

SECTION **BRM**  
BODY REPAIR

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# BODY EXTERIOR PAINT COLOR

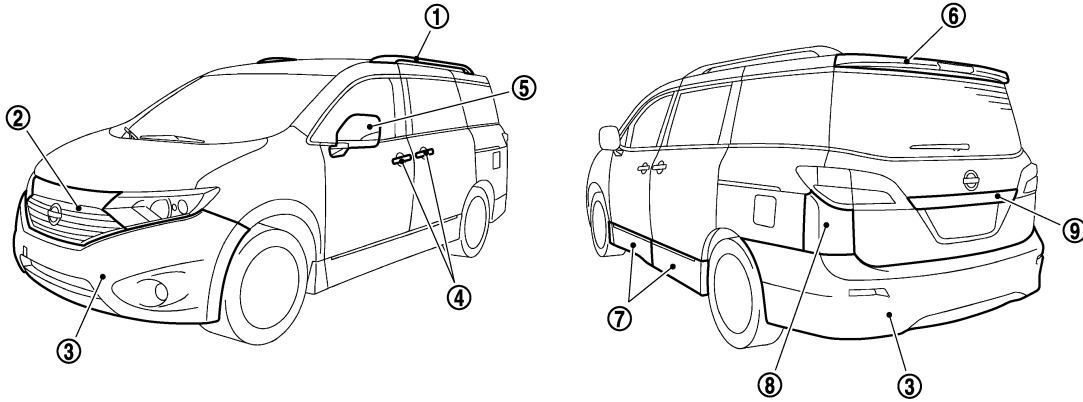
< VEHICLE INFORMATION >

## VEHICLE INFORMATION

### BODY EXTERIOR PAINT COLOR

#### Body Exterior Paint Color

INFOID:000000009648859



JSKIA2473ZZ

Component		Color code	BGAE	BK23	BKAD	BKAC	BQAB	BKH3
		Description	Black	Silver	Gray	Brownish Gray	White	Black
		Paint type <sup>Note</sup>	P	M	M	TM	3P	2S
		Hard clear coat	×	×	×	×	×	×
1	Roof rack	Silver	G08	G08	G08	G08	G08	G08
2	Front grille	Grille	Black	G03	G03	G03	G03	G03
		Molding	Chromium plate	Cr	Cr	Cr	Cr	Cr
3	Bumper fascia	Body color	BGAE	BK23	BKAD	BKAC	BQAB	BKH3
4	Door outside handle	Chromium plate	Cr	Cr	Cr	Cr	Cr	Cr
5	Door outside mirror cover	Body color	BGAE	BK23	BKAD	BKAC	BQAB	BKH3
6	Rear spoiler	Body color	BGAE	BK23	BKAD	BKAC	BQAB	BKH3
7	Protect molding	Body color	BGAE	BK23	BKAD	BKAC	BQAB	BKH3
8	Sight shield assembly	Body color	BGAE	BK23	BKAD	BKAC	BQAB	BKH3
9	Back door finisher	Chromium plate	Cr	Cr	Cr	Cr	Cr	Cr

**NOTE:**

- M: Metallic
- P: 2-Coat pearl
- 2S: Solid + Clear
- 3P: 3-Coat pearl
- TM: Micro titanium metallic

# REPAIRING HIGH STRENGTH STEEL

< PRECAUTION >

## PRECAUTION

### REPAIRING HIGH STRENGTH STEEL

#### High Strength Steel (HSS)

INFOID:000000009648860

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
440 - 780 MPa	<ul style="list-style-type: none"> <li>• Rear floor rear side</li> <li>• Rear floor extension front</li> <li>• Inner front side member stiffener (Front floor component part)</li> <li>• Lower dash crossmember (Lower dash component part)</li> <li>• Front side member closing plate assembly</li> <li>• Front side member assembly</li> <li>• Front side member extension front</li> <li>• Front side member extension center</li> <li>• Rear floor front stiffener</li> <li>• Front side member extension rear</li> <li>• Rear sill assembly</li> <li>• 3rd crossmember</li> <li>• 4th crossmember</li> <li>• 5th crossmember</li> <li>• 6th crossmember</li> <li>• 7th crossmember</li> <li>• Rear side member</li> <li>• Rear side member extension</li> <li>• Rear tie down hook</li> <li>• Front bumper stay</li> <li>• Inner side roof rail</li> <li>• Upper inner front pillar</li> <li>• Inner center pillar</li> <li>• Center pillar reinforcement</li> <li>• Upper front pillar reinforcement</li> <li>• Front pillar brace</li> <li>• Outer sill reinforcement</li> <li>• Inner rear pillar</li> <li>• Front roof rail</li> <li>• Roof bow No. 2</li> </ul>
980 - 1310 MPa	<ul style="list-style-type: none"> <li>• Front side member stiffener (Front floor component part)</li> <li>• Front side member reinforcement extension front (Front floor component part)</li> <li>• Inner sill</li> <li>• Front side member reinforcement (LH only) (Front side member assembly component part)</li> <li>• Center pillar seat belt reinforcement (Center pillar reinforcement component part)</li> </ul>

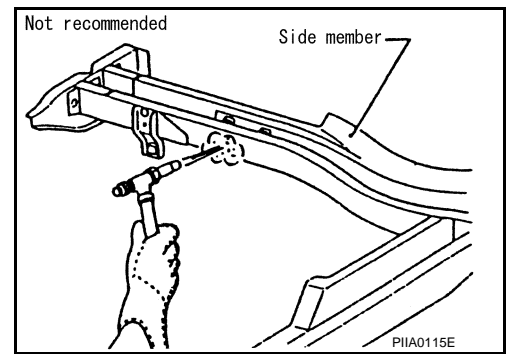
Read the following precautions when repairing HSS:

1. Additional points to consider

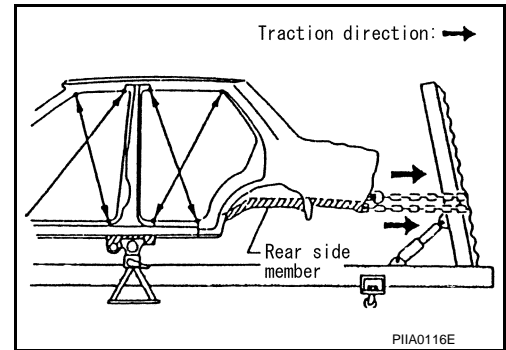
# REPAIRING HIGH STRENGTH STEEL

## < PRECAUTION >

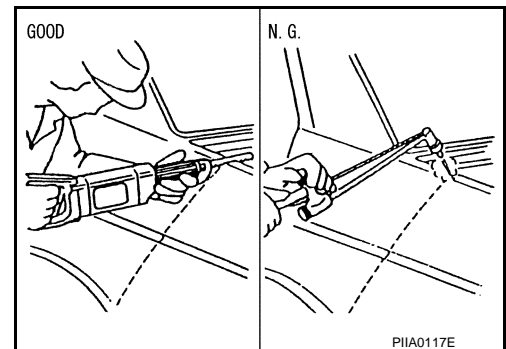
- The repair of reinforcements (such as side members) by heating is not recommended, because it may weaken the component. When heating is unavoidable, never heat HSS parts above 550°C (1,022°F). Verify heating temperature with a thermometer. (Crayon-type and other similar type thermometer are appropriate.)



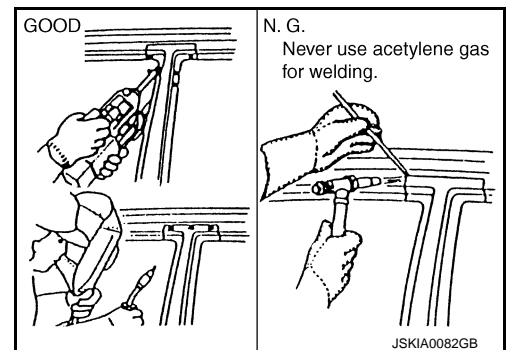
- When straightening body panels, use caution in pulling any HSS panel. Because HSS is very strong, pulling may cause deformation in adjacent sections of the body. In this case, increase the number of measuring points, and carefully pull the HSS panel.



- 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 (1.97in).



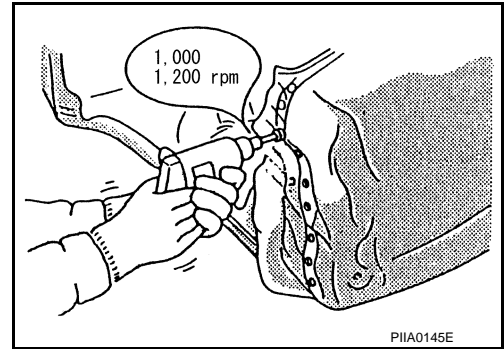
- When welding HSS panels, use spot welding whenever possible in order to minimize weakening surrounding areas due to heat. If spot welding is impossible, use MIG. welding. Do not use gas (torch) for welding because it is inferior in welding strength.



# REPAIRING HIGH STRENGTH STEEL

## < PRECAUTION >

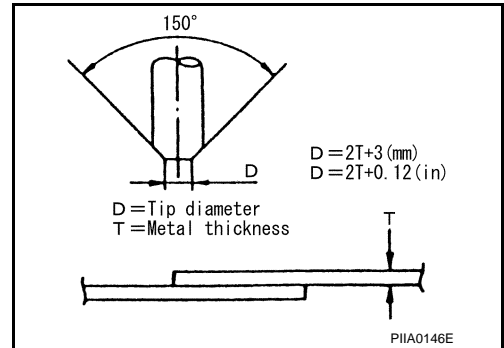
- Spot welding on HSS panels is harder than that of an ordinary steel panel. Therefore, when cutting spot welds on a HSS panel, use a low speed high torque drill (1,000 to 1,200 rpm) to increase drill bit durability and facilitate the operation.



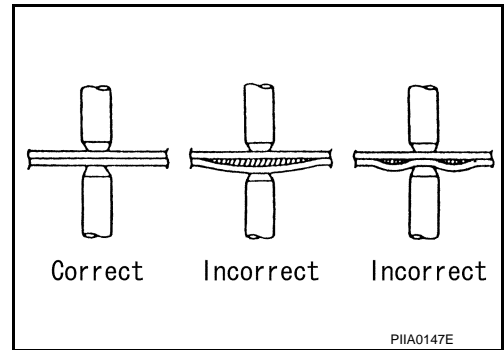
## 2. Precautions in spot welding HSS

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.



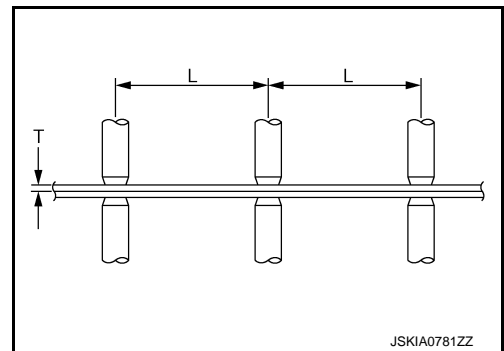
- The panel surfaces must fit flush to each other, leaving no gaps.



- 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:000000009648861

### 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.

# REPAIRING MATERIAL

< PREPARATION >

## PREPARATION

### REPAIRING MATERIAL

#### Foam Repair

INFOID:000000009648862

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.

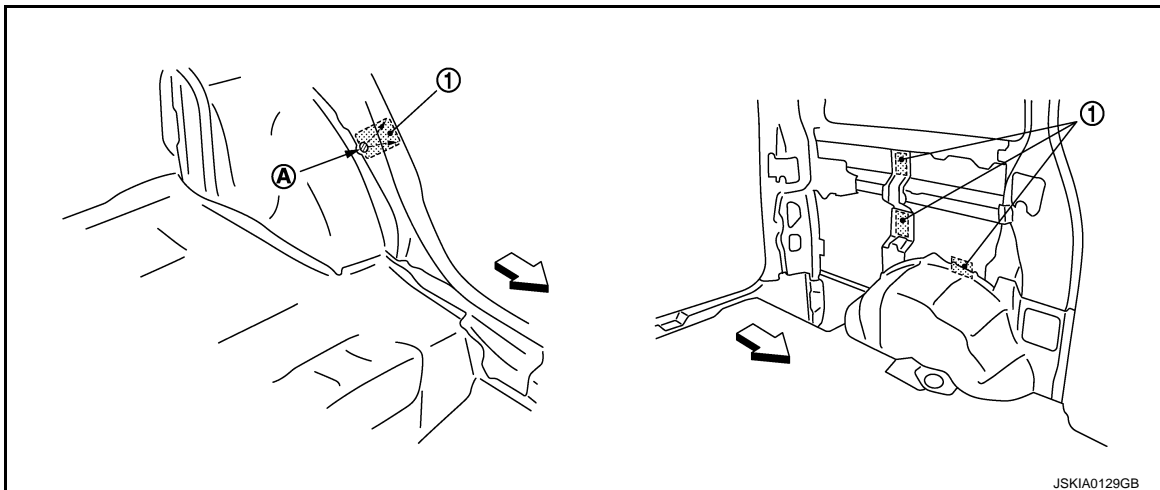
<Urethane foam for foaming agent>

**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 >

- 1. Urethane foam
- A. Fill while avoiding flange area

←: Vehicle front

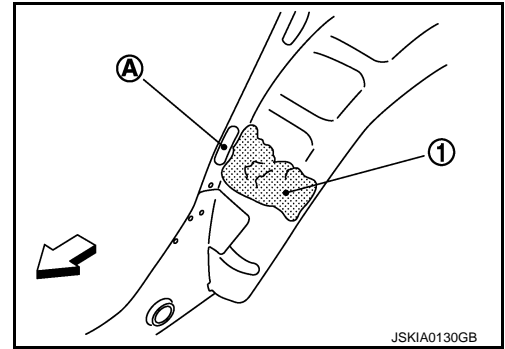
**NOTE:**

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.



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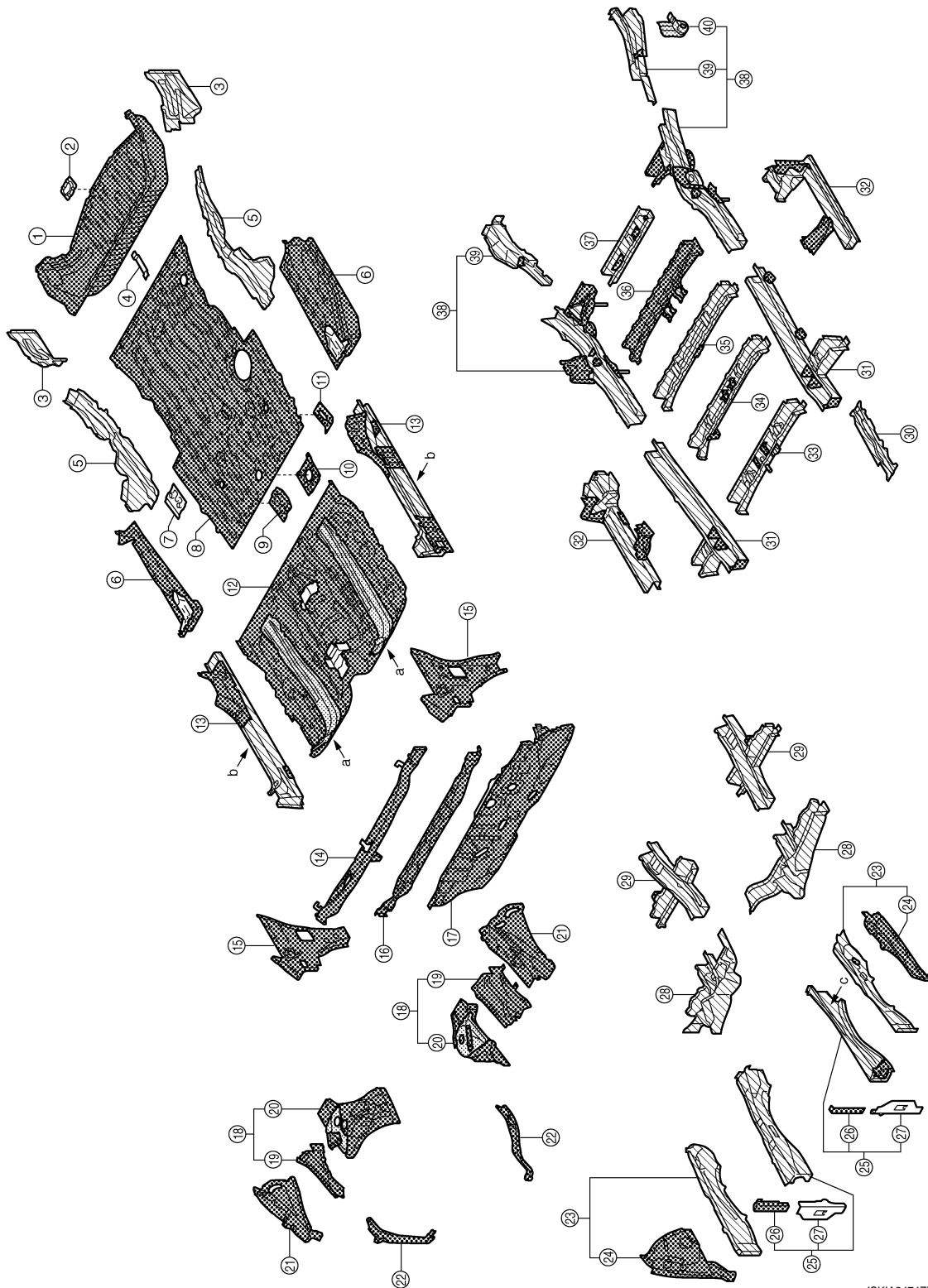
# BODY COMPONENT PARTS

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
## BODY COMPONENT PARTS

### Underbody Component Parts

INFOID:00000009648863



JSKIA2474ZZ

-  Both sided anti-corrosive pre-coated steel sections
-  High strength steel (HSS) sections
-  Both sided anti-corrosive steel and HSS sections



# BODY COMPONENT PARTS

< PREPARATION >

No.	Parts name		Tensile strength (MPa)	Both sided anti-corrosive pre-coated steel sections
1.	Rear floor rear		Under 440	×
2.	Jack mounting bracket		Under 440	—
3.	Rear floor rear side (RH & LH)		590	×
4.	Woofer bracket assembly		Under 440	—
5.	Rear floor extension front (RH & LH)		590	×
6.	Inner sill step extension assembly (RH & LH)		Under 440	×
7.	Rear floor side reinforcement		Under 440	—
8.	Rear floor front		Under 440	×
9.	Spare tire mounting bracket (Right)		Under 440	×
10.	Spare tire mounting bracket (Center)		Under 440	×
11.	Parking brake reinforcement		Under 440	×
12.	Front floor	a. T=2.0mm (0.079 in) 1350 MPa <sup>caution</sup>	780	×
13.	Inner sill (RH & LH)	b. T=1.4mm (0.055 in) 980 MPa <sup>caution</sup>	590	×
14.	Center cowl top		Under 440	×
15.	Side dash (RH & LH)		Under 440	×
16.	Upper dash		Under 440	×
17.	Lower dash		590	×
18.	Hoodledge assembly (RH & LH)		Refer to No.19–20	
19.	Upper hoodledge (RH & LH)		Under 440	×
20.	Lower rear hoodledge (RH & LH)		440	×
21.	Hoodledge reinforcement (RH & LH)		Under 440	×
22.	Upper radiator core support (RH & LH)		Under 440	×
23.	Front side member closing plate assembly (RH & LH)		780	×
24.	Lower front hoodledge (RH & LH)		Under 440	×
25.	Front side member assembly (RH & LH)	c. T=2.0mm (0.079 in) 980 MPa <sup>caution</sup>	780	×
26.	Side radiator core support (RH & LH)		Under 440	×
27.	Front side member connector assembly (RH & LH)		Under 440	—
28.	Front side member extension front (RH & LH)		780	×
29.	Front side member extension center (RH & LH)		780	×
30.	Rear floor front stiffener		780	×
31.	Front side member extension rear (RH & LH)		780	×
32.	Rear sill assembly (RH & LH)		590	×
33.	3rd crossmember		590	×
34.	4th crossmember		440	×
35.	5th crossmember		590	×
36.	6th crossmember		590	×
37.	7th crossmember		590	×

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## BODY COMPONENT PARTS

### < PREPARATION >

No.	Parts name	Tensile strength (MPa)	Both sided anti-corrosive precoated steel sections
38.	Rear side member (RH & LH)	590	×
39.	Rear side member extension (RH & LH)	590	×
40.	Rear tie down hook	440	—

**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.
- In the above table, Tensile strength (MPa) column shows the highest tensile strength of the part excluding the area using ultra high strength steel.

**CAUTION:**

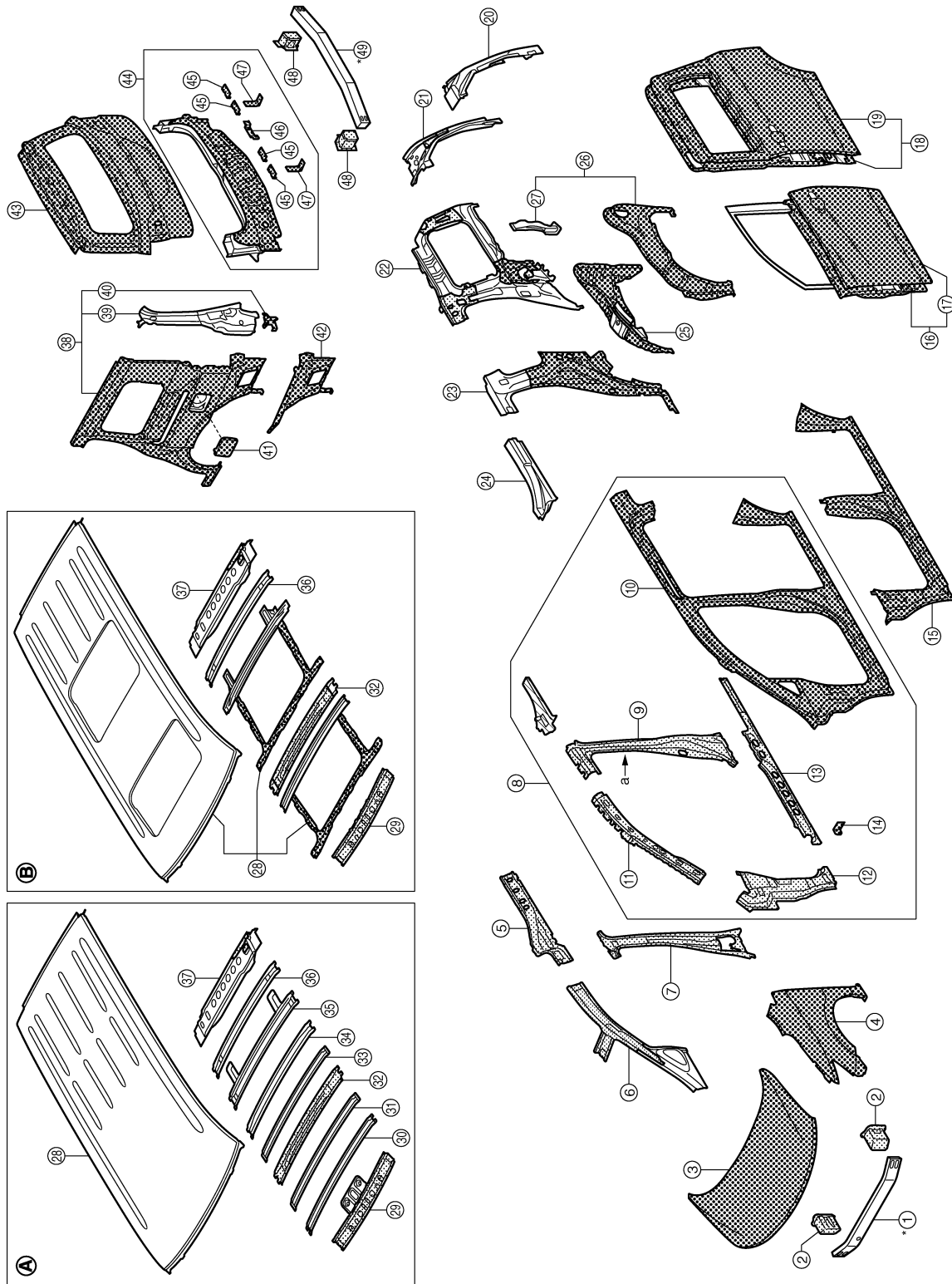
**If the high strength steel (ultra high strength steel) of this is broken, replace by assembly for the supply part.**

# BODY COMPONENT PARTS

< PREPARATION >

## Body Component Parts

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## BODY COMPONENT PARTS

< PREPARATION >

No.	Parts name	Tensile strength (MPa)	Both sided anti-corrosive pre-coated steel sections	Aluminum portion
1.	Front bumper armature assembly	—	—	×
2.	Front bumper stay (RH & LH)	440	—	—
3.	Hood	Under 440	×	—
4.	Front fender (RH & LH)	Under 440	×	—
5.	Inner side roof rail (RH & LH)	590	—	—
6.	Upper inner front pillar (RH & LH)	590	—	—
7.	Inner center pillar (RH & LH)	590	—	—
8.	Side body assembly (RH & LH)	Refer to No.9-14		
9.	Center pillar reinforcement (RH & LH)	a. T=1.8mm (0.071 in) 980 MPa <sup>caution</sup>	590	—
10.	Outer front side body (RH & LH)	440	×	—
11.	Upper front pillar reinforcement (RH & LH)	590	—	—
12.	Front pillar brace (RH & LH)	590	—	—
13.	Outer sill reinforcement (RH & LH)	590	×	—
14.	Front fender bracket assembly (RH & LH)	Under 440	×	—
15.	Outer sill (RH & LH)	Under 440	×	—
16.	Front door assembly (RH & LH)	Under 440	×	—
17.	Outer front door panel (RH & LH)	Under 440	×	—
18.	Slide door assembly (RH & LH)	590	×	—
19.	Outer slide door panel (RH & LH)	Under 440	×	—
20.	Back pillar reinforcement assembly (RH & LH)	440	—	—
21.	Inner back pillar (RH & LH)	440	—	—
22.	Inner rear pillar (RH & LH)	440	—	—
23.	Inner rear pillar reinforcement (RH & LH)	Under 440	×	—
24.	Outer side roof rail (RH & LH)	Under 440	—	—
25.	Inner rear wheelhouse (RH & LH)	440	×	—
26.	Outer rear wheelhouse (RH & LH)	Under 440	×	—
27.	Outer rear wheelhouse extension (RH & LH)	Under 440	—	—
28.	Roof	Under 440	—	—
29.	Front roof rail	590	—	—
30.	Front roof rail rear	Under 440	—	—
31.	Roof bow No. 1	Under 440	—	—
32.	Roof bow No. 2	590	—	—
33.	Roof bow No. 3	Under 440	—	—
34.	Roof bow No. 4	Under 440	—	—
35.	Roof bow No. 5	Under 440	—	—
36.	Rear roof bow	Under 440	—	—
37.	Rear roof rail	440	—	—
38.	Rear fender (RH & LH)	Under 440	×	—
39.	Outer back pillar (RH & LH)	Under 440	—	—
40.	Rear fender extension (RH & LH Bracket)	Under 440	×	—

## BODY COMPONENT PARTS

### < PREPARATION >

No.	Parts name	Tensile strength (MPa)	Both sided anti-corrosive pre-coated steel sections	Aluminum portion
41.	Fuel filler lid	Under 440	×	—
42.	Rear fender extension (RH & LH)	Under 440	×	—
43.	Back door	Under 440	×	—
44.	Upper rear panel	Under 440	×	—
45.	Upper rear bumper retainer	Under 440	×	—
46.	Upper rear bumper retainer (center)	Under 440	×	—
47.	Rear bumper fascia bracket	Under 440	×	—
48.	Rear bumper stay (RH & LH)	440	—	—
49.	Inner center rear bumper reinforcement	—	—	×

**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.
- In the above table, Tensile strength (MPa) column shows the highest tensile strength of the part excluding the area using ultra high strength steel.

**CAUTION:**

**If the high strength steel (ultra high strength steel) of this is broken, replace by assembly for the supply part.**

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# CORROSION PROTECTION

< REMOVAL AND INSTALLATION >

## REMOVAL AND INSTALLATION

### CORROSION PROTECTION

#### Description

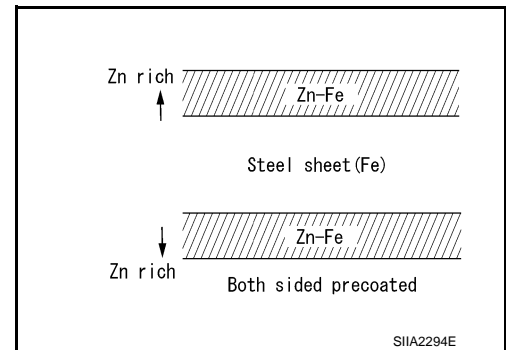
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To provide improved corrosion prevention, the following anti-corrosive measures have been implemented in NISSAN production plants. When repairing or replacing body panels, it is necessary to use the same anti-corrosive measures.

#### ANTI-CORROSIVE PRECOATED STEEL (GALVANNEALED STEEL)

To improve repairability and corrosion resistance, a new type of anti-corrosive precoated steel sheet has been 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.



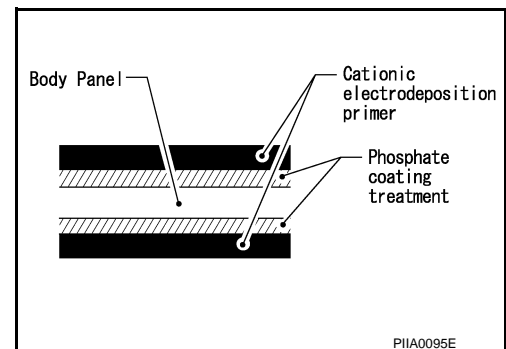
Nissan Genuine Service Parts are fabricated from galvannealed steel. Therefore, it is recommended that GENUINE NISSAN PARTS or equivalent be used for panel replacement to maintain the anti-corrosive performance built into the vehicle at the factory.

#### PHOSPHATE COATING TREATMENT AND CATIONIC ELECTRODEPOSITION PRIMER

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

#### **CAUTION:**

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



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

#### Anti-corrosive Wax

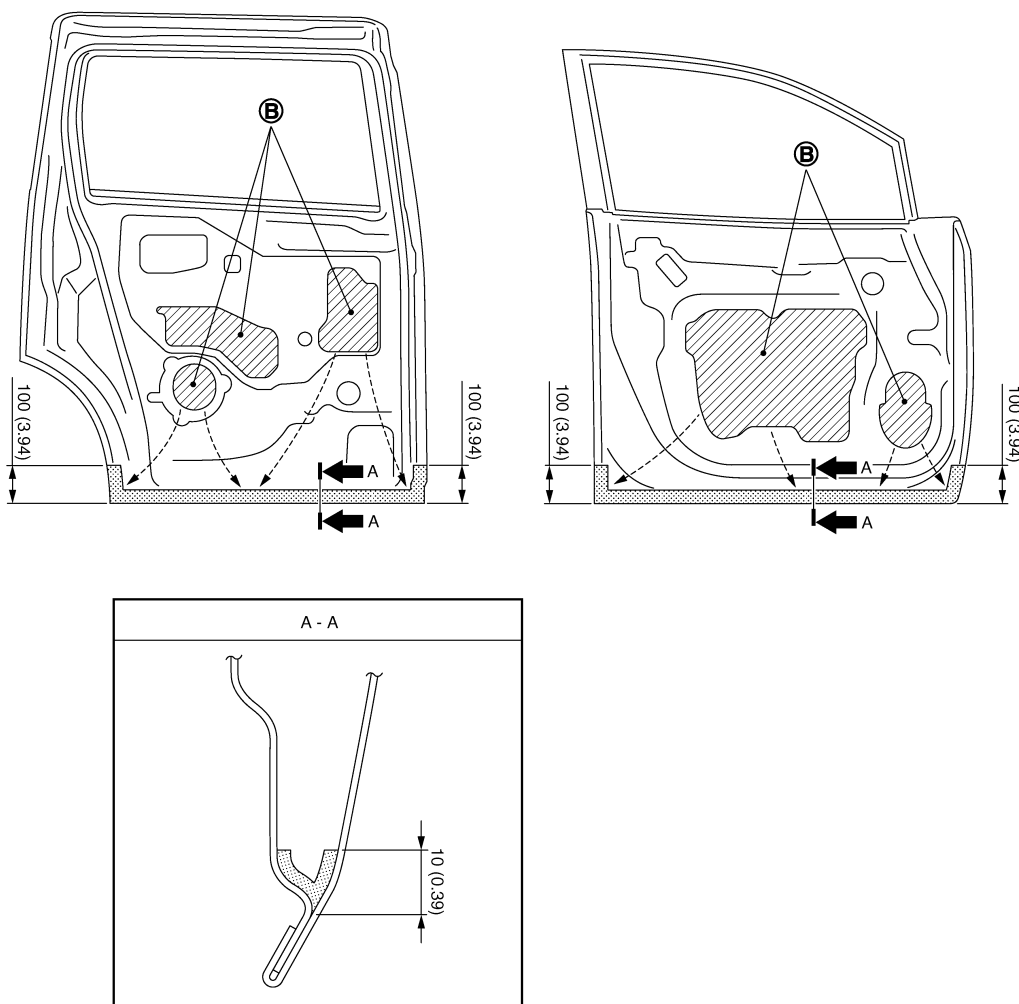
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To improve corrosion resistance, anti-corrosive wax is applied inside the body sill and inside other closed sections. Accordingly, when replacing these parts, be sure to apply anti-corrosive wax to the appropriate areas of the new parts. Select an excellent anti-corrosive wax which will penetrate after application and has a long shelf life.

#### DOOR


# CORROSION PROTECTION

## < REMOVAL AND INSTALLATION >



B. Nozzle insert hole

Unit: mm (in)

: Anti-corrosive wax coated portions

## Undercoating

INFOID:000000009648867

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.

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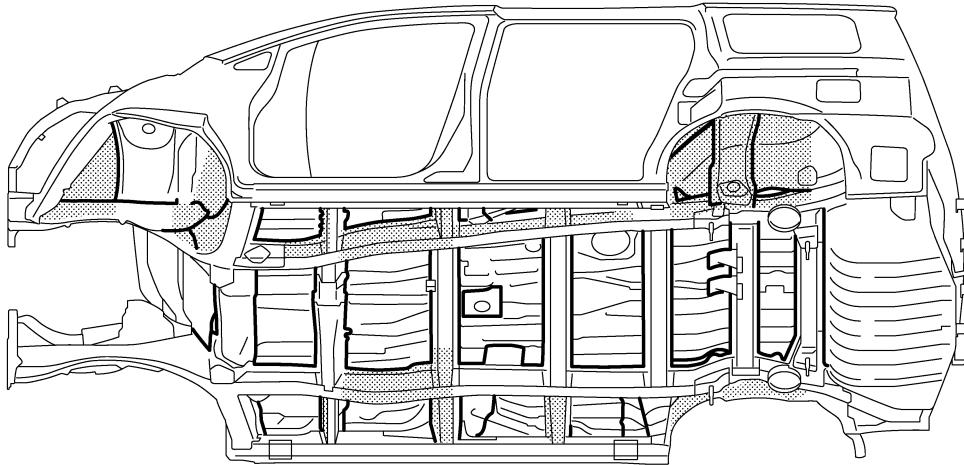
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# CORROSION PROTECTION

< REMOVAL AND INSTALLATION >

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JSKIA247ZZ

 Undercoated areas

 Sealed portions

## Stone Guard Coat

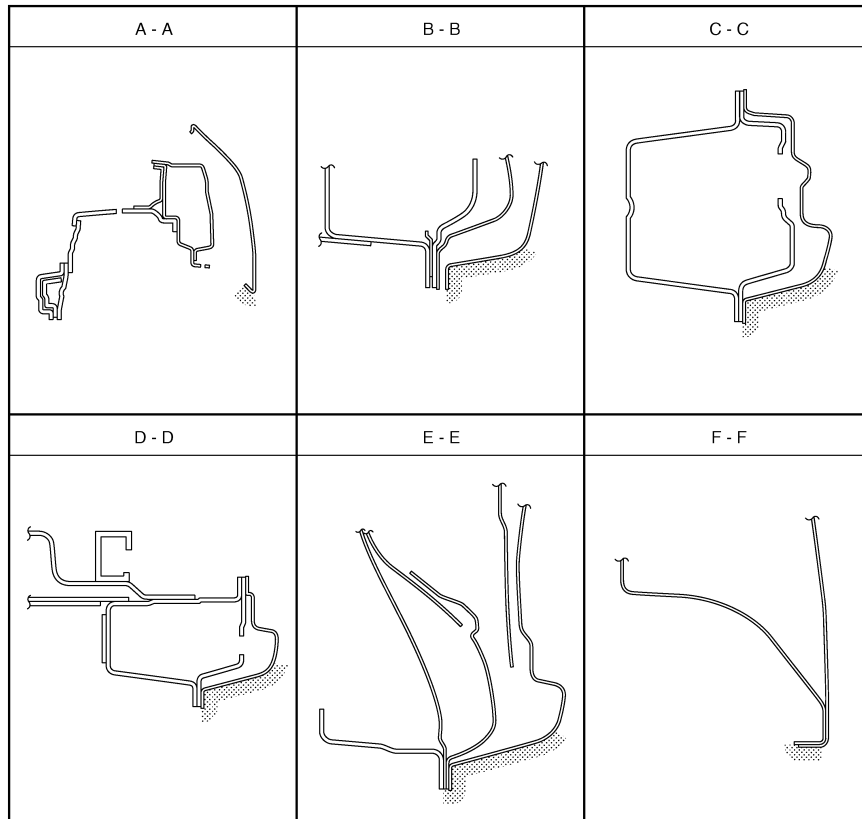
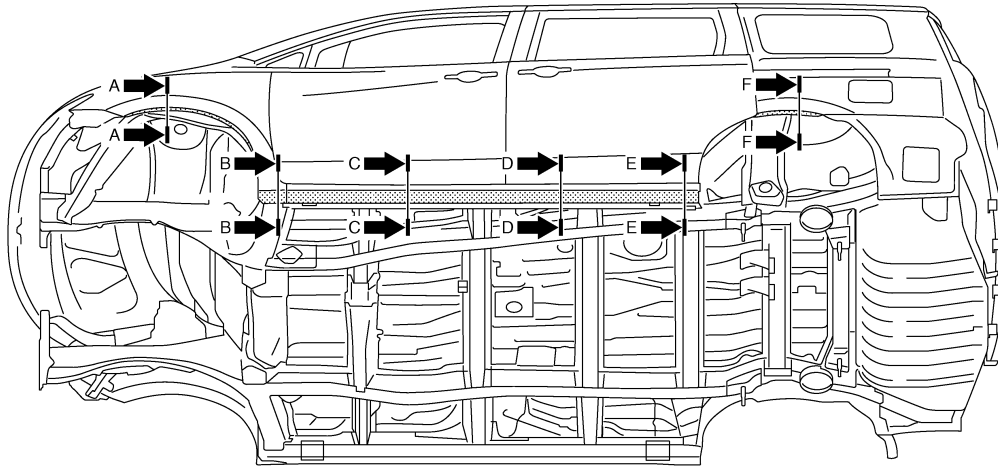
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To prevent damage caused by stones, the lower outer body panel (fender, door, etc.) have an additional layer of Stone Guard Coating over the ED primer coating. When replacing or repairing these panels, apply Stone Guard coating to the same portions as before. Use a coating which is rust preventive, durable, shock-resistant and has a long shelf life.




# CORROSION PROTECTION

## < REMOVAL AND INSTALLATION >



JSKIA2478ZZ

 Stone guard coated portions

### Body Sealing

INFOID:000000009648869

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.

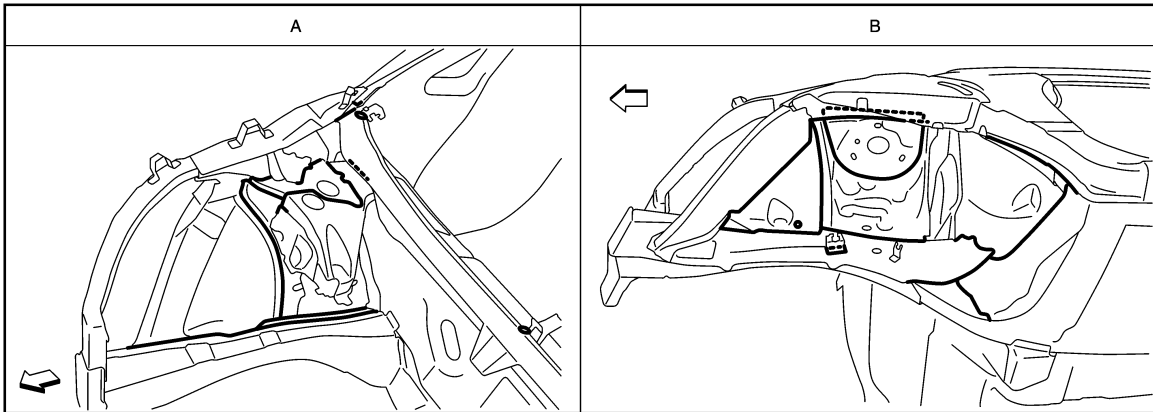
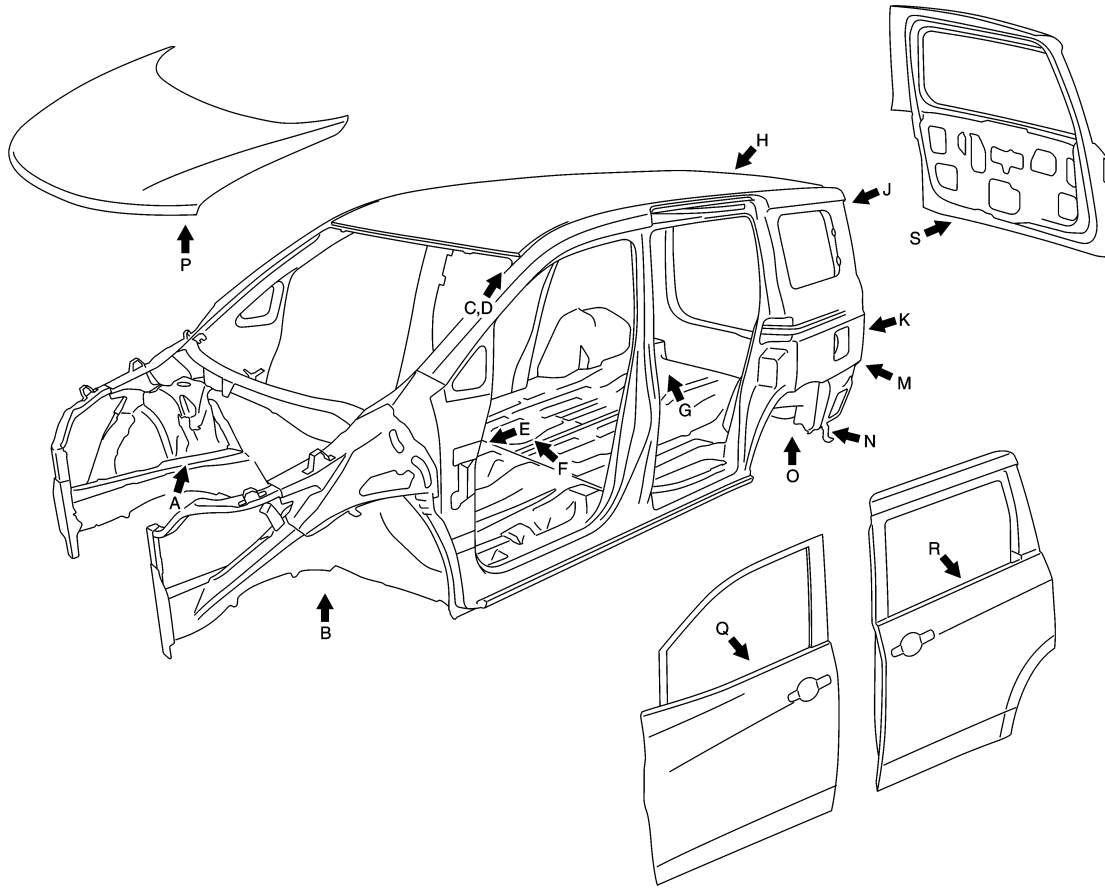
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# CORROSION PROTECTION

## < REMOVAL AND INSTALLATION >



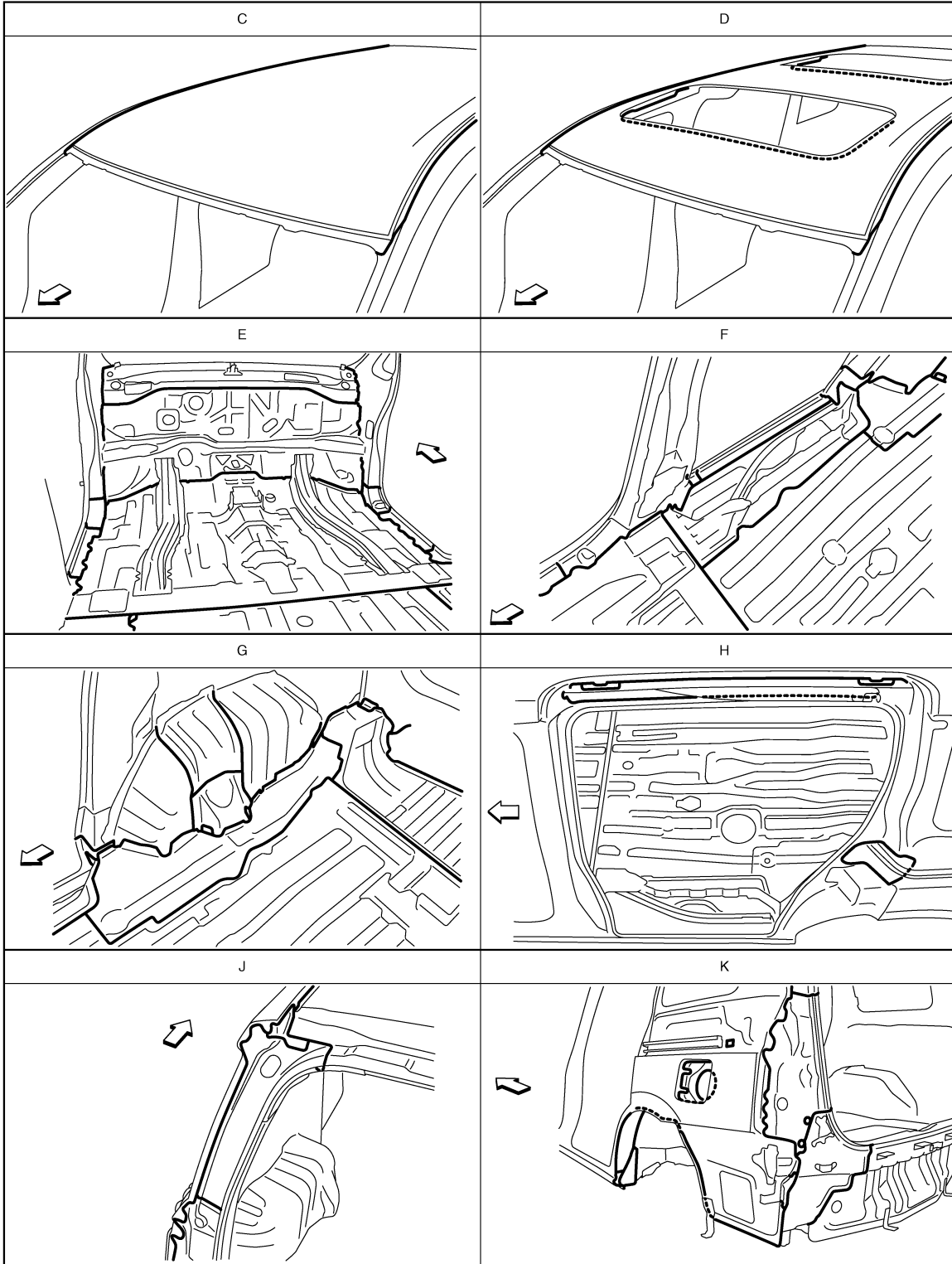
JSKIA2618ZZ

←: Vehicle front

█: Sealed portions

# CORROSION PROTECTION

## < REMOVAL AND INSTALLATION >



JSKIA2480ZZ

↔: Vehicle front

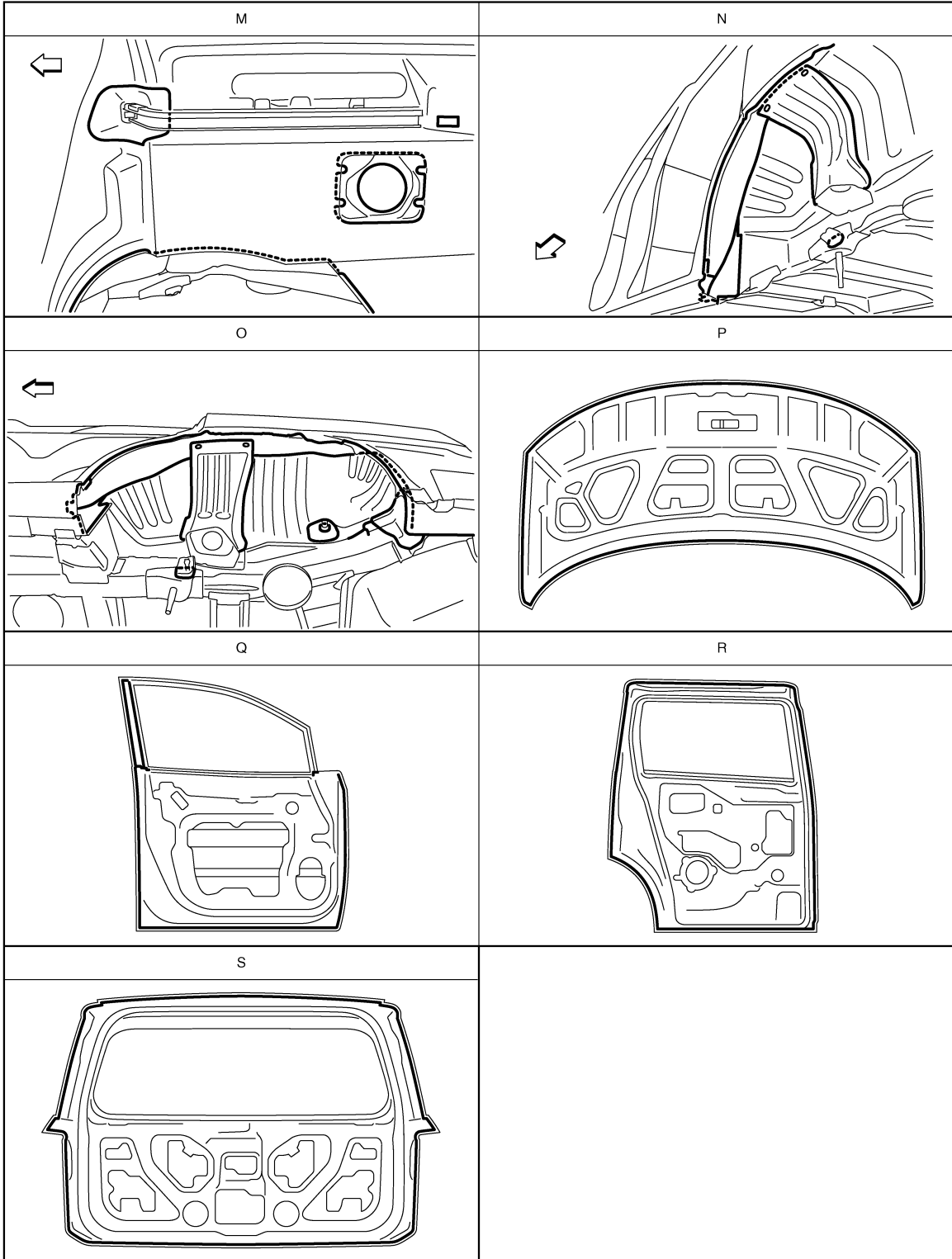
█: Sealed portions

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# CORROSION PROTECTION

## < REMOVAL AND INSTALLATION >



JSKIA2481ZZ

←: Vehicle front

—: Sealed portions

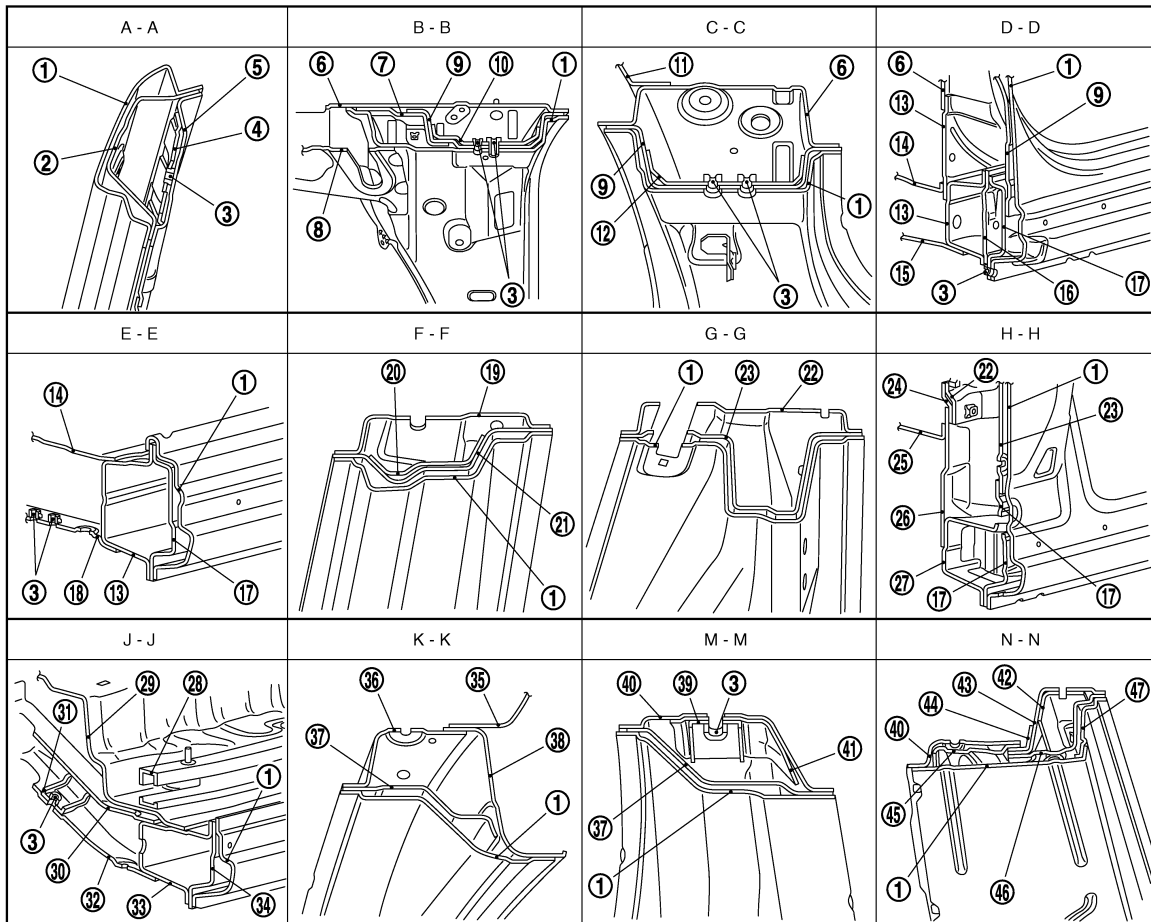
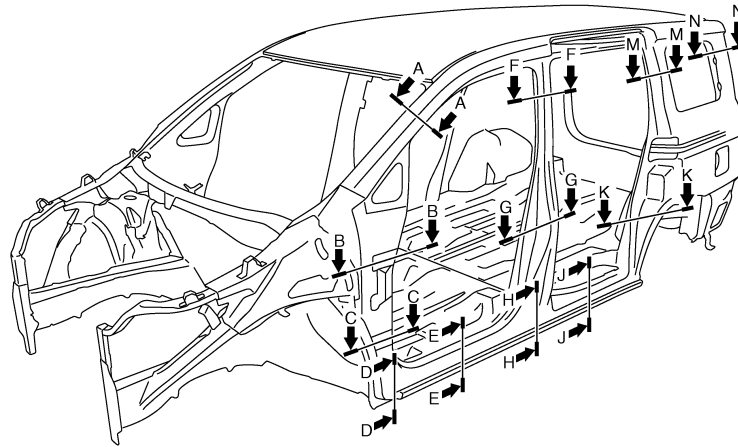
# BODY CONSTRUCTION

< REMOVAL AND INSTALLATION >

## BODY CONSTRUCTION

### Body Construction

INFOID:000000009648870



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- |                                     |                                     |                                   |
|-------------------------------------|-------------------------------------|-----------------------------------|
| 1. Outer side body                  | 2. Upper front pillar reinforcement | 3. Weld nut                       |
| 4. Inner front pillar reinforcement | 5. Upper inner front pillar         | 6. Side dash                      |
| 7. Upper front pillar hinge brace   | 8. Hoodledge reinforcement          | 9. Lower front pillar hinge brace |

JSKIA2482ZZ

# BODY CONSTRUCTION

## < REMOVAL AND INSTALLATION >

- |                                      |   |   |
|--------------------------------------|---|---|
| 10. Upper hinge plate                | 11. Lower dash                            | 12. Lower hinge plate                       |
| 13. Inner sill                       | 14. Front floor                           | 15. Front side member outrigger             |
| 16. Inner sill reinforcement         | 17. Outer sill reinforcement              | 18. 2nd side member outrigger               |
| 19. Upper inner center pillar        | 20. Center pillar seat belt reinforcement | 21. Upper outer center pillar reinforcement |
| 22. Inner center pillar              | 23. Center pillar reinforcement           | 24. Center pillar plate                     |
| 25. Rear step extension front        | 26. Center sill reinforcement             | 27. Inner rear sill front                   |
| 28. Lower guide rail                 | 29. Rear floor step panel                 | 30. Outrigger brace                         |
| 31. Fuel tank mounting reinforcement | 32. 4th side member outrigger             | 33. Inner sill extension                    |
| 34. Outer rear sill reinforcement    | 35. Inner rear wheelhouse                 | 36. Outer rear wheelhouse extension front   |
| 37. Inner rear pillar reinforcement  | 38. Outer rear wheelhouse                 | 39. Nut plate                               |
| 40. Inner rear pillar                | 41. Inner roof side rail reinforcement    | 42. Back pillar seat belt anchor            |
| 43. Rear roof rail brace             | 44. Upper inner back pillar               | 45. Upper rear reinforcement                |
| 46. Back pillar reinforcement        | 47. Back pillar main                      |   |

## Rear Fender Hemming Process

INFOID:000000009648871

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:

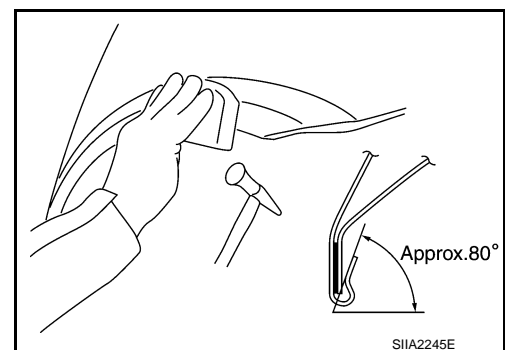
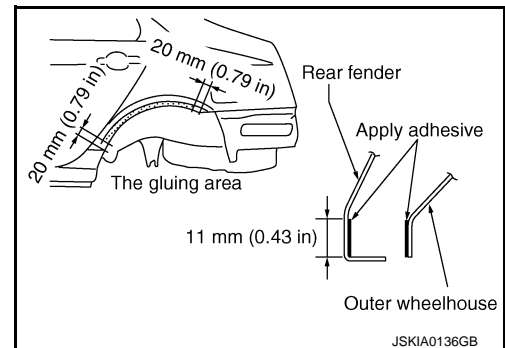
**Ensure that the area that is to be glued around the outer wheelhouse is undamaged or defaced.**

### 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**

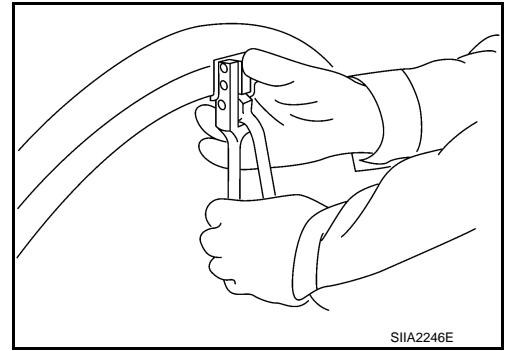
- Attach rear fender to the body of the car, and weld the required part except the hemming part.
- Bend the welded part starting from the center of the wheel arch gradually with a hammer and a dolly. (Also hem the end of the flange.)
- Hemming with a hammer is conducted to an approximate angle of 80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



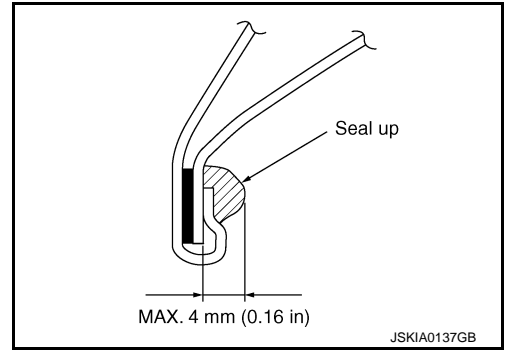
# BODY CONSTRUCTION

## < REMOVAL AND INSTALLATION >

- 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.



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# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

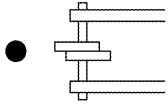
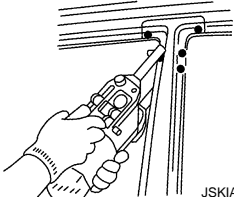
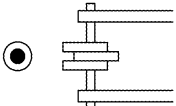
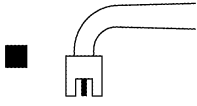



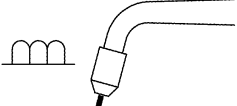
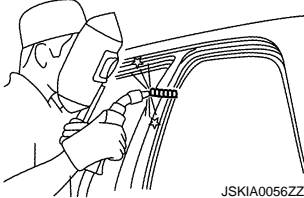
## REPLACEMENT OPERATIONS

### Description

INFOID:000000009648872

- 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.

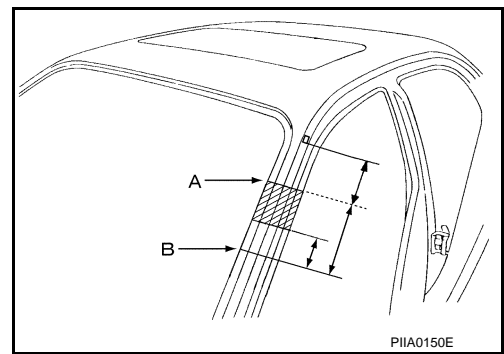
Symbol marks	Description	
 <p data-bbox="402 844 490 861">JSKIA0049ZZ</p>	2-spot welds	 <p data-bbox="1291 970 1377 987">JSKIA0053ZZ</p>
 <p data-bbox="402 1096 490 1113">JSKIA0050ZZ</p>	3-spot welds	
 <p data-bbox="402 1474 490 1491">JSKIA0051ZZ</p>	MIG plug weld	 <p data-bbox="1291 1348 1377 1365">JSKIA0054ZZ</p> <p data-bbox="1006 1381 1318 1407">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>



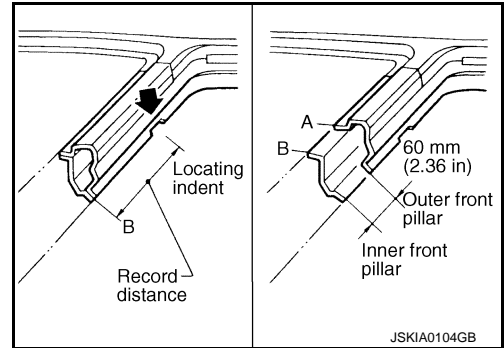
# REPLACEMENT OPERATIONS

## < REMOVAL AND INSTALLATION >

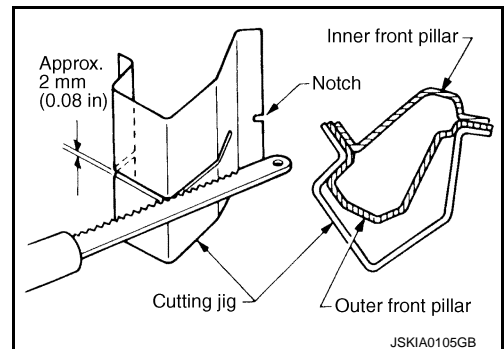
- Front pillar butt joint can be determined anywhere within shaded area as shown in the figure. The best location for the butt joint is at position A due to the construction of the vehicle.



- 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.

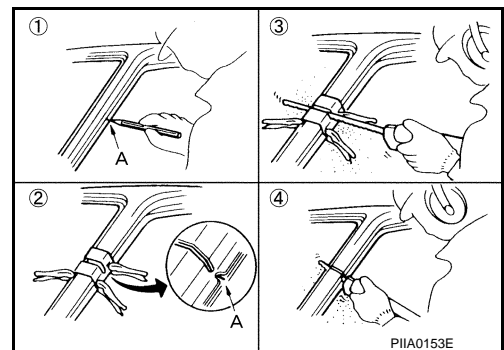


- Prepare a cutting jig to make outer pillar easier to cut. Also, this will permit the service part to be accurately cut at the joint position.



- 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.



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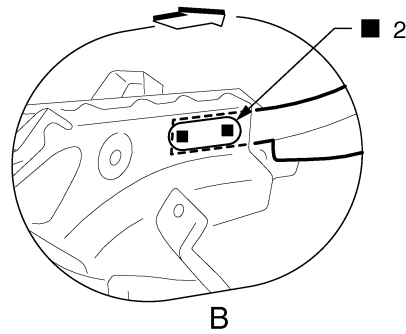
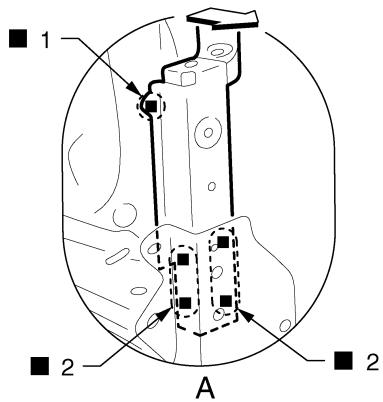
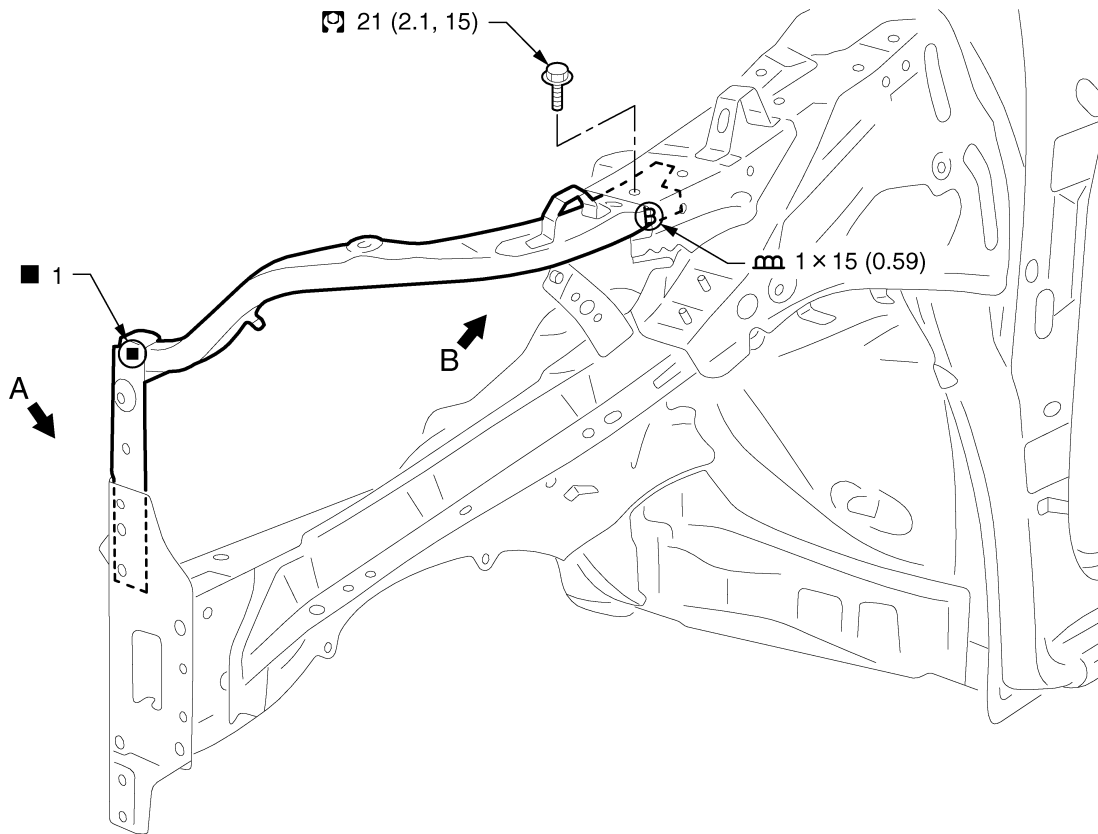
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# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

## Radiator Core Support

INFOID:00000009648873



JSKIA2452GB

Unit: mm (in)

◀: Vehicle front

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

Ⓜ: N-m (kg-m, ft-lb)

Replacement parts

- Upper radiator core support
- Side radiator core support

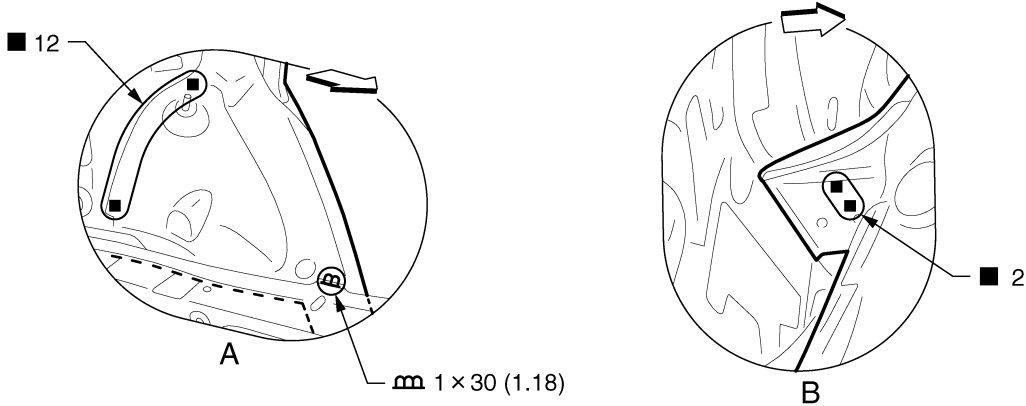
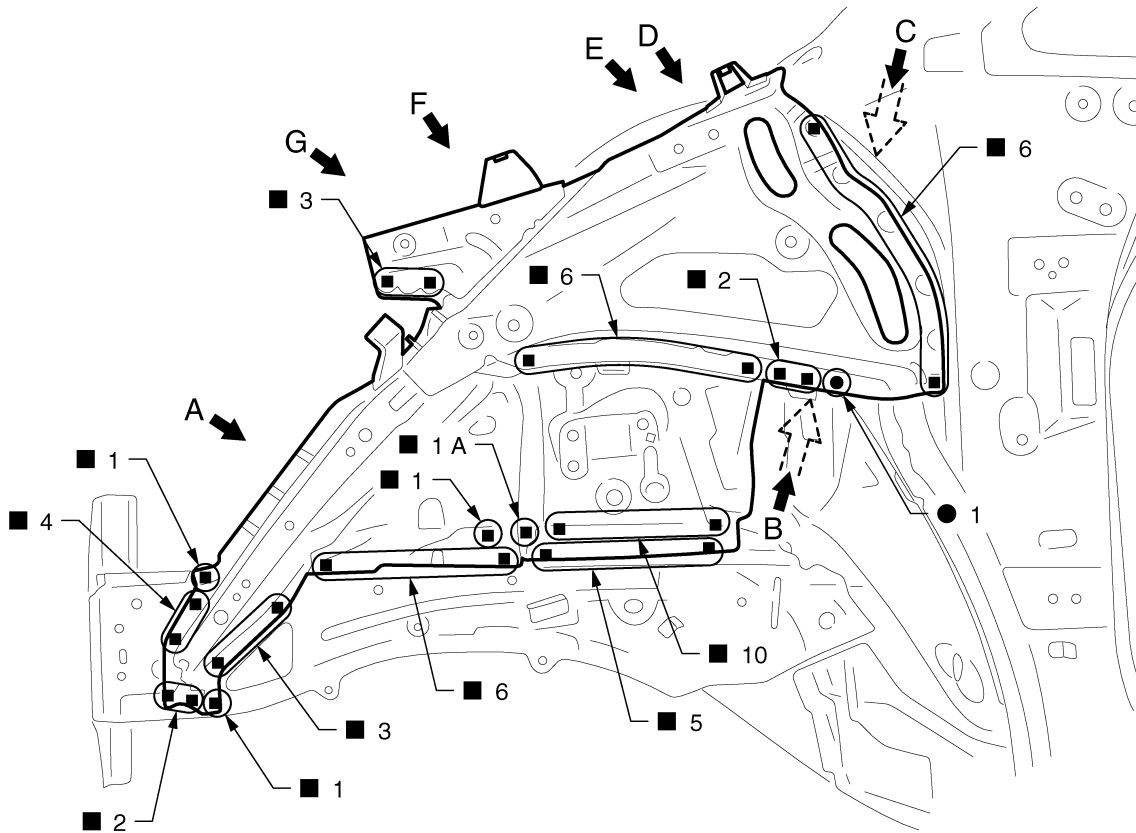
# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

## Hoodledge

INFOID:000000009648874

Work after radiator core support is removed.



JSKIA2453GB

Unit: mm (in)

⇐: Vehicle front

Replacement parts

● Hoodledge assembly

● Hoodledge reinforcement

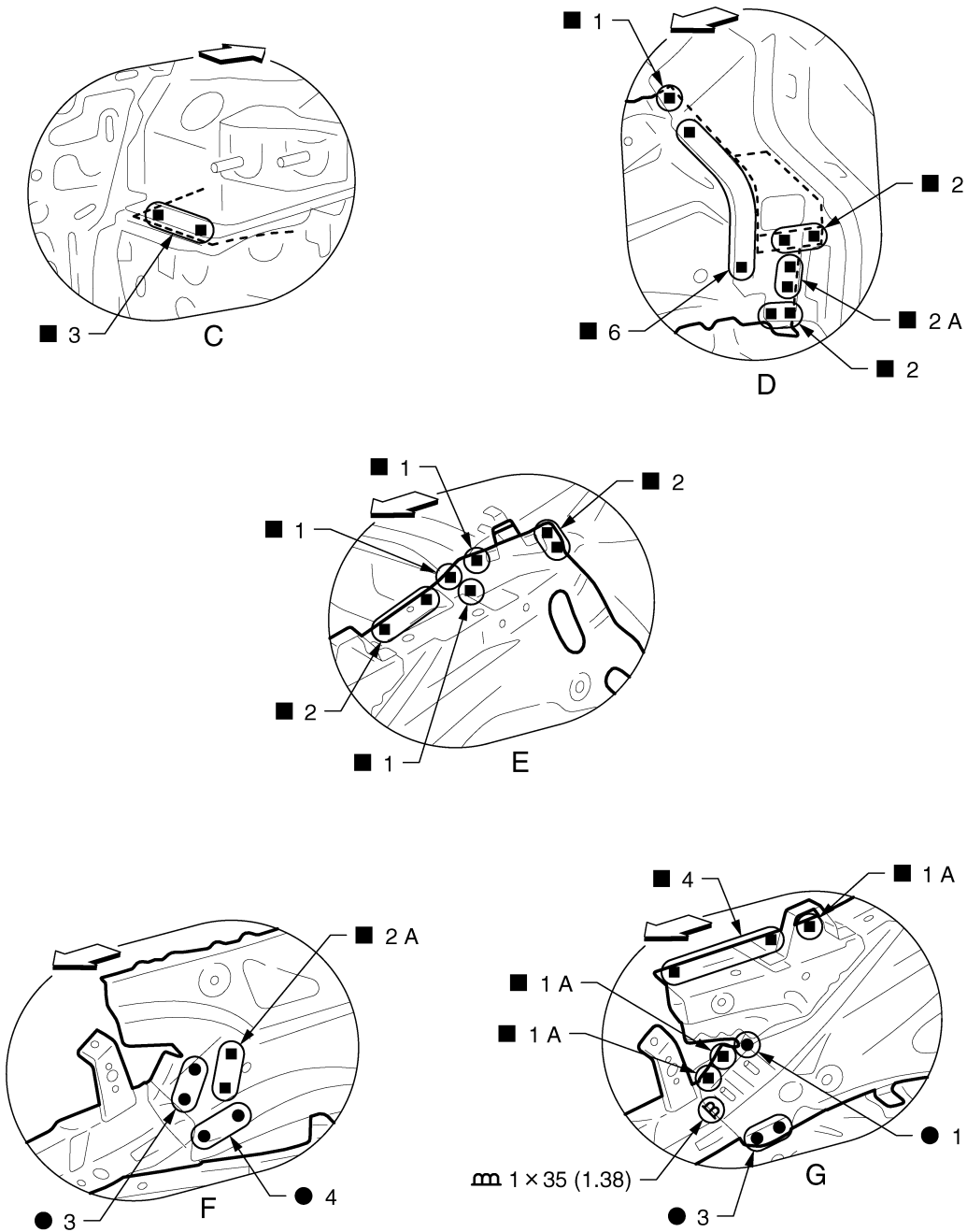
● Lower front hoodledge

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# REPLACEMENT OPERATIONS

## < REMOVAL AND INSTALLATION >



JSKIA2454GB

Unit: mm (in)

↔: Vehicle front

View D and F: Before installing hoodledge reinforcement

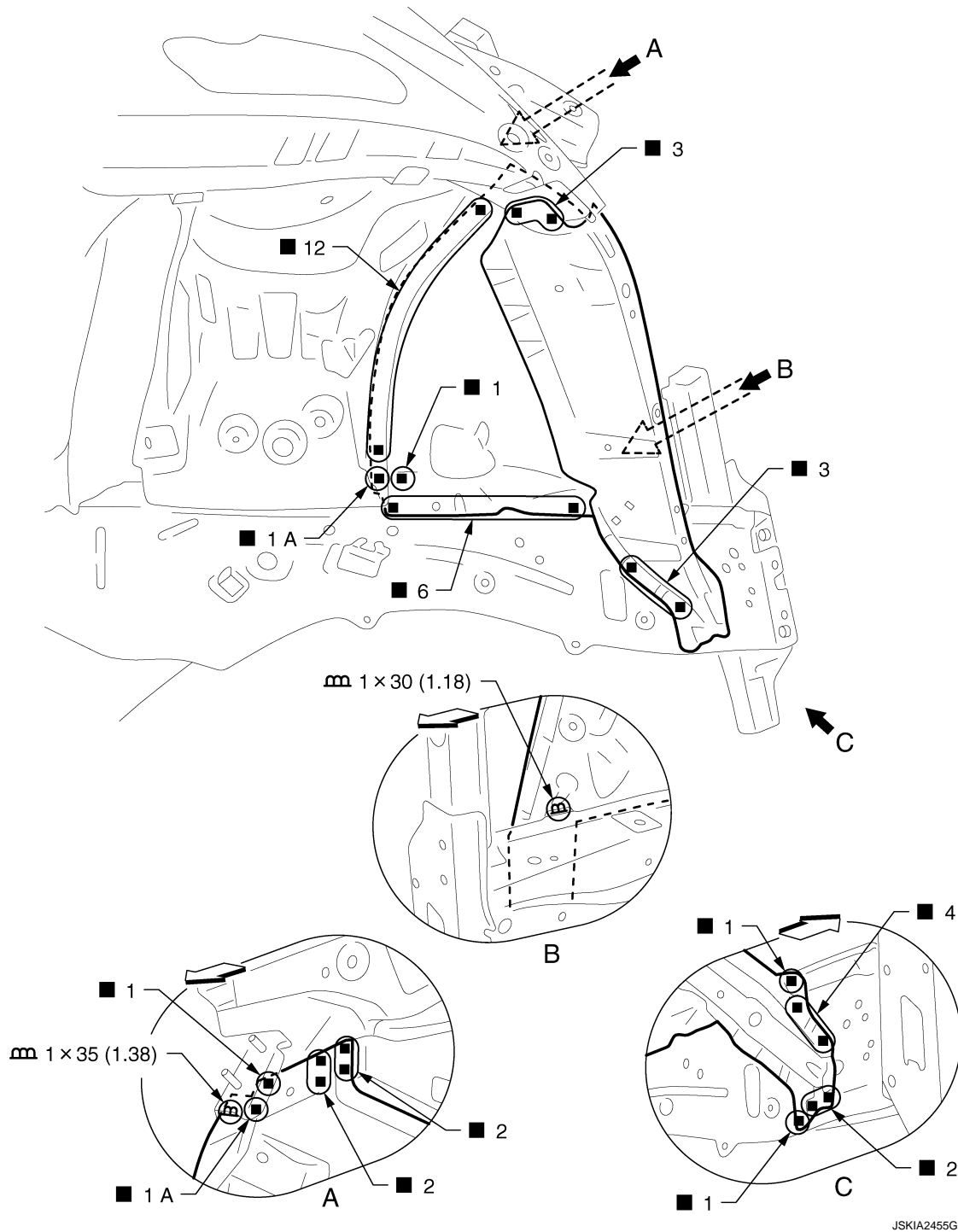
### Hoodledge (Partial Replacement)

INFOID:000000009648875

Work after radiator core support is removed.

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >



Unit: mm (in)

←: Vehicle front

Replacement parts

- Lower front hoodledge

## Front Side Member

Work after radiator core support and hoodledge are removed.

INFOID:000000009648876

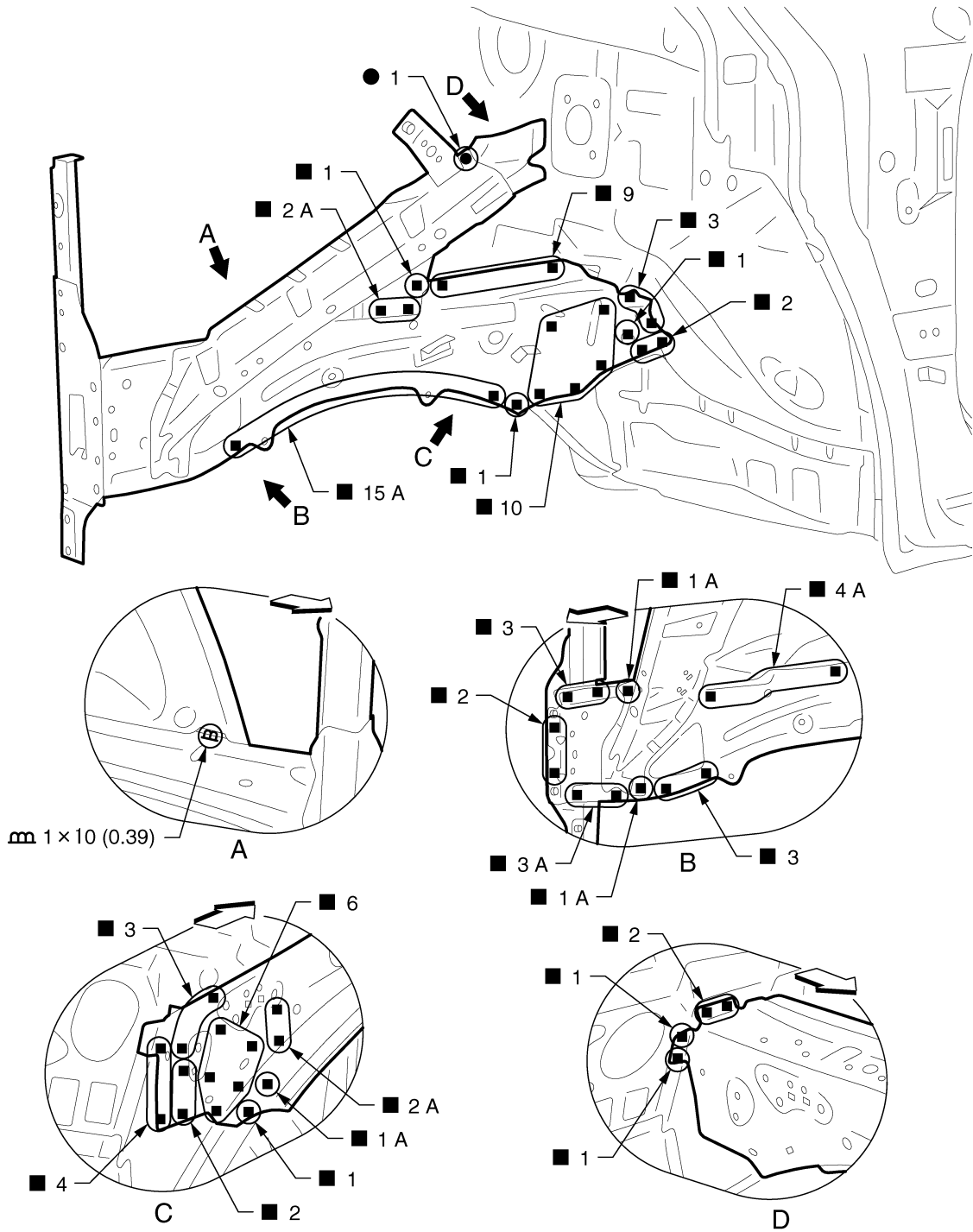
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JSKIA2455GB

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >



JSKIA2456GB

Unit: mm (in)

↔: Vehicle front

Replacement parts

- Front side member assembly
- Front side member closing plate assembly

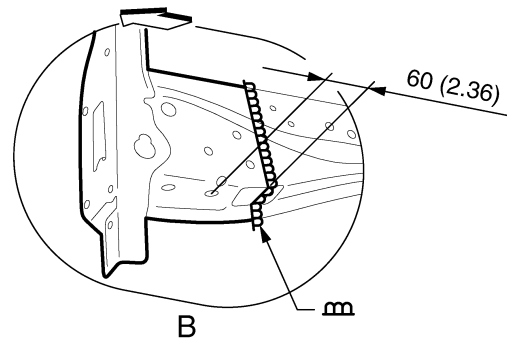
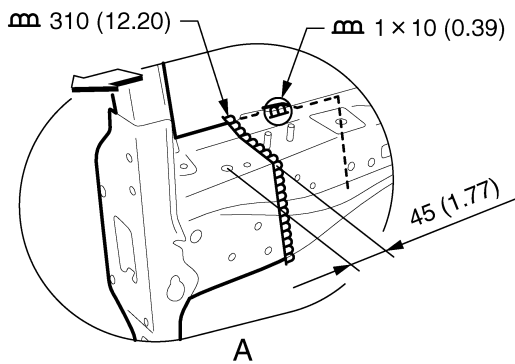
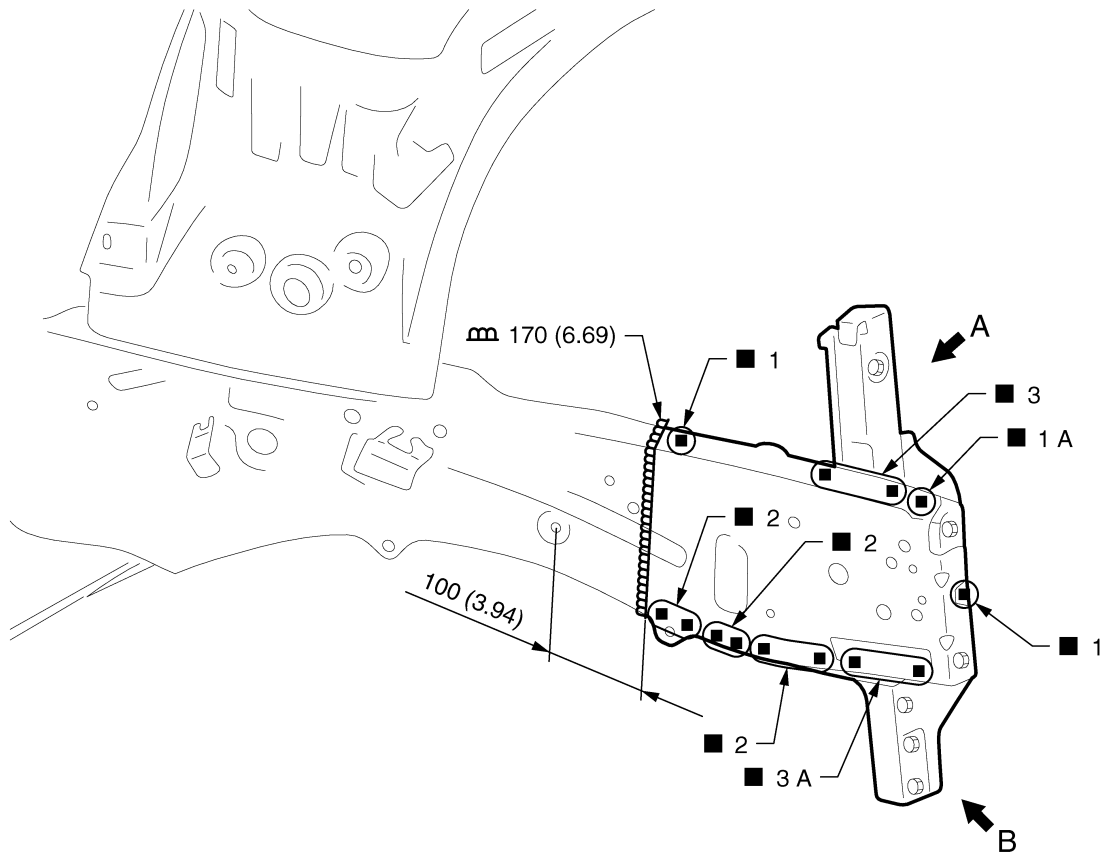
## Front Side Member (Partial Replacement)

INFOID:000000009648877

Work after radiator core support and lower front hoodledge are removed.

# REPLACEMENT OPERATIONS

## < REMOVAL AND INSTALLATION >



Unit: mm (in)

↔: Vehicle front

Replacement parts

- Front side member assembly (RH)
- Front side member closing plate assembly (RH)

### POINT

The front side member on the left can also be replaced partially by cutting at the position shown in the figure.

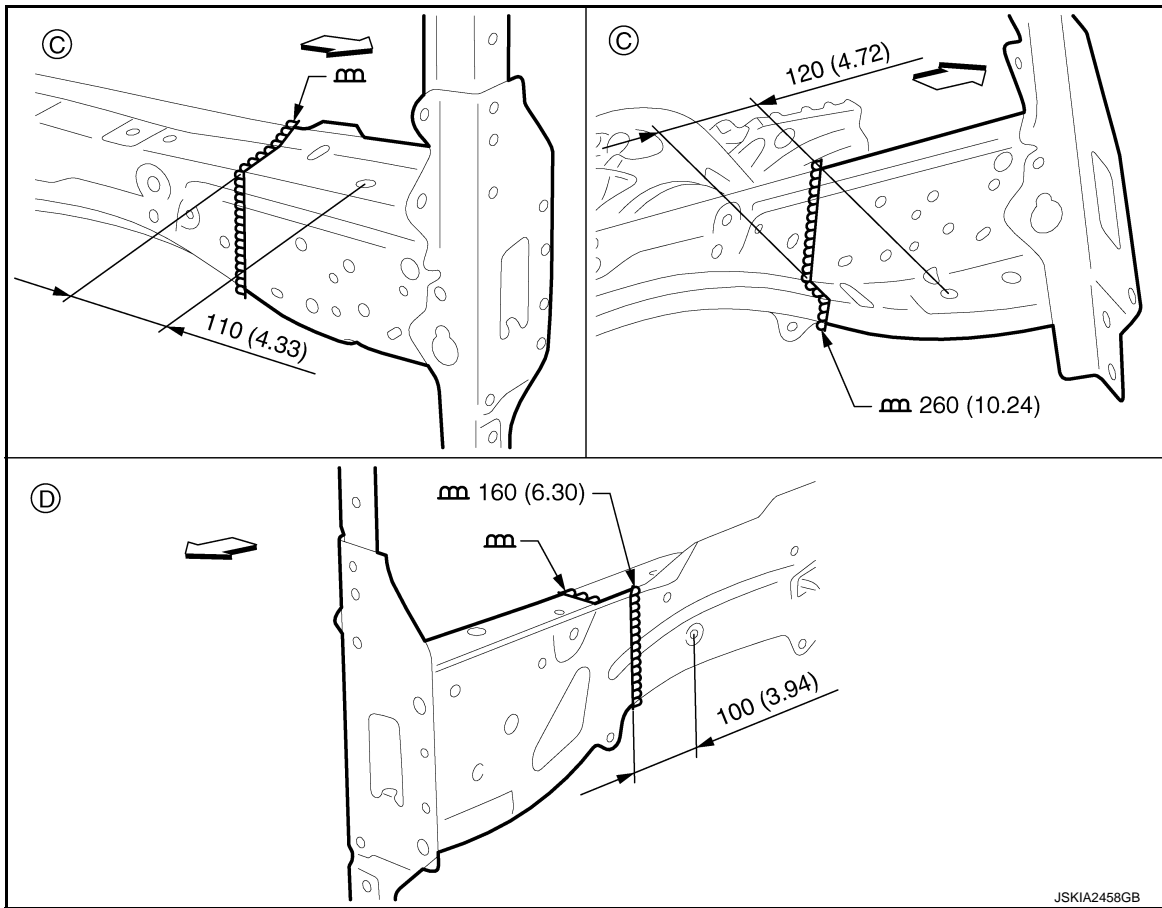
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# REPLACEMENT OPERATIONS

## < REMOVAL AND INSTALLATION >



C. Front side member assembly cutting position (LH)

D. Front side member closing plate assembly cutting position (LH)

Unit: mm (in)

↔: Vehicle front

Replacement parts

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

### NOTE:

For welding method and the number of welding points, refer to the front side member on the right.

## Front Pillar

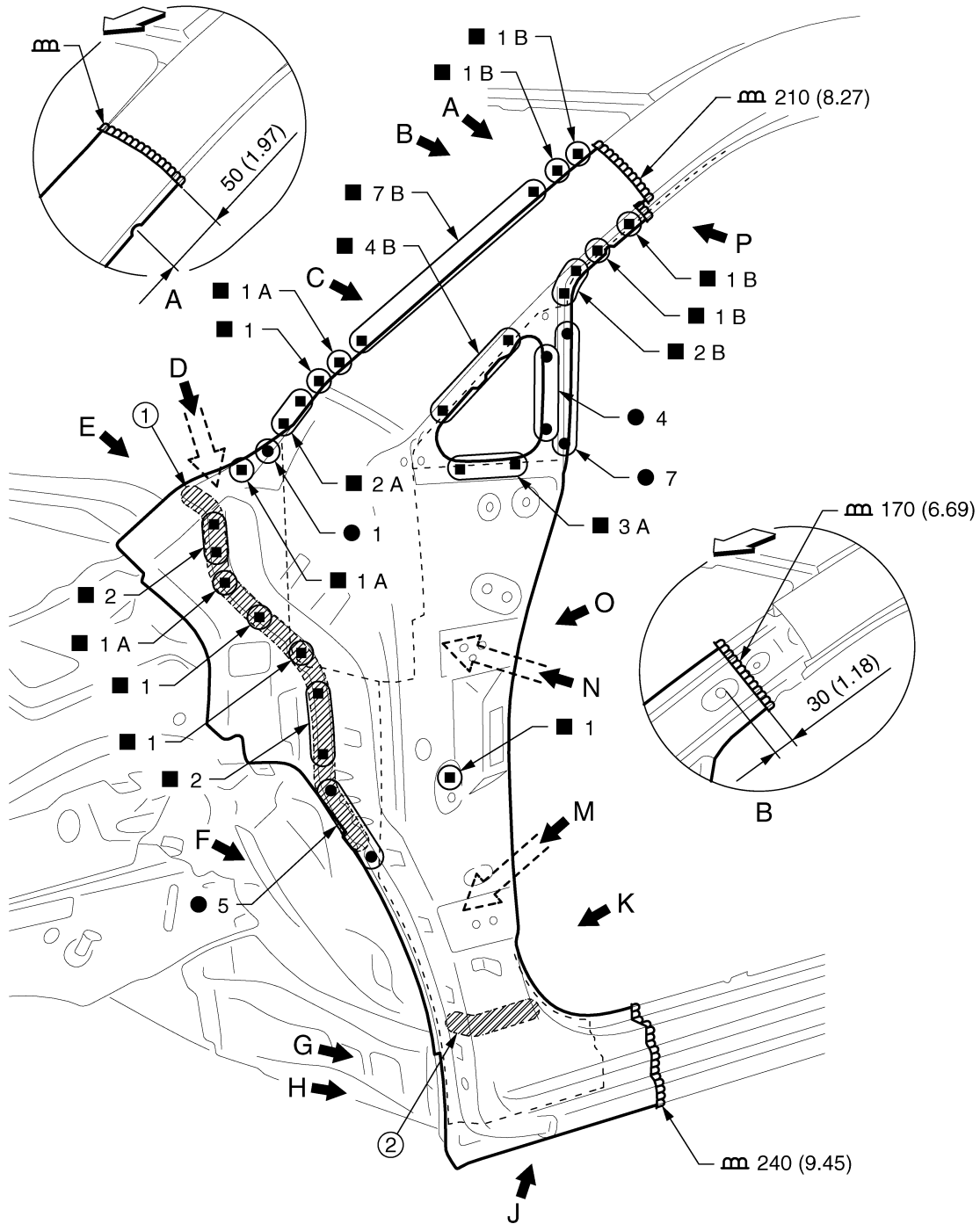
INFOID:000000009648878

Work after hoodledge reinforcement is removed.



# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >



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1. Body sealing  
Unit: mm (in)

2. Urethane foam

◁: Vehicle front

Replacement parts

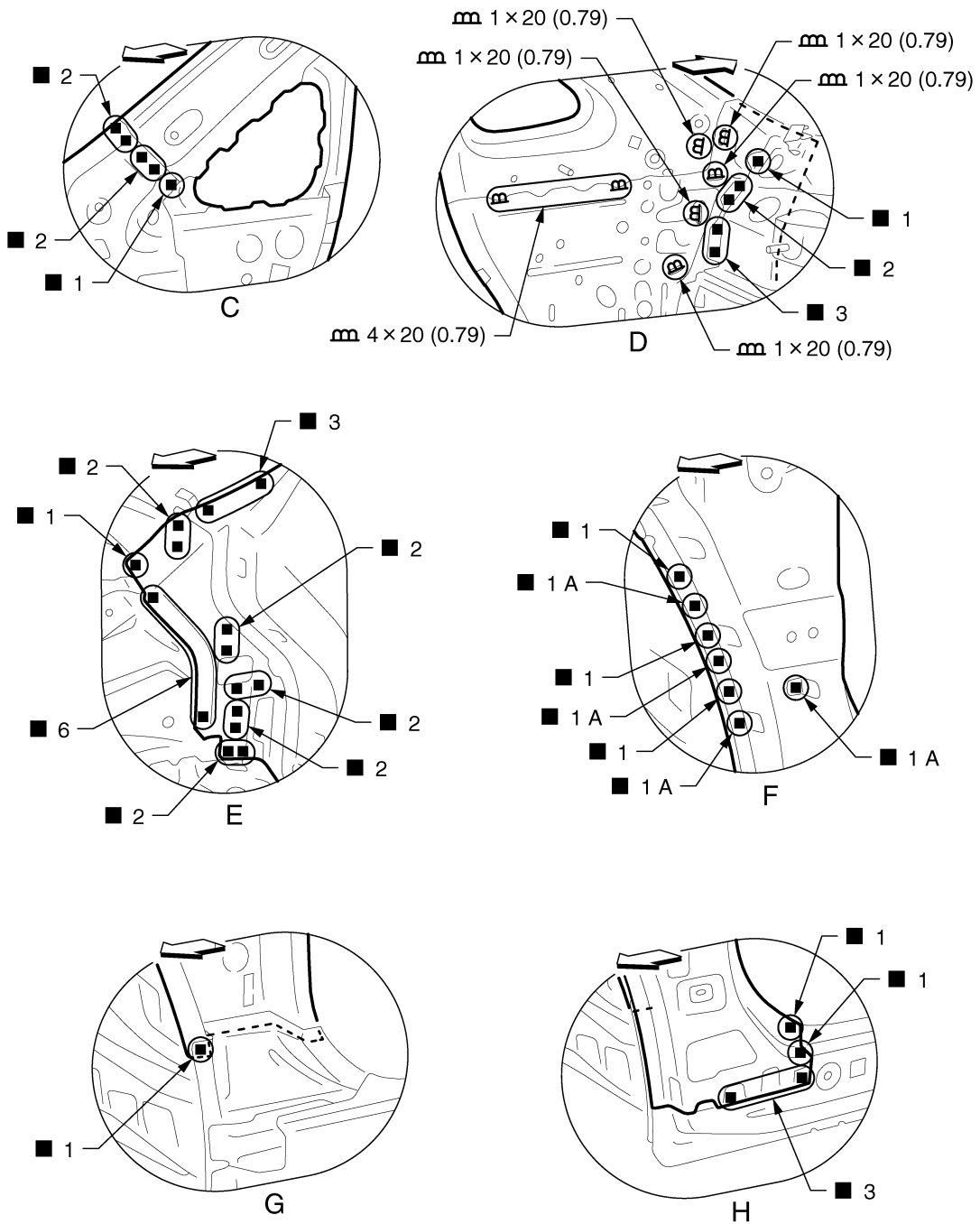
- Outer front side body
- Upper front pillar reinforcement
- Front pillar brace
- Upper inner front pillar
- Side dash
- Front fender bracket assembly

View B: Before installing outer front side body and front fender bracket assembly

JSKIA2459GB

# REPLACEMENT OPERATIONS

## < REMOVAL AND INSTALLATION >



JSKIA2460GB

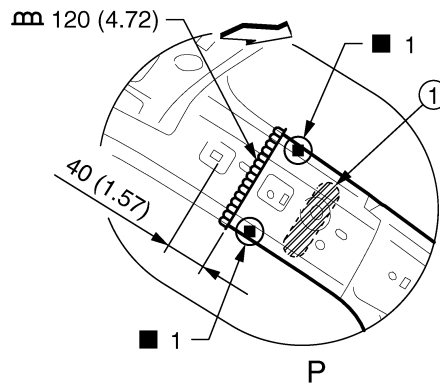
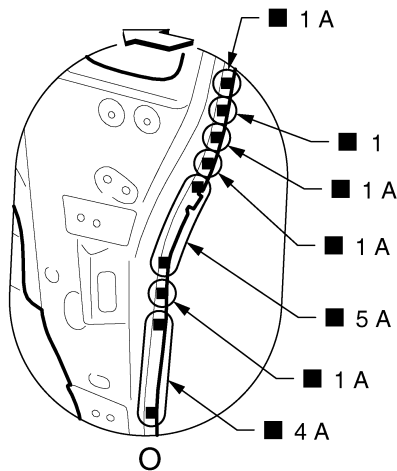
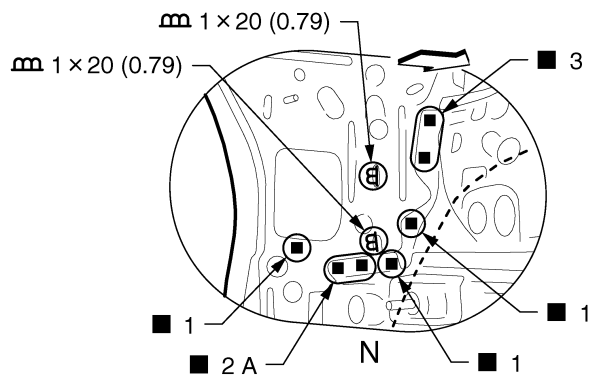
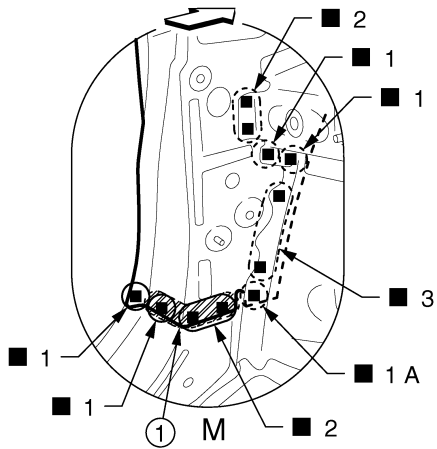
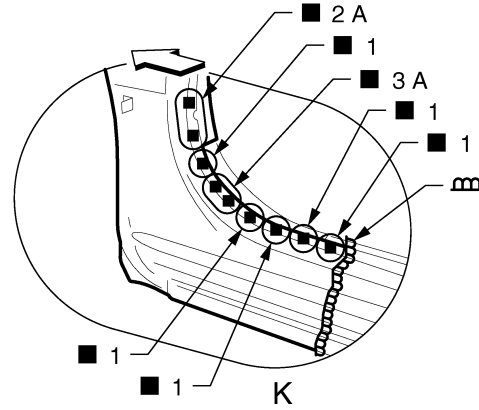
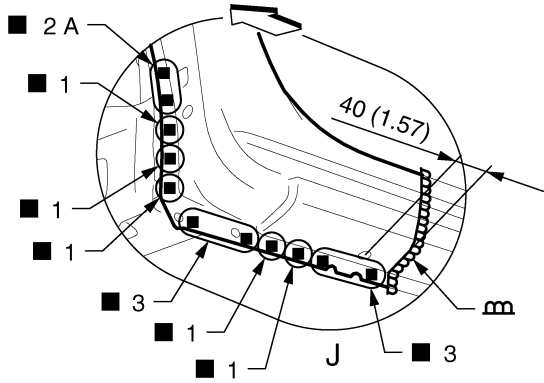
Unit: mm (in)

↔: Vehicle front

View C and H: Before installing outer front side body and front fender bracket assembly

# REPLACEMENT OPERATIONS

## < REMOVAL AND INSTALLATION >



1. Urethane foam

Unit: mm (in)

◄: Vehicle front

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

View M: Before installing outer front side body, front fender bracket assembly, and front pillar brace

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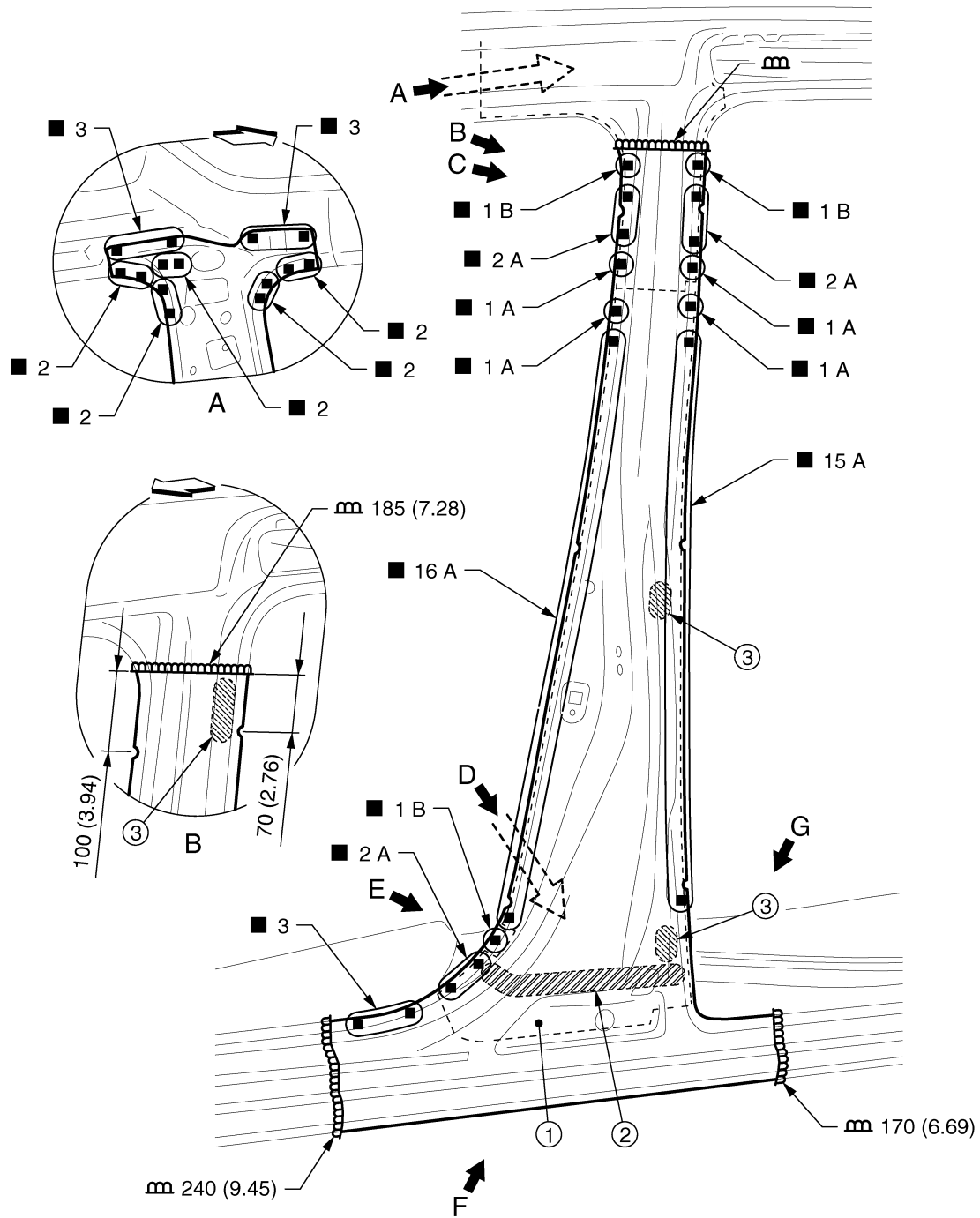
JSKIA2461GB

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

## Center Pillar

INFOID:00000009648879



JSKIA2462GB

1. Center pillar reinforcement

2. Urethane foam

3. Adhesive

Unit: mm (in)

↙: Vehicle front

Replacement parts

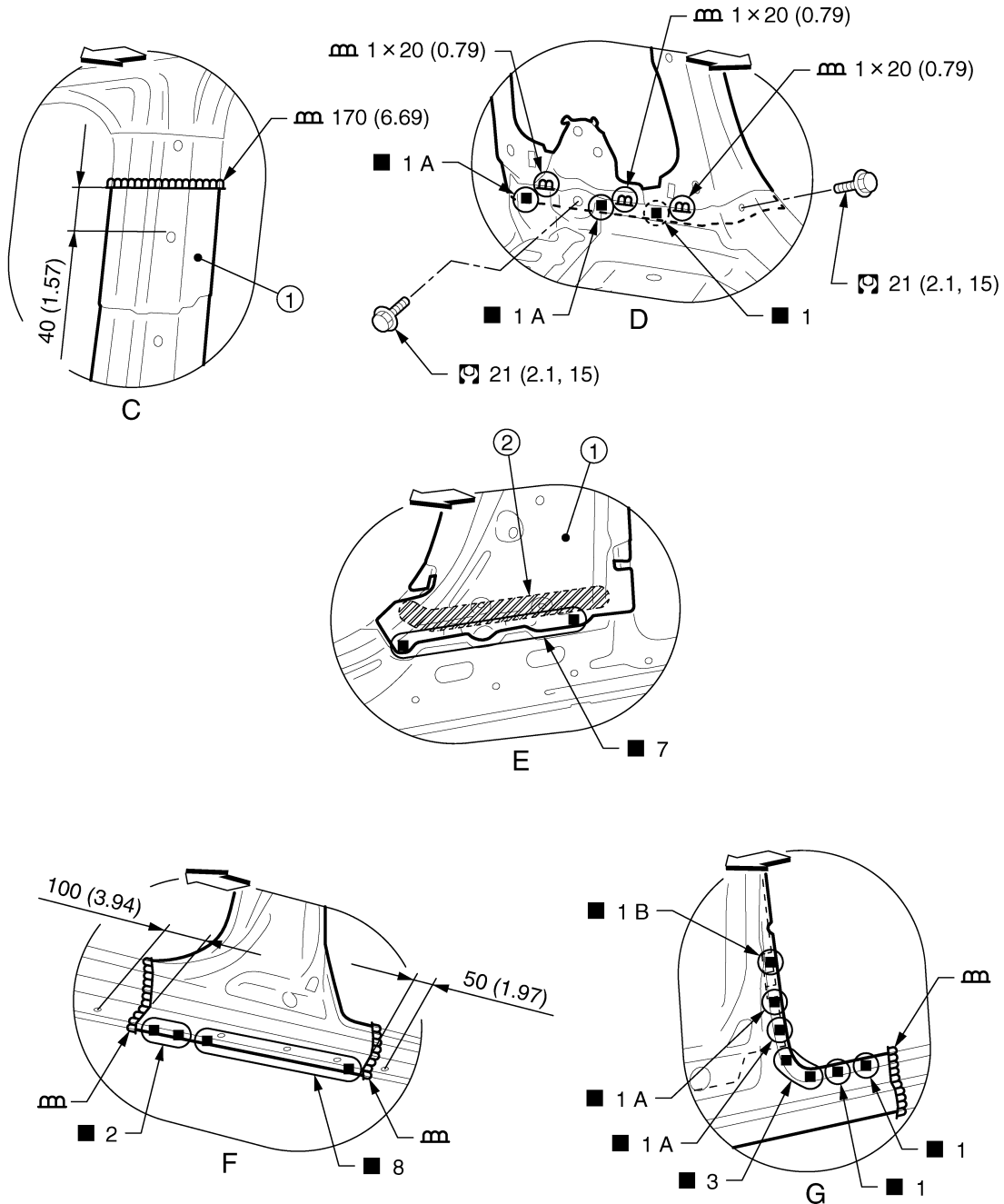
● Outer front side body

● Center pillar reinforcement

● Inner center pillar

# REPLACEMENT OPERATIONS

## < REMOVAL AND INSTALLATION >



- 1. Center pillar reinforcement
- 2. Urethane foam

Unit: mm (in)

◀: Vehicle front

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

⊞: N·m (kg·m, ft·lb)

View C and E: Before installing outer front side body

View D: Before installing outer front side body and center pillar reinforcement

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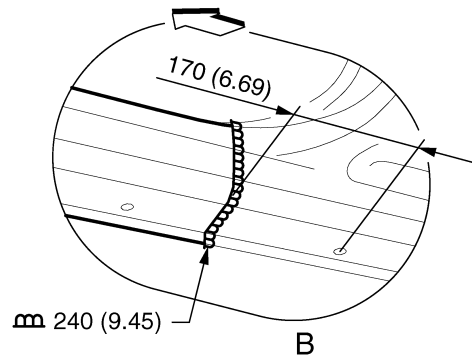
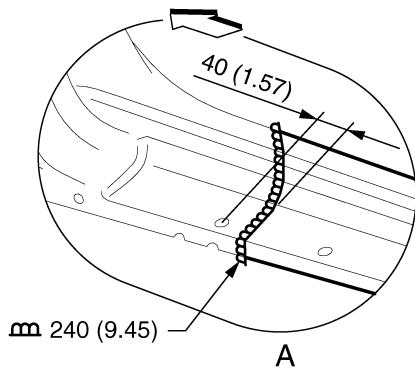
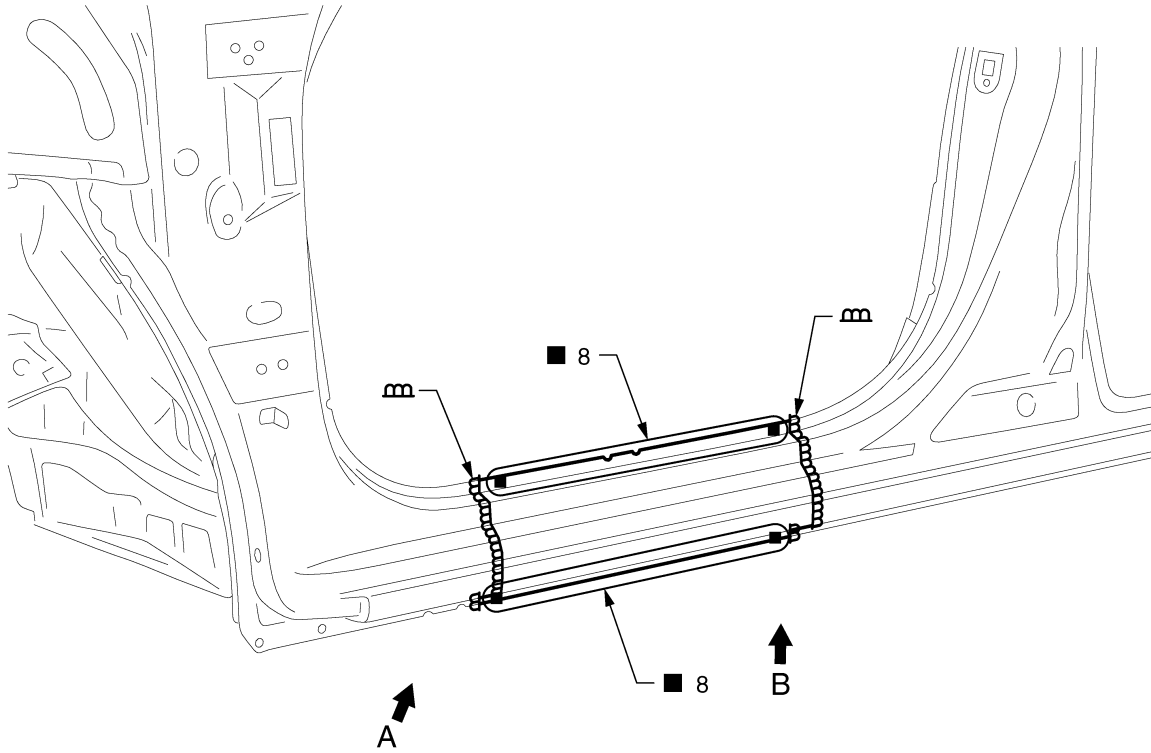
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# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

## Outer Sill (Partial Replacement)

INFOID:000000009648880



JSKIA2109GB

Unit: mm (in)

↔: Vehicle front

Replacement parts

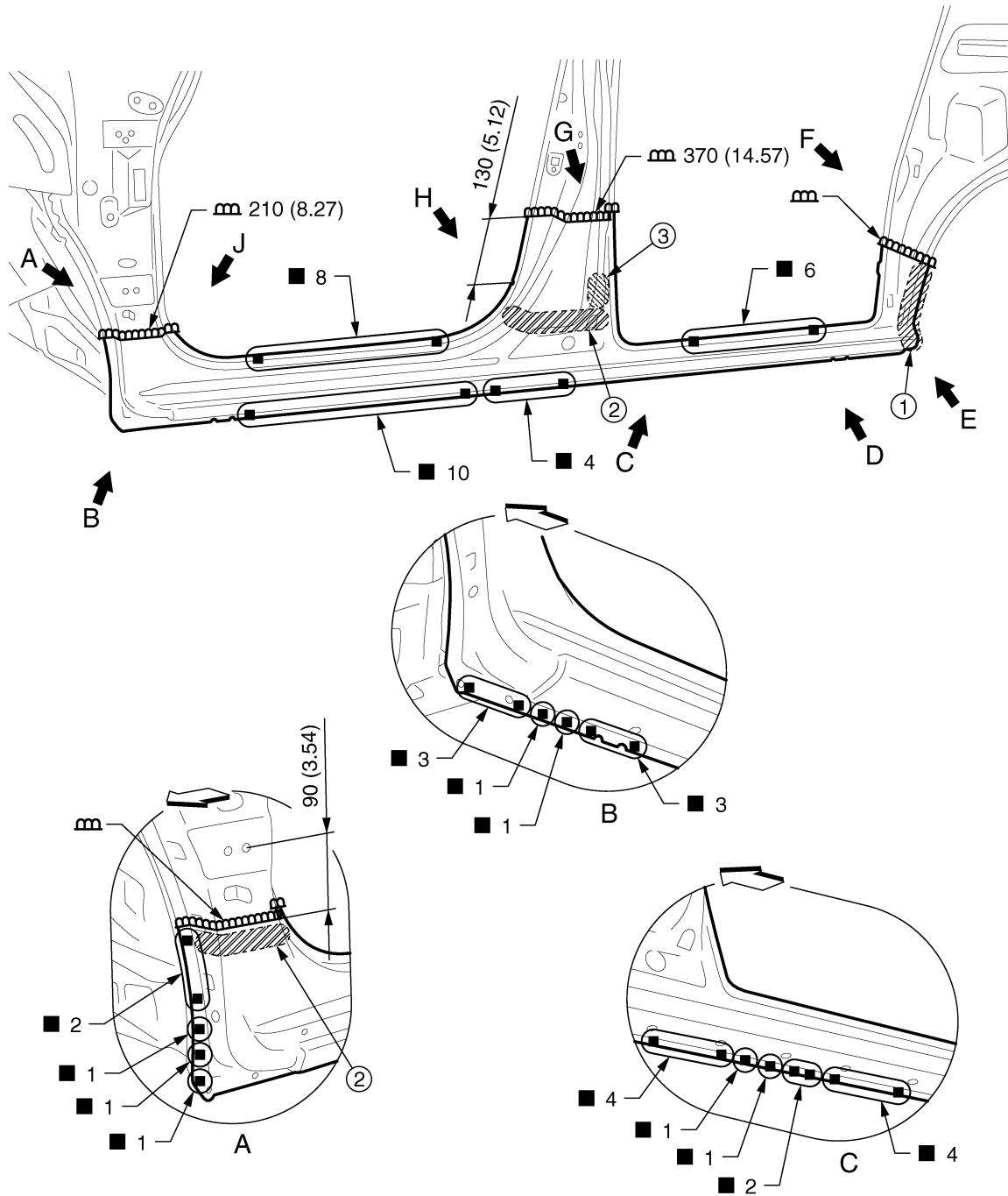
- Outer sill

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

## Outer Sill

INFOID:000000009648881



1. Body sealing

2. Urethane foam

3. Adhesive

Unit: mm (in)

↔: Vehicle front

Replacement parts

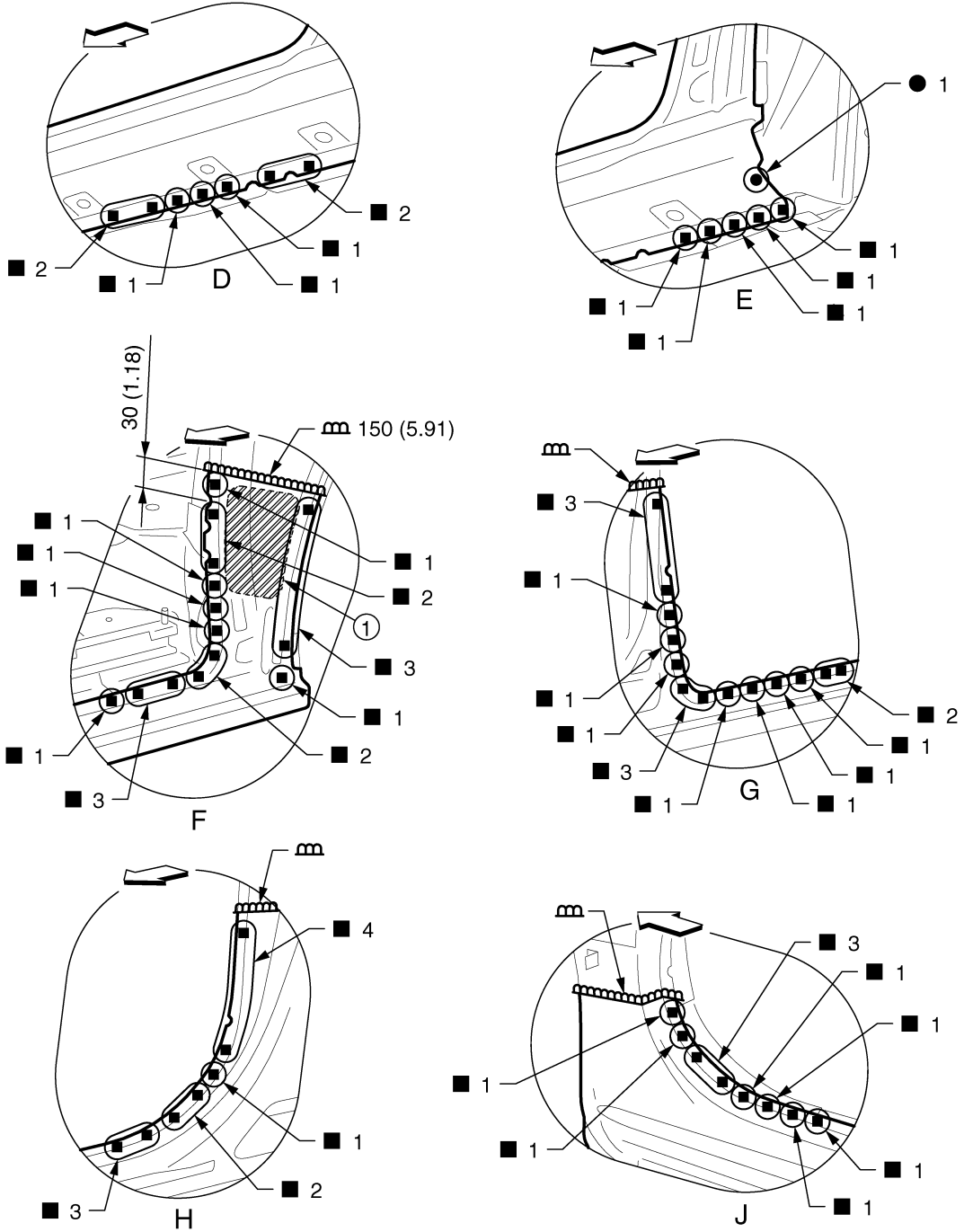
● Outer sill

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# REPLACEMENT OPERATIONS

## < REMOVAL AND INSTALLATION >



JSKIA2465GB

- 1. Urethane foam
- Unit: mm (in)
- ↔: Vehicle front

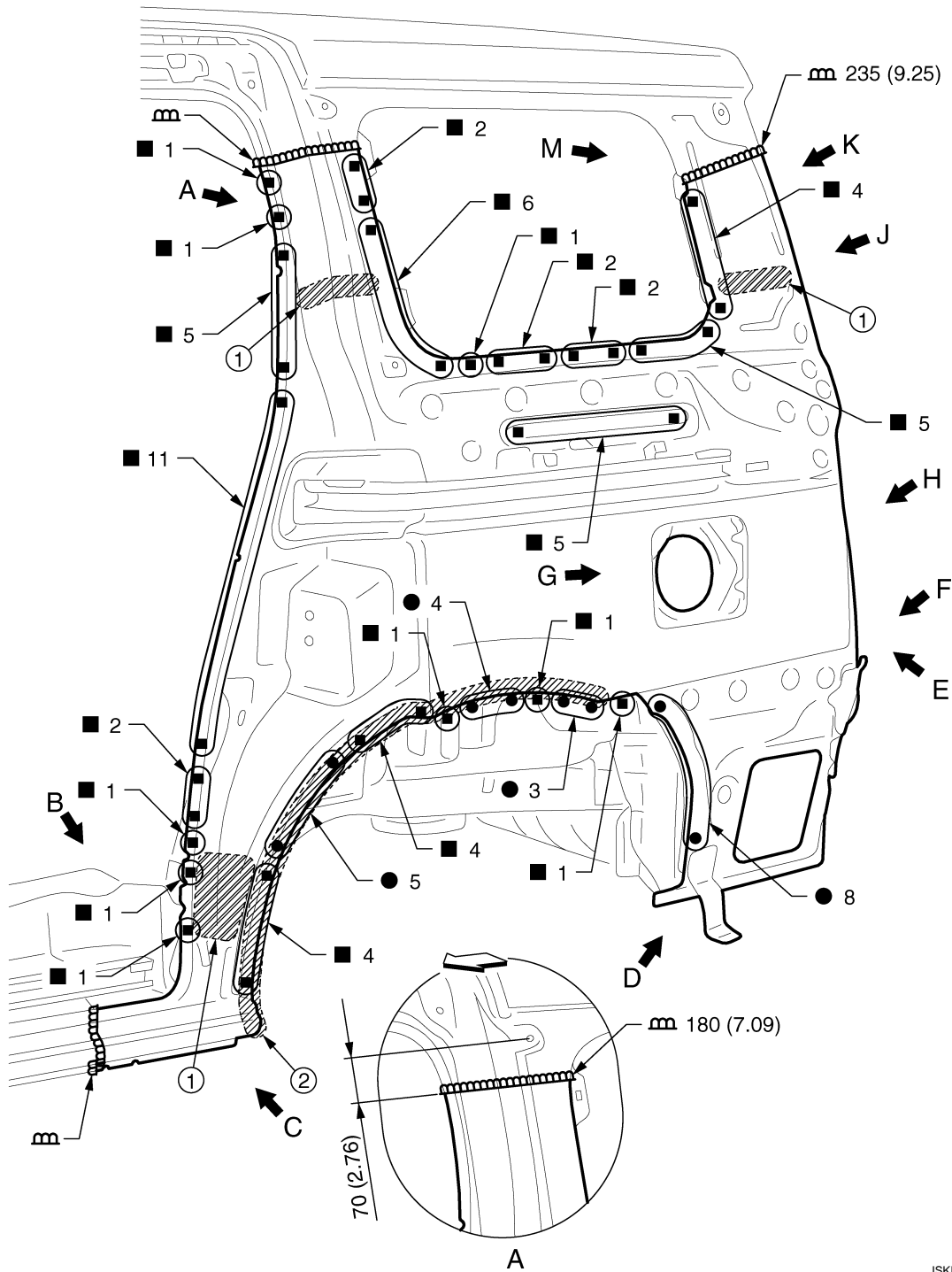


# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

## Rear Fender

INFOID:000000009648882



1. Urethane foam

Unit: mm (in)

◁: Vehicle front

Replacement parts

● Rear fender

2. Body sealing

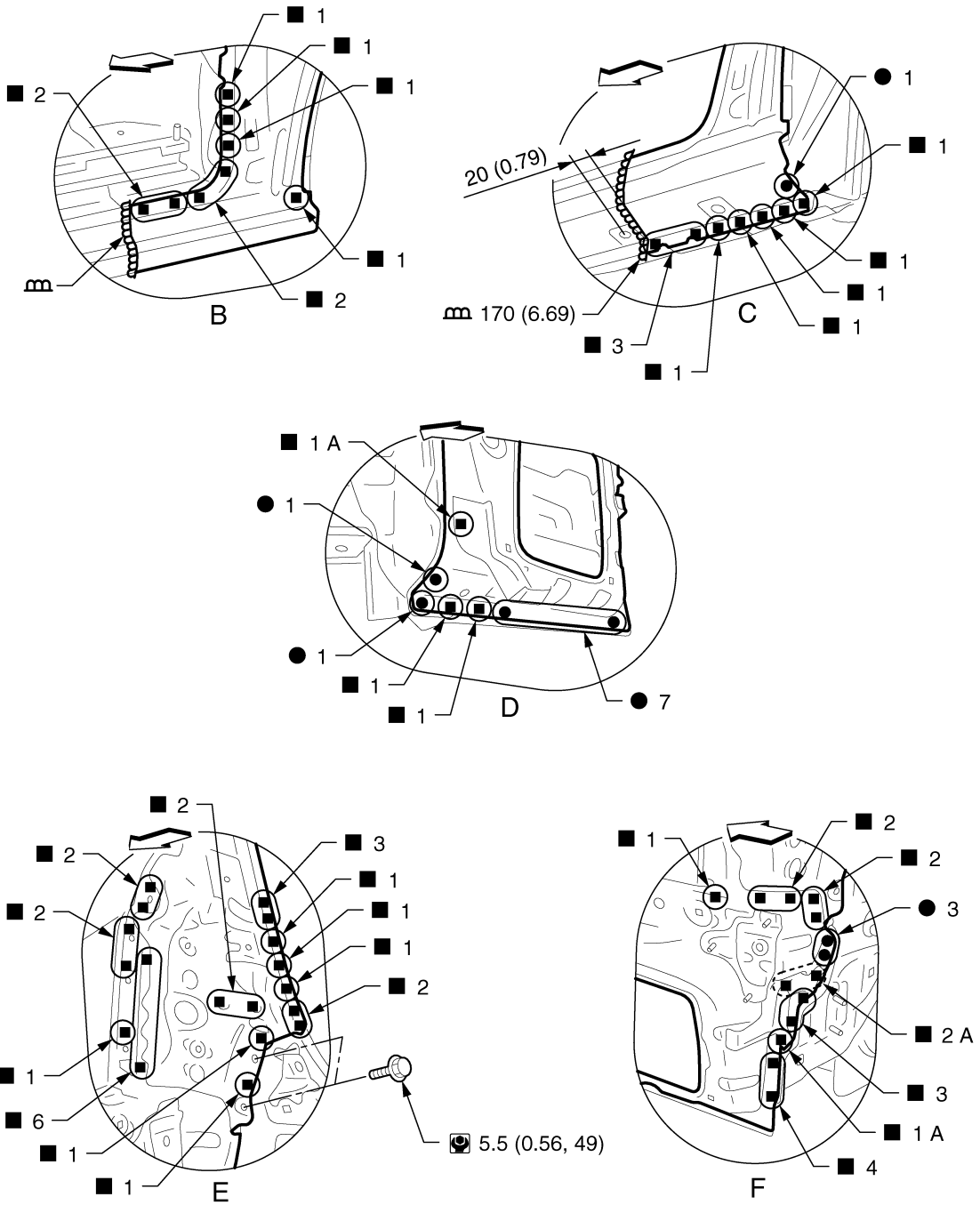
JSKIA2466GB

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# REPLACEMENT OPERATIONS

## < REMOVAL AND INSTALLATION >



JSKIA2467GB

Unit: mm (in)

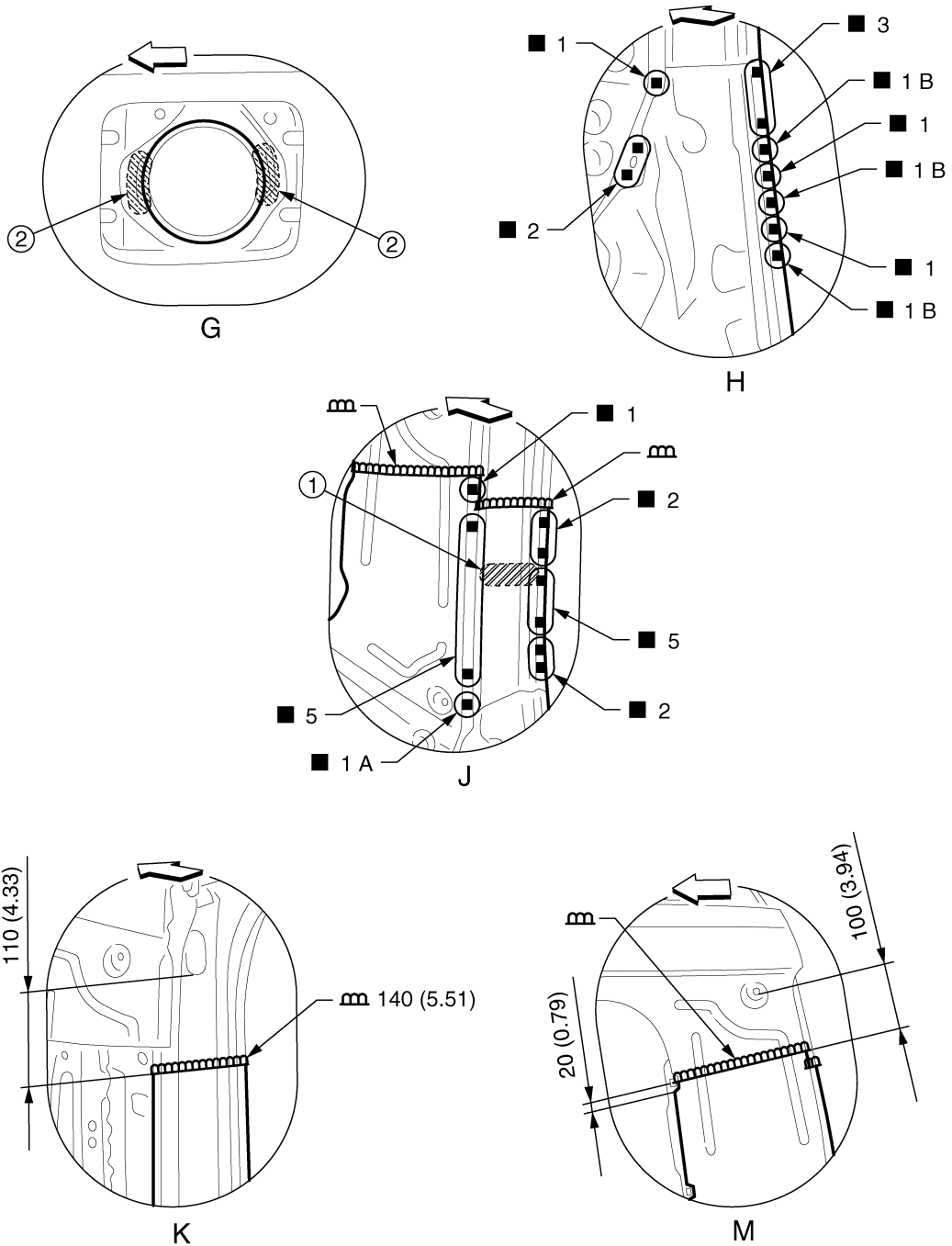
↔: Vehicle front

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

⊕: N·m (kg·m, in·lb)

# REPLACEMENT OPERATIONS

## < REMOVAL AND INSTALLATION >



1. Urethane foam

2. Adhesive

Unit: mm (in)

← Vehicle front

View K: Before installing rear fender

JSKIA2114GB

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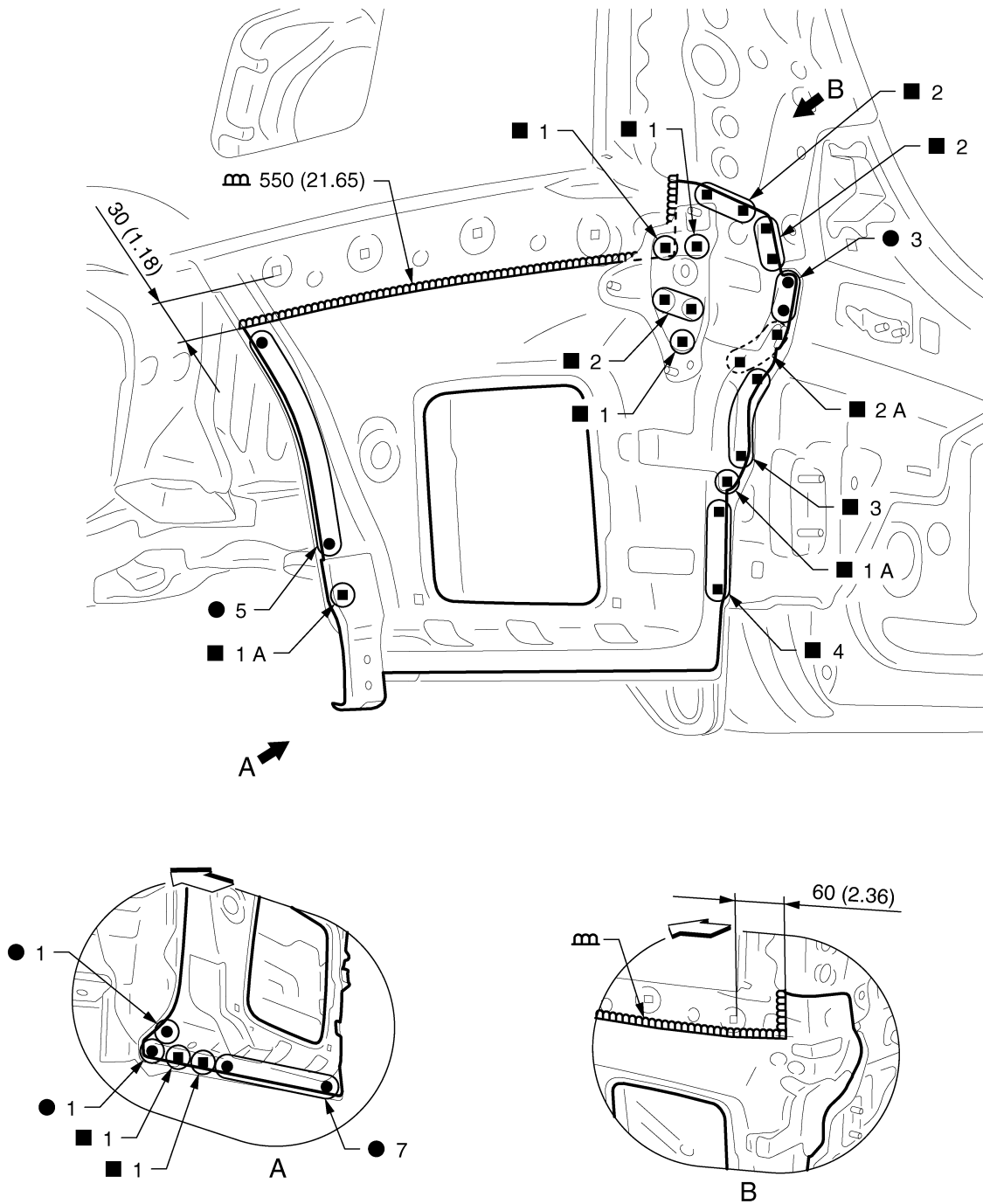
BRM

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

## Rear Fender Extension

INFOID:00000009648883



JSKIA2468GB

Unit: mm (in)

↔: Vehicle front

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

Replacement parts

- Rear fender extension
- Rear fender extension (Bracket)

View B: Before installing rear fender extension (Bracket)

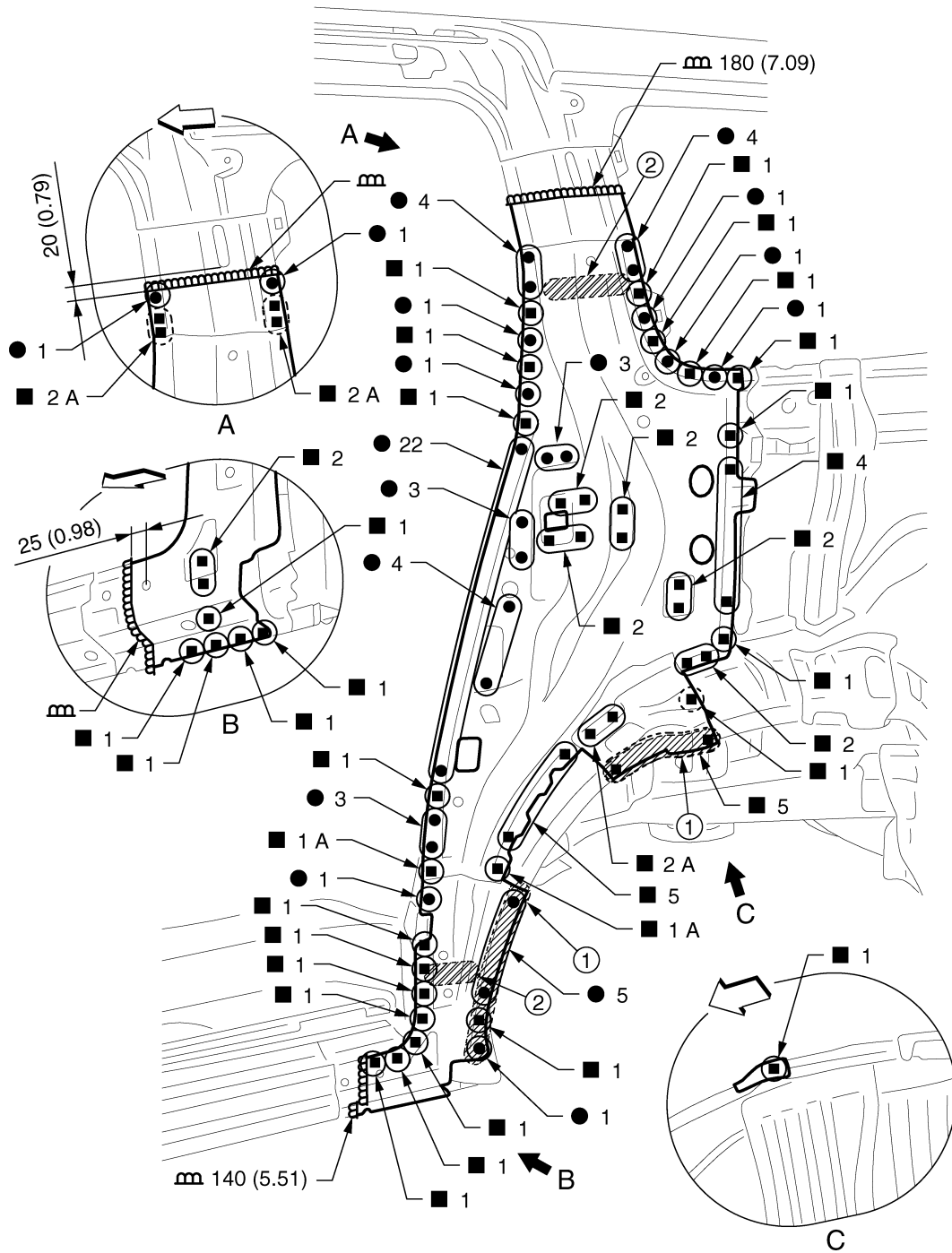
# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

## Rear Pillar Reinforcement

INFOID:000000009648884

Work after rear fender is removed.



1. Body sealing

2. Urethane foam

Unit: mm (in)

⇐: Vehicle front

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

Replacement parts

- Inner rear pillar reinforcement

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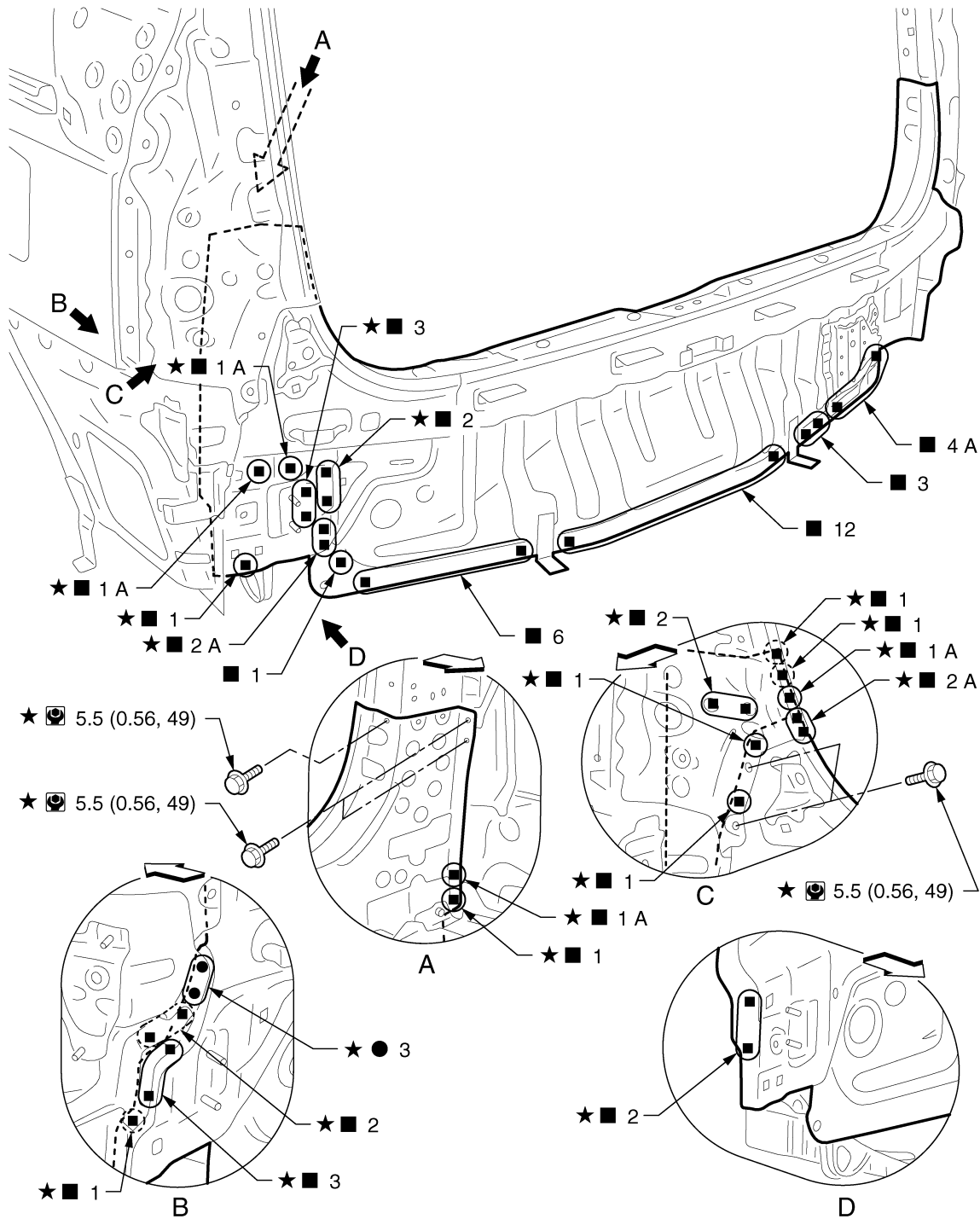
JSKIA2469GB

# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

Rear Panel

INFOID:0000000964885



JSKIA3718GB

← Vehicle front

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

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

★ ■: N-m (kg-m, in-lb)

Replacement parts

● Upper rear panel

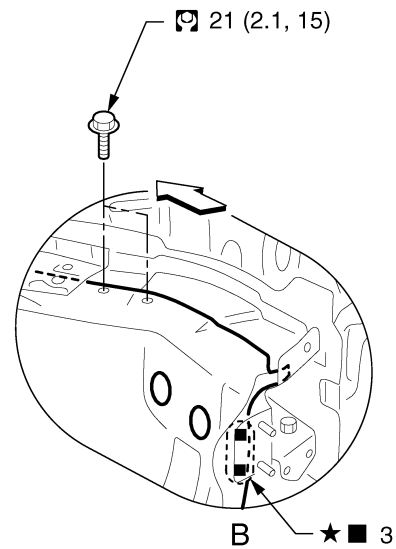
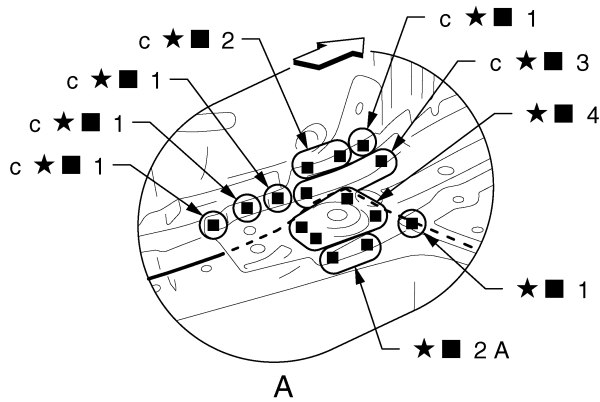
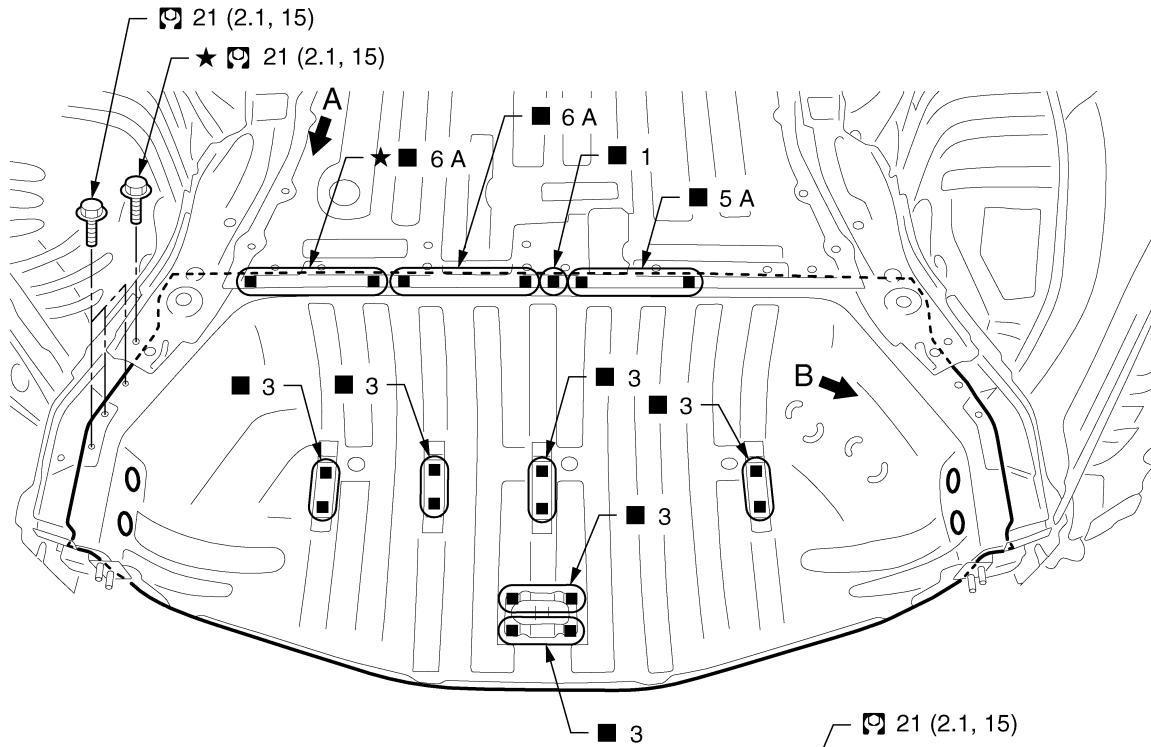
# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

## Rear Floor Rear

INFOID:000000009648886

Work after rear panel is removed.  
Remove the welding points "c" for easier installation.



←: Vehicle front

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

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

🔧: N·m (kg·m, ft·lb)

Replacement parts

● Rear floor rear

● Woofer bracket assembly

● Jack mounting bracket

JSKIA2471GB

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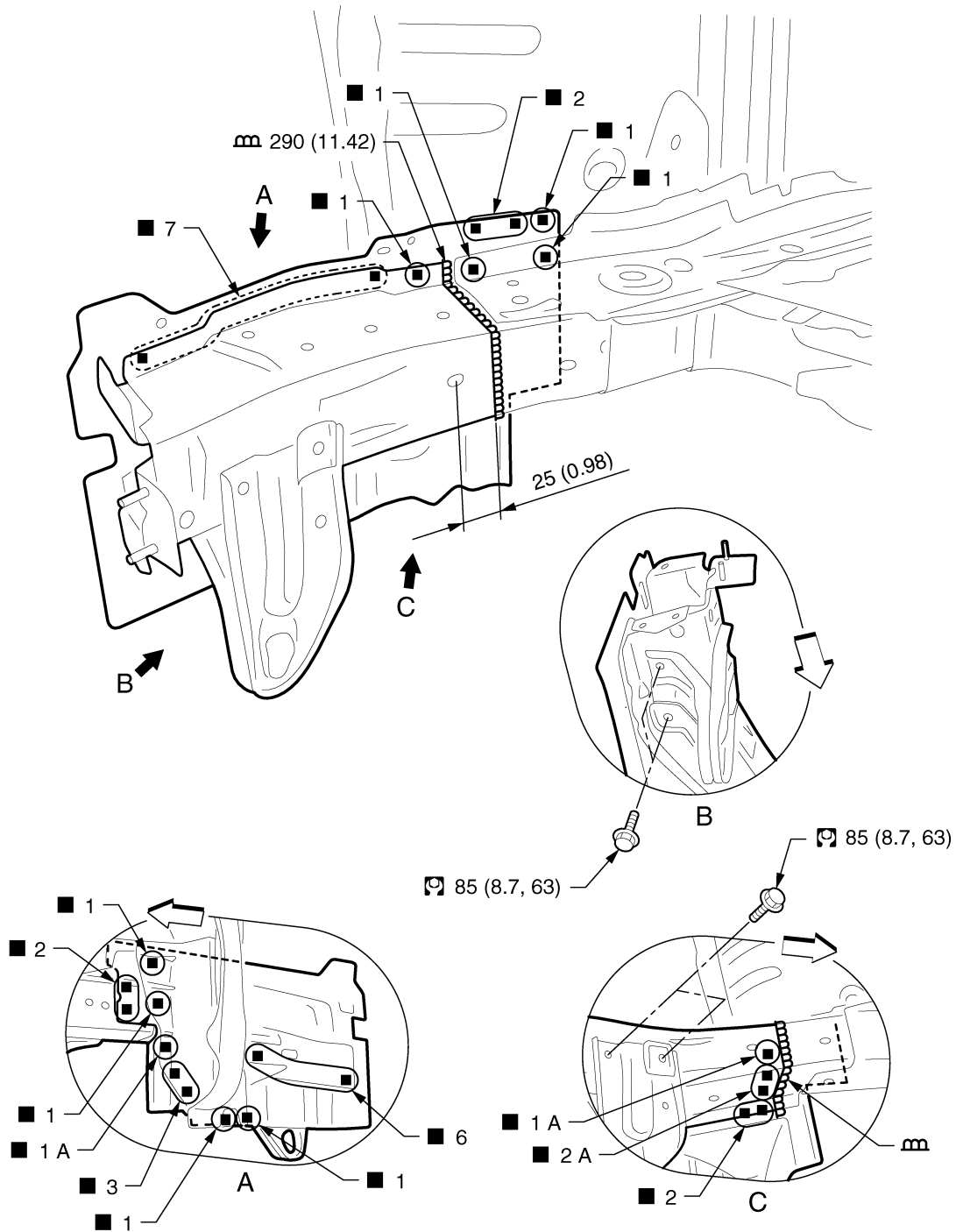
# REPLACEMENT OPERATIONS

< REMOVAL AND INSTALLATION >

## Rear Side Member Extension

INFOID:0000000964887

Work after rear fender extension, rear panel, and rear floor rear are removed.



JSKIA2472GB

Unit: mm (in)

◀: Vehicle front

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

⊙: N-m (kg-m, ft-lb)

Replacement parts

- Rear side member extension
- Rear floor rear side



# BODY ALIGNMENT

< SERVICE DATA AND SPECIFICATIONS (SDS)

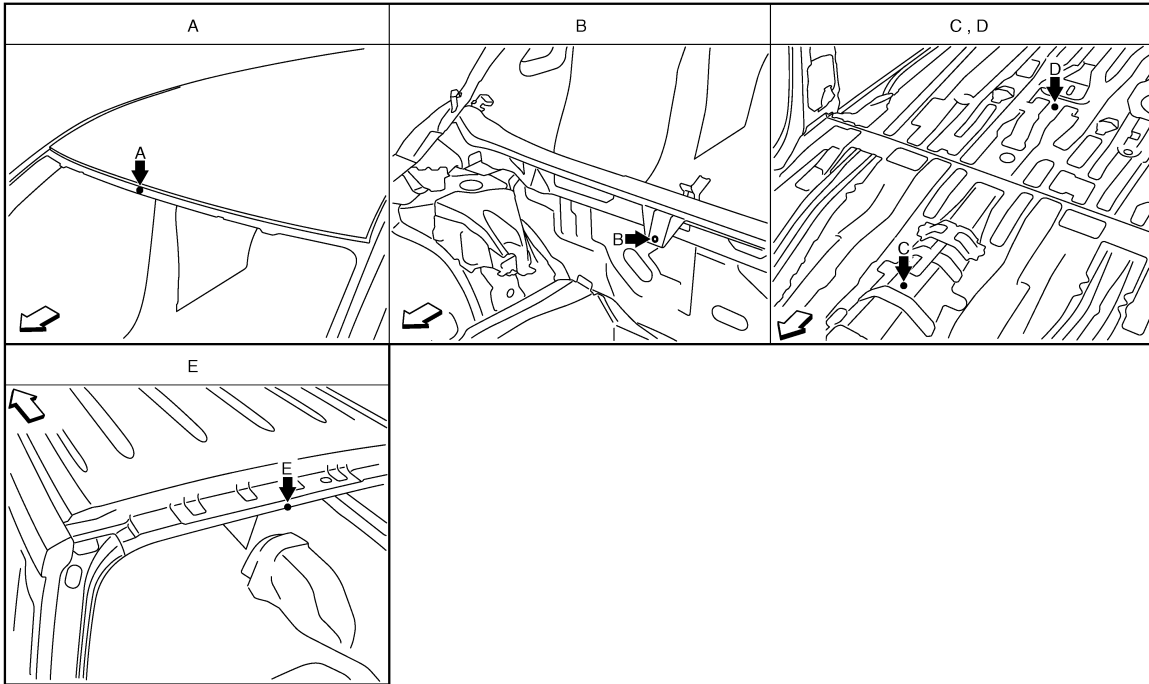
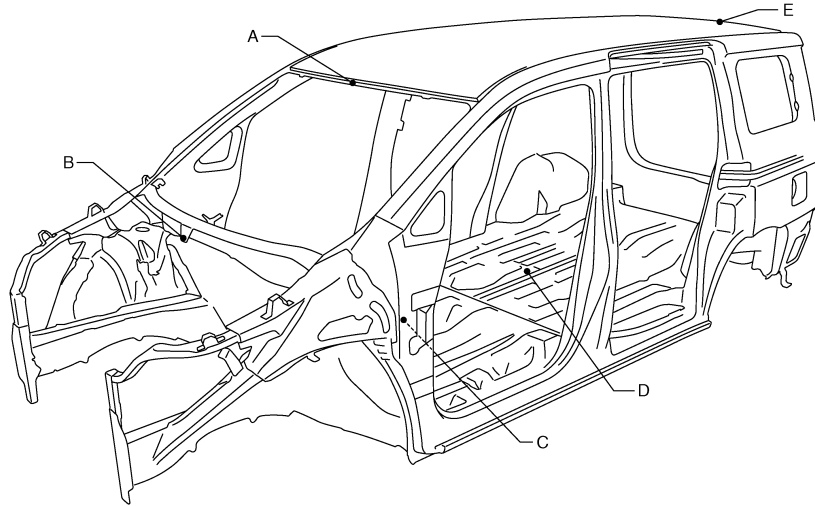
## SERVICE DATA AND SPECIFICATIONS (SDS)

### BODY ALIGNMENT

#### Body Center Marks

INFOID:000000009648888

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.



JSKIA2483ZZ

↶: Vehicle front

Unit: mm (in)

Points	Portion	Marks
A	Front roof	Embossment
B	Center cowl top	Hole $\phi 7$ (0.28)
C	Front floor	Embossment

# BODY ALIGNMENT

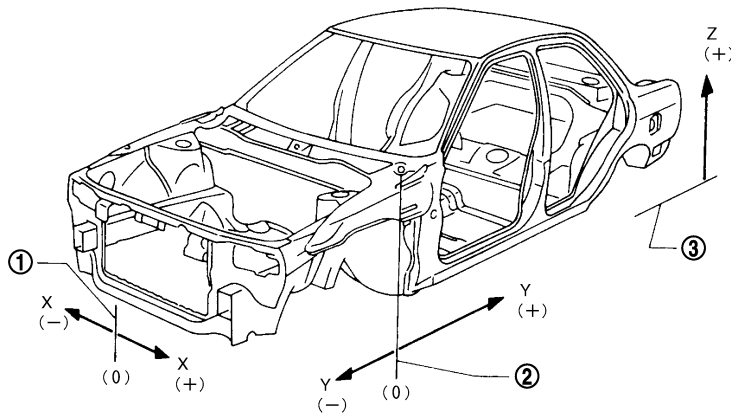
## < SERVICE DATA AND SPECIFICATIONS (SDS)

Points	Portion	Marks
D	Rear floor front	Embossment
E	Rear roof	Embossment

### Description

INFOID:000000009648889

- 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

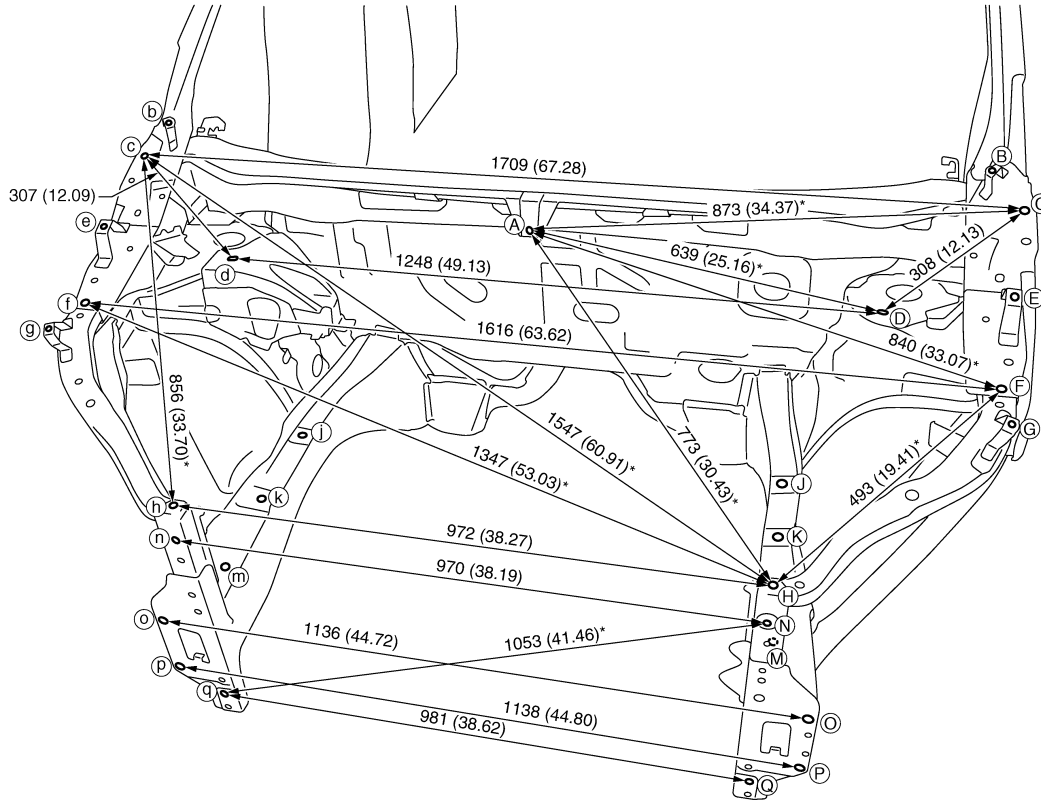
INFOID:000000009648890

#### 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)



JSKIA2484GB

Unit: mm (in)

«The others»

Unit: mm (in)

Point	Dimension	Memo	Point	Dimension	Memo	Point	Dimension	Memo	Point	Dimension	Memo
A - B	818 (32.20)*		A - m	825 (32.48)		J - k	1002 (39.45)		N - o	1074 (42.28)*	
A - E	826 (32.52)*		B - b	1581 (62.24)		J - m	1055 (41.54)		N - p	1107 (43.58)*	
A - G	875 (34.45)*		C - d	1493 (58.78)*		j - K	985 (38.78)		O - p	1144 (45.04)*	
A - J	681 (26.81)		C - F	403 (15.87)*		j - M	1056 (41.57)		O - q	1075 (42.32)*	
A - j	688 (27.09)		C - f	1710 (67.32)*		K - k	986 (38.82)		P - q	1061 (41.77)*	
A - K	712 (28.03)		E - e	1646 (64.80)		K - m	1015 (39.96)				
A - k	738 (29.06)		G - g	1625 (63.98)		k - M	1007 (39.65)				
A - M	828 (32.60)		J - j	973 (38.31)		M - m	990 (38.98)				

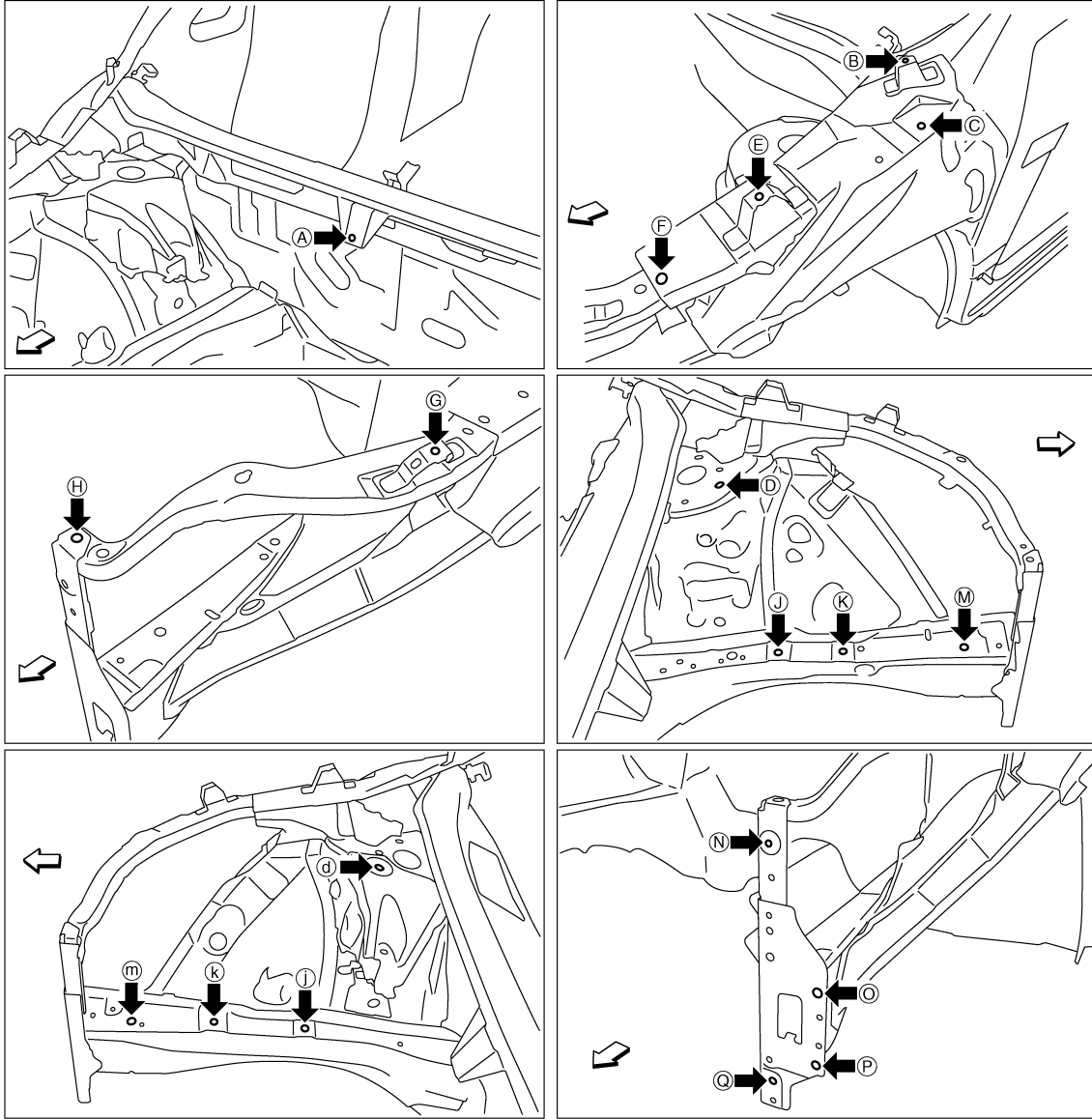
## MEASUREMENT POINTS

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# BODY ALIGNMENT

## < SERVICE DATA AND SPECIFICATIONS (SDS)



JSKIA2485ZZ

←: Vehicle front

Unit: mm (in)

Point	Material	Point	Material
A	Center cowl top hole center of center positioning mark $\phi 7$ (0.28)	H, h, N, n	Side radiator core support hole center H, h: $\phi 13$ (0.51) N, n: $\phi 9$ (0.35)
B, b, E, e, G, g	Front fender installing hole center $\phi 7$ (0.28)	J, j, K, k, M, m	Front side member hole center J, j, K, k: $\phi 14$ (0.55) M, m: $\phi 16$ (0.63)
C, c	Hood hinge installing hole center $\phi 11$ (0.43)	O, o, P, p	Front bumper stay installing hole center $\phi 11$ (0.43)
D, d	Front strut installing hole center 16×10 (0.63×0.39)	Q, q	Front side member connector hole center $\phi 9$ (0.35)
F, f	Hoodledge extension hole center $\phi 13$ (0.51)		

# BODY ALIGNMENT

## < SERVICE DATA AND SPECIFICATIONS (SDS)

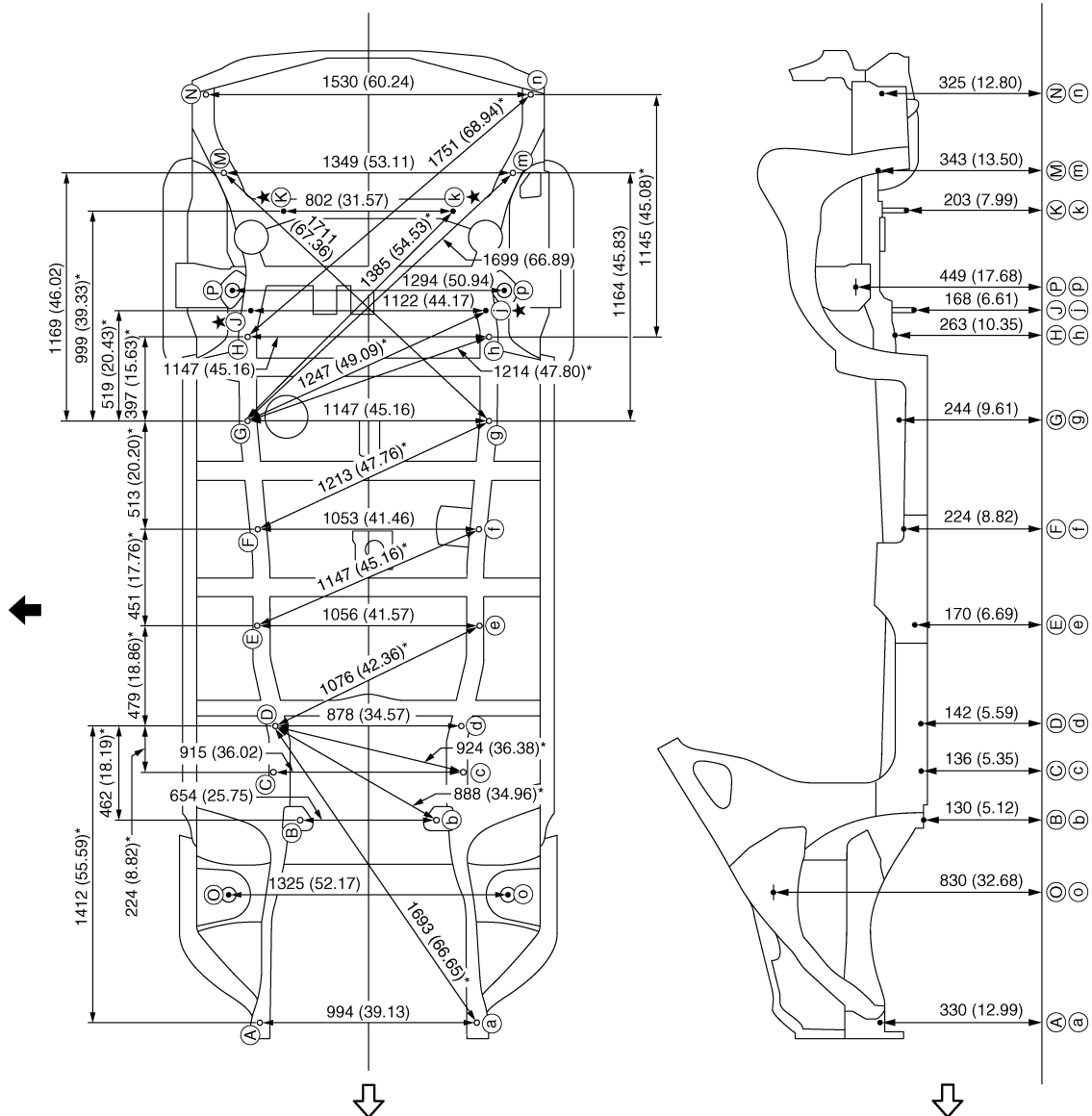
### Underbody

INFOID:000000009648891

### MEASUREMENT

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.



A  
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JSKIA2486GB

# BODY ALIGNMENT

## < SERVICE DATA AND SPECIFICATIONS (SDS)

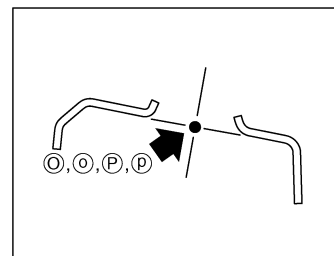
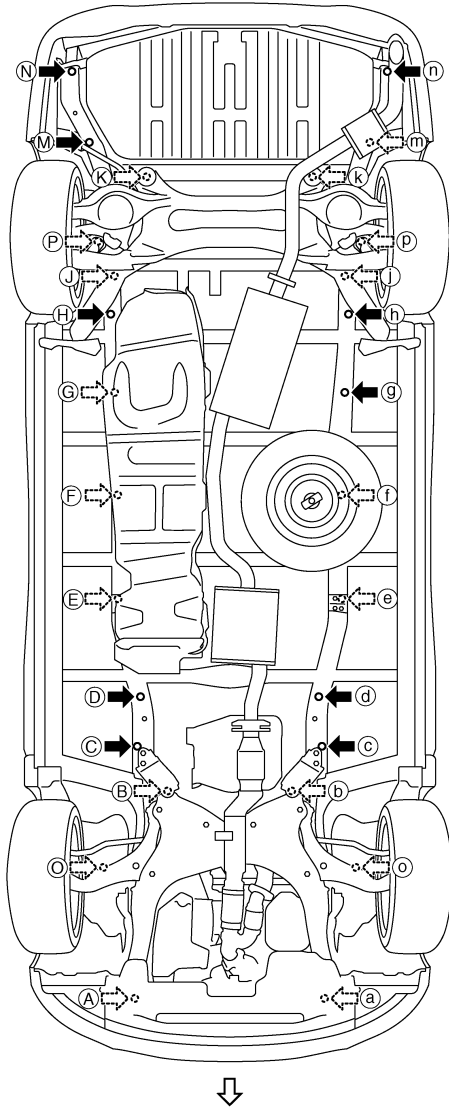
Unit: mm (in)

↔: Vehicle front

←: Vehicle left side

★: Bolt head

### MEASUREMENT POINTS



JSKIA2487ZZ

↔: Vehicle front

# BODY ALIGNMENT

## < SERVICE DATA AND SPECIFICATIONS (SDS)

Unit: mm (in)

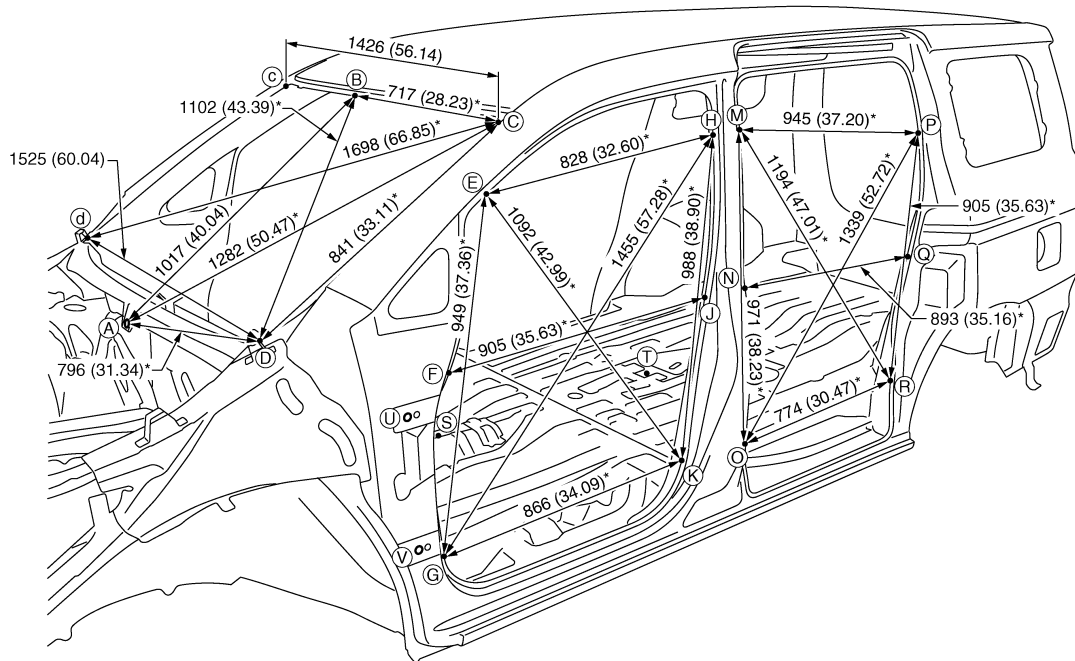
Points	Coordinates			Remarks	Points	Coordinates			Remarks
	X	Y	Z			X	Y	Z	
A, a	±497.0 (±19.567)	-555.5 (-21.870)	330.0 (12.992)	Hole φ17 (0.67)	J, j	±561.0 (±22.087)	2783.0 (109.567)	167.9 (6.610)	Bolt head
B, b	±327.0 (±12.874)	395.0 (15.551)	130.0 (5.118)	B: Hole φ29 (1.14) b: Hole 33×29 (1.30×1.14)	K, k	±401.0 (±15.787)	3253.0 (128.071)	203.1 (7.996)	Bolt head
C, c	±457.7 (±18.020)	620.0 (24.409)	136.0 (5.354)	Hole φ10 (0.39)	M	681.0 (26.811)	3430.0 (135.039)	342.5 (13.484)	Hole φ16 (0.63)
D, d	±439.2 (±17.291)	842.8 (33.181)	141.8 (5.583)	Hole φ16 (0.63)	m	-668.0 (-26.299)	3426.0 (134.882)	342.5 (13.484)	Hole φ16 (0.63)
E, e	±528.0 (±20.787)	1312.3 (51.665)	170.1 (6.697)	Hole φ17 (0.67)	N, n	±765.0 (±30.118)	3794.5 (149.389)	324.5 (12.776)	Hole 18×16 (0.71×0.63)
F, f	±526.5 (±20.728)	1760.0 (69.291)	223.7 (8.807)	Hole φ16 (0.63)	O	662.7 (26.090)	52.0 (2.047)	830.3 (32.689)	Hole φ59 (2.32)
G, g	±573.5 (±22.579)	2270.0 (89.370)	244.2 (9.614)	Hole 18×16 (0.71×0.63)	o	-662.7 (-26.090)	54.4 (2.142)	830.1 (32.681)	Hole φ59 (2.32)
H, h	±573.5 (±22.579)	2667.0 (105.000)	263.0 (10.354)	Hole φ16 (0.63)	P, p	±646.8 (±25.465)	2891.0 (113.819)	448.6 (17.661)	Hole φ64 (2.52)

### Passenger Compartment

INFOID:000000009648892

### MEASUREMENT

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



Unit: mm (in)

JSKIA2488GB

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# BODY ALIGNMENT

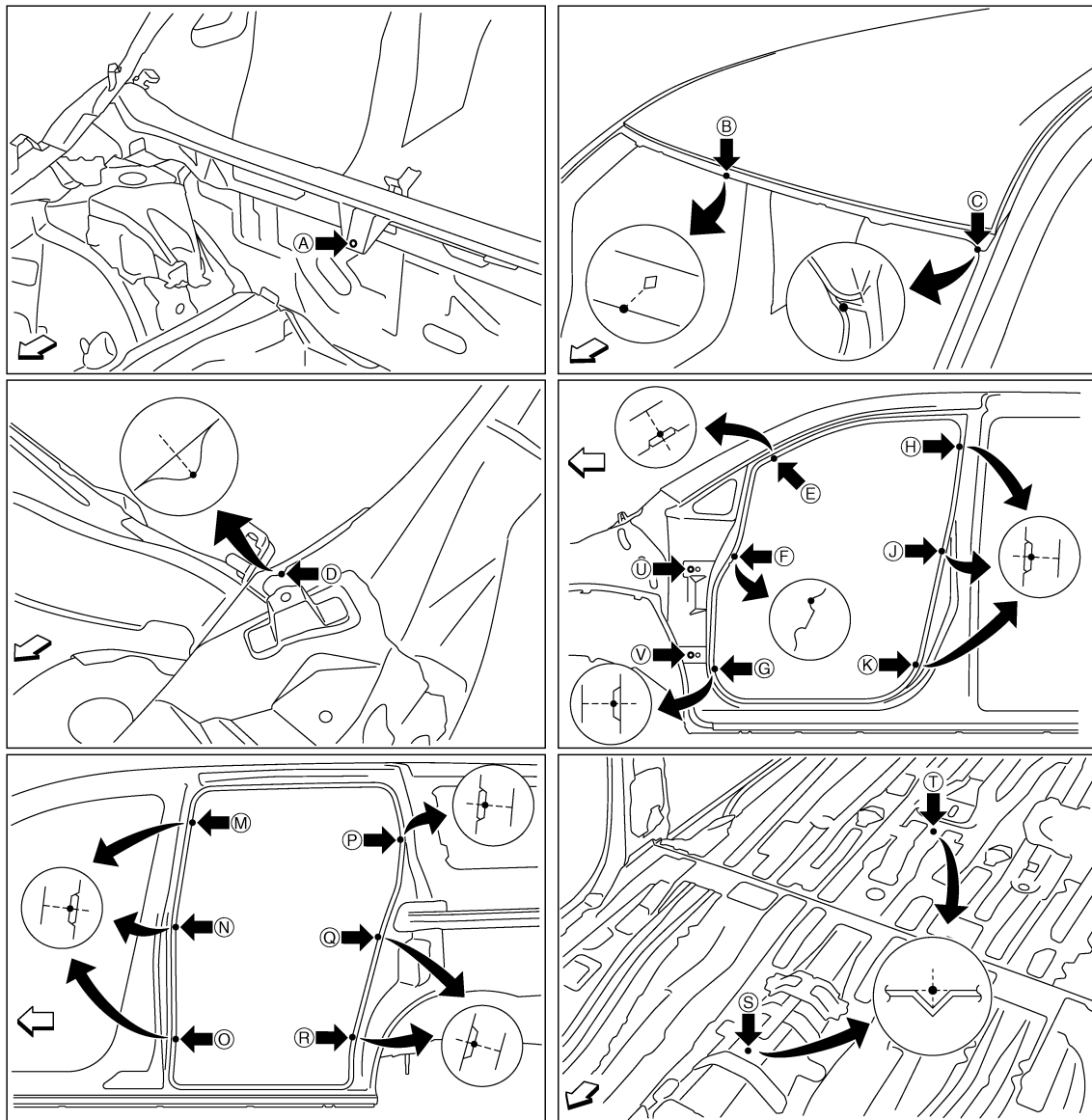
## < SERVICE DATA AND SPECIFICATIONS (SDS)

«The others»

Unit: mm (in)

Point	Dimension	Memo	Point	Dimension	Memo	Point	Dimension	Memo	Point	Dimension	Memo
E - e	1548 (60.94)		J - j	1680 (66.14)		P - p	1526 (60.08)		T - N	1072 (42.20)*	
E - g	1903 (74.92)*		K - k	1760 (69.29)		P - r	1885 (74.21)*		T - O	943 (37.13)*	
E - h	1747 (68.78)*		M - m	1484 (58.43)		Q - q	1675 (65.94)		T - P	1385 (54.53)*	
E - k	1979 (77.91)*		M - o	1878 (73.94)*		R - r	1793 (70.59)		T - Q	1125 (44.29)*	
F - f	1648 (64.88)		M - p	1777 (69.96)*		S - E	1260 (49.61)*		T - R	994 (39.13)*	
F - j	1895 (74.61)*		M - r	2021 (79.57)*		S - F	1047 (41.22)*		U - u	1792 (70.55)	
G - g	1758 (69.21)		N - n	1679 (66.10)		S - G	975 (38.39)*		U - H	1293 (50.91)*	
G - h	2192 (86.30)*		N - q	1900 (74.80)*		S - H	1454 (57.24)*		U - K	1041 (40.98)*	
G - k	1961 (77.20)*		O - o	1741 (68.54)		S - J	1168 (45.98)*		V - v	1824 (71.81)	
H - h	1529 (60.20)		O - p	2109 (83.03)*		S - K	993 (39.09)*		V - H	1485 (58.46)*	
H - k	1915 (75.39)*		O - r	1929 (75.94)*		T - M	1308 (51.50)*		V - K	960 (37.80)*	

## MEASUREMENT POINTS



JSKIA2489ZZ



# BODY ALIGNMENT

## < SERVICE DATA AND SPECIFICATIONS (SDS)

↶: Vehicle front

Unit: mm (in)

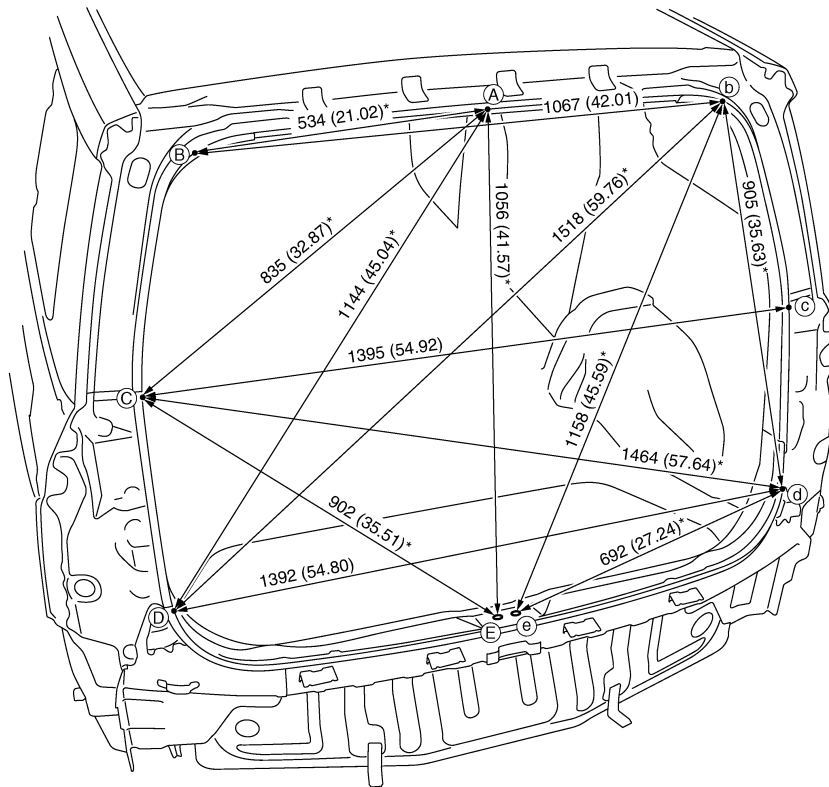
Point	Material	Point	Material
A	Center cowl top hole center of center positioning mark $\phi 7$ (0.28)	H, h, J, j, K, k, M, M, N, n, O, o	Center pillar indent
B	Roof flange end of center positioning mark	P, p, Q, q, R, r	Rear fender indent
C, c	Outer side body joggle	S	Front floor positioning mark of center positioning mark
D, d	Outer side body indent	T	Rear floor front positioning mark of center positioning mark
E, e, F, f, G, g	Front pillar indent	U, u, V, v	Door hinge installing hole center $\phi 12$ (0.47)

### Rear Body

INFOID:000000009648893

### MEASUREMENT

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



JSKIA2490GB

Unit: mm (in)

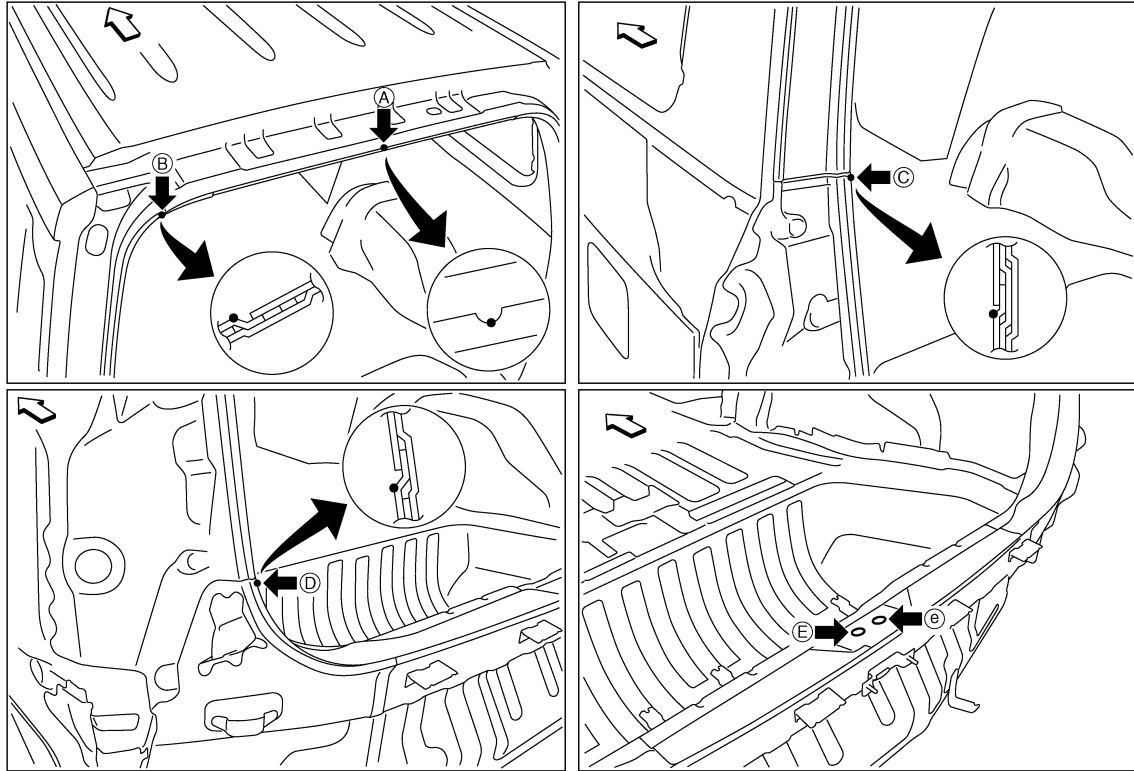
### MEASUREMENT POINTS

A  
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# BODY ALIGNMENT

< SERVICE DATA AND SPECIFICATIONS (SDS)



JSKIA2491ZZ

↶: Vehicle front

Unit: mm (in)

Point	Material	Point	Material
A	Roof flange end of center positioning mark	D, d	Upper rear panel joggle
B, b	Back pillar main joggle	E, e	Back door striker installing hole center $\phi 16$ (0.63)
C, c	Rear combination lamp base joggle		

# LOCATION OF PLASTIC PARTS

< SERVICE DATA AND SPECIFICATIONS (SDS)

## LOCATION OF PLASTIC PARTS

### Precautions for Plastics

INFOID:000000009648894

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.	—
AES	Acrylonitrile Ethylene Styrene	80 (176)	↑	—
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:**

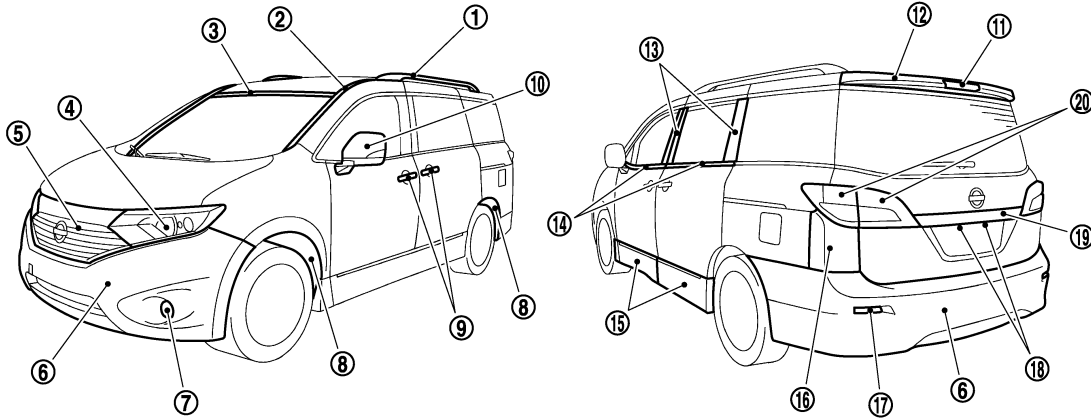
- When repairing and painting a portion of the body adjacent to plastic parts, consider their characteristics (influence of heat and solvent) and remove them if necessary or take suitable measures to protect them.
- Plastic parts should be repaired and painted using methods suiting the materials' characteristics.

# LOCATION OF PLASTIC PARTS

< SERVICE DATA AND SPECIFICATIONS (SDS)

## Location of Plastic Parts

INFOID:000000009648895



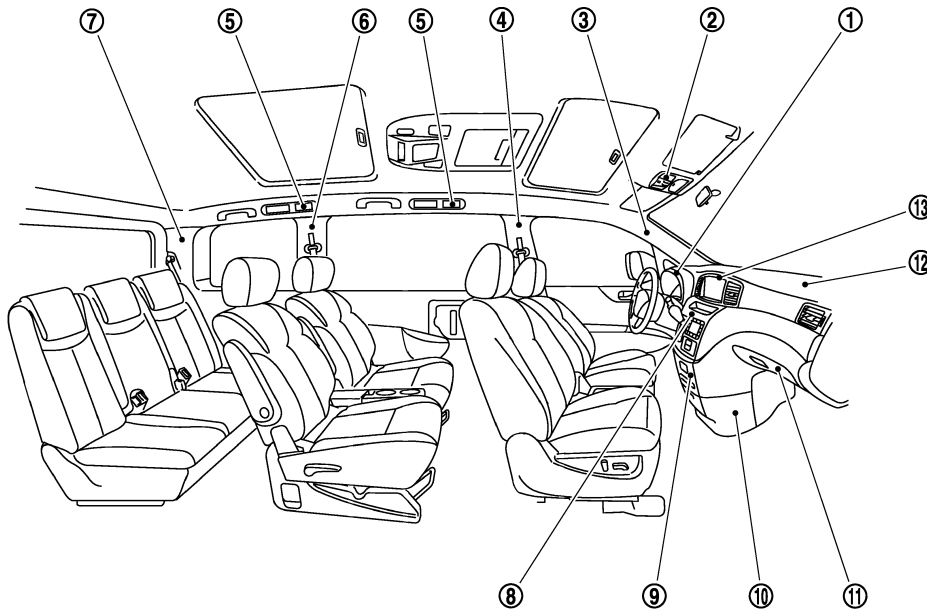
JSKIA2492ZZ

Component		Material	Component		Material		
1	Roof rack	Front cover	PC + PET	11	High mount stop lamp	Lens	PMMA
		Rear cover	ABS			Housing	ABS
		Pipe	Aluminum	12	Rear spoiler	PC + PET	
2	Roof side molding	PVC + Stainless		13	Door sash cover	Front door	PMMA
	Lower side molding	ASA					Slide door
3	Windshield molding	EPDM				Slide door outer corner cover	PMMA
4	Front combination lamp	Lens	PC	14	Door outside molding	PVC + Stainless	
		Housing	PP	15	Protect molding	ASA	
5	Front grille	ABS		16	Sight shield assembly	ABS	
	Upper molding	ABS		17	Reflex reflector	Lens	PMMA
	Lower molding	ABS					Housing
6	Bumper fascia	PP + EPM		18	License plate lamp	Lens	PC
7	Front fog lamp	Lens	Glass				Housing
		Housing	PBT + ASA + Glass fiber		19	Back door finisher	ABS

# LOCATION OF PLASTIC PARTS

## < SERVICE DATA AND SPECIFICATIONS (SDS)

Component			Material	Component		Material	
8	Front fender protector		PP	20	Rear combination lamp (Rear fender)	Lens	PMMA
	Rear bumper closing		PP			Housing	ASA
9	Door outside handle	Front door	PC + PET + Glass fiber		Rear combination lamp (Back door)	Lens	PMMA
		Grip body				PC + ABS	Housing
	Slide door		PC + ABS				
10	Door outside mirror		Housing	ASA			
			Base	ASA			
			Base cover	ABS			
			Mirror cover	ABS			
	Side turn signal lamp		Lens	PMMA			
			Housing	ABS			



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Component			Material	Component		Material		
1	Cluster lid A		ABS	8	Cluster lid C		PC + ABS	
2	Map lamp		Lens	PC	9	Instrument lower panel center		PP + EPDM
			Housing					
3	Front pillar garnish		PP	10	Instrument lower cover		PP	
4	Center pillar garnish		PP	11	Glove box		PP + EPDM	
5	Personal lamp		Lens					PC
			Housing					PP
6	Rear pillar garnish		PP	12	Instrument panel		Skin	TPU
7	Back pillar garnish		PP				Pad	PUR
							Core	PP + EPDM
				13	Cluster lid D		PC + ABS	