

BODY REPAIR MANUAL

BS

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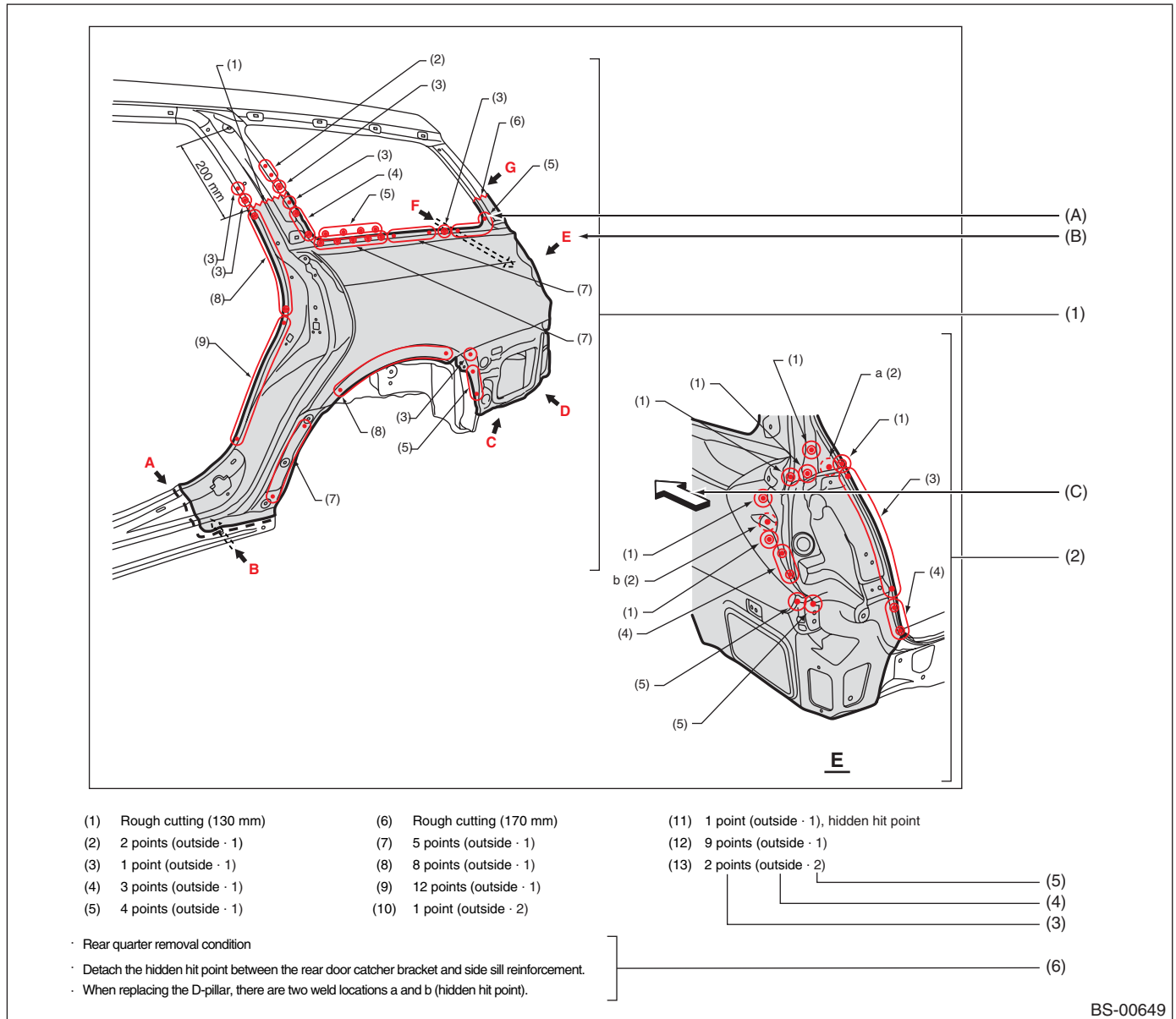
1. Foreword

A: USE OF THIS MANUAL

This manual explains important points for removal and installation of parts per location.

1. ILLUSTRATION EXAMPLE

- Symbols and number of points indicate the welding method and the number of welding points. Text in brackets indicate the direction of removal for welded parts, and numbers indicate the number of panels to be drilled to remove welded sections of panels.
- Areas enclosed by a broken line indicates work from the opposite side (rear side).
- Always apply anticorrosion wax to the welding locations when replacing panels.



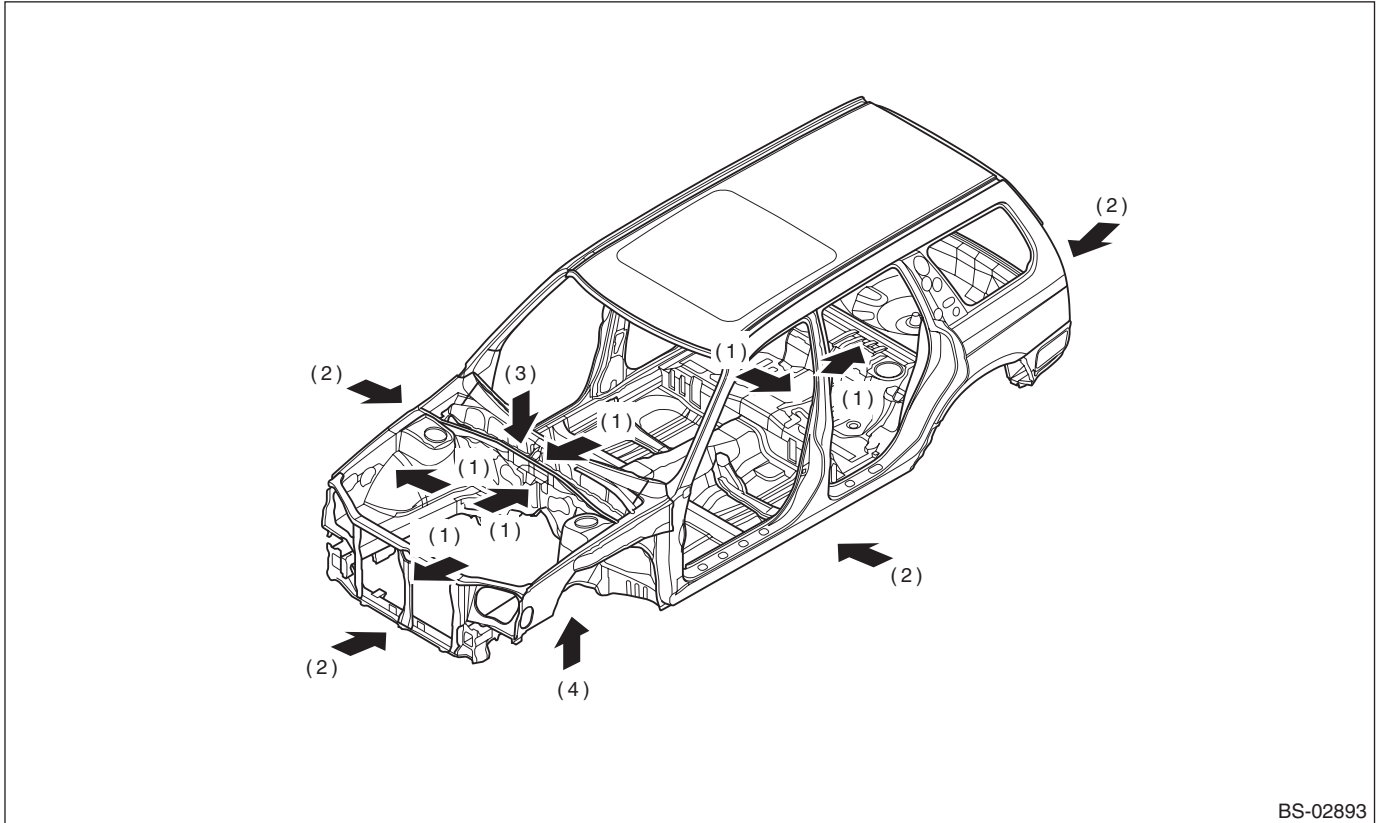
- (1) Overall view
- (2) Views
- (3) Number of welding points etc.
- (4) Removal direction
- (5) Number of panels to be drilled

- (6) Cautions when working, etc.
- (A) Welding method
- (B) View direction
- (C) Towards front of vehicle

Foreword

2. REMOVAL DIRECTION

Areas are divided into four groups of inside, outside, top, and bottom, and these directions are defined as shown in the following figure.



BS-02893

(1) Inward
(2) Outward

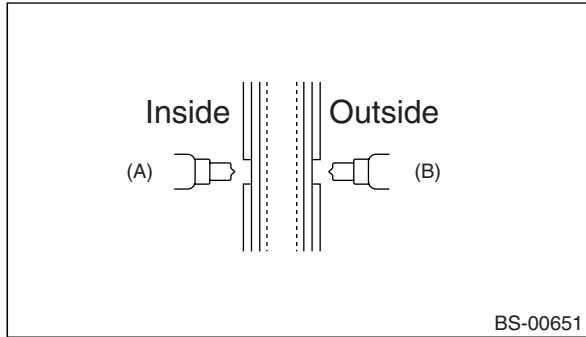
(3) Upward

(4) Downward

3. NUMBER OF PANELS TO BE DRILLED

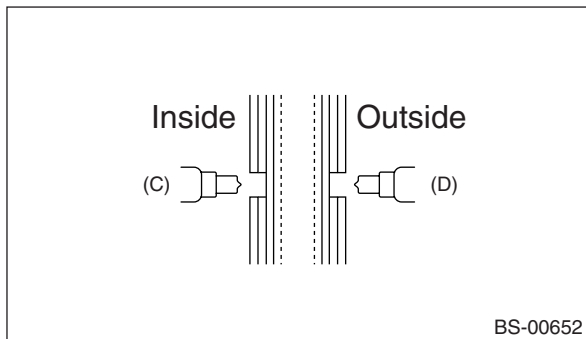
Depending on the number of panels, drilling is performed through one or two panels, and this is listed together with the removal direction.

(1) Drilling through one plate



- (A) (Inside · 1)
- (B) (Outside · 1)

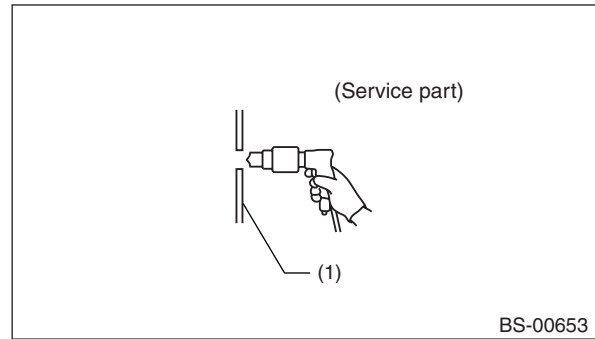
(2) Drilling through two plate



- (C) (Inside · 2)
- (D) (Outside · 2)

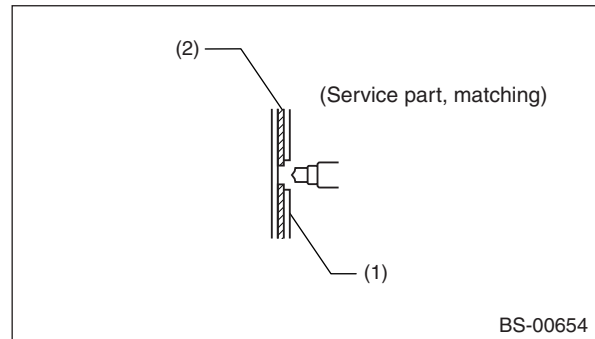
4. HOLE DRILLING FOR PLUG WELDING

(1) Drilling of holes for plug welding in service parts



- (1) Service part

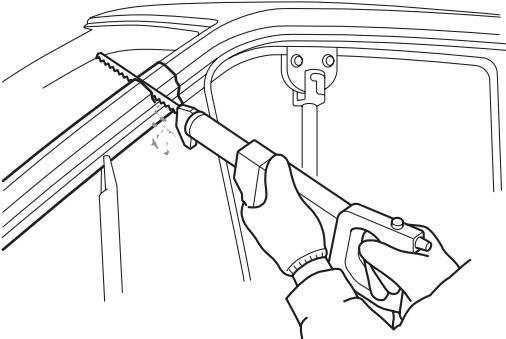
(2) Drilling of holes on service parts for plug welding, to match the holes on the vehicle side



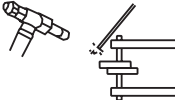
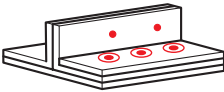
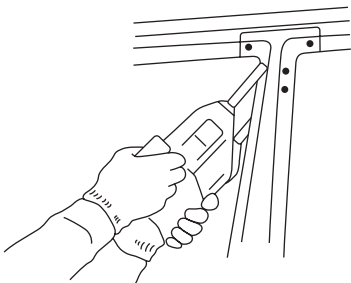
- (1) Service part
- (2) Vehicle side

5. MEANING OF SYMBOLS

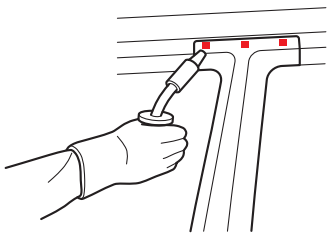
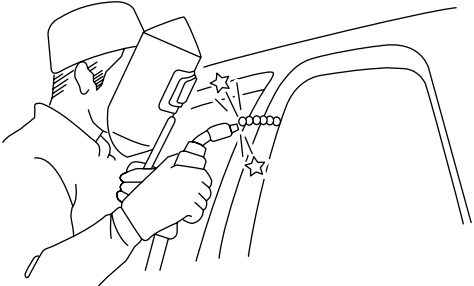
• Cutting

 BS-00352	 BS-00267
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• Spot welding

Two overlapping parts	 BS-00655	 BS-00656	 BS-00657	 BS-00658
Three overlapping parts	 BS-00659	 BS-00660		

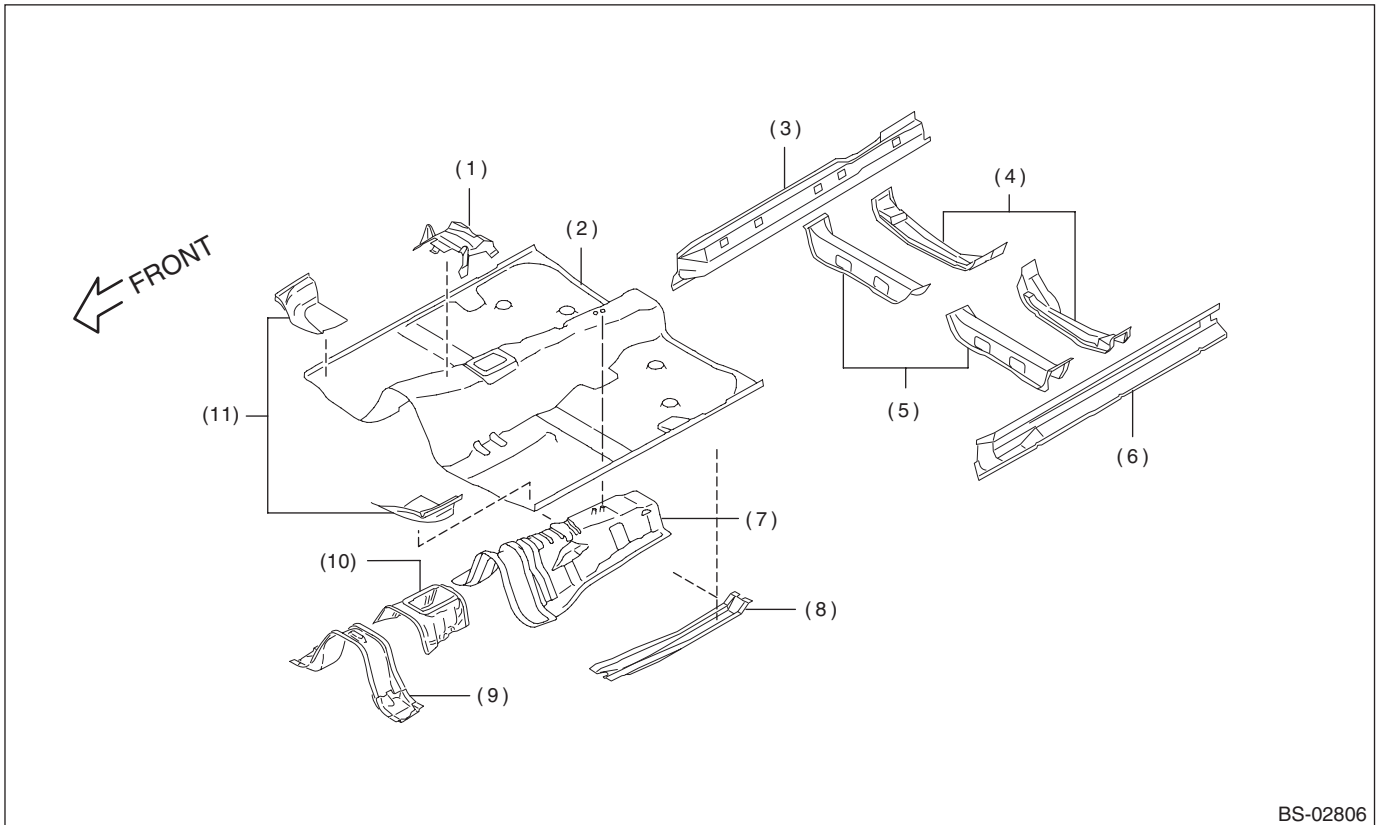
• Carbon dioxide gas arc welding (MIG welding)

Plug welding	 BS-00661	 BS-00662	 BS-00663
Continuous welding	 BS-00664	 BS-00665	 BS-00666

2. Panel Components

A: COMPONENTS

1. FLOOR PANEL

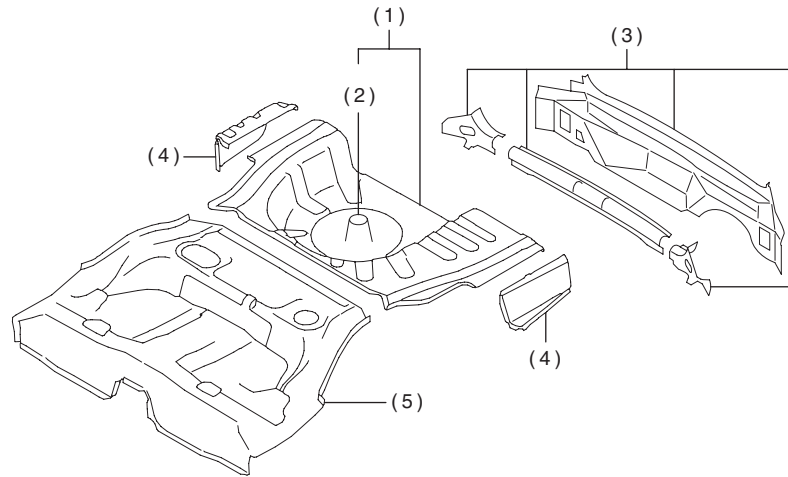


BS-02806

- | | | |
|------------------------------|------------------------------|------------------------------------|
| (1) Instrument panel bracket | (5) Crossmember front seat | (9) Crossmember bracket |
| (2) Front floor pan | (6) Side sill inner front | (10) Front floor reinforcement |
| (3) Side sill inner front | (7) Hand brake reinforcement | (11) Toe board upper reinforcement |
| (4) Seat crossmember doubler | (8) Side frame rear | |

Panel Components

2. FLOOR PANEL & REAR SKIRT



BS-02807

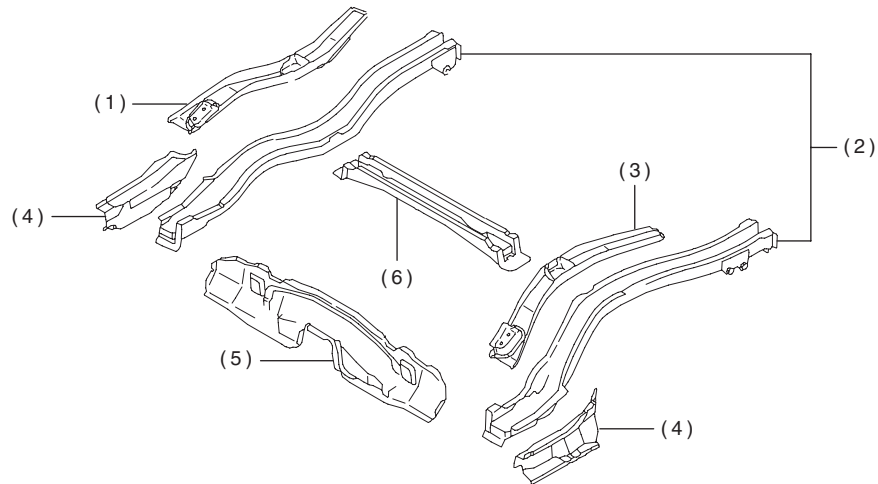
(1) Rear floor pan rear
(2) Spare tire bracket

(3) Rear skirt
(4) Rear floor side

(5) NS (Rear floor pan front)

Panel Components

3. REAR FLOOR SIDE FRAME

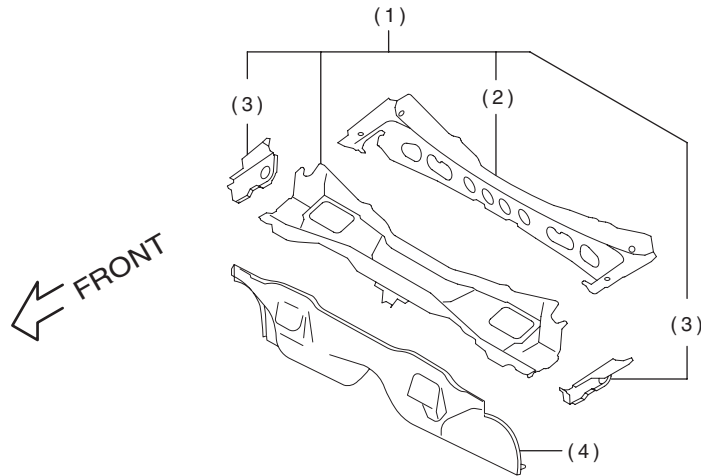


BS-02808

- | | | |
|---|---|------------------------|
| (1) Reinforcement rear floor side frame | (3) Reinforcement rear floor side frame | (5) NS (Crossmember A) |
| (2) Rear floor side frame | (4) Side sill inner rear | (6) Crossmember B |

Panel Components

4. TOE BOARD & FRONT PANEL



BS-02809

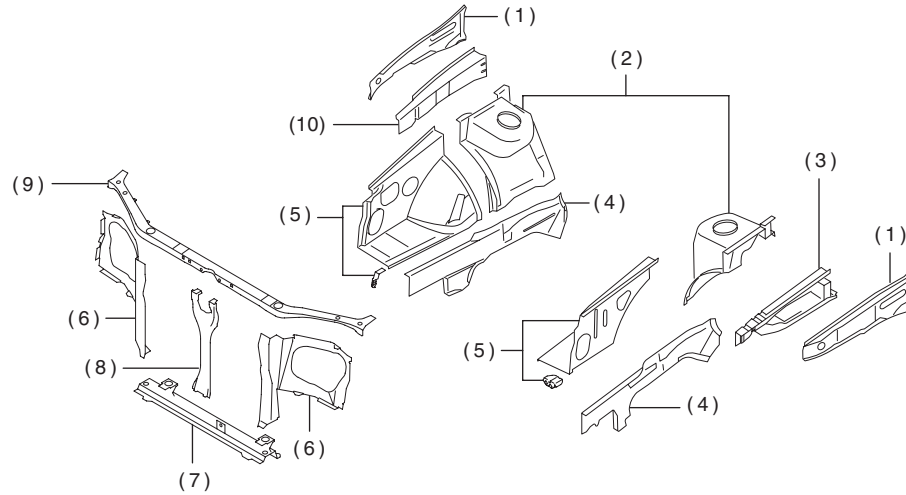
- (1) Duct
- (2) Front panel

- (3) Front bulkhead frame

- (4) Toe board

Panel Components

5. RADIATOR PANEL & FRONT WHEEL APRON

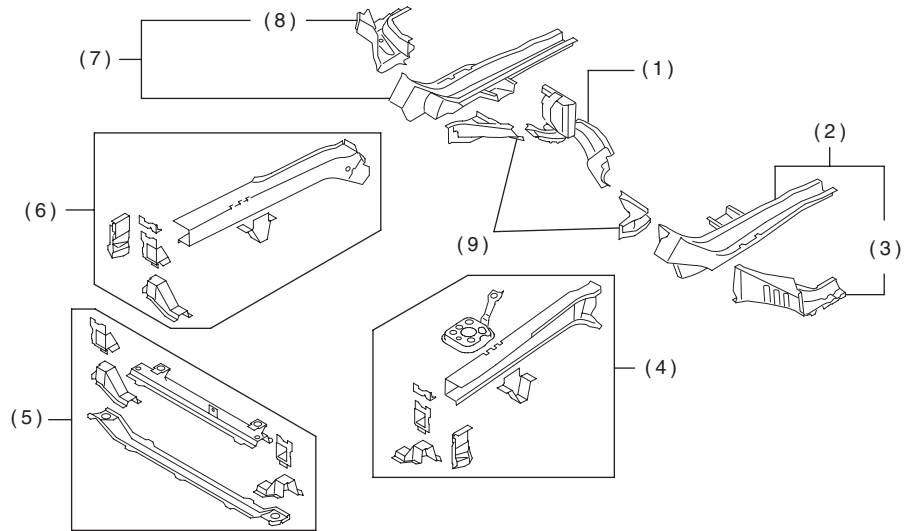


BS-02810

- | | | |
|------------------------------|----------------------------|------------------------------|
| (1) Side upper frame | (5) Front wheel apron | (8) Hood lock stay |
| (2) Front suspension bracket | (6) Radiator side panel | (9) Radiator upper frame |
| (3) Front wheel apron upper | (7) Radiator lower frame A | (10) Front wheel apron upper |
| (4) Closing plate | | |

Panel Components

6. FRONT SIDE FRAME

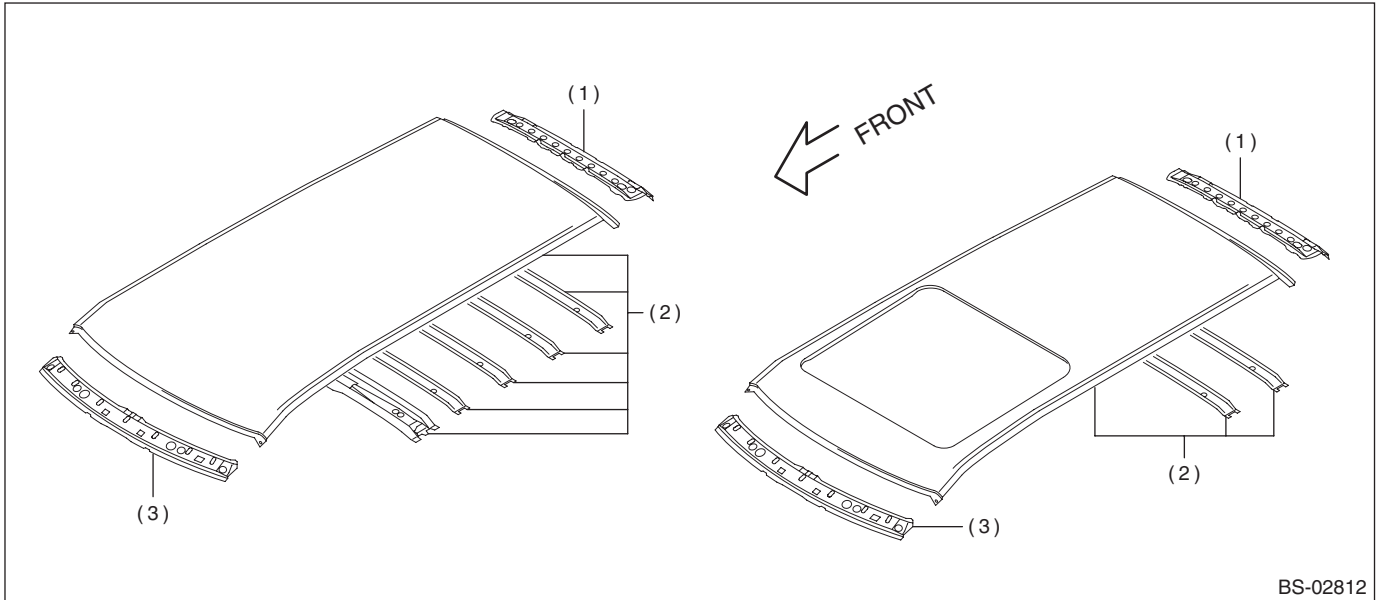


BS-02811

- | | | |
|-----------------------------------|-----------------------------------|-----------------------------------|
| (1) Pitching stopper bracket | (4) Front side frame front | (7) Front side frame rear |
| (2) Front side frame rear | (5) Radiator lower frame complete | (8) Toe board lower reinforcement |
| (3) Toe board lower reinforcement | (6) Front side frame front | (9) Toe board front frame |

Panel Components

7. ROOF



(1) Rear roof rail

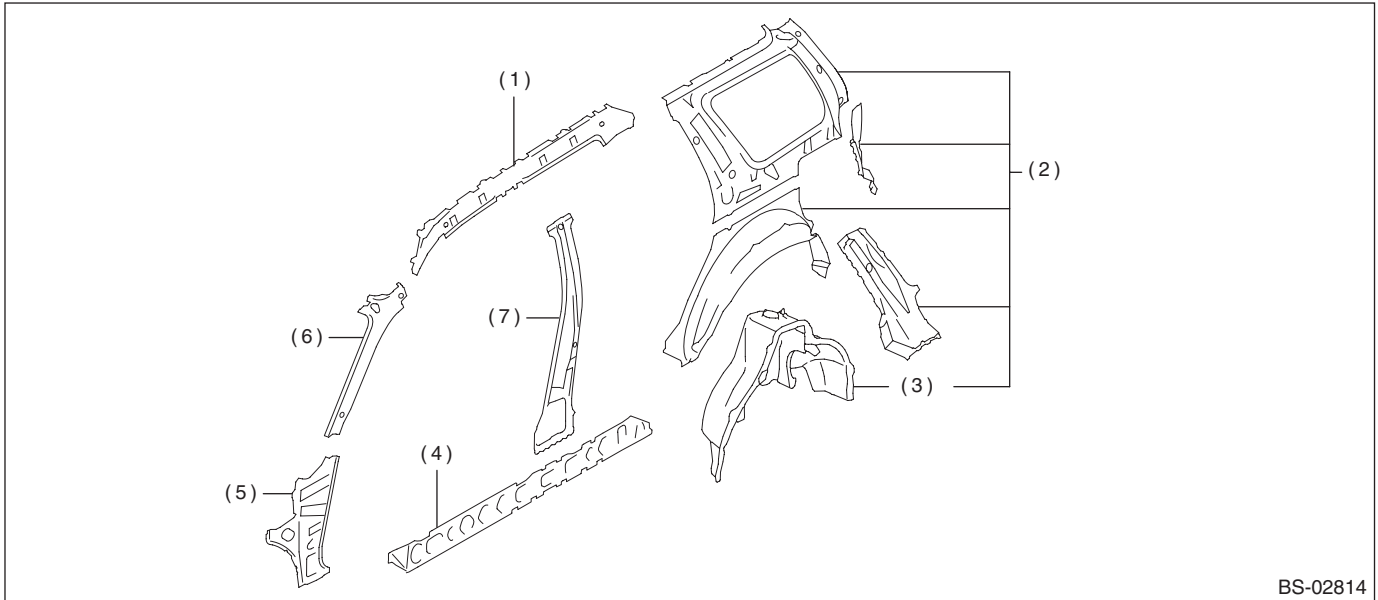
(2) Roof panel

(3) Front roof rail

Panel Components

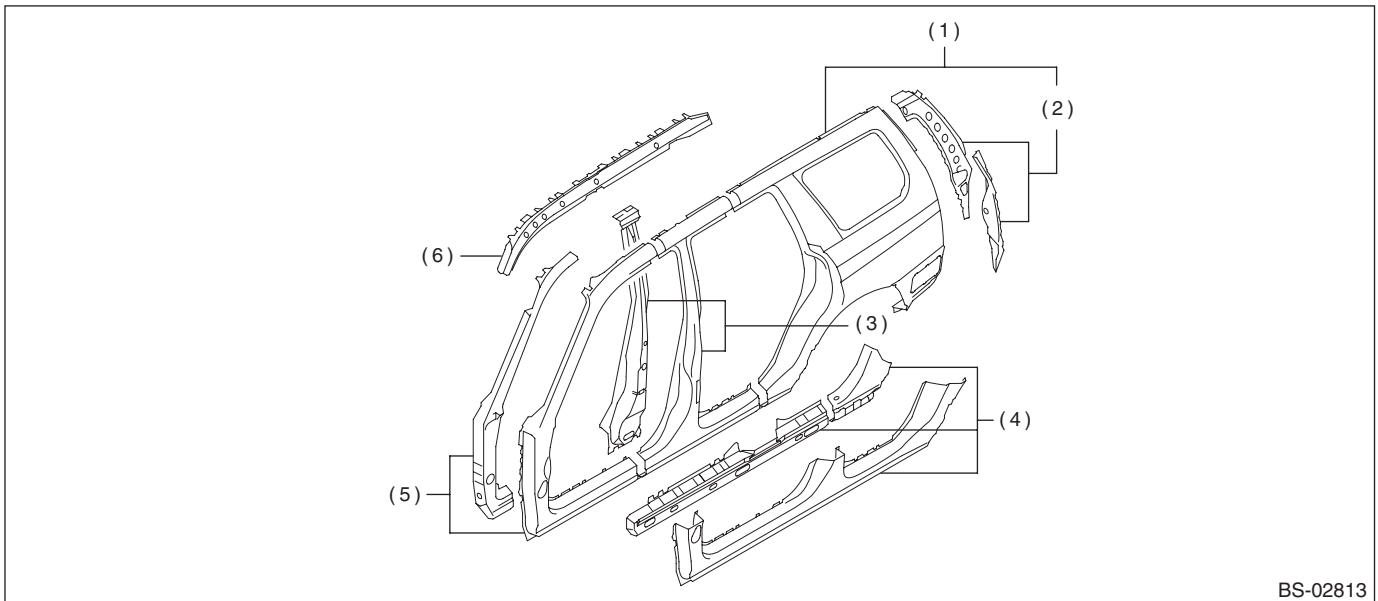
8. SIDE STRUCTURE

1) Inner panel



- | | | |
|------------------------|------------------------------|------------------------------|
| (1) Side rail inner | (4) Side sill reinforcement | (6) Front pillar inner upper |
| (2) Rear quarter inner | (5) Front pillar inner lower | (7) Center pillar inner |
| (3) Rear wheel apron | | |

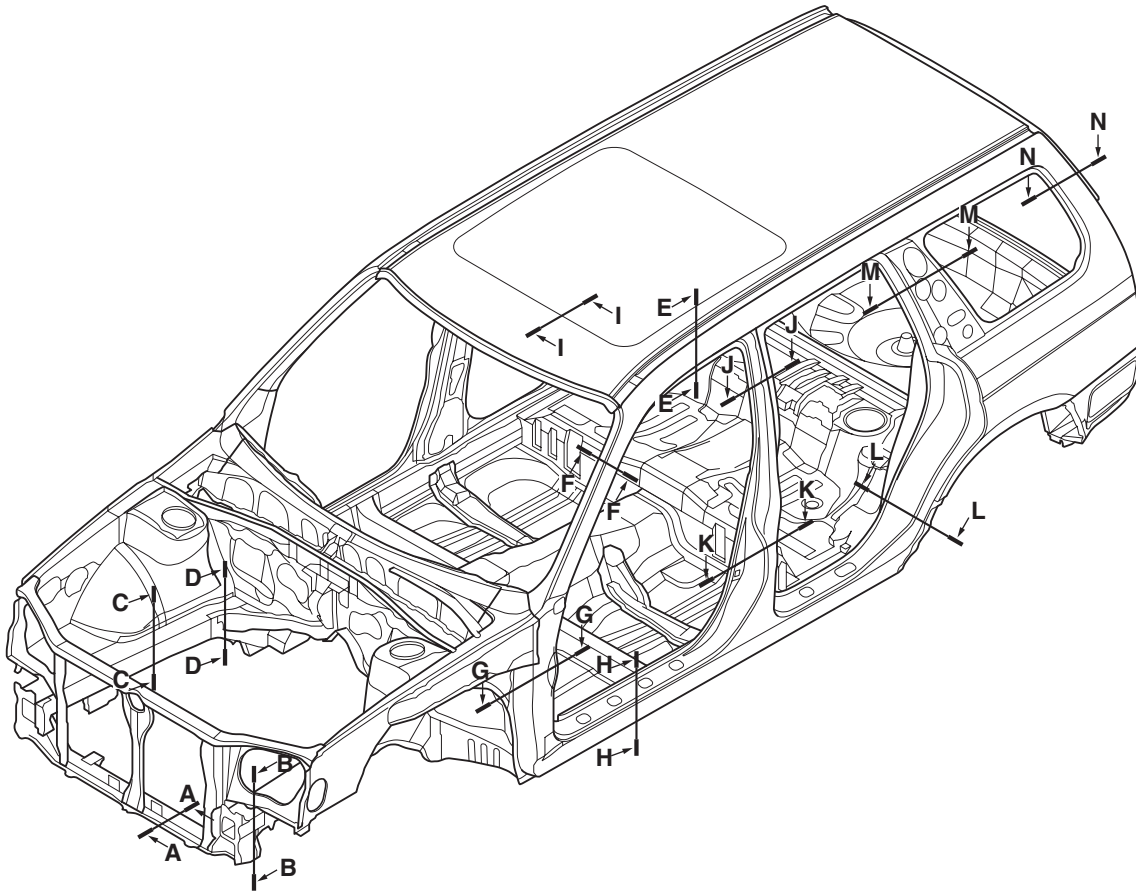
2) Outer panel



- | | | |
|----------------------------|-------------------------|-----------------------------------|
| (1) Rear quarter outer | (3) Center pillar outer | (5) Front pillar outer |
| (2) D-pillar reinforcement | (4) Side sill outer | (6) Side rail outer reinforcement |

3. Body Construction

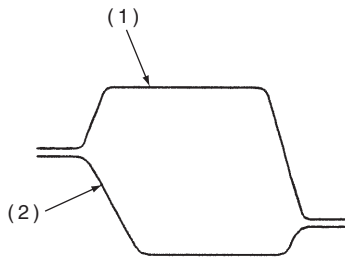
A: SPECIFICATION



BS-02668

Body Construction

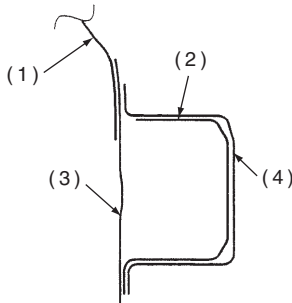
Cross section A — A



BS-02669

- (1) Radiator lower frame A
- (2) Radiator lower frame B

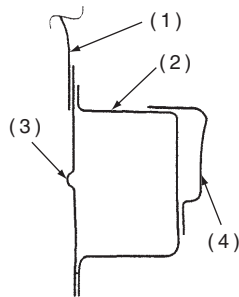
Cross section C — C



BS-02671

- (1) Front wheel apron
- (2) Frame inner reinforcement A
- (3) Closing plate
- (4) Front side frame front

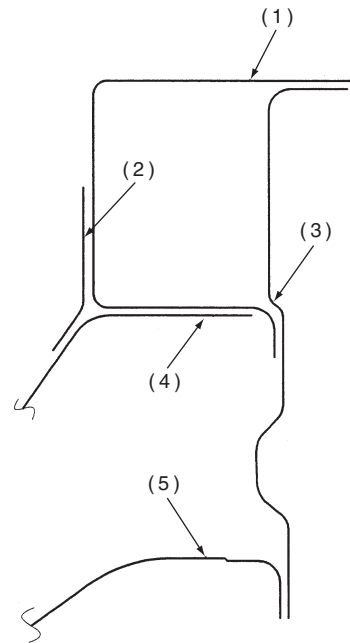
Cross section D — D



BS-02672

- (1) Front wheel apron
- (2) Front side frame front
- (3) Closing plate
- (4) Toe board front frame

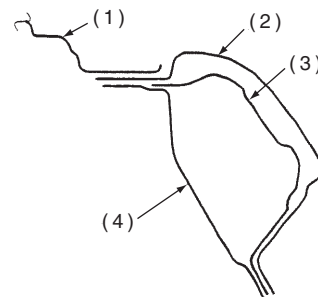
Cross section B — B



BS-02670

- (1) Front side frame front
- (2) Plate frame front
- (3) Bumper bracket A
- (4) Front frame gusset B
- (5) Radiator lower frame B

Cross section E — E

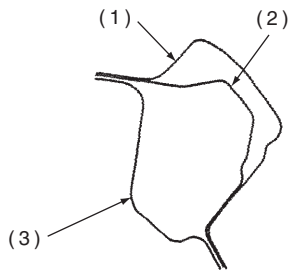


BS-02673

- (1) Roof panel
- (2) Side panel outer
- (3) Side rail outer reinforcement
- (4) Side rail inner

Body Construction

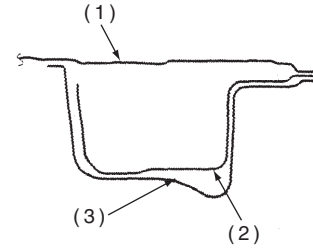
Cross section F — F



BS-02674

- (1) Side panel outer
- (2) Front pillar upper reinforcement
- (3) Front pillar inner upper

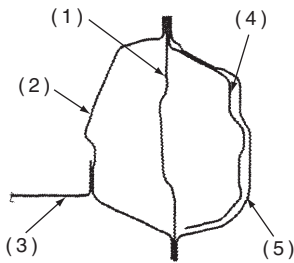
Cross section G — G



BS-02675

- (1) Front pillar inner lower
- (2) Front pillar outer reinforcement
- (3) Side panel outer

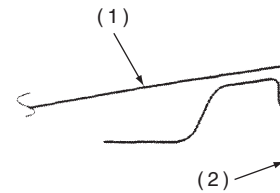
Cross section H — H



BS-02676

- (1) Side sill reinforcement
- (2) Side sill inner front
- (3) Front floor pan
- (4) Side sill outer reinforcement
- (5) Side panel outer

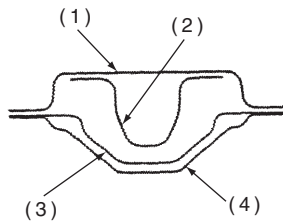
Cross section I — I



BS-02677

- (1) Roof panel
- (2) Sunroof front frame

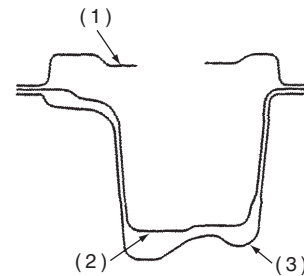
Cross section J — J



BS-02678

- (1) Center pillar inner
- (2) Center pillar inner reinforcement
- (3) Center pillar outer reinforcement
- (4) Side panel outer

Cross section K — K

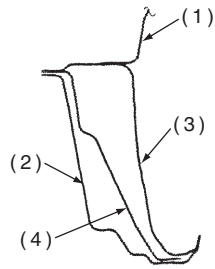


BS-02679

- (1) Center pillar inner
- (2) Center pillar outer reinforcement
- (3) Side panel outer

Body Construction

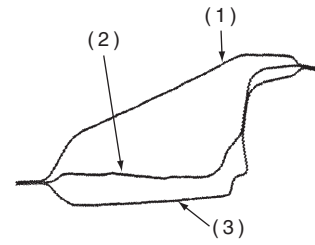
Cross section L — L



BS-02680

- (1) Rear wheel apron
- (2) Side panel outer
- (3) Rear arch inner
- (4) Side sill inner rear reinforcement

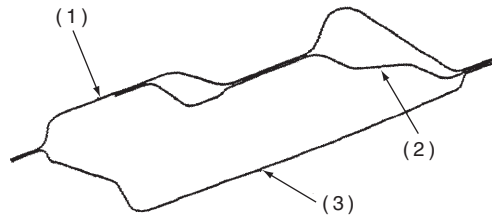
Cross section N — N



BS-02682

- (1) Rear quarter inner
- (2) D-pillar reinforcement
- (3) Side panel outer

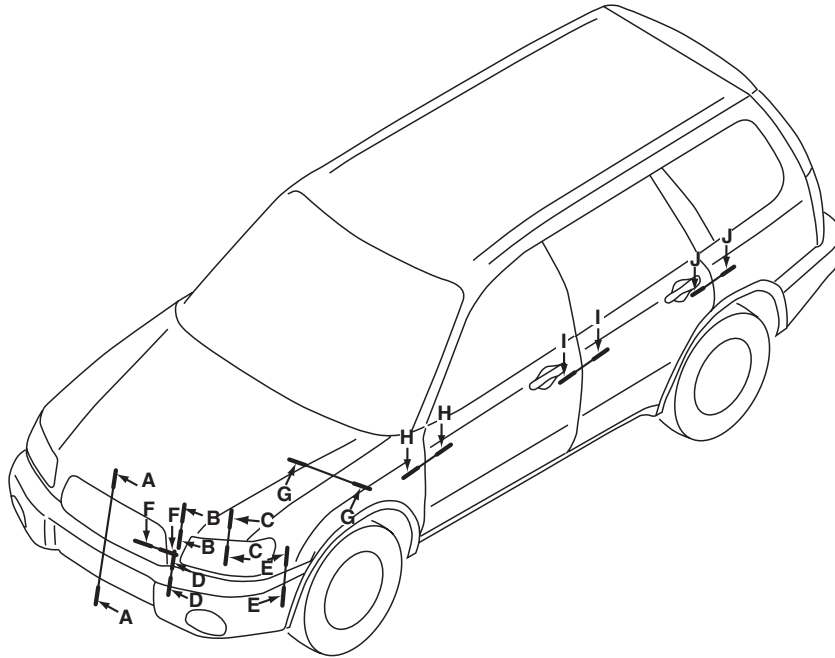
Cross section M — M



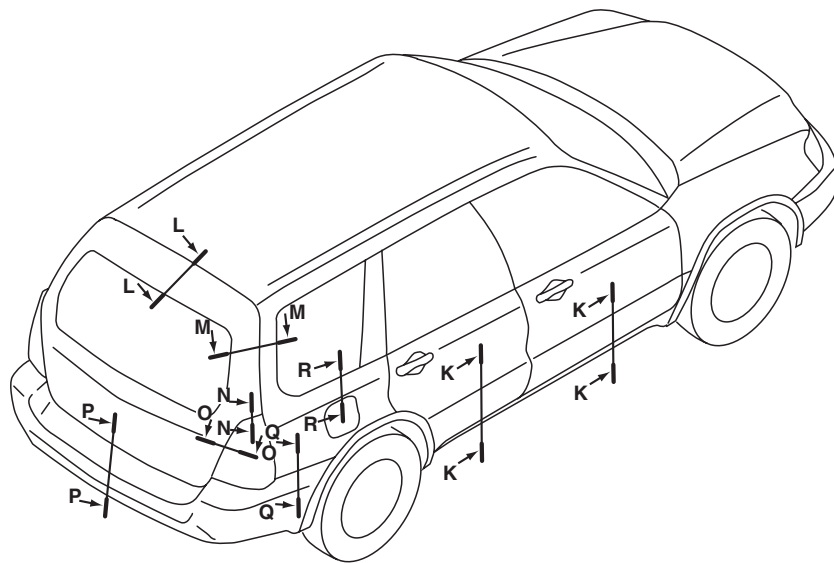
BS-02681

- (1) Rear quarter inner
- (2) C-pillar reinforcement
- (3) Side panel outer

4. Gauge Values for Fitting



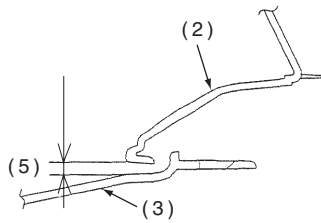
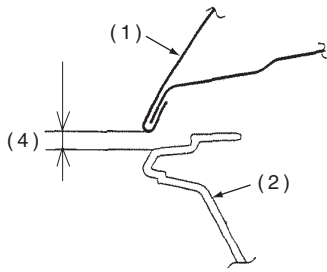
BS-02683



BS-02694

Gauge Values for Fitting

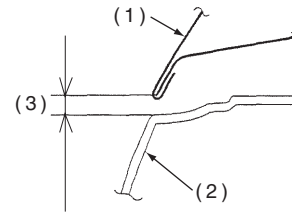
Cross section A — A



BS-02684

- (1) Front hood
- (2) Front grille
- (3) Front bumper
- (4) 6.0 ± 1.0 mm (0.24 ± 0.04 in)
- (5) 4.5 ± 1.0 mm (0.18 ± 0.04 in)

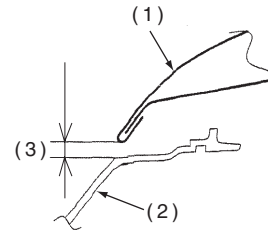
Cross section B — B



BS-02685

- (1) Front hood
- (2) Front extension
- (3) 5.8 ± 1.0 mm (0.23 ± 0.04 in)

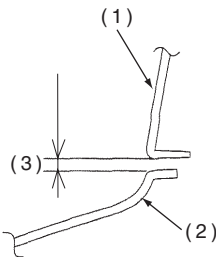
Cross section C — C



BS-02686

- (1) Front hood
- (2) Headlight
- (3) 5.4 ± 1.5 mm (0.21 ± 0.06 in)

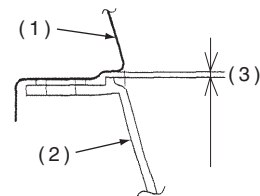
Cross section D — D



BS-02687

- (1) Front extension
- (2) Front bumper
- (3) 4.5 ± 1.0 mm (0.18 ± 0.04 in)

Cross section E — E

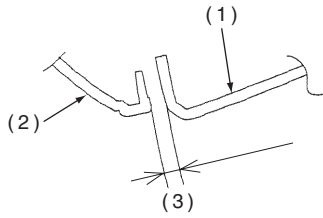


BS-02688

- (1) Fender
- (2) Front bumper
- (3) 2.0 ± 0.7 mm (0.08 ± 0.03 in)

Gauge Values for Fitting

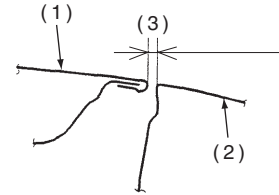
Cross section F — F



BS-02689

- (1) Front extension
- (2) Front grille
- (3) 4.5 ± 1.5 mm (0.18 ± 0.06 in)

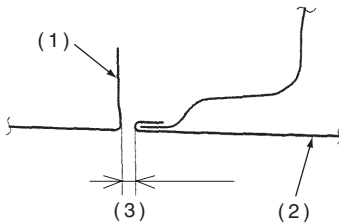
Cross section G — G



BS-02690

- (1) Front hood
- (2) Fender
- (3) 3.5 ± 1.0 mm (0.14 ± 0.04 in)

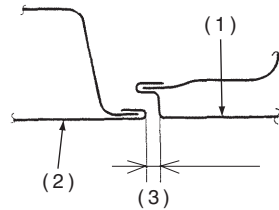
Cross section H — H



BS-02691

- (1) Fender
- (2) Front door
- (3) 4.7 ± 1.0 mm (0.19 ± 0.04 in)

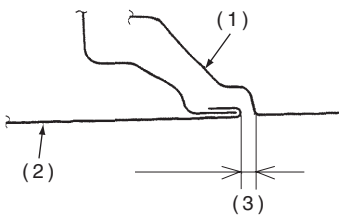
Cross section I — I



BS-02692

- (1) Rear door
- (2) Front door
- (3) 5.1 ± 1.0 mm (0.20 ± 0.04 in)

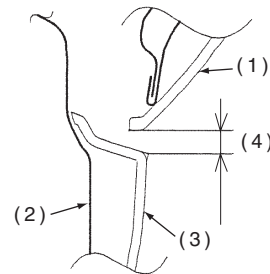
Cross section J — J



BS-02693

- (1) Side panel outer
- (2) Rear door
- (3) 4.6 ± 1.0 mm (0.18 ± 0.04 in)

Cross section K — K

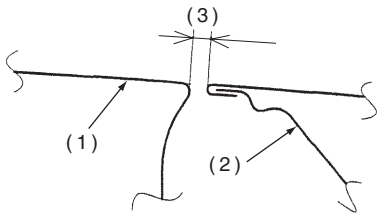


BS-02695

- (1) Side door garnish
- (2) Side panel outer
- (3) Side sill garnish
- (4) 7.0 ± 1.5 mm (0.28 ± 0.06 in)

Gauge Values for Fitting

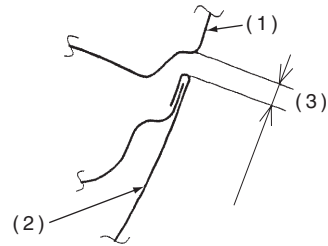
Cross section L — L



BS-02696

- (1) Roof panel
- (2) Rear gate
- (3) $6.6^{+1.0}_{-0.5}$ mm ($0.26^{+0.04}_{-0.02}$ in)

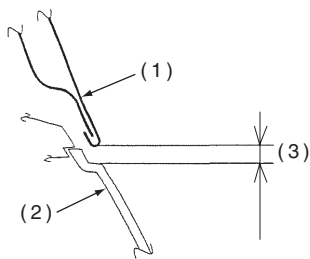
Cross section M — M



BS-02697

- (1) Side panel outer
- (2) Rear gate
- (3) $6.6^{+1.0}_{-0.5}$ mm ($0.26^{+0.04}_{-0.02}$ in)

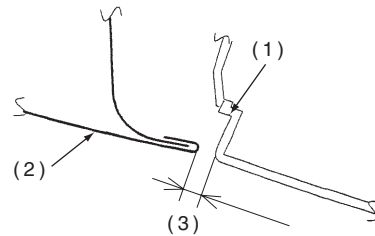
Cross section N — N



BS-02698

- (1) Rear gate
- (2) Rear combination light
- (3) $5.0^{+1.5}_{-0.5}$ mm ($0.20^{+0.06}_{-0.02}$ in)

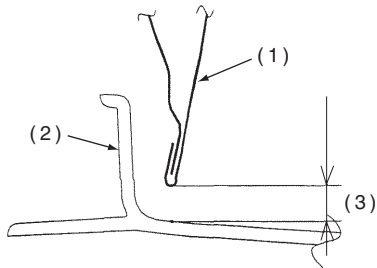
Cross section O — O



BS-02699

- (1) Rear combination light
- (2) Rear gate
- (3) $5.1^{+1.5}_{-0.5}$ mm ($0.20^{+0.06}_{-0.02}$ in)

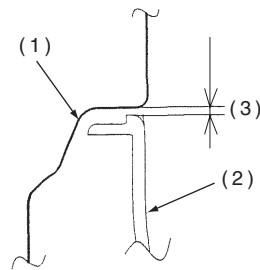
Cross section P — P



BS-02700

- (1) Rear gate
- (2) Rear bumper
- (3) 8.3 ± 1.5 mm (0.33 ± 0.06 in)

Cross section Q — Q

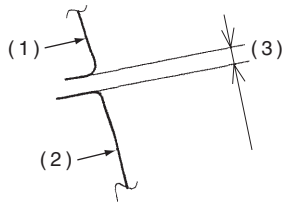


BS-02701

- (1) Side panel outer
- (2) Rear bumper
- (3) 2.0 ± 0.7 mm (0.08 ± 0.03 in)

Gauge Values for Fitting

Cross section R — R



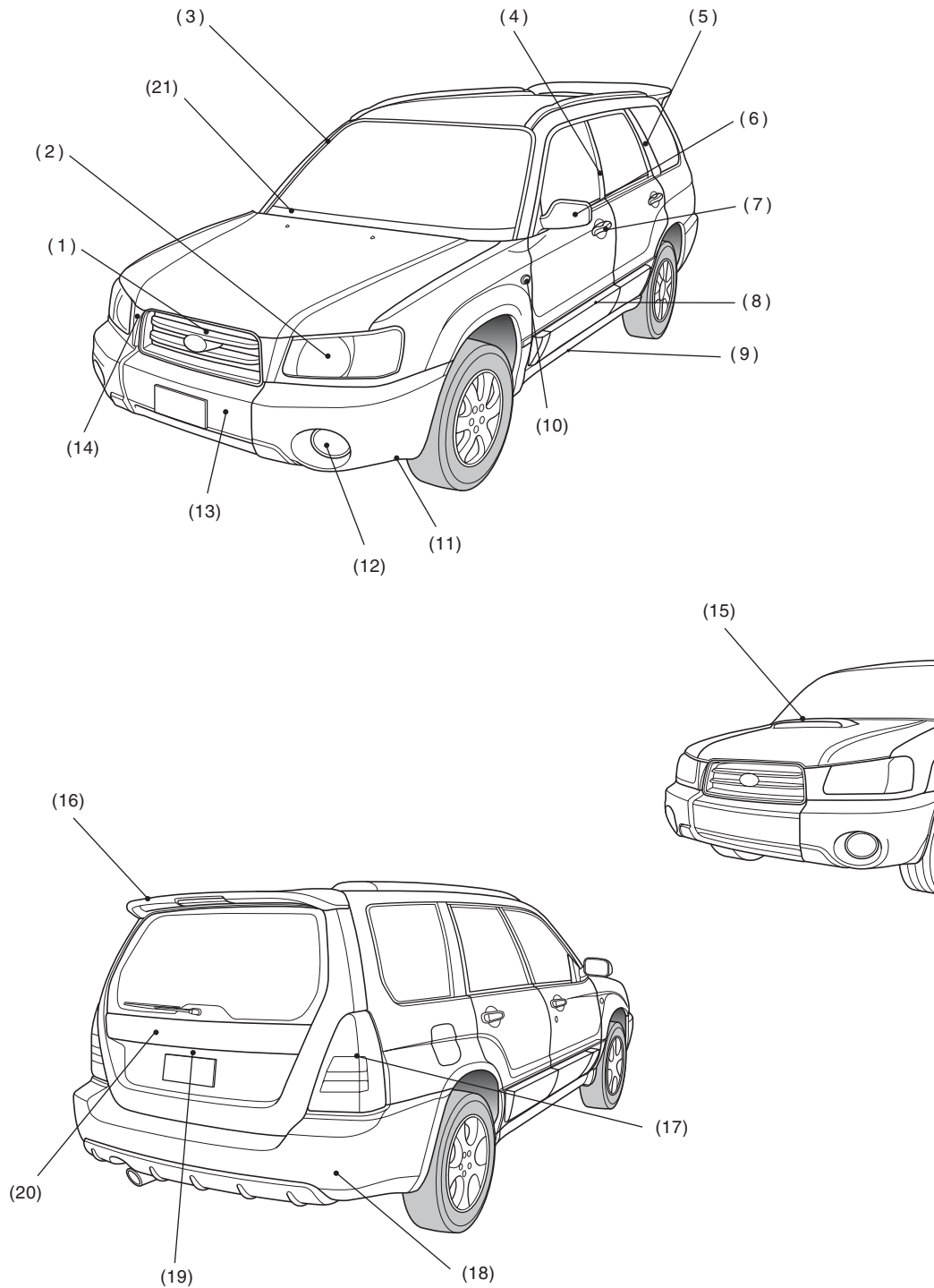
BS-02702

- (1) Side panel outer
- (2) Fuel flap
- (3) 3.5 ± 0.5 mm (0.14 ± 0.02 in)

SUBARU.

5. Plastic Parts and Materials

A: SPECIFICATION



BS-03413

Plastic Parts and Materials

(1) Front grille	(8) Side protector	(15) Hood grille
(2) Headlight	(9) Side spoiler	(16) Roof spoiler
(3) Front window moulding	(10) Side turn light	(17) Rear combination light
(4) Cover B pillar	(11) Air flap	(18) Rear bumper
(5) Cover C pillar	(12) Front fog light	(19) Rear gate handle
(6) Door mirror	(13) Front bumper	(20) Rear gate garnish
(7) Door handle	(14) Grille side front bumper	(21) Cowl panel

Plastic Parts and Materials

No.	Part name		Material
(1)	Front grille		ABS
(2)	Headlight	Lens	PC
		Housing	PP
(3)	Front window moulding		TPO
(4)	Cover B pillar		PC/SAS
(5)	Cover C pillar		ABS
(6)	Door mirror	Stay	PA - GF60
		Body (not painted)	AES
		Body (painted)	ABS
		Mirror holder	PP
(7)	Door handle	Body (not painted)	PC/PET
		Body (painted)	PPE/PA
		End cover	PP/EPDM
(8)	Side garnish		PP
(9)	Side spoiler		PP
(10)	Side turn light	Lens	PMMA
		Housing	PC
(11)	Air flap		PP
(12)	Front fog light	Lens	PC
		Housing	UP
		Cover	PP
(13)	Front bumper	Face	PP
		EA form	Foamed PP
(14)	Grille side front bumper		PP
(15)	Hood grille	Body	PPE+PA6
		Complete duct	EPDM
(16)	Roof spoiler		ABS
(17)	Rear combination light	Lens	PMMA
		Housing	PP
(18)	Rear bumper	Face	PP
(19)	Rear gate handle		PBT/PC
(20)	Rear gate garnish		PC - PET
(21)	Cowl panel		PP

List of Plastic Material Notations

6. List of Plastic Material Notations

A: SPECIFICATION

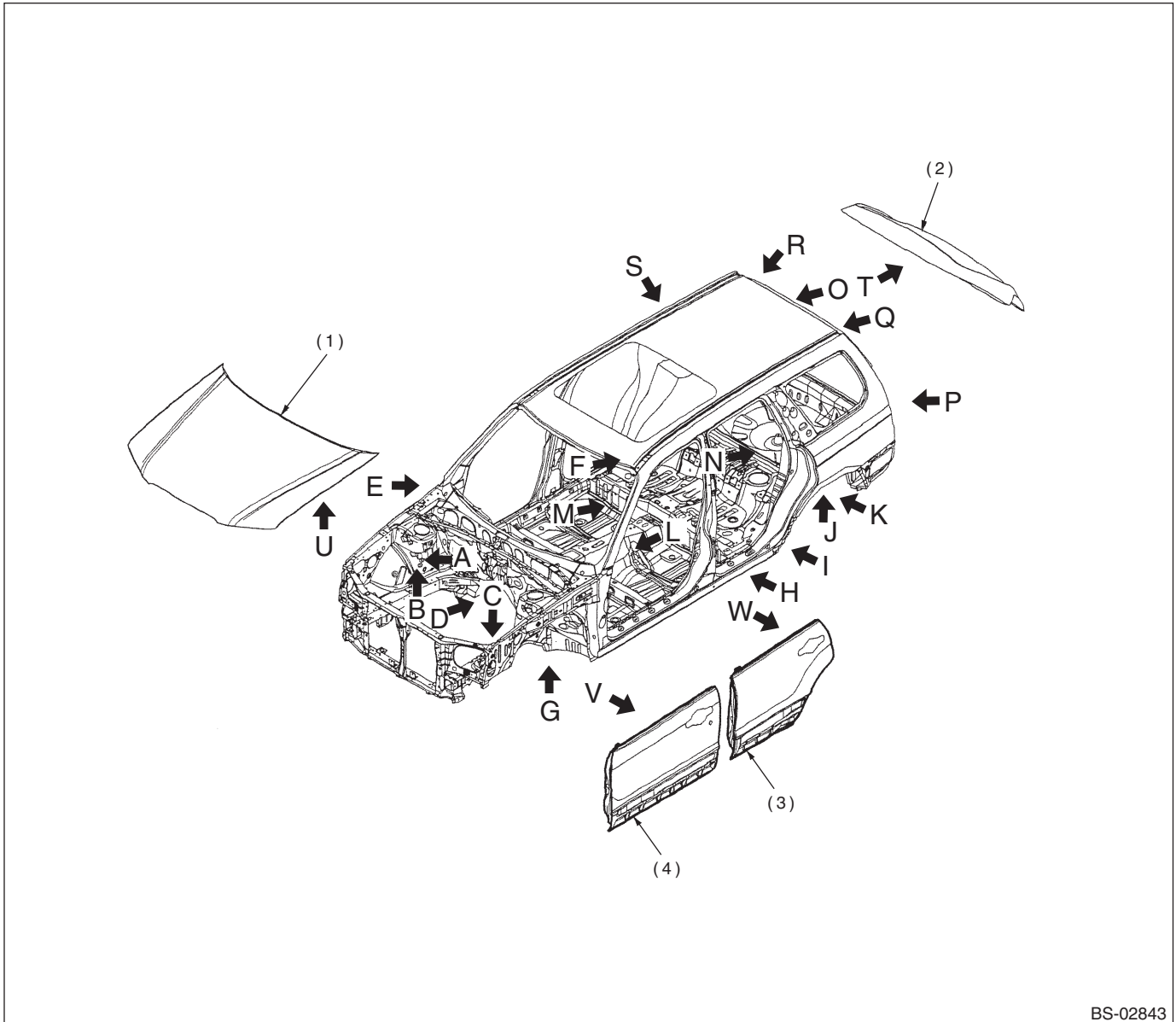
Notation symbol	Material name	Notation symbol	Material name
ABS	ABS resin (acrylonitrile/butadiene/styrene/resin)	PP	Polypropylene
AES	Acrylonitrile/ethylene/styrene	PPE	Polyphenylene ether
ASA	Acrylonitrile/styrene/acrylic resin	PP - GF20	Polypropylene (20% glass fiber content)
EPDM	Ethylene/propylene/dien rubber	PP - GF30	Polypropylene (30% glass fiber content)
GF	Glass fiber	PP - GF60	Polypropylene (60% glass fiber content)
PA	Nylon (polyamide)	PVC	Polyvinyl chloride
PA6	Nylon 6	SAS	Acrylonitrile/styrene/silicon
PBT	Poly (butylene terephthalate)	SEPM	Styrene/ethylene/propylene rubber
PC	Polycarbonate	TPO	Thermoplastic olefine
PE	Polyethylene	UP	Unsaturated polyester resin
PET	Polyethylene terephthalate	UP - GF10	Unsaturated polyester resin (10% glass fiber content)
PMMA	Polymethyl methacrylate		

7. Body Sealing

A: SPECIFICATION

Used material: **Three Bond 4101 (004403063)**

— : Sealer application location



BS-02843

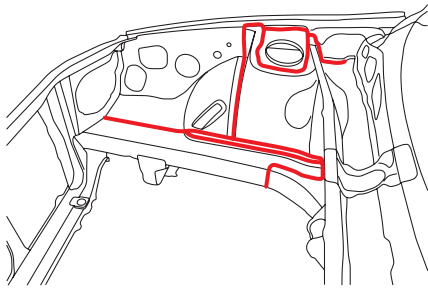
(1) Front hood
(2) Rear gate

(3) Rear door

(4) Front door

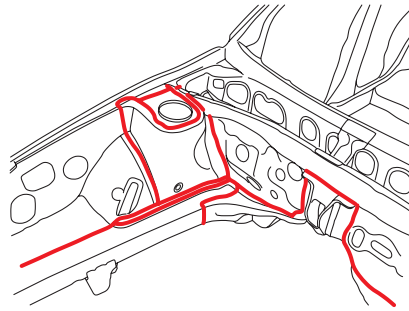
Body Sealing

View A



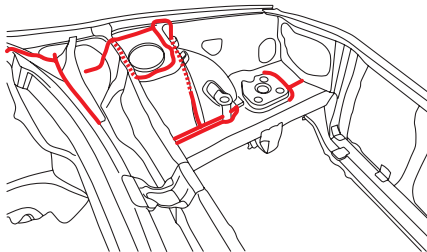
BS-02705

View B



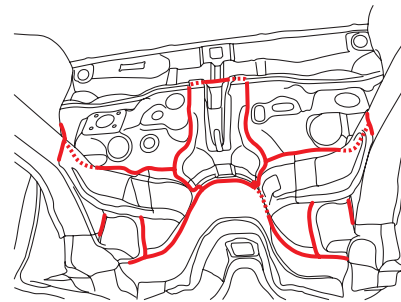
BS-02706

View C



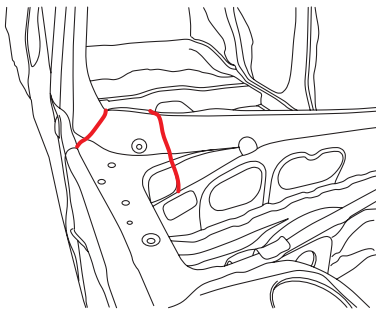
BS-02707

View D



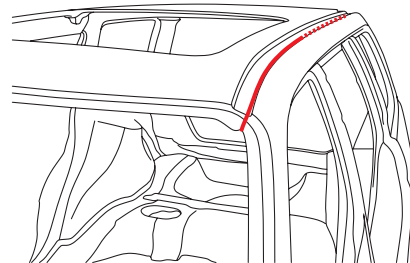
BS-02708

View E



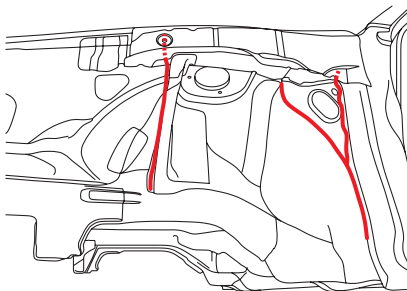
BS-02709

View F



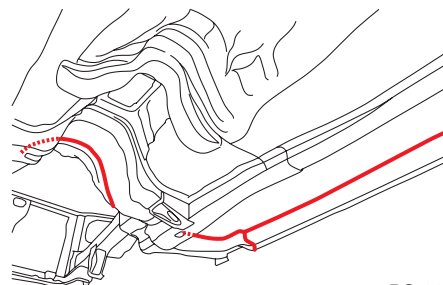
BS-02710

View G



BS-02711

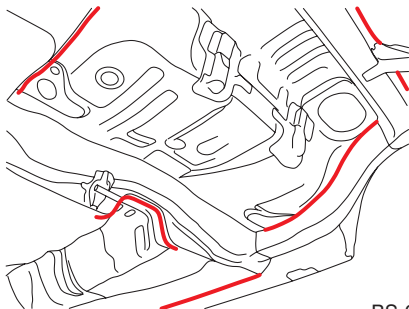
View H



BS-02712

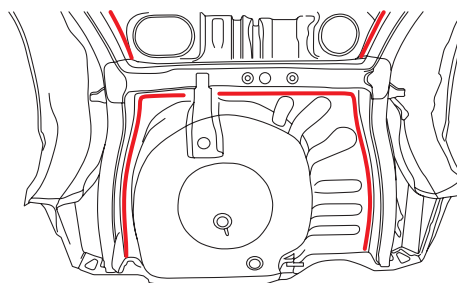
Body Sealing

View I



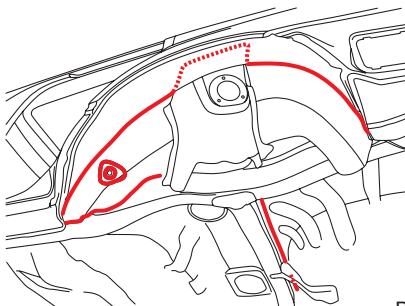
BS-02713

View J



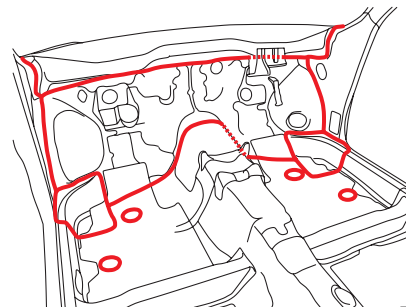
BS-02714

View K



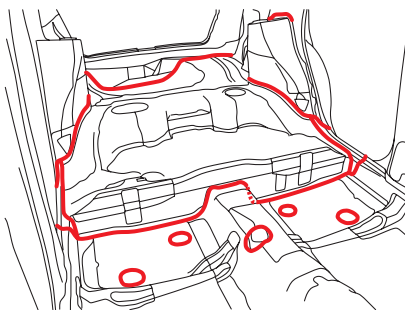
BS-02715

View L



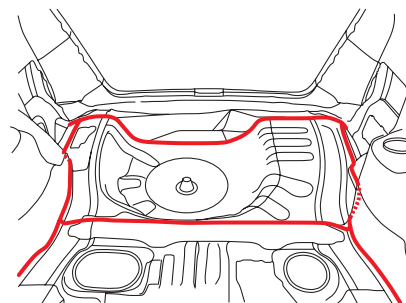
BS-02716

View M



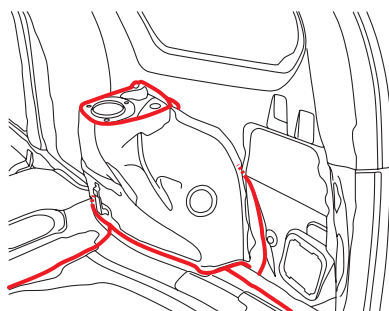
BS-02717

View N



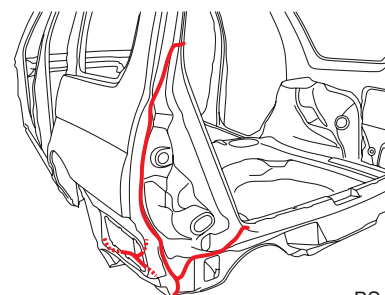
BS-02718

View O



BS-02719

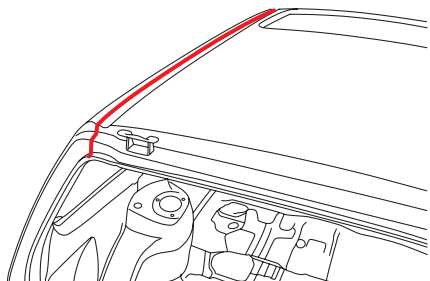
View P



BS-02720

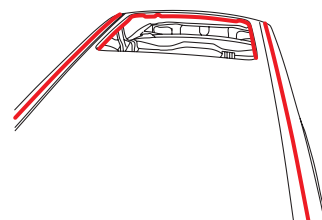
Body Sealing

View Q



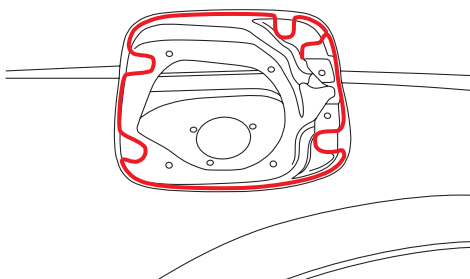
BS-02721

View R



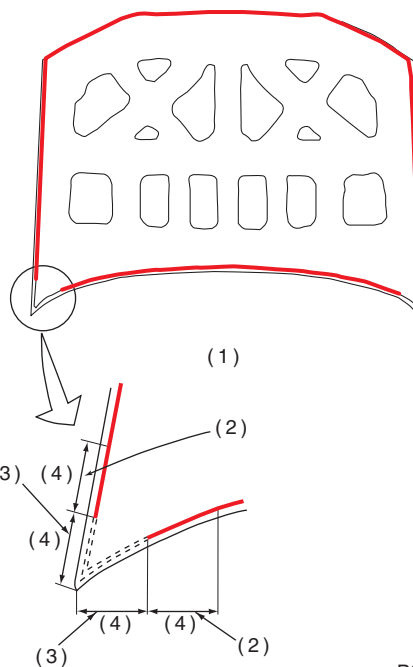
BS-02722

View S



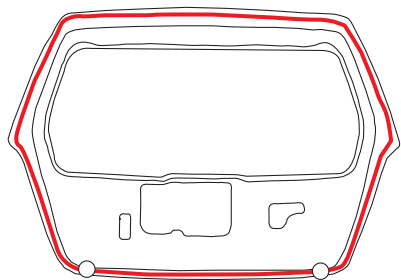
BS-02723

View U



BS-03421

View T

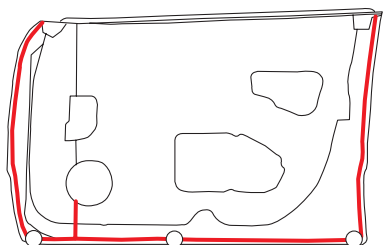


BS-02725

CAUTION:
Do not block the water drain holes (circled).

- (1) Paint symmetrically.
- (2) Smooth this section after applying PS.
- (3) No application of PS is required at this section.
- (4) 50 mm (1.97 in)

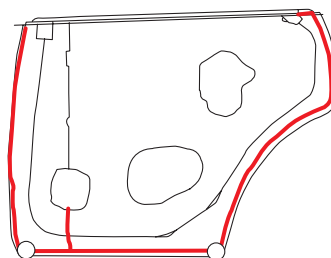
View V



BS-02726

CAUTION:
Do not block the water drain holes (circled).

View W



BS-02727

CAUTION:
Do not block the water drain holes (circled).

CAUTION:
Sealer already has been applied to hood, door and rear gate in replacement condition.

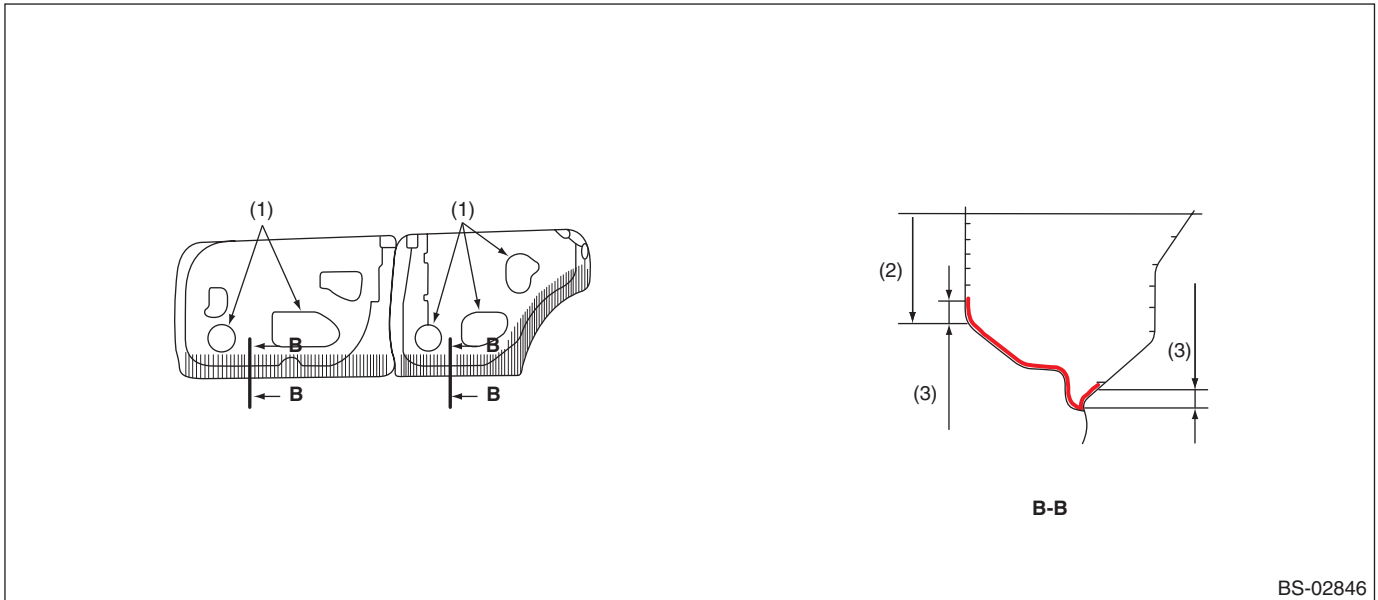
8. Anticorrosion Wax

A: SPECIFICATION

Used material:

Rust-stop aerosol (K0877YA015)

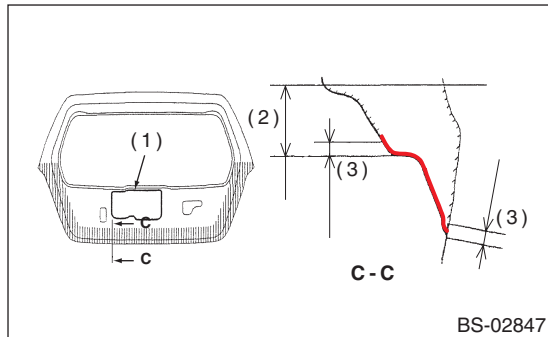
- and  : Application area
-  : Application thickness: 50 μm or more
-  : Application thickness: 20 μm or more
- Door (Front, rear)



BS-02846

- (1) Wax application work openings (2) 50 mm (1.97 in) (3) 10 mm (0.39 in) or more

• Rear gate

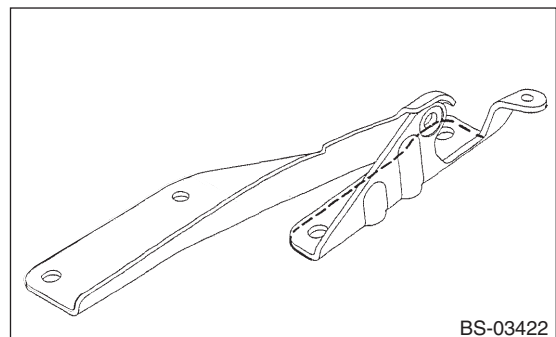


BS-02847

- (1) Wax application work openings
 (2) 50 mm (1.97 in)
 (3) 10 mm (0.39 in) or more

• Front hood hinge

Apply around the installation outer circumference (indicated range) at two locations on the left and right. (Application thickness: 15 μm or more)

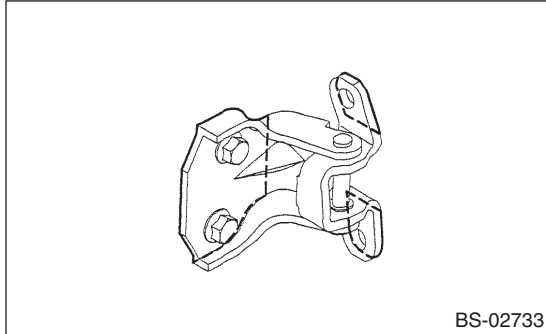


BS-03422

Anticorrosion Wax

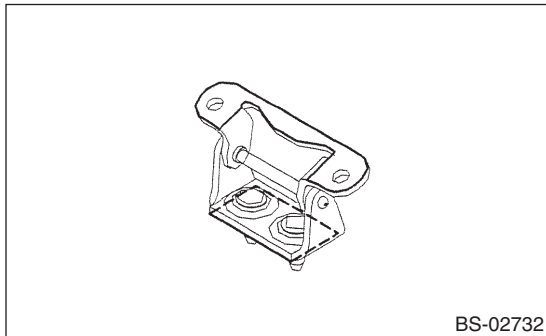
- Door hinge

Apply to the installation outer circumference at two locations at the top and bottom (eight locations in all). (Application thickness: 15 μm or more)



- Rear gate hinge

Apply around the installation outer circumference (plate edges) at two locations on the left and right. (Application thickness: 15 μm or more)



9. Undercoat

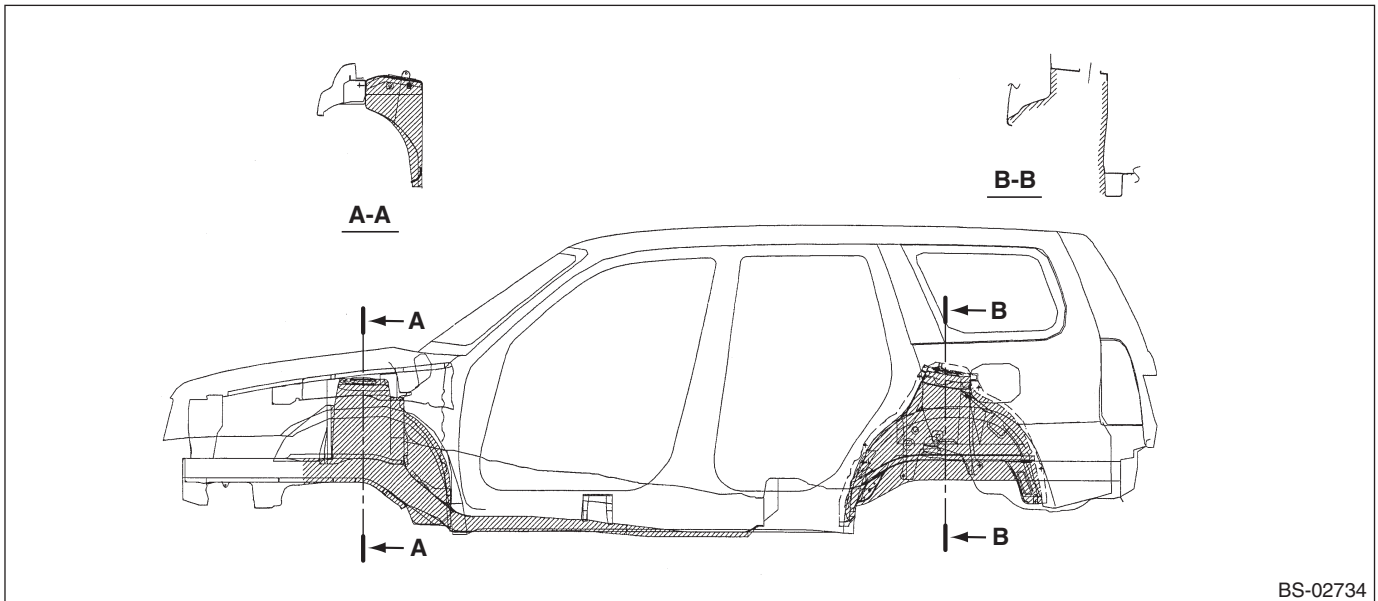
A: SPECIFICATION

Repair material: **THREE BOND 6115**

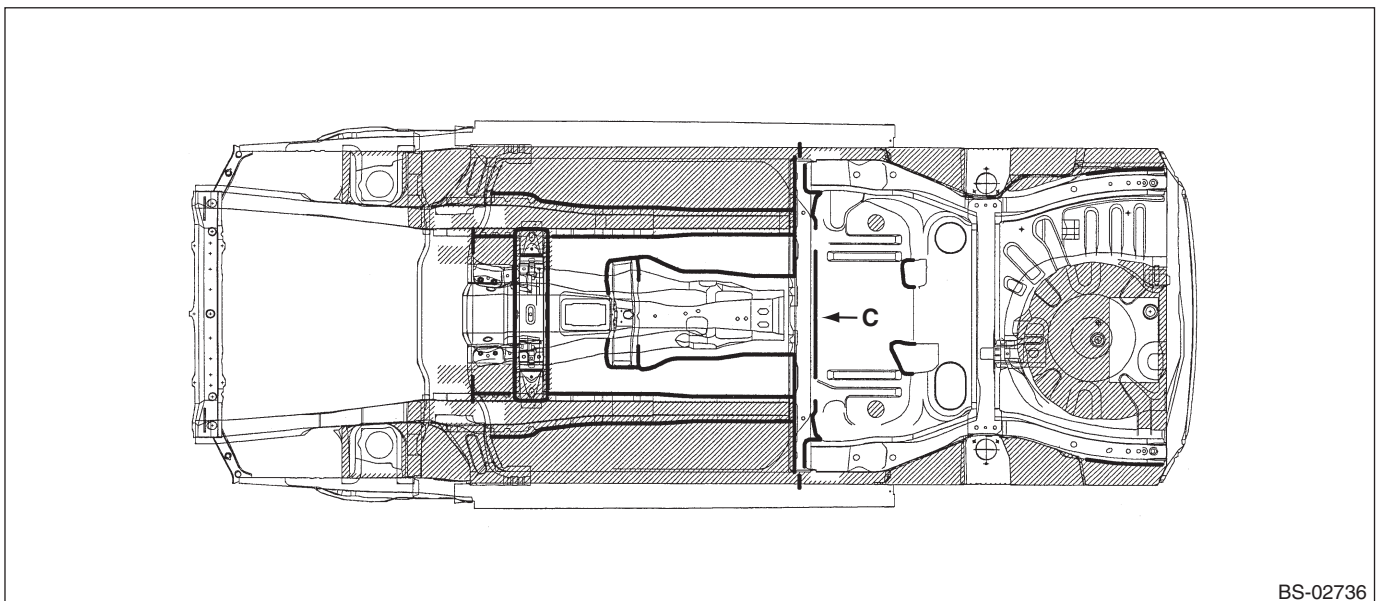
- 1) Application thickness is 0.4 mm (0.016 in) or more.
- 2) Be careful that the undercoat does not become attached to locations other than where indicated in the figure, and on the following locations.
 - High-temperature parts related to the exhaust pipe
 - Hoses, tubes, and harness parts
 - Installation surfaces of rear suspension, transmission, subframe etc.
- 3) Application area

 and  : Undercoat application location

Side view

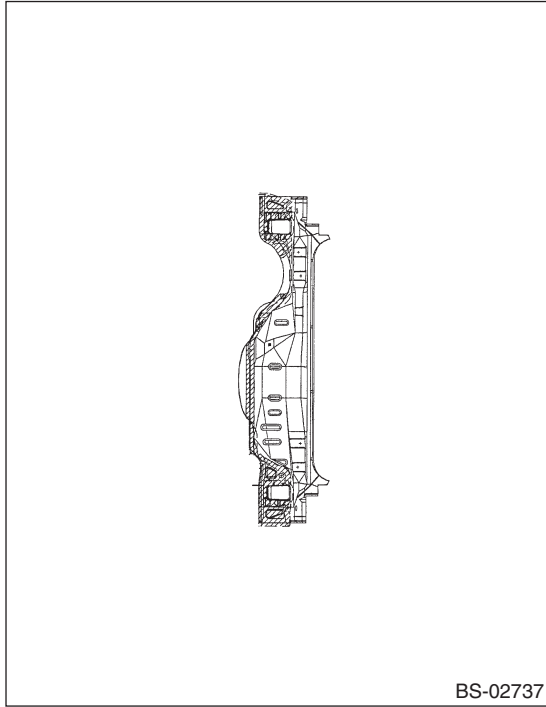


Bottom view

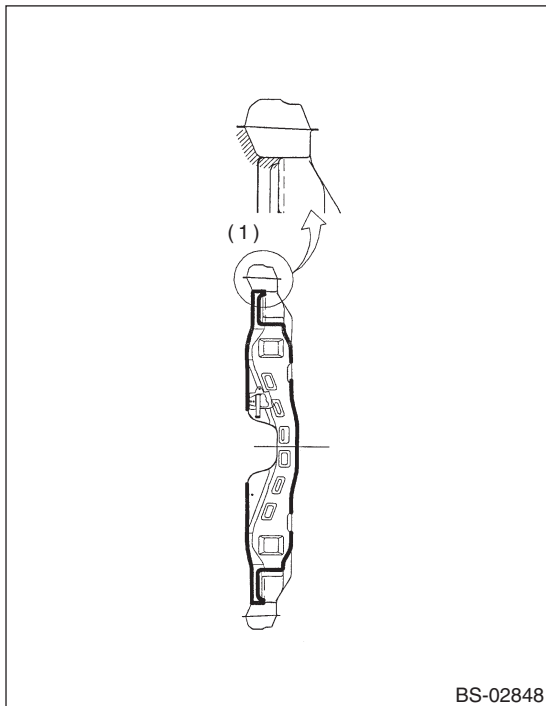


Undercoat

Rear view

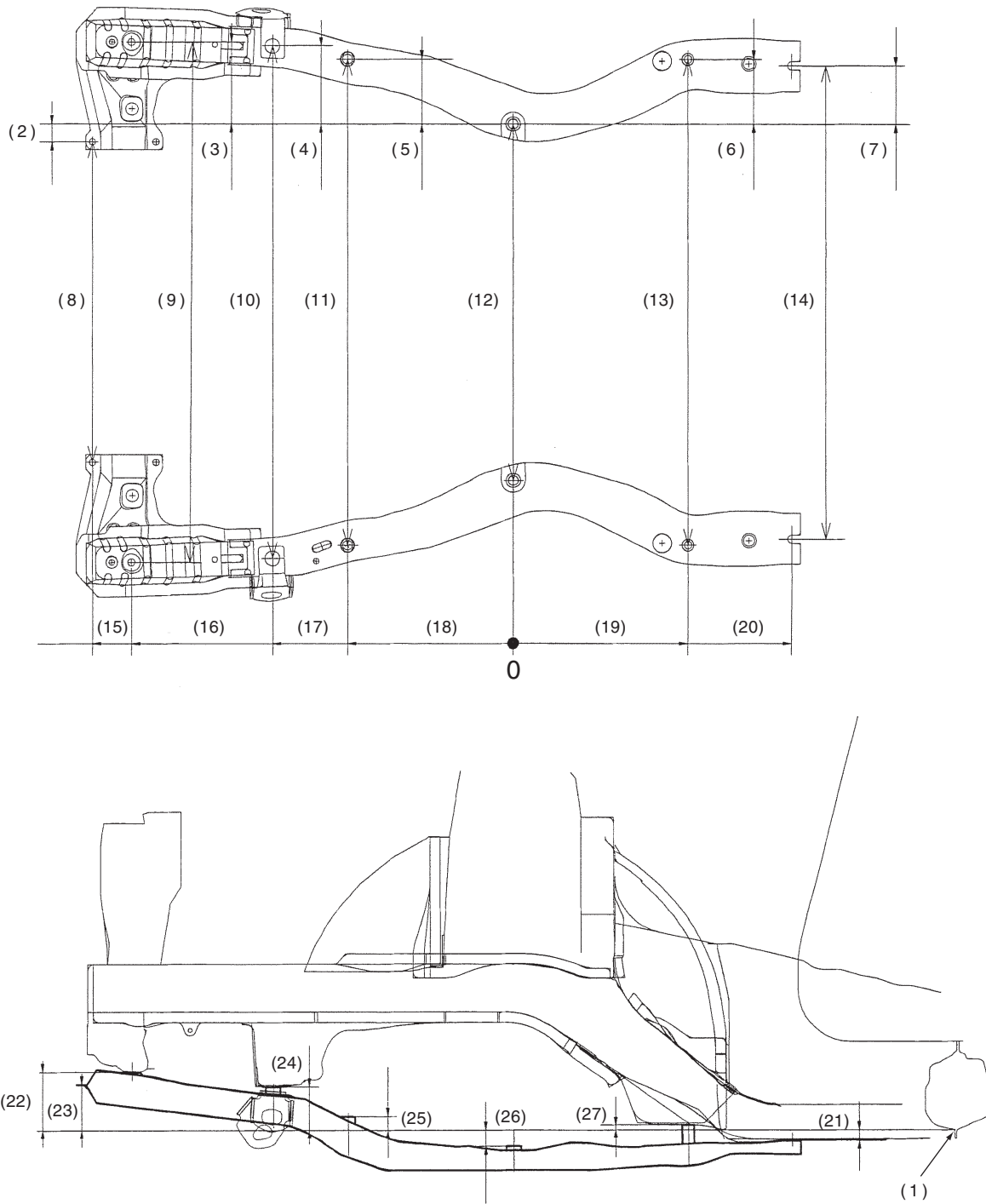


View C



(1) Symmetrical

10.Sub Frame



BS-02738

Sub Frame

(1) Side sill flange joint	(10) 906 mm (35.7 in)	(19) 311 mm (12.2 in)
(2) 32 mm (1.26 in)	(11) 860 mm (33.9 in)	(20) 495 mm (19.5 in)
(3) 146 mm (5.75 in)	(12) 628 mm (24.7 in)	(21) 20 mm (0.79 in)
(4) 139 mm (5.47 in)	(13) 860 mm (33.9 in)	(22) 105 mm (4.1 in)
(5) 116 mm (4.57 in)	(14) 838 mm (33.0 in)	(23) 81 mm (3.2 in)
(6) 116 mm (4.57 in)	(15) 749 mm (29.5 in)	(24) 77 mm (3.0 in)
(7) 105 mm (4.13 in)	(16) 679 mm (26.7 in)	(25) 25 mm (0.98 in)
(8) 564 mm (22.2 in)	(17) 429 mm (16.9 in)	(26) 29 mm (1.1 in)
(9) 920 mm (36.2 in)	(18) 296 mm (11.7 in)	(27) 9 mm (0.35 in)

CAUTION:

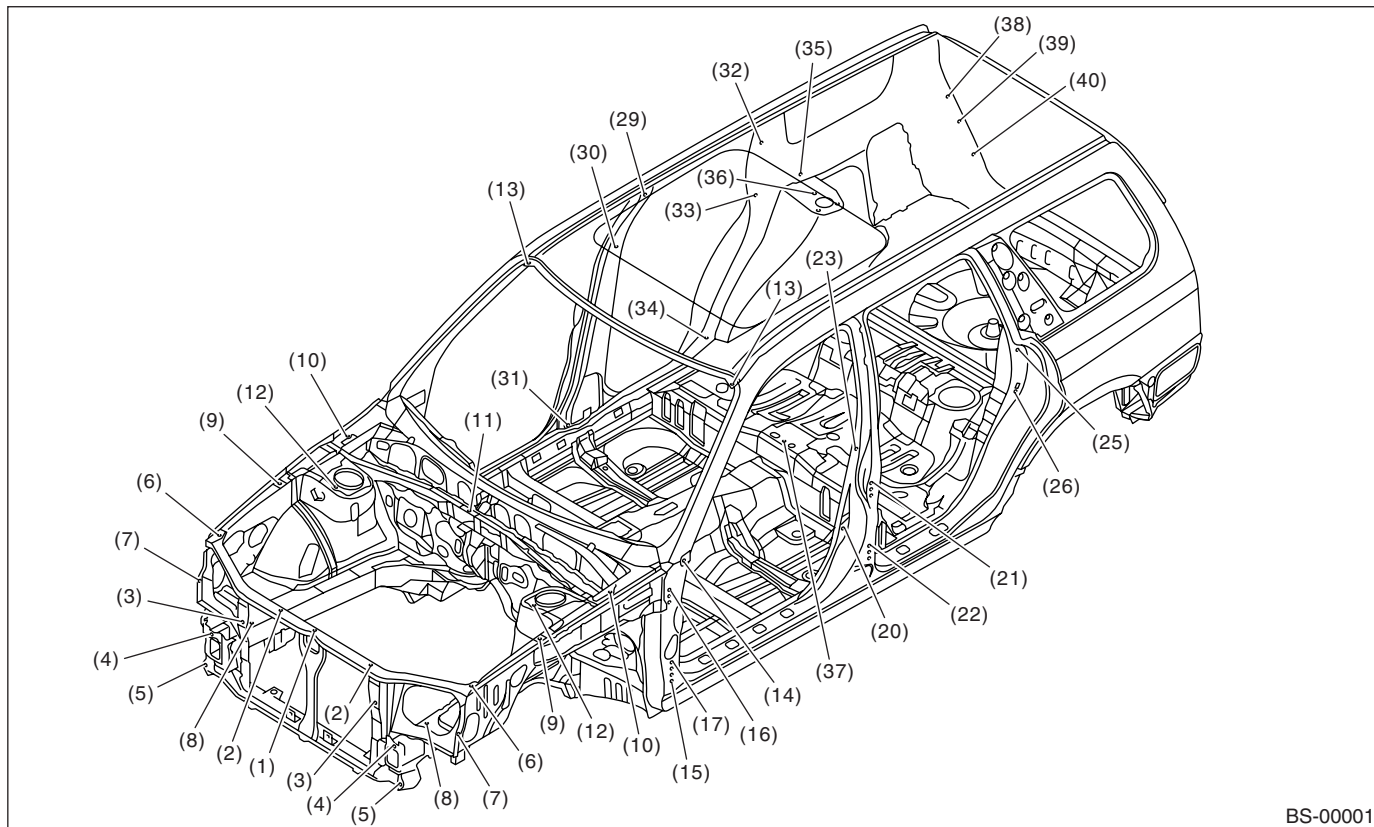
- Do not use the sub frame as a support point for jack-up.
- Do not use a deformed sub frame that does not fit the installation position.
- Do not use a sub frame whose cross section shape is deformed.

NOTE:

Any dimensional point in longitudinal directions is measured from the zero (0) reference point.

11.Body Reference Points

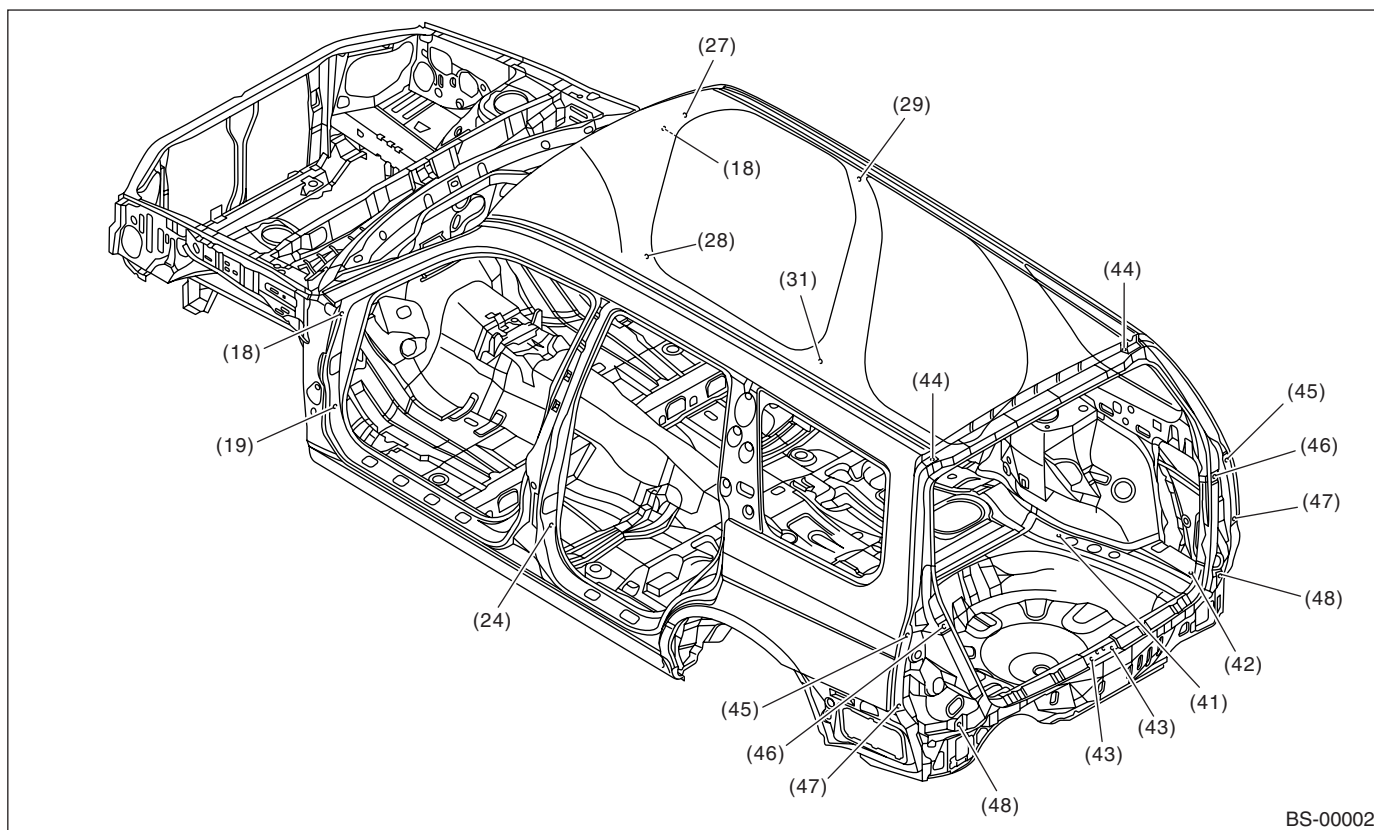
A: REFERENCE POINT



BS-00001

- | | | |
|---|---|---|
| (1) Radiator panel gauge hole dia.
6mm (0.24 in) (vehicle center) | (13) Front glass mounting hole RH 6.5
x 10.5 mm (0.26 x 0.41 in) LH 6.5
x 7 mm (0.26 x 0.28 in) | (30) Pad mounting hole dia.
5 mm (0.20 in) (symmetrical) |
| (2) Radiator mounting hole dia.
12 mm (0.47 in) | (14) Fender mounting hole dia.
10 mm (0.39 in) (symmetrical) | (31) Harness mounting hole dia.
7 mm (0.28 in) (symmetrical) |
| (3) Headlight mounting hole dia.
7 mm (0.28 in) (symmetrical) | (15) Fender mounting hole dia.
10 mm (0.39 in) (symmetrical) | (32) Trim mounting hole dia.
8.5 mm (0.33 in) (symmetrical) |
| (4) Frame plate gauge hole dia.
8 mm (0.31 in) (symmetrical) | (16) Front door hinge mounting hole
dia. 12 mm (0.47 in) (symmetrical) | (33) Trim mounting hole dia.
7 mm (0.28 in) (symmetrical) |
| (5) Bumper beam mounting hole dia.
11 mm (0.43 in) (symmetrical) | (17) Front door hinge mounting hole
dia. 12 mm (0.47 in) (symmetrical) | (34) Harness mounting hole 7 x 7 mm
(0.28 x 0.28 in) (symmetrical) |
| (6) Fender mounting hole dia.
7 mm (0.28 in) (symmetrical) | (20) Front door switch mounting hole
dia. 4.1 mm (0.16 in) (symmetrical) | (35) Tonneau cover mounting hole dia.
5.5 mm (0.22 in) (symmetrical) |
| (7) Fender mounting hole dia.
9 mm (0.35 in) (symmetrical) | (21) Rear door hinge mounting hole
dia. 12 mm (0.47 in) (symmetrical) | (36) Rear strut mounting hole dia.
10 mm (0.39 in) (symmetrical) |
| (8) RH power steering tank mounting
hole LH ATF cooler pipe mounting
hole dia. 9 mm (0.35 in) | (22) Rear door hinge mounting hole
dia. 12 mm (0.47 in) (symmetrical) | (37) Floor mat mounting hole dia.
8 mm (0.31 in) |
| (9) Fender mounting hole dia.
10 mm (0.39 in) (symmetrical) | (23) Front weather strip mounting hole
dia. 5.2 mm (0.20 in) (symmetrical) | (38) Trim mounting hole 9 x 9 mm
(0.35 x 0.35 in) (symmetrical) |
| (10) Fender mounting hole dia.
7 mm (0.28 in) (symmetrical) | (25) Rear weather strip mounting hole
dia. 5.2 mm (0.20 in) (symmetrical) | (39) Trim mounting hole dia.
8 mm (0.31 in) (symmetrical) |
| (11) Modular bracket gauge hole dia.
8 mm (0.31 in) (vehicle center) | (26) Rear door switch mounting hole dia.
4.1 mm (0.16 in) (symmetrical) | (40) Trim mounting hole dia.
8 mm (0.31 in) (symmetrical) |
| (12) Front strut mounting hole dia.
9.5 mm (0.37 in) (symmetrical) | (29) Trim mounting hole dia.
8.5 mm (0.33 in) (symmetrical) | |

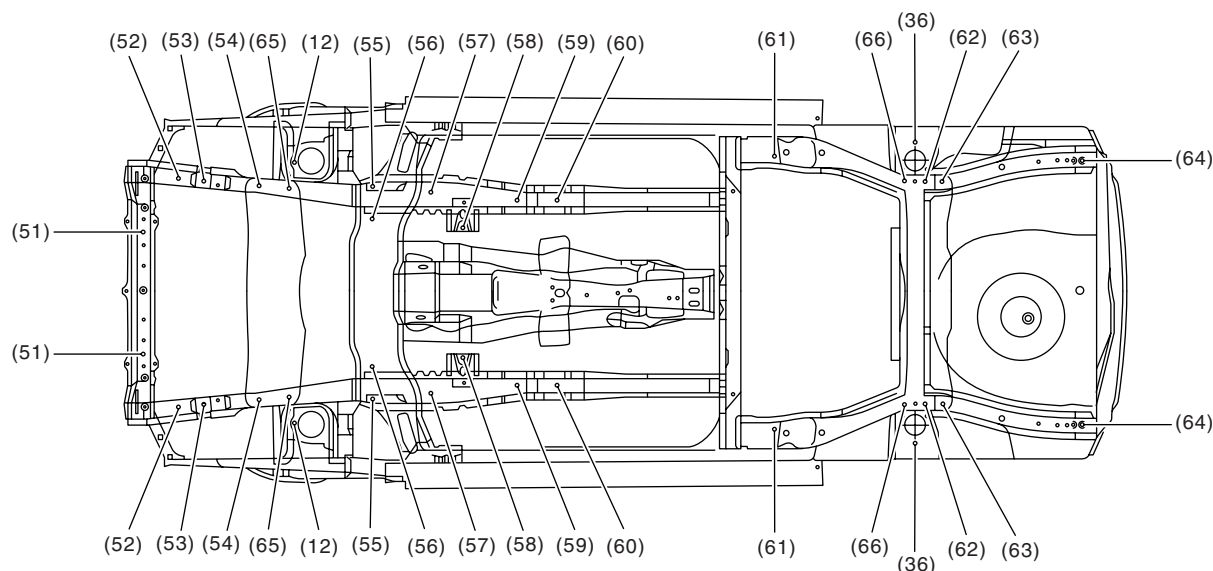
Body Reference Points



BS-00002

(18) Front weather strip mounting hole dia. 5.2 mm (0.20 in) (symmetrical)	(29) Trim mounting hole dia. 8.5 mm (0.33 in) (symmetrical)	(44) Harness mounting hole 7 x 7 mm (0.28 x 0.28 in) (symmetrical)
(19) Trim mounting hole dia. 7 mm (0.28 in) (symmetrical)	(31) Harness mounting hole dia. 7 mm (0.28 in) (symmetrical)	(45) Combination light mounting hole dia. 9.5 mm (0.37 in) (symmetrical)
(24) Trim mounting hole dia. 7 mm (0.28 in) (symmetrical)	(41) Harness mounting hole dia. 7.5 mm (0.30 in)	(46) Combination light mounting hole dia. 7 mm (0.28 in) (symmetrical)
(27) Front pillar gauge hole dia. 12 mm (0.47 in) (symmetrical)	(42) Bumper beam mounting hole dia. 12 mm (0.47 in)	(47) Combination light mounting hole 8 x 7mm (0.31x0.28in) (symmetrical)
(28) Insulator mounting hole dia. 8 mm (0.31 in) (symmetrical)	(43) Striker gauge hole dia. 5 mm (0.20 in) (symmetrical)	(48) Bumper bracket mounting hole dia. 7 mm (0.28 in) (symmetrical)

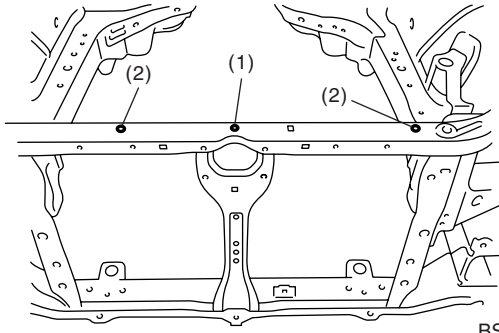
Body Reference Points



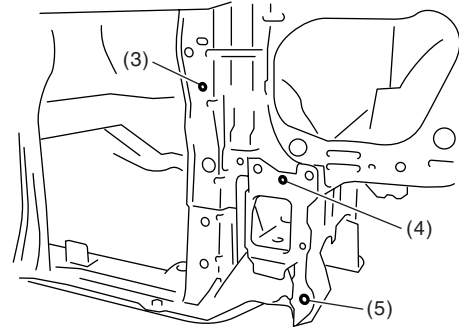
BS-00003

(12) Front strut mounting hole dia. 9.5 mm (0.37 in) (symmetrical)	(56) Transverse link mounting gauge hole dia. 17 mm (0.67 in) (symmetrical)	(62) Rear crossmember gauge hole dia. 16 mm (0.63 in) (symmetrical)
(36) Rear strut mounting hole dia. 10 mm (0.39 in) (symmetrical)	(57) Sub frame mounting hole dia. 16 mm (0.63 in) (symmetrical)	(63) Rear crossmember mounting hole dia. 12 mm (0.47 in) (symmetrical)
(51) Radiator lower frame gauge hole dia. 12 mm (0.47 in) (symmetrical)	(58) Transmission crossmember mounting hole dia. 14 mm (0.55 in) (symmetrical)	(64) Rear bumper beam mounting hole RH dia. 15 mm (0.57 in) LH 19 x 15 mm (0.75 x 0.59 in)
(52) Side frame gauge hole dia. 20 mm (0.79 in) (symmetrical)	(59) Rear side frame gauge hole dia. 15 mm (0.59 in) (symmetrical)	(65) Front crossmember mounting hole dia. 12.4 mm (0.49 in) (symmetrical)
(53) Sub frame mounting hole dia. 16 mm (0.63 in) (symmetrical)	(60) Rear side frame gauge hole dia. 18 mm (0.71 in) (symmetrical)	(66) Rear crossmember mounting hole dia. 16 mm (0.63 in) (symmetrical)
(54) Front crossmember mounting hole dia. 12.4 mm (0.49 in) (symmetrical)	(61) Rear differential mounting hole dia. 16 mm (0.63 in) (symmetrical)	
(55) Transverse link mounting hole dia. 16 mm (0.63 in) (symmetrical)		

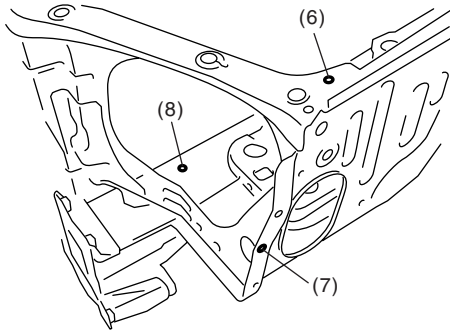
Body Reference Points



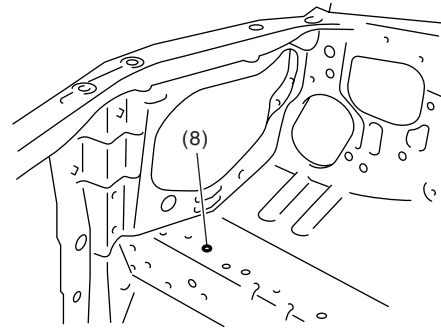
BS-00004



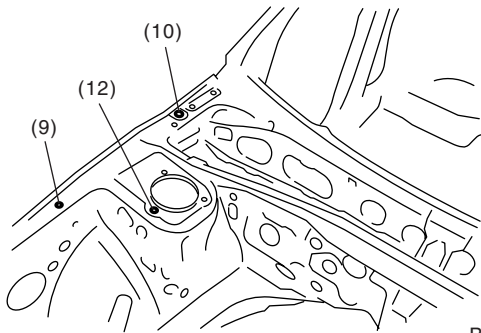
BS-00005



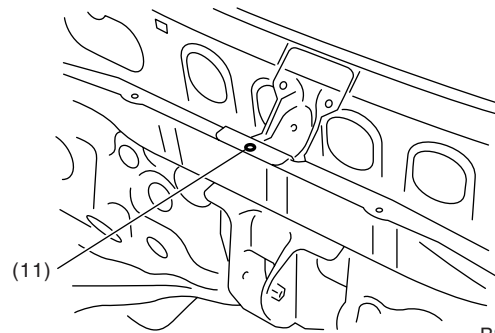
BS-00006



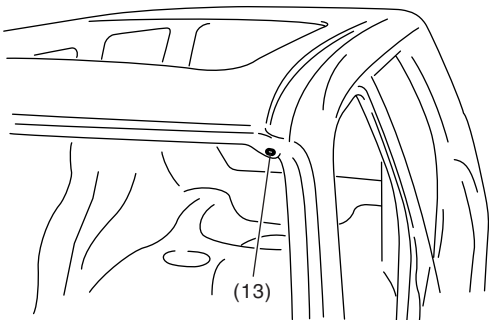
BS-00007



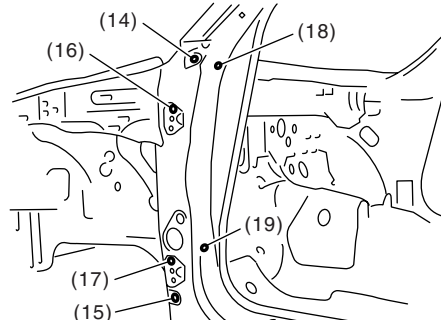
BS-00008



BS-00009

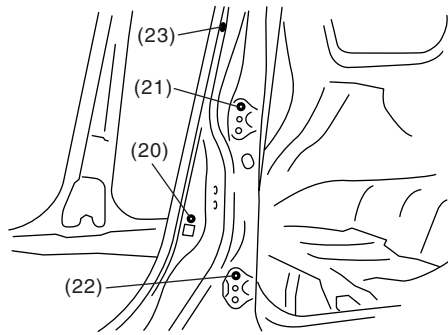


BS-00010

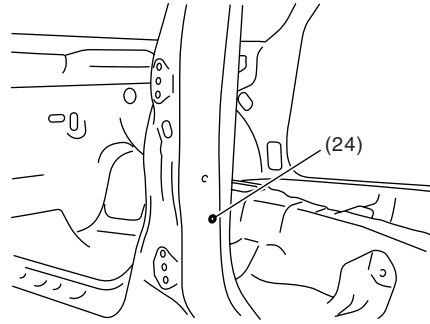


BS-00011

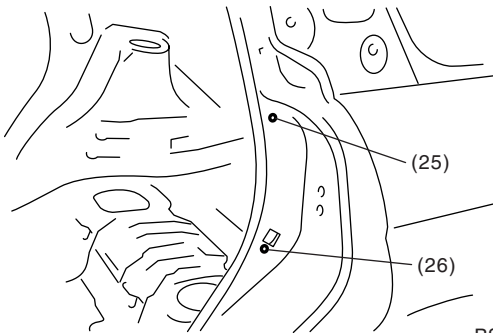
Body Reference Points



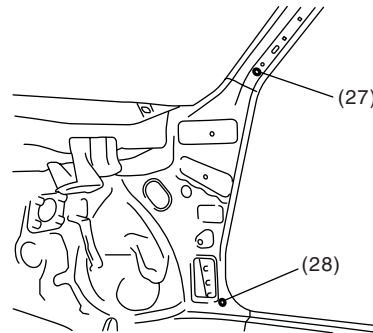
BS-00014



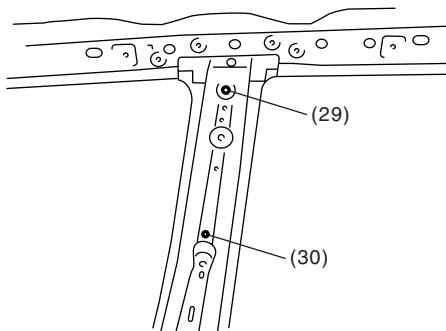
BS-00015



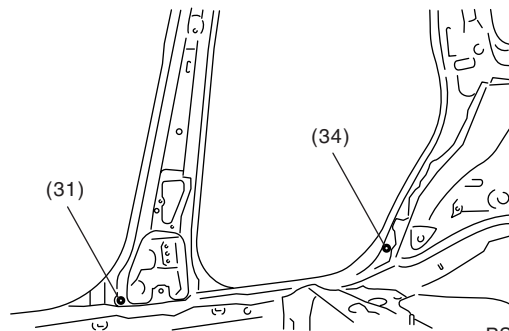
BS-00016



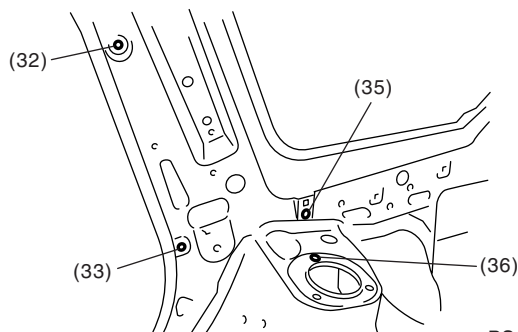
BS-00017



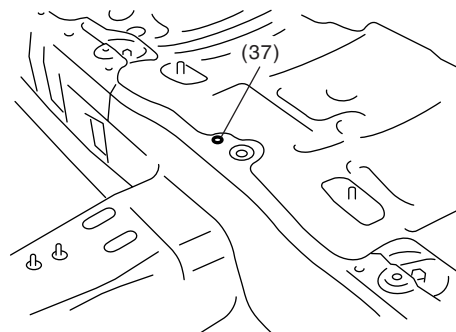
BS-00018



BS-00019

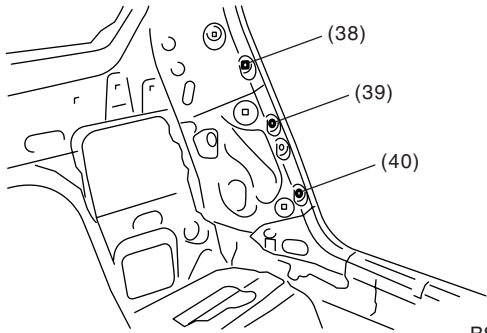


BS-00020

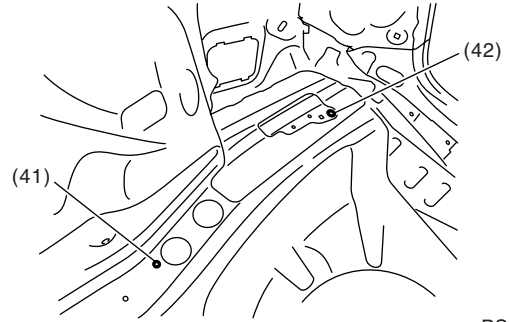


BS-00021

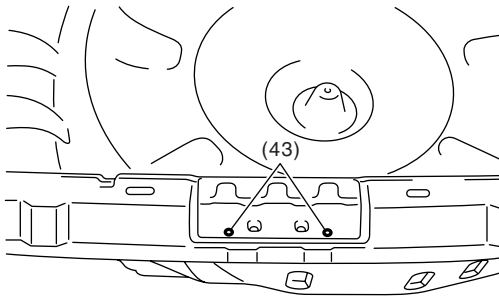
Body Reference Points



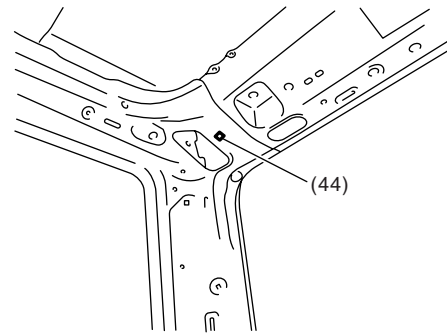
BS-00022



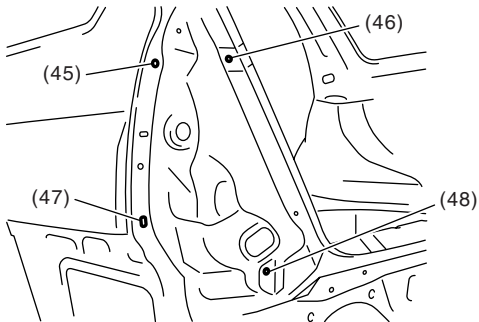
BS-00023



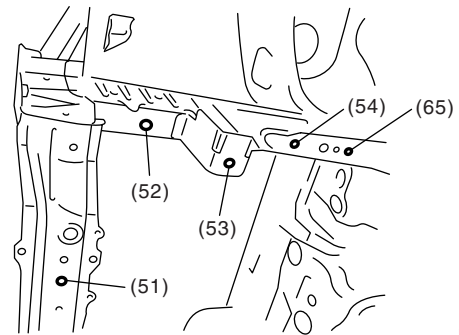
BS-00024



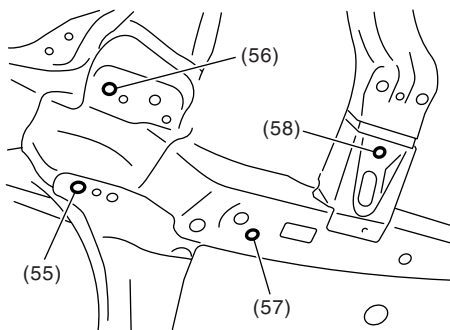
BS-00025



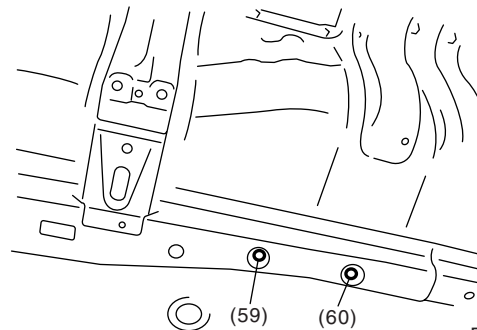
BS-00026



BS-00027

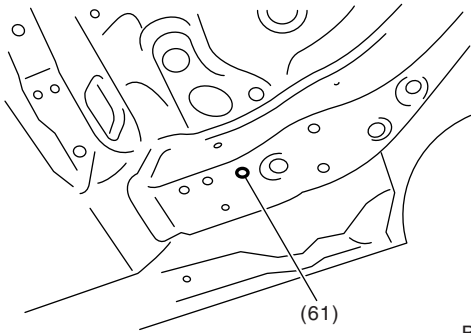


BS-00028

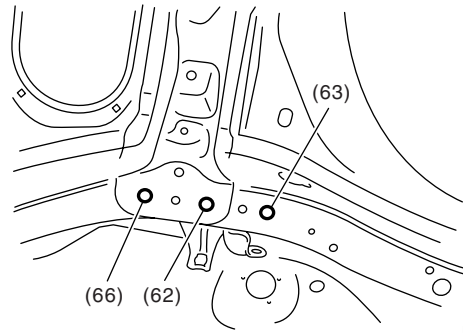


BS-00029

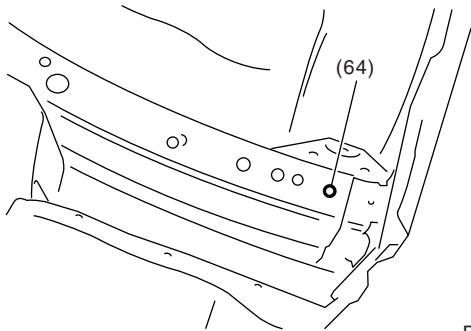
Body Reference Points



BS-00030



BS-00031



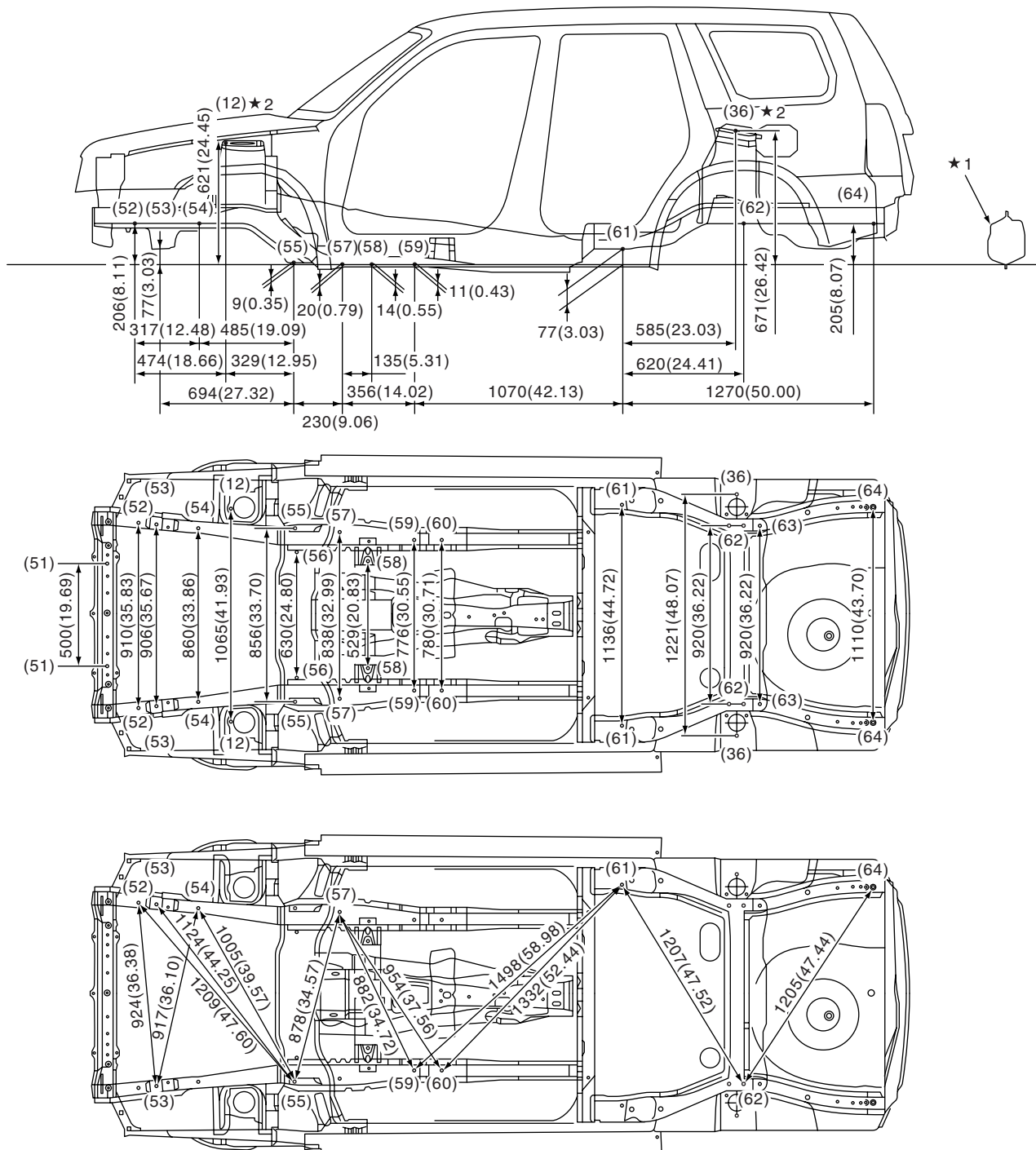
BS-00032

SUBARU.

Body Reference Points

B: DIMENSIONS

1. BOTTOM

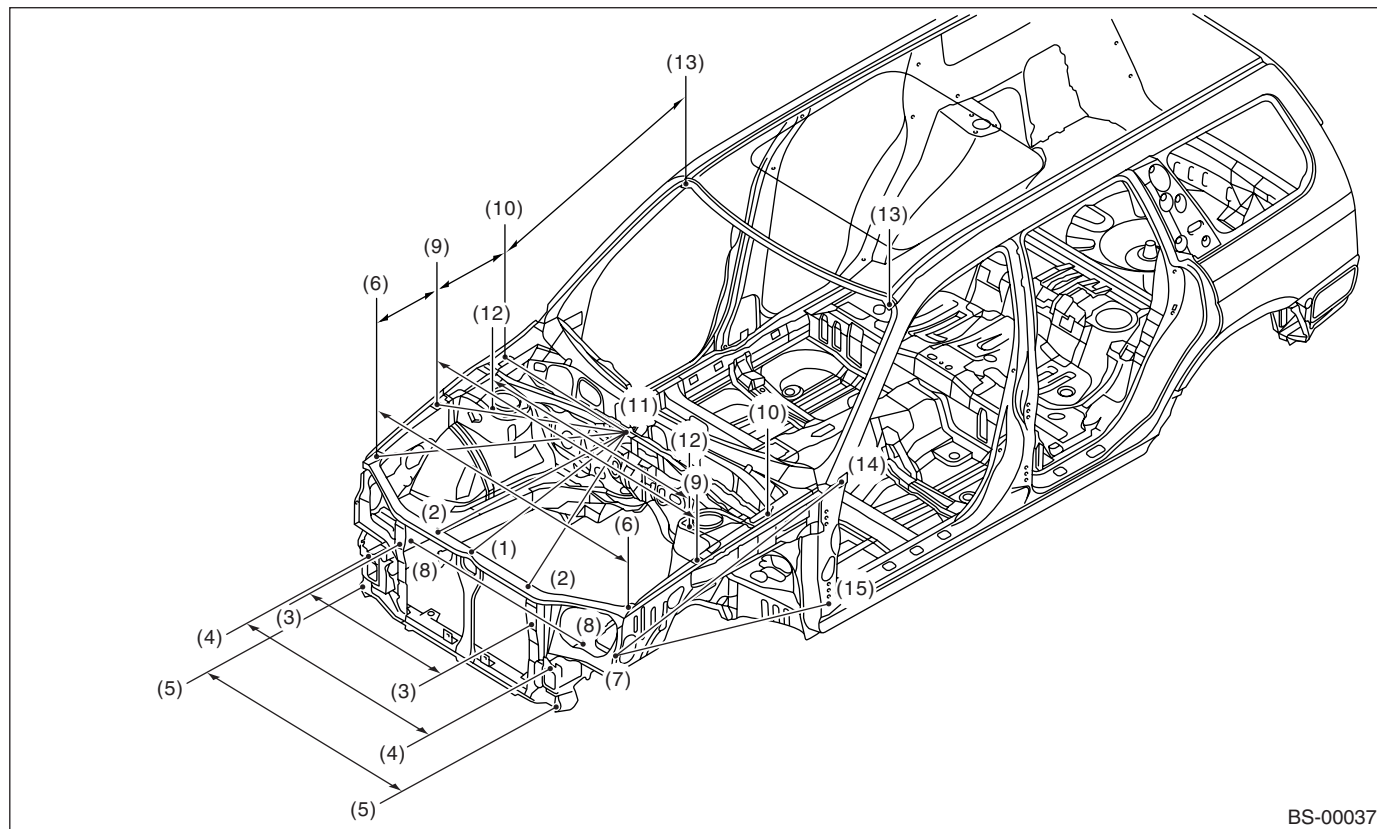


BS-00035

★1: Side sill
 ★2: Top
 Unit: mm (in)

Body Reference Points

2. FRONT

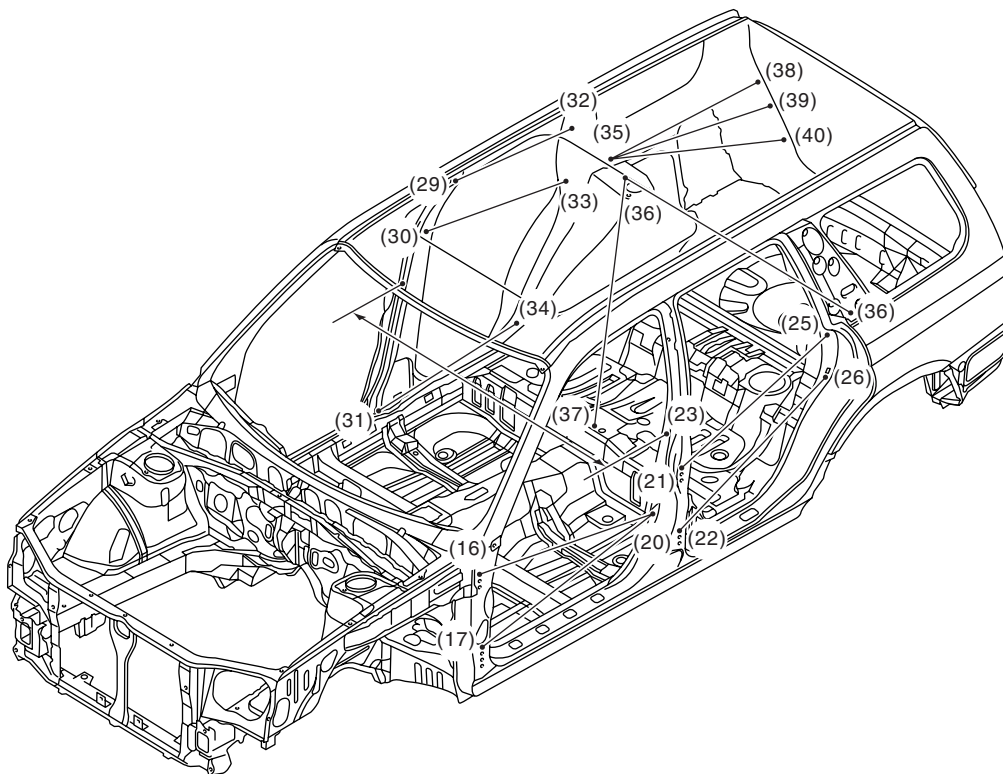


BS-00037

Unit: mm (in)

Measurement point	Datum dimension	Measurement point	Datum dimension
(1) — (11)	822 (32.36)	(7) LH — (15) LH	1,067 (42.01)
(2) RH — (11)	733 (28.86)	(8) RH — (8) LH	921 (36.26)
(2) LH — (11)	875 (34.45)	(9) RH — (9) LH	1,396 (54.96)
(3) RH — (3) LH	716 (28.19)	(9) RH — (10) RH	398 (15.67)
(4) RH — (4) LH	978 (38.50)	(9) LH — (10) LH	398 (15.67)
(5) RH — (5) LH	1,046 (41.89)	(9) RH — (11)	767 (30.20)
(6) RH — (6) LH	1,341 (52.80)	(9) LH — (11)	767 (30.20)
(6) RH — (9) RH	349 (13.74)	(10) RH — (11)	722 (28.43)
(6) LH — (9) LH	349 (13.74)	(10) LH — (11)	722 (28.43)
(6) RH — (11)	944 (37.17)	(10) RH — (13) RH	907 (35.71)
(6) LH — (11)	944 (37.17)	(10) LH — (13) LH	907 (35.71)
(7) RH — (14) RH	1,155 (45.47)	(11) — (12) RH	565 (22.24)
(7) LH — (14) LH	1,155 (45.47)	(11) — (12) LH	565 (22.24)
(7) RH — (15) RH	1,067 (42.01)	(12) RH — (12) LH	1,065 (41.93)

Body Reference Points



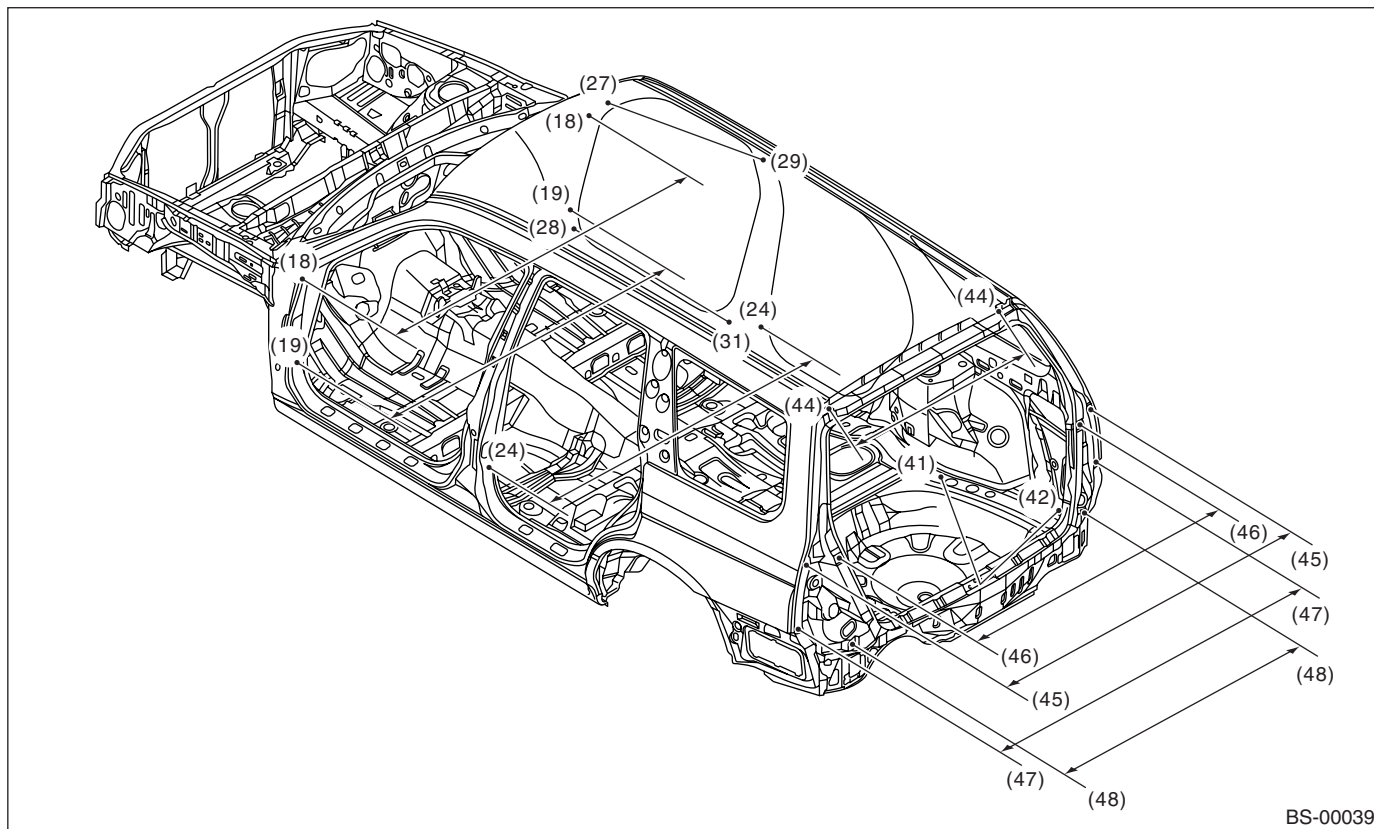
BS-00038

Unit: mm (in)

Measurement point	Datum dimension	Measurement point	Datum dimension
(16) RH — (20) RH	980 (38.58)	(30) LH — (33) LH	796 (31.34)
(16) LH — (20) LH	980 (38.58)	(31) RH — (34) RH	759 (29.88)
(17) RH — (20) RH	982 (38.66)	(31) LH — (34) LH	759 (29.88)
(17) LH — (20) LH	982 (38.66)	(35) RH — (38) RH	665 (26.18)
(21) RH — (25) RH	853 (33.58)	(35) LH — (38) LH	665 (26.18)
(21) LH — (25) LH	853 (33.58)	(35) RH — (39) RH	711 (27.99)
(22) RH — (26) RH	895 (35.24)	(35) LH — (39) LH	711 (27.99)
(22) LH — (26) LH	895 (35.24)	(35) RH — (40) RH	784 (30.87)
(23) LH — (23) RH	1,429 (56.26)	(35) LH — (40) LH	784 (30.87)
(29) RH — (32) RH	674 (26.54)	(36) LH — (36) RH	1,221 (48.07)
(29) LH — (32) LH	674 (26.54)	(36) RH — (37) RH	1,067 (42.01)
(30) RH — (33) RH	796 (31.34)	(36) LH — (37) LH	1,067 (42.01)

Body Reference Points

3. REAR AND INSIDE OF COMPARTMENT



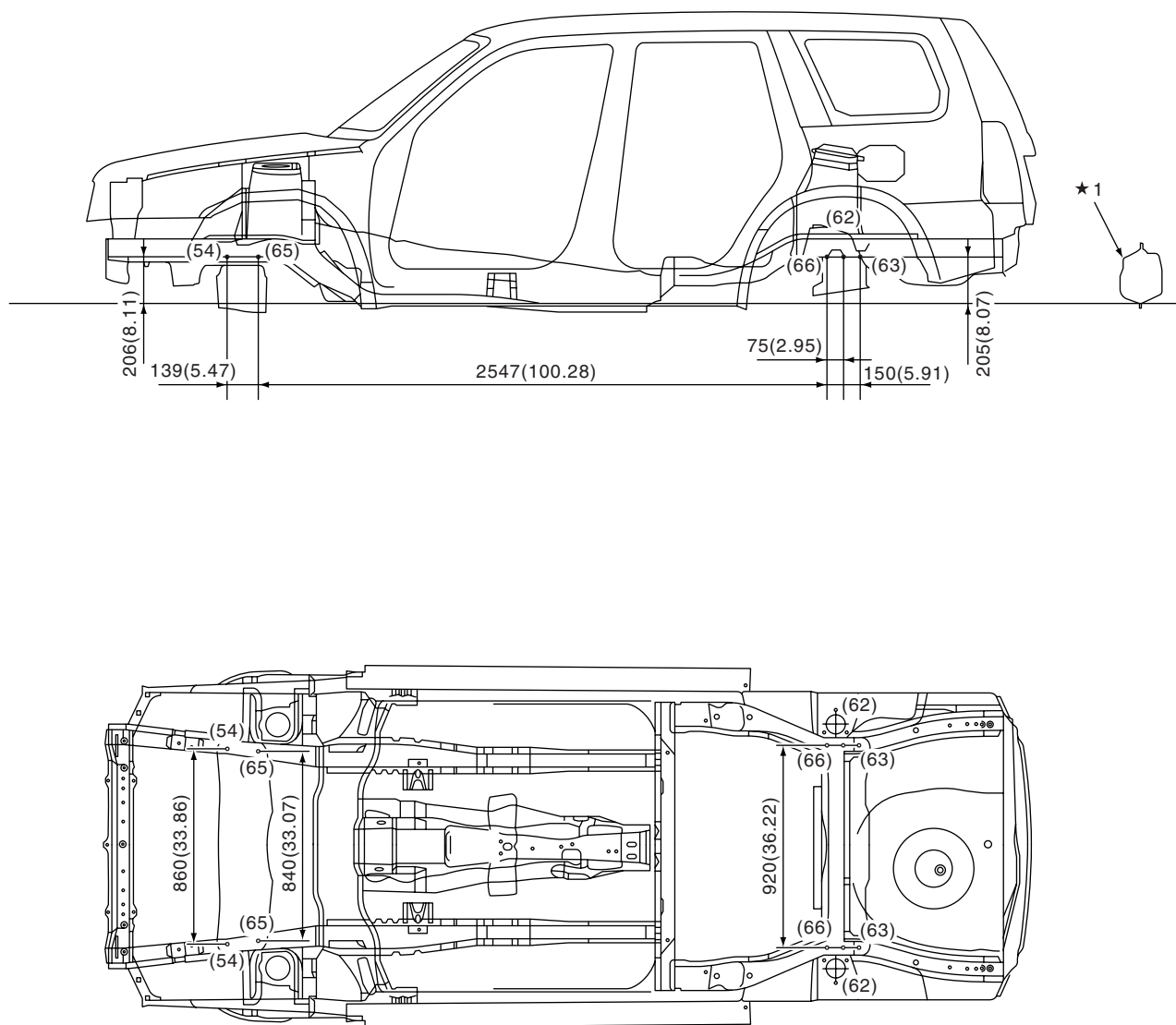
BS-00039

Unit: mm (in)

Measurement point	Datum dimension	Measurement point	Datum dimension
(18) RH — (18) LH	1,449 (57.05)	(41) RH — (43) RH	794 (31.26)
(19) RH — (19) LH	1,459 (57.44)	(41) LH — (43) LH	805 (31.69)
(27) RH — (29) RH	1,438 (56.61)	(42) RH — (42) LH	1,110 (43.70)
(27) LH — (29) LH	1,438 (56.61)	(44) RH — (44) LH	878 (34.57)
(28) RH — (31) RH	1,007 (39.65)	(45) RH — (45) LH	1,474 (58.03)
(28) LH — (31) LH	1,007 (39.65)	(46) RH — (46) LH	1,252 (49.29)
(24) RH — (24) LH	813 (32.01)	(47) RH — (47) LH	1,552 (61.10)
(41) RH — (41) LH	950 (37.40)	(48) RH — (48) LH	1,210 (47.64)

Body Reference Points

4. SUSPENSION MOUNT



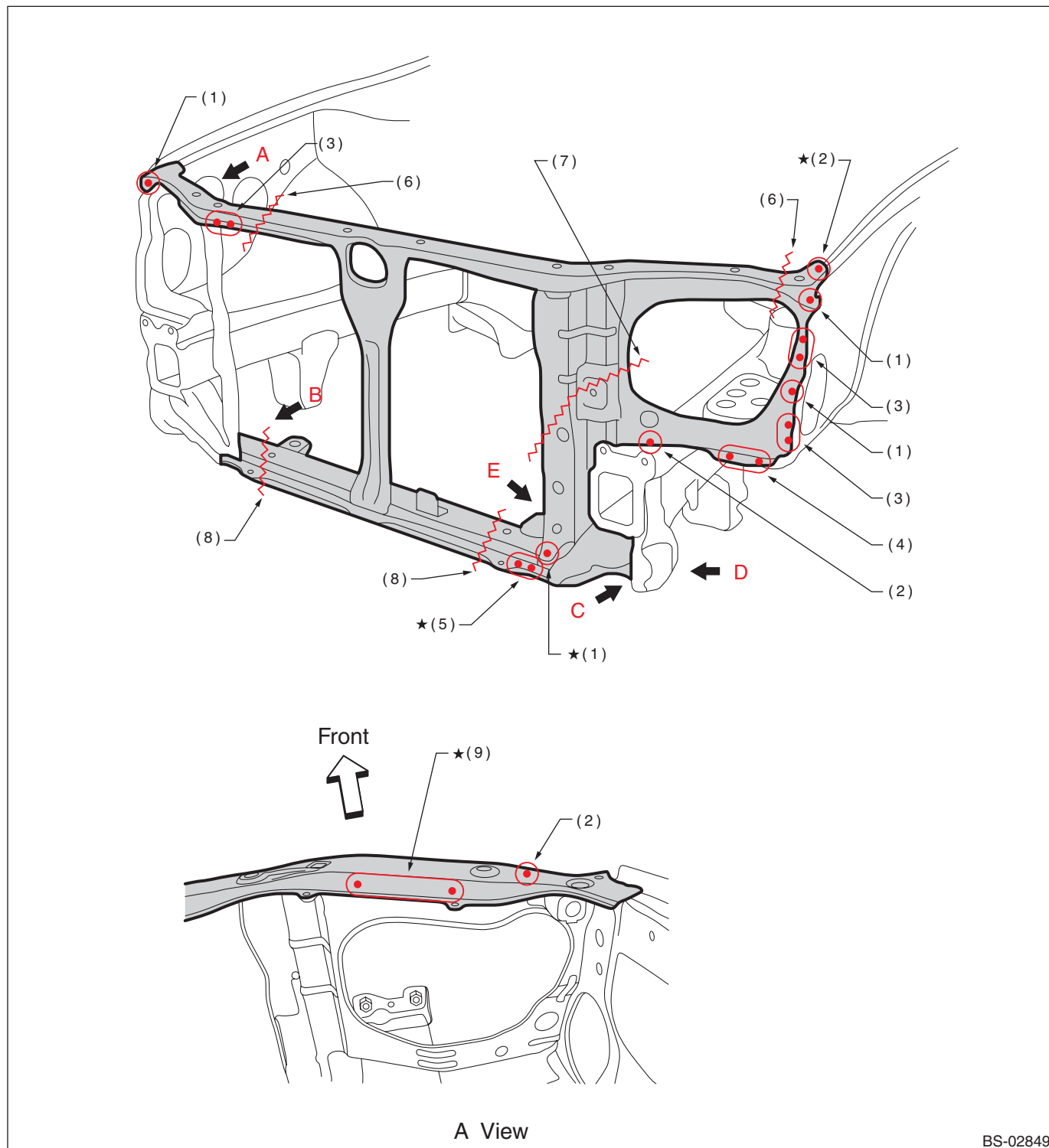
BS-00036

★1: Side sill
Unit: mm (in)

Radiator Panel (Total Replacement)

12.Radiator Panel (Total Replacement)

A: REMOVAL



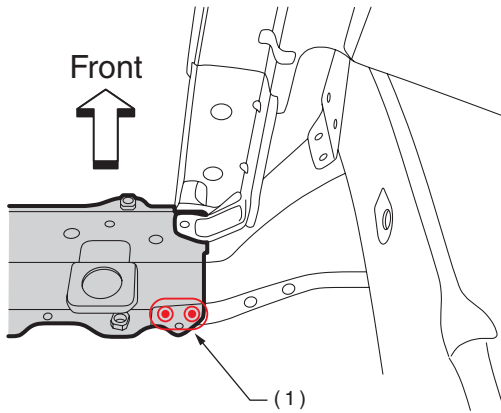
BS-02849

- | | | |
|----------------------------|------------------------------------|--------------------------------------|
| (1) 1 point (outside · 1) | (4) 3 points (top · 1) | (7) Rough cutting (130 mm) (5.1 in) |
| (2) 1 point (top · 1) | (5) 2 points (top · 1, bottom · 1) | (8) Rough cutting (260 mm) (10.2 in) |
| (3) 2 points (outside · 1) | (6) Rough cutting (80 mm) (3.1 in) | (9) 3 points (inside · 1) |

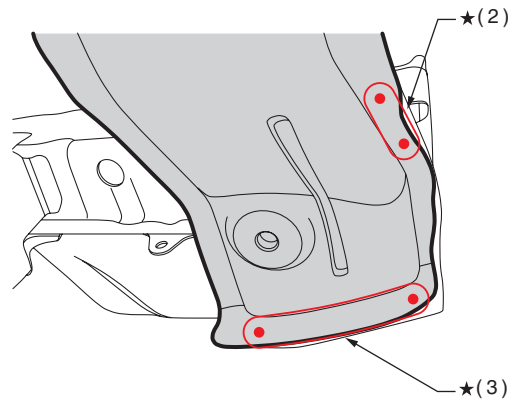
NOTE:

For locations marked by ★, the welding method, the number of welding points, and the rough cutting dimensions are the same on the left and the right.

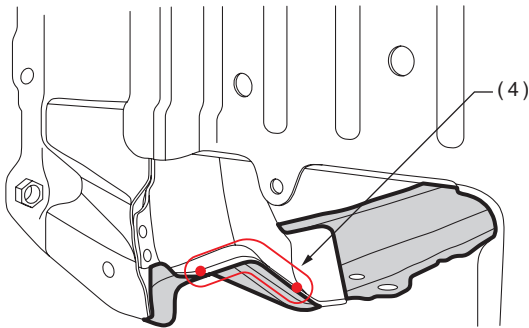
Radiator Panel (Total Replacement)



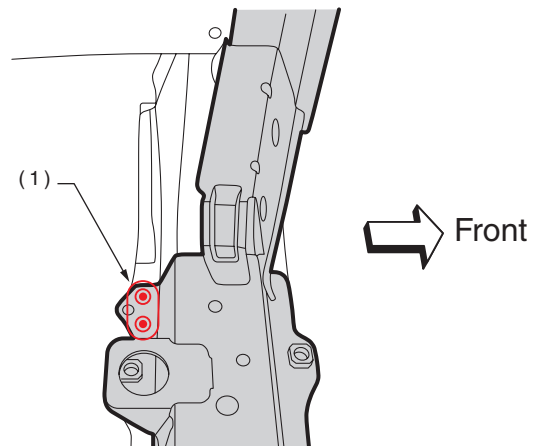
B View



C View



D View



E View

BS-02850

(1) 2 points (top · 1, bottom · 1)

(2) 2 points (bottom · 1)

(3) 4 points (inside · 1)

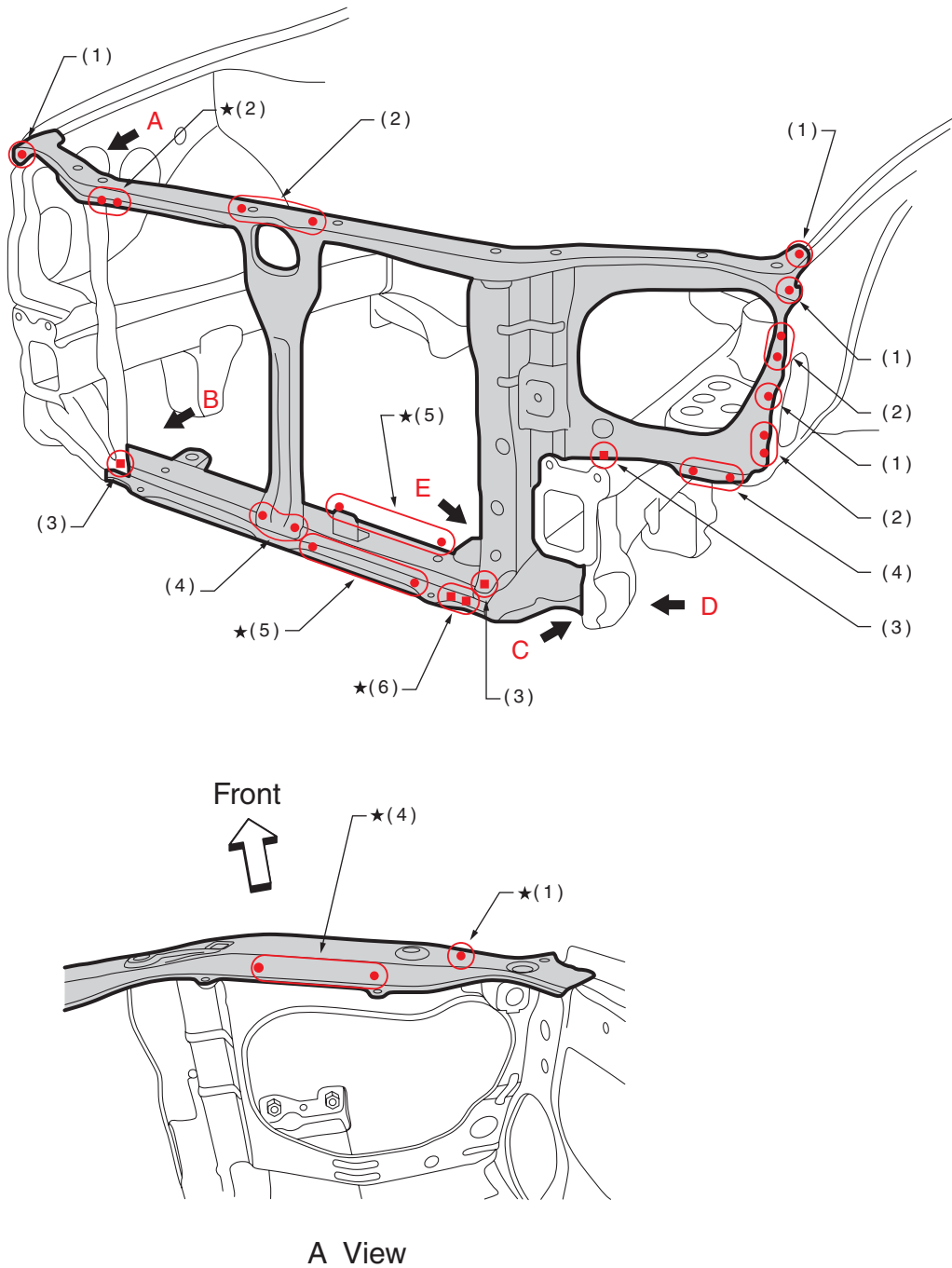
(4) 4 points (bottom · 1)

NOTE:

For locations marked by ★, the welding method, the number of welding points, and the rough cutting dimensions are the same on the left and the right.

Radiator Panel (Total Replacement)

B: INSTALLATION



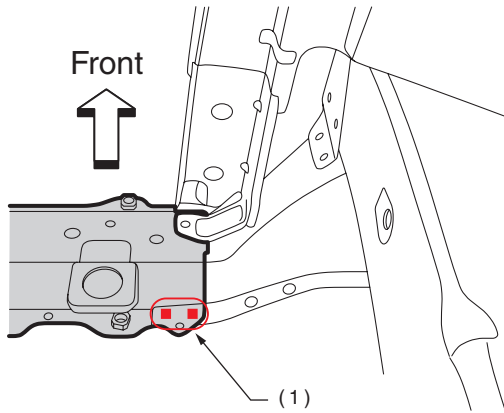
BS-02851

- | | | |
|--------------|-----------------------|--|
| (1) 1 point | (3) 1 point (service) | (5) 5 points |
| (2) 2 points | (4) 4 points | (6) 2 points (service · both surface plug) |

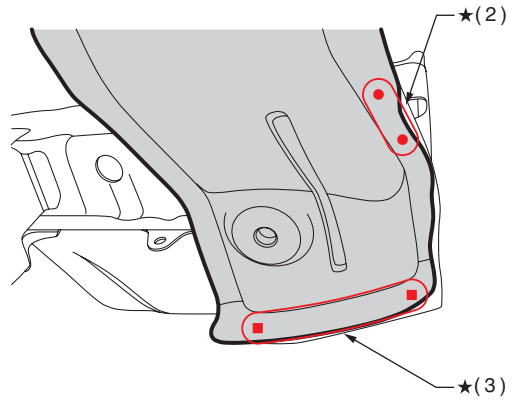
NOTE:

For locations marked by ★, the welding method, the number of welding points, and the dimensions are the same on the left and the right.

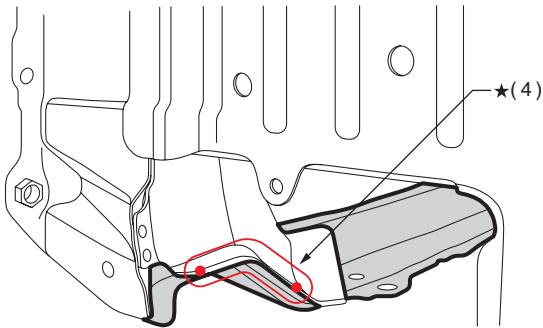
Radiator Panel (Total Replacement)



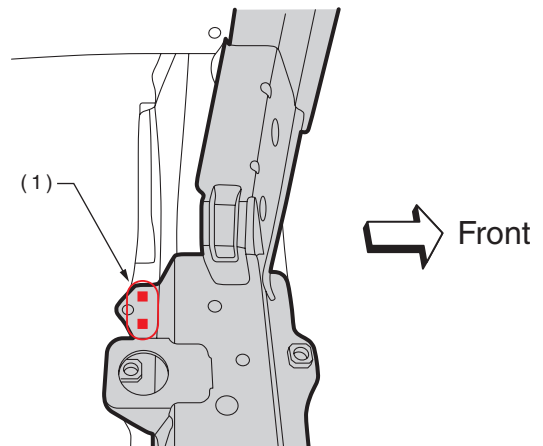
B View



C View



D View



E View

BS-02852

- (1) 2 points (service · both surface plug) (2) 3 points
(3) 4 points (service)

- (4) 5 points

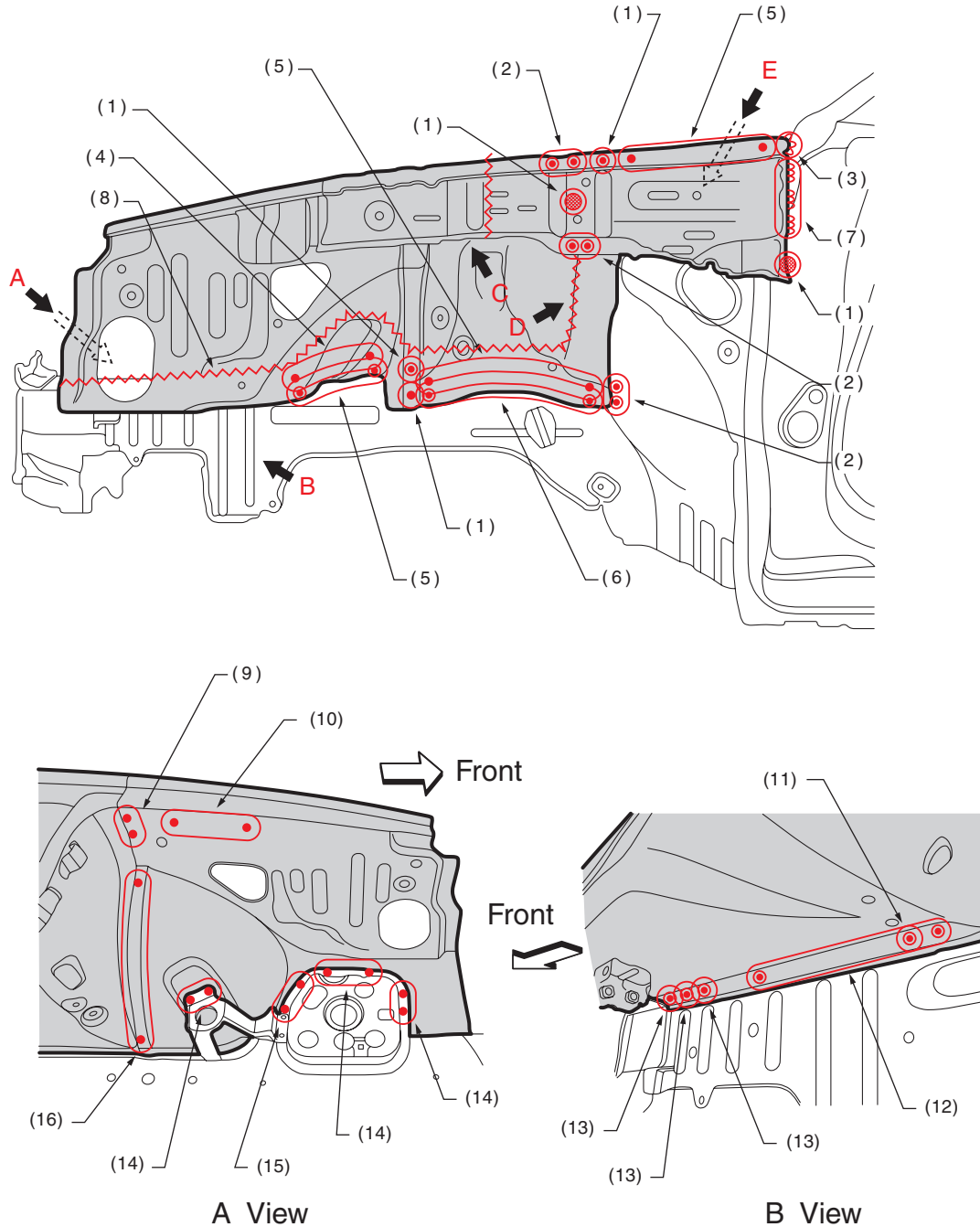
NOTE:

For locations marked by ★, the welding method, the number of welding points, and the rough cutting dimensions are the same on the left and the right.

Front Wheel Apron (Total Replacement)

13. Front Wheel Apron (Total Replacement)

A: REMOVAL



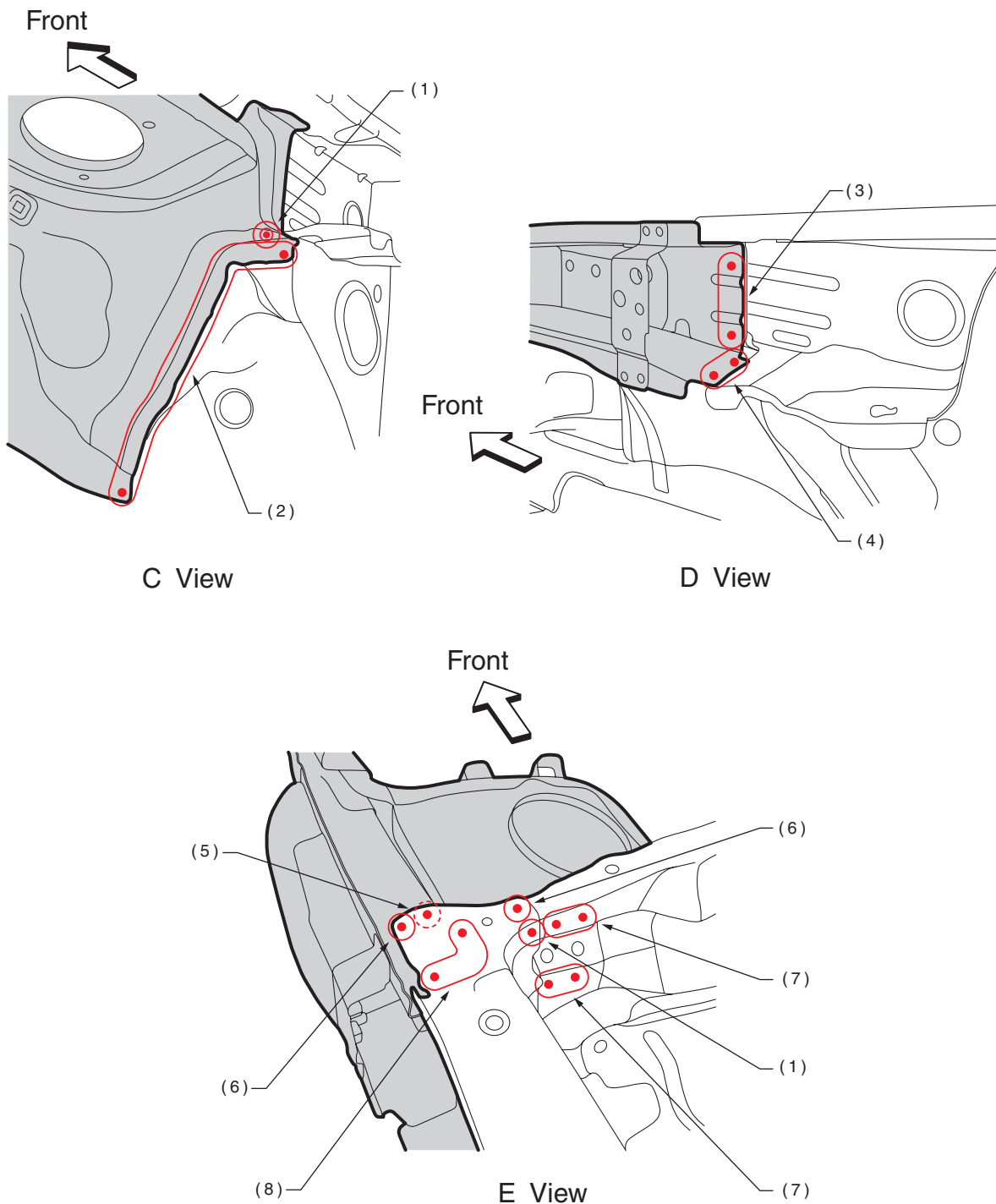
BS-03419

- | | | |
|--|---|----------------------------|
| (1) 1 point (outside · 1) | (7) 3 points (outside · 1, belt sander) | (12) 5 points (bottom · 1) |
| (2) 2 points (outside · 1) | (8) Rough cutting (1700 mm) (66.9 in) | (13) 1 point (bottom · 1) |
| (3) 1 point (outside · 1, belt sander) | (9) 2 points (inside · 1) | (14) 2 points (top · 1) |
| (4) 4 points (outside · 1) | (10) 4 points (inside · 1) | (15) 3 points (top · 1) |
| (5) 5 points (outside · 1) | (11) Temporary 1 point (bottom · 1) | (16) 5 points (top · 1) |
| (6) 6 points (outside · 1) | | |

Front Wheel Apron (Total Replacement)

NOTE:

The illustration indicates the removal condition of the radiator panel.



BS-02746

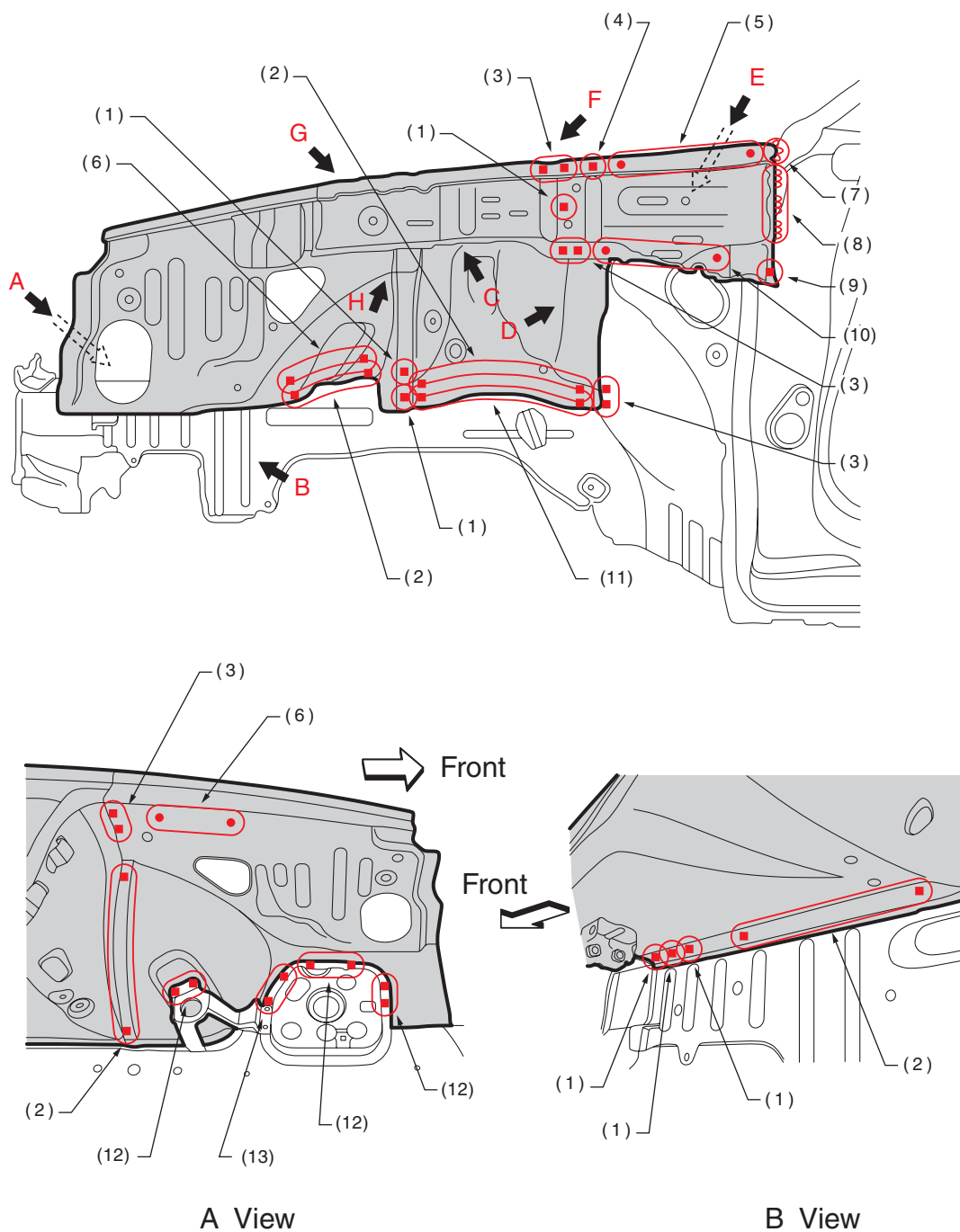
- (1) 1 point (inside · 1)
- (2) 11 points (inside · 1)
- (3) 3 points (outside · 1)
- (4) 4 points (bottom · 1)

- (5) 1 point (top · 1)
- hidden hit point (suspension bracket and front duct)

- (6) 1 point (top · 1)
- (7) 2 points (top · 1)
- (8) 3 points (top · 1)

Front Wheel Apron (Total Replacement)

B: INSTALLATION



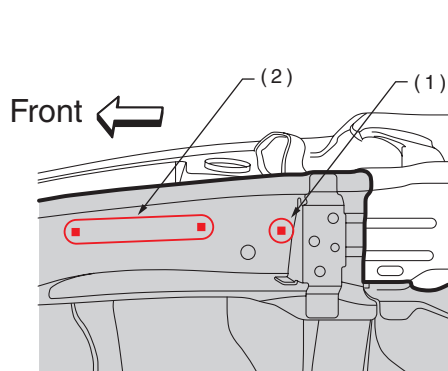
BS-02854

- | | | |
|----------------------------------|--|-------------------------|
| (1) 1 point (service) | (6) 4 points (service) | (10) 7 points |
| (2) 5 points (service) | (7) 1 point (20 mm x 1) (0.79 in x 1) | (11) 6 points (service) |
| (3) 2 points (service) | (8) 3 points (20 mm x 1) (0.79 in x 1) | (12) 2 points |
| (4) 1 point (service · matching) | (9) 1 point | (13) 3 points |
| (5) 6 points | | |

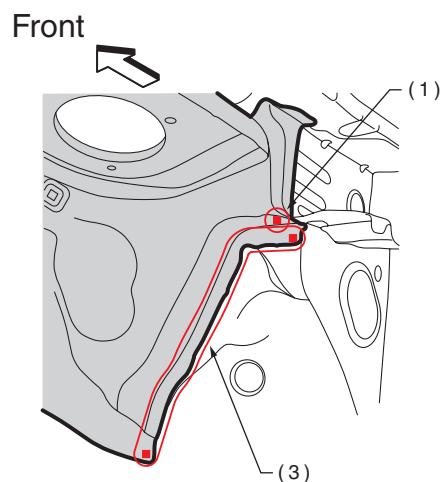
NOTE:

The illustration indicates the removal condition of the radiator panel.

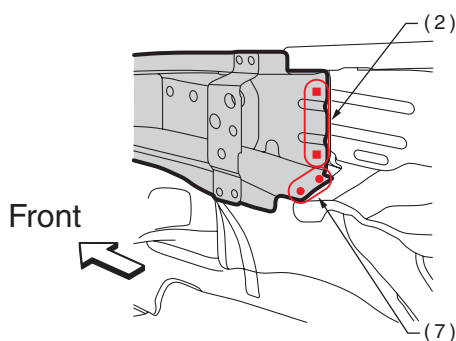
Front Wheel Apron (Total Replacement)



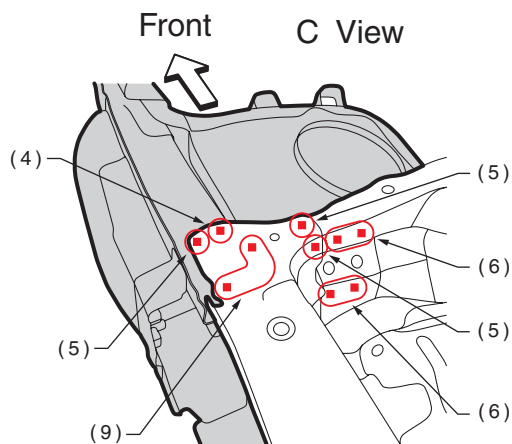
F View



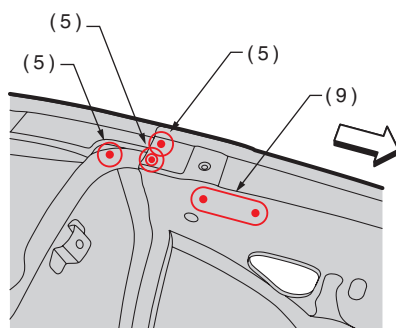
C View



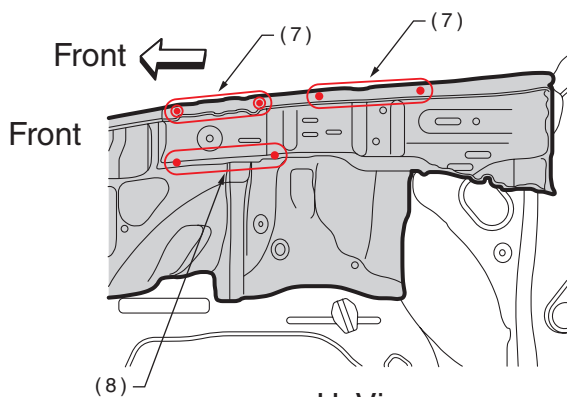
D View



E View



G View



H View

BS-02748

(1) 1 point (service · matching)

(2) 3 points (service)

(3) 11 points (service)

(4) 1 point (service), hidden hit point

(5) 1 point

(6) 2 points

(7) 5 points

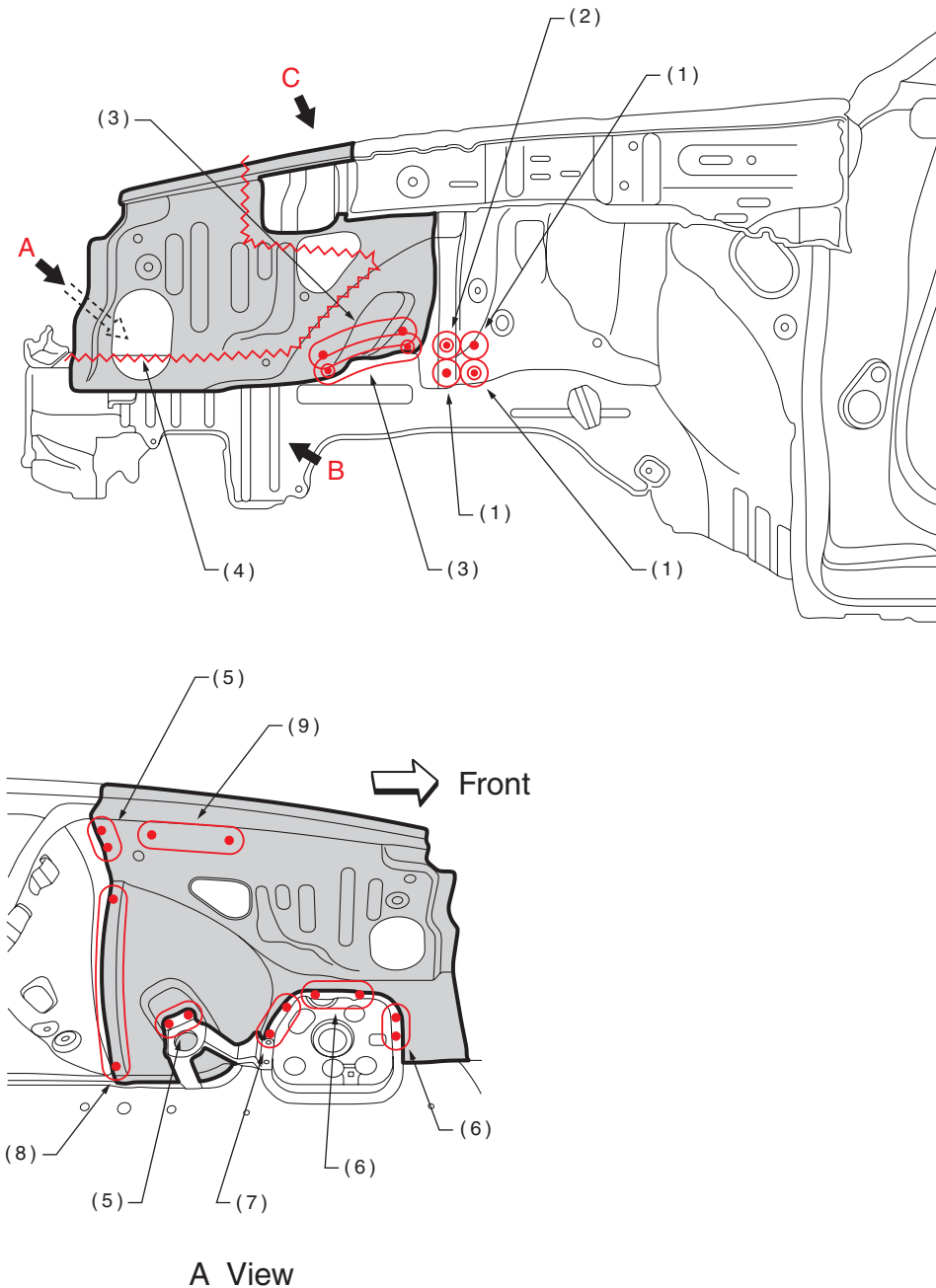
(8) 8 points

(9) 3 points

Front Wheel Apron Front (Total Replacement)

14.Front Wheel Apron Front (Total Replacement)

A: REMOVAL



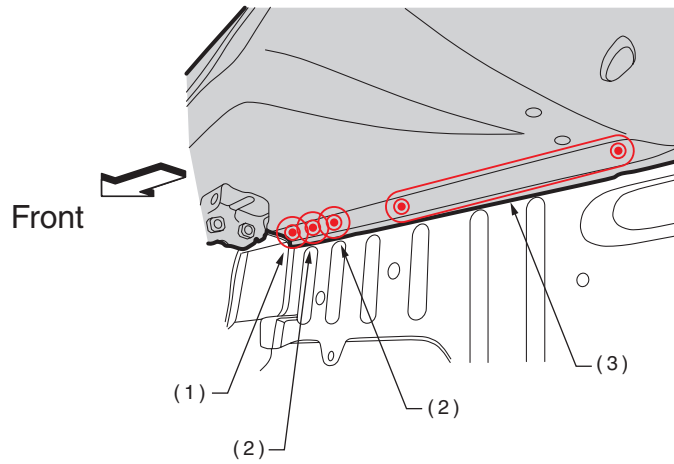
BS-02855

- | | | |
|----------------------------|---------------------------------------|---------------------------|
| (1) 1 point (outside · 1) | (4) Rough cutting (1100 mm) (43.3 in) | (7) 3 points (top · 1) |
| (2) 1 point (outside · 2) | (5) 2 points (inside · 1) | (8) 5 points (inside · 1) |
| (3) 4 points (outside · 1) | (6) 2 points (top · 1) | (9) 4 points (inside · 1) |

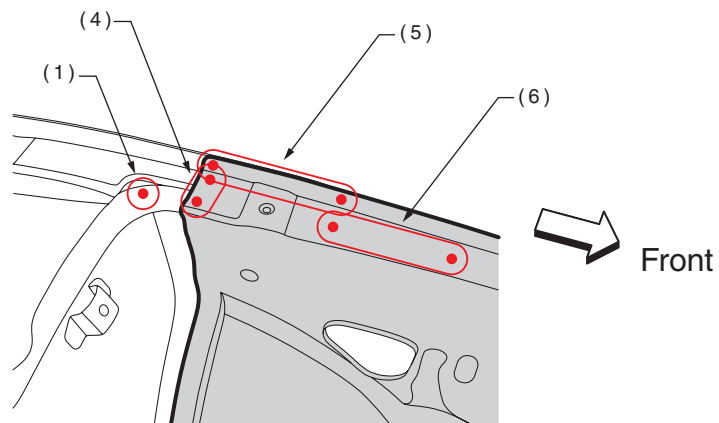
NOTE:

The illustration indicates the removal condition of the radiator panel.

Front Wheel Apron Front (Total Replacement)



B View



C View

BS-02750

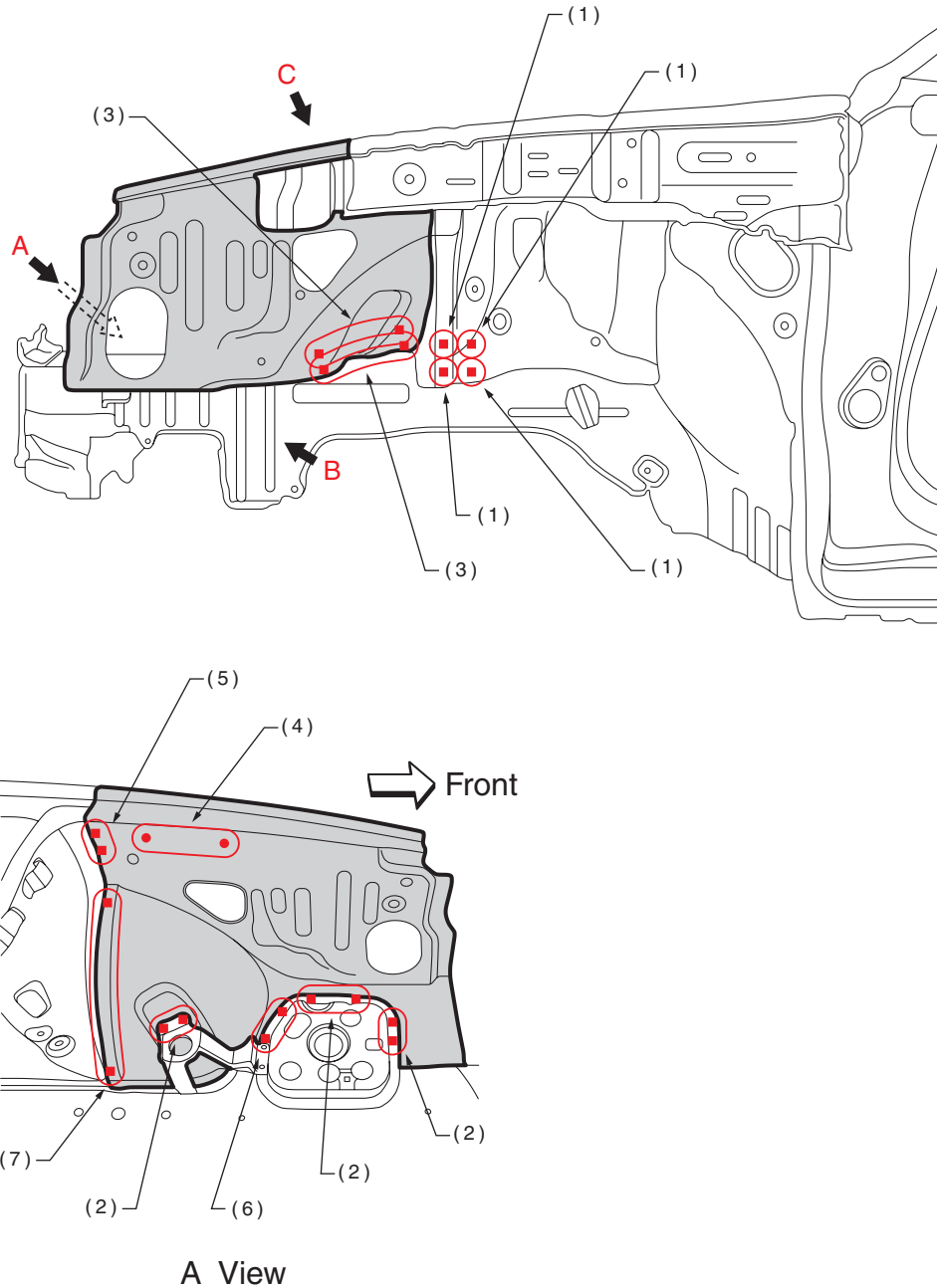
- (1) 1 point (top · 1)
- (2) 1 point (bottom · 1)

- (3) 4 points (bottom · 1)
- (4) 2 points (top · 1)

- (5) 4 points (inside · 1)
- (6) 3 points (top · 1)

Front Wheel Apron Front (Total Replacement)

B: INSTALLATION



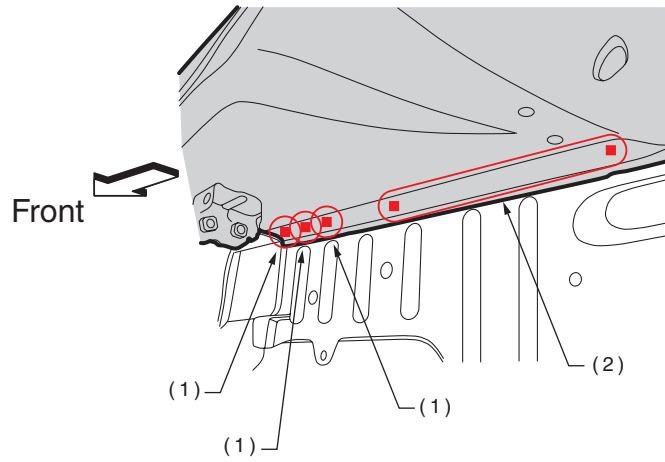
BS-02856

- | | | |
|------------------------|------------------------|------------------------|
| (1) 1 point | (4) 4 points | (6) 3 points |
| (2) 2 points | (5) 2 points (service) | (7) 5 points (service) |
| (3) 4 points (service) | | |

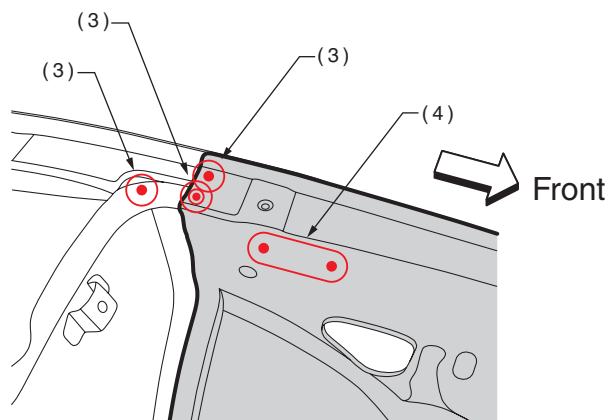
NOTE:

The illustration indicates the removal condition of the radiator panel.

Front Wheel Apron Front (Total Replacement)



B View



C View

BS-02752

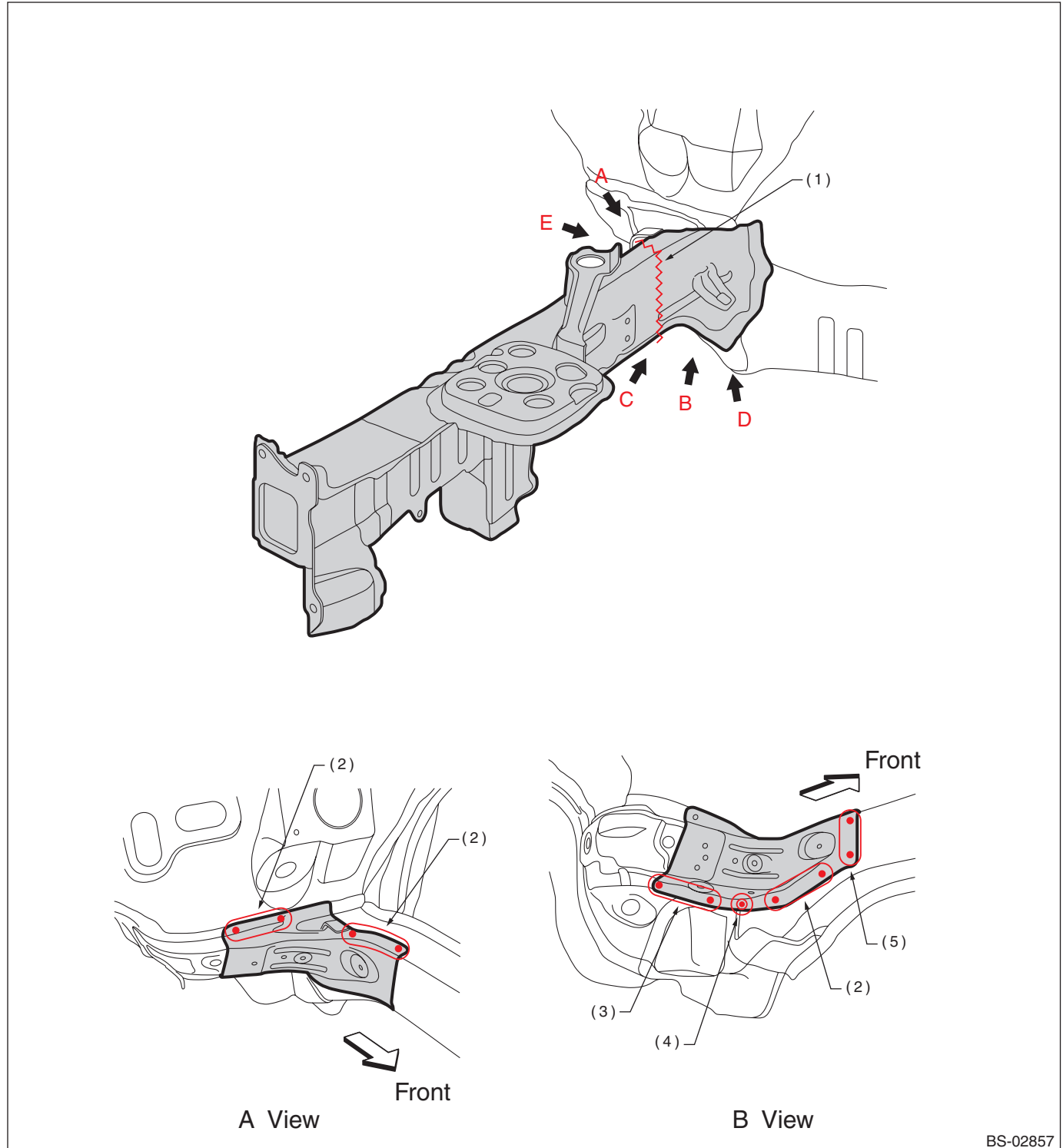
- (1) 1 point (service)
- (2) 5 points (service)

- (3) 1 point

- (4) 3 points

15.Frame Side Front (Total Replacement)

A: REMOVAL



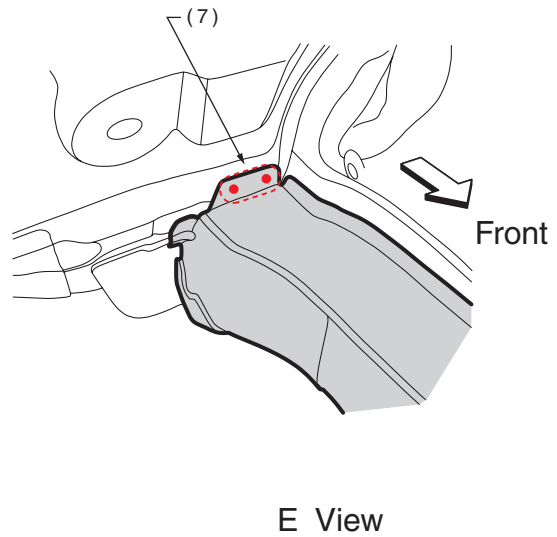
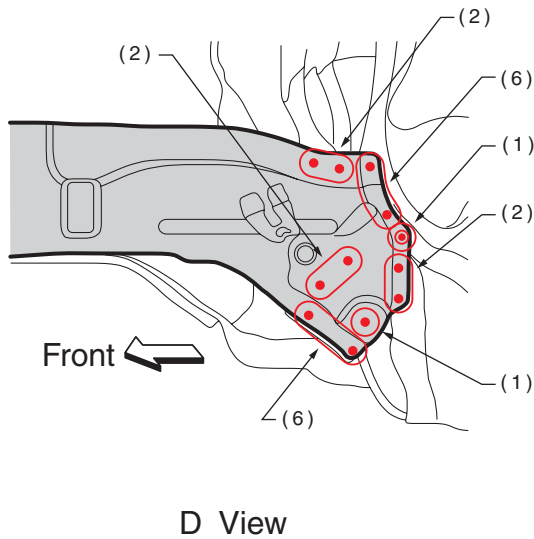
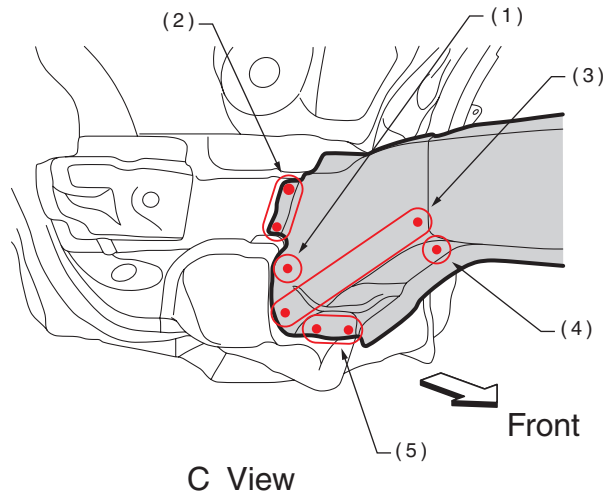
BS-02857

- | | | |
|-------------------------------------|---------------------------|----------------------------|
| (1) Rough cutting (250 mm) (9.8 in) | (3) 3 points (bottom · 1) | (5) 2 points (outside · 1) |
| (2) 3 points (outside · 1) | (4) 1 point (outside · 2) | |

NOTE:

The illustration indicates the removal condition of the radiator panel and front wheel apron.

Frame Side Front (Total Replacement)

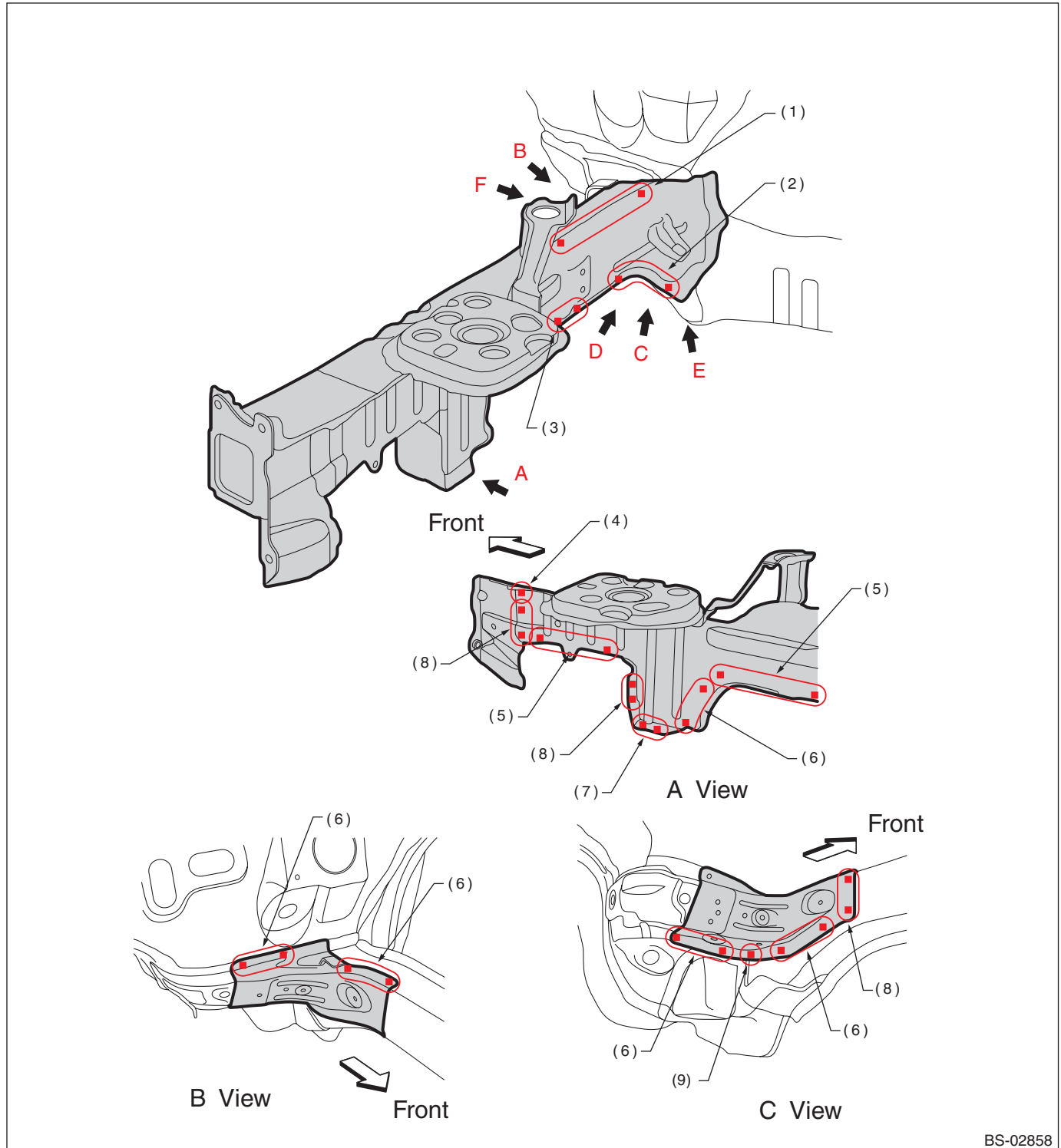


BS-02754

- | | | |
|----------------------------|---------------------------|----------------------------|
| (1) 1 point (outside · 1) | (4) 1 point (bottom · 1) | (6) 3 points (outside · 1) |
| (2) 2 points (outside · 1) | (5) 2 points (bottom · 1) | (7) 2 points (inside · 1) |
| (3) 4 points (outside · 1) | | |

Frame Side Front (Total Replacement)

B: INSTALLATION



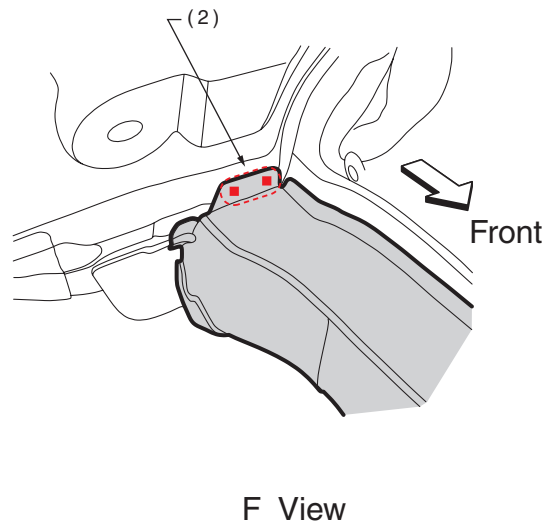
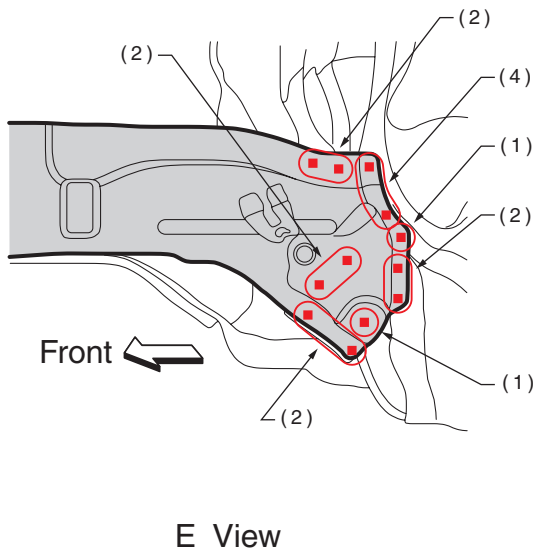
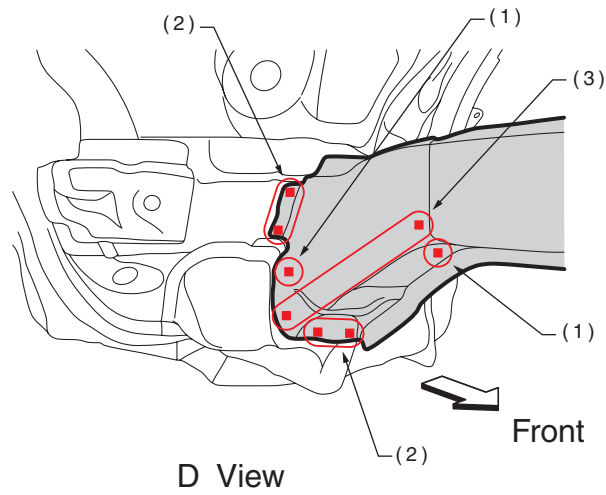
BS-02858

- | | | |
|--|---|--|
| (1) 8 points (service) | (4) 1 point (service · both surface plug) | (7) 3 points (service · both surface plug) |
| (2) 6 points (service) | (5) 4 points (service) | (8) 2 points (service) |
| (3) 3 points (service · both surface plug) | (6) 3 points (service) | (9) 1 point (service · matching) |

NOTE:

The illustration indicates the removal condition of the radiator panel and front wheel apron.

Frame Side Front (Total Replacement)



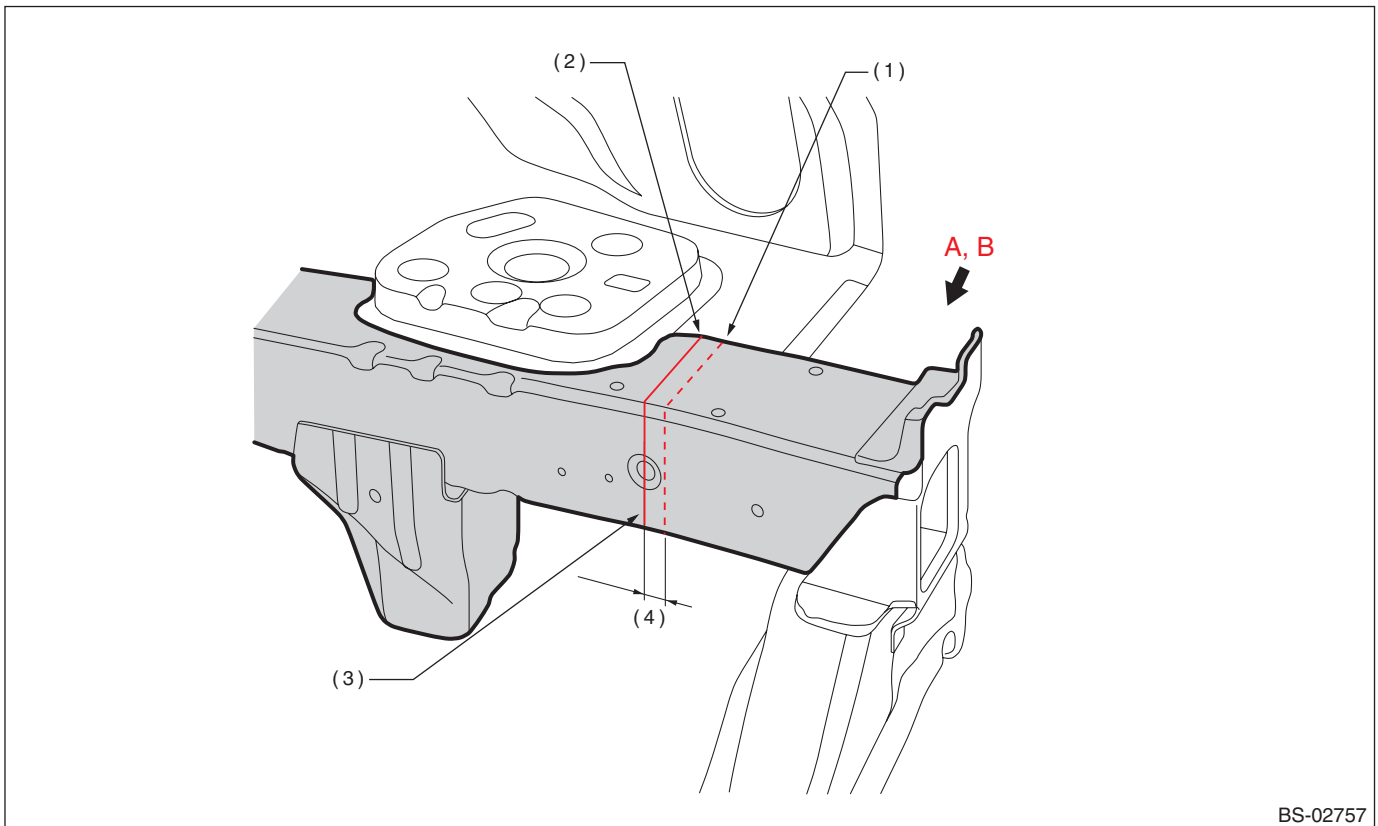
BS-02756

- (1) 1 point (service)
- (2) 2 points (service)

- (3) 4 points (service)

- (4) 3 points (service)

16.Front Frame (Partial Replacement)



(1) Reinforcement position
(2) Front frame cut position

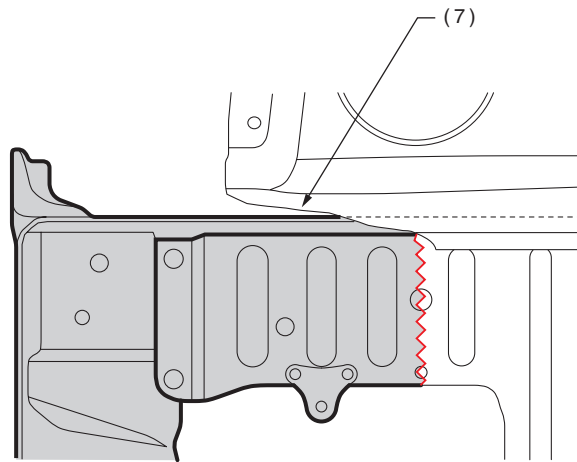
(3) Gauge hole A dia. 12 mm (0.47 in) (4) 10 mm (0.39 in)
(hole center)

NOTE:

To make half cutting easier, cut the front frame and reinforcement into stepped shape and butt-weld them.

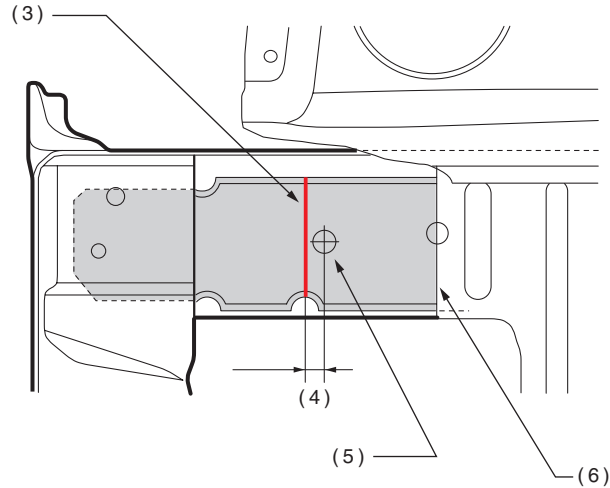
Front Frame (Partial Replacement)

(1)



A View

(2)



B View

BS-02758

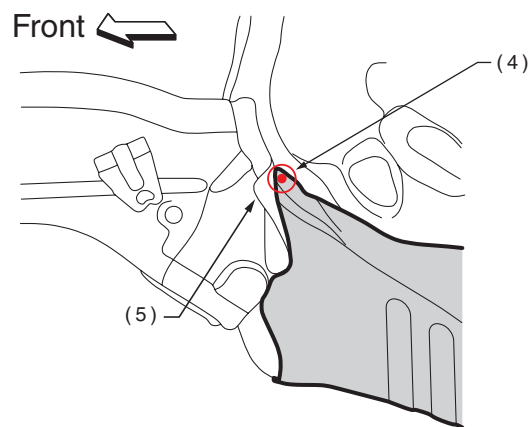
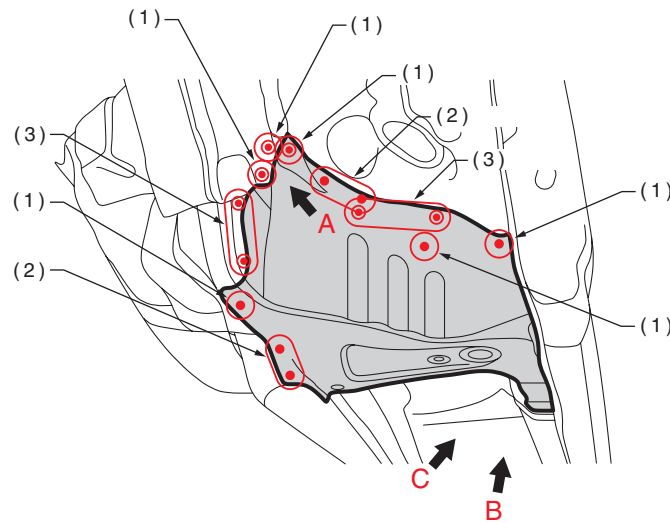
- | | | |
|--|--|--|
| (1) Closing plate cut | (4) 10 mm (0.39 in) | (7) Lift a part of the front wheel apron to make it easier to cut the closing plate. |
| (2) Reinforcement cut | (5) Gauge hole A dia. 12 mm (0.47 in) | |
| (3) Reinforcement cut position (hole center) | (6) Closing plate cut position (hole center) | |

NOTE:

Closing plate can be reused if necessary.

17.Reinforcement Toe Board (Total Replacement)

A: REMOVAL



A View

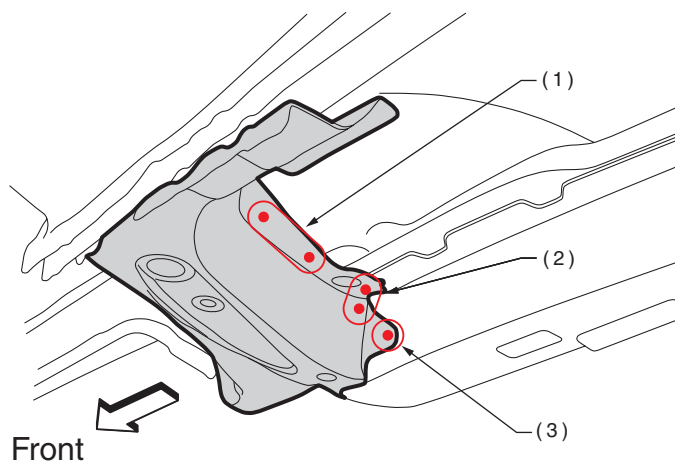
BS-02859

- (1) 1 point (outside · 1)
- (2) 2 points (outside · 1)

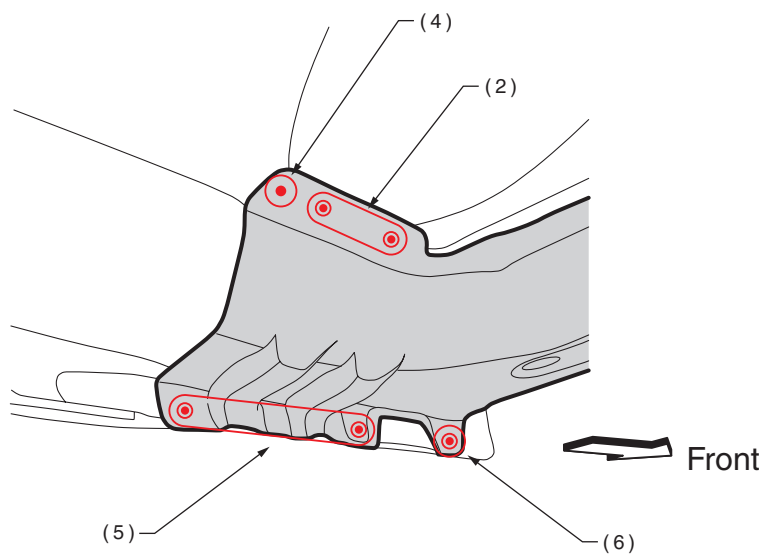
- (3) 3 points (outside · 1)
- (4) 1 point (outside · 1), hidden hit point

- (5) Closing plate is lifted

Reinforcement Toe Board (Total Replacement)



B View



C View

BS-02760

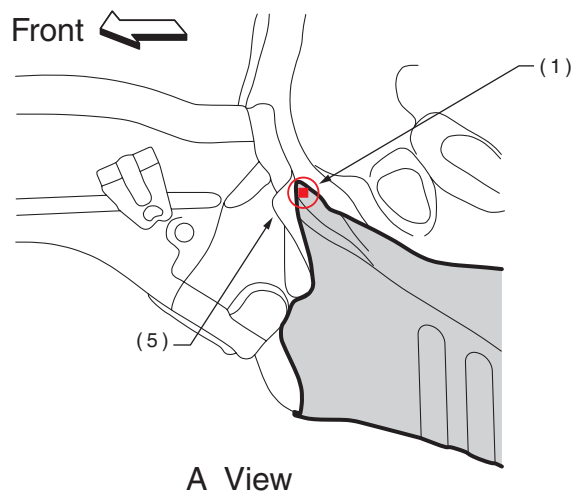
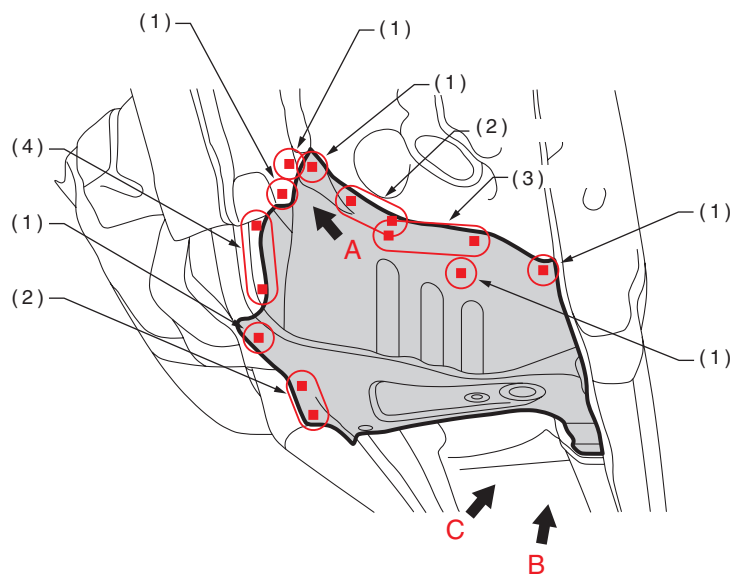
(1) 3 points (bottom · 1)
(2) 2 points (bottom · 1)

(3) 1 point (outside · 1)
(4) 1 point (bottom · 1)

(5) 6 points (inside · 1)
(6) 1 point (inside · 1)

Reinforcement Toe Board (Total Replacement)

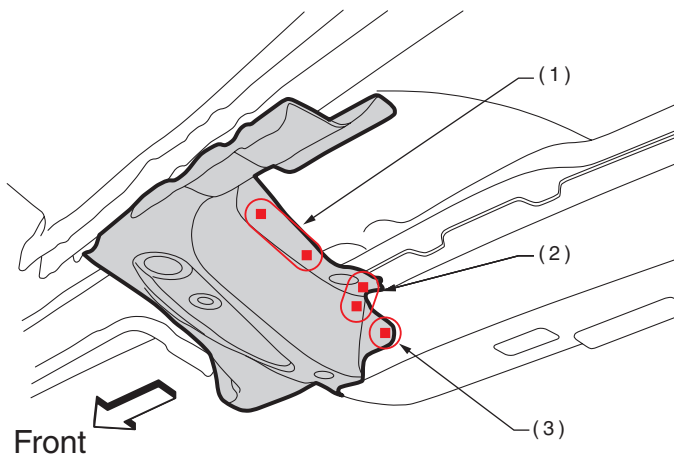
B: INSTALLATION



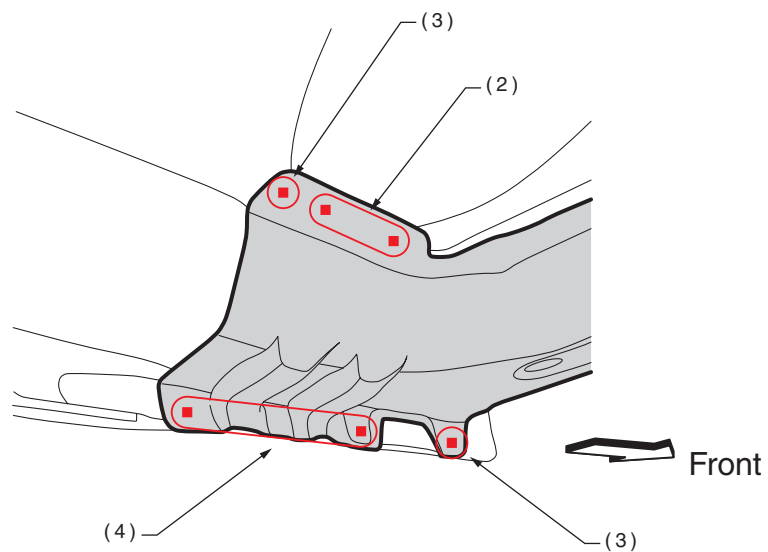
BS-02860

- | | | |
|------------------------|-----------------------------------|-----------------------------|
| (1) 1 point (service) | (3) 3 points (service) | (5) Closing plate is lifted |
| (2) 2 points (service) | (4) 3 points (service · matching) | |

Reinforcement Toe Board (Total Replacement)



B View



C View

BS-02861

(1) 3 points (service)
(2) 2 points (service)

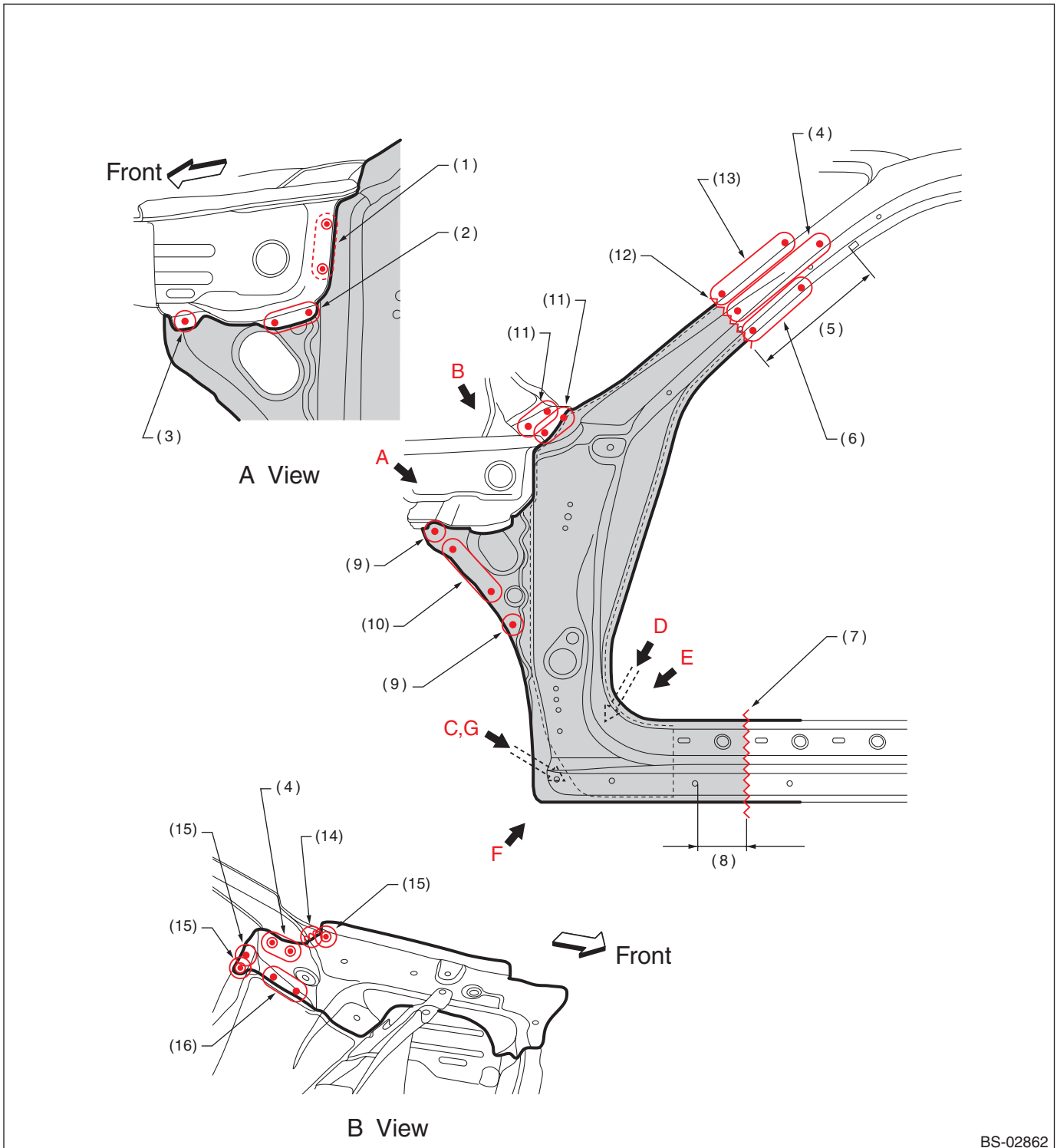
(3) 1 point (service)

(4) 6 points (service)

Front Pillar (Partial Replacement)

18. Front Pillar (Partial Replacement)

A: REMOVAL



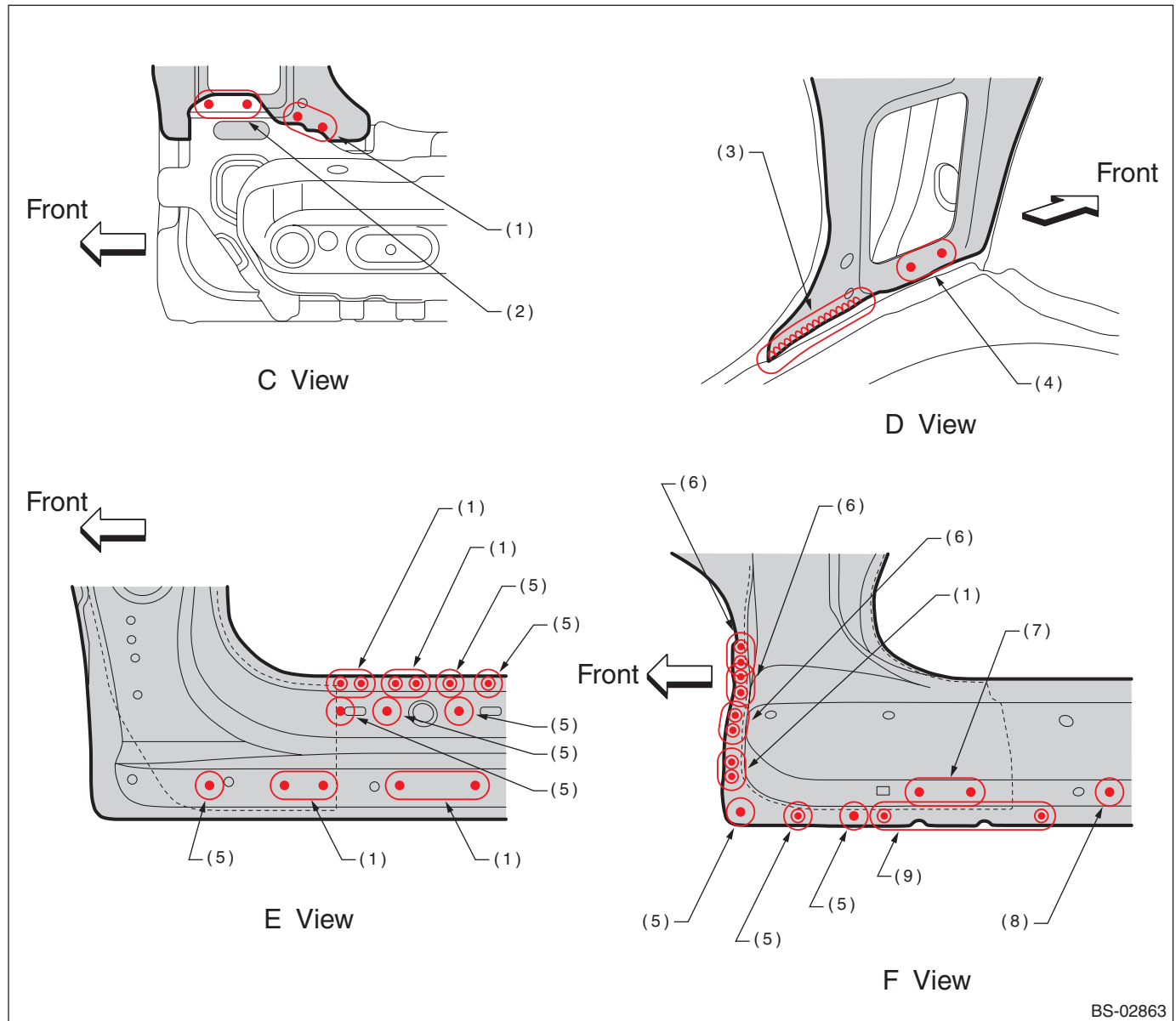
BS-02862

- | | | |
|---------------------------------|-------------------------------------|---|
| (1) 2 points (inside · through) | (7) Rough cutting (220 mm) (8.7 in) | (12) Rough cutting (370 mm) (14.6 in) |
| (2) 3 points (bottom · 1) | (8) 70 mm (2.8 in) | (13) 5 points (outside · 1) |
| (3) 1 point (bottom · 1) | (9) 1 point (outside · 1) | (14) 1 point (outside · 1, belt sander) |
| (4) 4 points (outside · 1) | (10) 5 points (outside · 1) | (15) 1 point (top · 1) |
| (5) 250 mm (9.8 in) | (11) 2 points (top · 1) | (16) 2 points (outside · 1) |
| (6) 6 points (outside · 1) | | |

Front Pillar (Partial Replacement)

NOTE:

The illustration indicates the removal condition of the frame side upper.

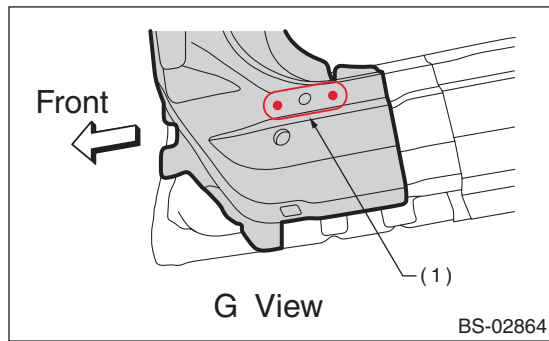


- | | | |
|---------------------------------------|----------------------------|-----------------------------|
| (1) 2 points (outside · 1) | (4) 2 points (inside · 1) | (7) 2 points (bottom · 1) |
| (2) 3 points (outside · 1) | (5) 1 point (outside · 1) | (8) 1 point (bottom · 1) |
| (3) 1 point (inside · 1, belt sander) | (6) 2 points (outside · 2) | (9) 10 points (outside · 1) |

NOTE:

- Detach the hidden hit point of the front pillar reinforcement and side sill reinforcement. (View G)
- The illustration indicates the removal condition of the front pillar and outer reinforcement.

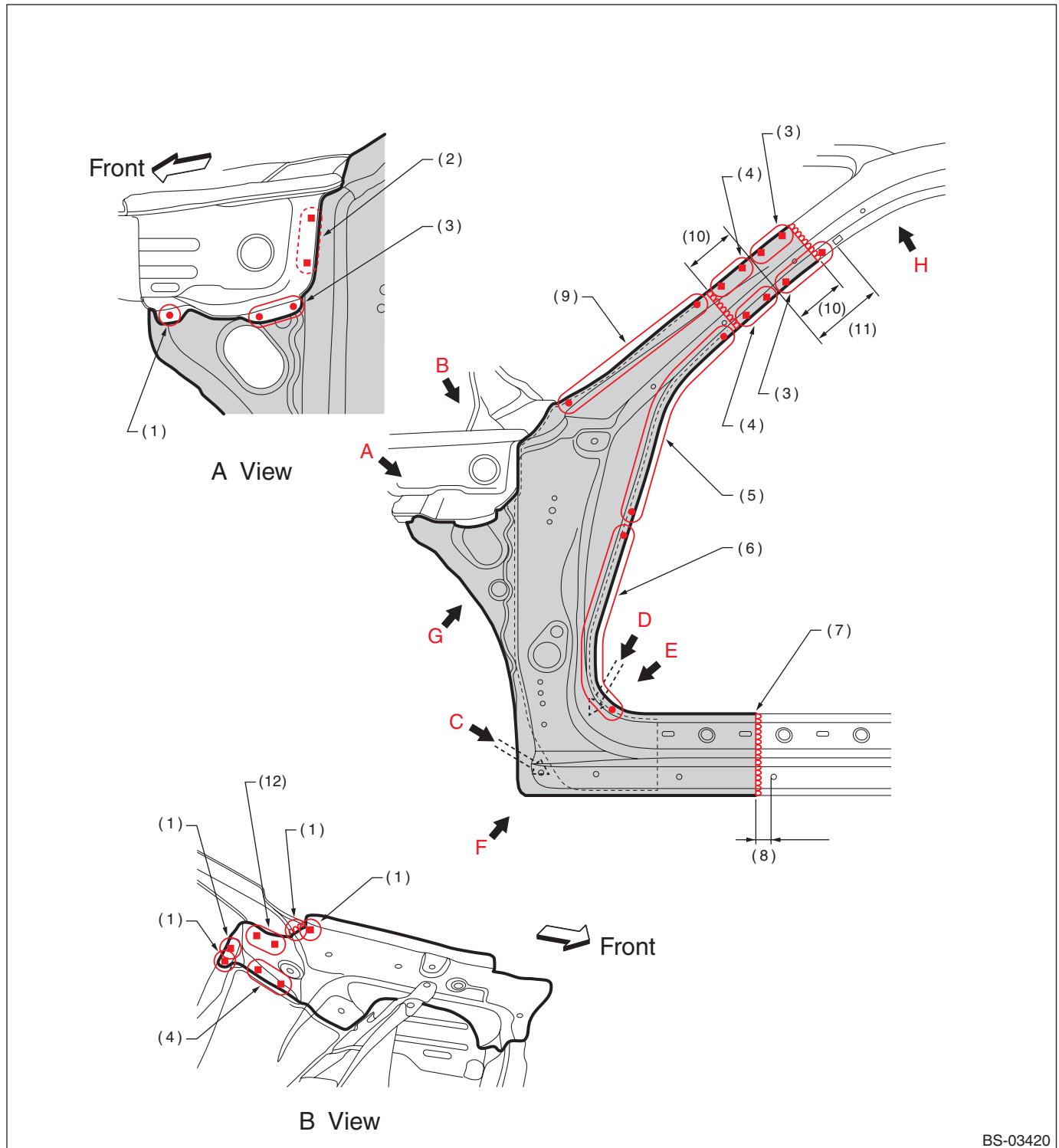
Front Pillar (Partial Replacement)



(1) 3 points (outside · 1)

Front Pillar (Partial Replacement)

B: INSTALLATION

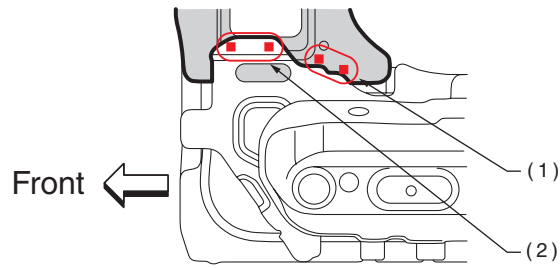


- | | | |
|--|---------------------------------------|----------------------|
| (1) 1 point | (5) 16 points | (9) 9 points |
| (2) 2 points (service - both surface plug) | (6) 14 points | (10) 80 mm (3.1 in) |
| (3) 3 points | (7) 1 point (220 mm x 1) (8.7 in x 1) | (11) 120 mm (4.7 in) |
| (4) 2 points | (8) 15 mm (0.59 in) | (12) 4 points |

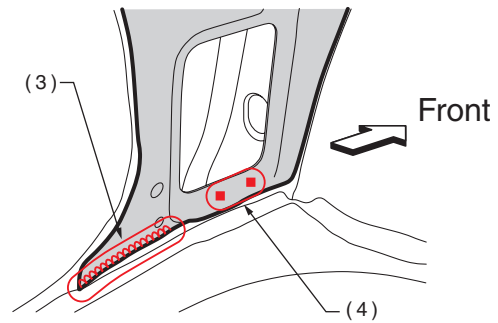
NOTE:

The illustration indicates the removal condition of the frame side upper.

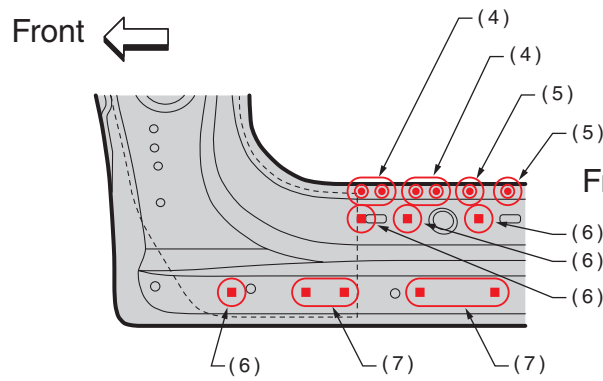
Front Pillar (Partial Replacement)



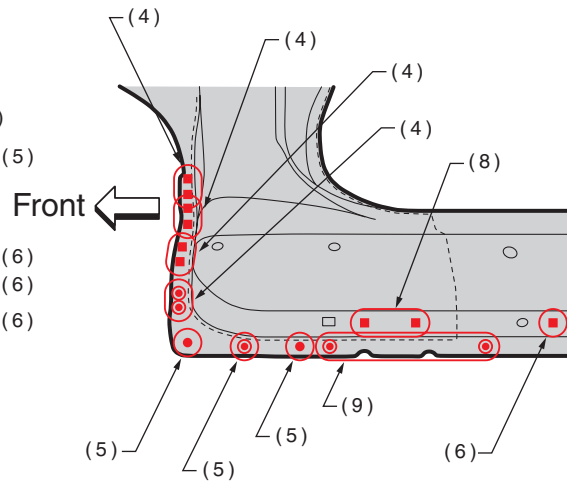
C View



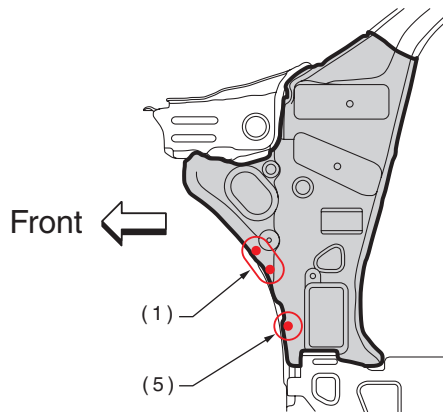
D View



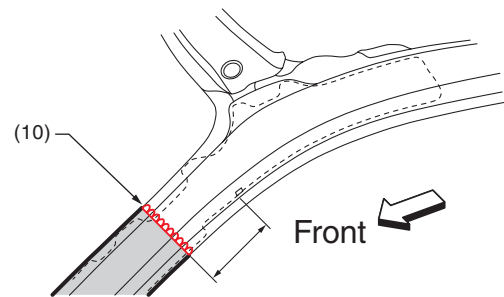
E View



F View



G View



H View

BS-02767

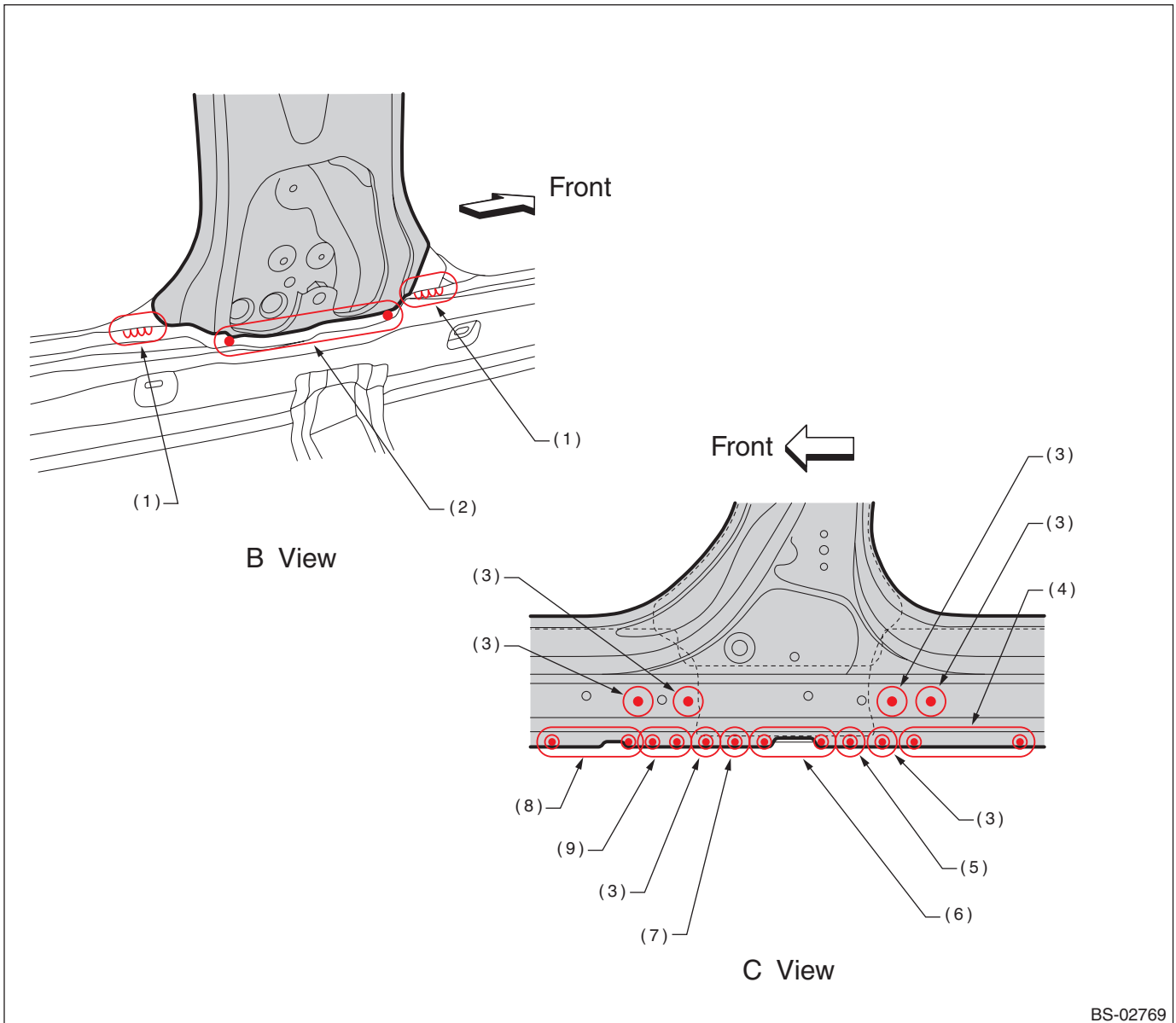
- | | | |
|--|------------------------|------------------------------------|
| (1) 2 points | (5) 1 point | (9) 10 points |
| (2) 3 points | (6) 1 point (service) | (10) 1 point (inside · 130 mm x 1) |
| (3) 1 point (inside · 130 mm) (5.1 in) | (7) 2 points (service) | (5.1 in x 1) |
| (4) 2 points | (8) 2 points (service) | |

A: REMOVAL



- BS - 76**

Center Pillar (Partial Replacement)



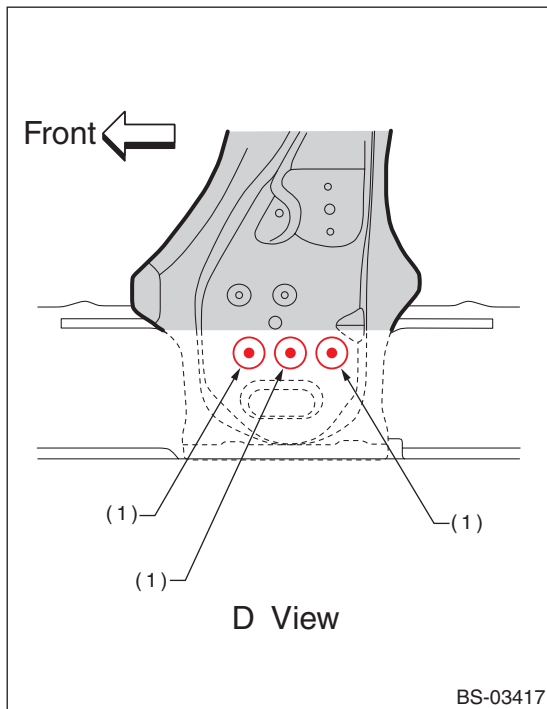
BS-02769

- (1) 1 point (20 mm x 1) (0.79 in x 1)
- (2) 5 points (inside · 1)
- (3) 1 point (outside · 1)

- (4) 5 points (outside · 1)
- (5) 1 point (outside · 2)
- (6) 3 points (outside · 2)

- (7) 1 point (outside · 2)
- (8) 4 points (outside · 1)
- (9) 2 points (outside · 2)

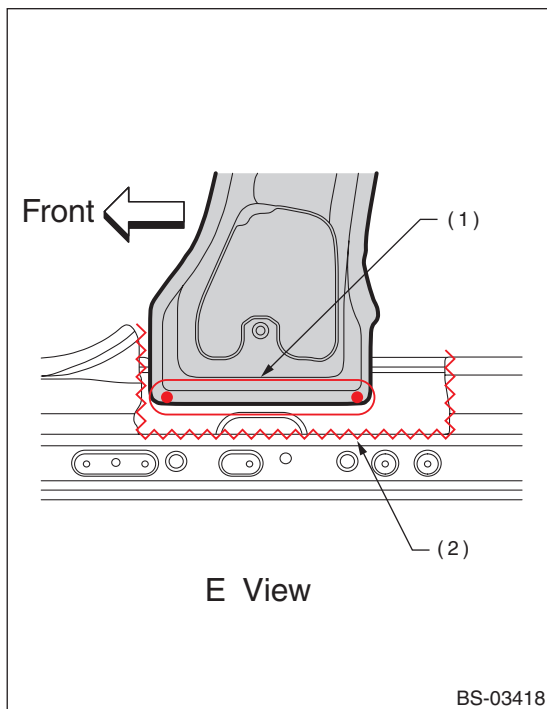
Center Pillar (Partial Replacement)



(1) 1 point (outside · 1)

NOTE:

Detach the hit point of the side sill reinforcement and center pillar outer reinforcement. (View D)



(1) 7 points (outside · 1)

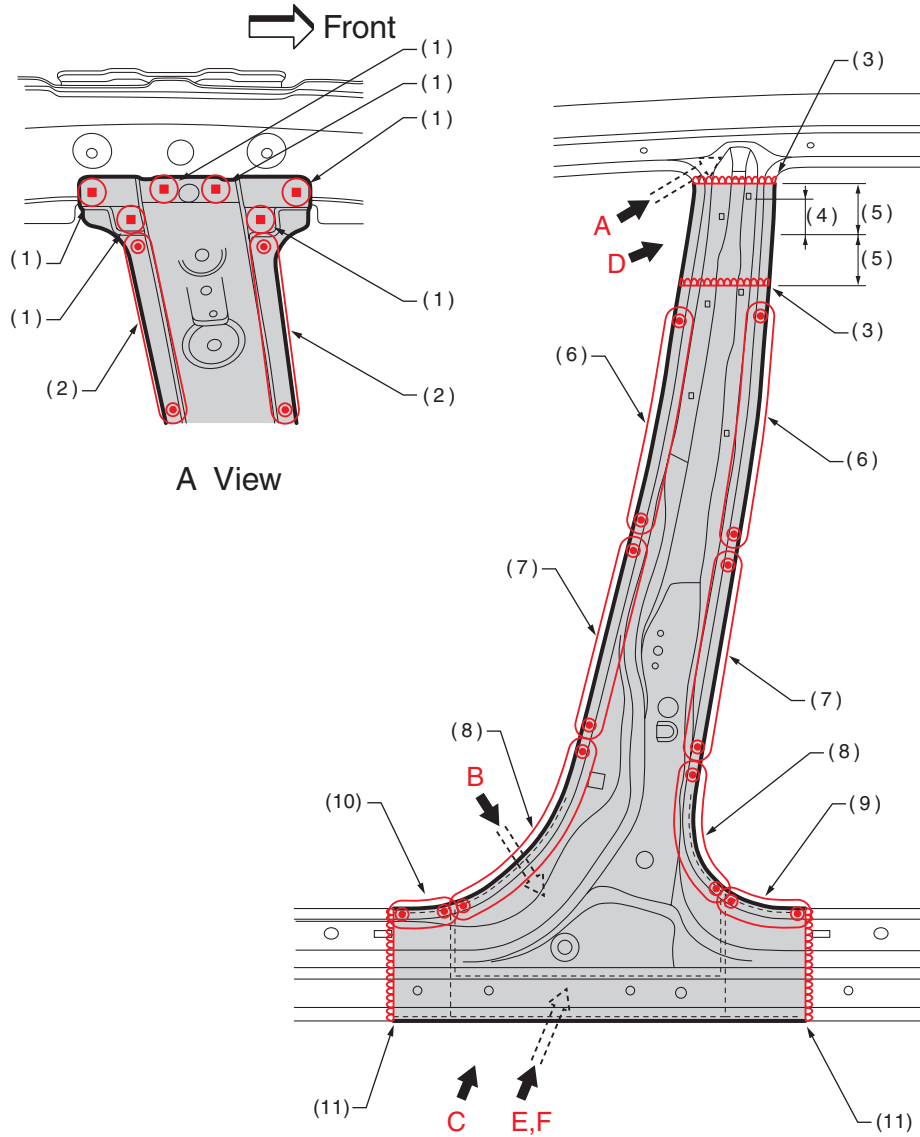
(2) Rough cutting (300 mm) (11.8 in)

NOTE:

- The illustration indicates the removal condition of the center pillar outer reinforcement.
- Cut the side sill reinforcement to detach the hit point of the center inner pillar lower portion. (View E)

Center Pillar (Partial Replacement)

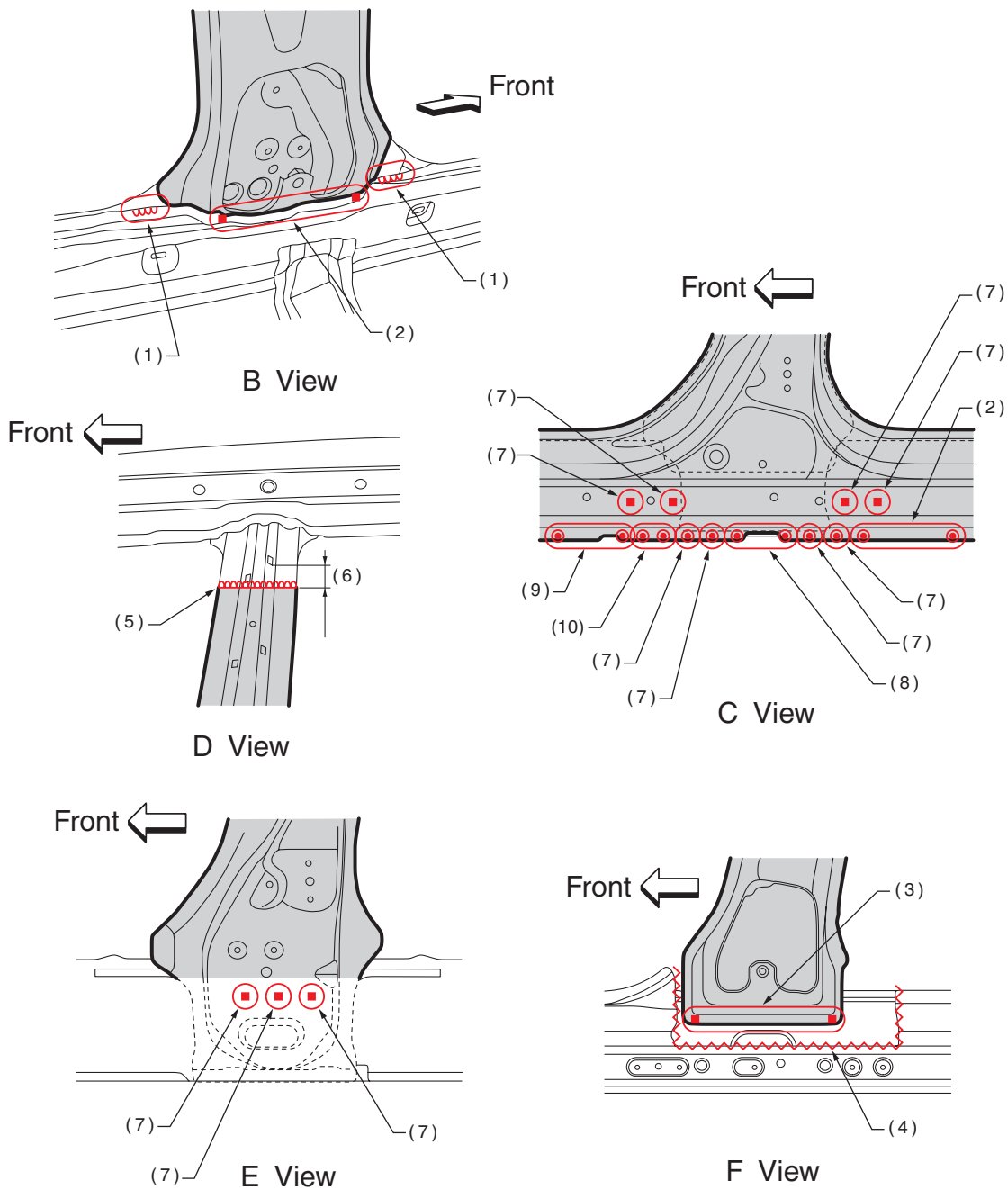
B: INSTALLATION



BS-02867

- | | | |
|-------------------------------|--------------------|--------------------------------|
| (1) 1 point | (5) 80 mm (3.1 in) | (9) 4 points |
| (2) 6 points | (6) 9 points | (10) 5 points |
| (3) 1 point (130 mm) (5.1 in) | (7) 8 points | (11) 1 point (250 mm) (9.8 in) |
| (4) 50 mm (2.0 in) | (8) 11 points | |

Center Pillar (Partial Replacement)



BS-02773

- | | | |
|--|-------------------------------|---------------|
| (1) 1 point (20 mm x 1) (0.79 in x 1) | (5) 1 point (130 mm) (5.1 in) | (8) 3 points |
| (2) 5 points | (6) 50 mm (2.0 in) | (9) 4 points |
| (3) 7 points | (7) 1 point | (10) 2 points |
| (4) 1 point (300 mm x 1) (11.8 in x 1) | | |

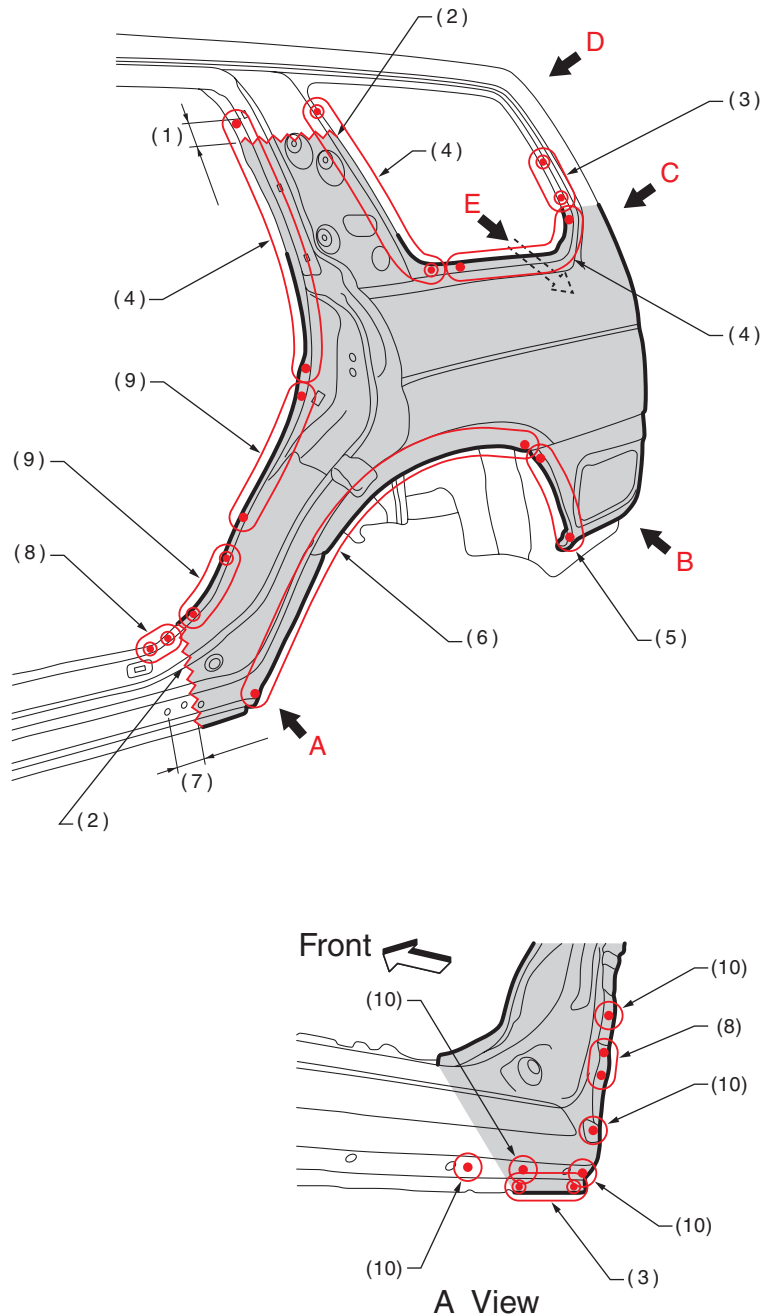
NOTE:

After welding the hit point, weld the cut portion of the side sill reinforcement. (View F)

Rear Quarter (Partial Replacement)

20.Rear Quarter (Partial Replacement)

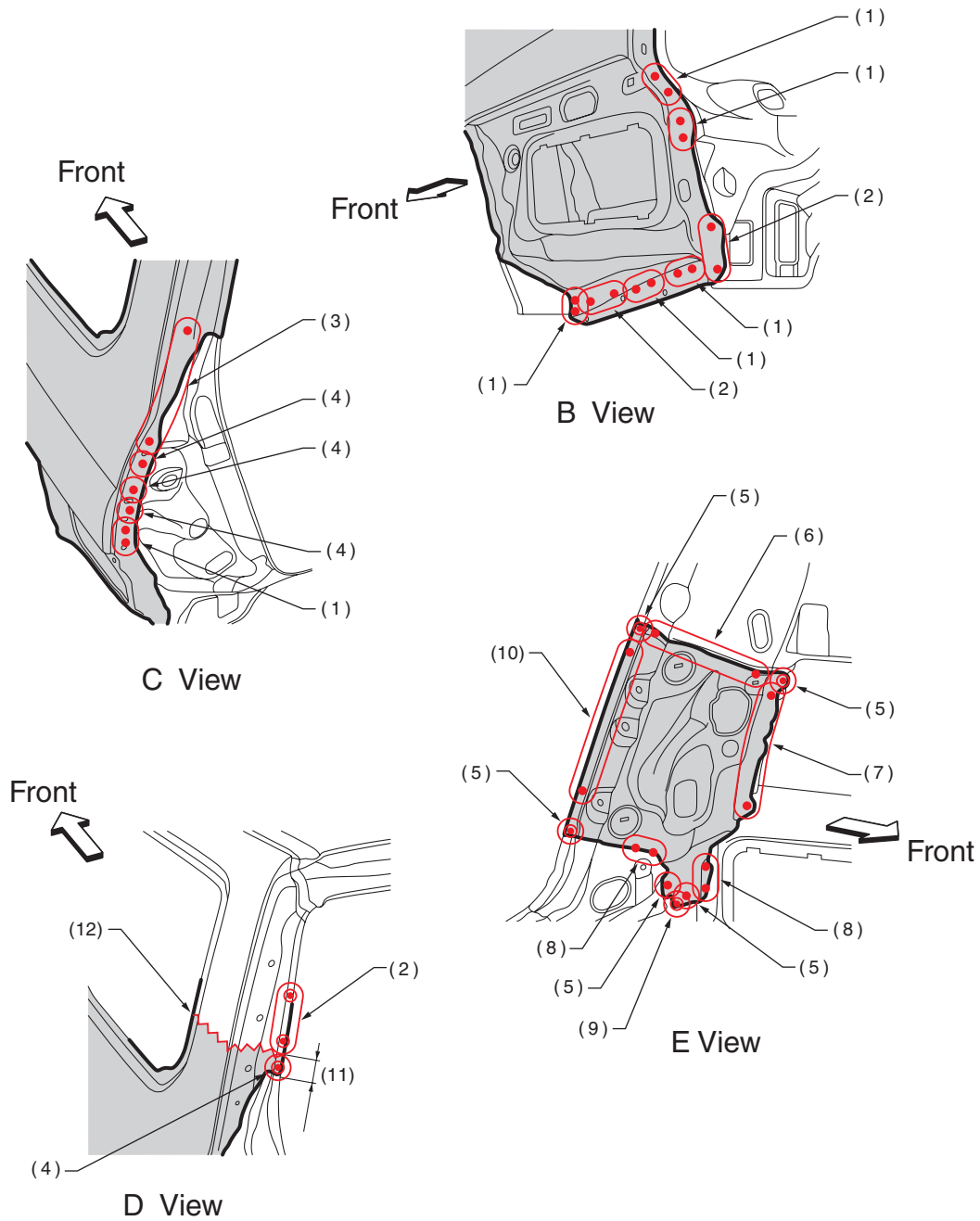
A: REMOVAL



BS-03414

- | | | |
|--------------------------------------|-----------------------------|----------------------------|
| (1) 60 mm (2.4 in) | (5) 5 points (outside · 1) | (8) 2 points (outside · 1) |
| (2) Rough cutting (300 mm) (11.8 in) | (6) 13 points (outside · 1) | (9) 5 points (outside · 1) |
| (3) 4 points (outside · 1) | (7) 80 mm (3.1 in) | (10) 1 point (outside · 1) |
| (4) 9 points (outside · 1) | | |

Rear Quarter (Partial Replacement)

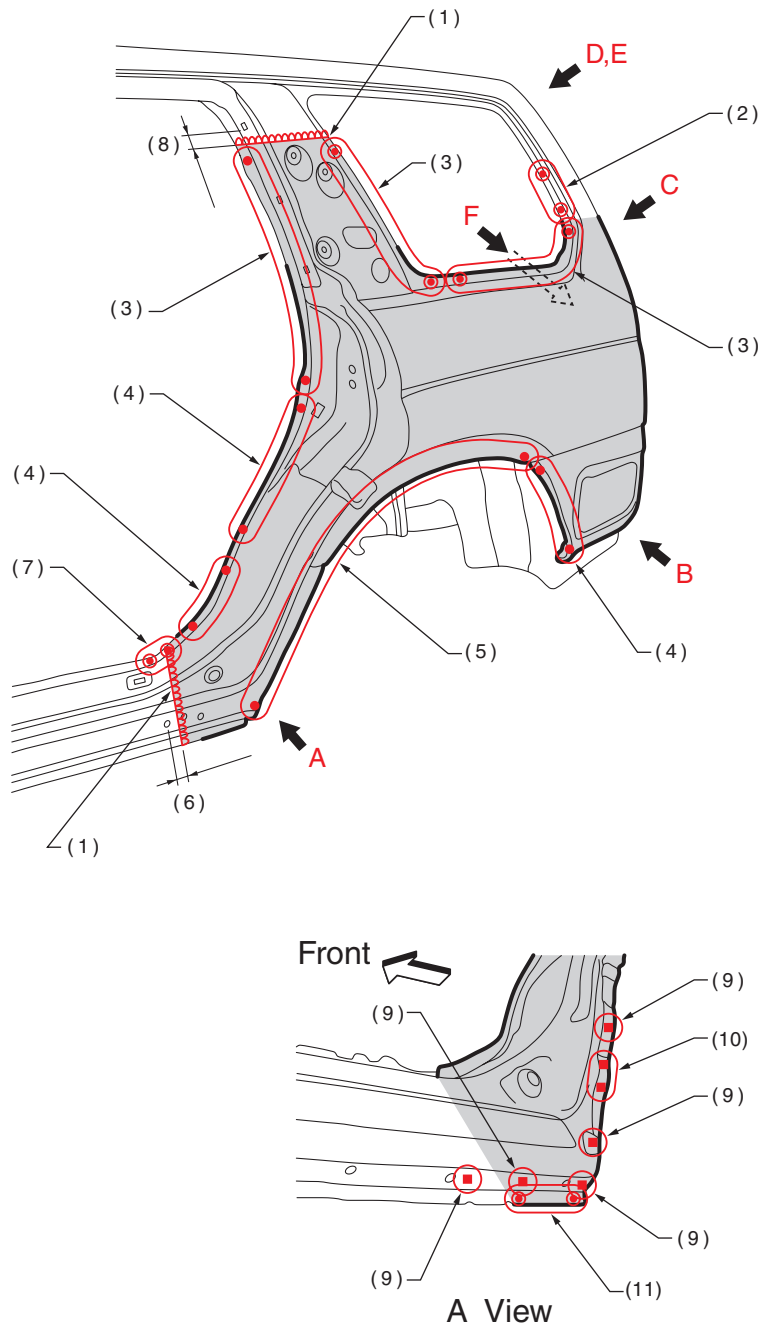


BS-03415

- | | | |
|----------------------------|---------------------------|--------------------------------------|
| (1) 2 points (outside · 1) | (5) 1 point (inside · 2) | (9) 1 point (inside · 2) |
| (2) 3 points (outside · 1) | (6) 3 points (inside · 1) | (10) 5 points (inside · 1) |
| (3) 4 points (outside · 1) | (7) 4 points (inside · 1) | (11) 30 mm (1.2 in) |
| (4) 1 point (outside · 1) | (8) 2 points (inside · 1) | (12) Rough cutting (250 mm) (9.8 in) |

Rear Quarter (Partial Replacement)

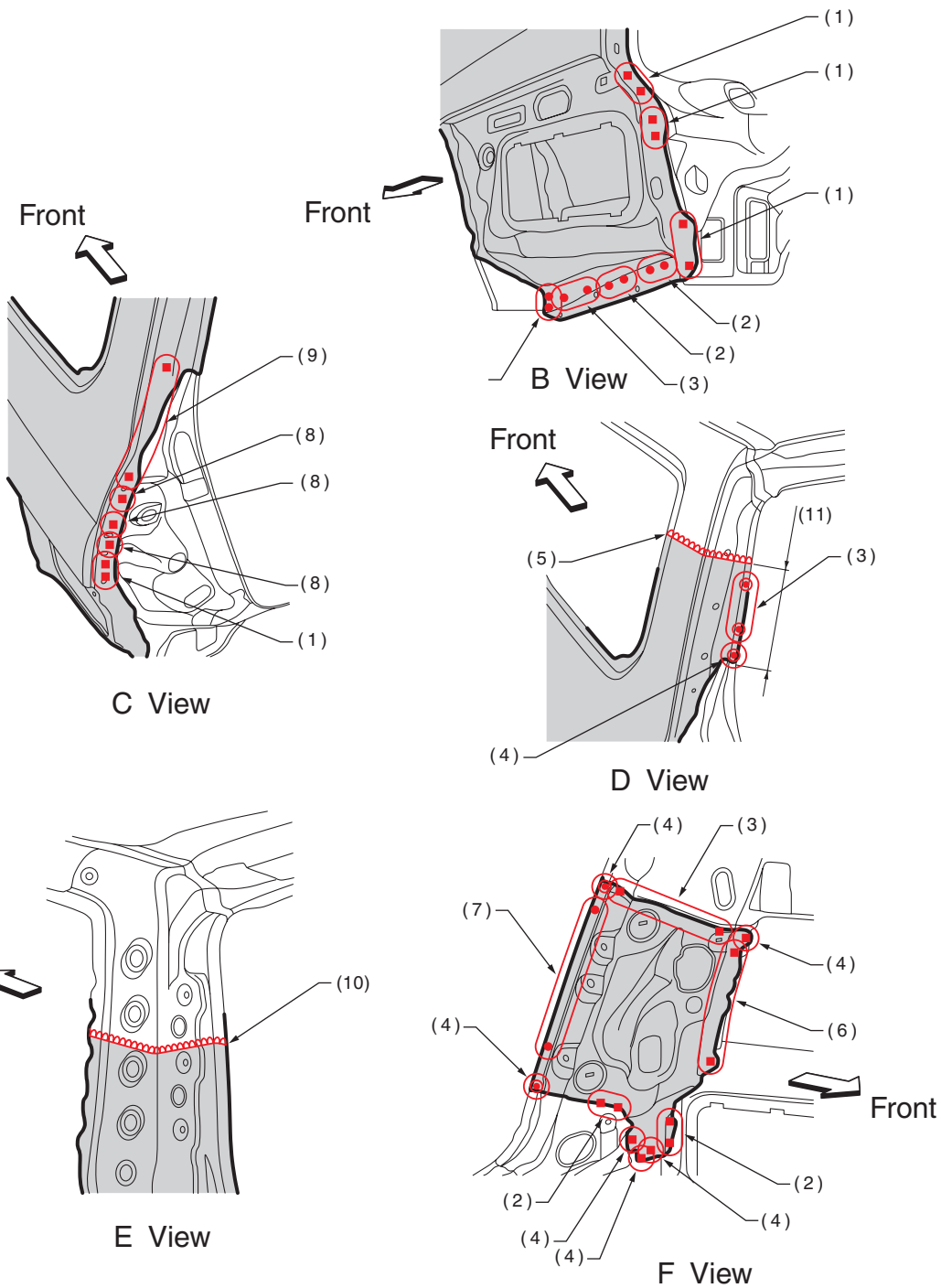
B: INSTALLATION



BS-02869

- | | | |
|--|--------------------|-------------------------|
| (1) 1 point (300 mm x 1) (11.8 in x 1) | (5) 17 points | (9) 1 point (service) |
| (2) 5 points | (6) 50 mm (2.0 in) | (10) 2 points (service) |
| (3) 11 points | (7) 3 points | (11) 4 points |
| (4) 6 points | (8) 30 mm (1.2 in) | |

Rear Quarter (Partial Replacement)



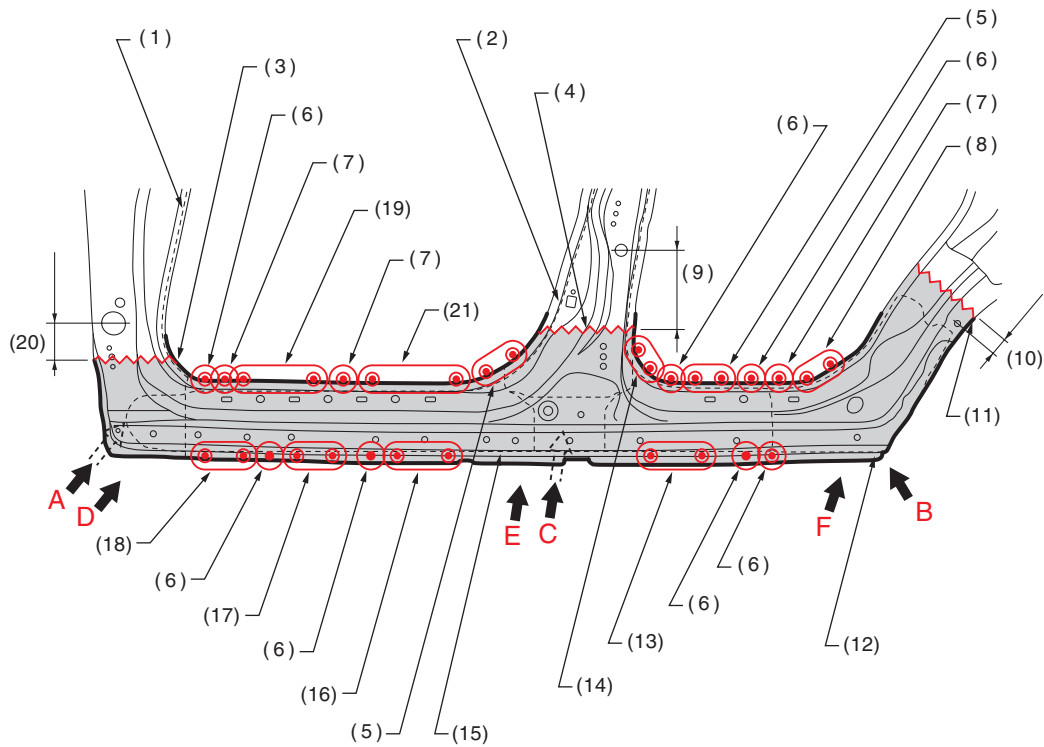
BS-02870

- | | | |
|------------------------|-------------------------------|--------------------------------|
| (1) 2 points (service) | (5) 1 point (230 mm) (9.1 in) | (9) 4 points (service) |
| (2) 2 points | (6) 4 points | (10) 1 point (220 mm) (8.7 in) |
| (3) 3 points | (7) 6 points | (11) 130 mm (5.1 in) |
| (4) 1 point | (8) 1 point (service) | |

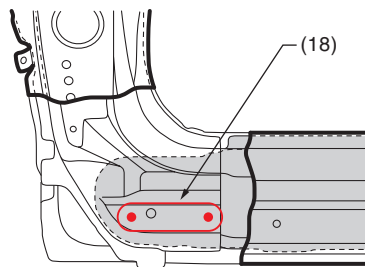
Side Sill Outer (Partial Replacement)

21.Side Sill Outer (Partial Replacement)

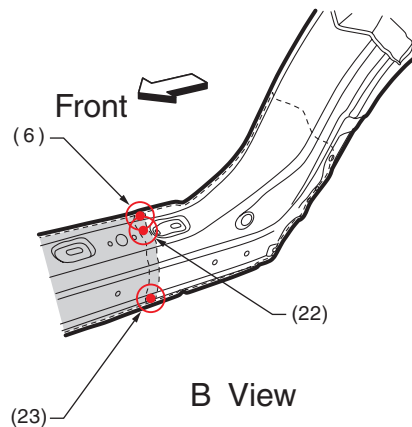
A: REMOVAL



Front ←



A View



B View

BS-02871

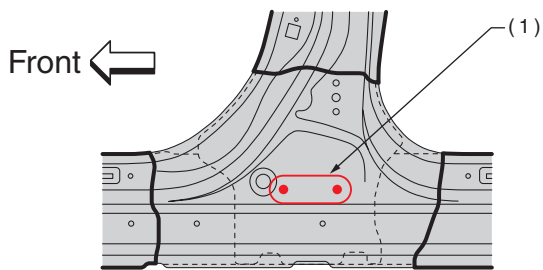
Side Sill Outer (Partial Replacement)

(1) Front pillar reinforcement	(9) 350 mm (13.8 in)	(17) 5 points (outside · 1)
(2) Center pillar reinforcement	(10) 50 mm (2.0 in)	(18) 3 points (outside · 1)
(3) Rough cutting (270 mm) (10.6 in)	(11) Rough cutting 260 mm (10.2 in)	(19) 7 points (outside · 1)
(4) Rough cutting (320 mm) (12.6 in)	(12) Side sill rear reinforcement	(20) 130 mm (5.1 in)
(5) 2 points (outside · 2)	(13) 7 points (outside · 1)	(21) 7 points (outside · 1)
(6) 1 point (outside · 1)	(14) 3 points (outside · 2)	(22) 1 point (top · 1)
(7) 1 point (outside · 2)	(15) Side sill outer reinforcement	(23) 1 point (bottom · 2)
(8) 2 points (outside · 1)	(16) 6 points (outside · 1)	

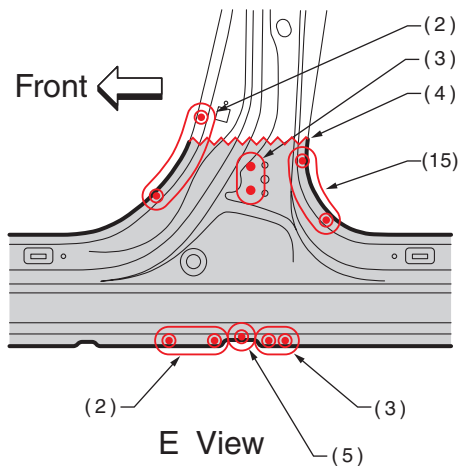
NOTE:

Detach the hit point of the front pillar reinforcement and side sill reinforcement. (View A)

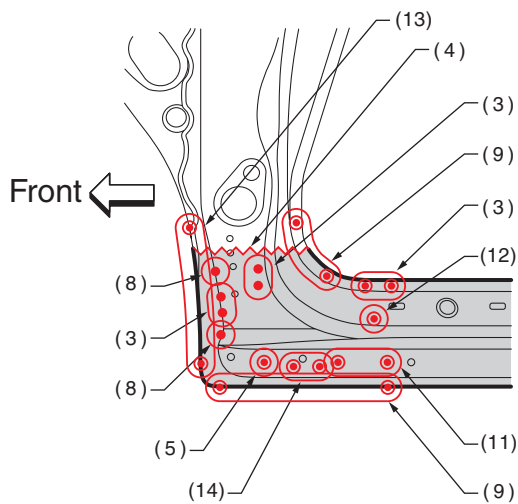
Side Sill Outer (Partial Replacement)



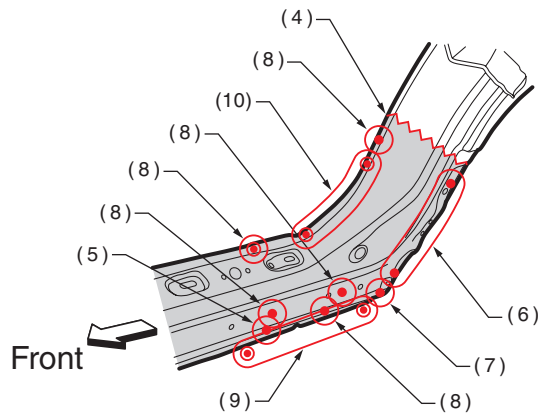
C View



E View



D View



F View

BS-02872

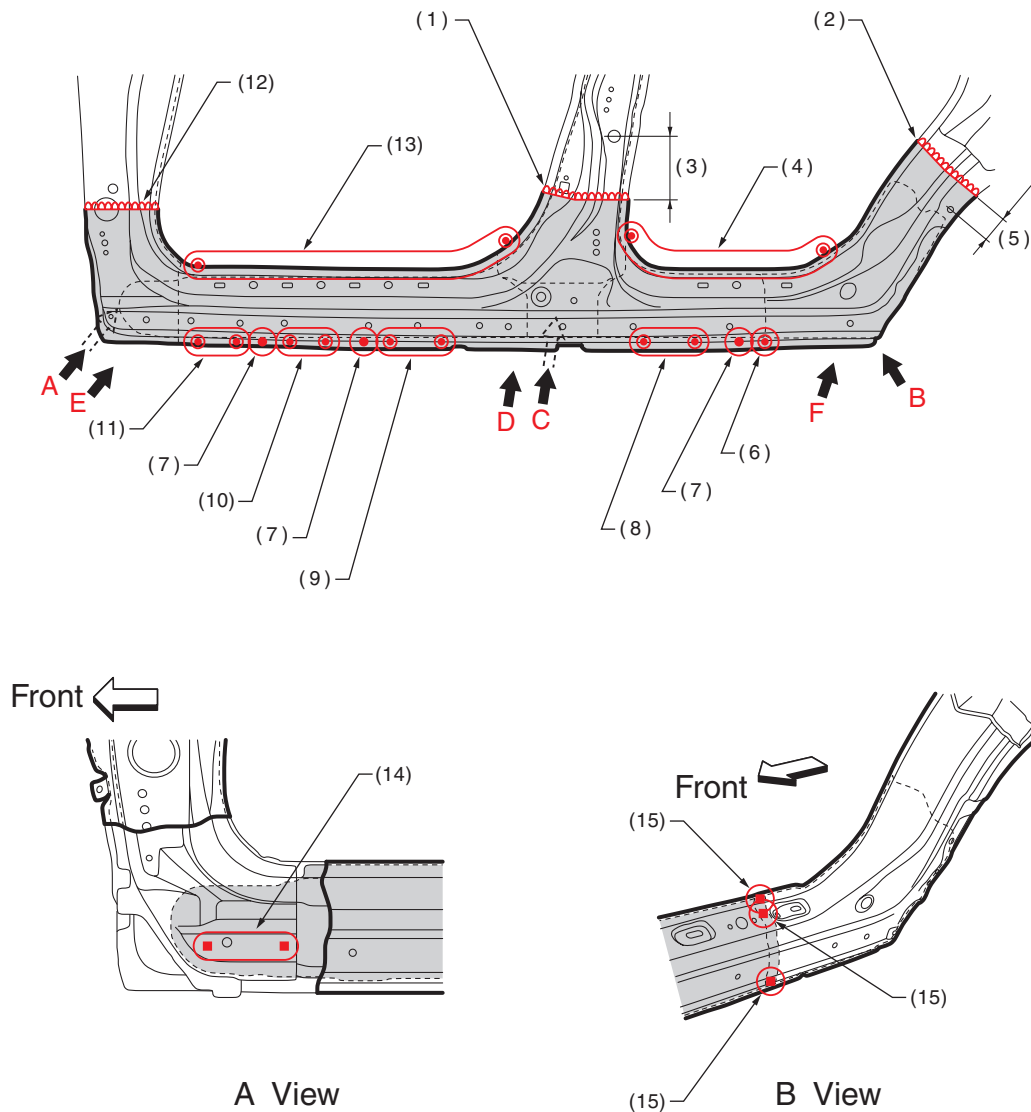
- | | | |
|----------------------------|-----------------------------|-----------------------------|
| (1) 3 points (outside · 1) | (6) 5 points (outside · 1) | (11) 2 points (through) |
| (2) 4 points (outside · 1) | (7) 1 point (bottom · 1) | (12) 1 point (outside · 2) |
| (3) 2 points (outside · 1) | (8) 1 point (outside · 1) | (13) 8 points (outside · 1) |
| (4) Rough cutting | (9) 6 points (outside · 1) | (14) 2 points (through) |
| (5) 1 point (through) | (10) 7 points (outside · 1) | (15) 3 points (outside · 1) |

NOTE:

Detach the hidden hit point of the side sill reinforcement and center pillar reinforcement. (View C)

Side Sill Outer (Partial Replacement)

B: INSTALLATION



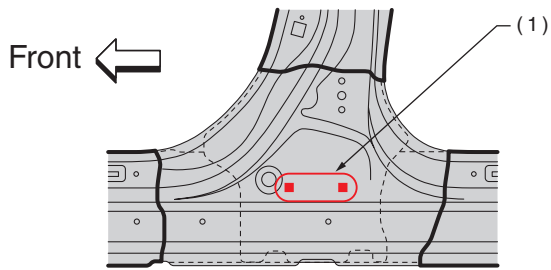
BS-02873

- | | | |
|--------------------------------|---------------|--|
| (1) 1 point (320 mm) (12.6 in) | (7) 1 point | (12) 1 point (270 mm) (10.6 in) door harness hole center |
| (2) 1 point (260 mm) (10.2 in) | (8) 9 points | (13) 23 points |
| (3) 140 mm (5.5 in) | (9) 8 points | (14) 3 points (outside · 1) |
| (4) 12 points | (10) 7 points | (15) 1 point (service) |
| (5) 80 mm (3.1 in) | (11) 4 points | |
| (6) 2 points | | |

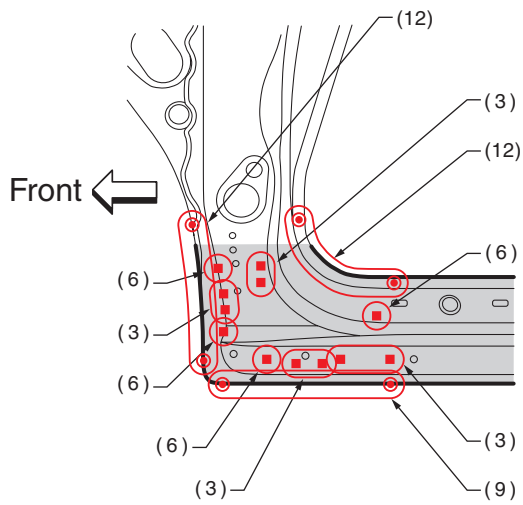
NOTE:

The illustration indicates the hit point of the front pillar reinforcement and side sill reinforcement. (View A)

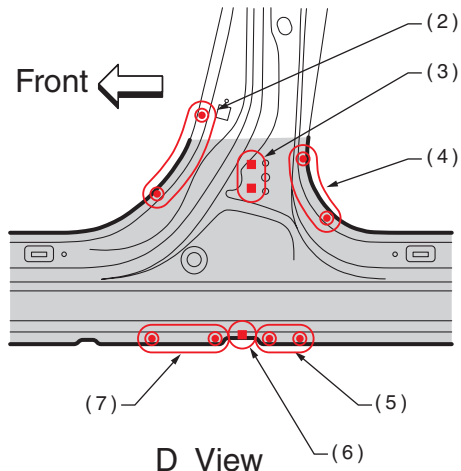
Side Sill Outer (Partial Replacement)



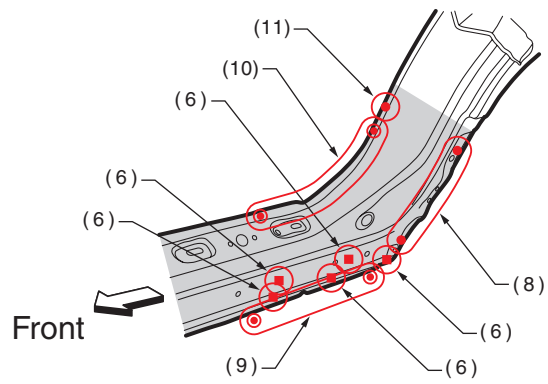
C View



E View



D View



F View

BS-02781

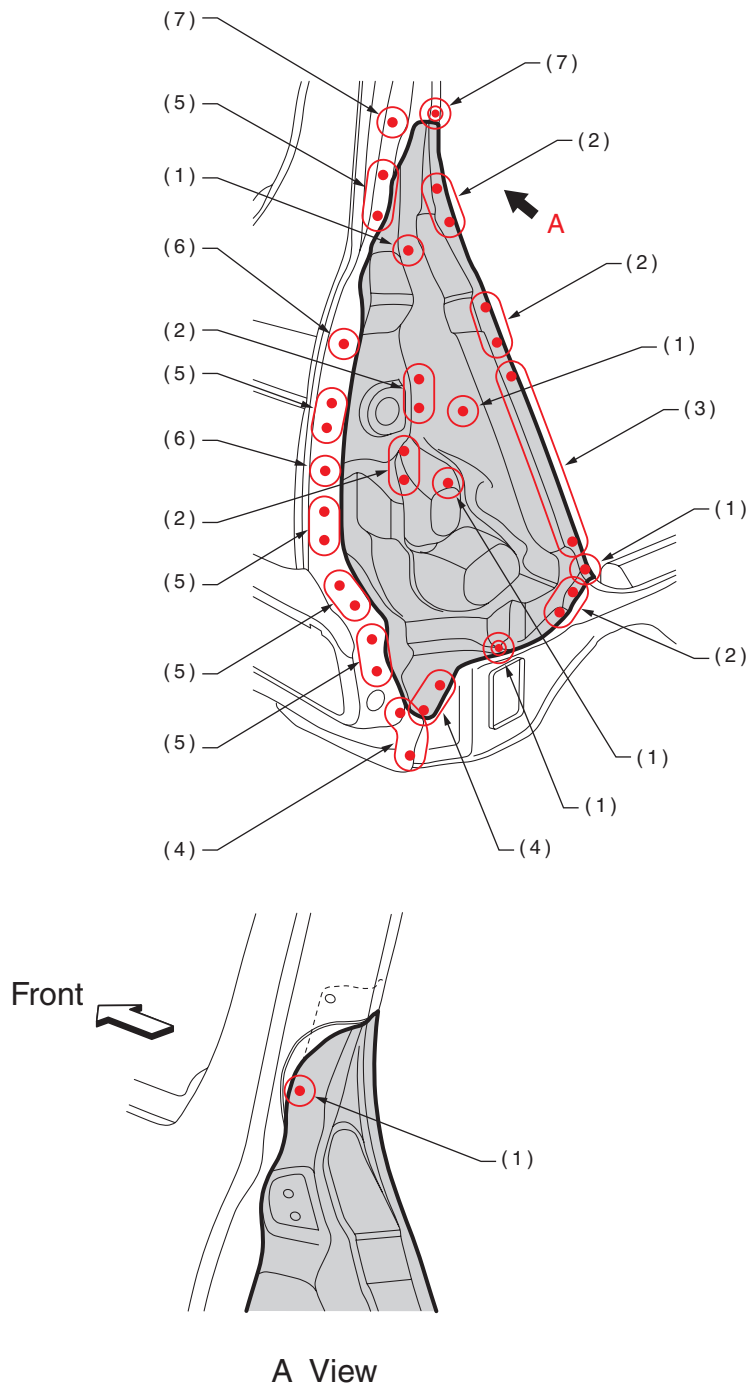
- | | | |
|------------------------|-----------------------|----------------|
| (1) 3 points (service) | (5) 3 points | (9) 8 points |
| (2) 5 points | (6) 1 point (service) | (10) 9 points |
| (3) 2 points (service) | (7) 5 points | (11) 1 point |
| (4) 4 points | (8) 6 points | (12) 10 points |

NOTE:

The illustration indicates the hidden hit point of the side sill reinforcement and center pillar reinforcement. (View C)

22.Rear Outer Pillar (Total Replacement)

A: REMOVAL



BS-02874

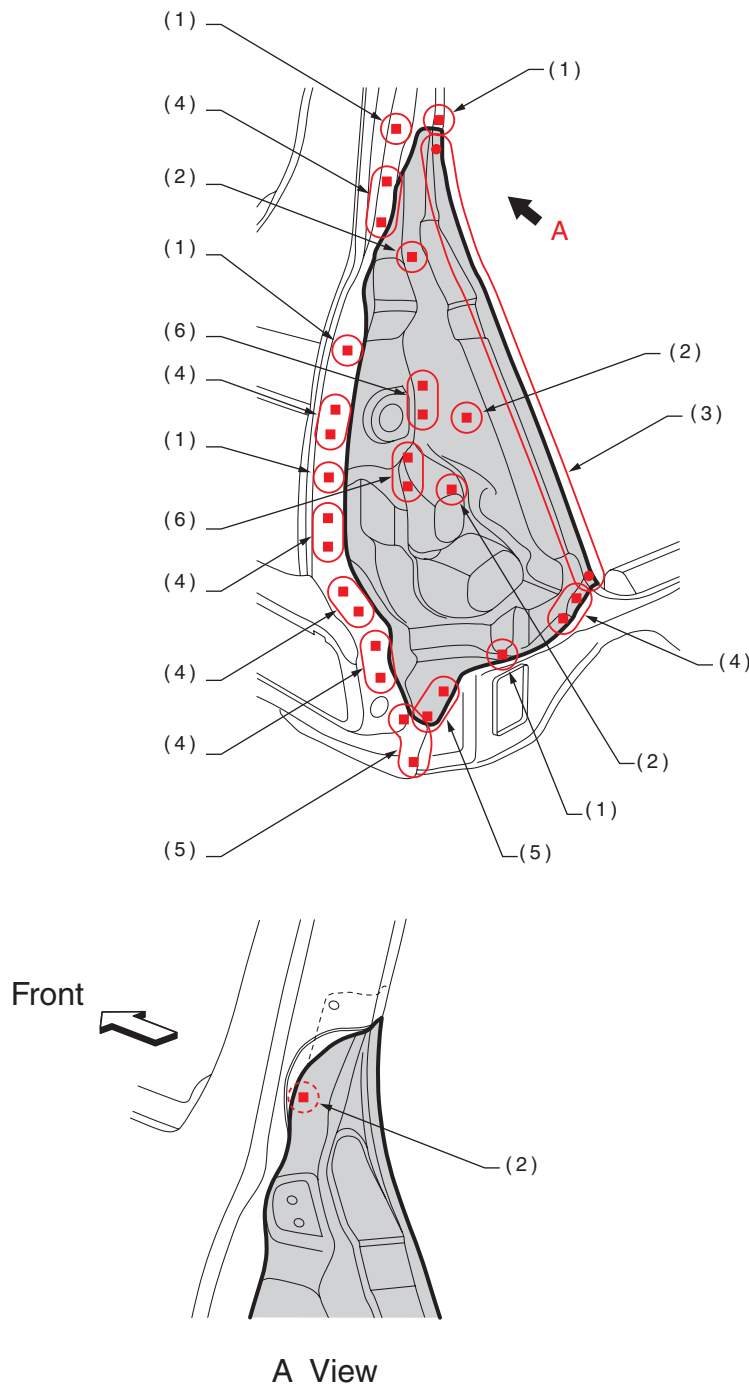
- | | | |
|----------------------------|----------------------------|---------------------------|
| (1) 1 point (outside · 1) | (4) 3 points (outside · 2) | (6) 1 point (outside · 2) |
| (2) 2 points (outside · 1) | (5) 2 points (outside · 2) | (7) 1 point (outside · 2) |
| (3) 9 points (outside · 1) | | |

NOTE:

Detach the hit point of the rear pillar outer and rear pillar reinforcement. (View A)

Rear Outer Pillar (Total Replacement)

B: INSTALLATION



BS-02875

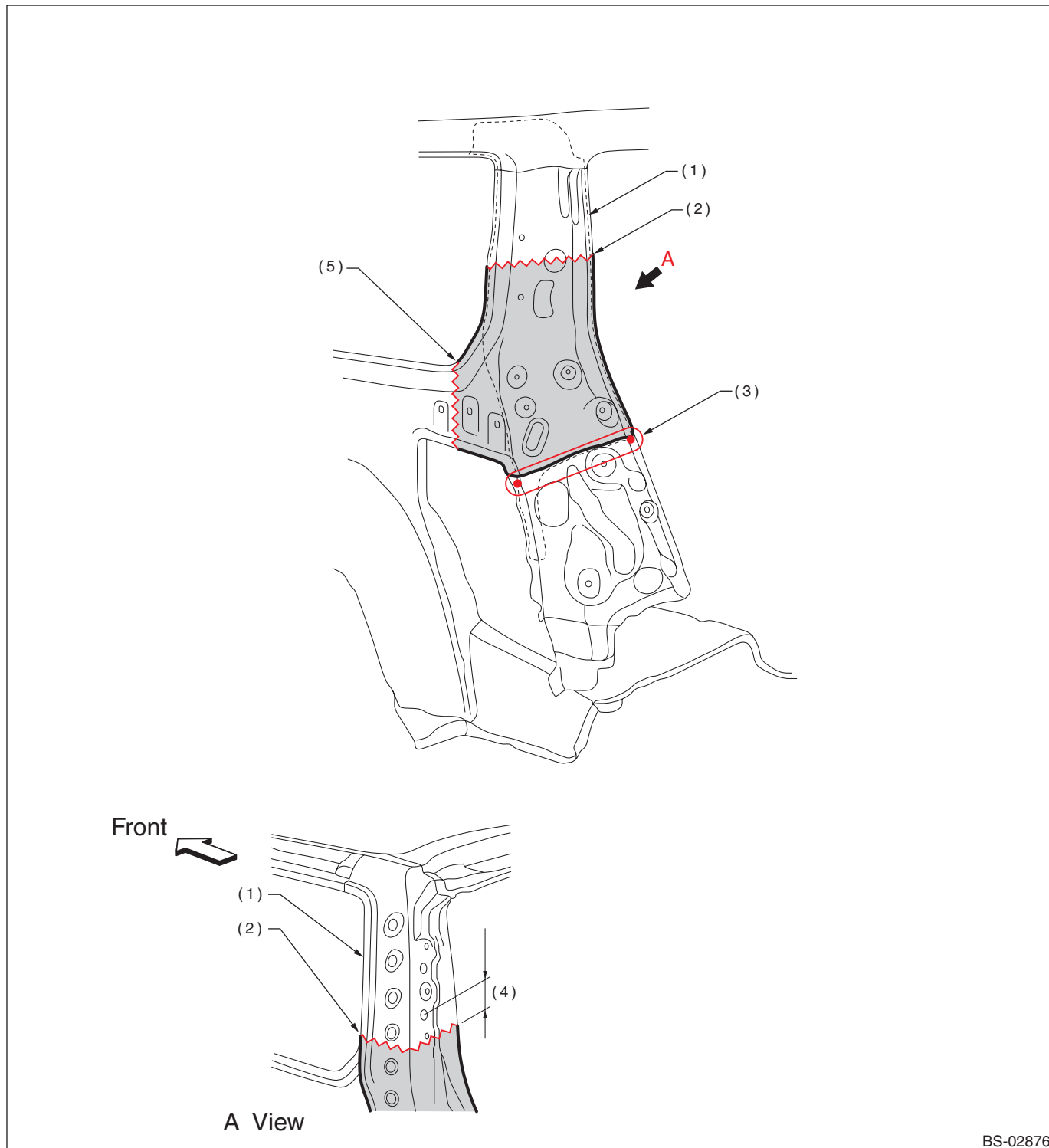
- | | | |
|-----------------------|---------------|------------------------|
| (1) 1 point | (3) 20 points | (5) 3 points |
| (2) 1 point (service) | (4) 2 points | (6) 2 points (service) |

NOTE:

The illustration indicates the hit point of the rear pillar outer and rear pillar reinforcement. (View A)

23.Rear Quarter Inner (Partial Replacement)

A: REMOVAL



BS-02876

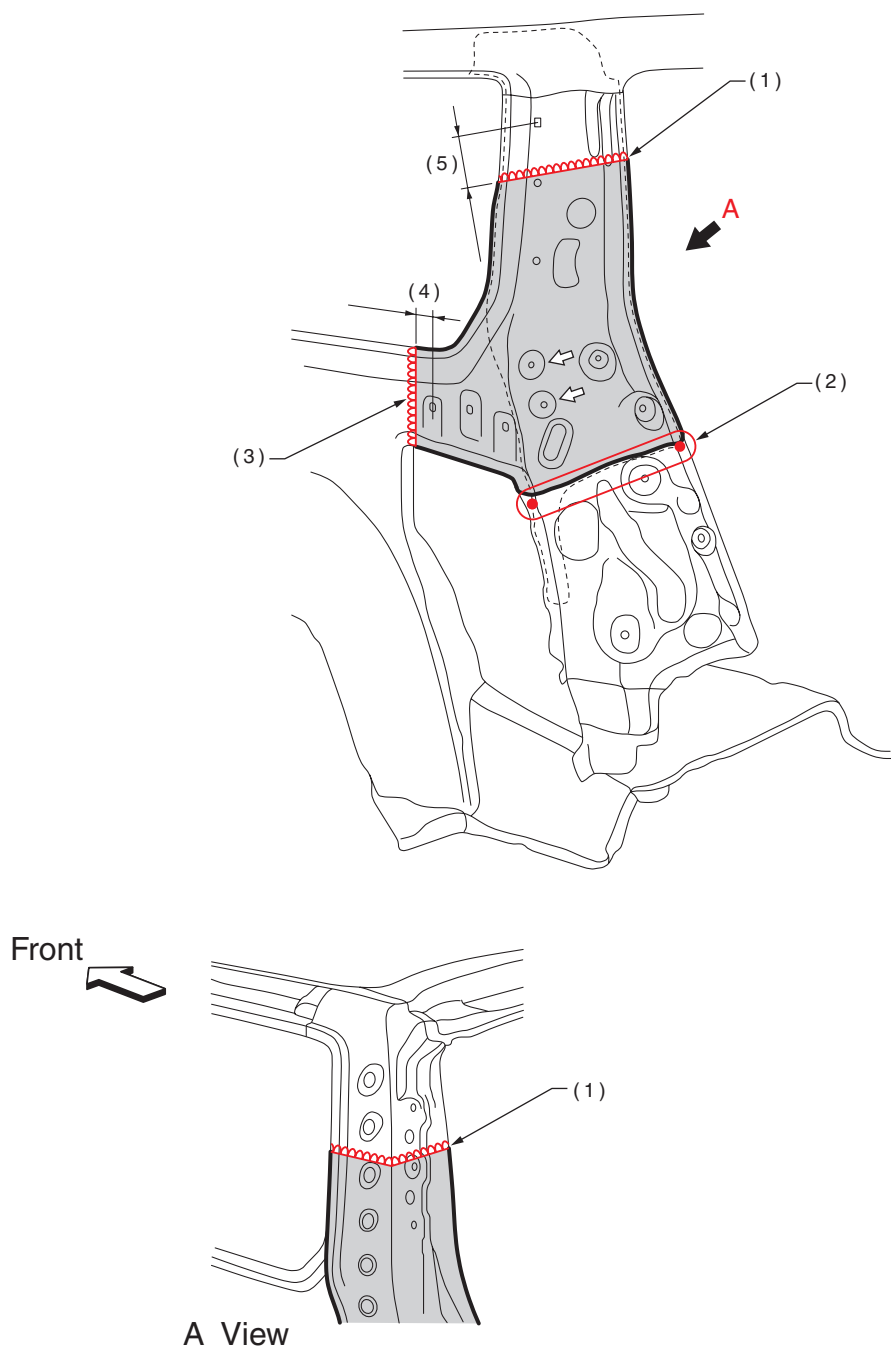
- | | | |
|-------------------------------------|--------------------|-------------------------------------|
| (1) Rear pillar reinforcement | (3) 5 points | (5) Rough cutting (150 mm) (5.9 in) |
| (2) Rough cutting (210 mm) (8.3 in) | (4) 60 mm (2.4 in) | |

NOTE:

- The illustration indicates the removal condition of the rear quarter and rear quarter end.
- View A indicates the removal condition of the rear quarter outer.

Rear Quarter Inner (Partial Replacement)

B: INSTALLATION



BS-02877

(1) 1 point (210 mm) (8.3 in)

(3) 1 point (150 mm) (5.9 in)

(5) 100 mm (3.9 in)

(2) 7 points

(4) 50 mm (2.0 in)

CAUTION:

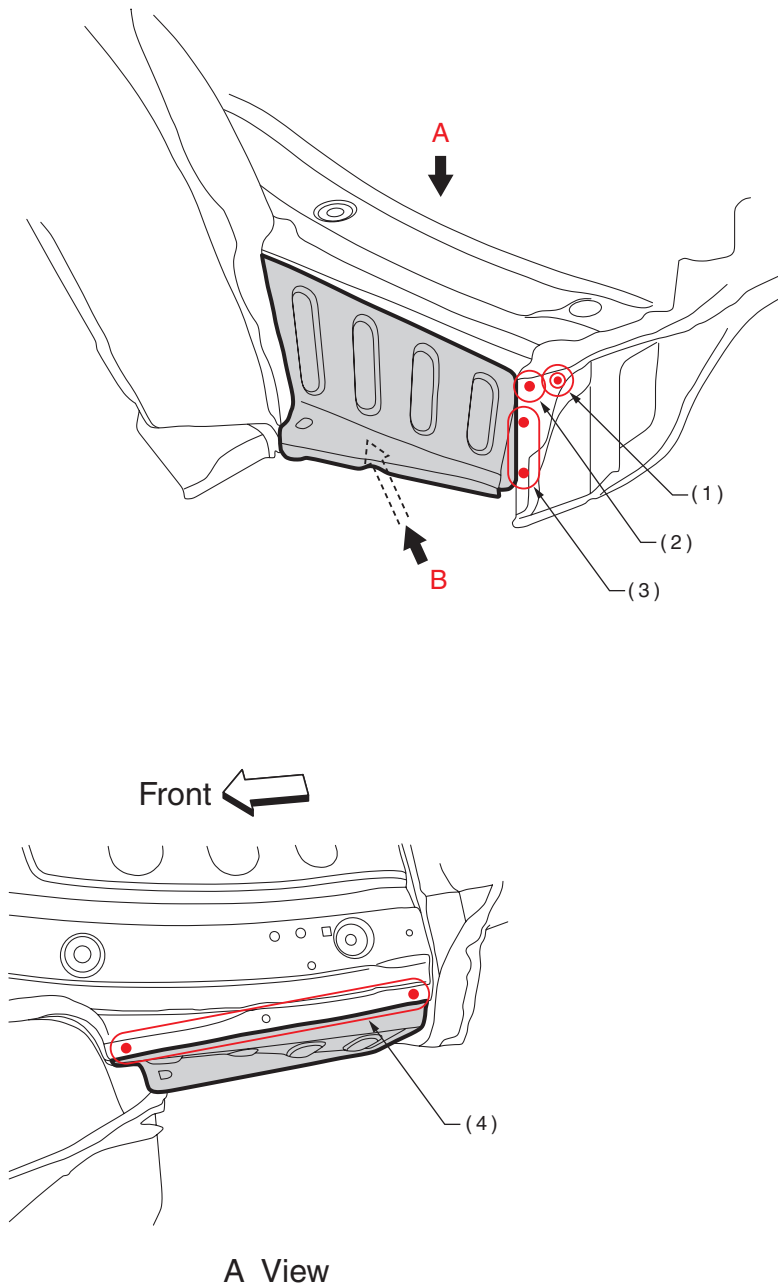
Be sure to attach two nutserts at ⇨ portion.

NOTE:

- The illustration indicates the removal condition of the rear quarter and rear quarter end.
- View A indicates the removal condition of the rear quarter outer.

24.Rear Floor Side (Total Replacement)

A: REMOVAL



BS-02878

- (1) 1 point (outside · 2)
(2) 1 point (outside · 1)

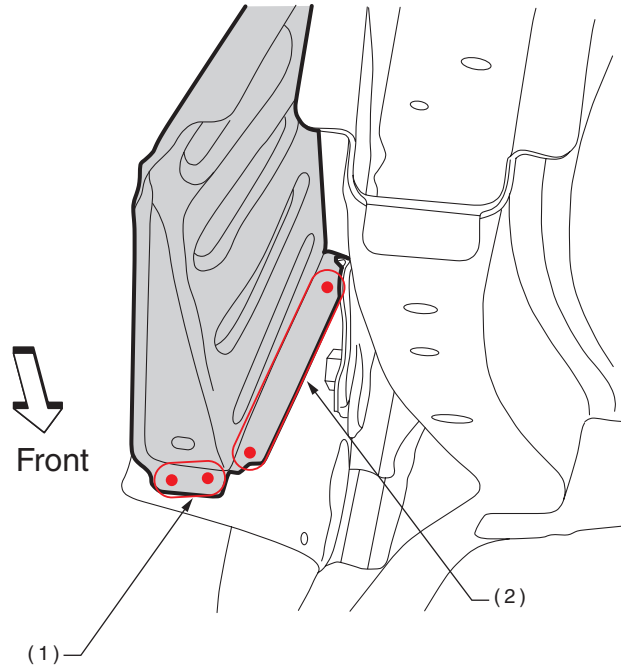
- (3) 3 points (outside · 1)

- (4) 9 points (top · 1)

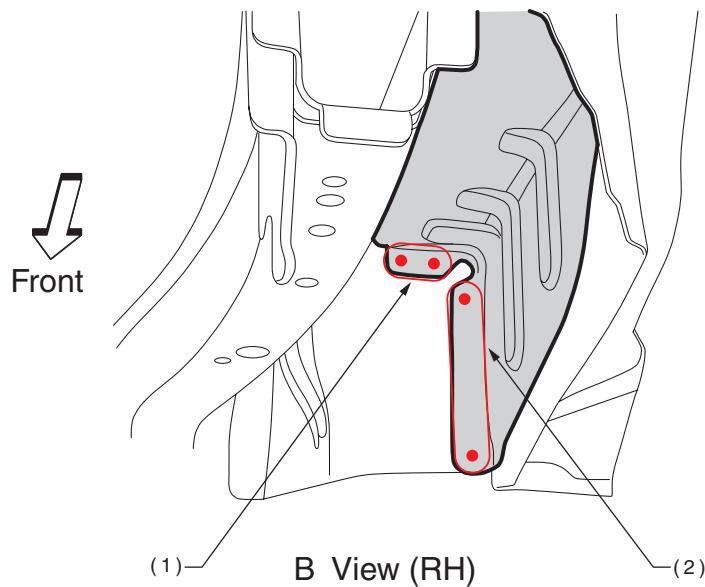
NOTE:

The illustration indicates the removal condition of the rear quarter and rear quarter end.

Rear Floor Side (Total Replacement)



B View



B View (RH)

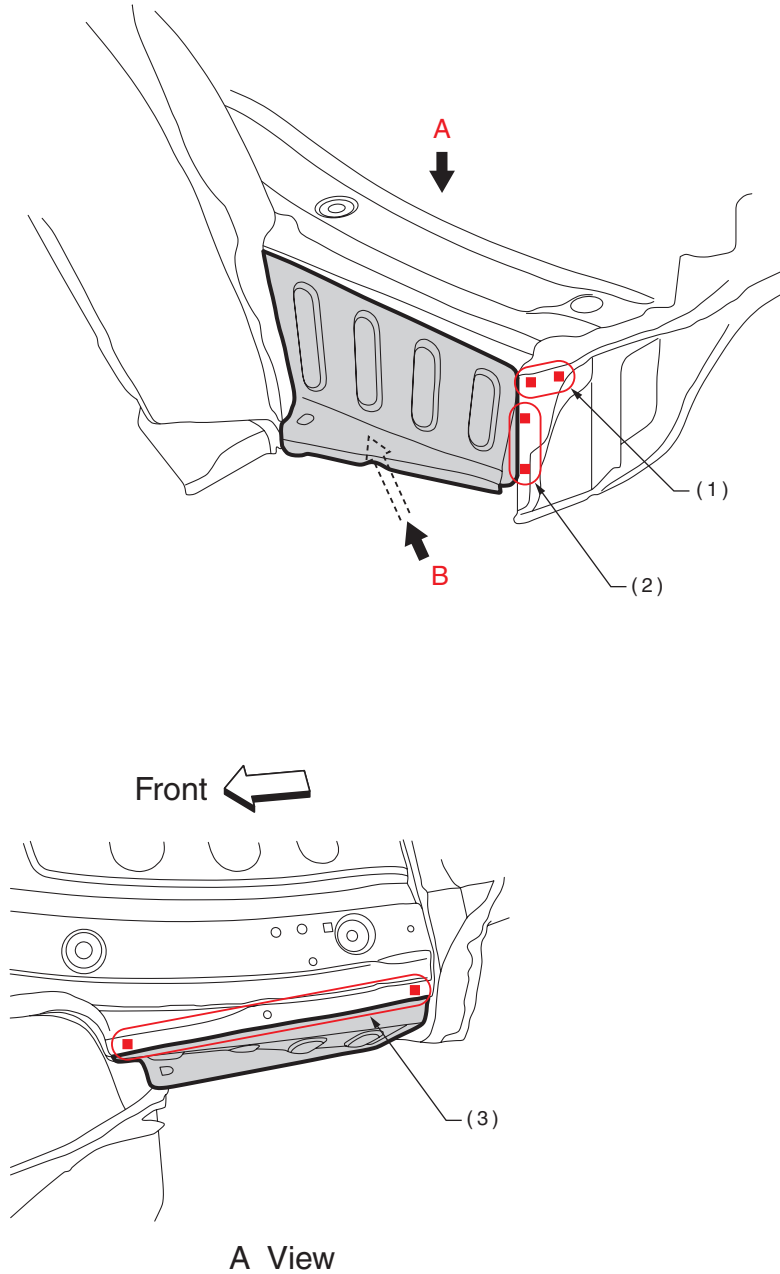
BS-02788

(1) 2 points (inside · 1)

(2) 4 points (inside · 1)

Rear Floor Side (Total Replacement)

B: INSTALLATION



BS-02879

(1) 2 points

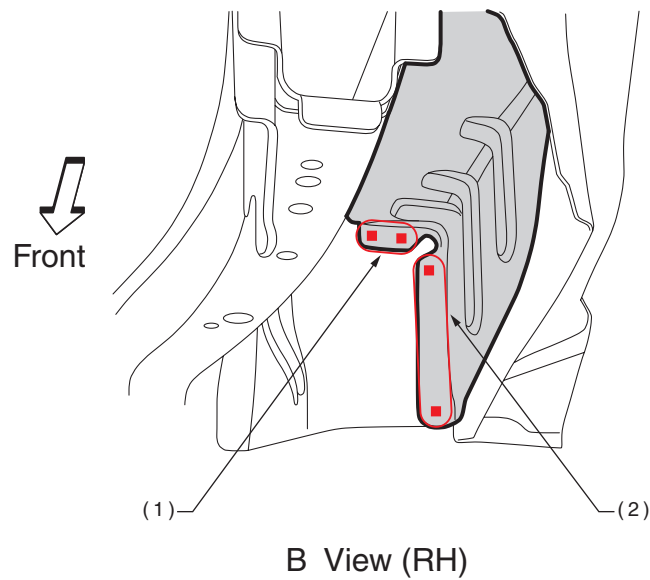
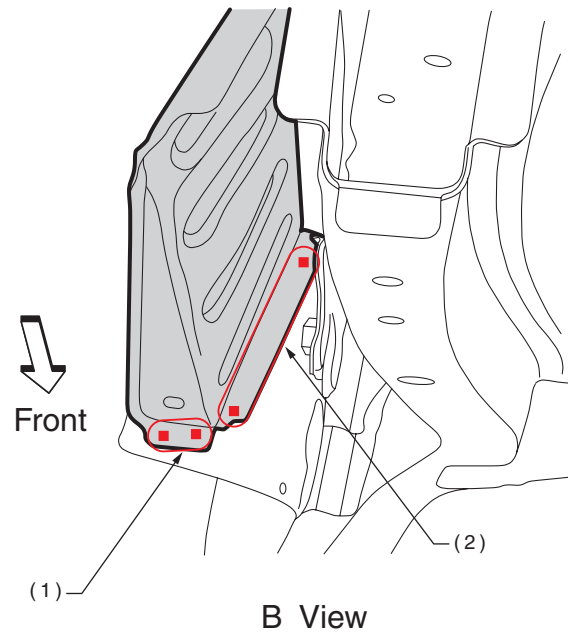
(2) 3 points

(3) 9 points

NOTE:

The illustration indicates the removal condition of the rear quarter and rear quarter end.

Rear Floor Side (Total Replacement)



BS-02790

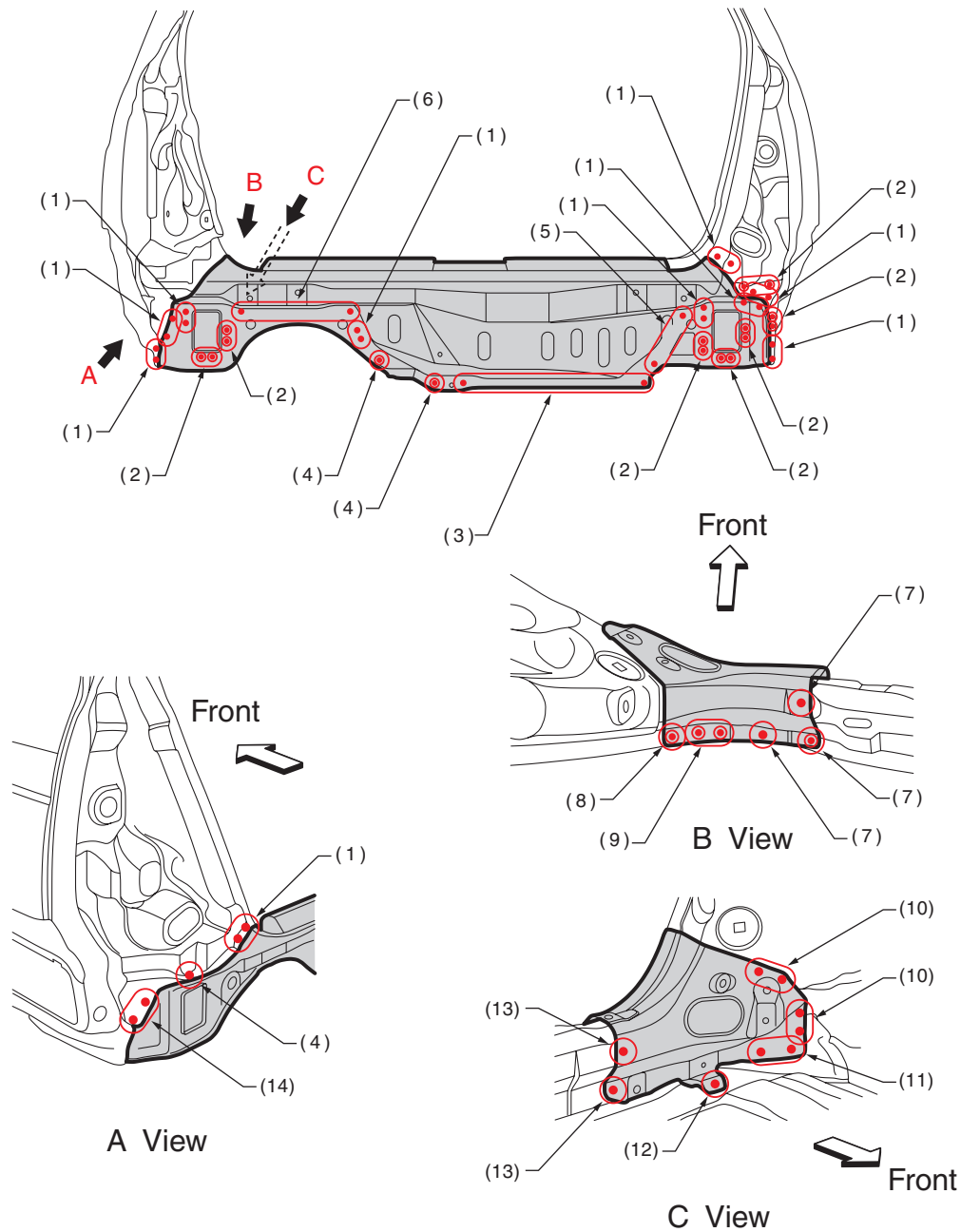
(1) 2 points (inside · 1)

(2) 4 points (inside · 1)

Rear Skirt (Total Replacement)

25.Rear Skirt (Total Replacement)

A: REMOVAL



BS-02880

Rear Skirt (Total Replacement)

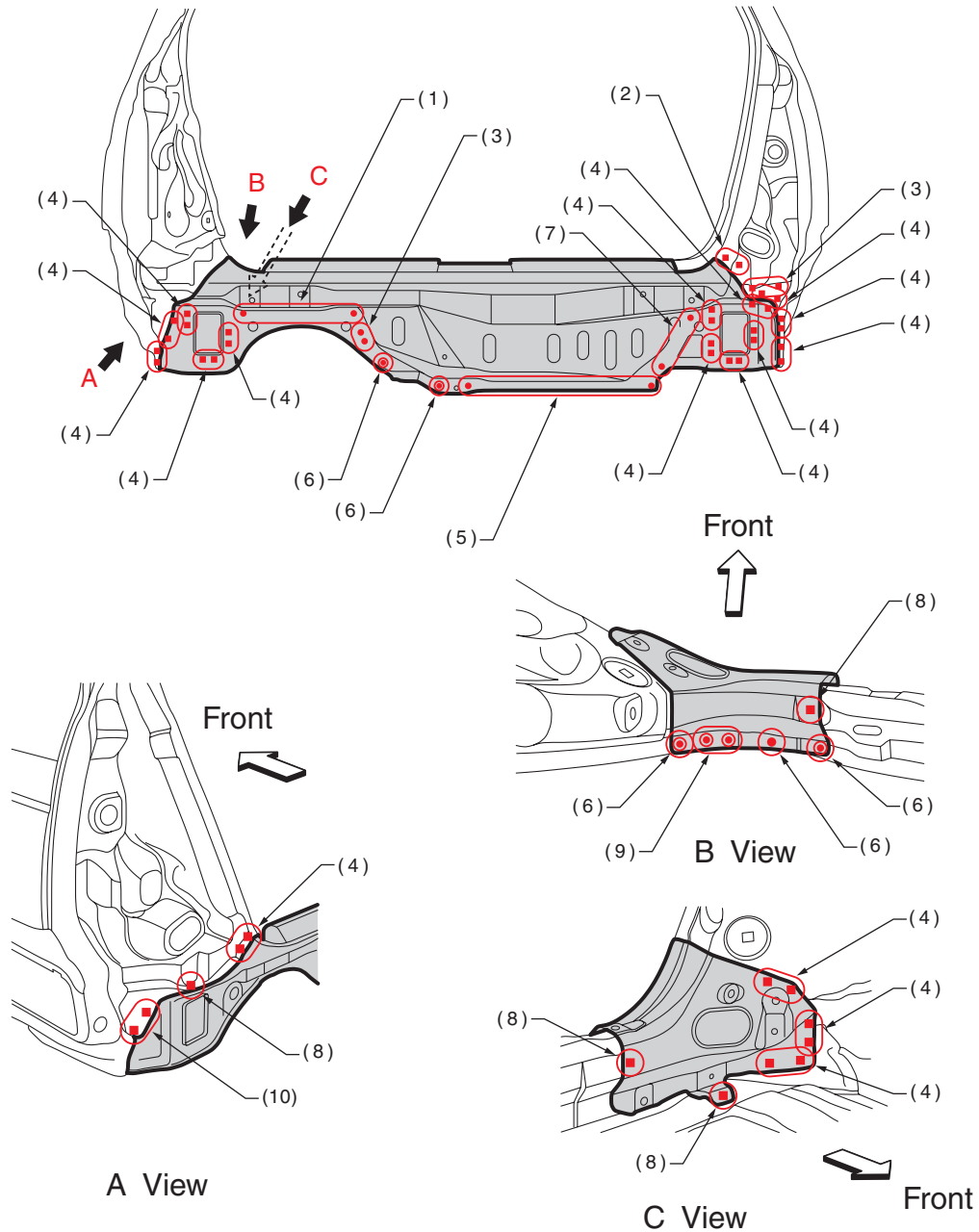
- | | | |
|-----------------------------|----------------------------|-----------------------------|
| (1) 2 points (outside · 1) | (6) 6 points (outside · 1) | (11) 2 points (inside · 1) |
| (2) 2 points (outside · 2) | (7) 1 point (top · 1) | (12) 1 point (top · 1) |
| (3) 12 points (outside · 1) | (8) 1 point (inside · 1) | (13) 1 point (inside · 1) |
| (4) 1 point (outside · 1) | (9) 3 points (inside · 1) | (14) 3 points (outside · 2) |
| (5) 4 points (outside · 1) | (10) 2 points (inside · 1) | |

NOTE:

The illustration indicates the removal condition of the rear outer pillar on one side.

Rear Skirt (Total Replacement)

B: INSTALLATION



BS-02881

- | | | |
|------------------------|---------------|-------------------------|
| (1) 8 points | (5) 15 points | (8) 1 point (service) |
| (2) 2 points | (6) 1 point | (9) 4 points |
| (3) 3 points | (7) 5 points | (10) 3 points (service) |
| (4) 2 points (service) | | |

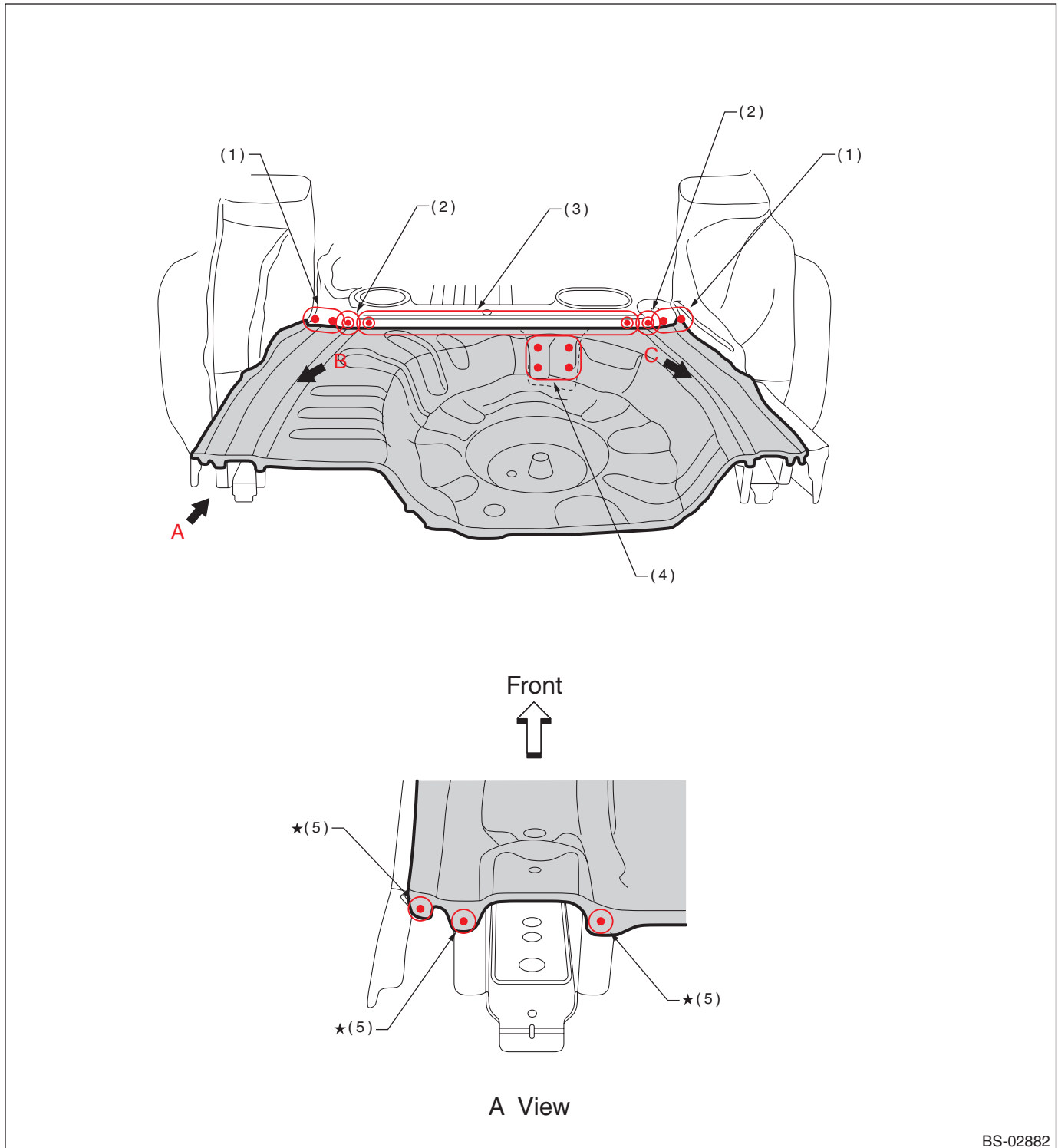
NOTE:

The illustration indicates the removal condition of the rear outer pillar on one side.

Rear Floor Pan (Total Replacement)

26.Rear Floor Pan (Total Replacement)

A: REMOVAL



BS-02882

(1) 2 points (top · 1)

(2) 1 point (top · 2)

(3) 17 points (top · 2)

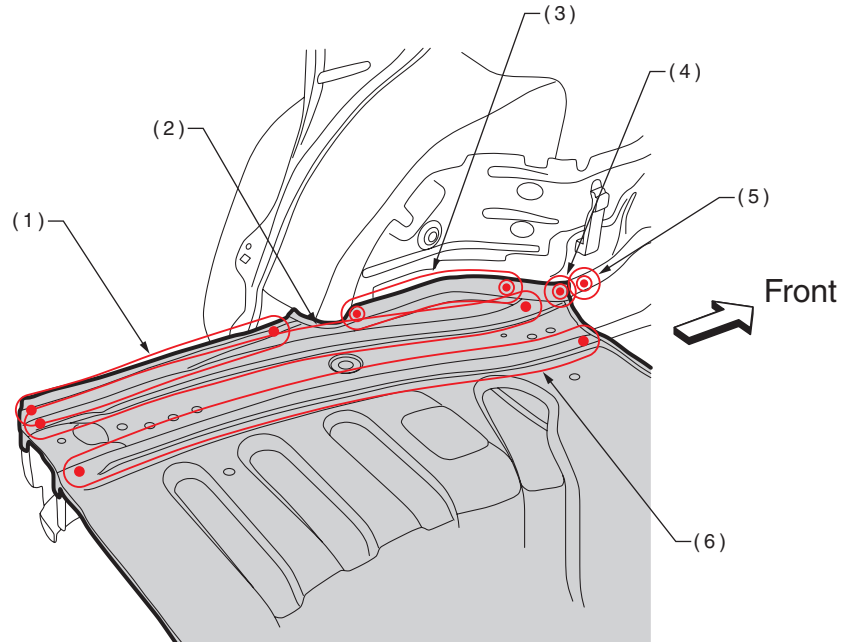
(4) 10 points (top · 1)

(5) 1 point (outside · 1)

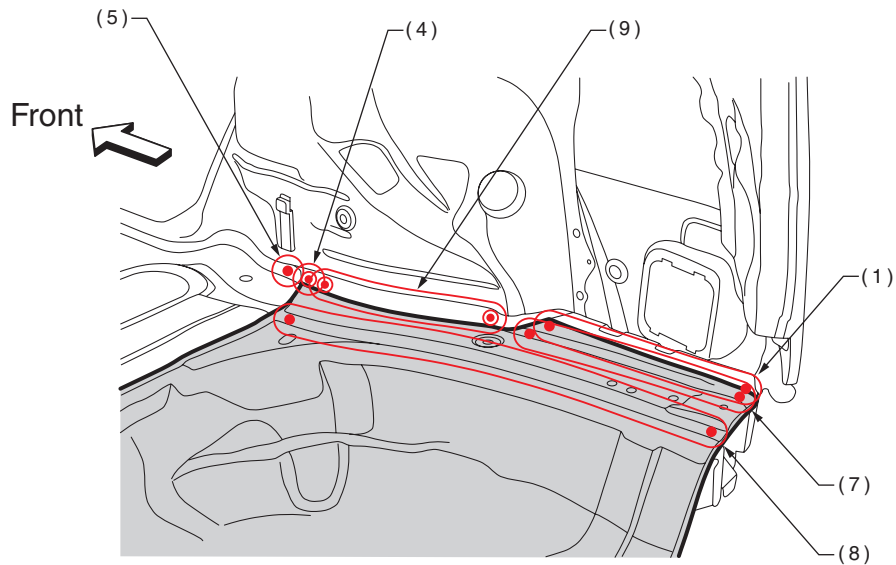
NOTE:

- The illustration indicates the removal condition of the rear skirt.
- For locations marked by ★, the welding method and the number of welding points are the same on the left and the right.

Rear Floor Pan (Total Replacement)



B View (LH)



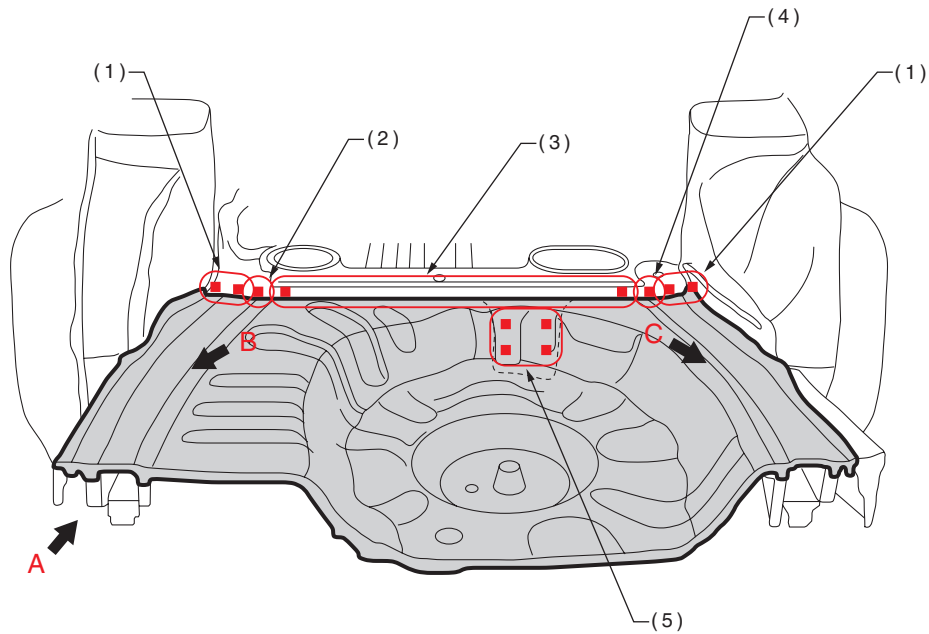
C View (RH)

BS-02794

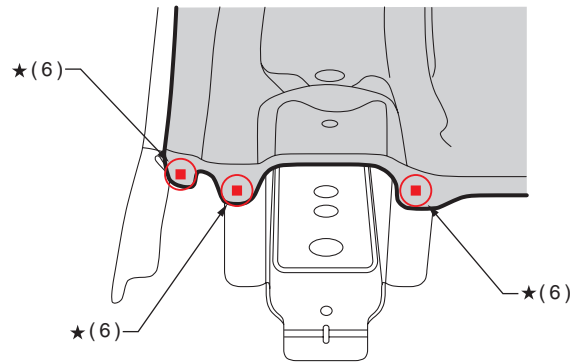
- | | | |
|---------------------------|--------------------------|----------------------------|
| (1) 8 points (top · 1) | (4) 1 point (inside · 2) | (7) 11 points (top · 1) |
| (2) 15 points (top · 1) | (5) 1 point (inside · 1) | (8) 17 points (top · 1) |
| (3) 7 points (inside · 1) | (6) 15 points (top · 1) | (9) 13 points (inside · 1) |

Rear Floor Pan (Total Replacement)

B: INSTALLATION



Front



A View

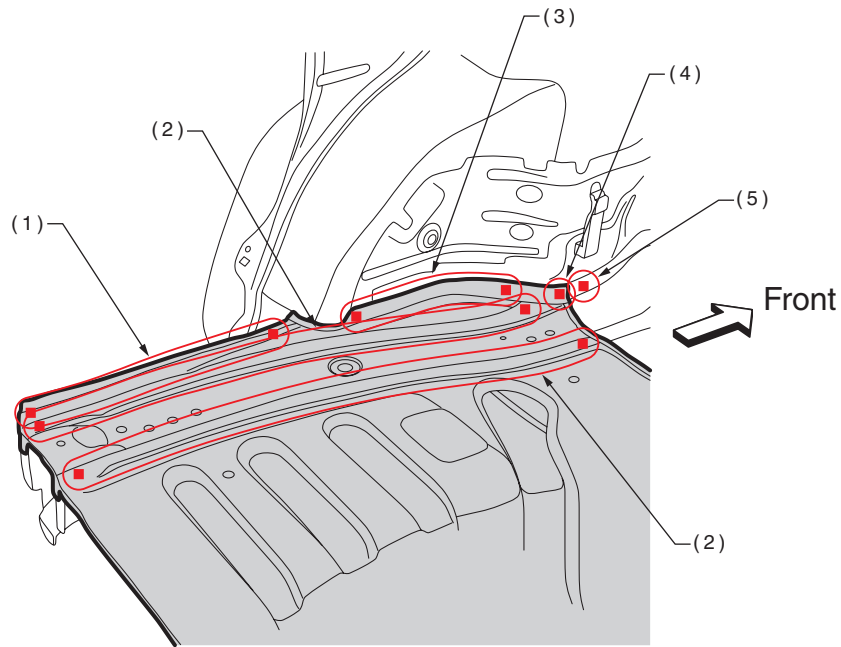
BS-02883

- | | | |
|----------------------------------|------------------------------------|-------------------------|
| (1) 2 points | (3) 21 points (service · matching) | (5) 10 points (service) |
| (2) 1 point (service · matching) | (4) 2 points (service · matching) | (6) 1 point |

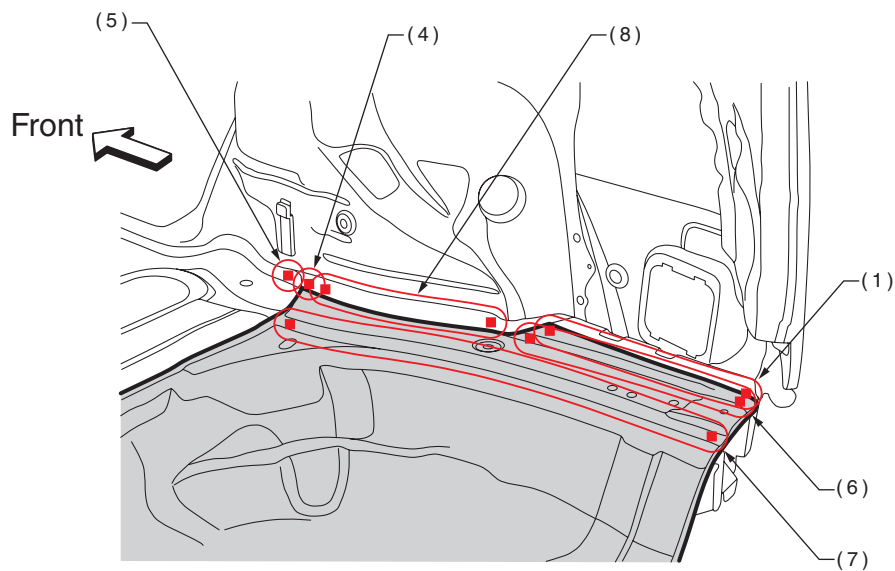
NOTE:

- The illustration indicates the removal condition of the rear skirt.
- For locations marked by ★, the welding method and the number of welding points are the same on the left and the right.

Rear Floor Pan (Total Replacement)



B View (LH)



C View (RH)

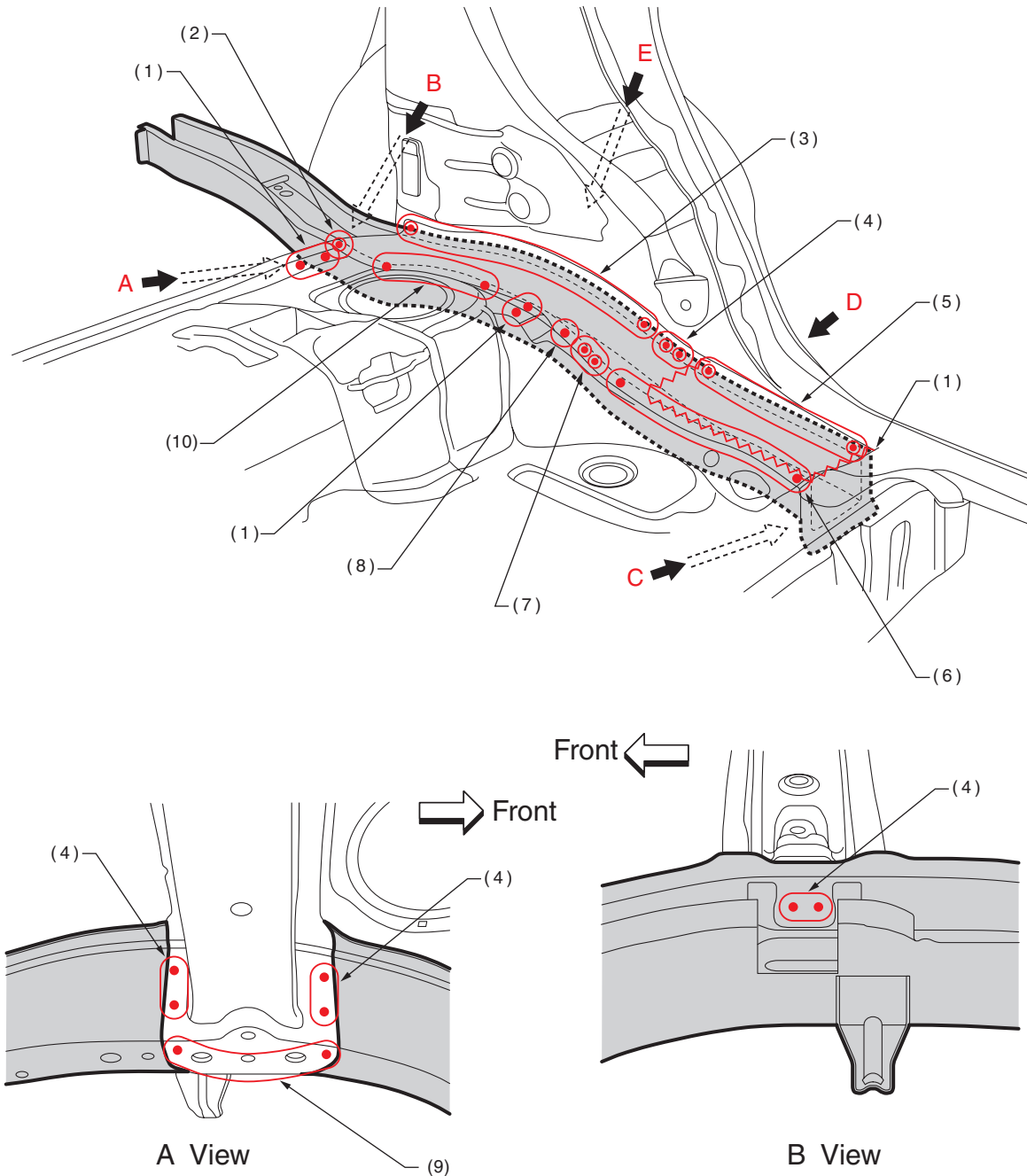
BS-02884

- | | | |
|-------------------------|----------------------------------|-------------------------|
| (1) 8 points (service) | (4) 1 point (service · matching) | (7) 17 points (service) |
| (2) 15 points (service) | (5) 1 point | (8) 13 points (service) |
| (3) 7 points (service) | (6) 11 points (service) | |

Rear Frame (Total Replacement)

27.Rear Frame (Total Replacement)

A: REMOVAL



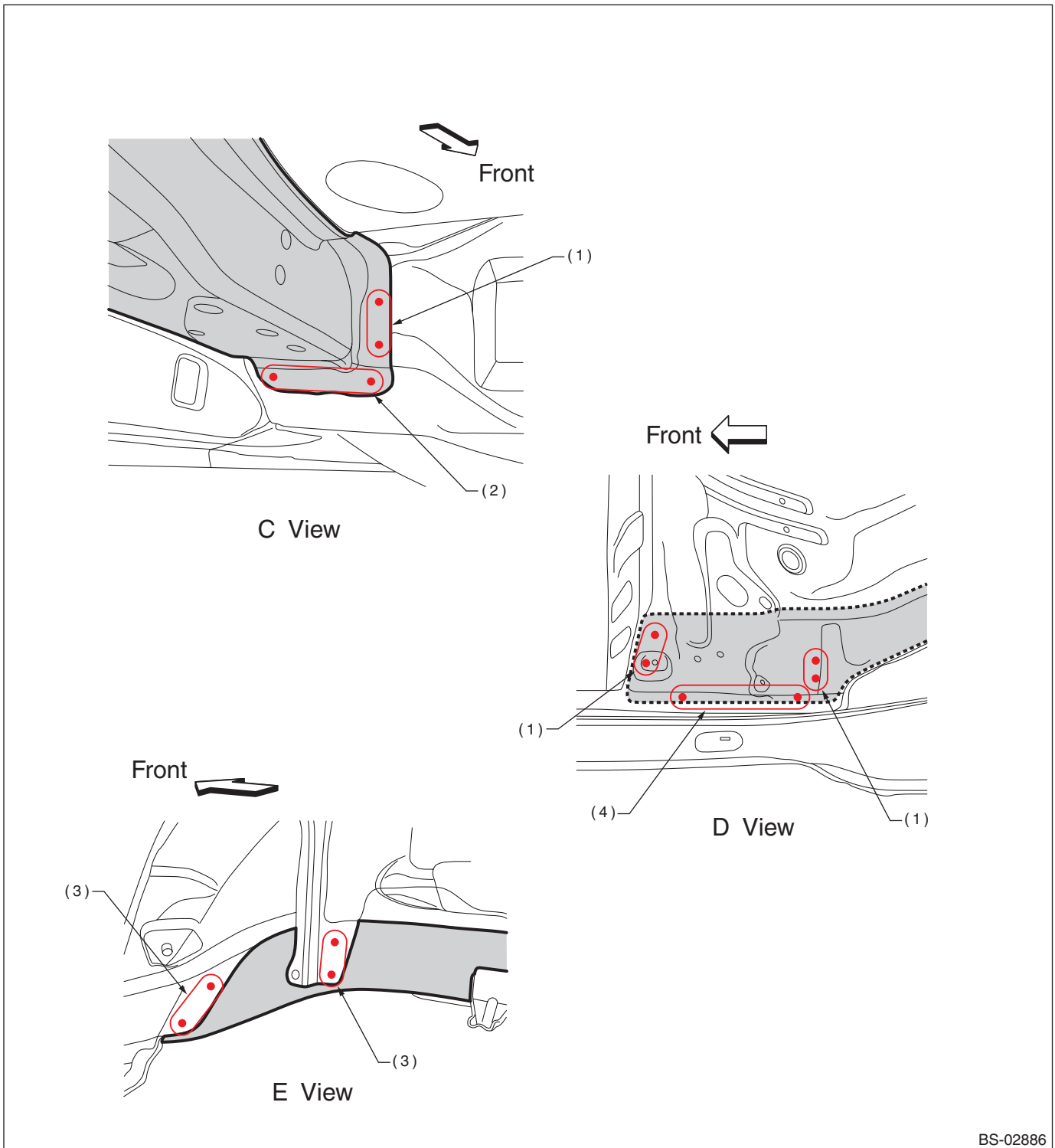
BS-02885

- | | | |
|----------------------------|------------------------|---------------------------|
| (1) 2 points (top · 1) | (5) 8 points (top · 2) | (8) 1 point (top · 1) |
| (2) 1 point (top · 2) | (6) 9 points (top · 1) | (9) 4 points (bottom · 1) |
| (3) 18 points (inside · 1) | (7) 3 points (top · 1) | (10) 5 points (top · 1) |
| (4) 2 points (inside · 1) | | |

Rear Frame (Total Replacement)

NOTE:

- To make the removal easier, cut the side frame and detach the hidden hit point of crossmember B. (View B)
- The illustration indicates the removal condition of the rear skirt and rear floor pan.



BS-02886

(1) 2 points (inside · 1)

(2) 4 points (bottom · 1)

(3) 2 points (outside · 1)

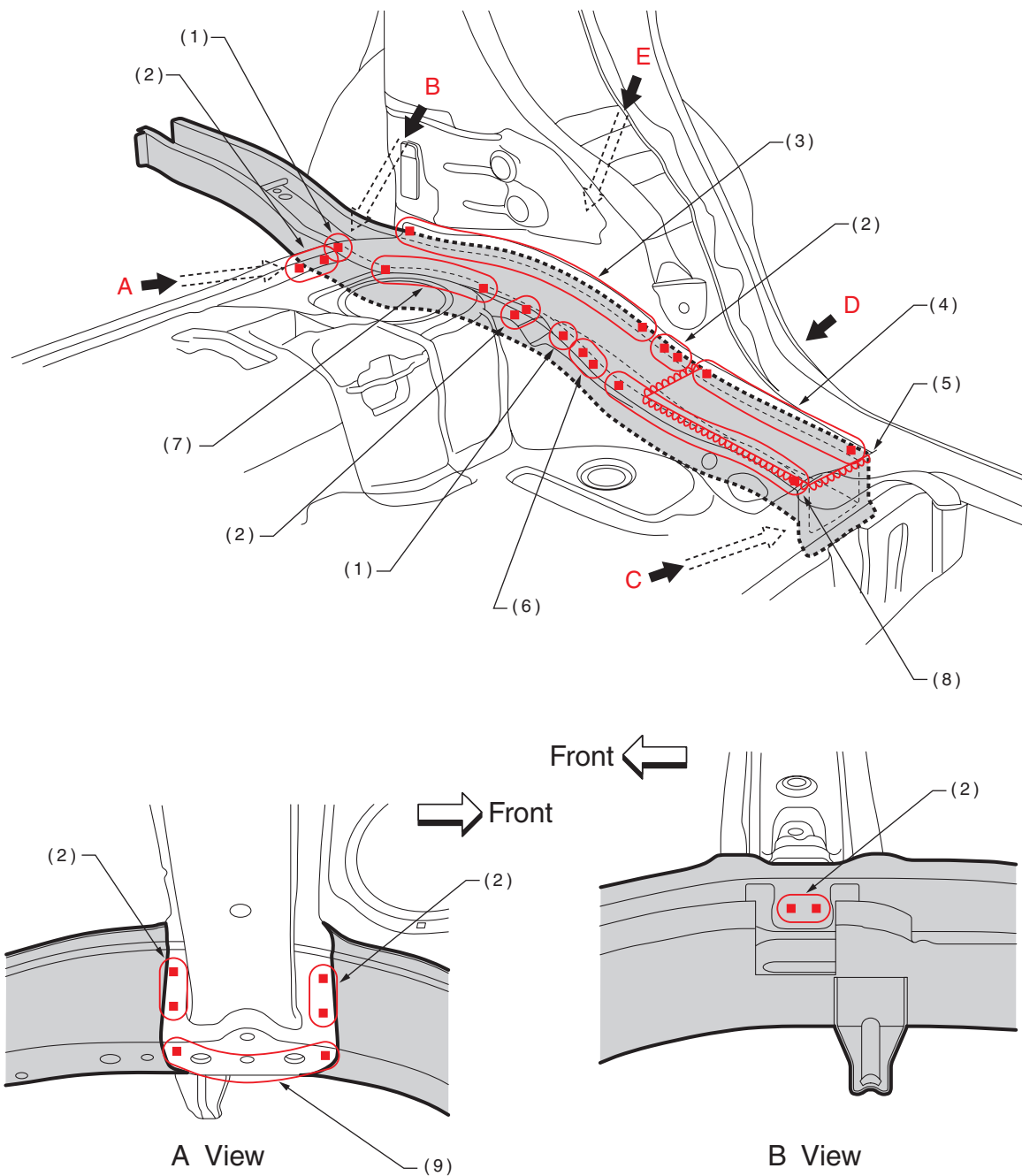
(4) 4 points (inside · 1)

NOTE:

The illustration indicates the removal condition of the rear skirt and rear floor pan.

Rear Frame (Total Replacement)

B: INSTALLATION



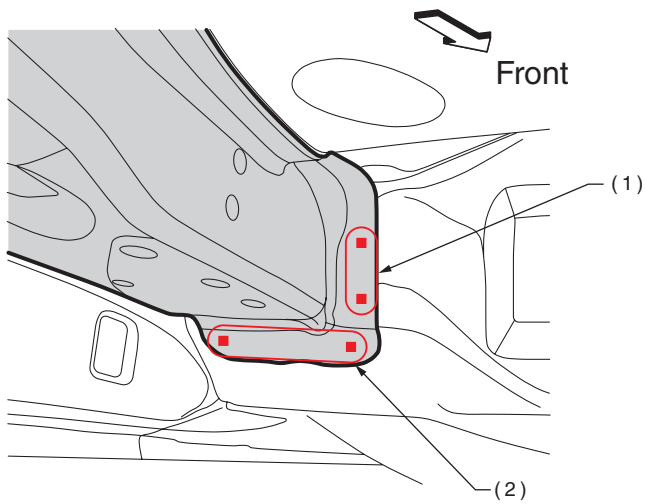
BS-02887

- | | | |
|----------------------------|--------------------------------|--------------|
| (1) 1 point | (4) 8 points | (7) 5 points |
| (2) 2 points | (5) 1 point (550 mm) (21.7 in) | (8) 9 points |
| (3) 18 points (inside · 1) | (6) 3 points | (9) 4 points |

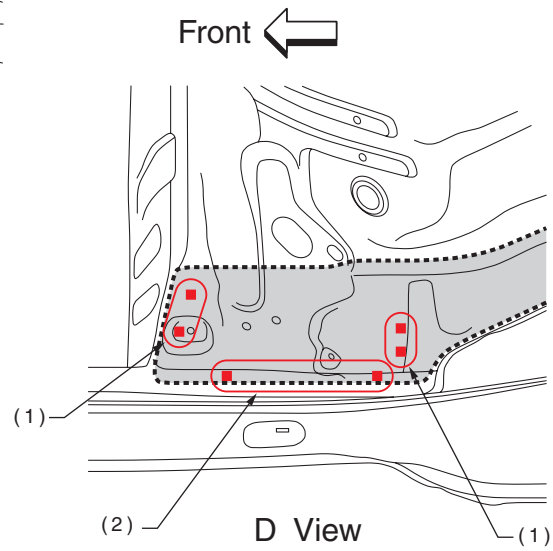
NOTE:

- The illustration indicates the removal condition of the rear skirt and rear floor pan.
- The illustration indicates the hidden hit point of the crossmember. (View B)

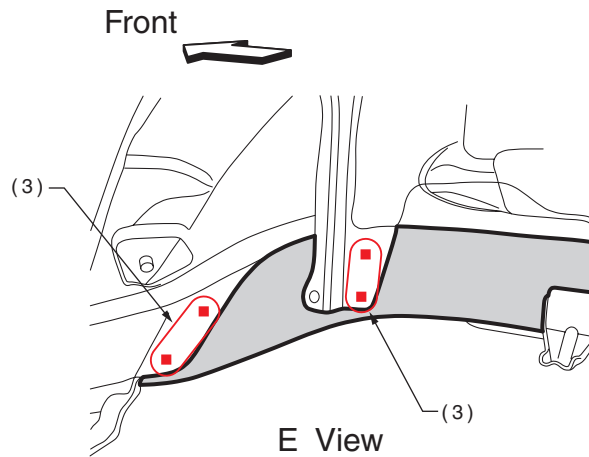
Rear Frame (Total Replacement)



C View



D View



E View

BS-02888

(1) 2 points (service)

(2) 4 points (service)

(3) 2 points

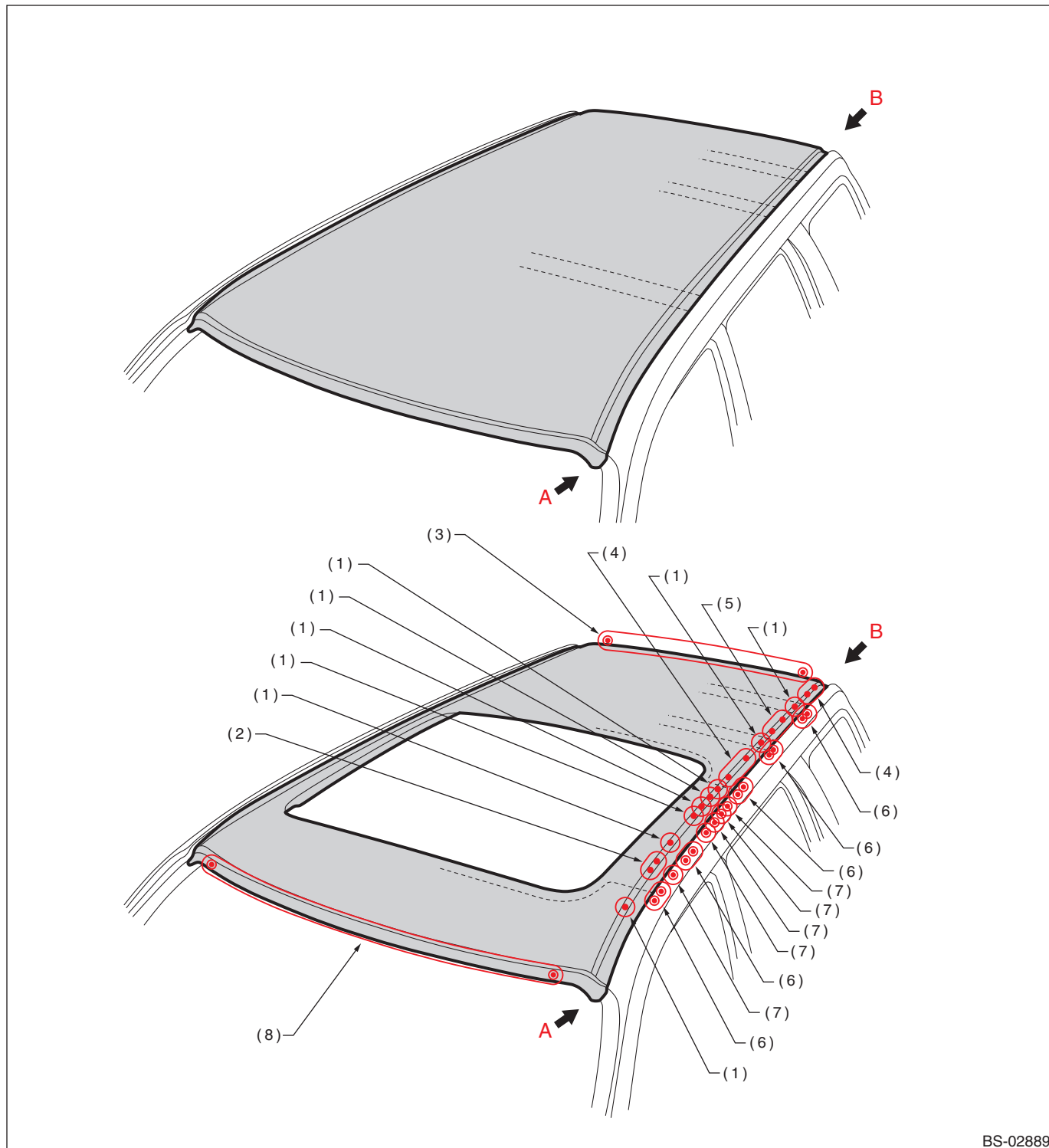
NOTE:

The illustration indicates the removal condition of the rear skirt and rear floor pan.

Roof Panel (Total Replacement)

28.Roof Panel (Total Replacement)

A: REMOVAL

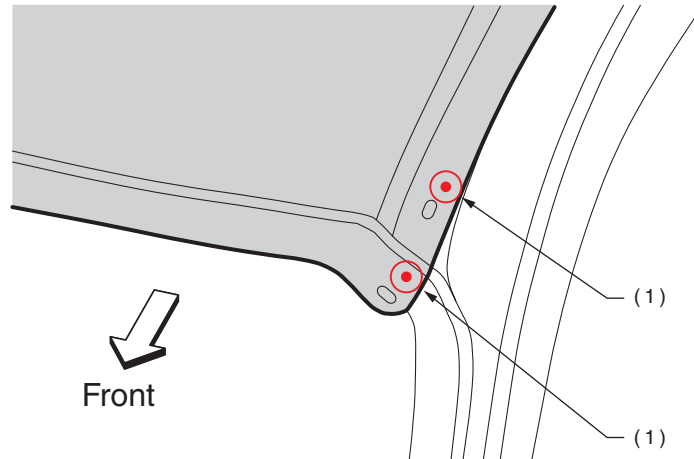


- (1) 1 point (top · 1)
- (2) 2 points (top · 1)
- (3) 13 points (top · 1)

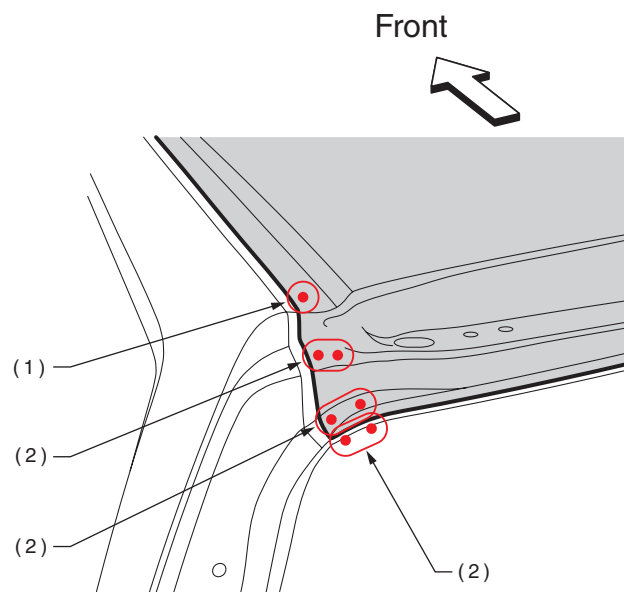
- (4) 3 points (top · 1)
- (5) 4 points (top · 1)
- (6) 2 points (top · 2)

- (7) 1 point (top · 2)
- (8) 15 points (top · 1)

Roof Panel (Total Replacement)



A View



B View

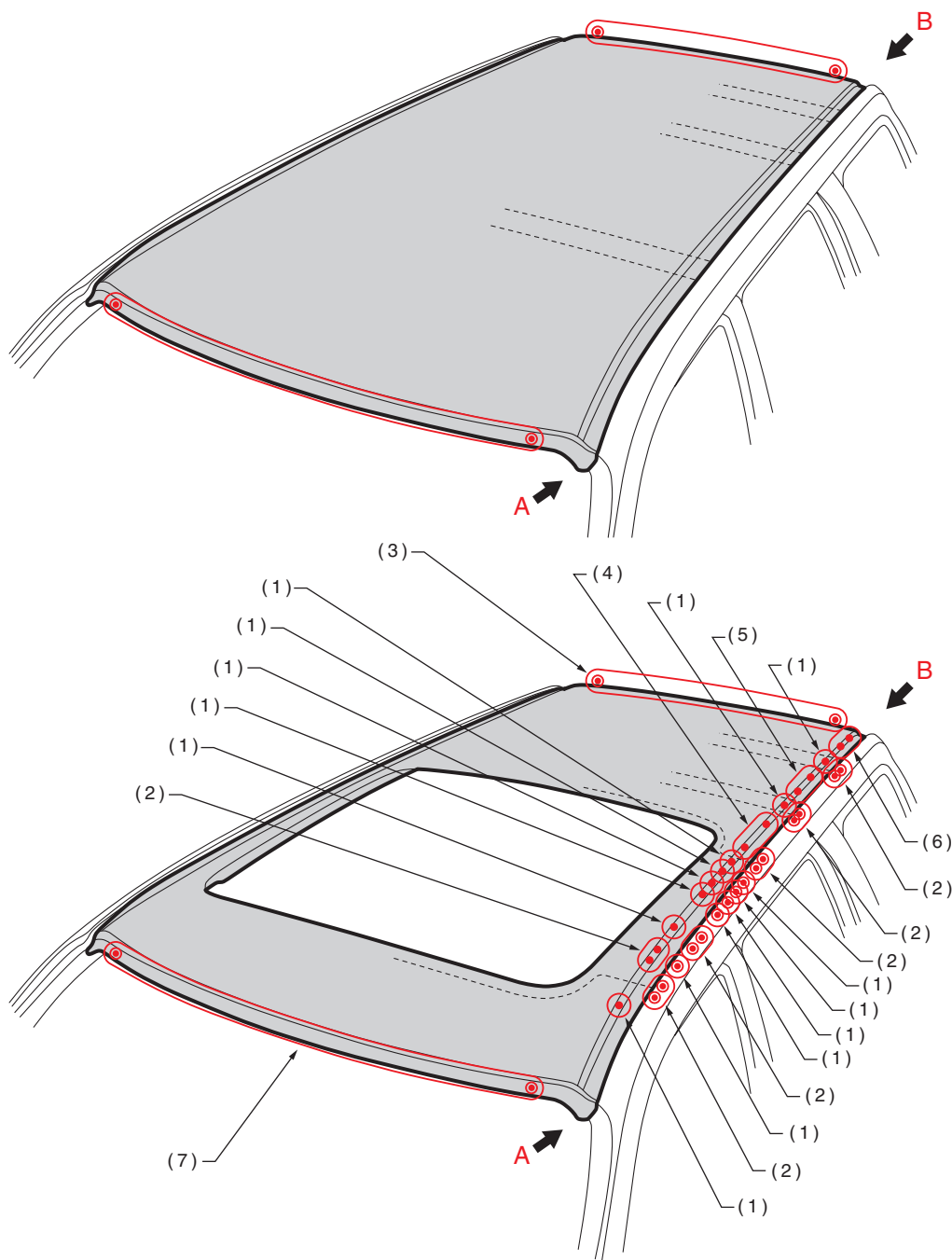
BS-02802

(1) 1 point (top · 1)

(2) 2 points (top · 1)

Roof Panel (Total Replacement)

B: INSTALLATION



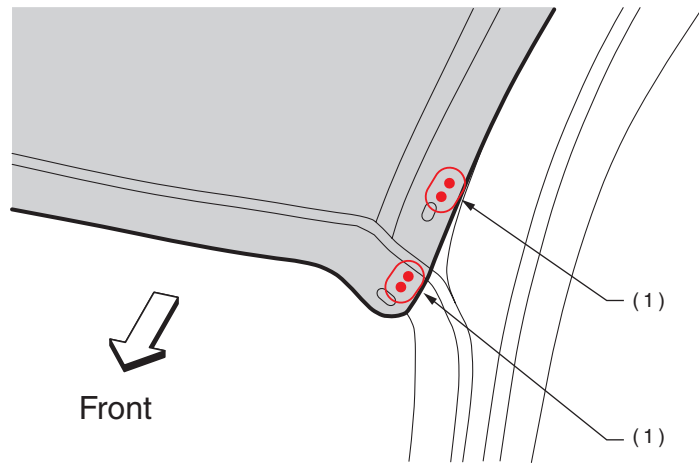
BS-02890

- (1) 1 point
- (2) 2 points
- (3) 16 points

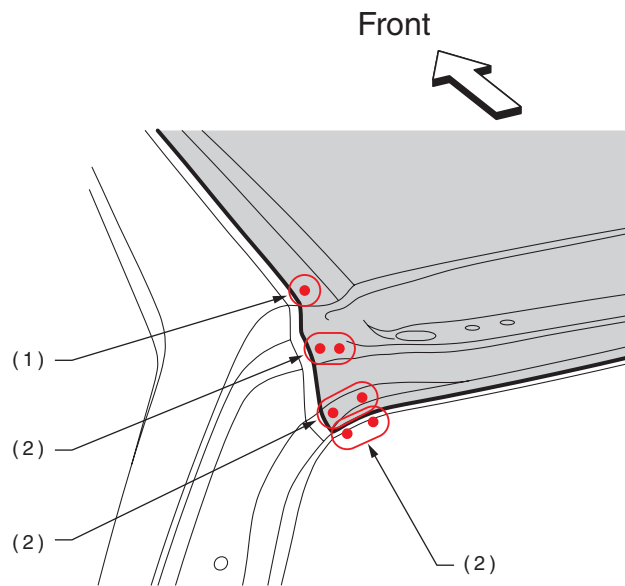
- (4) 4 points
- (5) 5 points

- (6) 3 points
- (7) 19 points

Roof Panel (Total Replacement)



A View



B View

BS-02804

(1) 2 points

(2) 3 points