

SECTION **BRM**  
BODY REPAIR

A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
L  
M  
N  
O  
P

CONTENTS

<b>COUPE (REGULAR GRADE)</b>	
<b>VEHICLE INFORMATION</b> .....	3
<b>BODY EXTERIOR PAINT COLOR</b> .....	3
Body Exterior Paint Color .....	3
<b>PRECAUTION</b> .....	4
<b>REPAIRING HIGH STRENGTH STEEL</b> .....	4
High Strength Steel (HSS) .....	4
Handling of Ultra High Strength Steel Plate Parts.....	6
<b>PREPARATION</b> .....	7
<b>REPAIRING MATERIAL</b> .....	7
Foam Repair .....	7
<b>BODY COMPONENT PARTS</b> .....	9
Underbody Component Parts .....	9
Body Component Parts .....	11
<b>REMOVAL AND INSTALLATION</b> .....	13
<b>CORROSION PROTECTION</b> .....	13
Description .....	13
Undercoating .....	13
Body Sealing .....	14
<b>BODY CONSTRUCTION</b> .....	18
Body Construction .....	18
Rear Fender Hemming Process .....	19
<b>REPLACEMENT OPERATIONS</b> .....	21
Description .....	21
Radiator Core Support .....	23
Hoodledge .....	23
Front Side Member .....	26
Front Side Member (Partial Replacement) .....	29
Front Pillar (Partial Replacement) .....	30
Front Pillar .....	32
Outer Sill (Partial Replacement by Cutting) .....	36
Outer Sill (Partial Replacement by Piece) .....	37
Outer Sill .....	38
Rear Fender .....	42
Rear Fender Extension .....	45
Lock Pillar Reinforcement .....	45
Rear Panel .....	47
Rear Floor Rear .....	47
Rear Side Member Extension .....	48
<b>SERVICE DATA AND SPECIFICATIONS (SDS)</b> .....	50
<b>BODY ALIGNMENT</b> .....	50
Body Center Marks .....	50
Description .....	51
Engine Compartment .....	51
Underbody .....	53
Passenger Compartment .....	56
Rear Body .....	57
<b>LOCATION OF PLASTIC PARTS</b> .....	60
Precautions for Plastics .....	60
Location of Plastic Parts .....	61
<b>COUPE (Nismo 370Z)</b>	
<b>SPEC CHANGE INFORMATION</b> .....	63
<b>BODY EXTERIOR PAINT COLOR</b> .....	63
Body Exterior Paint Color (NISMO models) .....	63
<b>REMOVAL AND INSTALLATION</b> .....	64
<b>HANDLING PRECAUTIONS</b> .....	64
Precautions for Plastics .....	64
Location of Plastic Parts (NISMO models) .....	65
<b>ROADSTER</b>	
<b>VEHICLE INFORMATION</b> .....	66
<b>BODY EXTERIOR PAINT COLOR</b> .....	66
Body Exterior Paint Color .....	66
<b>PRECAUTION</b> .....	67

BRM

<b>REPAIRING HIGH STRENGTH STEEL</b> .....	<b>67</b>	Front Side Member .....	89
High Strength Steel (HSS) .....	67	Front Side Member (Partial Replacement) .....	92
Handling of Ultra High Strength Steel Plate Parts..	69	Front Pillar .....	93
<b>PREPARATION</b> .....	<b>70</b>	Outer Sill .....	95
<b>REPAIRING MATERIAL</b> .....	<b>70</b>	Rear Fender .....	99
Foam Repair .....	70	Rear Fender Extension .....	102
<b>BODY COMPONENT PARTS</b> .....	<b>72</b>	Lock Pillar Reinforcement .....	102
Underbody Component Parts .....	72	Rear Panel .....	104
Body Component Parts .....	74	Rear Floor Rear .....	104
<b>REMOVAL AND INSTALLATION</b> .....	<b>76</b>	Rear Side Member Extension .....	105
<b>CORROSION PROTECTION</b> .....	<b>76</b>	<b>SERVICE DATA AND SPECIFICATIONS</b>	
Description .....	76	<b>(SDS)</b> .....	<b>107</b>
Undercoating .....	76	<b>BODY ALIGNMENT</b> .....	<b>107</b>
Body Sealing .....	77	Body Center Marks .....	107
<b>BODY CONSTRUCTION</b> .....	<b>81</b>	Description .....	108
Body Construction .....	81	Engine Compartment .....	108
Rear Fender Hemming Process .....	82	Underbody .....	110
<b>REPLACEMENT OPERATIONS</b> .....	<b>84</b>	Passenger Compartment .....	113
Description .....	84	Soft Top Mounting Bracket .....	114
Radiator Core Support .....	86	Rear Body .....	117
Hoodledge .....	86	<b>LOCATION OF PLASTIC PARTS</b> .....	<b>120</b>
		Precautions for Plastics .....	120
		Location of Plastic Parts .....	121

# BODY EXTERIOR PAINT COLOR

< VEHICLE INFORMATION >

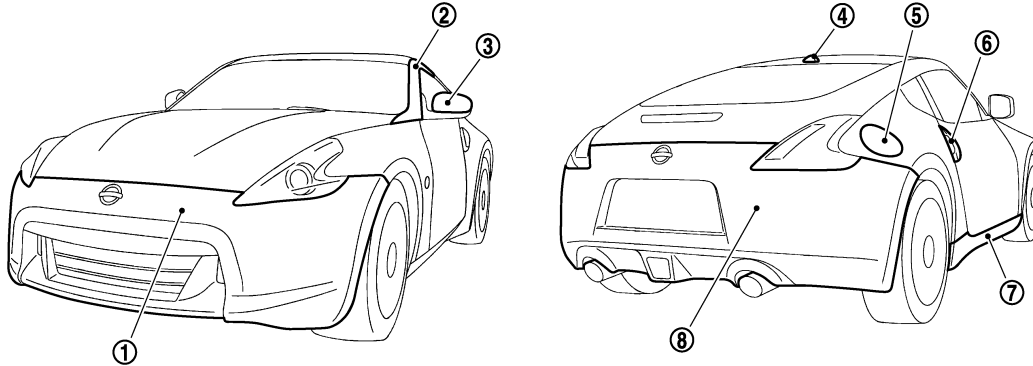
[COUPE (REGULAR GRADE)]

## VEHICLE INFORMATION

### BODY EXTERIOR PAINT COLOR

#### Body Exterior Paint Color

INFOID:000000006353775



JSKIA0899ZZ

Component			Color code	BA54	BG41	BK23	BKAD	BNAG	BQAB	BRAE
			Description	Red	Black	Silver	Gray	Dark Red	White	Blue
			Paint type <sup>note</sup>	CS	P	M	M	PM	3P	3P
			Hard clear coat	For Mexico	-	-	-	-	-	-
Except for Mexico	×	×		-	-	×	-	×		
1	Front bumper fascia	Body	Body color	BA54	BG41	BK23	BKAD	BNAG	BQAB	BRAE
		Grille	Material color	-	-	-	-	-	-	-
2	Front pillar finisher	Body color	BA54	BG41	BK23	BKAD	BNAG	BQAB	BRAE	
3	Door outside mirror	Cover	Body color	BA54	BG41	BK23	BKAD	BNAG	BQAB	BRAE
4	Antenna base cover	Body color	BA54	BG41	BK23	BKAD	BNAG	BQAB	BRAE	
5	Fuel filler lid	Body color	BA54	BG41	BK23	BKAD	BNAG	BQAB	BRAE	
6	Door outside handle and escutcheon	Velour chromium plate	Cr2p	Cr2p	Cr2p	Cr2p	Cr2p	Cr2p	Cr2p	Cr2p
7	Center mudguard	Body color	BA54	BG41	BK23	BKAD	BNAG	BQAB	BRAE	
8	Rear bumper fascia	Body color	BA54	BG41	BK23	BKAD	BNAG	BQAB	BRAE	

**NOTE:**

- S: Solid
- 2S: Solid + Clear
- CS: Color clear solid
- M: Metallic
- P: 2-Coat pearl
- 3P: 3-Coat pearl
- FPM: Iron oxide pearl
- TPM: Titanium pearl metallic
- RM, RPM: Multi flex color
- TM: Micro titanium metallic
- PM: Pearl metallic

A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
K  
L  
M  
N  
O  
P

BRM

# REPAIRING HIGH STRENGTH STEEL

< PRECAUTION >

[COUPE (REGULAR GRADE)]

## PRECAUTION

### REPAIRING HIGH STRENGTH STEEL

#### High Strength Steel (HSS)

INFOID:000000006353776

High strength steel is used for body panels in order to reduce vehicle weight.

Accordingly, precautions in repairing automotive bodies made of high strength steel are described below:

Tensile strength	Major applicable parts
370 - 590 MPa	<ul style="list-style-type: none"> <li>• Front side member assembly</li> <li>• Front side member closing plate assembly</li> <li>• Front side member outrigger assembly</li> <li>• Upper front hoodledge</li> <li>• Hoodledge reinforcement</li> <li>• Front strut housing</li> <li>• Lower dash</li> <li>• Lower dash crossmember assembly</li> <li>• Front roof rail</li> <li>• Upper front pillar reinforcement</li> <li>• Center front floor</li> <li>• Front floor (Component part)</li> <li>• Outer sill reinforcement</li> <li>• Inner rear pillar (Component part)</li> <li>• Outer rear wheelhouse extension</li> <li>• Lock pillar reinforcement assembly</li> <li>• Rear seat crossmember</li> <li>• Rear seat crossmember reinforcement assembly</li> <li>• Rear side member assembly</li> <li>• Rear pillar reinforcement</li> <li>• Other reinforcements</li> </ul>
780 - 1350 MPa	<ul style="list-style-type: none"> <li>• Upper front pillar reinforcement (Component part)</li> <li>• Stiffener front side member (Front floor component part)</li> <li>• Front side member rear extension</li> <li>• Inner sill</li> <li>• Inner lock pillar assembly (Component part)</li> <li>• Inner rear pillar (Component part)</li> </ul>

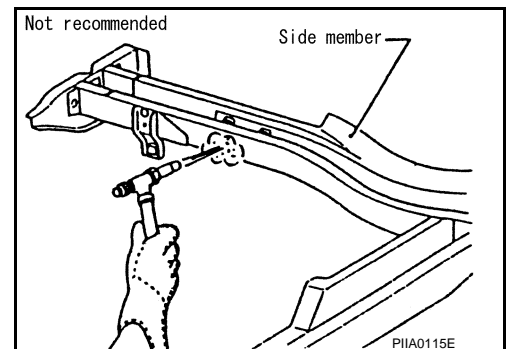
Read the following precautions when repairing HSS:

1. Additional points to consider

- The repair of reinforcements (such as side members) by heating is not recommended, because it may weaken the component. When heating is unavoidable, never heat HSS parts above 550°C (1,022°F).

Verify heating temperature with a thermometer.

(Crayon-type and other similar type thermometer are appropriate.)



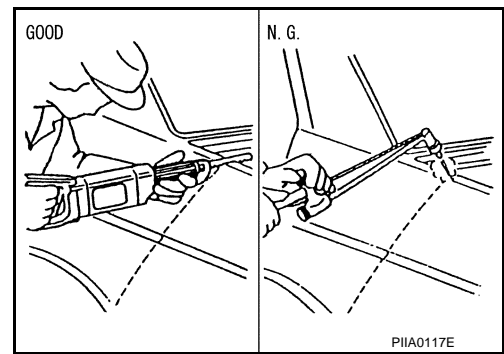
- When straightening body panels, use caution in pulling any HSS panel. Because HSS is very strong, pulling may cause deformation in adjacent sections of the body. In this case, increase the number of measuring points, and carefully pull the HSS panel.

# REPAIRING HIGH STRENGTH STEEL

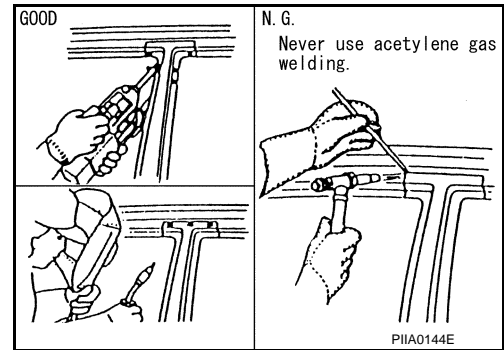
[COUPE (REGULAR GRADE)]

## < PRECAUTION >

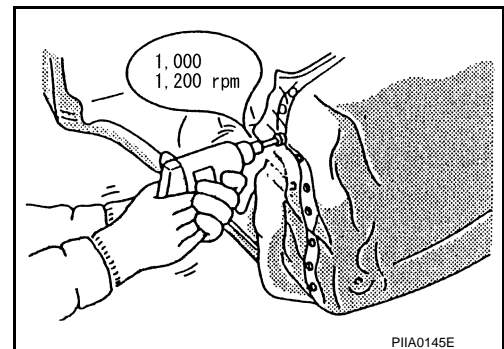
- When cutting HSS panels, avoid gas (torch) cutting if possible. Instead, use a saw to avoid weakening surrounding areas due to heat. If gas (torch) cutting is unavoidable, allow a minimum margin of 50 mm (1.97 in).



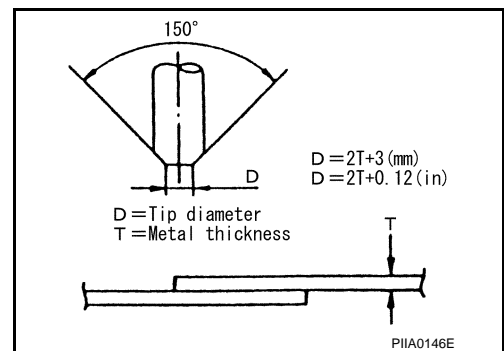
- When welding HSS panels, use spot welding whenever possible in order to minimize weakening surrounding areas due to heat. If spot welding is impossible, use MIG. welding. Do not use gas (torch) for welding because it is inferior in welding strength.



- Spot welding on HSS panels is harder than that of an ordinary steel panel. Therefore, when cutting spot welds on a HSS panel, use a low speed high torque drill (1,000 to 1,200 rpm) to increase drill bit durability and facilitate the operation.



- Precautions in spot welding HSS  
This work should be performed under standard working conditions. Always note the following when spot welding HSS:
  - The electrode tip diameter must be sized properly according to the metal thickness.



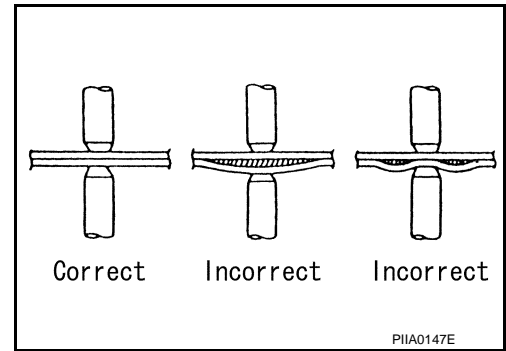
A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
BRM  
L  
M  
N  
O  
P

# REPAIRING HIGH STRENGTH STEEL

[COUPE (REGULAR GRADE)]

## < PRECAUTION >

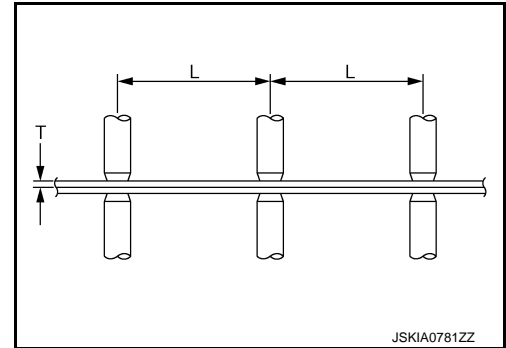
- The panel surfaces must fit flush to each other, leaving no gaps.



- Follow the specifications for the proper welding pitch.

Unit: mm (in)

Thickness (T)	Minimum pitch (L)
0.6 (0.024)	10 (0.39) or more
0.8 (0.031)	12 (0.47) or more
1.0 (0.039)	18 (0.71) or more
1.2 (0.047)	20 (0.79) or more
1.6 (0.063)	27 (1.06) or more
1.8 (0.071)	31 (1.22) or more



## Handling of Ultra High Strength Steel Plate Parts

INFOID:000000006353777

### PROHIBITION OF CUT AND CONNECTION

Never cut and Joint the stiffener front side member (front floor inside frame parts) because its material is high strength steel plate (ultra high strength steel plate).

The front floor assembly must be replaced if this part is damaged.

PREPARATION

REPAIRING MATERIAL

Foam Repair

INFOID:000000006353778

During factory body assembly, foam insulators are installed in certain body panels and locations around the vehicle. Use the following procedure(s) to replace any factory-installed foam insulators.

URETHANE FOAM APPLICATIONS

Use commercially available Urethane foam for sealant (foam material) repair of material used on vehicle.

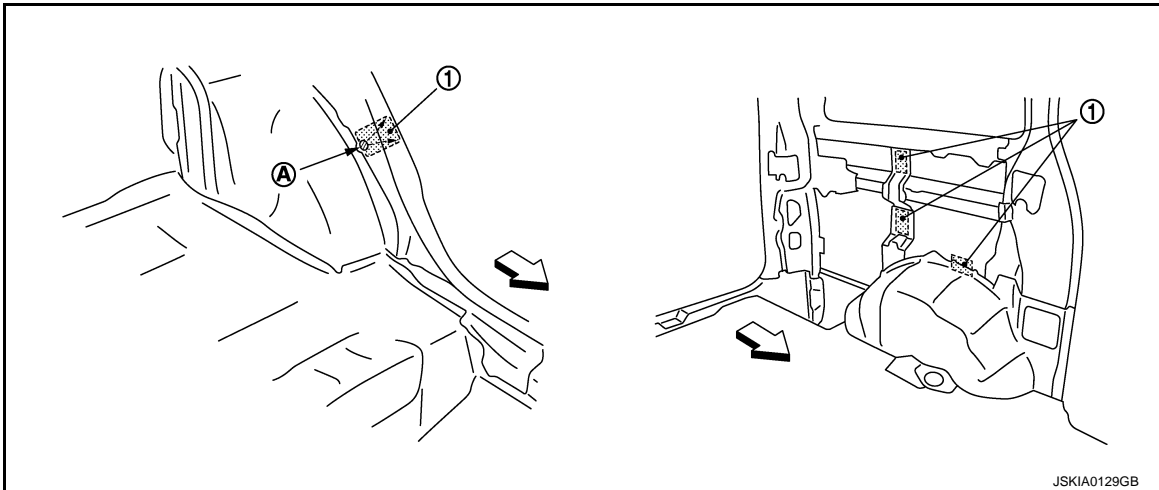
<Urethane foam for foaming agent>

3M™ Automix™ Flexible Foam 08463 or equivalent

Read instructions on product for fill procedures.

Example of foaming agent filling operation procedure

1. Fill procedures after installation of service part.
  - a. Eliminate foam material remaining on vehicle side.
  - b. Clean area after eliminating form insulator and foam material.
  - c. Install service part.
  - d. Insert nozzle into hole near fill area and fill foam material or fill enough to close gap with the service part.



1. Urethane foam
- A. Nozzle insert hole

↔: Vehicle front

2. Fill procedures before installation of service part.
  - a. Eliminate foam material remaining on vehicle side.
  - b. Clean area after eliminating foam insulator and foam material.
  - c. Fill foam material on wheelhouse outer side.

A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
L  
M  
N  
O  
P

BRM

# REPAIRING MATERIAL

< PREPARATION >

[COUPE (REGULAR GRADE)]

- 1. Urethane foam
  - A. Fill while avoiding flange area
- ← Vehicle front

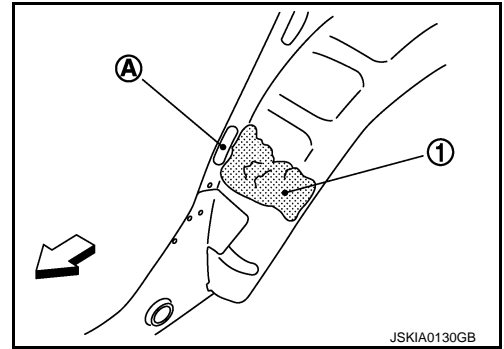
**NOTE:**

Fill enough to close gap with service part while avoiding flange area.

- d. Install service part.

**NOTE:**

Refer to label for information on working times.





# BODY COMPONENT PARTS

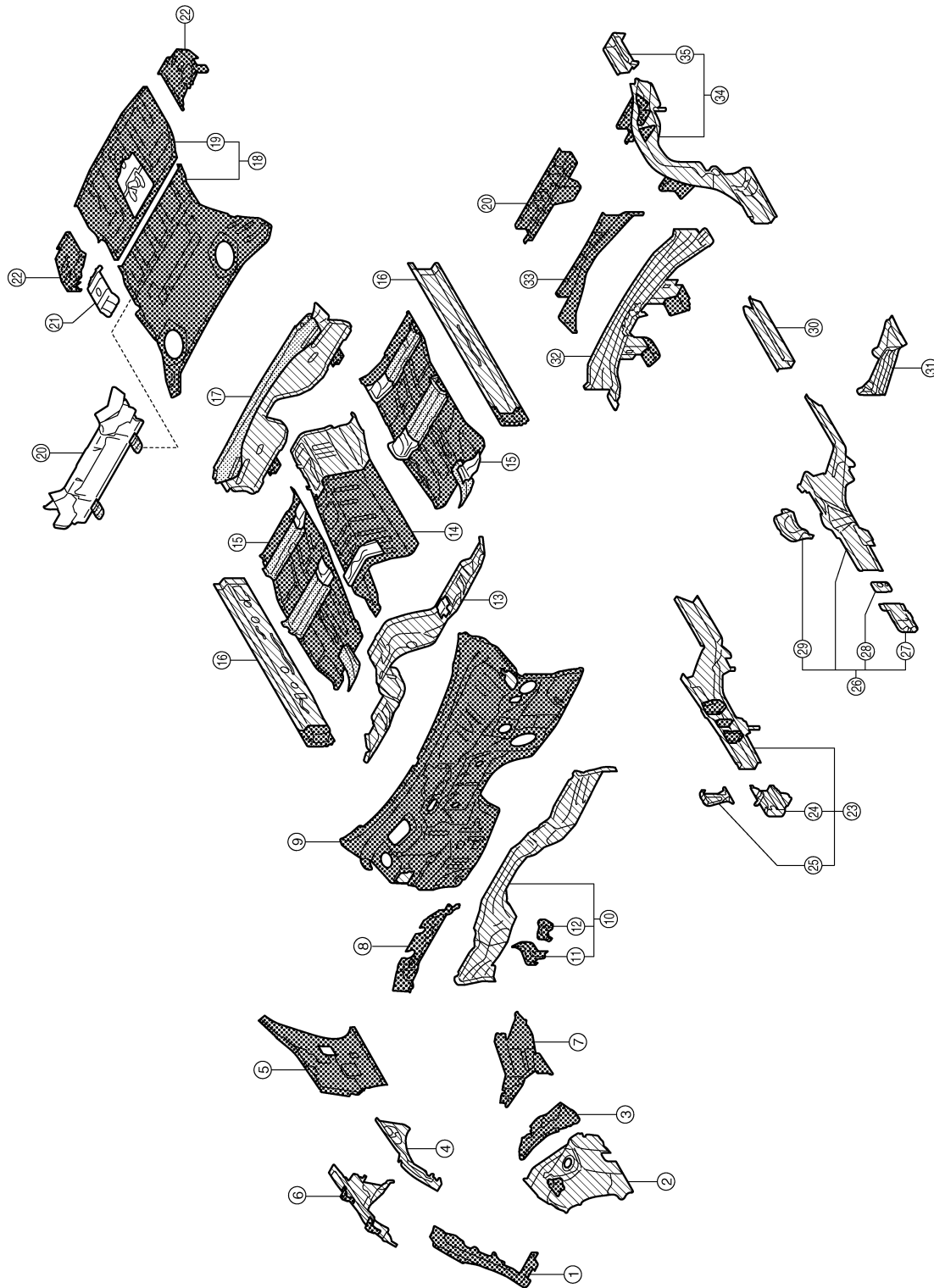
< PREPARATION >

[COUPE (REGULAR GRADE)]

## BODY COMPONENT PARTS

### Underbody Component Parts

INFOID:000000006353779



- |   |                                   |                                      |
|---|-----------------------------------|--------------------------------------|
| 1. Side radiator core support (RH & LH) | 2. Front strut housing (RH & LH)  | 3. Lower rear hoodledge (RH & LH)    |
| 4. Upper front hoodledge (RH & LH)      | 5. Upper rear hoodledge (RH & LH) | 6. Hoodledge reinforcement (RH & LH) |
| 7. Upper side cowl top (RH & LH)        | 8. Front cowl top                 | 9. Upper dash                        |


JSKIA0900ZZ


# BODY COMPONENT PARTS


< PREPARATION >

[COUPE (REGULAR GRADE)]

- |   |  |   |
|---|--|---|
| 10. Lower dash crossmember assembly                 | 11. Lower outer battery support bracket                | 12. Lower battery support bracket                   |
| 13. Lower dash                                      | 14. Center front floor                                 | 15. Front floor (RH & LH)                           |
| 16. Inner sill (RH & LH)                            | 17. Rear seat crossmember reinforcement assembly       | 18. Rear floor front                                |
| 19. Rear floor rear                                 | 20. Rear crossmember center assembly                   | 21. Sensor bracket                                  |
| 22. Rear floor side (RH & LH)                       | 23. Front side member assembly (RH & LH)               | 24. Front side member front extension (RH & LH)     |
| 25. Front side member connector assembly (RH & LH)  | 26. Front side member closing plate assembly (RH & LH) | 27. Front side member front closing plate (RH & LH) |
| 28. Front side rear closing reinforcement (RH & LH) | 29. Front side member center closing plate (RH & LH)   | 30. Front side member rear extension (RH & LH)      |
| 31. Front side member outrigger assembly (RH & LH)  | 32. Rear seat crossmember                              | 33. Rear crossmember                                |
| 34. Rear side member assembly (RH & LH)             | 35. Rear side member extension (RH & LH)               |   |

 Both sided anti-corrosive precoated steel sections

 High strength steel (HSS) sections

 Both sided anti-corrosive steel and HSS sections

**NOTE:**

For the parts without a number described in the figure, it is supplied only with the assembly part that the part is included with.

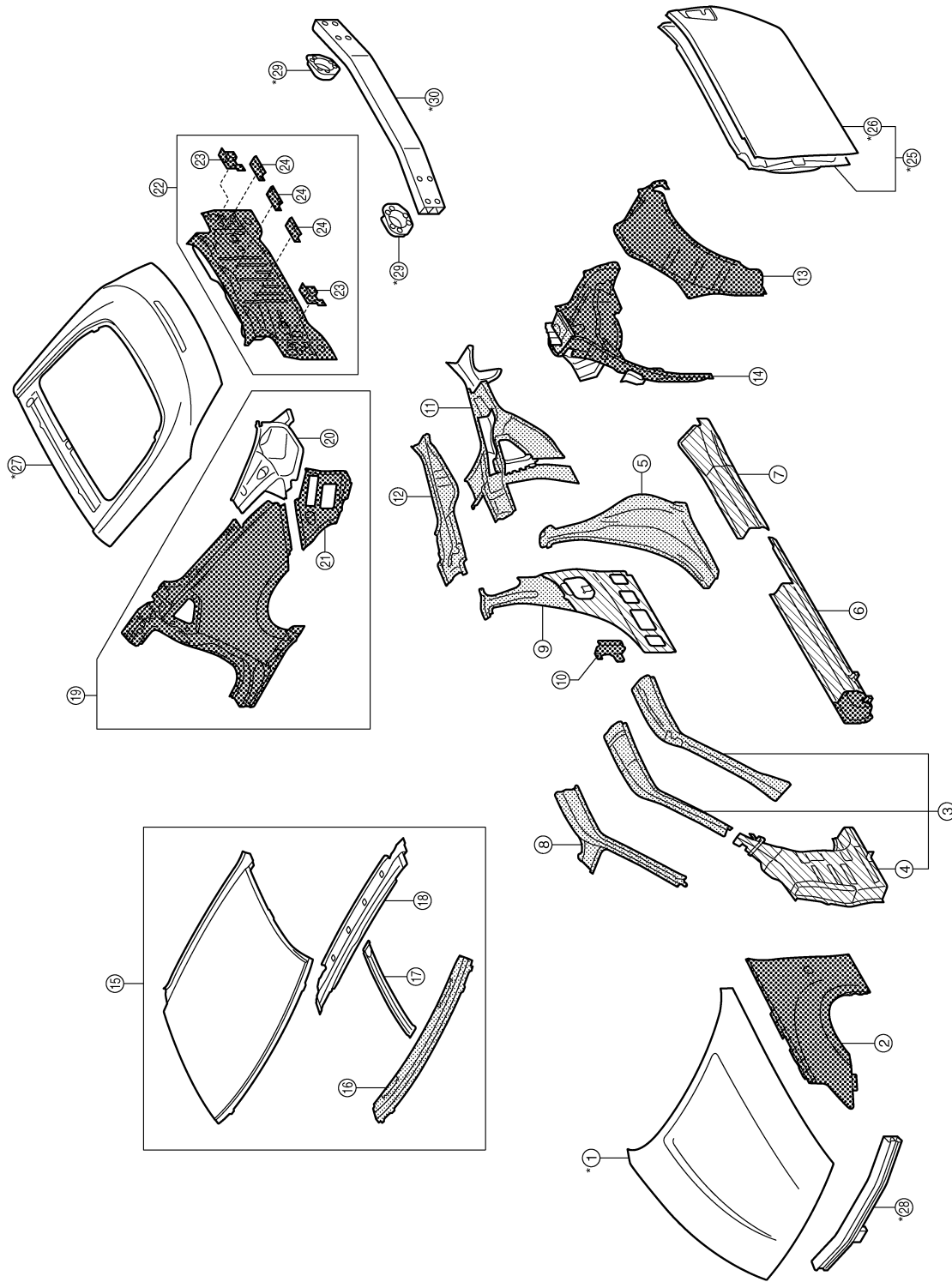
# BODY COMPONENT PARTS

< PREPARATION >

[COUPE (REGULAR GRADE)]

## Body Component Parts

INFOID:000000006353780



A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
K  
L  
M  
N  
O  
P

**BRM**

- |                                 |   |   |
|---------------------------------|---|---|
| 1. Hood                         | 2. Front fender (RH & LH)                       | 3. Upper front pillar reinforcement (RH & LH) |
| 4. Front pillar brace (RH & LH) | 5. Lock pillar reinforcement assembly (RH & LH) | 6. Outer sill reinforcement (RH & LH)         |

JSKIA0901ZZ


# BODY COMPONENT PARTS


< PREPARATION >

[COUPE (REGULAR GRADE)]

7. Outer rear wheelhouse extension (RH & LH)	8. Inner side roof rail (RH & LH)	9. Inner lock pillar assembly (RH & LH)
10. Outer sill brace (RH & LH)	11. Inner rear pillar (RH & LH)	12. Rear pillar reinforcement (RH & LH)
13. Outer rear wheelhouse (RH & LH)	14. Inner rear wheelhouse (RH & LH)	15. Roof
16. Front roof rail	17. Center roof bow	18. Rear roof rail
19. Rear fender assembly (RH & LH)	20. Rear combination lamp base (RH & LH)	21. Rear fender extension (RH & LH)
22. Rear panel assembly	23. Rear bumper fascia center bracket	24. Rear bumper bracket
25. Door assembly (RH & LH)	26. Outer door panel (RH & LH)	27. Back door
28. Front bumper armature assembly	29. Rear bumper stay (RH & LH)	30. Inner center rear bumper reinforcement assembly

 Both sided anti-corrosive precoated steel sections

 High strength steel (HSS) sections

 Both sided anti-corrosive steel and HSS sections

\*: Aluminum portion

## NOTE:

For the parts without a number described in the figure, it is supplied only with the assembly part that the part is included with.

# REMOVAL AND INSTALLATION

## CORROSION PROTECTION

### Description

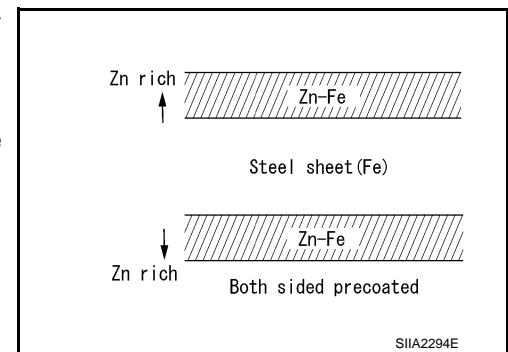
INFOID:000000006353781

To provide improved corrosion prevention, the following anti-corrosive measures have been implemented in NISSAN production plants. When repairing or replacing body panels, it is necessary to use the same anti-corrosive measures.

#### Anti-Corrosive Precoated Steel (Galvannealed Steel)

To improve repairability and corrosion resistance, a new type of anti-corrosive precoated steel sheet is adopted replacing conventional zinc-coated steel sheet.

Galvannealed steel is electroplated and heated to form Zinc-iron alloy, which provides excellent and long term corrosion resistance with cationic electrodeposition primer.



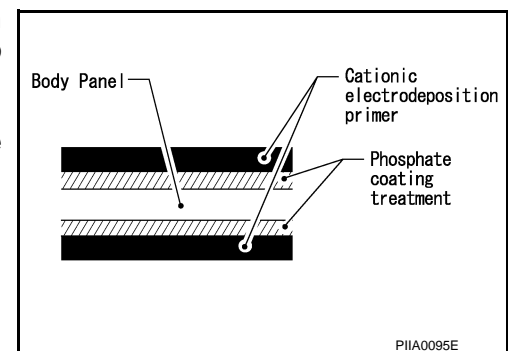
NISSAN genuine parts are fabricated from galvannealed steel. Therefore, it is recommended that NISSAN genuine parts or an equivalent be used for panel replacement to maintain the anti-corrosive performance built into the vehicle at the factory.

#### Phosphate Coating Treatment and Cationic Electrodeposition Primer

A phosphate coating treatment and a cationic electrodeposition primer, which provide excellent corrosion protection, are applied to all body components.

#### **CAUTION:**

**Confine paint removal during welding operation to an absolute minimum.**



NISSAN genuine parts are also treated in the same manner. Therefore, it is recommended that NISSAN genuine parts or an equivalent be used for panel replacement to maintain anti-corrosive performance built into the vehicle at the factory.

### Undercoating

INFOID:000000006353782

The underside of the floor and wheelhouse are undercoated to prevent rust, vibration, noise and stone chipping. Therefore, when such a panel is replaced or repaired, apply undercoating to that part. Use an undercoating which is rust resistant, soundproof, vibration-proof, shock-resistant, adhesive, and durable.

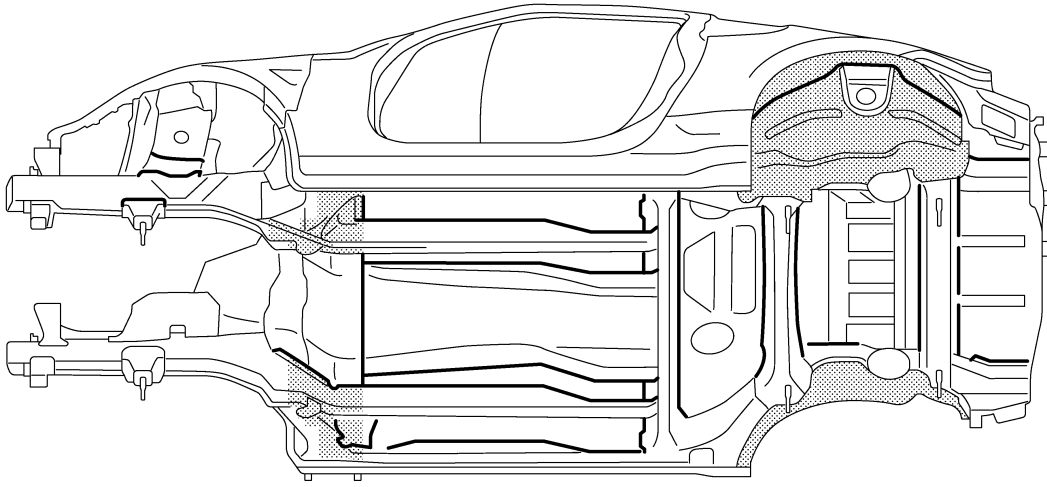
#### Precautions in Undercoating

1. Never apply undercoating to any place unless specified (such as the areas above the muffler and three way catalyst that are subjected to heat).
2. Never undercoat the exhaust pipe or other parts that become hot.
3. Never undercoat rotating parts.
4. Apply bitumen wax after applying undercoating.
5. After putting seal on the vehicle, put undercoating on it.


# CORROSION PROTECTION


< REMOVAL AND INSTALLATION >

[COUPE (REGULAR GRADE)]



JSKIA0897ZZ

 Undercoated areas

 Sealed portions

## Body Sealing

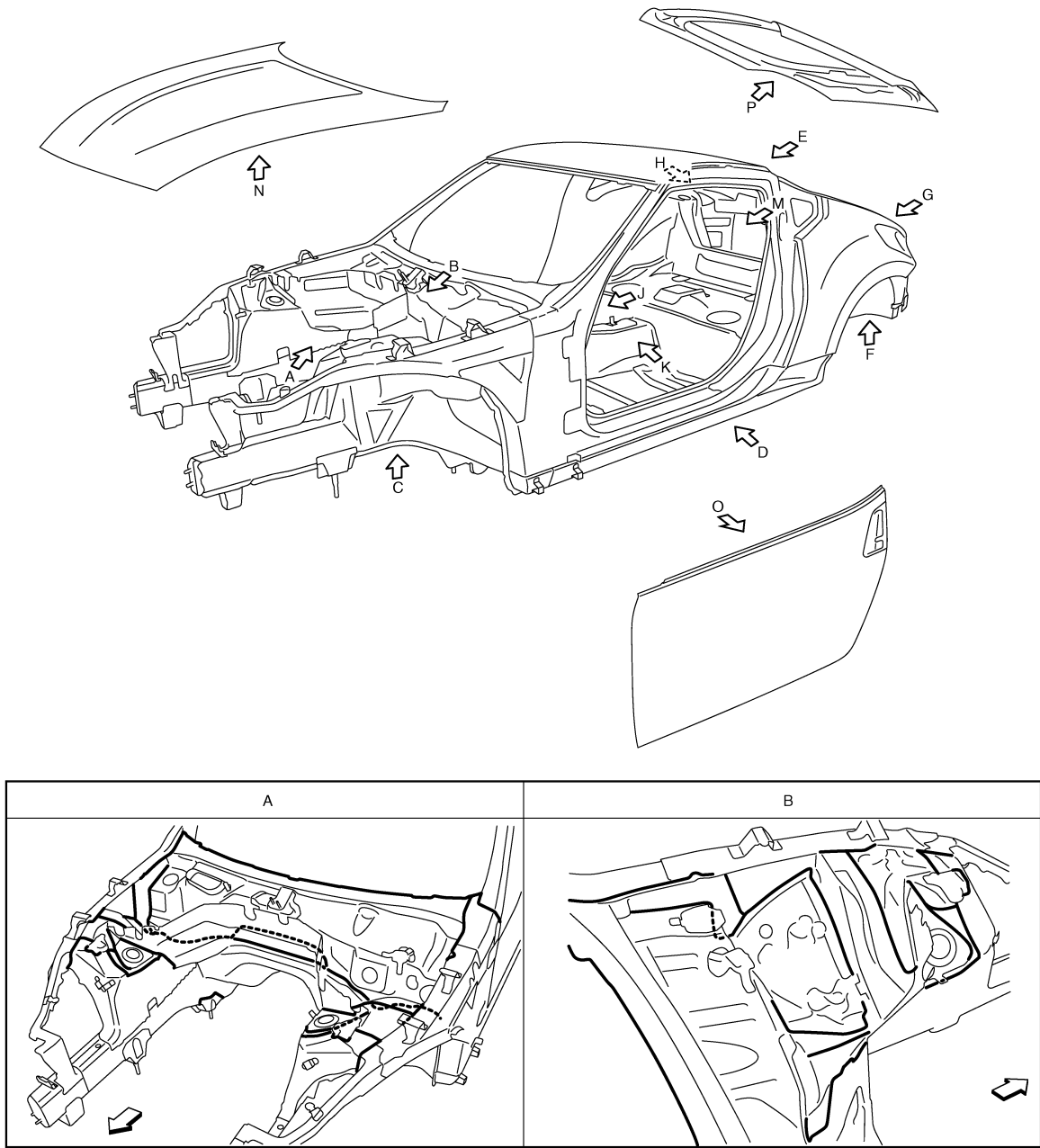
INFOID:000000006353783

The following figure shows the areas that are sealed at the factory. Sealant that is applied to these areas should be smooth and free from cuts or gaps. Care should be taken not to apply an excess amount of sealant and not to allow other unaffected parts to come into contact with the sealant.

# CORROSION PROTECTION

< REMOVAL AND INSTALLATION >

[COUPE (REGULAR GRADE)]



←: Vehicle front  
 —: Sealed portions

A  
 B  
 C  
 D  
 E  
 F  
 G  
 H  
 I  
 J  
 L  
 M  
 N  
 O  
 P

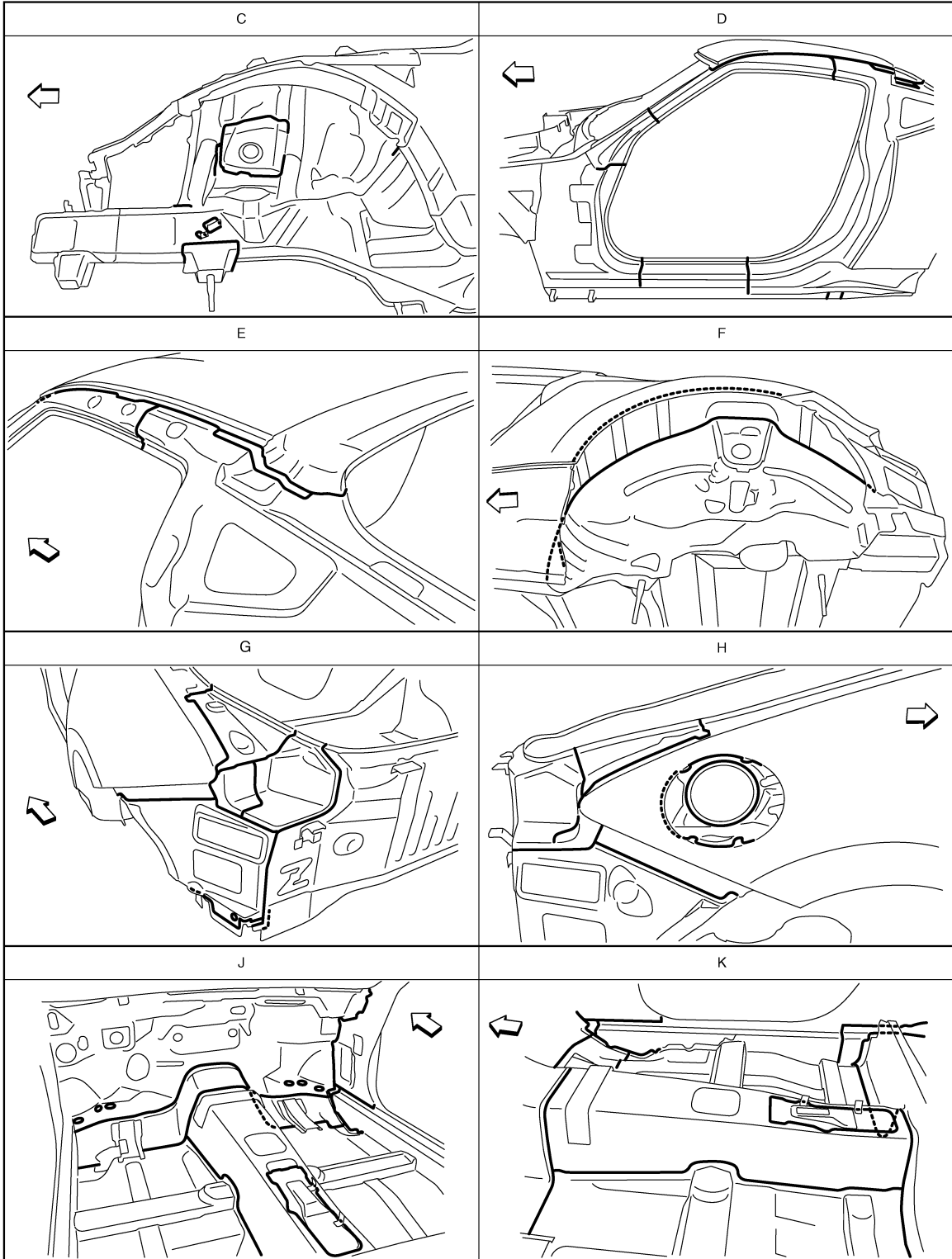
BRM

JSKIA0894ZZ

# CORROSION PROTECTION

< REMOVAL AND INSTALLATION >

[COUPE (REGULAR GRADE)]



JSKIA0895ZZ

↶: Vehicle front

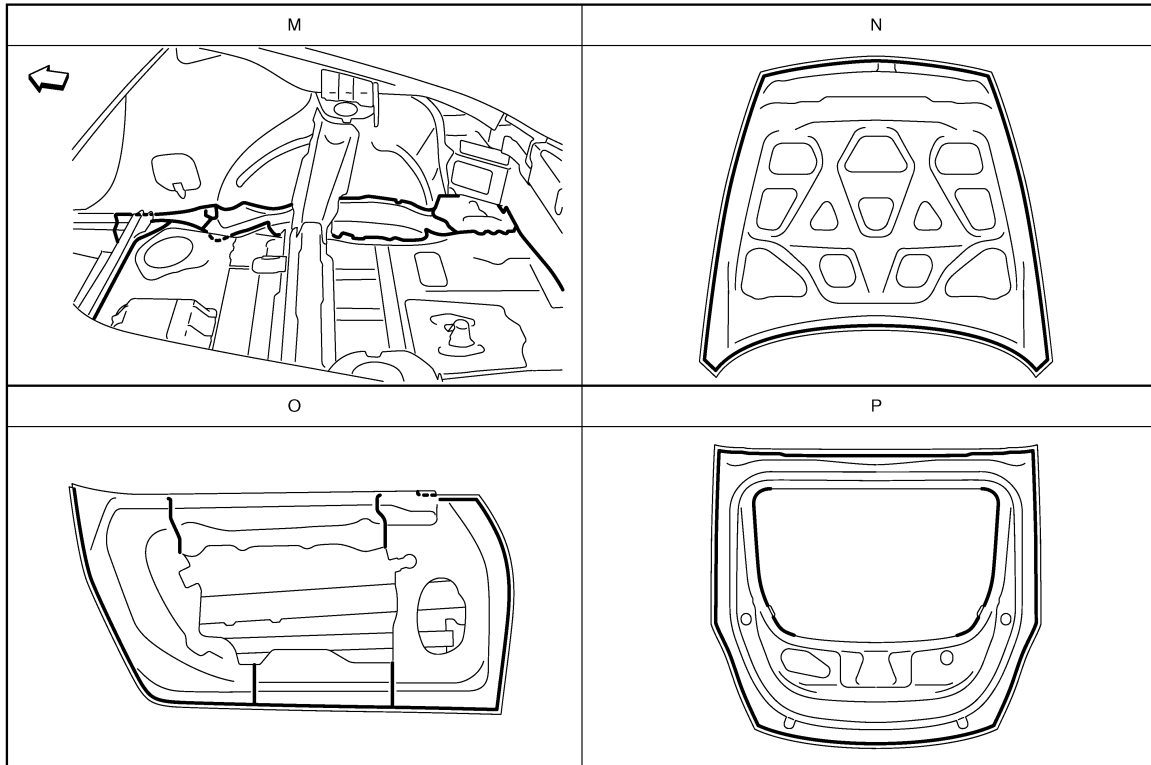
—: Sealed portions



# CORROSION PROTECTION

< REMOVAL AND INSTALLATION >

[COUPE (REGULAR GRADE)]



A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
L  
M  
N  
O  
P

JSKIA0896ZZ

↩: Vehicle front  
█: Sealed portions

**BRM**

# BODY CONSTRUCTION

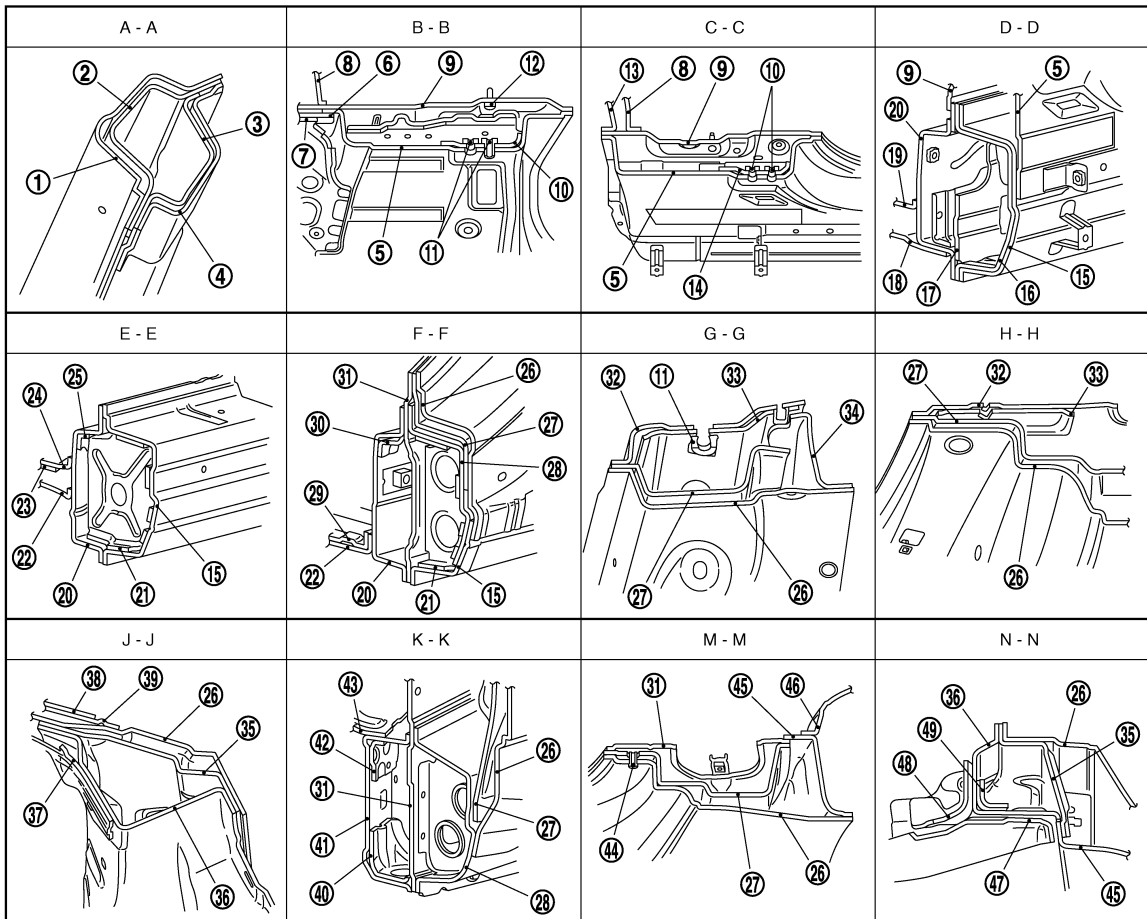
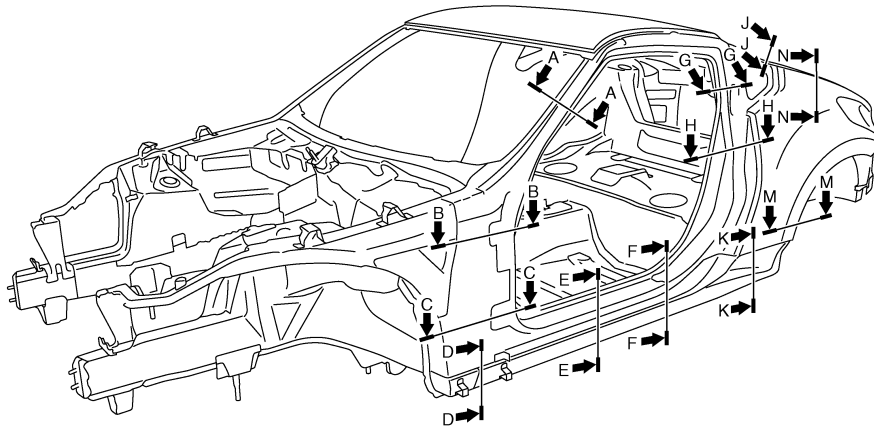
< REMOVAL AND INSTALLATION >

[COUPE (REGULAR GRADE)]

## BODY CONSTRUCTION

### Body Construction

INFOID:000000006353784



- |                                 |                                     |                                   |
|---------------------------------|-------------------------------------|-----------------------------------|
| 1. Upper outer front pillar     | 2. Outer front pillar reinforcement | 3. Upper inner front pillar       |
| 4. Front roof rail brace        | 5. Front pillar hinge brace         | 6. Hoodledge reinforcement gusset |
| 7. Rear hoodledge reinforcement | 8. Upper dash                       | 9. Upper rear hoodledge           |

JSKIA0898ZZ

# BODY CONSTRUCTION

## < REMOVAL AND INSTALLATION >

## [COUPE (REGULAR GRADE)]

- |                                      |                                      |   |
|--------------------------------------|--------------------------------------|---|
| 10. Upper front pillar reinforcement | 11. Weld nut                         | 12. Weld bolt                             |
| 13. Lower dash crossmember           | 14. Lower hinge plate                | 15. Outer sill reinforcement              |
| 16. Outer front sill brace           | 17. Lower front pillar reinforcement | 18. Front side member outrigger           |
| 19. Lower dash                       | 20. Inner sill                       | 21. Outer sill brace                      |
| 22. Front floor                      | 23. Plate nut                        | 24. 2nd crossmember                       |
| 25. Center sill reinforcement        | 26. Rear fender                      | 27. Lock pillar reinforcement             |
| 28. Outer rear wheelhouse extension  | 29. 3rd crossmember                  | 30. Inner rear sill reinforcement         |
| 31. Lower inner lock pillar          | 32. Upper inner lock pillar          | 33. Upper inner lock pillar reinforcement |
| 34. Inner side panel                 | 35. Rear pillar reinforcement        | 36. Inner rear pillar                     |
| 37. Rear roof rail brace             | 38. Roof                             | 39. Upper rear roof rail                  |
| 40. Rear tie down hook bracket       | 41. Rear side member front           | 42. Rear side member front reinforcement  |
| 43. Rear floor                       | 44. Calk nut                         | 45. Outer rear wheelhouse                 |
| 46. Inner rear wheelhouse            | 47. Shock absorber mounting bracket  | 48. Shock absorber bracket reinforcement  |
| 49. Inner rear pillar reinforcement  |                                      |   |

## Rear Fender Hemming Process

INFOID:000000006353785

1. A wheel arch is to be installed and hemmed over the left and right outer wheel houses.
2. In order to hem the wheel arch, it is necessary to repair any damaged or defaced parts around outer wheel house.

### CAUTION:

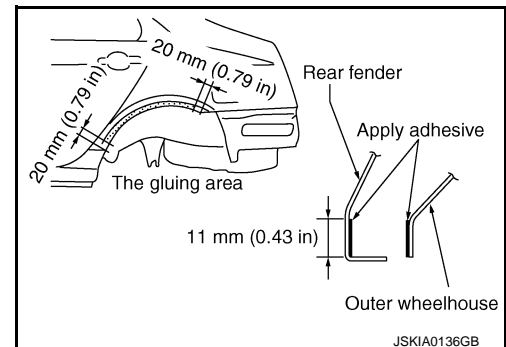
**Ensure that the area that is to be glued around the outer wheelhouse is undamaged or defaced.**

### PROCEDURE OF THE HEMMING PROCESS

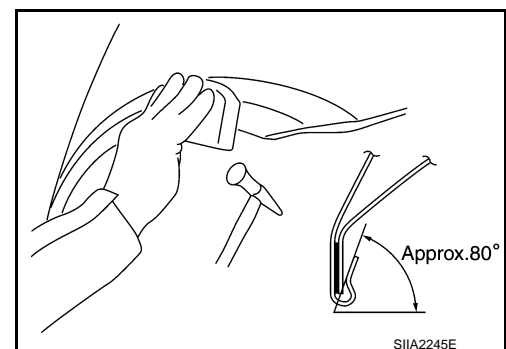
- Peel off old bonding material on the surface of the outer wheelhouse and clean thoroughly.
- Peel off a primer coat in the specified area where new adhesive is to be applied on rear fender (the replacing part).
- Apply new adhesive to both specified areas of the outer wheelhouse and rear fender.

**<Adhesive> 3M™ Automix™ Panel Bonding Adhesive 08115 or equivalent**

- Attach rear fender to the body of the car, and weld the required part except the hemming part.



- Bend the welded part starting from the center of the wheel arch gradually with a hammer and a dolly. (Also hem the end of the flange.)
- Hemming with a hammer is conducted to an approximate angle of 80 degrees.

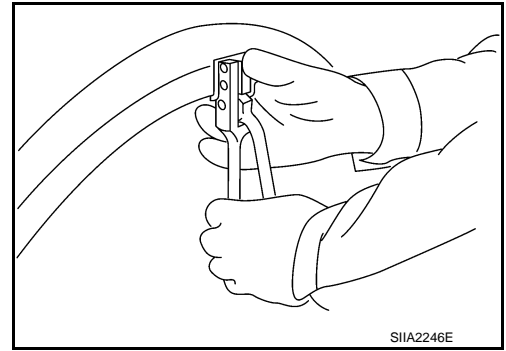


## BODY CONSTRUCTION

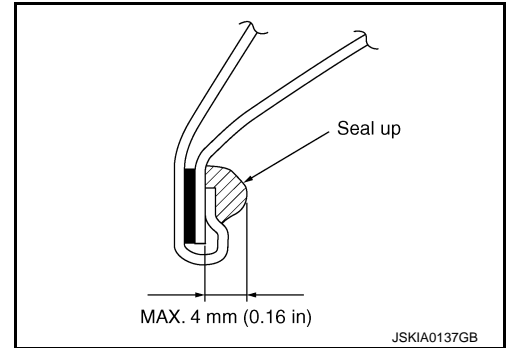
### < REMOVAL AND INSTALLATION >

[COUPE (REGULAR GRADE)]

- Starting from the center, hem the wheel arch gradually, using slight back and forth motion with a hemming tool.



- Seal up the area around the hemmed end of the flange.



# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[COUPE (REGULAR GRADE)]

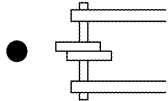
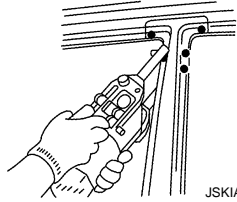
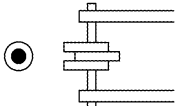
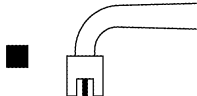



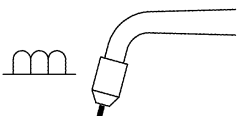
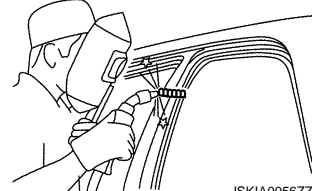
## REPLACEMENT OPERATIONS

### Description

INFOID:000000006353786

- This section is prepared for technicians who have attained a high level of skill and experience in repairing collision-damaged vehicles and also use modern service tools and equipment. Persons unfamiliar with body repair techniques should not attempt to repair collision-damaged vehicles by using this section.
- Technicians are also encouraged to read the Body Repair Manual (Fundamentals) in order to ensure that the original functions and quality of the vehicle are maintained. The Body Repair Manual (Fundamentals) contains additional information, including cautions and warnings, that are not including in this manual. Technicians should refer to both manuals to ensure proper repair.
- Please note that this information is prepared for worldwide usage, and as such, certain procedures might not apply in some regions or countries.

The symbols used in this section for welding operations are shown below.

Symbol marks	Description	
 <p>JSKIA0049ZZ</p>	2-spot welds	 <p>JSKIA0053ZZ</p>
 <p>JSKIA0050ZZ</p>	3-spot welds	
 <p>JSKIA0051ZZ</p>	MIG plug weld	 <p>JSKIA0054ZZ</p> <p>For 3 panels plug weld method</p> <div style="display: flex; flex-direction: column; align-items: center;"> <div data-bbox="1144 1438 1307 1480"> <p>■ A </p> </div> <div data-bbox="1144 1533 1307 1575"> <p>■ B </p> </div> </div> <p>JSKIA0055ZZ</p>
 <p>JSKIA0052ZZ</p>	MIG seam weld / Point weld	 <p>JSKIA0056ZZ</p>

A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
L  
M  
N  
O  
P

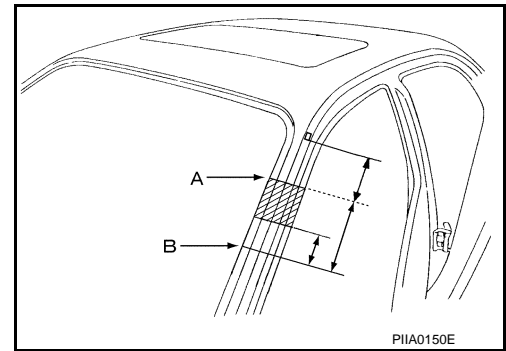
BRM

# REPLACEMENT OPERATIONS

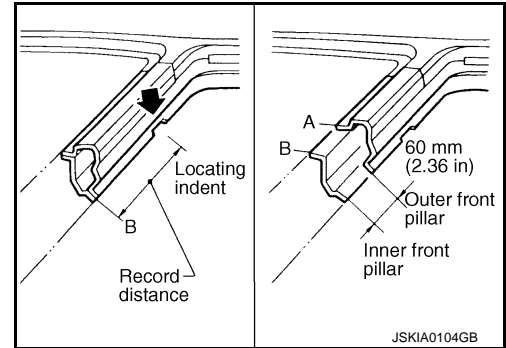
## < REMOVAL AND INSTALLATION >

[COUPE (REGULAR GRADE)]

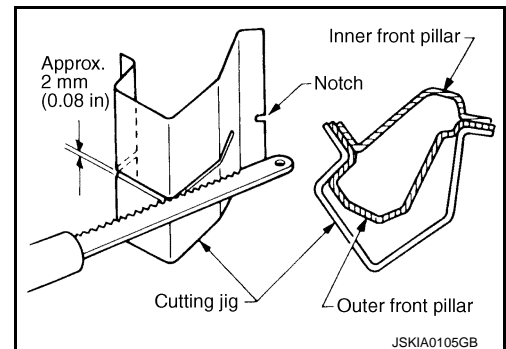
- Front pillar butt joint can be determined anywhere within shaded area as shown in the figure. The best location for the butt joint is at position A due to the construction of the vehicle.



- Determine cutting position and record distance from the locating indent. Use this distance when cutting the service part. Cut outer front pillar over 60 mm (2.36 in) above the inner front pillar cut position.

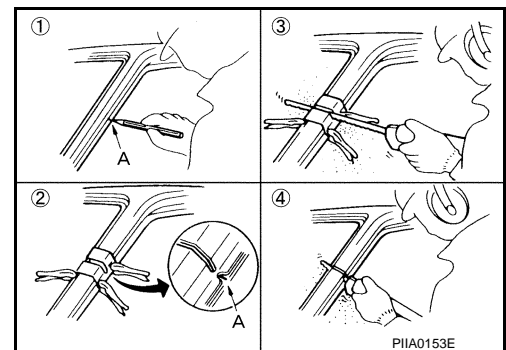


- Prepare a cutting jig to make outer pillar easier to cut. Also, this will permit the service part to be accurately cut at the joint position.



- An example of cutting operation using a cutting jig is as per the following.

1. Mark cutting lines.  
A: Cut position of outer pillar  
B: Cut position of inner pillar
2. Align cutting line with notch on jig. Clamp jig to pillar.
3. Cut outer pillar along groove of jig (at position A).
4. Remove jig and cut remaining portions.
5. Cut inner pillar at position B in same manner.



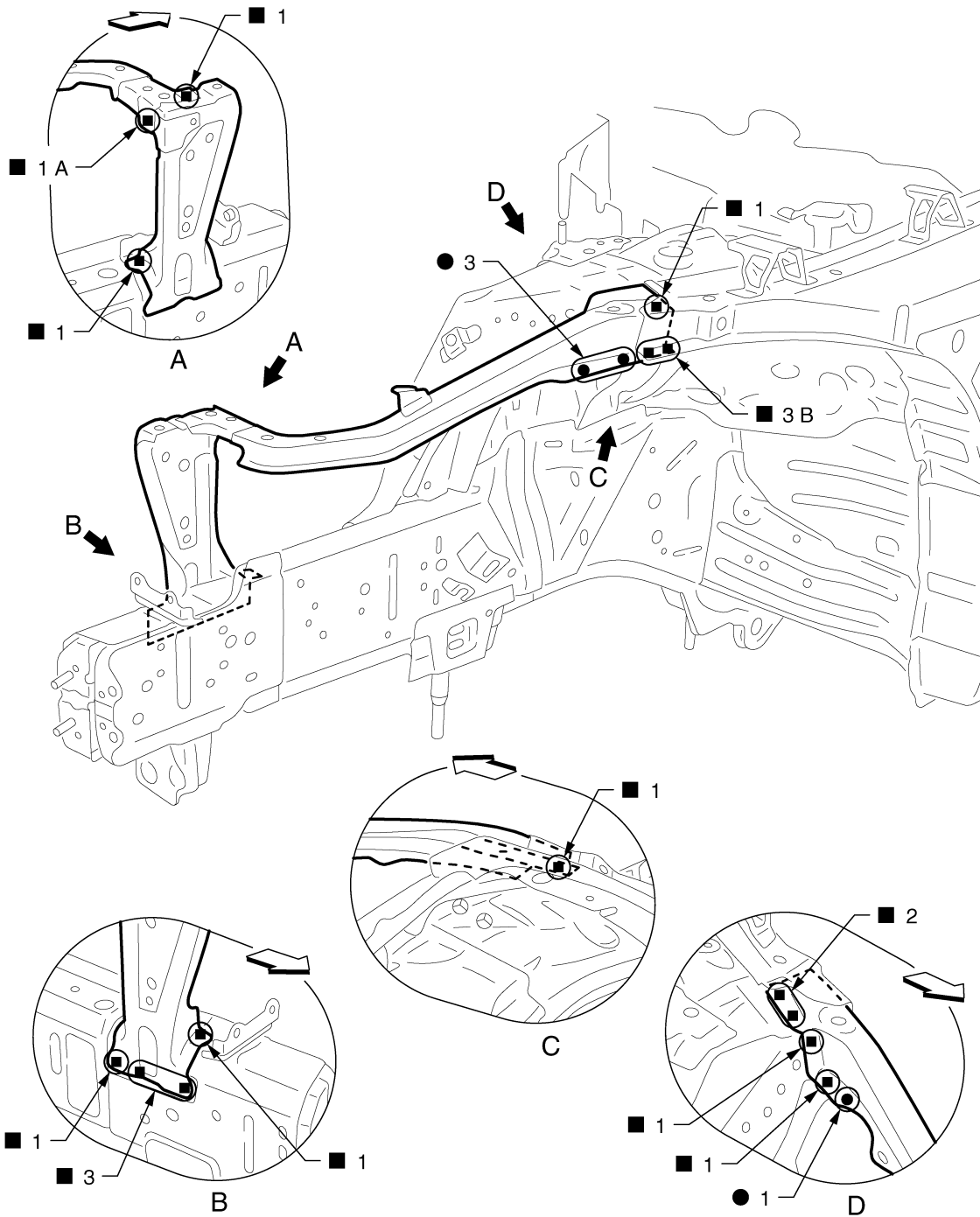
# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[COUPE (REGULAR GRADE)]

## Radiator Core Support

INFOID:000000006353787



A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
K  
L  
M  
N  
O  
P

BRM

←: Vehicle front

Replacement parts

● Side radiator core support (LH)

● Front side member connector assembly (LH)

## Hoodledge

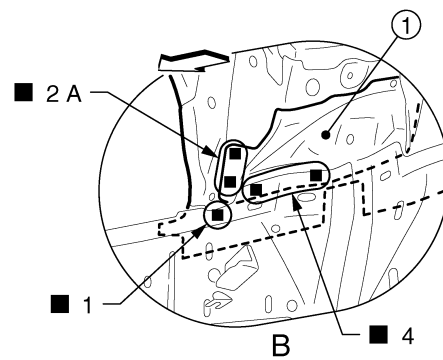
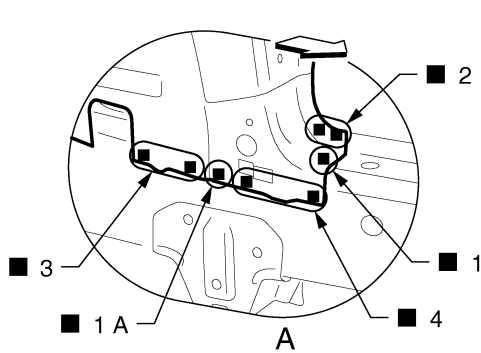
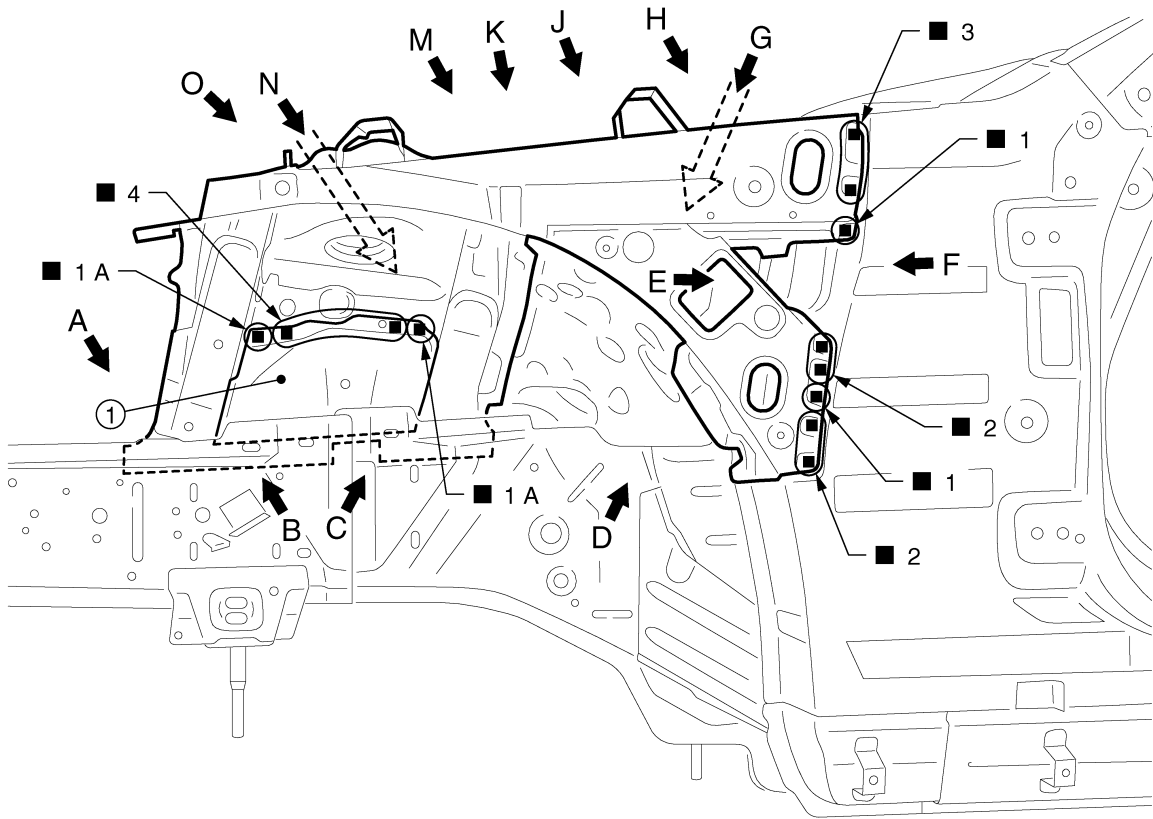
INFOID:000000006353788

Work after radiator core support is removed.  
Remove the front side member center closing plate (reusable).

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[COUPE (REGULAR GRADE)]



JSKIA0905ZZ

1. Front side member center closing plate

←: Vehicle front

Replacement parts

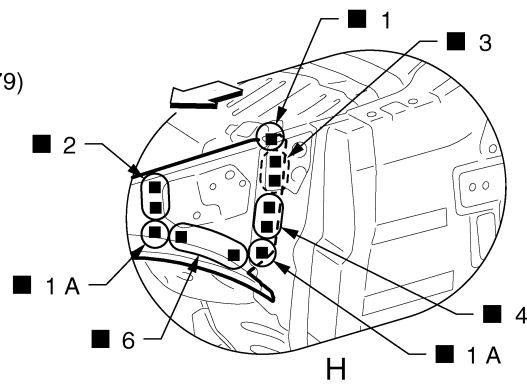
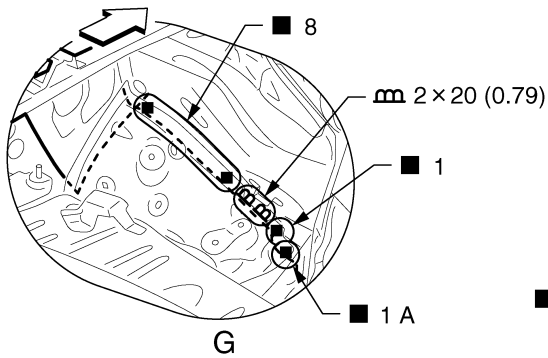
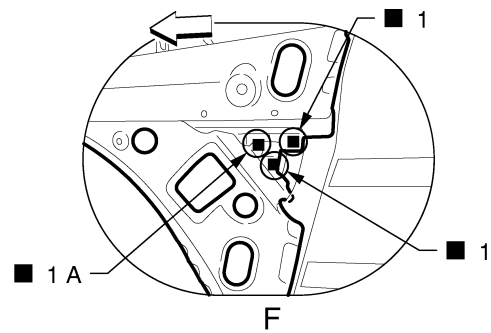
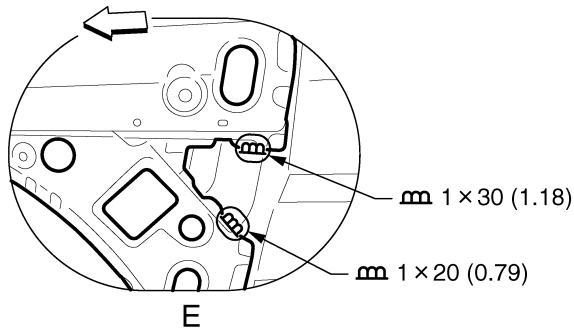
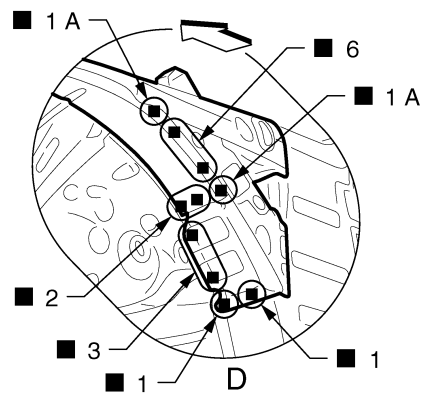
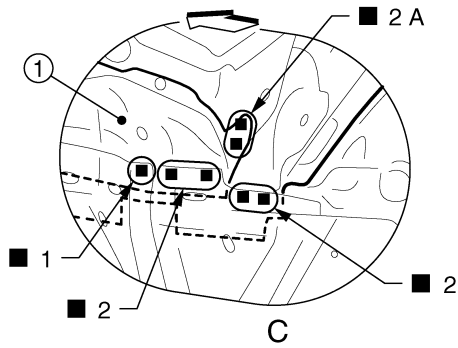
- Upper front hoodledge (LH)
- Hoodledge reinforcement (LH)
- Front strut housing (LH)



# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[COUPE (REGULAR GRADE)]



- 1. Front side member center closing plate

Unit: mm (in)

← Vehicle front

○: Weld the parts onto the back of the component part.

View H: Before installing hoodledge reinforcement

A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
K  
L  
M  
N  
O  
P

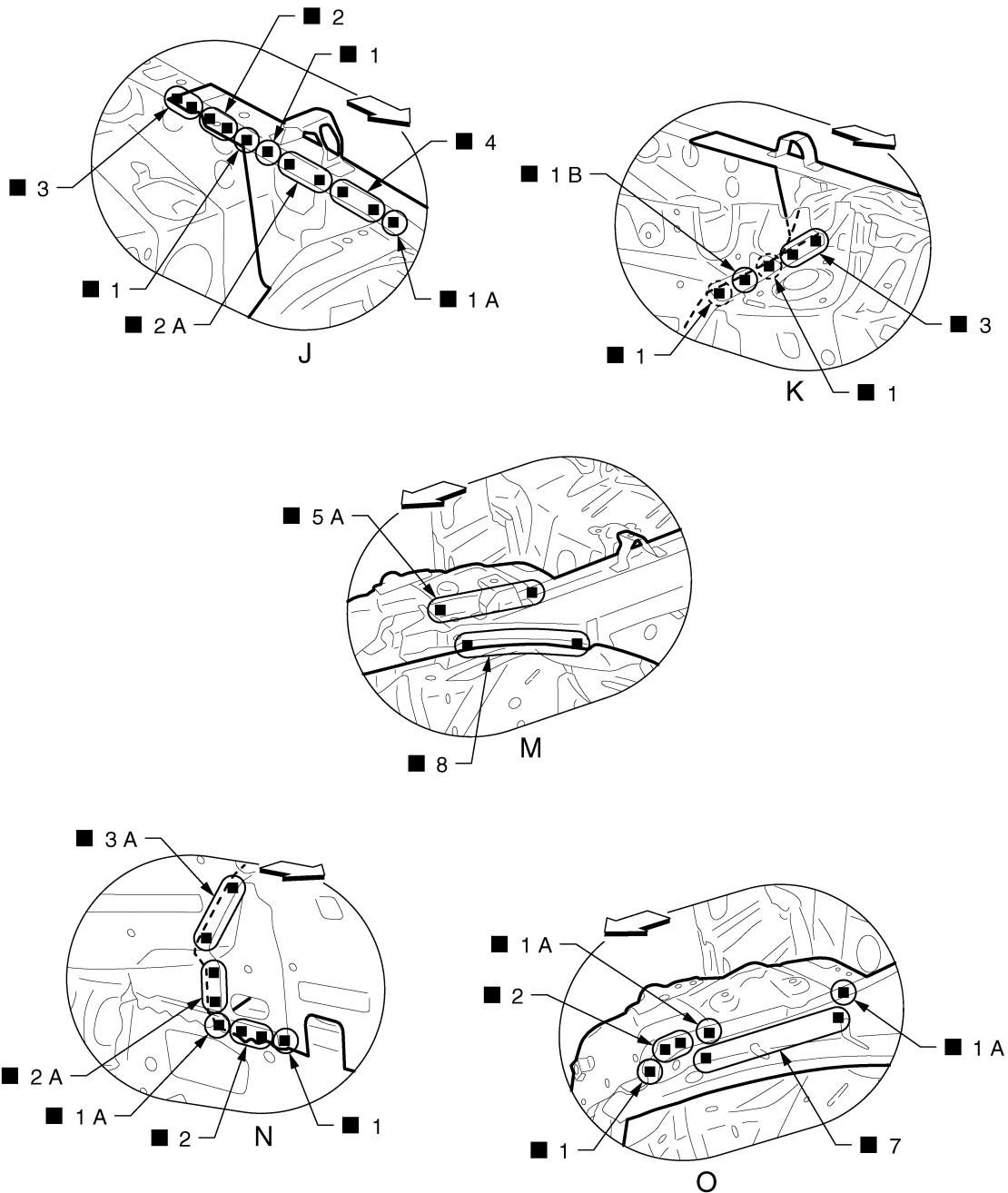
BRM

JSKIA0906GB

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[COUPE (REGULAR GRADE)]



JSKIA0907ZZ

←: Vehicle front

○: Weld the parts onto the back of the component part.

View O: Before installing hoodledge reinforcement

## Front Side Member

INFOID:00000006353789

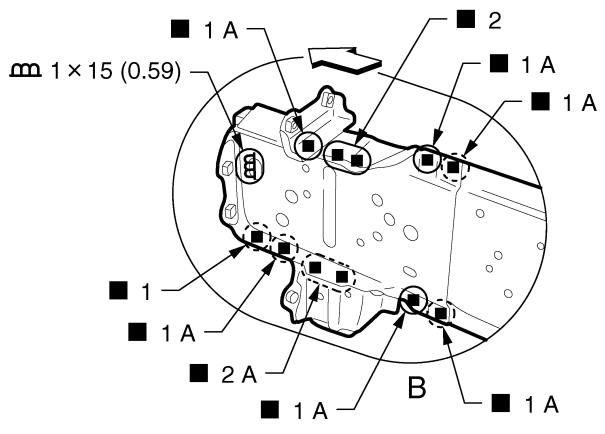
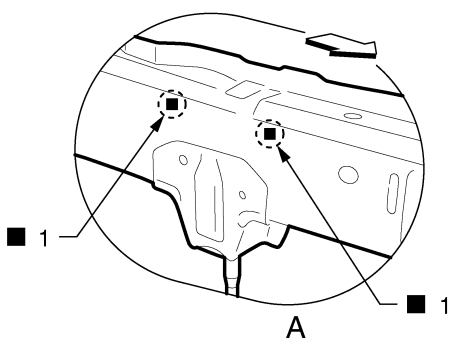
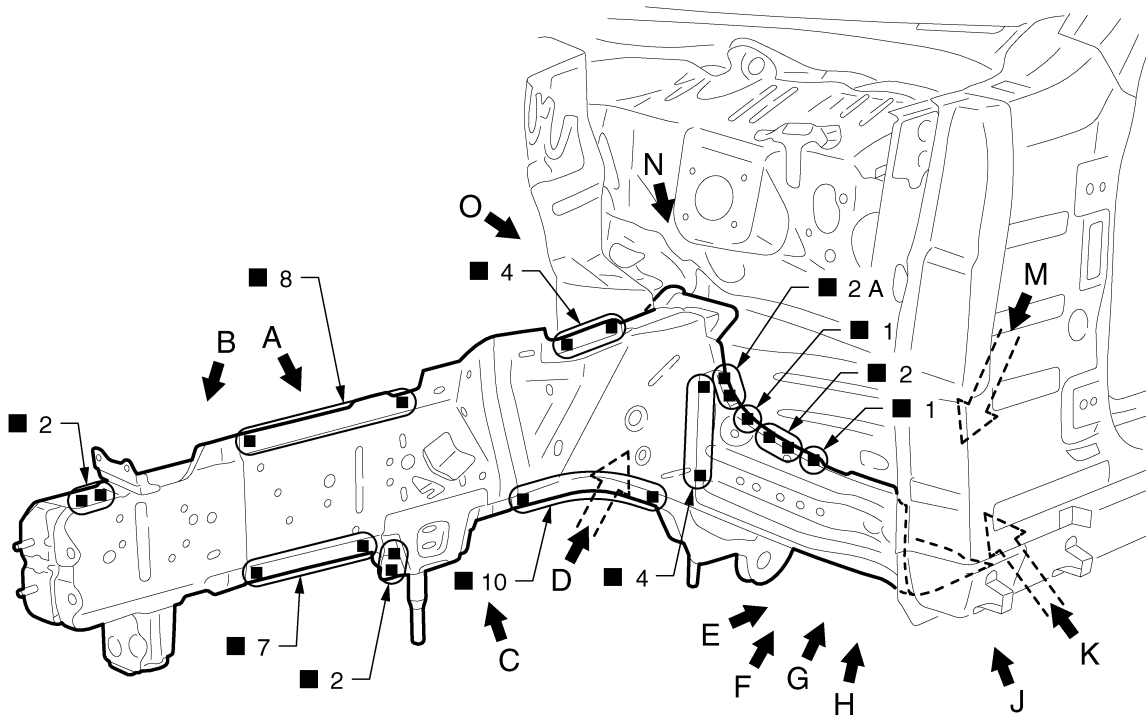
Work after radiator core support and hoodledge are removed.

Assemble the hoodledge and check the fitting according to Body Alignment before replacing the front side member center closing plate.

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[COUPE (REGULAR GRADE)]



JSKIA0908GB

Unit: mm (in)

⇨ Vehicle front

○: Weld the parts onto the back of the component part.

Replacement parts

- Front side member assembly (LH)
- Front side member closing plate assembly (LH)
- Front side member outrigger assembly (LH)

View A: Before installing front side member closing plate assembly

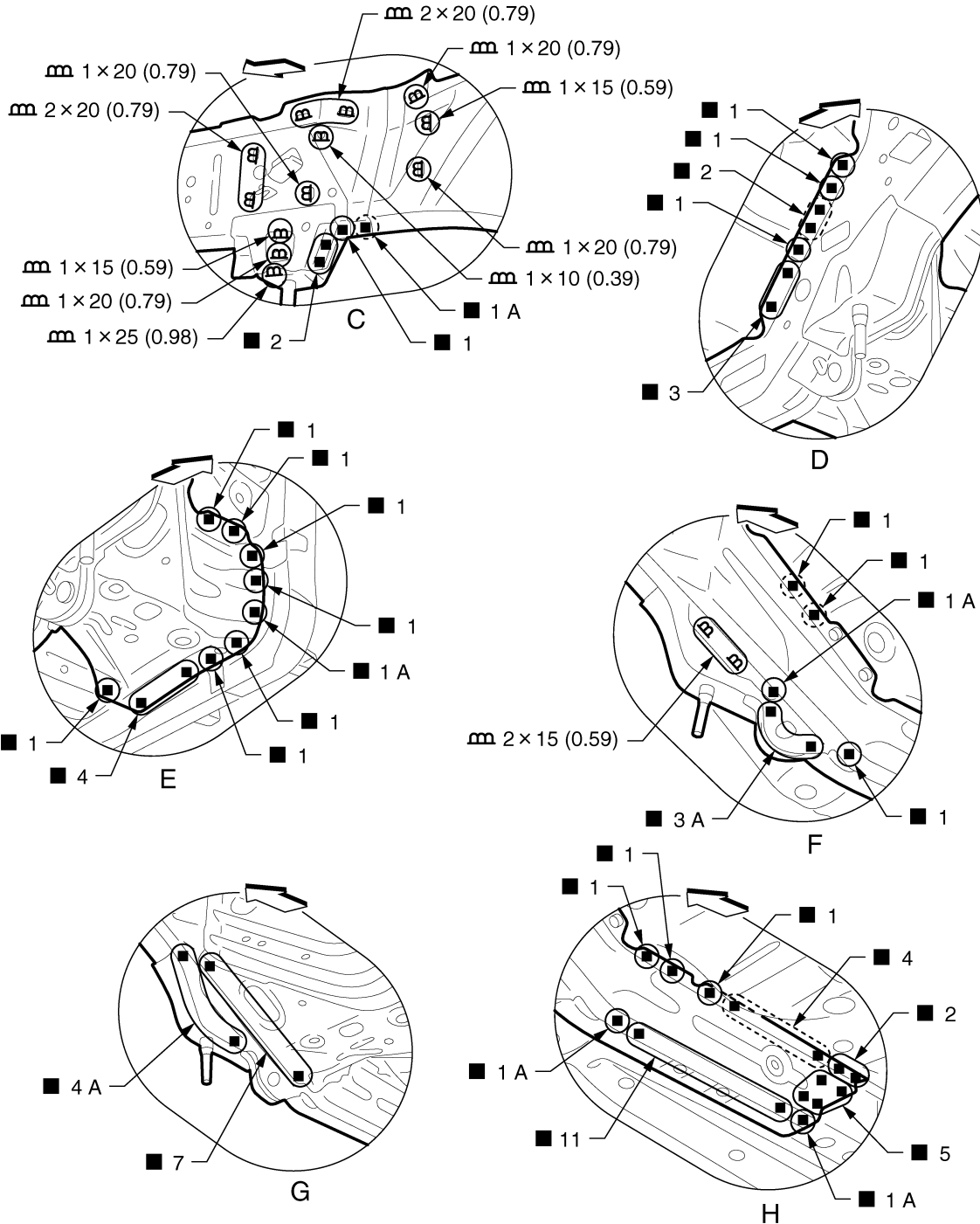
A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
K  
L  
M  
N  
O  
P

BRM

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[COUPE (REGULAR GRADE)]



JSKIA0909GB

Unit: mm (in)

↔: Vehicle front

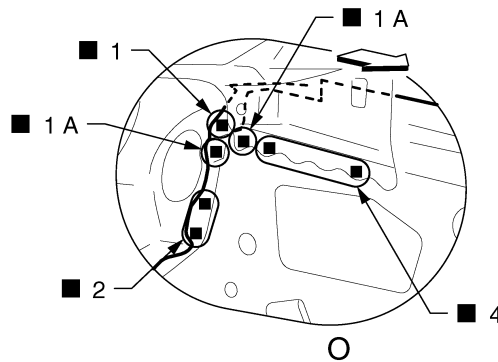
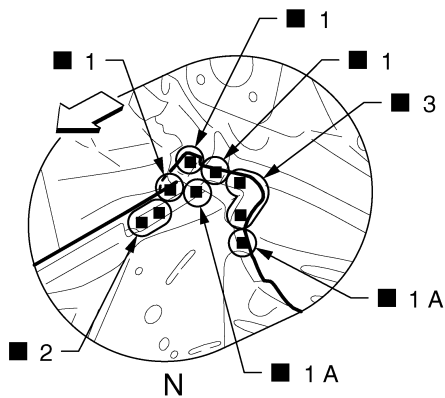
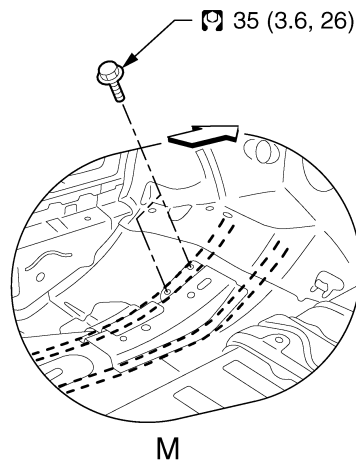
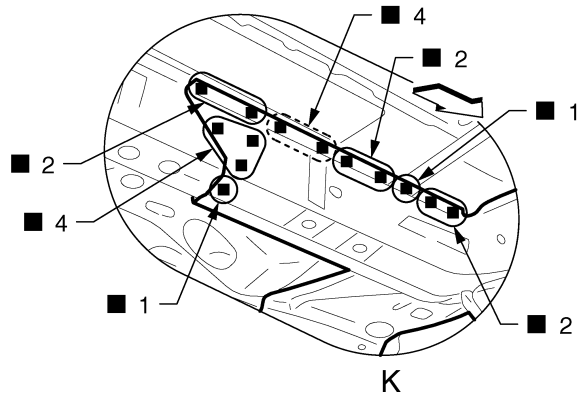
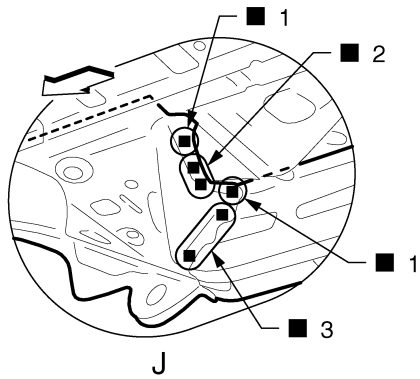
○: Weld the parts onto the back of the component part.

View F and H: Before installing front side member outrigger assembly

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[COUPE (REGULAR GRADE)]



JSKIA0910GB

←: Vehicle front

○: Weld the parts onto the back of the component part.

Refer to [GI-4, "Components"](#) for symbols in the figure.

## Front Side Member (Partial Replacement)

Work after radiator core support is removed.

INFOID:000000006353790

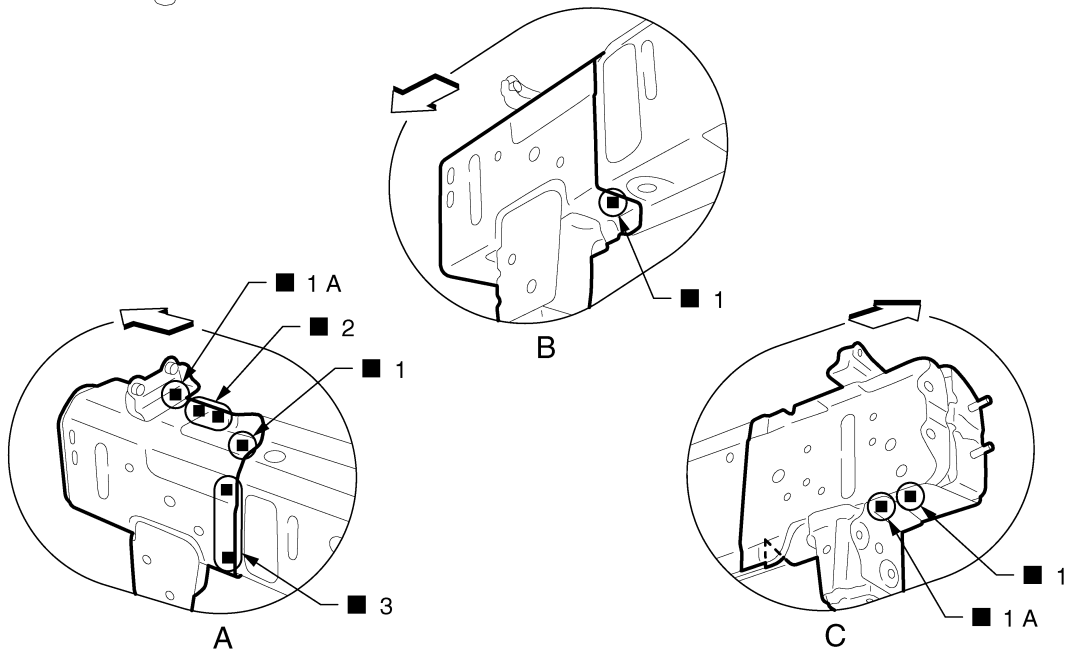
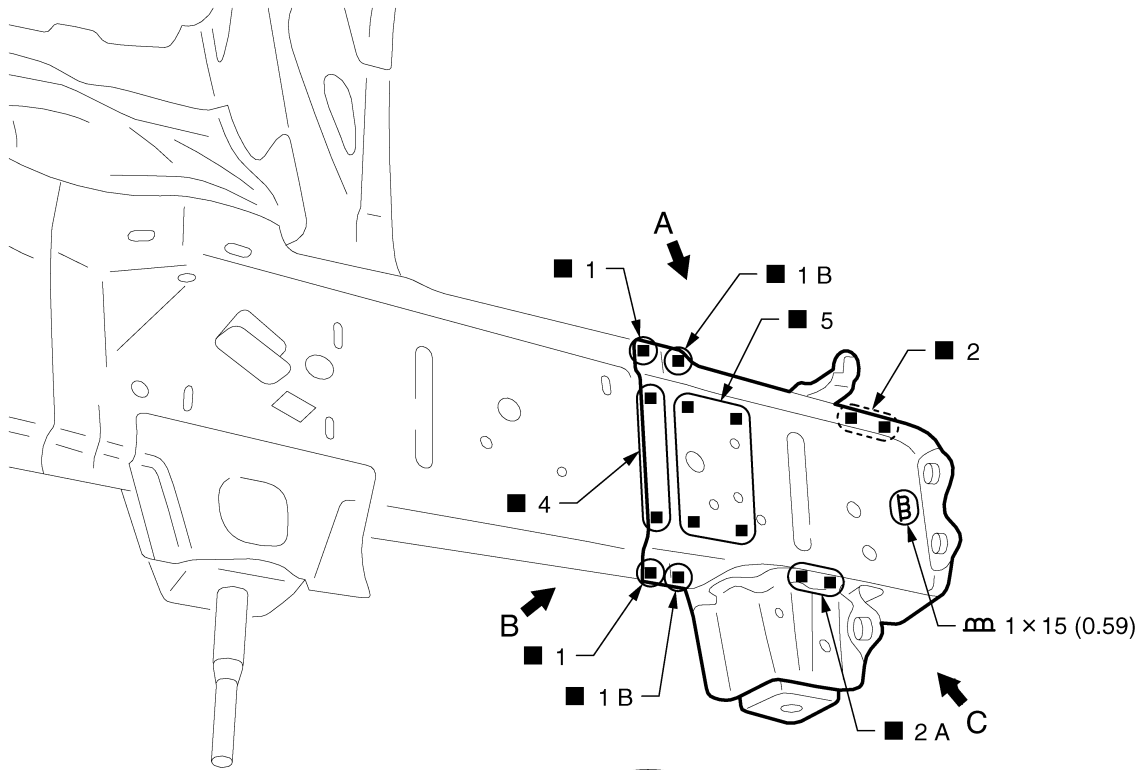
A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
K  
L  
M  
N  
O  
P

BRM

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[COUPE (REGULAR GRADE)]



JSKIA0911GB

Unit: mm (in)

↔: Vehicle front

○: Weld the parts onto the back of the component part.

Replacement parts

- Front side member front extension (RH)
- Front side member front closing plate (RH)
- Front side rear closing reinforcement (RH)

## Front Pillar (Partial Replacement)

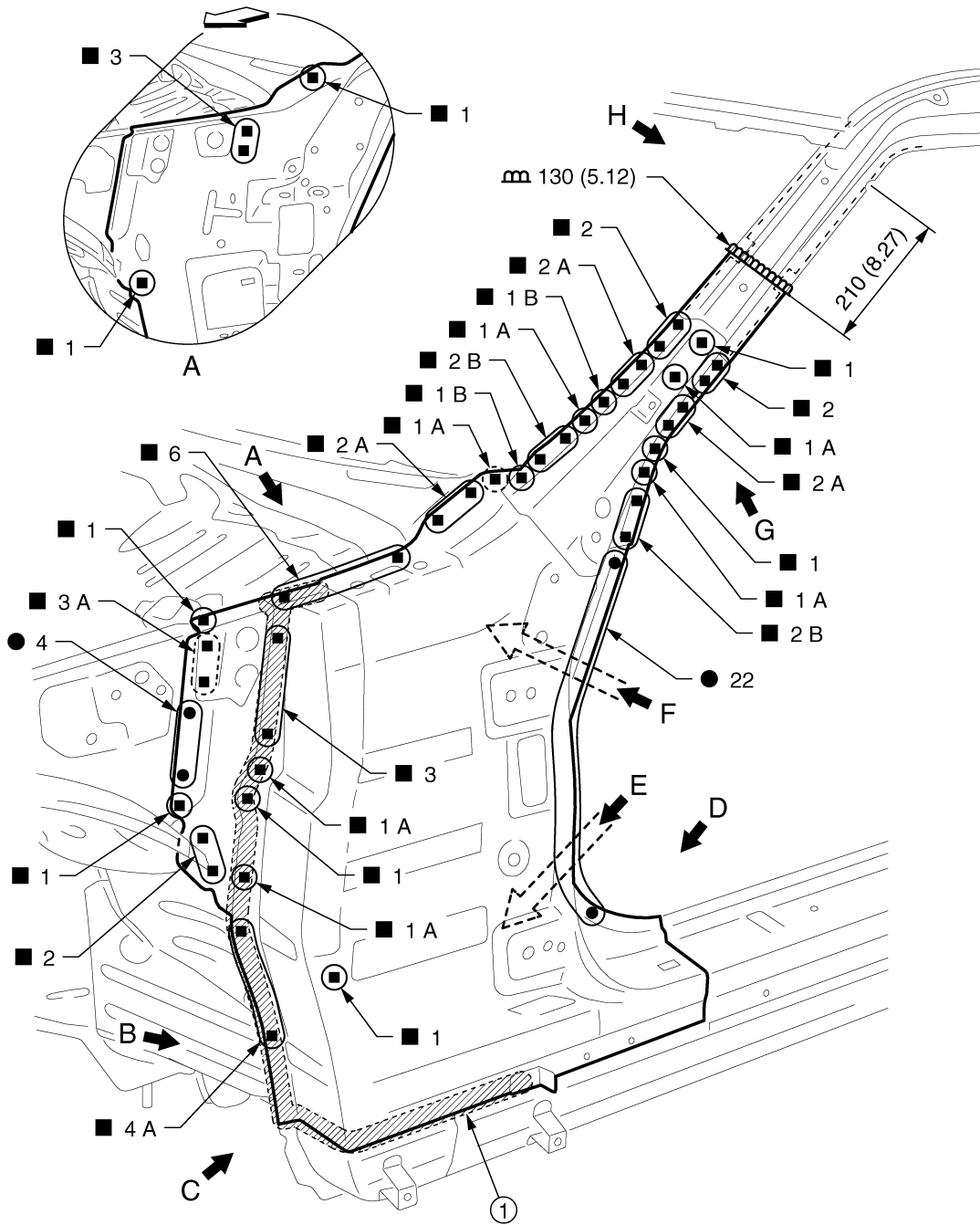
INFOID:000000006353791

Work after hoodledge reinforcement is removed.

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[COUPE (REGULAR GRADE)]



A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
K  
L  
M  
N  
O  
P

BRM

1. Body sealing

Unit: mm (in)

◁: Vehicle front

○: Weld the parts onto the back of the component part.

Replacement parts

- Upper front pillar reinforcement (LH)
- Upper rear hoodledge (LH)
- Inner side roof rail (LH)

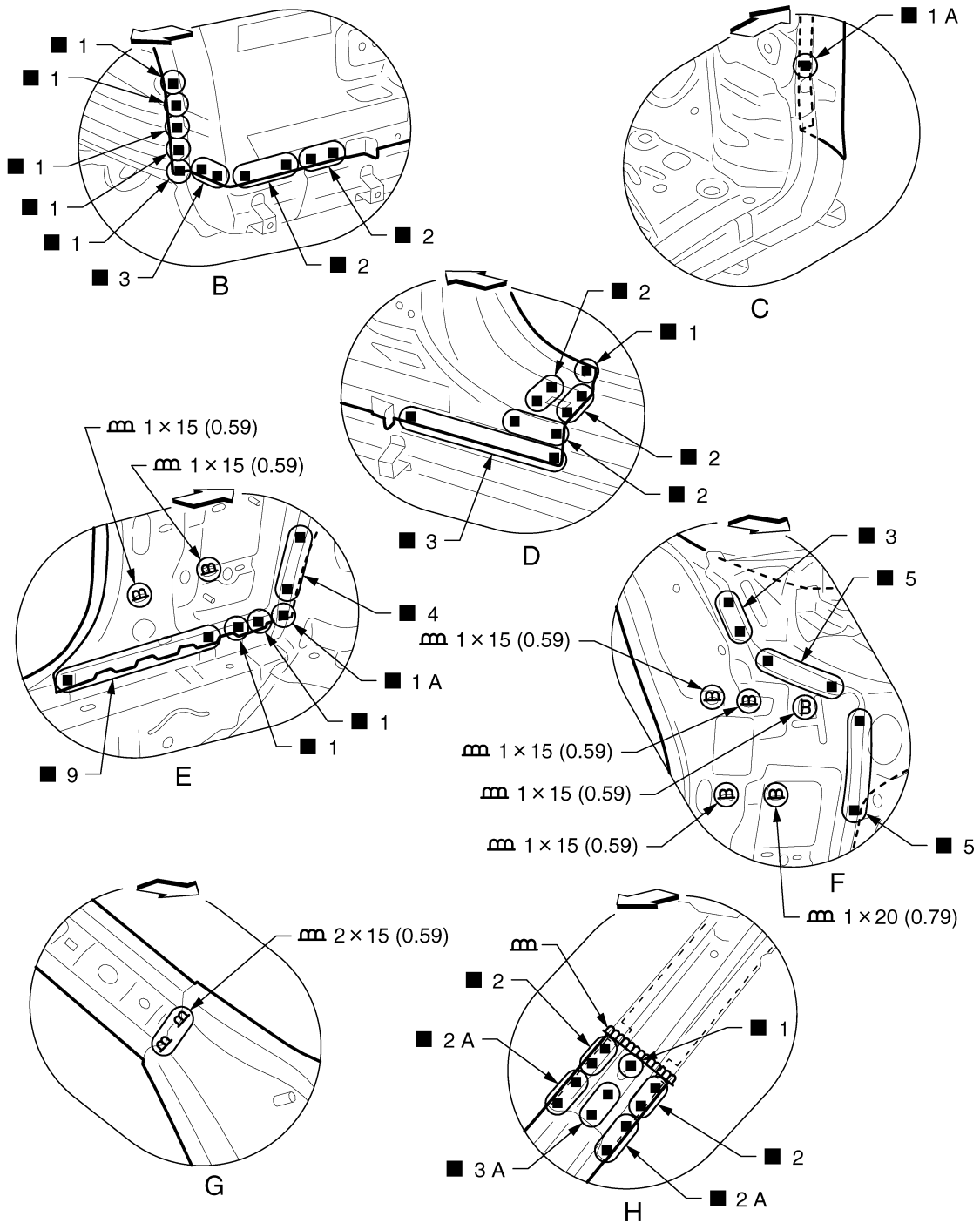
View A: Before installing upper front pillar reinforcement

JSKIA0912GB

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[COUPE (REGULAR GRADE)]



JSKIA0913GB

Unit: mm (in)

↔: Vehicle front

## Front Pillar

INFOID:000000006353792

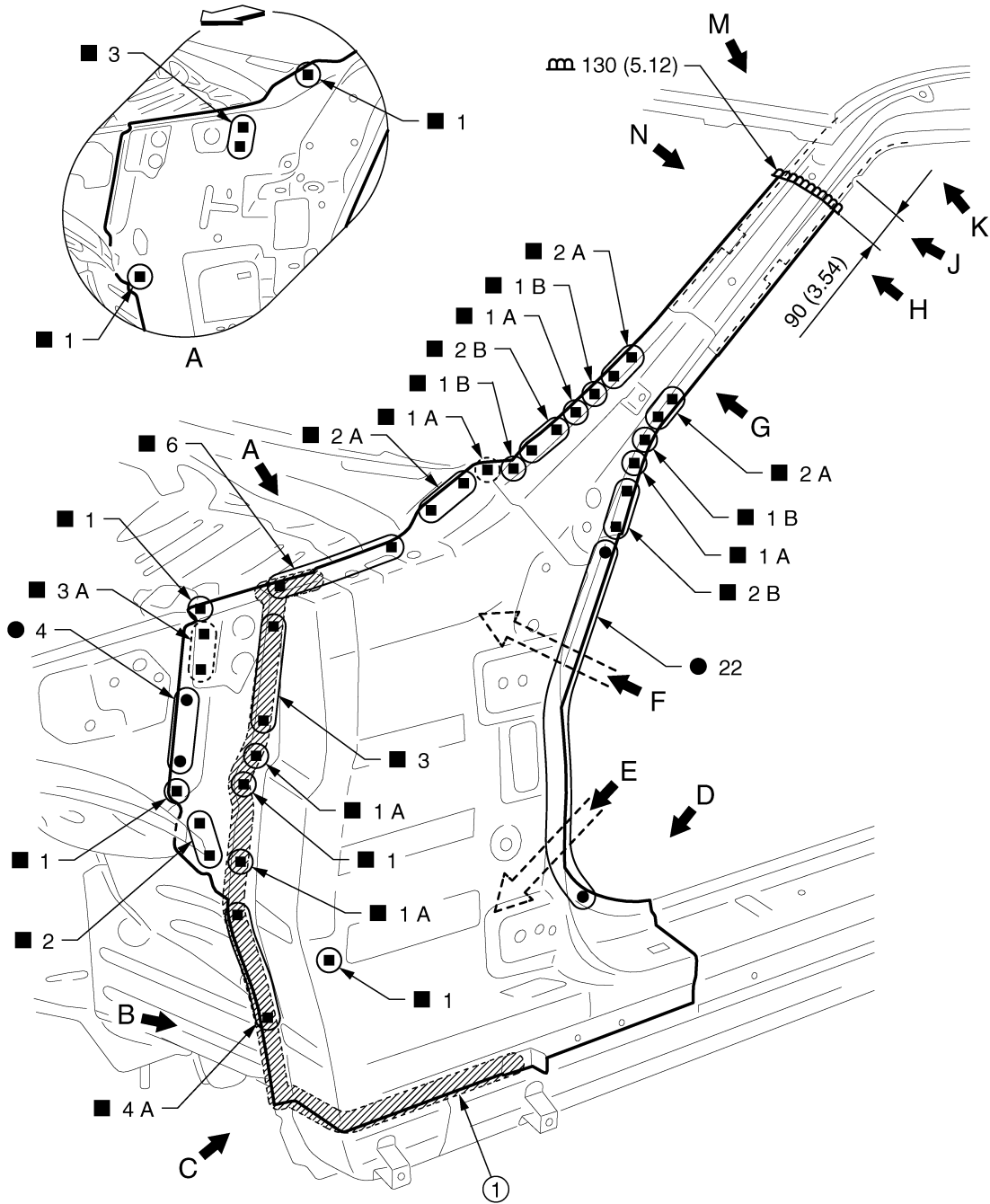
Work after hoodledge reinforcement is removed.  
Remove the front roof rail brace (reusable).



# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[COUPE (REGULAR GRADE)]



A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
K  
L  
M  
N  
O  
P

BRM

1. Body sealing

Unit: mm (in)

◁: Vehicle front

○: Weld the parts onto the back of the component part.

Replacement parts

- Upper front pillar reinforcement (LH)
- Upper rear hoodledge (LH)
- Inner side roof rail (LH)

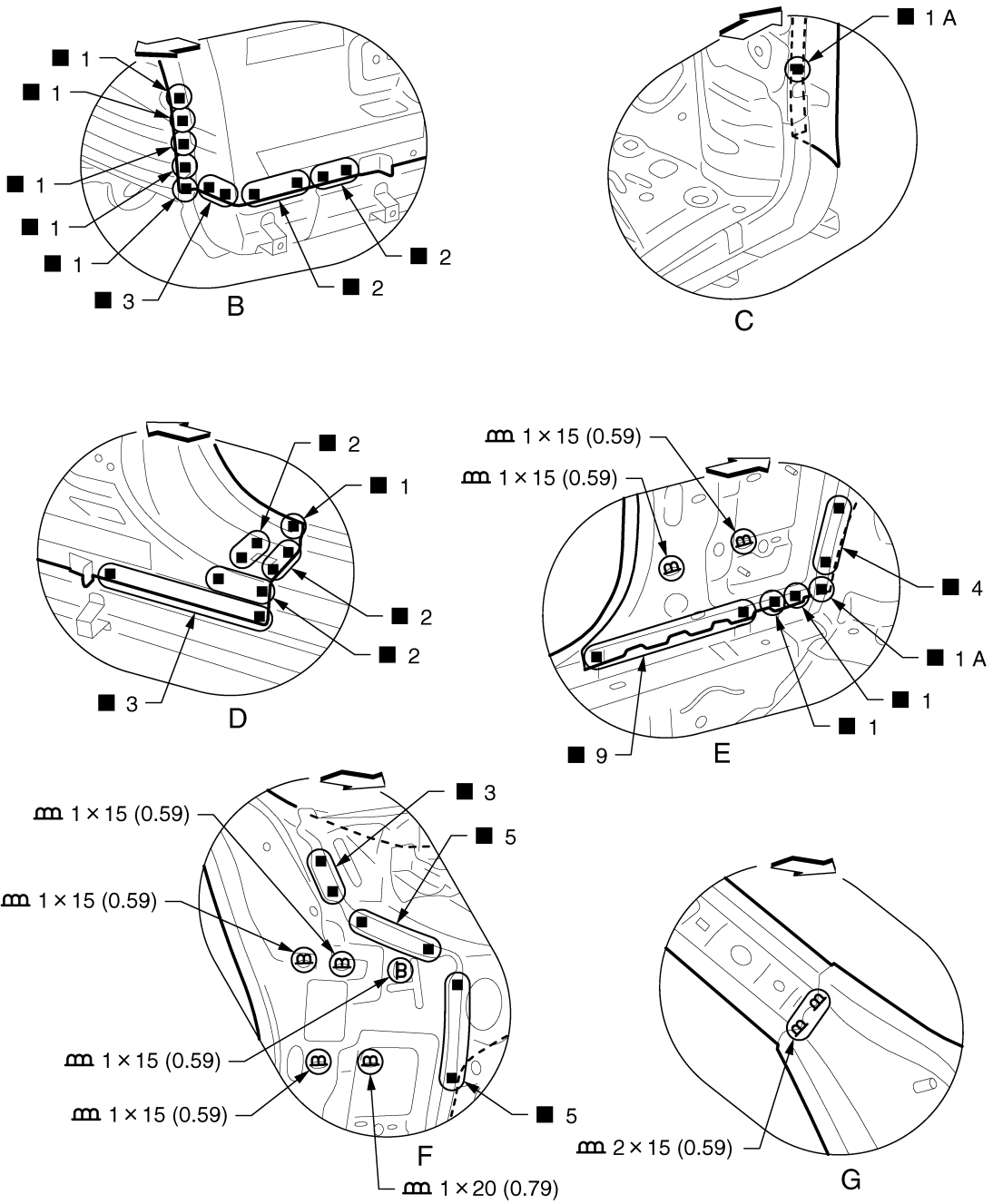
View A: Before installing upper front pillar reinforcement

JSKIA0914GB

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[COUPE (REGULAR GRADE)]



JSKIA0915GB

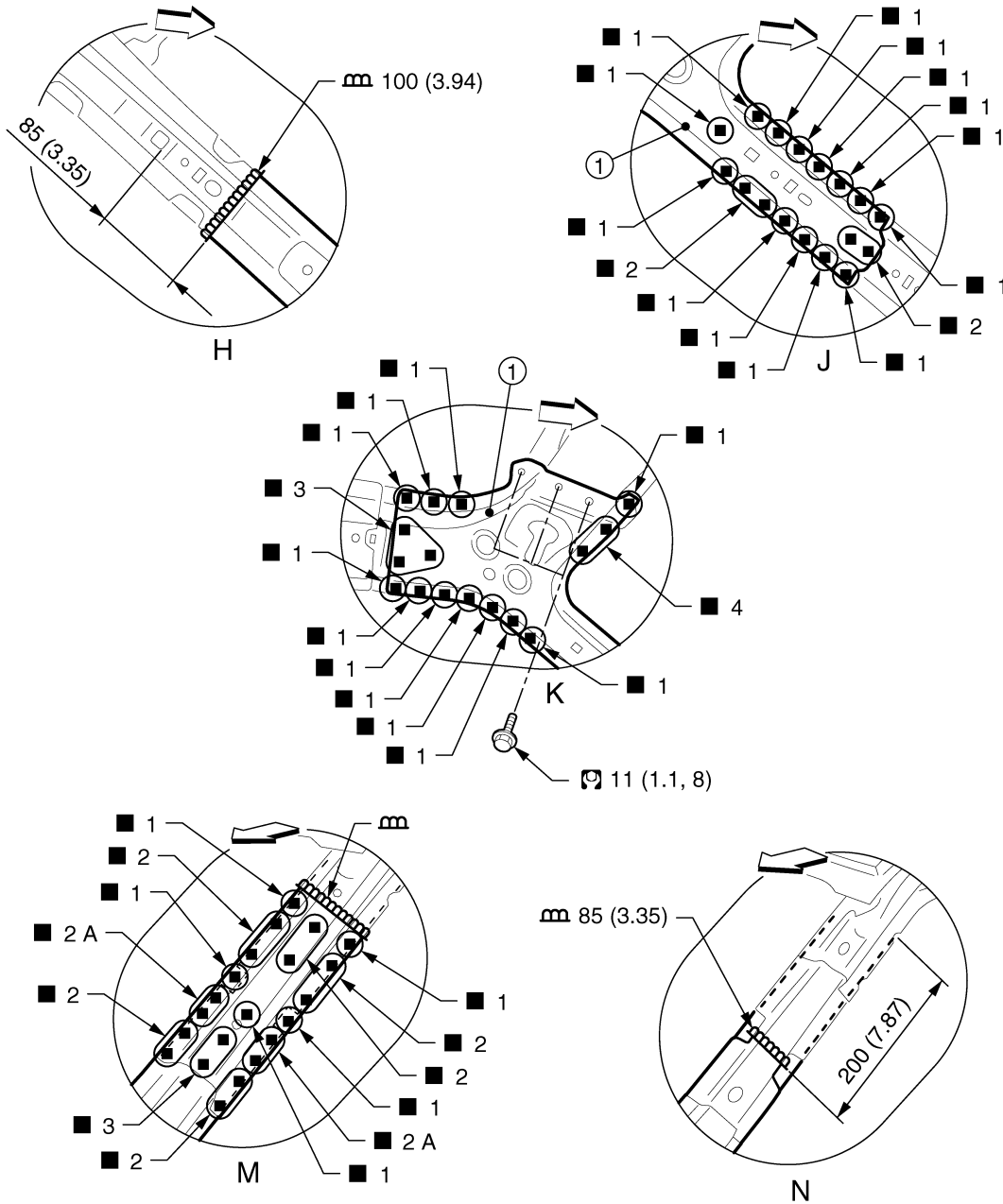
Unit: mm (in)

↔: Vehicle front

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[COUPE (REGULAR GRADE)]



1. Front roof rail brace

Unit: mm (in)

↔: Vehicle front

Refer to [GI-4, "Components"](#) for symbols in the figure.

View H: Before installing front roof rail brace

View N: Before installing upper outer front pillar

BRM

JSKIA0916GB

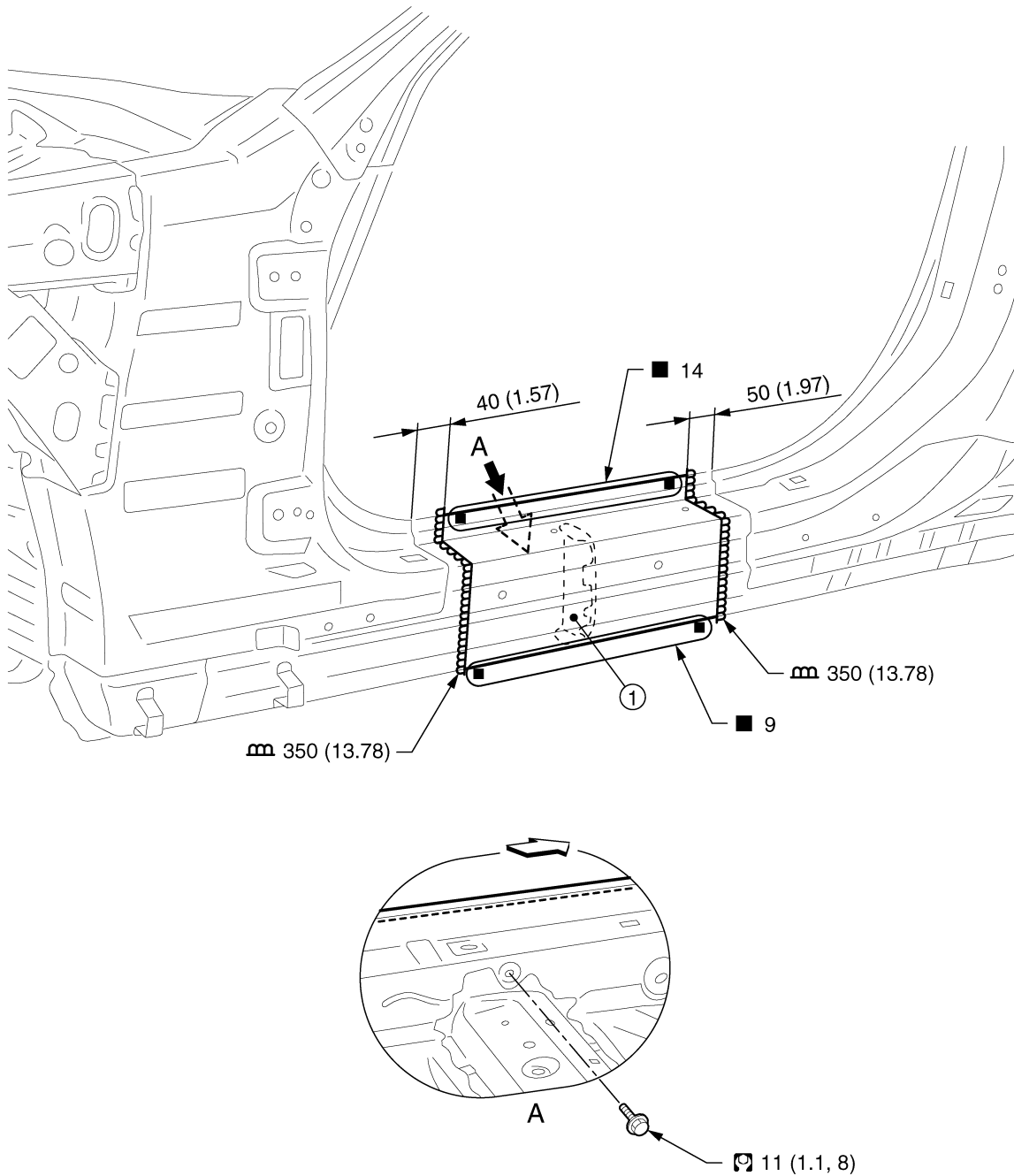
# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[COUPE (REGULAR GRADE)]

## Outer Sill (Partial Replacement by Cutting)

INFOID:00000006353793



JSKIA0917GB

1. Outer sill brace

Unit: mm (in)

↔: Vehicle front

Refer to [GI-4. "Components"](#) for symbols in the figure.

Replacement parts

- Outer sill reinforcement (LH)

# REPLACEMENT OPERATIONS

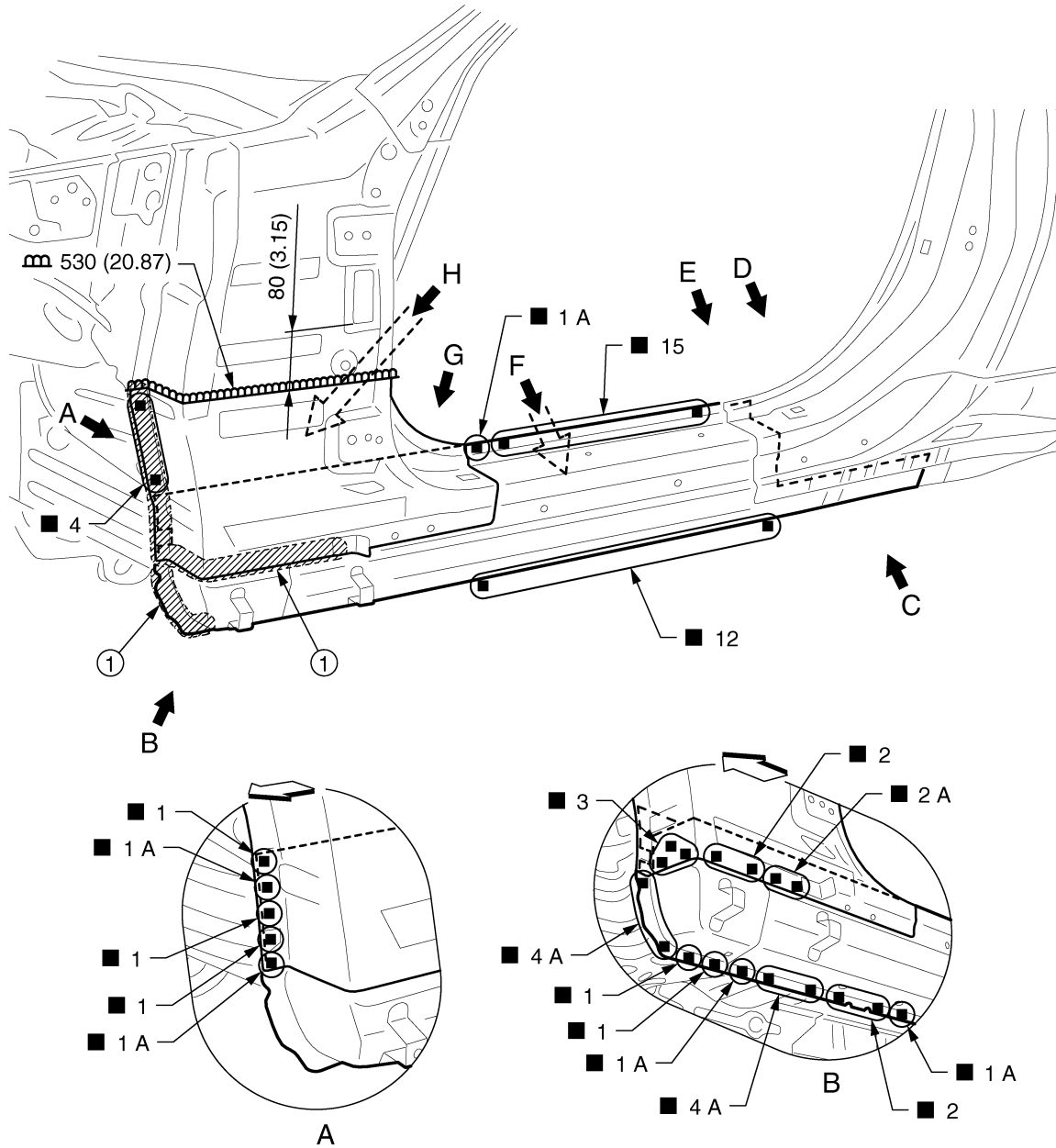
< REMOVAL AND INSTALLATION >

[COUPE (REGULAR GRADE)]

## Outer Sill (Partial Replacement by Piece)

INFOID:000000006353794

Work after hoodledge reinforcement is removed.  
Remove the front pillar brace (reusable).



A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
K  
L  
M  
N  
O  
P

BRM

1. Body sealing

Unit: mm (in)

◁: Vehicle front

Replacement parts

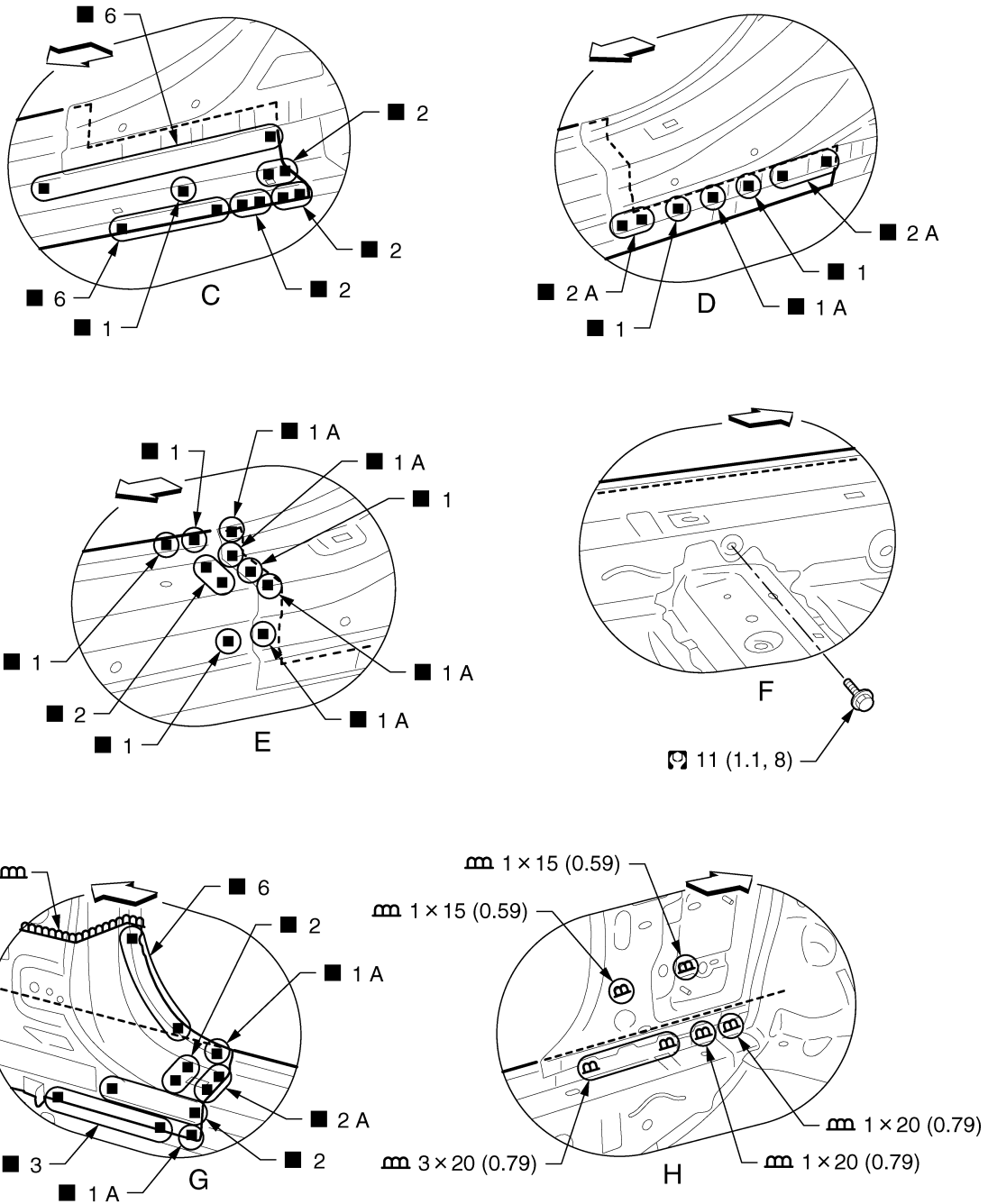
- Outer sill reinforcement (LH)

JSKIA0918GB

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[COUPE (REGULAR GRADE)]



JSKIA0919GB

Unit: mm (in)

↔: Vehicle front

Refer to [GI-4, "Components"](#) for symbols in the figure.

## Outer Sill

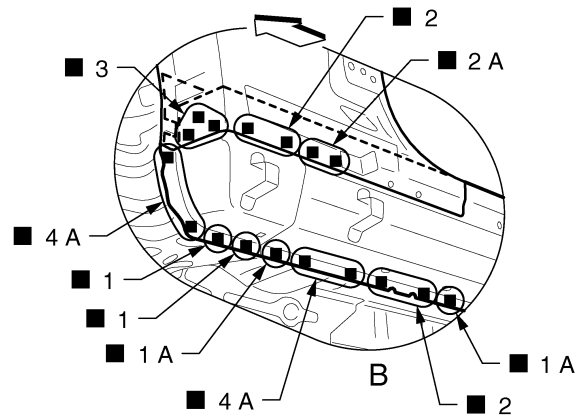
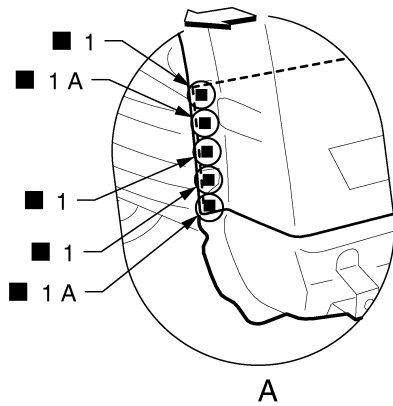
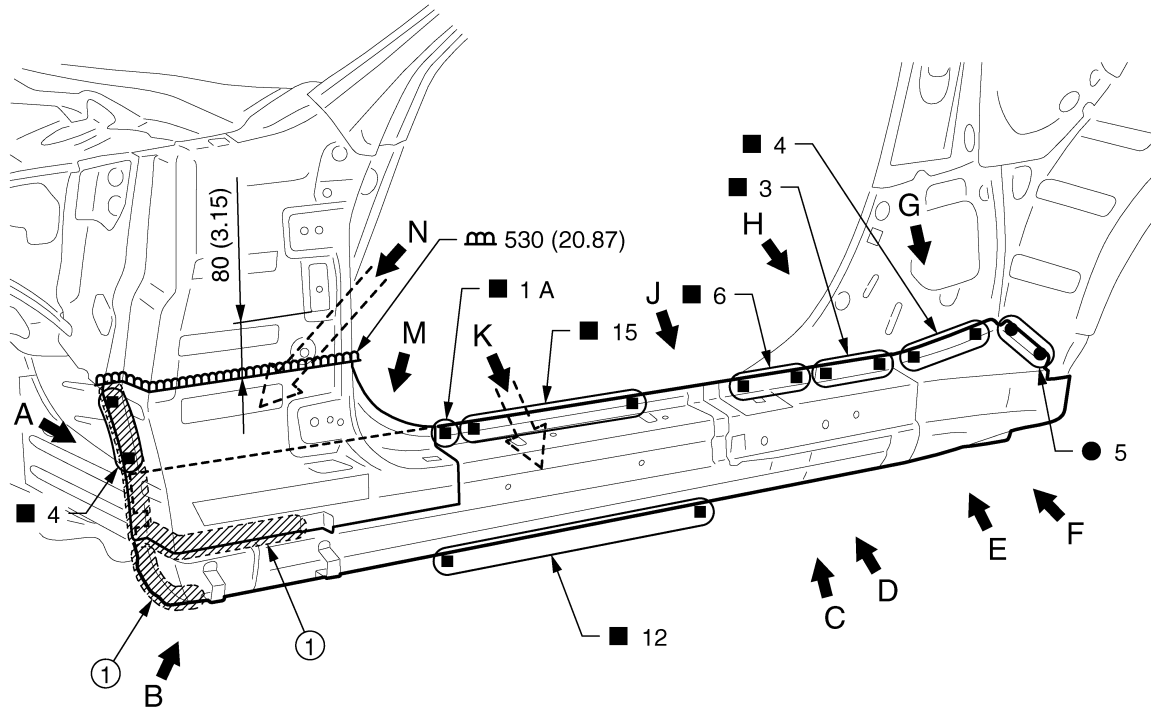
INFOID:000000006353795

Work after hoodledge reinforcement, rear fender, and lock pillar reinforcement are removed.  
Remove the front pillar brace (reusable).

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[COUPE (REGULAR GRADE)]



1. Body sealing

Unit: mm (in)

◁: Vehicle front

Replacement parts

● Outer sill reinforcement (LH)

● Outer rear wheelhouse extension (LH)

JSKIA0920GB

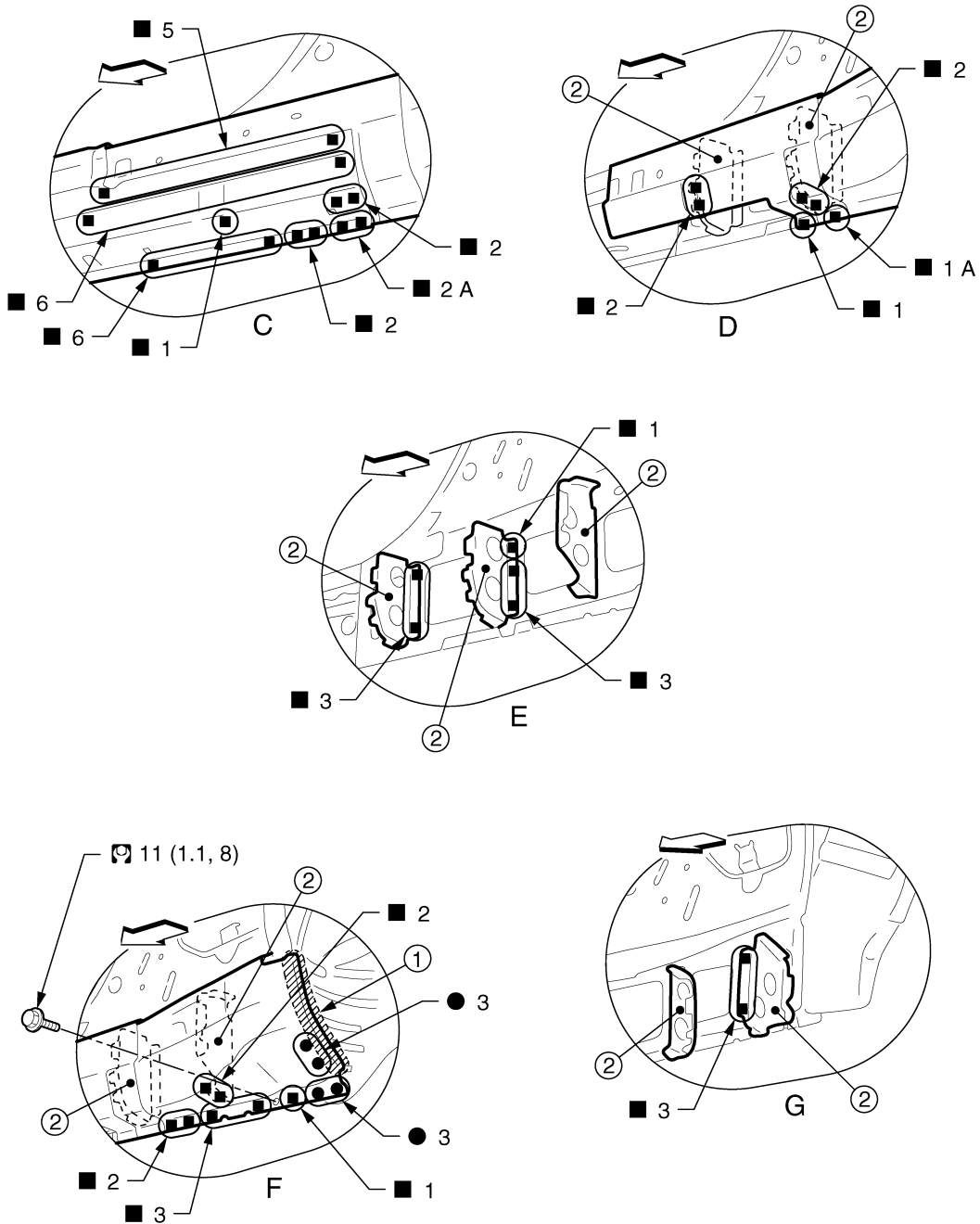
A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
L  
M  
N  
O  
P

BRM

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[COUPE (REGULAR GRADE)]



JSKIA0921GB

- 1. Body sealing
- 2. Outer sill brace

Unit: mm (in)

◁: Vehicle front

Refer to [GI-4, "Components"](#) for symbols in the figure.

View D: Before installing outer sill reinforcement

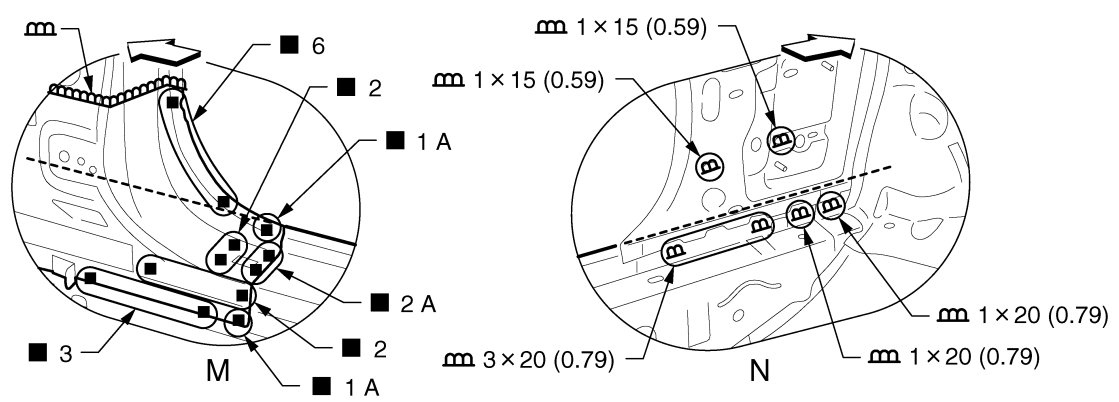
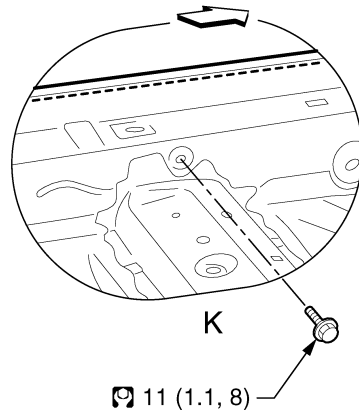
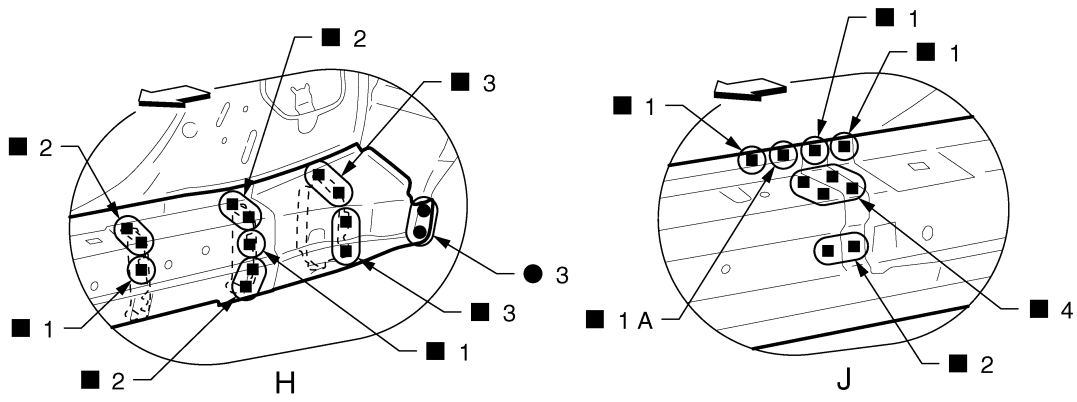
View E and G: Before installing outer rear wheelhouse extension



# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[COUPE (REGULAR GRADE)]



JSKIA0922GB

Unit: mm (in)  
 ⇐: Vehicle front

Refer to [GI-4, "Components"](#) for symbols in the figure.

View H: Before installing outer sill reinforcement

A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
K  
L  
M  
N  
O  
P

BRM

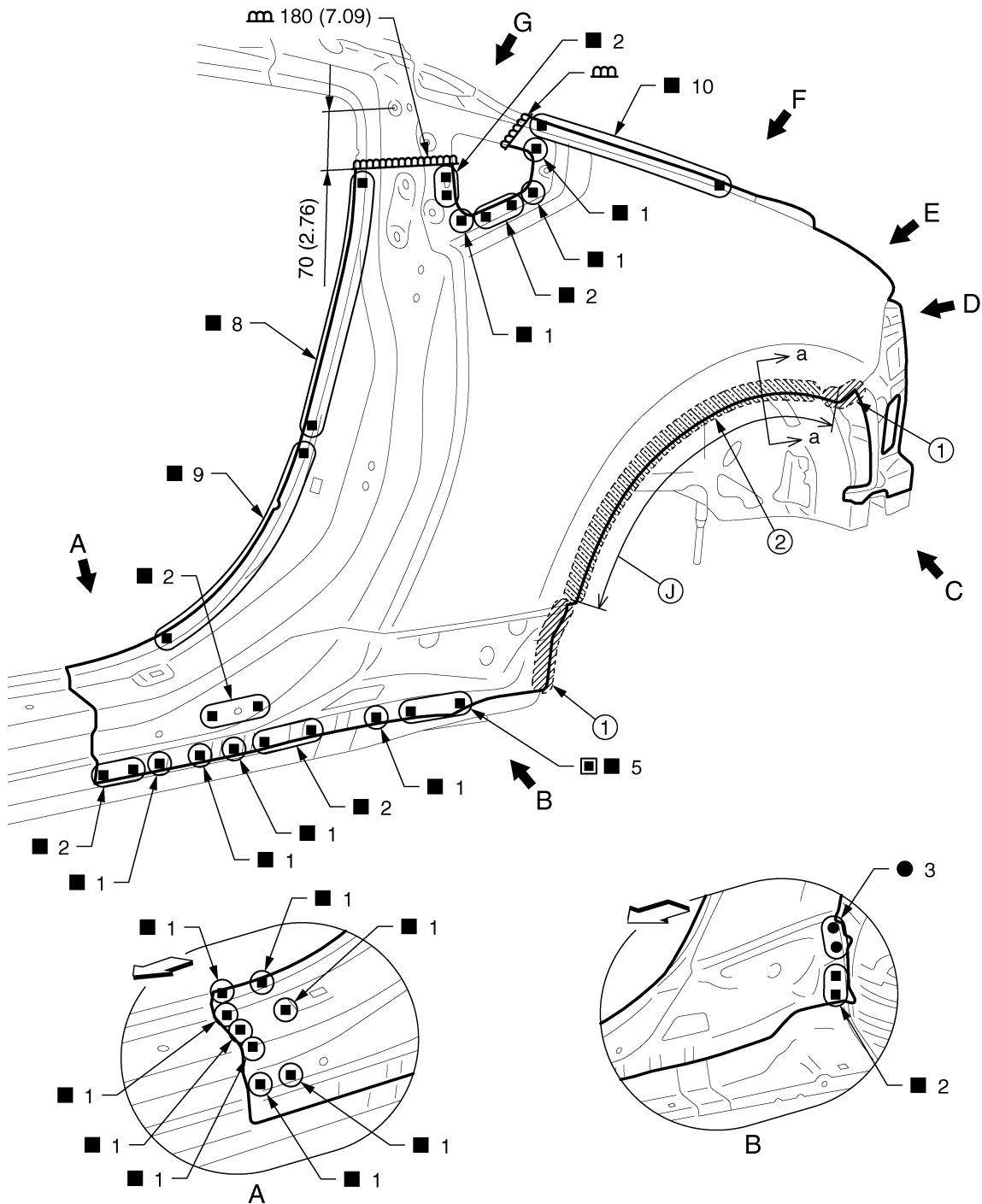
# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[COUPE (REGULAR GRADE)]

## Rear Fender

INFOID:00000006353796



JSKIA0923GB

- 1. Body sealing
- 2. Adhesive

J. Hemming portion

Unit: mm (in)

◁: Vehicle front

■: Perform the plug welding instead of the laser welding.

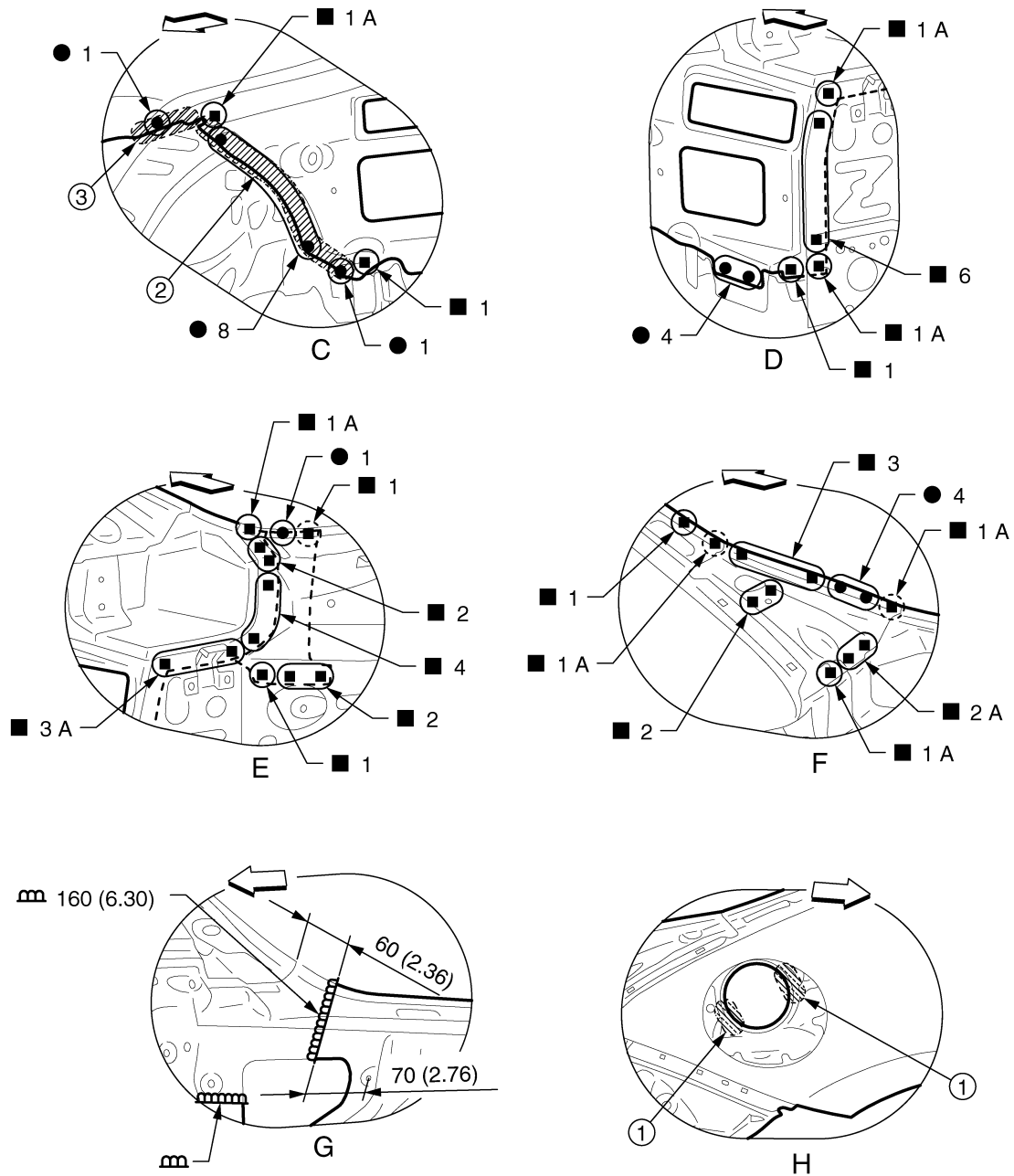
Replacement parts

- Rear fender assembly (LH)

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[COUPE (REGULAR GRADE)]



1. Adhesive

2. Body sealing

3. Urethane foam

Unit: mm (in)

⇐: Vehicle front

⊕: Weld the parts onto the back of the component part.

View H: Right side rear fender

POINT

A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
BRM  
L  
M  
N  
O  
P

JSKIA0924GB

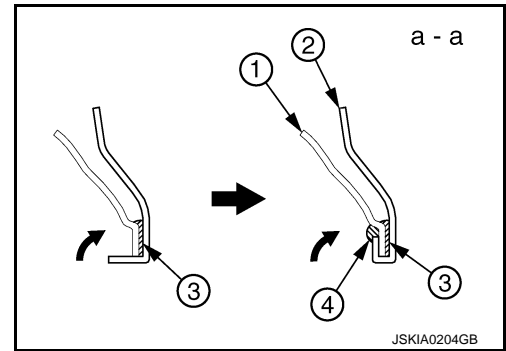
## REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[COUPE (REGULAR GRADE)]

- Perform the hemming to the flange of wheelarch after applying the adhesive.
- Apply the sealing to the flange end.
- Refer to [BRM-19. "Rear Fender Hemming Process"](#).

1. Outer rear wheelhouse
2. Rear fender
3. Adhesive
4. Sealant



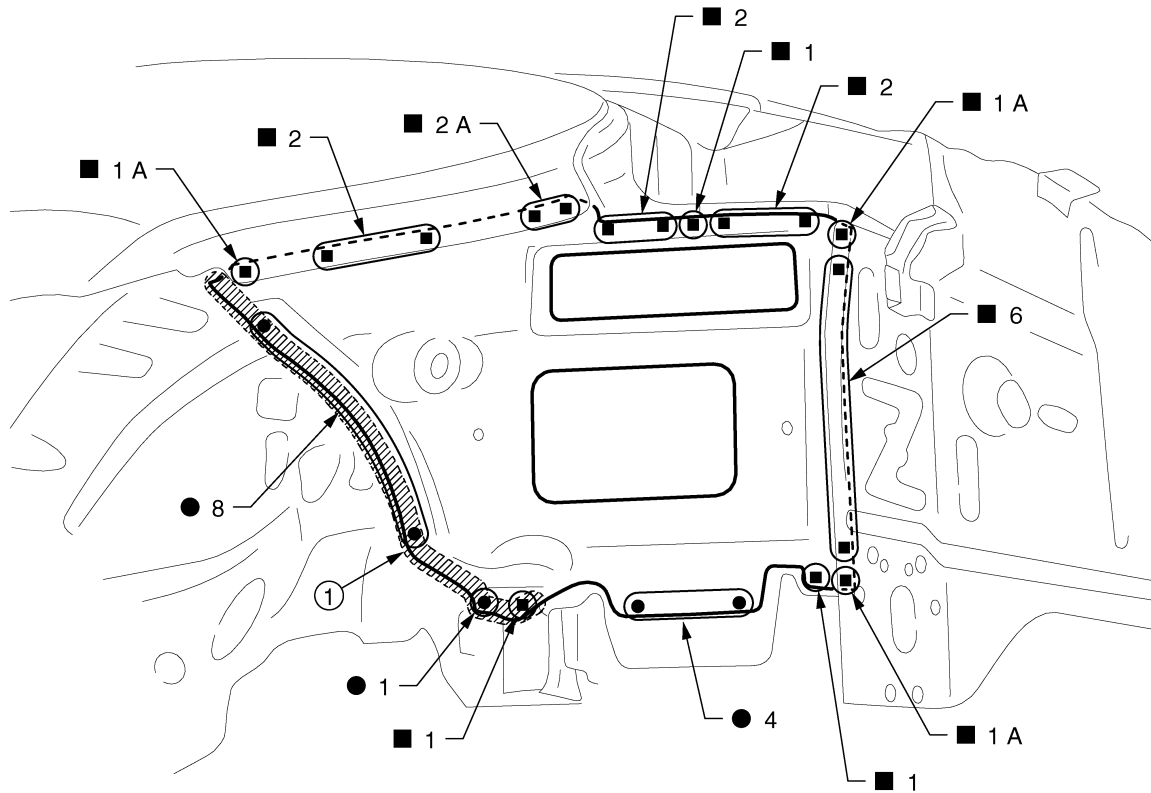
# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[COUPE (REGULAR GRADE)]

## Rear Fender Extension

INFOID:000000006353797



A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
K  
L  
M  
N  
O  
P

BRM

1. Body sealing

Replacement parts

- Rear fender extension (LH)

## Lock Pillar Reinforcement

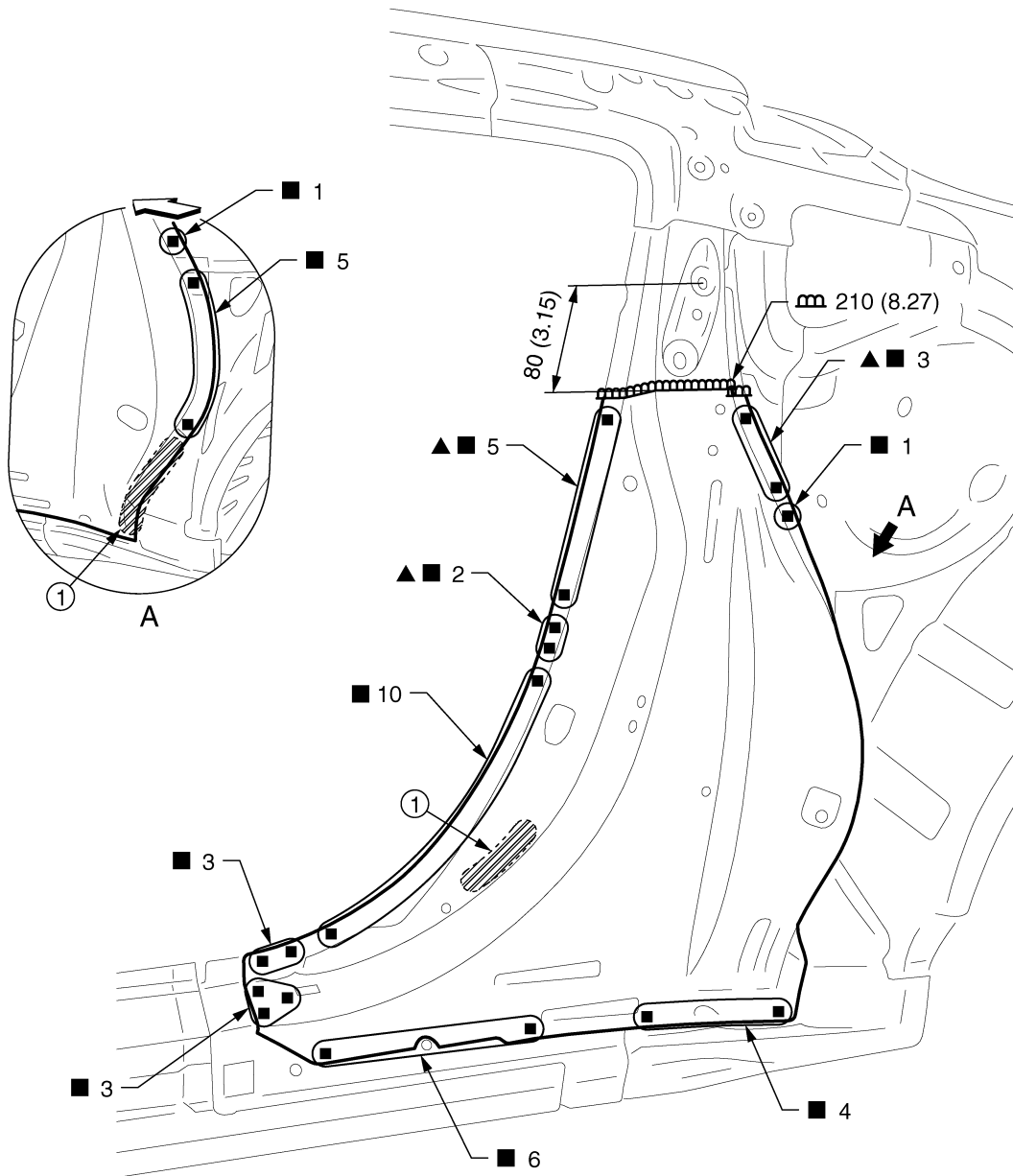
INFOID:000000006353798

Work after rear fender is removed.

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[COUPE (REGULAR GRADE)]



JSKIA0925GB

1. Urethane foam

Unit: mm (in)

↔: Vehicle front

▲: Drill  $\phi 9$  mm (0.35 in) hole for the plug welding hole (ultra high strength steel plate).

Replacement parts

- Lock pillar reinforcement assembly (LH)

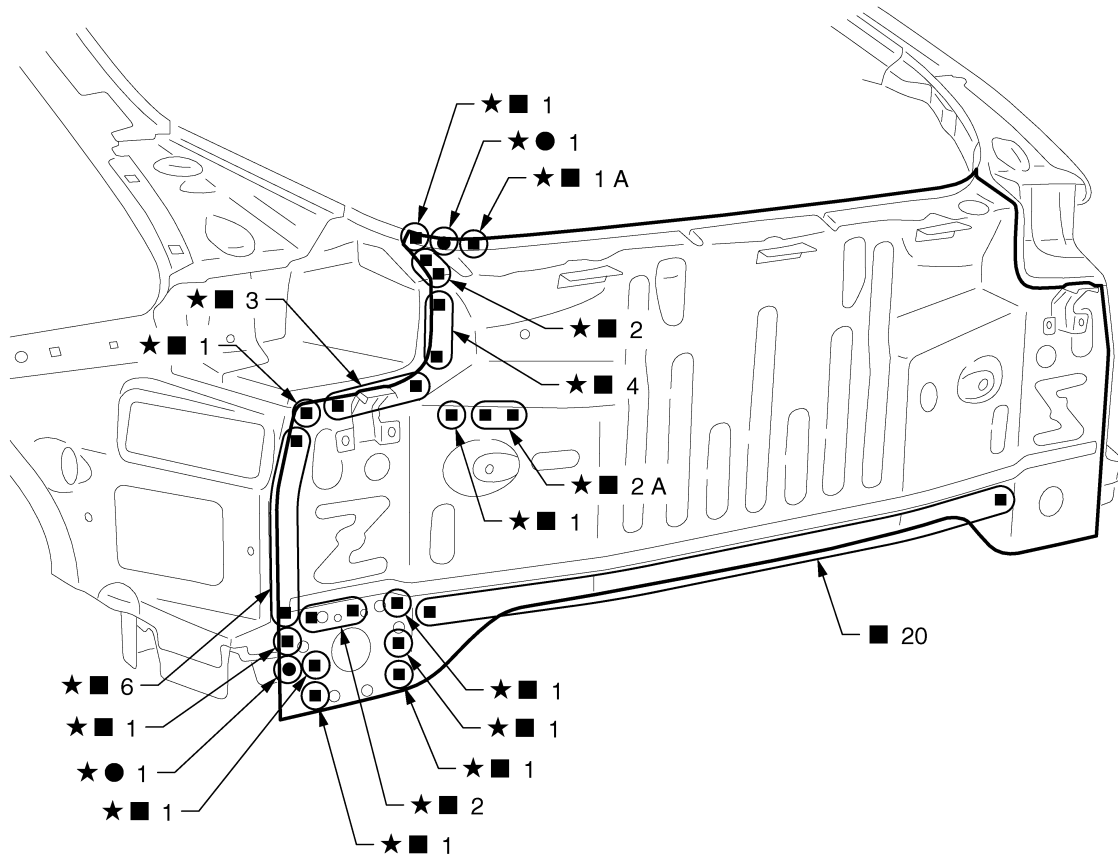
# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[COUPE (REGULAR GRADE)]

## Rear Panel

INFOID:000000006353799



A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
K  
L  
M  
N  
O  
P

BRM

★: An equivalent welding portion with the same dimensions is on the opposite side.

Replacement parts

- Rear panel assembly

## Rear Floor Rear

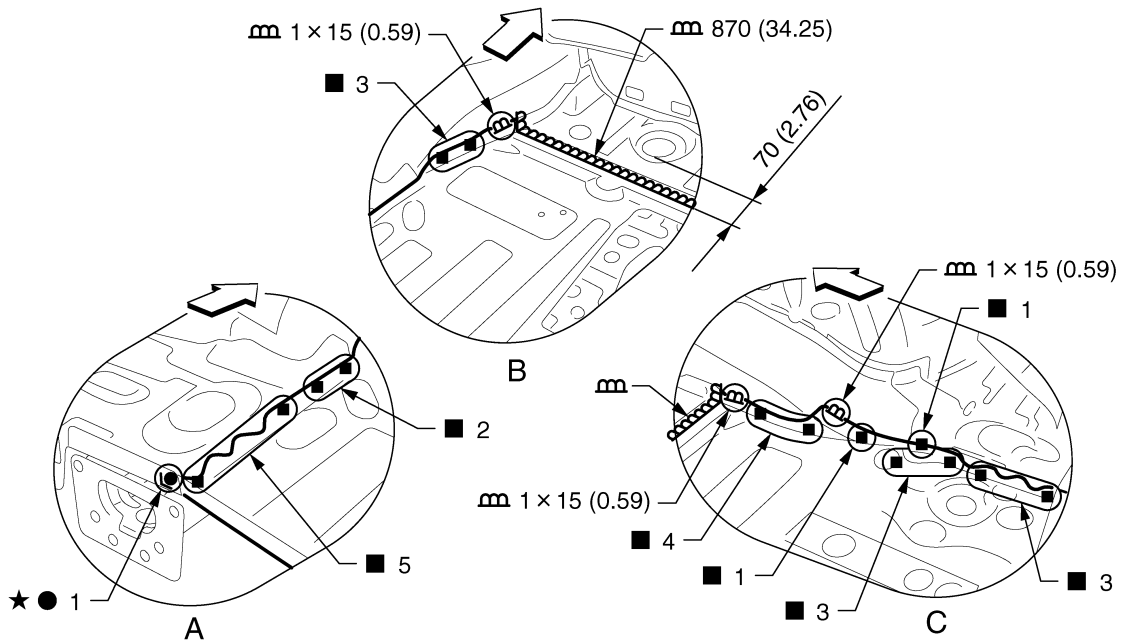
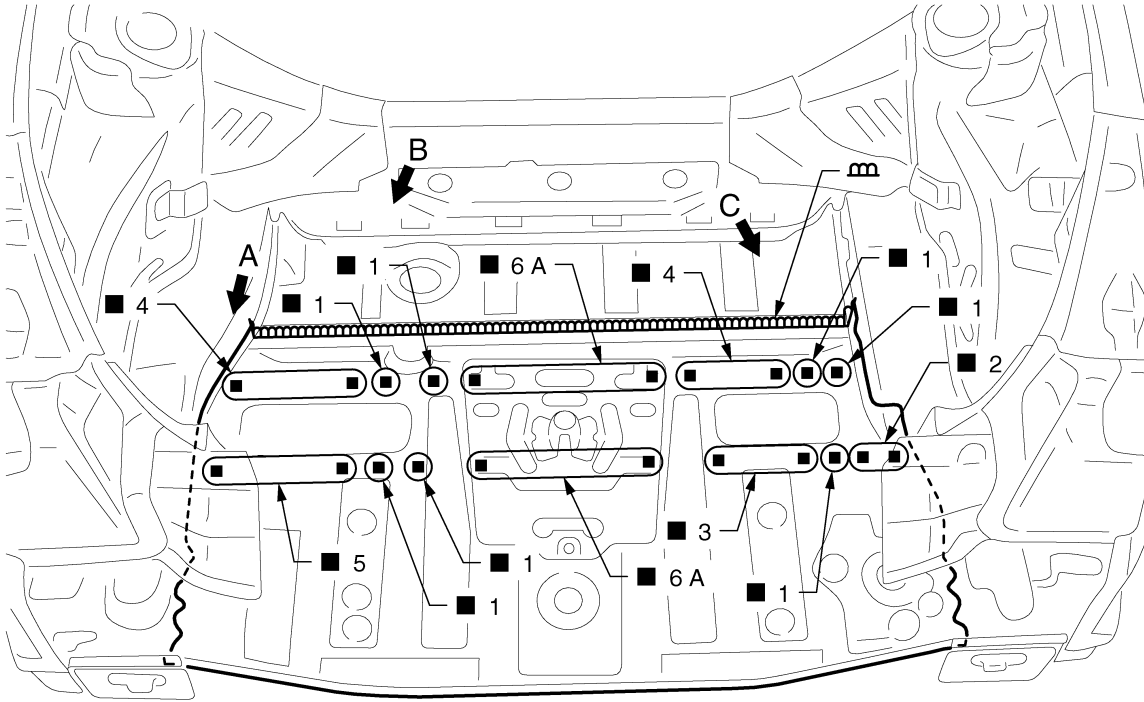
INFOID:000000006353800

Work after rear panel is removed.

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[COUPE (REGULAR GRADE)]



JSKIA0927GB

Unit: mm (in)

↔: Vehicle front

★: An equivalent welding portion with the same dimensions is on the opposite side.

Replacement parts

- Rear floor rear

## Rear Side Member Extension

INFOID:000000006353801

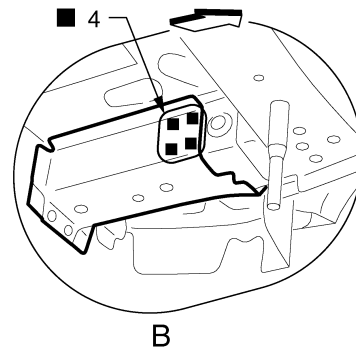
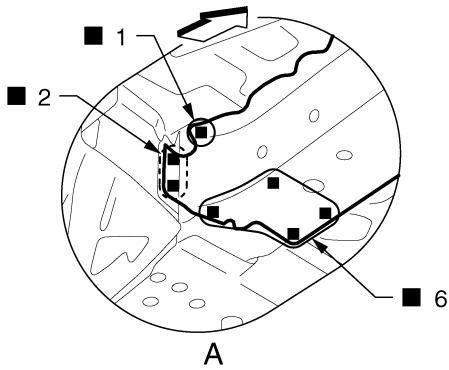
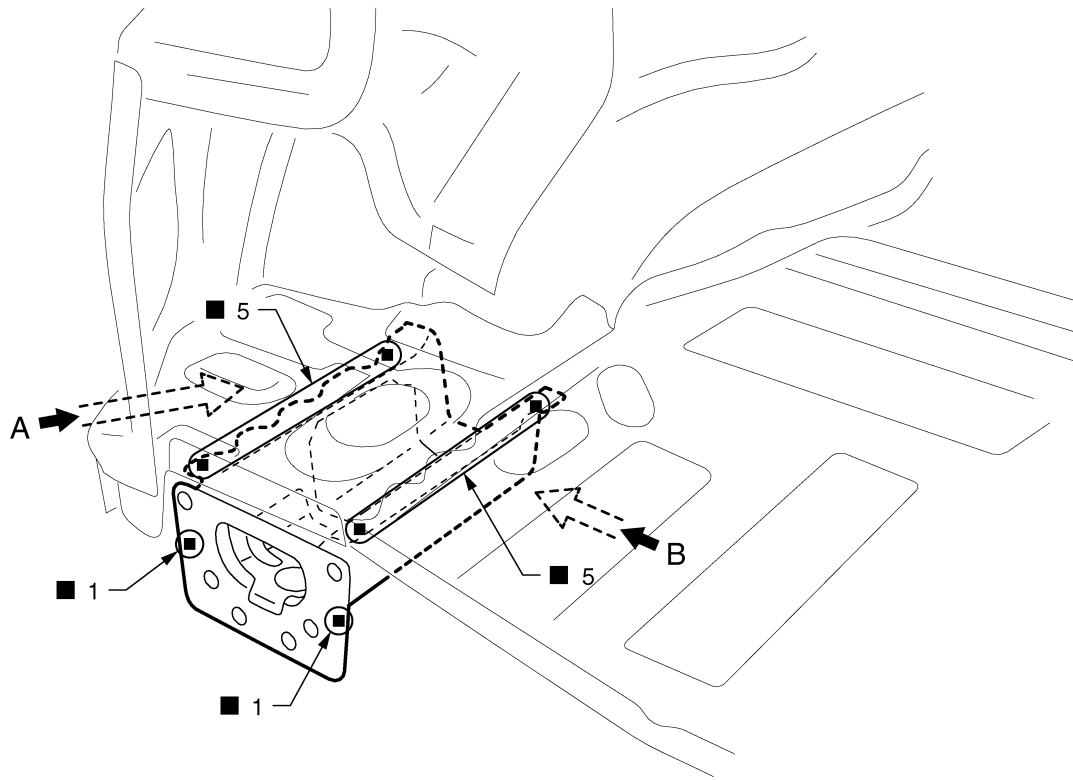
Work after rear panel is removed.



# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[COUPE (REGULAR GRADE)]



JSKIA0928ZZ

←: Vehicle front

○: Weld the parts onto the back of the component part.

Replacement parts

- Rear side member extension (LH)

A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
K  
L  
M  
N  
O  
P

BRM

# BODY ALIGNMENT

< SERVICE DATA AND SPECIFICATIONS (SDS)

[COUPE (REGULAR GRADE)]

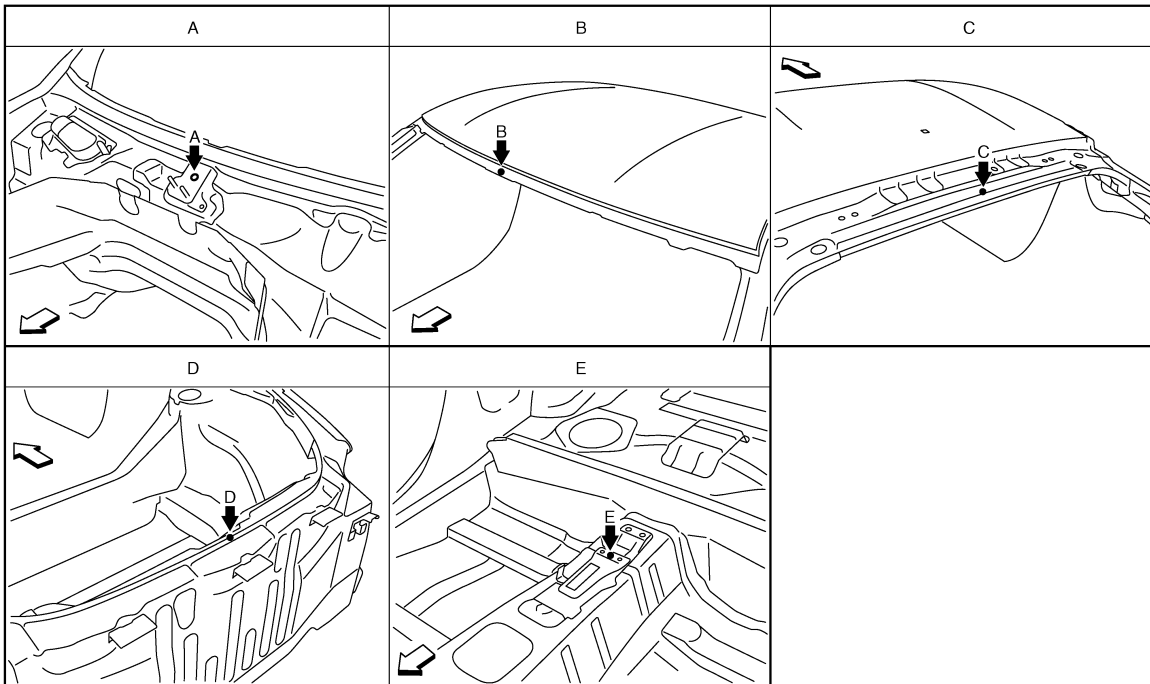
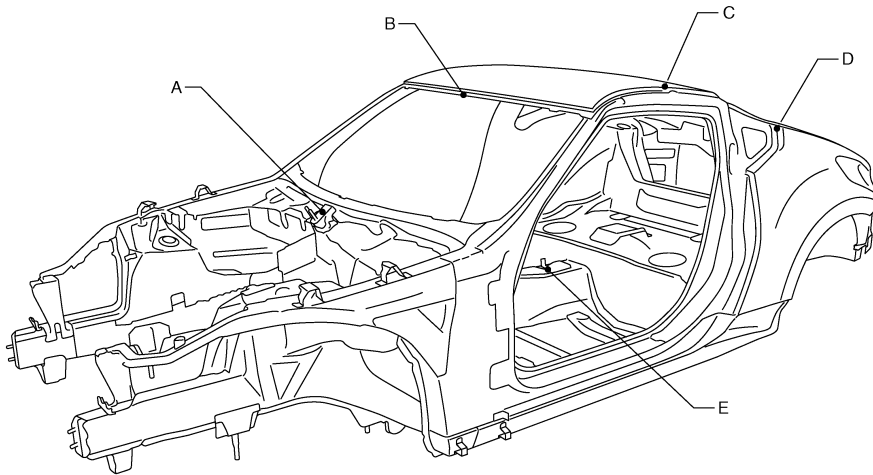
## SERVICE DATA AND SPECIFICATIONS (SDS)

### BODY ALIGNMENT

#### Body Center Marks

INFOID:000000006353802

A mark is placed on each part of the body to indicate the vehicle center. When repairing the vehicle frame (members, pillars, etc.) damaged by an accident which it enables more accurate and effective repair by using these marks together with body alignment specifications.



JSKIA0883ZZ

↶: Vehicle front

Unit: mm (in)

Points	Portion	Marks
A	Upper dash	Hole $\phi 8$ (0.31)
B	Front roof	Embossment
C	Rear roof	Embossment

# BODY ALIGNMENT

< SERVICE DATA AND SPECIFICATIONS (SDS)

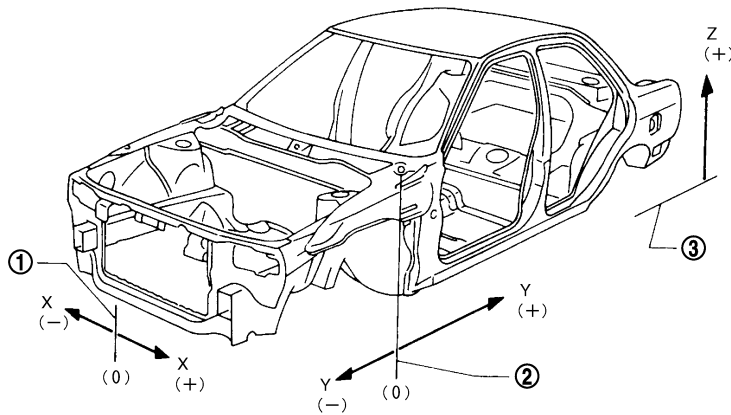
[COUPE (REGULAR GRADE)]

Points	Portion	Marks
D	Rear panel	Indent
E	Trans control reinforcement	Embossment

## Description

INFOID:000000006353803

- All dimensions indicated in the figures are actual.
- When using a tracking gauge, adjust both pointers to equal length. Then check the pointers and gauge itself to make sure there is no free play.
- When a measuring tape is used, check to be sure there is no elongation, twisting or bending.
- Measurements should be taken at the center of the mounting holes.
- An asterisk (\*) following the value at the measuring point indicates that the measuring point on the other side is symmetrically the same value.
- The coordinates of the measurement points are the distances measured from the standard line of "X", "Y" and "Z".
- "Z": Imaginary base line [200 mm (7.87 in) below datum line ("0Z" at design plan)]



JSKIA0073GB

1. Vehicle center

2. Front axle center

3. Imaginary base line

## Engine Compartment

INFOID:000000006353804

### MEASUREMENT

Dimensions marked with "\*" indicate symmetrically identical dimensions on both the right and left hand of the vehicle.

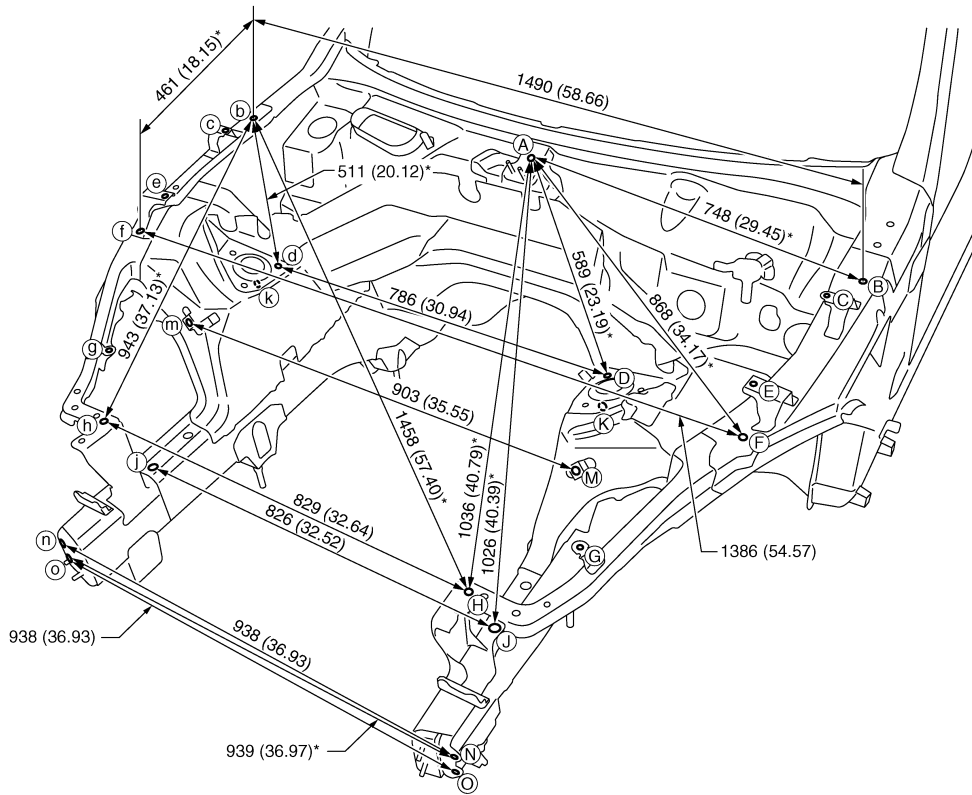
A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
L  
M  
N  
O  
P

BRM

# BODY ALIGNMENT

< SERVICE DATA AND SPECIFICATIONS (SDS)

[COUPE (REGULAR GRADE)]



JSKIA0884GB

Unit: mm (in)

«The others»

Unit: mm (in)

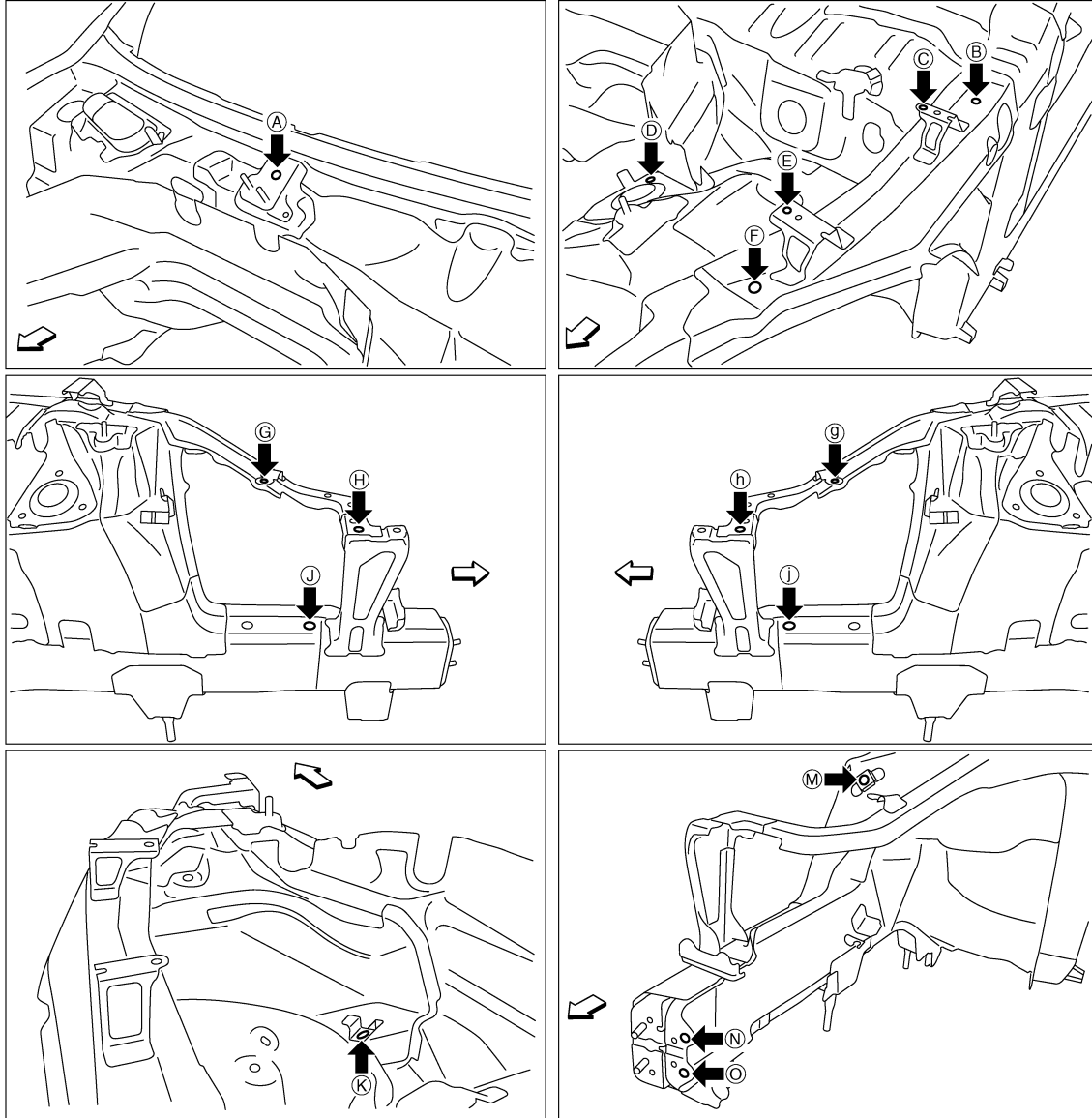
Point	Dimension	Memo	Point	Dimension	Memo	Point	Dimension	Memo	Point	Dimension	Memo
A - C	735 (28.94)*		B - d	1197 (47.13)*		C - c	1423 (56.02)		F - h	1187 (46.73)*	
A - E	804 (31.65)*		B - E	381 (15.00)*		D - m	875 (34.45)*		G - g	1073 (42.24)	
A - G	967 (38.07)*		B - f	1509 (59.41)*		E - e	1349 (53.11)		K - k	903 (35.55)	
B - C	131 (5.16)*		B - G	767 (30.20)*		F - H	511 (20.12)*				

## MEASUREMENT POINTS

# BODY ALIGNMENT

< SERVICE DATA AND SPECIFICATIONS (SDS)

[COUPE (REGULAR GRADE)]



A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
K  
L  
M  
N  
O

BRM

JSKIA0885ZZ

← Vehicle front

Unit: mm (in)

Point	Material	Point	Material
A	Center wiper pivot bracket hole center of center positioning mark $\phi 8$ (0.31)	H, h	Radiator core support stay hole center $\phi 12$ (0.47)
B, b, F, f	Hoodedge reinforcement hole center 12×14 (0.47×0.55)	J, j	Front side member hole center $\phi 20$ (0.79)
C, c, E, e	Front fender installing hole center $\phi 7$ (0.28)	K, k, M, m	Nut holder hole center $\phi 16$ (0.63)
D, d	Front strut installing hole center $\phi 11$ (0.43)	N, n, O, o	Front bumper reinforcement installing hole center $\phi 11$ (0.43)
G, g	Rear air cleaner bracket hole center $\phi 7$ (0.28)		

## Underbody

INFOID:000000006353805

## MEASUREMENT

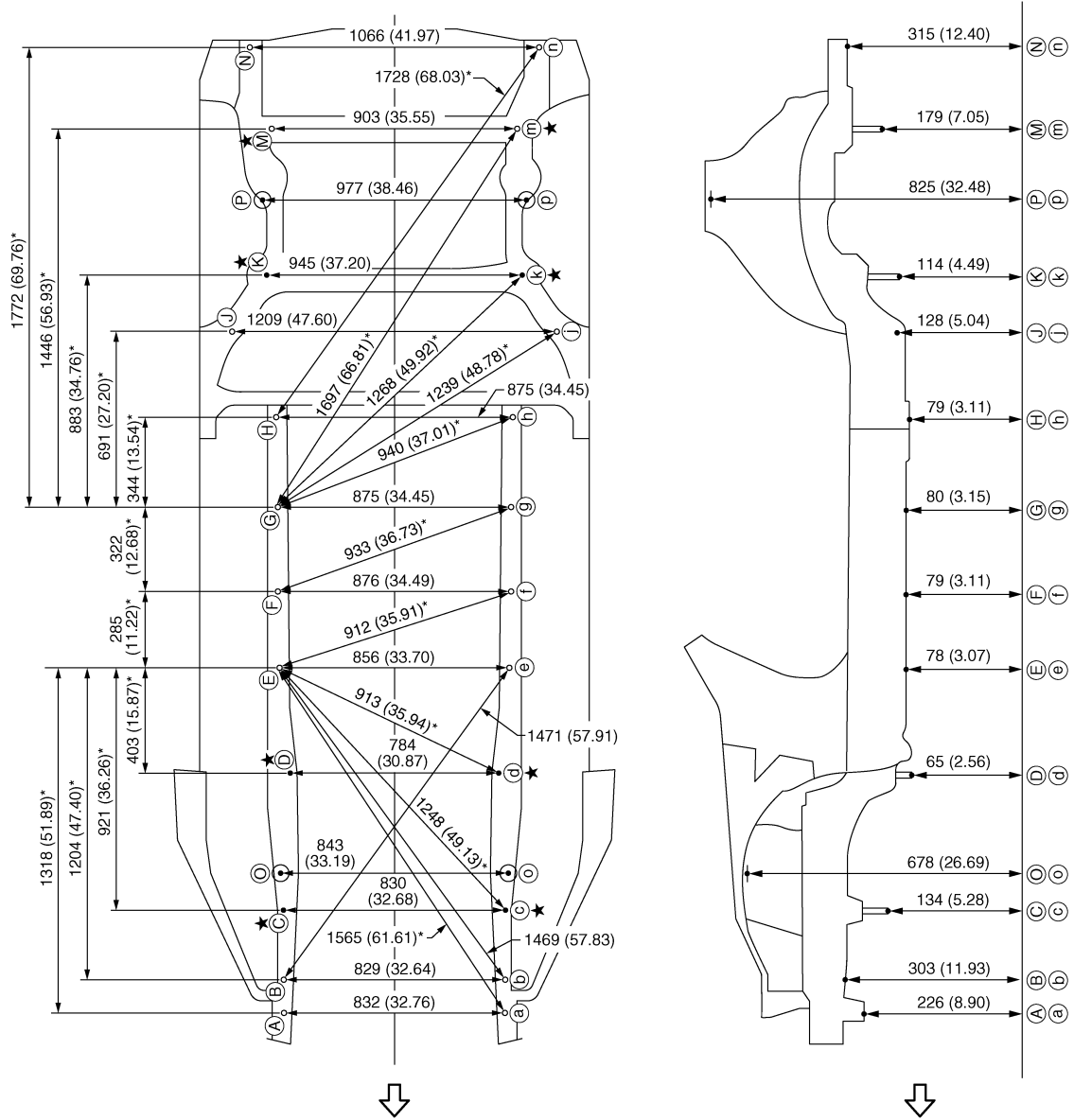
# BODY ALIGNMENT

< SERVICE DATA AND SPECIFICATIONS (SDS)

[COUPE (REGULAR GRADE)]

Dimensions marked with "\*" indicate symmetrically identical dimensions on both the right and left hand of the vehicle.

The following figure shows a bottom view and a side view of the vehicle.



JSKIA0886GB

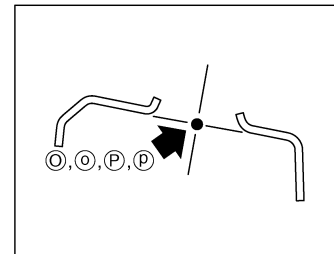
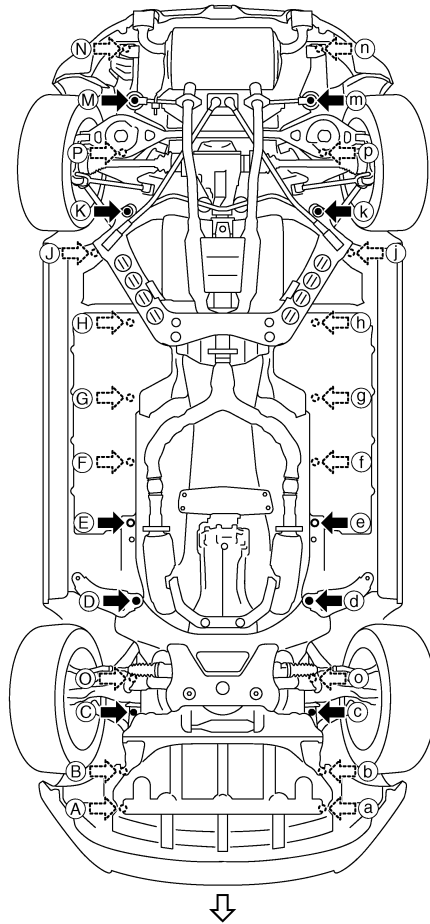
- Unit: mm (in)
- ↳ Vehicle front
- ★: Bolt head

## MEASUREMENT POINTS

# BODY ALIGNMENT

< SERVICE DATA AND SPECIFICATIONS (SDS)

[COUPE (REGULAR GRADE)]



A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
K  
L  
M  
N  
O  
P  
BRM

JSKIA0887ZZ

← Vehicle front

Unit: mm (in)

Points	Coordinates			Remarks	Points	Coordinates			Remarks
	X	Y	Z			X	Y	Z	
A, a	±415.8 (±16.370)	-495.0 (-19.488)	225.6 (8.882)	Hole φ13 (0.51)	H, h	±437.5 (±17.224)	1765.5 (69.508)	79.0 (3.110)	Hole φ8 (0.31)
B	416.2 (16.386)	-368.0 (-14.488)	303.2 (11.937)	Hole φ16 (0.63)	J, j	±604.5 (±23.799)	2090.5 (82.303)	128.3 (5.051)	Hole φ16 (0.63)
b	-413.2 (-16.268)	-368.0 (-14.488)	303.2 (11.937)	Hole φ16 (0.63)	K, k	±472.6 (±18.606)	2303.8 (90.701)	114.0 (4.488)	Bolt head
C, c	±415.0 (±16.339)	-104.0 (-4.094)	133.5 (5.256)	Bolt head	M, m	±451.5 (±17.776)	2863.9 (112.752)	179.1 (7.051)	Bolt head
D, d	±392.0 (±15.433)	414.0 (16.299)	64.5 (2.539)	Bolt head	N, n	±533.0 (±20.984)	3175.0 (125.000)	315.4 (12.417)	Hole φ16 (0.63)
E, e	±428.0 (±16.850)	815.0 (32.087)	78.4 (3.087)	Hole 16×20 (0.63×0.79)	O, o	±421.6 (±16.598)	38.2 (1.504)	677.9 (26.689)	Hole φ50.1 (1.972)

# BODY ALIGNMENT

< SERVICE DATA AND SPECIFICATIONS (SDS)

[COUPE (REGULAR GRADE)]

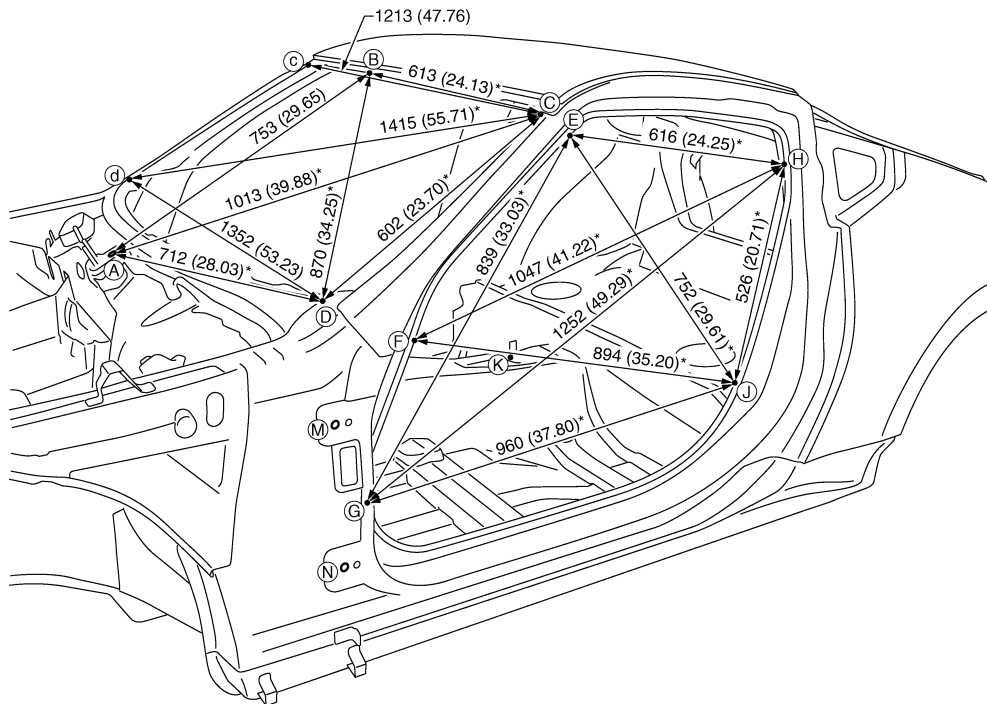
Points	Coordinates			Remarks	Points	Coordinates			Remarks
	X	Y	Z			X	Y	Z	
F, f	±438.0 (±17.244)	1100.0 (43.307)	79.0 (3.110)	Hole φ16 (0.63)	P, p	±488.4 (±19.228)	2591.7 (102.035)	825.0 (32.480)	Hole φ68 (2.68)
G, g	±437.5 (±17.224)	1421.8 (55.976)	80.0 (3.150)	Hole φ8 (0.31)					

## Passenger Compartment

INFOID:000000006353806

### MEASUREMENT

Dimensions marked with "\*" indicate symmetrically identical dimensions on both the right and left hand of the vehicle.



JSKIA0888GB

Unit: mm (in)

«The others»

Unit: mm (in)

Point	Dimension	Memo	Point	Dimension	Memo	Point	Dimension	Memo	Point	Dimension	Memo
E - e	1276 (50.24)		F - j	1713 (67.44)*		J - j	1471 (57.91)		M - m	1615 (63.58)	
E - g	1599 (62.95)*		G - g	1452 (57.17)		K - E	1024 (40.31)*		M - H	1273 (50.12)*	
E - h	1449 (57.05)*		G - h	1877 (73.90)*		K - F	1094 (43.07)*		M - J	1074 (42.28)*	
E - j	1563 (61.54)*		G - j	1749 (68.86)*		K - G	1095 (43.11)*		N - n	1649 (64.92)	
F - f	1452 (57.17)		H - h	1348 (53.07)		K - H	978 (38.50)*		N - H	1376 (54.17)*	
F - h	1748 (68.82)*		H - j	1504 (59.21)*		K - J	763 (30.04)*		N - J	1071 (42.17)*	

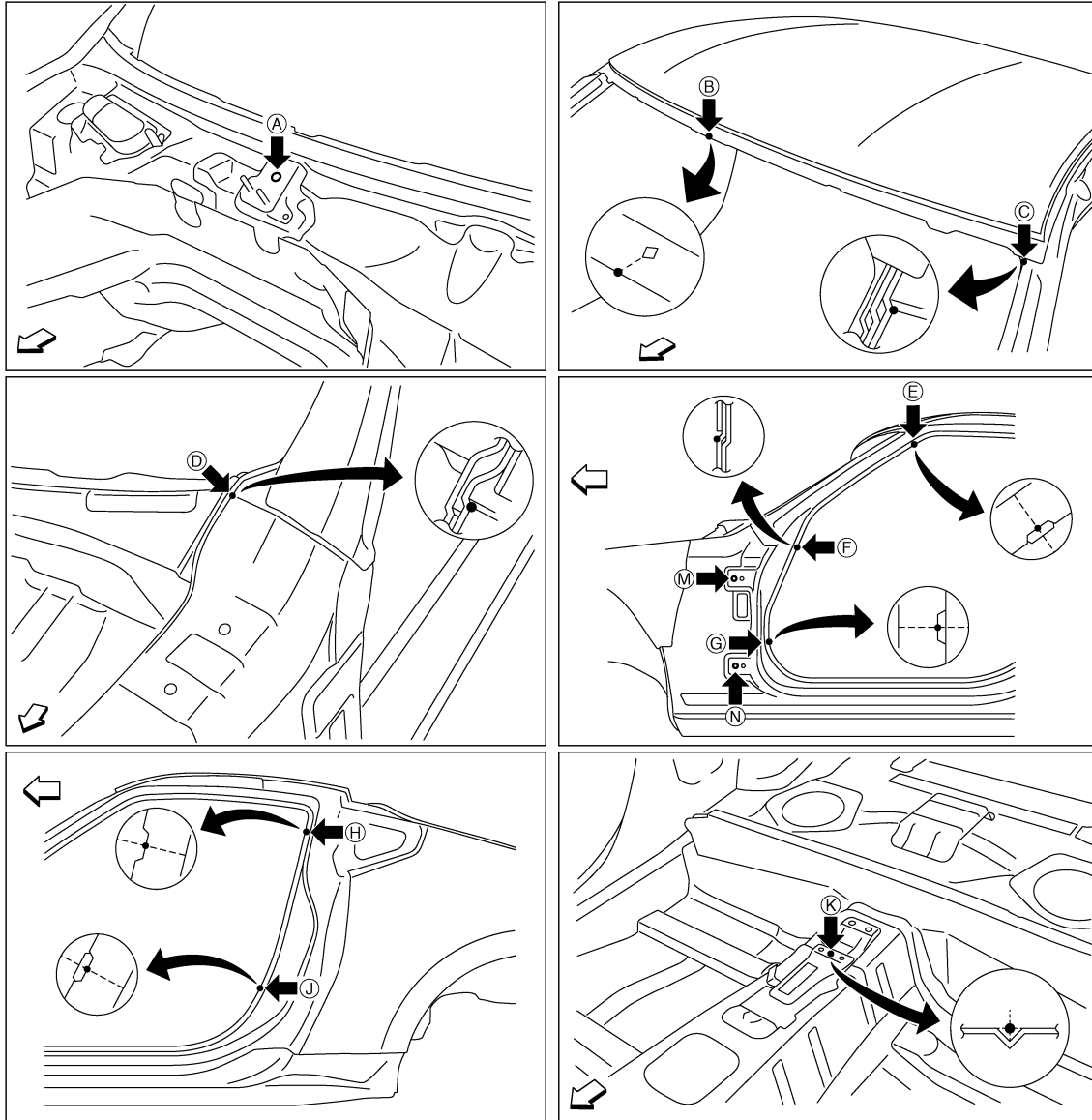
### MEASUREMENT POINTS



# BODY ALIGNMENT

< SERVICE DATA AND SPECIFICATIONS (SDS)

[COUPE (REGULAR GRADE)]



JSKIA0889ZZ

↶: Vehicle front

Unit: mm (in)

Point	Material	Point	Material
A	Center wiper pivot bracket hole center of center positioning mark $\phi 8$ (0.31)	G, g	Front pillar hinge brace indent
B	Roof flange end of center positioning mark	H, h, J, j	Rear fender indent
C, c	Front pillar joggle	K	Trans control reinforcement positioning mark of center positioning mark
D, d, F, f	Front pillar hinge brace joggle	M, m, N, n	Door hinge installing hole center $\phi 12$ (0.47)
E, e	Front pillar indent		

## Rear Body

INFOID:000000006353807

### MEASUREMENT

Dimensions marked with "\*" indicate symmetrically identical dimensions on both the right and left hand of the vehicle.

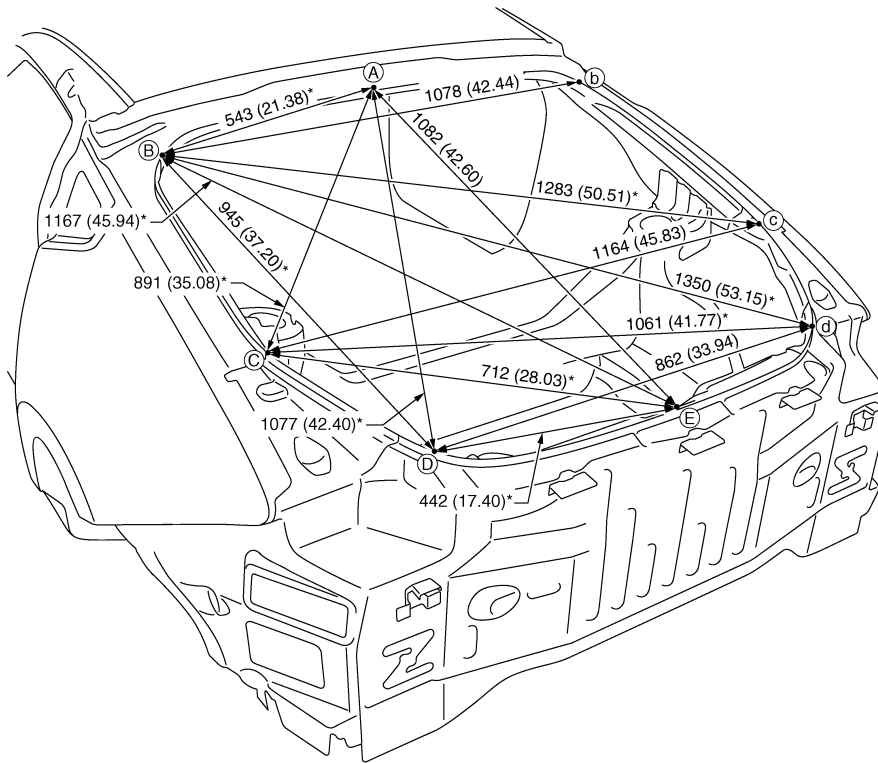
A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
L  
M  
N  
O  
P

BRM

# BODY ALIGNMENT

< SERVICE DATA AND SPECIFICATIONS (SDS)

[COUPE (REGULAR GRADE)]



JSKIA0890GB

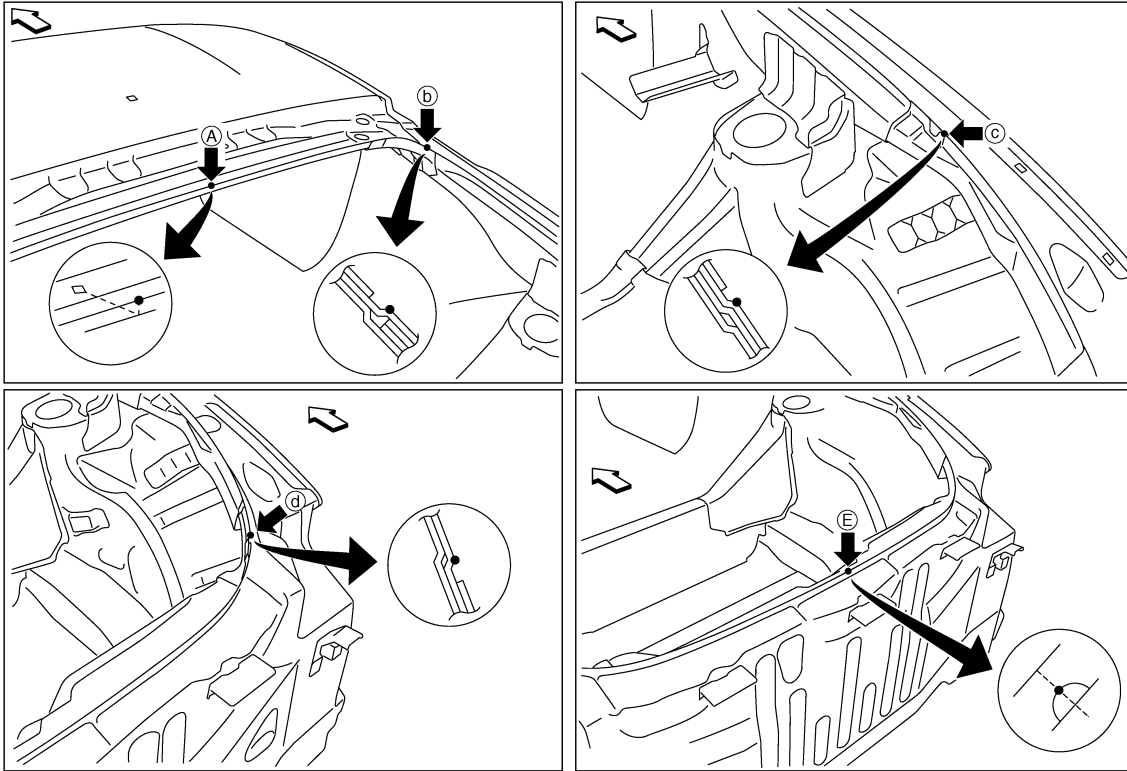
Unit: mm (in)

## MEASUREMENT POINTS

# BODY ALIGNMENT

< SERVICE DATA AND SPECIFICATIONS (SDS)

[COUPE (REGULAR GRADE)]



JSKIA0891ZZ

←: Vehicle front

Point	Material	Point	Material
A	Roof flange end of center positioning mark	D, d	Rear combination lamp base joggle
B, b	Rear fender joggle	E	Upper rear panel reinforcement indent of center positioning mark
C, c	Rear combination lamp base extension joggle		

BRM

L

M

N

O

P

# LOCATION OF PLASTIC PARTS

< SERVICE DATA AND SPECIFICATIONS (SDS)

[COUPE (REGULAR GRADE)]

## LOCATION OF PLASTIC PARTS

### Precautions for Plastics

INFOID:000000006353808

Abbreviation	Material name	Heatresisting temperature °C (°F)	Resistance to gasoline and solvents	Other cautions
PE	Polyethylene	60 (140)	Gasoline and most solvents are harmless if applied for a very short time (wipe out quickly).	Flammable
ABS	Acrylonitrile Butadiene Styrene	80 (176)	Avoid gasoline and solvents.	—
EPM/EPDM	Ethylene Propylene (Diene) copolymer	80 (176)	Gasoline and most solvents are harmless if applied for a very short time (wipe out quickly).	Flammable
PS	Polystyrene	80 (176)	Avoid solvents.	Flammable
PVC	Poly Vinyl Chloride	80 (176)	Gasoline and most solvents are harmless if applied for a very short time (wipe out quickly).	Poisonous gas is emitted when burned.
TPO	Thermoplastic Olefine	80 (176)	↑	Flammable
AAS	Acrylonitrile Acrylic Styrene	85 (185)	Avoid gasoline and solvents.	—
PMMA	Poly Methyl Methacrylate	85 (185)	↑	—
EVAC	Ethylene Vinyl Acetate	90 (194)	↑	—
PP	Polypropylene	90 (194)	Gasoline and most solvents are harmless if applied for a very short time (wipe out quickly).	Flammable, avoid battery acid.
PUR	Polyurethane	90 (194)	Avoid gasoline and solvents.	—
UP	Unsaturated Polyester	90 (194)	↑	Flammable
ASA	Acrylonitrile Styrene Acrylate	100 (212)	↑	Flammable
PPE	Poly Phenylene Ether	110 (230)	↑	—
TPU	Thermoplastic Urethane	110 (230)	↑	—
PBT+PC	Poly Butylene Terephthalate + Polycarbonate	120 (248)	↑	Flammable
PC	Polycarbonate	120 (248)	↑	—
POM	Poly Oxymethylene	120 (248)	↑	Avoid battery acid.
PA	Polyamide	140 (284)	↑	Avoid immersing in water.
PBT	Poly Butylene Terephthalate	140 (284)	↑	—
PAR	Polyarylate	180 (356)	↑	—
PET	Polyethylene terephthalate	180 (356)	↑	—
PEI	Polyetherimide	200 (392)	↑	—

**CAUTION:**

- When repairing and painting a portion of the body adjacent to plastic parts, consider their characteristics (influence of heat and solvent) and remove them if necessary or take suitable measures to protect them.
- Plastic parts should be repaired and painted using methods suiting the materials' characteristics.

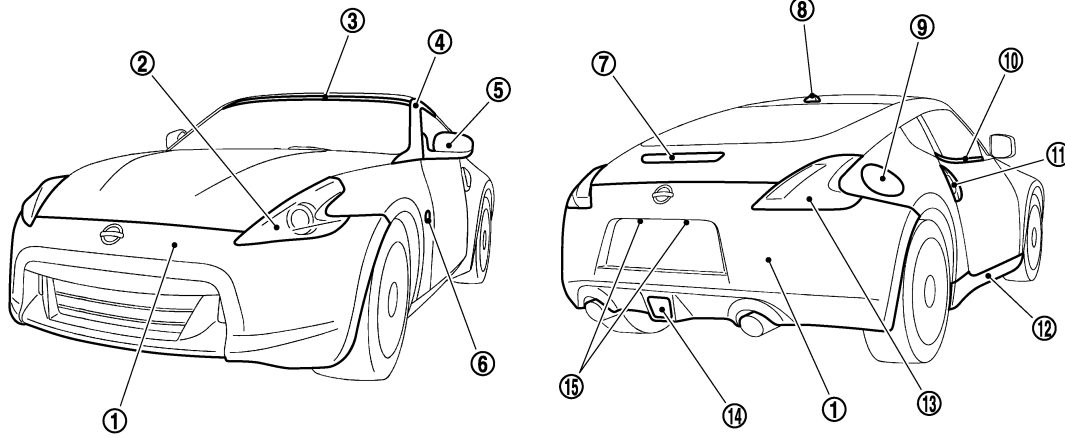
# LOCATION OF PLASTIC PARTS

< SERVICE DATA AND SPECIFICATIONS (SDS)

[COUPE (REGULAR GRADE)]

## Location of Plastic Parts

INFOID:000000006353809



JSKIA0902ZZ

Component		Material	Component		Material		
1	Bumper fascia	PP + EPM	8	Satellite radio antenna	ASA + PC		
2	Front combination lamp	Lens	9	Fuel filler lid	PA + PPE		
		Housing	10	Door outside molding	PVC + Stainless		
3	Upper windshield molding	TPO	11	Door outside handle	PC + ABS		
4	Front pillar finisher	PC + PET	12	Center mudguard	PP + EPM		
5	Door outside mirror	Cover	13	Rear combination lamp	Lens	PMMA	
		Housing			ASA	Housing	PP
		Base		PA + Glass fiber	14	Rear fog lamp	Lens
6	Side turn signal lamp	Lens	PMMA				
6	Side turn signal lamp	Housing	ABS	Housing	ABS		
		7	High mount stop lamp	Lens	PMMA		
7	High mount stop lamp	Housing	ASA	15	License plate lamp	Lens	PMMA
					Housing	PC	

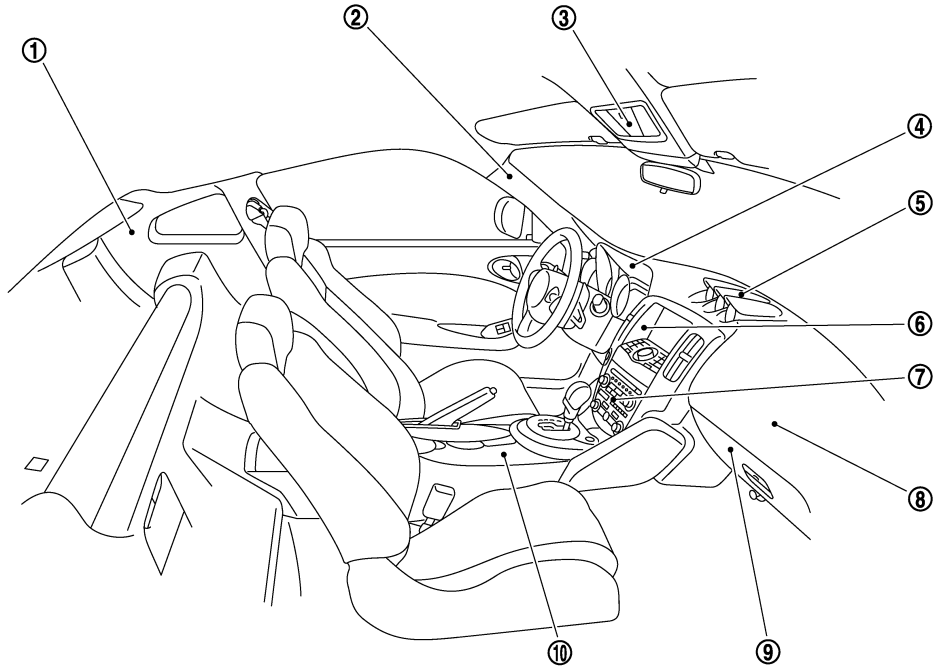
A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
K  
L  
M  
N  
O  
P

BRM

# LOCATION OF PLASTIC PARTS

< SERVICE DATA AND SPECIFICATIONS (SDS)

[COUPE (REGULAR GRADE)]



JSKIA0903ZZ

Component		Material	Component		Material
1	Rear pillar finisher	PP	6	Cluster lid C	PC + ABS
2	Front pillar garnish	PP	7	Cluster lid C finisher	PC + ABS
3	Map lamp	Lens	8	Instrument panel	Skin
		Housing			PP
4	Cluster lid A	PP	9	Glove box	PP
5	Triple meter panel	PP	10	Center console	PP

# BODY EXTERIOR PAINT COLOR

< SPEC CHANGE INFORMATION >

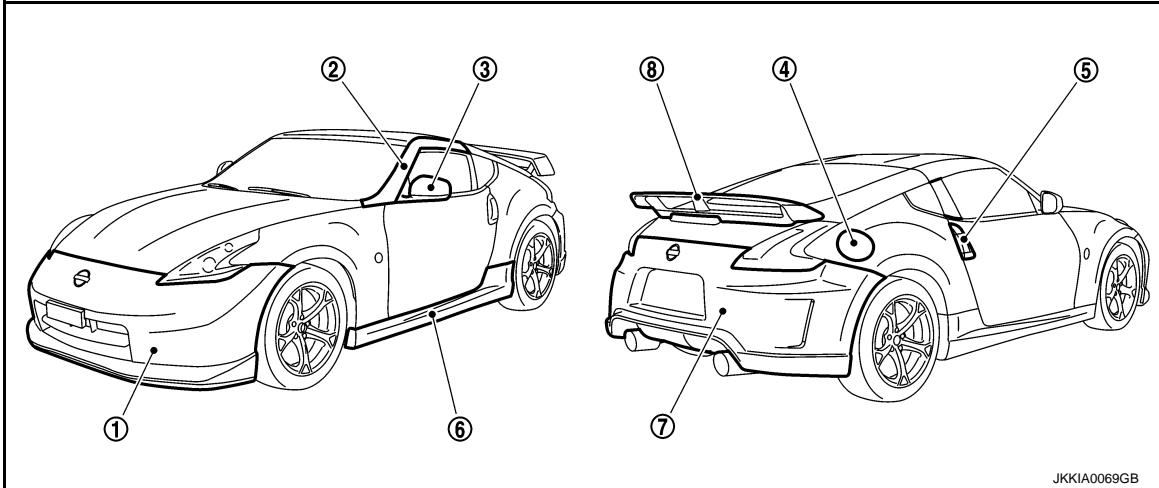
[COUPE (Nismo 370Z)]

## SPEC CHANGE INFORMATION

### BODY EXTERIOR PAINT COLOR

Body Exterior Paint Color (NISMO models)

INFOID:000000006353810



Component			Color code	BG41	BA54	BQAB	BK51	BK23
			Description	Black	Red	White	Gray	Silver
			Paint type	P	CS	3P	M	M
			Hard clear coat	×	×	-	-	-
1	Front bumper with aerodynamic splitter fascia	Body	Body color	BG41	BA54	BQAB	BK51	BK23
		Opening	Black color	G01	G01	G01	G01	G01
		Splitter	Material color	-	-	-	-	-
2	Front pillar finisher	Body color	BG41	BA54	BQAB	BK51	BK23	
3	Door outside mirror	Cover	Body color	BG41	BA54	BQAB	BK51	BK23
4	Fuel filler lid	Body color	BG41	BA54	BQAB	BK51	BK23	
5	Door outside handle and escutcheon	Velour chromium plate	Cr2p	Cr2p	Cr2p	Cr2p	Cr2p	
6	Side sill extensions	Body color	BG41	BA54	BQAB	BK51	BK23	
7	Rear bumper with aerodynamic diffuser fascia	Body color	BG41	BA54	BQAB	BK51	BK23	
8	Rear spoiler	Body color	BG41	BA54	BQAB	BK51	BK23	

**NOTE:**

- CS: Color clear solid
- M: Metallic
- P: 2-Coat pearl
- 3P: 3-Coat pearl

A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
K  
L  
M  
N  
O  
P

BRM

# HANDLING PRECAUTIONS

< REMOVAL AND INSTALLATION >

[COUPE (Nismo 370Z)]

## REMOVAL AND INSTALLATION

### HANDLING PRECAUTIONS

#### Precautions for Plastics

INFOID:000000006353811

Abbreviation	Material name	Heat resisting Temperature °C (°F)	Resistance to gasoline and solvents	Other cautions
PE	Polyethylene	60 (140)	Gasoline and most solvents are harmless if applied for a very short time (wipe up quickly).	Flammable
PVC	Poly Vinyl Chloride	80 (176)	Same as above.	Poison gas is emitted when burned.
EPM/EPDM	Ethylene Propylene (Diene) copolyMer	80 (176)	Same as above.	Flammable
PP	Polypropylene	90 (194)	Same as above.	Flammable, avoid battery acid.
UP	Unsaturated Polyester	90 (194)	Same as above.	Flammable
PS	Polystyrene	80 (176)	Avoid solvents.	Flammable
ABS	Acrylonitrile Butadiene Styrene	80 (176)	Avoid gasoline and solvents.	
AES	Acrylonitrile Ethylene Styrene	80 (176)	Same as above.	
PMMA	Poly Methyl Methacrylate	85 (185)	Same as above.	
EVAC	Ethylene Vinyl Acetate	90 (194)	Same as above.	
ASA	Acrylonitrile Styrene Acrylate	100 (222)	Same as above.	Flammable
PPE	Poly Phenylene Ether	110 (230)	Same as above.	
PC	Polycarbonate	120 (248)	Same as above.	
PAR	Polyarylate	180 (356)	Same as above.	
PUR	Polyurethane	90 (194)	Same as above.	
POM	Poly Oxymethylene	120 (248)	Same as above.	Avoid battery acid.
PBT+PC	Poly Butylene Terephthalate + Polycarbonate	120 (248)	Same as above.	Flammable
PA	Polyamide	140 (284)	Same as above.	Avoid immersing in water.
PBT	Poly Butylene Terephthalate	140 (284)	Same as above.	
PET	Polyethylene Terephthalate	180 (356)	Same as above.	
PEI	Polyetherimide	200 (392)	Same as above.	

1. When repairing and painting a portion of the body adjacent to plastic parts, consider their characteristics (influence of heat and solvent) and remove them if necessary or take suitable measures to protect them.
2. Plastic parts should be repaired and painted using methods suiting the materials, characteristics.



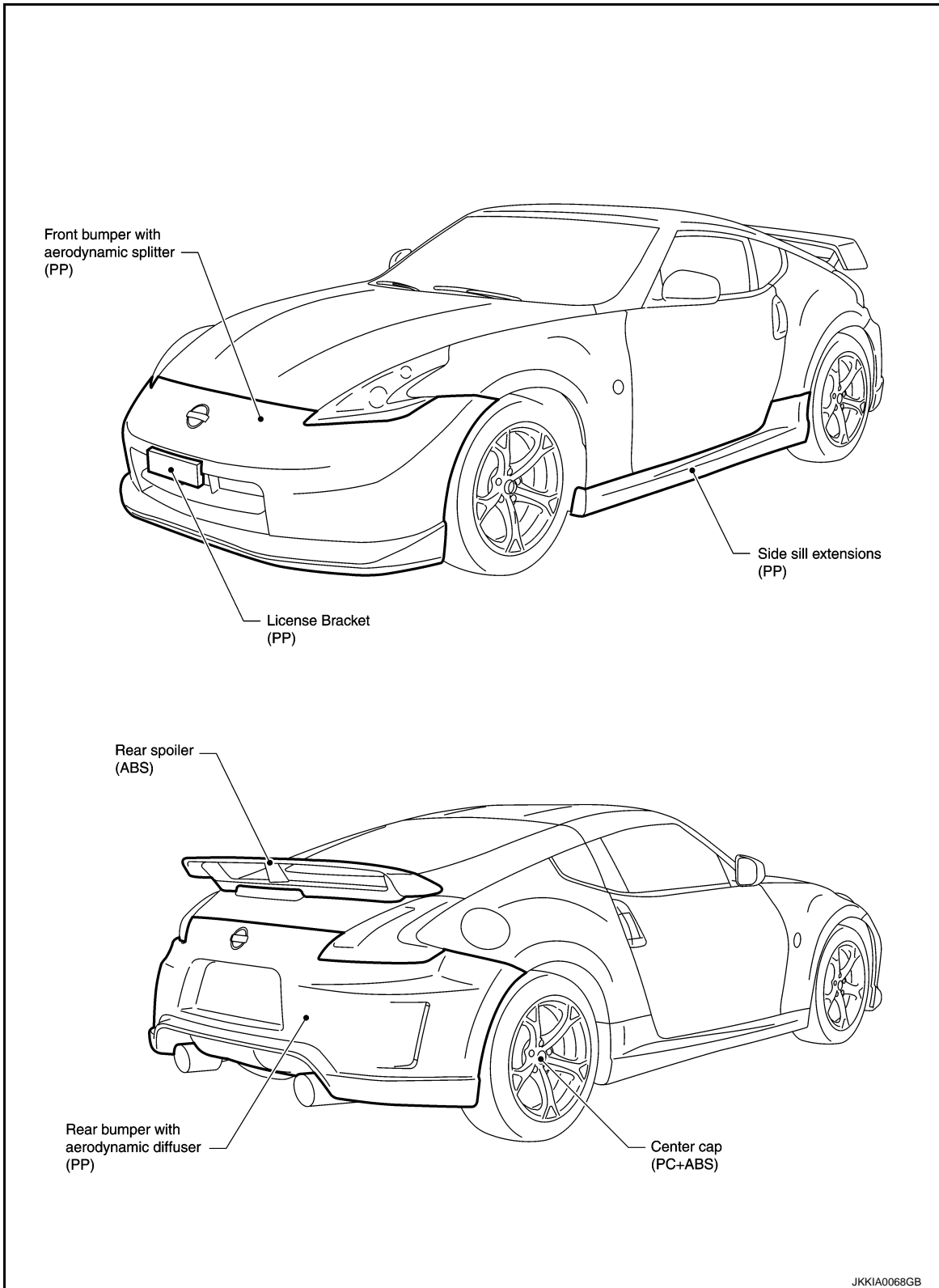
# HANDLING PRECAUTIONS

< REMOVAL AND INSTALLATION >

[COUPE (Nismo 370Z)]

## Location of Plastic Parts (NISMO models)

INFOID:000000006353812



A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
L  
M  
N  
O  
P

**BRM**

# BODY EXTERIOR PAINT COLOR

< VEHICLE INFORMATION >

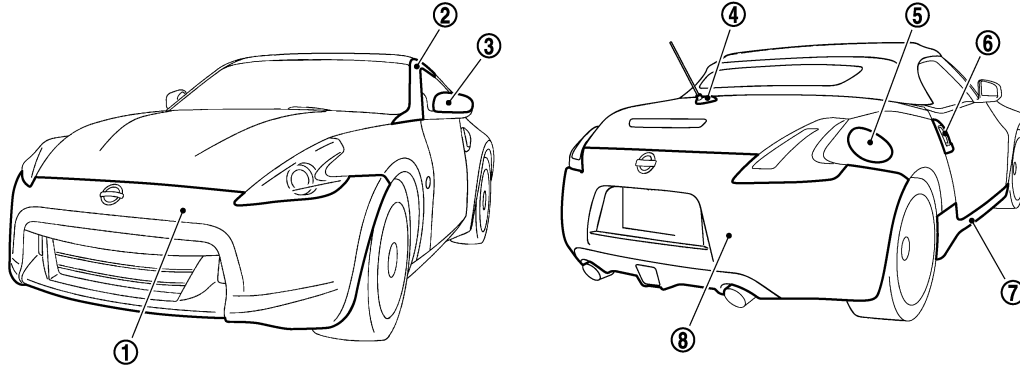
[ROADSTER]

## VEHICLE INFORMATION

### BODY EXTERIOR PAINT COLOR

#### Body Exterior Paint Color

INFOID:000000006896132



JSKIA1581ZZ

Component			Color code	BA54	BG41	BK23	BKAD	BNAG	BQAB	BRAE
			Description	Red	Black	Silver	Gray	Dark Red	White	Blue
			Paint type <sup>note</sup>	CS	P	M	M	PM	3P	3P
			Hard clear coat	For Mexico	–	–	–	–	–	–
Except for Mexico	×	×		–	–	×	–	×		
1	Front bumper fascia	Body	Body color	BA54	BG41	BK23	BKAD	BNAG	BQAB	BRAE
		Grille	Material color	–	–	–	–	–	–	–
2	Front pillar finisher	Body color	BA54	BG41	BK23	BKAD	BNAG	BQAB	BRAE	
3	Door outside mirror	Cover	Body color	BA54	BG41	BK23	BKAD	BNAG	BQAB	BRAE
4	Antenna base cover	Body color	BA54	BG41	BK23	BKAD	BNAG	BQAB	BRAE	
5	Fuel filler lid	Body color	BA54	BG41	BK23	BKAD	BNAG	BQAB	BRAE	
6	Door outside handle and escutcheon	Velour chromium plate	Cr2p	Cr2p	Cr2p	Cr2p	Cr2p	Cr2p	Cr2p	
7	Center mudguard	Body color	BA54	BG41	BK23	BKAD	BNAG	BQAB	BRAE	
8	Rear bumper fascia	Body color	BA54	BG41	BK23	BKAD	BNAG	BQAB	BRAE	

**NOTE:**

- S: Solid
- 2S: Solid + Clear
- CS: Color clear solid
- M: Metallic
- P: 2-Coat pearl
- 3P: 3-Coat pearl
- FPM: Iron oxide pearl
- TPM: Titanium pearl metallic
- RM, RPM: Multi flex color
- TM: Micro titanium metallic
- PM: Pearl metallic

PRECAUTION

REPAIRING HIGH STRENGTH STEEL

High Strength Steel (HSS)

INFOID:000000006353814

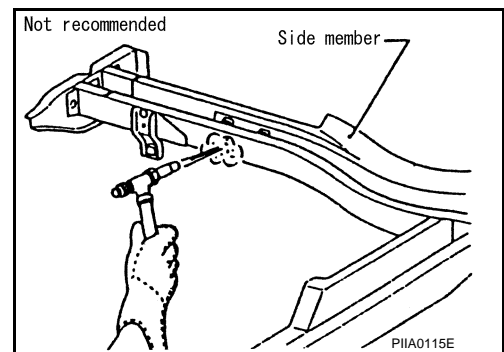
High strength steel is used for body panels in order to reduce vehicle weight. Accordingly, precautions in repairing automotive bodies made of high strength steel are described below:

Tensile strength	Major applicable parts
370 - 590 MPa	<ul style="list-style-type: none"> <li>• Front strut housing</li> <li>• Upper front hoodledge</li> <li>• Upper rear hoodledge</li> <li>• Hoodledge reinforcement</li> <li>• Lower dash crossmember assembly</li> <li>• Lower dash</li> <li>• Center front floor (Component part)</li> <li>• Front floor (Component part)</li> <li>• Rear seat crossmember reinforcement assembly</li> <li>• Front side member assembly</li> <li>• Front side member closing plate assembly</li> <li>• Front side member outrigger assembly</li> <li>• Rear seat crossmember</li> <li>• Rear side member assembly</li> <li>• Upper front pillar reinforcement</li> <li>• Lock pillar reinforcement assembly</li> <li>• Outer sill reinforcement</li> <li>• Front roof rail</li> <li>• Other reinforcements</li> </ul>
780 - 1350 MPa	<ul style="list-style-type: none"> <li>• Inner sill</li> <li>• Stiffener front side member (Front floor component part)</li> <li>• Front side member rear extension</li> </ul>

Read the following precautions when repairing HSS:

1. Additional points to consider

- The repair of reinforcements (such as side members) by heating is not recommended, because it may weaken the component. When heating is unavoidable, never heat HSS parts above 550°C (1,022°F). Verify heating temperature with a thermometer. (Crayon-type and other similar type thermometer are appropriate.)



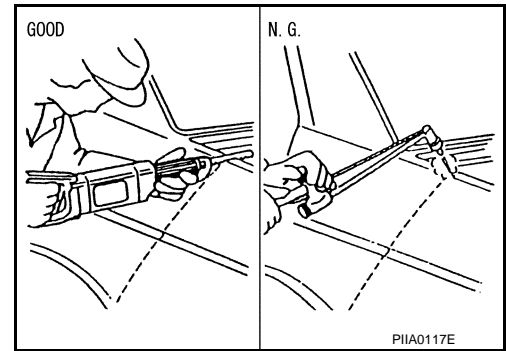
- When straightening body panels, use caution in pulling any HSS panel. Because HSS is very strong, pulling may cause deformation in adjacent sections of the body. In this case, increase the number of measuring points, and carefully pull the HSS panel.

# REPAIRING HIGH STRENGTH STEEL

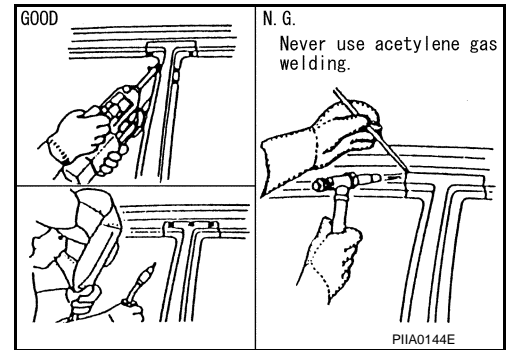
[ROADSTER]

## < PRECAUTION >

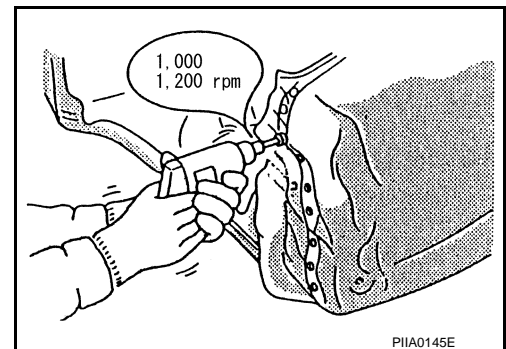
- When cutting HSS panels, avoid gas (torch) cutting if possible. Instead, use a saw to avoid weakening surrounding areas due to heat. If gas (torch) cutting is unavoidable, allow a minimum margin of 50 mm (1.97 in).



- When welding HSS panels, use spot welding whenever possible in order to minimize weakening surrounding areas due to heat. If spot welding is impossible, use MIG. welding. Do not use gas (torch) for welding because it is inferior in welding strength.



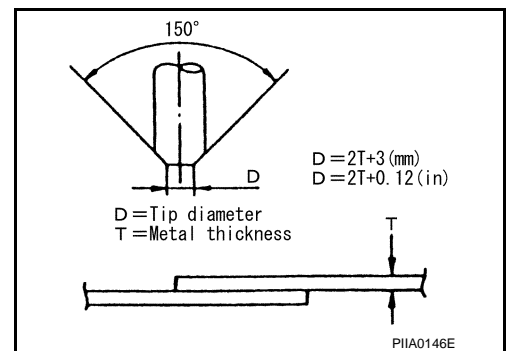
- Spot welding on HSS panels is harder than that of an ordinary steel panel. Therefore, when cutting spot welds on a HSS panel, use a low speed high torque drill (1,000 to 1,200 rpm) to increase drill bit durability and facilitate the operation.



## 2. Precautions in spot welding HSS

This work should be performed under standard working conditions. Always note the following when spot welding HSS:

- The electrode tip diameter must be sized properly according to the metal thickness.

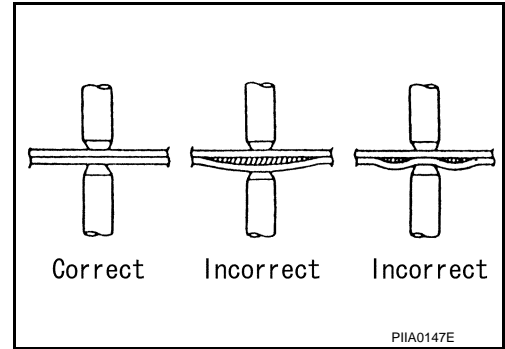


# REPAIRING HIGH STRENGTH STEEL

[ROADSTER]

## < PRECAUTION >

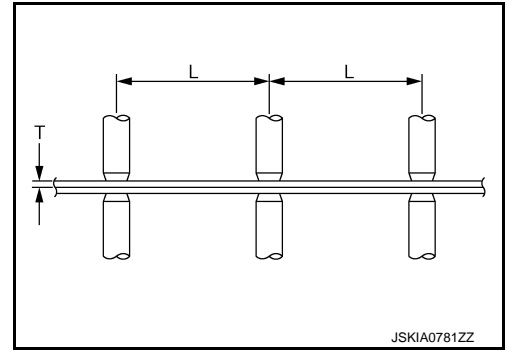
- The panel surfaces must fit flush to each other, leaving no gaps.



- Follow the specifications for the proper welding pitch.

Unit: mm (in)

Thickness (T)	Minimum pitch (L)
0.6 (0.024)	10 (0.39) or more
0.8 (0.031)	12 (0.47) or more
1.0 (0.039)	18 (0.71) or more
1.2 (0.047)	20 (0.79) or more
1.6 (0.063)	27 (1.06) or more
1.8 (0.071)	31 (1.22) or more



## Handling of Ultra High Strength Steel Plate Parts

INFOID:000000006353815

### PROHIBITION OF CUT AND CONNECTION

Never cut and Joint the stiffener front side member (front floor inside frame parts) because its material is high strength steel plate (ultra high strength steel plate).  
The front floor assembly must be replaced if this part is damaged.

A  
B  
C  
D  
E  
F  
G  
H  
I  
J

BRM

L  
M  
N  
O  
P

# PREPARATION

## REPAIRING MATERIAL

### Foam Repair

INFOID:000000006353816

During factory body assembly, foam insulators are installed in certain body panels and locations around the vehicle. Use the following procedure(s) to replace any factory-installed foam insulators.

#### URETHANE FOAM APPLICATIONS

Use commercially available Urethane foam for sealant (foam material) repair of material used on vehicle.

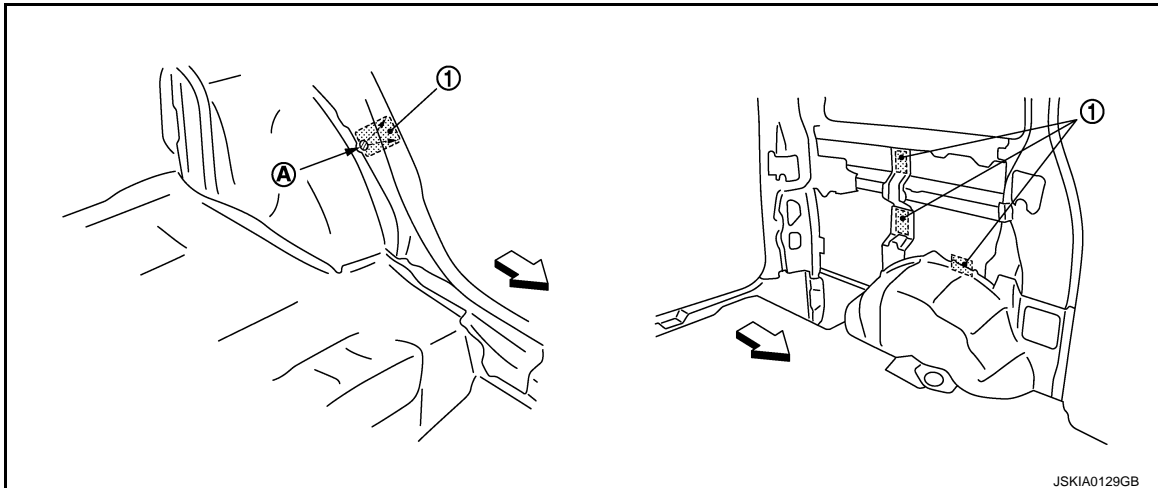
<Urethane foam for foaming agent>

**3M™ Automix™ Flexible Foam 08463 or equivalent**

Read instructions on product for fill procedures.

Example of foaming agent filling operation procedure

1. Fill procedures after installation of service part.
  - a. Eliminate foam material remaining on vehicle side.
  - b. Clean area after eliminating form insulator and foam material.
  - c. Install service part.
  - d. Insert nozzle into hole near fill area and fill foam material or fill enough to close gap with the service part.



1. Urethane foam
  - A. Nozzle insert hole
- ↙: Vehicle front

2. Fill procedures before installation of service part.
  - a. Eliminate foam material remaining on vehicle side.
  - b. Clean area after eliminating foam insulator and foam material.
  - c. Fill foam material on wheelhouse outer side.

# REPAIRING MATERIAL

< PREPARATION >

[ROADSTER]

- 1. Urethane foam
  - A. Fill while avoiding flange area
- ←: Vehicle front

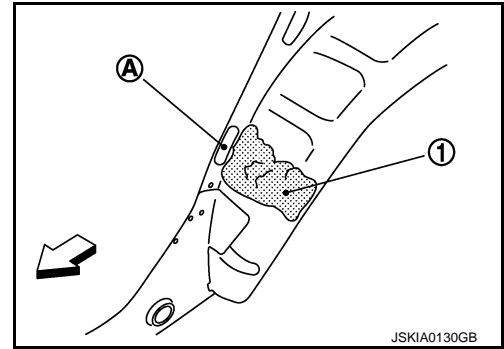
**NOTE:**

Fill enough to close gap with service part while avoiding flange area.

- d. Install service part.

**NOTE:**

Refer to label for information on working times.



A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
L  
M  
N  
O  
P

BRM

# BODY COMPONENT PARTS

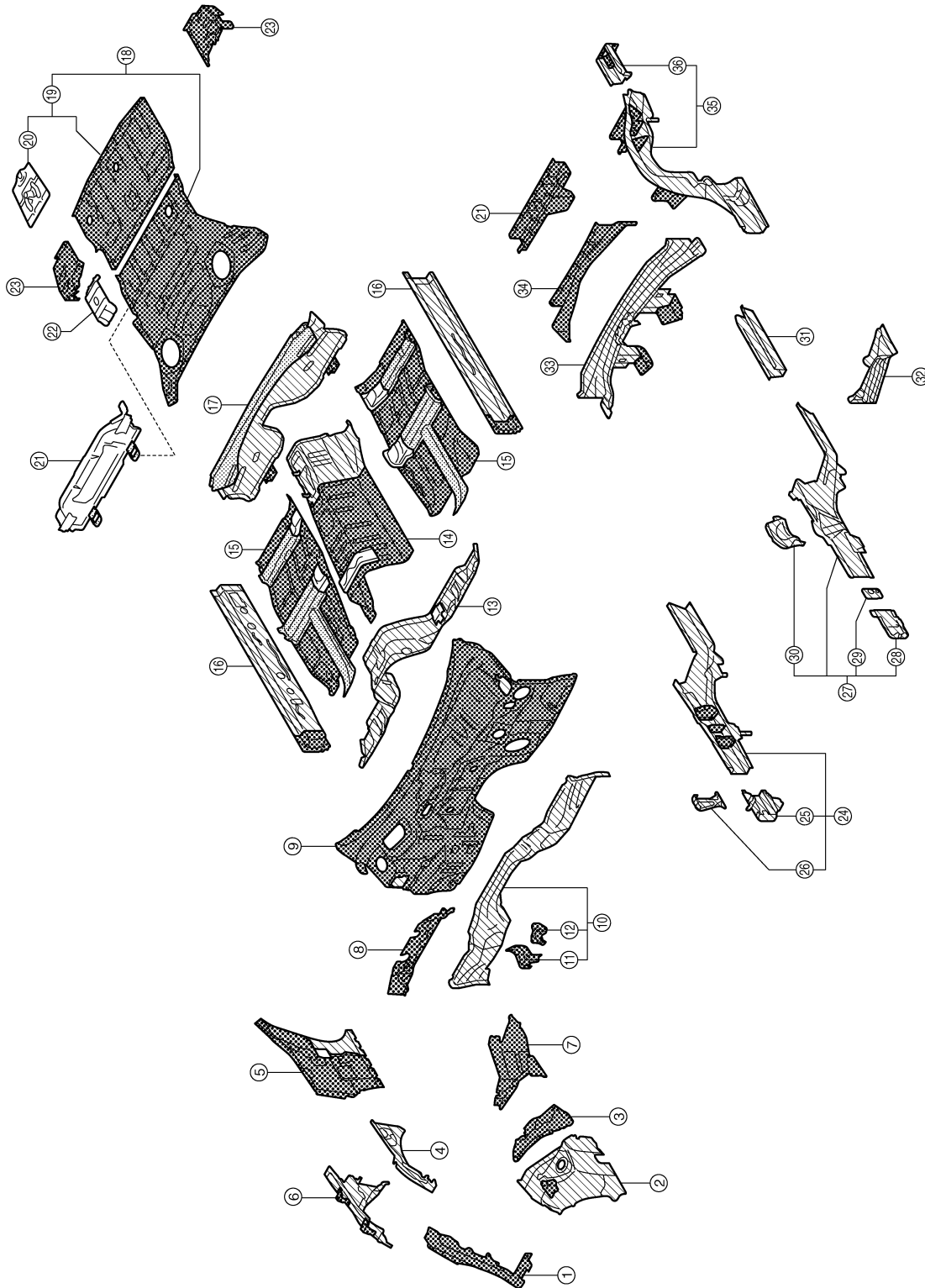
< PREPARATION >

[ROADSTER]

## BODY COMPONENT PARTS

### Underbody Component Parts

INFOID:00000006353817



JSKIA1525ZZ

- |   |                                   |                                      |
|---|-----------------------------------|--------------------------------------|
| 1. Side radiator core support (RH & LH) | 2. Front strut housing (RH & LH)  | 3. Lower rear hoodledge (RH & LH)    |
| 4. Upper front hoodledge (RH & LH)      | 5. Upper rear hoodledge (RH & LH) | 6. Hoodledge reinforcement (RH & LH) |
| 7. Upper side cowl top (RH & LH)        | 8. Front cowl top                 | 9. Upper dash                        |




# BODY COMPONENT PARTS


[ROADSTER]

< PREPARATION >

- |   |   |  |   |
|---|---|--|---|
| 10. Lower dash crossmember assembly                 | 11. Lower outer battery support bracket             | 12. Lower battery support bracket                      |   |
| 13. Lower dash                                      | 14. Center front floor                              | 15. Front floor (RH & LH)                              | A |
| 16. Inner sill (RH & LH)                            | 17. Rear seat crossmember reinforcement assembly    | 18. Rear floor front                                   |   |
| 19. Rear floor rear                                 | 20. Spare wheel clamp reinforcement                 | 21. Rear crossmember center assembly                   | B |
| 22. Sensor bracket                                  | 23. Rear floor side (RH & LH)                       | 24. Front side member assembly (RH & LH)               |   |
| 25. Front side member front extension (RH & LH)     | 26. Front side member connector assembly (RH & LH)  | 27. Front side member closing plate assembly (RH & LH) | C |
| 28. Front side member front closing plate (RH & LH) | 29. Front side rear closing reinforcement (RH & LH) | 30. Front side member center closing plate (RH & LH)   | D |
| 31. Front side member rear extension (RH & LH)      | 32. Front side member outrigger assembly (RH & LH)  | 33. Rear seat crossmember                              | E |
| 34. Rear crossmember                                | 35. Rear side member assembly (RH & LH)             | 36. Rear side member extension (RH & LH)               | F |

 Both sided anti-corrosive precoated steel sections

 High strength steel (HSS) sections

 Both sided anti-corrosive steel and HSS sections

**NOTE:**

For the parts without a number described in the figure, it is supplied only with the assembly part that the part is included with.

A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
L  
M  
N  
O  
P

BRM

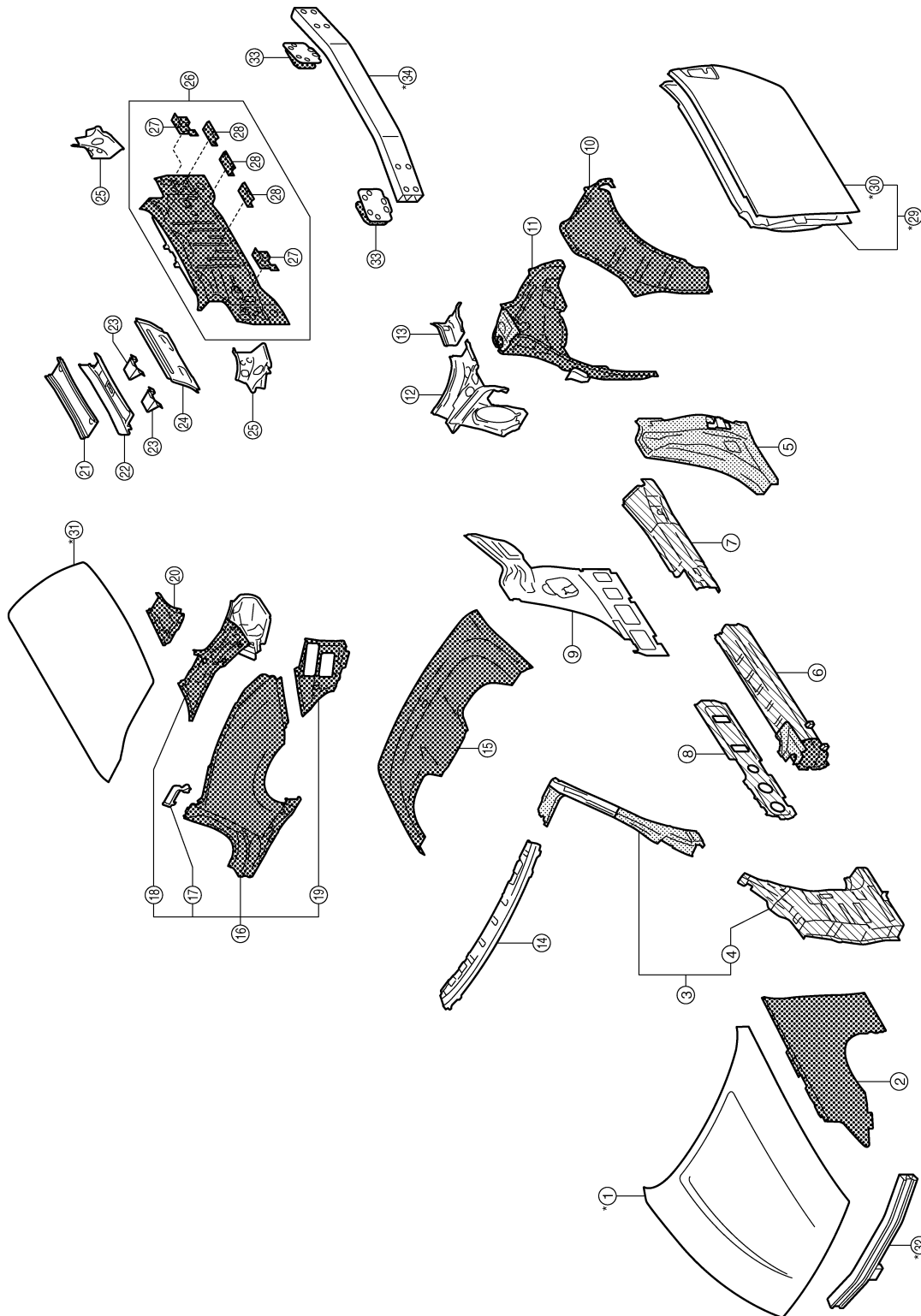
# BODY COMPONENT PARTS

< PREPARATION >

[ROADSTER]

## Body Component Parts

INFOID:00000006353818



JSKIA1526ZZ

- |                                 |   |   |
|---------------------------------|---|---|
| 1. Hood                         | 2. Front fender (RH & LH)                       | 3. Upper front pillar reinforcement (RH & LH) |
| 4. Front pillar brace (RH & LH) | 5. Lock pillar reinforcement assembly (RH & LH) | 6. Outer sill reinforcement (RH & LH front)   |


# BODY COMPONENT PARTS


[ROADSTER]

< PREPARATION >

- |   |  |                                       |  |
|---|--|---------------------------------------|--|
| 7. Outer sill reinforcement (RH & LH rear)          | 8. Lower front pillar reinforcement assembly (RH & LH) | 9. Inner rear pillar (RH & LH)        |  |
| 10. Outer rear wheelhouse (RH & LH)                 | 11. Inner rear wheelhouse (RH & LH)                    | 12. Side parcel shelf (RH & LH)       |  |
| 13. Lower inner side panel extension (RH & LH)      | 14. Front roof rail                                    | 15. Roof storage lid assembly         |  |
| 16. Rear fender assembly (RH & LH)                  | 17. Rear fender extension (RH & LH upper)              | 18. Rear fender extension (RH & LH)   |  |
| 19. Rear fender extension (RH & LH lower)           | 20. Rear fender extension (RH & LH inner)              | 21. Rear waist                        |  |
| 22. Parcel shelf                                    | 23. Rear seatback bracket                              | 24. Seatback support                  |  |
| 25. Rear panel reinforcement bracket (RH & LH)      | 26. Rear panel assembly                                | 27. Rear bumper fascia center bracket |  |
| 28. Rear bumper bracket                             | 29. Door assembly (RH & LH)                            | 30. Outer door panel (RH & LH)        |  |
| 31. Trunk lid                                       | 32. Front bumper armature assembly                     | 33. Rear bumper stay (RH & LH)        |  |
| 34. Inner center rear bumper reinforcement assembly |  |                                       |  |

 Both sided anti-corrosive precoated steel sections

 High strength steel (HSS) sections

 Both sided anti-corrosive steel and HSS sections

\*: Aluminum portion

**NOTE:**

For the parts without a number described in the figure, it is supplied only with the assembly part that the part is included with.

A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
L  
M  
N  
O  
P

BRM

## REMOVAL AND INSTALLATION

### CORROSION PROTECTION

#### Description

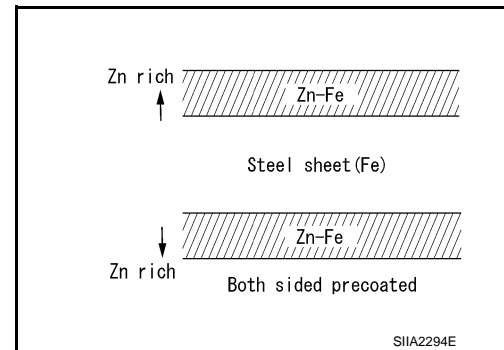
INFOID:000000006353819

To provide improved corrosion prevention, the following anti-corrosive measures have been implemented in NISSAN production plants. When repairing or replacing body panels, it is necessary to use the same anti-corrosive measures.

#### Anti-Corrosive Precoated Steel (Galvannealed Steel)

To improve repairability and corrosion resistance, a new type of anti-corrosive precoated steel sheet is adopted replacing conventional zinc-coated steel sheet.

Galvannealed steel is electroplated and heated to form Zinc-iron alloy, which provides excellent and long term corrosion resistance with cationic electrodeposition primer.



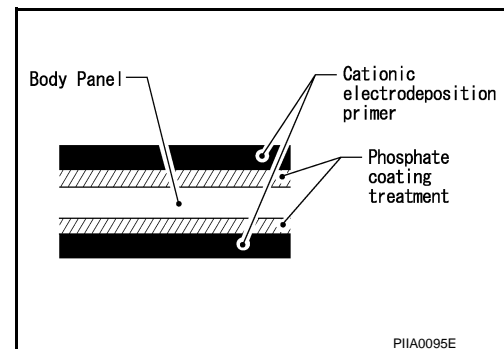
NISSAN genuine parts are fabricated from galvannealed steel. Therefore, it is recommended that NISSAN genuine parts or an equivalent be used for panel replacement to maintain the anti-corrosive performance built into the vehicle at the factory.

#### Phosphate Coating Treatment and Cationic Electrodeposition Primer

A phosphate coating treatment and a cationic electrodeposition primer, which provide excellent corrosion protection, are applied to all body components.

#### **CAUTION:**

**Confine paint removal during welding operation to an absolute minimum.**



NISSAN genuine parts are also treated in the same manner. Therefore, it is recommended that NISSAN genuine parts or an equivalent be used for panel replacement to maintain anti-corrosive performance built into the vehicle at the factory.

#### Undercoating

INFOID:000000006353820

The underside of the floor and wheelhouse are undercoated to prevent rust, vibration, noise and stone chipping. Therefore, when such a panel is replaced or repaired, apply undercoating to that part. Use an undercoating which is rust resistant, soundproof, vibration-proof, shock-resistant, adhesive, and durable.

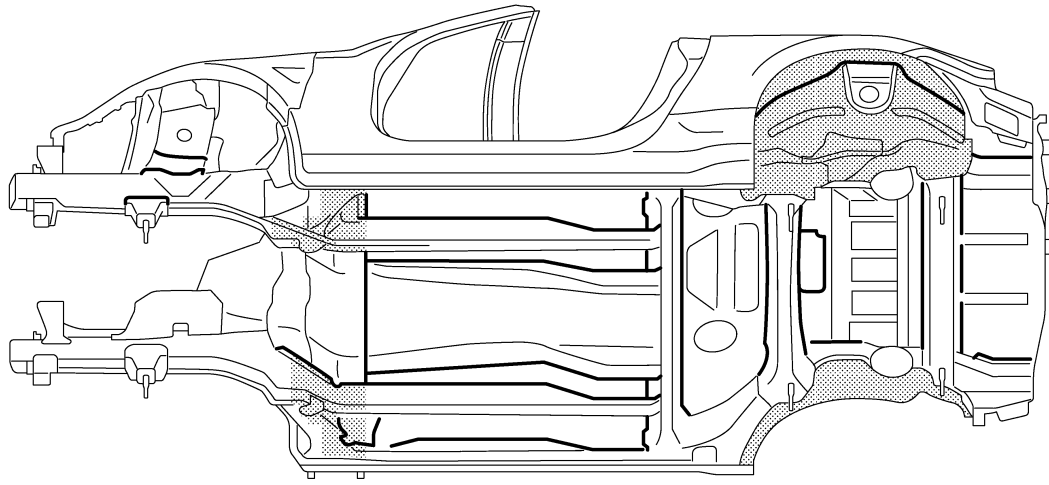
#### Precautions in Undercoating

1. Never apply undercoating to any place unless specified (such as the areas above the muffler and three way catalyst that are subjected to heat).
2. Never undercoat the exhaust pipe or other parts that become hot.
3. Never undercoat rotating parts.
4. Apply bitumen wax after applying undercoating.
5. After putting seal on the vehicle, put undercoating on it.


# CORROSION PROTECTION


< REMOVAL AND INSTALLATION >

[ROADSTER]



JSKIA1527ZZ

: Undercoated areas

: Sealed portions

## Body Sealing

INFOID:000000006353821

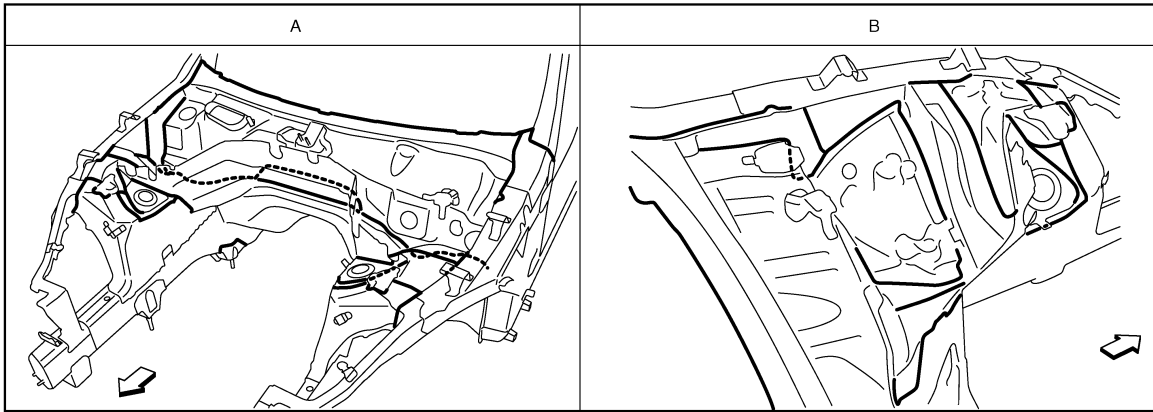
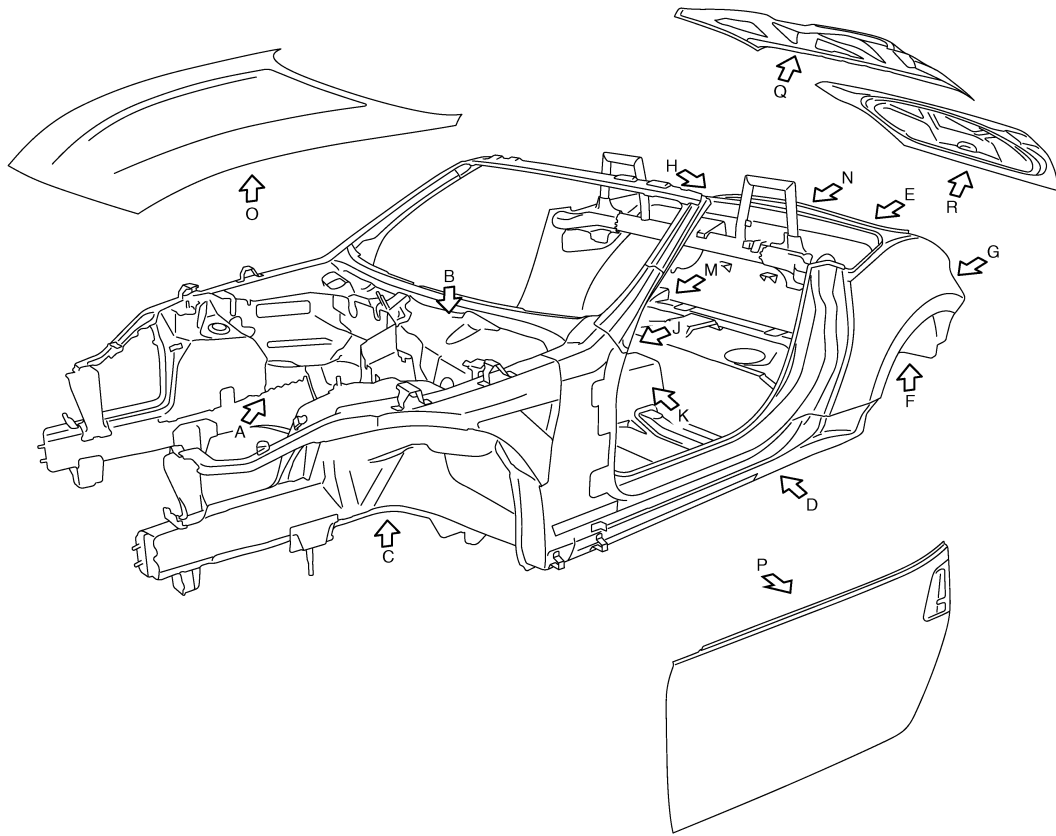
The following figure shows the areas that are sealed at the factory. Sealant that is applied to these areas should be smooth and free from cuts or gaps. Care should be taken not to apply an excess amount of sealant and not to allow other unaffected parts to come into contact with the sealant.

BRM

# CORROSION PROTECTION

< REMOVAL AND INSTALLATION >

[ROADSTER]



JSKIA1528ZZ

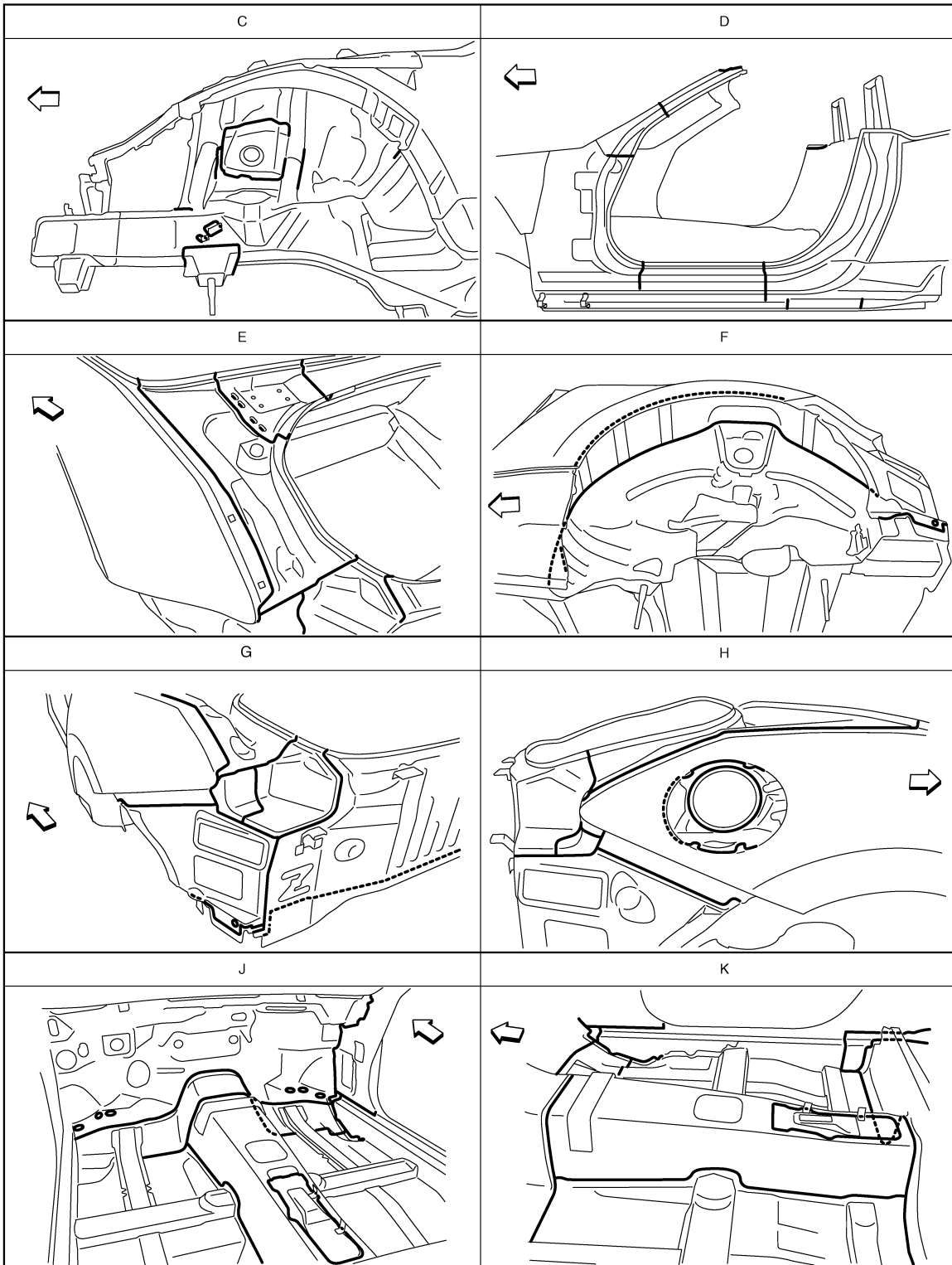
←: Vehicle front

—: Sealed portions

# CORROSION PROTECTION

< REMOVAL AND INSTALLATION >

[ROADSTER]



A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
K  
L  
M  
N  
O  
P

BRM

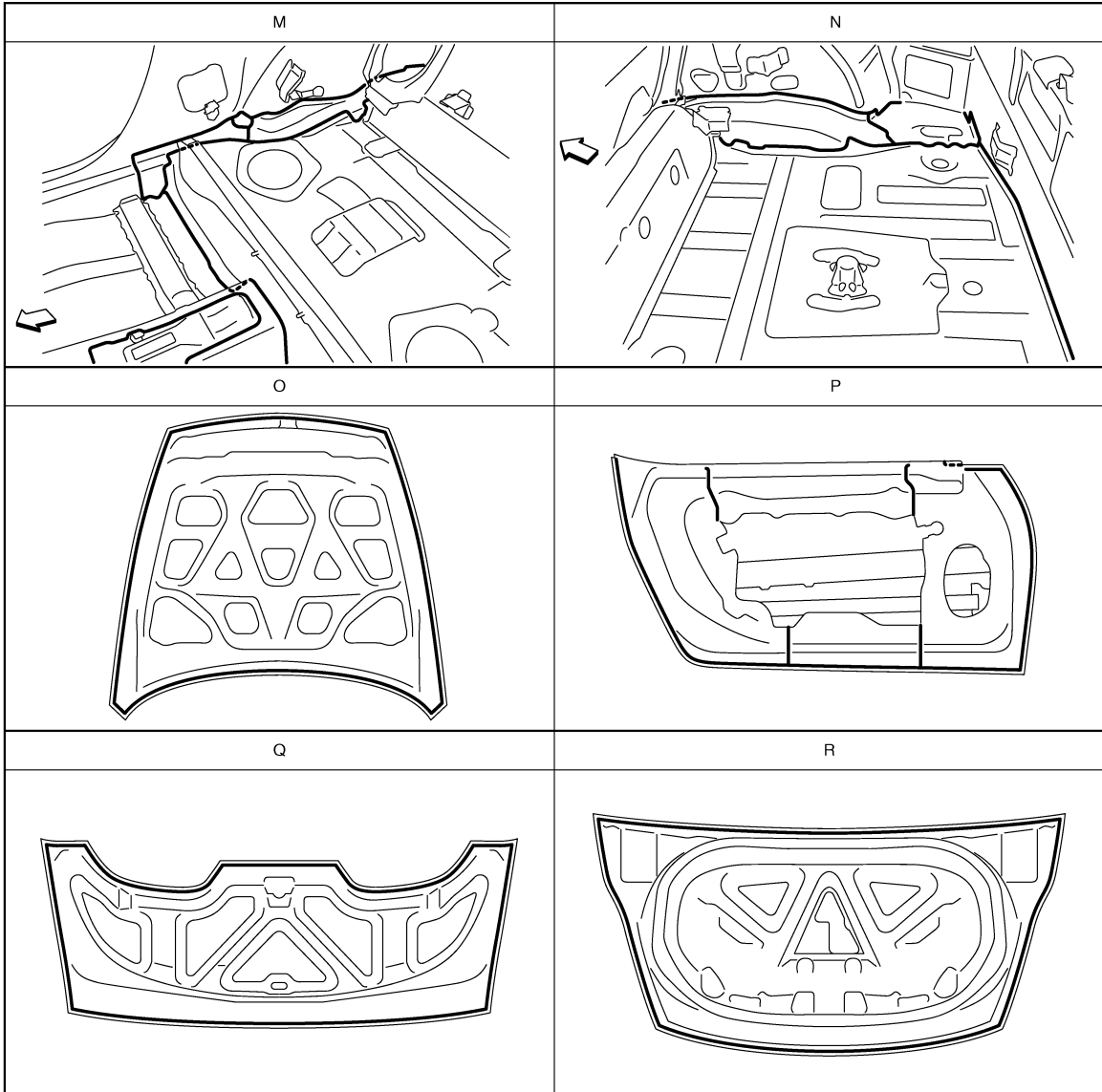
↔: Vehicle front  
—: Sealed portions

JSKIA1529ZZ

# CORROSION PROTECTION

< REMOVAL AND INSTALLATION >

[ROADSTER]



JSKIA1530ZZ

↶: Vehicle front

—: Sealed portions



# BODY CONSTRUCTION

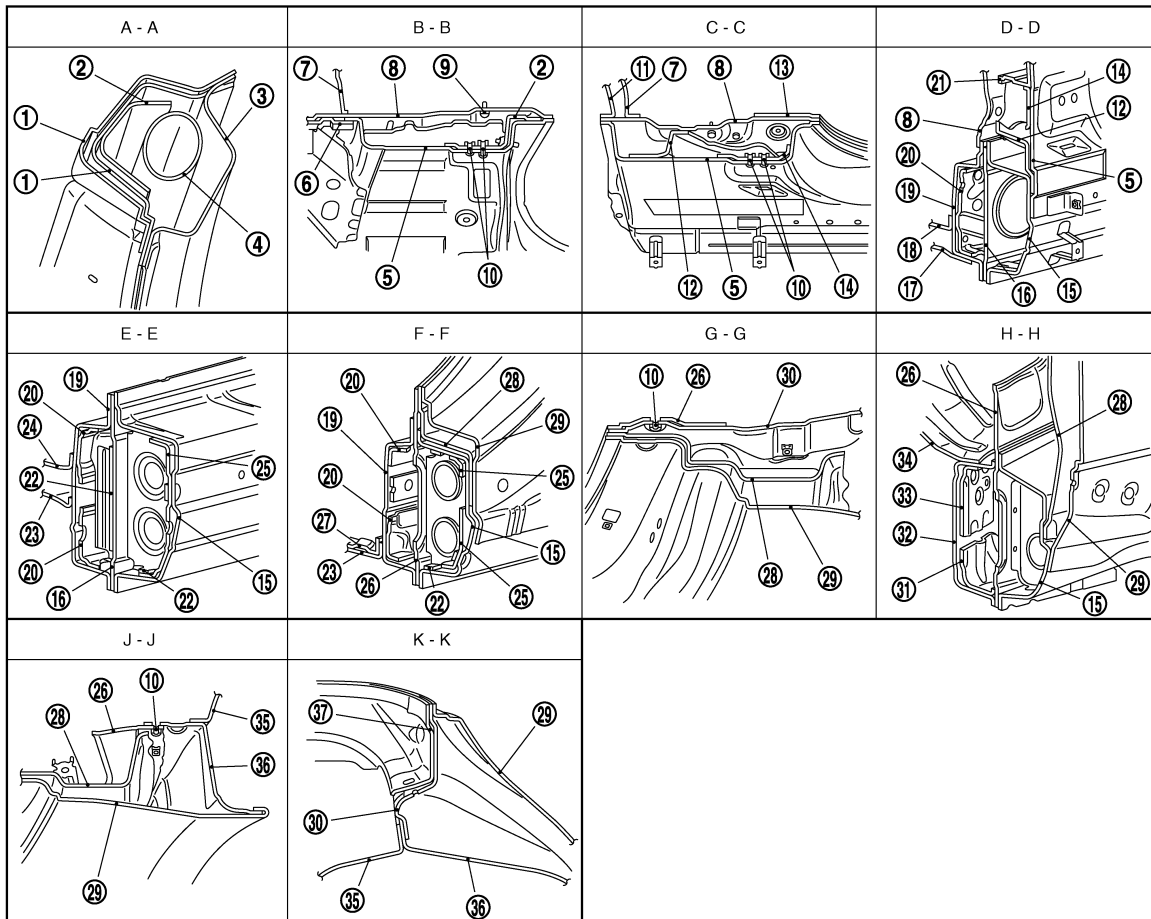
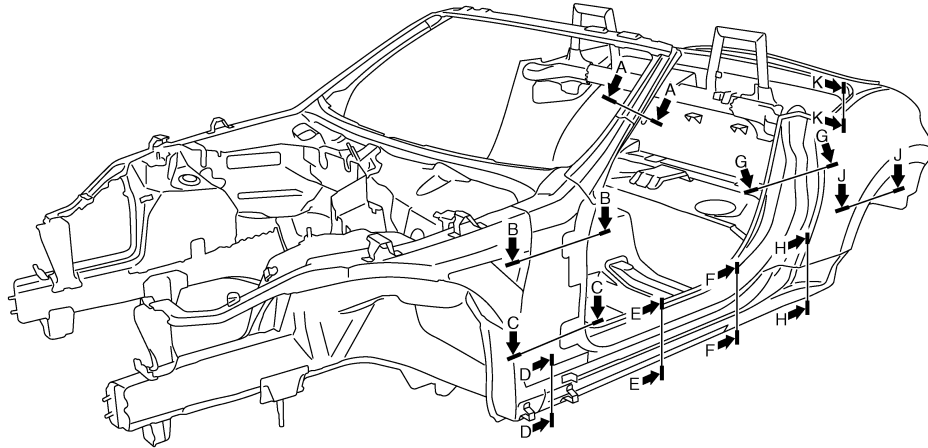
< REMOVAL AND INSTALLATION >

[ROADSTER]

## BODY CONSTRUCTION

### Body Construction

INFOID:000000006353822



- |                             |                                     |                                   |
|-----------------------------|-------------------------------------|-----------------------------------|
| 1. Upper outer front pillar | 2. Outer front pillar reinforcement | 3. Upper inner front pillar       |
| 4. Pipe reinforcement       | 5. Front pillar hinge brace         | 6. Hoodledge reinforcement gusset |
| 7. Upper dash               | 8. Upper rear hoodledge             | 9. Weld bolt                      |

JSKIA1531ZZ

A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
K  
L  
M  
N  
O  
P

**BRM**

# BODY CONSTRUCTION

## < REMOVAL AND INSTALLATION >

[ROADSTER]

- |                                      |                                   |  |
|--------------------------------------|-----------------------------------|--|
| 10. Weld nut                         | 11. Lower dash crossmember        | 12. Outer front sill reinforcement       |
| 13. Rear hoodledge reinforcement     | 14. Lower hinge plate             | 15. Outer sill reinforcement             |
| 16. Lower front pillar reinforcement | 17. Front side member outrigger   | 18. Lower dash                           |
| 19. Inner sill                       | 20. Inner rear sill reinforcement | 21. Lower front pillar bulkhead          |
| 22. Outer sill brace                 | 23. Front floor                   | 24. 2nd crossmember                      |
| 25. Center sill reinforcement        | 26. Lower inner rear pillar       | 27. 3rd crossmember                      |
| 28. Lock pillar reinforcement        | 29. Rear fender                   | 30. Inner rear pillar                    |
| 31. Rear tie down hook bracket       | 32. Rear side member front        | 33. Rear side member front reinforcement |
| 34. Rear floor                       | 35. Inner rear wheelhouse         | 36. Outer rear wheelhouse                |
| 37. Inner rear side extension        |                                   |  |

## Rear Fender Hemming Process

INFOID:000000006353823

1. A wheel arch is to be installed and hemmed over the left and right outer wheel houses.
2. In order to hem the wheel arch, it is necessary to repair any damaged or defaced parts around outer wheel house.

### CAUTION:

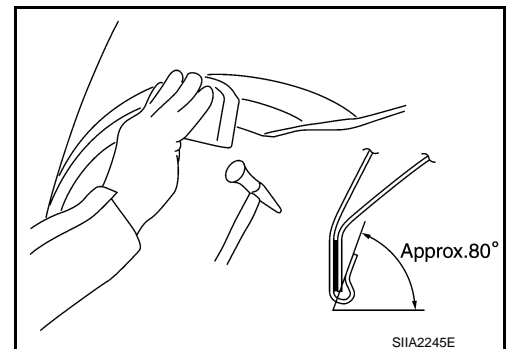
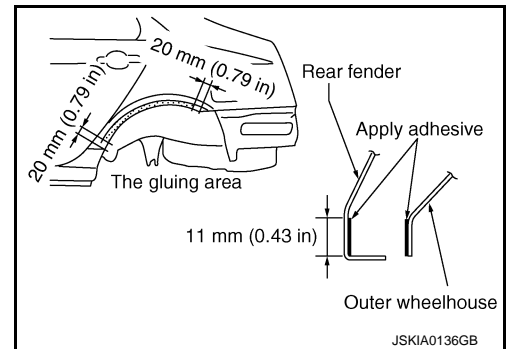
Ensure that the area that is to be glued around the outer wheelhouse is undamaged or defaced.

### PROCEDURE OF THE HEMMING PROCESS

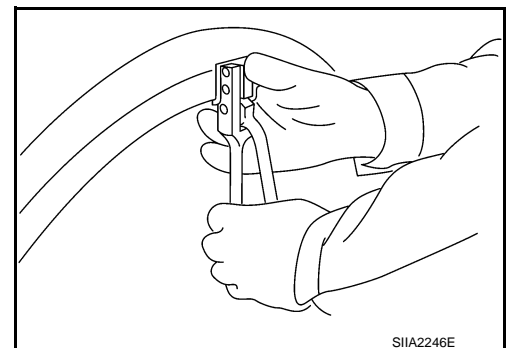
- Peel off old bonding material on the surface of the outer wheelhouse and clean thoroughly.
- Peel off a primer coat in the specified area where new adhesive is to be applied on rear fender (the replacing part).
- Apply new adhesive to both specified areas of the outer wheelhouse and rear fender.

<Adhesive> **3M™ Automix™ Panel Bonding Adhesive 08115 or equivalent**

- Attach rear fender to the body of the car, and weld the required part except the hemming part.
- Bend the welded part starting from the center of the wheel arch gradually with a hammer and a dolly. (Also hem the end of the flange.)
- Hemming with a hammer is conducted to an approximate angle of 80 degrees.



- Starting from the center, hem the wheel arch gradually, using slight back and forth motion with a hemming tool.

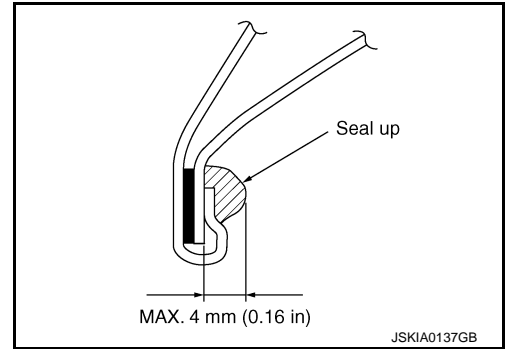


# BODY CONSTRUCTION

< REMOVAL AND INSTALLATION >

[ROADSTER]

- Seal up the area around the hemmed end of the flange.



A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
L  
M  
N  
O  
P

BRM

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[ROADSTER]

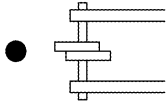
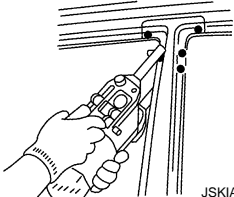
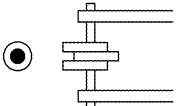
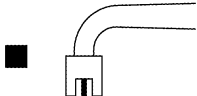



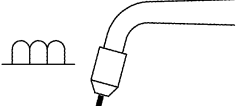
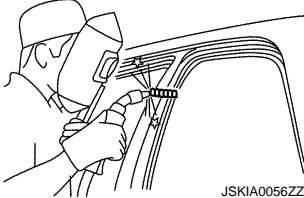
## REPLACEMENT OPERATIONS

### Description

INFOID:000000006353824

- This section is prepared for technicians who have attained a high level of skill and experience in repairing collision-damaged vehicles and also use modern service tools and equipment. Persons unfamiliar with body repair techniques should not attempt to repair collision-damaged vehicles by using this section.
- Technicians are also encouraged to read the Body Repair Manual (Fundamentals) in order to ensure that the original functions and quality of the vehicle are maintained. The Body Repair Manual (Fundamentals) contains additional information, including cautions and warnings, that are not including in this manual. Technicians should refer to both manuals to ensure proper repair.
- Please note that this information is prepared for worldwide usage, and as such, certain procedures might not apply in some regions or countries.

The symbols used in this section for welding operations are shown below.

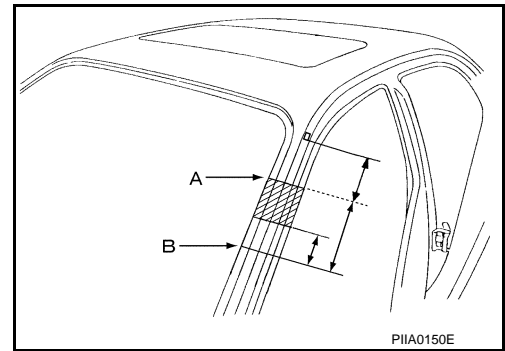
Symbol marks	Description	
 <p data-bbox="402 844 490 861">JSKIA0049ZZ</p>	2-spot welds	 <p data-bbox="1291 970 1377 987">JSKIA0053ZZ</p>
 <p data-bbox="402 1096 490 1113">JSKIA0050ZZ</p>	3-spot welds	
 <p data-bbox="402 1474 490 1491">JSKIA0051ZZ</p>	MIG plug weld	 <p data-bbox="1291 1348 1377 1365">JSKIA0054ZZ</p> <p data-bbox="1006 1381 1323 1411">For 3 panels plug weld method</p> <div style="display: flex; flex-direction: column; align-items: center;"> <div data-bbox="1144 1438 1307 1480"> <p data-bbox="1144 1449 1177 1470">■ A</p>  </div> <div data-bbox="1144 1533 1307 1575"> <p data-bbox="1144 1543 1177 1564">■ B</p>  </div> </div> <p data-bbox="1291 1600 1377 1617">JSKIA0055ZZ</p>
 <p data-bbox="402 1852 490 1869">JSKIA0052ZZ</p>	MIG seam weld / Point weld	 <p data-bbox="1291 1852 1377 1869">JSKIA0056ZZ</p>

# REPLACEMENT OPERATIONS

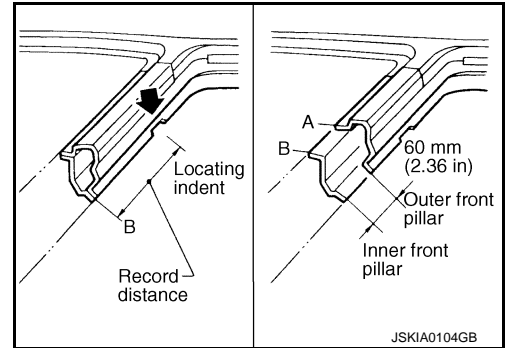
[ROADSTER]

## < REMOVAL AND INSTALLATION >

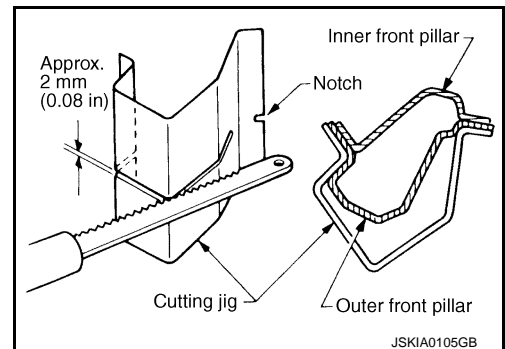
- Front pillar butt joint can be determined anywhere within shaded area as shown in the figure. The best location for the butt joint is at position A due to the construction of the vehicle.



- Determine cutting position and record distance from the locating indent. Use this distance when cutting the service part. Cut outer front pillar over 60 mm (2.36 in) above the inner front pillar cut position.

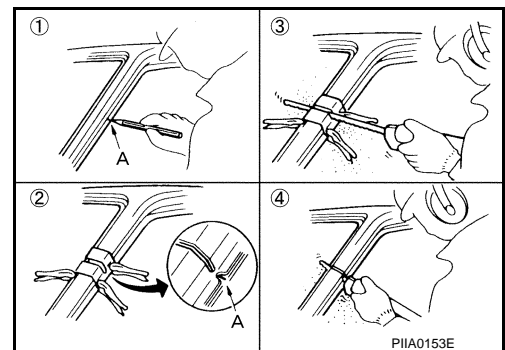


- Prepare a cutting jig to make outer pillar easier to cut. Also, this will permit the service part to be accurately cut at the joint position.



- An example of cutting operation using a cutting jig is as per the following.

1. Mark cutting lines.  
A: Cut position of outer pillar  
B: Cut position of inner pillar
2. Align cutting line with notch on jig. Clamp jig to pillar.
3. Cut outer pillar along groove of jig (at position A).
4. Remove jig and cut remaining portions.
5. Cut inner pillar at position B in same manner.



A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
L  
M  
N  
O  
P

BRM

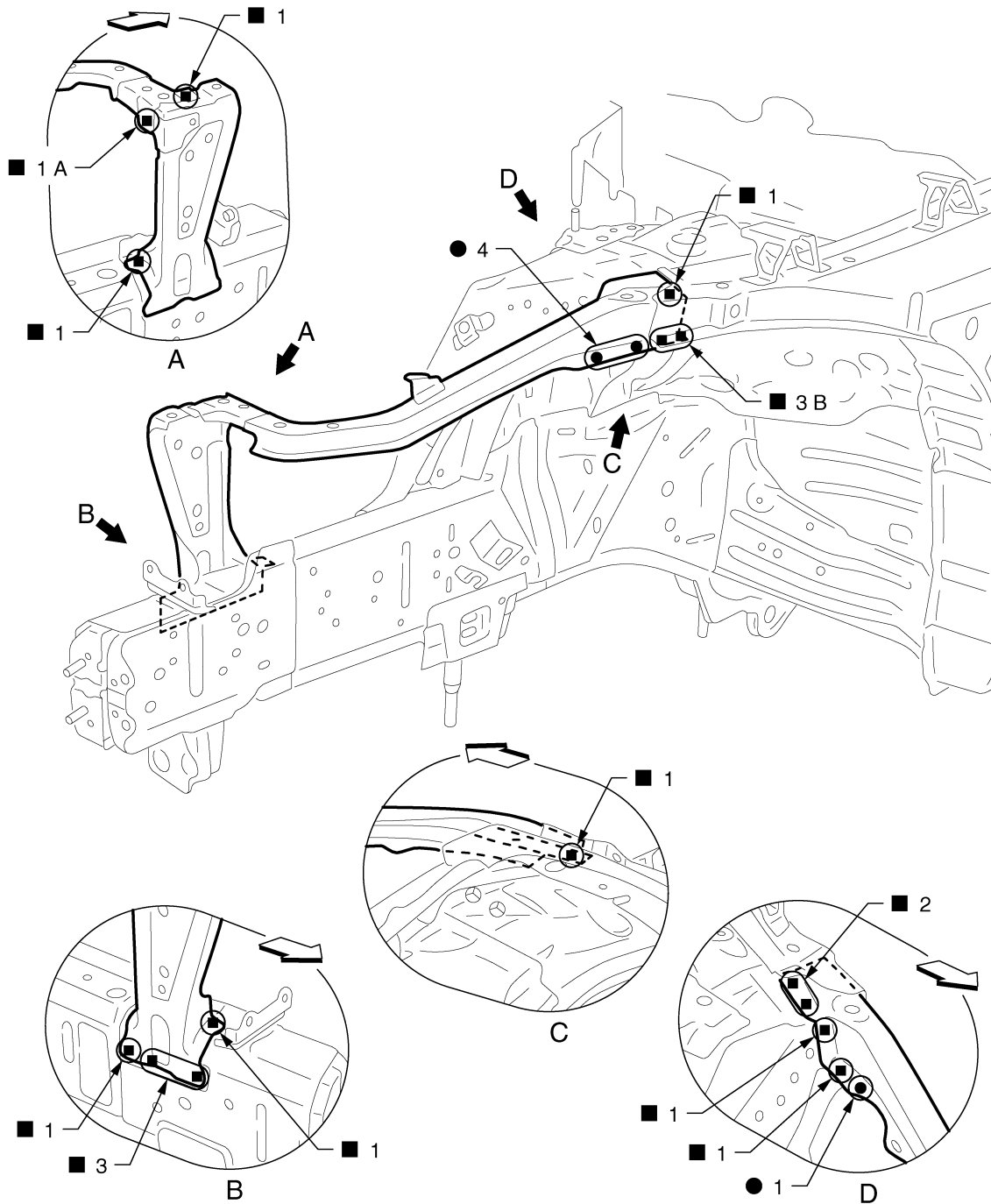
# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[ROADSTER]

## Radiator Core Support

INFOID:000000006353825



JSKIA1558ZZ

← Vehicle front

Replacement parts

● Side radiator core support (LH)

● Front side member connector assembly (LH)

## Hoodledge

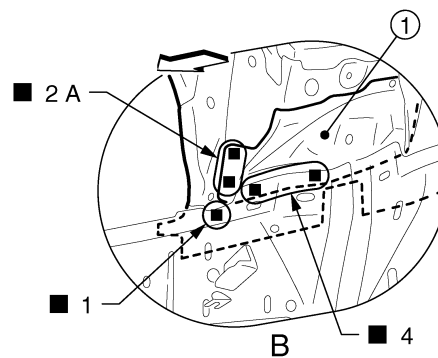
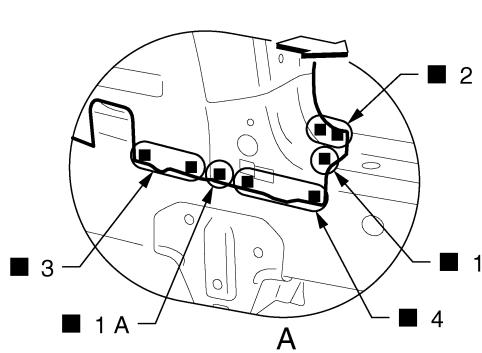
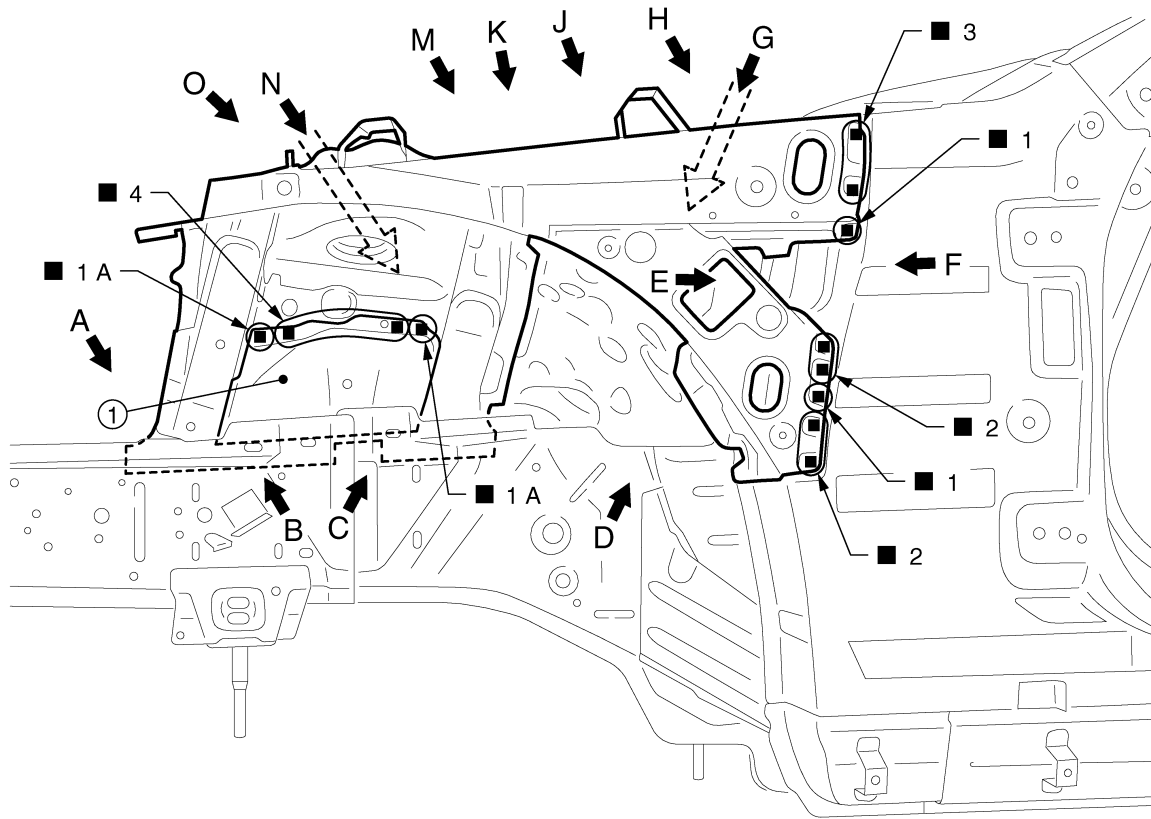
INFOID:000000006353826

Work after radiator core support is removed.  
Remove the front side member center closing plate (reusable).

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[ROADSTER]



1. Front side member center closing plate

←: Vehicle front

Replacement parts

- Upper front hoodledge (LH)
- Hoodledge reinforcement (LH)
- Front strut housing (LH)

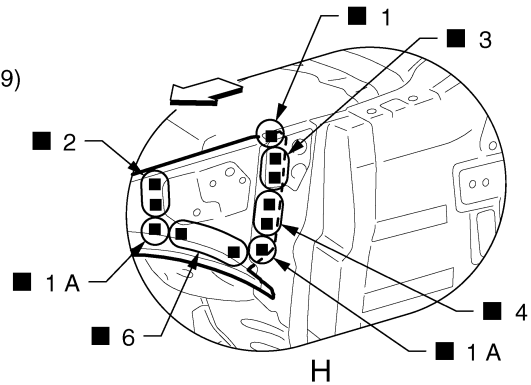
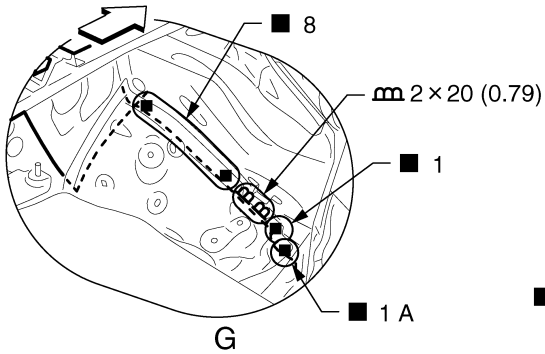
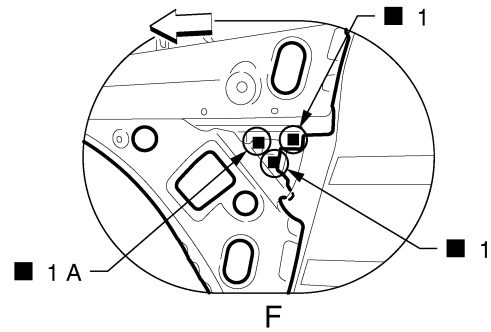
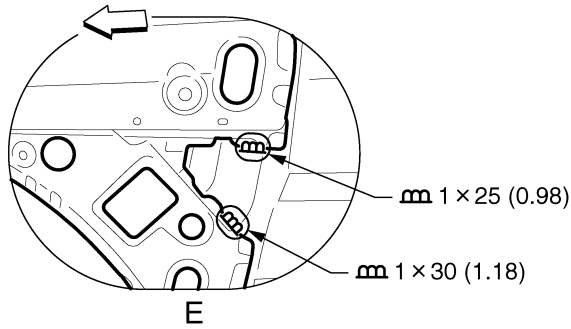
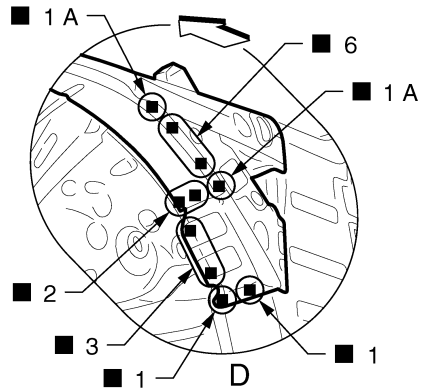
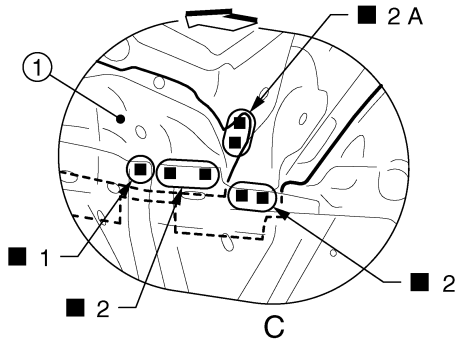
JSKIA0905ZZ

A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
BRM  
L  
M  
N  
O  
P

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[ROADSTER]



JSKIA1559GB

1. Front side member center closing plate

Unit: mm (in)

↔: Vehicle front

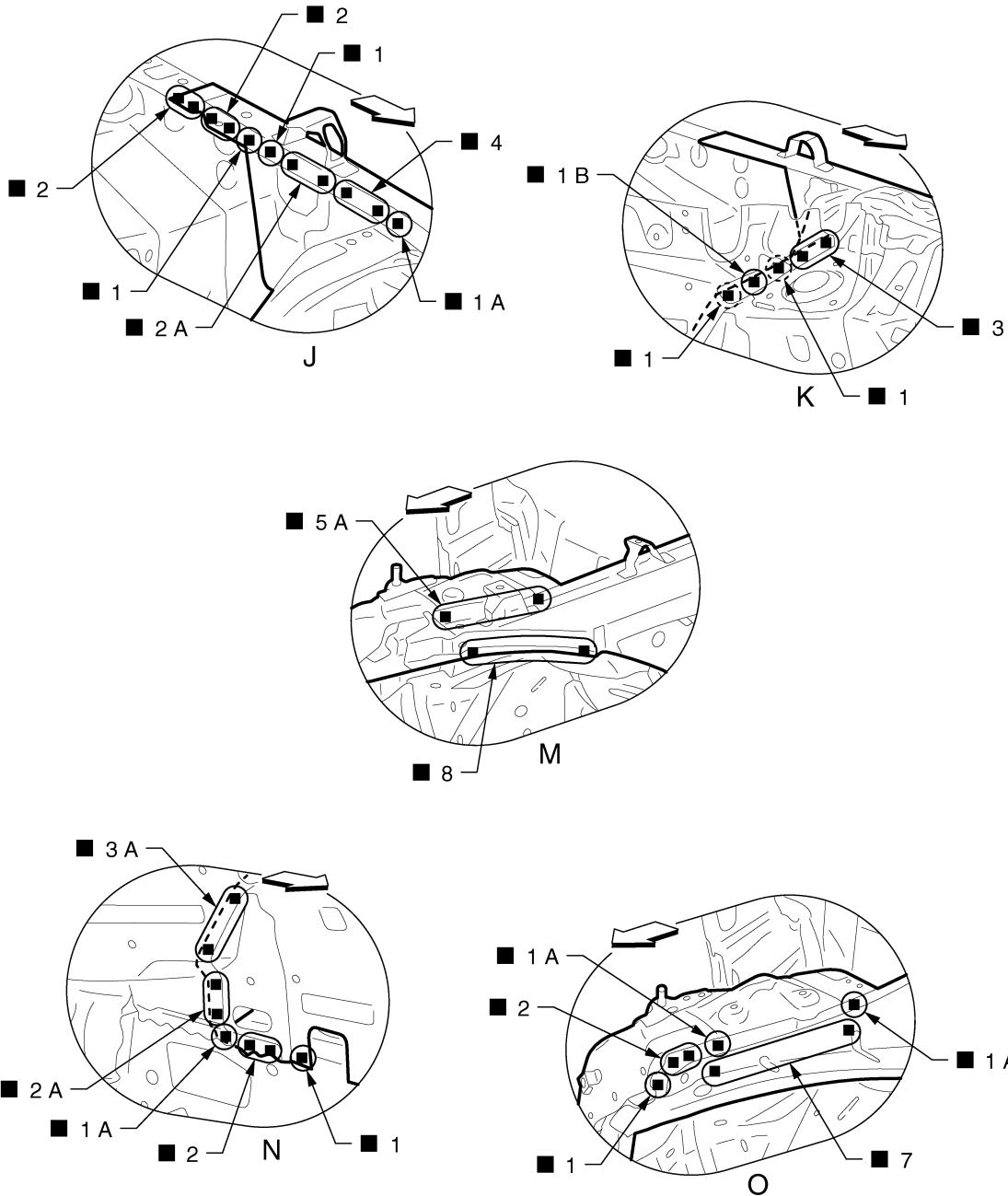
View H: Before installing hoodledge reinforcement



# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[ROADSTER]



A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
K  
L  
M  
N  
O  
P

BRM

JSKIA1560ZZ

- ← Vehicle front
- Weld the parts onto the back of the component part.

View O: Before installing hoodledge reinforcement

## Front Side Member

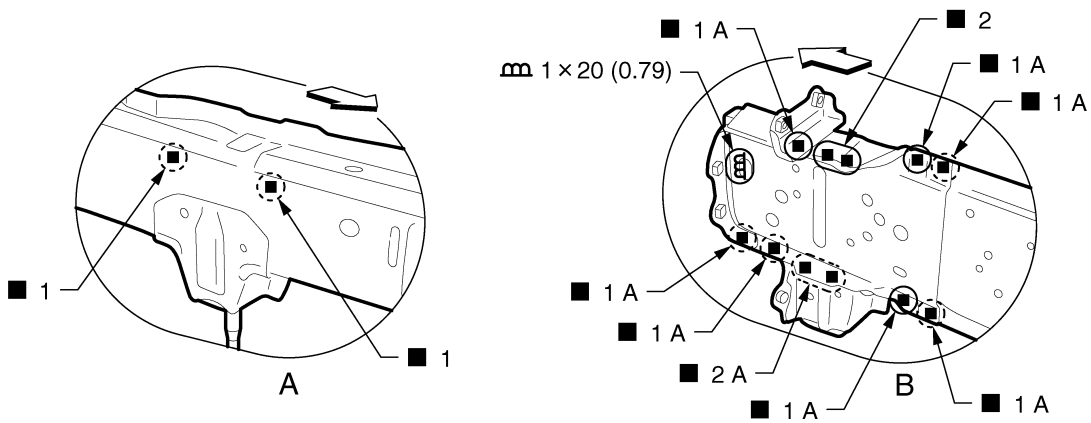
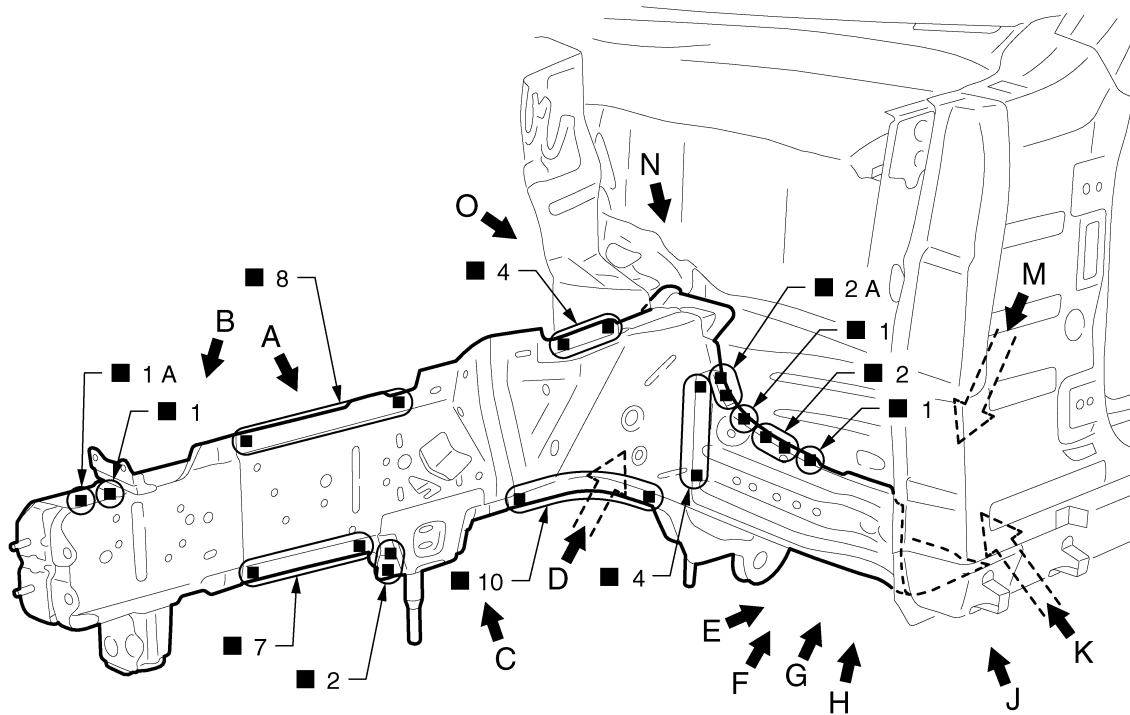
INFOID:000000006353827

Work after radiator core support and hoodledge are removed.  
Assemble the hoodledge and check the fitting according to Body Alignment before replacing the front side member center closing plate.

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[ROADSTER]



JSKIA1561GB

Unit: mm (in)

↔: Vehicle front

⊕: Weld the parts onto the back of the component part.

Replacement parts

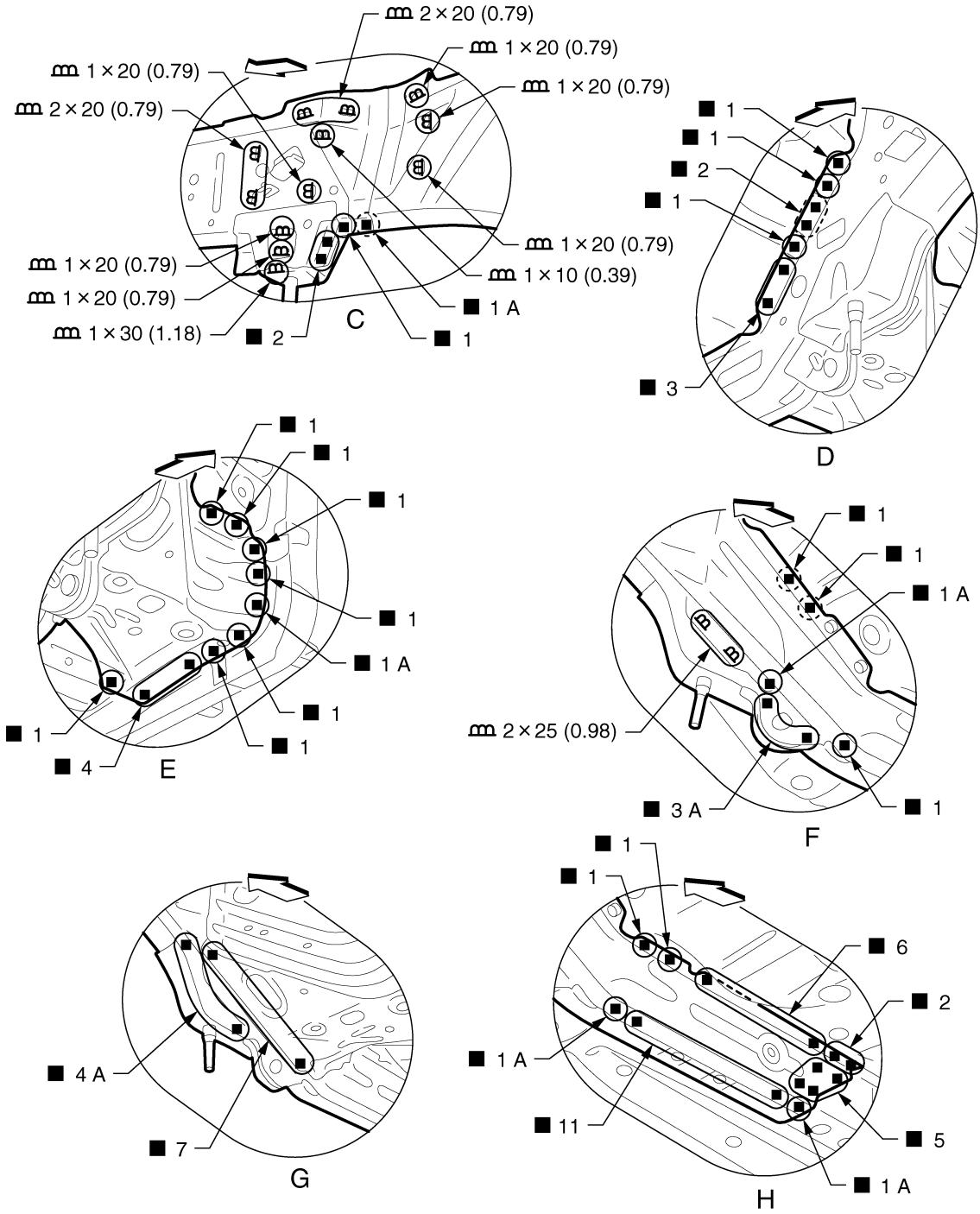
- Front side member assembly (LH)
- Front side member closing plate assembly (LH)
- Front side member outrigger assembly (LH)

View A: Before installing front side member closing plate assembly

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[ROADSTER]



A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
L  
M  
N  
O  
P

**BRM**

Unit: mm (in)

← Vehicle front

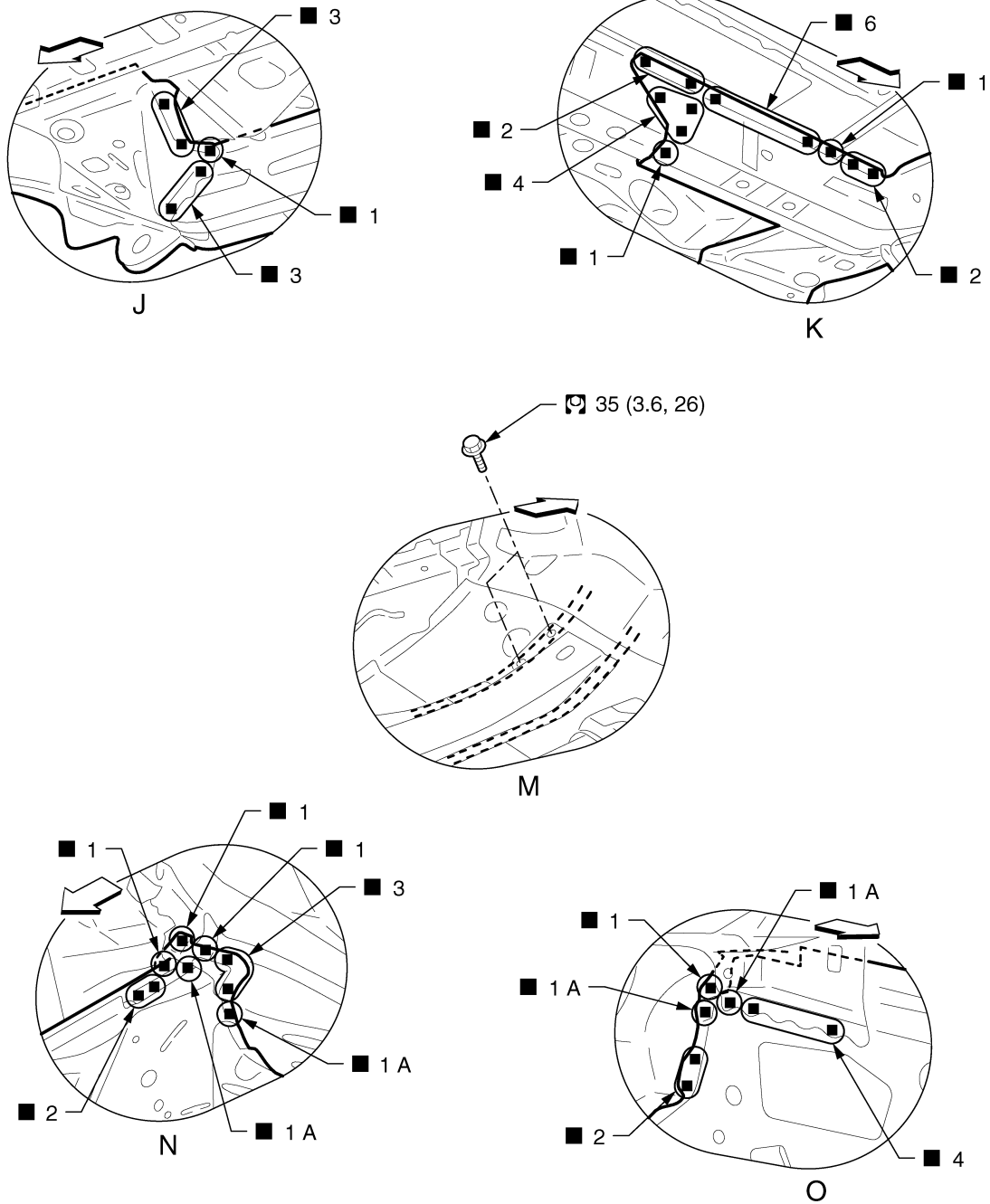
○: Weld the parts onto the back of the component part.

View F and H: Before installing front side member outrigger assembly

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[ROADSTER]



JSKIA1563GB

↶: Vehicle front

Refer to [GI-4, "Components"](#) for symbols in the figure.

## Front Side Member (Partial Replacement)

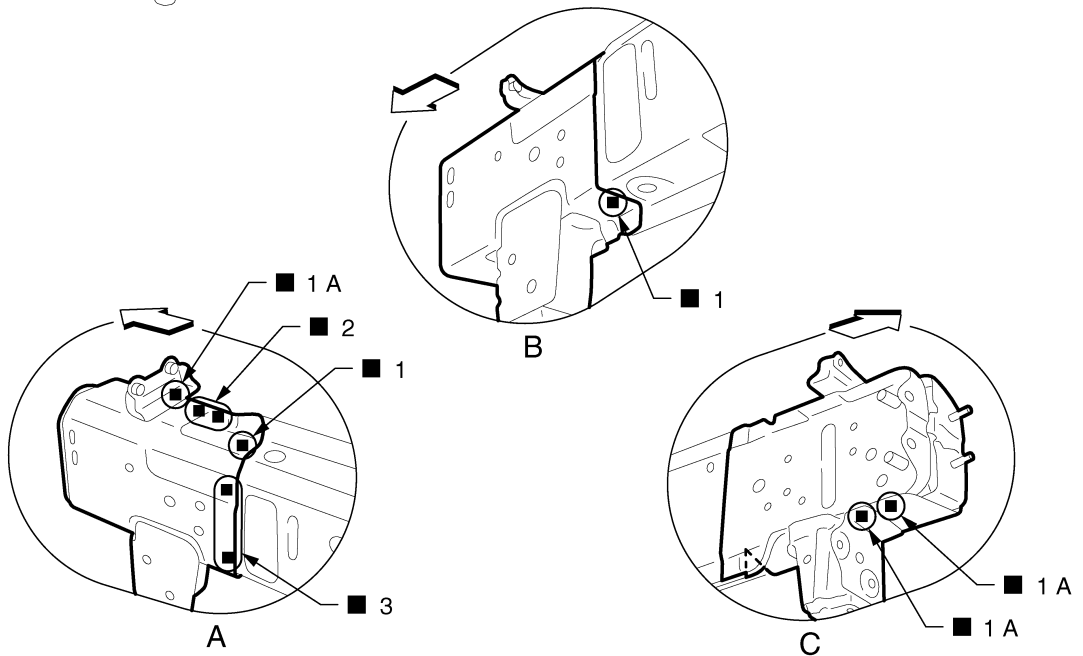
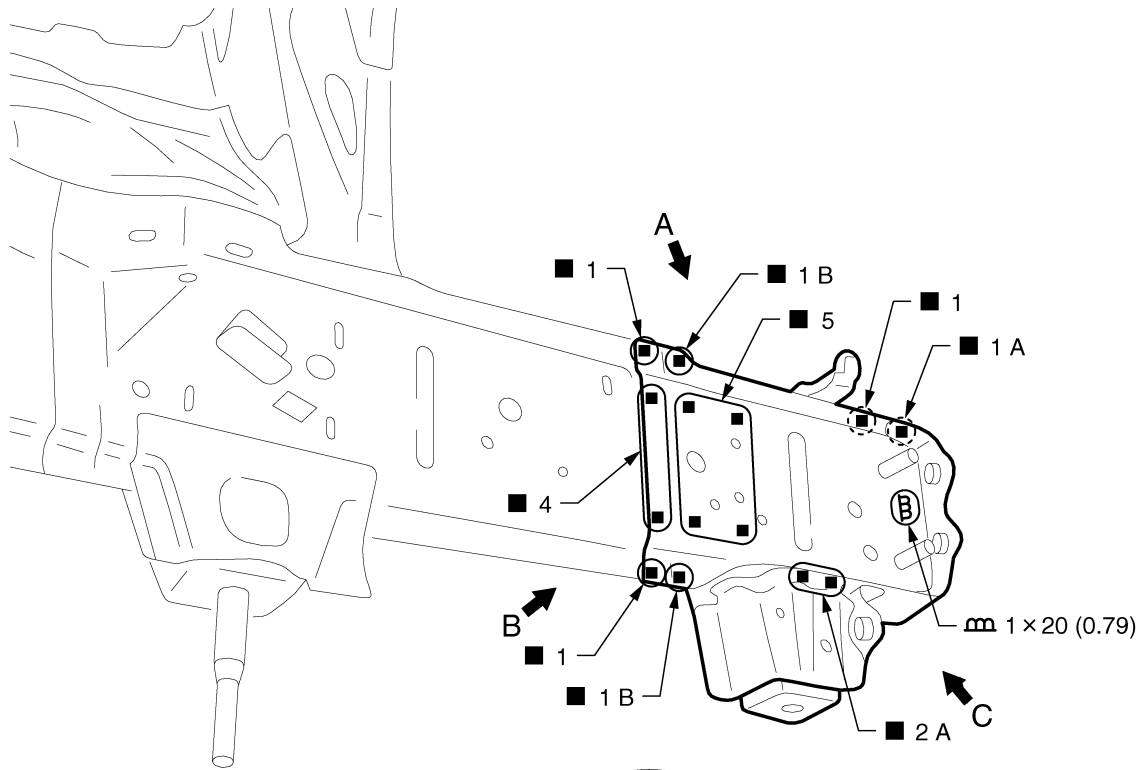
INFOID:000000006353828

Work after radiator core support is removed.

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[ROADSTER]



JSKIA1564GB

Unit: mm (in)

⇐: Vehicle front

○: Weld the parts onto the back of the component part.

Replacement parts

- Front side member front extension (RH)
- Front side member front closing plate (RH)
- Front side rear closing reinforcement (RH)

## Front Pillar

Work after hoodledge reinforcement is removed.

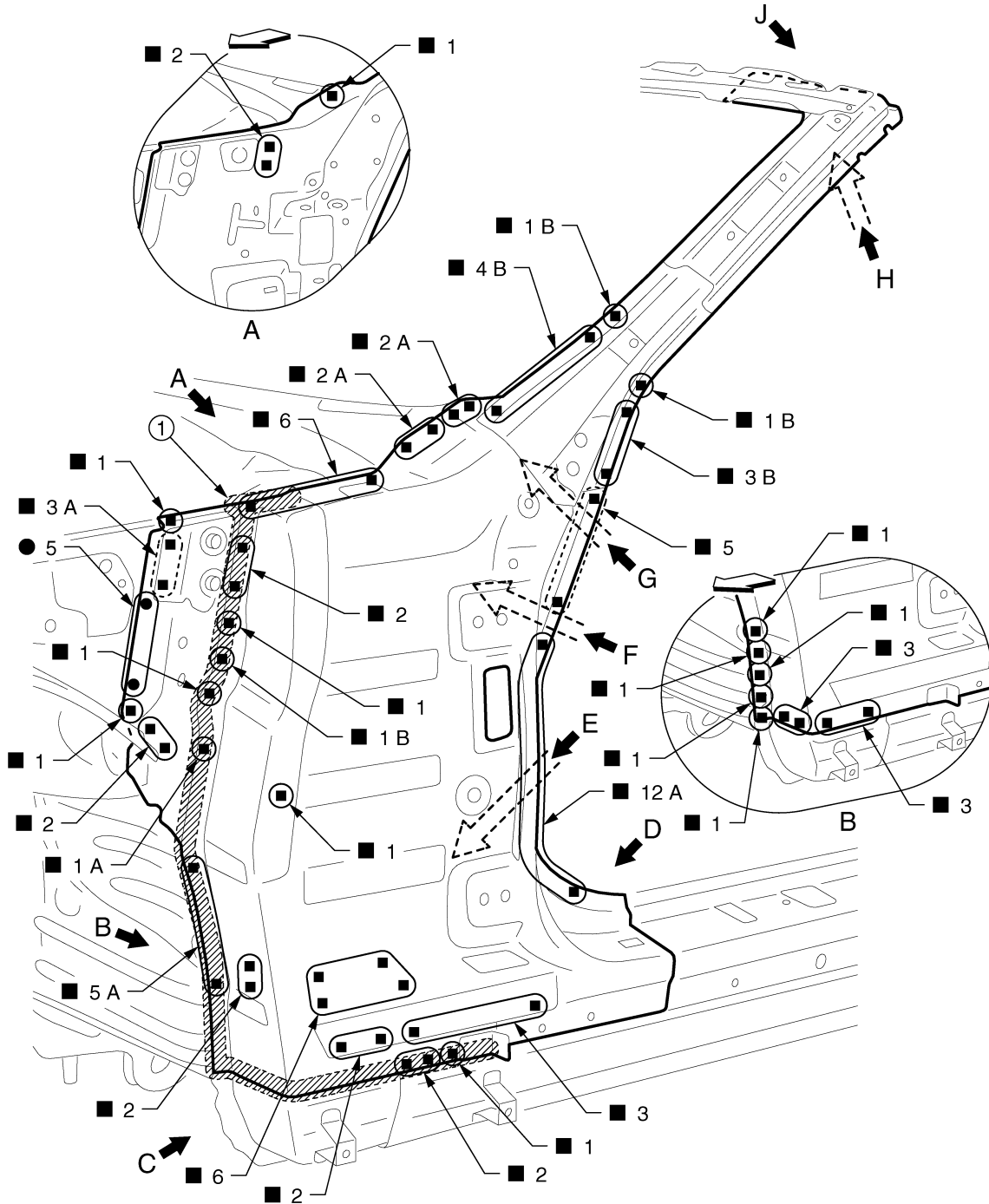
INFOID:000000006353829

A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
BRM  
L  
M  
N  
O  
P

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[ROADSTER]



JSKIA1565ZZ

1. Body sealing

Unit: mm (in)

◁: Vehicle front

○: Weld the parts onto the back of the component part.

Replacement parts

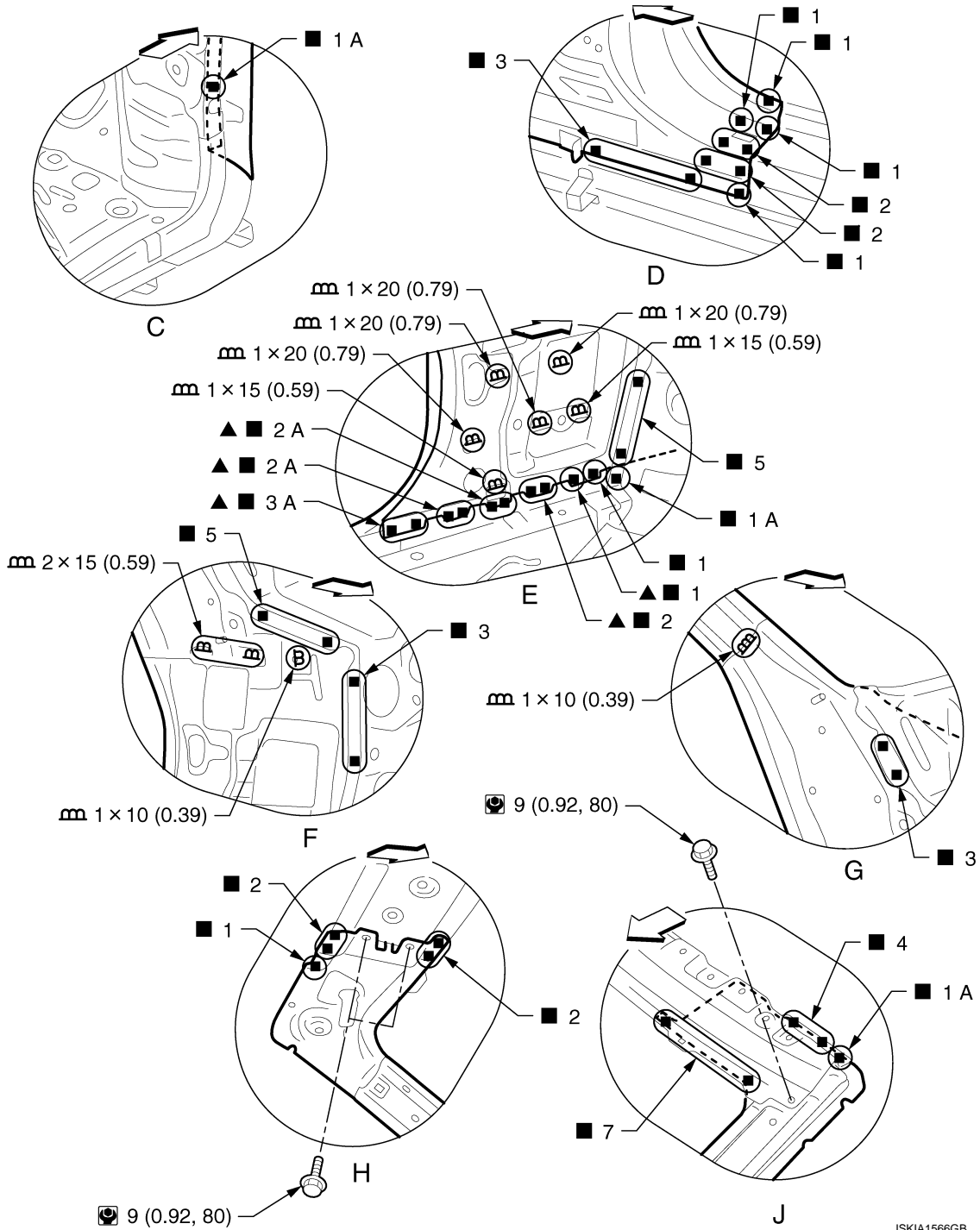
- Upper front pillar reinforcement (LH)
- Upper rear hoodledge (LH)

View A: Before installing upper front pillar reinforcement

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[ROADSTER]



Unit: mm (in)

↔: Vehicle front

▲: Drill  $\phi 8$  mm (0.31 in) hole for the plug welding hole (ultra high strength steel plate).

Refer to [GI-4, "Components"](#) for symbols in the figure.

## Outer Sill

INFOID:000000006353830

Work after hoodledge reinforcement, rear fender, and lock pillar reinforcement are removed.

Remove the front pillar brace (reusable).

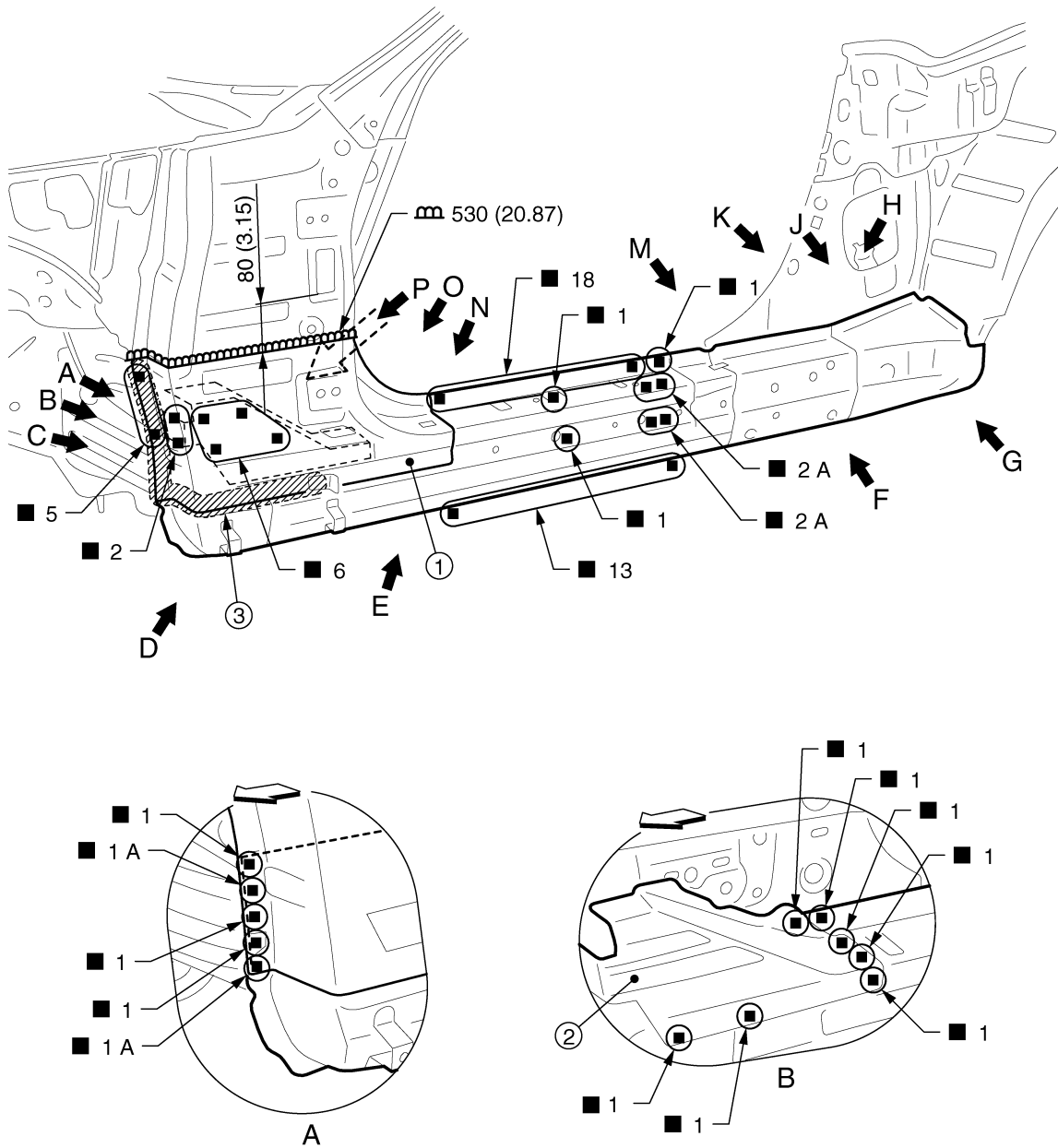
Remove the outer front sill reinforcement (reusable) from the service part "outer sill reinforcement" for easier installation of outer sill reinforcement.

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[ROADSTER]

Before installing outer sill reinforcement, remove outer sill brace from the service part "outer sill reinforcement" to install outer sill brace.



JSKIA1567GB

1. Front pillar brace

2. Outer front sill reinforcement

3. Body sealing

Unit: mm (in)

↔: Vehicle front

Replacement parts

● Outer sill reinforcement (LH front)

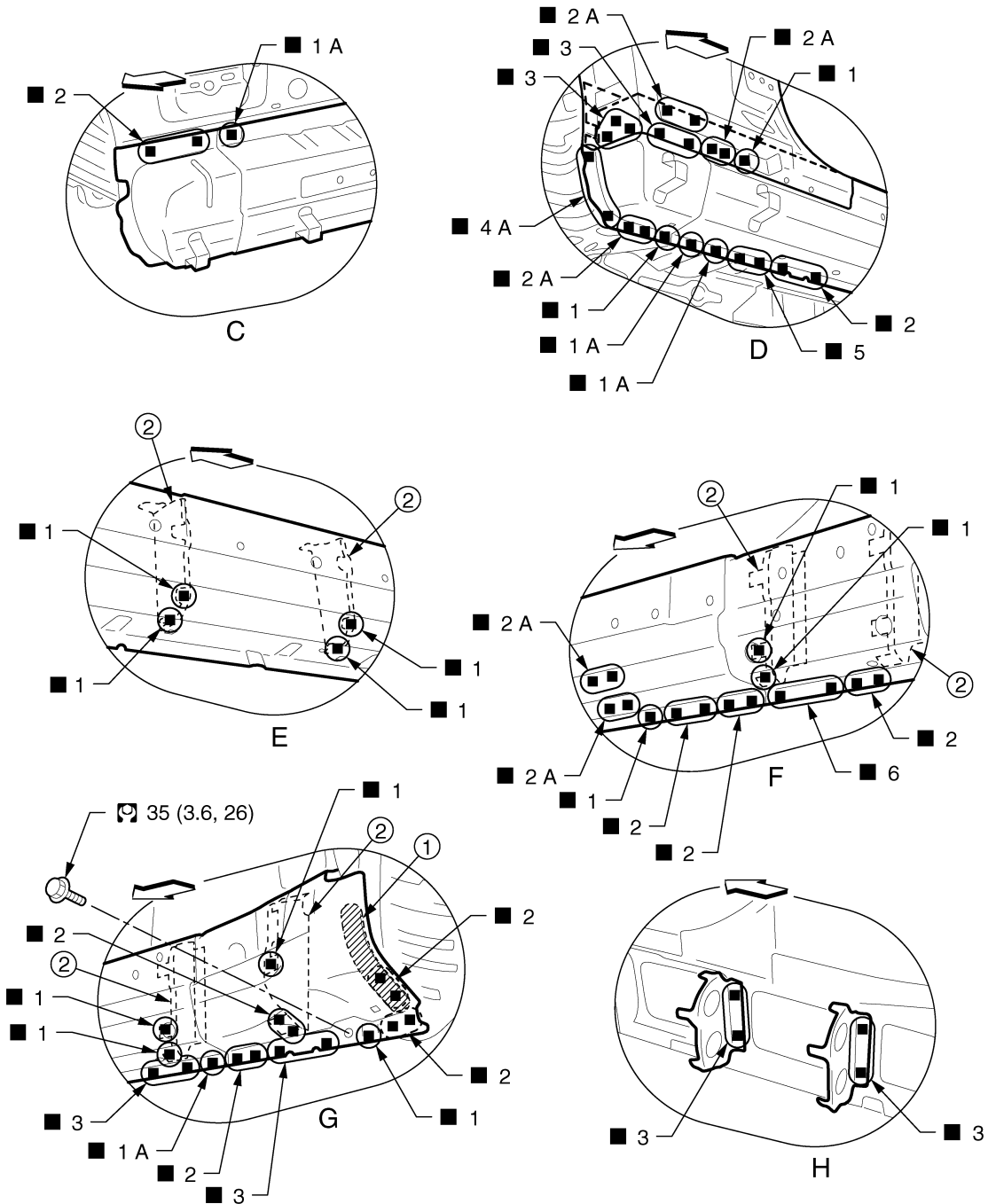
● Outer sill reinforcement (LH rear)



# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[ROADSTER]



- 1. Body sealing
- 2. Outer sill brace
- ⇐: Vehicle front
- ⊕: Weld the parts onto the back of the component part.
- Refer to [GI-4. "Components"](#) for symbols in the figure.

View C: Before installing outer front sill reinforcement  
 View H: Before installing outer sill reinforcement (rear)

JSKIA1568GB

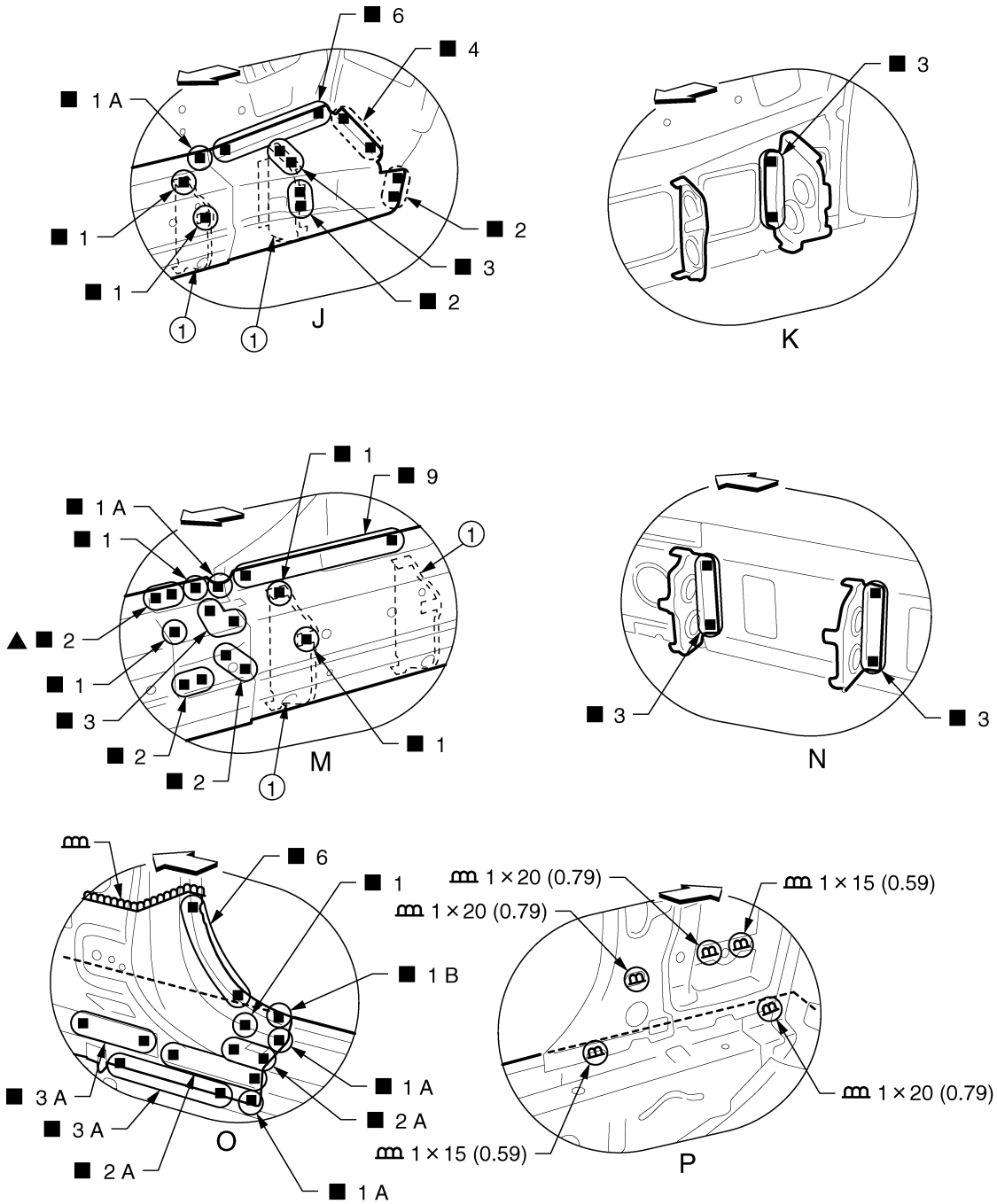
A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
L  
M  
N  
O  
P

BRM

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[ROADSTER]



JSKIA1569GB

1. Outer sill brace

Unit: mm (in)

←: Vehicle front

▲: Drill ø8 mm (0.31 in) hole for the plug welding hole (ultra high strength steel plate).

○: Weld the parts onto the back of the component part.

View K: Before installing outer sill reinforcement (rear)

View N: Before installing outer sill reinforcement (front)

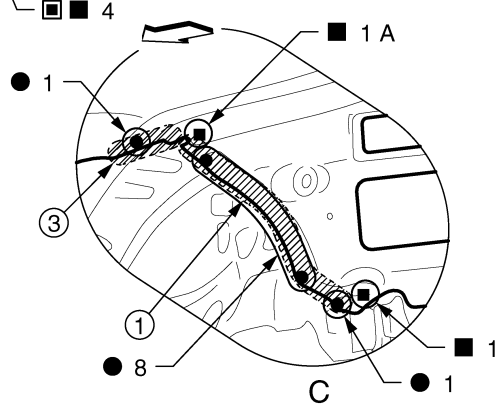
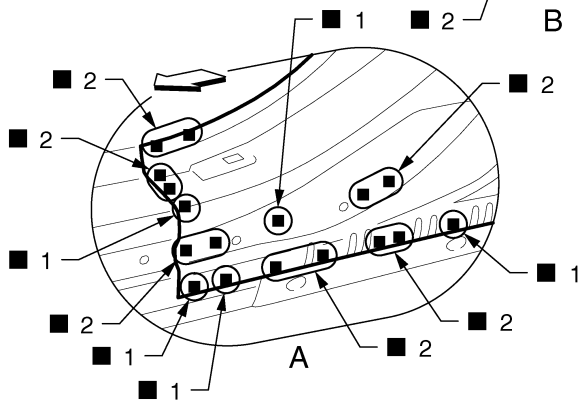
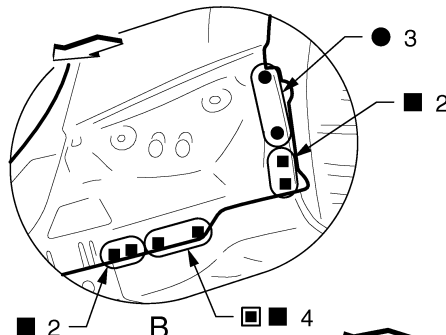
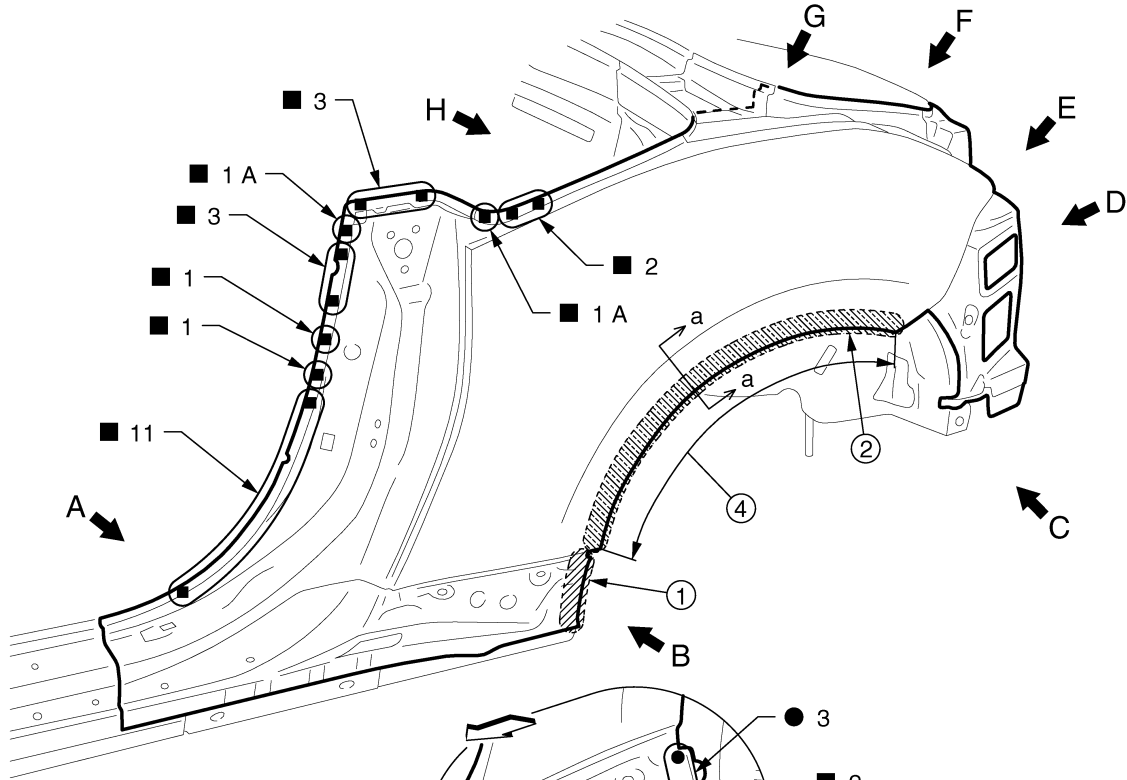
# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[ROADSTER]

## Rear Fender

INFOID:000000006353831



- 1. Body sealing
- 2. Adhesive
- 3. Urethane foam
- 4. Hemming portion

↔: Vehicle front

■: Perform the plug welding instead of the laser welding.

Replacement parts

- Rear fender (LH)

A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
K  
L  
M  
N  
O  
P

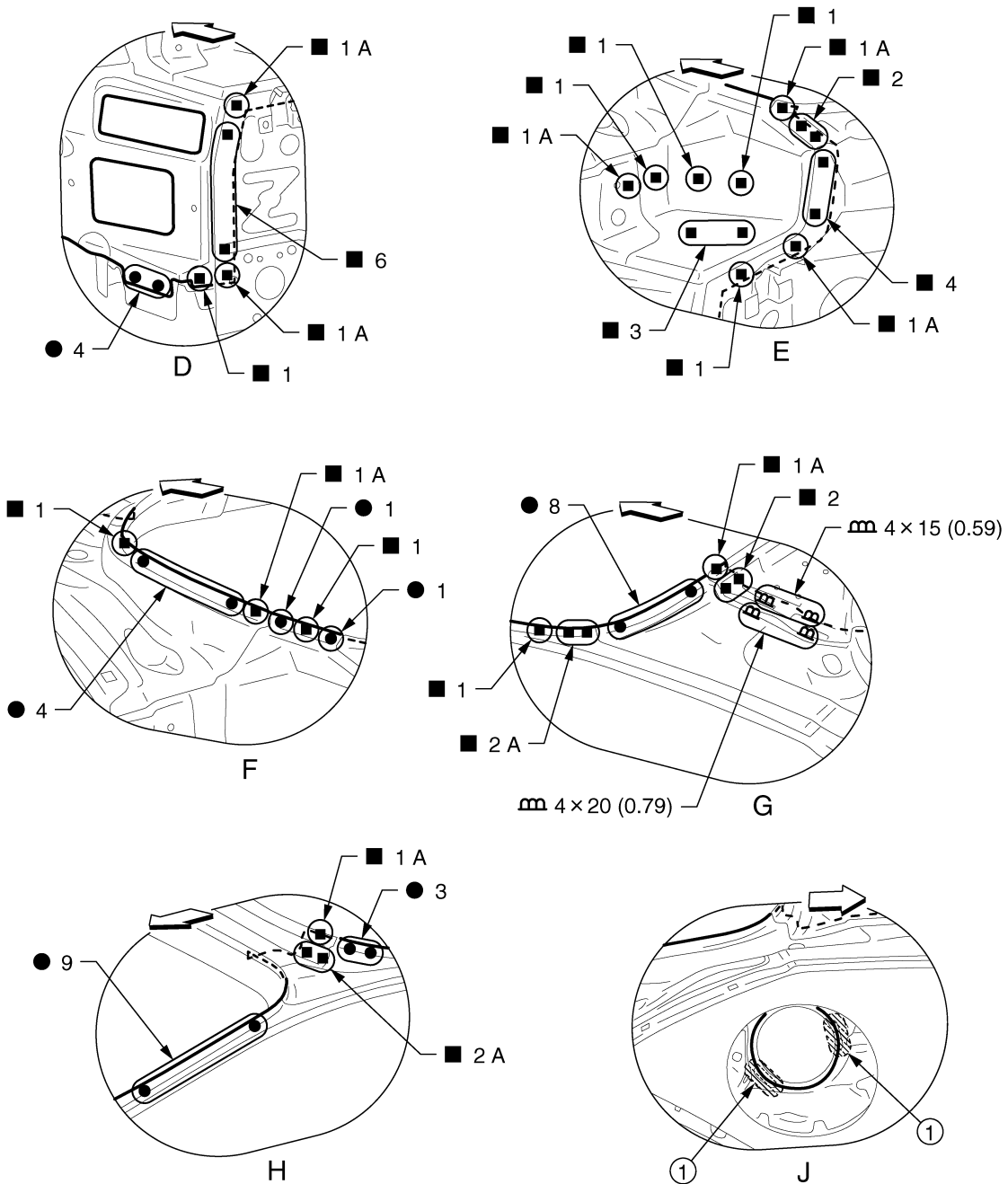
BRM

JSKIA1570ZZ

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[ROADSTER]



JSKIA1571GB

- 1. Adhesive
- Unit: mm (in)
- ◁: Vehicle front

View J: Right side rear fender  
POINT

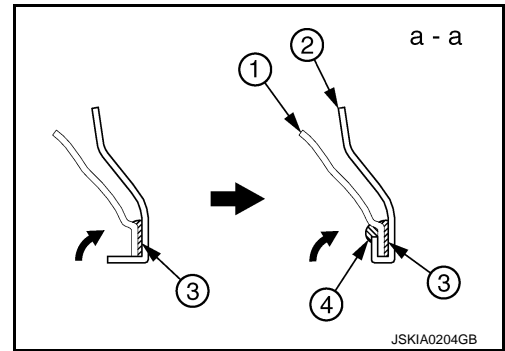
# REPLACEMENT OPERATIONS

## < REMOVAL AND INSTALLATION >

[ROADSTER]

- Perform the hemming to the flange of wheelarch after applying the adhesive.
- Apply the sealing to the flange end.
- Refer to [BRM-82. "Rear Fender Hemming Process"](#).

1. Outer rear wheelhouse
2. Rear fender
3. Adhesive
4. Sealant



A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
L  
M  
N  
O  
P

BRM

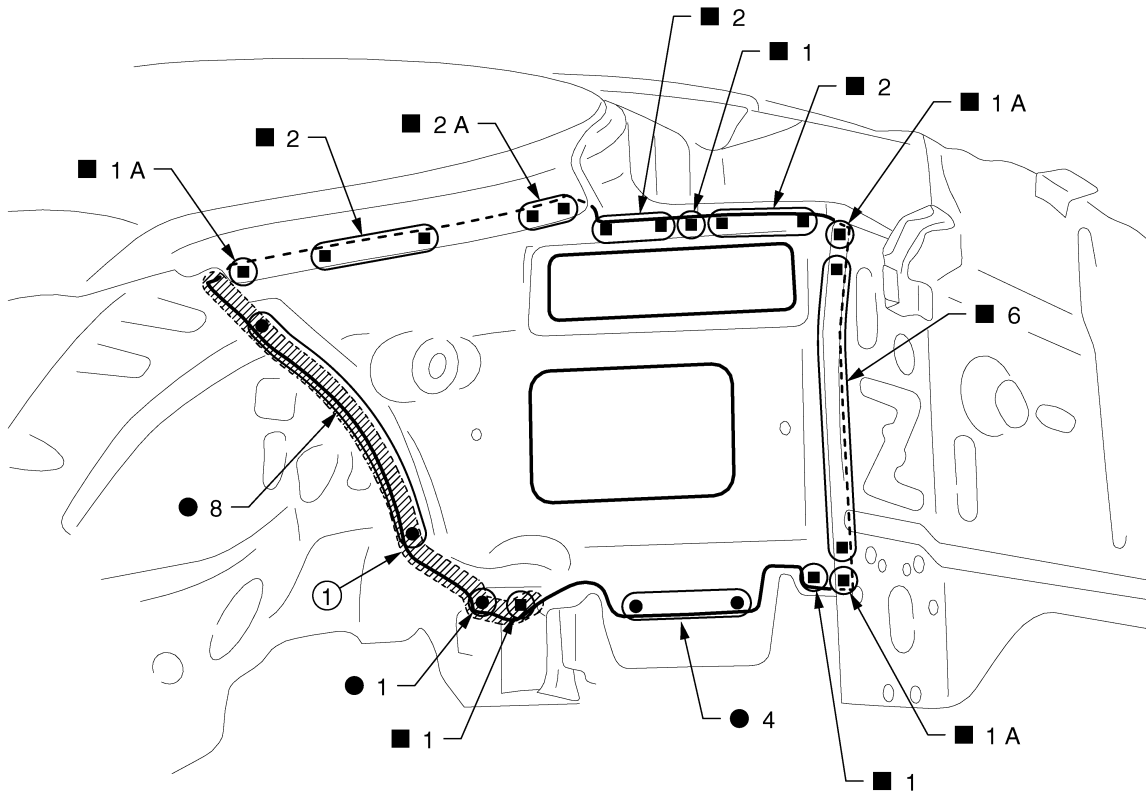
# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[ROADSTER]

## Rear Fender Extension

INFOID:000000006353832



JSKIA1572ZZ

1. Body sealing

Replacement parts

● Rear fender extension (LH)

## Lock Pillar Reinforcement

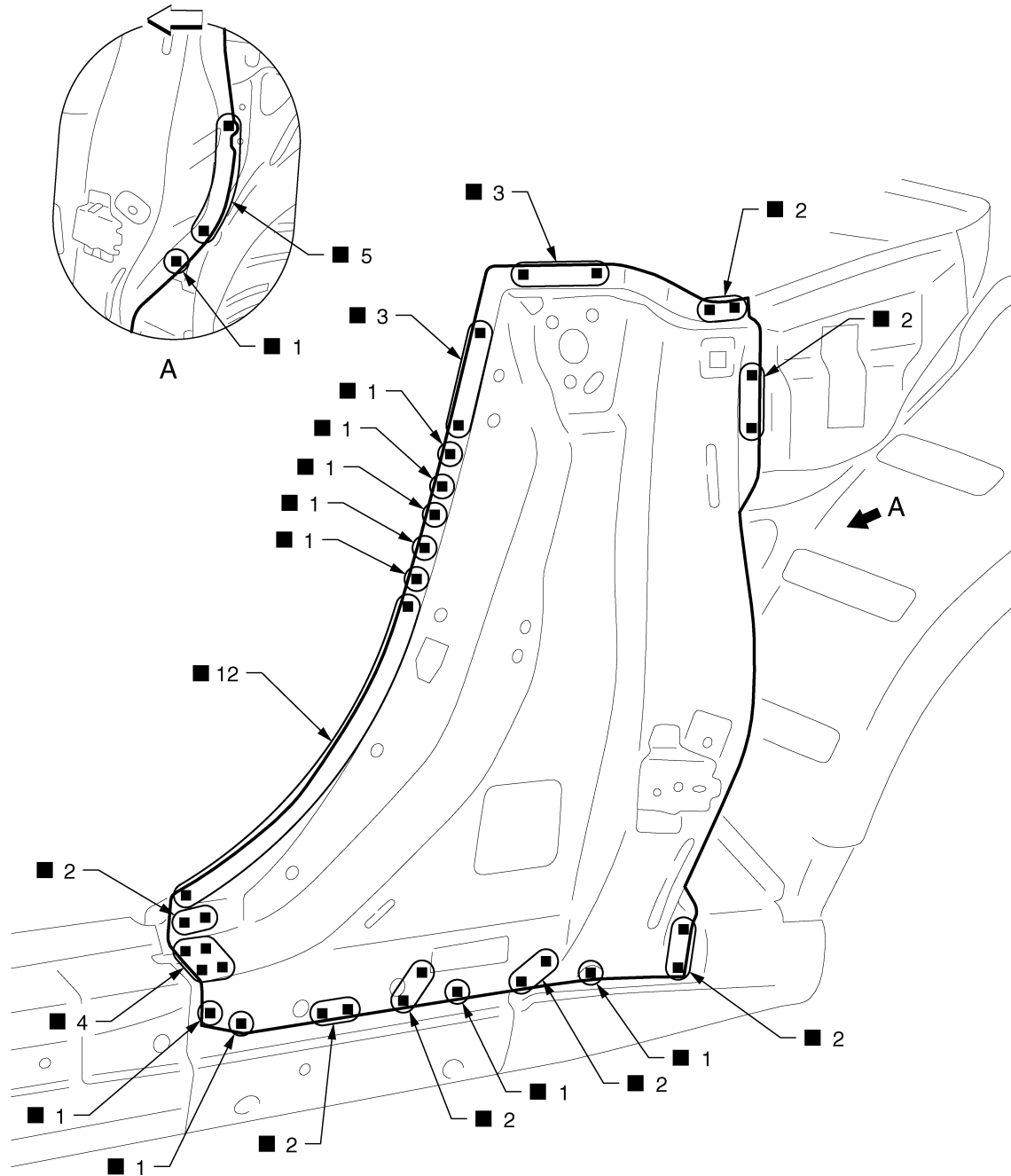
INFOID:000000006353833

Work after rear fender is removed.

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[ROADSTER]



←: Vehicle front

Replacement parts

- Lock pillar reinforcement assembly (LH)

JSKIA1573ZZ

A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
K  
L  
M  
N  
O  
P

BRM

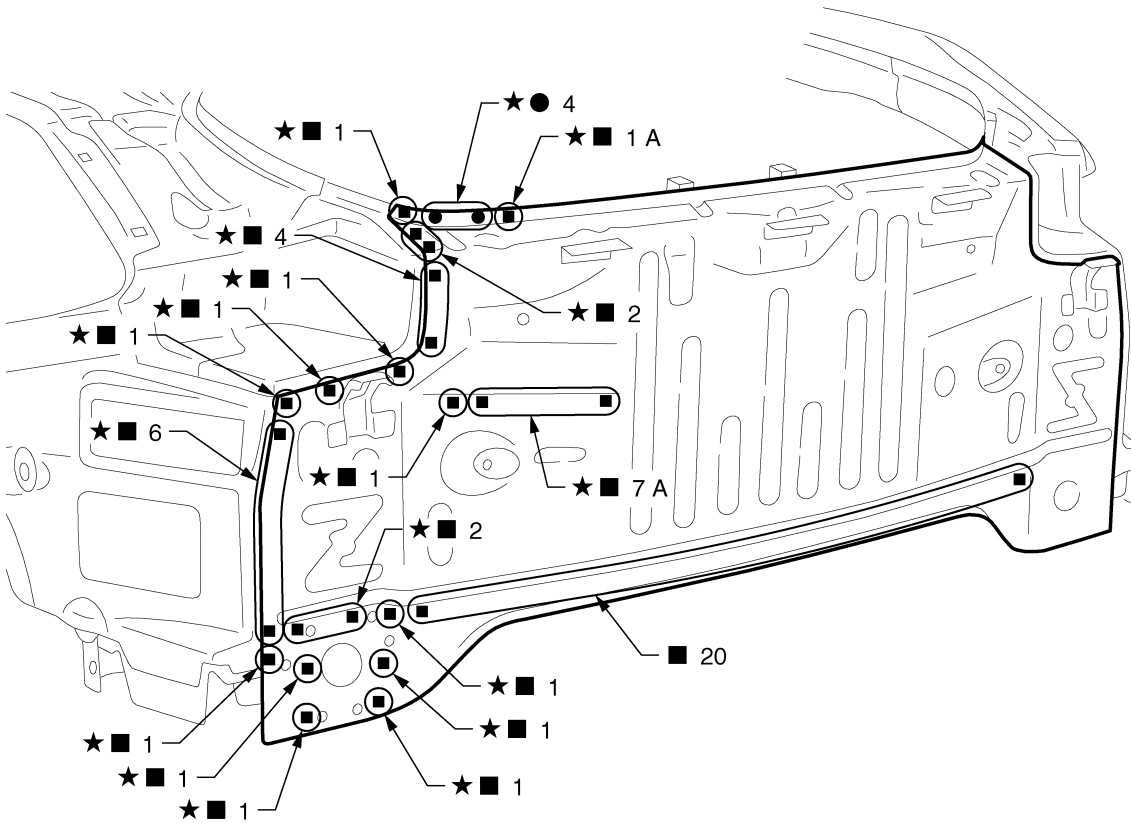
# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[ROADSTER]

## Rear Panel

INFOID:000000006353834



JSKIA1574ZZ

★: Welding method and the number of welding points apply to both side of the vehicle.

Replacement parts

- Rear panel assembly

## Rear Floor Rear

INFOID:000000006353835

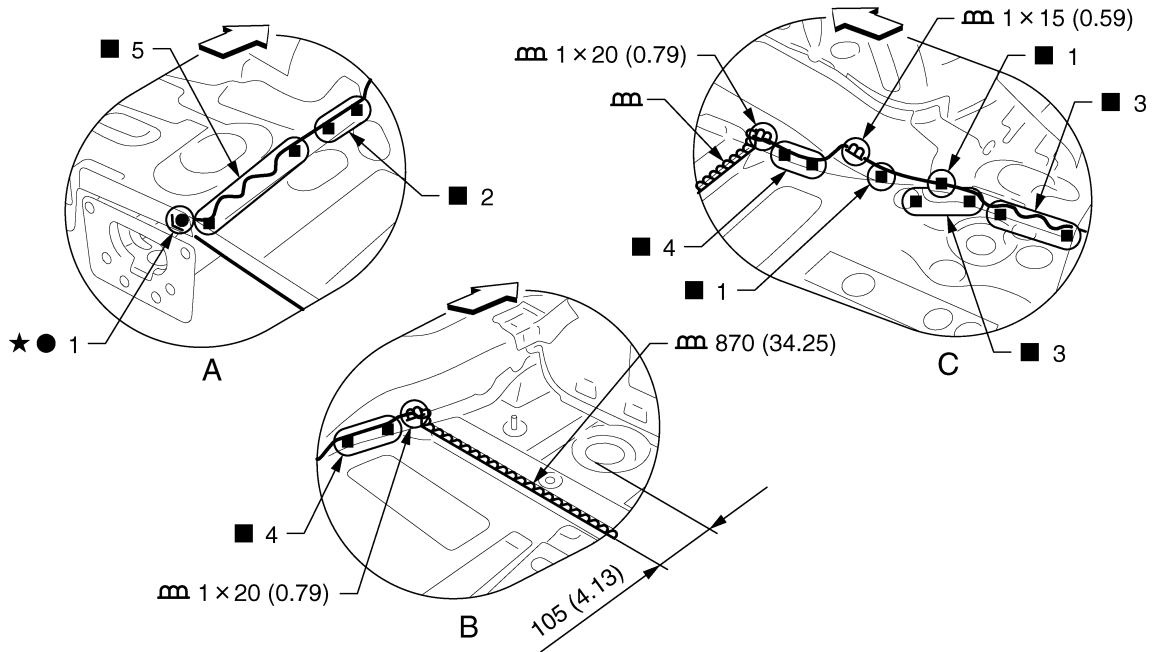
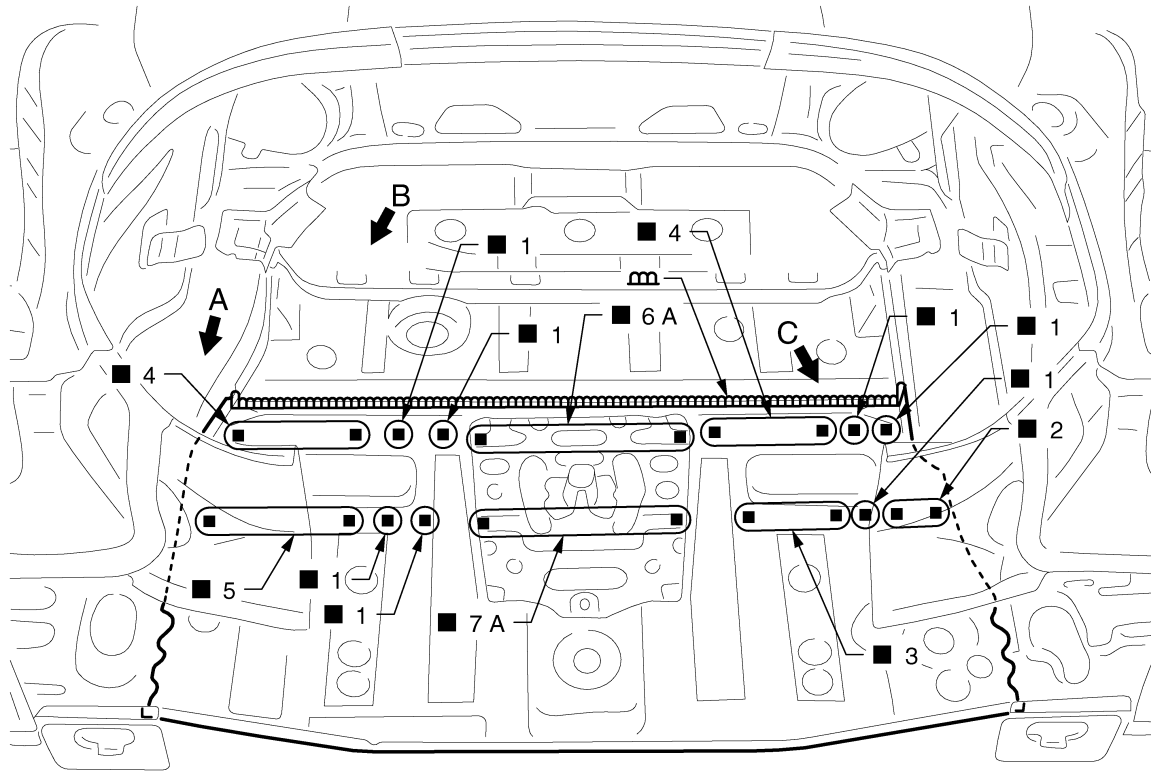
Work after rear panel is removed.



# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[ROADSTER]



JSKIA1575GB

Unit: mm (in)

↔: Vehicle front

★: Welding method and the number of welding points apply to both side of the vehicle.

Replacement parts

- Rear floor rear

## Rear Side Member Extension

INFOID:000000006353836

Work after rear panel is removed.

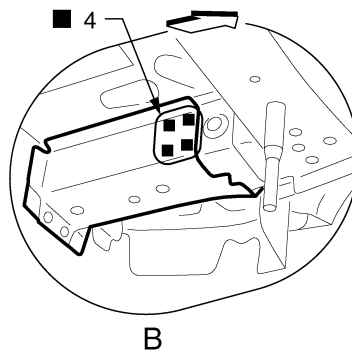
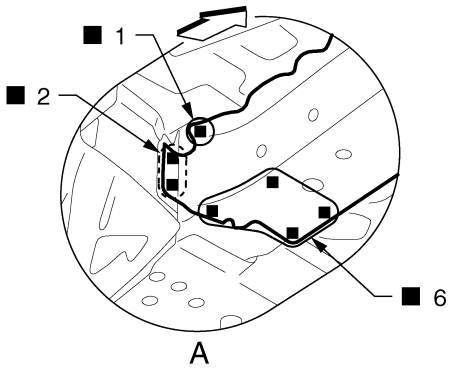
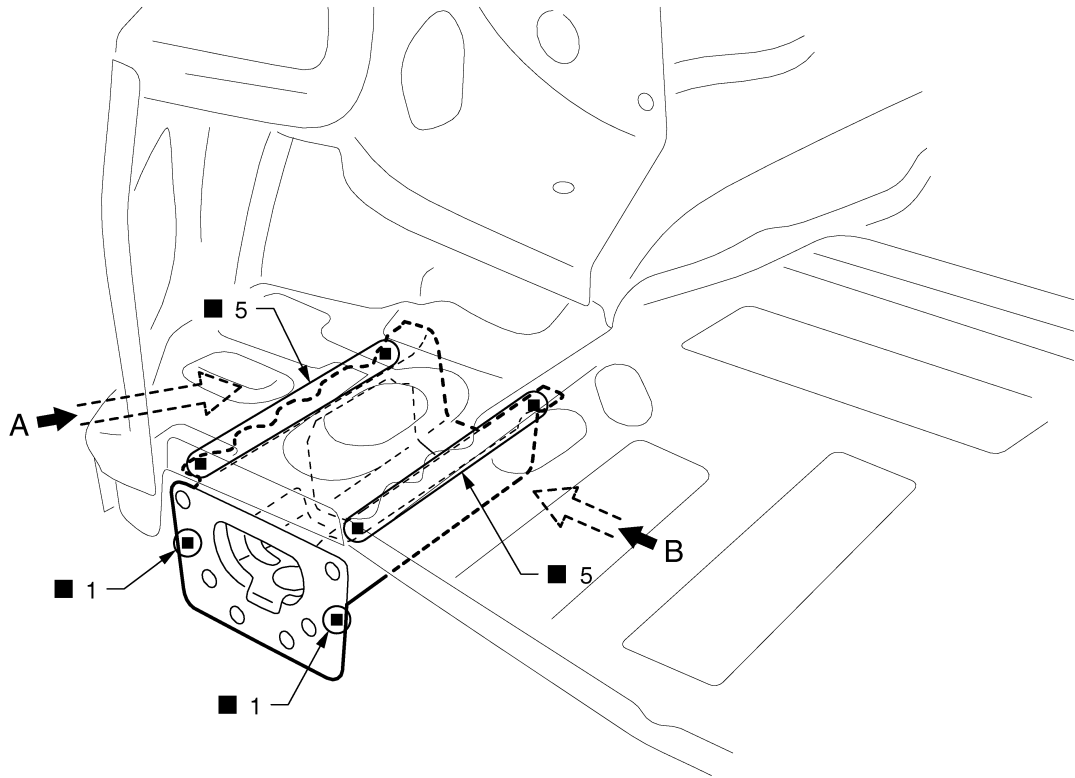
A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
K  
L  
M  
N  
O  
P

BRM

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

[ROADSTER]



JSKIA1576ZZ

←: Vehicle front

(○): Weld the parts onto the back of the component part.

Replacement parts

- Rear side member extension (LH)

# BODY ALIGNMENT

< SERVICE DATA AND SPECIFICATIONS (SDS)

[ROADSTER]

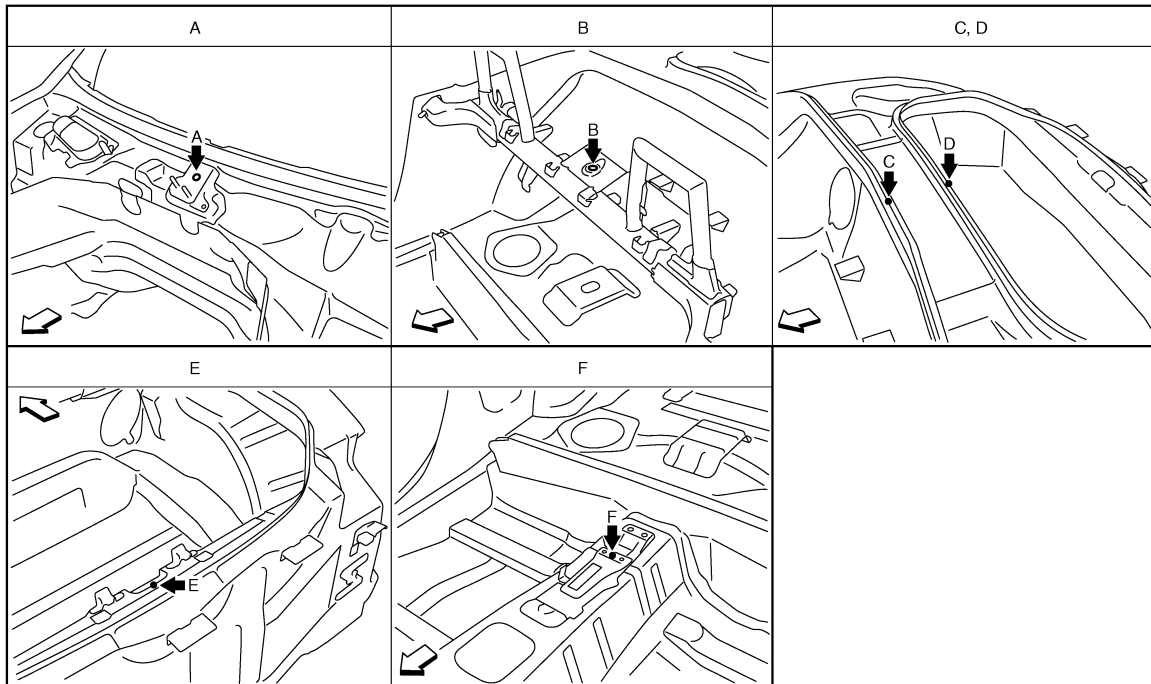
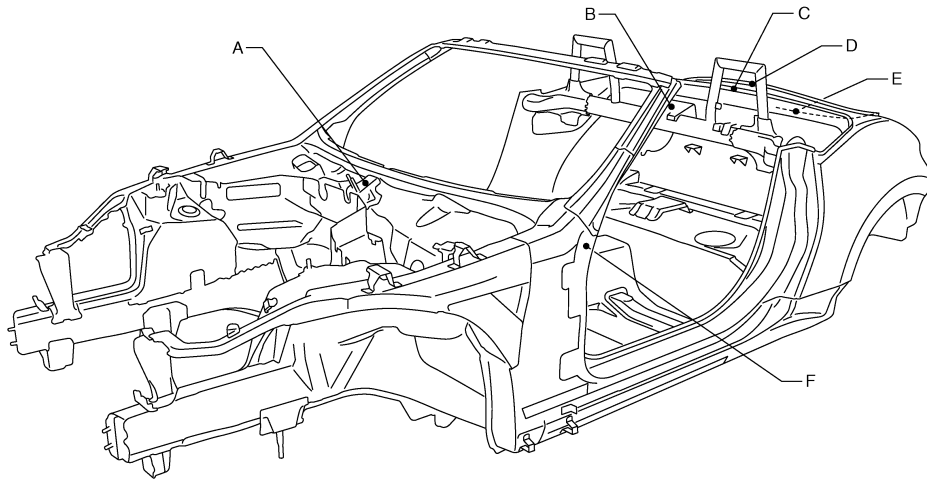
## SERVICE DATA AND SPECIFICATIONS (SDS)

### BODY ALIGNMENT

#### Body Center Marks

INFOID:000000006353837

A mark is placed on each part of the body to indicate the vehicle center. When repairing the vehicle frame (members, pillars, etc.) damaged by an accident which it enables more accurate and effective repair by using these marks together with body alignment specifications.



JSKIA1532ZZ

↶: Vehicle front

Unit: mm (in)

Points	Portion	Marks
A	Upper dash	Hole $\phi 8$ (0.31)
B	Storage lid lock reinforcement	Hole $\phi 16$ (0.63)
C, D	Rear waist	Bead

# BODY ALIGNMENT

< SERVICE DATA AND SPECIFICATIONS (SDS)

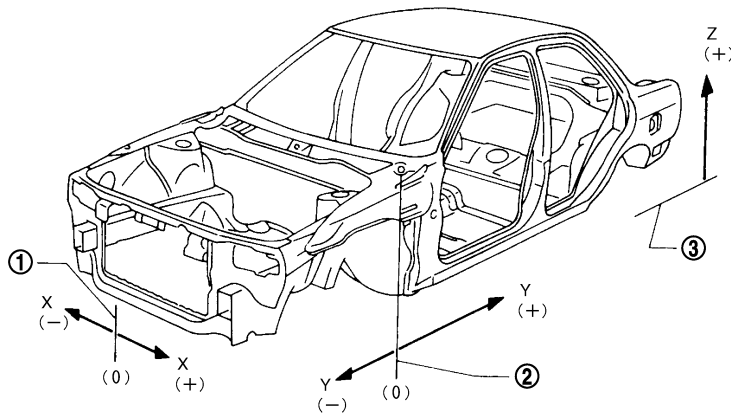
[ROADSTER]

Points	Portion	Marks
E	Rear panel	Indent
F	Trans control reinforcement	Embossment

## Description

INFOID:000000006353838

- All dimensions indicated in the figures are actual.
- When using a tracking gauge, adjust both pointers to equal length. Then check the pointers and gauge itself to make sure there is no free play.
- When a measuring tape is used, check to be sure there is no elongation, twisting or bending.
- Measurements should be taken at the center of the mounting holes.
- An asterisk (\*) following the value at the measuring point indicates that the measuring point on the other side is symmetrically the same value.
- The coordinates of the measurement points are the distances measured from the standard line of "X", "Y" and "Z".
- "Z": Imaginary base line [200 mm (7.87 in) below datum line ("0Z" at design plan)]



JSKIA0073GB

1. Vehicle center

2. Front axle center

3. Imaginary base line

## Engine Compartment

INFOID:000000006353839

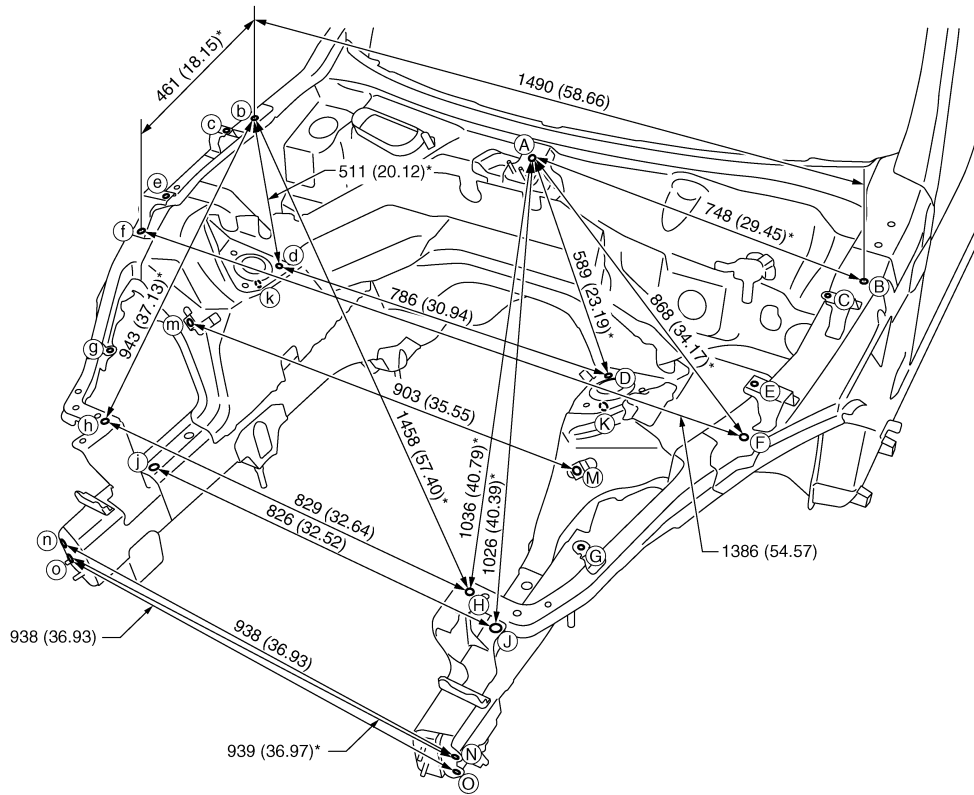
### MEASUREMENT

Dimensions marked with "\*" indicate symmetrically identical dimensions on both the right and left hand of the vehicle.

# BODY ALIGNMENT

< SERVICE DATA AND SPECIFICATIONS (SDS)

[ROADSTER]



JSKIA0884GB

Unit: mm (in)

«The others»

Unit: mm (in)

Point	Dimension	Memo	Point	Dimension	Memo	Point	Dimension	Memo	Point	Dimension	Memo
A - C	735 (28.94)*		B - d	1197 (47.13)*		C - c	1423 (56.02)		F - h	1187 (46.73)*	
A - E	804 (31.65)*		B - E	381 (15.00)*		D - m	875 (34.45)*		G - g	1073 (42.24)	
A - G	967 (38.07)*		B - f	1509 (59.41)*		E - e	1349 (53.11)		K - k	903 (35.55)	
B - C	131 (5.16)*		B - G	767 (30.20)*		F - H	511 (20.12)*				

## MEASUREMENT POINTS

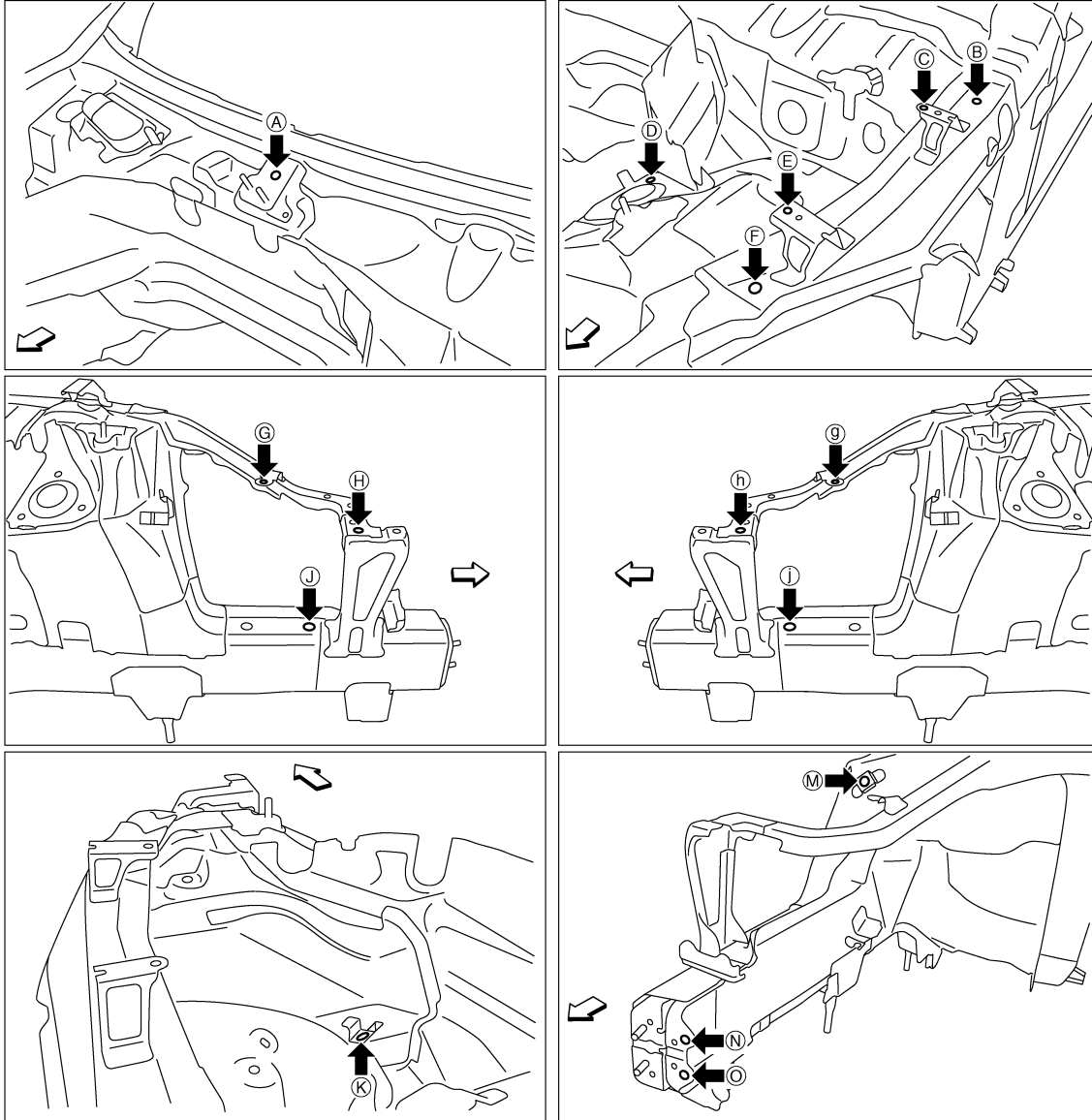
A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
K  
L  
M  
N  
O  
P

BRM

# BODY ALIGNMENT

< SERVICE DATA AND SPECIFICATIONS (SDS)

[ROADSTER]



JSKIA0885ZZ

↶: Vehicle front

Unit: mm (in)

Point	Material	Point	Material
A	Center wiper pivot bracket hole center of center positioning mark $\phi 8$ (0.31)	H, h	Radiator core support stay hole center $\phi 12$ (0.47)
B, b, F, f	Hoodedge reinforcement hole center 12×14 (0.47×0.55)	J, j	Front side member hole center $\phi 20$ (0.79)
C, c, E, e	Front fender installing hole center $\phi 7$ (0.28)	K, k, M, m	Nut holder hole center $\phi 16$ (0.63)
D, d	Front strut installing hole center $\phi 11$ (0.43)	N, n, O, o	Front bumper reinforcement installing hole center $\phi 11$ (0.43)
G, g	Rear air cleaner bracket hole center $\phi 7$ (0.28)		

## Underbody

INFOID:000000006353840

## MEASUREMENT

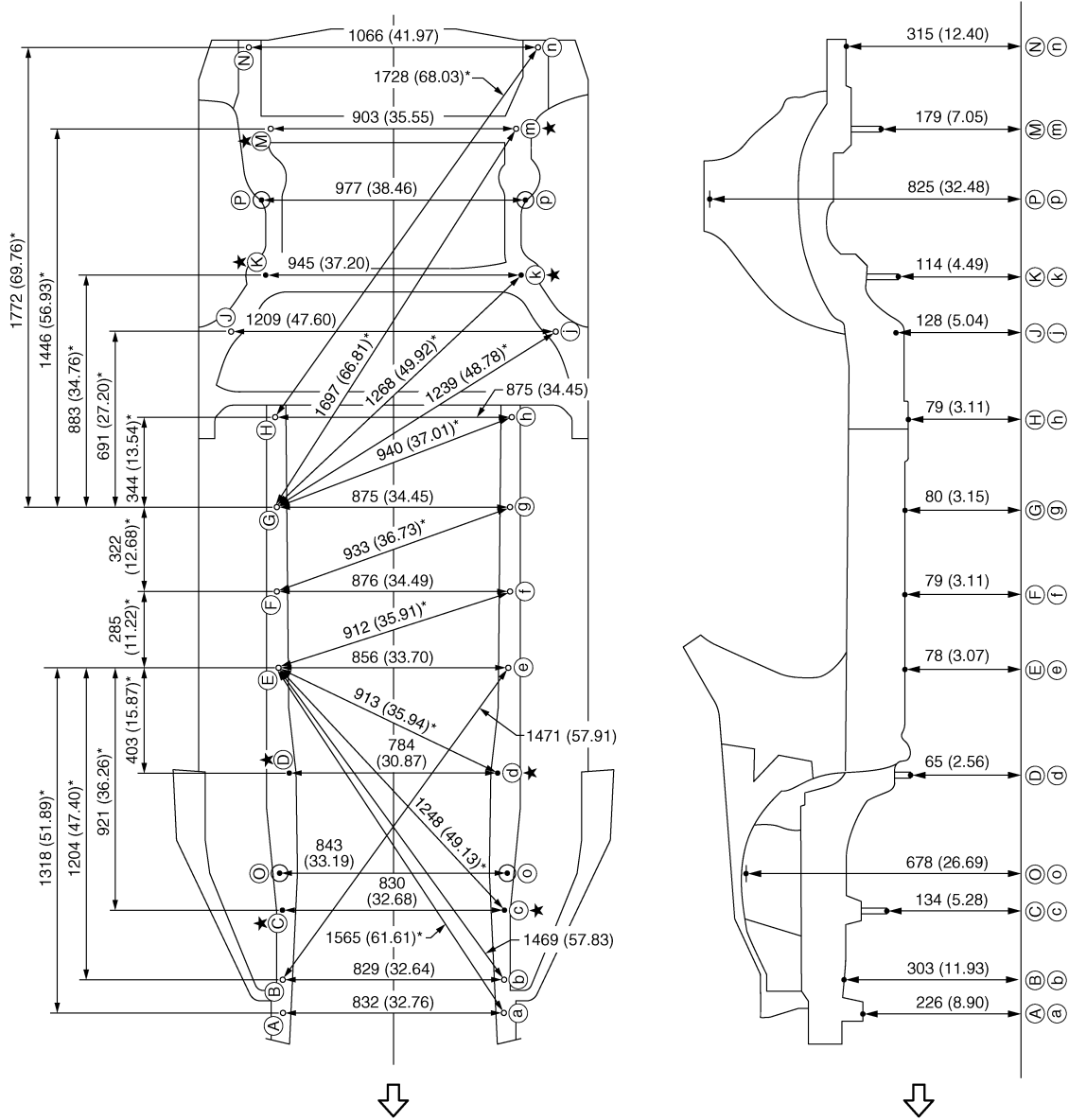
# BODY ALIGNMENT

< SERVICE DATA AND SPECIFICATIONS (SDS)

[ROADSTER]

Dimensions marked with "\*" indicate symmetrically identical dimensions on both the right and left hand of the vehicle.

The following figure shows a bottom view and a side view of the vehicle.



- Unit: mm (in)
- ↳ Vehicle front
- ★: Bolt head

## MEASUREMENT POINTS

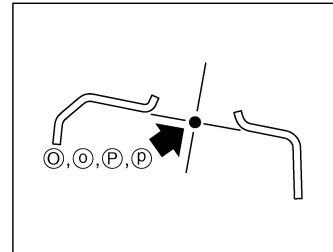
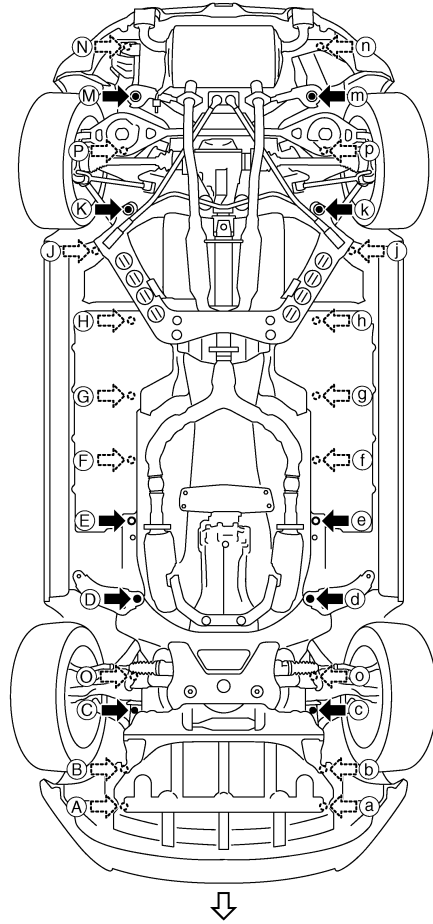
A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
K  
L  
M  
N  
O  
P

BRM

# BODY ALIGNMENT

< SERVICE DATA AND SPECIFICATIONS (SDS)

[ROADSTER]



JSKIA1533ZZ

↶ Vehicle front

Unit: mm (in)

Points	Coordinates			Remarks	Points	Coordinates			Remarks
	X	Y	Z			X	Y	Z	
A, a	±415.8 (±16.370)	-495.0 (-19.488)	225.6 (8.882)	Hole φ13 (0.51)	H, h	±437.5 (±17.224)	1765.5 (69.508)	79.0 (3.110)	Hole φ8 (0.31)
B	416.2 (16.386)	-368.0 (-14.488)	303.2 (11.937)	Hole φ16 (0.63)	J, j	±604.5 (±23.799)	2090.5 (82.303)	128.3 (5.051)	Hole φ16 (0.63)
b	-413.2 (-16.268)	-368.0 (-14.488)	303.2 (11.937)	Hole φ16 (0.63)	K, k	±472.6 (±18.606)	2303.8 (90.701)	114.0 (4.488)	Bolt head
C, c	±415.0 (±16.339)	-104.0 (-4.094)	133.5 (5.256)	Bolt head	M, m	±451.5 (±17.776)	2863.9 (112.752)	179.1 (7.051)	Bolt head
D, d	±392.0 (±15.433)	414.0 (16.299)	64.5 (2.539)	Bolt head	N, n	±533.0 (±20.984)	3175.0 (125.000)	315.4 (12.417)	Hole φ16 (0.63)
E, e	±428.0 (±16.850)	815.0 (32.087)	78.4 (3.087)	Hole 16×20 (0.63×0.79)	O, o	±421.6 (±16.598)	38.2 (1.504)	677.9 (26.689)	Hole φ50.1 (1.972)



# BODY ALIGNMENT

< SERVICE DATA AND SPECIFICATIONS (SDS)

[ROADSTER]

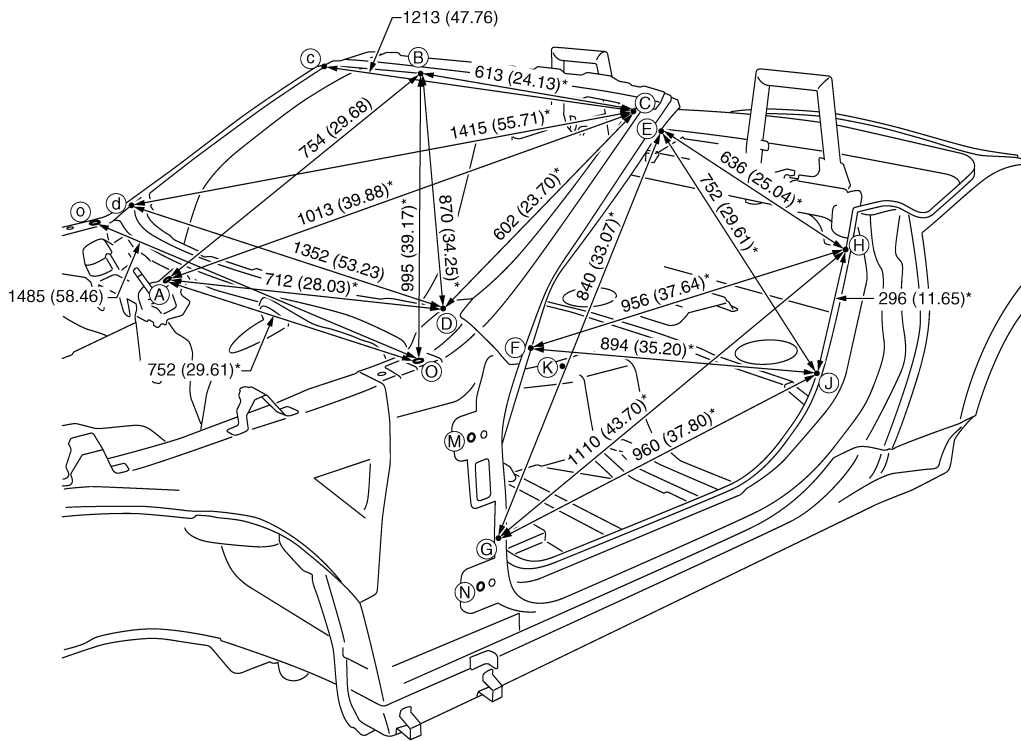
Points	Coordinates			Remarks	Points	Coordinates			Remarks
	X	Y	Z			X	Y	Z	
F, f	±438.0 (±17.244)	1100.0 (43.307)	79.0 (3.110)	Hole φ16 (0.63)	P, p	±488.4 (±19.228)	2591.7 (102.035)	825.0 (32.480)	Hole φ68 (2.68)
G, g	±437.5 (±17.224)	1421.8 (55.976)	80.0 (3.150)	Hole φ8 (0.31)					

## Passenger Compartment

INFOID:0000000006353841

### MEASUREMENT

Dimensions marked with "\*" indicate symmetrically identical dimensions on both the right and left hand of the vehicle.



JSKIA1534GB

Unit: mm (in)

«The others»

Unit: mm (in)

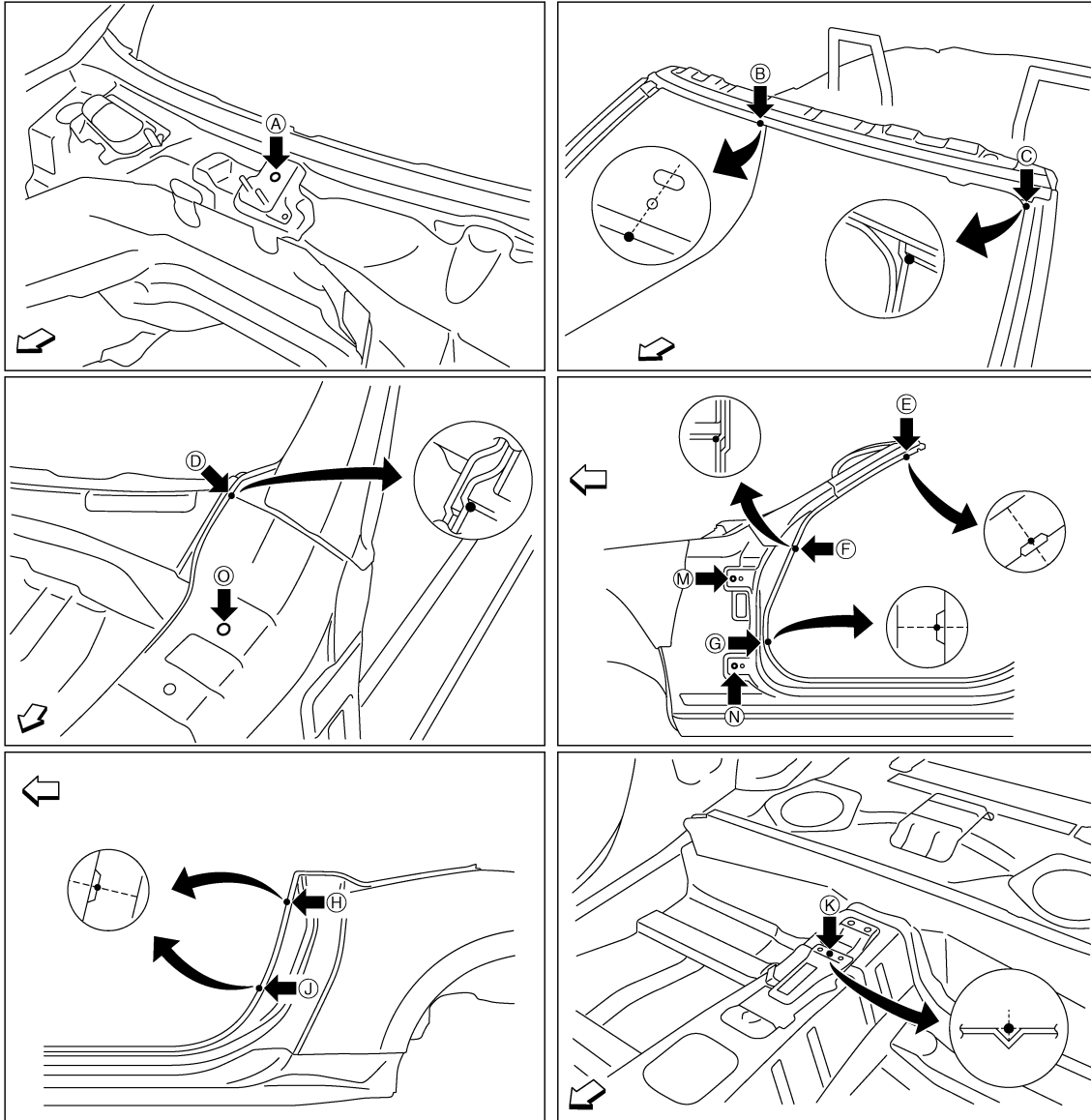
Point	Dimension	Memo	Point	Dimension	Memo	Point	Dimension	Memo	Point	Dimension	Memo
E - e	1275 (50.20)		F - j	1713 (67.44)*		J - j	1471 (57.91)		M - m	1615 (63.58)	
E - g	1599 (62.95)*		G - g	1452 (57.17)		K - E	1024 (40.31)*		M - H	1167 (45.94)*	
E - h	1499 (59.02)*		G - h	1825 (71.85)*		K - F	1094 (43.07)*		M - J	1074 (42.28)*	
E - j	1562 (61.50)*		G - j	1749 (68.86)*		K - G	1095 (43.11)*		N - n	1649 (64.92)	
F - f	1452 (57.17)		H - h	1445 (56.89)		K - H	871 (34.29)*		N - H	1230 (48.43)*	
F - h	1736 (68.35)*		H - j	1488 (58.58)*		K - J	763 (30.04)*		N - J	1071 (42.17)*	

### MEASUREMENT POINTS

# BODY ALIGNMENT

< SERVICE DATA AND SPECIFICATIONS (SDS)

[ROADSTER]



JSKIA1535ZZ

↶: Vehicle front

Unit: mm (in)

Point	Material	Point	Material
A	Center wiper pivot bracket hole center of center positioning mark $\phi 8$ (0.31)	G, g	Front pillar hinge brace indent
B	Front roof rail reinforcement flange end	H, h, J, j	Rear fender indent
C, c	Front pillar joggle	K	Trans control reinforcement positioning mark of center positioning mark
D, d, F, f	Front pillar hinge brace joggle	M, m, N, n	Door hinge installing hole center $\phi 12$ (0.47)
E, e	Front pillar indent	O, o	Hood hinge installing hole center $\phi 11$ (0.43)

## Soft Top Mounting Bracket

INFOID:000000006353842

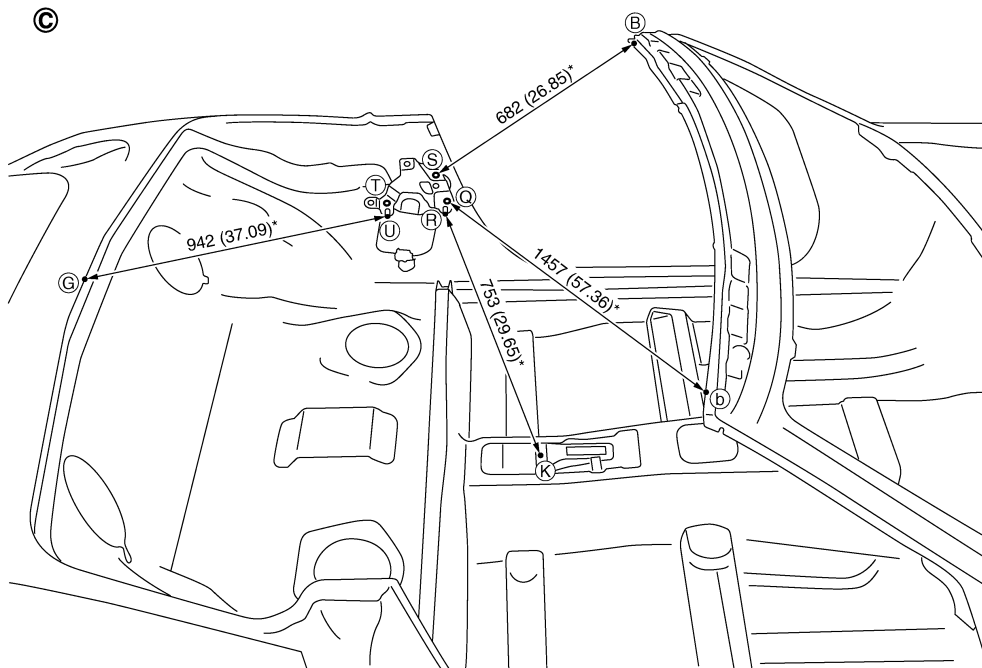
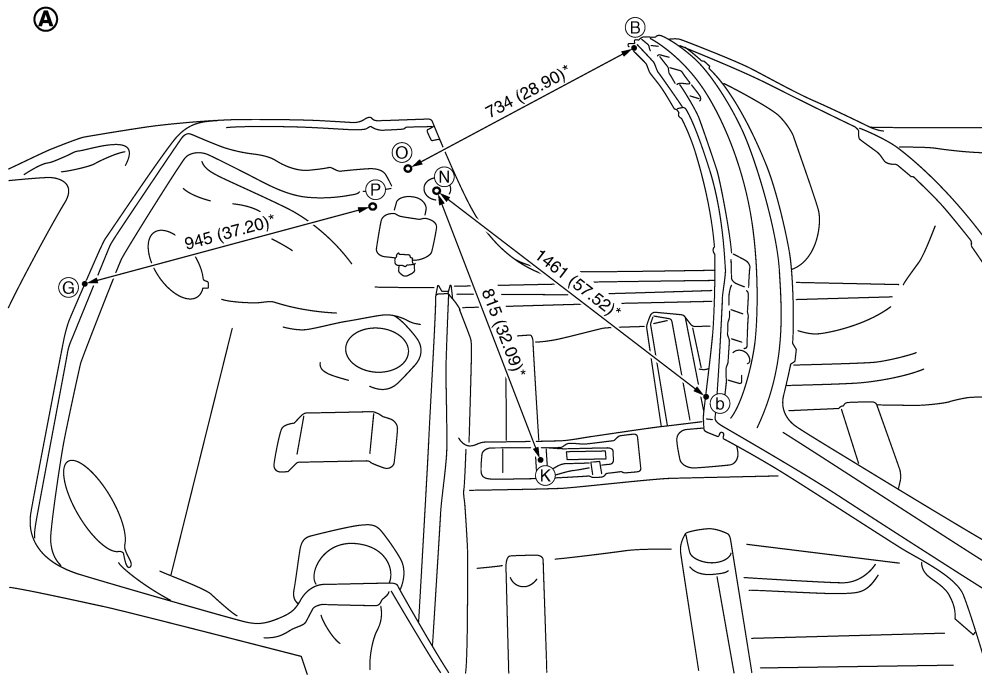
### MEASUREMENT

Dimensions marked with "\*" indicate symmetrically identical dimensions on both the right and left hand of the vehicle.

# BODY ALIGNMENT

< SERVICE DATA AND SPECIFICATIONS (SDS)

[ROADSTER]



A. After the removal of roof mounting bracket.

C. Before the removal of roof mounting bracket.

Unit: mm (in)

«The others»

A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
K  
L  
M  
N  
O  
P

BRM

JSKIA1536GB

# BODY ALIGNMENT

< SERVICE DATA AND SPECIFICATIONS (SDS)

**[ROADSTER]**

Unit: mm (in)

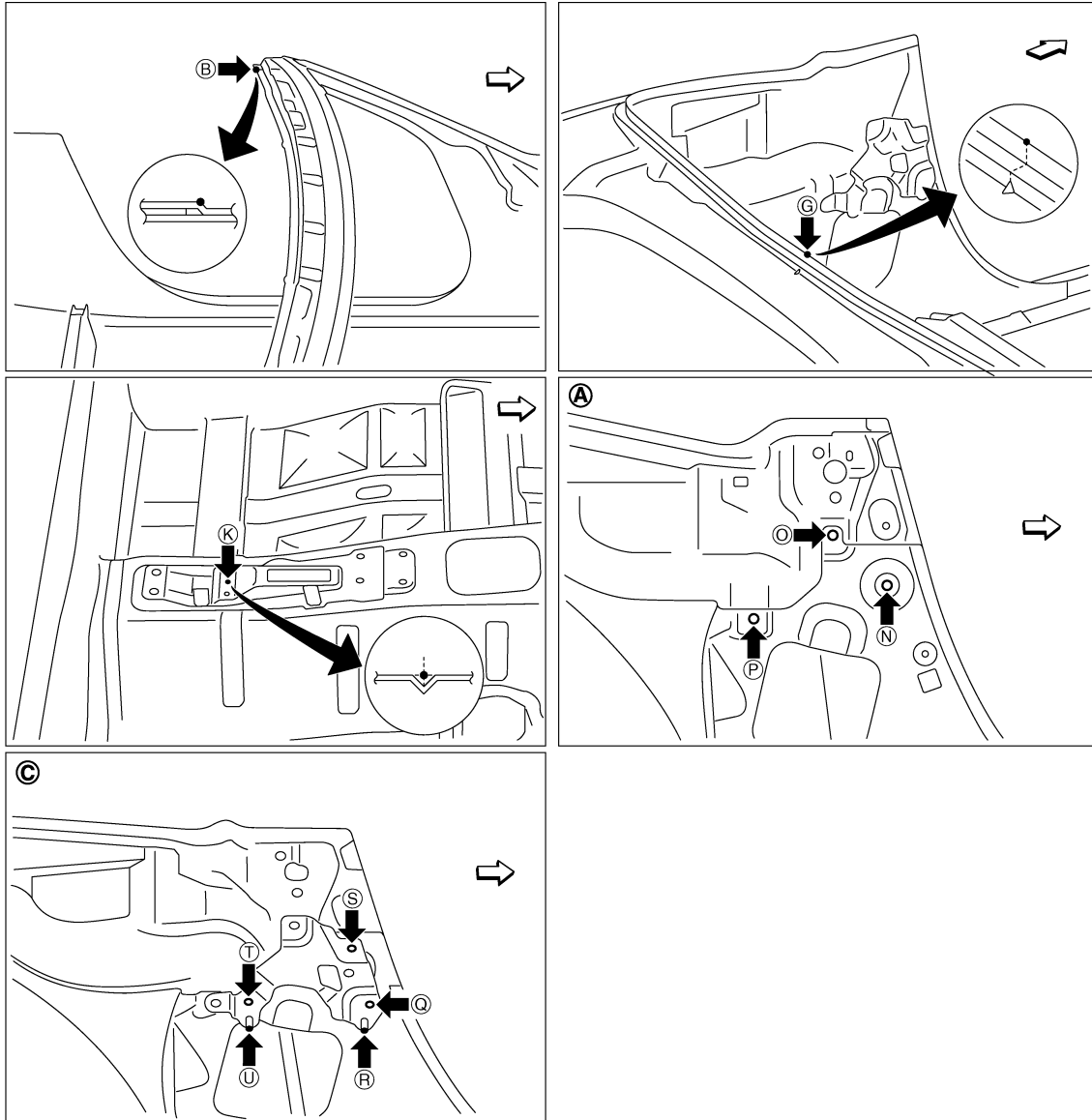
Point	Dimension	Memo	Point	Dimension	Memo	Point	Dimension	Memo	Point	Dimension	Memo
B - N	720 (28.35)*		G - N	1041 (40.98)*		N - n	1423 (56.02)		R - s	1376 (54.17)*	
B - o	1479 (58.23)*		G - O	985 (38.78)*		N - o	1440 (56.69)*		R - t	1375 (54.13)*	
B - P	882 (34.72)*		G - Q	1065 (41.93)*		N - p	1436 (56.54)*		R - u	1351 (53.19)*	
B - p	1548 (60.94)*		G - R	1053 (41.46)*		O - o	1450 (57.09)		S - s	1390 (54.72)	
B - Q	731 (28.78)*		G - S	1020 (40.16)*		O - p	1446 (56.93)*		S - t	1394 (54.88)*	
B - R	750 (29.53)*		G - T	950 (37.40)*		P - p	1424 (56.06)		S - u	1372 (54.02)*	
B - r	1449 (57.05)*		K - O	878 (34.57)*		Q - q	1400 (55.12)		T - t	1380 (54.33)	
B - s	1429 (56.26)*		K - P	875 (34.45)*		Q - r	1376 (54.17)*		T - u	1357 (53.43)*	
B - T	837 (32.95)*		K - Q	781 (30.75)*		Q - s	1398 (55.04)*		U - u	1332 (52.44)	
B - t	1506 (59.29)*		K - S	818 (32.20)*		Q - t	1400 (55.12)*				
B - U	851 (33.50)*		K - T	839 (33.03)*		Q - u	1376 (54.17)*				
B - u	1496 (58.90)*		K - U	811 (31.93)*		R - r	1352 (53.23)				

## MEASUREMENT POINTS

# BODY ALIGNMENT

< SERVICE DATA AND SPECIFICATIONS (SDS)

[ROADSTER]



A. After the removal of roof mounting bracket.

C. Before the removal of roof mounting bracket.

←: Vehicle front

JSKIA1537ZZ

Unit: mm (in)

Point	Material	Point	Material
B, b	Front roof rail reinforcement joggle	N, n, O, o, P, p	Lower inner rear pillar hole center $\phi 15$ (0.59)
G	Rear waist flange end of center positioning mark	Q, q, S, s, T, t	Folding roof mounting bracket hole center $\phi 9$ (0.35)
K	Trans control reinforcement positioning mark of center positioning mark	R, r, U, u	Folding roof mounting bracket pin top

## Rear Body

INFOID:000000006353843

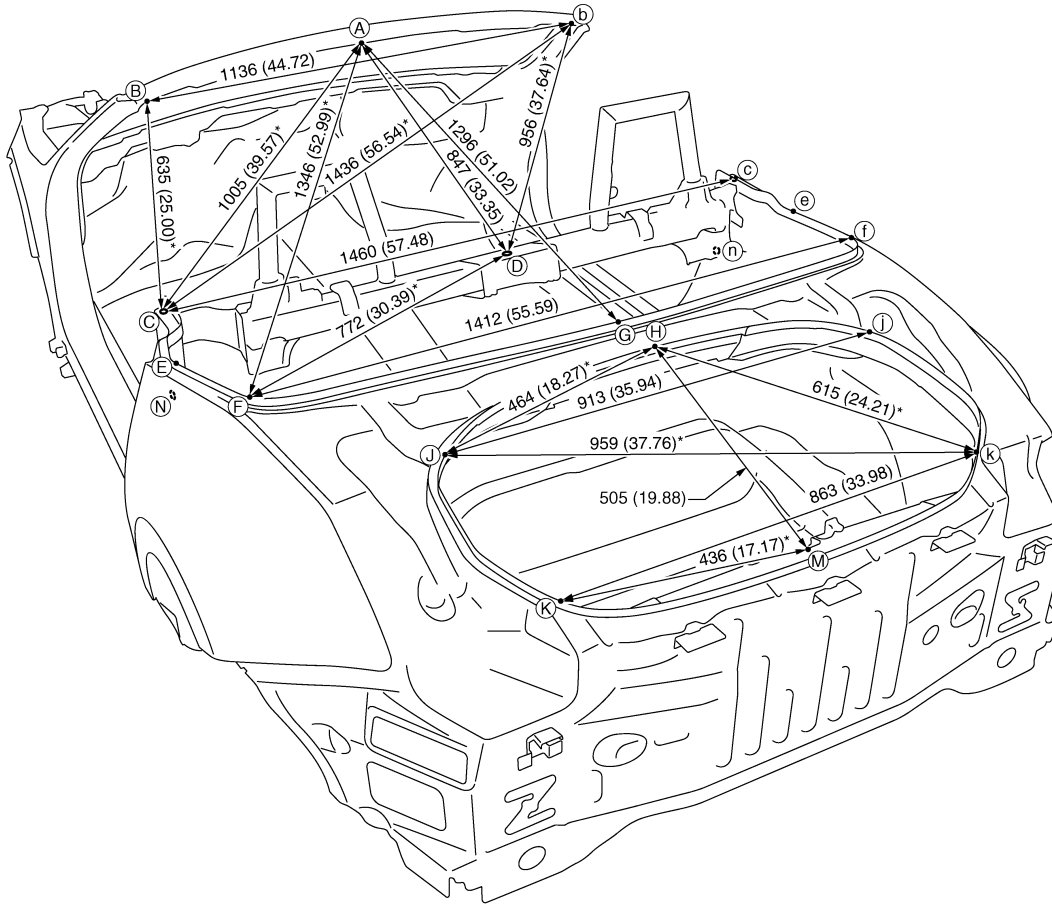
### MEASUREMENT

Dimensions marked with "\*" indicate symmetrically identical dimensions on both the right and left hand of the vehicle.

# BODY ALIGNMENT

< SERVICE DATA AND SPECIFICATIONS (SDS)

[ROADSTER]



JSKIA1538GB

Unit: mm (in)

«The others»

Unit: mm (in)

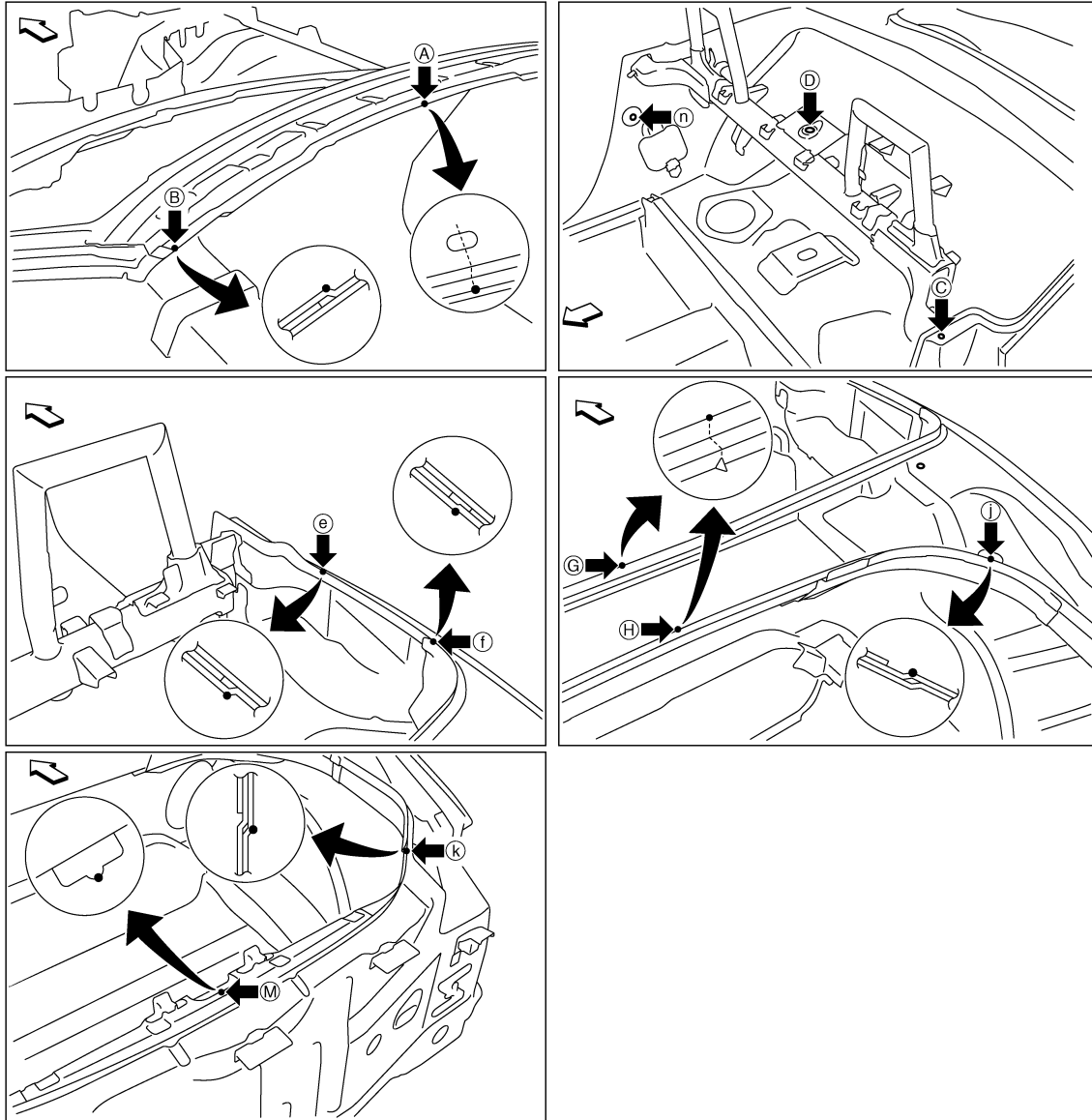
Point	Dimension	Memo	Point	Dimension	Memo	Point	Dimension	Memo	Point	Dimension	Memo
A - E	1173 (46.18)*		B - J	1430 (56.30)*		D - E	765 (30.12)*		F - G	726 (28.58)*	
A - H	1431 (56.34)*		B - K	1793 (70.59)		D - G	475 (18.70)*		J - K	363 (14.29)	
A - J	1571 (61.85)*		b - k	1794 (70.63)		D - H	614 (24.17)*		j - k	364 (14.33)	
A - N	1052 (41.42)*		B - N	720 (28.35)*		D - J	816 (32.13)*		J - M	626 (24.65)*	
B - F	1077 (42.40)*		B - n	1461 (57.52)*		E - e	1526 (60.08)		N - n	1423 (56.02)	
B - f	1663 (65.47)*		C - D	754 (29.68)*		E - f	1497 (58.94)*				
B - G	1345 (52.95)*		C - G	987 (38.86)*		E - G	890 (35.04)*				

## MEASUREMENT POINTS

# BODY ALIGNMENT

< SERVICE DATA AND SPECIFICATIONS (SDS)

[ROADSTER]



A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
L  
M  
N  
O  
P

BRM

JSKIA1539ZZ

←: Vehicle front

Unit: mm (in)

Point	Material	Point	Material
A	Front roof rail reinforcement flange end	G, H	Rear waist flange end of center positioning mark
B, b	Front roof rail reinforcement joggle	J, j	Rear fender extension joggle
C, c	Rear fender extension hole center $\phi 5$ (0.20)	K, k	Rear combination lamp base joggle
D	Storage lid lock reinforcement hole center $\phi 16$ (0.63)	M	Upper rear panel reinforcement indent of center positioning mark
E, e	Inner rear pillar joggle	N, n	Inner rear pillar hole center $\phi 15$ (0.59)
F, f	Inner rear side extension joggle		

# LOCATION OF PLASTIC PARTS

< SERVICE DATA AND SPECIFICATIONS (SDS)

[ROADSTER]

## LOCATION OF PLASTIC PARTS

### Precautions for Plastics

INFOID:000000006353844

Abbreviation	Material name	Heatresisting temperature °C (°F)	Resistance to gasoline and solvents	Other cautions
PE	Polyethylene	60 (140)	Gasoline and most solvents are harmless if applied for a very short time (wipe out quickly).	Flammable
ABS	Acrylonitrile Butadiene Styrene	80 (176)	Avoid gasoline and solvents.	—
EPM/EPDM	Ethylene Propylene (Diene) copolymer	80 (176)	Gasoline and most solvents are harmless if applied for a very short time (wipe out quickly).	Flammable
PS	Polystyrene	80 (176)	Avoid solvents.	Flammable
PVC	Poly Vinyl Chloride	80 (176)	Gasoline and most solvents are harmless if applied for a very short time (wipe out quickly).	Poisonous gas is emitted when burned.
TPO	Thermoplastic Olefine	80 (176)	↑	Flammable
AAS	Acrylonitrile Acrylic Styrene	85 (185)	Avoid gasoline and solvents.	—
PMMA	Poly Methyl Methacrylate	85 (185)	↑	—
EVAC	Ethylene Vinyl Acetate	90 (194)	↑	—
PP	Polypropylene	90 (194)	Gasoline and most solvents are harmless if applied for a very short time (wipe out quickly).	Flammable, avoid battery acid.
PUR	Polyurethane	90 (194)	Avoid gasoline and solvents.	—
UP	Unsaturated Polyester	90 (194)	↑	Flammable
ASA	Acrylonitrile Styrene Acrylate	100 (212)	↑	Flammable
PPE	Poly Phenylene Ether	110 (230)	↑	—
TPU	Thermoplastic Urethane	110 (230)	↑	—
PBT+PC	Poly Butylene Terephthalate + Polycarbonate	120 (248)	↑	Flammable
PC	Polycarbonate	120 (248)	↑	—
POM	Poly Oxymethylene	120 (248)	↑	Avoid battery acid.
PA	Polyamide	140 (284)	↑	Avoid immersing in water.
PBT	Poly Butylene Terephthalate	140 (284)	↑	—
PAR	Polyarylate	180 (356)	↑	—
PET	Polyethylene terephthalate	180 (356)	↑	—
PEI	Polyetherimide	200 (392)	↑	—

**CAUTION:**

- When repairing and painting a portion of the body adjacent to plastic parts, consider their characteristics (influence of heat and solvent) and remove them if necessary or take suitable measures to protect them.
- Plastic parts should be repaired and painted using methods suiting the materials' characteristics.



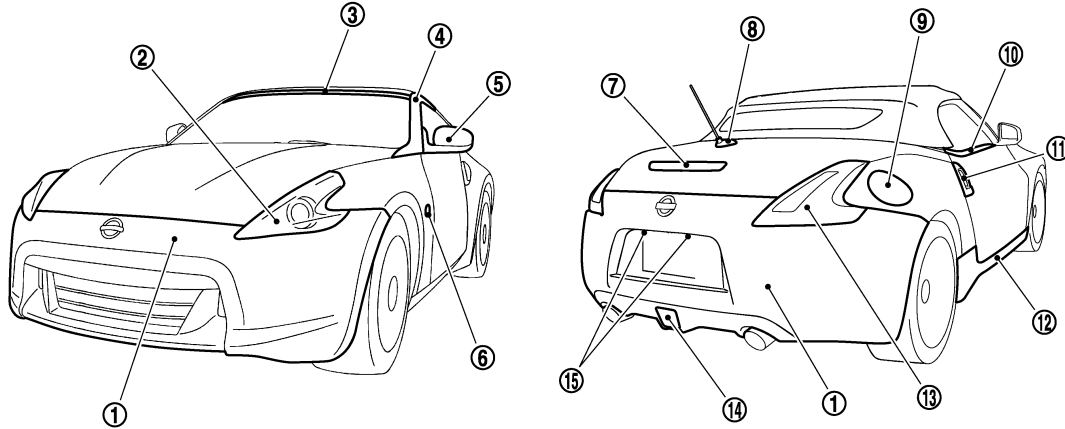
# LOCATION OF PLASTIC PARTS

< SERVICE DATA AND SPECIFICATIONS (SDS)

[ROADSTER]

## Location of Plastic Parts

INFOID:000000006353845



JSKIA1582ZZ

Component		Material	Component		Material		
1	Bumper fascia	PP + EPM	8	Antenna base cover	ASA + PC		
2	Front combination lamp	Lens	PC	9	Fuel filler lid	PA + PPE	
		Housing	PP	10	Door outside molding	PVC + Stainless	
3	Upper windshield molding	PVC	11	Door outside handle	PC + ABS		
4	Front pillar finisher	PC + PET	12	Center mudguard	PP + EPM		
5	Door outside mirror	Cover	ABS	13	Rear combination lamp	Lens	PMMA
		Housing	ASA			Housing	PP
		Base	PA + Glass fiber	14	Rear fog lamp	Lens	PMMA
6	Side turn signal lamp	Lens	PMMA			Housing	ABS
7		High mount stop lamp	Housing	ABS	15	License plate lamp	Lens
	Lens		PMMA	Housing			PC
		ASA					

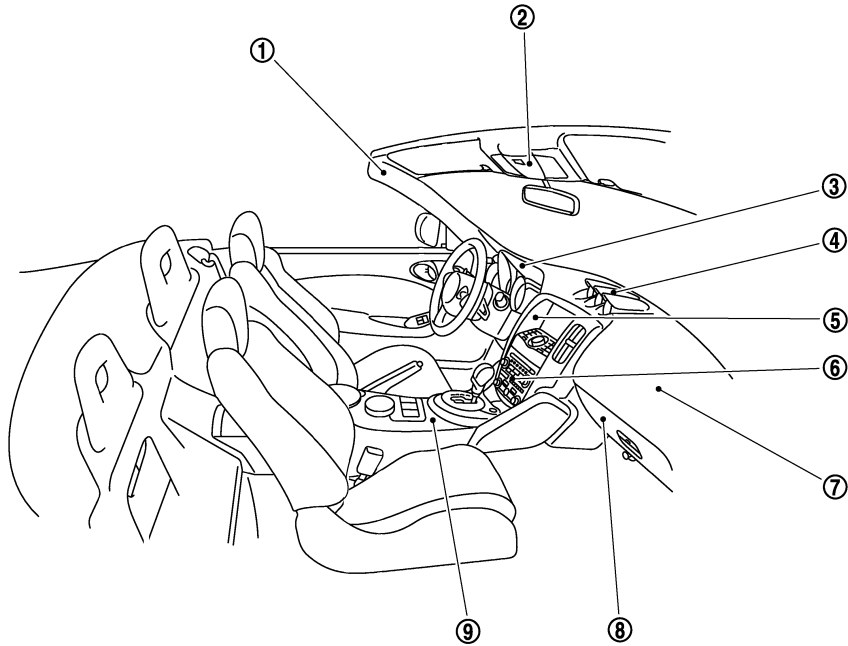
A  
B  
C  
D  
E  
F  
G  
H  
I  
J  
K  
L  
M  
N  
O  
P

BRM

# LOCATION OF PLASTIC PARTS

< SERVICE DATA AND SPECIFICATIONS (SDS)

[ROADSTER]



JSKIA1583ZZ

Component		Material	Component		Material
1	Front pillar garnish	PP	6	Cluster lid C finisher	PC + ABS
2	Map lamp	Lens	7	Instrument panel	Skin
		Housing			PP
3	Cluster lid A	PP	8	Glove box	PP
4	Triple meter panel	PP	9	Center console	PP
5	Cluster lid C	PC + ABS			