

BODY REPAIR MANUAL

BS

	Page
1. Foreword	2
2. Panel Components	6
3. Body Construction	17
4. Gauge Values for Fitting	23
5. Plastic Parts and Materials	29
6. List of Plastic Material Notations	32
7. Body Sealing	33
8. Anticorrosion Wax	39
9. Undercoat	42
10. Sub Frame	44
11. Body Reference Points	46
12. Radiator Panel (total replacement)	63
13. Front Wheel Apron (total replacement)	67
14. Front Side Frame Front (total replacement)	72
15. Toe Board Lower Reinforcement (total replacement)	76
16. Front Pillar Outer (partial replacement)	80
17. Rear Quarter (partial replacement) / Wagon	87
18. Rear Quarter (partial replacement) / Sedan	91
19. Rear Pillar Reinforcement (total replacement) / Sedan	95
20. Rear Pillar Inner (total replacement) / Sedan	97
21. D-pillar Inner Lower (total replacement) / Wagon	99
22. Rear Floor Side (total replacement) (right side)	101
23. Rear Floor Side (total replacement) (left side)	103
24. Rear Skirt (total replacement) / Wagon	105
25. Rear Skirt (total replacement) / Sedan	108
26. Rear Floor Pan Rear (total replacement)	110
27. Rear Side Frame (total replacement)	115
28. Side Sill Outer (partial replacement)	121
29. Rear Panel (total replacement)	125
30. Roof Panel (total replacement) / Wagon	127
31. Roof Panel (total replacement) / Sedan	131
32. Roof Panel / T-stud	134
33. Center Pillar Outer (partial replacement)	136
34. D-pillar Reinforcement (partial replacement) / Wagon	142

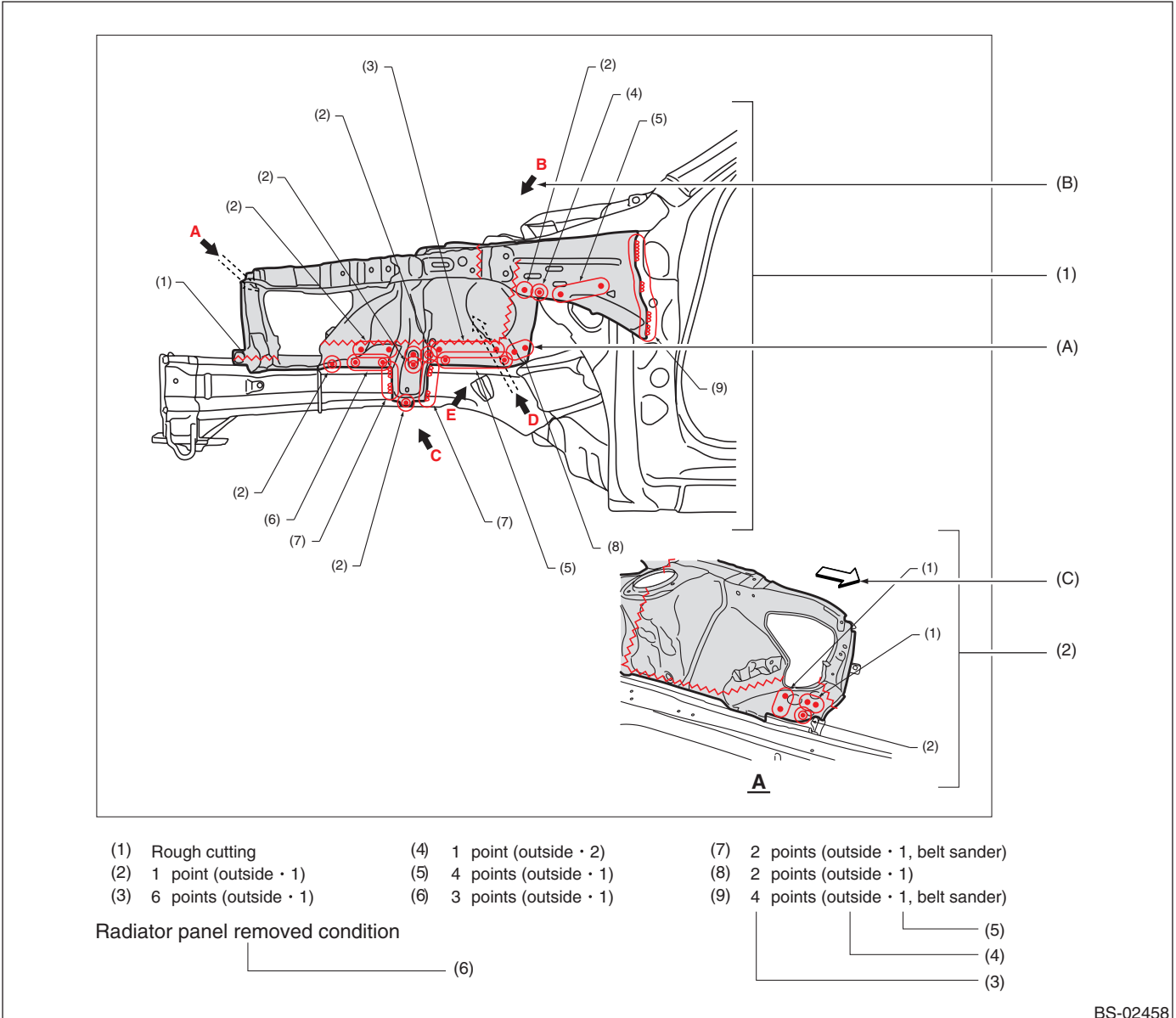
1. Foreword

A: USE OF THIS MANUAL

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

1. ILLUSTRATION EXAMPLE

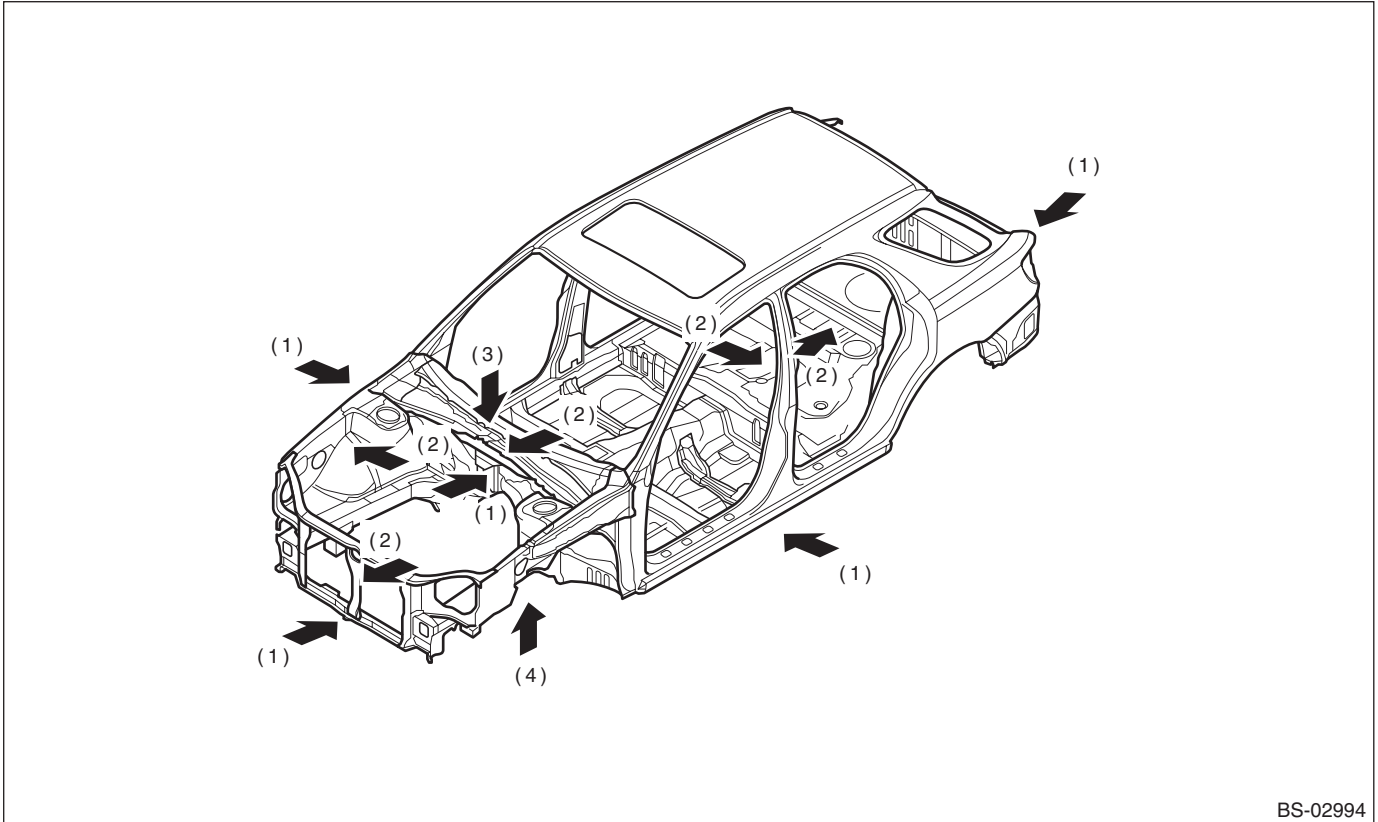
- Symbols and number of points indicate the welding method and the number of welding points. Text in brackets indicate the direction of removal for welded parts, and numbers indicate the number of panels to be drilled to remove welded sections of panels.
- Areas enclosed by a broken line indicates work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



- | | |
|------------------------------------|------------------------------|
| (1) Overall view | (A) Welding method |
| (2) Views | (B) View direction |
| (3) Number of welding points etc. | (C) Towards front of vehicle |
| (4) Removal direction | |
| (5) Number of panels to be drilled | |
| (6) Cautions when working, etc. | |

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.

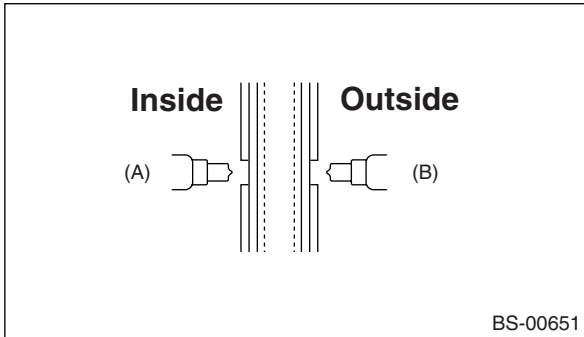


- (1) Outside
- (2) Inside
- (3) Top
- (4) Bottom

3. NUMBER OF PANELS TO BE DRILLED

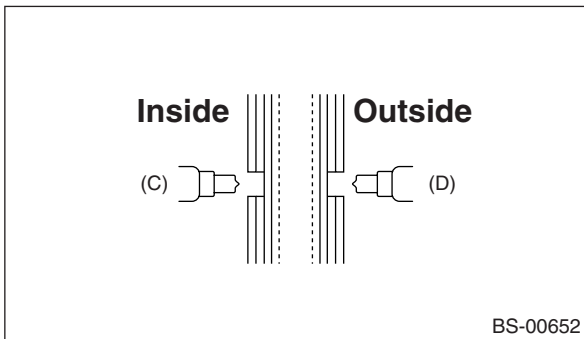
Depending on the number of panels, drilling is performed through one or two panels, and this is listed together with the removal direction.

(1) Drilling through one plate



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

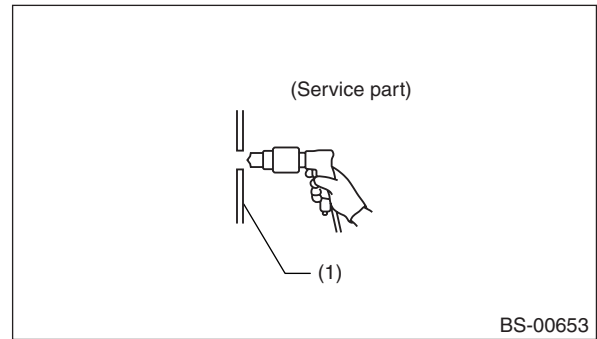
(2) Drilling through two plates



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

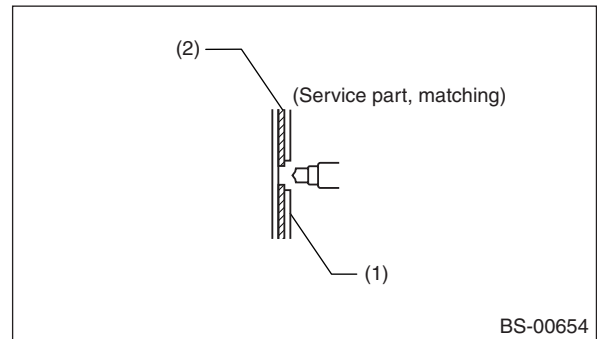
4. HOLE DRILLING FOR PLUG WELDING

(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

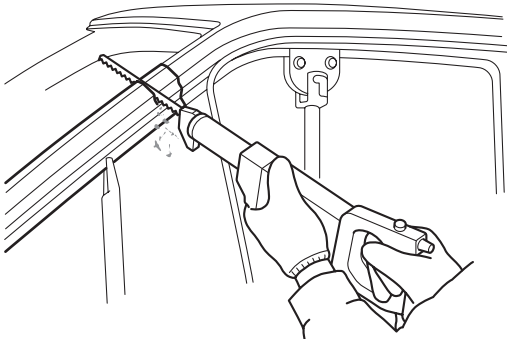


- (1) Vehicle side
- (2) Service part

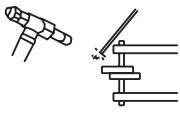
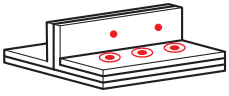
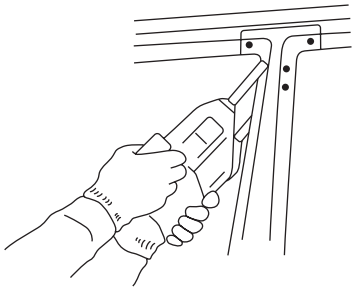
Foreword

5. MEANING OF SYMBOLS

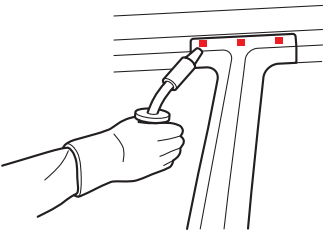
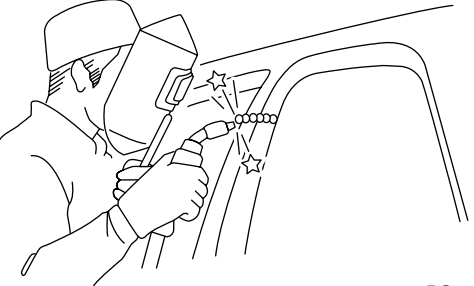
• Cutting

 BS-00352	 BS-00267
---	--

• Spot welding

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

• Carbon dioxide gas arc welding (MIG welding)

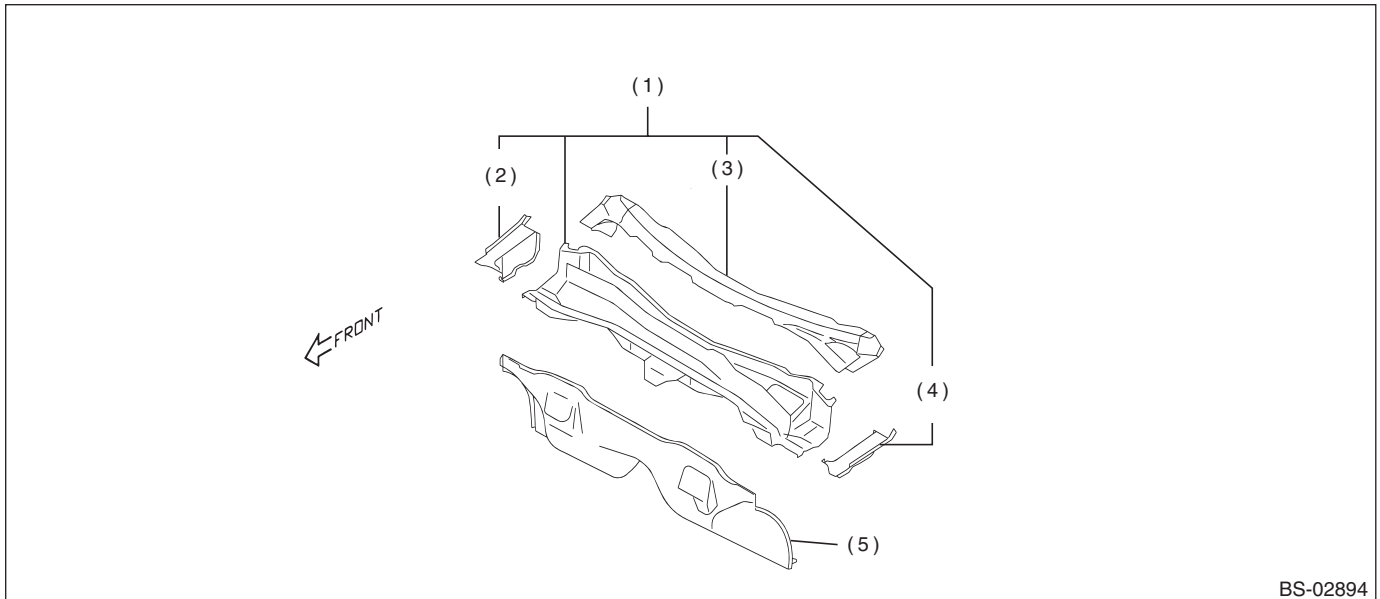
Plug welding	 BS-00661	 BS-00662	 BS-00663
Continuous welding	 BS-00664	 BS-00665	 BS-00666

Panel Components

2. Panel Components

A: COMPONENTS

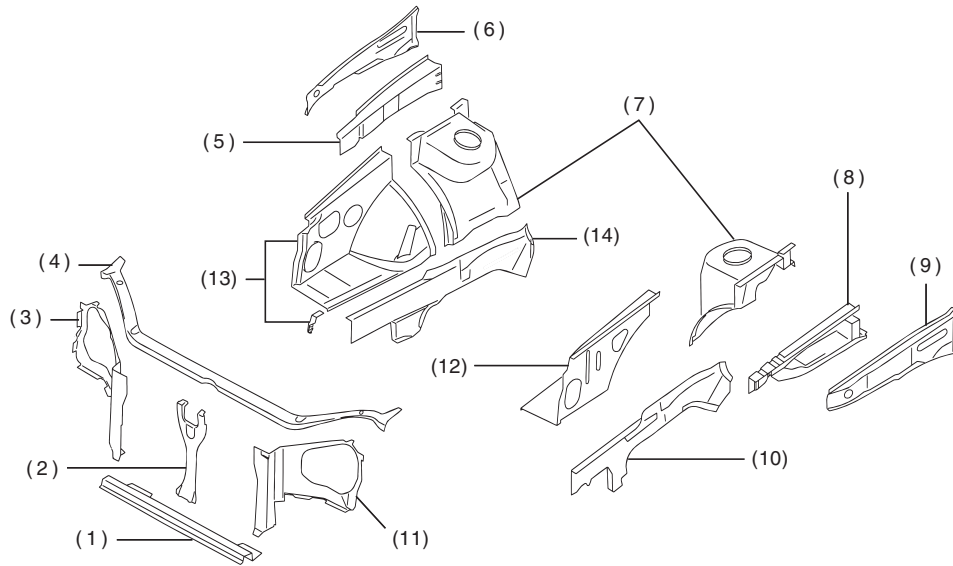
1. TOE BOARD & FRONT PANEL



- | | | |
|--------------------------|--------------------------|---------------|
| (1) Duct | (3) Front panel | (5) Toe board |
| (2) Front bulkhead frame | (4) Front bulkhead frame | |

Panel Components

2. RADIATOR PANEL & FRONT WHEEL APRON

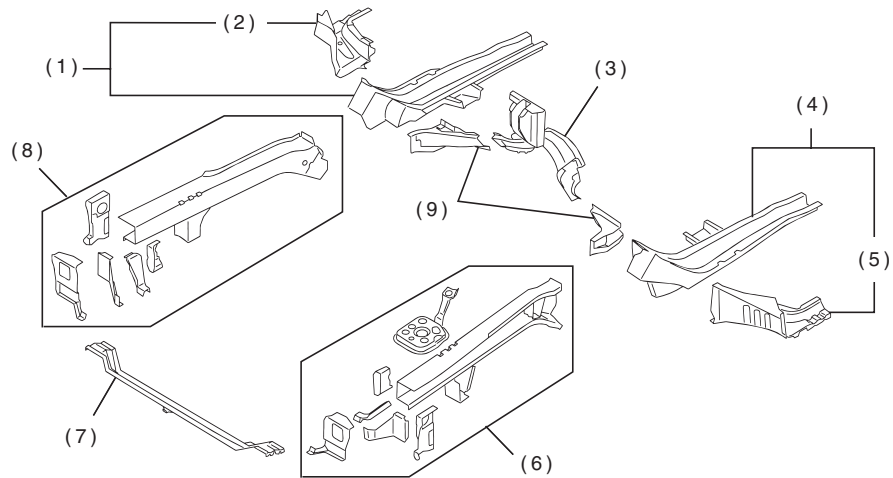


BS-02895

- | | | |
|-----------------------------|------------------------------|--------------------------|
| (1) Radiator lower frame A | (6) Side upper frame | (11) Radiator side panel |
| (2) Hood lock stay | (7) Front suspension bracket | (12) Front wheel apron |
| (3) Radiator side panel | (8) Front wheel apron upper | (13) Front wheel apron |
| (4) Radiator upper frame | (9) Side upper frame | (14) Closing plate |
| (5) Front wheel apron upper | (10) Closing plate | |

Panel Components

3. FRONT SIDE FRAME

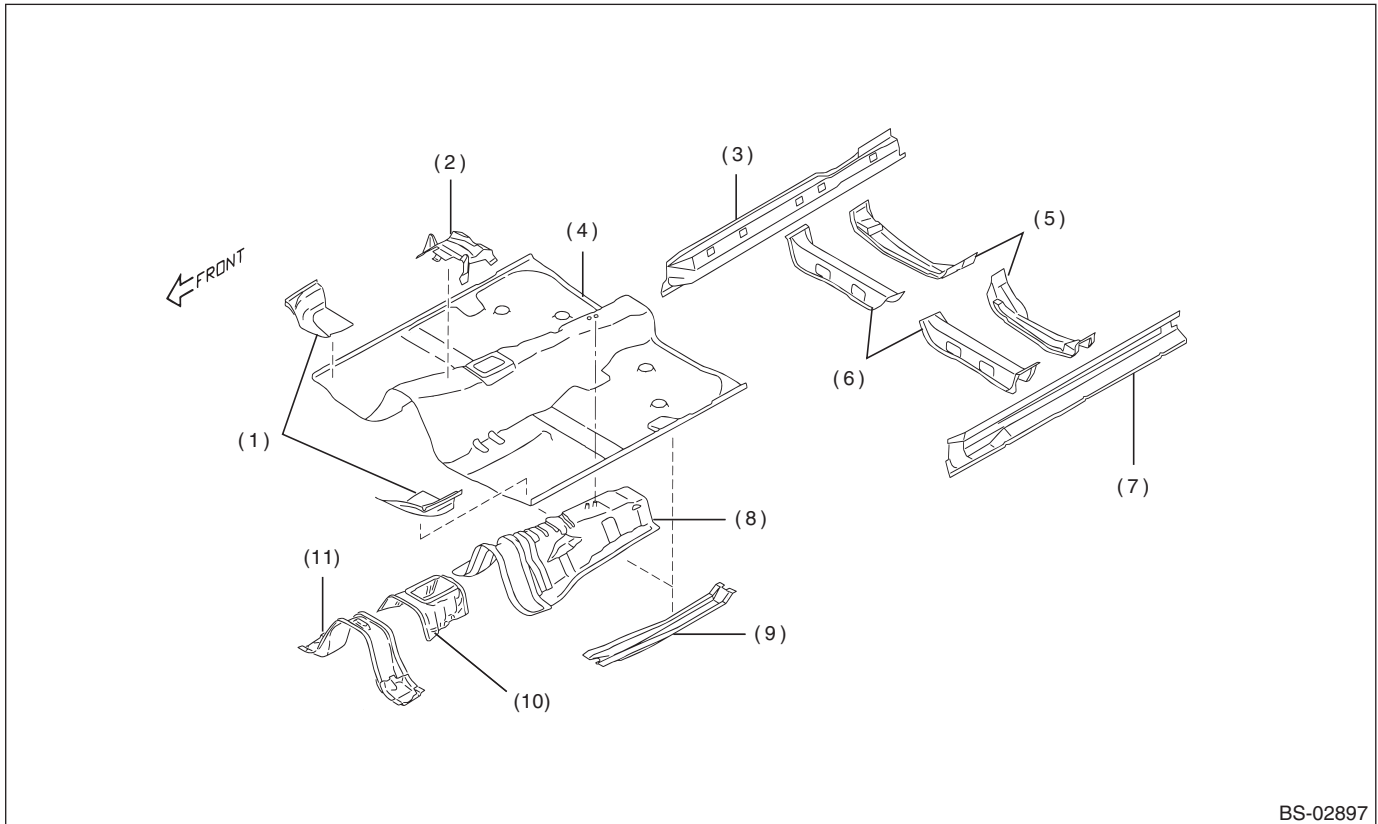


BS-02896

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

Panel Components

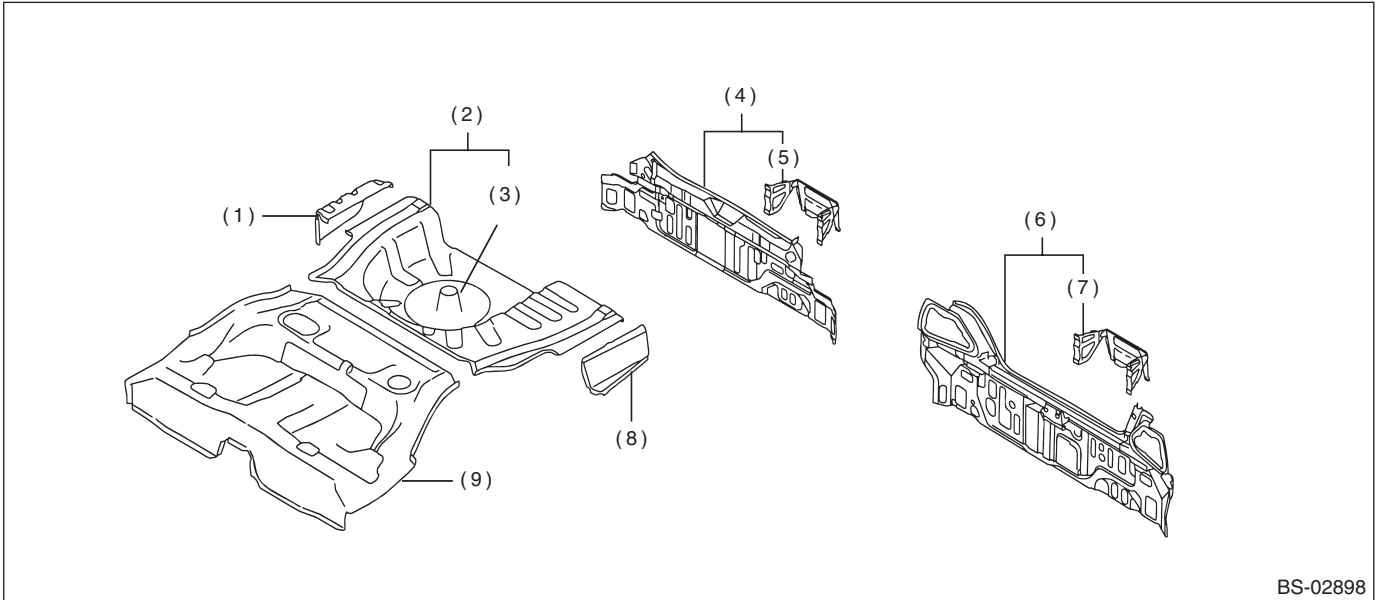
4. FRONT FLOOR PANEL



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

Panel Components

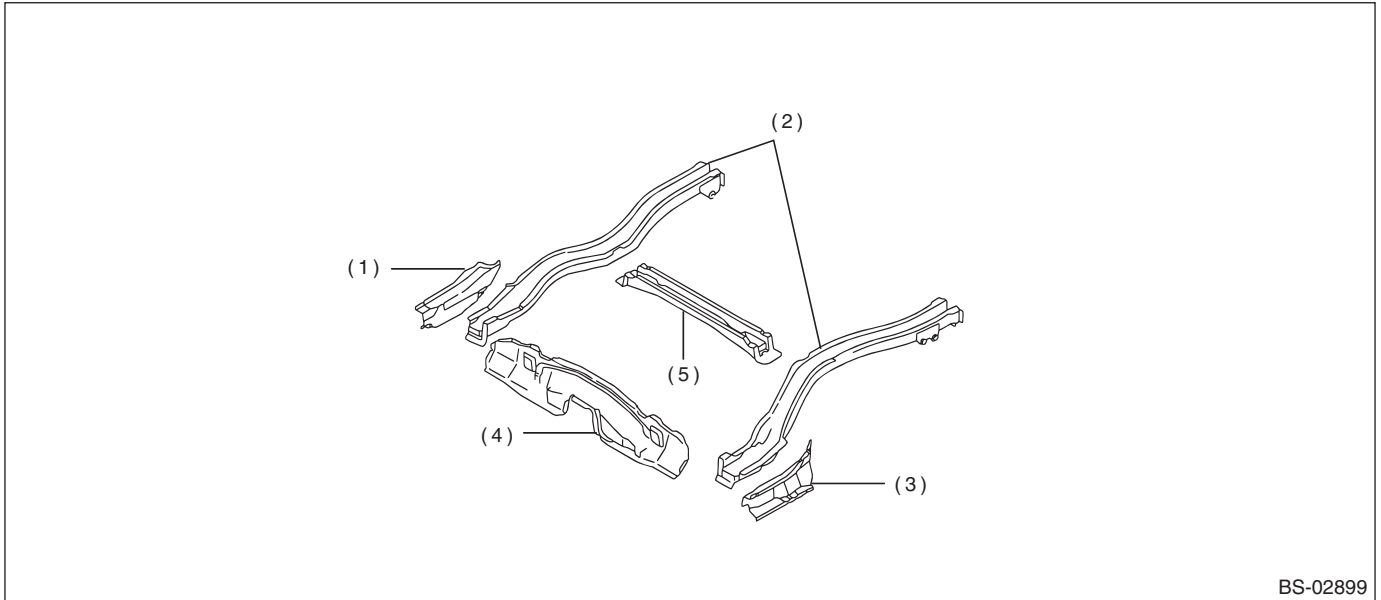
5. REAR FLOOR PANEL & REAR SKIRT



- | | | |
|-------------------------|---------------------------|-------------------------------|
| (1) Rear floor side | (4) Rear skirt (wagon) | (7) License plate bracket |
| (2) Rear floor pan rear | (5) License plate bracket | (8) Rear floor side |
| (3) Spare tire bracket | (6) Rear skirt (sedan) | (9) NS (rear floor pan front) |

Panel Components

6. REAR FLOOR SIDE FRAME



- (1) Sill side inner rear
- (2) Rear floor side frame

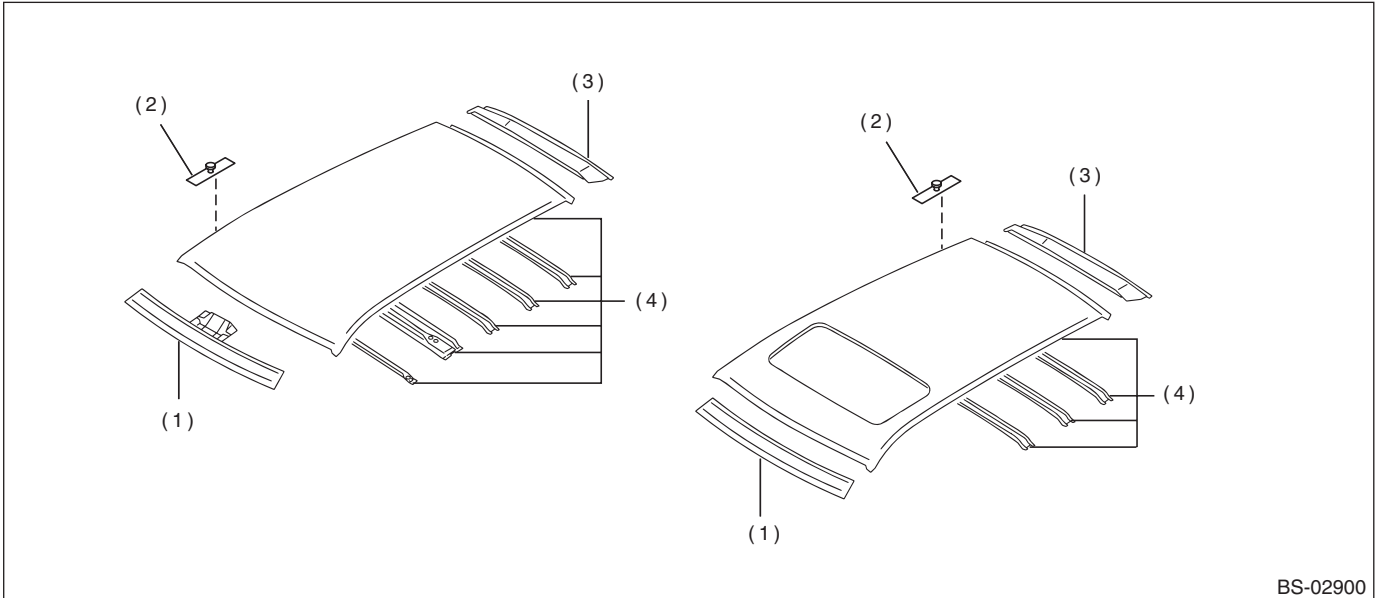
- (3) Sill side inner rear
- (4) NS (crossmember A)

- (5) Crossmember B

Panel Components

7. ROOF

• Wagon

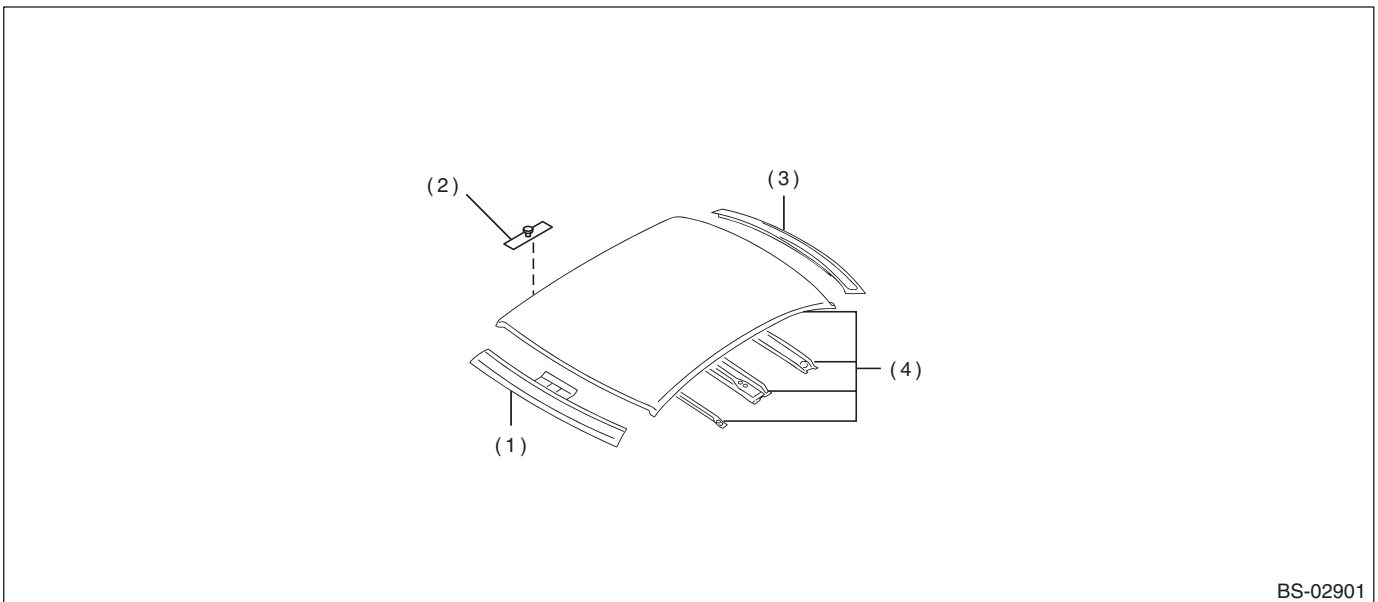


- (1) Front roof rail
(2) T-stud

- (3) Rear roof rail

- (4) Roof panel

• Sedan



- (1) Front roof rail
(2) T-stud

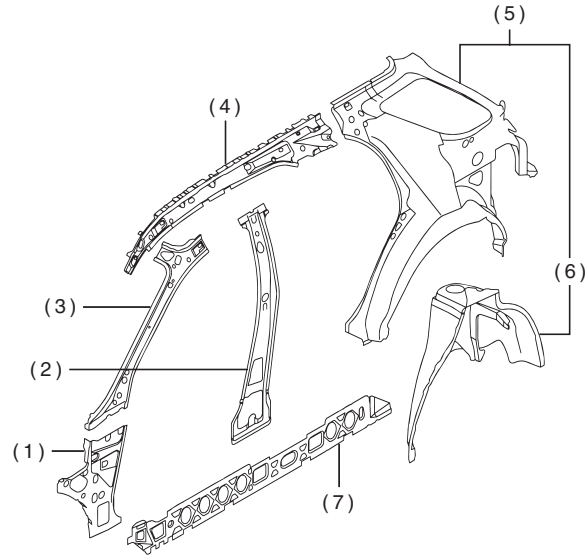
- (3) Rear roof rail

- (4) Roof panel

Panel Components

8. SIDE PANEL INNER

• Wagon



BS-02902

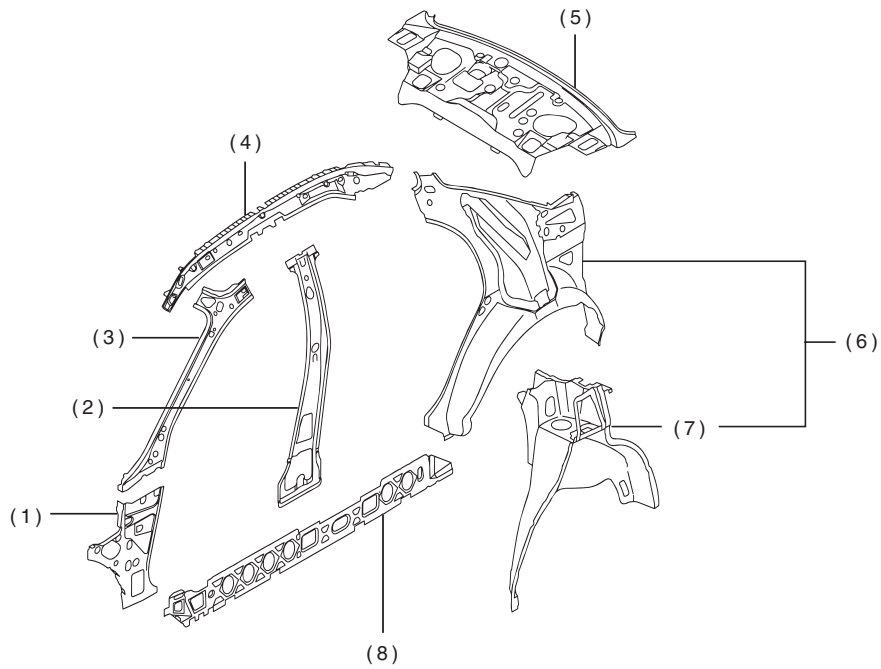
- (1) Front pillar inner lower
- (2) Center pillar inner
- (3) Front pillar inner upper

- (4) Side rail inner
- (5) Rear quarter inner

- (6) Rear wheel apron
- (7) Side sill reinforcement

Panel Components

• Sedan



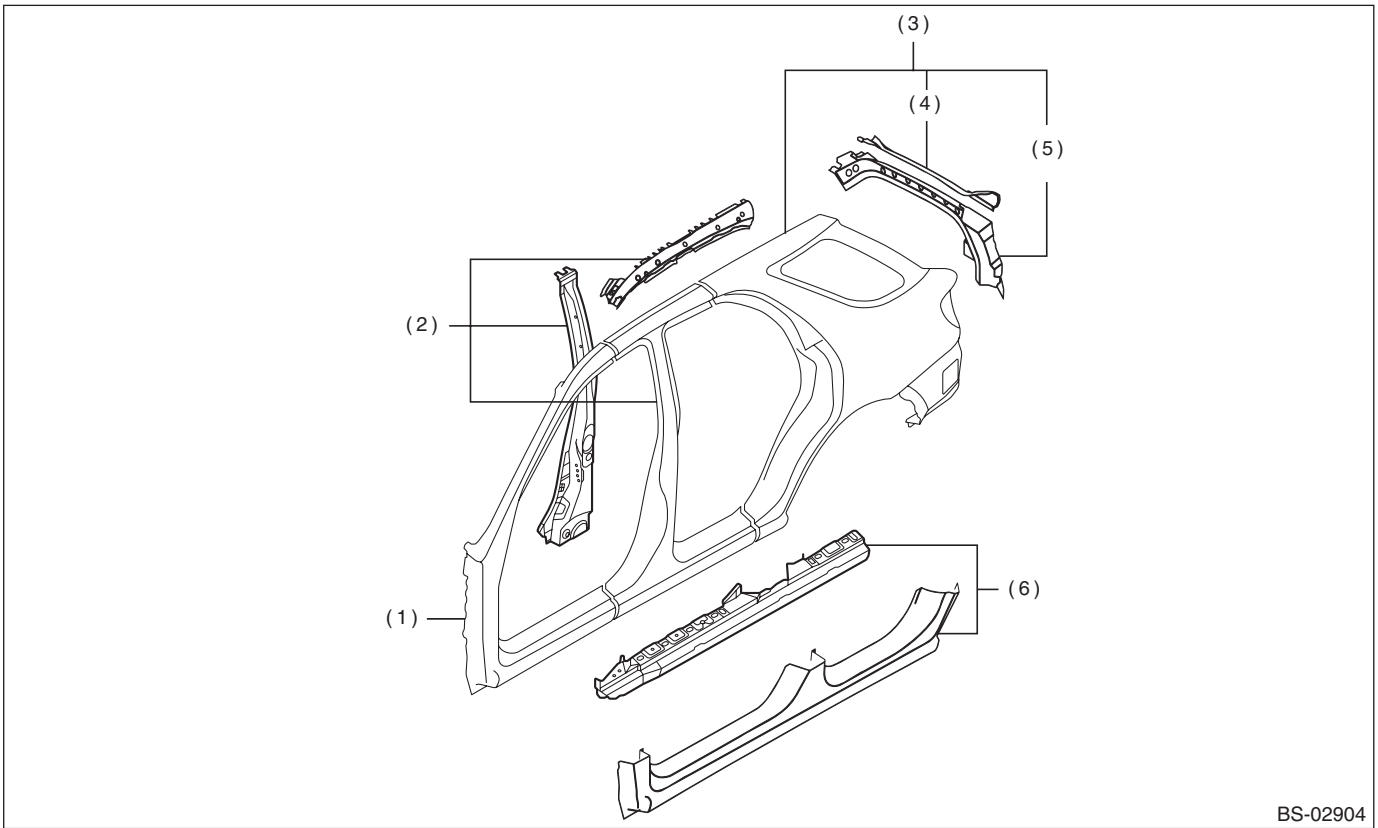
BS-02903

- | | | |
|------------------------------|------------------------|-----------------------------|
| (1) Pillar front inner lower | (4) Side rail inner | (7) Rear wheel apron |
| (2) Center pillar inner | (5) Rear panel | (8) Side sill reinforcement |
| (3) Front pillar inner upper | (6) Rear quarter inner | |

Panel Components

9. SIDE PANEL OUTER

• Wagon



BS-02904

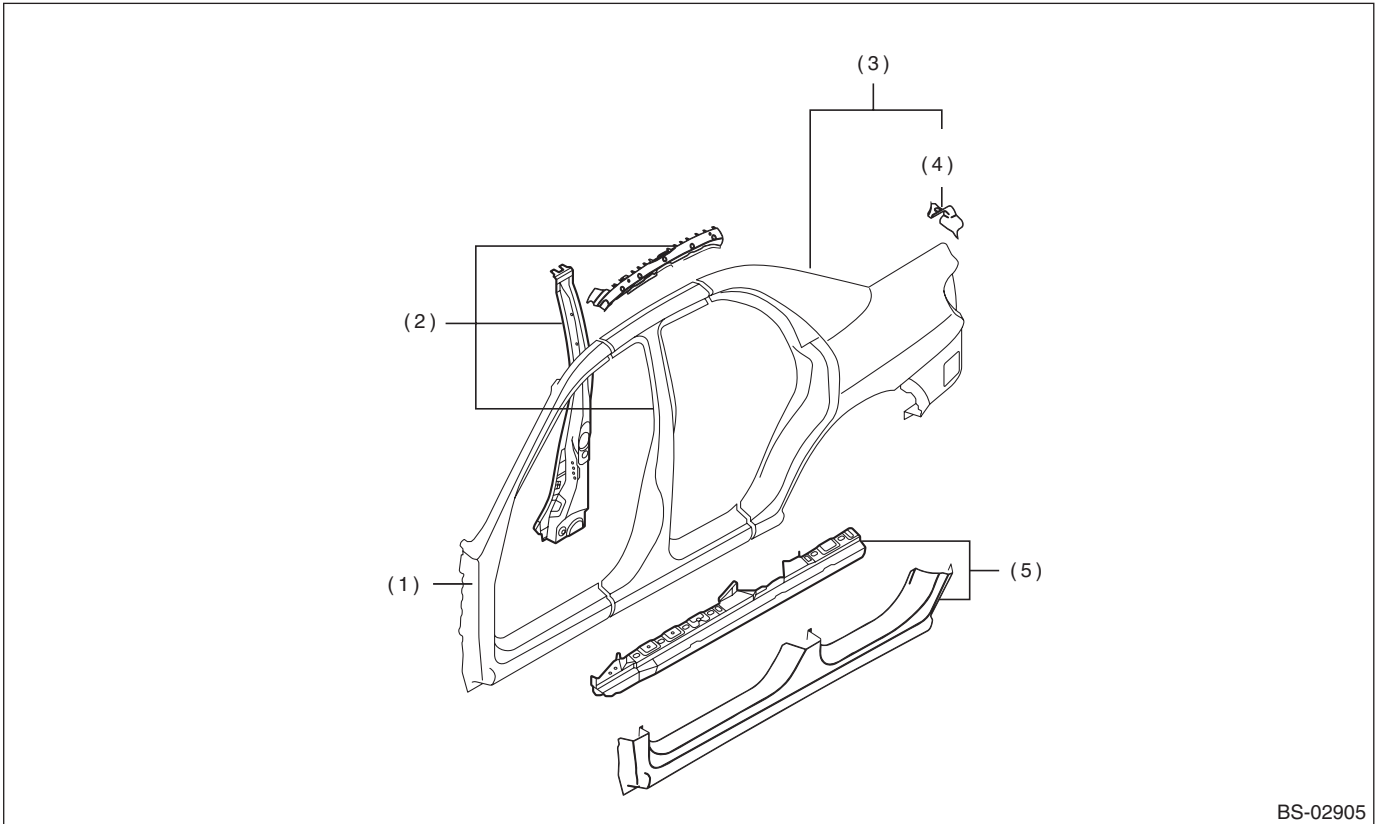
- (1) Front pillar outer
- (2) Center pillar outer

- (3) Rear quarter outer
- (4) D-pillar extension

- (5) D-pillar reinforcement
- (6) Side sill outer

Panel Components

- Sedan



BS-02905

- (1) Front pillar outer
- (2) Center pillar outer

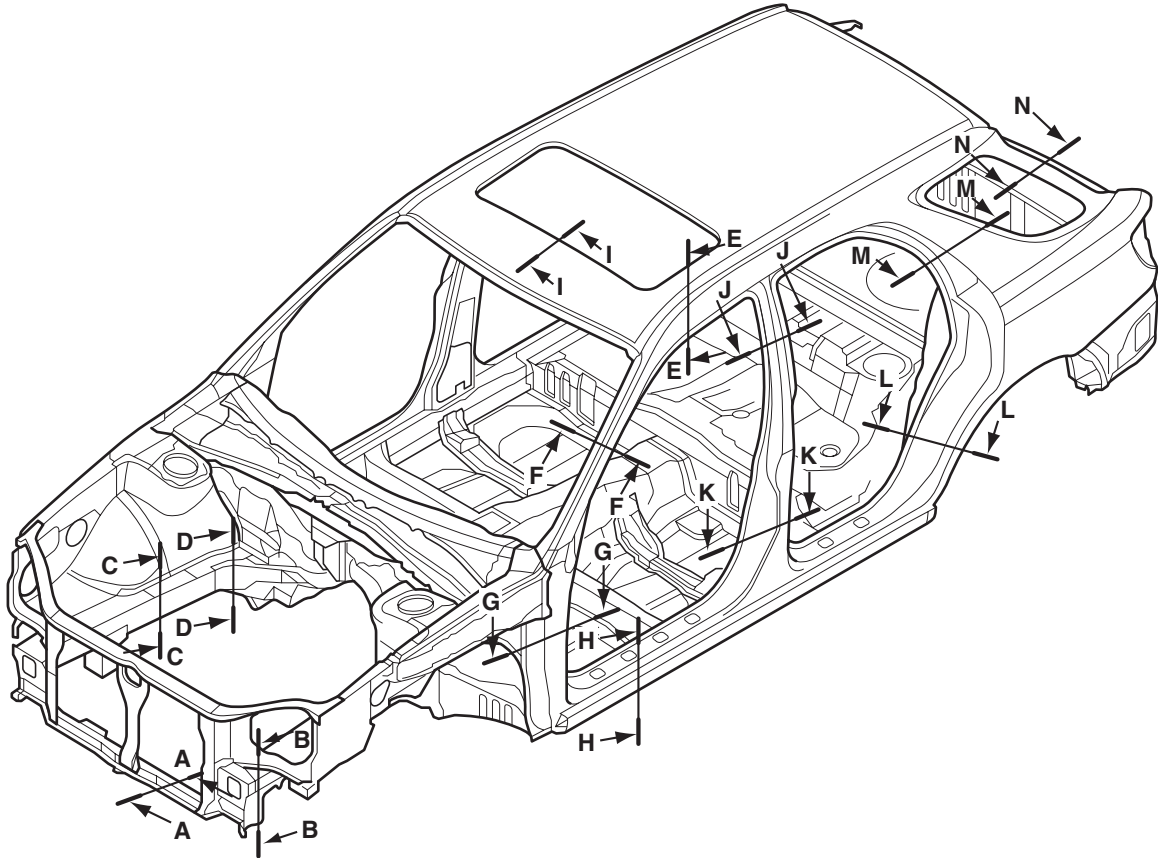
- (3) Rear quarter outer
- (4) Rear quarter end patch

- (5) Side sill outer

3. Body Construction

A: SPECIFICATION

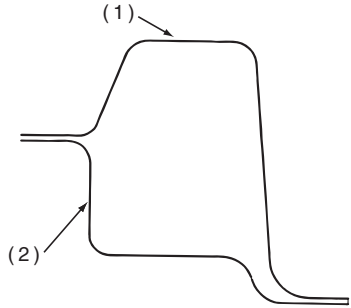
- Wagon/sedan common parts



BS-02906

Body Construction

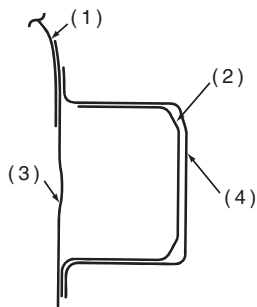
Cross section A — A



BS-02907

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

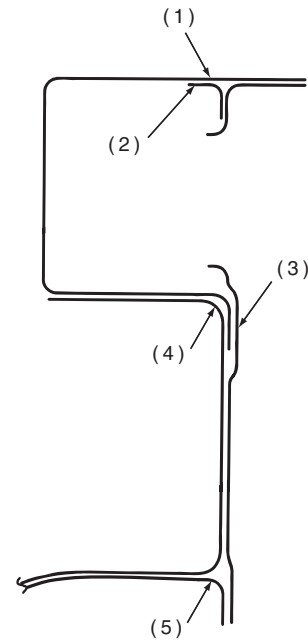
Cross section C — C



BS-02909

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

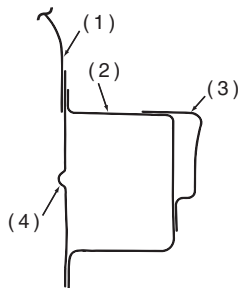
Cross section B — B



BS-02908

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

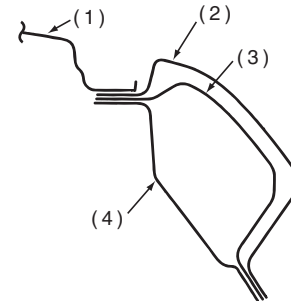
Cross section D — D



BS-02910

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

Cross section E — E

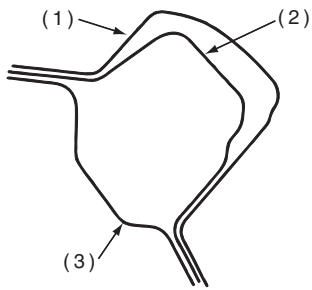


BS-02911

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

Body Construction

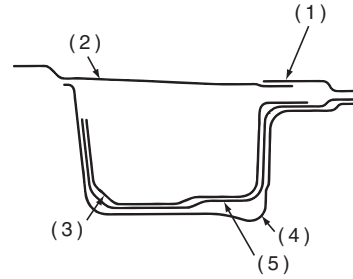
Cross section F — F



BS-02912

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

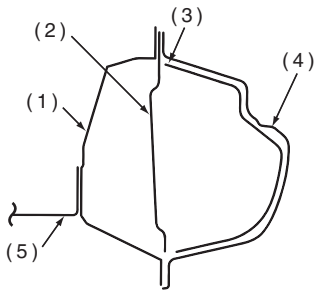
Cross section G — G



BS-02913

- (1) Steering support reinforcement
- (2) Front pillar inner lower
- (3) Front pillar center reinforcement
- (4) Side panel outer
- (5) Front pillar lower reinforcement

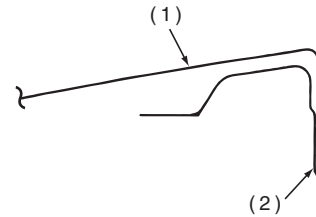
Cross section H — H



BS-02914

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

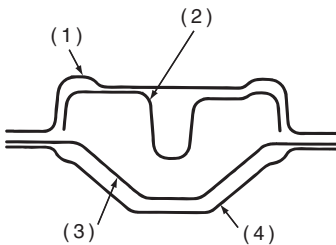
Cross section I — I



BS-02915

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

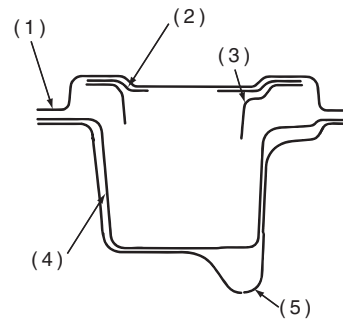
Cross section J — J



BS-02916

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

Cross section K — K

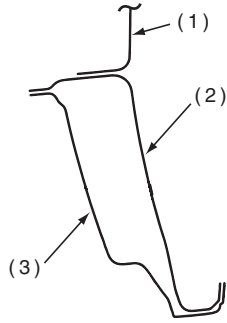


BS-02917

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

Body Construction

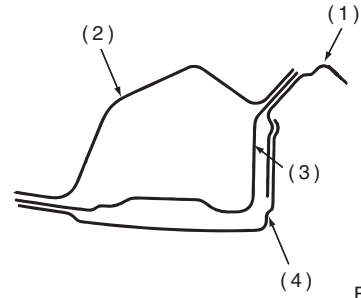
Cross section L — L



BS-02918

- (1) Rear wheel apron
- (2) Rear arch inner
- (3) Side panel outer

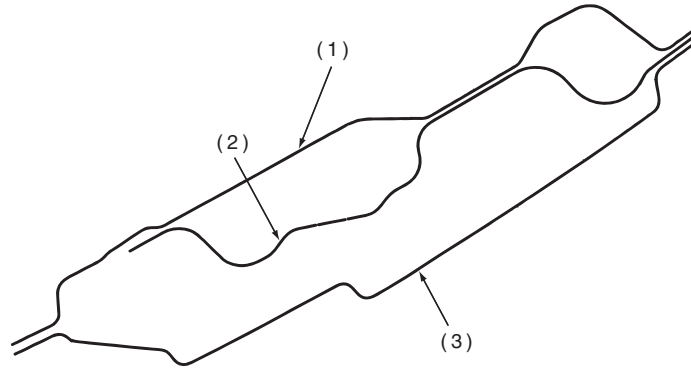
Cross section N — N



BS-02920

- (1) D-pillar extension
- (2) D-pillar inner upper
- (3) D-pillar reinforcement
- (4) Side panel outer

Cross section M — M

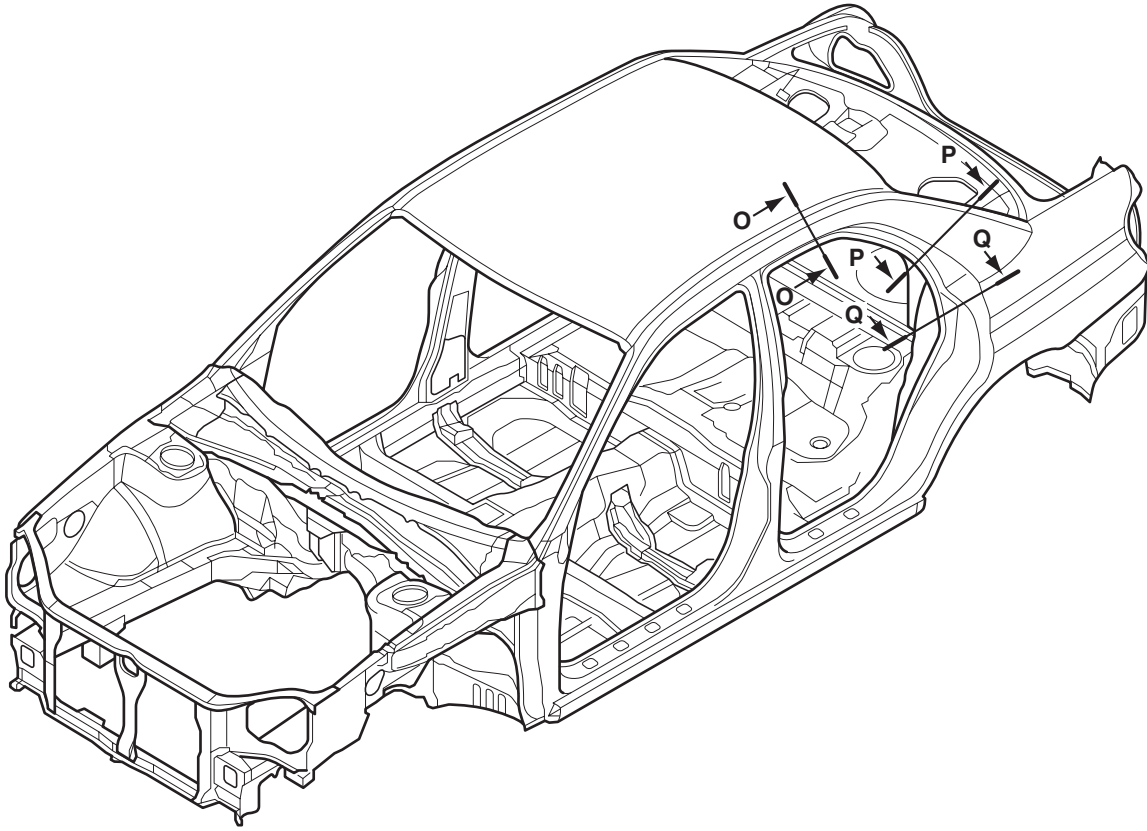


BS-02919

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

Body Construction

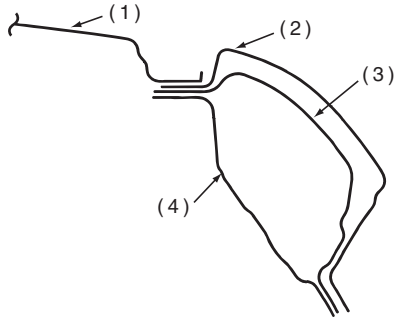
- Sedan only parts



BS-02921

Body Construction

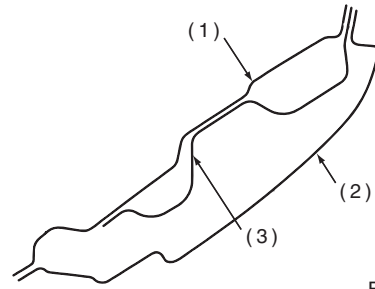
Cross section O — O



BS-02922

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

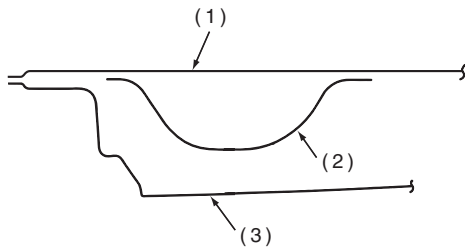
Cross section P — P



BS-02923

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

Cross section Q — Q



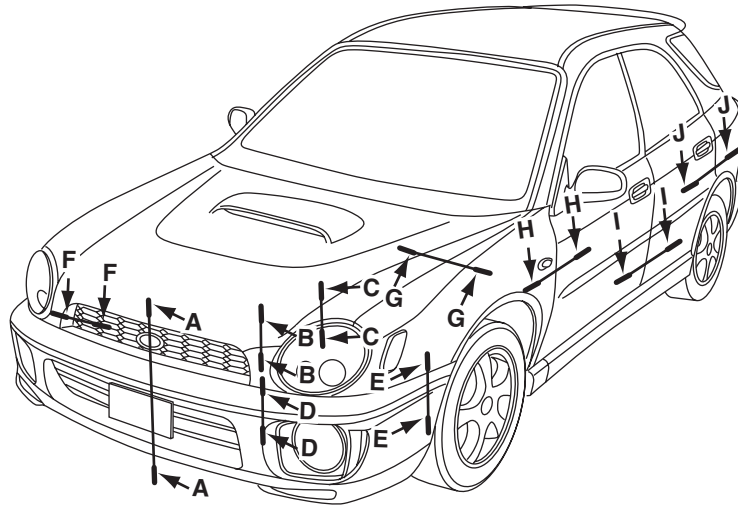
BS-02924

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

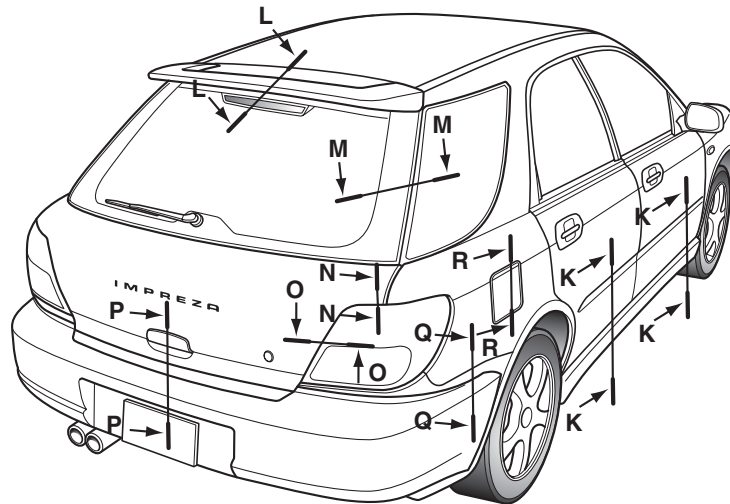
SUBARU.

4. Gauge Values for Fitting

A: DIMENSIONS

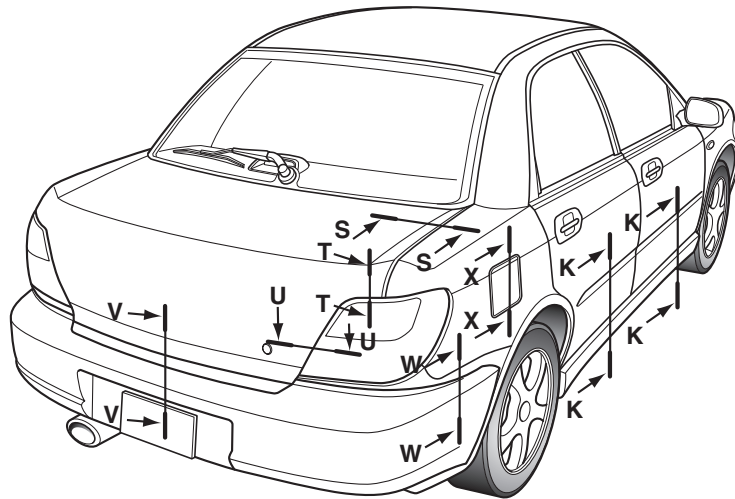


BS-03105



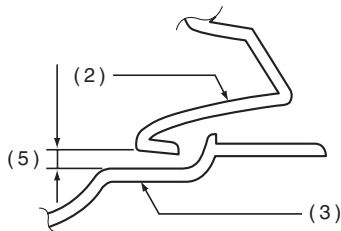
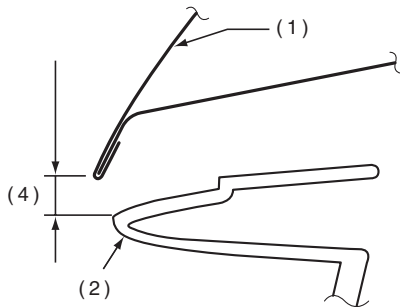
BS-02926

Gauge Values for Fitting



BS-02927

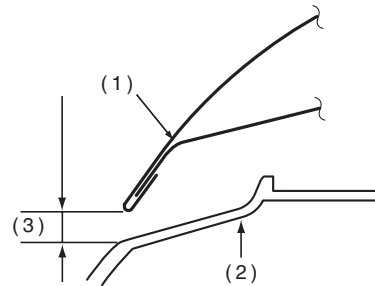
Cross section A — A



BS-02928

- (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)

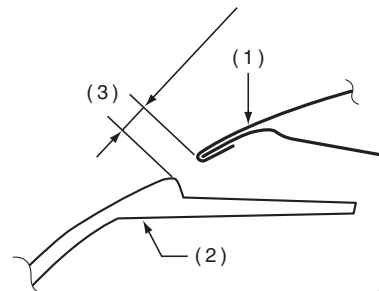
Cross section B — B



BS-02929

- (1) Front hood
- (2) Grille side
- (3) 7.0 ± 1.0 mm (0.28 ± 0.04 in)

Cross section C — C

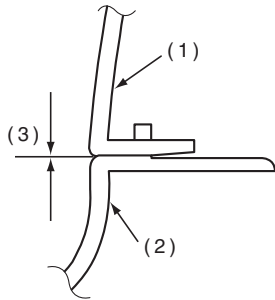


BS-02930

- (1) Front hood
- (2) Headlight
- (3) 5.0 ± 1.0 mm (0.20 ± 0.04 in)

Gauge Values for Fitting

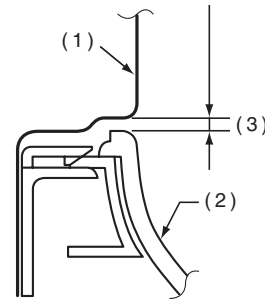
Cross section D — D



BS-02931

- (1) Grille side
- (2) Front bumper
- (3) 0 mm (0 in)

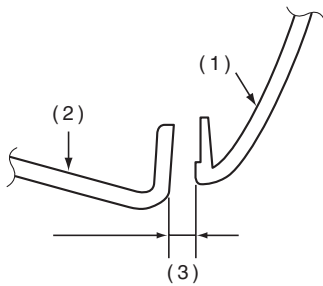
Cross section E — E



BS-02932

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

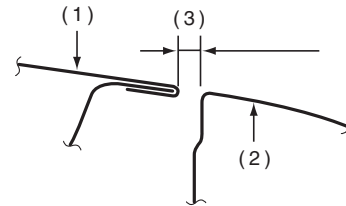
Cross section F — F



BS-02933

- (1) Front grille
- (2) Grille side
- (3) 4.5 ± 1.0 mm (0.18 ± 0.04 in)

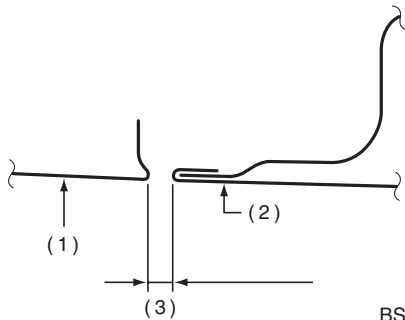
Cross section G — G



BS-02934

- (1) Front hood
- (2) Fender
- (3) 3.7 ± 1.0 mm (0.15 ± 0.04 in)

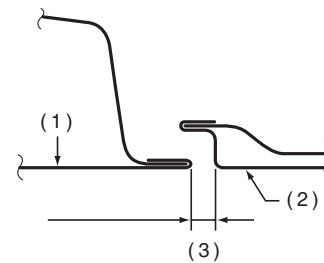
Cross section H — H



BS-02935

- (1) Fender
- (2) Front door
- (3) 4.6 ± 1.0 mm (0.18 ± 0.04 in)

Cross section I — I

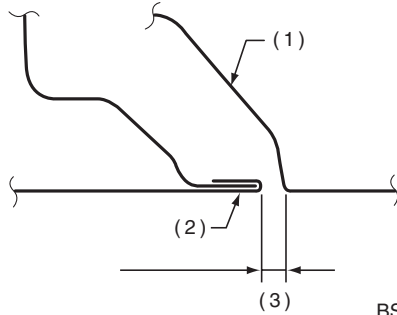


BS-02936

- (1) Front door
- (2) Rear door
- (3) 5.0 ± 1.0 mm (0.2 ± 0.04 in)

Gauge Values for Fitting

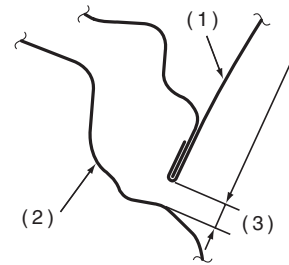
Cross section J — J



BS-02937

- (1) Rear quarter end
- (2) Rear door
- (3) 4.6 ± 1.0 mm (0.18 ± 0.04 in)

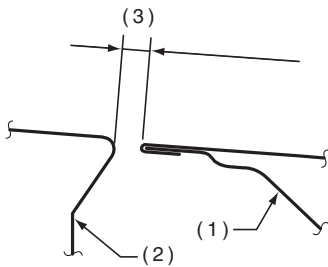
Cross section K — K



BS-02938

- (1) Door panel
- (2) Side panel outer
- (3) 5.8 ± 1.0 mm (0.23 ± 0.04 in) (F door)
 5.9 ± 1.0 mm (0.23 ± 0.04 in) (R door)

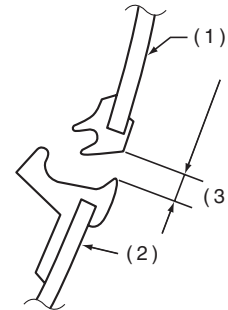
Cross section L — L



BS-02939

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

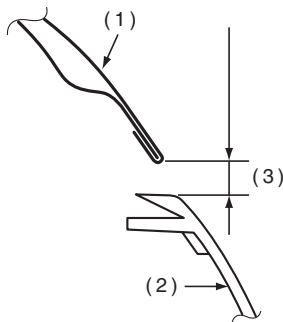
Cross section M — M



BS-02940

- (1) Rear gate glass
- (2) Rear quarter glass
- (3) 6.0 ± 1.5 mm (0.24 ± 0.06 in)

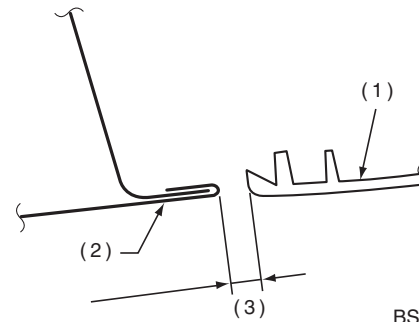
Cross section N — N



BS-02941

- (1) Rear gate
- (2) Rear combination light
- (3) 6.0 ± 1.5 mm (0.24 ± 0.06 in)

Cross section O — O

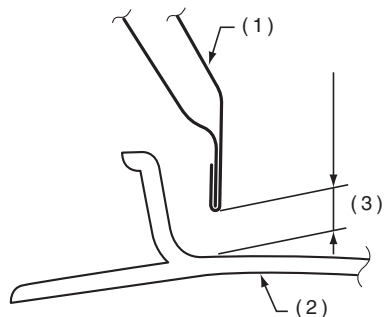


BS-02942

- (1) Rear combination light
- (2) Rear gate
- (3) 5.0 ± 1.5 mm (0.2 ± 0.06 in)

Gauge Values for Fitting

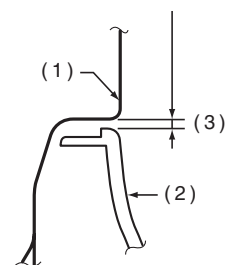
Cross section P — P



BS-02943

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

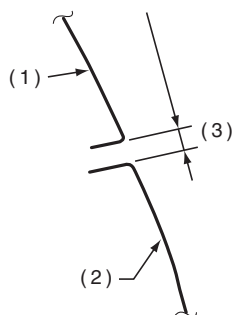
Cross section Q — Q



BS-02944

- (1) Rear quarter end
- (2) Rear bumper
- (3) $1.0 - 2.0 \pm 0.7$ mm ($0.04 - 0.08 \pm 0.03$ in)

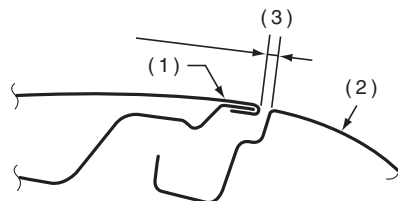
Cross section R — R



BS-02945

- (1) Rear quarter end
- (2) Fuel flap
- (3) 3.5 ± 0.5 mm (0.14 ± 0.02 in)

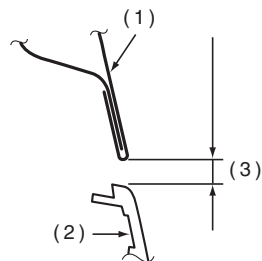
Cross section S — S



BS-02951

- (1) Trunk
- (2) Rear quarter
- (3) 4.0 ± 1.0 mm (0.16 ± 0.04 in)

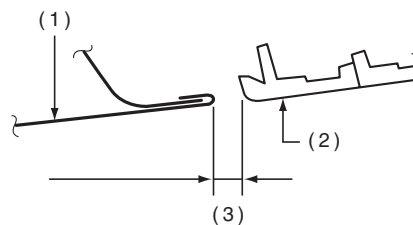
Cross section T — T



BS-02946

- (1) Trunk
- (2) Rear combination light
- (3) 7.0 ± 1.5 mm (0.28 ± 0.06 in)

Cross section U — U

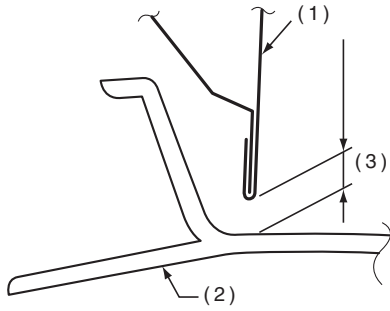


BS-02947

- (1) Trunk
- (2) Rear combination light
- (3) 5.0 ± 1.5 mm (0.2 ± 0.06 in)

Gauge Values for Fitting

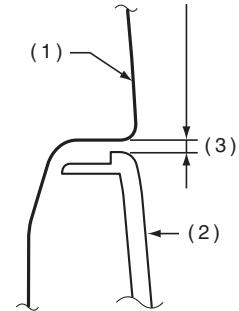
Cross section V — V



BS-02948

- (1) Trunk
- (2) Rear bumper
- (3) 7.0 ± 1.5 mm (0.28 ± 0.06 in)

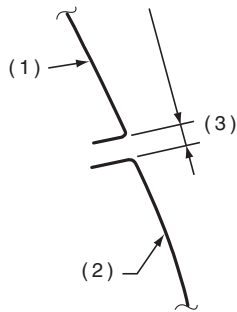
Cross section W — W



BS-02949

- (1) Rear quarter end
- (2) Rear bumper
- (3) $1.0 - 2.0 \pm 1.0$ mm ($0.04 - 0.08 \pm 0.04$ in)

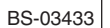
Cross section X — X



BS-02950

- (1) Rear quarter end
- (2) Fuel flap
- (3) 3.5 ± 0.5 mm (0.14 ± 0.02 in)

SUBARU.



Plastic Parts and Materials

- | | | |
|---------------------------|-------------------------------|-------------------------------|
| (1) Hood grille | (9) Side turn light | (17) Rear combination light |
| (2) Front window moulding | (10) Front fog light | (wagon) |
| (3) Side marker | (11) Front bumper | (18) Rear gate handle (wagon) |
| (4) Cover B-pillar | (12) Grille side front bumper | (19) Rear bumper |
| (5) Door mirror | (13) Front grille | (20) Rear combination light |
| (6) Door handle | (14) Headlight | (sedan) |
| (7) Side protector | (15) Roof spoiler (wagon) | (21) Cowl panel |
| (8) Side spoiler | (16) Lip spoiler (wagon) | (22) Cowl panel side |

Plastic Parts and Materials

No.	Part name		Material
(1)	Hood grille		PPO + PA
(2)	Front window moulding		Stainless steel + PVC
(3)	Side marker	Lens	PMMA
		Housing	ABS
(4)	Cover B-pillar		PC/SAS
(5)	Door mirror	Stay	PA - GF60
		Body (not painted)	AES
		Body (painted)	ABS
		Mirror holder	PP
(6)	Door handle	Body	PPE/PA
		End cover	PP
(7)	Side protector		PP
(8)	Side spoiler		PP
(9)	Side turn light	Lens	PMMA
		Housing	PC
(10)	Front fog light	Lens	Glass
		Housing	PP
		Cover	PP
(11)	Front bumper	Face	PP
		EAform	PP
(12)	Grille side front bumper		PP
(13)	Front grille		ABS
(14)	Headlight	Lens	PC
		Housing	PP
(15)	Roof spoiler (wagon)		ABS
(16)	Lip spoiler (wagon)		ABS
(17)	Rear combination light (wagon)	Lens	PMMA
		Housing	ASA + PC
(18)	Rear gate handle (wagon)		PBT/PC
(19)	Rear bumper	Face	PP
(20)	Rear combination light (sedan)	Lens	PMMA
		Housing	ASA
(21)	Cowl panel		PP
(22)	Cowl panel side		TPO
	Mudguard		PE
	Under cover		PP
	Splashboard		PP
	Cowl panel		PPE
	High mount stop light (indoor type)	Lens	PC
		Hood (wagon)	ABS
		Hood (sedan)	PP
		Cover	PP
		Housing	PP
	Rear spoiler (sedan)	Body	ABS
		High mount lens	PMMA
		High mount housing	ABS

List of Plastic Material Notations

6. List of Plastic Material Notations

A: SPECIFICATION

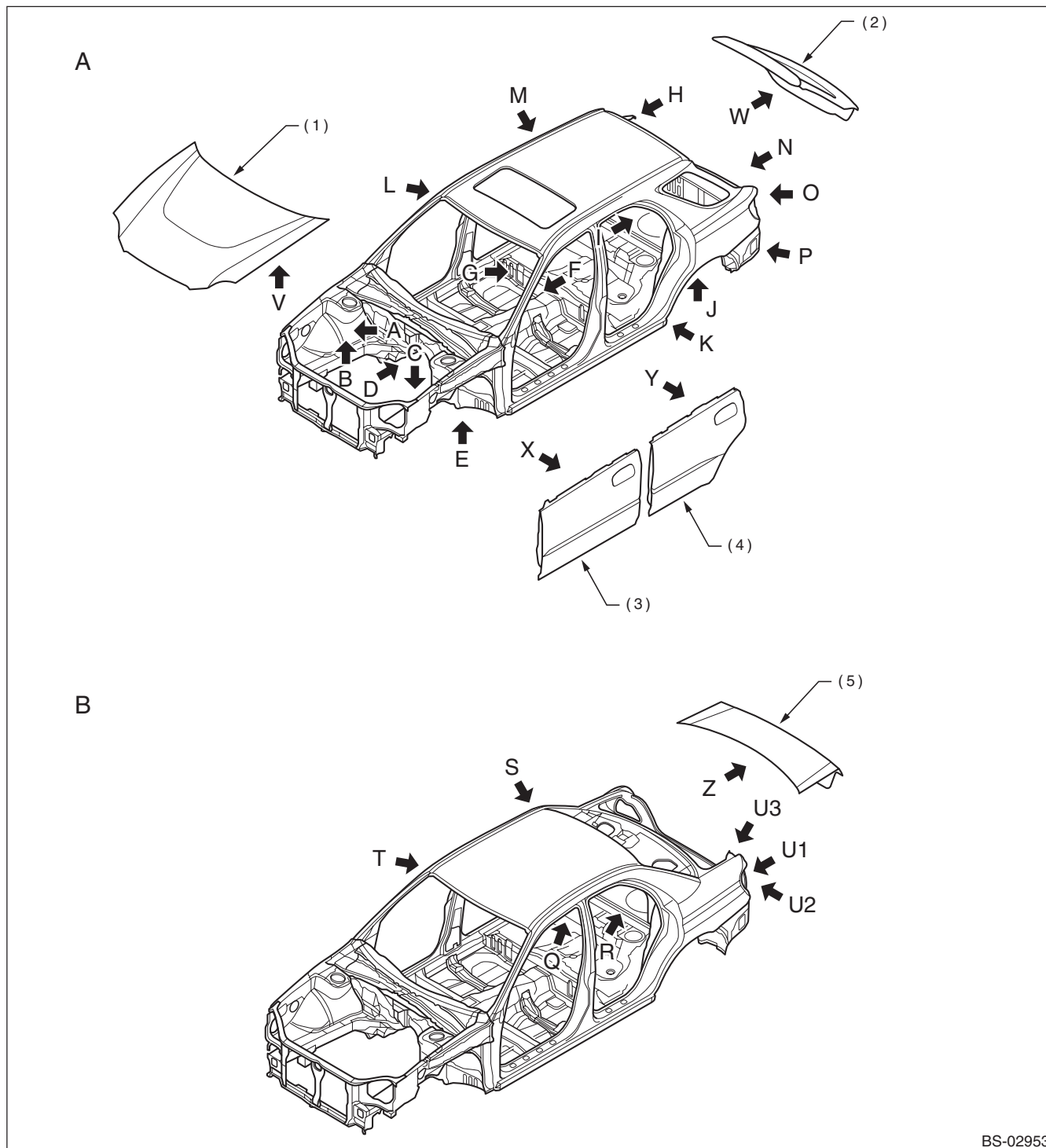
Notation symbol	Material name	Notation symbol	Material name
ABS	ABS resin (acrylonitrile/butadiene/styrene/resin)	PE	Polyethylene
AES	Acrylonitrile/ethylene/styrene	PET	Polyethylene terephthalate
ASA	Acrylonitrile/styrene/acrylate	PMMA	Polymethyl methacrylate
PA	Nylon (polyamide)	PP	Polypropylene
PA-GF60	Polyamide (60% glass fiber content)	PPE	Poly (phenylene ether)
PBT	Poly (butylene terephthalate)	PPO	Polyphenylene oxide
PC	Polycarbonate	PVC	Polyvinyl chloride
PCT	Polychlorotrifluoroethylene	SAS	Acrylonitrile/styrene/silicon
		TPO	Thermoplastic olefine

7. Body Sealing

A: SPECIFICATION

Used material: THREE BOND 4101 (004403063)

— : Sealer application location

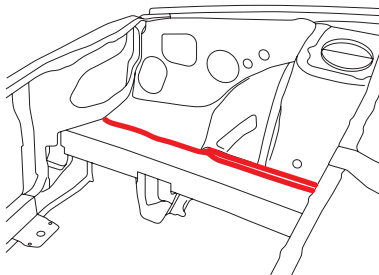


Body Sealing

- | | | |
|--------------------------------------|----------------|-----------|
| (A) Common parts for wagon and sedan | (B) Sedan only | |
| (1) Front hood | (3) Front door | (5) Trunk |
| (2) Rear gate | (4) Rear door | |

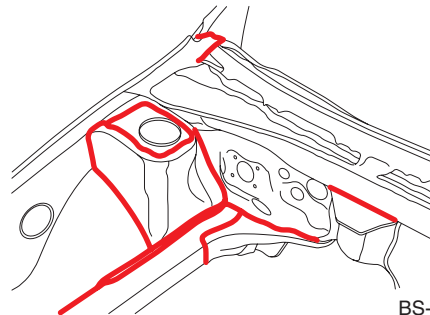
Body Sealing

View A



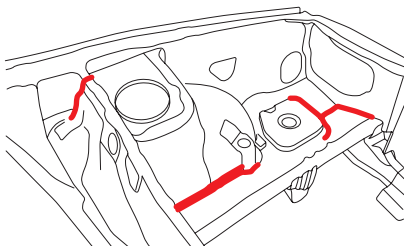
BS-02954

View B



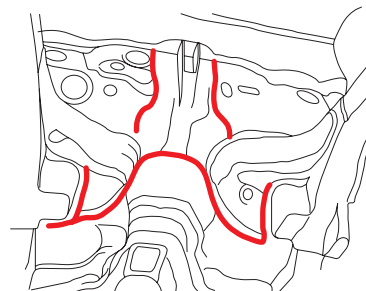
BS-02955

View C



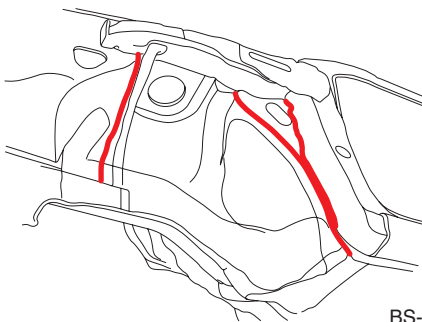
BS-02956

View D



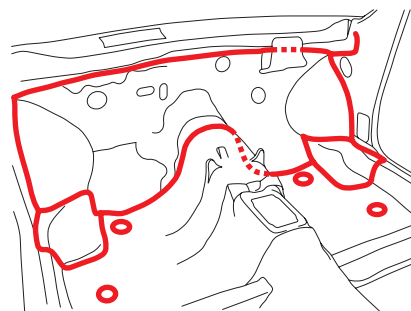
BS-02957

View E



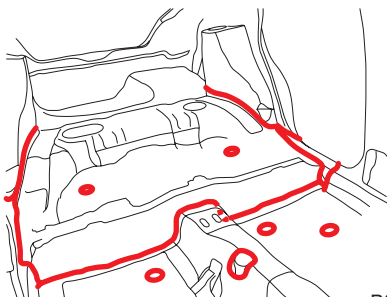
BS-02958

View F



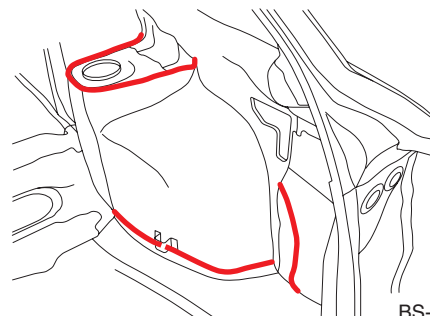
BS-02959

View G



BS-02960

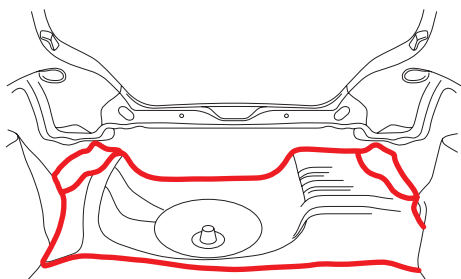
View H



BS-02961

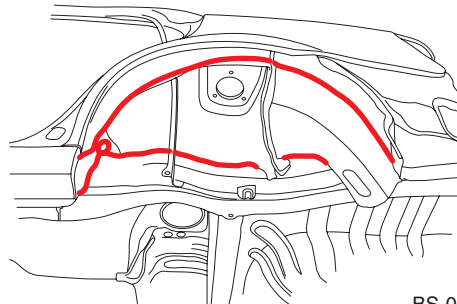
Body Sealing

View I



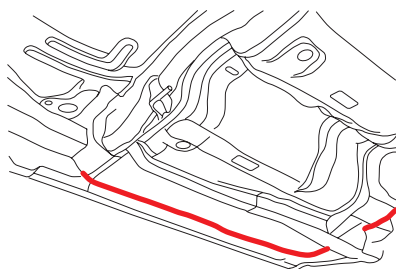
BS-02962

View J



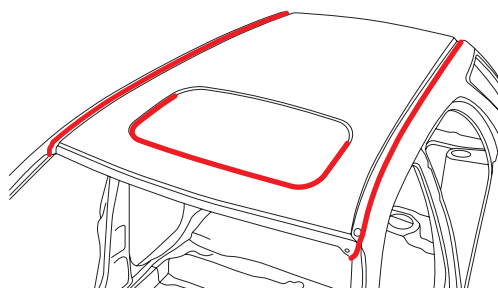
BS-02963

View K



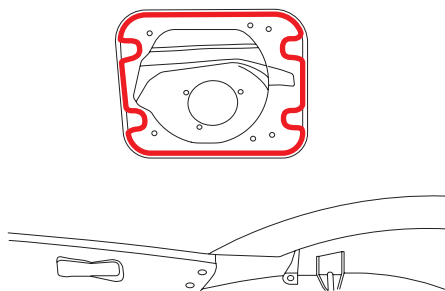
BS-02964

View L



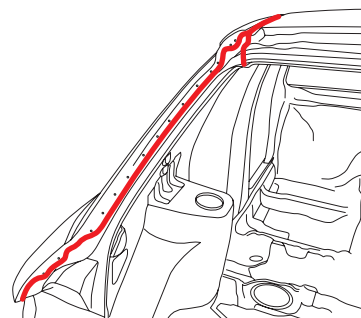
BS-02965

View M



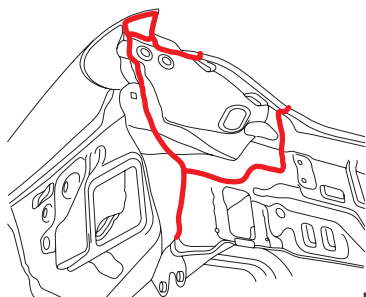
BS-02966

View N



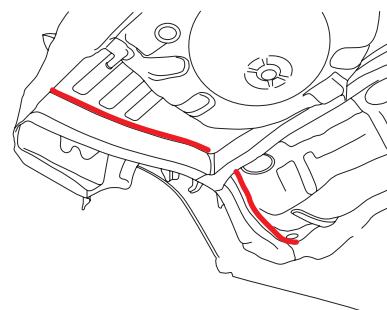
BS-02967

View O



BS-02968

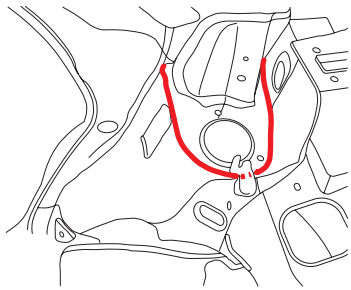
View P



BS-02969

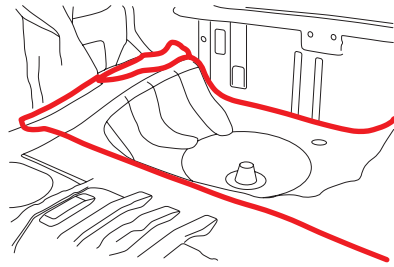
Body Sealing

View Q



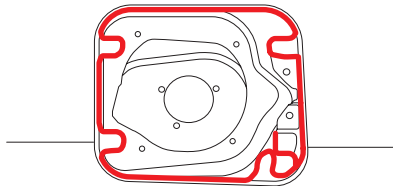
BS-02970

View R



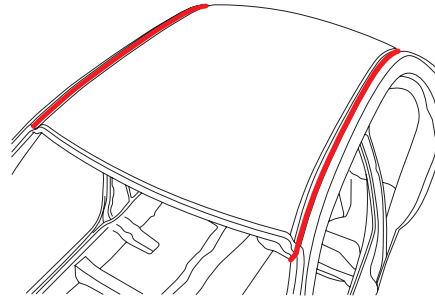
BS-02971

View S



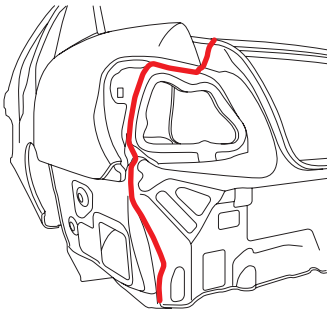
BS-03428

View T



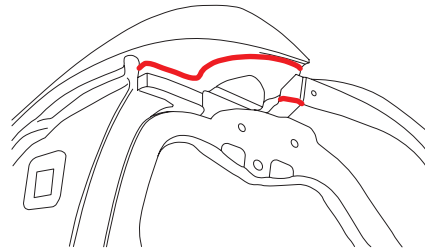
BS-02973

View U1



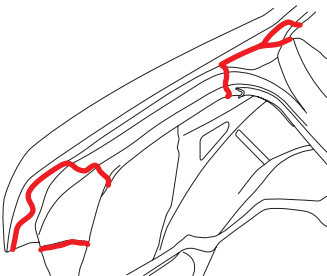
BS-02974

View U2



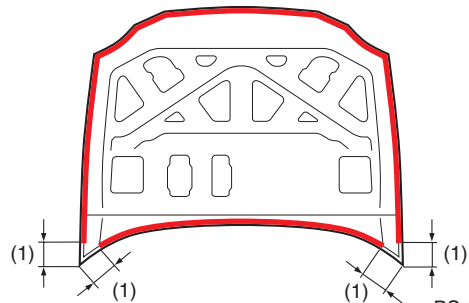
BS-02975

View U3



BS-02976

View V

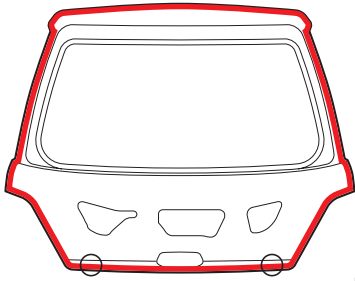


BS-03429

(1) 50 mm (1.97 in)

Body Sealing

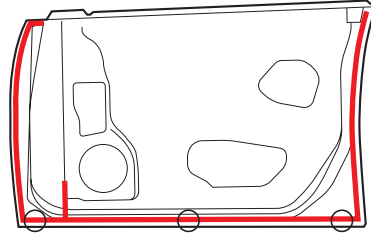
View W



BS-02978

CAUTION:
Do not block the water drain holes marked by ○.

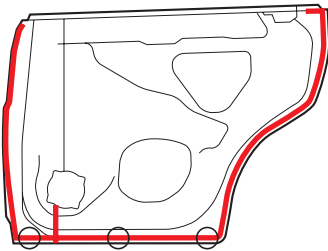
View X



BS-02979

CAUTION:
Do not block the water drain holes marked by ○.

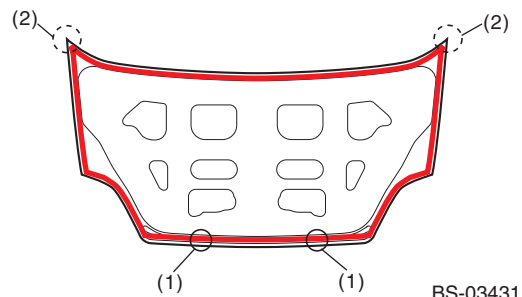
View Y



BS-02980

CAUTION:
Do not block the water drain holes marked by ○.

View Z



BS-03431

CAUTION:
• Do not block the water drain holes (1) .
• Block the hole (2) at the edge.

8. Anticorrosion Wax

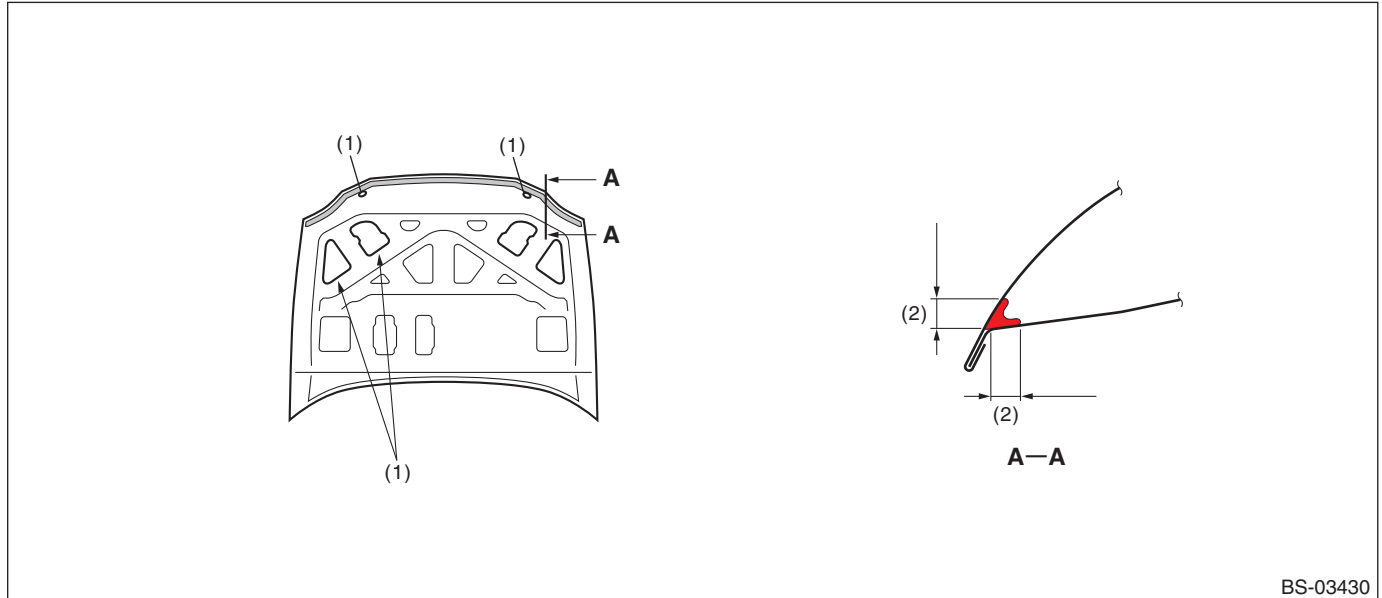
A: SPECIFICATION

Used material: Rust-stop aerosol (K0877YA015)

— and — : Application area

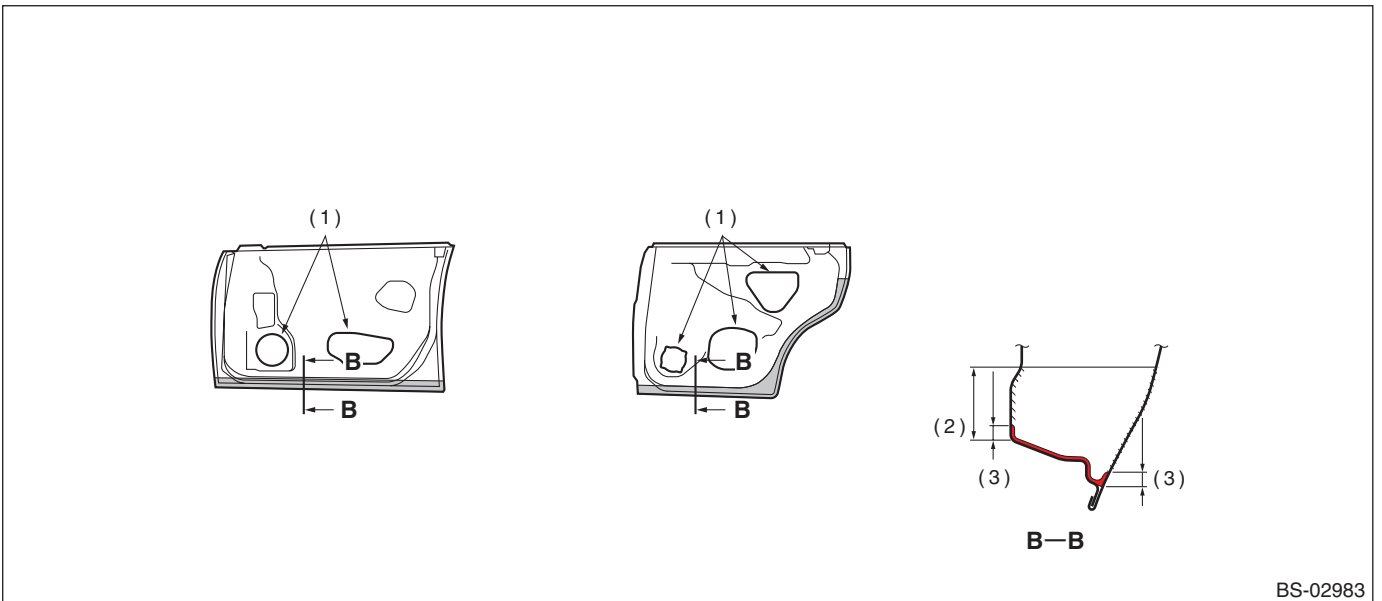
— : Application thickness 50 μm or more : Application thickness 20 μm or more

• Front hood



(1) Wax application work openings (2) 10 mm (0.39 in)

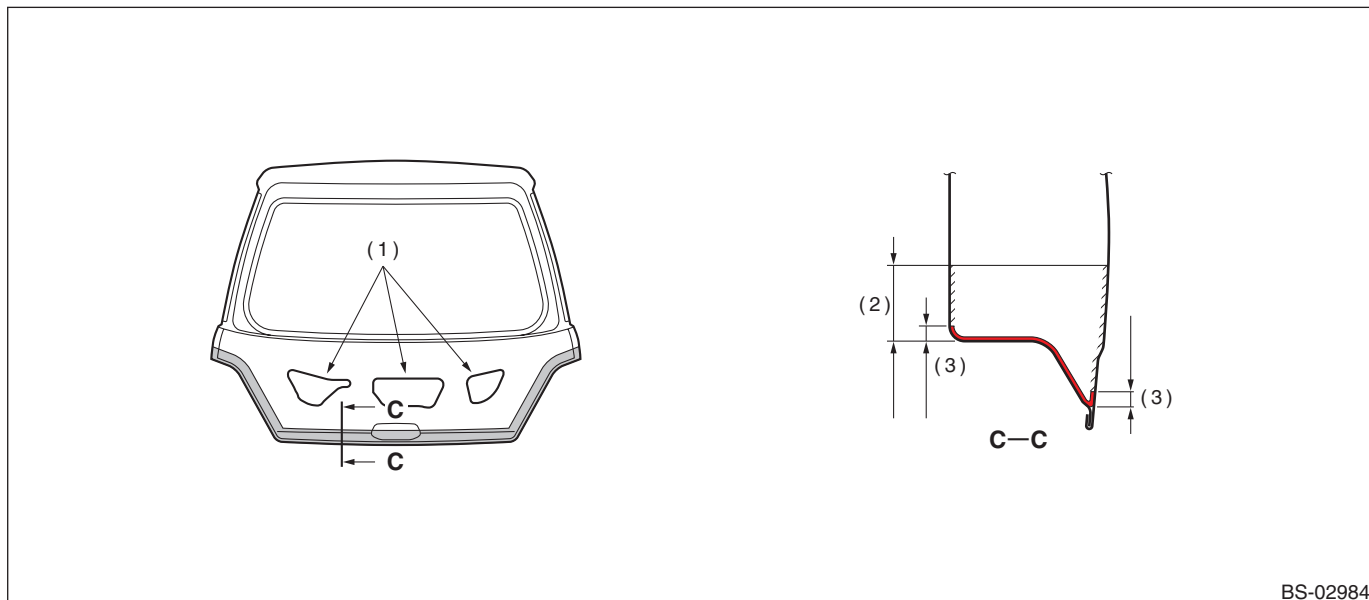
• Door (Front, rear)



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

Anticorrosion Wax

• Rear gate



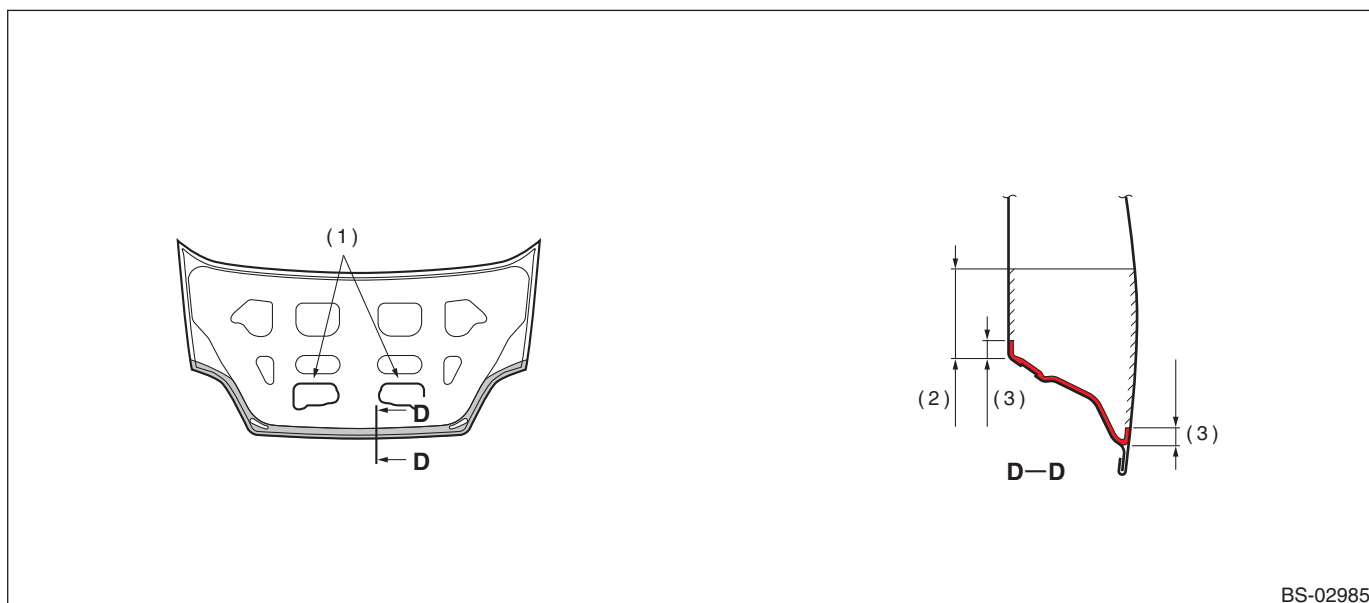
BS-02984

(1) Wax application work openings

(2) 50 mm (1.97 in)

(3) 10 mm (0.39 in)

• Trunklid



BS-02985

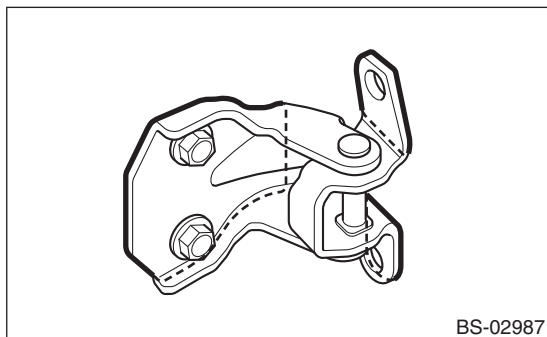
(1) Wax application work openings

(2) 50 mm (1.97 in)

(3) 10 mm (0.39 in)

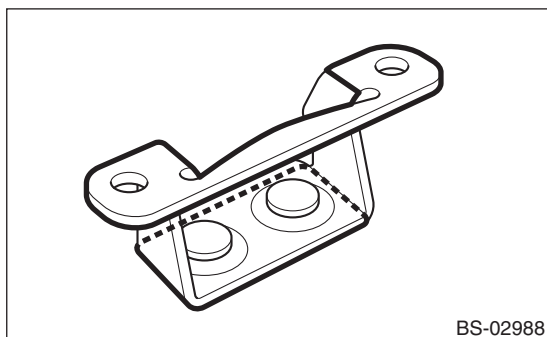
- **Door hinge**

Apply to the installation outer circumference (plate edges) at two locations at the top and bottom (eight locations in all).



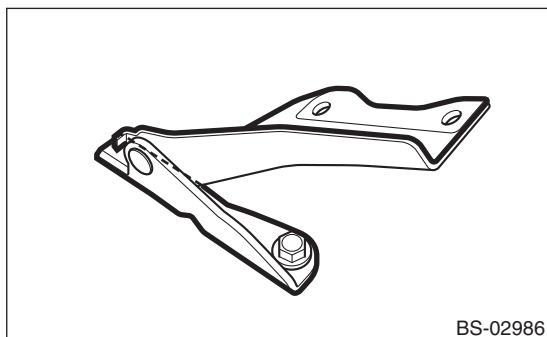
- **Rear gate hinge**

Apply around the installation outer circumference (plate edges) at two locations on the left and right.



- **Front hood hinge**

Apply around the installation outer circumference (plate edges) at two locations on the left and right.



9. Undercoat

A: SPECIFICATION

Repair material: **THREE BOND 6115**

1) Perform masking so that the undercoat will not become attached to locations other than shown and to the following locations.

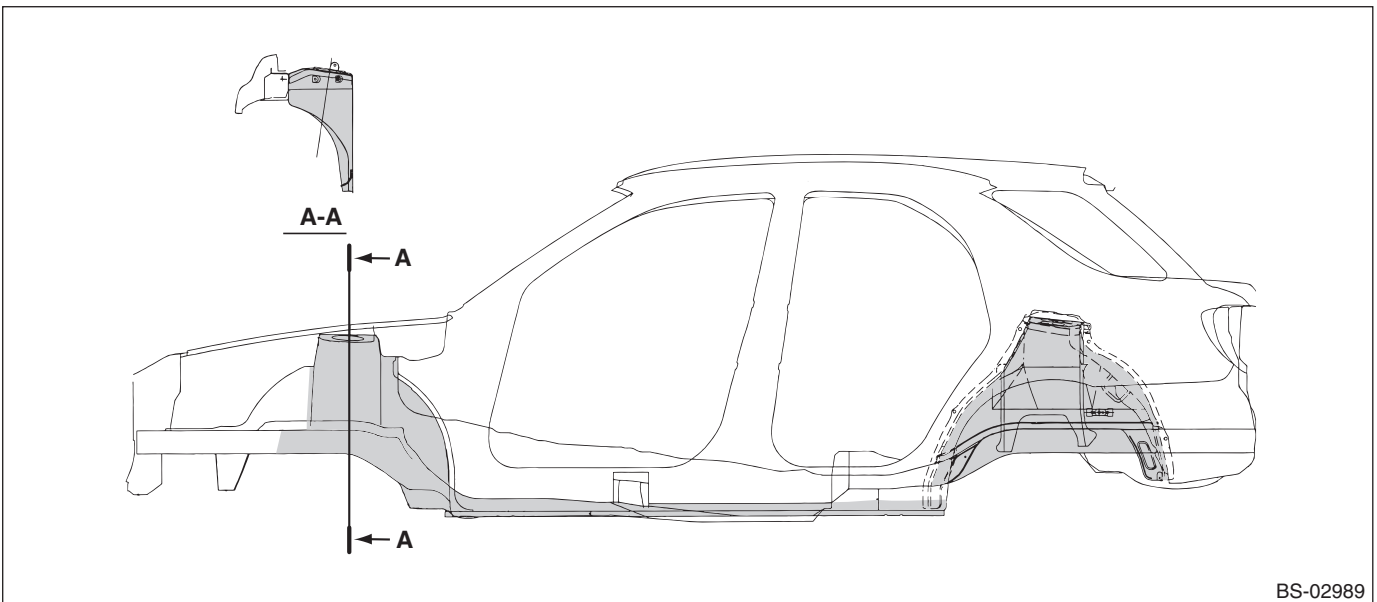
- High-temperature parts related to the exhaust pipe
- Hoses, tubes, and harness parts
- Installation surfaces of rear suspension, transmission, sub frame, mud guard etc.

2) Application area and application thickness

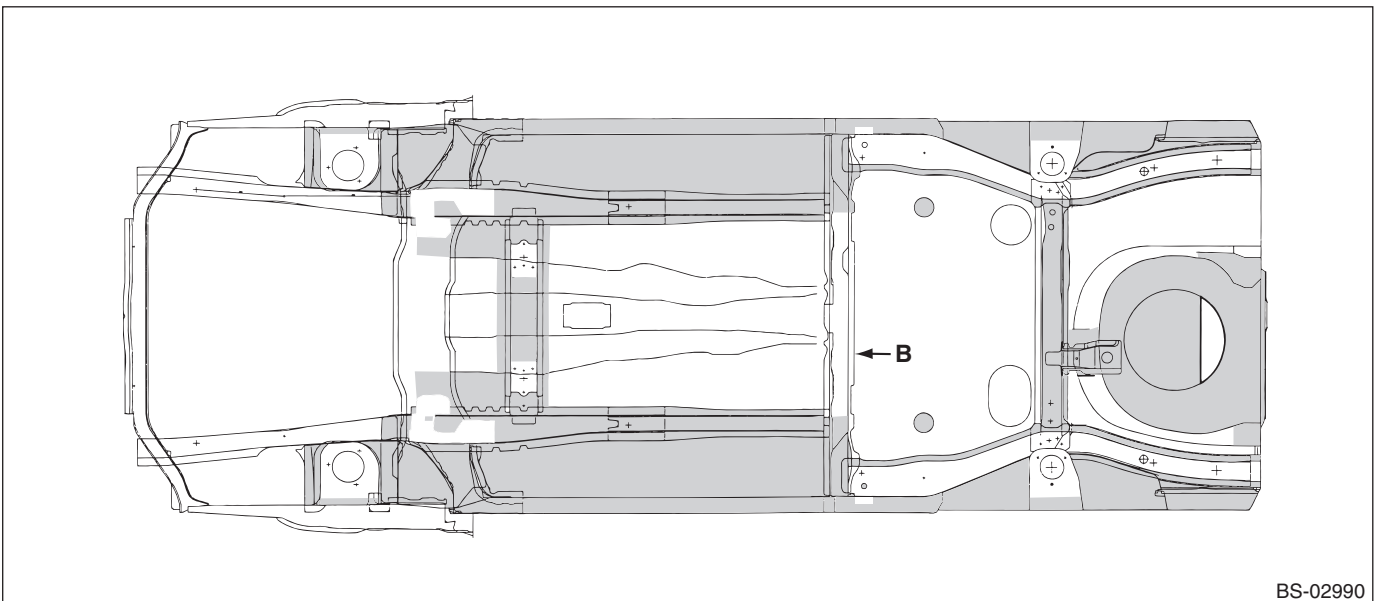
Application thickness should be **0.4 mm (0.02 in)** or less.

■ indicates the undercoat application area.

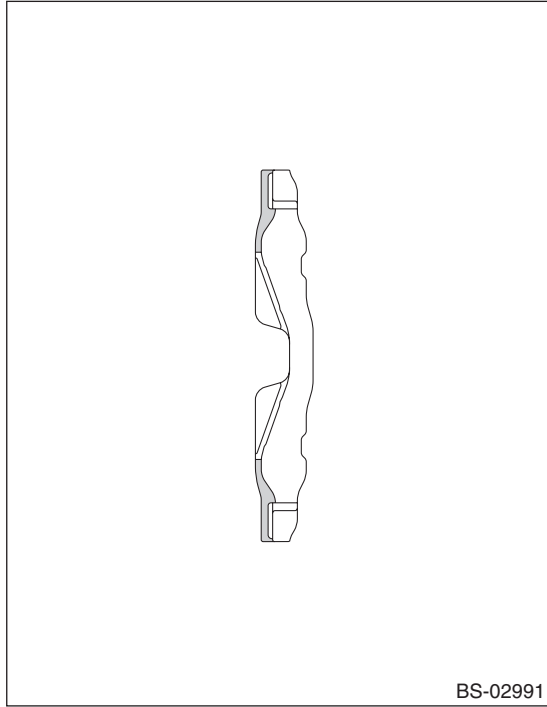
• Side view



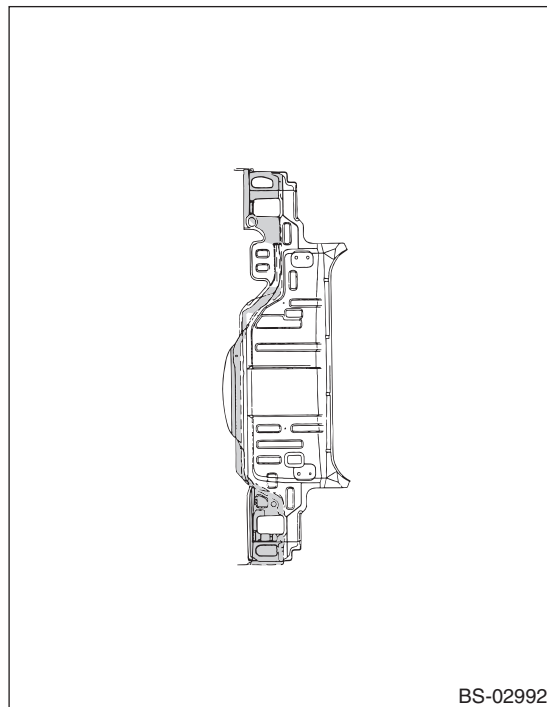
• Bottom view



- View B

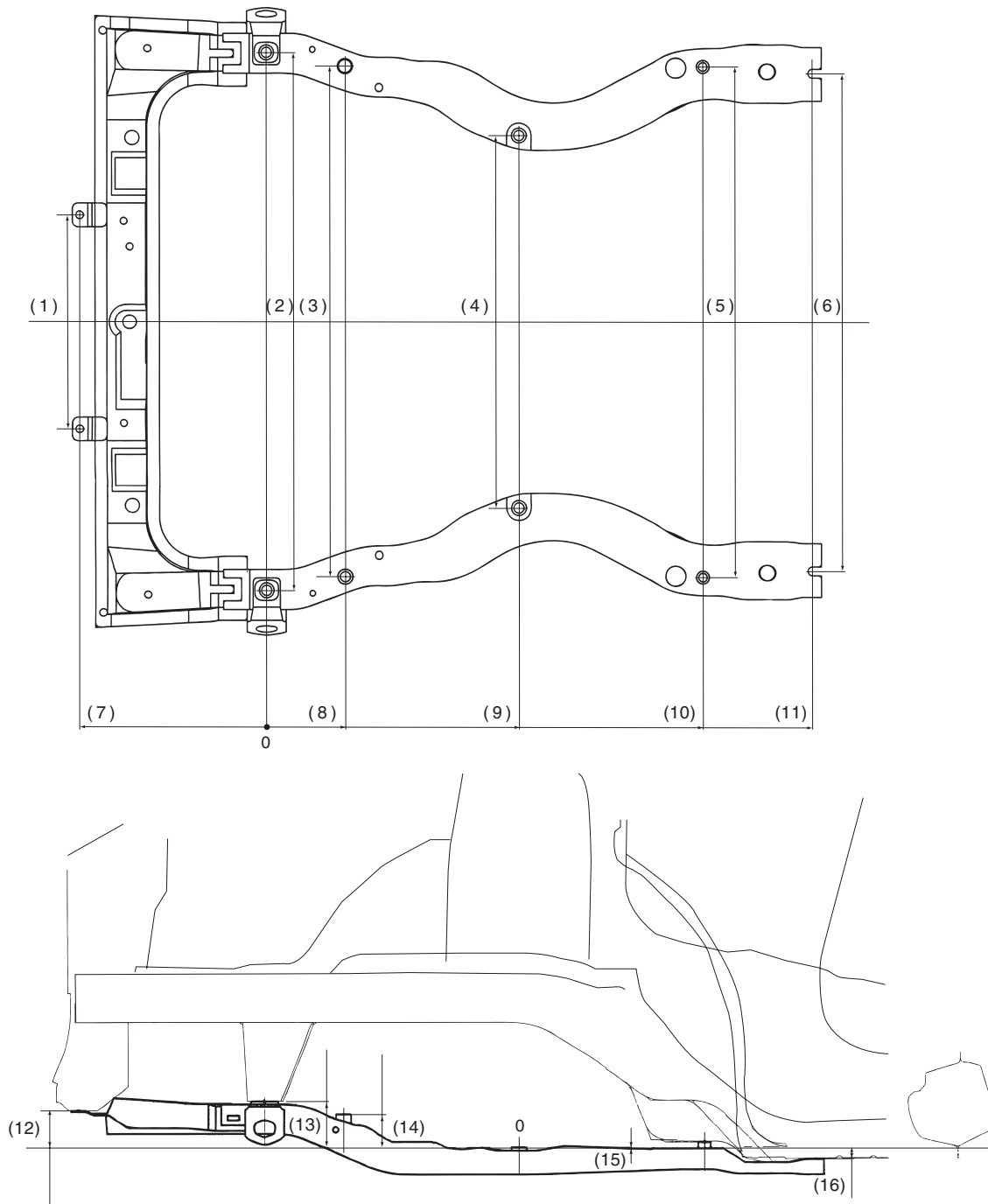


- Rear view



Sub Frame

10.Sub Frame



BS-02993

(1) 360 mm (14.17 in)	(7) 314 mm (12.36 in)	(13) 76.5 mm (3.01 in)
(2) 906 mm (35.51 in)	(8) 133.3 mm (5.25 in)	(14) 54.5 mm (2.15 in)
(3) 860 mm (33.86 in)	(9) 429 mm (16.89 in)	(15) 8 mm (0.31 in)
(4) 628 mm (24.72 in)	(10) 740 mm (29.13 in)	(16) 20.3 mm (0.80 in)
(5) 860 mm (33.86 in)	(11) 924 mm (36.38 in)	
(6) 838 mm (32.99 in)	(12) 61.3 mm (2.41 in)	

Sub Frame

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 which cross section shape of the pipe is deformed.**

NOTE:

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

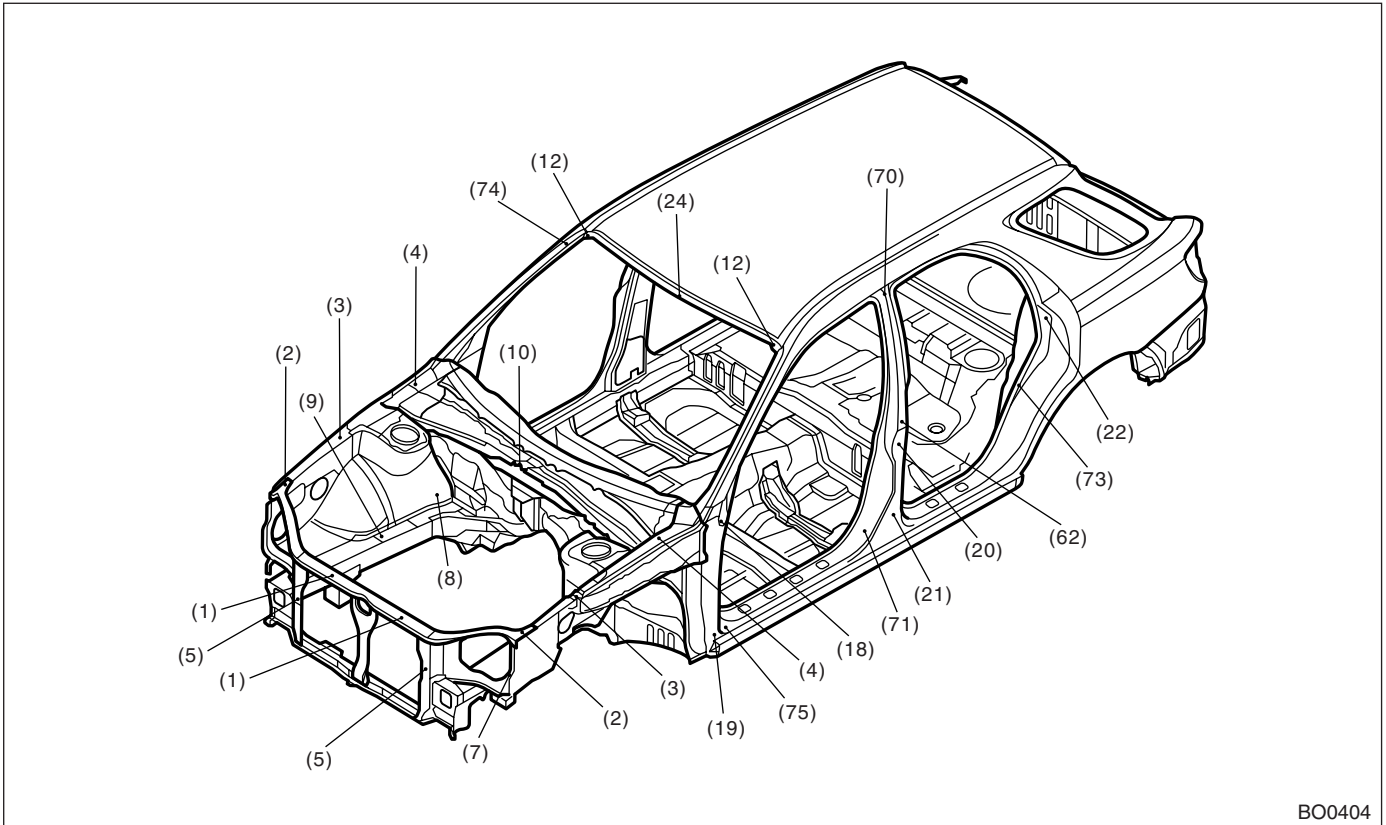
11.Body Reference Points

A: REFERENCE POINT

1. WAGON/SEDAN

NOTE:

- To make the panel replacement easy and to improve the location adjustment accuracy, the guide holes, locators and notches are provided.
- Reference point is left-right symmetrical.

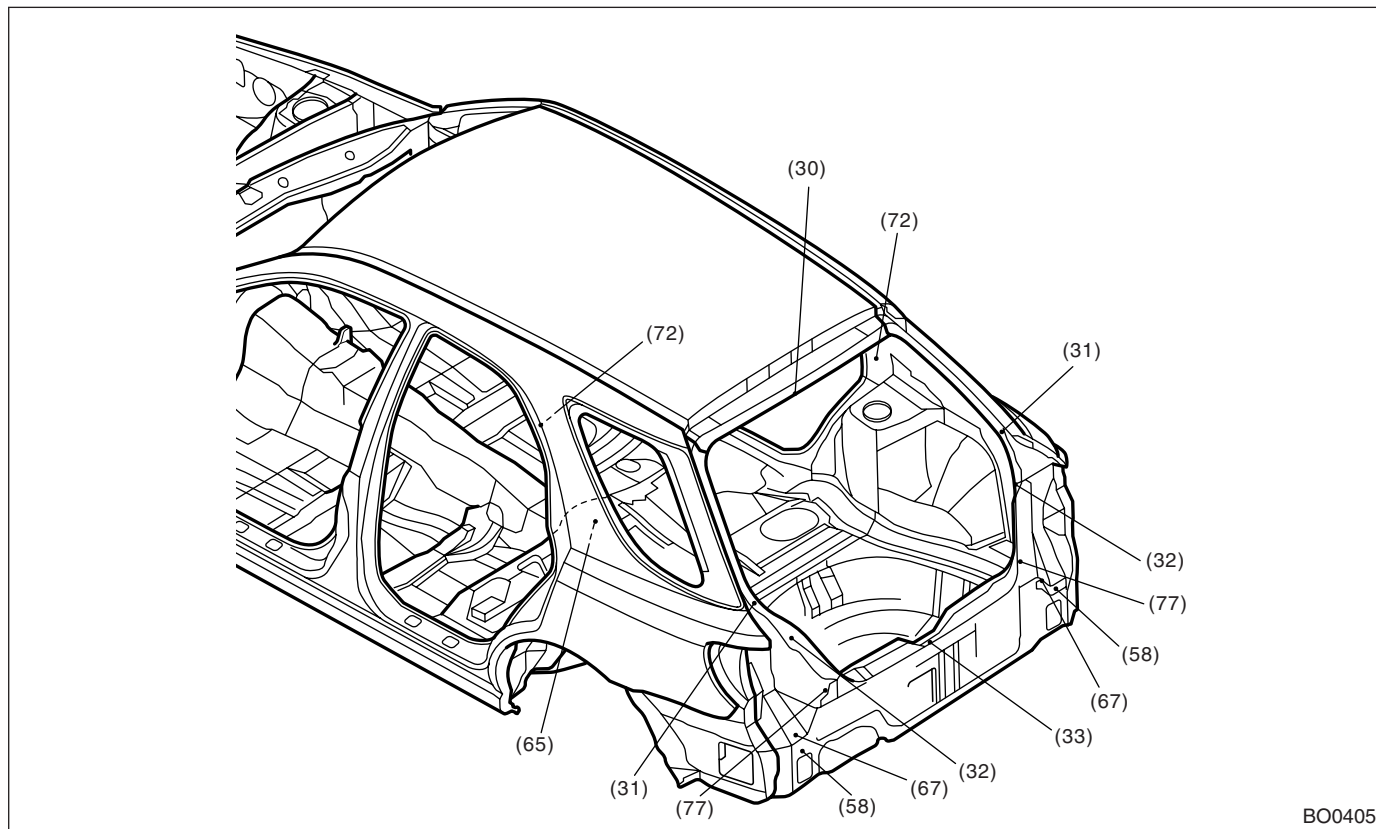


BO0404

- | | | |
|--|--|---|
| (1) Radiator mounting hole dia. 12 mm (0.47 in) (symmetrical) | (10) Cowl panel mounting hole dia. 6 mm (0.24 in) (center of vehicle) | (62) Belt anchor mounting hole dia. 11 mm (0.43 in) (symmetrical) |
| (2) Fender mounting hole dia. 7 mm (0.28 in) (symmetrical) | (12) Front glass mounting hole RH dia. 6.5 mm (0.256 in) LH dia. 6.5 × 10 mm (0.256 × 0.39 in) | (70) Trim clip mounting hole dia. 8.5 mm (0.335 in) (symmetrical) |
| (3) Fender mounting hole dia. 10 mm (0.39 in) (symmetrical) | (18) Fender mounting hole dia. 12mm (0.47 in) (symmetrical) | (71) Harness clip mounting hole dia. 7 mm (0.28 in) (symmetrical) |
| (4) Hood hinge mounting hole dia. 12 mm (0.47 in) (symmetrical) | (19) Fender mounting hole dia. 12mm (0.47 in) (symmetrical) | (73) Harness clip mounting hole dia. 7 mm (0.28 in) (symmetrical) |
| (5) Radiator panel side gauge hole dia. 20 mm (0.79 in) (symmetrical) | (20) Outer panel B-pillar gauge hole dia. 12 mm (0.47 in) (symmetrical) | (74) Trim clip mounting hole dia. 10 mm (0.39 in) (symmetrical) |
| (7) Fender mounting hole dia. 9 mm (0.35 in) (symmetrical) | (21) Outer panel B-pillar gauge hole dia. 12 mm (0.47 in) (symmetrical) | (75) Insulator mounting hole dia. 8 mm (0.31 in) (symmetrical) |
| (8) Gauge hole dia. 12 mm (0.47 in) (symmetrical) | (22) Weather strip patch mounting hole dia. 5.2 mm (0.205 in) (symmetrical) | |
| (9) Front suspension crossmember mounting hole dia. 12.4 mm (0.488 in) (symmetrical) | (24) Locator hole for roof panel repair | |

Body Reference Points

2. WAGON (REAR SECTION)

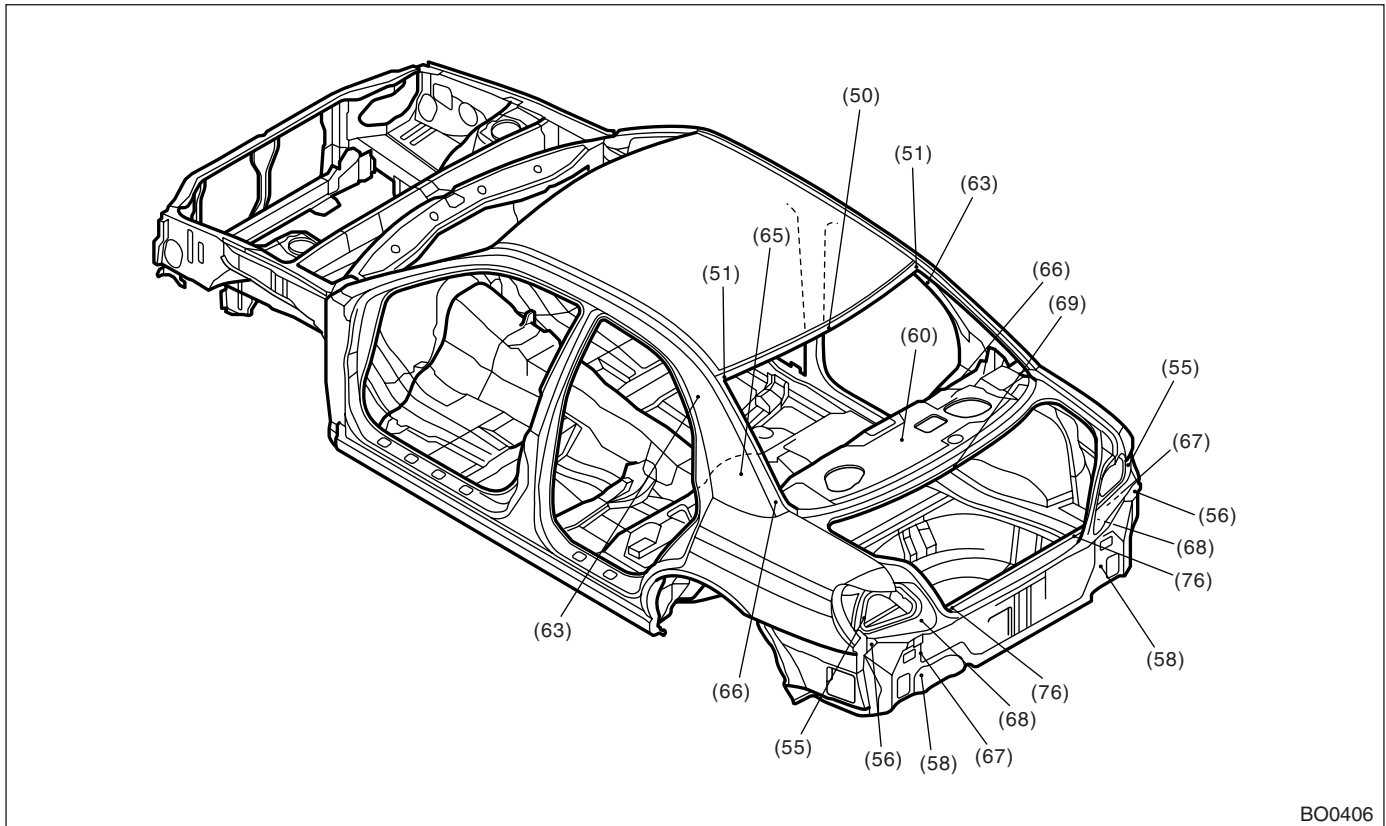


BO0405

- | | | |
|---|--|---|
| (30) Child anchor mounting hole dia. 11 mm (0.43 in) | (58) Rear bumper plate nut mounting hole dia. 11 mm (0.43 in) (symmetrical) | (72) Trim upper clip attachment hole dia. 8.5 mm (0.335 in) (symmetrical) |
| (31) Washer hose mounting hole LH dia. 7 mm (0.28 in) | (65) Floor mat clip attachment hole dia. 8 mm (0.31 in) | (77) Harness clip attachment hole dia. 7 mm (0.28 in) (symmetrical) |
| (32) Rear combination light mounting hole dia. 7 mm (0.28 in) (symmetrical) | (67) Rear side gusset floor gauge hole dia. 11.5 mm (0.453 in) (symmetrical) | |
| (33) Two striker mounting hole dia. 15 mm (0.59 in) | | |

Body Reference Points

3. SEDAN (REAR SECTION)

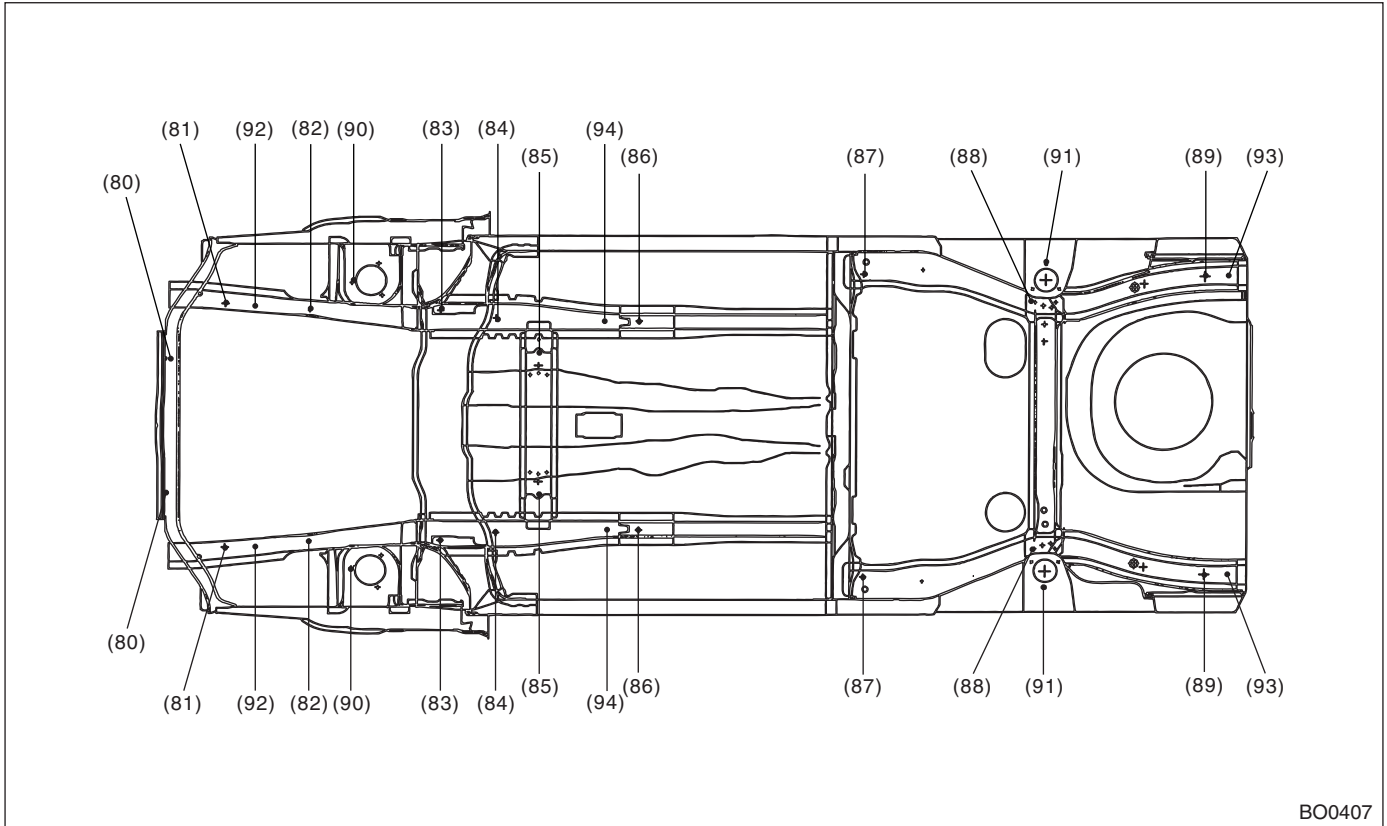


BO0406

- | | | |
|--|--|---|
| (50) Locator hole for repair (center of vehicle) | (60) Chalk coil harness mounting hole dia. 5.4 mm (0.213 in) | (68) Rear skirt inner side gauge hole dia. 10 mm (0.39 in) (symmetrical) |
| (51) Glass mounting hole RH dia. 6.5 mm (0.256 in) LH dia. 6.5 x 10 mm (0.256 x 0.39 in) | (63) Feeder line fixed hole 7 mm (0.28 in) (symmetrical) | (69) Locator hole for rear panel (reinforcement) repair (center of vehicle) |
| (55) Rear combination light mounting hole dia. 8 mm (0.31 in) (symmetrical) | (65) Floor mat clip attachment hole dia. 8 mm (0.31 in) | (76) Press position hole dia. 15 mm (0.59 in) (symmetrical) |
| (56) Bumper mounting hole dia. 7 mm (0.28 in) (symmetrical) | (66) Bulkhead rear gauge hole dia. 10 mm (0.39 in) (symmetrical) | |
| (58) Rear bumper mounting hole dia. 11 mm (0.43 in) (symmetrical) | (67) Rear side gusset floor gauge hole dia. 11.5 mm (0.453 in) (symmetrical) | |

Body Reference Points

4. UNDER BODY SECTION

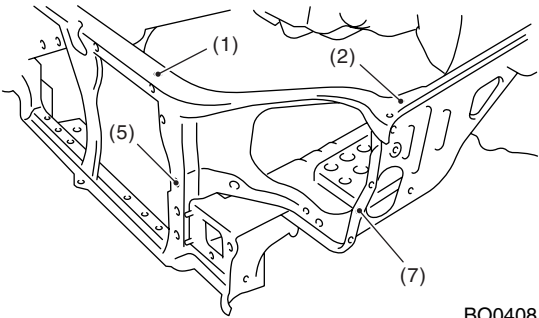
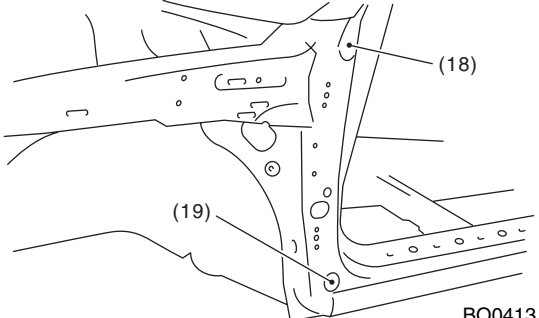
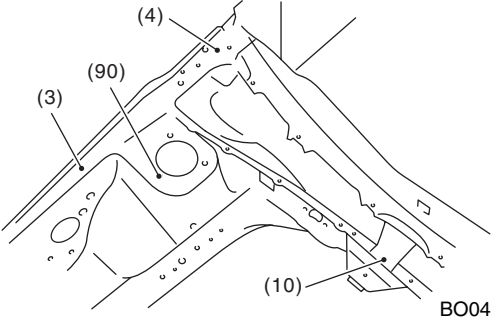
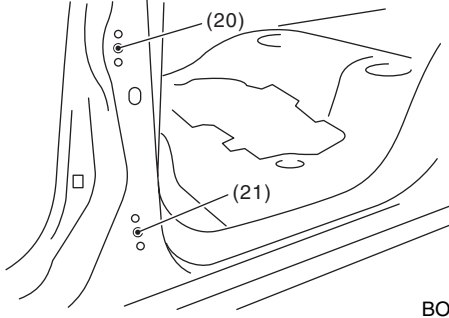
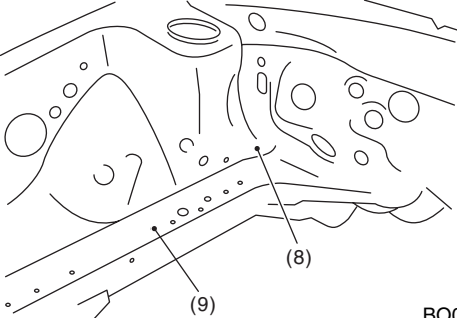
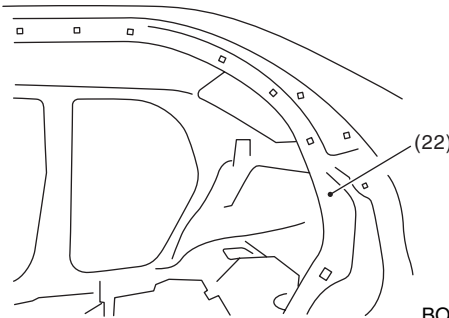
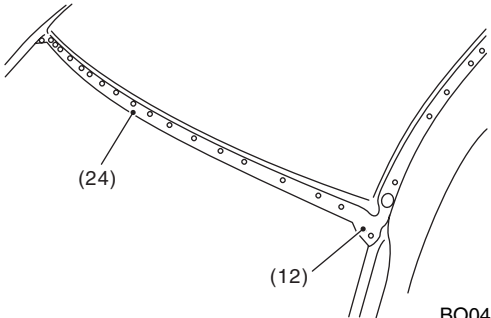
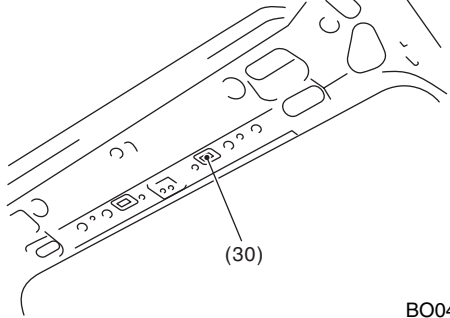


BO0407

- | | | |
|--|---|--|
| (80) Radiator lower frame gauge hole dia. 12 mm (0.47 in) (symmetrical) | (86) Side frame gauge hole dia. 18 mm (0.71 in) (symmetrical) | (91) Strut mount attachment hole dia. 10 mm (0.39 in) (symmetrical) |
| (81) Side frame gauge hole dia. 20 mm (0.79 in) (symmetrical) | (87) Rear differential mounting hole dia. 16 mm (0.63 in) (symmetrical) | (92) Sub frame mounting hole dia. 16 mm (0.63 in) (symmetrical) |
| (82) Front crossmember (front) mounting hole dia. 12.4 mm (0.488 in) (symmetrical) | (88) Rear suspension mounting hole dia. 16 mm (0.63 in) (symmetrical) | (93) Bumper beam mounting hole RH dia. 15 mm (0.59 in) LH dia. 19 × 15 mm (0.75 × 0.59 in) |
| (83) Suspension mounting hole dia. 17 mm (0.67 in) (symmetrical) | (89) Rear side frame gauge hole dia. 15 mm (0.59 in) (symmetrical) | (94) Side frame gauge hole dia. 15 mm (0.59 in) (symmetrical) |
| (84) Side frame gauge hole dia. 20 mm (0.79 in) (symmetrical) | (90) Strut mount attachment hole dia. 9.5 mm (0.374 in) (symmetrical) | |
| (85) Transmission mount attachment hole dia. 14 mm (0.55 in) | | |

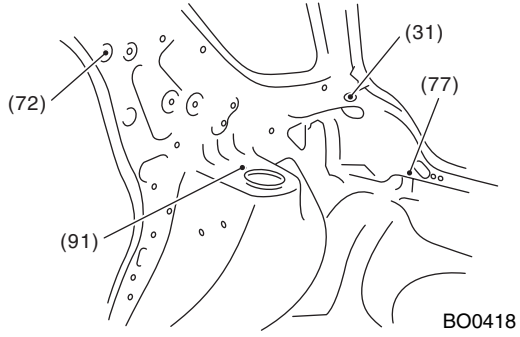
Body Reference Points

5. DETAILED REFERENCE POINT

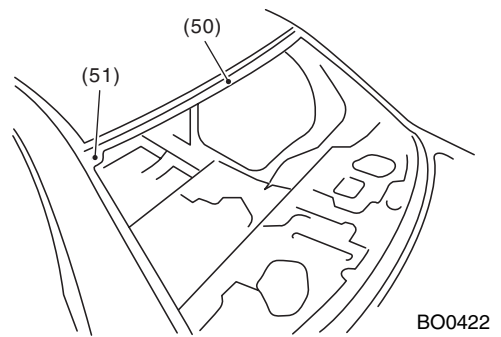
 BO0408	 BO0413
 BO0409	 BO0414
 BO0410	 BO0415
 BO0411	Wagon  BO0417

Body Reference Points

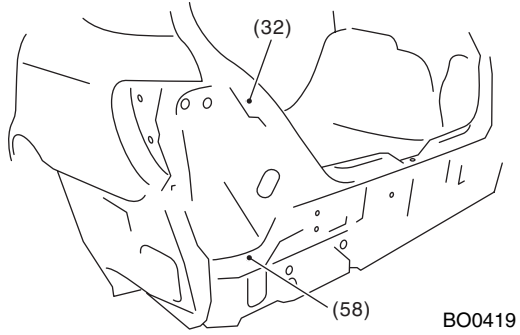
Wagon



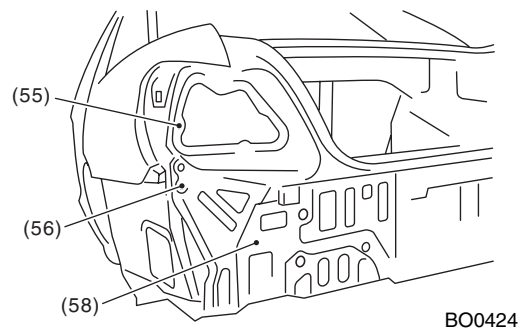
Sedan



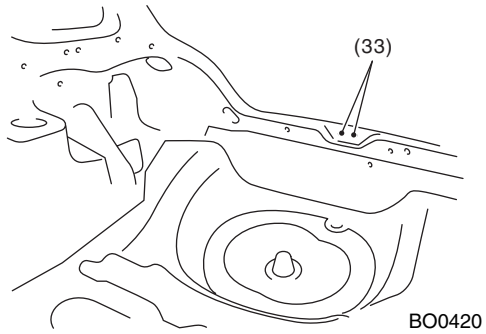
Wagon



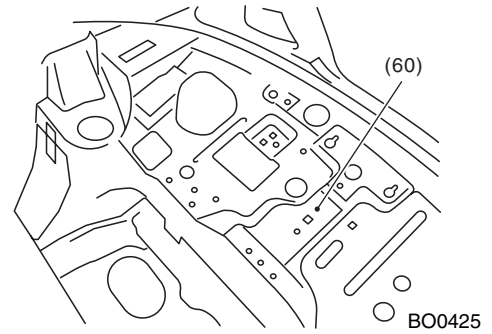
Sedan



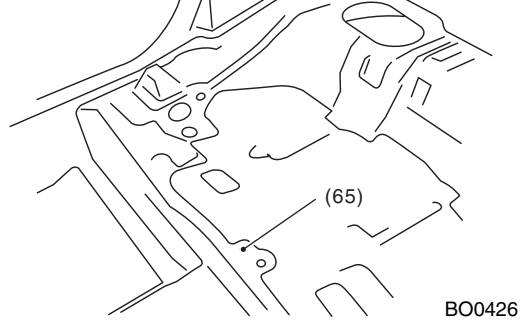
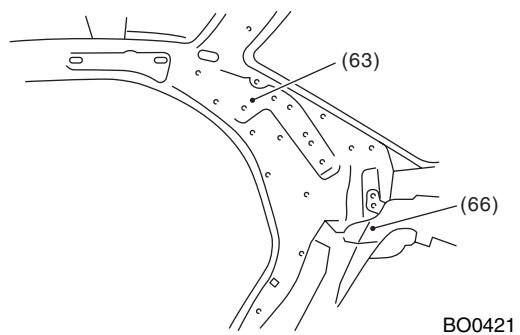
Wagon



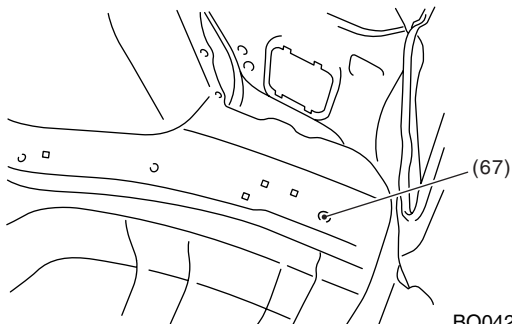
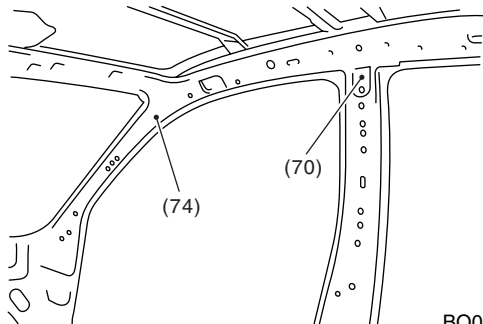
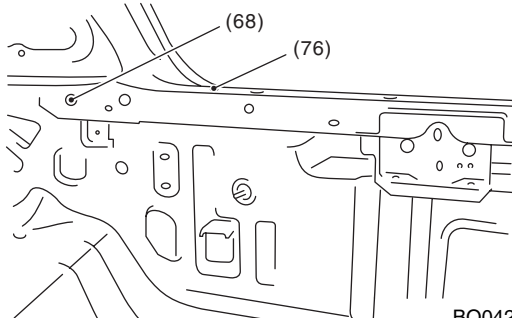
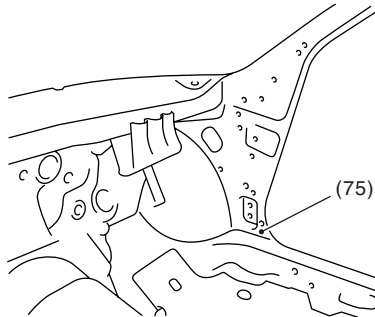
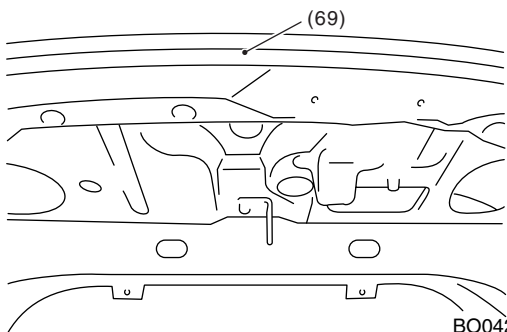
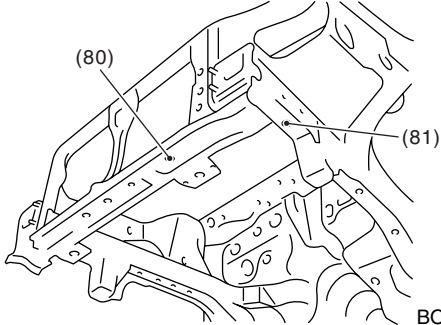
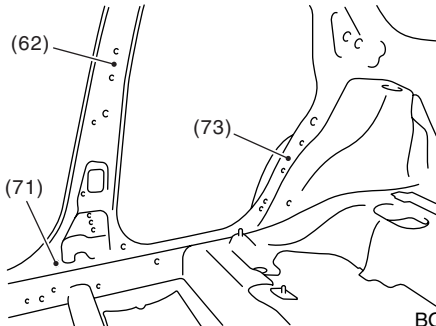
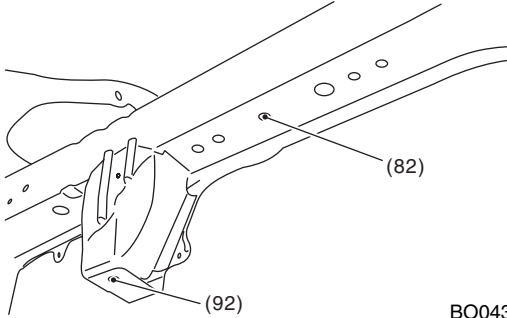
Sedan



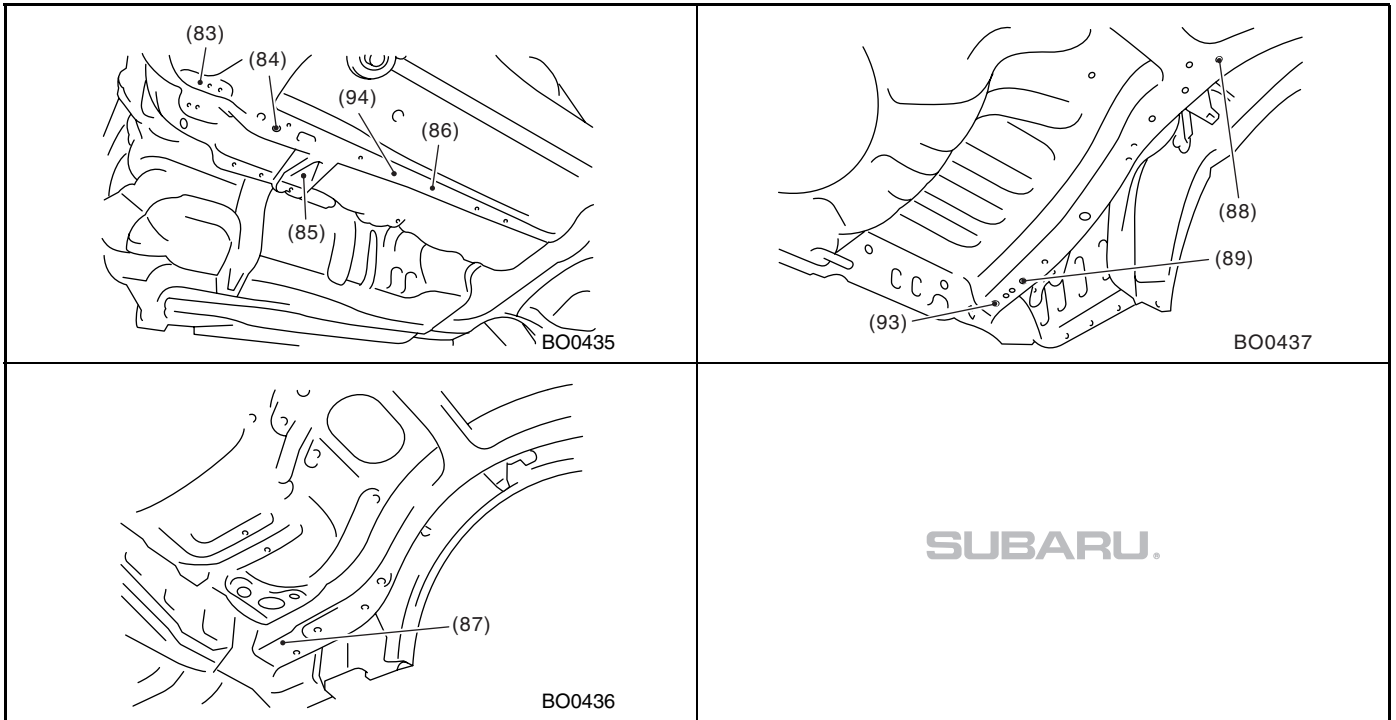
Sedan



Body Reference Points

 BO0427	 BO0431
Sedan  BO0428	 BO0432
Sedan  BO0429	 BO0433
 BO0430	 BO0434

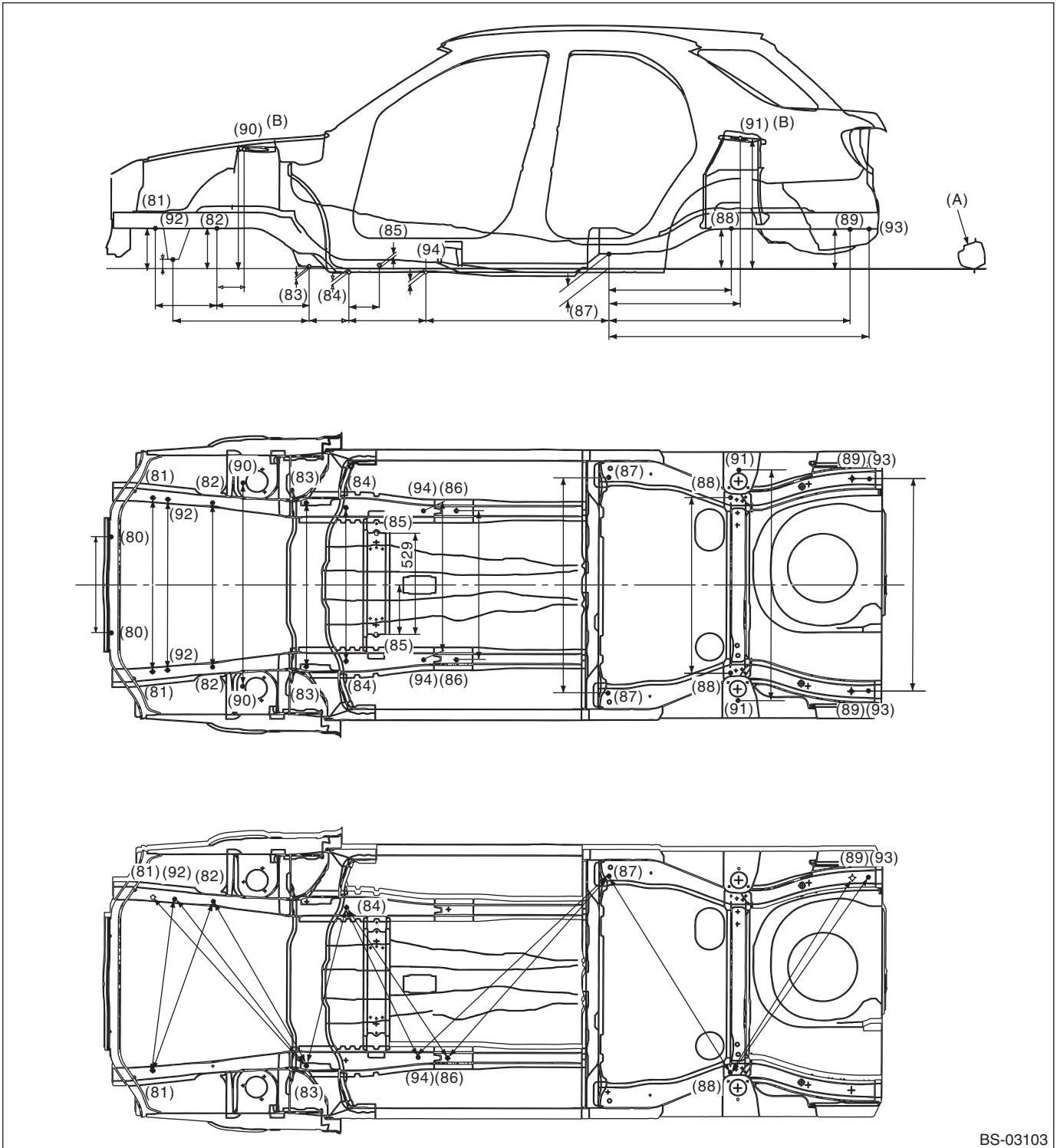
Body Reference Points



Body Reference Points

B: DATUM DIMENSION

1. UNDER BODY SECTION



BS-03103

(A) Side sill

(B) Upper face

Body Reference Points

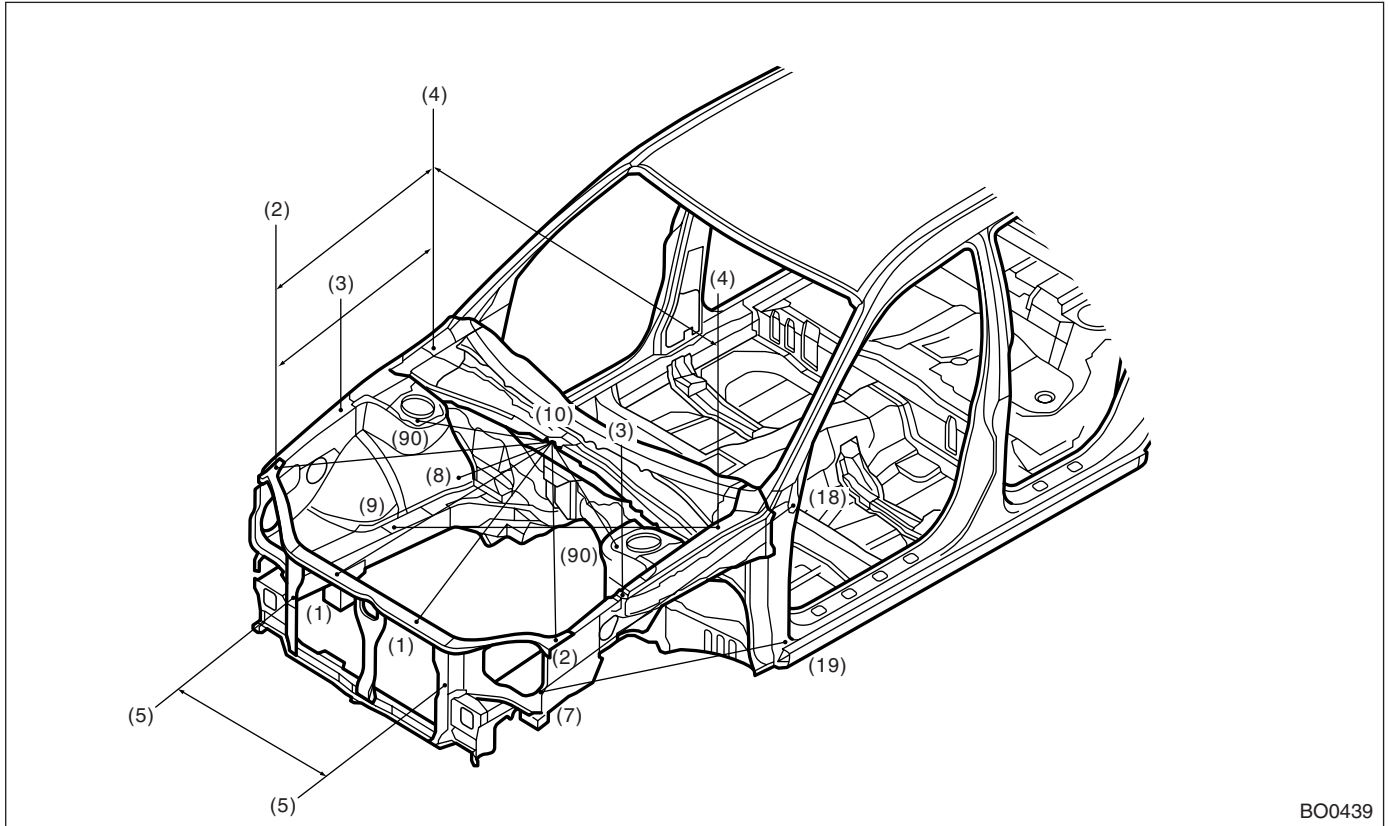
Measurement point	Datum dimension mm (in)
Datum line — (81)	206 (8.11)
Datum line — (82)	106 (4.17)
Datum line — (83)	8 (0.31)
Datum line — (84)	20 (0.79)
Datum line — (85)	13 (0.51)
Datum line — (87)	76 (2.99)
Datum line — (88)	206 (8.11)
Datum line — (89)	205 (8.07)
Datum line — (90)	620 (24.41)
Datum line — (91)	674 (26.54)
Datum line — (92)	77 (3.03)
Datum line — (94)	12 (0.47)
(81) — (82)	317 (12.48)
(82) — (83)	485 (19.09)
(82) — (90)	157 (6.18)
(83) — (84)	206 (8.11)
(84) — (85)	159 (6.26)
(84) — (94)	380 (14.96)
(87) — (88)	633 (24.92)
(87) — (89)	1258 (49.53)
(87) — (91)	673 (26.50)
(87) — (93)	1358 (53.46)
(92) — (83)	694 (27.32)
(94) — (87)	982 (38.66)
(80) LH — (80) RH	500 (19.69)
(81) LH — (81) RH	910 (35.83)
(82) LH — (82) RH	860 (33.86)
(83) LH — (83) RH	856 (33.70)
(84) LH — (84) RH	800 (31.50)
(85) LH — (85) RH	529 (20.83)
(86) LH — (86) RH	780 (30.71)
(87) LH — (87) RH	1128 (44.41)
(88) LH — (88) RH	920 (36.22)
(89) LH — (89) RH	1110 (43.70)
(90) LH — (90) RH	1065 (41.93)
(91) LH — (91) RH	1205 (47.44)
(92) LH — (92) RH	906 (35.67)
(93) LH — (93) RH	1110 (43.70)
(94) LH — (94) RH	776 (30.55)
(81) LH — (83) RH	1209 (47.60)
(82) LH — (81) RH	940 (37.01)
(82) LH — (83) RH	1005 (39.57)
(84) LH — (83) RH	854 (33.62)
(84) LH — (86) RH	951 (37.44)
(84) LH — (94) RH	875 (34.45)
(87) LH — (86) RH	1269 (49.96)
(87) LH — (88) RH	1211 (47.68)
(87) LH — (94) RH	1371 (53.98)
(89) LH — (88) RH	1192 (46.93)
(92) LH — (81) RH	924 (36.38)
(92) LH — (83) RH	1124 (44.25)
(93) LH — (88) RH	1247 (49.09)

NOTE:

- Longitudinal dimensions are projected dimensions.
- Height dimensions are the vertical distances from the gauge point on the assumed horizontal line through the side sill flange joint (bending angle point).
- Diagonal dimensions are the actual dimensions between reference points.

Body Reference Points

2. WAGON/SEDAN (FRONT STRUCTURE)

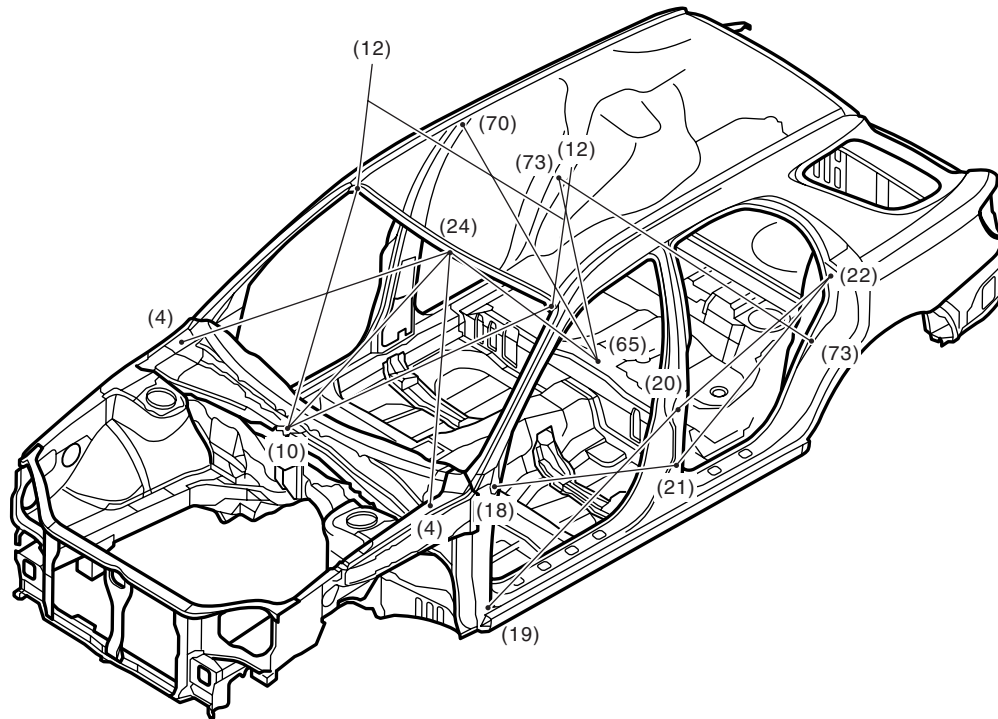


BO0439

Unit: mm (in)

Measurement point	Datum dimension	Measurement point	Datum dimension
(10) — (1) RH	912 (35.91)	(2) RH — (2) LH	1,341 (52.80)
(10) — (1) LH	912 (35.91)	(5) RH — (5) LH	720 (28.35)
(10) — (90) RH	566 (22.28)	(7) RH — (18) RH	1,138 (44.80)
(10) — (90) LH	566 (22.28)	(7) LH — (18) LH	1,138 (44.80)
(10) — (8) RH	581 (22.87)	(7) RH — (19) RH	1,116 (43.94)
(10) — (8) LH	581 (22.87)	(7) LH — (19) LH	1,116 (43.94)
(10) — (2) RH	947 (37.28)	(4) RH — (2) LH	1,583 (62.32)
(10) — (2) LH	947 (37.28)	(4) LH — (2) RH	1,583 (62.32)
(4) RH — (2) RH	778 (30.63)	(3) RH — (3) LH	1,396 (54.96)
(4) LH — (2) LH	778 (30.63)	(3) RH — (4) LH	1,470 (57.87)
(4) RH — (3) RH	430 (16.93)	(3) LH — (4) RH	1,470 (57.87)
(4) LH — (3) LH	430 (16.93)	(2) RH — (3) LH	1,412 (55.59)
(90) RH — (90) LH	1,065 (41.93)	(2) LH — (3) RH	1,412 (55.59)
(8) RH — (8) LH	894 (35.20)	(9) RH — (9) LH	860 (33.86)
(8) RH — (4) LH	1,210 (47.64)	(9) RH — (8) LH	931 (36.65)
(8) LH — (4) RH	1,210 (47.64)	(9) LH — (8) RH	931 (36.65)
(3) RH — (2) RH	349 (13.74)	(9) RH — (4) LH	1,280 (50.39)
(3) LH — (2) LH	349 (13.74)	(9) LH — (4) RH	1,280 (50.39)
(4) RH — (4) LH	1,417 (55.79)	—	—

Body Reference Points



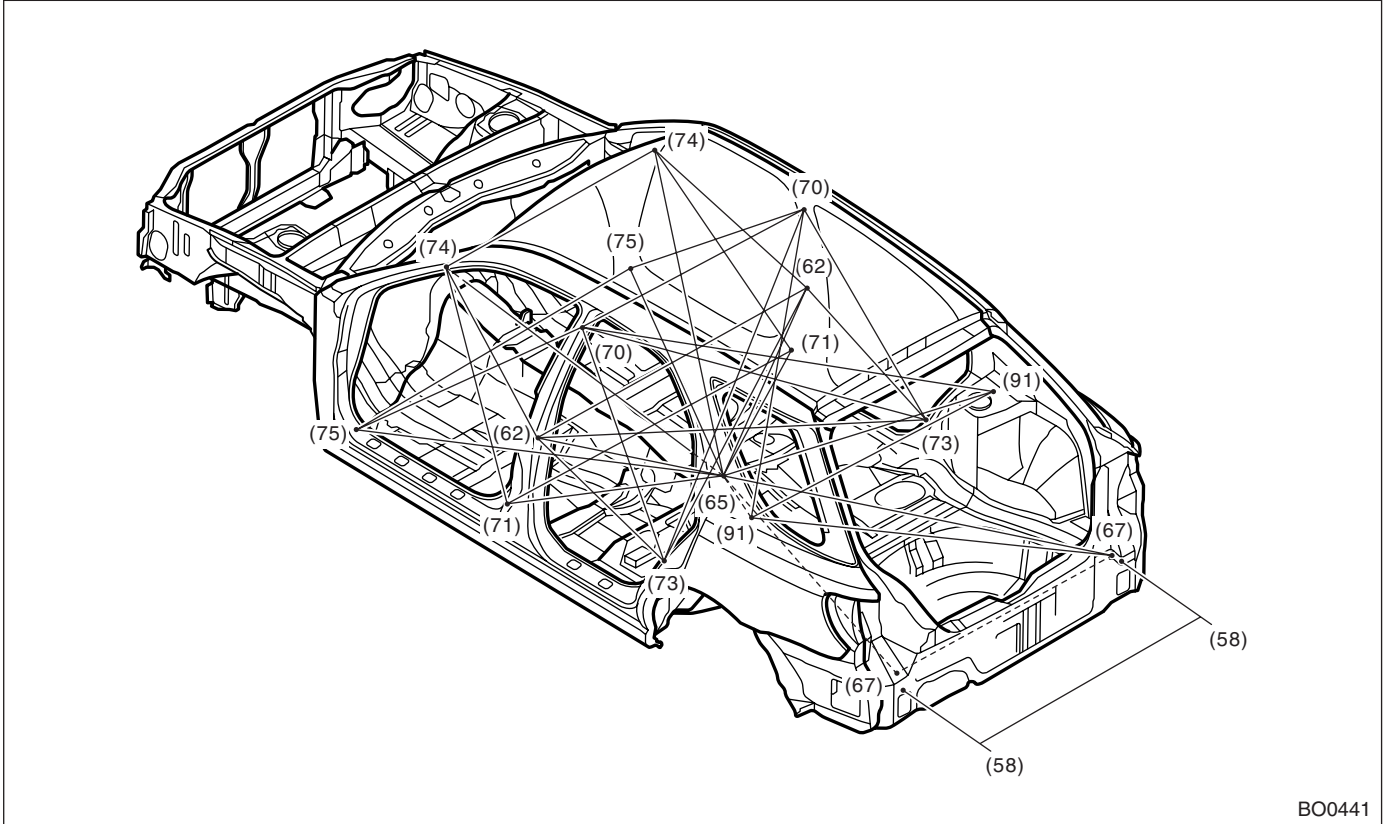
BO0440

Unit: mm (in)

Measurement point	Datum dimension	Measurement point	Datum dimension
(4) RH — (24)	1,127 (44.37) wagon	(19) LH — (20) LH	1,089 (42.87)
(4) LH — (24)	1,110 (43.70) sedan	(20) RH — (22) RH	869 (34.21)
(10) — (24)	957 (37.68) wagon	(20) LH — (22) LH	869 (34.21)
(10) — (24)	935 (36.81) sedan	(21) RH — (22) RH	985 (38.78)
(10) — (12) RH	1,122 (44.17) wagon	(21) LH — (22) LH	985 (38.78)
(10) — (12) RH	1,106 (43.54) sedan	(24) — (65)	1,232 (48.50) wagon
(10) — (12) LH	1,122 (44.17) wagon	(24) — (65)	1,237 (48.70) sedan
(10) — (12) LH	1,106 (43.54) sedan	(65) — (70) RH	1,067 (42.01)
(12) RH — (12) LH	1,029 (40.51) wagon	(65) — (70) LH	1,067 (42.01)
(12) RH — (12) LH	1,042 (41.02) sedan	(65) — (73) RH	830 (32.68)
(18) RH — (21) RH	1,049 (41.30)	(65) — (73) LH	830 (32.68)
(18) LH — (21) LH	1,049 (41.30)	(73) RH — (73) LH	1,394 (54.88)
(19) RH — (20) RH	1,089 (42.87)	—	—

Body Reference Points

3. WAGON/SEDAN (REAR STRUCTURE)



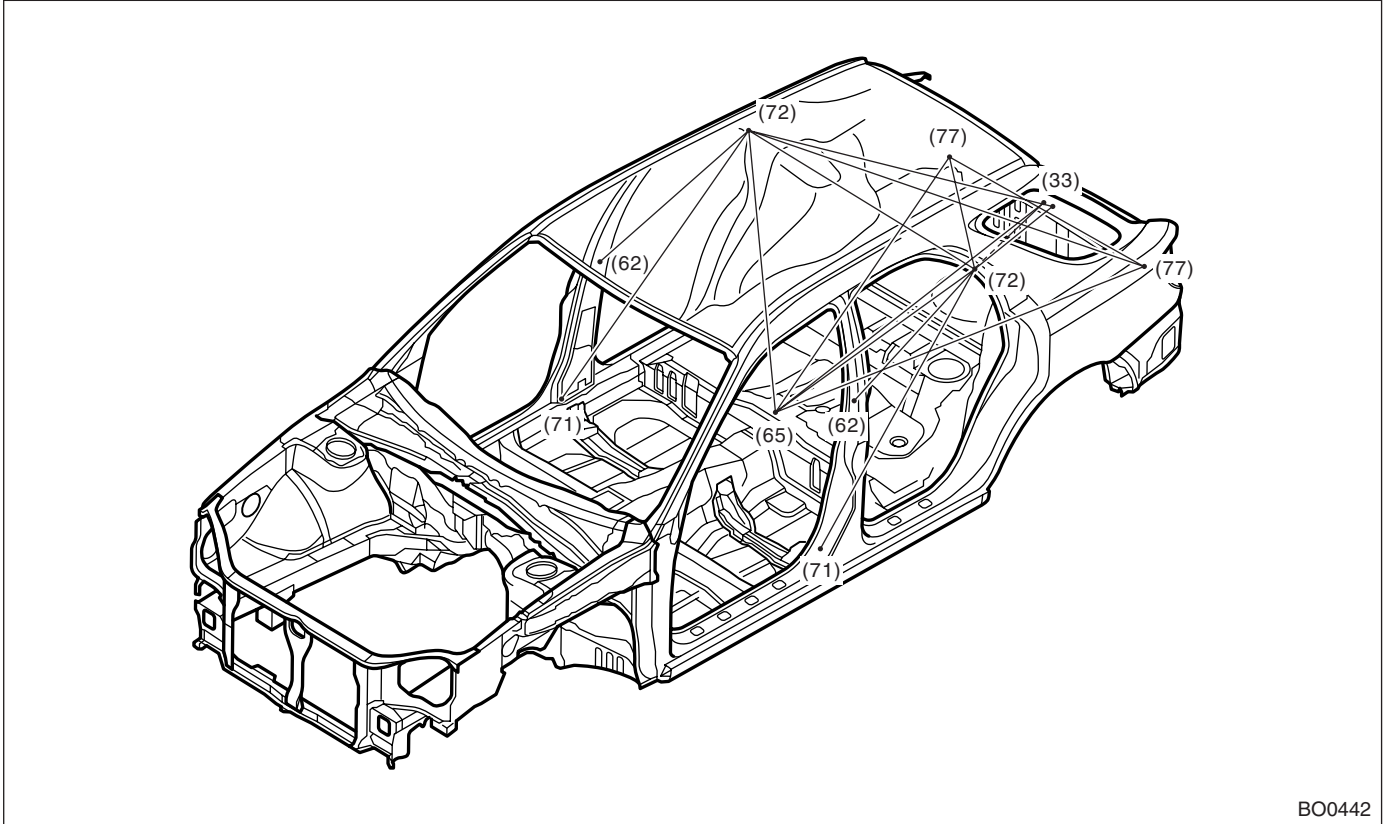
BO0441

Unit: mm (in)

Measurement point	Datum dimension	Measurement point	Datum dimension
(58) RH — (58) LH	1,128 (44.41)	(67) LH — (67) LH	1,110 (43.70)
(62) RH — (62) LH	1,332 (52.44)	(67) RH — (91) LH	1,381 (54.37)
(62) RH — (65)	915 (36.02)	(67) LH — (91) RH	1,381 (54.37)
(62) LH — (65)	915 (36.02)	(70) RH — (70) LH	1,060 (41.73)
(62) RH — (73) RH	762 (30.00)	(70) RH — (73) RH	948 (37.32)
(62) LH — (73) LH	762 (30.00)	(70) LH — (73) LH	948 (37.32)
(62) RH — (73) LH	1,561 (61.46)	(70) RH — (73) LH	1,542 (60.71)
(62) LH — (73) RH	1,561 (61.46)	(70) LH — (73) RH	1,542 (60.71)
(62) RH — (74) RH	592 (23.31) wagon	(70) RH — (75) RH	1,443 (56.81)
(62) LH — (74) LH	6.3 (23.74) sedan	(70) LH — (75) LH	1,443 (56.81)
(65) — (67) RH	1,501 (59.09)	(70) RH — (91) LH	1,532 (60.32)
(65) — (67) LH	1,501 (59.09)	(70) LH — (91) RH	1,532 (60.32)
(65) — (71) RH	823 (32.40)	(71) RH — (71) LH	1,361 (53.58)
(65) — (71) LH	823 (32.40)	(71) RH — (74) RH	954 (37.56) wagon
(65) — (74) RH	1,275 (50.20) wagon	(71) LH — (74) LH	949 (37.36) sedan
(65) — (74) LH	1,282 (50.47) sedan	(74) RH — (74) LH	1,135 (44.69) wagon
(65) — (75) RH	1,450 (57.09)	(74) RH — (74) LH	1,147 (45.16) sedan
(65) — (75) LH	1,450 (57.09)	(75) RH — (75) LH	1,399 (55.08)
(65) — (91) RH	1,064 (41.89)	(91) RH — (91) LH	1,205 (47.44)
(65) — (91) LH	1,064 (41.89)	—	—

Body Reference Points

4. WAGON (FRONT STRUCTURE)



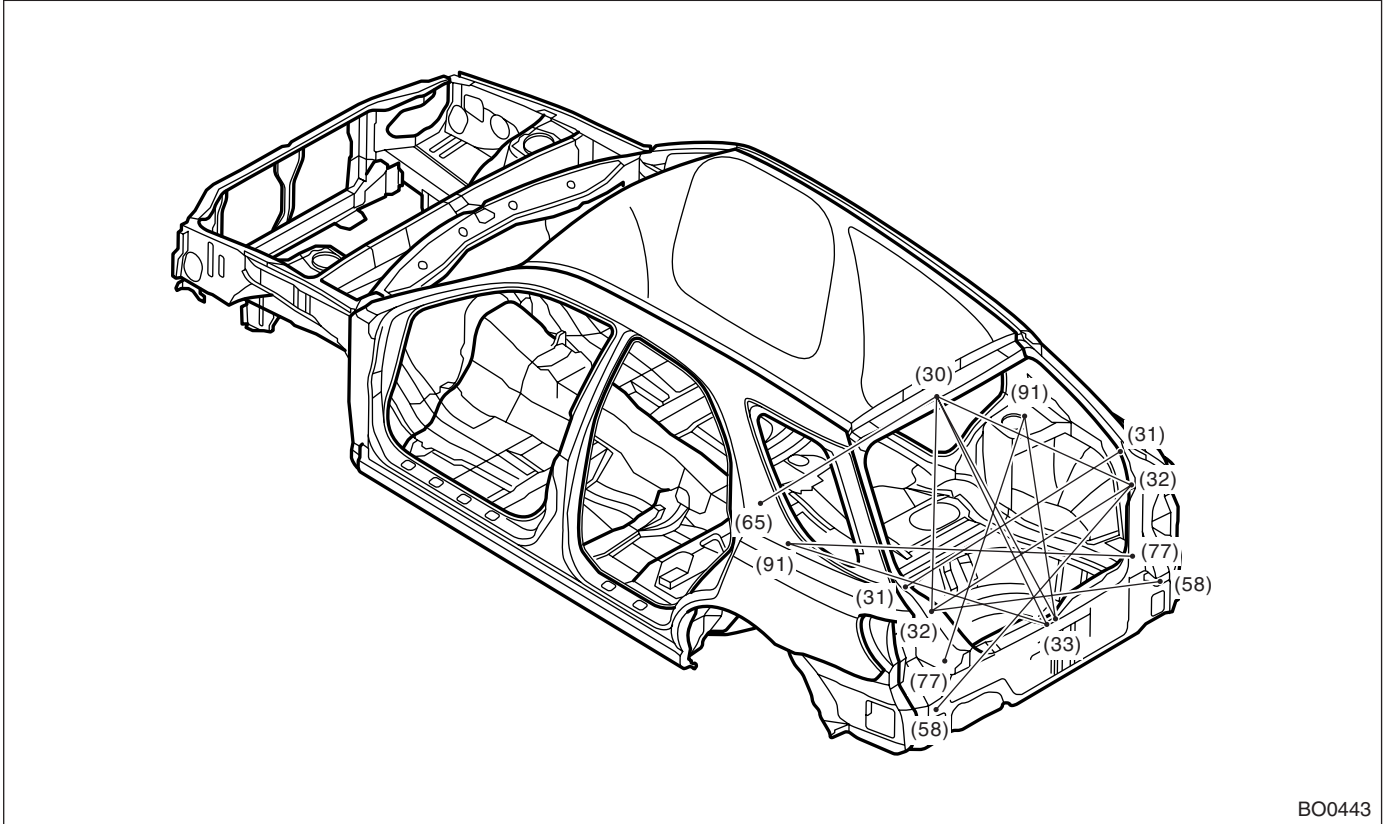
BO0442

Unit: mm (in)

Measurement point	Datum dimension	Measurement point	Datum dimension
(33) RH — (65)	1,534 (60.39)	(65) — (77) RH	1,538 (60.55)
(33) LH — (65)	1,534 (60.39)	(65) — (77) LH	1,538 (60.55)
(33) RH — (72) LH	1,344 (52.91)	(71) RH — (72) RH	1,223 (48.15)
(33) LH — (72) RH	1,344 (52.91)	(71) LH — (72) LH	1,223 (48.15)
(62) RH — (72) RH	732 (28.82)	(72) RH — (72) LH	1,226 (48.27)
(62) LH — (72) LH	732 (28.82)	(72) RH — (77) LH	1,544 (60.79)
(65) — (72) RH	1,076 (42.36)	(72) LH — (77) RH	1,544 (60.79)
(65) — (72) LH	1,076 (42.36)	(77) RH — (77) LH	898 (35.35)

Body Reference Points

5. WAGON (REAR STRUCTURE)



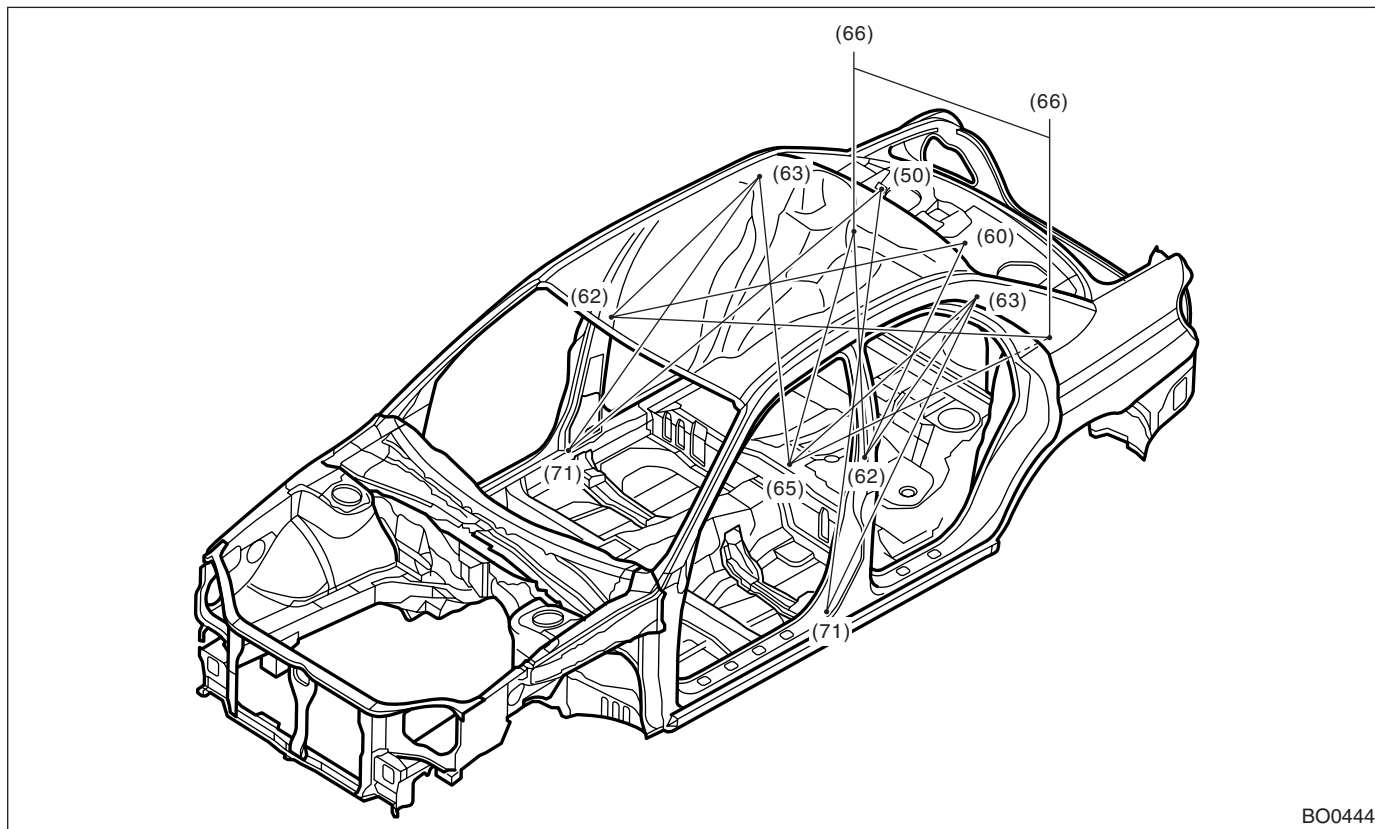
BO0443

Unit: mm (in)

Measurement point	Datum dimension	Measurement point	Datum dimension
(30) — (32) RH	850 (33.46)	(32) RH — (58) LH	1,139 (44.84)
(30) — (32) LH	850 (33.46)	(32) LH — (58) RH	1,139 (44.84)
(30) — (33) RH	904 (35.59)	(33) RH — (91) LH	993 (39.09)
(30) — (33) LH	904 (35.59)	(33) LH — (91) LH	993 (39.09)
(33) — (65)	1,292 (50.87)	(77) RH — (91) LH	1,289 (50.75)
(31) RH — (31) LH	1,212 (47.72)	(77) LH — (91) RH	1,289 (50.75)
(32) RH — (32) LH	1,038 (40.87)	—	—

Body Reference Points

6. SEDAN (FRONT STRUCTURE)



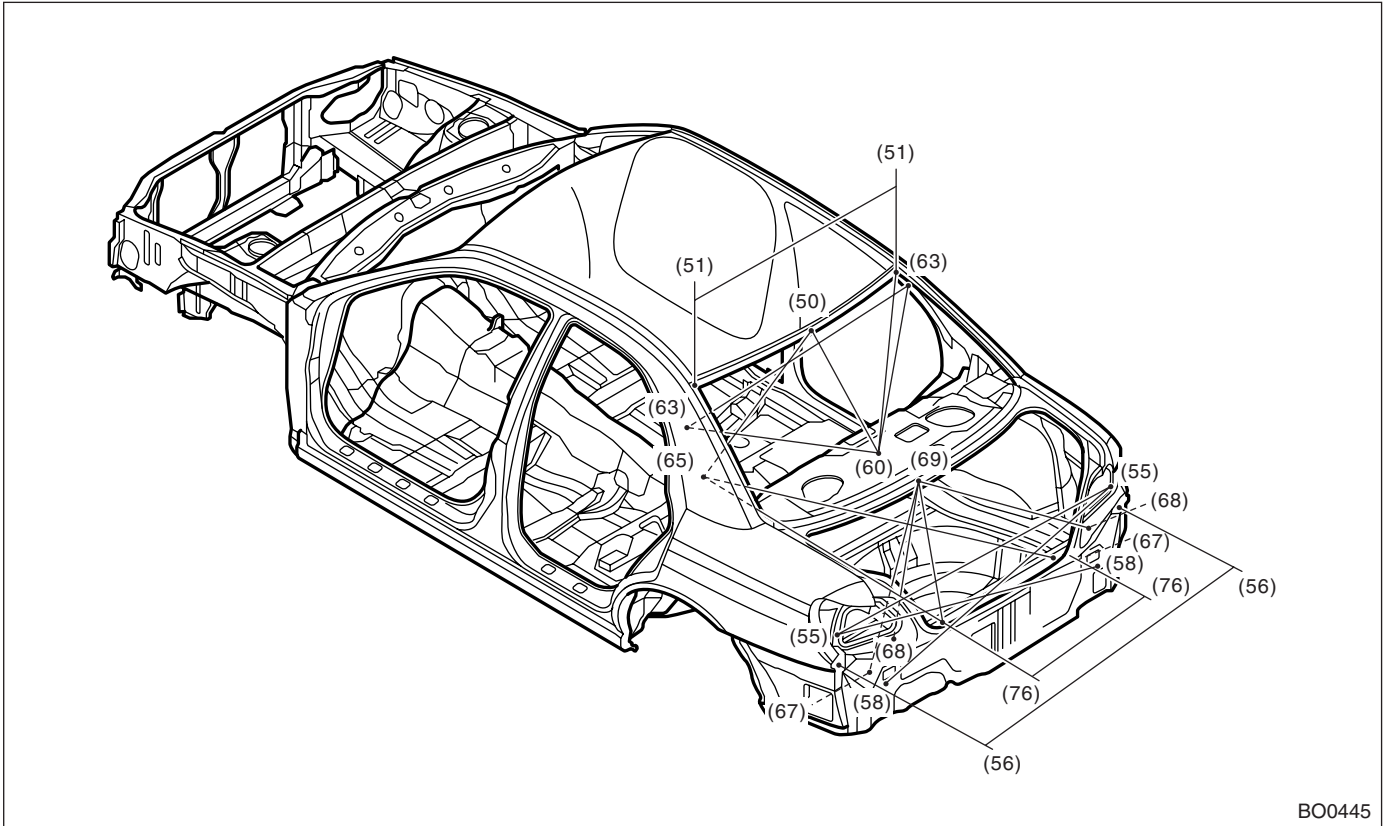
BO0444

Unit: mm (in)

Measurement point	Datum dimension	Measurement point	Datum dimension
(50) — (71) RH	1,562 (61.50)	(63) RH — (65)	1,118 (44.02)
(50) — (71) LH	1,562 (61.50)	(63) LH — (65)	1,118 (44.02)
(60) — (62) RH	1,338 (52.68)	(63) RH — (71) RH	1,283 (50.51)
(60) — (62) LH	1,338 (52.68)	(63) LH — (71) LH	1,283 (50.51)
(62) RH — (63) RH	773 (30.43)	(65) — (66) RH	956 (37.64)
(62) LH — (63) LH	773 (30.43)	(65) — (66) LH	956 (37.64)
(62) RH — (66) LH	1,449 (57.05)	(66) RH — (66) LH	840 (33.07)
(62) LH — (66) RH	1,449 (57.05)	—	—

Body Reference Points

7. SEDAN (REAR STRUCTURE)



BO0445

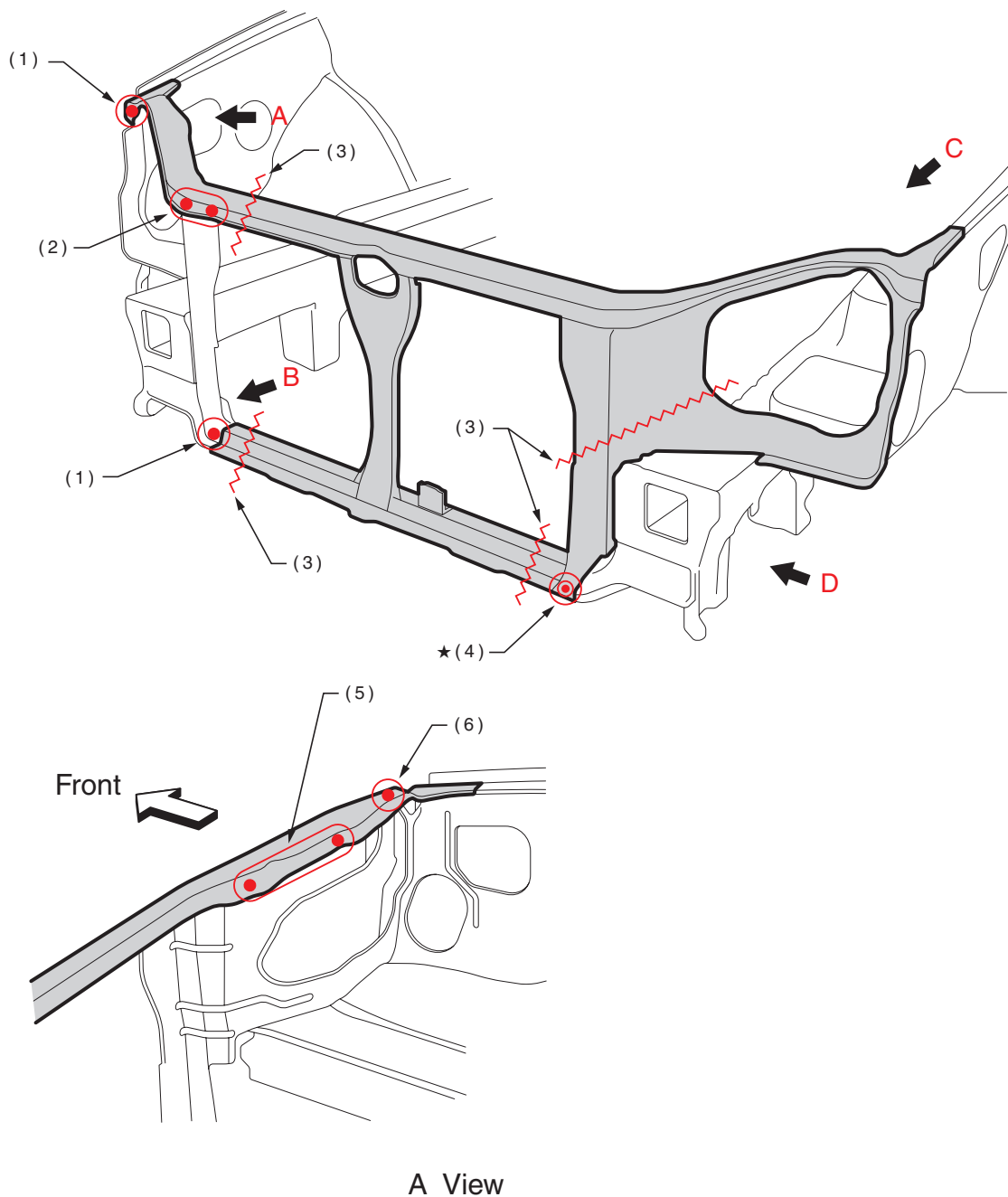
Unit: mm (in)

Measurement point	Datum dimension	Measurement point	Datum dimension
(50) — (60)	501 (19.72)	(65) — (76) LH	1,544 (60.79)
(50) — (65)	1,082 (42.60)	(65) — (68) RH	1,581 (62.24)
(51) LH — (51) LH	1,025 (40.35)	(65) — (68) LH	1,581 (62.24)
(51) RH — (60)	734 (28.90)	(67) RH — (69)	784 (30.87)
(55) RH — (55) LH	1,406 (55.35)	(67) LH — (69)	784 (30.87)
(55) RH — (58) LH	1,297 (51.06)	(68) RH — (68) LH	1,027 (40.16)
(55) LH — (58) RH	1,297 (51.06)	(68) RH — (69)	681 (26.81)
(56) RH — (56) LH	1,426 (56.14)	(68) LH — (69)	681 (26.81)
(60) — (63) RH	764 (30.08)	(69) — (76) RH	537 (21.14)
(60) — (63) LH	764 (30.08)	(69) — (76) LH	537 (21.14)
(63) RH — (63) LH	1,183 (46.57)	(76) RH — (76) LH	600 (23.62)
(65) — (76) RH	1,544 (60.79)	—	—

Radiator Panel (total replacement)

12.Radiator Panel (total replacement)

A: REMOVAL



BS-02995

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

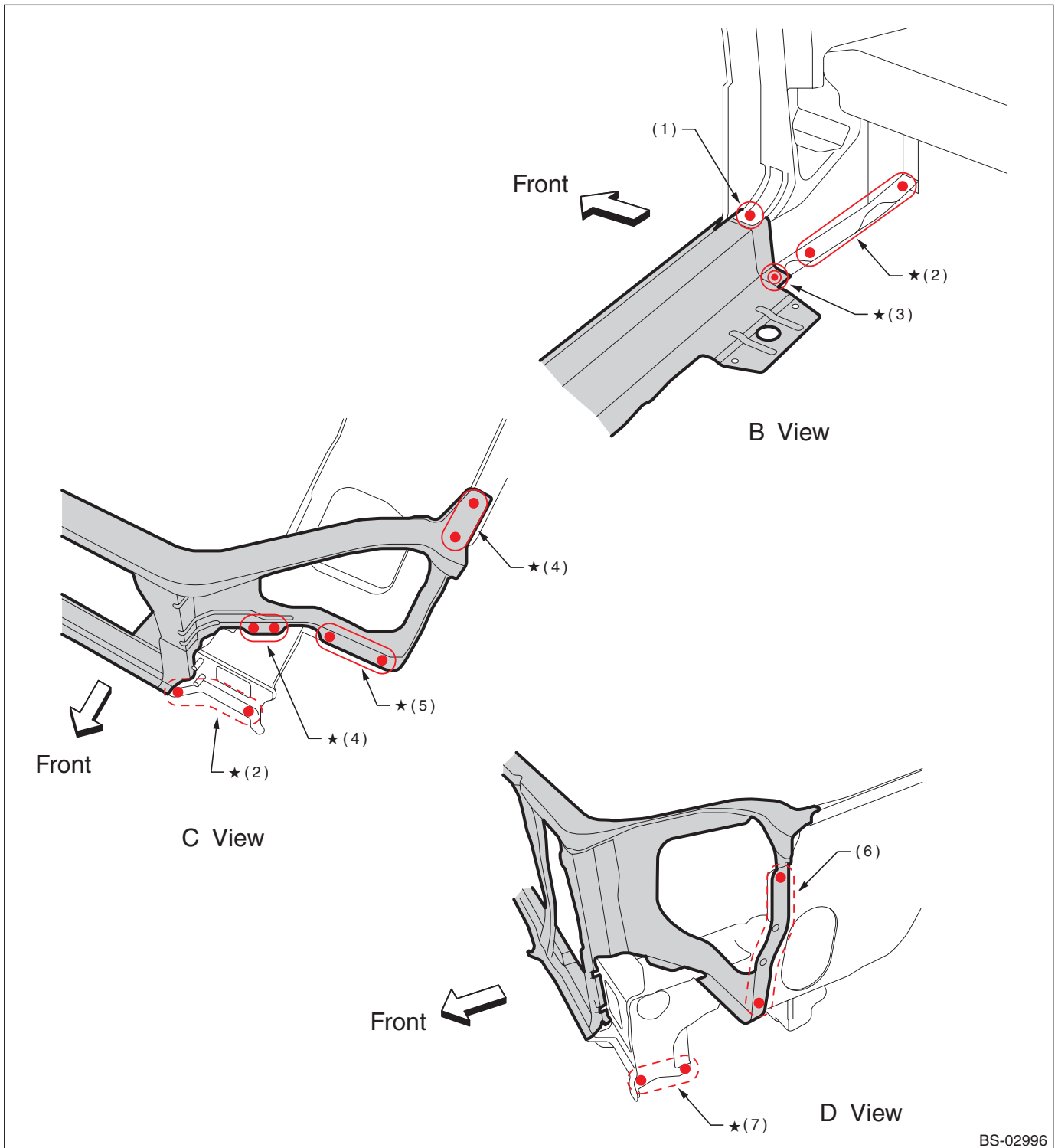
- (3) Rough cutting
- (4) 1 point (top · 1, bottom · 1)

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

NOTE:

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

Radiator Panel (total replacement)



BS-02996

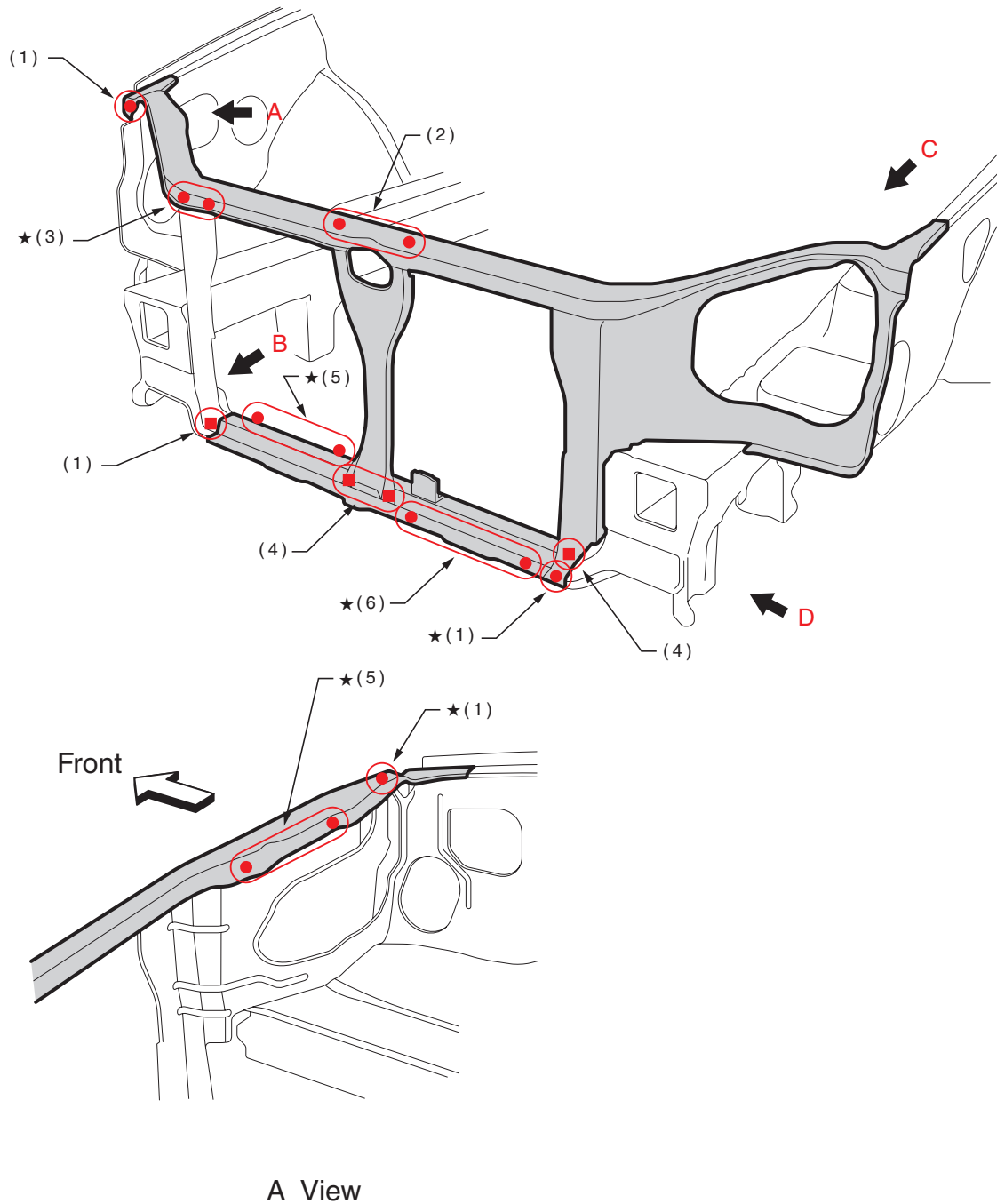
- | | | |
|-----------------------------------|---------------------------|---------------------------|
| (1) 1 point (top · 1) | (4) 2 points (top · 1) | (7) 4 points (inside · 1) |
| (2) 4 points (bottom · 1) | (5) 3 points (top · 1) | |
| (3) 1 point (top · 1, bottom · 1) | (6) 5 points (inside ·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

NOTE:

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

Radiator Panel (total replacement)

B: INSTALLATION



BS-02997

(1) 1 point
(2) 2 points

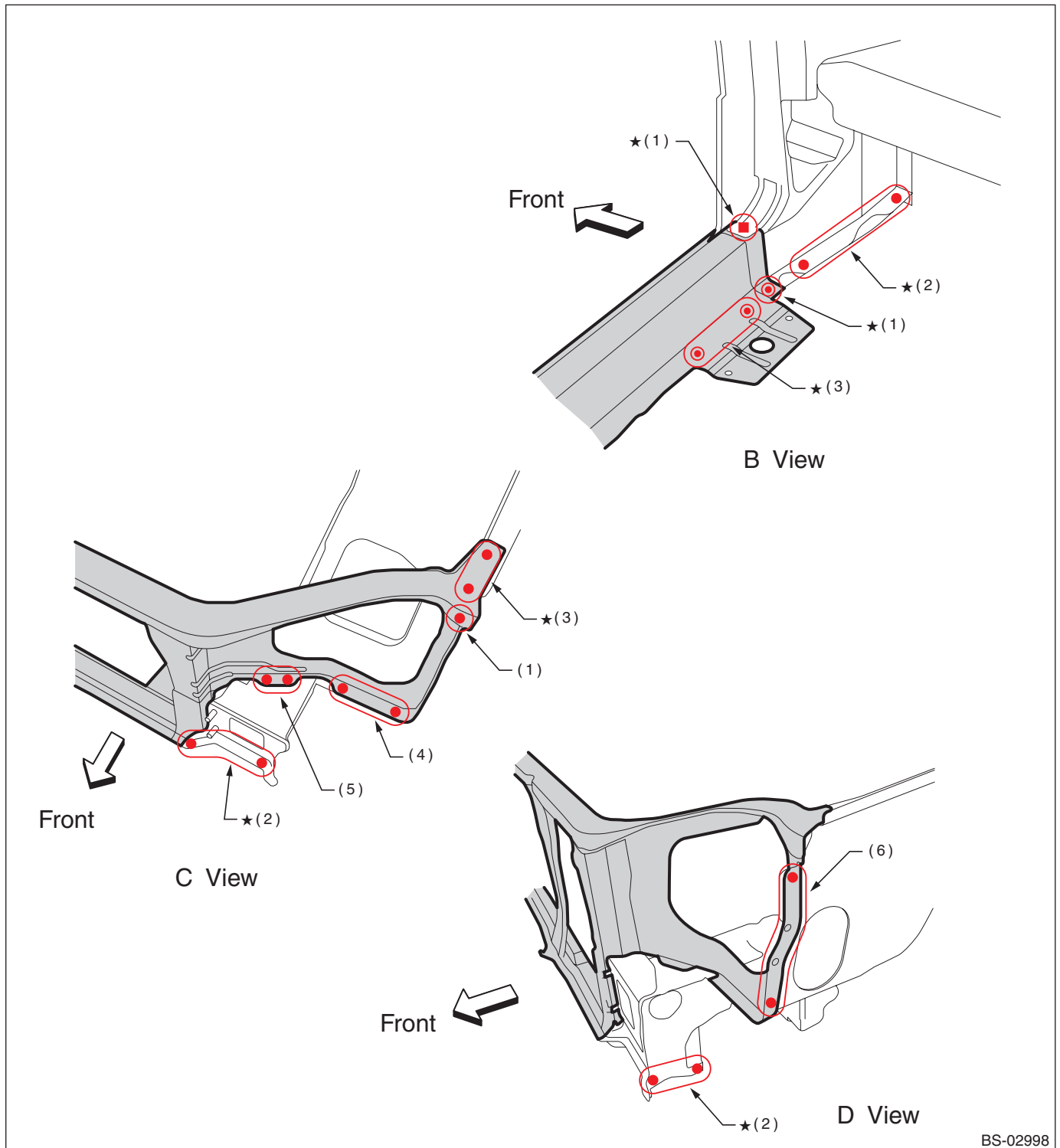
(3) 3 points
(4) 1 point (service)

(5) 5 points
(6) 9 points

NOTE:

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

Radiator Panel (total replacement)



BS-02998

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

- (3) 3 points
- (4) 4 points

- (5) 2 points (service)
- (6) 6 points

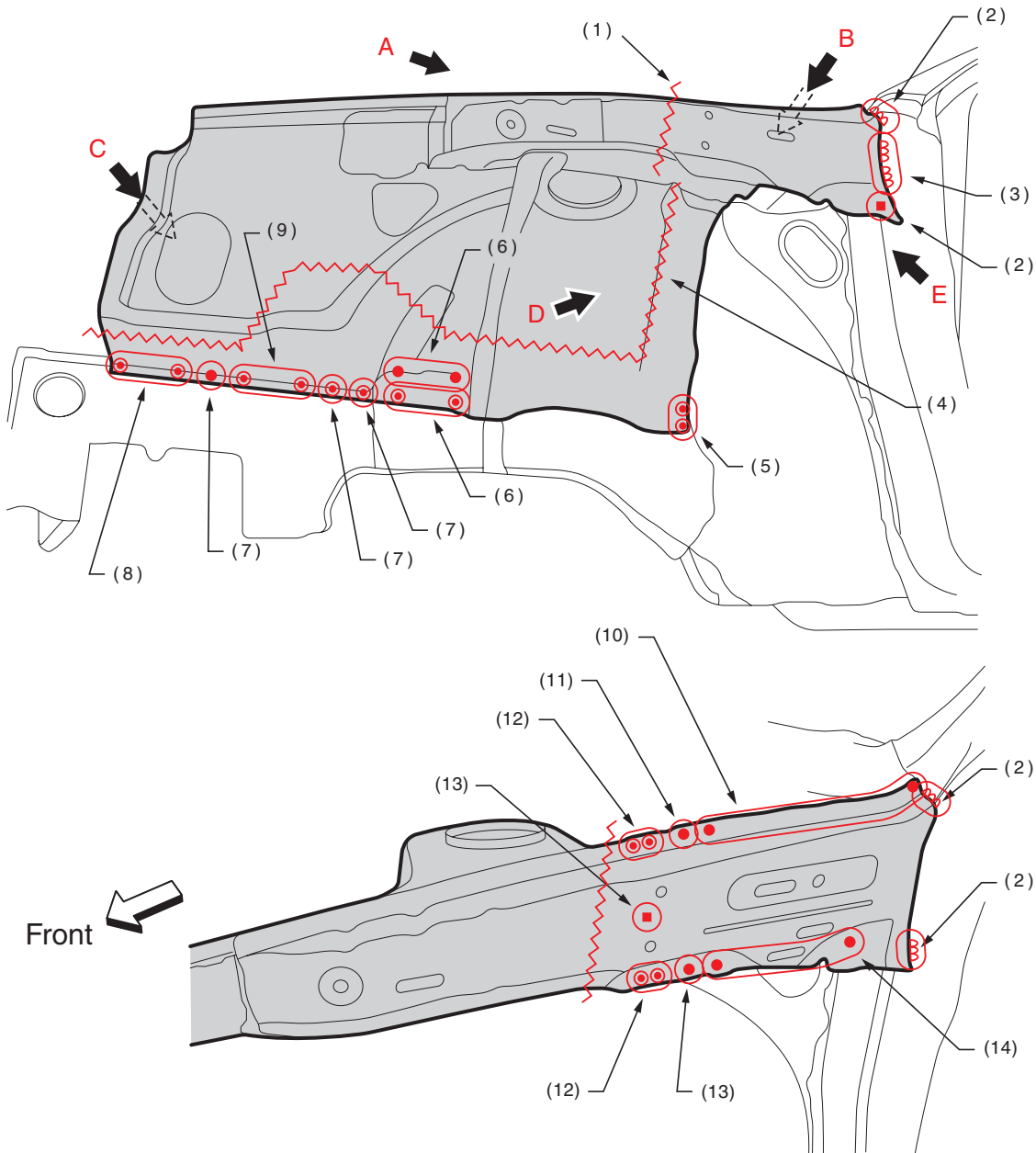
NOTE:

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

Front Wheel Apron (total replacement)

13. Front Wheel Apron (total replacement)

A: REMOVAL



A View

BS-02999

- | | | |
|---|-----------------------------|-----------------------------|
| (1) Rough cutting (side frame upper) | (6) 4 points (bottom · 1) | (11) 1 point (outside · 2) |
| (2) 1 point (outside · 1, belt sander) | (7) 1 point (bottom · 1) | (12) 2 points (outside · 1) |
| (3) 2 points (outside · 1, belt sander) | (8) 2 points (bottom · 1) | (13) 1 point (outside · 1) |
| (4) Rough cutting | (9) 3 points (bottom · 1) | (14) 4 points (outside · 1) |
| (5) 2 points (outside · 2) | (10) 5 points (outside · 1) | |

Front Wheel Apron (total replacement)

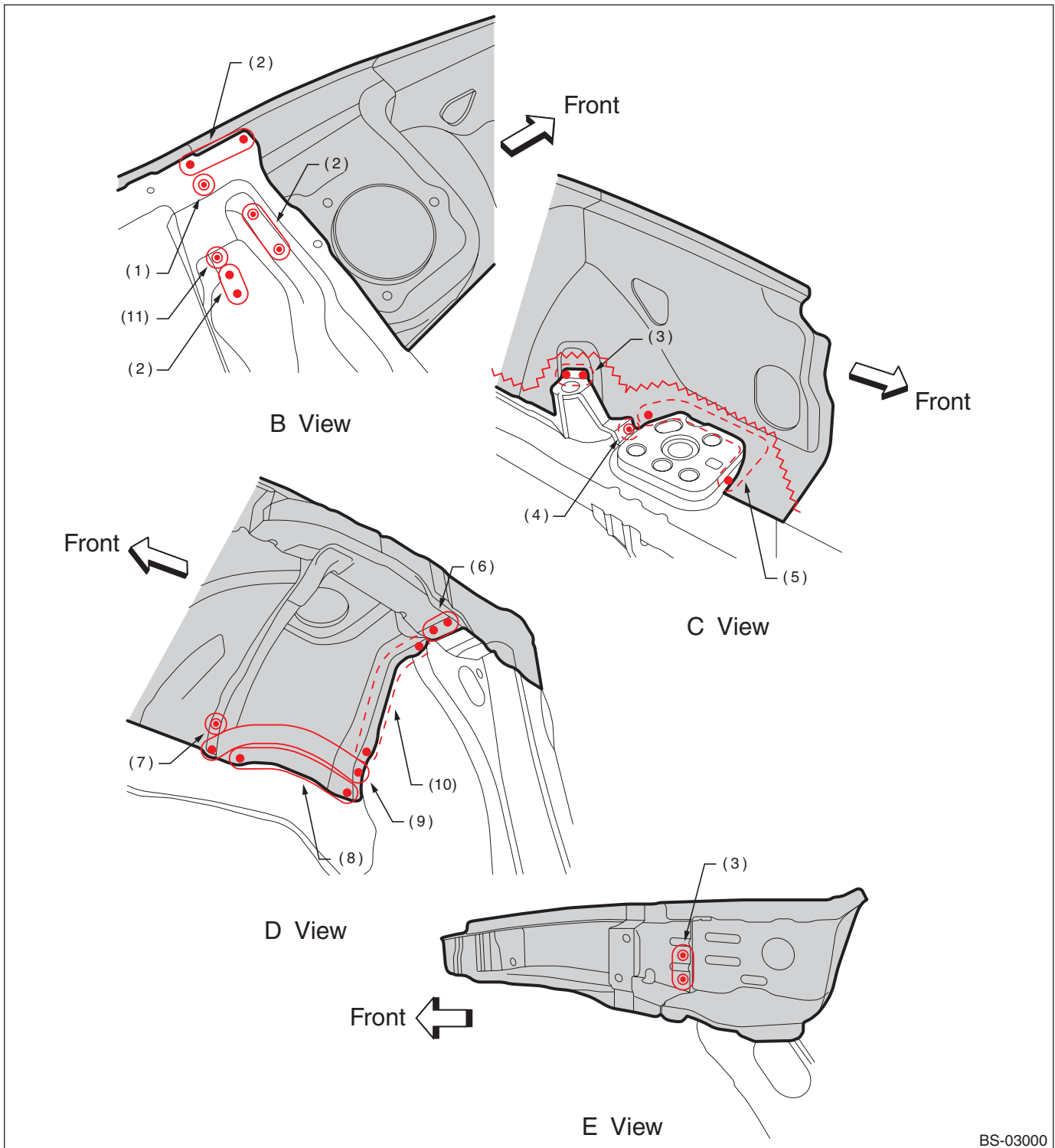
CAUTION:

When rough cutting, be careful not to damage the closing plate front bulkhead.

NOTE:

The illustration shows the radiator panel removed condition.

Front Wheel Apron (total replacement)



BS-03000

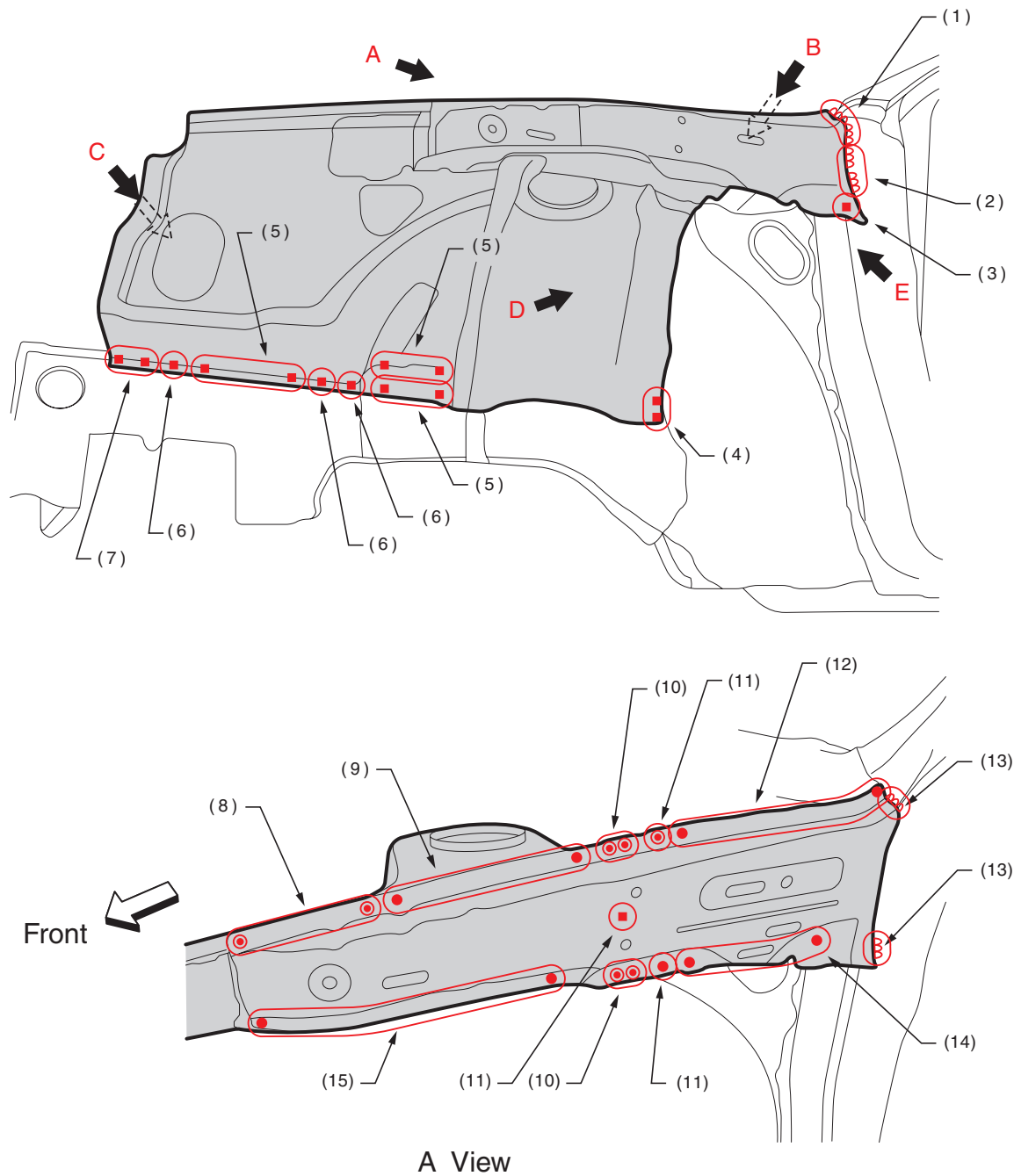
- | | | |
|----------------------------|----------------------------|-----------------------------|
| (1) 1 point (top · 1) | (5) 8 points (bottom · 1) | (9) 7 points (outside · 1) |
| (2) 2 points (top · 1) | (6) 4 points (bottom · 1) | (10) 10 points (inside · 1) |
| (3) 2 points (outside · 1) | (7)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

NOTE:

View E shows the side frame upper removed condition.

Front Wheel Apron (total replacement)

B: INSTALLATION



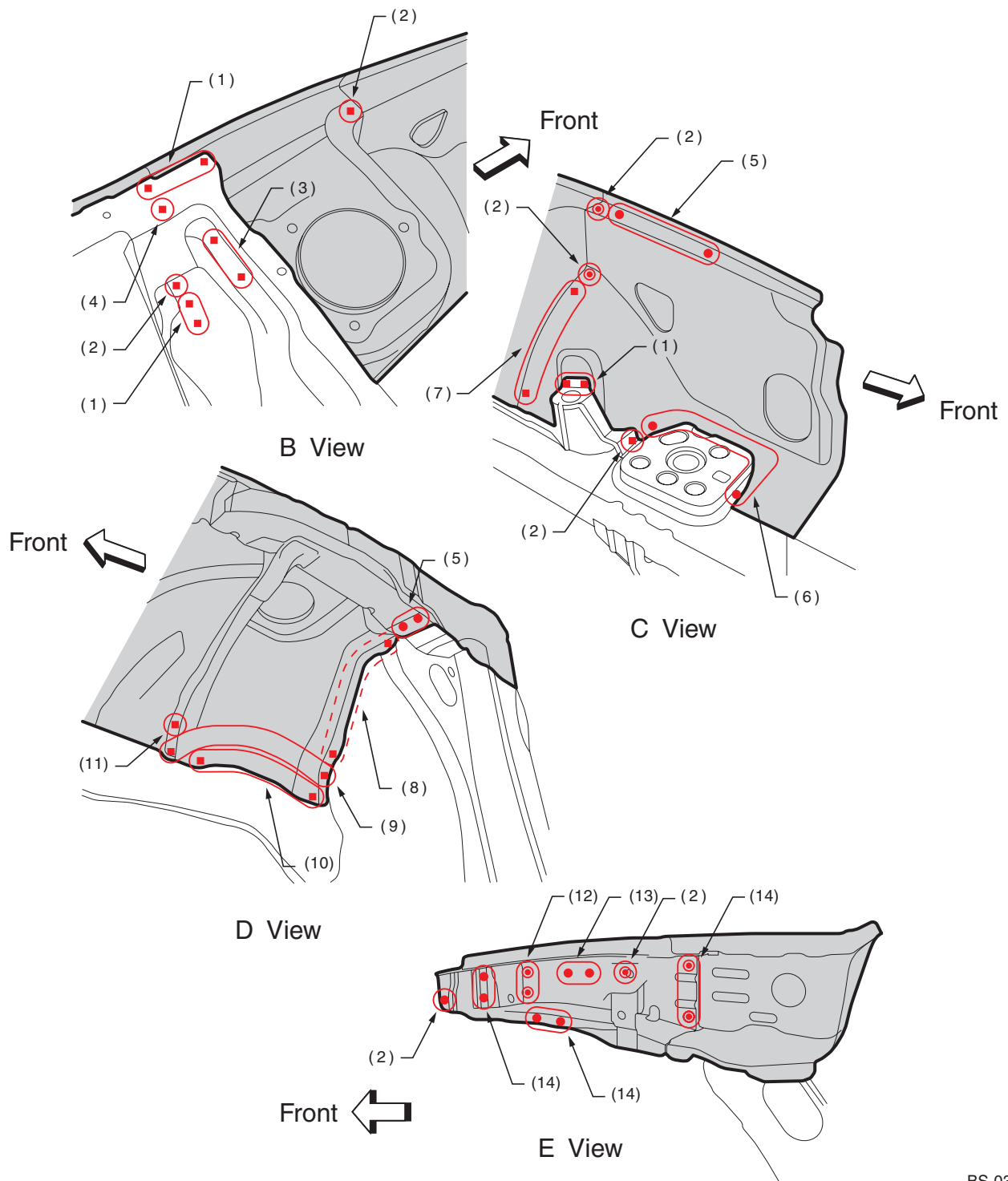
BS-03001

- | | | |
|------------------------------------|------------------------|------------------------------------|
| (1) 1 point (40 mm (1.57 in) × 1) | (6) 1 point (service) | (11) 1 point |
| (2) 2 points (20 mm (0.79 in) × 2) | (7) 2 points (service) | (12) 7 points |
| (3) 1 point | (8) 5 points | (13) 1 point (15 mm (0.59 in) × 1) |
| (4) 2 points (service - matching) | (9) 6 points | (14) 5 points |
| (5) 4 points (service) | (10) 2 points | (15) 8 points |

NOTE:

The illustration shows the radiator panel removed condition.

Front Wheel Apron (total replacement)



BS-03002

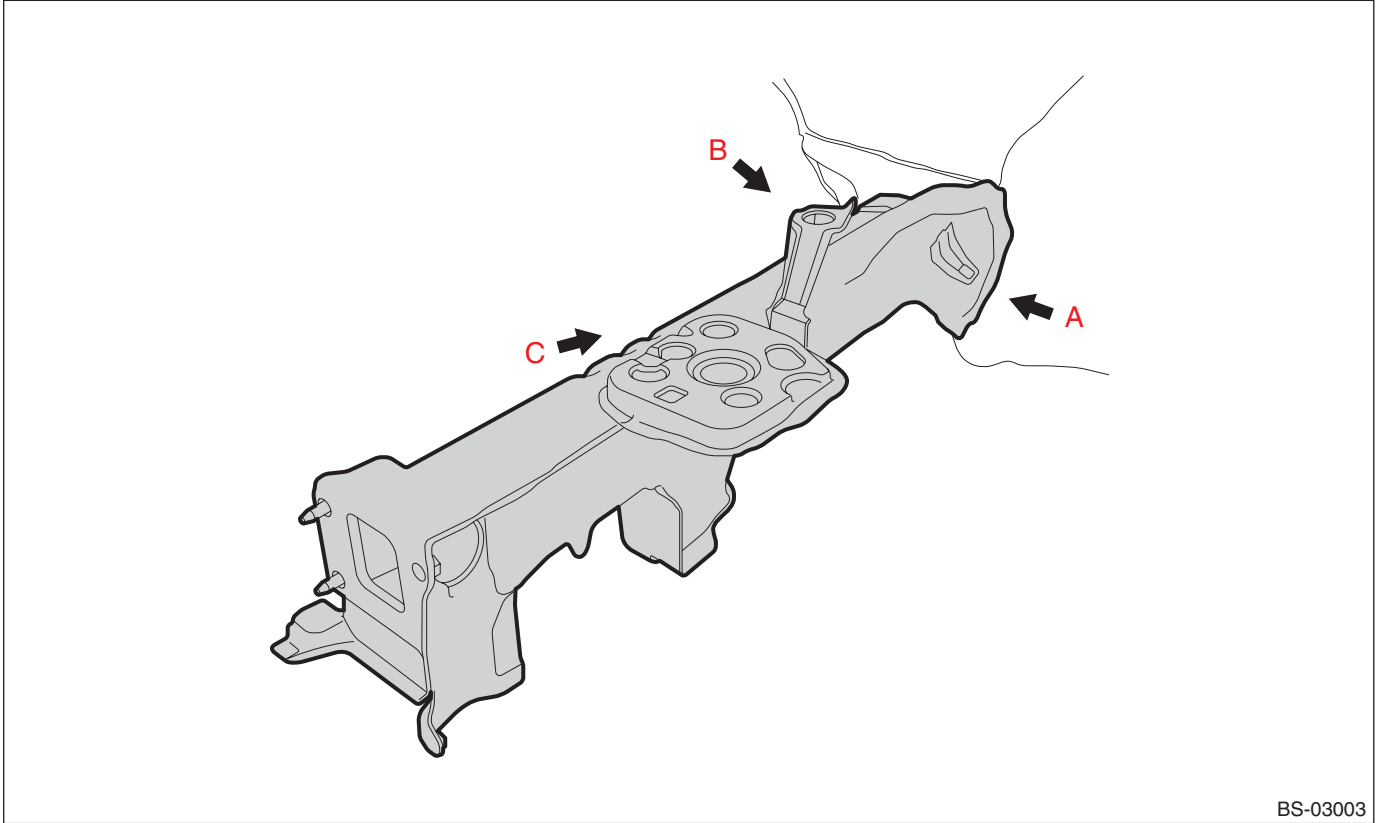
- | | | |
|-----------------------------------|-------------------------|------------------------|
| (1) 2 points | (6) 8 points | (11) 1 point (service) |
| (2) 1 point | (7) 5 points (service) | (12) 3 points |
| (3) 2 points (service · matching) | (8) 10 points (service) | (13) 4 points |
| (4) 1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

NOTE:

View E shows the condition before the side frame upper installed.

14.Front Side Frame Front (total replacement)

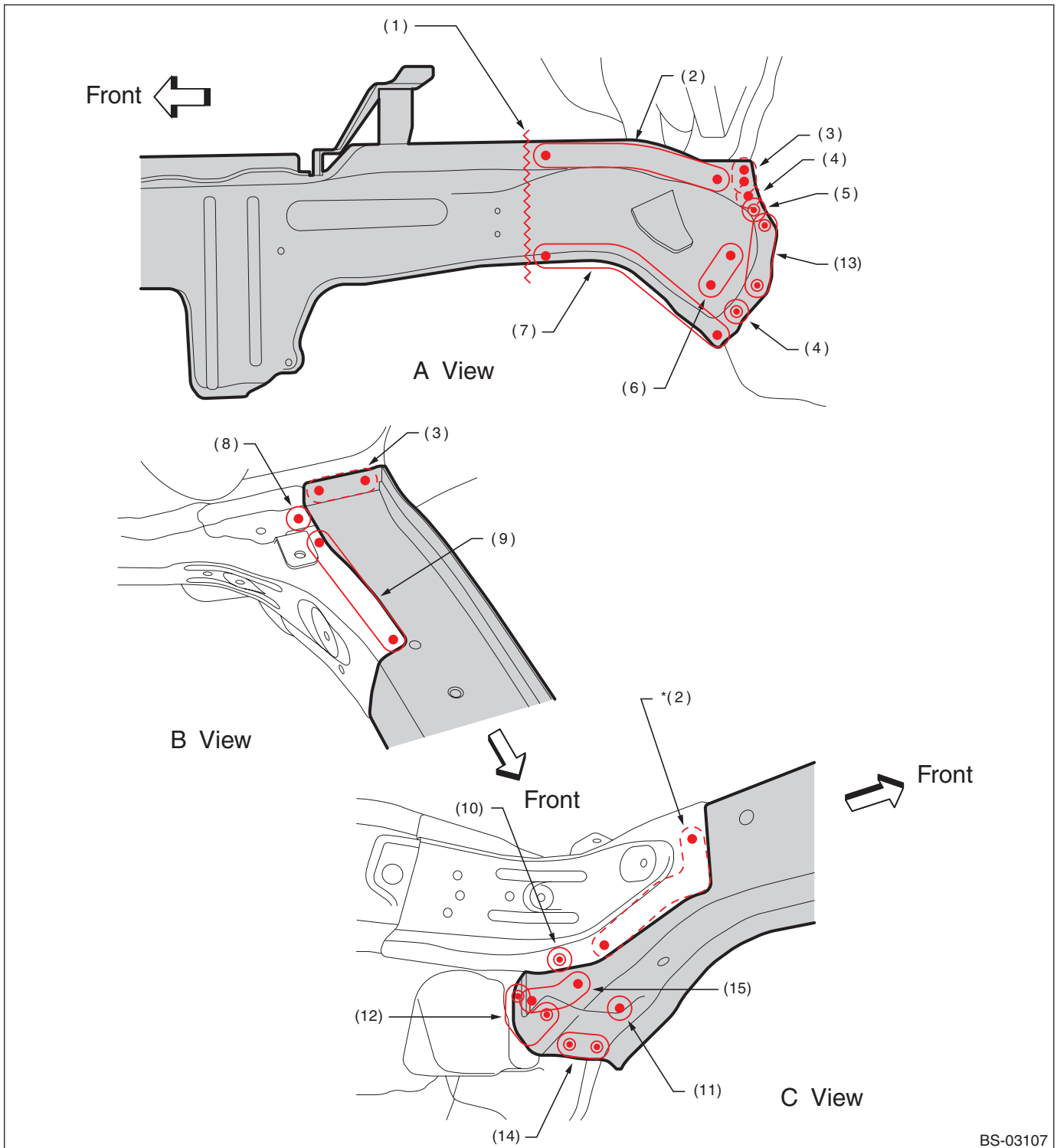
A: REMOVAL



NOTE:

The illustration shows the radiator panel and the front wheel apron removed condition.

Front Side Frame Front (total replacement)



BS-03107

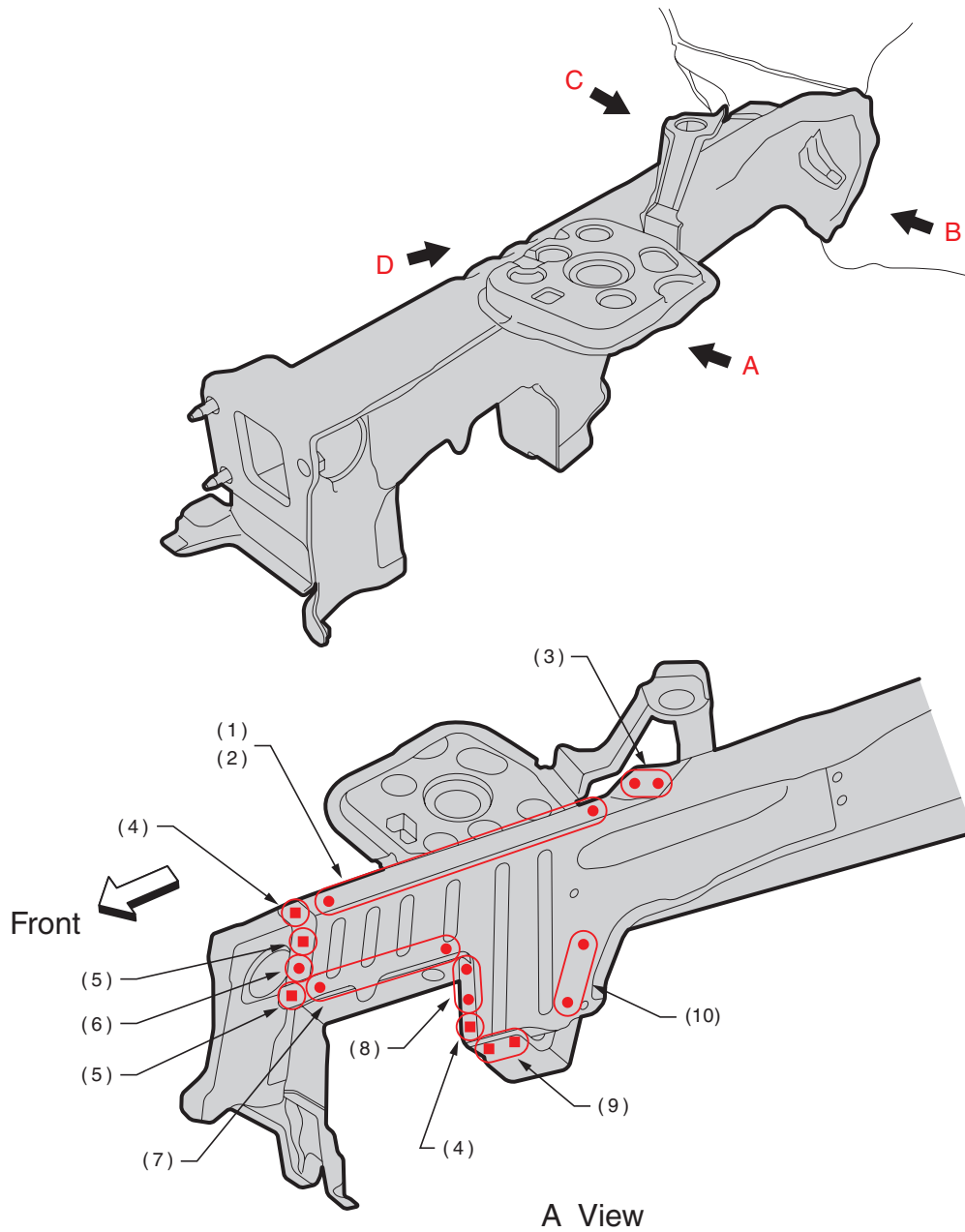
- | | | |
|-----------------------------------|----------------------------|-----------------------------|
| (1) Rough cutting (closing plate) | (6) 2 points (outside · 1) | (11) 1 point (bottom · 1) |
| (2) 5 points (outside · 1) | (7) 9 points (outside · 1) | (12) 4 points (inside · 1) |
| (3) 2 points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

NOTE:

Detach * portion after rough cutting of the closing plate.

Front Side Frame Front (total replacement)

B: INSTALLATION



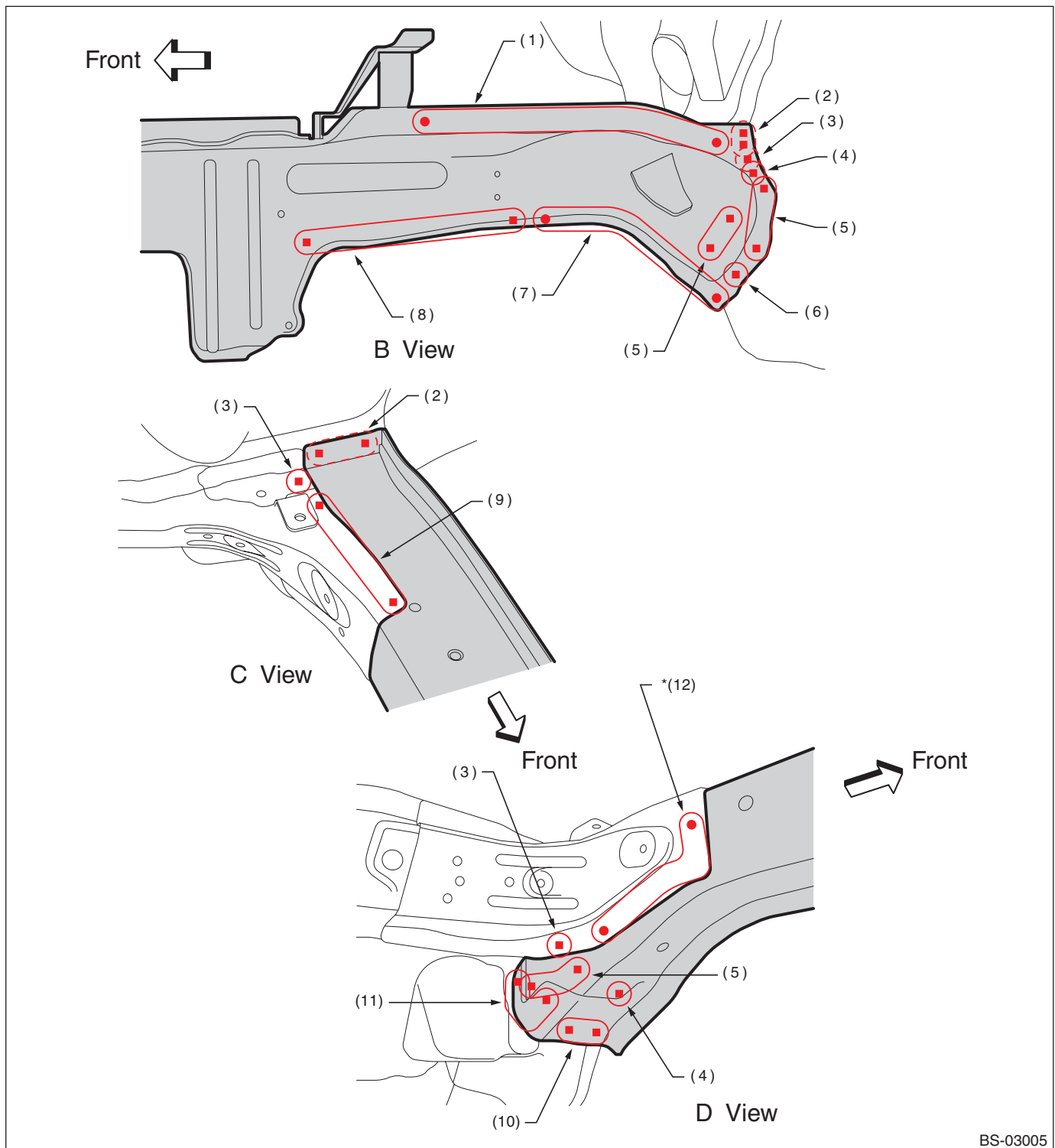
BS-03004

- | | | |
|---|----------------------------------|--|
| (1) 6 points (left side) | (5) 1 point (service · matching) | (8) 3 points |
| (2) 8 points (right side) | (6) 1 point | (9) 2 points (service · both surface plug) |
| (3) 2 points | (7) 5 points | (10) 4 points |
| (4) 1 point (service · both surface plug) | | |

NOTE:

The illustration shows the radiator panel and the front wheel apron removed condition.

Front Side Frame Front (total replacement)



BS-03005

- | | | |
|-----------------------|---|------------------------------------|
| (1) 8 points | (5) 3 points (service) | (9) 3 points |
| (2) 2 points | (6) 1 point (service) | (10) 2 points (service · matching) |
| (3) 1 point | (7) 11 points | (11) 4 points (service · matching) |
| (4) 1 point (service) | (8) 10 points (service · both surface plug) | (12) 7 points |

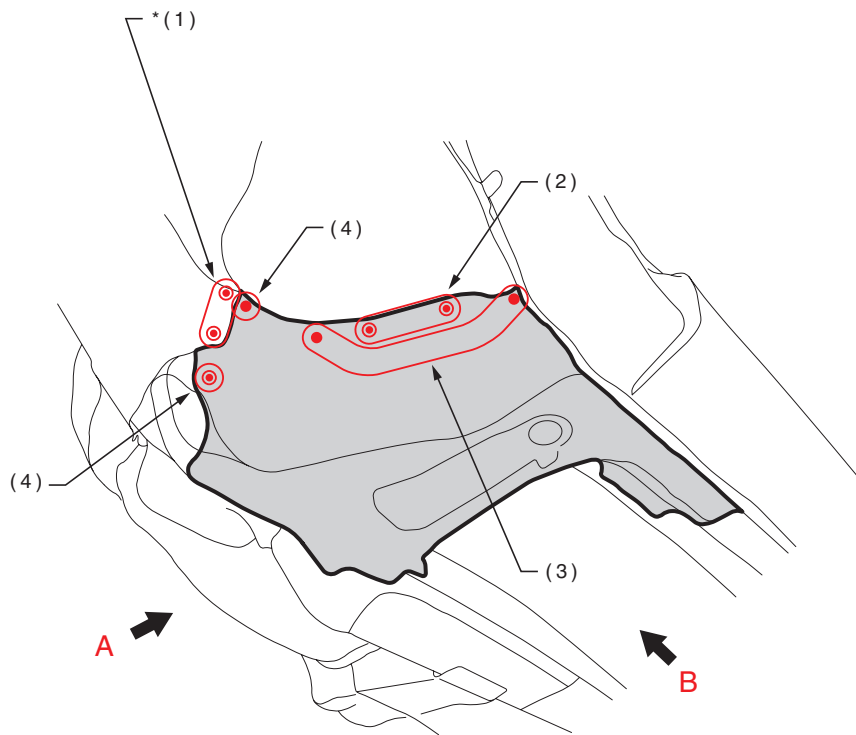
NOTE:

*: Before welding of the closing plate, spot welding should be done.

Toe Board Lower Reinforcement (total replacement)

15. Toe Board Lower Reinforcement (total replacement)

A: REMOVAL



BS-03006

(1) 3 points (outside · 2)
(2) 3 points (outside · 1)

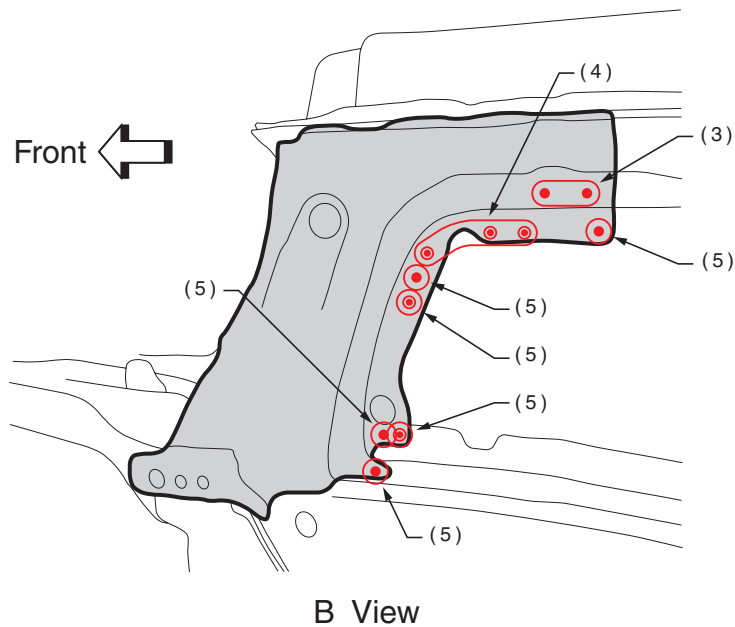
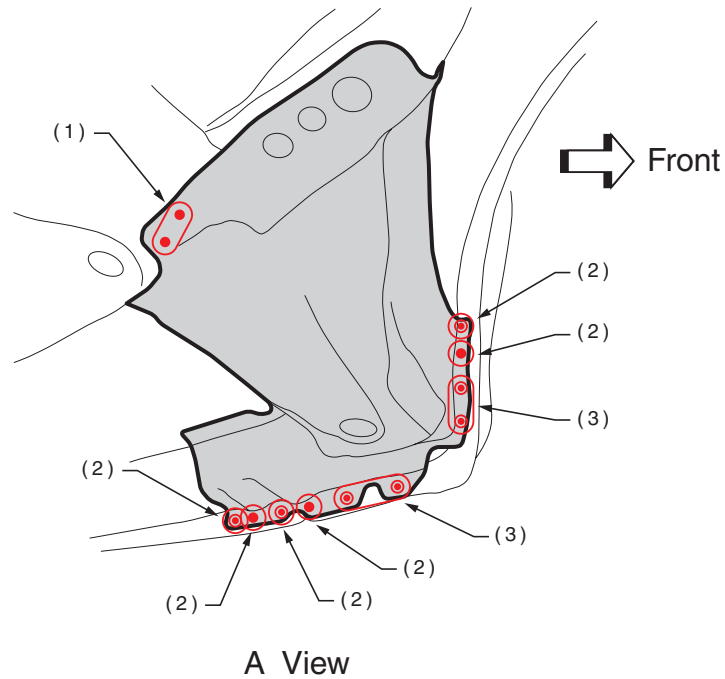
(3) 4 points (outside · 1)

(4) 1 point (outside · 1)

NOTE:

Peel off the closing plate for * portion.

Toe Board Lower Reinforcement (total replacement)



BS-03007

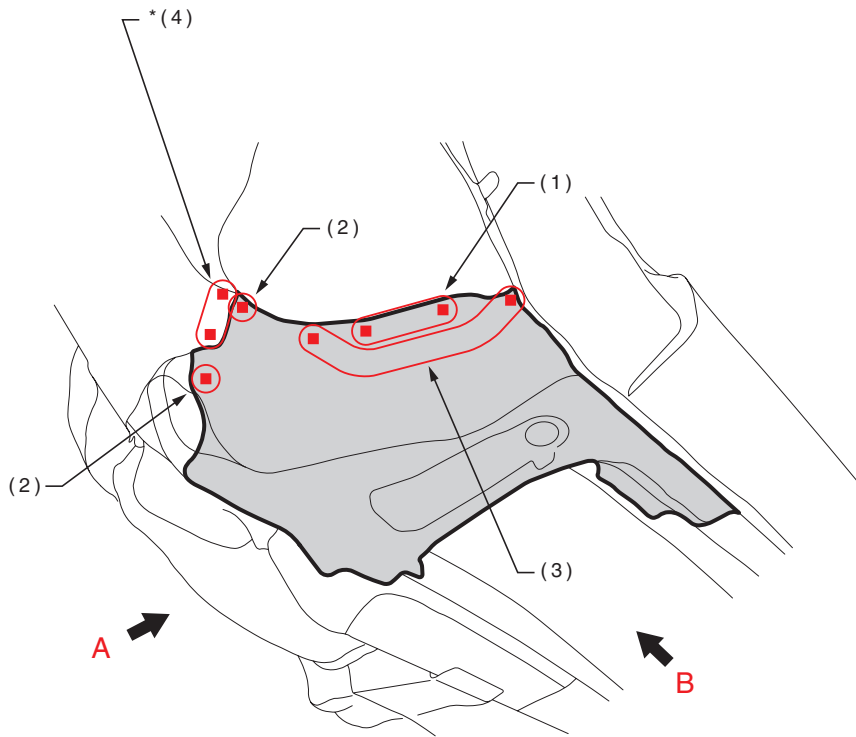
(1) 2 points (bottom · 1)
(2) 1 point (inside · 1)

(3) 2 points (inside · 1)
(4) 3 points (bottom · 1)

(5) 1 point (bottom · 1)

Toe Board Lower Reinforcement (total replacement)

B: INSTALLATION



BS-03108

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

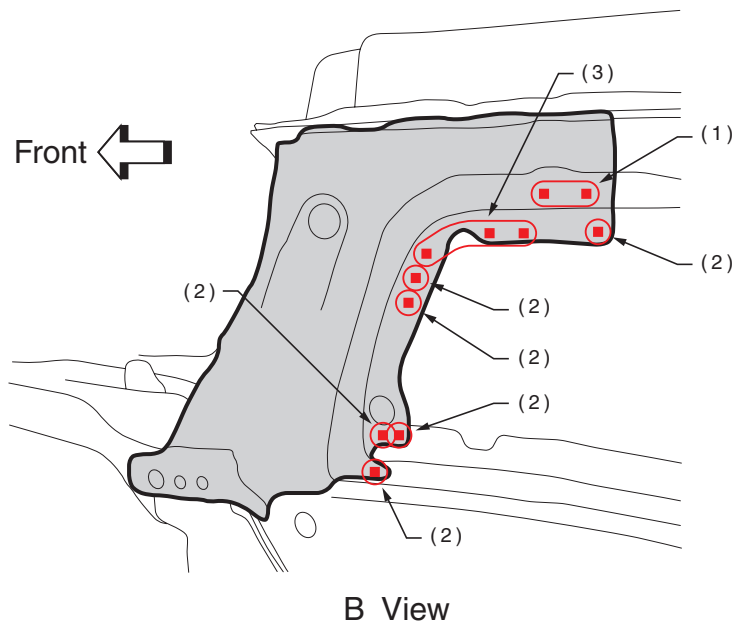
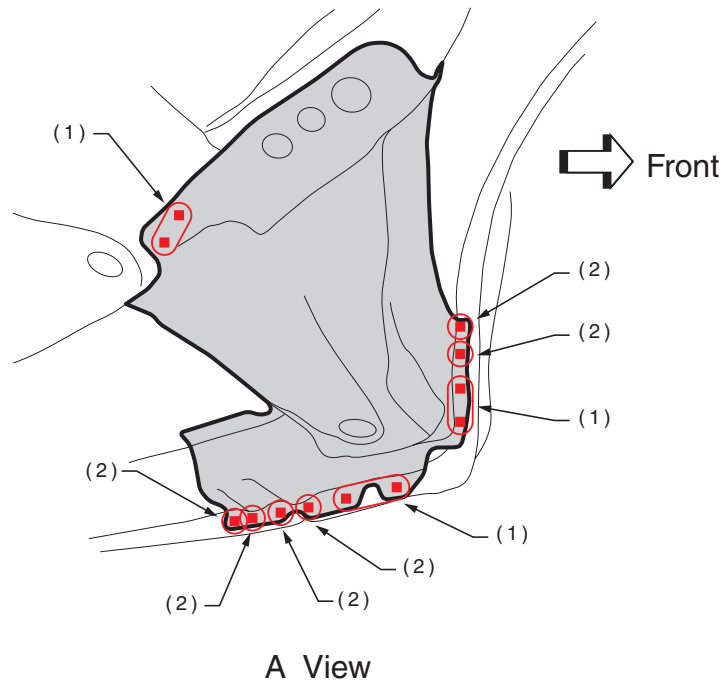
(3) 4 points (service)

(4) 3 points (service · matching)

NOTE:

Put * portion under the closing plate.

Toe Board Lower Reinforcement (total replacement)



BS-03009

(1) 2 points (service)

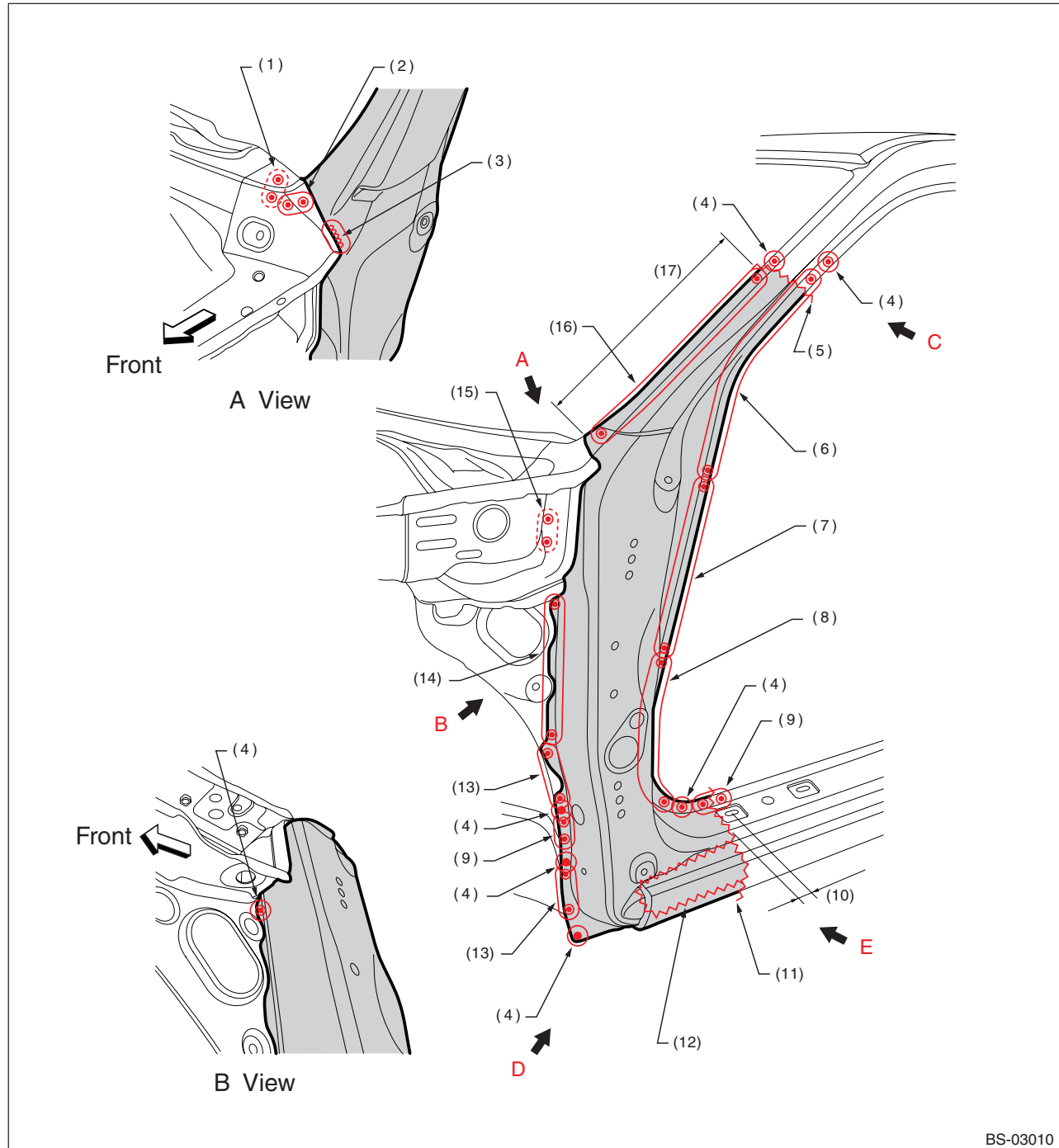
(2) 1 point (service)

(3) 3 points (service)

Front Pillar Outer (partial replacement)

16. Front Pillar Outer (partial replacement)

A: REMOVAL



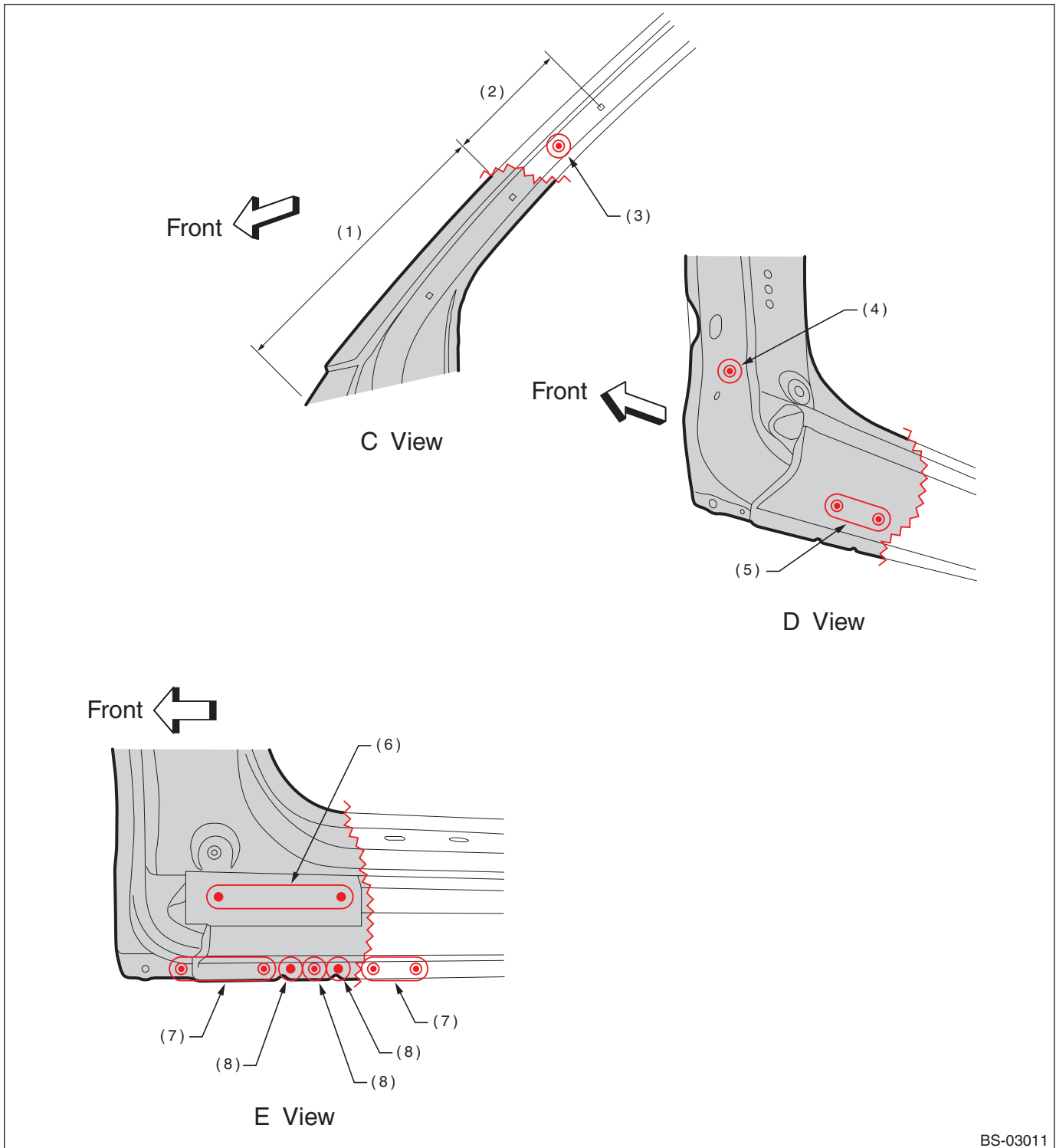
Front Pillar Outer (partial replacement)

- | | | |
|---|--|------------------------------|
| (1) 2 points (bottom · 1) | (7) 7 points (outside · 2) | (13) 3 points (outside · 1) |
| (2) 2 points (top · 2) | (8) 7 points (outside · 1) | (14) 4 points (outside · 1) |
| (3) 1 point (top · 1, belt sander) | (9) 2 points (outside · 1) | (15) 2 points (inside · 2) |
| (4) 1 point (outside · 1) | (10) 30 mm (1.18 in) | (16) 10 points (outside · 2) |
| (5) Rough cutting (outer panel reinforcement) | (11) Rough cutting (outer panel) | (17) 410 mm (16.14 in) |
| (6) 11 points (outside · 2) | (12) Rough cutting (outer panel work openings) | |

NOTE:

The illustration shows the side upper frame removed condition.

Front Pillar Outer (partial replacement)



BS-03011

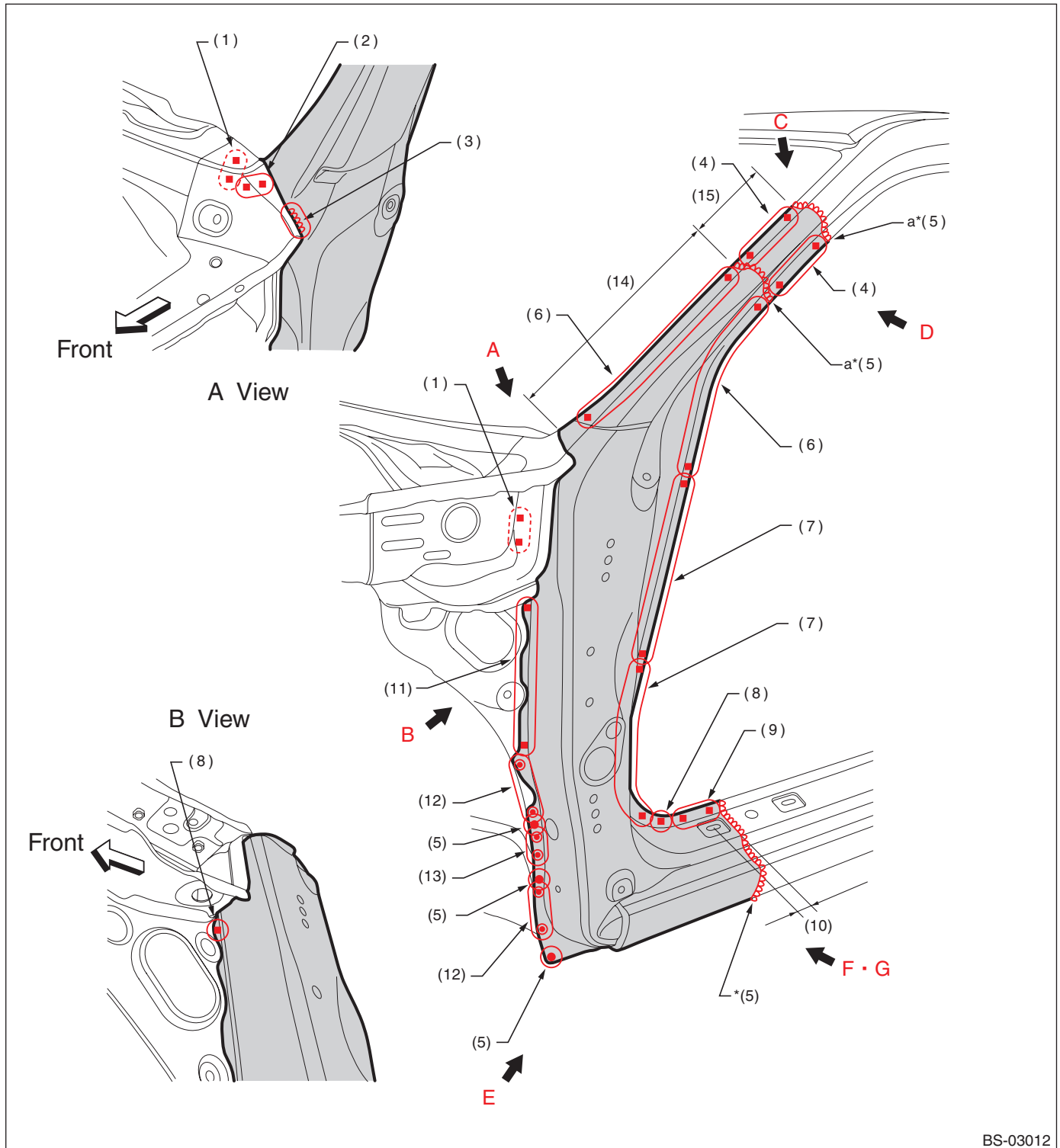
- | | | |
|---------------------------|--|----------------------------|
| (1) 410 mm (16.14 in) | (5) 2 points (bottom · 2) | (7) 3 points (outside · 1) |
| (2) 120 mm (4.72 in) | (6) 3 points (outside · 1), hidden hit point | (8) 1 point (outside · 1) |
| (3) 1 point (outside · 1) | | |
| (4) 1 point (outside · 2) | | |

NOTE:

View E shows the opened condition of the work openings.

Front Pillar Outer (partial replacement)

B: INSTALLATION



BS-03012

Front Pillar Outer (partial replacement)

- | | | |
|--------------------------------------|--------------------------------------|-------------------------|
| (1) 2 points (service) | (6) 9 points (service · both surface | (10) 30 mm (1.18 in) |
| (2) 2 points (service · matching) | plug) | (11) 4 points (service) |
| (3) 1 point (20 mm (0.79 in) × 1) | (7) 7 points (service · both surface | (12) 3 points |
| (4) 3 points (service · both surface | plug) | (13) 2 points |
| plug) | (8) 1 point (service) | (14) 390 mm (15.35 in) |
| (5) 1 point | (9) 3 points (service) | (15) 120 mm (4.72 in) |

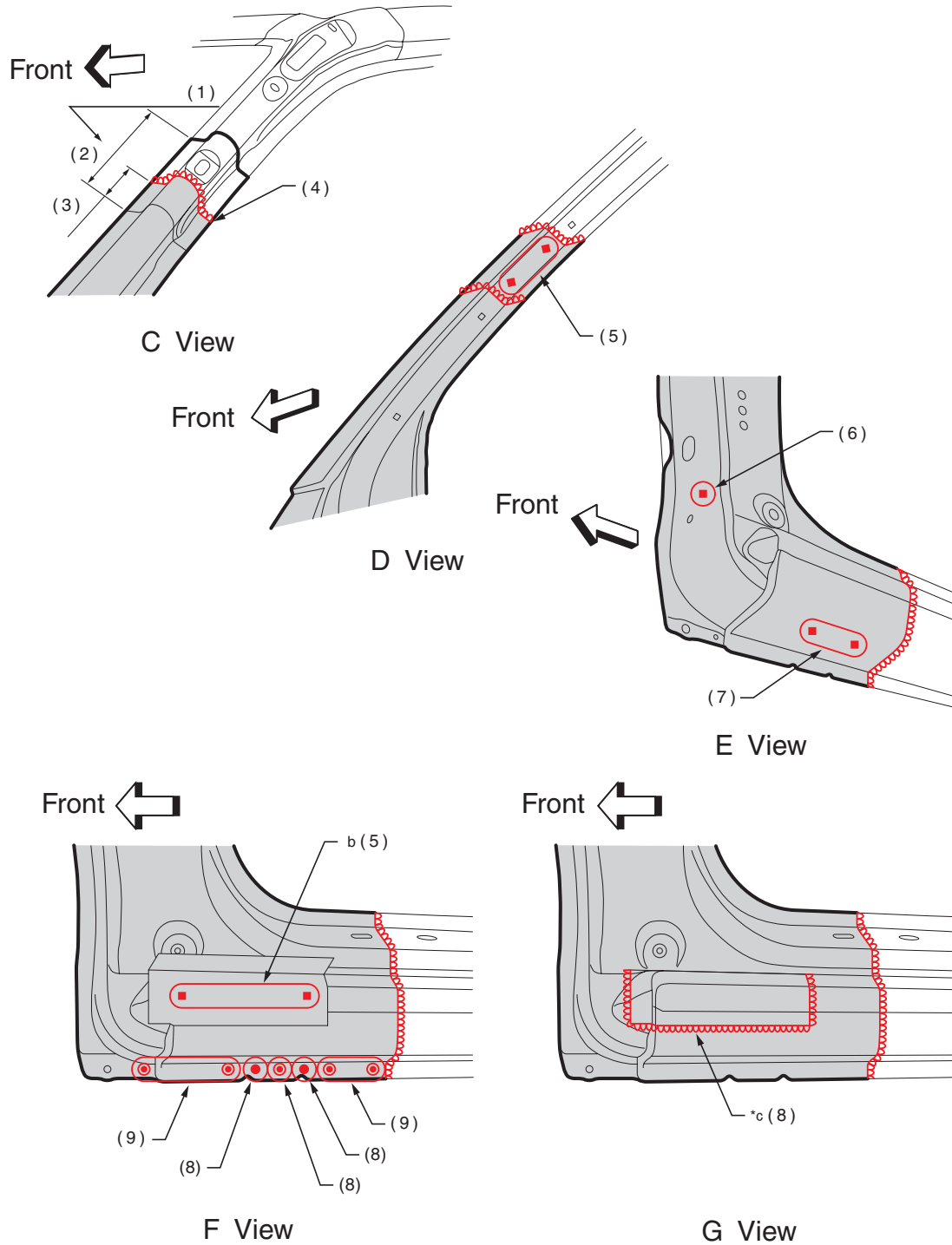
CAUTION:

- For continuous welds marked by *, apply anticorrosion wax thoroughly on the reverse side.
- Butt weld the reinforcement at portion “a” (at two locations).

NOTE:

The illustration shows the side upper frame removed condition.

Front Pillar Outer (partial replacement)



BS-03013

Front Pillar Outer (partial replacement)

- | | | |
|-------------------------|----------------------------------|------------------------|
| (1) Outer panel removal | (4) 1 point (butt reinforcement) | (7) 2 points (service) |
| (2) 120 mm (4.72 in) | (5) 3 points (service) | (8) 1 point |
| (3) 50 mm (1.97 in) | (6) 1 point (service) | (9) 3 points |

CAUTION:

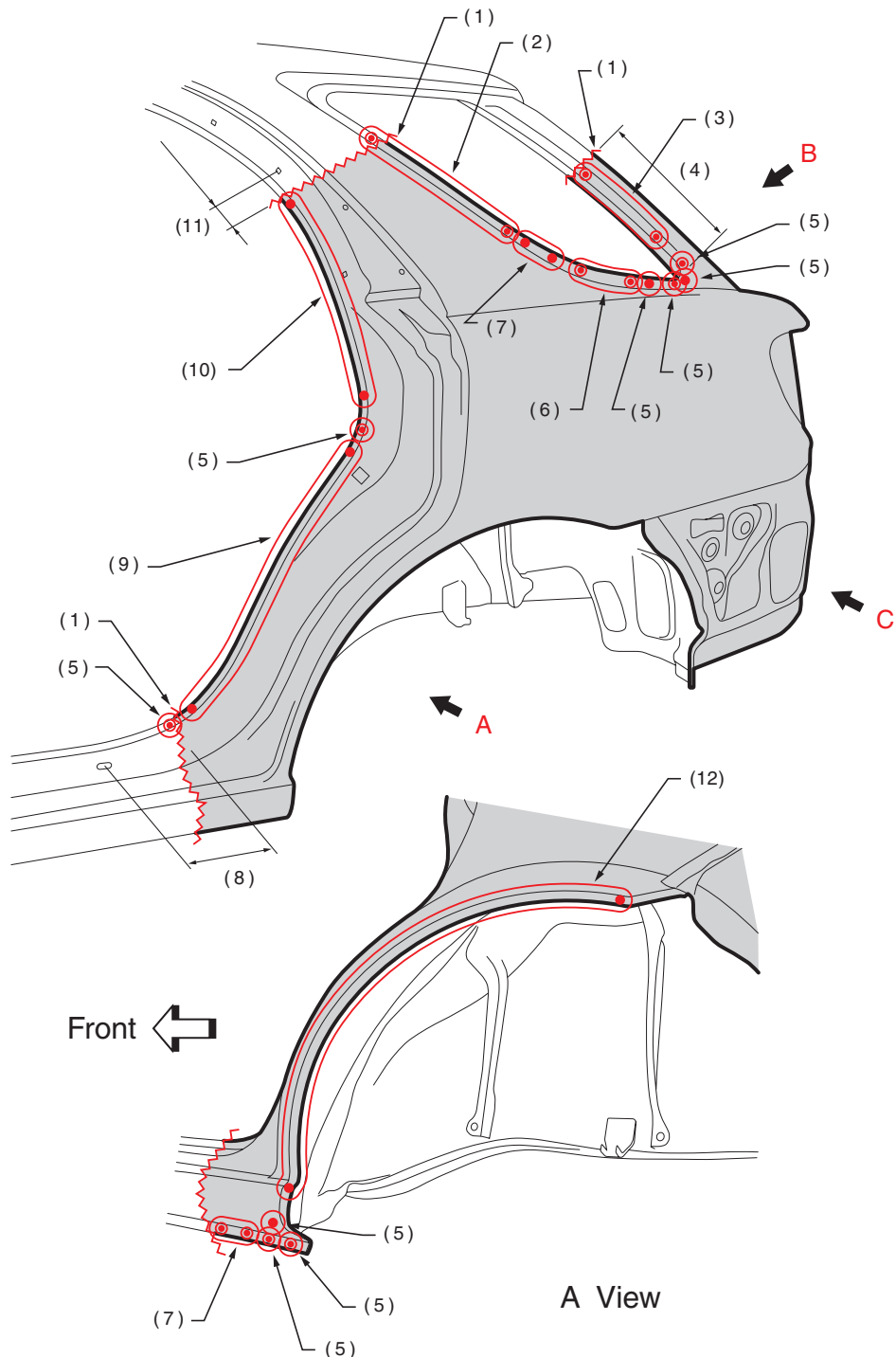
For continuous welds marked by *, apply anticorrosion wax thoroughly on the reverse side.

NOTE:

- b: Perform the operation after opening the work openings.
- c: Close the work openings after welding portion “b”.

17.Rear Quarter (partial replacement) / Wagon

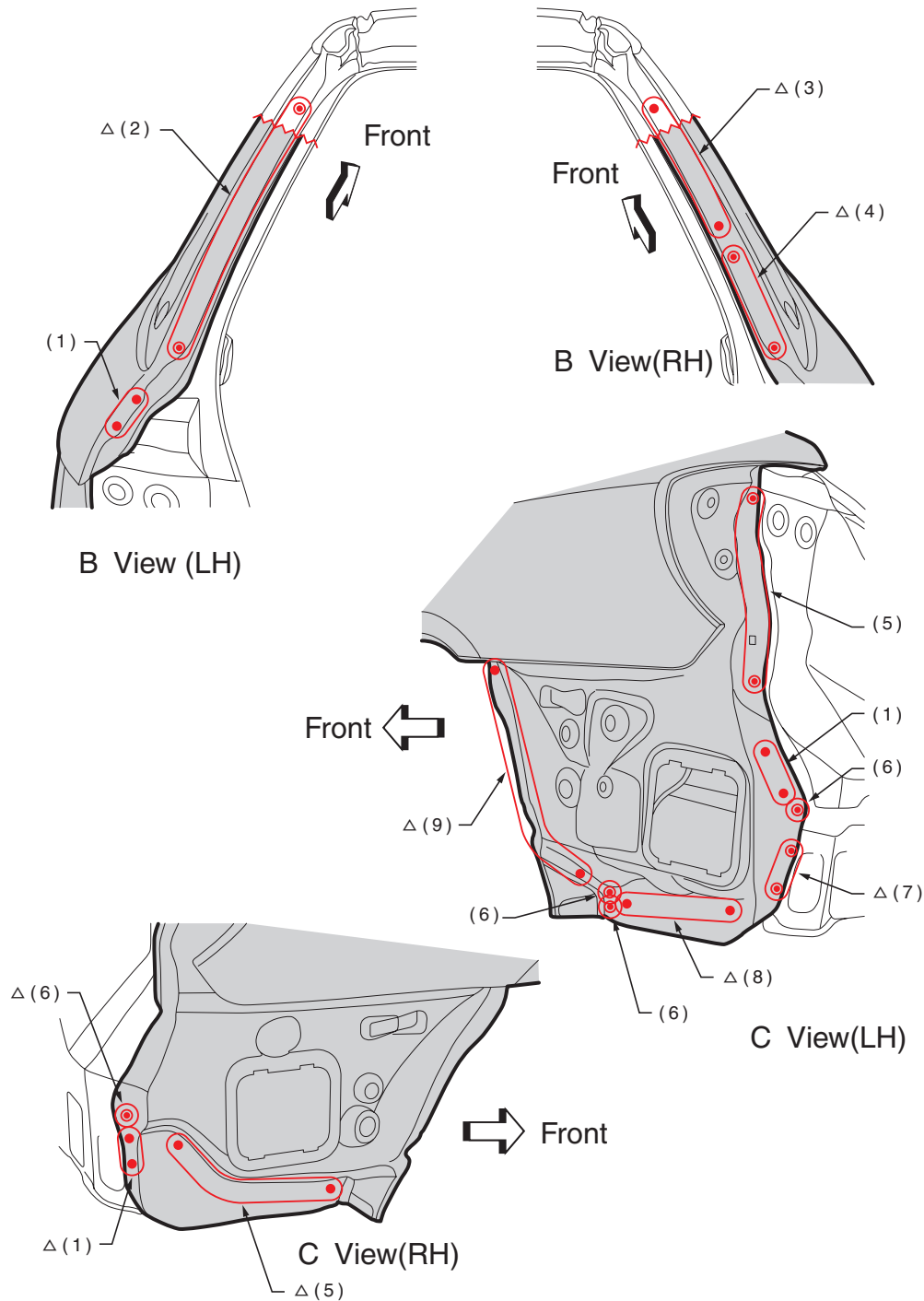
A: REMOVAL



BS-03022

- | | | |
|----------------------------|----------------------------|-----------------------------|
| (1) Rough cutting | (5) 1 point (outside · 1) | (9) 11 points (outside · 1) |
| (2) 9 points (outside · 1) | (6) 3 points (outside · 1) | (10) 8 points (outside · 1) |
| (3) 5 points (outside · 1) | (7) 2 points (outside · 1) | (11) 60 mm (2.36 in) |
| (4) 250 mm (9.84 in) | (8) 120 mm (4.72 in) | (12) 14 points (bottom · 1) |

Rear Quarter (partial replacement) / Wagon



BS-03023

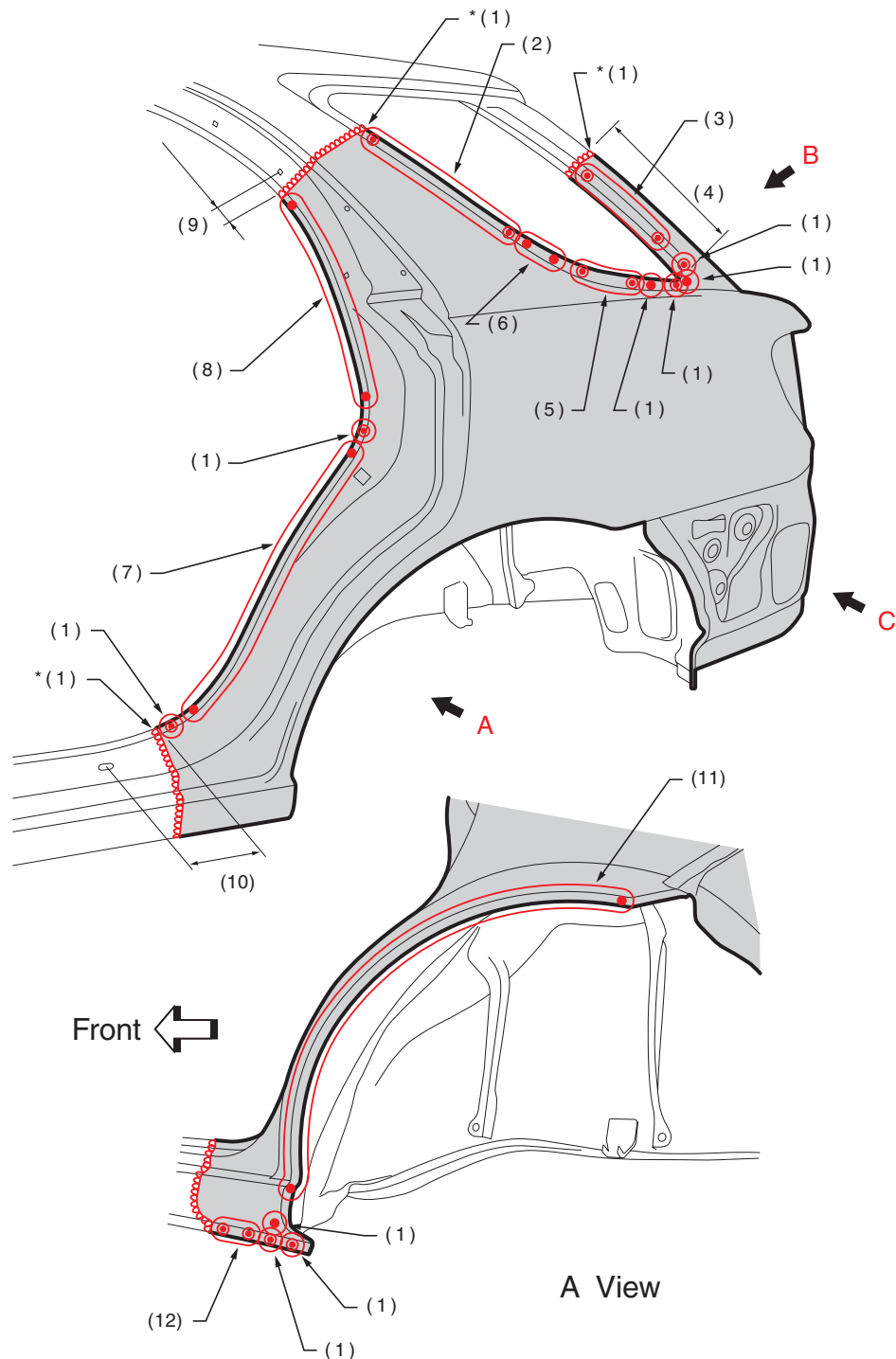
- | | | |
|----------------------------|----------------------------|----------------------------|
| (1) 2 points (outside · 1) | (4) 4 points (outside · 1) | (7) 3 points (outside · 1) |
| (2) 9 points (outside · 1) | (5) 6 points (outside · 1) | (8) 5 points (outside · 1) |
| (3) 5 points (outside · 1) | (6) 1 point (outside · 1) | (9) 8 points (outside · 1) |

NOTE:

For locations marked by Δ, the welding method is different from the left and the right of the body.

Rear Quarter (partial replacement) / Wagon

B: INSTALLATION



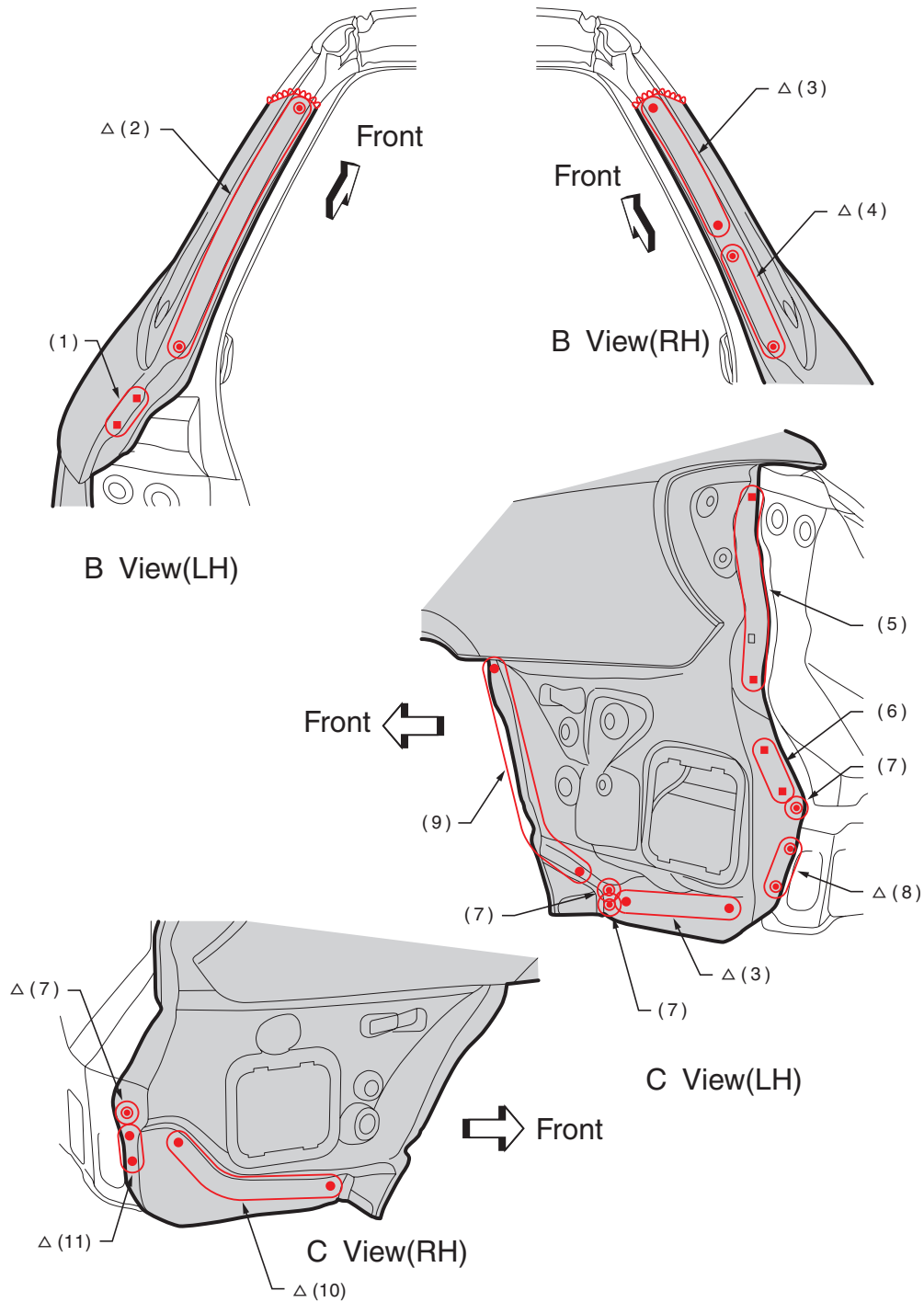
BS-03024

- | | | |
|-----------------------|---------------|-----------------------|
| (1) 1 point | (5) 4 points | (9) 30 mm (1.18 in) |
| (2) 11 points | (6) 2 points | (10) 100 mm (3.94 in) |
| (3) 6 points | (7) 14 points | (11) 17 points |
| (4) 280 mm (11.02 in) | (8) 10 points | (12) 3 points |

CAUTION:

For continuous welds marked by *, apply anticorrosion wax thoroughly on the reverse side.

Rear Quarter (partial replacement) / Wagon



BS-03025

(1) 2 points (service)

(2) 11 points

(3) 6 points

(4) 5 points

(5) 8 points

(6) 2 points

(7) 1 point

(8) 4 points

(9) 10 points

(10) 7 points

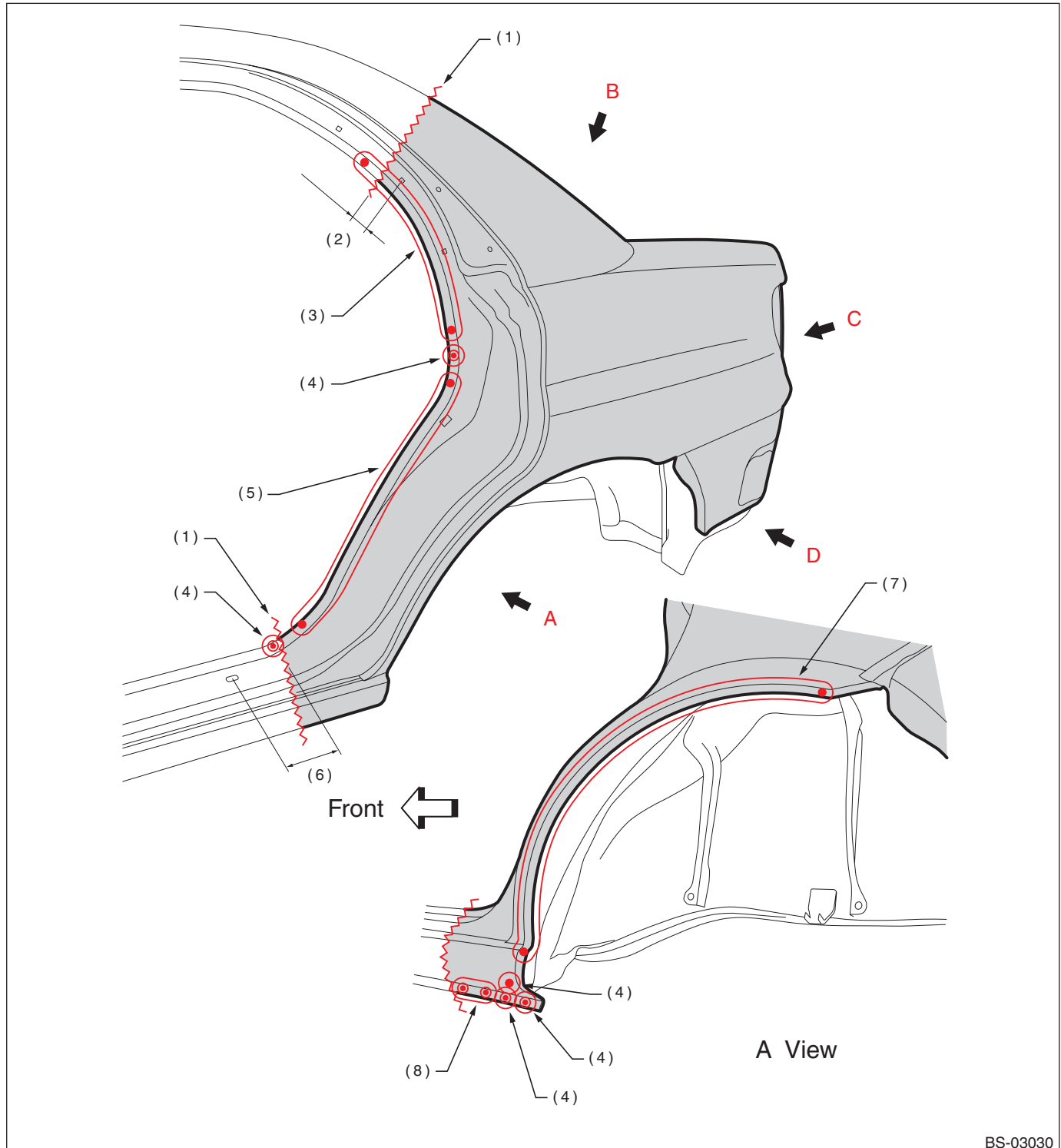
(11) 3 points

NOTE:

For locations marked by Δ , the welding is different from the left and the right of the body.

18.Rear Quarter (partial replacement) / Sedan

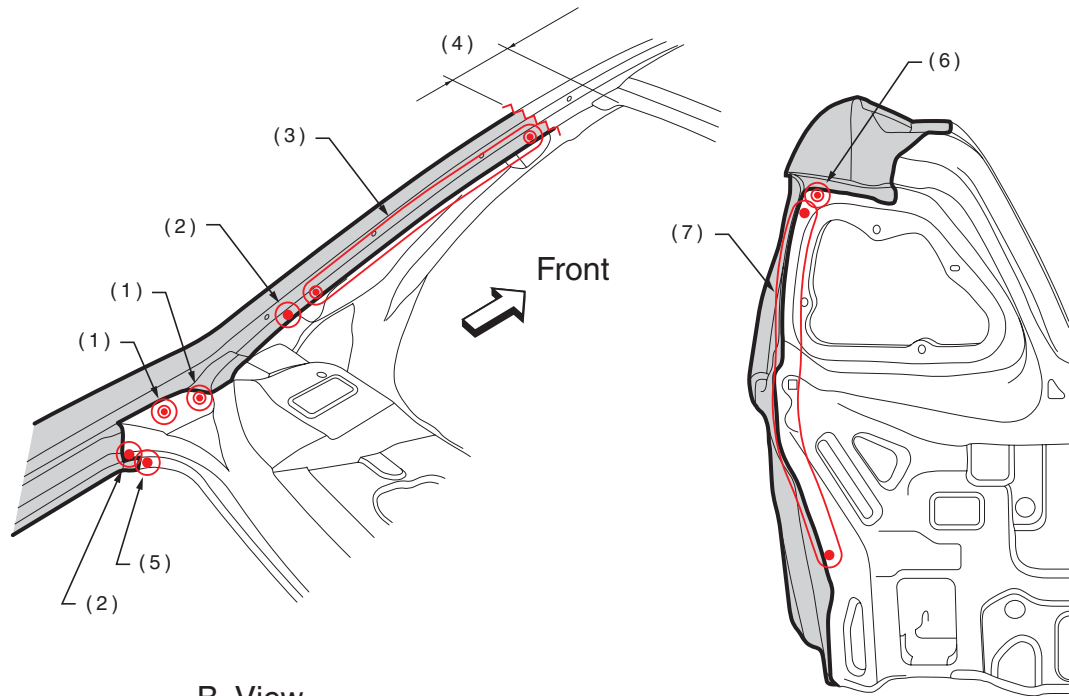
A: REMOVAL



BS-03030

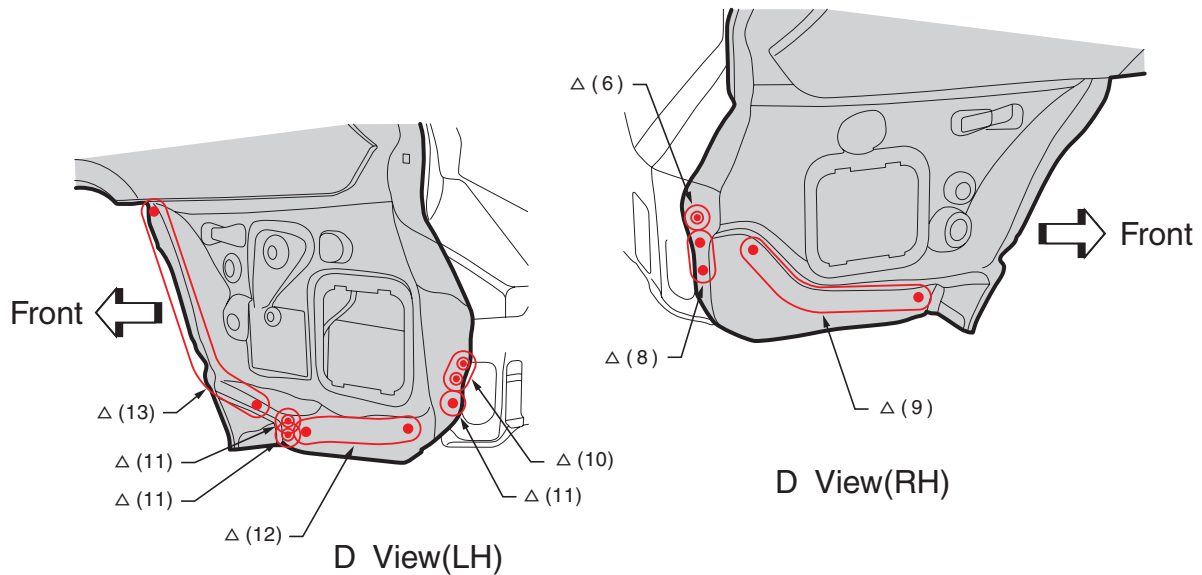
- | | | |
|----------------------------|-----------------------------|----------------------------|
| (1) Rough cutting | (4) 1 point (outside · 1) | (7) 14 points (bottom · 1) |
| (2) 10 mm (0.39 in) | (5) 11 points (outside · 1) | (8) 2 points (outside · 1) |
| (3) 9 points (outside · 1) | (6) 120 mm (4.72 in) | |

Rear Quarter (partial replacement) / Sedan



B View

C View



D View(LH)

D View(RH)

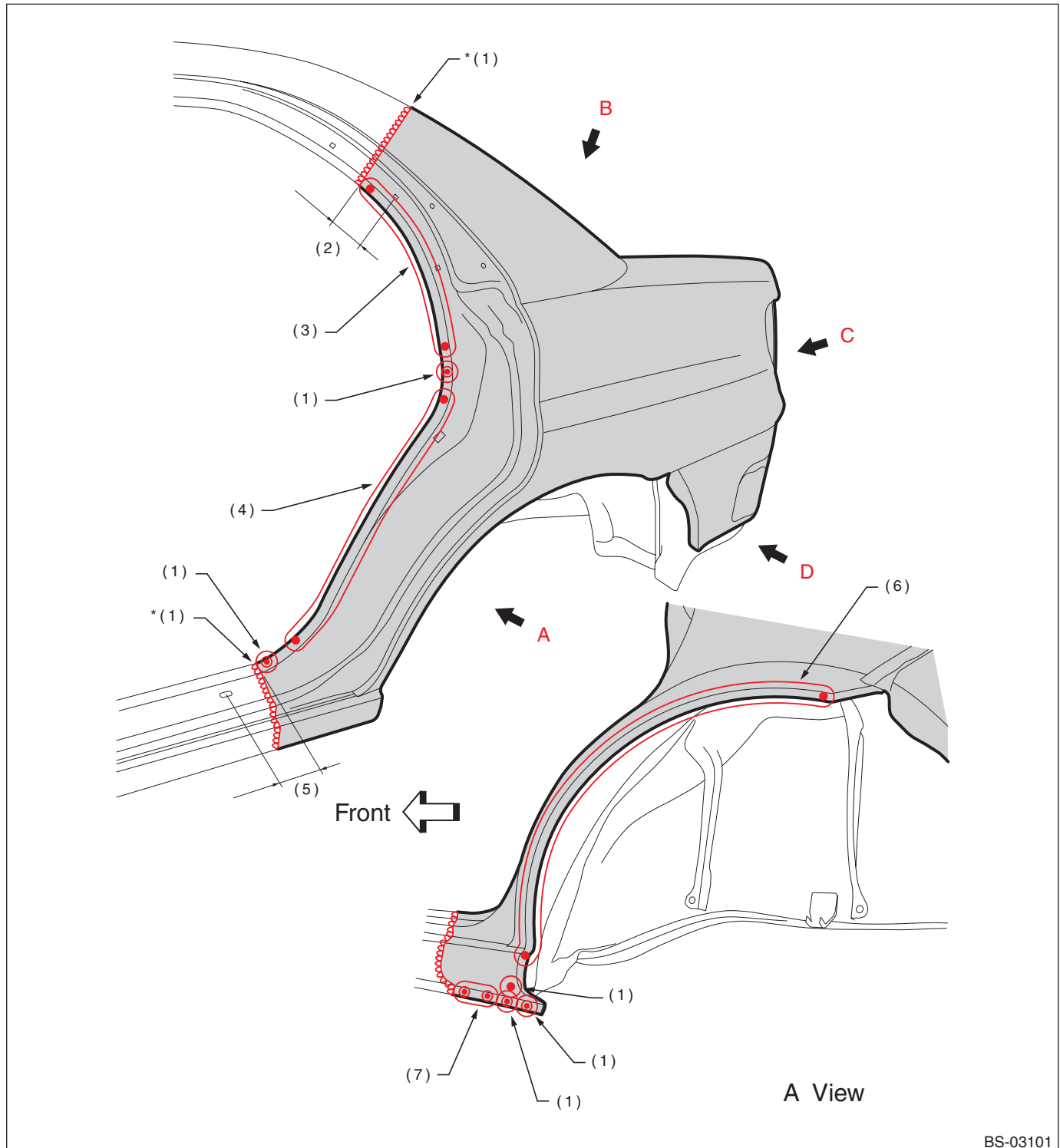
BS-03031

- | | | |
|----------------------------------|-----------------------------|-----------------------------|
| (1) 1 point (top · 2) | (6) 1 point (outside · 2) | (11) 1 point (outside · 1) |
| (2) 1 point (top · 1) | (7) 9 points (outside · 1) | (12) 5 points (outside · 1) |
| (3) 7 points (top · 1) | (8) 3 points (outside · 1) | (13) 8 points (outside · 1) |
| (4) 110 mm (4.33 in) (reference) | (9) 6 points (outside · 1) | |
| (5) 1 point (inside · 1) | (10) 2 points (outside · 2) | |

NOTE:

For locations marked by Δ , the welding method is different from the left and the right of the body.

B: INSTALLATION



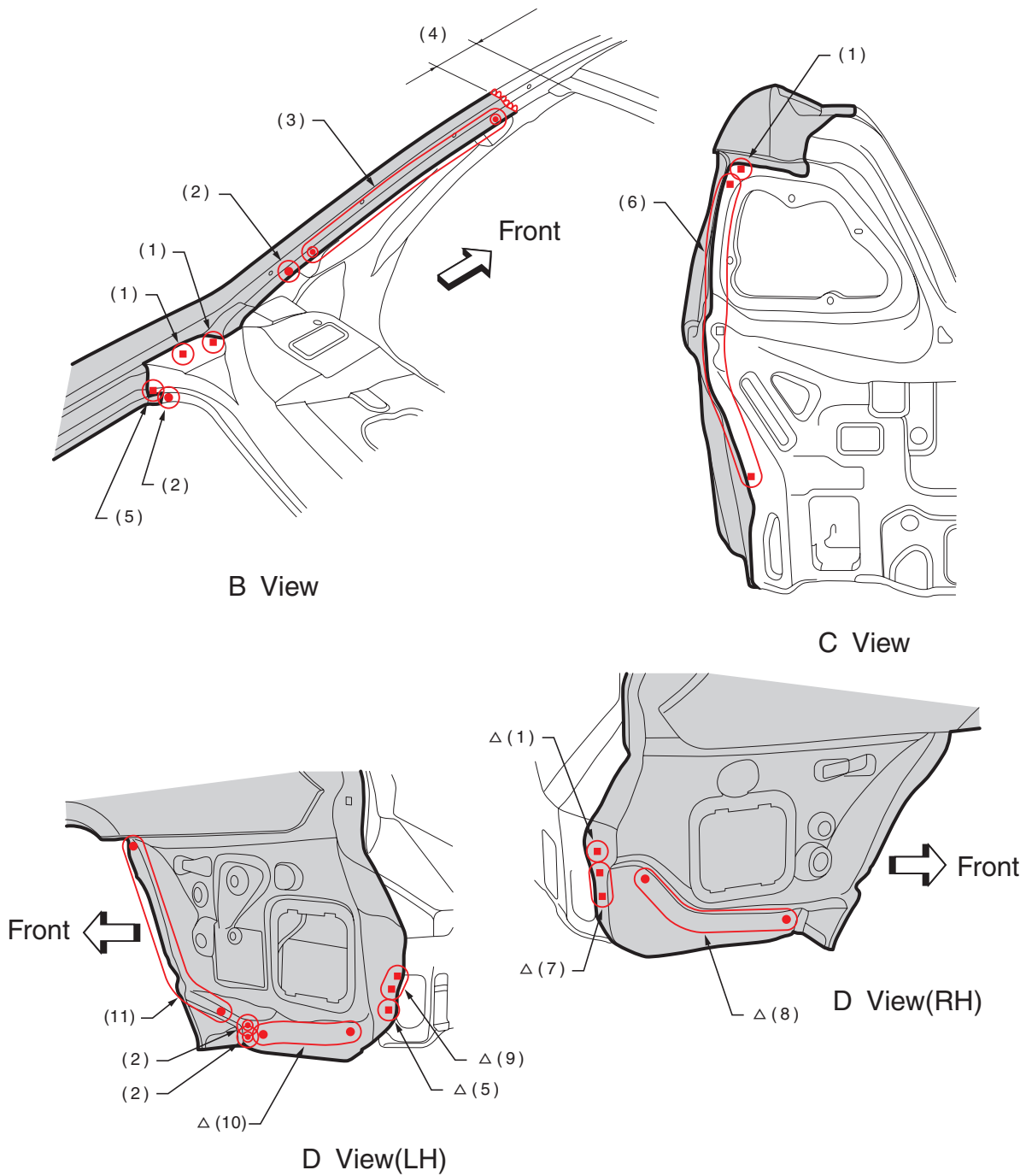
BS-03101

- | | | |
|---------------------|----------------------|--------------|
| (1) 1 point | (4) 14 points | (7) 3 points |
| (2) 30 mm (1.18 in) | (5) 100 mm (3.94 in) | |
| (3) 11 points | (6) 17 points | |

CAUTION:

For continuous welds marked by *, apply anticorrosion wax thoroughly on the reverse side.

Rear Quarter (partial replacement) / Sedan



BS-03032

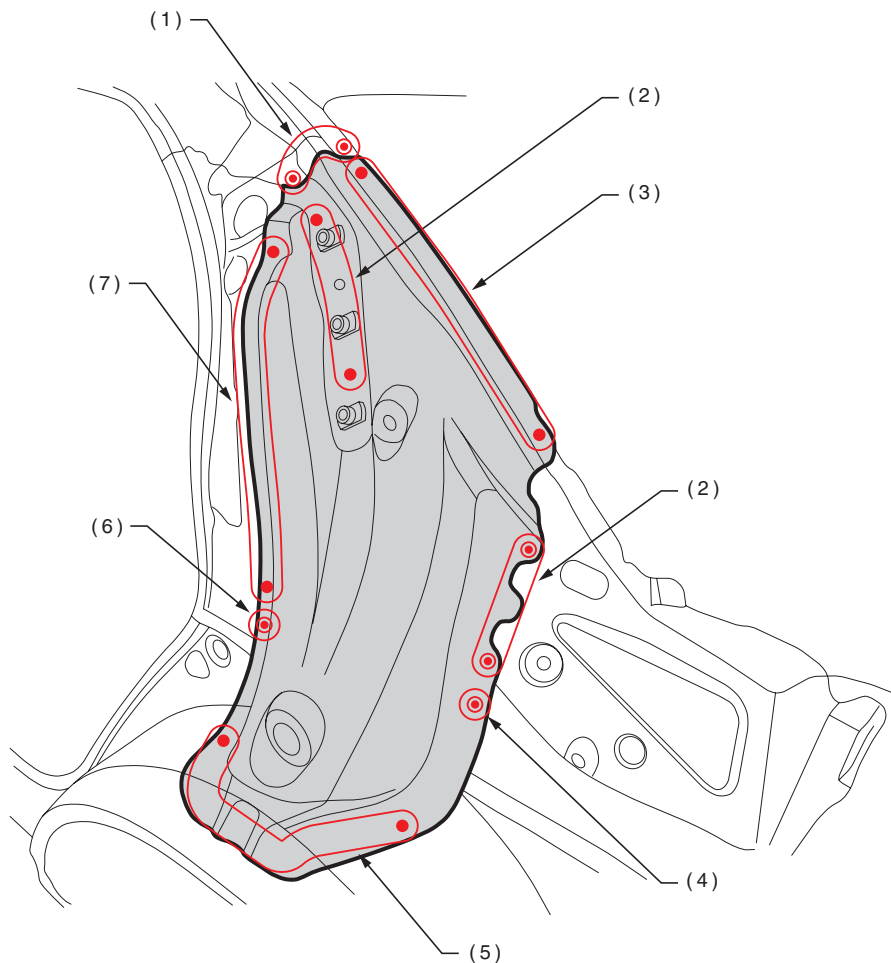
- | | | |
|----------------------------------|------------------------|-----------------------------------|
| (1) 1 point (service · matching) | (5) 1 point (service) | (9) 2 points (service · matching) |
| (2) 1 point | (6) 11 points | (10) 6 points |
| (3) 9 points | (7) 4 points (service) | (11) 10 points |
| (4) 90 mm (3.5 in) (reference) | (8) 7 points | |

NOTE:

For locations marked by Δ , the welding is different from the left and the right of the body.

19.Rear Pillar Reinforcement (total replacement) / Sedan

A: REMOVAL



BS-03033

(1) 2 points (outside · 2)

(2) 3 points (outside · 1)

(3) 7 points (outside · 1)

(4) 1 point (outside · 1)

(5) 8 points (outside · 1)

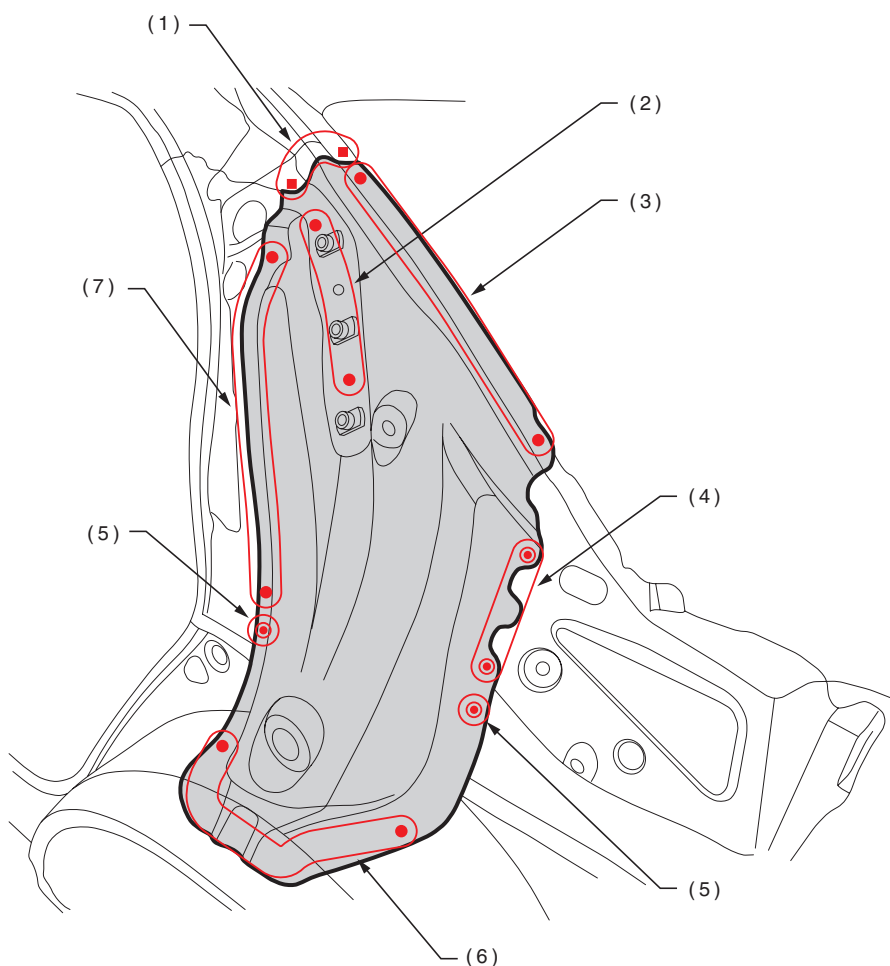
(6) 1 point (outside · 1)

(7) 9 points (outside · 1)

NOTE:

The illustration shows the rear quarter removed condition.

B: INSTALLATION



BS-03034

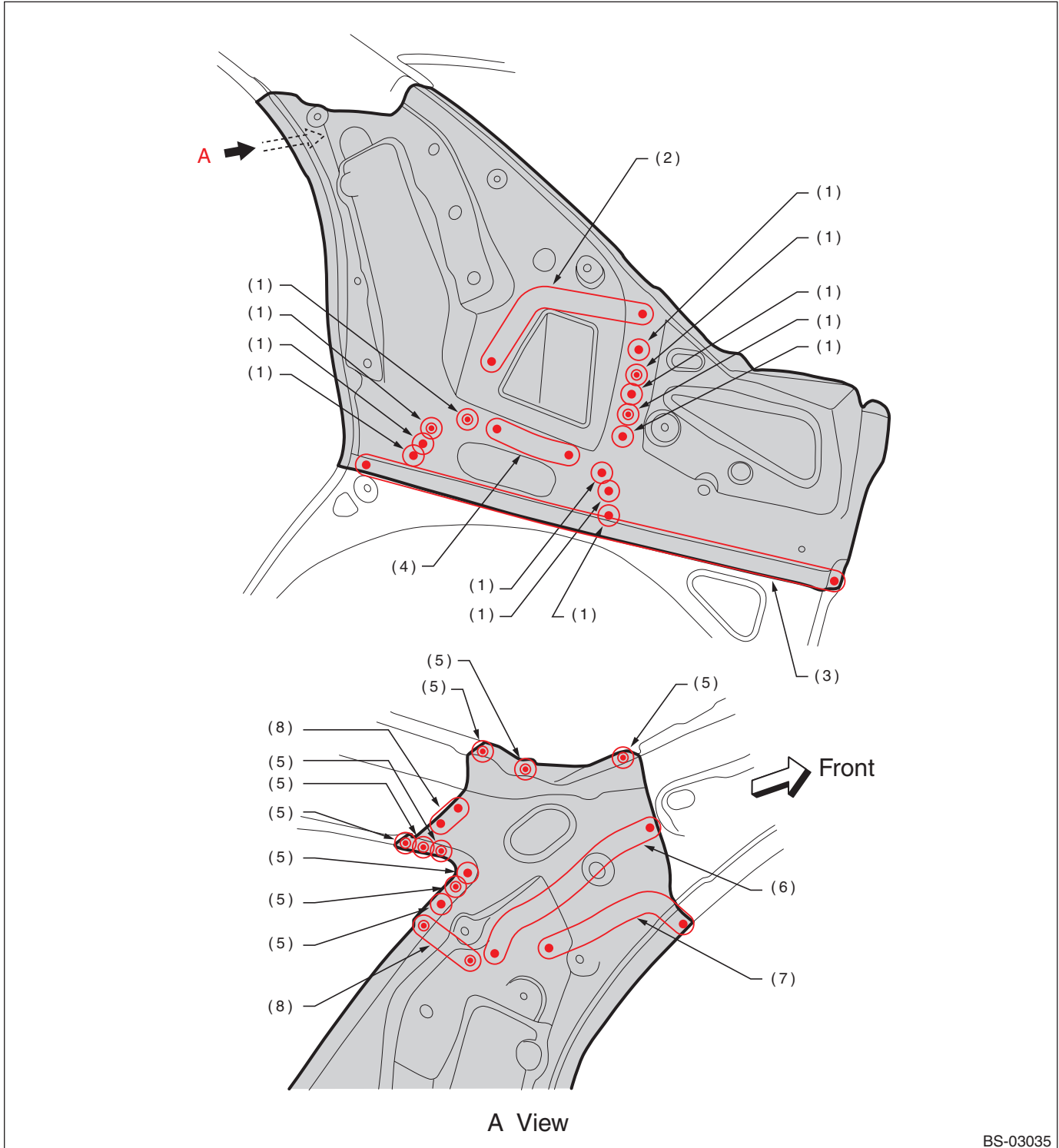
- | | | |
|-----------------------------------|---------------|---------------|
| (1) 2 points (service - matching) | (4) 3 points | (7) 12 points |
| (2) 4 points | (5) 1 point | |
| (3) 9 points | (6) 10 points | |

NOTE:

The illustration shows the rear quarter removed condition.

20.Rear Pillar Inner (total replacement) / Sedan

A: REMOVAL



BS-03035

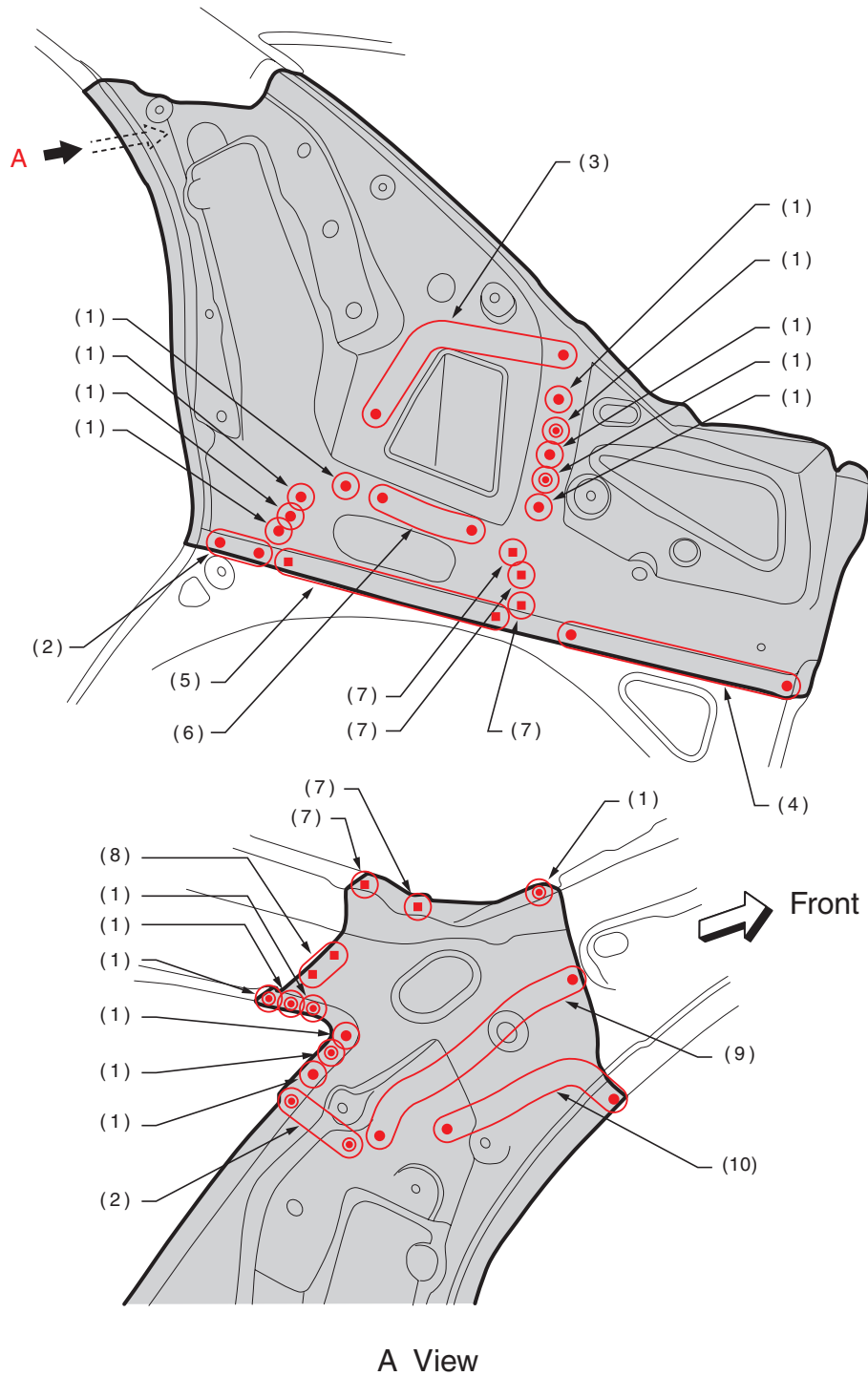
- | | | |
|-----------------------------|----------------------------|---------------------------|
| (1) 1 point (outside · 1) | (4) 3 points (outside · 1) | (7) 5 points (inside · 1) |
| (2) 7 points (outside · 1) | (5) 1 point (bottom · 1) | (8) 2 points (bottom · 1) |
| (3) 12 points (outside · 1) | (6) 6 points (inside · 1) | |

NOTE:

The illustration shows the rear quarter and the rear pillar reinforcement removed condition.

Rear Pillar Inner (total replacement) / Sedan

B: INSTALLATION



BS-03036

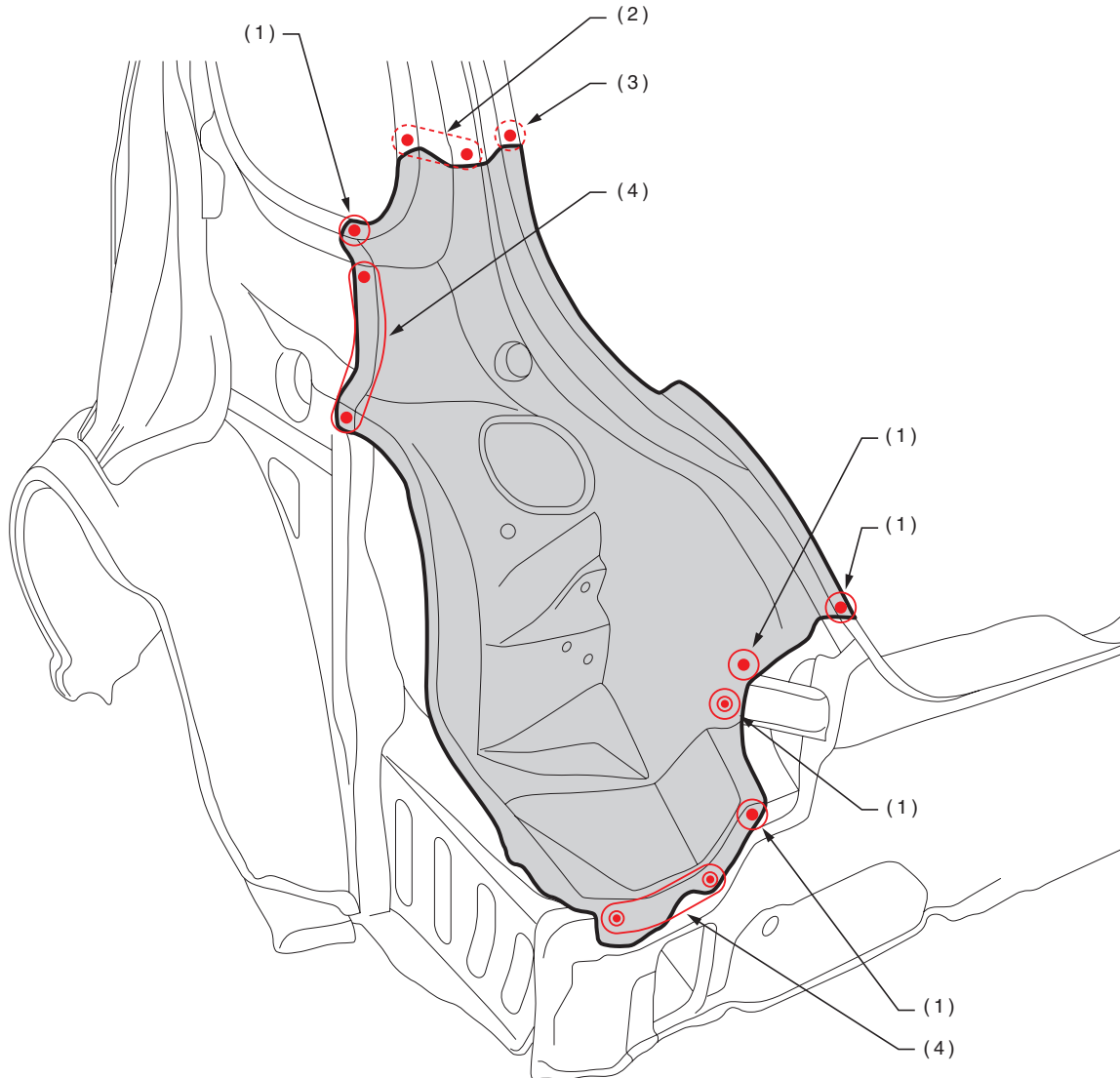
- | | | |
|--------------|------------------------|---------------|
| (1) 1 point | (5) 5 points (service) | (9) 7 points |
| (2) 2 points | (6) 4 points | (10) 6 points |
| (3) 9 points | (7) 1 point (service) | |
| (4) 8 points | (8) 2 points (service) | |

NOTE:

The illustration shows the rear quarter and the rear pillar reinforcement removed condition.

21.D-pillar Inner Lower (total replacement) / Wagon

A: REMOVAL



BS-03028

(1) 1 point (outside - 1)
(2) 3 points (inside - 1)

(3) 1 point (inside - 1)

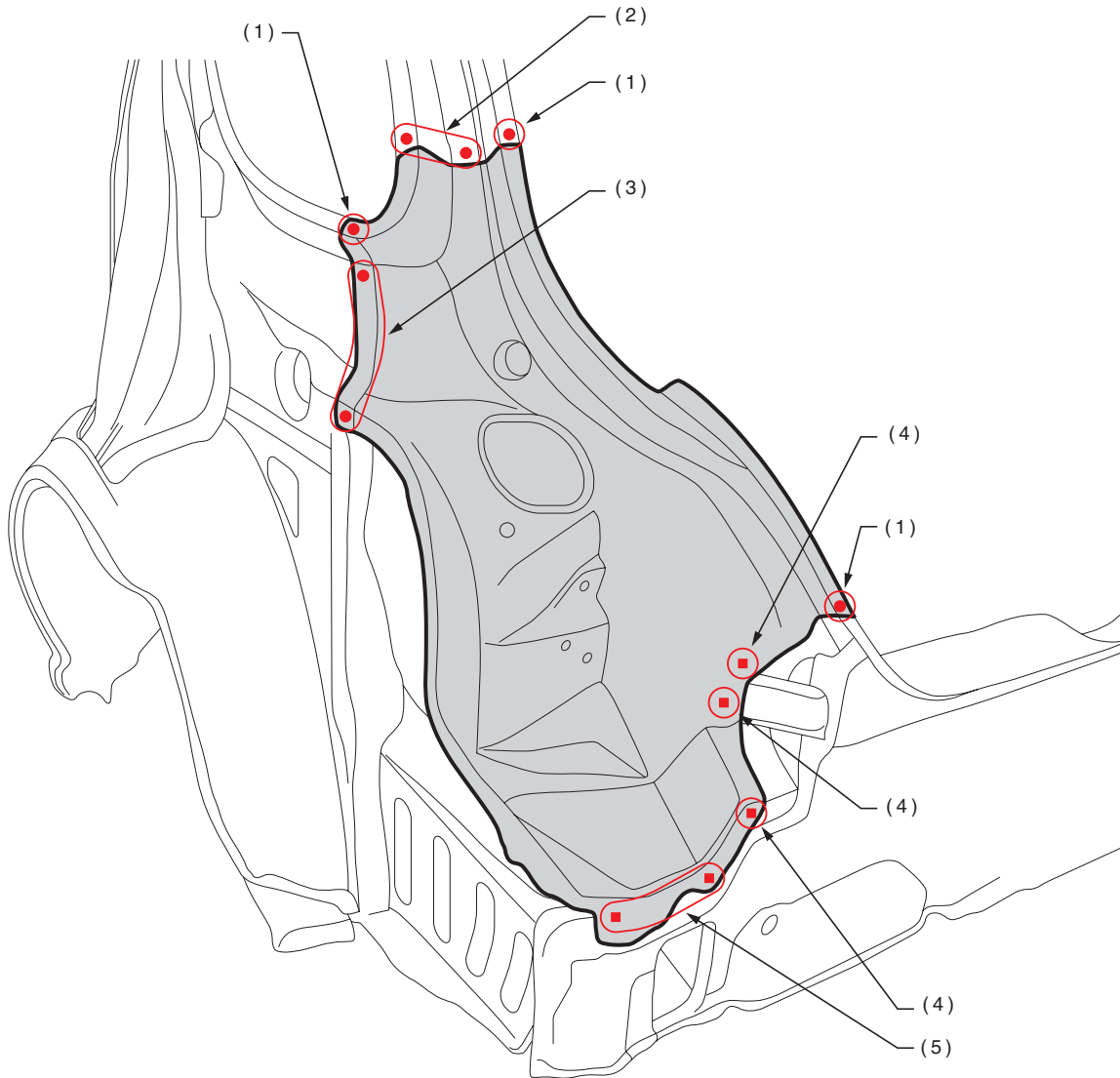
(4) 3 points (outside - 1)

NOTE:

The illustration shows the rear quarter and the D-pillar reinforcement removed condition.

D-pillar Inner Lower (total replacement) / Wagon

B: INSTALLATION



BS-03029

(1) 1 point
(2) 3 points

(3) 4 points
(4) 1 point (service)

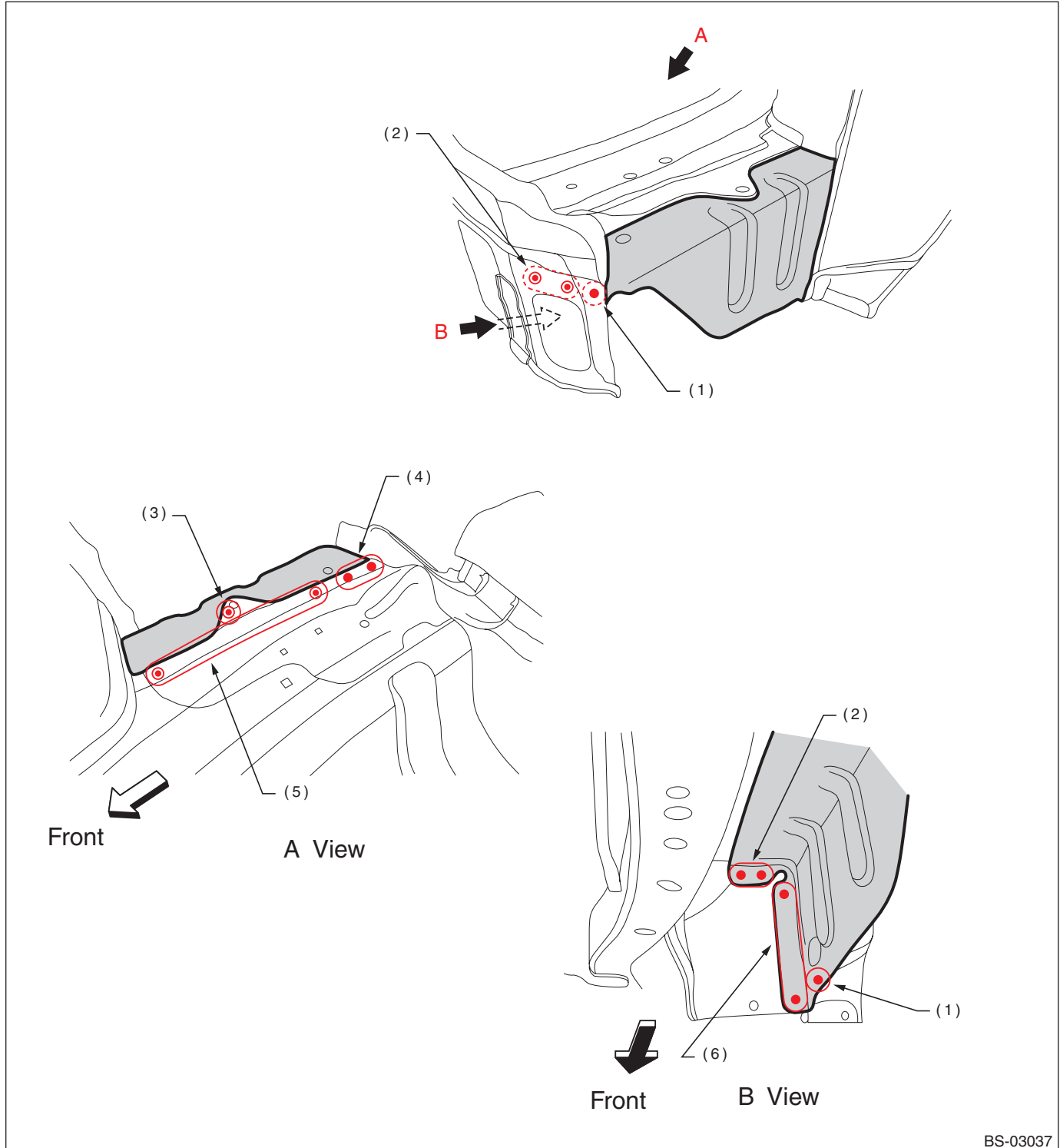
(5) 3 points (service)

NOTE:

The illustration shows the rear quarter and the D-pillar reinforcement removed condition.

22.Rear Floor Side (total replacement) (right side)

A: REMOVAL



BS-03037

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

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

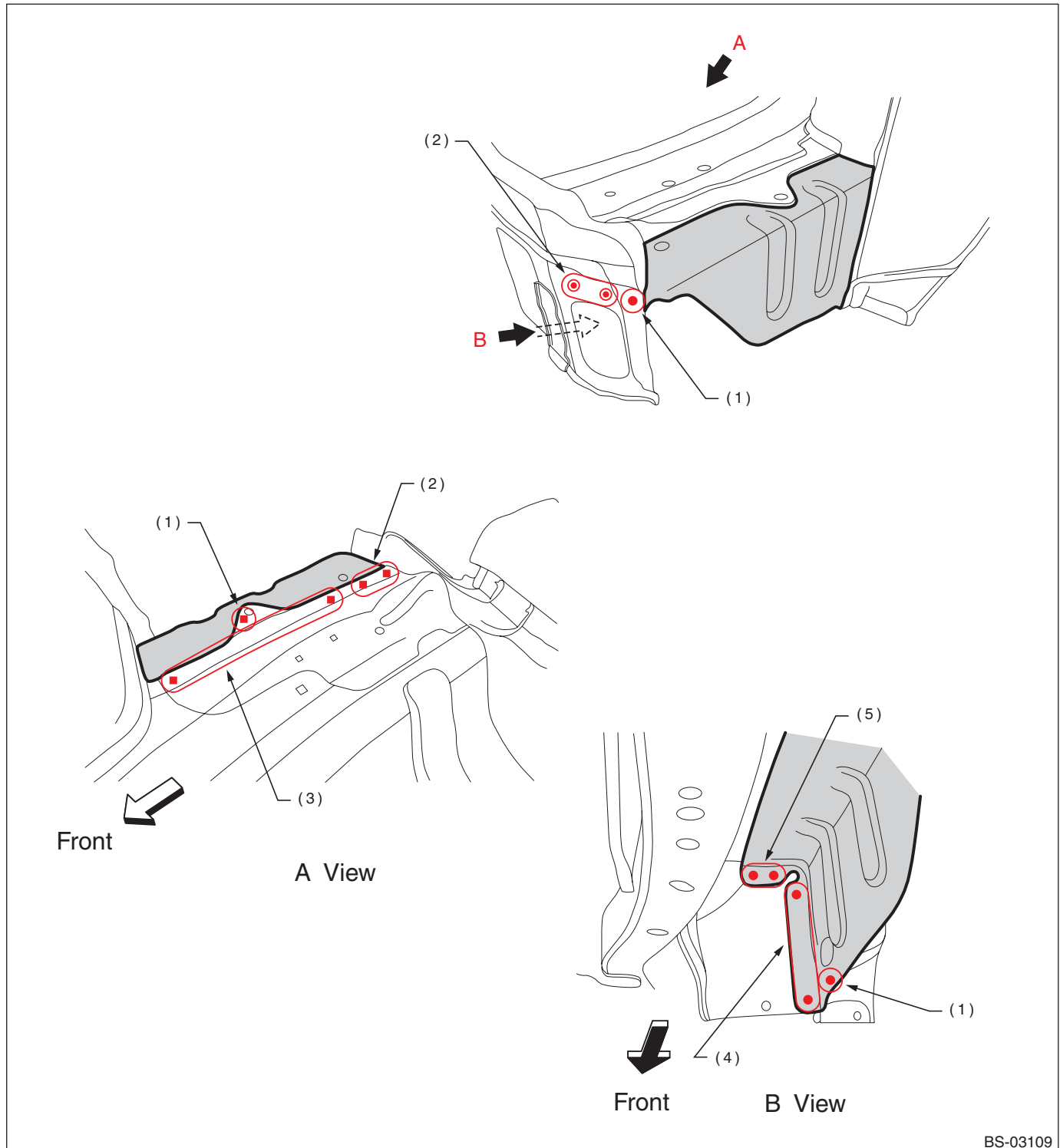
- (5) 6 points (top · 2)
- (6) 4 points (inside · 1)

NOTE:

The illustration shows the rear quarter and the rear quarter end removed condition.

Rear Floor Side (total replacement) (right side)

B: INSTALLATION



BS-03109

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

- (3) 6 points
- (4) 5 points

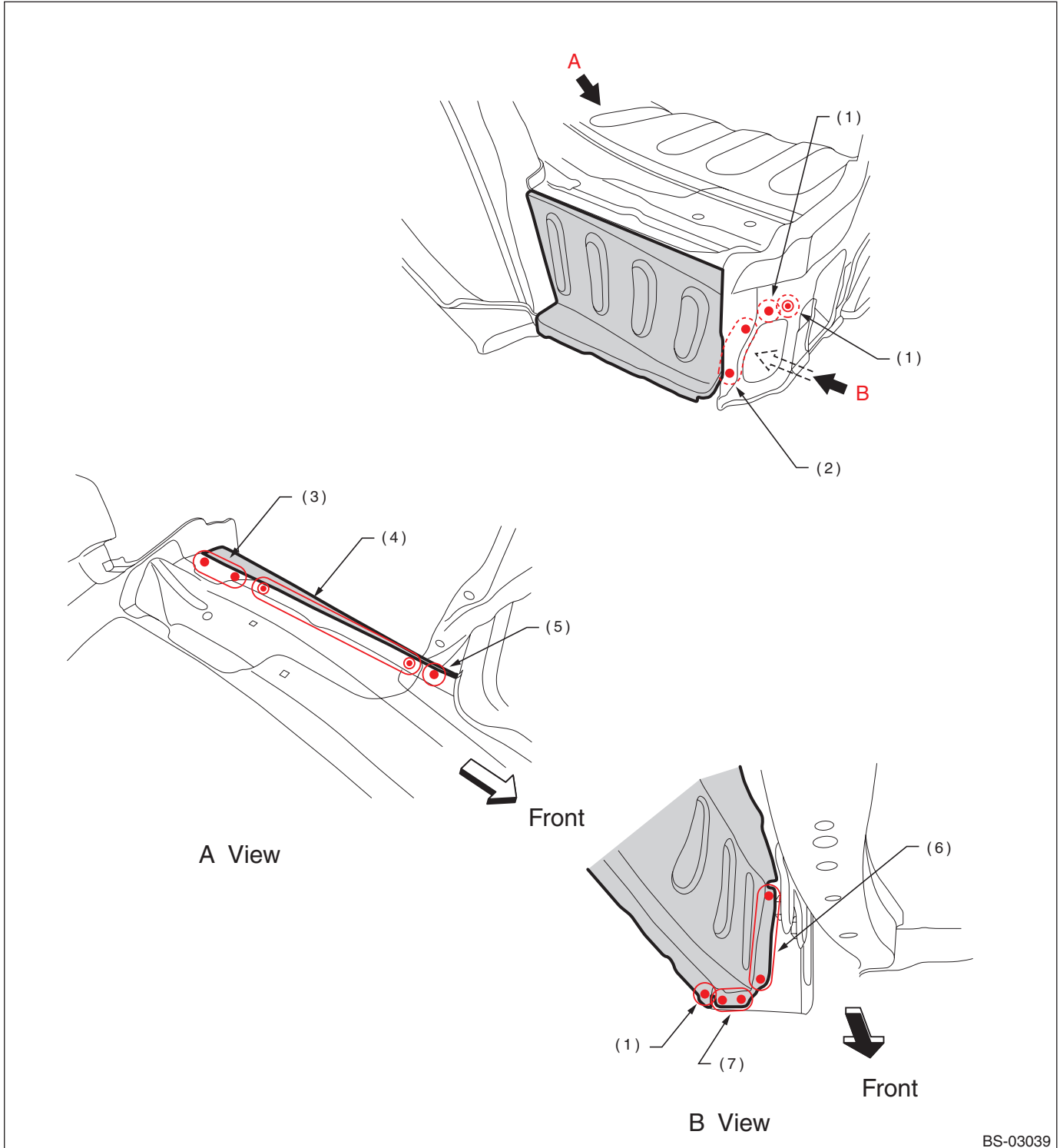
- (5) 3 points

NOTE:

The illustration shows the rear quarter and the rear quarter end removed condition.

23.Rear Floor Side (total replacement) (left side)

A: REMOVAL



BS-03039

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

- (4) 5 points (top · 2)
- (5) 1 point (top · 1)

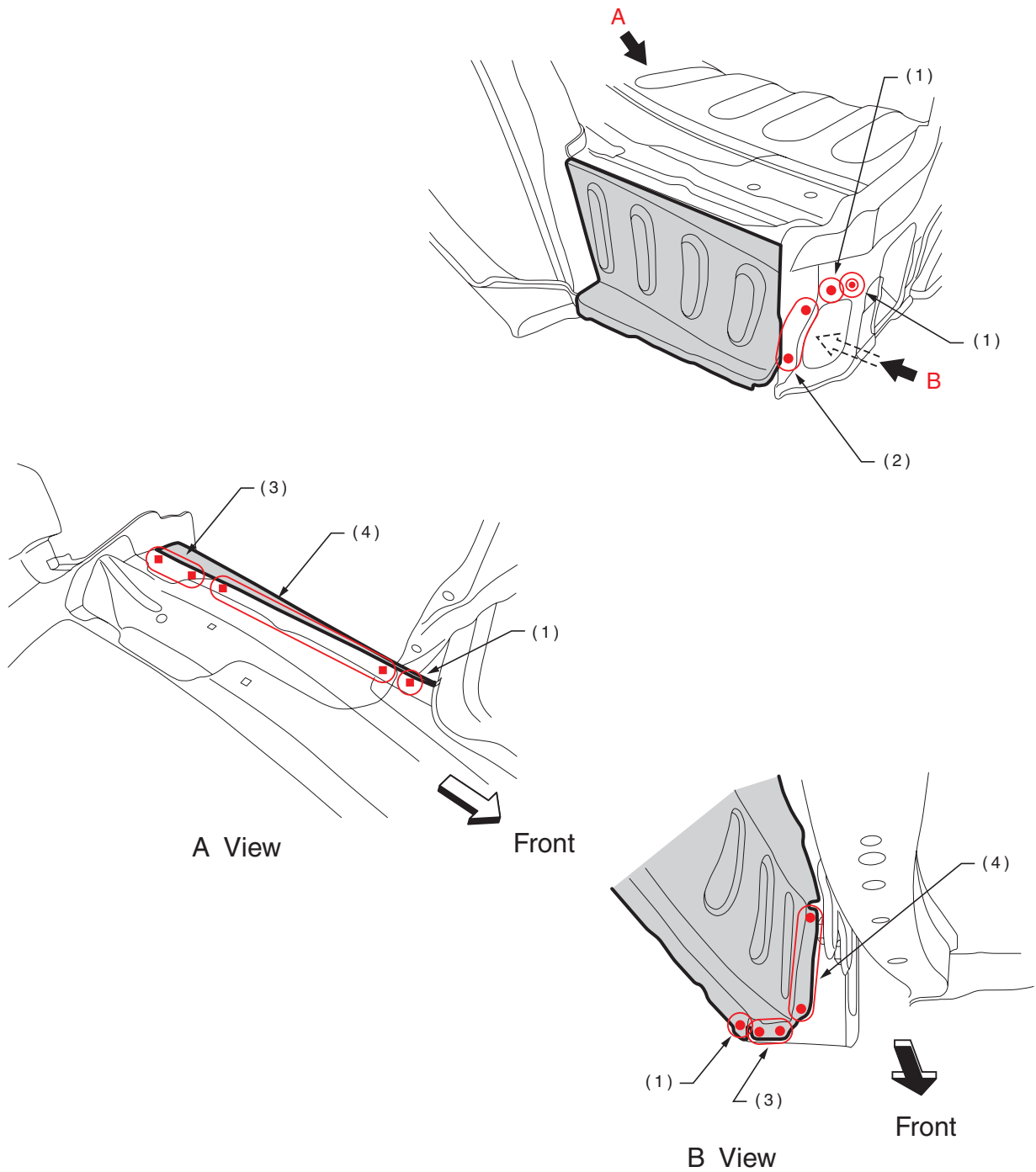
- (6) 4 points (inside · 1)
- (7) 2 points (inside · 1)

NOTE:

The illustration shows the rear quarter and the rear quarter end removed condition.

Rear Floor Side (total replacement) (left side)

B: INSTALLATION



BS-03040

- (1) 1 point
- (2) 4 points

- (3) 2 points

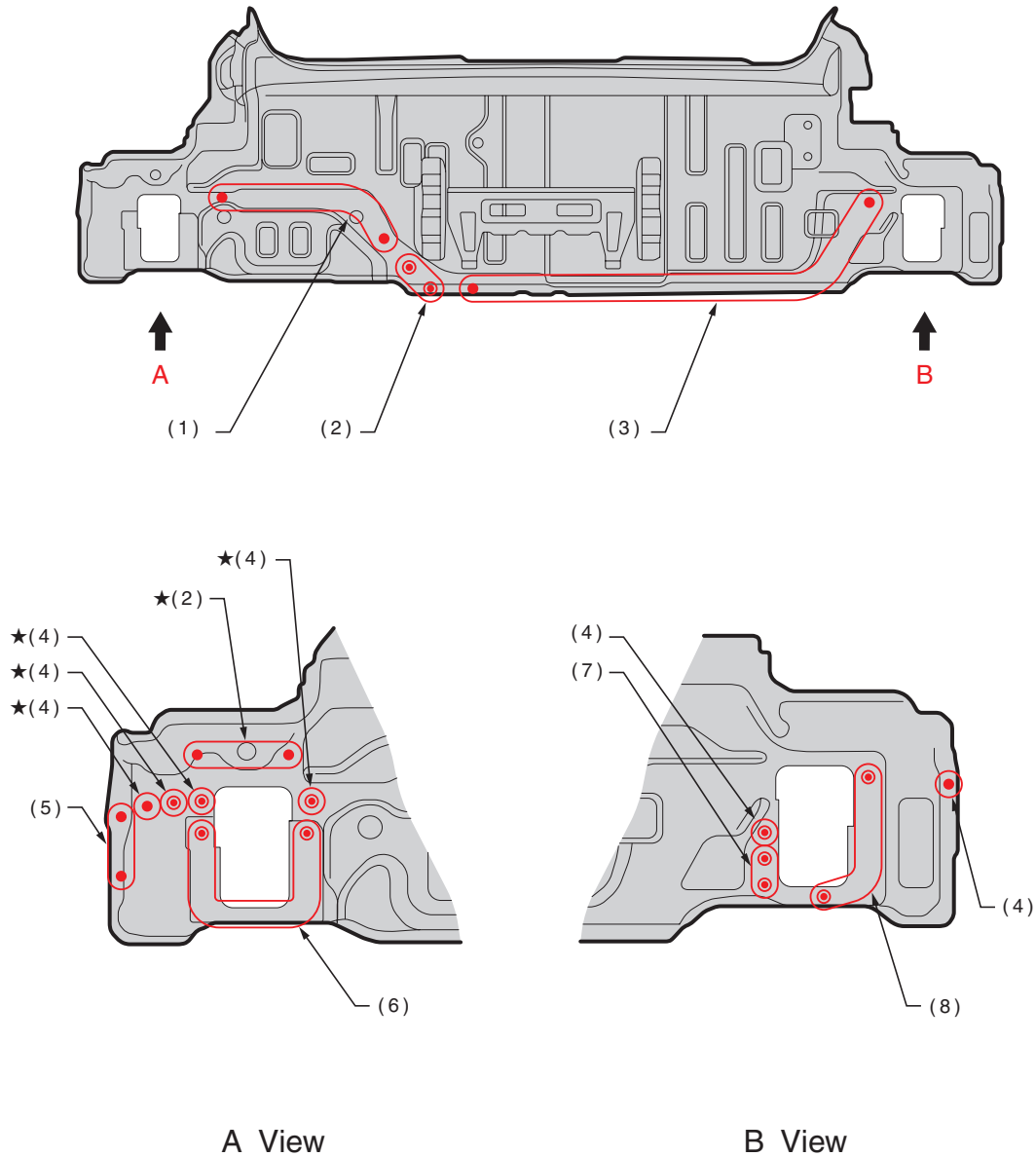
- (4) 5 points

NOTE:

The illustration shows the rear quarter and the rear quarter end removed condition.

24.Rear Skirt (total replacement) / Wagon

A: REMOVAL



BS-03041

Rear Skirt (total replacement) / Wagon

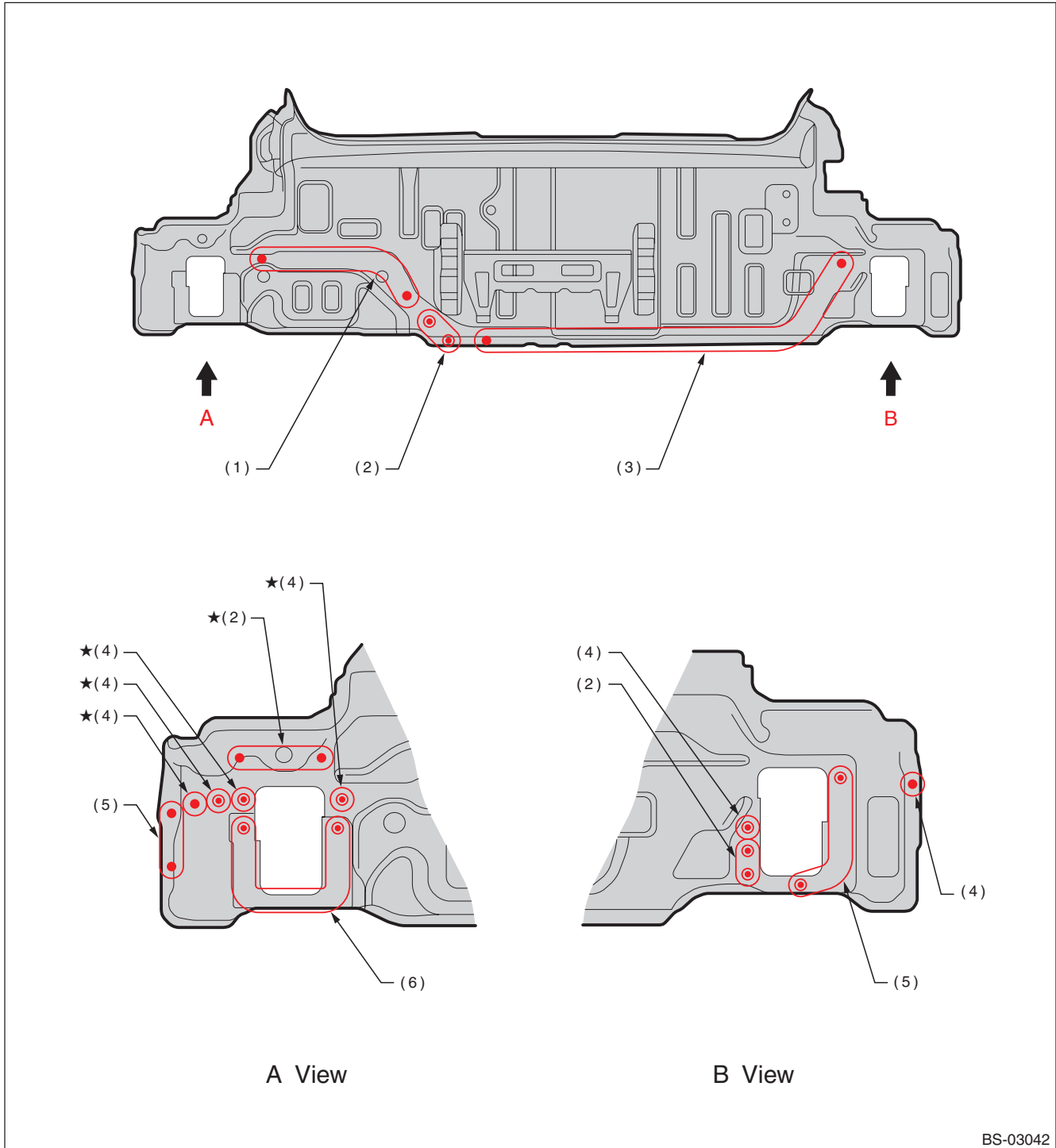
- | | | |
|-----------------------------|----------------------------|----------------------------|
| (1) 7 points (outside · 1) | (4) 1 point (outside · 1) | (7) 2 points (outside · 2) |
| (2) 2 points (outside · 1) | (5) 3 points (outside · 1) | (8) 3 points (outside · 2) |
| (3) 15 points (outside · 1) | (6) 5 points (outside · 1) | |

NOTE:

- The illustration shows the rear quarter, D-pillar reinforcement and the D-pillar inner lower removed condition.
- For locations marked by ★, the welding method and the number of welding points are the same on the left and the right.

Rear Skirt (total replacement) / Wagon

B: INSTALLATION



BS-03042

(1) 9 points
(2) 2 points

(3) 18 points
(4) 1 point

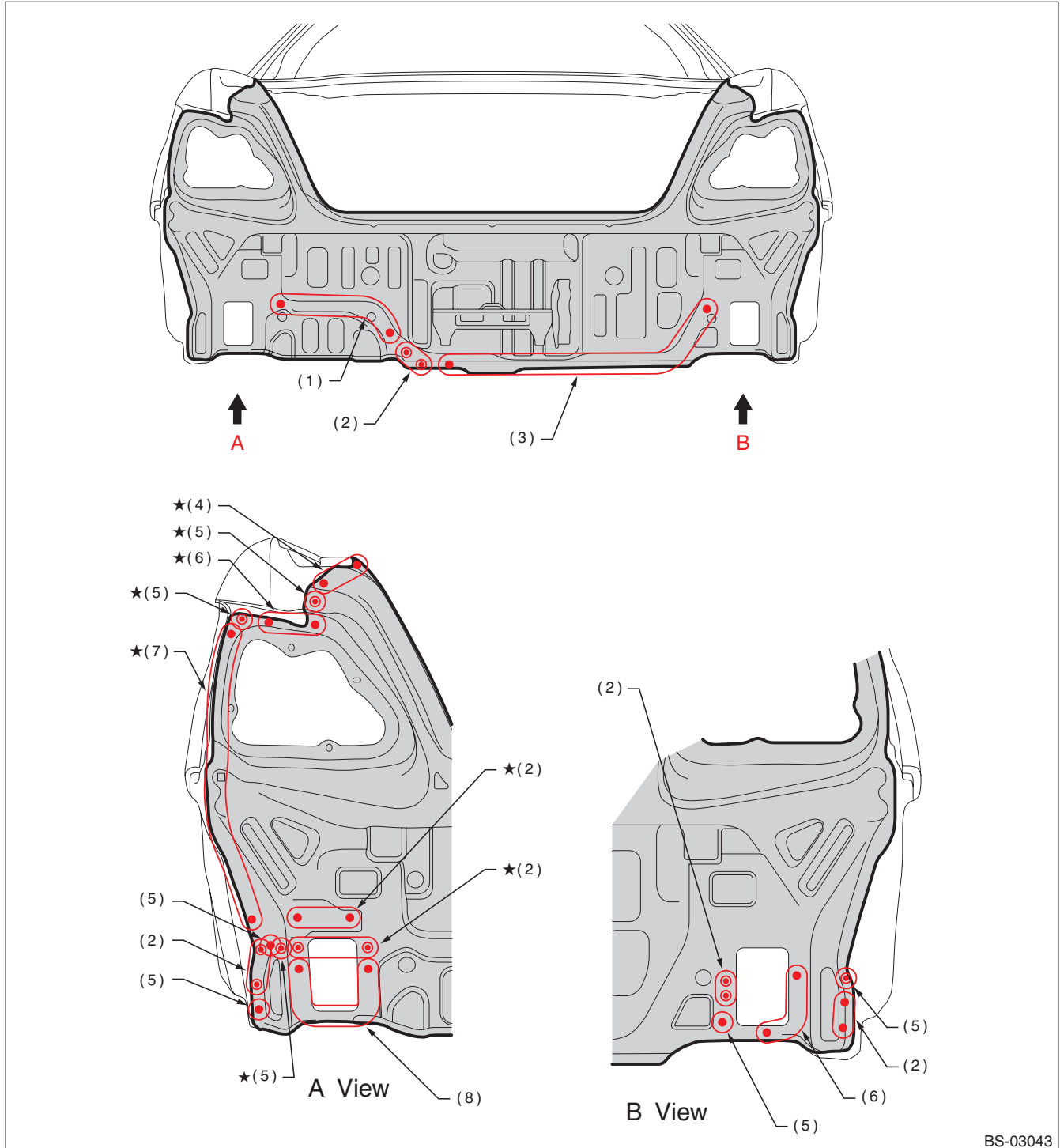
(5) 3 points
(6) 7 points

NOTE:

- For locations marked by ★, the welding method and the number of welding points are the same on the left and the right.
- The illustration shows the rear quarter, D-pillar reinforcement and the D-pillar inner lower removed condition.

25.Rear Skirt (total replacement) / Sedan

A: REMOVAL



BS-03043

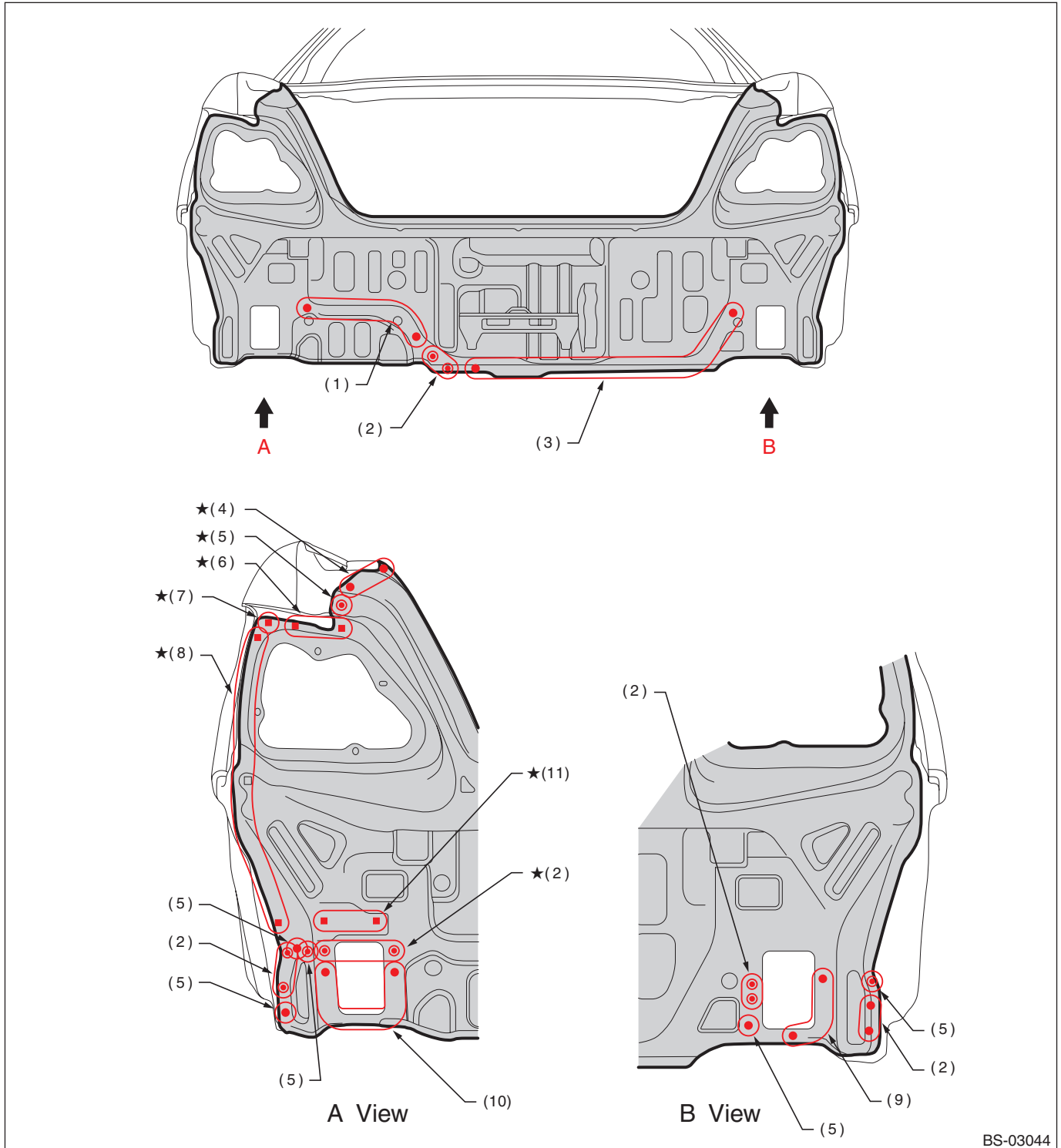
- | | | |
|-----------------------------|----------------------------|----------------------------|
| (1) 7 points (outside · 1) | (4) 4 points (outside · 1) | (7) 9 points (outside · 1) |
| (2) 2 points (outside · 1) | (5) 1 point (outside · 1) | |
| (3) 15 points (outside · 1) | (6) 3 points (outside · 1) | |

NOTE:

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

Rear Skirt (total replacement) / Sedan

B: INSTALLATION



BS-03044

- | | | |
|---------------|-------------------------|-------------------------|
| (1) 9 points | (5) 1 point | (9) 3 points |
| (2) 2 points | (6) 3 points (service) | (10) 7 points |
| (3) 18 points | (7) 1 point (service) | (11) 2 points (service) |
| (4) 4 points | (8) 12 points (service) | |

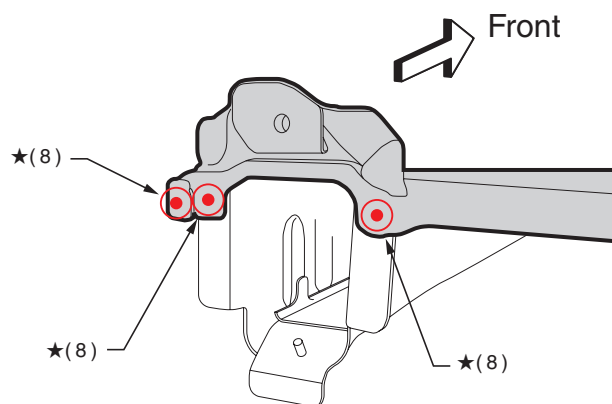
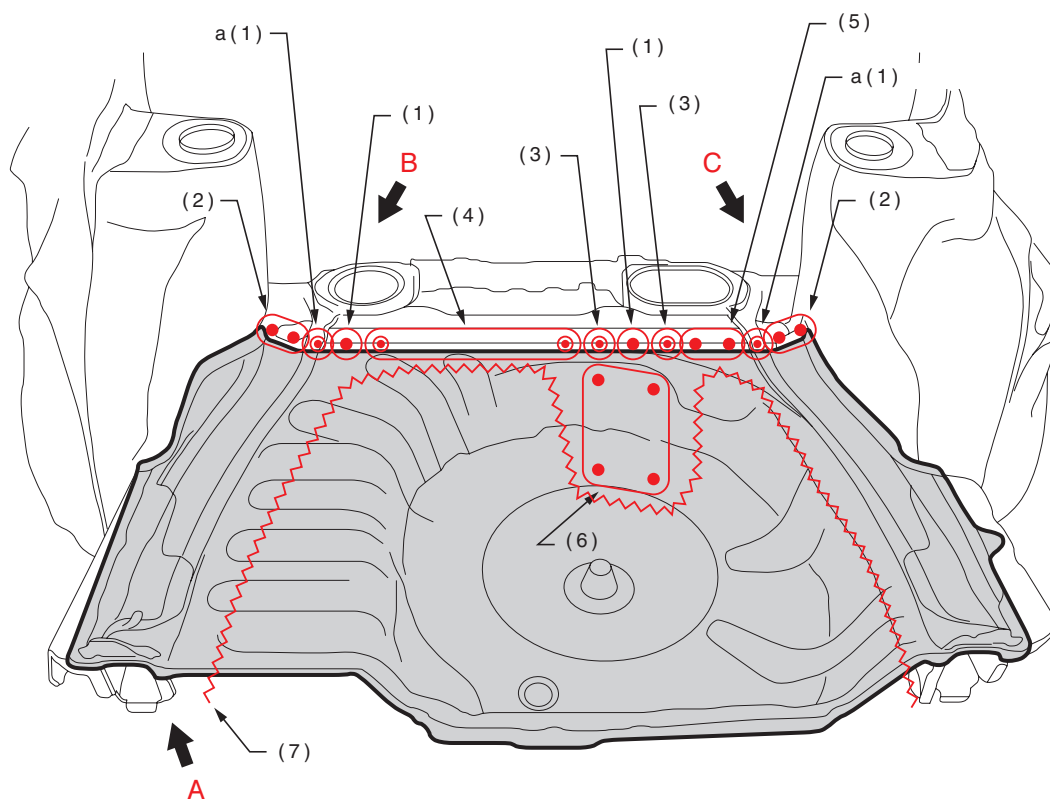
NOTE:

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 Rear (total replacement)

26.Rear Floor Pan Rear (total replacement)

A: REMOVAL



A View

BS-03045

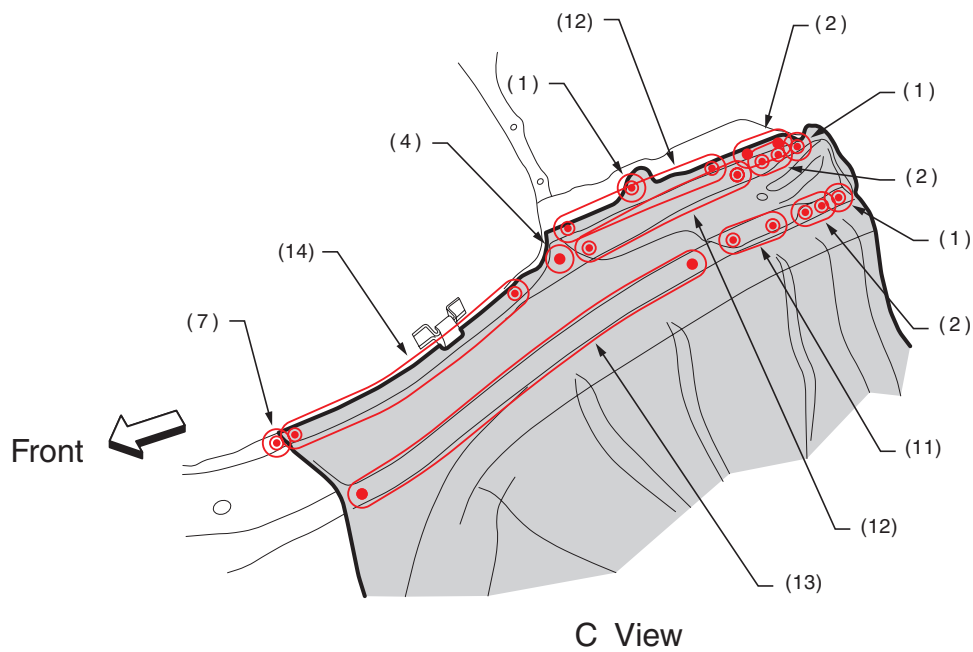
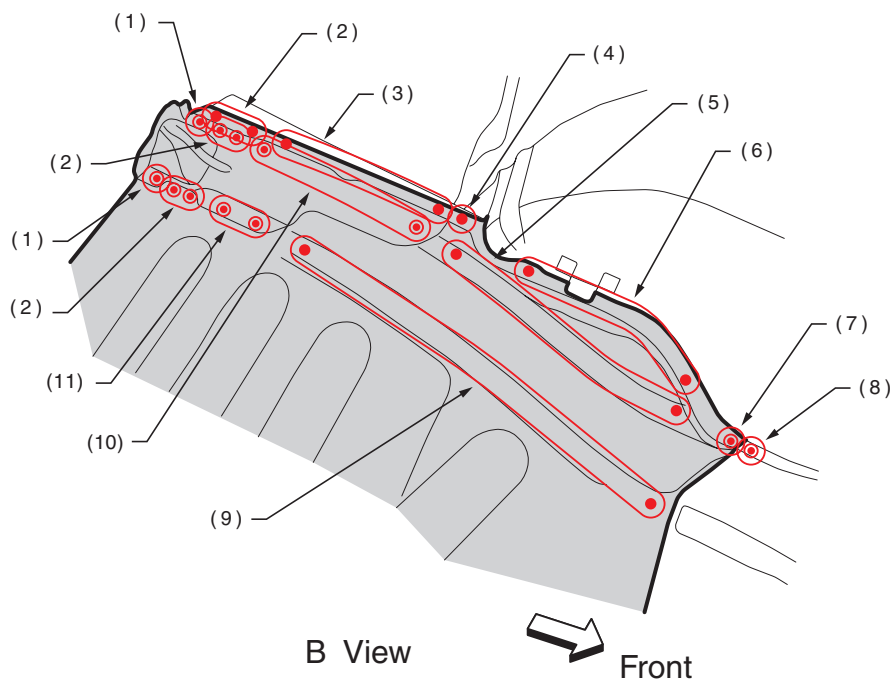
Rear Floor Pan Rear (total replacement)

- | | | |
|------------------------|-------------------------|---------------------------|
| (1) 1 point (top · 1) | (4) 9 points (top · 2) | (7) Rough cutting |
| (2) 2 points (top · 1) | (5) 4 points (top · 1) | (8) 1 point (outside · 1) |
| (3) 1 point (top · 2) | (6) 10 points (top · 1) | |

NOTE:

- Remove the welding point “a” to make the operation easier.
- For locations marked by ★, the welding method and the number of welding points are the same on the left and the right.
- The illustration shows the rear skirt removed condition.

Rear Floor Pan Rear (total replacement)

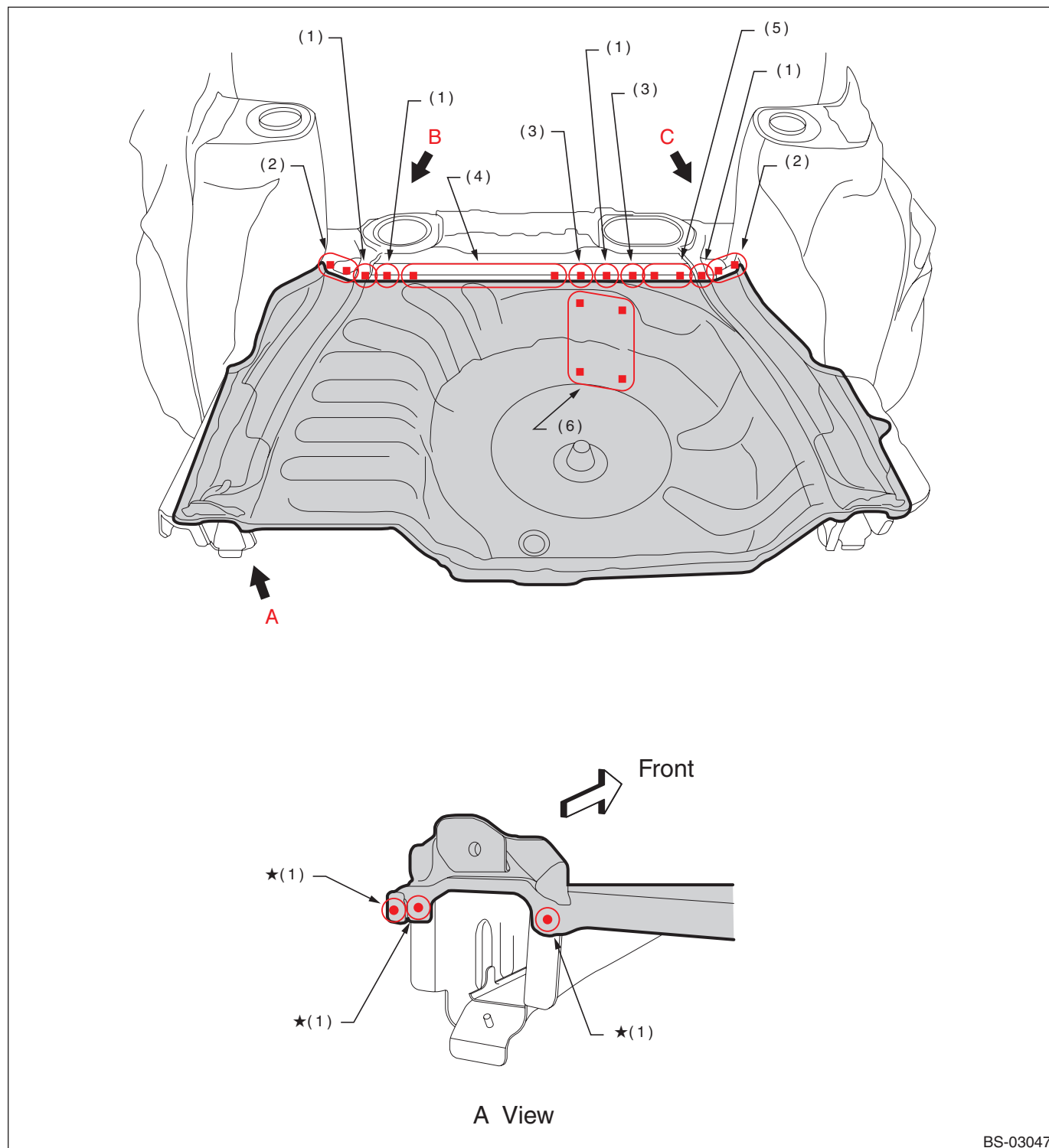


BS-03046

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

Rear Floor Pan Rear (total replacement)

B: INSTALLATION



BS-03047

(1) 1 point
(2) 2 points

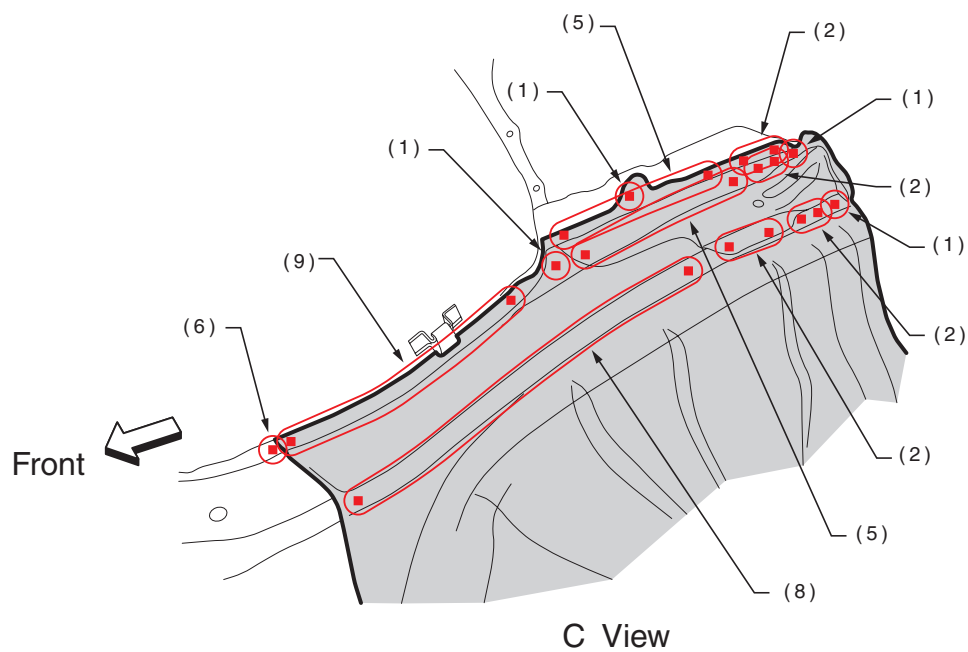
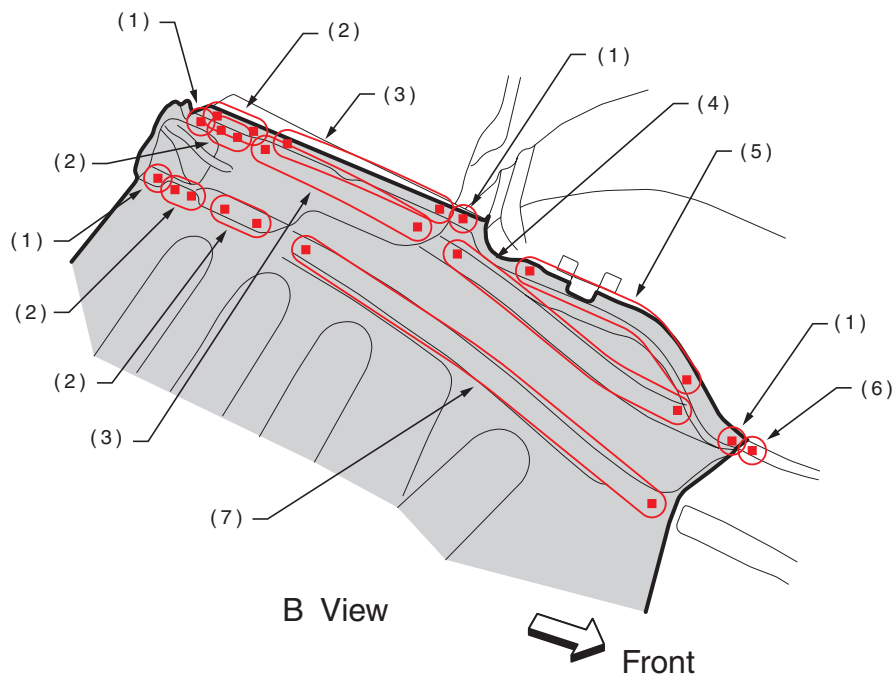
(3) 1 point (service · matching)
(4) 9 points (service · matching)

(5) 4 points
(6) 10 points (service)

NOTE:

- The illustration shows the rear skirt removed condition.
- 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 Rear (total replacement)



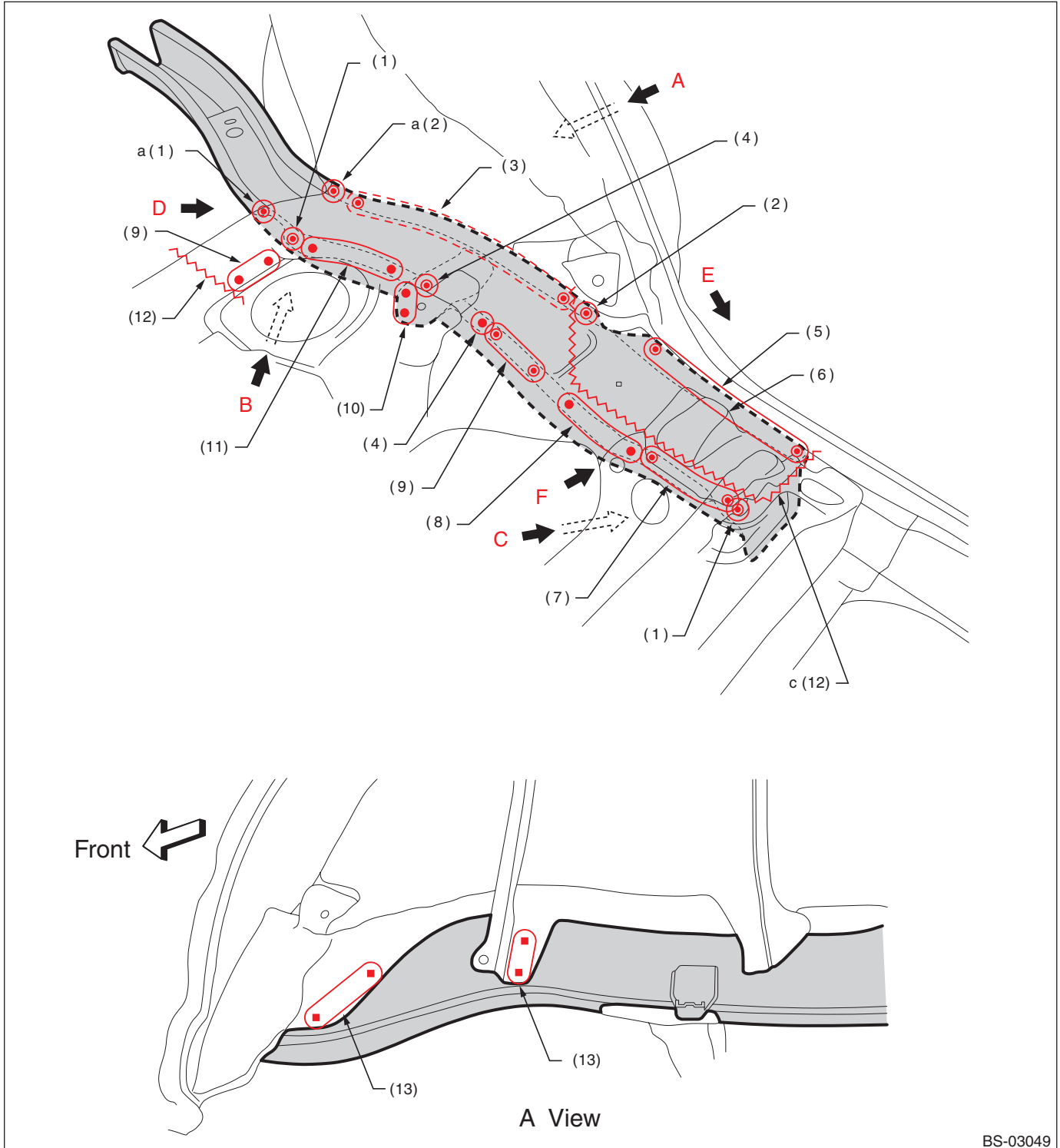
BS-03048

- | | | |
|------------------------|----------------------------------|-------------------------|
| (1) 1 point (service) | (4) 7 points (service) | (7) 10 points (service) |
| (2) 2 points (service) | (5) 6 points (service) | (8) 12 points (service) |
| (3) 5 points (service) | (6) 1 point (service · matching) | (9) 13 points (service) |

Rear Side Frame (total replacement)

27.Rear Side Frame (total replacement)

A: REMOVAL



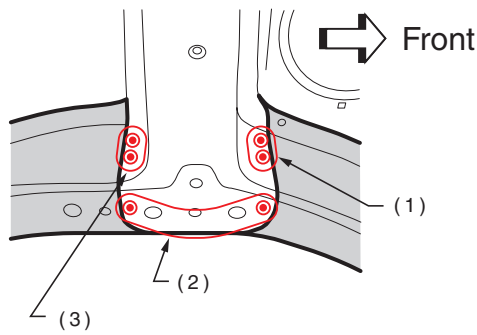
Rear Side Frame (total replacement)

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

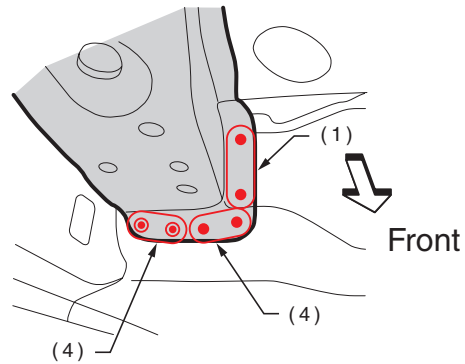
NOTE:

- The illustration shows the rear skirt and the rear floor pan rear removed condition.
- Work for welding point “a” should be done when removing the rear floor pan rear.
- Rough cut the section “c” after removing the bracket. The bracket should be reused.

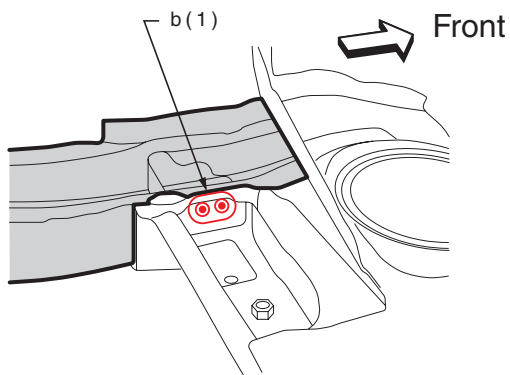
Rear Side Frame (total replacement)



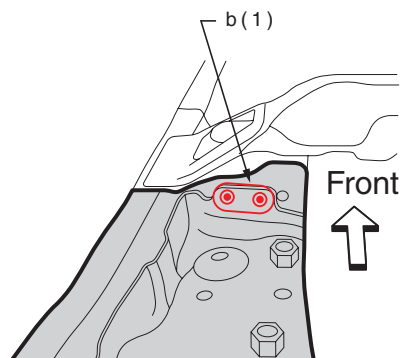
B View



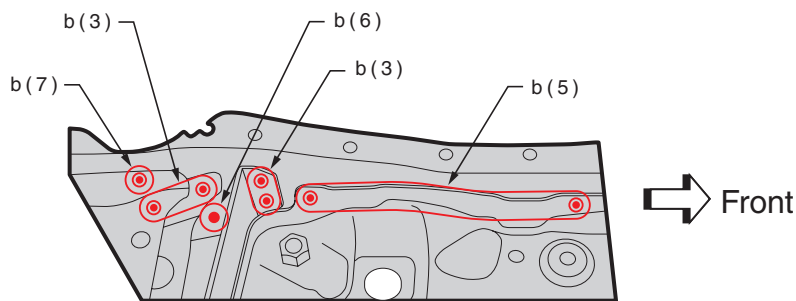
C View



D View



E View



F View

BS-03050

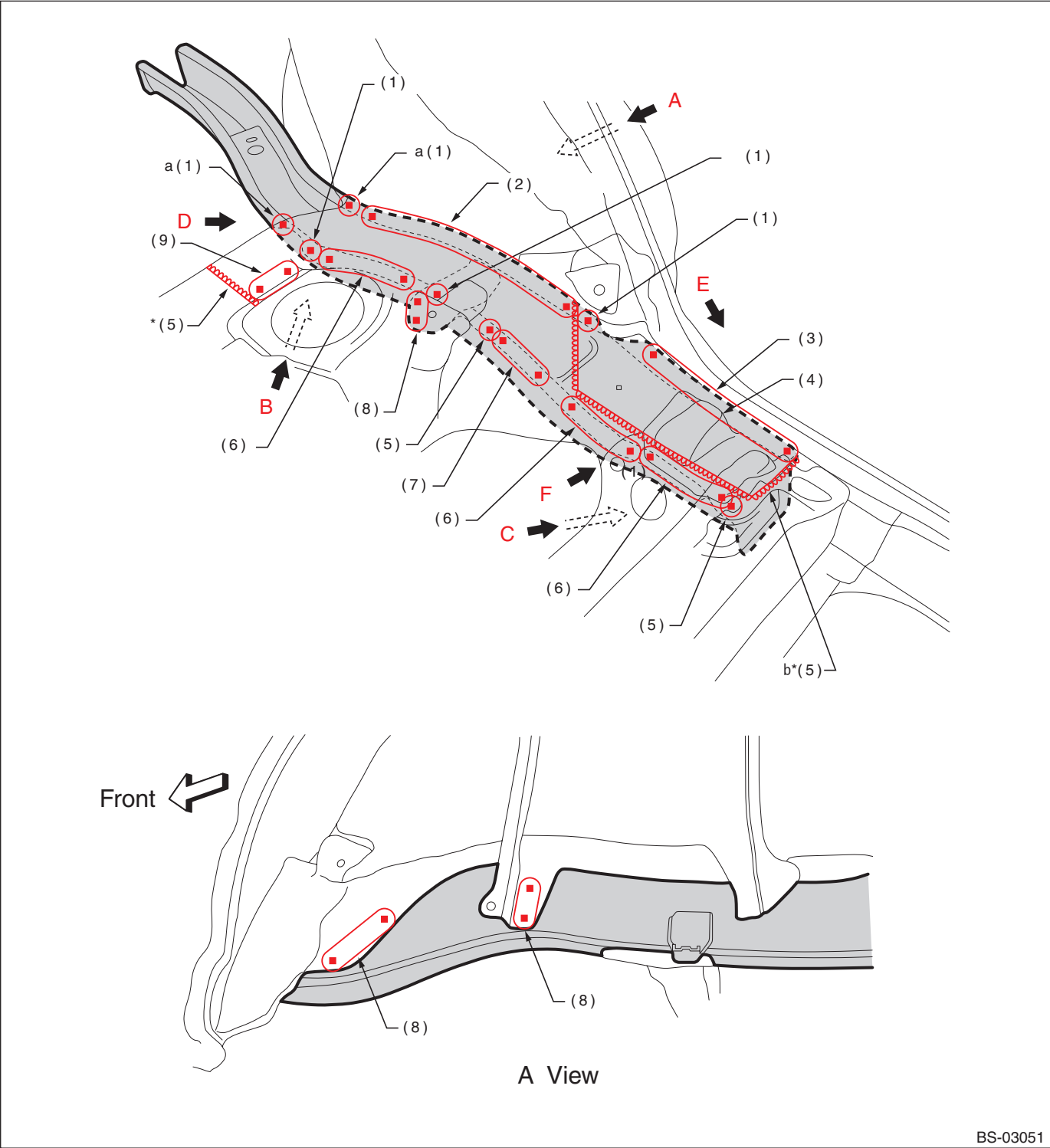
- | | | |
|---------------------------|---------------------------|--------------------------|
| (1) 2 points (inside · 1) | (4) 2 points (bottom · 1) | (6) 1 point (inside · 1) |
| (2) 4 points (bottom · 1) | (5) 4 points (inside · 2) | (7) 1 point (inside · 2) |
| (3) 2 points (inside · 2) | | |

NOTE:

- If the removal of the welding point marked by “b” is difficult, open the work openings from the opposite side.
- View D shows the opened condition of the rear floor pan front.
- View E and view F show the opened condition of the rough cutting part.

Rear Side Frame (total replacement)

B: INSTALLATION



BS-03051

Rear Side Frame (total replacement)

- | | | |
|-----------------------------------|--------------|-----------------------------------|
| (1) 1 point (service · matching) | (4) Bracket | (7) 3 points (service · matching) |
| (2) 13 points (both surface plug) | (5) 1 point | (8) 2 points |
| (3) 5 points (service · matching) | (6) 4 points | (9) 3 points |

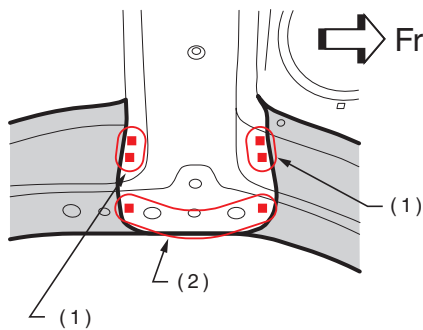
CAUTION:

For continuous welds marked by *, apply anticorrosion wax thoroughly on the reverse side.

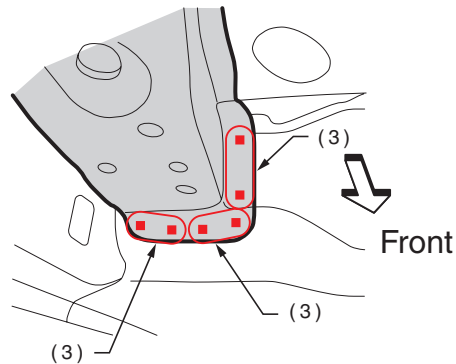
NOTE:

- Work for welding point “a” should be done when installing the rear floor pan rear.
- When working for welding point “b”, weld the work openings, then install bracket.
- The illustration shows the rear skirt and the rear front pan rear removed condition.

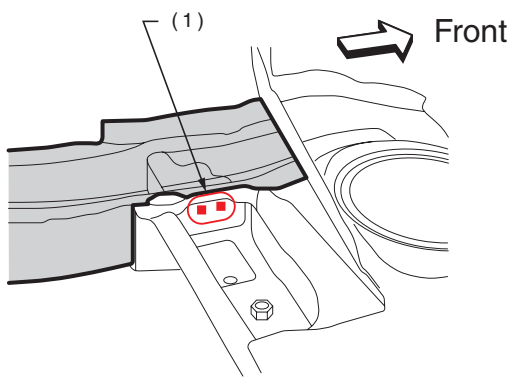
Rear Side Frame (total replacement)



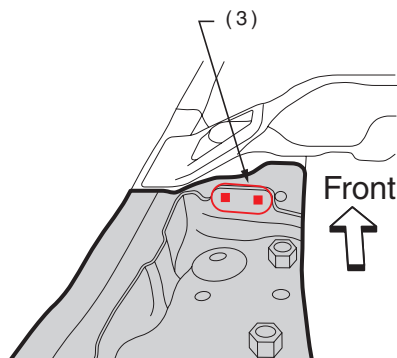
B View



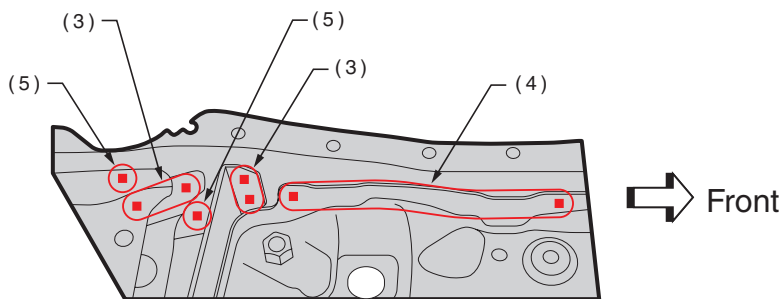
C View



D View



E View



F View

BS-03052

(1) 2 points (service · matching)

(2) 4 points (service · matching)

(3) 2 points (service)

(4) 4 points (service)

(5) 1 point (service)

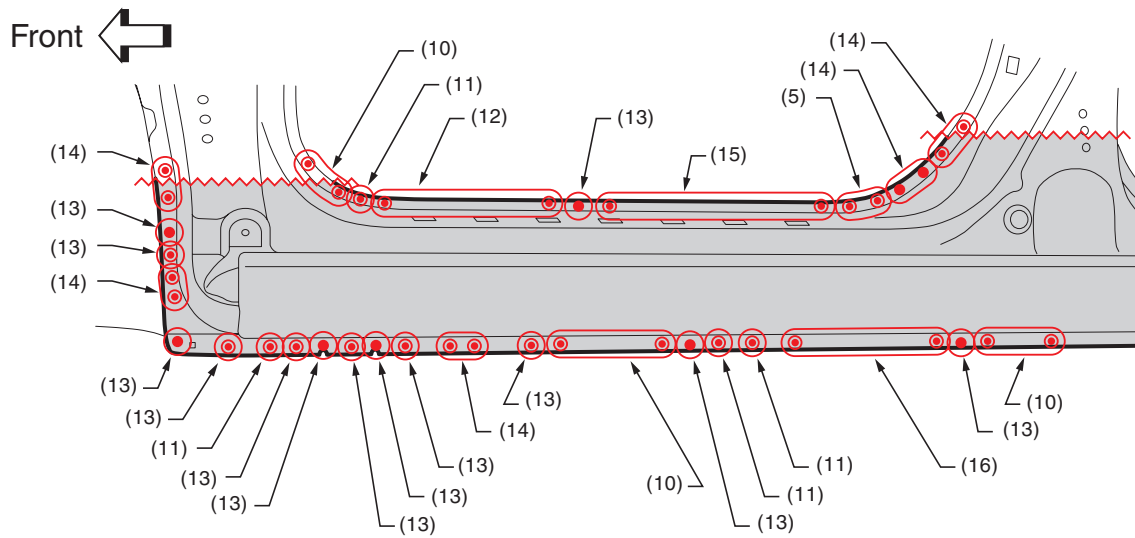
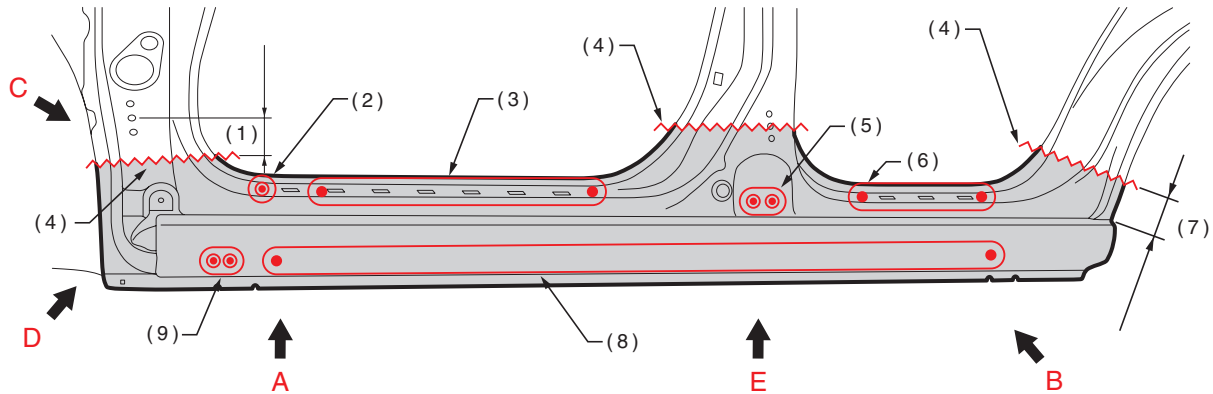
NOTE:

- Part replacement of the rear side frame in this operation is described with rear wheel apron attached. To make the part replacement of the rear side frame easier, remove the rear apron before this operation.
- View D shows the opened condition of the rear floor pan front.
- View E and view F show the opened condition of the rough cutting.

Side Sill Outer (partial replacement)

28.Side Sill Outer (partial replacement)

A: REMOVAL

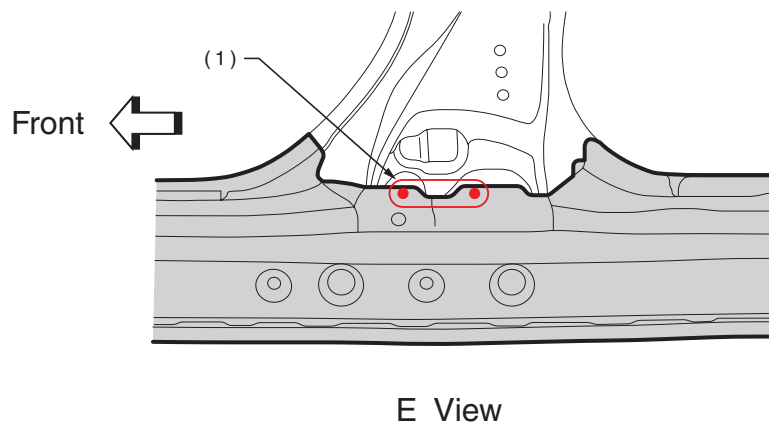
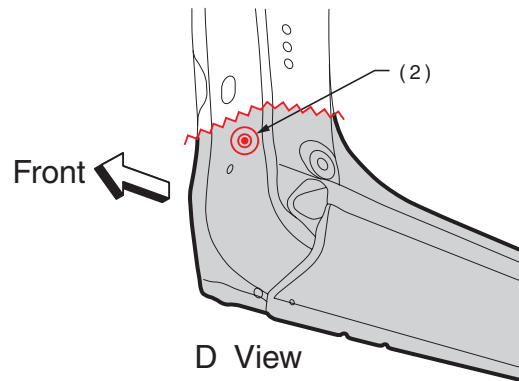
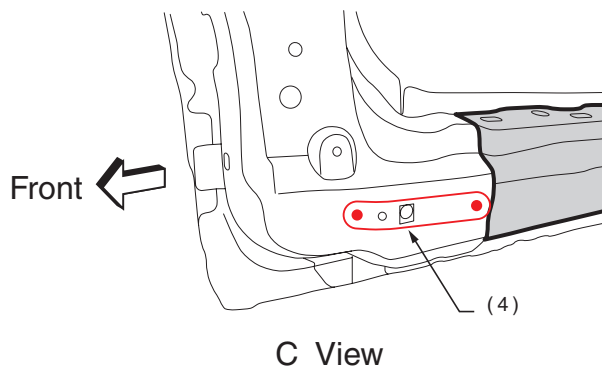
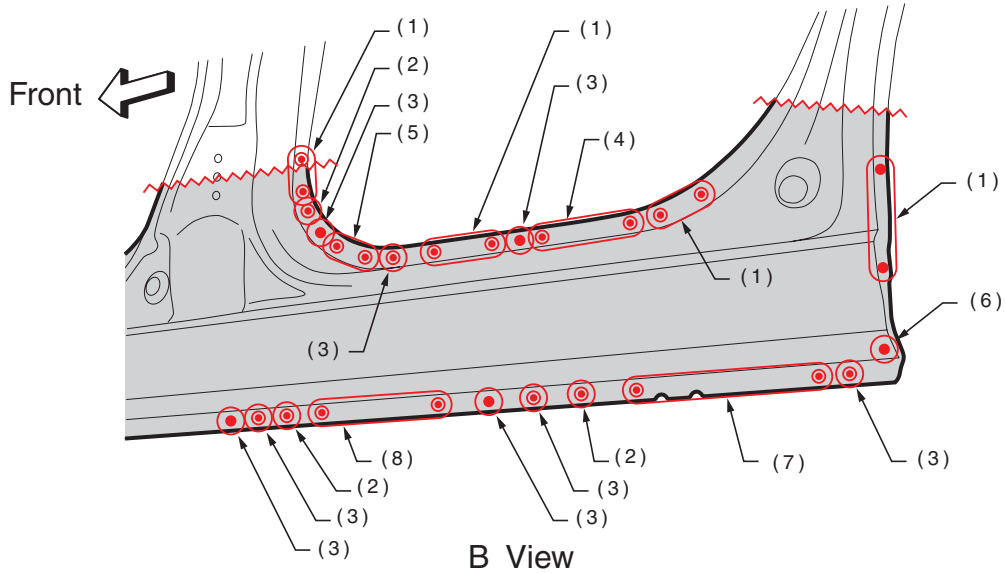


A View

BS-03018

- | | | |
|----------------------------|-----------------------------|-----------------------------|
| (1) 60 mm (2.36 in) | (7) 80 mm (3.15 in) | (13) 1 point (outside · 1) |
| (2) 1 point (top · 1) | (8) 13 points (bottom · 1) | (14) 2 points (outside · 1) |
| (3) 7 points (top · 1) | (9) 2 points (bottom · 1) | (15) 7 points (outside · 2) |
| (4) Rough cutting | (10) 3 points (outside · 1) | (16) 7 points (outside · 1) |
| (5) 2 points (outside · 2) | (11) 1 point (outside · 2) | |
| (6) 4 points (top · 1) | (12) 6 points (outside · 2) | |

Side Sill Outer (partial replacement)



BS-03019

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

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

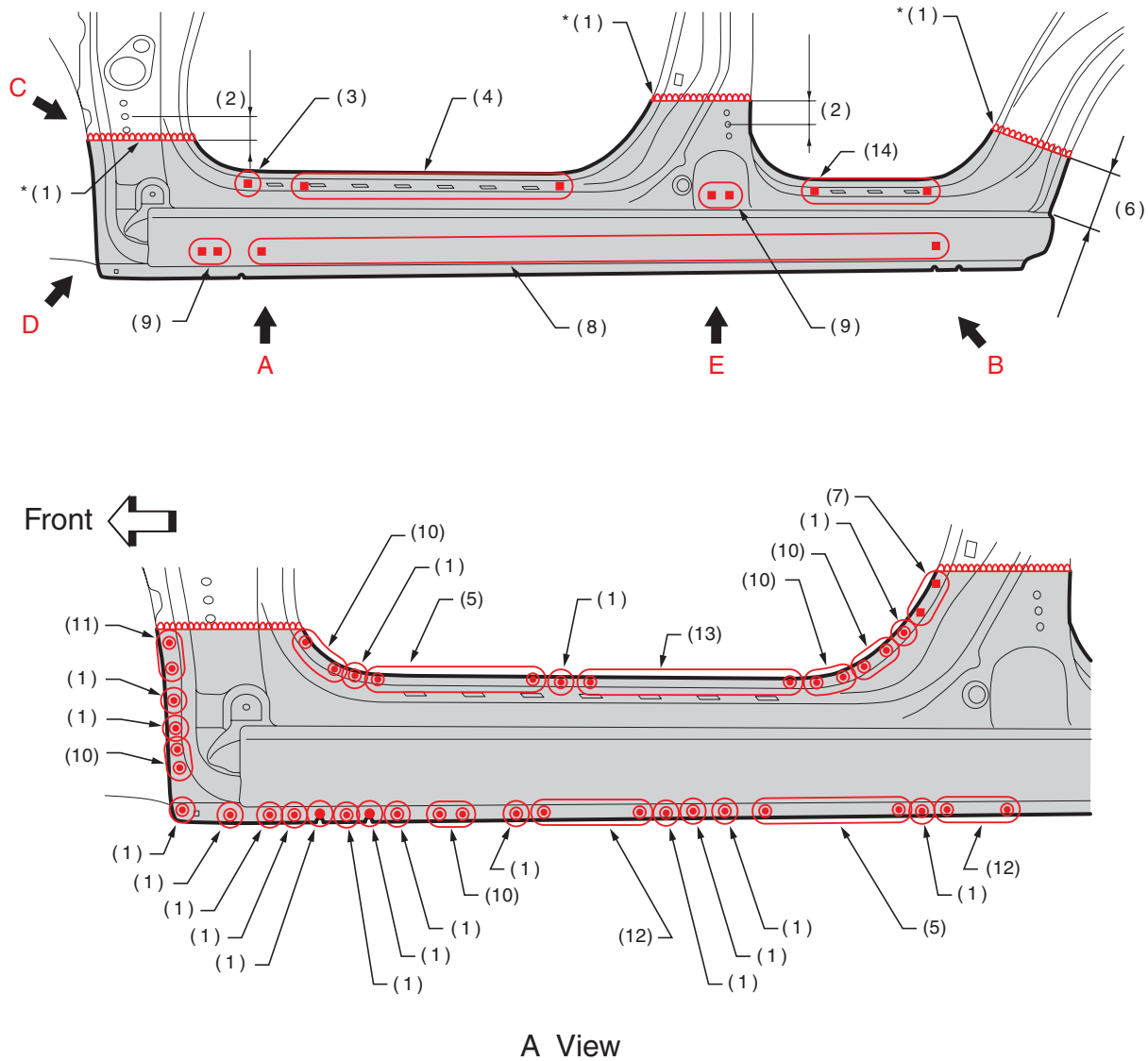
- (7) 5 points (outside - 1)
- (8) 4 points (outside - 1)

NOTE:

- In this side sill outer removal operation, outer panel is removed and then reinforcement is removed. Side sill outer can be removed without removing the outer panel if the outer panel at view C and view E are rough cut.
- View C and view E show the outer panel removed condition.

Side Sill Outer (partial replacement)

B: INSTALLATION



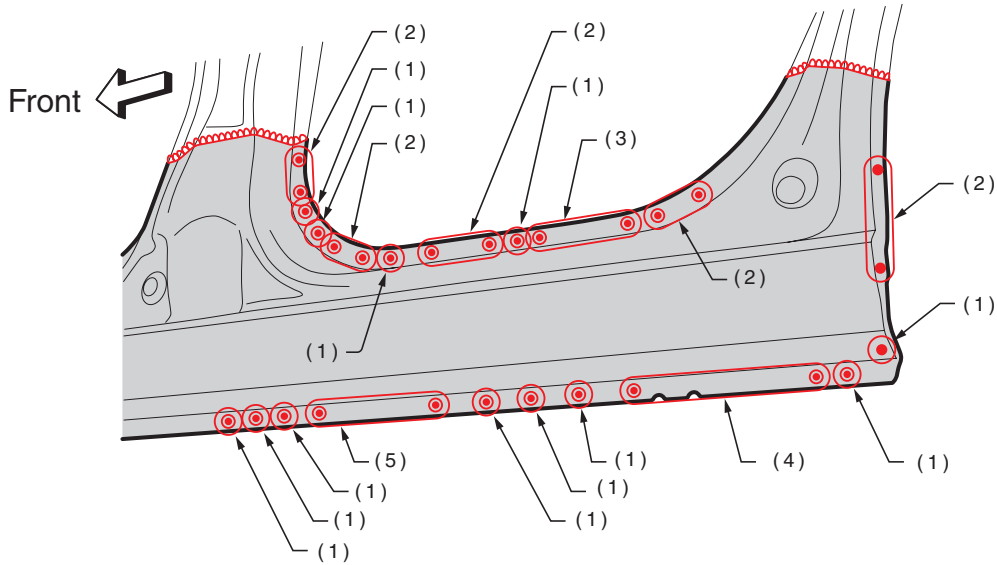
BS-03020

- | | | |
|------------------------|-----------------------------------|-------------------------|
| (1) 1 point | (6) 100 mm (3.94 in) | (11) 3 points |
| (2) 40 mm (1.57 in) | (7) 2 points (service) | (12) 4 points |
| (3) 1 point (service) | (8) 13 points (service) | (13) 9 points |
| (4) 7 points (service) | (9) 2 points (service · matching) | (14) 4 points (service) |
| (5) 8 points | (10) 2 points | |

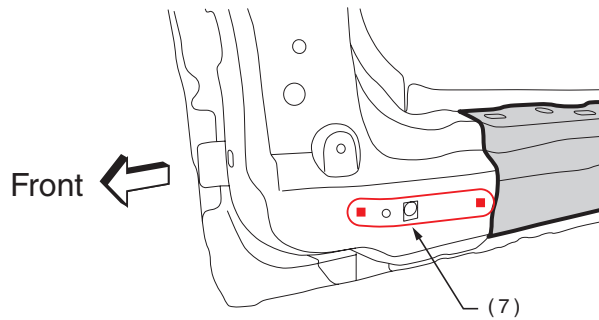
CAUTION:

For continuous welds marked by *, apply anticorrosion wax thoroughly on the reverse side.

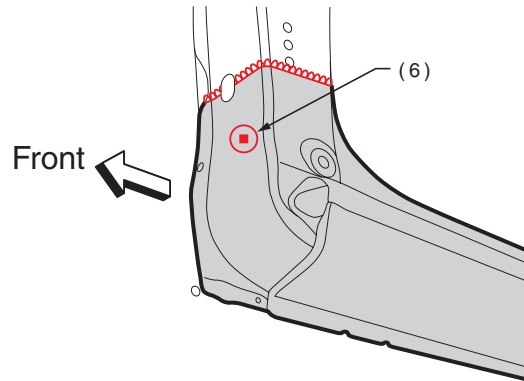
Side Sill Outer (partial replacement)



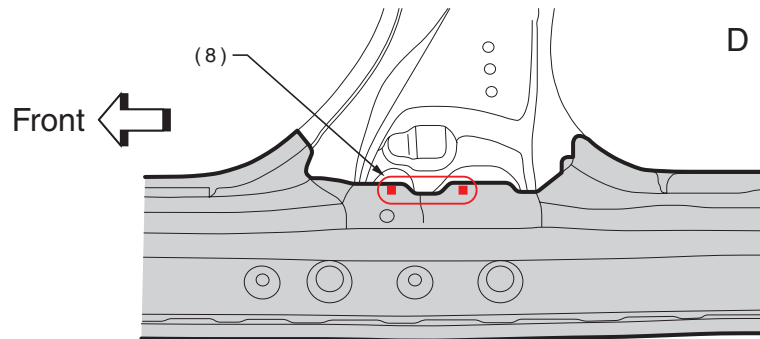
B View



C View



D View



E View

BS-03021

- (1) 1 point
- (2) 2 points
- (3) 4 points

- (4) 7 points
- (5) 5 points
- (6) 1 point (service - matching)

- (7) 3 points
- (8) 2 points (service)

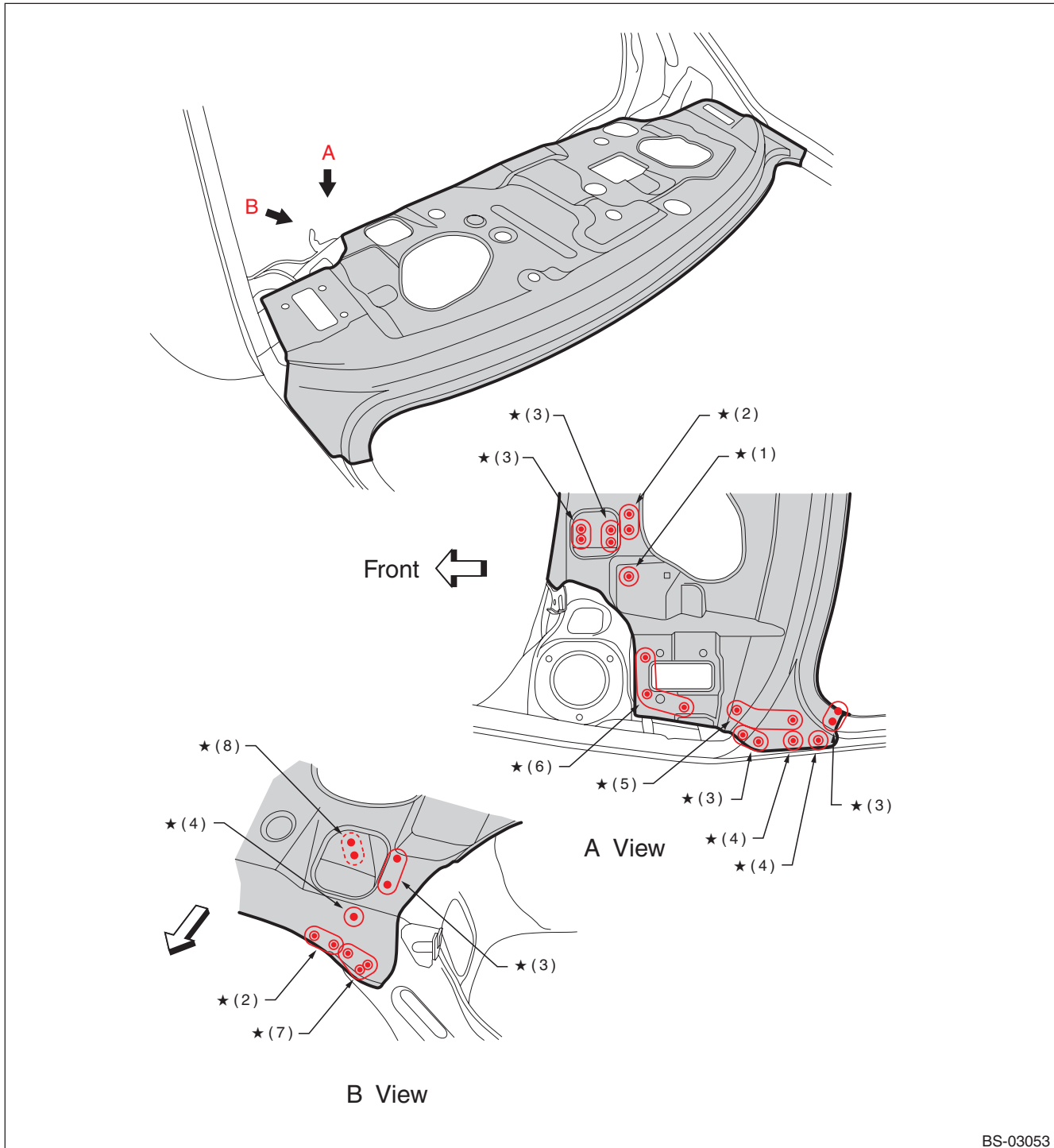
NOTE:

- In this side sill outer installation operation, side sill outer repair parts are disassembled once, and reinforcement is installed, and then outer panel is installed.
- View C and view E show the outer panel removed condition.

Rear Panel (total replacement)

29.Rear Panel (total replacement)

A: REMOVAL



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

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

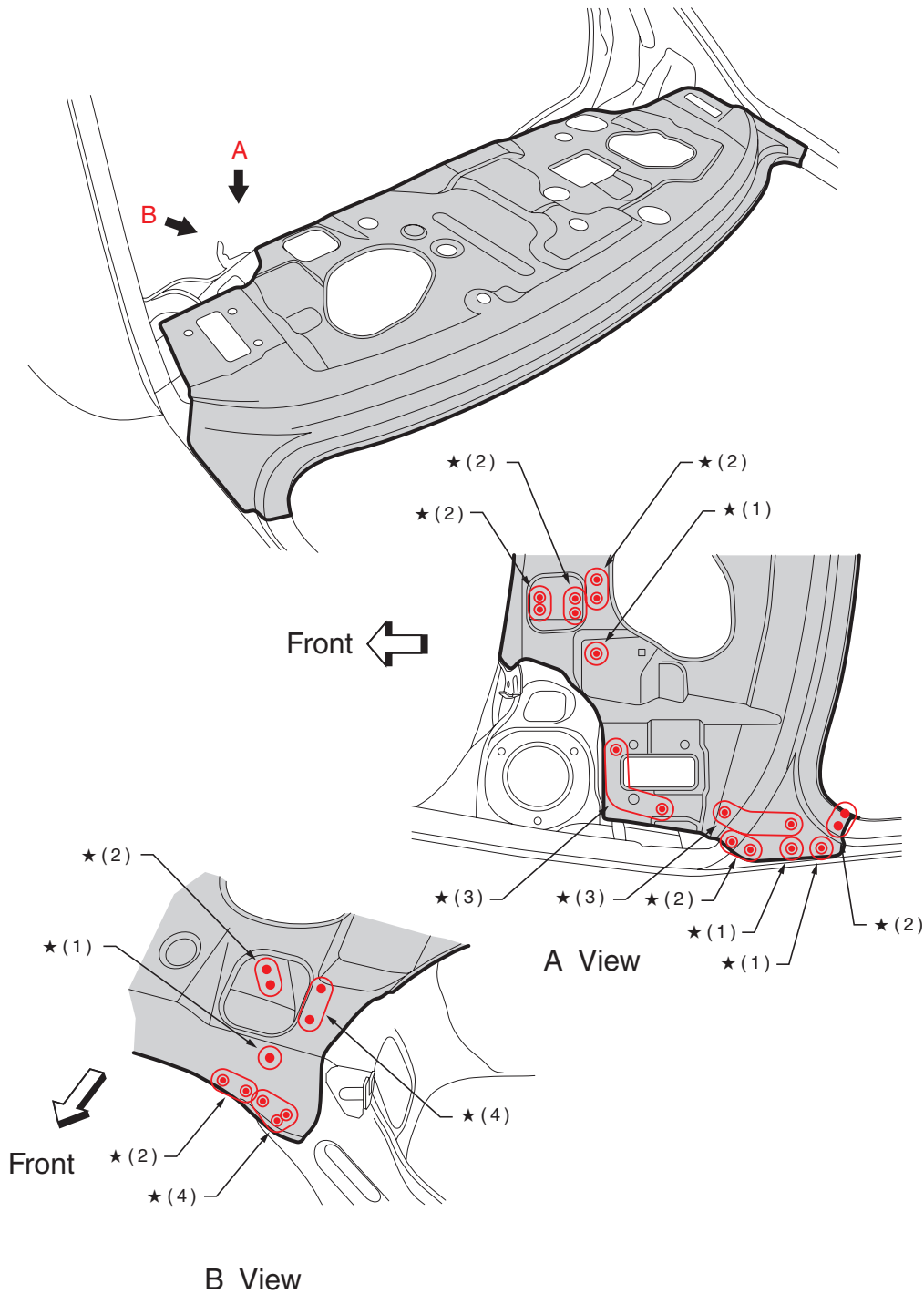
- (7) 3 points (top · 1)
- (8) 2 points (outside · 1)

NOTE:

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

Rear Panel (total replacement)

B: INSTALLATION



BS-03054

(1) 1 point
(2) 2 points

(3) 4 points

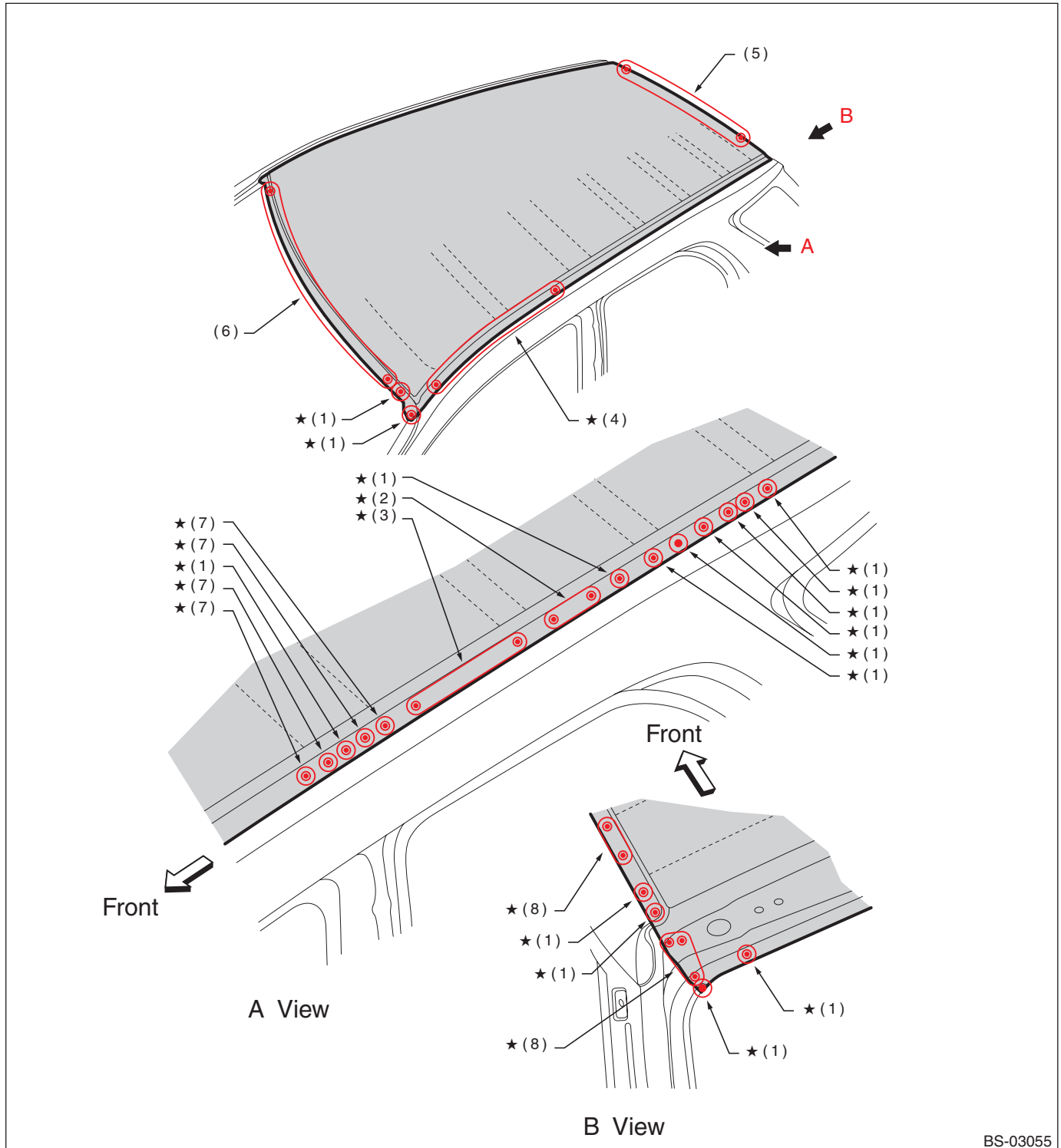
(4) 3 points

NOTE:

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

30.Roof Panel (total replacement) / Wagon

A: REMOVAL



BS-03055

Roof Panel (total replacement) / Wagon

(1) 1 point (top · 1)
(2) 2 points (top · 1)
(3) 4 points (top · 1)

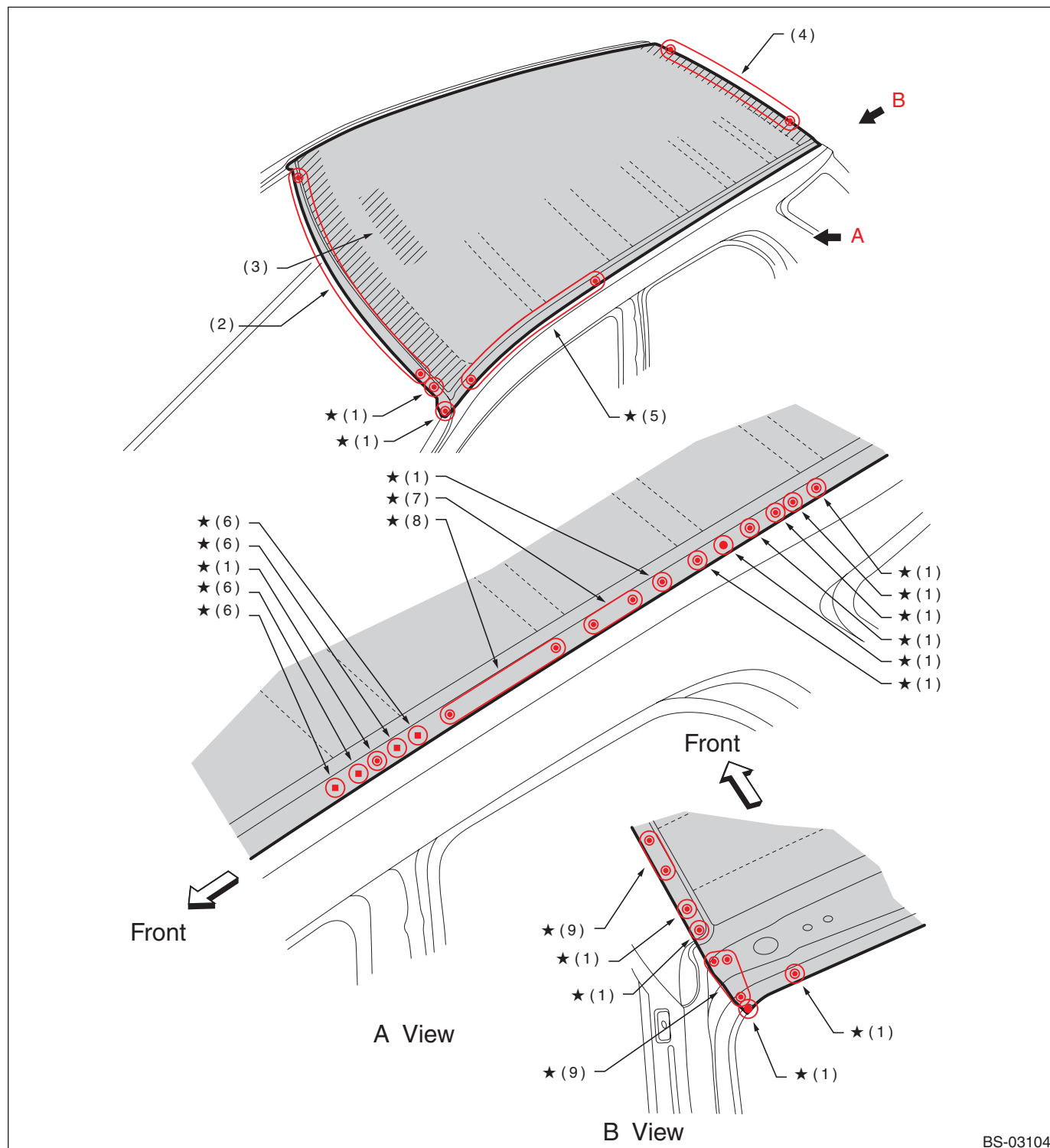
(4) 6 points (top · 1)
(5) 13 points (top · 1)
(6) 15 points (top · 1)

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

NOTE:

- For locations marked by ★, the welding method and the number of welding points are the same on the left and the right.
- Common for standard roof/sunroof

B: INSTALLATION



BS-03104

Roof Panel (total replacement) / Wagon

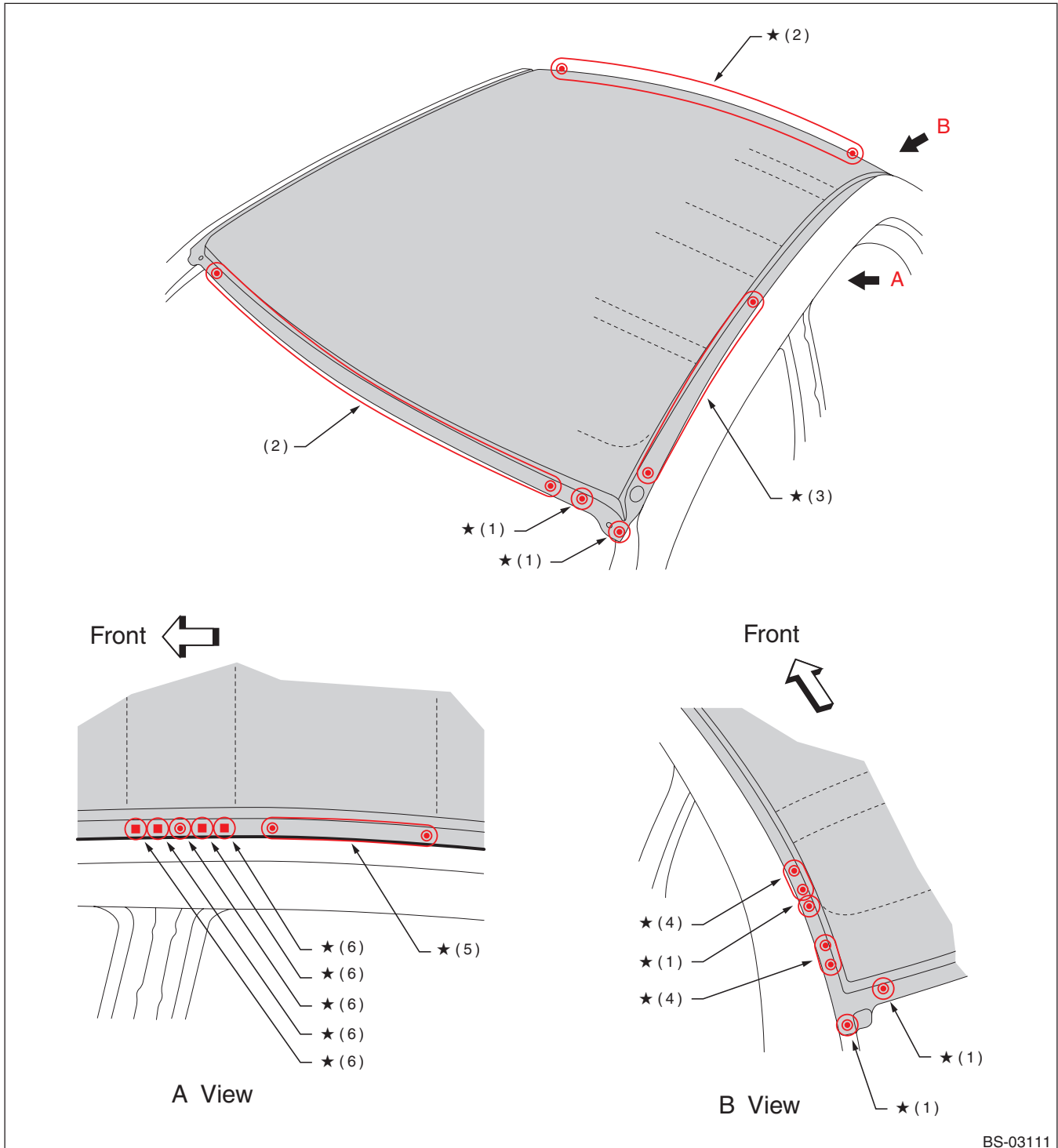
(1) 1 point	(4) 16 points	(7) 2 points
(2) 19 points	(5) 8 points	(8) 6 points
(3) Standard roof only	(6) 1 point (service)	(9) 3 points

NOTE:

- Weld the three pieces matching part with the main material when installing the side rail portion of the roof panel.
- When installing the roof panel, apply the adhesive at  point.
- Common for standard roof/sunroof
- For locations marked by ★, the welding method and the number of welding points are the same on the left and the right.

31.Roof Panel (total replacement) / Sedan

A: REMOVAL



BS-03111

(1) 1 point (top · 1)
(2) 15 points (top · 1)

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

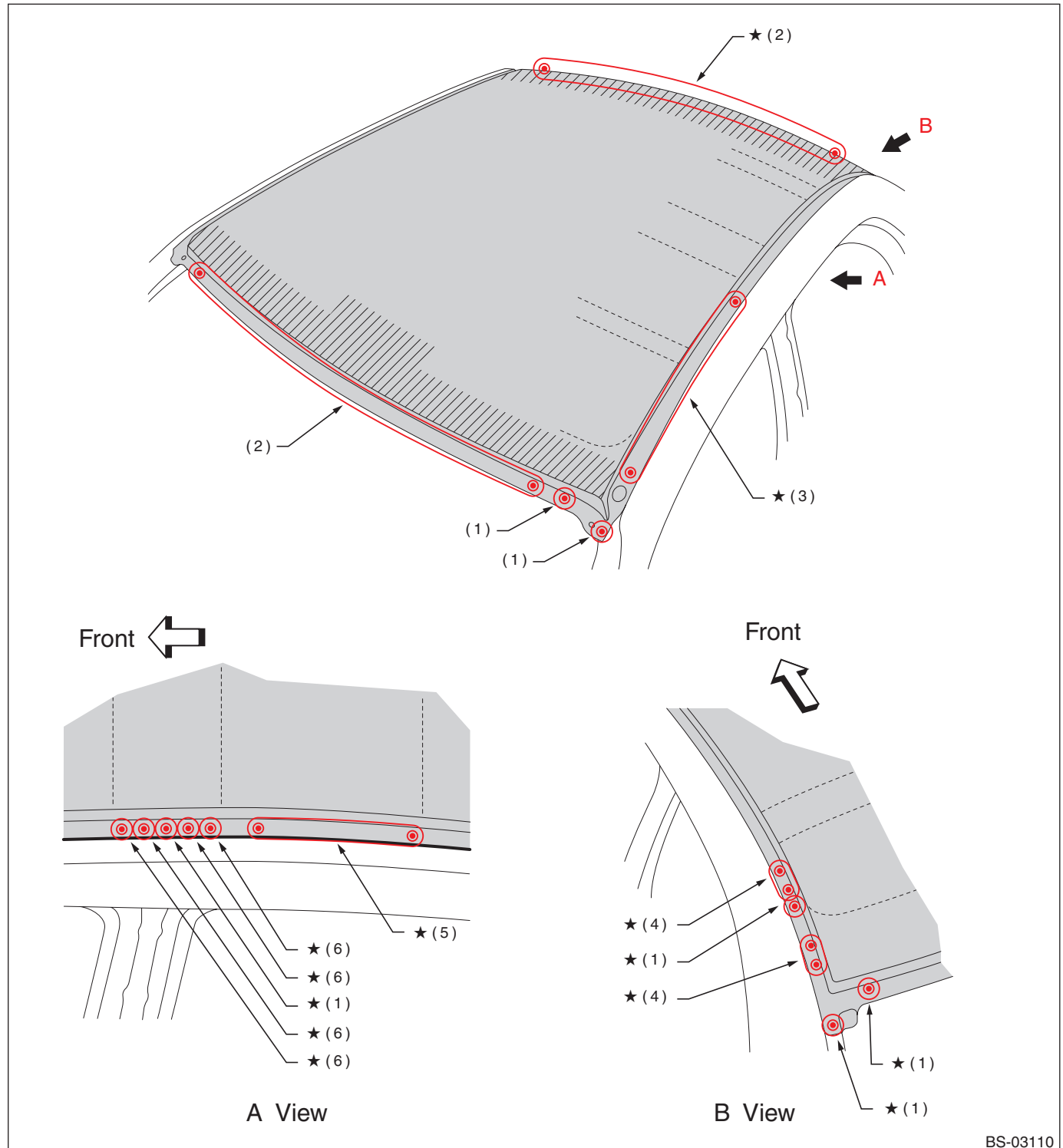
(5) 5 points (top · 1)
(6) 1 point (top · 2)

NOTE:

- For locations marked by ★, the welding method and the number of welding points are the same on the left and the right.
- View A shows the center pillar.

Roof Panel (total replacement) / Sedan

B: INSTALLATION



Roof Panel (total replacement) / Sedan

(1) 1 point
(2) 19 points

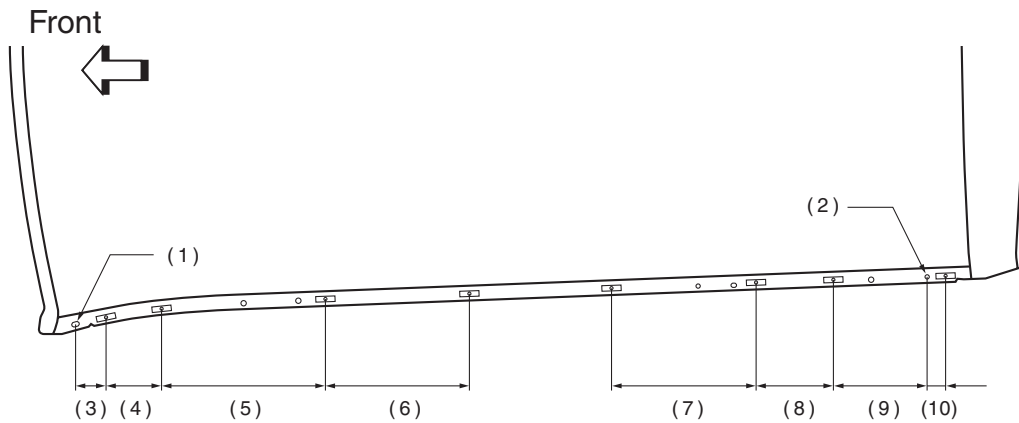
(3) 6 points
(4) 2 points

(5) 5 points
(6) 1 point (service)

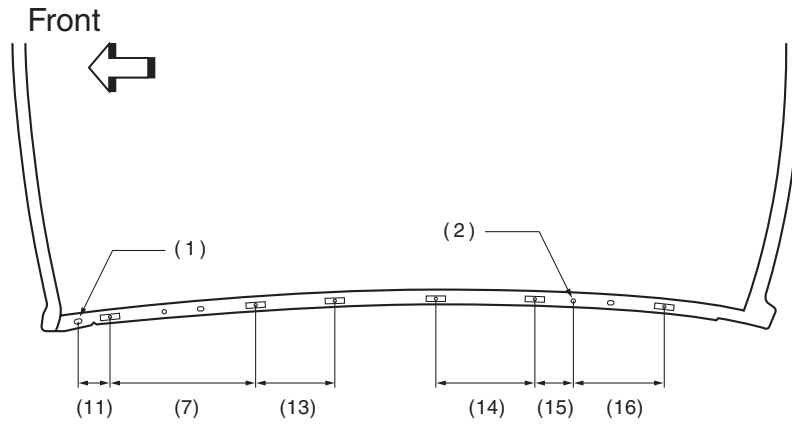
NOTE:

- Weld the three pieces matching part with the main material when installing the side rail portion of the roof panel.
- For locations marked by ★, the welding method and the number of welding points are the same on the left and the right.
- When installing the roof panel, apply the adhesive at  point.
- View A shows the center pillar.

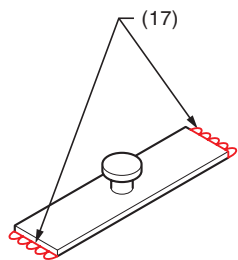
32.Roof Panel / T-stud



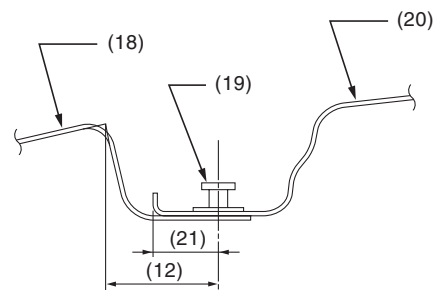
A



B



C



D

BS-03058

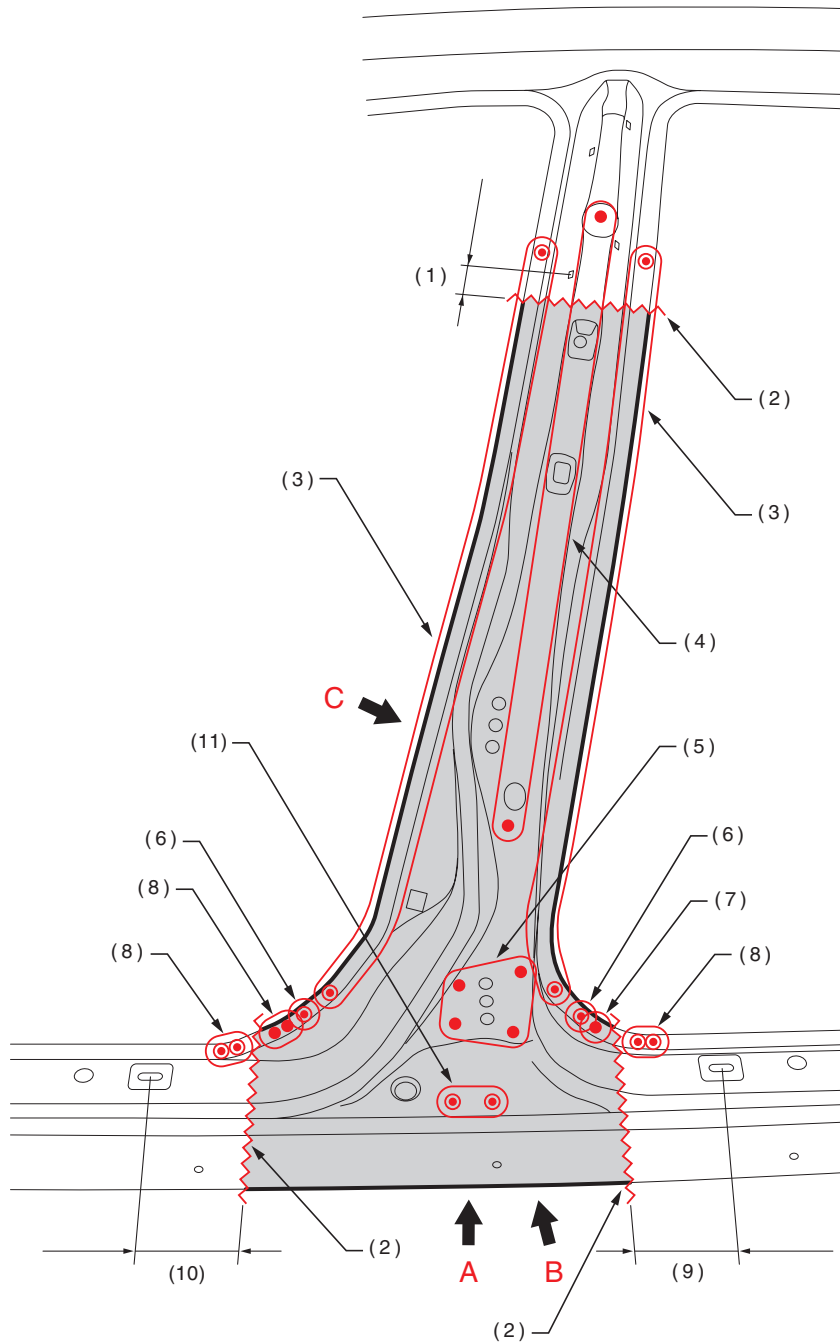
Roof Panel / T-stud

(A) Wagon installation position	(C) T-stud welding (common for wagon · sedan)	(D) T-stud basic cross section (common for wagon · sedan)
(B) Sedan installation position		
(1) 8 × 12 mm (0.31 × 0.47 in) elongated hole (grommet installation hole)	(7) 250 mm (9.84 in)	(15) 69 mm (2.72 in)
(2) ø6.5 mm (0.26 in) hole (roof rail installation hole)	(8) 135 mm (5.31 in)	(16) 156 mm (6.14 in)
(3) 52 mm (2.05 in)	(9) 165 mm (6.50 in)	(17) 2 points
(4) 95 mm (3.74 in)	(10) 33 mm (1.30 in)	(18) Side panel
(5) 286 mm (11.26 in)	(11) 55 mm (2.05 in)	(19) T-stud
(6) 249 mm (9.69 in)	(12) 18 mm (0.71 in)	(20) Roof panel
	(13) 140 mm (5.51 in)	(21) 10 mm (0.39 in)(reference dimension)
	(14) 175 mm (6.89 in)	

Center Pillar Outer (partial replacement)

33.Center Pillar Outer (partial replacement)

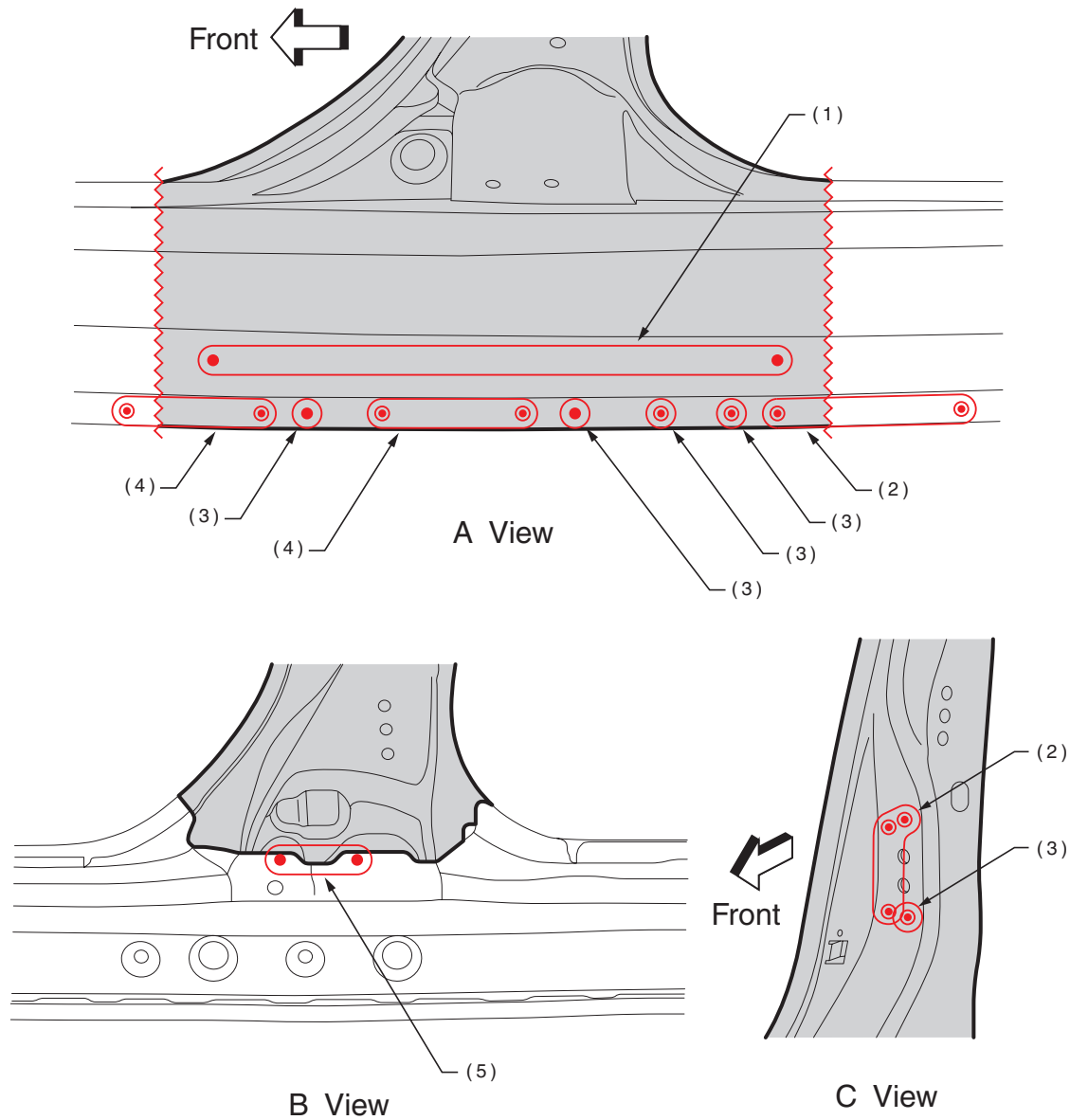
A: REMOVAL



BS-03014

- | | | |
|-----------------------------|----------------------------|-----------------------------|
| (1) 25 mm (0.98 in) | (5) 4 points (outside · 1) | (9) 100 mm (3.94 in) |
| (2) Rough cutting | (6) 1 point (outside · 2) | (10) 110 mm (4.33 in) |
| (3) 20 points (outside · 2) | (7) 1 point (outside · 1) | (11) 2 points (outside · 2) |
| (4) 6 points (outside · 1) | (8) 2 points (outside · 1) | |

Center Pillar Outer (partial replacement)



BS-03015

(1) 5 points (outside · 1)
(2) 3 points (outside · 1)

(3) 1 point (outside · 1)
(4) 3 points (outside · 2)

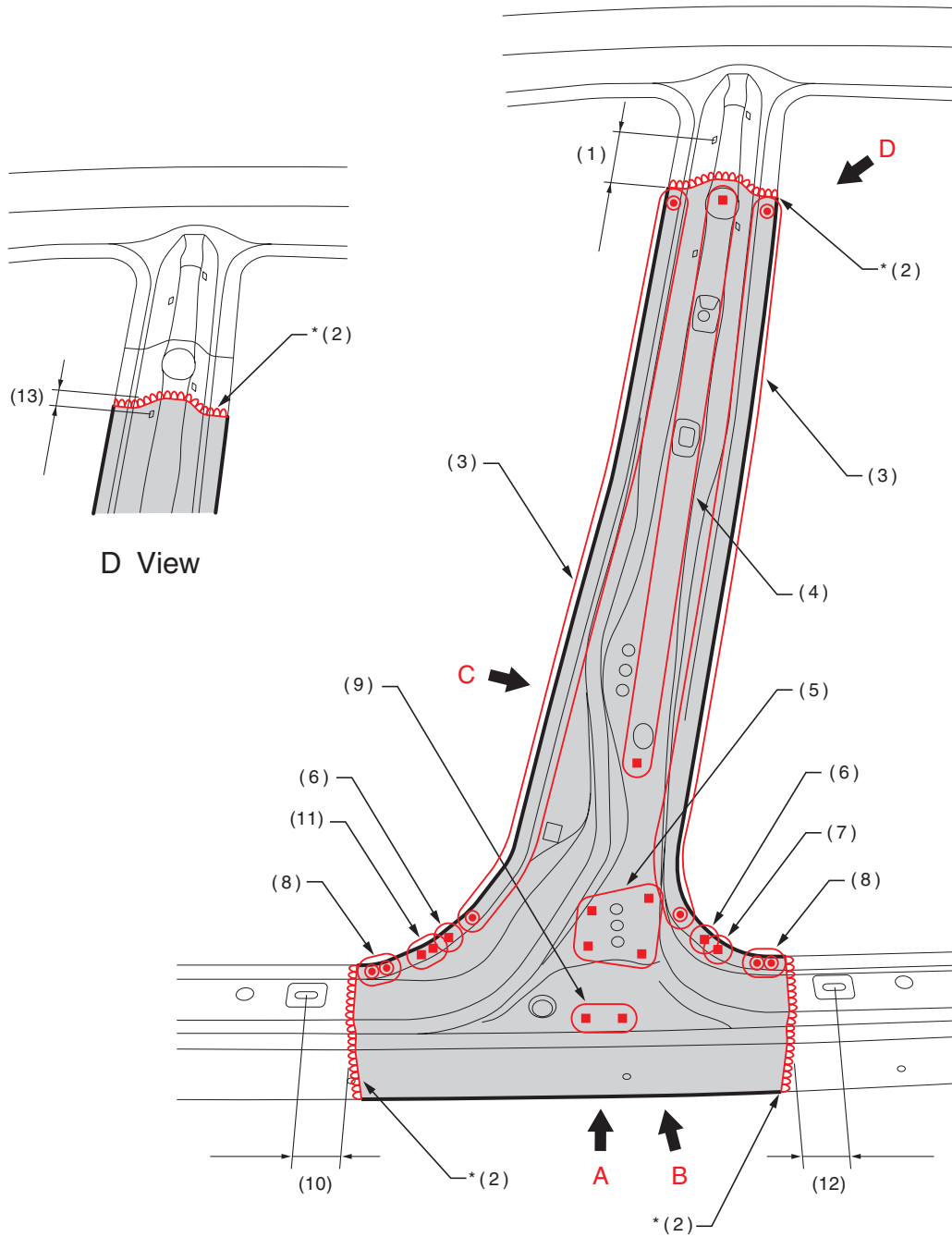
(5) 2 points (outside · 1)

NOTE:

- In this center pillar removal operation, outer panel is removed and then reinforcement is removed. Center pillar can be removed without removing the outer panel if the outer panel at view B hidden hit point is opened.
- View B shows the outer panel removed condition.

Center Pillar Outer (partial replacement)

B: INSTALLATION



BS-03016

Center Pillar Outer (partial replacement)

(1) 40 mm (1.57 in)	(6) 1 point (service · matching)	(11) 2 points (service)
(2) 1 point	(7) 1 point (service)	(12) 60 mm (2.36 in)
(3) 24 points	(8) 2 points	(13) 15 mm (0.59 in)
(4) 6 points (service)	(9) 2 points (service · matching)	
(5) 4 points (service)	(10) 70 mm (2.76 in)	

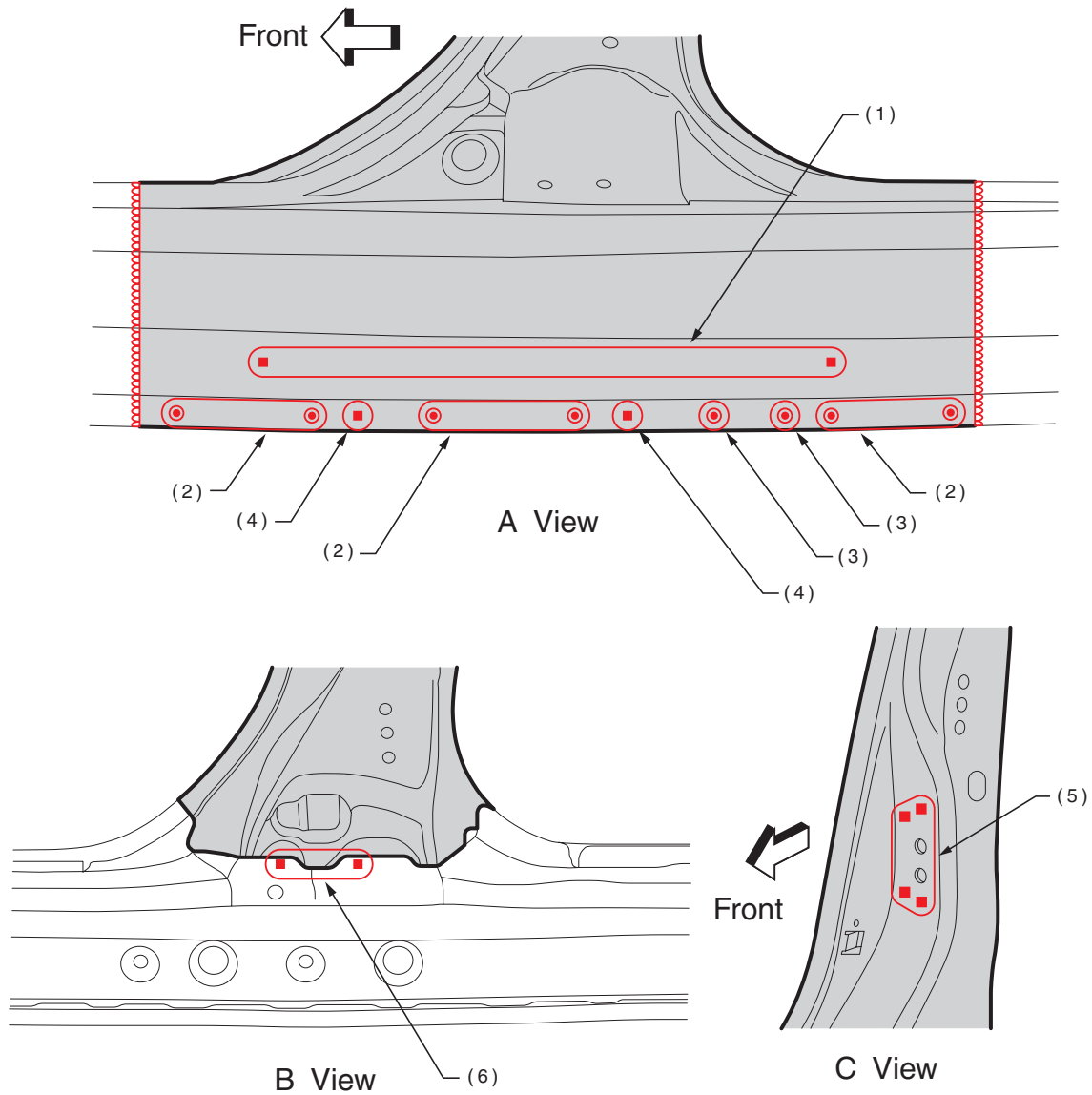
CAUTION:

For continuous welds marked by *, apply anticorrosion wax thoroughly on the reverse side.

NOTE:

View D shows the outer panel removed condition.

Center Pillar Outer (partial replacement)



BS-03017

(1) 5 points (service)
(2) 4 points

(3) 1 point
(4) 1 point (service)

(5) 4 points (service)
(6) 2 points (service)

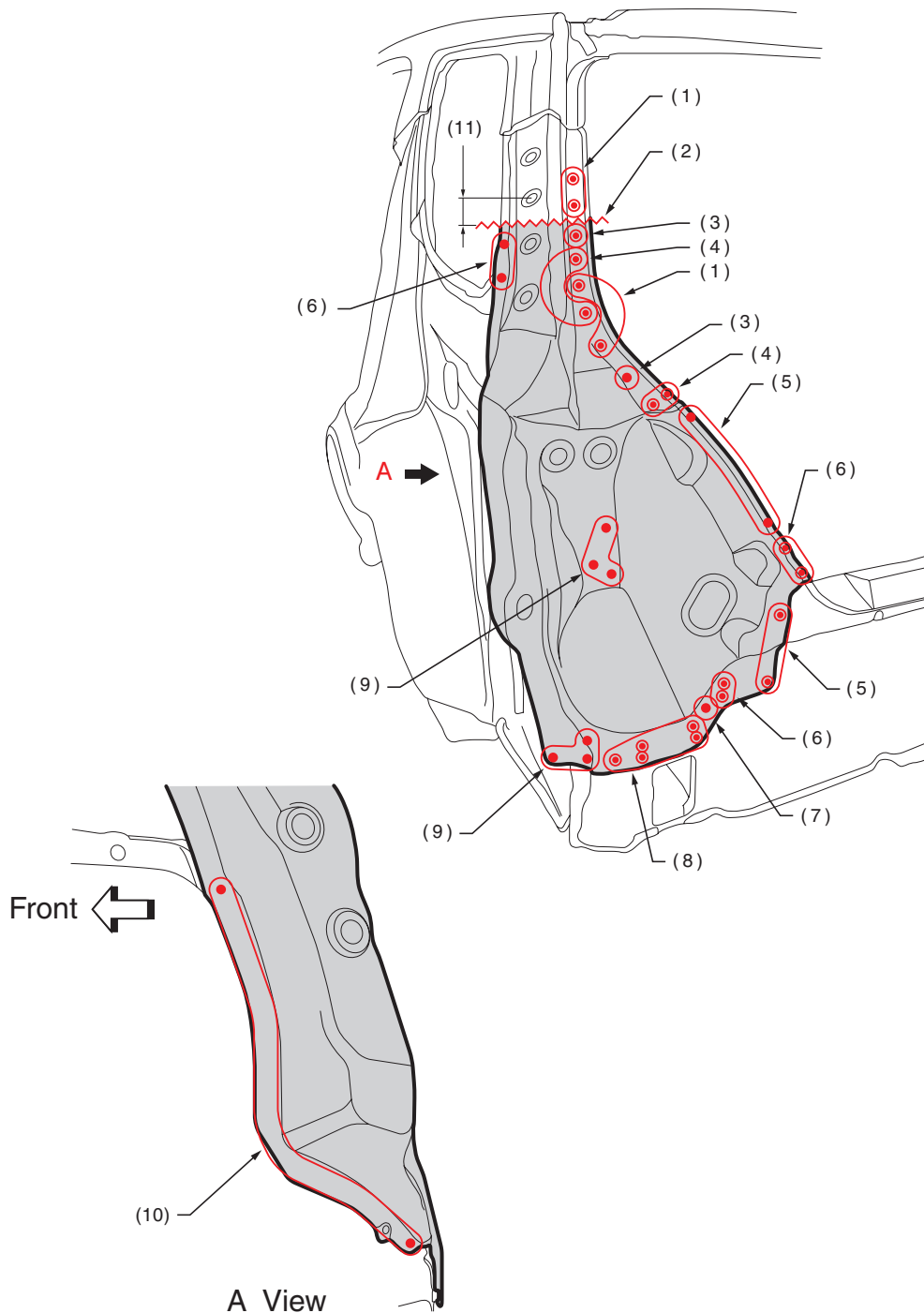
Center Pillar Outer (partial replacement)

NOTE:

- Install the center pillar outer with the following procedures.
 1. Remove the outer panel from the center pillar outer repair parts once.
 2. Remove the side sill reinforcement.
 3. After installing the center pillar reinforcement, re-install the outer panel that was removed before.
- Refer to the “side sill outer” section about the parts replacement including the side sill reinforcement.
- When replacing the center pillar outer including the side sill reinforcement, the replacement that doesn't remove the outer panel and side sill reinforcement from the center pillar outer repair parts is recommended.
- View B shows the outer panel removed condition.

34.D-pillar Reinforcement (partial replacement) / Wagon

A: REMOVAL



BS-03026

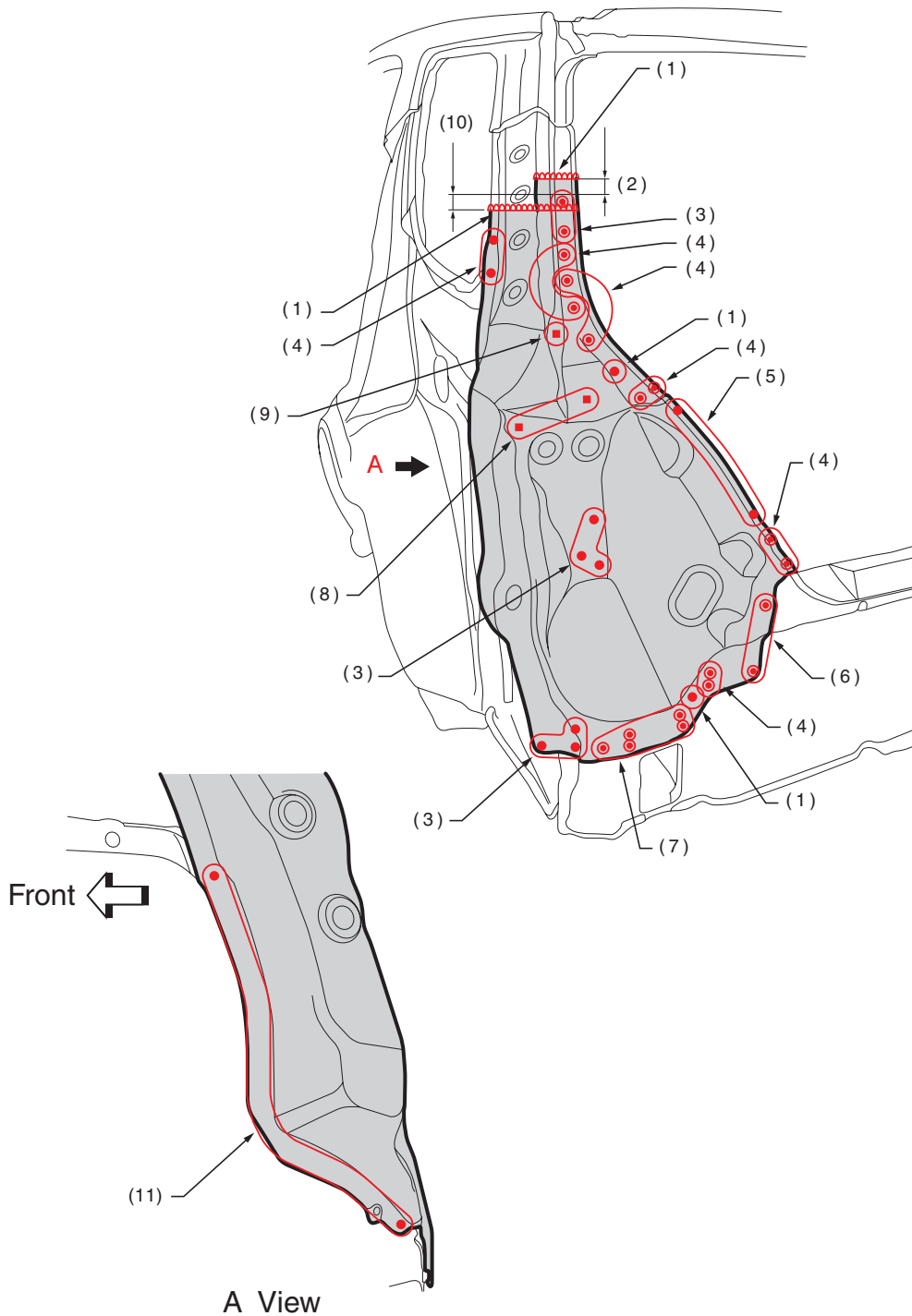
- | | | |
|------------------------|----------------------------|-----------------------------|
| (1) 2 points (top · 1) | (5) 4 points (outside · 1) | (9) 3 points (outside · 1) |
| (2) Rough cutting | (6) 2 points (outside · 1) | (10) 9 points (outside · 1) |
| (3) 1 point (top · 1) | (7) 1 point (outside · 1) | (11) 40 mm (1.57 in) |
| (4) 2 points (top · 2) | (8) 5 points (outside · 1) | |

NOTE:

The illustration shows the rear quarter removed condition.

D-pillar Reinforcement (partial replacement) / Wagon

B: INSTALLATION



BS-03027

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

NOTE:

- The illustration shows the rear quarter removed condition.
- After installing the D-pillar reinforcement, install the D-pillar extension.

