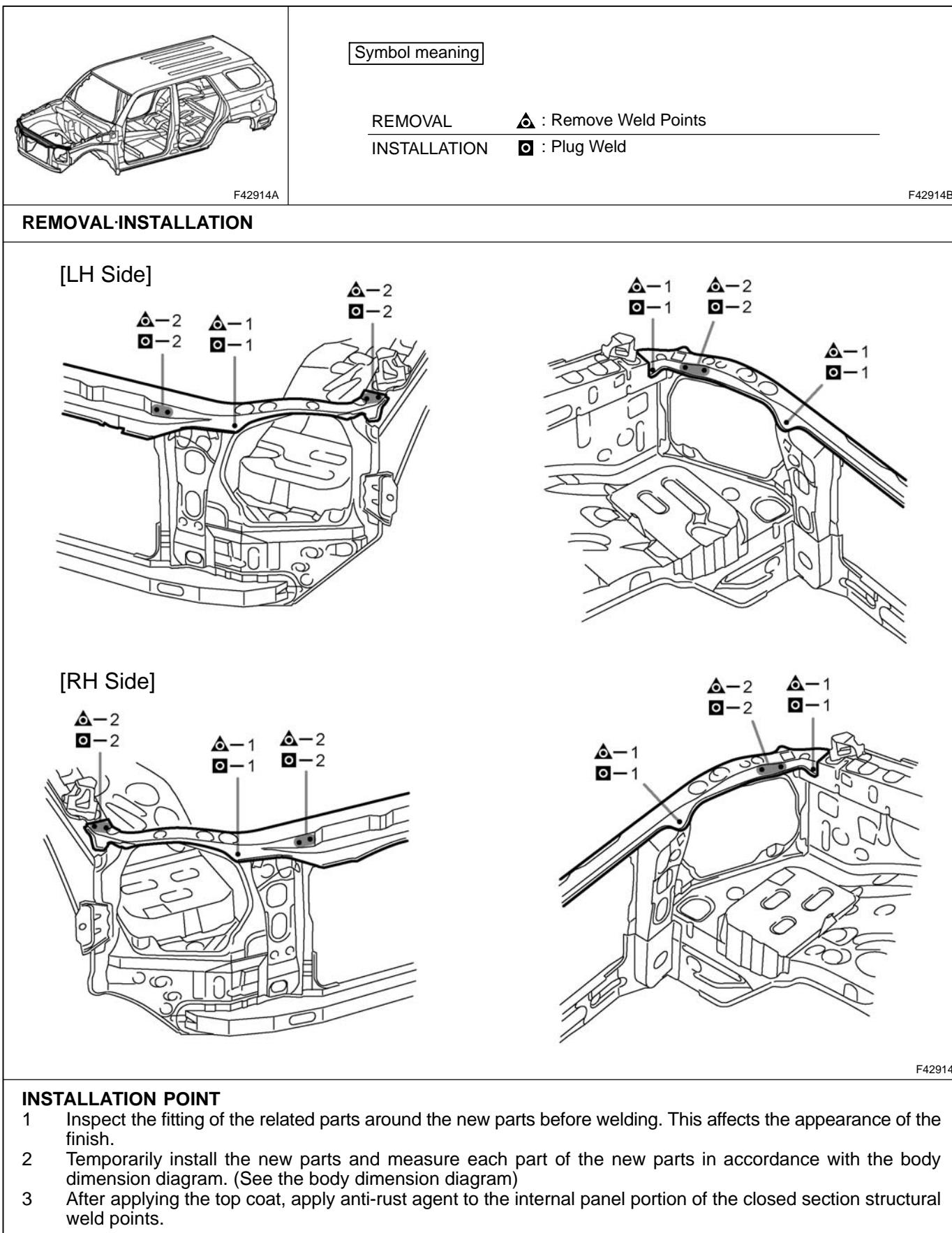
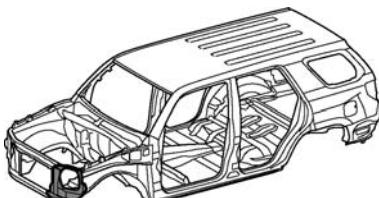
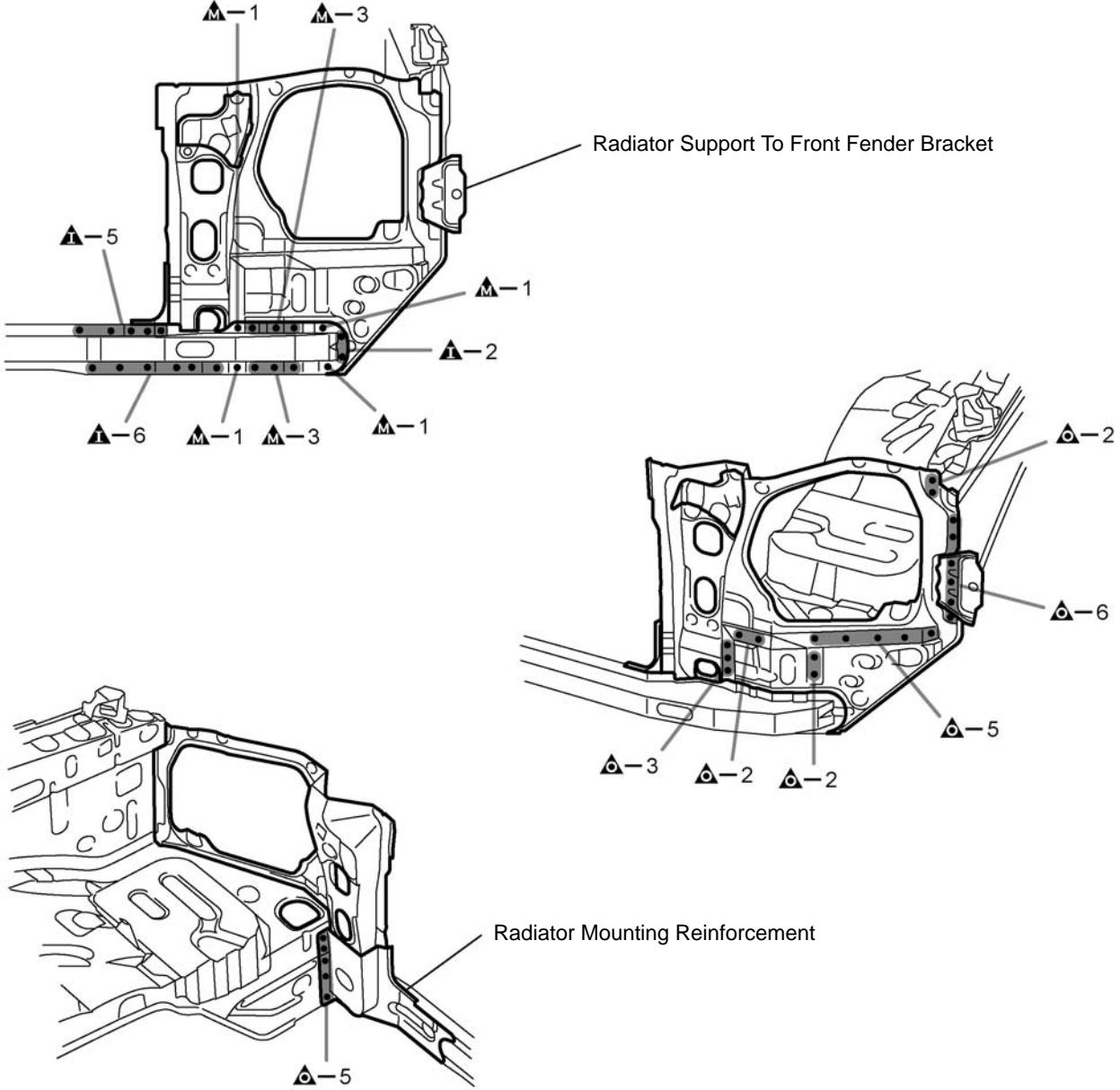


RADIATOR UPPER SUPPORT (ASSY)



RADIATOR SIDE SUPPORT (ASSY)

 F42915A	<p>With the radiator upper support removed.</p> <p>Symbol meaning</p> <p>▲ M ▲ : Remove Weld Points</p> <p>F42915B</p>
<p>REMOVAL</p>  <p>Radiator Support To Front Fender Bracket</p> <p>Radiator Mounting Reinforcement</p>	
<p>REMOVAL POINT</p> <p>1 Remove the radiator support to front fender bracket and radiator mounting reinforcement at the same time.</p>	

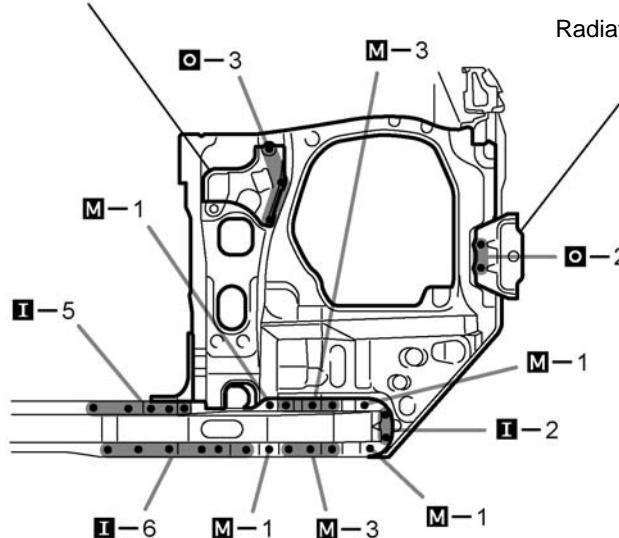
Symbol meaning

○ M I : Plug Weld

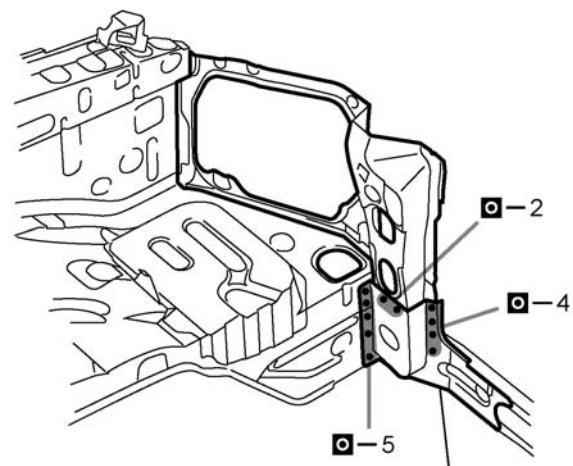
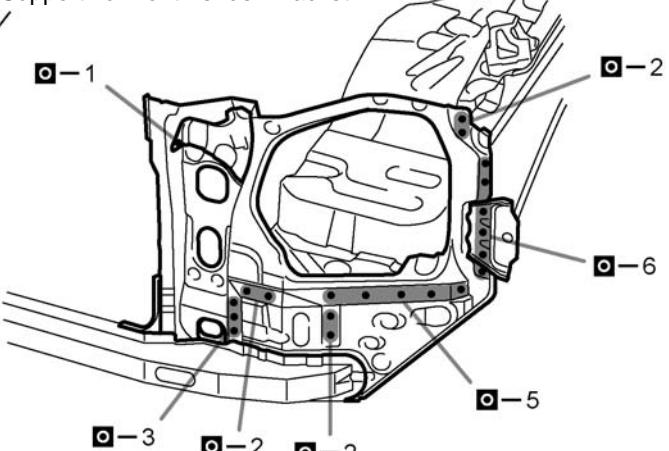
F42916B

INSTALLATION

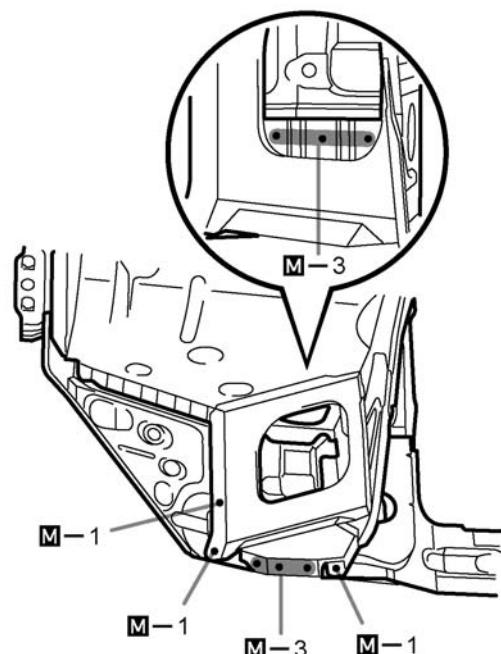
Front Body Mounting No. 2 Reinforcement



Radiator Support To Front Fender Bracket



Radiator Mounting Reinforcement

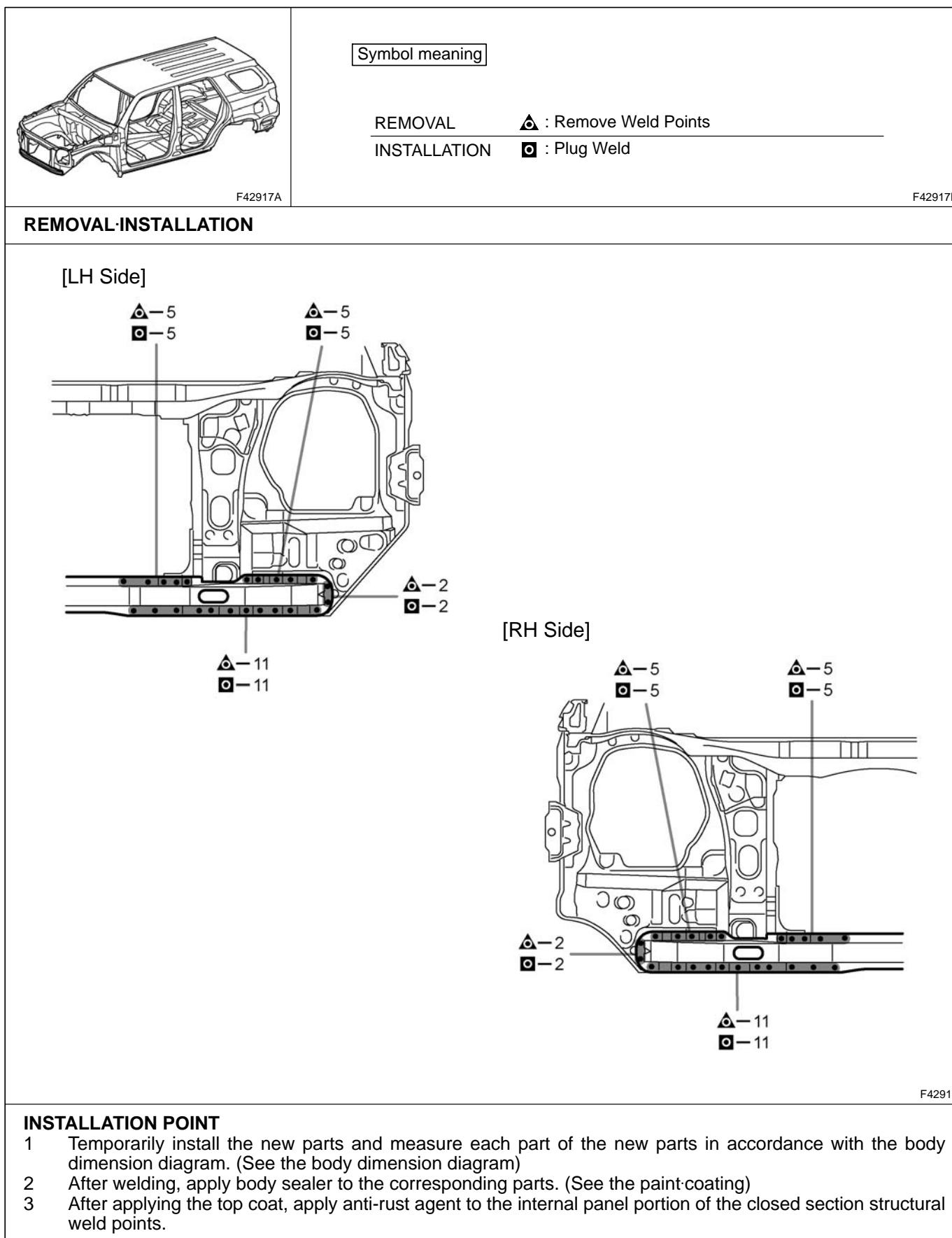


F42916

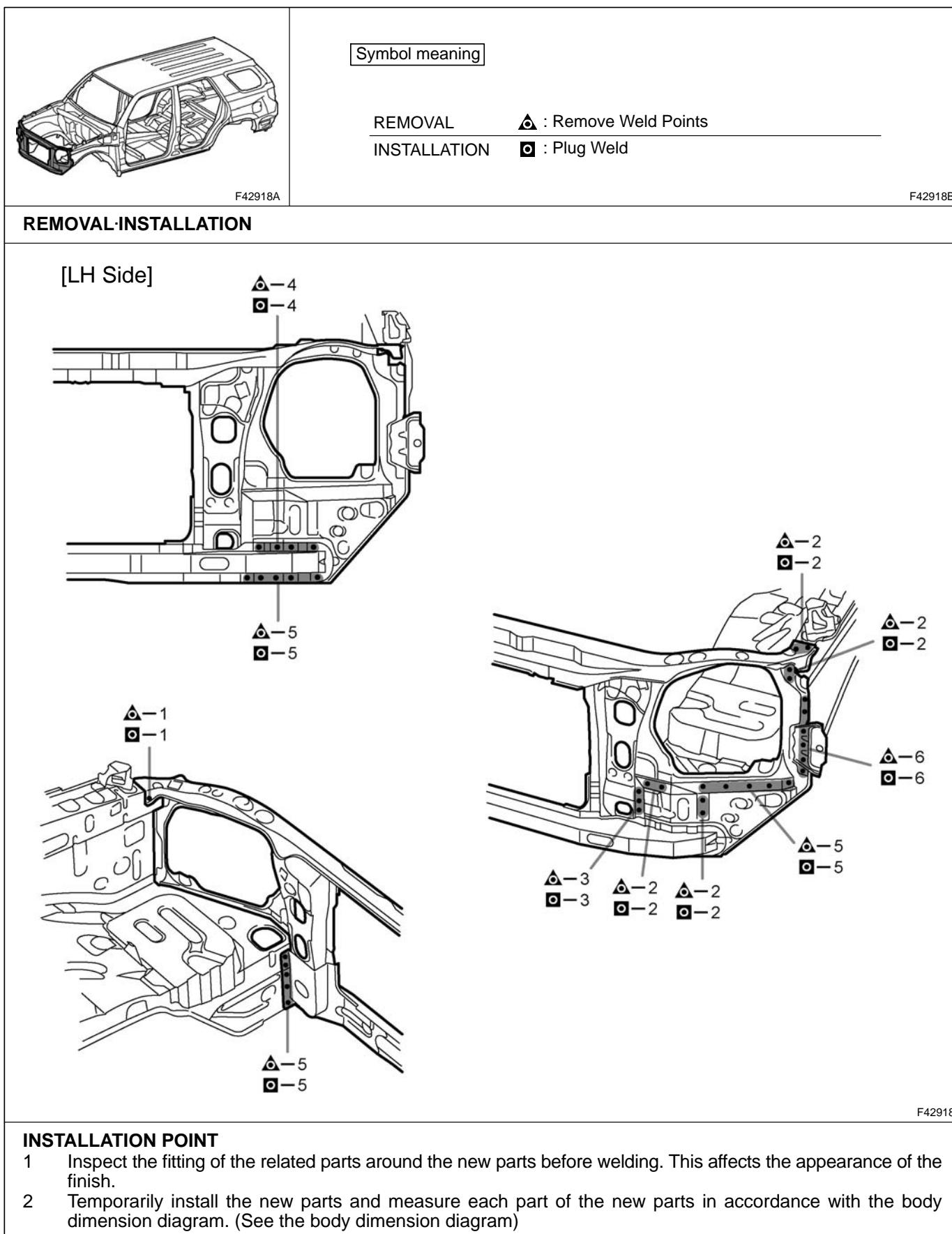
INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 After welding, apply body sealer to the corresponding parts. (See the paint-coating)
- 4 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

FRONT CROSMEMBER (ASSY)



RADIATOR SUPPORT (ASSY)



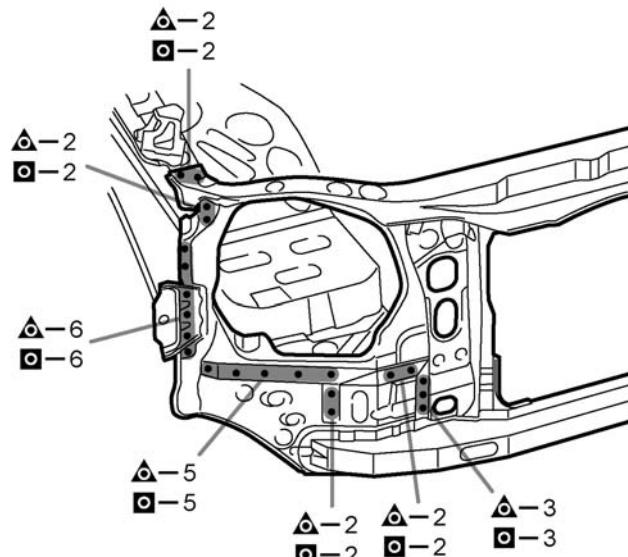
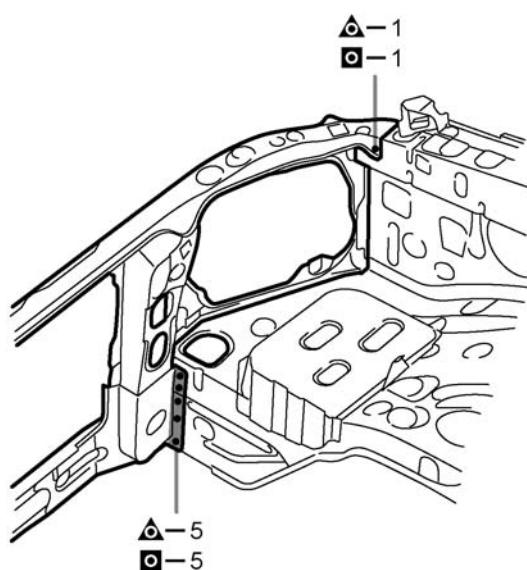
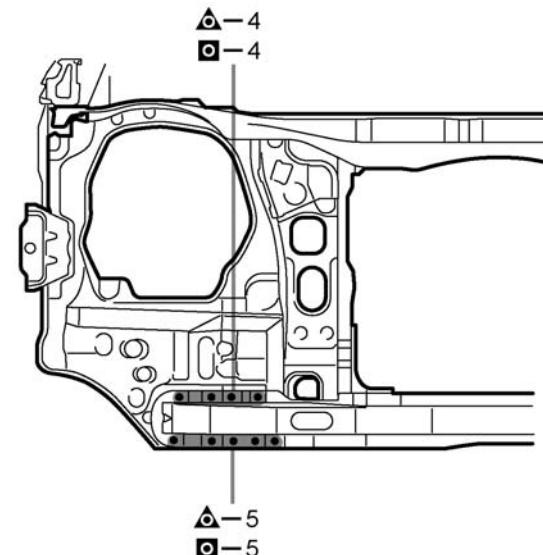
Symbol meaning

REMOVAL : Remove Weld Points

INSTALLATION : Plug Weld

F42919B

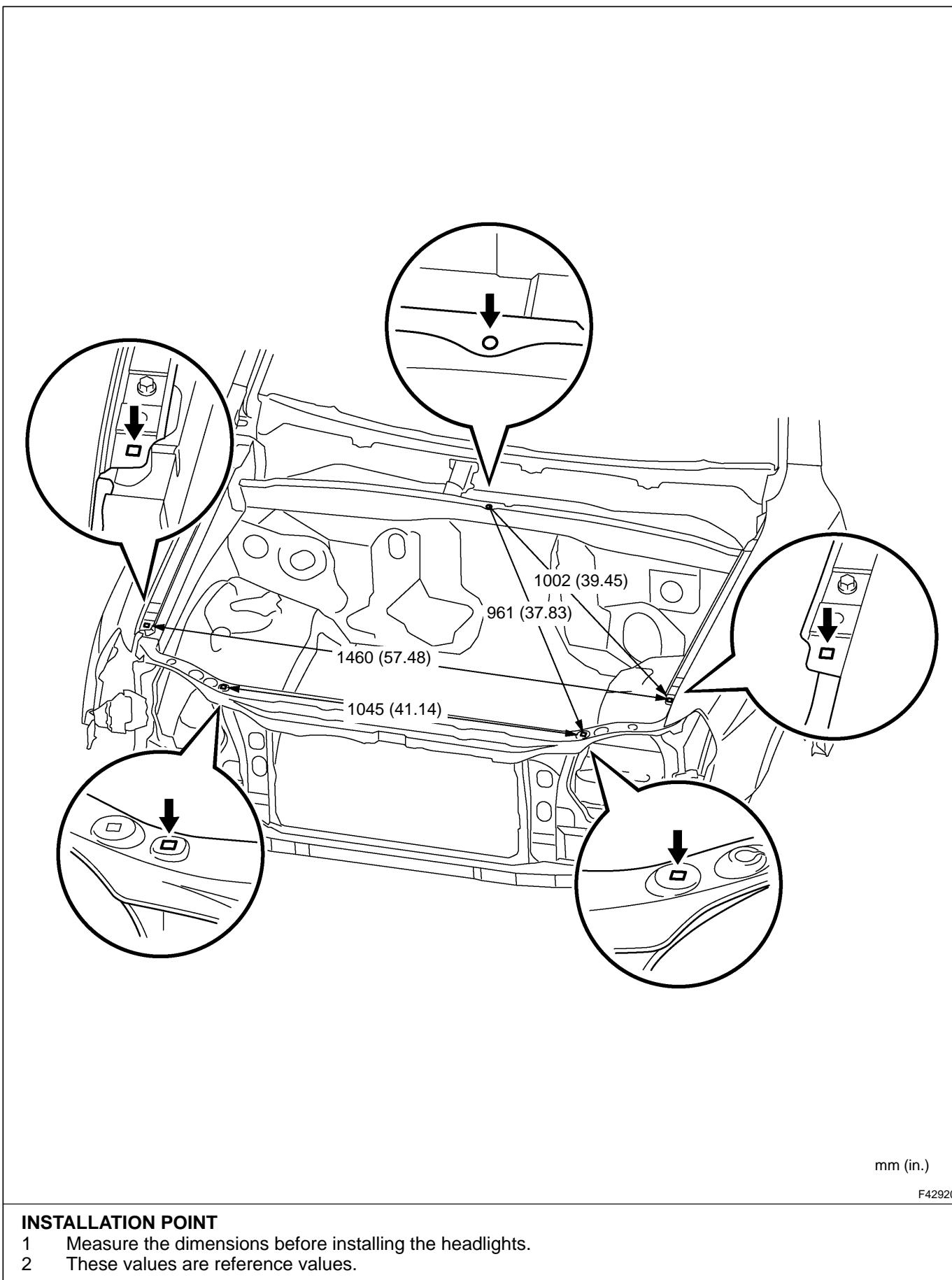
[RH Side]



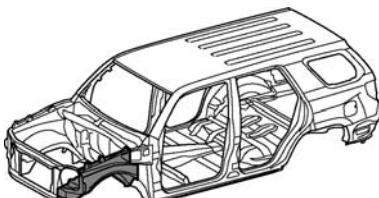
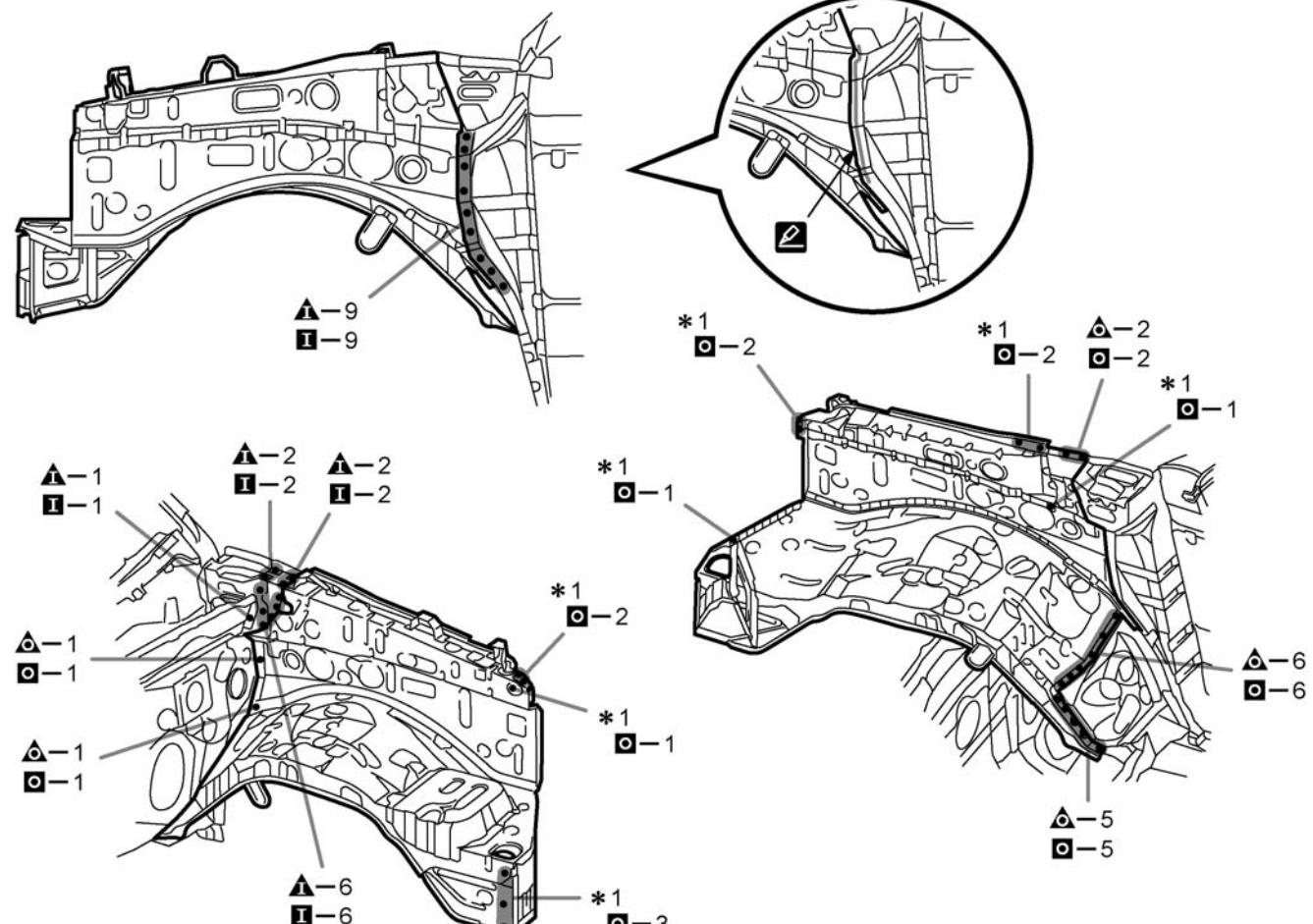
F42919

INSTALLATION POINT

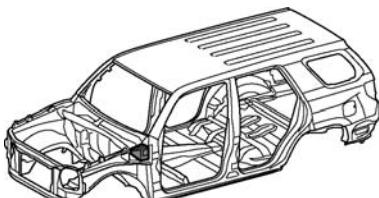
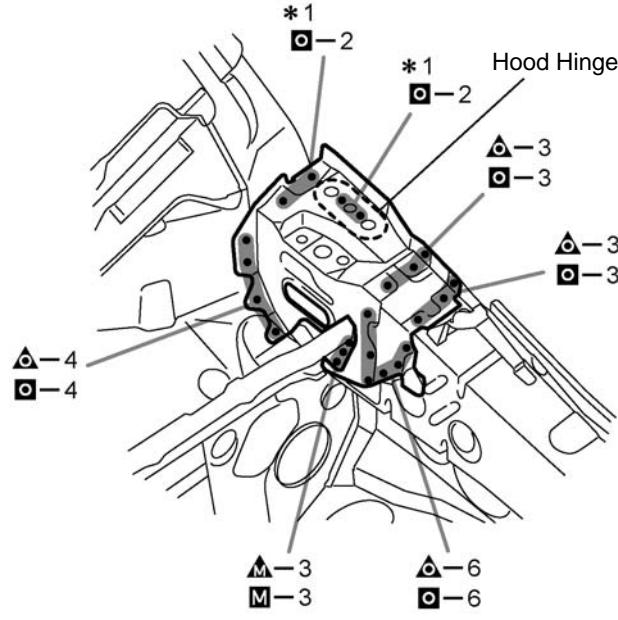
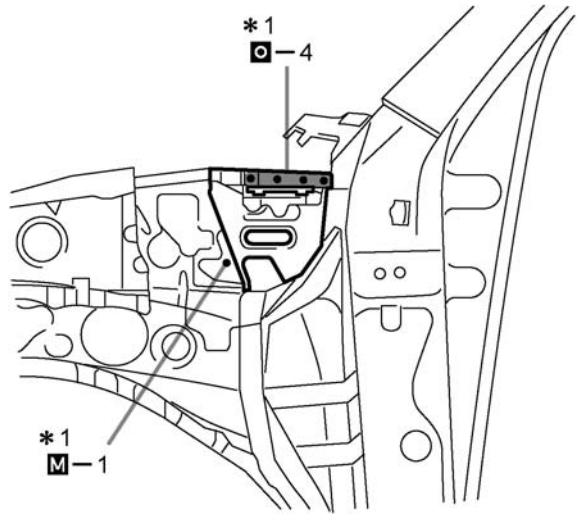
- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 After welding, apply body sealer to the corresponding parts. (See the paint-coating)
- 4 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.



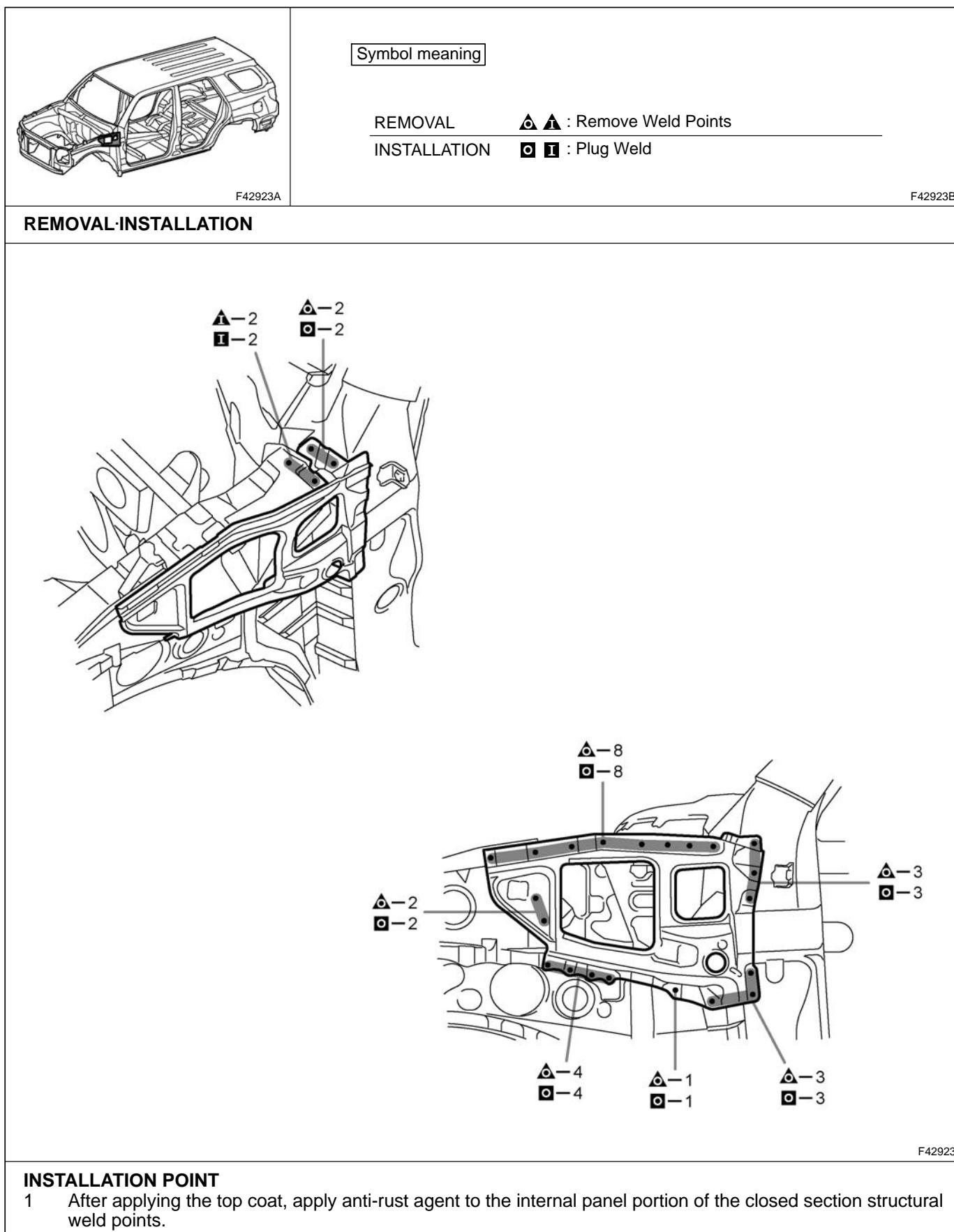
FRONT FENDER APRON (ASSY)

 F42921A	<p>With the radiator support and front body pillar lower gusset removed.</p> <p>Symbol meaning</p> <table border="0"> <tr> <td>REMOVAL</td><td> : Remove Weld Points</td></tr> <tr> <td>INSTALLATION</td><td> : Plug Weld : Body Sealer</td></tr> </table>	REMOVAL	: Remove Weld Points	INSTALLATION	: Plug Weld : Body Sealer
REMOVAL	: Remove Weld Points				
INSTALLATION	: Plug Weld : Body Sealer				
REMOVAL·INSTALLATION					
 F42921					
<p>INSTALLATION POINT</p> <ol style="list-style-type: none"> 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish. 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram) 3 *1 is only for installation. 4 Before installing a new part, apply body sealer. <p><i>HINT:</i> <i>Apply body sealer in an even, continuous bead.</i></p> <ol style="list-style-type: none"> 5 After welding, apply body sealer and undercoating to the corresponding parts. (See the paint-coating) 6 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points. 					

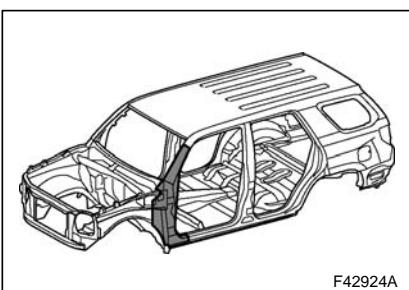
COWL TOP SIDE PANEL (ASSY)

 F42922A	<p>With the front body pillar lower gusset removed.</p> <p>Symbol meaning</p> <table border="0"> <tr> <td>REMOVAL</td><td>  : Remove Weld Points</td></tr> <tr> <td>INSTALLATION</td><td>  : Plug Weld</td></tr> </table>	REMOVAL	  : Remove Weld Points	INSTALLATION	  : Plug Weld
REMOVAL	  : Remove Weld Points				
INSTALLATION	  : Plug Weld				
REMOVAL-INSTALLATION					
 	F42922				
INSTALLATION POINT <ol style="list-style-type: none"> Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish. Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram) *1 is only for installation. After welding, apply body sealer to the corresponding parts. (See the paint-coating) After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points. 					

FRONT BODY PILLAR LOWER GUSSET (ASSY)



FRONT BODY PILLAR (CUT)



Weld work for 980 MPa ultra high strength steel

- 1 **Follow the welding conditions below when welding ultra high strength steel to assure sufficient weld strength. (When repairing this model)**

*1: When welding 2 panels together including 980 MPa ultra high strength steel.

Spot weld	Pressure	2940 N (300 kgf, 661 lbf)
	Weld current	10000 A
	Weld time	18 Cyc. (0.30 Sec.)
Plug weld	Plug diameter	10 mm (0.39 in.)
	Wire type	AWS A5.18 ER70S-3
	Shield gas	Metal active gas

*2: When welding more than 3 panels together including 980 MPa ultra high strength steel.
(When plug welding a panel to the welded panels with the weld condition above.)

Plug weld	Plug diameter	Same as the standard method (See the introduction)
	Wire type	AWS A5.18 ER70S-3
	Shield gas	Metal active gas

HINT:

*Be sure to use Metal active gas (Ar 80% + CO₂ 20%) as the shield gas when plug welding.
Sufficient weld strength cannot be assured when using 100% CO₂ shield gas.*

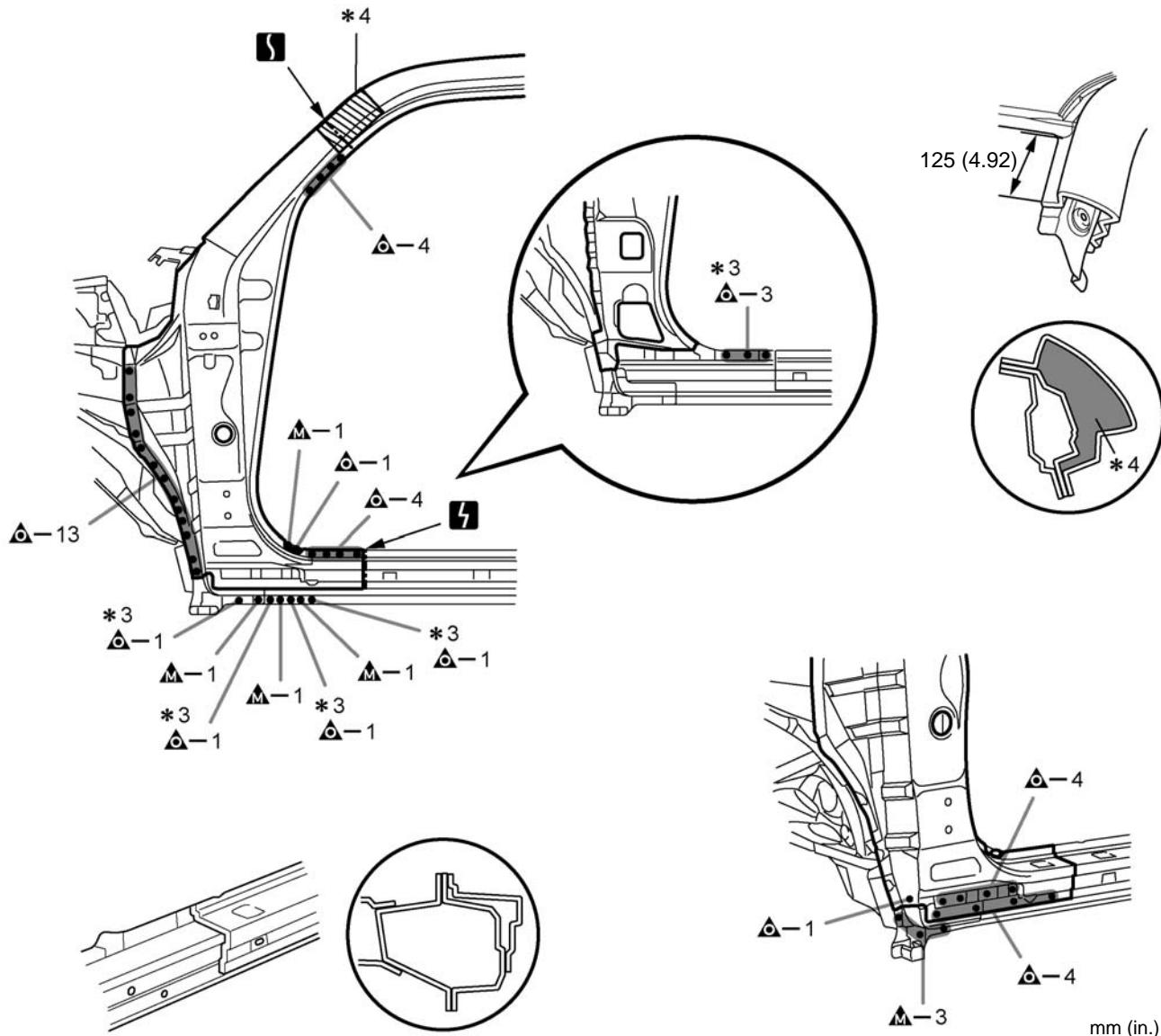
With the cowl top side panel removed.

Symbol meaning

▲ M ▲ : Remove Weld Points S : Cut and Join Location L : Cut Location for Supply Parts

F42924B

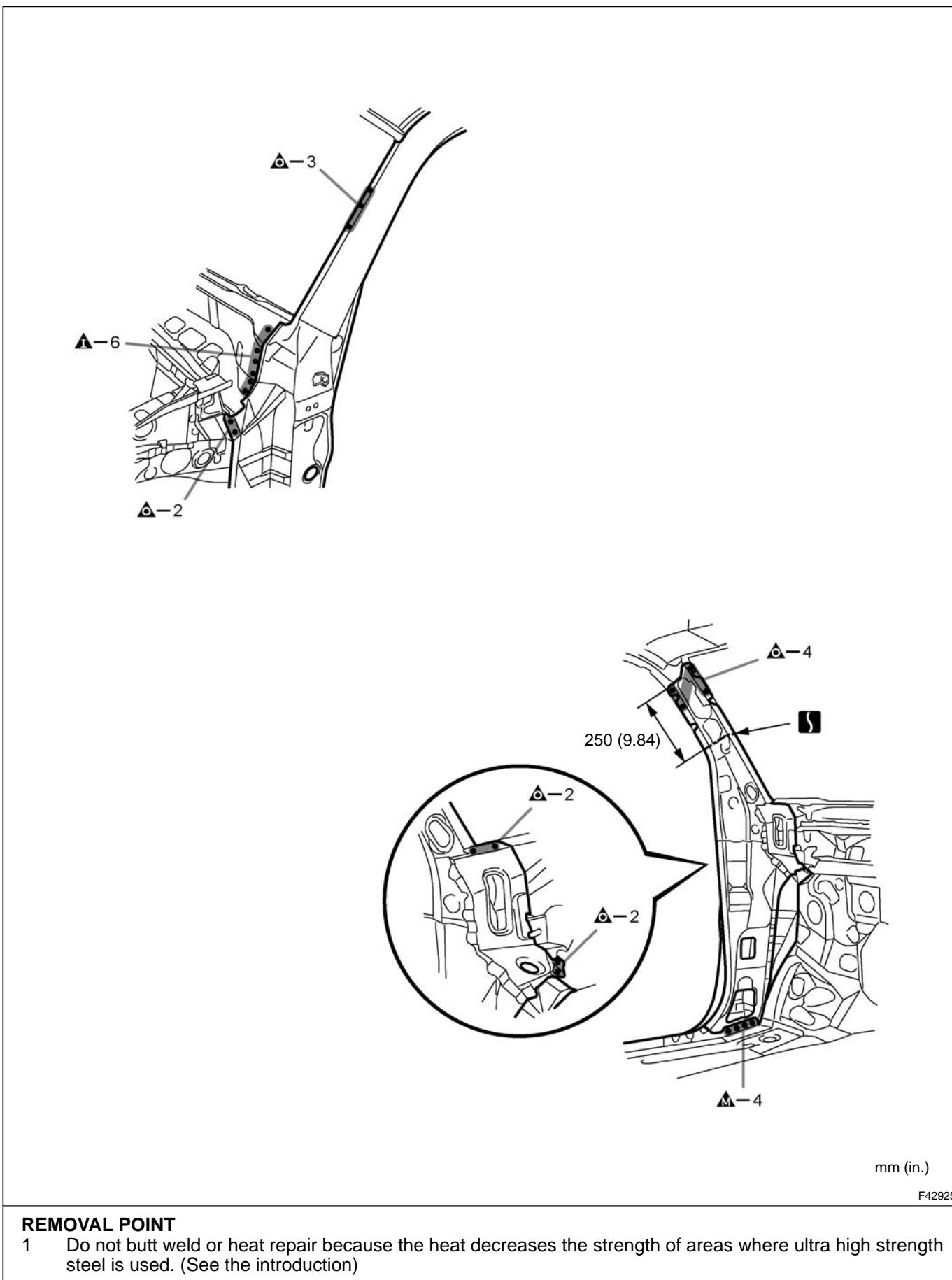
REMOVAL



F42924

REMOVAL POINT

- 1 Do not butt weld or heat repair because the heat decreases the strength of areas where ultra high strength steel is used. (See the introduction)
- 2 *3 indicates welds to remove for easier removal.
- 3 *4 indicates the location of the foamed sealing material. Be careful when cutting as the foamed sealing material is located near the cutting position.
- 4 Remove the remaining foamed sealing material from the vehicles side.

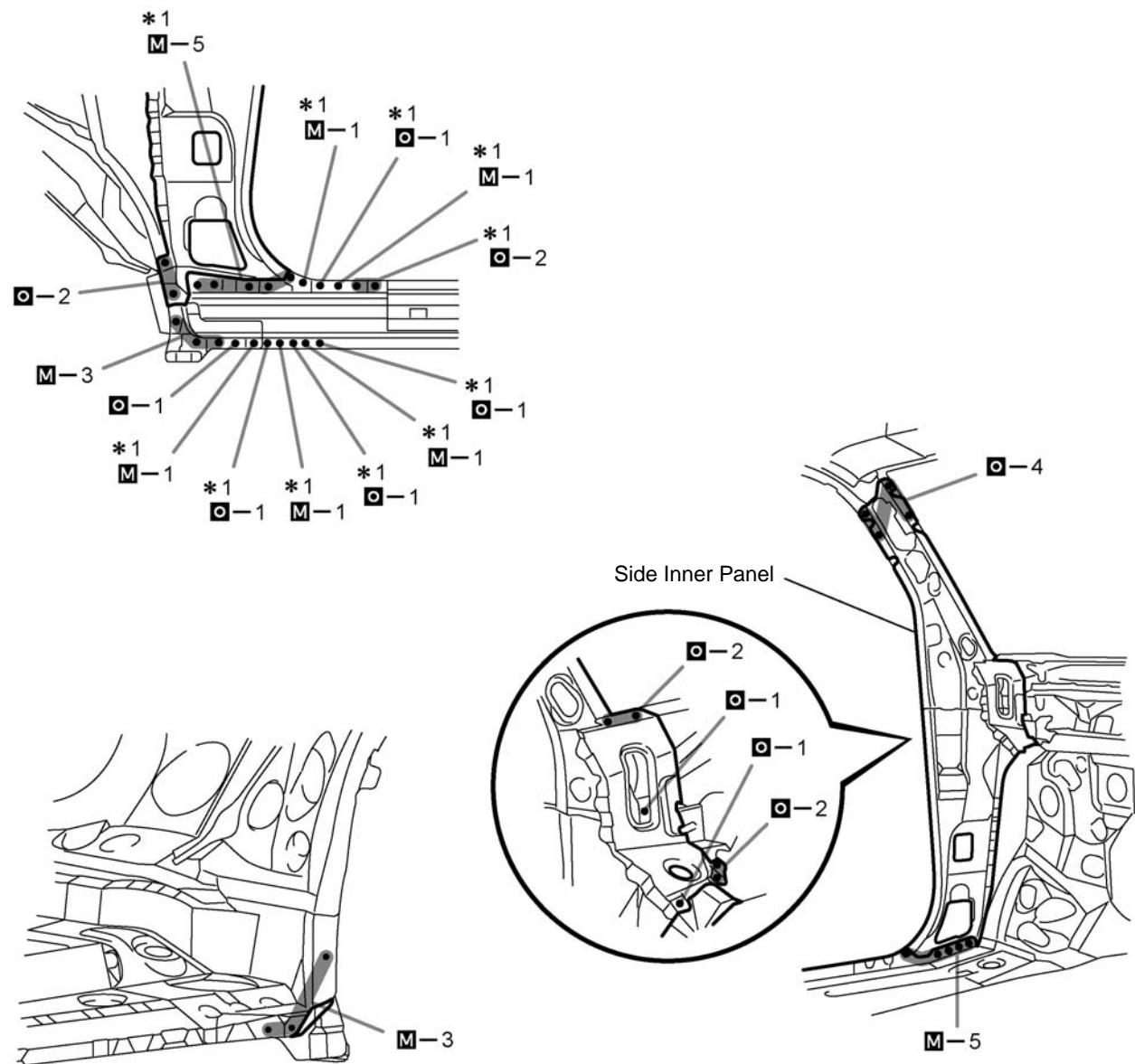


Symbol meaning

■ M I : Plug Weld  : Butt Weld  : Body Sealer

F42926B

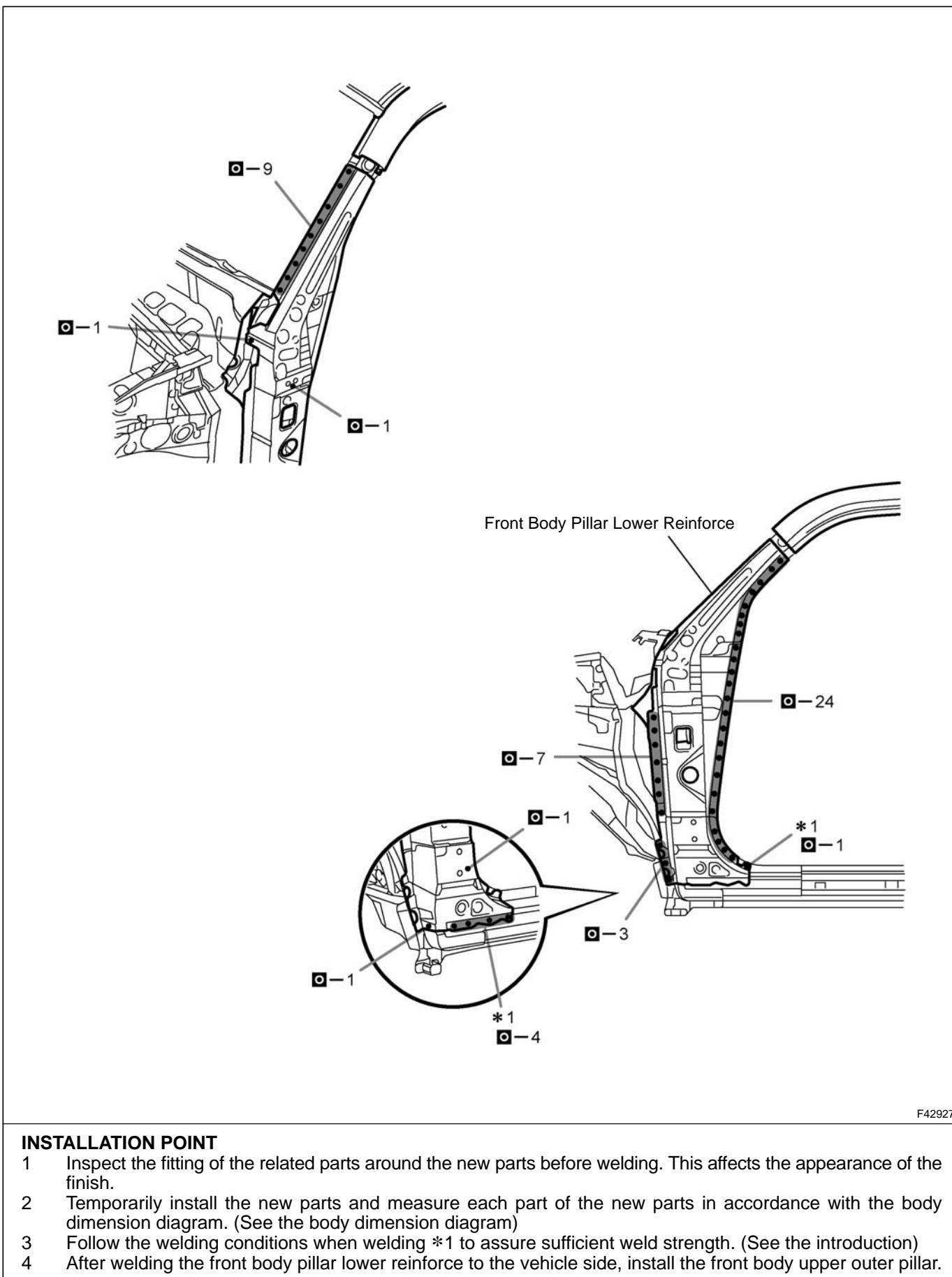
INSTALLATION

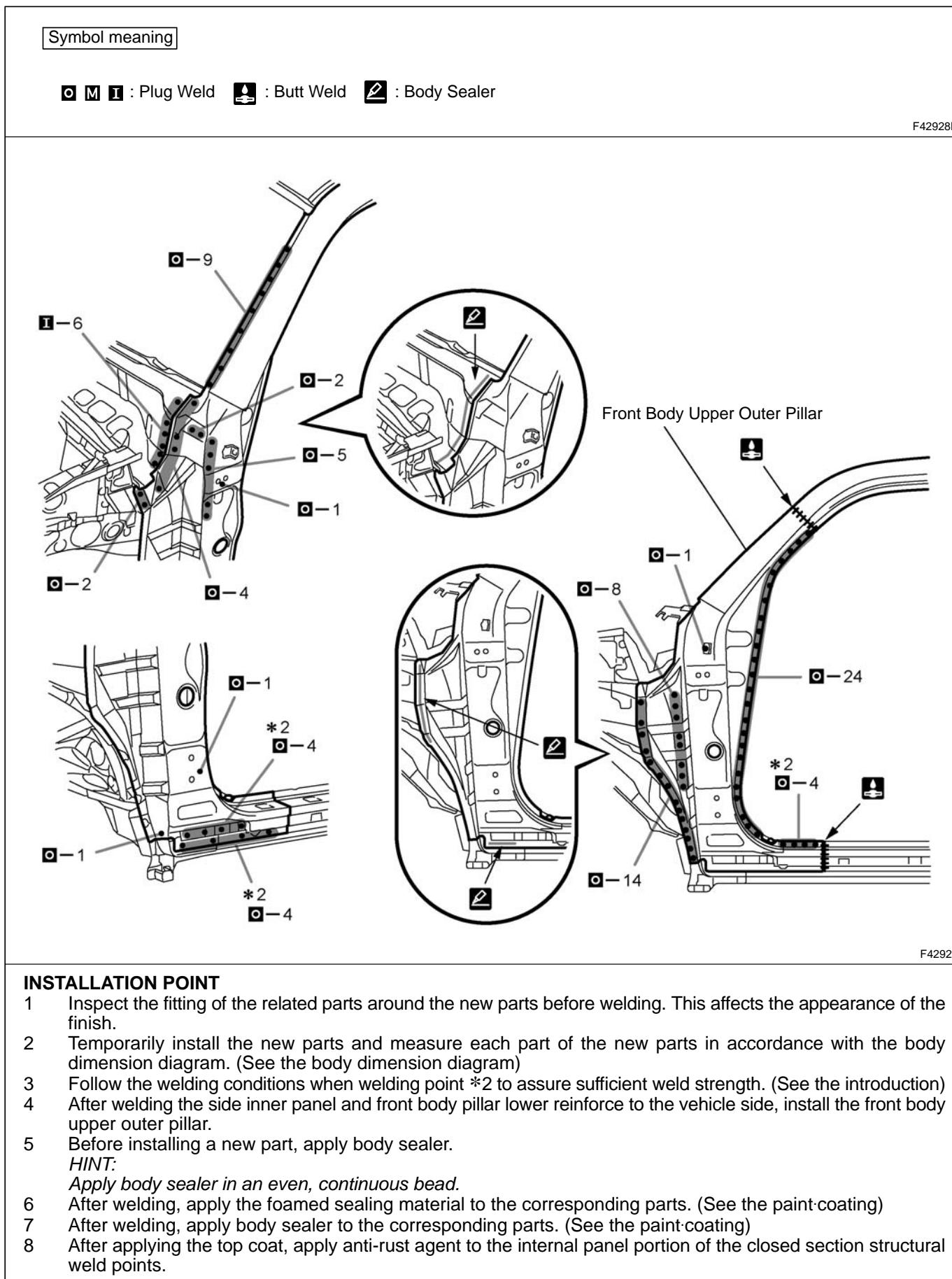


F42926

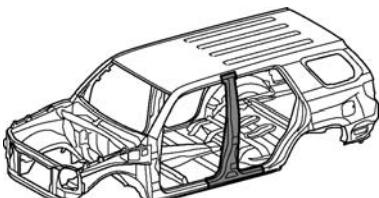
INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 Follow the welding conditions when welding point *1 to assure sufficient weld strength. (See the introduction)
- 4 After welding the side inner panel to the vehicle side, install the front body pillar lower reinforce.





CENTER BODY PILLAR (CUT)

 F42929A	Weld work for 980 MPa ultra high strength steel														
1 Follow the welding conditions below when welding ultra high strength steel to assure sufficient weld strength. (When repairing this model)															
*1: When welding 2 panels together including 980 MPa ultra high strength steel.															
<table border="1"><tr><td rowspan="3">Spot weld</td><td>Pressure</td><td>2940 N (300 kgf, 661 lbf)</td></tr><tr><td>Weld current</td><td>10000 A</td></tr><tr><td>Weld time</td><td>18 Cyc. (0.30 Sec.)</td></tr><tr><td rowspan="3">Plug weld</td><td>Plug diameter</td><td>10 mm (0.39 in.)</td></tr><tr><td>Wire type</td><td>AWS A5.18 ER70S-3</td></tr><tr><td>Shield gas</td><td>Metal active gas</td></tr></table>		Spot weld	Pressure	2940 N (300 kgf, 661 lbf)	Weld current	10000 A	Weld time	18 Cyc. (0.30 Sec.)	Plug weld	Plug diameter	10 mm (0.39 in.)	Wire type	AWS A5.18 ER70S-3	Shield gas	Metal active gas
Spot weld	Pressure		2940 N (300 kgf, 661 lbf)												
	Weld current		10000 A												
	Weld time	18 Cyc. (0.30 Sec.)													
Plug weld	Plug diameter	10 mm (0.39 in.)													
	Wire type	AWS A5.18 ER70S-3													
	Shield gas	Metal active gas													
*2: When welding more than 3 panels together including 980 MPa ultra high strength steel. (When plug welding a panel to the welded panels with the weld condition above.)															
<table border="1"><tr><td rowspan="3">Plug weld</td><td>Plug diameter</td><td>Same as the standard method (See the introduction)</td></tr><tr><td>Wire type</td><td>AWS A5.18 ER70S-3</td></tr><tr><td>Shield gas</td><td>Metal active gas</td></tr></table>		Plug weld	Plug diameter	Same as the standard method (See the introduction)	Wire type	AWS A5.18 ER70S-3	Shield gas	Metal active gas							
Plug weld	Plug diameter		Same as the standard method (See the introduction)												
	Wire type		AWS A5.18 ER70S-3												
	Shield gas	Metal active gas													
<i>HINT:</i> <i>Be sure to use Metal active gas (Ar 80% + CO₂ 20%) as the shield gas when plug welding. Sufficient weld strength cannot be assured when using 100% CO₂ shield gas.</i>															

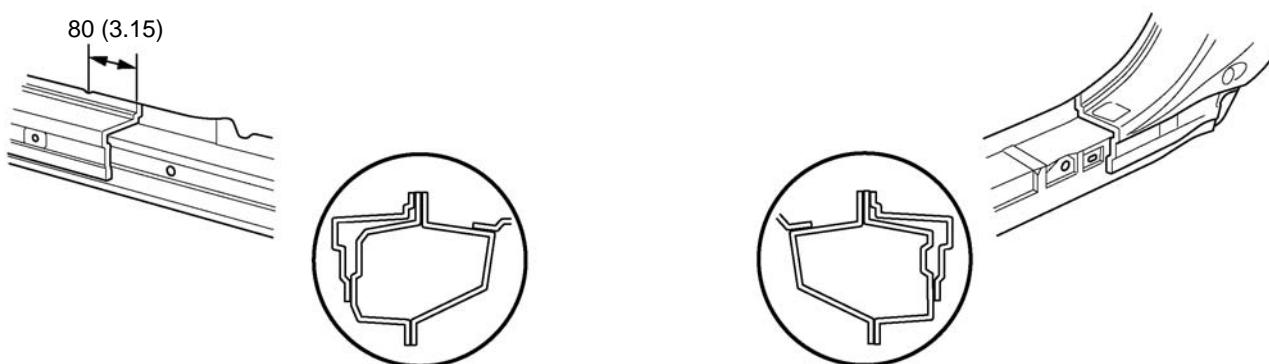
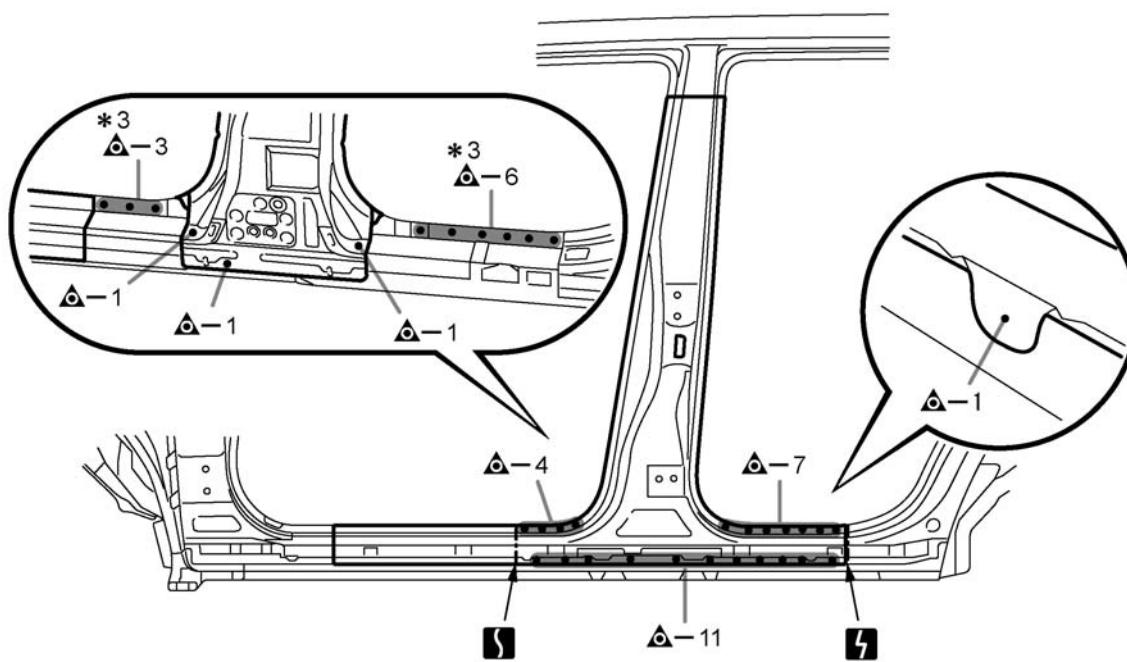
Symbol meaning

: Remove Weld Points : Cut with Disc Sander etc. : Cut and Join Location

: Cut Location for Supply Parts

F42929B

REMOVAL

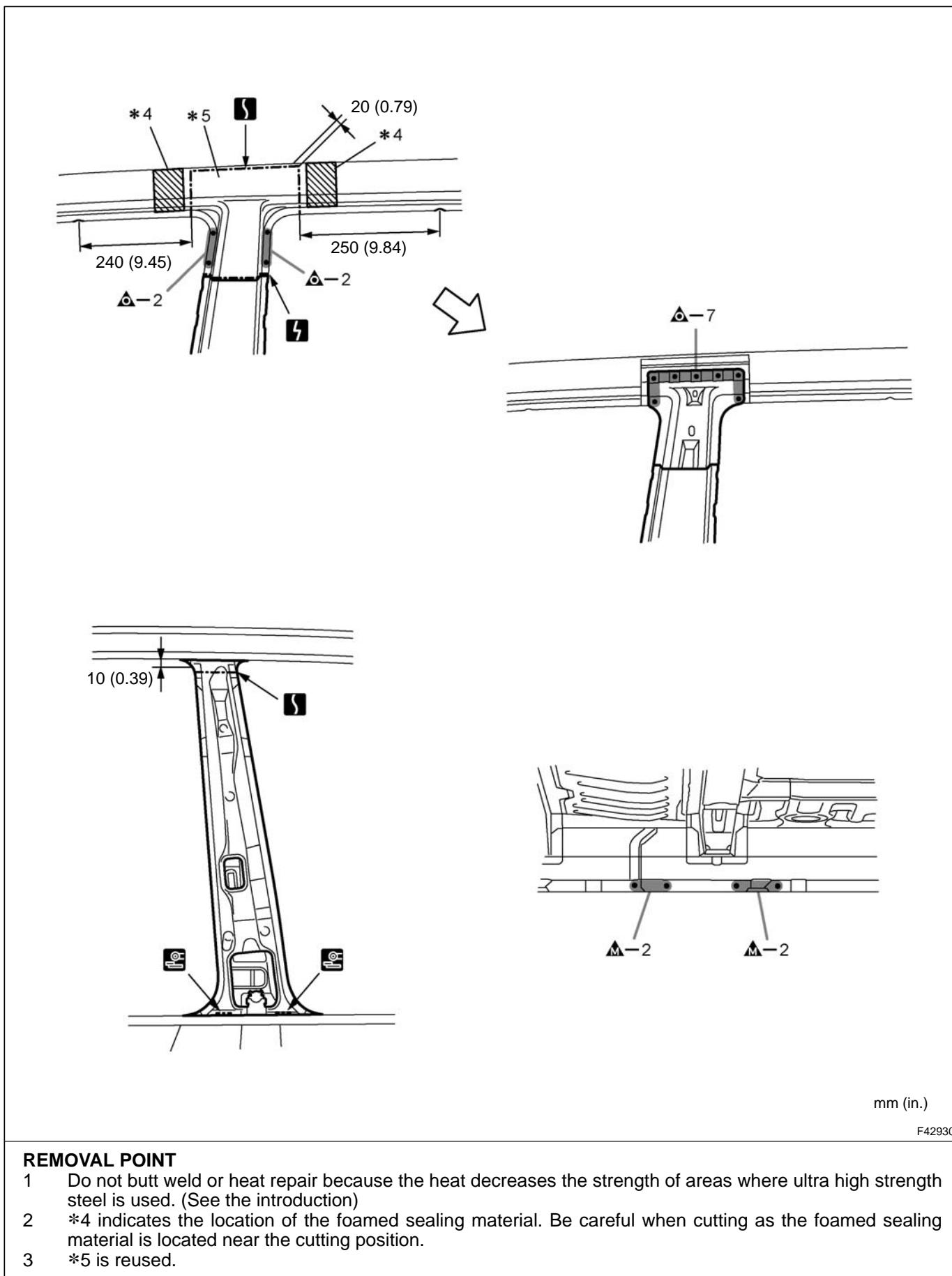


mm (in.)

F42929

REMOVAL POINT

- 1 Do not butt weld or heat repair because the heat decreases the strength of areas where ultra high strength steel is used. (See the introduction)
- 2 *3 indicates welds to remove for easier removal.

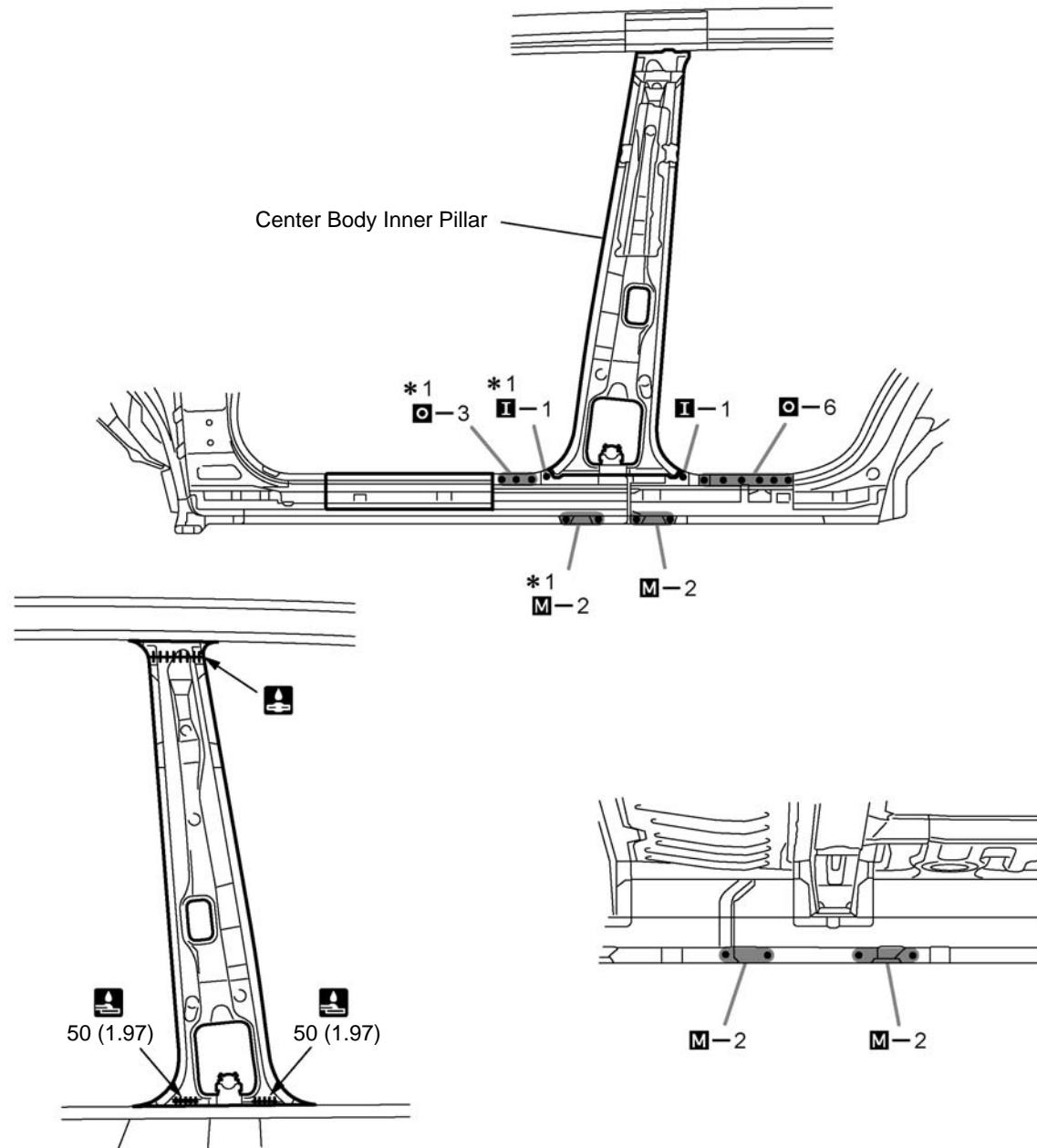


Symbol meaning

○ M I : Plug Weld  : Fillet Weld  : Butt Weld

F42931B

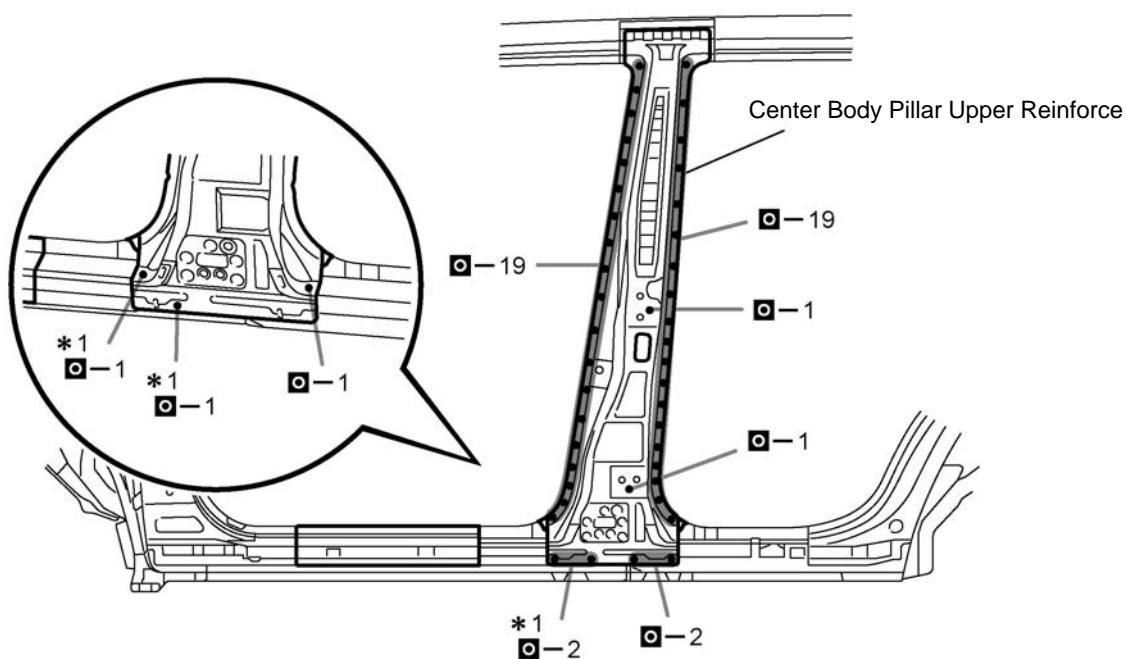
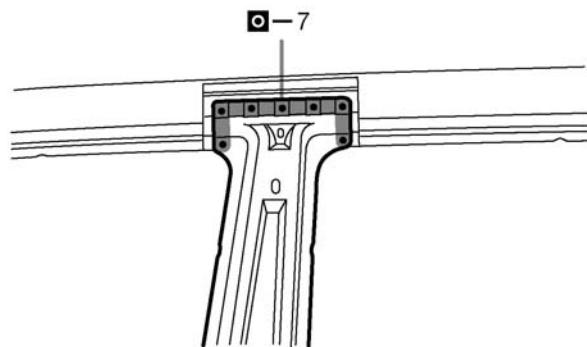
INSTALLATION



F42931

INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 Follow the welding conditions when welding point *1 to assure sufficient weld strength. (See the introduction)
- 4 After welding the center body inner pillar to the vehicle side, install the center body pillar upper reinforce.



F42932

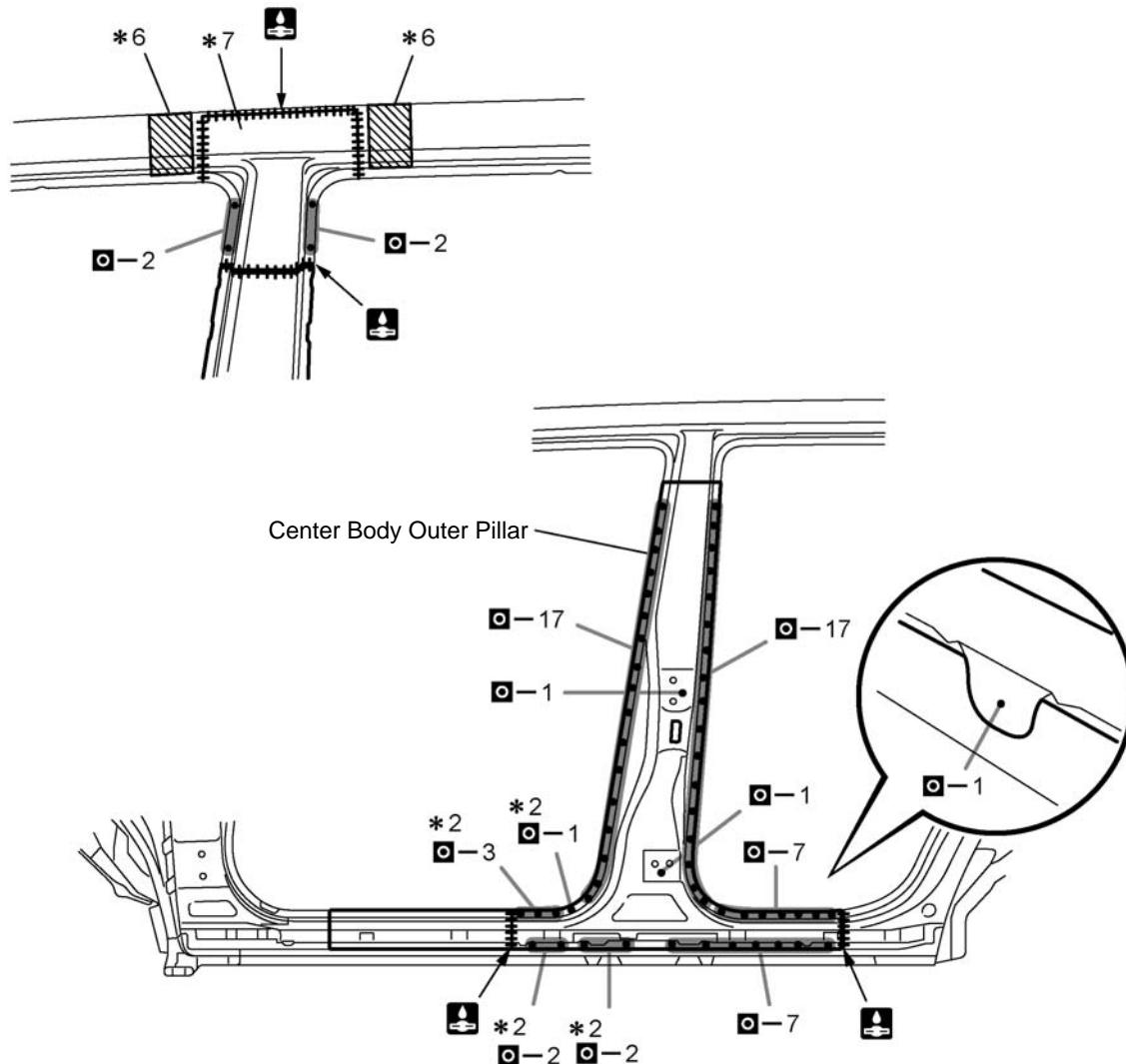
INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 Follow the welding conditions when welding point *1 to assure sufficient weld strength. (See the introduction)
- 4 After welding the center body pillar upper reinforce to the vehicle side, install the center body outer pillar.

Symbol meaning

□ M I : Plug Weld  : Fillet Weld  : Butt Weld

F42931B

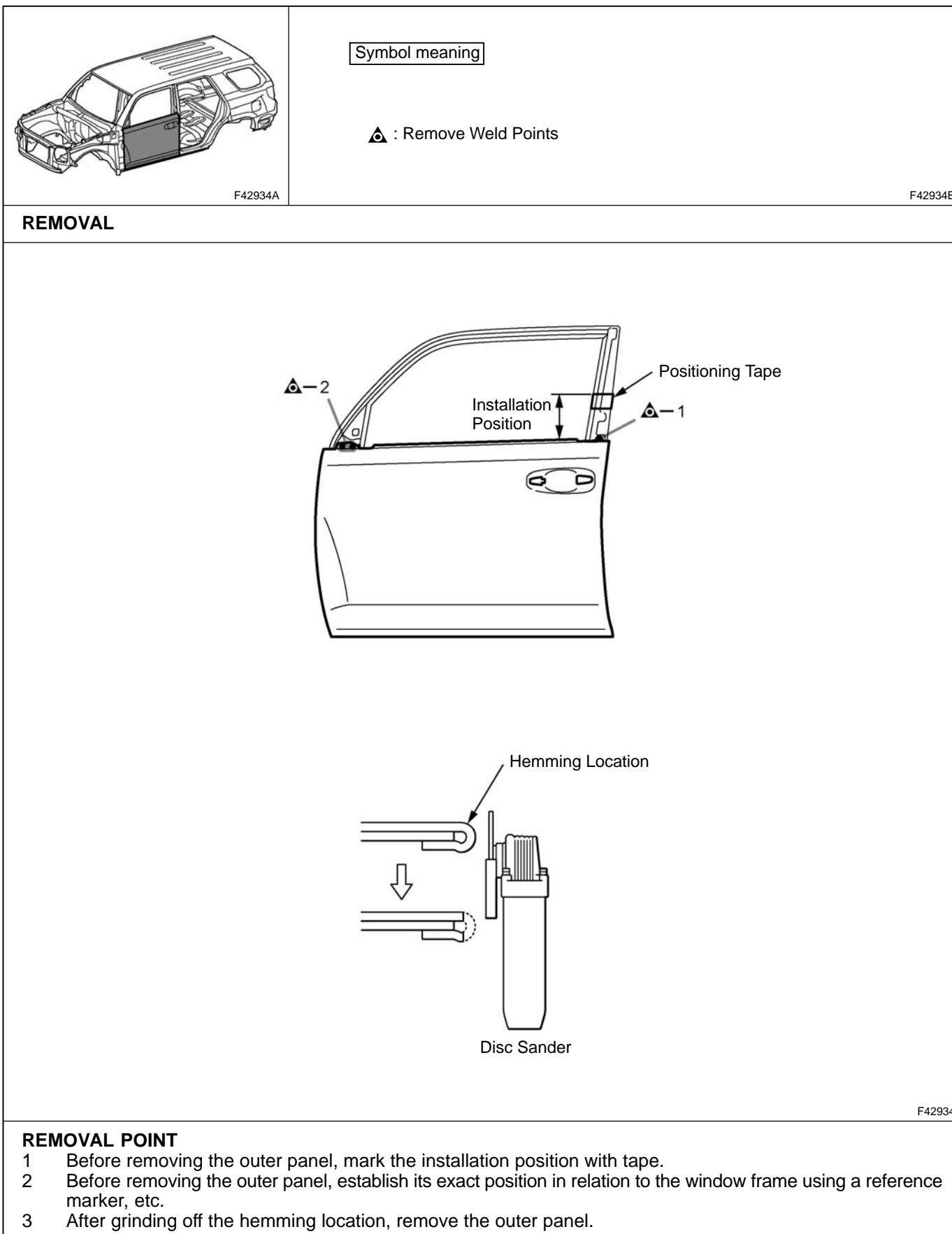


F42933

INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 Follow the welding conditions when welding point *2 to assure sufficient weld strength. (See the introduction)
- 4 *6 indicates the location of the foamed sealing material. Be careful when welding as the foamed sealing material is located near the area that is cut and joined together.
- 5 After welding the center body inner pillar and center body pillar upper reinforce to the vehicle side, install the center body outer pillar and *7.
- 6 After welding, apply the foamed sealing material to the corresponding parts. (See the paint-coating)
- 7 After welding, apply body sealer to the corresponding parts. (See the paint-coating)
- 8 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

FRONT DOOR OUTER PANEL (ASSY)

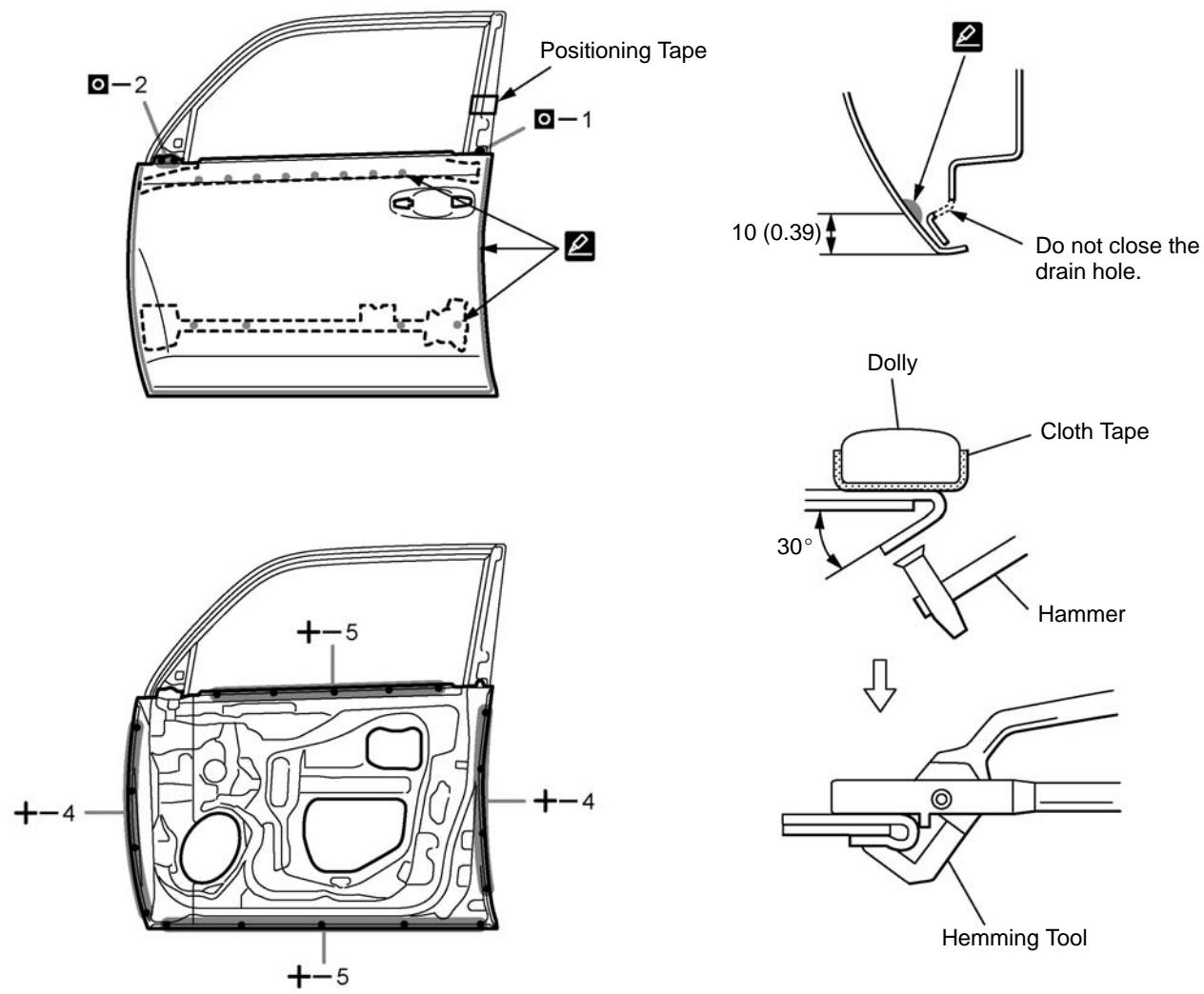


Symbol meaning

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

F42935B

INSTALLATION



mm (in.)

F42935

INSTALLATION POINT

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

HINT:

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

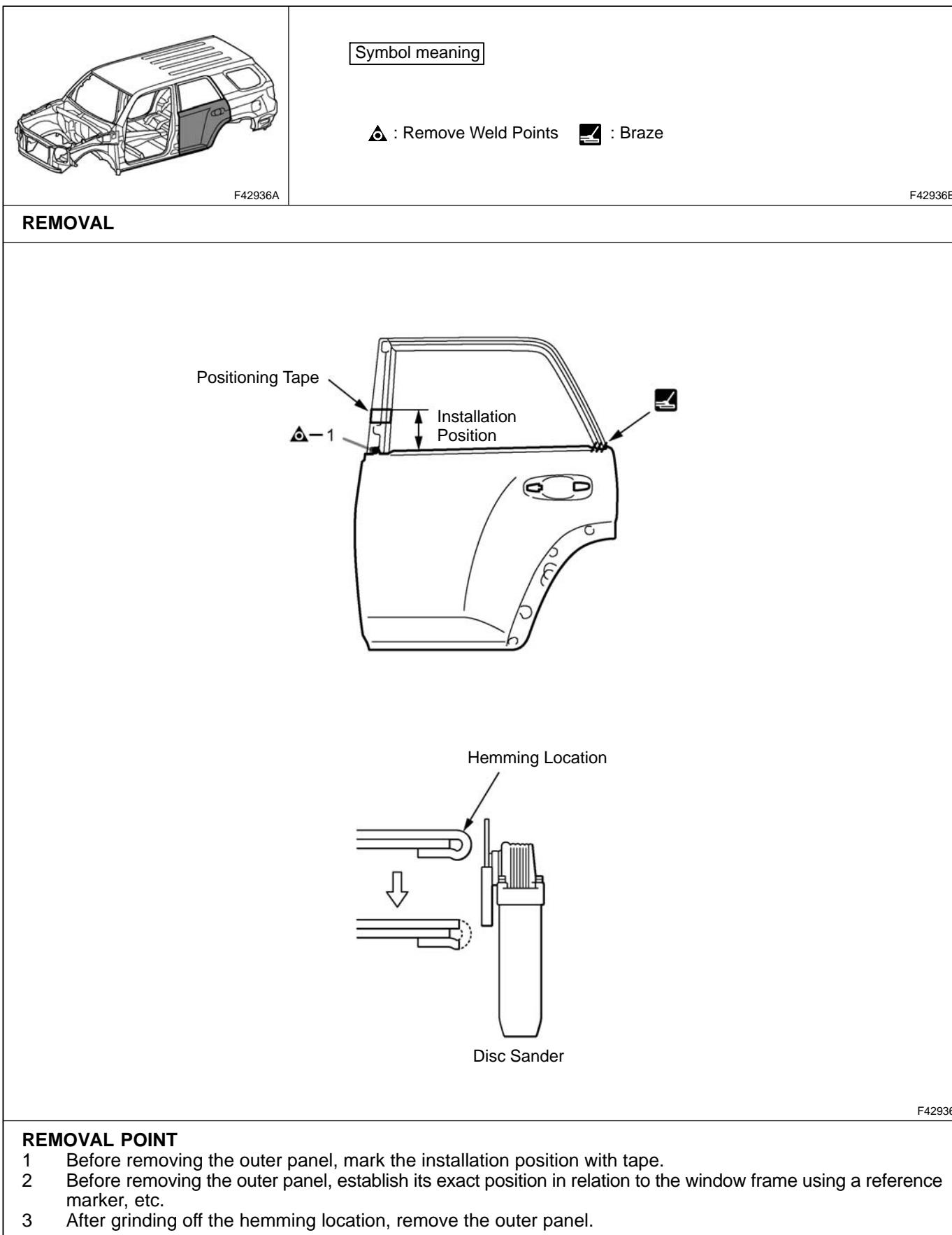
- Bend the flange hem about 30° with a hammer and dolly. Then, fasten tightly with a hemming tool.

HINT:

- Perform hemming in three steps, being careful not to warp the panel.*
- If a hemming tool cannot be used, hem with a hammer and dolly.*

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

REAR DOOR OUTER PANEL (ASSY)

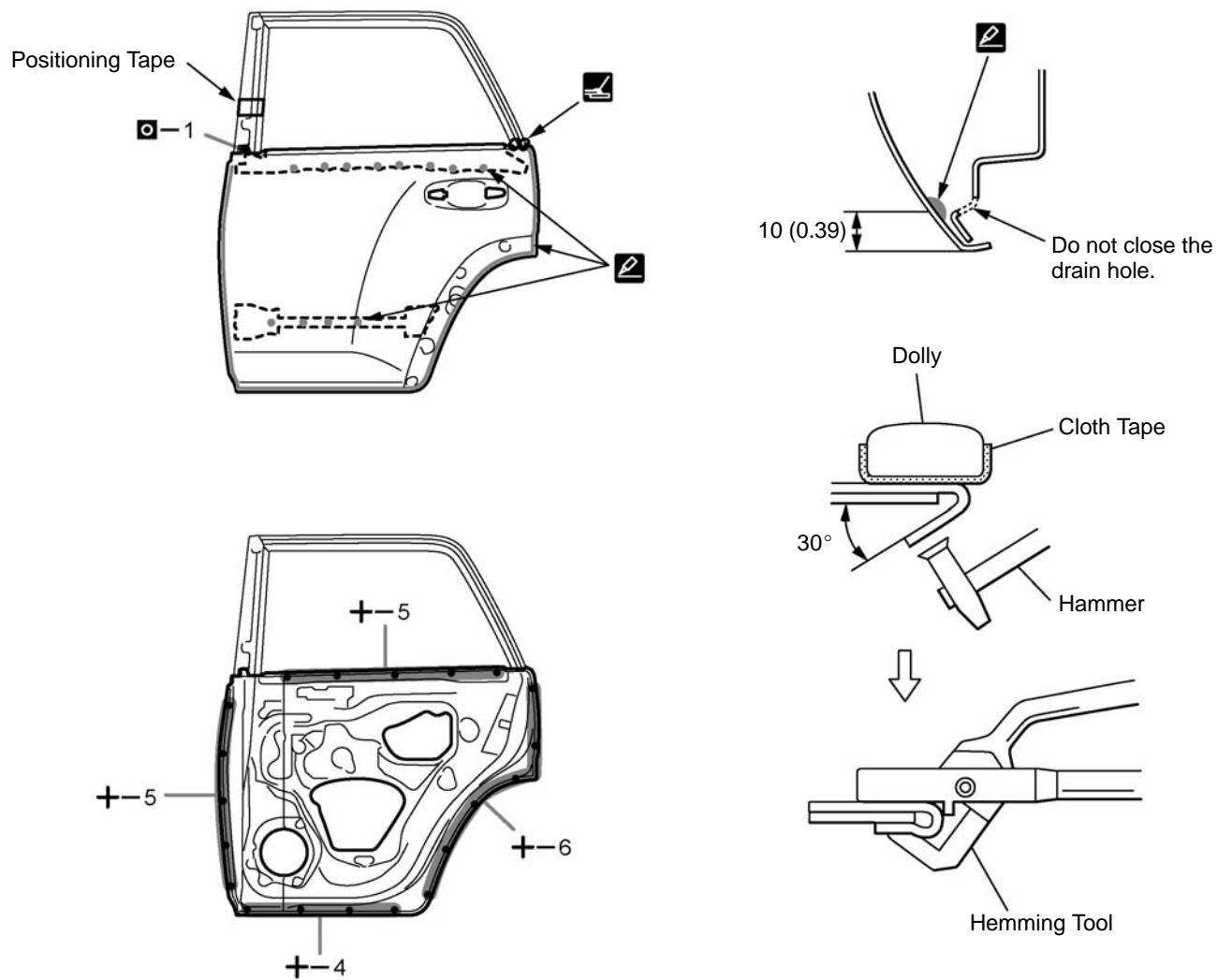


Symbol meaning

◻ : Plug Weld ↗ : Braze + : Spot MIG Weld ⌂ : Body Sealer

F42937B

INSTALLATION



INSTALLATION POINT

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

HINT:

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

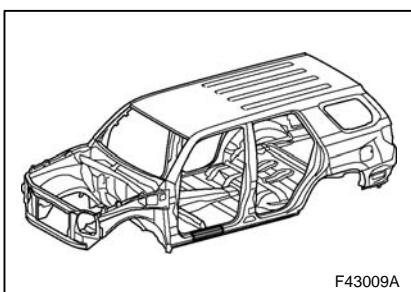
- Bend the flange hem about 30° with a hammer and dolly. Then, fasten tightly with a hemming tool.

HINT:

- Perform hemming in three steps, being careful not to warp the panel.*
- If a hemming tool cannot be used, hem with a hammer and dolly.*

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

CENTER BODY OUTER PILLAR (CUT)



Weld work for 980 MPa ultra high strength steel

- 1 **Follow the welding conditions below when welding ultra high strength steel to assure sufficient weld strength. (When repairing this model)**

*1: When welding 2 panels together including 980 MPa ultra high strength steel.

Spot weld	Pressure	2940 N (300 kgf, 661 lbf)
	Weld current	10000 A
	Weld time	18 Cyc. (0.30 Sec.)
Plug weld	Plug diameter	10 mm (0.39 in.)
	Wire type	AWS A5.18 ER70S-3
	Shield gas	Metal active gas

*2: When welding more than 3 panels together including 980 MPa ultra high strength steel.
(When plug welding a panel to the welded panels with the weld condition above.)

Plug weld	Plug diameter	Same as the standard method (See the introduction)
	Wire type	AWS A5.18 ER70S-3
	Shield gas	Metal active gas

HINT:

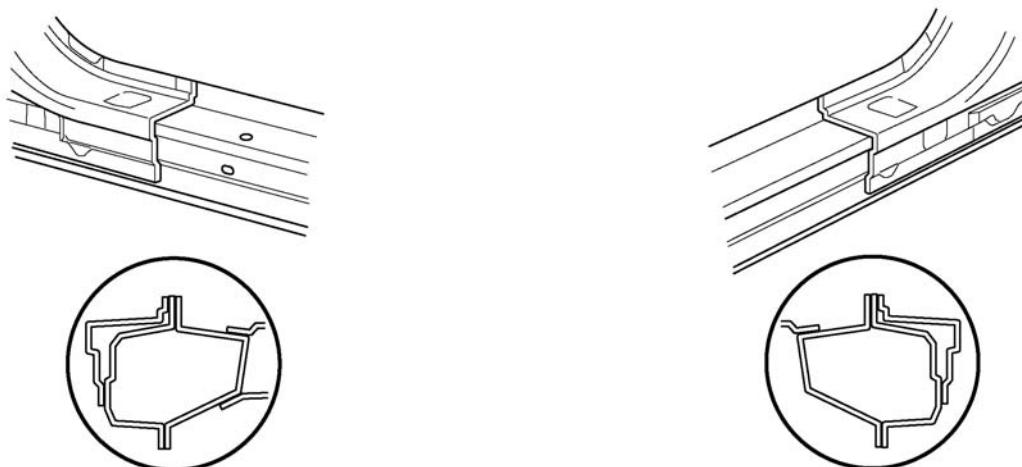
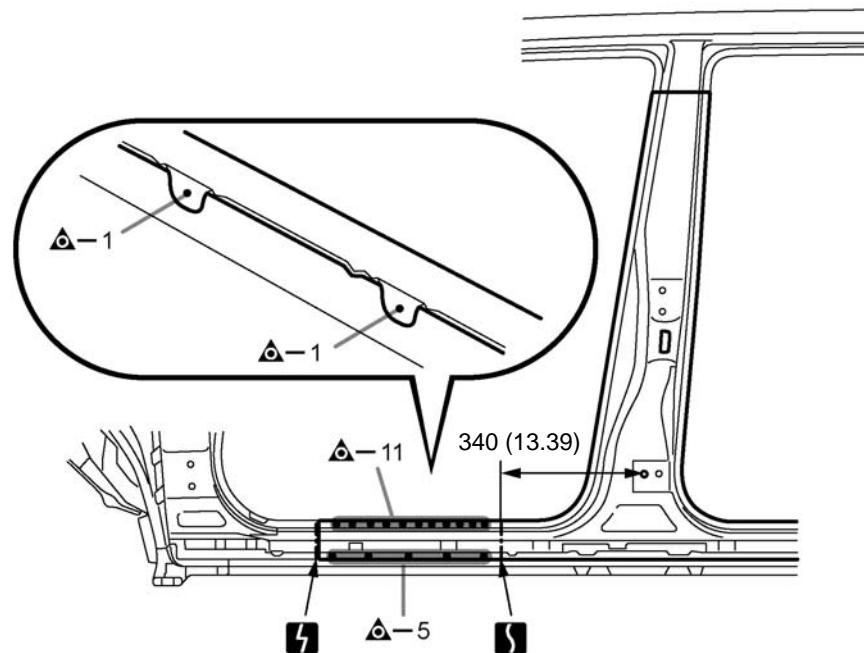
*Be sure to use Metal active gas (Ar 80% + CO₂ 20%) as the shield gas when plug welding.
Sufficient weld strength cannot be assured when using 100% CO₂ shield gas.*

Symbol meaning

▲ : Remove Weld Points S : Cut and Join Location L : Cut Location for Supply Parts

F43009B

REMOVAL



mm (in.)

F43009

REMOVAL POINT

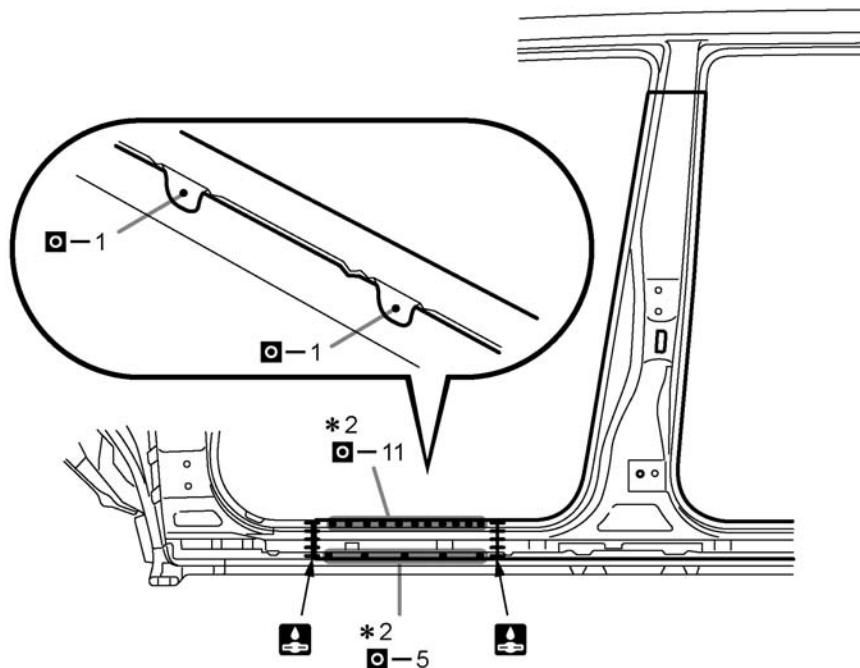
- 1 Do not butt weld or heat repair because the heat decreases the strength of areas where ultra high strength steel is used. (See the introduction)

Symbol meaning

○ : Plug Weld  : Butt Weld

F43010B

INSTALLATION

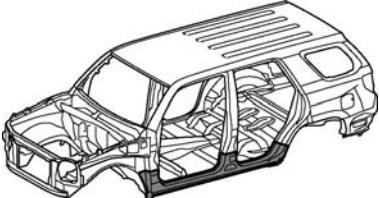


F43010

INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 Follow the welding conditions when welding point *2 to assure sufficient weld strength. (See the introduction)
- 4 After welding, apply body sealer to the corresponding parts. (See the paint coating)
- 5 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

ROCKER OUTER PANEL (ASSY)

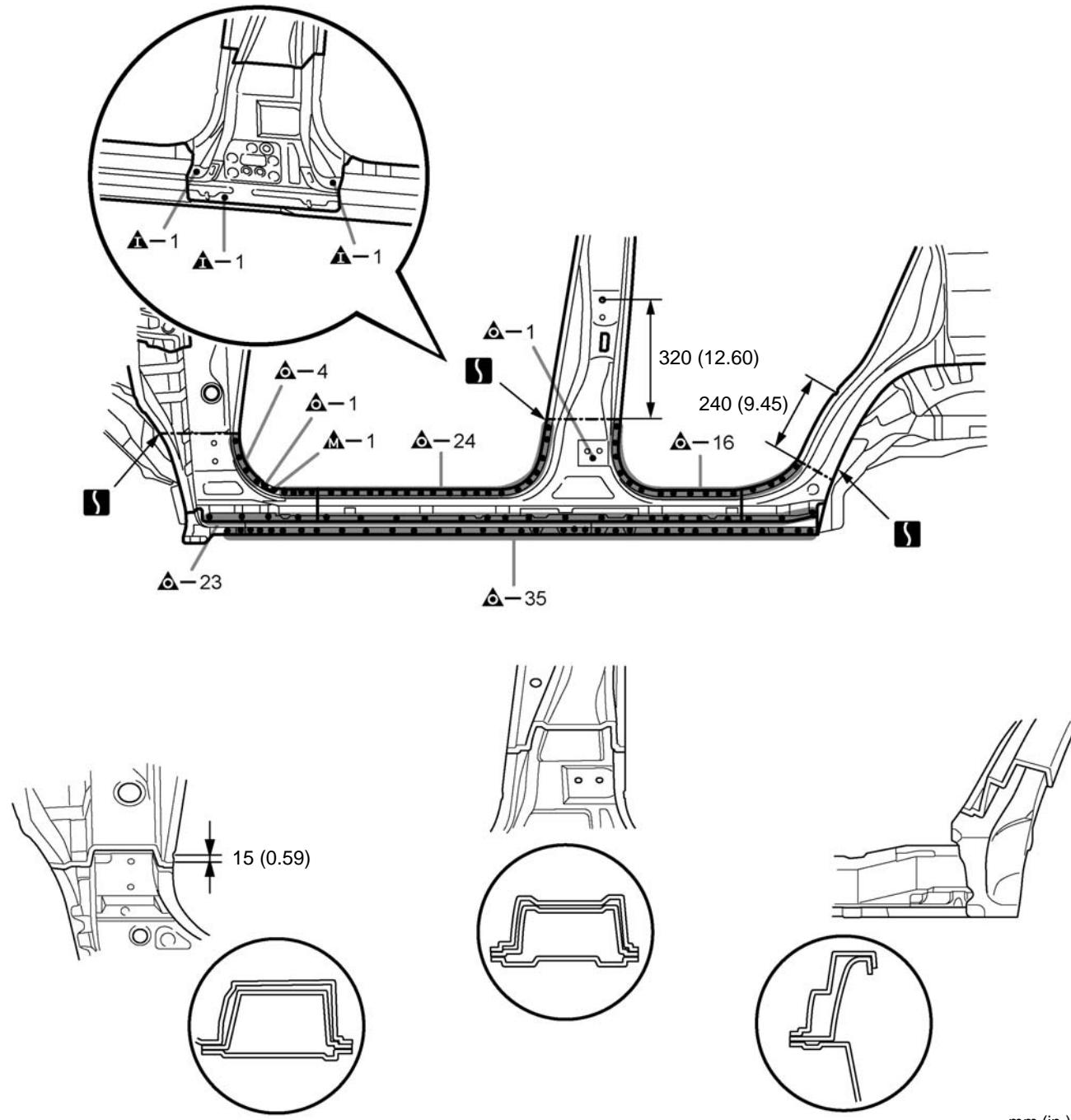
 F42938A	Weld work for 980 MPa ultra high strength steel														
1 Follow the welding conditions below when welding ultra high strength steel to assure sufficient weld strength. (When repairing this model)															
*1: When welding 2 panels together including 980 MPa ultra high strength steel.															
<table border="1"><tr><td rowspan="3">Spot weld</td><td>Pressure</td><td>2940 N (300 kgf, 661 lbf)</td></tr><tr><td>Weld current</td><td>10000 A</td></tr><tr><td>Weld time</td><td>18 Cyc. (0.30 Sec.)</td></tr><tr><td rowspan="3">Plug weld</td><td>Plug diameter</td><td>10 mm (0.39 in.)</td></tr><tr><td>Wire type</td><td>AWS A5.18 ER70S-3</td></tr><tr><td>Shield gas</td><td>Metal active gas</td></tr></table>		Spot weld	Pressure	2940 N (300 kgf, 661 lbf)	Weld current	10000 A	Weld time	18 Cyc. (0.30 Sec.)	Plug weld	Plug diameter	10 mm (0.39 in.)	Wire type	AWS A5.18 ER70S-3	Shield gas	Metal active gas
Spot weld	Pressure		2940 N (300 kgf, 661 lbf)												
	Weld current		10000 A												
	Weld time	18 Cyc. (0.30 Sec.)													
Plug weld	Plug diameter	10 mm (0.39 in.)													
	Wire type	AWS A5.18 ER70S-3													
	Shield gas	Metal active gas													
*2: When welding more than 3 panels together including 980 MPa ultra high strength steel. (When plug welding a panel to the welded panels with the weld condition above.)															
<table border="1"><tr><td rowspan="3">Plug weld</td><td>Plug diameter</td><td>Same as the standard method (See the introduction)</td></tr><tr><td>Wire type</td><td>AWS A5.18 ER70S-3</td></tr><tr><td>Shield gas</td><td>Metal active gas</td></tr></table>		Plug weld	Plug diameter	Same as the standard method (See the introduction)	Wire type	AWS A5.18 ER70S-3	Shield gas	Metal active gas							
Plug weld	Plug diameter		Same as the standard method (See the introduction)												
	Wire type		AWS A5.18 ER70S-3												
	Shield gas	Metal active gas													
<i>HINT:</i> <i>Be sure to use Metal active gas (Ar 80% + CO₂ 20%) as the shield gas when plug welding. Sufficient weld strength cannot be assured when using 100% CO₂ shield gas.</i>															

Symbol meaning

: Remove Weld Points : Cut with Disc Sander etc. : Cut and Join Location

F42938B

REMOVAL



REMOVAL POINT

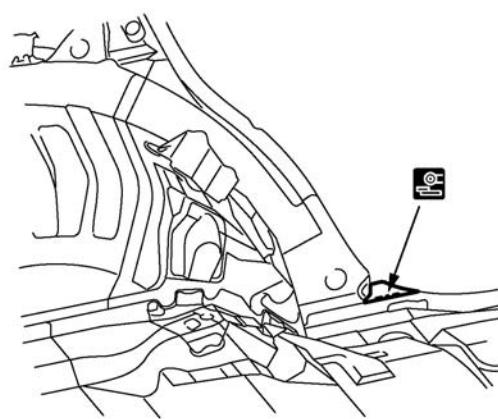
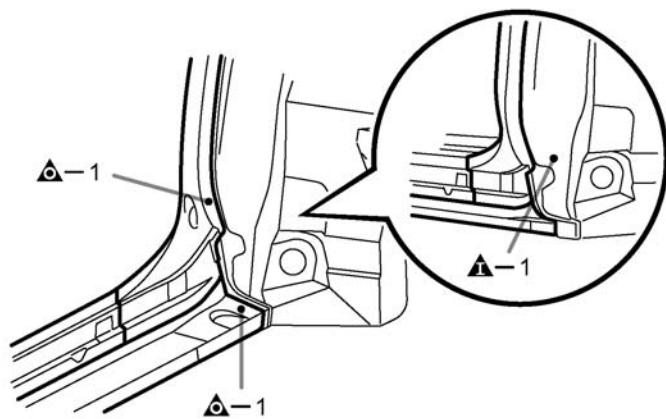
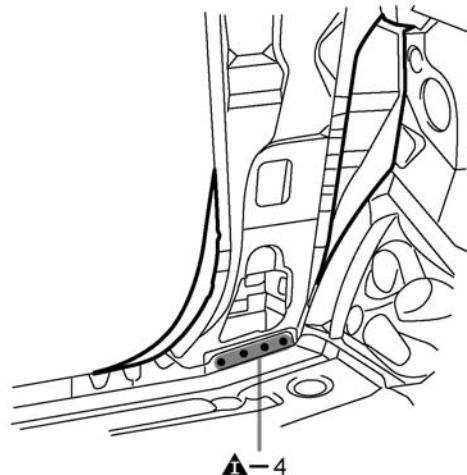
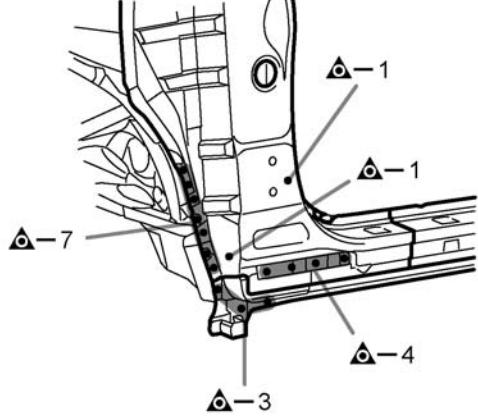
- 1 Do not butt weld or heat repair because the heat decreases the strength of areas where ultra high strength steel is used. (See the introduction)

F42938

Symbol meaning

▲ : Remove Weld Points ☰ : Cut with Disc Sander etc. ⚡ : Cut and Join Location

F42938B



F42939

REMOVAL POINT

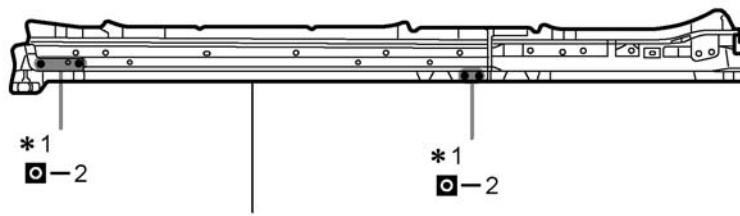
- 1 Do not butt weld or heat repair because the heat decreases the strength of areas where ultra high strength steel is used. (See the introduction)

Symbol meaning

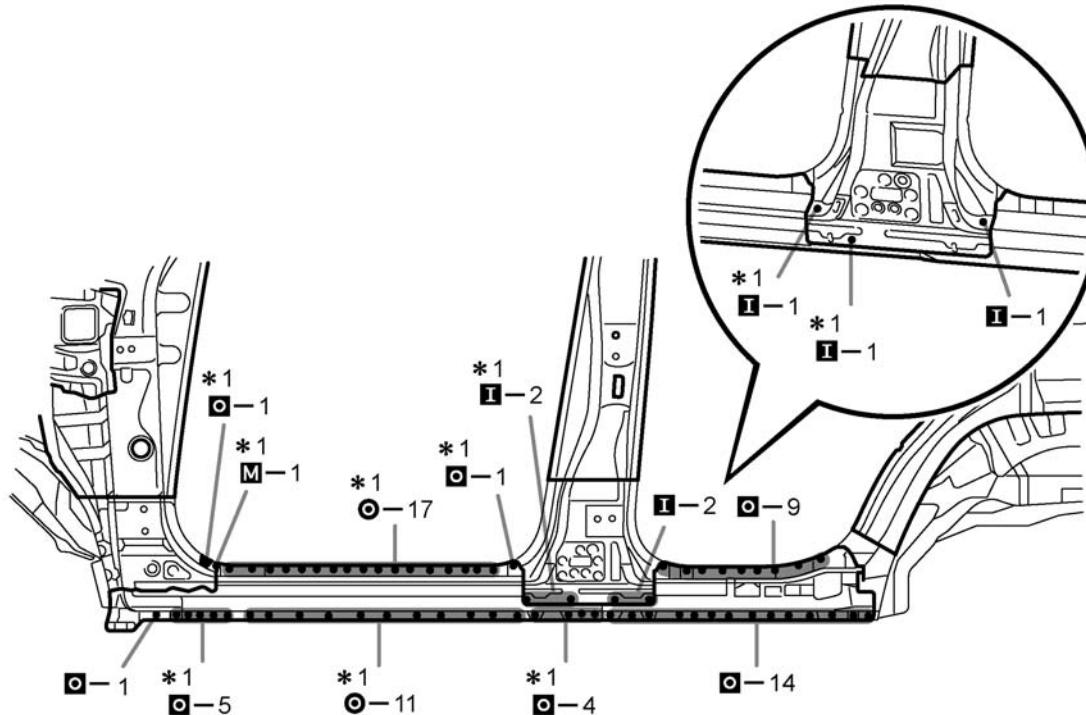
● : Spot Weld ○ M I : Plug Weld ■ : Fillet Weld
 ▲ : Butt Weld □ : Body Sealer

F42940B

INSTALLATION



Rocker Panel Reinforcement



F42940

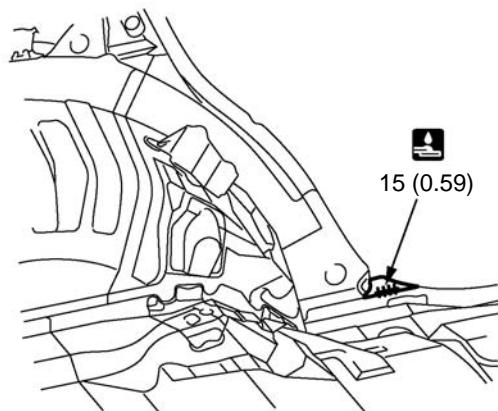
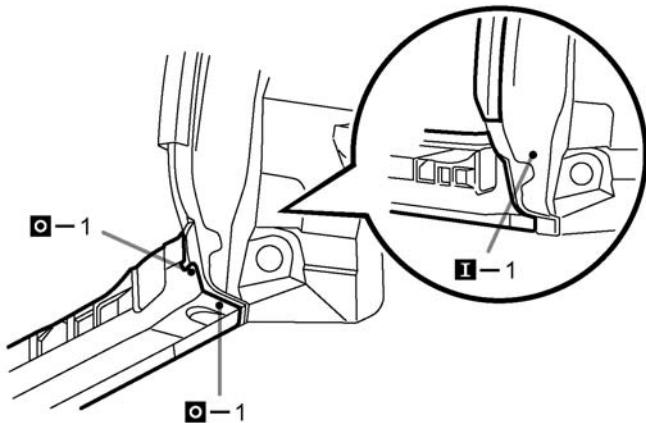
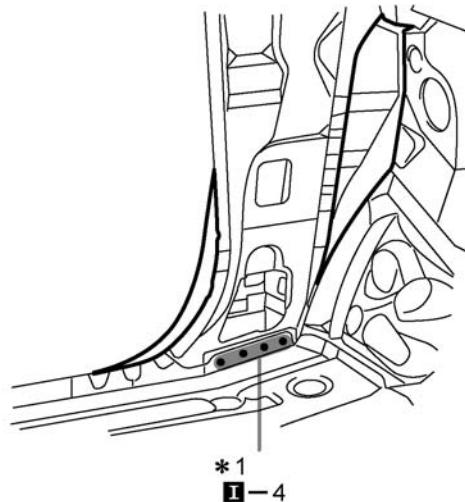
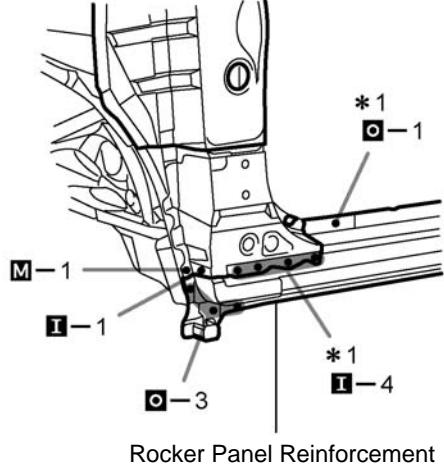
INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 Follow the welding conditions when welding point *1 to assure sufficient weld strength. (See the introduction)
- 4 After welding the rocker panel reinforcement to the vehicle side, install the front body upper outer pillar, center body outer pillar and quarter panel.

Symbol meaning

● : Spot Weld ○ M I : Plug Weld 🔥 : Fillet Weld
 🔨 : Butt Weld 🖌 : Body Sealer

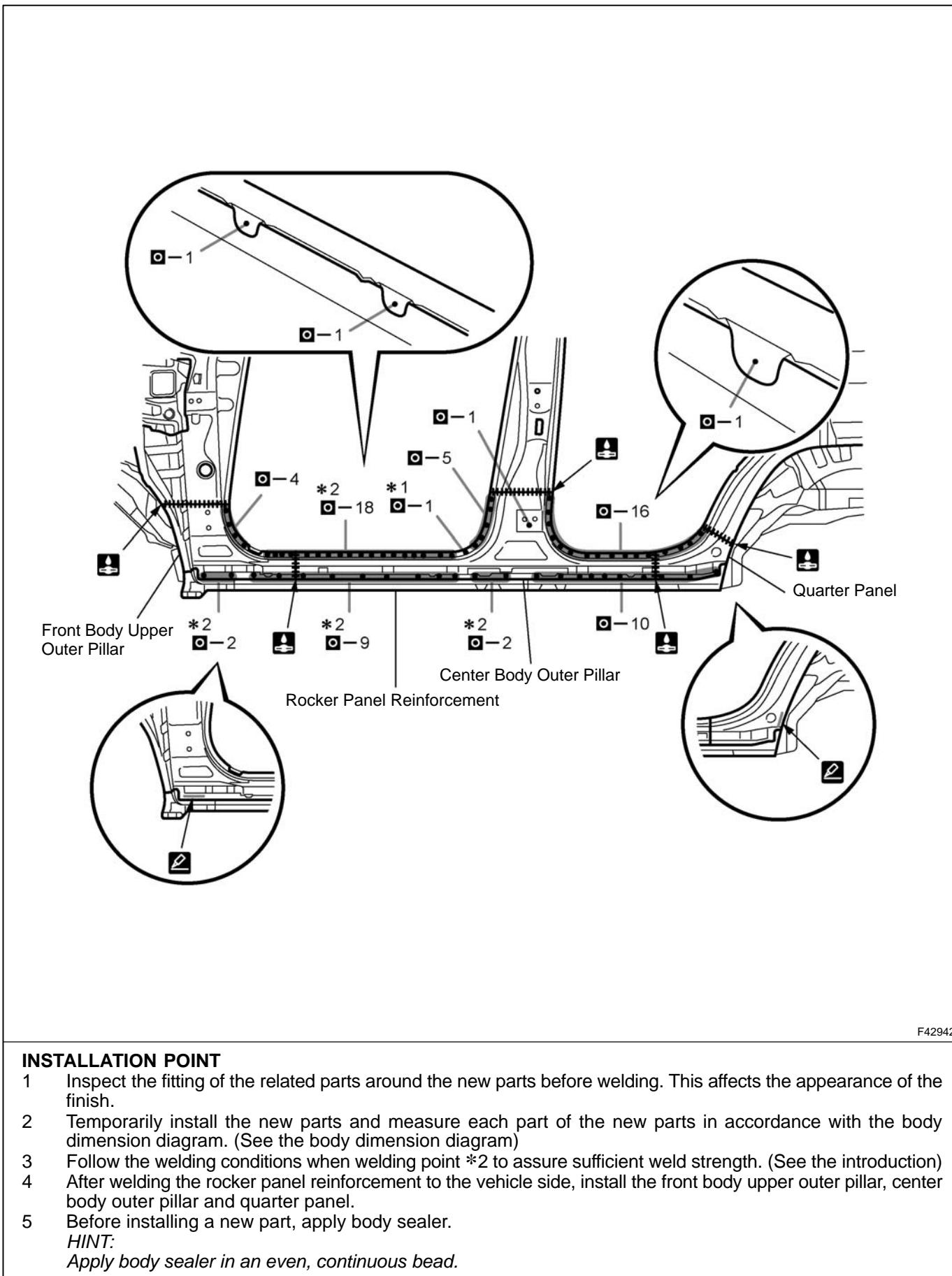
F42940B



F42941

INSTALLATION POINT

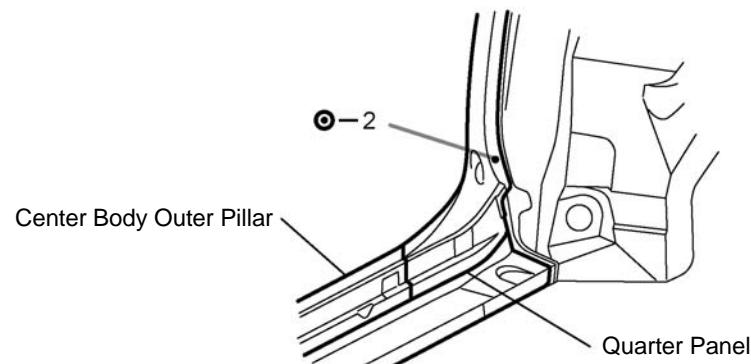
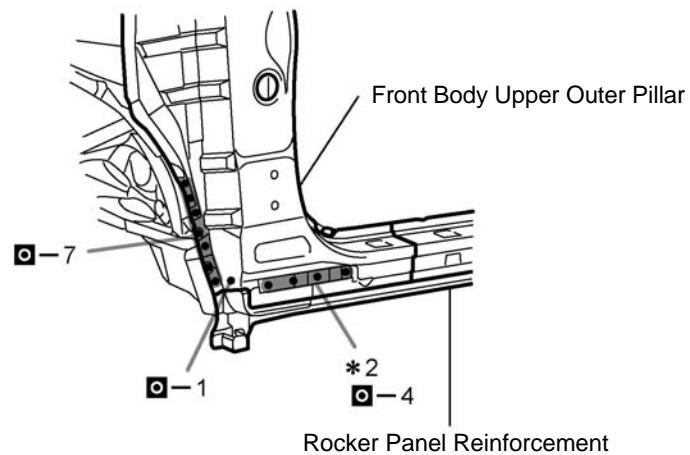
- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 Follow the welding conditions when welding point *1 to assure sufficient weld strength. (See the introduction)
- 4 After welding the rocker panel reinforcement to the vehicle side, install the front body upper outer pillar, center body outer pillar and quarter panel.



Symbol meaning

● : Spot Weld □ M I : Plug Weld 🔥 : Fillet Weld
 🔨 : Butt Weld 🖌 : Body Sealer

F42940B

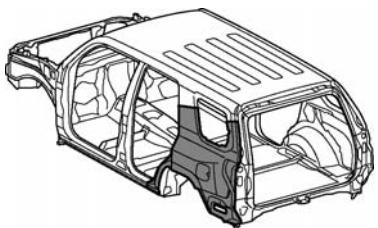


F42943

INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 Follow the welding conditions when welding point *2 to assure sufficient weld strength. (See the introduction)
- 4 After welding the rocker panel reinforcement to the vehicle side, install the front body upper outer pillar, center body outer pillar and quarter panel.
- 5 After welding, apply the foamed sealing material to the corresponding parts. (See the paint-coating)
- 6 After welding, apply body sealer to the corresponding parts. (See the paint-coating)
- 7 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

QUARTER PANEL (ASSY)

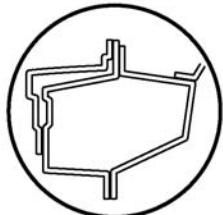
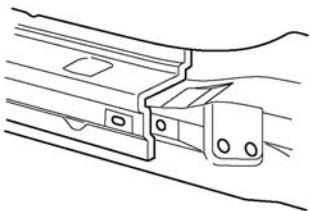
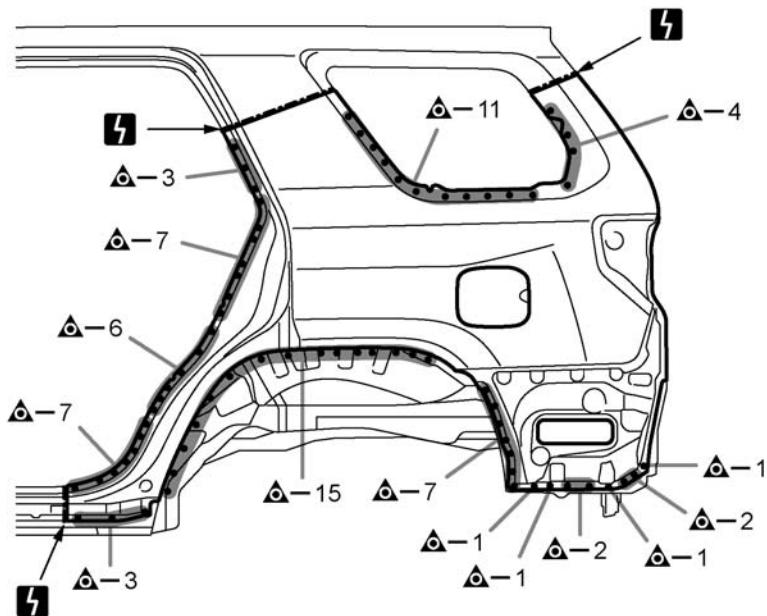
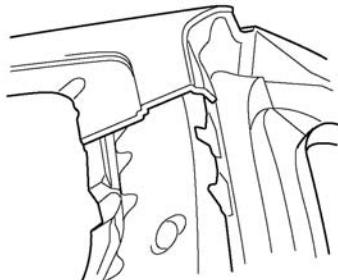
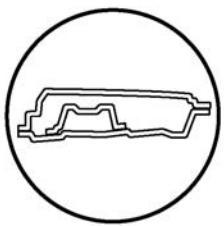
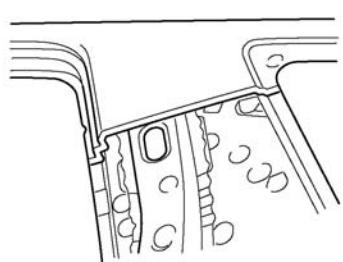


Symbol meaning

 : Remove Weld Points : Cut with Disc Sander etc.

⚡ : Cut Location for Supply Parts

REMOVAL

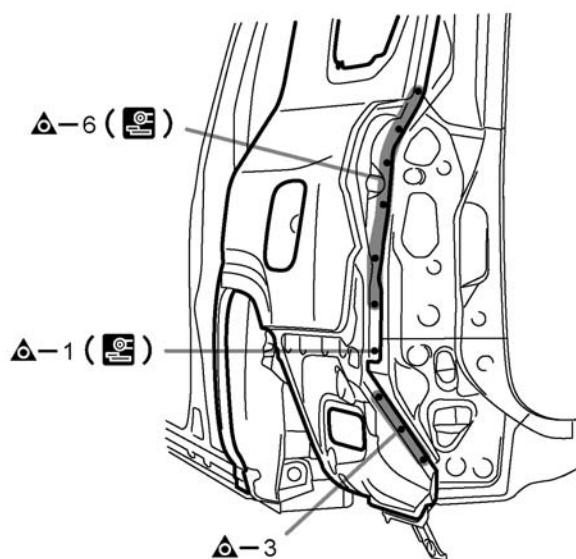
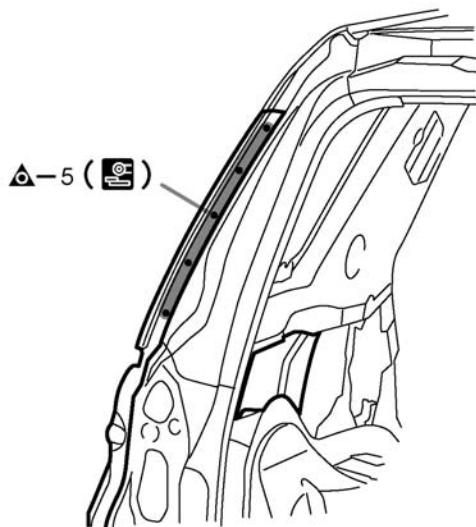


Symbol meaning

△ : Remove Weld Points  : Cut with Disc Sander etc.

 : Cut Location for Supply Parts

F42944B



F42945

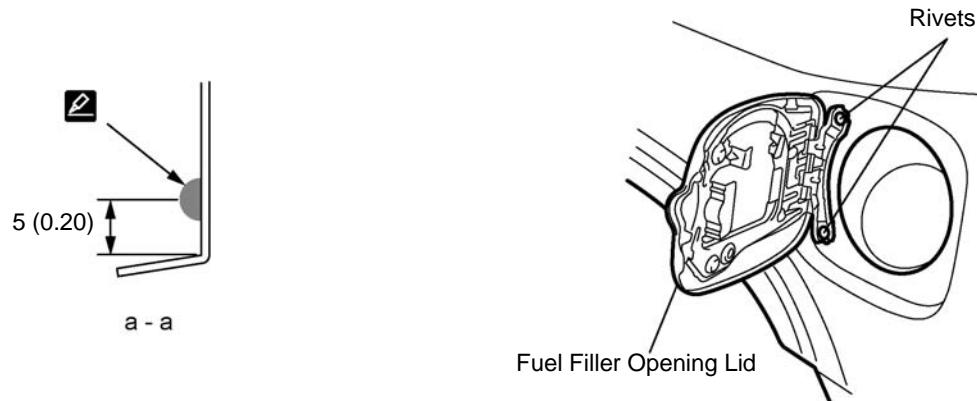
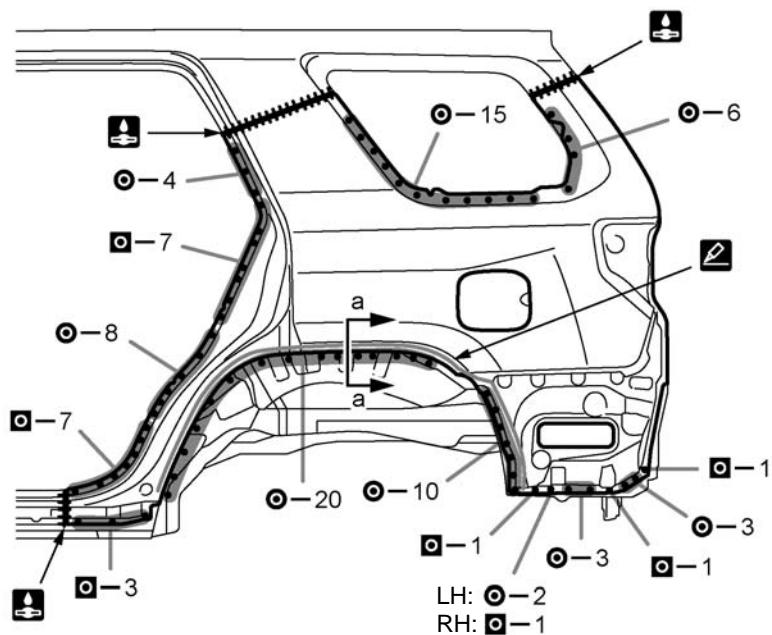
Symbol meaning

Ⓐ : Spot Weld Ⓛ : Plug Weld Ⓜ : Butt Weld

Ⓑ : Body Sealer

F42946B

INSTALLATION



mm (in.)

F42946

INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 Before installing a new part, apply body sealer.

HINT:

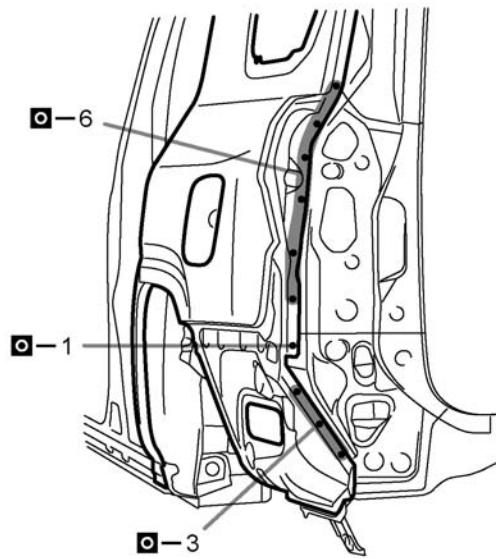
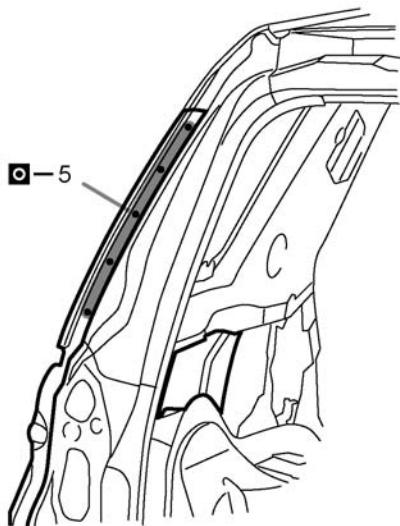
*Apply body sealer evenly about 5 mm (0.20 in.) from the flange, avoiding any oozing.
Apply body sealer evenly, about 3 – 4 mm (0.12 – 0.16 in.) in diameter.*

Symbol meaning

◎ : Spot Weld ◻ : Plug Weld 🔨 : Butt Weld

▨ : Body Sealer

F42946B

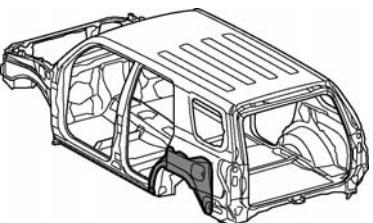
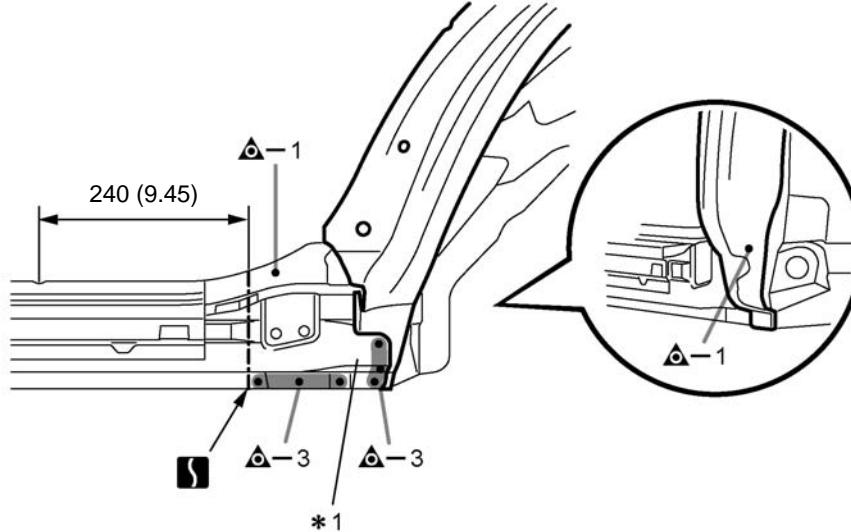
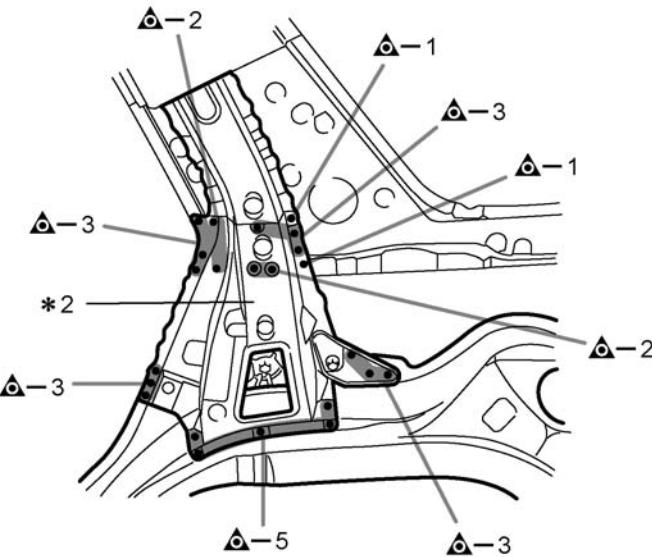
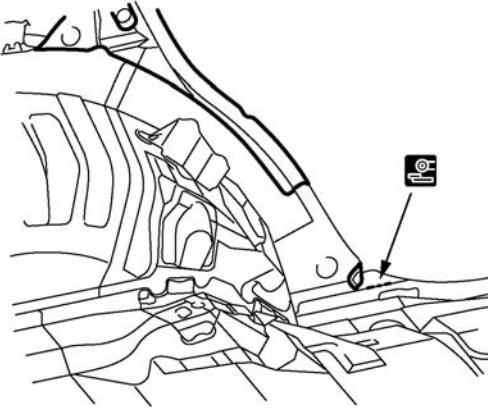


F42947

INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 After welding, apply the foamed sealing material to the corresponding parts. (See the paint-coating)
- 4 After welding, apply body sealer to the corresponding parts. (See the paint-coating)
- 5 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

QUARTER WHEEL HOUSING OUTER PANEL (ASSY)

 F42948A	<p>With the quarter panel removed.</p> <p>Symbol meaning</p> <ul style="list-style-type: none"> △ : Remove Weld Points ◎ : Cut with Disc Sander etc. ſ : Cut and Join Location
	F42948B
REMOVAL	
<p>[LH]</p> 	
	 mm (in.)
<p>REMOVAL POINT</p> <p>1 *1 is reused.</p> <p>2 After removing the *1 and *2 remove the quarter wheel housing outer panel.</p>	F42948

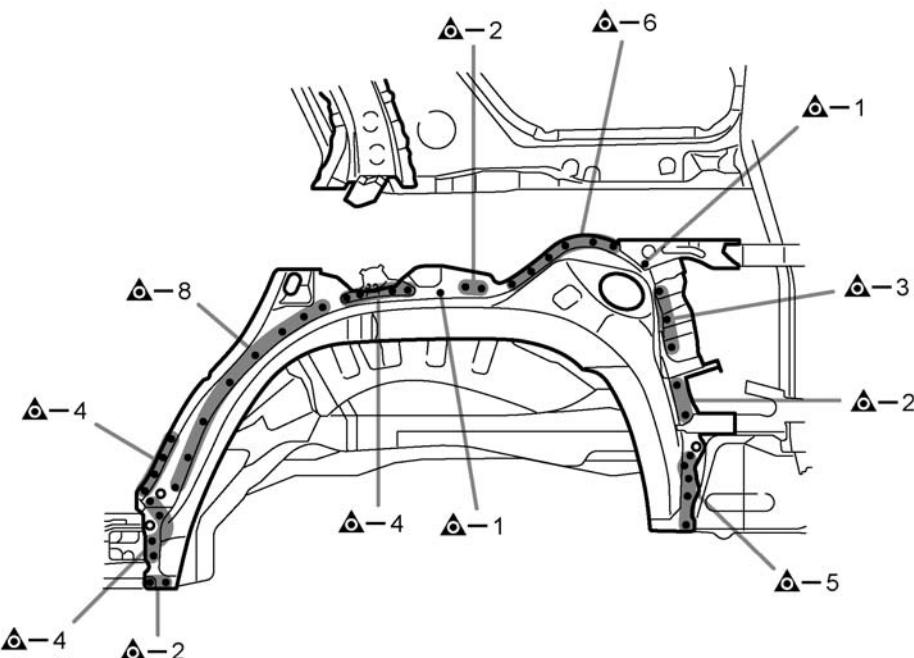
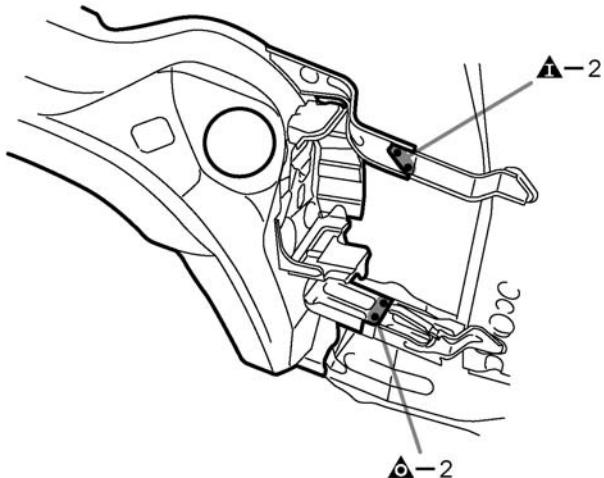
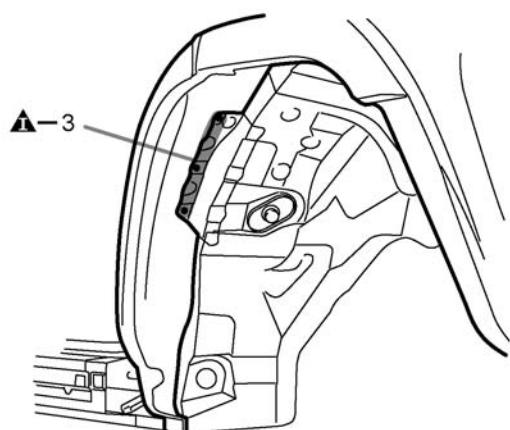
Symbol meaning

▲ : Remove Weld Points  : Cut with Disc Sander etc.

ſ : Cut and Join Location

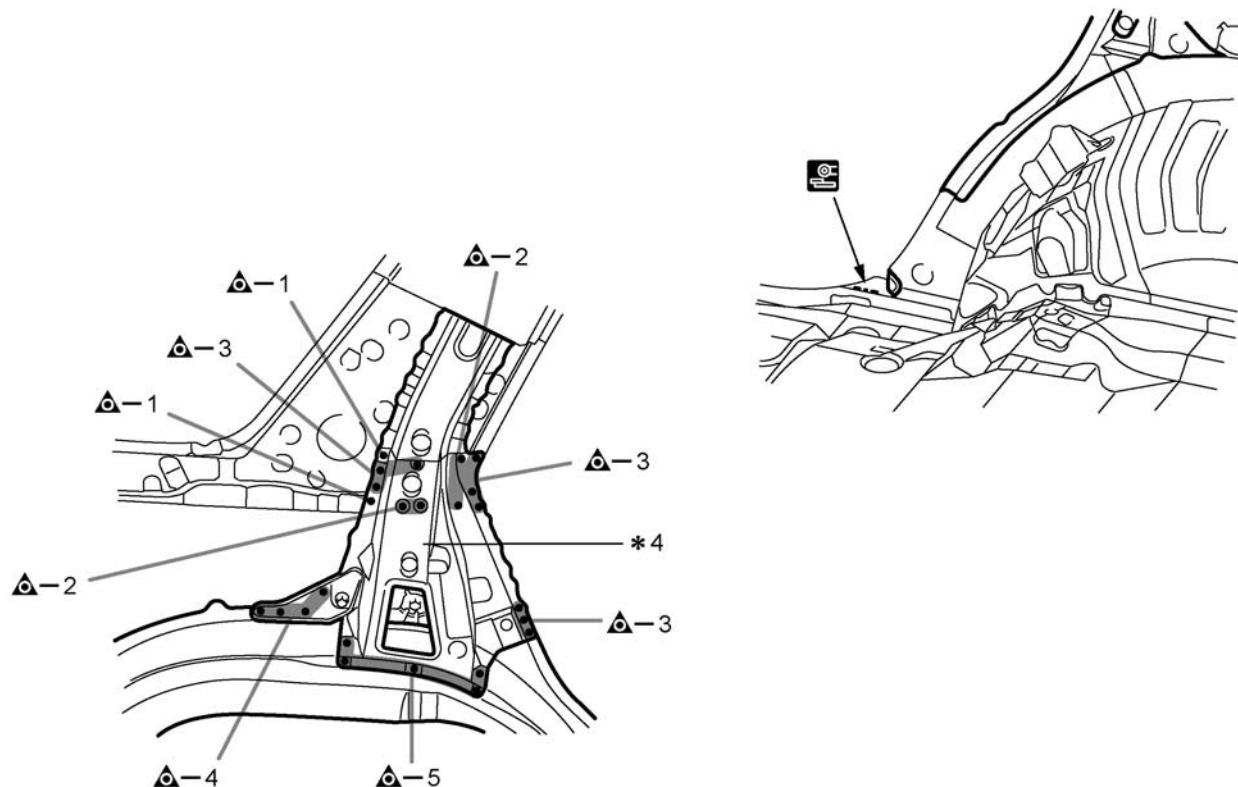
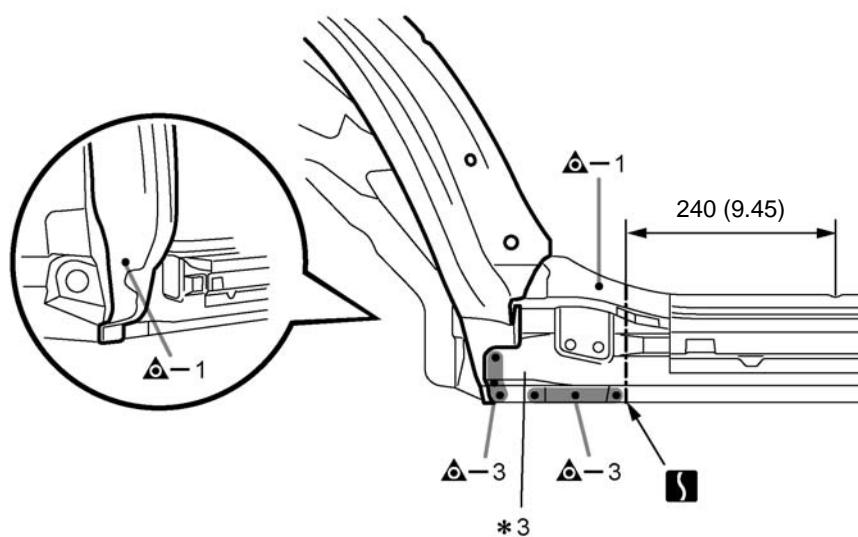
F42948B

[LH]



F42949

[RH]



mm (in.)

F42950

REMOVAL POINT

- 1 *3 is reused.
- 2 After removing the *3 and *4 remove the quarter wheel housing outer panel.

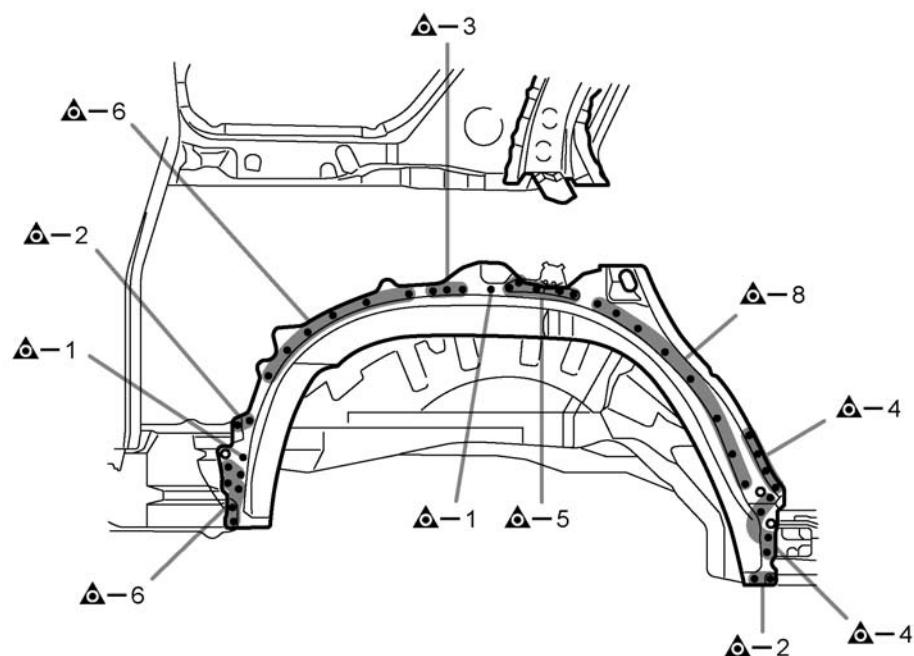
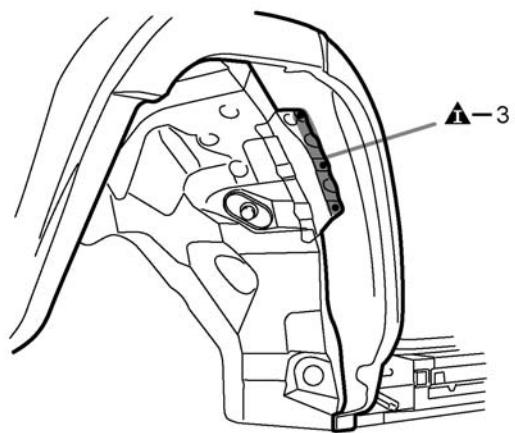
Symbol meaning

▲ : Remove Weld Points  : Cut with Disc Sander etc.

ſ : Cut and Join Location

F42948B

[RH]



F42951

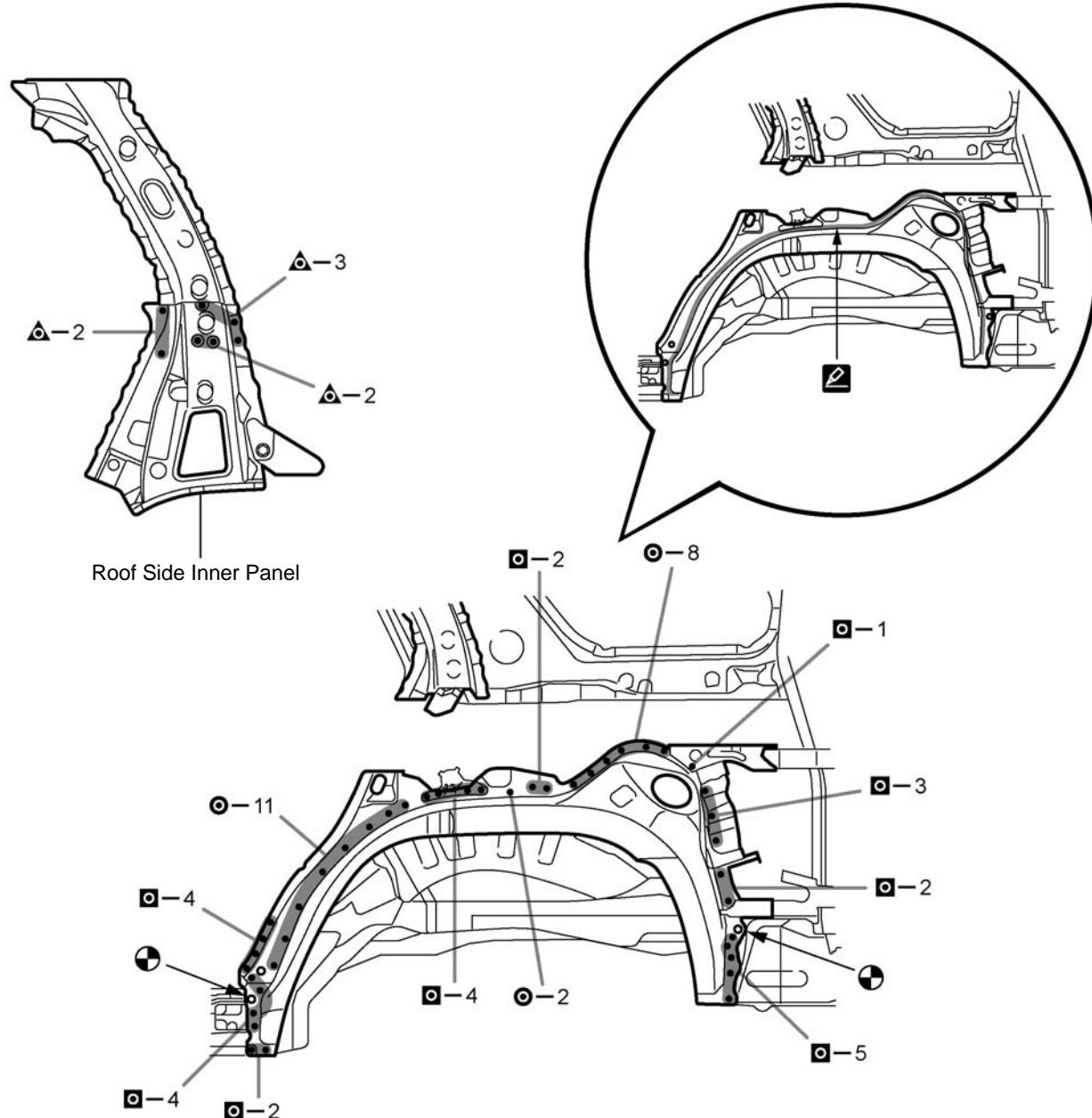
Symbol meaning

▲ : Remove Weld Points ◎ : Spot Weld □ I : Plug Weld
 └─ : Fillet Weld ── : Butt Weld └─ : Body Sealer

F42952B

INSTALLATION

[LH]



F42952

INSTALLATION POINT

- 1 If the entire supply part is not needed, remove the part of the supply part that is needed.
- 2 For positioning of the new parts, align the installation standard holes of the outer panel and the inner panel.
- 3 Before installing a new part, apply body sealer.

*HINT:**Apply body sealer in an even, continuous bead.*

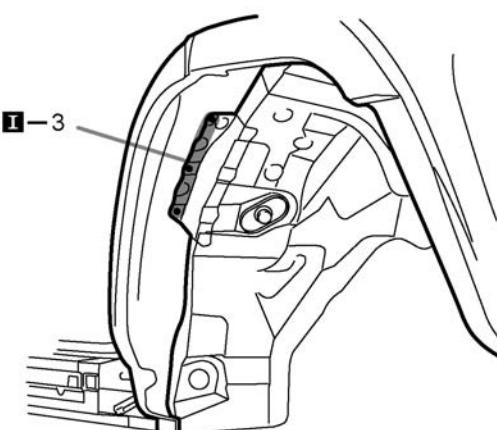
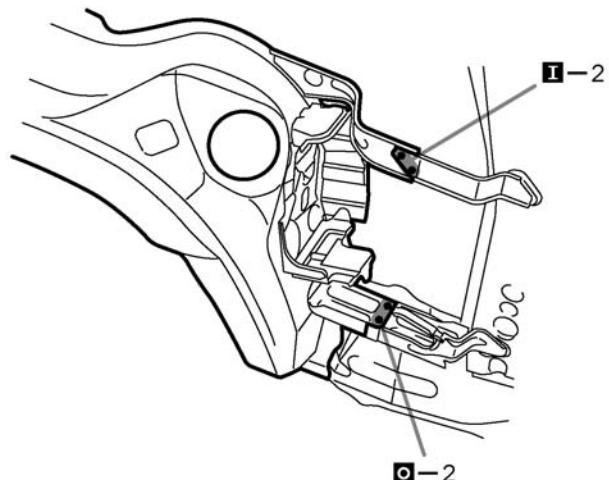
Symbol meaning

▲ : Remove Weld Points ◎ : Spot Weld □ I : Plug Weld

■ : Fillet Weld └─┘ : Butt Weld ┏━┓ : Body Sealer

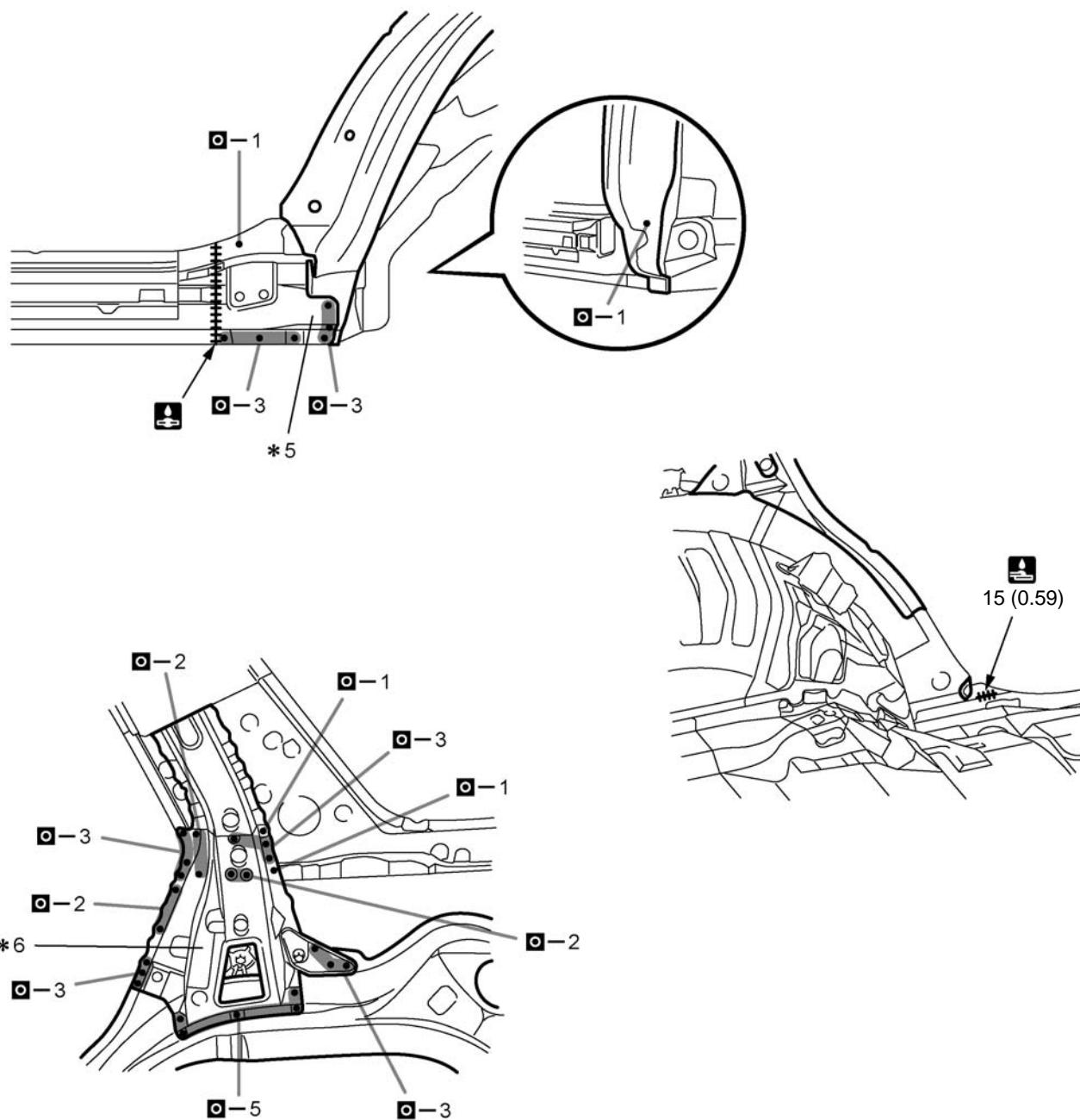
F42952B

[LH]



F42953

[LH]



mm (in.)

F42954

INSTALLATION POINT

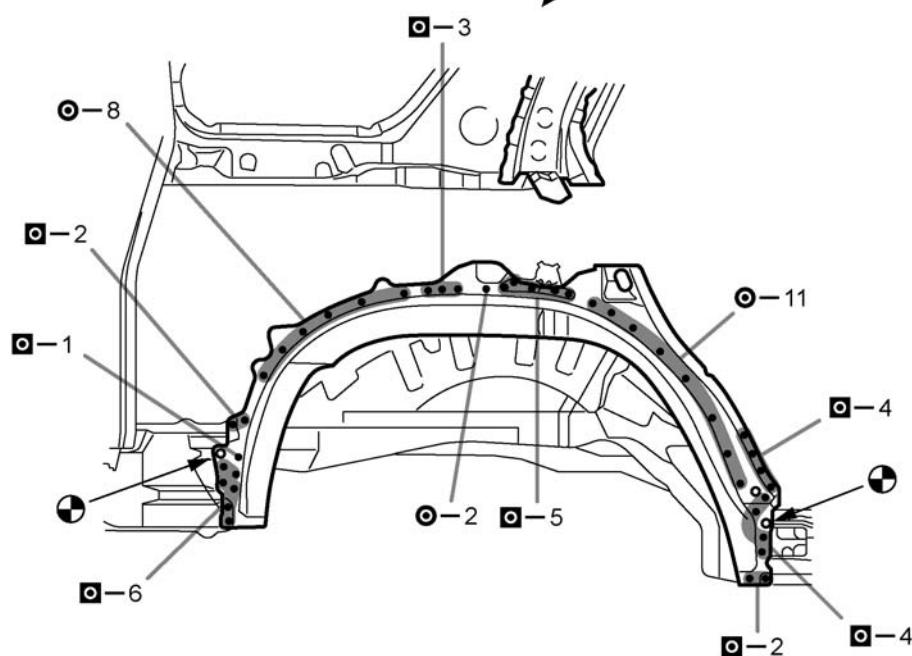
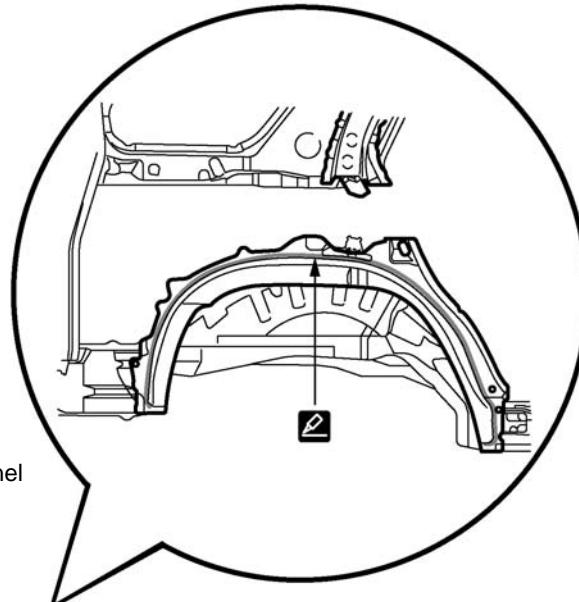
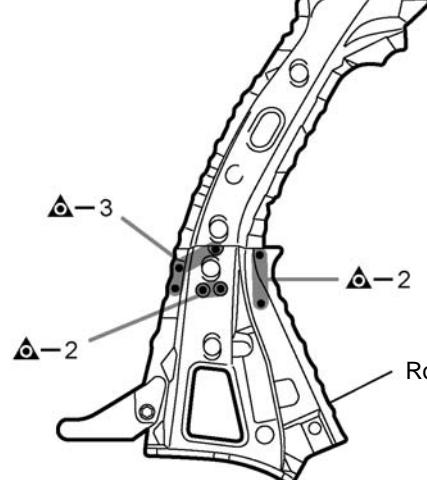
- 1 After welding the quarter wheel housing outer panel to the vehicle side, install the *5 and *6.
- 2 After welding, apply body sealer and undercoating to the corresponding parts. (See the paint-coating)
- 3 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

Symbol meaning

▲ : Remove Weld Points ◎ : Spot Weld ◻ I : Plug Weld
 ◑ : Fillet Weld ◑ : Butt Weld ⌂ : Body Sealer

F42952B

[RH]



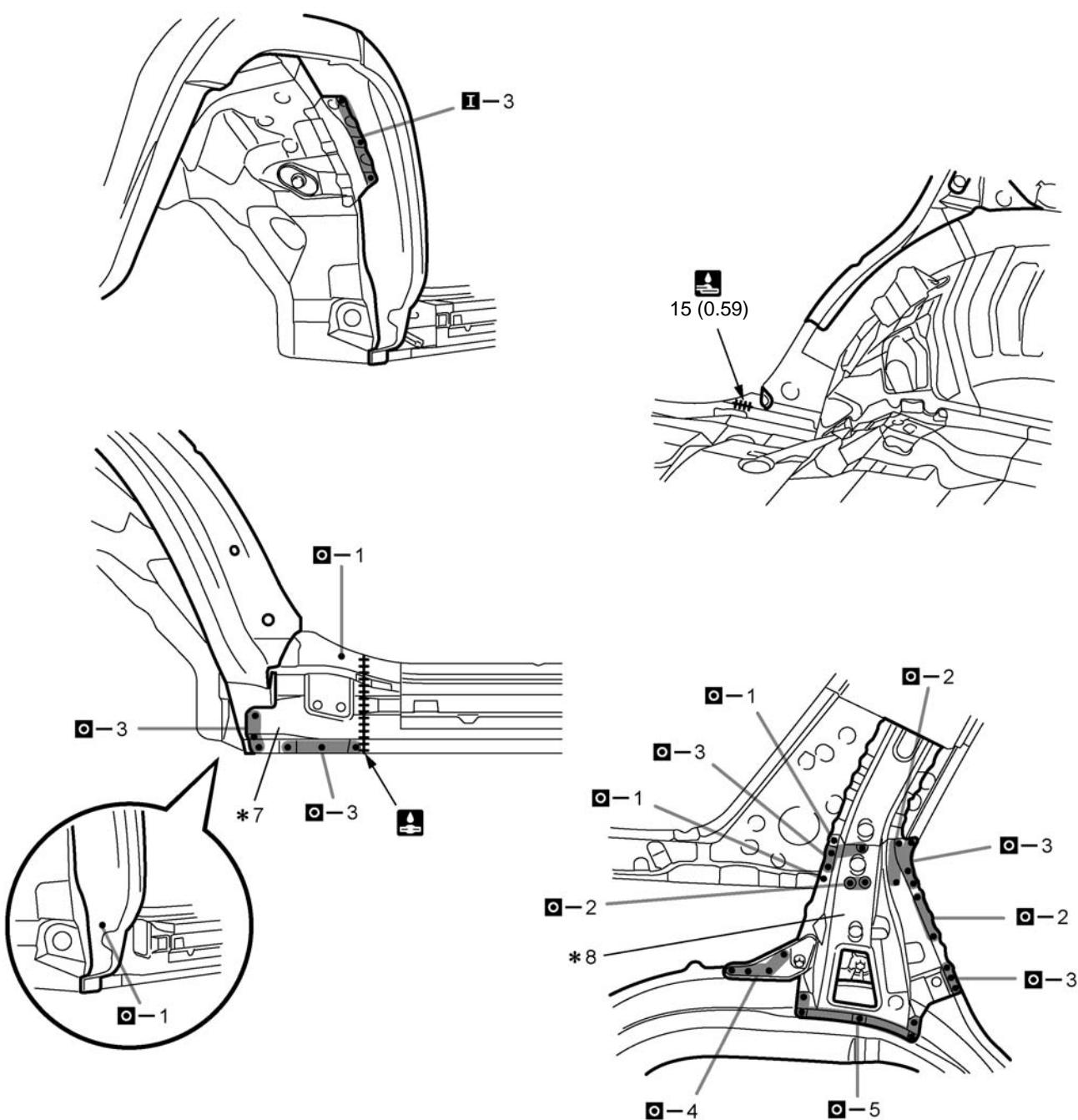
F42955

INSTALLATION POINT

- 1 If the entire supply part is not needed, remove the part of the supply part that is needed.
- 2 For positioning of the new parts, align the installation standard holes of the outer panel and the inner panel.
- 3 Before installing a new part, apply body sealer.

*HINT:**Apply body sealer in an even, continuous bead.*

[RH]



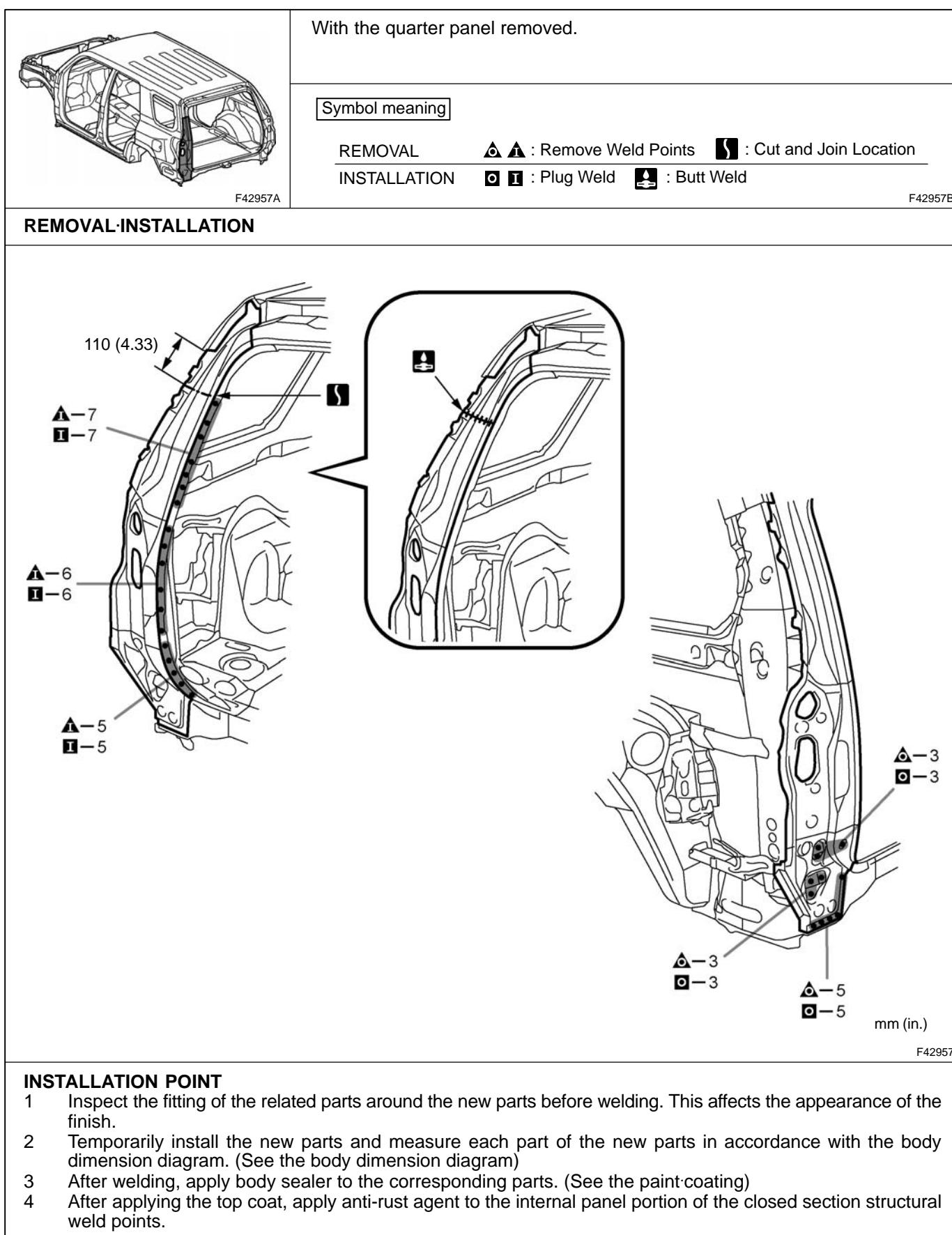
mm (in.)

F42956

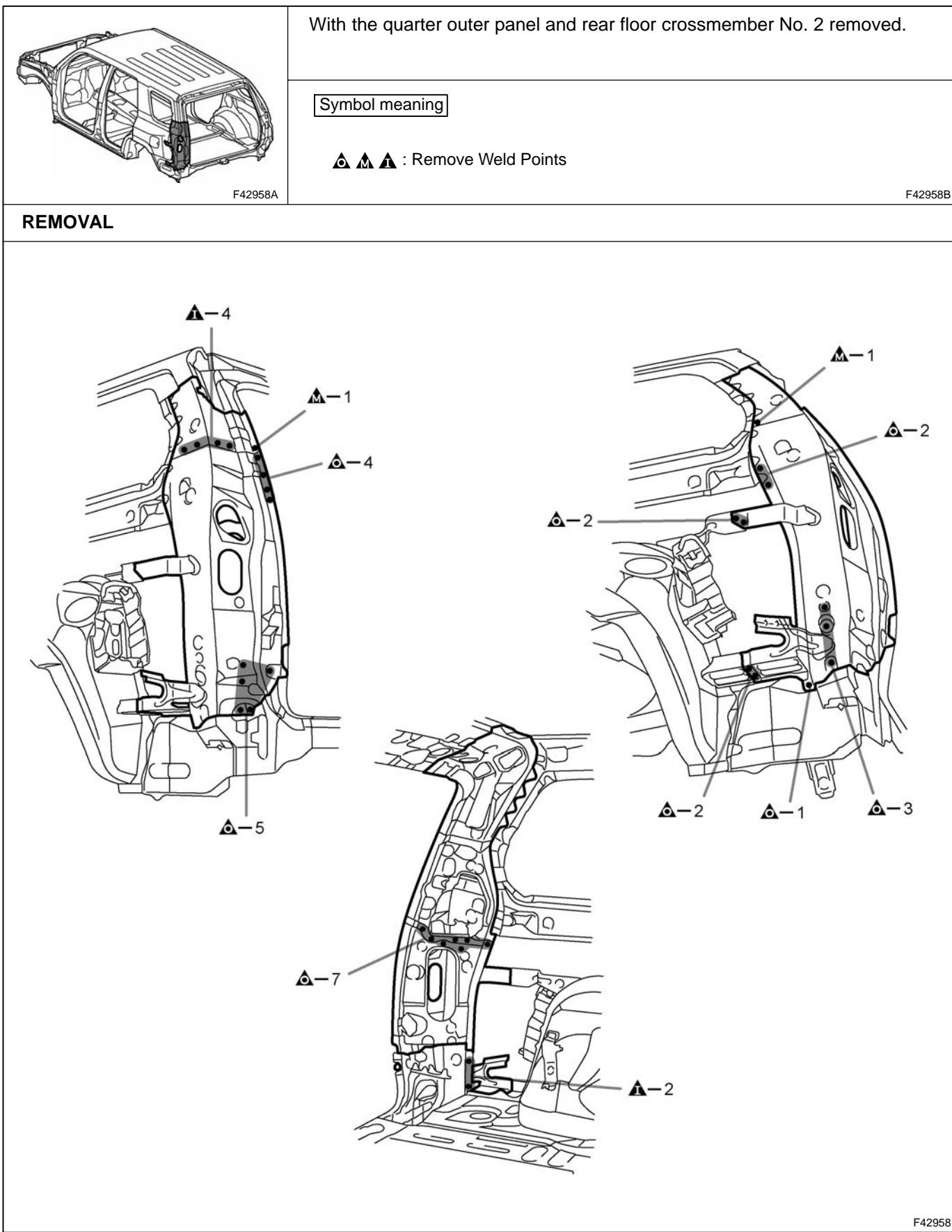
INSTALLATION POINT

- 1 After welding the quarter wheel housing outer panel to the vehicle side, install the *7 and *8.
- 2 After welding, apply body sealer and undercoating to the corresponding parts. (See the paint-coating)
- 3 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

QUARTER OUTER PANEL (CUT)



ROOF SIDE INNER REINFORCE (CUT)

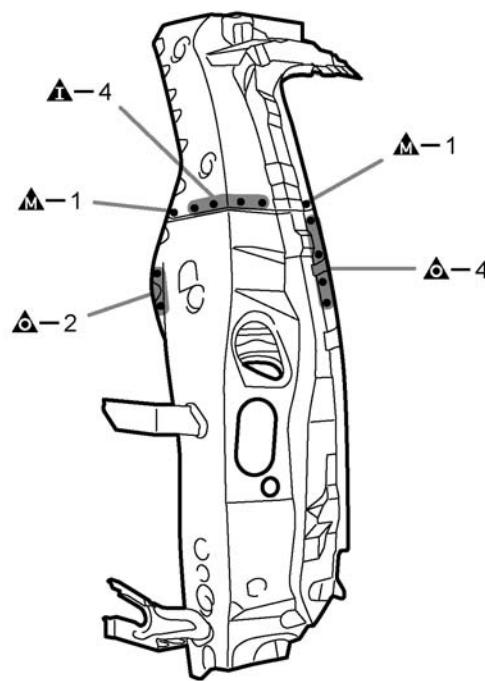
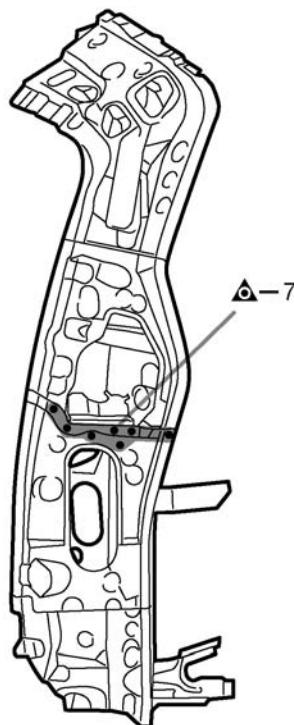


Symbol meaning

▲ M ▲ : Remove Weld Points ◻ M I : Plug Weld

F43013B

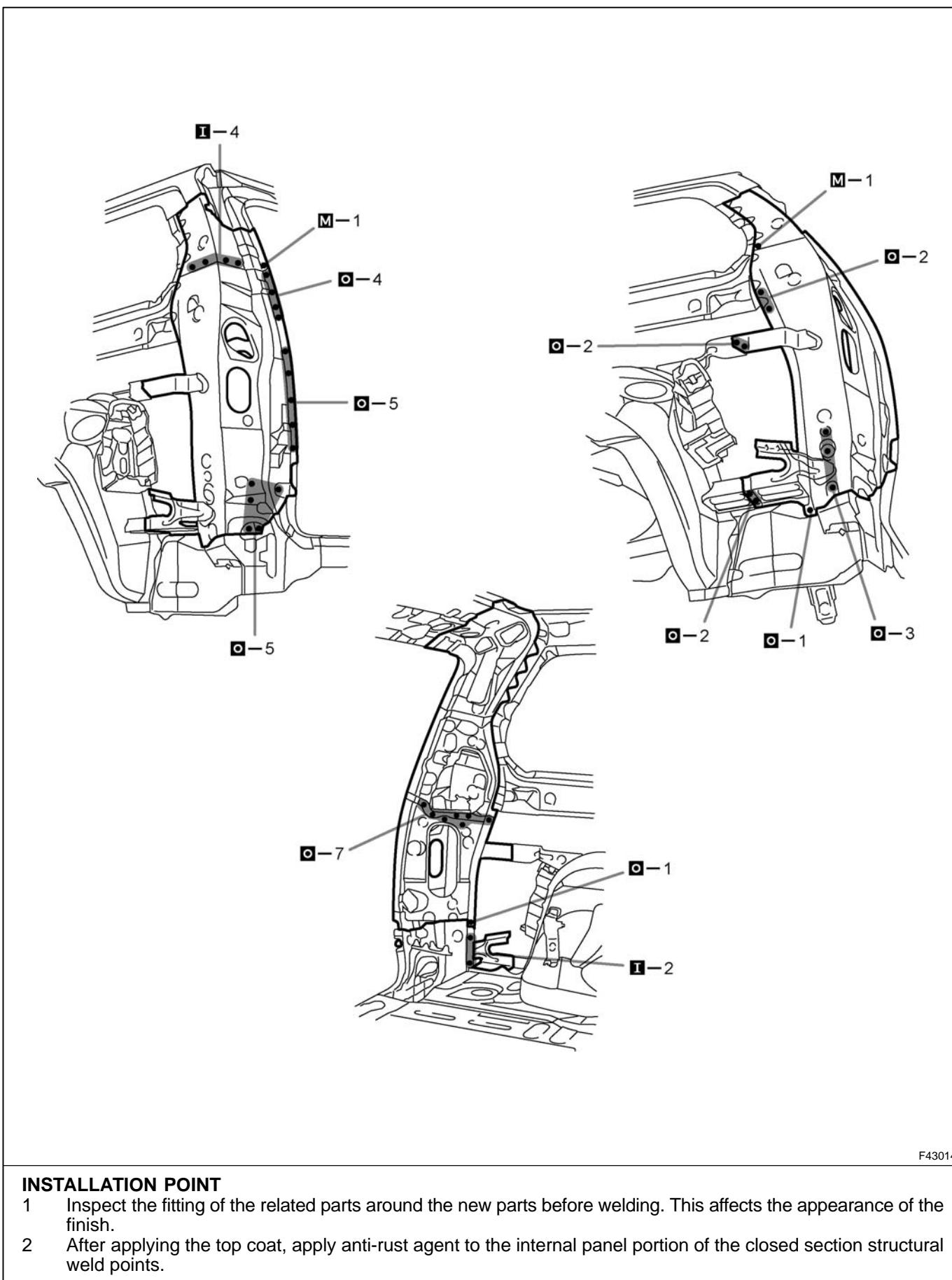
INSTALLATION



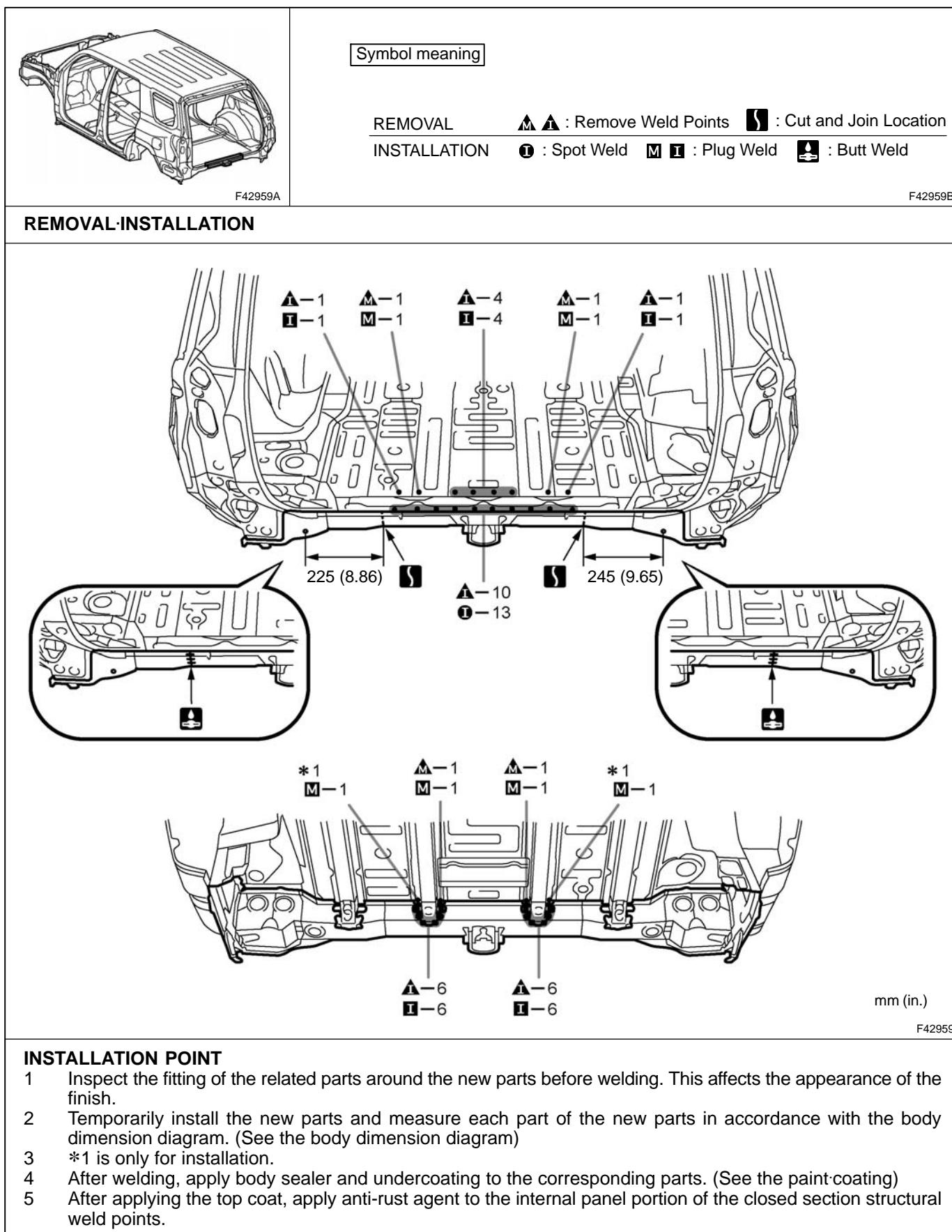
F43013

INSTALLATION POINT

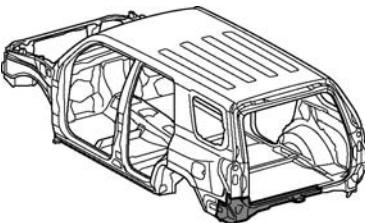
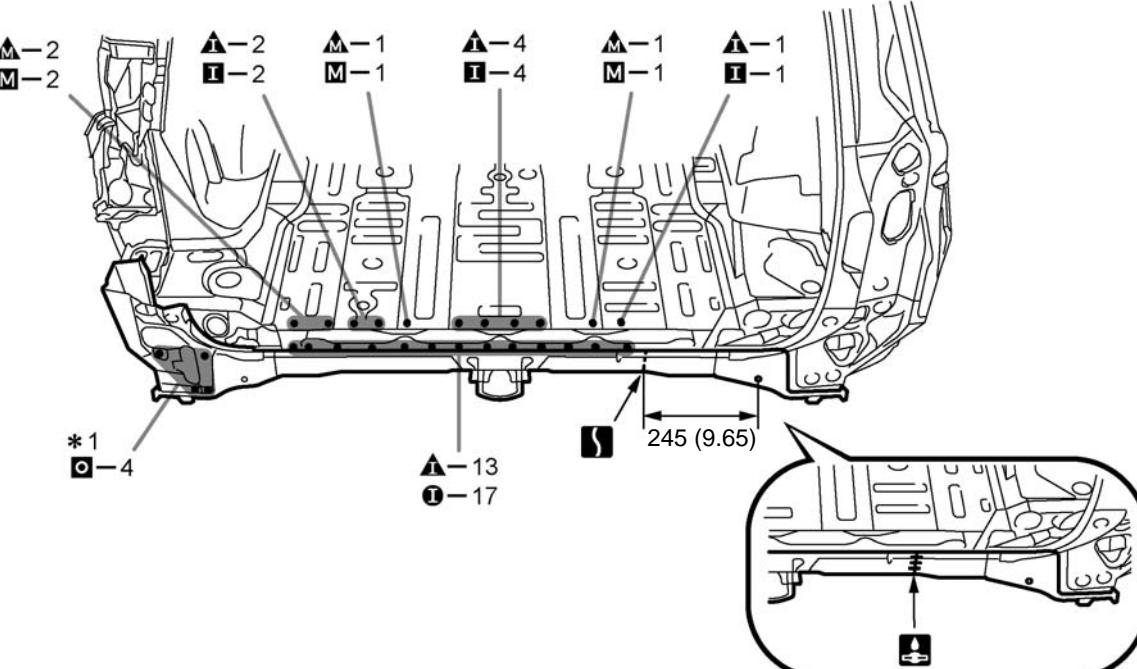
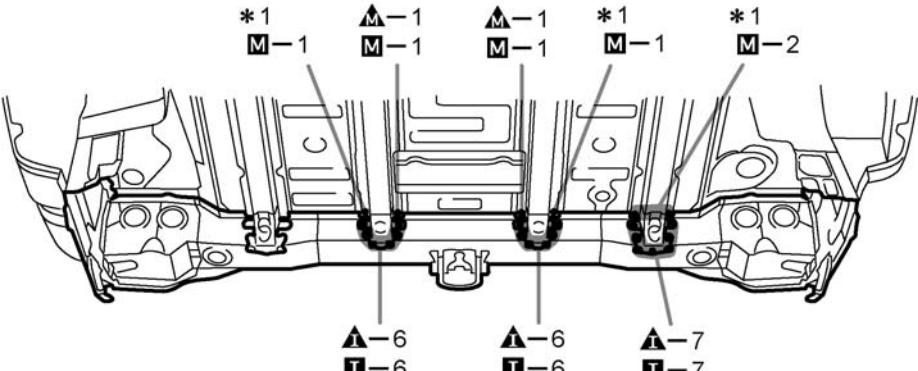
- 1 If the entire supply part is not needed, remove the part of the supply part that is needed.



BODY LOWER BACK PANEL (CUT)



BODY LOWER BACK PANEL (ASSY)

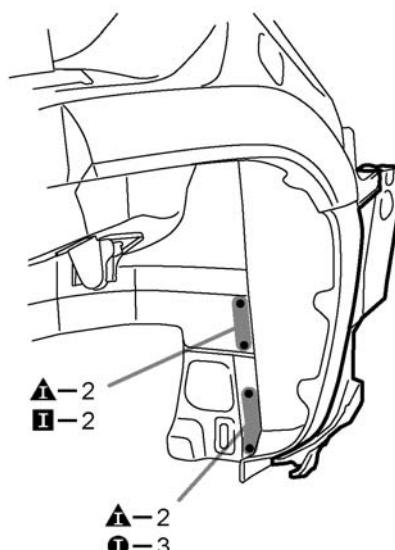
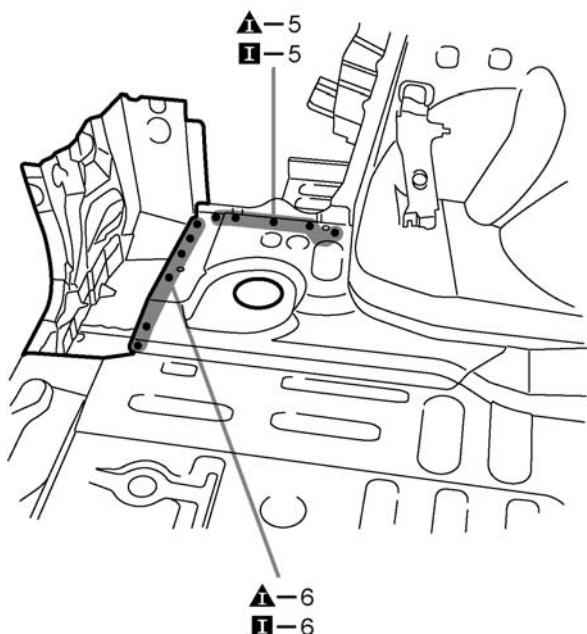
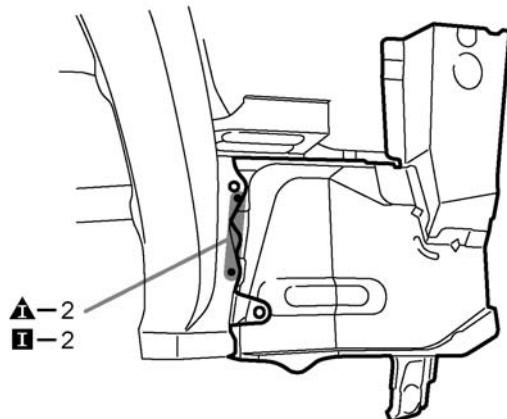
 F42960A	With the roof side inner reinforce removed.
	Symbol meaning REMOVAL : Remove Weld Points : Cut and Join Location
INSTALLATION : Spot Weld : Plug Weld : Butt Weld	F42960B
REMOVAL-INSTALLATION	
[LH Side]	
	
	
INSTALLATION POINT	
1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish. 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram) 3 *1 is only for installation.	

Symbol meaning

REMOVAL : Remove Weld Points : Cut and Join Location
 INSTALLATION : Spot Weld M I : Plug Weld : Butt Weld

F42960B

[LH Side]

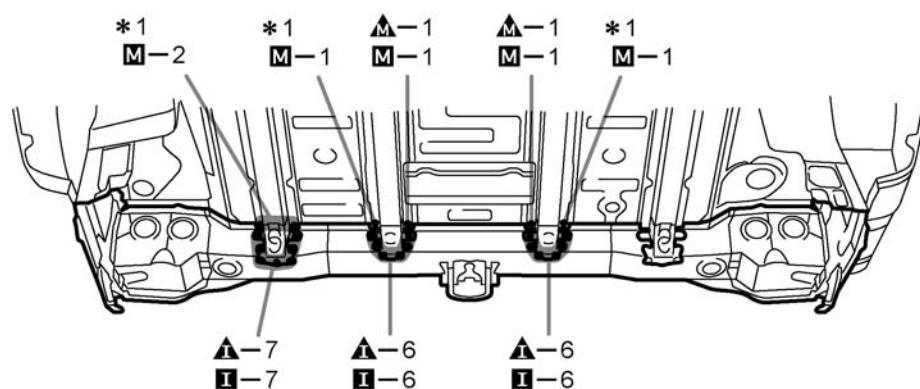
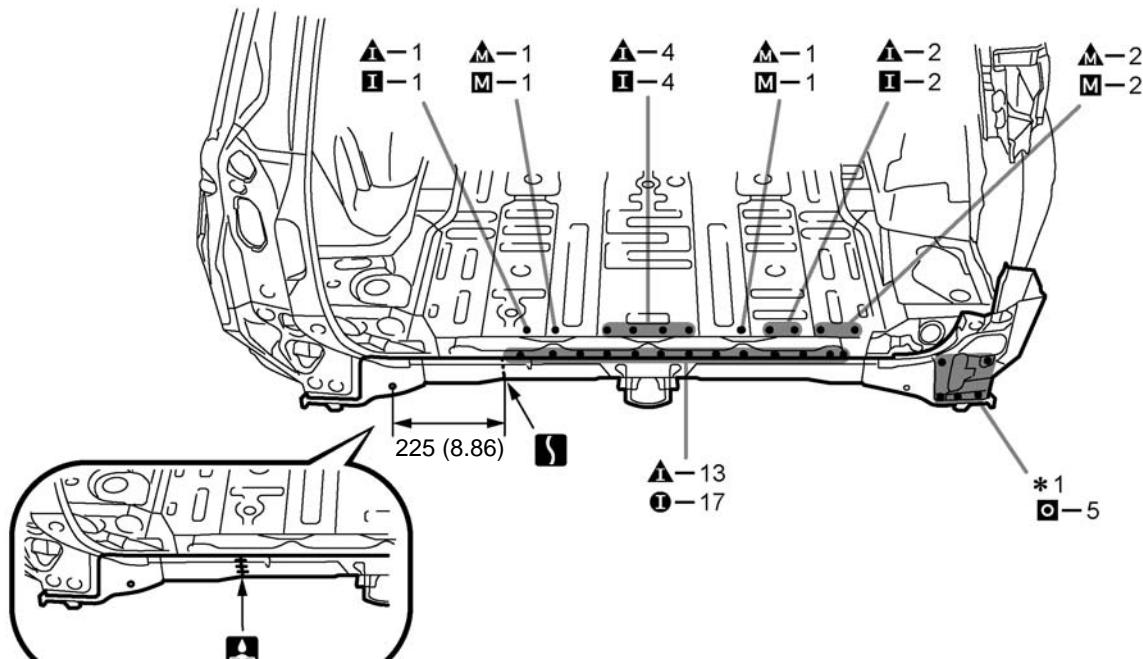


F42961

INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 After welding, apply body sealer and undercoating to the corresponding parts. (See the paint-coating)
- 4 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

[RH Side]



mm (in.)

F42962

INSTALLATION POINT

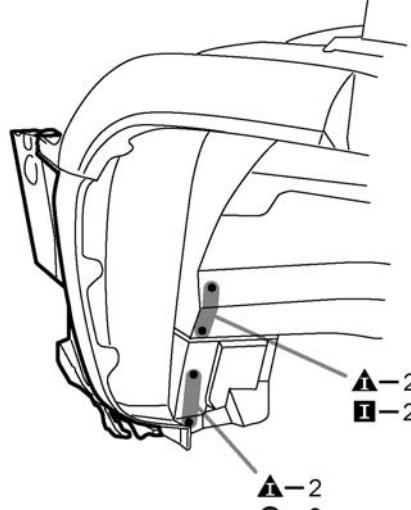
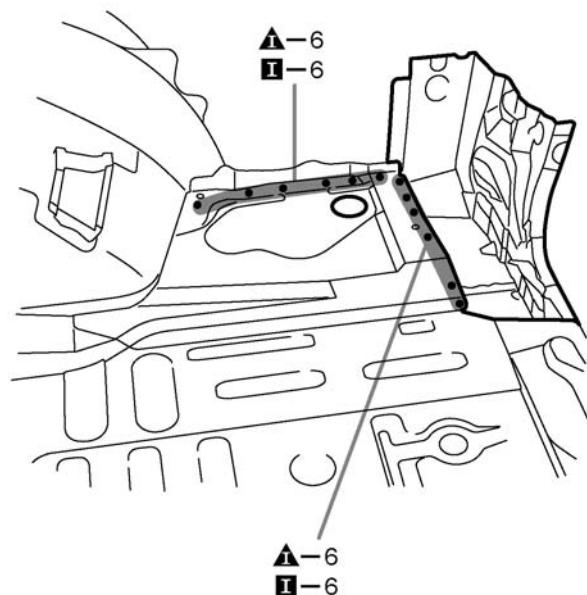
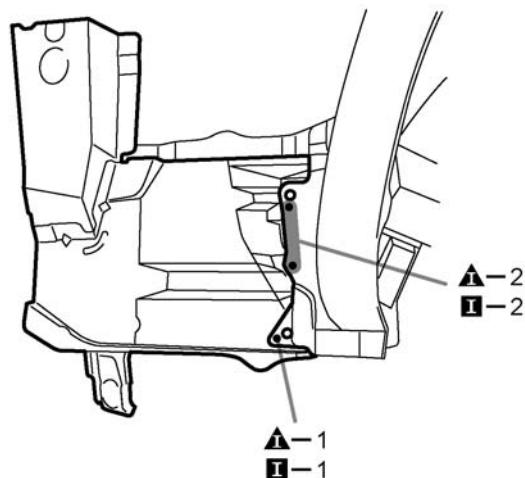
- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 *1 is only for installation.

Symbol meaning

REMOVAL : Remove Weld Points : Cut and Join Location
 INSTALLATION : Spot Weld : Plug Weld : Butt Weld

F42960B

[RH Side]

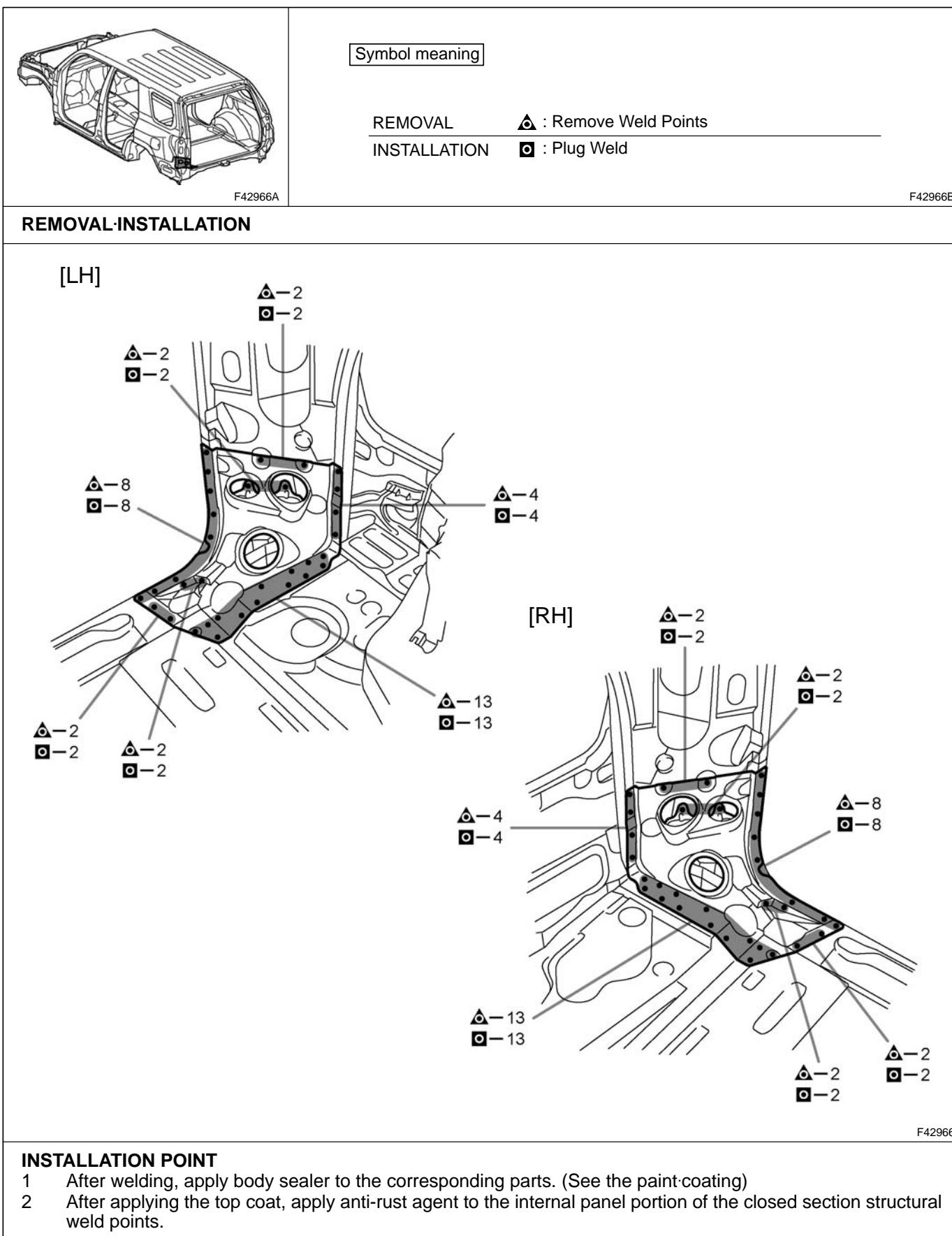


F42963

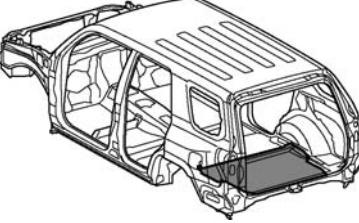
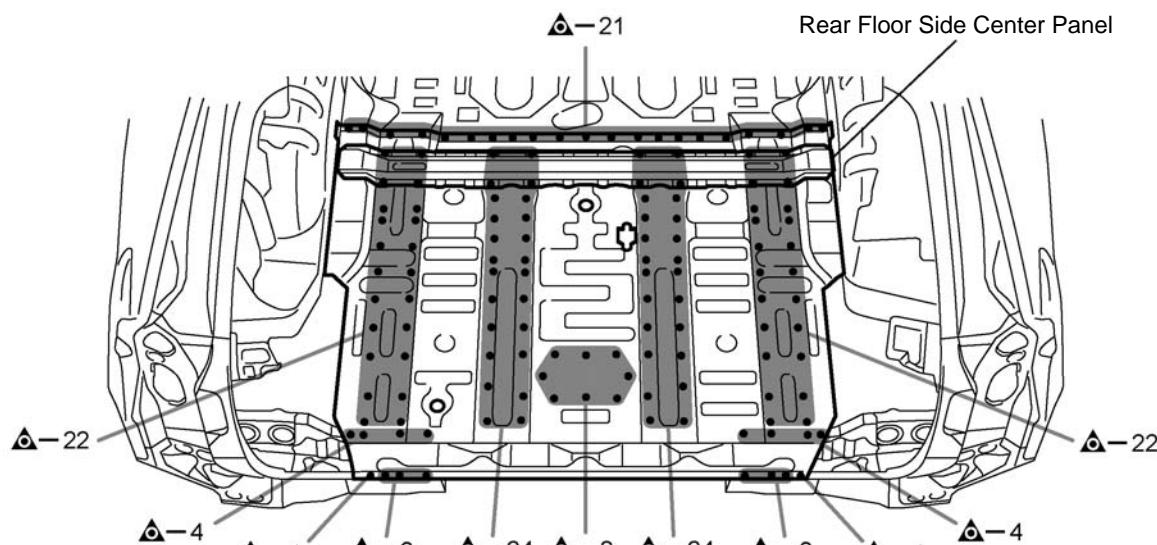
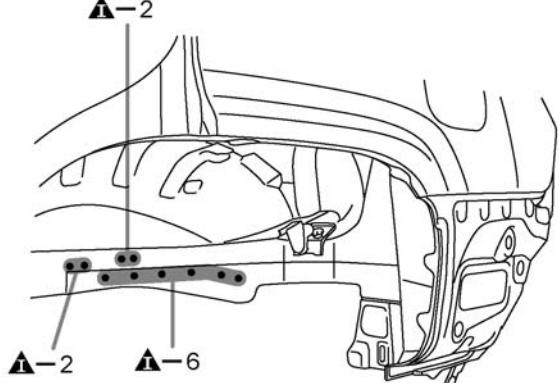
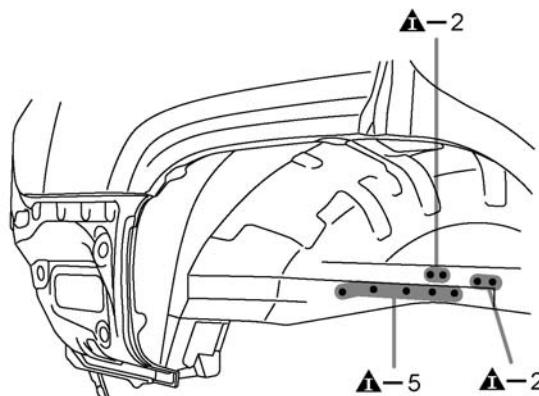
INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 After welding, apply body sealer and undercoating to the corresponding parts. (See the paint-coating)
- 4 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

REAR FLOOR CROSSMEMBER NO. 2 (ASSY)



REAR FLOOR PAN (ASSY)

 F42967A	<p>With the body lower back panel and rear floor side panel removed.</p> <p>Symbol meaning</p> <p>▲ : Remove Weld Points</p>
	F42967B
REMOVAL	
 <p>[LH Side]</p>  <p>[RH Side]</p> 	
REMOVAL POINT	
1 Remove the rear floor side center panel at the same time.	

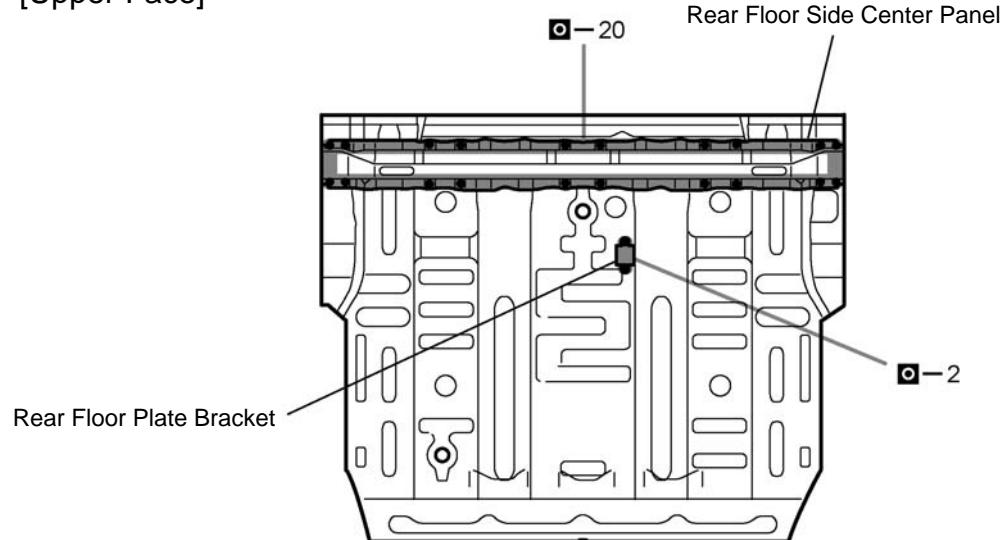
Symbol meaning

◎ : Spot Weld ◻ I : Plug Weld ◇ : Fillet Weld

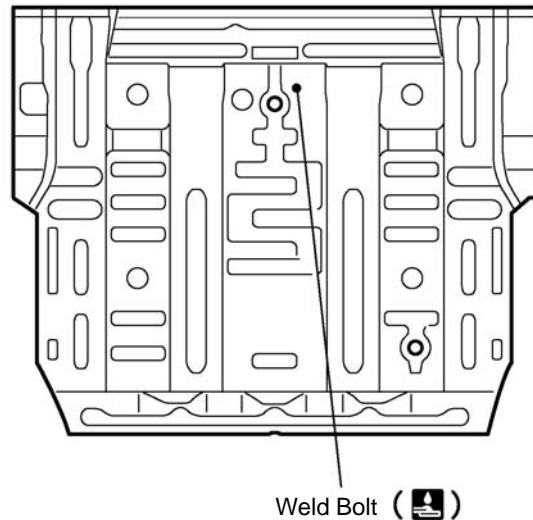
F42968B

INSTALLATION

[Upper Face]



[Lower Face]



F42968

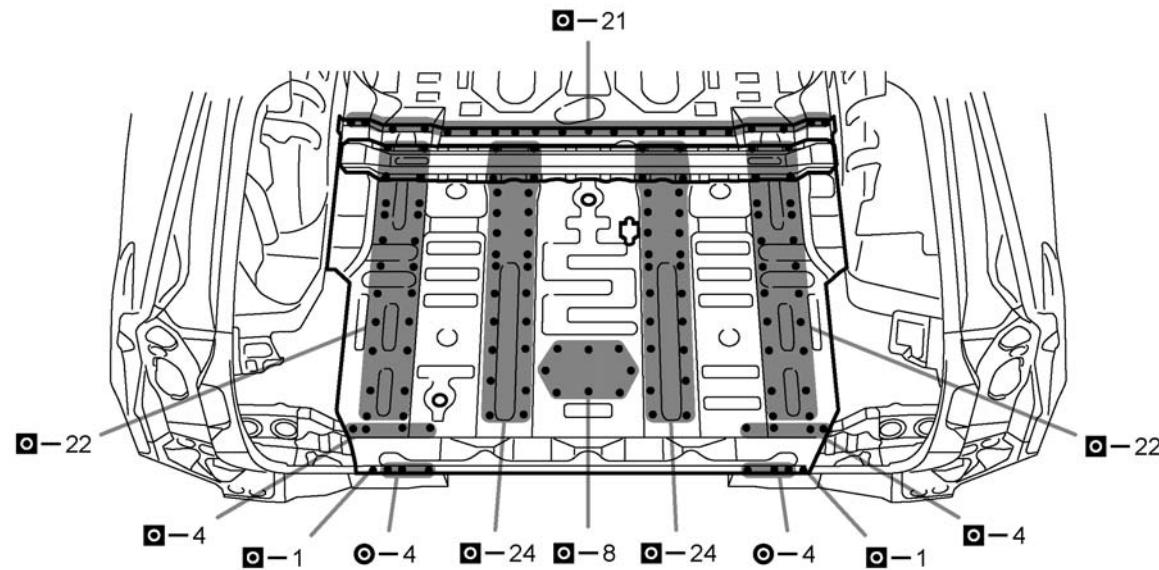
INSTALLATION POINT

- 1 Before temporarily installing the new parts, weld the rear floor side center panel, rear floor plate bracket and weld bolt with the standard number of welding points.

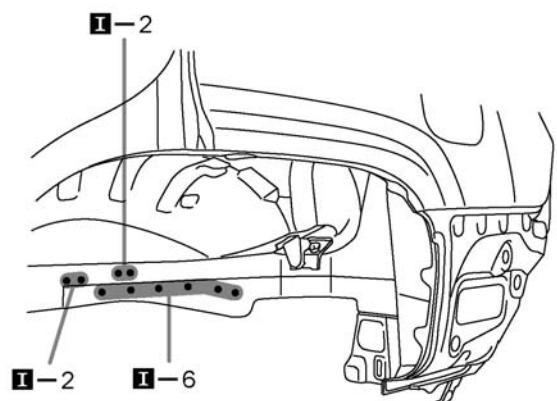
Symbol meaning

◎ : Spot Weld ◻ I : Plug Weld 🔥 : Fillet Weld

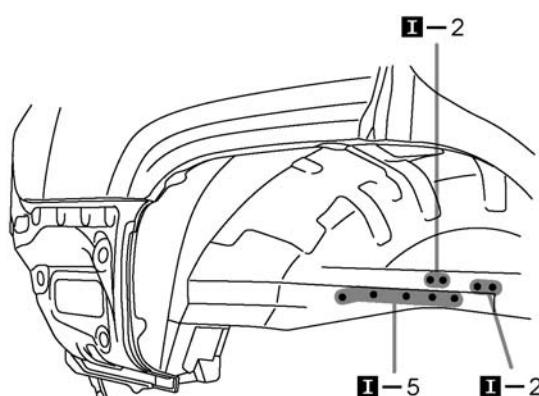
F42968B



[LH Side]



[RH Side]

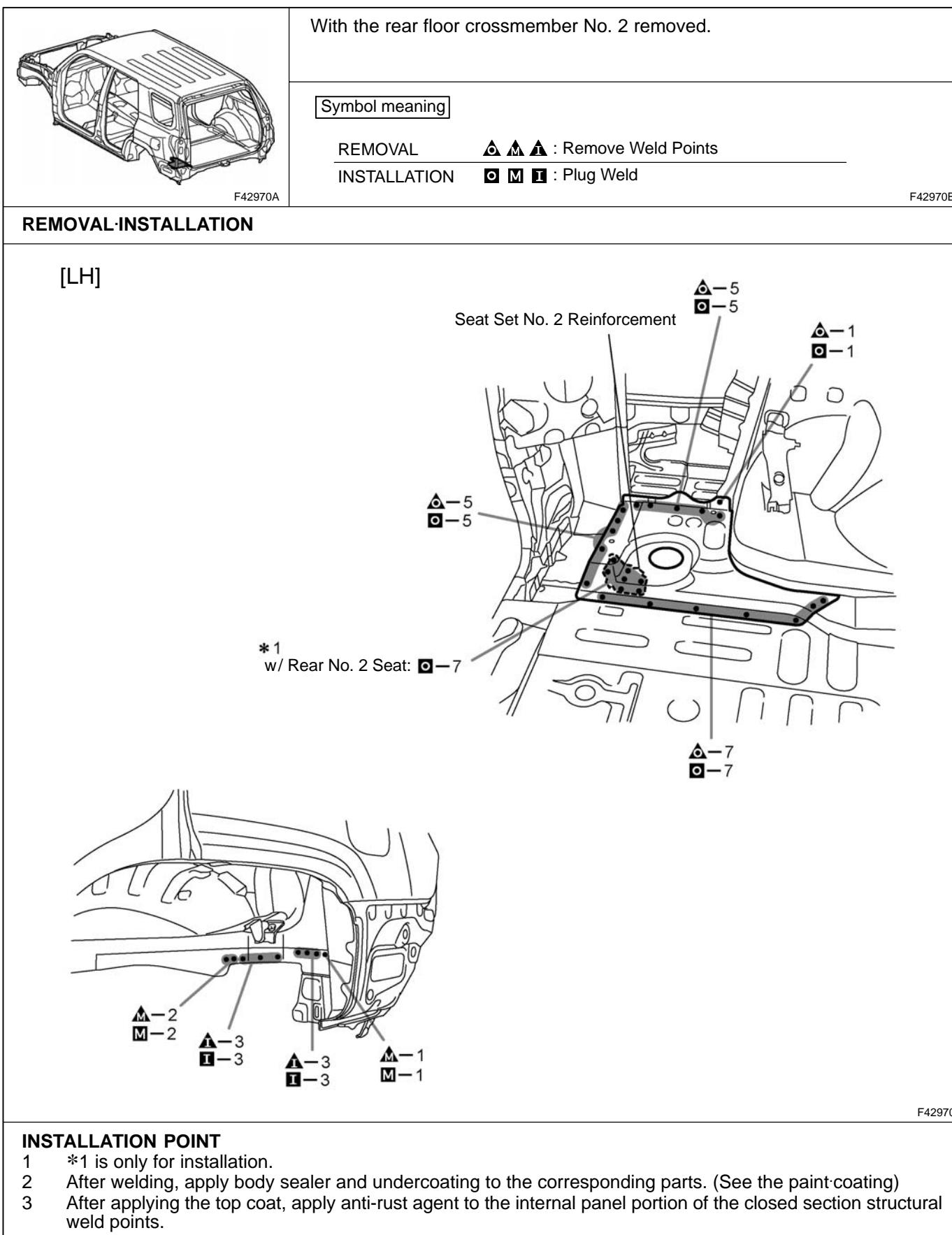


F42969

INSTALLATION POINT

- 1 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 2 After welding, apply body sealer and undercoating to the corresponding parts. (See the paint-coating)
- 3 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

REAR FLOOR SIDE PANEL (ASSY)



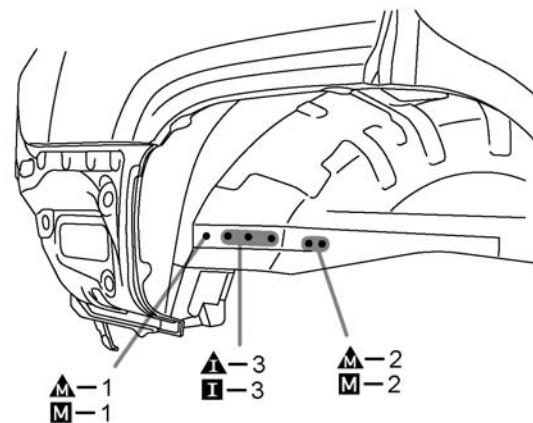
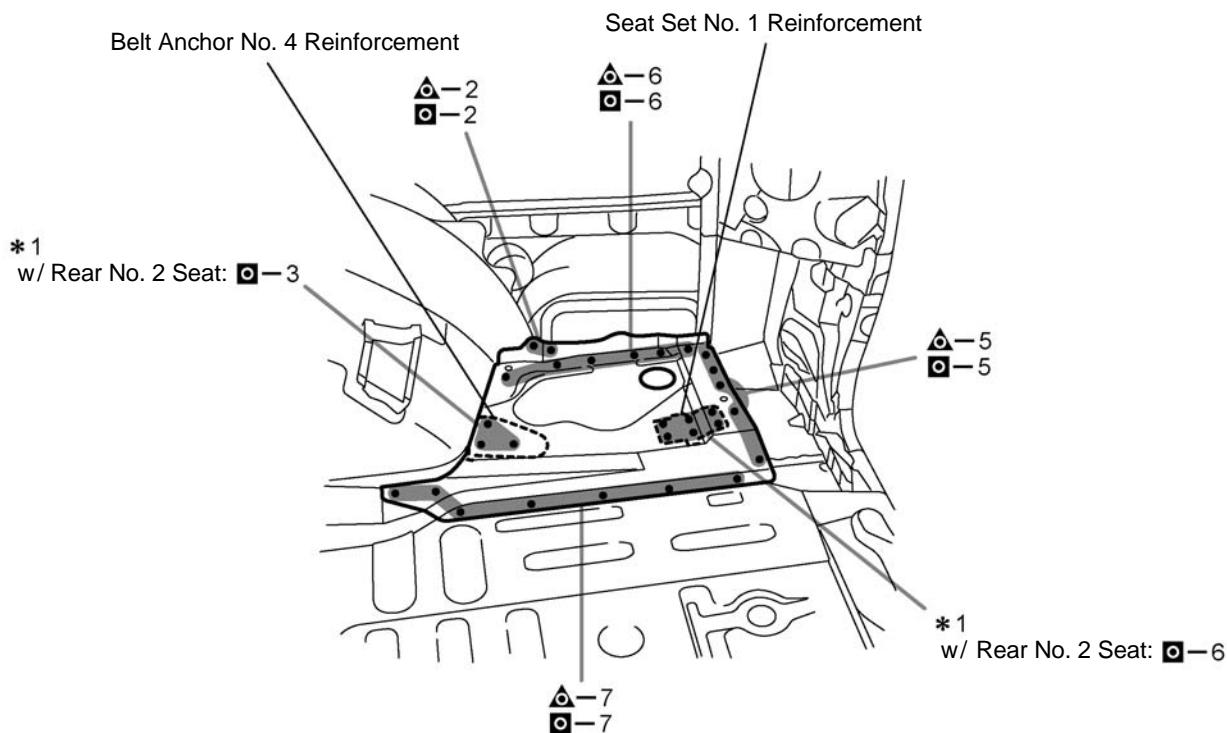
Symbol meaning

REMOVAL : Remove Weld Points

INSTALLATION : Plug Weld

F42970B

[RH]

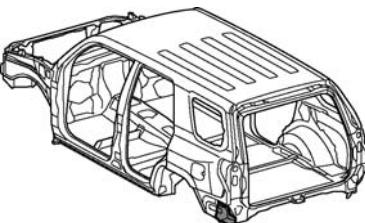
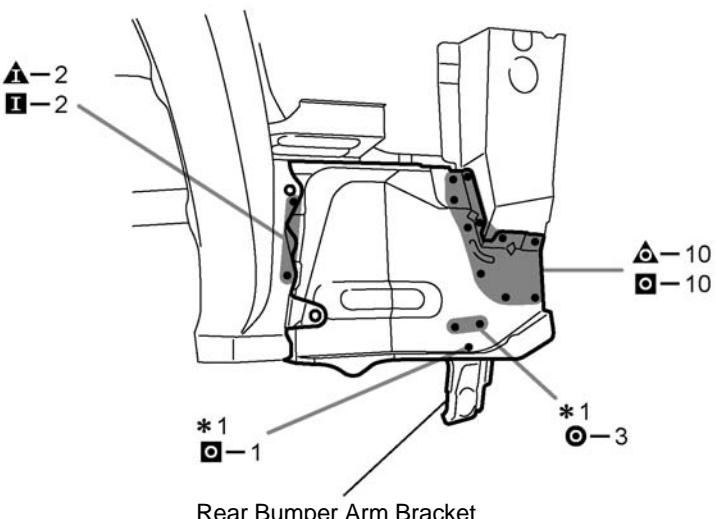
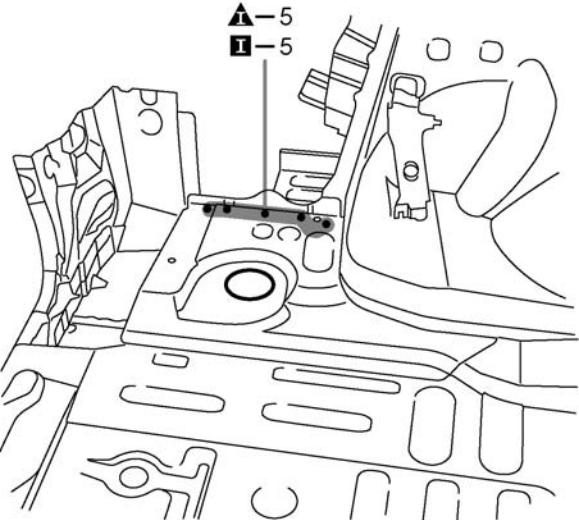
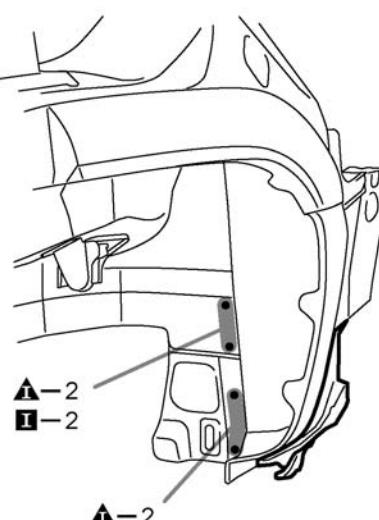


F42971

INSTALLATION POINT

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

REAR FLOOR SIDE PANEL REAR EXTENSION (ASSY)

 F42972A	With the roof side inner reinforce removed.								
	Symbol meaning <table border="0"> <tr> <td>REMOVAL</td> <td></td> <td>: Remove Weld Points</td> </tr> <tr> <td>INSTALLATION</td> <td></td> <td>: Spot Weld</td> </tr> <tr> <td></td> <td></td> <td>: Plug Weld</td> </tr> </table>	REMOVAL		: Remove Weld Points	INSTALLATION		: Spot Weld		
REMOVAL		: Remove Weld Points							
INSTALLATION		: Spot Weld							
		: Plug Weld							
F42972B									
REMOVAL·INSTALLATION									
<p>[LH]</p> 									
 									
F42972									
<p>INSTALLATION POINT</p> <p>1 *1 is only for installation. 2 After welding, apply body sealer and undercoating to the corresponding parts. (See the paint·coating) 3 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.</p>									

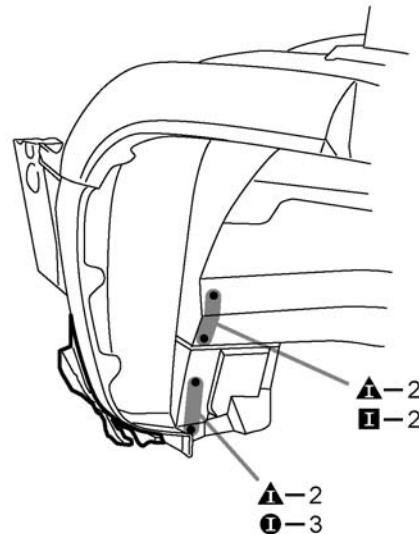
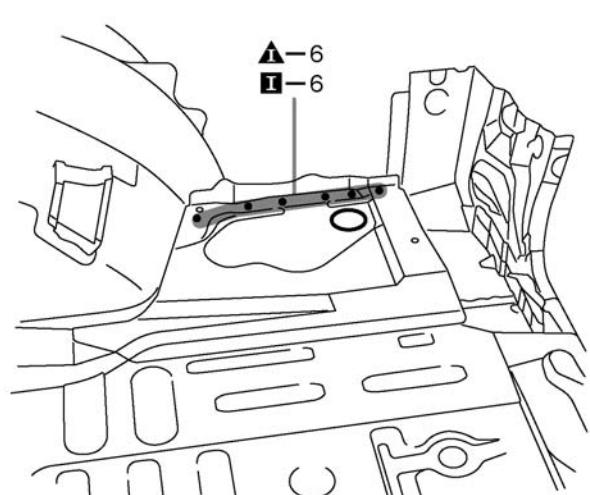
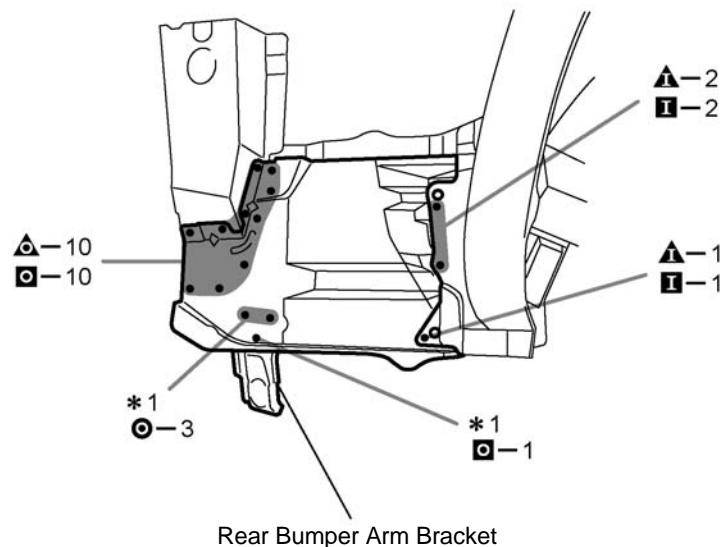
Symbol meaning

REMOVAL : Remove Weld Points

INSTALLATION : Spot Weld : Plug Weld

F42972B

[RH]

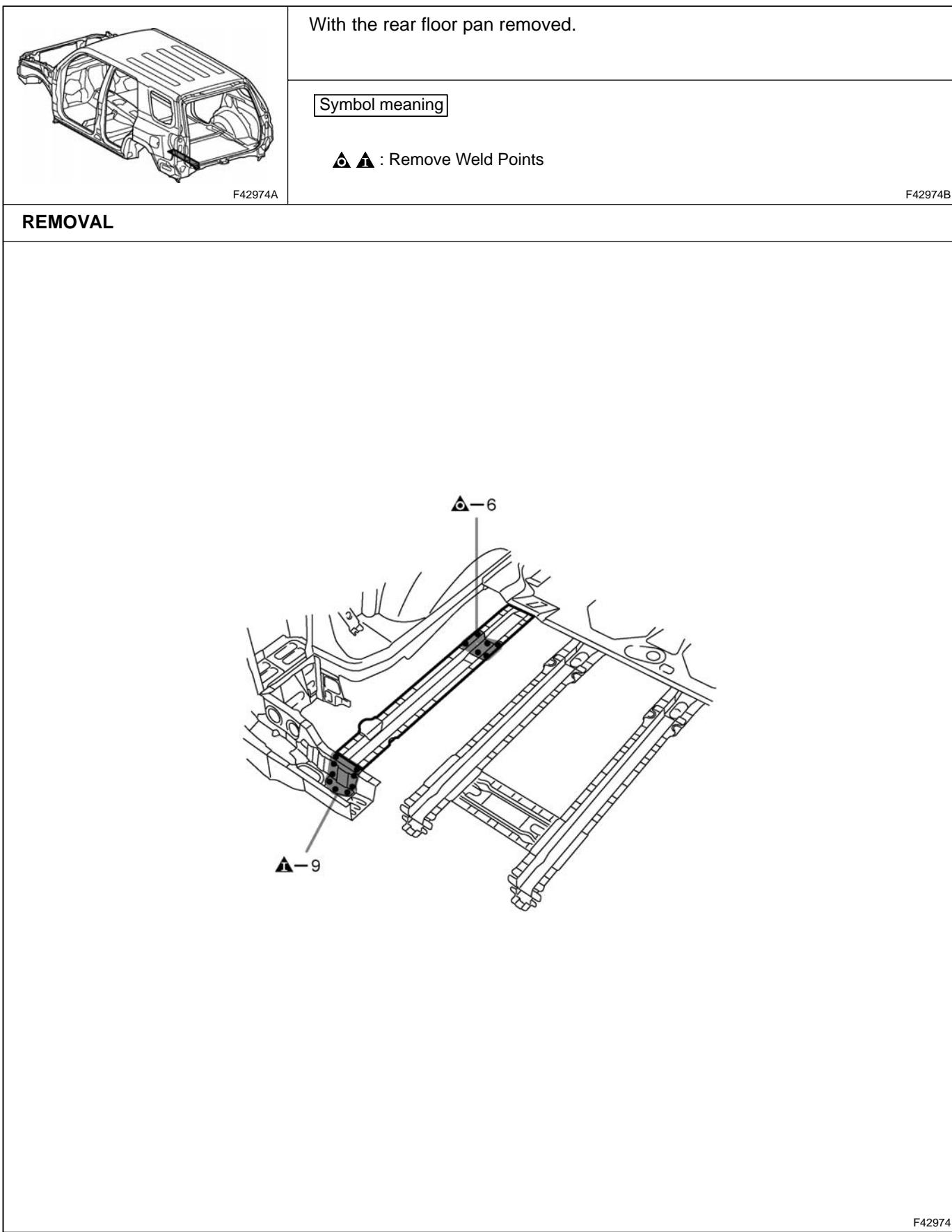


F42973

INSTALLATION POINT

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

REAR FLOOR SIDE MEMBER (CUT)

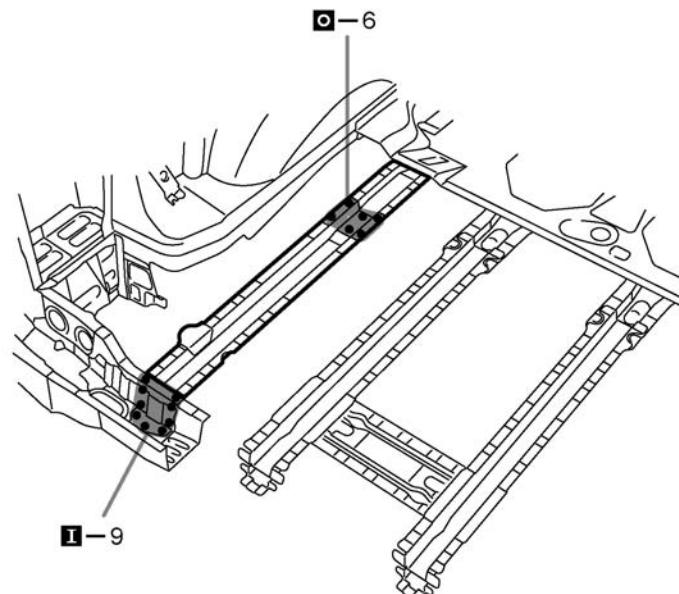
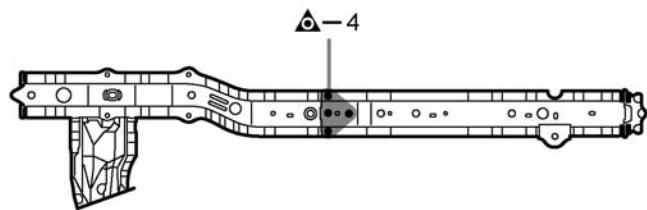


Symbol meaning

▲ : Remove Weld Points □ I : Plug Weld

F43011B

INSTALLATION

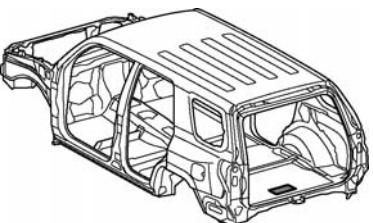
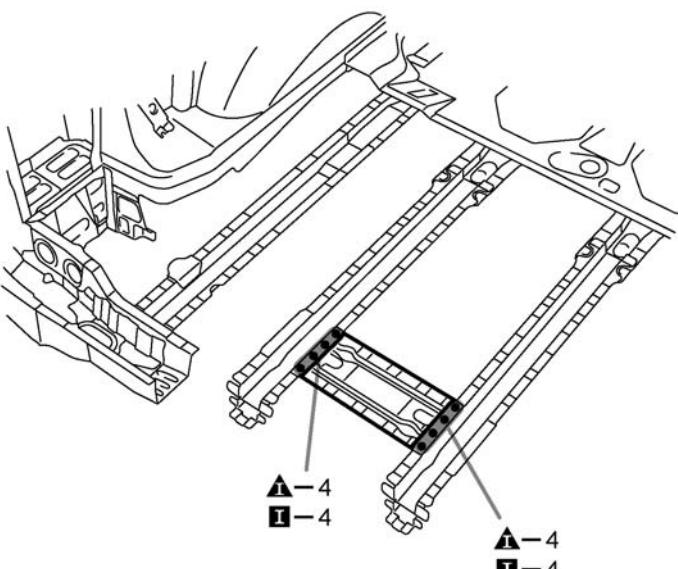


F43011

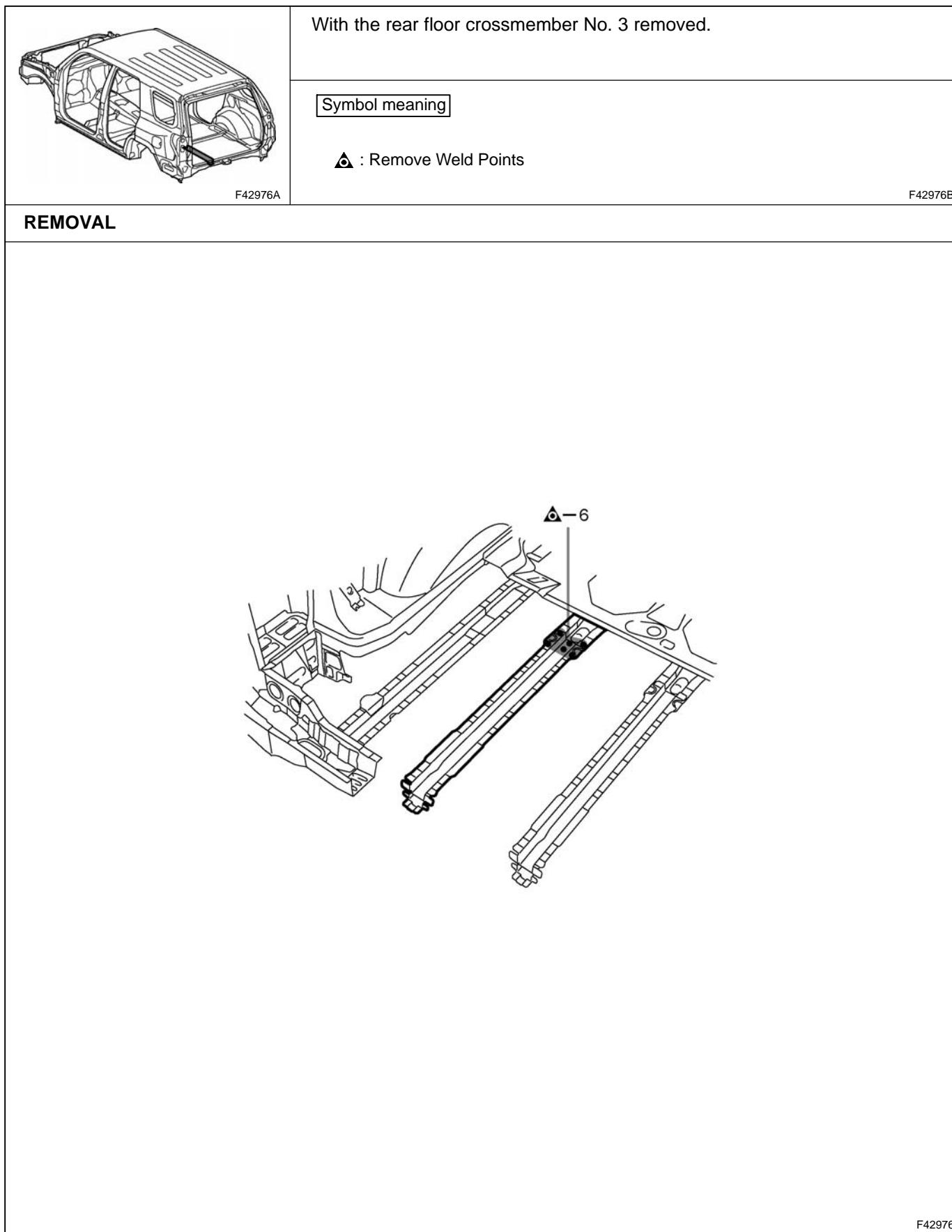
INSTALLATION POINT

- 1 If the entire supply part is not needed, remove the part of the supply part that is needed.
- 2 After welding, apply undercoating to the corresponding parts. (See the paint-coating)
- 3 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

REAR FLOOR CROSSMEMBER NO. 3 (ASSY)

 F42975A	With the rear floor pan removed.
	Symbol meaning
	REMOVAL  : Remove Weld Points
	INSTALLATION  : Plug Weld
	F42975B
REMOVAL·INSTALLATION	
	
F42975	
INSTALLATION POINT	
1 After welding, apply undercoating to the corresponding parts. (See the paint-coating) 2 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.	

REAR FLOOR SIDE CENTER MEMBER (CUT)

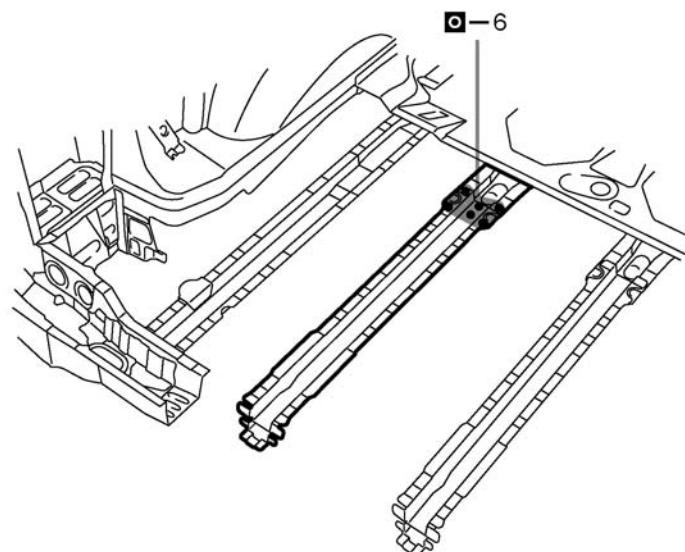
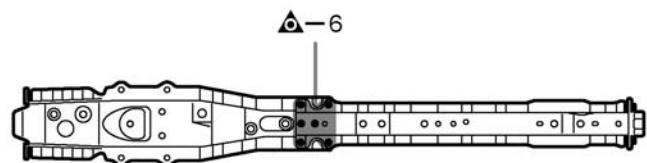


Symbol meaning

▲ : Remove Weld Points □ : Plug Weld

F43012B

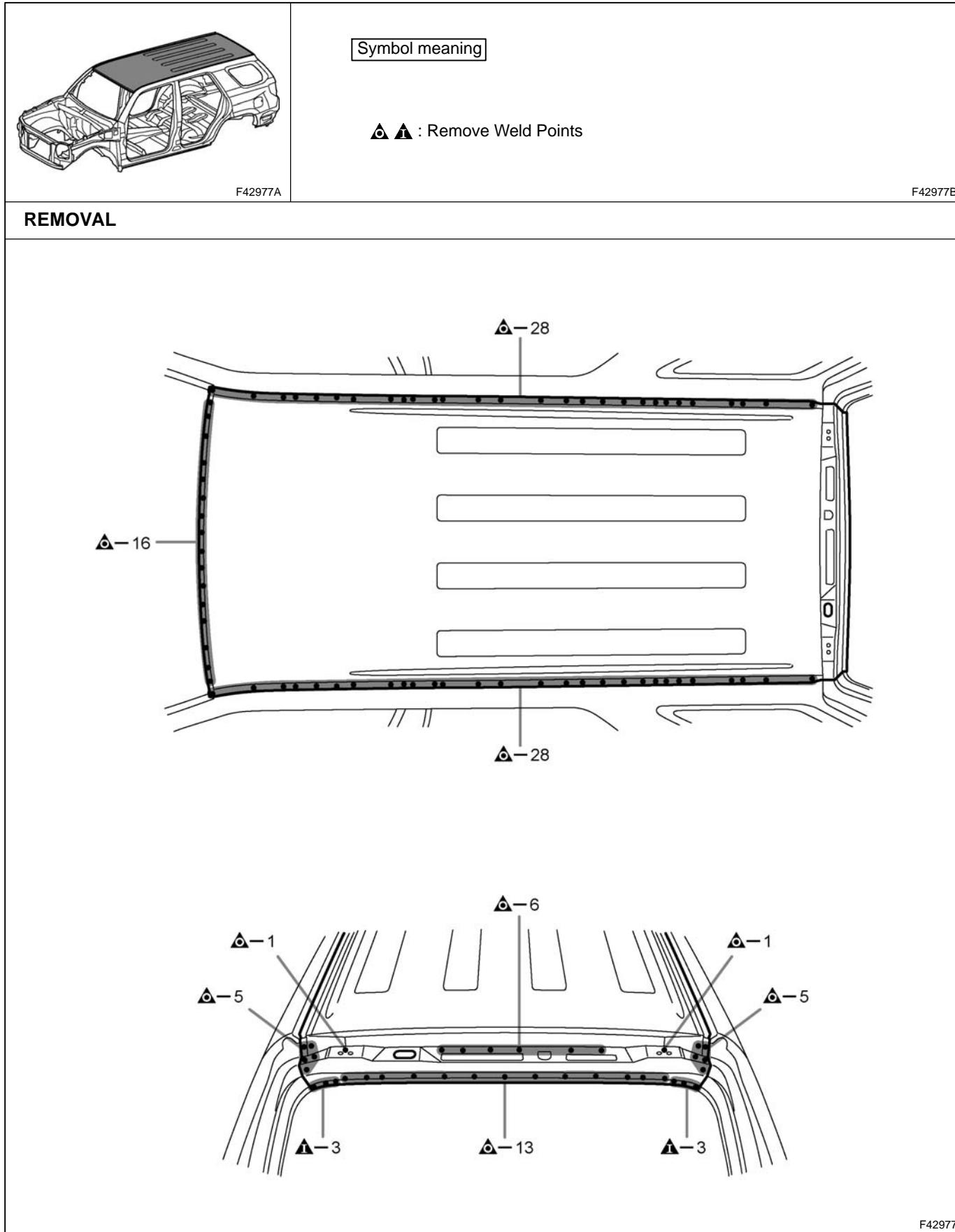
INSTALLATION



F43012

INSTALLATION POINT

- 1 If the entire supply part is not needed, remove the part of the supply part that is needed.
- 2 After welding, apply undercoating to the corresponding parts. (See the paint-coating)
- 3 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

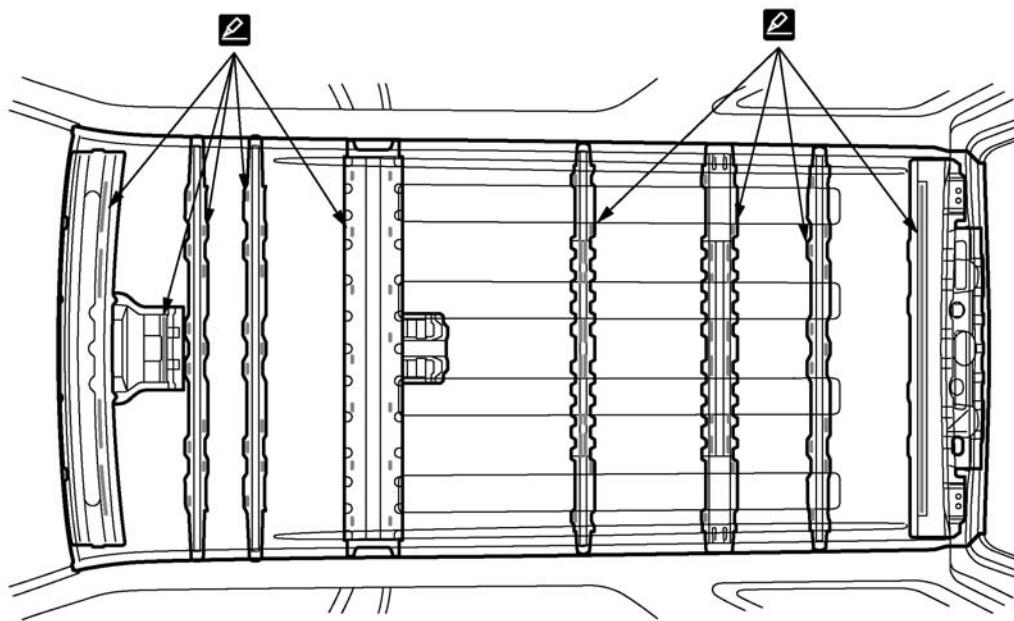
**ROOF PANEL (ASSY):
w/o Sliding Roof**

Symbol meaning

○ I : Plug Weld  : Body Sealer

F42978B

INSTALLATION



F42978

INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 After the roof panel reinforcement is welded to the new parts, install the roof panel to the vehicle side.
- 4 Before temporarily installing the new parts, apply body sealer to the windshield header panel, roof panel reinforcement and back door opening frame.

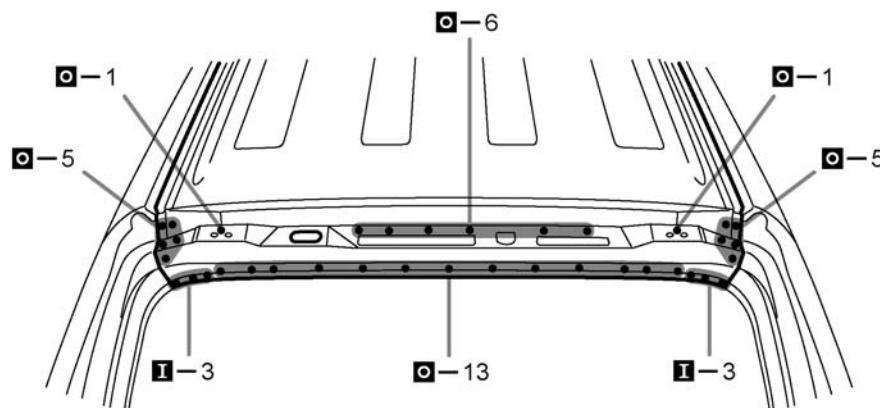
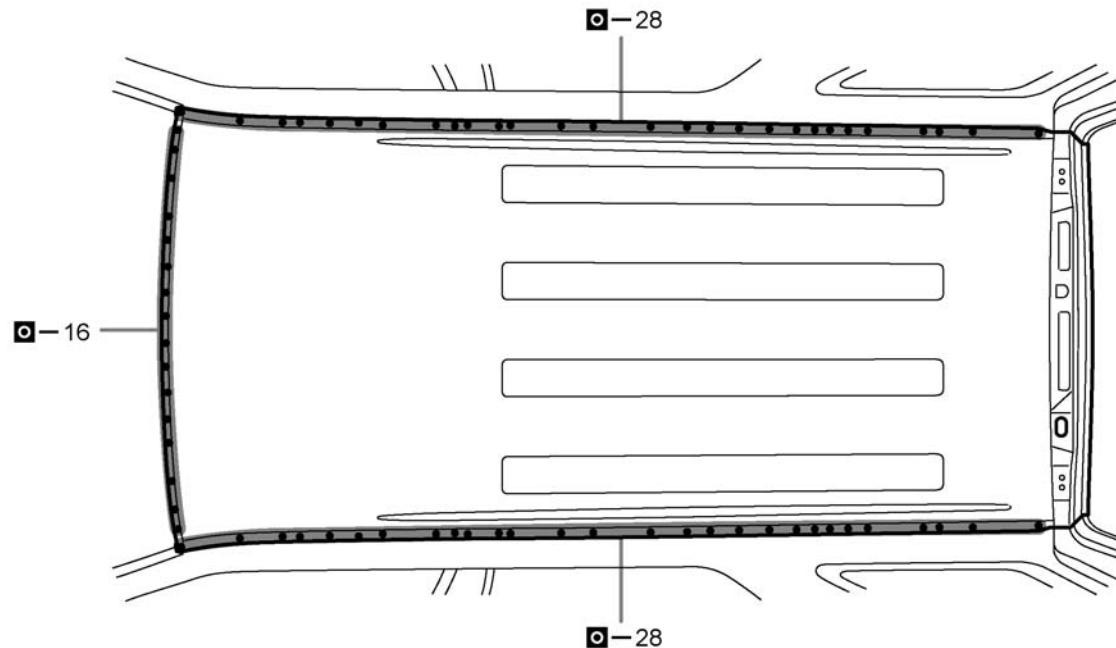
HINT:

Apply just enough body sealer for the new parts to make contact.

Symbol meaning

○ I : Plug Weld  : Body Sealer

F42978B

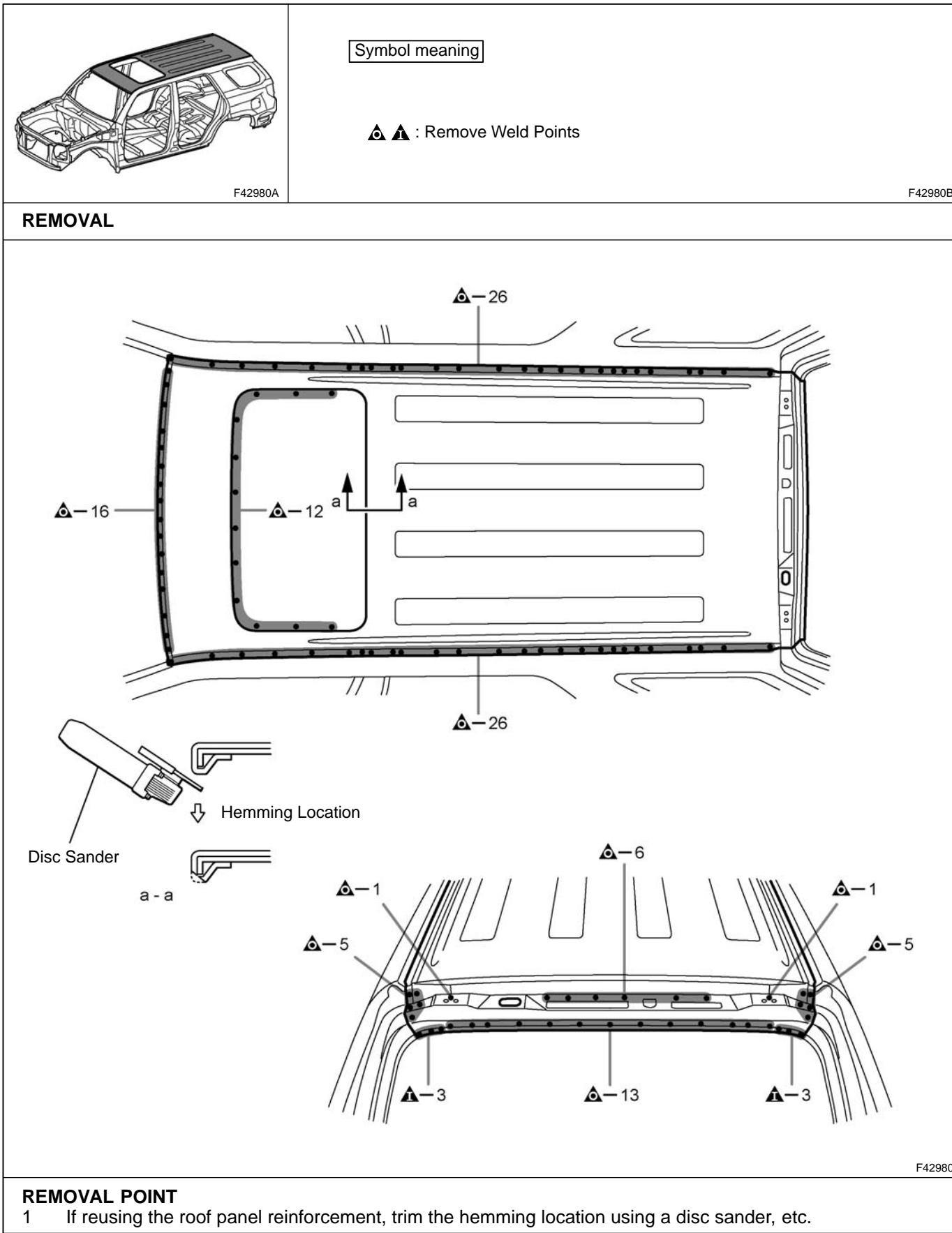


F42979

INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 After welding, apply the foamed sealing material to the corresponding parts. (See the paint-coating)
- 4 After welding, apply body sealer to the corresponding parts. (See the paint-coating)
- 5 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

ROOF PANEL (ASSY): w/ Sliding Roof

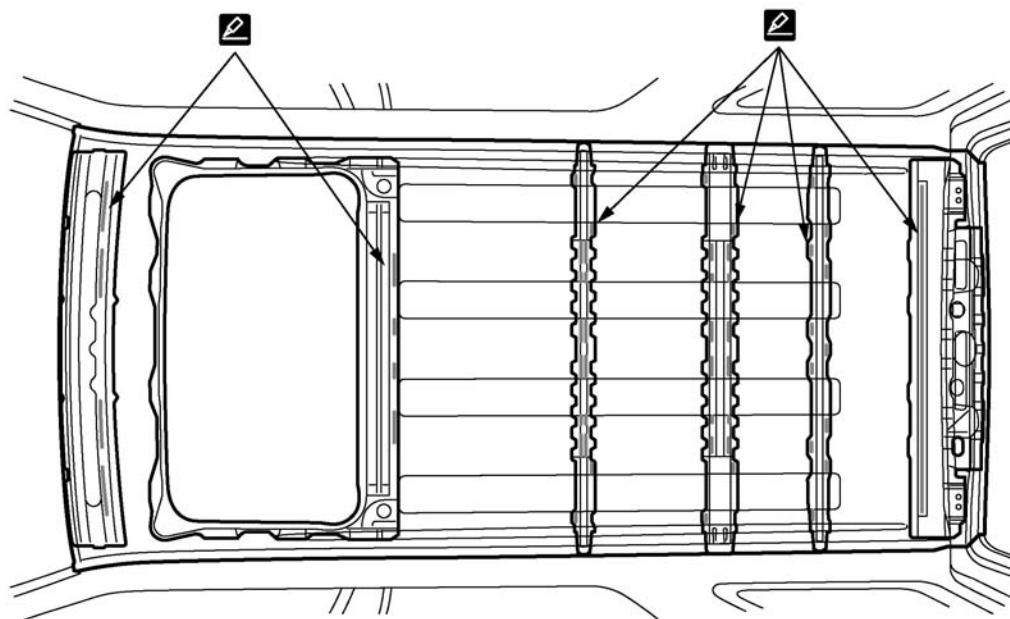


Symbol meaning

○ I : Plug Weld  : Body Sealer

F42981B

INSTALLATION



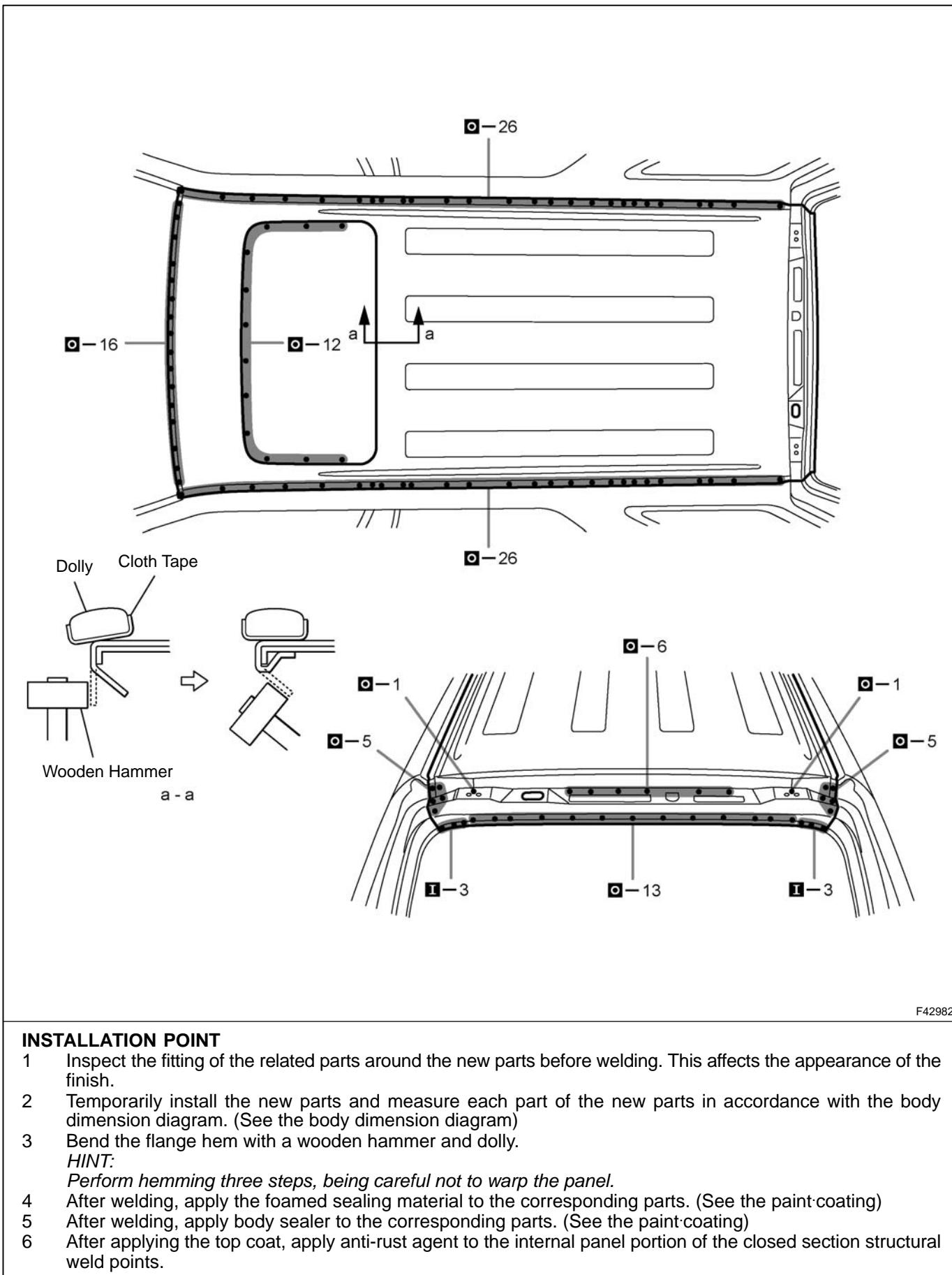
F42981

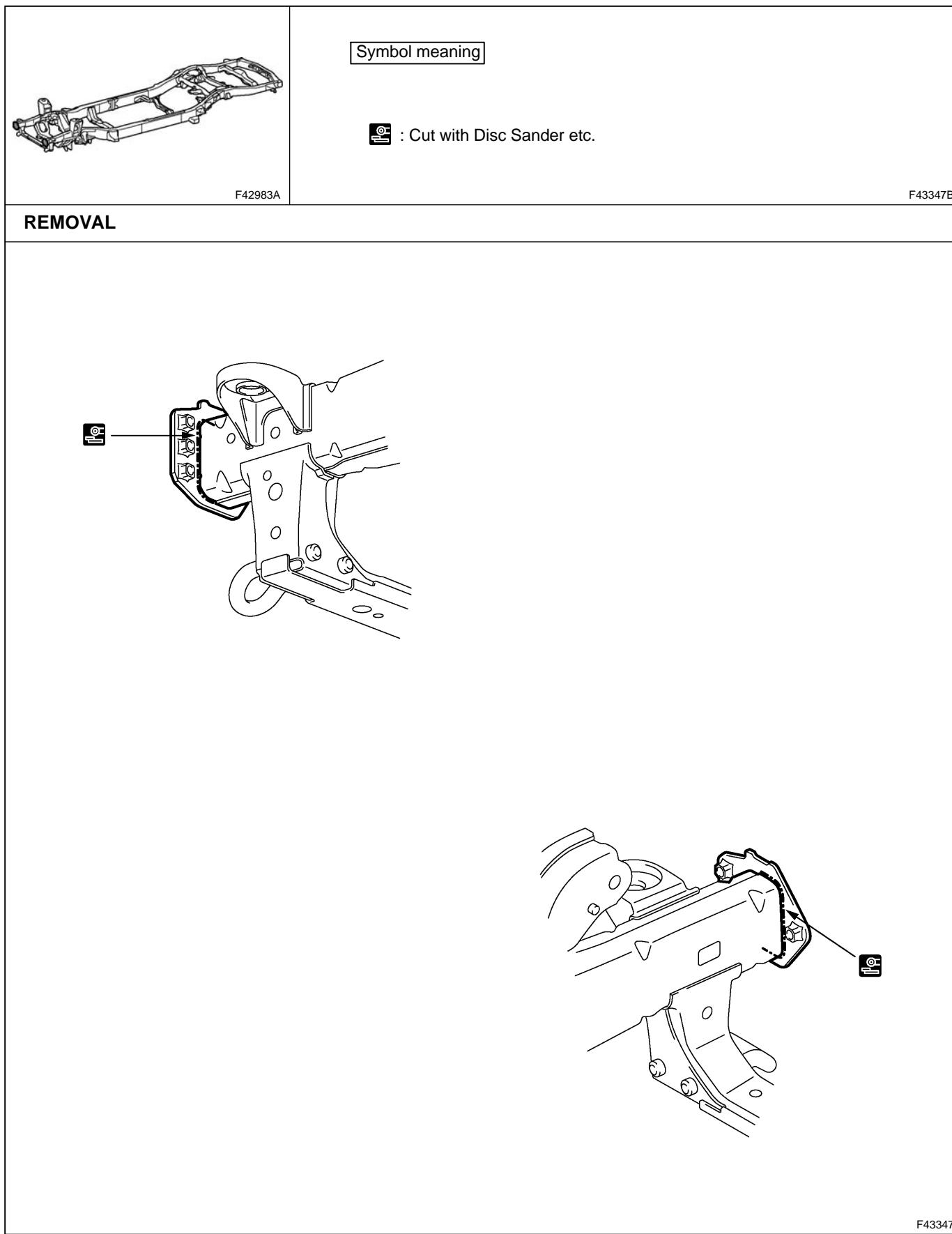
INSTALLATION POINT

- 1 Inspect the fitting of the related parts around the new parts before welding. This affects the appearance of the finish.
- 2 Temporarily install the new parts and measure each part of the new parts in accordance with the body dimension diagram. (See the body dimension diagram)
- 3 After the roof panel reinforcement is welded to the new parts, install the roof panel to the vehicle side.
- 4 Before temporarily installing the new parts, apply body sealer to the windshield header panel, roof panel reinforcement and back door opening frame.

HINT:

Apply just enough body sealer for the new parts to make contact.



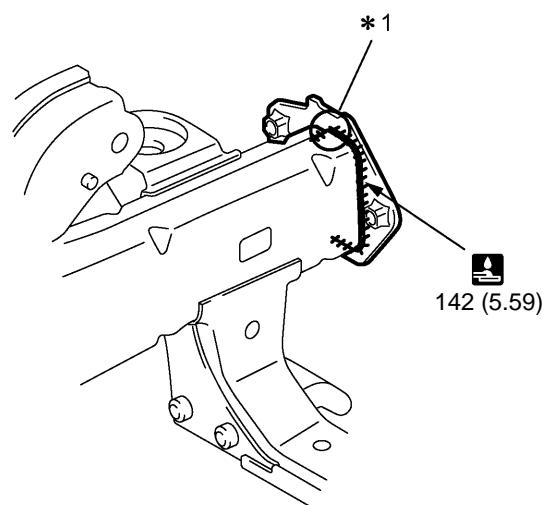
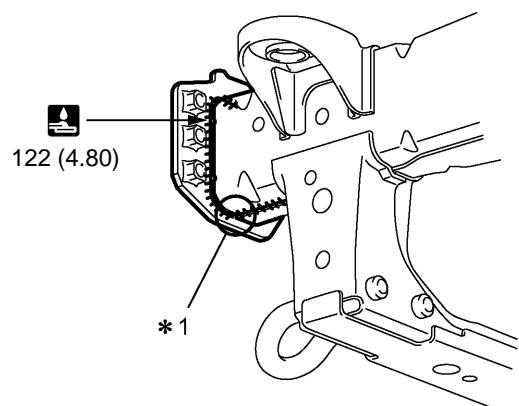
FRAME SIDE RAIL PLATE (ASSY)

Symbol meaning

 : Fillet Weld

F43348B

INSTALLATION



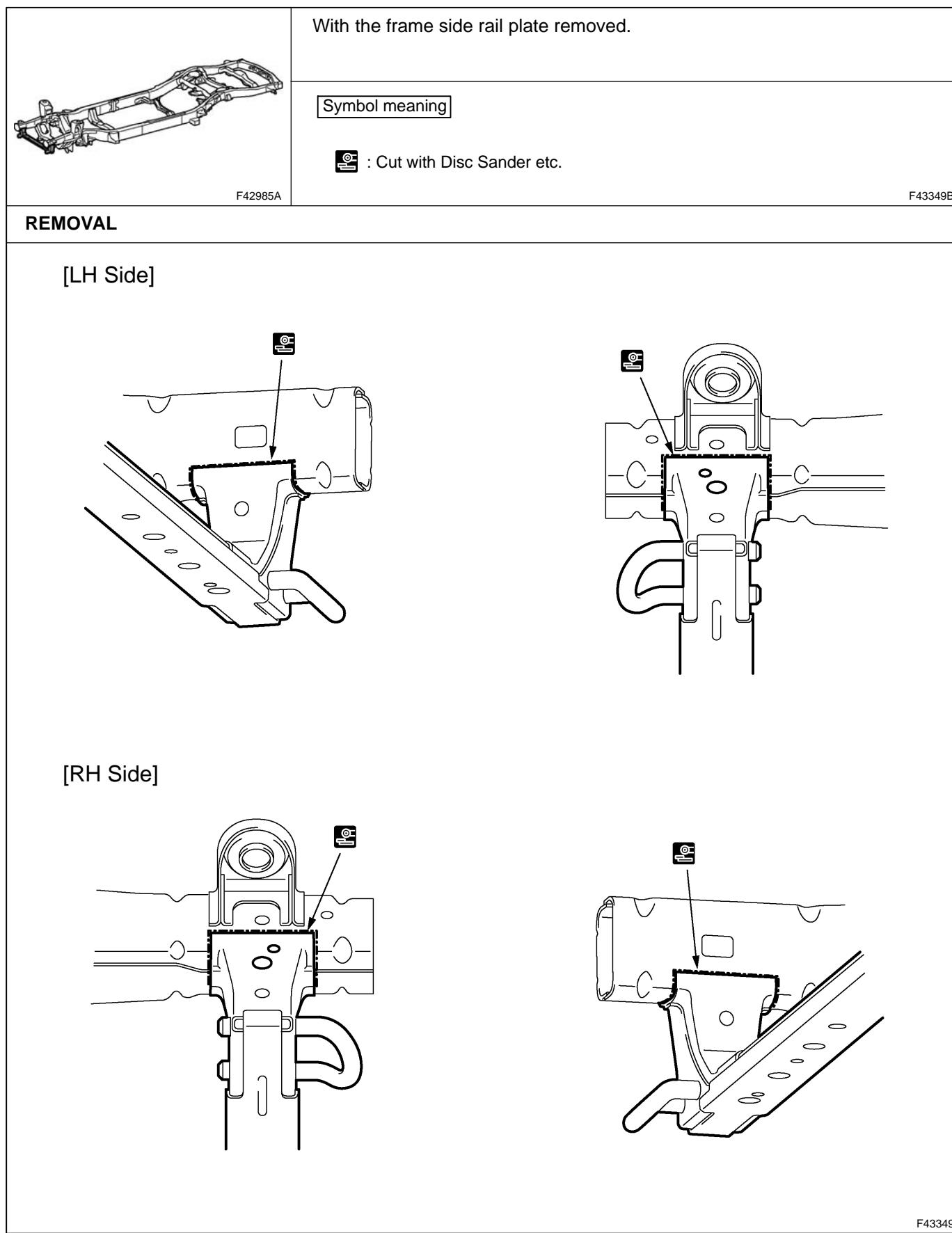
mm (in.)

F43348

INSTALLATION POINT

- 1 Make sure that proper welding can be performed by setting up the welding conditions as necessary before performing work.
- 2 Make sure that the welding bead at *1 is overlapped.
- 3 To prevent heat deformation, weld the right and left side of each part before continuing to the next part.
- 4 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

FRAME AUXILIARY CROSSMEMBER (ASSY)



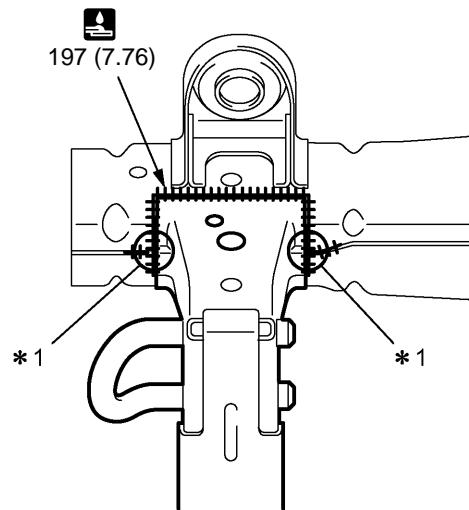
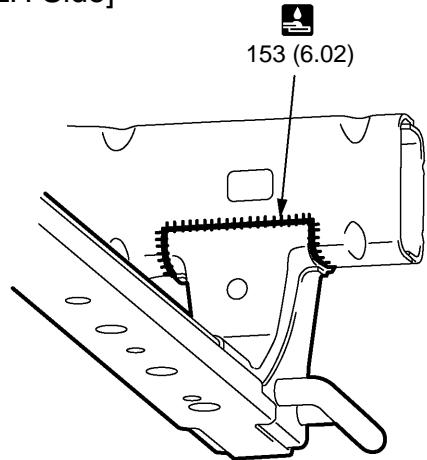
Symbol meaning

 : Fillet Weld

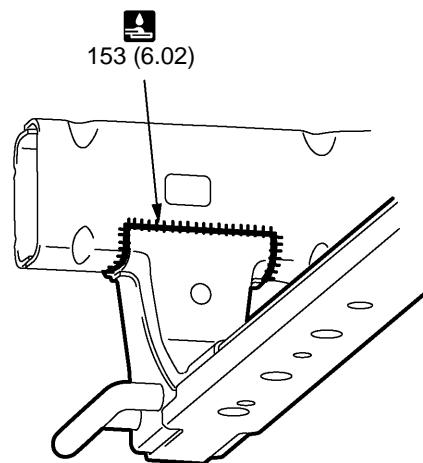
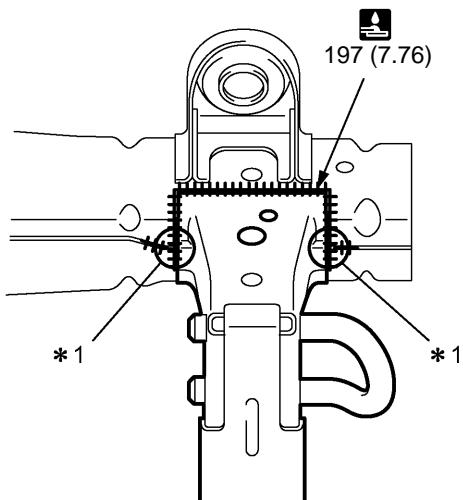
F43350B

INSTALLATION

[LH Side]



[RH Side]

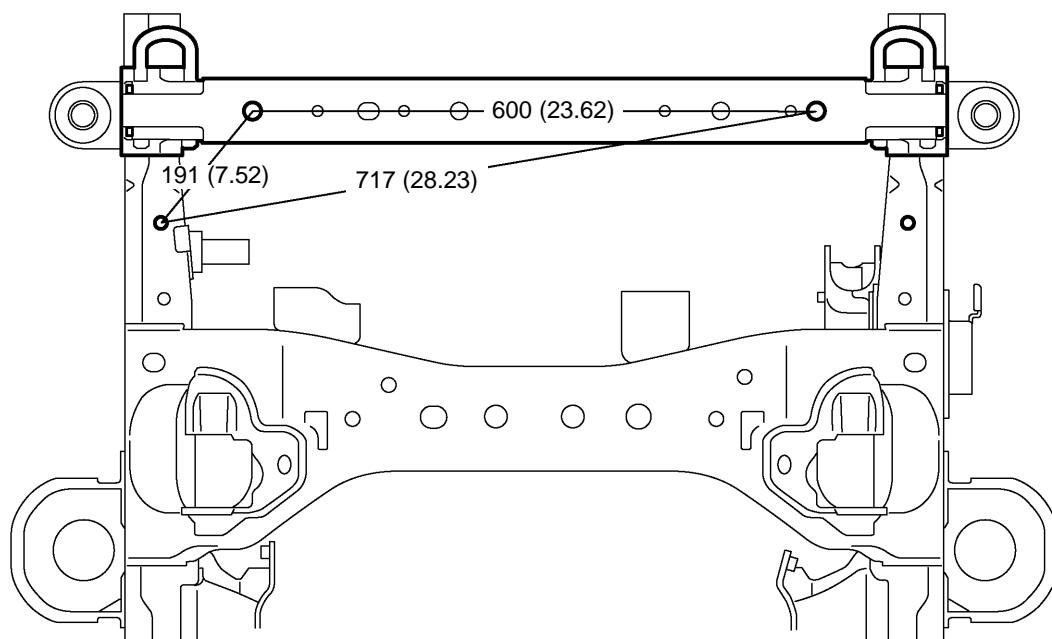


mm (in.)

F43350

INSTALLATION POINT

- 1 Make sure that proper welding can be performed by setting up the welding conditions as necessary before performing work.
- 2 Make sure that the welding bead at *1 is overlapped.
- 3 To prevent heat deformation, weld the right and left side of each part before continuing to the next part.
- 4 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.



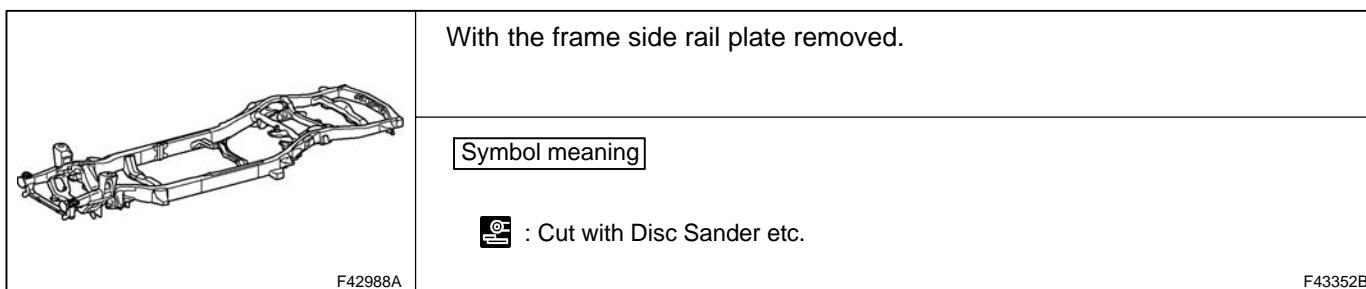
mm (in.)

F43351

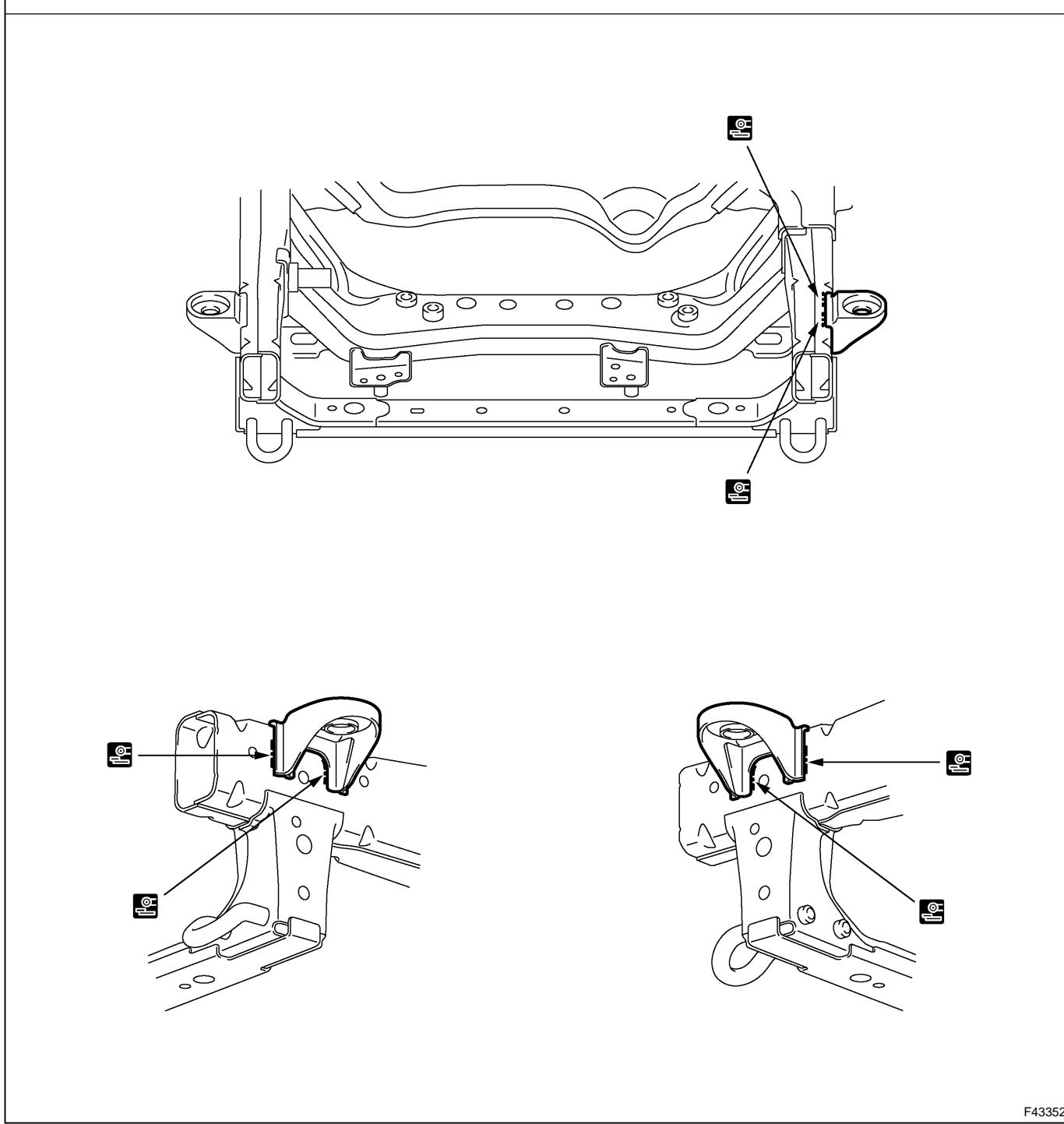
INSTALLATION POINT

1 These values are reference values.

CAB MOUNTING NO. 1 BRACKET (ASSY)



REMOVAL

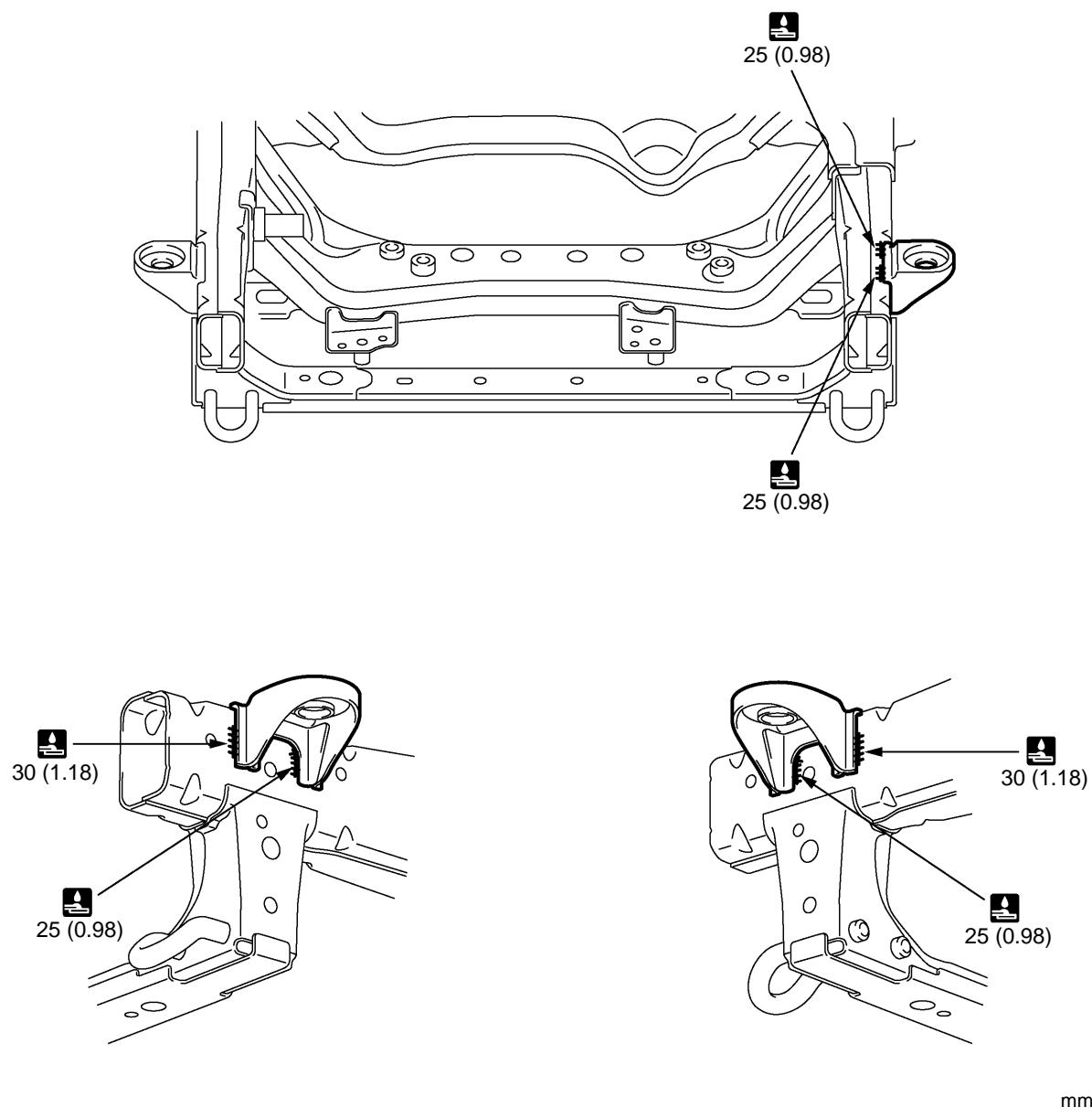


Symbol meaning

 : Fillet Weld

F43353B

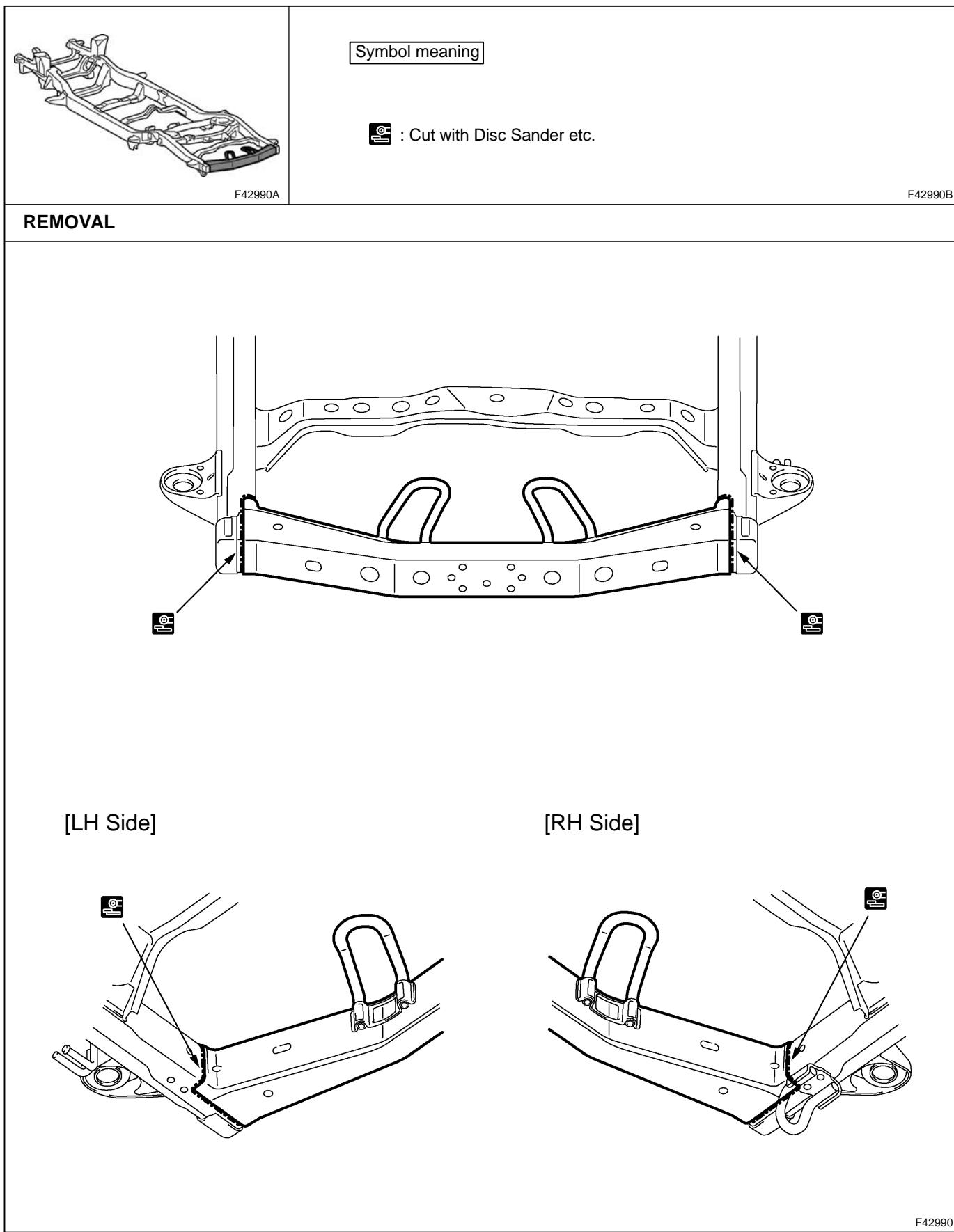
INSTALLATION



INSTALLATION POINT

- 1 Make sure that proper welding can be performed by setting up the welding conditions as necessary before performing work.
- 2 Before installing the cab mounting No. 1 brackets, set the cab (upper body) on the vehicle frame and confirm the cab mounting No. 1 brackets' installation positions.
- 3 To prevent heat deformation, weld the right and left side of each part before continuing to the next part.
- 4 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

FRAME REAR CROSSMEMBER (ASSY)

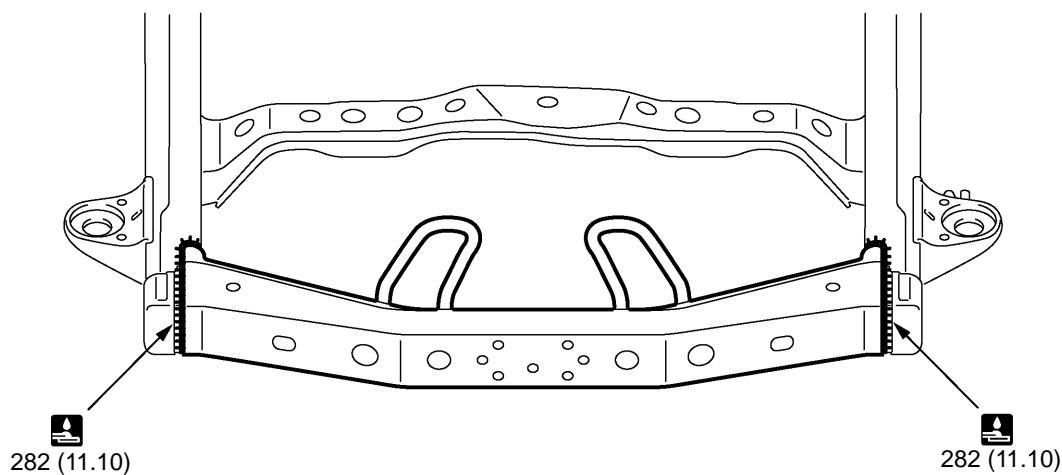


Symbol meaning

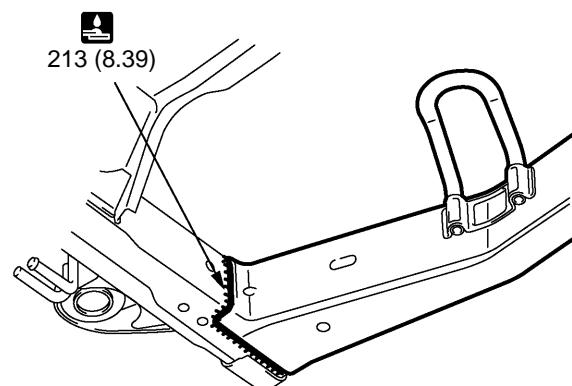
 : Fillet Weld

F42991B

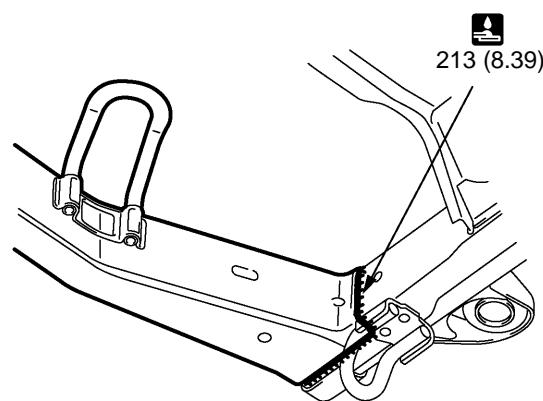
INSTALLATION



[LH Side]



[RH Side]

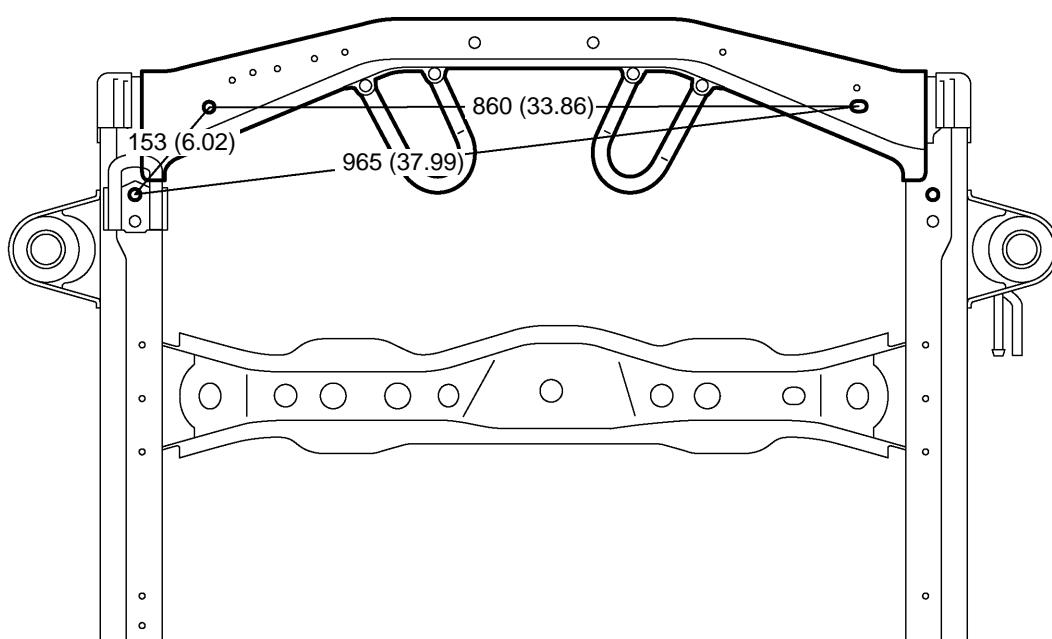


mm (in.)

F42991

INSTALLATION POINT

- 1 Make sure that proper welding can be performed by setting up the welding conditions as necessary before performing work.
- 2 To prevent heat deformation, weld the right and left side of each part before continuing to the next part.
- 3 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.



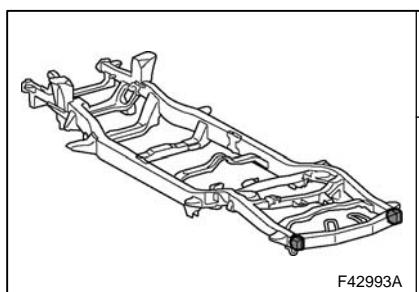
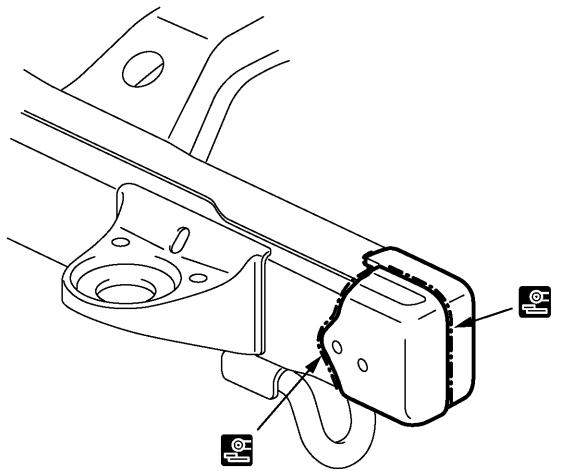
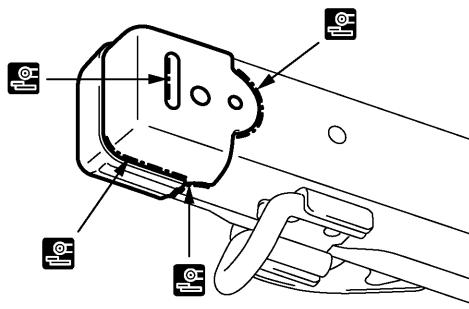
mm (in.)

F42992

INSTALLATION POINT

1 These values are reference values.

FRAME REAR CROSSMEMBER GUSSET (ASSY)

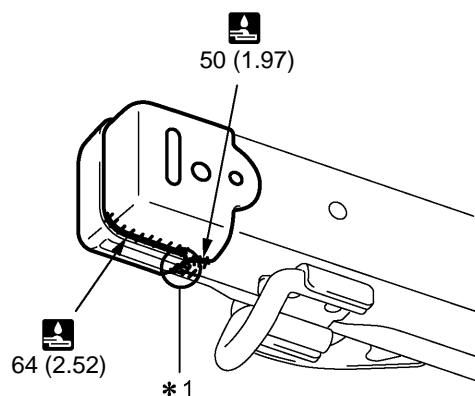
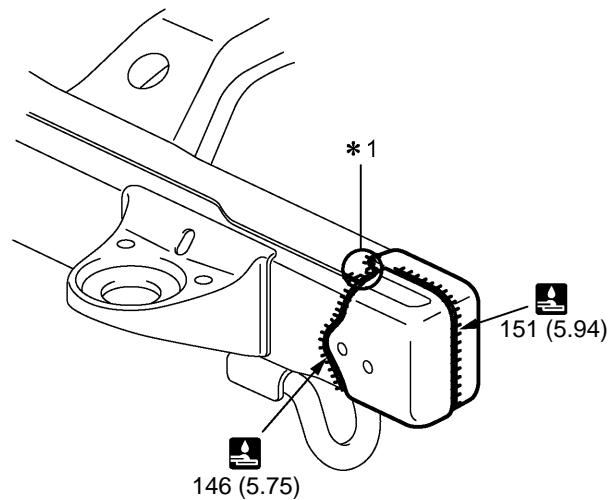
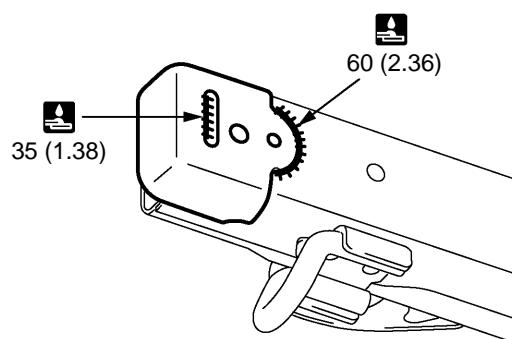
 F42993A	<p>With the frame rear crossmember removed.</p> <p>Symbol meaning</p> <p> : Cut with Disc Sander etc.</p> <p>F43357B</p>
REMOVAL	
 	

Symbol meaning

 : Fillet Weld

F43358B

INSTALLATION

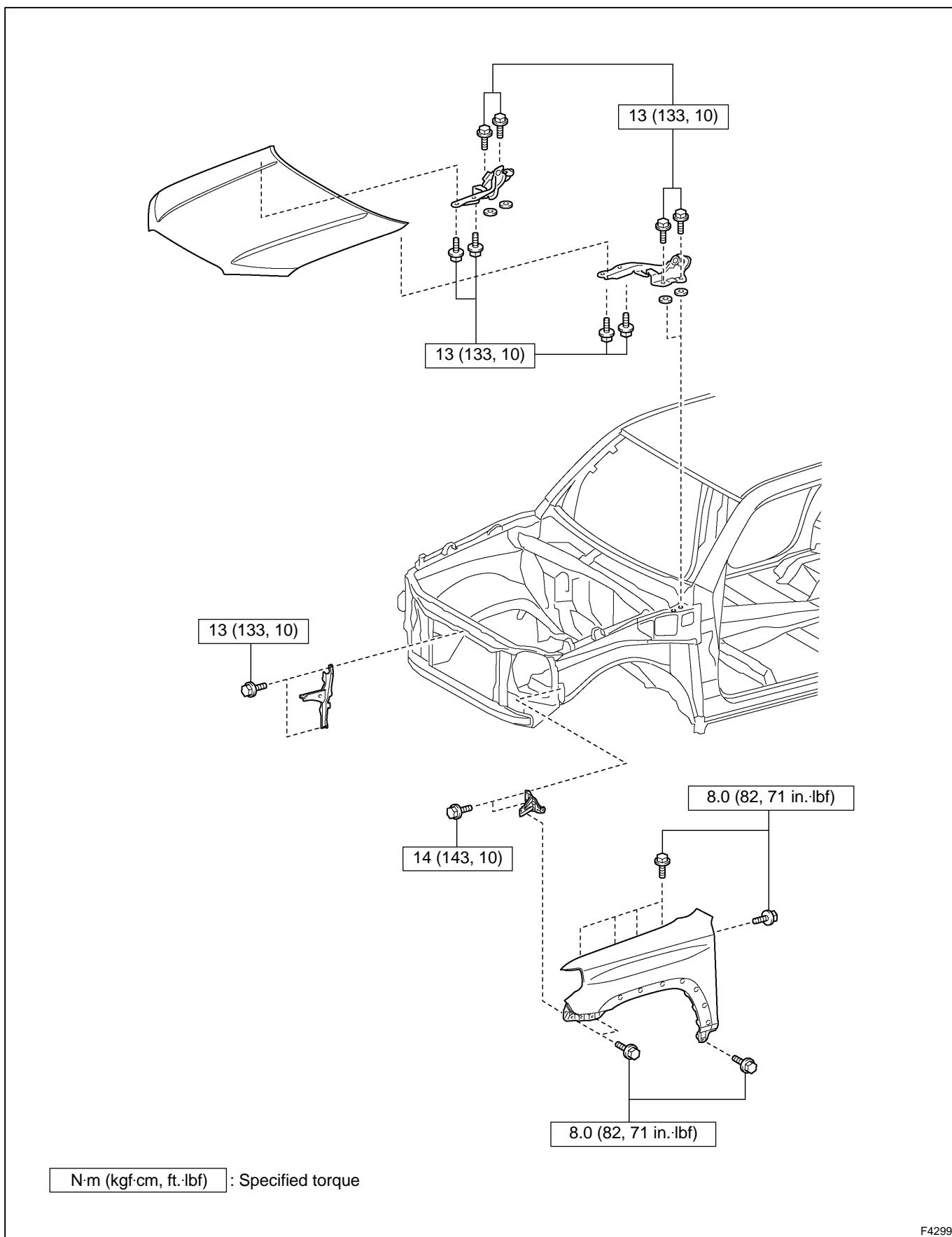


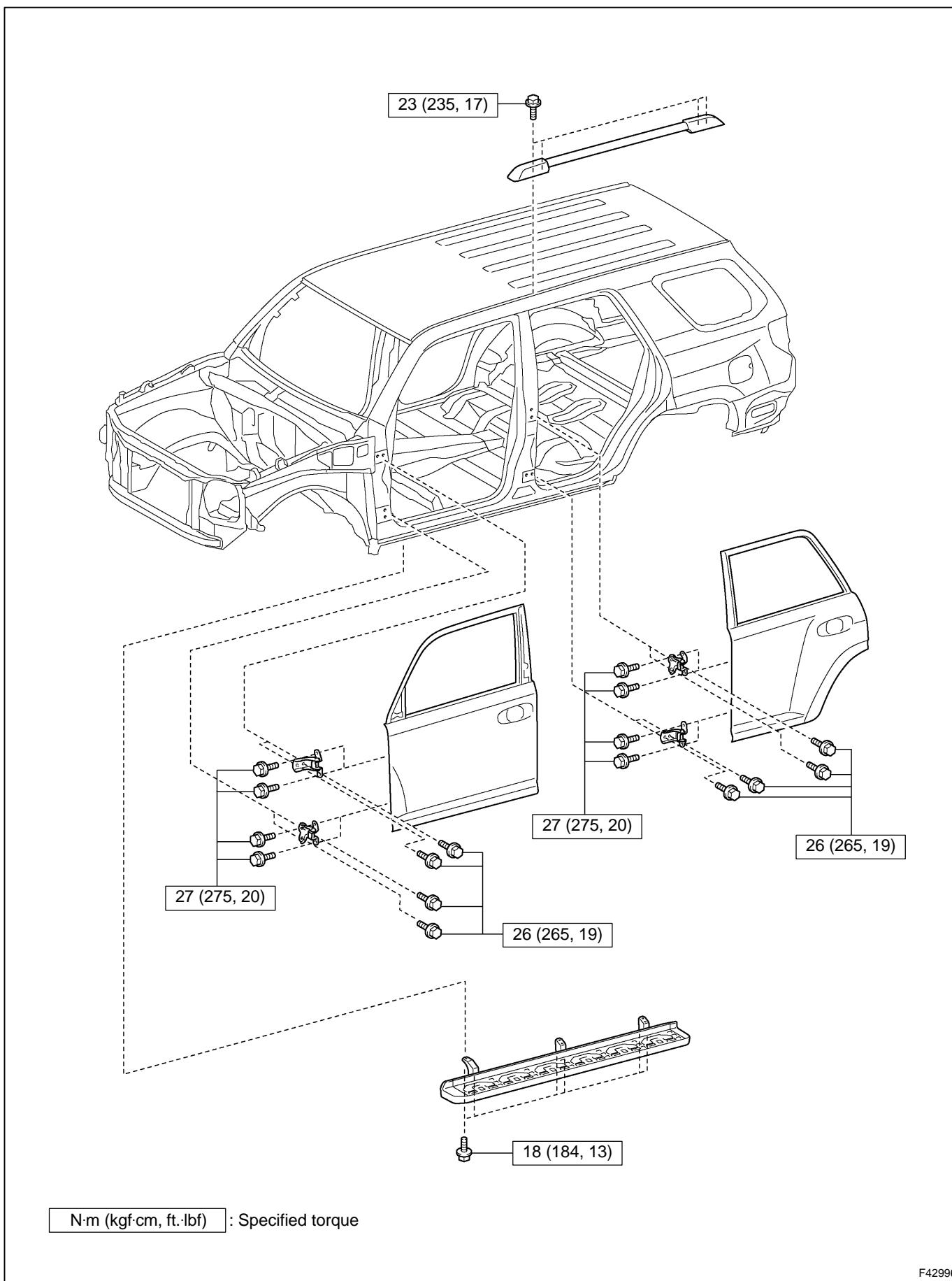
mm (in.)

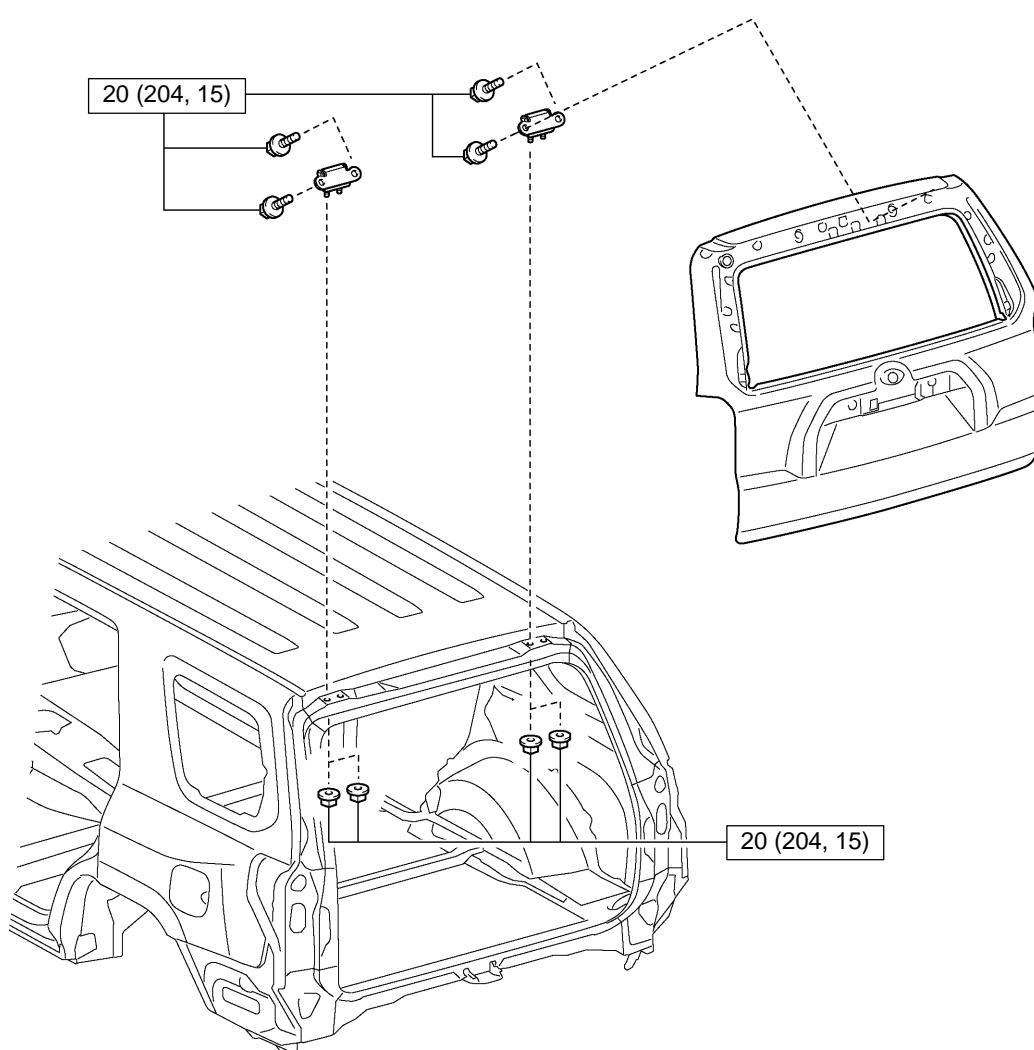
F43358

INSTALLATION POINT

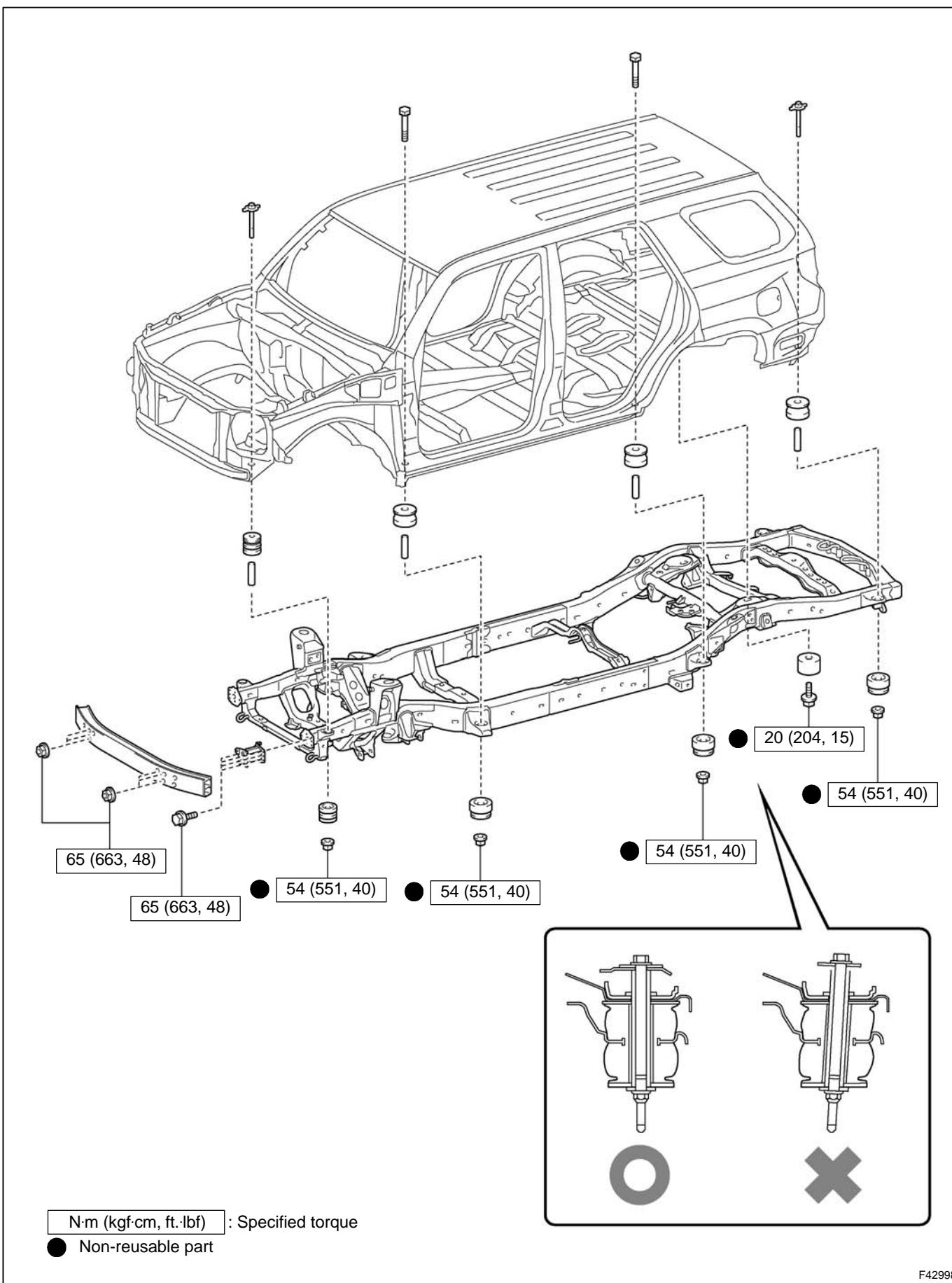
- 1 Make sure that proper welding can be performed by setting up the welding conditions as necessary before performing work.
- 2 Make sure that the welding bead at *1 is overlapped.
- 3 To prevent heat deformation, weld the right and left side of each part before continuing to the next part.
- 4 After applying the top coat, apply anti-rust agent to the internal panel portion of the closed section structural weld points.

OUTER PANEL INSTALLATION TORQUE



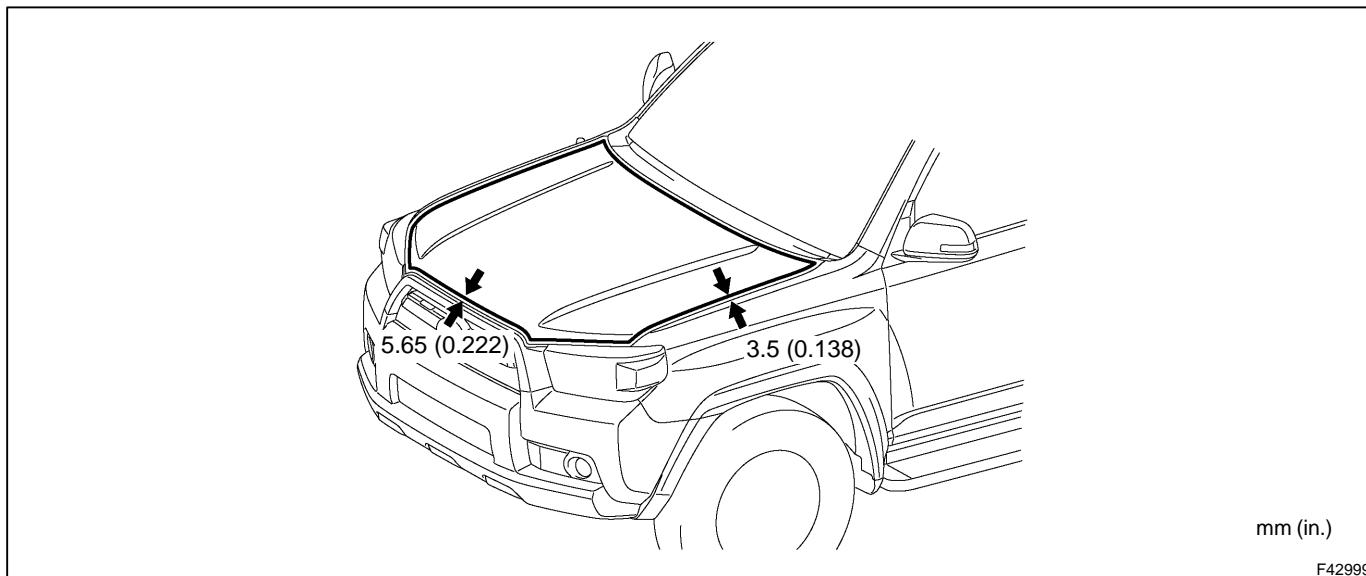


N·m (kgf·cm, ft·lbf) : Specified torque



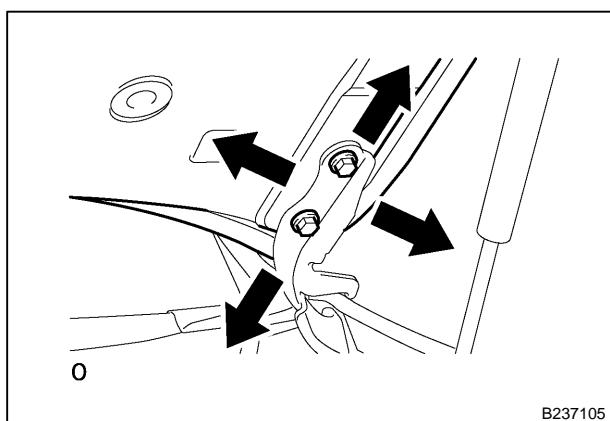
FIT STANDARD/ADJUSTMENT METHOD/TORQUE SPECIFICATION

1. HOOD SUB-ASSEMBLY



HINT:

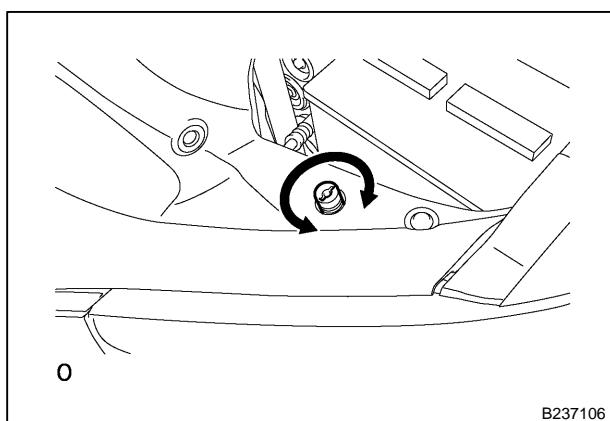
Centering bolts are used to mount the hood hinge and hood lock. The hood and hood lock cannot be adjusted with the centering bolts installed. Substitute the centering bolts with standard bolts when making adjustments.



- (a) Adjust the hood position.
 - (1) Loosen the 4 hinge bolts on the hood.
 - (2) Move the hood and adjust the clearance between the hood and front fender.
 - (3) Tighten the 4 hinge bolts on the hood after the adjustment.

Torque:

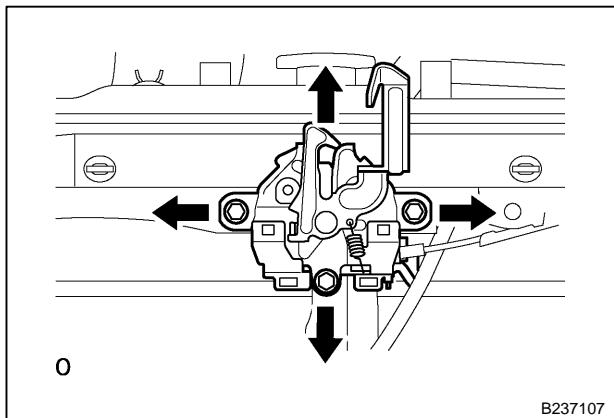
13 N·m (133 kgf·cm, 10 ft·lbf)



- (b) Adjust the height of the front end of the hood using the cushion rubbers.
 - (1) Adjust the cushion rubbers so that the hood and fender are aligned.

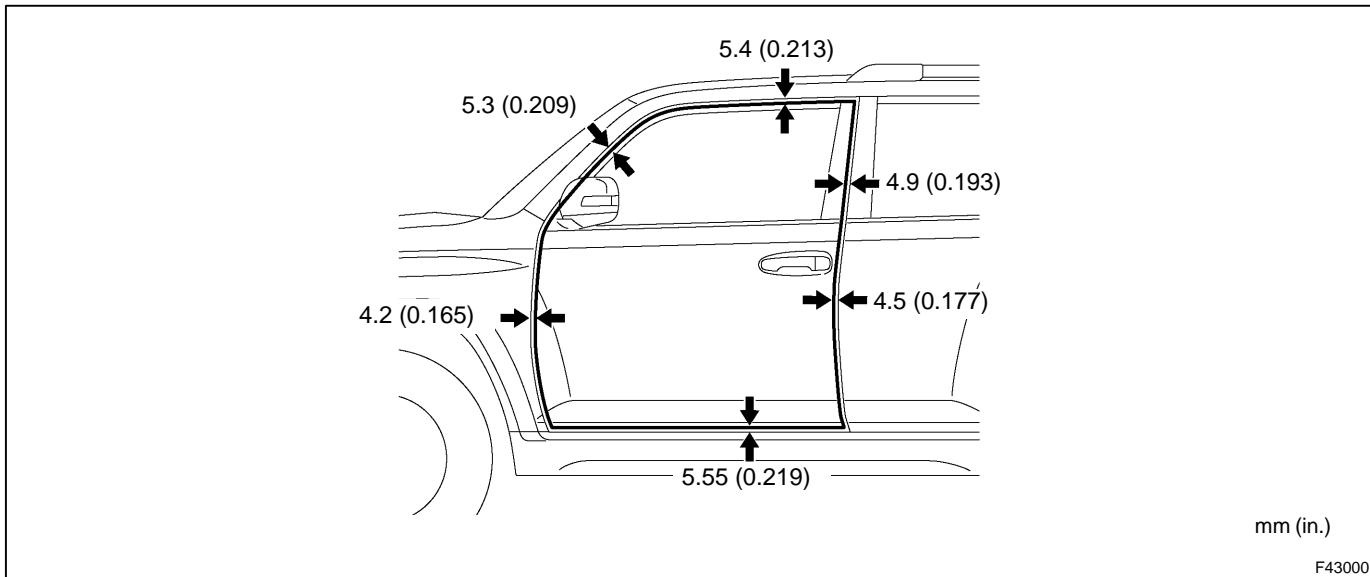
HINT:

Raise or lower the front end of the hood by turning the 2 cushion rubbers.



- (c) Adjust the hood lock.
- (1) Loosen the 3 bolts.
 - (2) Adjust the hood lock and tighten the 3 bolts.
Torque:
7.5 N·m (76 kgf·cm, 66 in·lbf)
 - (3) Check that the striker can engage with the hood lock smoothly.

2. FRONT DOOR



CAUTION:

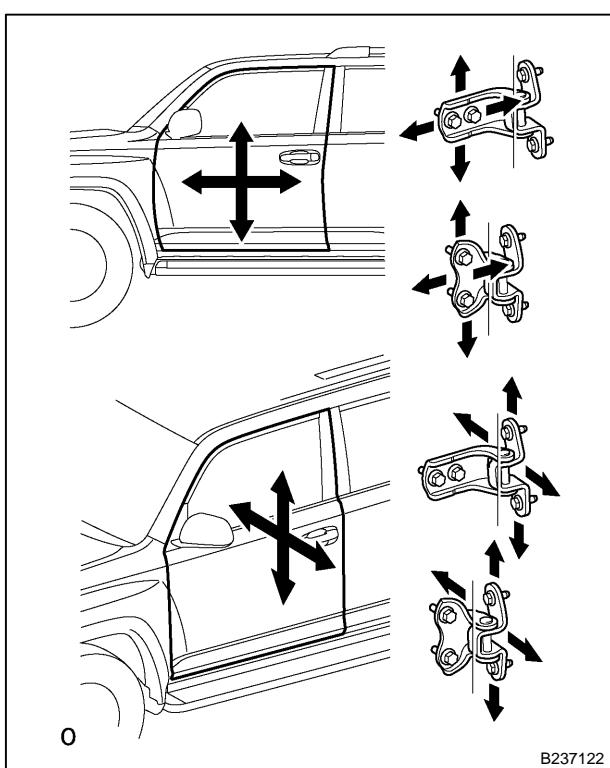
Wait at least 90 seconds after disconnecting the cable from the negative (-) battery terminal to disable the SRS system.

NOTICE:

When disconnecting the cable, some systems need to be initialized after the cable is reconnected.

HINT:

Centering bolts are used to mount the door hinge to the vehicle body and door. The door cannot be adjusted with the centering bolts installed on it. Substitute the centering bolts with standard bolts when making adjustments.



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

SST
09812-00010

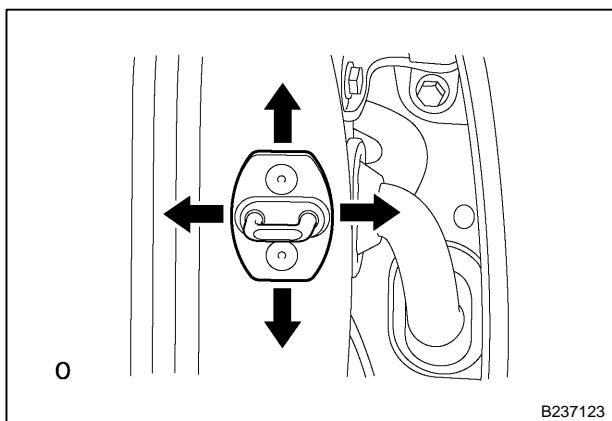
- (b) Tighten the hinge bolts on the vehicle body after the adjustment.

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

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

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

Torque:
27 N·m (275 kgf·cm, 20 ft·lbf)

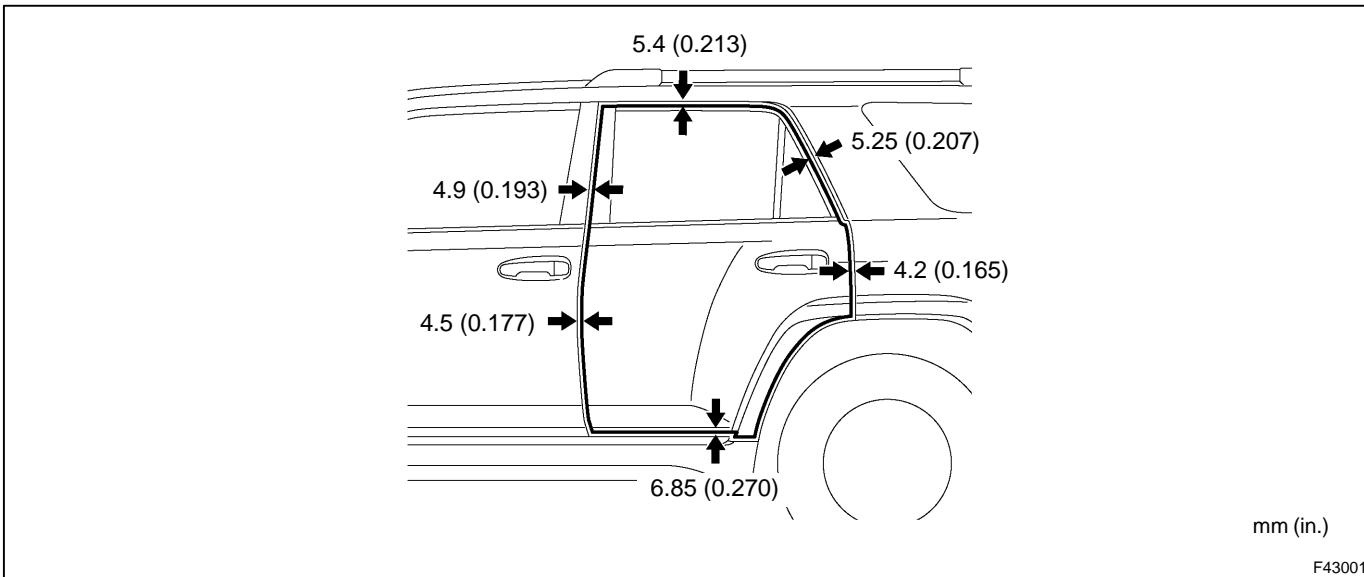


- (e) Using a T40 "TORX" socket wrench, slightly loosen the striker mounting screws.
- (f) Using a brass bar and hammer, hit the striker to adjust its position.
- (g) Using a T40 "TORX" socket wrench, tighten the striker mounting screws after the adjustment.

Torque:

23 N·m (235 kgf·cm, 17 ft·lbf)

3. REAR DOOR

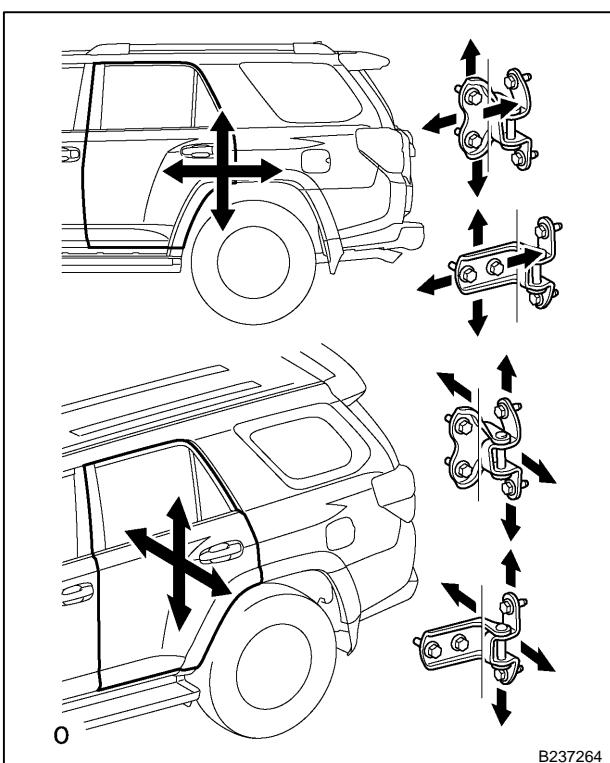


NOTICE:

When disconnecting the cable, some systems need to be initialized after the cable is reconnected.

HINT:

Centering bolts are used to mount the door hinge to the vehicle body and door. The door cannot be adjusted with the centering bolts installed. Substitute the centering bolts with standard bolts when making adjustments.



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

SST
09812-00010

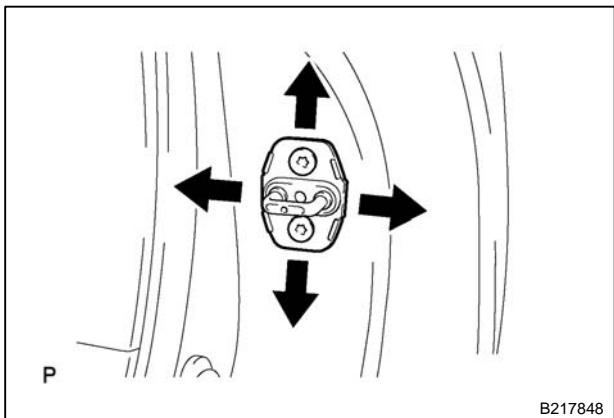
- Tighten the hinge bolts on the vehicle body after the adjustment.

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

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

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

Torque:
27 N·m (275 kgf·cm, 20 ft·lbf)

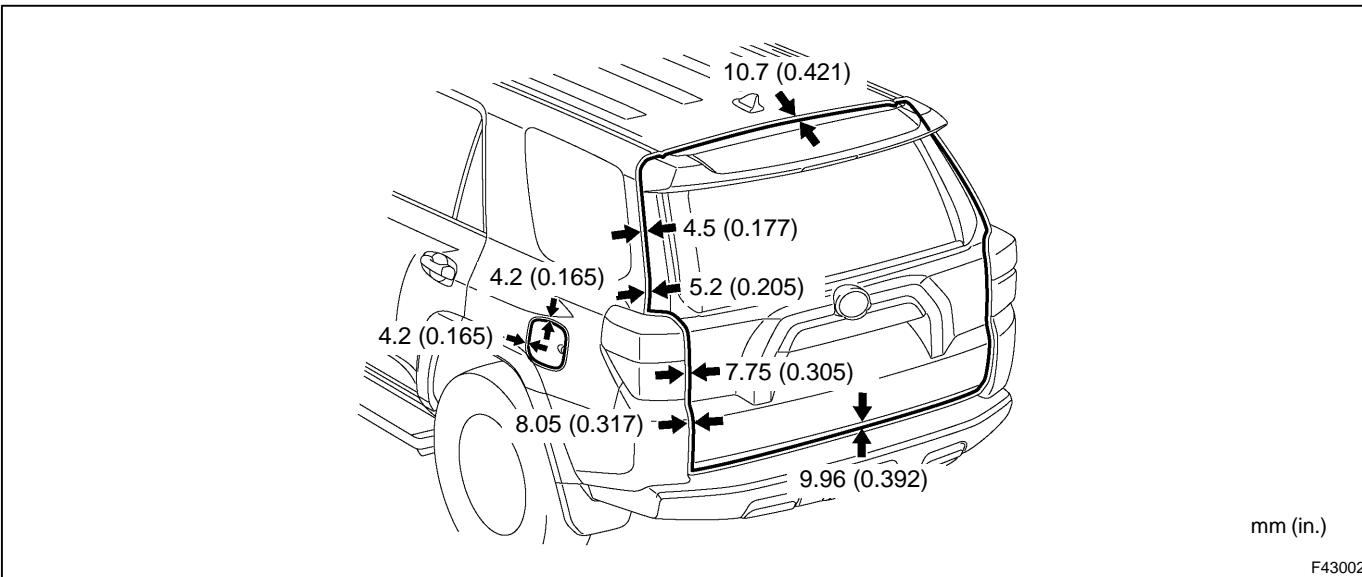


- (e) Using a T40 "TORX" socket wrench, slightly loosen the striker mounting screws.
- (f) Using a brass bar and hammer, hit the striker to adjust its position.
- (g) Using a T40 "TORX" socket wrench, tighten the striker mounting screws after the adjustment.

Torque:

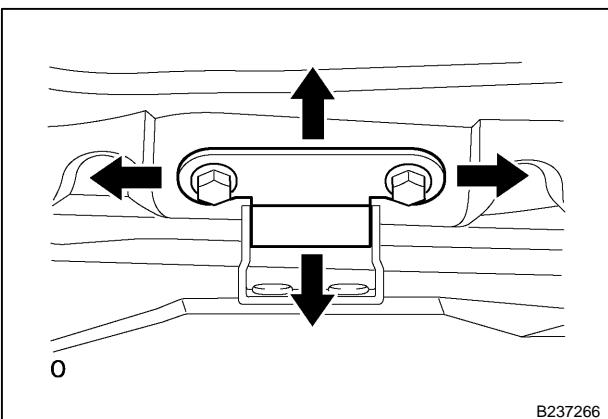
23 N·m (235 kgf·cm, 17 ft·lbf)

4. BACK DOOR



HINT:

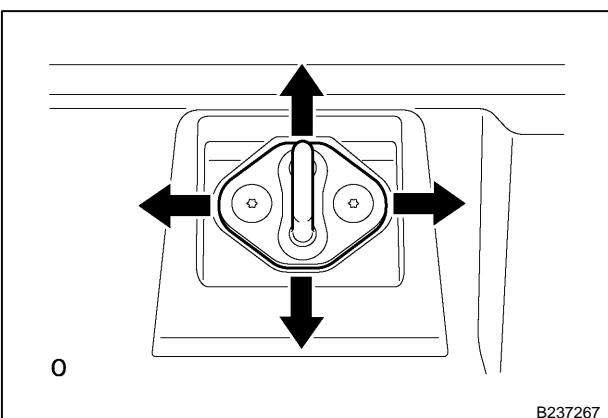
- Use the same procedure for the RH side and LH side.
- The following procedure is for the LH side.
- Centering bolts are used to mount the door hinge to the vehicle body and door. The door cannot be adjusted with the centering bolts installed. Substitute the centering bolts with standard bolts and washers when making adjustments.



- Before adjusting the upper end of the back door up and down or left and right, loosen the bolts.
- Tighten the body side hinge after the adjustment.

Torque:

20 N·m (204 kgf·cm, 15 ft·lbf)



- Using a T40 "TORX" socket wrench, slightly loosen the striker mounting screws.
- Using a brass bar and hammer, hit the striker to adjust its position.
- Using a T40 "TORX" socket wrench, tighten the striker mounting screws after the adjustment.

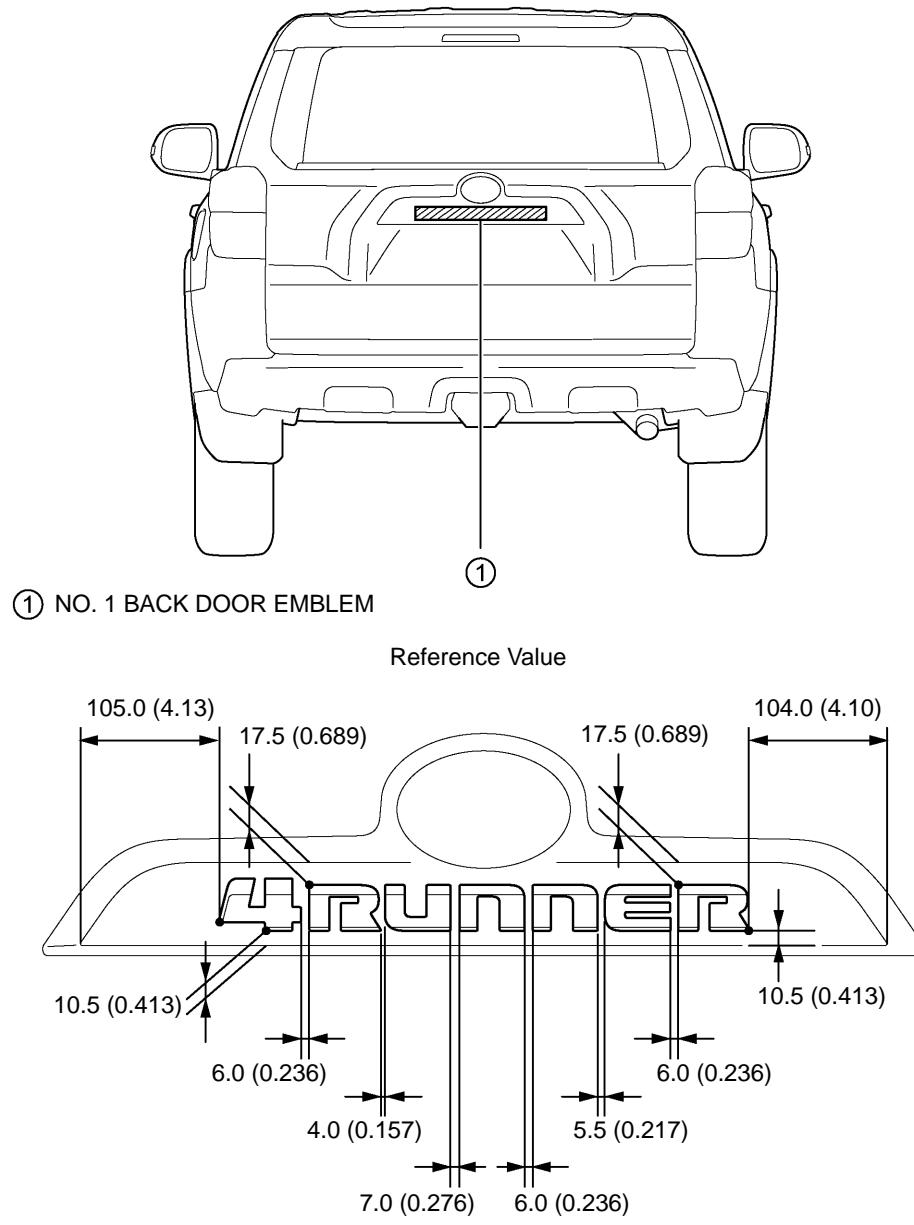
Torque:

27 N·m (275 kgf·cm, 20 ft·lbf)

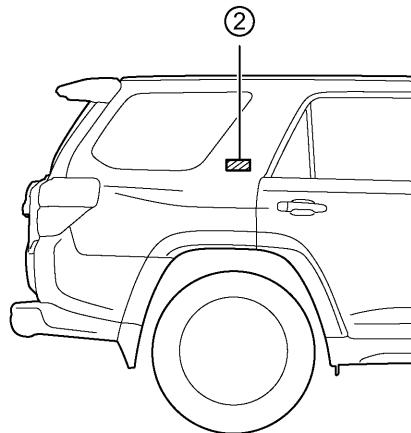
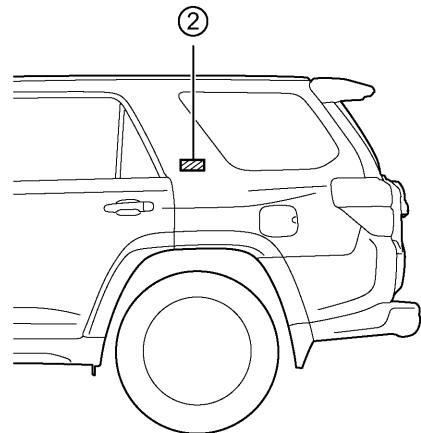
NAME PLATE APPLICATION PROCEDURE

- 1 Heat the double-sided tape remaining on the body with an infrared lamp or equivalent.
HINT:
Heat the tape to 40 to 60° C for approximately 1 to 2 minutes.
- 2 Wipe off the remaining double-sided tape using a clean cloth or equivalent.
HINT:
If a name plate is installed without thoroughly removing the remaining double-sided tape from the body, the name plate will not adhere properly. Make sure to thoroughly wipe off the double-sided tape.
- 3 After cleaning the installation area of the body with degreasing agent, attach the name plate to the position shown in the illustration.
HINT:
The working environment should be 20° C when installing the name plate. If the working environment is below 20° C, heat the installation area of the body to 20 to 30° C and then install the name plate.

[USA, Canada]

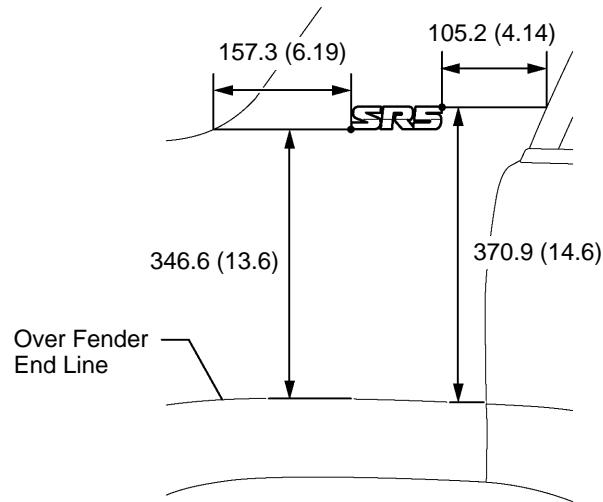
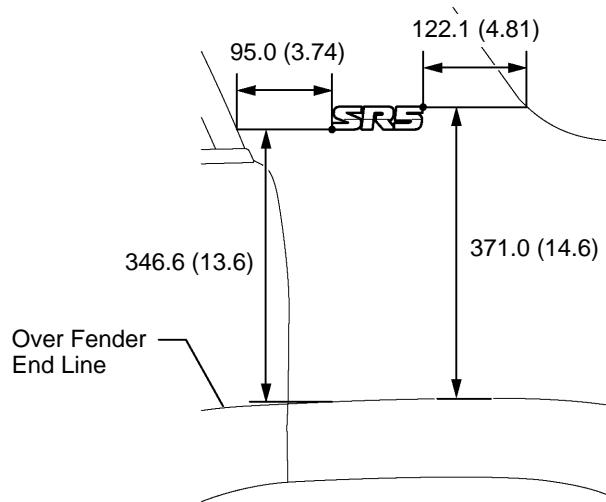


[USA, Canada]



② NO. 1 ROOF SIDE MARK

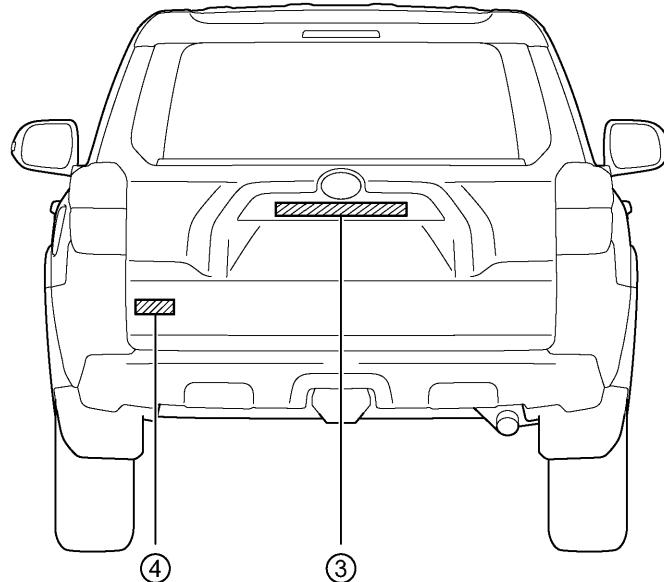
Reference Value



mm (in.)

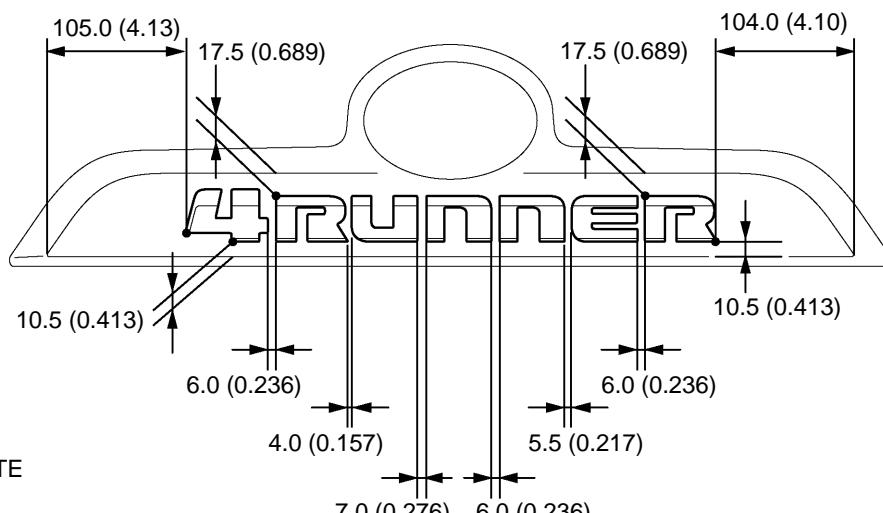
F43016

[Except USA, Canada]

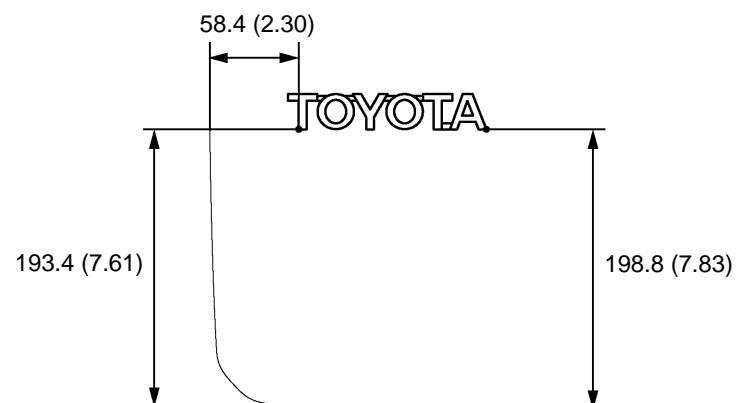


③ NO. 1 BACK DOOR EMBLEM

Reference Value



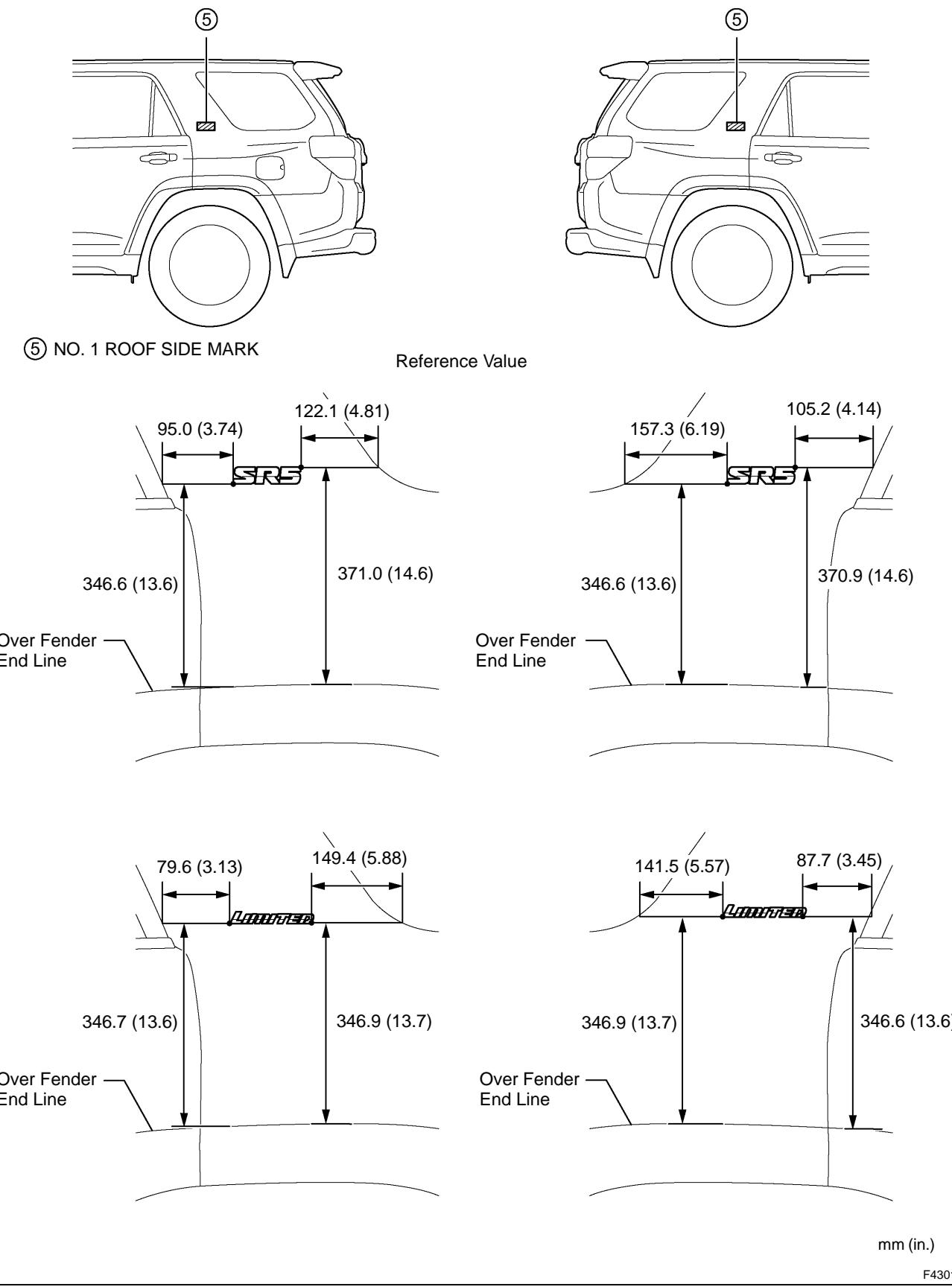
④ NO. 2 BACK DOOR NAME PLATE



mm (in.)

F43017

[Except USA, Canada]



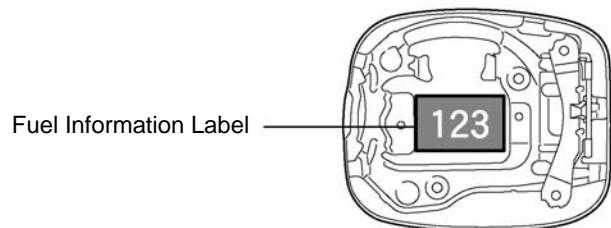
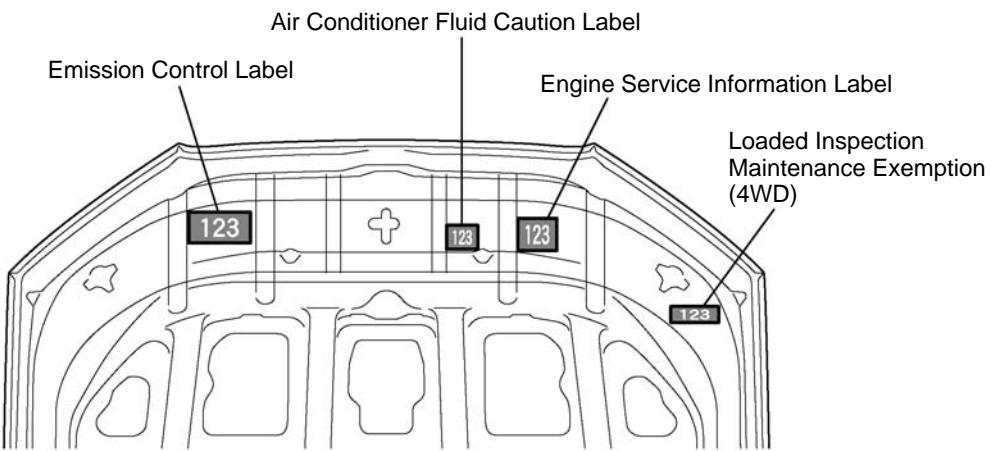
CAUTION LABEL ATTACHMENT POSITION

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

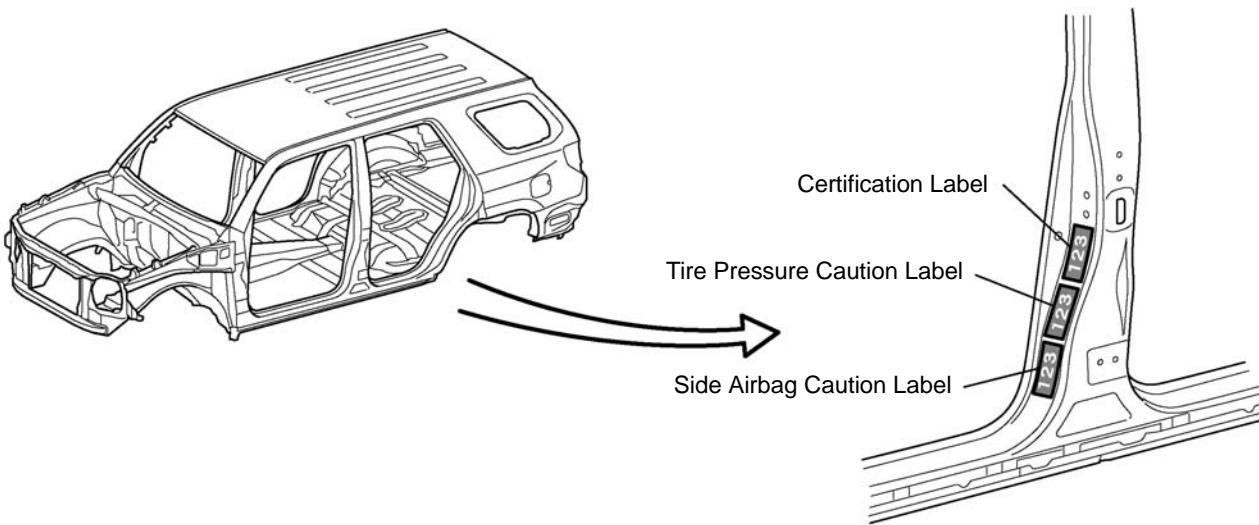
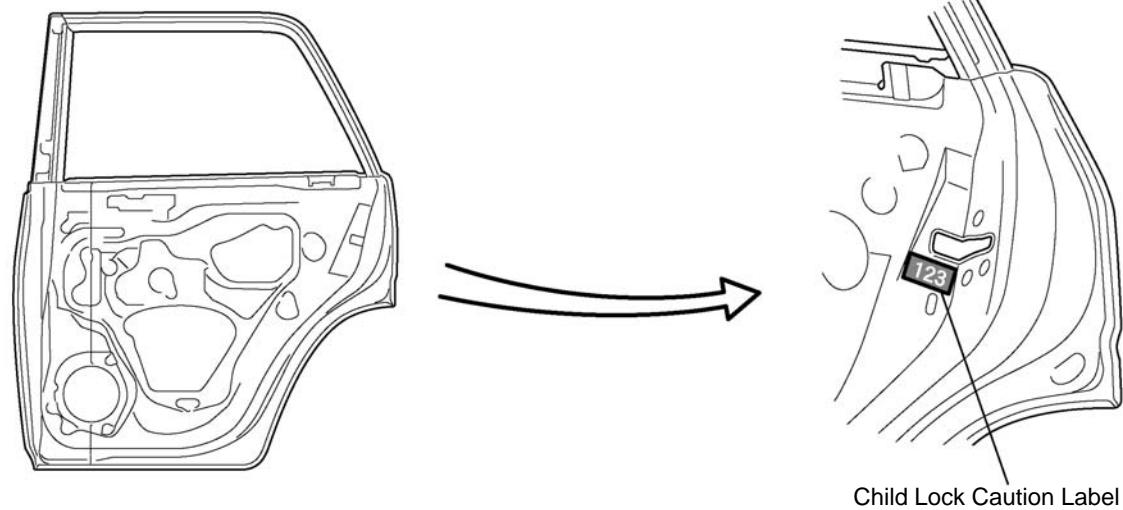
HINT:

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

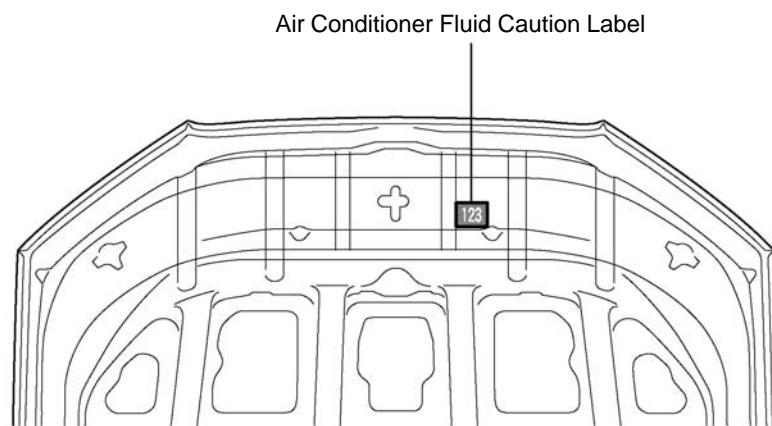
[USA, Canada]



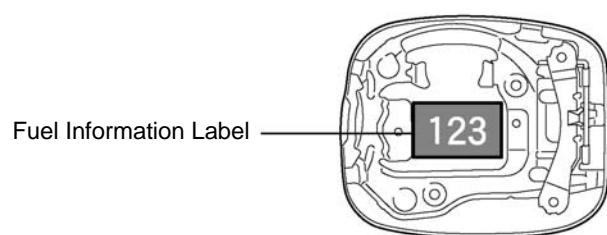
[USA, Canada]



[Except USA, Canada]



Air Conditioner Fluid Caution Label



Fuel Information Label

[Except USA, Canada]

