

TOYOTA

REPAIR MANUAL FOR COLLISION DAMAGE

CELICA

AT160,ST16__ series Aug., 1985

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 CELICA.

Applicable models:
AT160 series
ST161, 162 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 CELICA, refer to the following repair manuals.

2A, 3A, 3A-C, 4A, 4A-C, 4A-GE Engine Repair Manual
(Pub. No. 36230E)
1S, 1S-E, 2S-C, 2S-E, 3S-GE Engine Repair Manual
(Pub. No. RM016E)
A130L, A131, A131L, A132, A132L, A140L, A140E,
A240L, A241L Automatic Transmission Repair Manual
(Pub. No. RM018E)
CELICA Chassis and Body Repair Manual
(Pub. No. RM013E)
CELICA 1986 Repair Manual (USA & CANADA)
(Pub. No. RM005U)

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 CELICA REPAIR MANUAL FOR COLLISION DAMAGE

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PLASTIC BODY PARTS	PL
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PART LISTS	PL
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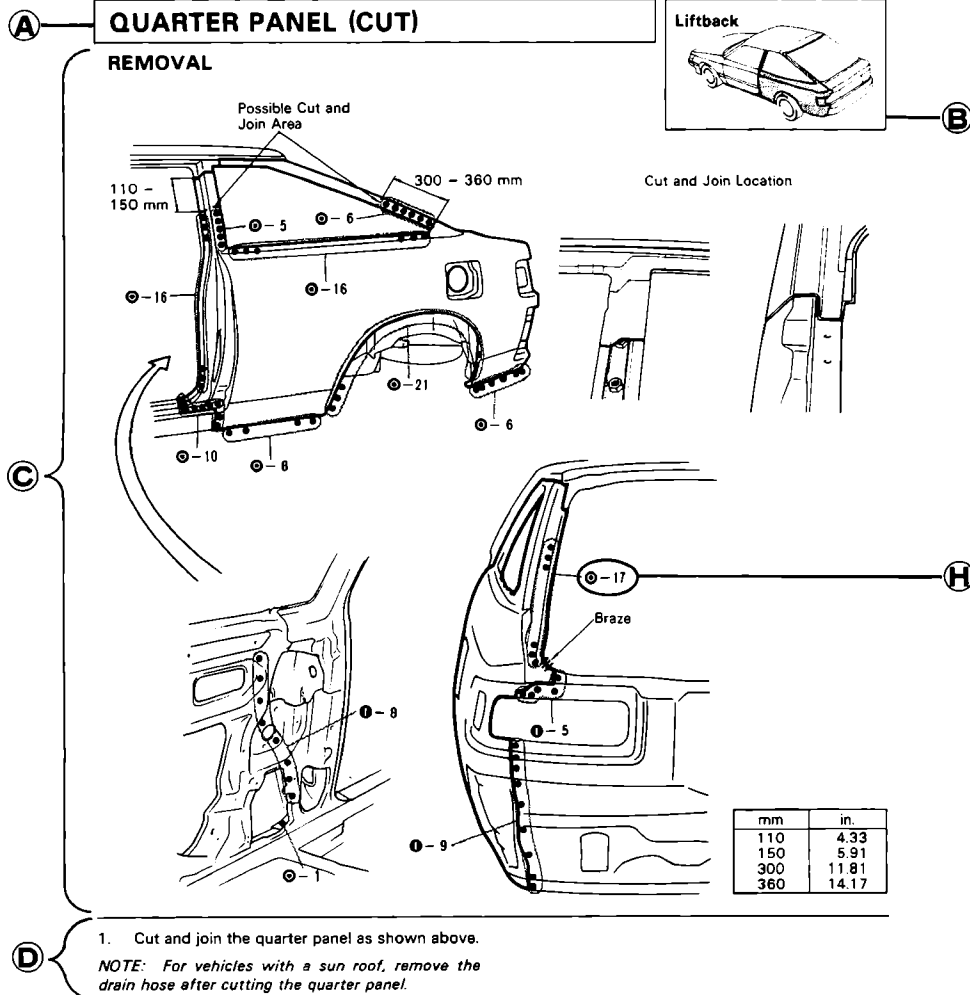
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HOW TO USE THIS MANUAL

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

RE-32 BODY PANEL REPLACEMENT — Rear Body Components



A : REPLACEMENT PART AND METHOD

QUARTER PANEL (CUT)

Replacement method

- (ASSY) ... Assembly replacement
- (CUT) ... Major cutting (less than 1/2 of part used)
- (CUT-H) .. Half cutting (about 1/2 of part used)
- (CUT-P) .. Partial cutting (most of part used)

Replacement part

B : BODY VARIATIONS AND PART LOCATION

Body variations: Non ... All models
 Liftback
 Coupe

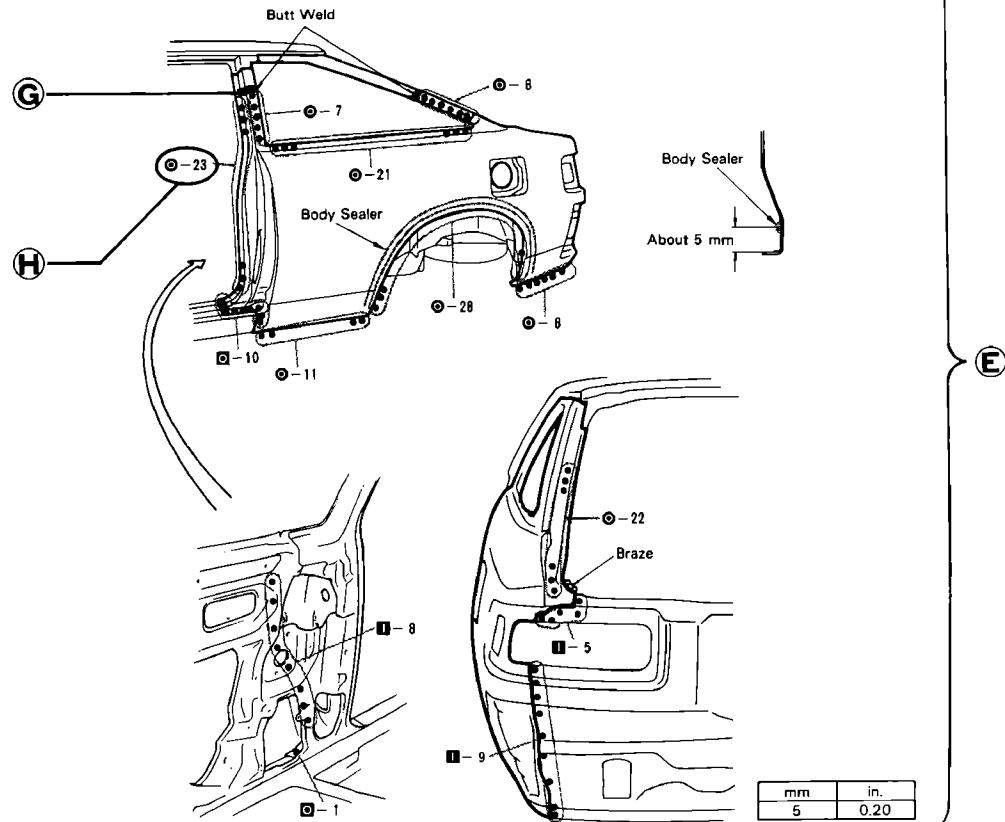
C : REMOVAL DIAGRAM

Describes in detail removal of the damaged part involving repair by cutting.

D : REMOVAL GUIDE

Provides additional information to more efficiently help you perform the removal.

INSTALLATION



1. Before temporarily installing the new part, apply body sealer to the wheel arch portion.
2. Temporarily installing the new part and check the fit of the front door, back door and rear combination lamp.

NOTE:

- 1) Apply sealer approx. 5 mm (0.20 in.) from the flange, avoiding any oozing.
- 2) Apply evenly, approx. 3 - 4 mm (0.12 - 0.16 in.) in diameter.
- 3) For other sealing points, refer to section SU.

E : INSTALLATION DIAGRAM

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

F : INSTALLATION GUIDE

Provides additional information to more efficiently help you perform the installation.

G : SYMBOLS

See page IN-4.

H : 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 the types of weld required.


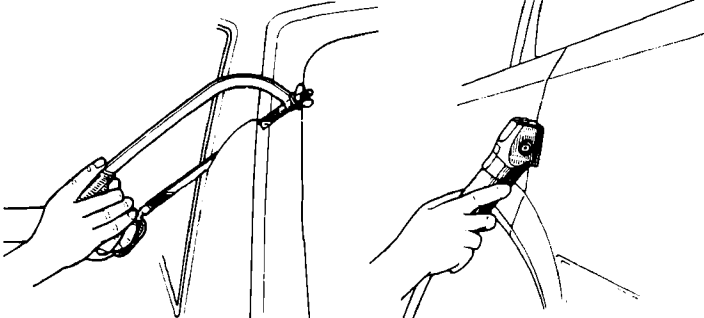

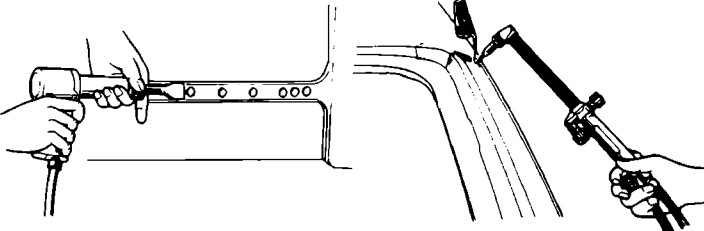
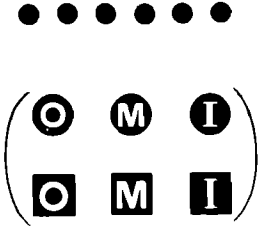
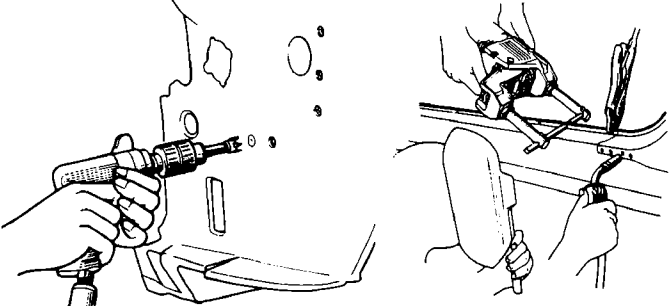

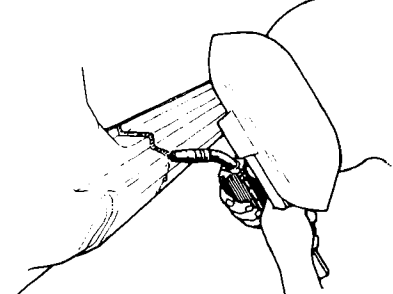

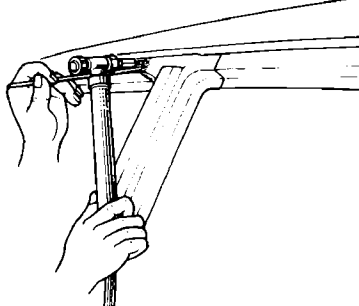
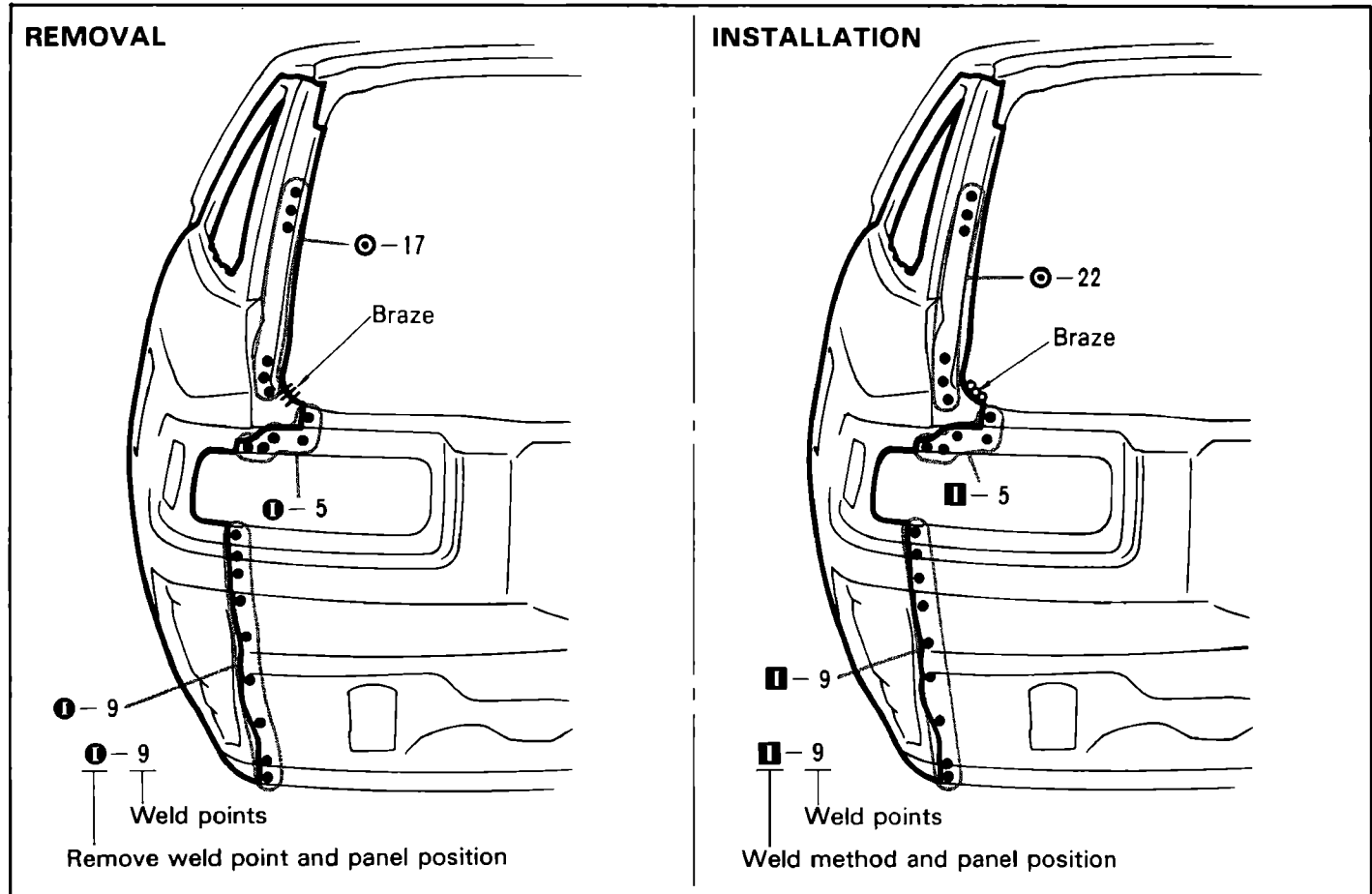
SYMBOLS	NOMENCLATURE	ILLUSTRATION
	<p>SAW CUT OR ROUGH CUT</p>	
	<p>REMOVE BRAZE OR SPOT WELD</p>	
	<p>WELD POINT SPOT WELD OR MIG PLUG WELD (See page IN-5)</p>	
	<p>CONTINUOUS MIG WELD (BUTT WELD)</p>	
	<p>BRAZE</p>	

Illustration of Weld Point Symbols

EXAMPLE:



SYMBOL	NOMENCLATURE	ILLUSTRATION	SYMBOL	NOMENCLATURE	ILLUSTRATION
<div style="display: flex; flex-direction: column; align-items: center;"> <div style="border: 1px solid black; border-radius: 50%; width: 20px; height: 20px; display: flex; align-items: center; justify-content: center; margin-bottom: 5px;">●</div> <div style="border: 1px solid black; border-radius: 50%; width: 20px; height: 20px; display: flex; align-items: center; justify-content: center; margin-bottom: 5px;">M</div> <div style="border: 1px solid black; border-radius: 50%; width: 20px; height: 20px; display: flex; align-items: center; justify-content: center;">I</div> </div>	Remove Weld Points		<div style="display: flex; flex-direction: column; align-items: center;"> <div style="border: 1px solid black; border-radius: 50%; width: 20px; height: 20px; display: flex; align-items: center; justify-content: center; margin-bottom: 5px;">●</div> <div style="border: 1px solid black; border-radius: 50%; width: 20px; height: 20px; display: flex; align-items: center; justify-content: center; margin-bottom: 5px;">M</div> <div style="border: 1px solid black; border-radius: 50%; width: 20px; height: 20px; display: flex; align-items: center; justify-content: center; margin-bottom: 5px;">I</div> </div>	Spot Weld	
<div style="border: 1px solid black; border-radius: 50%; width: 20px; height: 20px; display: flex; align-items: center; justify-content: center;">●</div>	(Outside)		<div style="border: 1px solid black; border-radius: 50%; width: 20px; height: 20px; display: flex; align-items: center; justify-content: center;">●</div>	MIG Plug Weld	
<div style="border: 1px solid black; border-radius: 50%; width: 20px; height: 20px; display: flex; align-items: center; justify-content: center;">M</div>	(Middle)		<div style="border: 1px solid black; border-radius: 50%; width: 20px; height: 20px; display: flex; align-items: center; justify-content: center;">M</div>	MIG Plug Weld	
<div style="border: 1px solid black; border-radius: 50%; width: 20px; height: 20px; display: flex; align-items: center; justify-content: center;">I</div>	(Inside)		<div style="border: 1px solid black; border-radius: 50%; width: 20px; height: 20px; display: flex; align-items: center; justify-content: center;">I</div>	MIG Plug Weld	
+	Spot MIG Weld or Tack Weld				

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

GENERAL REPAIR INSTRUCTIONS

Work Precautions

SAFETY

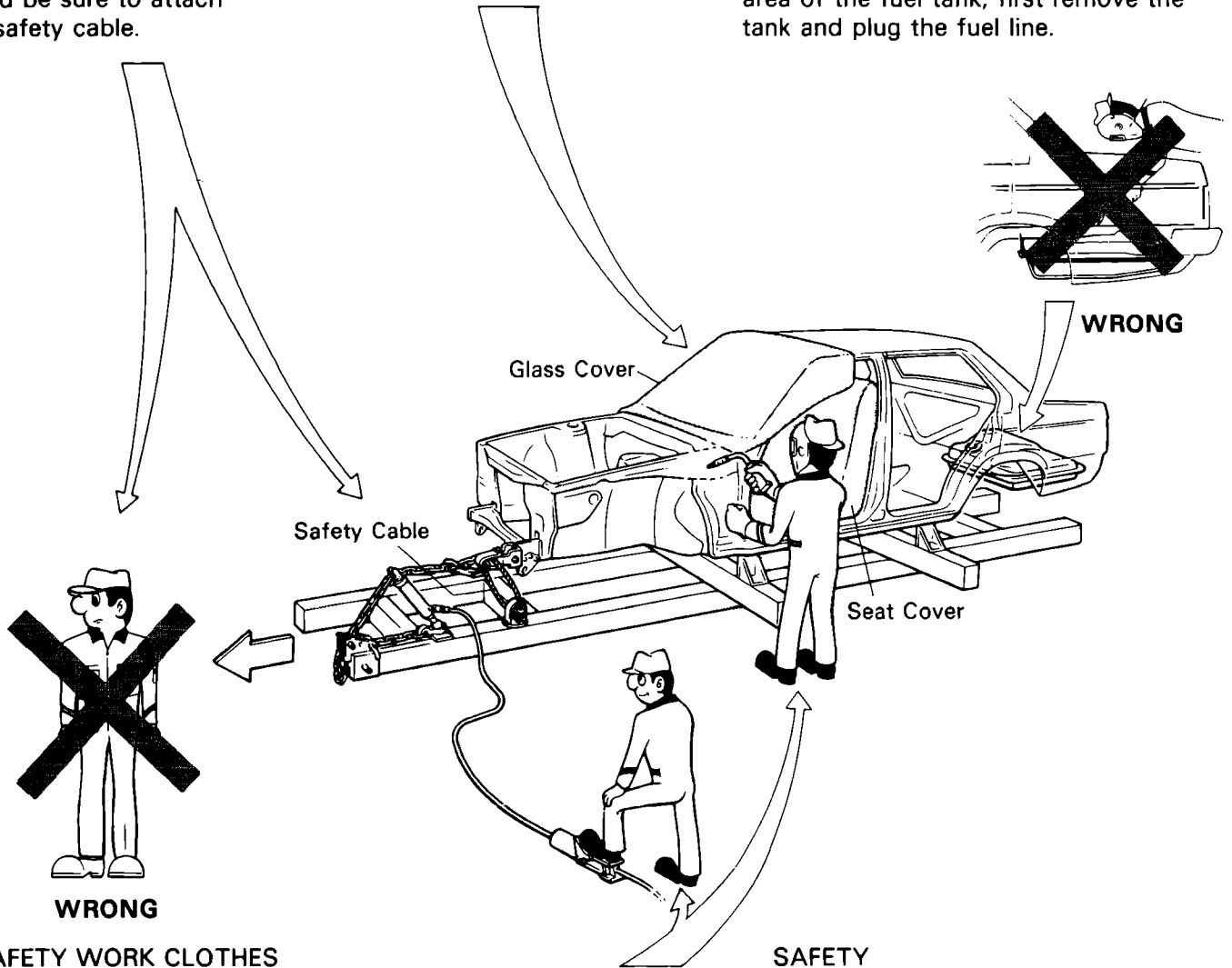
Never stand in direct line with the chain when using a puller on the body or frame, and be sure to attach a safety cable.

VEHICLE PROTECTION

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

SAFETY

1. Before performing repair work, check for fuel leaks. If a leak is found, be sure to close the opening totally.
2. If it is necessary to use a flame in the area of the fuel tank, first remove the tank and plug the fuel line.



SAFETY WORK CLOTHES

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

SAFETY

Before performing repair work, disconnect the battery cables.

Dust-Prevention Mask



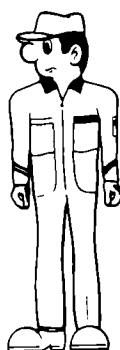
Face Protector



Head Protector



Safety Shoes



Welder's Glasses



Ear Plugs

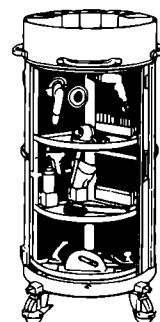


Welder's Gloves



Cotton Gloves

Body Mechanic Stand



HAND TOOLS

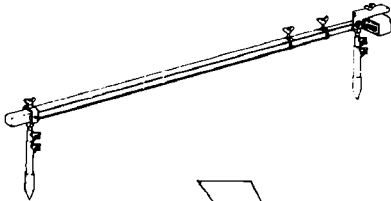
Keeping your hand tools in neat order will have an effect on your work efficiency.

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.

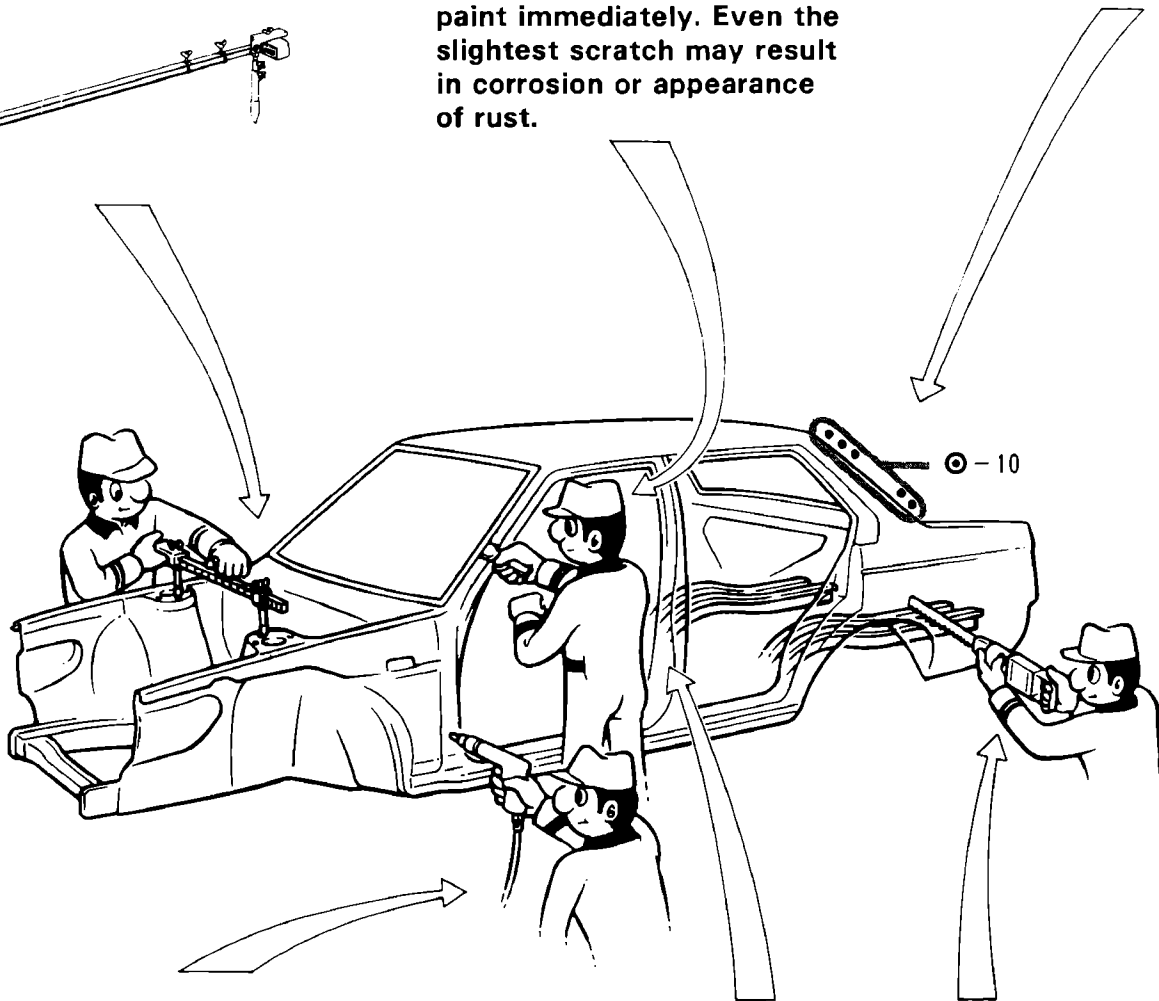
CAUTION:

1. Be especially careful not to damage screw or clip holes.
2. If the paint is accidentally 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.

REMOVAL OF ADJACENT PARTS

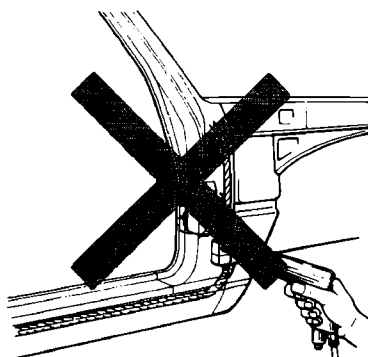
When removing adjacent parts by avoid accidental marring, etc., wrapping the tools used and surrounding body parts in protective tape.

NOTE:

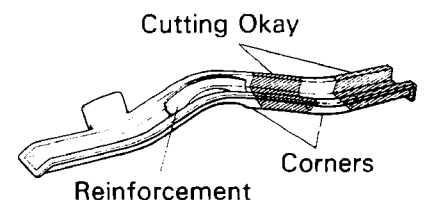
- 1) Take particular care not to damage any screw or clip holes.
- 2) If you do scratch a painted surface, retouch immediately after. Even a small scratch will result in rust and corrosion.

CUTTING AREA

Always cut in a straight line and avoid reinforced areas.

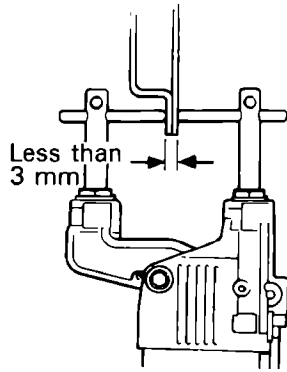


WRONG



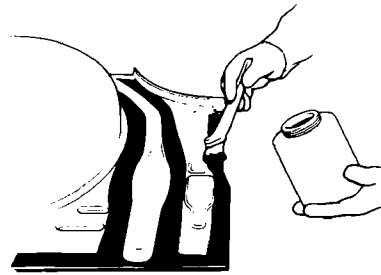
PREPARATION FOR INSTALLATION

SPOT WELD POINTS

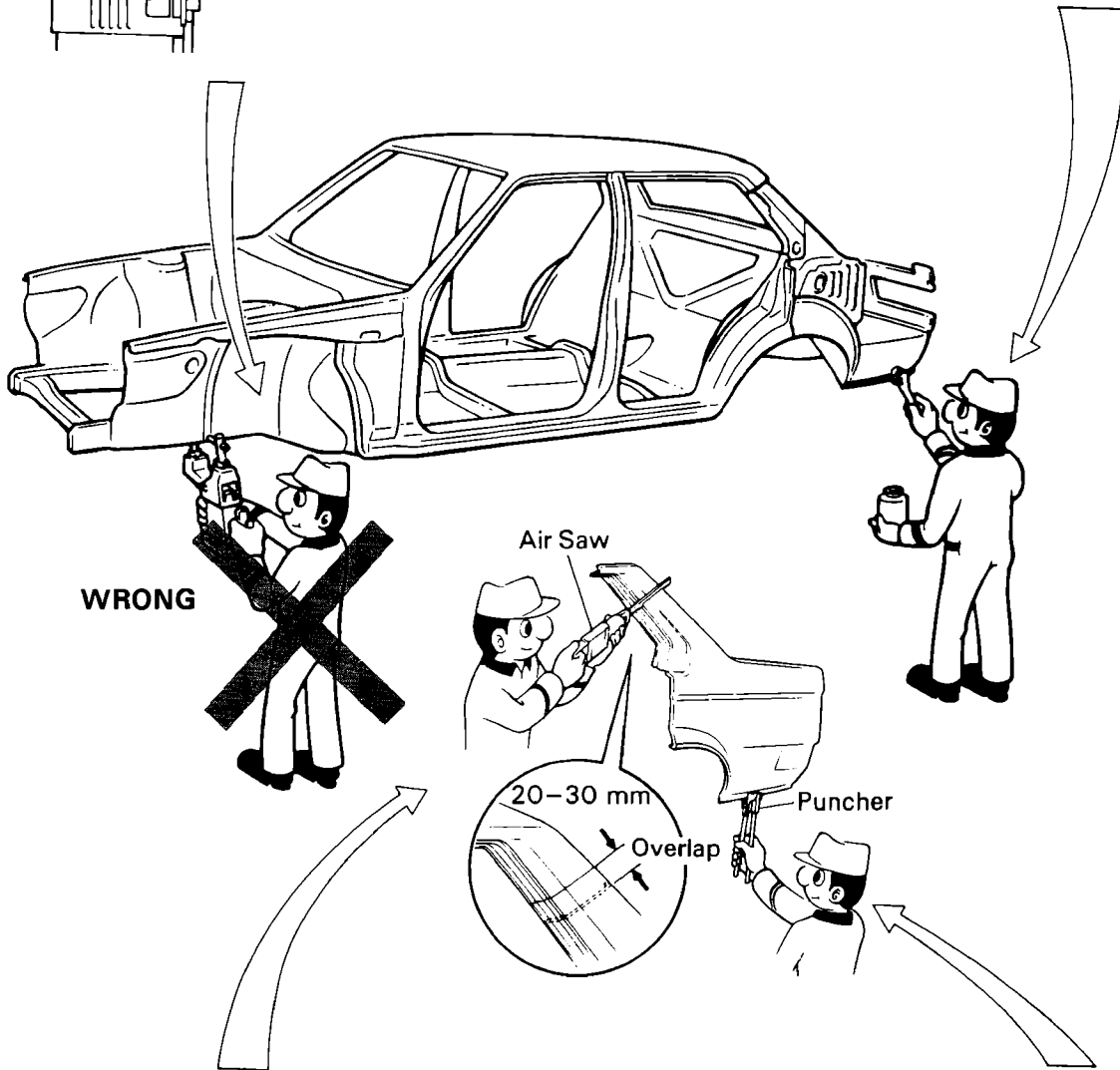


When welding panels with a combined thickness of over 3 mm (0.12 in.), use a MIG (Metal Inert Gas) welder for plug welding.
NOTE: Spot welding will not provide sufficient durability for panels over 3 mm (0.12 in.) thick.

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.



WRONG

Air Saw

20-30 mm

Overlap

Puncher

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:

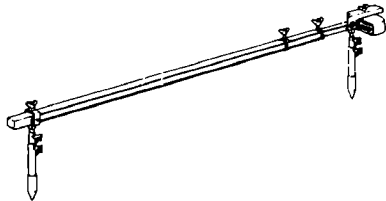
mm (in.)

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

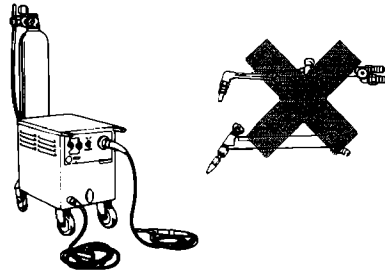
PRE-WELDING MEASUREMENTS

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



WELDING PRECAUTIONS

- 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.

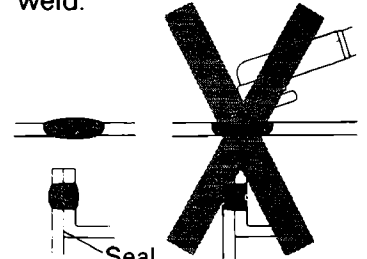


OKAY WRONG

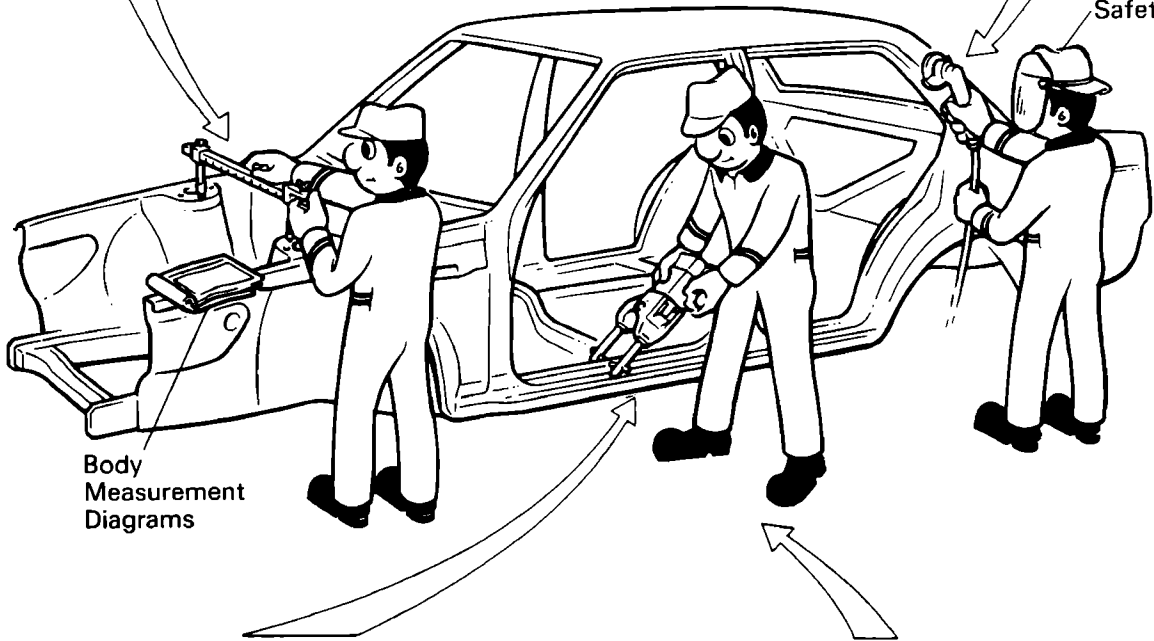
- Plug welding should be done with a MIG (Metal Inert Gas) welder. Do not gas weld or braze panels at areas other than specified.

POST-WELDING REFINISHING

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

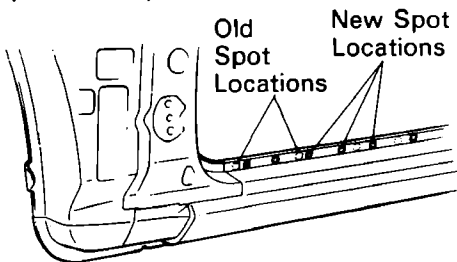


OKAY WRONG



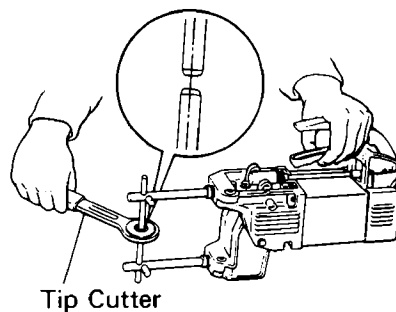
SPOT WELD LOCATIONS

Try to avoid welding over previous spots.



SPOT WELDING PRECAUTIONS

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

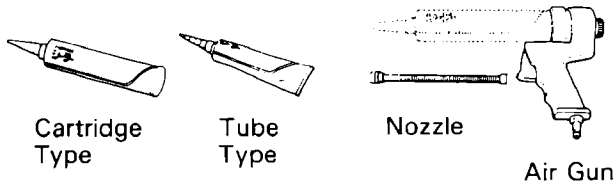


ANTI-CORROSIVE TREATMENT

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

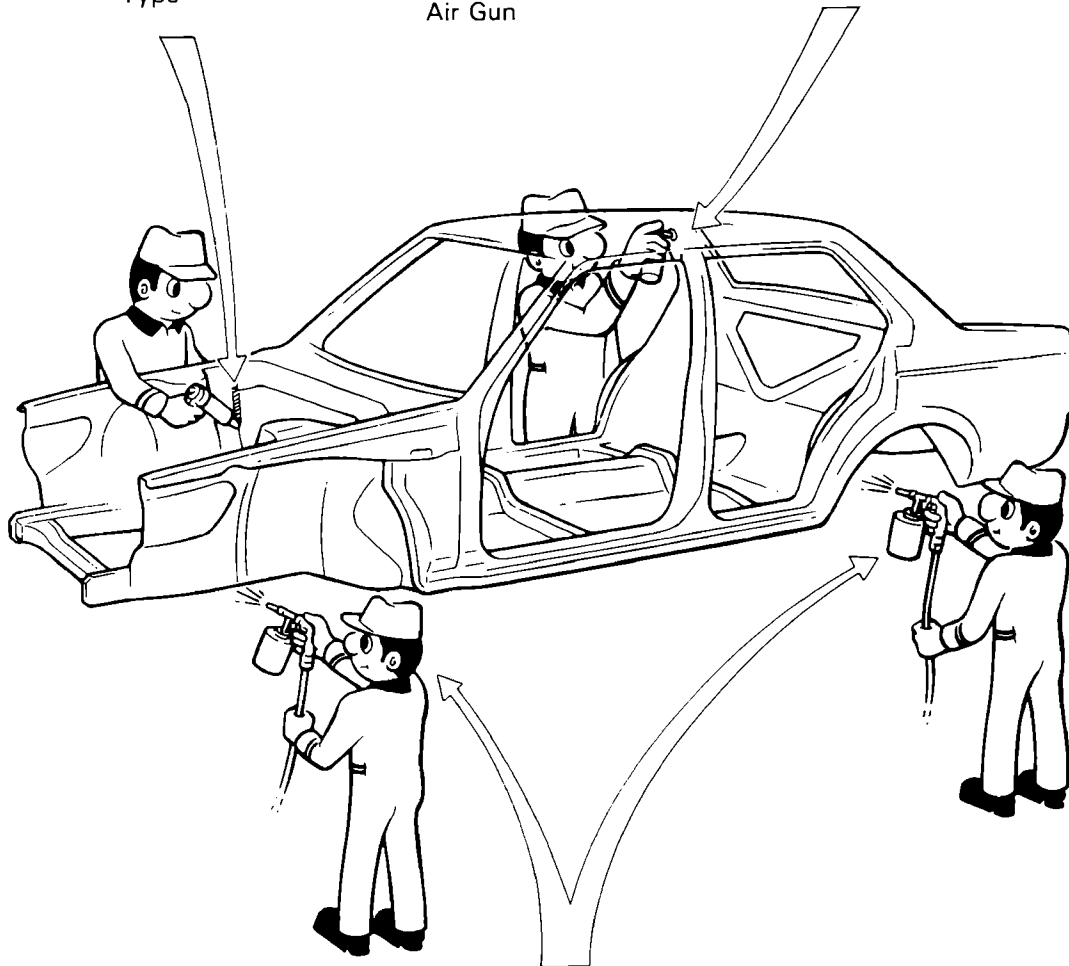
BODY SEALER

Apply body sealer to the required areas.



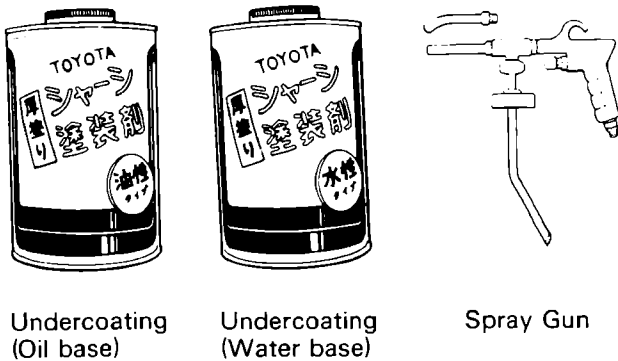
CHASSIS RUST-PROOFING

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

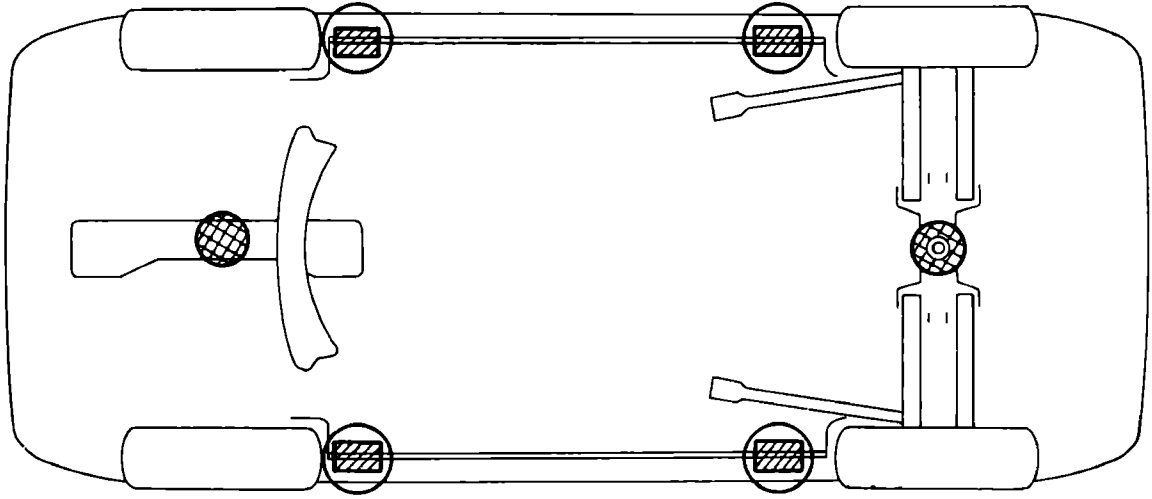


UNDERCOATING

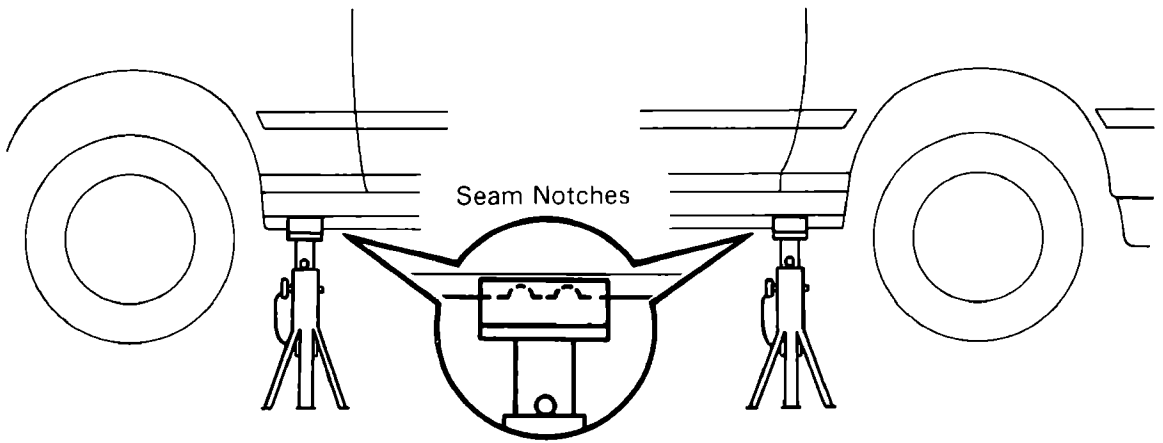
Anti-rust treatment for underbody welding spots and wheel housings.



VEHICLE LIFT AND SUPPORT LOCATIONS



← Front



JACK POSITION _____ ●

Front
Rear

Center of engine mounting center member
Jack up support of rear floor pan

PANTOGRAPH JACK POSITION _____ ○

SUPPORT POSITION

Safety stand ▨

ABBREVIATIONS USED IN THIS MANUAL

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

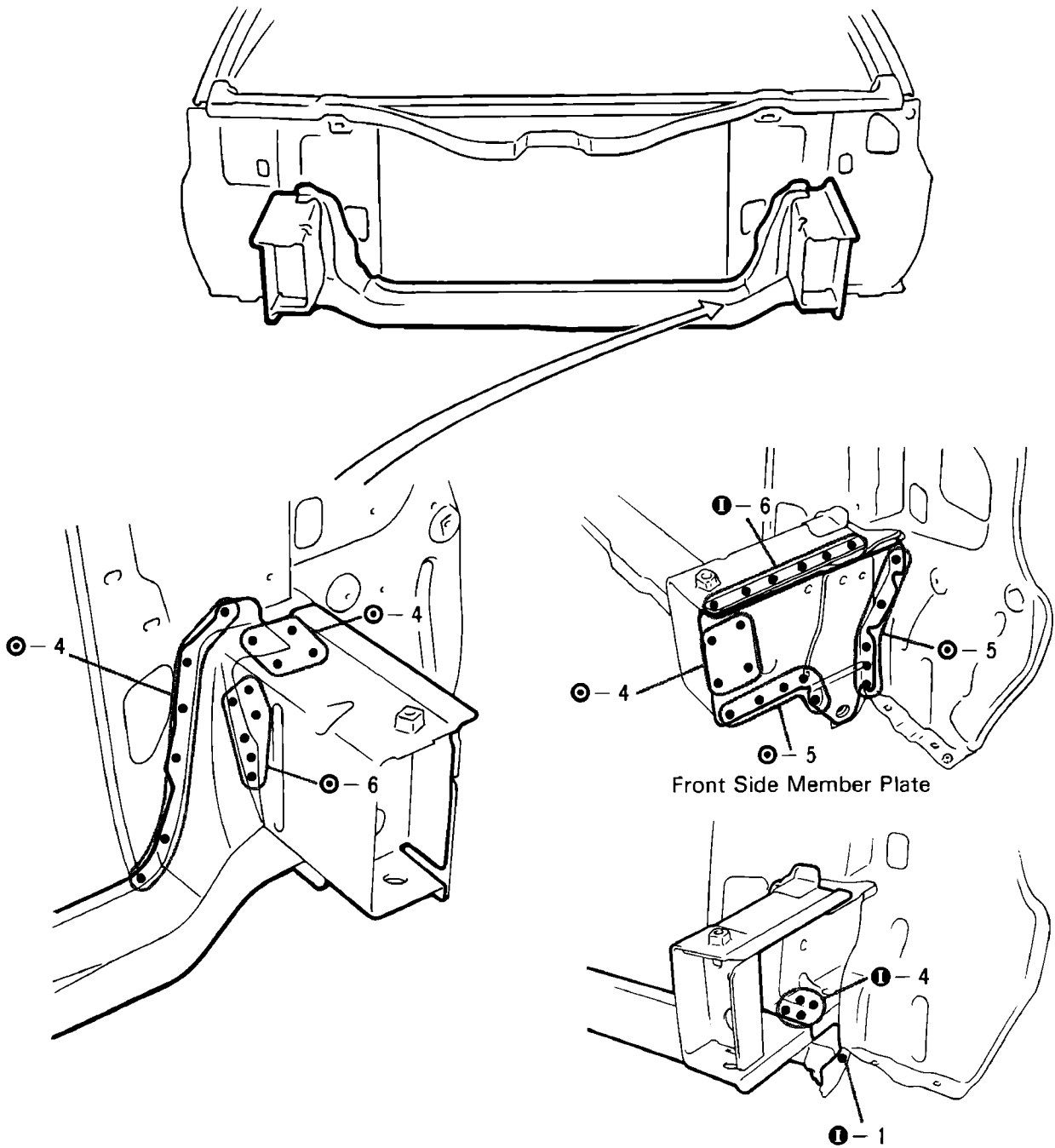
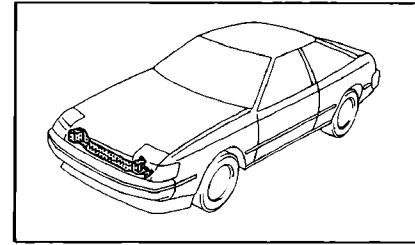
Assy, assy	Assembly, assembly
Sub-assy	Sub-assembly
Ex.	Except
in.	Inch
IRS	Independent Rear Suspension
4-link	4-link Rear Suspension
MIG	Metal Inert Gas
OPN	Operation
SP	Spot Weld (Resistance Spot Weld)
w/	With
w/o	Without
FR	Front
RR	Rear
RH	Right-hand
RHD	Right-hand Drive
LH	Left-hand
LHD	Left-hand Drive

BODY PANEL REPLACEMENT

	Page
FRONT BODY COMPONENTS	
FRONT CROSSMEMBER (ASSY)	RE-2
RADIATOR SUPPORT (ASSY)	RE-4
RADIATOR UPPER SUPPORT (ASSY)	RE-6
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REAR FLOOR SIDE MEMBER (ASSY)	RE-54
REAR FLOOR NO. 2 CROSSMEMBER (ASSY)	RE-56

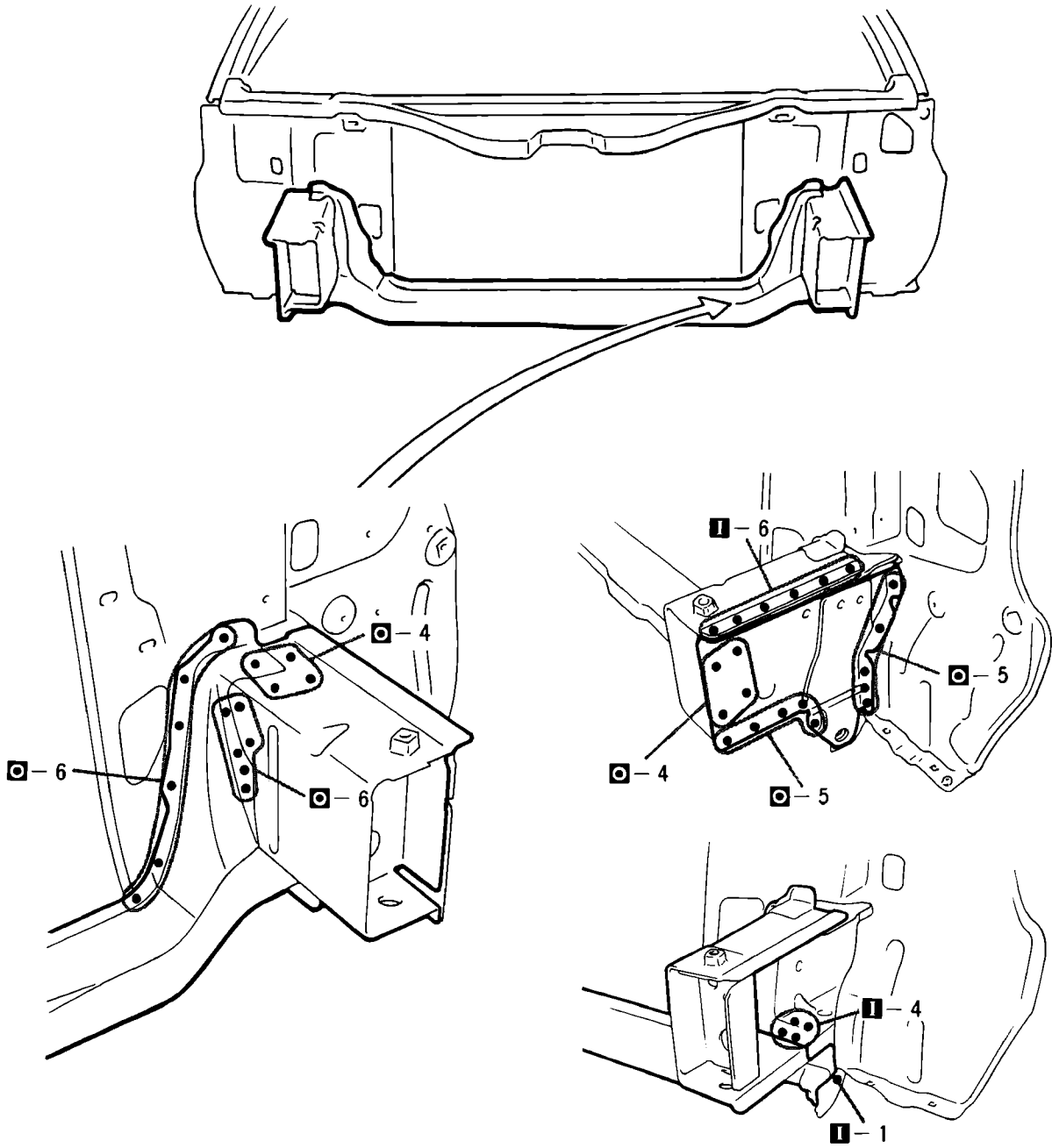
FRONT CROSSMEMBER (ASSY)

REMOVAL



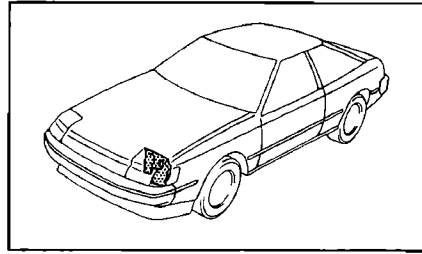
1. Remove the front side member plate.
2. After rough cutting the crossmember, cut the front side member weld points from the lower side.

INSTALLATION



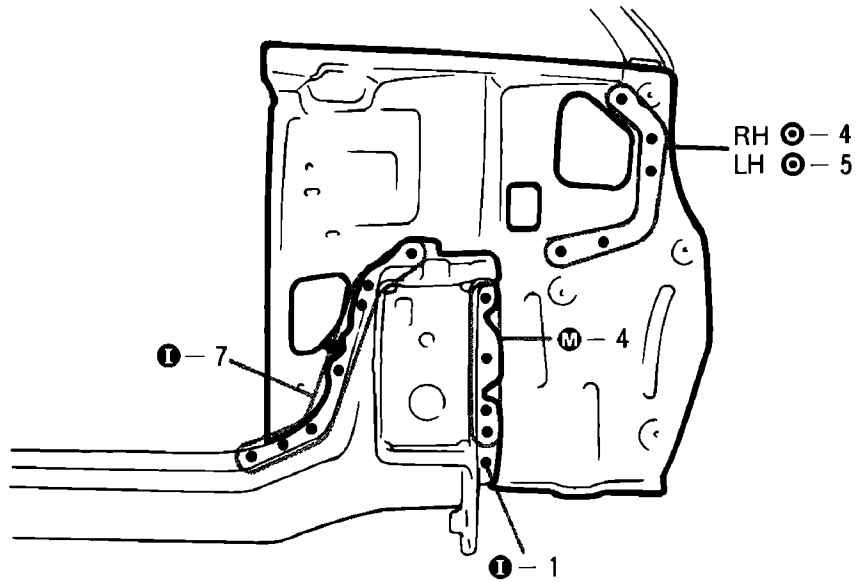
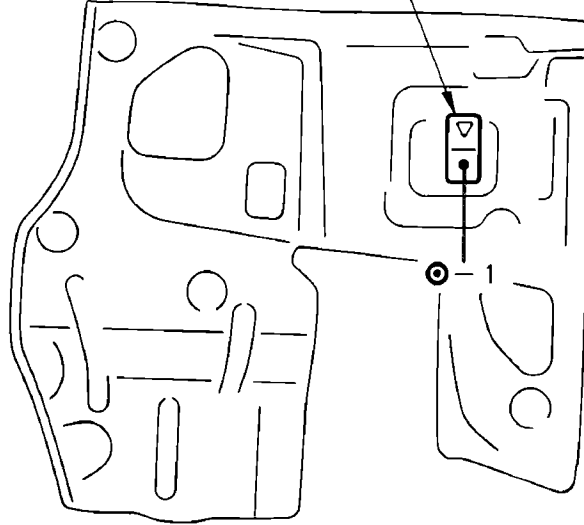
1. Temporarily install the new part and measure each part in accordance with the body dimension diagram.

RADIATOR SUPPORT (ASSY)



REMOVAL

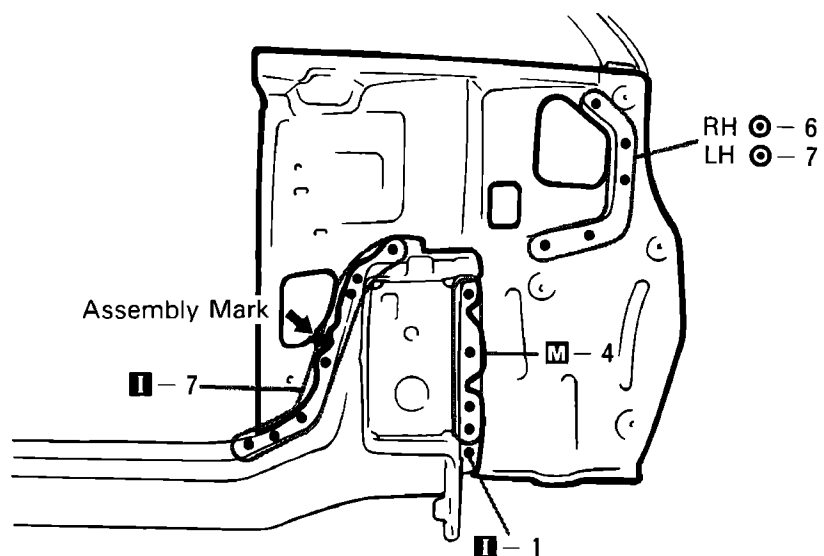
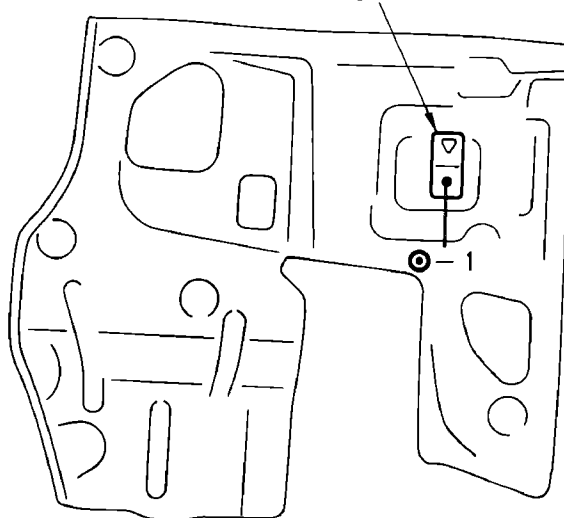
Relay Box Mounting Bracket (LH only)



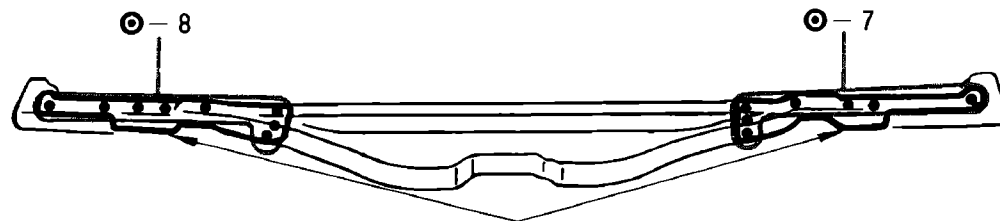
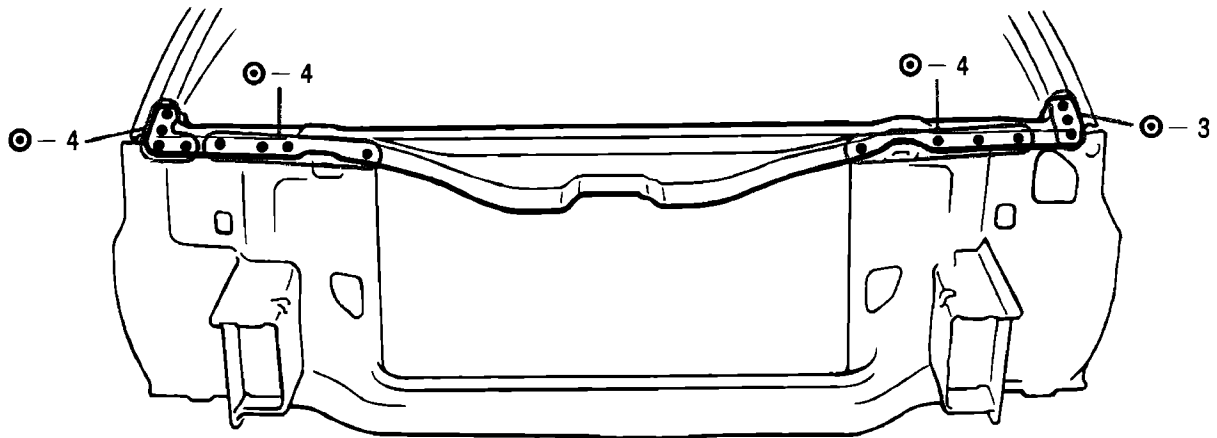
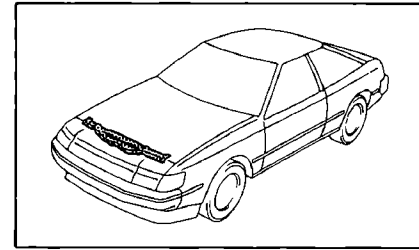
1. If reusing the relay box mounting bracket, remove it from the radiator support. (LH)

INSTALLATION

Relay Box Mounting Bracket (LH only)



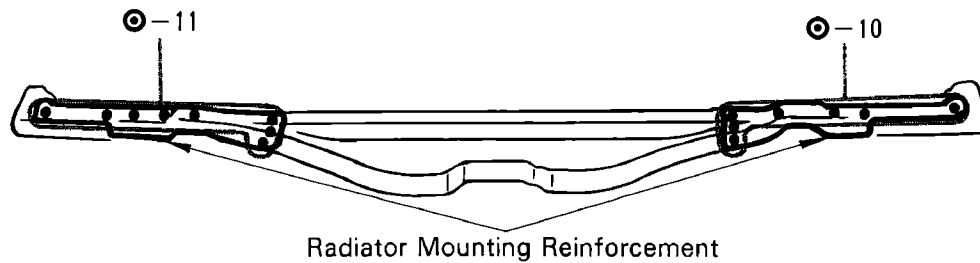
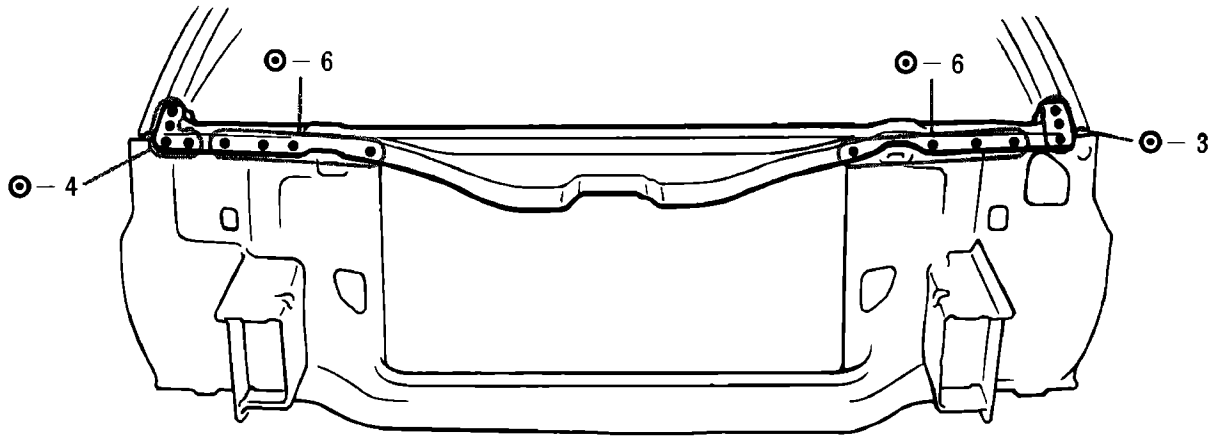
1. Temporarily install the new part with the assembly mark and measure each part in accordance with the body dimension diagram.

RADIATOR UPPER SUPPORT (ASSY)**REMOVAL**

Radiator Mounting Reinforcement

1. If reusing the radiator mounting reinforcements, remove them from the radiator upper support.

INSTALLATION

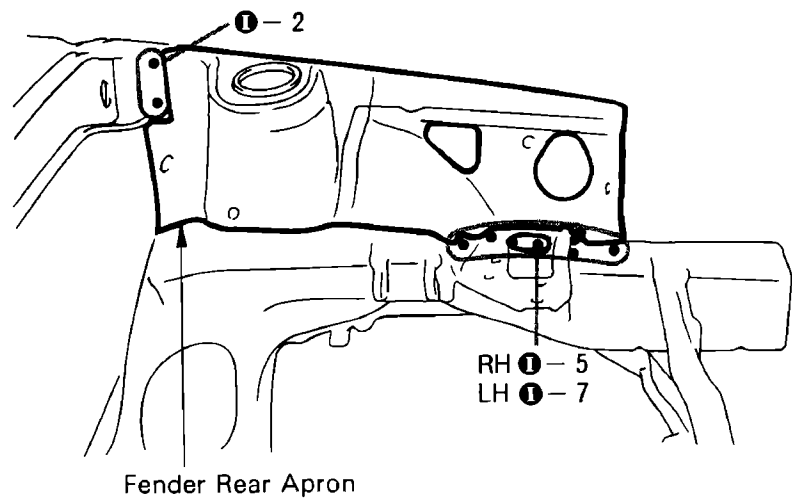
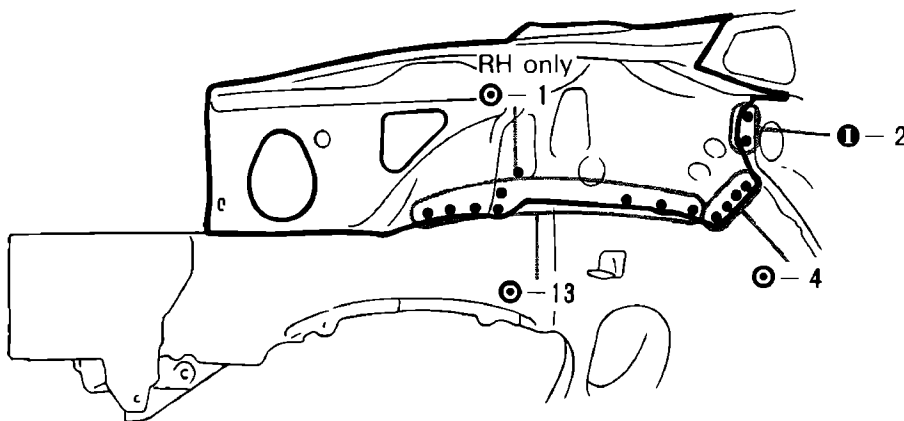
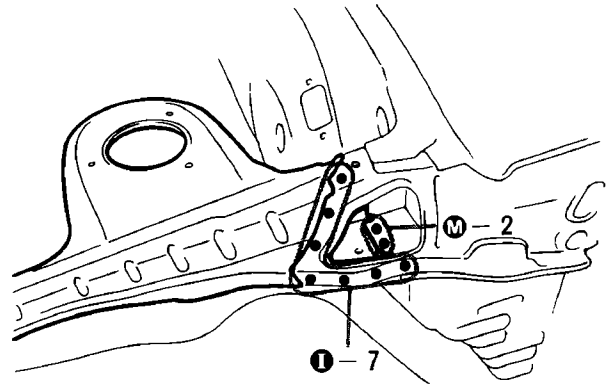
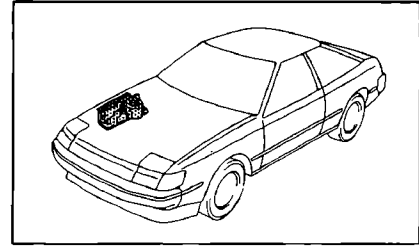


1. Before temporarily installing the new part, install the radiator mounting reinforcements to the part.
2. Temporarily install the new part and measure each part in accordance with the body dimension diagram.

NOTE: Install the new panel with the hood lock support.

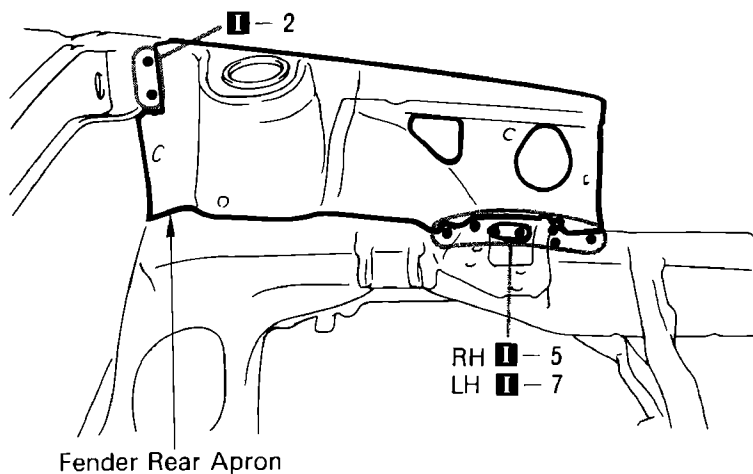
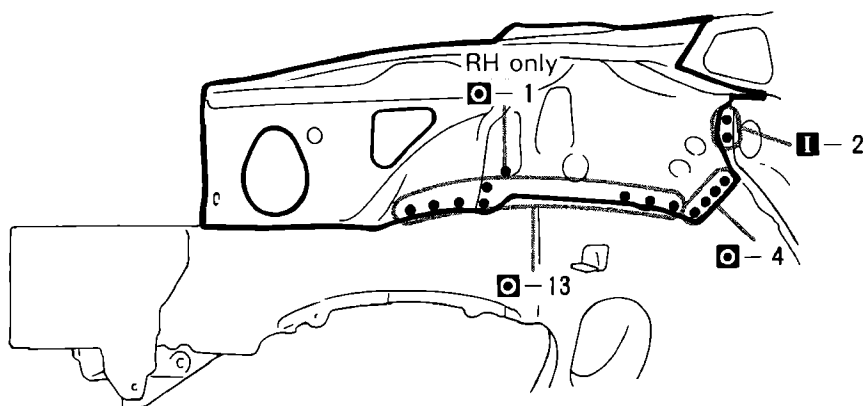
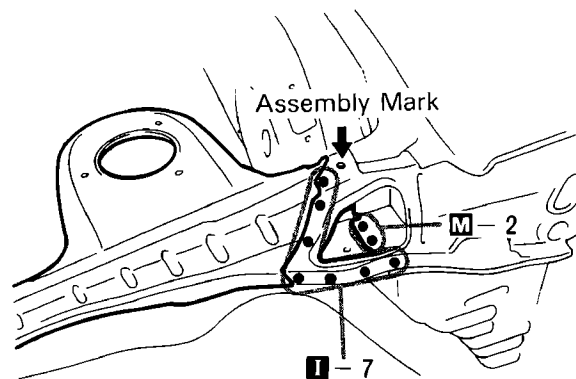
FRONT FENDER APRON (ASSY)

REMOVAL



1. Repair can be done with the fender rear apron left on the vehicle.

INSTALLATION



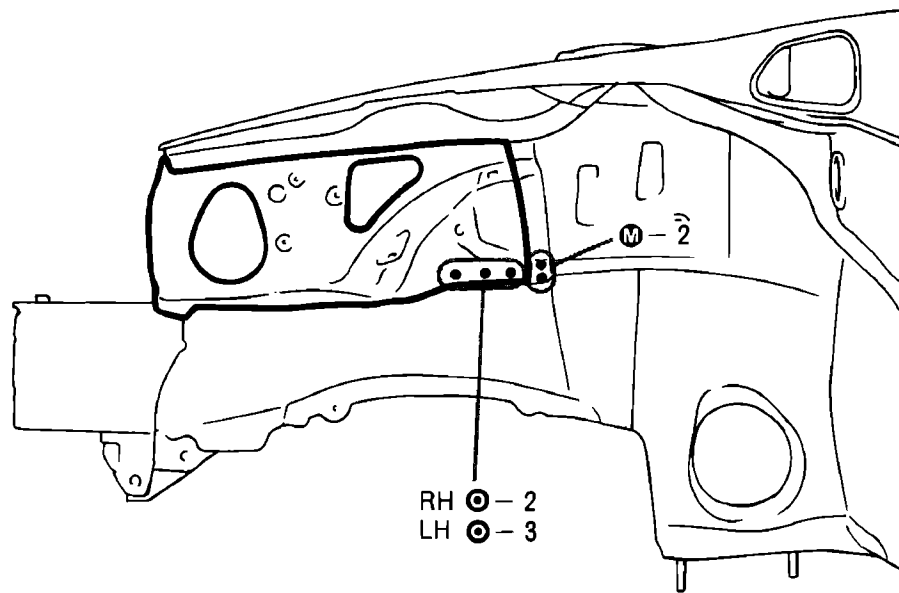
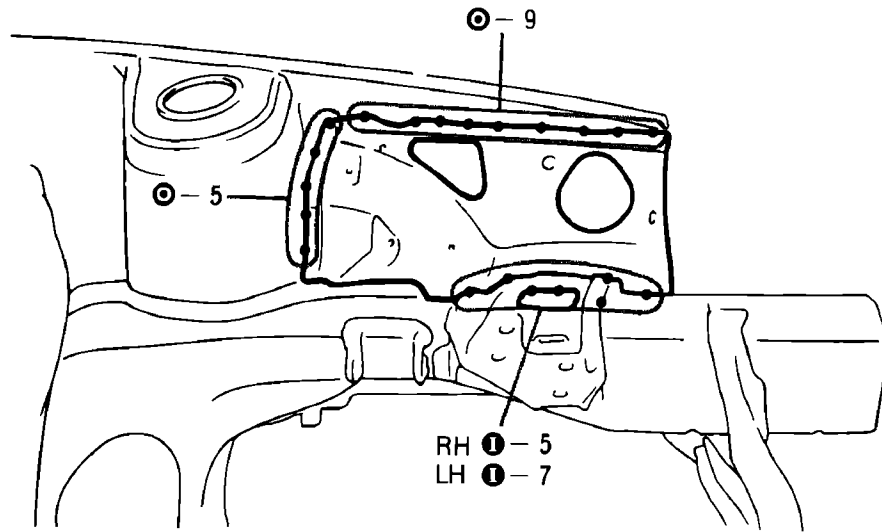
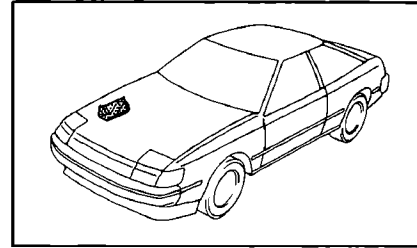
1. Determine the installation position of the new part by the assembly mark.
2. Measurements must be accurate with the body dimension diagram, as this effects the front wheel alignment.

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

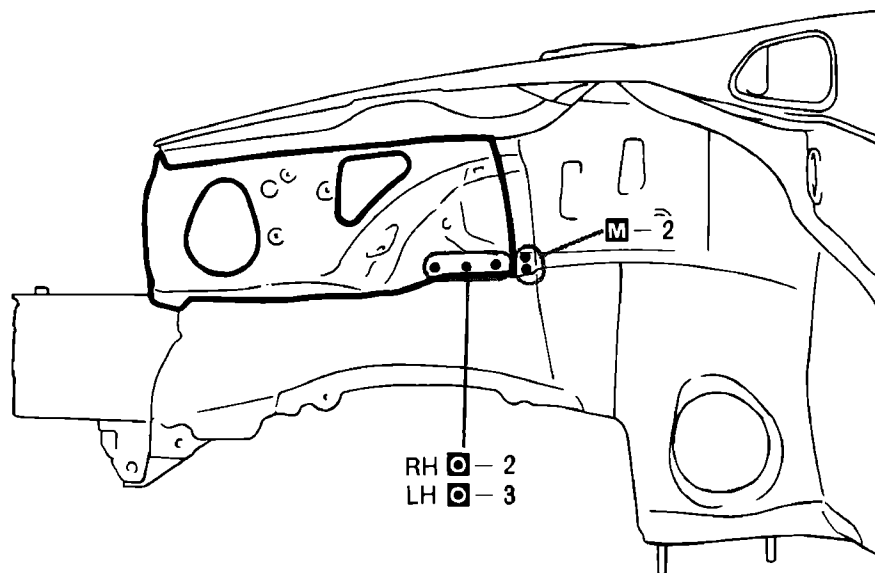
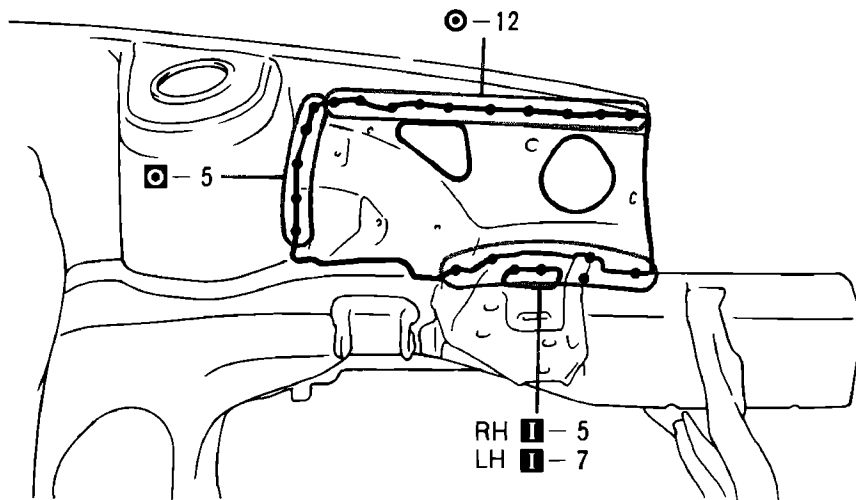
3. Check the fit of the front fender and hood.

FRONT FENDER FRONT APRON (ASSY)

REMOVAL

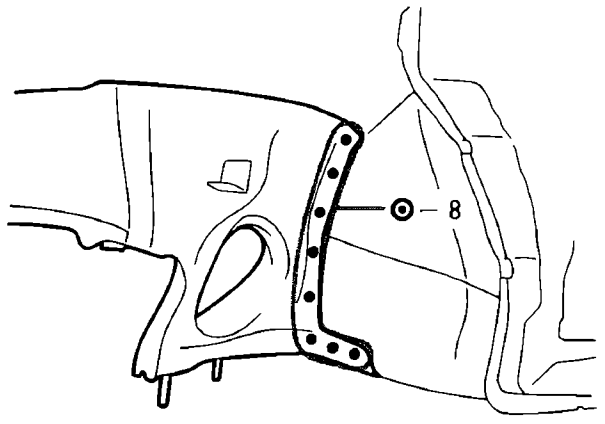
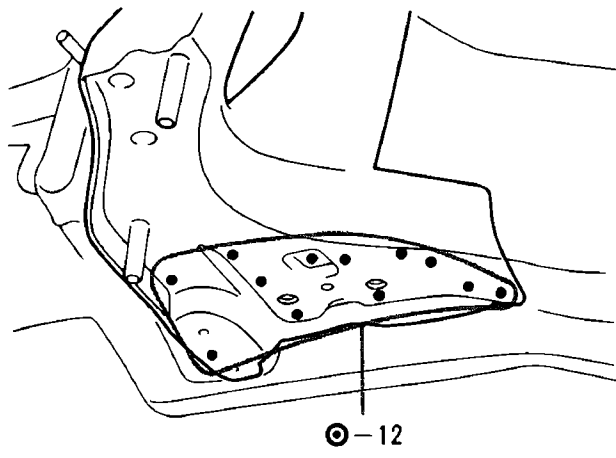
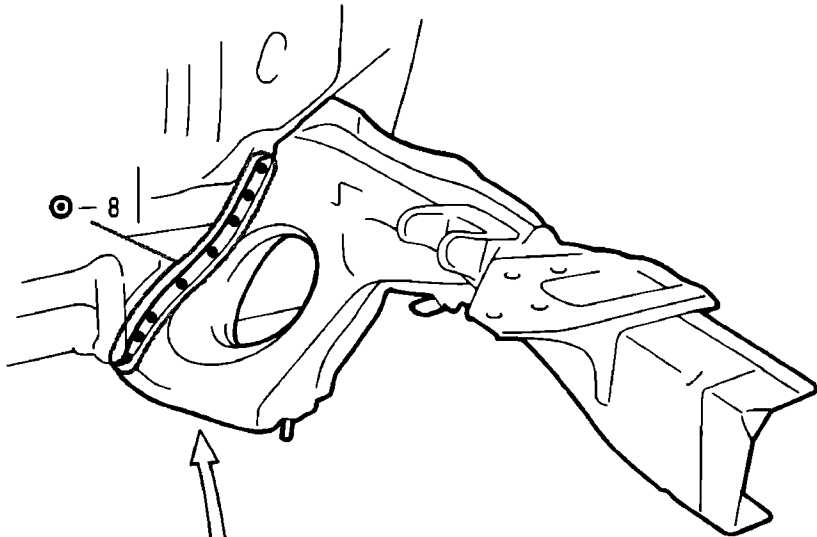
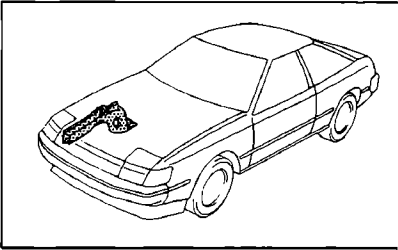


INSTALLATION

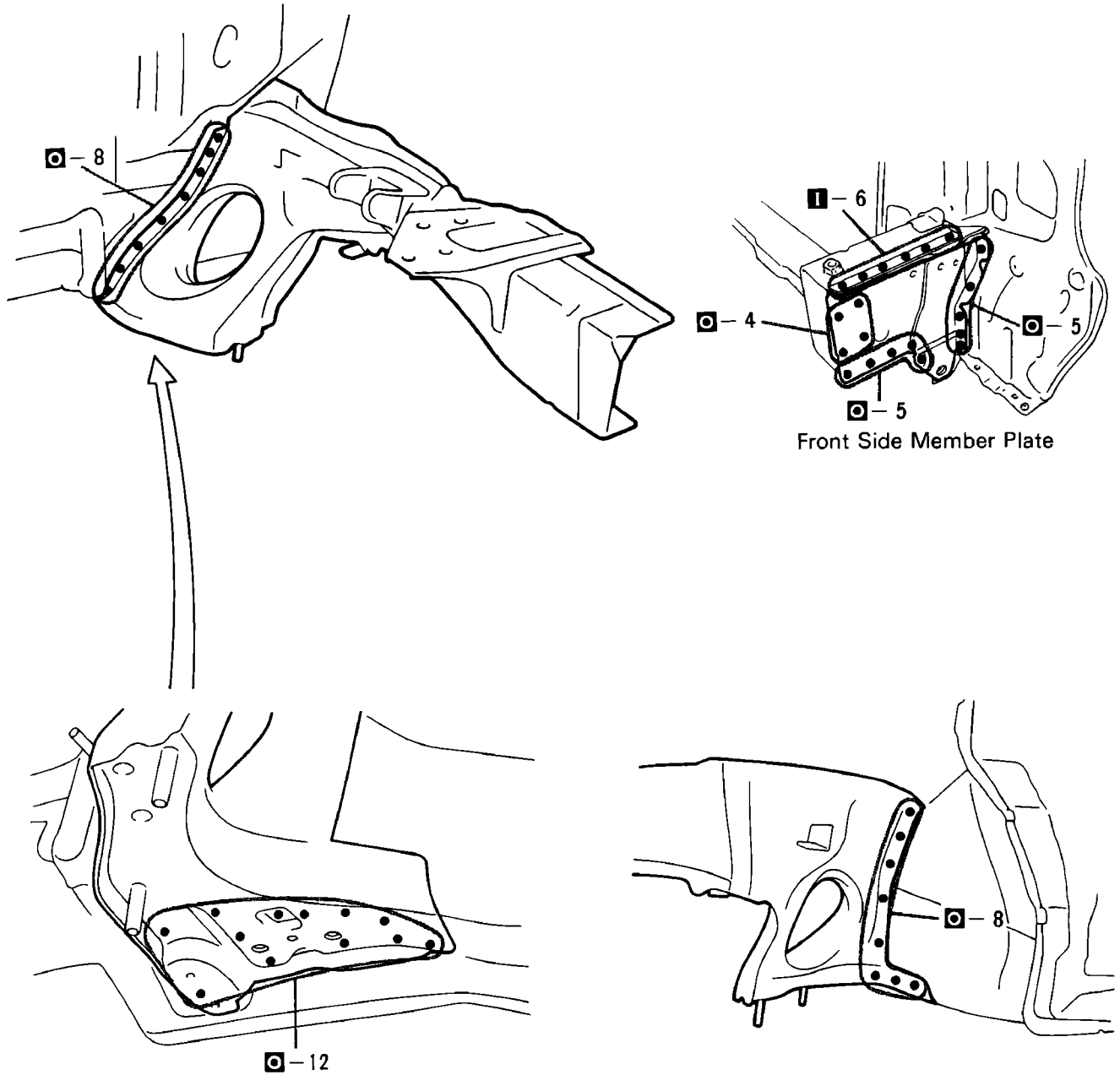


FRONT SIDE MEMBER (ASSY)

REMOVAL



INSTALLATION

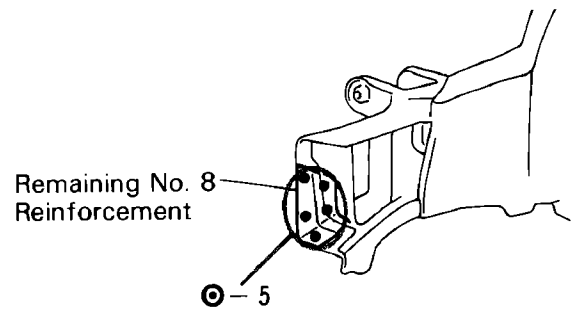
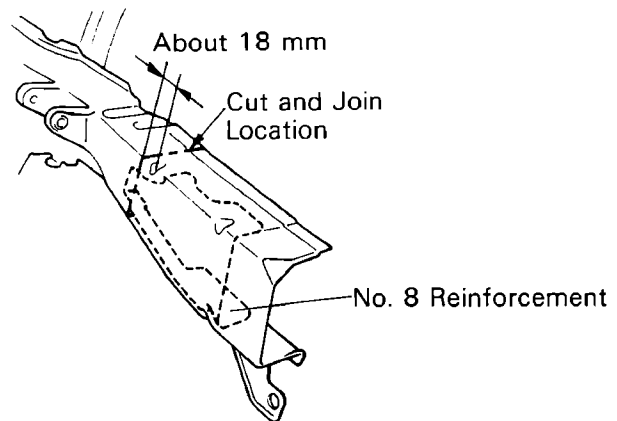
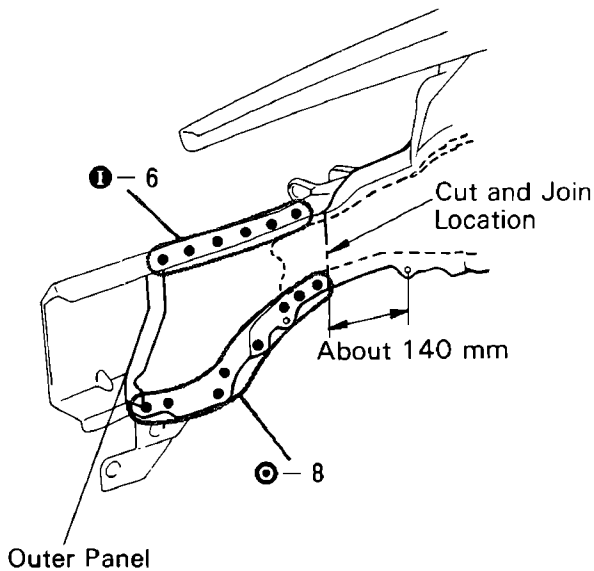
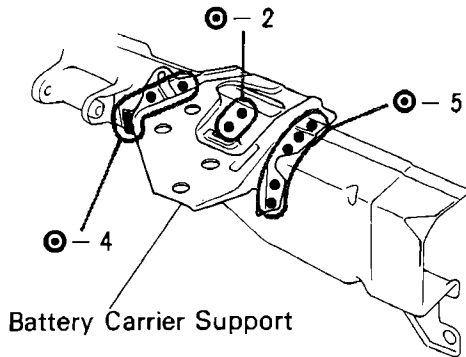
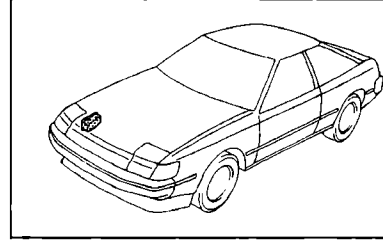


1. Temporarily install the new part and measure each part in accordance with the body dimension diagram.

NOTE: Make sure each measurement is correct, as this part effects the front wheel alignment.

FRONT SIDE MEMBER (CUT-P)

REMOVAL



mm	in.
18	0.71
140	5.51

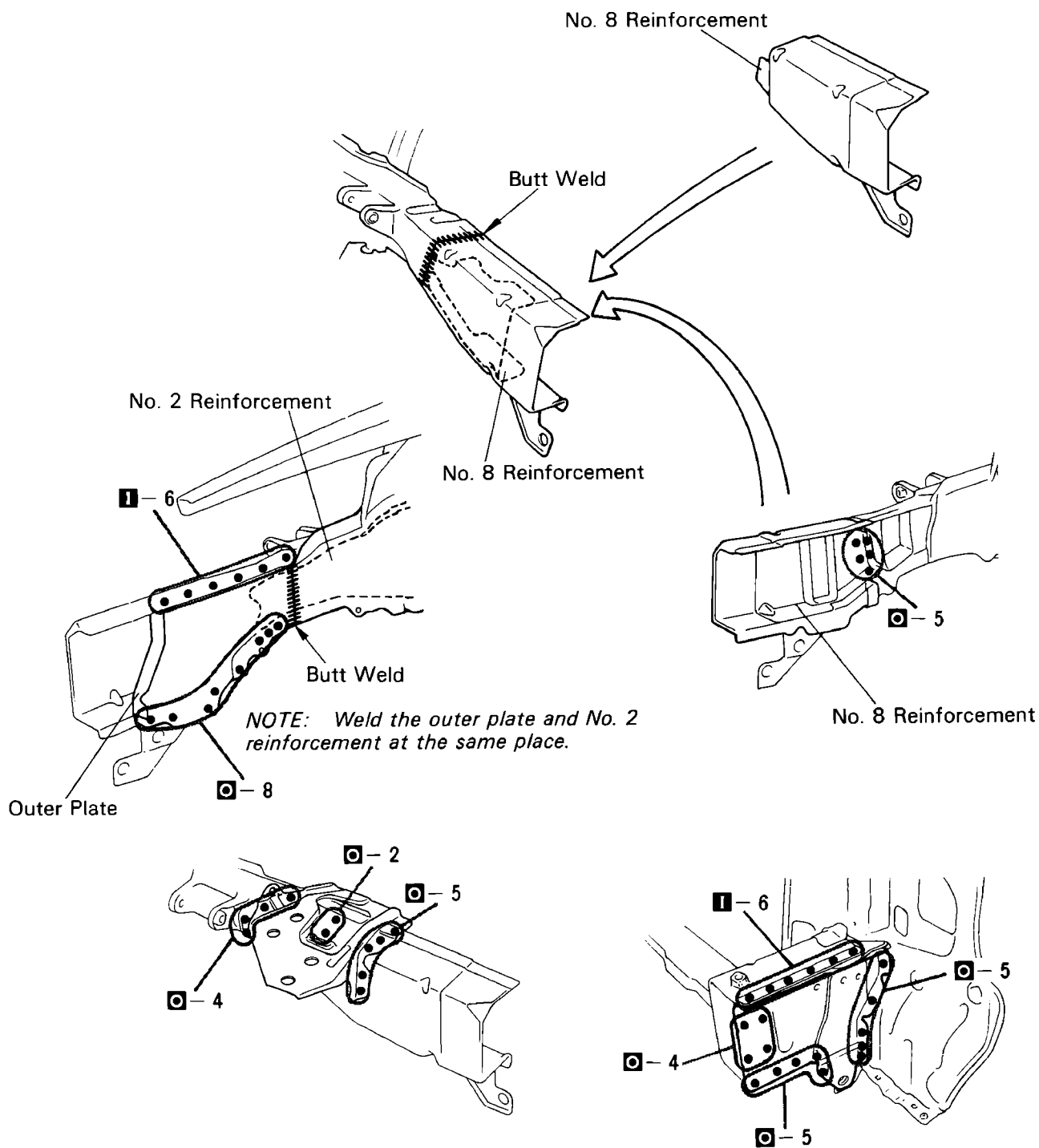
1. Before cutting the side member, remove the battery carrier support. (LH only)
2. Cut and join the front side member as shown above.

NOTE:

- 1) Cut and join the front side member outer panel and the No. 2 reinforcement at the same place. (With No. 2 reinforcement)
- 2) Cut the front side member and the No. 8 reinforcement at the same place. (With No. 8 reinforcement)
3. Remove the remaining No. 8 reinforcement. (With No. 8 reinforcement)

INSTALLATION

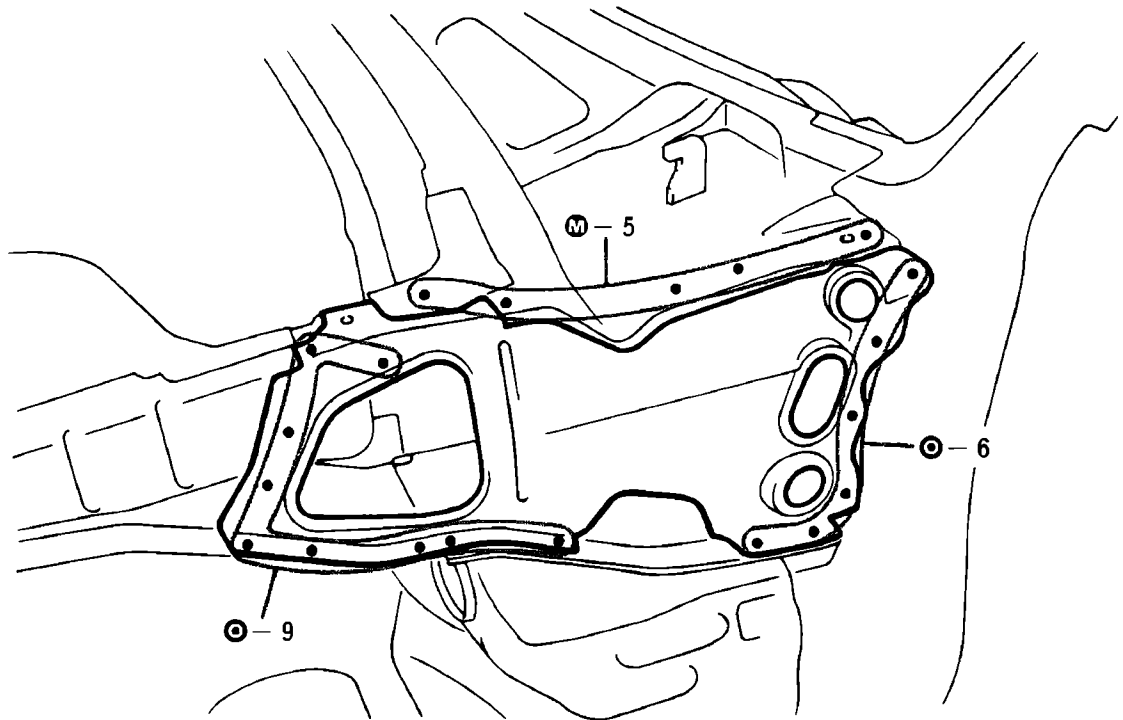
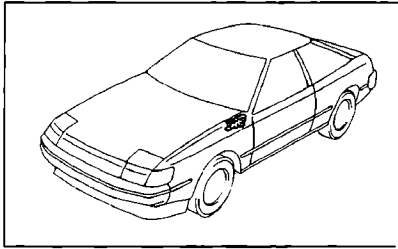
*NOTE: Be careful not to damage the No. 8 reinforcement when cutting the new side member.
(With No. 8 reinforcement)*



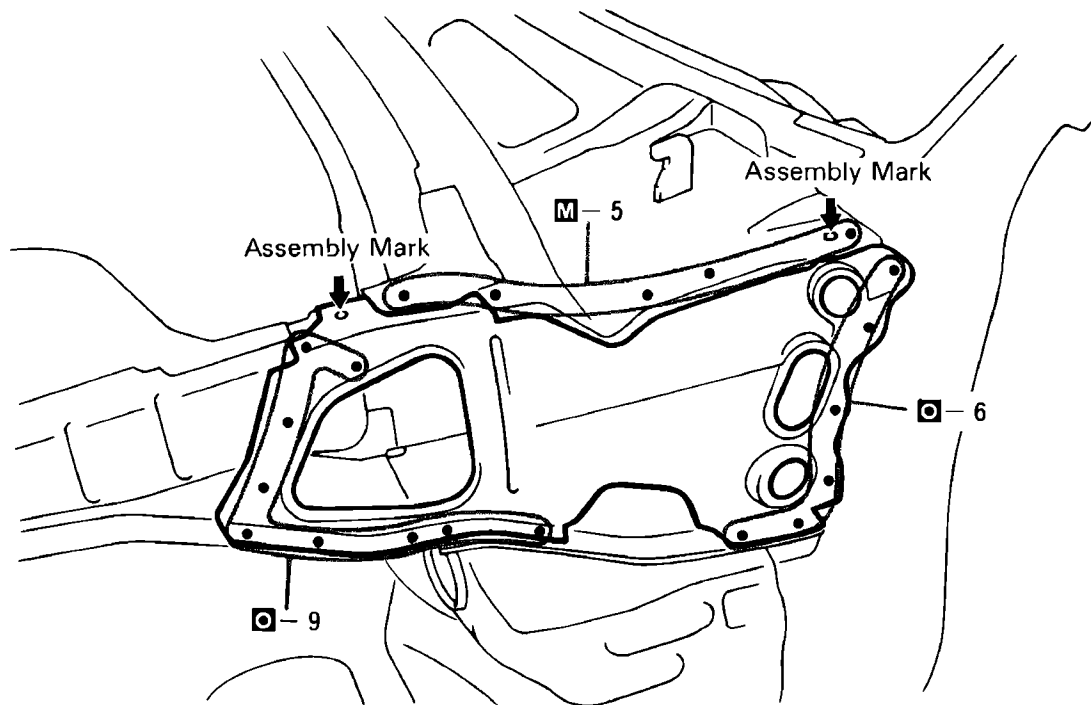
1. Be careful not to damage the No. 8 reinforcement when cutting the new side member. (With No. 8 reinforcement)
2. Temporarily install the new member, measure each part in accordance with the body dimension diagram.
3. After installing the new member, install the battery carrier support. (LH only)

COWL TOP SIDE PANEL (ASSY)

REMOVAL



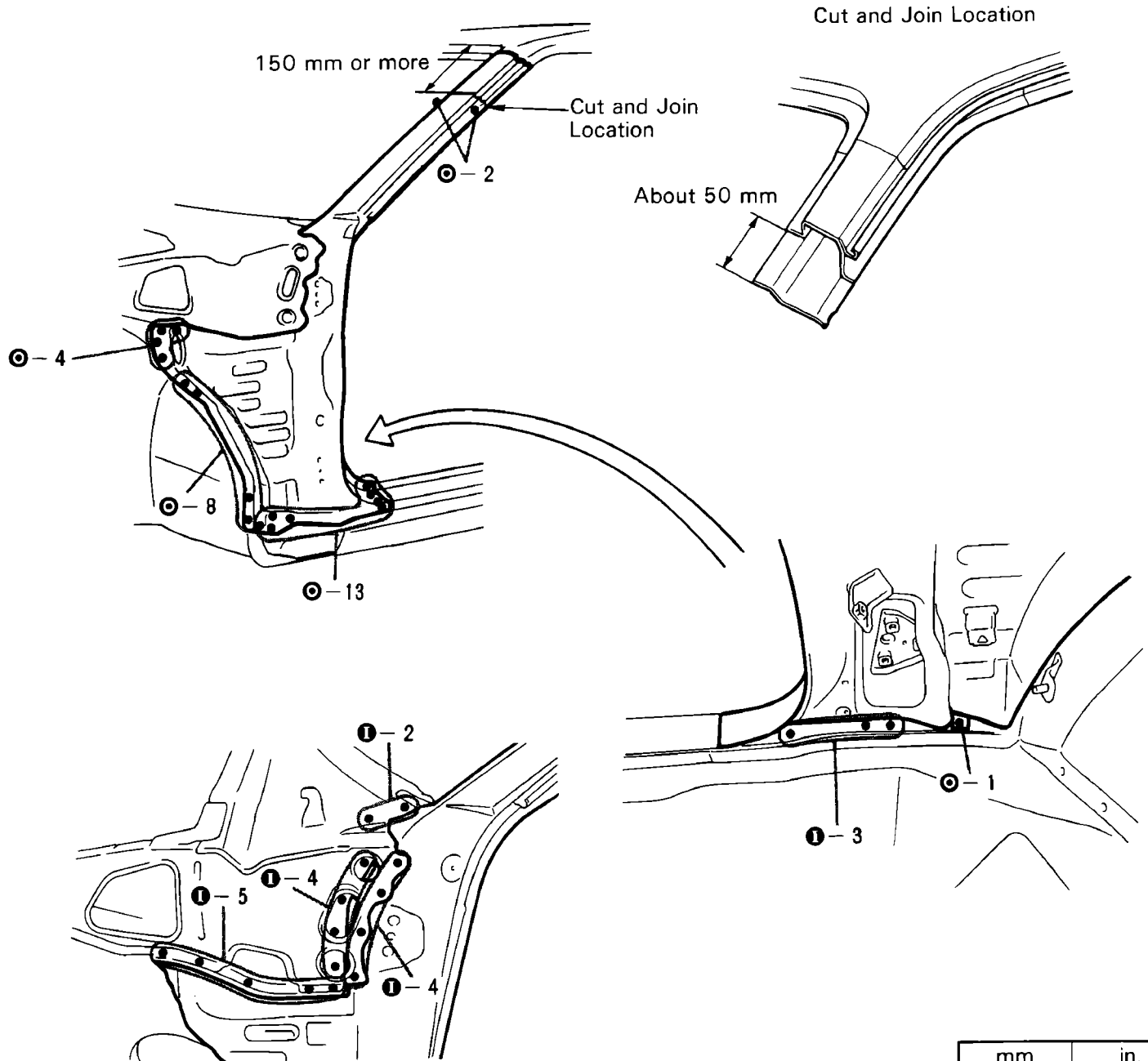
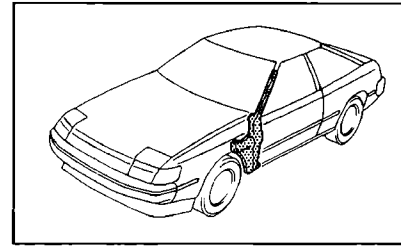
INSTALLATION



1. Determine the installation position of the new part by the assembly mark.
2. Temporarily installing the new part and measure each part in accordance with the body dimension diagram.

FRONT BODY PILLAR (CUT)

REMOVAL



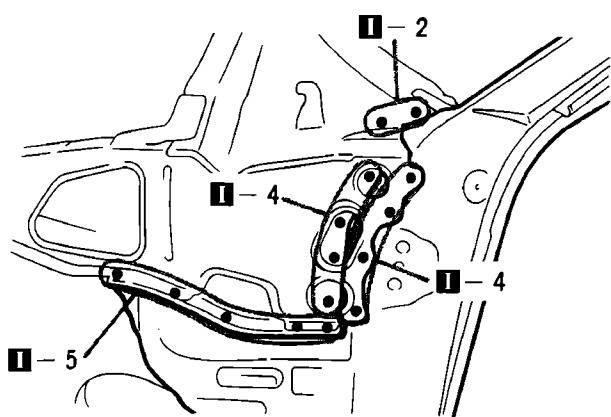
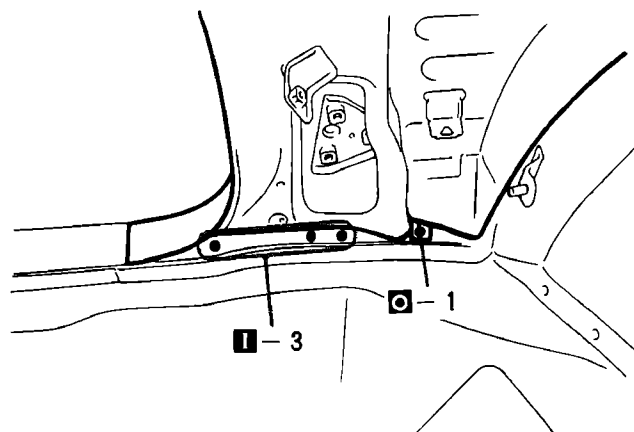
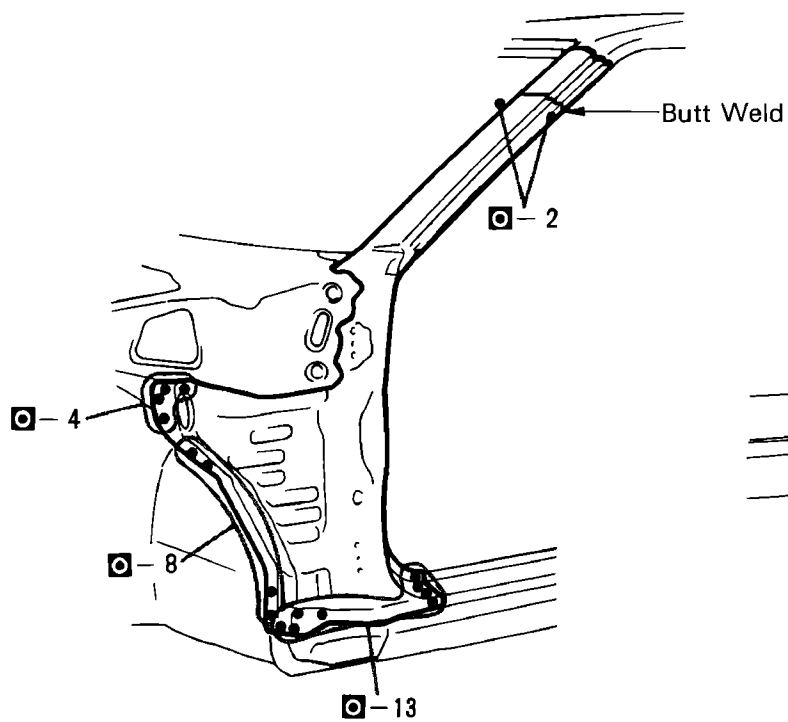
mm	in.
50	1.97
150	5.91

1. Cut and join the front body pillar at the location shown above.

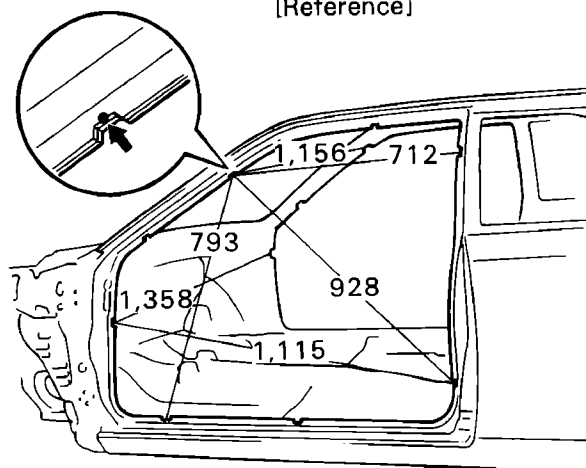
NOTE:

- 1) As shown above, cut and join the front body pillar outer and inner panels at a position shifted about 50 mm (1.97 in.).
- 2) Before cutting, remove the antenna cord and drain hose of the sun roof.

INSTALLATION



[Reference]

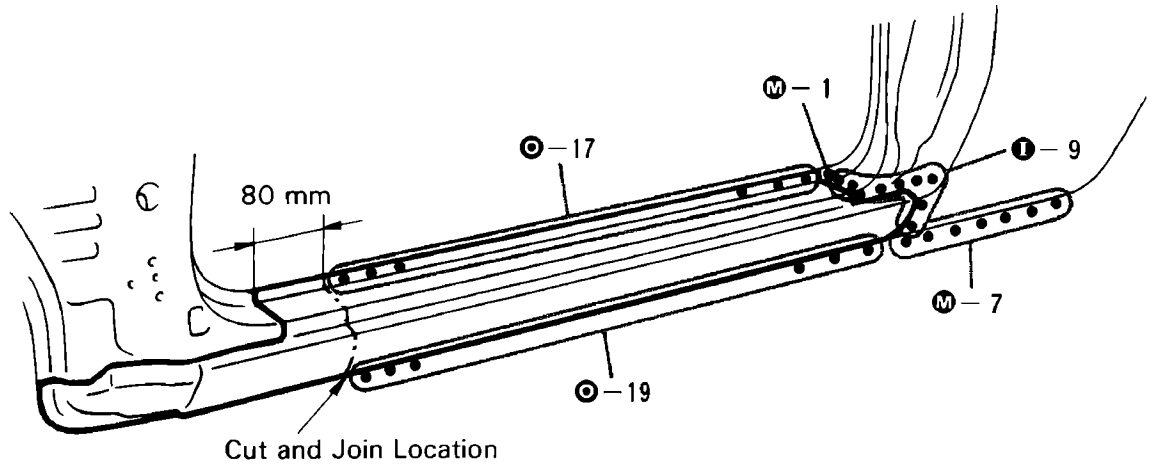
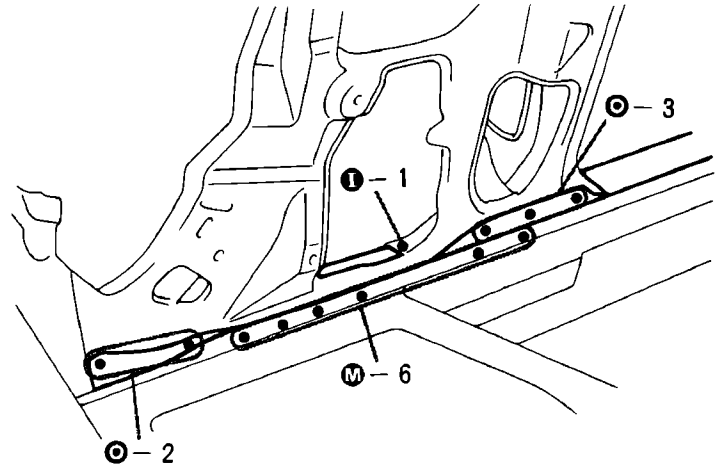
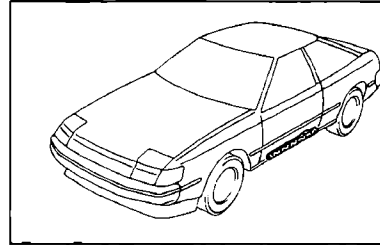


mm	in.
712	28.03
793	31.22
928	36.54
1,115	43.90
1,158	45.59
1,358	53.46

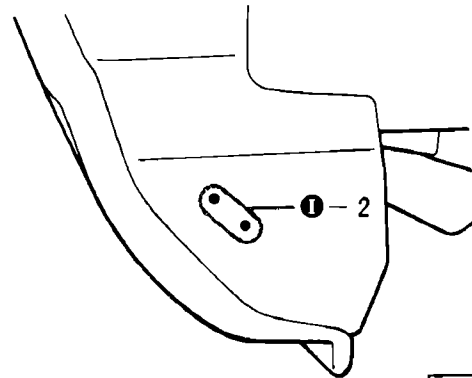
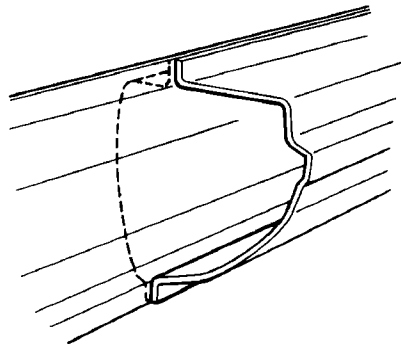
1. Temporarily installing the new part and check the fit of the front door, front fender, hood and windshield glass.

OUTER ROCKER PANEL (CUT)

REMOVAL



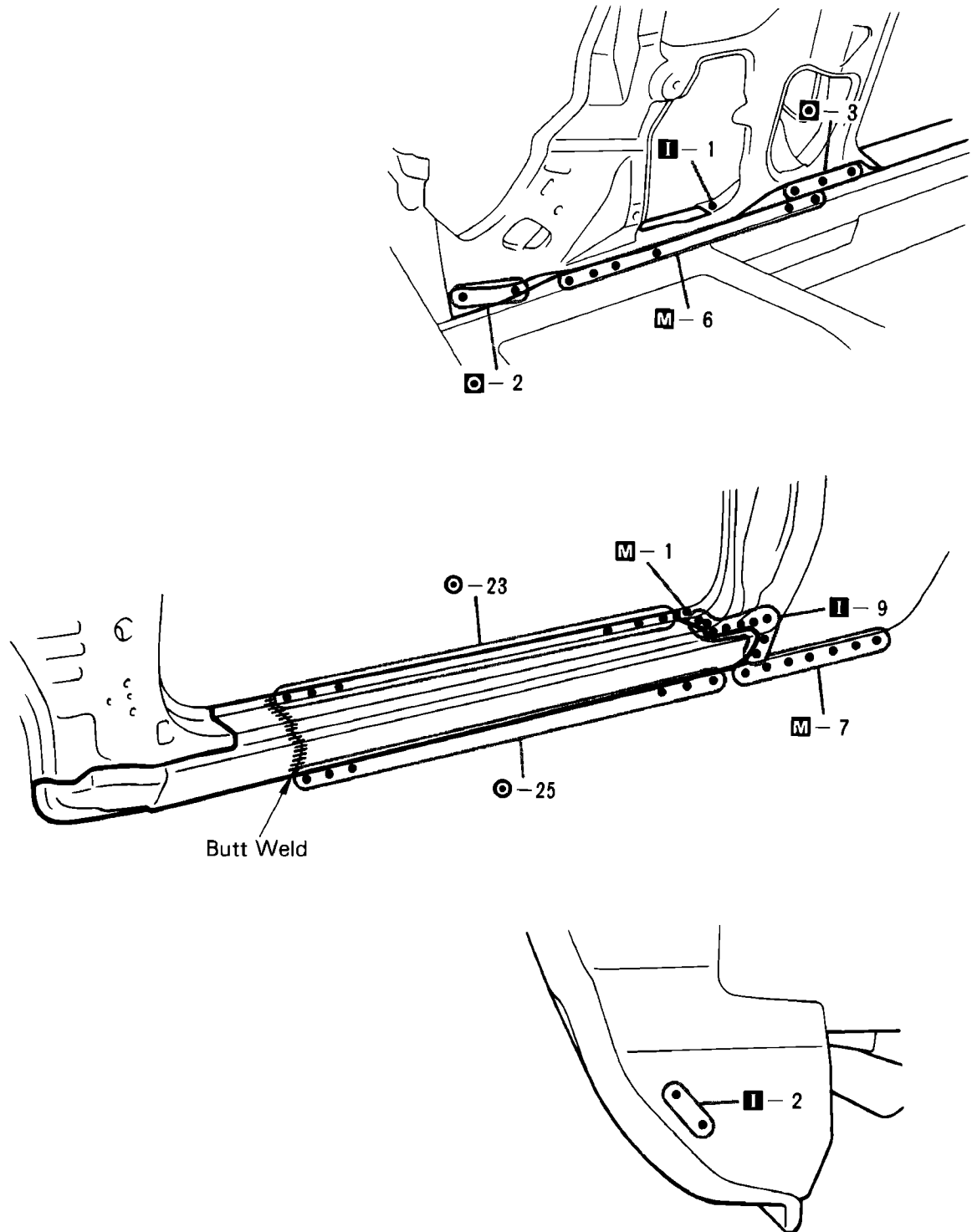
Cut and Join Location



mm	in.
80	3.15

1. Cut and join the outer panel at the area as shown above.

INSTALLATION

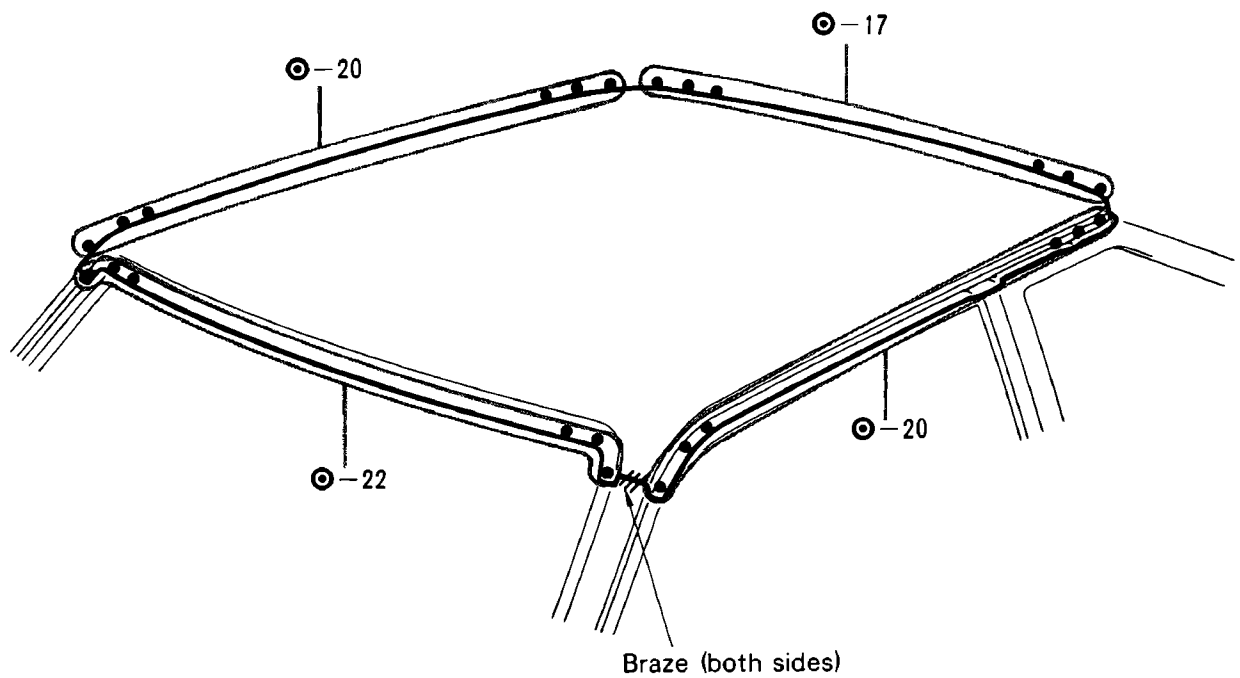
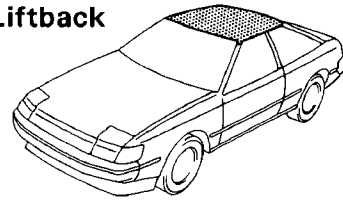


1. Temporarily installing the new panel and check the fit for the front door and front fender.
2. There will be less warp if the cut edge (30 – 40 mm or 1.18 – 1.57 in.) is adhered to the matching part before welding.

NOTE: Scrape off the film on the cut edge and apply weld-through primer to adhere the matching part.

ROOF PANEL (ASSY)**REMOVAL**

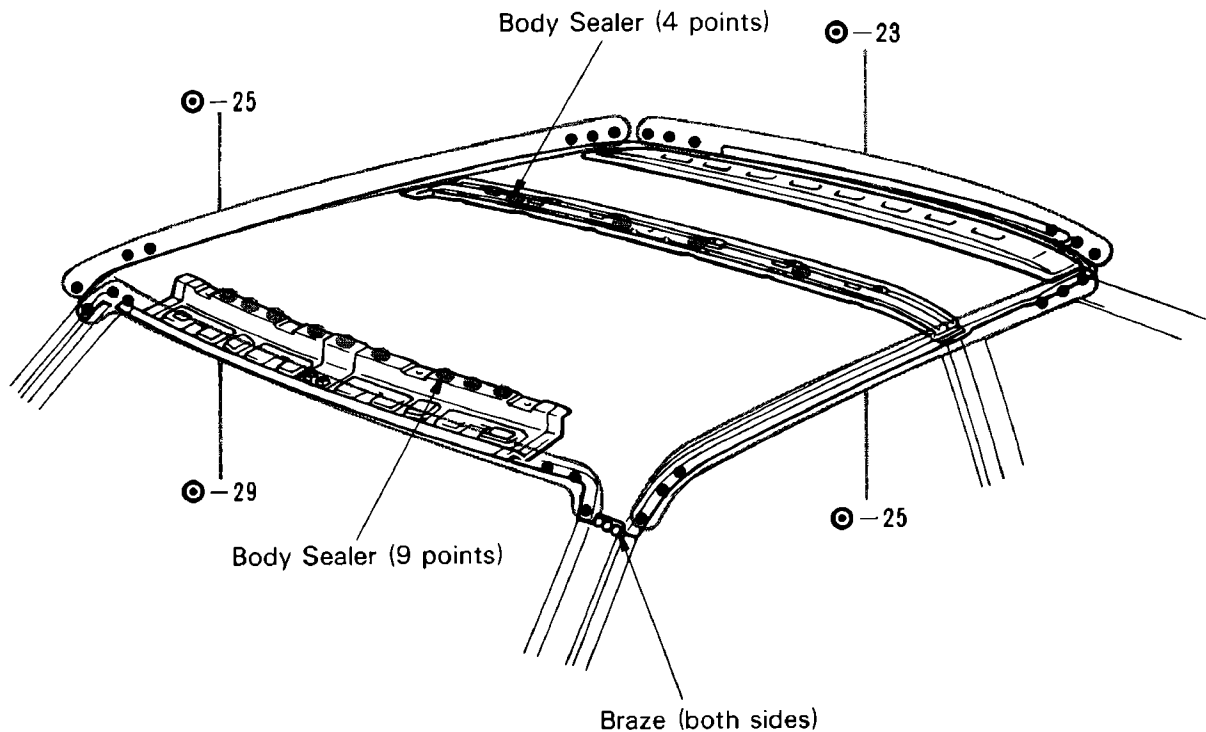
Liftback



1. Heat the brazed area of the front pillar and scrape off the brazing with a wire brush.

NOTE: Be careful not to overheat the pillar.

INSTALLATION



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

NOTE:

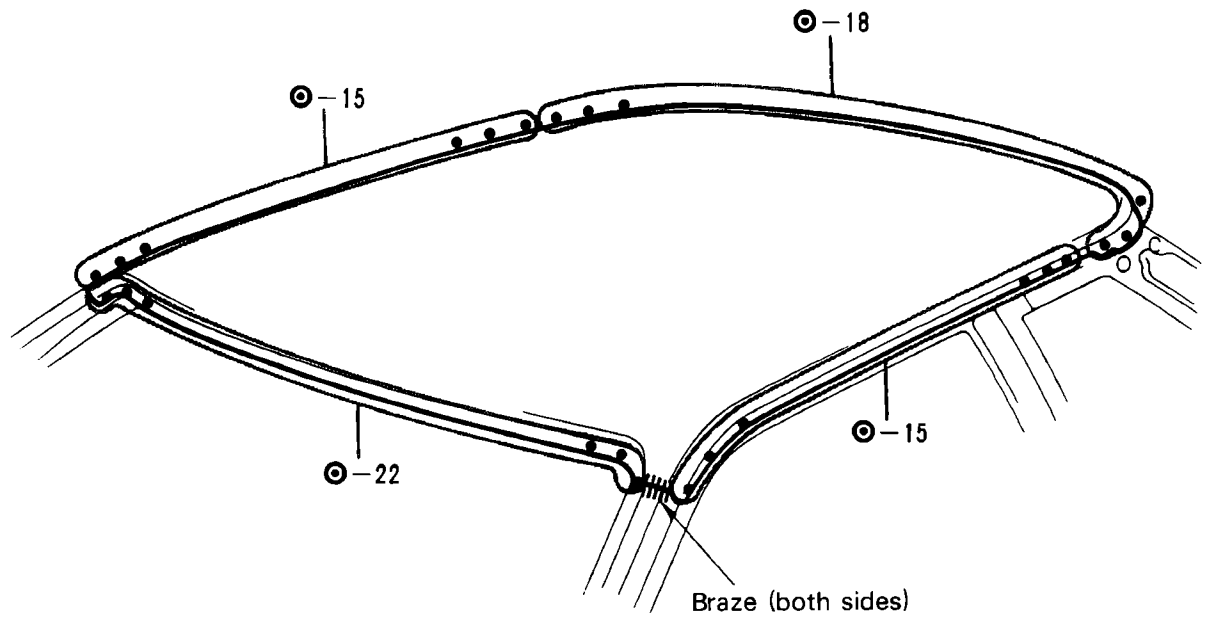
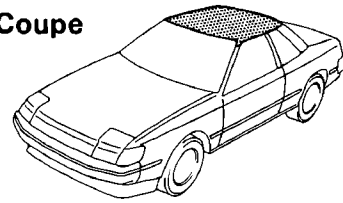
- 1) Apply just enough sealer for the new part to make contact.
- 2) For other sealing points, refer to section SU.

2. Braze the front body pillar connection.

NOTE: Before performing these operations, place a wet rag on the roof panel to protect it from damage.

ROOF PANEL (ASSY)**REMOVAL**

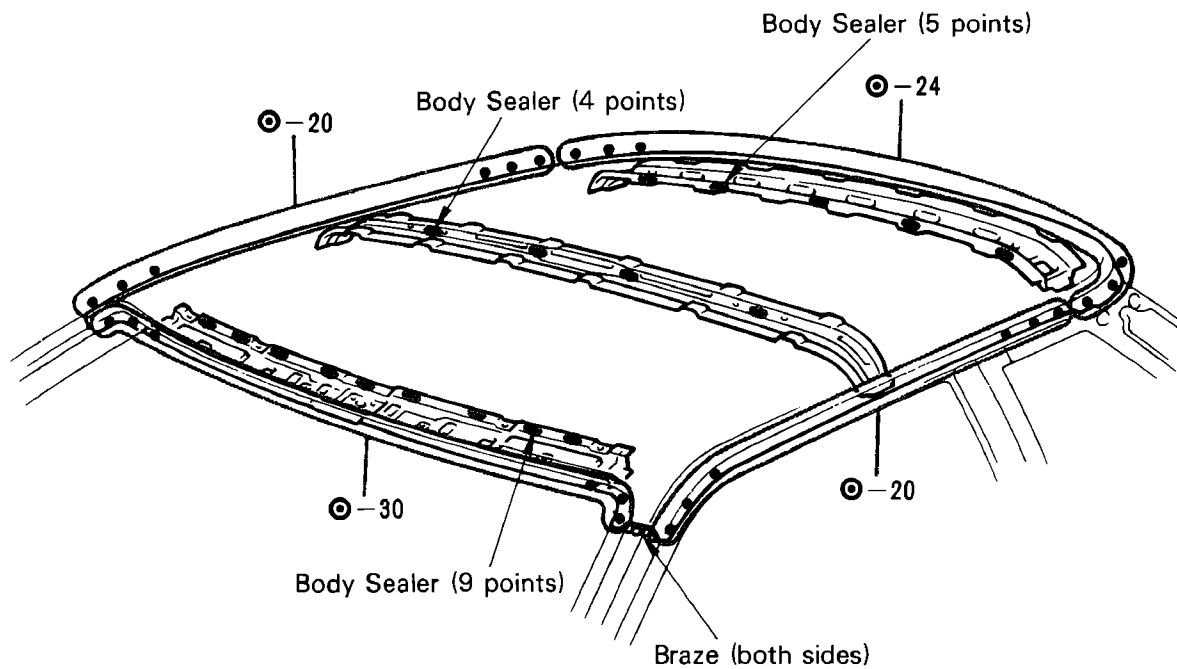
Coupe



1. Heat the brazed area of the front pillar and scrape off the brazing with a wire brush.

NOTE: Be careful not to overheat the pillar.

INSTALLATION



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

NOTE:

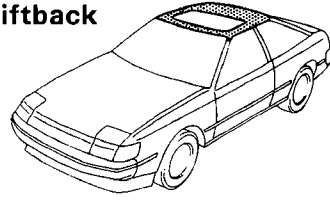
- 1) Apply just enough sealer for the new part to make contact.
- 2) For other sealing points, refer to section SU.

2. Braze the front body pillar connection.

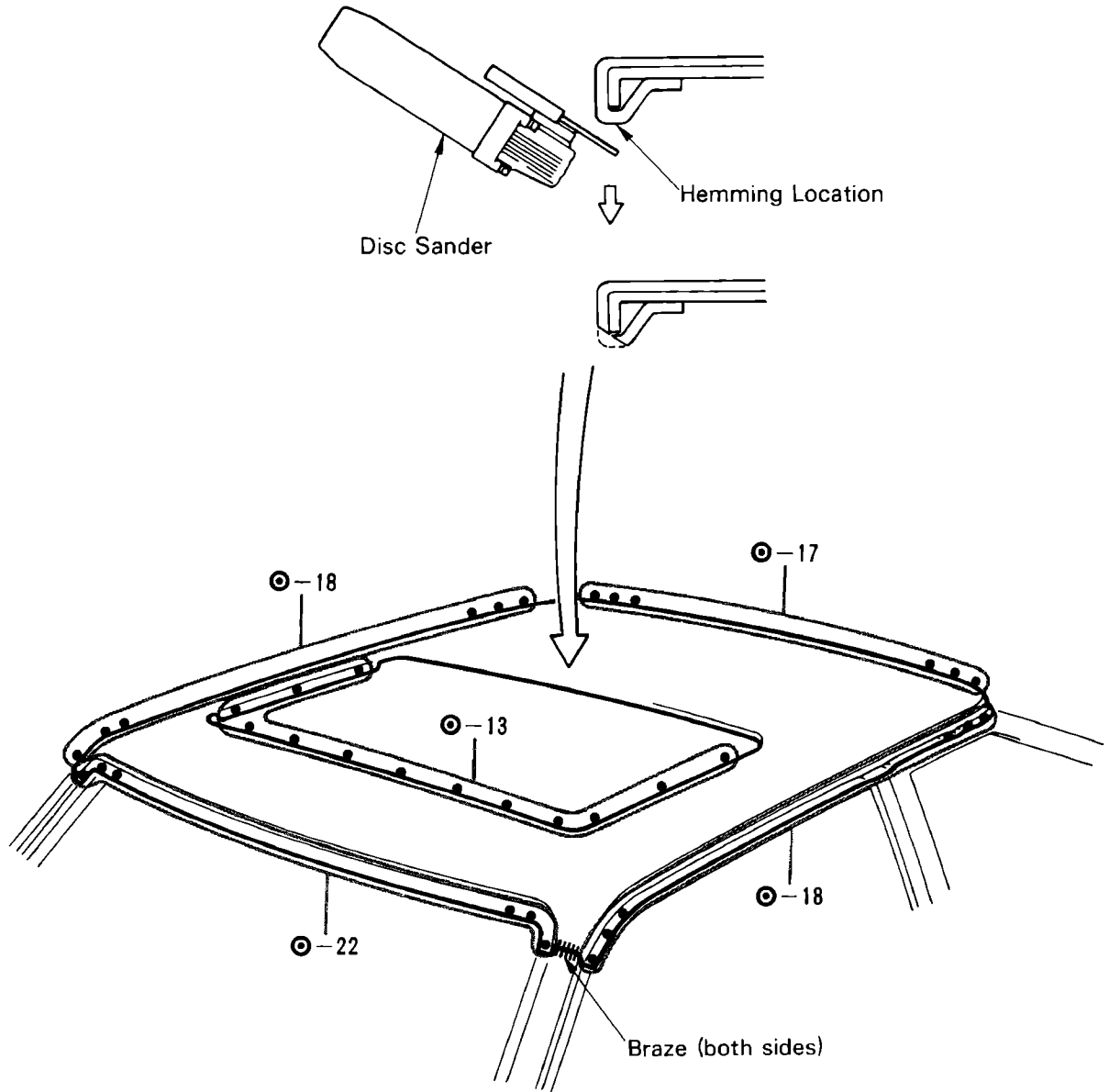
NOTE: Before performing these operations, place a wet rag on the roof panel to protect it from damage.

ROOF PANEL w/ SUN ROOF (ASSY)**REMOVAL**

Liftback

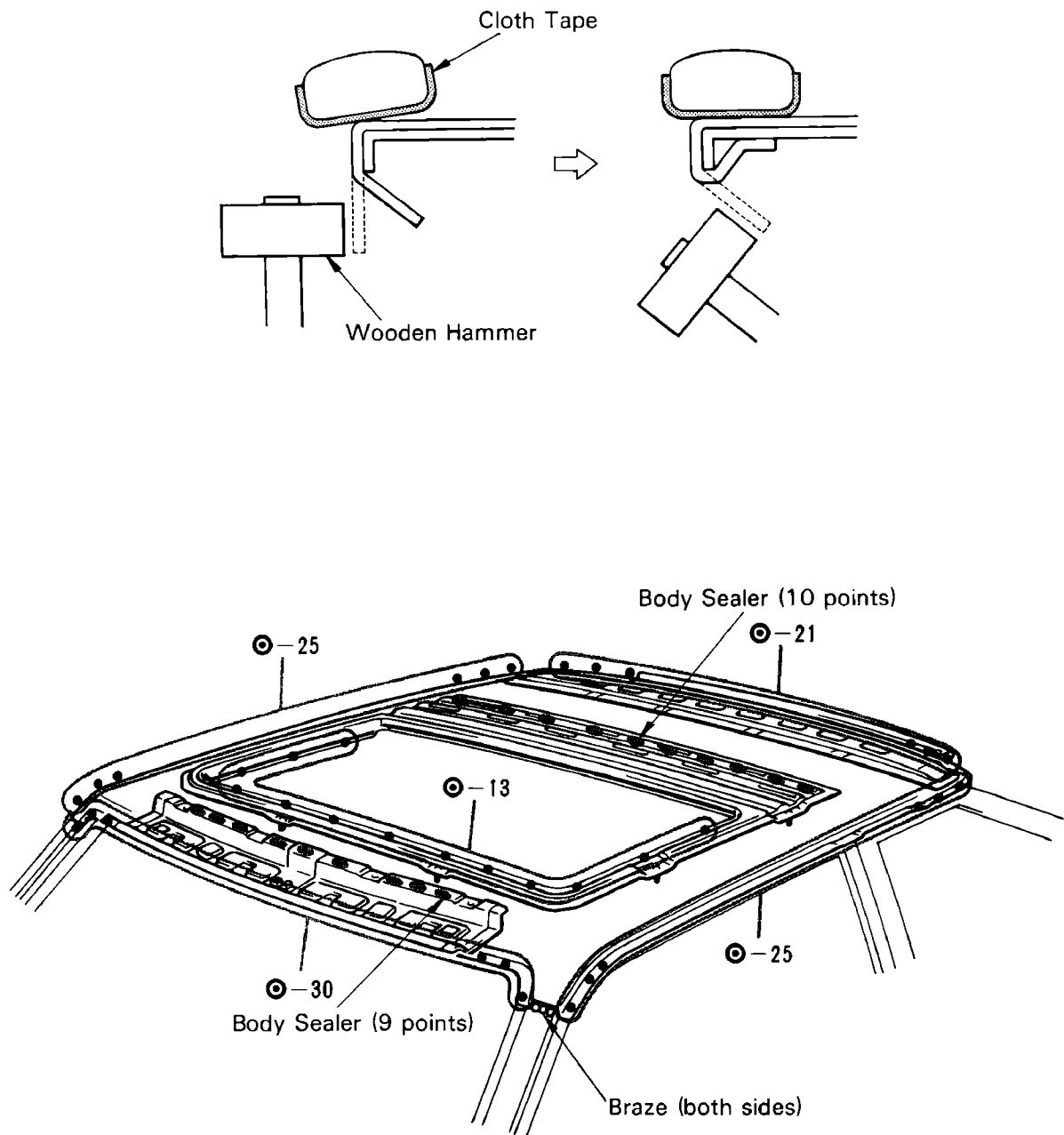


[If reusing the roof panel reinforcement No. 2]



1. If reusing the roof panel reinforcement No. 2 slightly heating the roof panel first will soften the sealer and make removal easier.

INSTALLATION



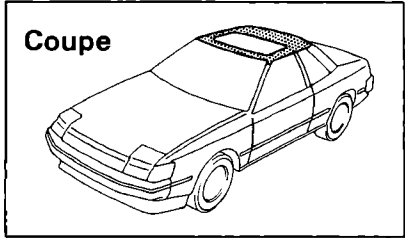
1. Before temporarily installing the new part, apply body sealer to the windshield header panel, roof panel center reinforcement and back window opening frame.
2. Hem the area rear tip of the sliding roof opening with a wooden hammer and dolly.

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

NOTE:

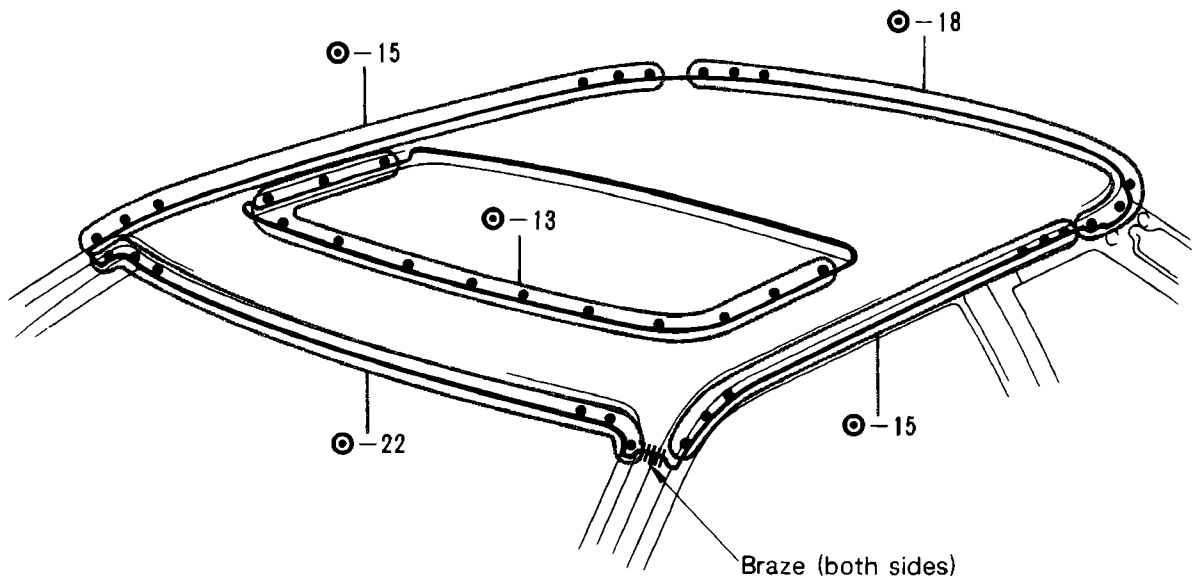
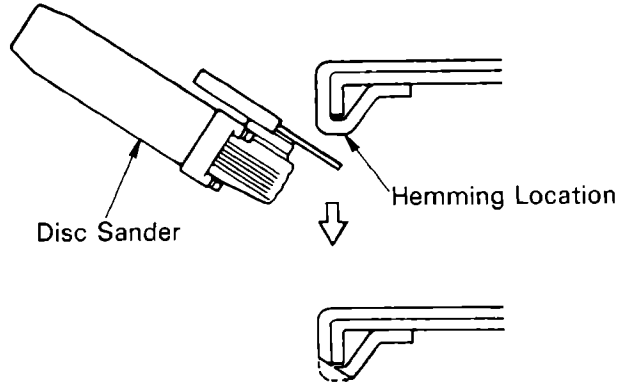
- 1) Apply just enough sealer for the new part to make contact.
- 2) For other sealing points, refer to section SU.

ROOF PANEL w/ SUN ROOF (ASSY)



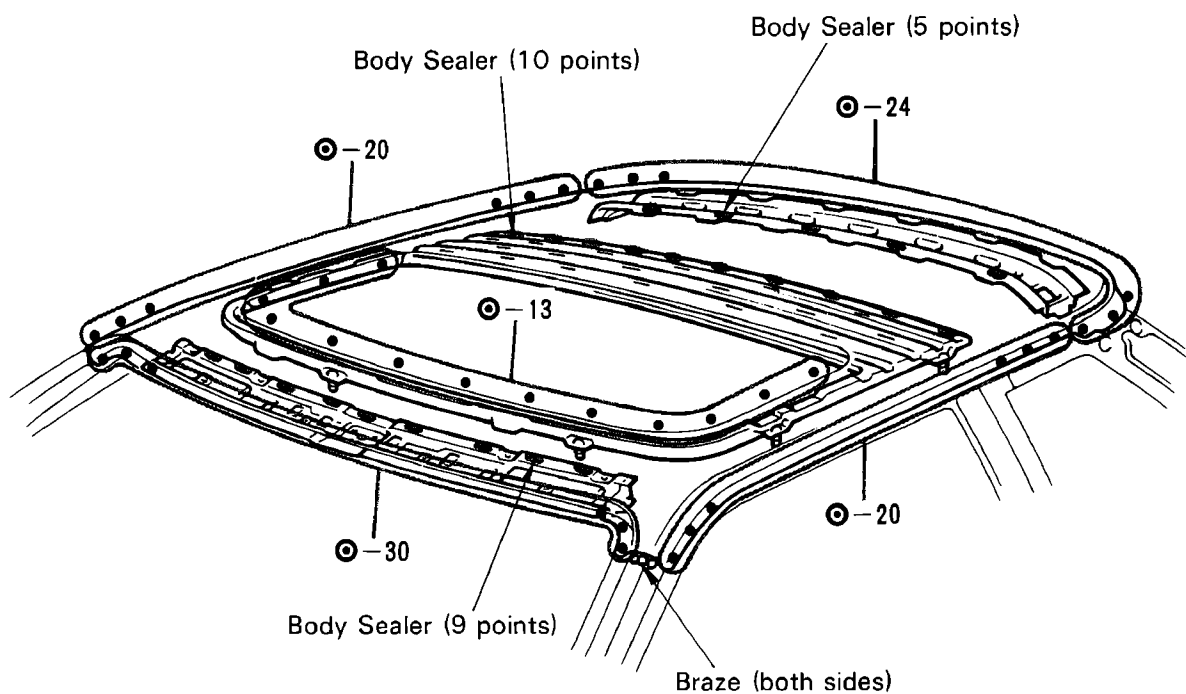
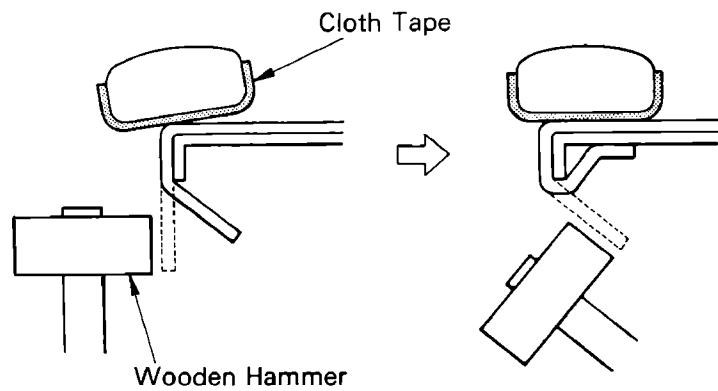
REMOVAL

[If reusing the roof panel reinforcement No. 2]



1. If reusing the roof panel reinforcement No. 2 slightly heating the roof panel first will soften the sealer and make removal easier.

INSTALLATION



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

2. Hem the area rear tip of the sliding roof opening with a wooden hammer and dolly.

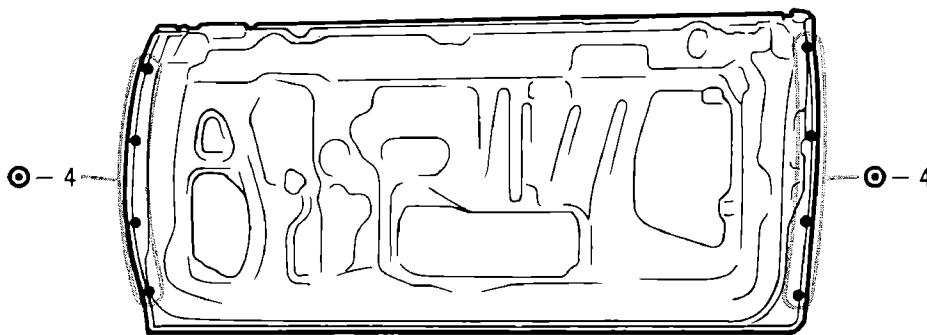
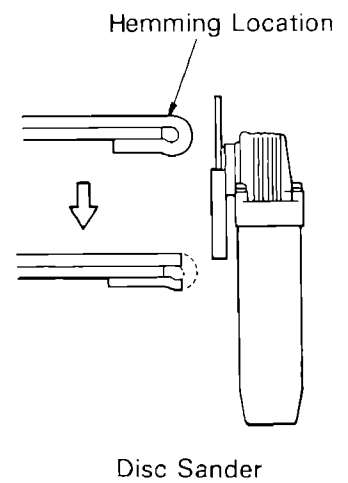
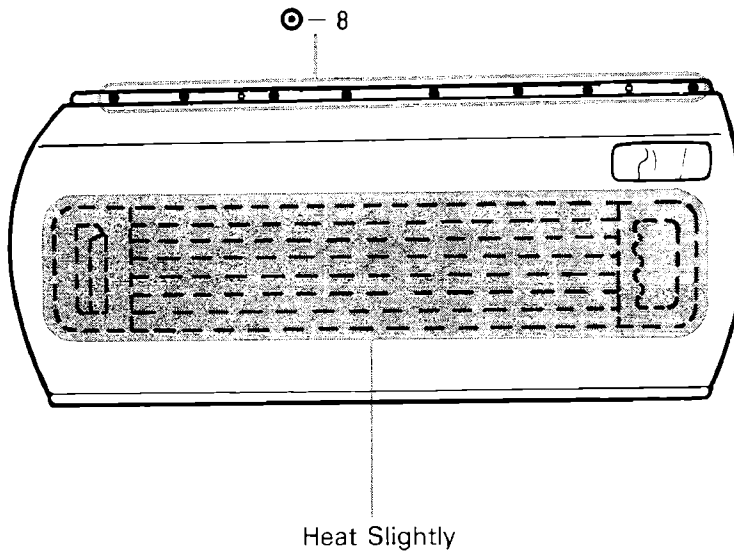
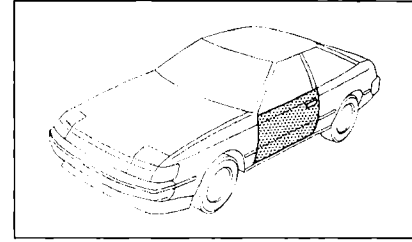
NOTE: Perform hemming in three steps, being careful not to warp the panel.

NOTE:

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

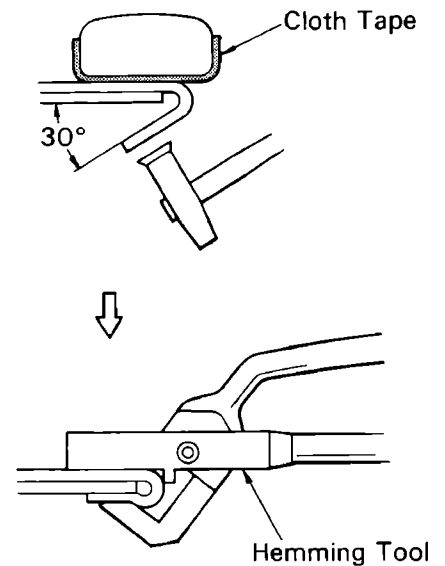
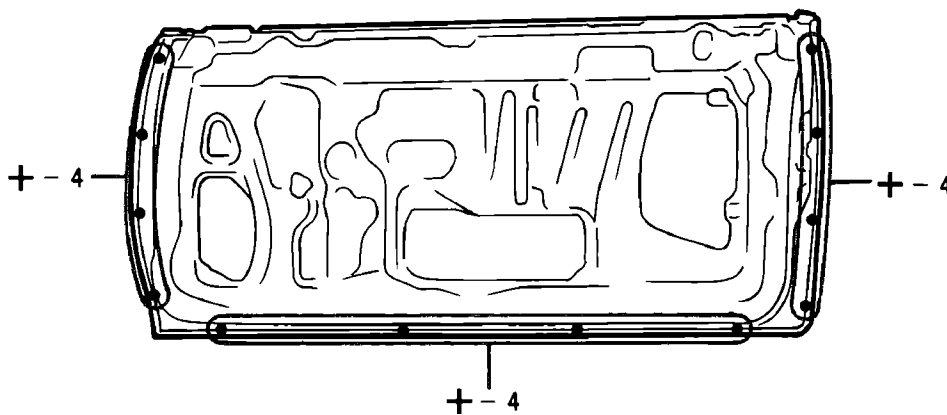
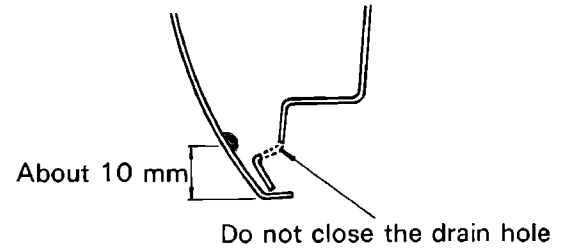
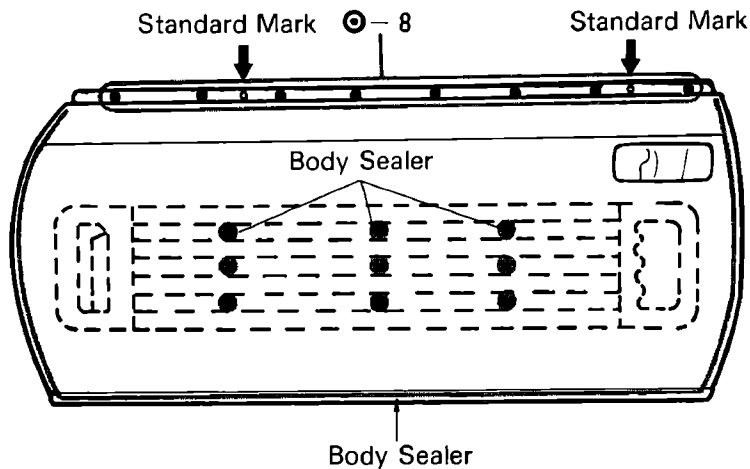
FRONT DOOR OUTER PANEL (ASSY)

REMOVAL



1. Grind out the hemming location, and remove the outer panel.
2. Slightly heating the outer panel will soften the sealer and make removal easier. (USA, Canada and Saudi Arabia)

INSTALLATION



mm	in.
10	0.39

1. Before temporarily installing the new part, coat the back side of the new panel with body sealer.

NOTE:

- 1) Coat evenly about 10 mm (0.39 in.) from the flange and 3 mm (0.12 in.) in diameter.
 - 2) For other sealing points, refer to section SU.
2. Determine the position for the new panel by the assembly marks.

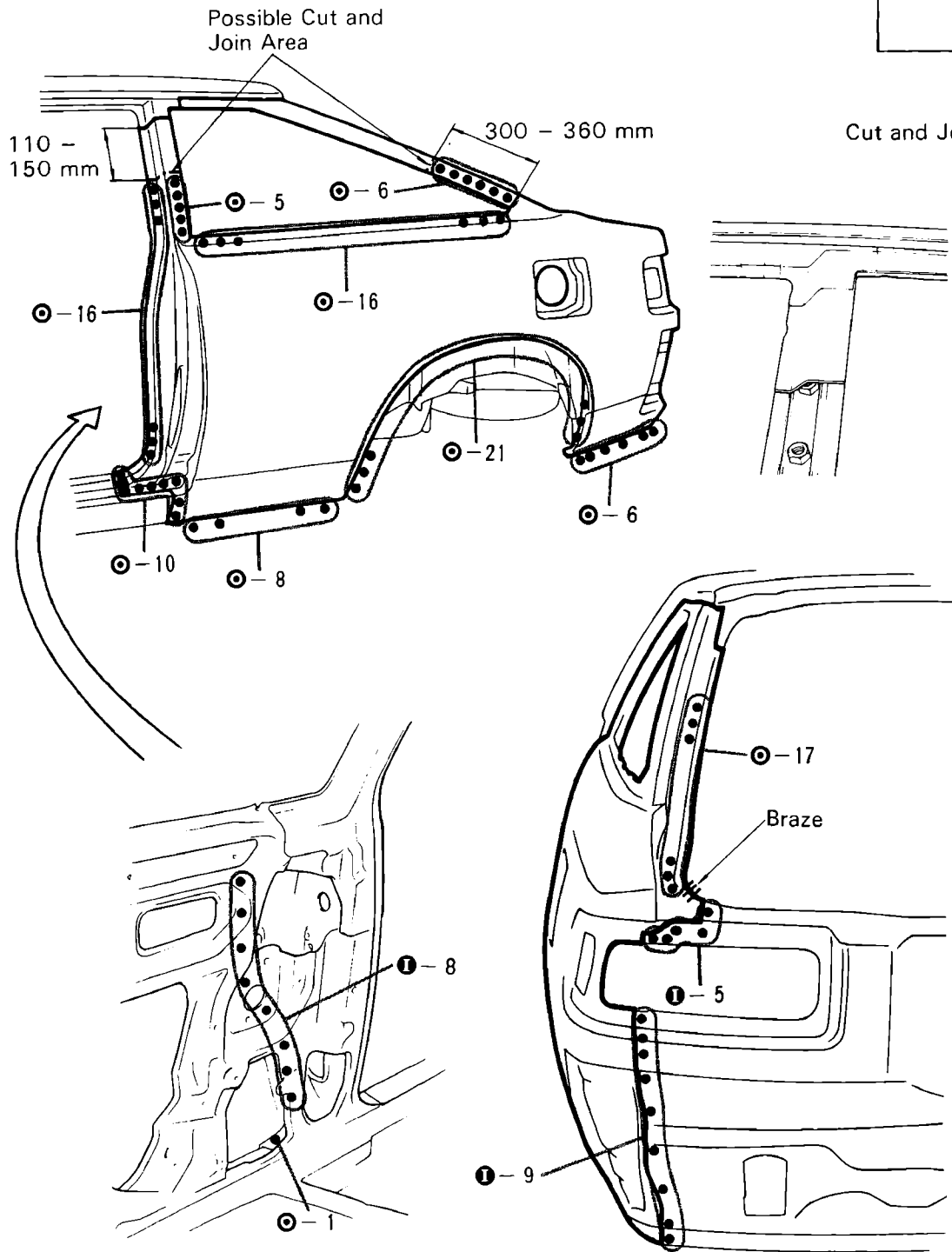
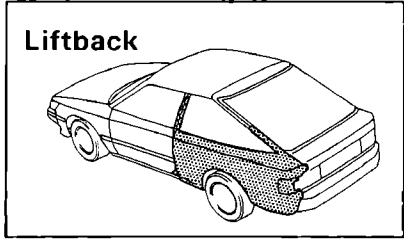
3. Bend the flange hem approx. 30° with a hammer and dolly. Then use a hemming tool.

NOTE:

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

QUARTER PANEL (CUT)

REMOVAL

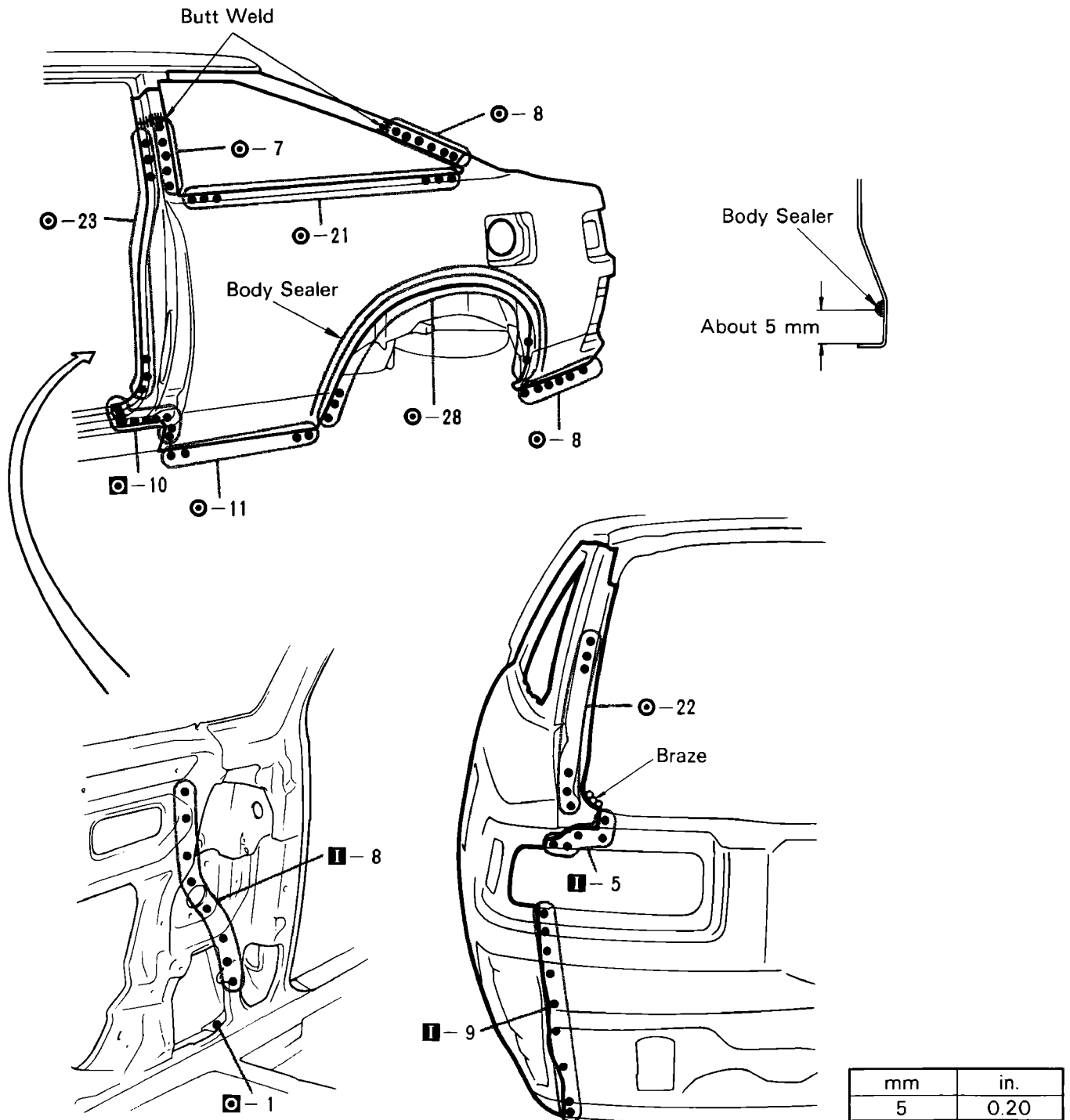


mm	in.
110	4.33
150	5.91
300	11.81
360	14.17

1. Cut and join the quarter panel as shown above.

NOTE: For vehicles with a sun roof, remove the drain hose after cutting the quarter panel.

INSTALLATION



1. Before temporarily installing the new part, apply body sealer to the wheel arch portion.
2. Temporarily installing the new part and check the fit of the front door, back door and rear combination lamp.

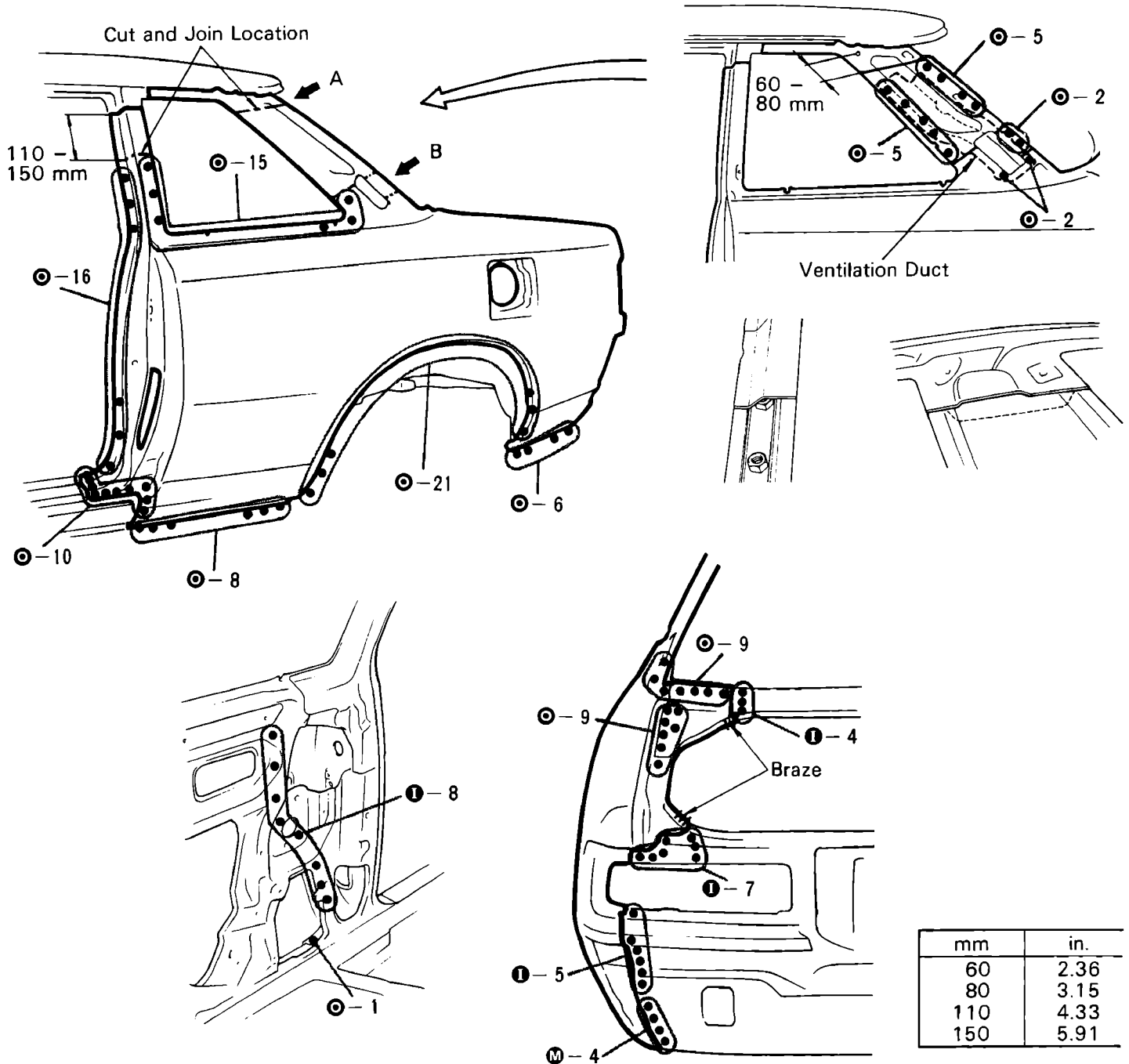
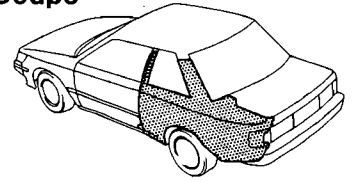
NOTE:

- 1) Apply sealer approx. 5 mm (0.20 in.) from the flange, avoiding any oozing.
- 2) Apply evenly, approx. 3 - 4 mm (0.12 - 0.16 in.) in diameter.
- 3) For other sealing points, refer to section SU.

QUARTER PANEL (CUT)

REMOVAL

Coupe



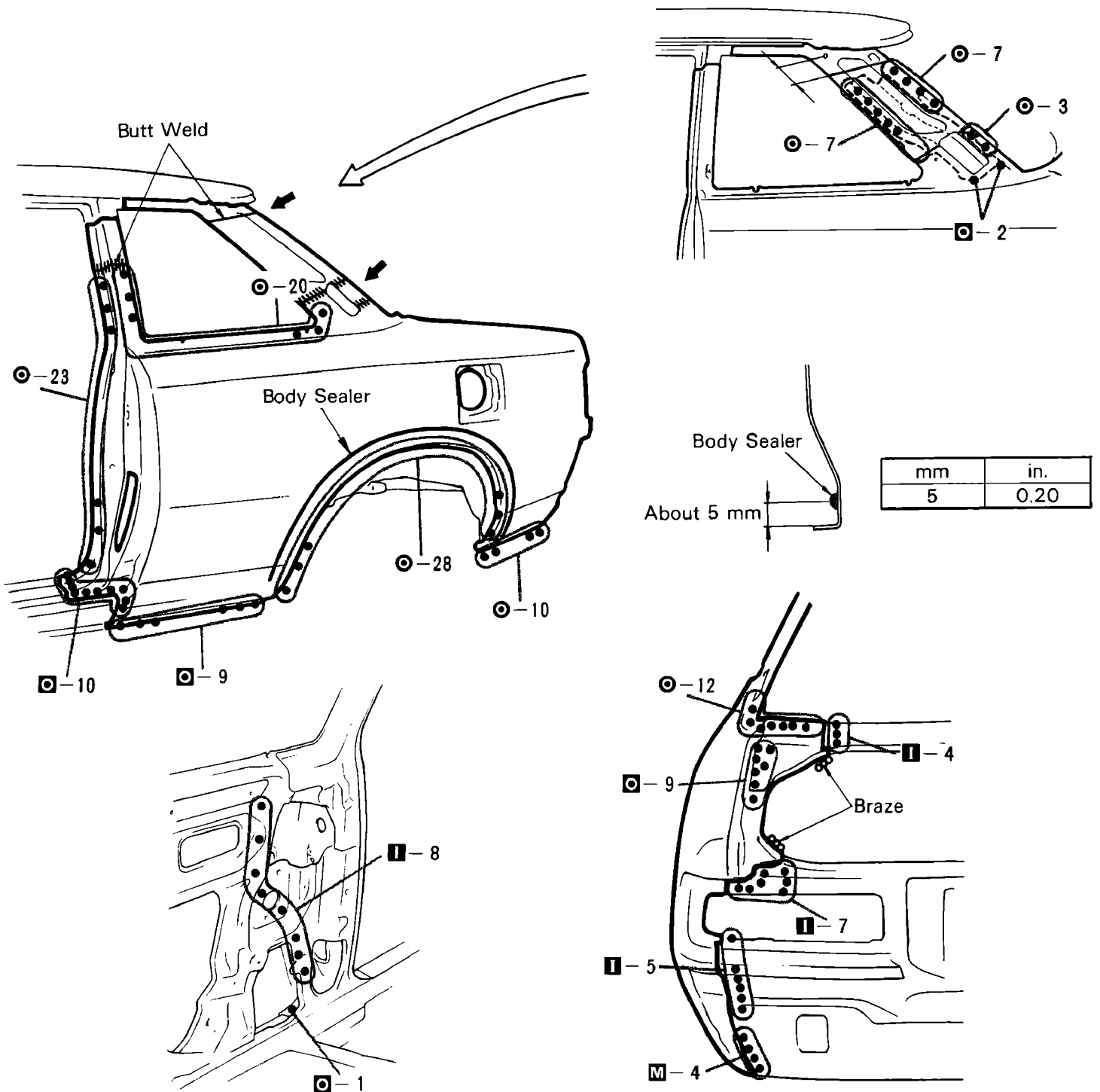
mm	in.
60	2.36
80	3.15
110	4.33
150	5.91

1. Cut and join the quarter panel as shown above.

NOTE:

- 1) When cutting the quarter pillar at portion B, do not cut away the ventilation duct.
- 2) For vehicles with a sun roof, remove the drain hose after cutting the quarter panel.

INSTALLATION



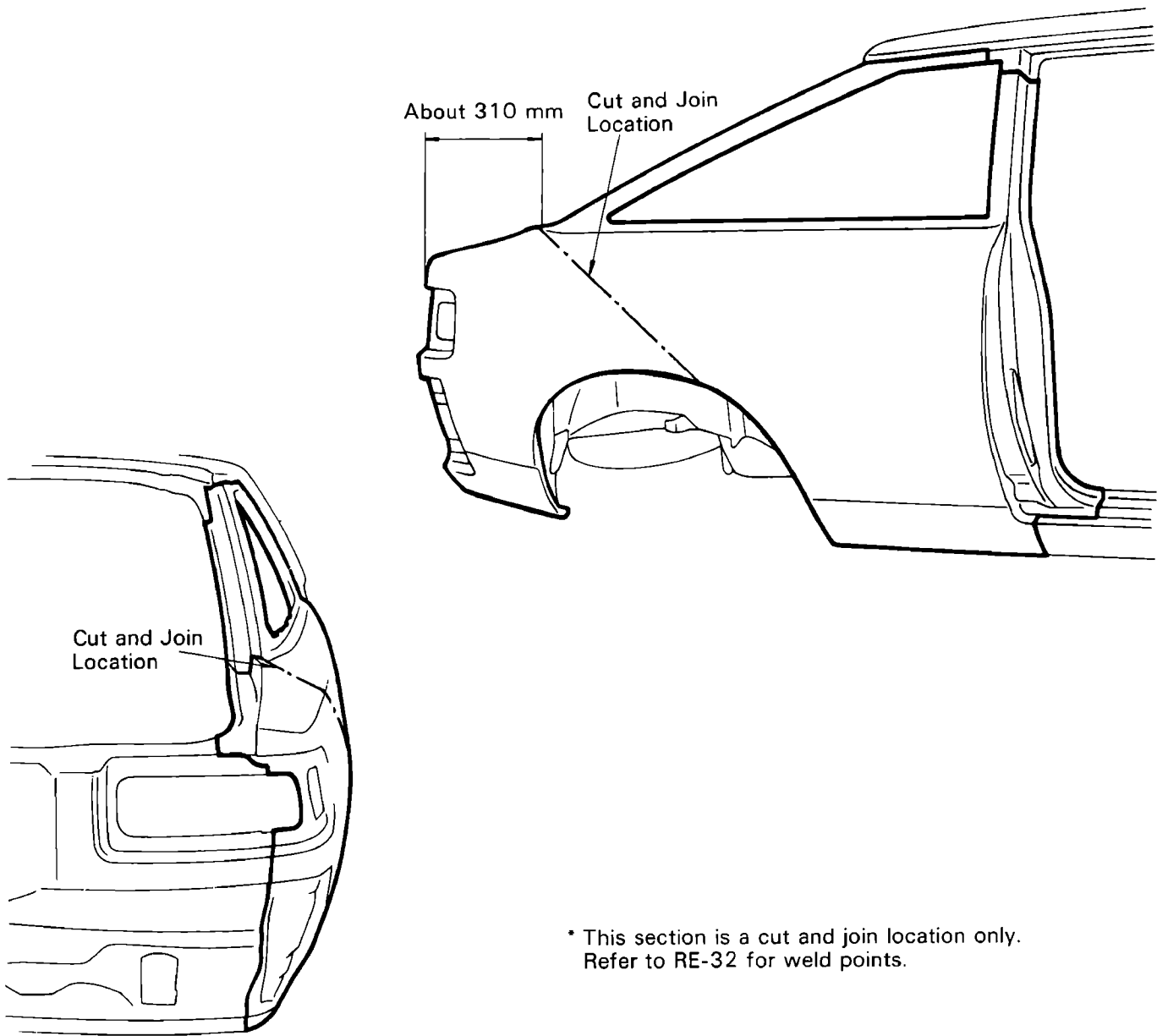
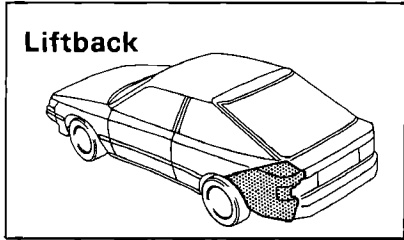
1. Before temporarily installing the new part, apply body sealer to the wheel arch portion.
2. Temporarily installing the new part and check the fit of the front door, luggage compartment door and rear combination lamp.

NOTE:

- 1) Apply sealer approx. 5 mm (0.20 in.) from the flange, avoiding any oozing.
- 2) Apply evenly, approx. 3 – 4 mm (0.12 – 0.16 in.) in diameter.
- 3) For other sealing points, refer to section SU.

QUARTER PANEL (CUT-P)

REMOVAL

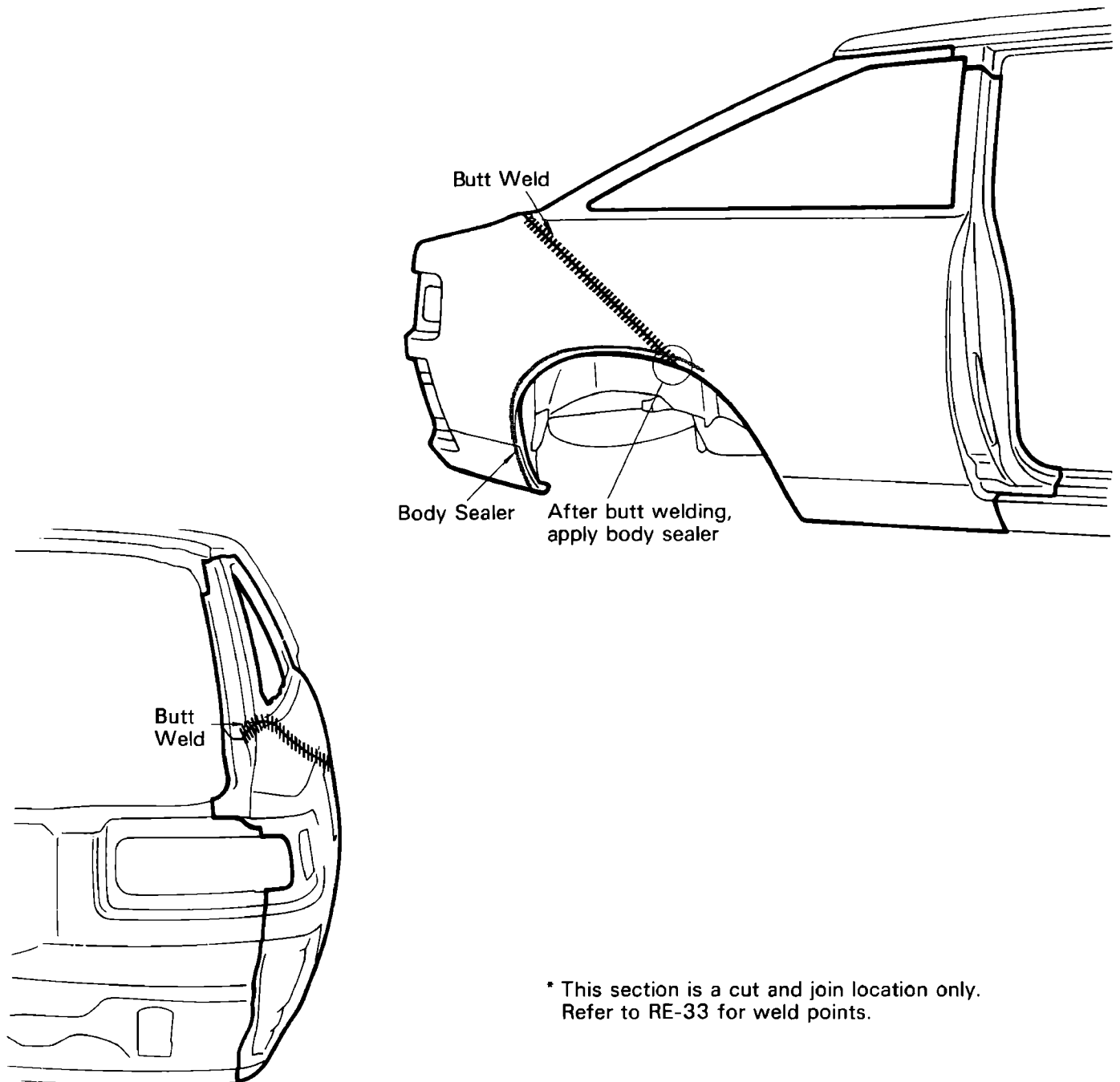


* This section is a cut and join location only. Refer to RE-32 for weld points.

mm	in.
310	12.20

1. Cut on the line shown above.

INSTALLATION



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

1. Before cutting the overlap areas, check the fit for the back door and rear combination lamp.
2. Before welding, apply body sealer from inside of the vehicle.
- 2) For other sealing points, refer to section SU.
3. Surface finish the weld seams from the inside also.

NOTE:

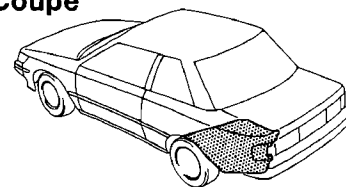
- 1) Do not apply body sealer to the weld seams before welding as the sealer will melt, resulting in a bad seal and a bad weld.

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

QUARTER PANEL (CUT-P)

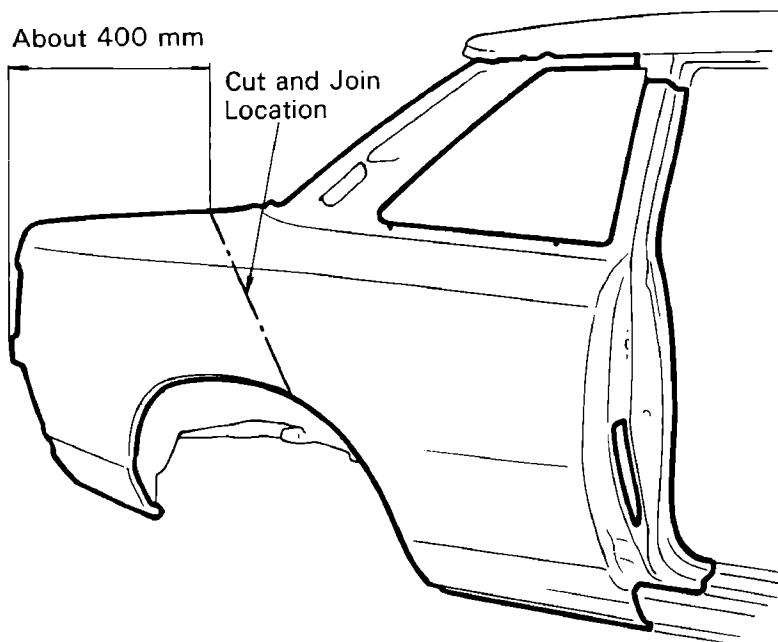
REMOVAL

Coupe

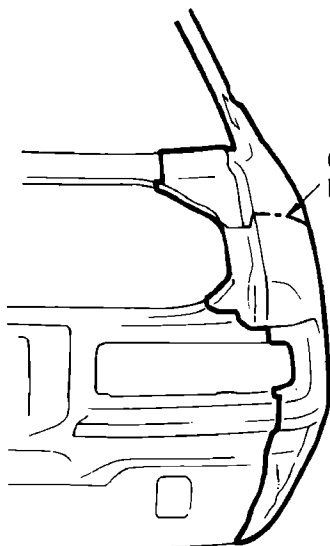


About 400 mm

Cut and Join Location



Cut and Join Location

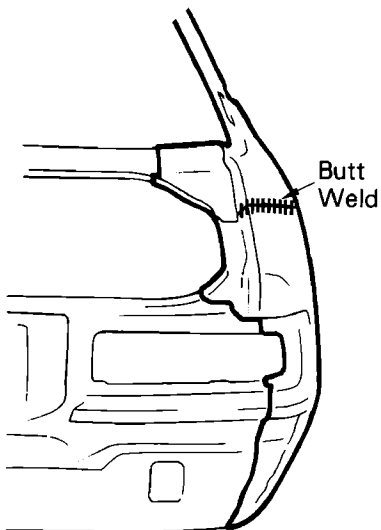
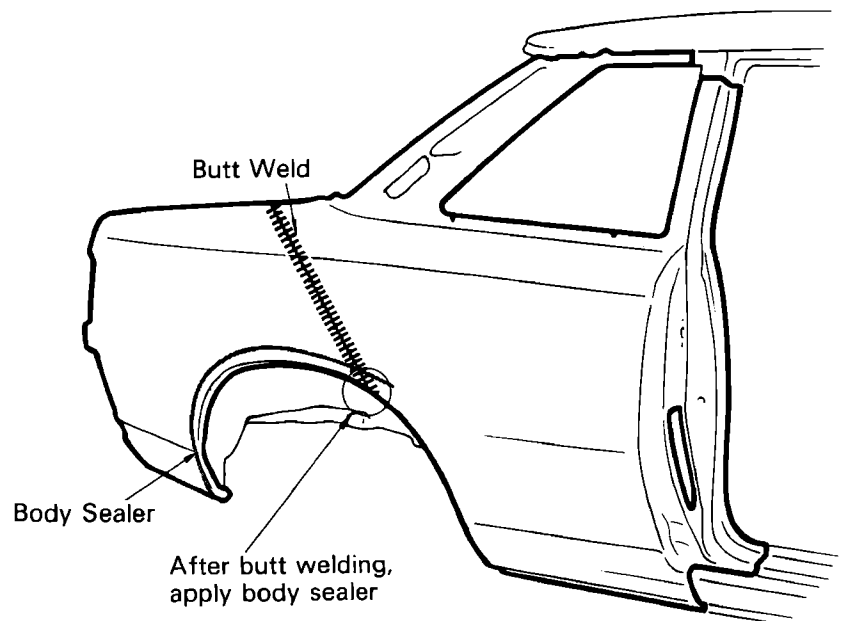


* This section is a cut and join location only.
Refer to RE-34 for weld points.

mm	in.
400	15.75

1. Cut on the line shown above.

INSTALLATION



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

1. Before cutting the overlap areas, check the fit for the luggage compartment door and rear combination lamp.
2. Before welding, apply body sealer from inside of the vehicle.
- 2) For other sealing points, refer to section SU.
3. Surface finish the weld seams from the inside also.

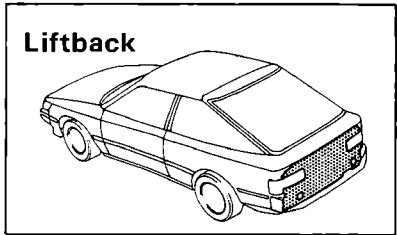
NOTE: Be careful not to grind off too much weld as it will result in loss of durability.

NOTE:

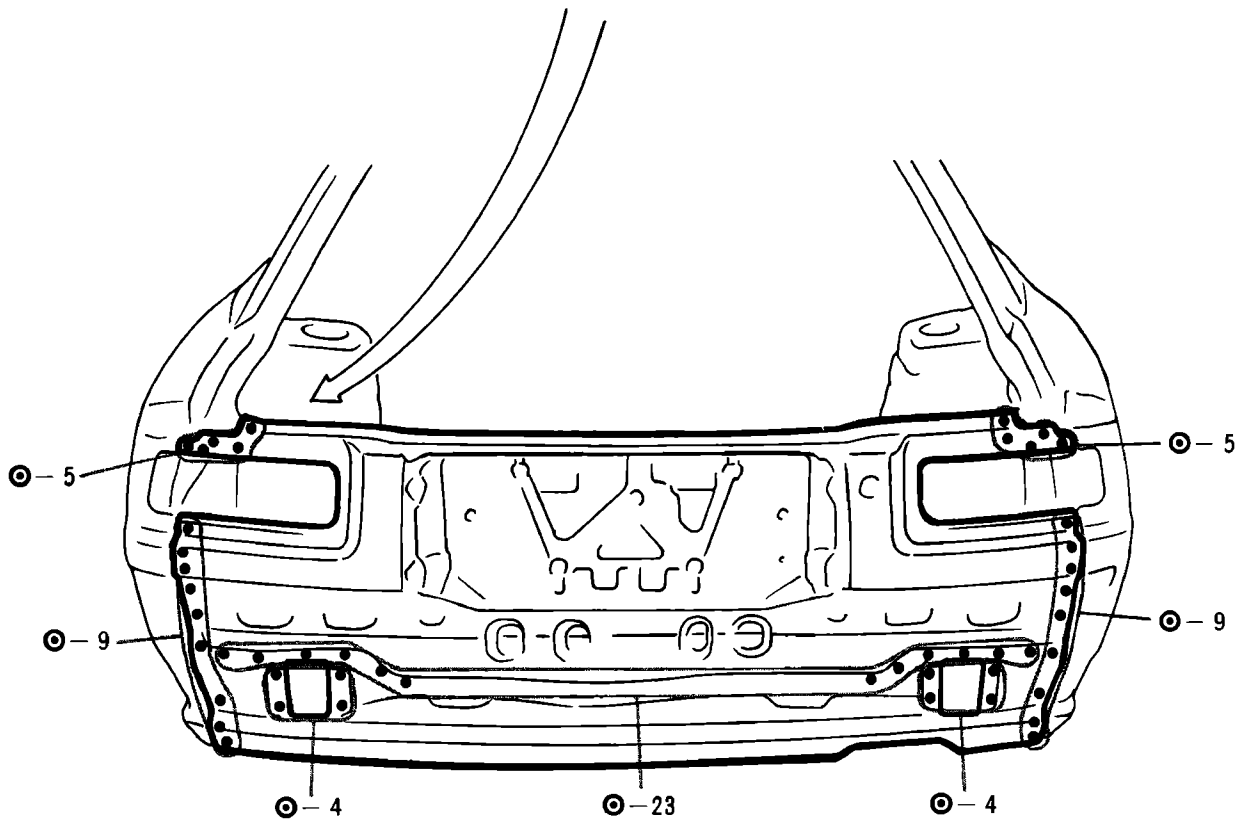
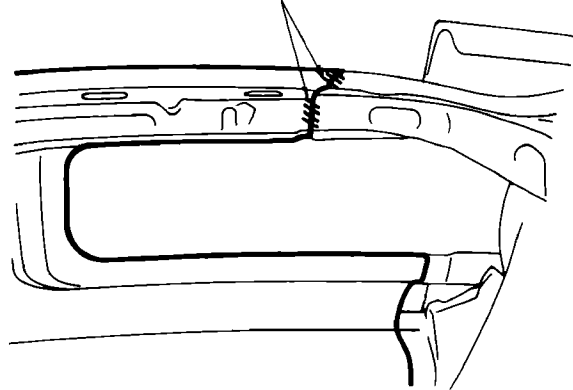
- 1) Do not apply body sealer to the weld seams before welding as the sealer will melt, resulting in a bad seal and a bad weld.

BODY LOWER BACK PANEL (ASSY)

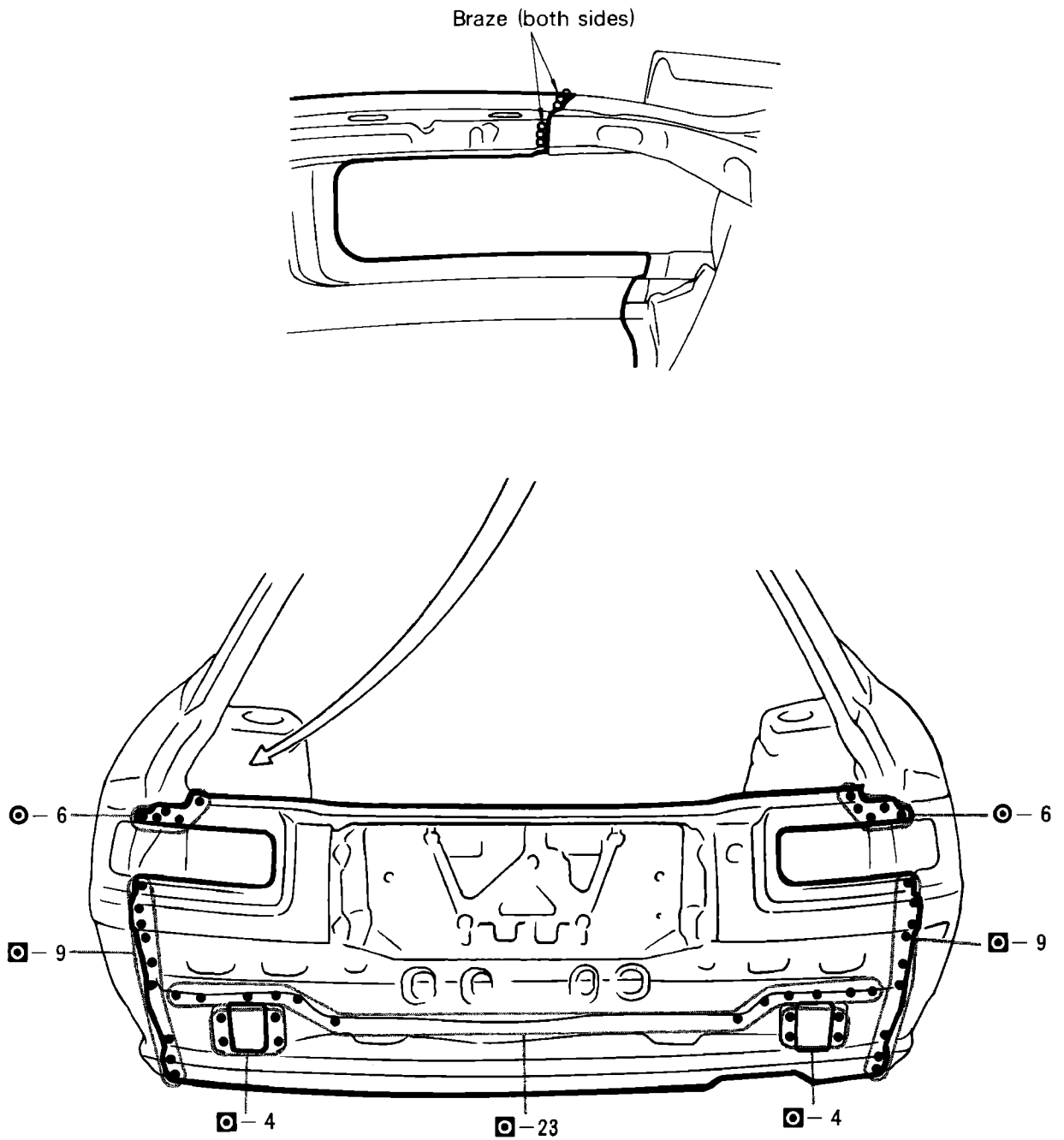
REMOVAL



Braze (both sides)



INSTALLATION

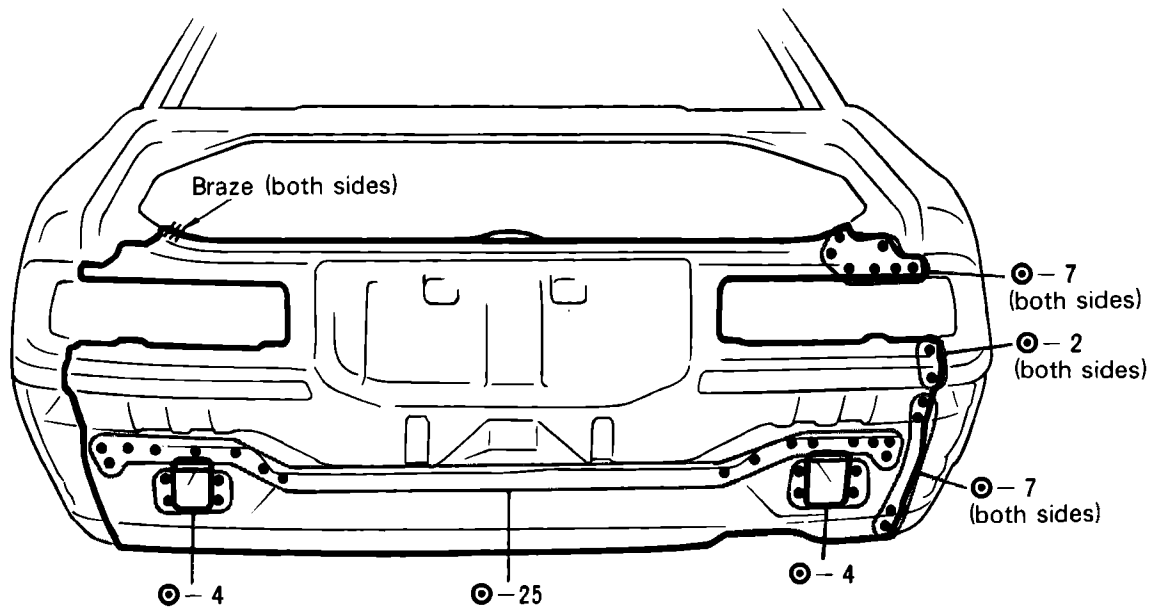
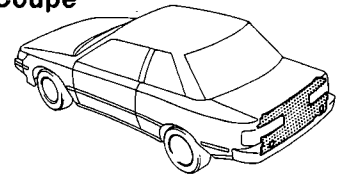


1. Temporarily install the new part and check the fit of the back door and rear combination lamp.

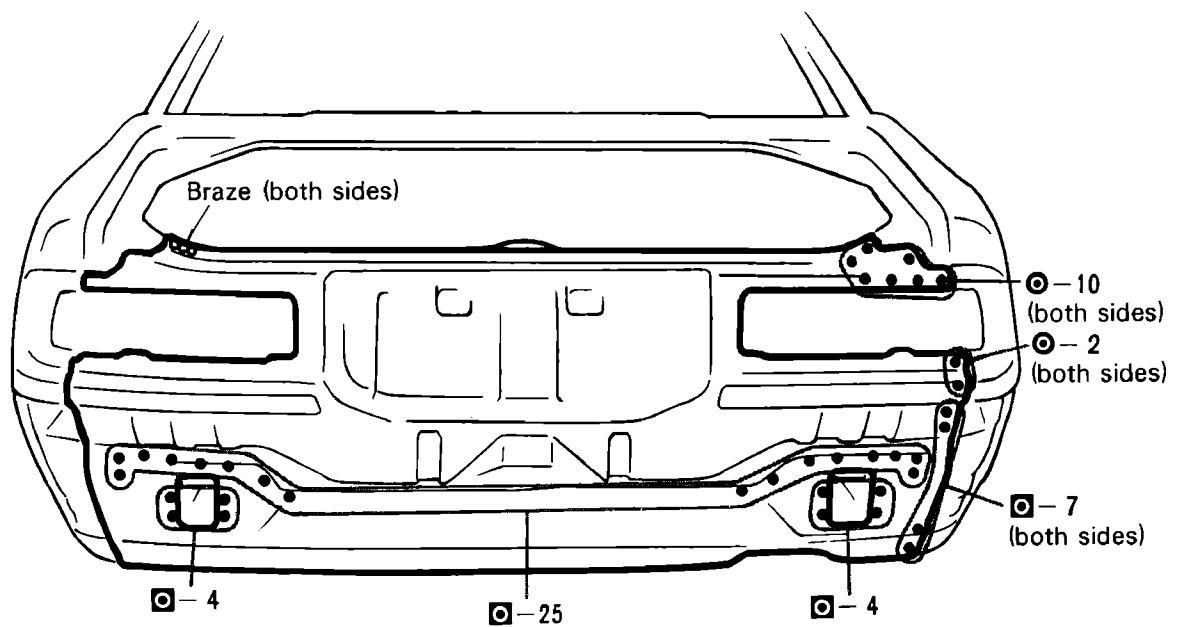
BODY LOWER BACK PANEL (ASSY)

REMOVAL

Coupe



INSTALLATION

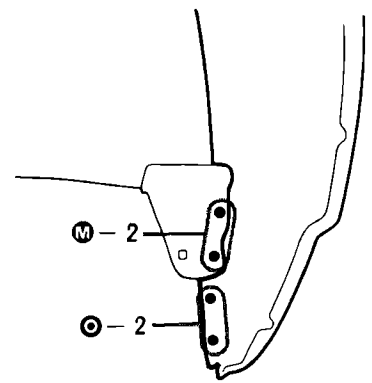
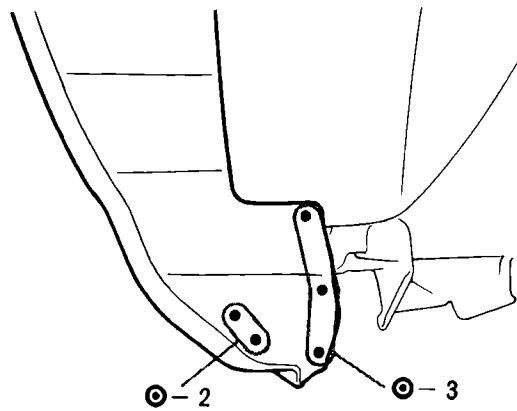
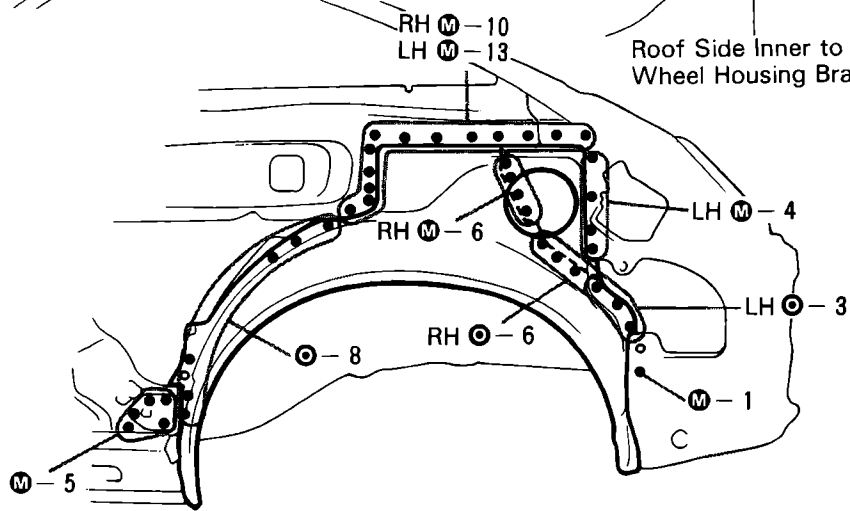
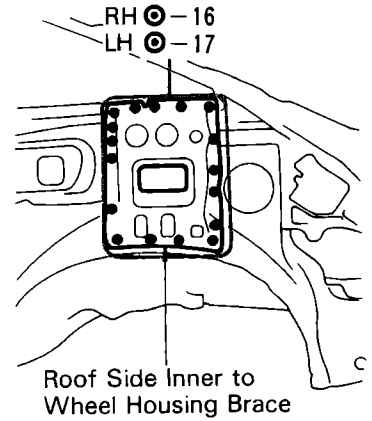
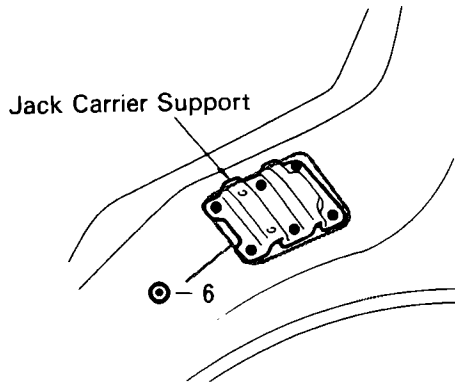
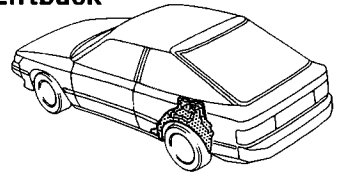


1. Temporarily install the new part and check the fit of the luggage compartment door and rear combination lamp.

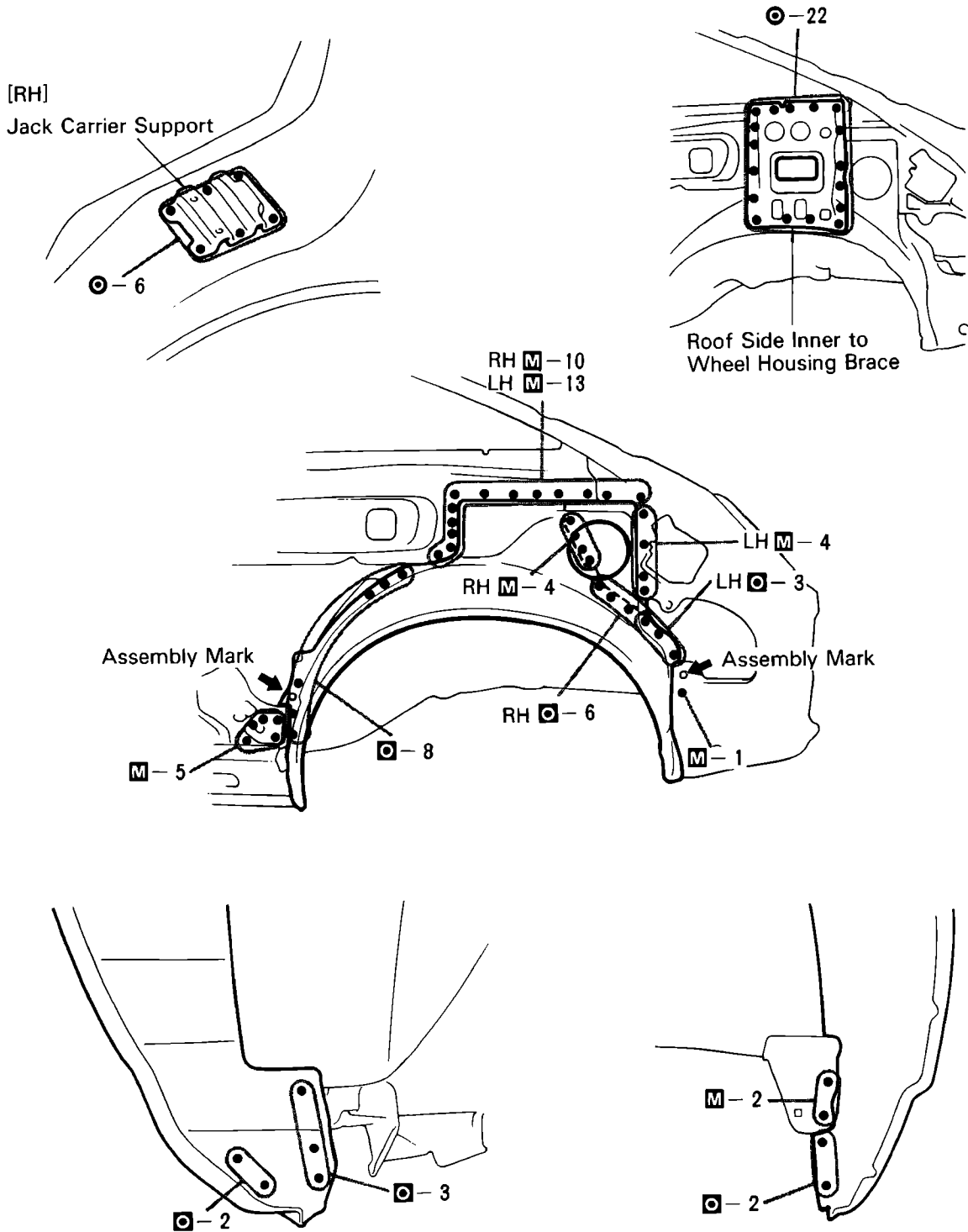
QUARTER WHEEL HOUSING OUTER PANEL (ASSY)

REMOVAL

Liftback



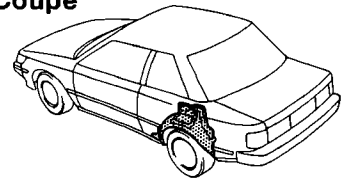
INSTALLATION



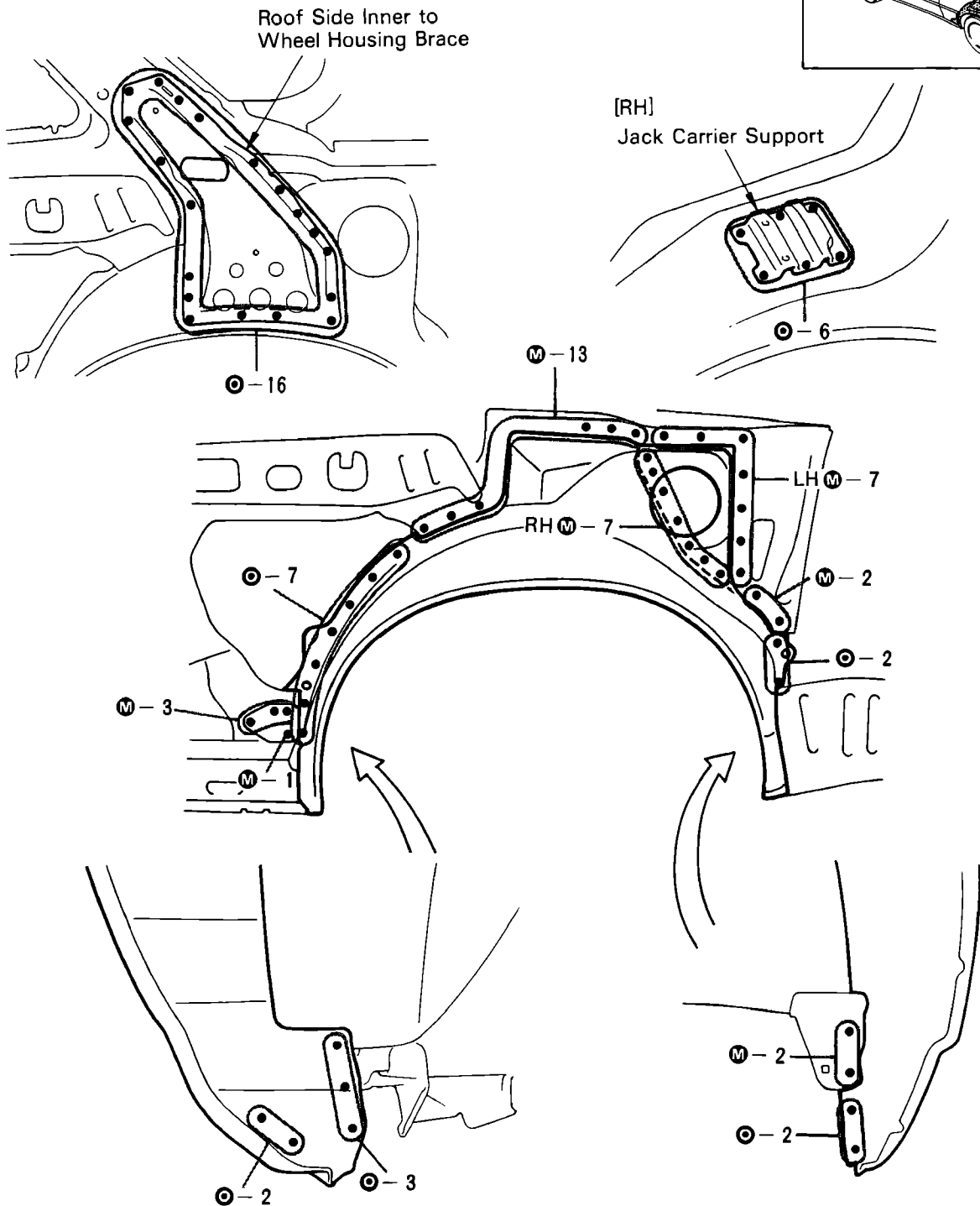
1. Determine the position of the new part by the assembly marks of the inner and outer panels.
2. Before welding the new part, temporarily install the quarter panel and check the fit.

QUARTER WHEEL HOUSING OUTER PANEL (ASSY)

Coupe

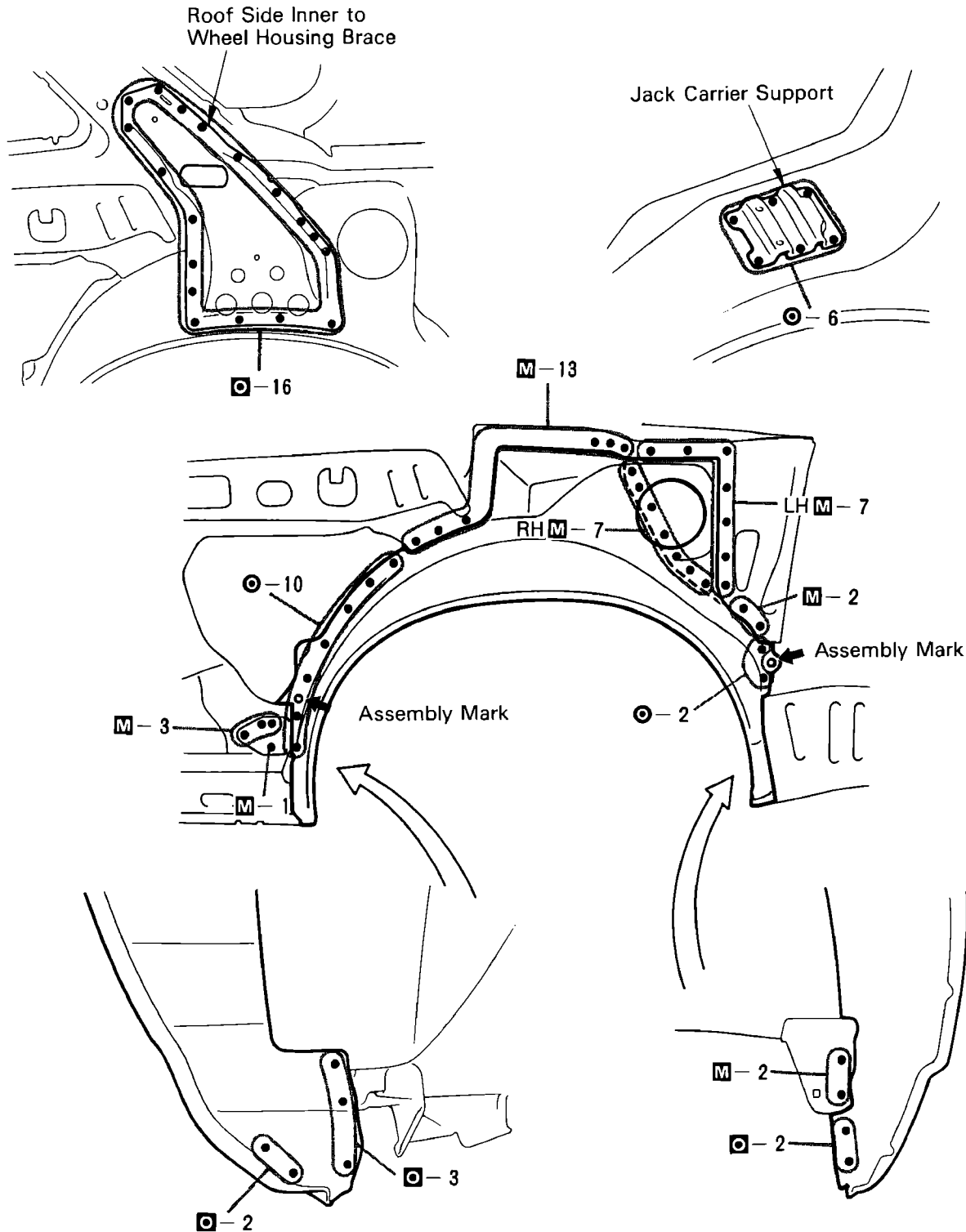


REMOVAL



1. Before removing the quarter wheel housing outer panel, remove the roof side inner to wheel housing brace.

INSTALLATION

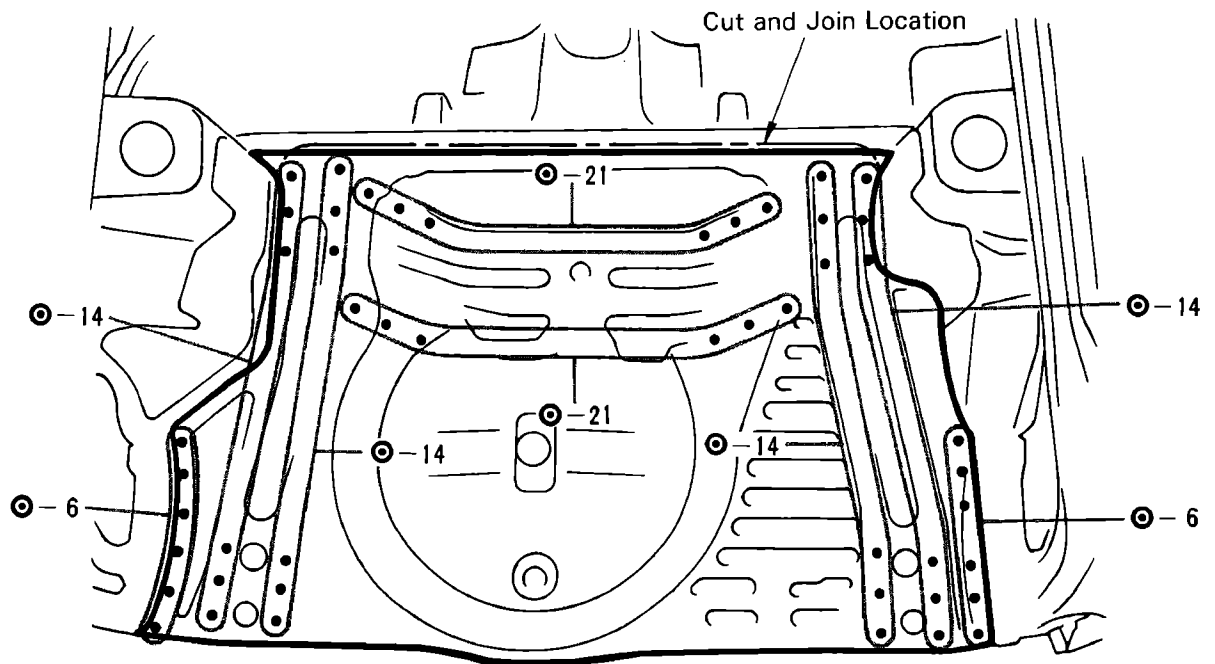
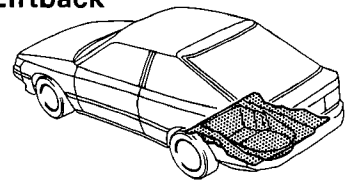


1. Determine the position of the new part by the assembly marks of the inner and outer panels.
2. Before welding the new part, temporarily install the quarter panel and check the fit.

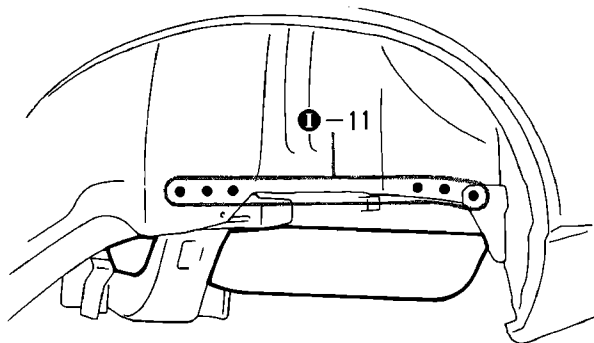
REAR FLOOR PAN (CUT)

REMOVAL

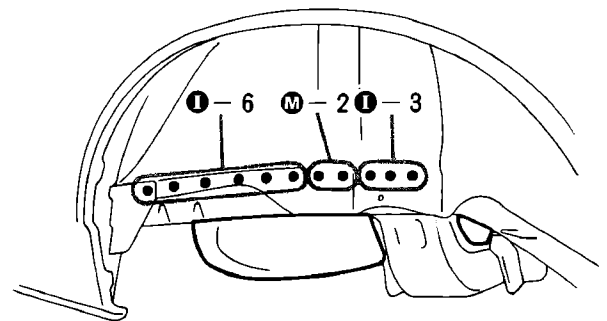
Liftback



[LH]

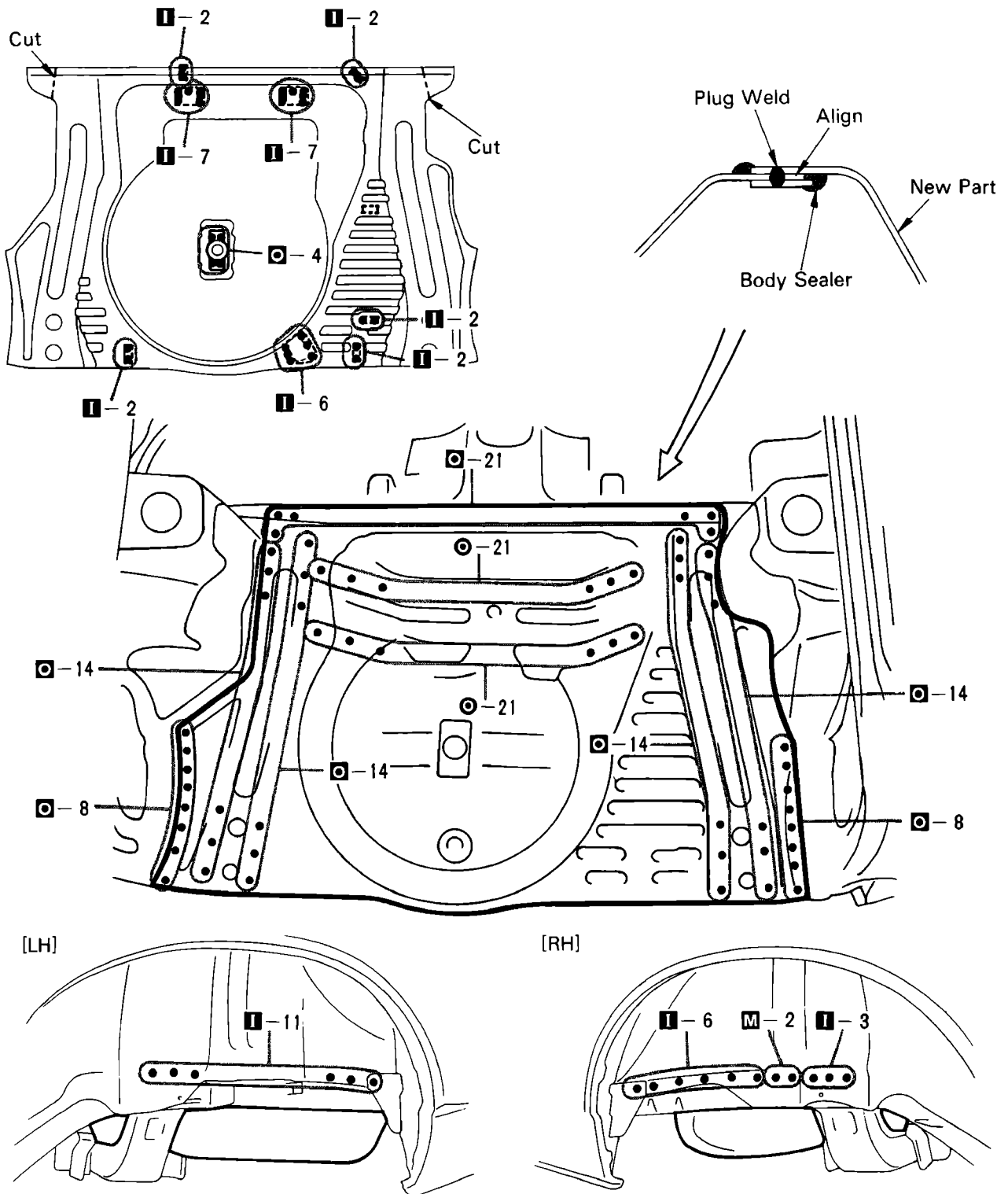


[RH]



1. Cut and join the rear floor pan shown above.
2. Avoid the rear floor side member and rear floor No. 2 crossmember when rough cutting the rear floor pan.

INSTALLATION



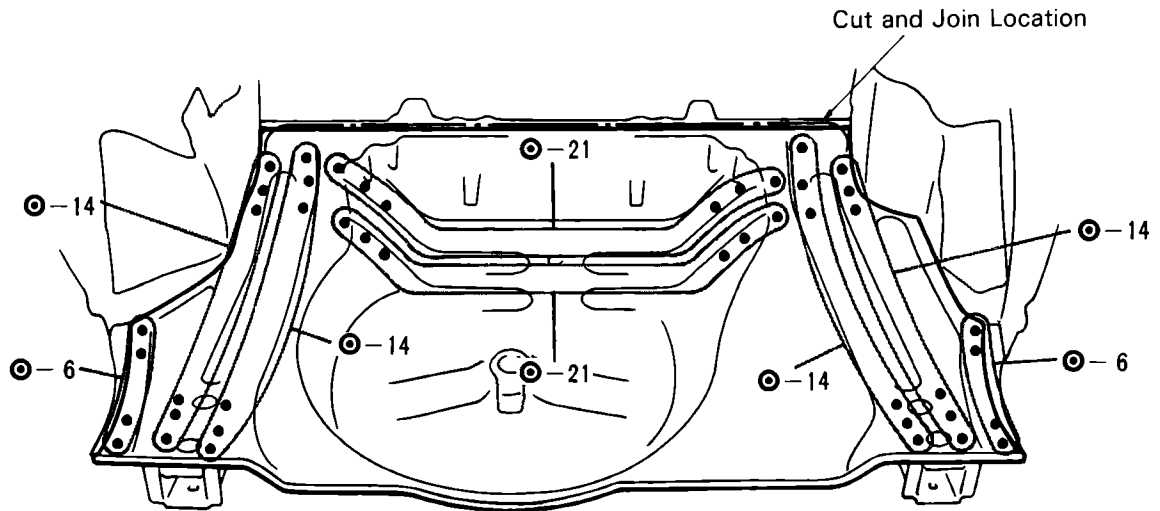
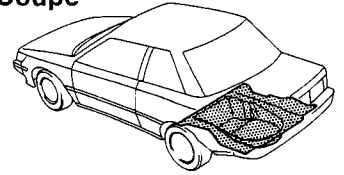
1. Cut the new panel shown above.
2. After temporarily installing the new part, measure each part in accordance with the body dimension diagram.
3. Plug weld the overlapping portion of the new part.
4. Coat the overlapping opening portion from the both sides with body sealer.

NOTE: Be sure the portion to be welded are align and not loose.

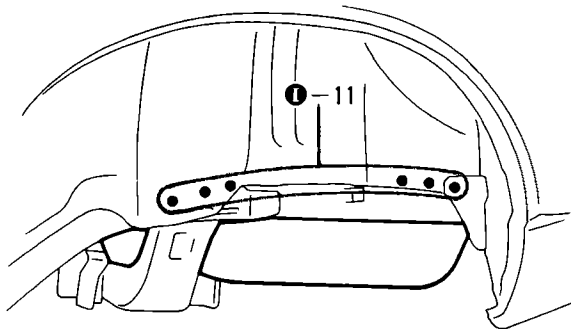
REAR FLOOR PAN (CUT)

REMOVAL

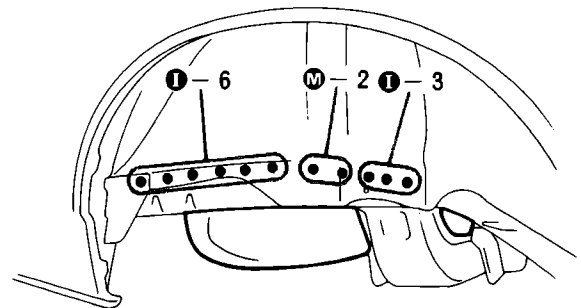
Coupe



[LH]

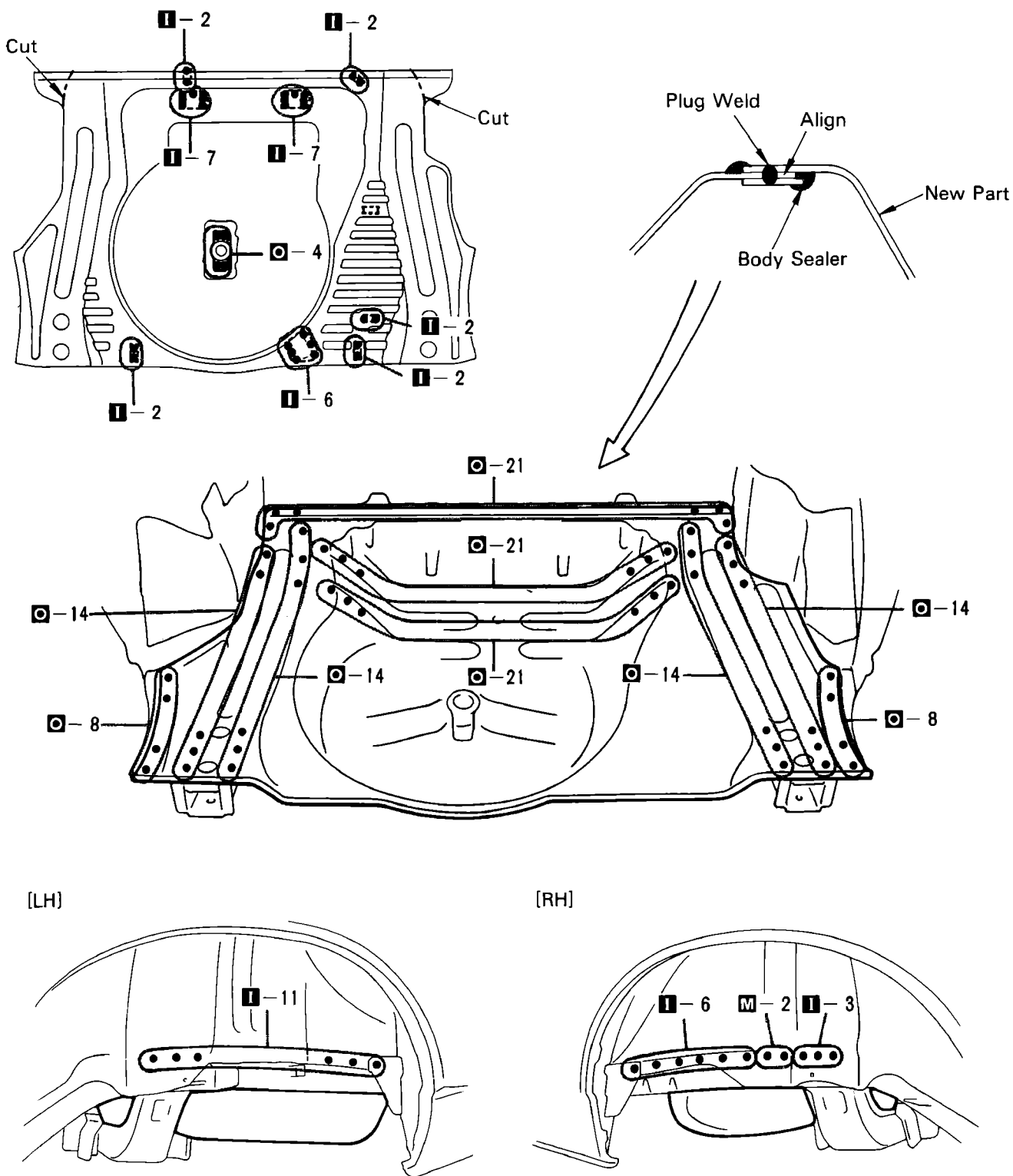


[RH]



1. Cut and join the rear floor pan shown above.
2. Avoid the rear floor side member and rear floor No. 2 crossmember when rough cutting the rear floor pan.

INSTALLATION

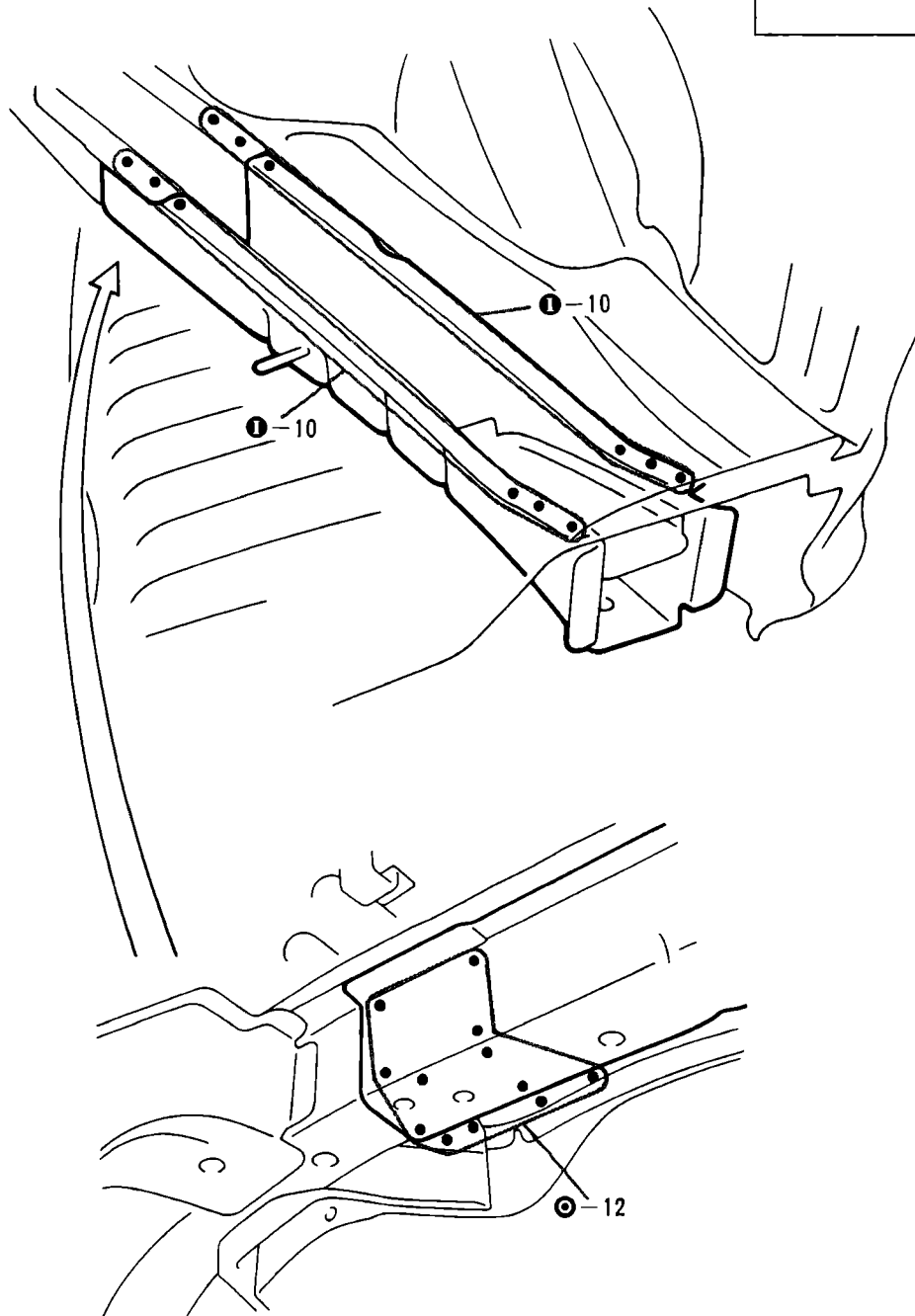
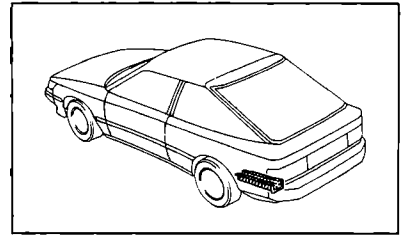


1. Cut the new panel shown above.
2. After temporarily installing the new part, measure each part in accordance with the body dimension diagram.
3. Plug weld the overlapping portion of the new part.
4. Coat the overlapping opening portion from the both sides with body sealer.

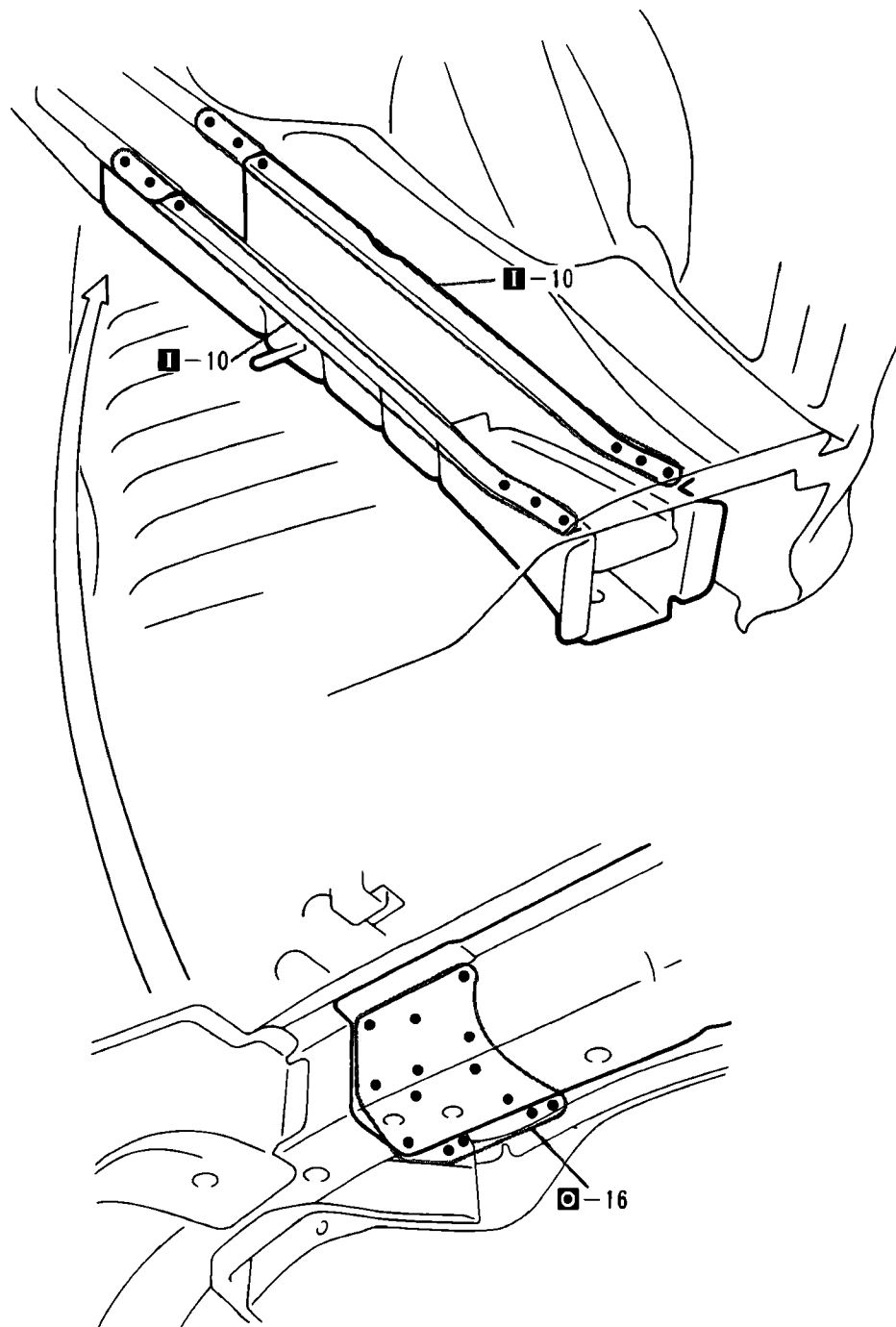
NOTE: Be sure the portion to be welded are align and not loose.

REAR FLOOR REAR SIDE MEMBER (ASSY)

REMOVAL



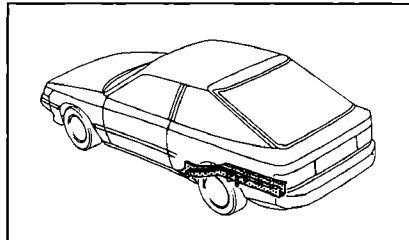
INSTALLATION



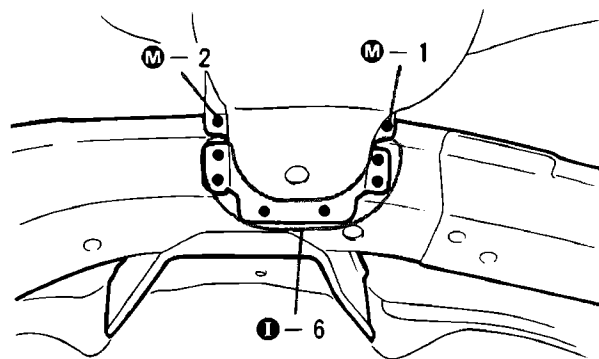
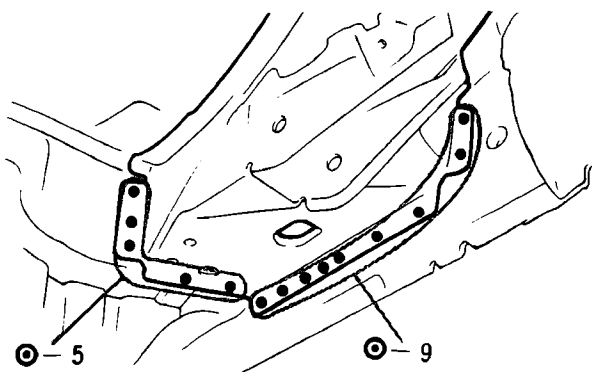
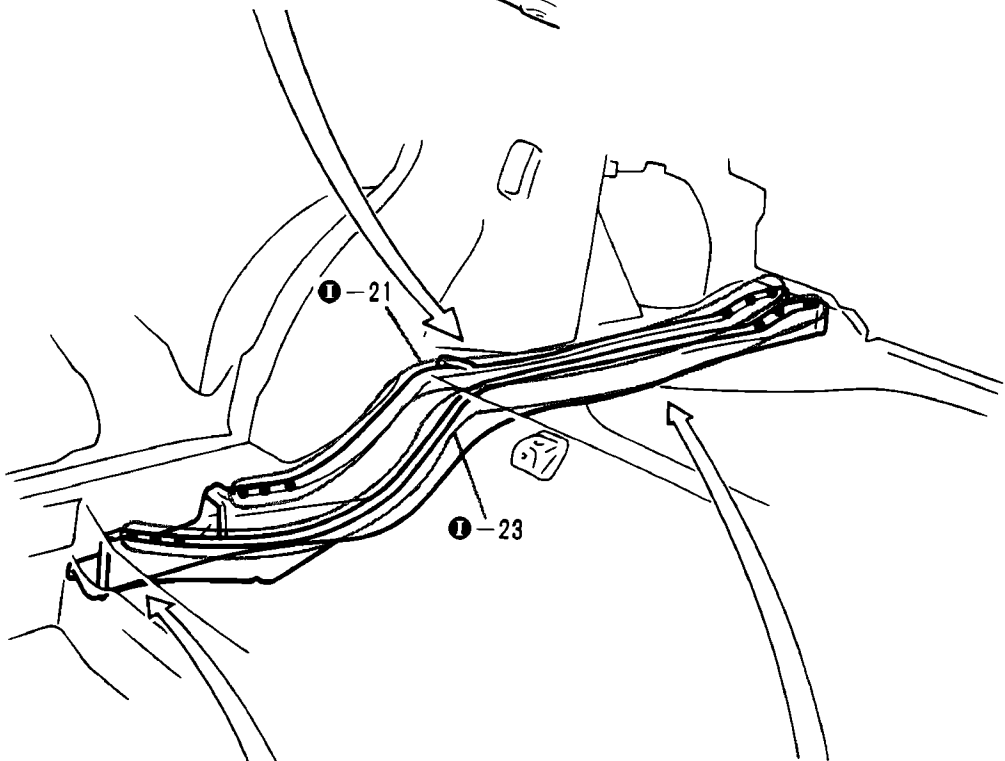
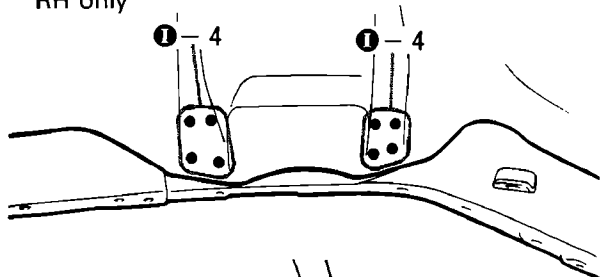
1. Temporarily install the new part and measure each part in accordance with the body dimension diagram.

REAR FLOOR SIDE MEMBER (ASSY)

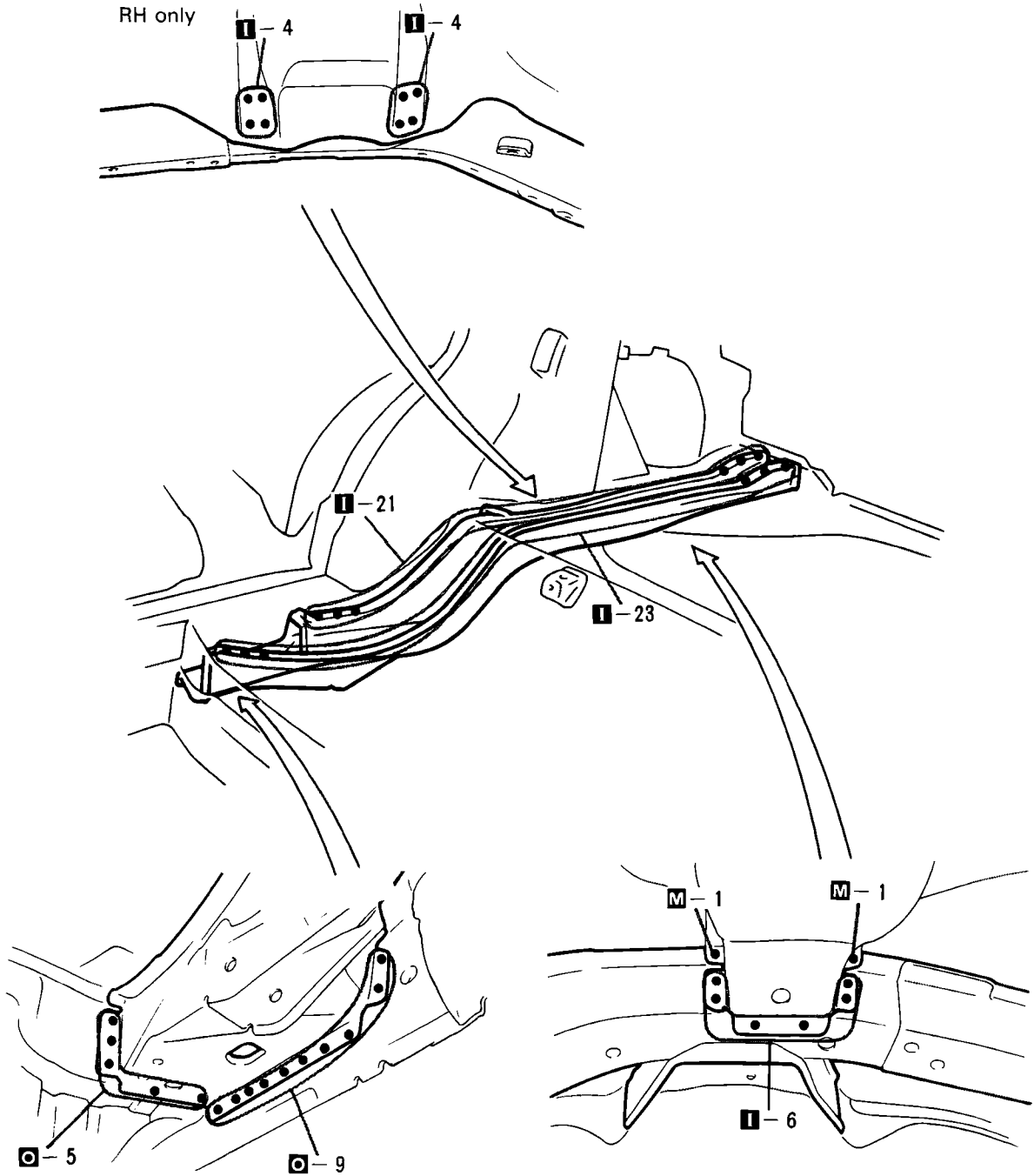
REMOVAL



RH only



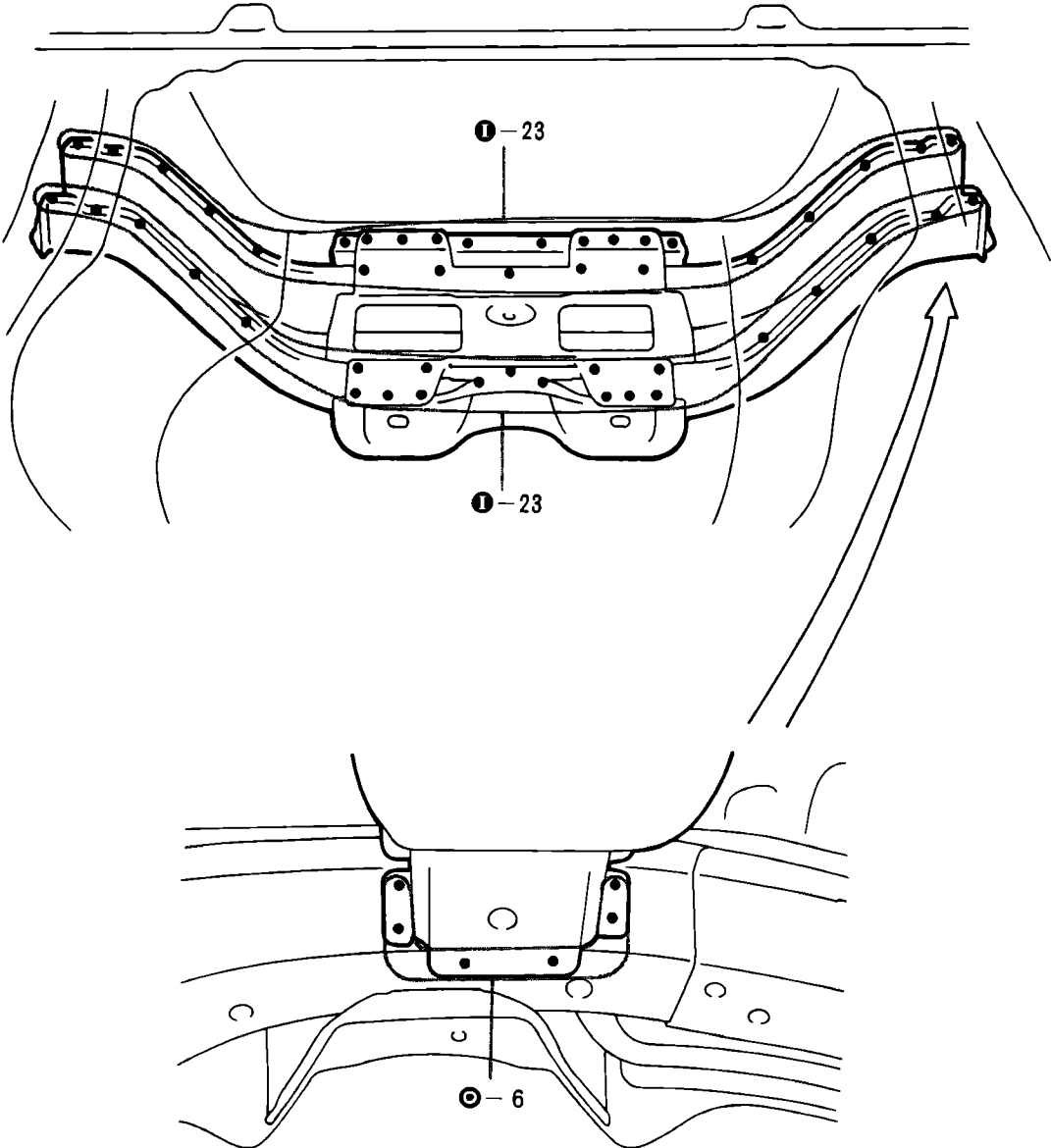
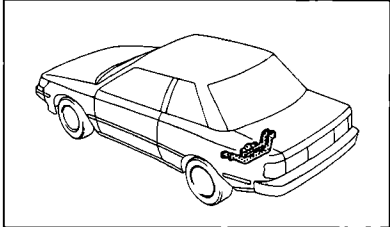
INSTALLATION



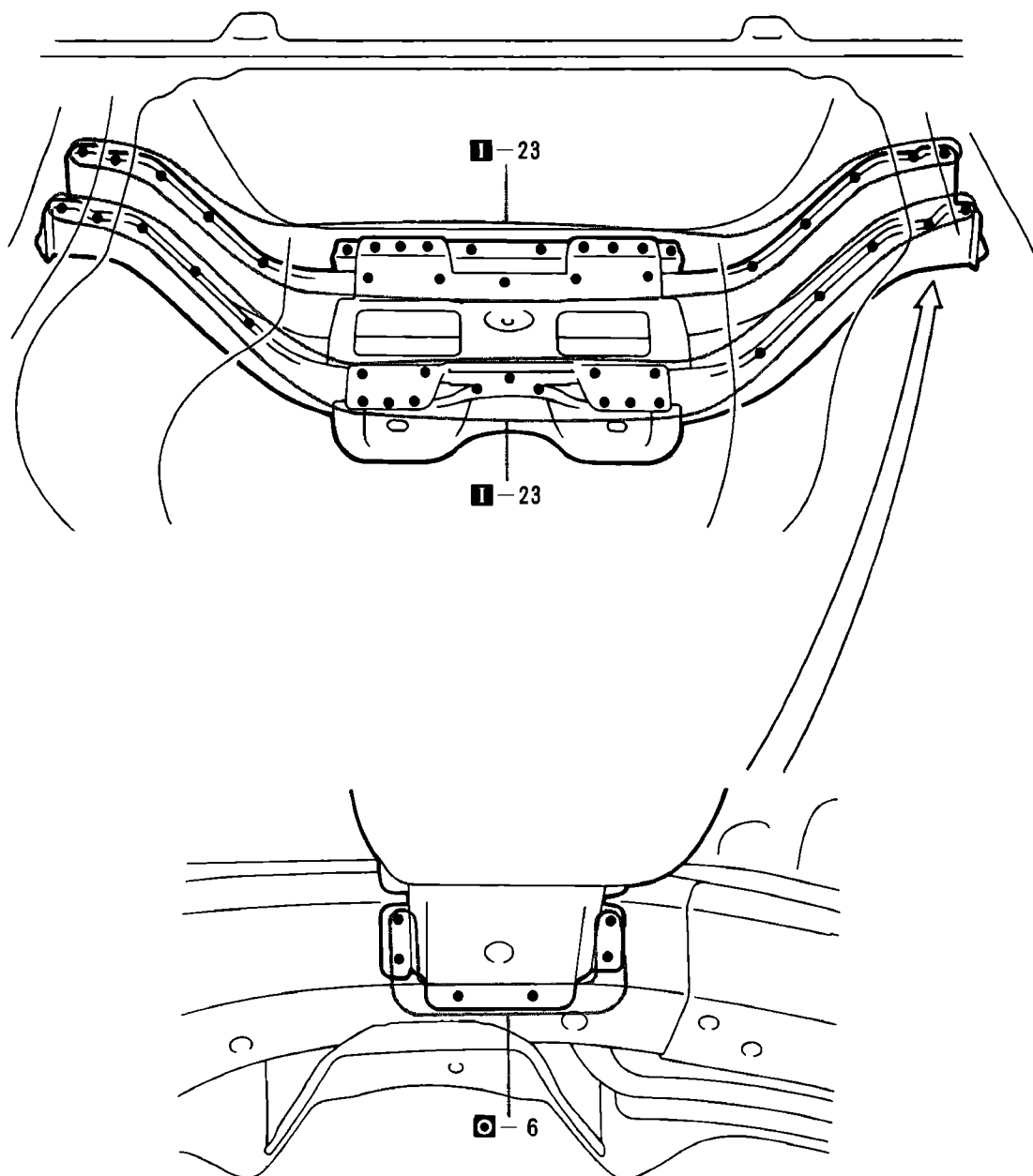
1. Temporarily install the new part and measure each part in accordance with the body dimension diagram.

REAR FLOOR NO. 2 CROSSMEMBER (ASSY)

REMOVAL



INSTALLATION



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

NOTE: Make sure each measurement is correct, as this part effects the rear wheel alignment.

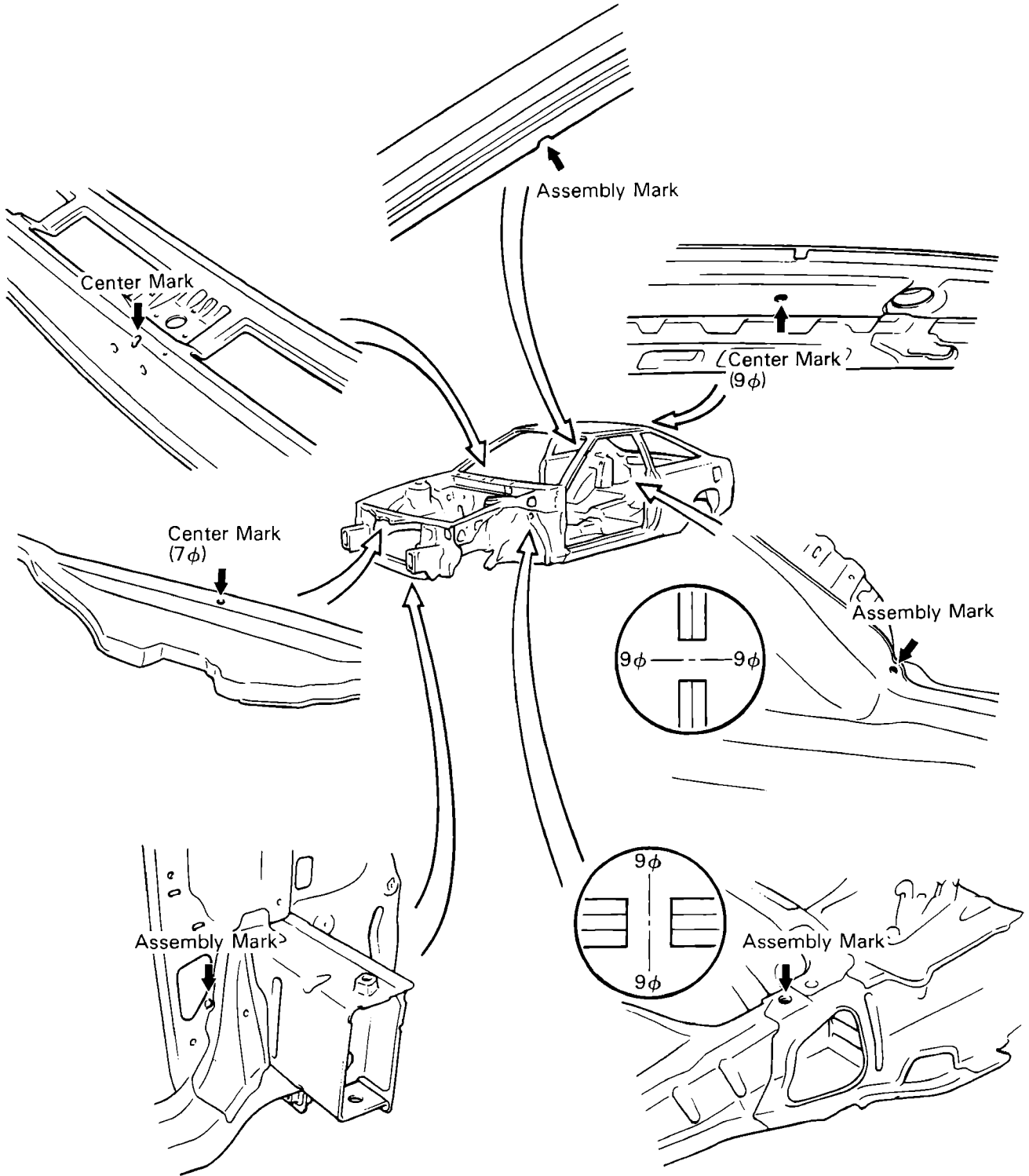
BODY PANEL CONSTRUCTION

	Page
STANDARD BODY MARKS	CN-2
HIGH STRENGTH STEEL PARTS	CN-4



STANDARD BODY MARKS

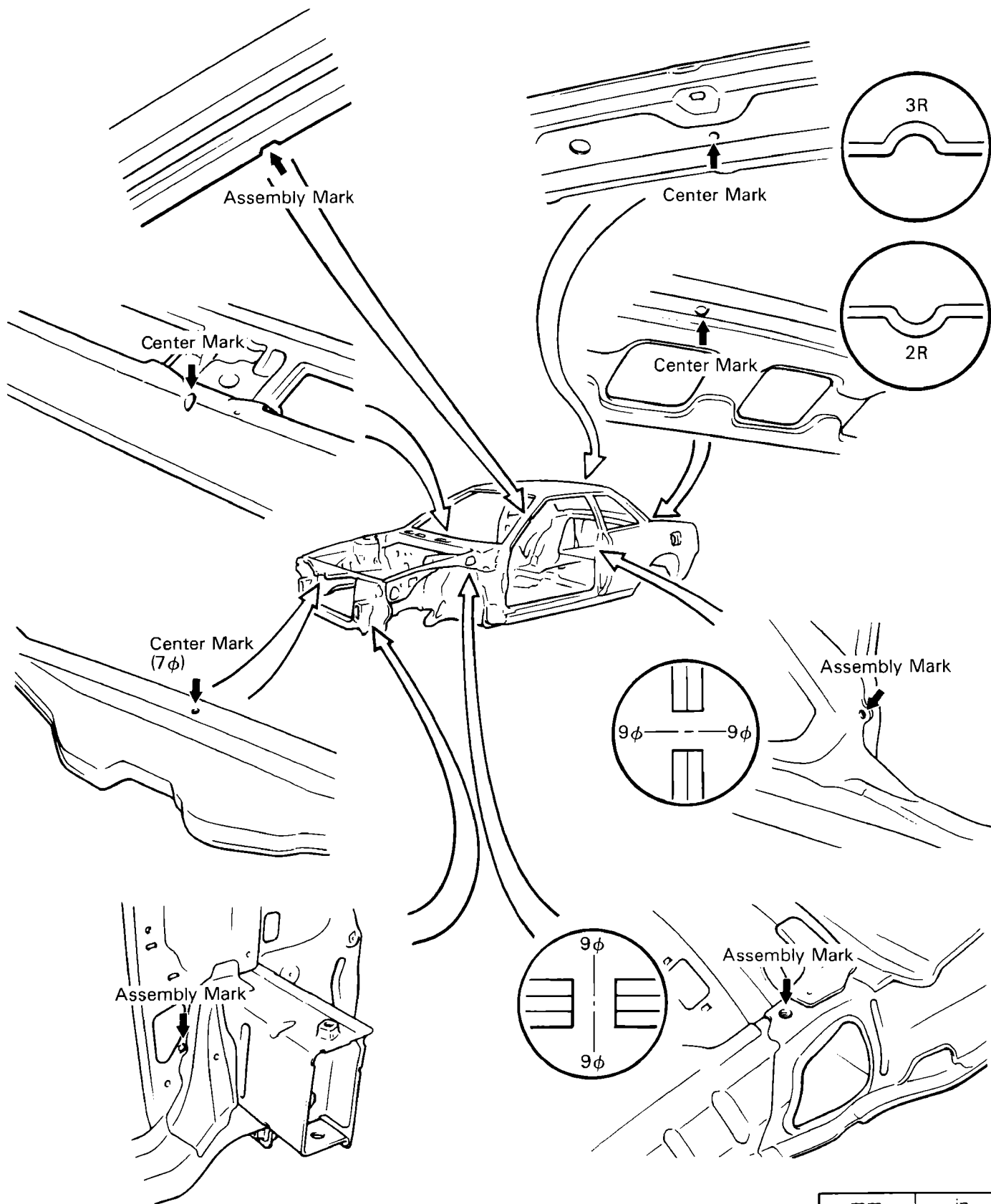
LIFTBACK



(mm)

mm	in.
7	0.28
9	0.35

COUPE



(mm)

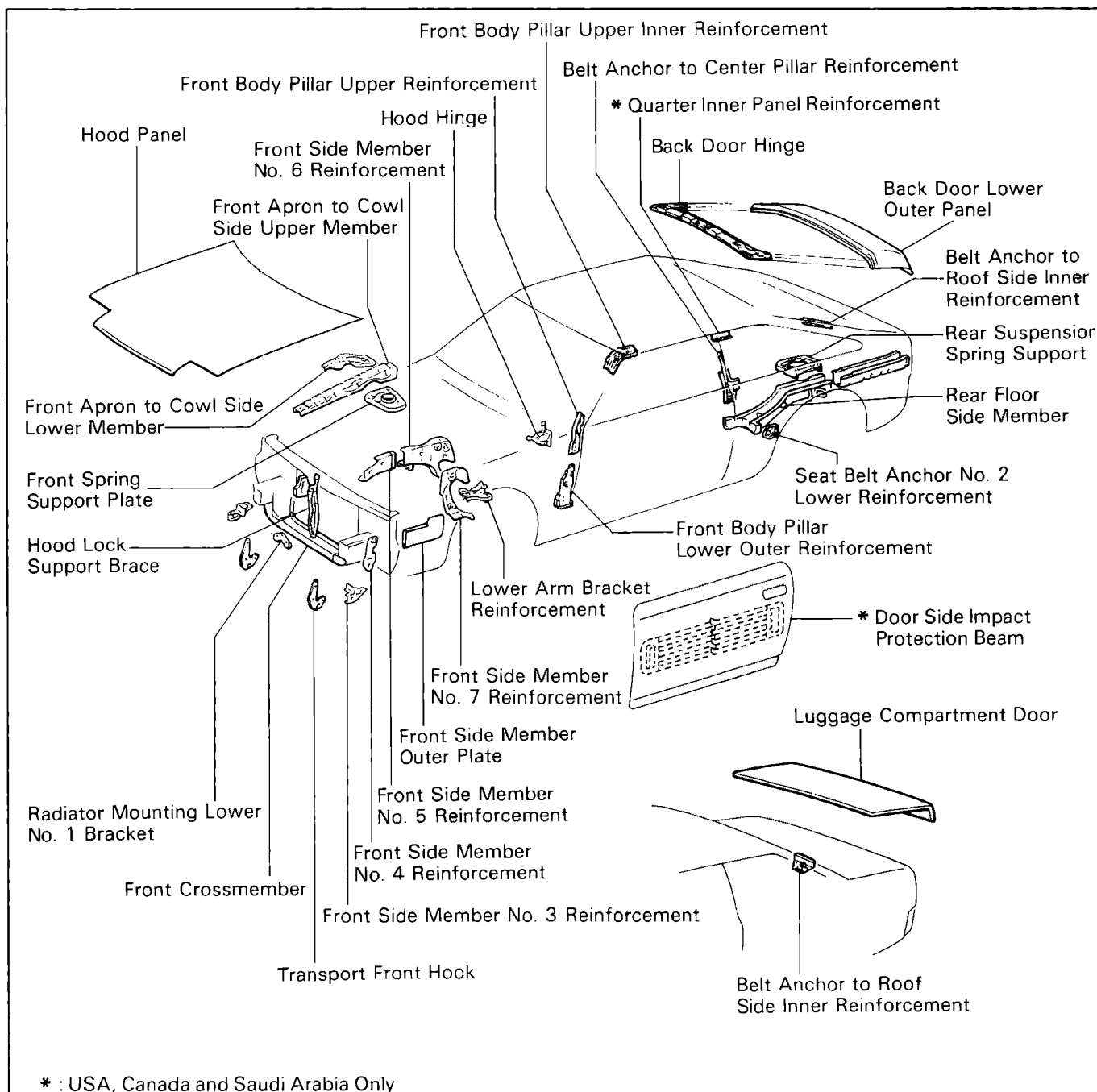
mm	in.
2	0.08
3	0.12
7	0.28
9	0.35

HIGH STRENGTH STEEL (HSS) PARTS

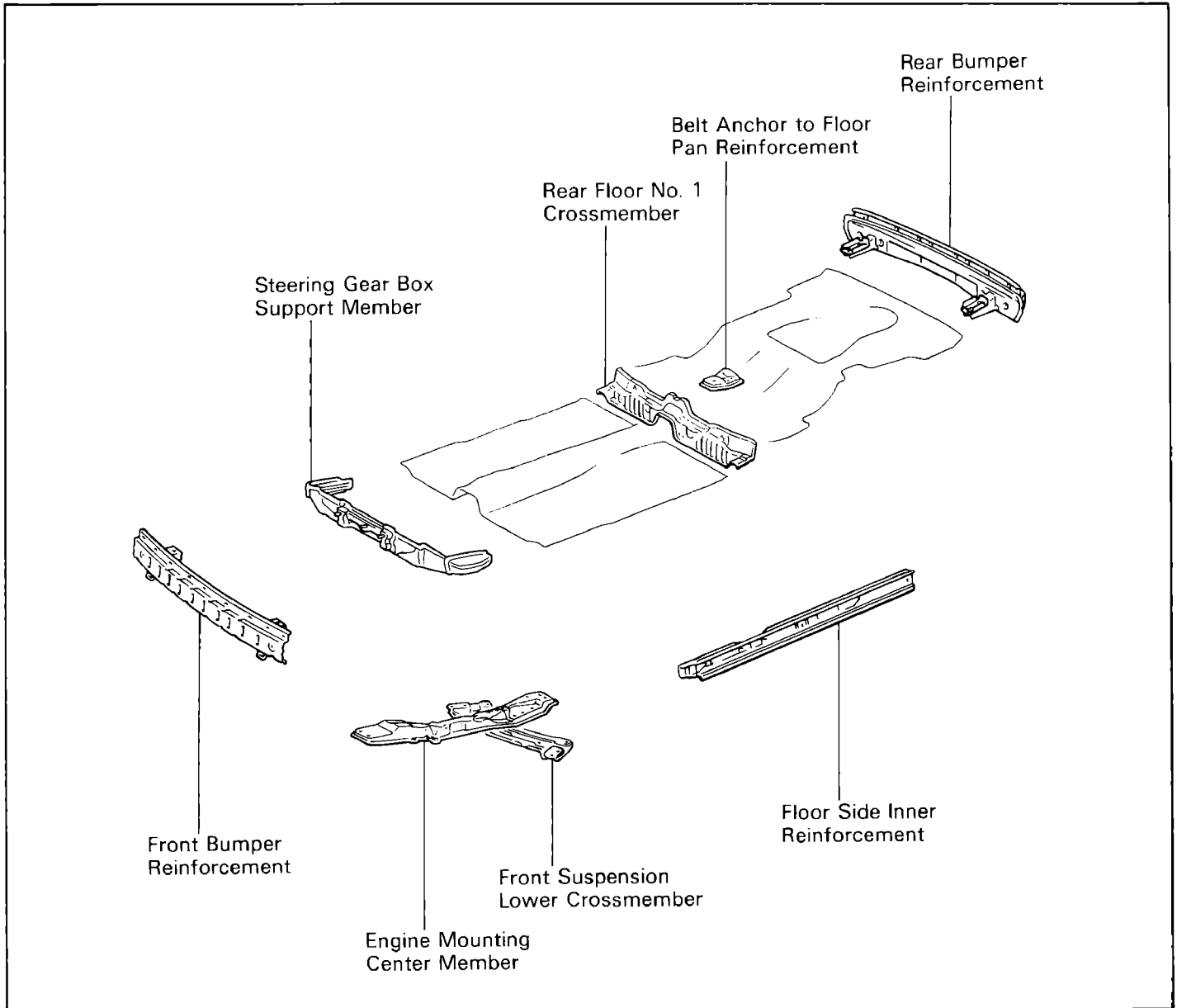
Generally, High Strength Steel (HSS) is that which has an intensity value of at least 35 kgf/mm², and distinguished from mild steel.

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



HIGH STRENGTH STEEL (HSS) PARTS (Cont'd)



PLASTIC BODY PARTS

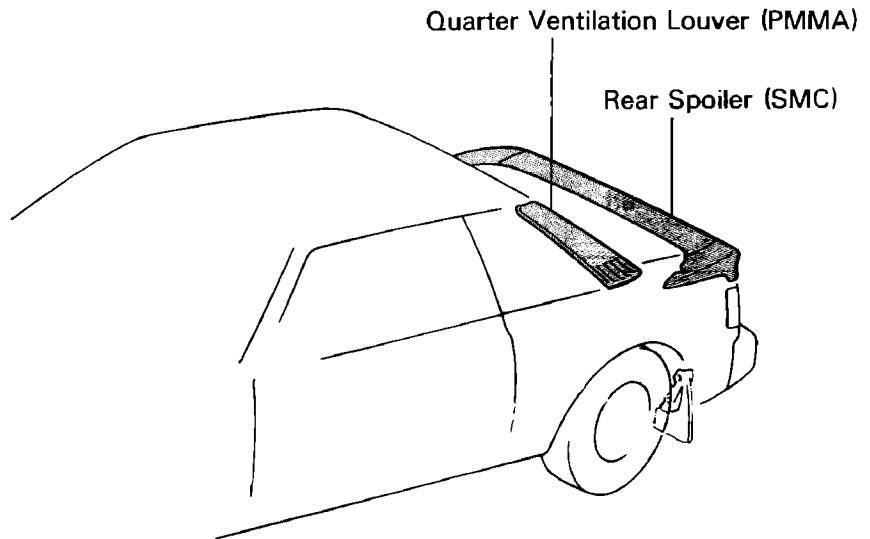
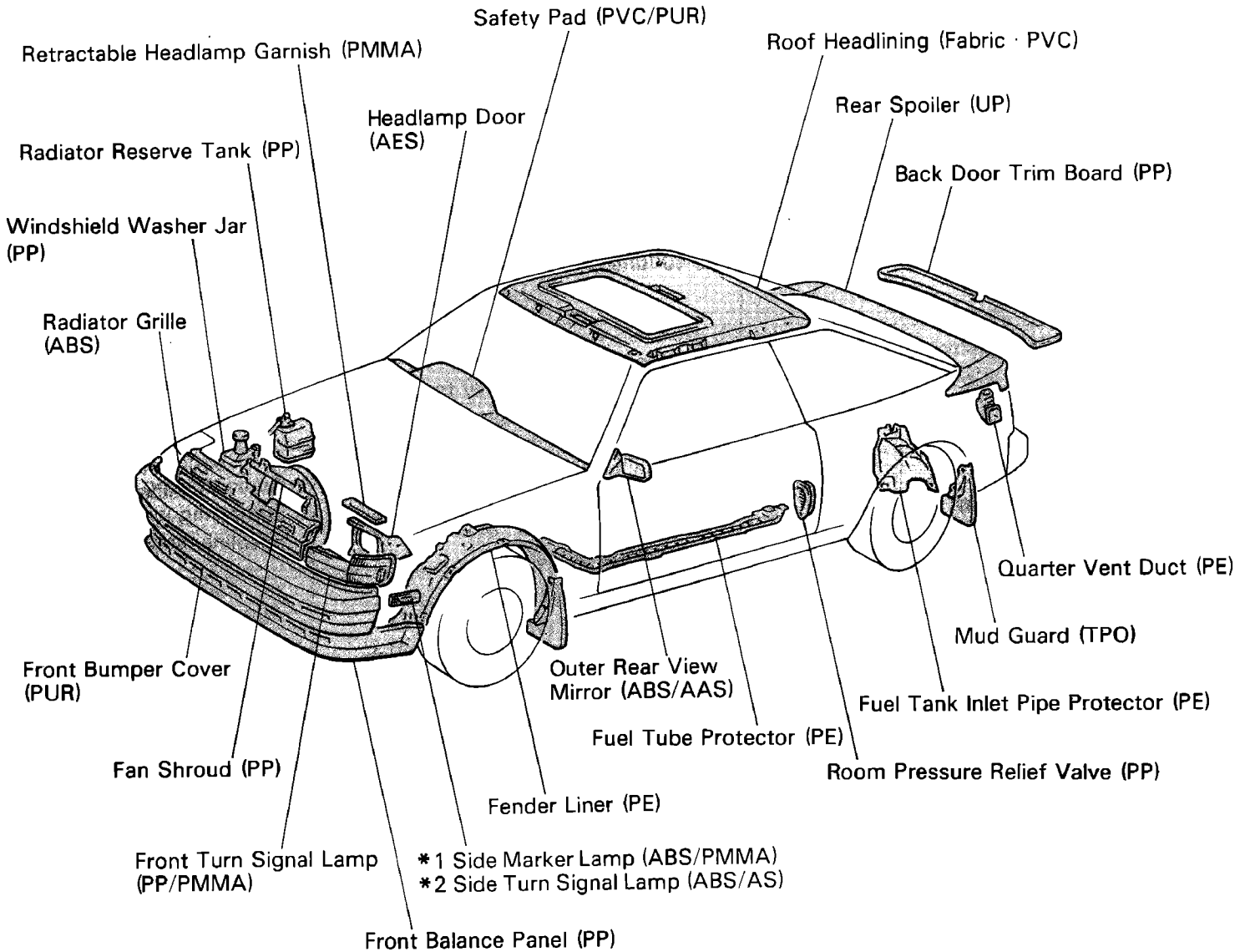
	Page
HANDLING PRECAUTIONS	PP-2
LOCATION OF PLASTIC BODY PARTS	PP-4

PP

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 amounts.	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 amounts (ex., quick wiping to remove grease).	Avoid dipping or immersing in alcohol, gasoline, solvents, etc.
PVC	Polyvinylchloride (Vinyl)	80 (176)	Alcohol and gasoline are harmless if applied only for short time in small amounts (ex., quick wiping to remove grease).	Avoid dipping or immersing in alcohol, gasoline, solvents, etc.
PMMA	Polymethyl Methacrylate	80 (176)	Alcohol is harmless if applied only for short time in small amounts.	Avoid dipping or immersing in alcohol, gasoline, solvents, etc.
SAN	Styrene Acrylonitrile Resin	80 (176)	Alcohol is harmless if applied only for short time in small amounts (ex., quick wiping to remove grease).	Avoid dipping or immersing in alcohol, gasoline, solvents, etc.
SMC	Sheet Moulding Compound	180 (356)	Alcohol and gasoline are harmless.	Avoid alkali
TPO	Thermoplastic Olefine	80 (176)	Alcohol is harmless. Gasoline is harmless if applied only for short time in small amounts.	Most solvents are harmless but avoid dipping in gasoline, solvents, etc.
TPUR	Thermoplastic Polyurethane	60 (140)	Alcohol is harmless if applied only for very short time in small amounts (ex., quick wiping to remove grease).	Avoid dipping or immersing in alcohol, gasoline, solvents, etc.

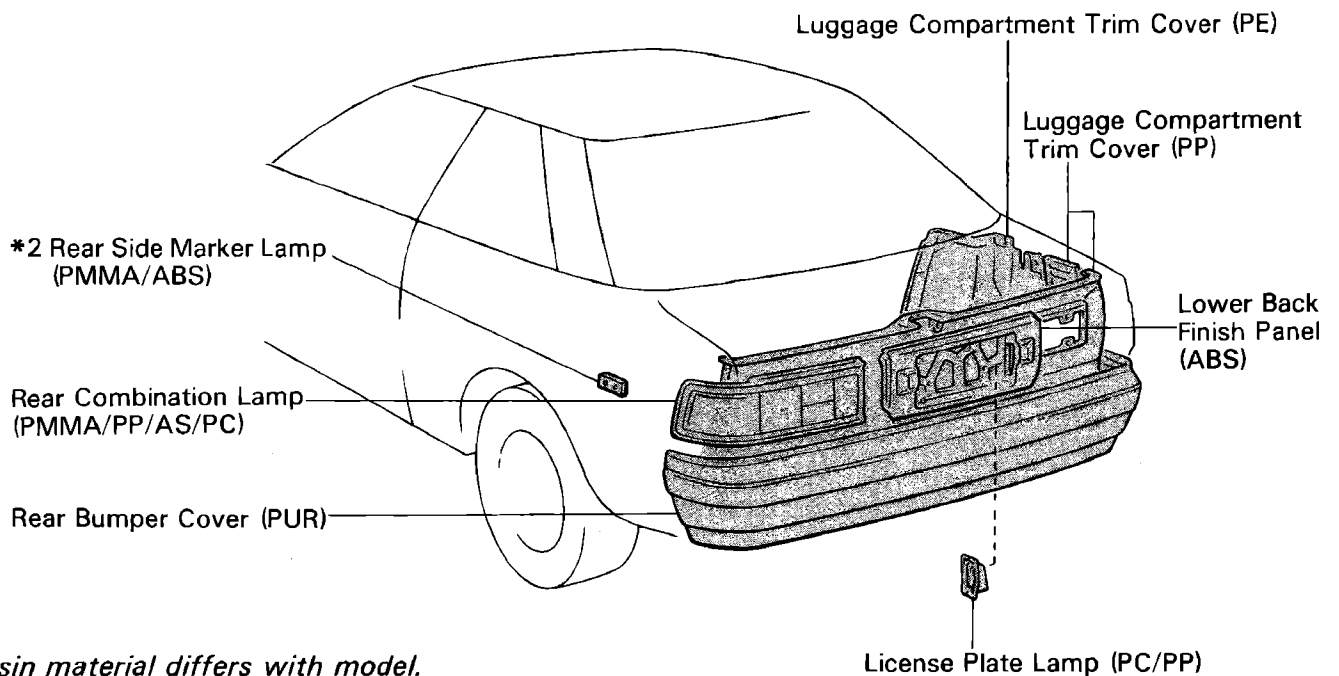
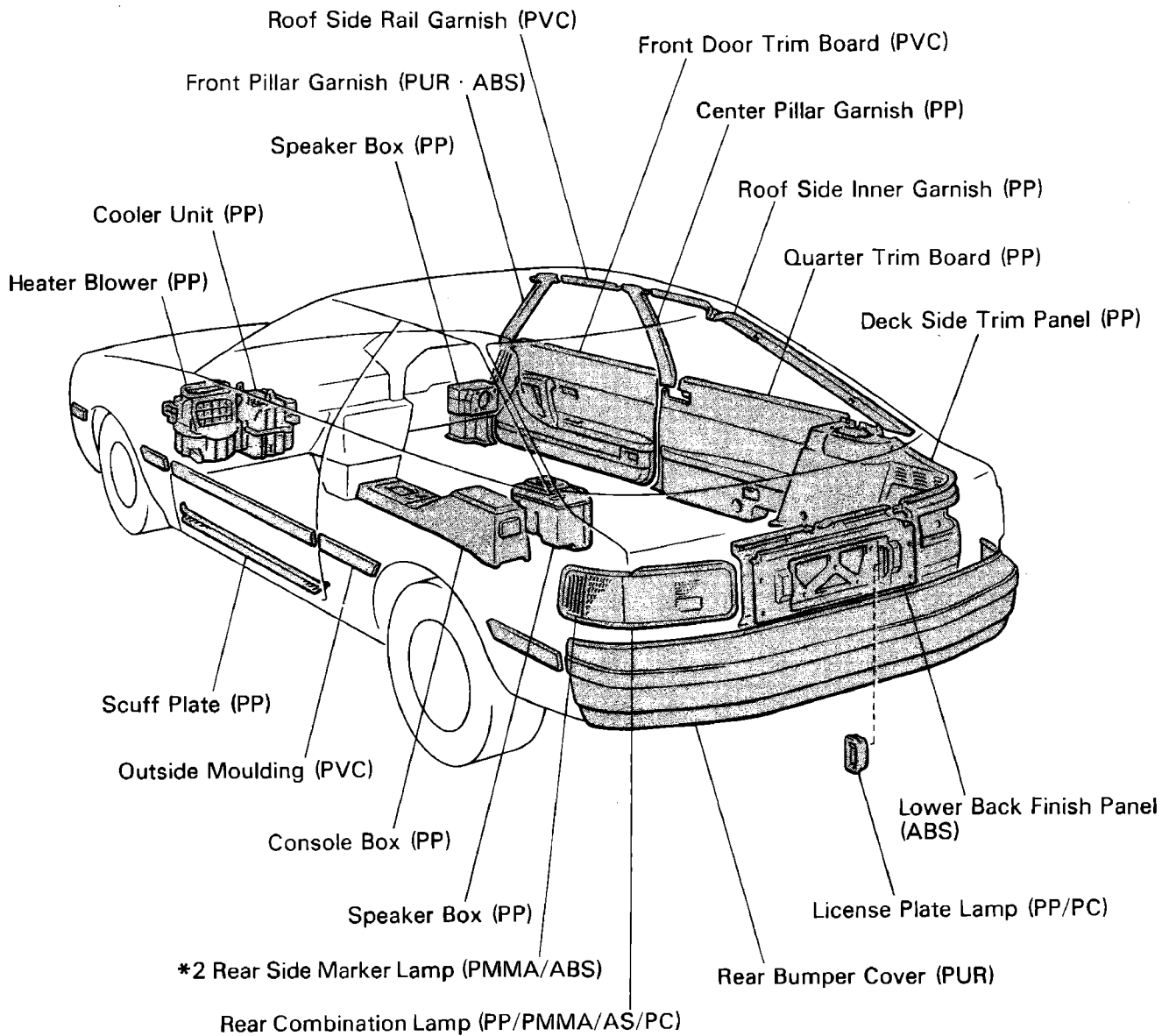
* Temperature higher than those listed here may result in material deformation during repair.

LOCATION OF PLASTIC BODY PARTS



NOTE:

- Resin material differs with model.
- / Made up of 2 or more kinds of materials.
- *1 USA and Canada
- *2 Except USA and Canada



NOTE:

- Resin material differs with model.
- / Made up of 2 or more kinds of materials.
- *1 USA and Canada
- *2 Except USA and Canada

BODY PANEL SEALING AND UNDERCOATING

	Page
BODY PANEL SEALING AREAS	SU-2
BODY PANEL UNDERCOATING AREAS	SU-6

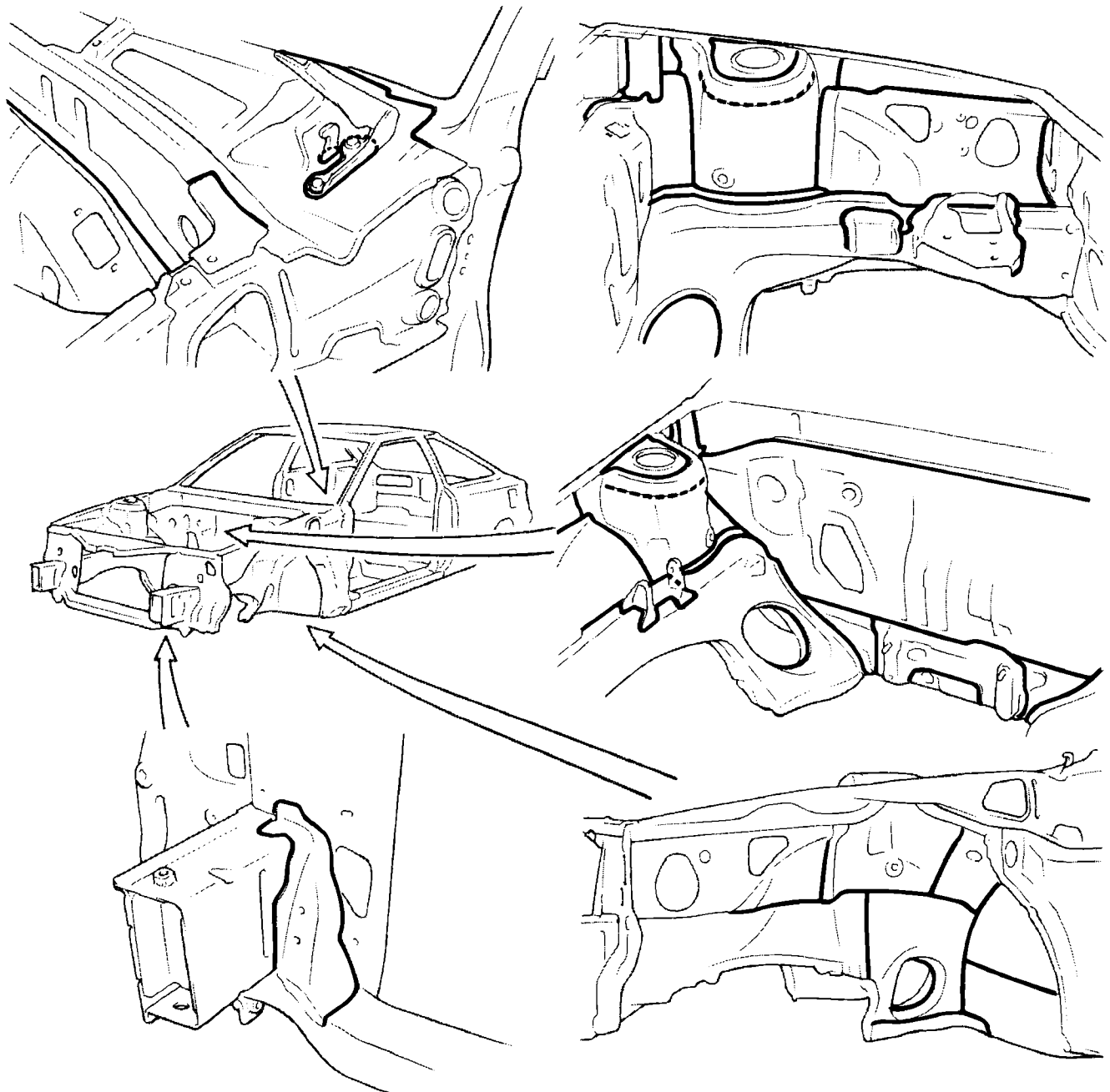


BODY PANEL SEALING AREAS

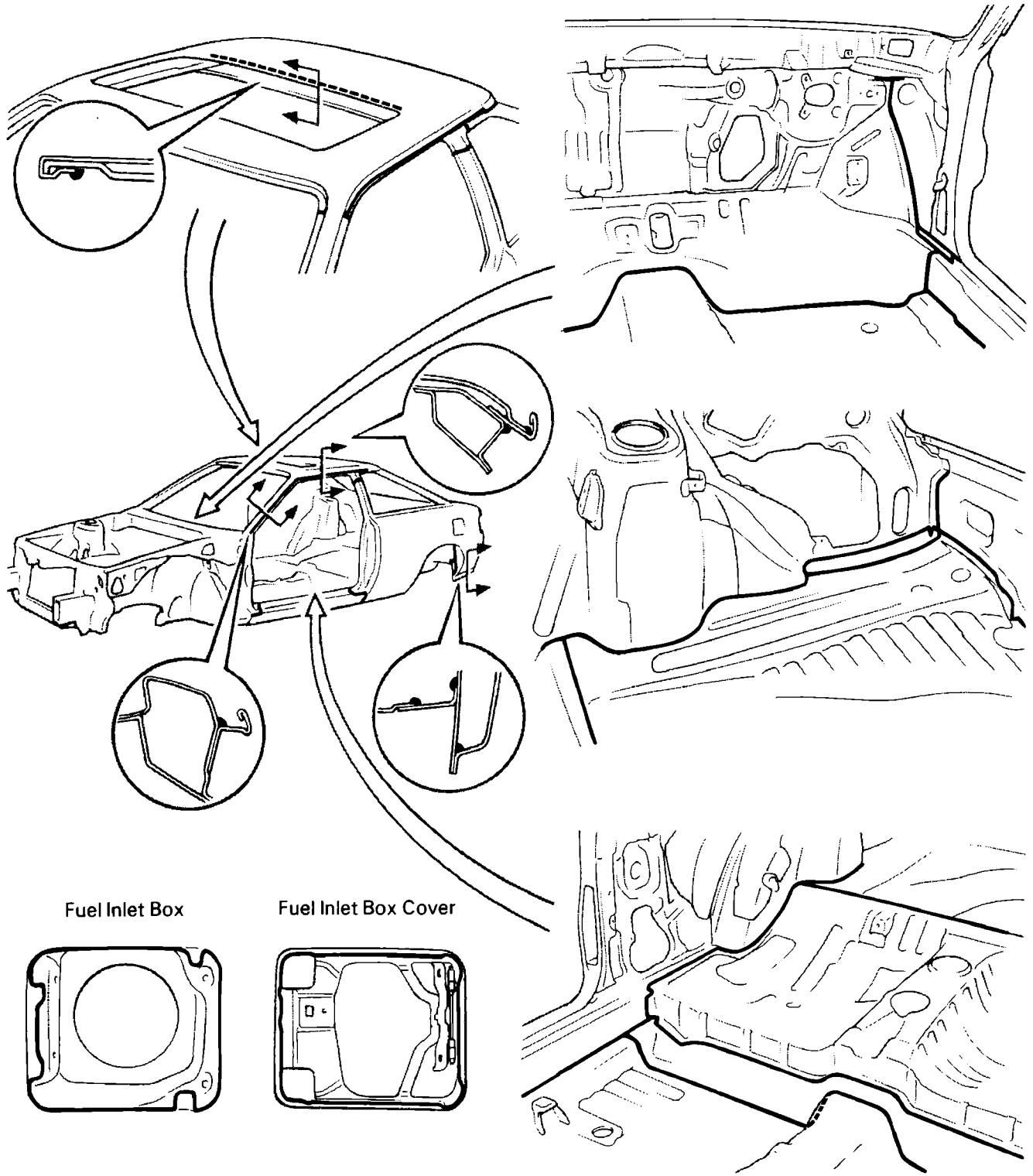
For water-proofing and anti-corrosion measures, always apply body sealer to the body panel seams and hems of the doors, hood, etc.

NOTE:

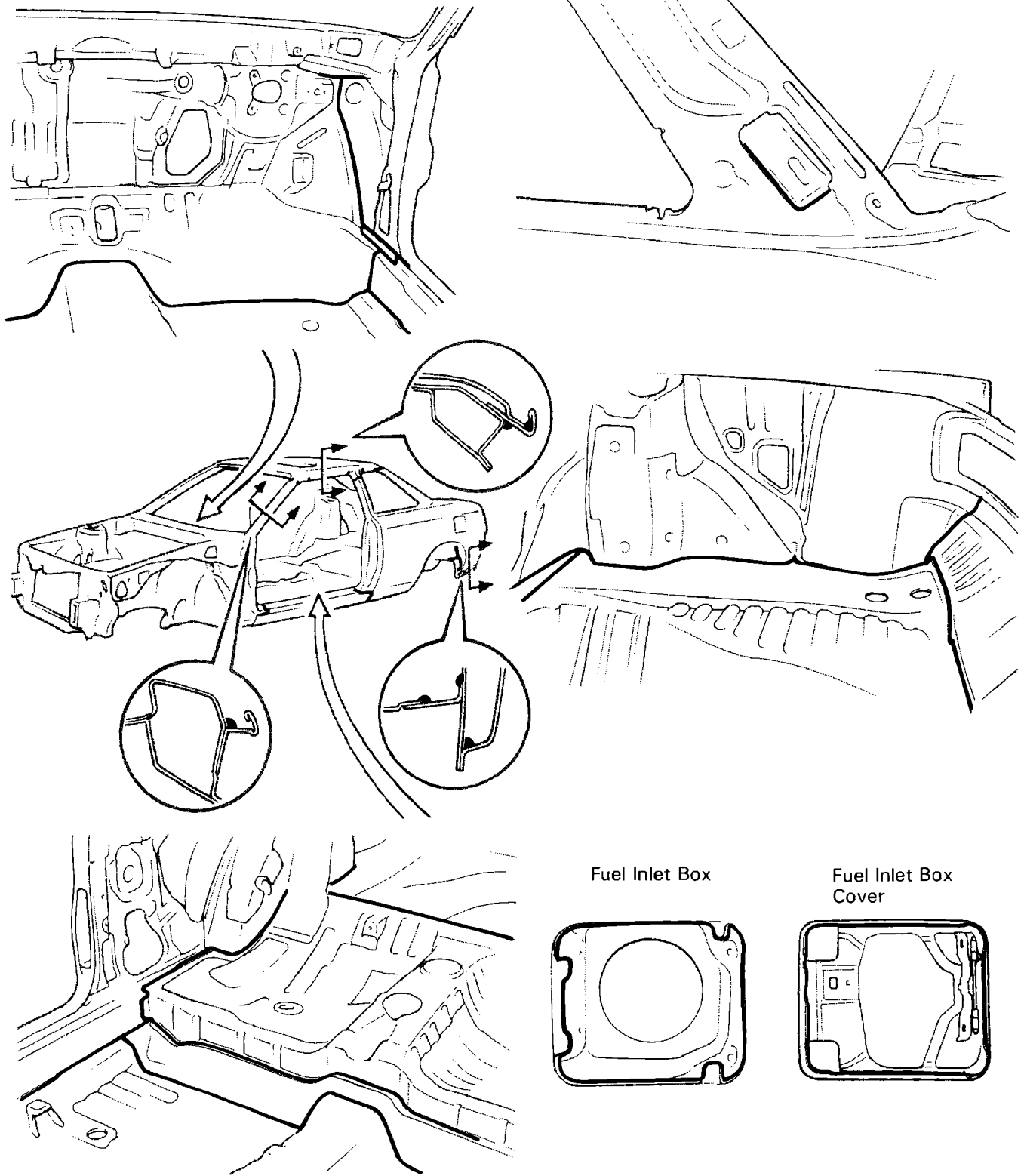
1. *Prior to applying body sealer, clean the area with a rag soaked in white gasoline.*
2. *If weld-through primer was used, first wipe off any excess with thinner, and coat with anti-corrosion primer before applying body sealer.*
3. *Wipe off any excess body sealer with a rag soaked in white gasoline.*



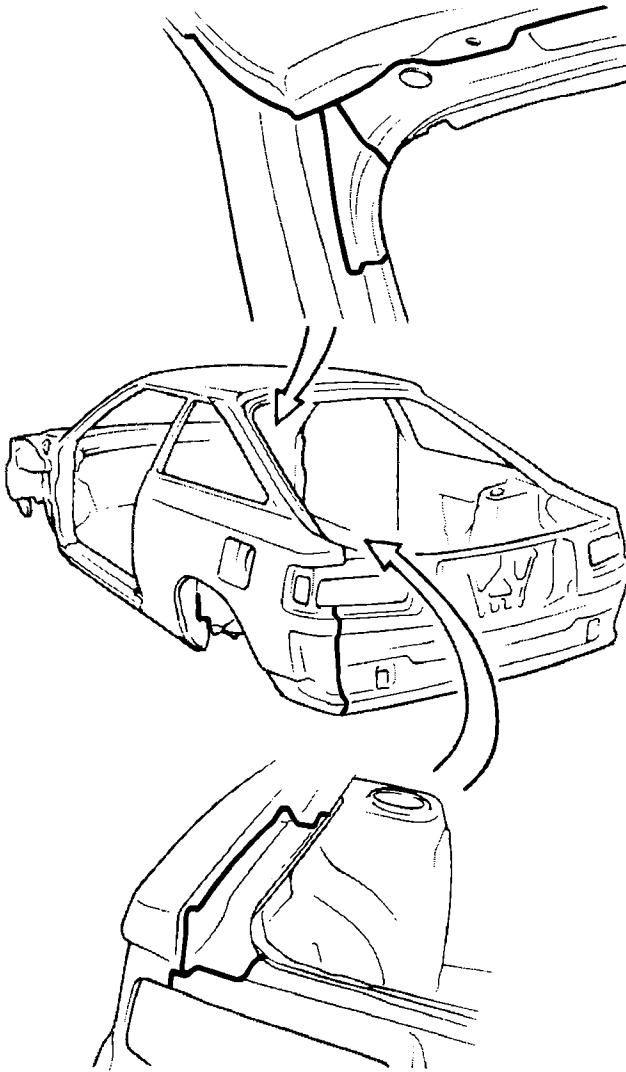
LIFTBACK



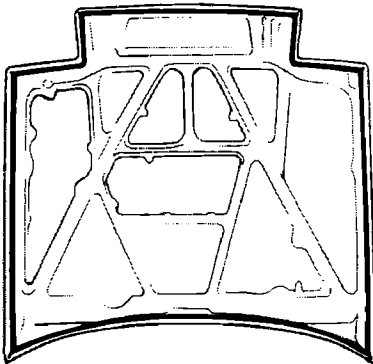
COUPE



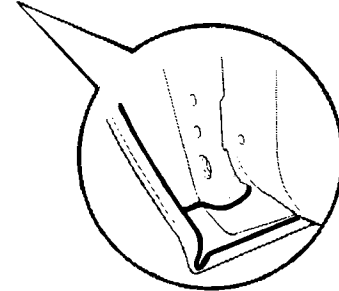
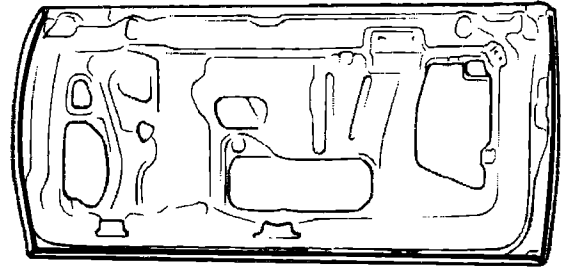
LIFTBACK



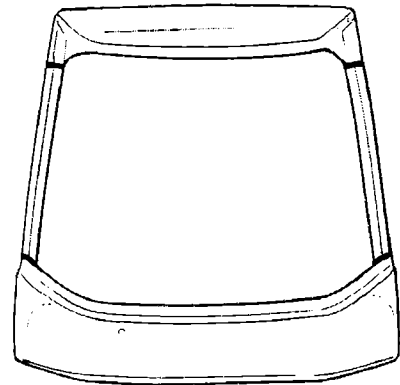
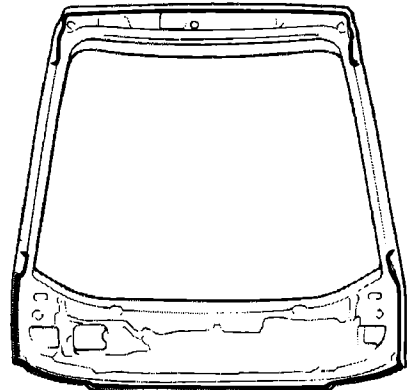
Engine Hood



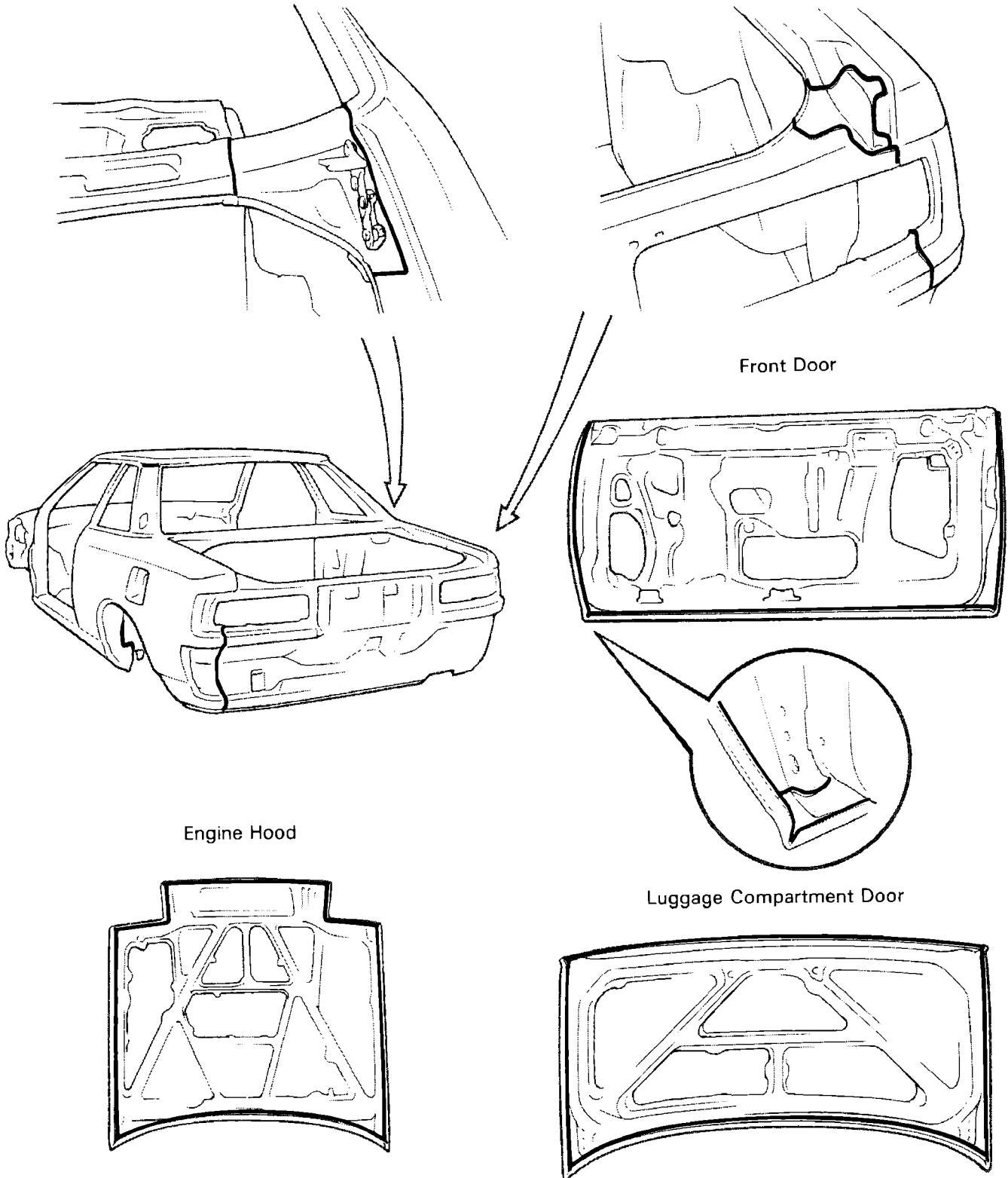
Front Door Panel



Back Door Panel



COUPE

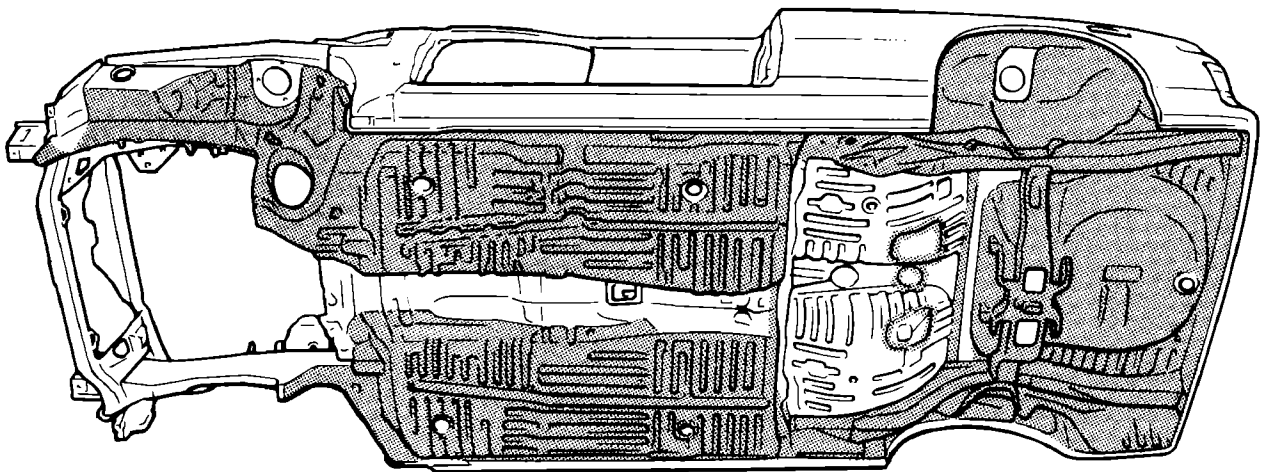


BODY PANEL UNDERCOATING AREAS

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 dirt, 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 accidentally coated, wipe off the coating immediately.*
3. *Do not coat parts which become hot, such as the tailpipe, or moving 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 flange of the member and bracket with undercoating.*



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

BODY DIMENSIONS

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

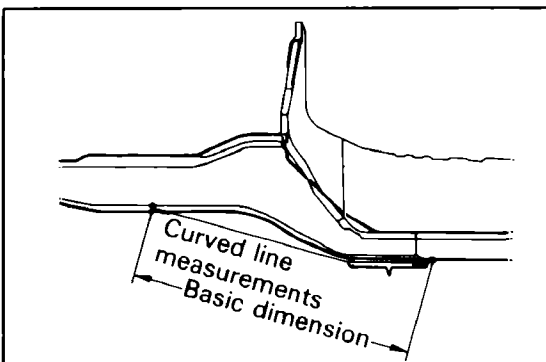
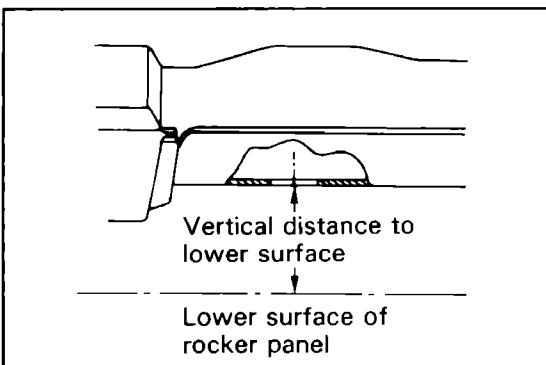
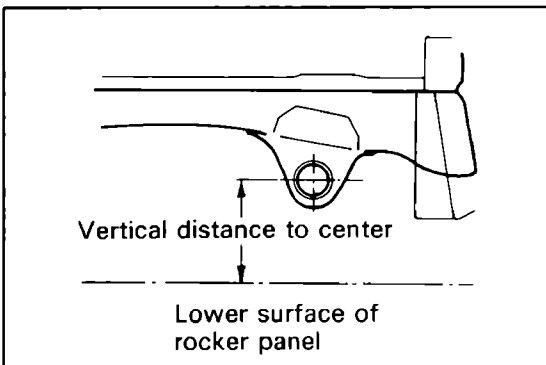
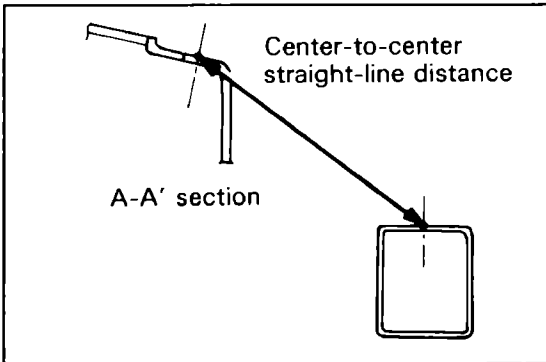
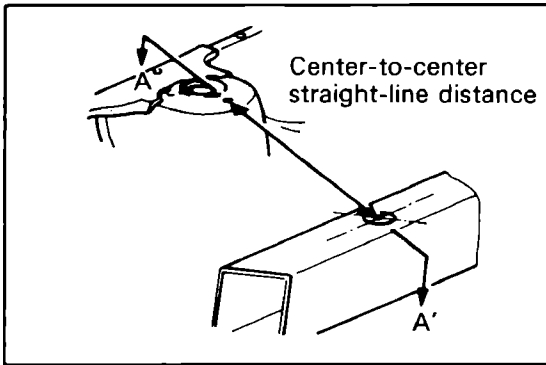
DI

BODY MEASUREMENTS

1. BASIC DIMENSIONS

All dimensions shown in the drawing on page DI-4 through page DI-8 are basic dimensions which define either of the following distances:

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



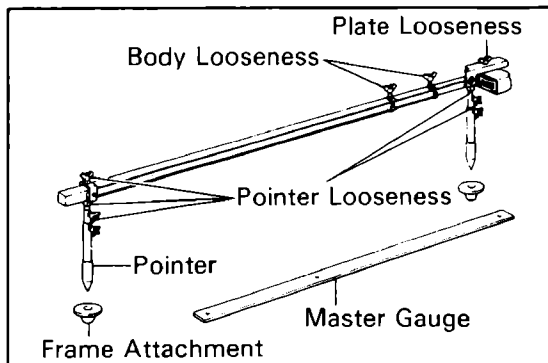
- (b) Vertical distance from an imaginary line at the lower surface of the rocker panel to the lower surface or center of a measuring point.

2. REFERENCE DIMENSIONS

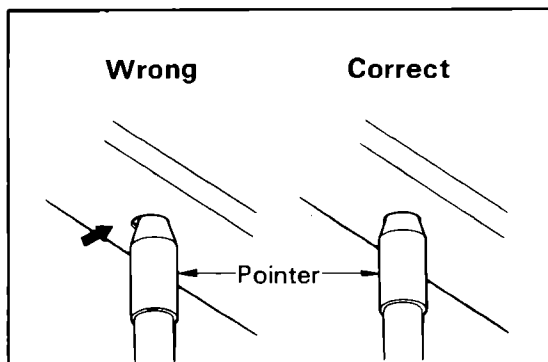
Curved line measurements, if applicable, are shown in brackets together with basic dimensions in the body dimension table on page DI-4.

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

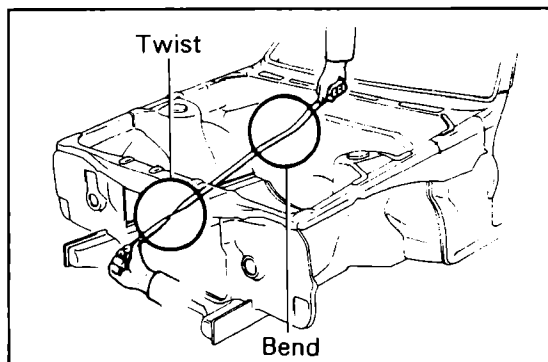


- (a) Basically, all measurements are taken with a tracking gauge. However, dimensions which can be measured with a tape measure only are indicated by a CHAIN LINE.
- (b) Use only a tracking gauge that has no looseness in the body, pointers or gauge plate.

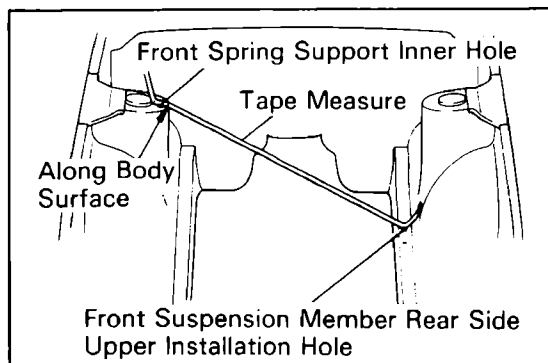


NOTE:

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 shock it.
4. Confirm that the pointers are securely in the holes.



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

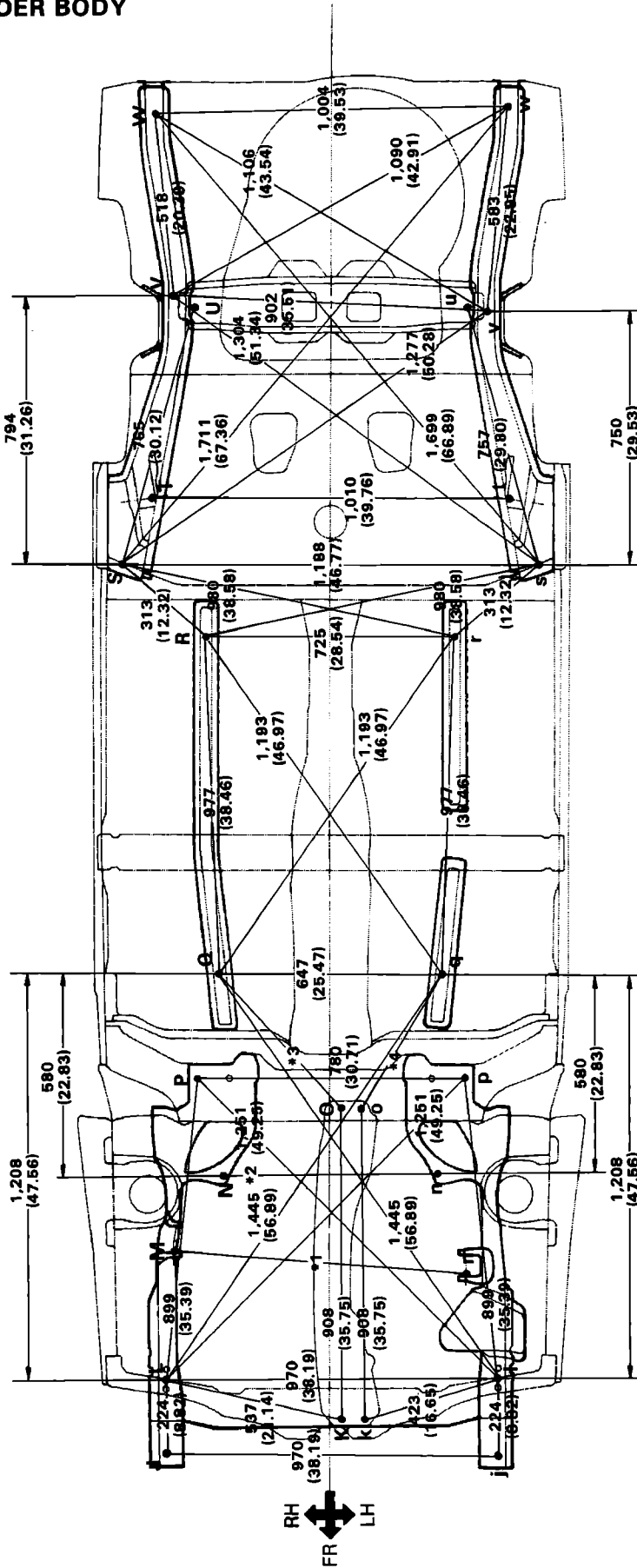


- (d) When taking a diagonal measurement from the front spring support inner hole to the suspension member upper rear installation hole, measure along the front spring support panel surface.

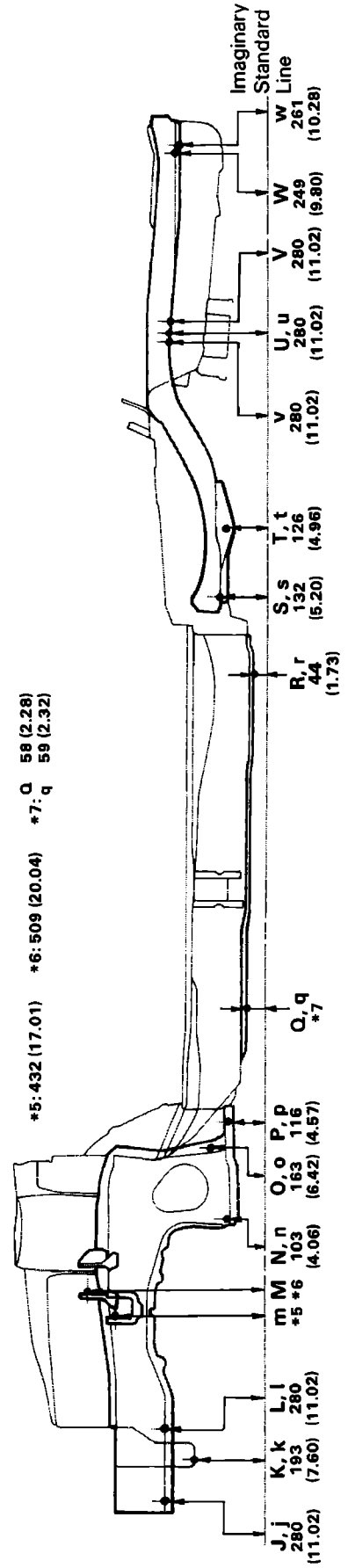
BODY DIMENSION DRAWINGS

UNDER BODY

*1: M-m 864 (34.02) *2: N-n 650 (25.59) *3: O-o 544 (21.42) *4: o-q 471 (18.54)



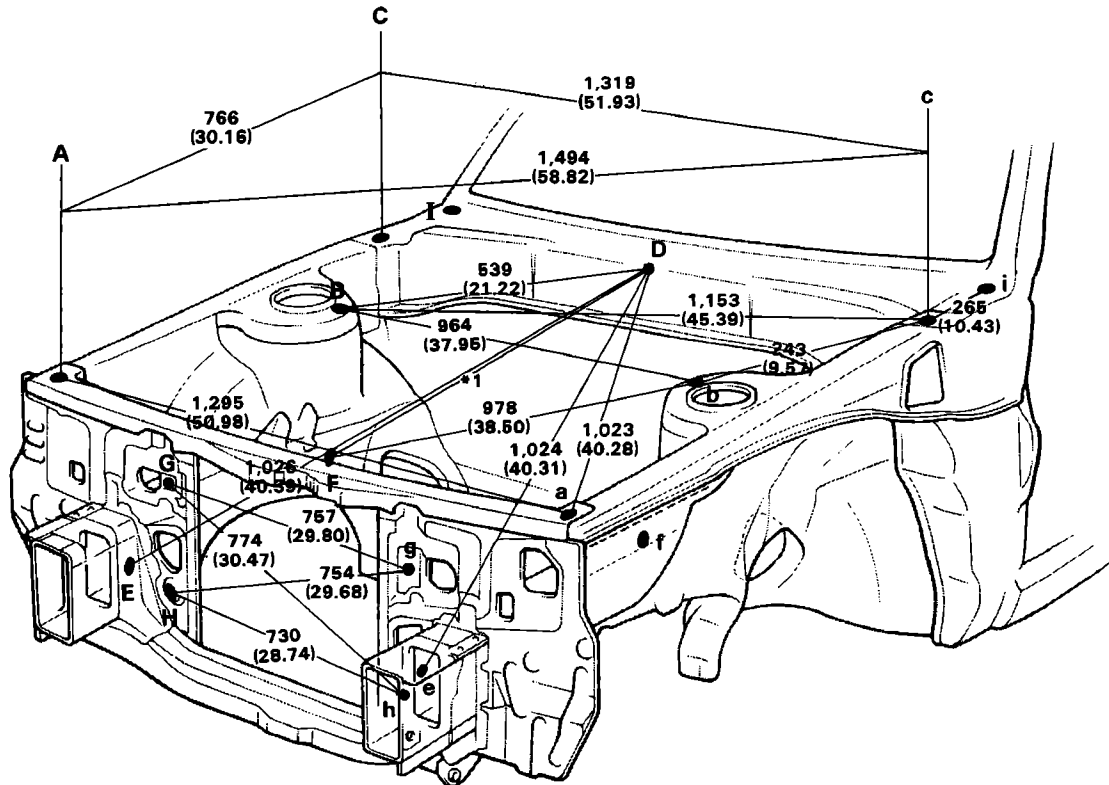
*5: 432 (17.01) *6: 509 (20.04) *7: Q 58 (2.28) *7: q 59 (2.32)



mm (in.)

Symbol	Nomenclature	Hole dia.	Symbol	Nomenclature	Hole dia.
J, j	Front side member bumper installation nut	RH 15 (0.59) LH 16 (0.63)	Q	Front floor under reinforcement standard hole (RH)	15 (0.59)
K	Engine mounting member installation nut – front (RH)	10 (0.39)	q	Front floor under reinforcement standard hole (LH)	15 (0.59)
k	Engine mounting member installation nut – front (LH)	10 (0.39)	R, r	Front floor under reinforcement standard hole	15 (0.59)
L, l	Front side member standard hole	15 (0.59)	S, s	Rear floor side member standard	15 (0.59)
M	Engine mounting bracket hole – front (RH)	13 (0.51)	T, t	Strut bar installation hole – inner	12 (0.47)
m	Engine mounting bracket hole – front (LH)	13 (0.51)	U, u	Rear floor crossmember standard hole	15 (0.59)
N, n	Lower arm installation nut	12 (0.47)	V	Rear floor side member standard hole (RH)	15 (0.59)
O	Engine mounting member installation nut (RH)	10 (0.39)	v	Rear floor side member standard hole (LH)	15 (0.59)
o	Engine mounting member installation nut (LH)	10 (0.39)	W	Rear floor side member standard hole (LH)	15 (0.59)
P, p	Lower arm installation nut	12 (0.47)	w	Rear floor side member standard hole (RH)	15 (0.59)

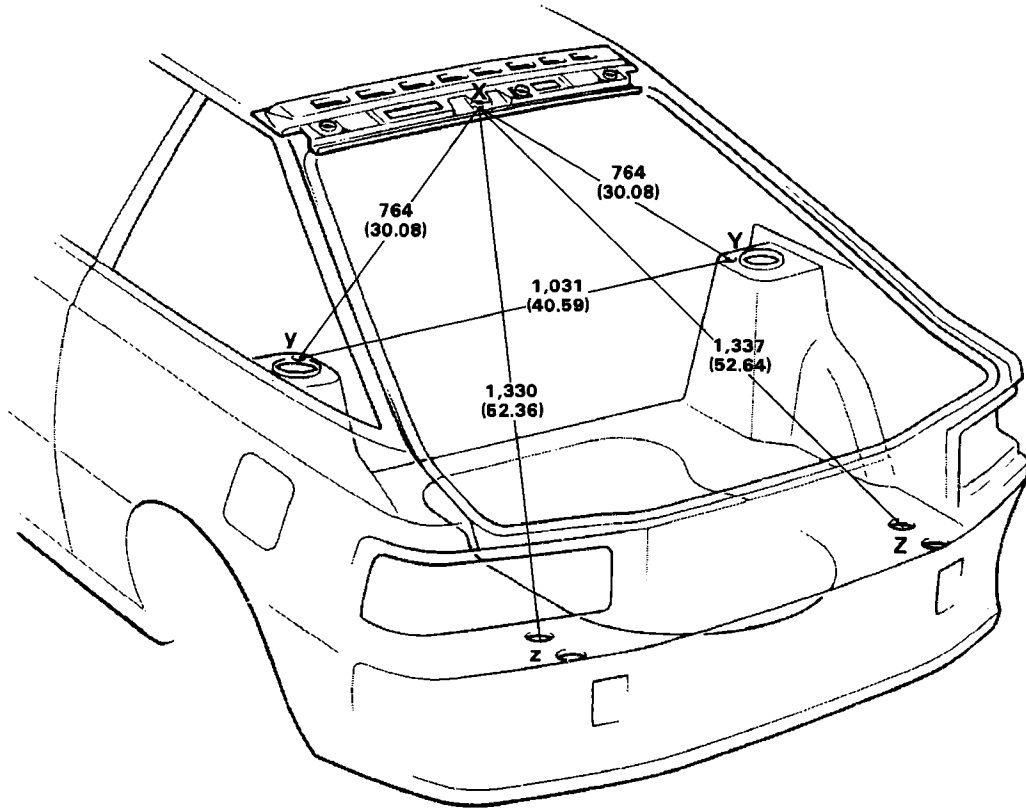
ENGINE COMPARTMENT



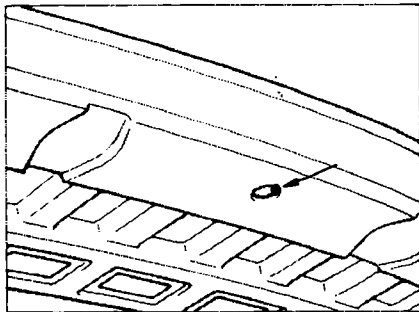
*1: 655 (25.79)
mm (in.)

Symbol	Nomenclature	Hole dia.
A, a	Front fender installation nut – front	6 (0.24)
B, b	Front spring support hole – inner	11 (0.43)
C, c	Front fender installation nut – rear	6 (0.24)
D	Cowl top panel center mark	—
E	Front side member standard hole (RH)	15 (0.59)
e	Front side member standard hole (LH)	15 (0.59)
F, f	Front side member working hole	15 (0.59)
G	Cooler pipe installation nut	6 (0.24)
g	Radiator support standard hole	9 (0.35)
H, h	Cooler condenser installation hole	10 (0.39)
I, i	Cowl top side panel standard hole	10 (0.39)

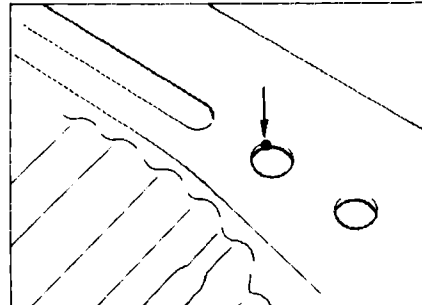
LUGGAGE COMPARTMENT (Liftback)



X Point



Z, z Points

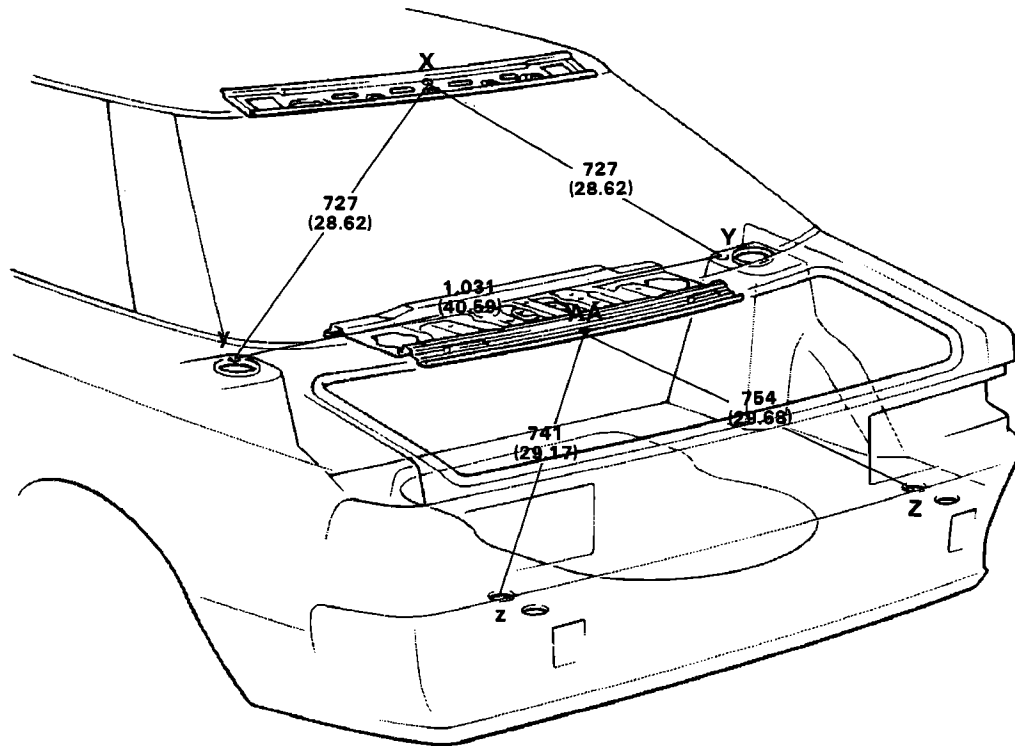


NOTE: The luggage compartment measurement is performed between the two dot marked points as shown in the above figure.

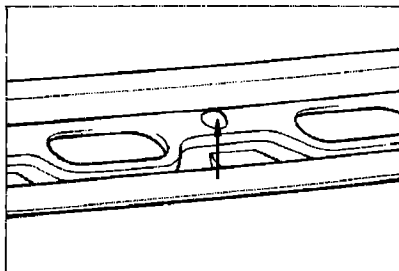
mm (in.)

Symbol	Nomenclature	Hole dia.
X	Back door opening frame standard hole	9 (0.35)
Y, y	Rear spring support hole – front	9.5 (0.374)
Z	Rear floor pan bumper installation hole – front (RH)	40 (1.57)
z	Rear floor pan bumper installation hole – front (LH)	40 (1.57)

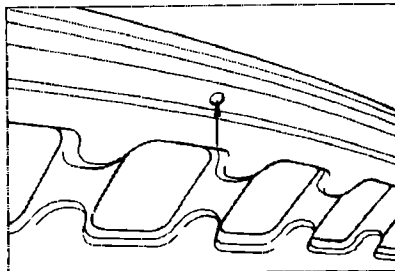
LUGGAGE COMPARTMENT (Coupe)



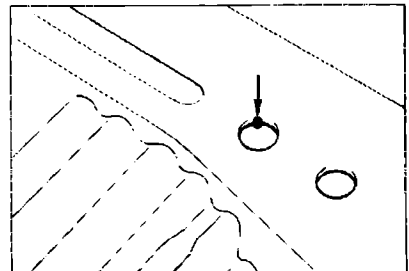
X Point



Z, z Points



AA Point



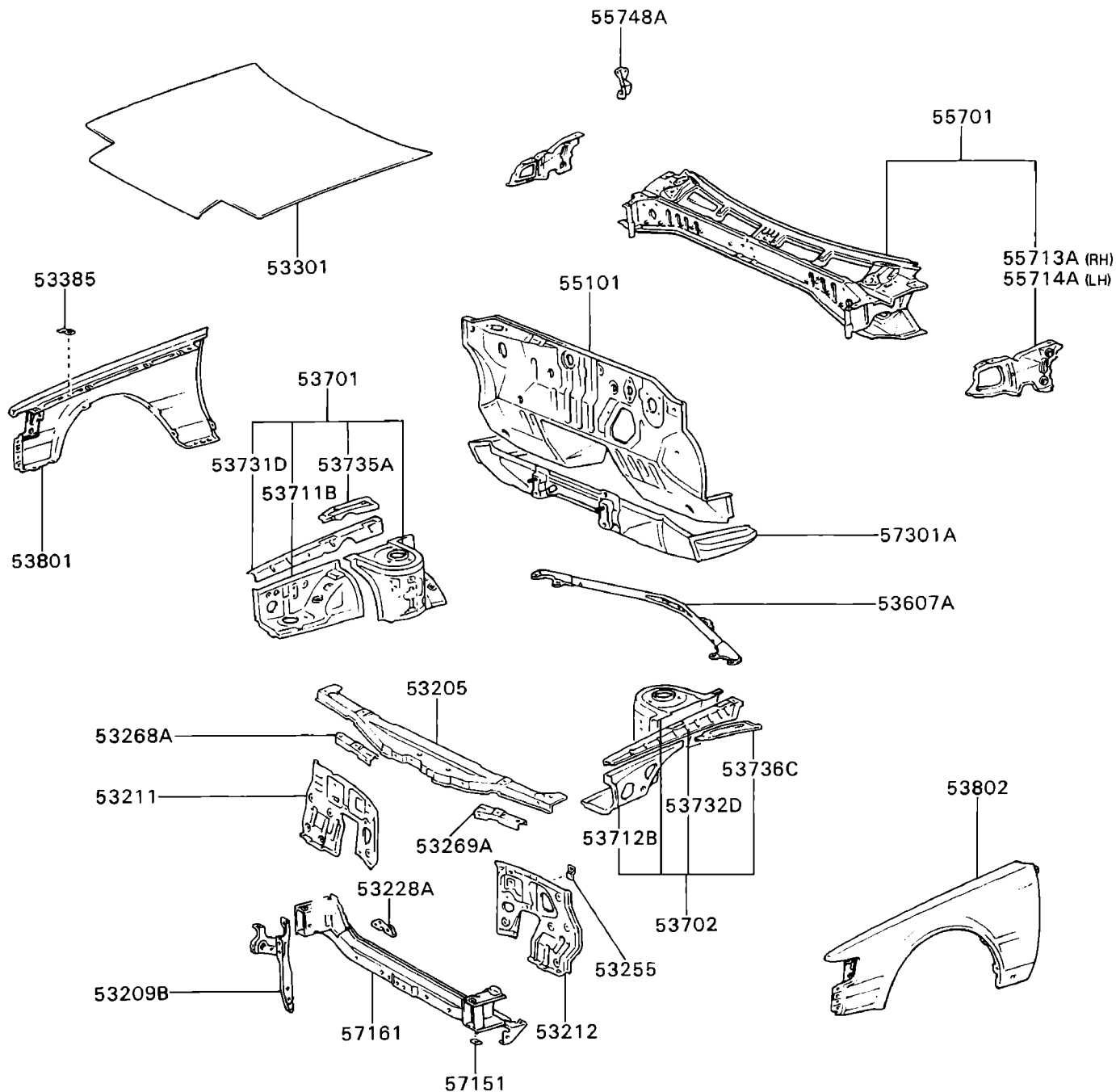
mm (in.)

Symbol	Nomenclature	Hole dia.
X	Back window upper frame center mark	—
Y, y	Rear spring support hole — front	9.5 (0.374)
AA	Upper back reinforcement center mark	—
Z	Rear floor pan bumper installation hole — front (RH)	40 (1.57)
z	Rear floor pan bumper installation hole — front (RH)	40 (1.57)

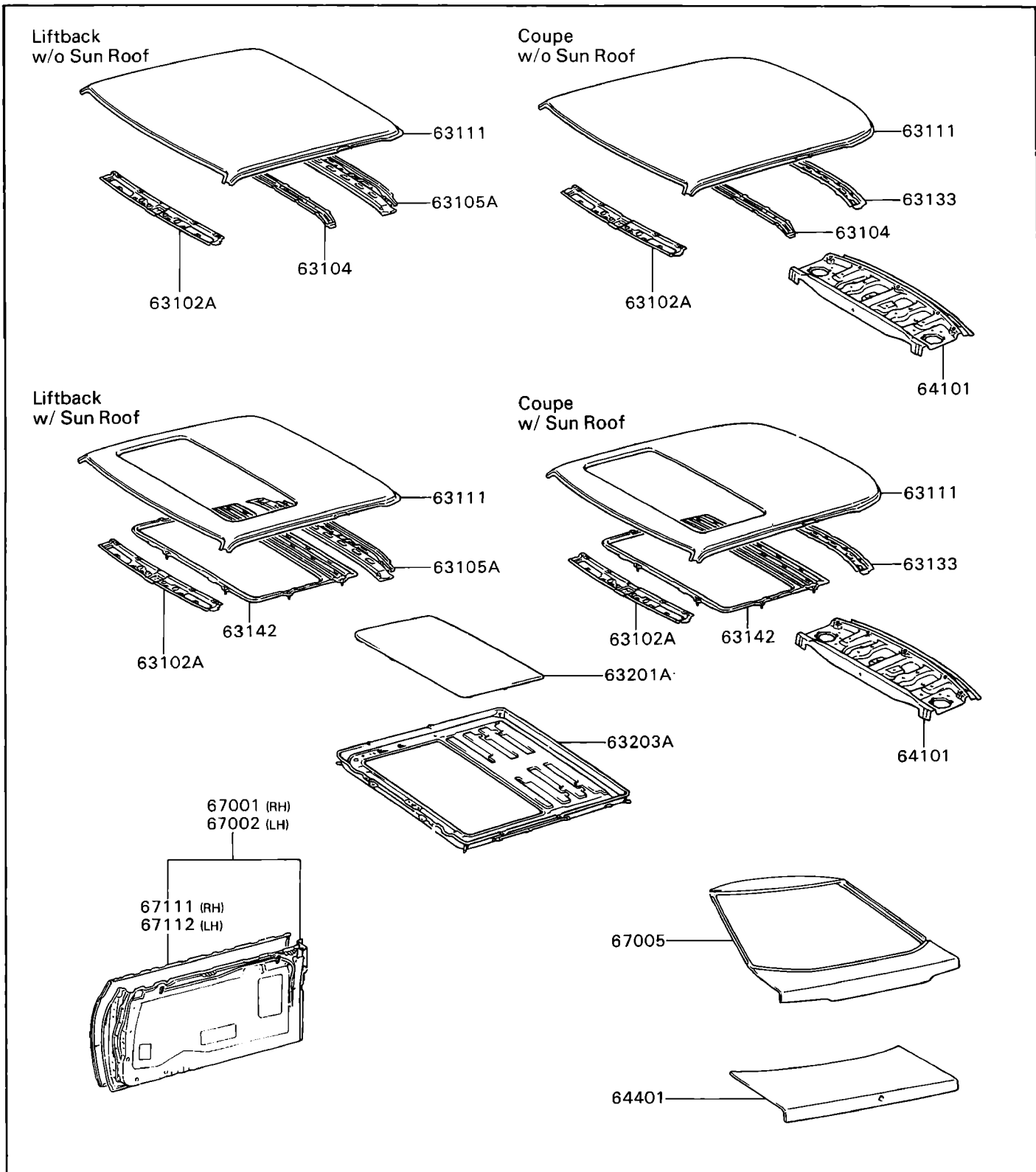
PART LISTS

	Page
PART LISTS	PL-2

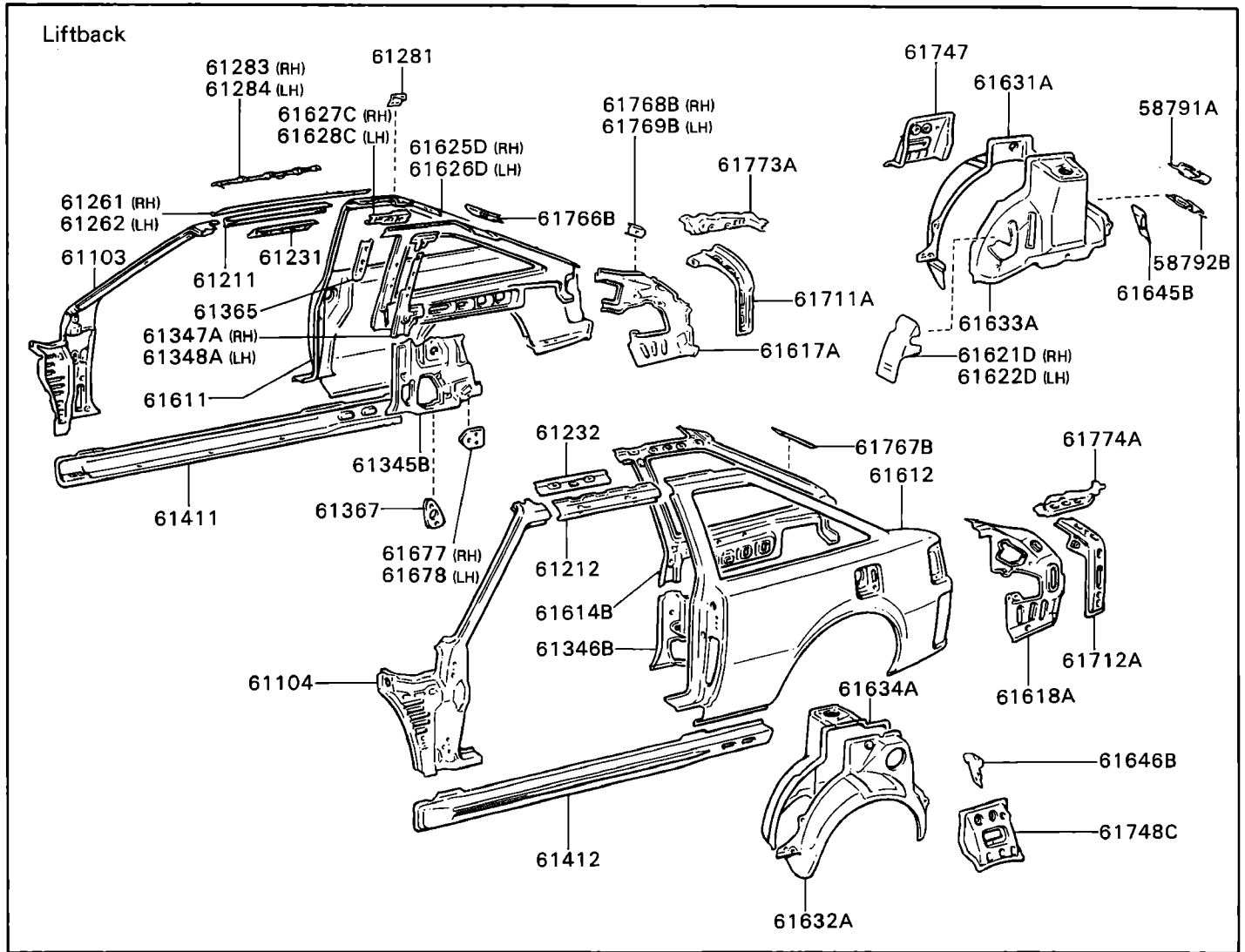




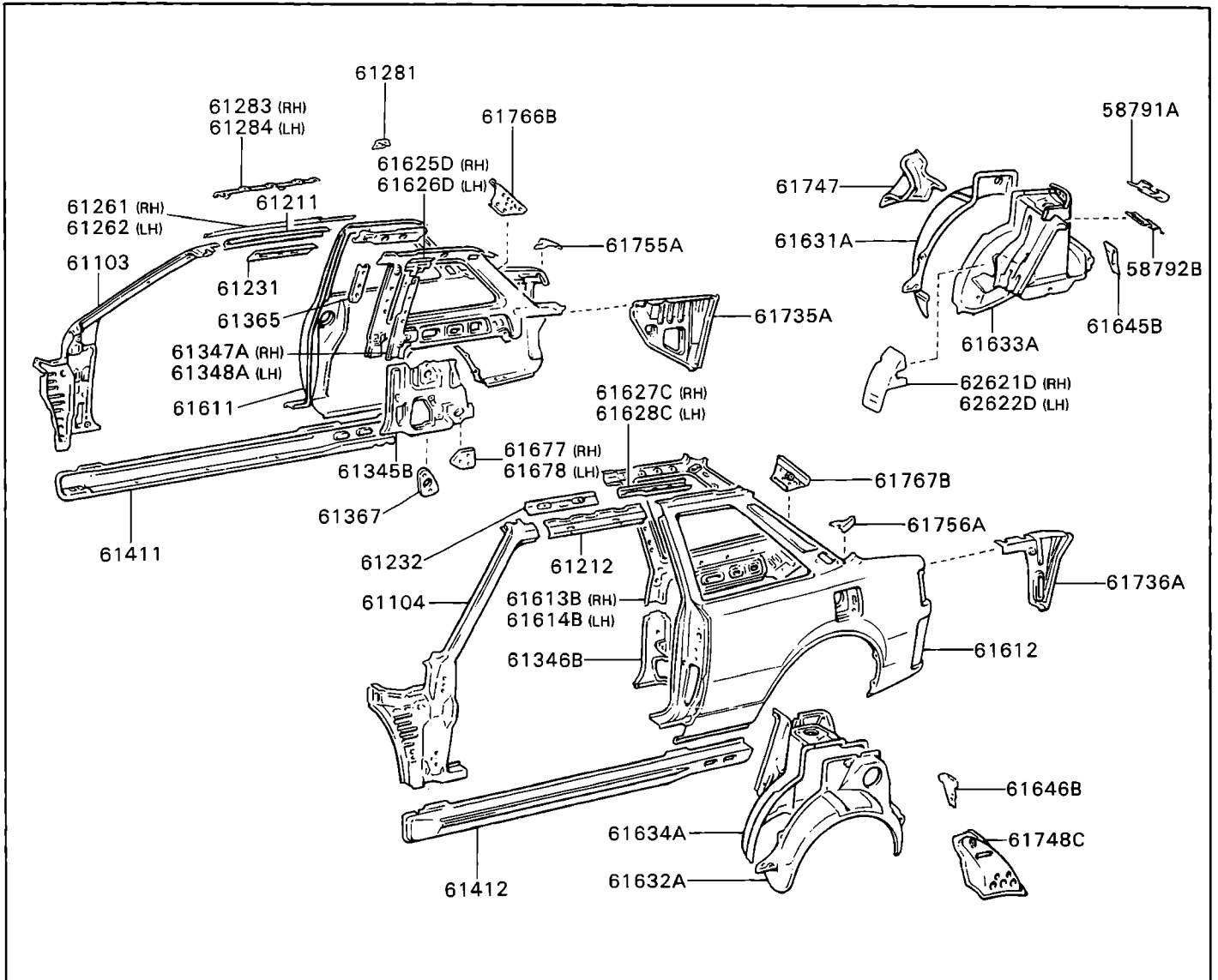
Code	Part Name	Code	Part Name
53205	Radiator Upper Support Sub-Assy	53711B	Front Fender Apron
53209B	Hood Lock Support Brace Sub-Assy	53712B	Front Fender Apron
53211	Radiator Support	53731D	Front Apron to Cowl Side Upper Member
53212	Radiator Support	53732D	Front Apron to Cowl Side Upper Member
53228A	Radiator Mounting Lower No. 1 Bracket	53735A	Front Apron to Cowl Side Lower Member
53255	Relay Box Mounting Bracket	53736C	Front Apron to Cowl Side Lower Member
53268A	Radiator Mounting Reinforcement	53801	Front Fender Sub-Assy
53269A	Radiator Mounting Reinforcement	53802	Dash Panel Sub-Assy
53301	Hood Sub-Assy	55101	Dash Panel Sub-Assy
53385	Hood Bumper Retainer	55701	Cowl Panel Sub-Assy
53607A	Front Suspension Upper Center Brace Sub-Assy	55713A	Cowl Top Side Panel
53701	Front Fender Apron Sub-Assy	55714A	Cowl Top Side Panel
53702	Front Fender Apron Sub-Assy	55748A	Cowl Top Inner to Pillar Brace
-	-	57151	Front Side Member No. 1 Reinforcement
-	-	57161	Front Crossmember
-	-	57301A	Steering Gear Box Support Member Sub-Assy



Code	Part Name	Code	Part Name
63102A	Windshield Header Panel Sub-Assy	64101	Upper Back Panel Sub-Assy
63104	Roof Panel Center Reinforcement Sub-Assy	64401	Luggage Compartment Door Panel Sub-Assy
63105A	Back Door Opening Frame Sub-Assy	67001	Front Door Panel Sub-Assy
63111	Roof Panel	67002	Front Door Panel Sub-Assy
63133	Back Window Opening Upper Frame	67005	Back Door Panel Sub-Assy
63142	Roof Panel No. 2 Reinforcement	67111	Front Door Panel Sub-Assy
63201A	Sliding Roof or Removable Roof Panel Sub-Assy	67112	Front Door Panel Sub-Assy
63203A	Sliding Roof or Removable Roof Housing Sub-Assy	-	-

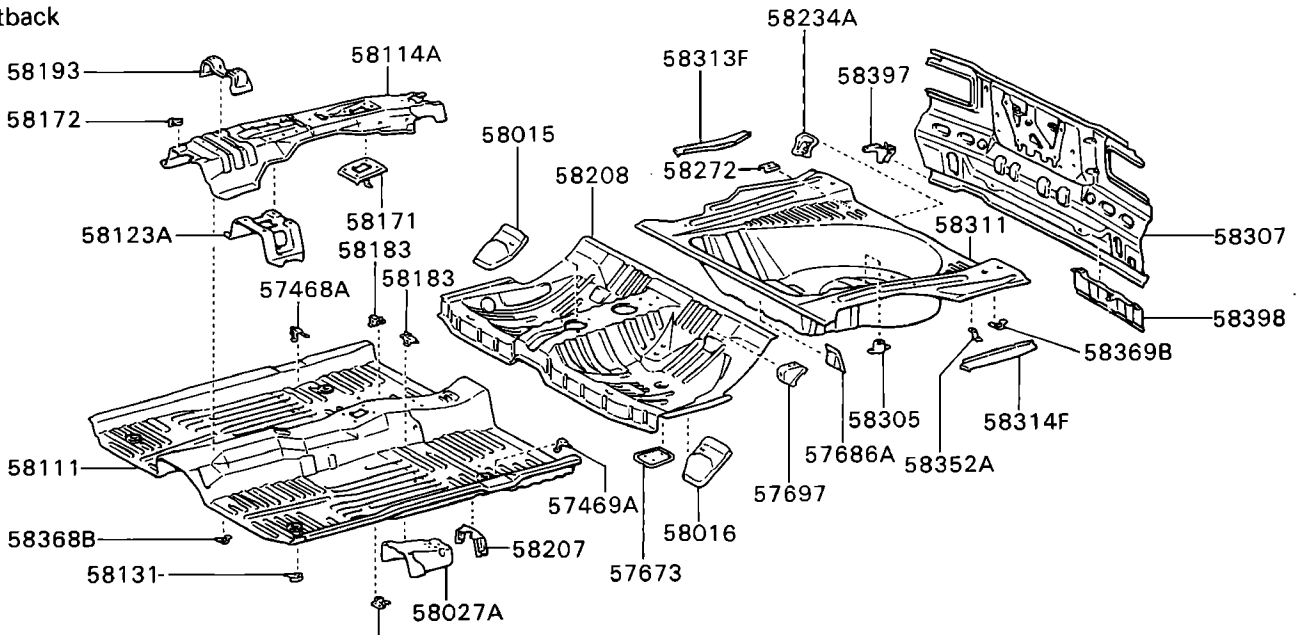


Code	Part Name	Code	Part Name
58791A	Jack Carrier	61617A	Quarter Inner Rear Panel
58792B	Jack Carrier Support	61618A	Quarter Inner Rear Panel
61103	Front Body Pillar Sub-Assy	61621D	Back Door Opening Trough
61104			
61211	Roof Side Outer Rail	61625D	Quarter Panel Upper Front Extension
61212			
61231	Roof Side Inner Rail	61627C	Quarter Inner Panel Reinforcement
61232			
61261	Roof Drip Channel	61631A	Quarter Wheel House Outer Panel
61262			
61281	Sliding Roof Housing Mounting No. 1 Bracket	61632A	Quarter Wheel House Inner Panel
61283	Sliding Roof Housing Mounting No. 3 Bracket	61633A	
61284			
61345B	Center Body Inner Lower Pillar	61634A	Quarter Wheel House Rear Gusset
61346B			
61347A	Belt Anchor to Center Pillar Reinforcement	61645B	Seat Belt Anchor No. 2 Lower Reinforcement
61348A			
61365	Belt Anchor to Center Pillar Reinforcement	61711A	Roof Side Outer Reinforcement
61367	Belt Anchor to Center Pillar Lower Reinforcement	61712A	
61411	Rocker Outer Panel	61747	Roof Side Inner to Wheel House Brace
61412			
61611	Quarter Panel	61766B	Belt Anchor to Roof Side Inner Reinforcement
61612			
61613B	Quarter Inner Front Panel	61768B	Belt Anchor to Roof Side Inner Rear Reinforcement
61614B			
		61773A	Back Door Opening Lower Patch
		61774A	

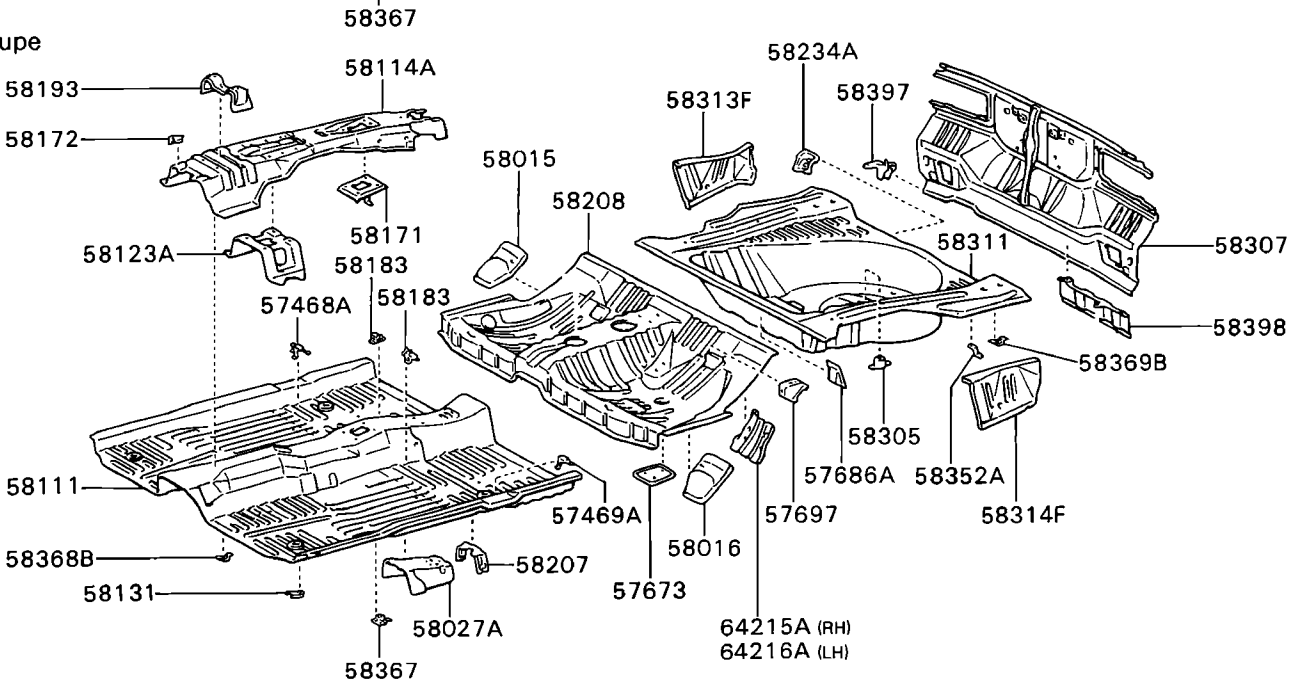


Code	Part Name	Code	Part Name
58791A	Jack Carrier	61613B	Quarter Inner Front Panel
58792B	Jack Carrier Support	61614B	Quarter Inner Front Panel
61103	Front Body Pillar Sub-Assy	61621D	Back Door Opening Trough
61104	Front Body Pillar Sub-Assy	61622D	Back Door Opening Trough
61211	Roof Side Outer Rail	61625D	Quarter Panel Upper Front Extension
61212	Roof Side Inner Rail	61626D	Quarter Panel Upper Front Extension
61231	Roof Side Inner Rail	61627C	Quarter Inner Panel Reinforcement
61232	Roof Side Inner Rail	61628C	Quarter Inner Panel Reinforcement
61261	Roof Drip Channel	61631A	Quarter Wheel House Outer Panel
61262	Roof Drip Channel	61632A	Quarter Wheel House Outer Panel
61281	Sliding Roof Housing Mounting No. 1 Bracket	61633A	Quarter Wheel House Inner Panel
61283	Sliding Roof Housing Mounting No. 3 Bracket	61634A	Quarter Wheel House Inner Panel
61284	Sliding Roof Housing Mounting No. 3 Bracket	61645B	Quarter Wheel House Rear Gusset
61345B	Center Body Inner Lower Pillar	61646B	Quarter Wheel House Rear Gusset
61346B	Center Body Inner Lower Pillar	61677	Seat Belt Anchor No. 2 Lower Reinforcement
61347A	Belt Anchor to Center Pillar Reinforcement	61678	Seat Belt Anchor No. 2 Lower Reinforcement
61348A	Belt Anchor to Center Pillar Reinforcement	61735A	Roof Side Inner Rear Panel
61365	Belt Anchor to Center Pillar Reinforcement	61736A	Roof Side Inner Rear Panel
61367	Belt Anchor to Center Pillar Lower Reinforcement	61747	Roof Side Inner to Wheel House Brace
61411	Rocker Outer Panel	61748C	Roof Side Inner to Wheel House Brace
61412	Rocker Outer Panel	61755A	Deck Side Trim Upper Retainer
61611	Quarter Panel	61756A	Deck Side Trim Upper Retainer
61612	Quarter Panel	61766B	Belt Anchor to Roof Side Inner Reinforcement
		61767B	Belt Anchor to Roof Side Inner Reinforcement

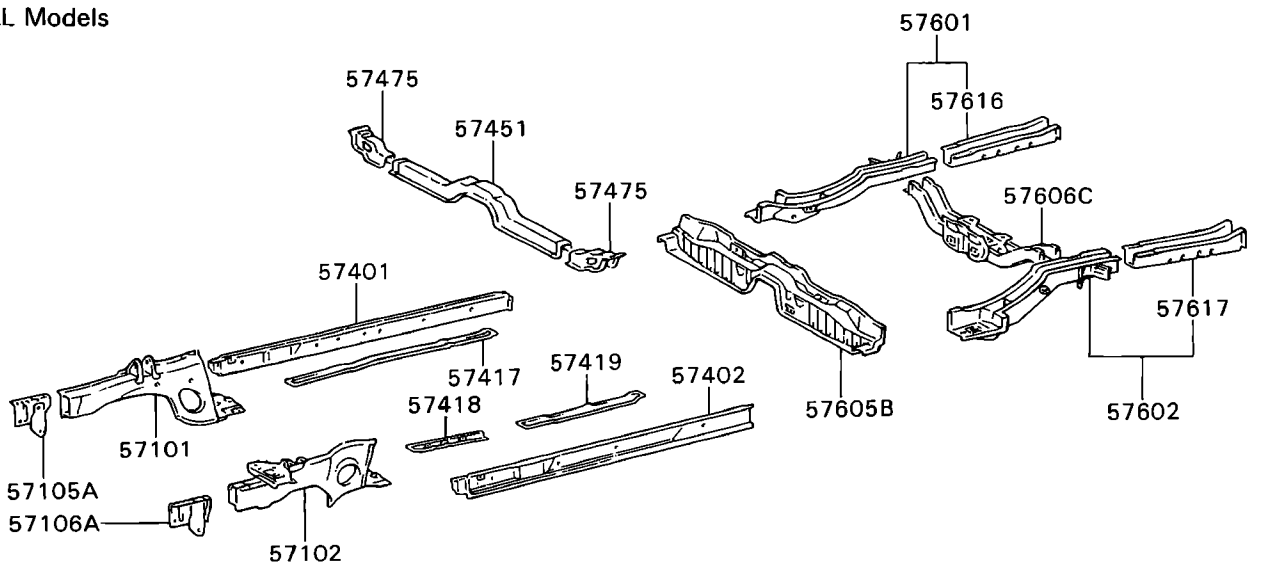
Liftback



Coupe



ALL Models



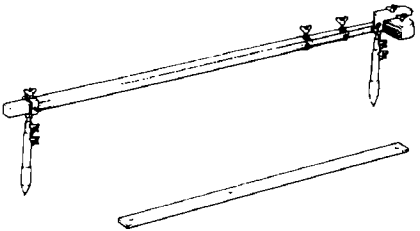
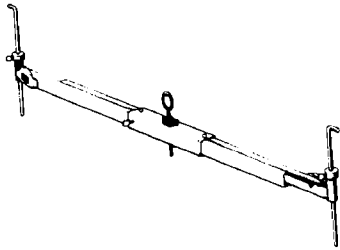
Code	Part Name	Code	Part Name
57101 57102	Front Side Member Sub-Assy	58114A	Front Floor Panel Reinforcement
57105A 57106A	Front Side Member Plate Sub-Assy	58123A	Shift and Select Lever Support
57401 57402	Main Floor Side Member Sub-Assy	58131	Front Floor Heat Insulator No. 1 Bracket
57417 57418	Front Floor Under Reinforcement	58171	Parking Brake Base Reinforcement
57419	Front Floor Under No. 2 Reinforcement	58172	Computer Mounting No. 3 Bracket
57451	Front Floor Crossmember Member	58183	Front Seat Mounting Inside Bracket
57468A 57469A	Front Seat Outside Rear Bracket	58193	Instrument Panel Brace Mounting Bracket
57475	Front Floor Crossmember Plate	58207	Parking Brake Cable No. 1 Bracket Sub-Assy
57601 57602	Rear Floor Side Member Sub-Assy	58208	Center Floor Pan
57605B 57606C	Rear Floor No. 1 Crossmember Sub-Assy	58234A	Exhaust Pipe Mounting Inside Bracket
57616 57617	Rear Floor Rear Side Member	58272	Belt Anchor Front Plate
57673	Rear Seat Back Hinge Mounting Bracket	58305	Spare Wheel Clamp Bracket Sub-Assy
57686A	Fuel Tank Mounting Rear Bracket	58307	Body Lower Back Panel Sub-Assy
57697	Rear Seat Cushion Retainer	58311	Rear Floor Pan
58015 58016	Belt Anchor to Floor Pan Reinforcement	58313F 58314F	Rear Floor Pan to Quarter Panel Extension
58027A	Seat Belt Anchor Reinforce Sub-Assy	58352A	Rear Floor Stay Bracket
58111	Front Floor Pan	58367	Fuel Tube Clamp Bracket
		58368B	Fuel Tube No. 2 Bracket
		58369B	Fuel Tube No. 3 Bracket
		58397 58398	Lower Back Outer Cover
		64215A 64216A	Rear Floor to Package Tray Extension
		-	-

TOOLS AND EQUIPMENT

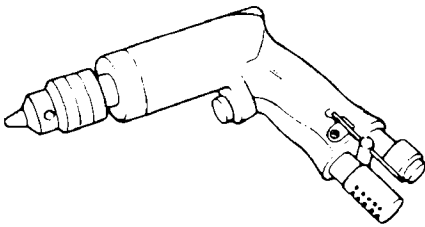
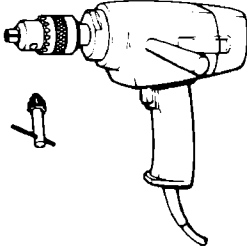
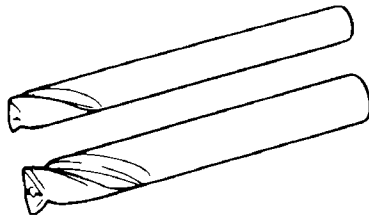
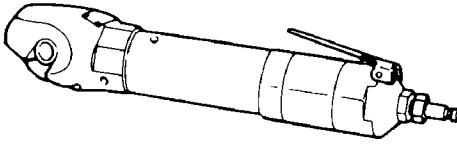
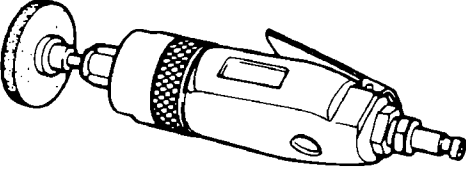
	Page
MEASURING INSTRUMENTS	TE-2
SEPARATING TOOLS	TE-2
INSTALLATION ASSISTANCE TOOLS	TE-4
BODY PROTECTORS	TE-4
WELDING INSTRUMENTS	TE-5
LIGHT BODY REPAIR TOOLS	TE-6
GRINDING AND POLISHING TOOLS	TE-6



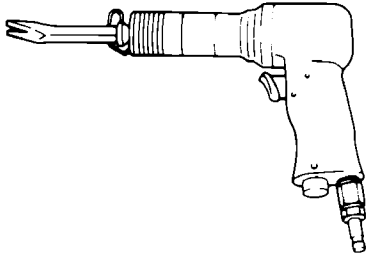
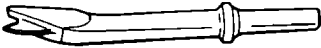
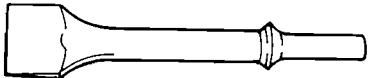
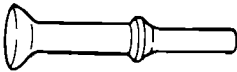
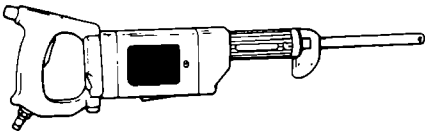
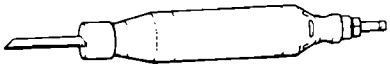
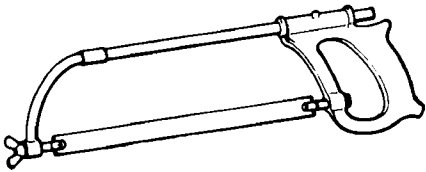
MEASURING INSTRUMENTS

	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.

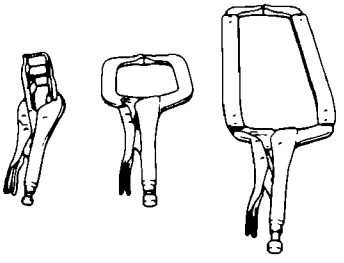
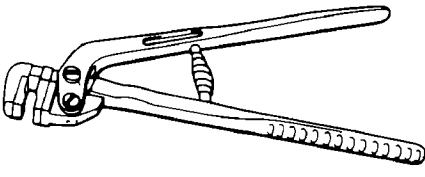
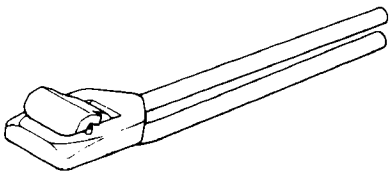
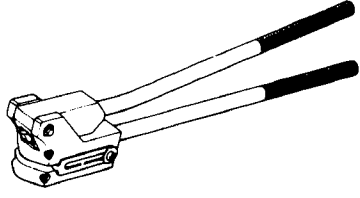
SEPARATING TOOLS

	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.

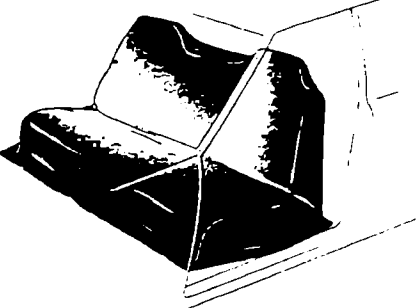
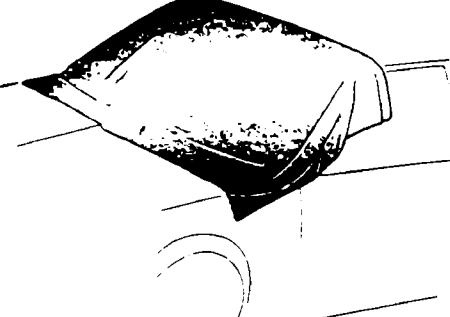
SEPARATING TOOLS (Cont'd)

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

INSTALLATION ASSISTANCE TOOLS

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

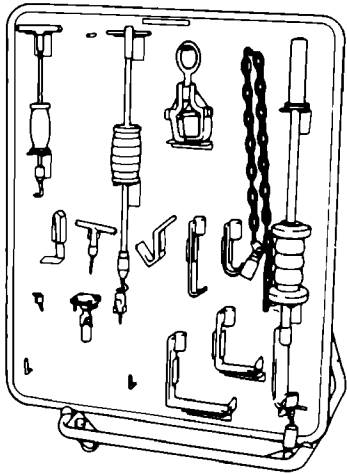
BODY PROTECTORS

	<p>Seat Cover</p>	<p>For protecting the seats from welding sparks, etc.</p>
	<p>Glass Cover</p>	<p>For protecting the glass from welding sparks, etc.</p>

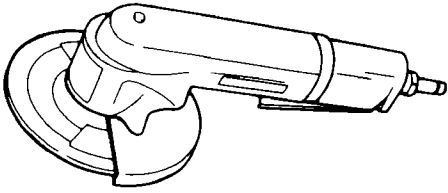
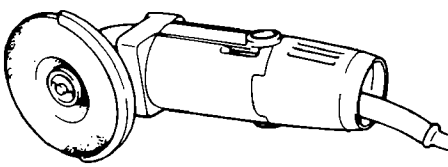
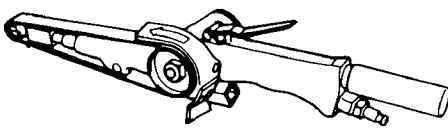
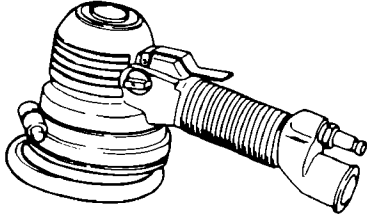
WELDING INSTRUMENTS

<p>A line drawing of a MIG welder. It is a rectangular unit on four casters with a vertical handle on the left side. Two cables, one for the electrode and one for the gas, extend from the front of the unit.</p>	<p>MIG Welder (Metal Inert Gas)</p>	<p>For panel welding.</p>
<p>A line drawing of a spot welder. It is a rectangular unit on four casters with a handle on top. Two large, rounded electrodes are attached to the front of the unit.</p>	<p>Spot Welder</p>	<p>For panel welding.</p>
<p>A line drawing showing two types of gas torches. The top one is a gas welder torch with a long handle and a nozzle. The bottom one is a gas cutter torch, which has a similar handle but a different nozzle design for cutting.</p>	<p>Gas Welder Torch Gas Cutter Torch</p>	<p>For rough cutting of panels, members, etc.</p>
<p>A line drawing of an acetylene gas torch. It has a long, curved handle and a nozzle at the end.</p>	<p>Acetylene Gas Torch</p>	<p>For soldering and peeling of paint.</p>
<p>A line drawing of a straightening machine. It is a rectangular unit with a handle on top and a large, curved metal plate on the front for supporting a panel.</p>	<p>Straightening Machine</p>	<p>For straightening distorted panels.</p>
<p>A line drawing of a panel extractor. It is a rectangular unit on four casters with a handle on top. A large, circular metal plate is attached to the front of the unit.</p>	<p>Panel Extractor</p>	<p>For extraction of closed-in panels.</p>

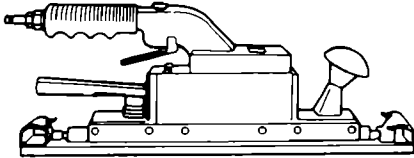
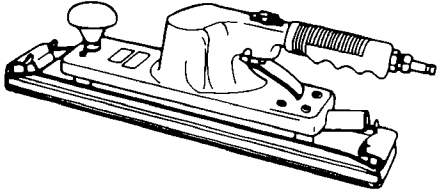
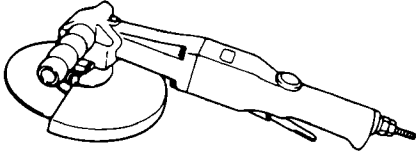

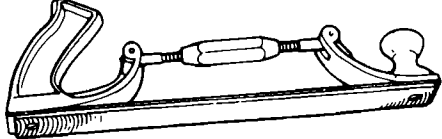
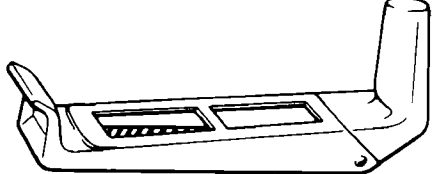
LIGHT BODY REPAIR TOOLS

	<p>Body Pullers</p>	<p>For straightening lightly damaged panels.</p>
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GRINDING AND POLISHING TOOLS

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

GRINDING AND POLISHING TOOLS (Cont'd)

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

