TOYOTA

REPAIR MANUAL FOR COLLISION DAMAGE

COROLLA *FF, FR*

(SPRINTER)

AE80.82.86, CE80 series Apr., 1983

Pub.No.36434E

FOREWORD

This repair manual has been prepared to provide information on the repair methods (including cutting and welding operations, but excluding painting) recommended by TOYOTA for collision-damaged body components of the TOYOTA COROLLA (AE80·82·86, CE80 series).

This manual consists of body repair methods, exploded diagrams and illustrations of the body components and other information relating to body panel replacement such as handling precautions, tools, equipment, etc. However, it should be noted that the front fenders of all TOYOTA models are bolted on and require no welding.

Body construction will sometimes differ depending on specifications and country of destination. Therefore, please keep in mind that the information contained herein is based on vehicles for general destinations.

For the service of other than collision-damaged body components of the TOYOTA COROLLA, refer to the following repair manuals.

COROLLA FF Chassis & Body Repair Manual
(AE80·82, CE80) (Pub. No. 36216E)
COROLLA FR Chassis & Body Repair Manual
(AE86) (Pub. No. 36217E)
2A, 3A, 3A-C, 4A, 4A-C Engine Repair Manual
(Pub. No. 36214E)
1C Engine Repair Manual (Pub. No. 36178E)
A40D, A42D, A43D, A42DL, A43D, A43DE Automatic
Transmission Repair Manual (Pub. No. 36136E)
COROLLA FF 1984 Repair Manual (USA & CANADA)
(AE82, CE80) (Pub. No. 36219A)
COROLLA FR 1984 Repair Manual (USA & CANADA)
(AE86) (Pub. No. 36220A)

All information contained in this manual is the most up-to-date at the time of publication. However, specifications and procedures are subject to change without prior notice.

TOYOTA MOTOR CORPORATION

TOYOTA COROLLA (SPRINTER) FF, FR REPAIR MANUAL FOR COLLISION DAMAGE

INTRODUCTION IN
BODY PANEL REPLACEMENT RE
BODY PANEL CONSTRUCTION CN
PLASTIC BODY PARTS PP
BODY PANEL SEALING AND UNDERCOATING SU
BODY DIMENSIONS DI
PART LISTS PL
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INTRODUCTION

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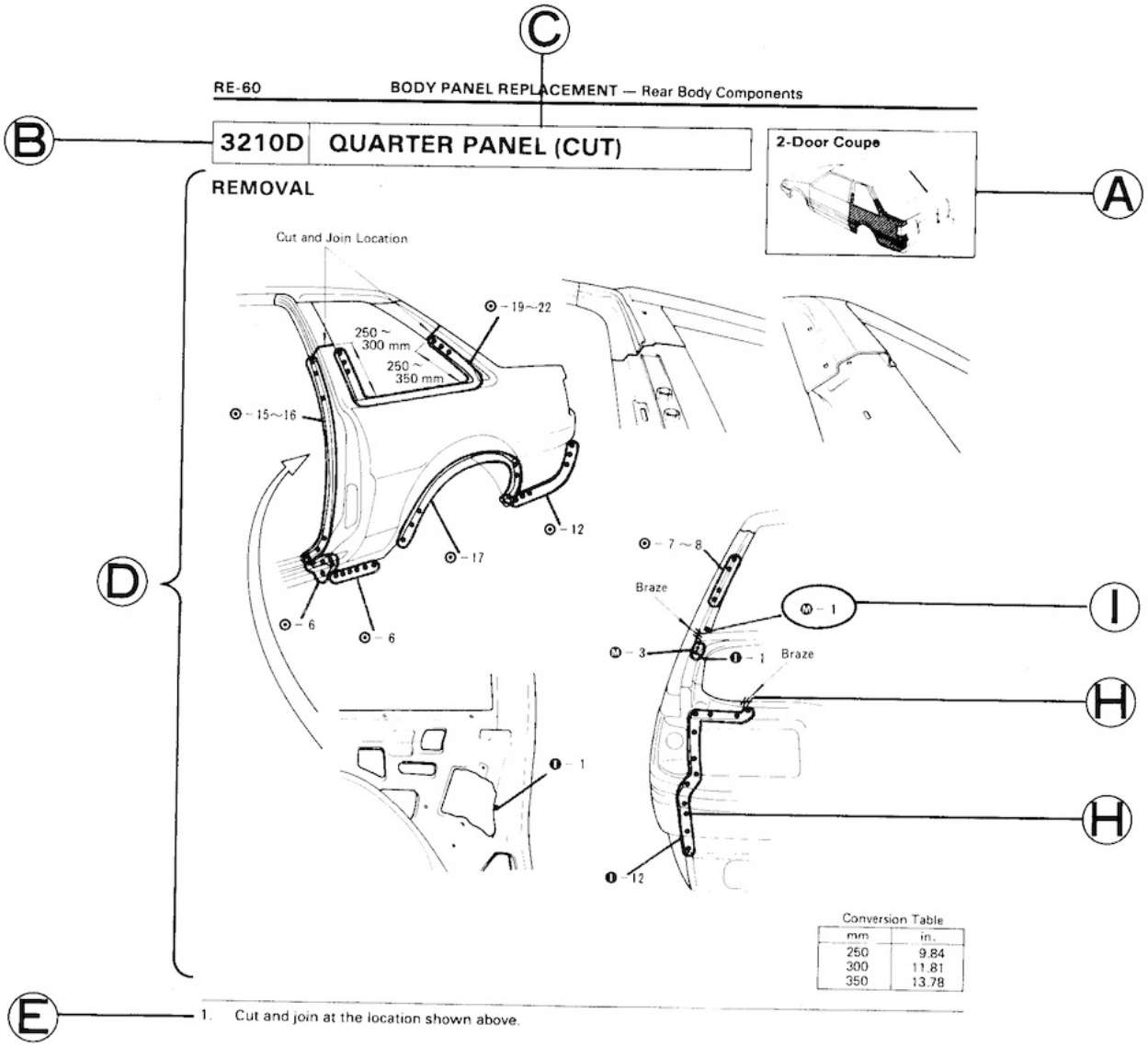
VEHICLE LIFT AND SUPPORT LOCATIONS	IN-11
ABBREVIATIONS USED IN THIS MANUAL	IN-12

HOW TO USE THIS MANUAL

Each repair method description provided in Section RE of this manual comprises two pages, divided itno 2 blocks (REMOVAL AND INSTALLATION) and includes illustrations to facilitate body repair.



(A) : PART LOCATION

(B) : OPERATION NO.
An OPERATION No. is assigned to each method description to identify the specific repair operation. The following coding classification is used in the assignment of an operation number.

3 2 1 0 A

COMPONENT PORTION
1 Front
2 Center
3 Rear
4 Rear Under

REPLACEMENT COMPONENT (Identifier code assigned arbitrarily) 1~9

REPLACEMENT METHOD
0 . . Assembly
1 . . Partial cutting (most of part used)
2 . . 1/2 cutting (about 1/2 of part used)
3 . . Major cutting (less than 1/2 of part used)

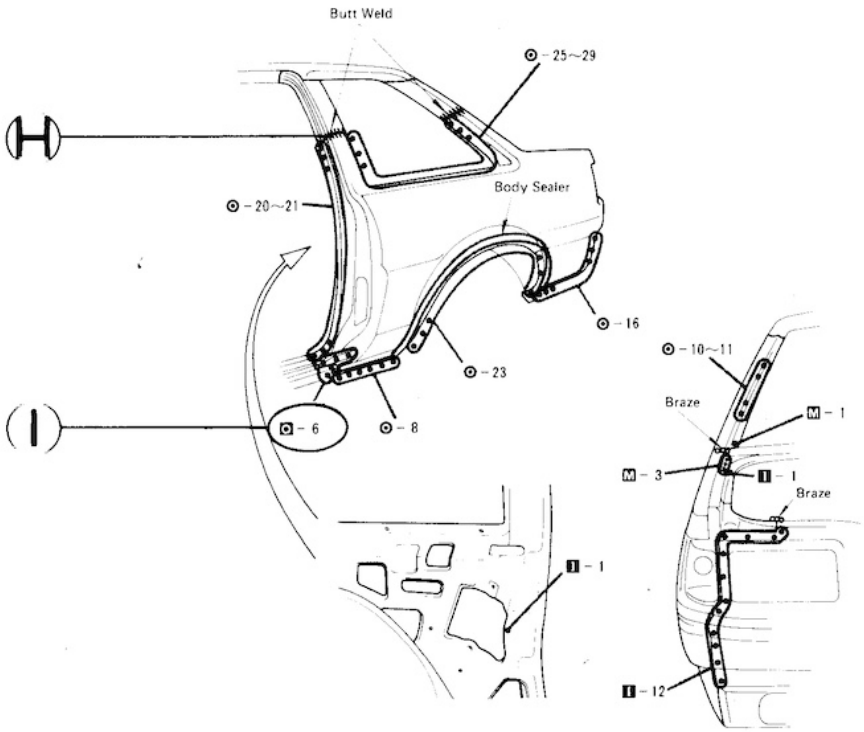
COMBINATION OPERATION
0 . . . . Single component replacement
1~9 . . Combination components replacement

BODY VARIATIONS
Non . . All Models
A . . . Sedan
B . . . 3-Door Coupe
C . . . Liftback
D . . . 2-Door Coupe

(A) OPERATION NAME

(B) REMOVAL DIAGRAM
Describes in detail removal of the damaged part involving repair by cutting.

INSTALLATION



(F)

1. Before temporarily installing the new parts, apply body sealer to the wheel arch.

NOTE:
1) Apply sealer about 5 mm (0.20 in.) from the flange, avoiding any oozing. Oozing will prevent a good weld.
2) Apply evenly, about 3 - 4 mm (0.12 - 0.16 in.) in diameter.

2. Temporarily install the new part, temporarily install the door and laggage compartment door, and check the fit.

(G)

(C) REMOVAL GUIDE
Provides additional information to more efficiently help you perform the removal.

(D) INSTALLATION DIAGRAM
Describes in detail installation of the new part involving repair by welding and/or cutting, but excluding painting.

(E) INSTALLATION GUIDE
Provides additional information to more efficiently help you perform the installation.

(H) SYMBOLS
See page IN-4.

(I) ILLUSTRATION OF WELD POINT
Weld method and panel position symbols.
See page IN-5.

SYMBOLS

The following symbols are used in the Welding Diagrams contained in Section RE of this manual to indicate cutting areas and types of weld required.

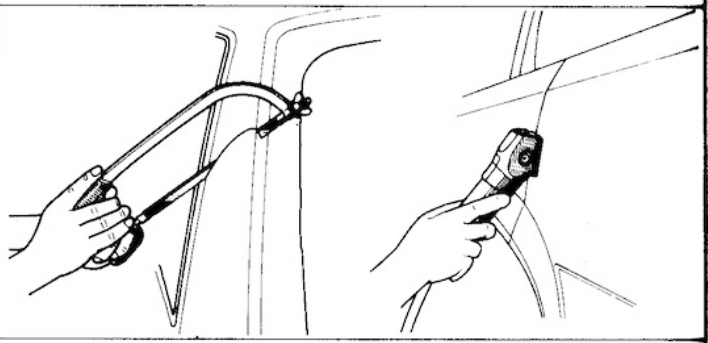
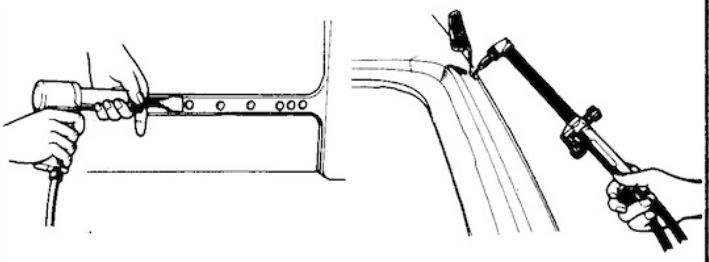
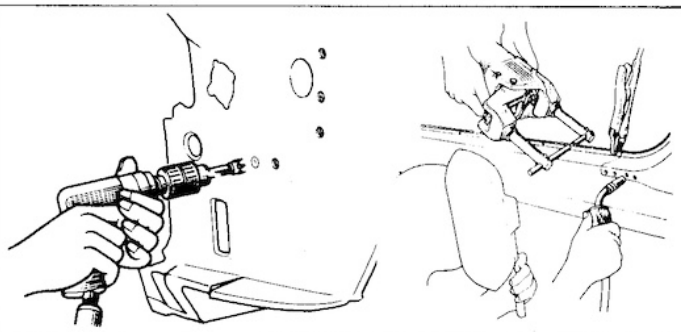
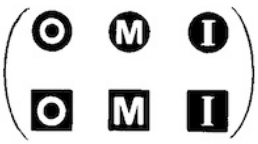
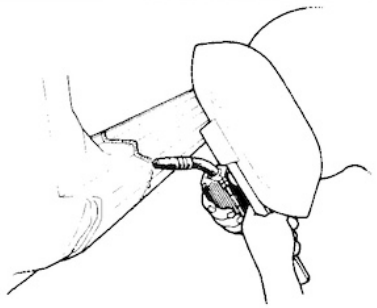
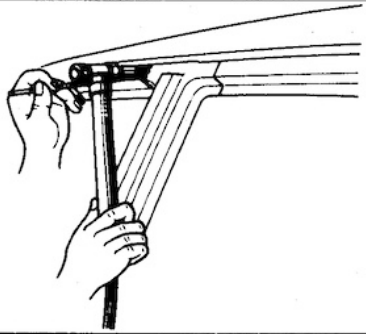
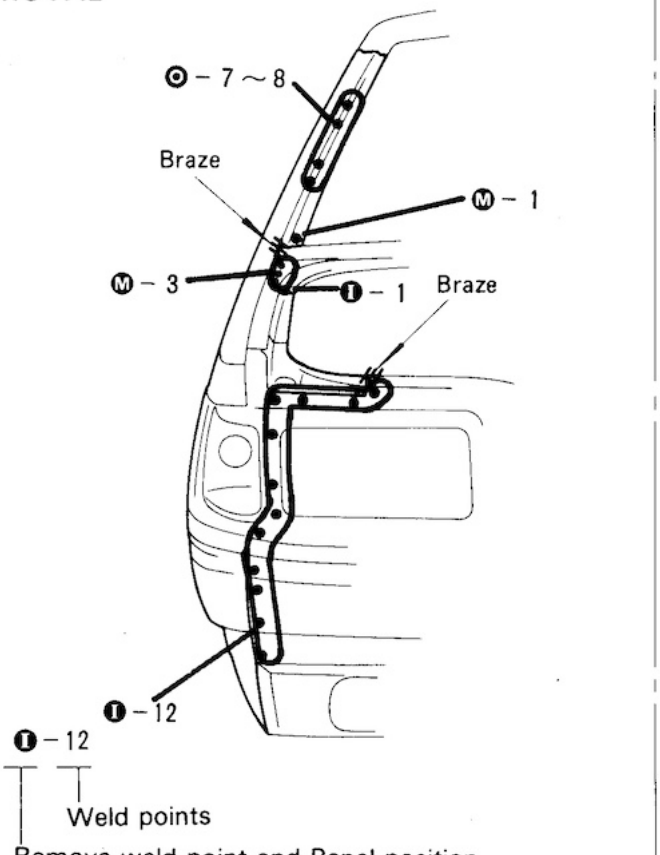
SYMBOLS	NOMENCLATURE	ILLUSTRATION
	SAW CUT OR ROUGH CUT	
	REMOVE BRAZE OR SPOT WELD	
	WELD POINT	
	SPOT WELD OR MIG PLUG WELD (See page IN-5)	
	CONTINUOUS MIG WELD (BUTT WELD)	
	BRAZE	

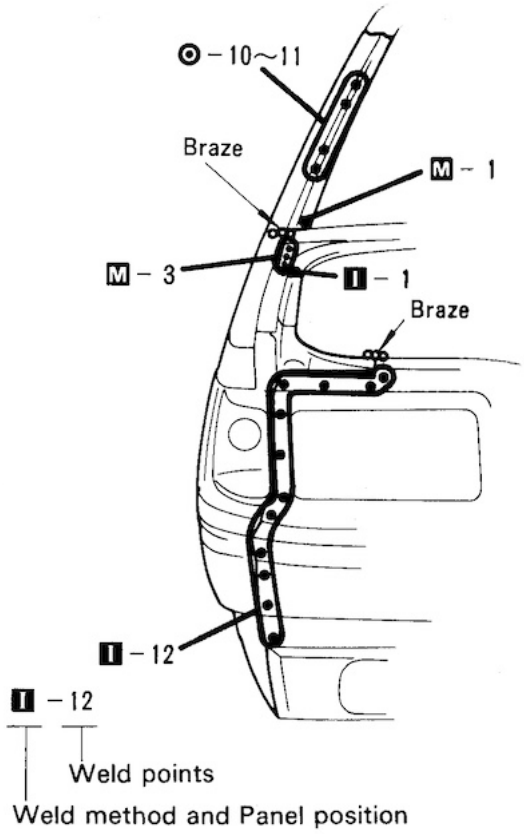
Illustration of Weld Point Symbols

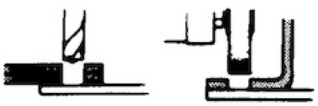
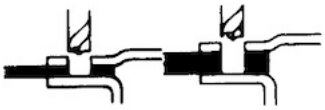
EXAMPLE:

REMOVAL

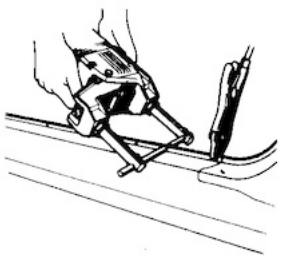
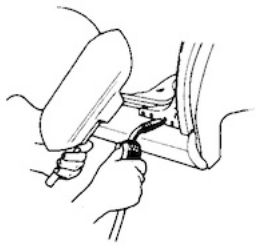
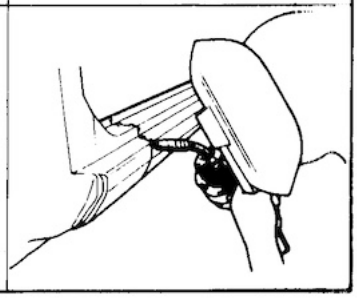


INSTALLATIO"



SYMBOL	NOMENCLATURE	ILLUSTRATION
⊙ Ⓜ Ⓘ	Remove Weld points	
⊙	(Outside)	
Ⓜ	(Middle)	
Ⓘ	(Inside)	

NOTE: Panel position symbols are as seen from the working posture.

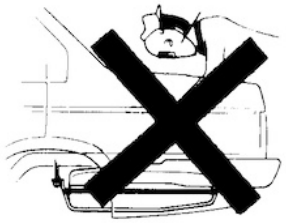
SYMBOL	NOMENCLATURE	ILLUSTRATION
⊙ Ⓜ Ⓘ	Spot weld	
⊙ Ⓜ Ⓘ	MIG Plug Weld	
+	Spot MIG Weld or Tack Weld	

GENERAL REPAIR INSTRUCTIONS

Work Precautions

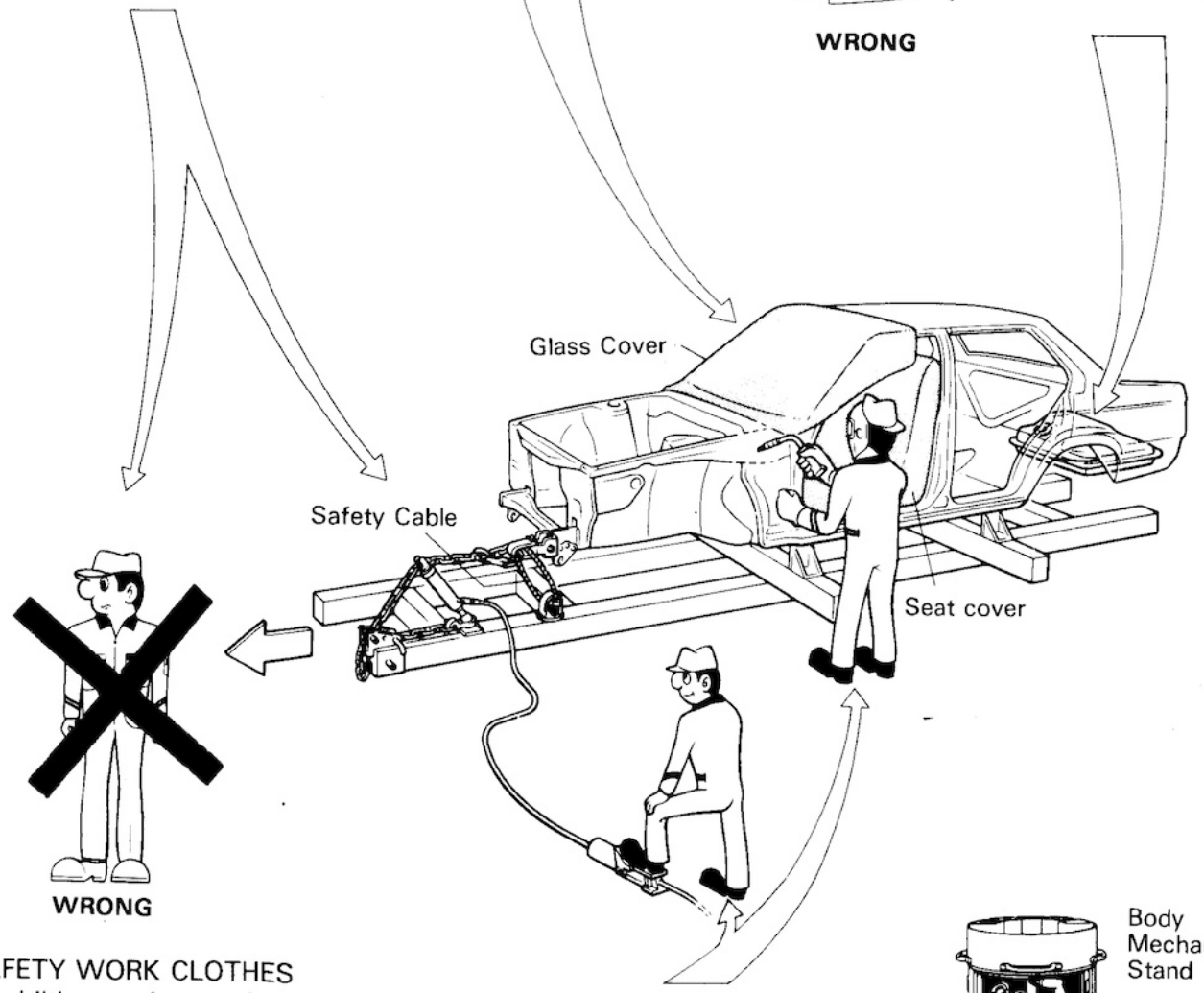
SAFETY
Never stand in direct line with the chain when using a puller on the body or frame, and be sure to attach a safety cable.

VEHICLE PROTECTION
When welding, protect the windows, seats and carpet with heat-resistant, fire-proof covers.



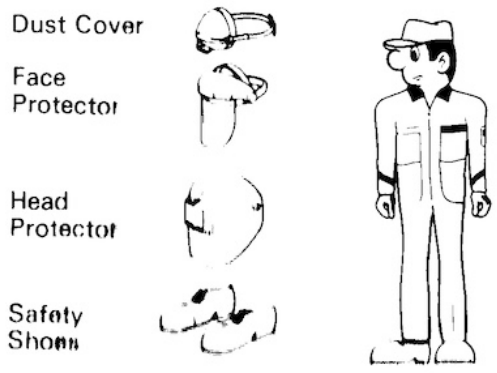
WRONG

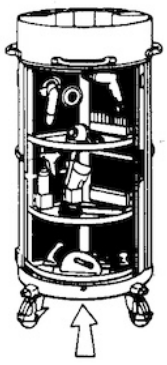
SAFETY
If it is necessary to use a flame in the area of the fuel tank, first remove the tank and plug the fuel line.



WRONG

SAFETY WORK CLOTHES
In addition to the usual mechanic wear, cap and safety shoes, the necessary gloves, mask, glasses, ear plugs, face protector, dust mask, etc. should be worn as the situation demands.





Body Mechanic Stand

HAND TOOLS
Keeping your hand tools in neat order will have an effect on your work efficiency.

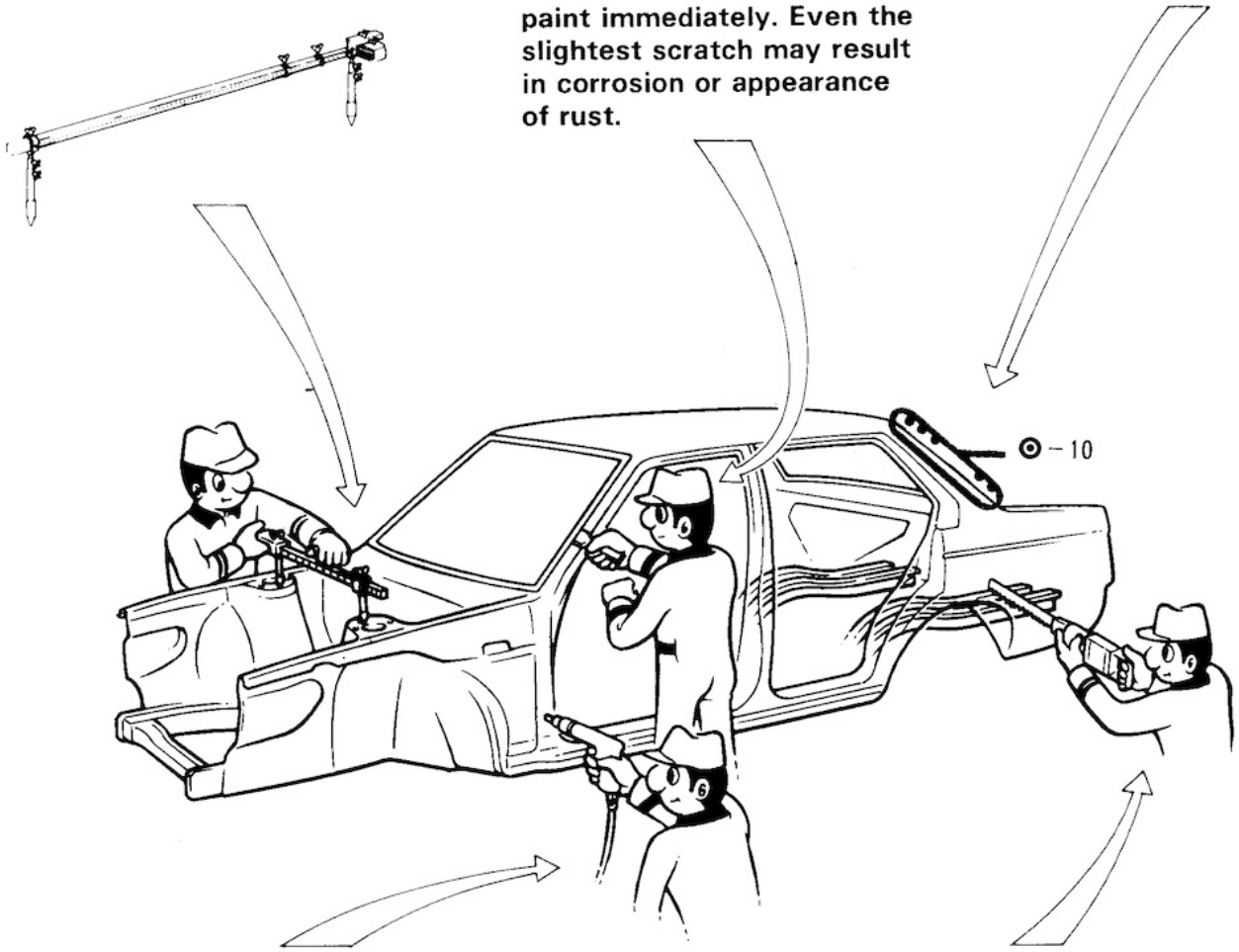
Proper and Efficient Work Procedures

REMOVAL

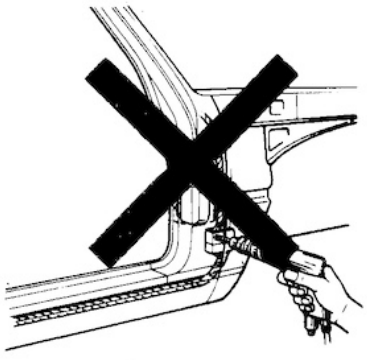
PRE-REMOVAL MEASURING
Before removal or cutting operations, take measurements in accordance with the dimension diagram. Always use a puller to straighten a damaged body or frame.

REMOVAL OF ADJACENT COMPONENTS
When removing adjacent components, apply protective tape to the surrounding body and your tools to prevent damage.
CAUTION:
1. **Be especially careful not to damage screw or clip holes.**
2. **If the paint is accidently scratched, apply touch-up paint immediately. Even the slightest scratch may result in corrosion or appearance of rust.**

NO OF SPOT WELDS
Make a note of the number of spot welds for later reference
NOTE: The number of spot welds may vary depending on the vehicle.

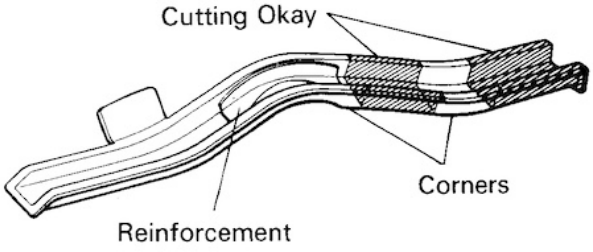


PRECAUTIONS FOR DRILLING OR CUTTING
Check behind any area to be drilled or cut to insure that there are no hoses, wires, etc. that may be damaged.



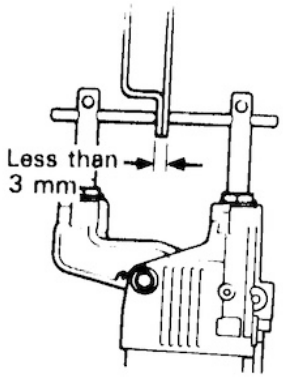
WRONG

CUTTING AREA
Always cut in a straight line and avoid reinforced areas.



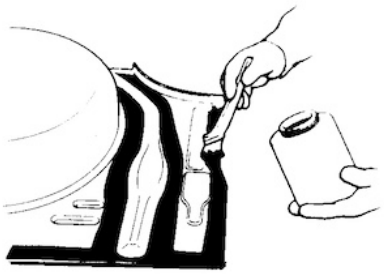
PREPARATION FOR INSTALLATION

SPOT WELD POINTS

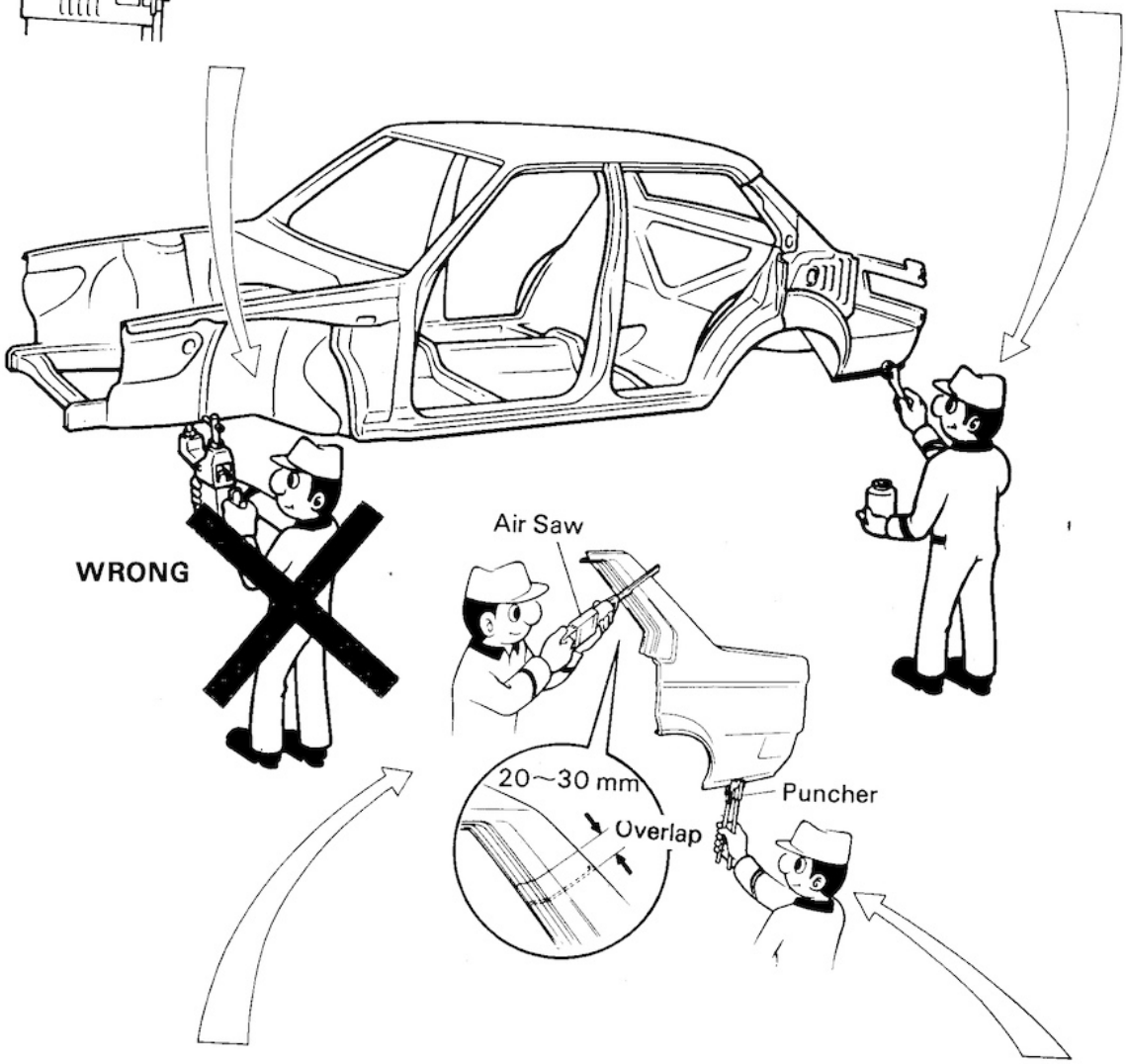


When welding panels with a combined thickness of over 3 mm (0.12 in.), use a MIG (Metal Inert Gas) welder for plug welding.
NOTE: Spot welding will not provide sufficient durability for panels over 3 mm (0.12 in.) thick.

APPLICATION OF WELD-THROUGH PRIMER



For treatment against corrosion, remove the paint from the portion of the new part and body to be welded, and apply weld-through primer.



ROUGH CUTTING OF JOINTS
For joint areas, rough cut the new part, leaving 20 – 30 mm (0.79-1.18 in.) overlap.

MAKING HOLES FOR PLUG WELDING
For areas where a spot welder cannot be used, use a puncher or drill to make holes for plug welding.

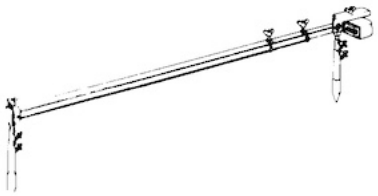
REFERENCE:

mm (in.)

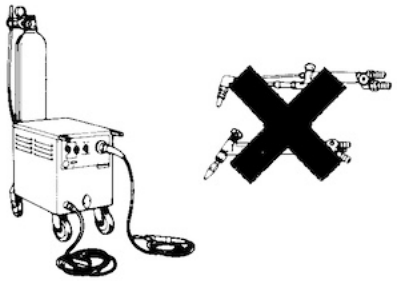
Thickness of welded portion	Size of plug hole
1.0 (0.04) under	5 (0.20) ϕ over
1.0 (0.04) over	6.5 (0.26) ϕ over

INSTALLATION

PRE-WELDING MEASUREMENTS
Always take measurements before installing underbody or engine components to insure correct assembly. After installation, confirm proper fit.



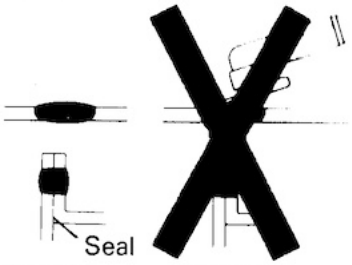
WELDING PRECAUTIONS
1. The number of welding spots should be as follows.
   Spot weld: 1.3 x No. of manufacturer's spots.
   Plug weld: More than No. of manufacturer's plugs.



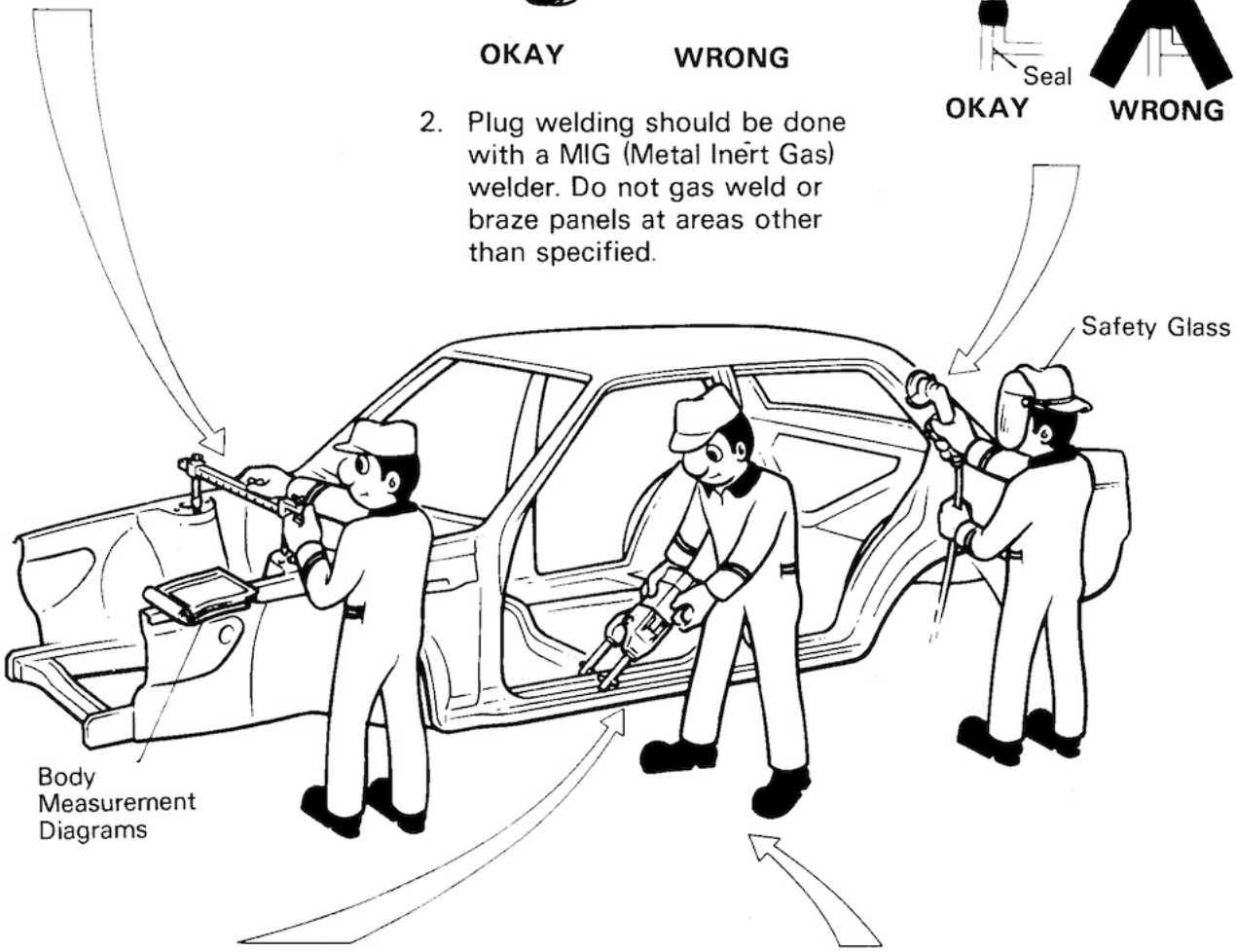
OKAY WRONG

2. Plug welding should be done with a MIG (Metal Inert Gas) welder. Do not gas weld or braze panels at areas other than specified.

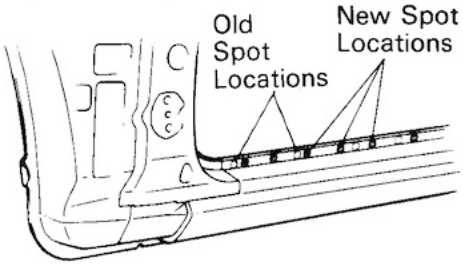
POST-WELDING REFINISHING
1. Always check the welded spots to insure they are secure.
2. When smoothing out the weld spots with a disc grinder, be careful not to grind off too much as this would weaken the weld.



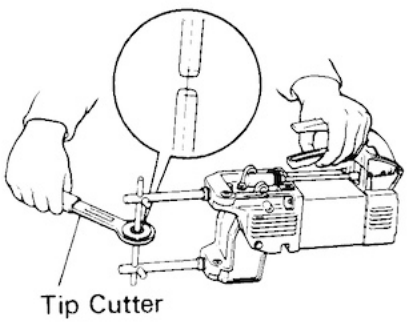
OKAY WRONG



SPOT WELD LOCATIONS
Try to avoid welding over previous spots.



SPOT WELDING PRECAUTIONS



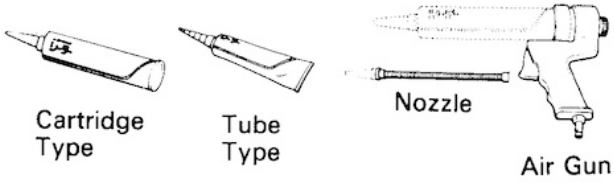
1. The shape of the welding tip point has an effect on the strength of the weld.
2. Always insure that the seams and welding tip are free of paint.

ANTI-CORROSIVE TREATMENT

When replacing body panels, always apply body sealer, anti-rust treatment or undercoating according to the requirements of your country.

BODY SEALER
Apply body sealer to the required areas.

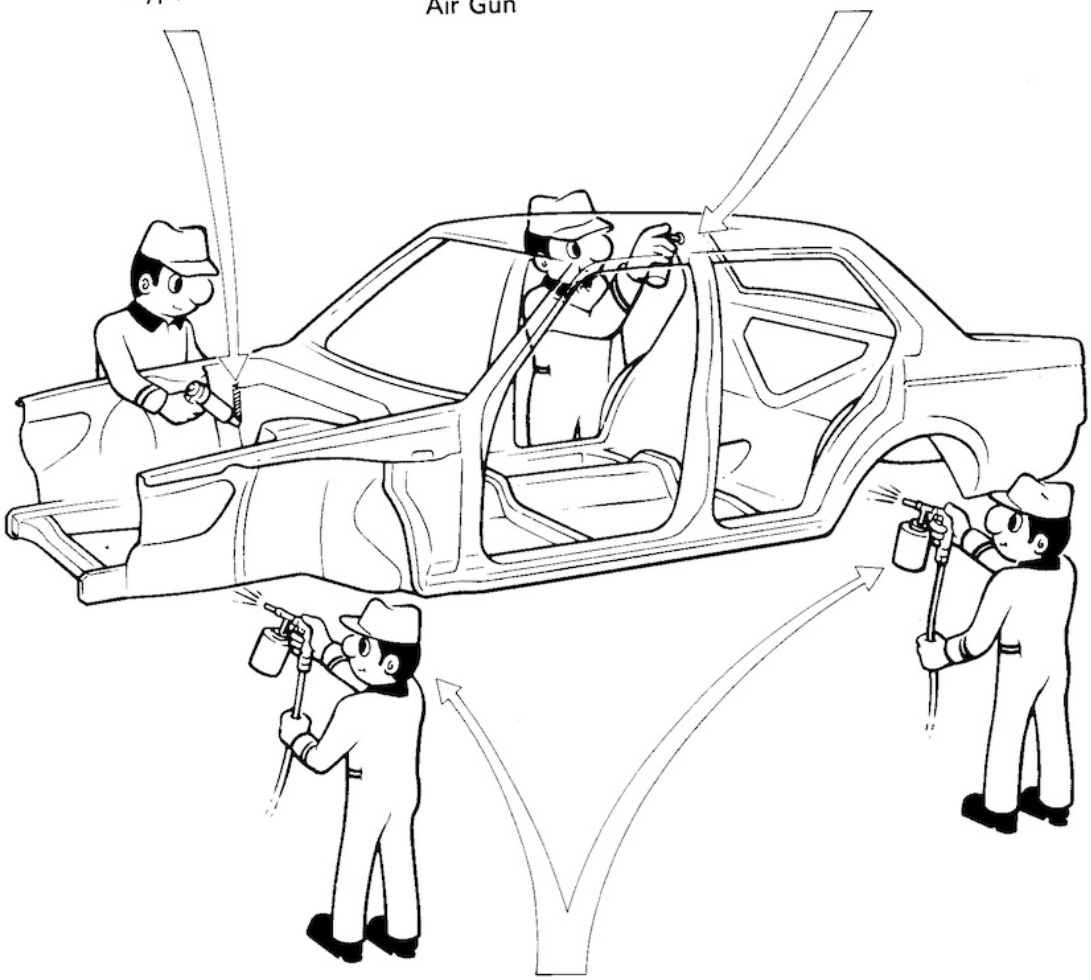
CHASSIS RUST-PROOFING
Anti-rust treatment for welding spots or inside brazed areas (torque box).



Cartridge Type

Tube Type

Air Gun



UNDERCOATING
Anti-rust treatment for underbody welding spots and wheel housings.

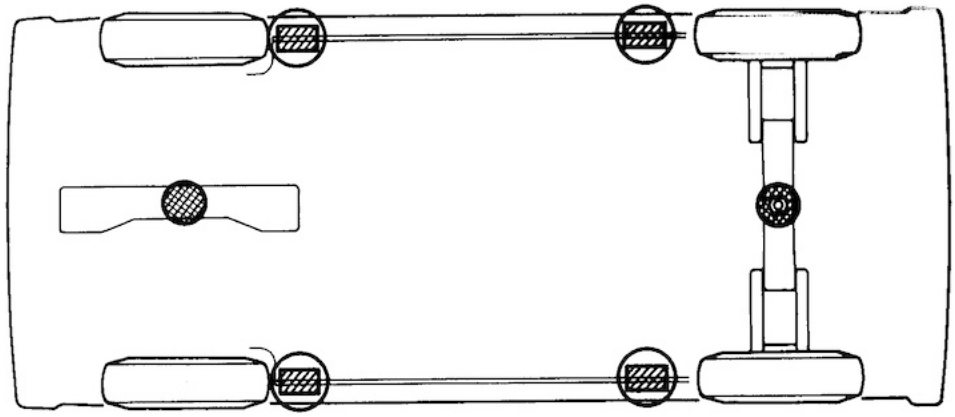
Undercoating (Oil base)

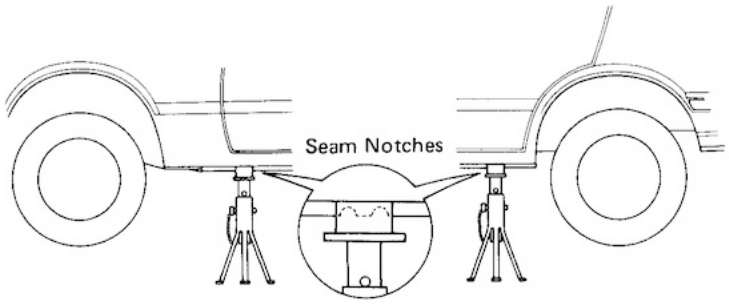
Undercoating (Water base)

Spray Gun

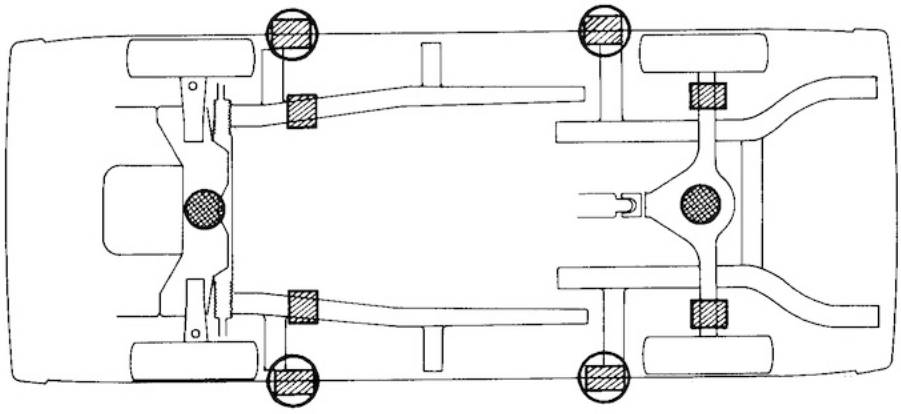
VEHICLE LIFT AND SUPPORT LOCATIONS

Sedan Liftback





Coupe



JACK POSITION

Front	Sedan, Liftback :	Center of engine mounting center member
	Coupe :	Center of front suspension crossmember
Rear	Sedan, Liftback :	Jack up support of rear floor pan
	Coupe :	Center of rear axle housing

PANTOGRAPH JACK POSITION

SUPPORT POSITION

Safety stand .....

ABBREVIATIONS USED IN THIS MANUAL

For convenience, the following abbreviations are used in this manual.

Assy, assy	Assembly, assembly
Sub-assy	Sub-assembly
Ex.	Except
MIG	Metal Inert Gas
OPN	Operation
SP	Spot Weld (Resistance Spot Weld)
W/	With
W/O	Without
FR	Front
RR	Rear
RH	Right-hand
RHD	Right-hand Drive
LH	Left-hand
LHD	Left-hand Drive
SED	Sedan
LB	Liftback

BODY PANEL REPLACEMENT

Page

FRONT BODY COMPONENTES

OPN NO.1100A, C FRONT CROSSMEMBER (ASSY) RE-2
OPN NO.1100B, D FRONT CROSSMEMBER (ASSY) RE-4
OPN NO.1200A, C RADIATOR SUPPORT (ASSY) RE-6
OPN NO.1200B, D RADIATOR SUPPORT (ASSY) RE-8
OPN NO.1300A, C RADIATOR UPPER SUPPORT (ASSY) RE-10
OPN NO.1300B, D RADIATOR UPPER SUPPORT (ASSY) RE-12
OPN NO.1400A, C FRONT FENDER APRON (ASSY) RE-14
OPN NO.1400B, D FRONT FENDER APRON (ASSY) RE-16
OPN NO.1410A, C FRONT FENDER APRON (CUT) RE-18
OPN NO.1410B, D FRONT FENDER APRON (CUT) RE-20
OPN NO.1500A, C FRONT SIDE MEMBER (ASSY) RE-22
OPN NO.1500B, D FRONT SIDE MEMBER (ASSY) RE-24

CENTER BODY COMPONENTS

OPN NO.2110A, C FRONT BODY PILLAR (CUT) RE-26
OPN NO.2110B, D FRONT BODY PILLAR (CUT) RE-28
OPN NO.2210A, C CENTER BODY PILLAR (CUT) RE-30
OPN NO.2300A, C OUTER ROCKER PANEL (ASSY) RE-32
OPN NO.2300B, D OUTER ROCKER PANEL (ASSY) RE-34
OPN NO.2310A, C OUTER ROCKER PANEL (CUT) RE-36
OPN NO.2310B, D OUTER ROCKER PANEL (CUT) RE-38
OPN NO.2400A ROOF PANEL (ASSY) RE-40
OPN NO.2400C ROOF PANEL (ASSY) RE-42
OPN NO.2400D ROOF PANEL (ASSY) RE-44
OPN NO.2400B ROOF PANEL (ASSY) RE-46
OPN NO.2401 ROOF PANEL W/ SUN ROOF (ASSY) RE-48
OPN NO.2500A, C FRONT DOOR OUTER PANEL (ASSY) RE-50
OPN NO.2500B, D FRONT DOOR OUTER PANEL (ASSY) RE-52
OPN NO.2600A, C REAR DOOR OUTER PANEL (ASSY) RE-54

REAR BODY COMPONENTS

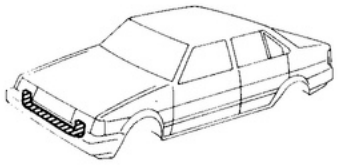
OPN NO.3210A QUARTER PANEL (CUT) RE-56
OPN NO.3210C QUARTER PANEL (CUT) RE-58
OPN NO.3210D QUARTER PANEL (CUT) RE-60
OPN NO.3210B QUARTER PANEL (CUT) RE-62
OPN NO.3230A QUARTER PANEL (CUT) RE-64
OPN NO.3230C QUARTER PANEL (CUT) RE-66
OPN NO.3230D QUARTER PANEL (CUT) RE-68
OPN NO.3230B QUARTER PANEL (CUT) RE-70
OPN NO.3300A BODY LOWER BACK PANEL (ASSY) RE-72
OPN NO.3300C BODY LOWER BACK PANEL (ASSY) RE-74
OPN NO.3300D BODY LOWER BACK PANEL (ASSY) RE-76
OPN NO.3300B BODY LOWER BACK PANEL (ASSY) RE-78
OPN NO.3500B, D REAR VALANCE PANEL (ASSY) RE-80
OPN NO.3700A, C QUARTER WHEEL HOUSING OUTER PANEL (ASSY) RE-82
OPN NO.3700B, D QUARTER WHEEL HOUSING OUTER PANEL (ASSY) RE-84

REAR UNDER BODY COMPONENTS

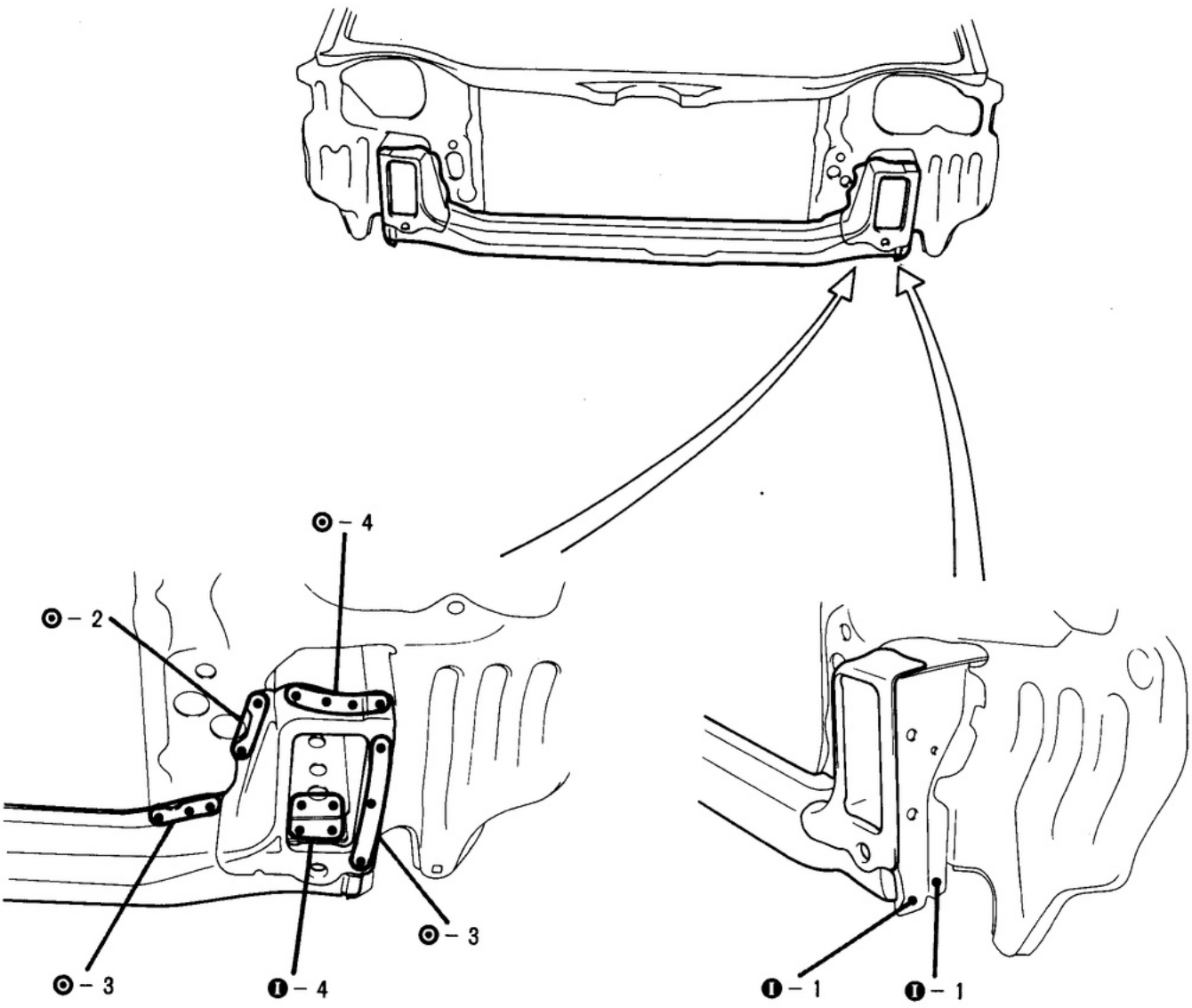
OPN NO.4110A, C REAR FLOOR PAN (CUT) RE-86
OPN NO.4100B, D REAR FLOOR PAN (ASSY)..... RE-88
OPN NO.4200A, C REAR FLOOR REAR SIDE MEMBER (ASSY) RE-90
OPN NO.4300A, C REAR FLOOR SIDE MEMBER (ASSY) RE-92
OPN NO.4300B, D REAR FLOOR SIDE MEMBER (ASSY) RE-94
OPN NO.4310B, D REAR FLOOR SIDE MEMBER (CUT) RE-96
OPN NO.4600A, C REAR FLOOR CROSSMEMBER NO.2 (ASSY) RE-98
OPN NO.4600B, D REAR FLOOR CROSSMEMBER NO.2 (ASSY) RE-100

1100A, C FRONT CROSSMEMBER (ASSY)

Sedan, Liftback

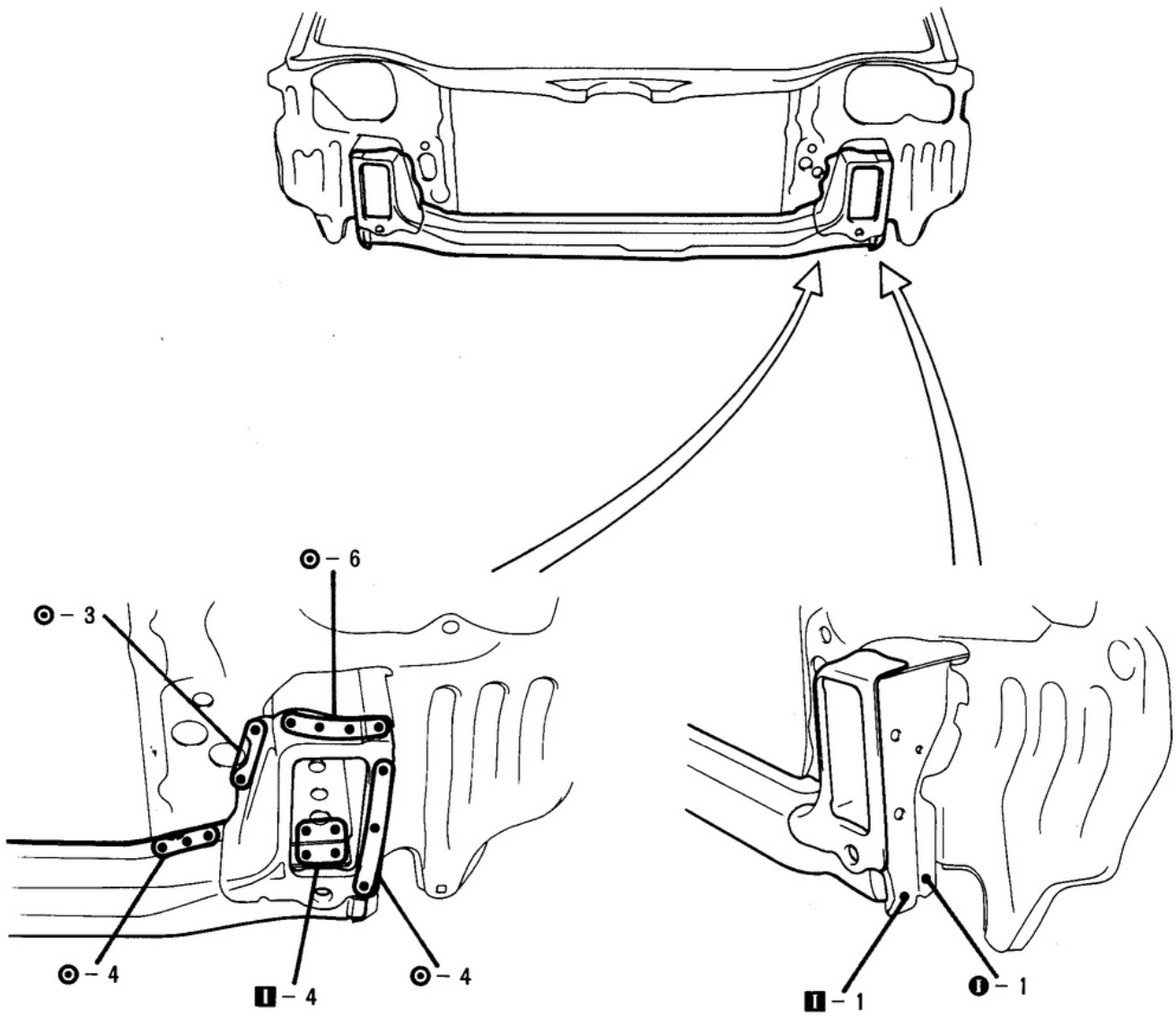


REMOVAL



1. Rough cut the lower portion of the crossmember for the lower surface of the front side member weld points, and remove from the bottom

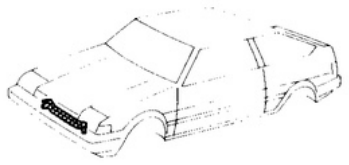
INSTALLATION



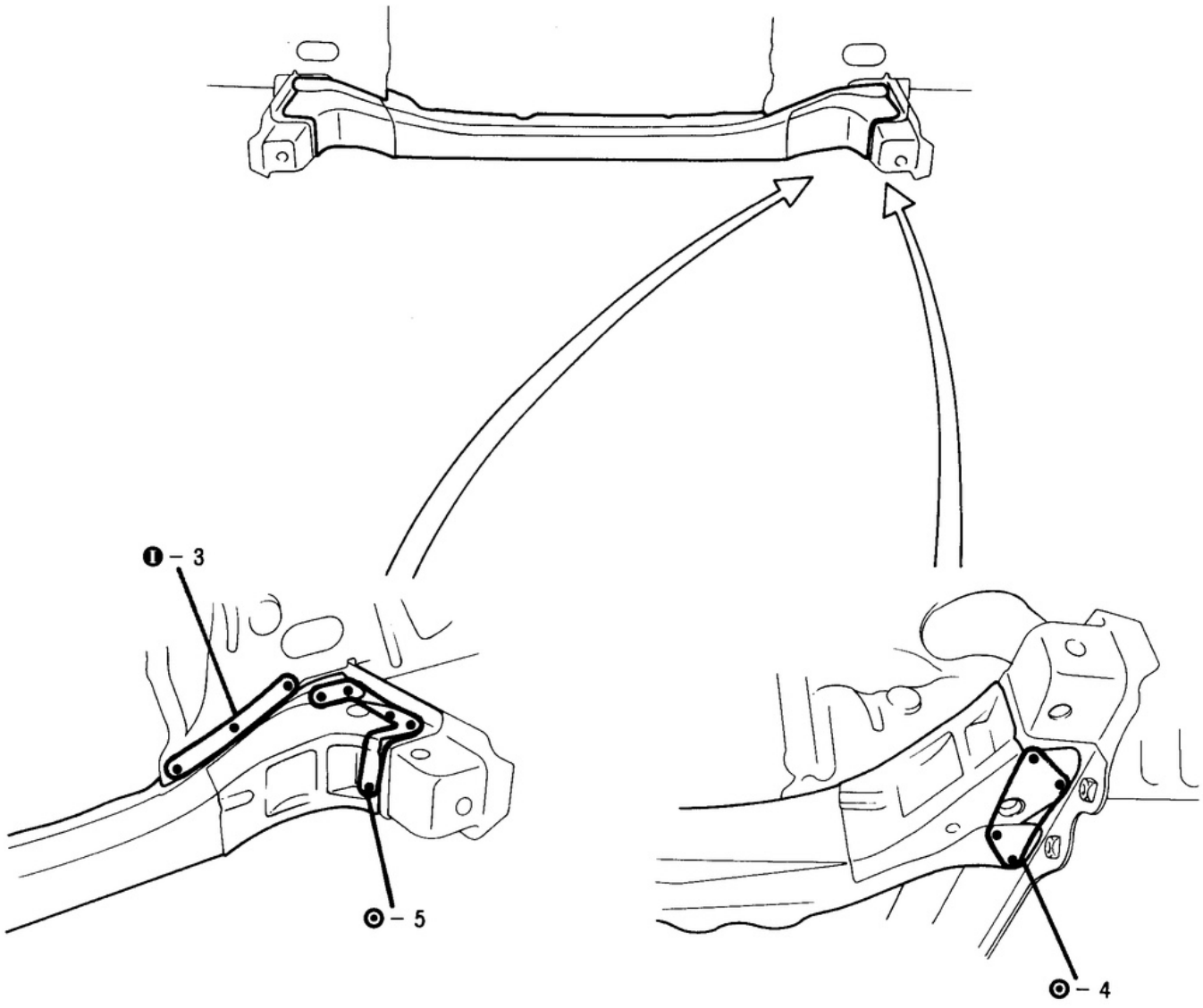
1. Temporarily install the new part, and measure each part in accordance with the body dimension diagram.

1100B, D FRONT CROSSMEMBER (ASSY)

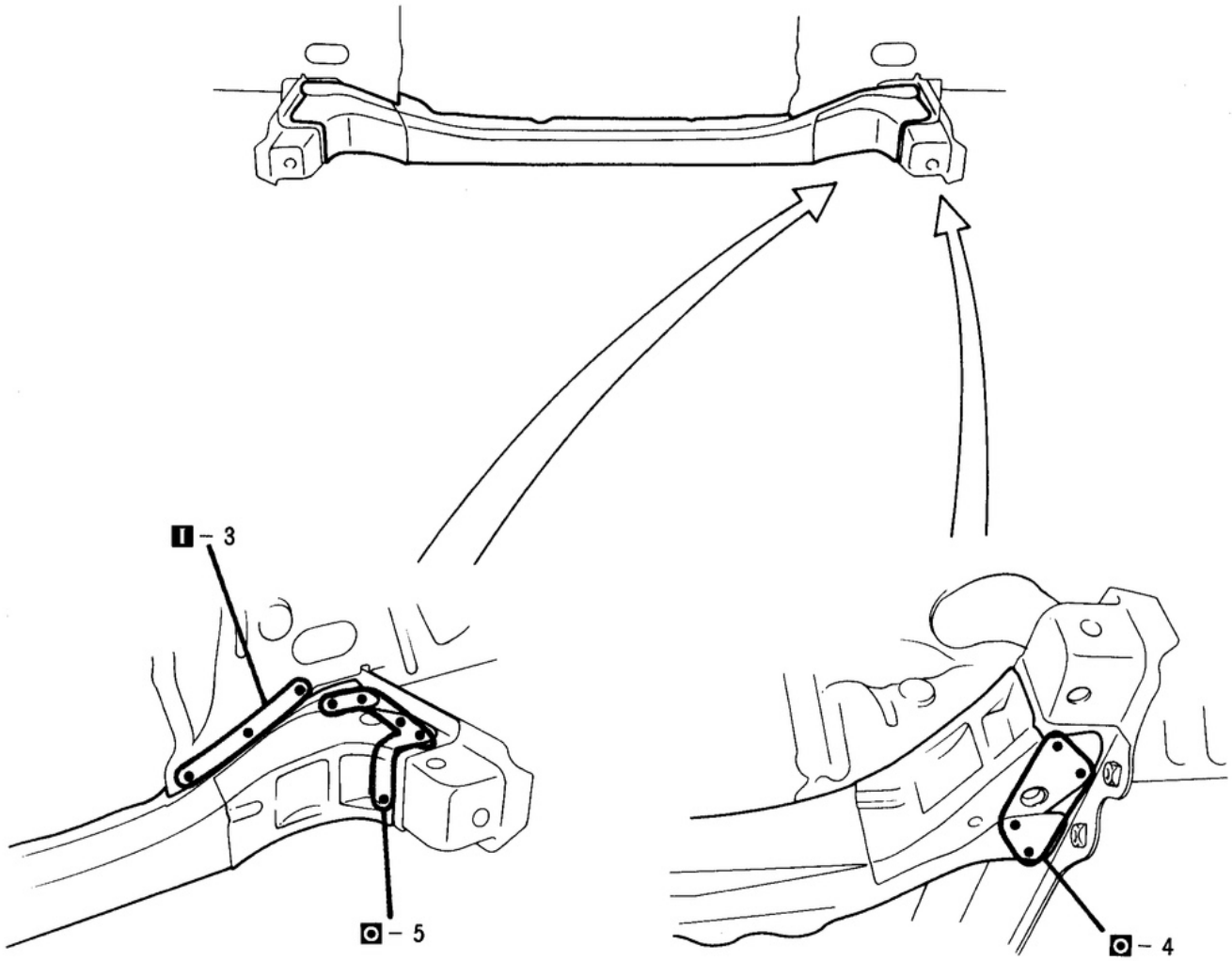
Coupe



REMOVAL



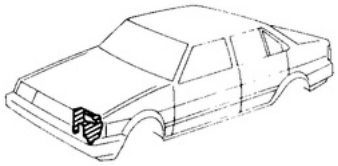
INSTALLATION



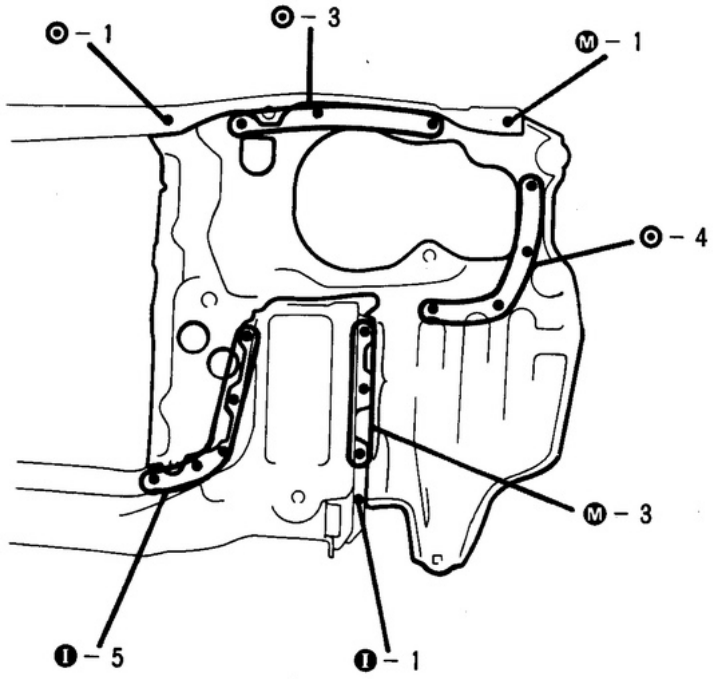
1. Temporarily install the new part, and measure each part in accordance with the body dimension diagram.
2. After measuring, install the strut bar bracket for installation of the front crossmember.

1200A, C RADIATOR SUPPORT (ASSY)

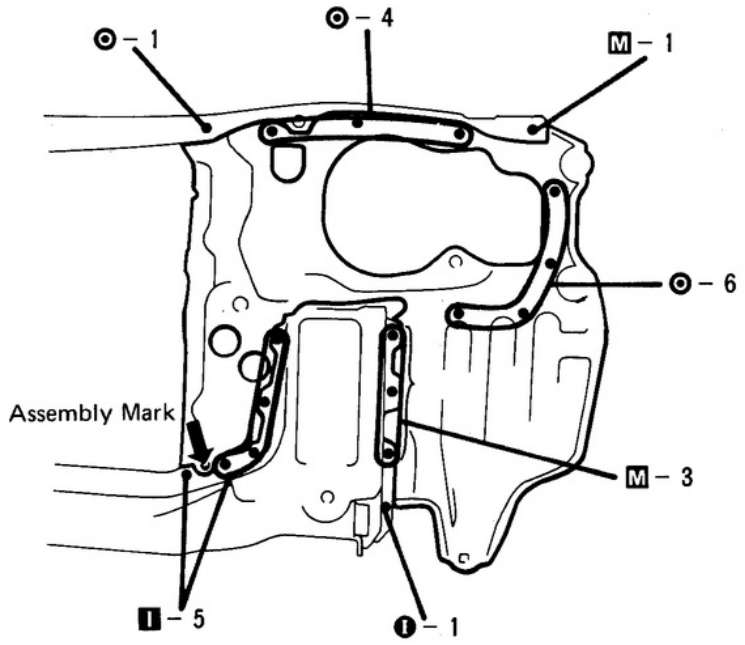
Sedan, Liftback



REMOVAL



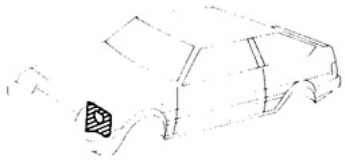
INSTALLATION



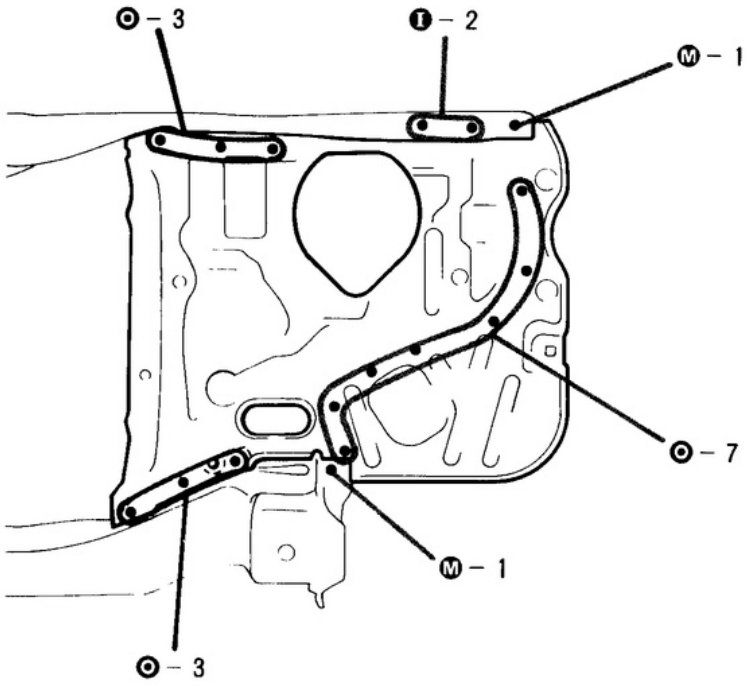
1. Align the new parts with the basic assembly mark, and temporarily install them.
2. Measure each part in accordance with the body dimension diagram.

1200B, D RADIATOR SUPPORT (ASSY)

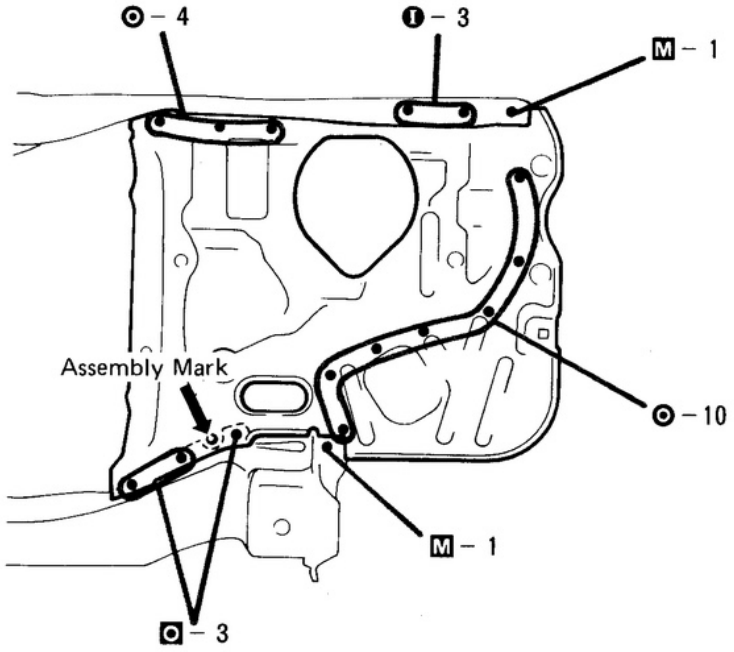
Coupe



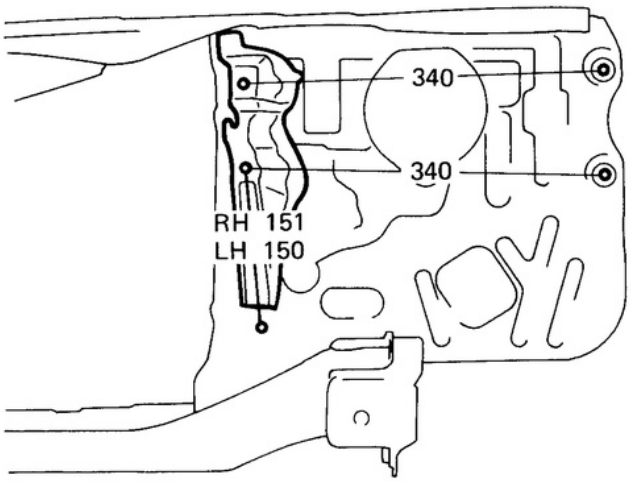
REMOVAL



INSTALLATION



Headlight Mounting Bracket
Installation Measurement (mm)



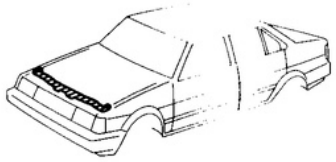
Conversion Table

mm	in.
150	5.91
151	5.94
340	13.39

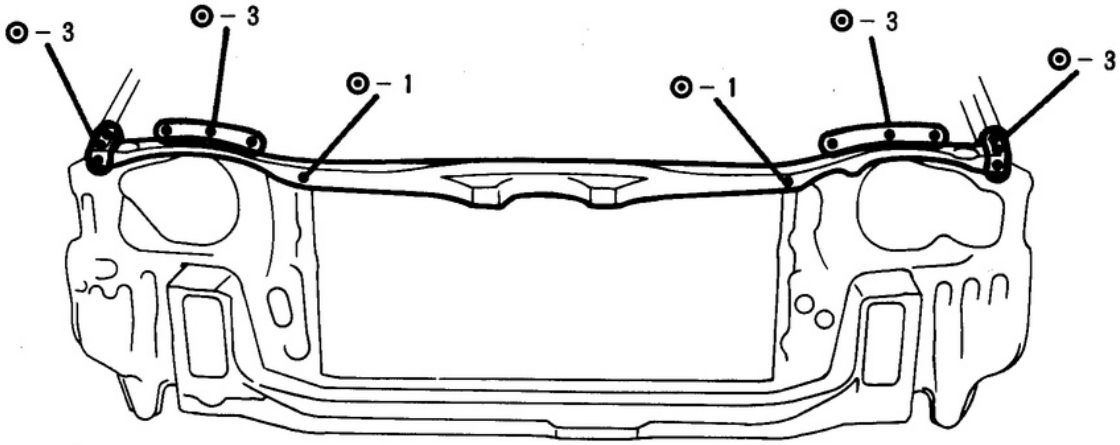
1. Align the new parts with the basic assembly marks, and temporarily install them.
2. Measure each part in accordance with the body dimension diagram.
3. Install the headlight mounting bracket as shown above.

1300A, C RADIATOR UPPER SUPPORT(ASSY)

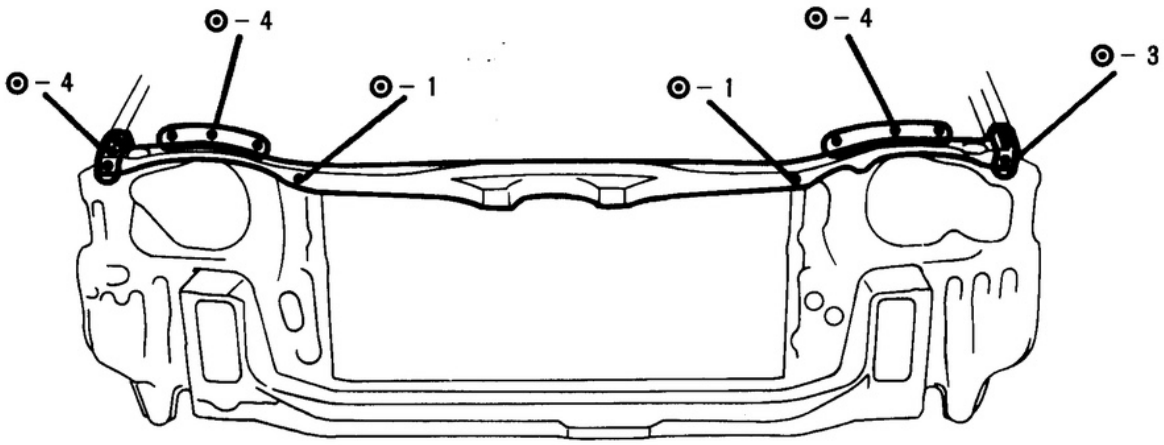
Sedan, Liftback



REMOVAL



INSTALLATION

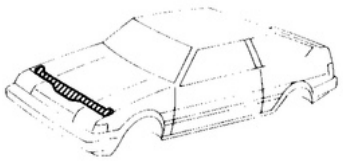


1. Temporarily install the new parts, and measure each part in accordance with the body dimension diagram.

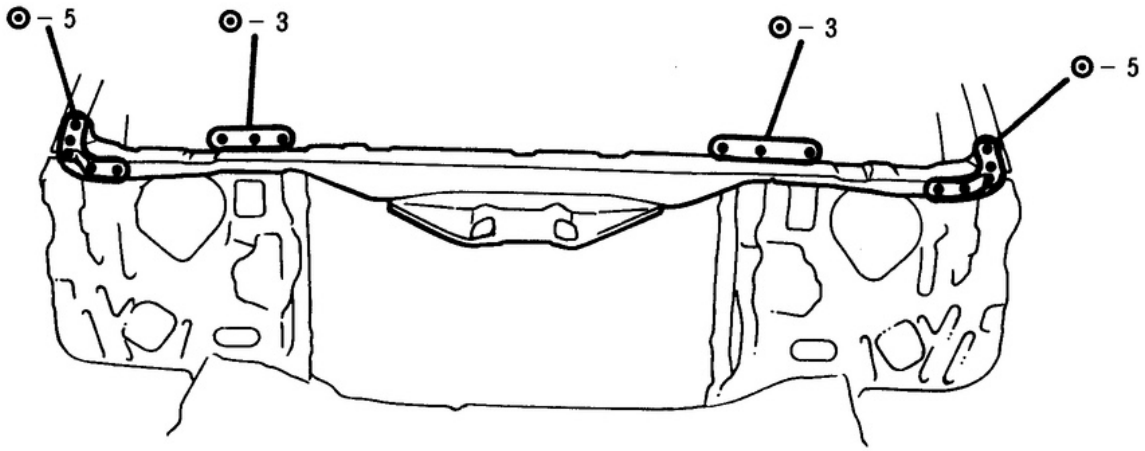
NOTE: The hood lock support should be installed.

1300B, D RADIATOR UPPER SUPPORT(ASSY)

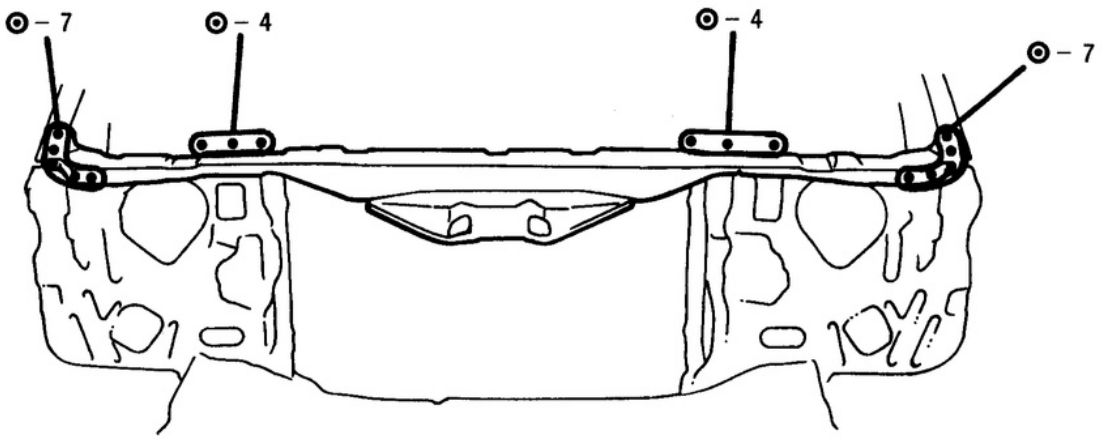
Coupe



REMOVAL



INSTALLATION

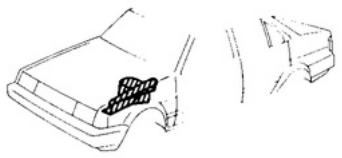


1. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.

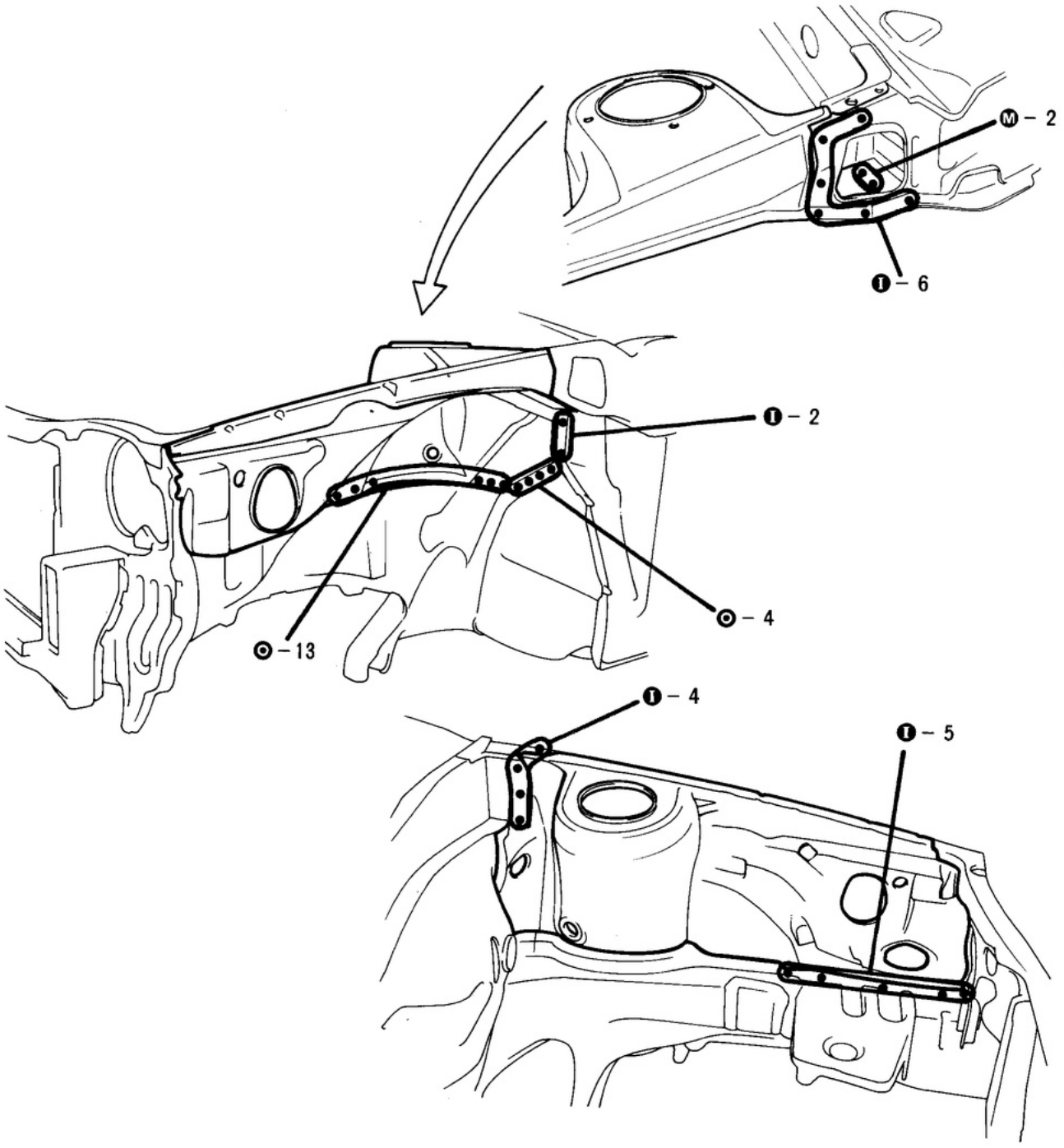
NOTE: The hood lock support should be installed.

1400A, C FRONT FENDER APRON (ASSY)

Sedan, Liftback

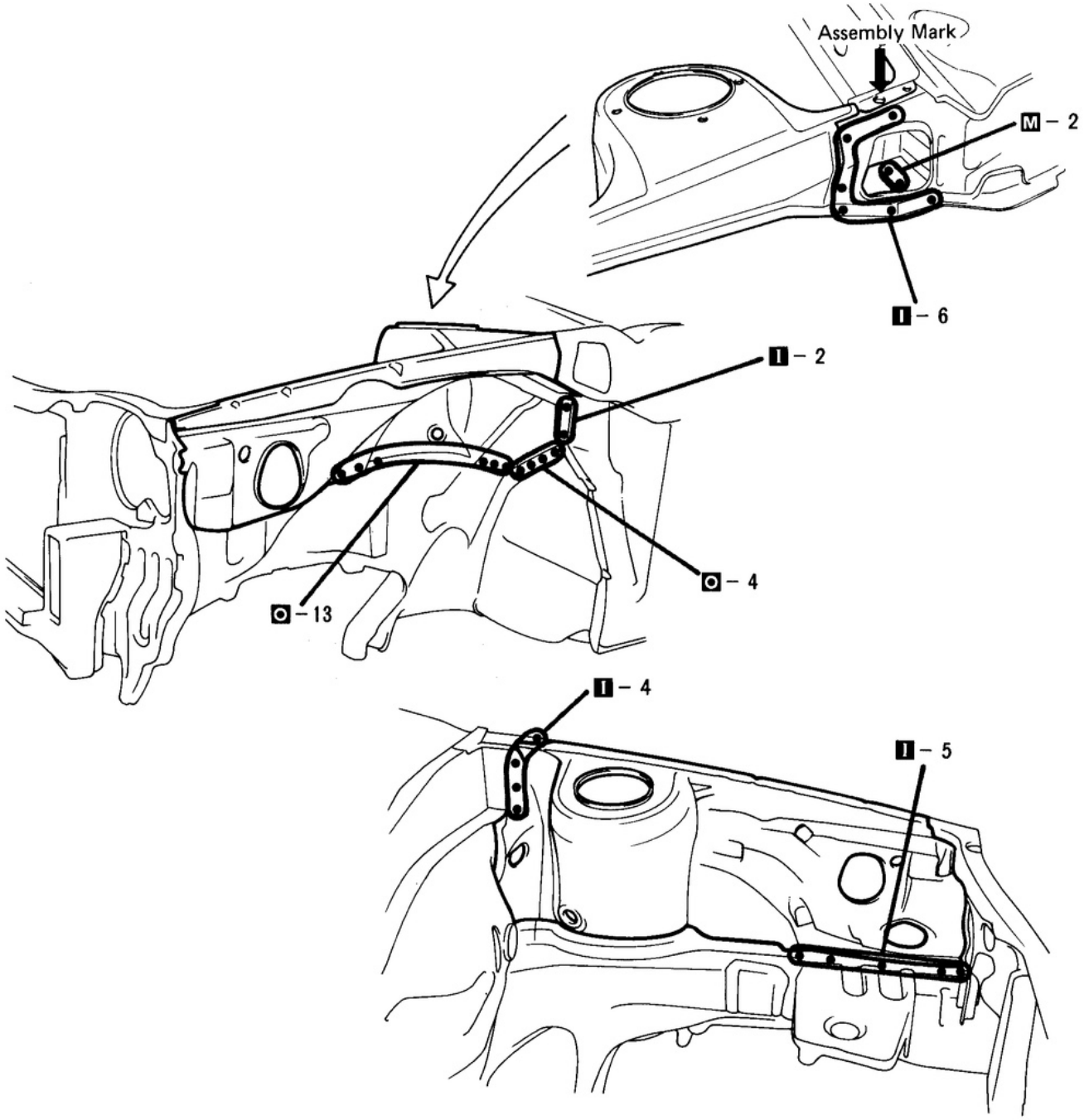


REMOVAL



1. Before removing the front fender apron, mark the position to assist in reinstallation.

INSTALLATION



1. Temporarily install the new part with the basic assembly mark and scribing mark.
2. Measurements must be accurate as these parts have an effect on front wheel alignment.

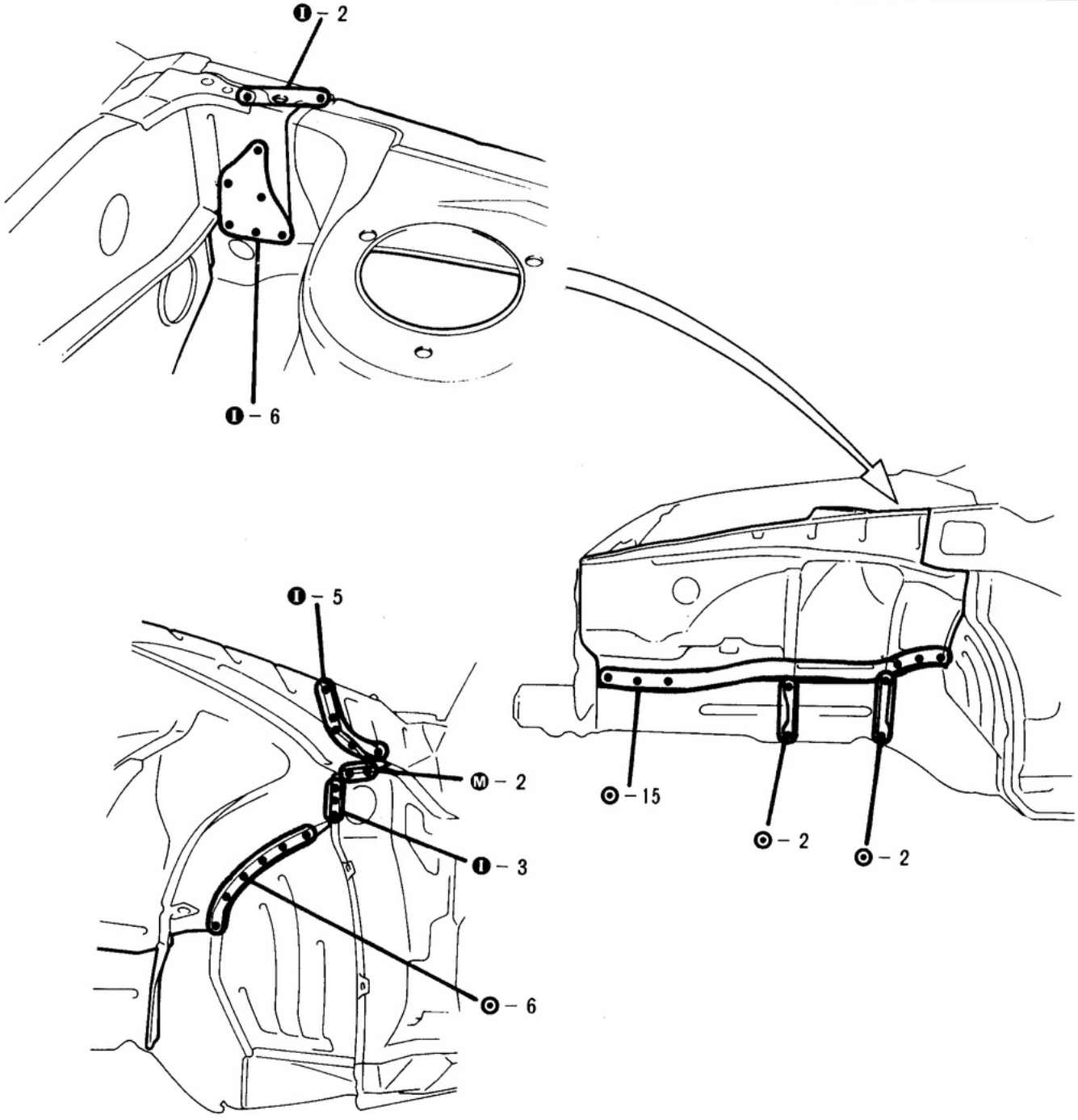
NOTE: The position of the front spring support hole is very important.

3. Install the front fender and hood and then check the fit.

1400B, D FRONT FENDER APRON (ASSY)

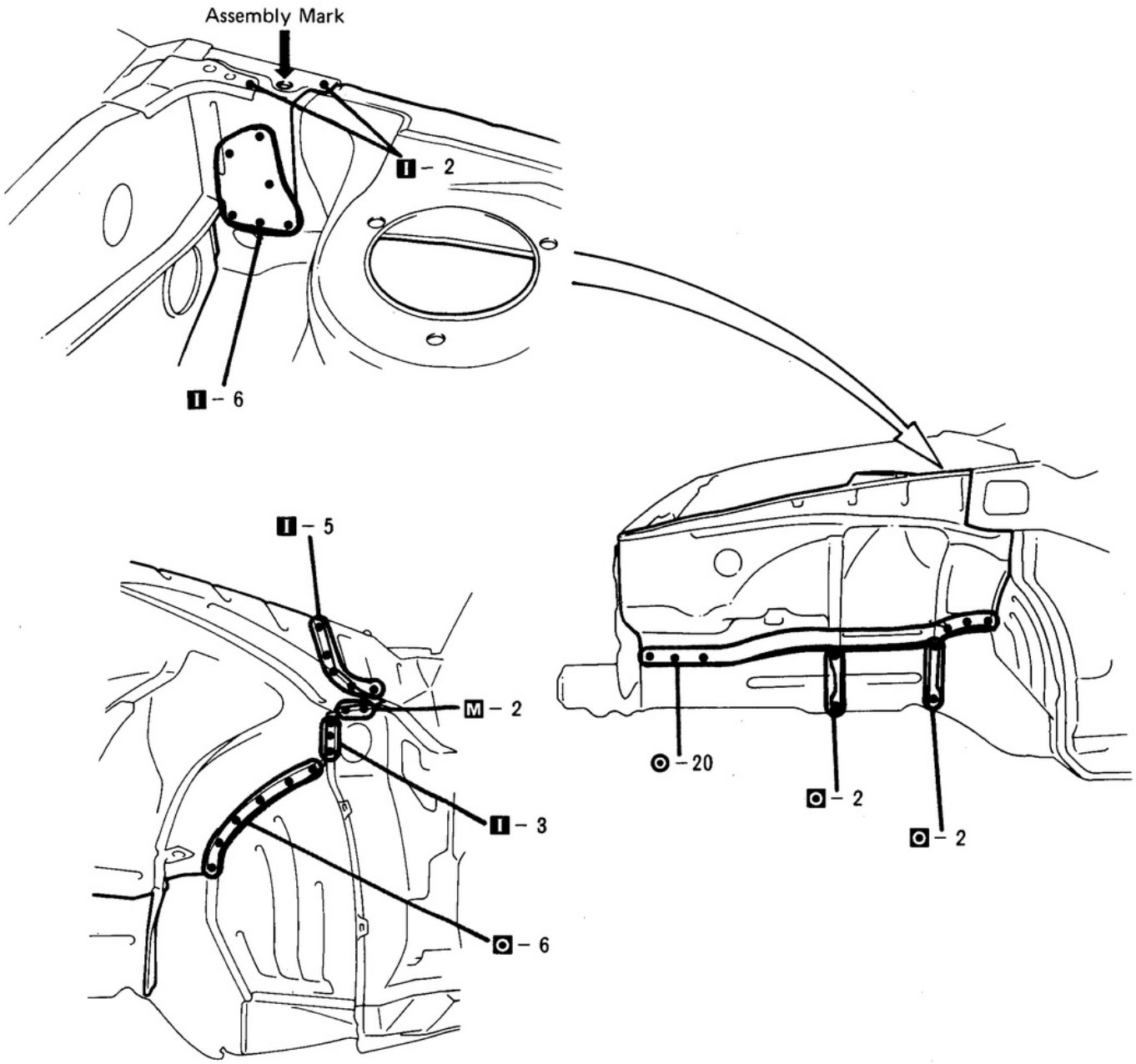
Coupe

REMOVAL



1. Before removing the front fender apron, mark the position to assist in reinstallation.

INSTALLATION



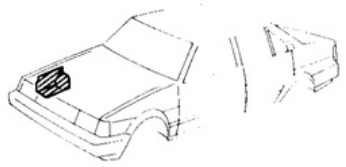
1. Temporarily intall the new part with the basic assembly mark and scribing mark.
2. Measurements must be accurate as these parts have and effect on front wheel alignment.

NOTE: The position of the front spring support hole is very important.

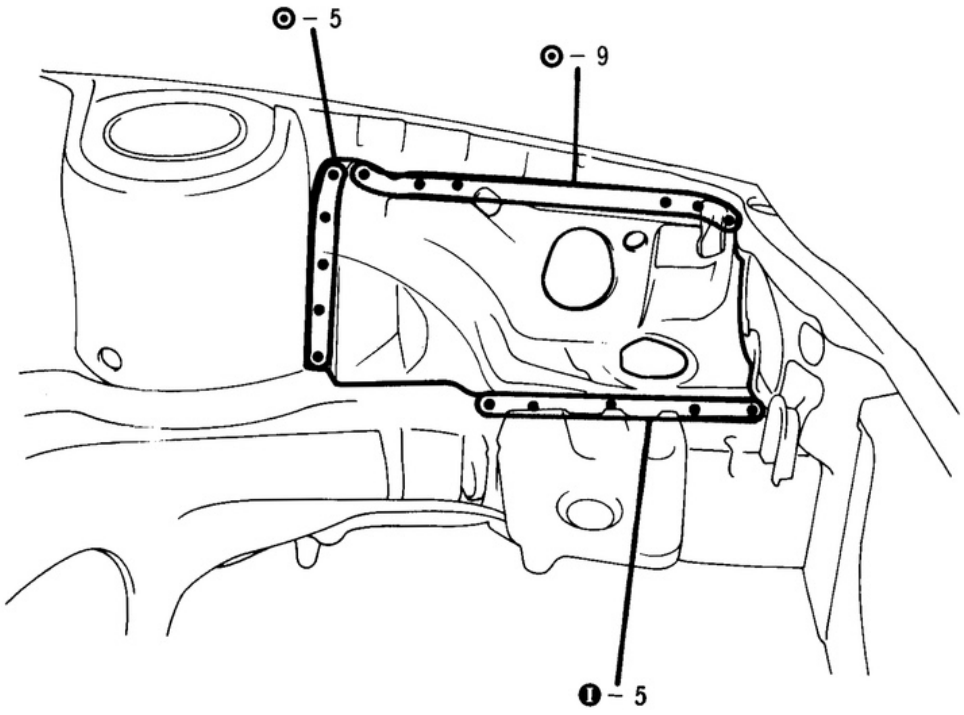
3. Install the front fender and hood and then check the fit.

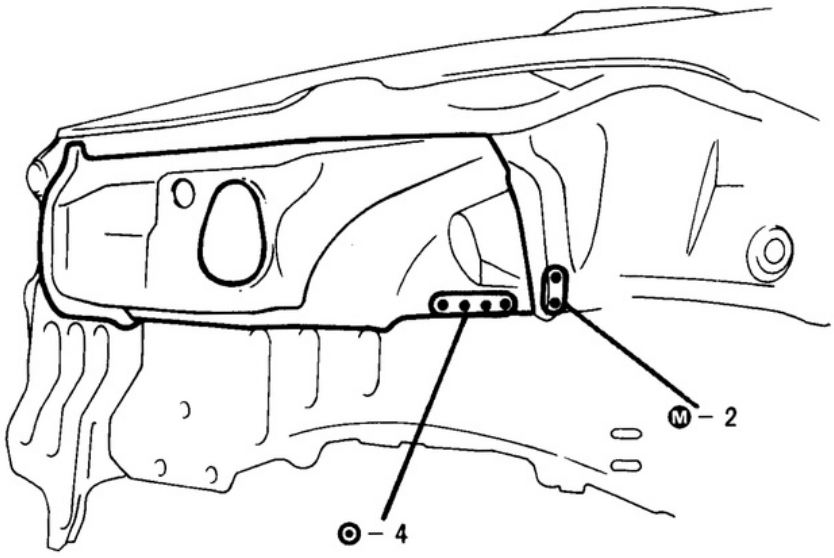
1410A, C FRONT FENDER APRON (CUT)

Sedan, Liftback

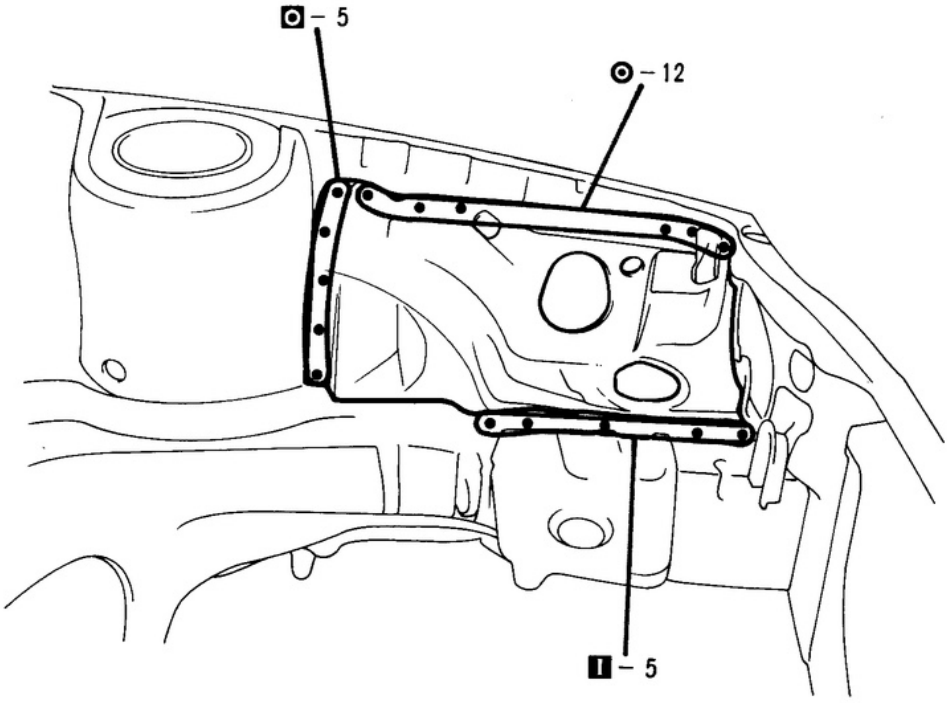


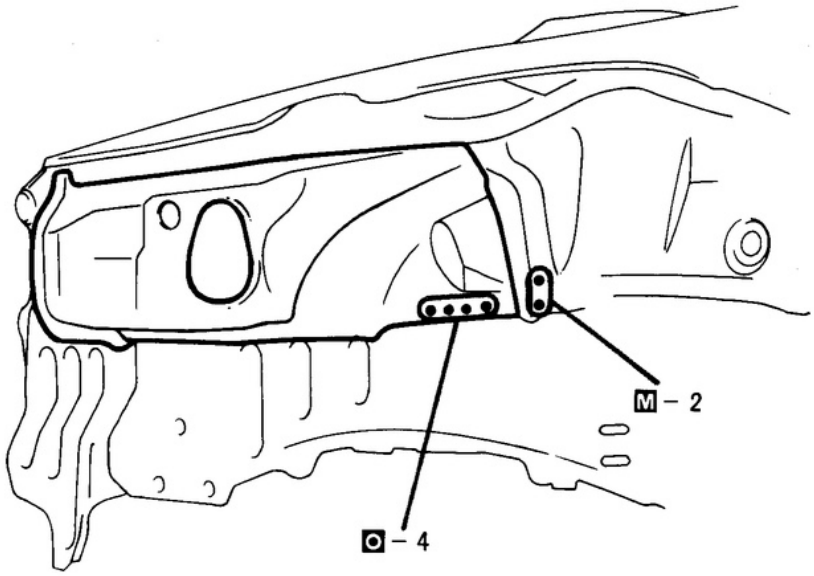
REMOVAL





INSTALLATION

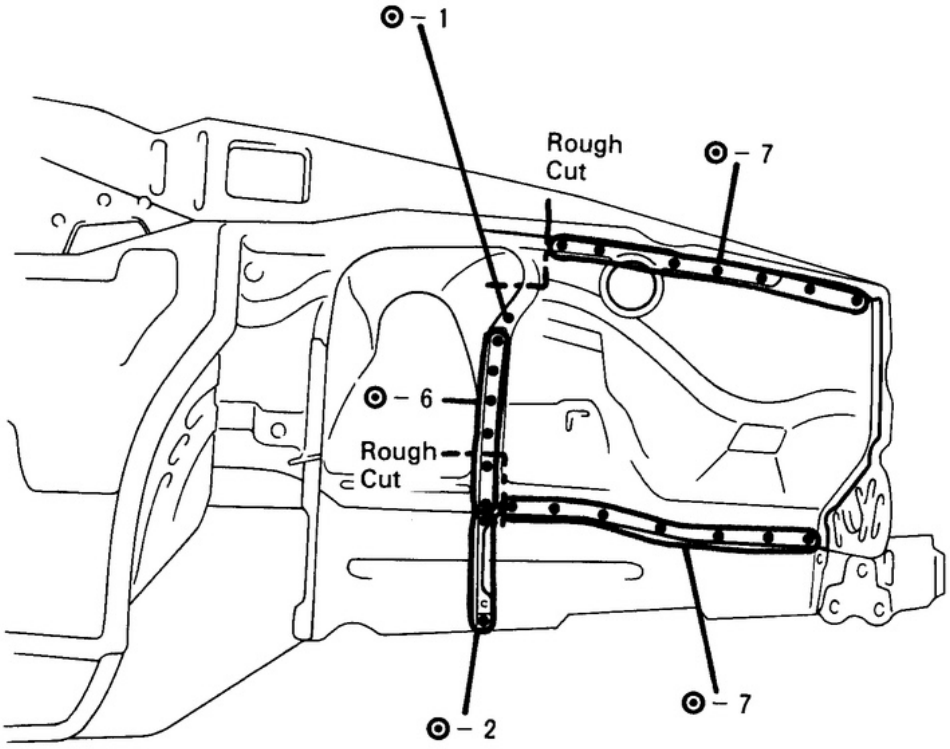




1410B, D FRONT FENDER APRON (CUT)

Coupe

REMOVAL



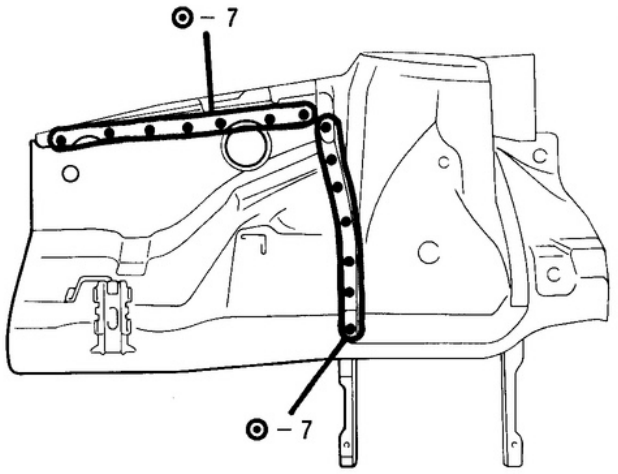
Front Fender RH Apron as seen from the out side.

1. After remove the spot welds, rough cut the front fender apron shown above.

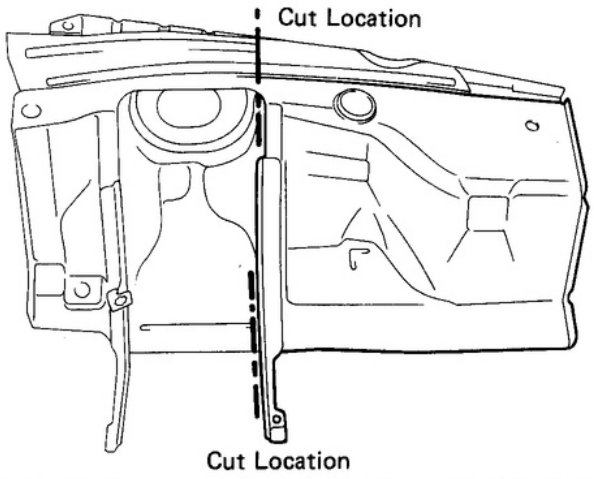
INSTALLATION

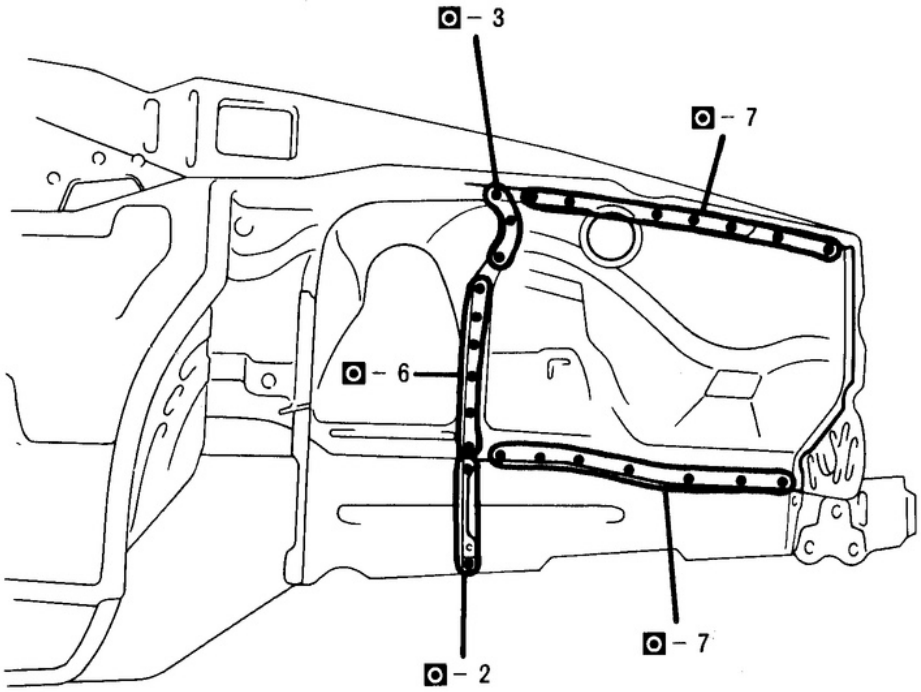
Cut for supply part.

1. Remove the spot welds.



2. Cut the panel.

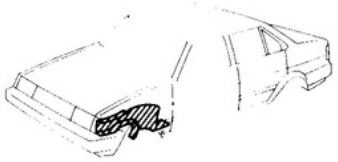




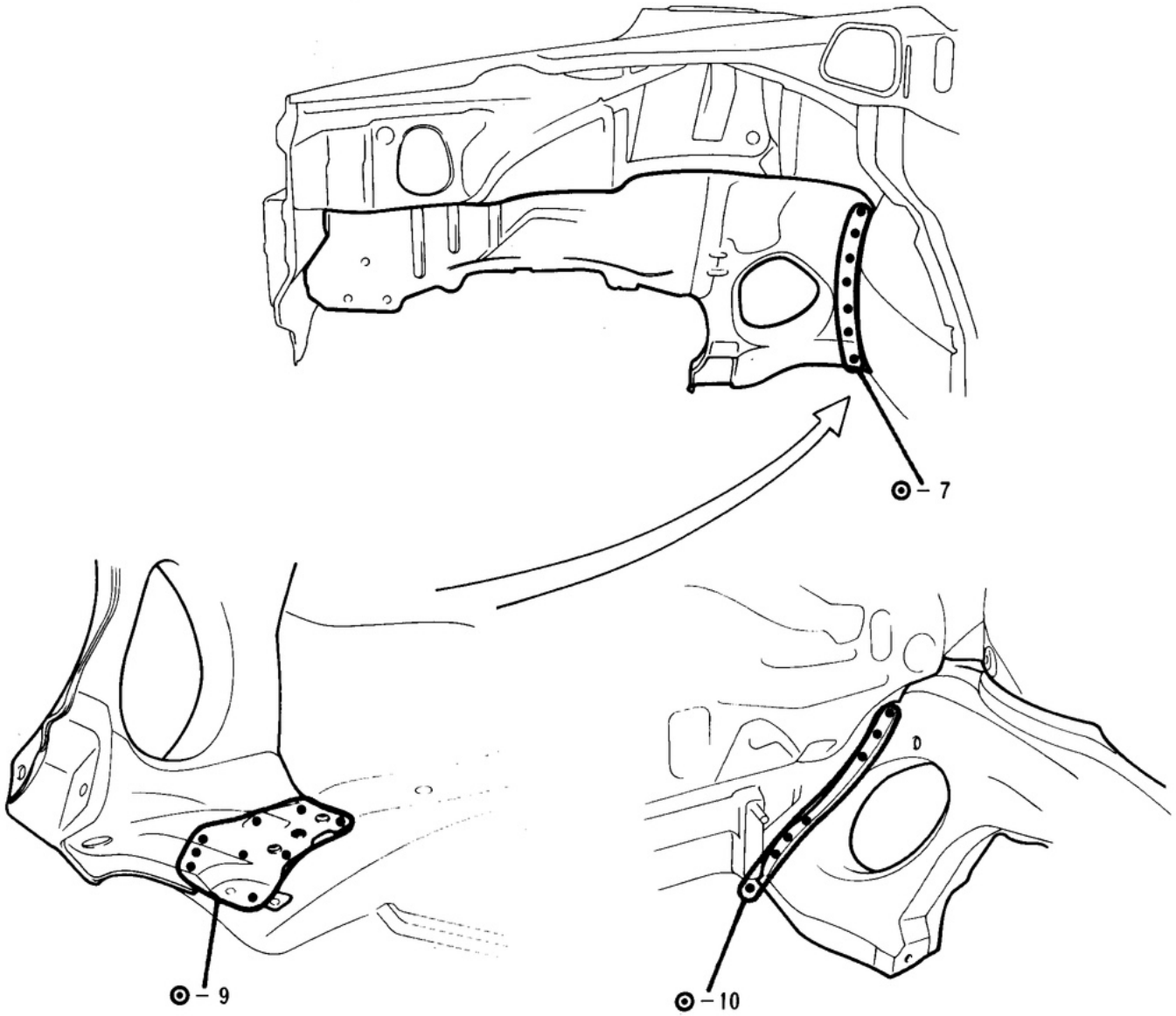
1. Cut the supply part shown above.

1500A, C FRONT SIDE MEMBER (ASSY)

Sedan, Liftback

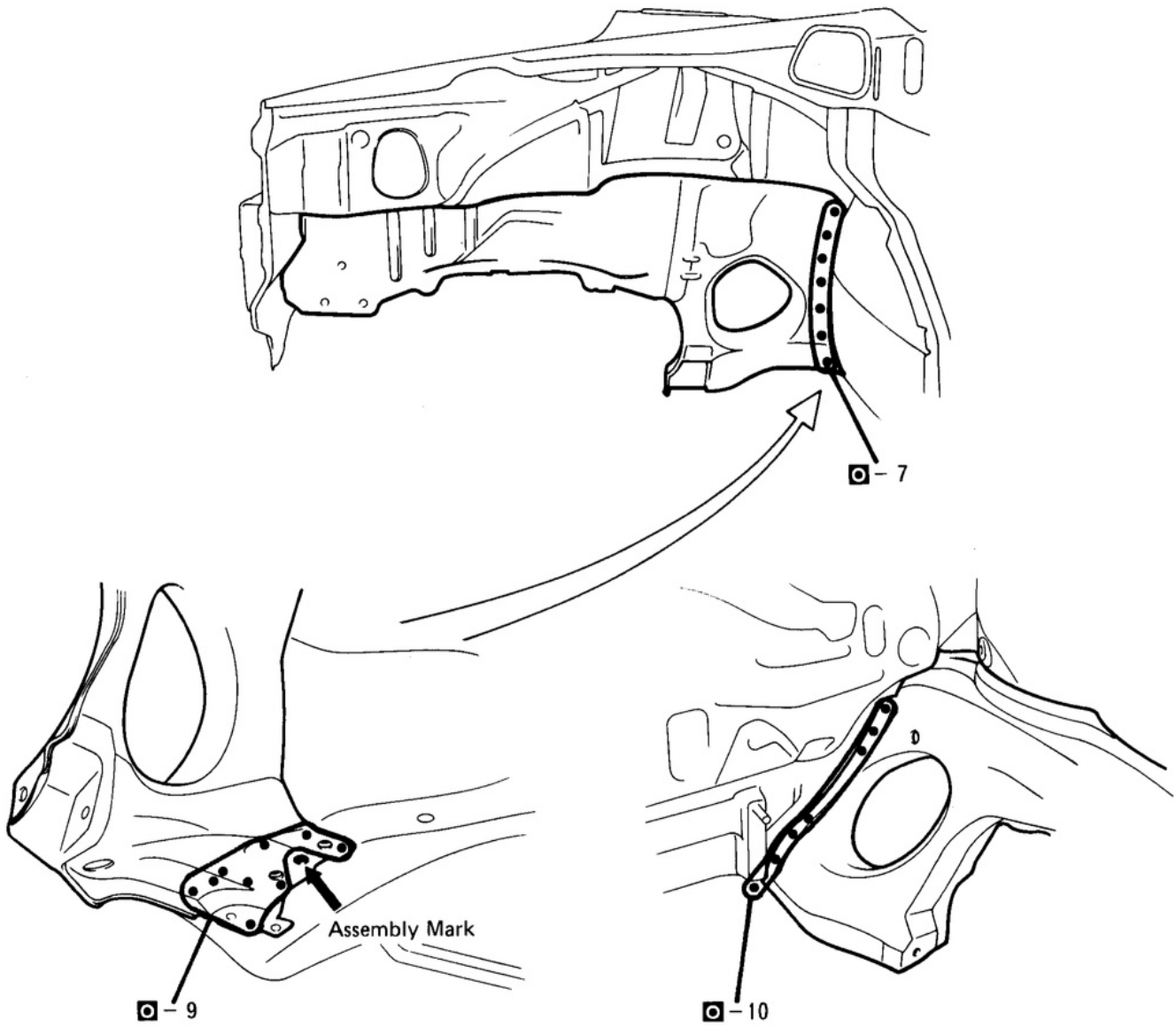


REMOVAL



1. Before removing the front side member, mark the position to assist in reinstallation.

INSTALLATION

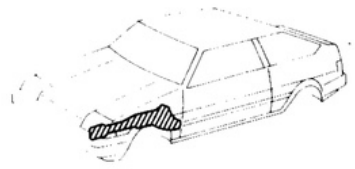


1. Use the standard assembly mark and scribing mark as a guide for temporary installation of the new parts.
2. Measure each part in accordance with the body dimension diagram.

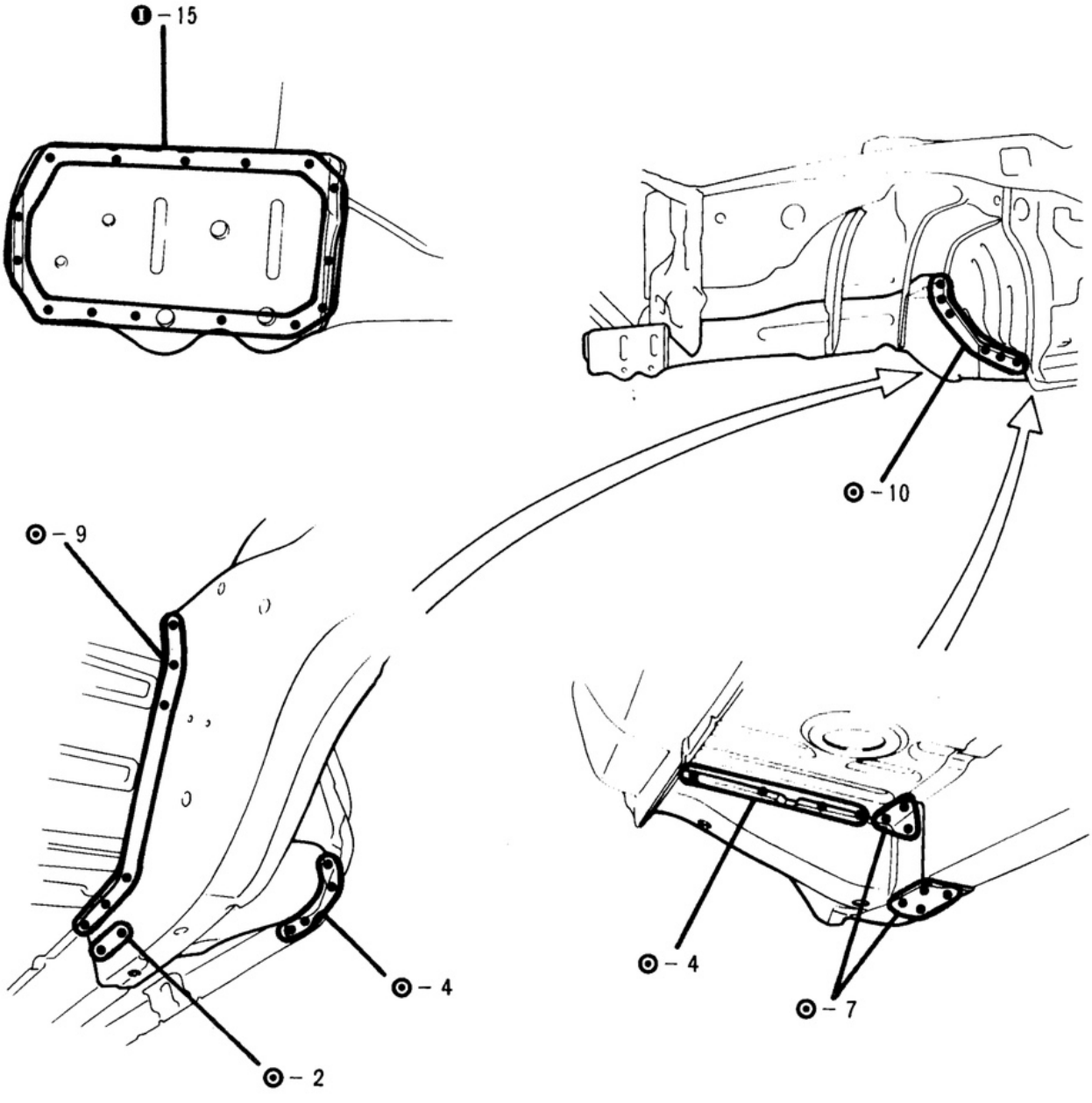
NOTE: Be sure each measurement is correct as these parts effect front wheel alignment.

1500B, D FRONT SIDE MEMBER (ASSY)

Coupe

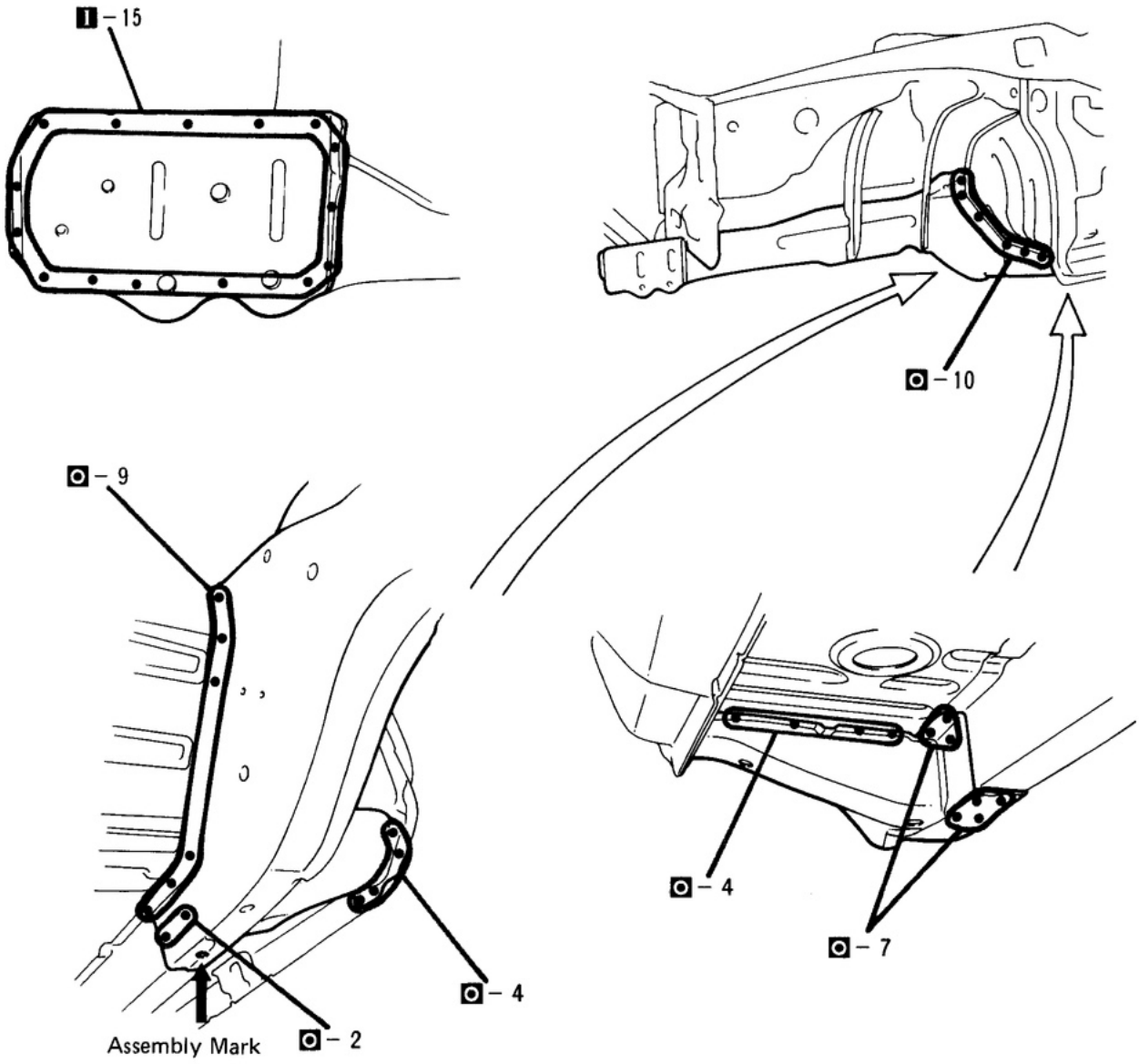


REMOVAL



1. Before removing the front side member, mark the position to assist in reinstallation.

INSTALLATION

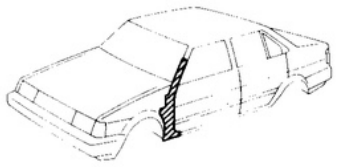


1. Use the standard assembly mark and scribing mark as a guide for temporary installation of the new parts.
2. Measure each part in accordance with the body dimension diagram.

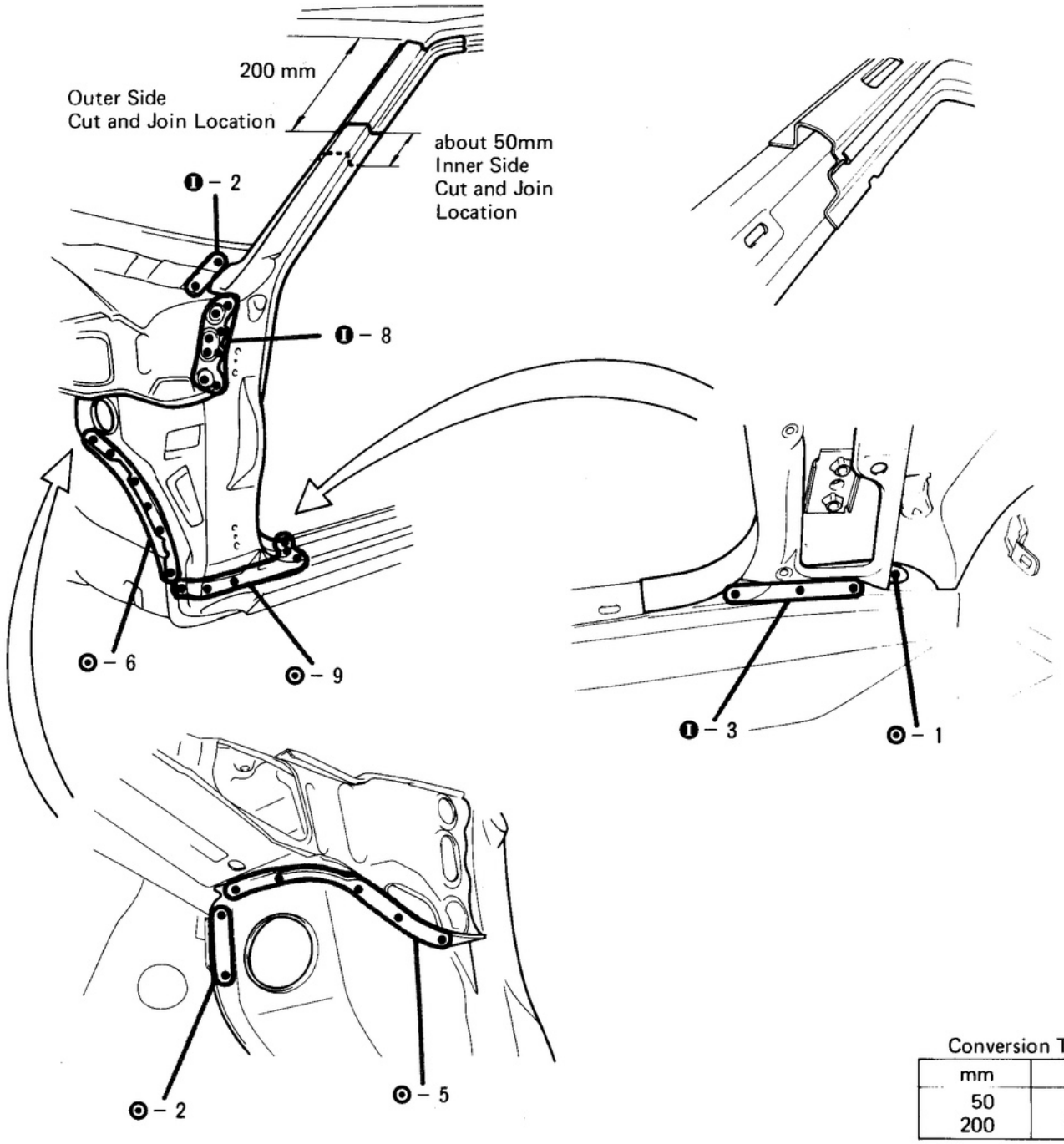
NOTE: Be sure each measurement is correct as these parts effect front wheel alignment.

2110A, C FRONT BODY PILLAR (CUT)

Sedan, Liftback



REMOVAL



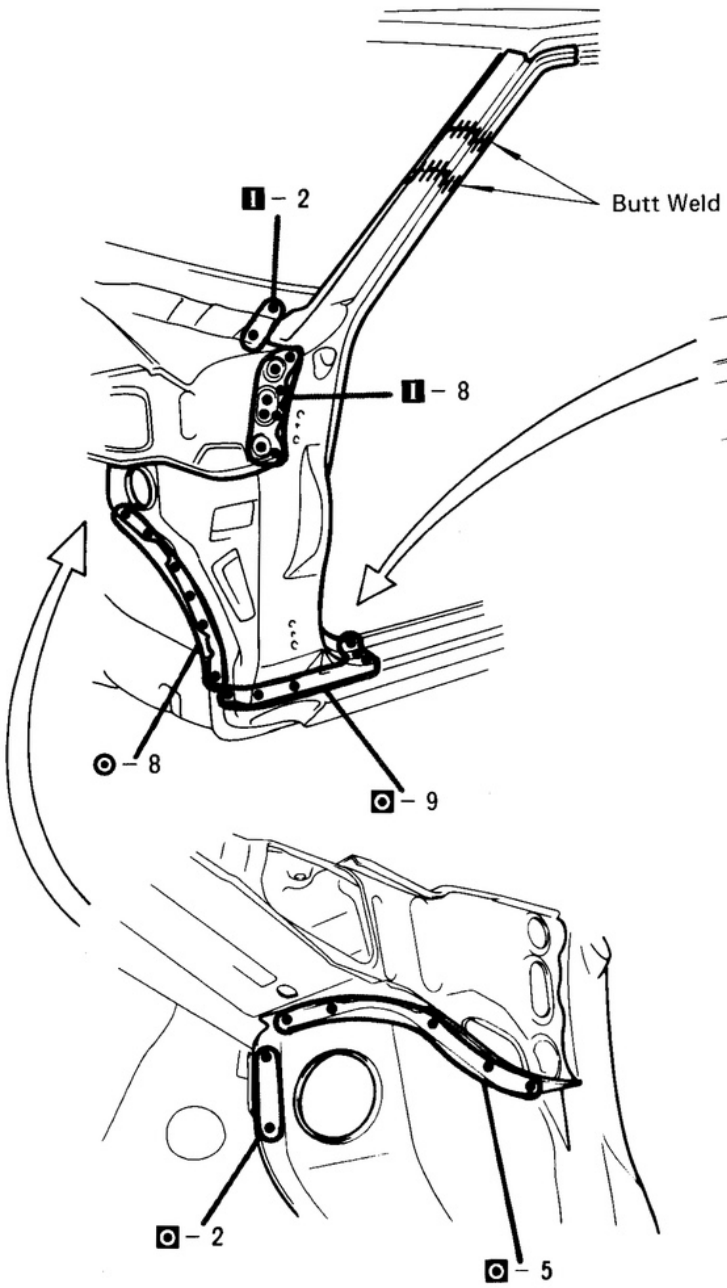
Conversion Table

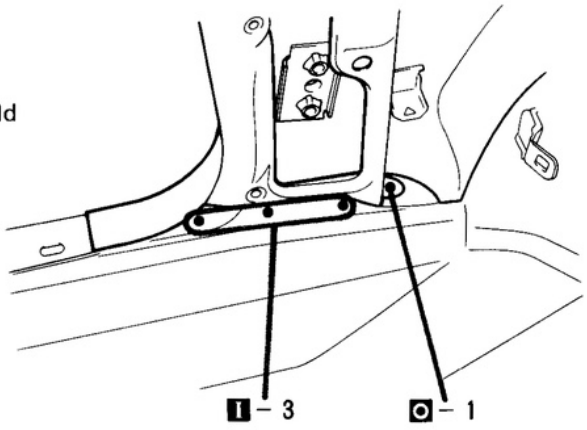
mm	in.
50	1.97
200	7.87

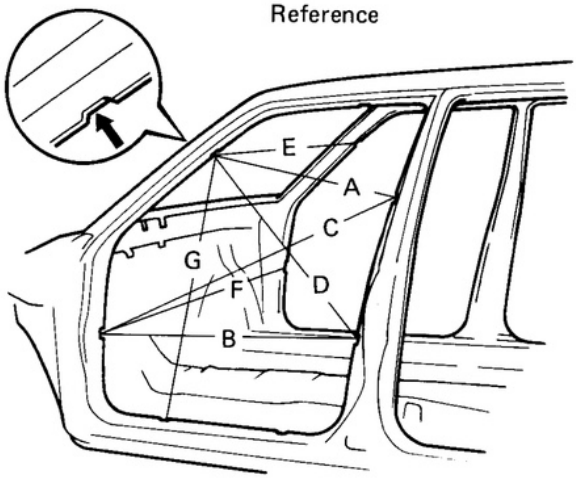
1. Cut and join the front body pillar as shown above.

NOTE: As shown above, cut and join the front body pillar outer and inner panels at a position shifted about 50 mm (1.97 in.).

INSTALLATION







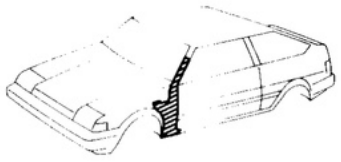
mm (in)

	Sedan		Liftback	
A	584	(22.99)	585	(23.03)
B	833	(32.80)	833	(32.80)
C	1,002	(39.45)	1,002	(39.45)
D	691	(27.20)	677	(26.65)
E	1,200	(47.24)	1,221	(48.07)
F	1,355	(53.35)	1,355	(53.35)
G	825	(32.48)	800	(31.50)

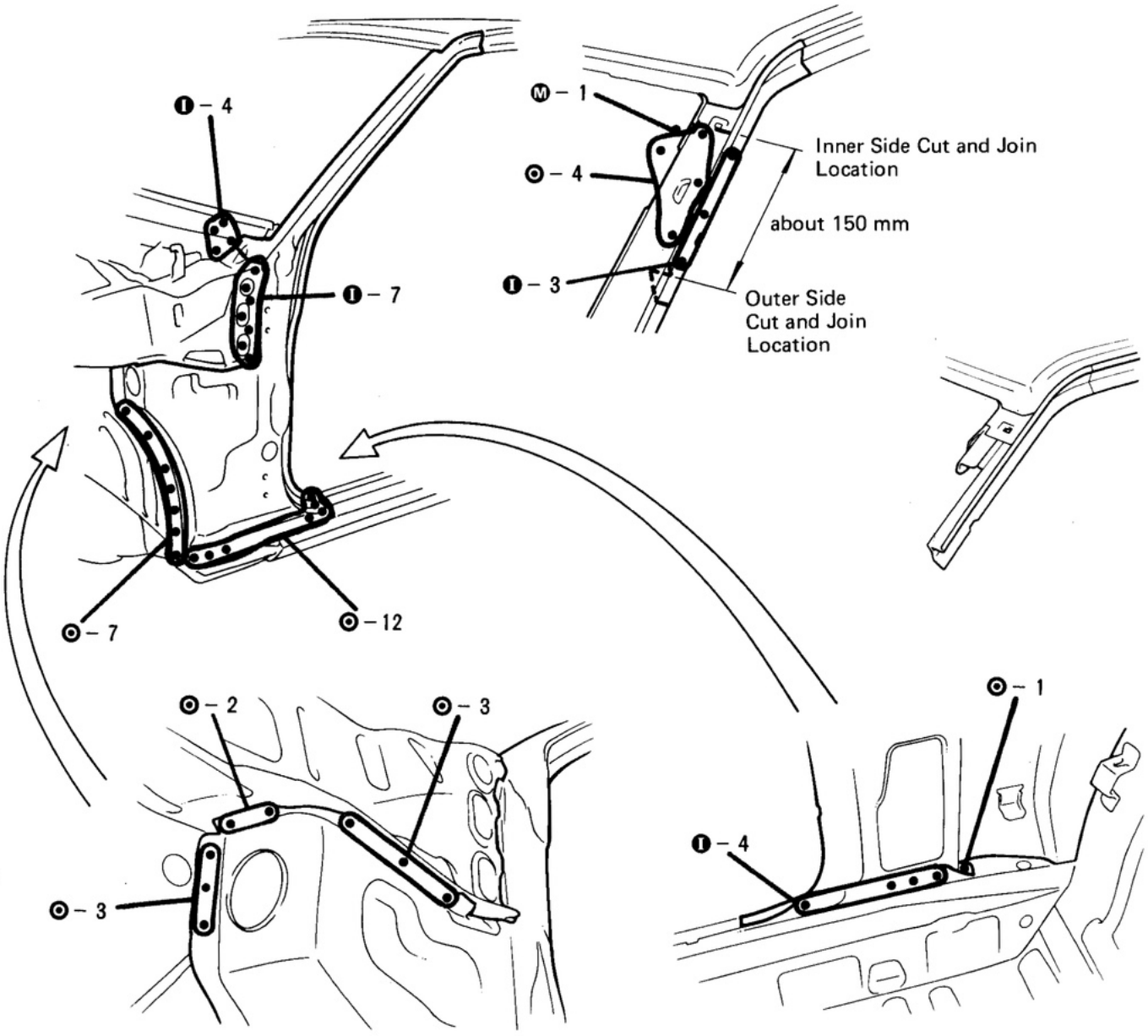
1. Temporarily intall the new part, and then temporarily install the front windshield, door fender and hood, and check the fit.

2110B, D FRONT BODY PILLAR (CUT)

Coupe



REMOVAL

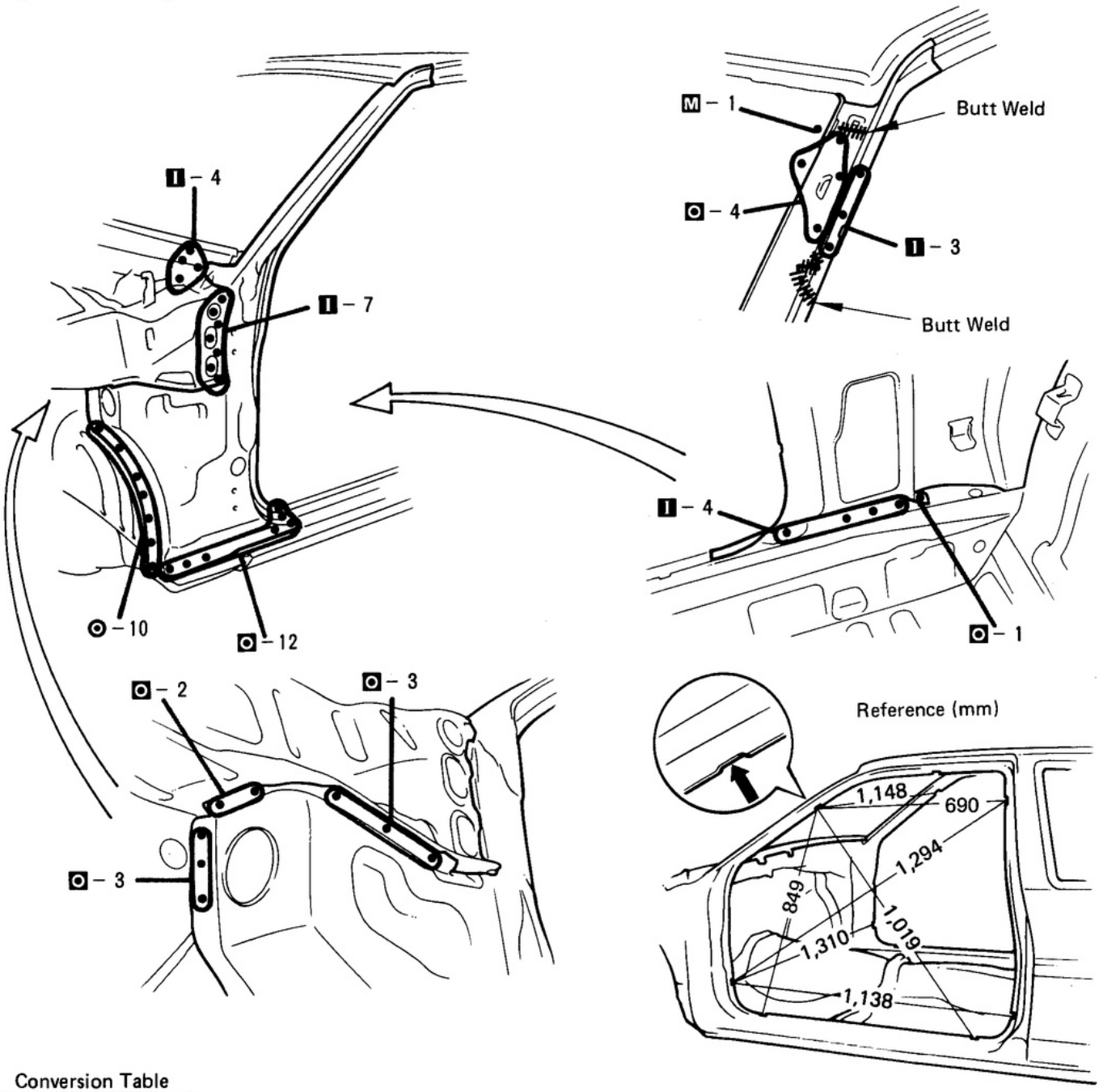


Conversion Table

mm	in.
150	5.91

1. Cut and join the front body pillar as shown above.

INSTALLATION



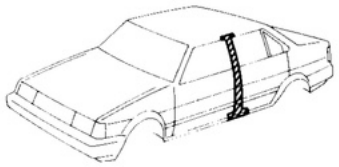
Conversion Table

mm	in.
690	27.17
849	33.43
1,019	40.12
1,138	44.80
1,148	45.20
1,294	50.94
1,310	51.57

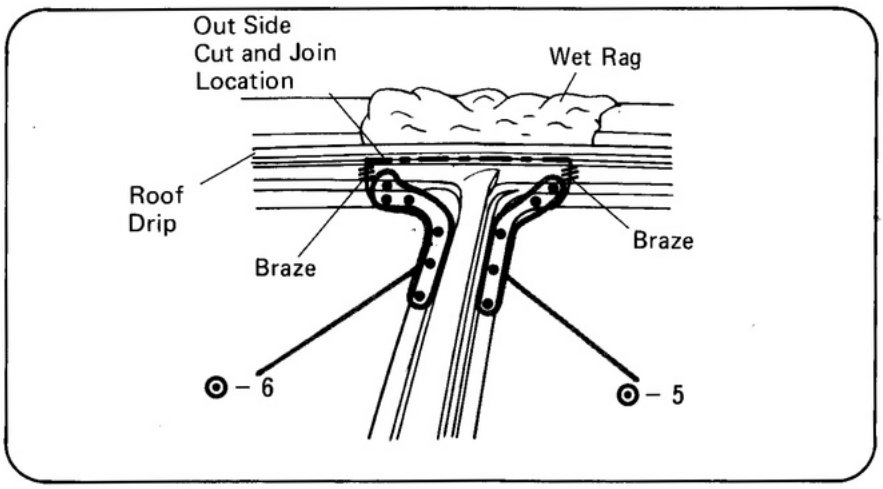
1. Temporarily install the new part, and then temporarily install the front windshield, door fender and hood, and check the fit.

2210A, C CENTER BODY PILLAR (CUT)

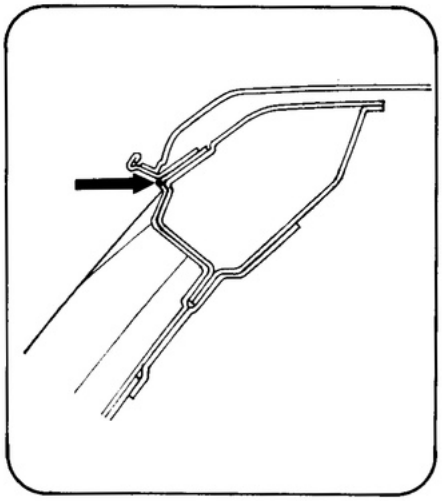
Sedan, Liftback

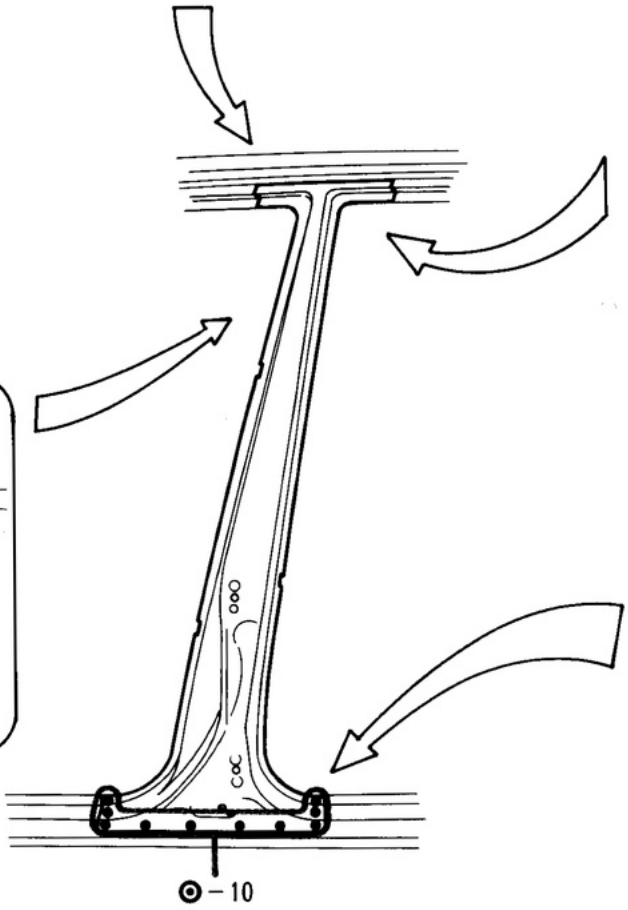


REMOVAL

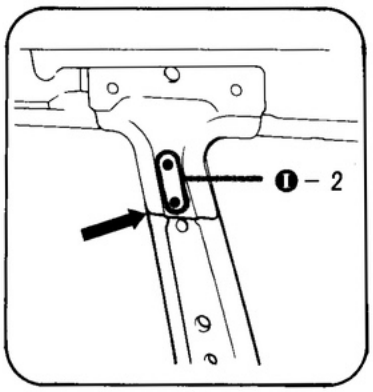


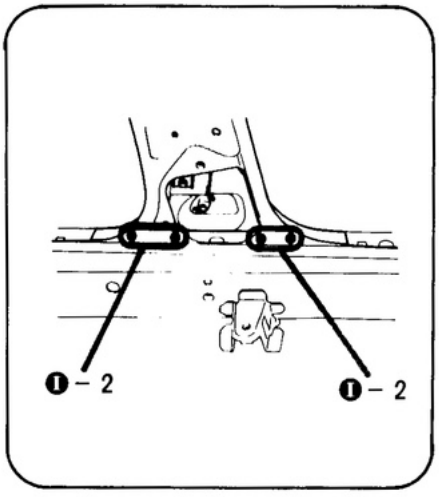
Cutting Location





Inner side
Replacement
Location





1. Cut and join the outer side at the location shown above.

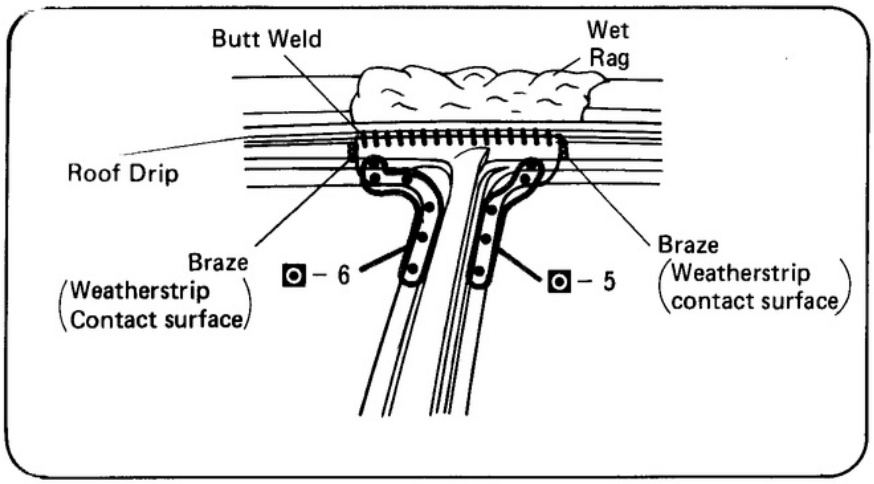
NOTE: Be careful not to damage the roof side outer rail when cutting the center pillar with an air powered grinder or such.

2. Replacement of the inner side is at the spot weld location.

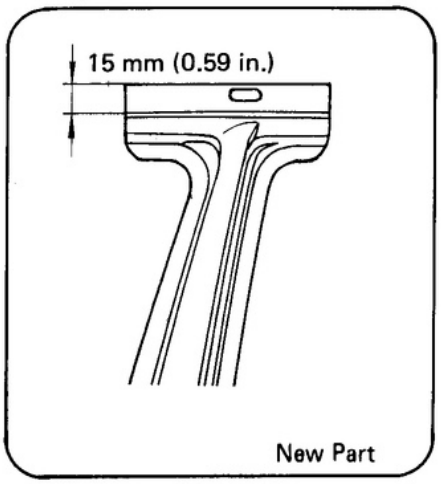
3. Heat the brazed area of the roof side outer rail and scrape it with a wire brush.

NOTE: Use wet a rag to protect the roof panel paint from damage.

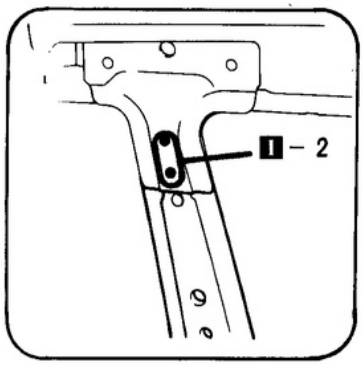
INSTALLATION

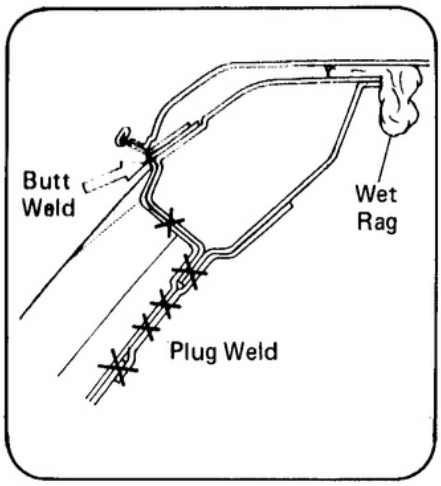


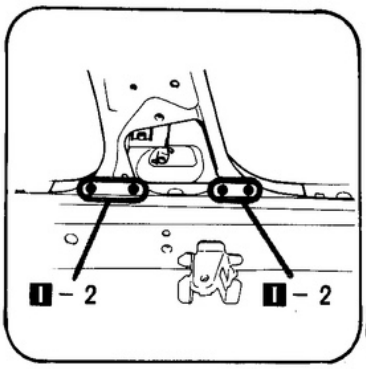
Cutting Location

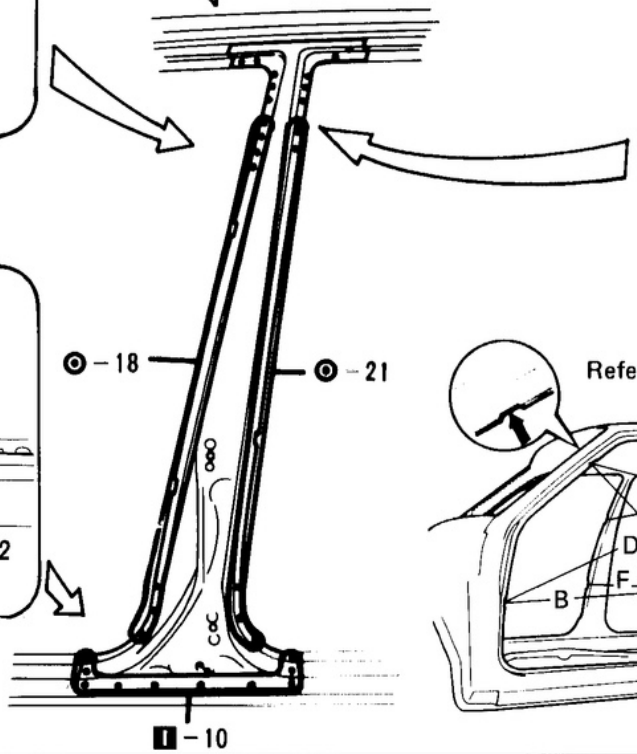


CAUTION: Avoid sparks in interior.









(mm)

	4-door	5-door
A	584	585
B	833	833
C	691	677
D	1,002	1,002
E	1,296	1,296
F	1,355	1,355

1. Cut the new part as shown above.

NOTE: When cutting, leave a little overlap and sand off the extra portion to match it with the shape of the cut and join line.

2. Plug weld (2 points) the outer and inner sides before temporarily installing the new part.
3. Temporarily install the new parts and check the fit of the front and rear doors.
4. Butt weld the cut and joint location with a MIG welder, and smoothen out with a sander.

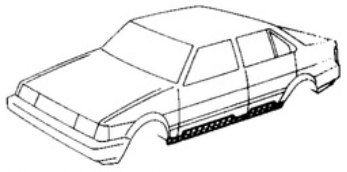
NOTE: Use wet rags to protect the roof panel paint from damage.

5. Braze the roof side outer rail and center pillar connection.

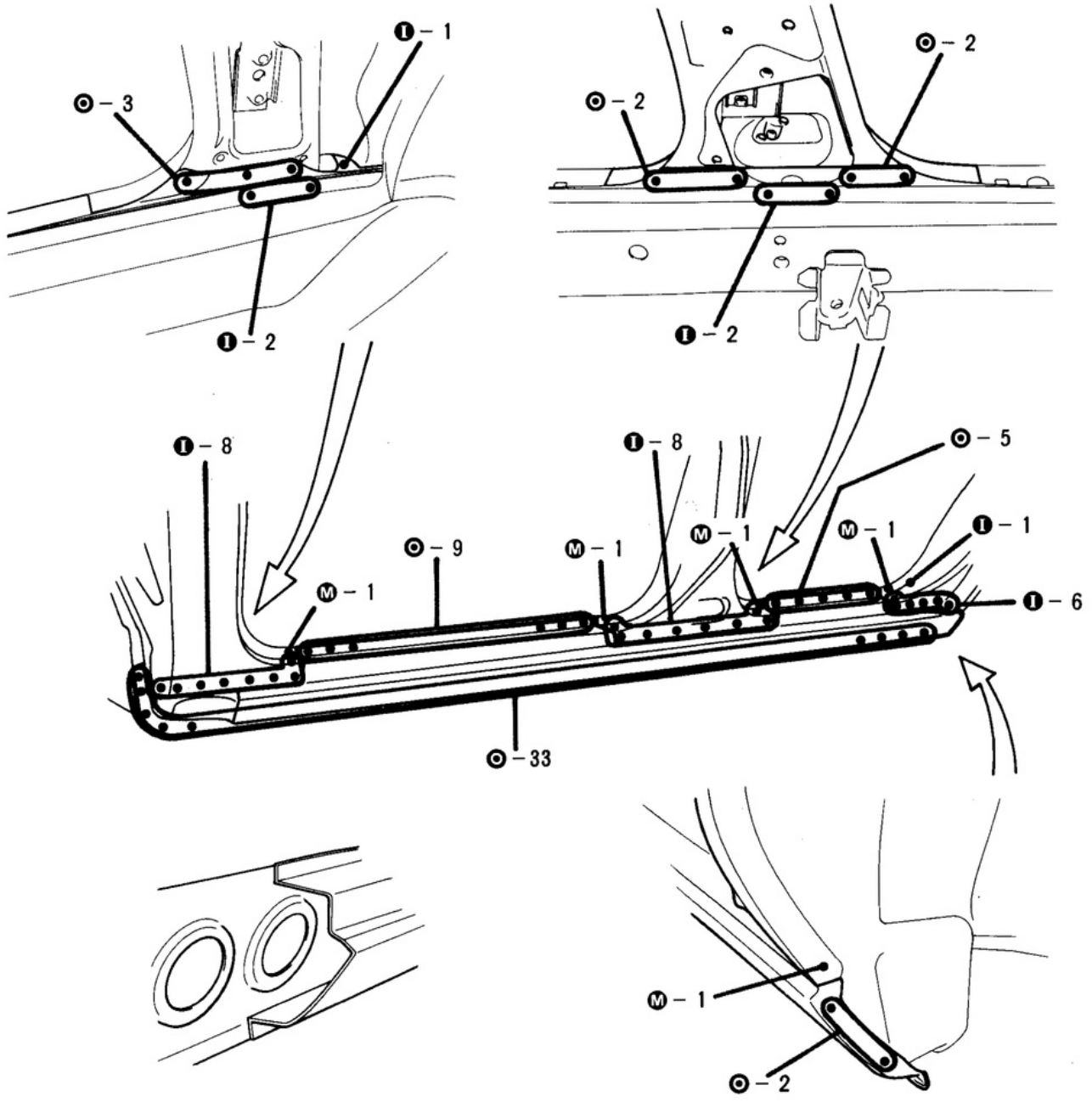
NOTE: Smoothen out the surface. Rain leakage will occur if the weatherstrip contact is defective.

2300A,C OUTER ROCKER PANEL (ASSY)

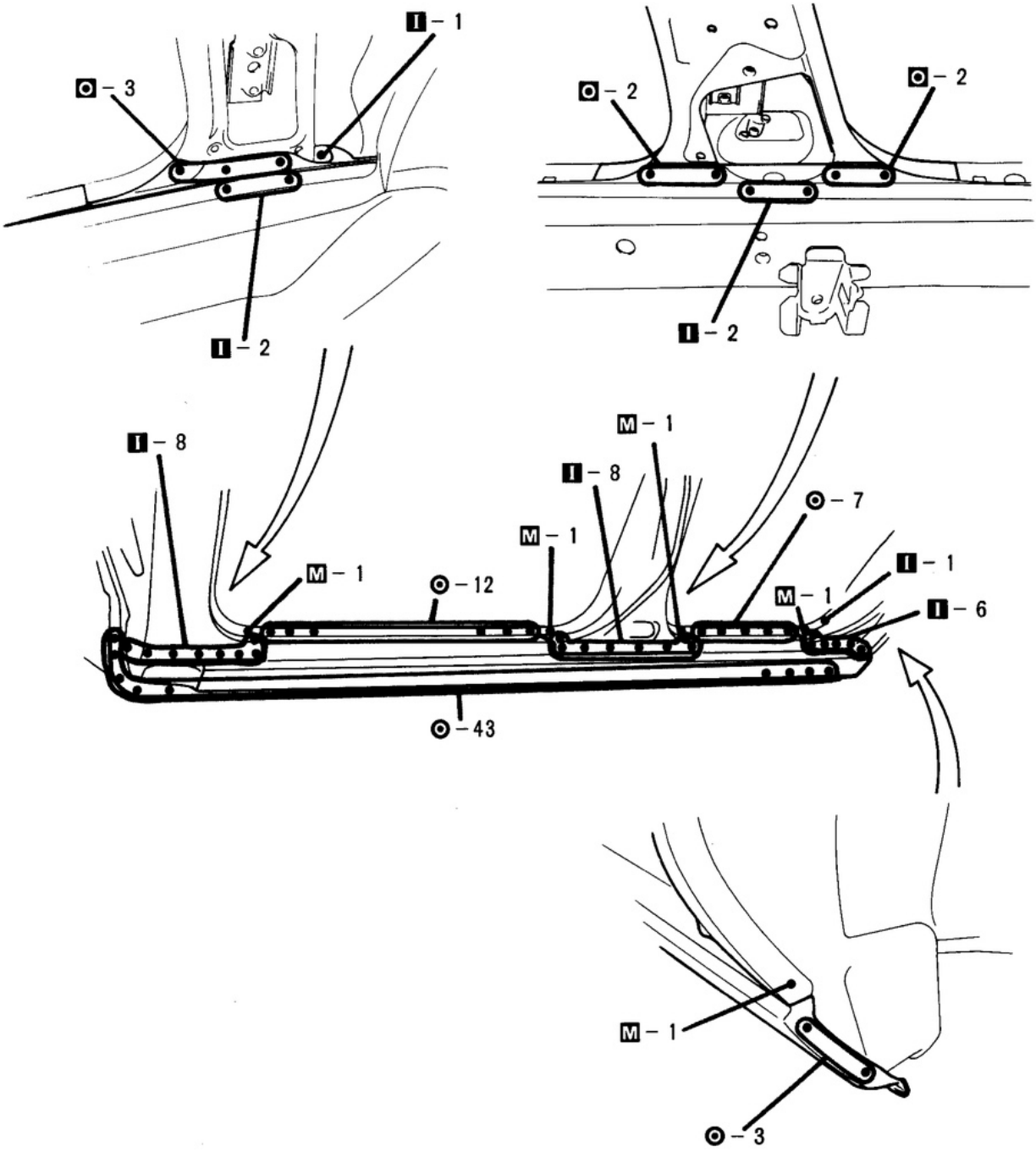
Sedan, Liftback



REMOVAL



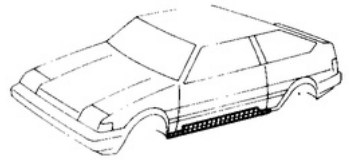
INSTALLATION



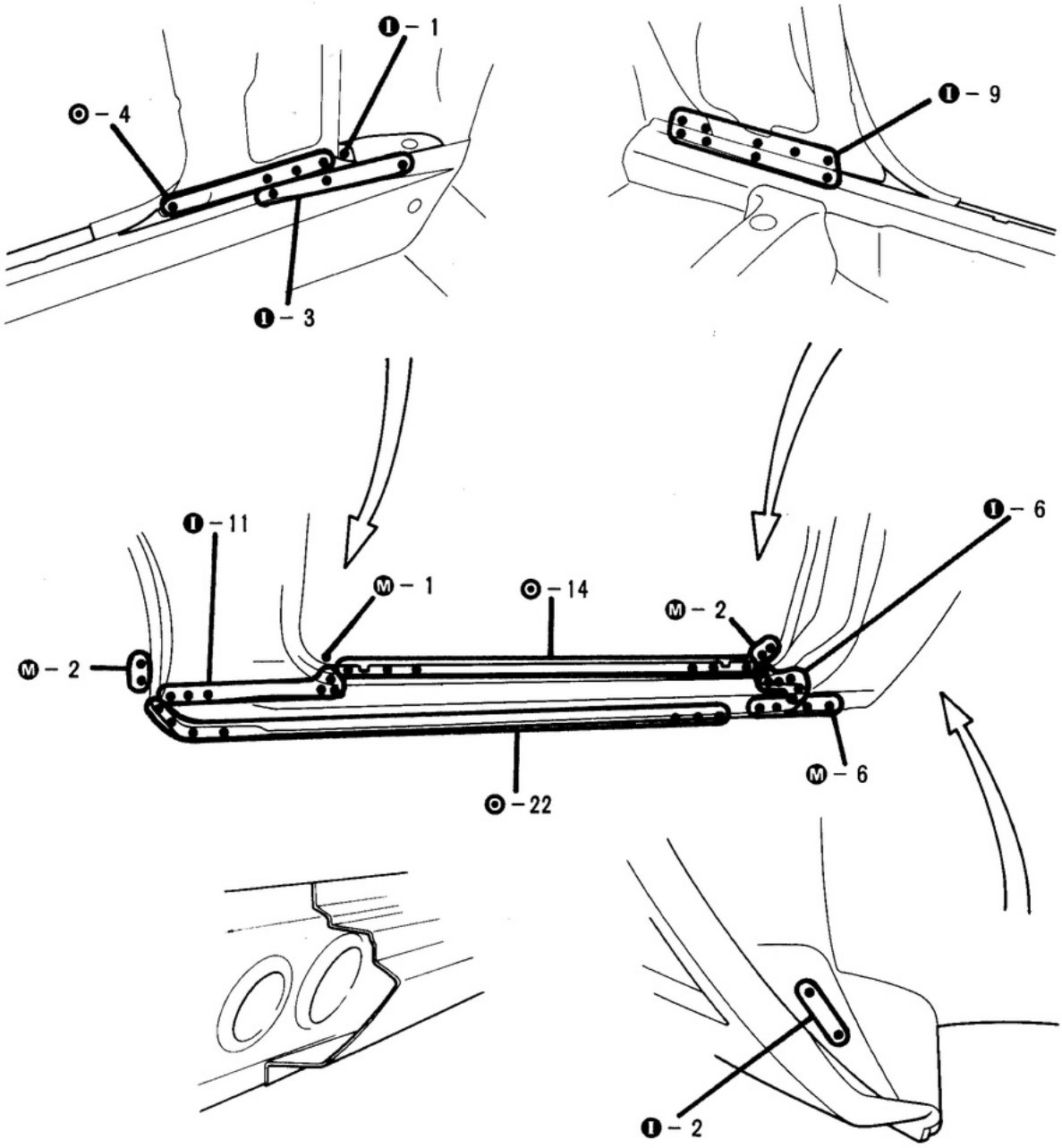
1. Temporarily install the new part with the basic assembly mark.
2. Temporarily install the front door, rear door and front fender, and check the fit.

2300B, D OUTER ROCKER PANEL (ASSY)

Coupe

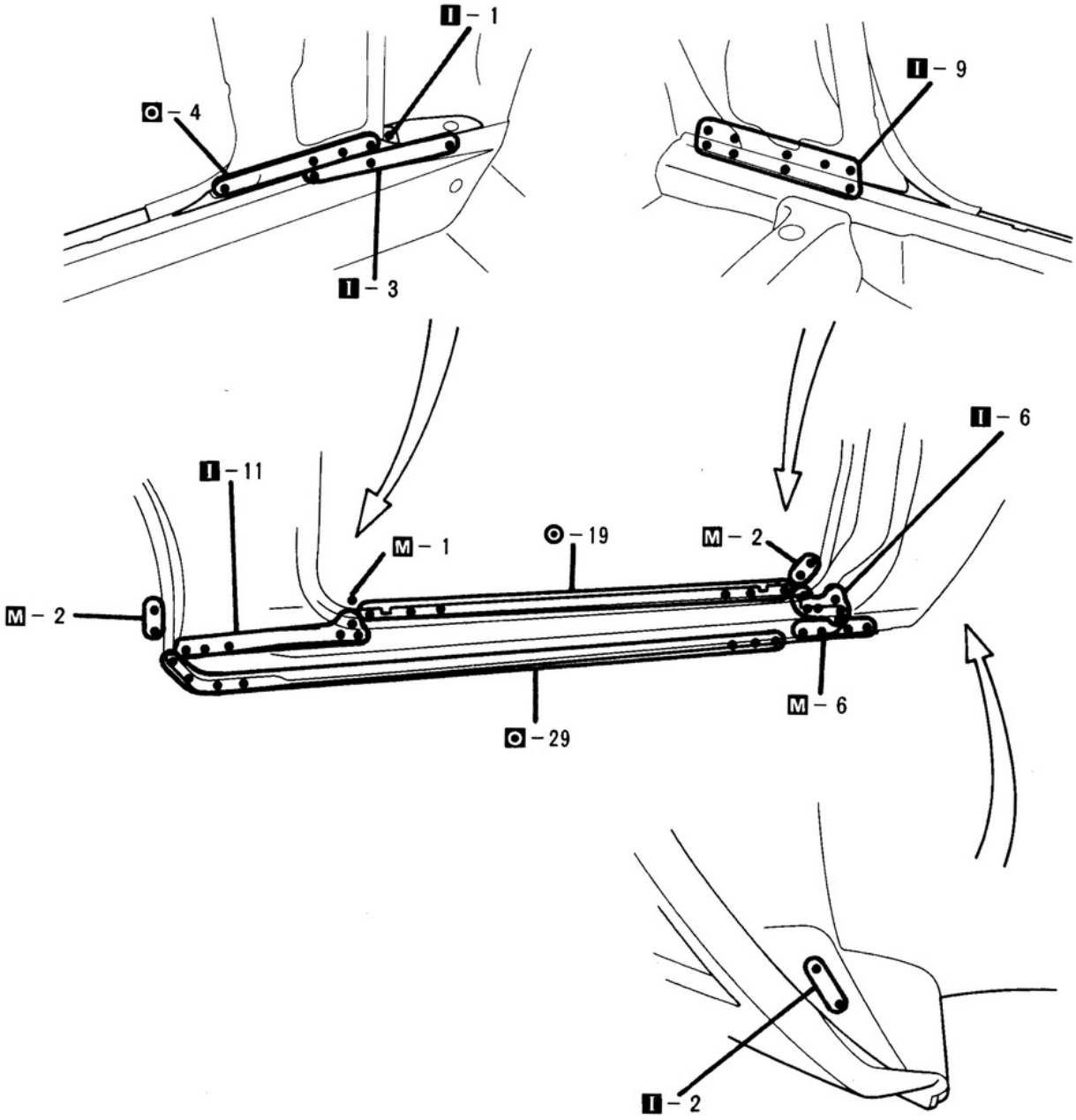


REMOVAL



1. Separation of the welding points is done by removing the outer rocker panel and reinforcement together.

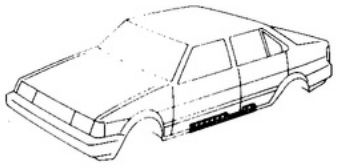
INSTALLATION



1. Temporarily install the new part with the basic assembly mark.
2. Temporarily install the front door, rear door and front fender, and check the fit.

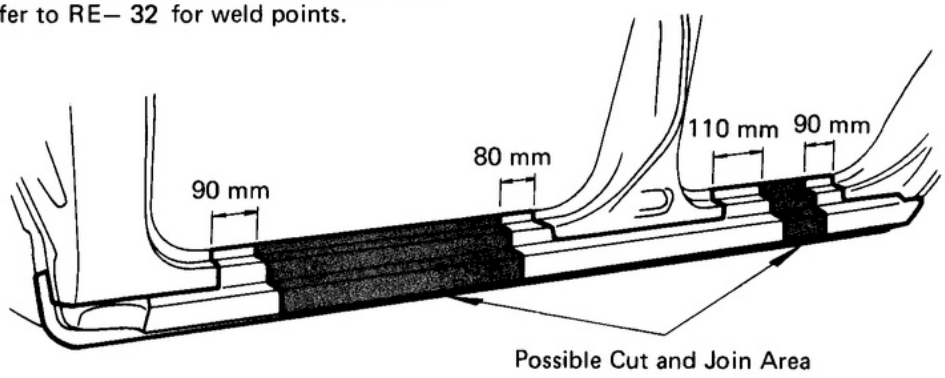
2310A, C OUTER ROCKER PANEL (CUT)

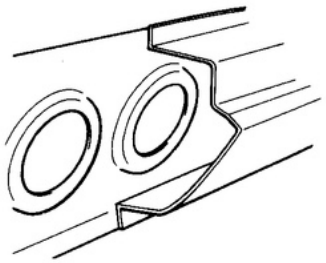
Sedan, Liftback



REMOVAL

* This section is a cut and join location only.
Refer to RE– 32 for weld points.





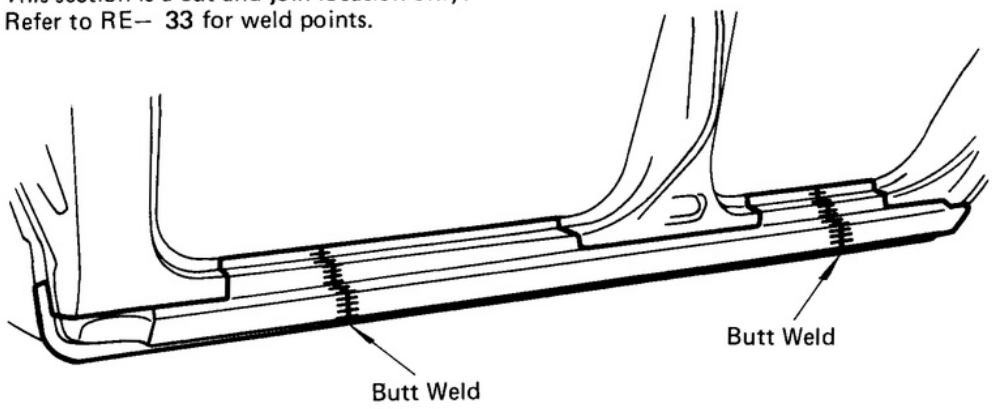
Conversion Table

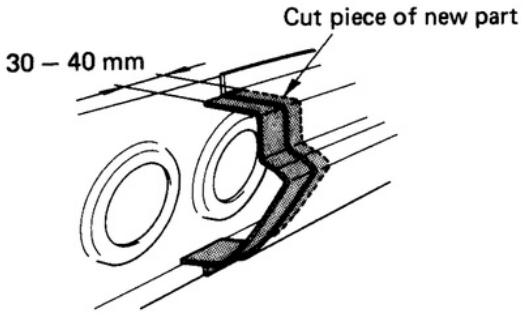
mm	in.
80	3.15
90	3.54
110	4.33

1. Cut and join the outer panel at either or both areas shown above.

INSTALLATION

* This section is a cut and join location only.
Refer to RE-- 33 for weld points.





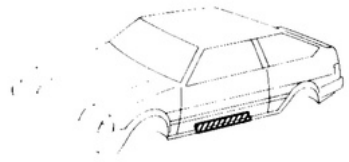
Conversion Table

mm	in.
30	1.18
40	1.57

1. Temporarily install the new part with the basic assembly mark.
2. Temporarily install the front door, rear door and front fender, and check the fit.

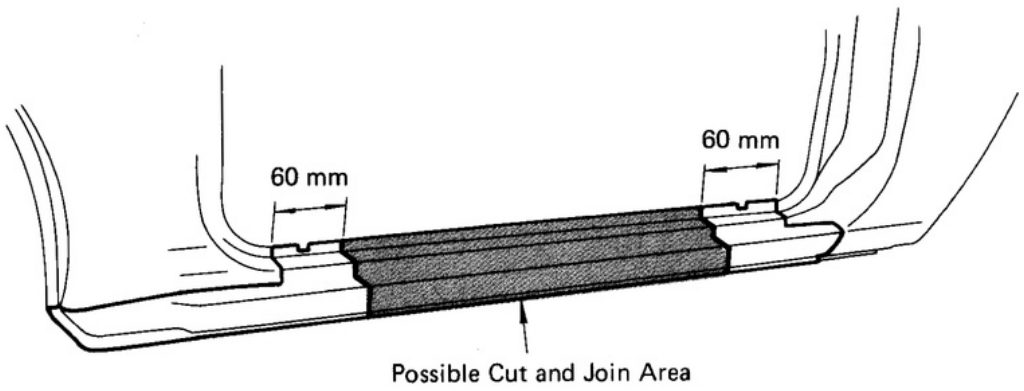
2310B, D OUTER ROCKER PANEL (CUT)

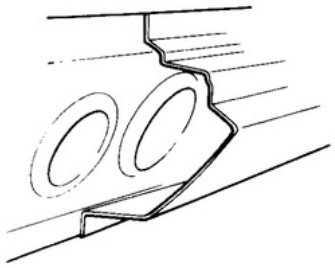
Coupe



REMOVAL

* This section is a cut and join location only.
Refer to RE–34 for weld points.





Conversion Table

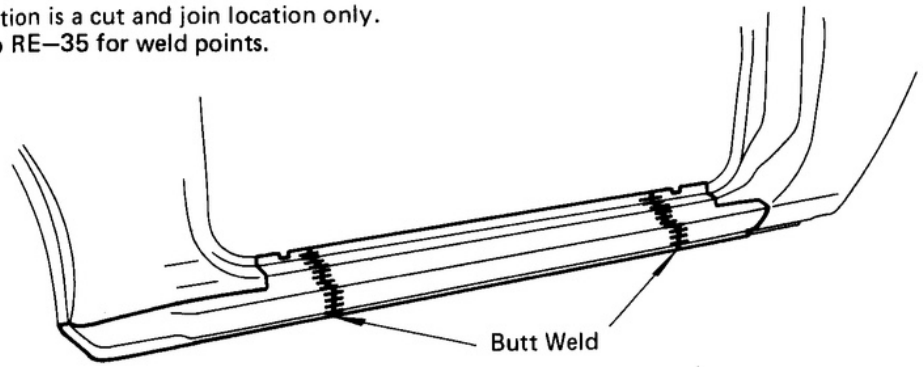
mm	in.
60	2.36

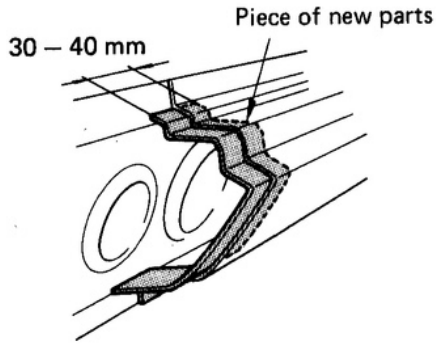
1. Cut and join the outer panel only at the areas shown above.

NOTE: When replacing the reinforcement, slightly shift the cut and join position of the outer panel.

INSTALLATION

* This section is a cut and join location only.
Refer to RE–35 for weld points.





Conversion Table

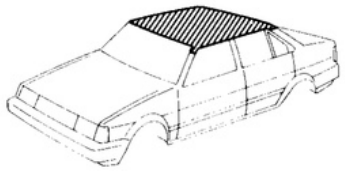
mm	in.
30	1.18
40	1.57

1. Temporarily install the new part with the basic assembly mark.
2. Temporarily install the door, and check the fit.

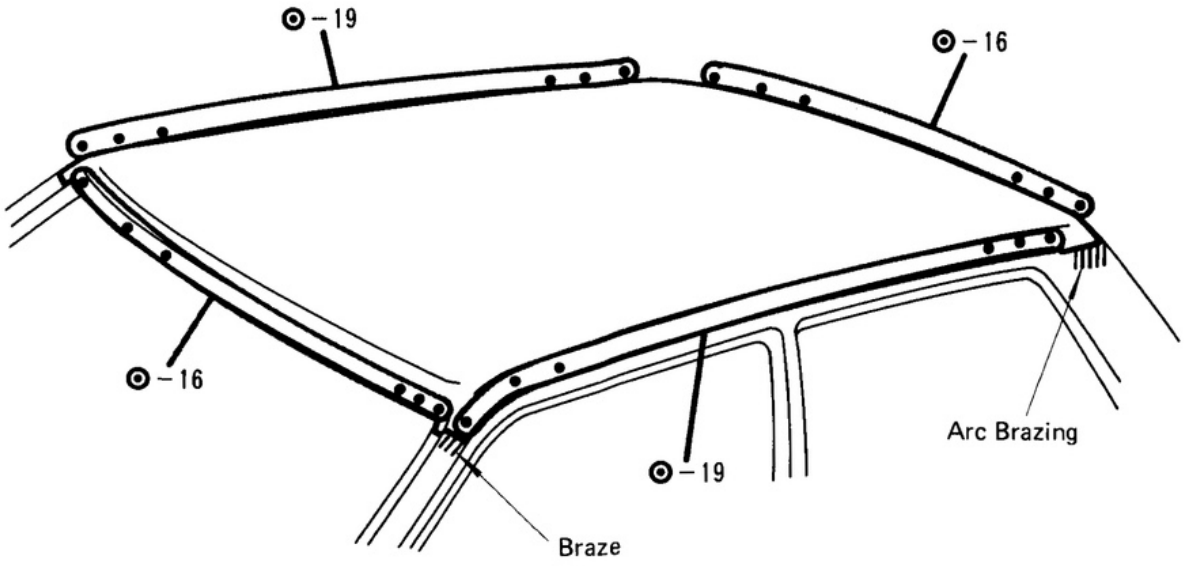
Reference: When replacing the reinforcement, first weld the reinforcement to the body side.

2400A ROOF PANEL (ASSY)

Sedan



REMOVAL



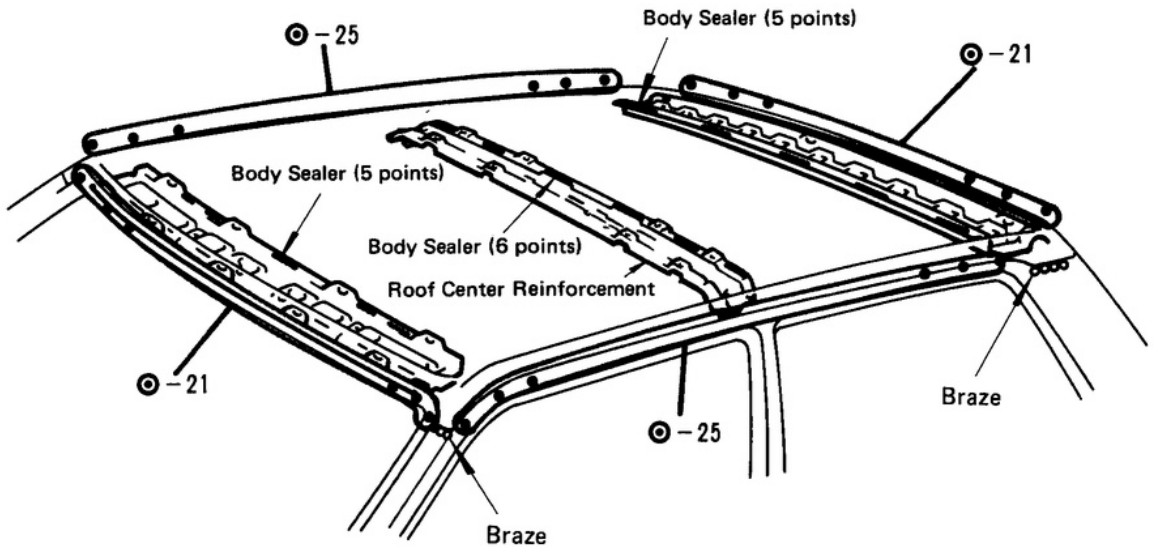
1. Heat the brazed area of the front body pillar and scrape it with a wire brush.

NOTE: Be careful not to overheat.

2. Using a rotary cutter, cut off the roof panel tip at the quarter panel arc brazing connection.

NOTE: Adjust the blade cutting depth of the rotary cutter.

INSTALLATION



1. Before temporarily installing the new part, apply body sealer to the windshield heater panel and back window opening frame.

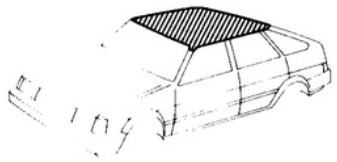
NOTE: Apply just enough sealer for the new part to make contact.

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

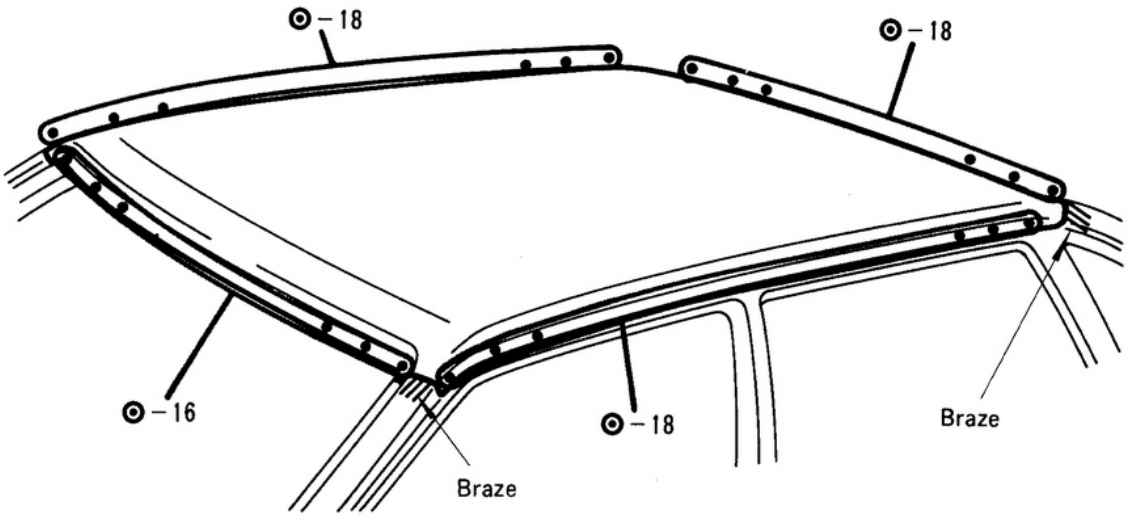
NOTE: Distortion occurs easily so protect the brazing circumference with a wet rag.

2400C ROOF PANEL (ASSY)

Liftback



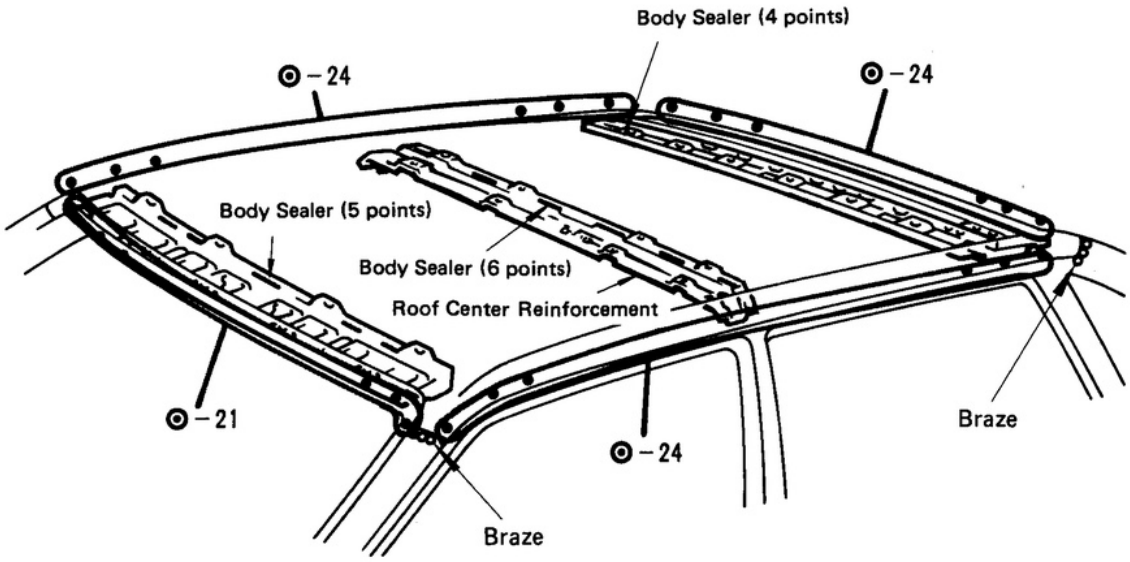
REMOVAL



1. Heat the brazed area of the front body pillar and quarter panel and scrape it with a wire brush.

NOTE: Be careful not to overheat.

INSTALLATION



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

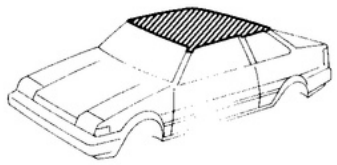
NOTE: Apply just enough sealer for the new part to make contact.

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

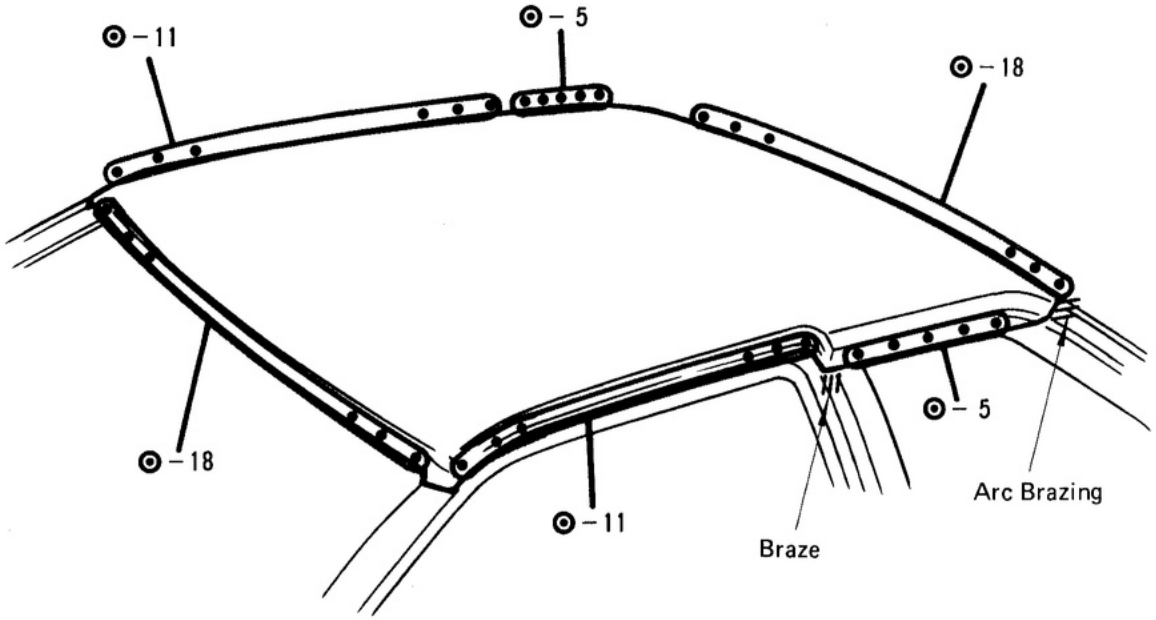
NOTE: Distortion occurs easily so protect the brazing circumference with a wet rag.

2400D ROOF PANEL (ASSY)

2-Door Coupe



REMOVAL



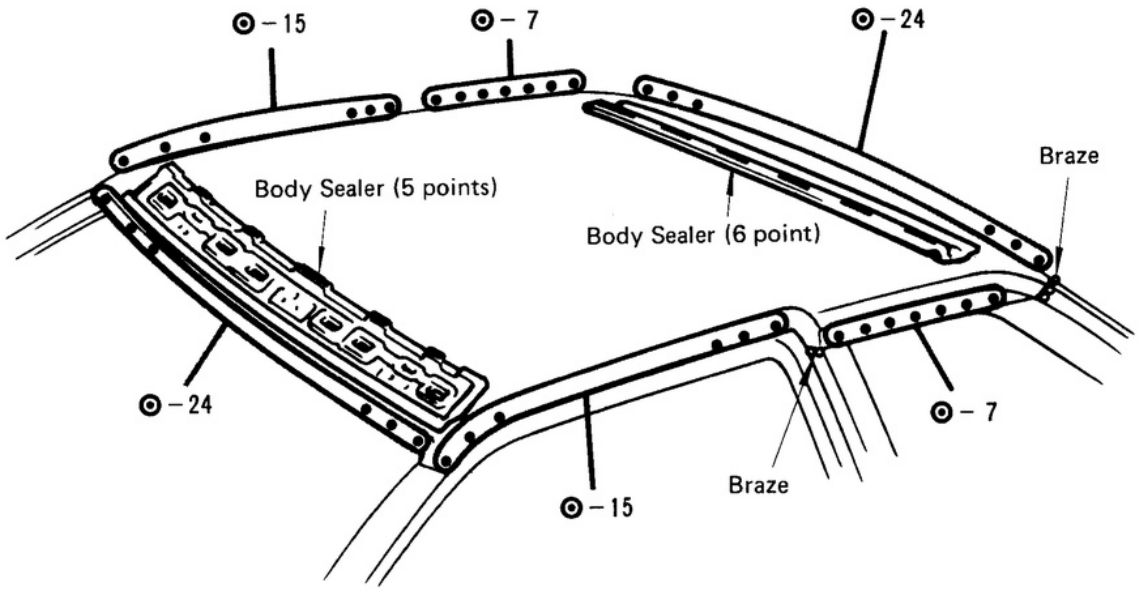
1. Heat the brazed area of the quarter panel and scrape it with a wire brush.

NOTE: Be careful not to overheat.

2. Cut off the roof panel tip at the quarter panel arc brazing connection with a rotary cutter.

NOTE: If using rotary cutters, adjust the blade cutting depth.

INSTALLATION



1. Before temporarily installing the new part, apply body sealer to the windshield header panel and back window opening frame.

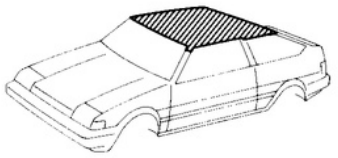
NOTE: Apply just enough sealer for the new part to make contact.

2. Braze the quarter panel connection.

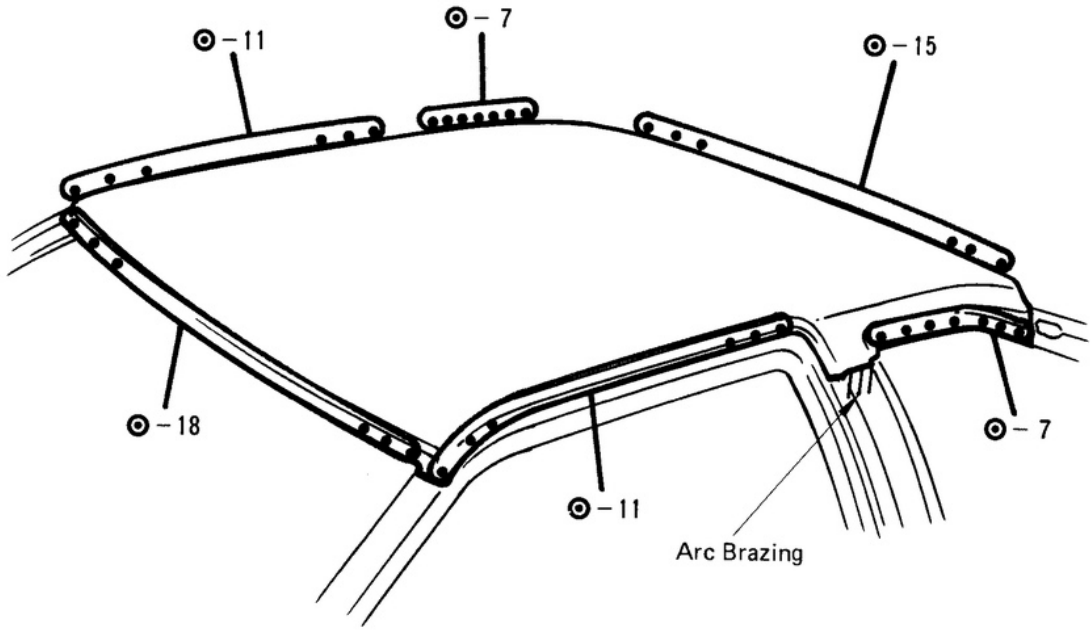
NOTE: Distortion occurs easily so protect the brazing circumference with a wet rag.

2400B ROOF PANEL (ASSY)

3-Door Coupe



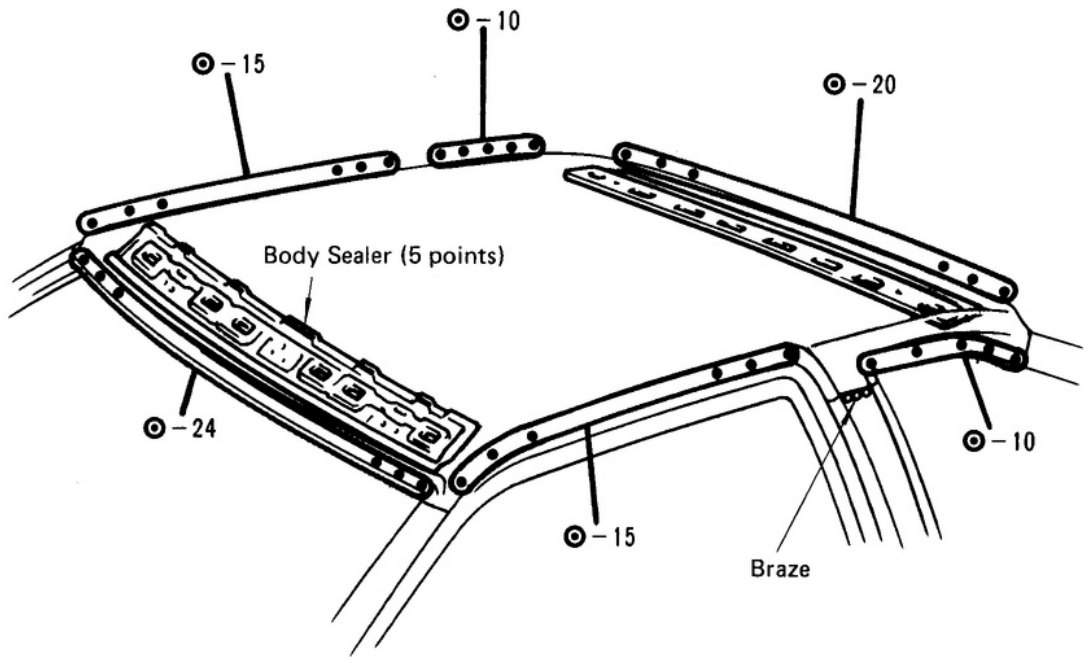
REMOVAL



1. Using a rotary cutter, cut off the roof panel tip at the quarter panel arc brazing connection.

NOTE: Adjust the blade cutting depth of the rotary cutter.

INSTALLATION



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

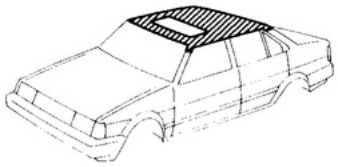
NOTE: Apply just enough sealer for the new part to make contact.

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

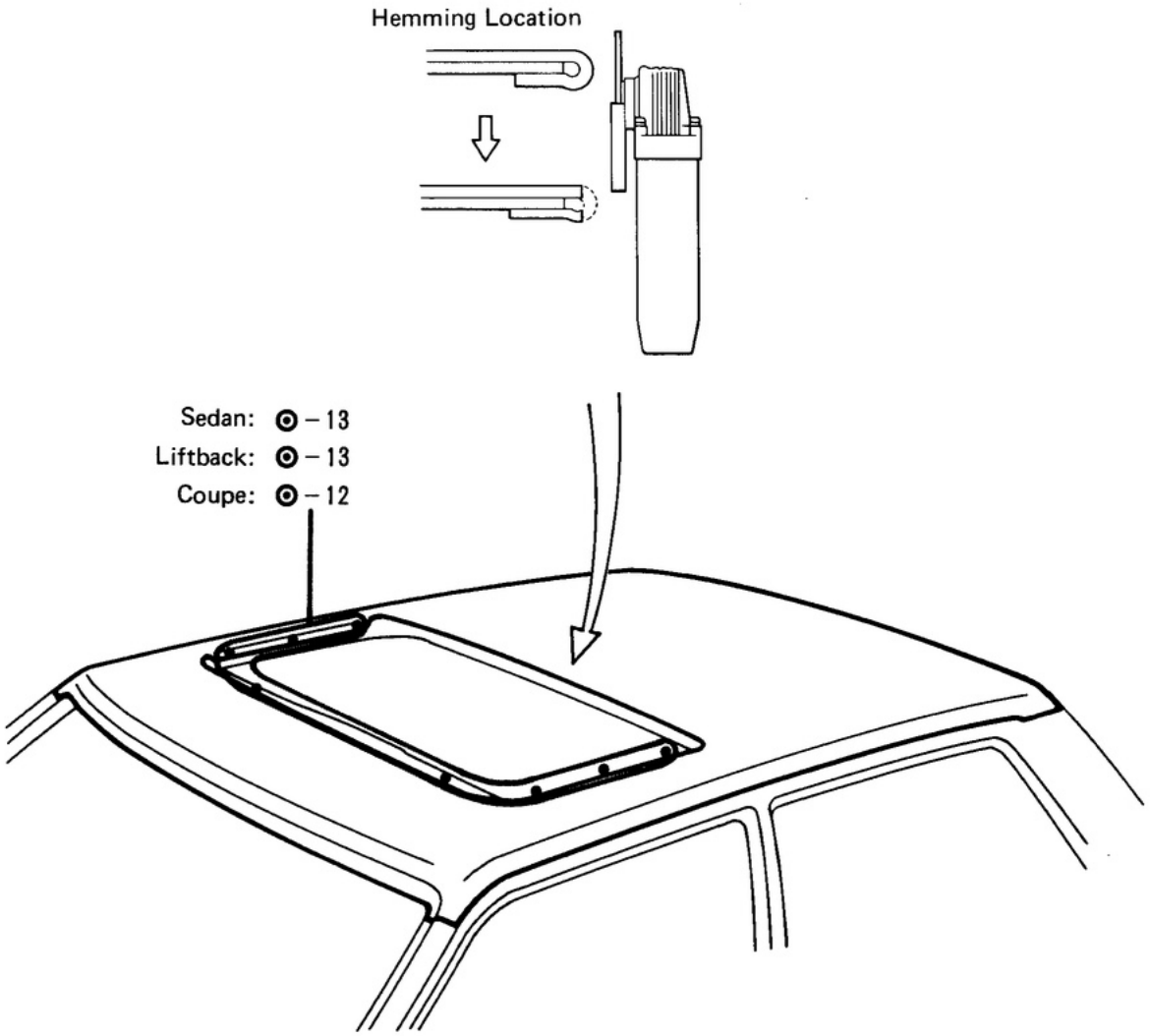
NOTE: Distortion occurs easily so protect the brazing circumference with a wet rag.

2401 ROOF PANEL W/SUN ROOF (ASSY)

All models

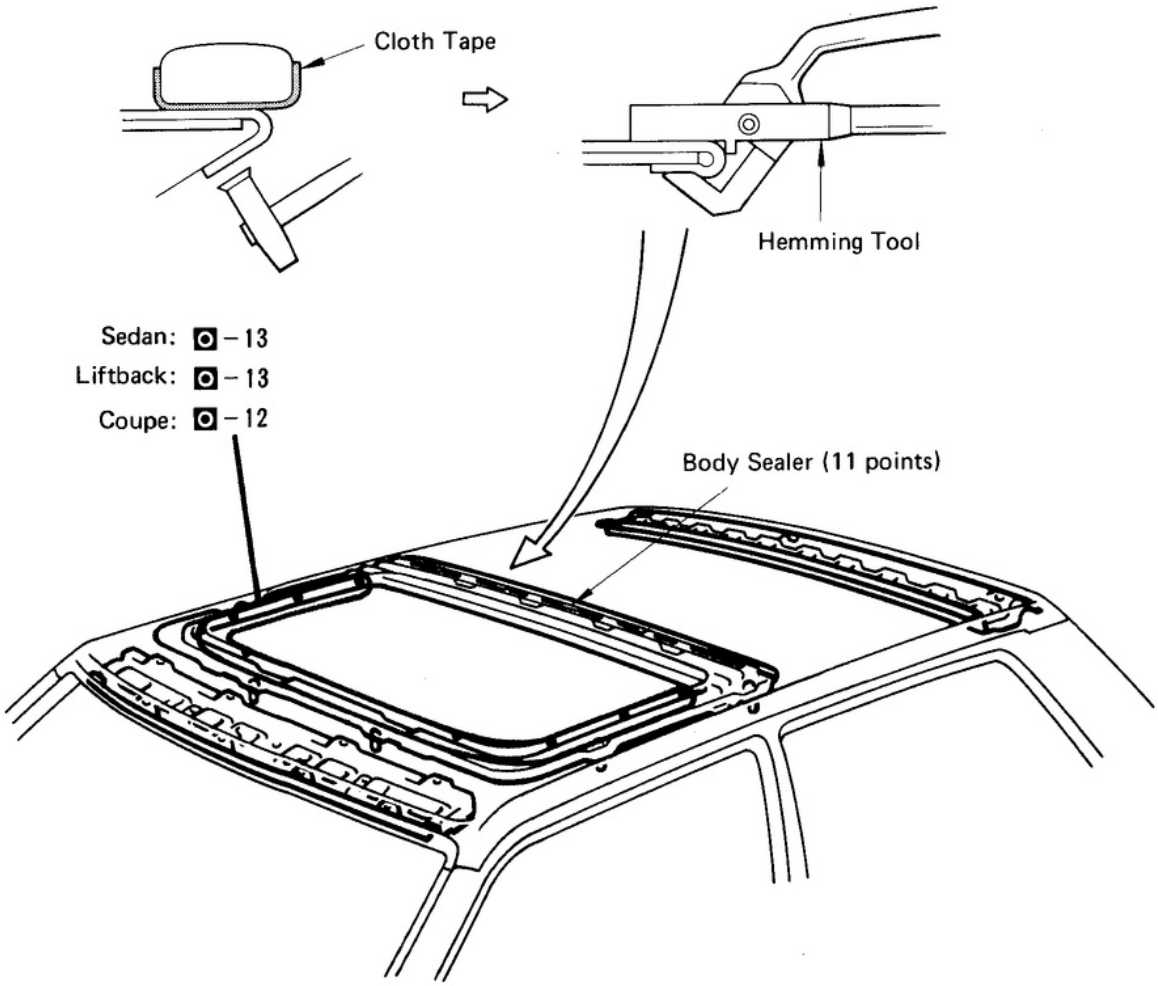


REMOVAL



1. Removal of the sealer adhered points of the roof panel center reinforcement will be easier by slightly heating the roof panel side.

INSTALLATION



1. Apply body sealer to the roof panel center reinforcement before temporarily install the new part.

NOTE: Apply just enough sealer for the new part to make contact.

2. Hem the area rear tip of the roof panel opening.

NOTE:

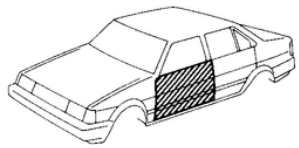
1) First bend the panel about 30° with a hammer and dolly. Then use a hemming tool.

2) Tape the dolly before use.

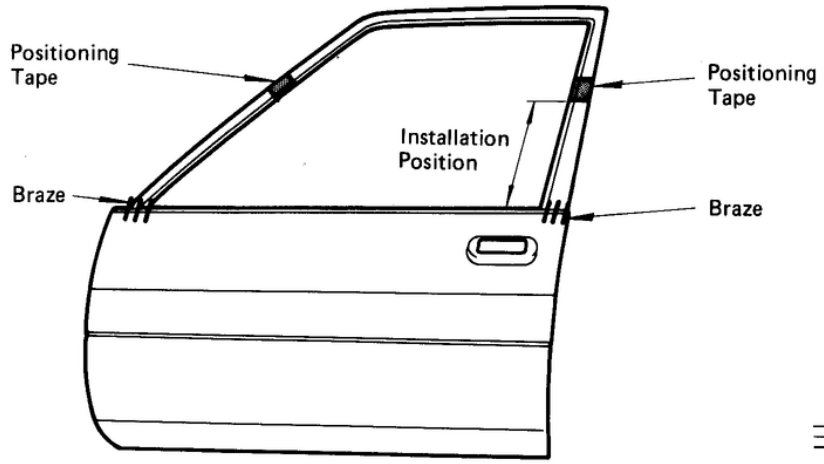
3) Do each hem in three passes to keep the panel from warping.

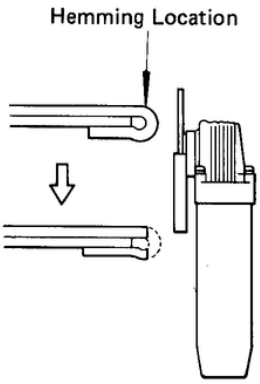
2500A, C FRONT DOOR OUTER PANEL (ASSY)

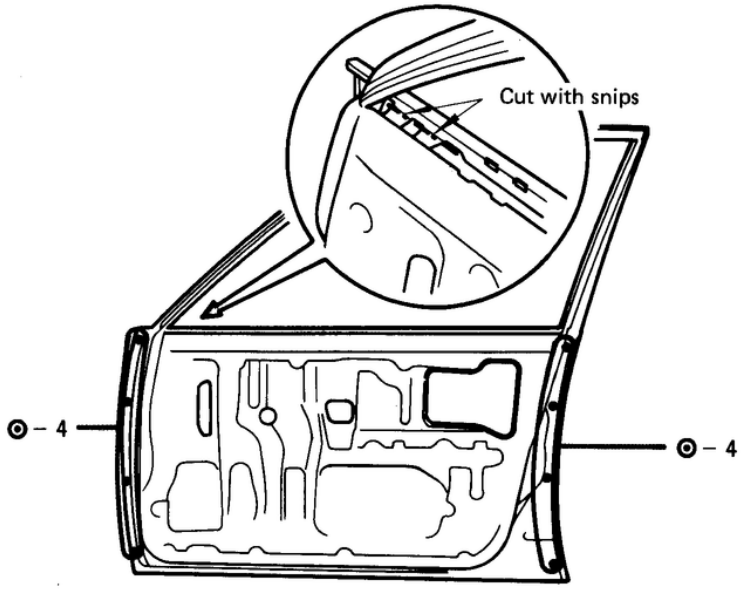
Sedan, Liftback



REMOVAL

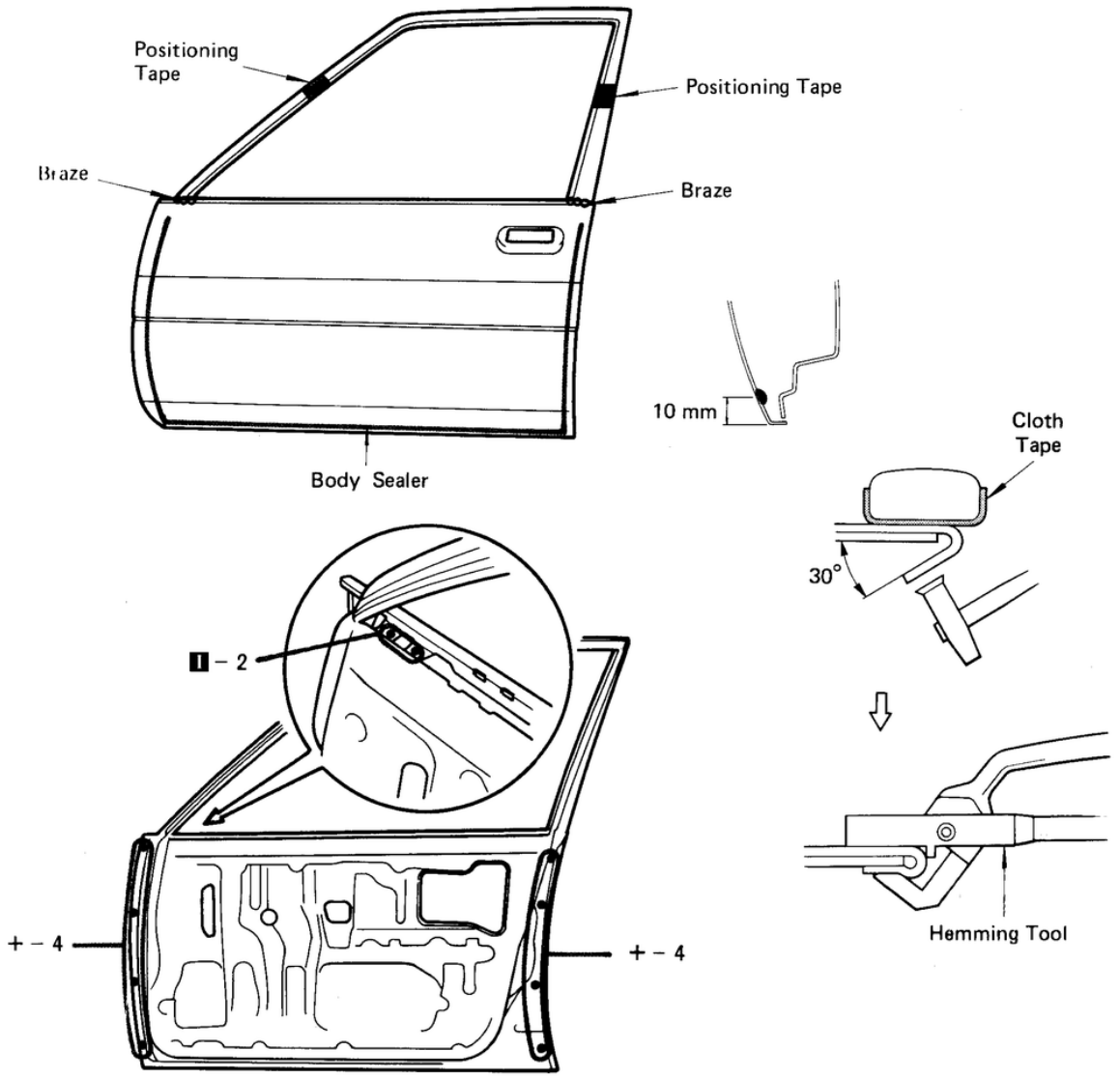






1. Before removing the outer panel, mark the installation position with tape.
2. Cut the spot weld point of the outer panel and inner panel with snips.

INSTALLATION



Conversion Table

mm	in.
10	0.39

1. Before temporarily installing the new parts, coat their back sides with body sealer.

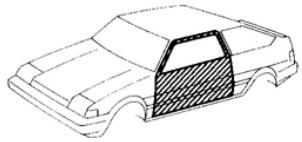
NOTE: Coat evenly about 10 mm (0.39 in.) from the flange and 3 mm (0.12 in.) in diameter.

2. Determine the position for the new parts by the distance from the tape.
3. For the flange hem, bend about 30° with a hammer and dolly. Then use a hemming tool.

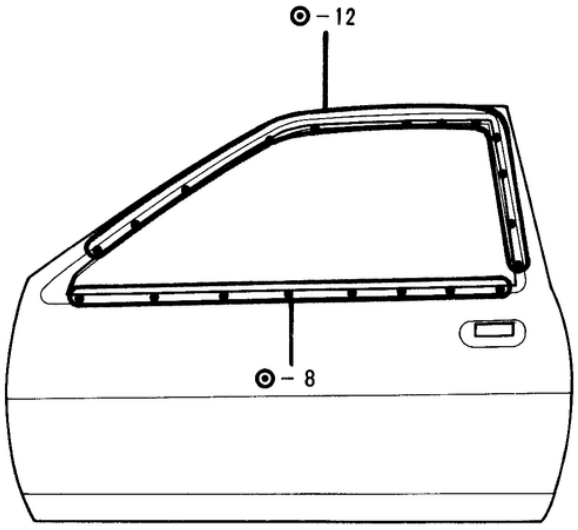
NOTE: Perform hemming in three steps, being careful not to warp the panel.

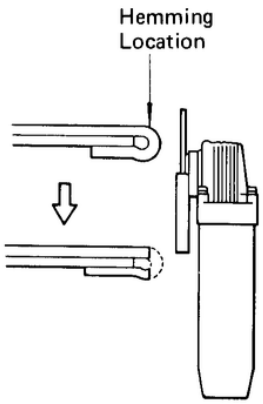
2500B, D FRONT DOOR OUTER PANEL (ASSY)

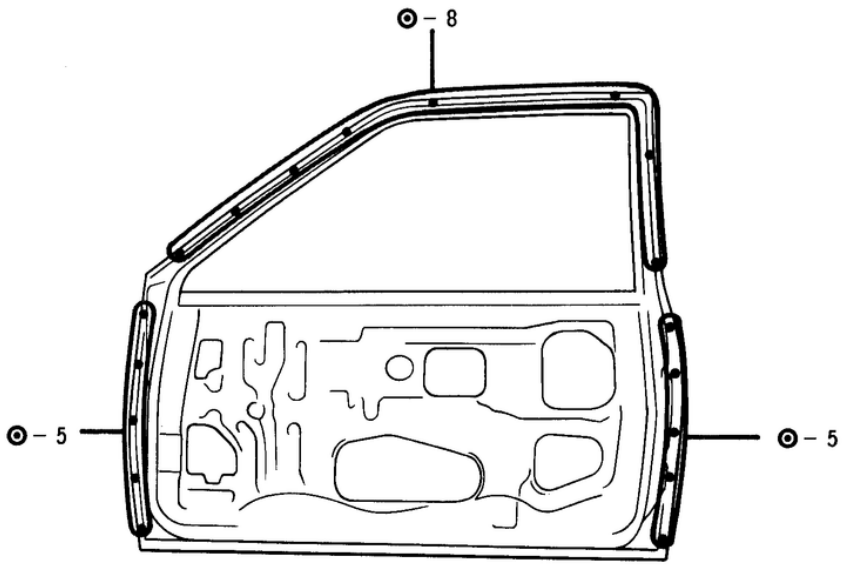
Coupe



REMOVAL

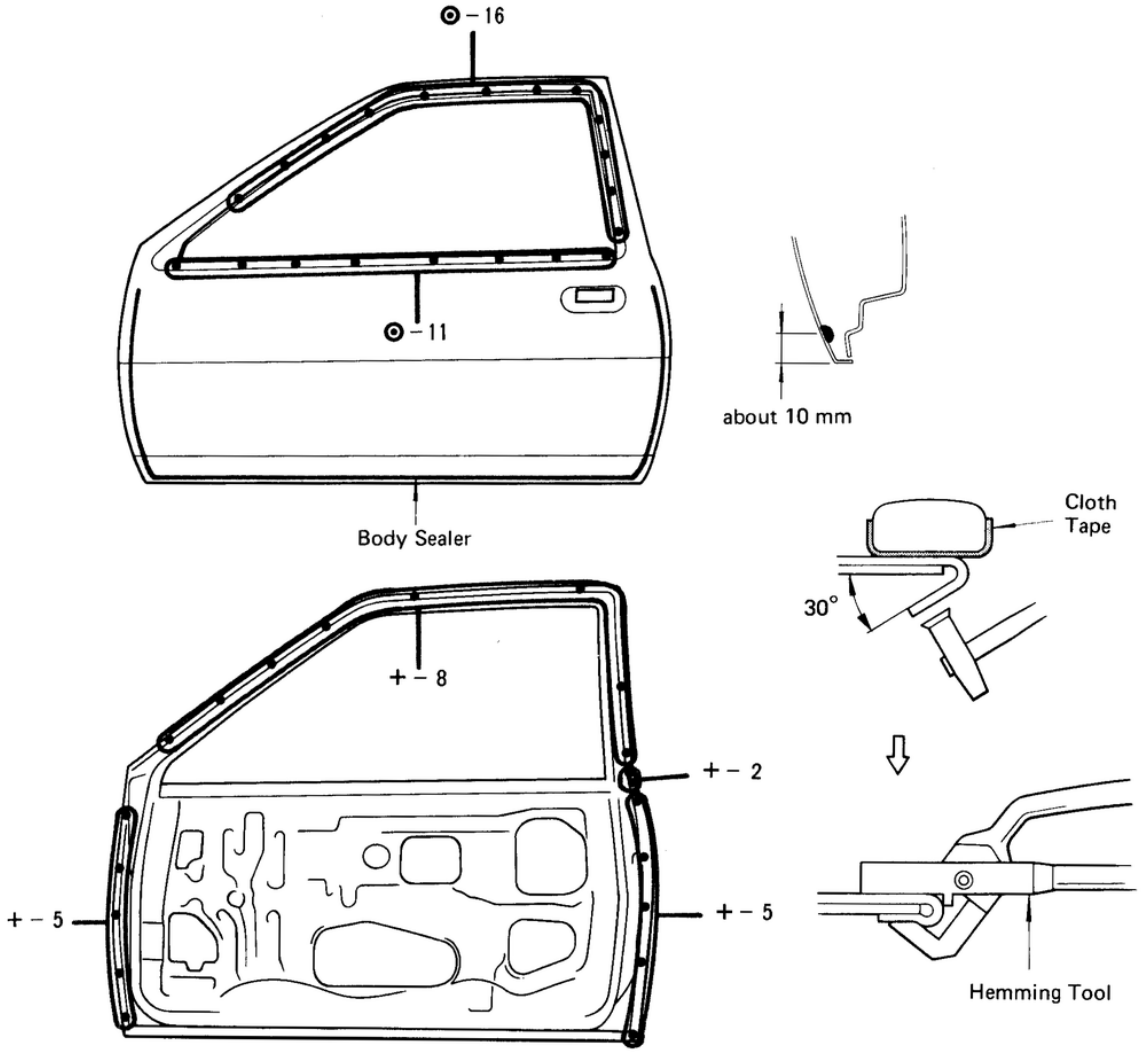






Reference: Cut and join of the outer panel as shown above is also possible.

INSTALLATION



Conversion Table

mm	in.
10	0.39

1. Before temporarily installing the new parts, coat their back side with body sealer.

NOTE: Coat evenly about 10 mm (0.39 in.) from the flange and 3 mm (0.12 in.) in diameter.

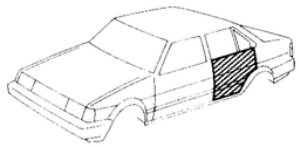
2. Determine the position for the new parts with the standard hole.

3. For the flange hem, bend about 30° with a hammer and dolly. Then use a hemming tool.

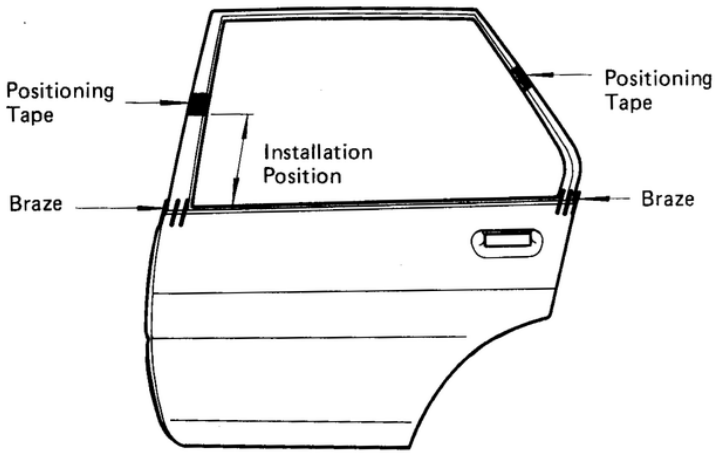
NOTE: Perform hemming in three steps, being careful not to warp the panel.

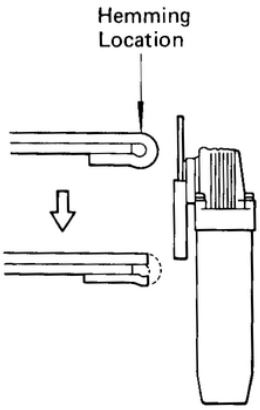
2600A, C REAR DOOR OUTER PANEL (ASSY)

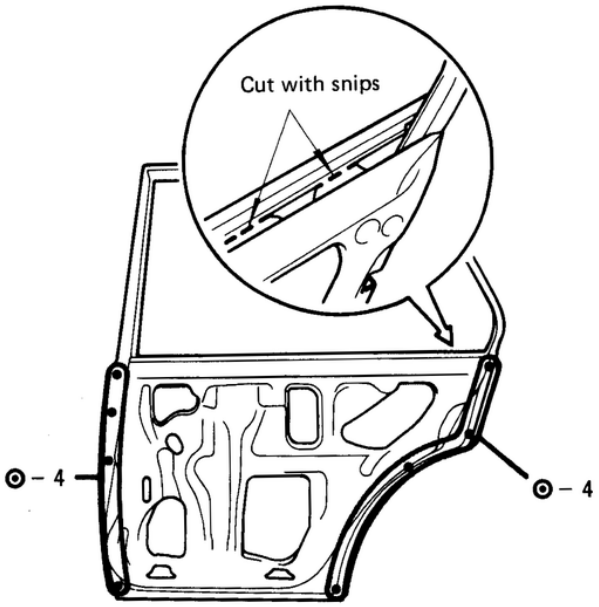
Sedan, Liftback



REMOVAL

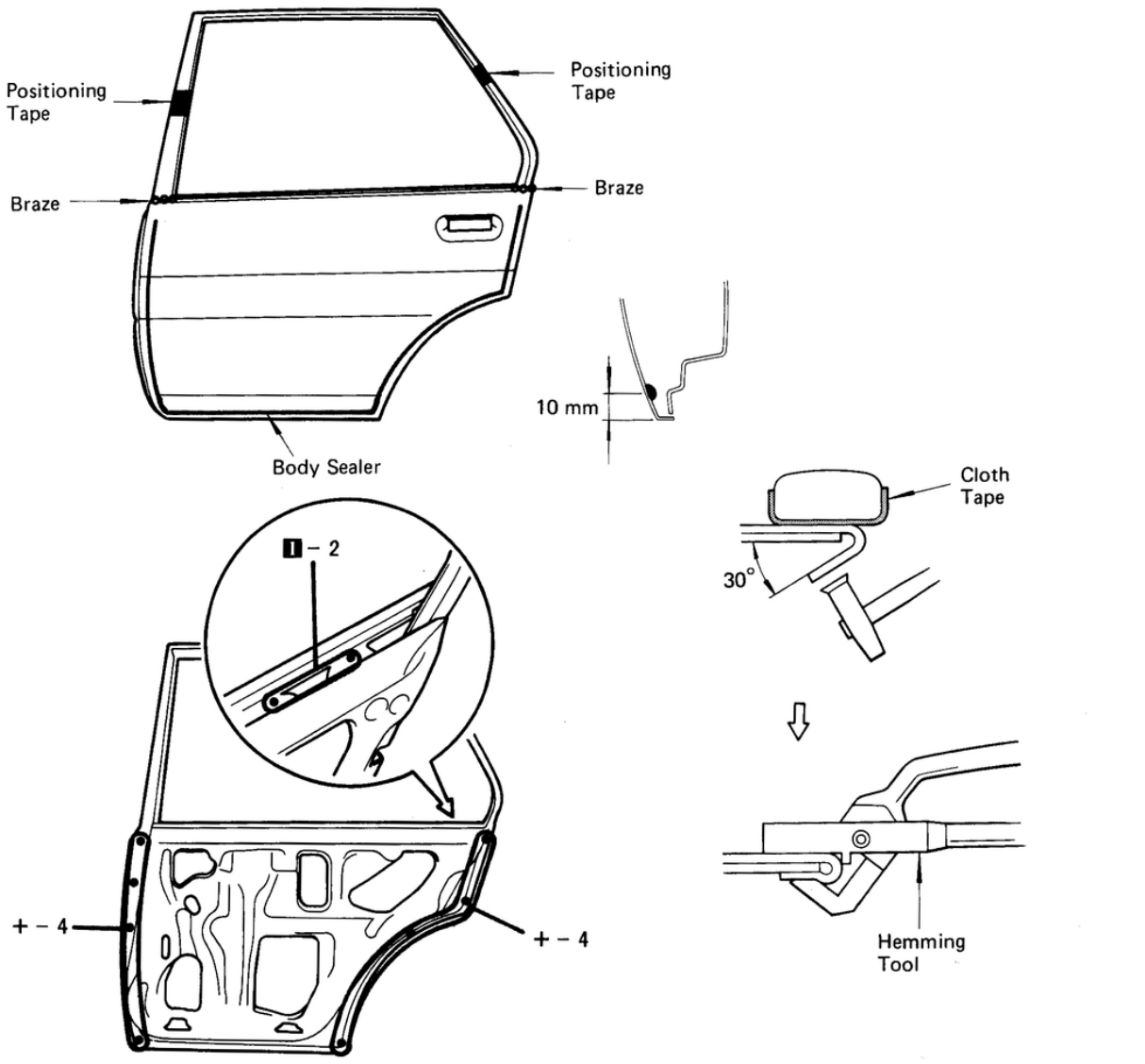






1. Before removing the outer panel, mark the installation position with tape.
2. Cut the spot weld point of the outer panel and inner panel with snips.

INSTALLATION



Conversion Table

mm	in.
10	0.39

1. Before temporarily installing the new parts, coat their back sides with body sealer.

NOTE: Coat evenly about 10 mm (0.39 in.) from the flange and 3 mm (0.12 in.) in diameter.

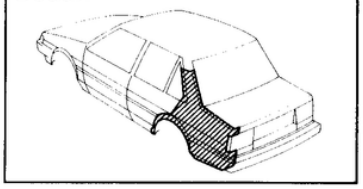
2. Determine the position for the new parts by the distance from the tape.

3. For the flange hem, bend about 30° with a hammer and dolly. Then use a hemming tool.

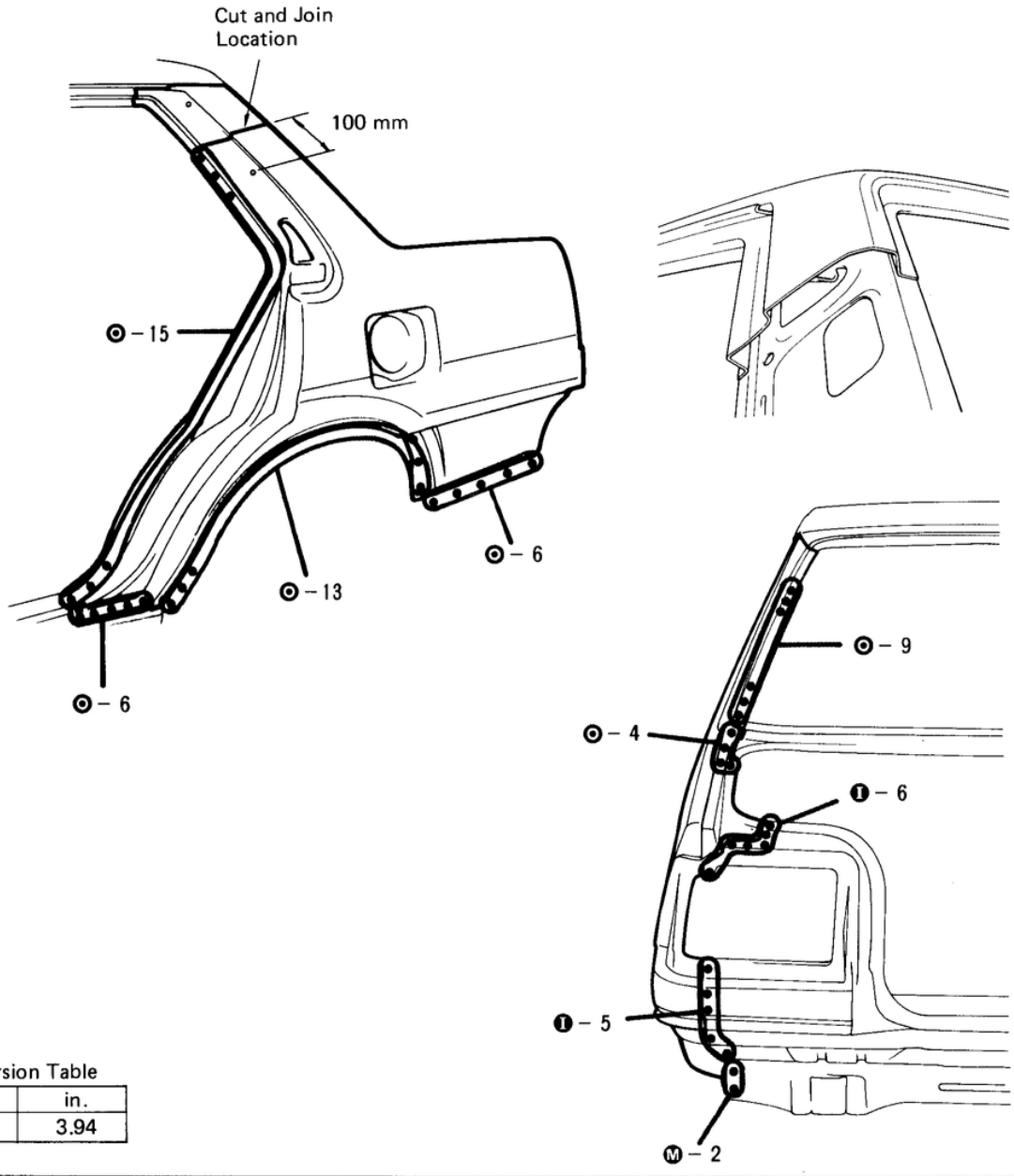
NOTE: Perform hemming in three steps, being careful not to warp the panel.

3210A QUARTER PANEL (CUT)

Sedan



REMOVAL

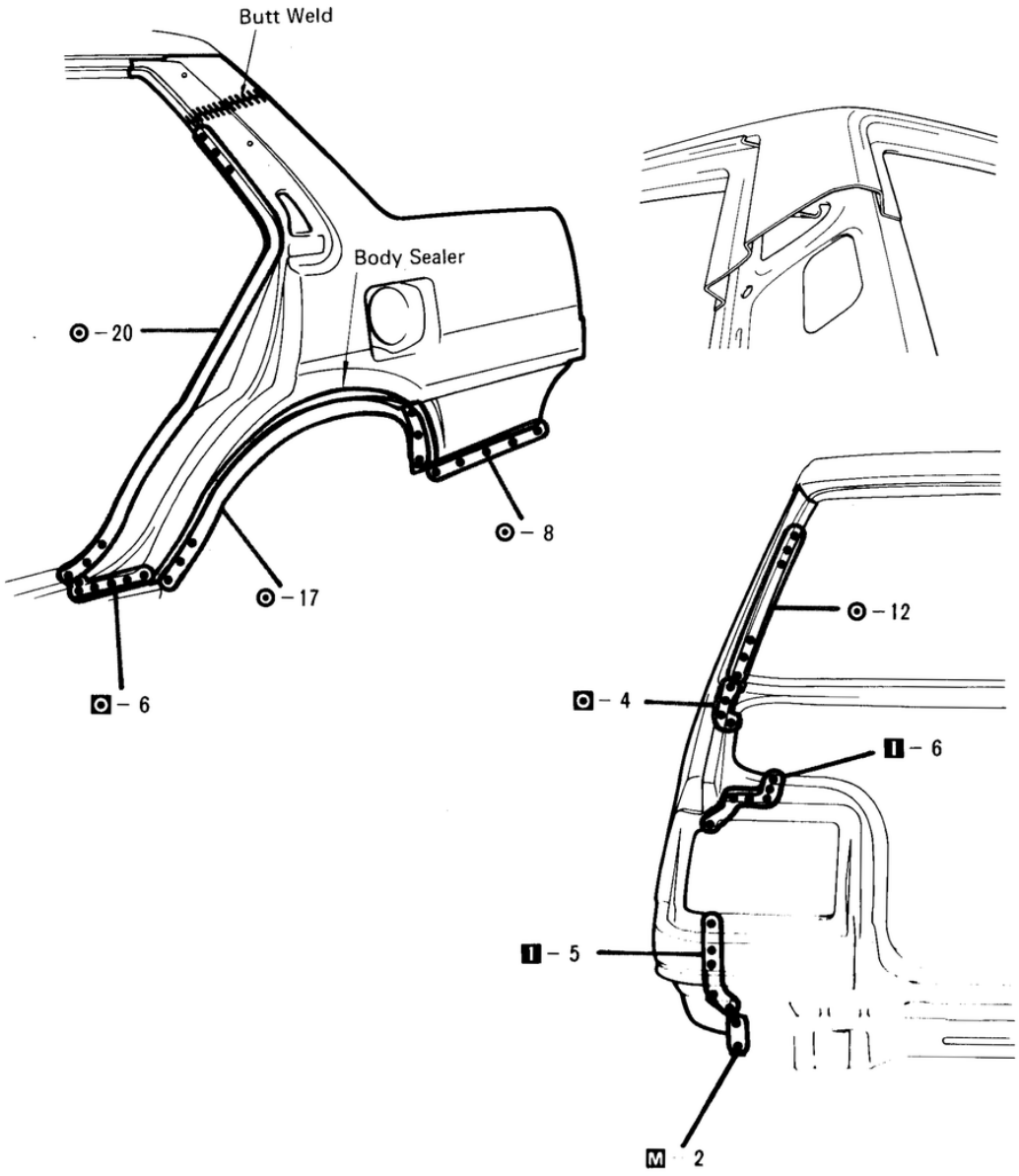


Conversion Table

mm	in.
100	3.94

1. Cut and join at the location shown above.

INSTALLATION



1. Before temporarily installing the new parts, apply body sealer to the wheel arch.

NOTE:

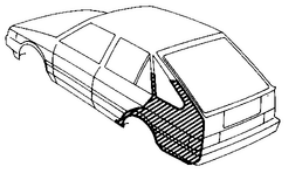
1) Apply sealer about 5 mm (0.20 in.) from the flange, avoiding any oozing. Oozing will prevent a good weld.

2) Apply evenly, about 3 – 4 mm (0.12 – 0.16 in.) in diameter.

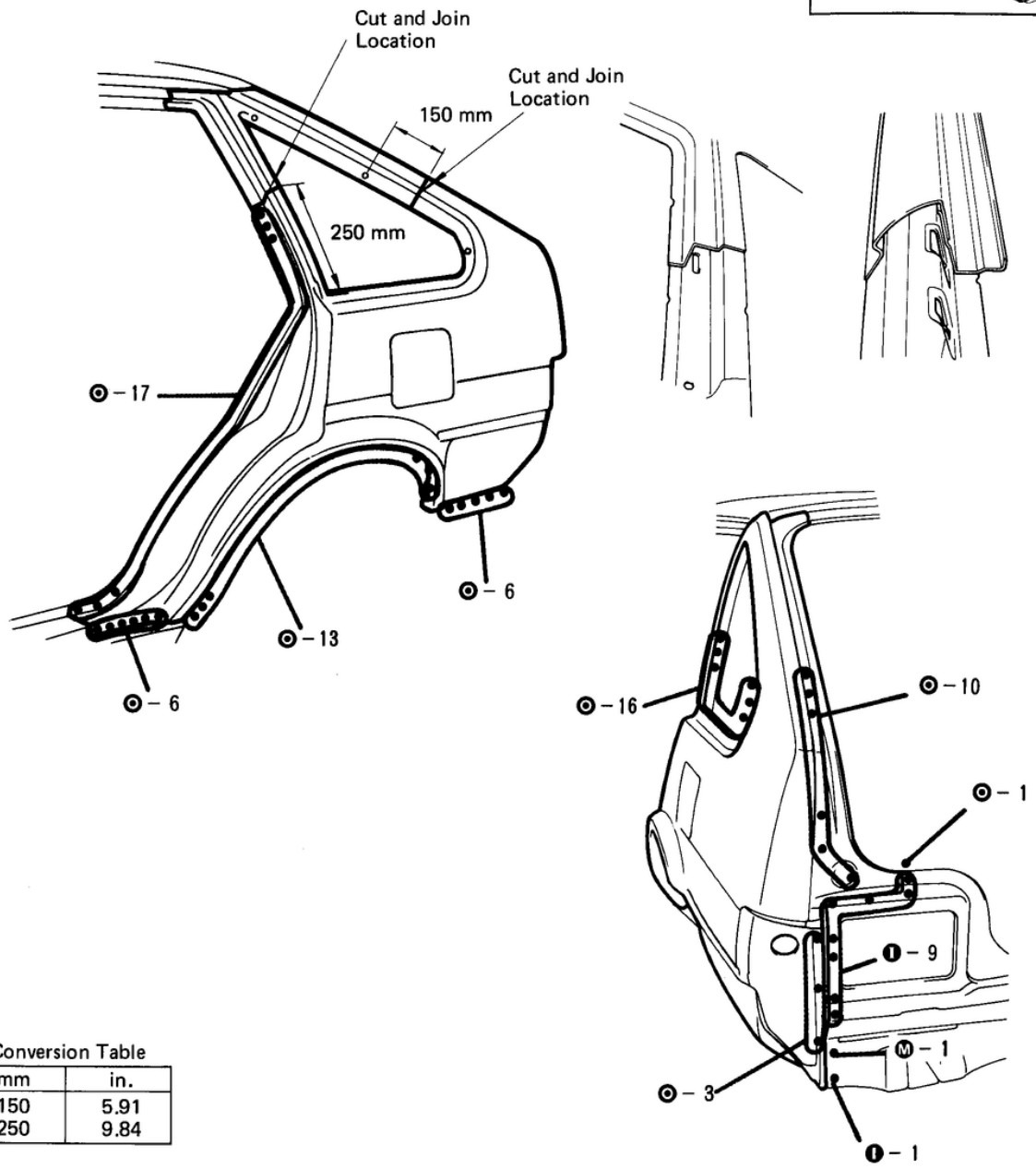
2. Temporarily install the new part, temporarily install the rear door and laggage compartment door, and check the fit.

3210C QUARTER PANEL (CUT)

Liftback



REMOVAL

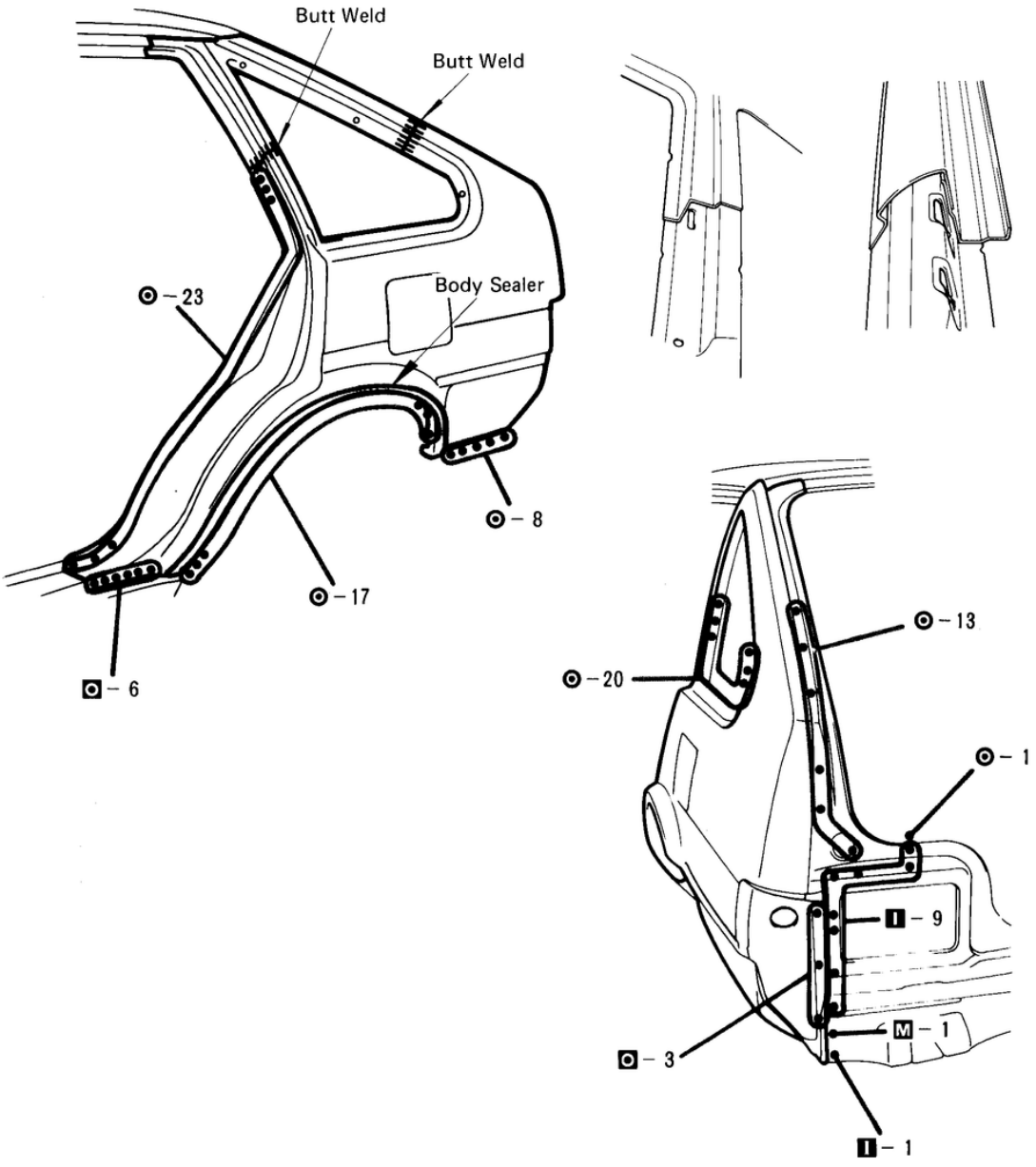


Conversion Table

mm	in.
150	5.91
250	9.84

1. Cut and join at the location shown above.

INSTALLATION



1. Before temporarily installing the new parts, apply body sealer to the wheel arch.

NOTE:

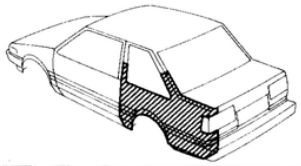
1) Apply sealer about 5 mm (0.20 in.) from the flange, avoiding any oozing. Oozing will prevent good weld.

2) Apply evenly, about 3 – 4 mm (0.12 – 0.16 in.) in diameter.

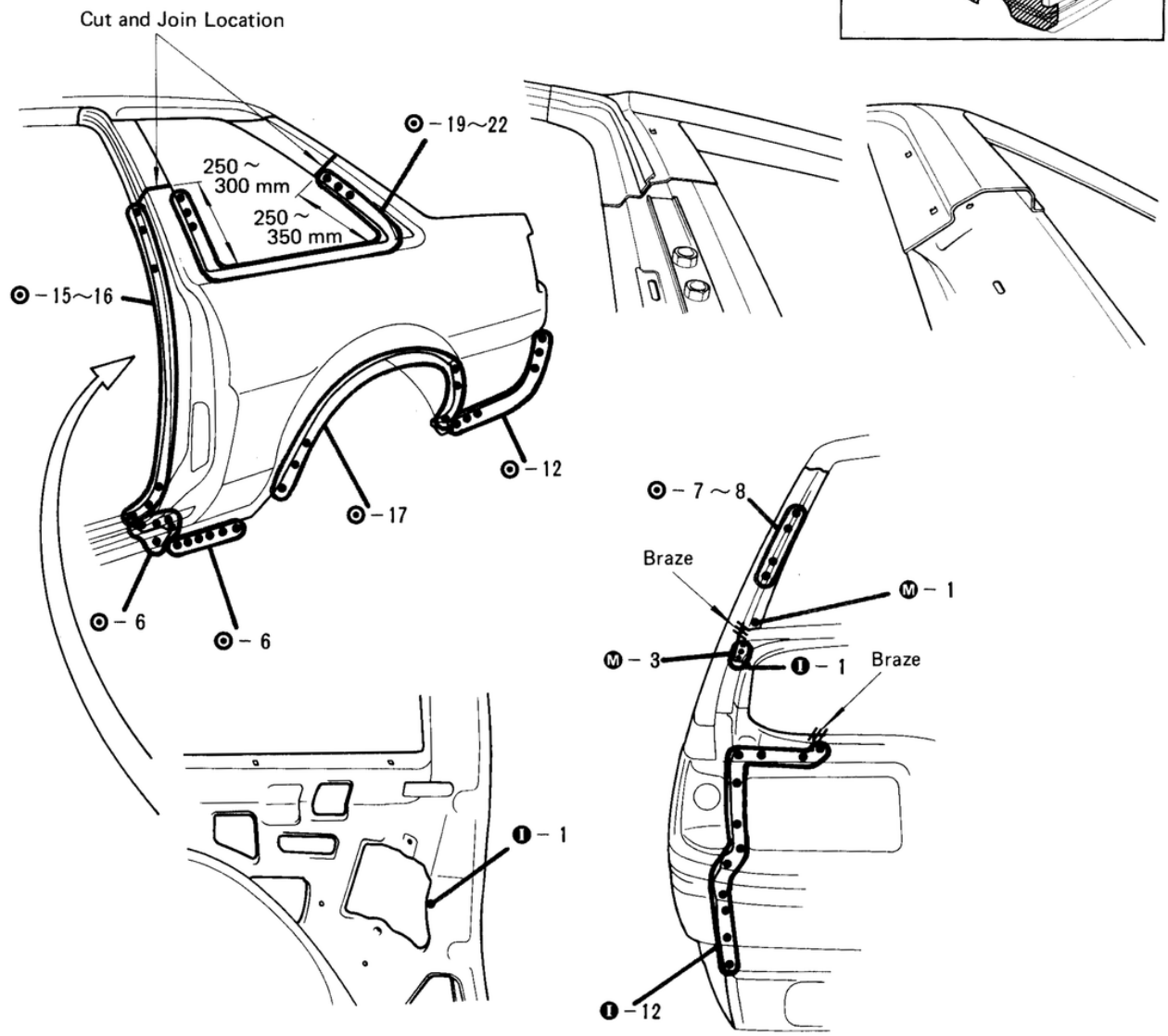
2. Temporarily install the new part, and temporarily install the rear door and back door, check the fit.

3210D QUARTER PANEL (CUT)

2-Door Coupe



REMOVAL

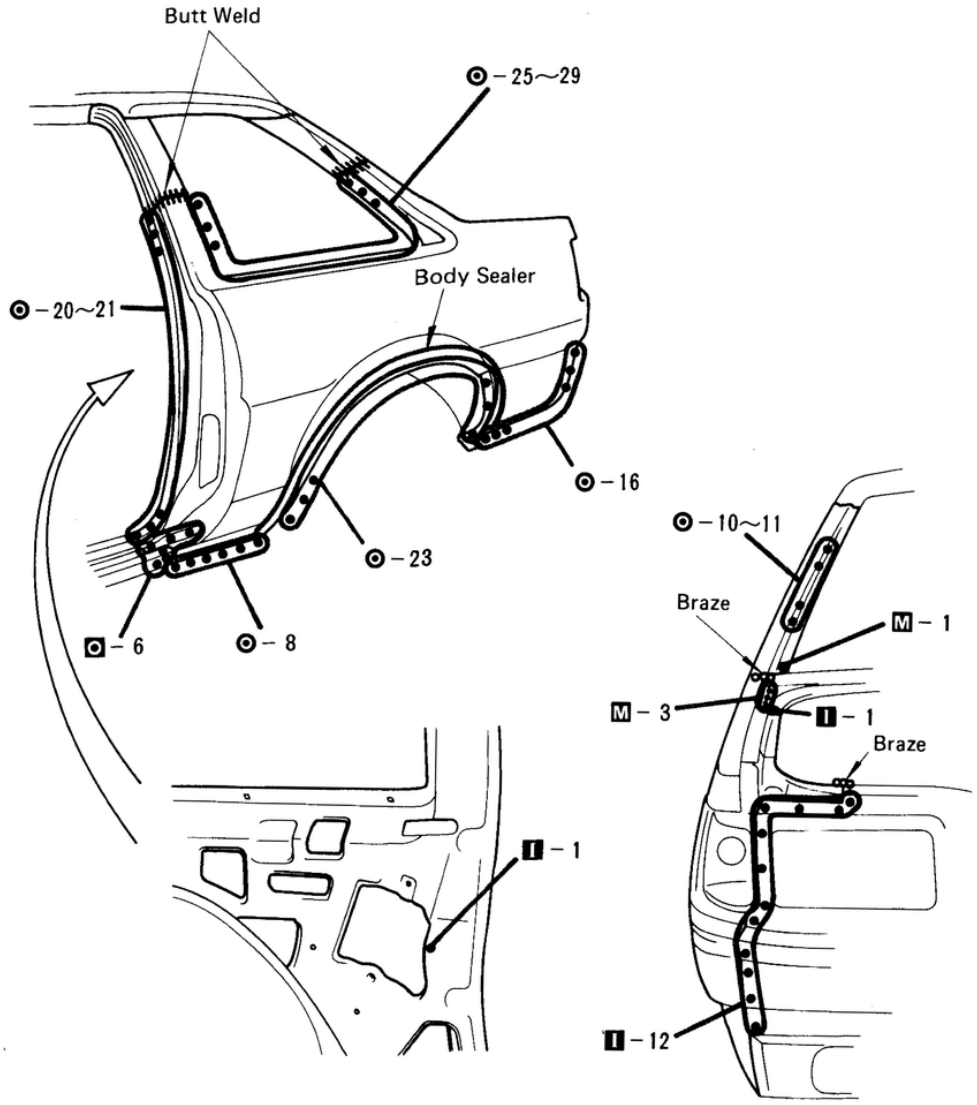


Conversion Table

mm	in.
250	9.84
300	11.81
350	13.78

1. Cut and join at the location shown above.

INSTALLATION



1. Before temporarily installing the new parts, apply body sealer to the wheel arch.

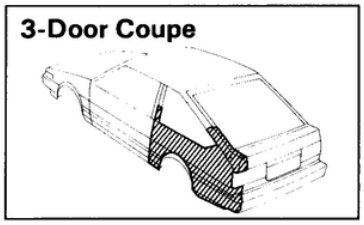
NOTE:

1) Apply sealer about 5 mm (0.20 in.) from the flange, avoiding any oozing. Oozing will prevent a good weld.

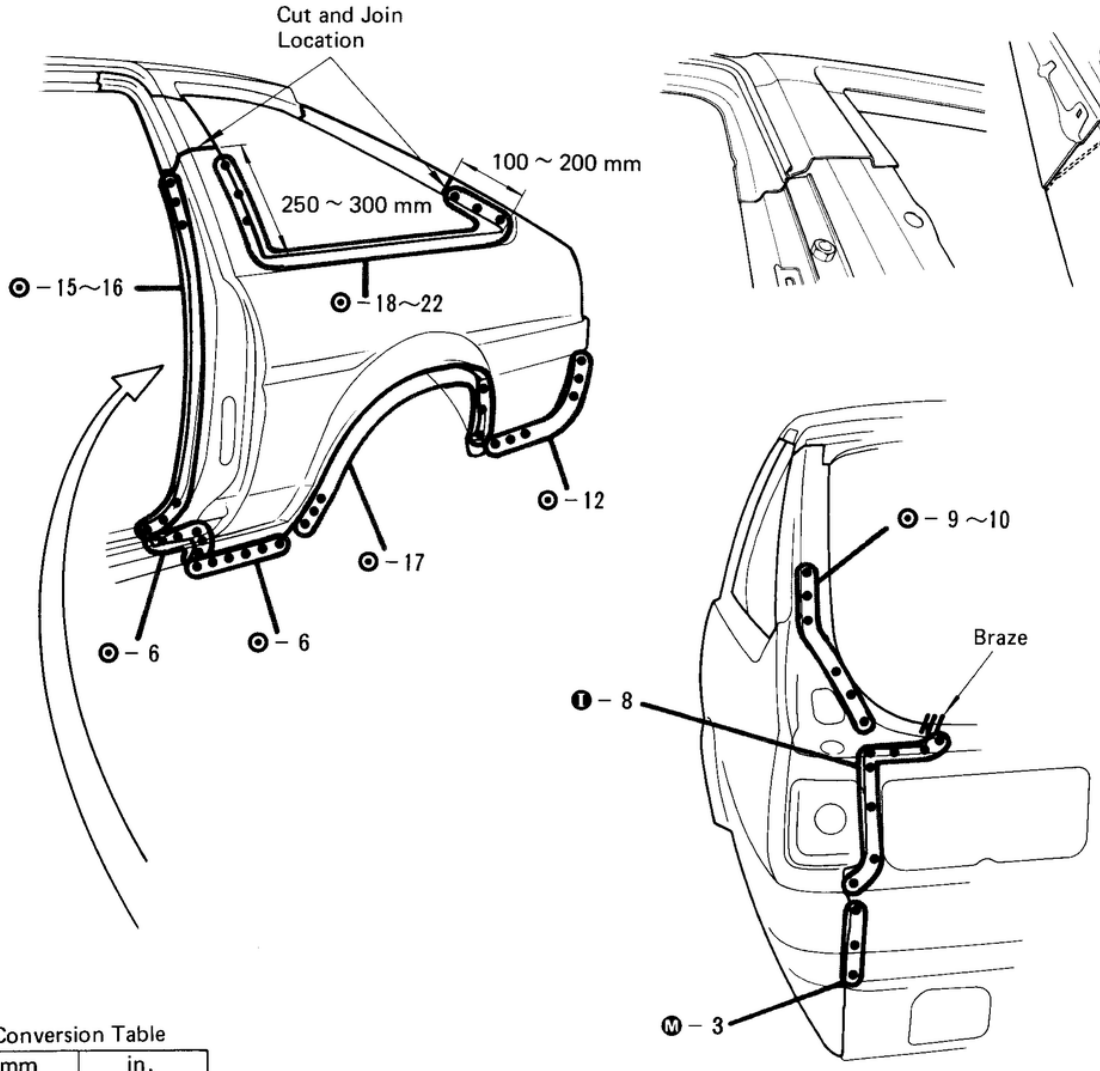
2) Apply evenly, about 3 – 4 mm (0.12 – 0.16 in.) in diameter.

2. Temporarily install the new part, temporarily install the door and laggage compartment door, and check the fit.

3210B QUARTER PANEL (CUT)



REMOVAL

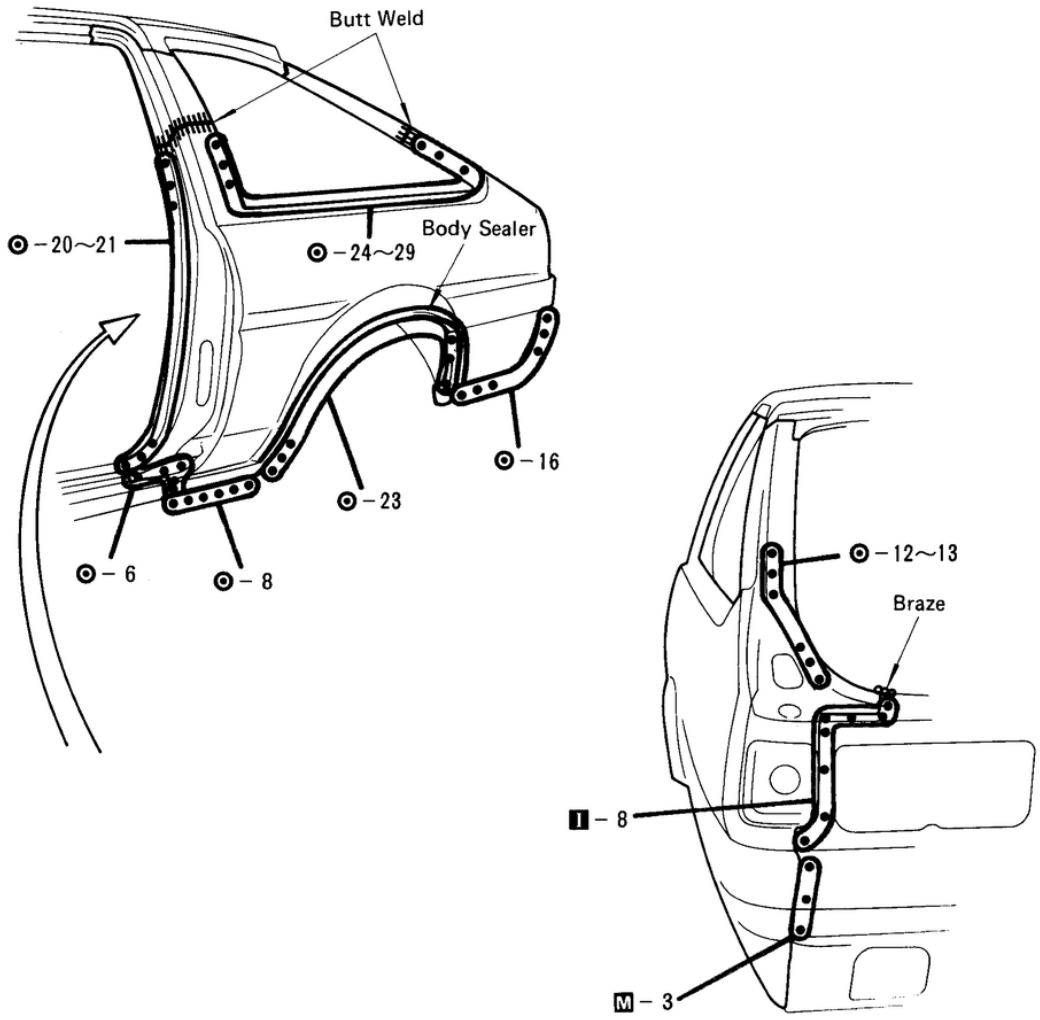


Conversion Table

mm	in.
100	3.94
200	7.87
250	9.84
300	11.81

1. Cut and join at the location shown above.

INSTALLATION



1. Before temporarily installing the new parts, apply body sealer to the wheel arch.

NOTE:

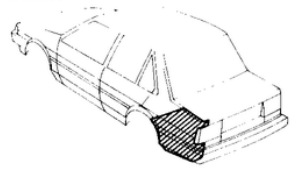
1) Apply sealer about 5 mm (0.20 in.) from the flange, avoiding any oozing. Oozing will prevent good weld.

2) Apply evenly, about 3 - 4 mm (0.12 - 0.16 in.) in diameter.

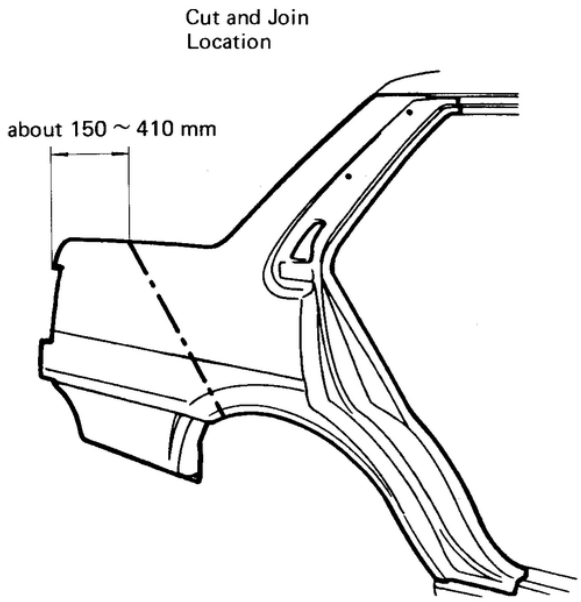
2. Temporarily install the new part, temporarily install the door and back door, and check the fit.

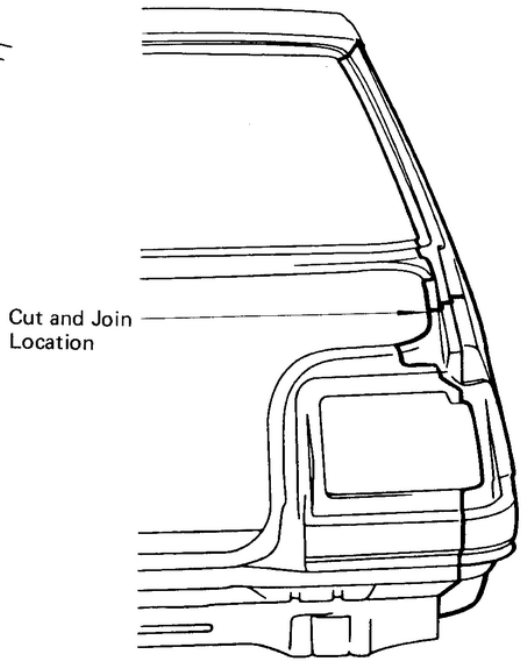
3230A QUARTER PANEL (CUT)

Sedan



REMOVAL





* This section is a cut and join location only. Refer to RE– 56 for weld points.

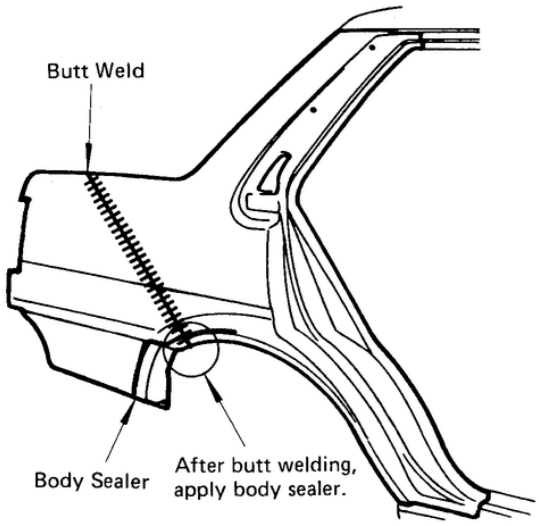
Conversion Table

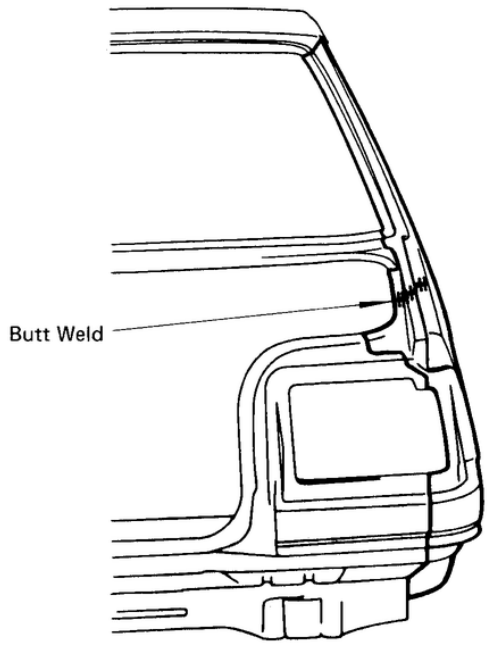
mm	in.
150	5.91
410	16.14

1. Cut on the line shown above.

NOTE: Avoid the fuel inlet box when cutting the quarter panel.

INSTALLATION





* This section is a cut and join location only. Refer to RE– 57 for weld points.

1. Before cutting the overlap areas, check the fit.

NOTE: Temporarily install the luggage compartment door panel. Then check the fit.

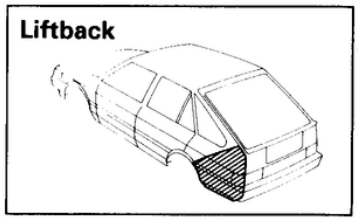
2. Before welding, apply body sealer from inside of the vehicle.

NOTE: Do not apply body sealer to the weld seams before welding as the sealer would melt, resulting in a bad seal and a bad weld.

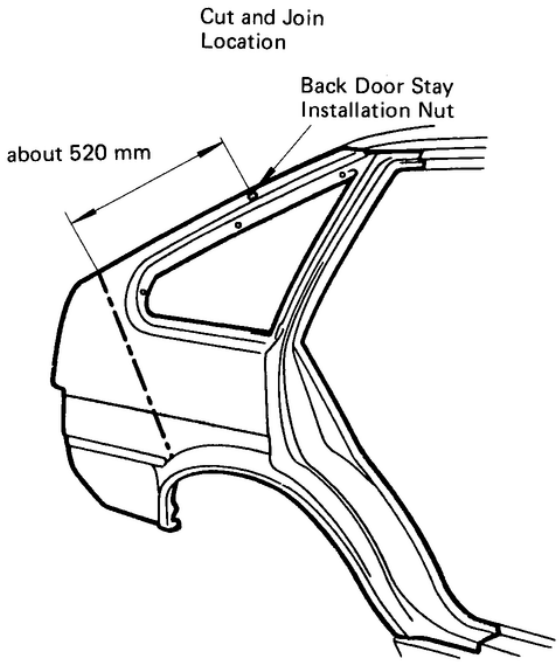
3. Surface finish the weld seams from the inside also.

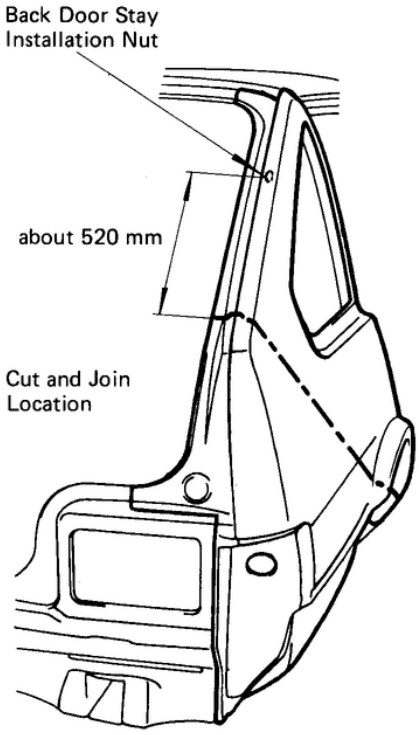
NOTE: Be careful not to grind off too much weld as it would result in loss of durability.

3230C QUARTER PANEL (CUT)



REMOVAL





* This section is a cut and join location only. Refer to RE– 58 for weld points.

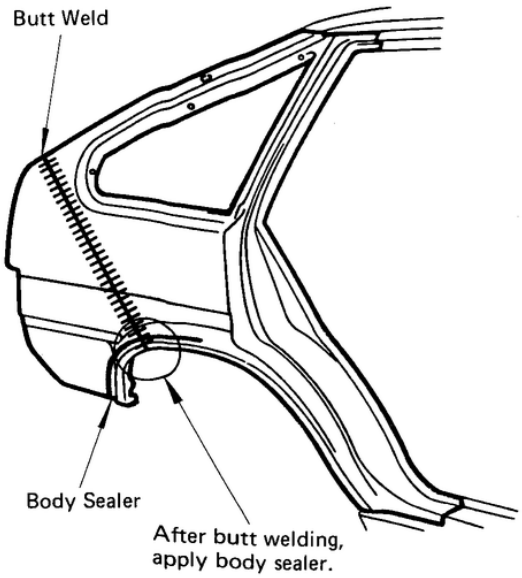
Conversion Table

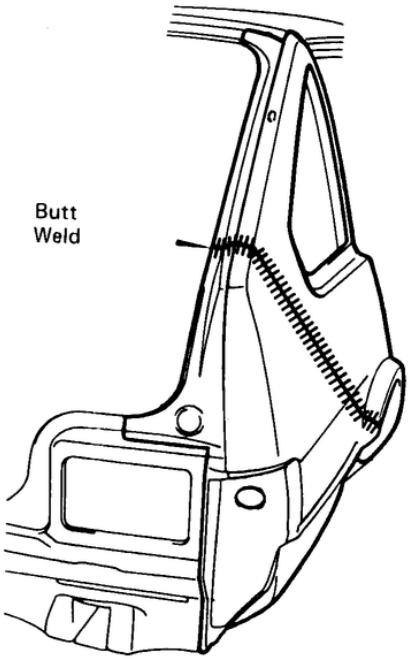
mm	in.
520	20.47

1. Cut on the line shown above.

NOTE: Avoid the roof side inner panel and fuel inlet box when cutting the quarter panel.

INSTALLATION





* This section is a cut and join location only. Refer to RE–59 for weld points.

1. Before cutting the overlap areas, check the fit.

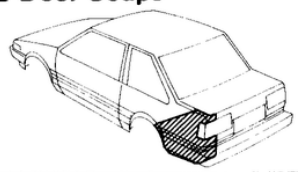
NOTE: Temporarily install the back door. Then check the fit.

2. Before welding, apply body sealer from inside of the vehicle.

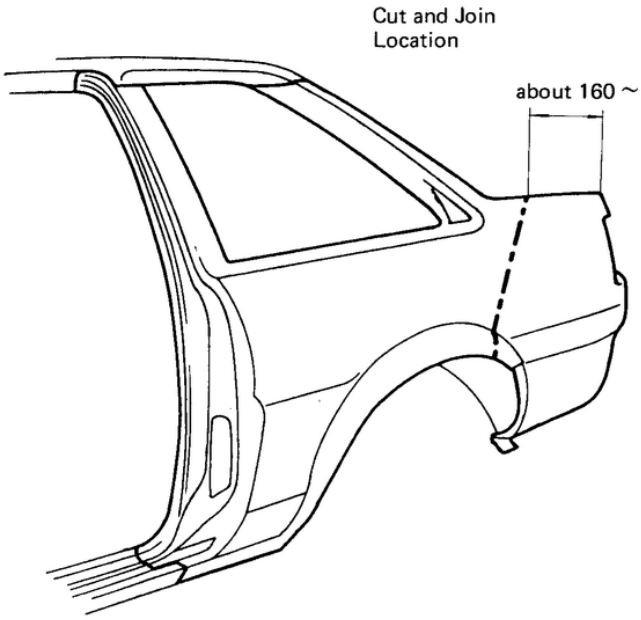
NOTE: Do not apply body sealer to the weld seams before welding as the sealer would melt, resulting in a bad seal and a bad weld.

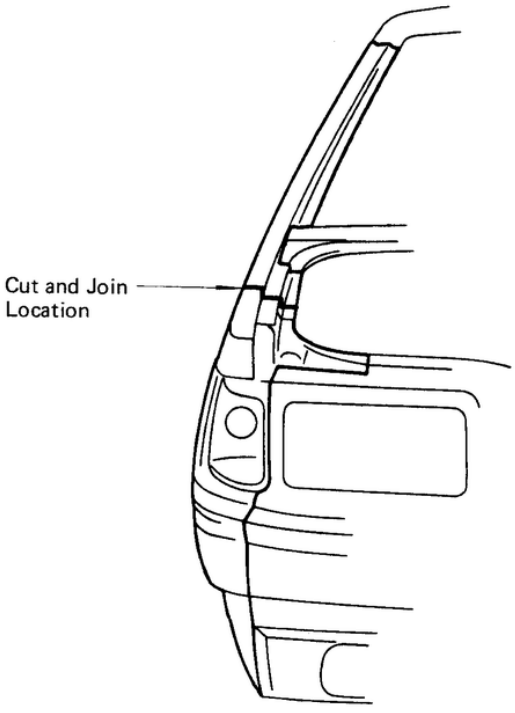
3230D QUARTER PANEL (CUT)

2-Door Coupe



REMOVAL





* This section is a cut and join location only. Refer to RE– 60 for weld points.

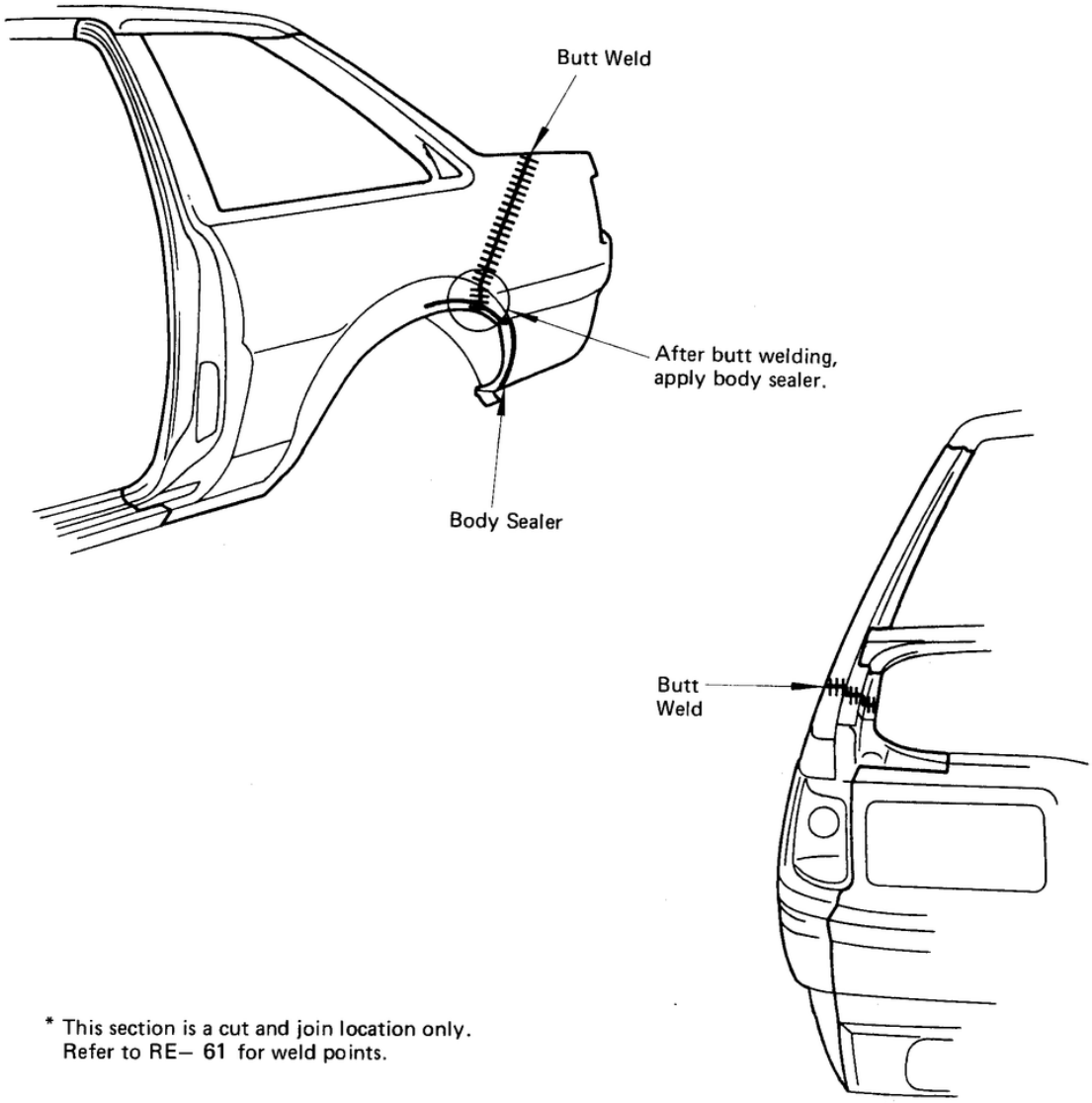
Conversion Table

mm	in.
160	6.30
360	14.17

1. Cut on the line shown above.

NOTE: Avoid the fuel inlet box when cutting the quarter panel.

INSTALLATION



* This section is a cut and join location only. Refer to RE– 61 for weld points.

1. Before cutting the overlap areas, check the fit.

NOTE: Temporarily install the luggage compartment door panel. Then check the fit.

2. Before welding, apply body sealer from inside of the vehicle.

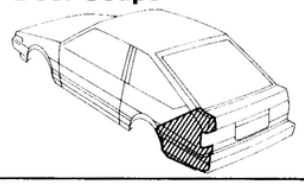
NOTE: Do not apply body sealer to the weld seams before welding as the sealer would melt, resulting in a bad seal and a bad weld.

3. Surface finish the weld seams from the inside also.

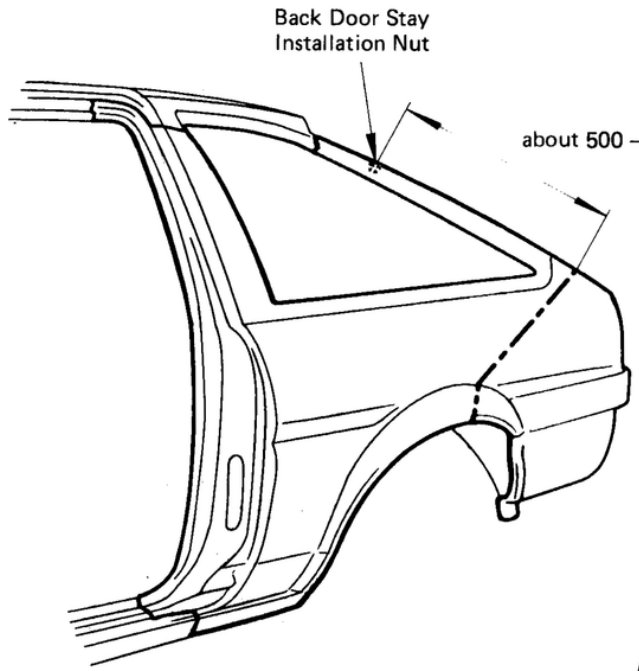
NOTE: Be careful not to grind off too much weld as it would result in loss of durability.

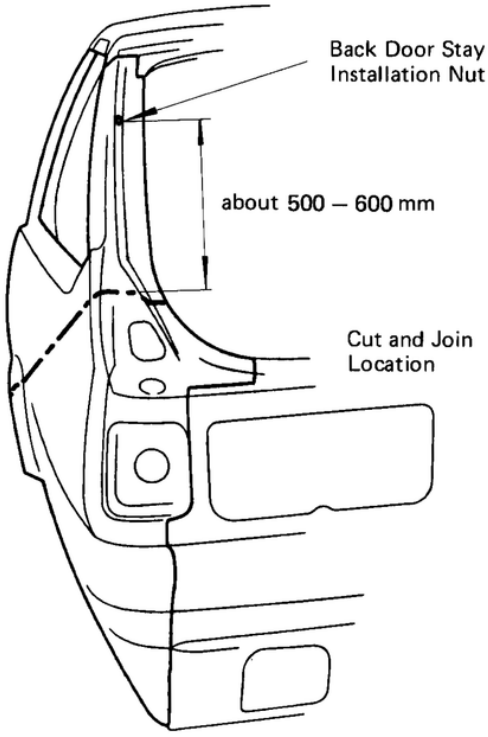
3230B QUARTER PANEL (CUT)

3-Door Coupe



REMOVAL





* This section is a cut and join location only. Refer to RE–62 for weld points.

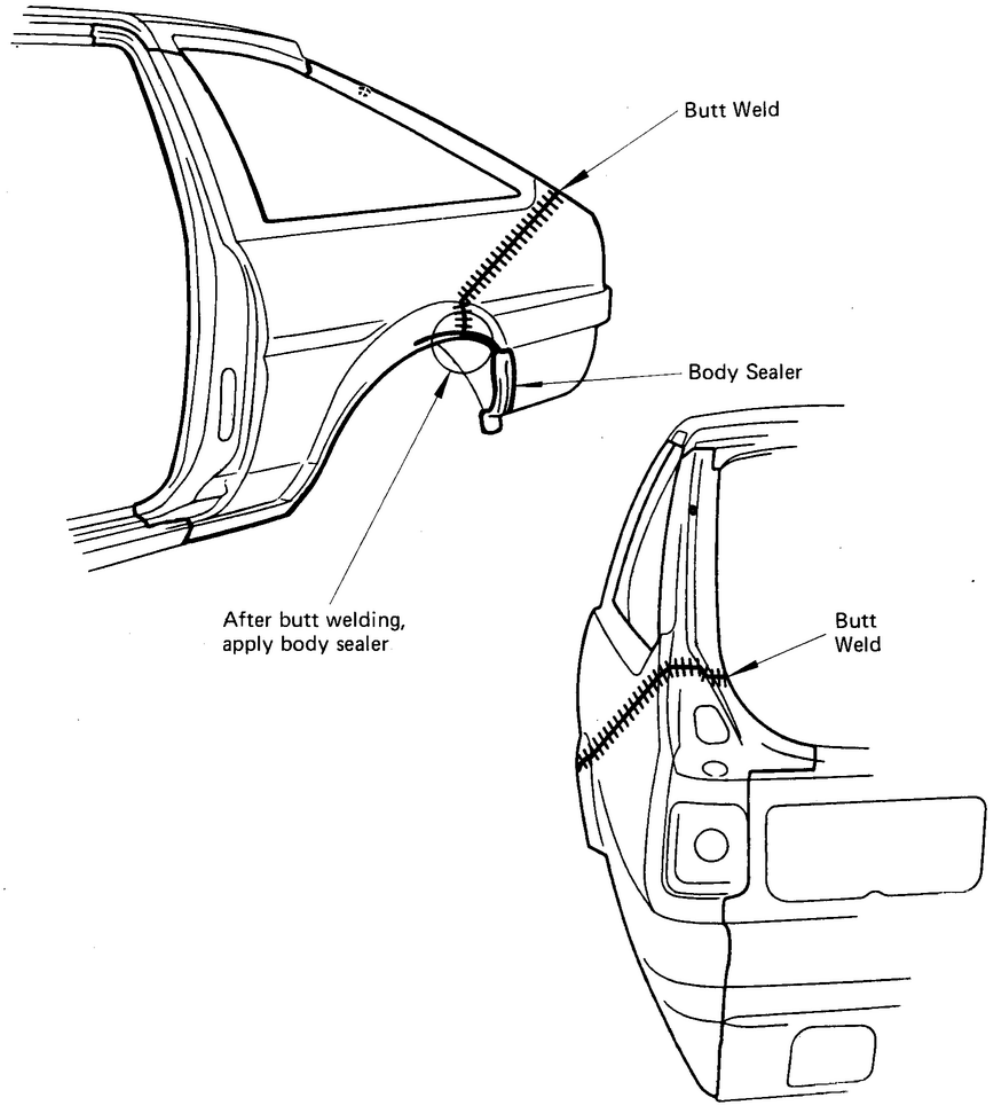
Conversion Table

mm	in.
500	19.69
600	23.62

1. Cut on the line shown above.

NOTE: Avoid the fuel inlet box when cutting the quarter panel.

INSTALLATION



* This section is a cut and join location only. Refer to RE– 63 for weld points.

1. Before cutting the overlap areas, check the fit.

NOTE: Temporarily install the back door. Then check the fit.

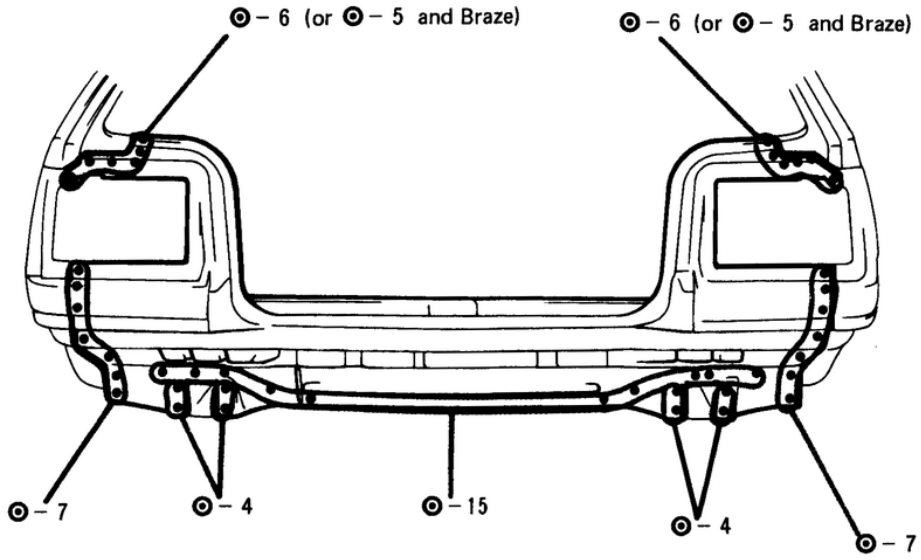
2. Before welding, apply body sealer from inside of the vehicle.

NOTE: Do not apply body sealer to the weld seams before welding as the sealer would melt, resulting in a bad seal and a bad weld.

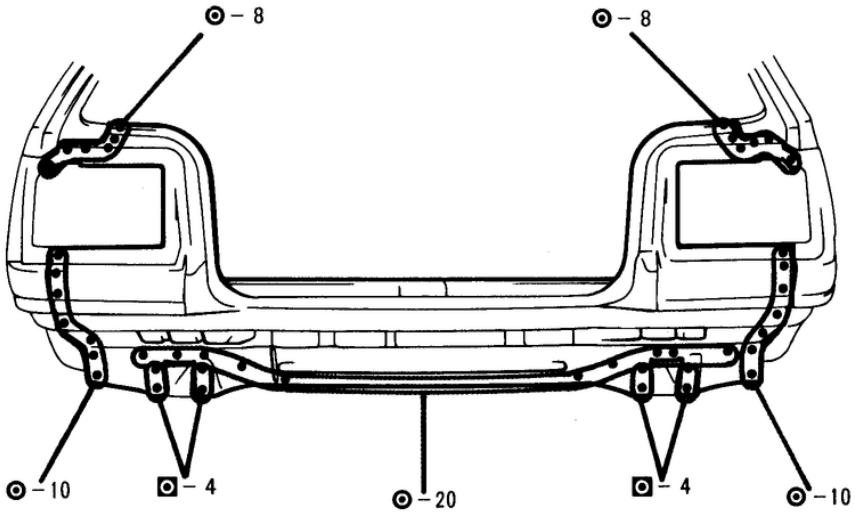
3300A BODY LOWER BACK PANEL (ASSY)

Sedan

REMOVAL



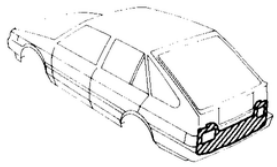
INSTALLATION



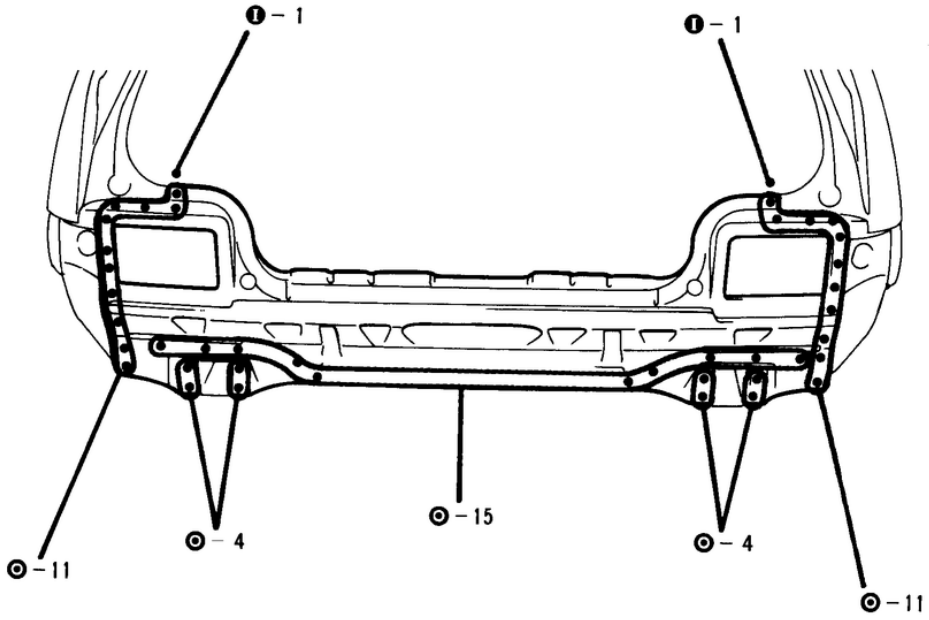
1. Temporarily install the new part. Then temporarily install the rear combination light and luggage compartment door, and check the fit.

3300C BODY LOWER BACK PANEL (ASSY)

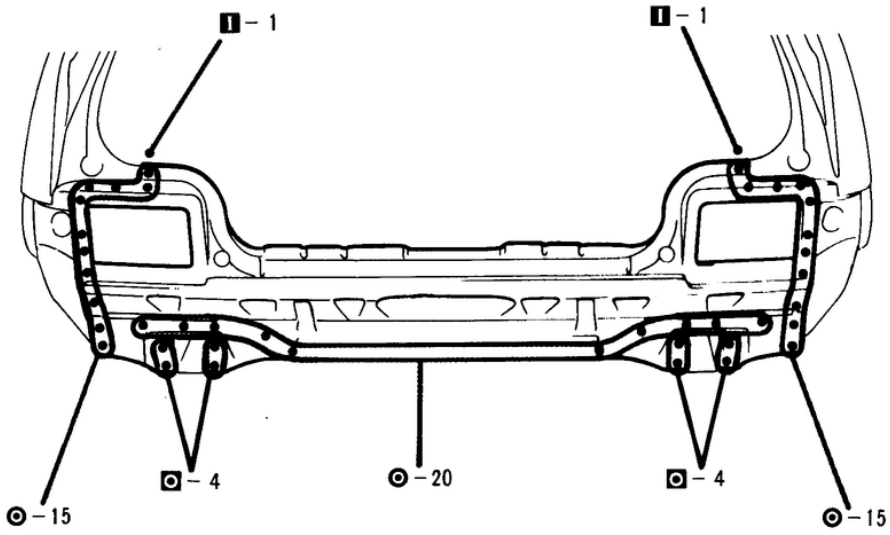
Liftback



REMOVAL

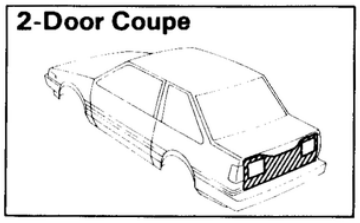


INSTALLATION

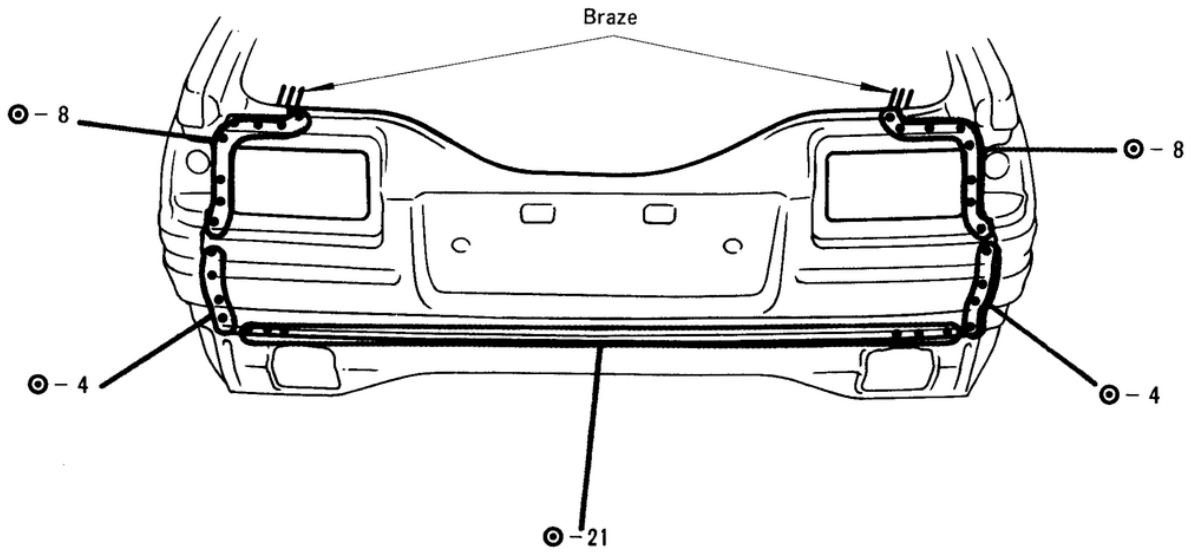


1. Temporarily install the new part. Then temporarily install the rear combination light and back door, and check the fit.

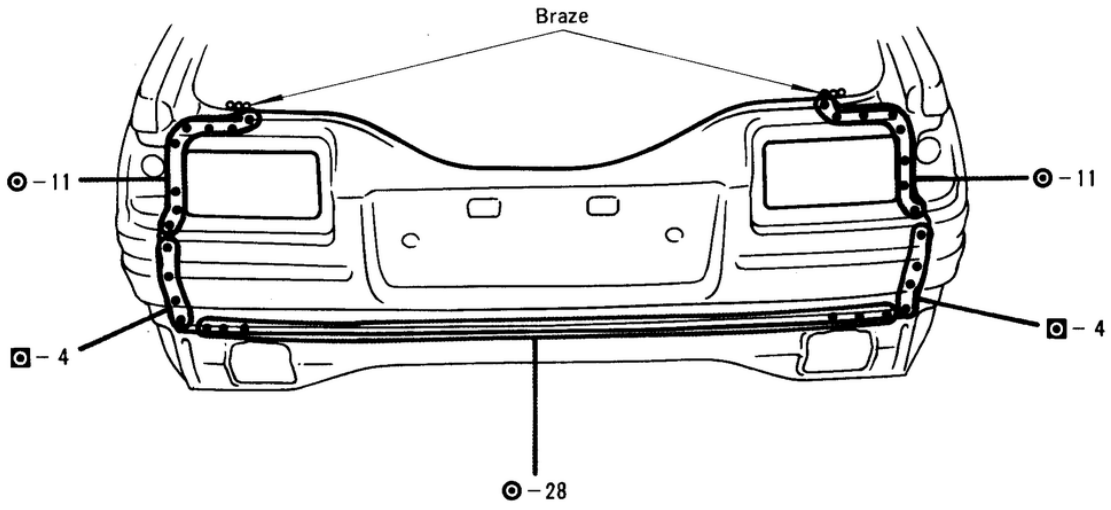
3300D BODY LOWER BACK PANEL (ASSY)



REMOVAL



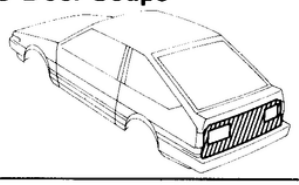
INSTALLATION



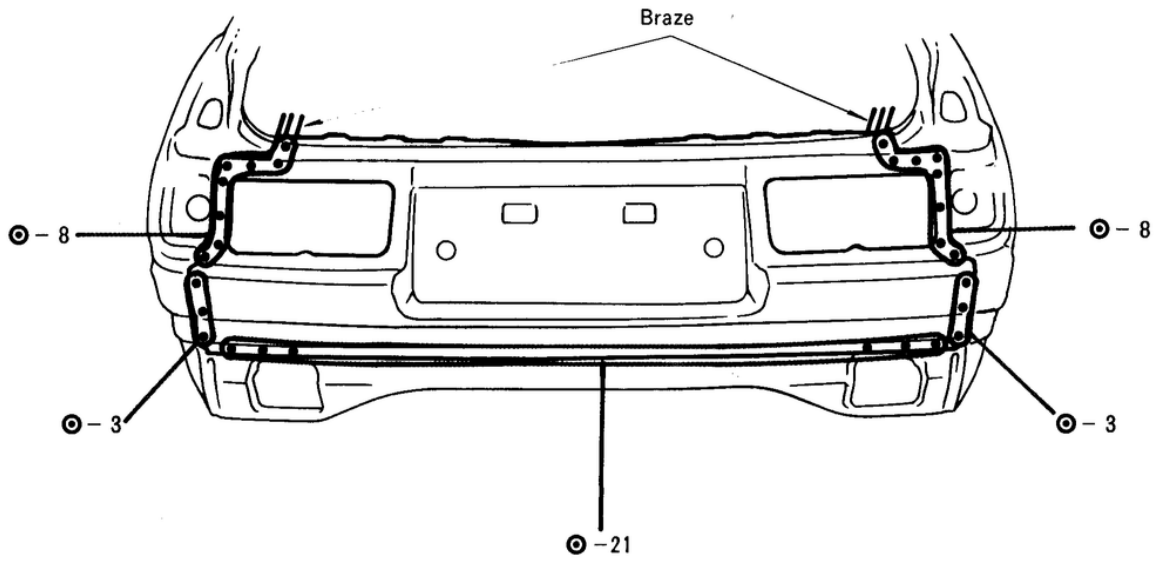
1. Temporarily install the new part. Then temporarily install the rear combination light and luggage compartment door, and check the fit.

3300B BODY LOWER BACK PANEL (ASSY)

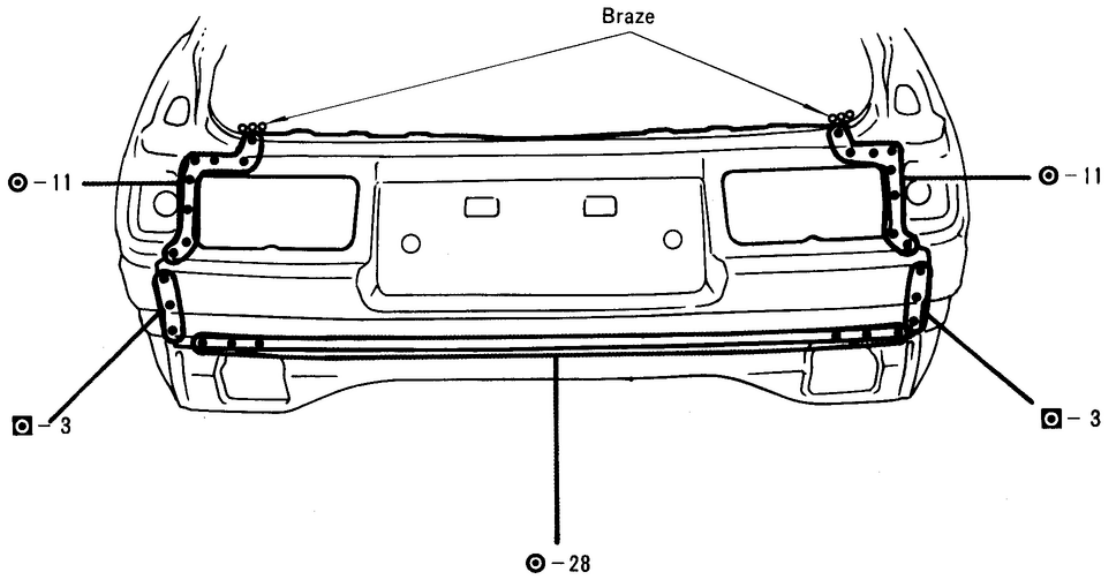
3-Door Coupe



REMOVAL



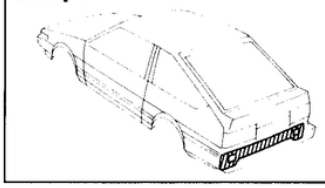
INSTALLATION



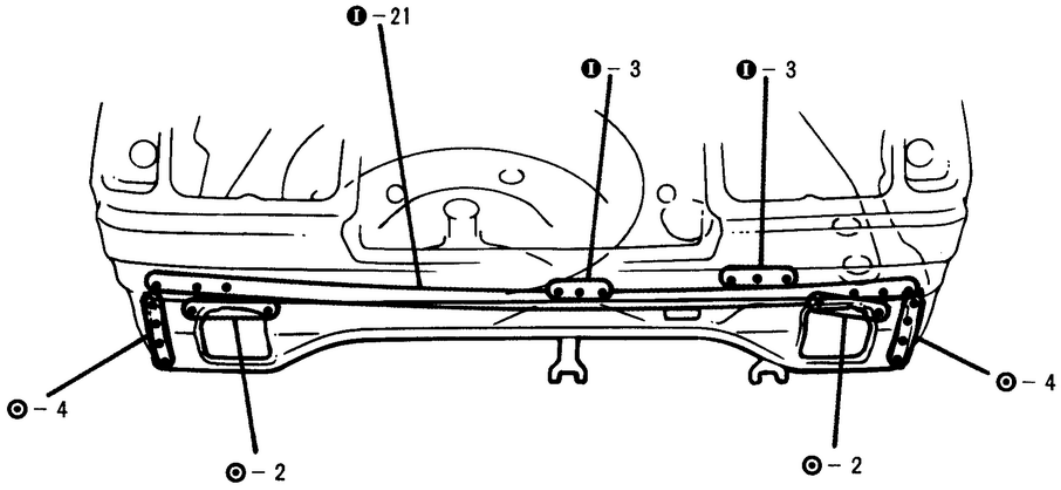
1. Temporarily install the new part. Then temporarily install the rear combination light and back door, and check the fit.

3500B, D REAR VALANCE PANEL (ASSY)

Coupe

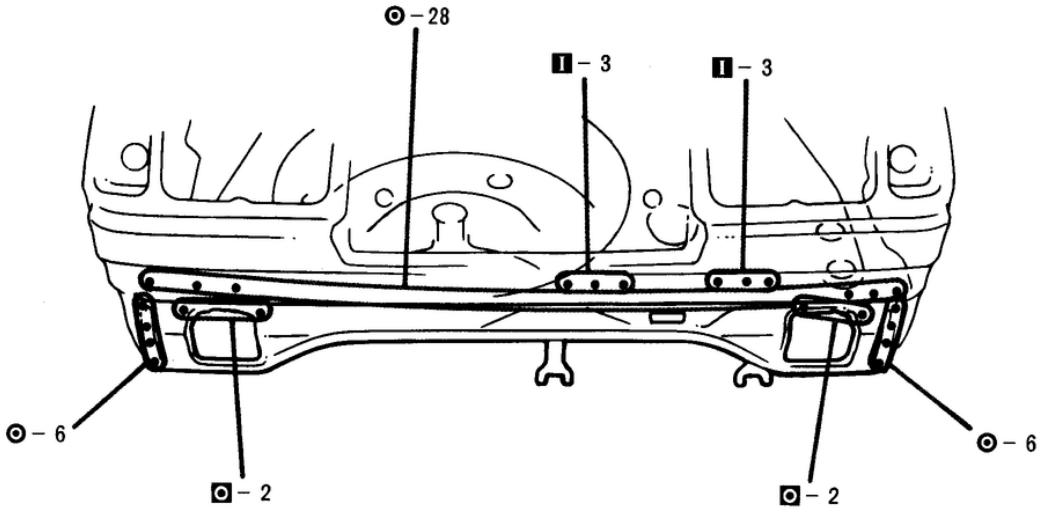


REMOVAL



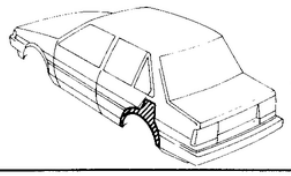
1. Leave the fuel tank bracket on the vehicle side if it is not damaged.

INSTALLATION

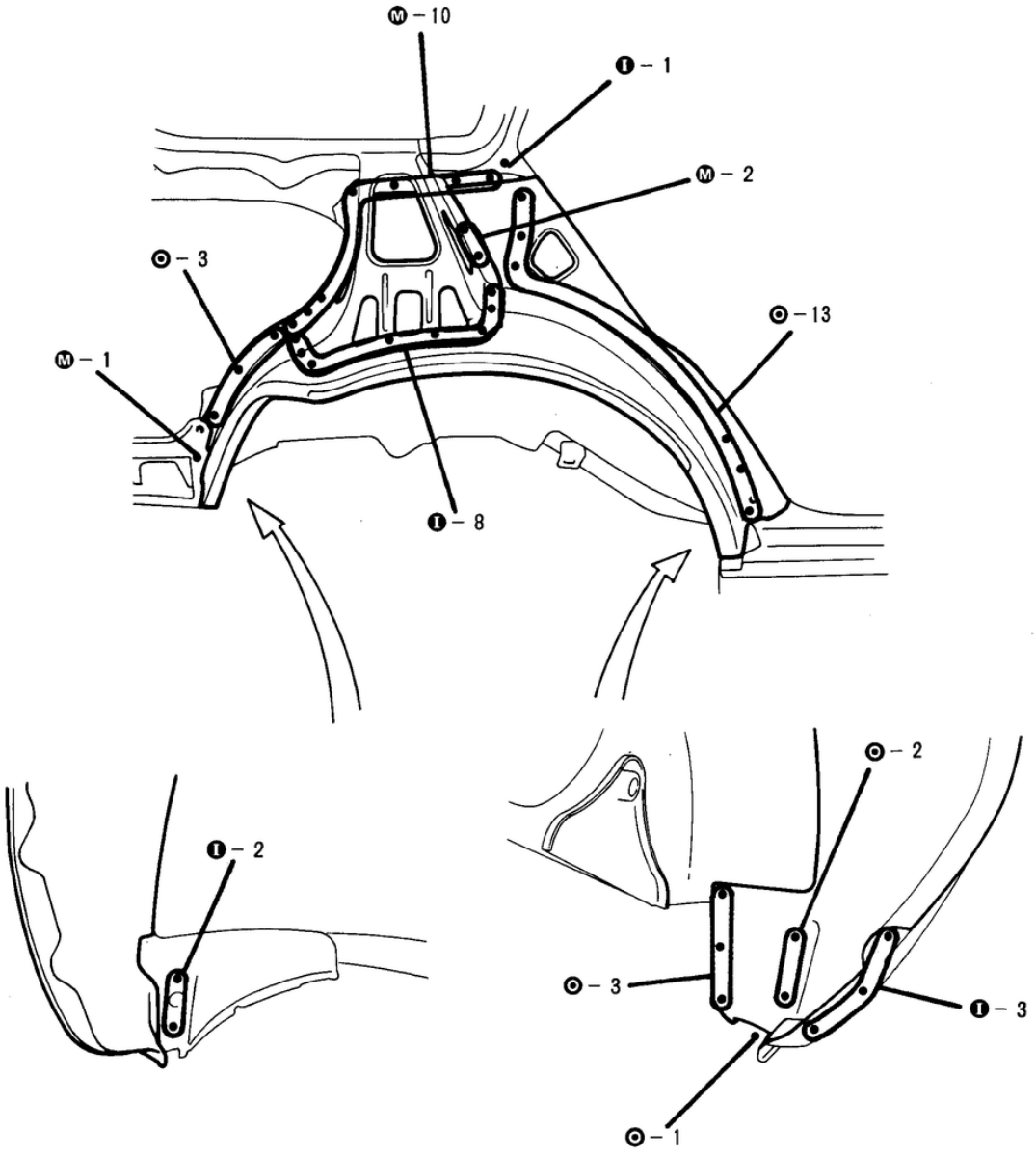


3700A, C QUARTER WHEEL HOUSING OUTER PANEL (ASSY)

Sedan, Liftback

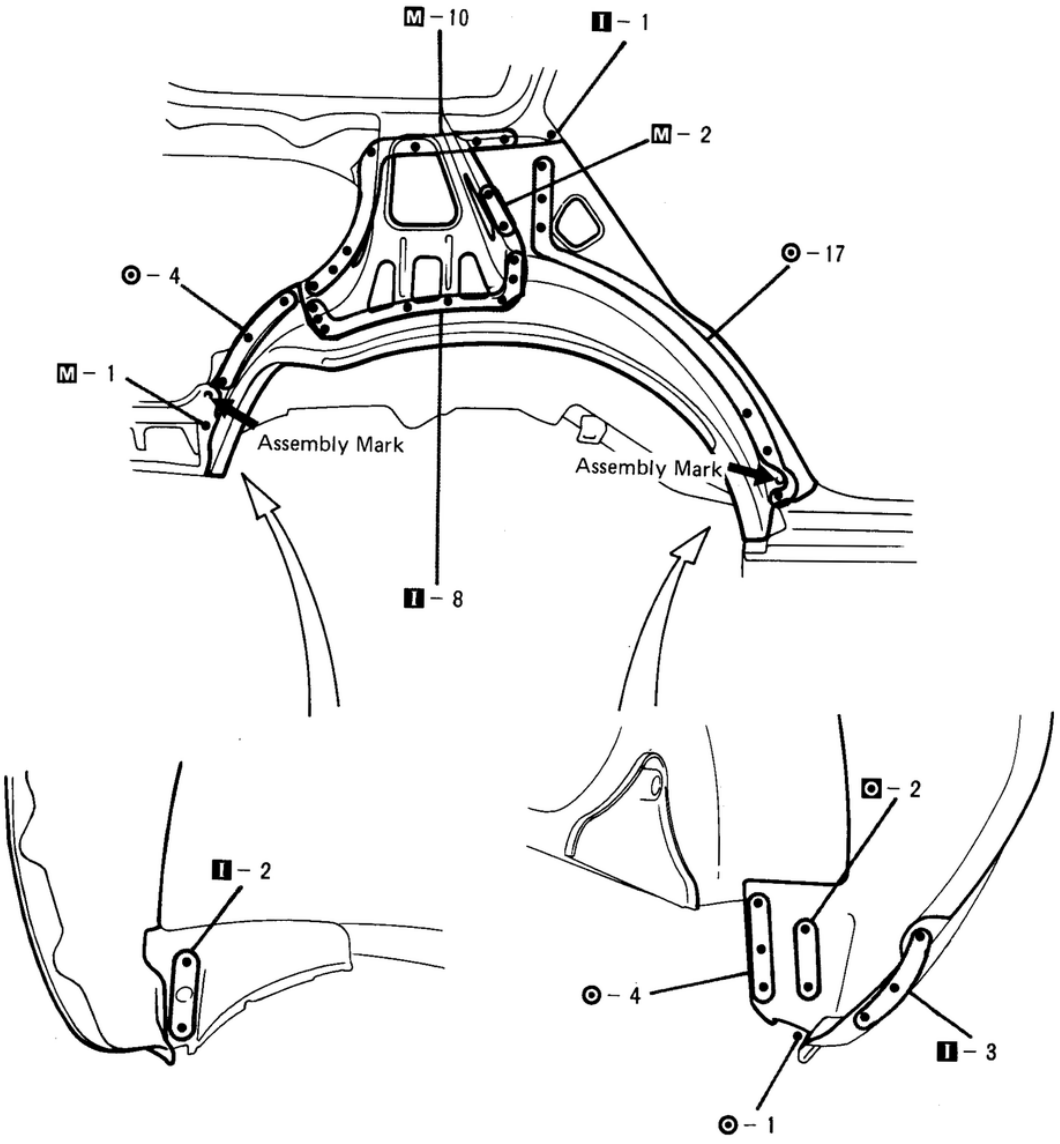


REMOVAL



1. First remove the quarter panel, and then remove the quarter wheel housing outer panel.

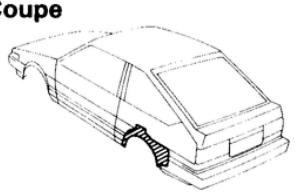
INSTALLATION



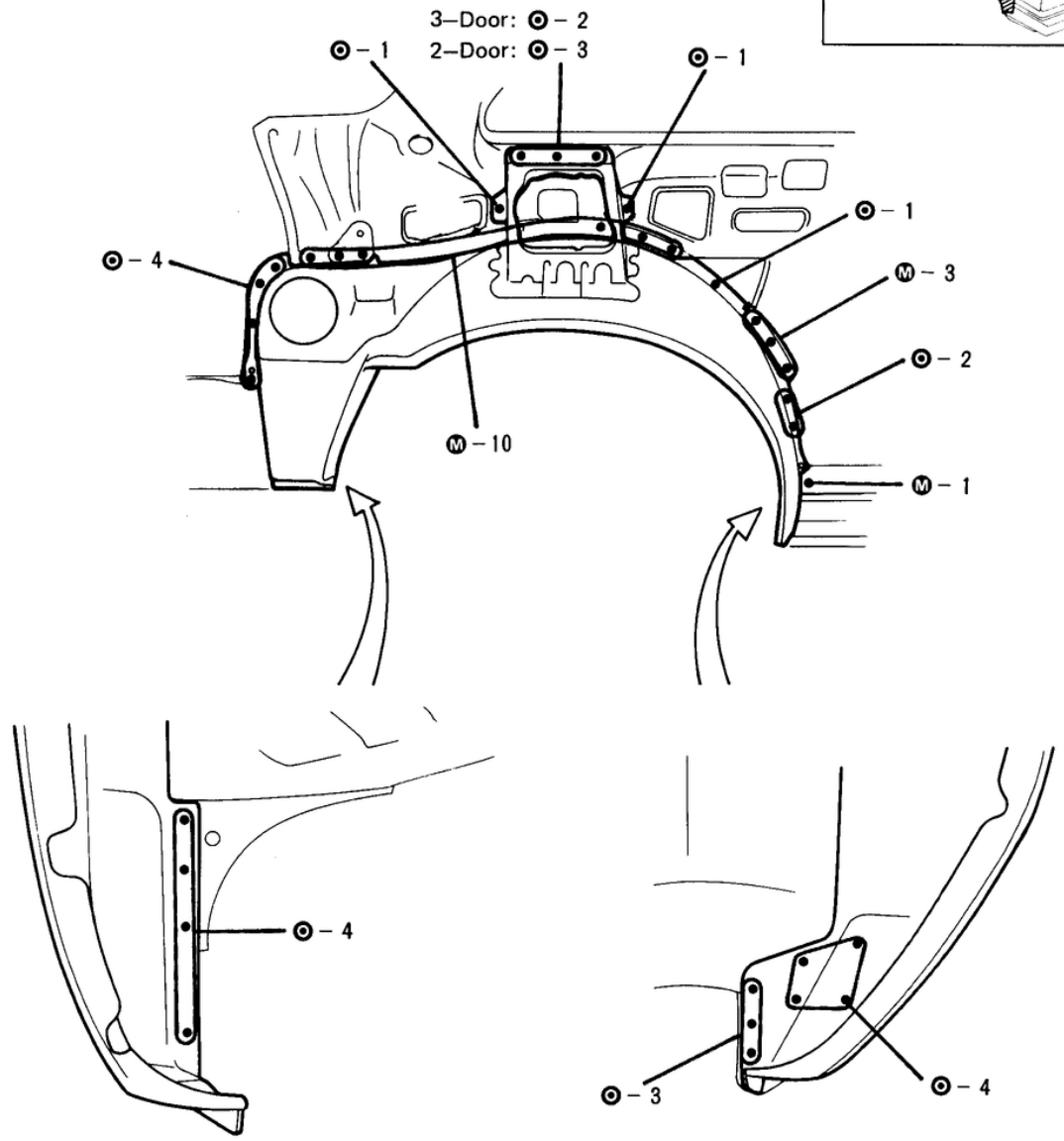
1. Determine the position for the new part by the standard hole of the outer and inner panels.
2. Before welding, temporarily install the quarter panel, and check the fit.

3700B, D QUATRTER WHEEL HOUSING OUTER PANEL (ASSY)

Coupe

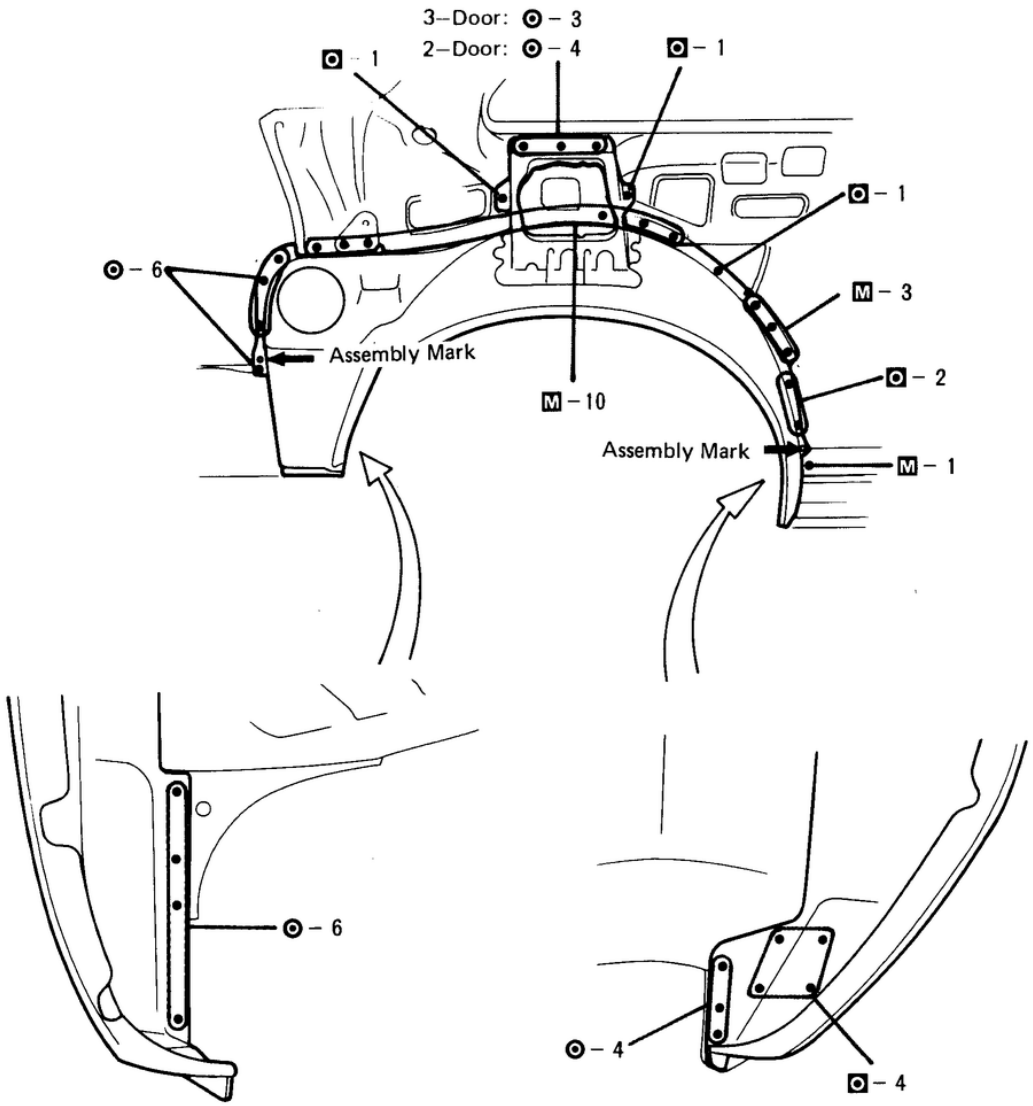


REMOVAL



1. First remove the quarter panel, and then remove the quarter wheel housing outer panel.

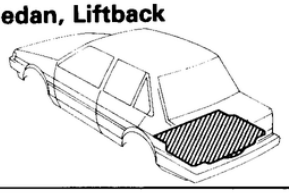
INSTALLATION



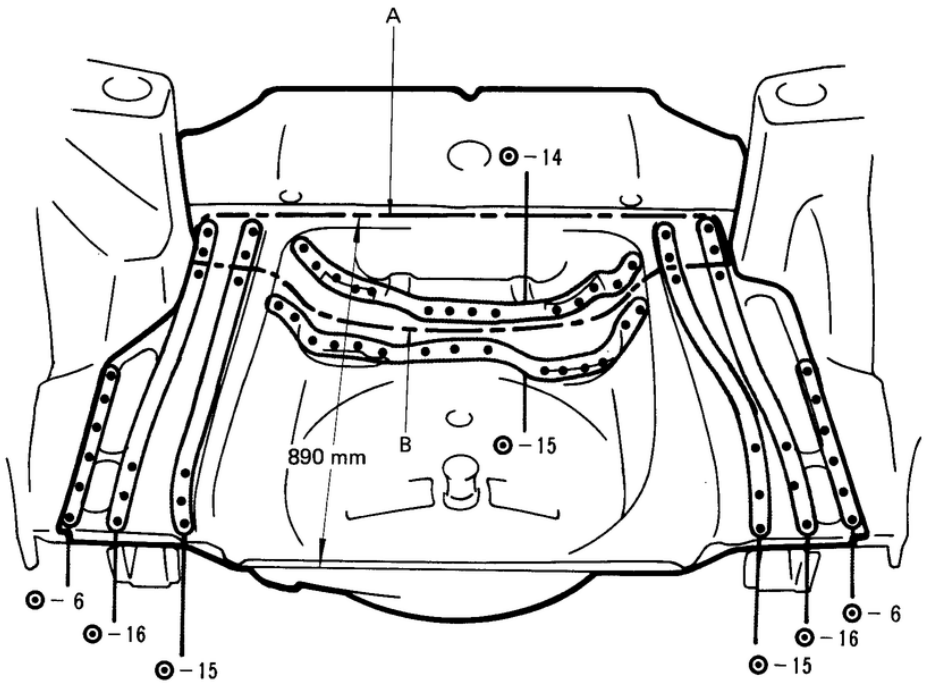
1. Determine the position for the new part by the standard hole of the outer and inner panels.
2. Before welding, temporarily install the quarter panel, and check the fit.

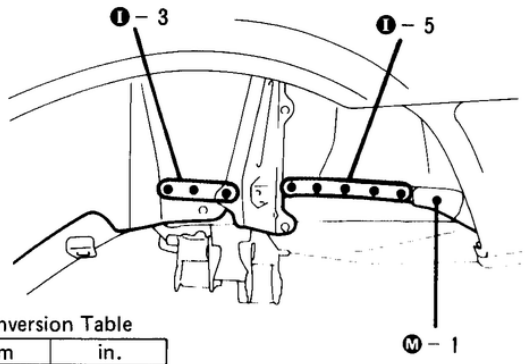
4110A, C REAR FLOOR PAN (CUT)

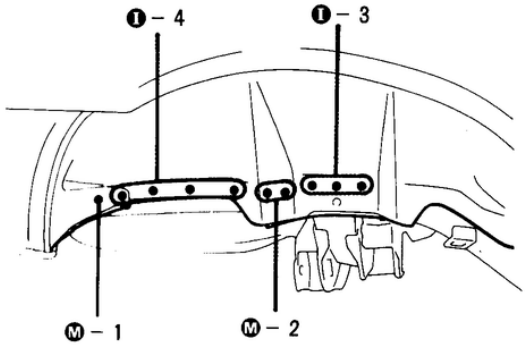
Sedan, Liftback



REMOVAL







Conversion Table

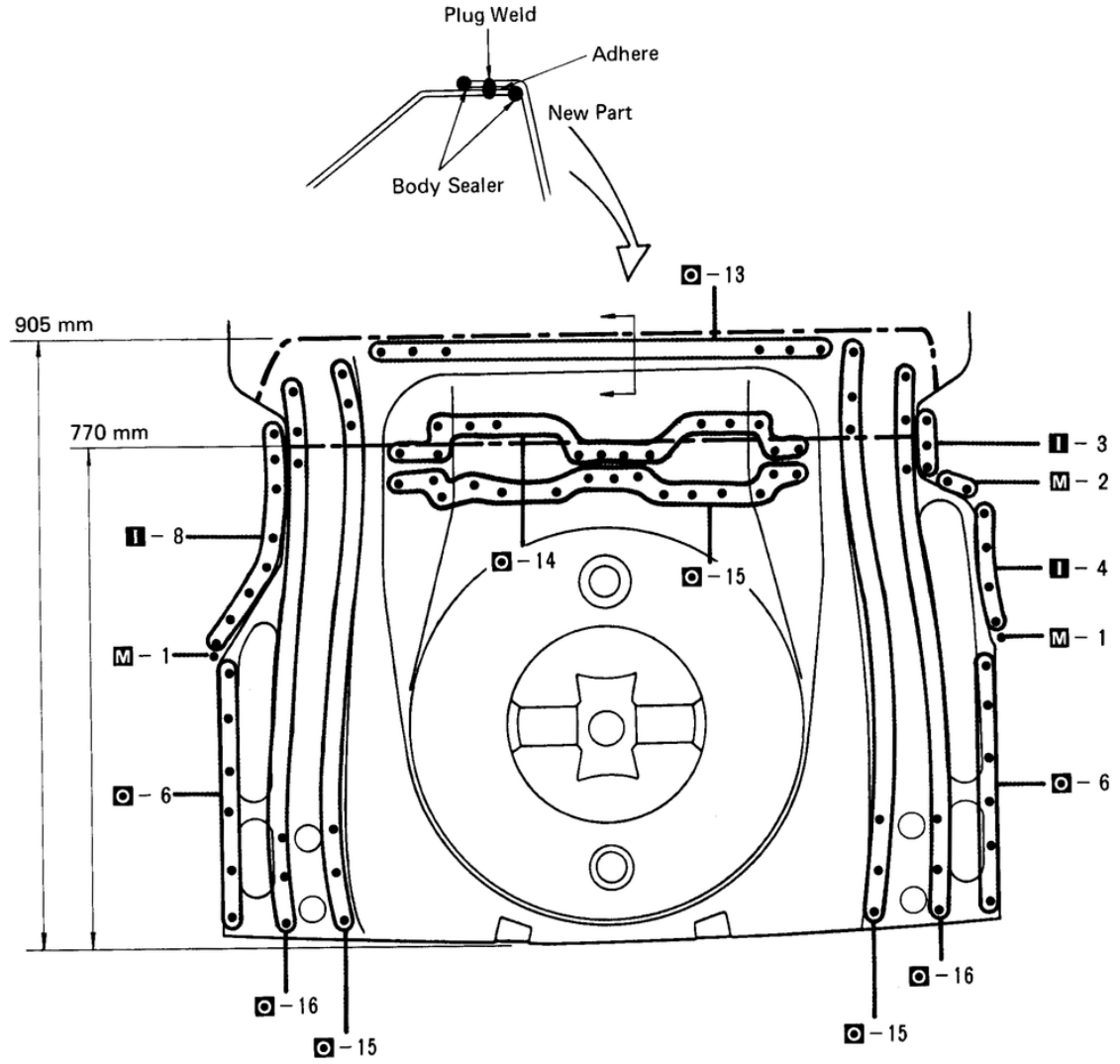
mm	in.
890	35.04

1. Cut and join at location A shown above.

Reference: Possible cut and join at location B.

2. Avoid the rear floor side member and center floor crossmember when rough cutting the rear floor panel.

INSTALLATION



Conversion Table

mm	in.
770	30.31
905	35.63

1. Cut the new part shown above.
2. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.
3. Plug weld at the overlap portion.

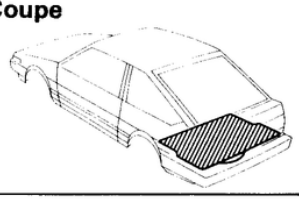
NOTE: Be sure adhere the welding points.

4. Apply body sealer from both sides.

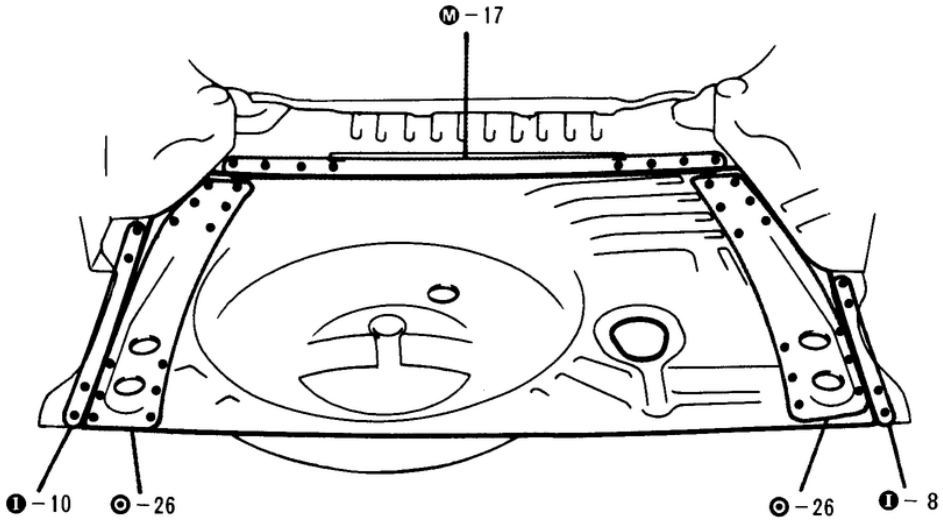
Reference: If cutting and joining at location B, apply body sealer from inside the vehicle.

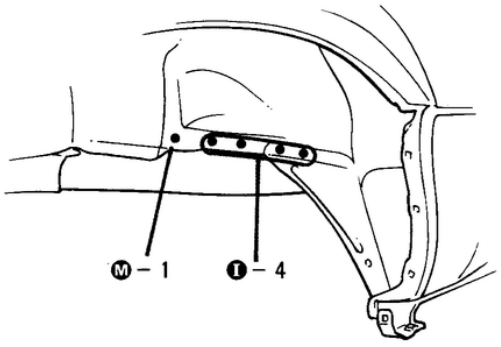
4100B, D	REAR FLOOR PAN (ASSY)

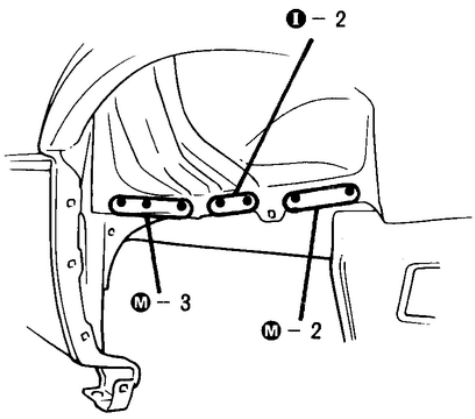
Coupe



REMOVAL

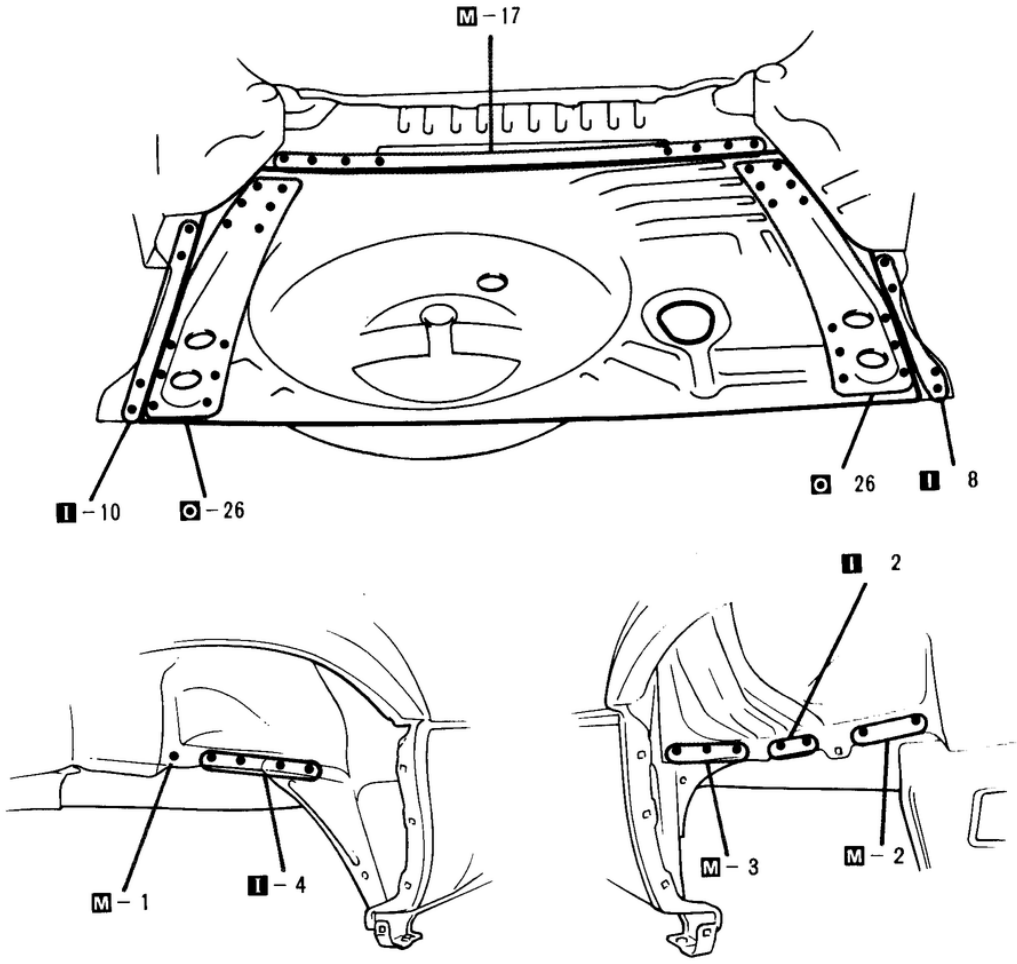






1. Avoid the rear floor side member and center floor crossmember when rough cutting the rear floor panel.

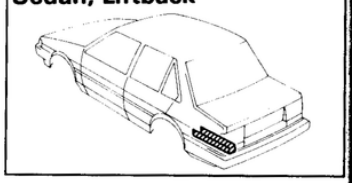
INSTALLATION



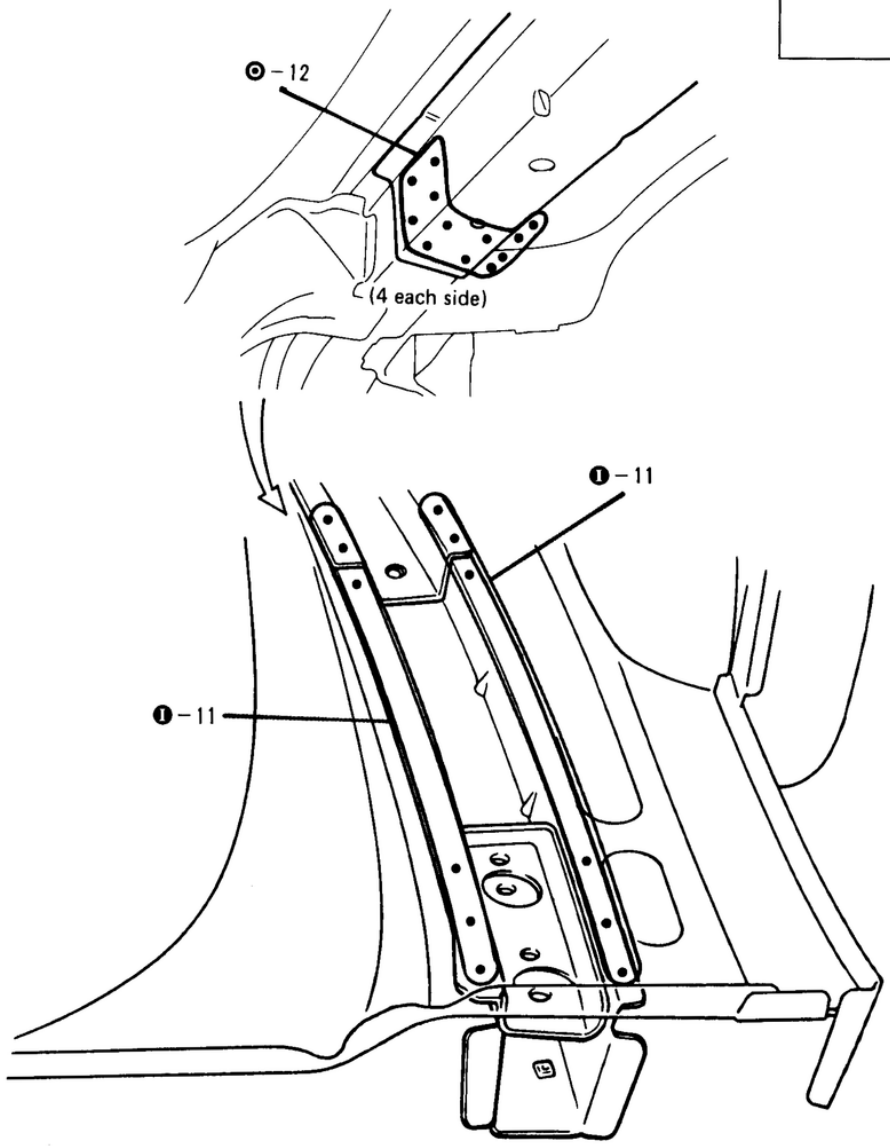
1. Temporarily install the new parts and measure each part in accordance with the body dimension diagram.

4200A, C REAR FLOOR REAR SIDE MEMBER (ASSY)

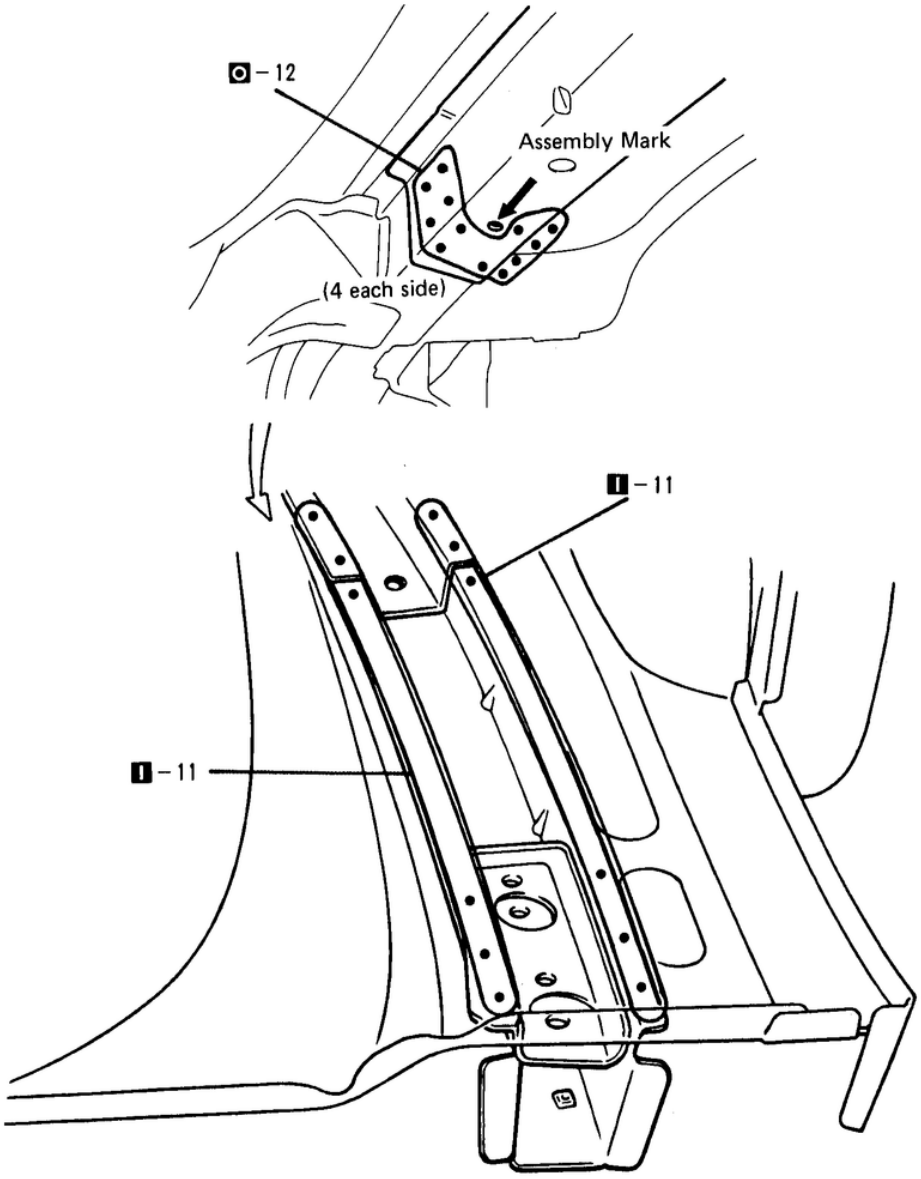
Sedan, Liftback



REMOVAL



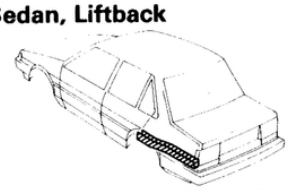
INSTALLATION



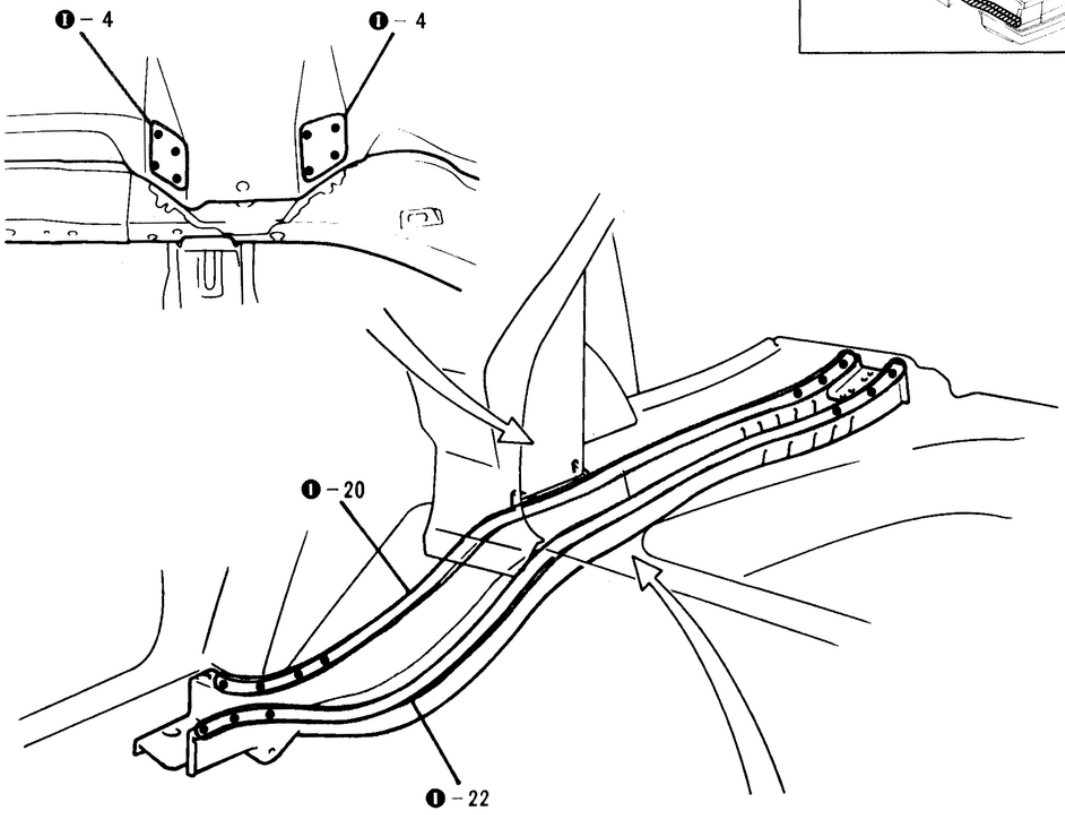
1. Align the new parts with the standard marks and temporarily install them.
2. Measure each part in accordance with the body dimension diagram.

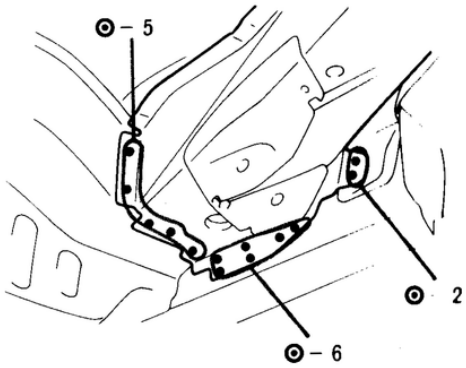
4300A, C REAR FLOOR SIDE MEMBER (ASSY)

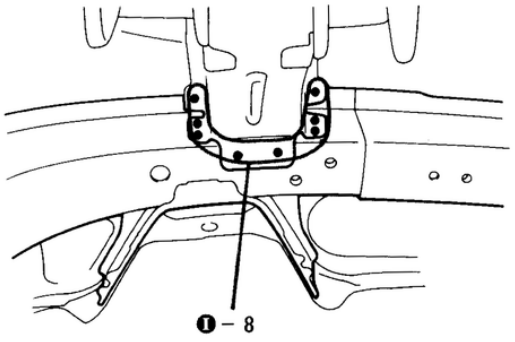
Sedan, Liftback



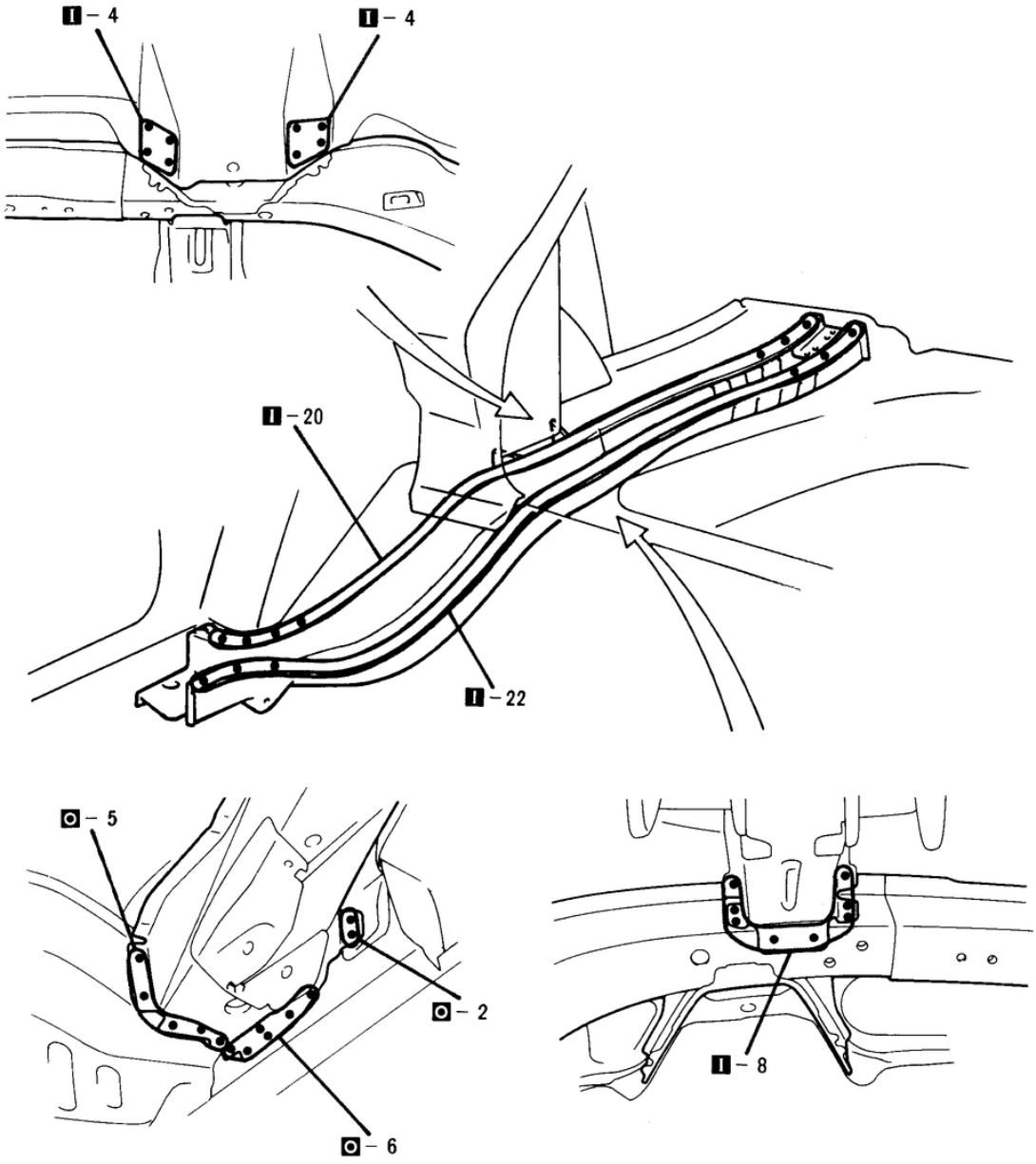
REMOVAL







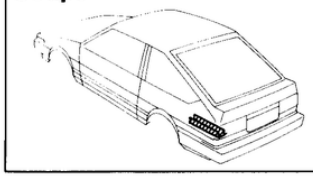
INSTALLATION



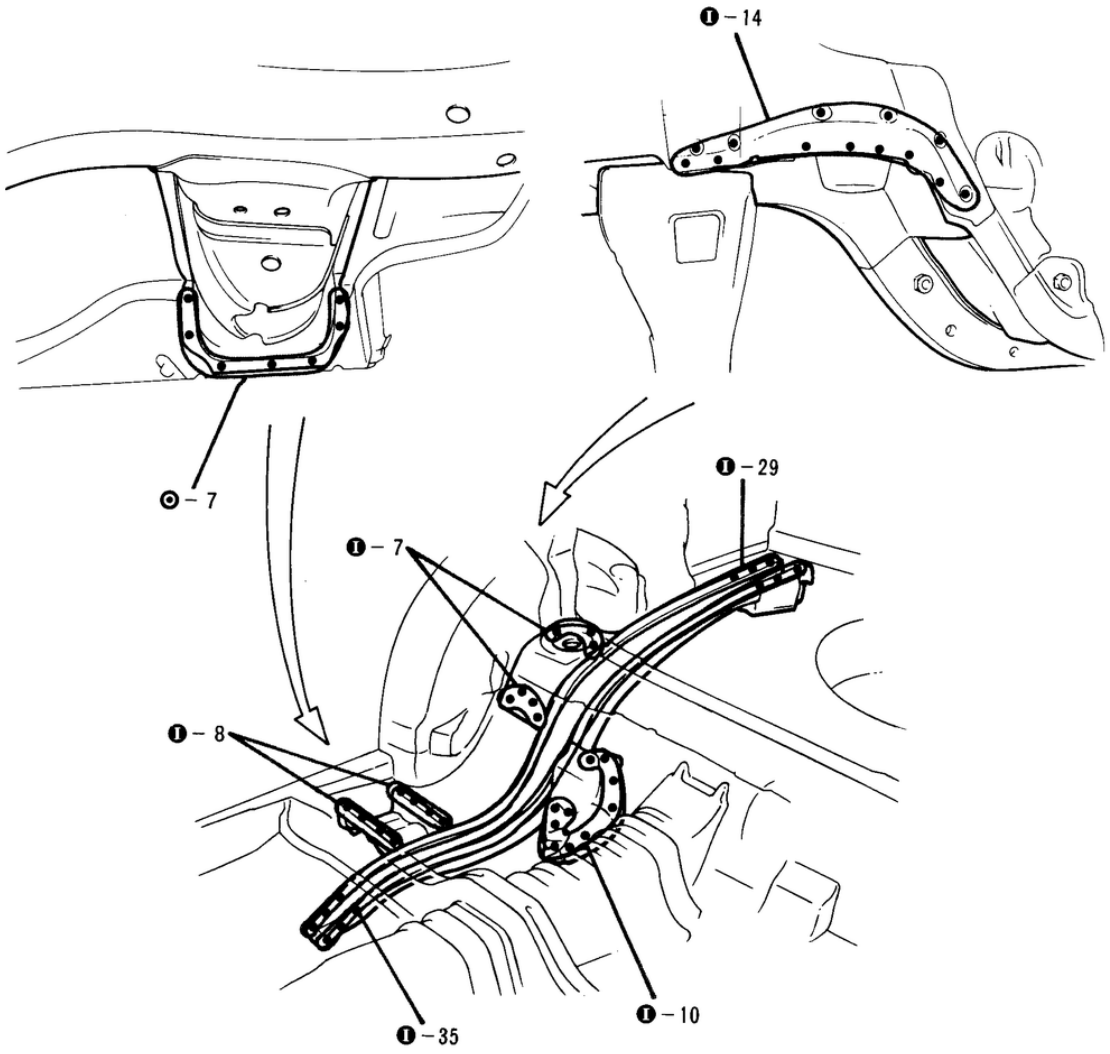
1. Temporarily install the new part, and measure each part in accordance with the body dimension diagram.

4300B, D REAR FLOOR SIDE MEMBER (ASSY)

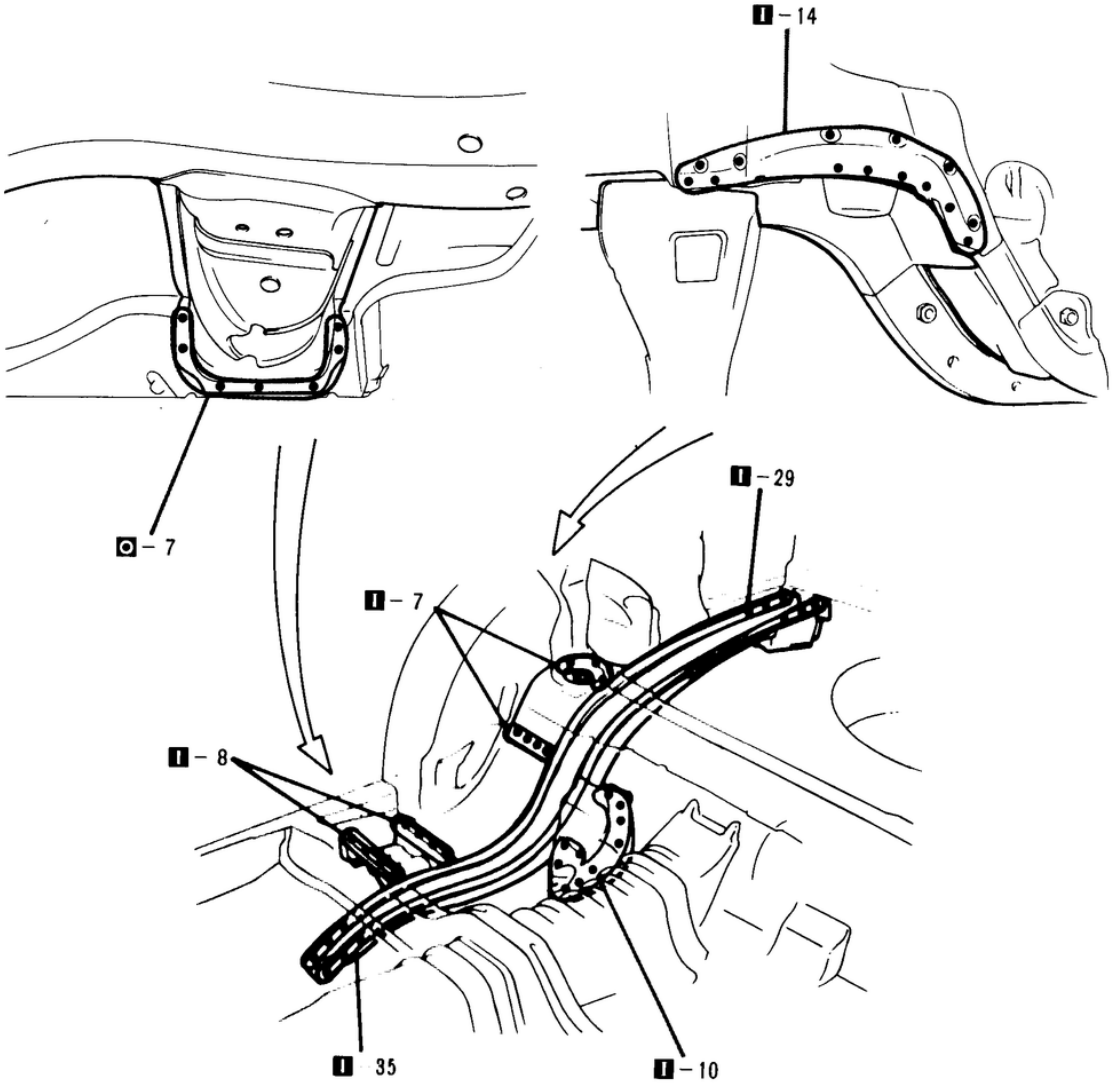
Coupe



REMOVAL



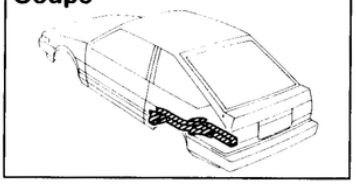
INSTALLATION



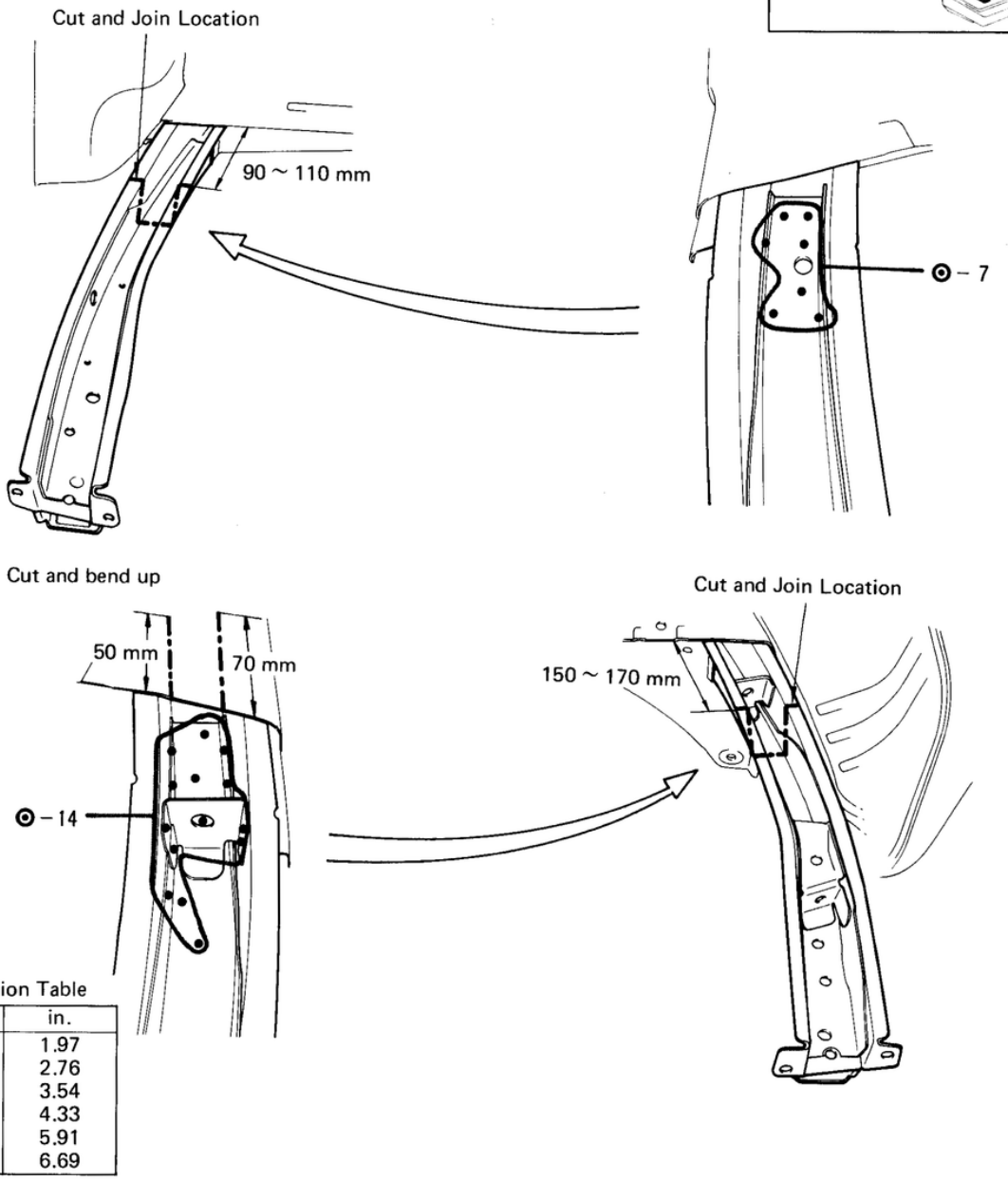
1. Temporarily install the new part, and measure each part in accordance with the body dimension diagram.

4310B, D REAR FLOOR SIDE MEMBER (CUT)

Coupe



REMOVAL



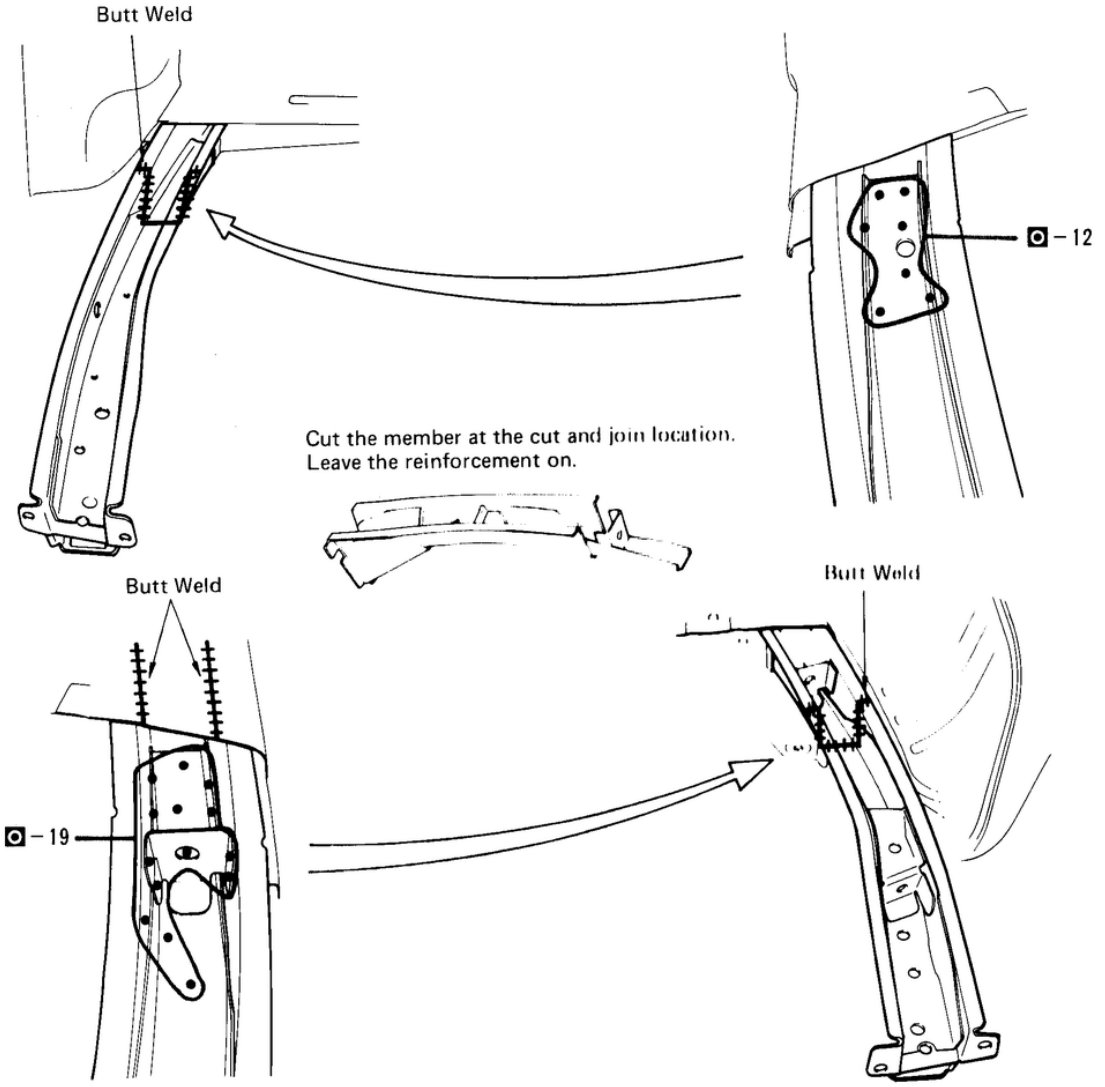
Conversion Table

mm	in.
50	1.97
70	2.76
90	3.54
110	4.33
150	5.91
170	6.69

1. Remove the body lower back panel rear balance panel and rear floor pan.
2. Cut off the rear floor side member at the places shown in the diagram and then remove the reinforcement remaining on the body side.

NOTE: To spot weld the right side member reinforcement, cut the center floor pan and bend it upward.

INSTALLATION



1. When cutting and joining the new part, align with the removed panel.

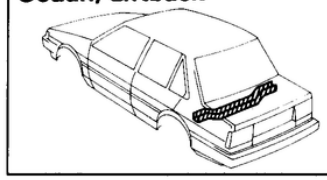
NOTE: Cut and join on the outside only to avoid damage to the reinforcement.

2. Temporarily install the new parts, and measure each part in accordance with the body dimension diagram.
3. Butt weld the cut portion of the center floor pan.

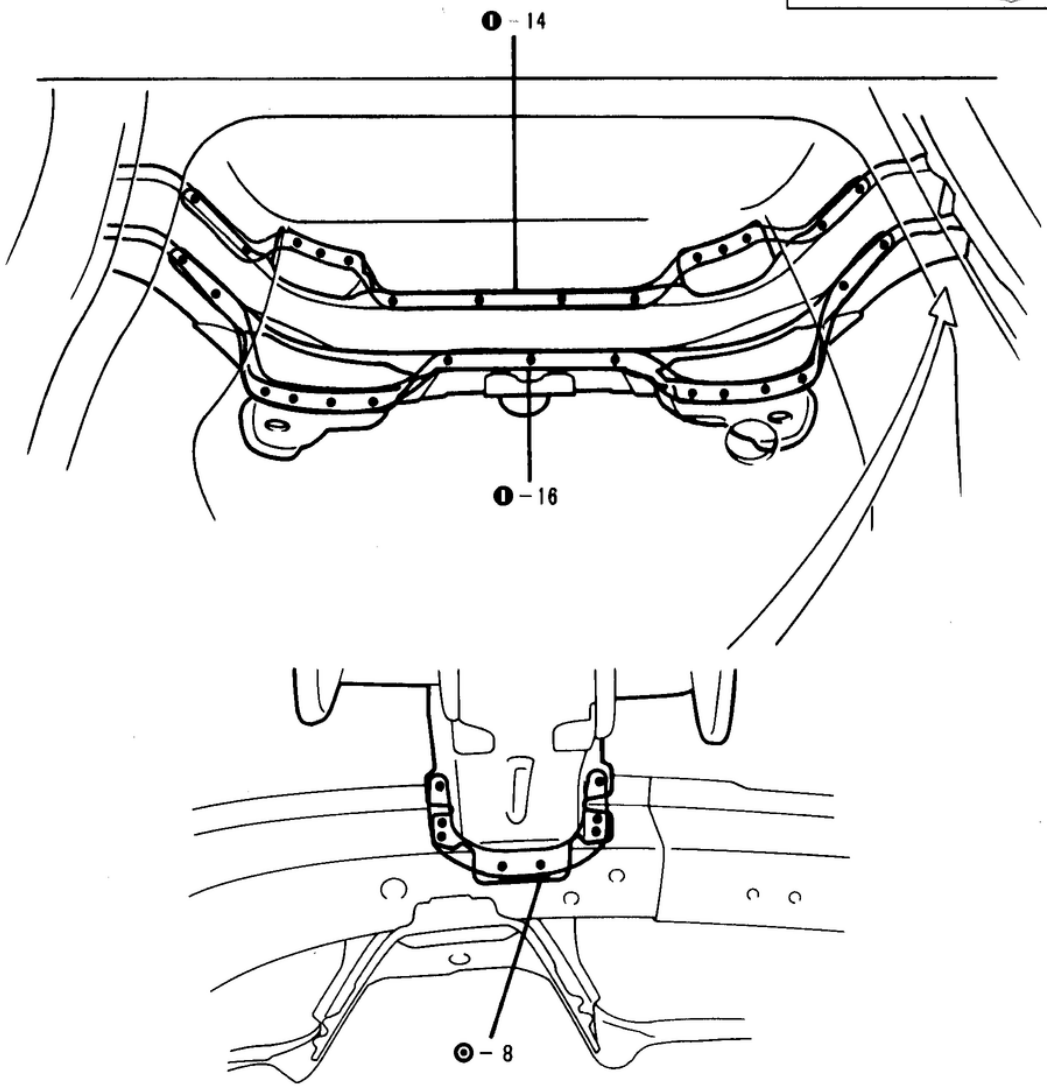
Reference: Do this before installing the rear floor panel.

4600A, C	REAR FLOOR CROSSMEMBER NO.2 (ASSY)

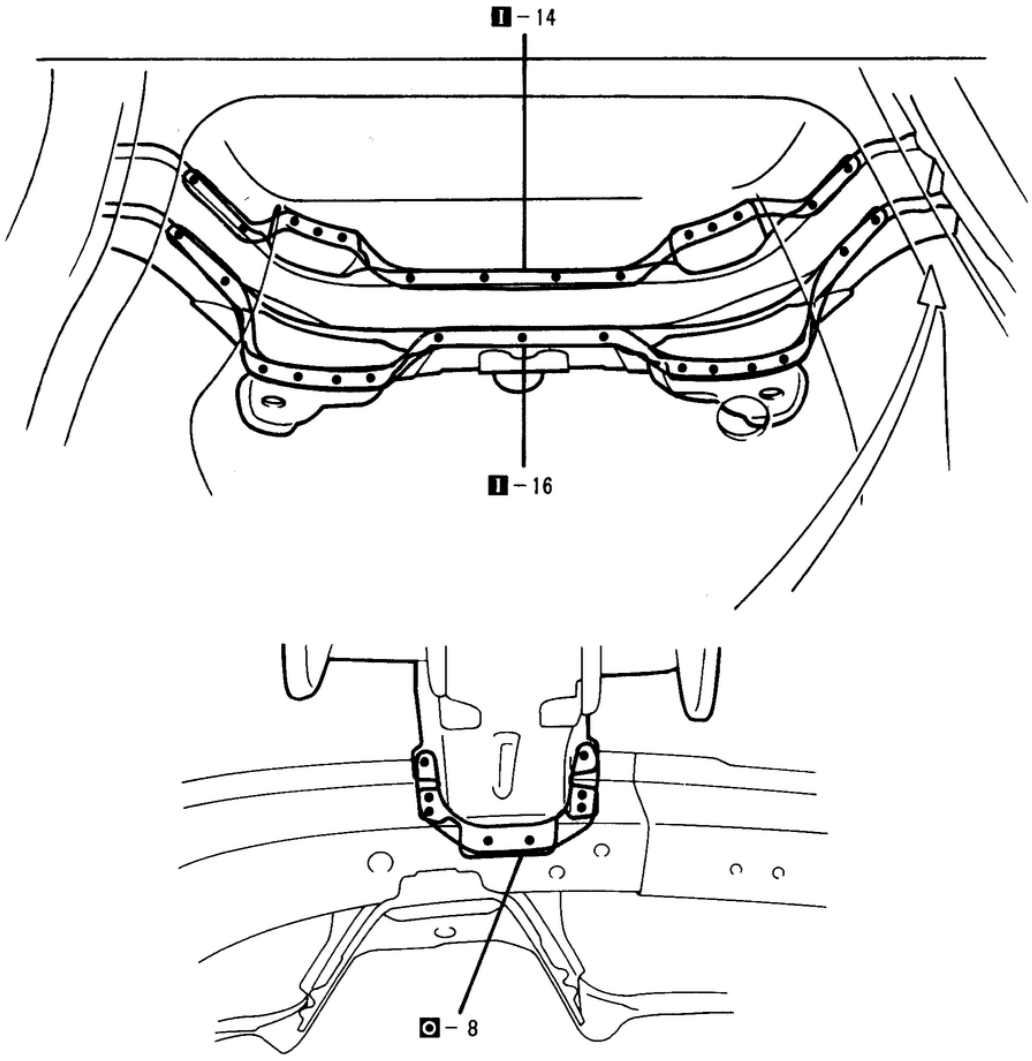
Sedan, Liftback



REMOVAL



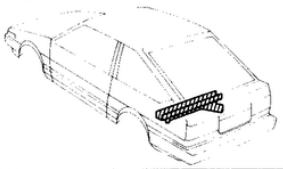
INSTALLATION



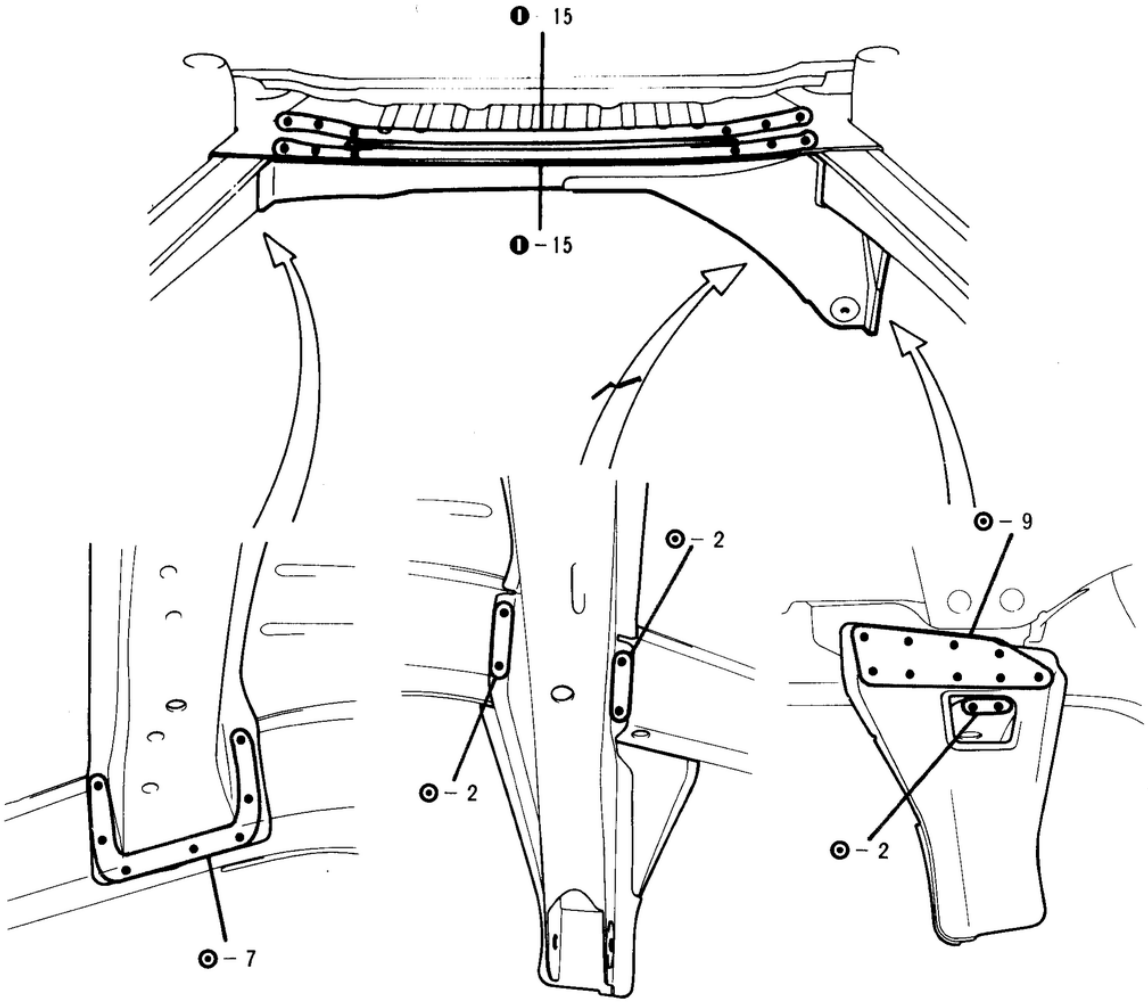
1. Be sure to install these parts correctly in accordance with the body dimensions as they have effect on rear wheel alignment.

4600B, D	REAR FLOOR CROSSMEMBER NO.2 (ASSY)

Coupe

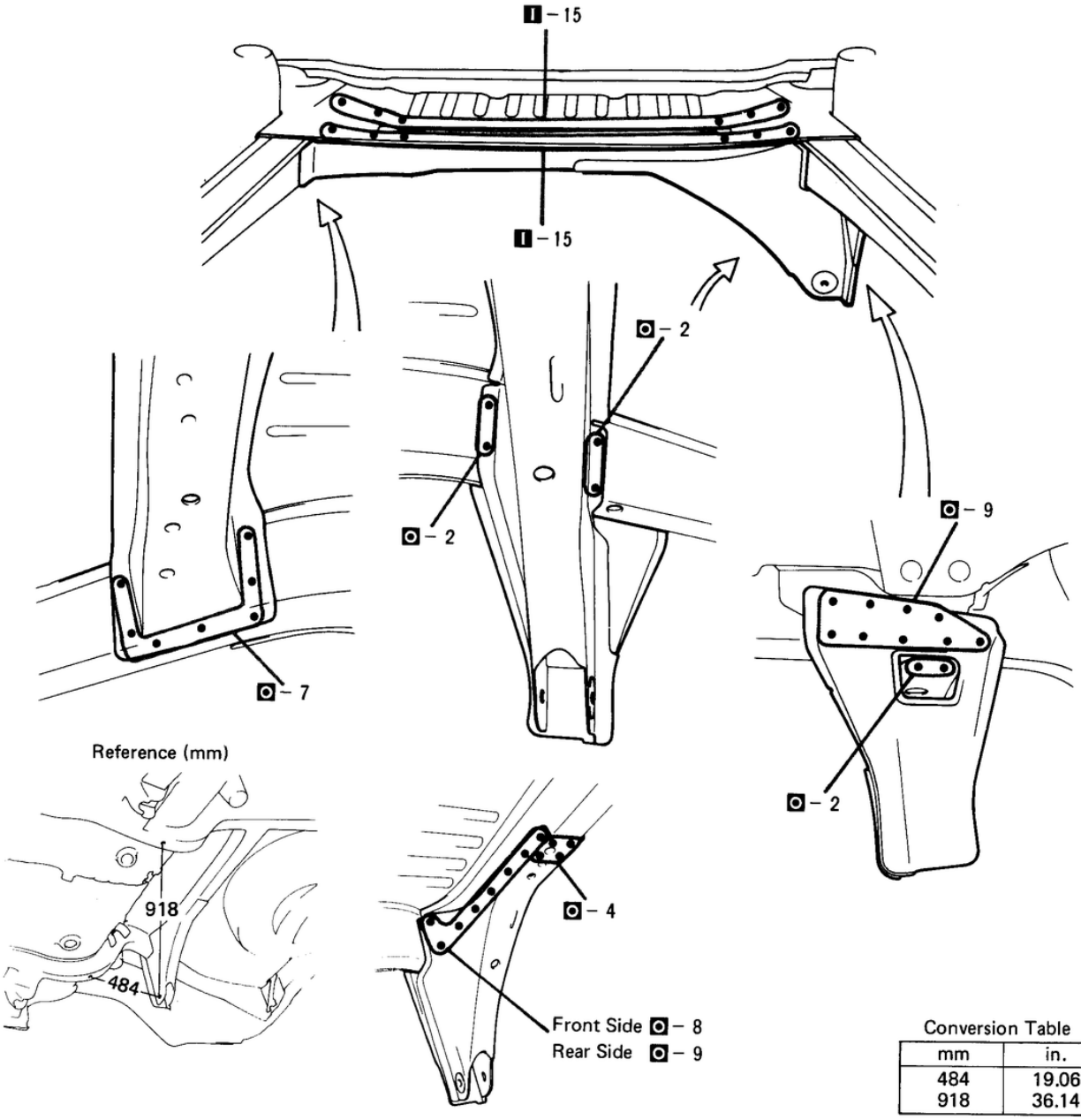


REMOVAL



1. To spot weld the rear floor side member lower side, rough cut and separate the lateral rod bracket (right side only).

INSTALLATION



Conversion Table

mm	in.
484	19.06
918	36.14

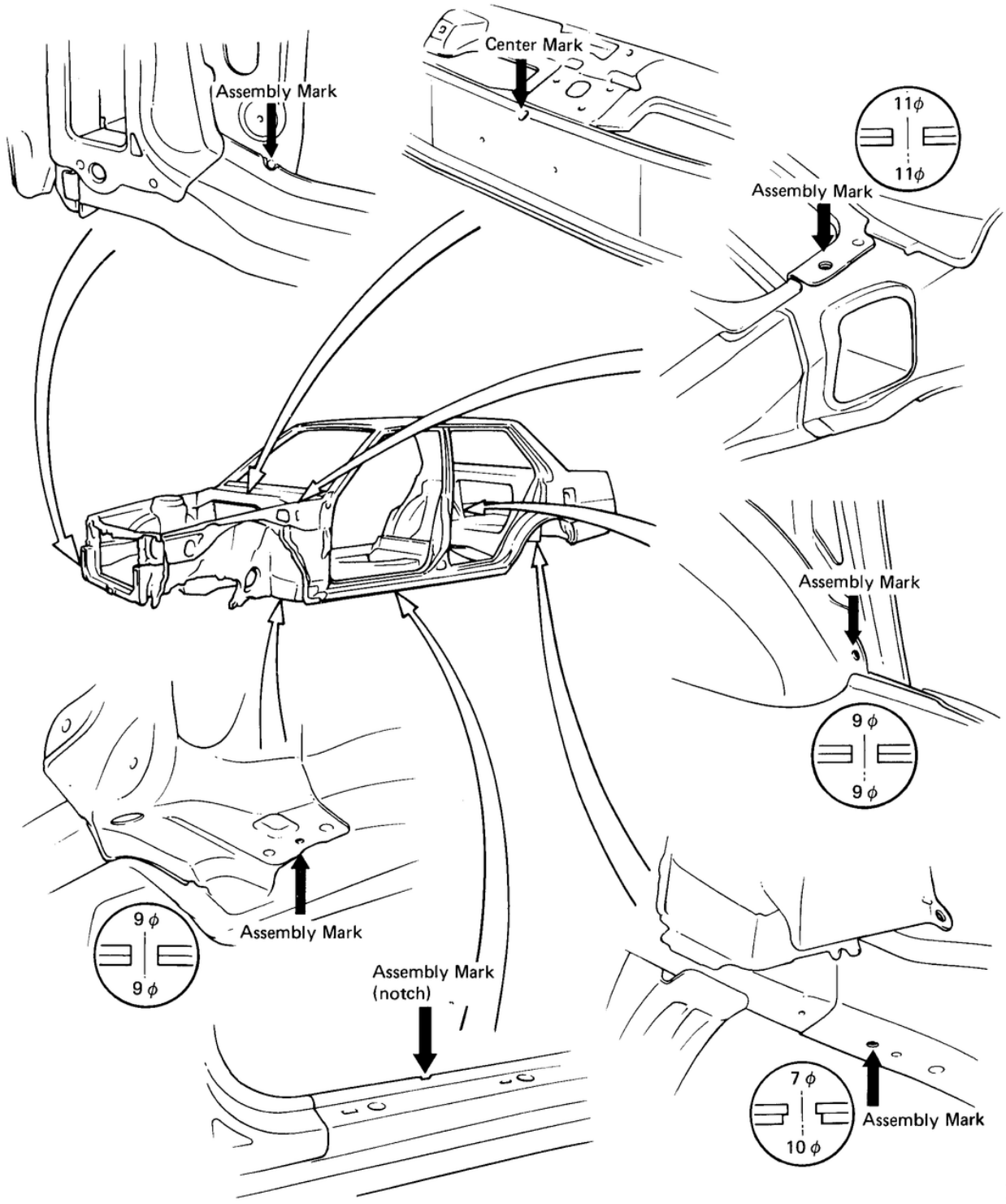
– MEMO –

BODY PANEL CONSTRUCTION

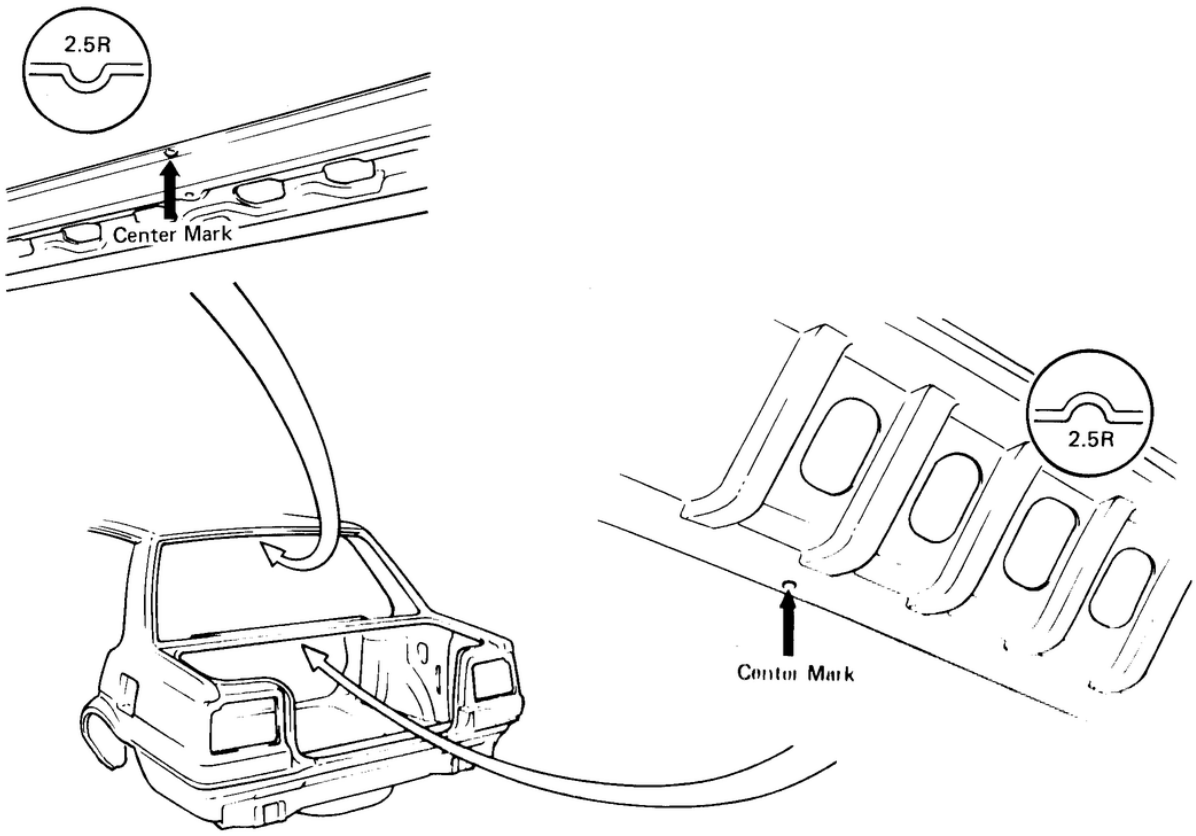
	Page
STANDARD BODY MARKS	CN-2
HIGH STRENGTH STEEL PARTS	CN-6

STANDARD BODY MARKS

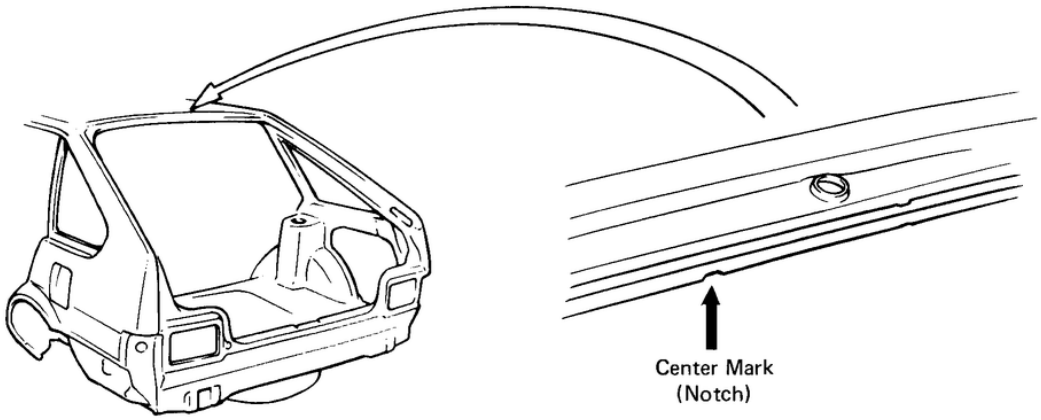
SEDAN AND LIFTBACK



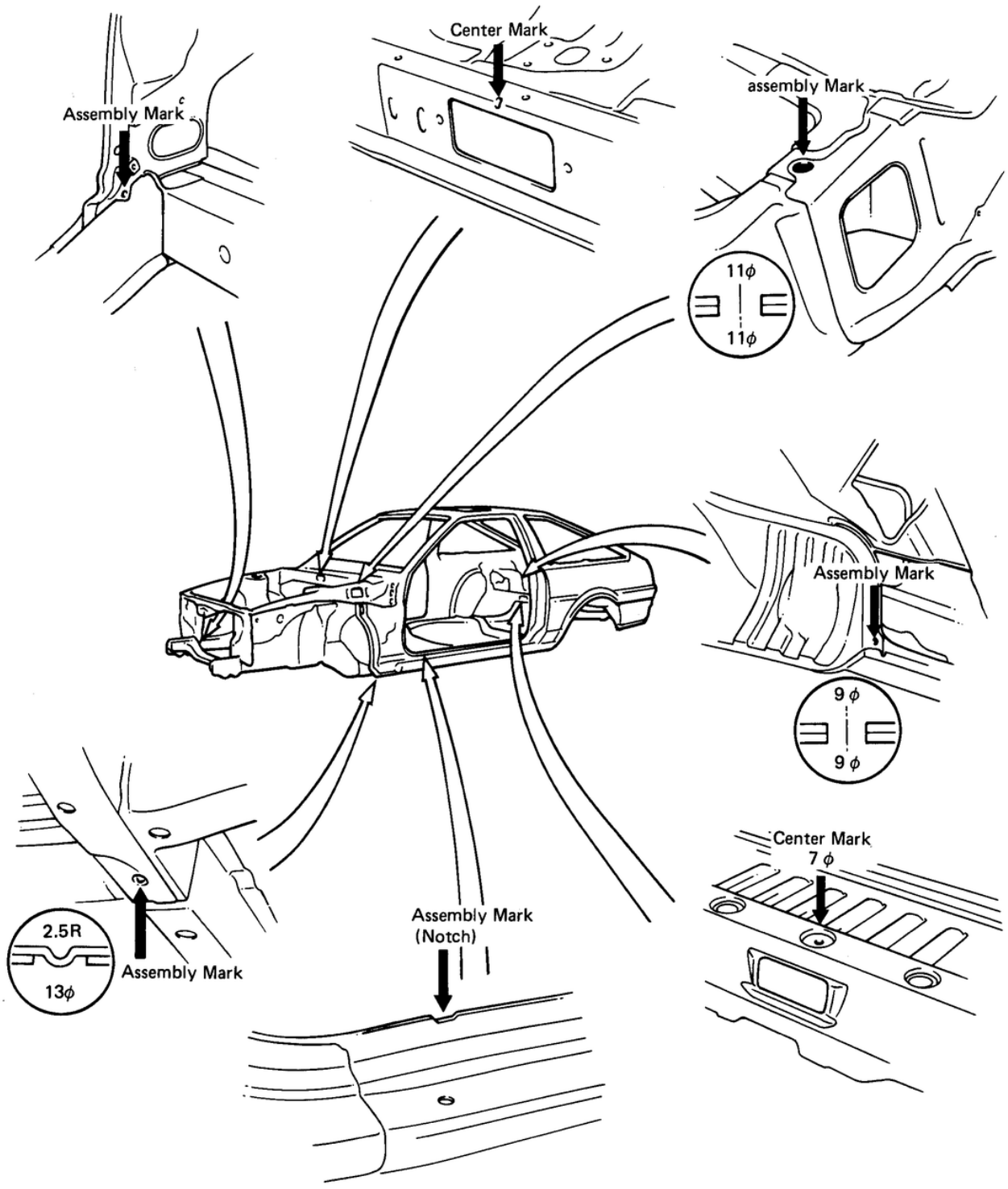
SEDAN



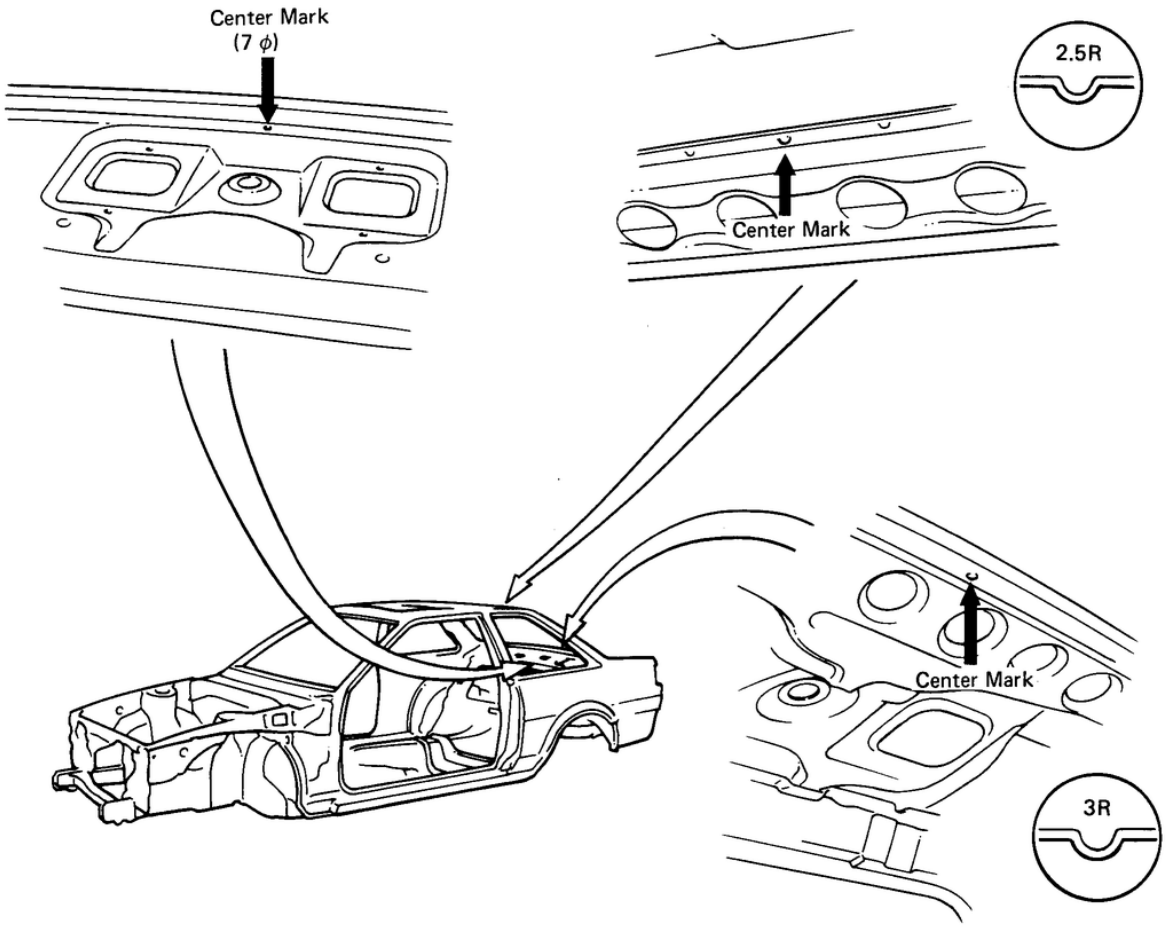
LIFTBACK



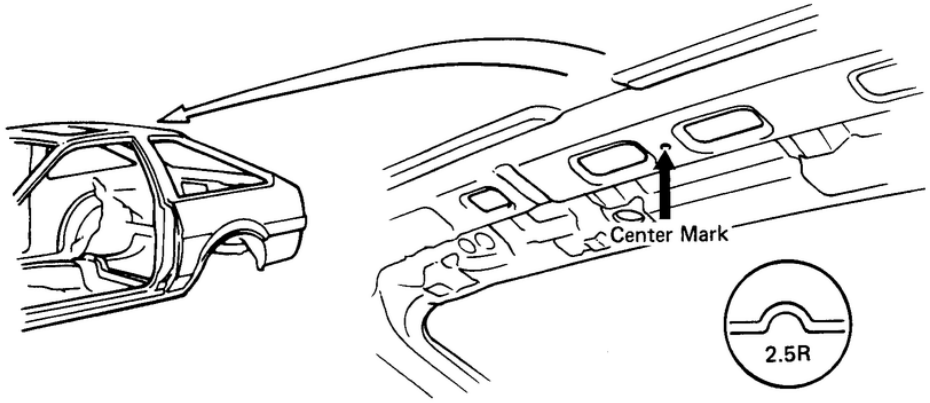
COUPE


Assembly Mark
Center Mark
assembly Mark
11ϕ
11ϕ
Assembly Mark
9ϕ
9ϕ
2.5R
13ϕ
Assembly Mark
Assembly Mark
(Notch)
Center Mark
7ϕ

2-DOOR COUPE



3-DOOR COUPE



HIGH STRENGTH STEEL (HSS) PARTS

Generally, High Strength Steel (HSS) is that which has an intensith value of at least 35 kg f/mm^2, and distinguished from mild steel.

The handling of HSS is the same as for mild steel, but the following should be observed.

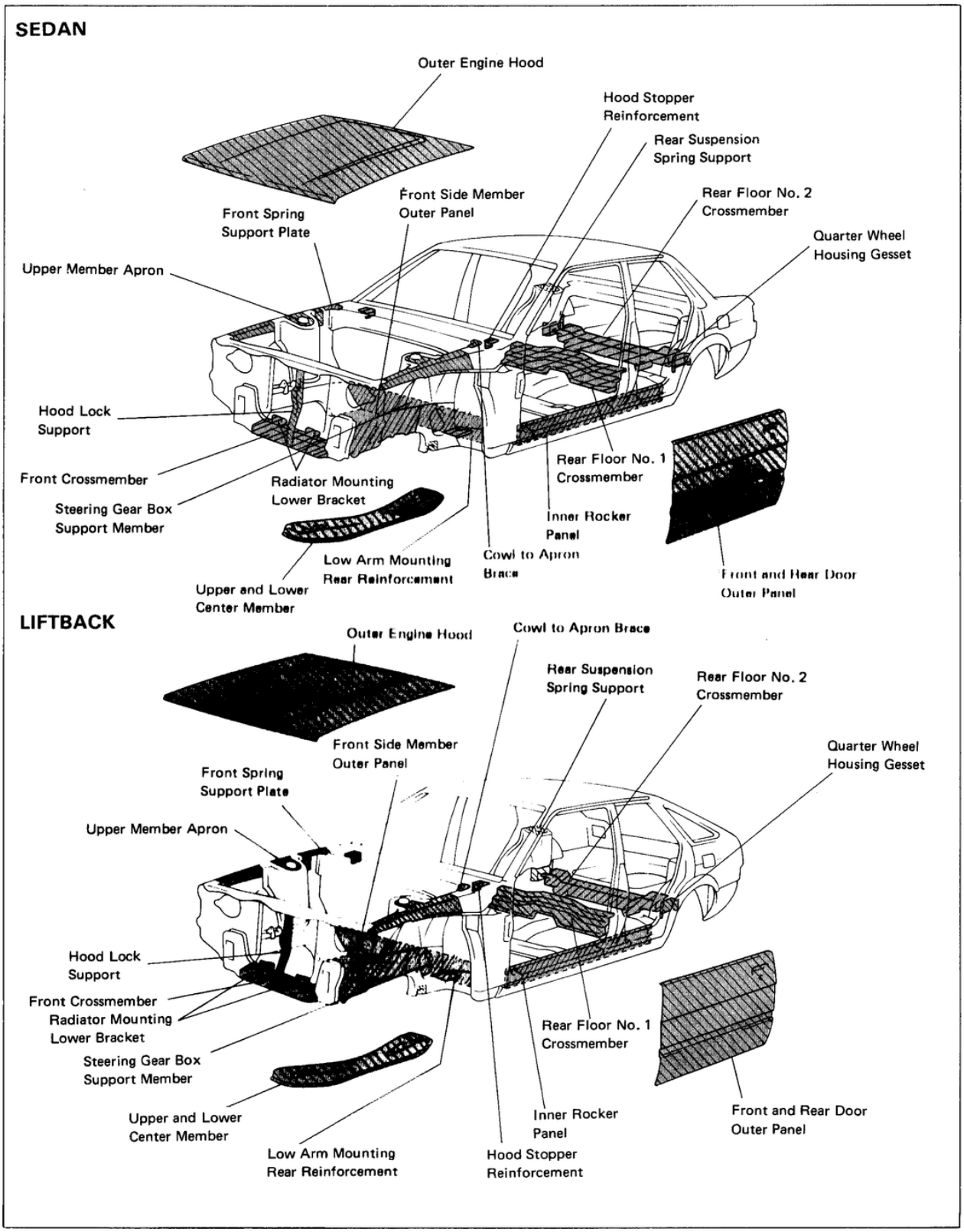
1. Panel Hammering
   Because HSS is thinner than mild steel, care should be taken to avoid warping during hammering operations.

2. Removing Spot Welds
   Because HSS is tougher than mild steel, damage will occur more easily to a regular drill. Therefore, as HSS Spot Cutter is recommended.
   Also, use a high-torque drill at low speed, and supply grinding oil to the drill during use.

3. Panel Welding
   Panel welding procedures for HSS are exactly the same as for mild steel.

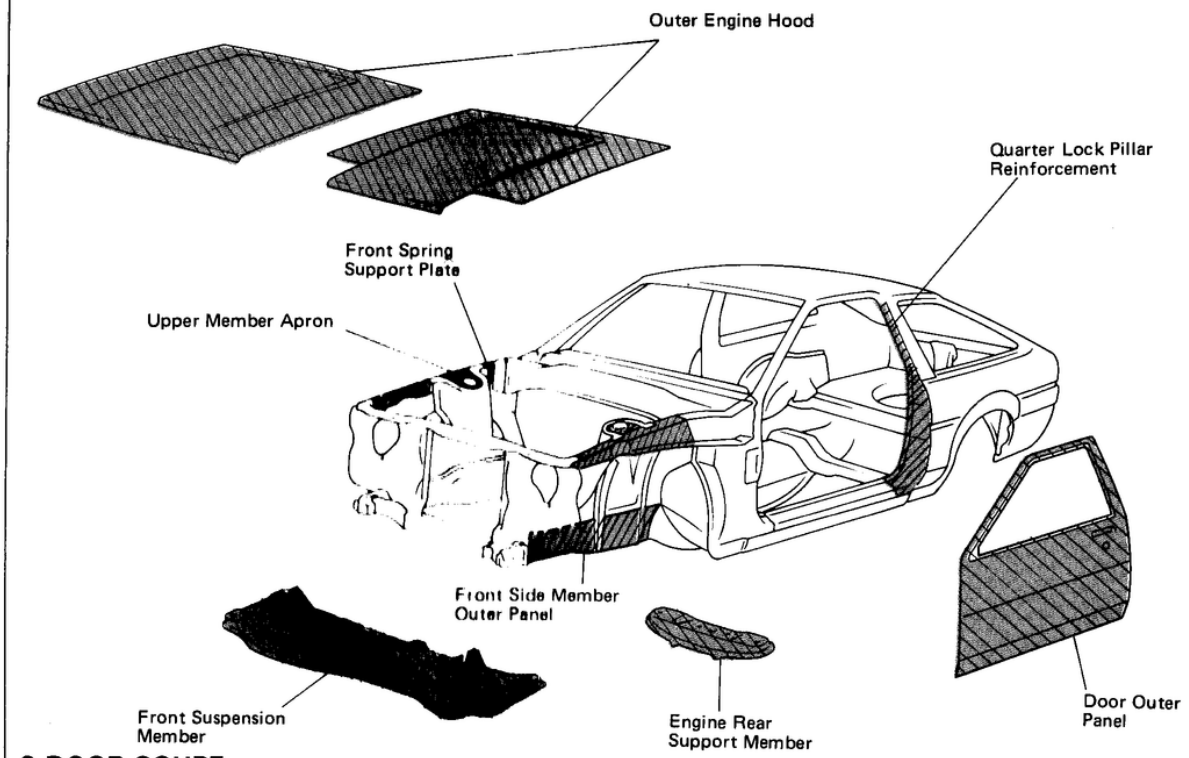
HIGH STRENGTH STEEL PARTS

Sedan and Liftback

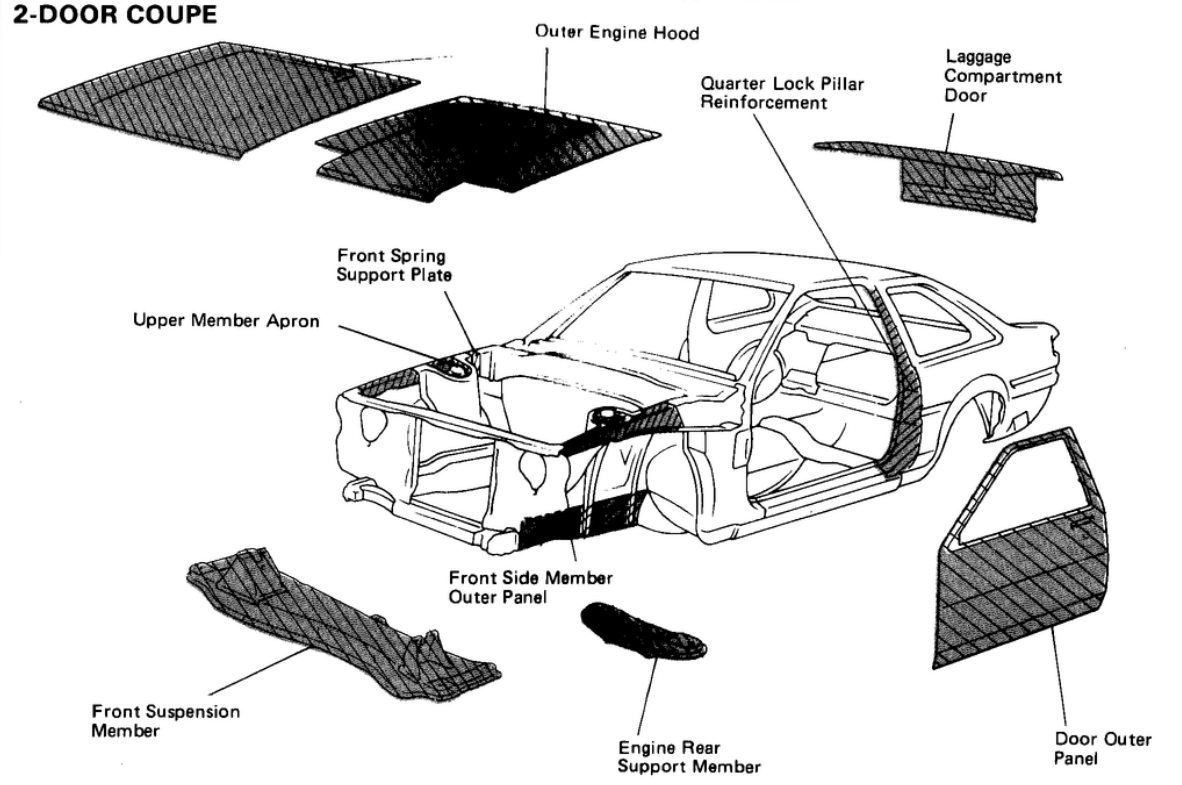


Coupe

3-DOOR COUPE



2-DOOR COUPE



PLASTIC BODY PARTS

	Page
HANDLING PRECAUTIONS	PP-2
LOCATION OF PLASTIC BODY PARTS	PP-4

PP

HANDLING PRECAUTIONS

1. The repair procedure for plastic body parts must conform with the type of plastic material.
2. Plastic body parts are identified by the codes in the following chart.
3. When repairing metal body parts adjoining plastic body parts (by brazing, frame cutting, welding, painting, etc.), consideration must given to the property of the plastic.

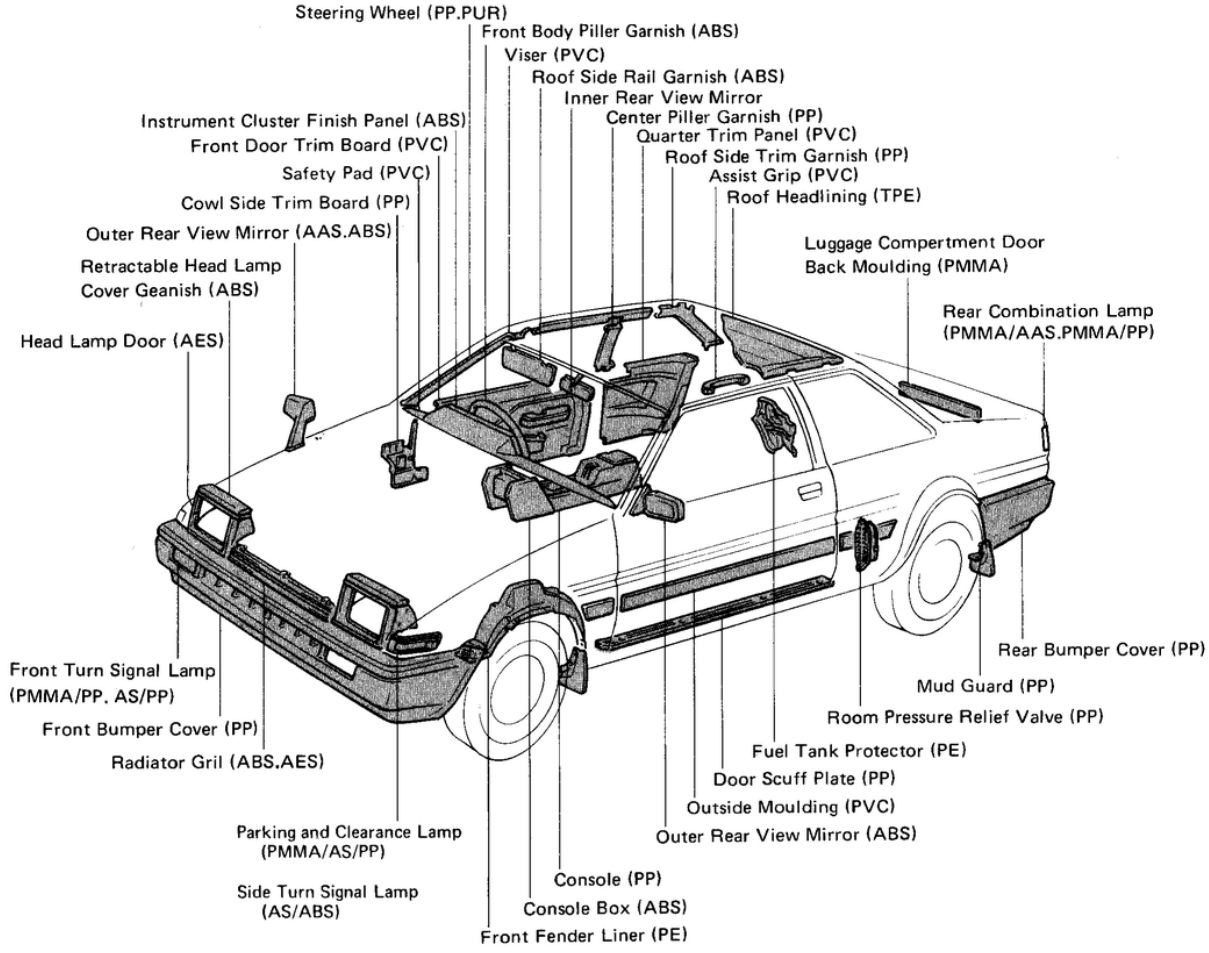
Code	Material Name	Heat * Resisting Temperature °C (°F)	Resistance To Alcohol or Gasoline	Notes
AAS	Acrylonitrile Acrylic Rubber Styrene Resin	80 (176)	Alcohol is harmless if applied only for short time in small amount (ex., quick wiping to remove grease).	Avoid gasoline and organic or aromatic solvents.
ABS	Acrylonitrile Butadian Styrene Resin	80 (176)	Alcohol is harmless if applied only for short time in small amount (ex., quick wiping to remove grease).	Avoid gasoline and organic or aromatic solvents.
AES	Acrylonitrile Ethylene Rubber Styrene Resin	80 (176)	Alcohol is harmless if applied only for short time in small amount (ex., quick wiping to remove grease).	Avoid gasoline and organic or aromatic solvents.
AS	Acrylonitrile Styrene Resin	80 (176)	Alcohol is harmless if applied only for short time in small amount (ex., quick wiping to remove grease).	Avoid dipping or immersing in alcohol, gasoline, solvents, etc.
PA	Polyamide (Nylon)	80 (176)	Alcohol and gasoline are Harmless.	Avoid battery acid.
PC	Polycarbonate	120 (248)	Alcohol is harmless.	Avoid gasoline, brake fluid, wax, wax removers and organic solvents.
PE	Polyethylene	80 (176)	Alcohol and gasoline are harmless.	Most solvents are harmless.
POM	Polyoxymethylene (Polyacetal)	100 (212)	Alcohol and gasoline are harmless.	Most solvents are harmless.

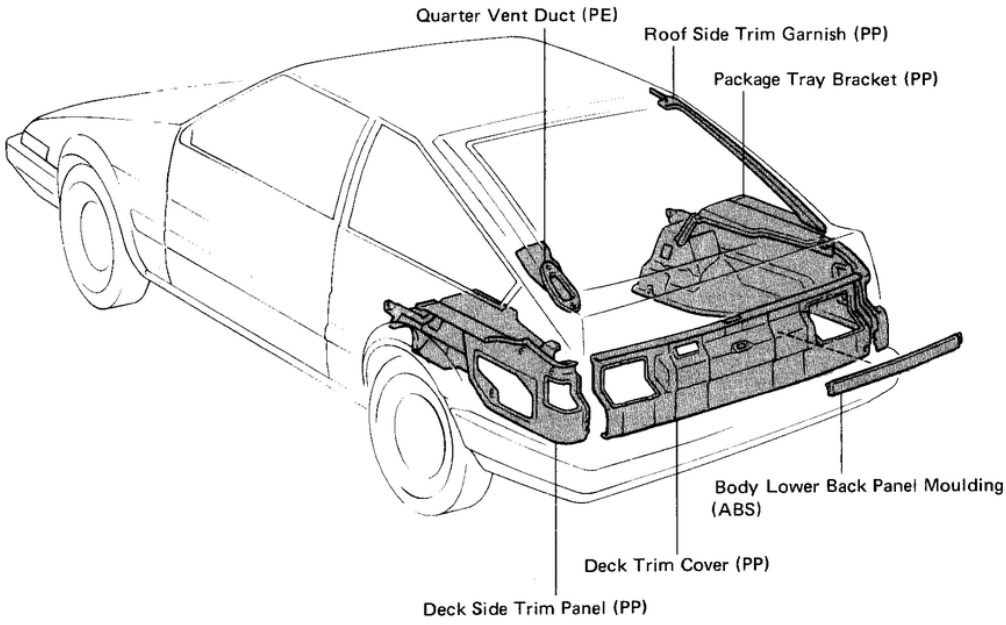
* Temperature higher than those listed here may result in material deformation during repair.

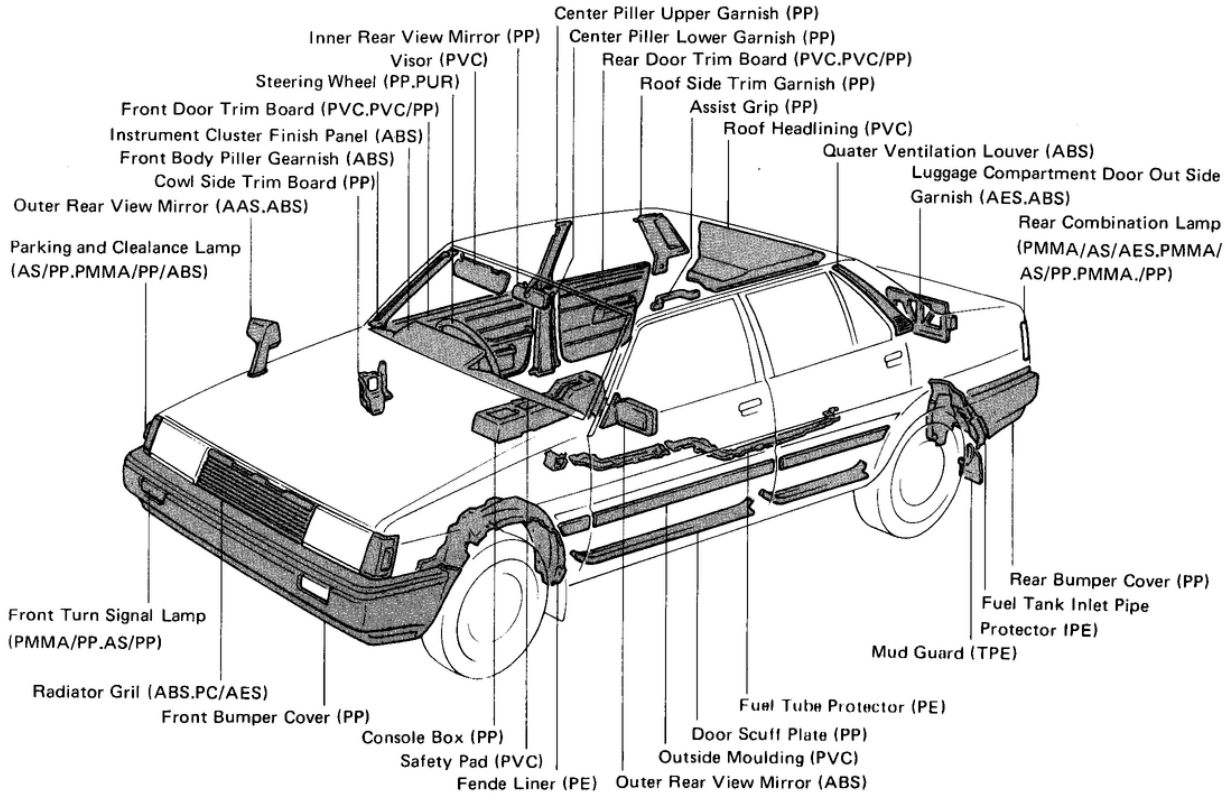
Code	Material Name	Heat * Resisting Temperature °C (°F)	Resistance To Alcohol or Gasoline	Notes
PP	Polypropylene	80 (176)	Alcohol and gasoline are harmless.	Most solvents are harmless.
PPO	Modified Polyphenylene Oxide	100 (212)	Alcohol is harmless.	Gasoline is harmless if applied only for quick wiping to remove grease.
PS	Polystyrene	60 (140)	Alcohol and gasoline are harmless if applied only for short time in small amount.	Avoid dipping or immersing in alcohol, gasoline, solvents, etc.
PUR	Thermosetting Polyurethane	80 (176)	Alcohol is harmless if applied only for very short time in small amount (ex., quick wiping to remove grease).	Avoid dipping or immersing in alcohol, gasoline, solvents, etc.
PVC	Polyvinylchloride (Vinyl)	55 (131)	Alcohol and gasoline are harmless if applied only for short time in small amoutn (ex., quick wiping to remove grease).	Avoid dipping or immersing in alcohol, gasoline, solvents, etc.
PMMA	Polymethyl Methacylic Acrylate	80 (176)	Alcohol is harmless if applied only for short time in small amount.	Avoid dipping or immersing in alcohol, gasoline, solvents, etc.
TPE	Thermoplastic Elastomer	60 (140)	Alcohol is harmless. Gasoline is harmless if applied only for short time in small amount.	Most solvents are harmless but avoid dipping in gasoline, solvents, etc.
TRUR	Thermoplastic Polyurethane	60 (140)	Alcohol is harmless if applied only for very short time in small amount (ex., quick wiping to remove grease).	Avoid dipping or immersing in alcohol, gasoline, solvents, etc.
TPR	Thermoplastic Rubber (EPDM)	60 (140)	Alcohol is harmless. Gasoline is harmless if applied only for short time in small amount.	Most solvents are harm- but avoid dipping in gasoline, solvents, etc.
UP	Unsaturated Polyester	180 (356)	Alcohol and gasoline are harmless.	Avoid alkali

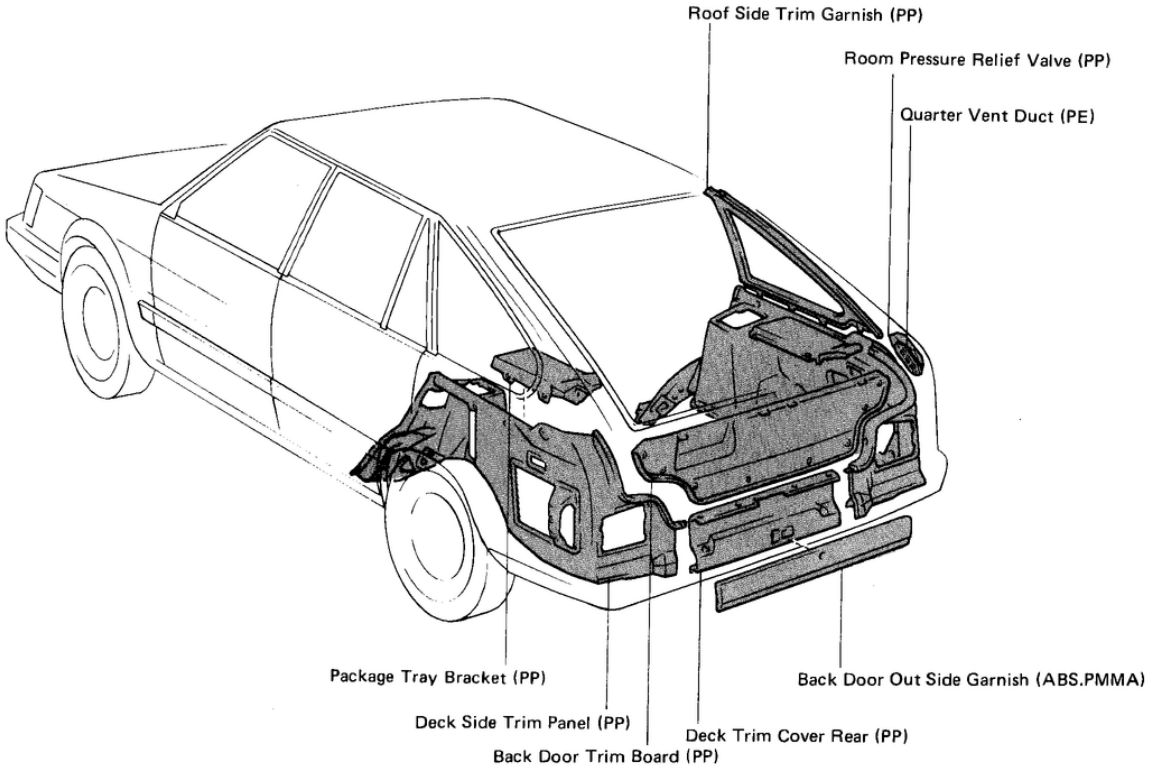
* Temperature higher than those listed here may result in material deformation during repair.

LOCATION OF PLASTIC BODY PARTS






Center Piller Upper Garnish (PP)
Inner Rear View Mirror (PP)
Center Piller Lower Garnish (PP)
Visor (PVC)
Rear Door Trim Board (PVC.PVC/PP)
Steering Wheel (PP.PUR)
Roof Side Trim Garnish (PP)
Front Door Trim Board (PVC.PVC/PP)
Assist Grip (PP)
Instrument Cluster Finish Panel (ABS)
Roof Headlining (PVC)
Front Body Piller Gearnish (ABS)
Quater Ventilation Louver (ABS)
Cowl Side Trim Board (PP)
Luggage Compartment Door Out Side Garnish (AES.ABS)
Outer Rear View Mirror (AAS.ABS)
Rear Combination Lamp (PMMA/AS/AES.PMMA/AS/PP.PMMA./PP)
Parking and Clealance Lamp (AS/PP.PMMA/PP/ABS)
Rear Bumper Cover (PP)
Fuel Tank Inlet Pipe Protector IPE)
Front Turn Signal Lamp (PMMA/PP.AS/PP)
Mud Guard (TPE)
Radiator Gril (ABS.PC/AES)
Fuel Tube Protector (PE)
Front Bumper Cover (PP)
Door Scuff Plate (PP)
Console Box (PP)
Outside Moulding (PVC)
Safety Pad (PVC)
Outer Rear View Mirror (ABS)
Fende Liner (PE)


Roof Side Trim Garnish (PP)
Room Pressure Relief Valve (PP)
Quarter Vent Duct (PE)
Package Tray Bracket (PP)
Back Door Out Side Garnish (ABS.PMMA)
Deck Side Trim Panel (PP)
Deck Trim Cover Rear (PP)
Back Door Trim Board (PP)

BODY PANEL SEALING AND UNDERCOATING

Page
BODY PANEL SEALING AREAS SU-2
BODY PANEL UNDERCOATING AREAS SU-11

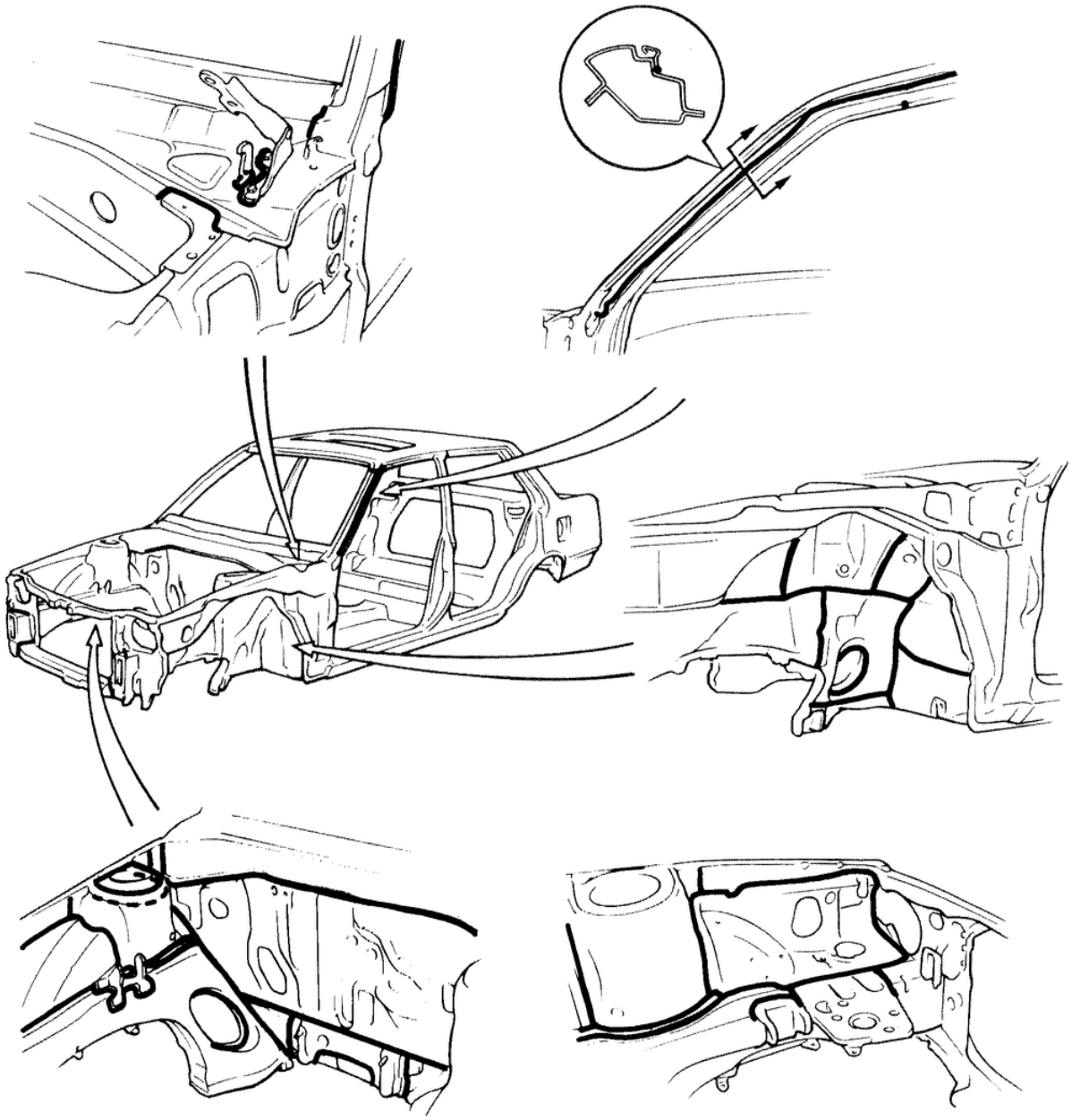
BODY PANEL SEALING AREAS

For water-proofing and anti-corrosion measures, always apply body sealer to the body panel seams and hems of the doors, hood, etc.

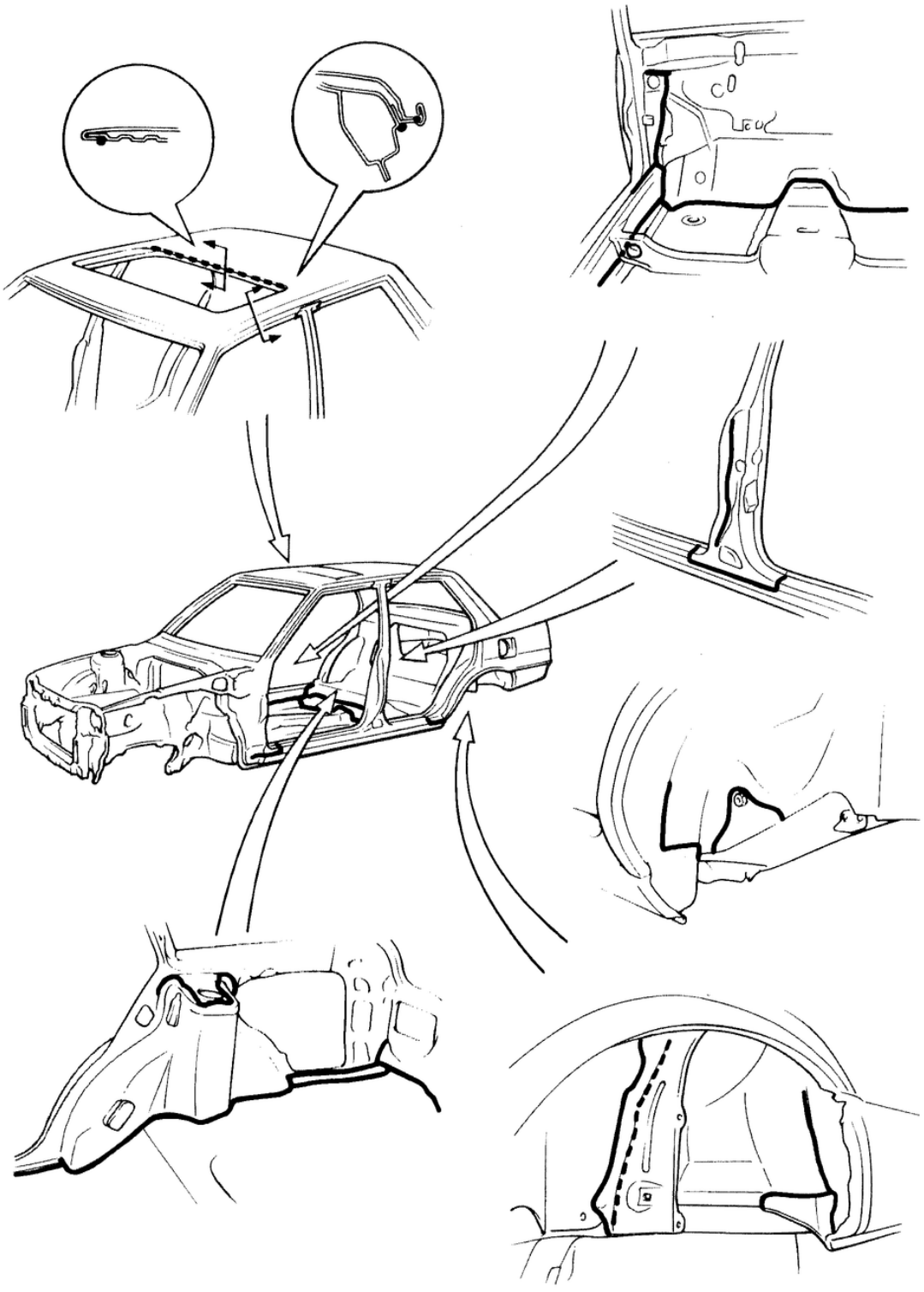
NOTE:

1. *Prior to applying body sealer, clean the area with a rag soaked in white gasoline.*
2. *If weld-through primer was used, first wipe off any excess with thinner, and coat with anti-corrosion primer before applying body sealer.*
3. *Wipe off any excess body sealer with a rag soaked in white gasoline.*

SEDAN AND LIFTBACK

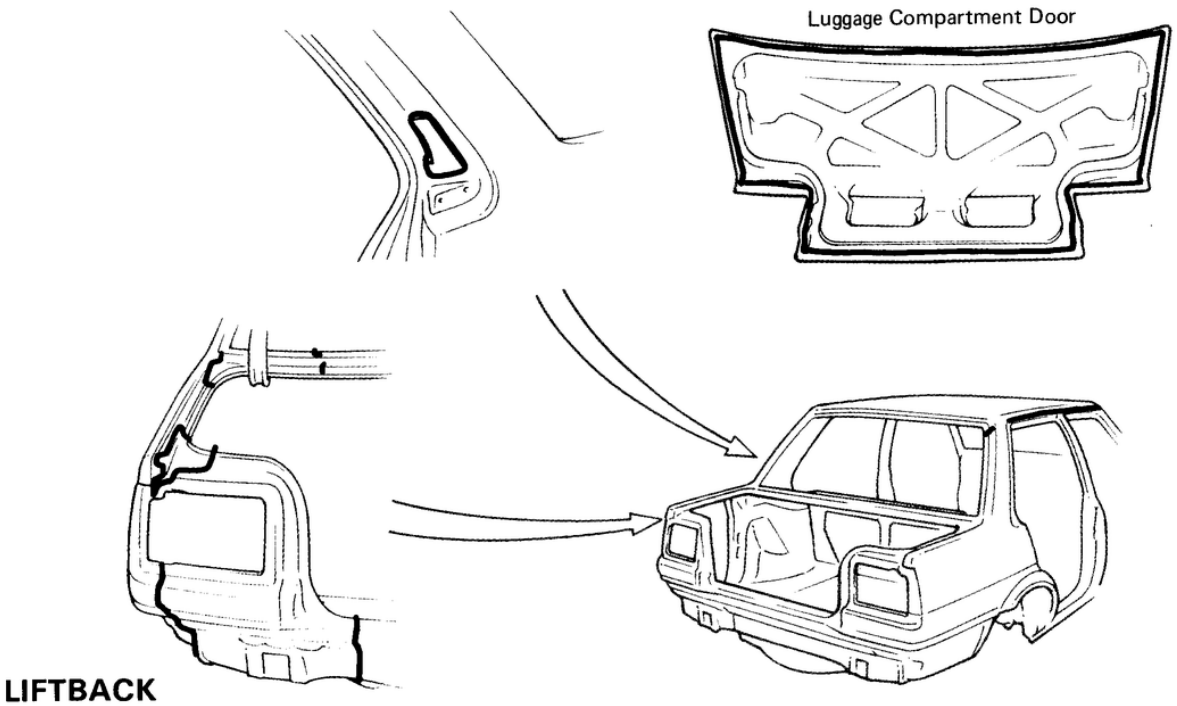


SEDAN AND LIFTBACK (CONT'D)

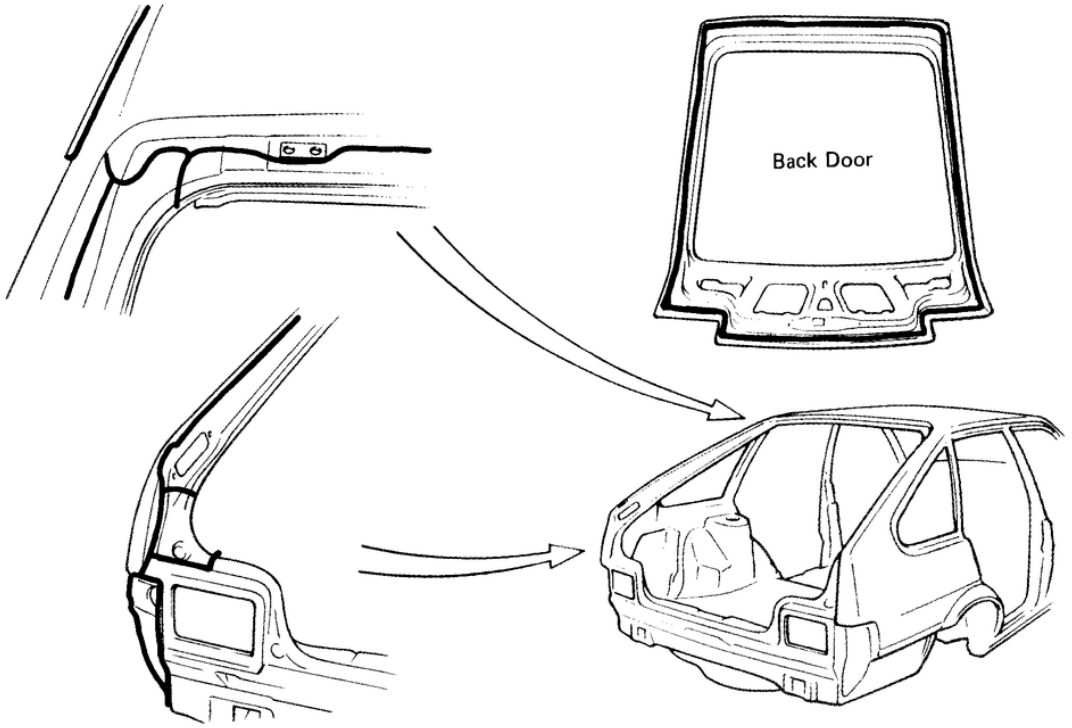


SEDAN AND LIFTBACK (CONT'D)

SEDAN

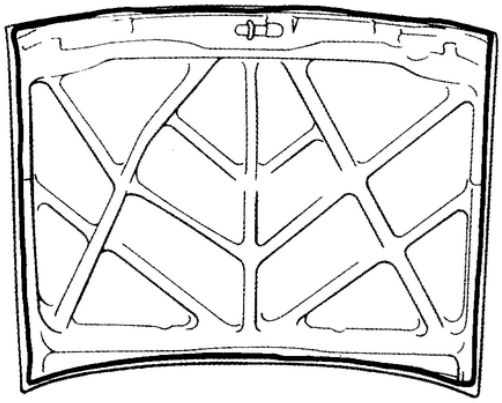


LIFTBACK

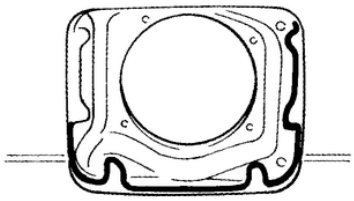


SEDAN AND LIFTBACK (CONT'D)

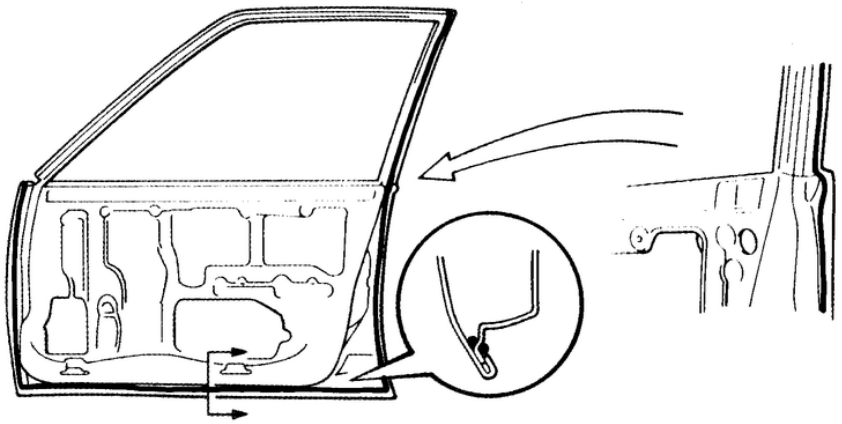
Engine Hood



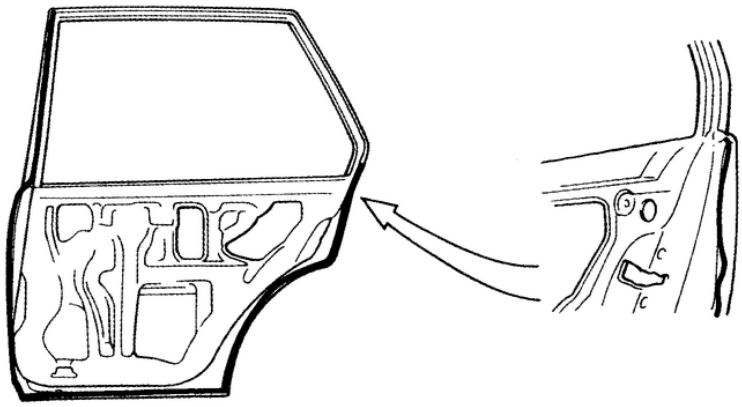
Fuel Inlet Box



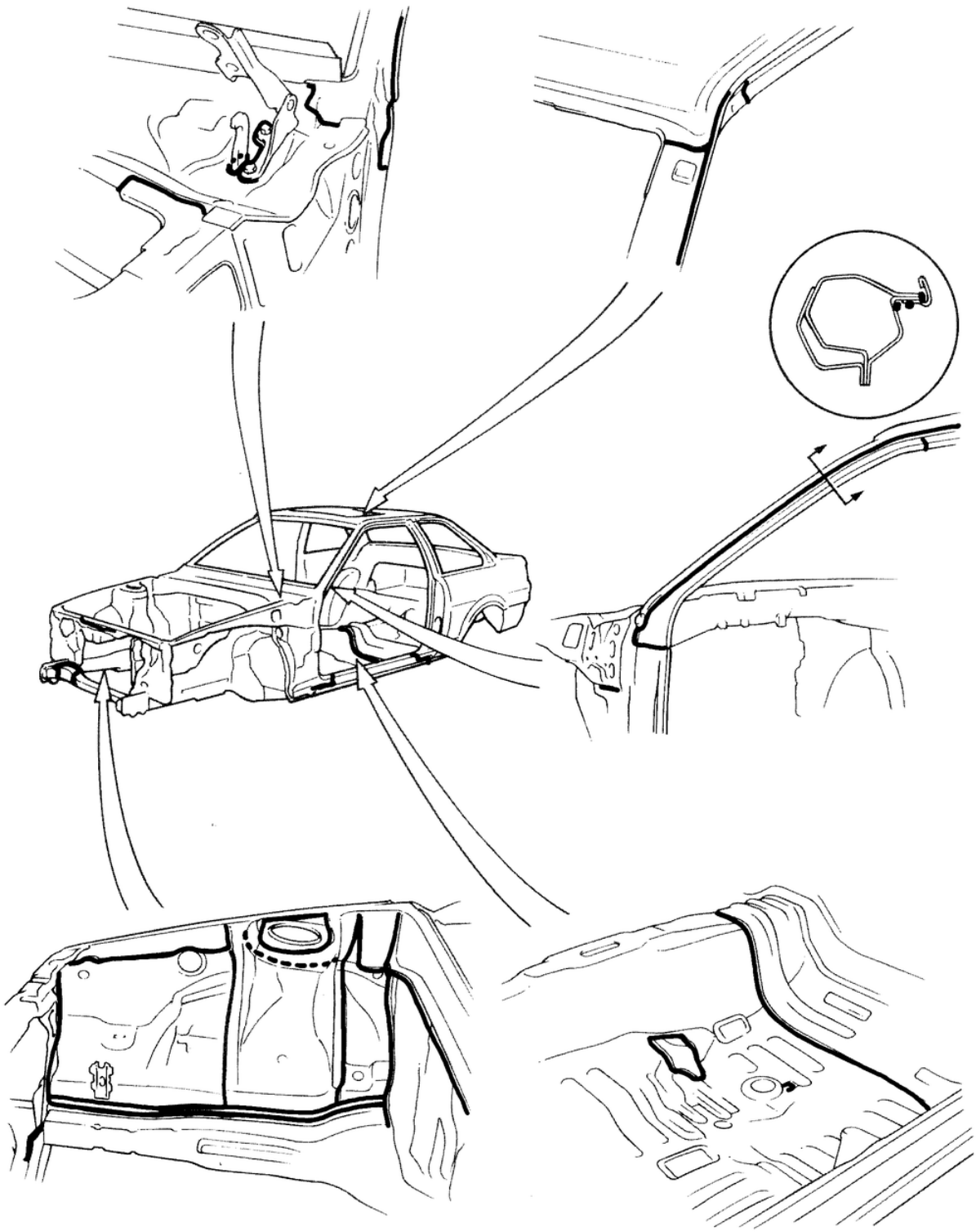
Front Door



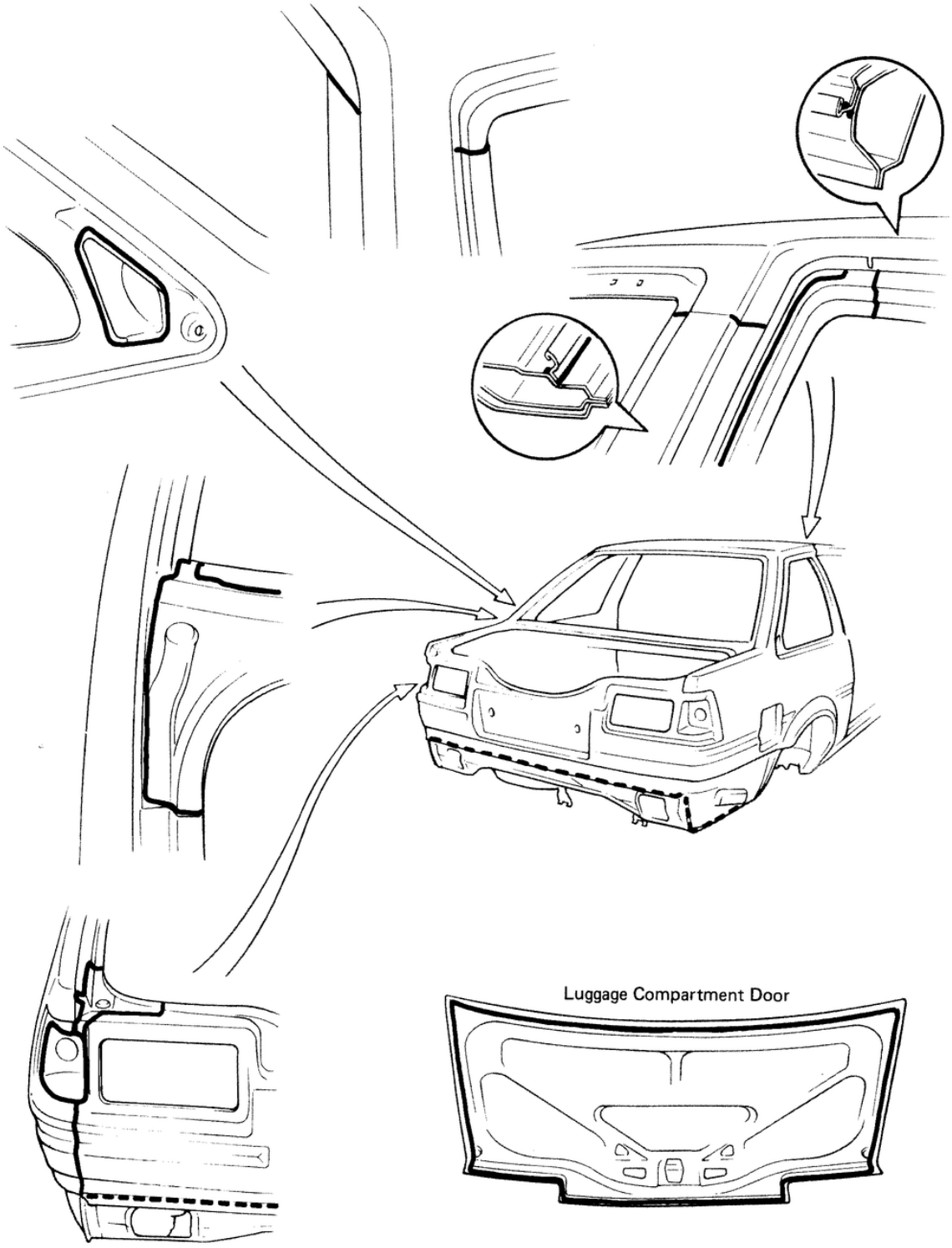
Rear Door



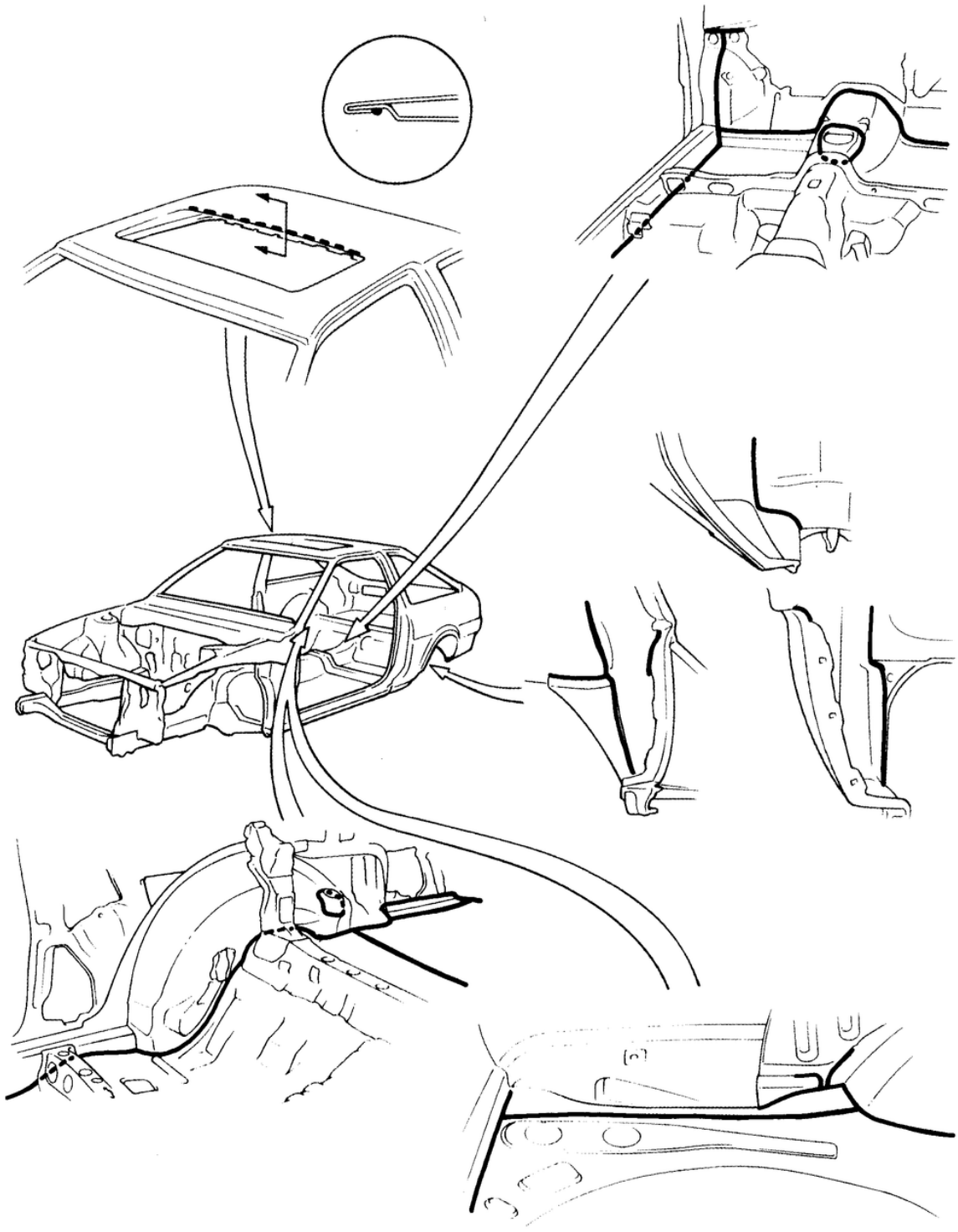
2-DOOR COUPE



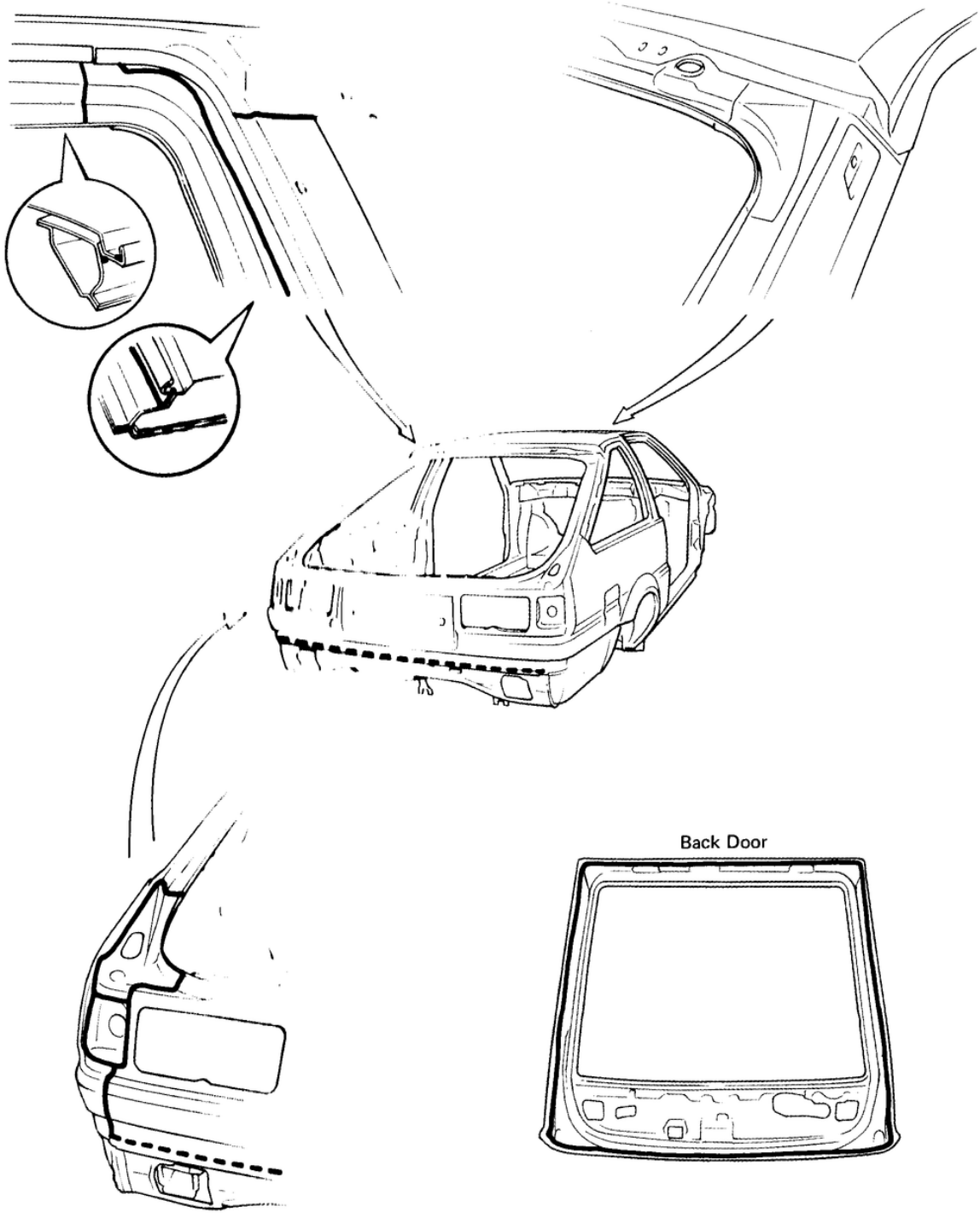
2-DOOR COUPE (CONT'D)



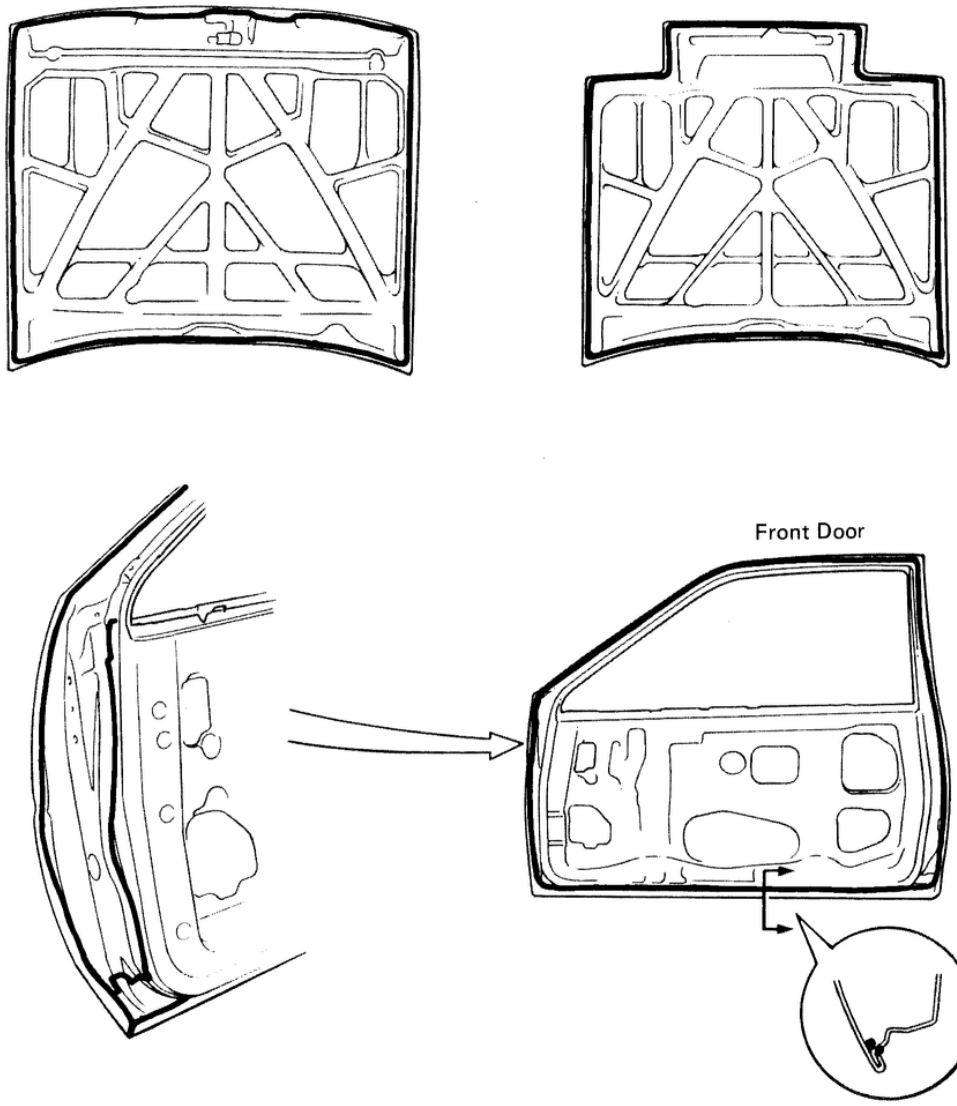
Luggage Compartment Door



3-DOOR COUPE (CONT'D)



2-DOOR COUPE AND 3-DOOR COUPE



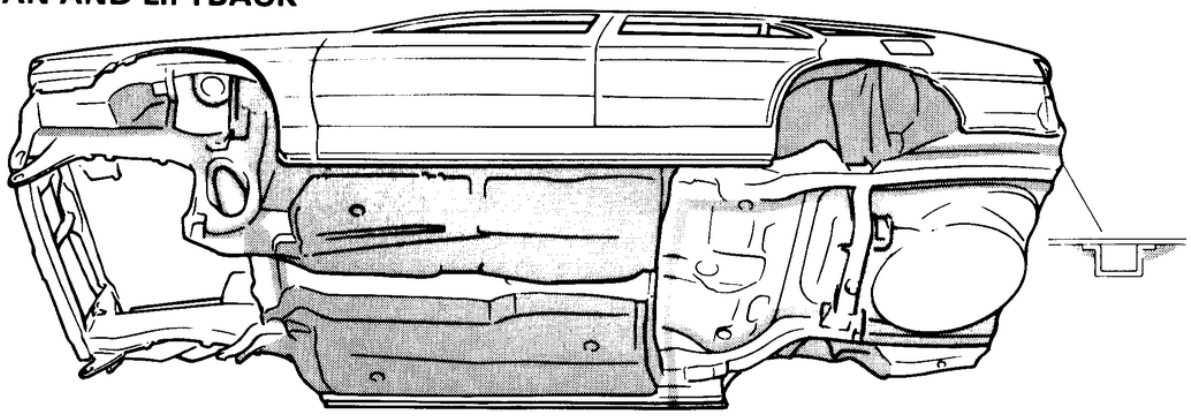
BODY PANEL UNDERCOATING AREAS

To prevent corrosion and protect the body from damage by flying stones, always apply undercoating to the welded seams and wheel housings after chassis, under body or panel repair.

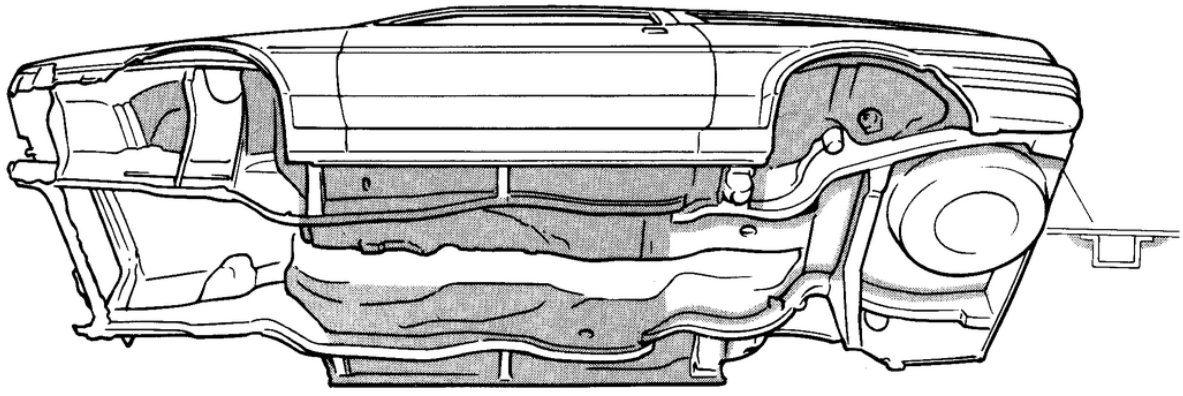
NOTE:

1. *First wipe off any drit, grease or oil with white gasoline or such.*
2. *Cover the surrounding areas with masking paper to avoid coating unnecessary areas. If other areas are accidently coated, wipe off the coating immediately.*
3. *Do not coat parts which become hot, such as the tailpipe, or drive parts, such as the propeller shaft.*
4. *Besides the locations described below, apply undercoating to all weld points under the body to insure corrosion prevention.*
5. *Be sure to seal the edge of the flang of the member and bracket with undercoating.*

SEDAN AND LIFTBACK



2-DOOR COUPE AND 3-DOOR COUPE

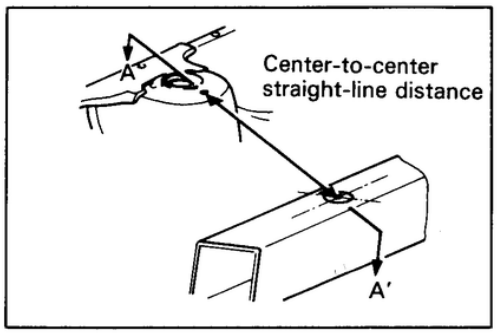


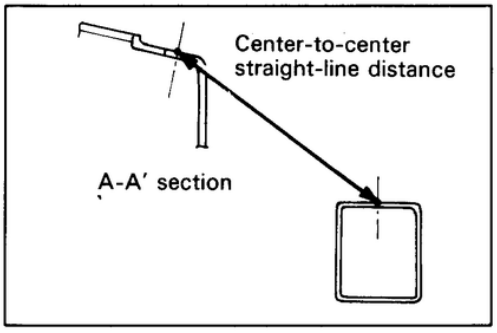
REFERENCE: Referring to the notes above, undercoating should be applied according to the specifications for your country.

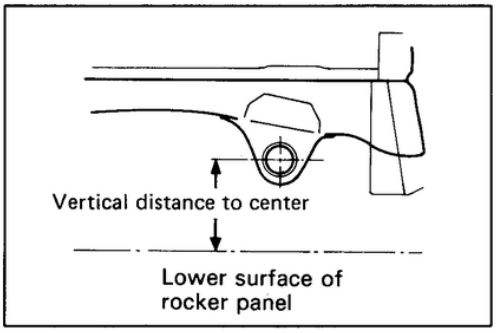
– MEMO –

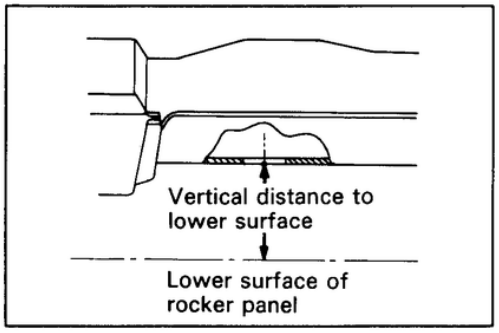
BODY DIMENSIONS

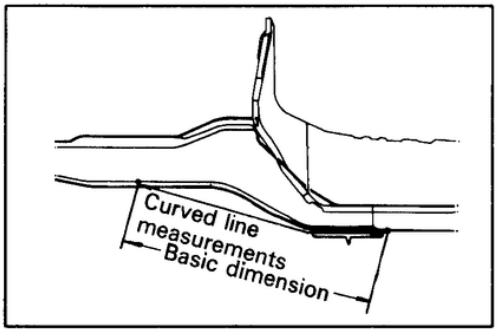
	Page
BODY MEASUREMENTS	DI-2
MEASURING PROCEDURES	DI-3
BODY DIMENSION DRAWINGS	DI-4











BODY MEASUREMENTS

1. BASIC DIMENSIONS

All dimensions shown in the drawing on page DI-5 through page DI-7 are basic dimensions which define either of the following distances:

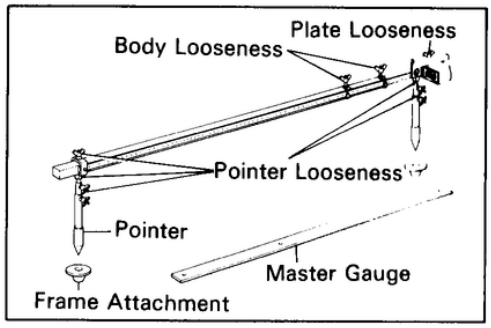
(a) Straight-line distance between the respective centers of two measuring points.

(b) Vertical distance from an imaginary line at the lower surface of the rocker panel to the lower surface or center of a measuring point.

2. REFERENCE DIMENSIONS

Curved line measurements, if applicable, are shown in brackets together with basic dimensions in the body dimension table on page DI-5.

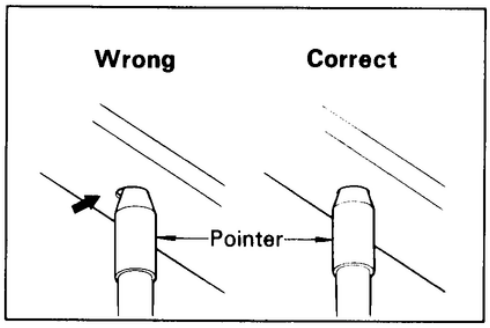
NOTE: The curved line measurements are for reference only. Final confirmation of body mounting dimensions must be made in accordance with the basic dimension, utilizing a tram tracking gauge.



MEASURING PROCEDURES

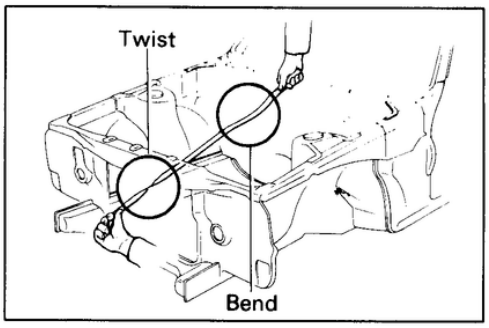
(a) Basically, all measurements are taken with a tracking gauge. However, dimensions which can be measured with a tape measure only are indicated by a CHAIN LINE.

(b) Use only a tracking gauge that has no looseness in the body, pointers or gauge plate.

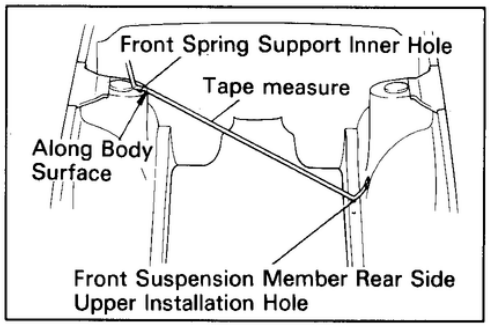


NOTE:

1. *The height of the left and right pointers must be equal.*
2. *Always calibrate the tracking gauge before measuring or after adjusting the pointer height.*
3. *Take care not to drop the tracking gauge or otherwise cause a shock to it.*
4. *Confirm that the pointers are securely in the holes.*



(c) When using a tape measure, avoid twists and bends in the tape.



(d) When taking a diagonal measurement from the front spring support inner hole to the suspension member upper rear installation hole, measure along the front spring support panel surface.

BODY DIMENSION DRAWINGS

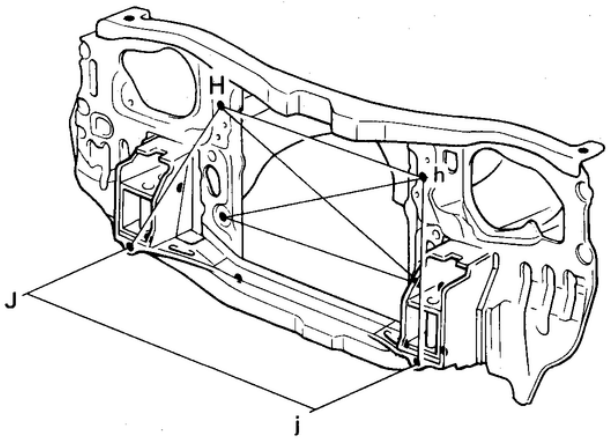
Sedan and Liftback

Symbol	Nomenclature	Hole dia.
A, a	Front fender installation nut	6ϕ
B, b	Front spring support inner hole	9.5ϕ
C, c	Fender rear installation nut	6ϕ
D	Cowl top panel center mark	–
E, e	Front crossmemeber standard hole	11ϕ
F, f	Front side member standard hole	16ϕ
G, g	Front side member standard hole	16ϕ
H, h	A/C condenser upper installation nut	6ϕ
I, i	A/C condenser lower installation nut	6ϕ
J, j	Front crossmemeber bumper installation nut	*A 13ϕ | *B 12ϕ
K, k	Cowl top side panel standard hole	11ϕ
L, l	Engine mounting member front installation nut	12ϕ
M, m	Front side member front bumper installation nut	*A 15ϕ | *B 17ϕ
N, n	Engine mounting bracket rear hole	12.5ϕ
O, o	Lower arm front installation hole	12.5ϕ
P, p	Engine mounting member rear installation nut	12ϕ
Q, q	Front side member standard hole	9ϕ
R, r	Front floor under reinforcement stadard hole	15ϕ
S, s	Front floor under reinforcement stadard hole	15ϕ
T, t	Strut bar inner installation hole	12ϕ
U, u	Rear floor side member standard hole	15ϕ
V, v	Rear floor crossmemeber stadard hole	15ϕ
W, w	Rear floor side member standard hole	15ϕ
CC, cc	Rear spring outer support hole	9.5ϕ
BB	Back window upper frame center mark (4-Door Sedan)	2.5R
X	Upper back reinforcement center mark (4-Door Sedan)	2.5R
Z	Back door opening frame center mark (5-Door LIft Back)	–
AA, aa	Rear floor pan bumper front installation hole	40ϕ

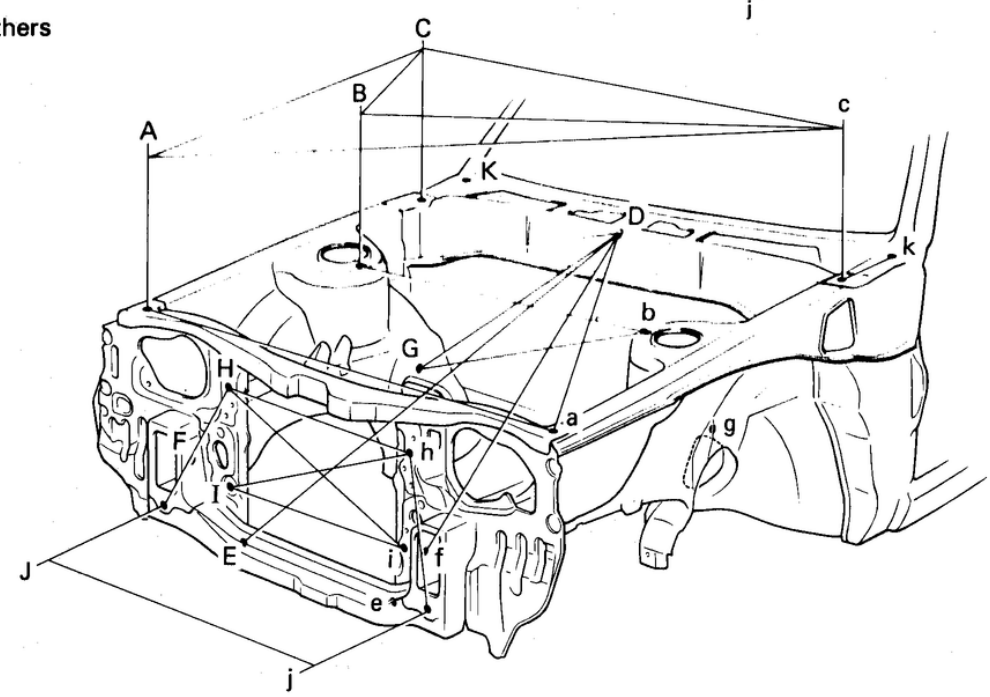
*A USA, CANADA AND SAUDI ARABIA *B Others

Engine Compartment

*A : USA, CANADA and SAUDI ARABIA



*B : Others



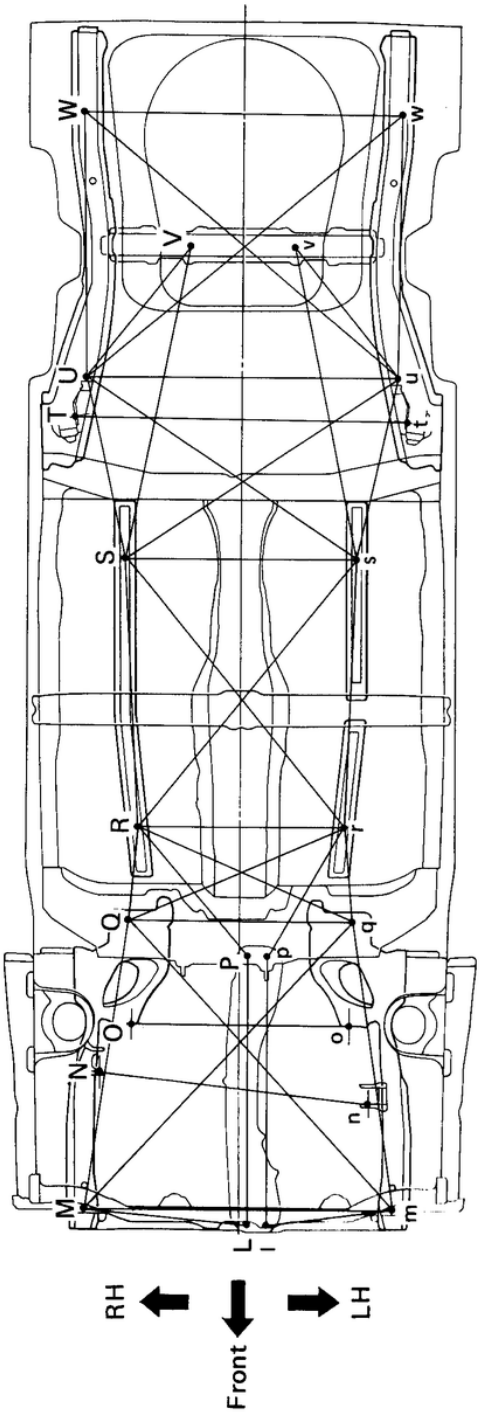
mm (in.)

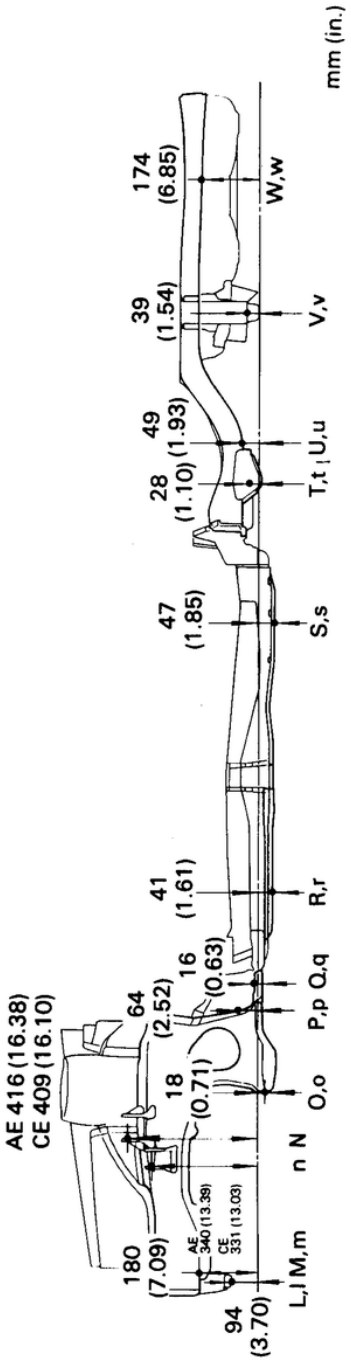
A — a	A — C	A — c	B — b	B — D	B — C	B — c	c — k	D — a	D — E	D — e
1,298 (51.10)	771 (30.35)	1,520 (59.84)	929 (36.57)	518 (20.39)	294 (11.57)	1,147 (45.16)	180 (7.09)	1,014 (39.92)	1,031 (40.59)	1,038 (40.87)

D — f	D — G	G — b	*A H — h	*B H — h	*A H — i	*B H — i	*A I — h	—
1,022 (40.24)	587 (23.11)	952 (37.48)	738 (29.06)	AE A/T CE: 738 (29.06); Others: 658 (25.91)	750 (29.53)	AE A/T CE: 750 (29.53); Others: 669 (26.34)	762 (30.00)	—

*B I — h		*A I — i	*B I — i		*A J — j	*B J — j	C — c	*A H — J, h — j	*B H — J, h — j	
AE A/T CE	Others	730 (28.74)	AE A/T CE	Others	934 (36.77)	970 (38.19)	1,322 (52.05)	316 (12.44)	AE A/T CE	Others
762 (30.00)	685 (26.97)		732 (28.82)	652 (25.67)					289 (11.38)	316 (12.44)

Under Body



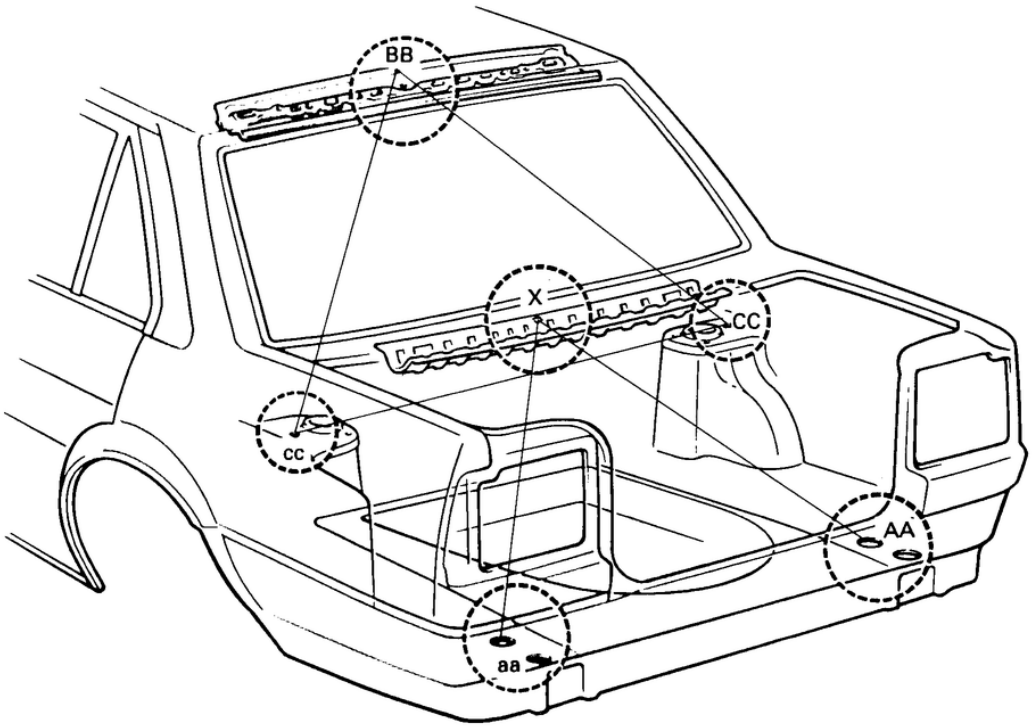


Point Symbol	Reference, length mm (in.)
L — M	524 (20.63)
l — m	407 (16.02)
L — P l — P	857 (33.74)
M — m	970 (38.19)
M — Q	*A 1,057 (41.61)
m — q	*B 933 (36.73)
M — q	*A 1,342 (52.83)
M — Q	*B 1,247 (49.09)
N — n	AE 886 (34.88) CE 852 (33.54)
O — o	698 (27.48)
P — R	544 (21.42)
p — r	471 (18.54)
Q — q	704 (27.72)
Q — r q — R	741 (29.17)
Q — R q — r	305 (12.01)
R — r	647 (25.47)
R — S r — s	854 (33.62)
R — s r — S	1,095 (43.11)
S — s	725 (28.54)
S — U s — u	581 (22.87)
S — u s — U	1,018 (40.08)
T — t	1,005 (39.57)
U — u	964 (37.95)
U — V u — v	550 (21.65)
U — W u — w	874 (34.41)
W — w	940 (37.01)
S — V s — v	1,018 (40.08)

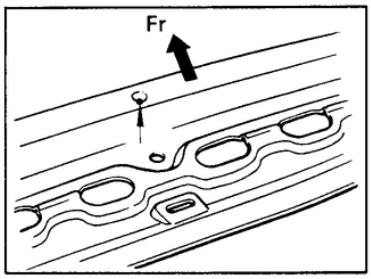
*A USA, CANADA and SAUDI ARABIA

*B Others

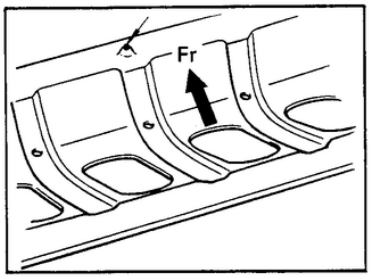
Luggage Compartment (4-Door Sedan)



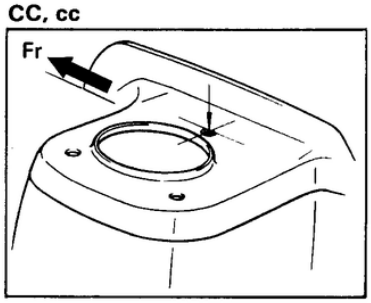
BB



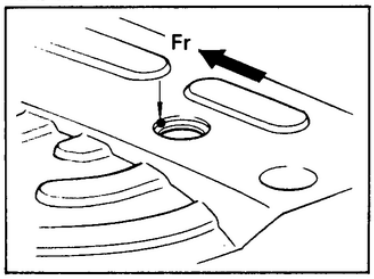
X



CC, cc



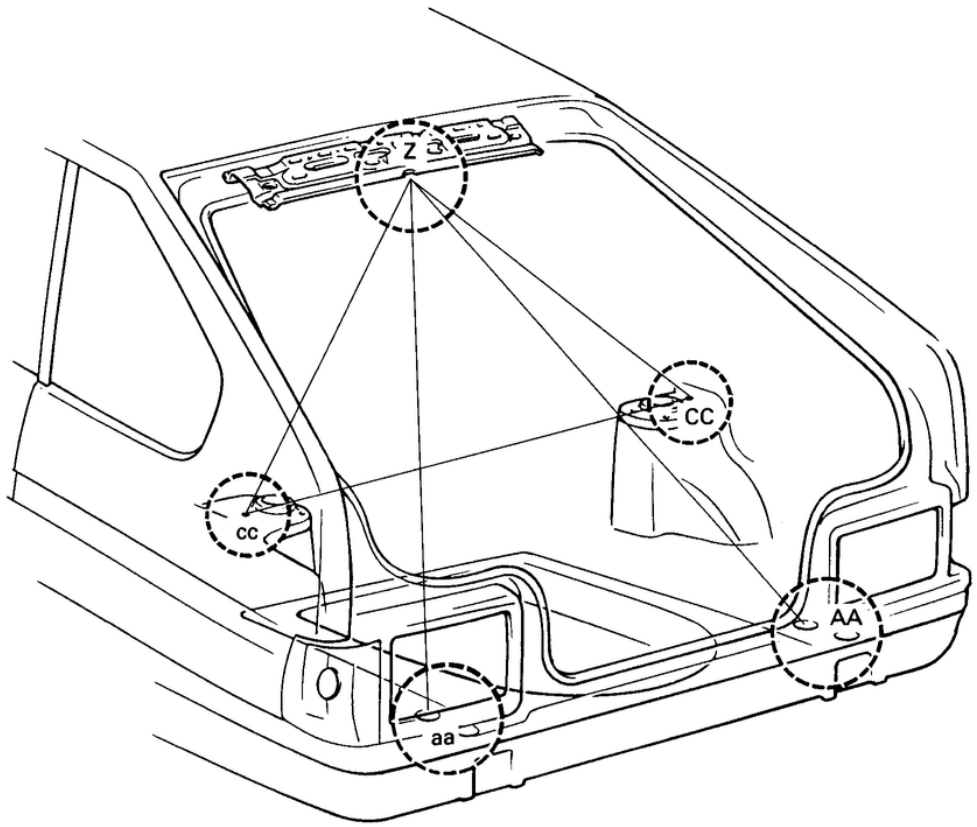
AA, aa



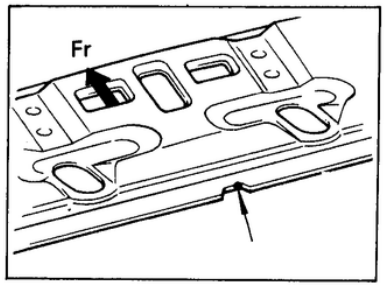
Point symbol	Reference length mm (in.)
BB — CC BB — cc	819 (32.24)
CC — cc	1,211 (47.68)
X — AA X — aa	743 (29.25)

Note: The luggage compartment measurement is performed between the two dot-marked points as shown in the figure above.

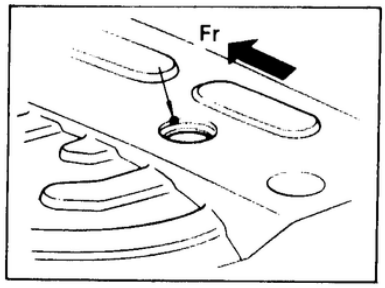
Luggage Compartment (5-Door Liftback)



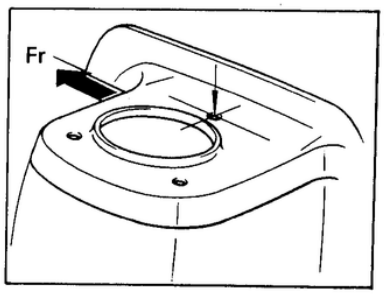
Z



AA, aa



CC, cc



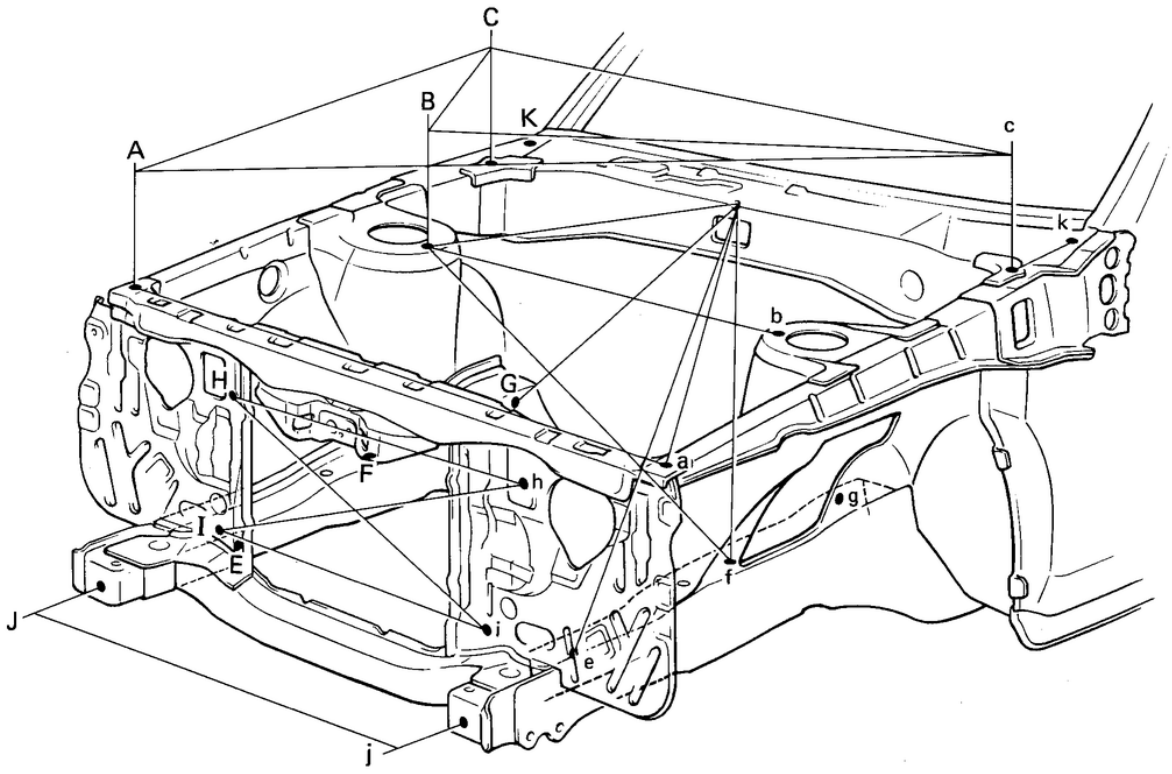
Note: The luggage compartment measurement is performed between the two dot-marked points as shown in the figure above.

Point symbol	Reference length mm (in.)
Z – CC Z — cc	793 (31.22)
CC — cc	1,211 (47.68)
Z — AA Z — aa	1,210 (47.64)

Coupe

Symbol	Nomenclature	Hole dia.
A, a	Fender front installation nut	6ϕ
B, b	Front spring support inner hole	10ϕ
C, c	Fender rear installation nut	6ϕ
D	Cowl top panel center mark	–
E, e	Front side member standard hole	15ϕ
F, f	Suspension member rear side upper installation hole	15ϕ
G, g	Front side member stnadard hole	11ϕ
H	Radiator support upper hole	nonagon
h	Radiator support upper hole	7ϕ
I, i	A/C condenser lower installation nut	6ϕ
J, j	Front side member bumper installation nut	12ϕ
K, k	Cawl top side panel standard hole	11ϕ
L, l	Front side member bumper installation hole	19ϕ
M, m	Strut bar bracket fron side inner installation nut	10ϕ
N, n	Strut bar bracket rear side rear installation nut	10ϕ
O, o	Suspension member front side lower installation hole	15ϕ
P, p	Suspension member rear side lower installation hole	13ϕ
Q, q	Front floor under reinforcement standard hole	17ϕ
R, r	Front floor under reinforcement standard hole	15ϕ
S, s	Lower control link bracket inner hole	12.5ϕ
T, t	Rear floor side member standard hole	13ϕ
U, u	Upper control link bracket inner hole	12.5ϕ
V, v	Rear floor side member standard hole	11ϕ
W, w	Rear floor side member standard	13ϕ
X	Upper back reinforcement center mark (2-Door Coupe)	3R
Y	Back door opening frame center mark (3-Door Coupe)	2.5R
Z, z	Rear floor pan punch mark	2.5R

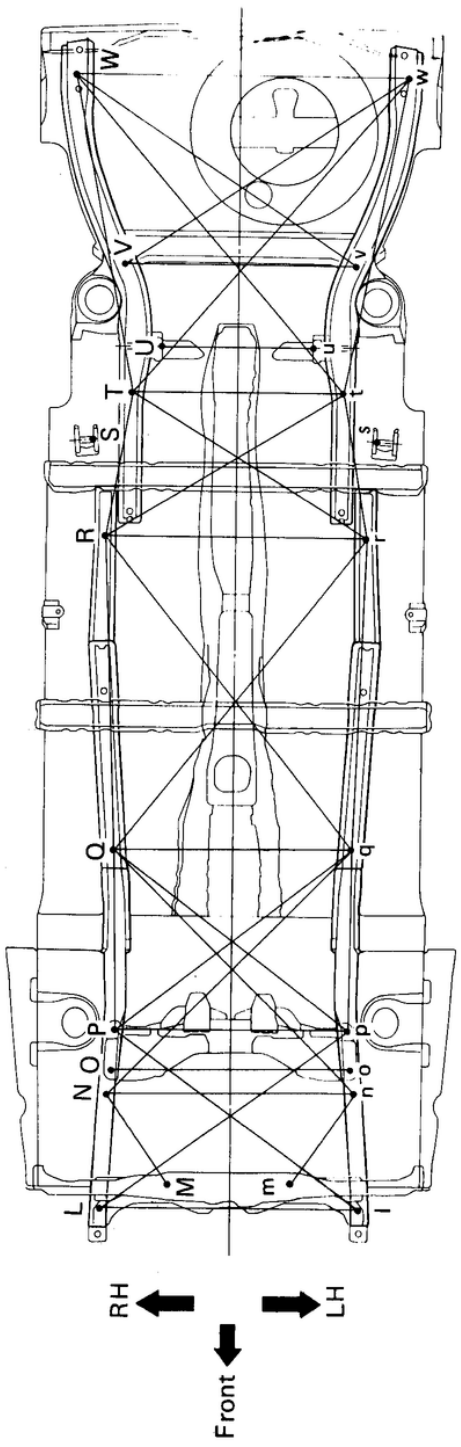
Engine Compartment

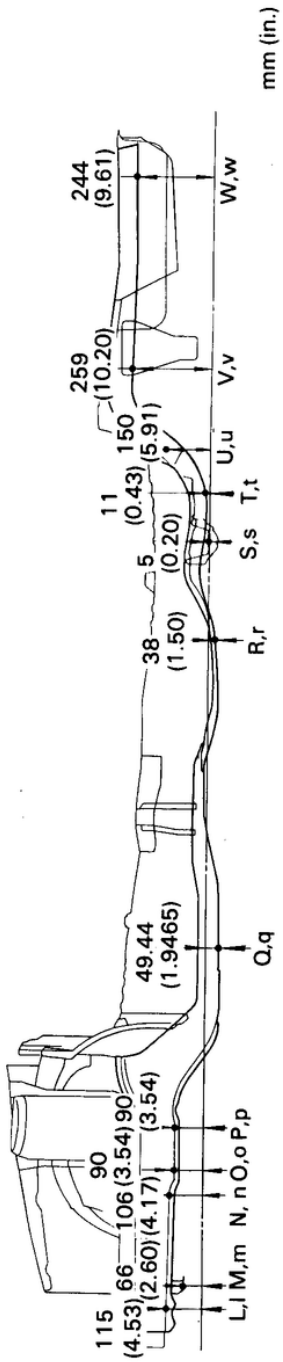


mm (in.)

A — a	A — C	A — c	B — b	B — D	B — f	B — C	B — c	D — a	D — e
1,259 (49.57)	736 (28.98)	1,467 (57.76)	890 (35.04)	510 (20.08)	915 (36.02)	304 (11.97)	1,110 (43.70)	981 (38.62)	940 (37.01)
D — f	D — G	H — h	H — i	I — h	I — i	J — j	C — c	c — k	—
644 (25.35)	552 (21.73)	728 (28.66)	696 (27.40)	765 (30.12)	671 (26.42)	854 (33.62)	1,280 (50.39)	212 (8.35)	—

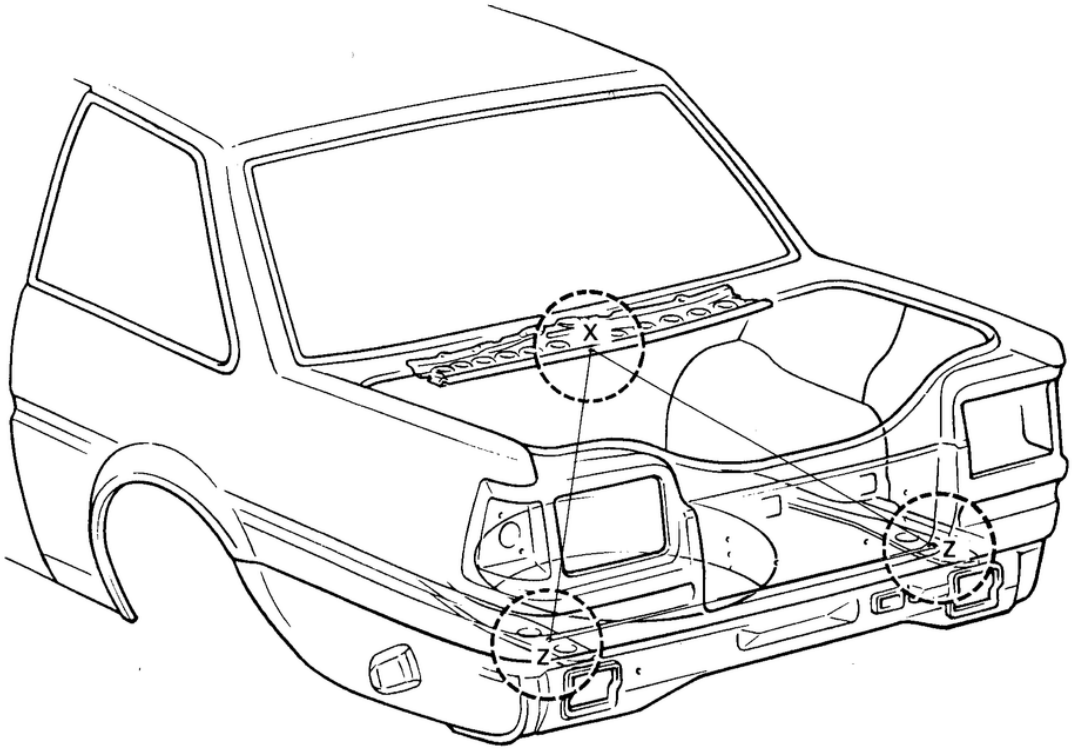
Under Body



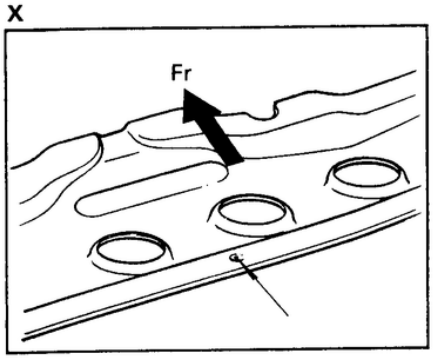


Point Symbol	Reference, length mm (in.)
L — l	823 (32.40)
L — p l — P	986 (38.82)
M — N m — n	352 (13.86)
N — n	781 (30.75)
N — q	1,118 (44 02)
n — Q	1,117 (43.98)
O — o	778 (30.63)
P — p	761 (29.96)
P — q	962 (37.87)
p — Q	963 (37.91)
p — Q	587 (23.11)
p — q	586 (23.07)
Q — q	765 (30.12)
Q — R q — r	994 (39.13)
Q — r q — R	1,280 (50.39)
R — r	1,095 (43.11)
R — T r — t	489 (19.25)
R — t r — T	909 (35.79)
S — s	892 (35.12)
T — t	690 (27.17)
T — W t — w	1,082 (42.59)
T — w t — W	1,379 (54.29)
U — u	490 (19.29)
V — v	760 (29.92)
V — w v — W	1,101 (43.35)

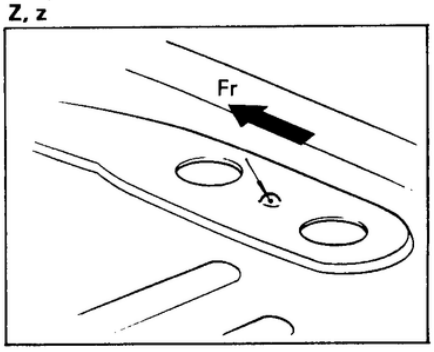
Luggage Compartment (2-Door Coupe)



X



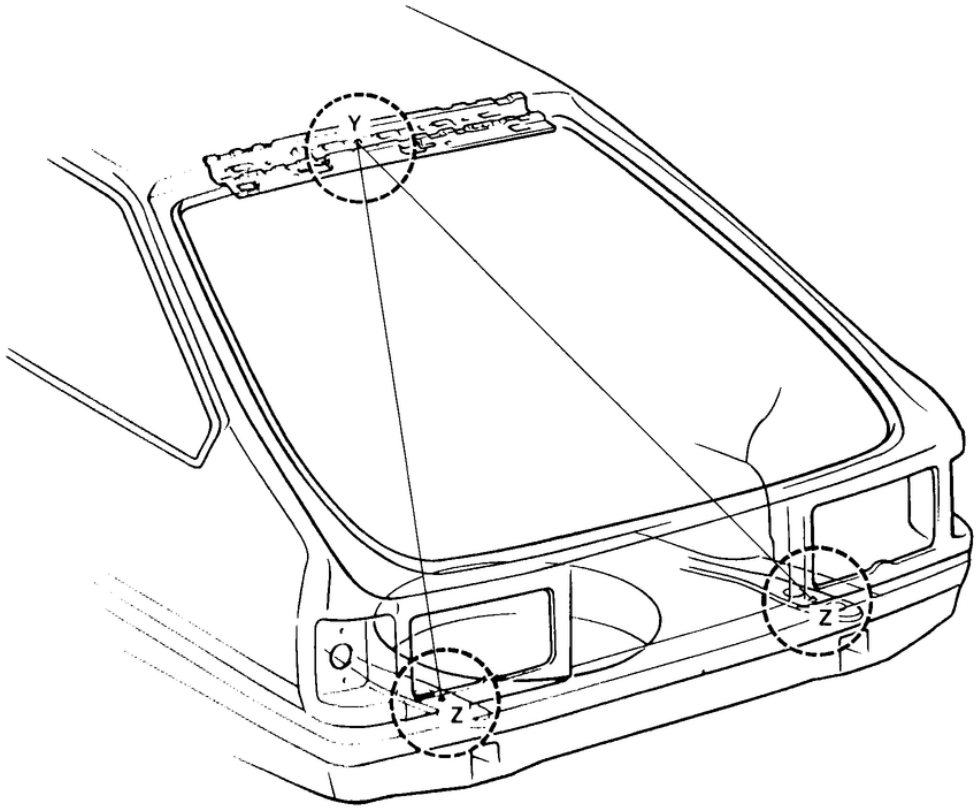
Z, z



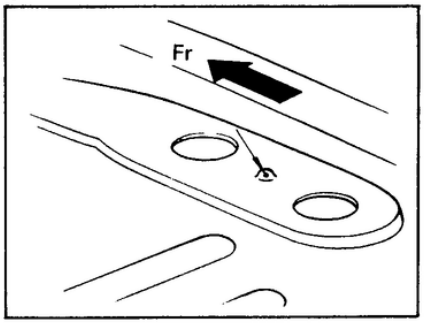
Note: The luggage compartment measurement is performed between the two dot-marked points as shown in the figure above.

Point symbol	Reference length mm (in.)
X — Z	744 (29.29)
X — z	7.33 (0.2886)

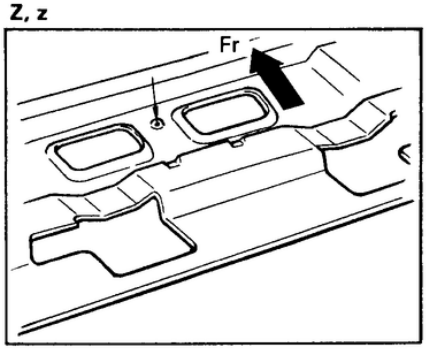
Luggage Compartment (3-Door Coupe)



Y



Z, z



Note: The luggage compartment measurement is performed between the two dot-marked points as shown in the figure above.

Point symbol	Reference length mm (in.)
Y — Z	1,360 (53.54)
Y — z	1,354 (53.31)

— MEMO —

PARTS LISTS

Page

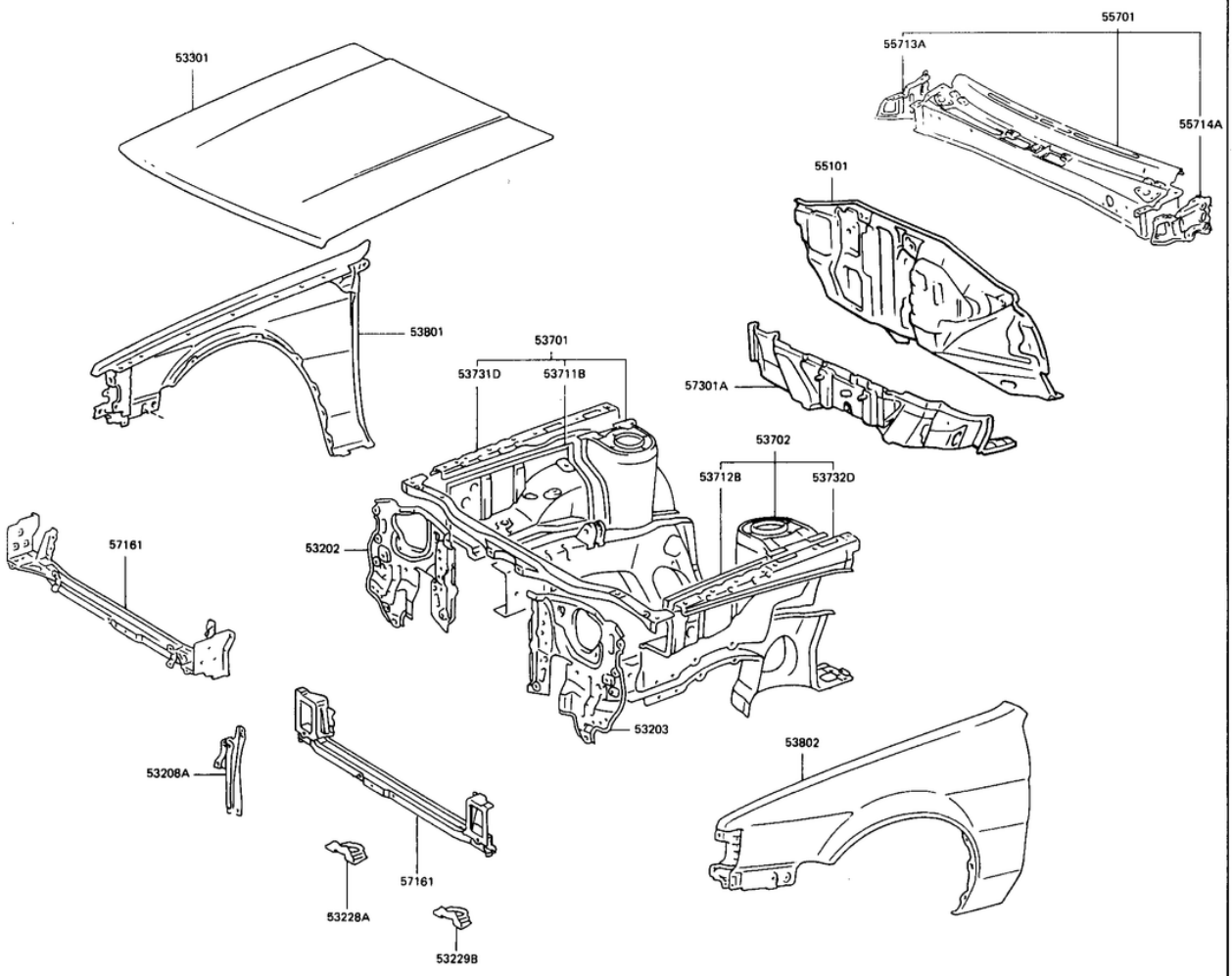
PARTS LISTS

Sedan and Lift back PL-2

Coupe PL-7

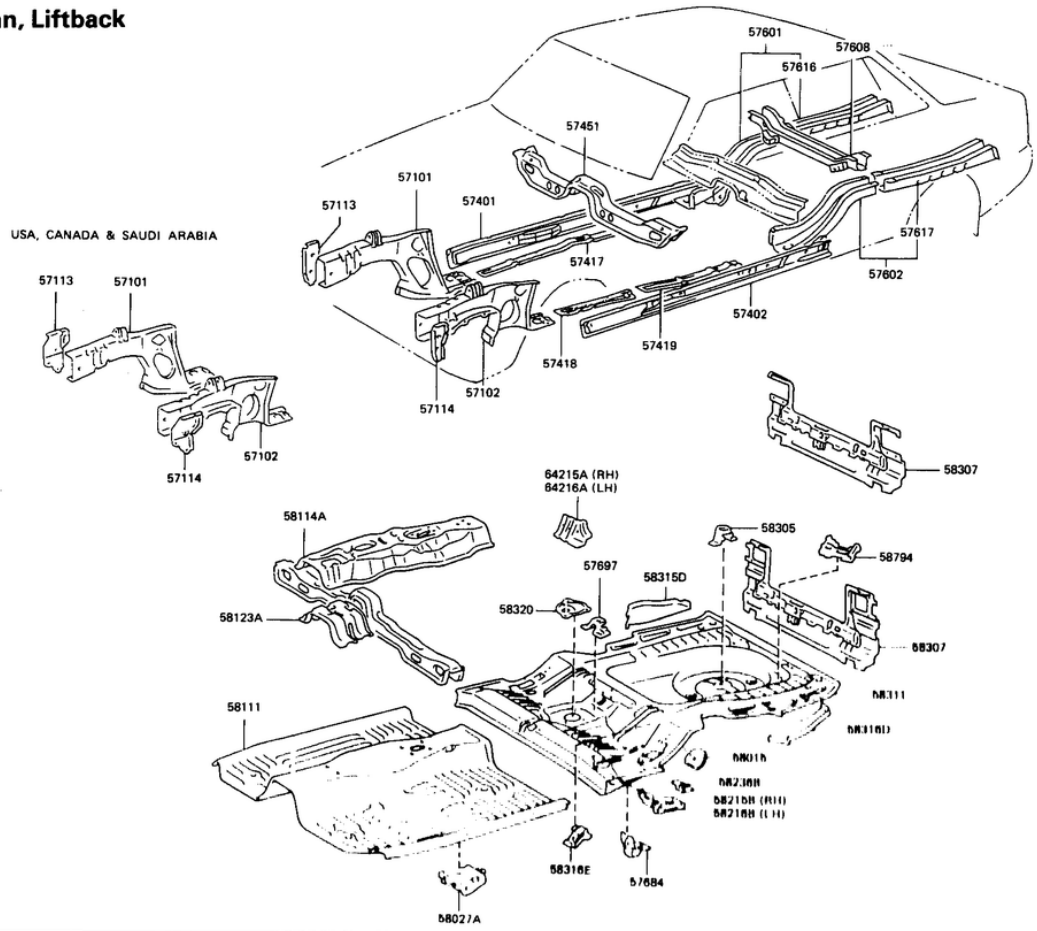
PL

Sedan, Liftback



Code	Part Name	Code	Part Name
52105 52106	Front Bumper Stay Sub-Assy	53731D 53732D	Front Apron To Cowl Side Upper Member
53202 53203	Radiator Support Sub-Assy	53801 53802	Front Fender Sub-Assy
53208A	Hood Lock Support Sub-Assy	55101	Dash Panel Sub-Assy
53228A	Radiator Mounting Lower No.1 Bracket	55701	Cowl Panel Sub-Assy
53229B	Radiator Mounting Lower No.2 Bracket	55713A 55714A	Cowl Top Side Panel
53301	Hood Sub-Assy	57161	Front Crossmember
53701 53702	Front Fender Apron Sub-Assy	57301A	Steering Gear Box Support Member Sub-Assy
53711B 53712B	Front Fender Apron	—	—

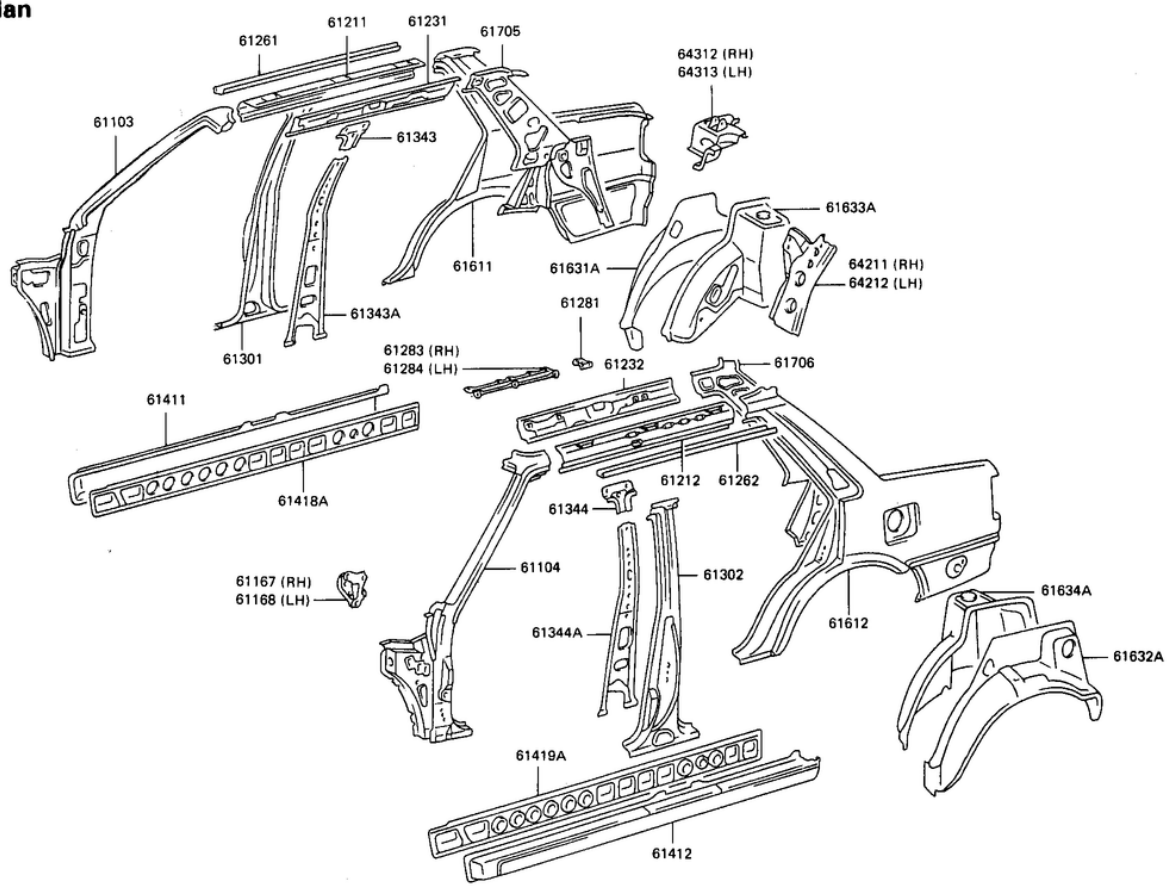
Sedan, Liftback



Code	Part Name
57101 57102	Front Side Member Sub-Assy
57113 57114	Front Side Member Extension
57401 57402	Main Floor Side Member Sub-Assy
57417 57418	Front Floor Under Reinforcement
57419	Front Floor Under No.2 Reinforcement
57451	Front Floor Crossmember Member
57601 57602	Rear Floor Side Member Sub-Assy
57608	Rear Floor No.2 Crossmember Sub-Assy
57616 57617	Rear Floor Side Rear Member
57684	Fuel Tank Rear Bracket
57697	Rear Seat Cushion Retainer
58015	Belt Anchor To Floor Pan Reinforcement

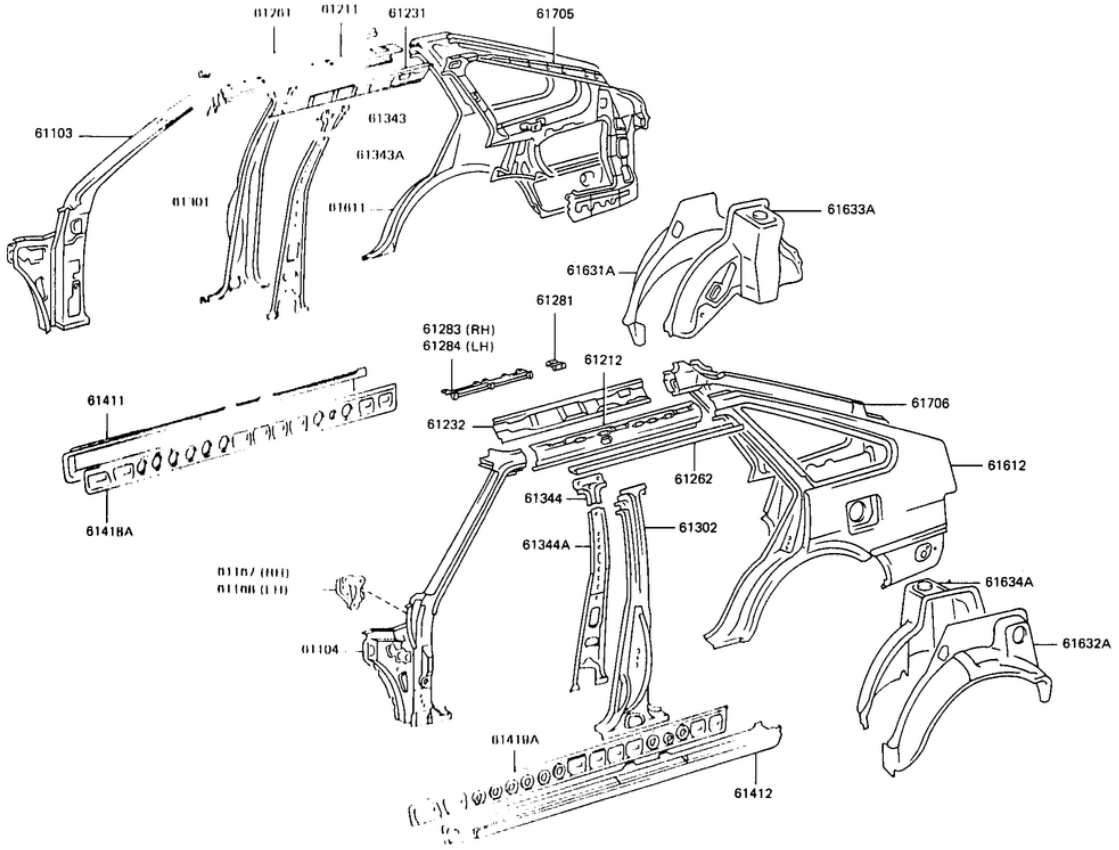
Code	Part Name
58027A	Seat Belt Anchor Reinforce Sub-Assy
58111	Front Floor Pan
58114A	Front Floor Panel Reinforcement
58123A	Shift & Select Lever Support
58215B 58216B	Rear Seat Mounting Bracket
58236B	Center Floor Insulator Bracket
58305	Space Wheel Clamp Bracket Sub-Assy
58307	Body Lower Back Panel Sub-Assy
58311	Rear Floor Pan
58315D 58316D	Rear Floor Pan Extension
58316E	Rear Seat Set Retainer
58320	Rear Floor Service Hole Cover
58794	Jack Carrier
64215A	Rear Floor To Package Tray Extension
—	—

Sedan



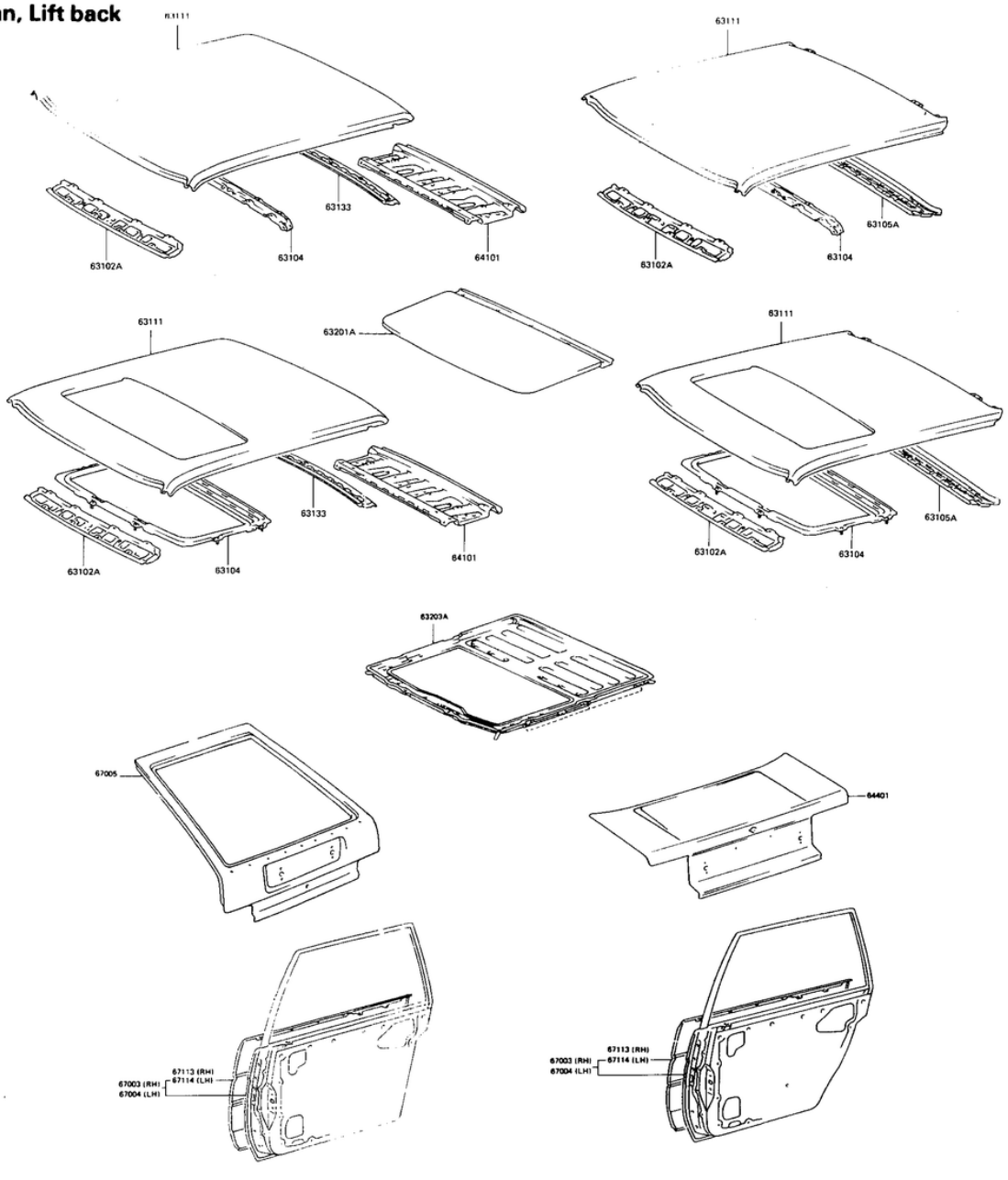
Code	Part Name	Code	Part Name
61103 61104	Front Body Pillar Sub-Assy	61411 61412	Pocker Outer Panel
61167 61168	Instrument Panel To Cowl Side Bracket	61418A 61419A	Pocker Panel Reinforcement
61211 61212	Roof Side Outer Rail	61611 61612	Quarter Panel
61231 61232	Roof Side Inner Rail	61631A 61632A	Quarter Wheel House Outer Panel
61261 61262	Roof Drip Channel	61633A 61634A	Quarter Wheel House Inner Panel
61283 61284	Sliding Roof Housing Mounting No.3 Bracket (w/Sun Roof)	61705 61706	Roof Side Inner Panel Sub-Assy
61301 61302	Center Body Pillar Sub-Assy	61281	Sliding Roof Housing Mounting No.1 Bracket (w/Sun Roof)
61343 61344	Center Body Inner Upper Pillar	64211 64212	Package Tray To Floor Strainer
61343 61344	Center Body İnner Upper Pillar	64312 64313	Package Tray Bracket
61343A 61344A	Center Body Inner Pillar	—	—

Liftback



Code	Part Name	Code	Part Name
61103 61104	Front Body Pillar Sub-Assy	61343A 61344A	Center Body Inner Pillar
61167 61168	Instrument Panel To Cowl Side Bracket	61411 61412	Pocker Outer Panel
61211 61212	Roof Side Outer Rail	61418A 61419A	Pocker Panel Reinforcement
61231 61232	Roof Side Inner Rail	61611 61612	Quarter Panel
61261 61262	Roof Drip Channel	61631A 61632A	Quarter Wheel House Outer Panel
61281	Sliding Roof Housing Mounting No.1 Bracket (w/Sun Roof)	61633A 61634A	Quarter Wheel House Outer Panel
61283 61284	Sliding Roof Housing Mounting No.3 Bracket (w/Sun Roof)	61705 61706	Roof Side Inner Panel Sub-Assy
61301 61302	Center Body Pillar Sub-Assy	—	—
61343 61344	Center Body Pillar Sub-Assy		

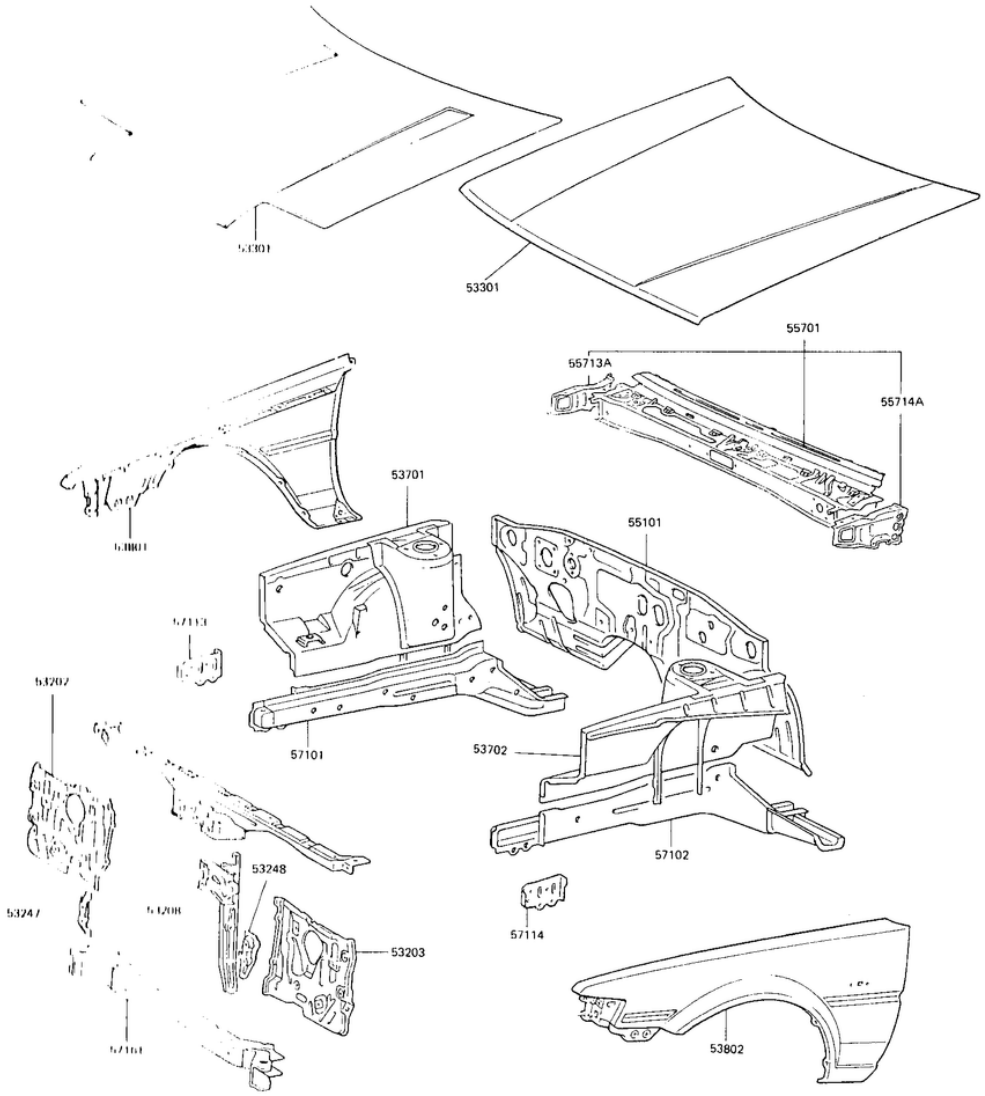
Sedan, Lift back



Code	Part Name
63102A	Windshield Header Panel Sub-Assy
63104	Roof Panel Center Reinforcement Sub-Assy
63105A	Back Door Opening Frame Sub-Assy
63111	Roof Panel
63133	Back Window Opening Upper Frame
63201A	Sliding Roof or Removal Roof Panel Sub-Assy
63203A	Sliding Roof or Removal Roof Housing Sub-Assy

Code	Part Name
64101	Upper Back Panel Sub-Assy
64401	Luggage Compartment Door Panel Sub-Assy
67003 67004	Rear Door Panel Sub-Assy
67005	Back Door Panel Sub-Assy
67113 67114	Rear Door Outer Panel
—	—

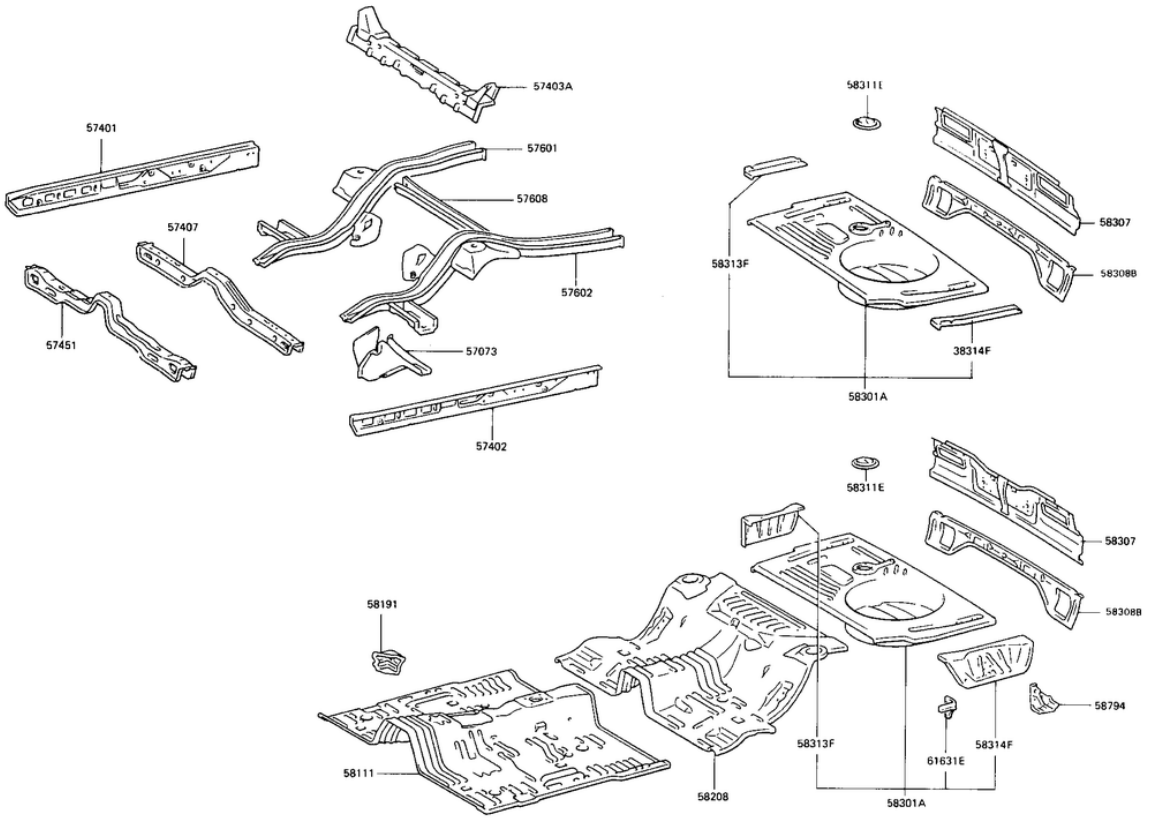
Coupe



Code	Part Name
53202 53203	Radiator Support Sub-Assy
53205	Radiator Upper Support Sub-Assy
53208A	Hood Lock Support Sub-Assy
53247 53248	Headlamp Mounting Inner Bracket (Ex. Rise-up type headlight)
53301	Hood Sub-Assy
53701 53702	Front Fender Apron Sub-Assy
53801 53802	Front Fender Sub-Assy

Code	Part Name
53802E	Front Fender To Apron Brace
55101	Dash Panel Sub-Assy
55701	Cowl Panel Sub-Assy
55713A 55704A	Cowl Top Side Panel
57101 57102	Front Side Member Sub-Assy
57161	Front Crossmember
57113 57114	Front Side Member Extension
—	—

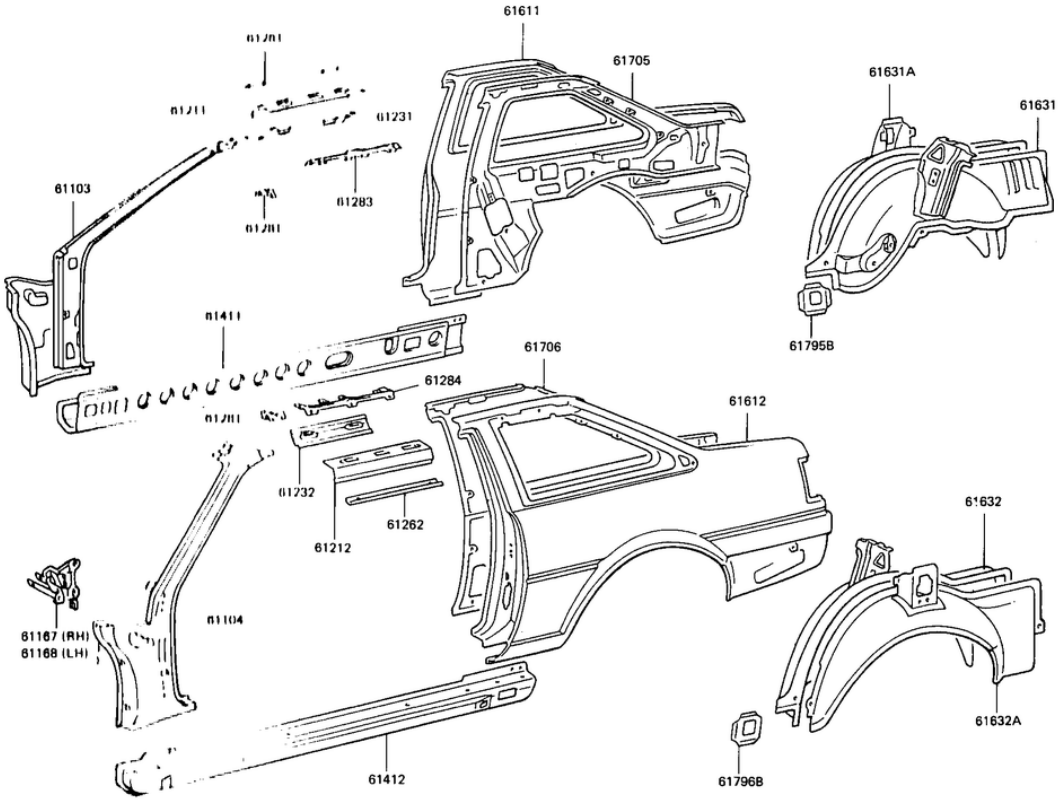
Coupe



Code	Part Name
57073	Lateral Rod Bracket Sub-Assy
57401 57402	Main Floor Side Member Sub-Assy
57407	Center Floor No.1 Crossmember Sub-Assy
57451	Front Floor Crossmember Member
57601 57602	Rear Floor Side Member Sub-Assy
57608	Rear Floor No.2 Crossmember Sub-Assy
58111	Front Floor Pan
58208	Center Floor Pan

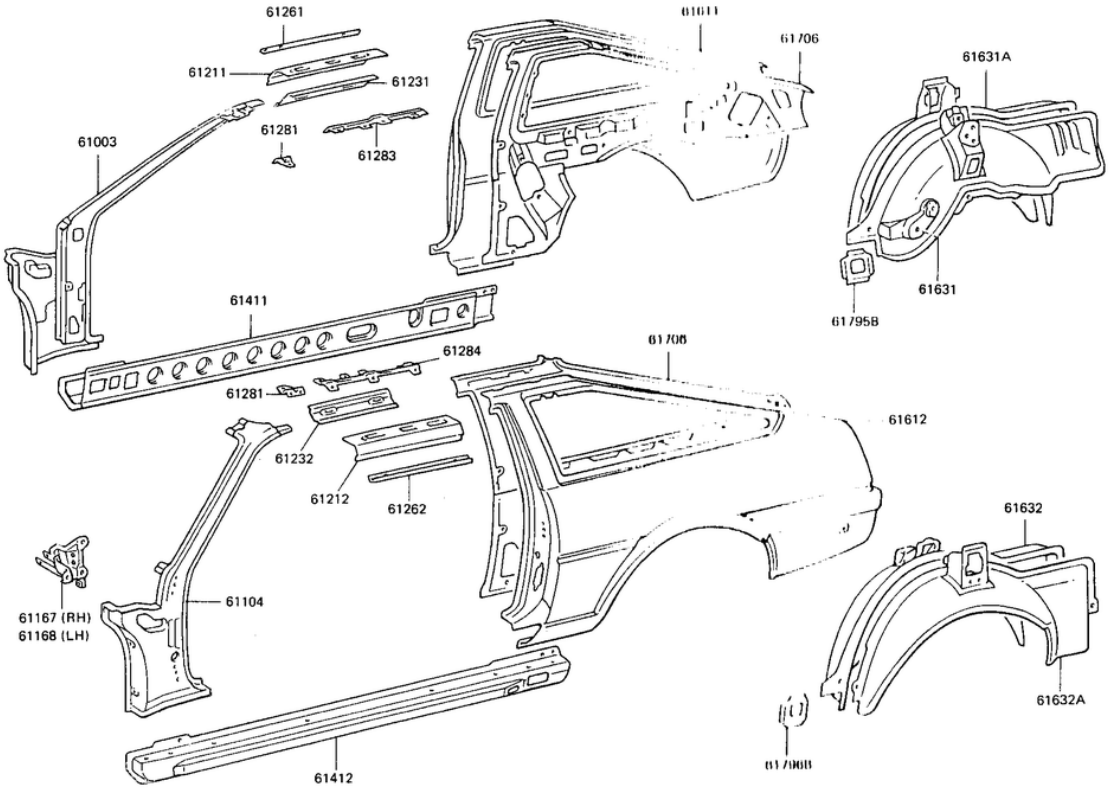
Code	Part Name
58301A	Rear Floor Panel Sub-Assy
58307	Body Lower Back Panel Sub-Assy
58308B	Body Rear Valance Panel Sub-Assy
58311E	Rear Floor Service Hole Cover
58313F 58314F	Rear Floor Pan To Quarter Panel Extension
58794	Jack Carrier
61631E	Quarter Wheel House Rear Gusset
—	—

2-Door Coupe



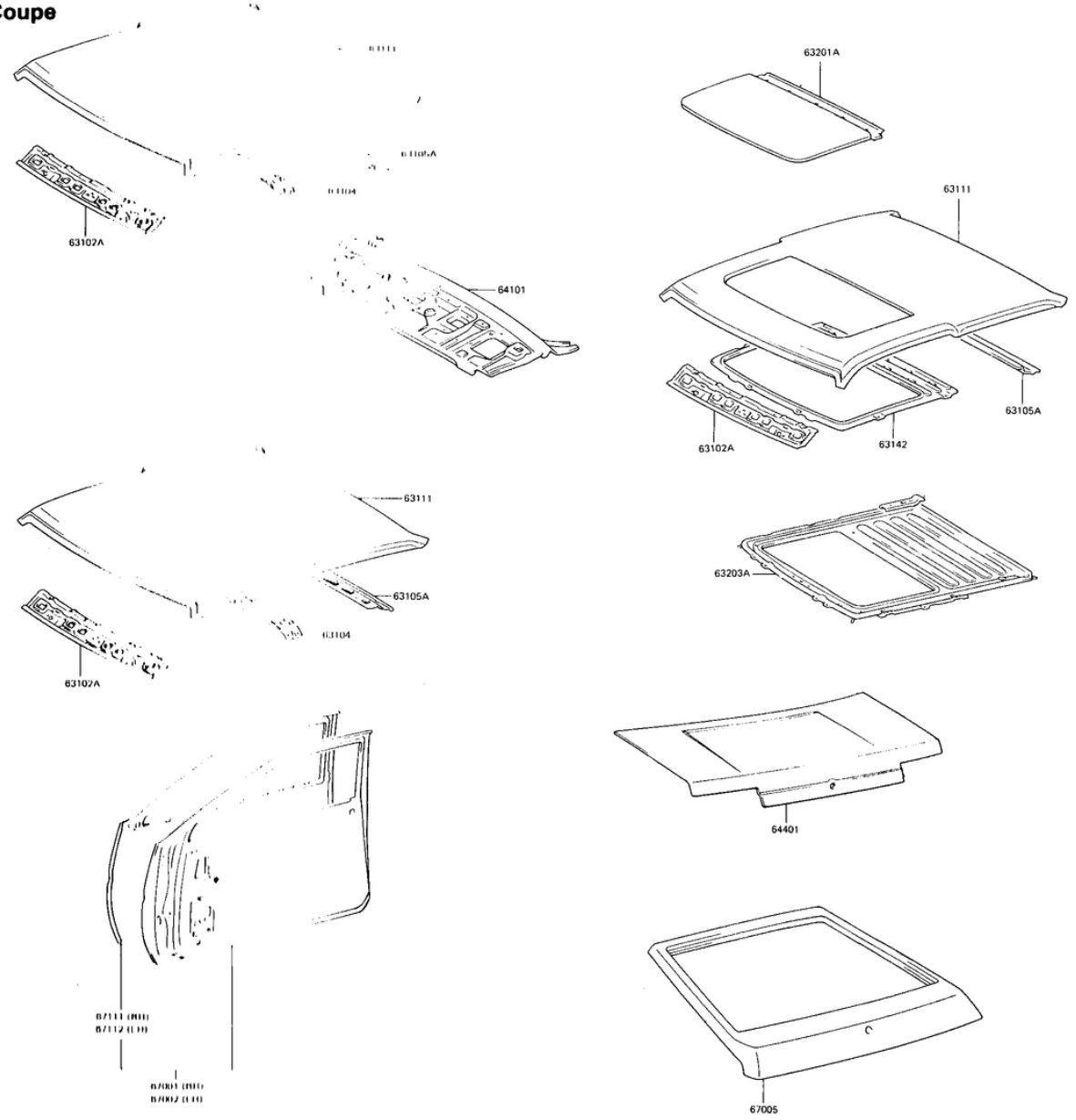
Code	Part Name	Code	Part Name
61103 61104	Front Body Pillar Sub-Assy	61411 61412	Rocker Outer Panel
61167 61168	Instrument Panel To Cowl Side Bracket	61611 61612	Quarter Panel
61211 61212	Roof Side Outer Rail	61631 61632	Quarter Wheel House Panel
61231 61232	Roof Side Inner Rail	61631A 61632A	Quarter Wheel House Outer Panel
61261 61262	Roof Drip Channel	61705 61706	Roof Side Inner Panel Sub-Assy
61281	Sliding Roof Housing Mounting No.1 Bracket (w/Sun Roof)	61795B 61796B	Quarter Wheel House Extension
61283 61284	Sliding Roof Housing Mounting No.3 Bracket (w/Sun Roof)	—	—

3-Door Coupe



Code	Part Name	Code	Part Name
61103 61104	Front Body Pillar Sub-Assy	61411 61412	Rocket Outer Panel
61167 61168	Instrument Panel To Cowl Side Bracket	61611 61612	Quarter Panel
61211 61212	Roof Side Outer Rail	61631 61632	Quarter Wheel House Panel
61231 61232	Roof Side Inner Rail	61631A 61632A	Quarter Wheel House Outer Panel
61261 61262	Roof Drip Channel	61705 61706	Roof Side Inner Panel Sub-Assy
61281	Sliding Roof Housing Mounting No.1 Bracket (w/Sun Roof)	61795B 61796B	Quarter Wheel House Extension
61283 61284	Sliding Roof Housing Mounting No.3 Bracket (w/Sun Roof)	—	—

Coupe



Code	Part Name
61102A	Windshield Header Panel Sub-Assy
63104	Roof Panel Center Reinforcement Sub-Assy
63105A	Back Door Opening Frame Sub-Assy
63111	Roof Panel
63142	Roof Panel No.2 Reinforcement
63201A	Sliding Roof or Removable Roof Panel Sub-Assy
63203A	Sliding Roof or Removable Roof Housing Sub-Assy

Code	Part Name
64101	Upper Back Panel Sub-Assy
64401	Luggage Compartment Door Panel Sub-Assy
67001 67002	Front Door Panel Sub-Assy
67005	Back Door Panel Sub-Assy
67111 67112	Front Door Outer Panel
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TOOLS AND EQUIPMENT

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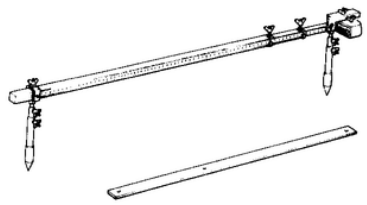
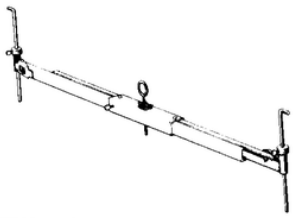
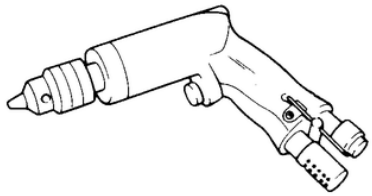
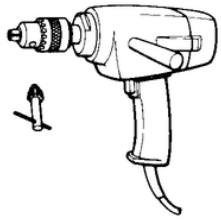
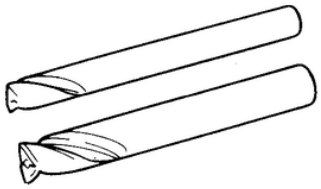
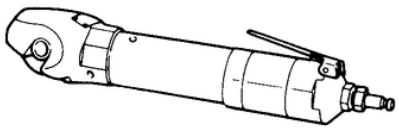
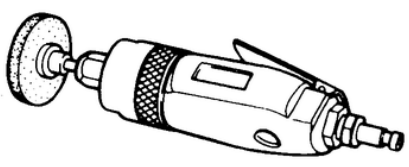
TE

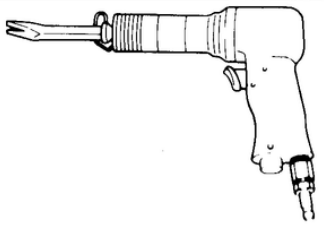
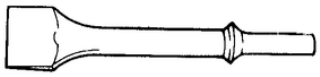
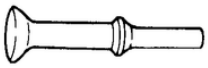
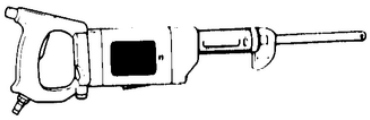
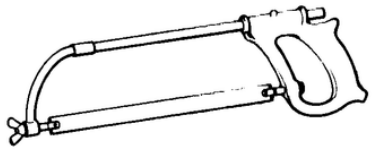
MEASURING INSTRUMENTS

	Tracking Gauge	For measuring body dimensions
	Frame Centering Gauge	When 3 or 4 are used together, measurements of twists, bends or warps in the body and frame are possible.

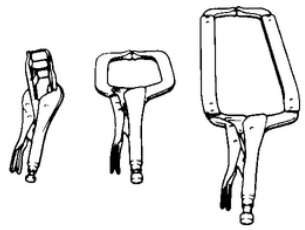
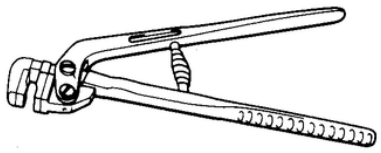
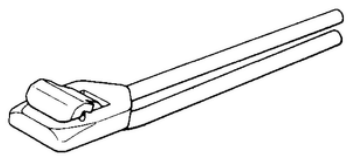
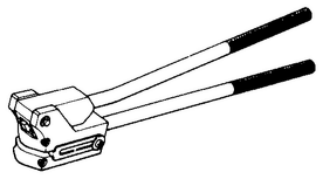
SEPARATING TOOLS

	Air-powered Drill	For separating spot welds and making holes in the body.
	Electric-powered Drill	For separating spot welds and making holes in the body
	Spot Cutter	For separating spot welds.
	Air-powered Cutter	For cutting panels.
	Air-powered Chuck Grinder	For separating spot and plug welds and grinding off traces of plug welds.

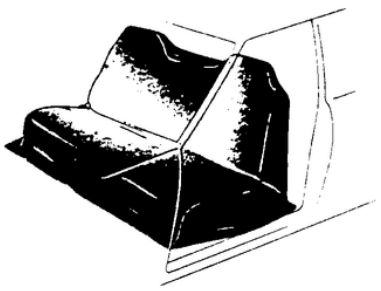
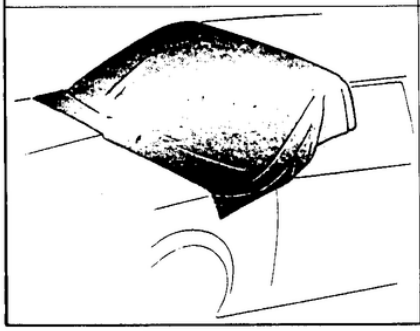
SEPARATING TOOLS (Cont'd)

	Air-powered Chisel	For rough cutting and rough flattening of panels.
	Panel Cutter	For rough cutting of panels.
	Flat Chisel	For separating spot welds.
	Hammer Tool	For rough flattening in hard-to-reach areas.
	Air-powered Saw	For rough cutting of pillars, rocker panels, etc.
	Air-powered Saw	For rough cutting of pillars, rocker panels, etc.
	Hacksaw	For rough cutting of pillars, rocker panels, etc.

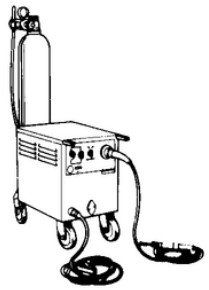
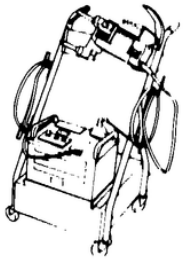
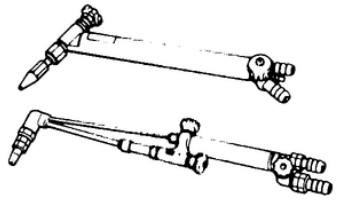
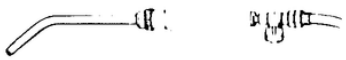
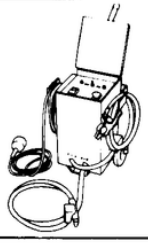
INSTALLATION ASSISTANCE TOOLS

	Vise Grip Wrench	For temporary installation of panels and holding of portions to be welded.
	Flanging Tool	For making flanges in over-lapping panels.
	Hemming Tool	For hemming door outer panels, etc.
	Hole Punch	For making holes for MIG plug welding.

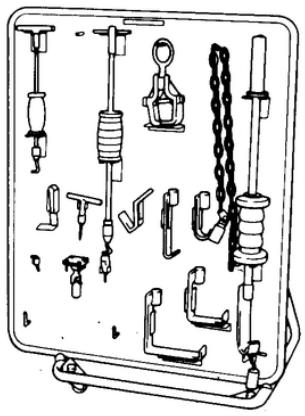
BODY PROTECTORS

	Seat Cover	For protecting the seats from welding sparks, etc.
	Glass Cover	For protecting the glass from welding sparks, etc.

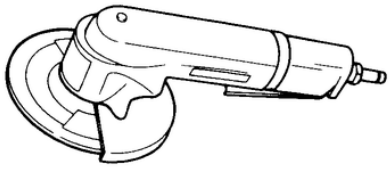
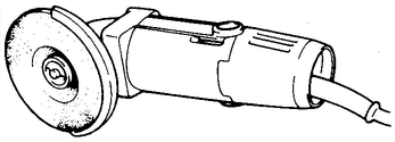
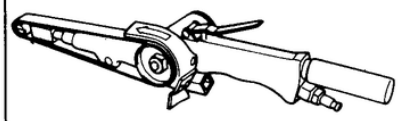
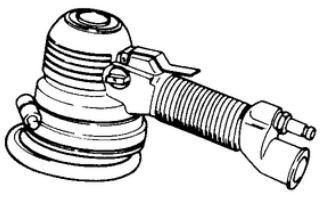
WELDING INSTRUMENTS

	MIG Welder (Metal Inert Gas)	For panel welding.
	Spot Welder	For panel welding.
	Gas Welder Torch Gas Cutter Torch	For rough cutting of panels, members, etc.
	Acetylene Gas Torch	For soldering and peeling of paint.
	Straightening Machine	For straightening distorted panels.
	Panel Extractor	For extraction of closed-in panels.

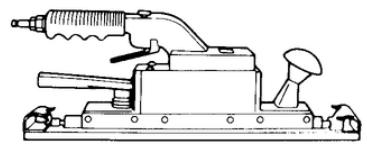
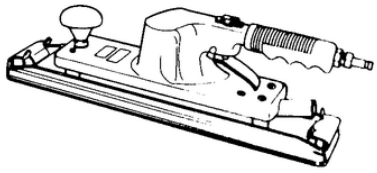
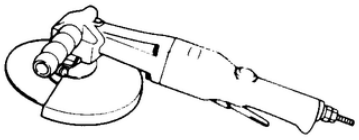
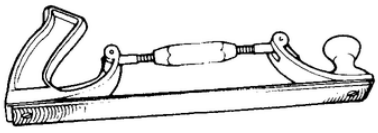
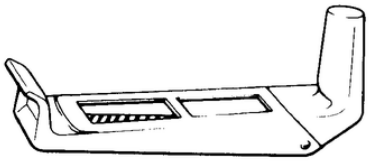
LIGHT BODY REPAIR TOOLS

	Body Pullers	For straightening lightly damaged panels.

GRINDING AND POLISHING TOOLS

	Air-powered Disc Grinder	For grinding plug welds, butt welds and door hems.
	Electric-powered Disc Sander	For grinding plug welds, butt welds and door hems.
	Belt Sander	For removing paint around weld areas.
	Double-action Sander	For rough grinding and polishing, and feather edging.

GRINDING AND POLISHING TOOLS (Cont'd)

	Straight-line Sander	For rough polishing of panel putty.
	Air-powered Orbital Sander	For removing putty over a wide area, resurfacing and refinishing.
	Air-powered Disc Sander	For peeling paint.
	File Holder	For paint removal.
	Flexible File Holder	For correction of soldering spots and resurfacing of panels.
	Surform Tool	For rough finishing of panels.

— MEMO —

Prepared by

TOYOTA MOTOR CORPORATION

Overseas Service Department

Haruhi Center

First Issue: September 6, 1983

Publication No. 36434E

Printed in Japan