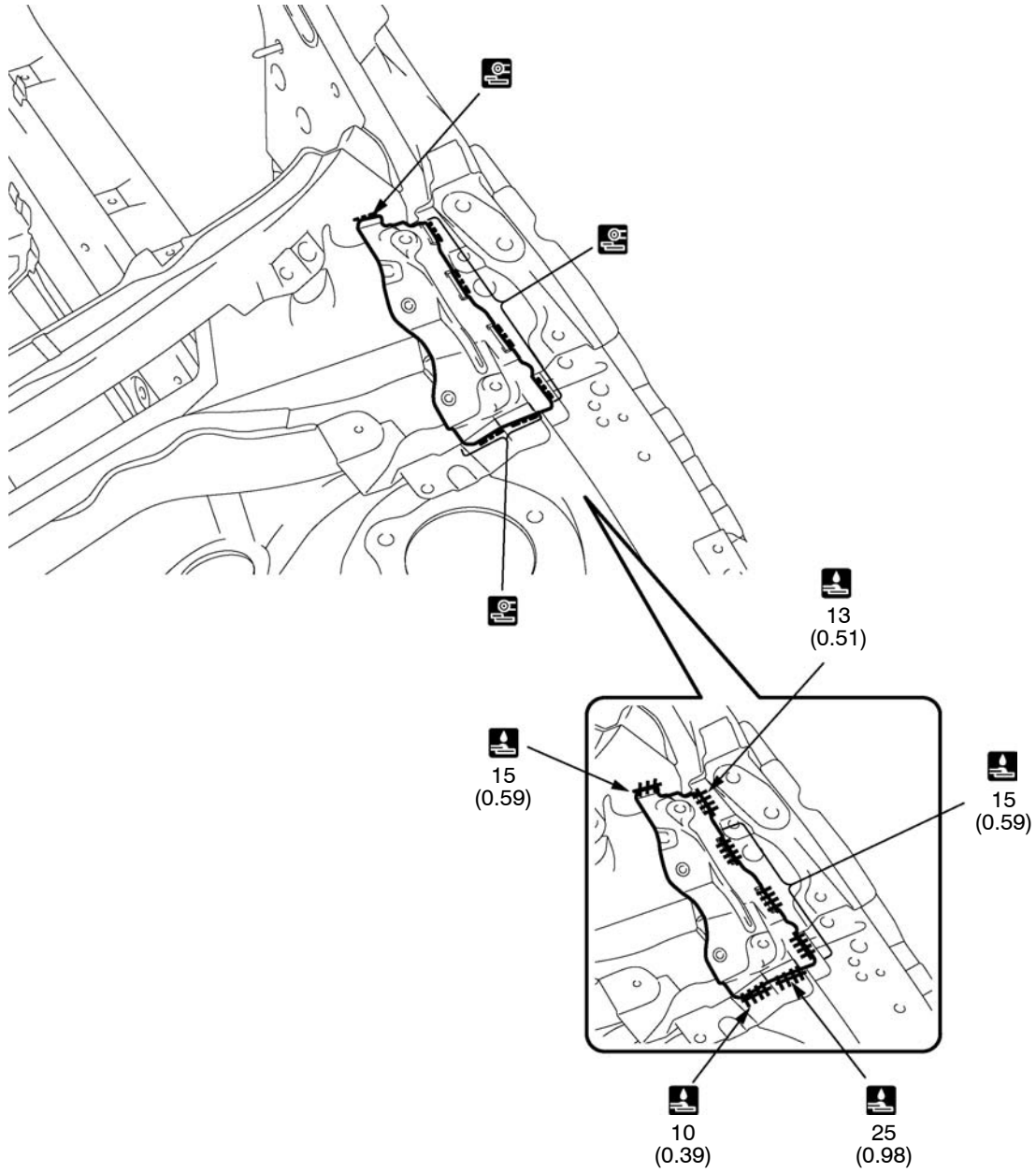
INSTALLATION



: Tack Weld

F25720B

### REMOVAL-INSTALLATION

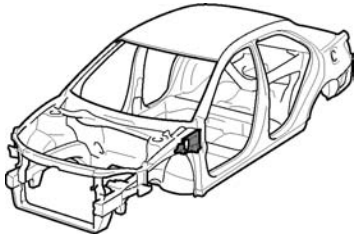


F25720

### INSTALLATION POINT

- 1 After welding, apply body sealer to the corresponding parts. ([See the paint-coating](#))
- 2 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

# FRONT BODY PILLAR LOWER GUSSET (ASSY)



F25719A

## Symbol meaning

REMOVAL

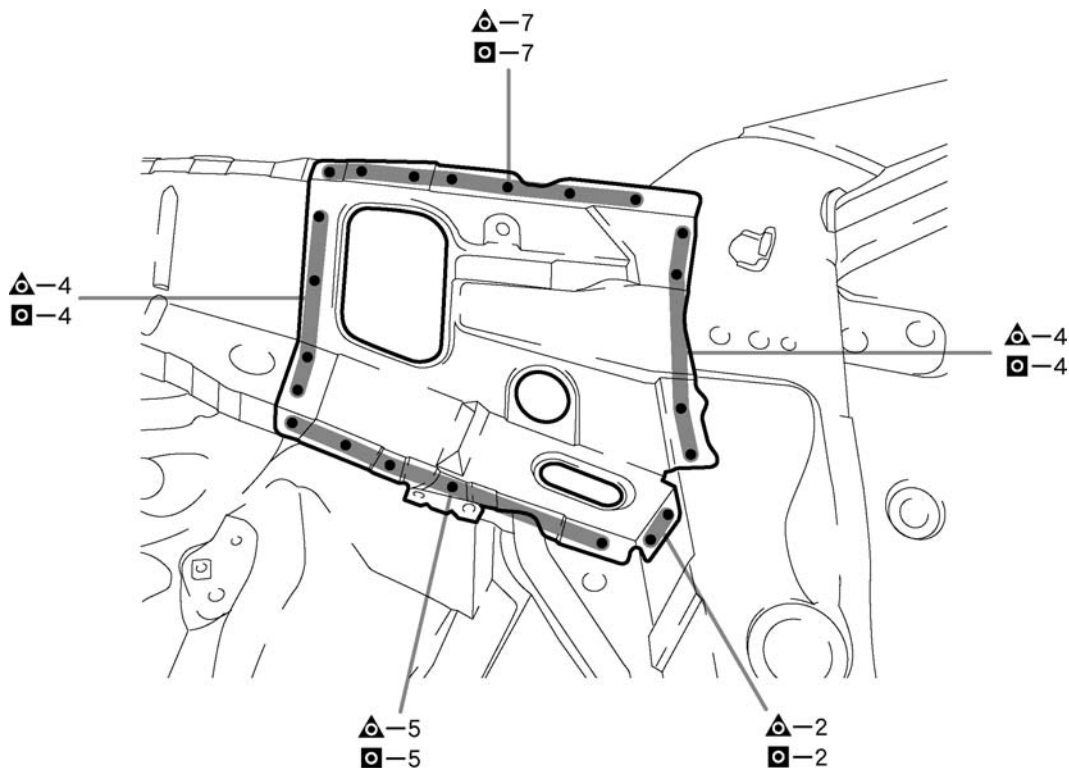
▲ : Remove Weld Points

INSTALLATION

◻ : MIG Plug Weld

F25719B

## REMOVAL·INSTALLATION

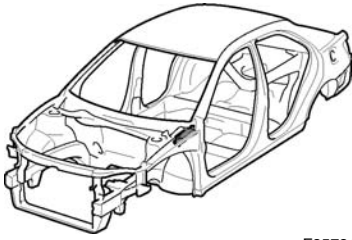


F25719

## INSTALLATION POINT

- 1 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

## COWL TOP OUTER PANEL (ASSY)



F25721A

With the cowl top side reinforcement and front body pillar lower gusset removed.

### Symbol meaning

REMOVAL

△ : Remove Weld Points

⊙ : Cut with disc sander, etc.

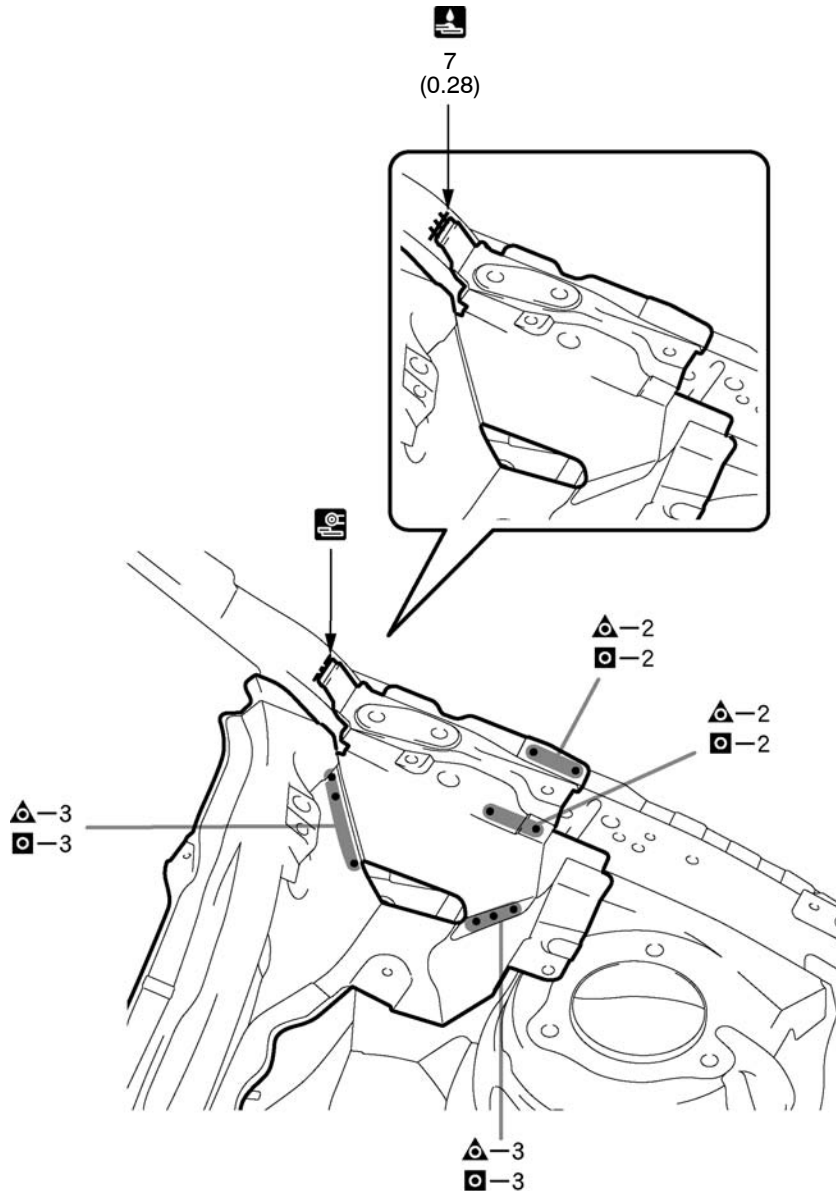
INSTALLATION

⊙ : MIG Plug Weld

⊙ : Tack Weld

F25721B

### REMOVAL·INSTALLATION



mm (in.)

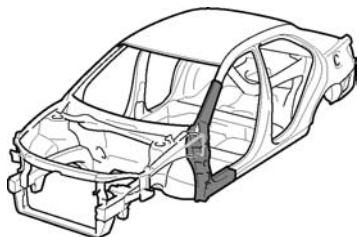
F25721

### INSTALLATION POINT

- 1 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](#))
- 2 After welding, apply body sealer to the corresponding parts. ([See the paint coating](#))
- 3 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.




## FRONT BODY PILLAR (CUT)






F25722A

With the cowl top outer panel and front body pillar lower gusset removed.

### Symbol meaning

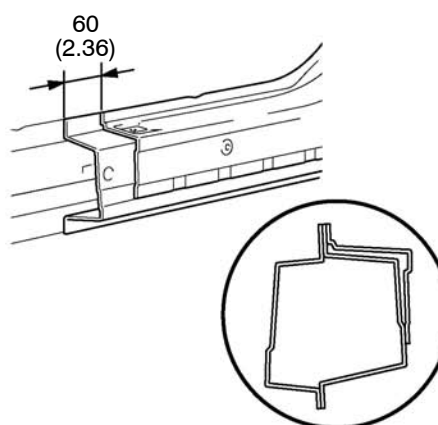
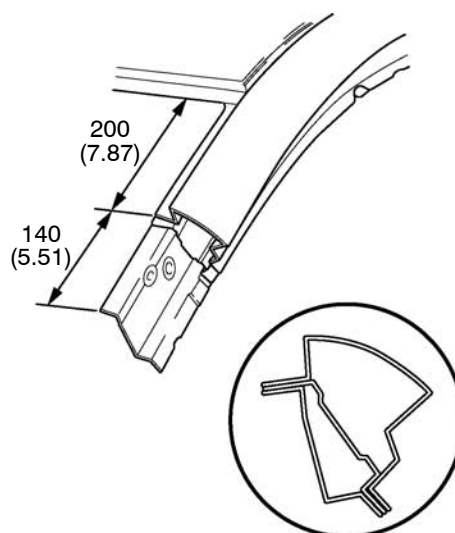
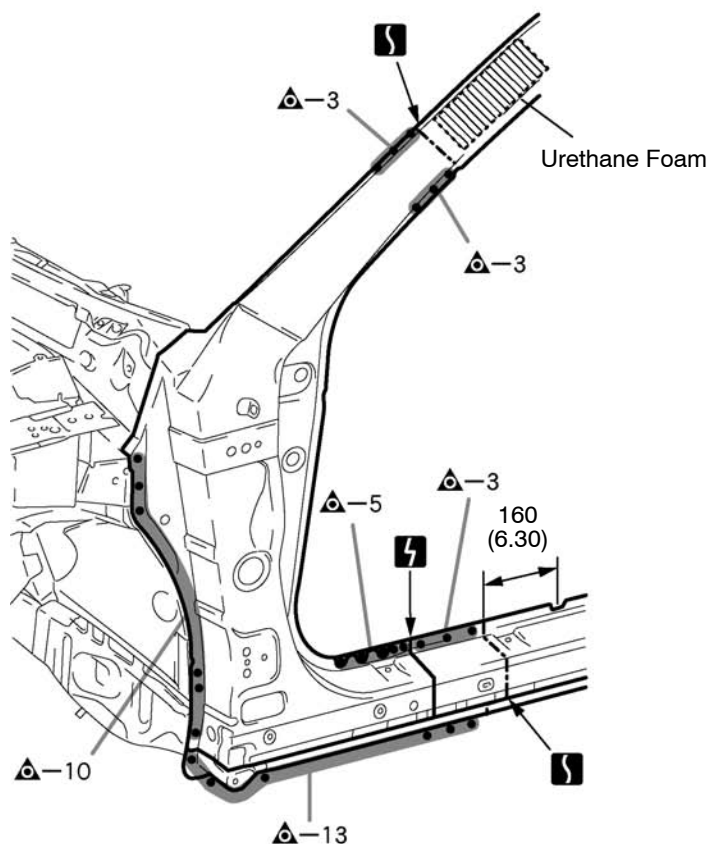
 : Cut with disc sander, etc.

 : Cut and Join Location

 : Remove Weld Points  : Cut Location for Supply Parts

F25722B


### REMOVAL





mm (in.)


F25722

Symbol meaning

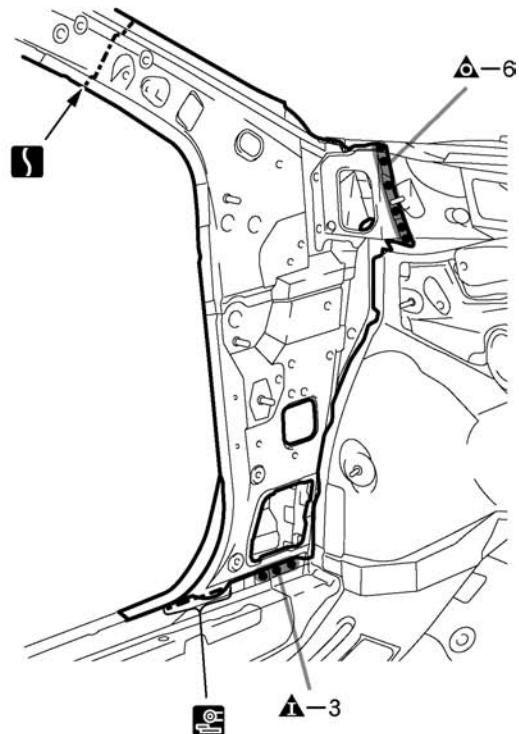
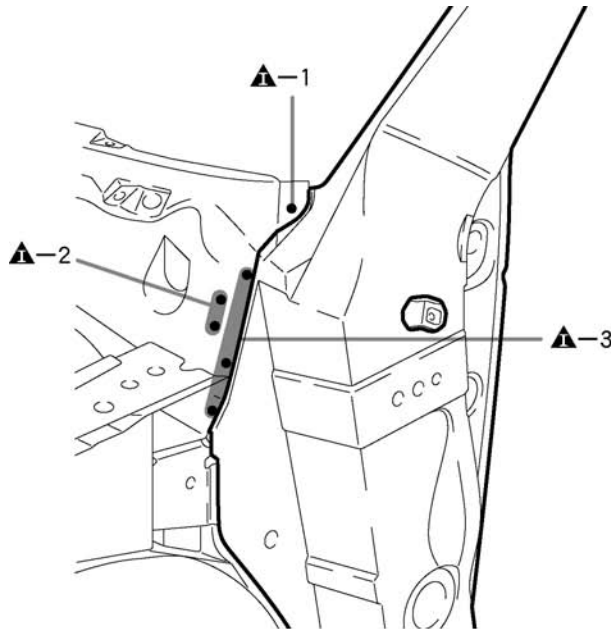
 : Cut with disc sander, etc.

 : Cut and Join Location

 : Remove Weld Points


 : Cut Location for Supply Parts

F25722B



F25723

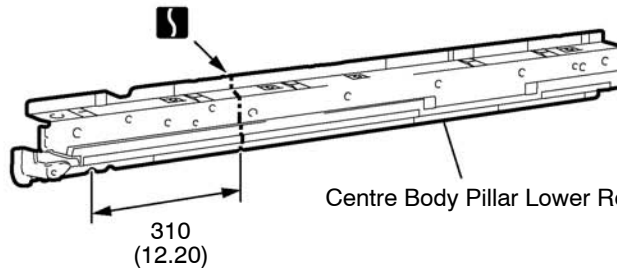
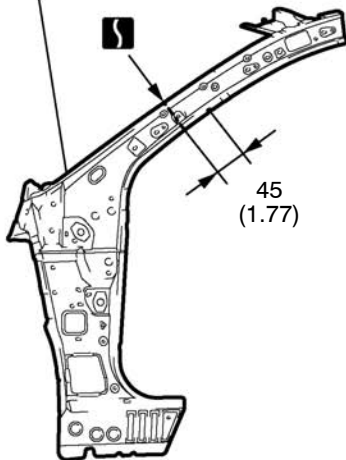
## Symbol meaning

 : MIG Plug Weld   
  : Cut and Join Location  
 : Tack Weld   
  : Butt Weld   
  : Body Sealer

F25724B

## INSTALLATION

Cowl Side Panel



Centre Body Pillar Lower Reinforcement

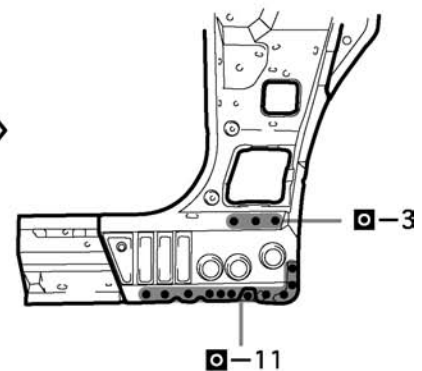
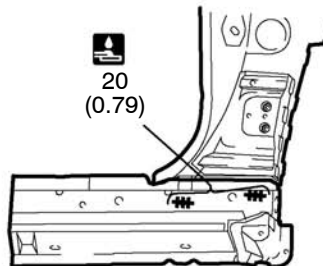
□-10

Front Body Pillar Lower Reinforcement

□-22

□-3

□-6



mm (in.)

F26107

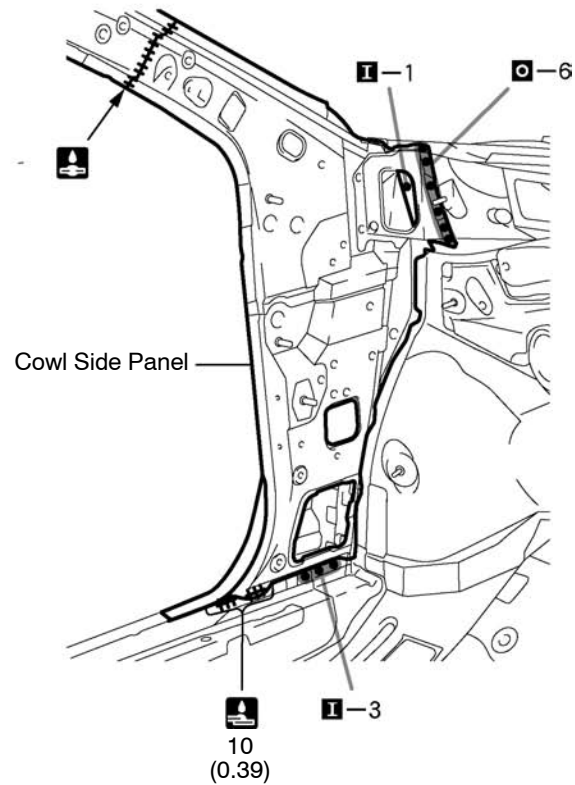
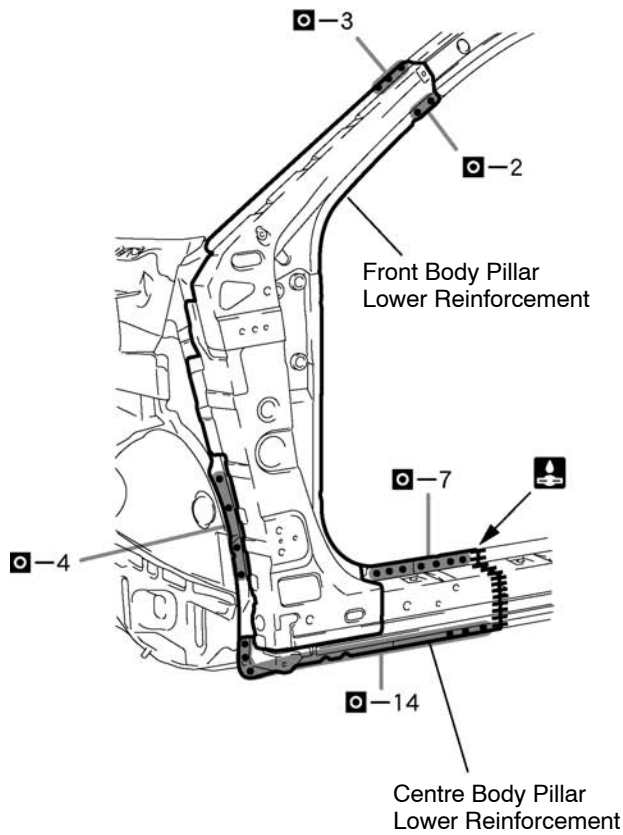
## INSTALLATION POINT

- 1 Before temporarily installing the new parts, weld the centre body pillar lower reinforcement, front body pillar lower reinforcement and cowl side panel with the standard number of welding points.

Symbol meaning

-  **I** : MIG Plug Weld    
  : Cut and Join Location  
 : Tack Weld    
  : Butt Weld    
  : Body Sealer

F25724B

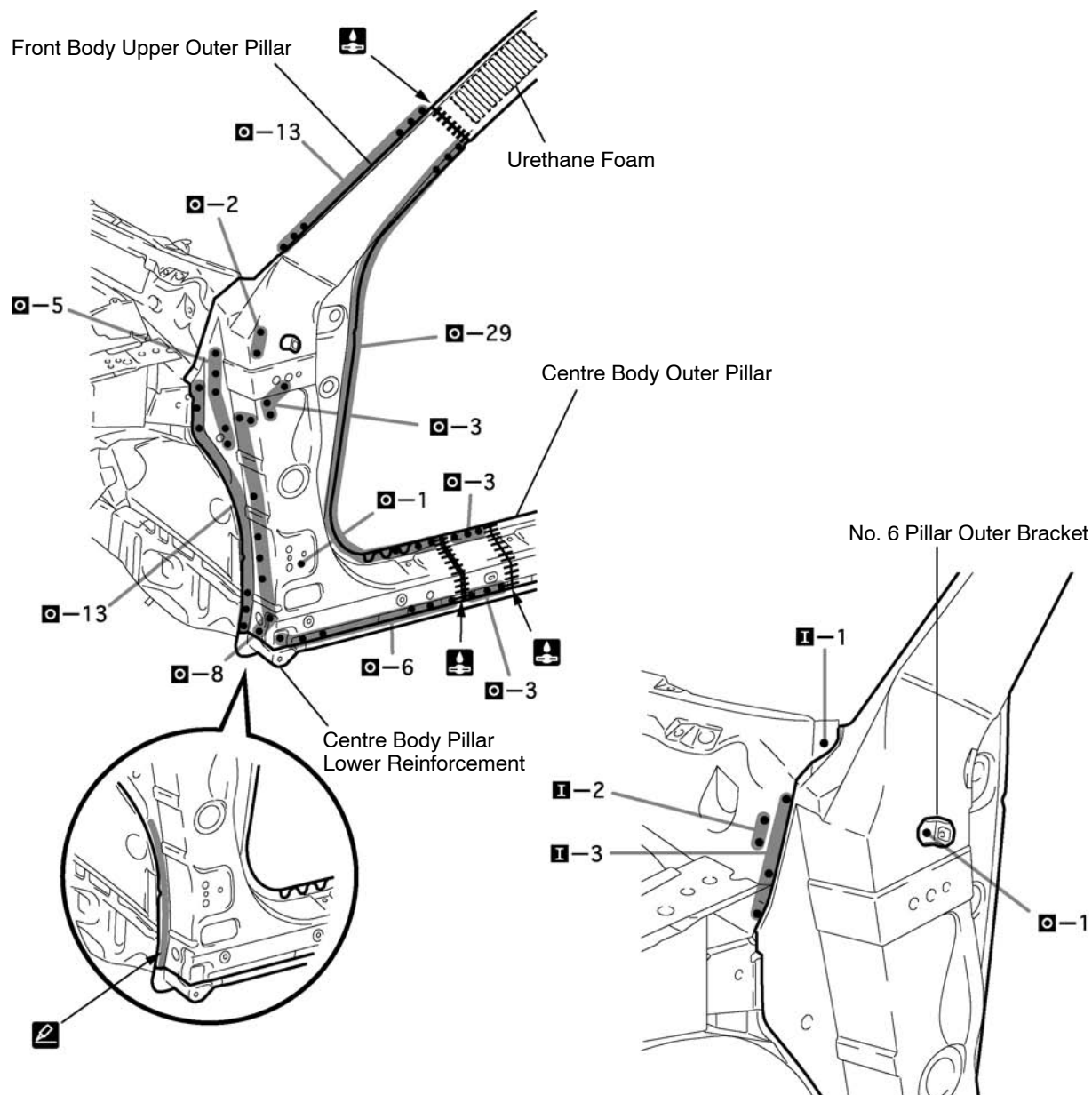


mm (in.)

F25725

**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 After welding the centre body pillar lower reinforcement, front body pillar lower reinforcement and cowl side panel to the vehicle side, install the front body upper outer pillar and centre body outer pillar.

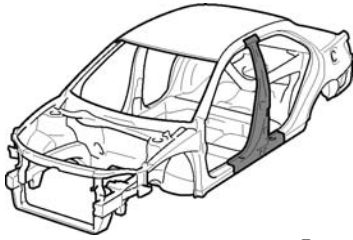


F26353

### 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 installing a new part, apply body sealer.  
*HINT:*  
1) Apply sealer in an even, continuous bead.
- 4 After welding the centre body pillar lower reinforcement and front body pillar lower reinforcement to the vehicle side, install the front body upper outer pillar, centre body outer pillar and No.6 pillar outer bracket.
- 5 After welding, apply polyurethane foam to the corresponding parts. (See the paint-coating)
- 6 After welding, apply body sealer and undercoating to the corresponding parts. (See the paint-coating)
- 7 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

# CENTRE BODY PILLAR (CUT)



F25726A

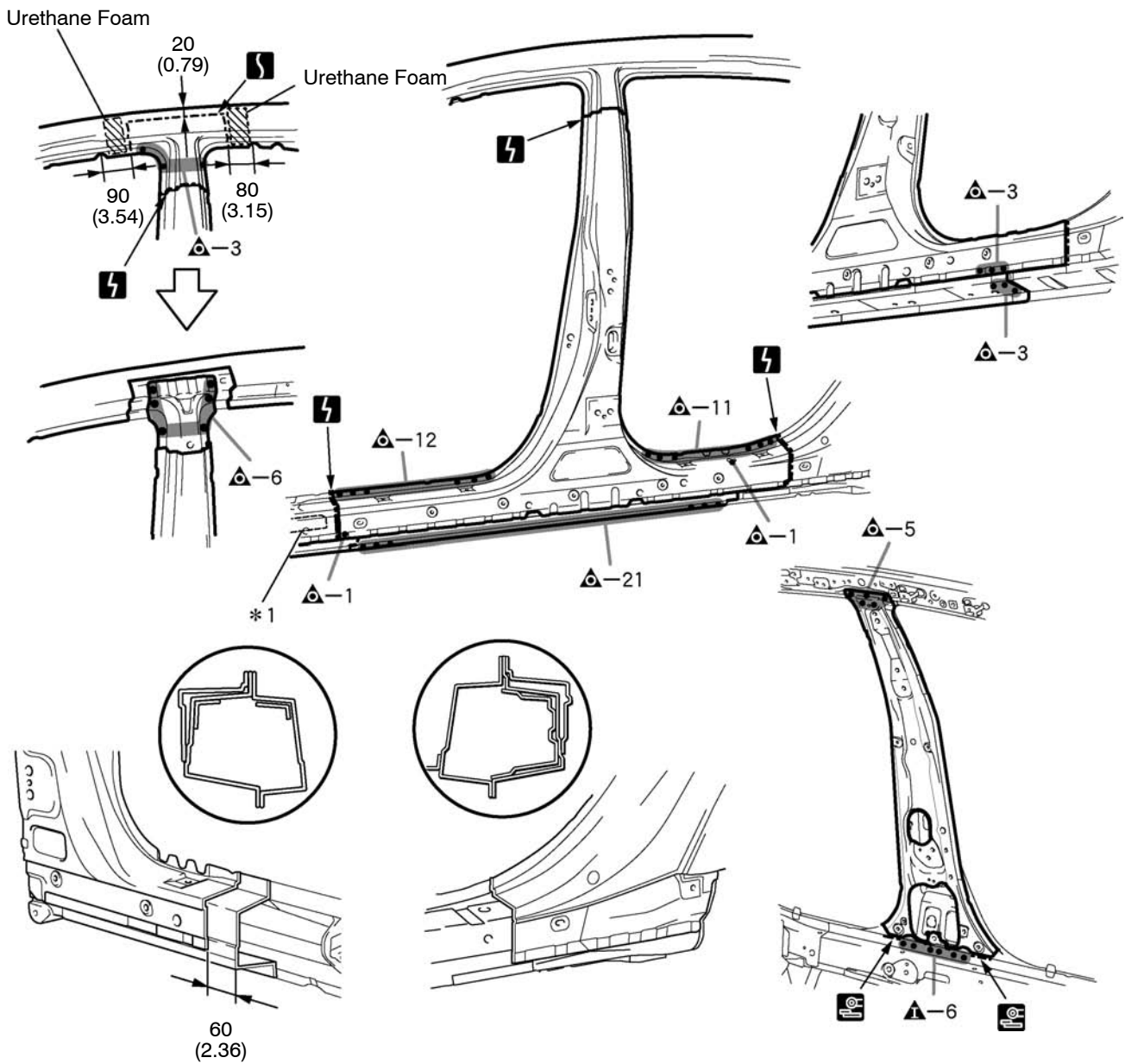
Symbol meaning

: Cut with disc sander, etc.

: Remove Weld Points : Cut and Join Location : Cut Location for Supply Parts

F25726B

## REMOVAL



mm (in.)

F25726

## REMOVAL POINT

1 \*1: Take care not to damage the internal reinforcement.



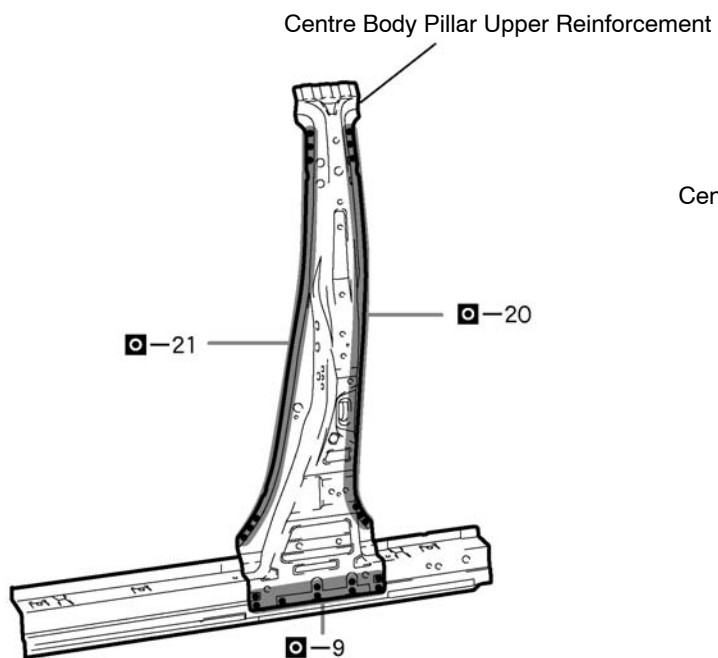
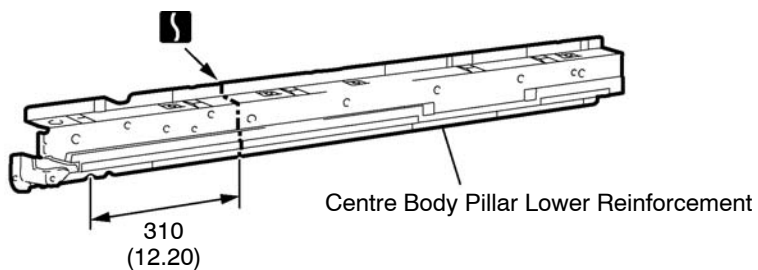
## Symbol meaning

□ I : MIG Plug Weld    S : Cut and Join Location

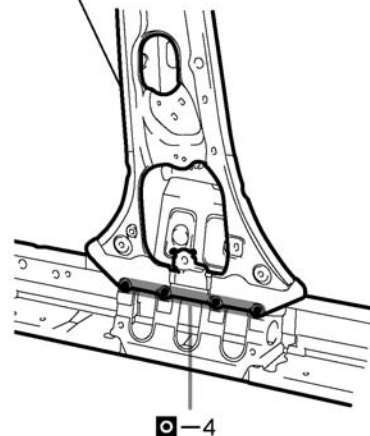
⬮ : Tack Weld    ⬮ : Butt Weld

F25727B

## INSTALLATION



Centre Body Inner Pillar



mm (in.)

F25727

## INSTALLATION POINT

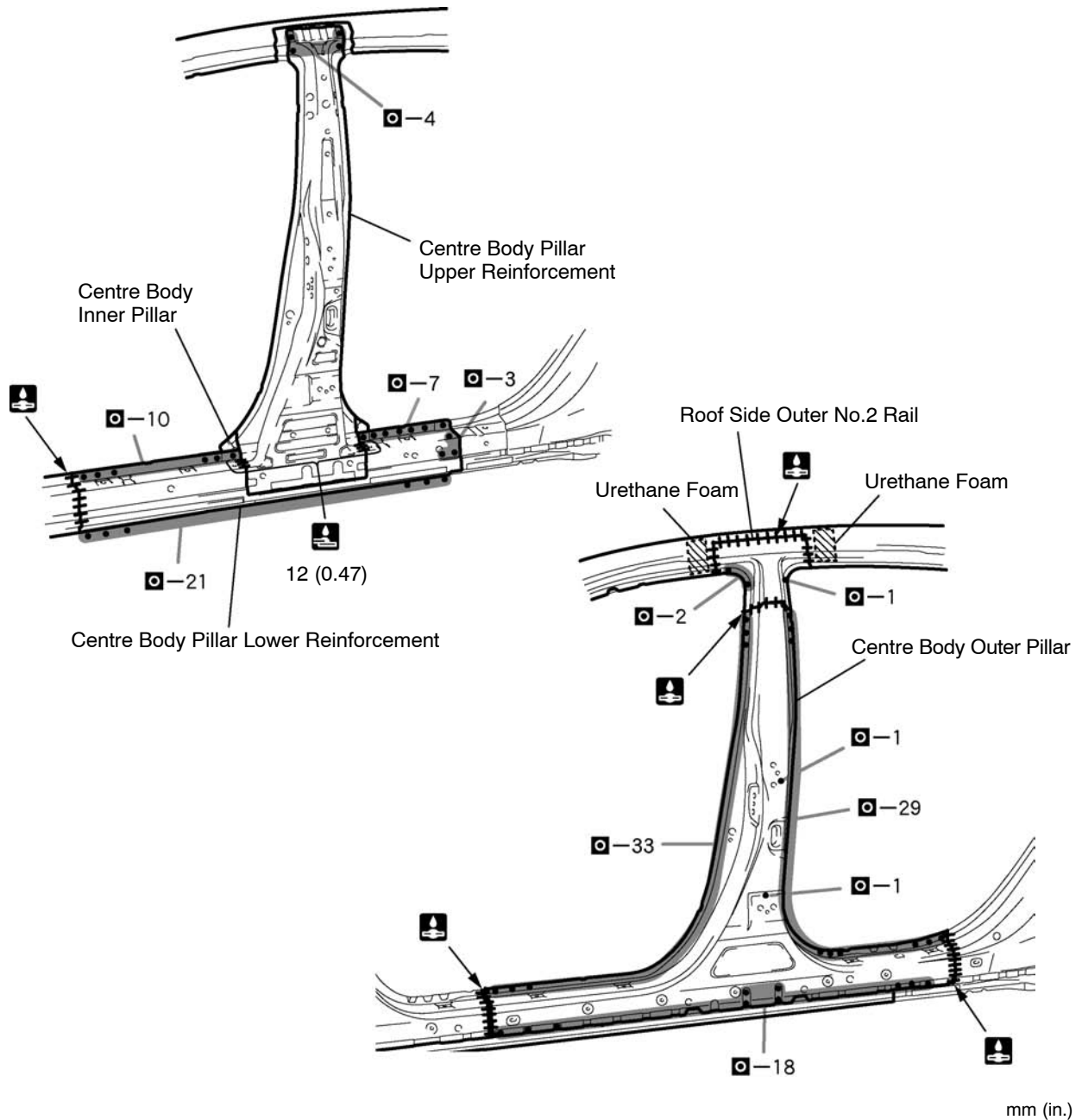
- 1 Before temporarily installing the new parts, weld the centre body pillar lower reinforcement, centre body pillar upper reinforcement and centre body inner pillar with the standard number of welding points.

## Symbol meaning

○ I : MIG Plug Weld    S : Cut and Join Location

⬮ : Tack Weld    ⬮ : Butt Weld

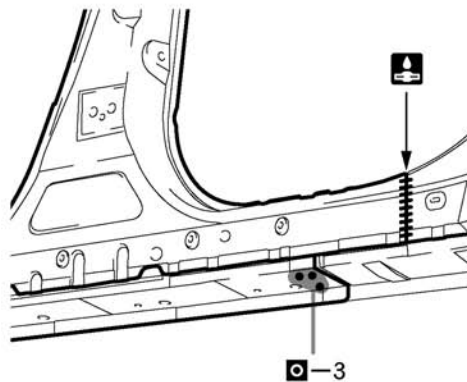
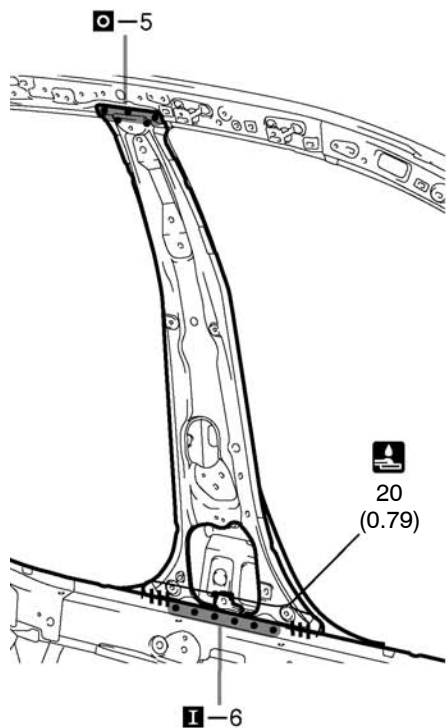
F25727B



F25728

**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 After welding the centre body pillar lower reinforcement, centre body pillar upper reinforcement and centre body inner pillar to the vehicle side, install the centre body outer pillar and roof side outer No.2 rail.

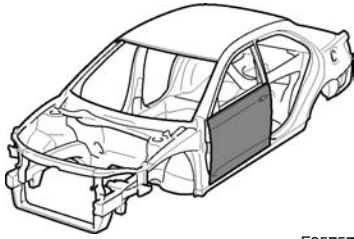


F25808

### 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 After welding, apply polyurethane foam to the corresponding parts. ([See the paint coating](#))
- 4 After welding, apply body sealer and undercoating to the corresponding parts. ([See the paint coating](#))
- 5 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

## FRONT DOOR OUTER PANEL (ASSY)



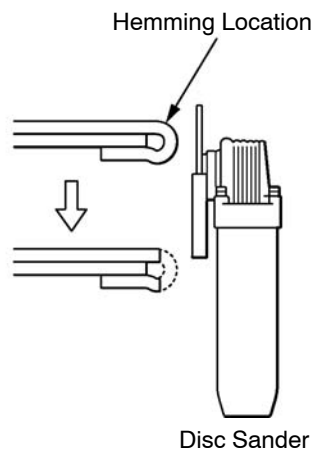
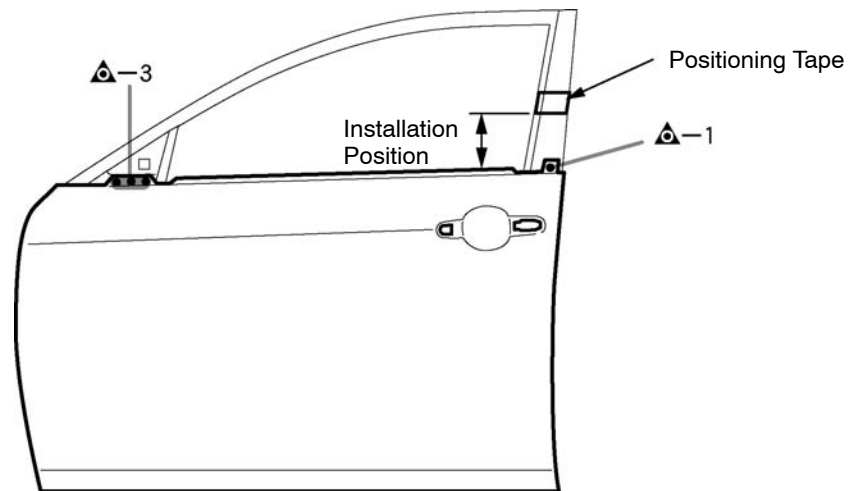
F25757A

### Symbol meaning

△ : Remove Weld Points

F25757B

### REMOVAL



F25757

### REMOVAL POINT

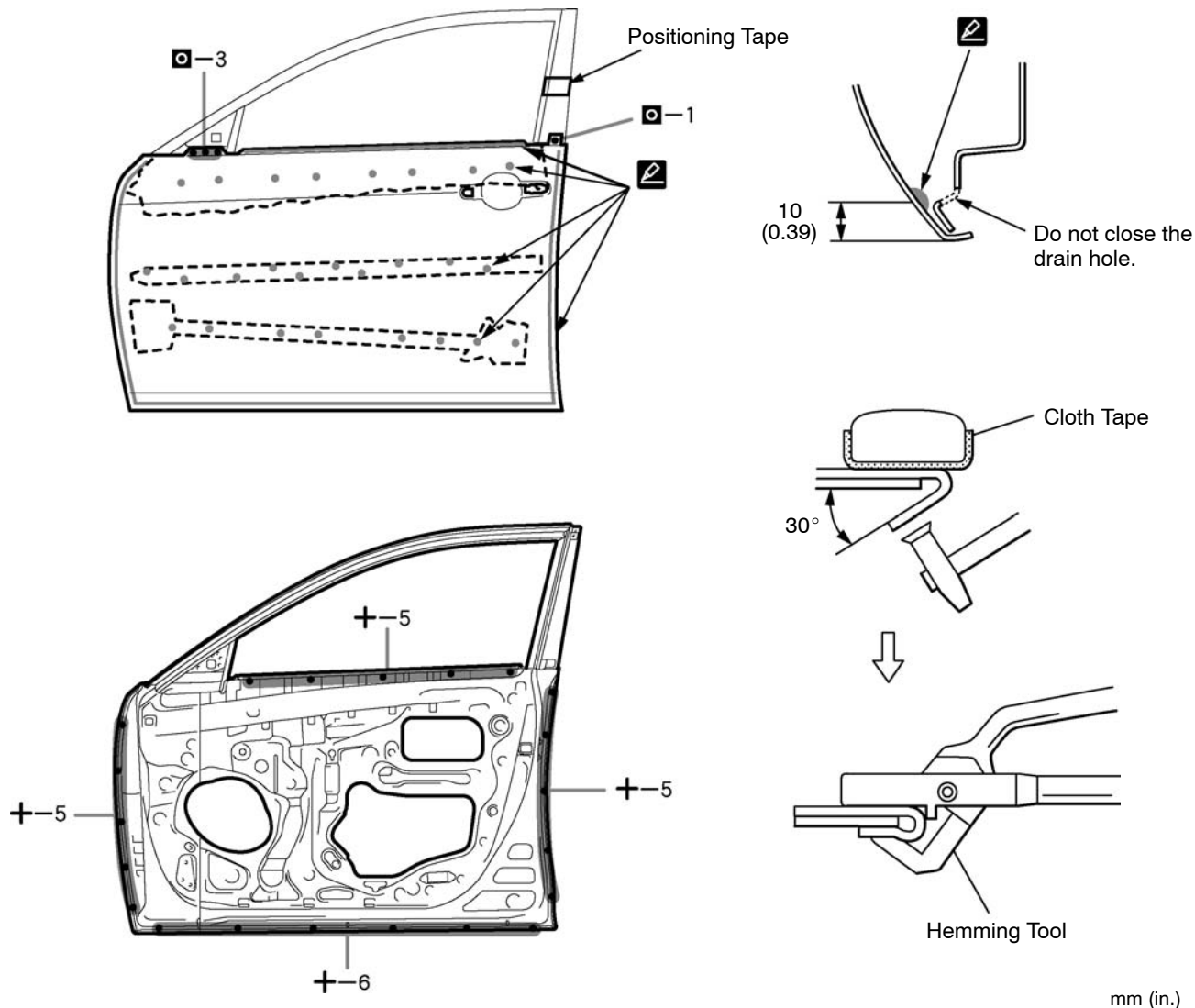
- 1 Before removing the outer panel, mark the installation position with tape.
- 2 Before removing the outer panel, establish its exact position in relation to the window frame using a reference marker, etc.
- 3 After grinding off the hemming location, remove the outer panel.

## Symbol meaning

◻ : MIG Plug Weld    + : Spot MIG Weld    ◻ : Body Sealer

F25758B

## INSTALLATION



F25758

## INSTALLATION POINT

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

**HINT:**

- 1) Apply sealer evenly about 10 mm (0.39 in.) from the flange and 3 mm (0.12 in.) in diameter on the outer panel and apply just enough sealer for the reinforcement and side impact protection beam to make contact.

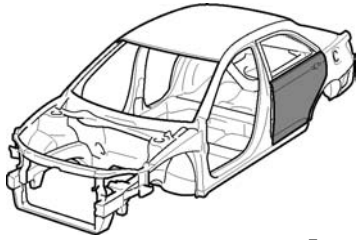
- 2 Bend the flange hem about 30° with a hammer and dolly. Then, fasten tightly with a hemming tool.

**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.

- 3 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

## REAR DOOR OUTER PANEL (ASSY)



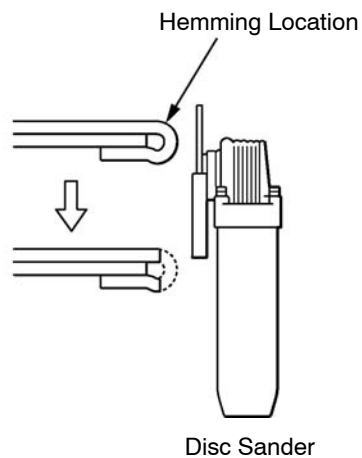
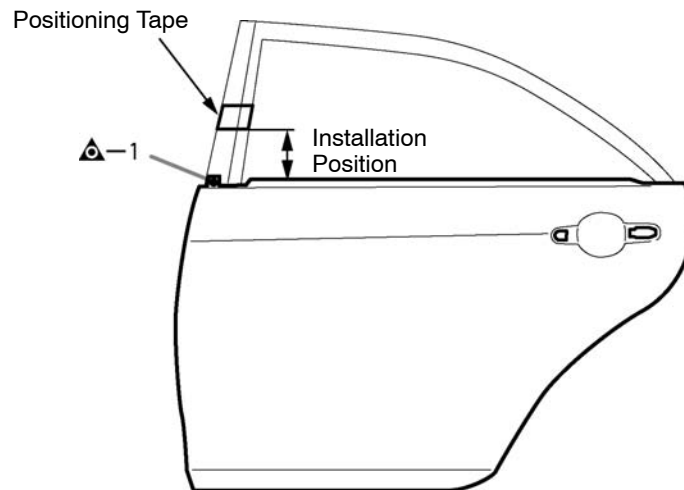
F25759A

### Symbol meaning

⚠ : Remove Weld Points

F25759B

### REMOVAL



F25759

### REMOVAL POINT

- 1 Before removing the outer panel, mark the installation position with tape.
- 2 Before removing the outer panel, establish its exact position in relation to the window frame using a reference marker, etc.
- 3 After grinding off the hemming location, remove the outer panel.

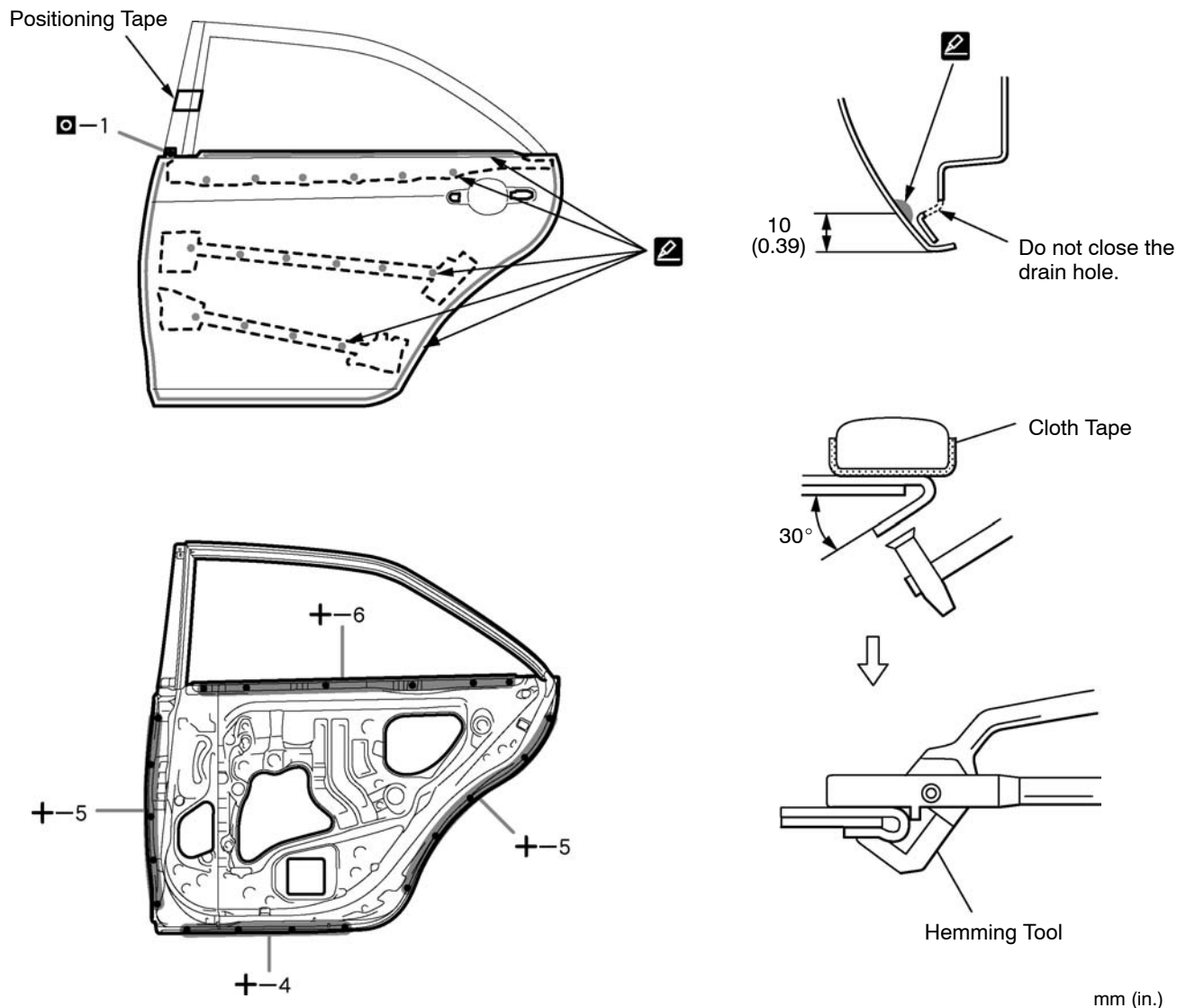


## Symbol meaning

◻ : MIG Plug Weld    + : Spot MIG Weld    ◻ : Body Sealer

F25760B

## INSTALLATION

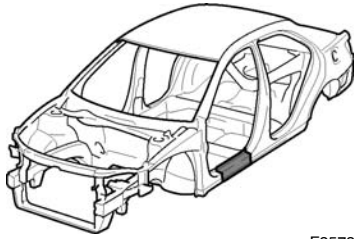


F25760

## INSTALLATION POINT

- Before temporarily installing the new parts, apply body sealer to the reinforcement, side impact protection beam and backside of the new parts.  
**HINT:**
  - Apply sealer evenly about 10 mm (0.39 in.) from the flange and 3 mm (0.12 in.) in diameter on the outer panel and apply just enough sealer for the reinforcement and side impact protection beam to make contact.
- Bend the flange hem about 30° with a hammer and dolly. Then, fasten tightly with a hemming tool.  
**HINT:**
  - Perform hemming in three steps, being careful not to warp the panel.
  - If a hemming tool cannot be used, hem with a hammer and dolly.
- After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

# ROCKER OUTER PANEL (CUT-P)



F25729A

## Symbol meaning

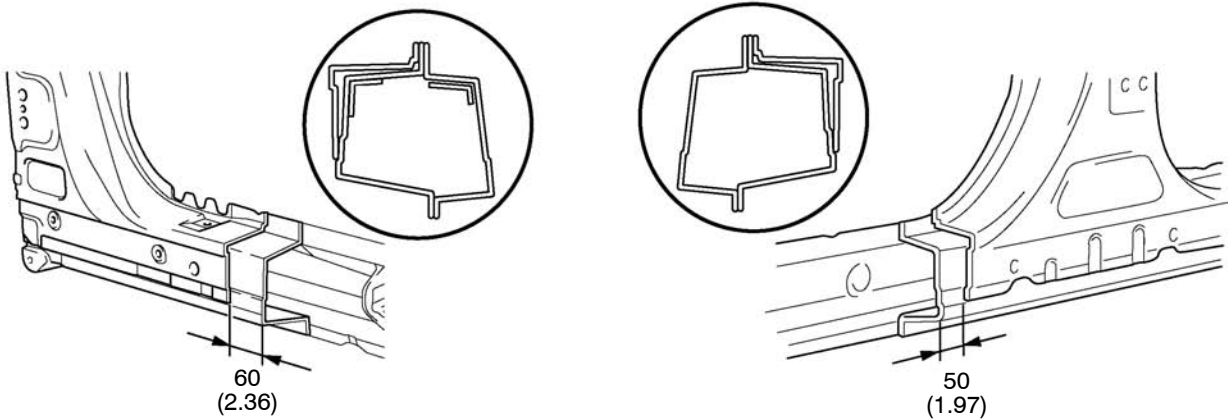
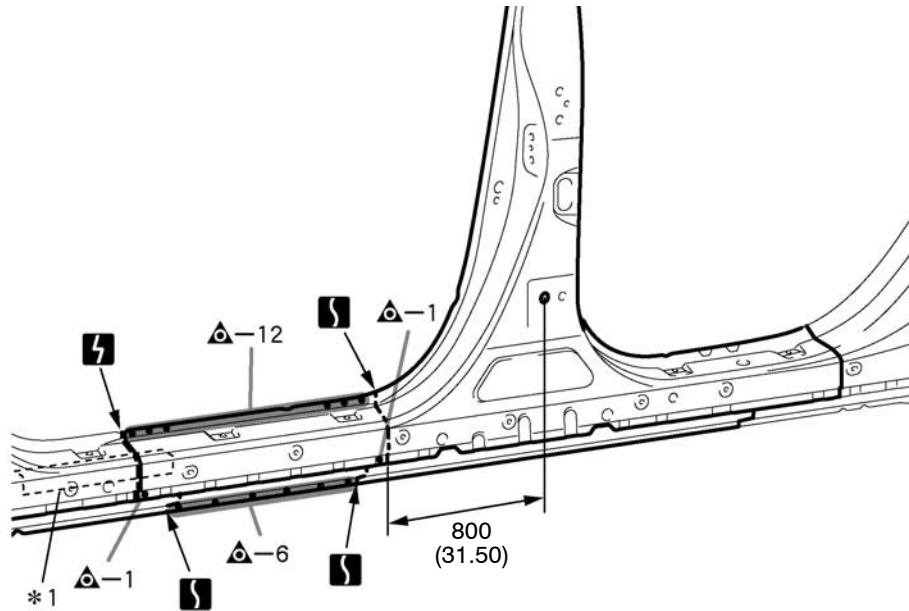
△ : Remove Weld Points

⌋ : Cut and Join Location

⚡ : Cut Location for Supply Parts

F25729B

## REMOVAL






mm (in.)

F25729

## REMOVAL POINT

1 \*1: Take care not to damage the internal reinforcement.

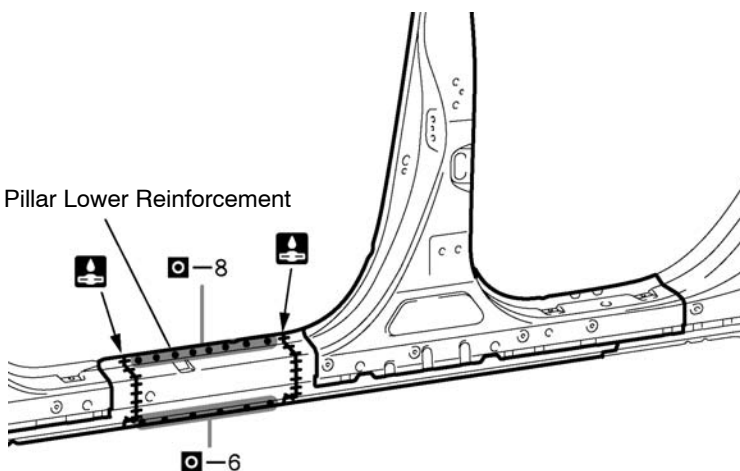
## Symbol meaning

 : MIG Plug Weld    
  : Cut and Join Location    
  : Butt Weld

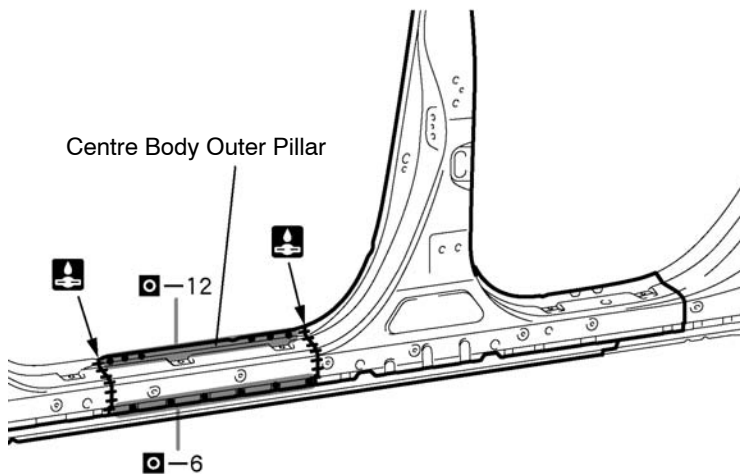
F25730B

## INSTALLATION

Centre Body Pillar Lower Reinforcement



Centre Body Outer Pillar



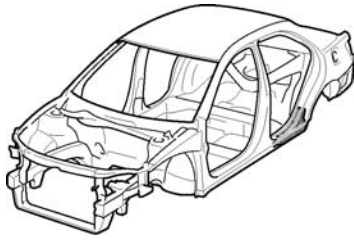
mm (in.)

F25730

## 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 After welding the centre body pillar lower reinforcement to the vehicle side, install the centre body outer pillar.
- 4 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

# ROCKER OUTER REINFORCEMENT (ASSY)



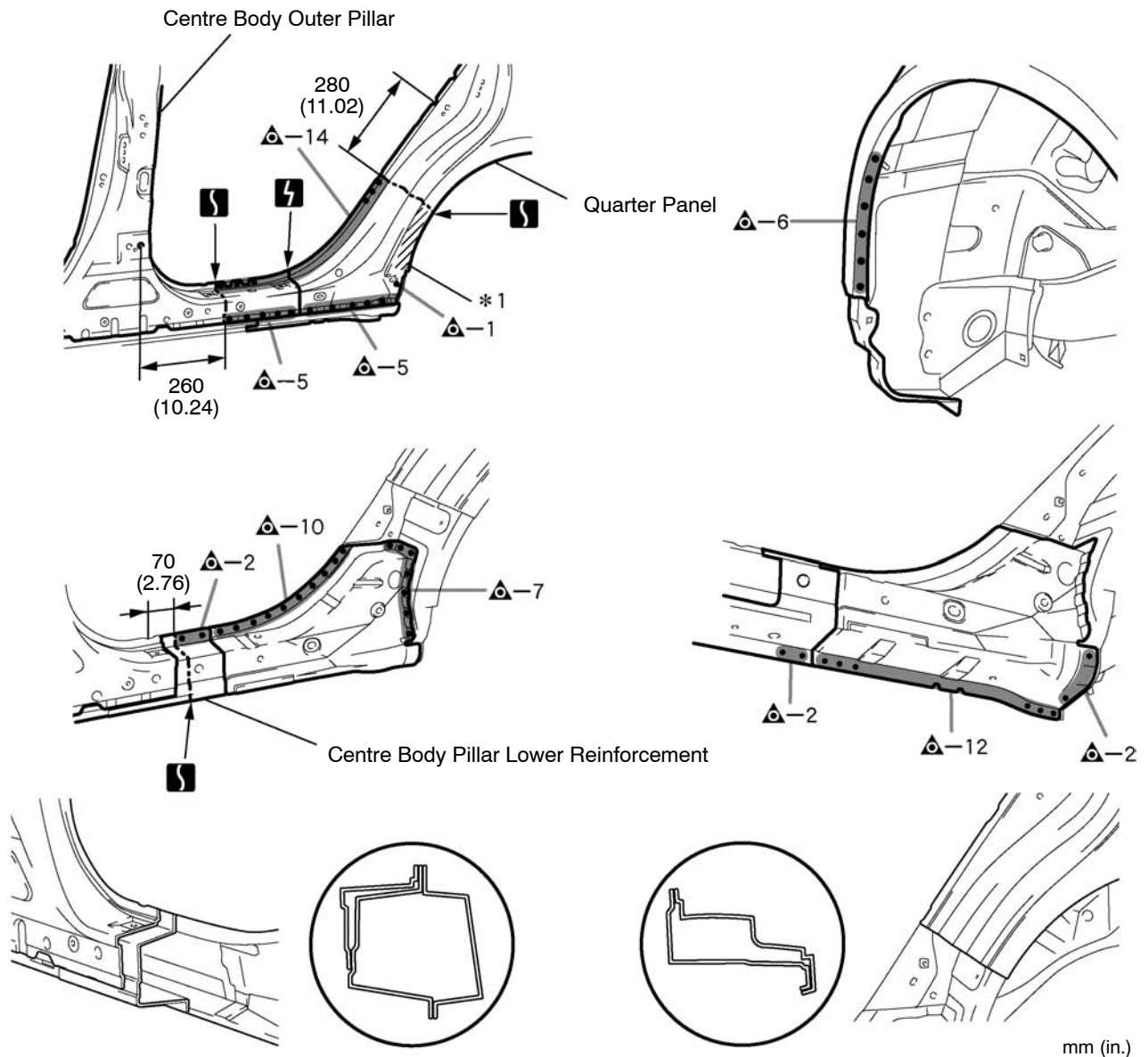
F25733A

## Symbol meaning

△ : Remove Weld Points    S : Cut and Join Location    ⚡ : Cut Location for Supply Parts

F25733B

## REMOVAL






F25733

## INSTALLATION POINT

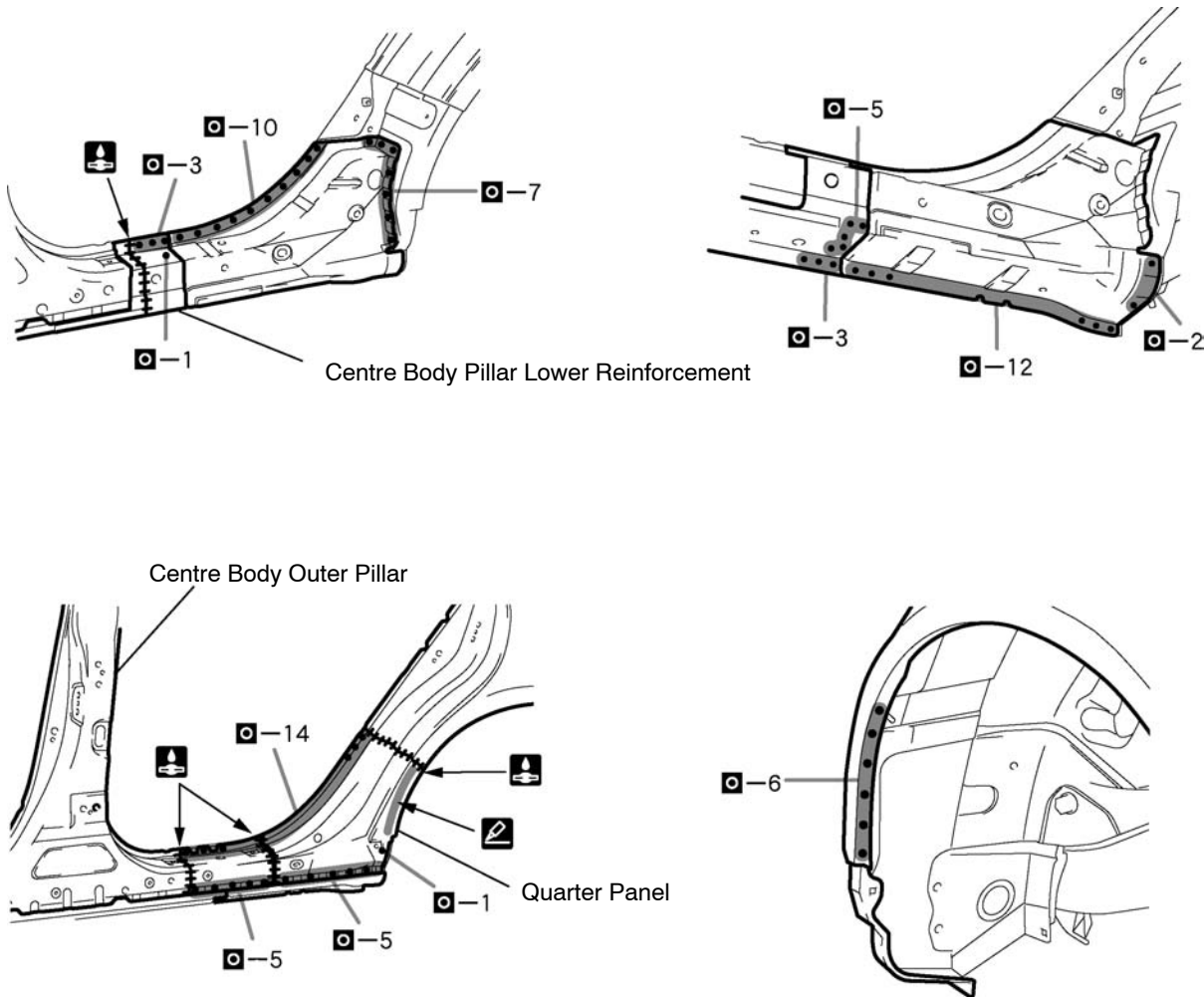
- 1 \*1 in illustration above indicates where the adhesive is located.
- 2 After removing the centre body outer pillar and quarter panel, remove the rocker outer reinforcement and centre body pillar lower reinforcement.

## Symbol meaning

 : MIG Plug Weld    
  : Butt Weld    
  : Body Sealer

F25734B

## INSTALLATION

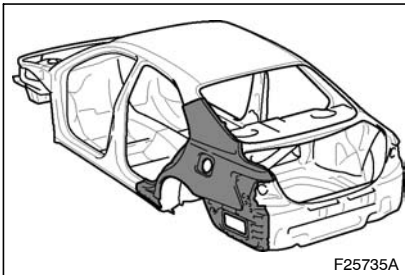


F25734

## 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 installing a new part, apply body sealer.  
**HINT:**  
 1) *Apply sealer in an even, continuous bead.*
- 4 After welding the rocker outer reinforcement to the vehicle side, install the centre body outer pillar and quarter panel.
- 5 After welding, apply body sealer and undercoating to the corresponding parts. ([See the paint-coating](#))
- 6 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

## QUARTER PANEL (CUT)




### Quarter Panel Replacement Using Adhesive


Work Procedure	Precaution
<ol style="list-style-type: none"> <li>1 Cut the wheel arch portion.</li> <li>2 Heat the quarter panel adhesive area and remove the quarter panel.</li> <li>3 Clean off any adhesive that remains on the vehicle.</li> <li>4 Using a disc grinder or belt sander, scuff and sand any adhesive that remains on the vehicle.</li> <li>5 Apply adhesive to the exposed metal areas on the vehicle. Using a spatula, spread the adhesive evenly. Specification: 3M Automix™ Panel Bonding Adhesive #8115</li> <li>6 Apply adhesive to the vehicle again.</li> <li>7 Using #60-240 grit sandpaper, scuff the adhesive application area on the new quarter panel.</li> <li>8 Apply adhesive to the new quarter panel. Using a spatula, spread the adhesive evenly.</li> <li>9 Using a clamp or the palms of your hands, press the quarter panel so that the thickness of the adhesive is even.</li> <li>10 Complete installation the new quarter panel.</li> <li>11 Dry the adhesive areas of the new quarter panel.</li> </ol>	<ol style="list-style-type: none"> <li>(1) Using an industrial dryer or oxygen acetylene burner, heat the quarter panel to 110 to 140°C. Make sure the quarter panel does not warp.</li> <li>(1) Using an industrial dryer or oxygen acetylene burner, heat the adhesive to 110 to 140°C.</li> <li>(2) Using a scraper, scrape away the adhesive.</li> <li>(3) If adhesive remains, the strength of any subsequently applied adhesive will be weak.</li> <li>(1) Scuff at a width of approximately 10 mm over the previous adhesive coating.</li> <li>(1) Hardening Time Estimation With dryer or equivalent (60°C) : 60 minutes (complete hardening: 90 minutes) Ambient temperature (25°C) : 12 hours (complete hardening: 24 hours)</li> </ol>





## Symbol meaning

△ △ △ : Remove Weld Points

 : Cut with disc sander, etc.

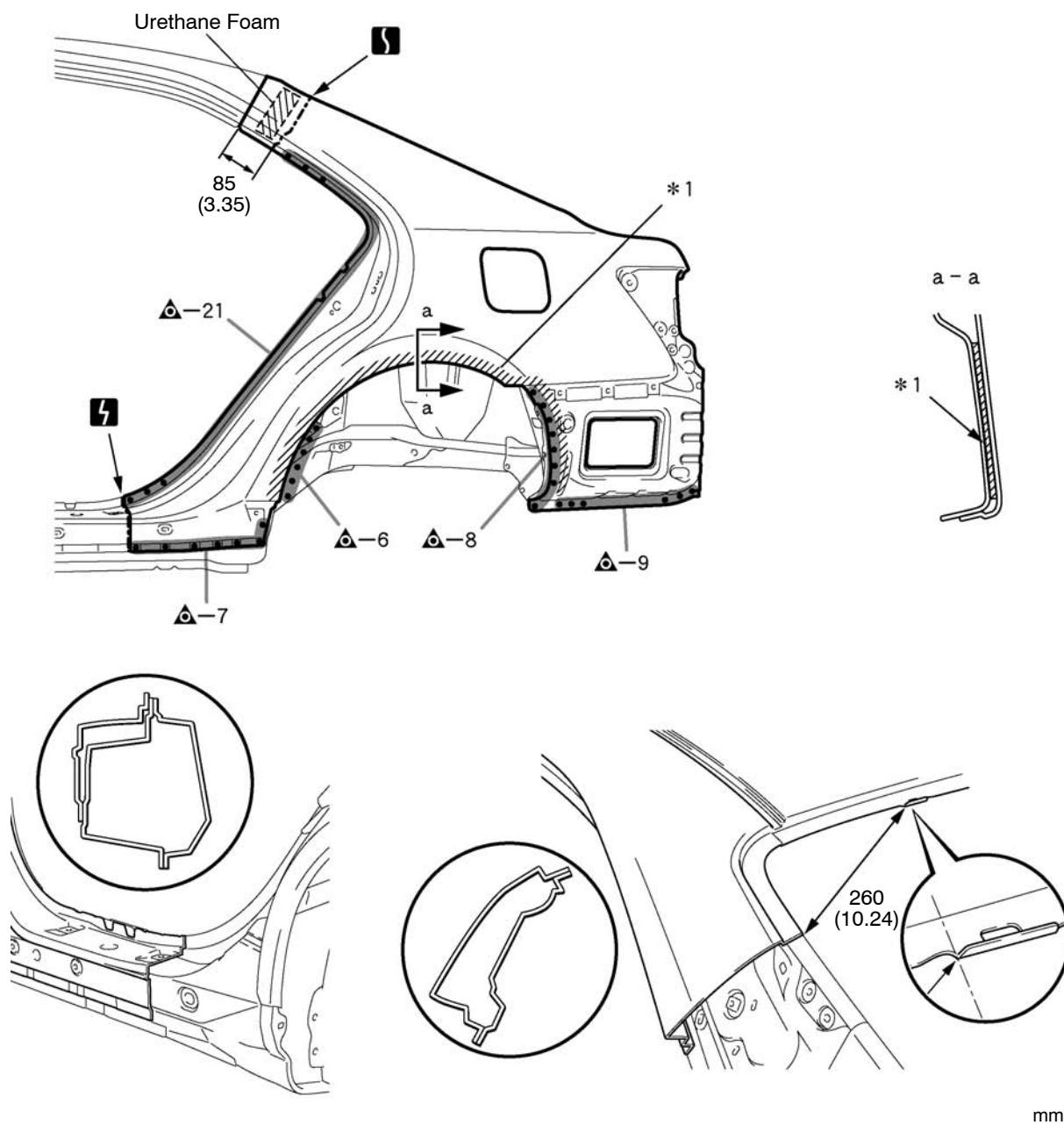
 : Cut and Join Location

 : Cut Location for Supply Parts

 : Braze

F25735B

## REMOVAL



F25735








## REMOVAL POINT

- 1 \*1 in illustration above indicates where the adhesive is located.
- 2 Roughly cut open the wheel arch of the panel so that the adhesive can be reached. Cut through the adhesive with a cut chisel to remove the panel.

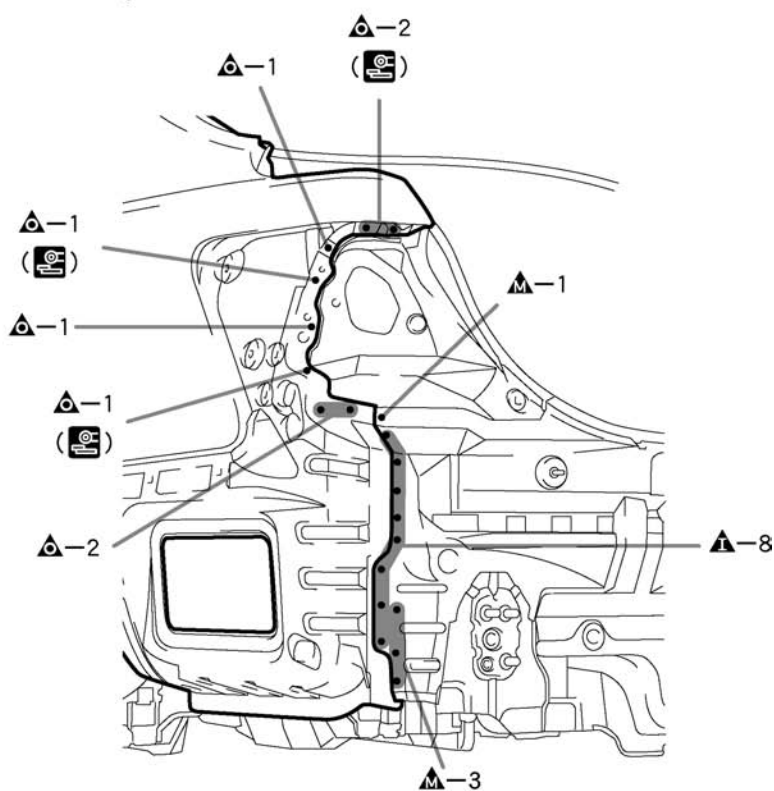
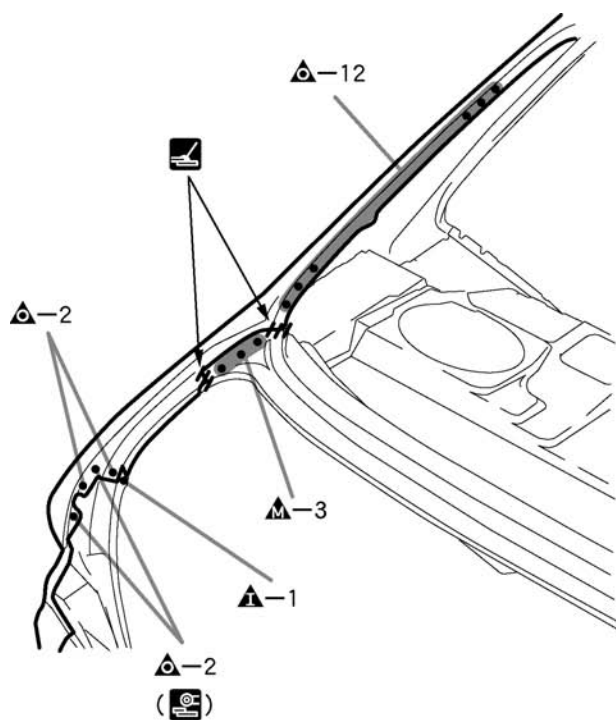
## HINT:

- 1) If the cut chisel cannot reach the adhesive, heat the adhesive with a heat gun, oxygen-acetylene burner. When heating, do not deform the quarter housing outer panel.

Symbol meaning

-    : Remove Weld Points
  : Cut with disc sander, etc.
  : Cut Location for Supply Parts
  : Cut and Join Location
  : Braze

F25735B



F25736

## Symbol meaning

⊙ : Spot Weld

□ M I : MIG Plug Weld

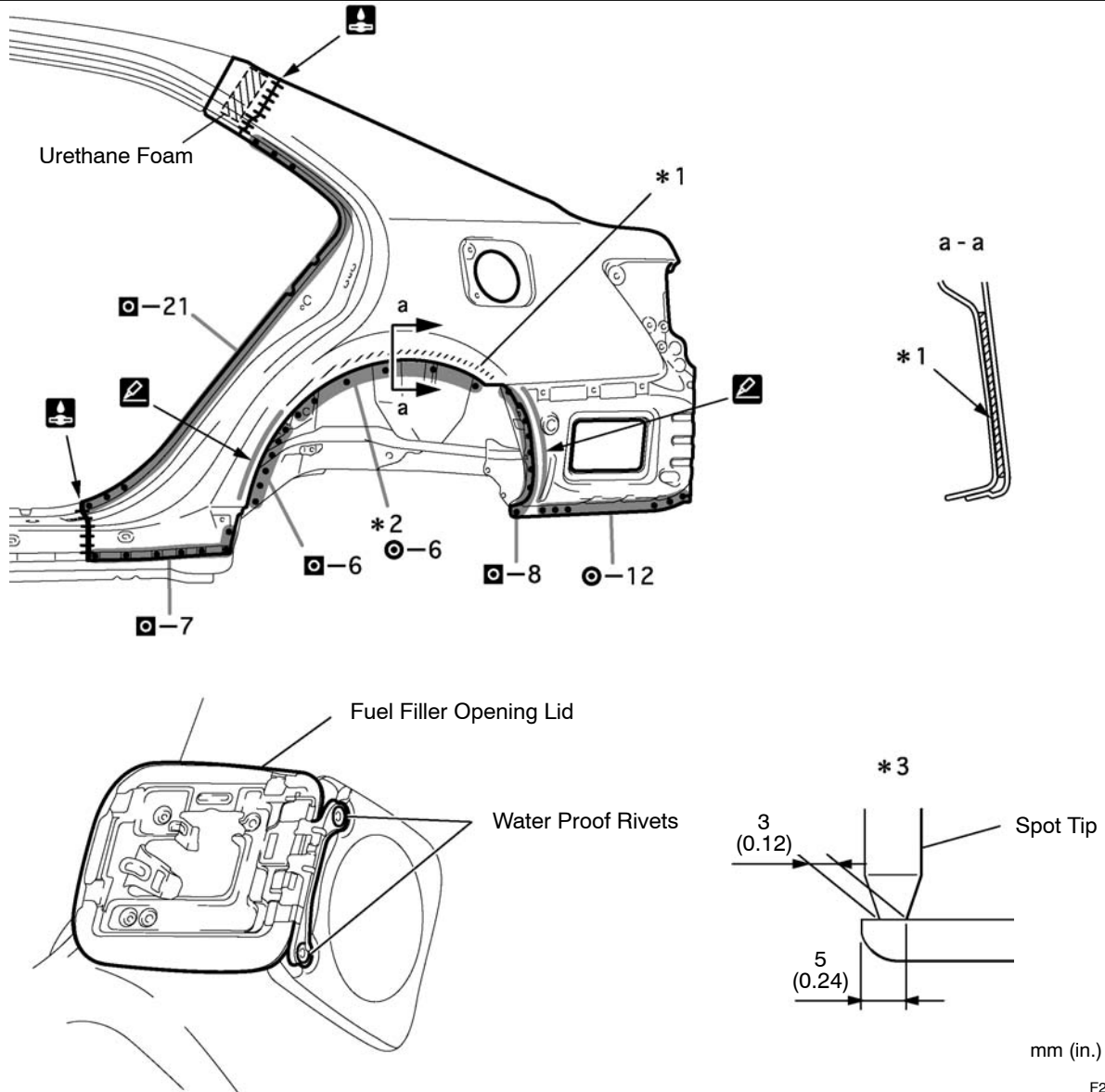
⌞ : Butt Weld

▨ : Body Sealer

⌞ : Braze

F25737B

## INSTALLATION



F26354

## 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 Apply adhesive(3M™ Automix™ Panel Bonding Adhesive #8115) to the area indicated by \*1 in illustration.  
*HINT:*  
1) Apply enough adhesive for the panels to stick to each other.
- 4 Perform spot-welding on the flange indicated by \*2 in the illustration. Modify/cut the spot tip as shown in the illustration (\*3) so that it can fit in to the narrow flange.
- 5 Before installing a new part, apply body sealer.  
*HINT:*  
1) Apply sealer in an even, continuous bead.

## Symbol meaning

○ : Spot Weld

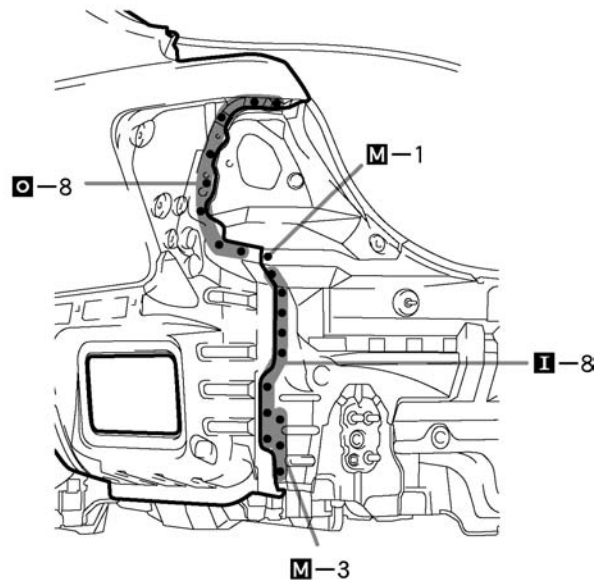
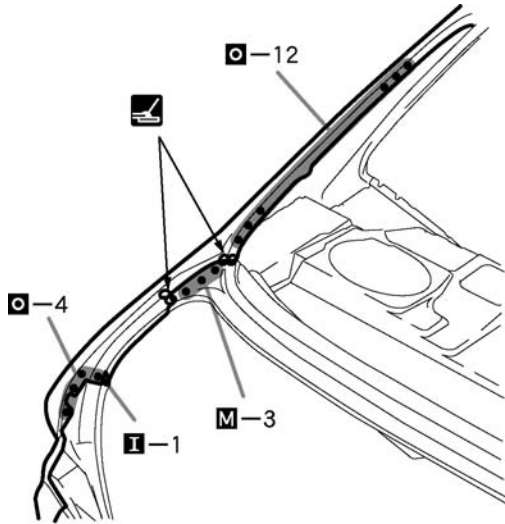
◻ M I : MIG Plug Weld

☐ : Butt Weld

▨ : Body Sealer

▩ : Braze

F25737B

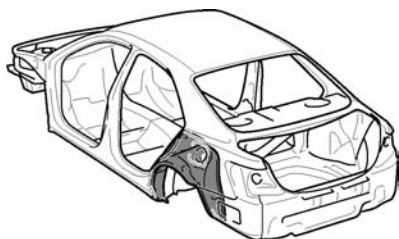


F25738

**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 After welding, apply polyurethane foam to the corresponding parts. ([See the paint-coating](#))
- 4 After welding, apply body sealer and undercoating to the corresponding parts. ([See the paint-coating](#))
- 5 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

# QUARTER WHEEL HOUSING OUTER PANEL (ASSY)



F25797A

With the quarter panel removed.

## Symbol meaning

REMOVAL      △ △ △ : Remove Weld Points

INSTALLATION      ◻ M I : MIG Plug Weld

⊙ : Cut with disc sander, etc.

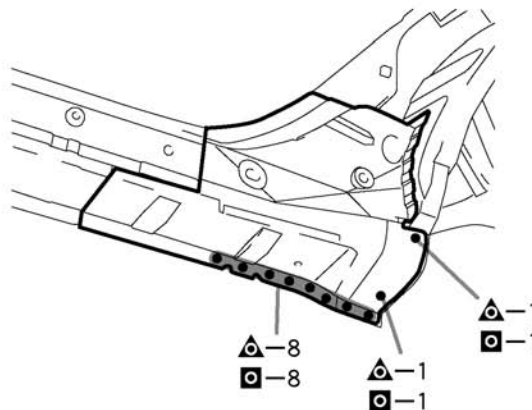
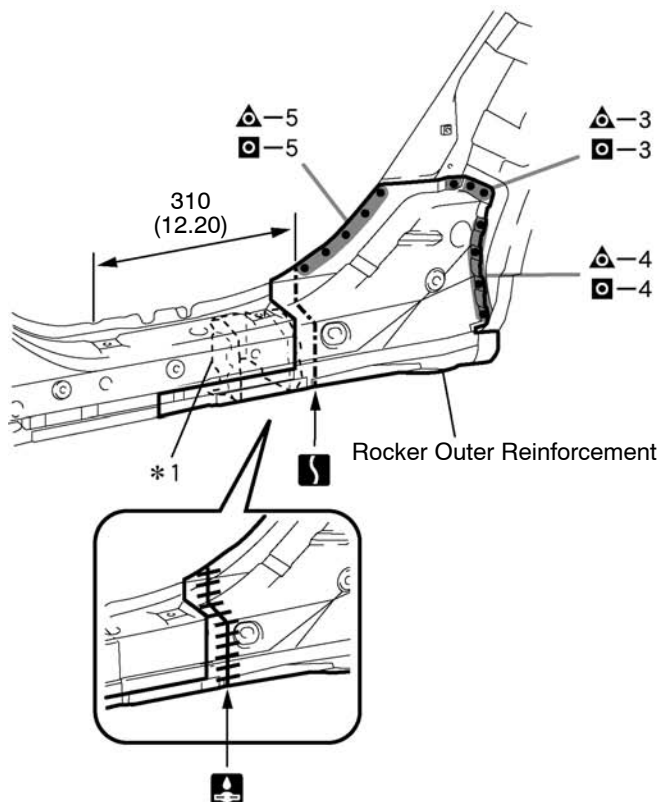
⌋ : Cut and Join Location

⌋ : Tack Weld      ⌋ : Butt Weld

F25797B

## REMOVAL·INSTALLATION

[LH]



mm (in.)

F25797

### REMOVAL POINT

- 1 \*1: Take care not to damage the internal reinforcement.
- 2 After removing the rocker outer reinforcement, remove the quarter wheel housing outer panel.

### INSTALLATION POINT

- 1 After welding the quarter wheel housing outer panel to the vehicle side, install the rocker outer reinforcement.

Symbol meaning

REMOVAL

△ △ △ : Remove Weld Points

INSTALLATION

○ M I : MIG Plug Weld

⊖ : Cut with disc sander, etc.

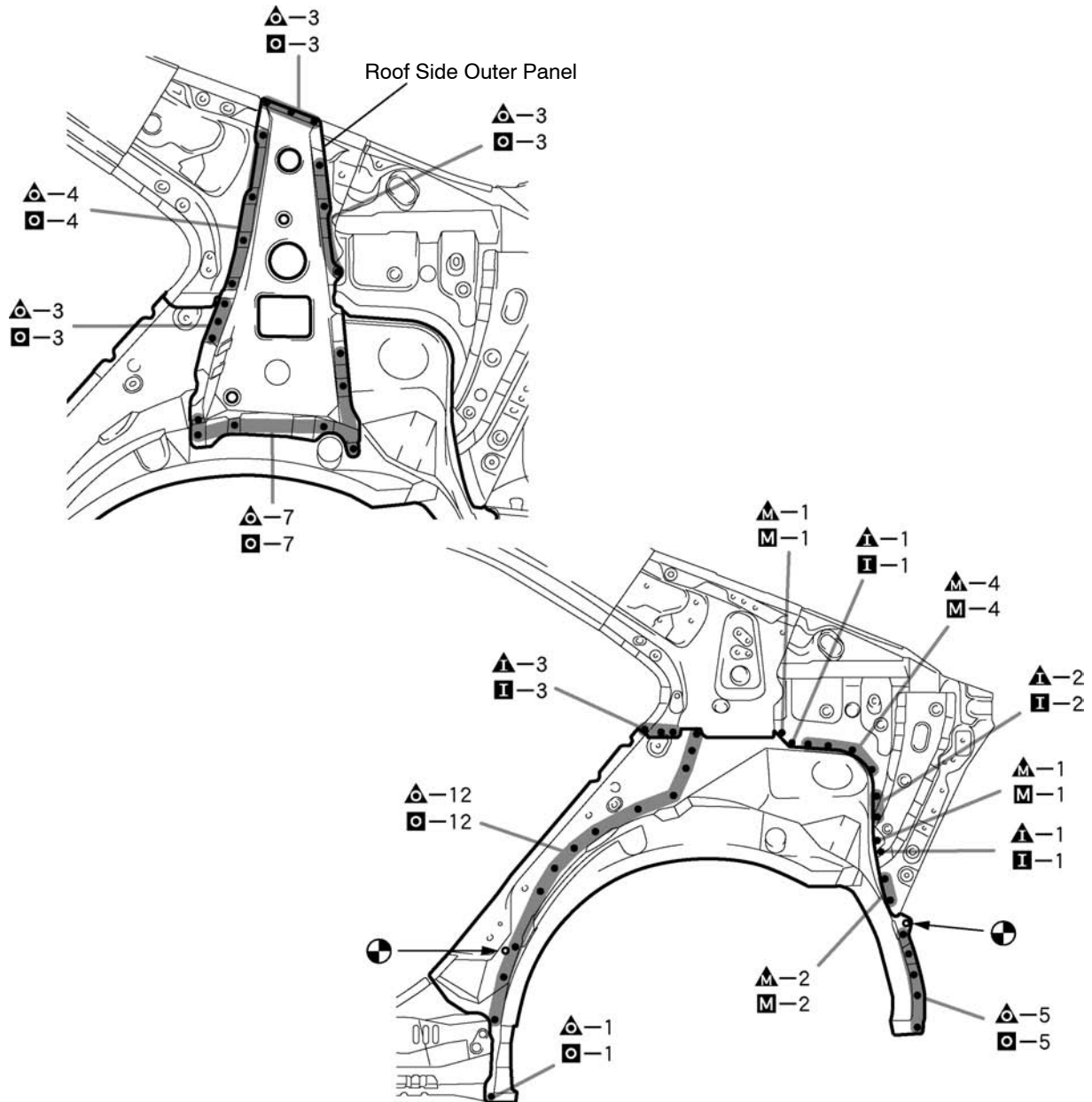
⌋ : Cut and Join Location

⌋ : Tack Weld

⌋ : Butt Weld

F25797B

[LH]



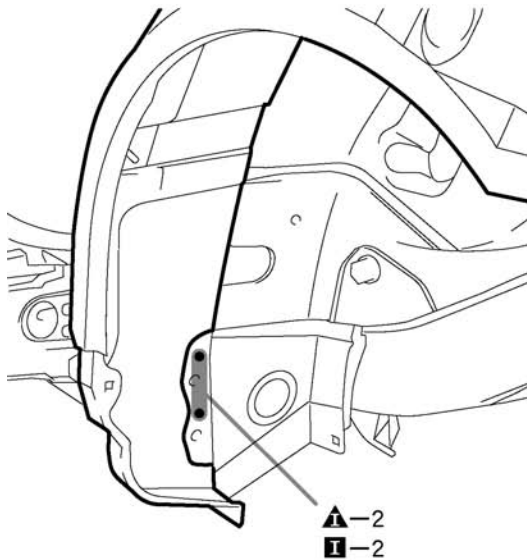
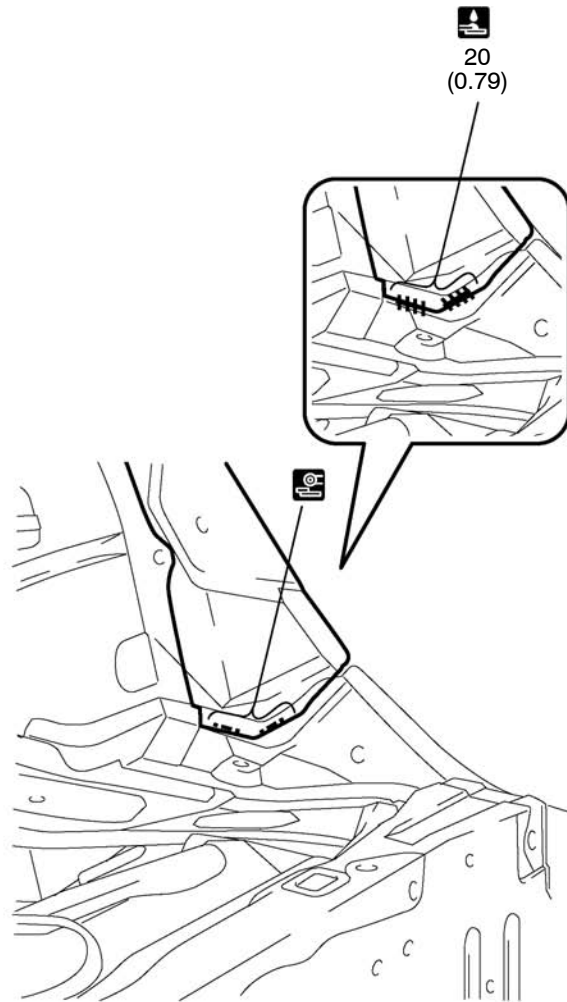
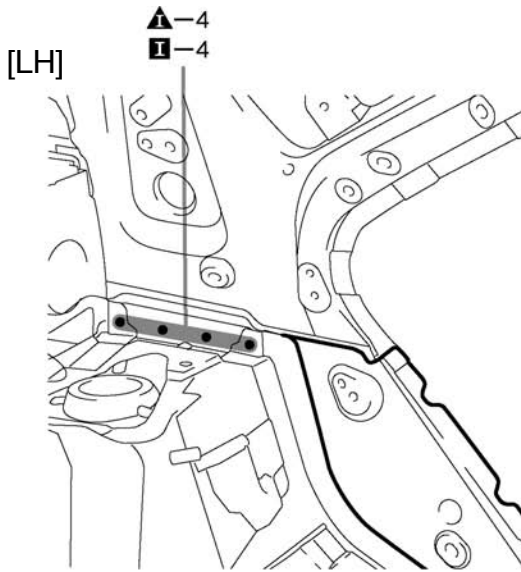
F25798

**REMOVAL POINT**

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

**INSTALLATION POINT**

1 After welding the quarter wheel housing outer panel to the vehicle side, install the roof side outer panel.



mm (in.)

F25799

**INSTALLATION POINT**

- 1 After welding, apply body sealer and undercoating to the corresponding parts. ([See the paint coating](#))
- 2 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.



Symbol meaning

REMOVAL

△ △ △ : Remove Weld Points

INSTALLATION

○ M I : MIG Plug Weld

⊖ : Cut with disc sander, etc.

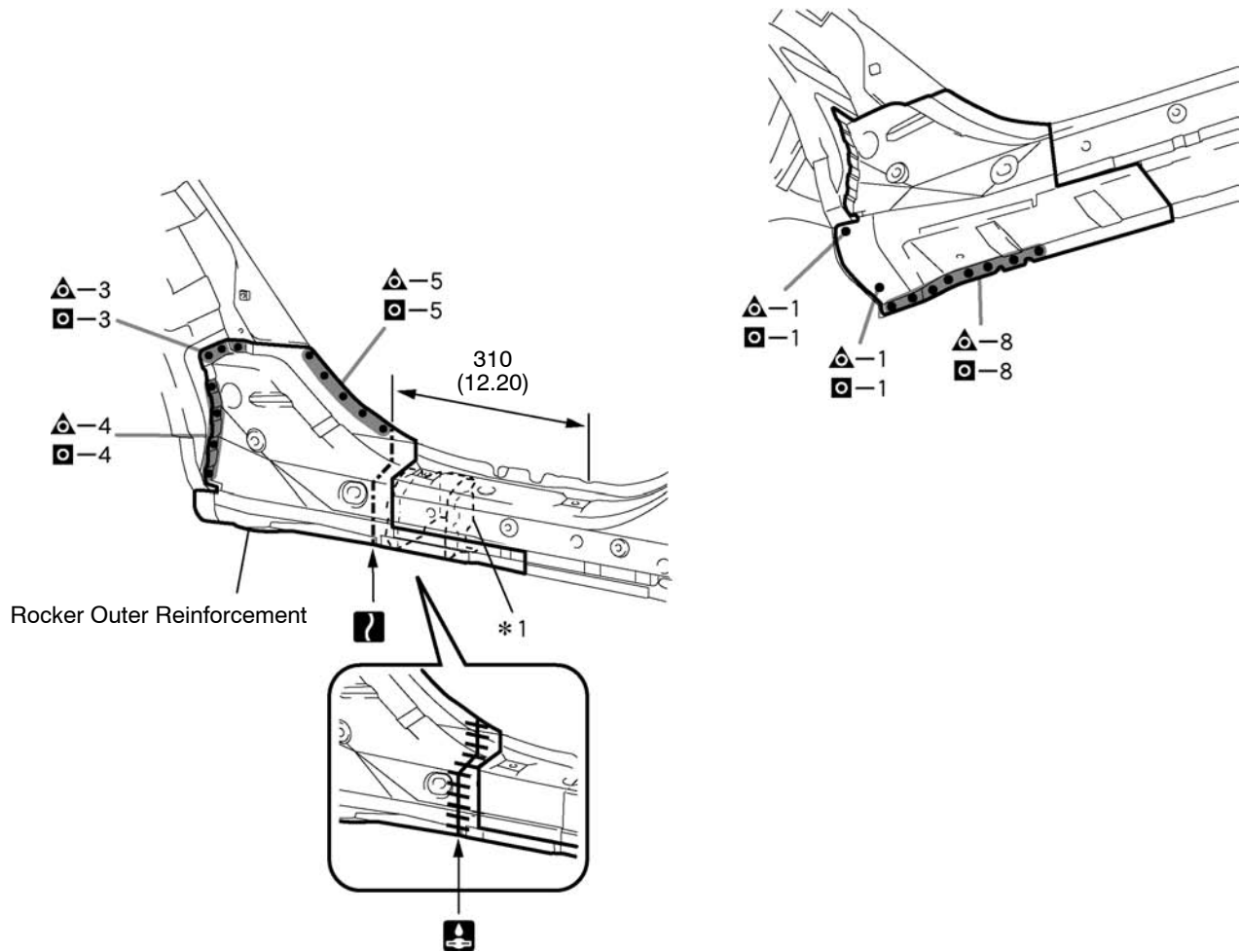
⌋ : Cut and Join Location

⊕ : Tack Weld

⊕ : Butt Weld

F25797B

[RH]



mm (in.)

F25800

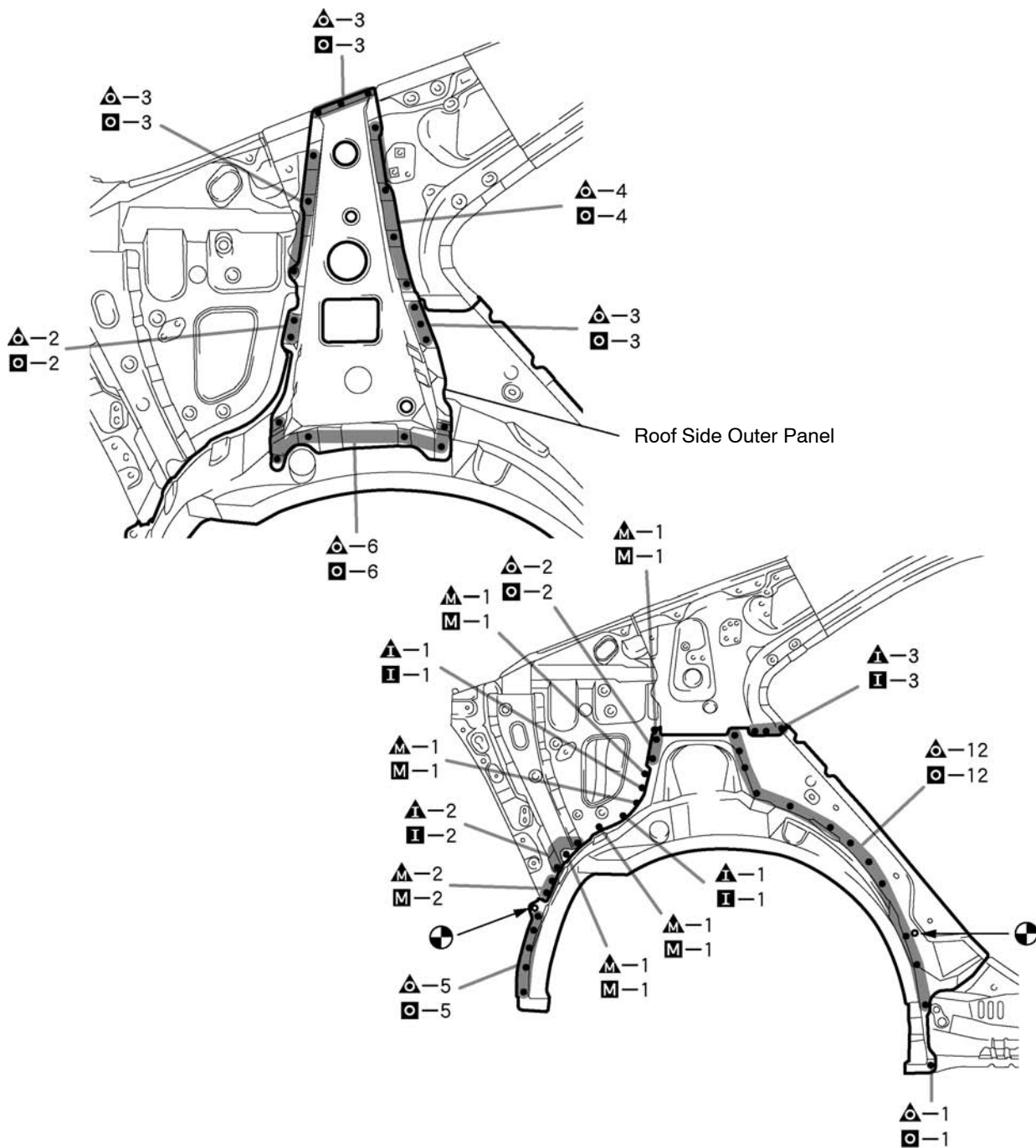
**REMOVAL POINT**

- 1 \*1: Take care not to damage the internal reinforcement.
- 2 After removing the rocker outer reinforcement, remove the quarter wheel housing outer panel.

**INSTALLATION POINT**

- 1 After welding the quarter wheel housing outer panel to the vehicle side, install the rocker outer reinforcement.

[RH]



F25801

**REMOVAL POINT**

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

**INSTALLATION POINT**

- 1 After welding the quarter wheel housing outer panel to the vehicle side, install the roof side outer panel.

Symbol meaning

REMOVAL

△ △ △ : Remove Weld Points

INSTALLATION ○ M I : MIG Plug Weld

⊖ : Cut with disc sander, etc.

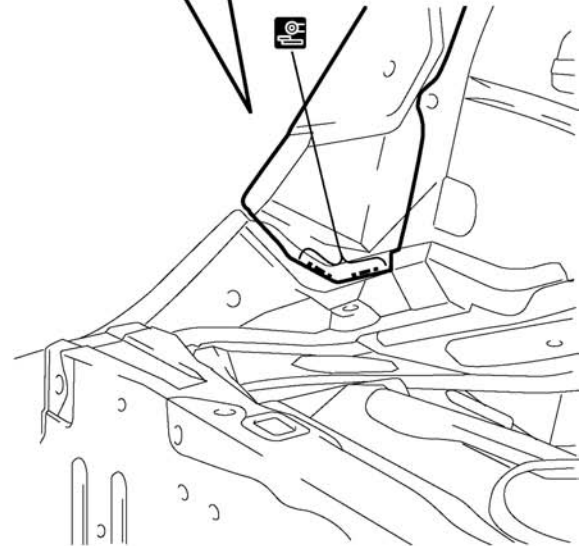
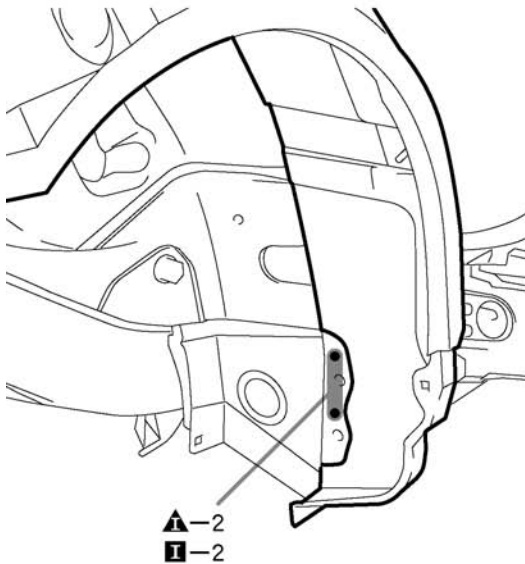
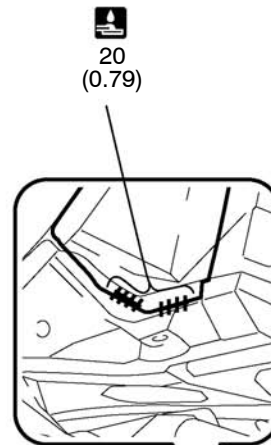
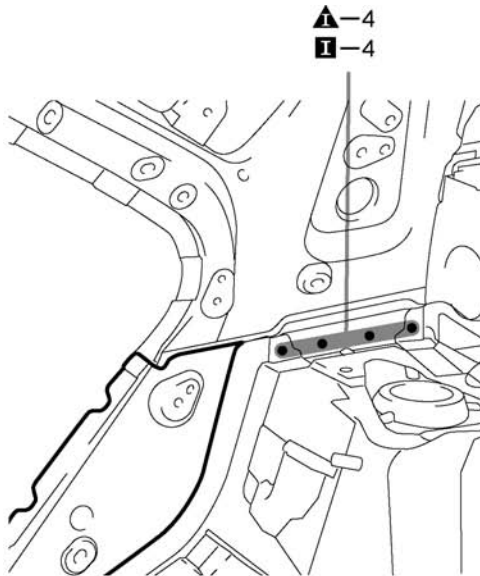
⌋ : Cut and Join Location

⌋ : Tack Weld

⌋ : Butt Weld

F25797B

[RH]



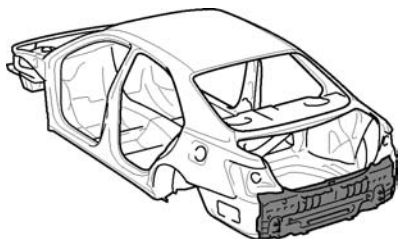
mm (in.)

F25802

INSTALLATION POINT

- 1 After welding, apply body sealer and undercoating to the corresponding parts. (See the paint-coating)
- 2 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

## BODY LOWER BACK PANEL (ASSY)



F25743A

### Symbol meaning

REMOVAL

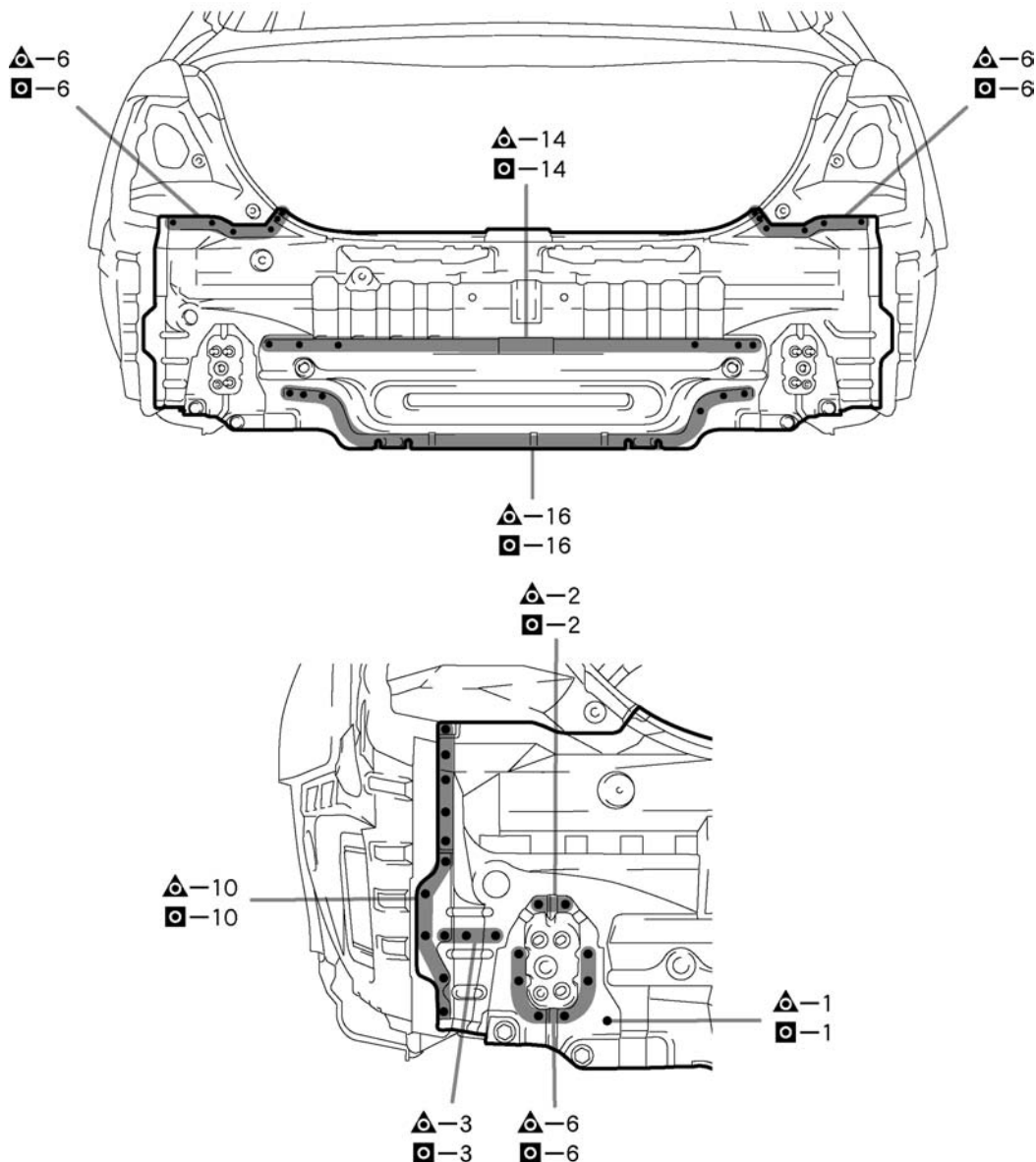
△ : Remove Weld Points

INSTALLATION

◻ : MIG Plug Weld

F25743B

### REMOVAL-INSTALLATION

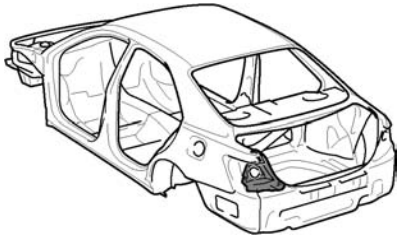


F25743

### 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 After welding, apply body sealer and undercoating to the corresponding parts. ([See the paint-coating](#))
- 4 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

## QUARTER PANEL END HOUSING (ASSY)



F25745A

### Symbol meaning

REMOVAL



: Remove Weld Points



: Cut with disc sander, etc.

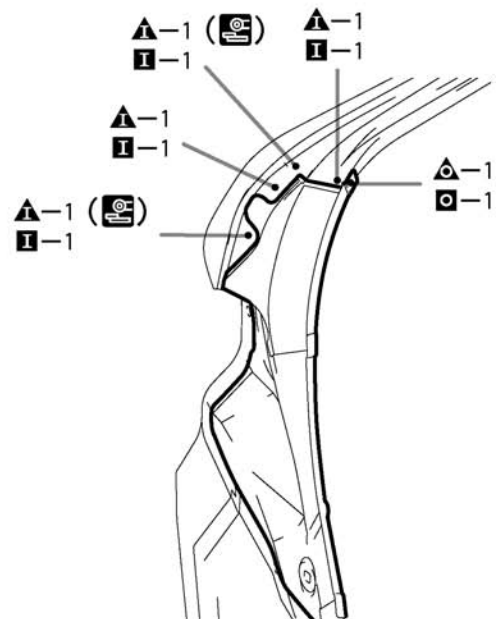
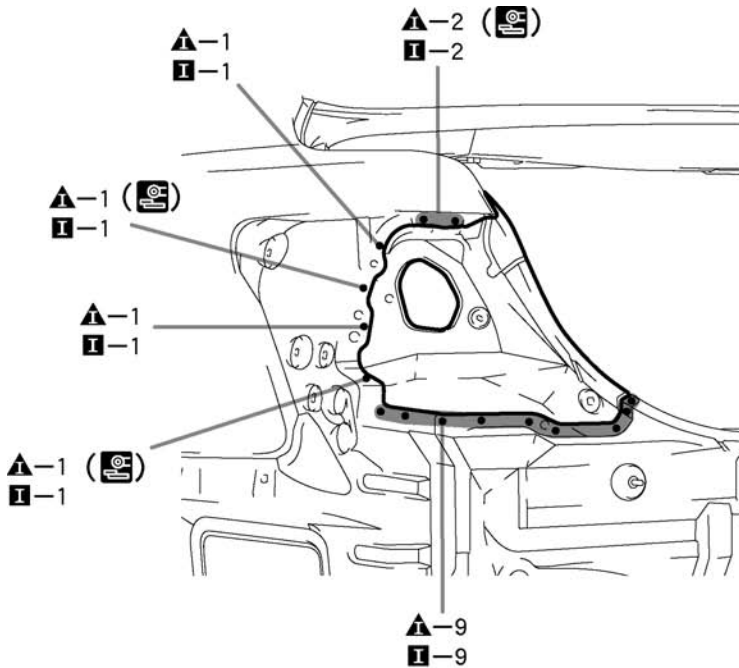
INSTALLATION



: MIG Plug Weld

F25745B

### REMOVAL-INSTALLATION

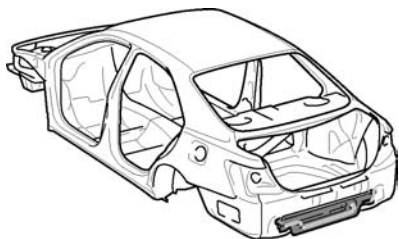


F25745

### 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 After welding, apply body sealer to the corresponding parts. ([See the paint coating](#))
- 4 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

## REAR FLOOR NO. 3 CROSSMEMBER (ASSY)



F25746A

With the body lower back panel removed.

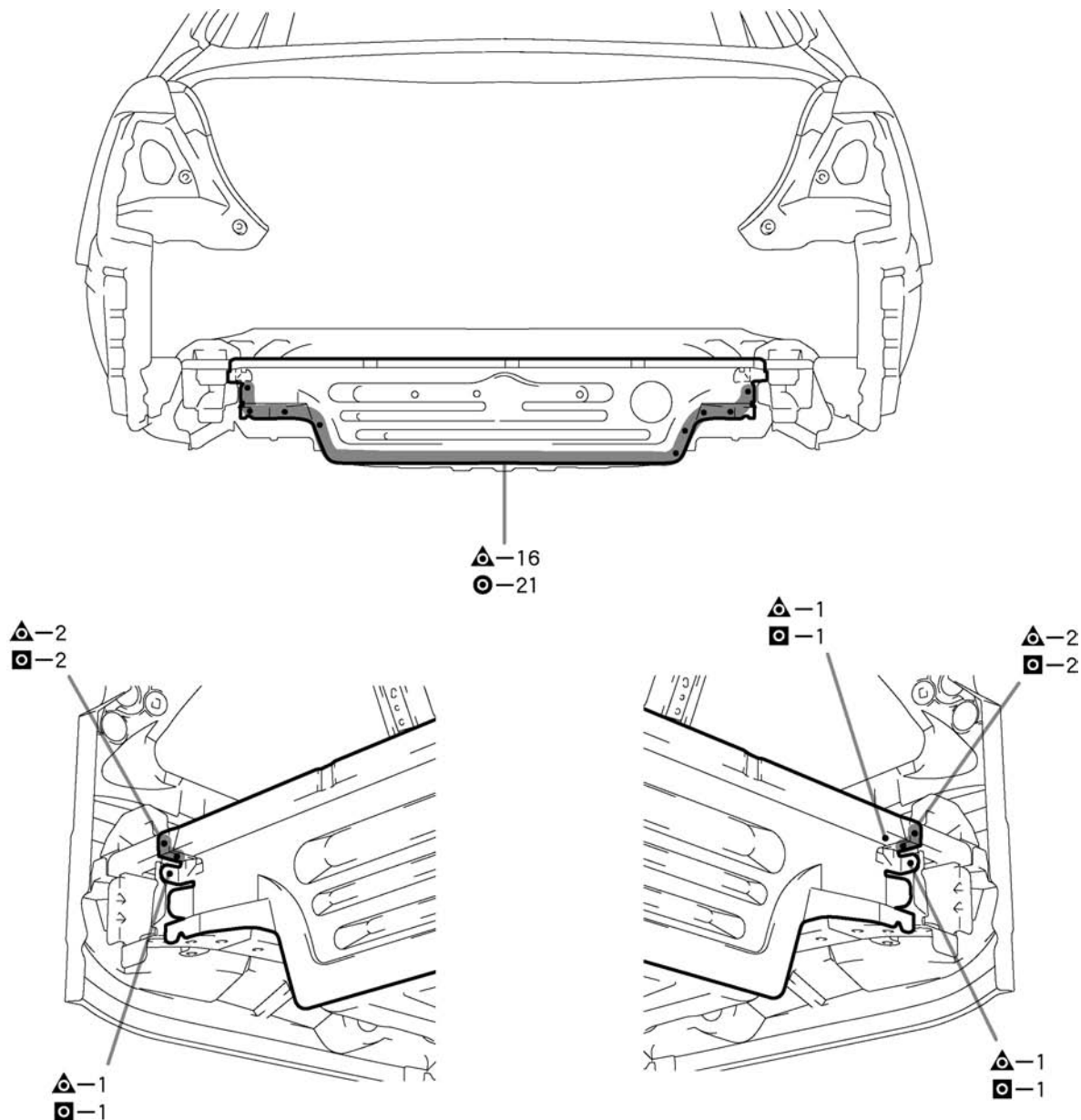
### Symbol meaning

REMOVAL      ▲ : Remove Weld Points

INSTALLATION      ● : Spot Weld      ◻ : MIG Plug Weld

F25746B

### REMOVAL·INSTALLATION

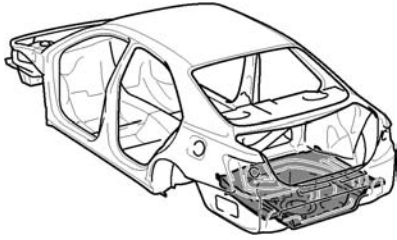


F25746

### INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 After welding, apply body sealer and undercoating to the corresponding parts. ([See the paint coating](#))
- 3 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

## REAR FLOOR PAN (ASSY)



F25747A

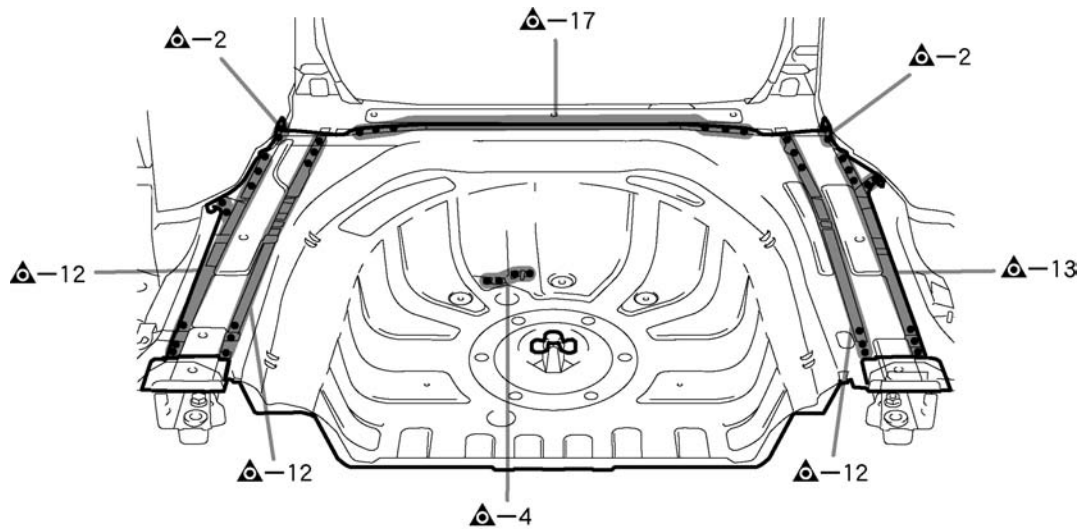
With the rear floor no.3 crossmember removed.

### Symbol meaning

△ △ △ : Remove Weld Points

F25747B

### REMOVAL



### Rear Floor Pan Reinforcement



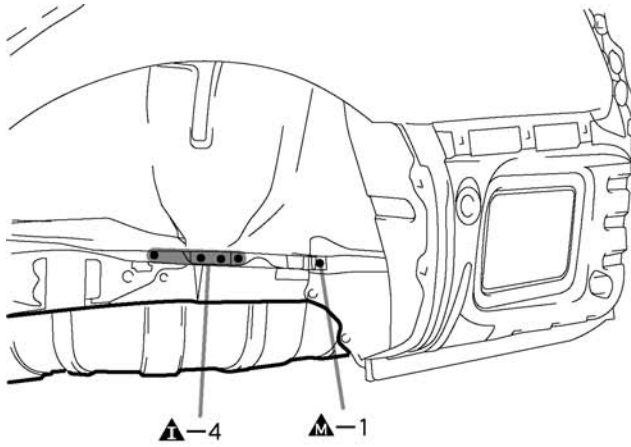
F25747

### REMOVAL POINT

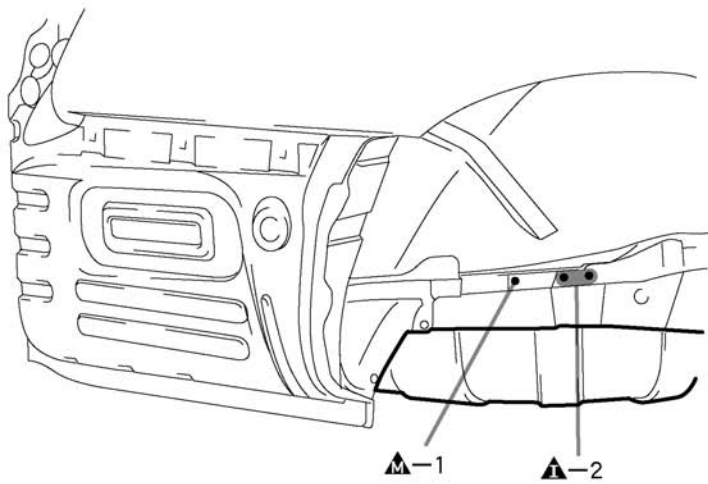
- 1 Remove the rear floor pan reinforcement at the same time.



[LH]



[RH]

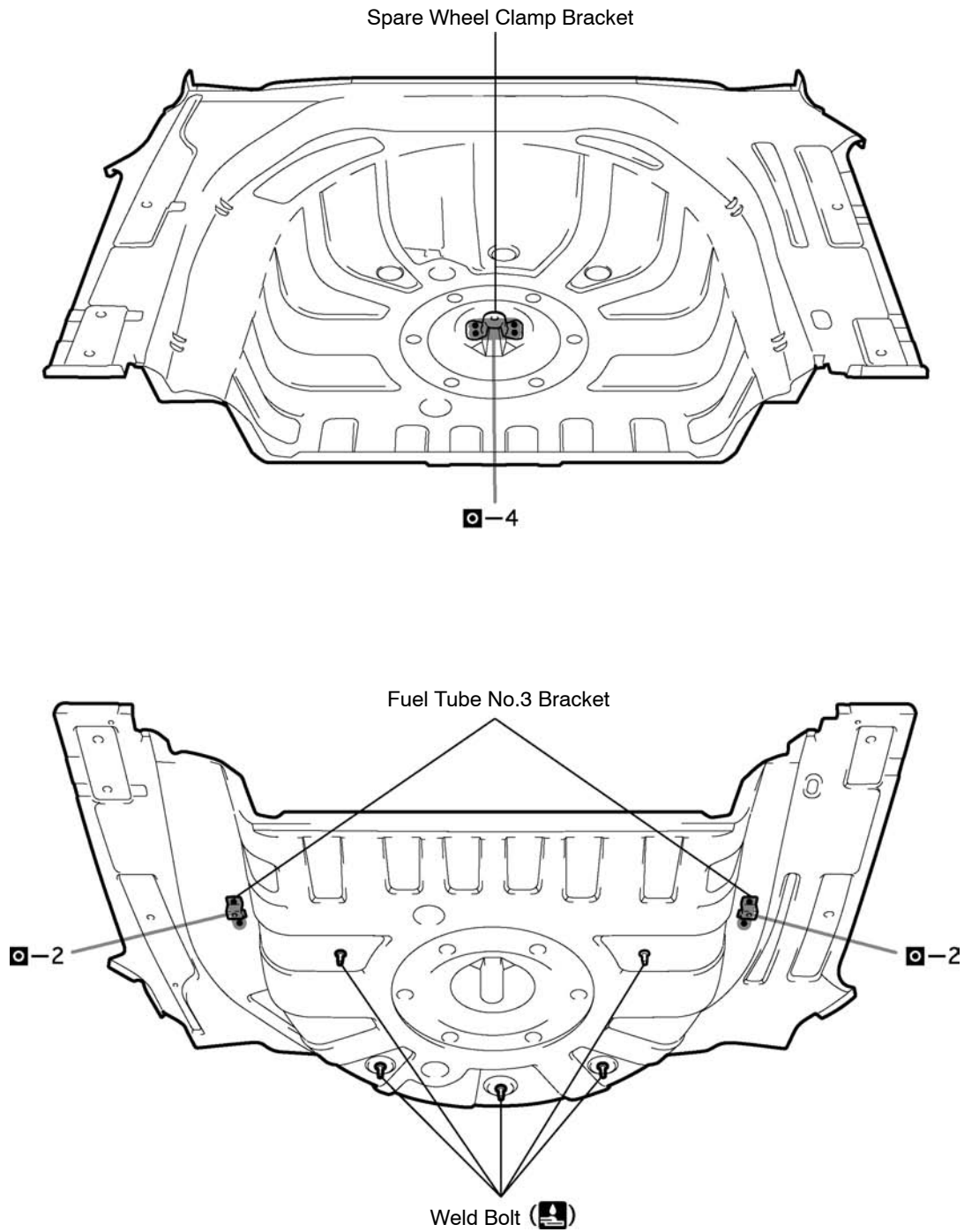


## Symbol meaning

 **M** **I** : MIG Plug Weld    
  : Tack Weld

F25749B

## INSTALLATION

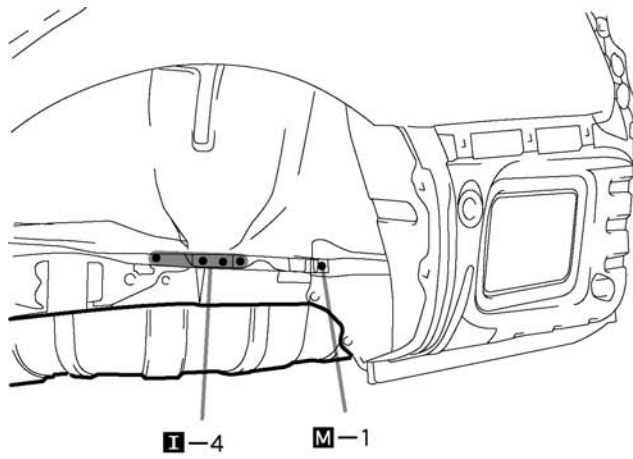


F26452

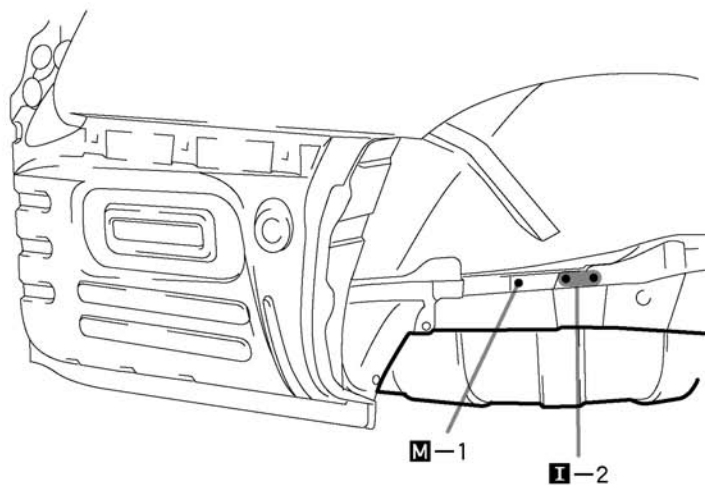
## INSTALLATION POINT

- 1 Before temporarily installing the new parts, weld the spare wheel clamp bracket and fuel tube No.3 bracket with the standard number of welding points.

[LH]



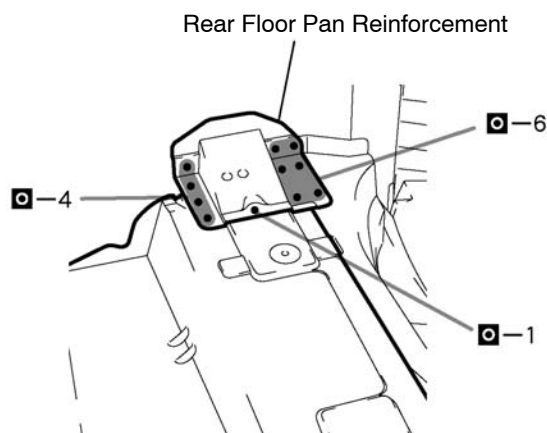
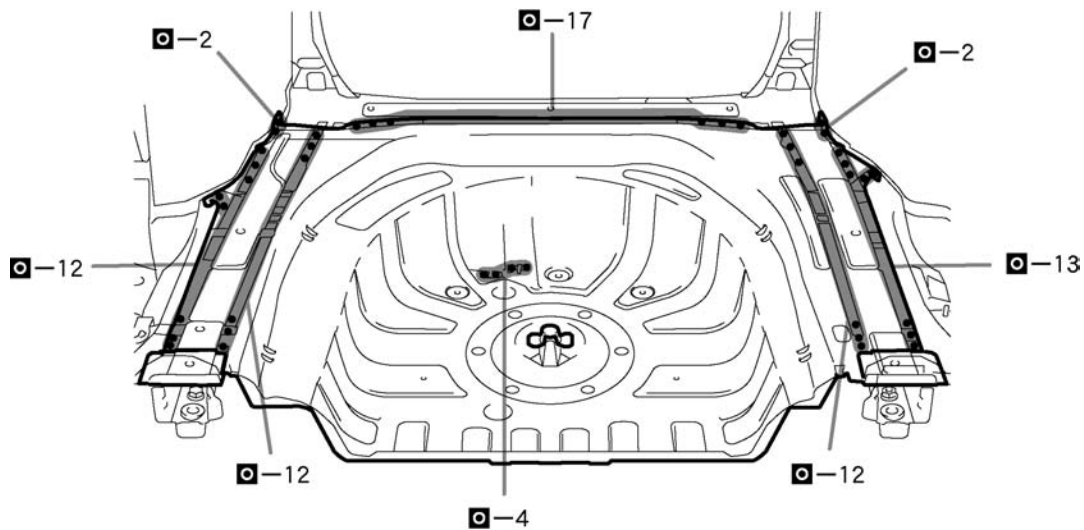
[RH]



## Symbol meaning

 **M** **I** : MIG Plug Weld    
  : Tack Weld

F25749B

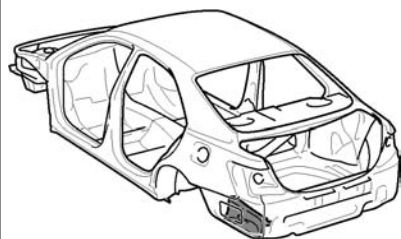


F25803

**INSTALLATION POINT**

- 1 After welding, apply body sealer and undercoating to the corresponding parts. ([See the paint-coating](#))
- 2 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

## REAR FLOOR SIDE PANEL (ASSY)



F25750A

With the rear floor pan removed.

### Symbol meaning

REMOVAL

△ △ : Remove Weld Points

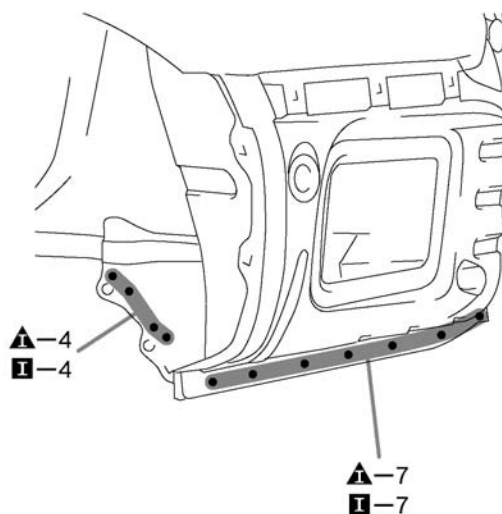
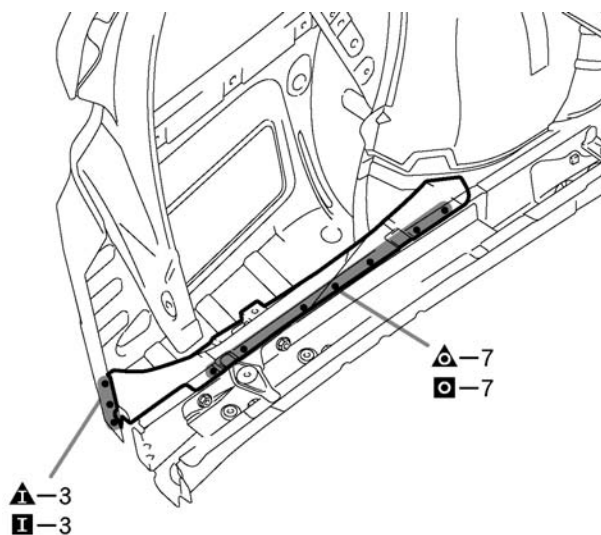
INSTALLATION

□ I : MIG Plug Weld

F25750B

### REMOVAL·INSTALLATION

[LH]



F25750

### INSTALLATION POINT

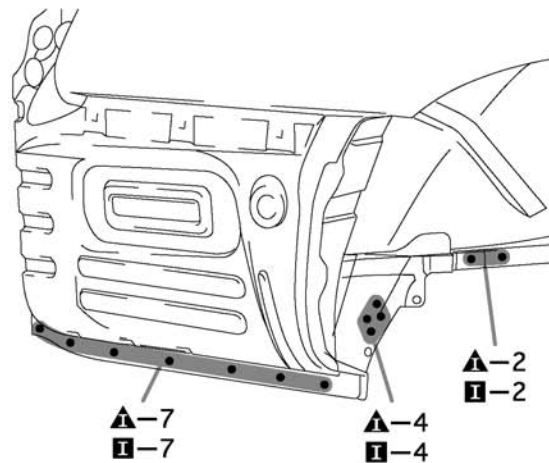
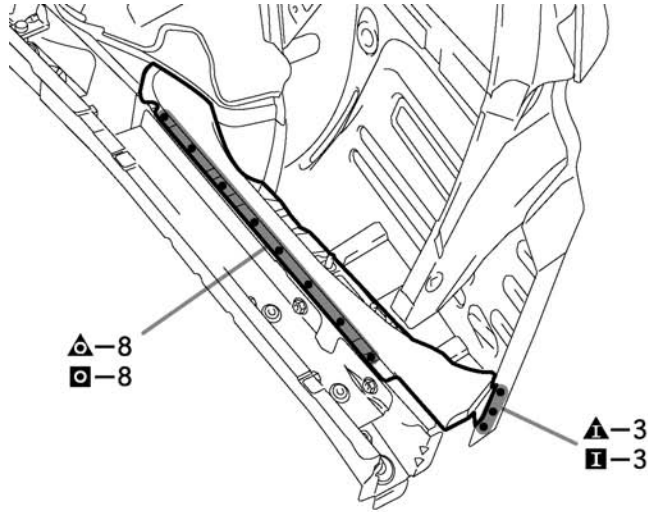
- 1 After welding, apply body sealer and undercoating to the corresponding parts. ([See the paint coating](#))
- 2 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

## Symbol meaning

REMOVAL        : Remove Weld PointsINSTALLATION        : MIG Plug Weld

F25750B

[RH]

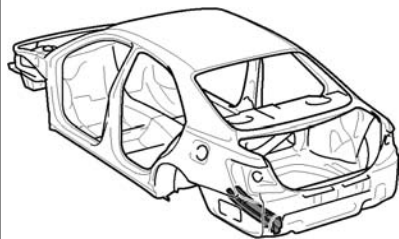


F26463

**INSTALLATION POINT**

- 1 After welding, apply body sealer and undercoating to the corresponding parts. ([See the paint-coating](#))
- 2 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

## REAR FLOOR SIDE REAR MEMBER (ASSY)



F25752A

With the rear floor no.3 crossmember removed.

### Symbol meaning

REMOVAL

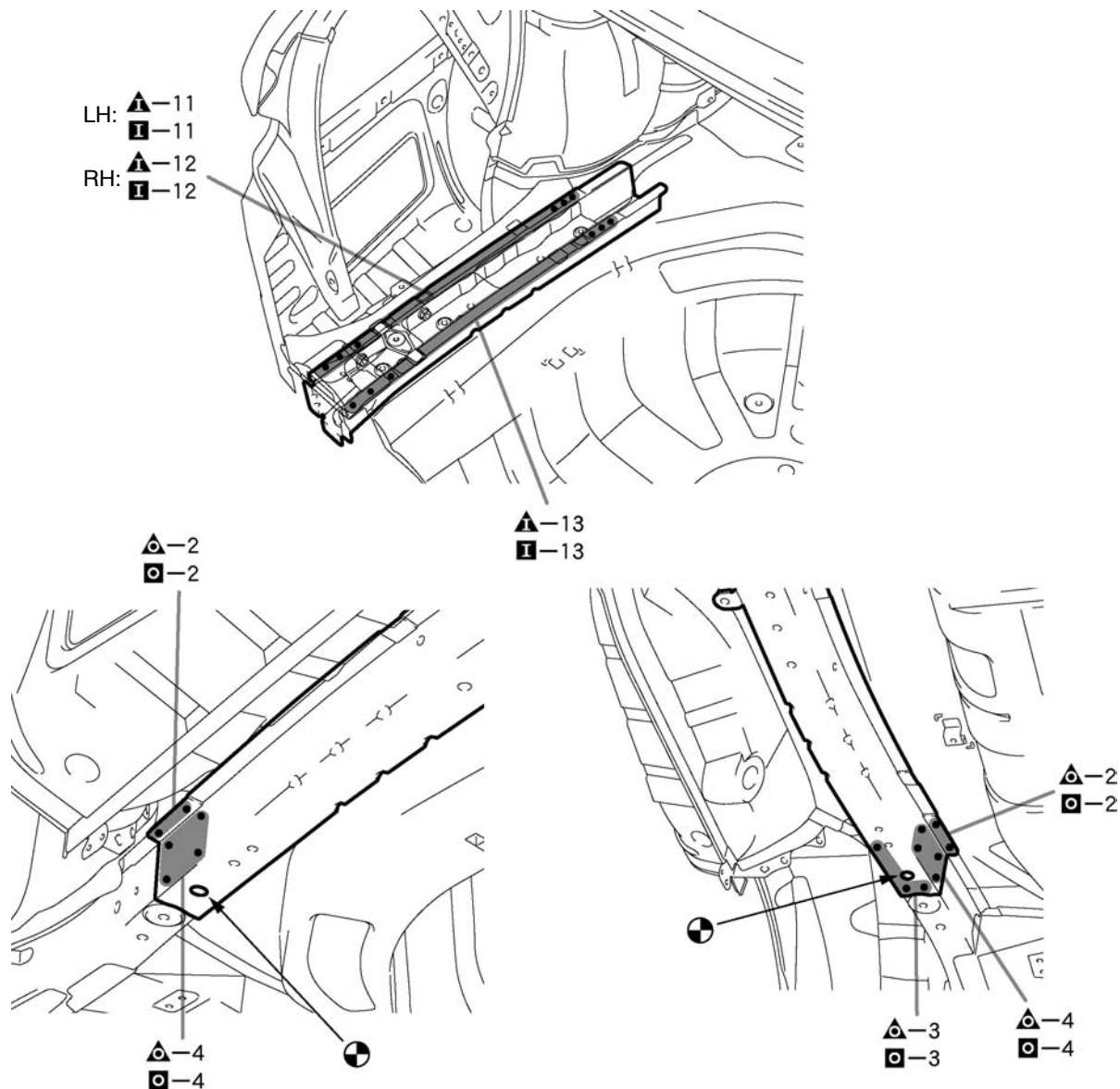
△ △ : Remove Weld Points

INSTALLATION

○ □ : MIG Plug Weld

F25752B

### REMOVAL-INSTALLATION



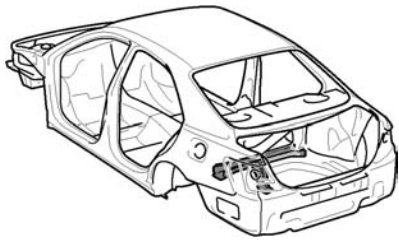
F25752

### INSTALLATION POINT

- 1 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](#))
- 2 After welding, apply undercoating to the corresponding parts. (See the [paint-coating](#))
- 3 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.





## REAR FLOOR NO. 2 CROSSMEMBER (ASSY)



F25753A

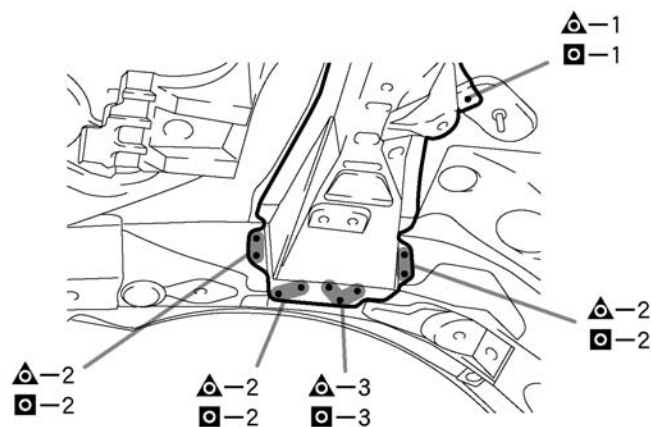
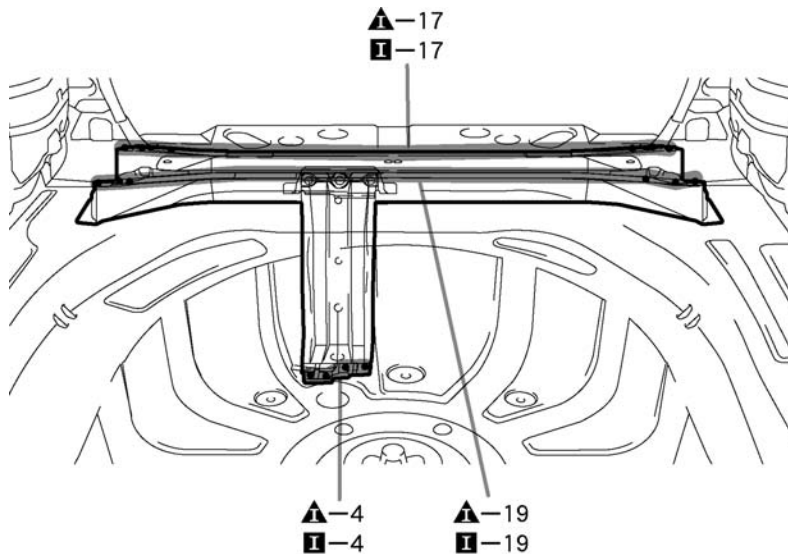
### Symbol meaning

REMOVAL        : Remove Weld Points

INSTALLATION        : MIG Plug Weld

F25753B

### REMOVAL-INSTALLATION

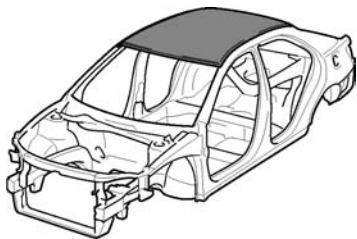


F25753

### INSTALLATION POINT

- 1 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](#))
- 2 After welding, apply undercoating to the corresponding parts. ([See the paint-coating](#))
- 3 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

## ROOF PANEL (ASSY): Normal Roof



F25754A

### Symbol meaning

REMOVAL

△ : Remove Weld Points

INSTALLATION

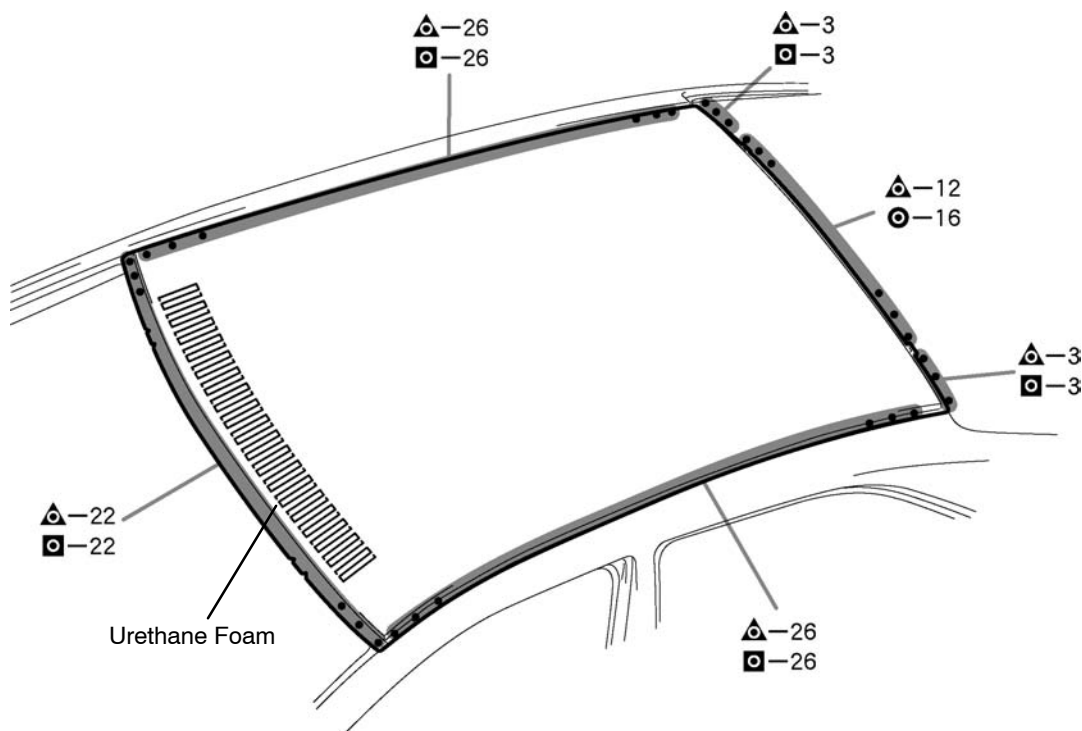
● : Spot Weld

◻ : MIG Plug Weld

◻ : Body Sealer

F25754B

### REMOVAL·INSTALLATION



F25754

### 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 After welding, apply polyurethane foam to the corresponding parts. ([See the paint-coating](#))
- 4 After welding, apply body sealer to the corresponding parts. ([See the paint-coating](#))
- 5 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

## Symbol meaning

REMOVAL

△ : Remove Weld Points

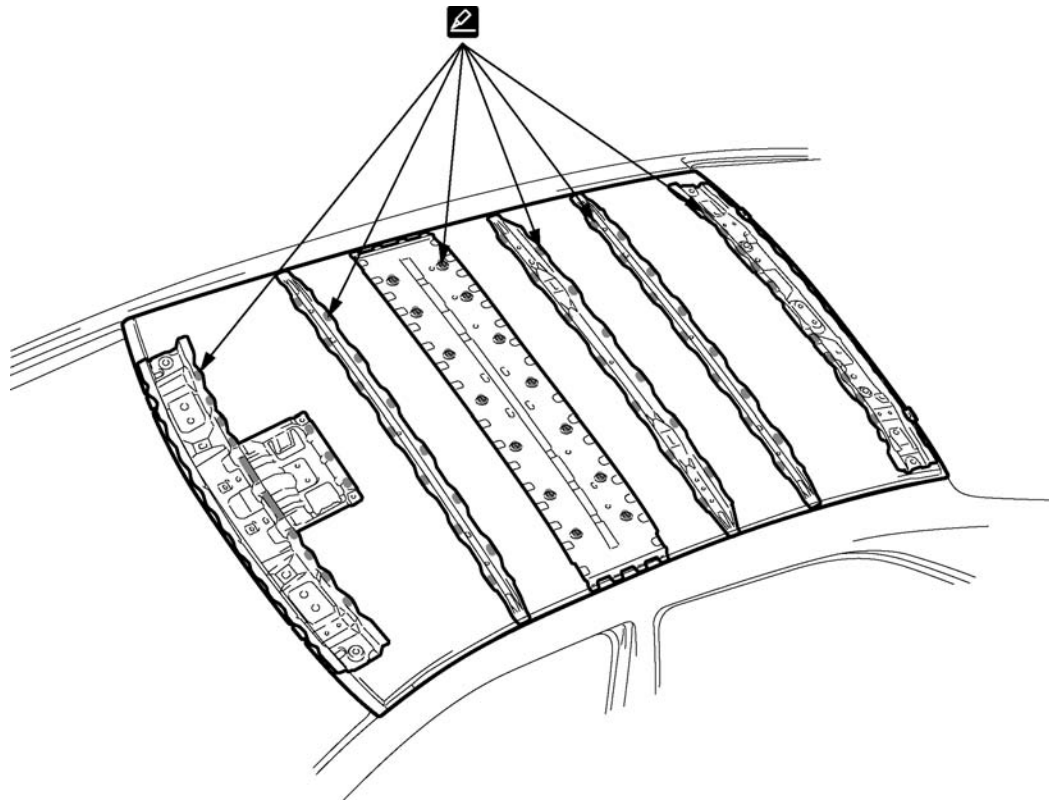
INSTALLATION

⊙ : Spot Weld

◻ : MIG Plug Weld

◻ : Body Sealer

F25754B



F25806

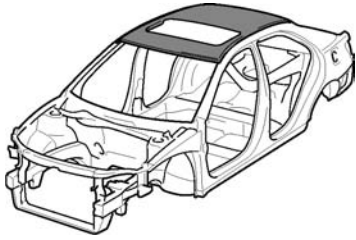
**INSTALLATION POINT**

- 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.

## ROOF PANEL (ASSY): Moon Roof



F25755A

### Symbol meaning

REMOVAL

△ : Remove Weld Points

INSTALLATION

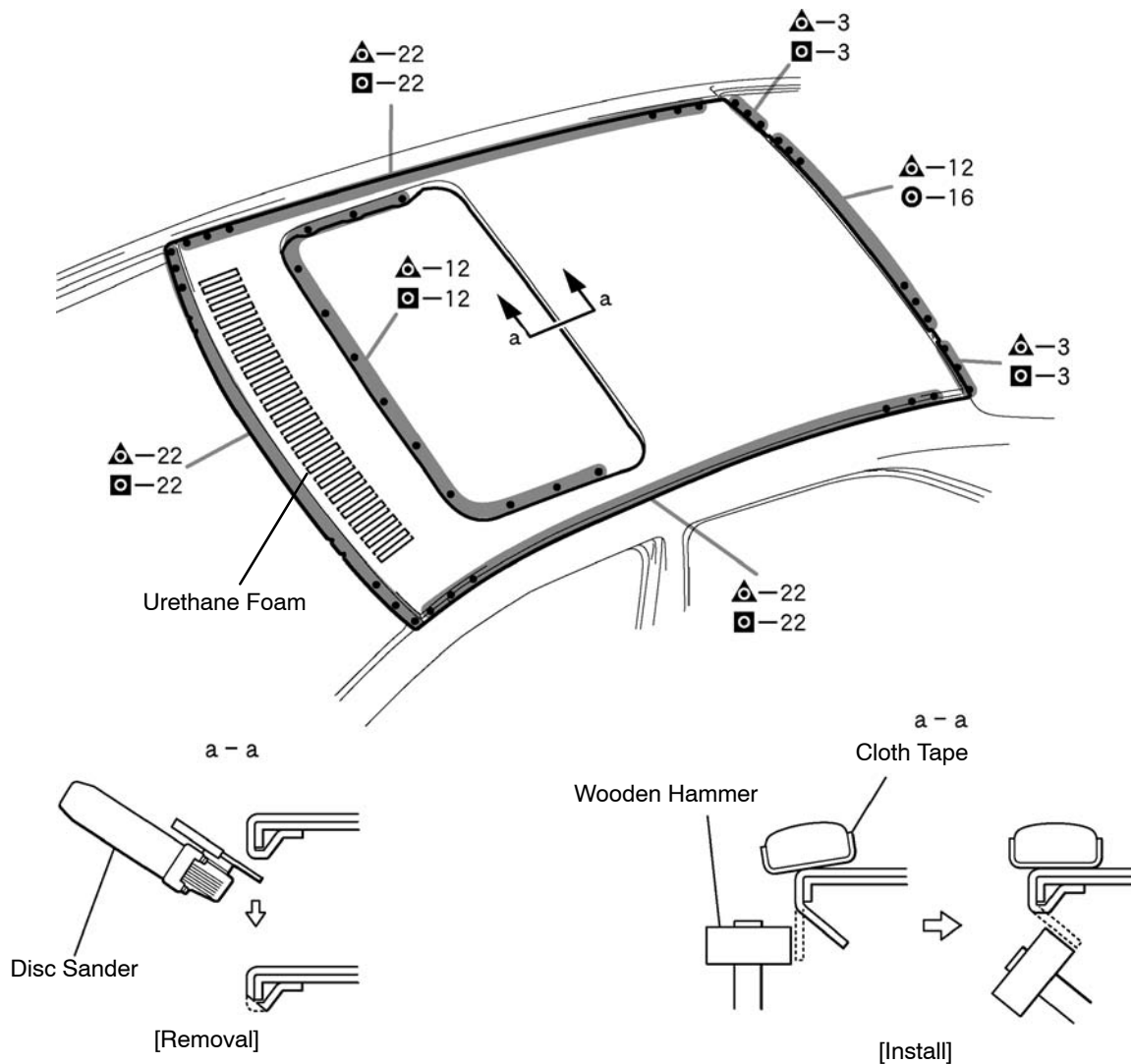
● : Spot Weld

◻ : MIG Plug Weld

◻ : Body Sealer

F25755B

### REMOVAL·INSTALLATION



F25755

### 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 After welding, apply polyurethane foam to the corresponding parts. (See the paint coating)
- 4 After welding, apply body sealer to the corresponding parts. (See the paint coating)
- 5 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

## Symbol meaning

REMOVAL

△ : Remove Weld Points

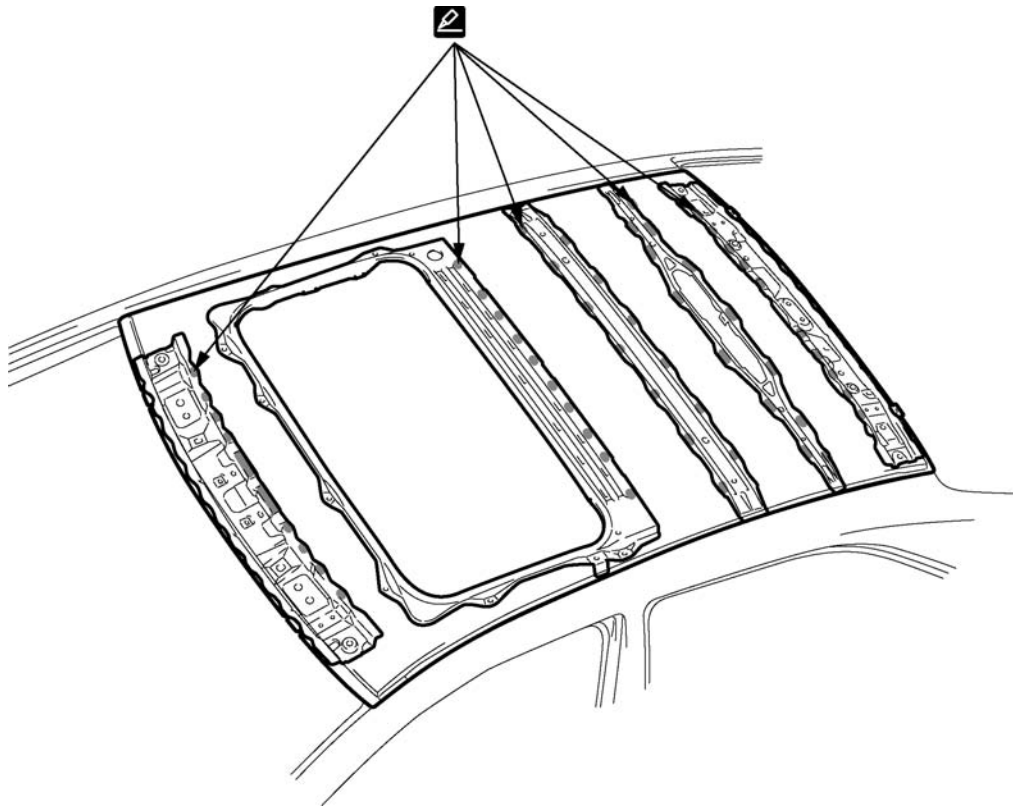
INSTALLATION

⊙ : Spot Weld

⊠ : MIG Plug Weld

◻ : Body Sealer

F25755B



F25756

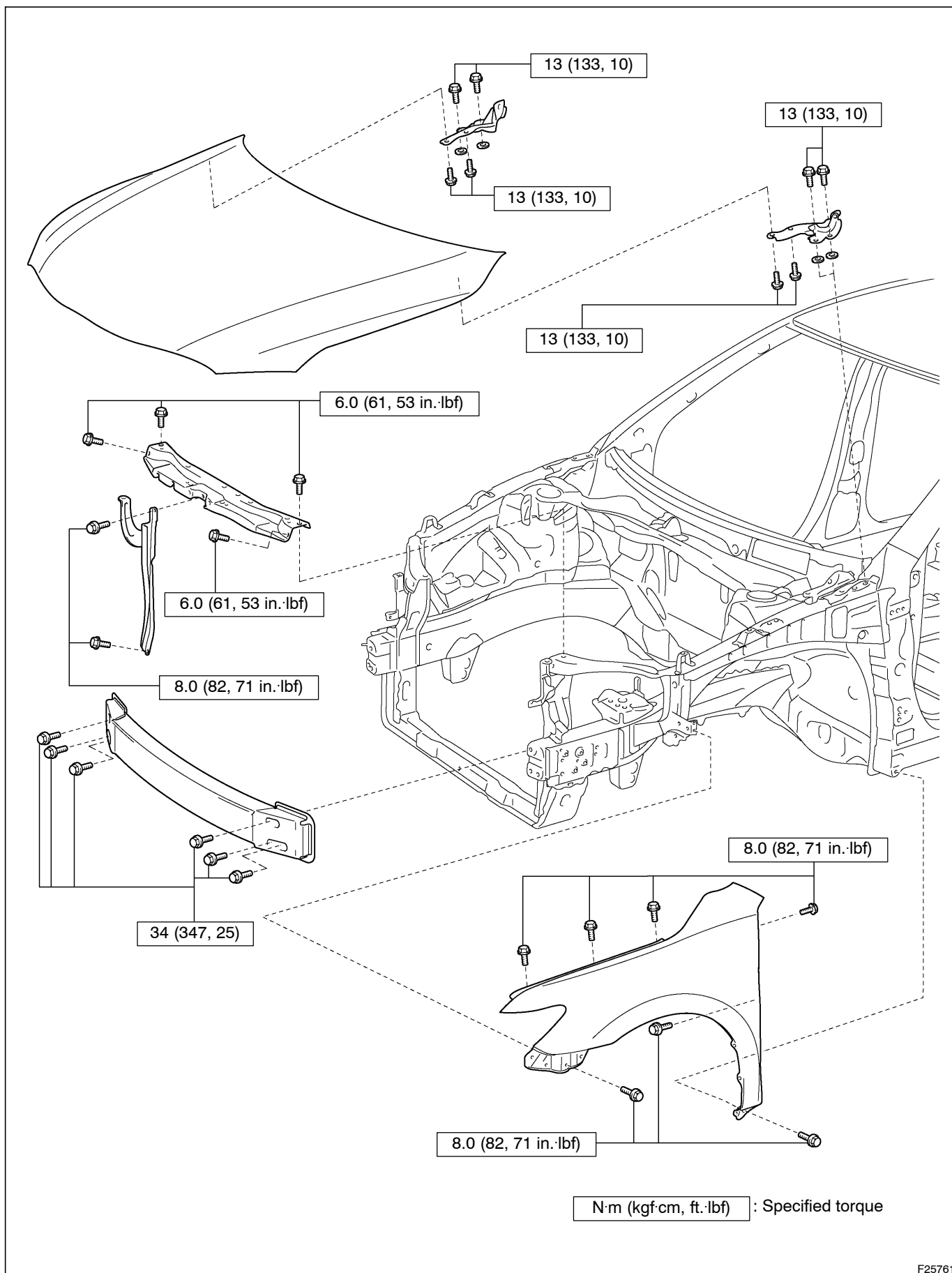
**INSTALLATION POINT**

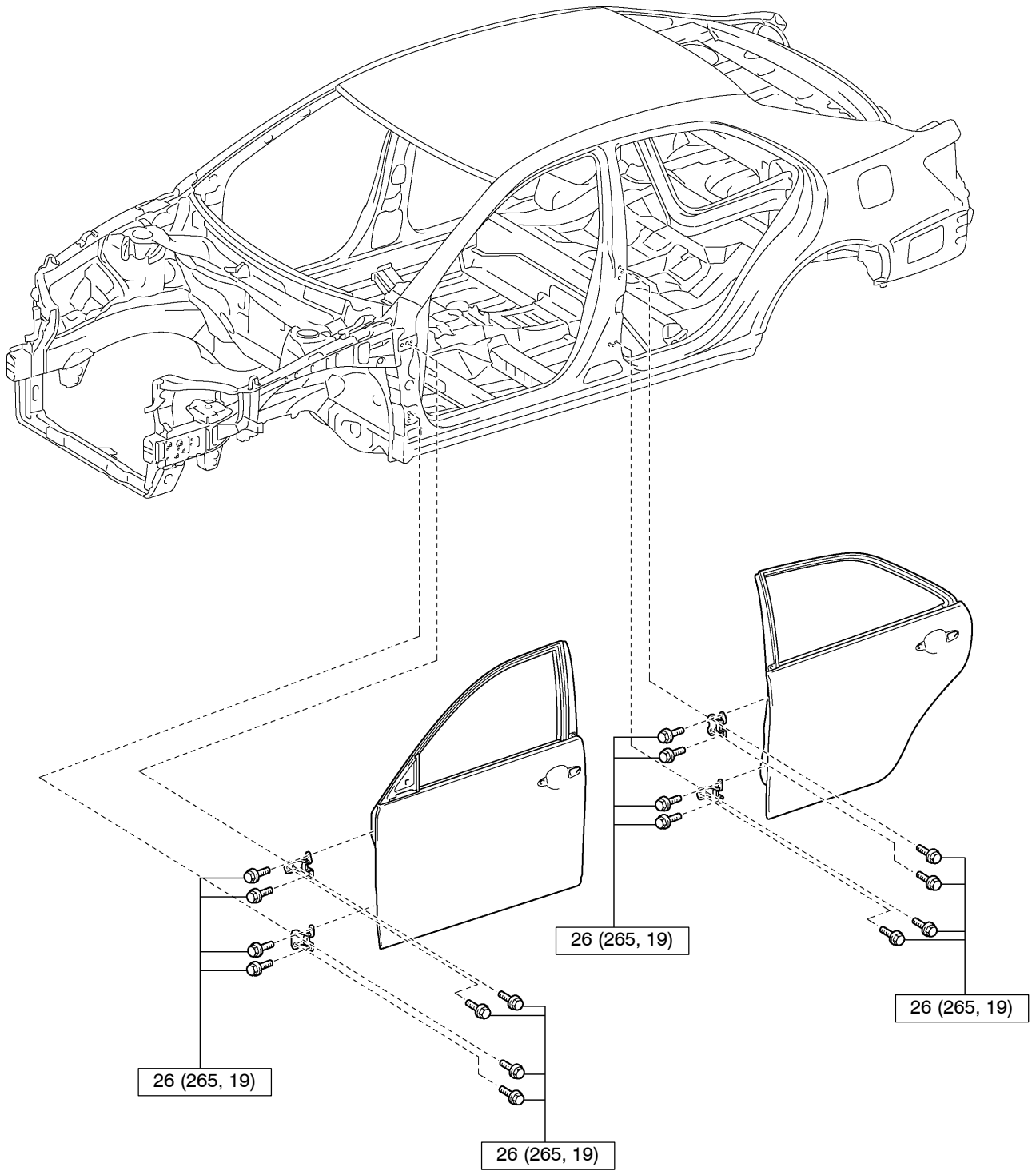
- 1 Before temporarily installing the new parts, apply body sealer to the windshield header panel, roof panel reinforcement and back door opening frame.

**HINT:**

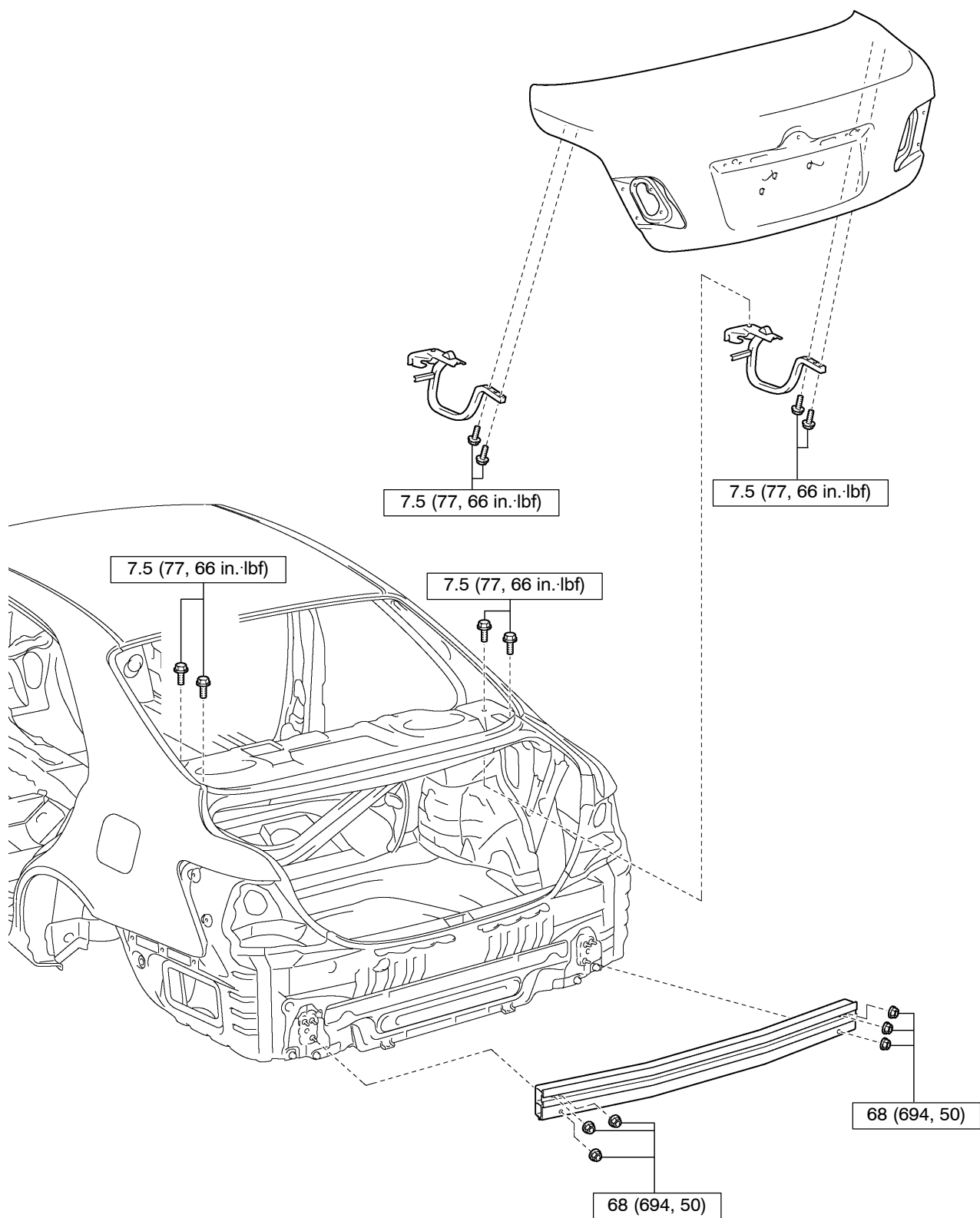
- 1) Apply just enough sealer for the new parts to make contact.

# OUTER PANEL INSTALLATION TORQUE





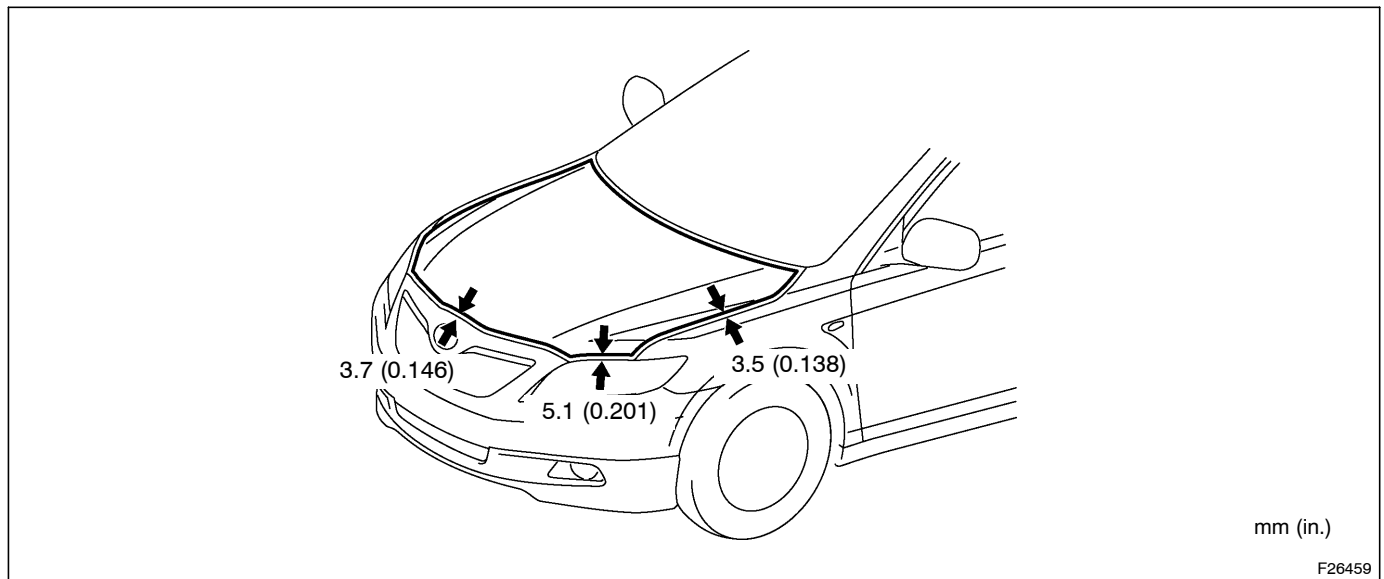




N·m (kgf·cm, ft.·lbf) : Specified torque

# FIT STANDARD/ADJUSTMENT METHOD/TORQUE SPECIFICATION

## ENGINE HOOD



### 1. ADJUST HOOD

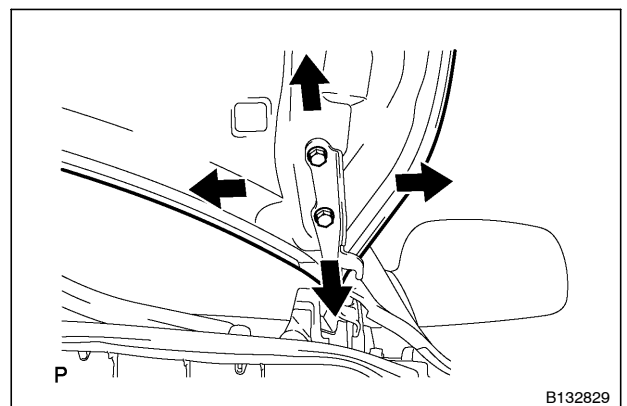
#### **HINT:**

- Centring bolts are used to mount the hood hinge and hood lock. The hood and hood lock cannot be adjusted with the centring bolts fitted. Substitute the centring bolts with standard bolts (with washers) when making adjustments.

- a. Horizontally and vertically adjust the hood.
  - i. Loosen the 4 hinge bolts of the hood.
  - ii. Adjust the clearance between the hood and front fender by moving the hood.
  - iii. Tighten the 4 hinge bolts after the adjustment.

#### **Torque:**

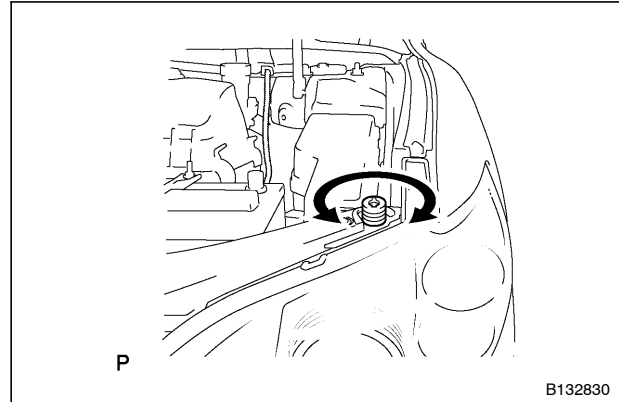
**13 N·m (133 kgf·cm, 10 ft·lbf)**



- b. Adjust the height of the front end of the hood using the cushion rubber.
- i. Adjust the cushion rubber so that the height of the hood and fender are aligned.

**HINT:**

*Raise or lower the front end of the hood by turning the cushion rubber.*

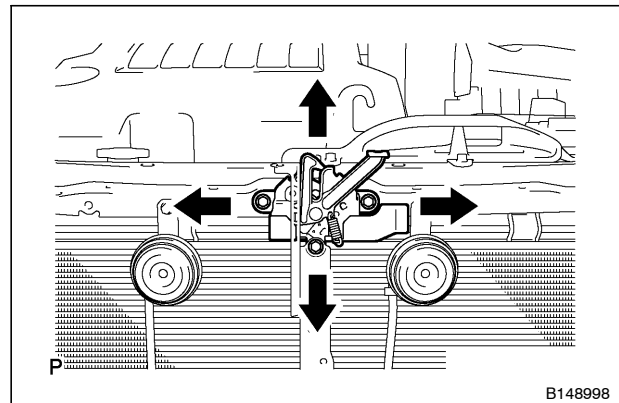


- c. Adjust the hood lock.
- i. Loosen the 3 bolts.
- ii. Tighten the bolts after the adjustment.

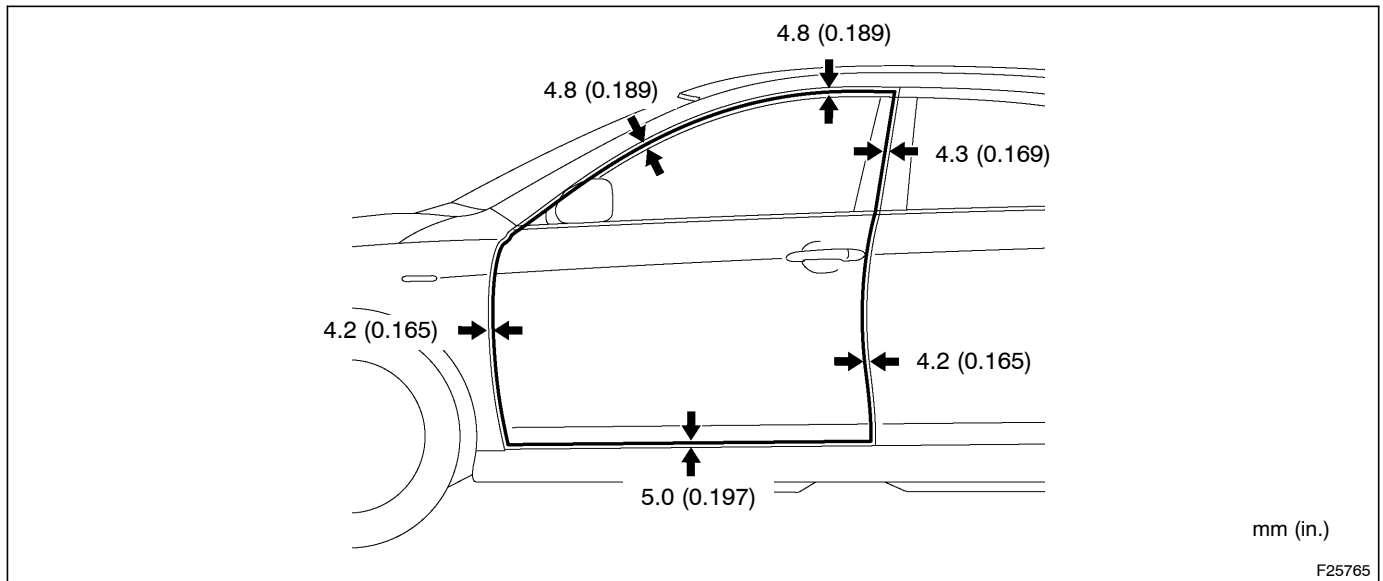
**Torque:**

**7.5 N·m (77 kgf·cm, 66 in·lbf)**

- iii. Check that the striker can engage with the hood lock smoothly.



## FRONT DOOR



### 1. ADJUST FRONT DOOR

#### **HINT:**

- Before adjusting the door position of vehicles equipped with side airbags and curtain shield airbags, disconnect the battery. After adjustment, inspect the SRS warning light, the side airbag system, and the curtain shield airbag system for normal operation. Then initialise both airbag systems.
- Use the same procedures for the RH side and LH side.
- The procedures listed below are for the LH side.
- Centring bolts are used to mount the door hinge to the vehicle body and door. The door cannot be adjusted with the centring bolts fitted. Substitute the centring bolts with standard bolts (with washers) when making adjustments.

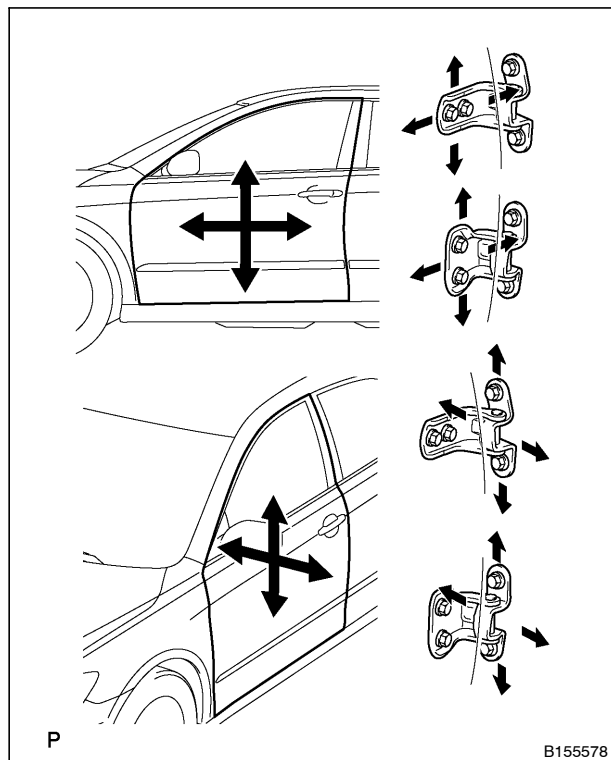
- a. Using SST, loosen the hinge bolts on the vehicle body and adjust the door position.

**SST****09812-00010**

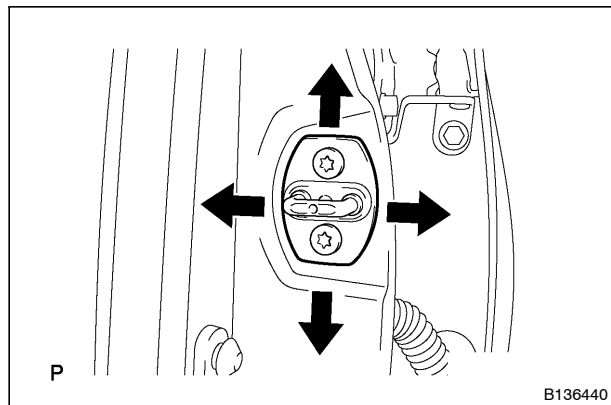
- b. Tighten the hinge bolts on the vehicle body after the adjustment.

**Torque:****26 N·m (265 kgf·cm, 19 ft·lbf)**

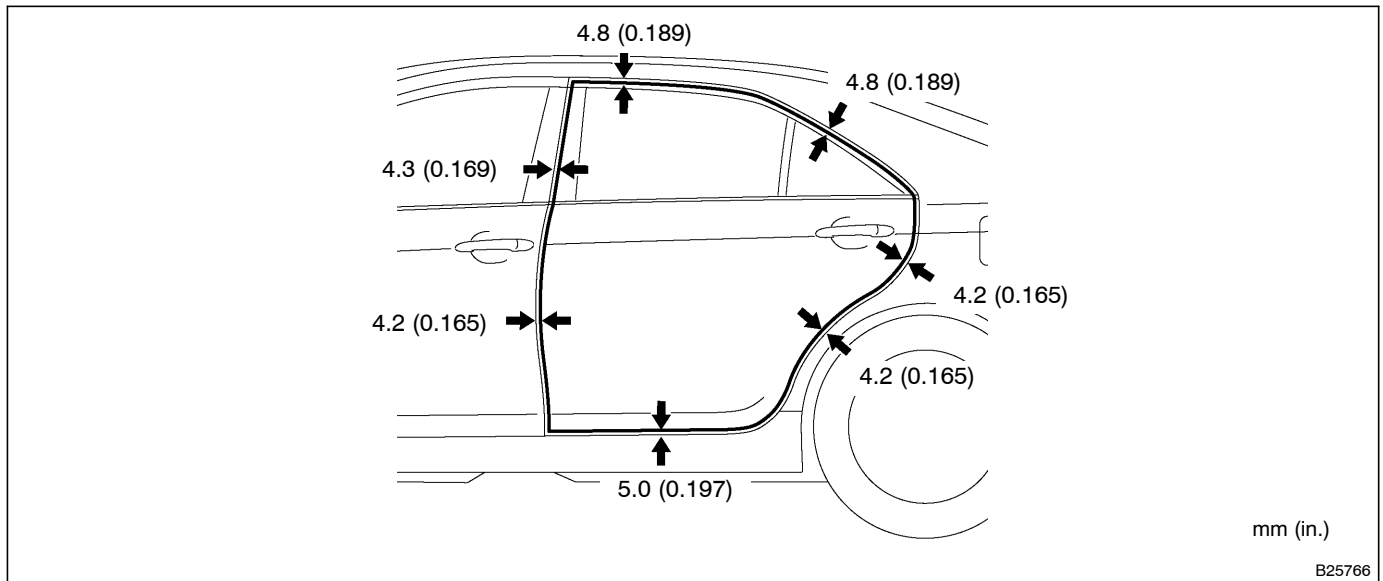
- c. Loosen the hinge bolts on the door and adjust the door position.
- d. Tighten the hinge bolts on the door after the adjustment.

**Torque:****26 N·m (265 kgf·cm, 19 ft·lbf)**

- e. Adjust the striker position by slightly loosening the striker mounting screws with a "TORX" socket wrench (T40) and tapping the striker with a plastic hammer.
- f. Using a "TORX" socket wrench (T40), tighten the striker mounting screws after the adjustment.

**Torque:****23 N·m (235 kgf·cm, 17 ft·lbf)**

## REAR DOOR



### 1. ADJUST REAR DOOR

#### **HINT:**

- Before adjusting the door position of vehicles equipped with side airbags and curtain shield airbags, disconnect the battery. After adjustment, inspect the SRS warning light, the side airbag system, and the curtain shield airbag system for normal operation. Then initialise both airbag systems.
- Use the same procedures for the RH side and LH side.
- The procedures listed below are for the LH side.
- Centring bolts are used to mount the door hinge to the vehicle body and door. The door cannot be adjusted with the centring bolts fitted. Substitute the centring bolts with standard bolts (with washers) when making adjustments.

- a. Loosen the hinge bolts on the vehicle body and adjust the door position.

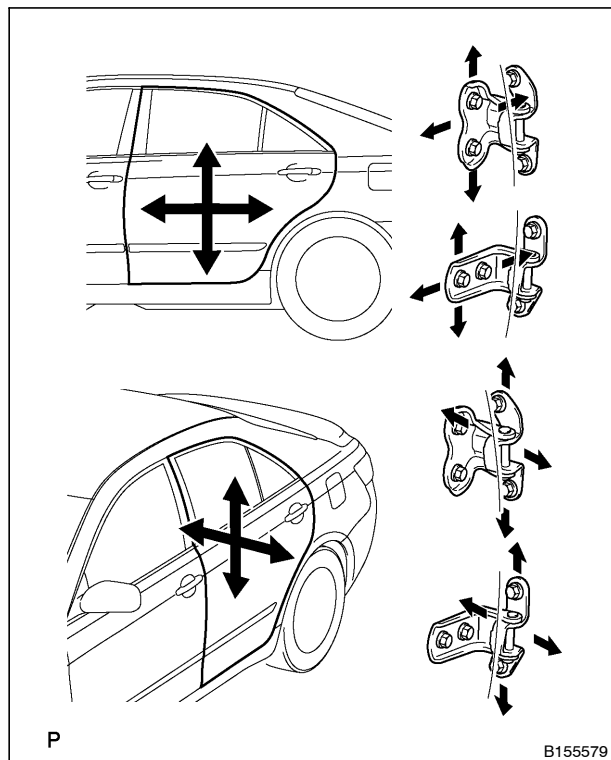
**SST****09812-00010**

- b. Tighten the hinge bolts on the vehicle body after the adjustment.

**Torque:****26 N·m (265 kgf·cm, 19 ft·lbf)**

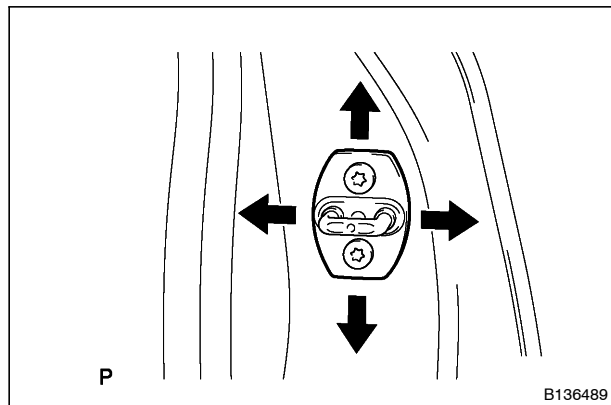
- c. Loosen the hinge bolts on the door and adjust the door position.

- d. Tighten the hinge bolts on the door after the adjustment.

**Torque:****26 N·m (265 kgf·cm, 19 ft·lbf)**

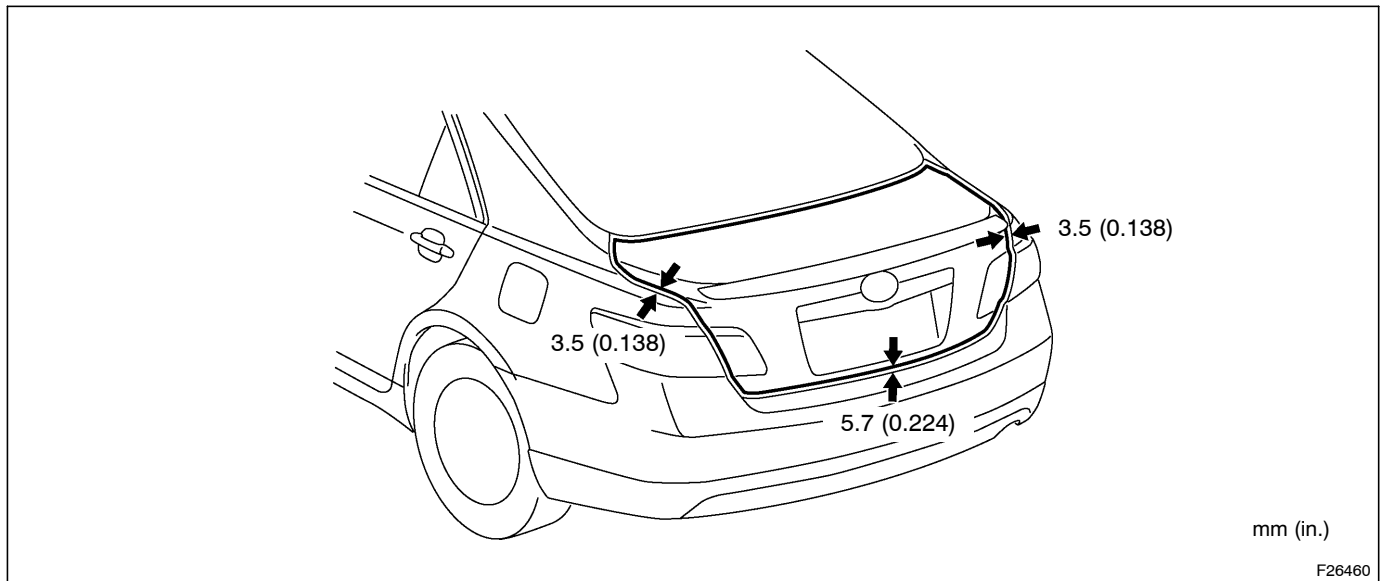
- e. Adjust the striker position by slightly loosening the striker mounting screws with a "TORX" socket wrench (T40) and tapping the striker with a plastic hammer.

- f. Using a "TORX" socket wrench (T40), tighten the striker mounting screws after the adjustment.

**Torque:****23 N·m (235 kgf·cm, 17 ft·lbf)**



## LUGGAGE COMPARTMENT DOOR



### 1. ADJUST LUGGAGE COMPARTMENT DOOR

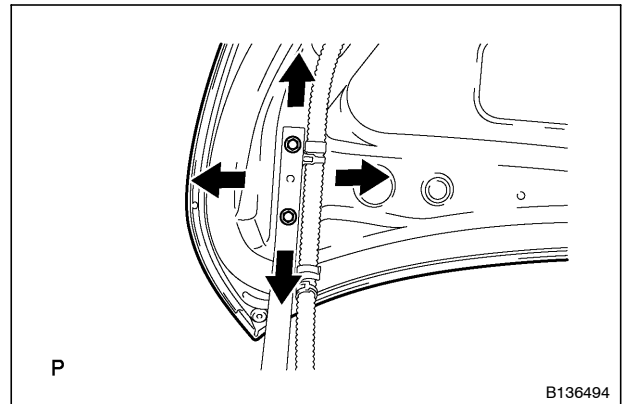
#### HINT:

- Centring bolts are used to mount the door hinge to the luggage compartment door. The door cannot be adjusted with the centring bolts fitted. Substitute the centring bolts with standard bolts (with washers) when making adjustments.

- Loosen the door hinge bolts to adjust the door horizontally and vertically.
- Tighten the door hinge bolts after the adjustment.

#### Torque:

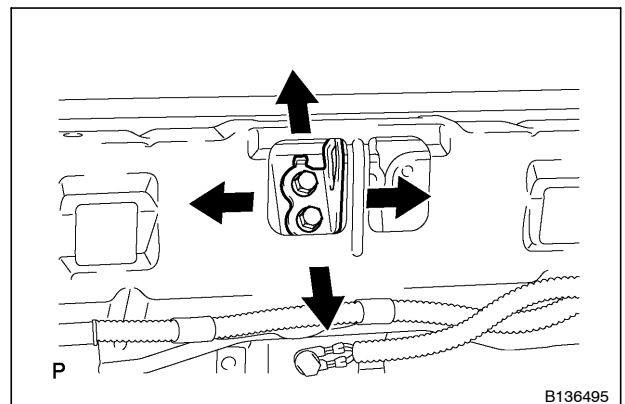
7.5 N·m (77 kgf·cm, 66 in·lbf)



- Adjust the striker position by slightly loosening the striker mounting screws and tapping the striker with a plastic hammer.
- Tighten the striker mounting screws after the adjustment.

#### Torque:

5.5 N·m (56 kgf·cm, 49 in·lbf)



## NAME PLATE APPLICATION PROCEDURE

- (a) Heat the double-sided tape remaining on the body with an infrared lamp or equivalent.

*HINT:*

*Heat the tape to 40 to 60°C for approximately 1 to 2 minutes.*

- (b) Wipe off the remaining double-sided tape using a clean cloth or equivalent.

*HINT:*

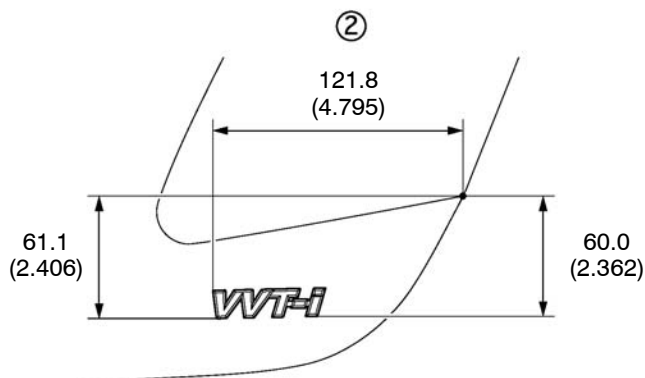
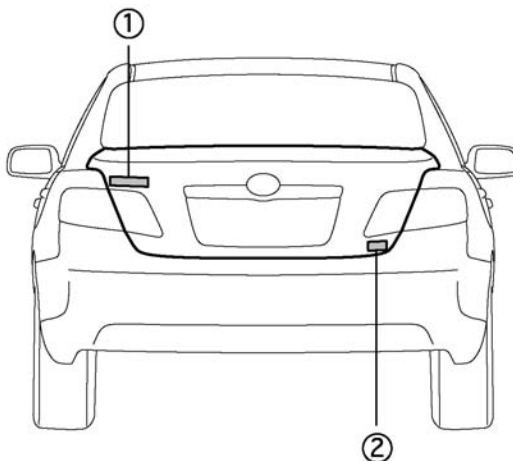
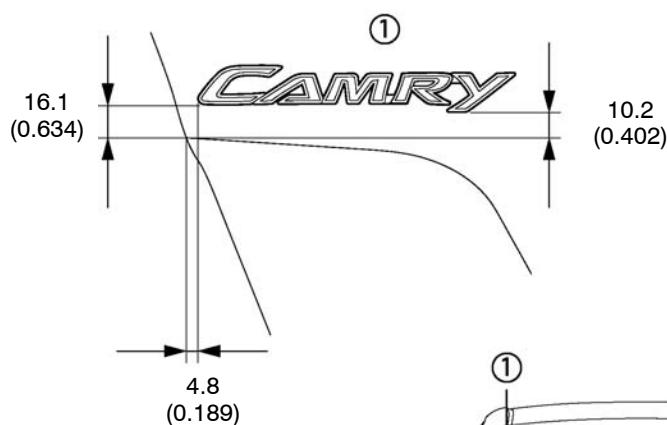
*If a name plate is installed without thoroughly removing the remaining double-sided tape from the body, the name plate will not adhere properly. Make sure to thoroughly wipe off the double-sided tape.*

- (c) After cleaning the installation area of the body with degreasing agent, attach the name plate to the position shown in the illustration.

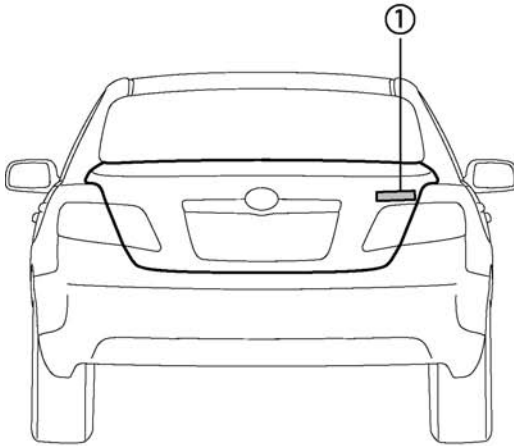
*HINT:*

*The working environment should be 20°C when installing the name plate. If the working environment is below 20°C, heat the installation area of the body to 20 to 30°C and then install the name plate.*

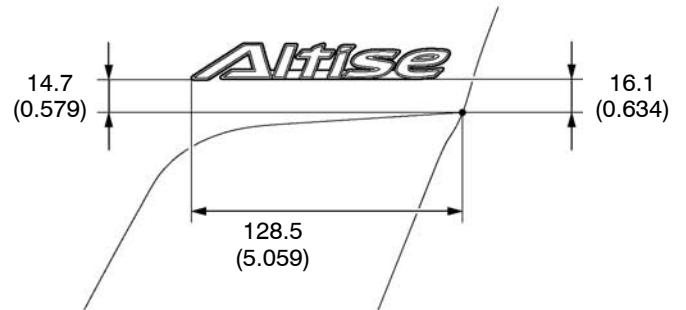
[for 2AZ-FE]



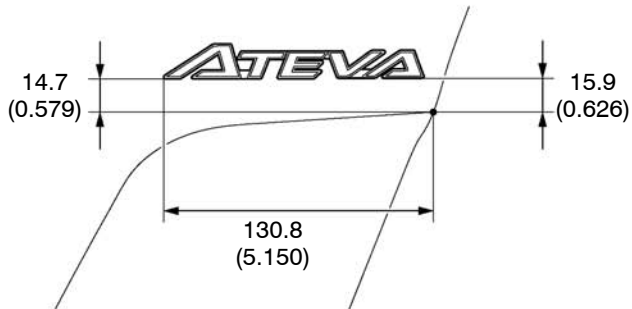
mm (in.)



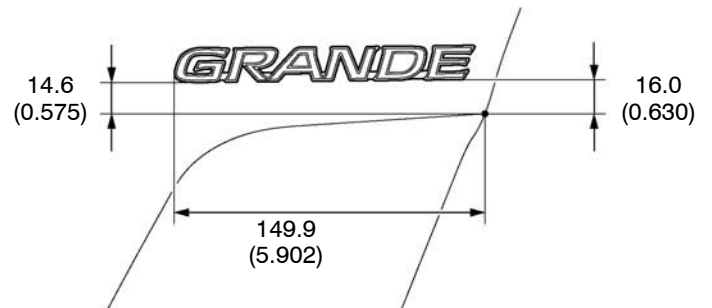
① [For Altise plate]



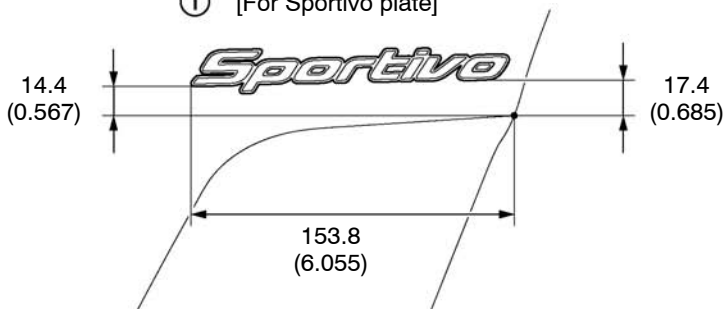
① [For ATEVA plate]



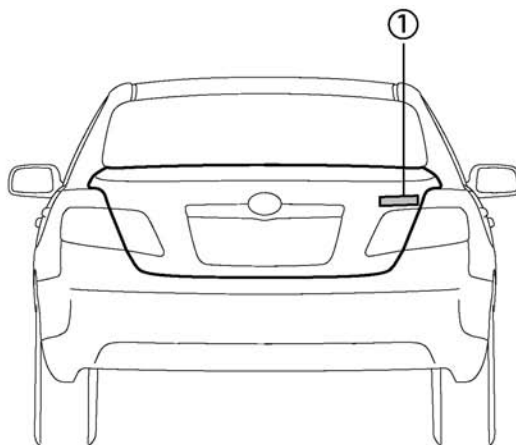
① [For GRANDE plate]



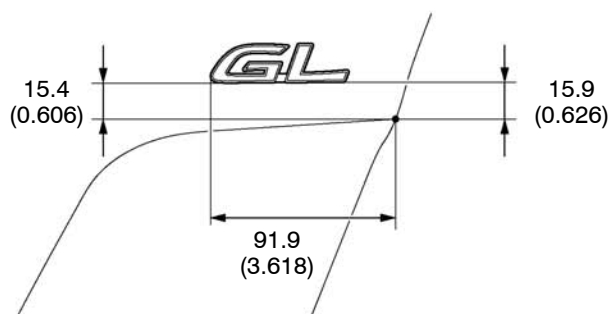
① [For Sportivo plate]



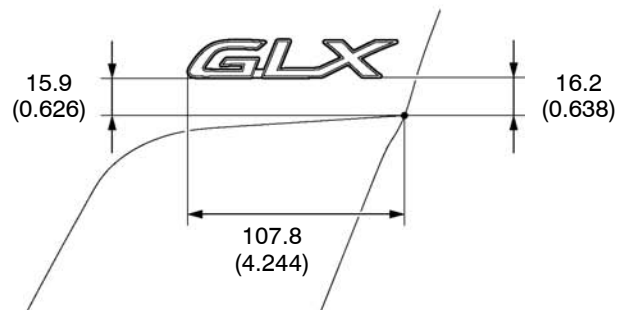
mm (in.)



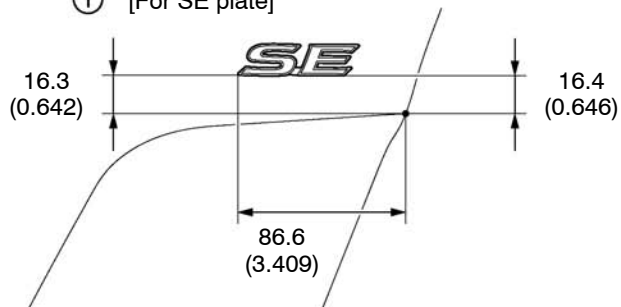
① [For GL plate]



① [For GLX plate]

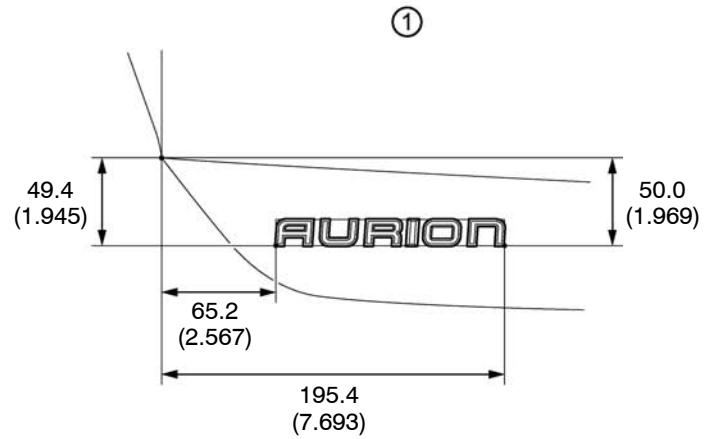
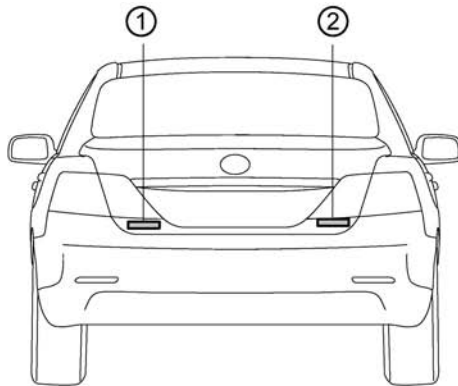


① [For SE plate]

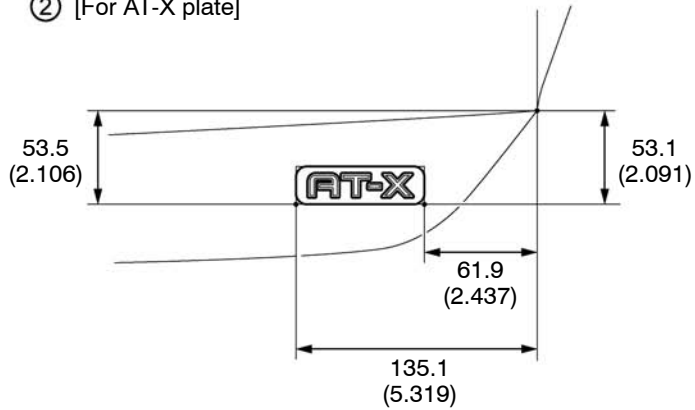


mm (in.)

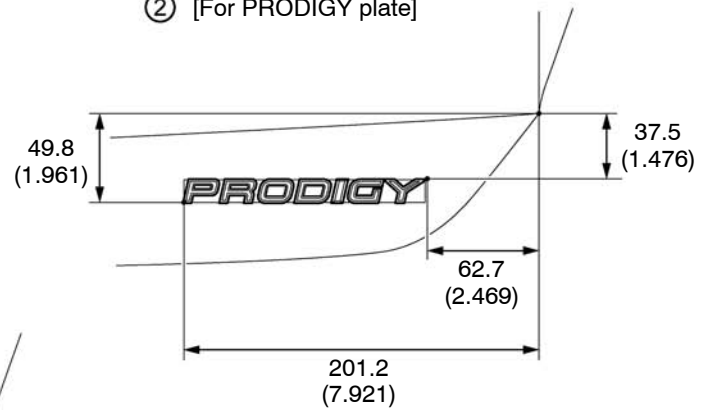
[for 2GR-FE]



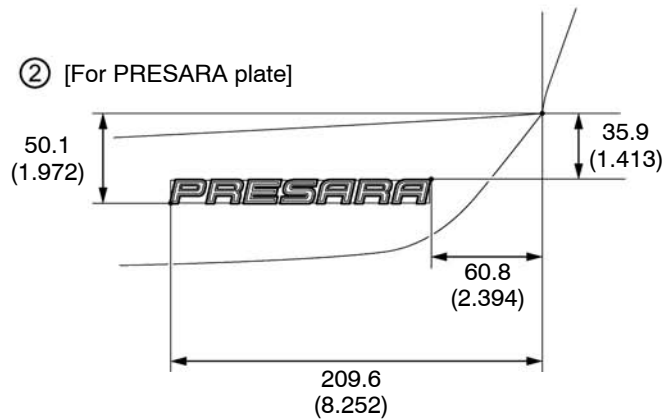
② [For AT-X plate]



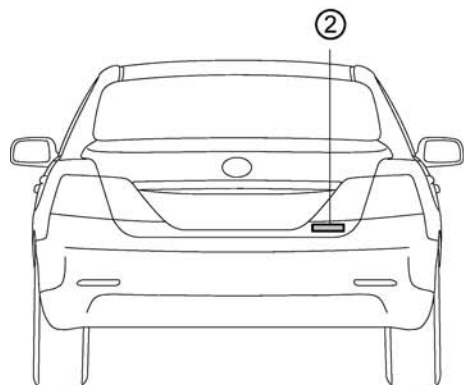
② [For PRODIGY plate]



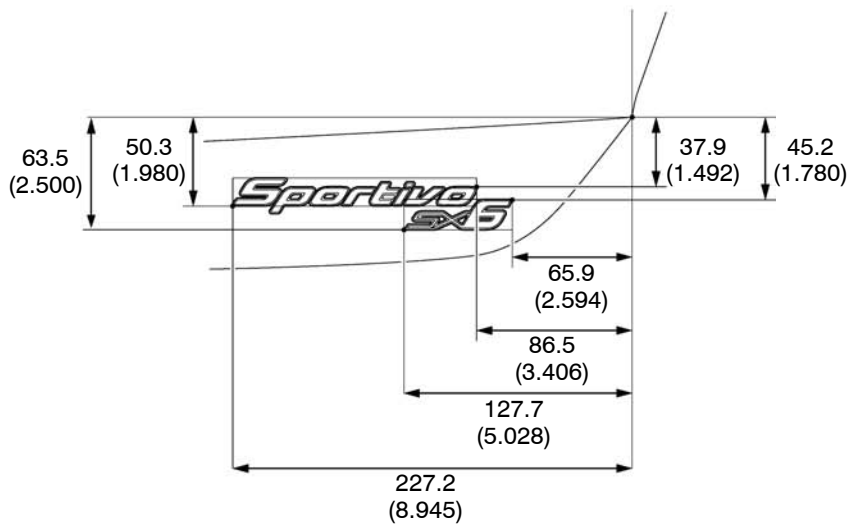
② [For PRESARA plate]



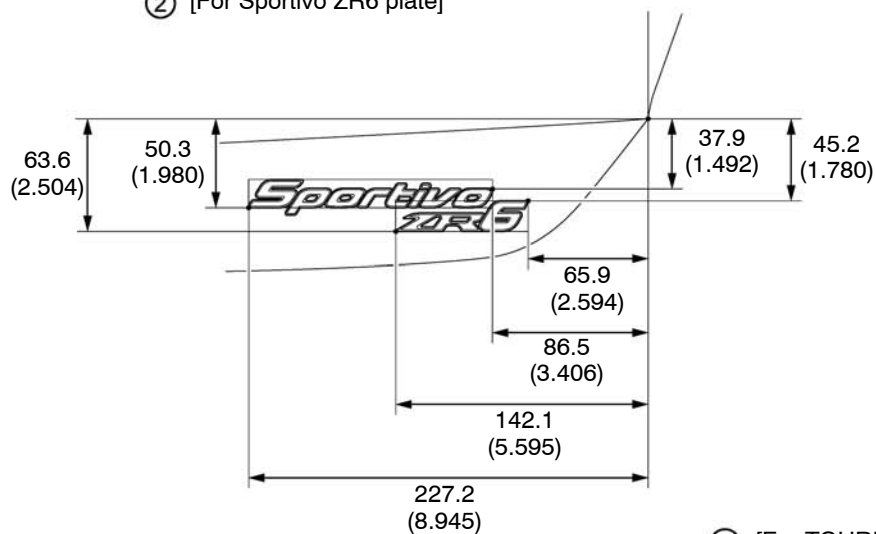
mm (in.)



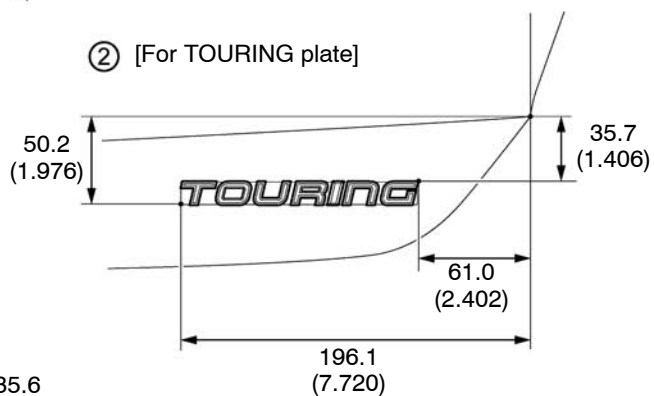
② [For Sportivo SX6 plate]



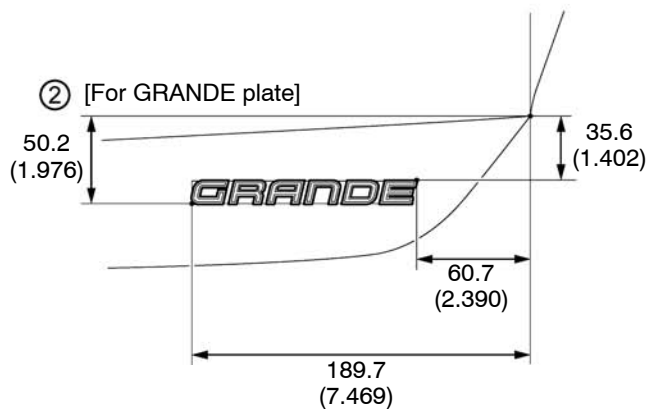
② [For Sportivo ZR6 plate]



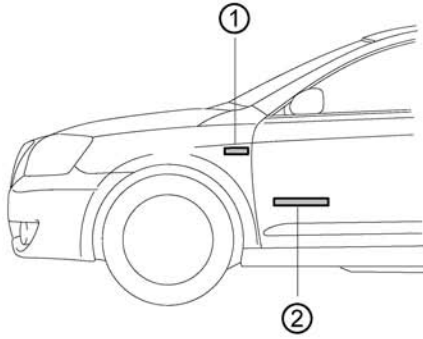
② [For TOURING plate]



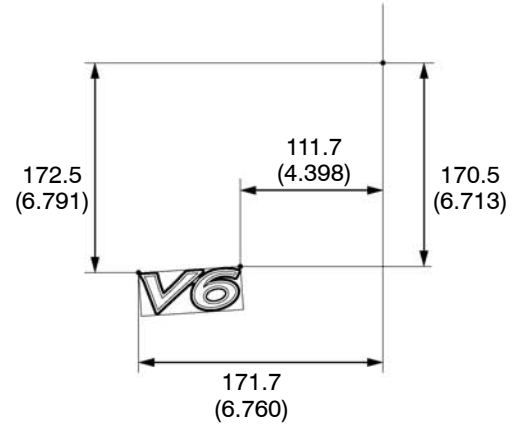
② [For GRANDE plate]



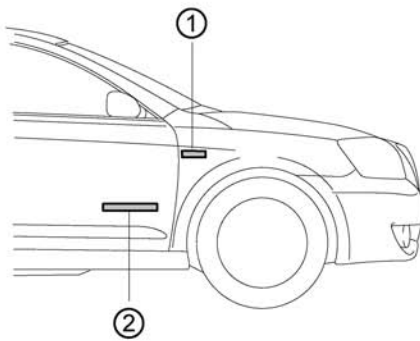
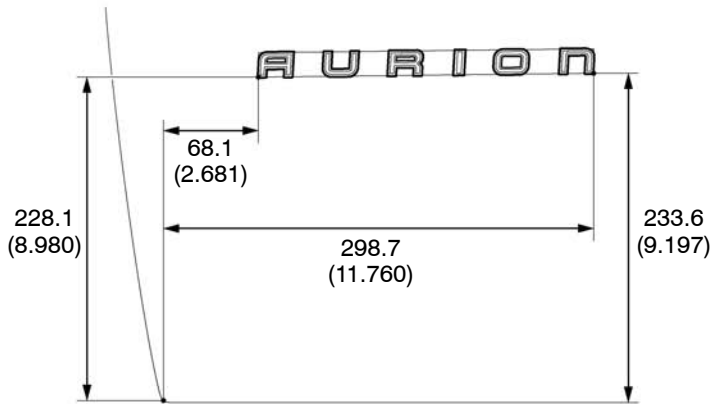
mm (in.)



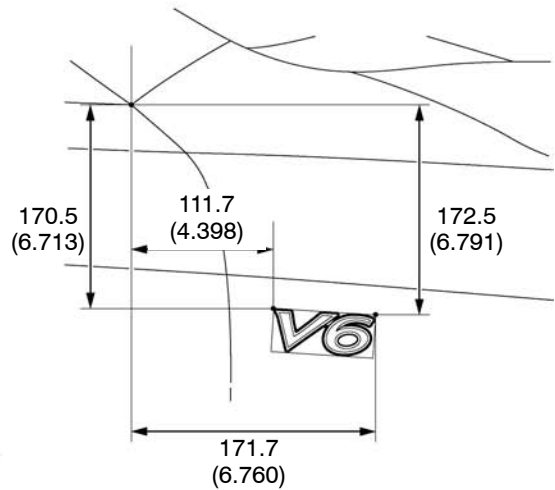
① [For V6 plate LH side]



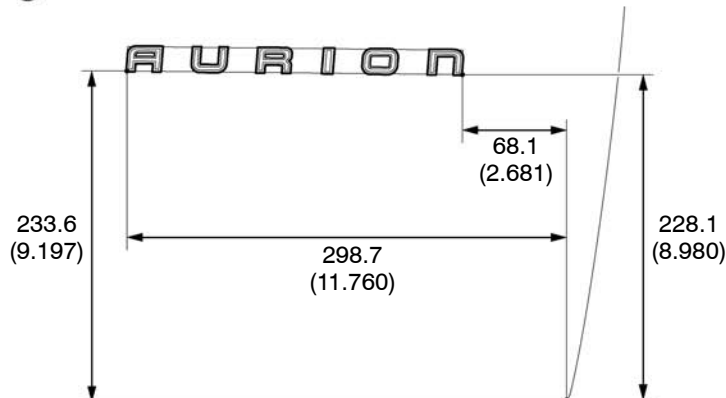
② [For AURION plate LH side]



① [For V6 plate RH side]



② [For AURION plate RH side]



mm (in.)



## CAUTION LABEL ATTACHMENT POSITION

After using a degreasing agent to clean the surfaces of the body where the caution labels will be attached, attach the caution labels to the positions shown in the illustration.

**HINT:**

- 1) Attach each caution label with its orientation the same as the numbers shown in the illustration.
- 2) Make sure the caution label is not attached over a spot weld.
- 3) When attaching the caution label, make sure not to touch the label's adhesive surface.
- 4) To prevent the edges of the caution label from peeling, apply extra pressure to the label's periphery.
- 5) If the work area's temperature is 5°C or less, the caution label's adhesive will deteriorate. It is recommended that you heat the label to 20 to 40°C.

