SECTION BRM
BODY REPAIR

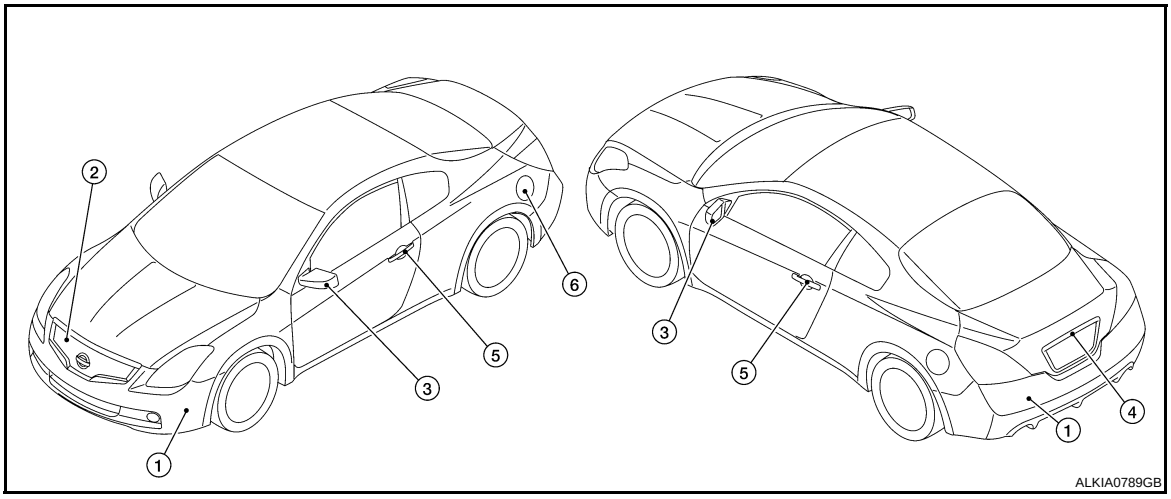
CONTENTS

FEATURES OF NEW MODEL

BODY EXTERIOR PAINT COLOR

Body Exterior Paint Color

INFOID:0000000001345578



Component			Color code	A20	B54	K12	K50	KH3	QX3	W40
			Description	Red	Blue	Silver	Dark Grey	Black	White	Medium Grey
			Paint type	2M	2M	2M	2M	2S	3P	2M
			Hard clear coat	×	×	×	-	-	-	-
1	Bumper fascia		Body color	A20	B54	K12	K50	KH3	QX3	W40
2	Front grille	Surround	Body color	A20	B54	K12	K50	KH3	QX3	W40
		Slats	Black	—	—	—	—	—	—	—
		Base	chromium-plate	Cr	Cr	Cr	Cr	Cr	Cr	Cr
3	Door outside mirror	Case	Body color	A20	B54	K12	K50	KH3	QX3	W40
		Base	Black	—	—	—	—	—	—	—
4	License plate finisher		Body color	A20	B54	K12	K50	KH3	QX3	W40
5	Door outside handle		Body color	A20	B54	K12	K50	KH3	QX3	Cr
6	Fuel filler lid		Body color	A20	B54	K12	K50	KH3	QX3	W40

M=Metallic, S= Solid, 2S= Solid and Clear, 2P= 2-stage Pearl, 3P= 3-Stage pearl, PM=Pearl metallic, Black is solvent based, all others are water based.

PRECAUTION

HANDLING PRECAUTIONS FOR PLASTICS

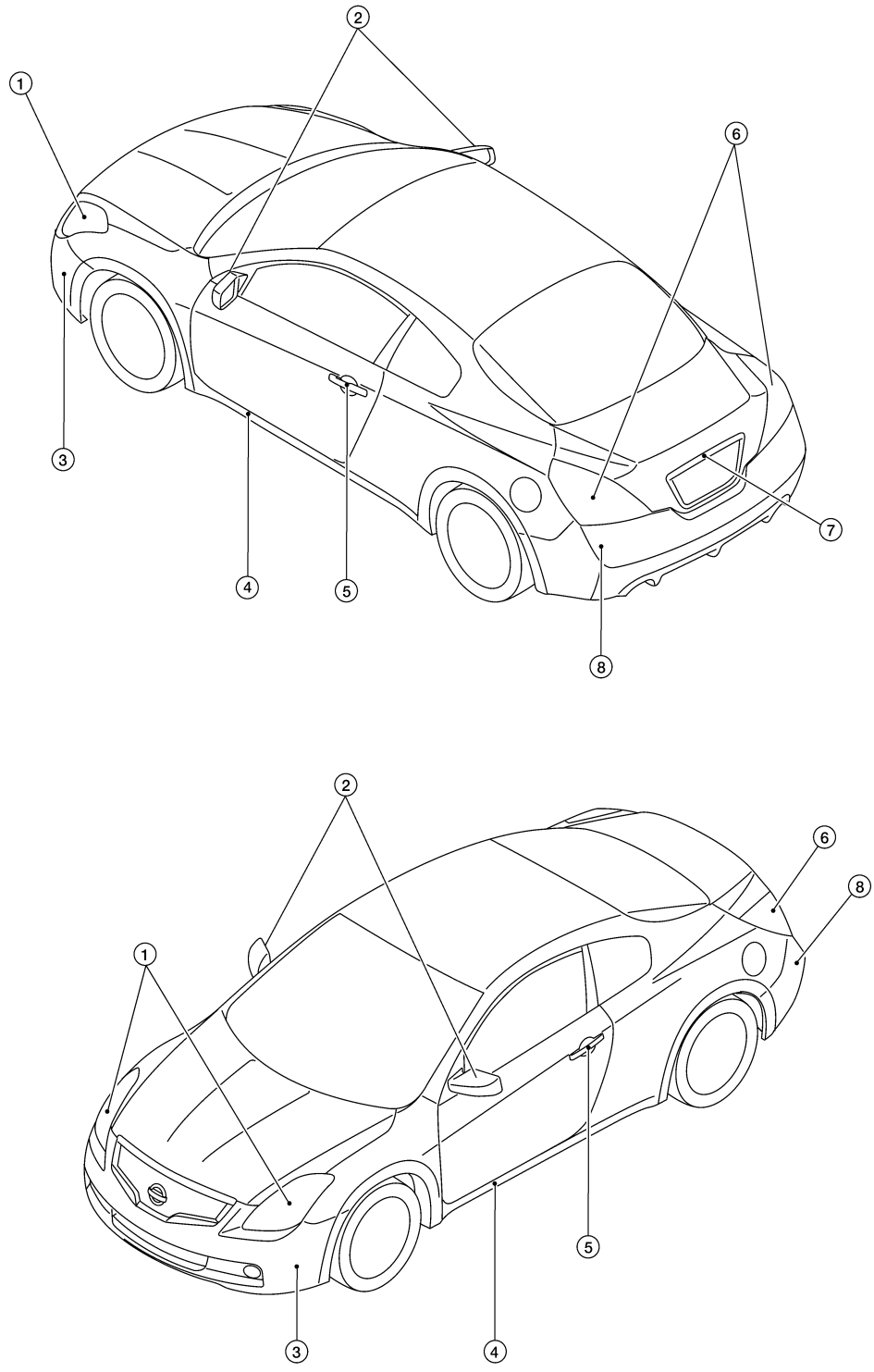
Precautions For Plastics

INFOID:0000000001345579

Abbre-viation	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) co-polymer	80(176)	Same as above.	Flammable
TPO/ TPR	Thermoplastic Olefine/ Thermoplastic rubber	80(176)	Same as above.	Flammable
PP	Polypropylene	90(194)	Same as above.	Flammable, avoid bat-tery 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.	
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.	
PPC	Polypropylene Composite	115 (239)	Same as above	Flammable
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 (Nylon)	140(284)	Same as above.	Avoid immersing in wa-ter.
PBT	Poly Butylene Terephthalate	140(284)	Same as above.	
PET	Polyester	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.

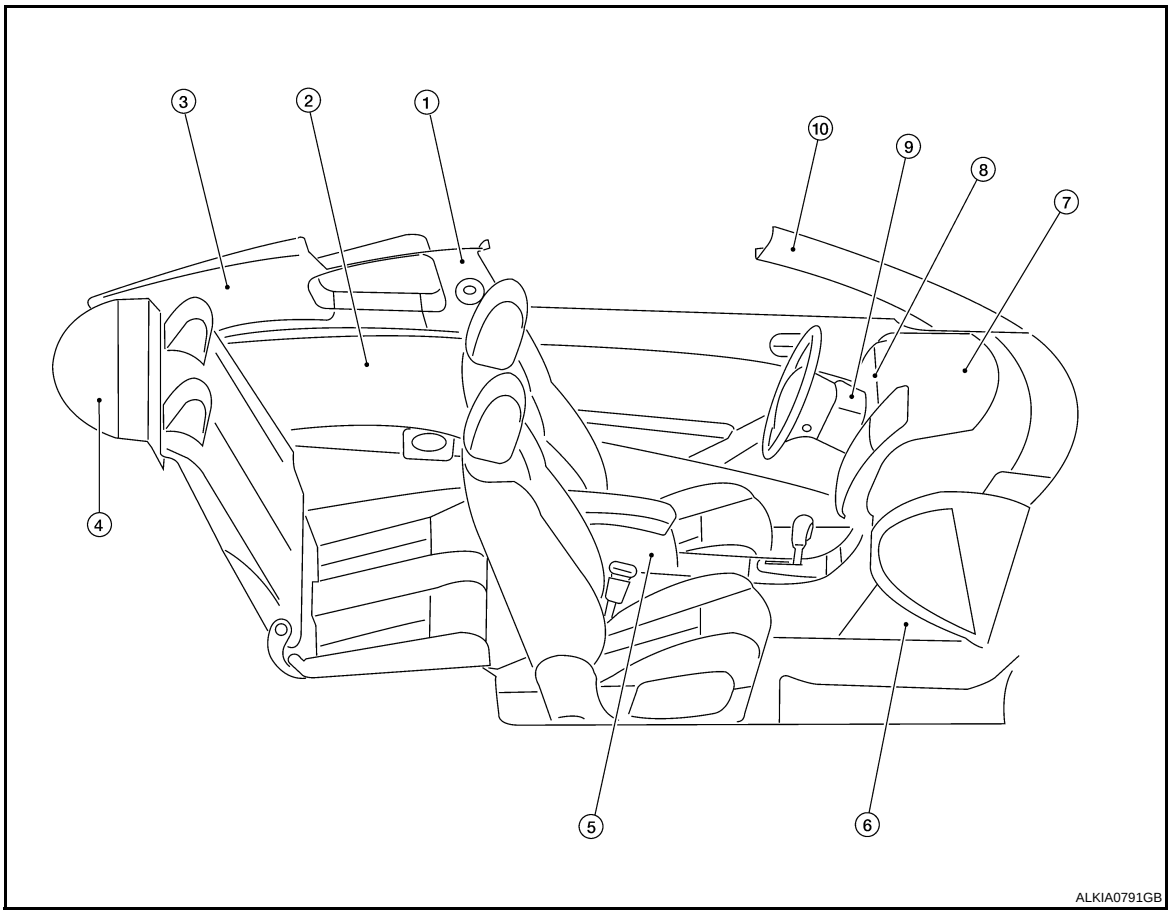
LOCATION OF PLASTIC PARTS



ALKIA0790GB

Item	Component		Abbreviation	Material
1.	Front combination lamp	Lens	PC	Polycarbonate
		Housing	PP	Polypropylene
2.	Door Mirror	Case	ASA	Acrylonitrile Styrene Acrylate
		Skull cap	ABS	Acrylonitrile Butadiene Styrene

Item	Component		Abbreviation	Material
3.	Front Fascia		PP + EPM	Polypropylene + Ethylene Propylene (Diene) copolymer
4.	Mudguard		TPO	Thermoplastic Olefine
5.	Outside door handle	Grip	PC	Polycarbonate
		Escutcheon	PA	Polyamide (Nylon)
6.	Rear combination lamp	Lens	PMMA	Poly Methyl Methacrylate
		Housing	ABS	Acrylonitrile Butadiene Styrene
7.	Trunk lid finisher		ABS + PC	Acrylonitrile Butadiene Styrene + Polycarbonate
8.	Rear fascia		PP + EPM	Polypropylene + Ethylene Propylene (Diene) copolymer



Item	Component		Abbreviation	Material
1.	Lock pillar upper trim		PP	Polypropylene
2.	Rear side finisher		PP	Polypropylene
3.	Rear pillar trim		PP	Polypropylene
4.	Rear parcel shelf finisher		PP	Polypropylene
5.	Center Console	Pocket	ABS	Acrylonitrile Butadiene Styrene + Polycarbonate
		Lid Substrate	PPC	Polypropylene Composite
		Lid slide plate	POM	Poly Oxymethylene
6.	Lower instrument cover		PP	Polypropylene
7.	Instrument panel		PP	Polypropylene

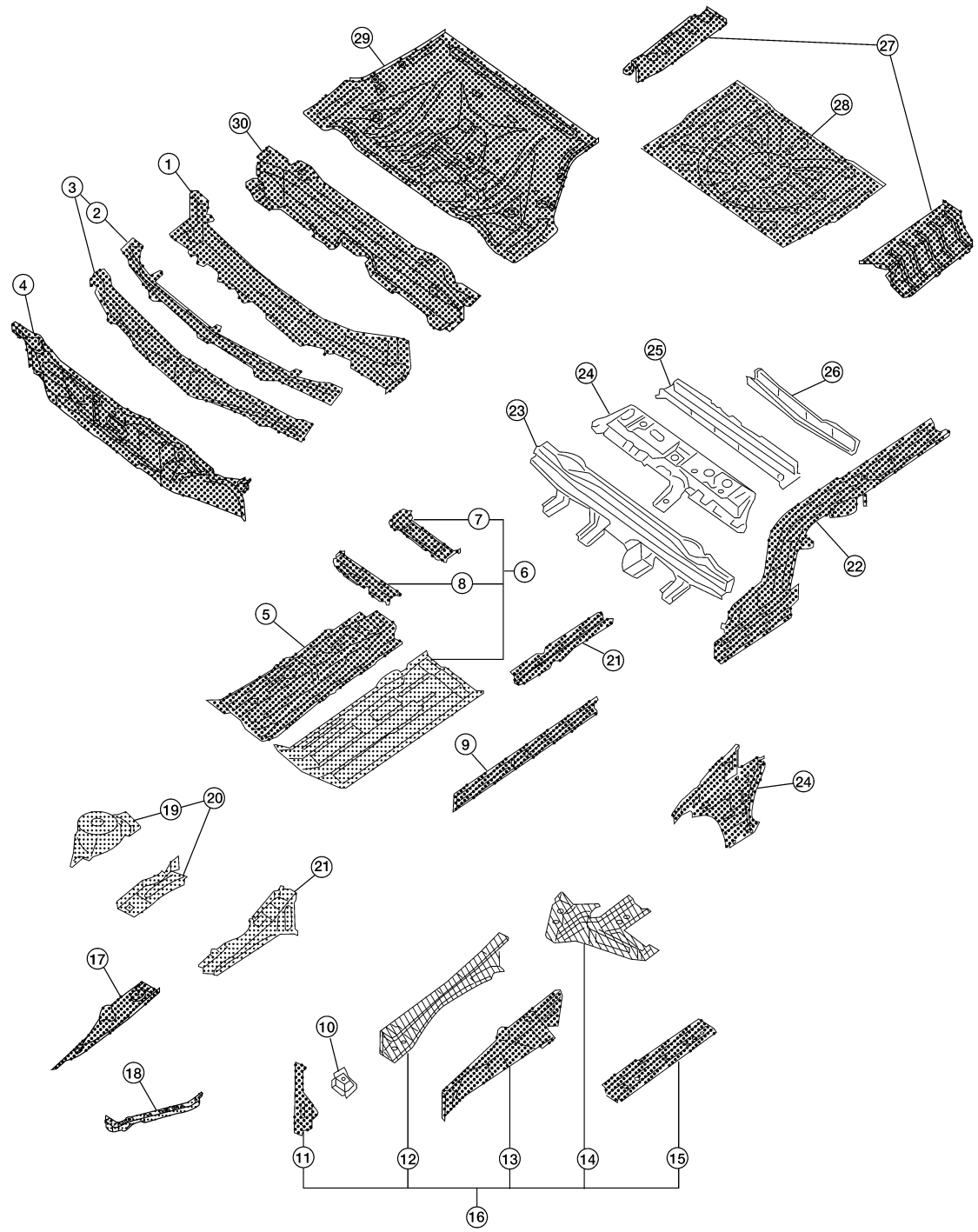
Item	Component	Abbreviation	Material
8.	Cluster lid A	PP	Polypropylene
9.	Steering column covers	PP	Polypropylene
10.	Front pillar garnish	PP	Polypropylene

ON-VEHICLE REPAIR

BODY COMPONENT PARTS

Underbody Component Parts

INFOID:0000000001345580



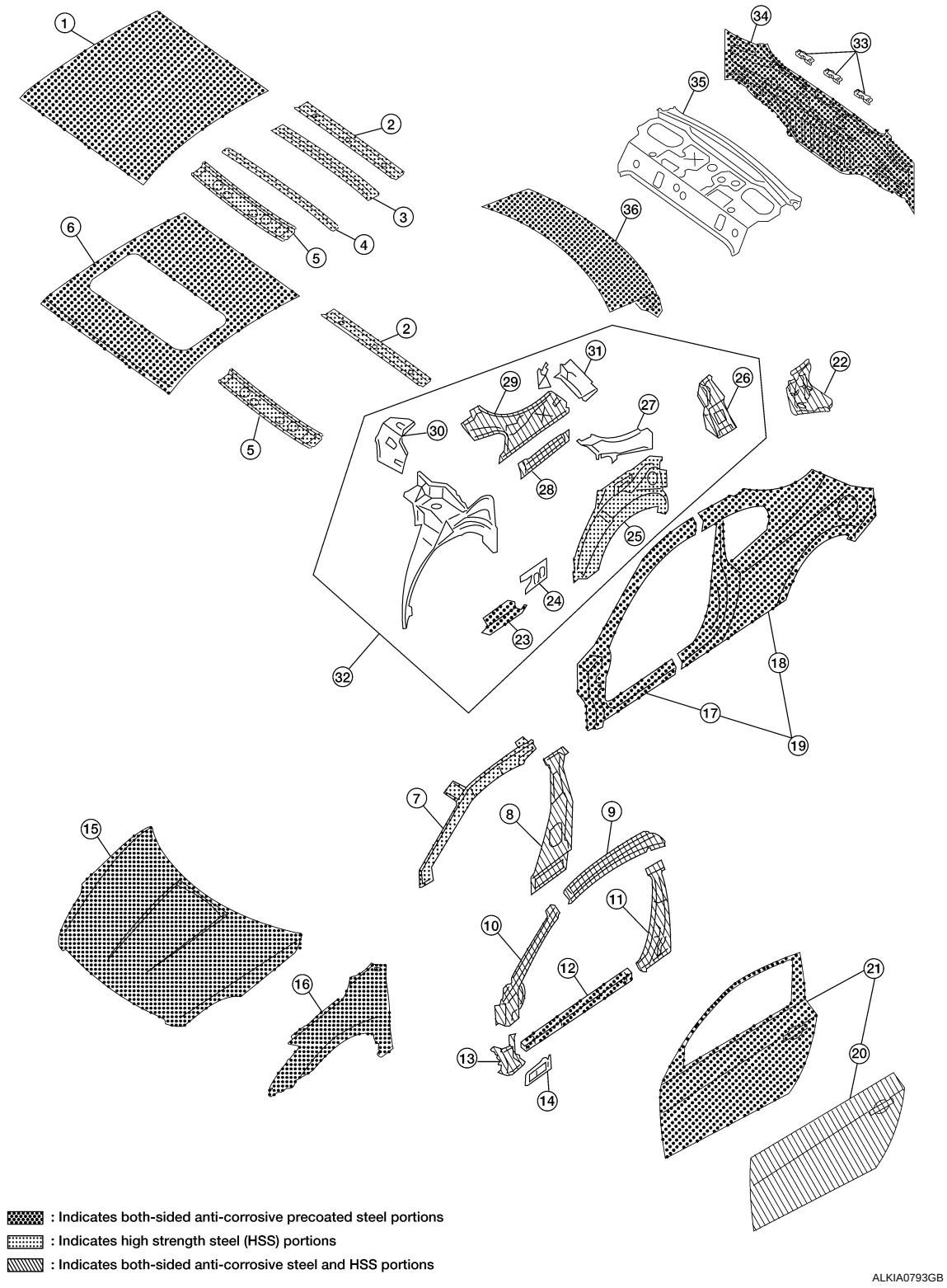
: Indicates both-sided anti-corrosive precoated steel portions
: Indicates high strength steel (HSS) portions
: Indicates both-sided anti-corrosive steel and HSS portions

ALKIA0792GB

1. Upper dash assembly
2. Wiper bracket
3. Cowl top assembly
4. Lower dash assembly
5. Center floor assembly
6. Front floor assembly (RH,LH)
7. Rear crossmember (RH, LH)
8. Front crossmember (RH, LH)
9. Inner sill (RH, LH)
10. Front suspension member front nut plate (RH, LH)
11. Radiator core support side (RH, LH)
12. Front side member front assembly (RH, LH)
13. Front side member closing plate (RH, LH)
14. Front side member assembly (RH, LH)
15. Front side member center extension (RH, LH)
16. Front side member (RH, LH)
17. Hoodledge connector (RH, LH)
18. Radiator core support upper (RH, LH)
19. Strut tower (RH, LH)
20. Strut tower assembly (RH, LH)
21. Front side member rear extension (RH. LH)
22. Rear side member assembly (RH, LH)
23. Rear seat crossmember lower
24. Rear seat crossmember upper
25. Rear center crossmember
26. Rear floor rear crossmember
27 Rear floor rear side
28. Rear floor rear
29. Rear floor front
30. Rear floor front extension

Body Component Parts

INFOID:0000000001345581



1. Roof panel assembly
2. Rear roof rail assembly
3. Center roof bow
4. Front roof bow
5. Front roof rail assembly
6. Sun roof panel assembly
7. Front pillar inner reinforcement (RH, LH)
8. Inner lock pillar (RH, LH)
9. Outer upper roof side rail (RH, LH)

10. Hinge pillar upper reinforcement (RH, LH)
11. Lock pillar reinforcement (RH, LH)
12. Outer sill reinforcement (RH, LH)
13. Hinge pillar lower reinforcement (RH, LH)
14. Front pillar lower reinforcement (RH, LH)
15. Hood assembly
16. Front fender (RH, LH)
17. Front portion of body side outer (RH, LH)
18. Rear fender portion of body side outer (RH, LH)
19. Body side outer (RH, LH)
20. Front door outer (RH, LH)
21. Front door assembly (RH, LH)
22. Rear combination lamp base (RH, LH)
23. Rear outer sill reinforcement (RH, LH)
24. Rear wheel outer front extension (RH, LH)
25. Rear wheel outer RH, LH)
26. Rear pillar inner reinforcement B (RH, LH)
27. Rear pillar inner reinforcement A (RH, LH)
28. Inner rear pillar lower (RH, LH)
29. Rear pillar inner (RH, LH)
30. Rear seat back side support (RH, LH)
31. Rear side upper reinforcement (RH, LH)
32. Rear wheel inner reinforcement assembly (RH, LH)
33. Rear bumper fascia brackets
34. Rear panel assembly
35. Parcel shelf assembly
36. Trunk lid assembly

CORROSION PROTECTION

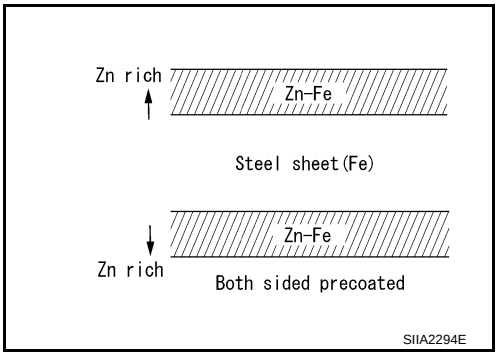
Description

INFOID:0000000001345582

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.



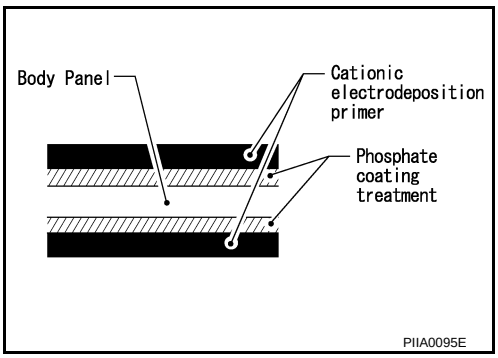
Nissan Genuine Service Parts are fabricated from galvannealed steel. Therefore, it is recommended that GENUINE NISSAN PARTS or equivalent be used for panel replacement to maintain the anti-corrosive performance built into the vehicle at the factory.

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.



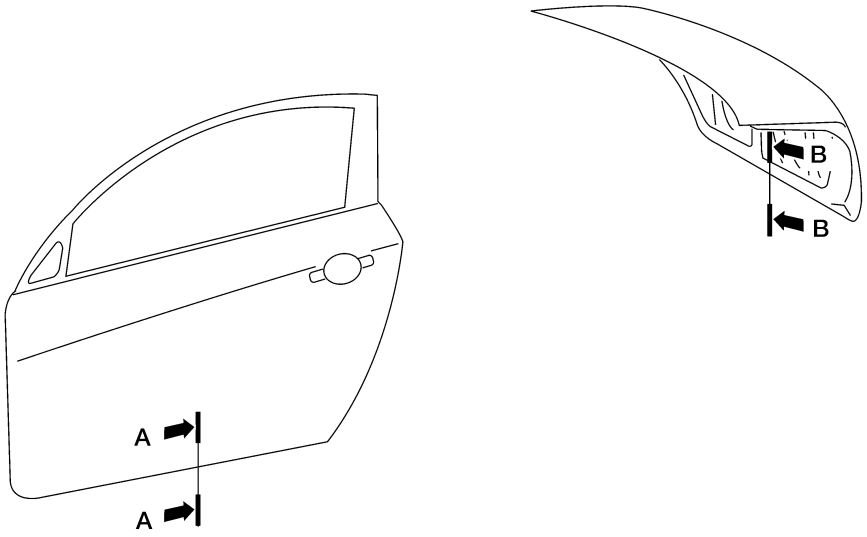
Nissan Genuine Service Parts are also treated in the same manner. Therefore, it is recommended that GENUINE NISSAN PARTS or equivalent be used for panel replacement to maintain anti-corrosive performance built into the vehicle at the factory.

Anti-Corrosive Wax

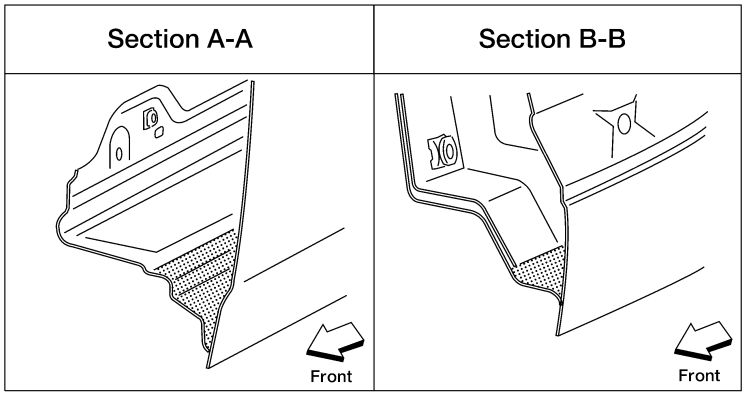
INFOID:0000000001345583

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.



: Indicates anti-corrosive wax coated portions



ALKIA0794GB

Undercoating

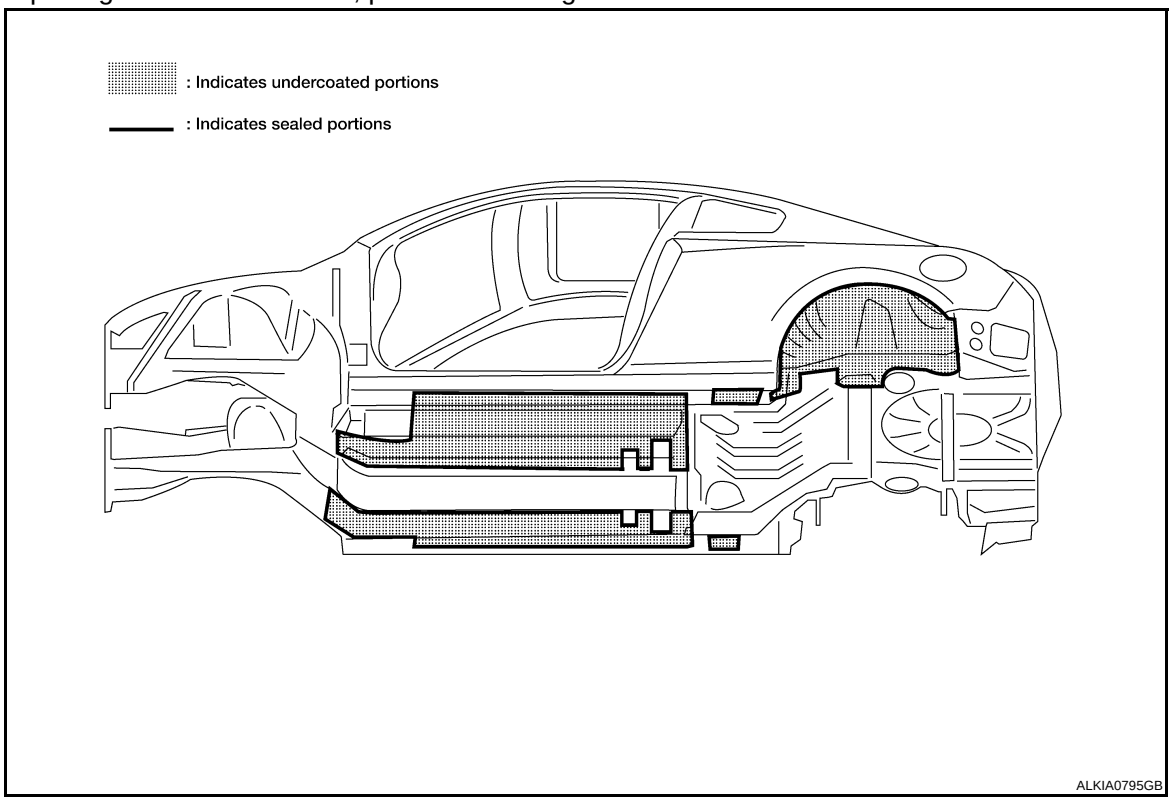
INFOID:0000000001345584

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 preventive, soundproof, vibration-proof, shock-resistant, adhesive, and durable.

Precautions in Undercoating

1. Do not apply undercoating to any place unless specified (such as the areas above the muffler and three way catalyst which are subjected to heat).
2. Do not undercoat the exhaust pipe or other parts which become hot.
3. Do not undercoat rotating parts.
4. Apply bitumen wax after applying undercoating.

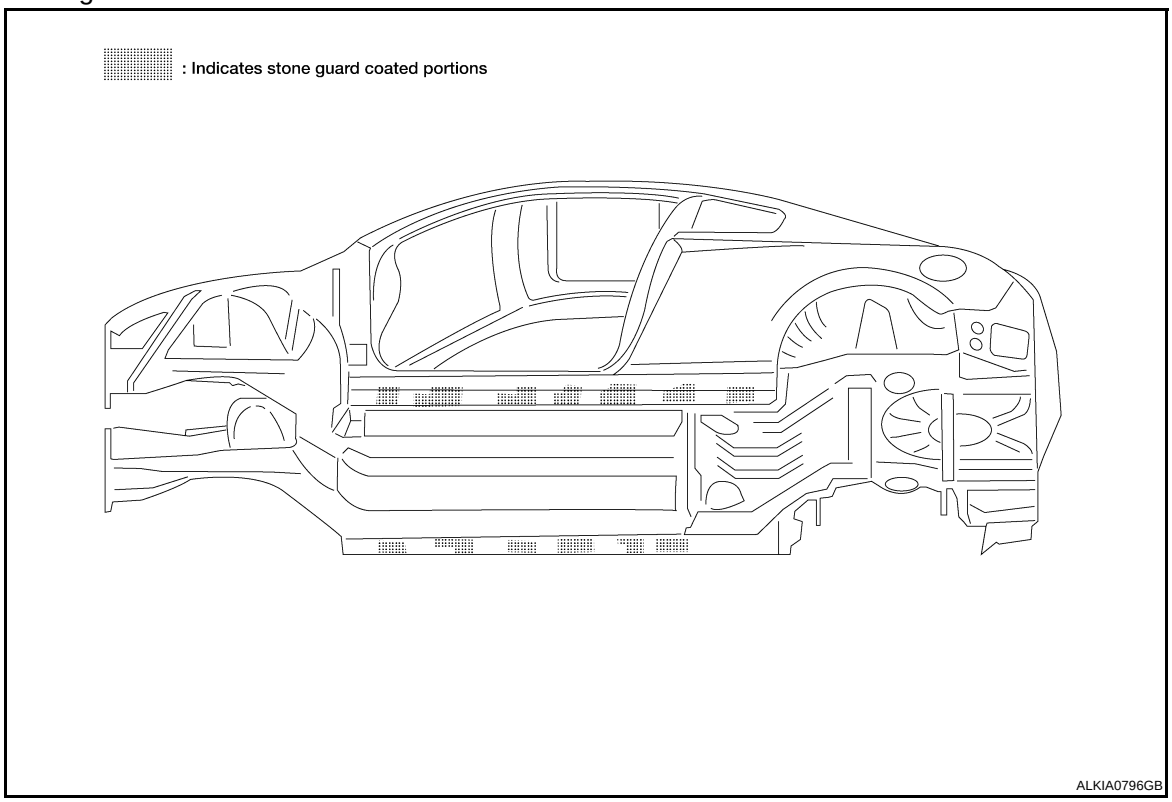
5. After putting seal on the vehicle, put undercoating on it.



Stone Guard Coat

INFOID:0000000001345585

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.

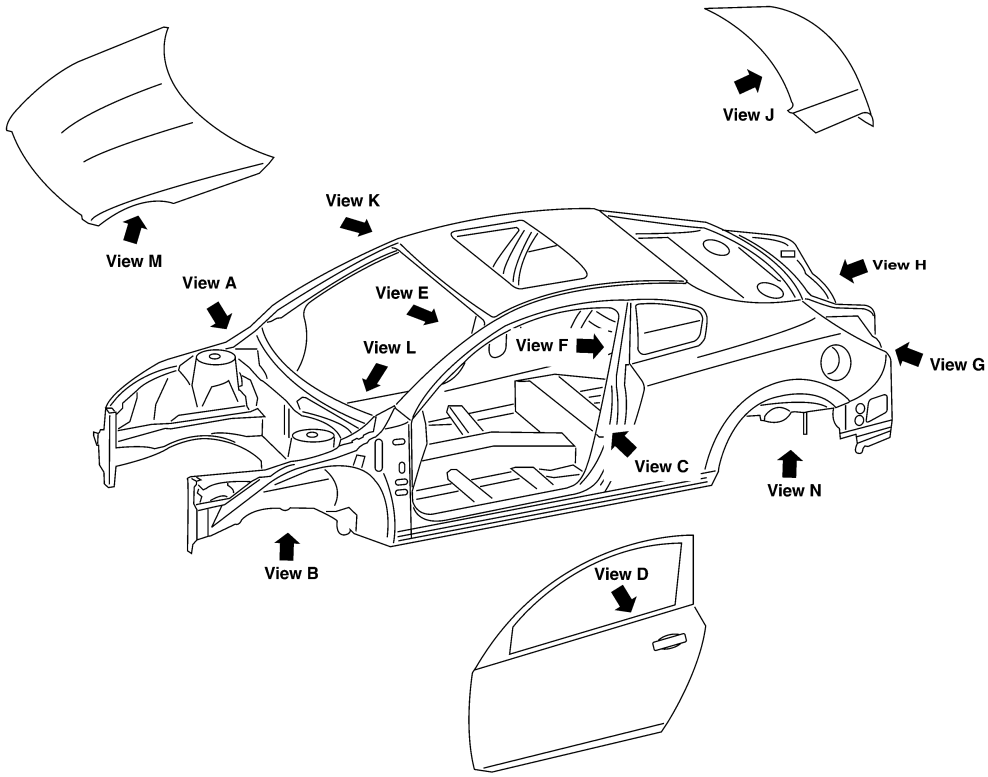


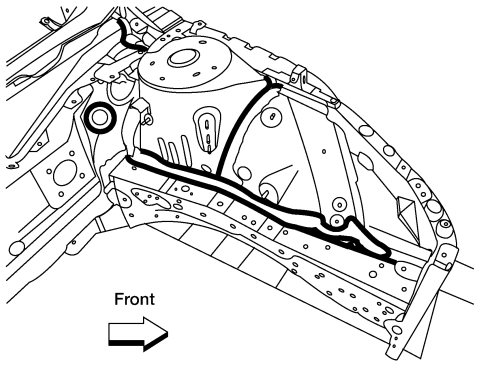
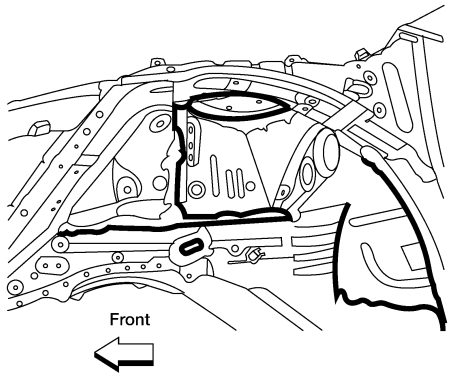
BODY SEALING

Description

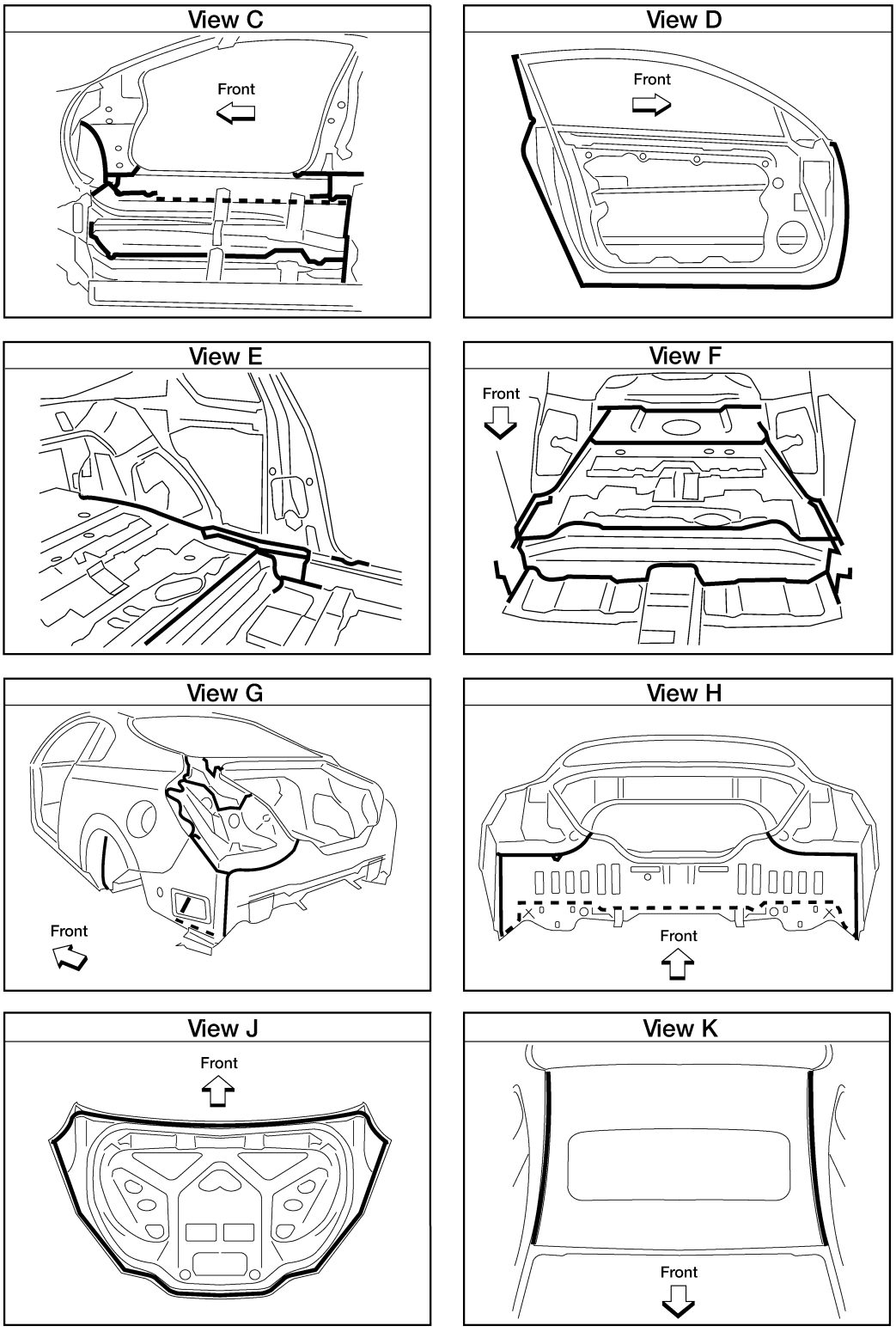
INFOID:0000000001345586

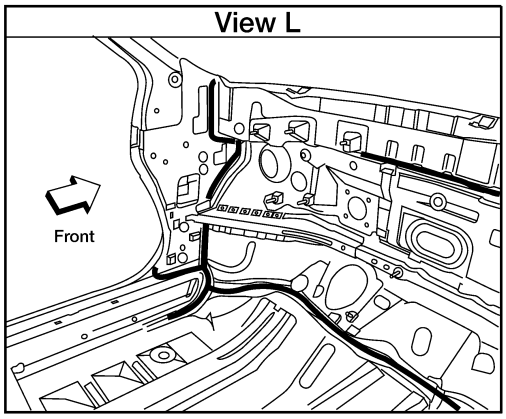
The following figure shows the areas which are sealed at the factory. Sealant which has been applied to these areas should be smooth and free from cuts or gaps. Care should be taken not to apply an excess amount of sealant and not to allow other unaffected parts to come into contact with the sealant.

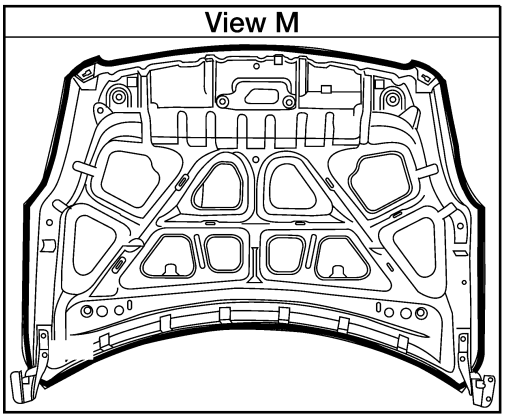


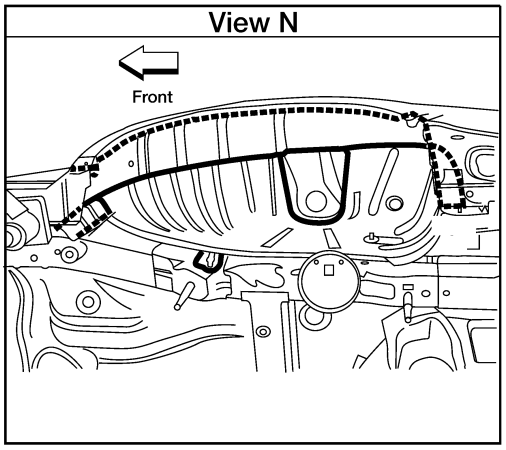
View A	View B
	

ALKIA0797GB


View C
Front
View D
Front
View E
View F
Front
View G
Front
View H
Front
View J
Front
View K
Front
ALKIA0798GB





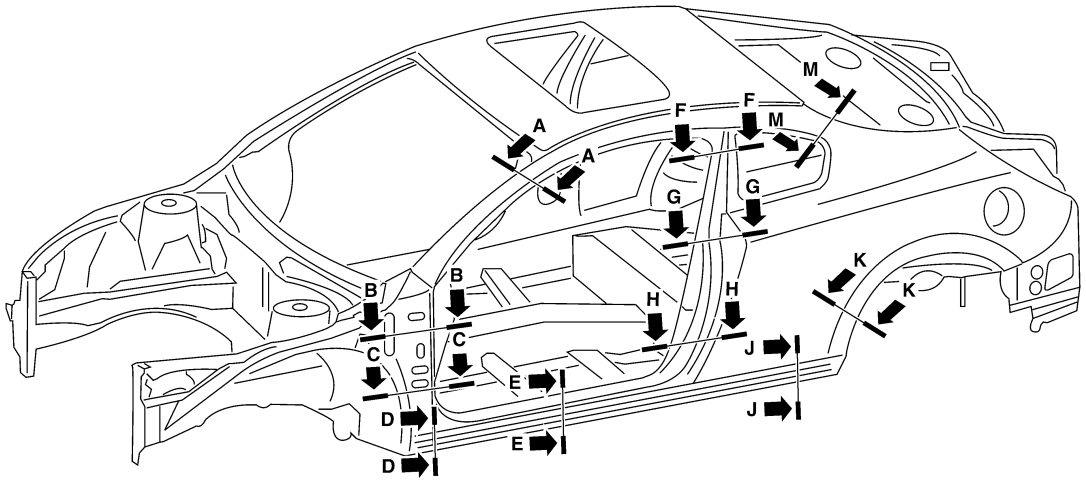


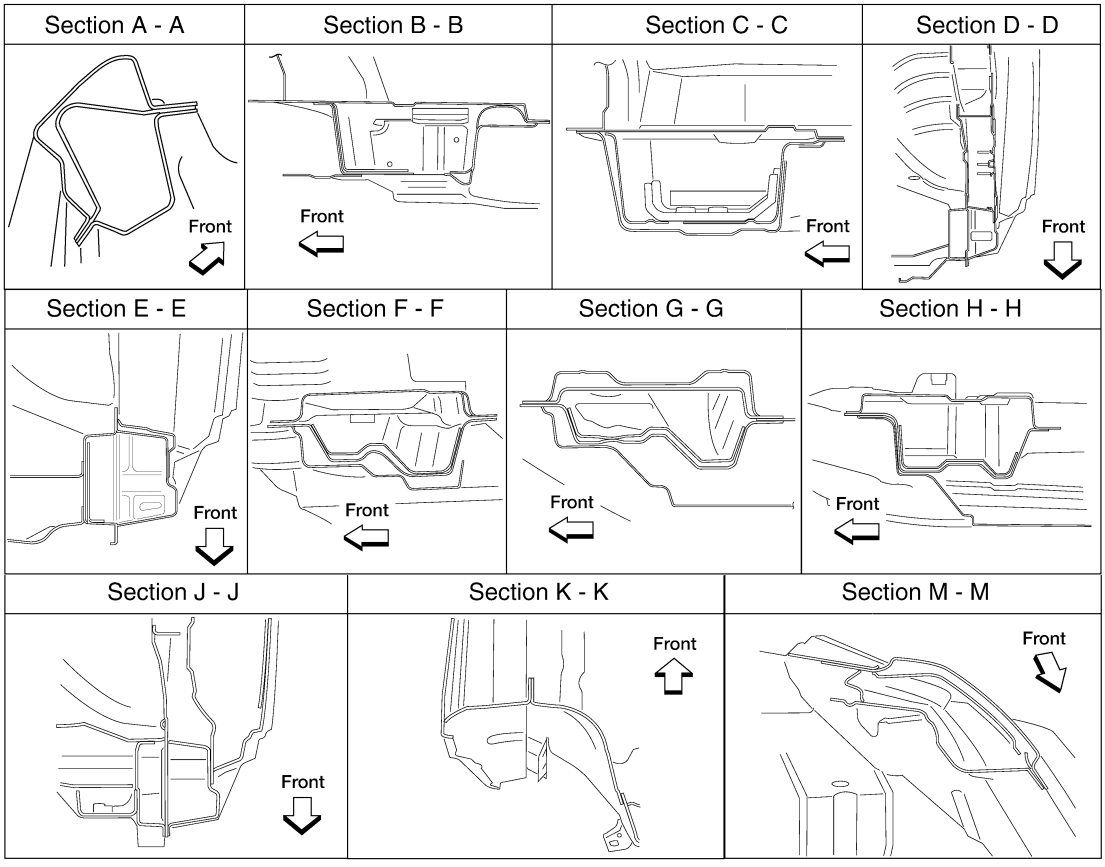
AWKIA0002GB

BODY CONSTRUCTION

Body Construction

INFOID:0000000001345587





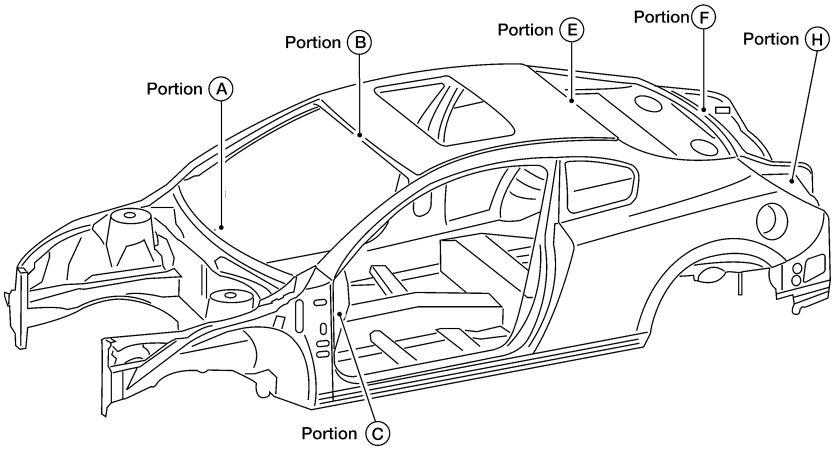
ALKIA0799GB

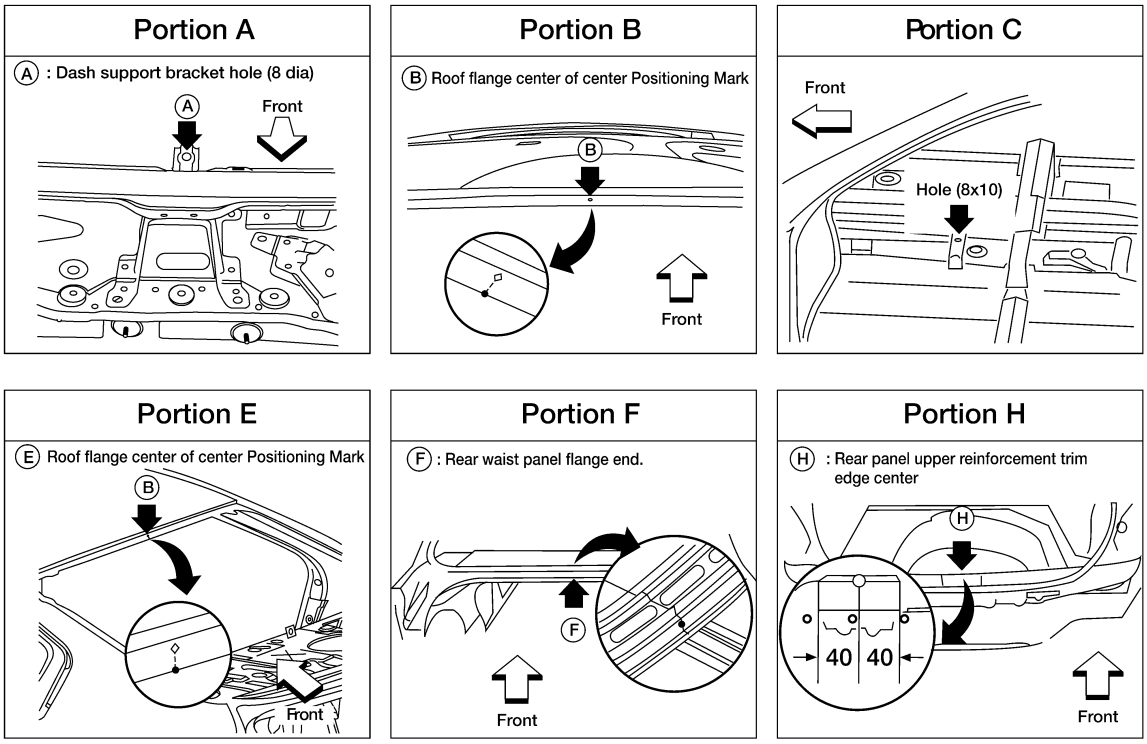
BODY ALIGNMENT

Body Center Marks

INFOID:0000000001345588

A mark has been placed on each part of the body to indicate the vehicle center. When repairing parts damaged by an accident which might affect the vehicle frame (members, pillars, etc.), more accurate and effective repair will be possible by using these marks together with body alignment specifications.



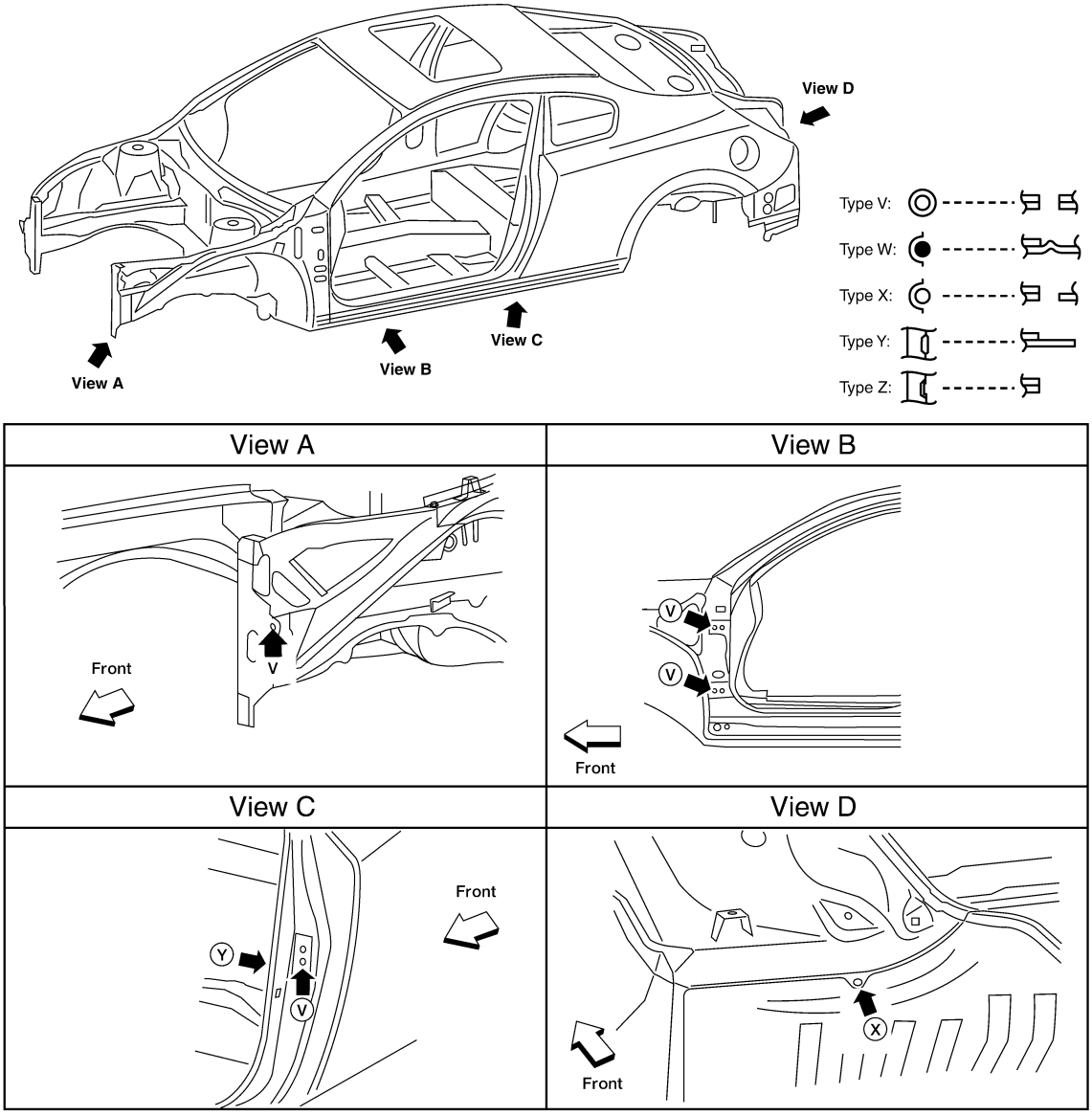


ALKIA0800GB

Panel Parts Matching Marks

INFOID:0000000001345589

A mark has been placed on each body panel to indicate the parts matching positions. When repairing parts damaged by an accident which might affect the vehicle structure (members, pillars, etc.), more accurate and effective repair will be possible by using these marks together with body alignment specifications.

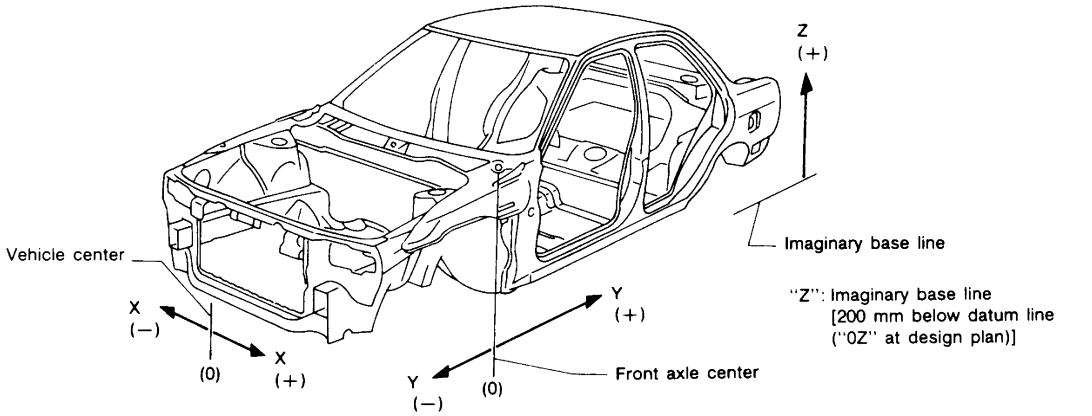


ALKIA0801GB

Description

INFOID:0000000001345590

- 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″.

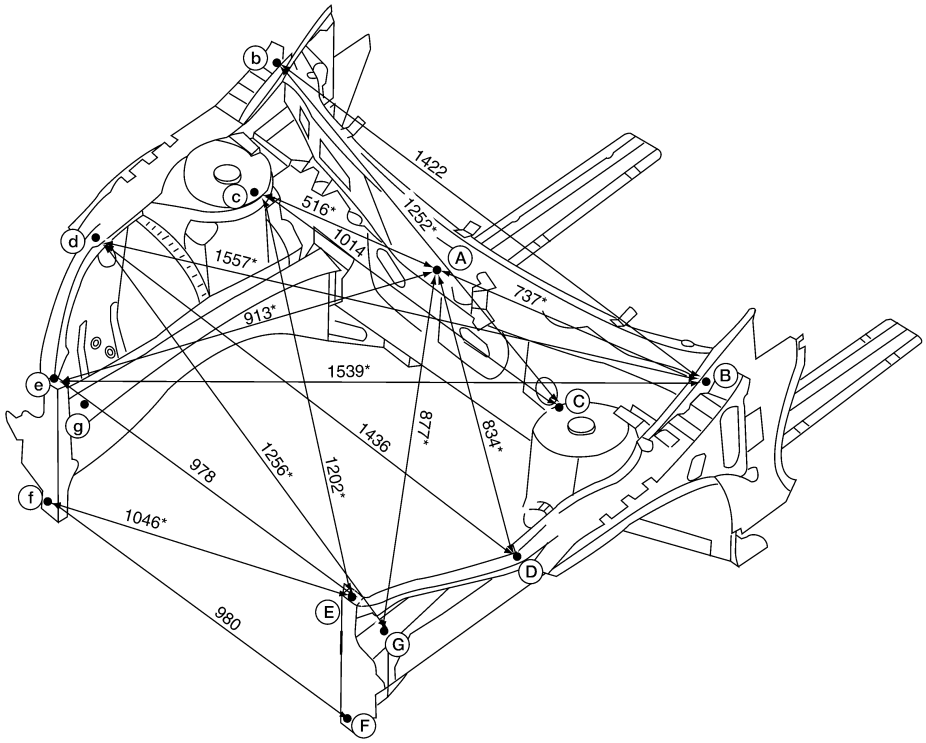

Z
(+)
Imaginary base line
"Z": Imaginary base line
[200 mm below datum line
("0Z" at design plan)]
Vehicle center
X
(−)
X
(+)
(0)
Y
(+)
Y
(−)
(0)
Front axle center
PIIA0104E

Engine Compartment

INFOID:0000000001345591

Measurement

Figures marked with a (*) indicate symmetrically identical dimensions on both right and left sides of the vehicle.

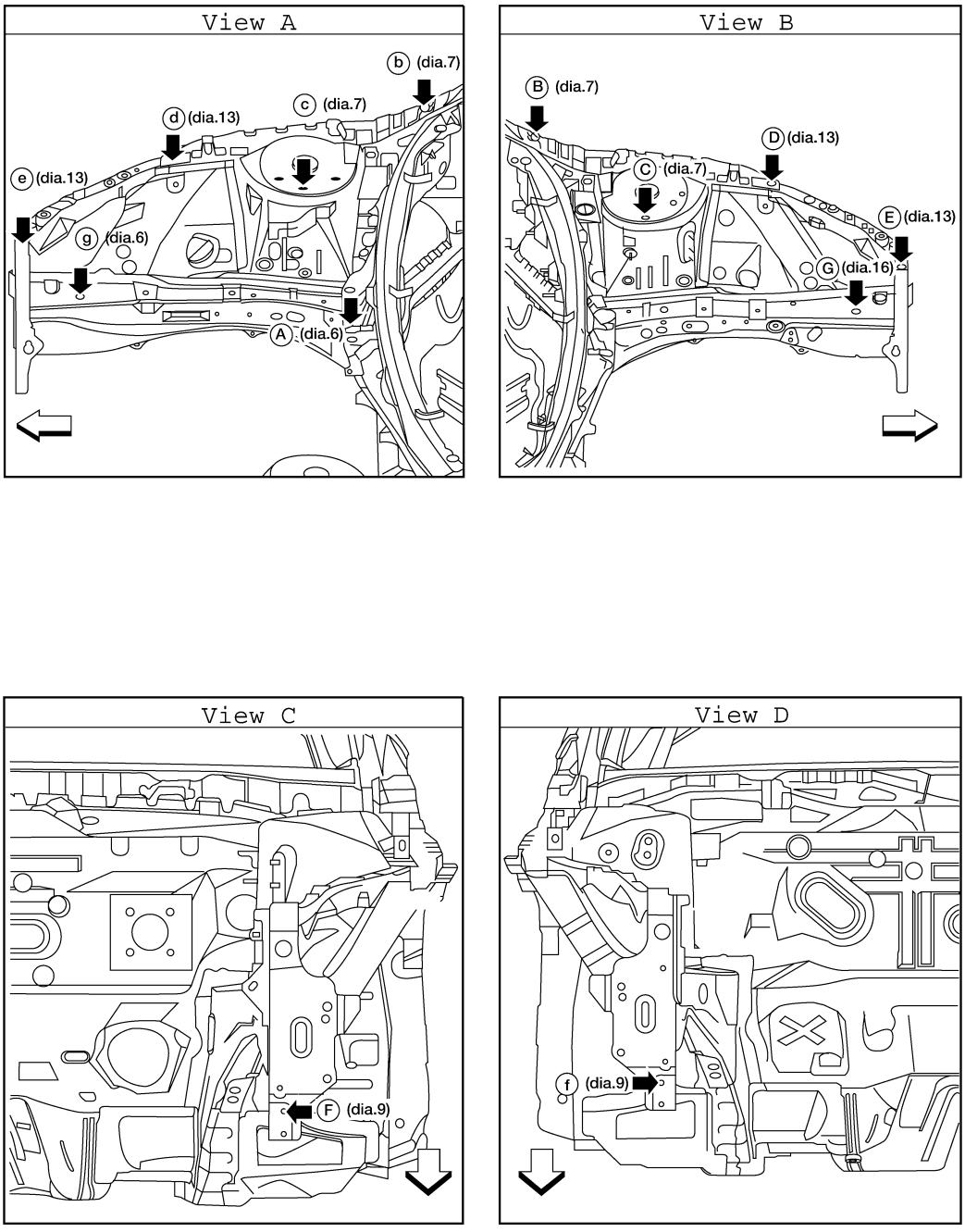


Point	Dimension
Ⓑ ~ Ⓓ	617*
Ⓑ ~ Ⓔ	989*
Ⓑ ~ Ⓖ	1512*
Ⓒ ~ Ⓑ	1268*
Ⓒ ~ Ⓓ	389*
Ⓒ ~ Ⓔ	673*
Ⓒ ~ Ⓖ	630*
Ⓒ ~ ⓖ	1182*
Ⓓ ~ Ⓖ	394*
Ⓔ ~ Ⓖ	201*
Ⓖ ~ ⓖ	990

Unit : mm

ALKIA0802GB

Measurement Points



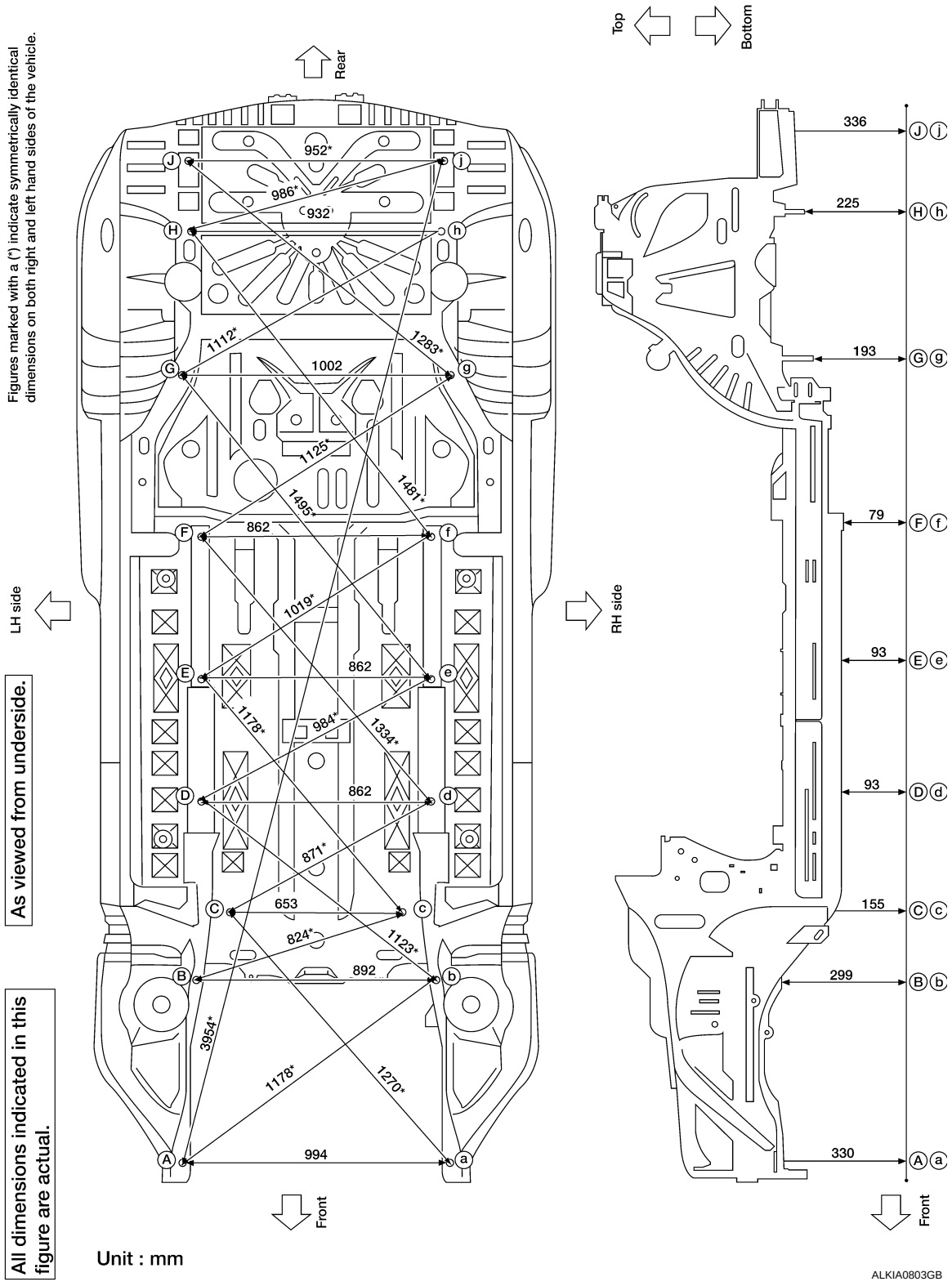
Unit : mm

AWKIA0389GB

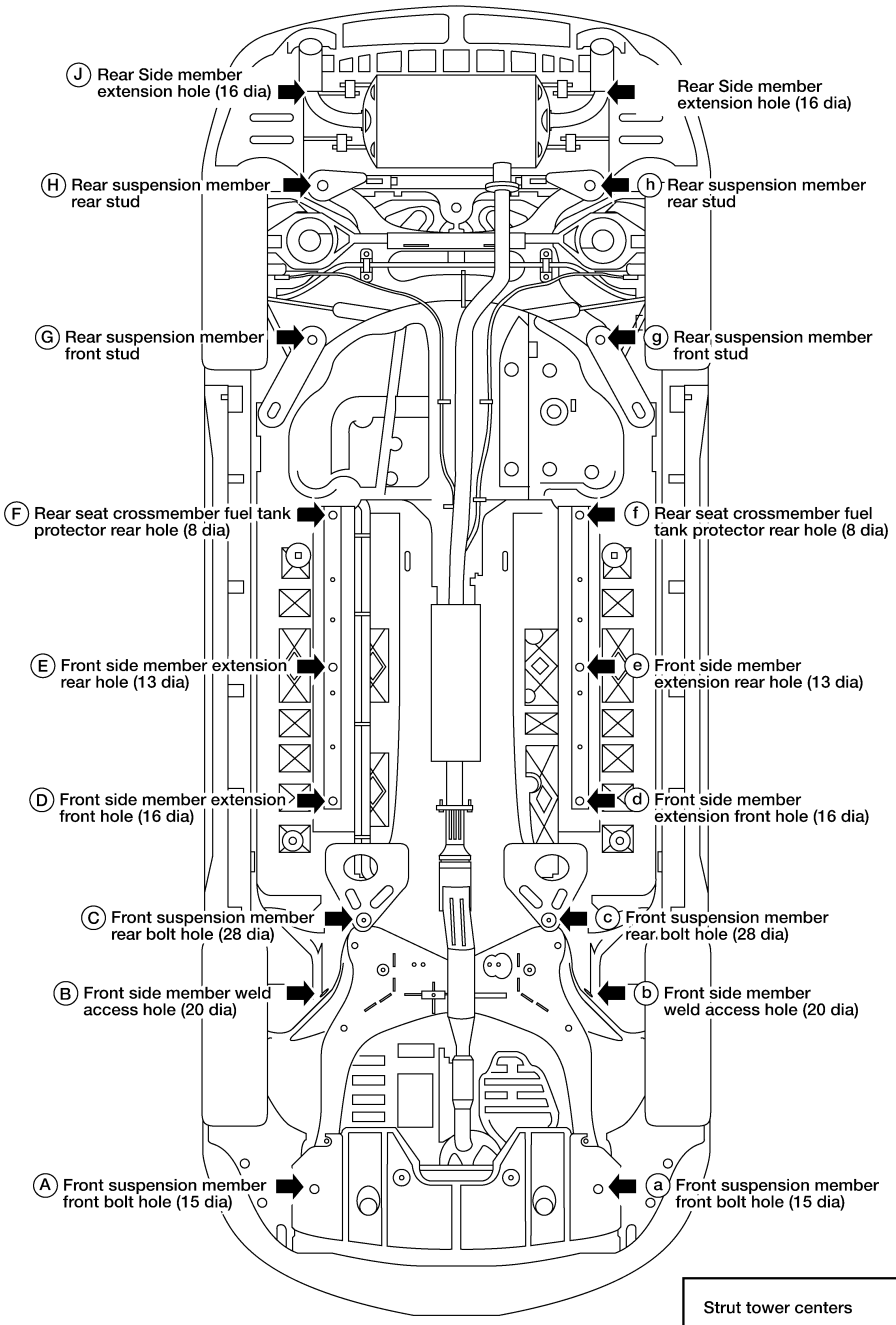
Underbody

INFOID:0000000001345592

Measurement



Measurement Points



Ⓐ ⓐ
X : -556
Y : ±497
Z : 330

Ⓑ ⓑ
X : 149
Y : ±466
Z : 299

Ⓒ ⓒ
X : 395
Y : ±327
Z : 155

Ⓓ ⓓ
X : 820
Y : ±431
Z : 93

Ⓔ ⓔ
X : 1294
Y : ±431
Z : 93

Ⓕ ⓕ
X : 1838
Y : ±431
Z : 79

Ⓖ ⓖ
X : 2458
Y : ±501
Z : 193

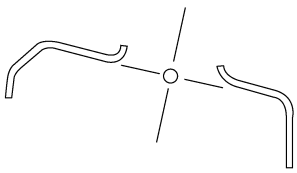
Ⓗ ⓗ
X : 3007
Y : ±466
Z : 225

Ⓙ ⓙ
X : 3276
Y : ±476
Z : 336

Strut tower centers

Coordinates

Ⓚ ⓚ Front
X: 48
Y: ± 584
Z : 790



Unit : mm

ALKIA0804GB

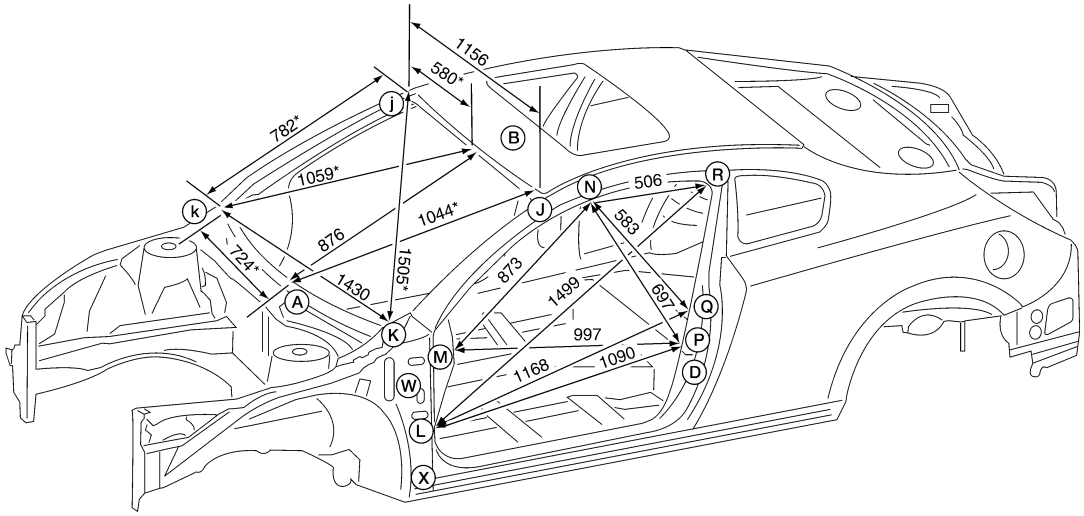
Passenger Compartment

INFOID:0000000001345593

Measurement

Unit : mm

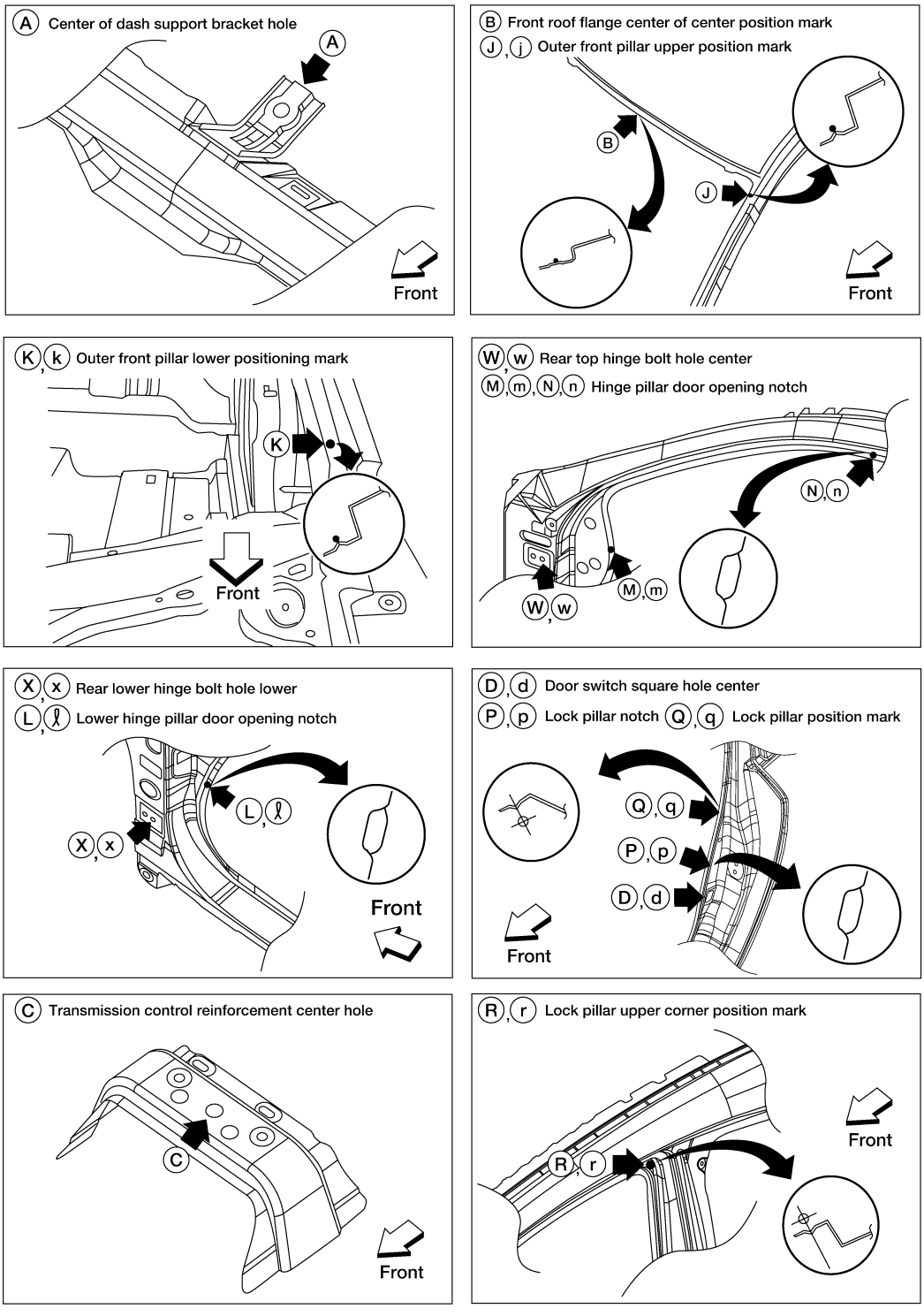
Figures marked with a (*) indicate symmetrically identical dimensions on both right and left sides of the vehicle.



Point	Dimension	Point	Dimension	Point	Dimension
Ⓐ ~ Ⓒ	999	ⓙ ~ Ⓒ	1071*	ⓟ ~ Ⓒ	955*
Ⓧ ~ Ⓓ	1195	ⓘ ~ Ⓒ	918*	Ⓟ ~ ⓟ	1472
Ⓧ ~ Ⓦ	320	Ⓛ ~ ⓛ	1466	ⓠ ~ Ⓒ	1040*
Ⓐ ~ ⓔ	2029	ⓜ ~ Ⓒ	932*	Ⓠ ~ ⓠ	1473
Ⓑ ~ Ⓒ	954	Ⓜ ~ ⓜ	1443	ⓡ ~ Ⓒ	1295*
Ⓓ ~ Ⓦ	1200	ⓝ ~ Ⓒ	1092*	Ⓡ ~ ⓡ	1178
Ⓔ ~ Ⓒ	1497	Ⓝ ~ ⓝ	1167	ⓢ ~ Ⓒ	1594*

ALKIA0805GB

Measurement Points



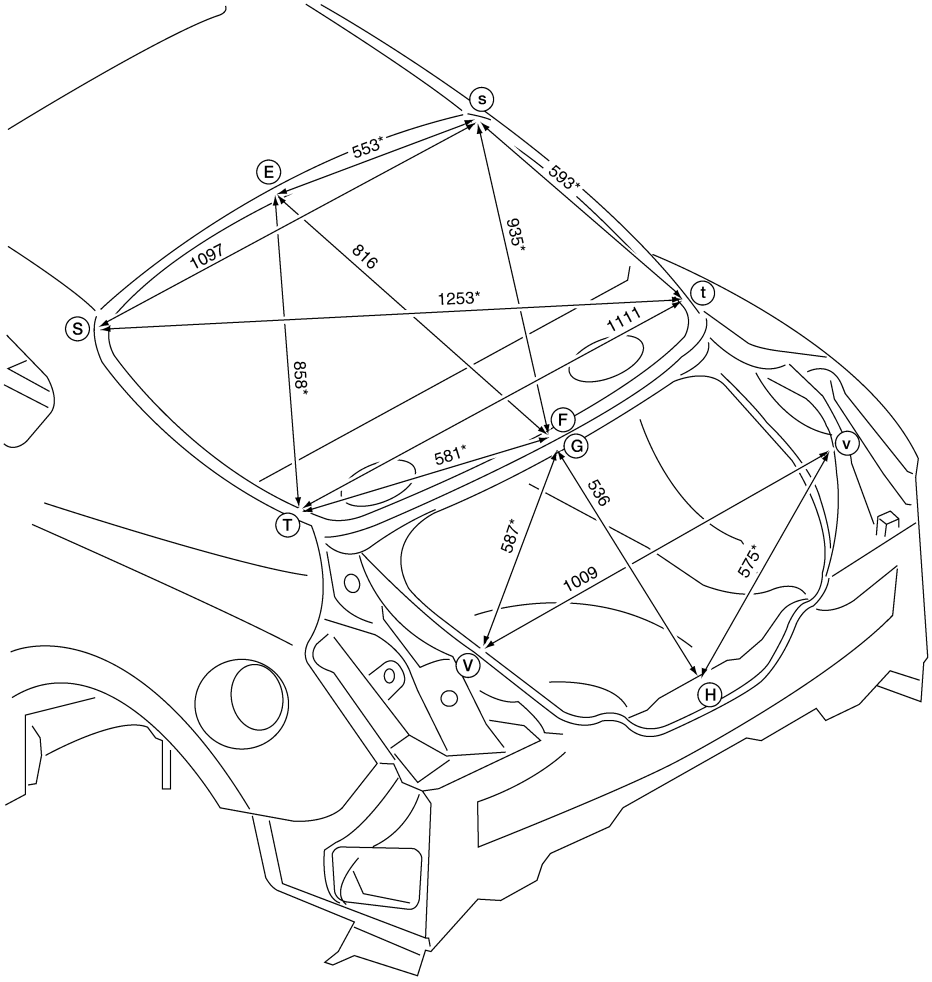
ALKIA0806GB

Rear Body

INFOID:0000000001345594

Measurement

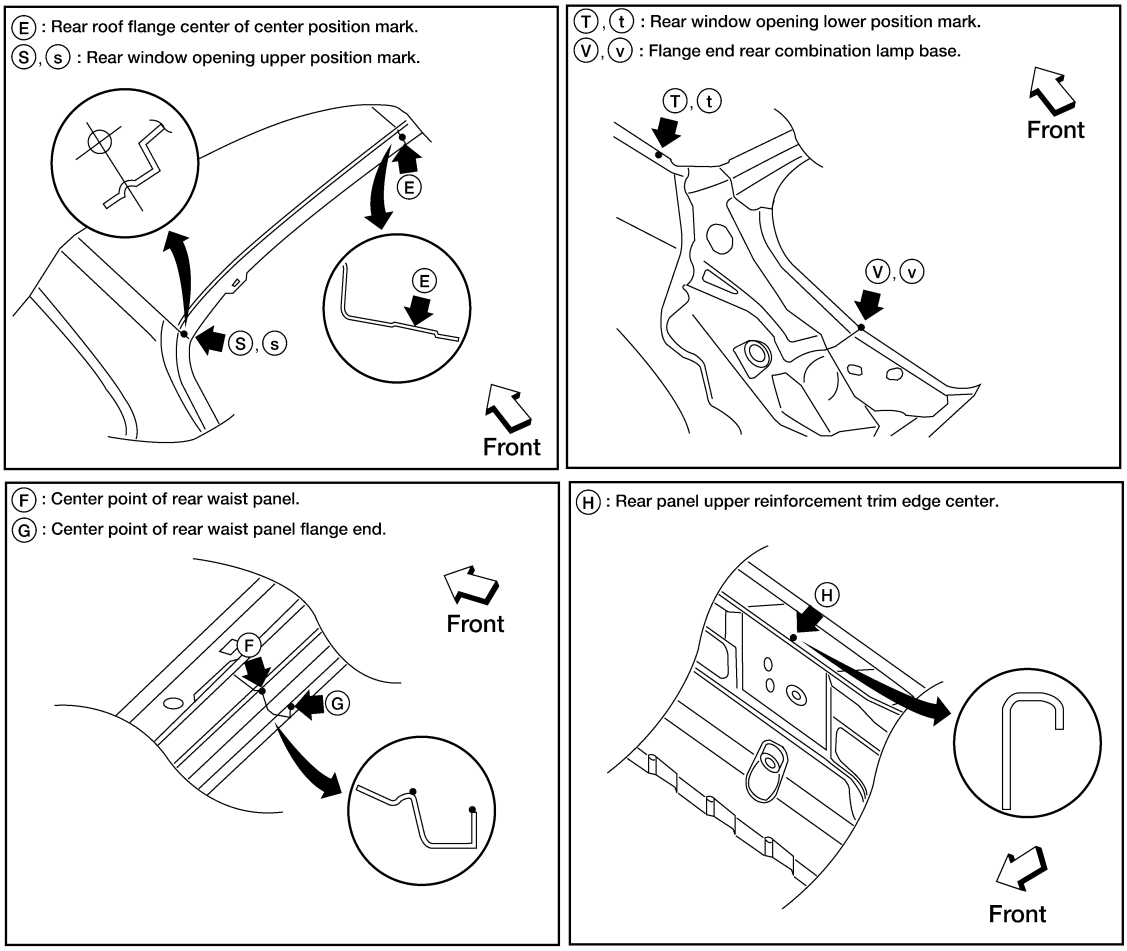
Figures marked with a (*) indicate symmetrically identical dimensions on both right and left sides of the vehicle.



Unit : mm

ALKIA0807GB

Measurement Points



ALKIA0808GB

PRECAUTIONS IN REPAIRING HIGH STRENGTH STEEL

High Strength Steel (HSS)

INFOID:0000000001345595

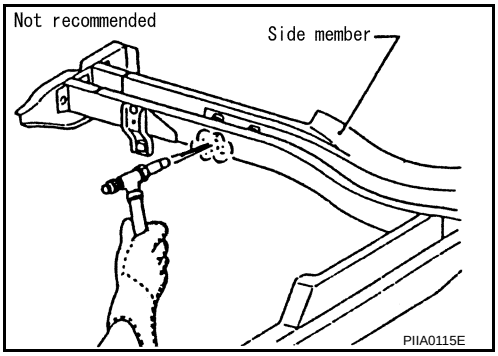
High strength steel is used for body panels in order to reduce vehicle weight.
Accordingly, precautions in repairing automotive bodies made of high strength steel are described below:

Tensile strength	Nissan/Infiniti designation	Major applicable parts
373 N/mm^2 (38kg/mm^2,54klb/sq in)	SP130	• Front side member assembly • Hoodledge assembly • Upper dash • Front pillar reinforcement assembly • Rear side member assembly • Other reinforcements

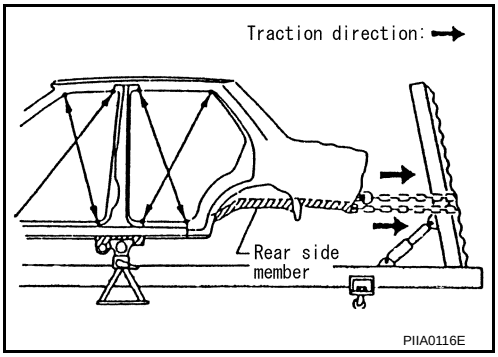
SP130 is the most commonly used HSS.

Read the following precautions when repairing HSS:

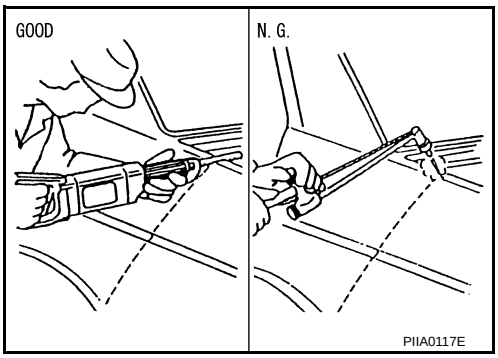
1. Additional points to consider
   - The repair of reinforcements (such as side members) by heating is not recommended since it may weaken the component. When heating is unavoidable, do not heat HSS parts above 550°C (1,022°F).
     Verify heating temperature with a thermometer.
     (Crayon-type and other similar type thermometer are appropriate.)



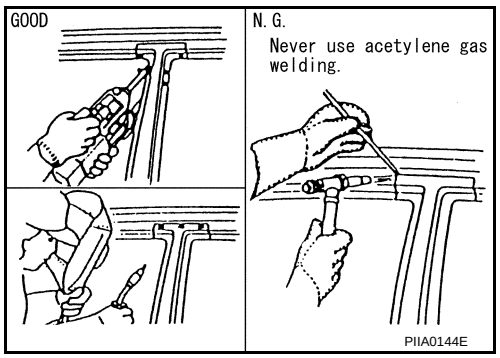
   - When straightening body panels, use caution in pulling any HSS panel. Because HSS is very strong, pulling may cause deformation in adjacent portions of the body. In this case, increase the number of measuring points, and carefully pull the HSS panel.



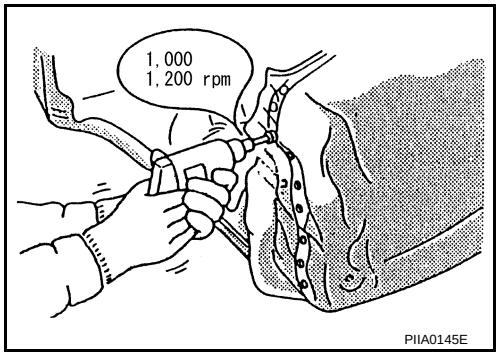
   - When cutting HSS panels, avoid gas (torch) cutting if possible. Instead, use a saw to avoid weakening surrounding areas due to heat. If gas (torch) cutting is unavoidable, allow a minimum margin of 50 mm (1.97in).



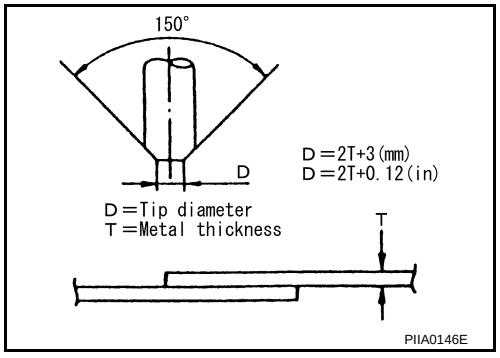
- When welding HSS panels, use spot welding whenever possible in order to minimize weakening surrounding areas due to heat.
  If spot welding is impossible, use M.I.G. welding. Do not use gas (torch) welding because it is inferior in welding strength.



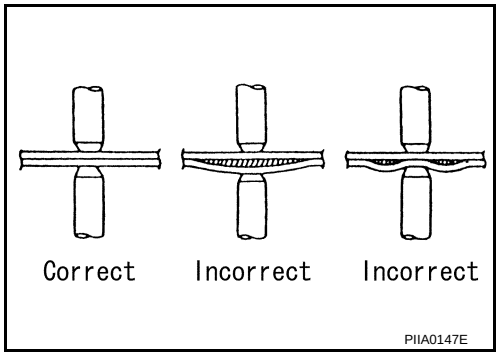
- The spot weld on HSS panels is harder than that of an ordinary steel panel.
  Therefore, when cutting spot welds on a HSS panel, use a low speed high torque drill (1,000 to 1,200 rpm) to increase drill bit durability and facilitate the operation.



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.



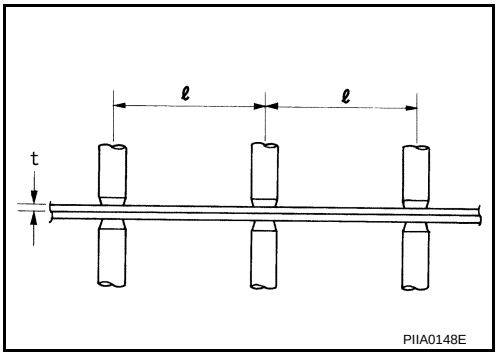
- The panel surfaces must fit flush to each other, leaving no gaps.



- Follow the specifications for the proper welding pitch.

Unit:mm

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



REPLACEMENT OPERATIONS

Description

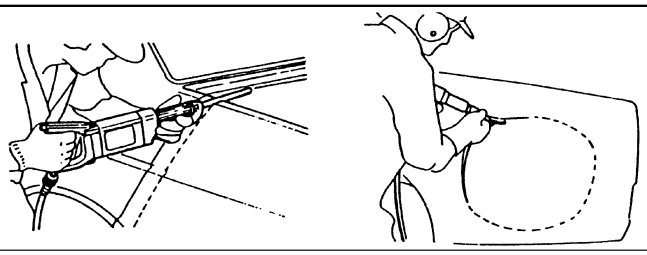
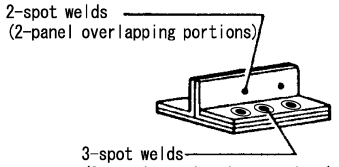
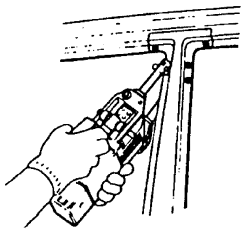
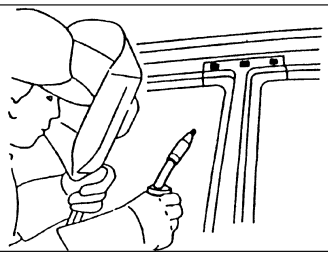
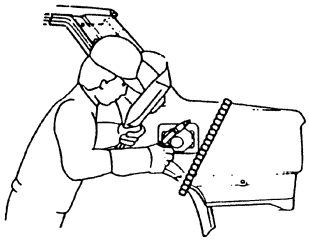
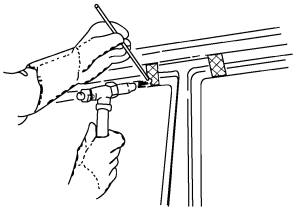
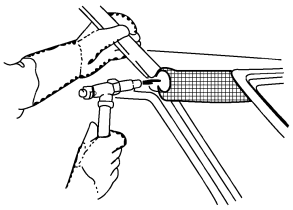
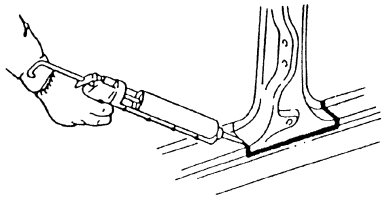
INFOID:0000000001345596

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 Body Repair Manual (Fundamentals) in order to ensure that the original functions and quality of the vehicle can be maintained. The Body Repair Manual (Fundamentals) contains additional information, including cautions and warning, that are not including in this manual. Technicians should refer to both manuals to ensure proper repairs.

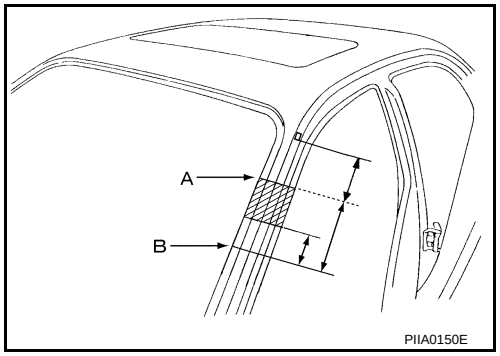
Please note that these information are prepared for worldwide usage, and as such, certain procedures might not apply in some regions or countries.

The symbols used in this section for cutting and welding / brazing operations are shown below.

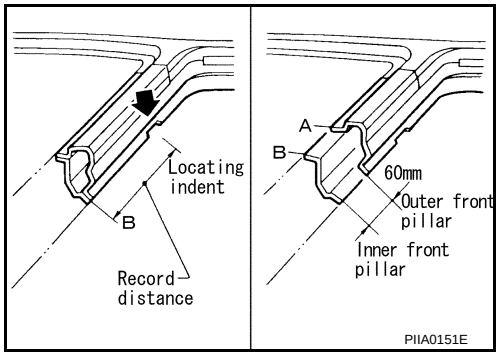
Saw cut or air chisel cut	
Spot weld ●●●● 2-spot welds	 
◉◉◉◉ 3-spot welds	
■■■ MIG plug weld	 
MIG seam weld/ Point weld	
Brazing	
Soldering	
Sealing	

PIIA0149E

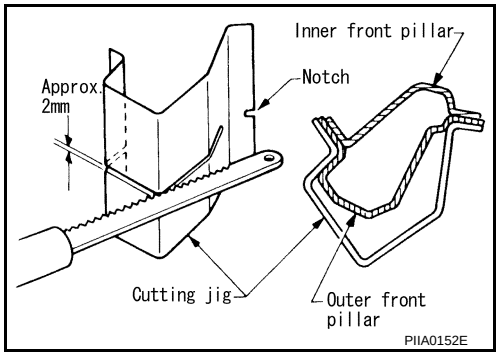
- Front pillar butt joint can be determined anywhere within shaded area as shown in the figure. The best location for the butt joint is at position A due to the construction of the vehicle. Refer to the front pillar section.



- 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 above inner front pillar cut position.

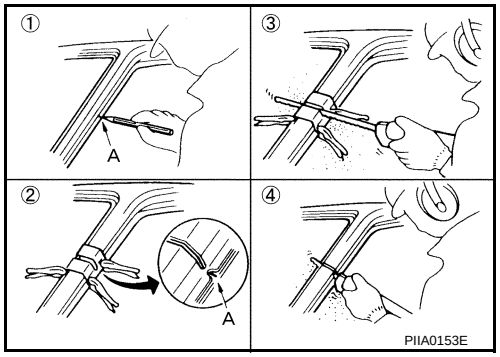


- Prepare a cutting jig to make outer pillar easier to cut. Also, this will permit service part to be accurately cut at joint position.



- An example of cutting operation using a cutting jig is as follows.

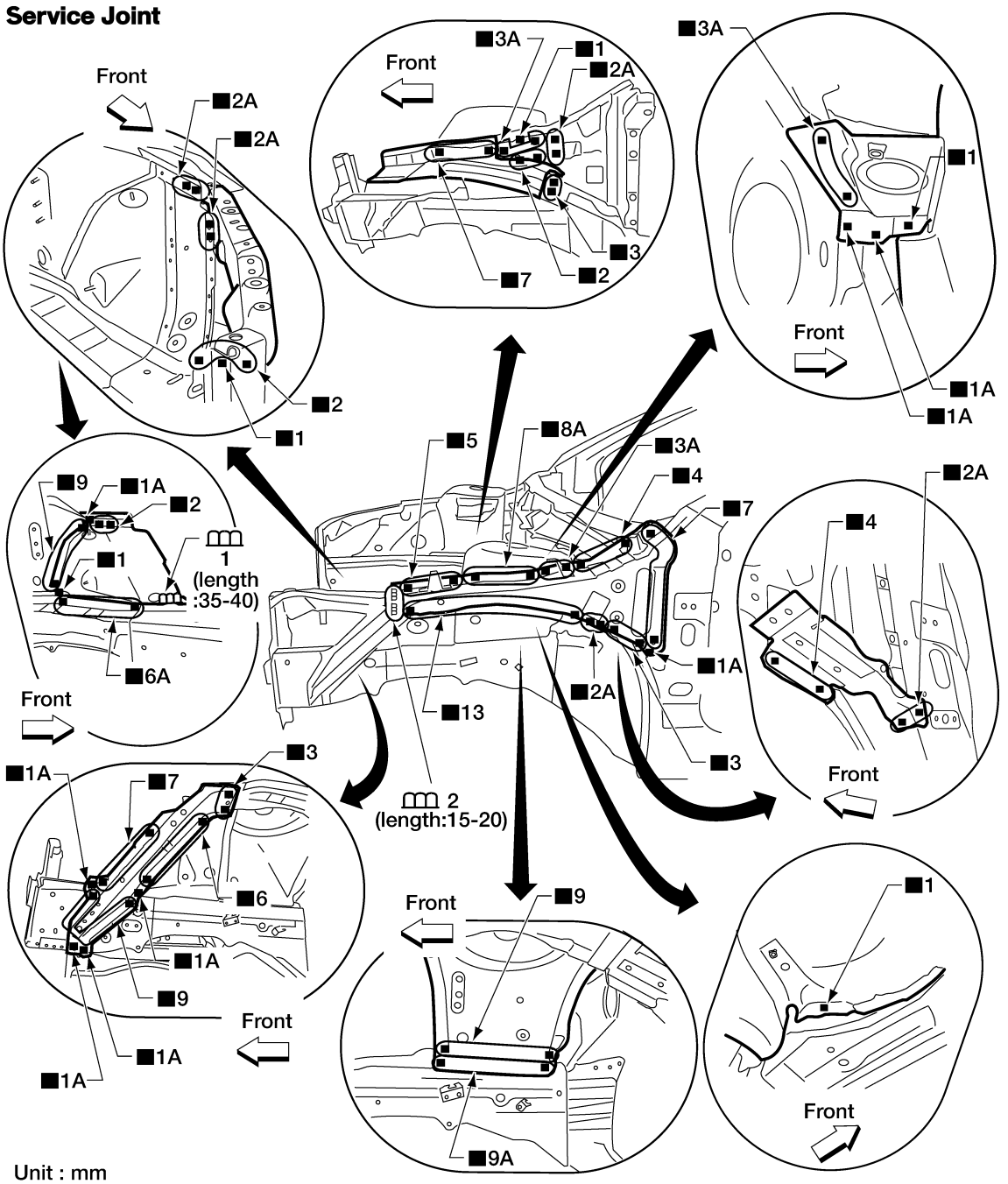
1. Mark cutting lines.
   A: Cut position of outer pillar
   B: Cut position of inner pillar
2. Align cutting line with notch on jig. Clamp jig to pillar.
3. Cut outer pillar along groove of jig. (At position A)
4. Remove jig and cut remaining portions.
5. Cut inner pillar at position B in same manner.



Hoodledge

INFOID:0000000001345597

Service Joint



Unit : mm

2-spot welds | 3-spot welds | MIG Plug weld | For 3 panels plug weld method (■ A | ■ B) | MIG seam weld/ Point weld

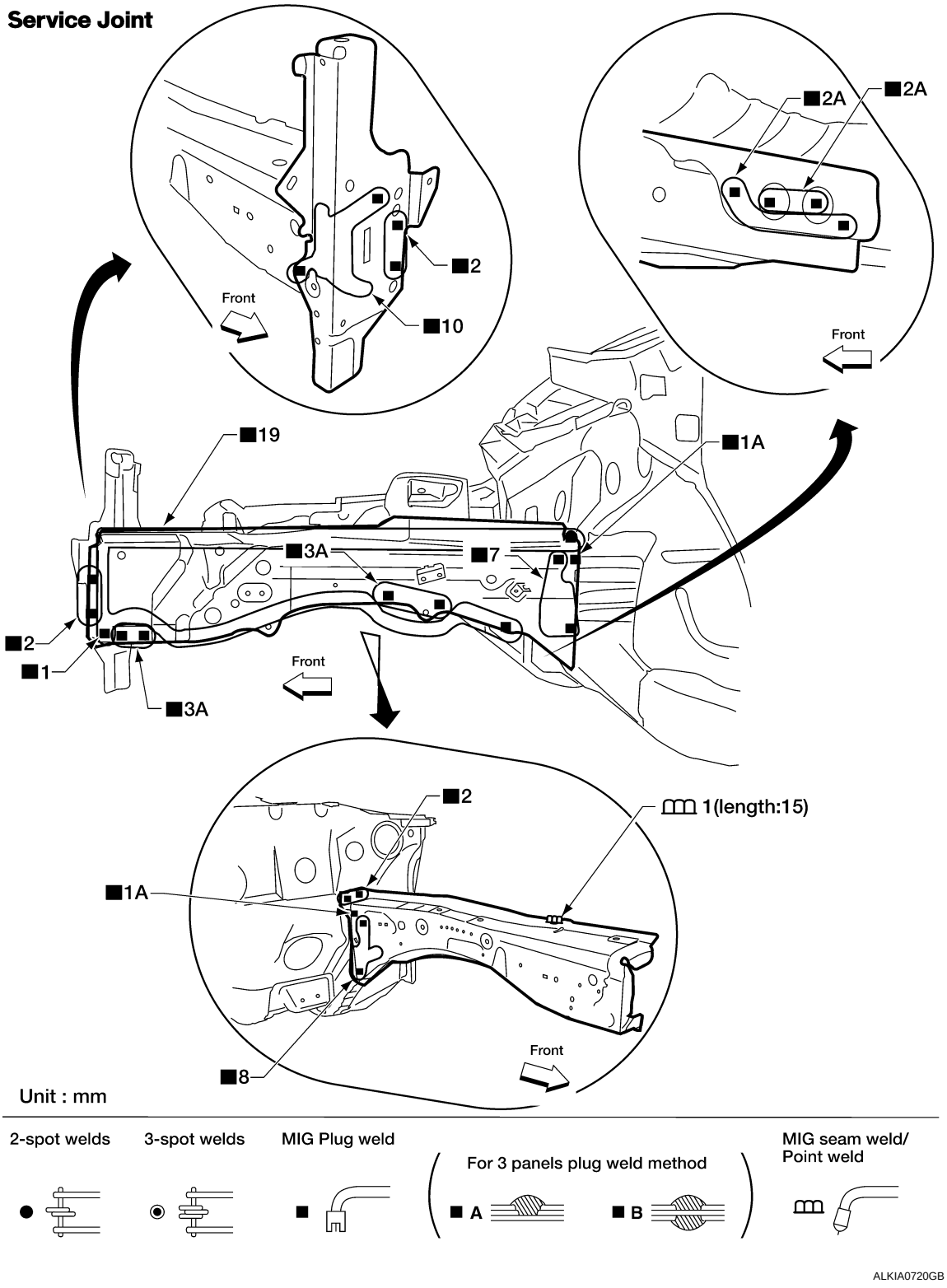
ALKIA0719GB

Change parts

- Front strut housing (LH)
- Hoodledge connector
- Upper front hoodledge
- Radiator core support upper
- Hoodledge reinforcement
- Hoodledge reinforcement rear

Front Side Member Front Assembly

INFOID:0000000001345599



Change parts

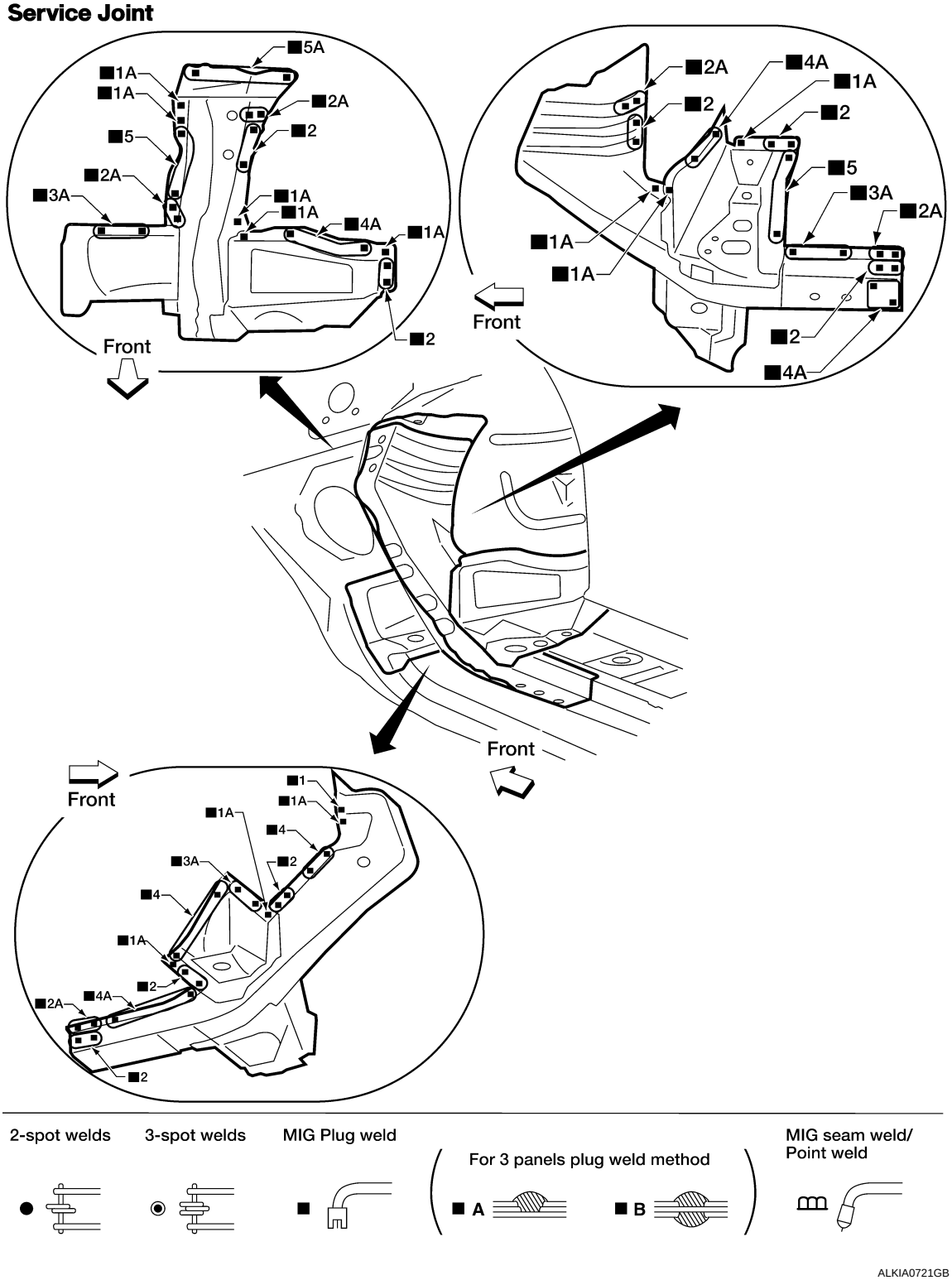
- Front side member front assembly
- Front side member front closing plate
- Radiator core side support

Front Side Member

INFOID:0000000001345598

- Work after front side member front assembly has been removed.

Service Joint



Change parts

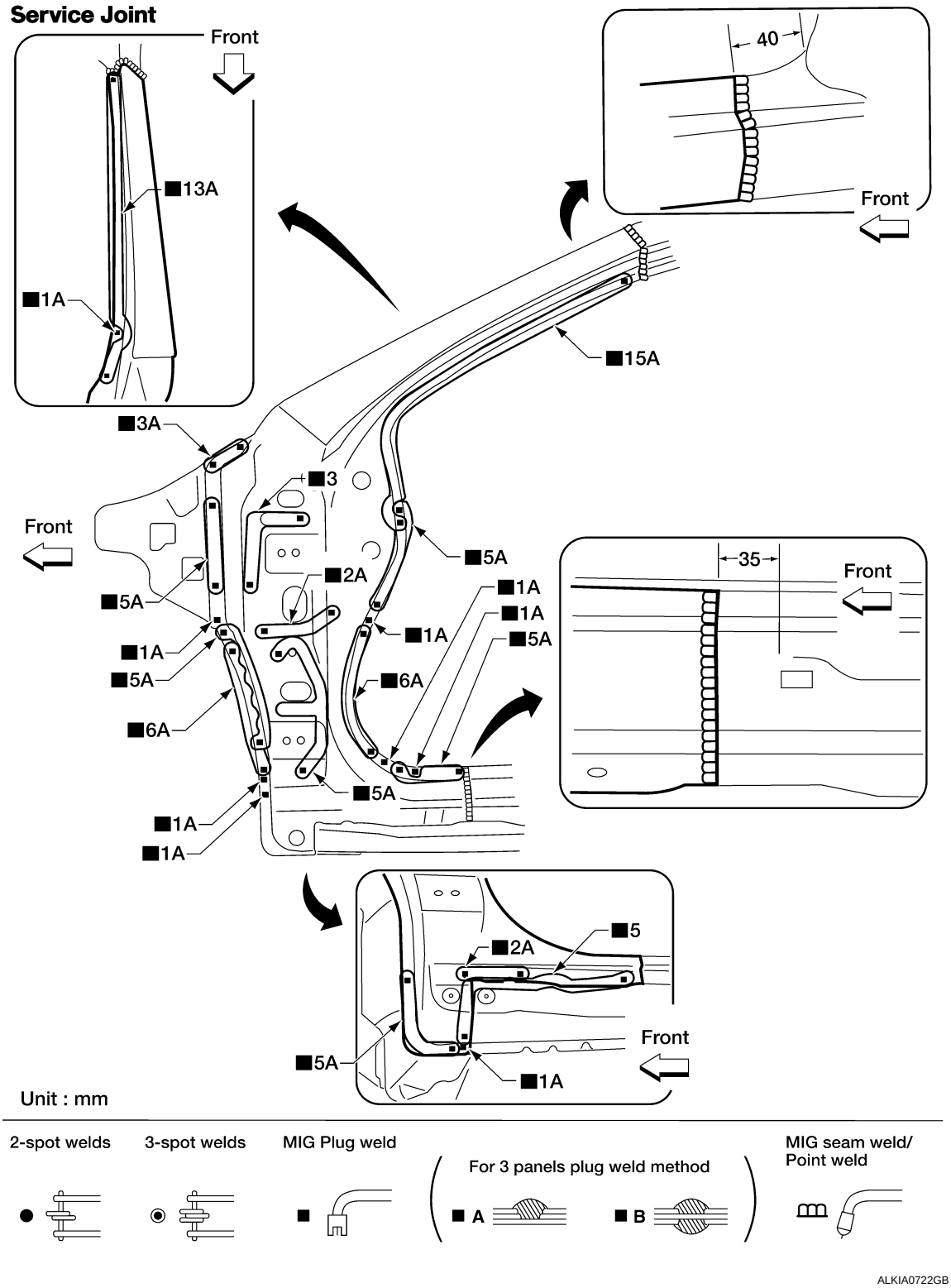
- Front side member assembly

Front Pillar

INFOID:0000000001345600

OUTER

- Work after hoodledge and hoodledge reinforcement rear has been removed.



ALKIA0722GB

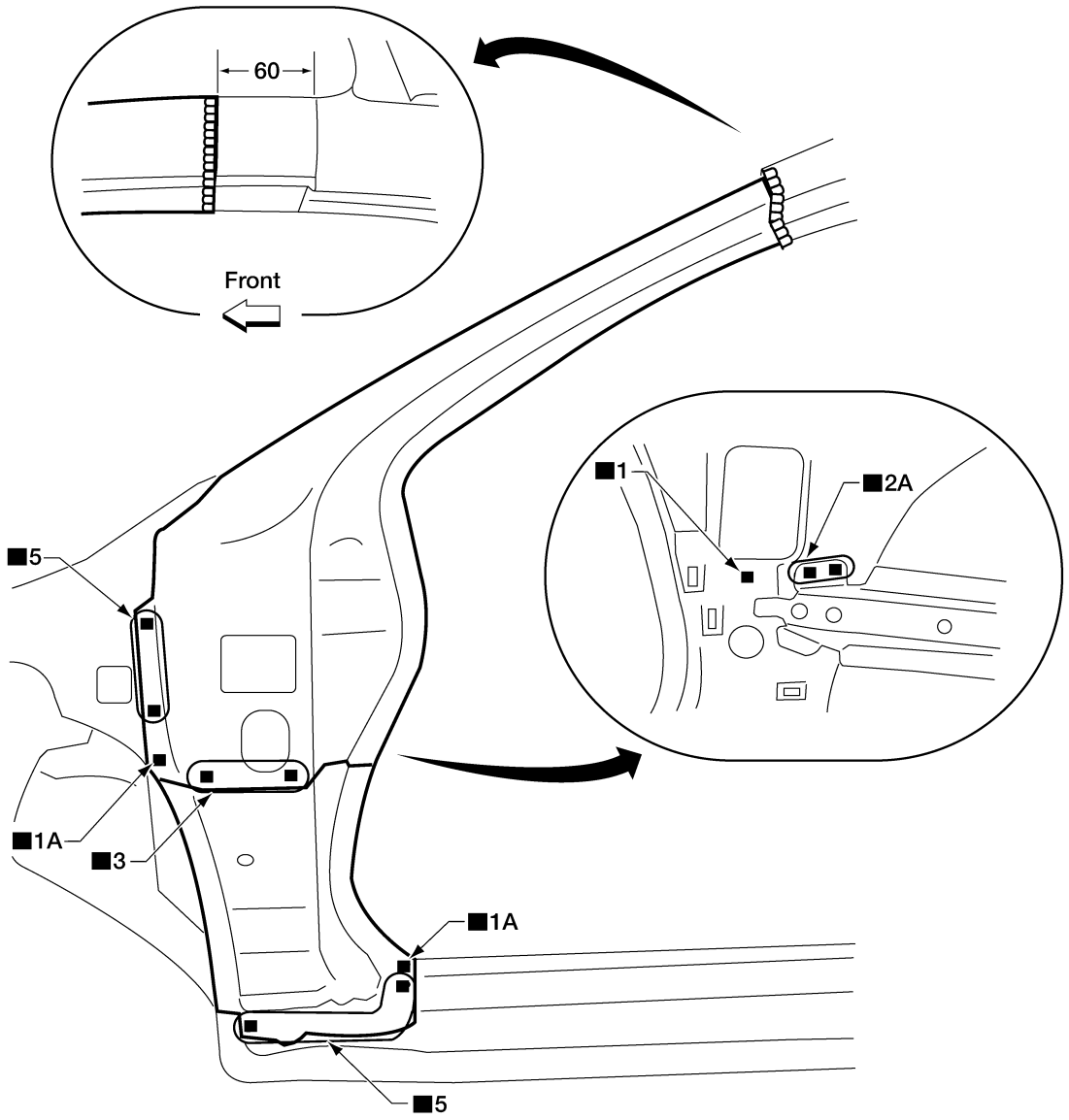
Change parts

- Front pillar section of body side outer

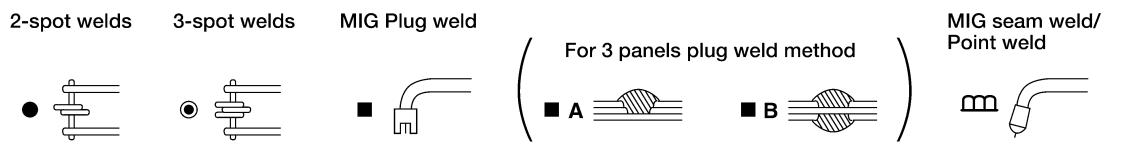
REINFORCEMENT

• Work after front pillar outer has been removed.

Service Joint



Unit : mm



ALKIA0723GB

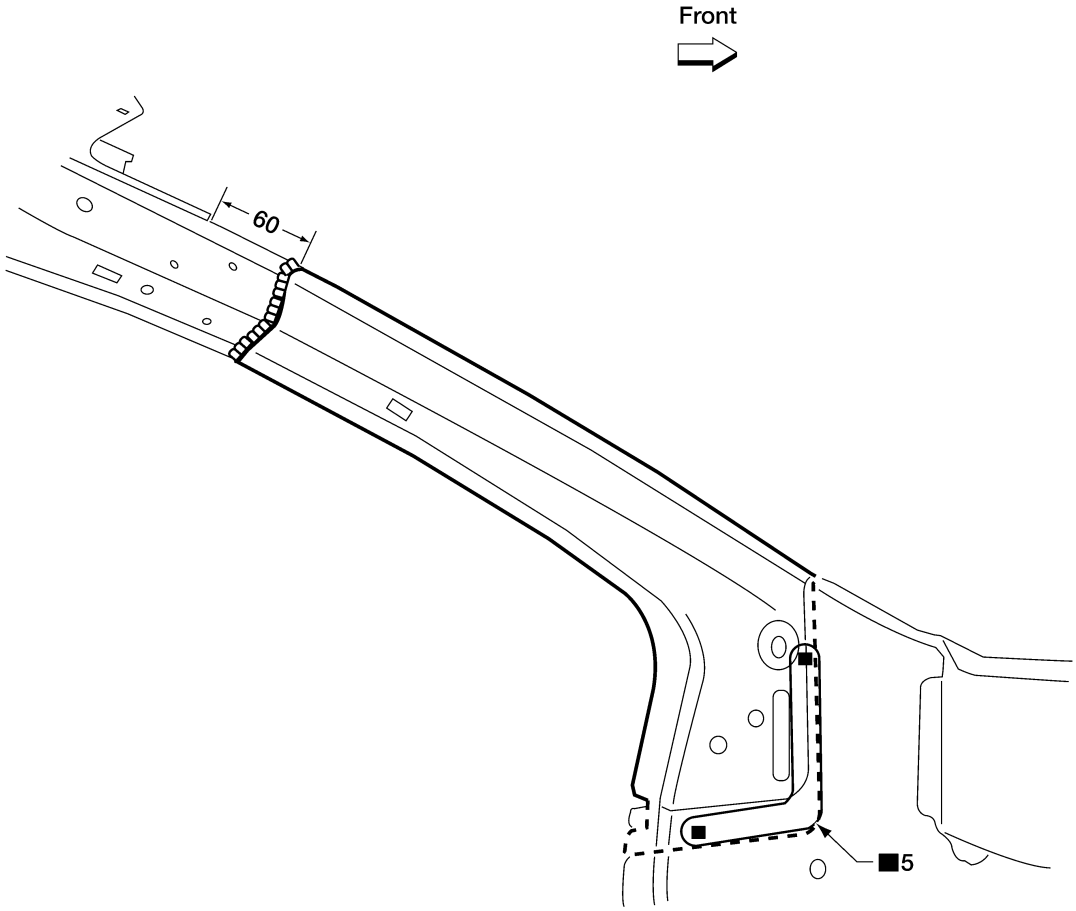
Change parts

- Hinge pillar upper reinforcement
- Hinge pillar lower reinforcement

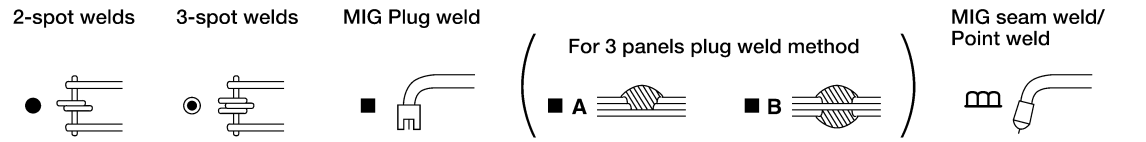
INNER

• Work after front pillar upper and lower reinforcements have been removed.

Service Joint



Unit : mm



ALKIA0724GB

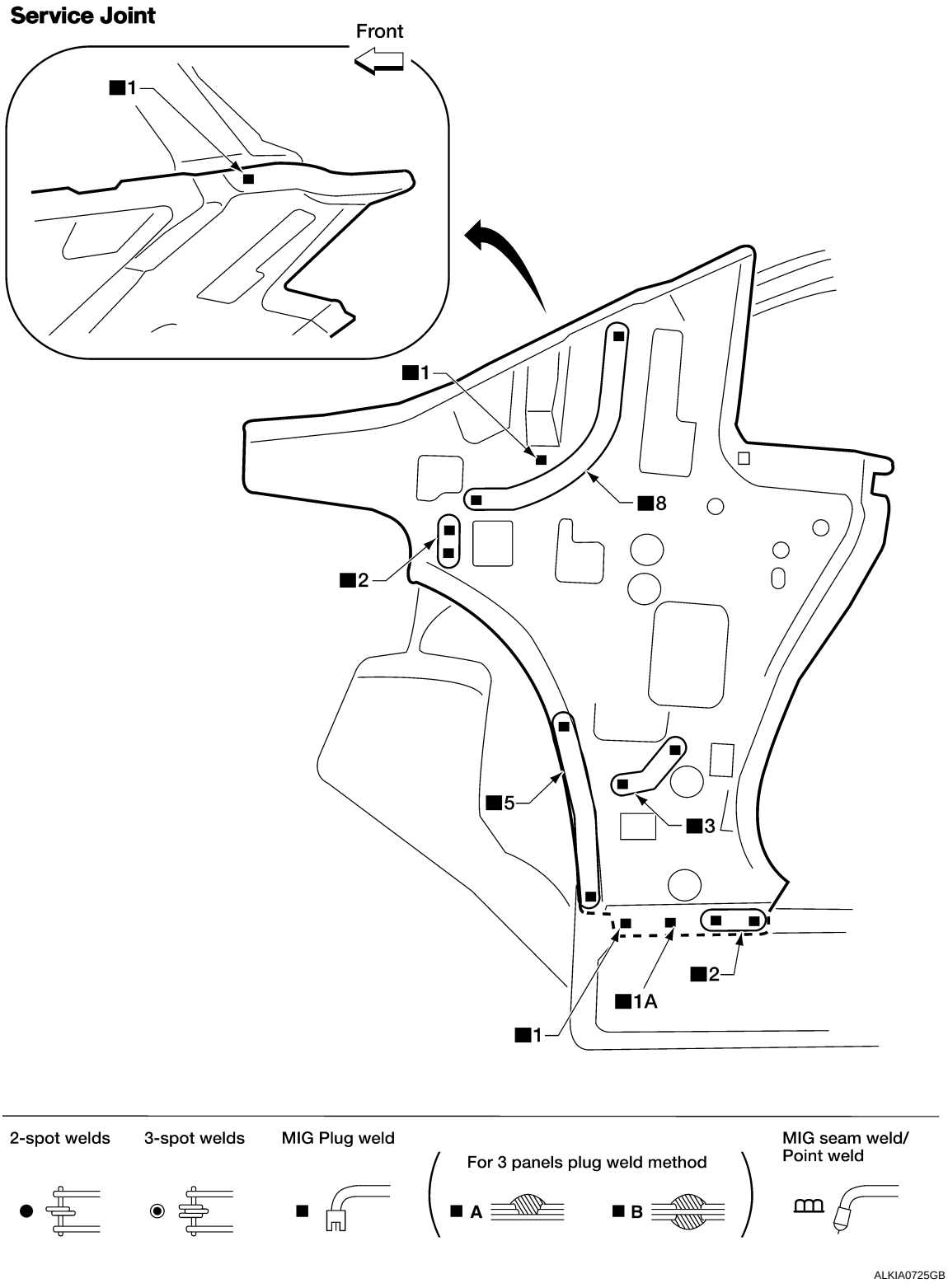
Change parts

- Front pillar inner reinforcement

Dash Side

INFOID:0000000001345601

Work with front pillar reinforcement removed.



Change parts

- Dash side

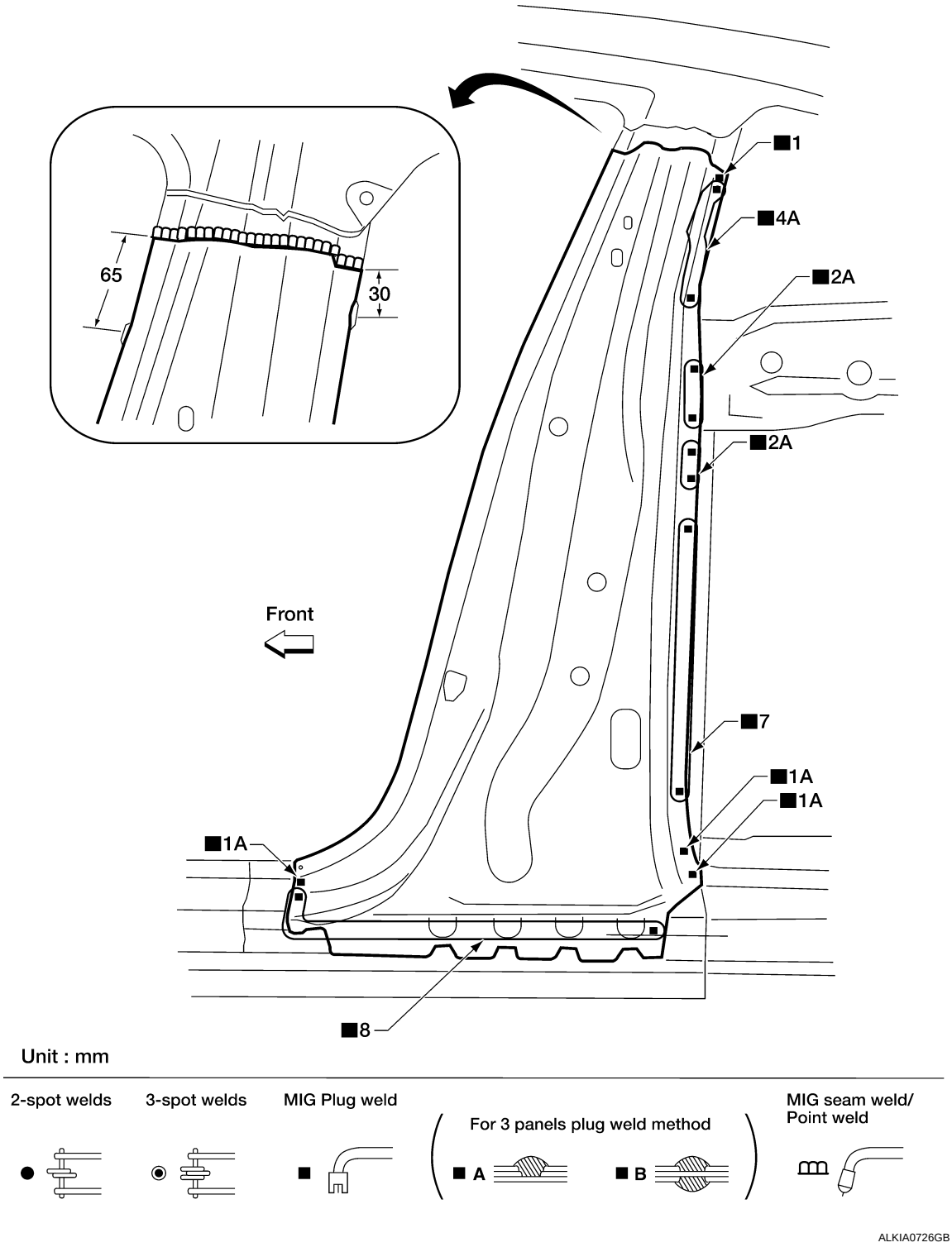
Center Pillar

INFOID:0000000001345602

REINFORCEMENT

work after rear fender has been removed.

Service Joint



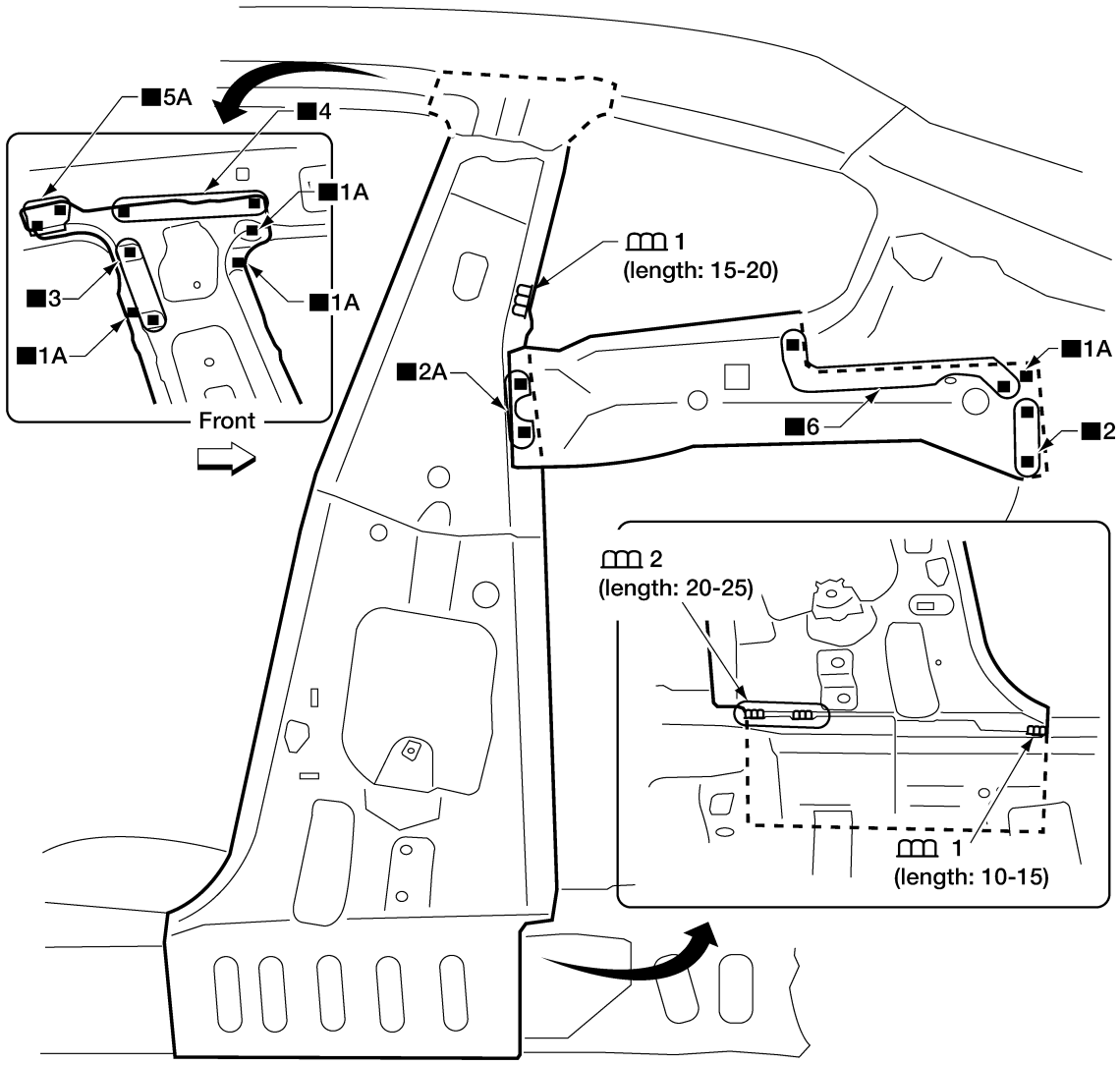
Change parts

- Lock pillar reinforcement

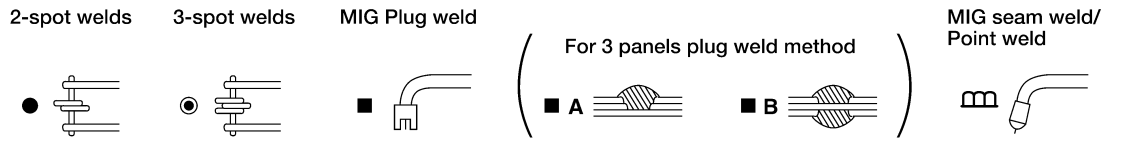
INNER

Work after center pillar reinforcement and outer sill have been removed.

Service Joint



Unit : mm



ALKIA0727GB

Change parts

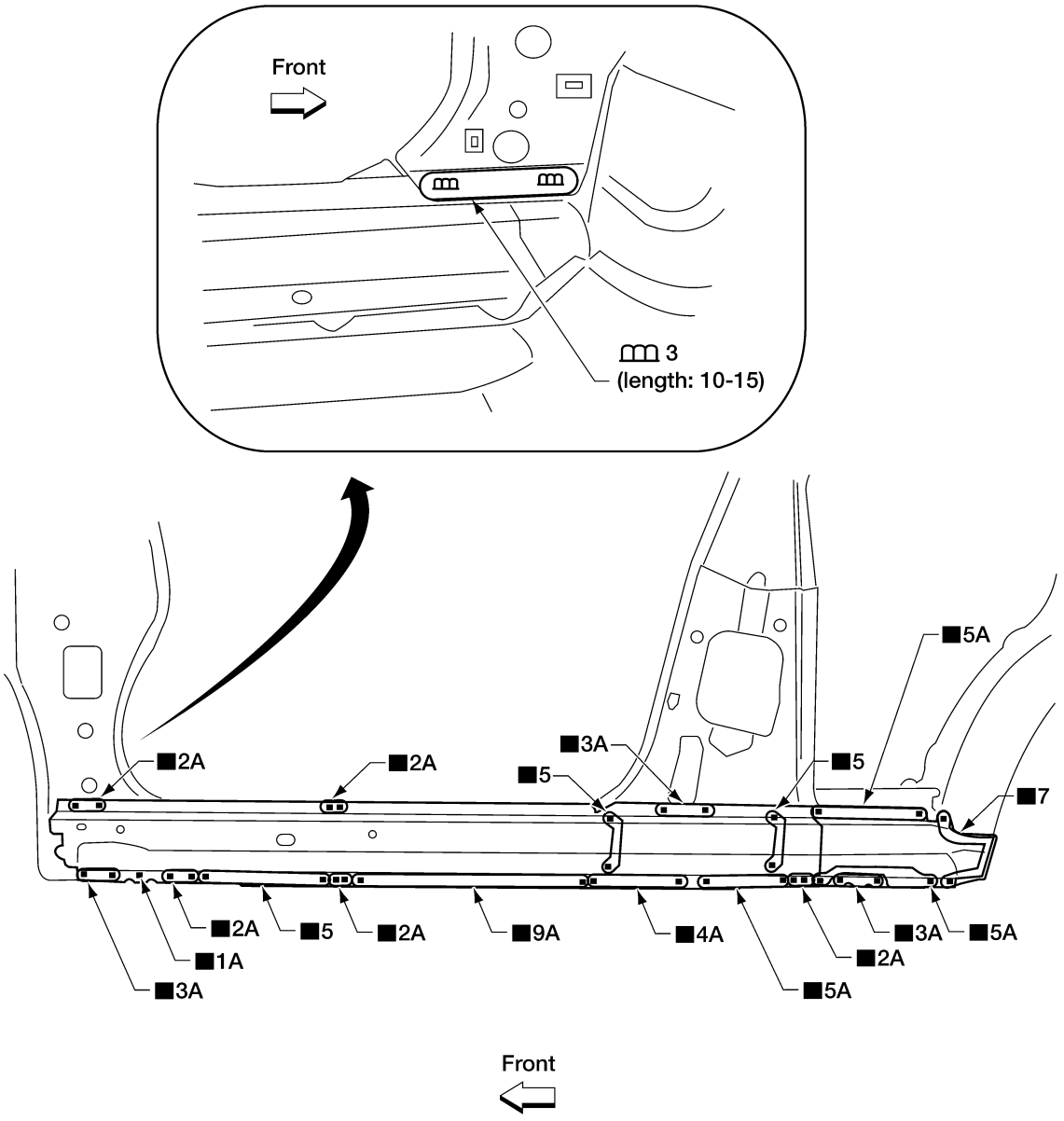
- Lock pillar inner
- Rear pillar inner
- Rear pillar inner

Outer Sill Reinforcement

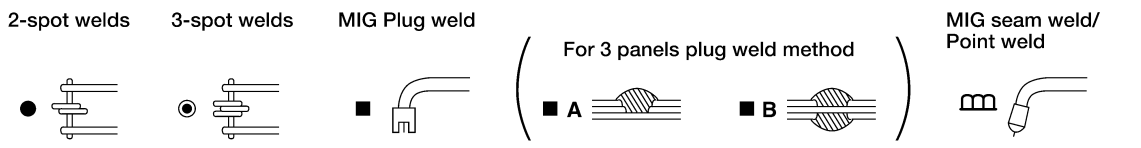
INFOID:0000000001345603

Work after the front pillar reinforcement and lock pillar reinforcement have been removed.

Service Joint



Unit : mm



ALKIA0728GB

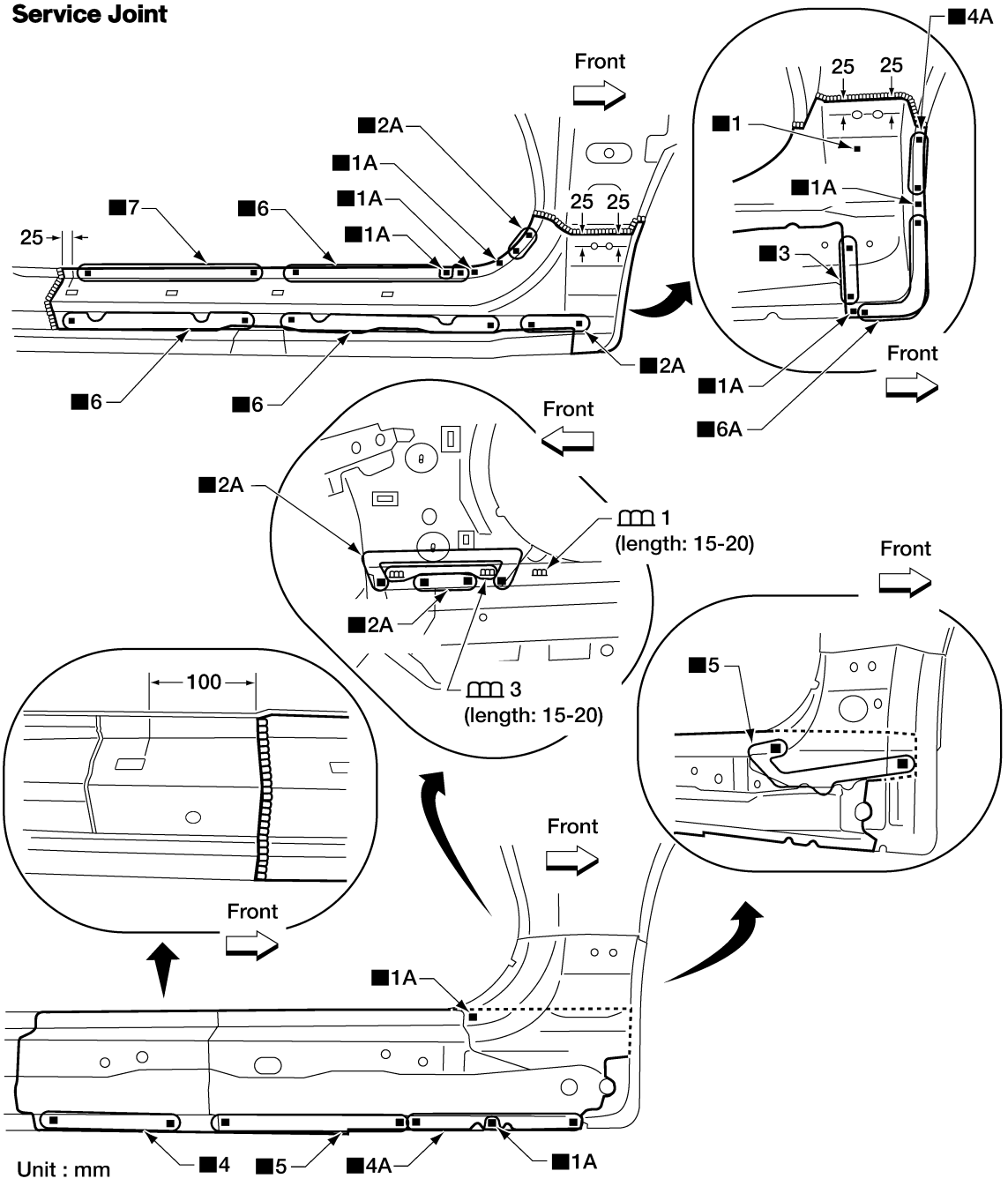
Change parts

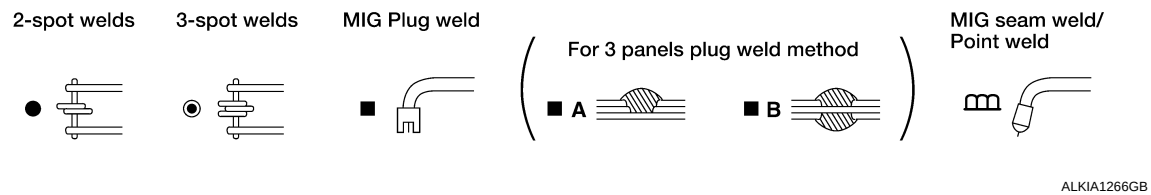
- Outer sill reinforcement

Sill Partial

INFOID:0000000001728597

Service Joint





ALKIA1266GB

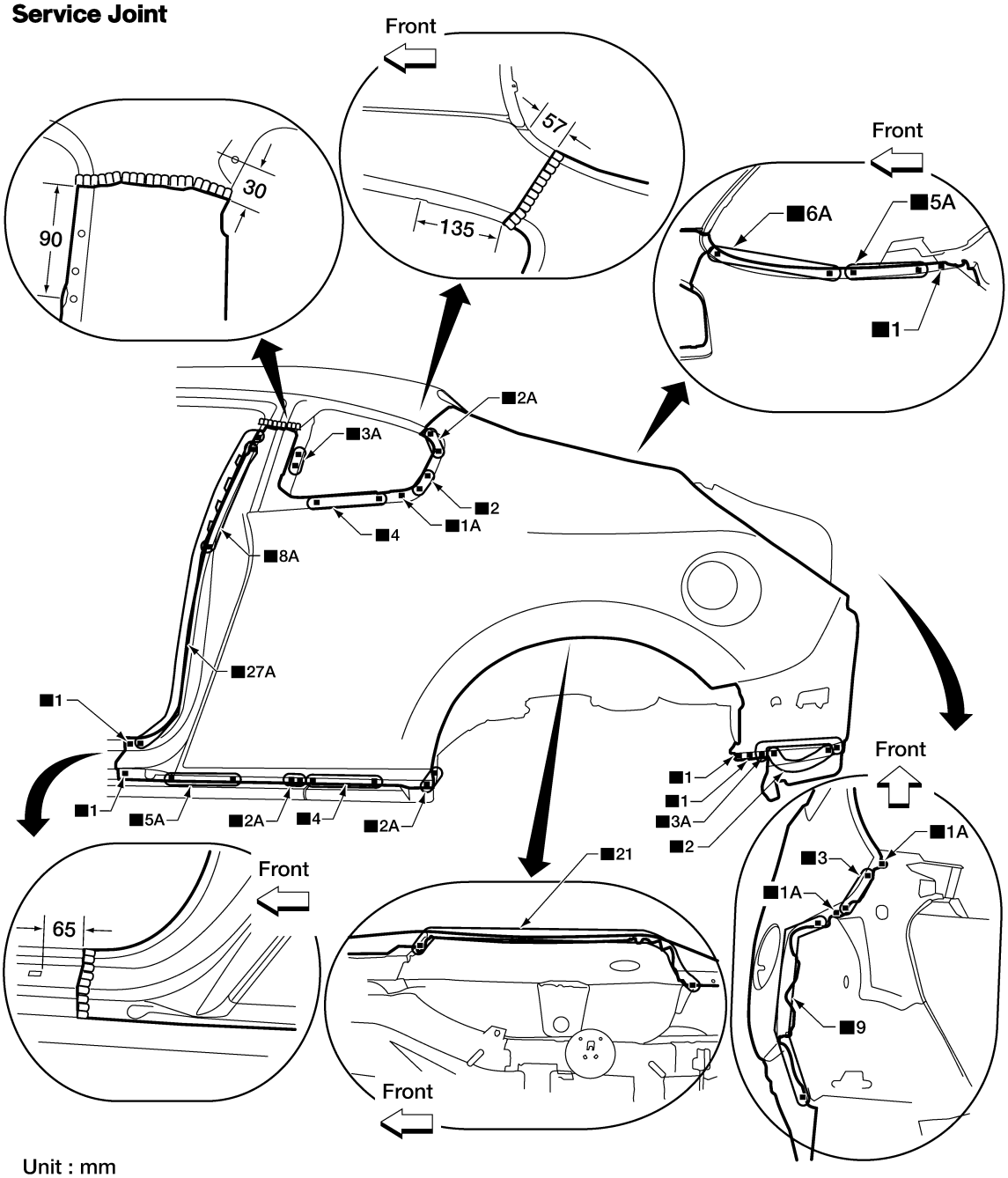
Change parts

- Sill portion of body side outer
- Front portion of outer sill reinforcement

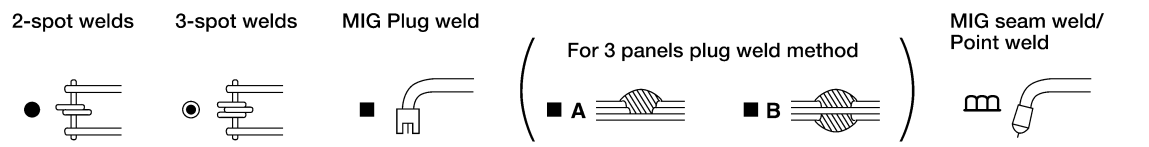
Rear Fender

INFOID:0000000001345604

Service Joint



Unit : mm



ALKIA0732GB

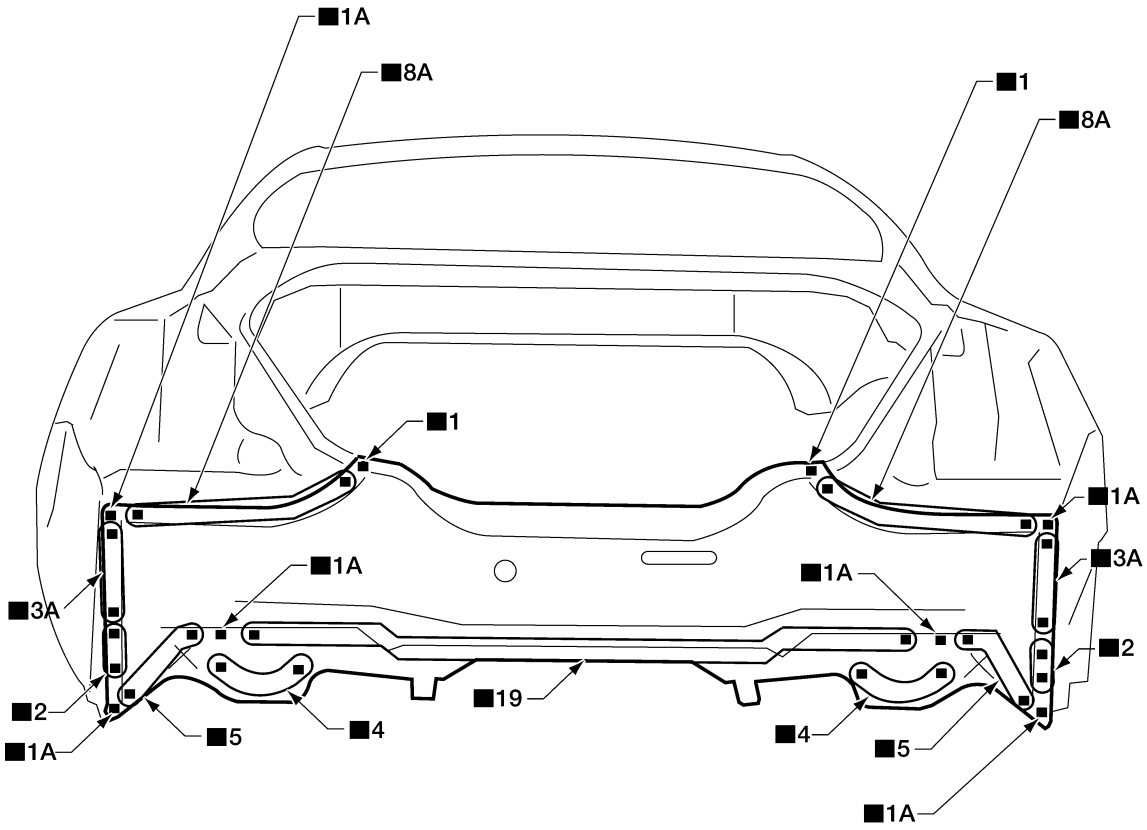
Change parts

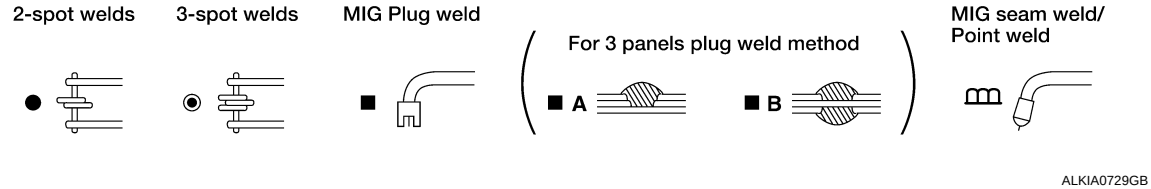
- Rear fender

Rear Panel

INFOID:0000000001345605

Service Joint





ALKIA0729GB

Change parts

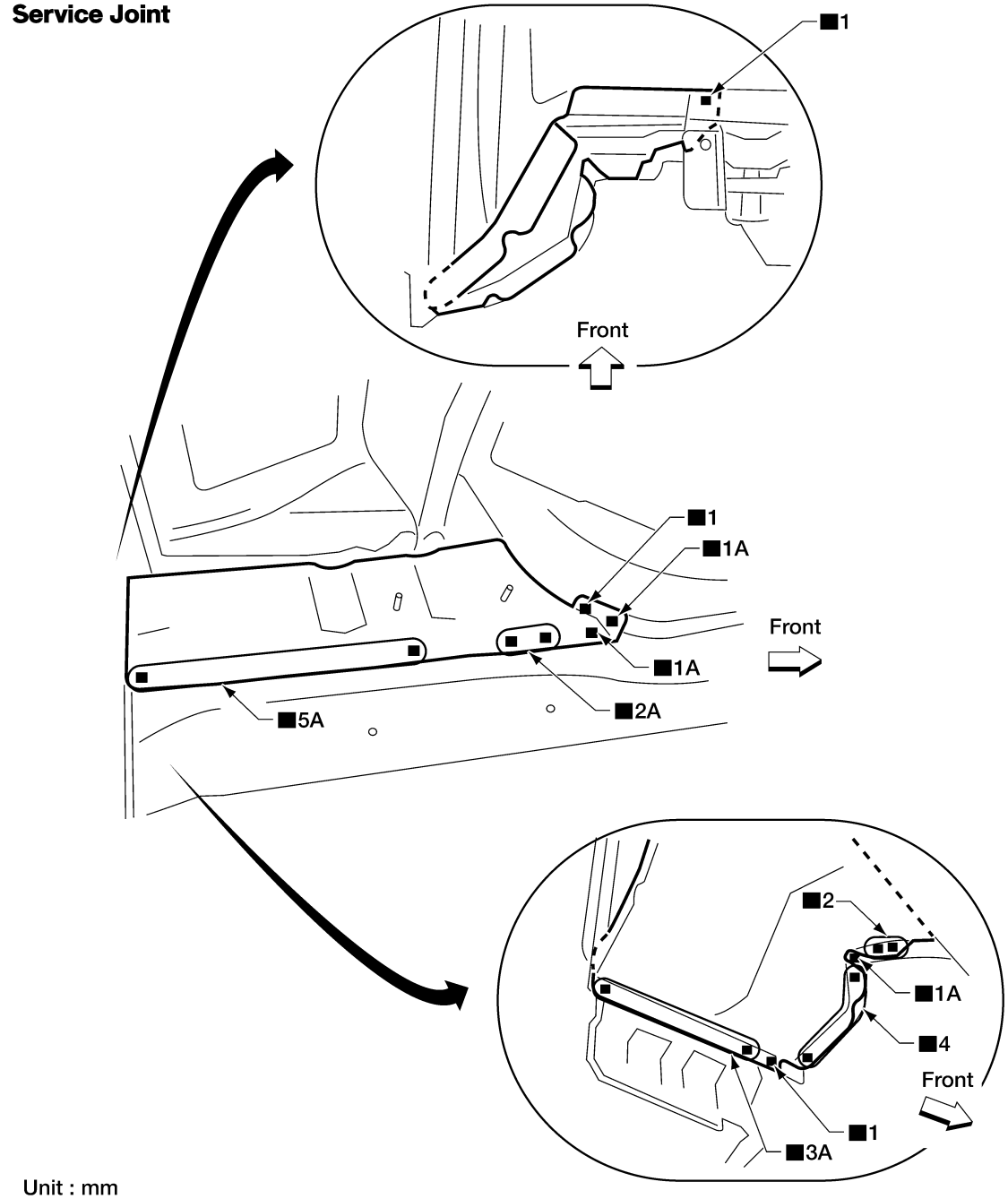
- Rear panel assembly

Rear Floor Rear LH

INFOID:0000000001527652

- Work after rear panel assembly has been removed.

Service Joint



Change parts

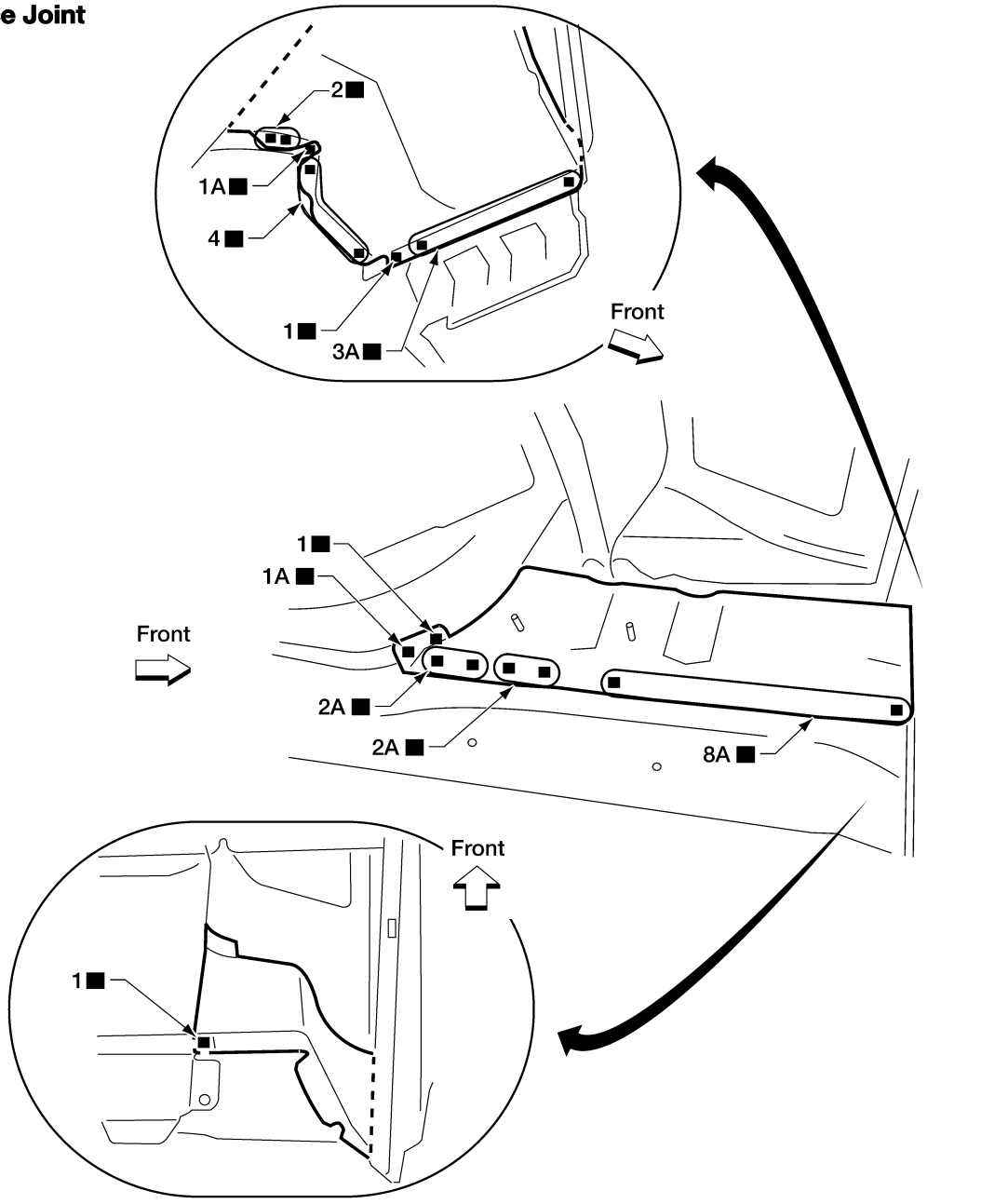
- Rear floor rear LH

Rear Floor Rear RH

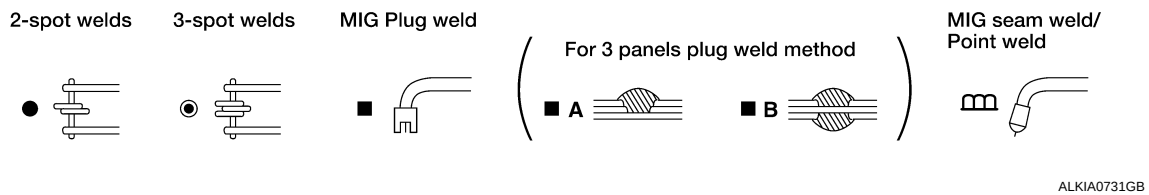
INFOID:0000000001527653

- Work after rear panel assembly has been removed.

Service Joint



Unit : mm



ALKIA0731GB

Change parts

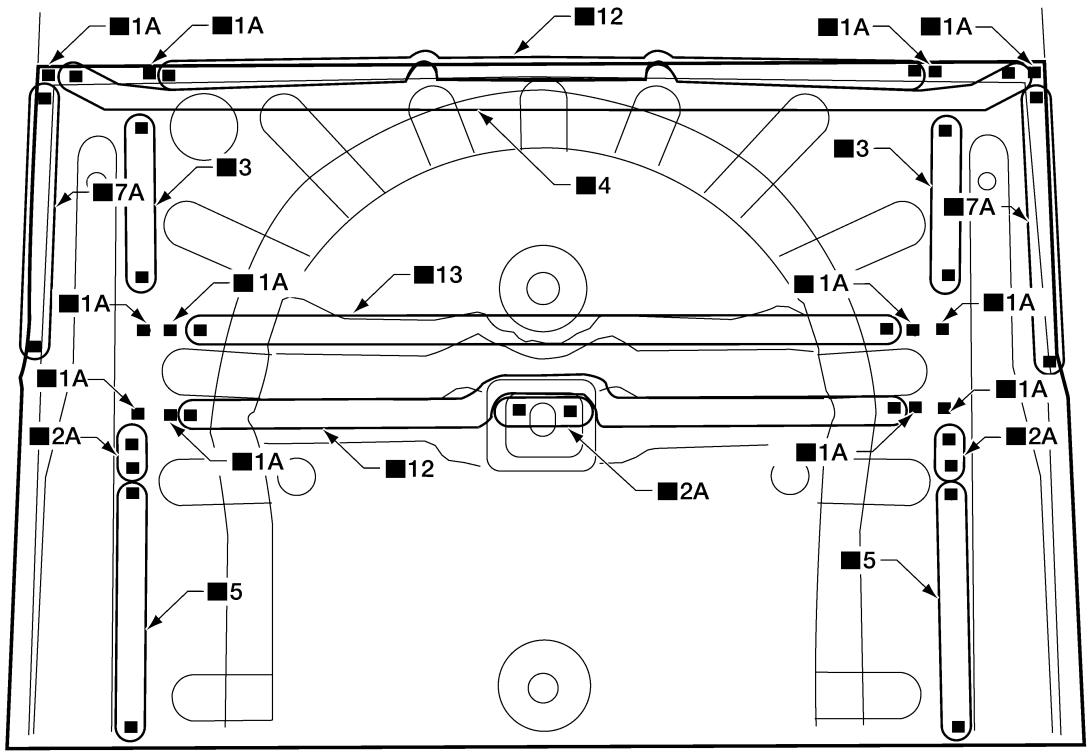
- Rear floor rear RH

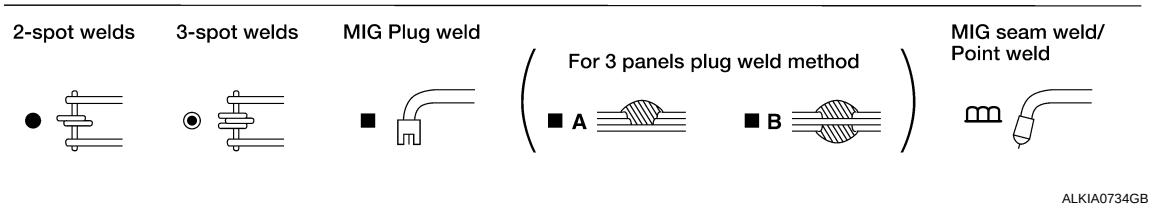
Rear Floor Rear

INFOID:0000000001345606

- Work after rear panel assembly, rear floor rear LH, and rear floor rear RH have been removed.

Service Joint





ALKIA0734GB

Change parts

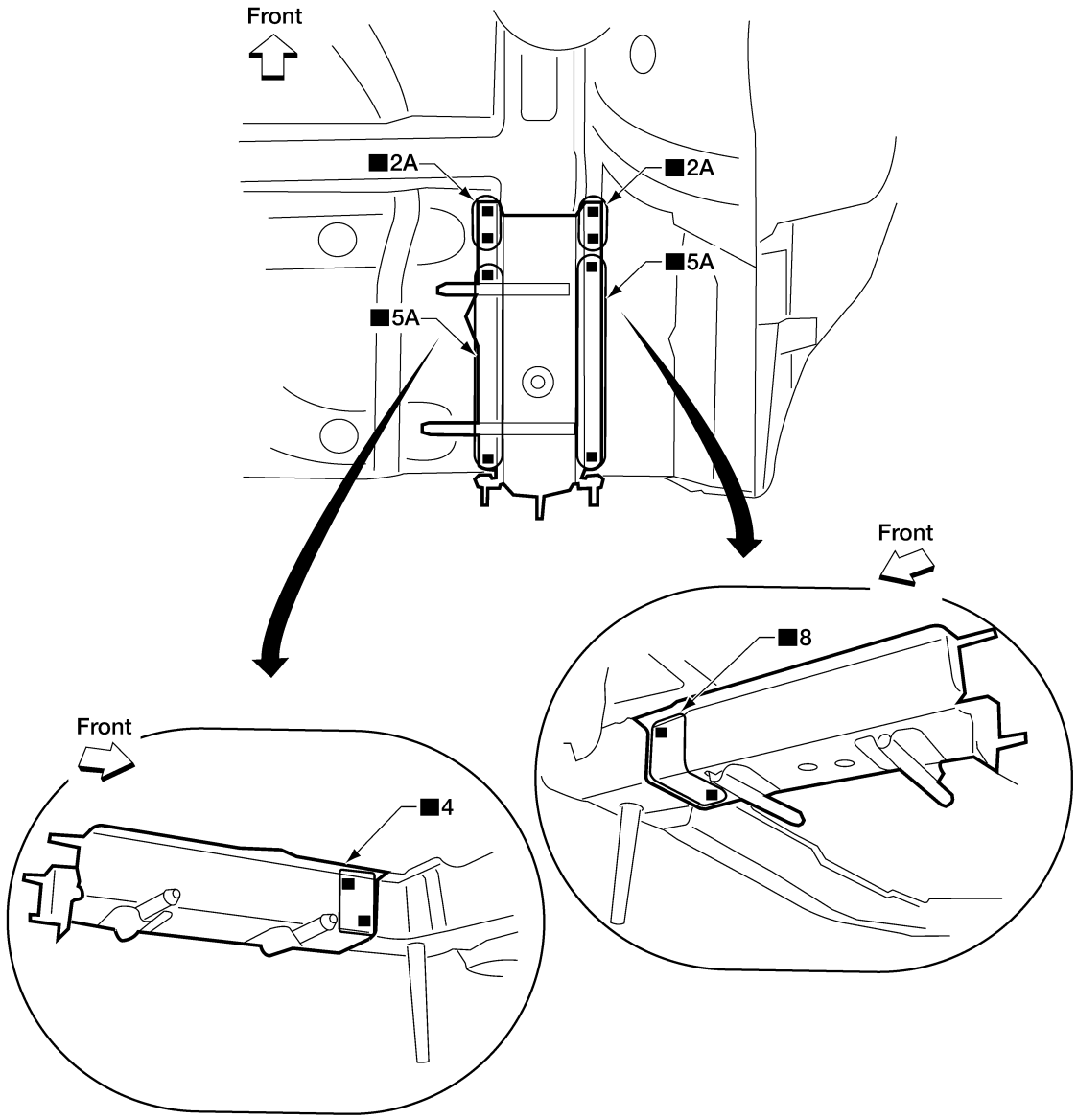
- Rear floor rear

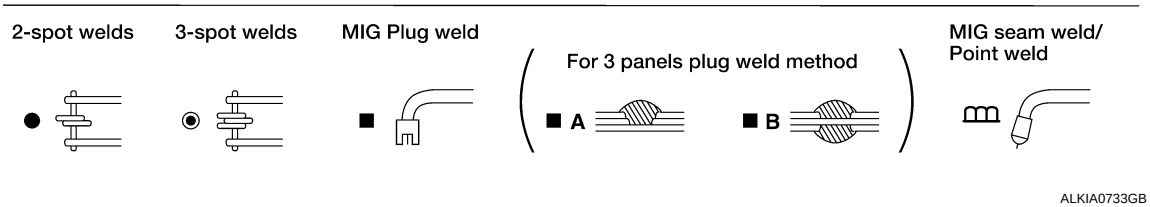
Rear Side Member Extension

INFOID:0000000001345607

- Work after rear panel assembly has been removed.

Service Joint





ALKIA0733GB

Change parts

- Rear side member extension

Foam Repair

INFOID:0000000001345608

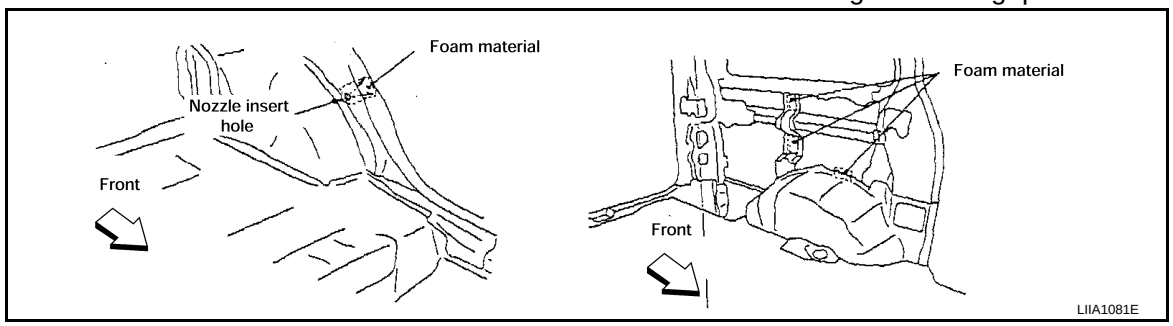
During factory assembly, foam insulators are installed in certain body panels and locations around the vehicle. Use the following procedure(s) to replace any factory-installed foam insulators.

URETHANE FOAM APPLICATIONS

Use commercially available spray for sealant (foam material) repair of material used on vehicle. Read instructions on product for fill procedures.

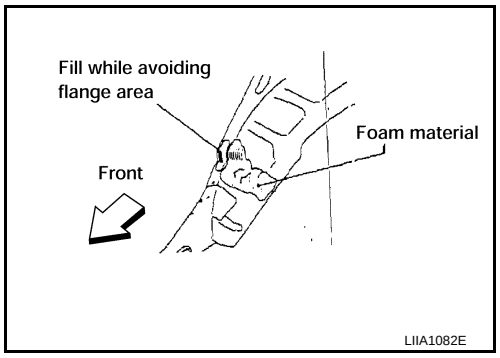
FILL PROCEDURES

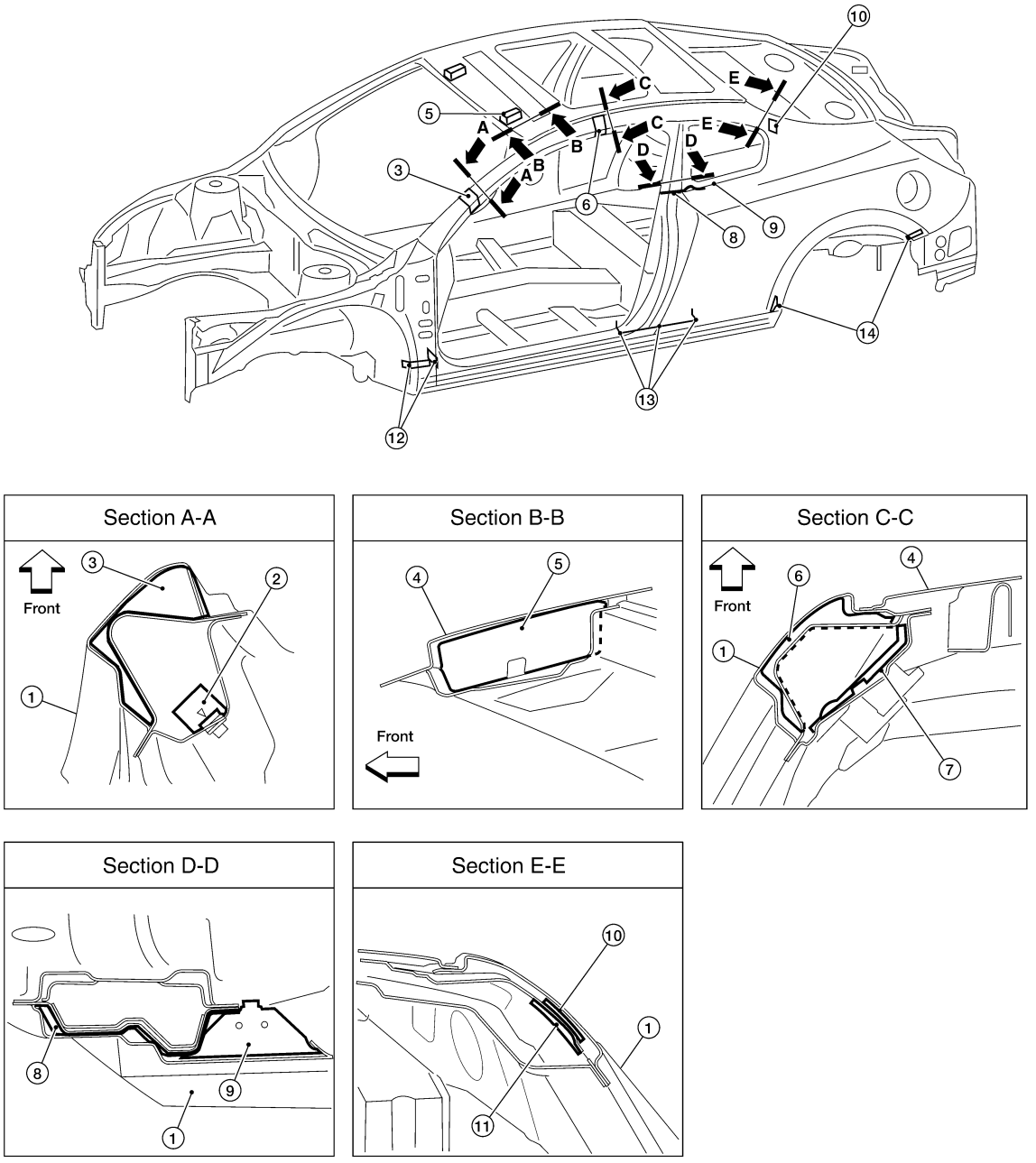
1. Fill procedures after installation service part.
   - Remove foam material remaining on vehicle side.
   - Clean area in which foam was removed.
   - Install service part.
   - Insert nozzle into hole near fill area and fill foam material or fill in enough to close gap with service part.



2. Fill procedures before installation service part

- Remove foam material remaining on vehicle side.
- Clean area in which foam material on wheelhouse outer side.
  NOTE:
  Fill in enough to close gap with service part while avoiding flange area.
- Install service part.
  NOTE:
  Refer to label for information on working times.





ALKIA0809GB

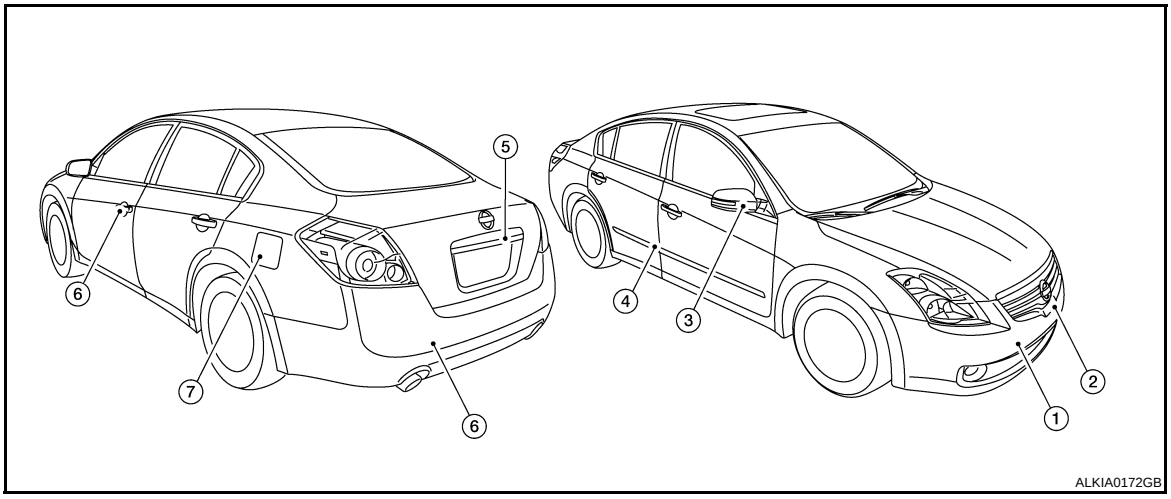
1. Body side outer
2. Body side insulation (expanding foam baffle) upper front pillar
3. Body side insulation (expanding foam tape) front pillar
4. Roof panel assembly
5. Roof panel insulation (expanding foam baffle) front roof rail
6. Body side insulation (expanding foam tape) rear pillar
7. Body side insulation (expanding foam baffle) roof side
8. Body side insulation (expanding foam tape) lock pillar upper
9. 9.Body side insulation (expanding foam baffle) lock pillar upper
10. Body side insulation (expanding foam tape) upper rear pillar
11. Body side insulation (expanding foam tape) inner upper rear pillar
12. Body side insulation (expanding foam tape) hinge pillar lower
13. body side insulation (expanding foam tape) lock pillar lower
14. Body side insulation (expanding foam tape) rear wheel well

FEATURES OF NEW MODEL

BODY EXTERIOR PAINT COLOR

Body Exterior Paint Color

INFOID:0000000003110805



Component			Color code	A15	BW9	C43	J40	K12	K50	KH3	QX3	W40
			Description	Sonoma Sunset	Majestic Blue	Pebble Beach	Metallic Jade	Radiant Silver	Dark-Slate	Super Black	Winter Frost	Precision Grey
			Paint type	PM	PM	M	PM	M	M	2S	3P	M
			Hard clear coat	×	×	×	-	×	-	-	-	-
1	Bumper fascia		Body color	A15	BW9	C43	J40	K12	K50	KH3	QX3	BWV2
2	Front grille		Chromium-plate + Smoke clear	Cr + HFM-09	Cr + HFM-09	Cr + HFM-09	Cr + HFM-09	Cr + HFM-09	Cr + HFM-09	Cr + HFM-09	Cr + HFM-09	Cr + HFM-09
3	Door outside mirror	Case	Body color	A15	BW9	C43	J40	K12	K50	KH3	QX3	BWV2
4	Body side molding		Body color	A15	BW9	C43	J40	K12	K50	KH3	QX3	BWV2
5	License plate finisher		Body color	A15	BW9	C43	J40	K12	K50	KH3	QX3	BWV2
6	Door outside handle		Chromium-plate	Cr	Cr	Cr	Cr	Cr	Cr	Cr	Cr	Cr
7	Fuel filler lid		Body color	A15	BW9	C43	J40	K12	K50	KH3	QX3	BWV2

M=Metallic, S= Solid, 2S= Solid and Clear, 2P= 2-stage Pearl, 3P= 3-Stage pearl, PM=Pearl metallic, Black is solvent based, all others are water based.

PRECAUTION

HANDLING PRECAUTIONS FOR PLASTICS

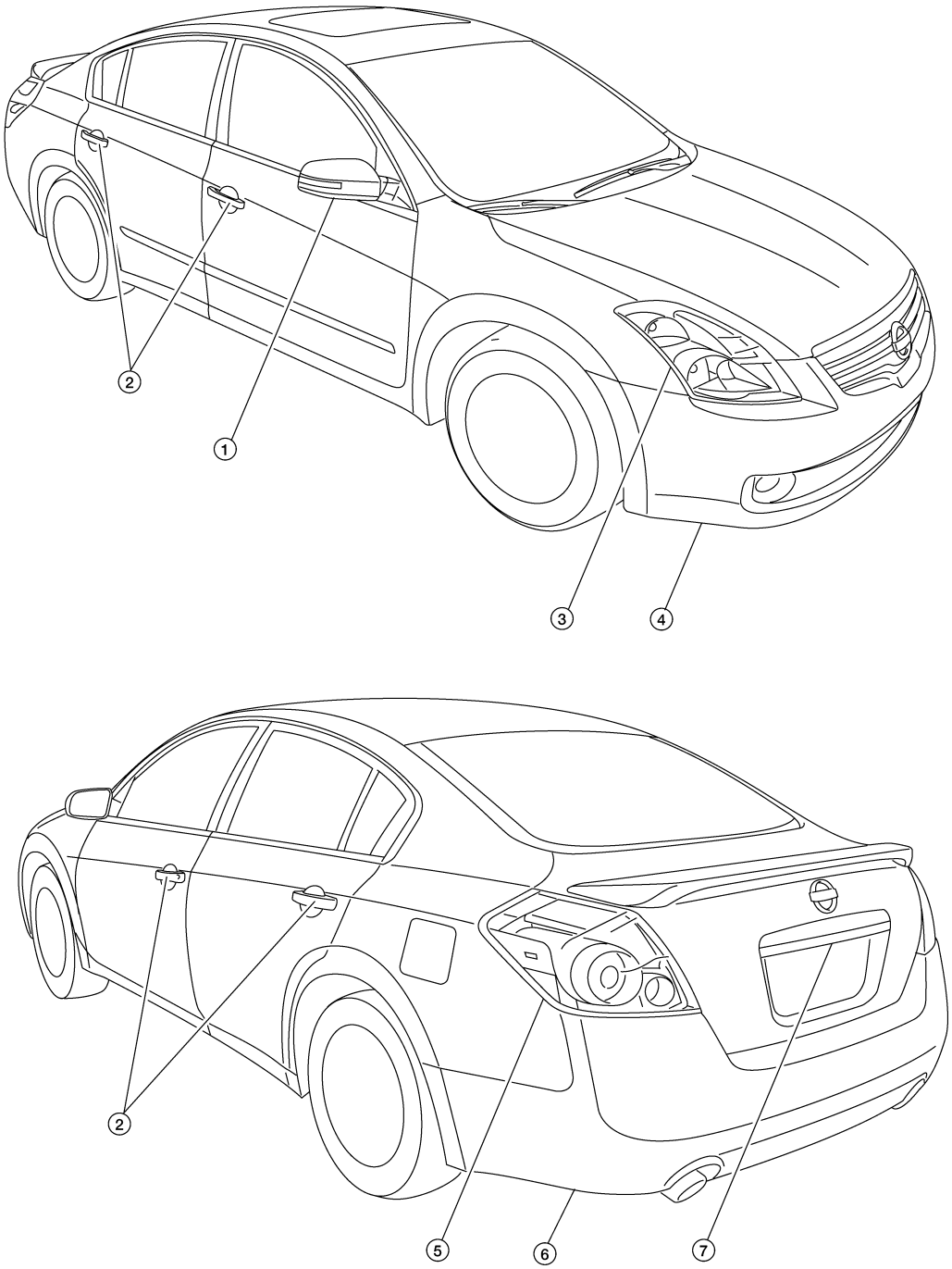
Precautions For Plastics

INFOID:0000000003110806

Abbre-viation	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) co-polymer	80(176)	Same as above.	Flammable
PP	Polypropylene	90(194)	Same as above.	Flammable, avoid bat-tery 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.	
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 wa-ter.
PBT	Poly Butylene Terephthalate	140(284)	Same as above.	
PET	Polyester	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.

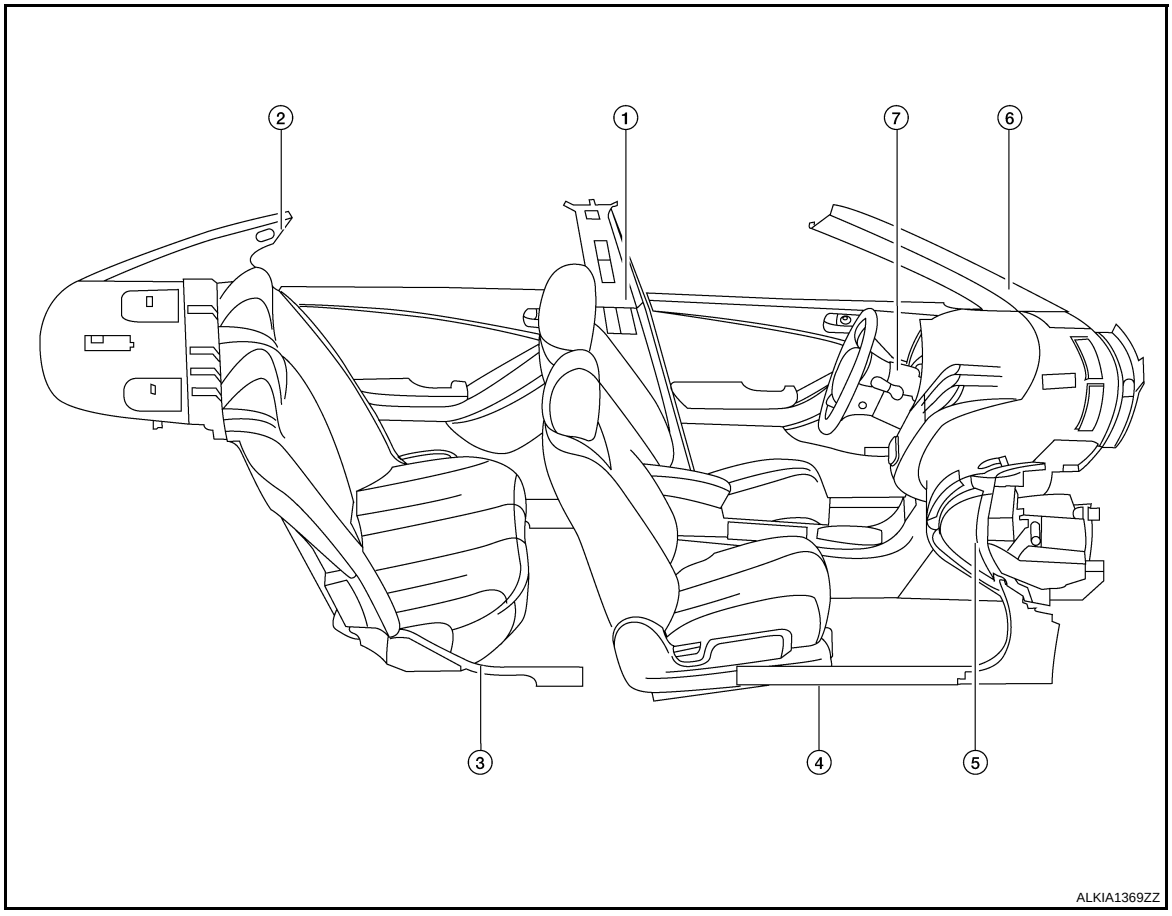
LOCATION OF PLASTIC PARTS



ALKIA1368ZZ

Item	Component		Abbreviation	Material
1.	Door Mirror	Case	ASA	Acronitrile Styrene Acrylate
		Skull cap	ABS	Acronitrile Butadiene Acrylate
2.	Outside door handle	Grip	PC	Polycarbonate
		Escutcheon	PA	Polyamide (Nylon)

Item	Component		Abbreviation	Material
3.	Front combination lamp	Lens	PC	Polycarbonate
		Housing	PP	Polypropylene
4.	Front bumper fascia		PP + EPM	Polypropylene + Ethylene Propylene (Diene) copolymer
5.	Rear combination lamp	Lens	PMMA	Poly Methyl Methacrylate
		Housing	ABS	Acronitrile Butadiene Acrylate
6.	Rear bumper fascia		PP + EPM	Polypropylene + Ethylene Propylene (Diene) copolymer
7.	Trunk lid finisher		ABS + PC	Acronitrile Butadiene Acrylate + Polycarbonate



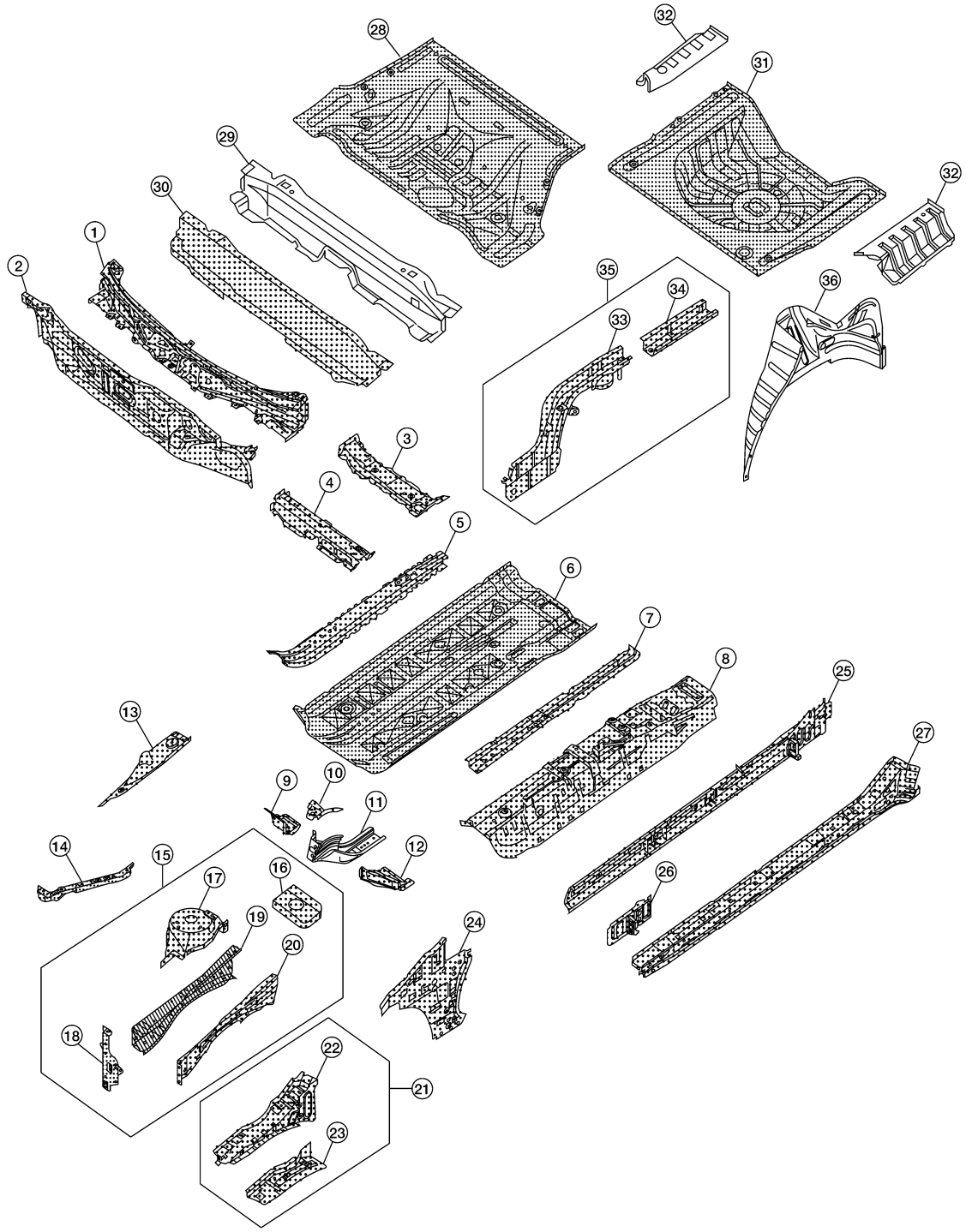
Item	Component	Abbreviation	Material
1.	Center pillar trim	PP	Polypropylene
2.	Upper quarter trim	PP	Polycarbonate
3.	Rear inner kicking plate	PP	Polypropylene
4.	Front inner kicking plate	PP	Polypropylene
5.	Dash side finisher	PP	Polypropylene
6.	Front pillar garnish	PP	Polypropylene
7.	Steering column covers	PP	Polypropylene

ON-VEHICLE REPAIR

BODY COMPONENT PARTS

Underbody Component Parts

INFOID:0000000003110807



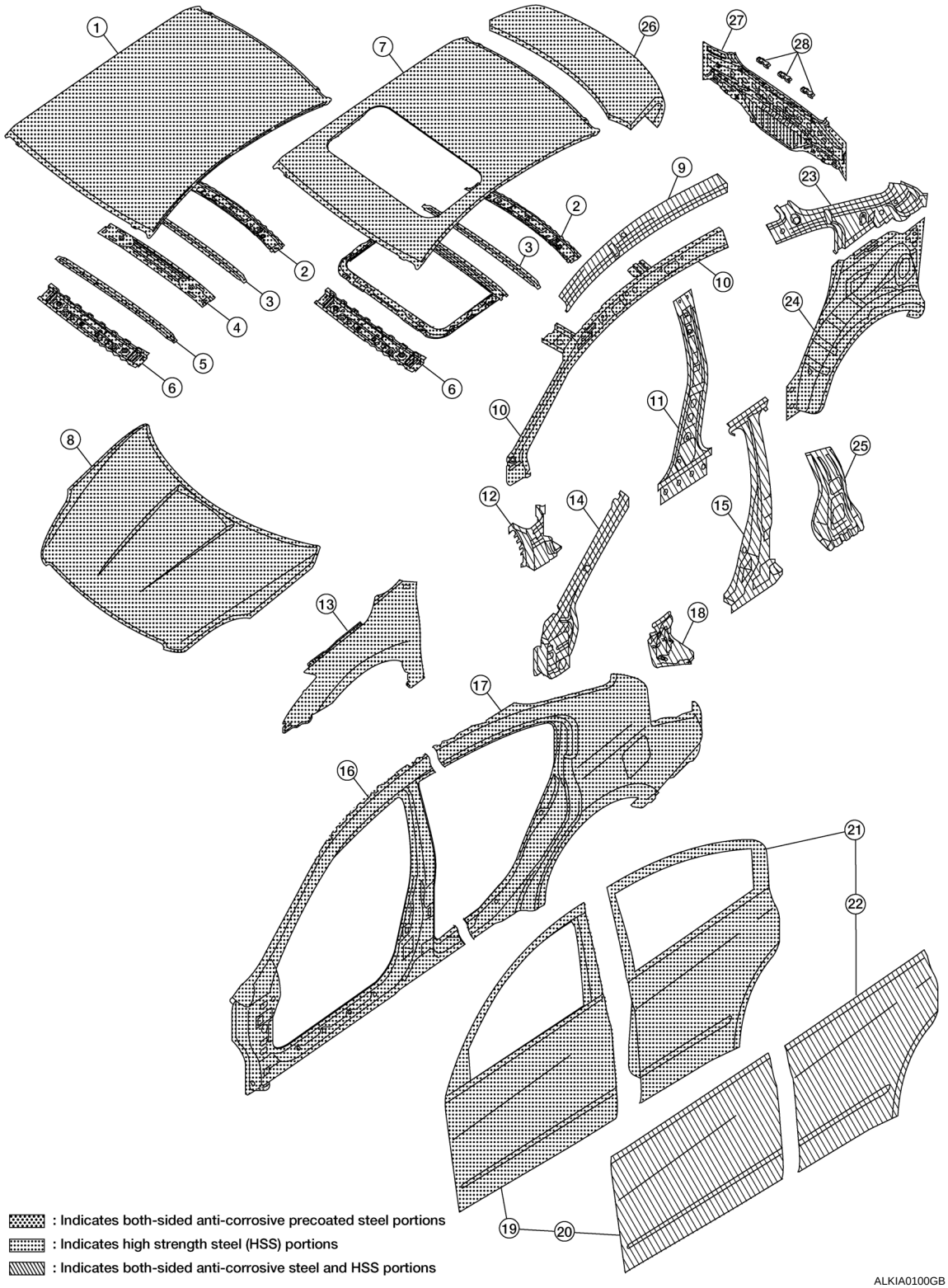
ALKIA0099GB

1. Upper dash assembly
2. Lower dash crossmember reinforcement
3. Rear crossmember (RH, LH)
25. Inner sill (RH, LH)
26. Outer sill support bracket (RH, LH)
27. Outer sill (RH, LH)

4. Front crossmember (RHLH)
5. Front sidemember reinforcement upper (RHLH)
6. Front floor assembly (RHLH)
7. Front sidemember reinforcement lower
8. Front floor center
9. Front suspension member plate (RH, LH)
10. Front sidemember cap (RH, LH)
11. Front sidemember (RH, LH)
12. Outrigger (RH, LH)
13. Lower hoodledge support (RH, LH)
14. Radiator core support (RH, LH)
15. Front sidemember assembly (RH, LH)
16. Strut housing bracket (RH, LH)
17. Strut housing (RH, LH)
18. Radiator core support side (RH, LH)
19. Front sidemember extension (RH, LH)
20. Closing plate (RH, LH)
21. Hoodledge assembly (RH, LH)
22. Upper hoodledge (RH, LH)
23. Upper hoodledge lower (RH, LH)
24. Dash side (RH, LH)
28. Rear floor front
29. Rear seat crossmember
30. Rear seat crossmember lower
31. Rear floor rear
32. Rear floor rear side (RH, LH)
33. Rear side member (RH, LH)
34. Rear side member extension (RH, LH)
35. Rear side member assembly (RH, LH)
36. Rear wheel housing outer (RH, LH)

Body Component Parts

INFOID:0000000003110808



1. Roof panel assembly
2. Rear roof rail
3. 3rd roof rail
4. 2nd roof rail
5. 1st roof rail
6. Front roof rail
21. Rear door assembly (RH, LH)
22. Outer rear door panel (RH, LH)
23. Rear roof rail reinforcement (RH, LH)
24. Rear wheel well housing outer (RH, LH)
25. Rear pillar inner reinforcement (RH, LH)
26. Trunk lid assembly (RH, LH)

7. Sun roof panel assembly
8. Hood assembly
9. Roof side rail reinforcement (RH, LH)
10. Outer roof side rail (RH, LH)
11. Inner center pillar (RH,LH)
12. Front pillar reinforcement (RHLH)
13. Fender (RH, LH)
14. Front pillar inner (RH, LH)
15. Center pillar reinforcement (RH, LH)
16. Side body (RH, LH)
17. Rear fender (RH, LH)
18. Rear fender corner (RH, LH)
19. Front door assembly (RH, LH)
20. Outer front door panel (RH, LH)
27. Rear bumper fascia center bracket (RH, LH)

CORROSION PROTECTION

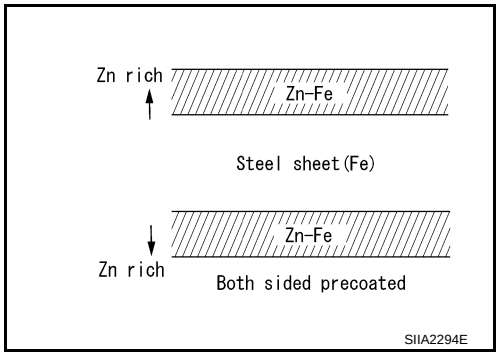
Description

INFOID:0000000003110809

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.



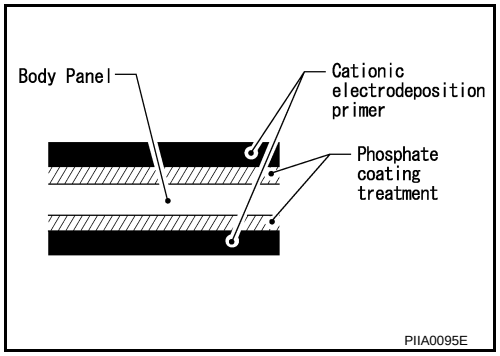
Nissan Genuine Service Parts are fabricated from galvannealed steel. Therefore, it is recommended that GENUINE NISSAN PARTS or equivalent be used for panel replacement to maintain the anti-corrosive performance built into the vehicle at the factory.

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.



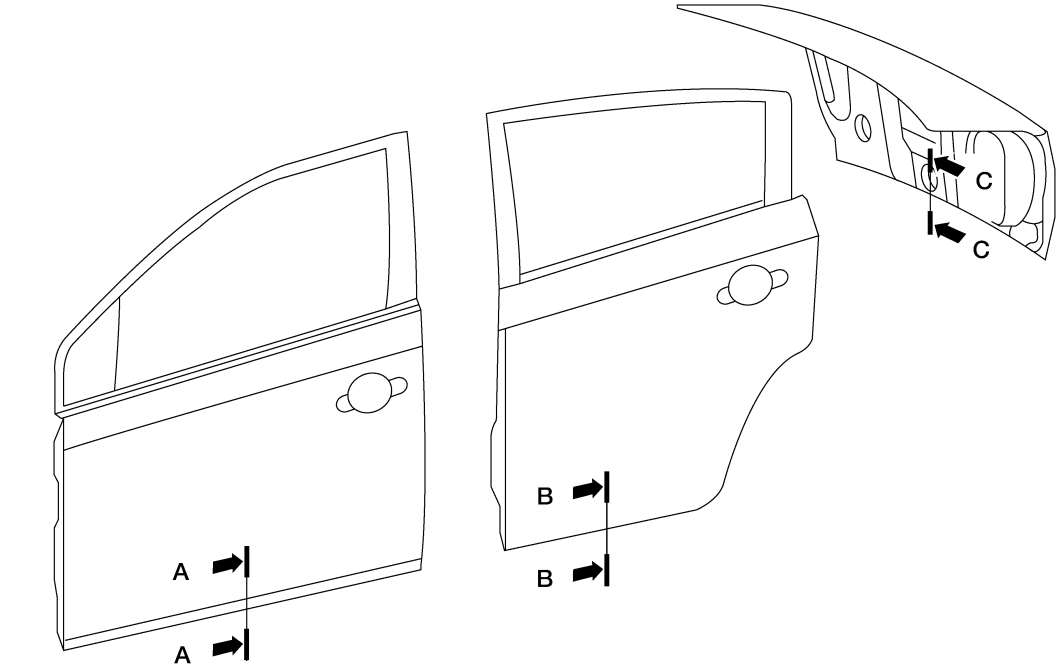
Nissan Genuine Service Parts are also treated in the same manner. Therefore, it is recommended that GENUINE NISSAN PARTS or equivalent be used for panel replacement to maintain anti-corrosive performance built into the vehicle at the factory.

Anti-Corrosive Wax

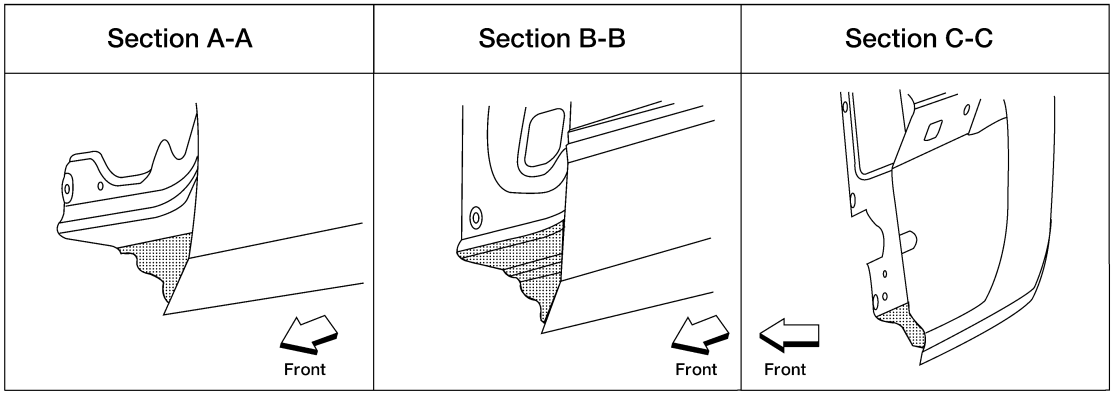
INFOID:0000000003110810

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.



: Indicates anti-corrosive wax coated portions



ALKIA0146GB

Undercoating

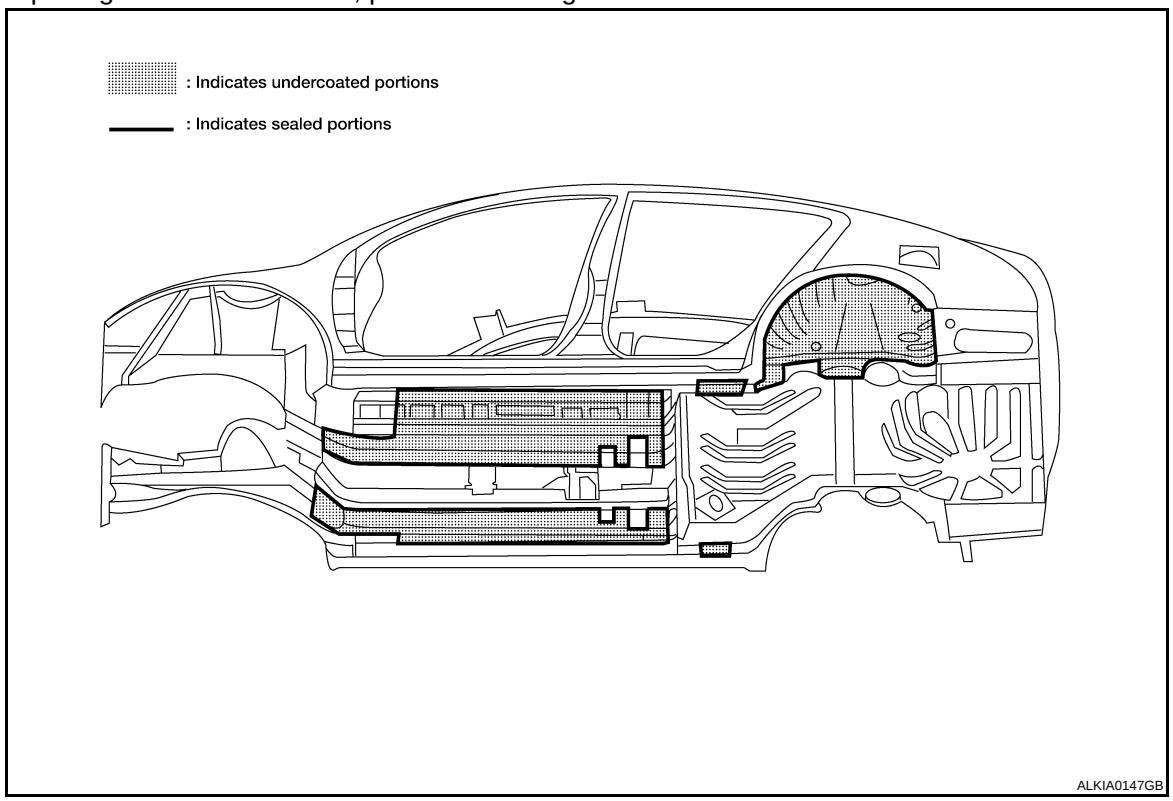
INFOID:0000000003110811

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 preventive, soundproof, vibration-proof, shock-resistant, adhesive, and durable.

Precautions in Undercoating

1. Do not apply undercoating to any place unless specified (such as the areas above the muffler and three way catalyst which are subjected to heat).
2. Do not undercoat the exhaust pipe or other parts which become hot.
3. Do not undercoat rotating parts.
4. Apply bitumen wax after applying undercoating.

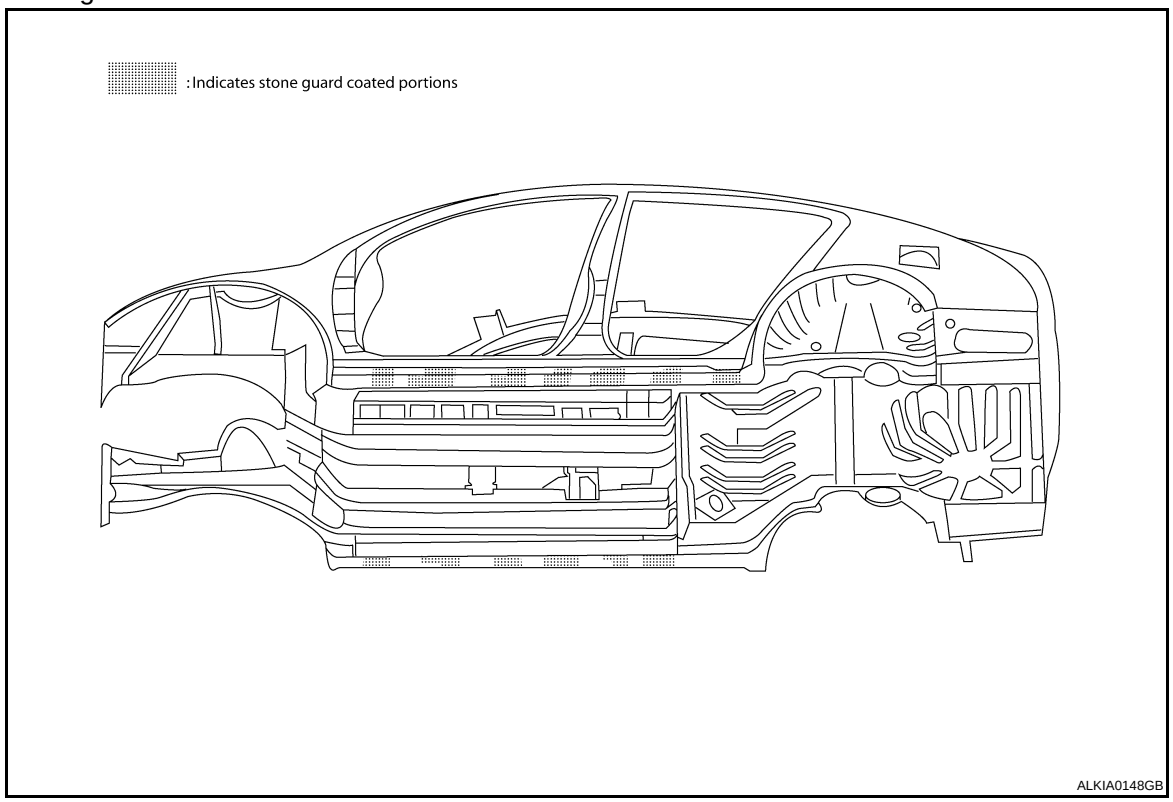
5. After putting seal on the vehicle, put undercoating on it.



Stone Guard Coat

INFOID:0000000003110812

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.

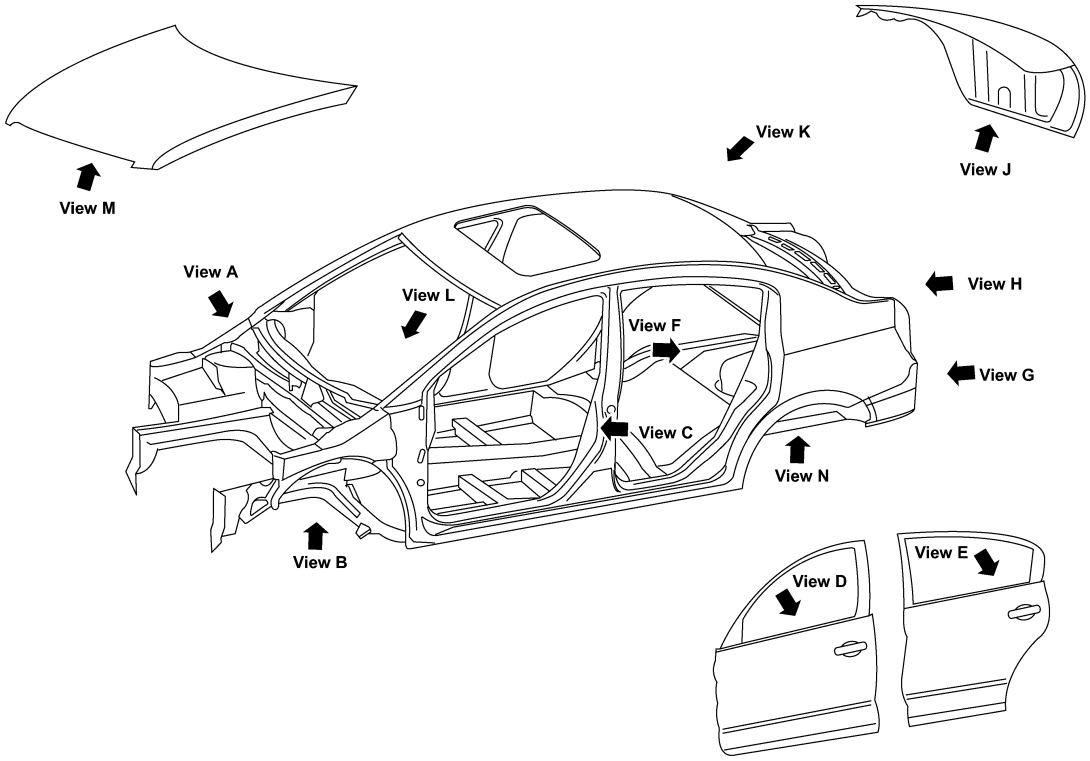


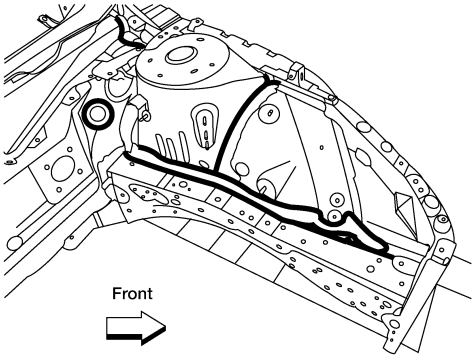
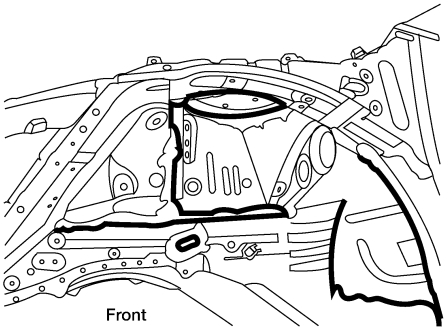
BODY SEALING

Description

INFOID:0000000003110813

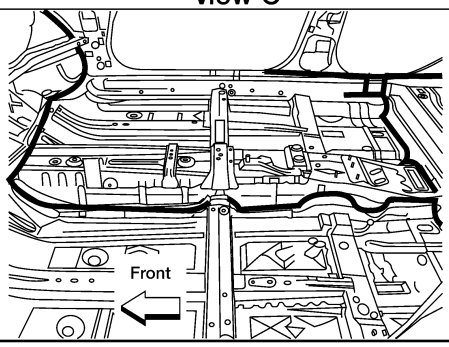
The following figure shows the areas which are sealed at the factory. Sealant which has been applied to these areas should be smooth and free from cuts or gaps. Care should be taken not to apply an excess amount of sealant and not to allow other unaffected parts to come into contact with the sealant.



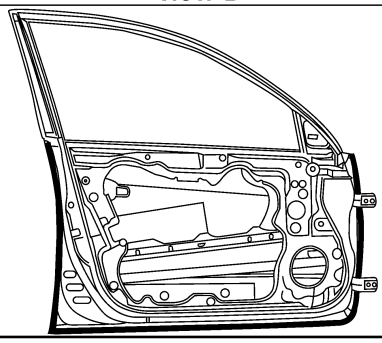
View A	View B
	

ALKIA0149GB

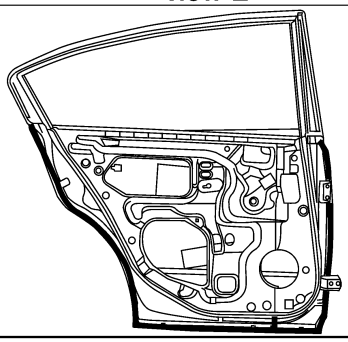
View C



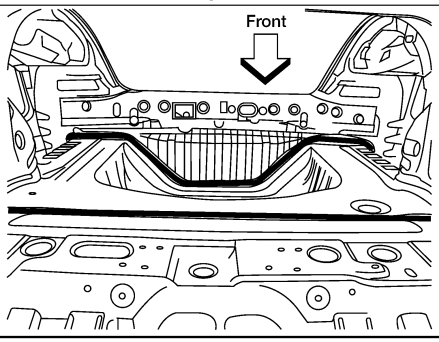
View D



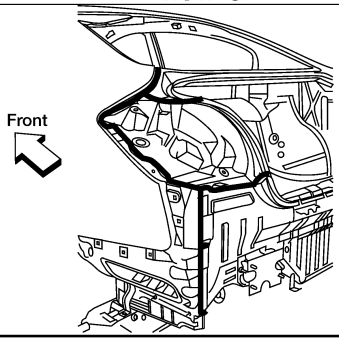
View E



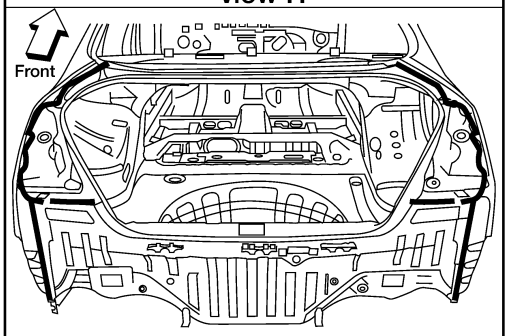
View F



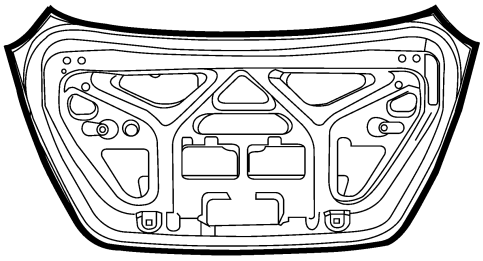
View G



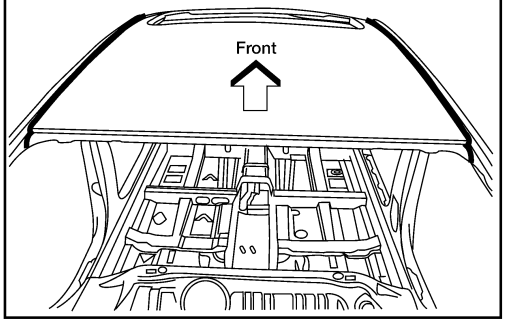
View H



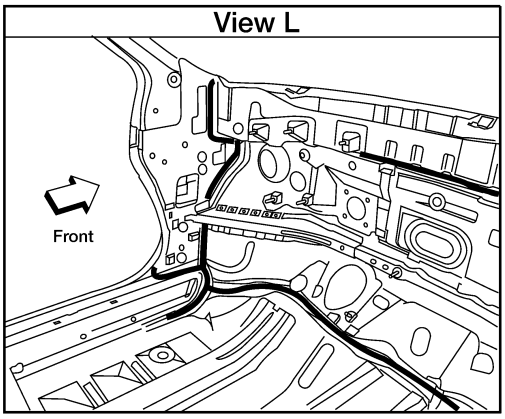
View J

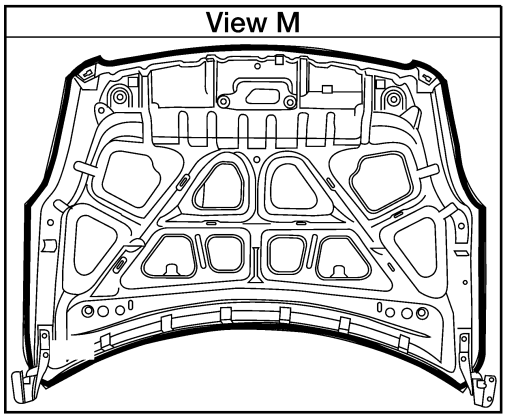


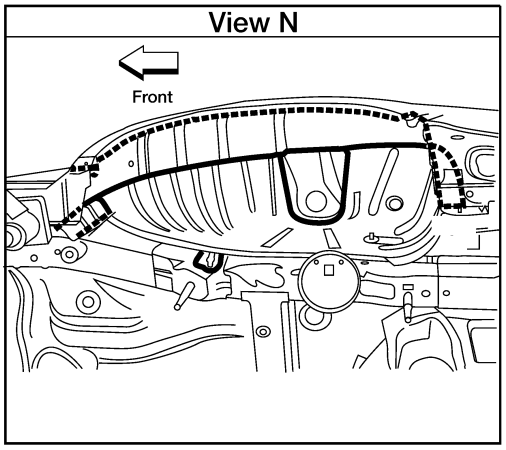
View K



AWKIA0001GB





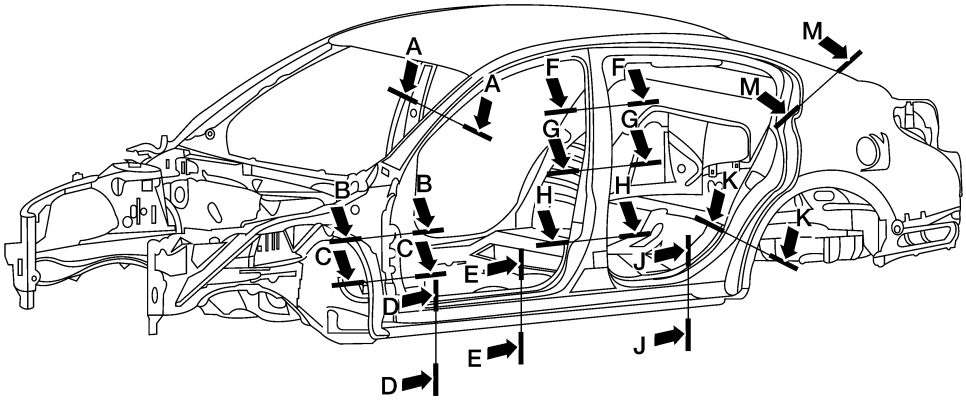


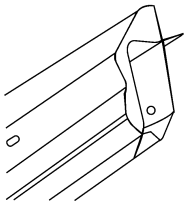
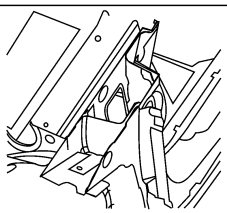
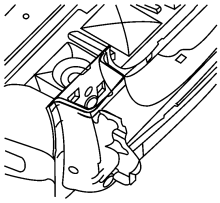
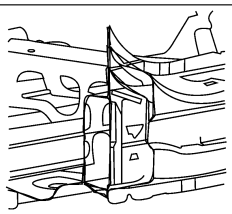
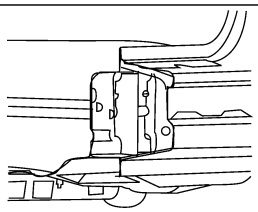
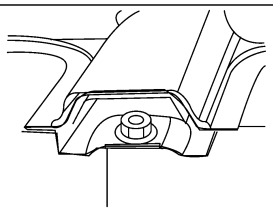
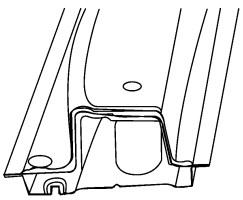
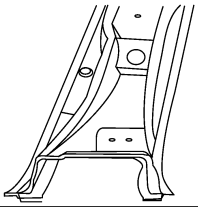
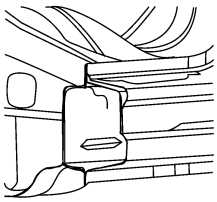
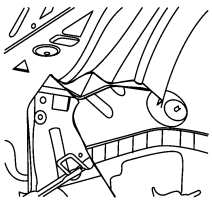
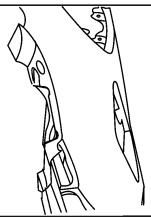
AWKIA0002GB

BODY CONSTRUCTION

Body Construction

INFOID:0000000003110814



Section A-A	Section B-B	Section C-C
		
Section D-D	**Section E-E**	**Section F-F**
		
Section G-G	**Section H-H**	**Section J-J**
		
Section K-K	**Section M-M**	
		

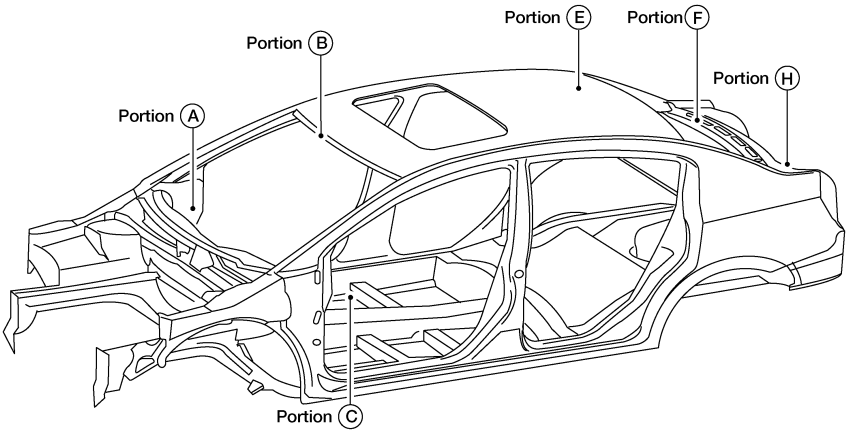
ALKIA0150GB

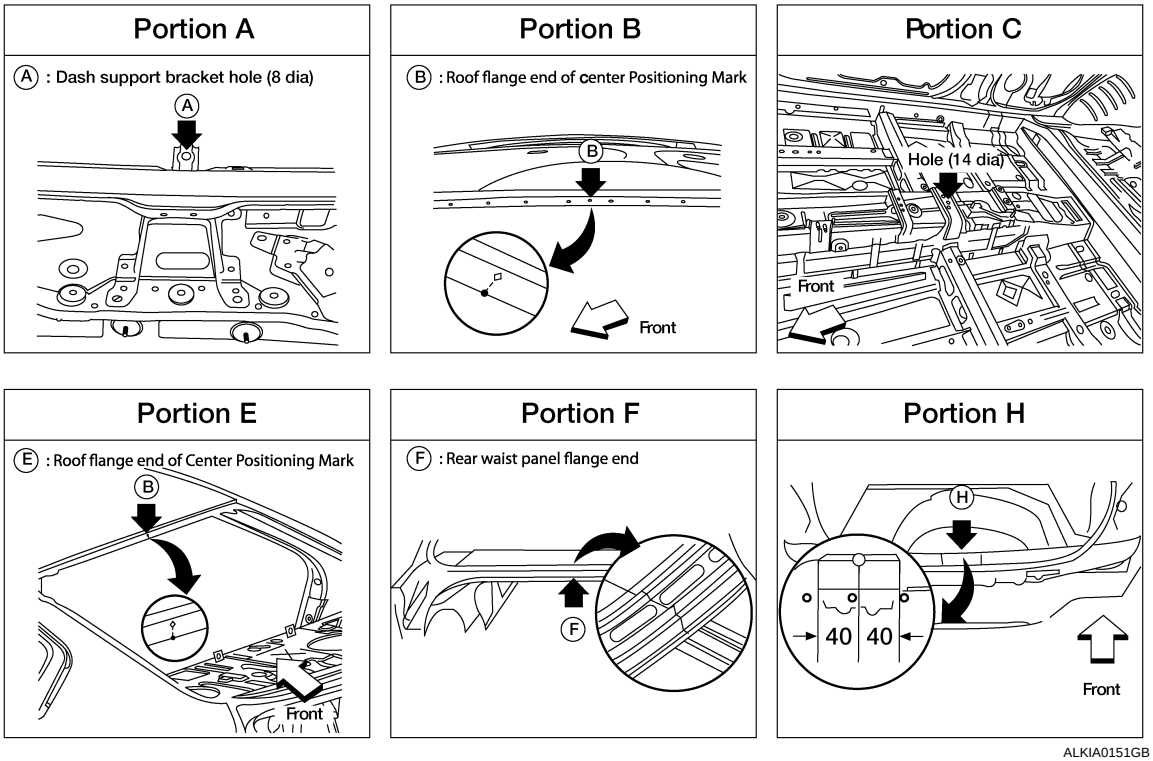
BODY ALIGNMENT

Body Center Marks

INFOID:0000000003110815

A mark has been placed on each part of the body to indicate the vehicle center. When repairing parts damaged by an accident which might affect the vehicle frame (members, pillars, etc.), more accurate and effective repair will be possible by using these marks together with body alignment specifications.



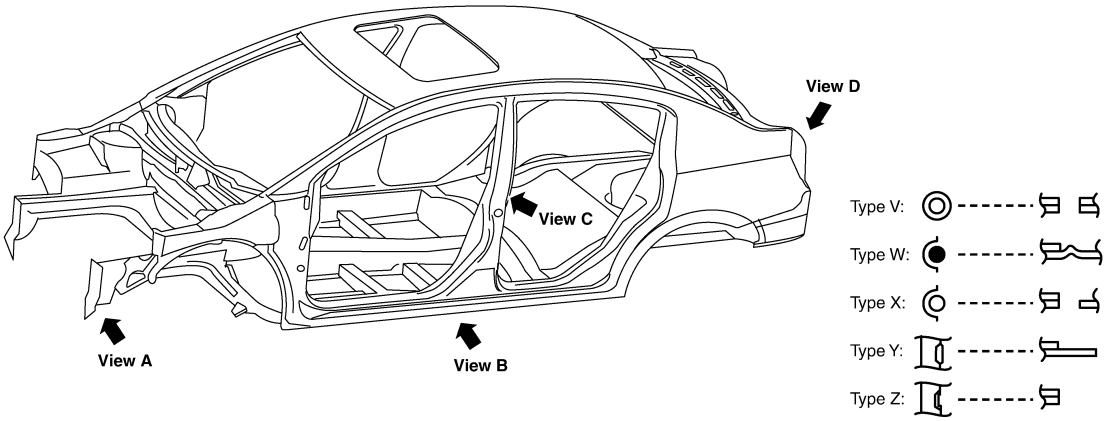


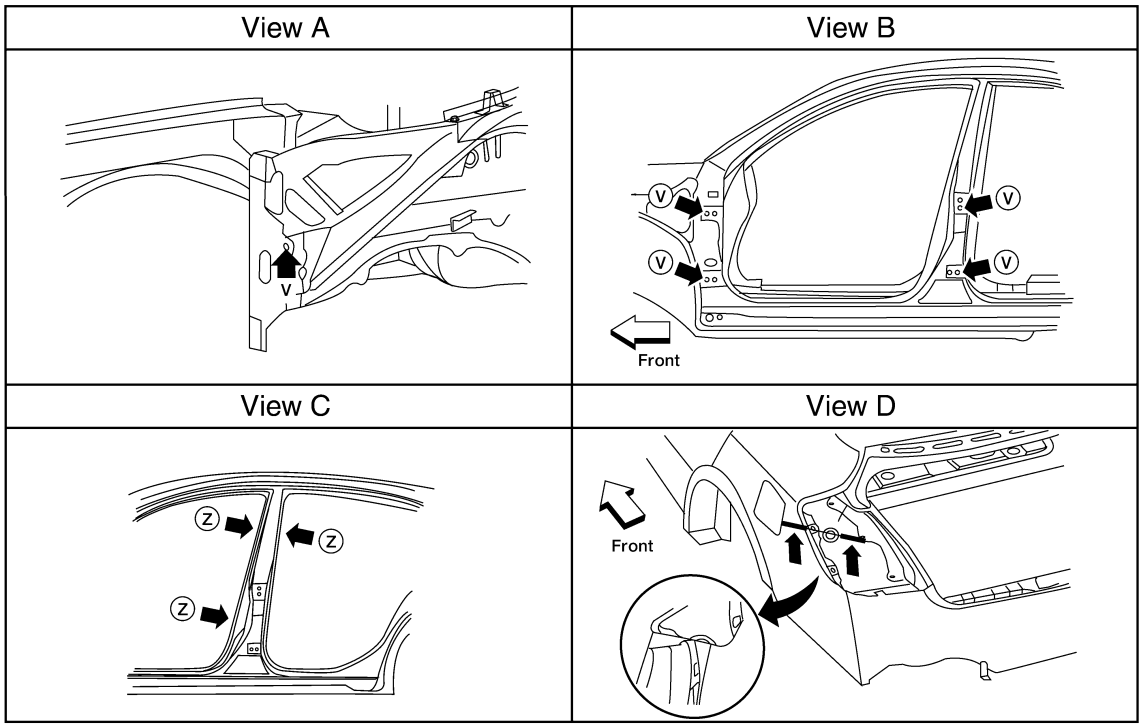
ALKIA0151GB

Panel Parts Matching Marks

INFOID:0000000003110816

A mark has been placed on each body panel to indicate the parts matching positions. When repairing parts damaged by an accident which might affect the vehicle structure (members, pillars, etc.), more accurate and effective repair will be possible by using these marks together with body alignment specifications.



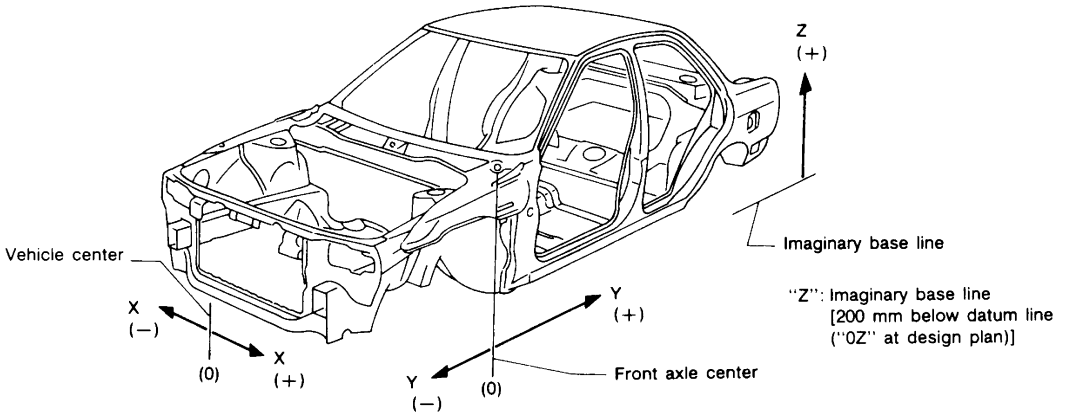


ALKIA0159GB

Description

INFOID:0000000003110817

- 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″.

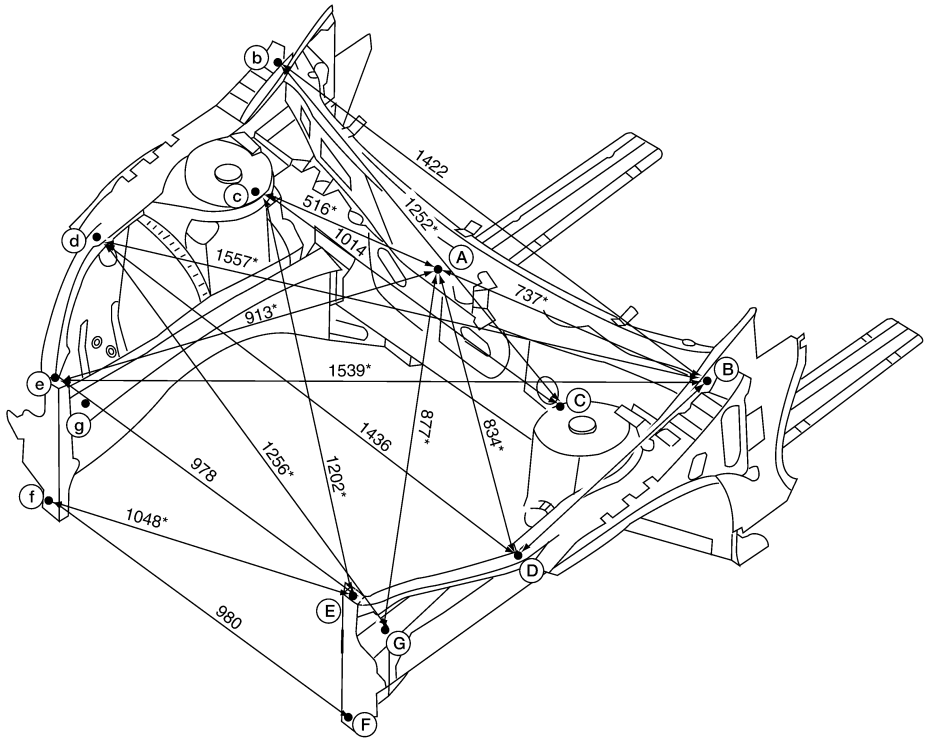

Z
(+)
Imaginary base line
"Z": Imaginary base line
[200 mm below datum line
("0Z" at design plan)]
Vehicle center
X
(−)
(0)
X
(+)
Y
(+)
Y
(−)
(0)
Front axle center
PIIA0104E

Engine Compartment

INFOID:0000000003110818

Measurement

Figures marked with a (*) indicate symmetrically identical dimensions on both right and left sides of the vehicle.

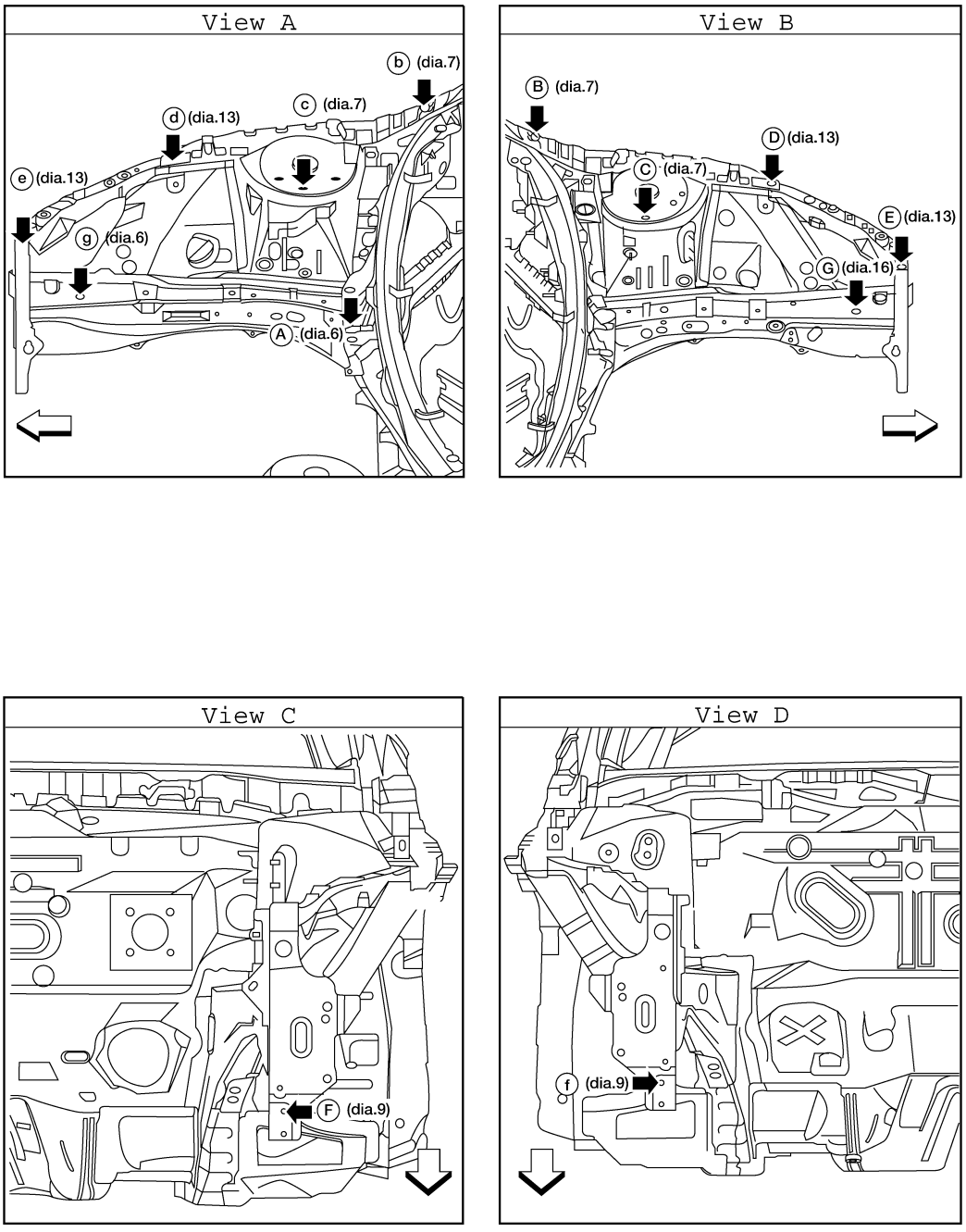


Point	Dimension
Ⓑ ~ Ⓓ	617*
Ⓑ ~ Ⓔ	989*
Ⓑ ~ Ⓖ	1512*
Ⓒ ~ Ⓑ	1268*
Ⓒ ~ Ⓓ	389*
Ⓒ ~ Ⓔ	673*
Ⓒ ~ Ⓖ	630*
Ⓒ ~ ⓖ	1182*
Ⓓ ~ Ⓖ	394*
Ⓔ ~ Ⓖ	201*
Ⓖ ~ ⓖ	990

Unit : mm

ALKIA0168GB

Measurement Points



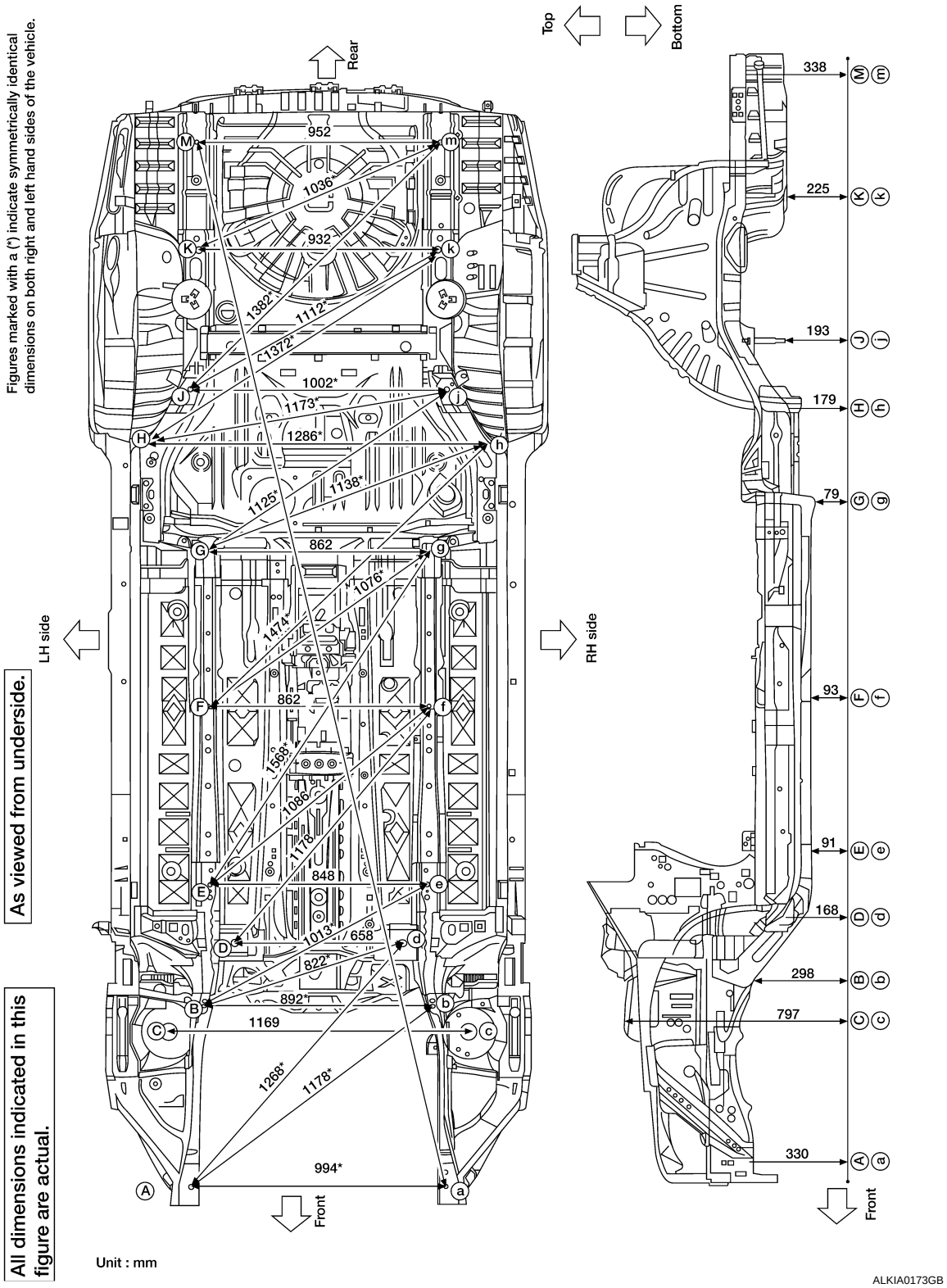
Unit : mm

AWKIA0389GB

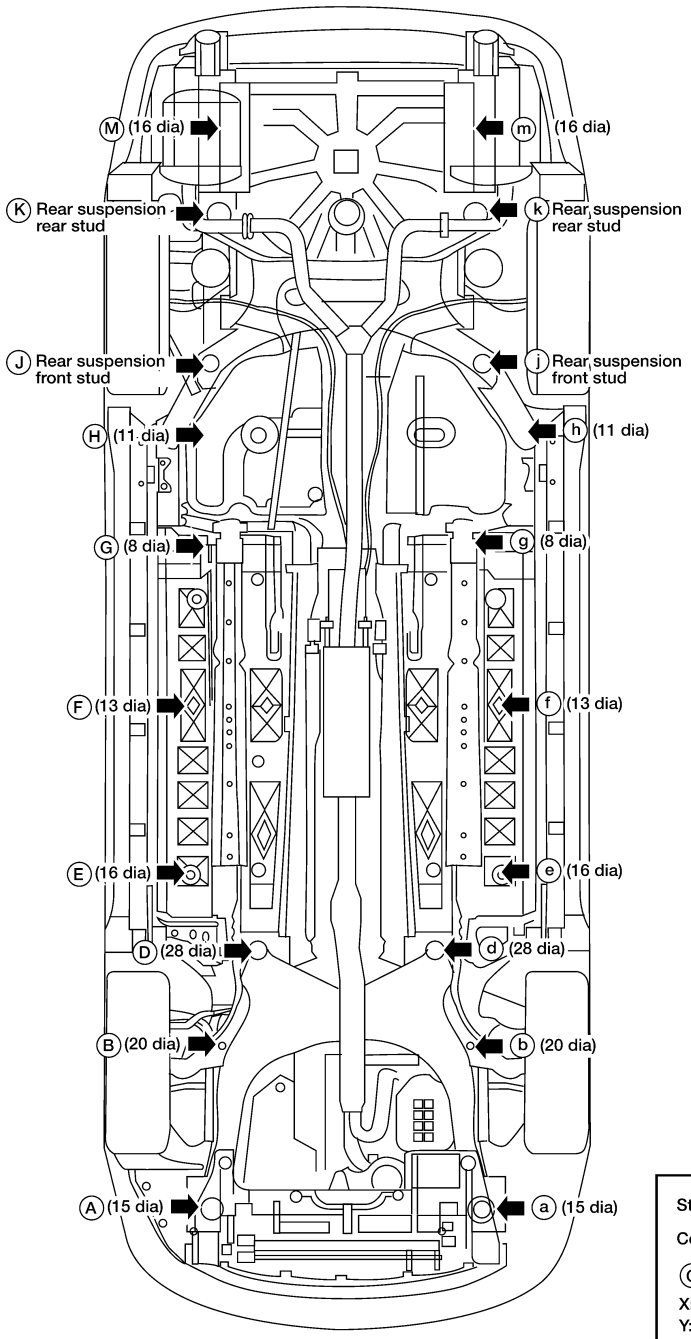
Underbody

INFOID:0000000003110819

Measurement



Measurement Points



Ⓐ ⓐ
X : 556
Y : ±497
Z : 330

Ⓑ ⓑ
X : 149
Y : ±446
Z : 298

Ⓓ ⓓ
X : 395
Y : ±327
Z : 168

Ⓔ ⓔ
X : 624
Y : ±424
Z : 91

Ⓕ ⓕ
X : 1294
Y : ±431
Z : 93

Ⓖ ⓖ
X : 1938
Y : ±431
Z : 79

Ⓗ ⓗ
X : 2301
Y : ±643
Z : 79

Ⓙ ⓙ
X : 2558
Y : ±501
Z : 193

Ⓚ ⓚ
X : 3107
Y : ±466
Z : 225

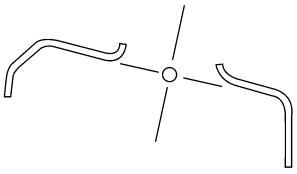
Ⓜ ⓜ
X : 3525
Y : ±476
Z : 338

Strut tower centers

Coor

Ⓒ ⓒ Front

X: 49
Y: ± 585
Z : 597



Unit : mm

ALKIA0174GB

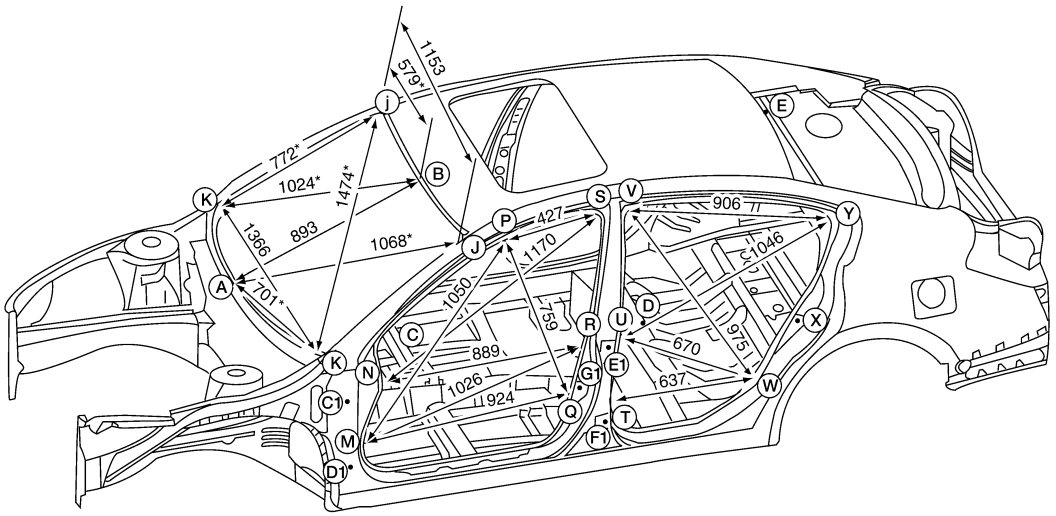
Passenger Compartment

INFOID:0000000003110820

Measurement

Unit : mm

Figures marked with a (*) indicate symmetrically identical dimensions on both right and left sides of the vehicle.



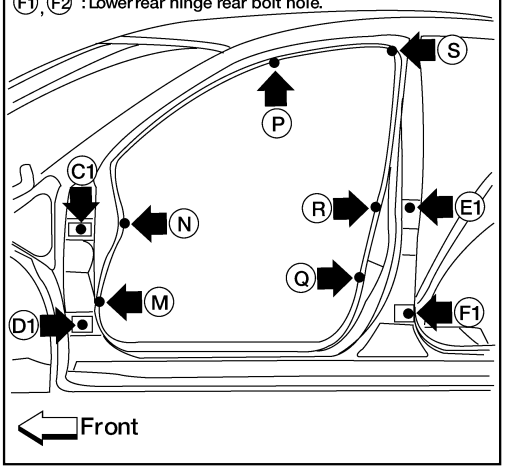
Point	Dimension	Point	Dimension	Point	Dimension	Point	Dimension
Ⓐ ~ Ⓒ	1044	Ⓓ ~ Ⓣ	742	Ⓖ1 ~ Ⓧ	987	Ⓢ ~ Ⓠ	779
Ⓐ ~ Ⓓ	1890	Ⓓ ~ ⓣ	904	Ⓜ ~ ⓜ	1464	Ⓢ ~ ⓢ	1143
Ⓐ ~ Ⓕ	3134	Ⓓ ~ ⓤ	973	Ⓜ ~ Ⓟ	1050	Ⓣ ~ ⓣ	1471
Ⓑ ~ Ⓒ	972	Ⓓ ~ Ⓤ	823	Ⓜ ~ ⓠ	1735*	Ⓣ ~ Ⓥ	840
Ⓒ ~ Ⓔ	1796*	Ⓓ ~ ⓥ	1148	Ⓜ ~ ⓡ	1794*	Ⓣ ~ ⓨ	1823*
Ⓒ ~ ⓜ	912*	Ⓓ ~ Ⓥ	1054	Ⓜ ~ ⓢ	1896*	Ⓣ ~ Ⓨ	1212
Ⓒ ~ ⓝ	928*	Ⓓ ~ ⓦ	883	Ⓜ ~ Ⓢ	1386	Ⓤ ~ ⓤ	1479
Ⓒ ~ ⓟ	1100*	Ⓓ ~ Ⓦ	715	Ⓝ ~ ⓝ	1442	Ⓥ ~ ⓣ	1544*
Ⓒ ~ ⓠ	860*	Ⓓ ~ ⓨ	1234	Ⓝ ~ Ⓟ	803	Ⓥ ~ ⓥ	1139
Ⓒ ~ ⓡ	970*	Ⓓ ~ Ⓨ	1137	Ⓝ ~ ⓡ	1710*	Ⓥ ~ ⓦ	1624*
Ⓒ ~ ⓢ	1249*	Ⓓ1 ~ Ⓔ1	1223	Ⓟ ~ ⓟ	1181	Ⓦ ~ ⓣ	1607*
Ⓒ1 ~ Ⓔ1	1167	Ⓓ1 ~ Ⓕ1	1147	Ⓠ ~ ⓝ	1686*	Ⓦ ~ ⓤ	1624*
Ⓒ1 ~ Ⓕ1	1181	Ⓓ1 ~ Ⓖ1	1068	Ⓠ ~ ⓟ	1521*	Ⓦ ~ ⓦ	1480
Ⓒ1 ~ Ⓖ1	1064	Ⓓ1 ~ Ⓧ	2054	Ⓠ ~ ⓠ	1471	Ⓦ ~ ⓨ	1564*
Ⓒ1 ~ Ⓧ	2029	Ⓔ1 ~ Ⓧ	867	Ⓠ ~ ⓢ	1513*	Ⓦ ~ Ⓨ	762
Ⓓ ~ Ⓔ	1102	Ⓕ1 Ⓧ	931	Ⓡ ~ ⓡ	1480	Ⓨ ~ ⓨ	1261

ALKIA0167GB

Measurement Points

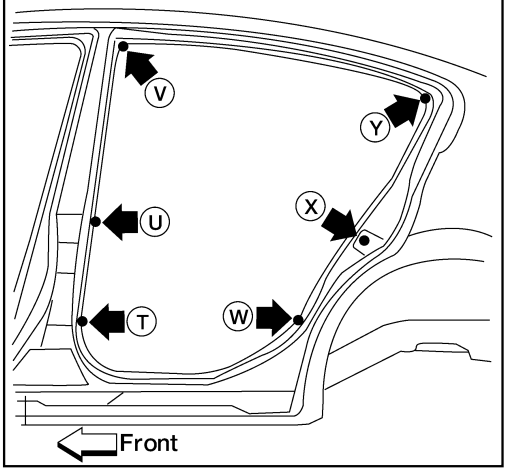
View A

Ⓢ, ⓢ : Top of center pillar raised dimple.
Ⓡ, Ⓠ : Lower center pillar raised dimple.
Ⓟ, ⓟ : Raised dimple near top of front pillar.
Ⓝ, ⓐ : Raised dimple near center of front pillar.
Ⓜ, ⓝ : Lower notch near lower front pillar.
Ⓒ1, Ⓒ2 : Rear upper front hinge bolt hole.
Ⓓ1, Ⓓ2 : Rear lower front hinge bolt hole.
Ⓔ1, Ⓔ2 : Upper rear hinge stud hole.
Ⓕ1, Ⓕ2 : Lower rear hinge rear bolt hole.



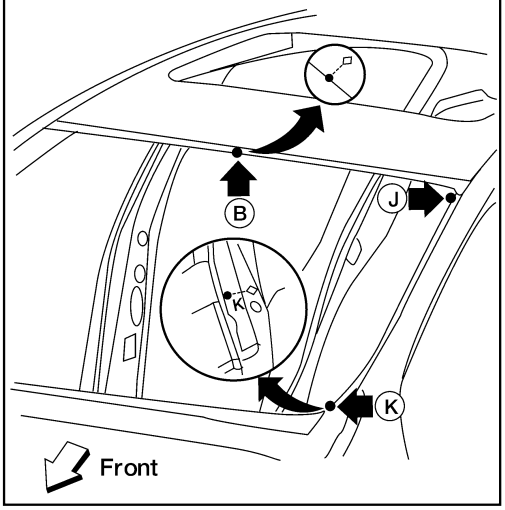
View B

ⓤ : Center rear pillar raised dimple.
Ⓥ, ⓥ, Ⓨ, ⓨ : Upper rear pillar raised dimple.
Ⓧ, ⓧ : Door switch hole.
Ⓣ, ⓣ, Ⓦ, ⓦ : Lower rear pillar raised dimple.



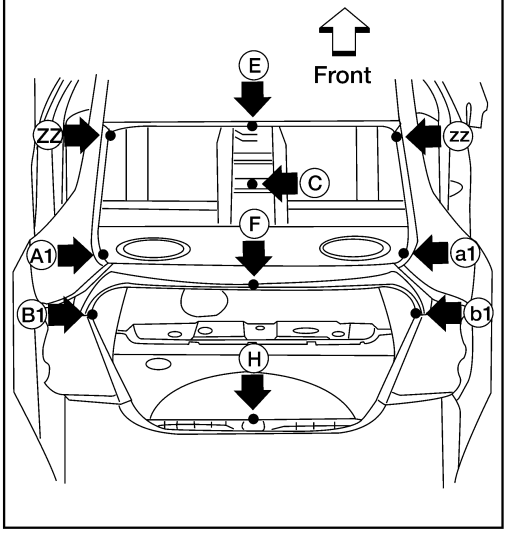
View C

Ⓑ : Roof flange end of center positioning.
Ⓙ, ⓙ : Raised dimple on front pillar rear top.
Ⓚ, ⓚ : Lower corner of windshield opening.



View D

Ⓒ : 14 diameter hole.
Ⓔ : Roof flange end of center positioning mark.
Ⓗ : Trunk striker flange center positioning.
Ⓩ, ⓩ : Upper corner of rear window.
Ⓐ1, ⓐ1 : Lower corner of rear window.
Ⓑ1, ⓑ1 : Upper trunk flange.



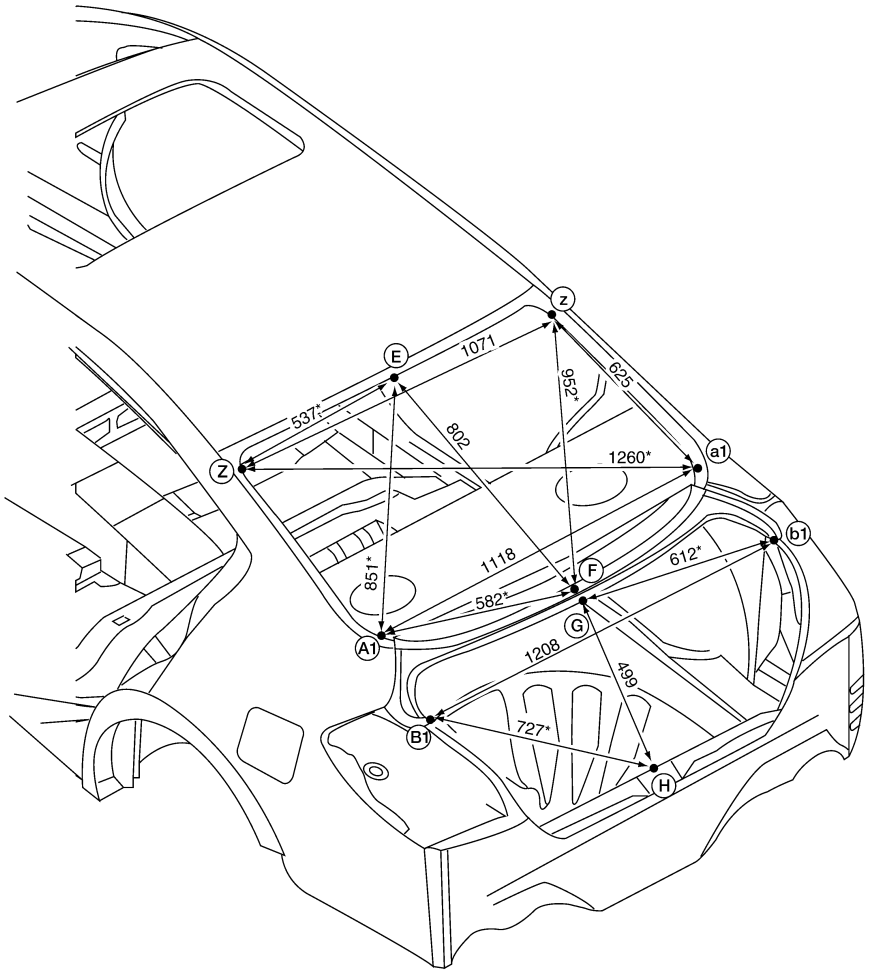
ALKIA0160GB

Rear Body

INFOID:0000000003110821

Measurement

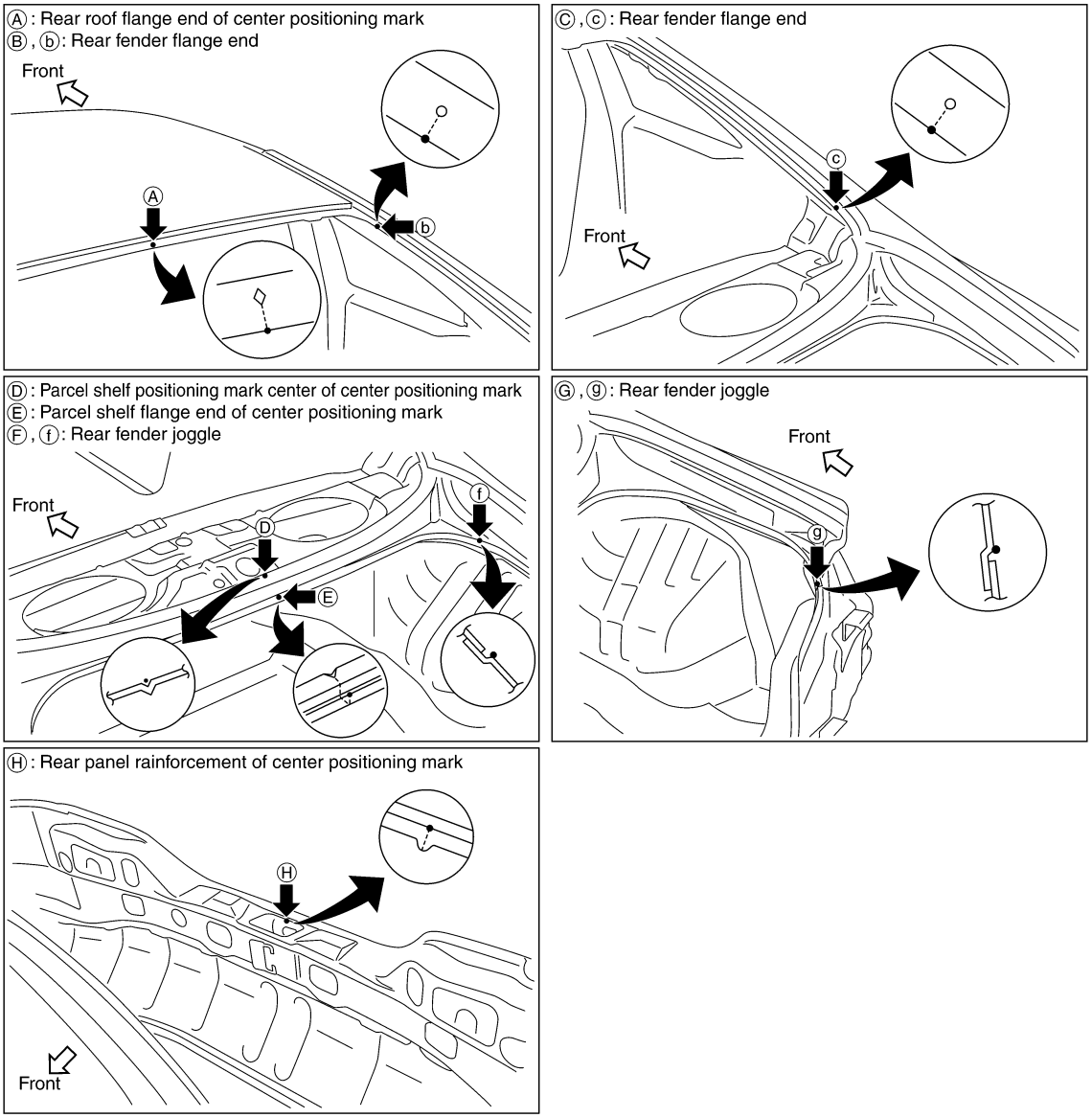
Figures marked with a (*) indicate symmetrically identical dimensions on both right and left sides of the vehicle.



Unit : mm

ALKIA0169GB

Measurement Points



SIIA2147E

PRECAUTIONS IN REPAIRING HIGH STRENGTH STEEL

High Strength Steel (HSS)

INFOID:0000000003110822

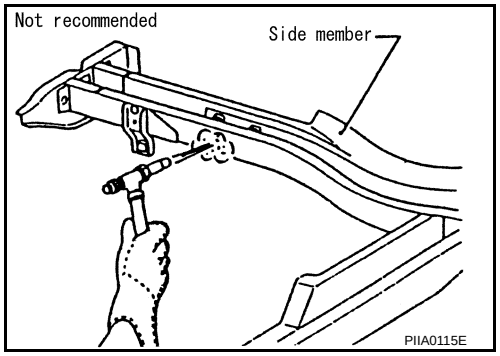
High strength steel is used for body panels in order to reduce vehicle weight.
Accordingly, precautions in repairing automotive bodies made of high strength steel are described below:

Tensile strength	Nissan/Infiniti designation	Major applicable parts
373 N/mm^2 (38kg/mm^2,54klb/sq in)	SP130	• Front side member assembly • Hoodledge assembly • Upper dash • Front pillar reinforcement assembly • Rear side member assembly • Other reinforcements

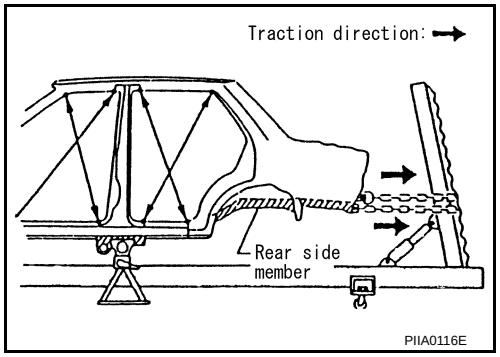
SP130 is the most commonly used HSS.

Read the following precautions when repairing HSS:

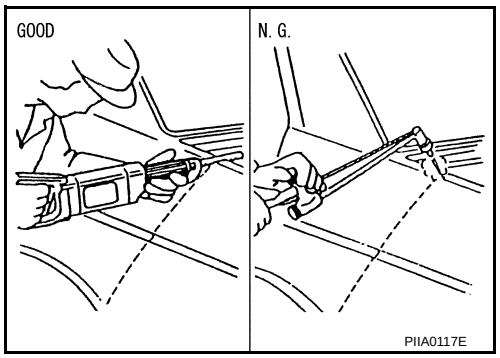
1. Additional points to consider
   - The repair of reinforcements (such as side members) by heating is not recommended since it may weaken the component. When heating is unavoidable, do not heat HSS parts above 550°C (1,022°F).
     Verify heating temperature with a thermometer.
     (Crayon-type and other similar type thermometer are appropriate.)



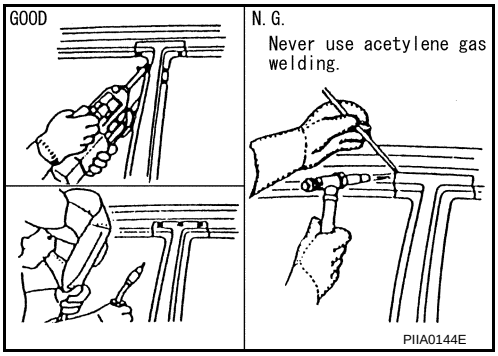
   - When straightening body panels, use caution in pulling any HSS panel. Because HSS is very strong, pulling may cause deformation in adjacent portions of the body. In this case, increase the number of measuring points, and carefully pull the HSS panel.



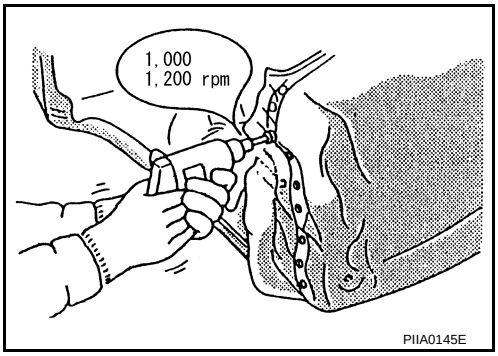
   - When cutting HSS panels, avoid gas (torch) cutting if possible. Instead, use a saw to avoid weakening surrounding areas due to heat. If gas (torch) cutting is unavoidable, allow a minimum margin of 50 mm (1.97in).



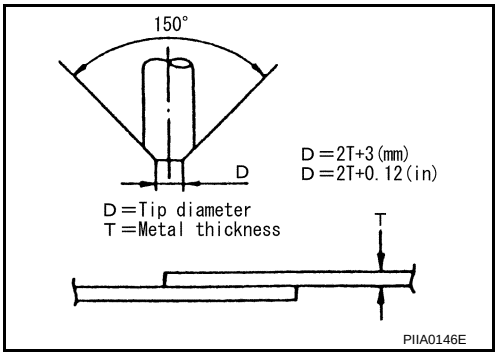
- When welding HSS panels, use spot welding whenever possible in order to minimize weakening surrounding areas due to heat.
  If spot welding is impossible, use M.I.G. welding. Do not use gas (torch) welding because it is inferior in welding strength.



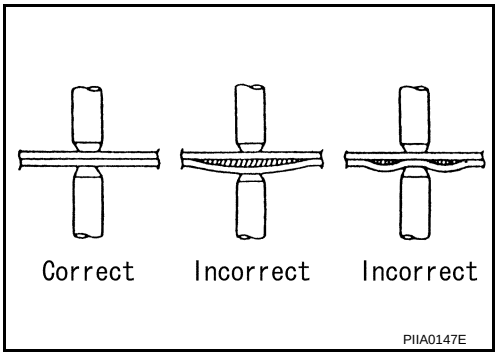
- The spot weld on HSS panels is harder than that of an ordinary steel panel.
  Therefore, when cutting spot welds on a HSS panel, use a low speed high torque drill (1,000 to 1,200 rpm) to increase drill bit durability and facilitate the operation.



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.



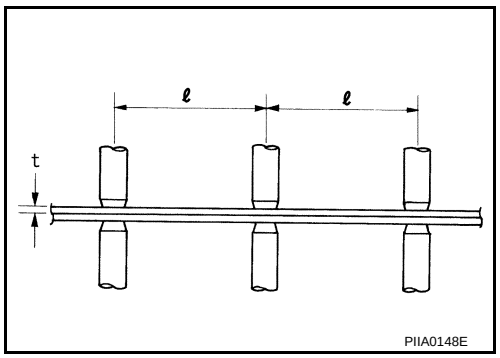
- The panel surfaces must fit flush to each other, leaving no gaps.



- Follow the specifications for the proper welding pitch.

Unit:mm

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



REPLACEMENT OPERATIONS

Description

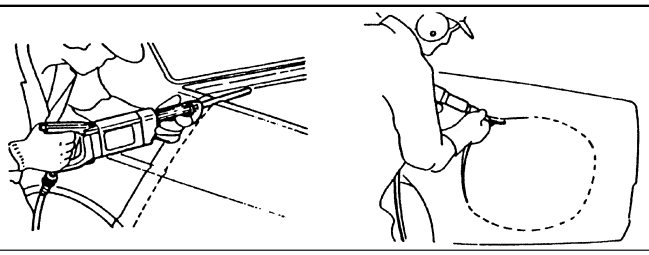
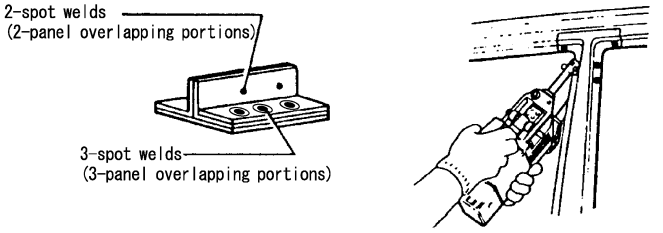
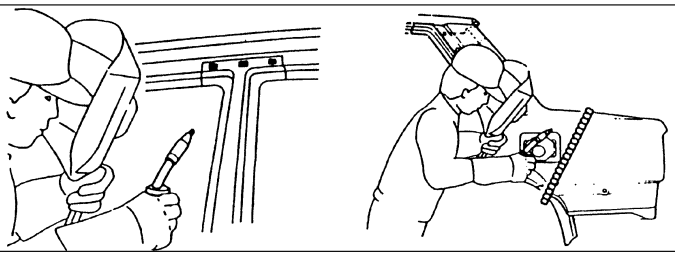
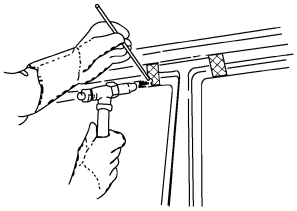
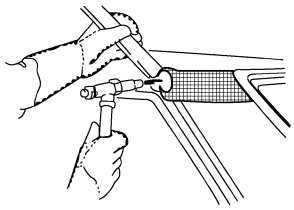
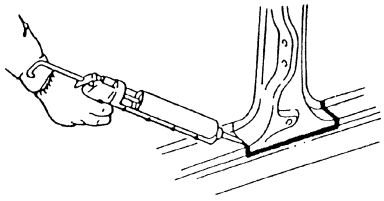
INFOID:0000000003110823

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 Body Repair Manual (Fundamentals) in order to ensure that the original functions and quality of the vehicle can be maintained. The Body Repair Manual (Fundamentals) contains additional information, including cautions and warning, that are not including in this manual. Technicians should refer to both manuals to ensure proper repairs.

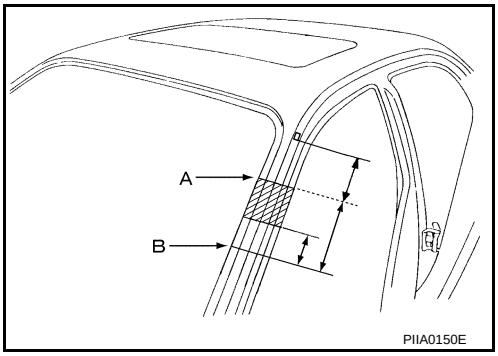
Please note that these information are prepared for worldwide usage, and as such, certain procedures might not apply in some regions or countries.

The symbols used in this section for cutting and welding / brazing operations are shown below.

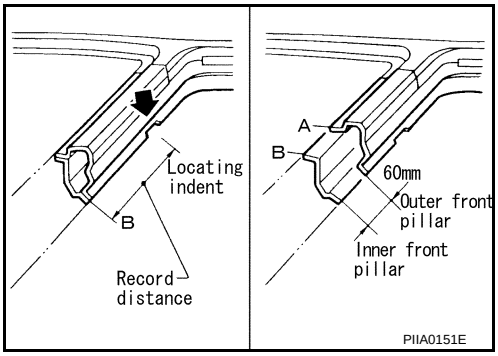
Saw cut or air chisel cut	
Spot weld — 2-spot welds	
Spot weld — 3-spot welds	
MIG plug weld	
MIG seam weld/ Point weld	
Brazing	
Soldering	
Sealing	

PIIA0149E

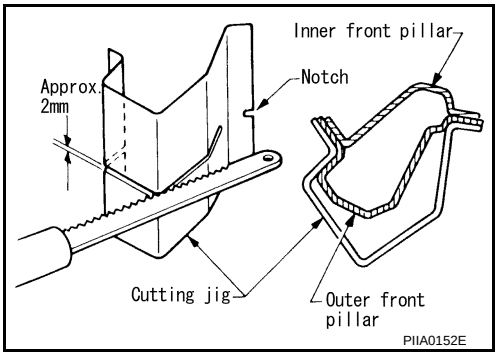
- Front pillar butt joint can be determined anywhere within shaded area as shown in the figure. The best location for the butt joint is at position A due to the construction of the vehicle. Refer to the front pillar section.



- 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 above inner front pillar cut position.

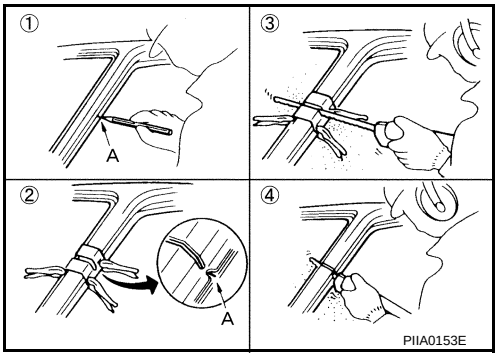


- Prepare a cutting jig to make outer pillar easier to cut. Also, this will permit service part to be accurately cut at joint position.



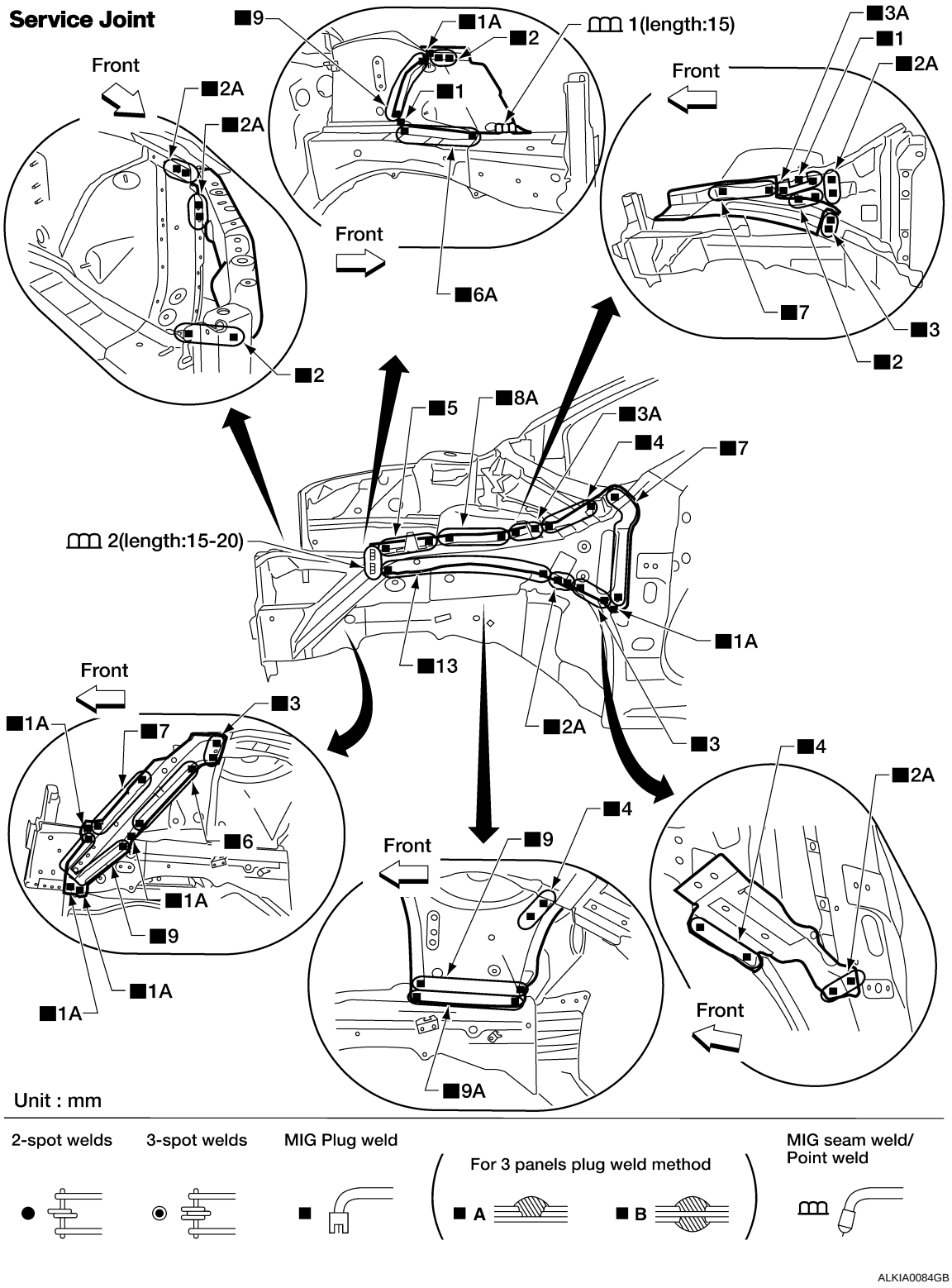
- An example of cutting operation using a cutting jig is as follows.

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.



Hoodledge

INFOID:0000000003110824



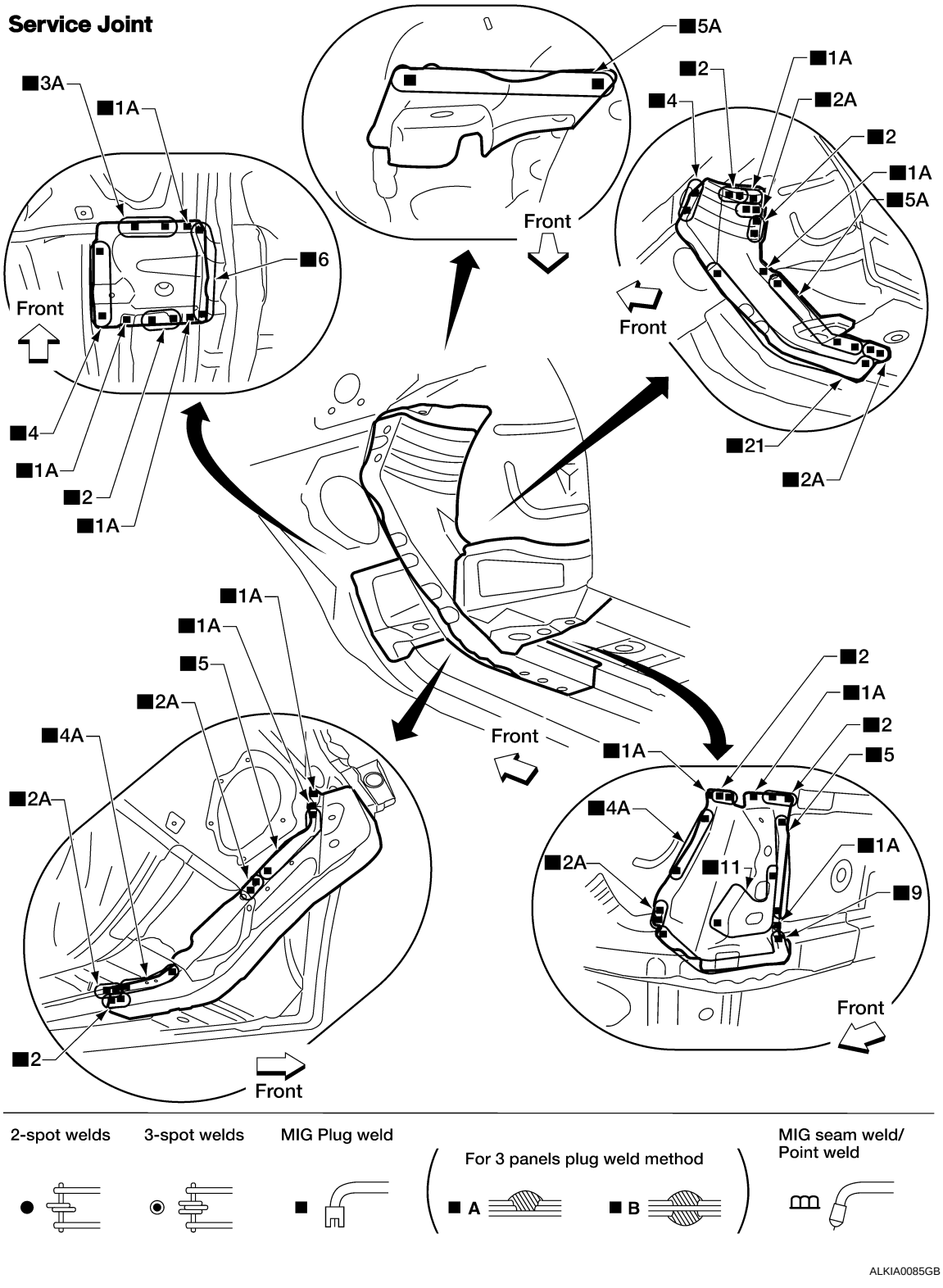
Change parts

- Front strut housing (LH)
- Hoodledge connector
- Upper front hoodledge
- Radiator core support upper
- Hoodledge reinforcement
- Hoodledge reinforcement rear

Front Side Member

INFOID:0000000003110825

- Work after hoodledge partial has been removed.

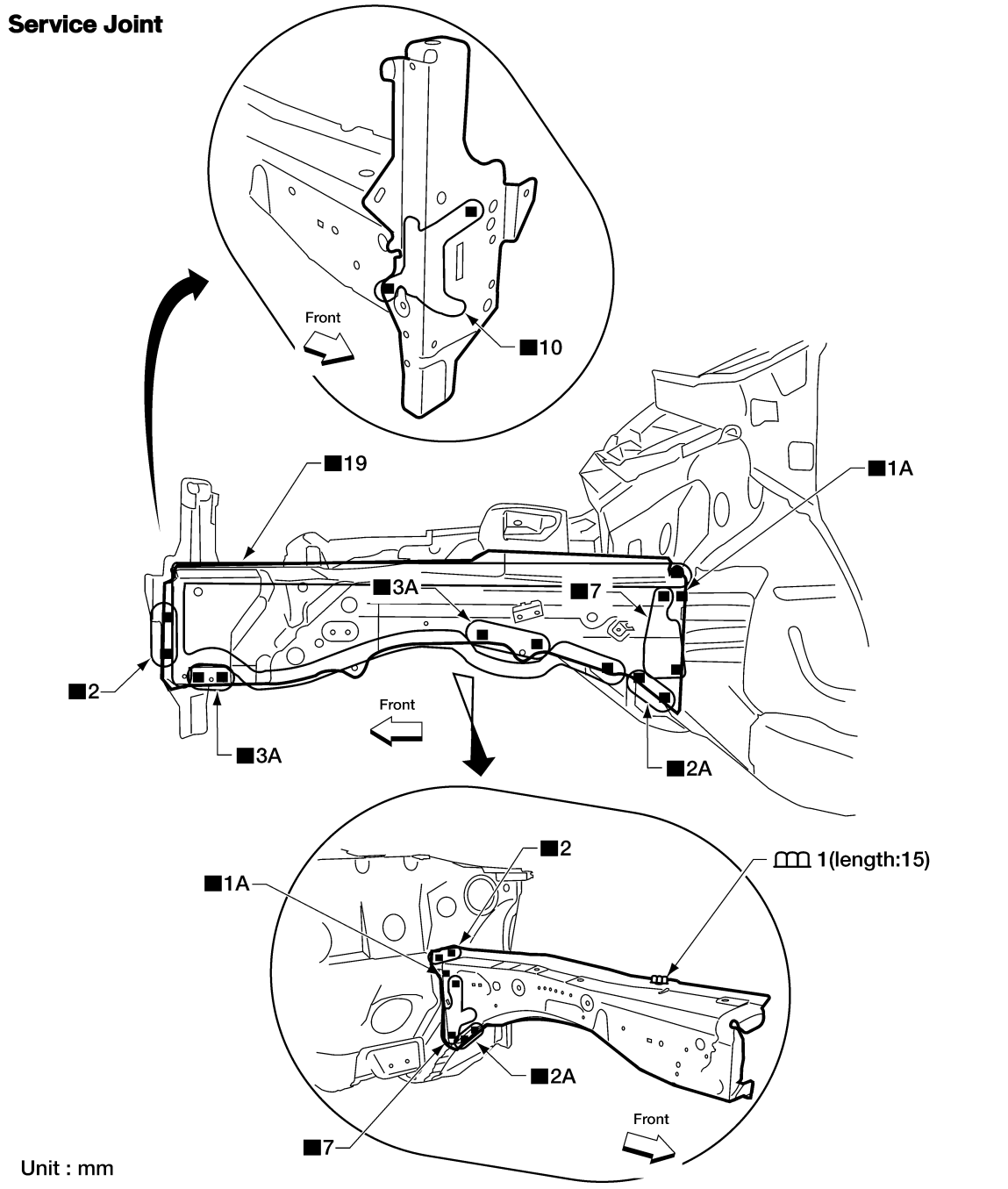


Change parts

- Front side member rear assembly
- Front side member rear reinforcement
- Front suspension member plate
- Front side member outrigger assembly
- Front side member rear closing plate assembly

Front Side Member (Partial Replacement)

INFOID:0000000003110826



Change parts

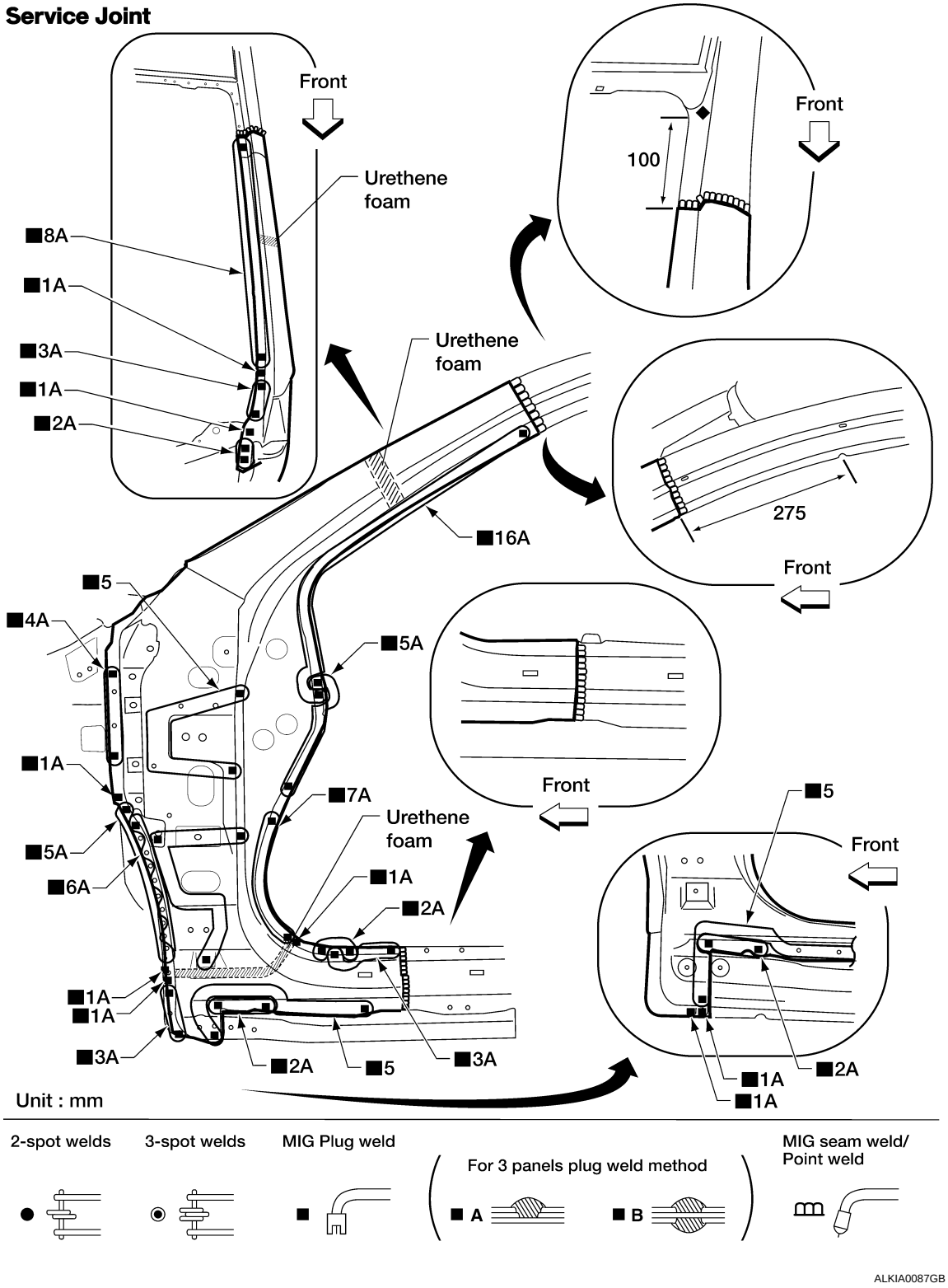
- Front side member front assembly
- Front side member front closing plate
- Radiator core side support

Front Pillar

INFOID:0000000003110827

OUTER

• Work after hoodledge and hoodledge reinforcement rear has been removed.



ALKIA0087GB

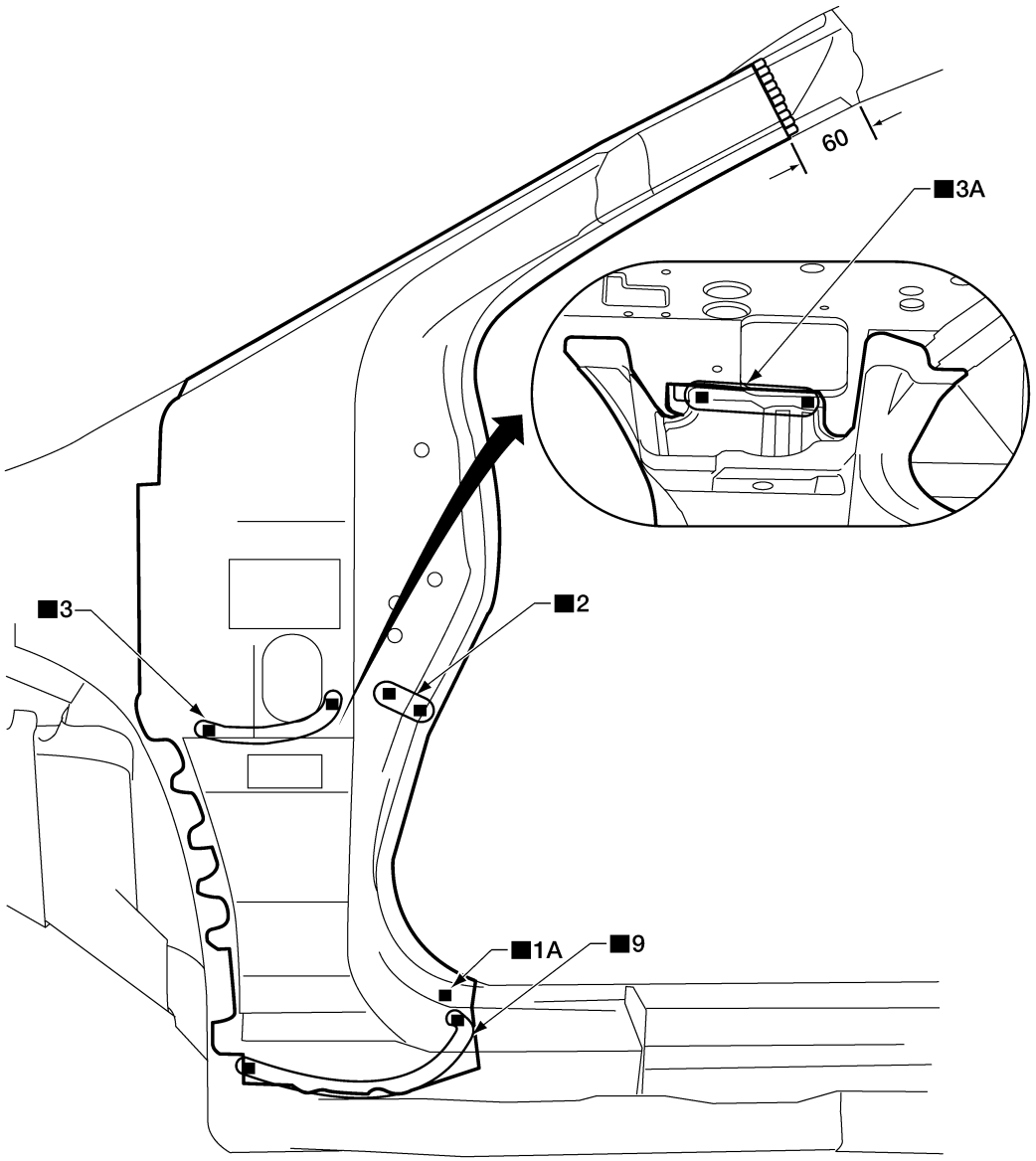
Change parts

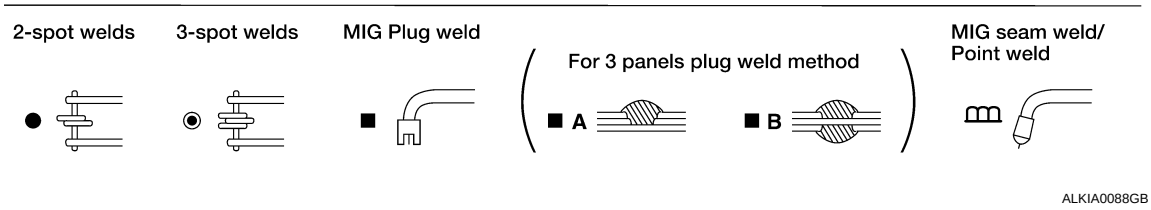
- Front pillar section of body side outer

REINFORCEMENT

• Work after front pillar outer has been removed.

Service Joint





ALKIA0088GB

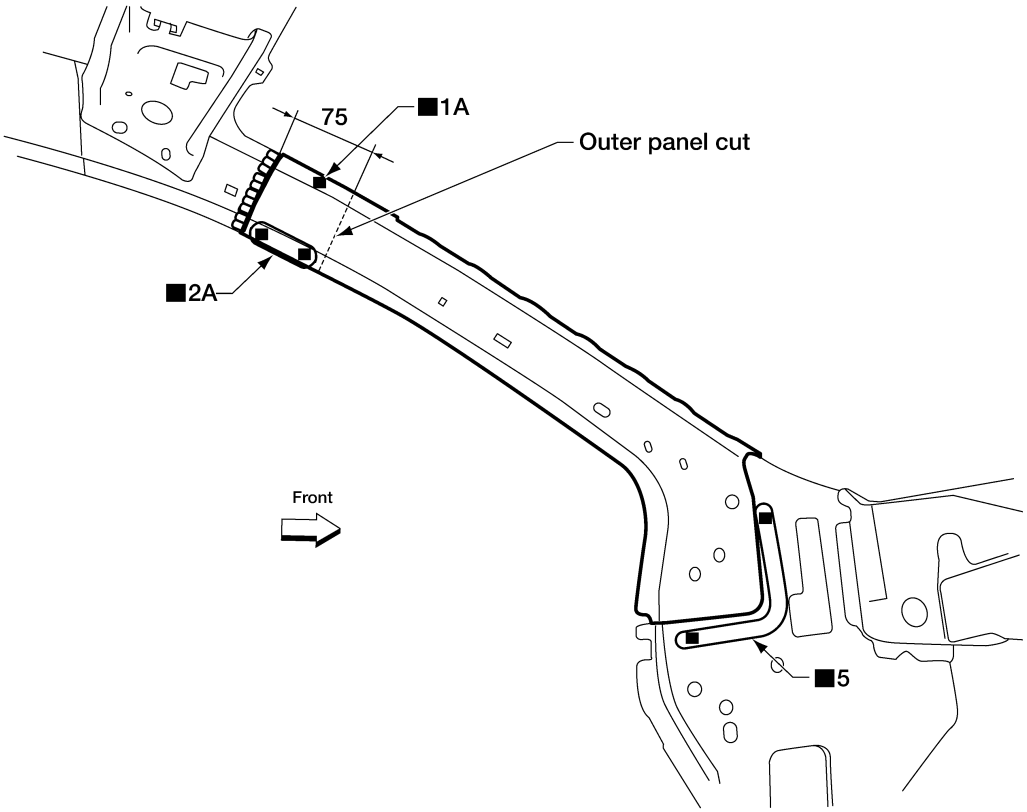
Change parts

- Front pillar upper reinforcement
- Front pillar lower reinforcement

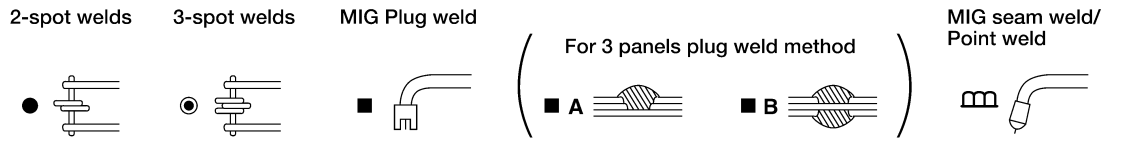
INNER

• Work after front pillar reinforcement has been removed.

Service Joint



Unit : mm



ALKIA0089GB

Change parts

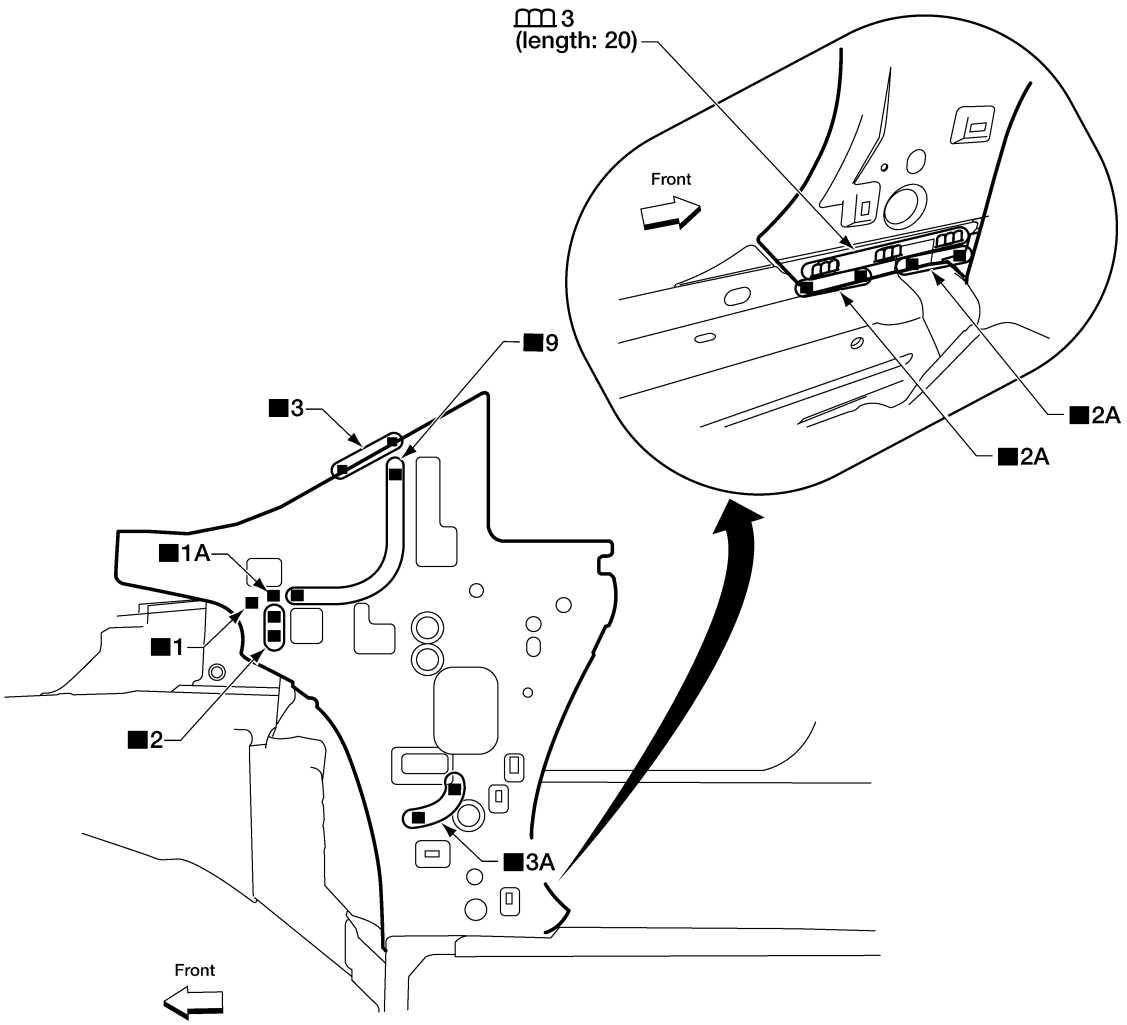
- Front pillar inner reinforcement

Dash Side

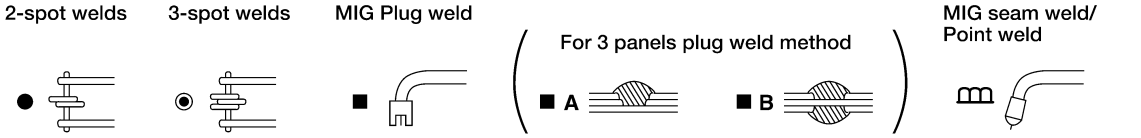
INFOID:0000000003110828

Work with front pillar reinforcement removed.

Service Joint



Unit : mm



ALKIA0091GB

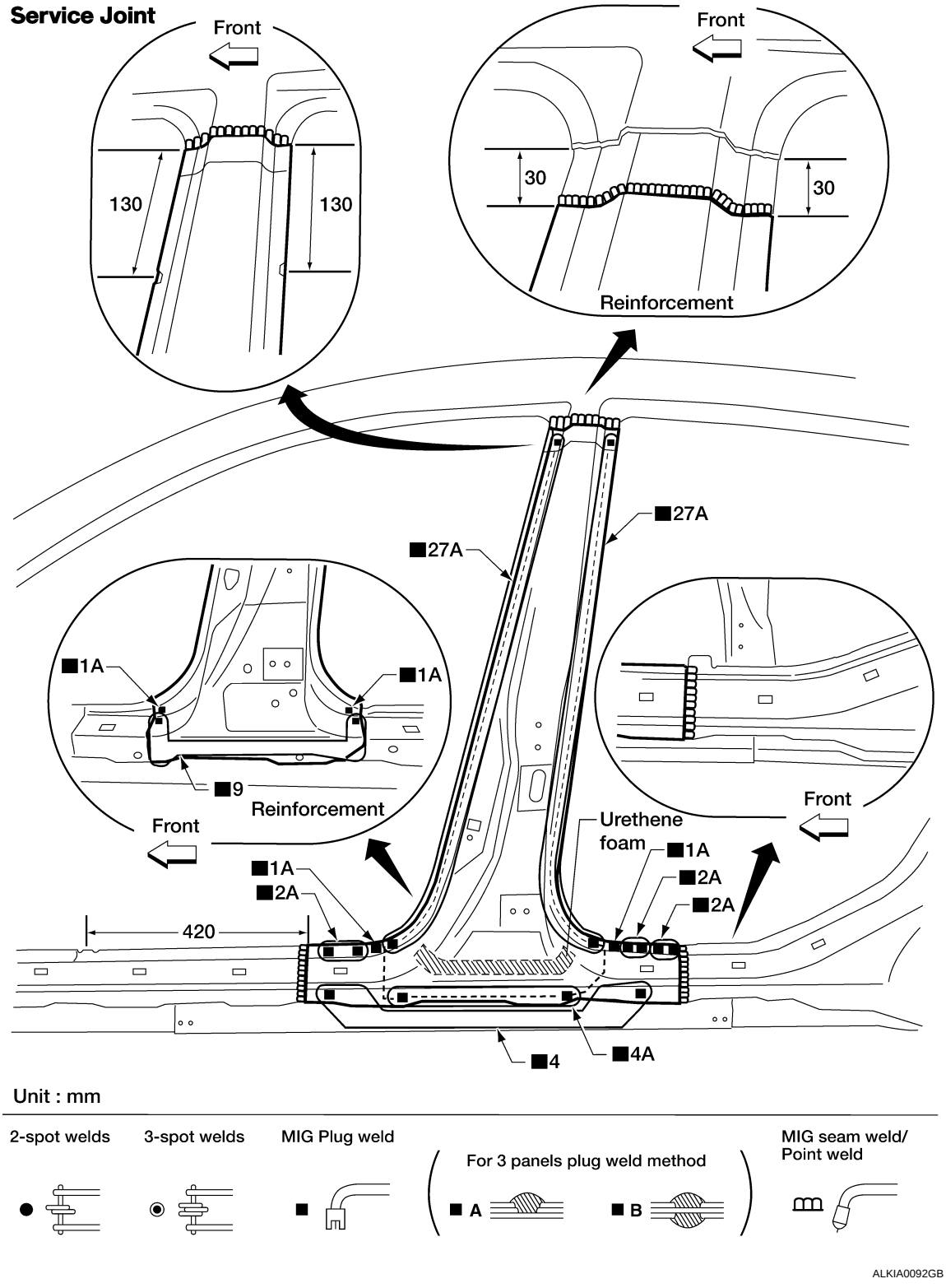
Change parts

- Dash side

Center Pillar

INFOID:0000000003110829

OUTER



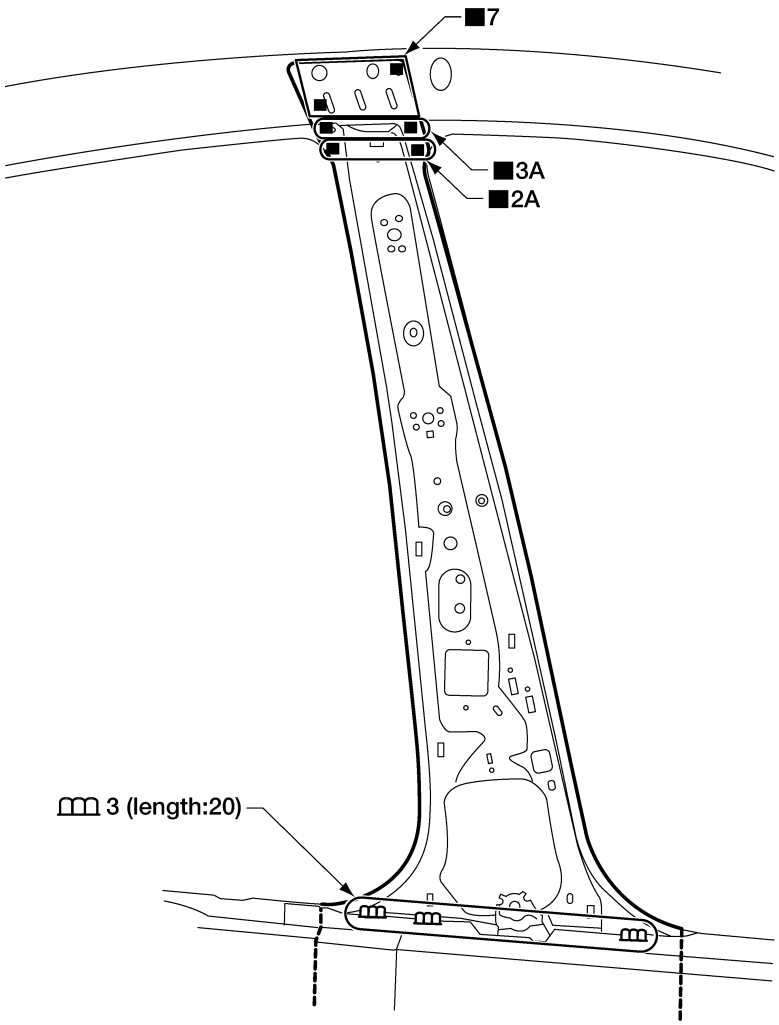
Change parts

- Center pillar portion of body side outer
- Center pillar reinforcement

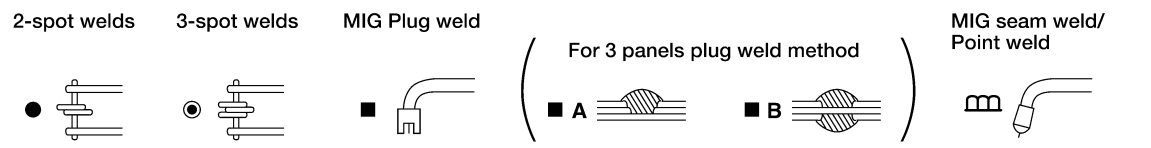
INNER

Work after center pillar outer and outer sill have been removed.

Service Joint



Unit : mm



ALKIA0093GB

Change parts

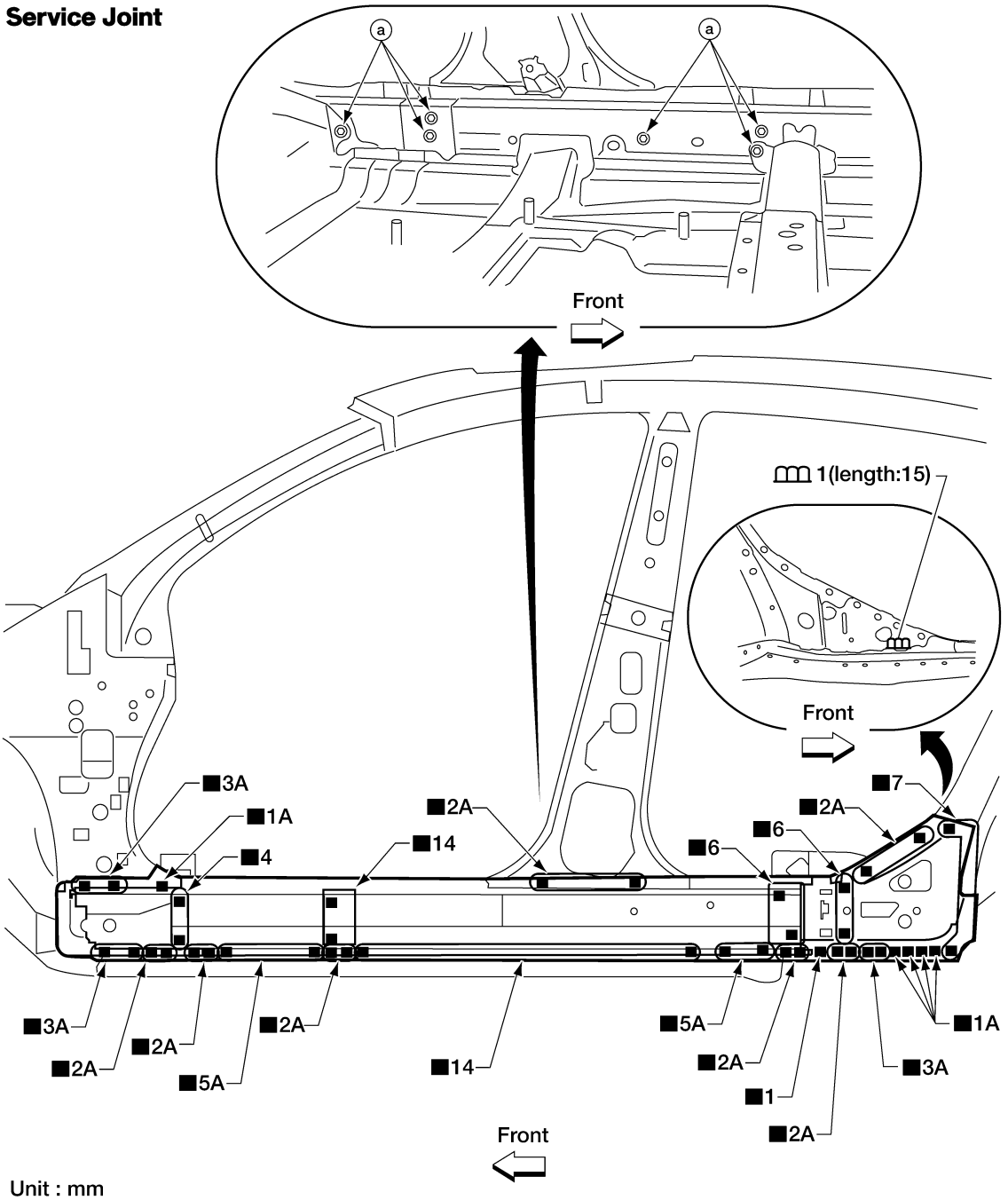
- Center pillar inner

Outer Sill

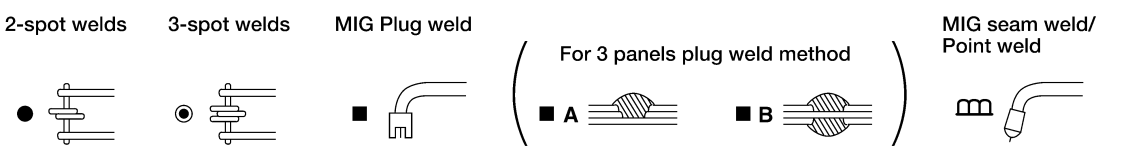
INFOID:0000000003110830

Work after the front pillar reinforcement, center pillar reinforcement, and rear fender have been removed.

Service Joint



Unit : mm



ALKIA0094GB

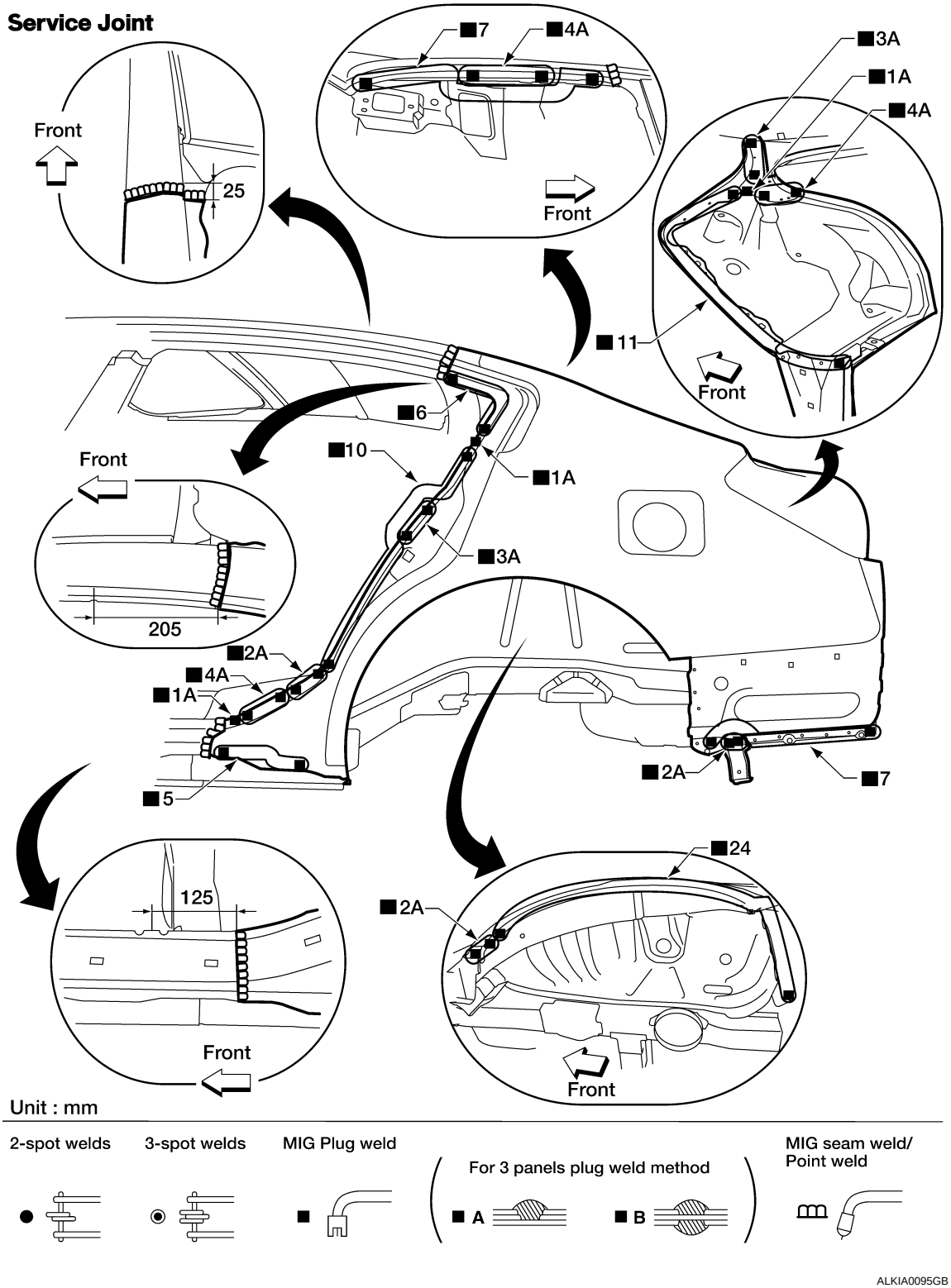
Change parts

- Outer sill reinforcement

A. 24Nm (2.4Kg-m, 18lb-ft)

Rear Fender

INFOID:0000000003110831



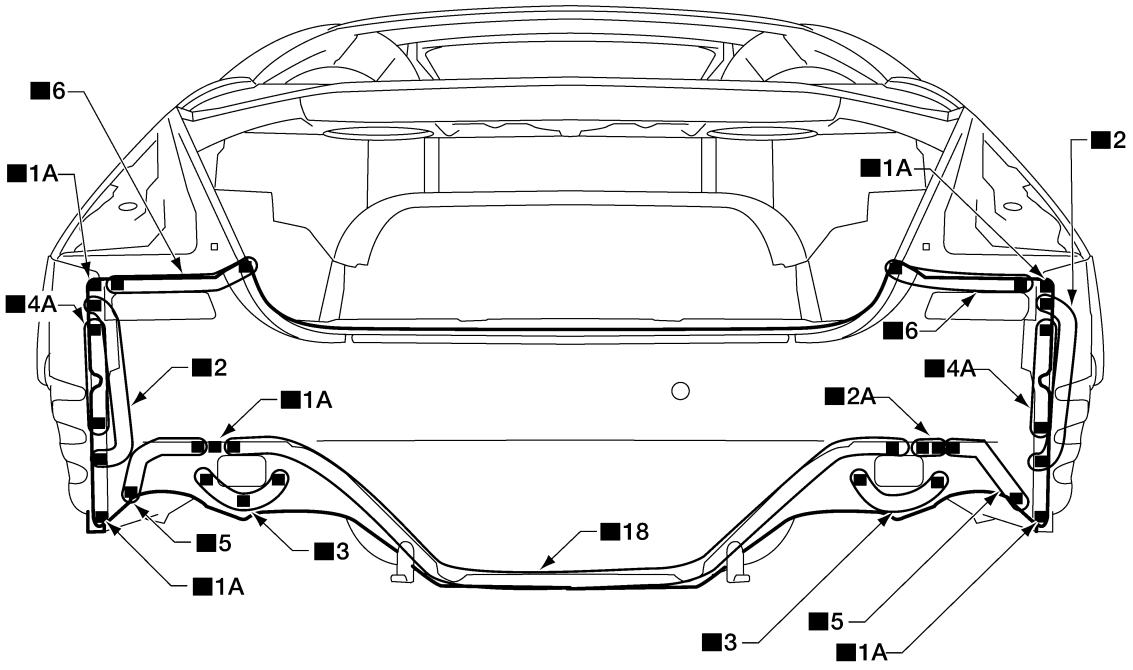
Change parts

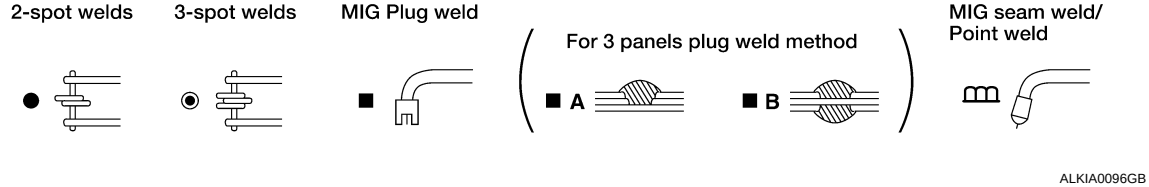
- Rear fender

Rear Panel

INFOID:0000000003110832

Service Joint





Change parts

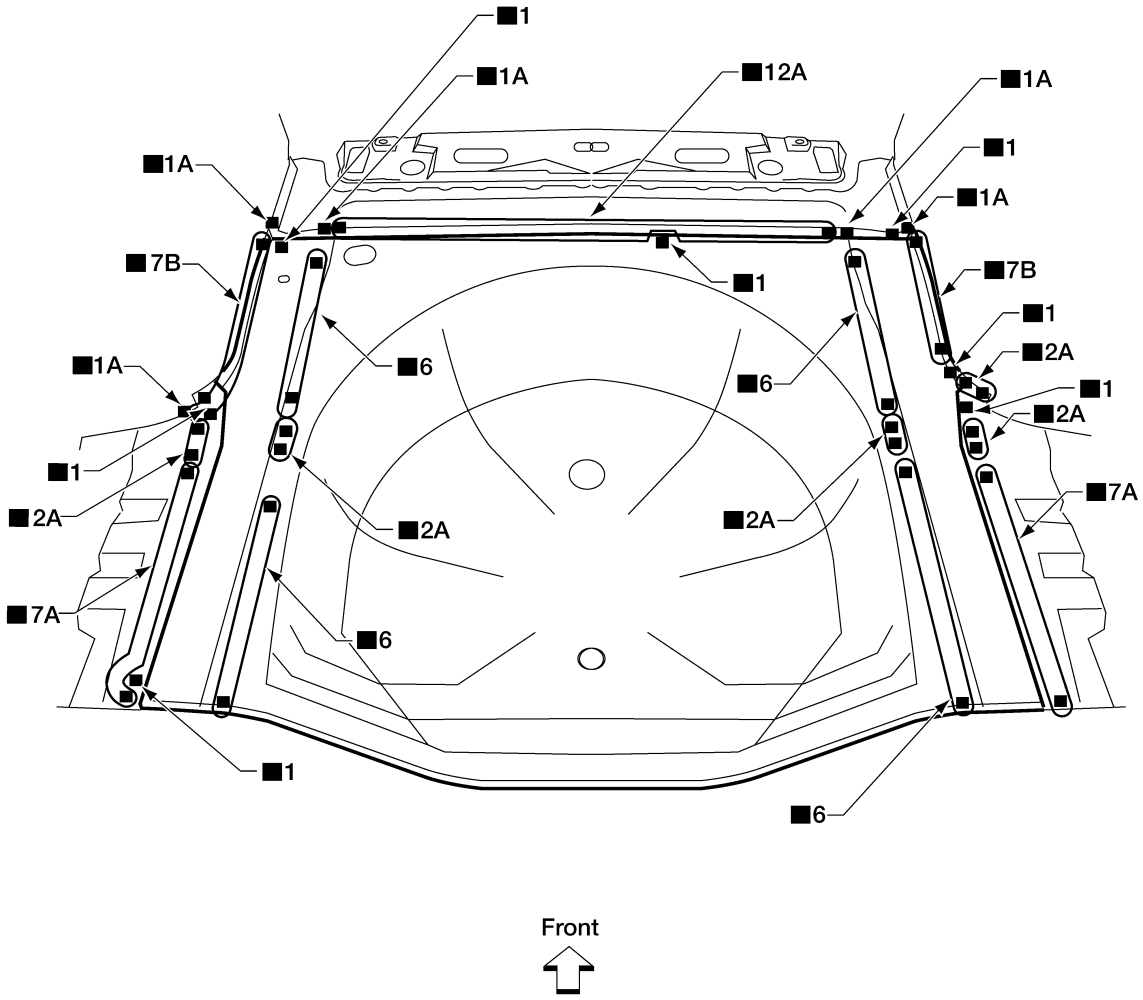
- Rear panel assembly

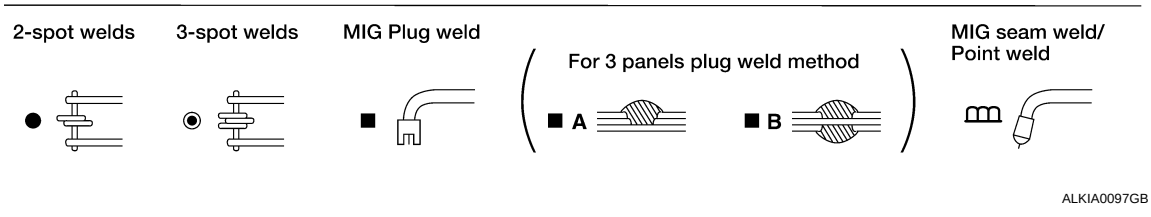
Rear Floor Rear

INFOID:0000000003110833

- Work after rear panel assembly has been removed.

Service Joint





Change parts

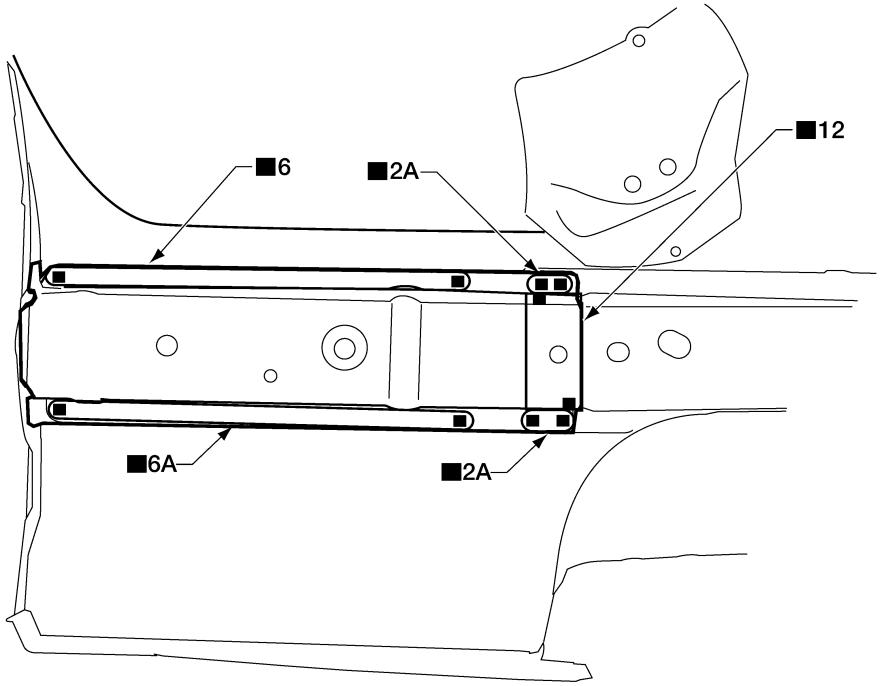
- ● Rear floor rear

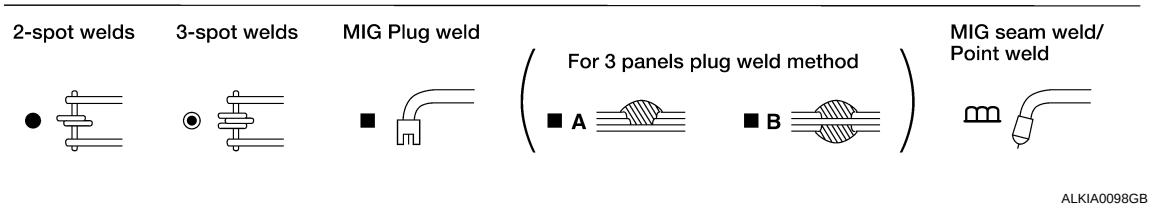
Rear Side Member Extension

INFOID:0000000003110834

- Work after rear panel assembly has been removed.

Service Joint





Change parts

- Rear side member extension

Foam Repair

INFOID:0000000003110835

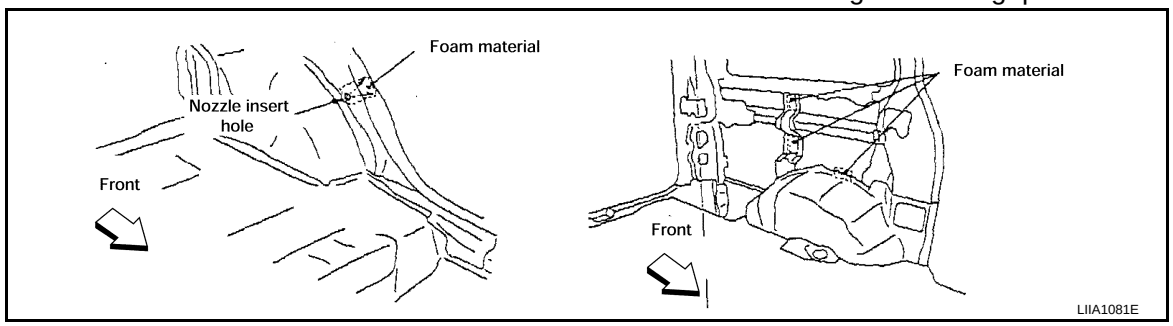
During factory assembly, foam insulators are installed in certain body panels and locations around the vehicle. Use the following procedure(s) to replace any factory-installed foam insulators.

URETHANE FOAM APPLICATIONS

Use commercially available spray for sealant (foam material) repair of material used on vehicle. Read instructions on product for fill procedures.

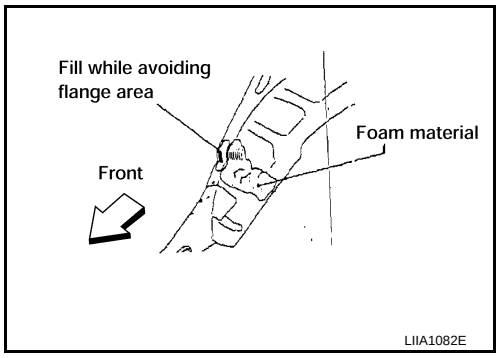
FILL PROCEDURES

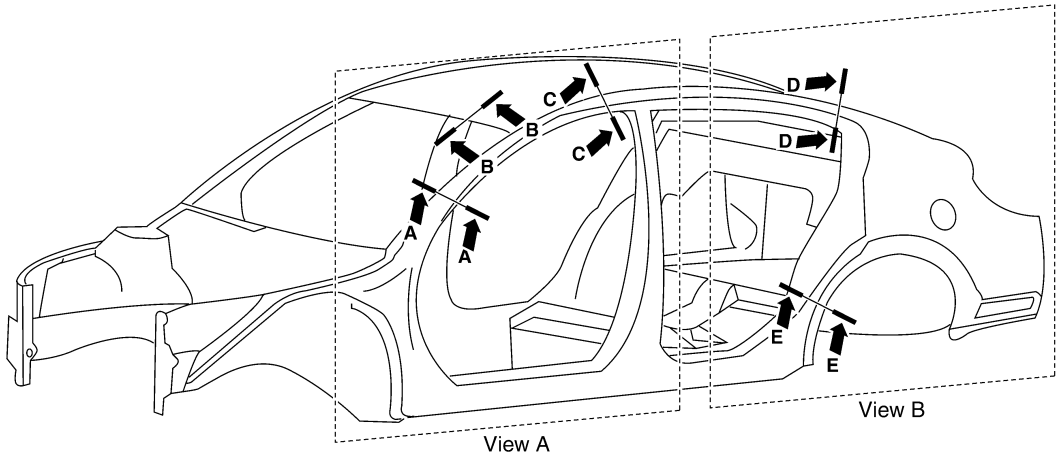
1. Fill procedures after installation service part.
   - Remove foam material remaining on vehicle side.
   - Clean area in which foam was removed.
   - Install service part.
   - Insert nozzle into hole near fill area and fill foam material or fill in enough to close gap with service part.

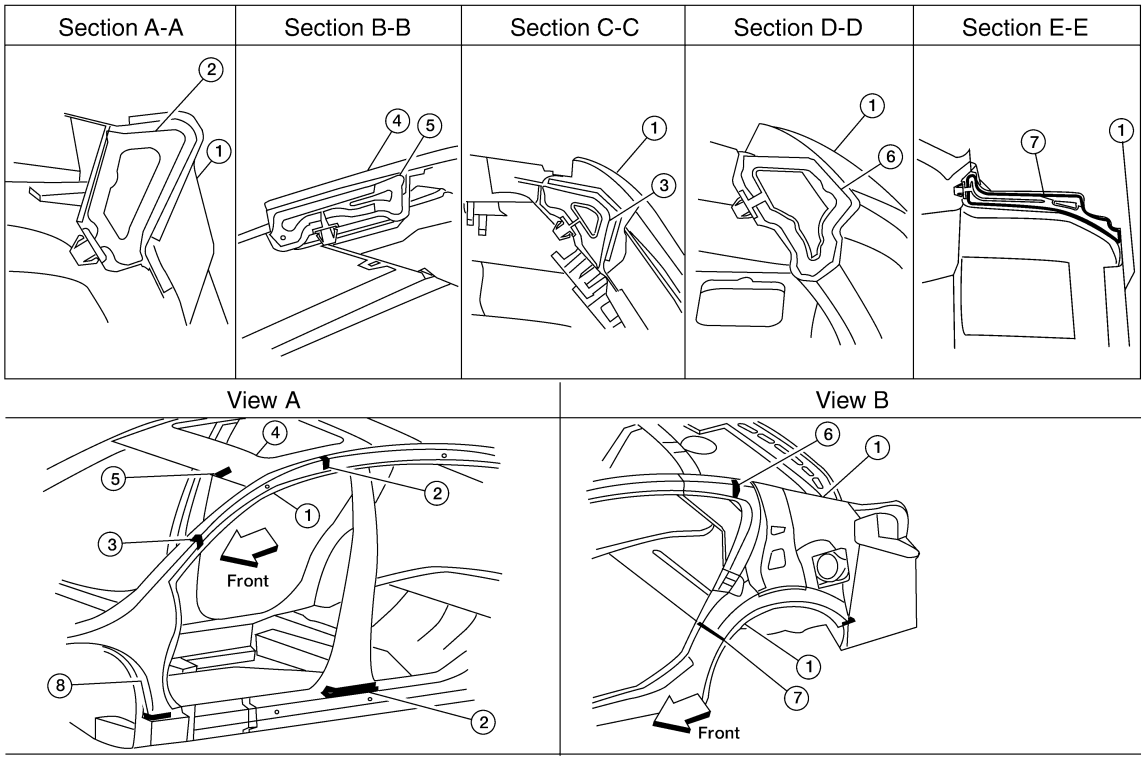


2. Fill procedures before installation service part

- Remove foam material remaining on vehicle side.
- Clean area in which foam material on wheelhouse outer side.
  NOTE:
  Fill in enough to close gap with service part while avoiding flange area.
- Install service part.
  NOTE:
  Refer to label for information on working times.







ALKIA0161GB

1. Body side outer
2. Body side insulation (foam) upper front pillar
3. Body side insulation (foam) front pillar
4. Roof panel assembly
5. Roof panel insulation (foam) front roof rail
6. Body side insulation (foam) rear pillar
7. Body side insulation (foam) rear pillar lower
8. Body side insulation strip, front pillar lower reinforcement
9. 9.Body side insulation strip, center pillar reinforcement