

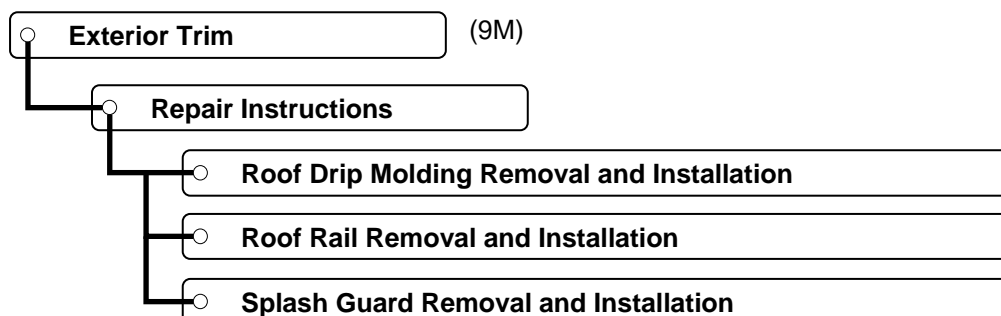
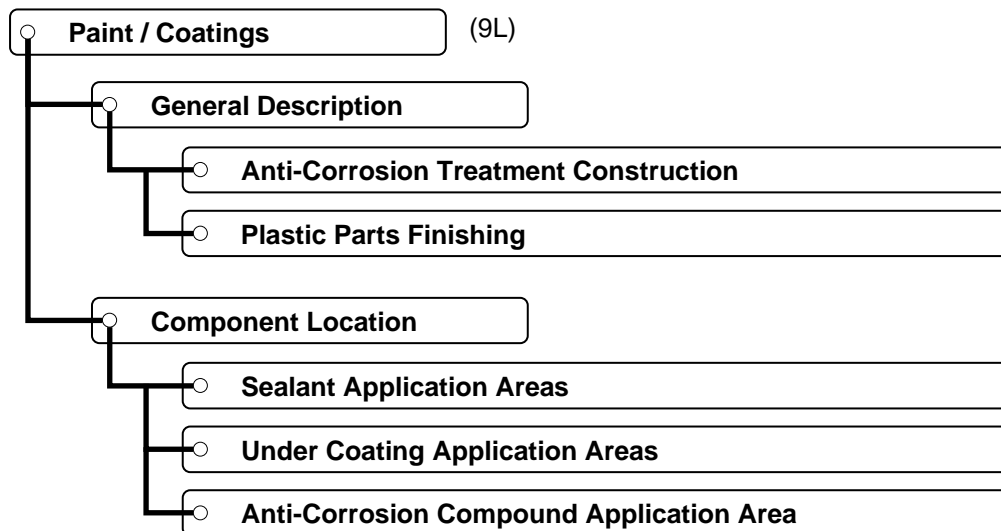
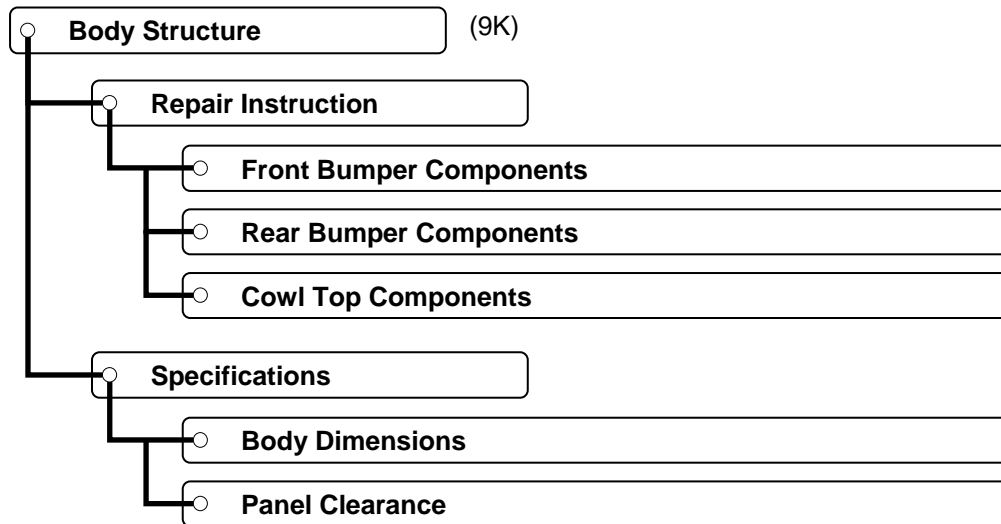


JB Grand Vitara - Body Repair Manual



GRAND VITARA

99500-64J00-01E

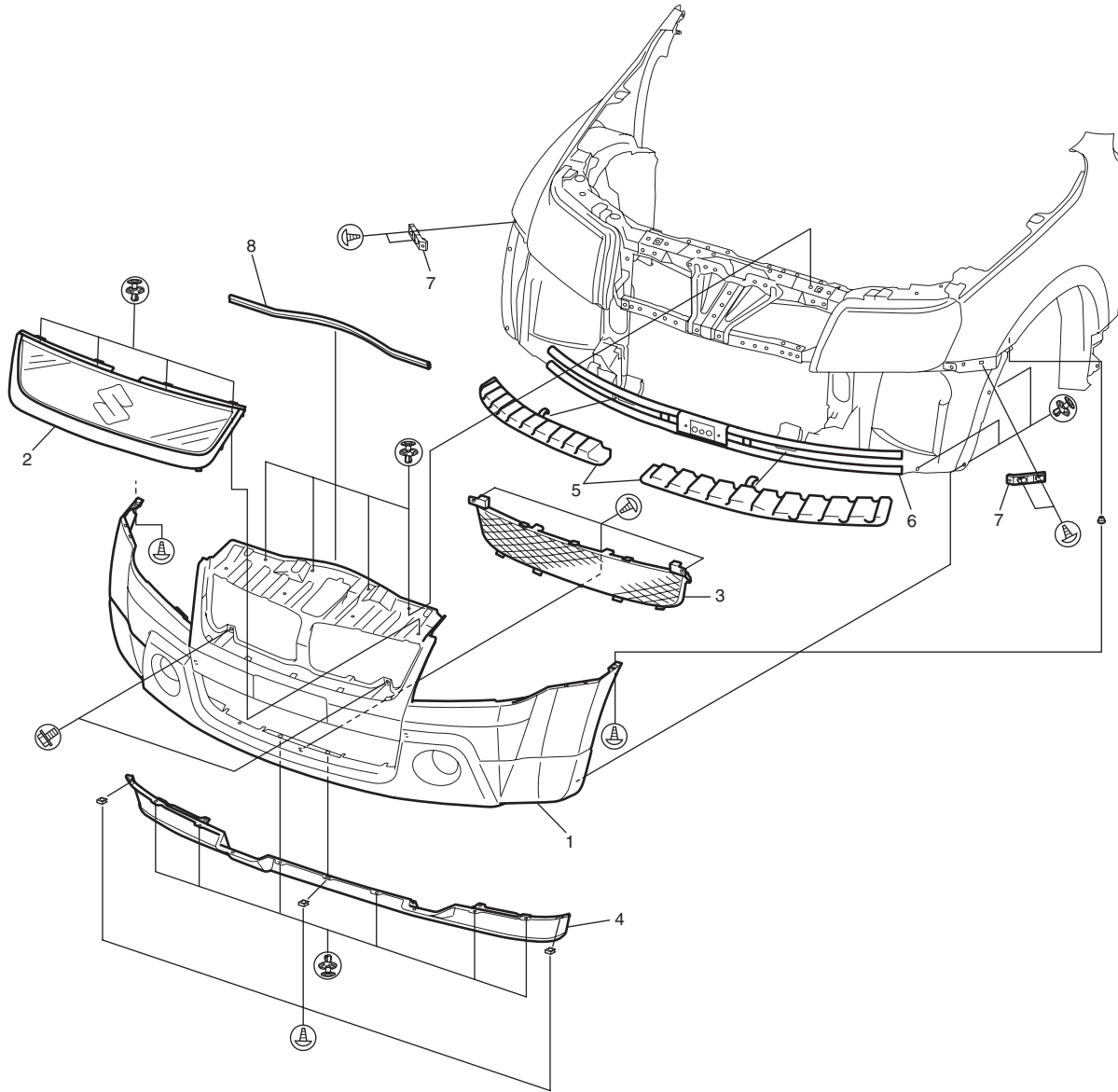


Body Structure

Repair Instructions

Front Bumper Components

S5JB0A9B06001



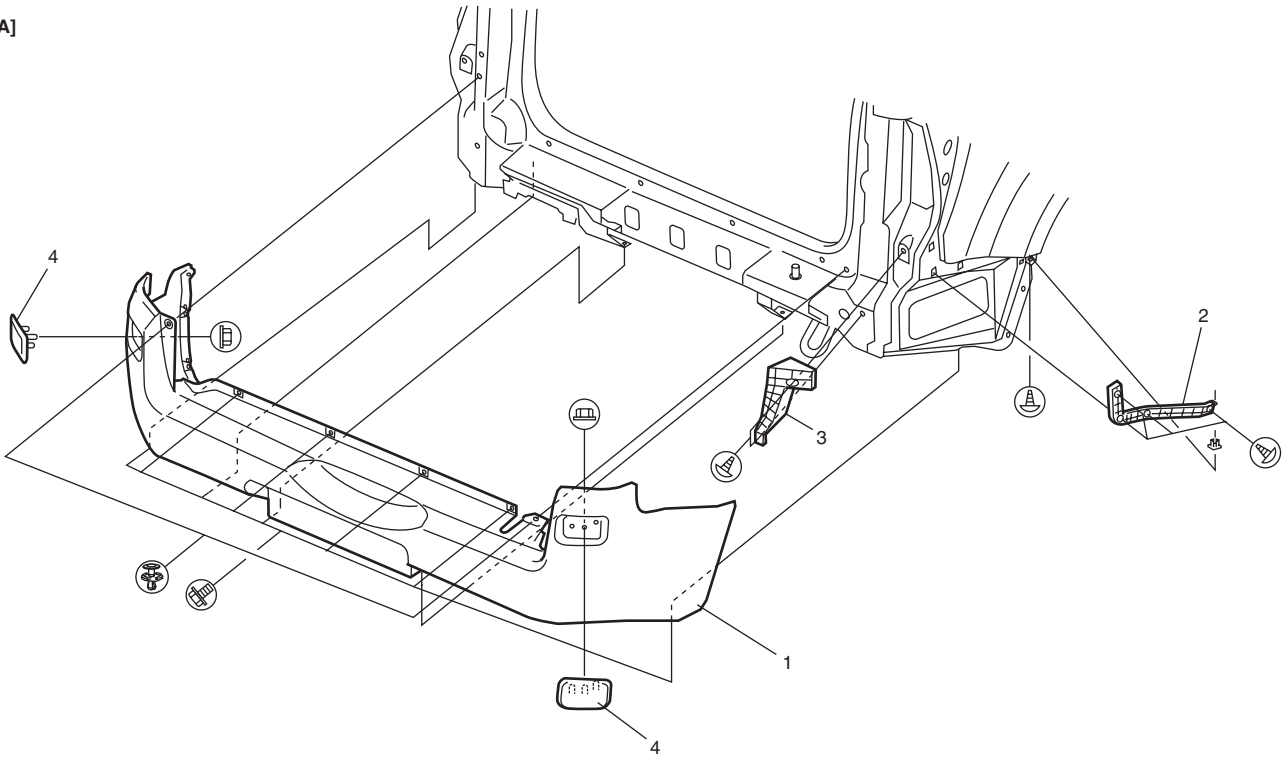
I5JB0A9B0001-02

1. Front bumper	3. Front bumper net	5. Front bumper absorber	7. Front bumper holder
2. Radiator grill	4. Front air dam skirt	6. Front bumper member	8. Seal

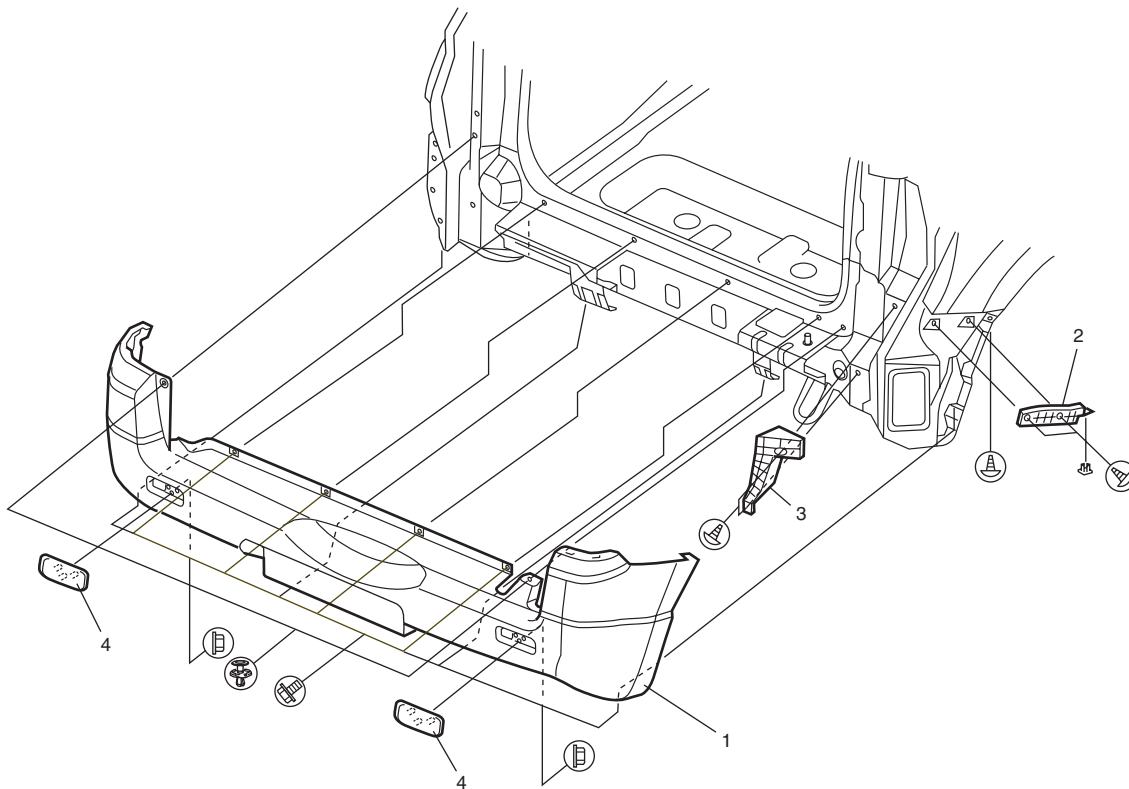
Rear Bumper Components

S5JB0A9B06004

[A]



[B]

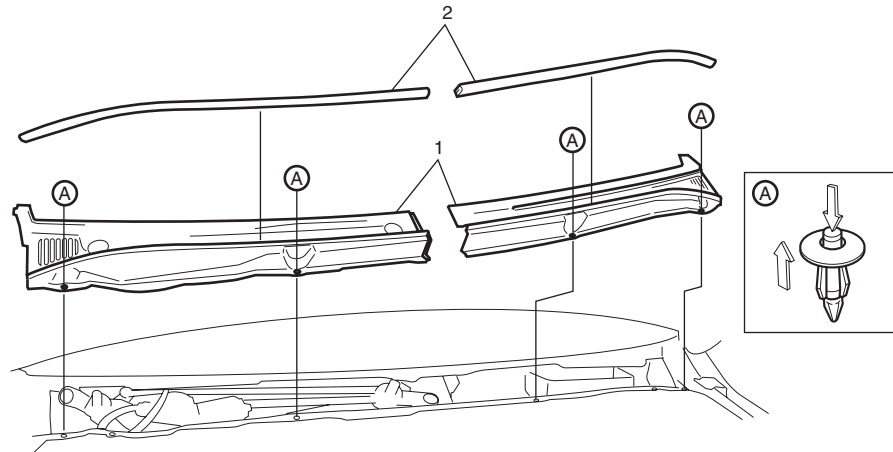


I5JB0A9B0002-01

[A]: 5 door model	1. Rear bumper	3. Rear bumper No.2 holder
[B]: 3 door model	2. Rear bumper No.1 holder	4. Reflector

Cowl Top Components

S5JB0A9B06003



- | |
|---------------------|
| 1. Cowl top garnish |
| 2. Hood rear seal |

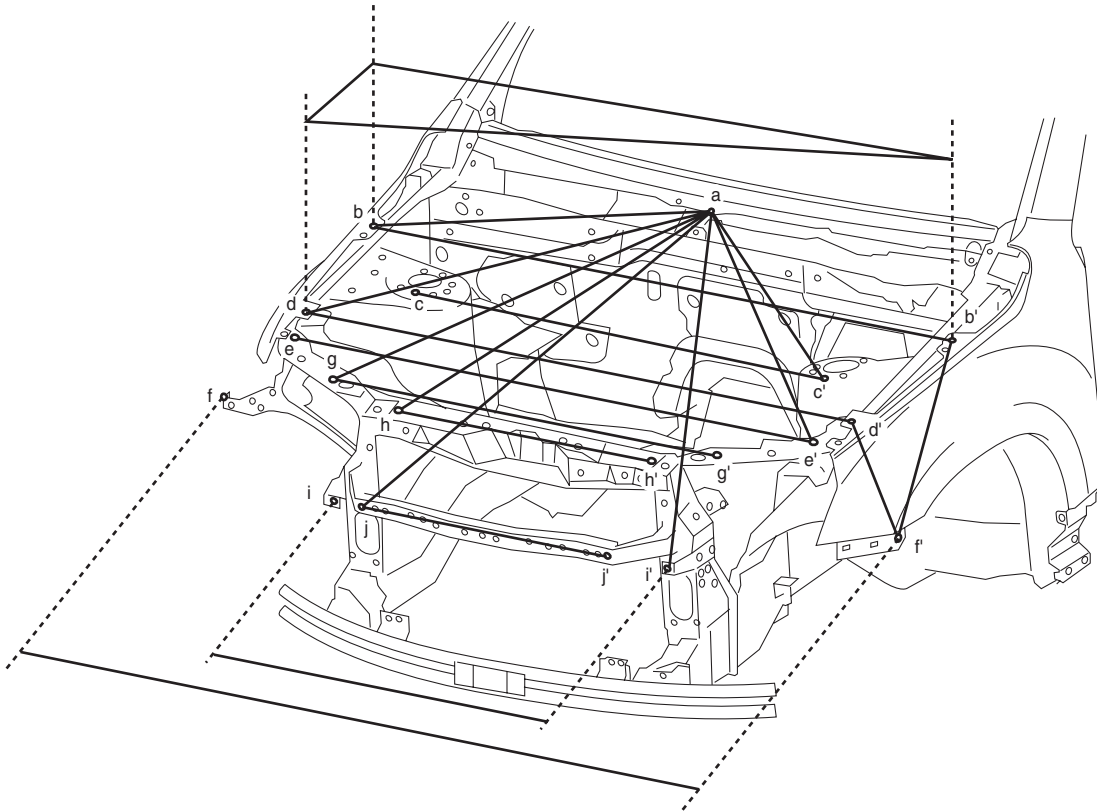
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Specifications

Body Dimensions

S5JB0A9B07001

Engine Room



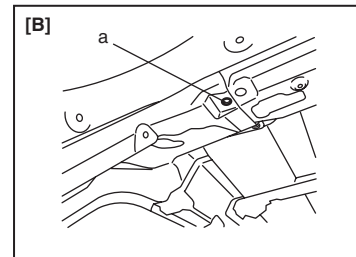
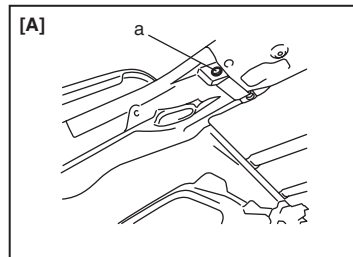
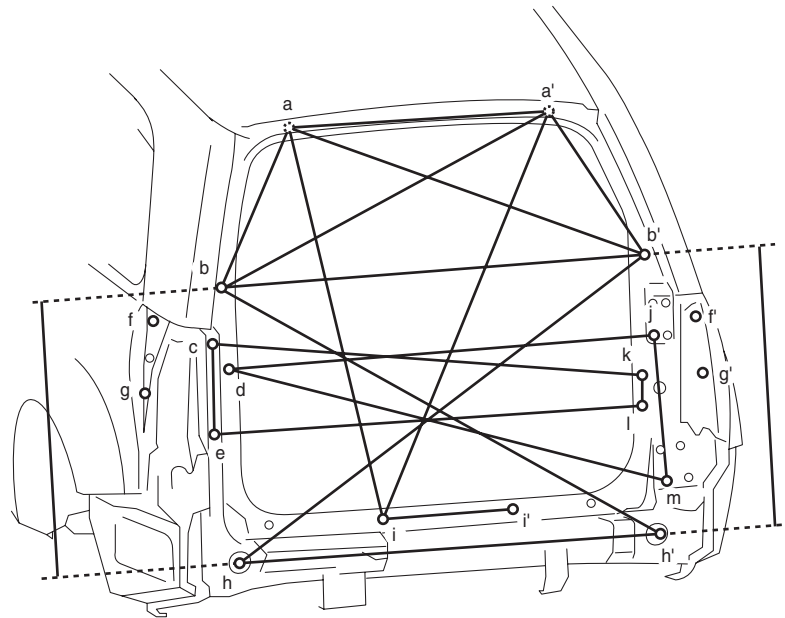
I5JB0A9B0004-01

a. Cowl top installation center hole	e (e'). Headlight installation hole	i (i'). Headlight installation hole
b (b'). Front fender installation hole	f (f'). Front fender installation hole	j (j'). Front upper member installation hole
c (c'). Jig hole (ϕ 8 mm)	g (g'). Headlight installation hole	
d (d'). Front fender installation hole	h (h'). Hood lock member installation hole	

Hole to hole distance

a-b(b') : 792 mm (31.18 in.)	a-j(j') : 1111 mm (43.74 in.)	d(d')-f(f') : 277 mm (10.91 in.)
a-c(c') : 697 mm (27.44 in.)	b-b' : 1512 mm (59.53 in.)	e-e' : 1384 mm (54.49 in.)
a-d(d') : 937 mm (36.89 in.)	b(b')-d(d') : 375 mm (14.76 in.)	f-f' : 1750 mm (68.90 in.)
a-e(e') : 982 mm (38.66 in.)	b(b')-f(f') : 535 mm (21.06 in.)	g-g' : 980 mm (38.58 in.)
a-g(g') : 969 mm (38.15 in.)	c-c' : 1089 mm (42.87 in.)	h-h' : 662 mm (26.06 in.)
a-h(h') : 910 mm (35.83 in.)	d-b' : 1519 mm (59.80 in.)	i-i' : 865 mm (34.06 in.)
a-i(i') : 1110 mm (43.70 in.)	d-d' : 1432 mm (56.38 in.)	j-j' : 630 mm (24.80 in.)

Rear End Door



I5JB0A9B0005-01

[A]: 5 door model	c (c'). Rear combination lamp installation hole	g (g'). Rear combination lamp clip installation hole
[B]: 3 door model	d (d'). Rear end door switch installation hole	h (h'). Jig hole (φ 15 mm)
a (a'). Roof back inner panel bolt installation hole	e (e'). Rear combination lamp installation hole	i (i'). Rear bumper installation hole
b (b'). Jig hole (φ 15 mm)	f (f'). Rear combination lamp clip installation hole	

Hole to hole distance for 5 door model

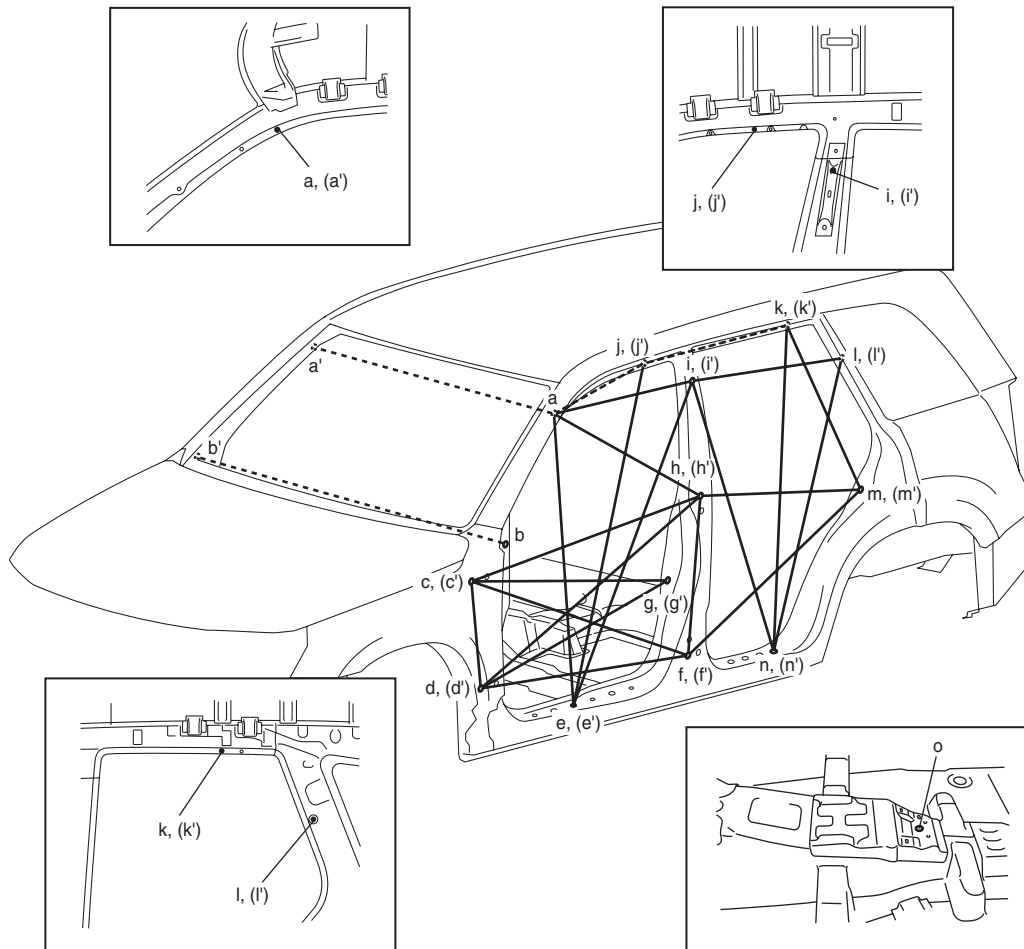
a-a': 718 mm (28.27 in.)	b-h: 729 mm (28.70 in.)	e-l: 1208 mm (47.56 in.)
a-b: 436 mm (17.17 in.)	b-h': 1355 mm (53.35 in.)	f-f': 1491 mm (58.70 in.)
a-b': 1002 mm (39.45 in.)	b'-h: 1347 mm (53.03 in.)	g-g': 1548 mm (60.94 in.)
a-i: 1019 mm (40.12 in.)	b'-h': 727 mm (28.62 in.)	h-h': 1138 mm (44.80 in.)
a'-b: 1006 mm (39.61 in.)	c-e: 264 mm (10.39 in.)	i-i': 300 mm (11.81 in.)
a'-b': 438 mm (17.24 in.)	c-k: 1214 mm (47.80 in.)	j-m: 385 mm (15.16 in.)
a'-i: 1120 mm (44.09 in.)	d-j: 1163 mm (45.79 in.)	k-l: 145 mm (57.09 in.)
b-b': 1138 mm (44.80 in.)	d-m: 1213 mm (47.76 in.)	

Hole to hole distance for 3 door model

a-a': 718 mm (28.27 in.)	b-h: 729 mm (28.70 in.)	e-l: 1208 mm (47.56 in.)
a-b: 436 mm (17.17 in.)	b-h': 1355 mm (53.35 in.)	f-f': 1491 mm (58.70 in.)
a-b': 1002 mm (39.45 in.)	b'-h: 1347 mm (53.03 in.)	g-g': 1548 mm (60.94 in.)
a-i: 1019 mm (40.12 in.)	b'-h': 727 mm (28.62 in.)	h-h': 1138 mm (44.80 in.)
a'-b: 1006 mm (39.61 in.)	c-e: 264 mm (10.39 in.)	i-i': 300 mm (11.81 in.)
a'-b': 438 mm (17.24 in.)	c-k: 1214 mm (47.80 in.)	j-m: 385 mm (15.16 in.)
a'-i: 1120 mm (44.09 in.)	d-j: 1163 mm (45.79 in.)	k-l: 145 mm (57.09 in.)
b-b': 1138 mm (44.80 in.)	d-m: 1213 mm (47.76 in.)	

Side Body

5 door model



15JB0A9B0006-02

a (a'). Jig hole (φ 8 mm)	f (f'). Rear door lower hinge installation front side hole	k (k'). Jig hole (φ 8 mm)
b (b'). Steering support member installation hole	g (g'). Front door switch installation hole	l (l'). Rear quarter upper trim installation hole
c (c'). Front door upper hinge installation front side hole	h (h'). Rear door upper hinge installation upper side hole	m (m'). Rear door switch installation hole
d (d'). Front door lower hinge installation front side hole	i (i'). Jig hole (φ 8 mm)	n (n'). Rear side sill scuff installation hole
e (e'). Front side sill scuff installation hole	j (j'). Jig hole (φ 8 mm)	o. Jig hole (φ 10 mm)

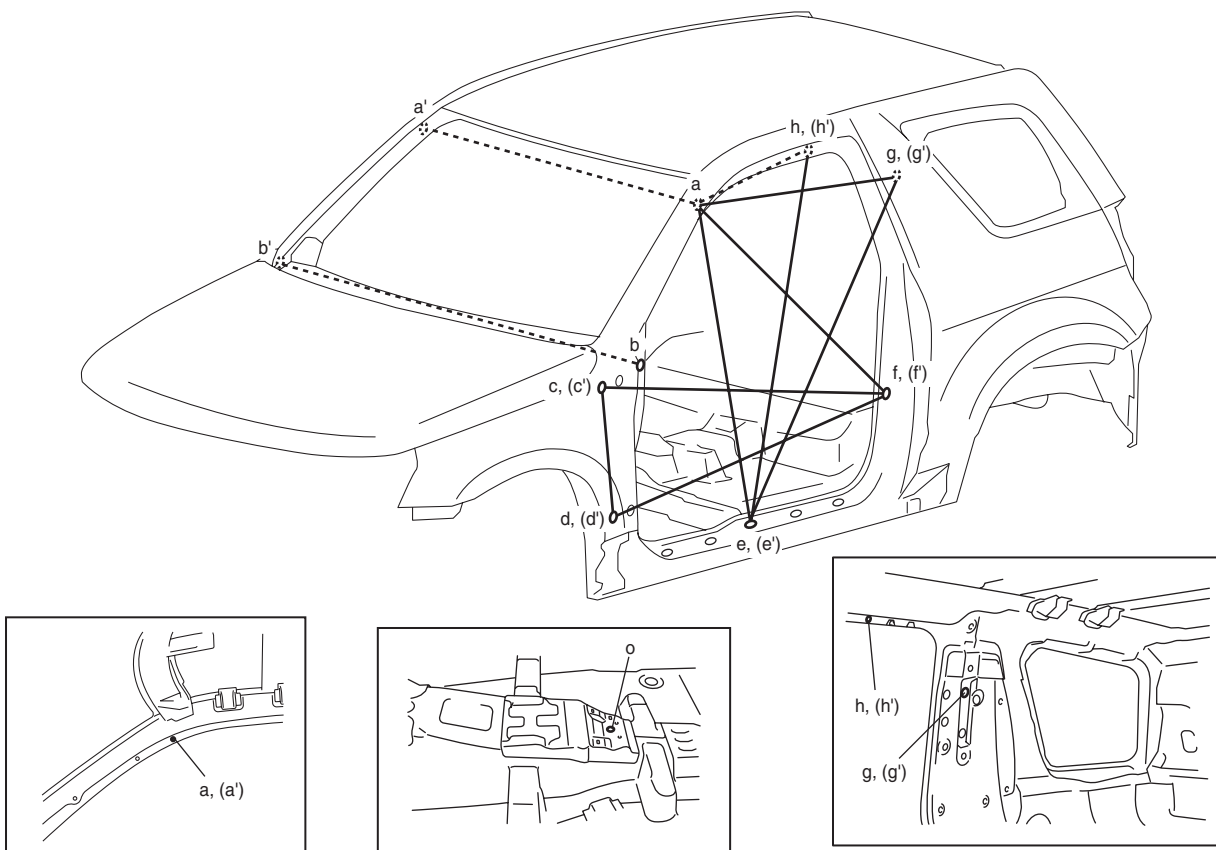
Hole to hole distance

a-a': 1248 mm (49.13 in.)	d(d')-f(f'): 1085 mm (42.72 in.)	i-i': 1302 mm (51.26 in.)
a(a')-e(e'): 1093 mm (43.03 in.)	d(d')-g(g'): 1081 mm (42.56 in.)	i(i')-n(n'): 1063 mm (41.85 in.)
a(a')-h(h'): 731 mm (28.78 in.)	d(d')-h(h'): 1226 mm (44.33 in.)	i(i')-l(l'): 833 mm (32.80 in.)
a(a')-i(i'): 573 mm (22.56 in.)	e-e': 1567 mm (61.69 in.)	j-j': 1205 mm (47.44 in.)
a(a')-j(j'): 340 mm (13.39 in.)	e(e')-i(i'): 1248 mm (49.13 in.)	j(j')-k(k'): 753 mm (29.65 in.)
b-b': 1506 mm (59.29 in.)	e(e')-j(j'): 1239 mm (48.78 in.)	k-k': 1190 mm (46.85 in.)
c-c': 1594 mm (62.76 in.)	f(f'): 1621 mm (63.82 in.)	k(k')-m(m'): 713 mm (28.07 in.)
c(c')-d(d'): 345 mm (13.58 in.)	f(f')-h(h'): 391 mm (15.39 in.)	k(k')-n(n'): 1171 mm (46.10 in.)
c(c')-f(f'): 1123 mm (44.21 in.)	f(f')-m(m'): 979 mm (38.54 in.)	l-l': 1329 mm (52.32 in.)
c(c')-g(g'): 1149 mm (45.24 in.)	g-g': 1472 mm (57.95 in.)	l(l')-n(n'): 1069 mm (42.09 in.)
c(c')-h(h'): 1148 mm (45.20 in.)	h-h': 1580 mm (62.20 in.)	m-m': 1476 mm (58.11 in.)
d-d': 1630 mm (64.17 in.)	h(h')-m(m'): 859 mm (33.82 in.)	n-n': 1567 mm (61.69 in.)

NOTE

Use jig hole (o) as datum point to check symmetry of body structure.

3 door model



I5JB0A9B0007-01

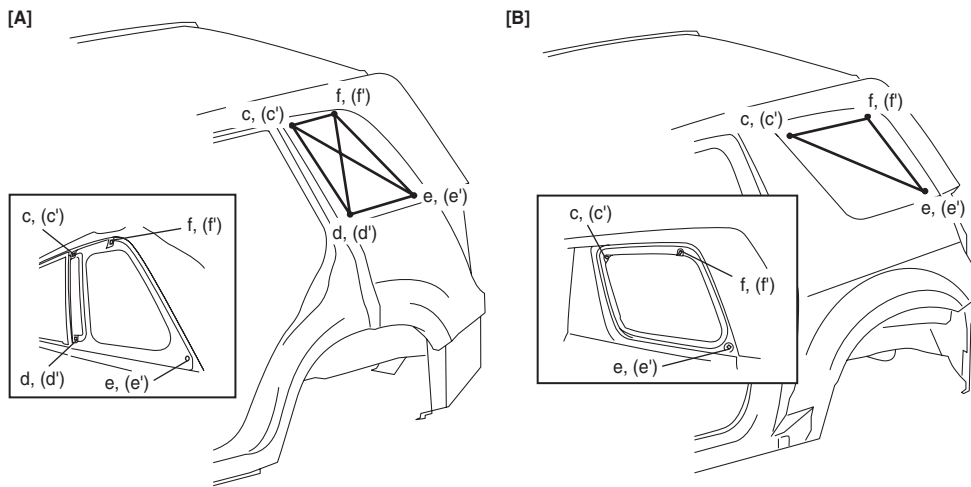
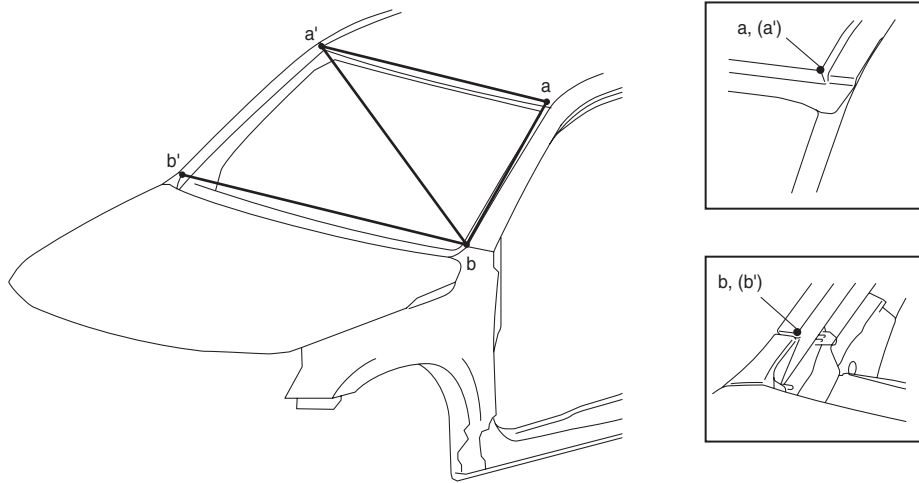
a (a'). Jig hole (φ 8 mm)	d (d'). Door lower hinge installation front side hole	g (g'). Jig hole (φ 8 mm)
b (b'). Steering support member installation hole	e (e'). Side sill scuff installation hole	h (h'). Jig hole (φ 8 mm)
c (c'). Door upper hinge installation front side hole	f (f'). Door switch installation hole	

Hole to hole distance

a-a': 1248 mm (49.13 in.)	c-c': 1593 mm (62.72 in.)	e(e')-h(h'): 1183 mm (46.57 in.)
a(a')-e(e'): 1064 mm (41.89 in.)	c(c')-d(d'): 345 mm (13.58 in.)	f-f': 1467 mm (57.76 in.)
a(a')-f(f'): 937 mm (36.89 in.)	c(c')-f(f'): 1298 mm (51.10 in.)	g-g': 1337 mm (52.64 in.)
a(a')-g(g'): 708 mm (27.87 in.)	d-d': 1630 mm (64.17 in.)	h-h': 1207 mm (47.52 in.)
a(a')-h(h'): 355 mm (13.98 in.)	e-e': 1567 mm (61.69 in.)	
b-b': 1506 mm (59.29 in.)	e(e')-g(g'): 1217 mm (47.91 in.)	

NOTE

Use jig hole (o) as datum point to check symmetry of body structure.



15JB0A9B0008-01

[A]: 5 door model	b (b'). Front pillar end corner	e (e'). Rear quarter window installation hole
[B]: 3 door model	c (c'). Rear quarter window installation hole	f (f'). Rear quarter window installation hole
a (a'). Roof panel end corner	d (d'). Rear quarter window installation hole	

Hole to hole distance for 5 door model

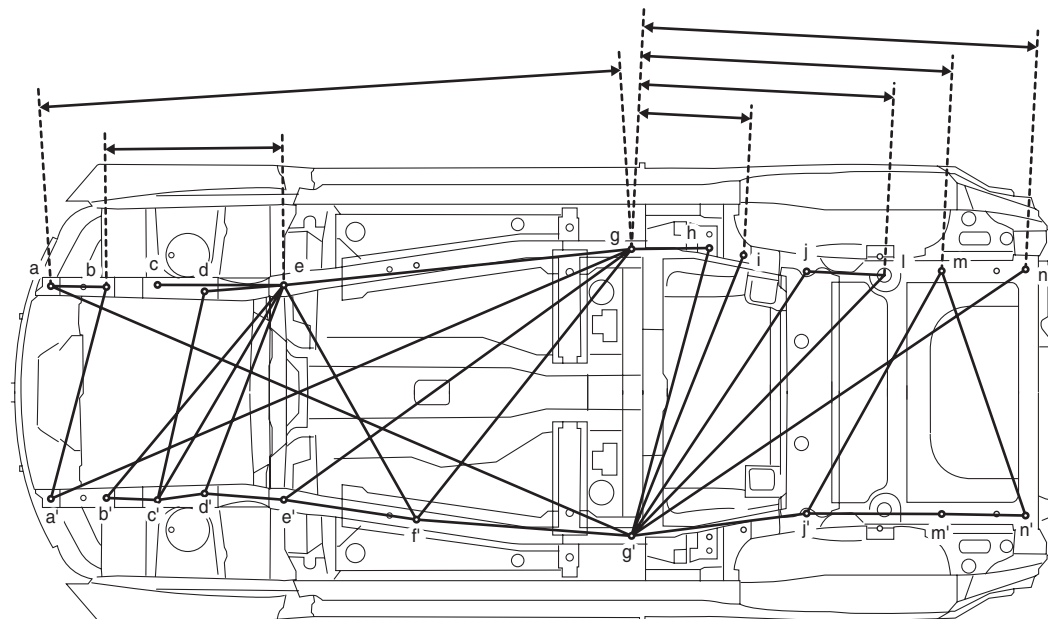
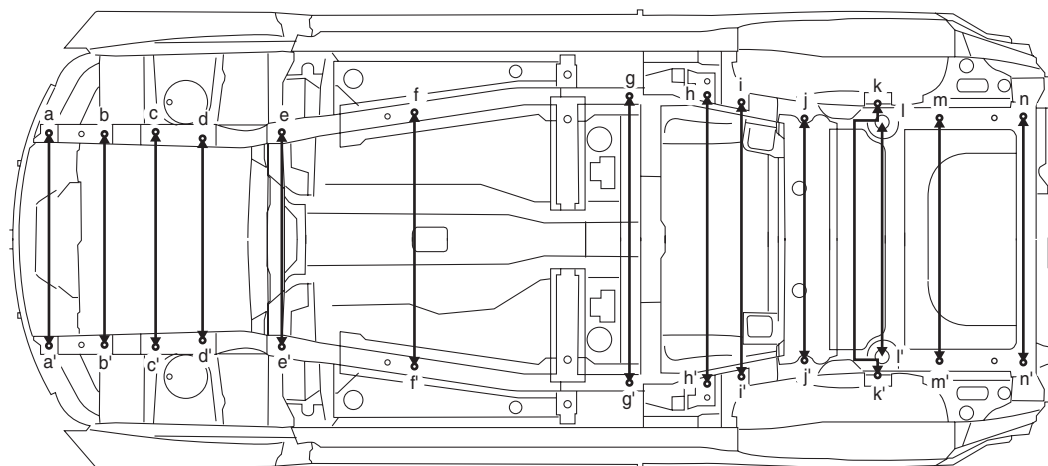
a-a': 1131 mm (44.53 in.)	c(c')-d(d)': 409 mm (16.10 in.)	d(d')-f(f)': 383 mm (15.08 in.)
a-b: 717 mm (28.23 in.)	c(c')-e(e)': 710 mm (27.95 in.)	e-e': 1458 mm (57.40 in.)
a'-b: 1478 mm (58.19 in.)	c(c')-f(f)': 268 mm (10.55 in.)	e(e')-f(f)': 496 mm (19.53 in.)
b-b': 1475 mm (58.07 in.)	d-d': 1509 mm (59.41 in.)	f-f': 1293 mm (48.78 in.)
c-c': 1252 mm (49.29 in.)	d(d')-e(e)': 443 mm (17.44 in.)	

Hole to hole distance for 3 door model

a-a': 1128 mm (44.41 in.)	c-c': 1301 mm (51.22 in.)	e(e')-f(f)': 418 mm (16.46 in.)
a-b: 717 mm (28.23 in.)	c(c')-e(e)': 756 mm (29.76 in.)	f-f': 1249 mm (49.17 in.)
a'-b: 1478 mm (58.19 in.)	c(c')-f(f)': 433 mm (17.05 in.)	
b-b': 1478 mm (58.19 in.)	e-e': 1480 mm (58.27 in.)	

Under Body

5 door model



I5JB0A9B0009-01

a (a'). Jig hole (φ 16 mm)	f (f'). Engine rear mounting member installation hole	k (k'). Rear shock absorber installation hole
b (b'). Front suspension frame installation hole	g (g'). Jig hole (φ 25 mm)	l (l'). Rear coil spring hole
c (c'). Front suspension frame installation hole	h (h'). Trailing rod mount bracket installation front inner side hole	m (m'). Rear suspension frame installation rear side hole
d (d'). Front suspension frame installation hole	i (i'). Trailing rod mount bracket installation rear side hole	n (n'). Towing hook installation hole
e (e'). Front suspension frame installation hole	j (j'). Rear suspension frame installation front side hole	

Hole to hole distance

a-a': 860 mm (33.86 in.)	f-f': 1013 mm (39.88 in.)	k-k': 1079 mm (42.48 in.)
b-b': 830 mm (32.68 in.)	g-g': 1144 mm (45.04 in.)	l-l': 936 mm (36.85 in.)
c-c': 840 mm (33.07 in.)	h-h': 1134 mm (44.65 in.)	m-m': 955 mm (37.60 in.)
d-d': 794 mm (31.26 in.)	i-i': 1116 mm (43.94 in.)	n-n': 953 mm (37.52 in.)
e-e': 860 mm (33.86 in.)	j-j': 1000 mm (39.37 in.)	

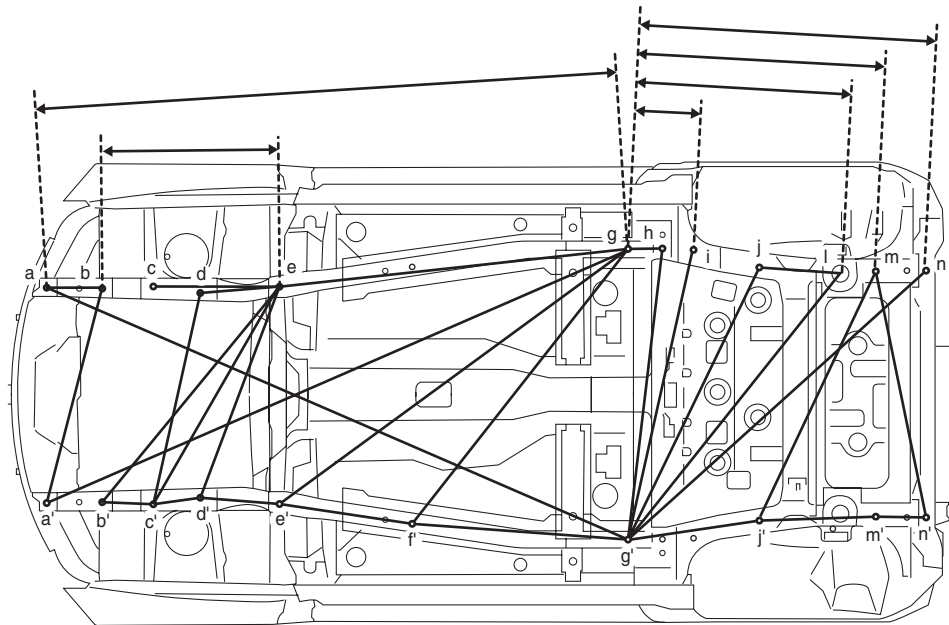
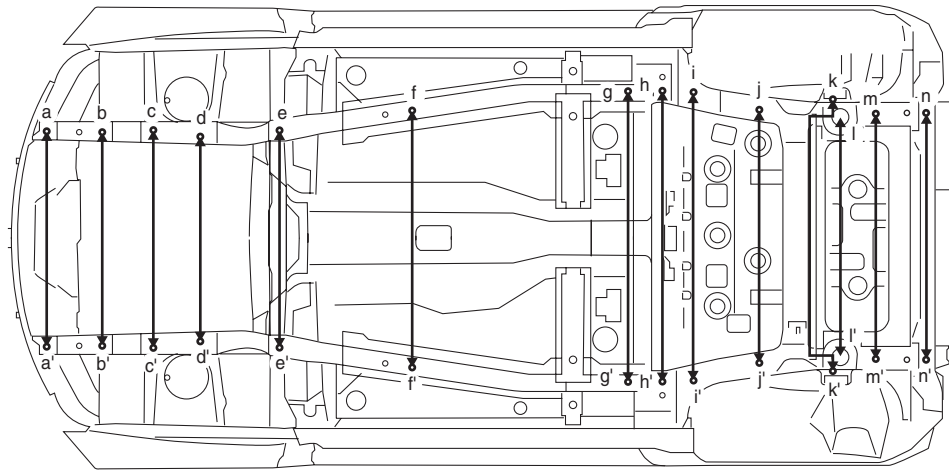
Hole to hole distance

a-b: 198 mm (7.80 in.)	d-e: 384 mm (15.12 in.)	g'-h: 1177 mm (46.34 in.)
a-g: 2320 mm (91.34 in.)	d'-e: 911 mm (35.87 in.)	g'-i: 1214 mm (47.80 in.)
a-g': 2523 mm (99.33 in.)	d'-e': 384 mm (15.12 in.)	g'-j: 1288 mm (50.71 in.)

9K-10 Body Structure:

a'-b: 868 mm (34.17 in.)	e-f': 1067 mm (42.01 in.)	g'-j': 718 mm (28.27 in.)
a'-g: 2523 mm (99.33 in.)	e-g: 1381 mm (54.37 in.)	g'-l: 1446 mm (56.93 in.)
b-e: 750 mm (29.53 in.)	f'-g: 1380 mm (54.33 in.)	g'-n: 1892 mm (74.49 in.)
b'-c': 249 mm (9.80 in.)	f'-g': 864 mm (34.02 in.)	j-l: 314 mm (12.36 in.)
b'-e: 1130 mm (44.49 in.)	g-h: 295 mm (11.61 in.)	j'-m: 1078 mm (42.44 in.)
c-e: 532 mm (20.94 in.)	g-i: 445 mm (17.52 in.)	j'-m': 455 mm (17.91 in.)
c'-d: 833 mm (32.80 in.)	g-l: 1010 mm (39.76 in.)	m-n': 1046 mm (41.18 in.)
c'-d': 163 mm (6.42 in.)	g-m: 1158 mm (45.59 in.)	m'-n': 429 mm (16.89 in.)
c'-e: 1003 mm (39.49 in.)	g-n: 1577 mm (62.09 in.)	

3 door model



15JB0A9B0010-01

a (a'). Jig hole (φ 16 mm)	f (f'). Engine rear mounting member installation hole	k (k'). Rear shock absorber installation hole
b (b'). Front suspension frame installation hole	g (g'). Jig hole (φ 25 mm)	l (l'). Rear coil spring hole
c (c'). Front suspension frame installation hole	h (h'). Trailing rod mount bracket installation front inner side hole	m (m'). Rear suspension frame installation rear side hole
d (d'). Front suspension frame installation hole	i (i'). Trailing rod mount bracket installation rear side hole	n (n'). Towing hook installation hole
e (e'). Front suspension frame installation hole	j (j'). Rear suspension frame installation front side hole	

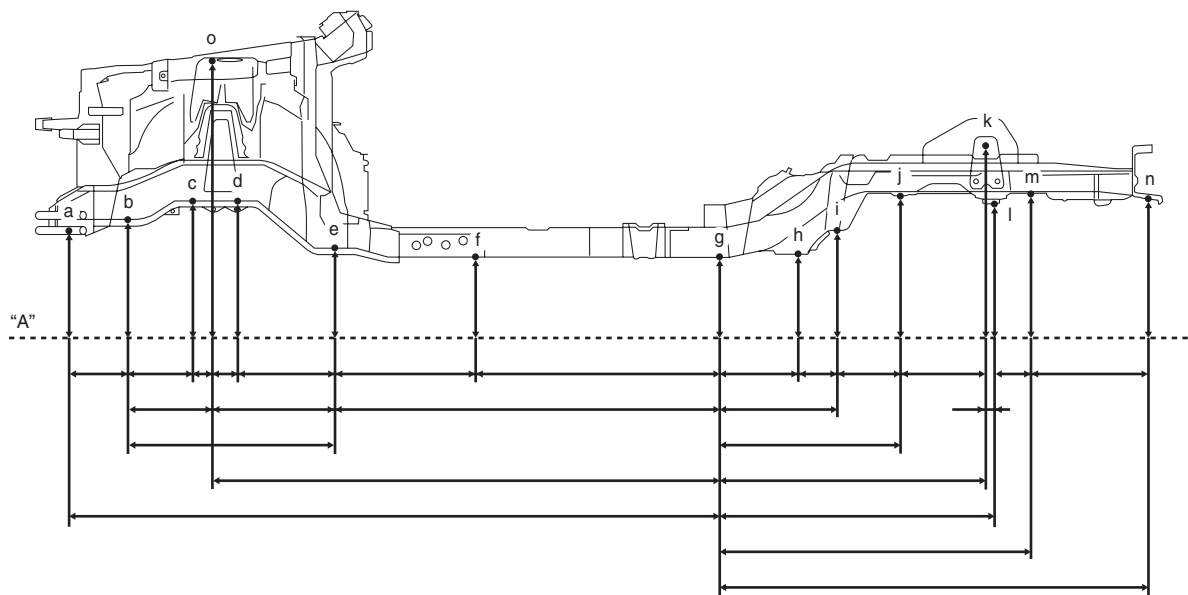
Hole to hole distance

a-a': 860 mm (33.86 in.)	f-f': 1013 mm (39.88 in.)	k-k': 1154 mm (45.43 in.)
b-b': 830 mm (32.68 in.)	g-g': 1144 mm (45.04 in.)	l-l': 937 mm (36.89 in.)
c-c': 840 mm (33.07 in.)	h-h': 1134 mm (44.65 in.)	m-m': 955 mm (37.60 in.)
d-d': 794 mm (31.26 in.)	i-i': 1116 mm (43.94 in.)	n-n': 954 mm (37.56 in.)
e-e': 860 mm (33.86 in.)	j-j': 1000 mm (39.37 in.)	

Hole to hole distance

a-b: 198 mm (7.80 in.)	d-e: 384 mm (15.12 in.)	g'-h: 1143 mm (45.00 in.)
a-g: 2320 mm (91.34 in.)	d'-e: 911 mm (35.87 in.)	g'-i: 1158 mm (45.59 in.)
a-g': 2523 mm (99.33 in.)	d'-e': 384 mm (15.12 in.)	g'-j: 1196 mm (47.09 in.)
a'-b: 868 mm (34.17 in.)	e-f': 1067 mm (42.01 in.)	g'-j': 534 mm (21.02 in.)
a'-g: 2523 mm (99.33 in.)	e-g: 1381 mm (54.37 in.)	g'-l: 1317 mm (51.85 in.)
b-e: 750 mm (29.53 in.)	f'-g: 1380 mm (54.33 in.)	g'-n: 1549 mm (60.98 in.)
b'-c': 249 mm (9.80 in.)	f'-g': 864 mm (34.02 in.)	j-l: 314 mm (12.36 in.)
b'-e: 1130 mm (44.49 in.)	g-h: 96 mm (3.78 in.)	j'-m: 1078 mm (42.44 in.)
c-e: 532 mm (20.94 in.)	g-i: 254 mm (10.00 in.)	j'-m': 455 mm (17.91 in.)
c'-d: 833 mm (32.80 in.)	g-l: 815 mm (32.09 in.)	m-n': 973 mm (38.31 in.)
c'-d': 163 mm (6.42 in.)	g-m: 963 mm (37.91 in.)	m'-n': 190 mm (7.48 in.)
c'-e: 1003 mm (39.49 in.)	g-n: 1144 mm (45.04 in.)	

5 door model



I5JB0A9B0011-01

a. Jig hole (φ 16 mm)	f. Engine rear mounting member installation hole	k. Rear shock absorber installation hole
b. Front suspension frame installation hole	g. Jig hole (φ 25 mm)	l. Rear coil spring hole
c. Front suspension frame installation hole	h. Trailing rod mount bracket installation front inner side hole	m. Rear suspension frame installation rear side hole
d. Front suspension frame installation hole	i. Trailing rod mount bracket installation rear side hole	n. Towing hook installation hole
e. Front suspension frame installation hole	j. Rear suspension frame installation front side hole	o. Jig hole (φ 10 mm)

Hole to hole distance

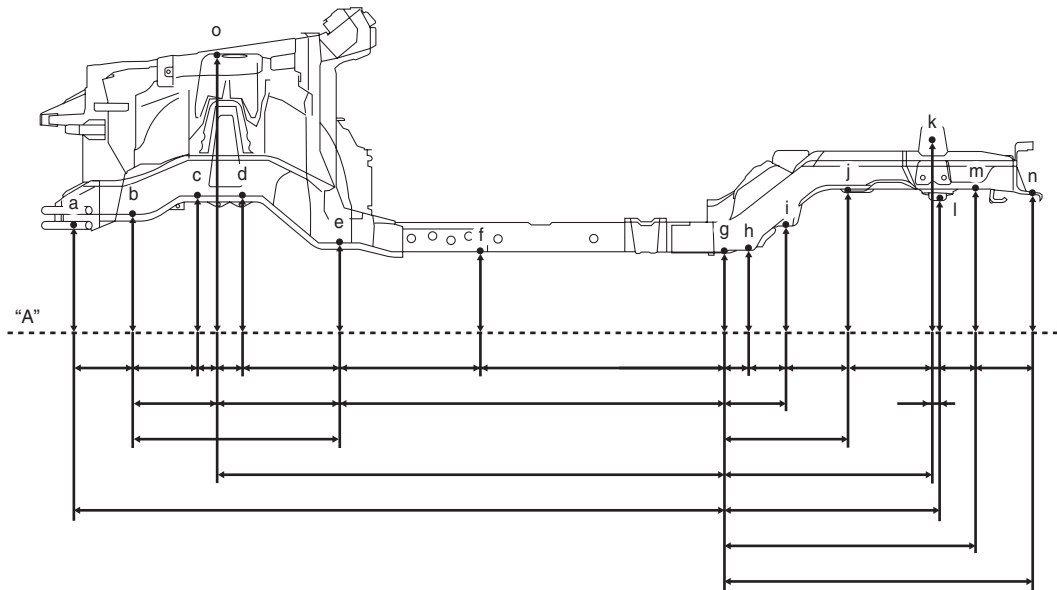
a-b: 196 mm (7.72 in.)	d-e: 344 mm (13.54 in.)	g-m: 1131 mm (44.53 in.)
a-g: 2313 mm (91.06 in.)	e-f: 512 mm (20.16 in.)	g-n: 1560 mm (61.42 in.)
b-c: 239 mm (9.41 in.)	e-g: 1373 mm (54.06 in.)	h-i: 139 mm (5.47 in.)
b-o: 289 mm (11.38 in.)	f-g: 862 mm (33.94 in.)	i-j: 243 mm (9.57 in.)
b-e: 744 mm (29.29 in.)	g-h: 295 mm (11.61 in.)	j-k: 294 mm (11.57 in.)
c-o: 50 mm (1.97 in.)	g-i: 434 mm (17.09 in.)	k-l: 15 mm (0.59 in.)
o-d: 111 mm (4.37 in.)	g-j: 677 mm (26.65 in.)	l-m: 145 mm (5.71 in.)
o-e: 455 mm (17.91 in.)	g'-k: 971 mm (38.23 in.)	m-n: 429 mm (16.89 in.)
o-g: 1828 mm (71.97 in.)	g-l: 987 mm (38.86 in.)	

9K-12 Body Structure:

Projection dimension from standard line "A"

a: 166 mm (6.54 in.)	f: 66 mm (2.60 in.)	k: 436 mm (17.17 in.)
b: 193 mm (7.60 in.)	g: 64 mm (2.52 in.)	l: 252 mm (9.92 in.)
c: 263 mm (10.35 in.)	h: 72 mm (2.83 in.)	m: 293 mm (11.54 in.)
d: 263 mm (10.35 in.)	i: 159 mm (6.26 in.)	n: 275 mm (10.83 in.)
e: 95 mm (3.74 in.)	j: 293 mm (11.54 in.)	o: 774 mm (30.47 in.)

3 door model



I5JB0A9B0012-01

a. Jig hole (ϕ 16 mm)	f. Engine rear mounting member installation hole	k. Rear shock absorber installation hole
b. Front suspension frame installation hole	g. Jig hole (ϕ 25 mm)	l. Rear coil spring hole
c. Front suspension frame installation hole	h. Trailing rod mount bracket installation front inner side hole	m. Rear suspension frame installation rear side hole
d. Front suspension frame installation hole	i. Trailing rod mount bracket installation rear side hole	n. Towing hook installation hole
e. Front suspension frame installation hole	j. Rear suspension frame installation front side hole	o. Jig hole (ϕ 10 mm)

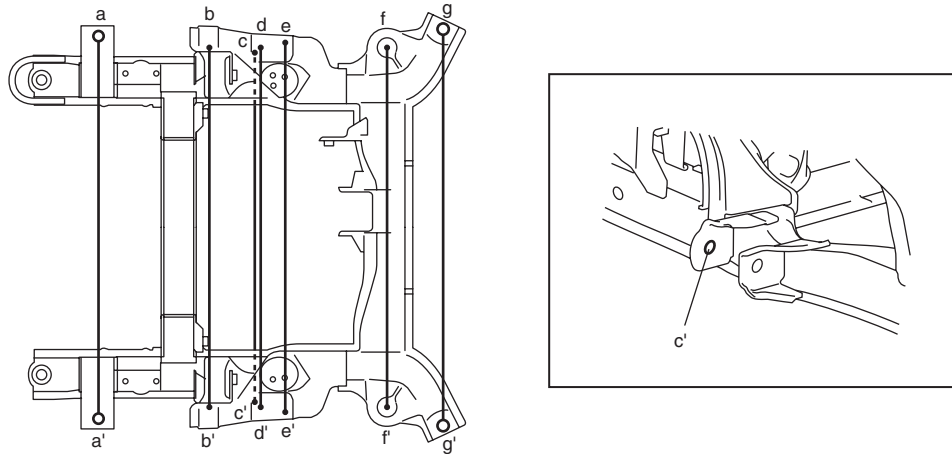
Hole to hole distance

a-b: 196 mm (7.72 in.)	d-e: 344 mm (13.54 in.)	g-m: 931 mm (36.65 in.)
a-g: 2313 mm (91.06 in.)	e-f: 511 mm (20.12 in.)	g-n: 1120 mm (44.09 in.)
b-c: 239 mm (9.41 in.)	e-g: 1373 mm (54.06 in.)	h-i: 139 mm (5.47 in.)
b-o: 289 mm (11.38 in.)	f-g: 862 mm (33.94 in.)	i-j: 243 mm (9.57 in.)
b-e: 744 mm (29.29 in.)	g-h: 95 mm (3.74 in.)	j-k: 294 mm (11.57 in.)
c-o: 50 mm (1.97 in.)	g-i: 234 mm (9.21 in.)	k-l: 15 mm (0.59 in.)
o-d: 111 mm (4.37 in.)	g-j: 477 mm (18.78 in.)	l-m: 145 mm (5.71 in.)
o-e: 455 mm (17.91 in.)	g'-k: 771 mm (30.35 in.)	m-n: 189 mm (7.44 in.)
o-g: 1828 mm (71.97 in.)	g-l: 786 mm (30.94 in.)	

Projection dimension from standard line "A"

a: 166 mm (6.54 in.)	f: 65 mm (2.56 in.)	k: 440 mm (17.32 in.)
b: 193 mm (7.60 in.)	g: 63 mm (2.48 in.)	l: 250 mm (9.84 in.)
c: 263 mm (10.35 in.)	h: 73 mm (2.87 in.)	m: 293 mm (11.54 in.)
d: 263 mm (10.35 in.)	i: 160 mm (6.30 in.)	n: 275 mm (10.83 in.)
e: 95 mm (3.74 in.)	j: 293 mm (11.54 in.)	o: 772 mm (30.39 in.)

Front Suspension Frame

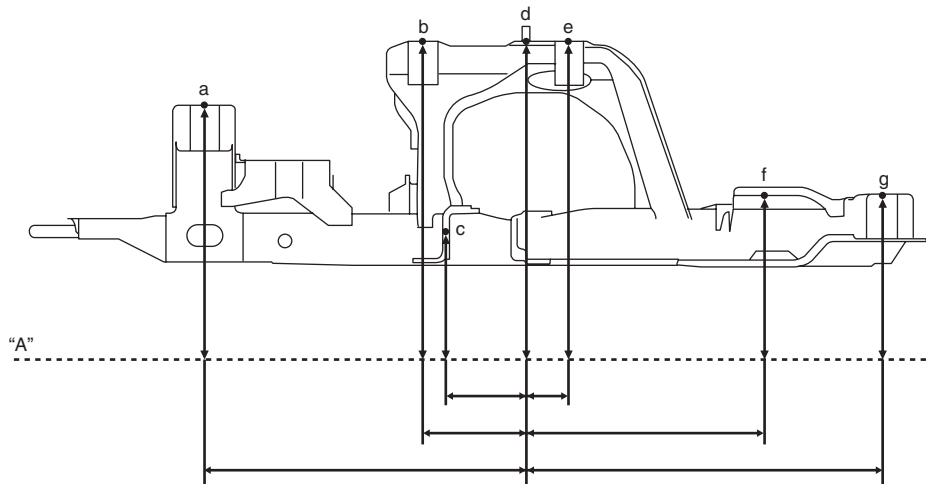


I5JB0A9B0013-01

a (a'). Front suspension frame installation front side bolt hole	d (d'). Front suspension frame stud	g (g'). Front suspension frame installation rear side bolt hole
b (b'). Front suspension frame installation bolt hole	e (e'). Front suspension frame installation bolt hole	
c (c'). Front suspension arm installation front side hole	f (f'). Front suspension arm installation rear side hole	

Hole to hole distance

a-a': 830 mm (32.68 in.)	d-d': 790 mm (31.10 in.)	g-g': 860 mm (33.86 in.)
b-b': 840 mm (33.07 in.)	e-e': 794 mm (31.26 in.)	
c-c': 780 mm (30.71 in.)	f-f': 780 mm (30.71 in.)	



I5JB0A9B0014-01

a. Front suspension frame installation front side bolt hole	d. Front suspension frame stud	g. Front suspension frame installation rear side bolt hole
b. Front suspension frame installation bolt hole	e. Front suspension frame installation bolt hole	
c. Front suspension arm installation front side hole	f. Front suspension arm installation rear side hole	

Hole to hole distance

a-d: 349 mm (13.74 in.)	d-e: 51 mm (2.01 in.)
b-d: 110 mm (4.33 in.)	d-f: 275 mm (10.83 in.)
c-d: 80 mm (3.15 in.)	d-g: 395 mm (15.55 in.)

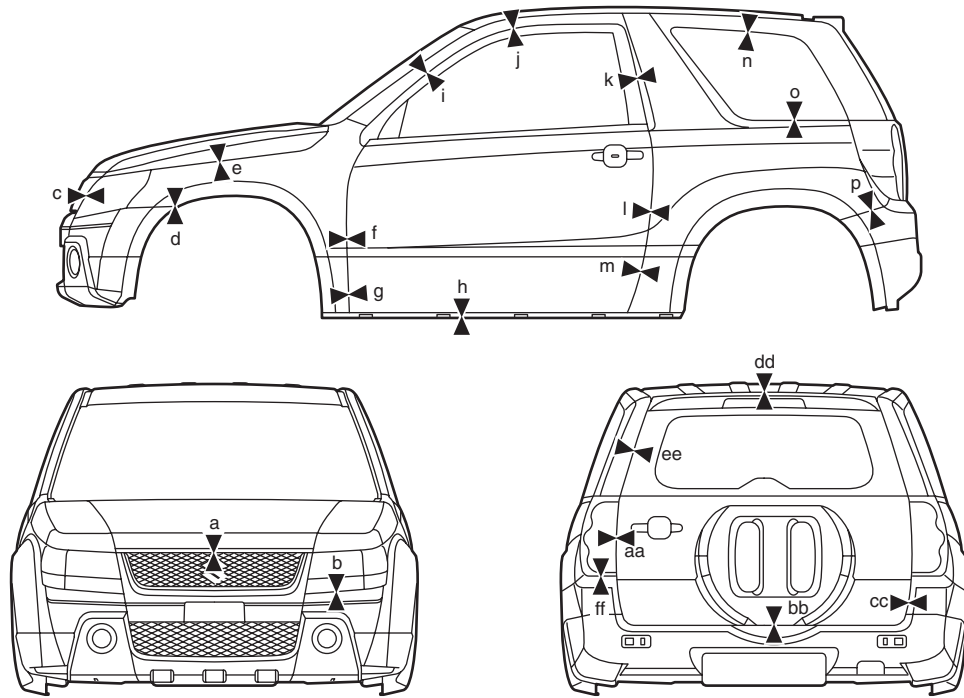
Projection dimension from standard line "A"

a: 193 mm (7.60 in.)	d: 263 mm (10.35 in.)	g: 95 mm (3.74 in.)
b: 263 mm (10.35 in.)	e: 263 mm (10.35 in.)	
c: 49 mm (1.93 in.)	f: 96 mm (3.78 in.)	

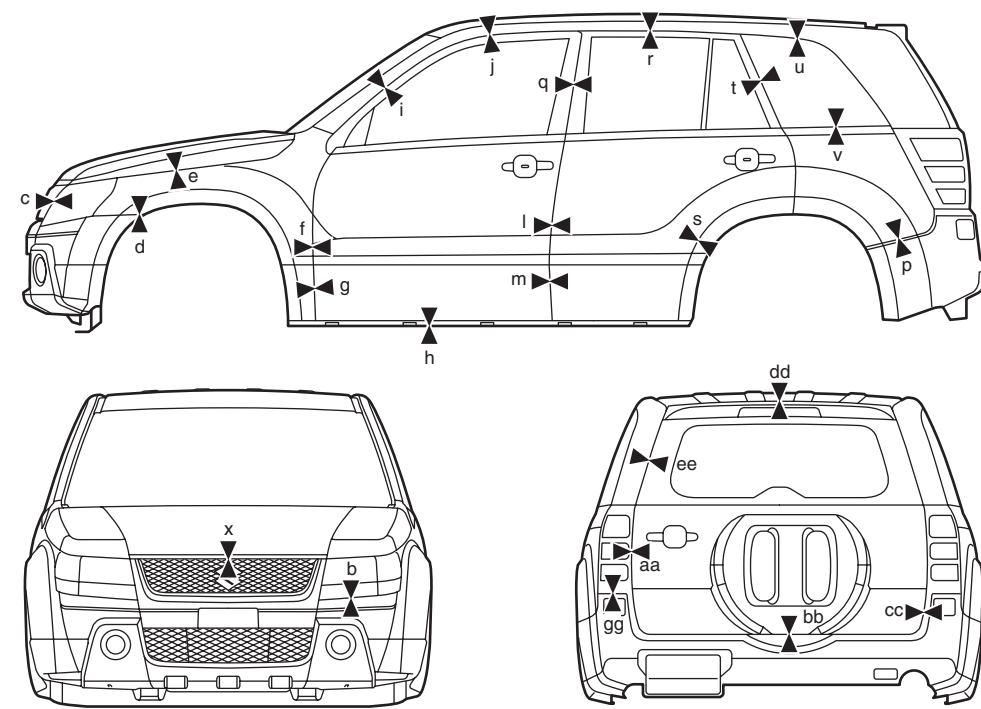
Panel Clearance

S5JB0A9B07002

[A]



[B]



I5JB0A9B0015-01

Panel to panel distance

[A]: 3 door model	j: 4.0 – 6.0 mm (0.158 – 0.236 in.)	u: 1.8 – 3.8 mm (0.071 – 0.149 in.)
[B]: 5 door model	k: 4.4 – 6.4 mm (0.213 – 0.251 in.)	v: 3.3 – 5.3 mm (0.130 – 0.208 in.)
a: 4.9 – 6.9 mm (0.193 – 0.271 in.)	l: 3.0 – 5.0 mm (0.119 – 0.196 in.)	w: 3.0 – 5.0 mm (0.119 – 0.196 in.)
b: 1.0 – 3.0 mm (0.040 – 0.118 in.)	m: 4.0 – 6.0 mm (0.158 – 0.236 in.)	x: 5.9 – 7.9 mm (0.233 – 0.311 in.)
c: 1.9 – 2.9 mm (0.075 – 0.114 in.)	n: 2.5 – 4.5 mm (0.099 – 0.177 in.)	aa: 4.0 – 6.0 mm (0.158 – 0.236 in.)
d: 0.5 – 1.0 mm (0.020 – 0.039 in.)	o: 2.0 – 4.0 mm (0.079 – 0.157 in.)	bb: 6.3 – 8.3 mm (0.249 – 0.327 in.)
e: 5.8 – 7.8 mm (0.229 – 0.307 in.)	p: 0.5 – 1.0 mm (0.020 – 0.039 in.)	cc: 5.0 – 7.0 mm (0.197 – 0.275 in.)
f: 3.0 – 5.0 mm (0.119 – 0.196 in.)	q: 3.0 – 5.0 mm (0.119 – 0.196 in.)	dd: 6.2 – 8.2 mm (0.245 – 0.322 in.)
g: 4.0 – 6.0 mm (0.158 – 0.236 in.)	r: 4.0 – 6.0 mm (0.158 – 0.236 in.)	ee: 4.0 – 6.0 mm (0.158 – 0.236 in.)
h: 15.7 – 17.7 mm (0.619 – 0.696 in.)	s: 17.5 – 19.5 mm (0.689 – 0.767 in.)	ff: 1.1 – 3.1 mm (0.044 – 0.122 in.)
i: 4.0 – 6.0 mm (0.158 – 0.236 in.)	t: 6.0 – 8.0 mm (0.237 – 0.314 in.)	gg: 1.0 – 3.0 mm (0.040 – 0.118 in.)

Paint / Coatings

General Description

Anti-Corrosion Treatment Construction

S5JB0A9C01001

▲ WARNING

Standard shop practices, particularly eye protection, should be followed during the performance of the following operations to avoid personal injury.

As rust proof treatment, steel sheets are given corrosion resistance on the interior and/or exterior.

These corrosion resistance steel sheet materials are called one of two-side galvanized steel sheets.

It is for the sake of rust protection that these materials are selected and given a variety of treatments as described blow.

- Steel sheets are treated with cathodic electro primer which is excellent in corrosion resistance.
- Rust proof wax coatings are applied to door and side sill insides where moisture is liable to stay.
- Vinyl coating is applied to body underside and wheel housing inside.
- Sealer is applied to door hem, engine compartment steel sheet-to-steel sheet joint, and the like portions to prevent water penetration and resulting in rust occurrence.

In panel replacement or collision damage repair, leaving the relevant area untreated as it is in any operation which does disturb the rust proof treatment will cause corrosion to that area. Therefore, it is the essential function of any repair operation to correctly recoat the related surfaces of the relevant area.

All the metal panels are coated with metal conditioners and primer coating during vehicle production. Following the repair and/or replacement parts installation, every accessible bare metal surface should be cleaned and coated with rust proof primer. Perform this operation prior to the application of sealer and rust proof wax coating.

Sealer is applied to the specific joints of a vehicle during production. The sealer is intended to prevent dust from entering the vehicle and serves also as an anticorrosion barrier. The sealer is applied to the door and hood hem areas and between panels. Correct and reseal the originally sealed joints if damaged. Reseal the attaching joints of a new replacement panel and reseal the hem area of a replacement door or hood.

Use a quality sealer to seal the flanged joints, overlap joints and seams. The sealer must have flexible characteristics and paint ability after it's applied to repair areas.

For the sealer to fill open joints, use caulking material. Select a sealer in conformance with the place and purpose of a specific use. Observe the manufacturer's label-stand instructions when using the sealer.

In many cases, repaired places require color painting. When this is required, follow the ordinary techniques specified for the finish preparation, color painting and undercoating build-up.

Rust proof wax, a penetrative compound, is applied to the metal-to-metal surfaces (door and side sill insides) where it is difficult to use ordinary undercoating material for coating. Therefore, when selecting the rust proof wax, it may be the penetrative type.

During the undercoating (vinyl coating) application, care should be taken that sealer is not applied to the engine-related parts and shock absorber mounting or rotating parts. Following the under coating, make sure that body drain holes are kept open.

The sequence of the application steps of the anti-corrosion materials are as follows:

- 1) Clean and prepare the metal surface.
- 2) Apply primer.
- 3) Apply sealer (all joints sealed originally).
- 4) Apply color in areas where color is required such as hem flanges, exposed joints and under body components.
- 5) Apply anticorrosion compound (penetrative wax).
- 6) Apply undercoating (rust proof material).

Plastic Parts Finishing

S5JB0A9C01002

Paintable plastic parts are ABS plastic parts.

Painting

Rigid or hand ABS plastic needs no primer coating. General acrylic lacquers can be painted properly over hard ABS plastic in terms of adherence.

- 1) Use cleaning solvent for paint finish to wash each part.
- 2) Apply conventional acrylic color lacquer to part surface.
- 3) Follow lacquer directions for required drying time. (Proper drying temperature range is 60 – 70 °C (140 – 158 °F)).

Reference

Plastic parts employ not only ABS (Acrylonitrile Butadiene Styrene) plastic but also polypropylene, vinyl, or the like plastic. Burning test method to identify ABS plastic is described below.

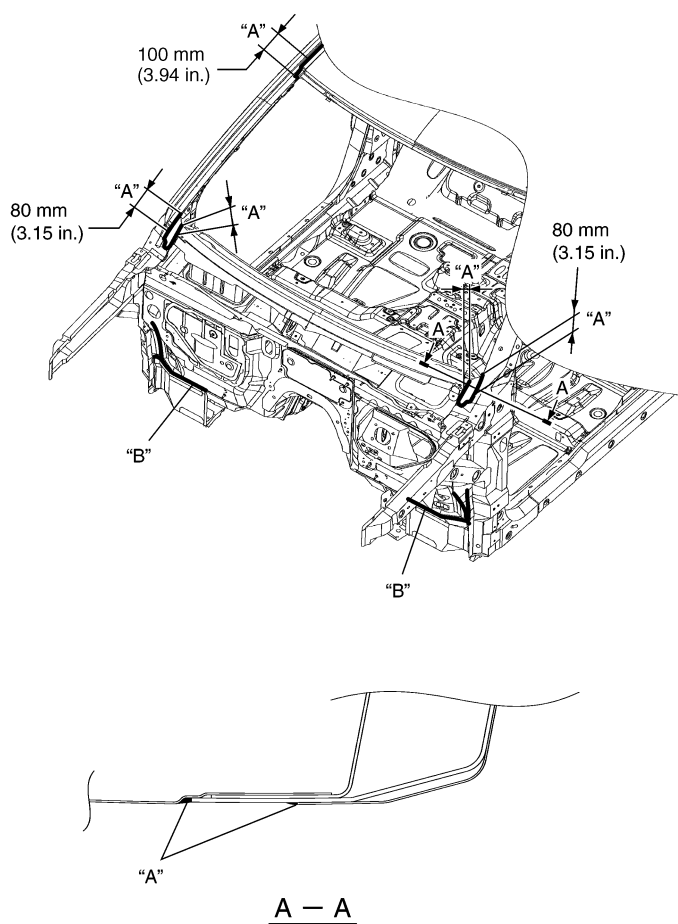
- 1) Use a sharp blade to cut off a plastic sliver from the part at its hidden backside.
- 2) Hold sliver with pincers and set it on fire.
- 3) Carefully observe condition of the burning plastic.
- 4) ABS plastic must raise readily distinguishable back smoke while burning with its residue suspended in air temporarily.
- 5) Polypropylene must raise no readily distinguishable smoke while burning.

Component Location

Sealant Application Areas

S5JB0A9C03001

Front Structure Panel

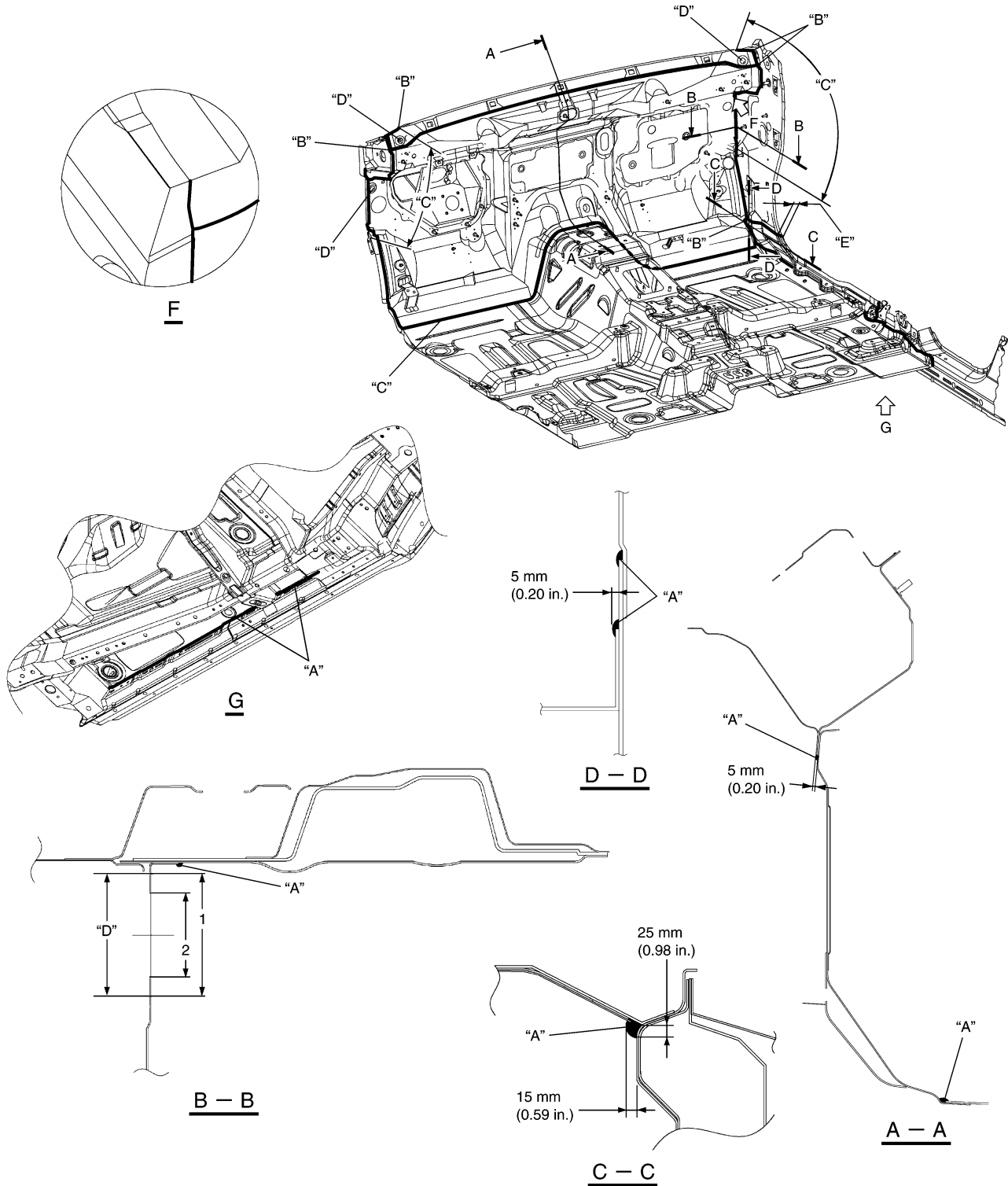


"A": Flatten sealant.	"B": Smooth out sealant with a brush.
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I5JB0A9C0001-03

9L-3 Paint / Coatings:

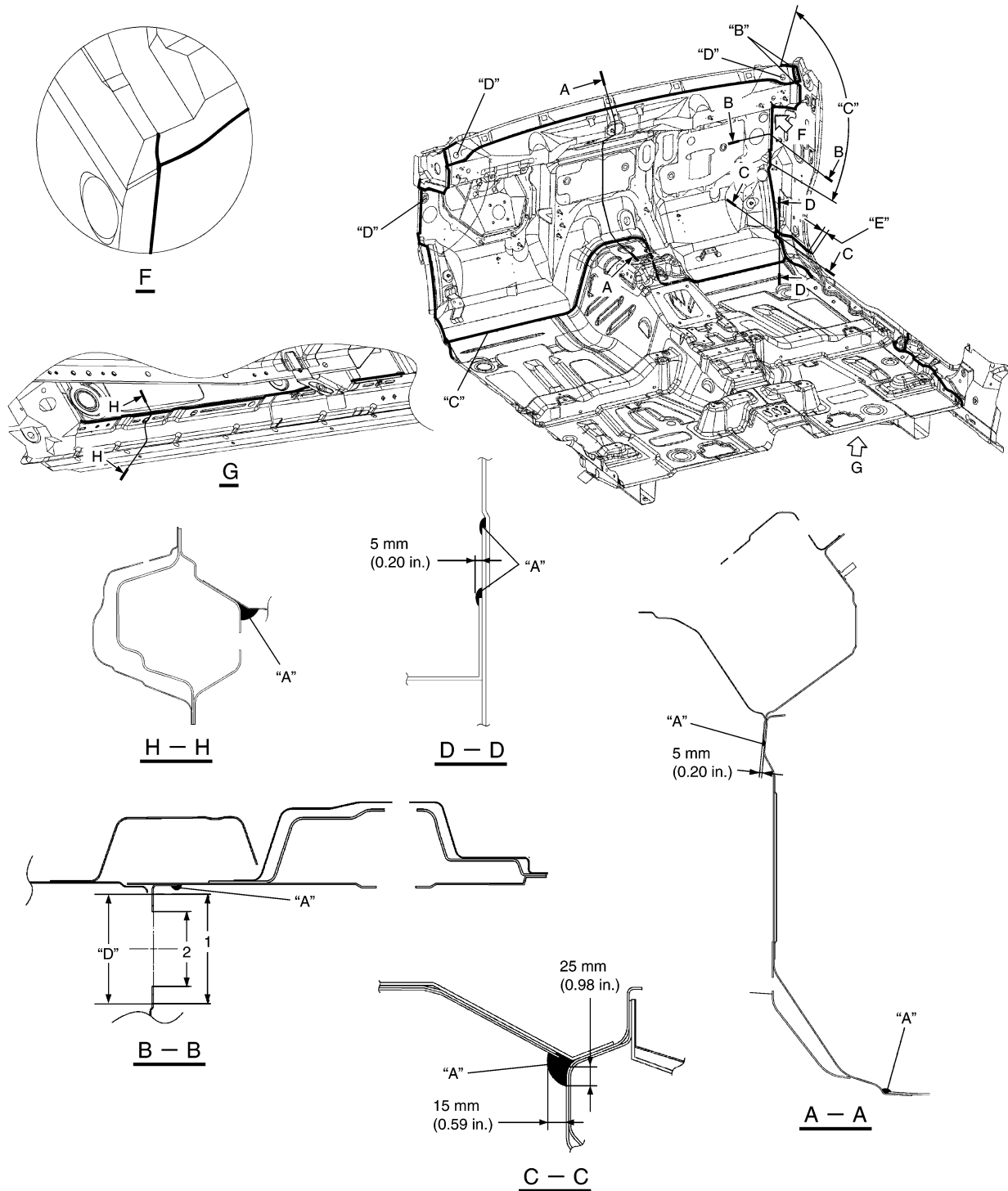
Dash Panel and Front Floor Panel (5 Door Model)



15JB0A9C0002-01

"A": Apply sealant.	"E": Flatten sealant.
"B": Fill gap / hole with sealant.	1. 88 mm (3.46 in.) diameter
"C": Smooth out sealant with a brush.	2. 60 mm (2.36 in.) diameter hole
"D": Do not apply sealant.	

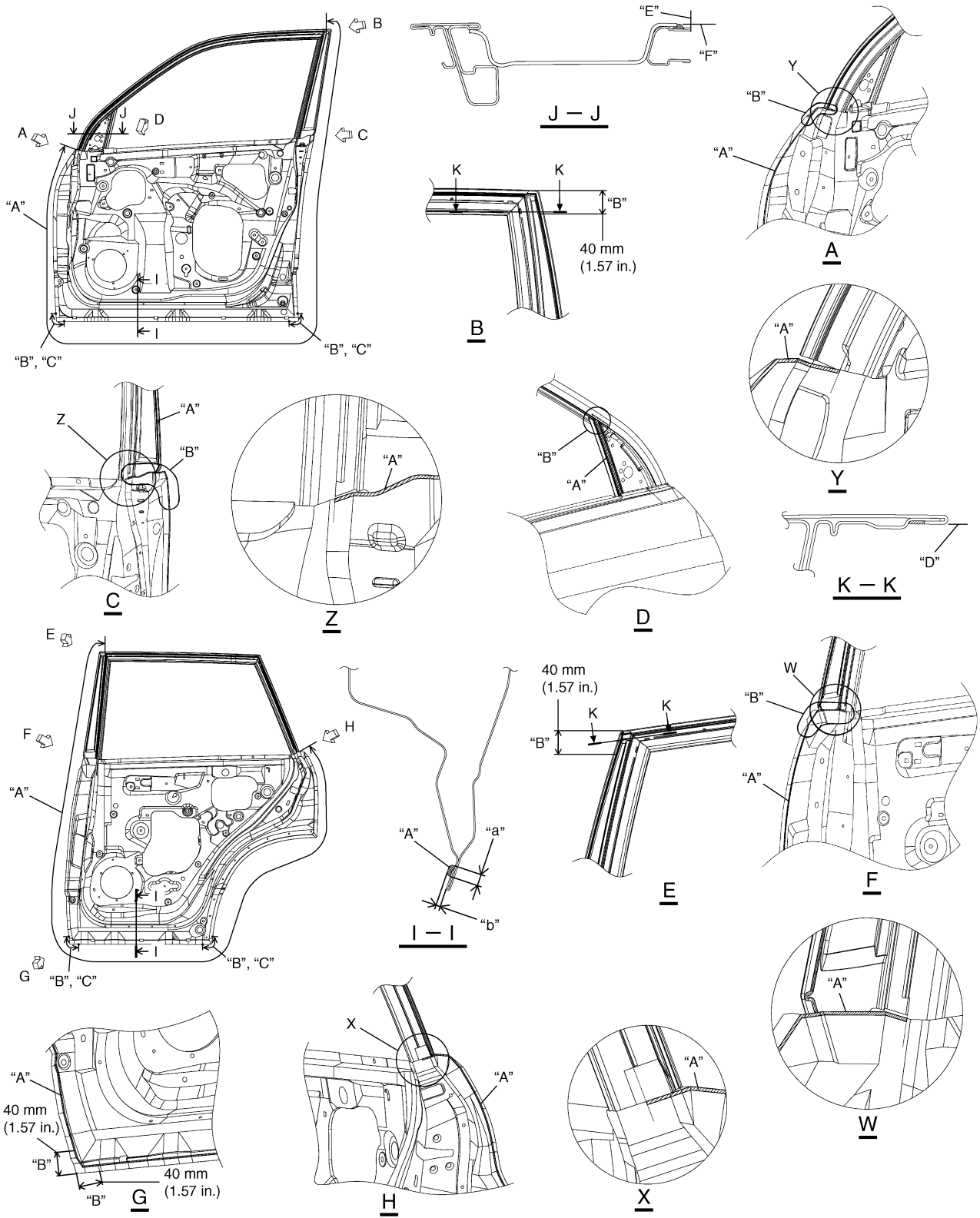
Dash Panel and Front Floor Panel (3 Door Model)



"A": Apply sealant.	"E": Flatten sealant.
"B": Fill gap / hole with sealant.	1. 88 mm (3.46 in.) diameter
"C": Smooth out sealant with a brush.	2. 60 mm (2.36 in.) diameter hole
"D": Do not apply sealant.	

9L-5 Paint / Coatings:

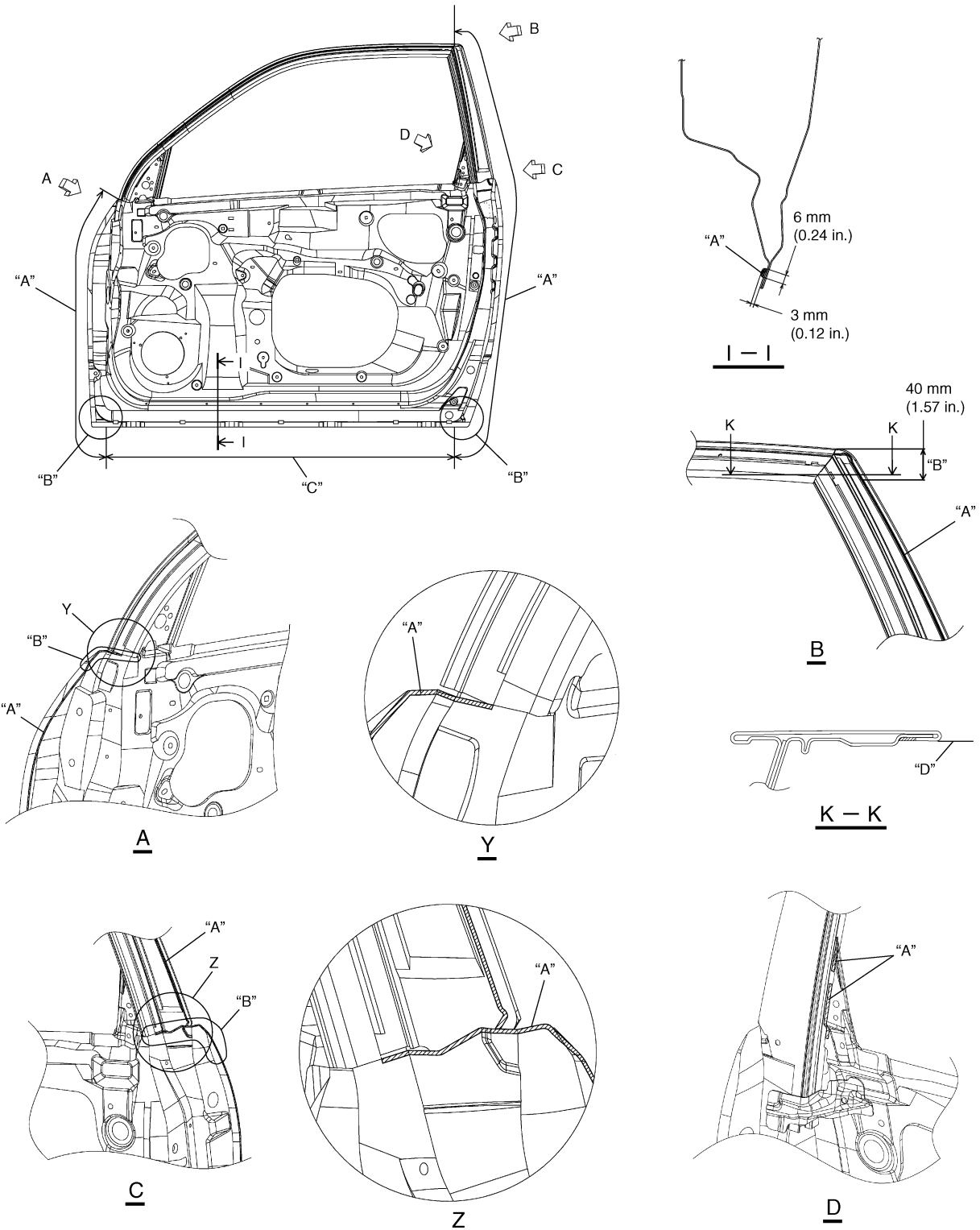
Front and Rear Door Panels (5 Door Model)



15JB0A9C0004-02

"A": Apply sealant.	"D": Wipe off sealant so as not to protrude from this surface.	"a": Min. 6 mm (0.24 in.)
"B": Wipe off excess sealant after application.	"E": Do not protrude sealant backward from this line.	"b": Max. 3 mm (0.12 in.)
"C": Do not fill up drain hole.	"F": Do not protrude sealant outside from this line.	

Front Door Panel (3 Door Model)

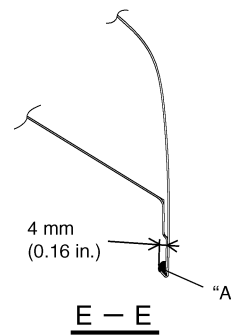
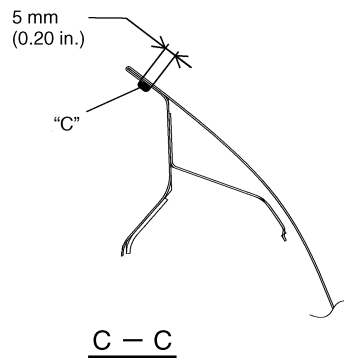
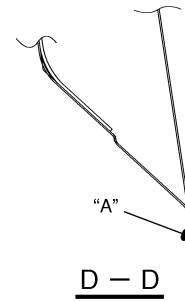
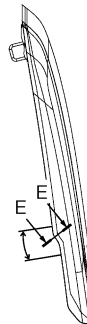
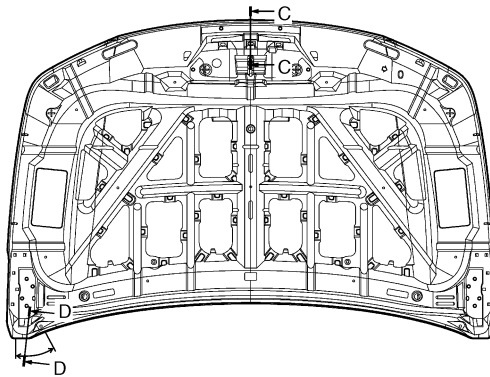
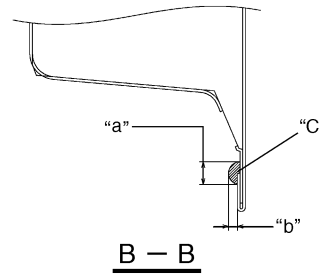
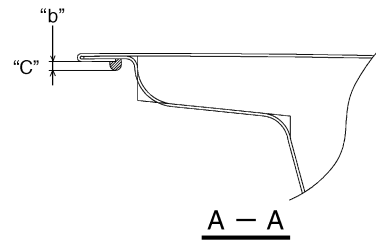
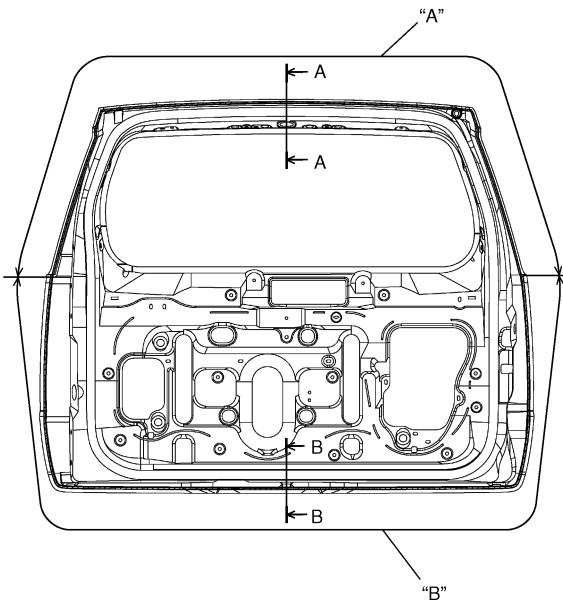


I5JB0A9C0005-01

"A": Apply sealant.	"C": Apply wide sealant.
"B": Wipe off excess sealant after application.	"D": Wipe off sealant so as not to protrude from this surface.

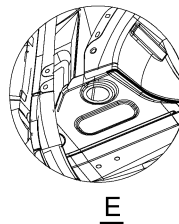
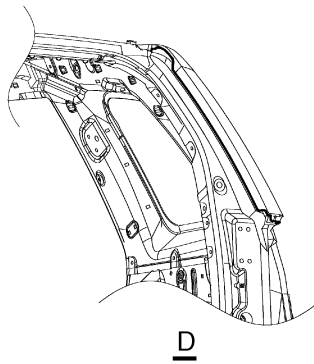
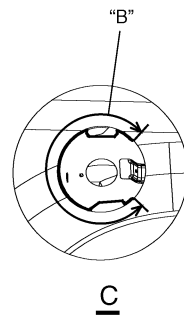
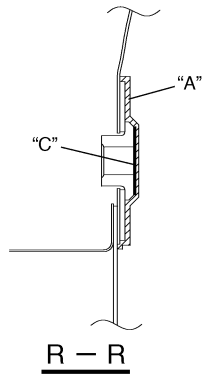
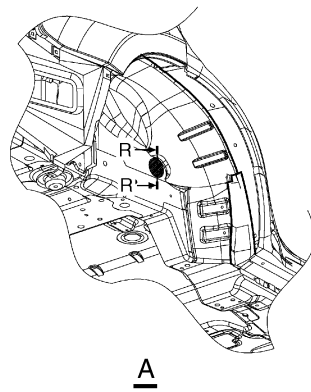
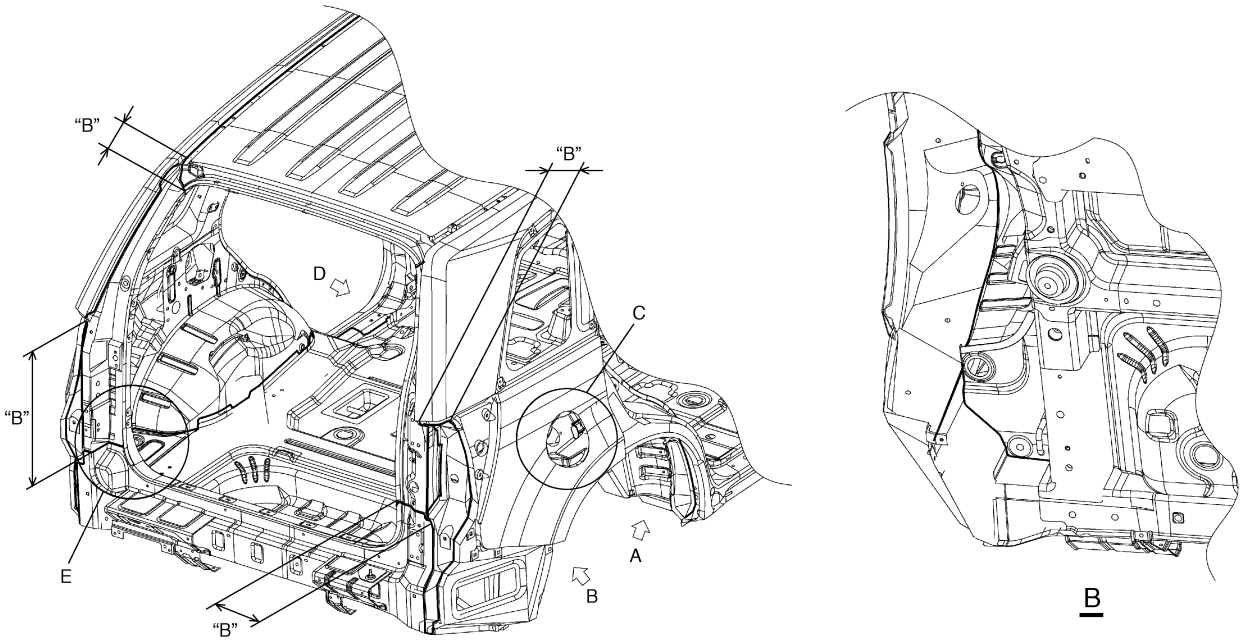
9L-7 Paint / Coatings:

Rear End Door Panel and Hood Panel



"A": Apply sealant.	"a": Min. 6 mm (0.24 in.)
"B": Apply wide sealant.	"b": Max. 3 mm (0.12 in.)
"C": Apply sealant covering flange end.	

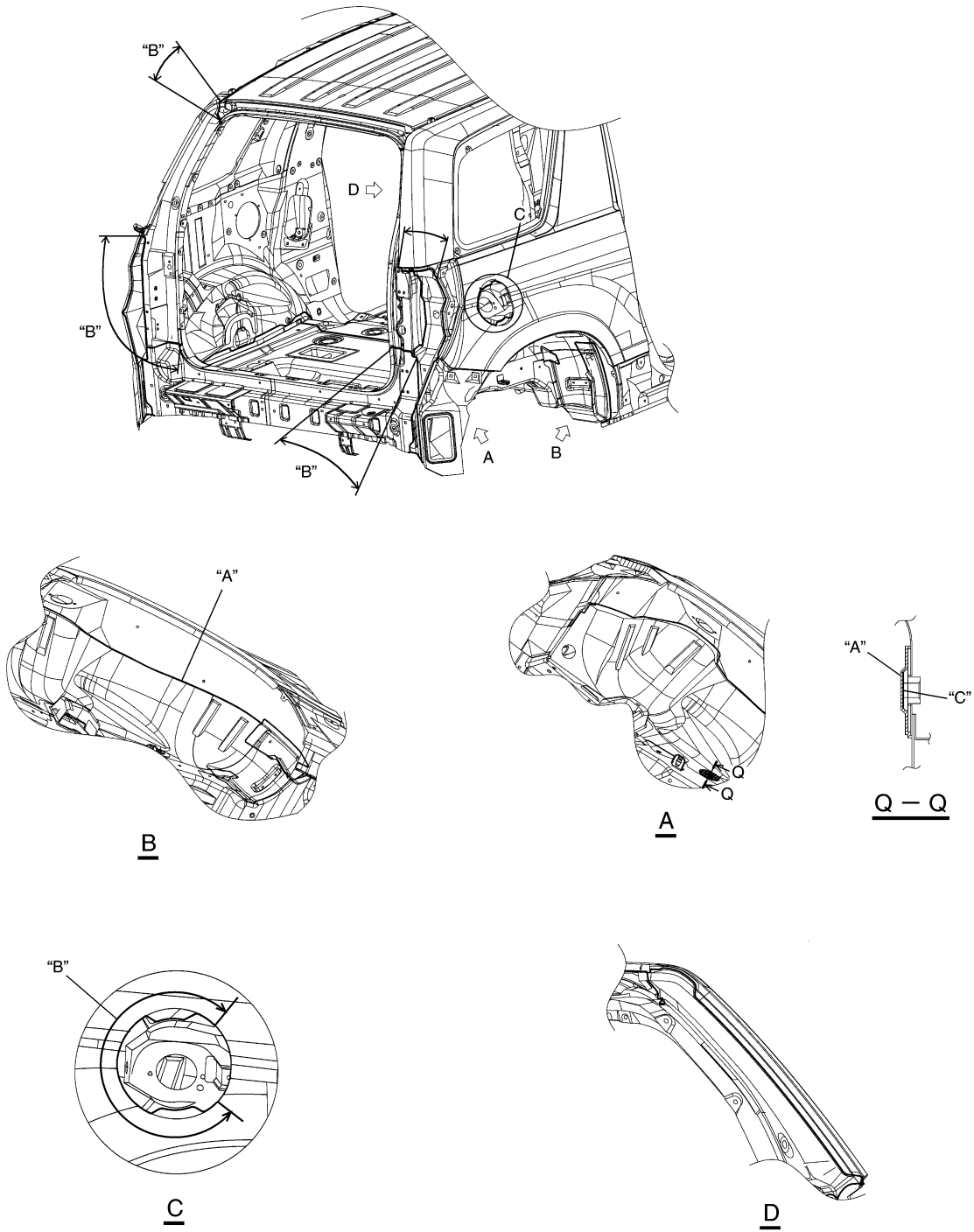
Rear Structure Panel (5 Door Model)



"A": Apply sealant.	"C": Do not apply sealant.
"B": Smooth out sealant with a brush.	

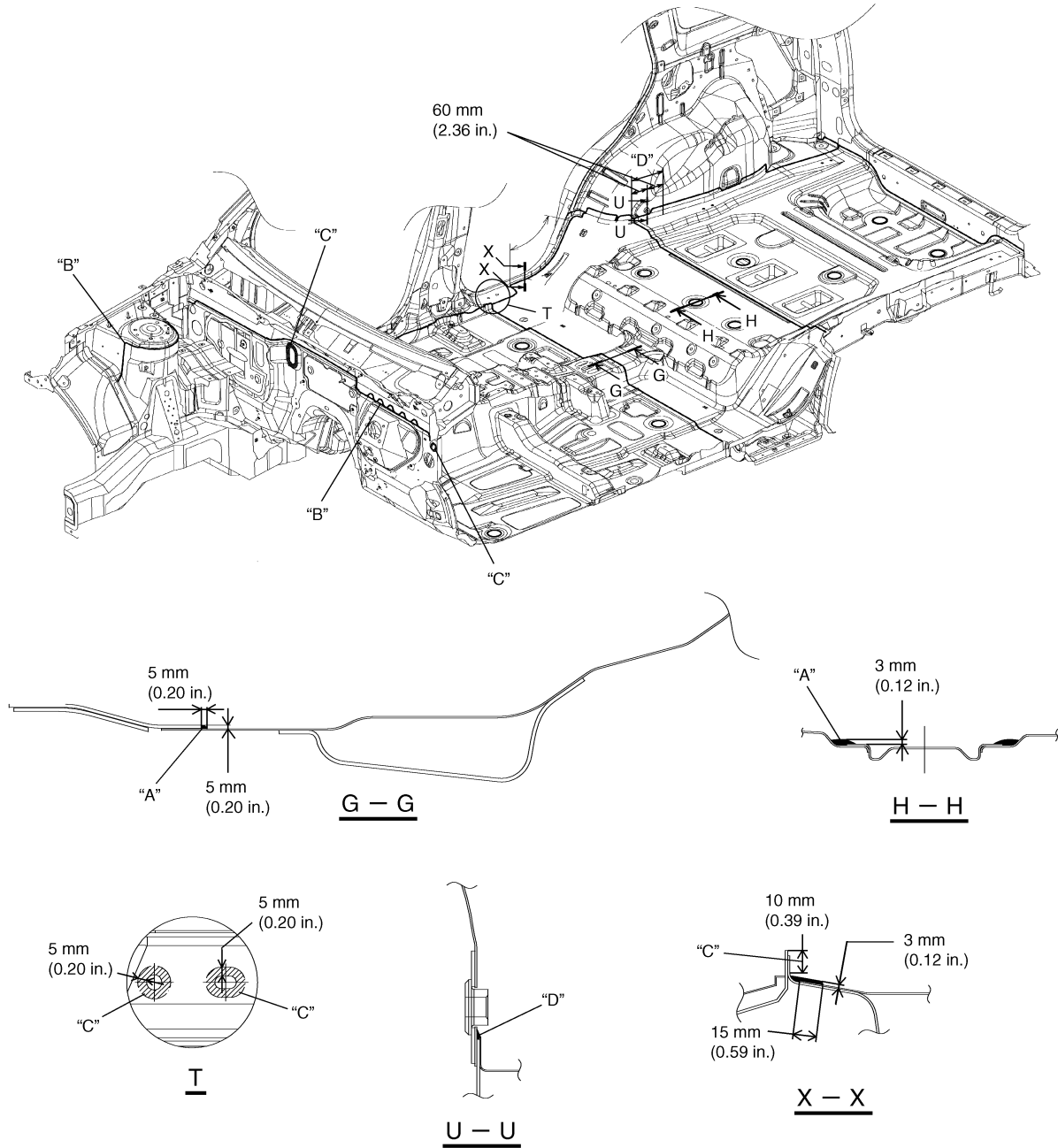
9L-9 Paint / Coatings:

Rear Structure Panel (3 Door Model)



"A": Apply sealant.	"C": Do not apply sealant.
"B": Smooth off sealant with a brush.	

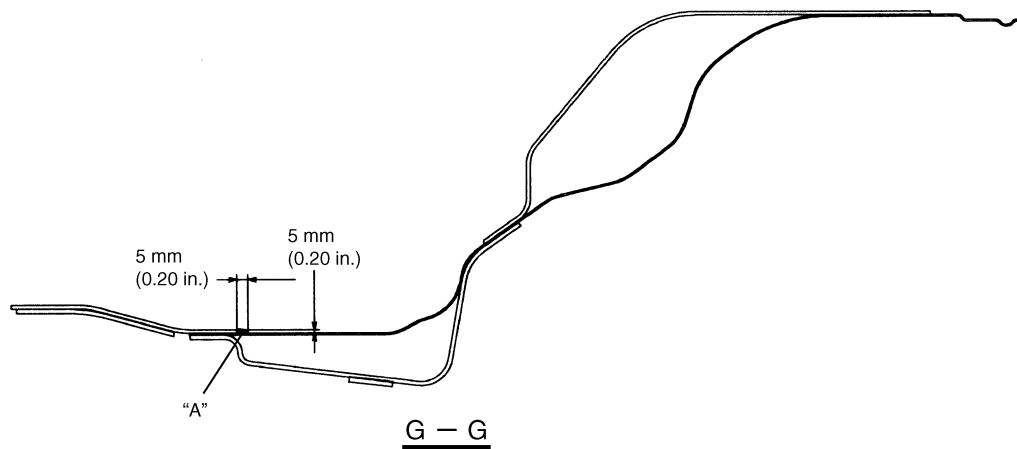
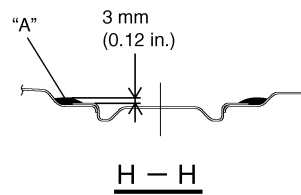
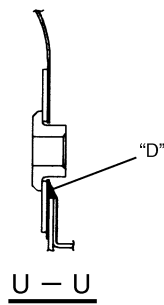
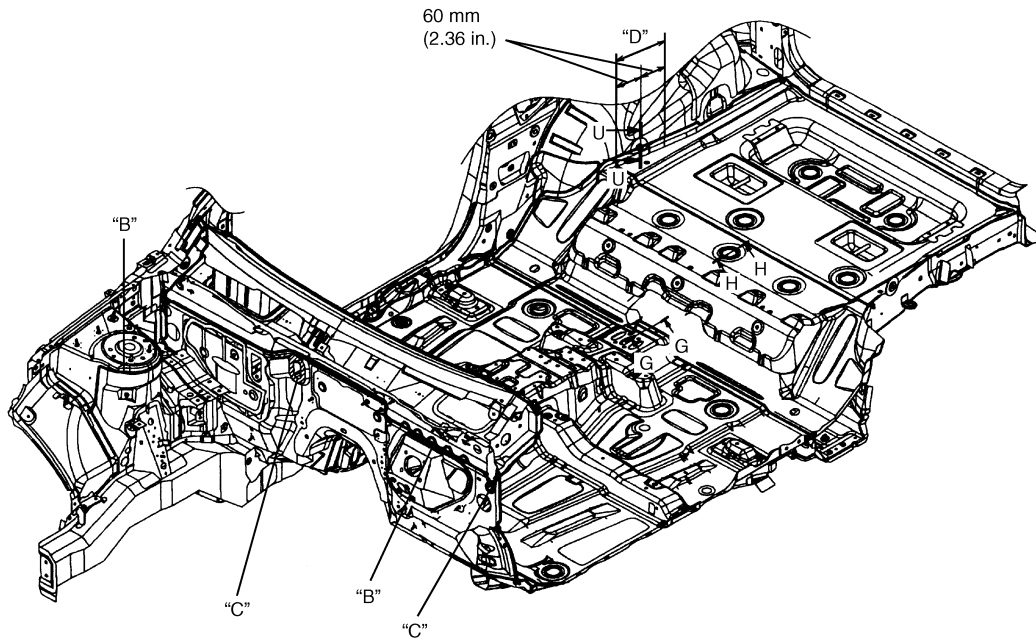
Floor Panel (5 Door Model)



I5JB0A9C0009-01

"A": Apply sealant.	"C": Do not apply sealant.
"B": Smooth off sealant with a brush.	"D": Flatten sealant.

Floor Panel (3 Door Model)

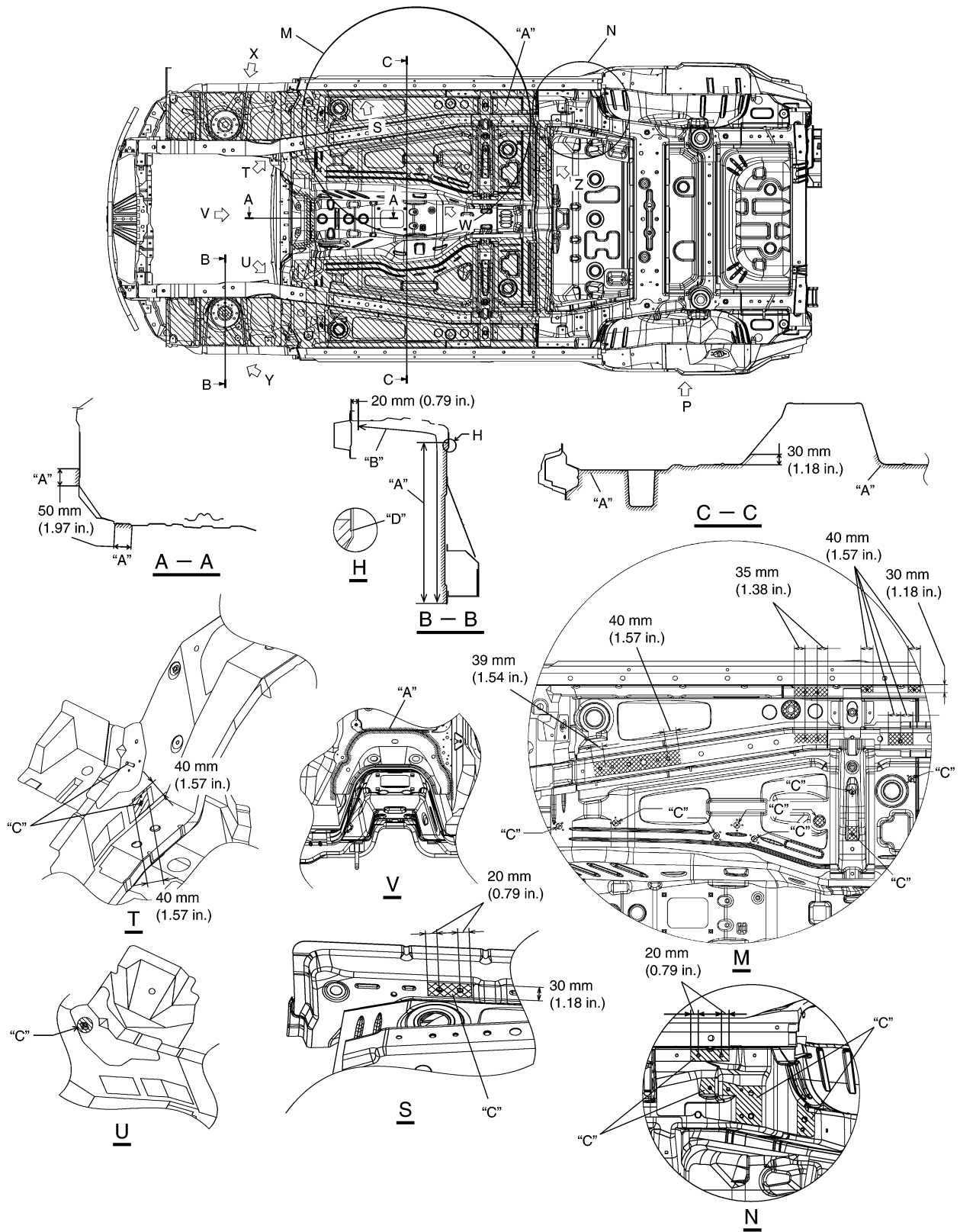


"A": Apply sealant.	"C": Do not apply sealant.
"B": Smooth off sealant with a brush.	"D": Flatten sealant.

Under Coating Application Areas

S5JB0A9C03002

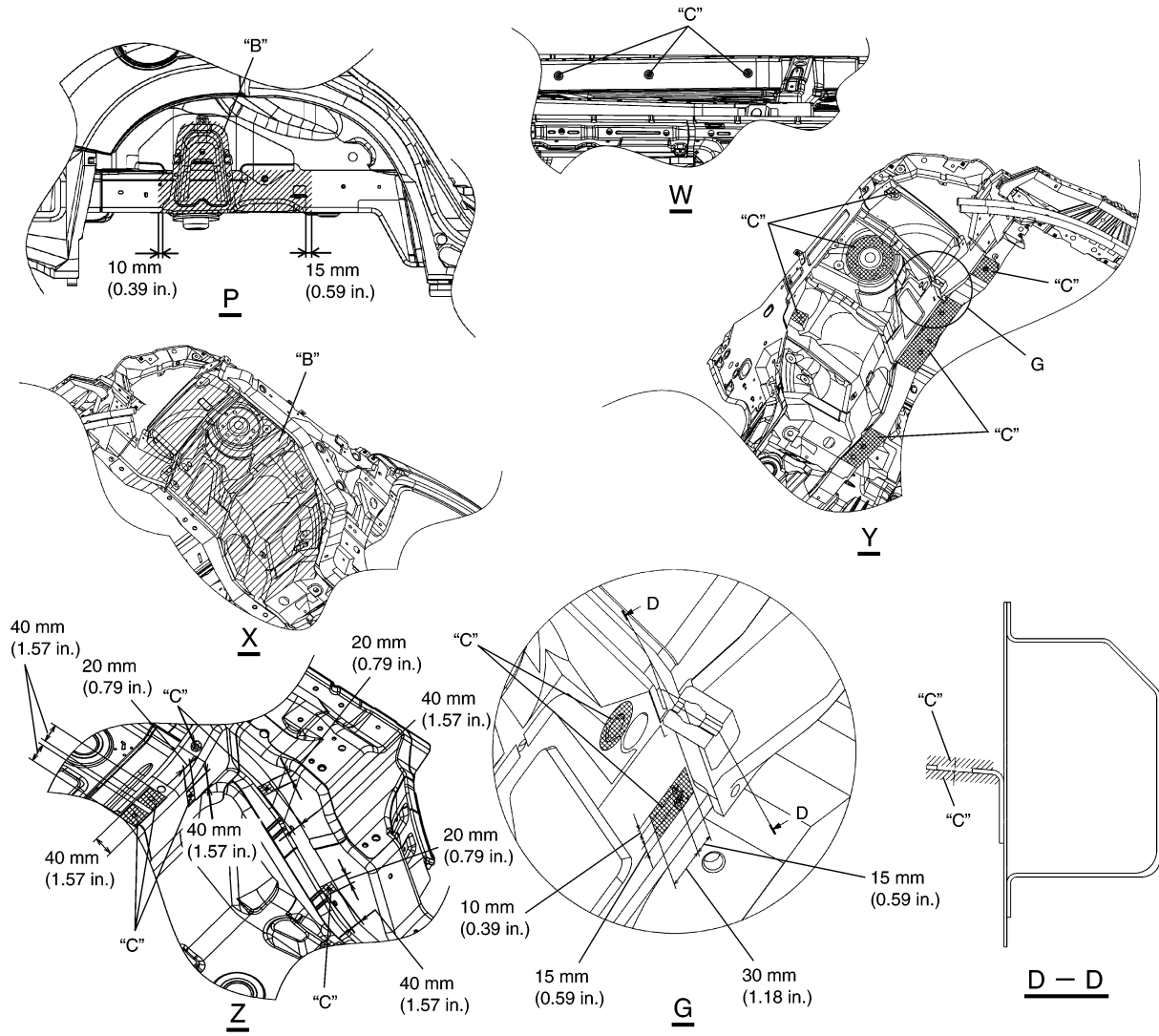
5 Door Model



I5JB0A9C0011-01

<p>"A": Apply undercoating (PVC, 400 µm or more).</p>	<p>"C": Do not apply undercoating.</p>
<p>"B": Apply black painting.</p>	<p>"D": Apply undercoating (PVC, 400 µm or more) covering flange end.</p>

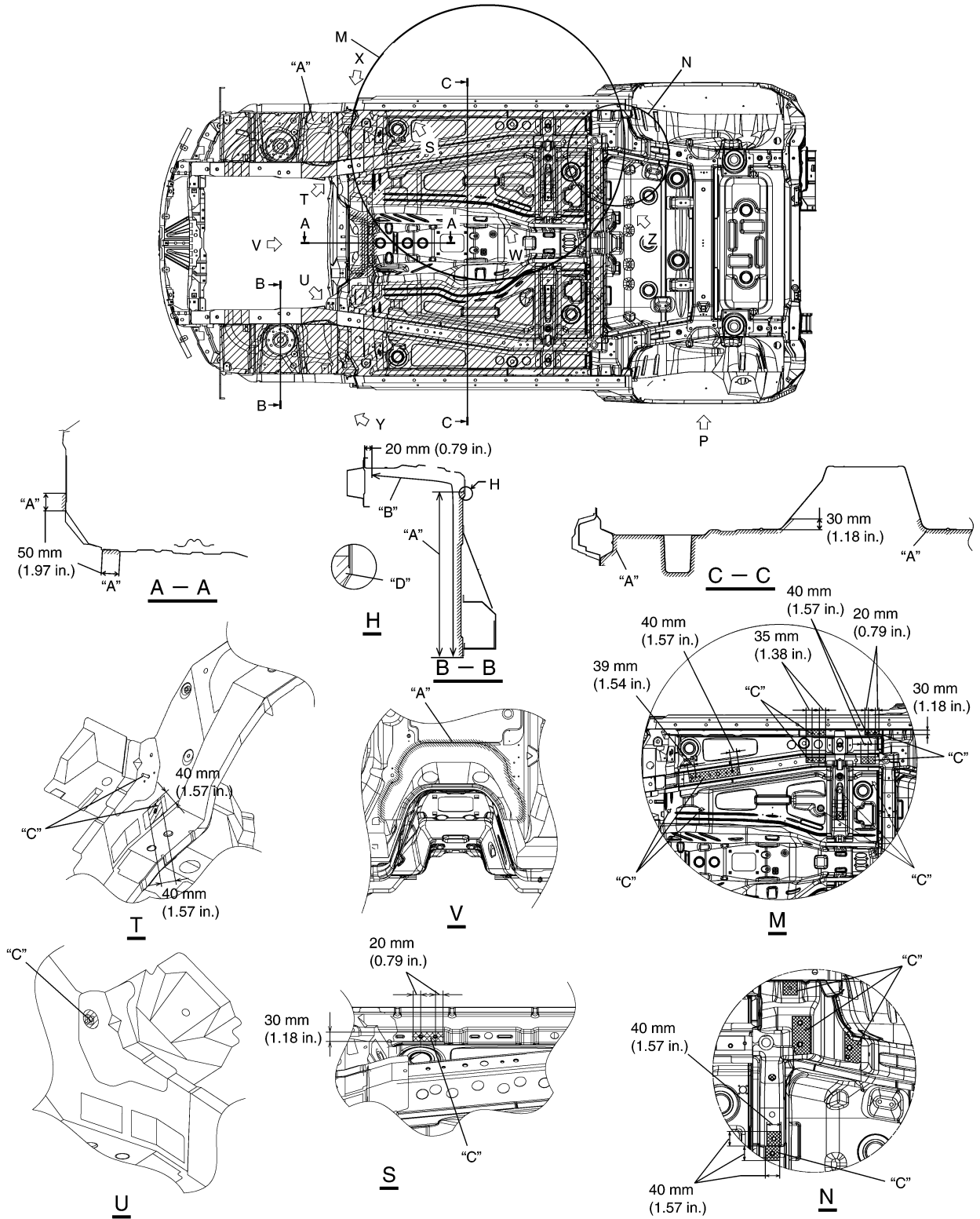
9L-13 Paint / Coatings:



15JB0A9C0012-01

"A": Apply undercoating (PVC, 400 μm or more).	"C": Do not apply undercoating.
"B": Apply black painting.	

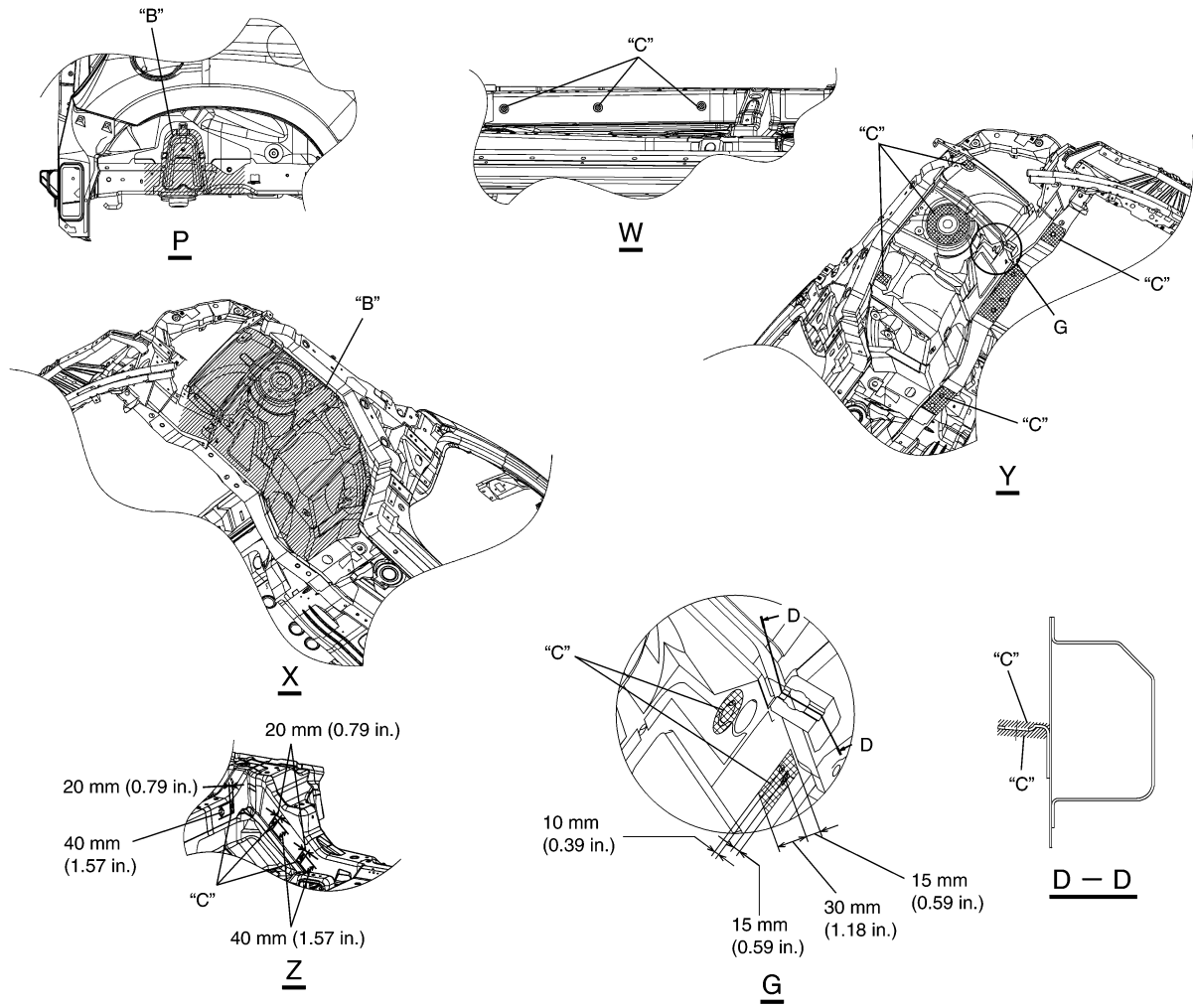
3 Door Model



I5JB0A9C0013-01

"A": Apply undercoating (PVC, 400 µm or more).	"C": Do not apply undercoating.
"B": Apply black painting.	"D": Apply undercoating (PVC, 400 µm or more) covering flange end.

9L-15 Paint / Coatings:



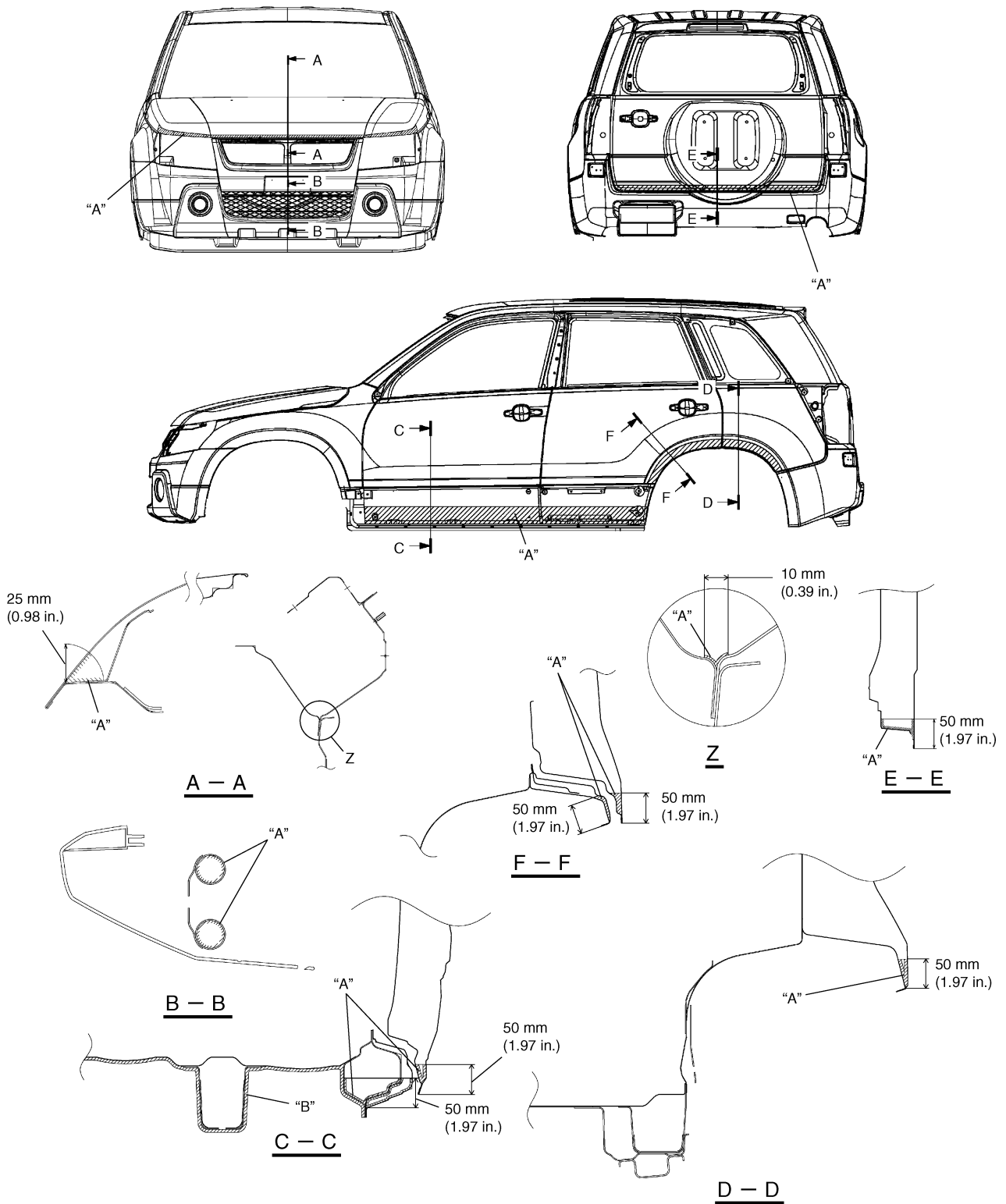
15JB0A9C0014-01

"A": Apply undercoating (PVC, 400 μ m or more).	"C": Do not apply undercoating.
"B": Apply black painting.	

Anti-Corrosion Compound Application Area

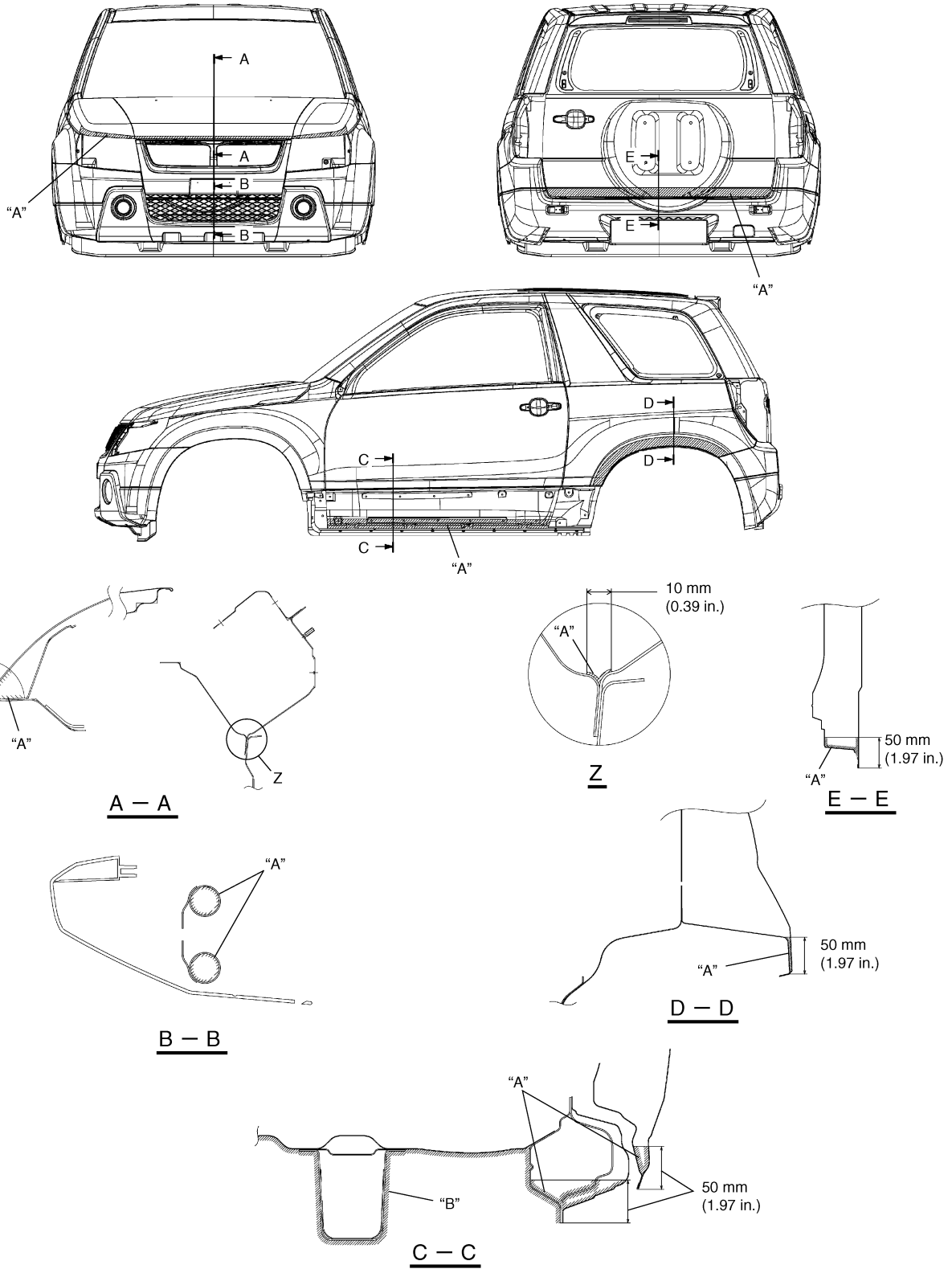
S5JB0A9C03003

5 Door Model



"A": Apply rust proof wax (hot wax 50 µm or more).
"B": Apply rust proof wax (high viscosity wax 50 µm or more).

3 Door Model



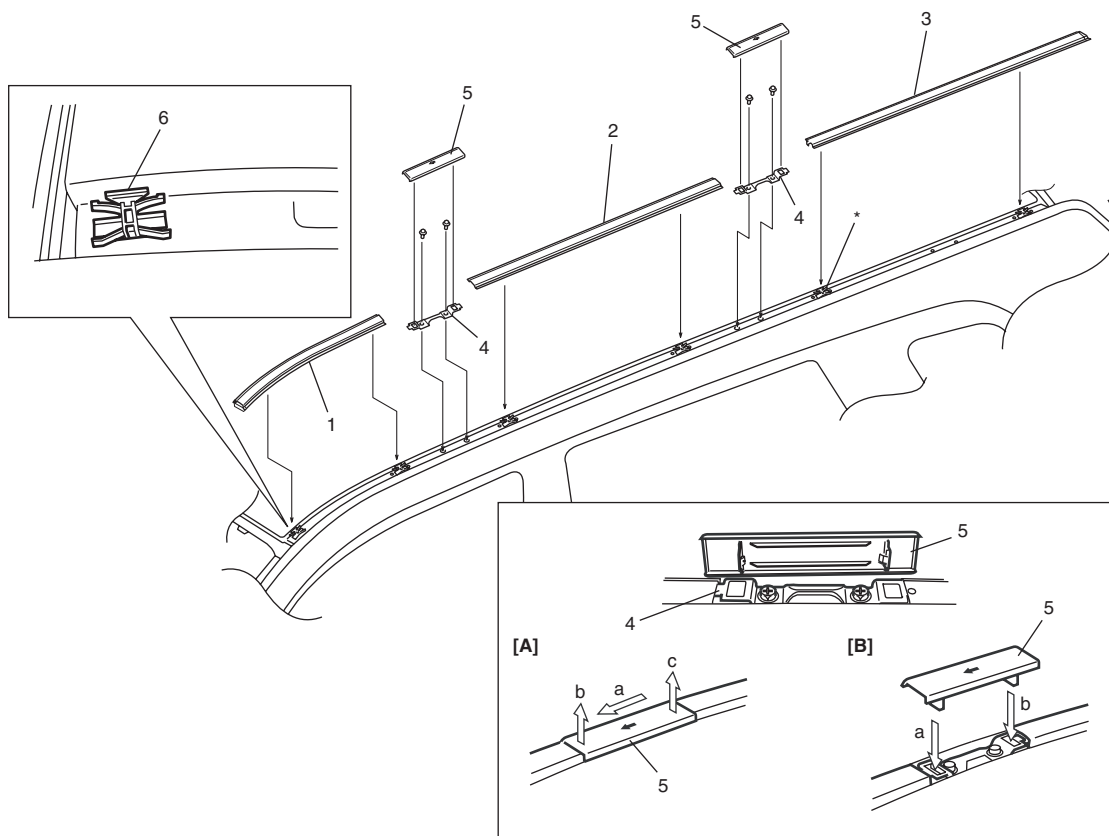
"A": Apply rust proof wax (hot wax 50 µm or more).
"B": Apply rust proof wax (high viscosity wax 50 µm or more).

Exterior Trim

Repair Instructions

Roof Drip Molding Removal and Installation (If Equipped)

S5JB0A9D06005

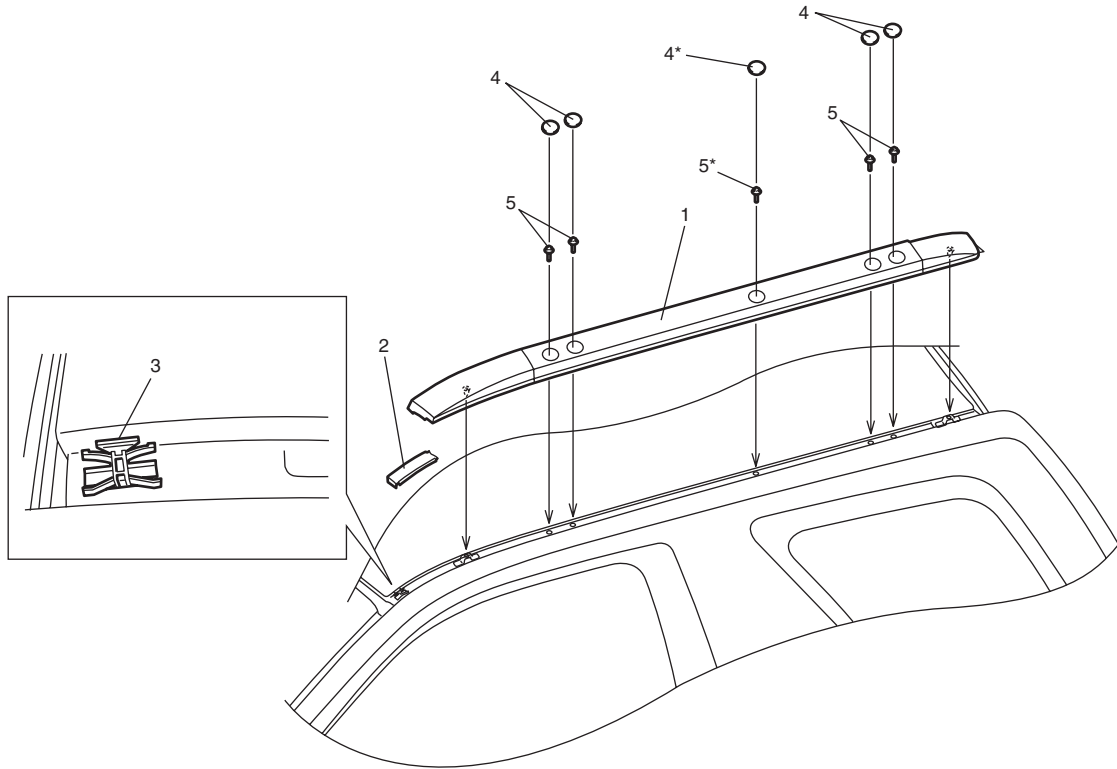


I5JB0A9D0001-02

<p>[A]: Molding Cap Removal Remove cap by pushing in arrow direction shown on cap and then pulling in alphabetical order indicated in figure.</p>	<p>4. Roof carrier bracket</p>
<p>[B]: Molding Cap Installation Be sure to direct arrow mark of left side molding cap to vehicle forward and arrow mark of right side molding cap to vehicle rearward.</p>	<p>5. Roof drip molding cap</p>
<p>1. Roof drip front molding</p>	<p>6. Roof drip molding clip (Push-in type)</p>
<p>2. Roof drip center molding</p>	<p>*: 5 door model only</p>
<p>3. Roof drip rear molding</p>	

Roof Rail Removal and Installation (If Equipped)

S5JB0A9D06007

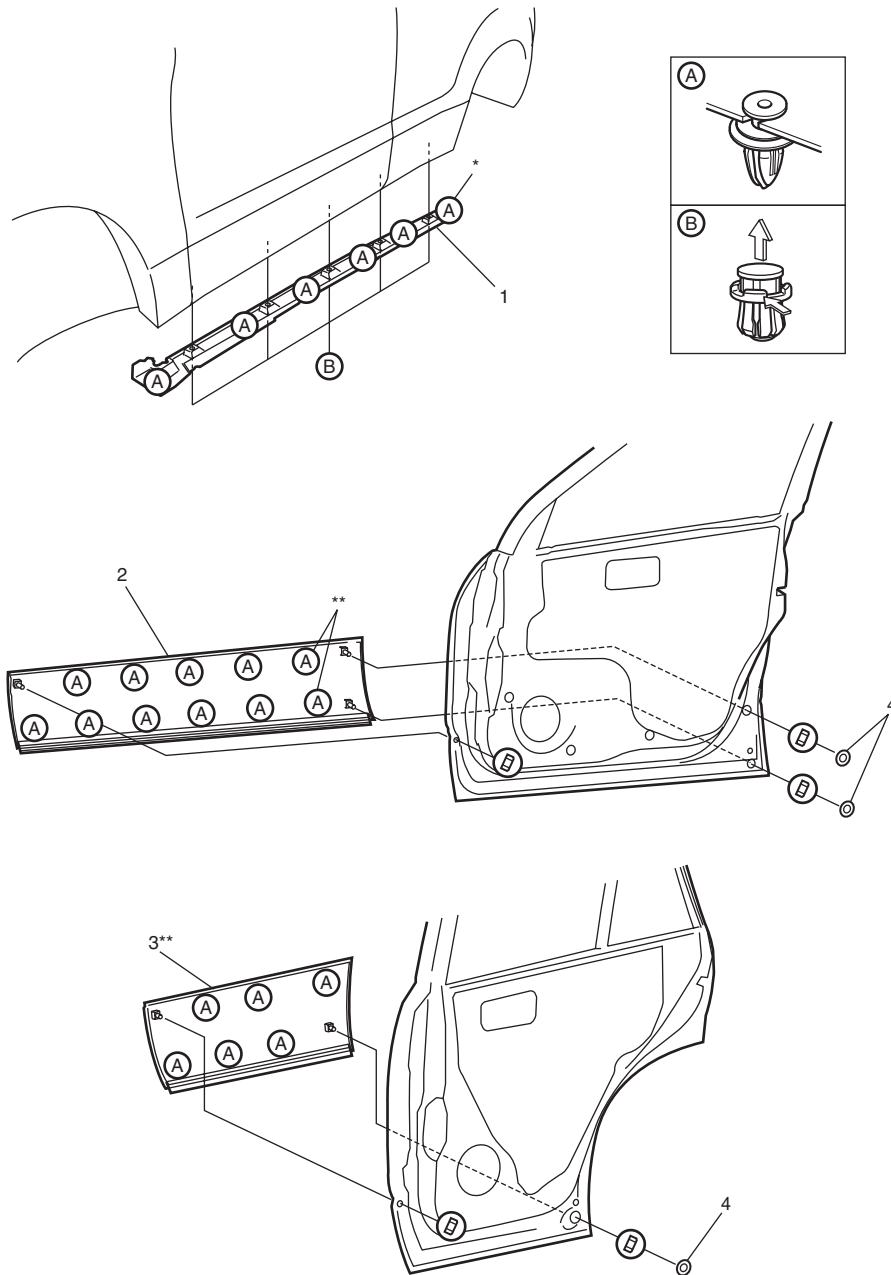


15JB0A9D0002-03

1. Roof rail	3. Roof drip molding clip (Push-in type)	5. Roof rail bolt
2. Roof drip front molding	4. Roof rail cap	*: 5 door model only

Splash Guard Removal and Installation (If Equipped)

S5JB0A9D06006



15JB0A9D0003-02

1. Side sill splash guard	3. Rear door splash guard	*: 3 door model only
2. Front door splash guard	4. Cap	** : 5 door model only