

BODY REPAIR MANUAL

BS

	Page
1. Foreword	3
2. Panel Components.....	16
3. Galvanized Sheet Metal	39
4. Body Construction.....	42
5. Body Reference Points.....	49
6. Measurement for combined parts	74
7. Panel Replacement.....	76
7-1. Radiator Panel (total replacement)	76
7-2. Front Wheel Apron (total replacement)	82
7-3. Front Wheel Apron RH (partial replacement)/Hybrid Model	92
7-4. Front Wheel Apron RH (total replacement)/Hybrid Model	96
7-5. Closing Plate (partial replacement)	98
7-6. Front Side Frame (total replacement)	102
7-7. Front Side Frame (partial replacement).....	110
7-8. Toe Board Reinforcement (total replacement).....	114
7-9. Front Pillar (partial replacement)	118
7-10. Center Pillar (partial replacement).....	126
7-11. Side Sill (partial replacement)	136
7-12. Rear Quarter (partial replacement)/5 Door	142
7-13. D-pillar Extension Quarter End (partial replacement) / 5 Door.....	148
7-14. Rear Wheel Apron (total replacement)	150
7-15. Rear Quarter Inner (partial replacement)	158
7-16. Rear Quarter (partial replacement) / 4 Door	166
7-17. Rear Quarter End Panel (total replacement) / 4 Door	174
7-18. Rear Quarter Inner Reinforcement (total replacement) / 4 Door	176
7-19. Rear Quarter Inner Upper (total replacement) / 4 Door.....	178
7-20. Rear Panel (total replacement) / 4 Door	182
7-21. Side Sill Inner Rear (total replacement)	186
7-22. Rear Skirt (total replacement) / 5 Door.....	192
7-23. Rear Skirt (total replacement) / 4 Door.....	196
7-24. Rear Floor Pan (partial replacement)/5 Door/Except fro Hybrid Model	198
7-25. Rear Floor Pan (partial replacement)/5 Door/Hybrid Model	200
7-26. Rear Floor Pan (partial replacement) / 4 Door	204
7-27. Rear Floor Side (total replacement) / 5 Door	206
7-28. Rear Floor Side (total replacement) / 4 Door	210
7-29. Rear Side Frame Upper RH / Hybreid Model	214
7-30. Rear Side Frame Upper Rear (total replacement) / 5 Door	216
7-31. Rear Side Frame Upper Rear (total replacement) / 4 Door	222
7-32. Rear Side Frame Lower Rear (total replacement).....	224
7-33. Closing Plate (total replacement)	226
7-34. Rear Frame (total replacement)	228
7-35. Roof Center Brace (total replacement).....	232
7-36. Roof Panel (total replacement) / 5 Door	236

7-37.	Roof Panel (total replacement) / 4 Door	240
7-38.	T Stud Installation.....	244
8.	Body Sealing	246
9.	Anticorrosion Wax	253
10.	Undercoat	259
11.	Damping seat.....	265
12.	Insulator	267
13.	Plastic Parts and Materials	270
14.	List of Plastic Material Notations.....	274

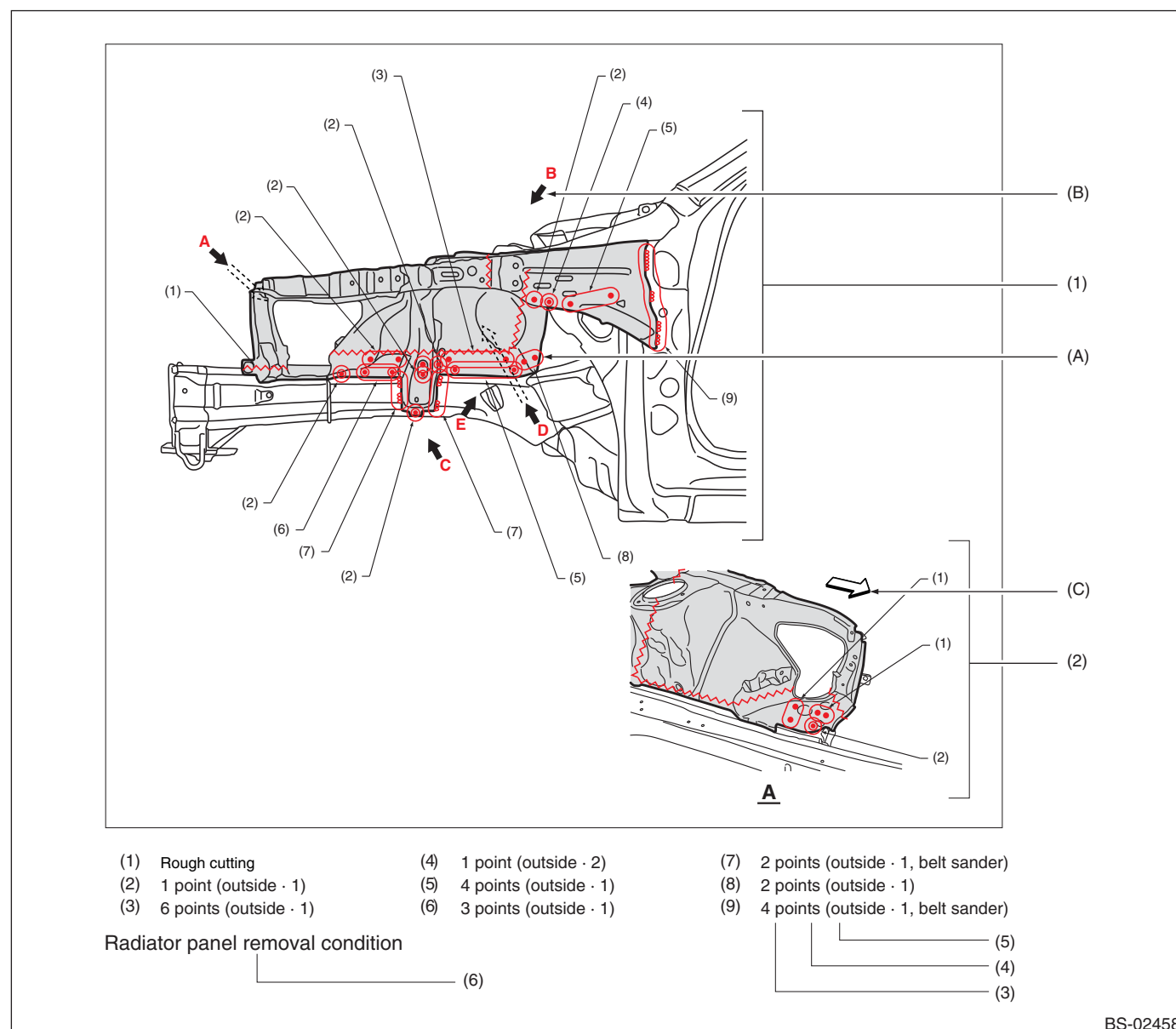
1. Foreword

A: USE OF THIS MANUAL

This manual explains the points to be observed during removal and installation of parts separately by location.

1. ILLUSTRATION EXAMPLE

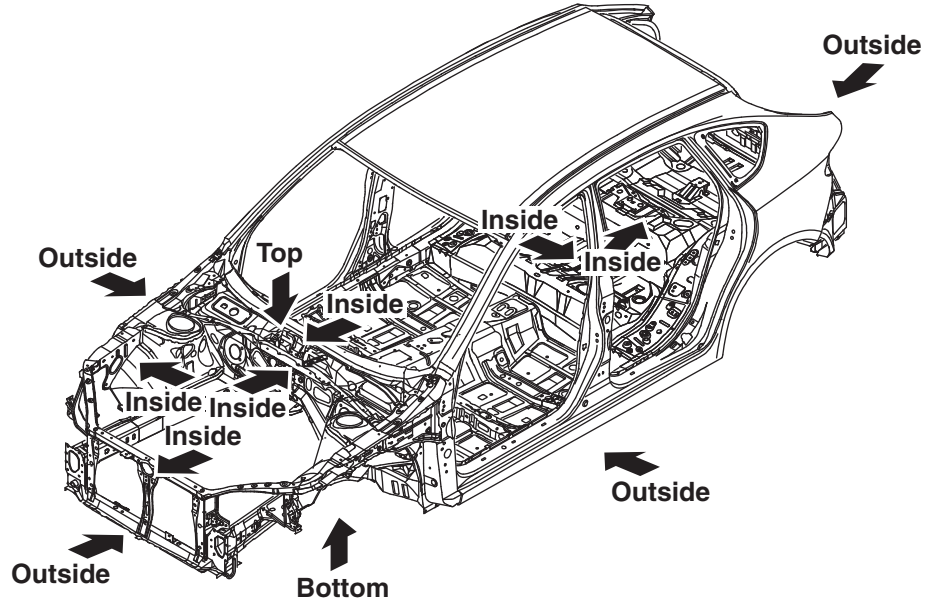
- Symbols and number of points indicate the welding method and the number of welding points. Text in brackets indicates the direction for removal of welded parts, and numbers indicate the number of plates to be drilled in panels of welded parts to be removed.
- An enclosure by a broken line indicates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



- | | |
|------------------------------------|--|
| (1) Overall view | (A) Welding method |
| (2) View | (B) View direction |
| (3) Number of welding points etc. | (C) Direction towards the front of the vehicle |
| (4) Removal direction | |
| (5) Number of plates to be drilled | |
| (6) Cautions for the work etc. | |

2. REMOVAL DIRECTION

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

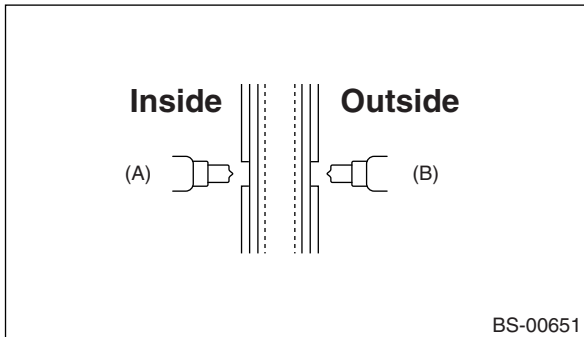


BS-02459

3. NUMBER OF PANELS TO BE DRILLED

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

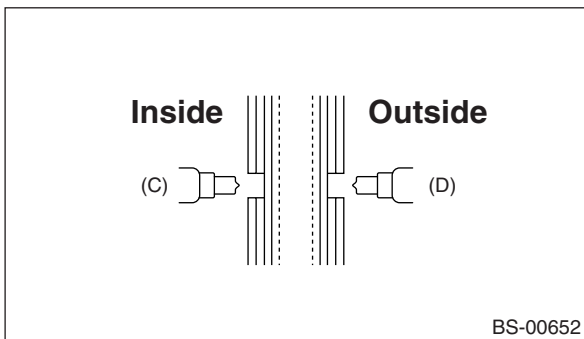
(1) Drilling through one plate



(A) (Inside · 1)

(B) (Outside · 1)

(2) Drilling through two plates

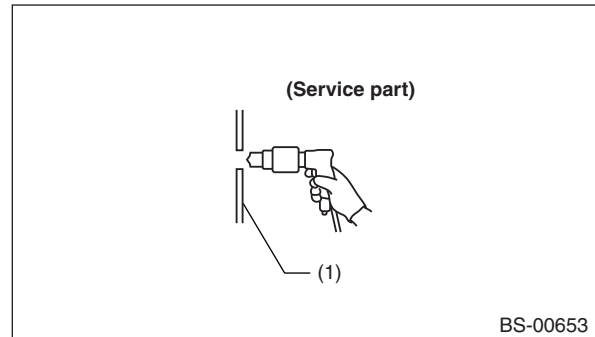


(C) (Inside · 2)

(D) (Outside · 2)

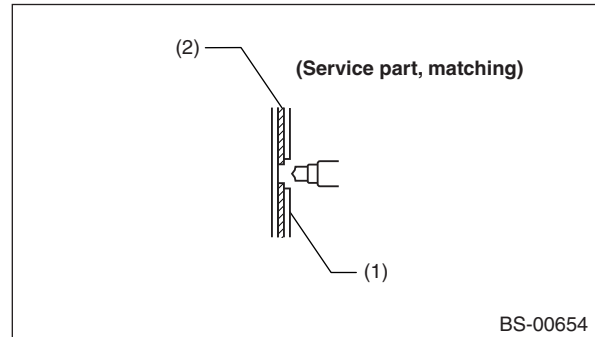
4. HOLE DRILLING FOR PLUG WELDING

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



(1) Service part

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



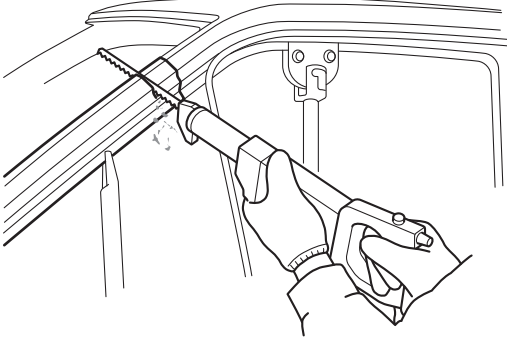
(1) Vehicle side

(2) Service part

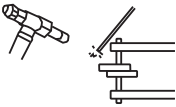
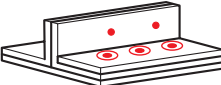
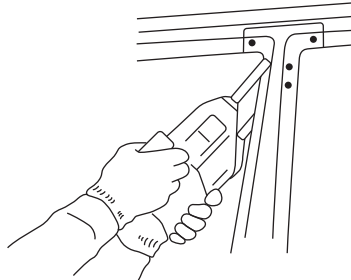
Foreword

5. MEANING OF SYMBOLS

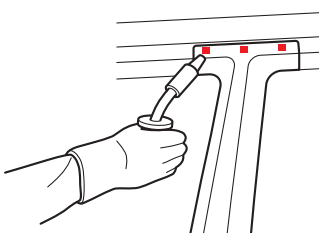
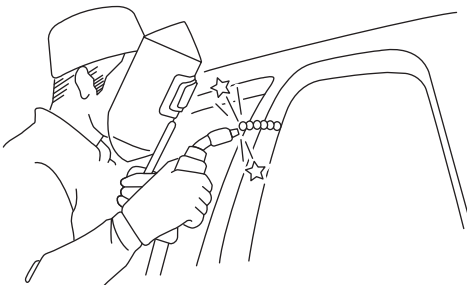
• Cutting

	
BS-00352	BS-00267

• Spot welding

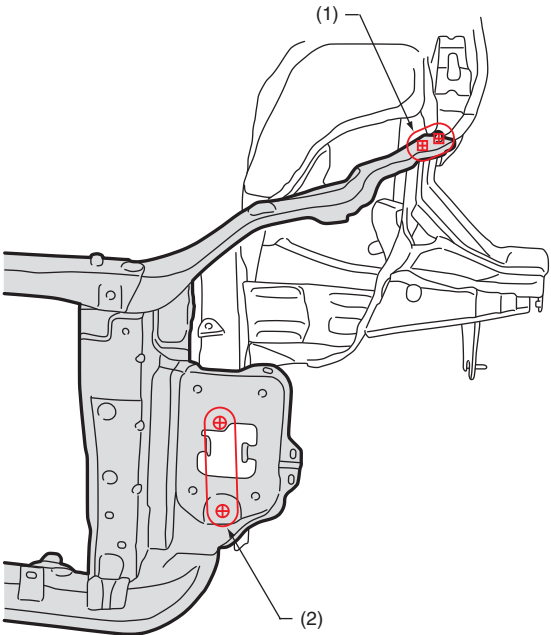
Two overlapping parts	 BS-00655	 BS-00656	 BS-00657	 BS-00658
Three or more overlapping parts	 BS-00659	 BS-00660		

• Carbon dioxide gas arc welding (MIG welding)

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

Foreword

- Bolt, nut tightening portion

Bolt	 BS-04481	 BS-04483
Nut	 BS-04482	

B: CAUTION

Since there is a possibility that the required strength will not be obtained, an inverter welder must be used for spot-welding at locations where high-strength steel is used.

C: PRECAUTION FOR HANDLING HIGH VOLTAGE (Only for Hybrid Model)

1. PRECAUTIONS FOR MAINTENANCE

The hybrid system includes a high voltage circuit. Mishandling may cause electric shocks and leakage. Therefore, perform proper operations by following procedures in this manual.

HIGH VOLTAGE CAUTION LABEL

- Before working on the HEV, the vehicle should be marked with a caution sign.

Foreword

- Copy this page, fold along the perforation and put it on the roof of the vehicle in service before performing any service on the HEV system.

HIGH VOLTAGE CAUTION LABEL

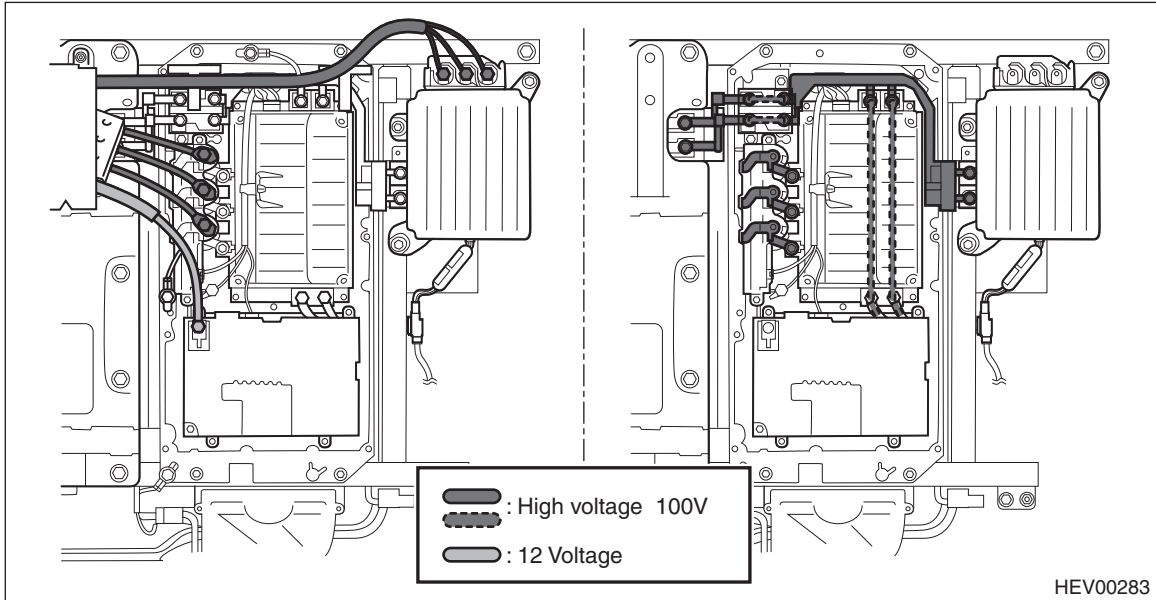
Person in charge: _____ CAUTION: HIGH VOLTAGE. DO NOT TOUCH DURING OPERATION 	
	CAUTION: HIGH VOLTAGE. DO NOT TOUCH DURING OPERATION Person in charge: _____
Copy this page and put it after folding on the roof of the vehicle in service.	

HEV00088

- Only technicians who have received the Subaru training for HEV Systems should be allowed to perform service or maintenance of high voltage circuits.
- All the harnesses and connectors for power cables are orange in color. In addition, caution labels indicating [High Voltage] are attached on the High voltage battery and its battery cover. Do not touch the wires and parts related to high voltage without proper PPE (Personal Protective Equipment) and extreme caution.

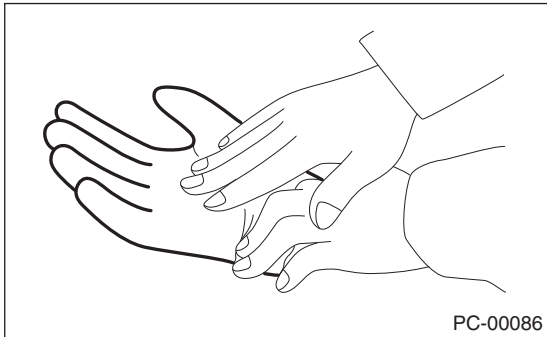
Foreword

- Use great care when handling the high voltage system power supply circuits shown in the figure below.



PERSONAL PROTECTIVE EQUIPMENT (PPE)

- Always wear PPE which is in good condition when working on the HEV system. Never touch any high voltage terminals or components without proper PPE.
- Personal Protective Equipment consists of insulated rubber gloves, protective goggles, rubber boots or insulated protective shoes or insulating rubber sheet for the shop floor.
- Always check the insulated gloves for holes or damage before starting work. To check for leaks, create a tight seal around your wrist with the glove gauntlet, and squeeze the glove to confirm that the trapped air does not leak, indicating a hole in the insulating material.



- Never use wet insulated gloves.

NOTE:

Maintenance of the high voltage battery cooling fan and cooling duct parts outside the battery cover, and drive motor control module parts does not require you to wear PPE, even in the compartment, because the voltage is only 12 V.

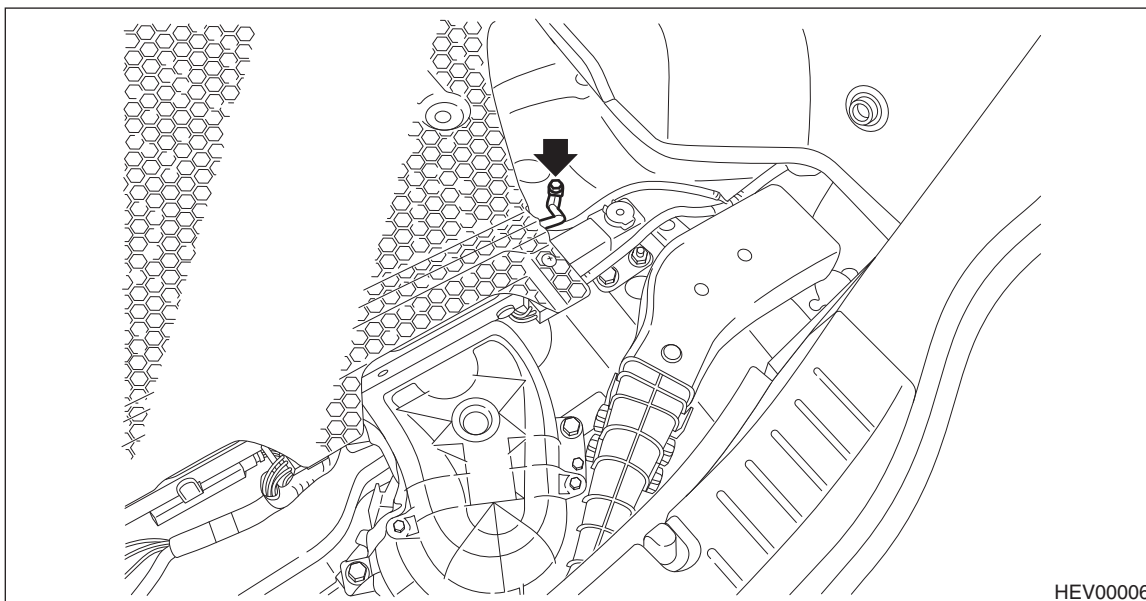
PPE is not required for maintenance or service of engine compartment and CVT unit, except for the power cables (orange in color).

Foreword

PROPER WORK PROCEDURES

In addition to PPE, other precautions must be observed when working on the HEV system since parts with high voltage and strong magnetic force are used.

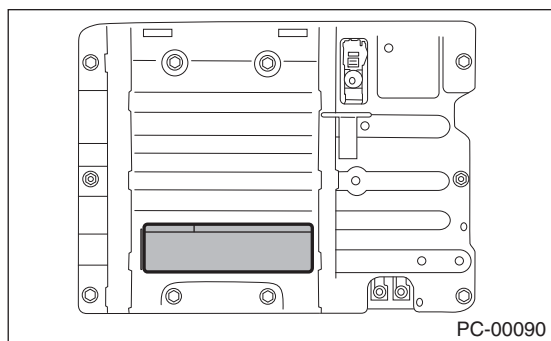
- Do not carry any metallic products, such as mechanical pencils and rulers, etc., which may be dropped and cause a short circuit.
- Do not wear any metallic objects such as belts or buckles, chains, etc.
- The strong magnetic force can damage or erase magnetic recording media (such as cash cards and pre-paid cards), etc.
- Always confirm that the voltage at any high voltage terminal is at 0 V using an Insulation multimeter before beginning work.
- To work on the high voltage wire connections, always use insulated tools. If insulated tools are not available, wrap tools with electrical tape for insulation before use.
- When using tools wrapped with electrical tape as alternatives to insulated tools, confirm the insulated condition before working, using a Insulation multimeter.
- Make sure to maintain the proper polarity of the positive and negative terminal connections during the high voltage battery removal and installation procedures.
- Never connect the high voltage battery in reverse polarity. Otherwise, the control module will be broken instantly, and other parts will also be damaged.
- Do not disconnect the battery terminals while the engine is running. A large counter electromotive force will be generated, and this voltage may damage electronic parts such as control modules.
- When disconnecting the connectors of the electrical components, always be sure to turn the ignition switch to OFF. Perform the Clear Memory Mode after connecting the connectors.
- When measuring the voltage or resistance of individual sensors or all control modules, use a tapered pin with a diameter of less than 0.6 mm (0.024 in). Do not insert the pin 4 mm (0.16 in) or more into the part.
- Take care not to allow water to get into the connectors when servicing or washing the vehicle in rainy weather. Avoid exposure to water even if the connectors are waterproof.
- Use the engine ground terminal or engine assembly for the grounding point when measuring the voltage and resistance in engine compartment.
- Use the body ground bolt on the inverter frame as the grounding point, when measuring voltage and resistance in rear of the vehicle.



- All parts related to the hybrid system are precision parts. Do not drop or otherwise apply impact. Do not reuse the parts that are dropped accidentally.
- Each warning light may illuminate during or after the diagnosis. However, this does not indicate a system malfunction. After the hybrid system diagnosis, perform Clear Memory Mode.
- Take the ignition key or access key out of the vehicle, except when the key is needed inside.

Foreword

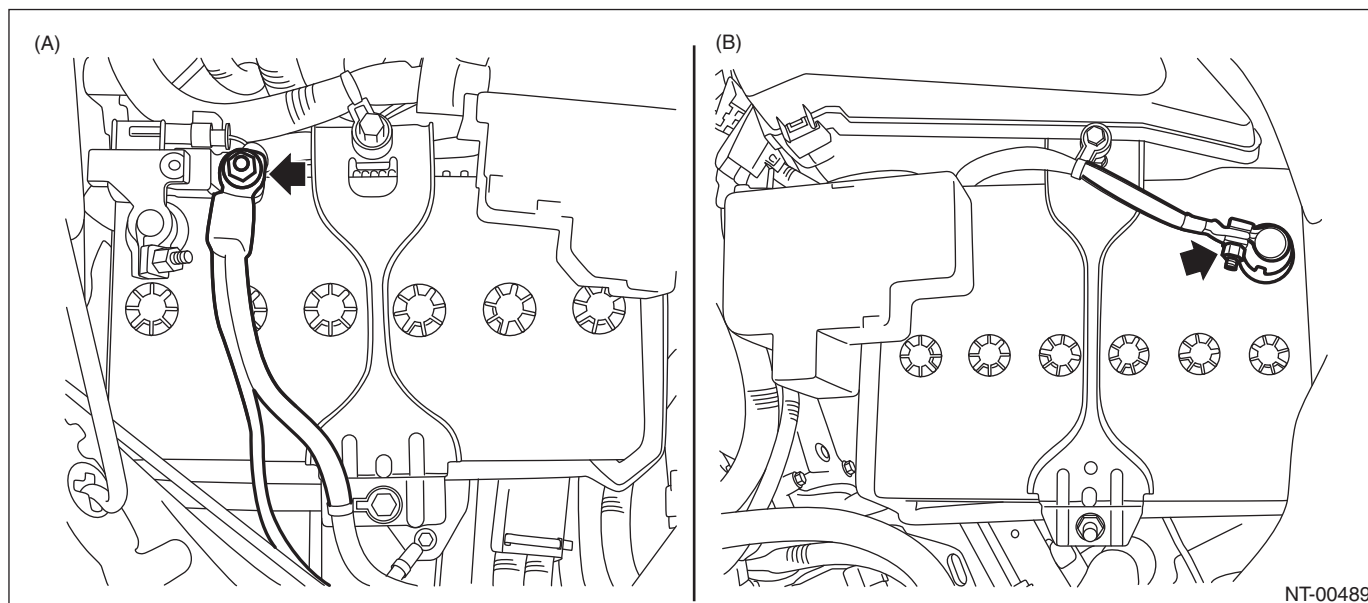
- When the part is replaced or the label is detached, make sure to attach a new label in the original position and direction. Many of the HEV components are labeled with caution warnings.



- This engine starts and stops automatically, when the Hybrid READY indicator light in the meter illuminates. Make sure to turn the ignition to OFF before performing maintenance.

2. SERVICE DISCONNECT PLUG REMOVAL

- Always remove the Service disconnect plug before beginning work on the HEV system.
 - The ignition must be OFF before removing the Service disconnect plug.
 1. Turn off the ignition switch and remove the key, or move the remote transmitter away from the vehicle.
 2. Confirm that the READY light is not illuminated.
- 1) Remove the ground terminal from the 12 volt auxiliary battery.
 - 2) Remove the ground terminal from the 12 volt engine restart battery sensor.



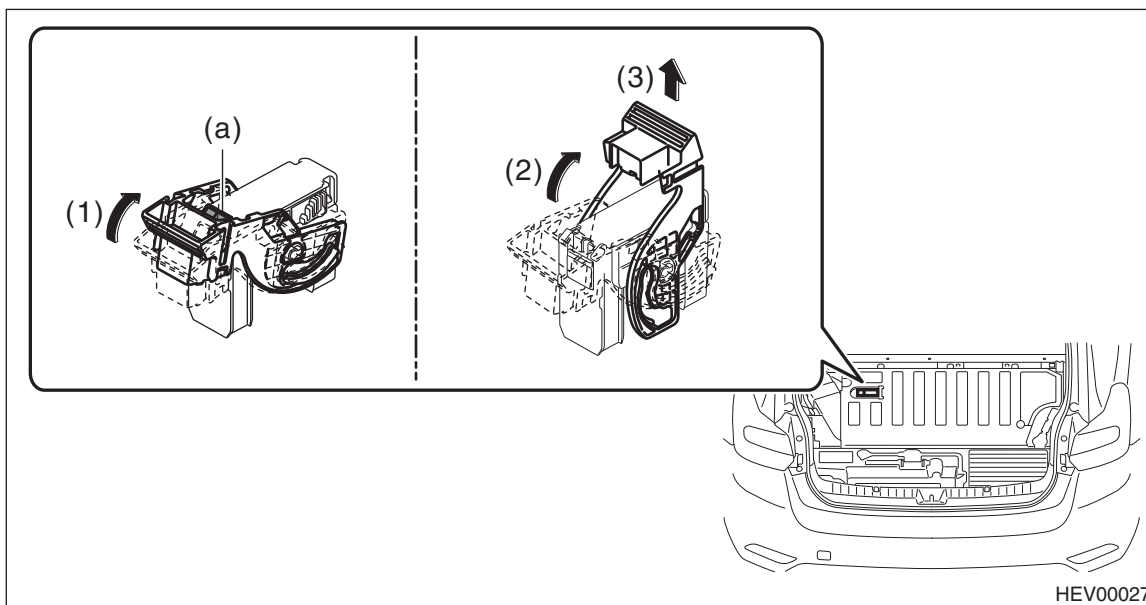
(A) 12 volt engine restart battery

(B) 12 volt auxiliary battery

- 3) Remove the mat from the rear floor area.

Foreword

4) Remove the Service disconnect plug.



HEV00027

- (1) Pull up the lever until it touches the stopper.
- (2) Move the lever upwards while pressing the claw (a).

NOTE:

The lever locks in the vertical position.

- (3) Remove the Service disconnect plug.

WARNING:

After removing the Service disconnect plug, be sure to wait for ten minutes before touching the high voltage connectors and terminals.

NOTE:

This time allows the high voltage condenser in the inverter to discharge.

- Always confirm that the voltage at any high voltage terminal is at 0 V using an Insulation multimeter before beginning additional work.

CAUTION:

After removing the Service disconnect plug and waiting ten minutes, cover the connection on the battery with electrical tape to protect from intrusion of foreign matter such as water or dust, tools, etc.

- Do not turn the ignition to ON with the Service disconnect plug removed in order to prevent system damage.
- After removal, always carry the removed Service disconnect plug in your pocket in order to prevent other technicians from accidentally re-installing it while you are working on the system.
- Even after the Service disconnect plug is removed, make sure to wear insulated gloves (PPE) during maintenance of all the parts inside the cover including the battery cover, and underfloor power cable.
- Insulate the high voltage power cables, connectors and terminals with electrical tape immediately after removing them.
- Be sure to tighten the high voltage screw terminals firmly to the specified torque. Lack of, or excess torque causes failures.
- Be careful not to allow foreign matter to enter the high voltage battery.

3. INSTALLATION OF THE SERVICE DISCONNECT PLUG

WARNING:

Make sure the connectors are connected completely and locked securely.

- After performing work for the high voltage system, make sure to check again for misplaced parts and tools, tightening conditions of high voltage terminals, and connector connections, before connecting the Service disconnect plug.
- Always replace faulty or damaged Service disconnect plug with a new part.
- If not damaged, always re-use the original Service disconnect plug from the vehicle you are servicing. Never use a Service disconnect plug removed from another vehicle.

Install in the reverse order of removal.

NOTE:

Move the lever to the horizontal position and push it until a click is heard and confirm it is securely locked.

4. PRECAUTION DURING REPAIR OF DAMAGED VEHICLE

- Preparation items

Protective equipment (insulated gloves, rubber gloves, protective goggles, and rubber boots for electrical purposes)

Saturated boric-acid solution 20 L (In a container, dissolve 800 g of boric acid powder purchased at a drug store in 20 L of water.)

Red litmus paper (purchase at a drug store)

Cloth, old towels (for wiping electrolytic solution)

Insulating tape

Circuit tester

- Precaution during repair of damaged vehicle

CAUTION:

Follow the procedures to ensure safety.

Make sure to use insulated tools, and wear insulated gloves or rubber gloves, protective goggles, and rubber boots for electrical purposes.

Check for any leakage in the high voltage battery vicinity.

CAUTION:

- **Do not touch any leaked fluid, because it may be strong alkaline electrolytic solution. When it is necessary to touch it, wear insulated gloves and protective goggles, neutralize with saturated boric-acid solution, confirm that red litmus paper does not change to blue, and then wipe off with cloth.**
- **If the electrolytic solution should touch the skin directly, immediately wash it away with saturated boric-acid solution or plenty of water. Also, take off the contaminated clothes.**
- **If it enters your eyes, scream for help, do not rub your eyes, immediately wash it away with plenty of water, and consult a doctor.**

Foreword

When the vehicle is damaged due to collision, stop the hybrid system in the following steps.

CAUTION:

Do not touch the exposed wires, when whether they are high voltage wires or not is unknown. When it is necessary or possible to touch them, make sure to wear insulated gloves and insulate the wires using insulating tape.

1. Turn the ignition to OFF.

NOTE:

When the ignition cannot be turned to OFF, remove the fuse in engine compartment.

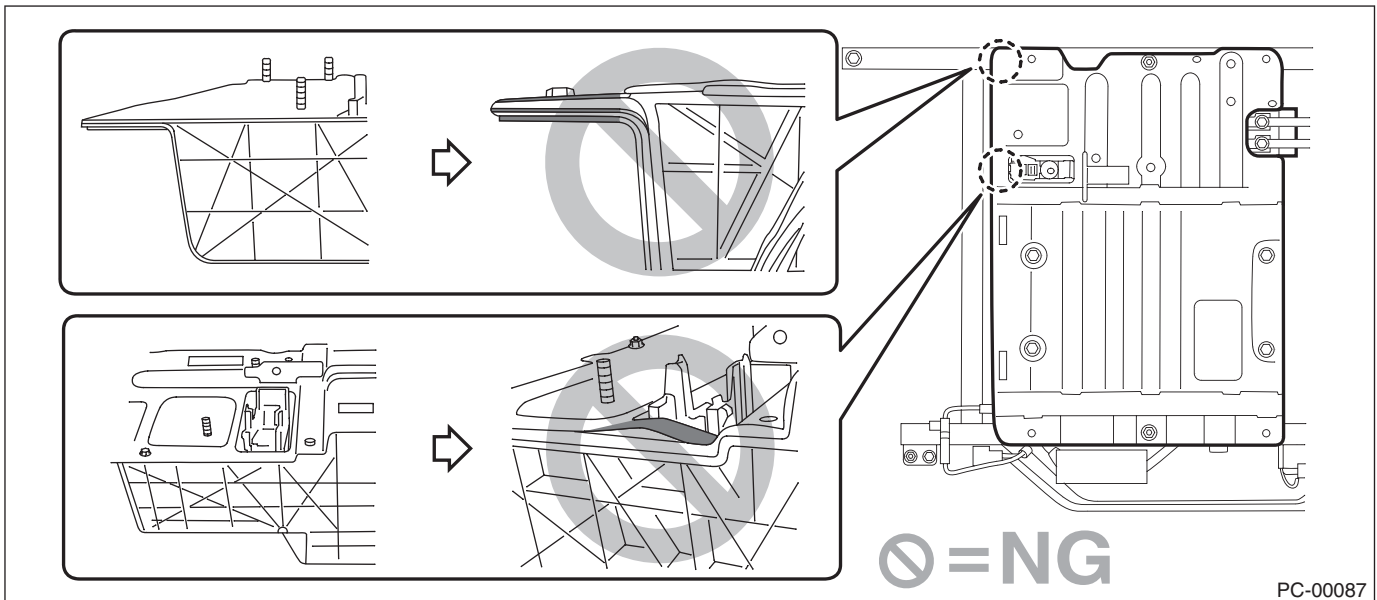
2. Wear insulated gloves and remove the service disconnect plug.

5. PRECAUTION FOR HIGH VOLTAGE BATTERY

Through the route specified by the manufacturer, make sure to collect the high voltage batteries that are no longer needed due to replacement or other reasons.

CAUTION:

- When high voltage batteries are dumped or left without proper measures, electric shock accidents may occur. Be sure to collect the high voltage batteries through the route specified by the manufacturer.
- Do not leave the removed high voltage batteries in a place where water may splash, because generated heat may cause fire.
- When the collision is severe, high impact is applied to the high voltage battery, possibly causing damage inside the high voltage battery. Therefore, visually check the exterior of high voltage battery, and replace with a new one if deformation or such evidence is found at the following locations.



6. PRECAUTION REGARDING PAINTING BOOTH

When heating and drying a vehicle in the painting booth, keep the temperature below 70°C (158°F) and perform the work within 1 hour. If the work requires a higher temperature or longer working time, remove the high-voltage battery from the vehicle.

7. OTHER PRECAUTIONS

For details regarding other precautions, refer to the PC (Precautions) Chapter in the Service Manual (Publication No. G1171BE).

D: NOTE

1. On 980MPa class High-strength tensile steel

It is recommended to perform the weldings using 980Mpa class high-strength steel under the following conditions.

- It is recommended to perform spot welding according to board thickness and number of overlapping sheets under the following conditions ([a] — [f])
- When conditions can't be met, it is recommended to perform the plug welding following [g] or [h].

Spot welding	[a]	Compression	3.0 kN	Total number of 2 overlapping sheets
		Current	6.0 kA	
		Welding time	15 cyc	
	[b]	Compression	4.0 kN	
		Current	6.5 kA	
		Welding time	15 cyc	
	[c]	Compression	3.0 kN	Total number of 3 overlapping sheets
		Current	6.5 kA	
		Welding time	25 cyc	
	[d]	Compression	3.5 kN	
		Current	7.0 kA	
		Welding time	25 cyc	
	[e]	Compression	3.5 kN	
		Current	7.5 kA	
		Welding time	16 cyc	
	[f]	Compression	4.4 kN	
		Current	8.0 kA	
		Welding time	20 cyc	
Plug welding	[g]	Plug diameter	8 mm (0.31 in) or more	Total number of 2 or 3 overlapping sheets
		Wire	YGW12	
		Gas	CO2	
	[h]	Plug diameter	8 mm (0.31 in) or more	
		Wire	YGW16	
		Gas	Gas mixture (argon: 80%, CO2: 20%)	

CAUTION:

- For new spot welding, avoid previously welded locations.
- After spot welding, inspect the welding locations, and if the weld appears to be insufficient, perform plug welding.
- Shape correction by heating and splice welding shall not be performed for components using 980 MPa class and high-strength tensile steel because this may decrease the strength of the material.

2. Hole diameter required for plug welding of a steel plate below 980 MPa class

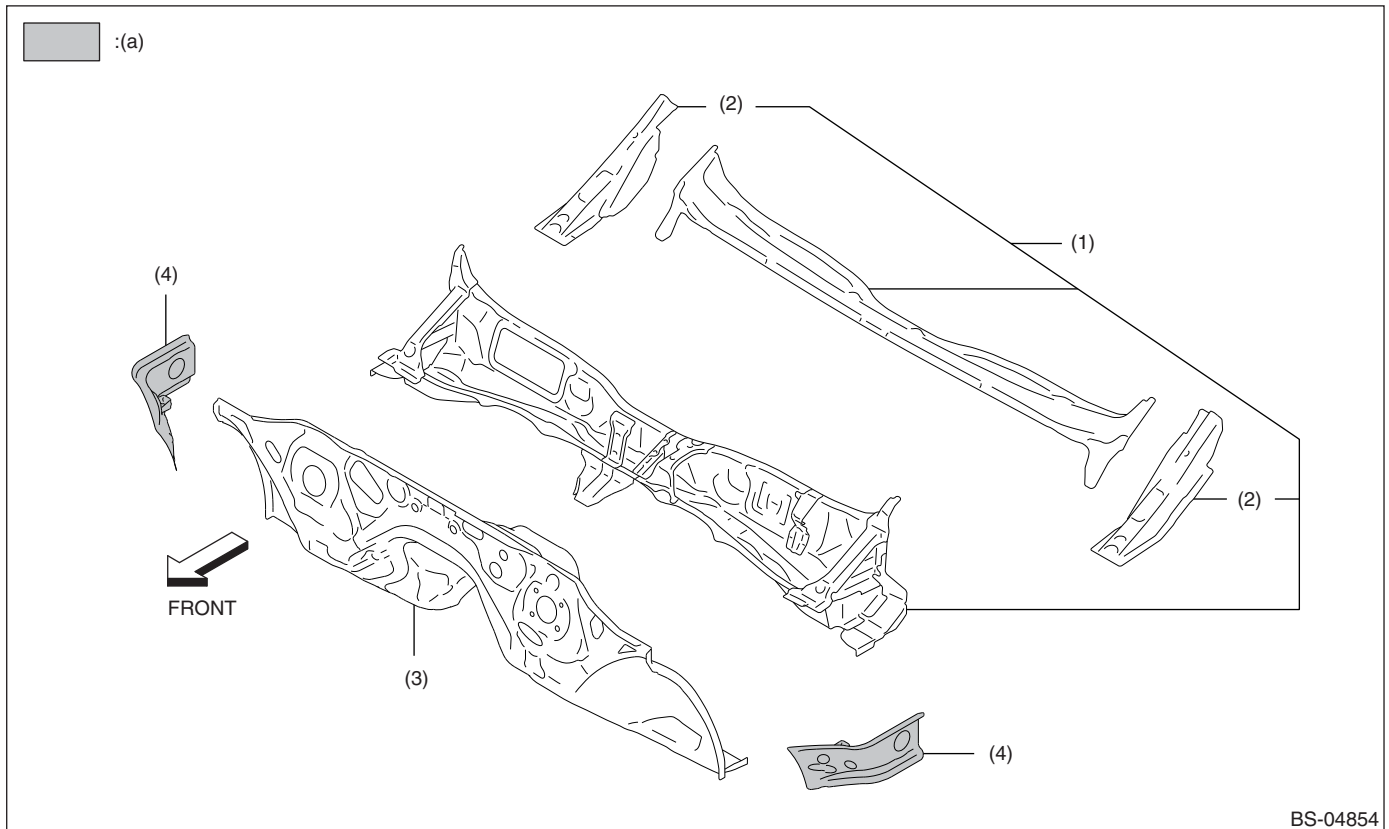
At locations where spot welding is not possible, use a punch or a drill to open holes for plug welding according to the following table.

Plate thickness of the welding material	Plug welding hole diameter
Less than 1.0 mm (0.04 in)	φ5.0 mm (0.20 in) or more
1.0 — 1.6 mm (0.04 — 0.06 in)	φ6.5mm (0.26 in) or more
1.7 — 2.3 mm (0.07 — 0.09 in)	φ8.0mm (0.31 in) or more
2.4 mm (0.09 in) or more	φ10.0 mm (0.39 in) or more

2. Panel Components

A: COMPONENTS

1. TOE BOARD & FRONT PANEL



(a) High-strength tensile steel
(440-590 MPa class)

(1) Front panel and Duct

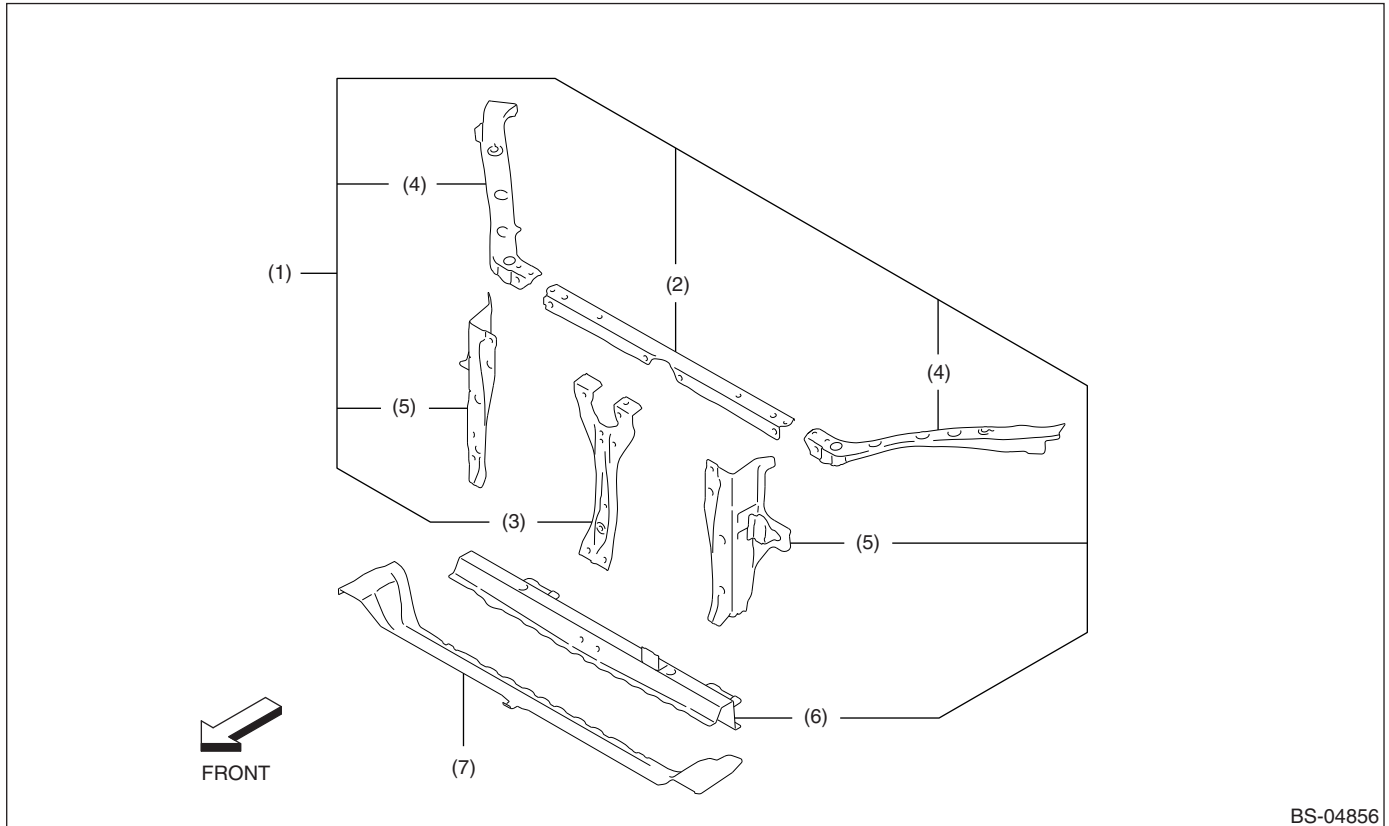
(3) Toe board

(4) Gusset

(2) Front panel side reinforcement

Panel Components

2. RADIATOR PANEL



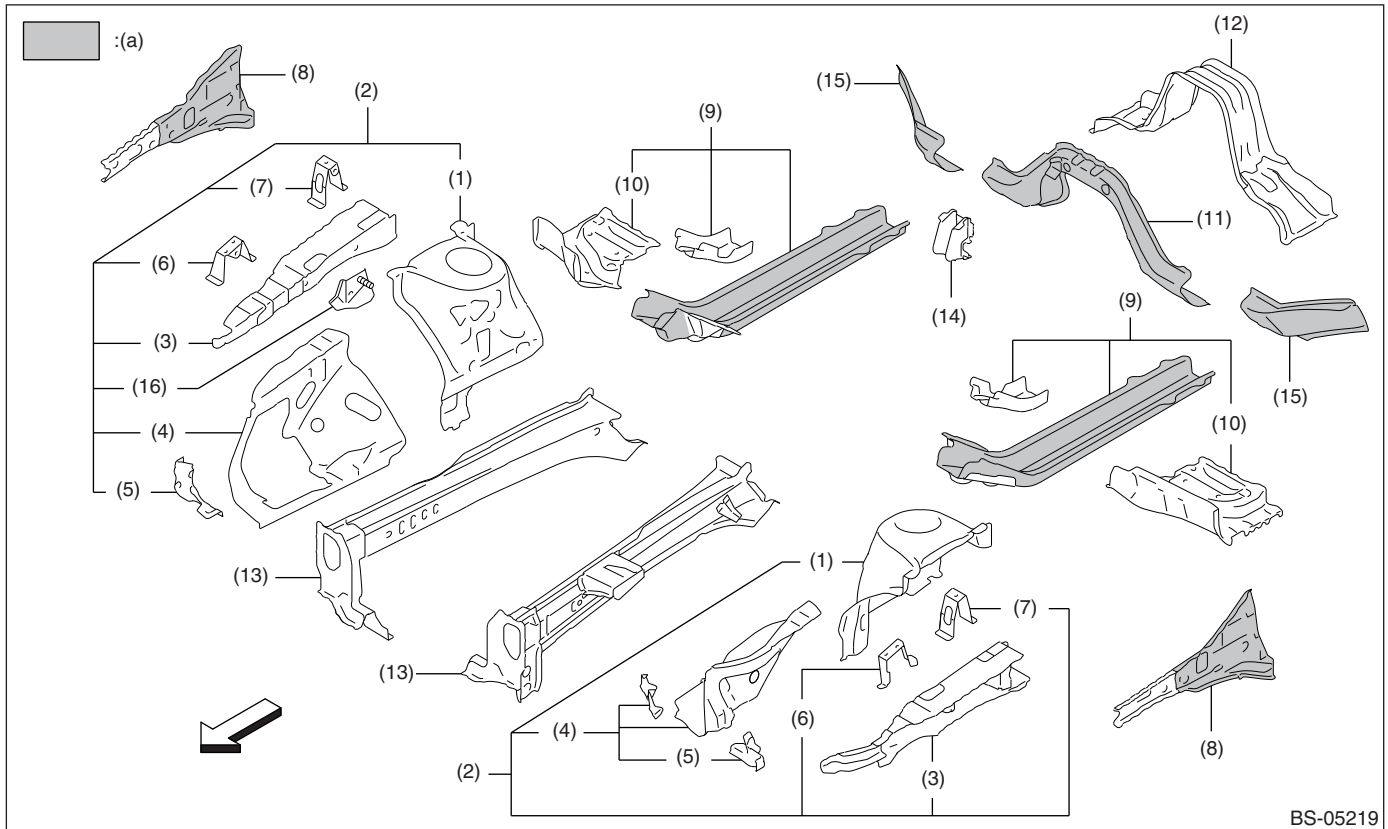
BS-04856

- | | | |
|--------------------------|--------------------------------|--------------------------|
| (1) Radiator panel | (4) Radiator side frame upper | (7) Frame radiator lower |
| (2) Radiator frame upper | (5) Radiator panel side | |
| (3) Hood lock stay | (6) Frame radiator panel lower | |

Panel Components

3. FRONT WHEEL APRON

- **Except for Hybrid model (Up to the 13MY)**

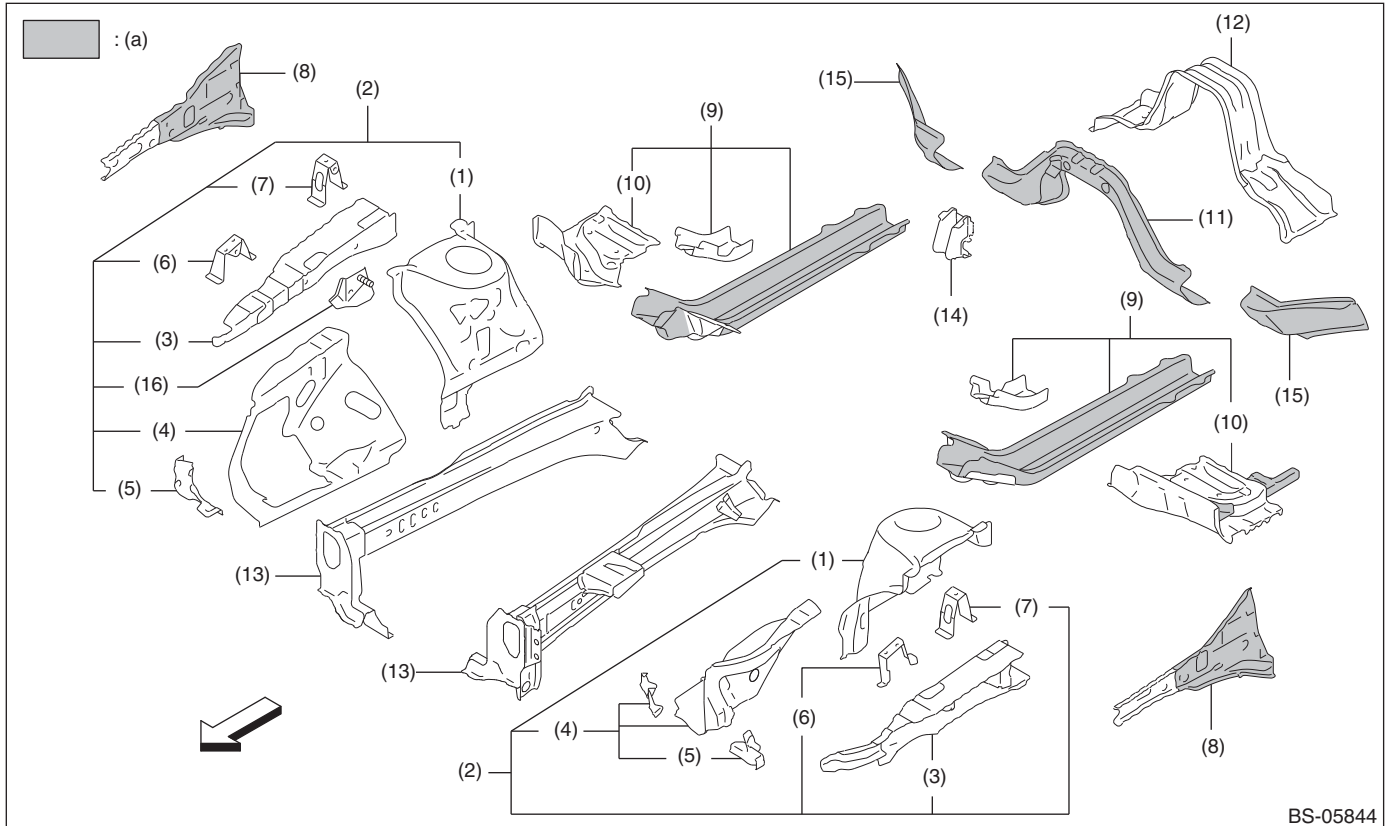


(a) High-strength tensile steel
(440-590 MPa class)

- | | | |
|--------------------------------|-----------------------------------|---------------------------------|
| (1) Front suspension bracket | (7) Upper rear fender bracket | (13) Front side frame front |
| (2) Wheel apron | (8) Side upper frame | (14) Pitching stopper bracket |
| (3) Wheel apron front upper | (9) Front side frame rear | (15) Toe board crossmember side |
| (4) Front wheel apron | (10) Toe board reinforcement | (16) VDC bracket |
| (5) Side fender bracket | (11) Toe board crossmember center | |
| (6) Upper front fender bracket | (12) Floor crossmember front | |

Panel Components

• Except for Hybrid model (14MY)



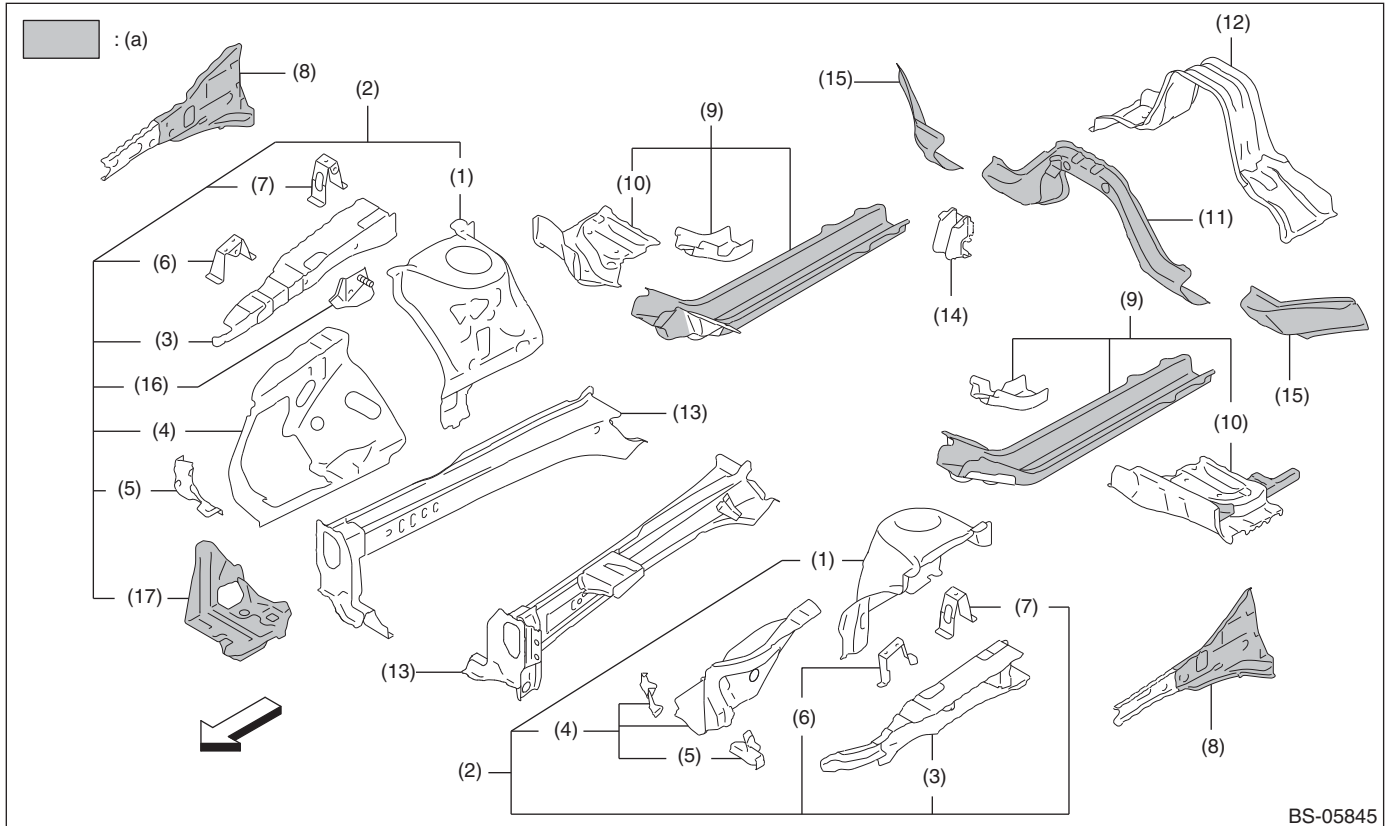
BS-05844

(a) High-strength tensile steel
(440-590 MPa class)

- | | | |
|--------------------------------|-----------------------------------|---------------------------------|
| (1) Front suspension bracket | (7) Upper rear fender bracket | (13) Front side frame front |
| (2) Wheel apron | (8) Side upper frame | (14) Pitching stopper bracket |
| (3) Wheel apron front upper | (9) Front side frame rear | (15) Toe board crossmember side |
| (4) Front wheel apron | (10) Toe board reinforcement | (16) VDC bracket |
| (5) Side fender bracket | (11) Toe board crossmember center | |
| (6) Upper front fender bracket | (12) Floor crossmember front | |

Panel Components

• Hybrid model



BS-05845

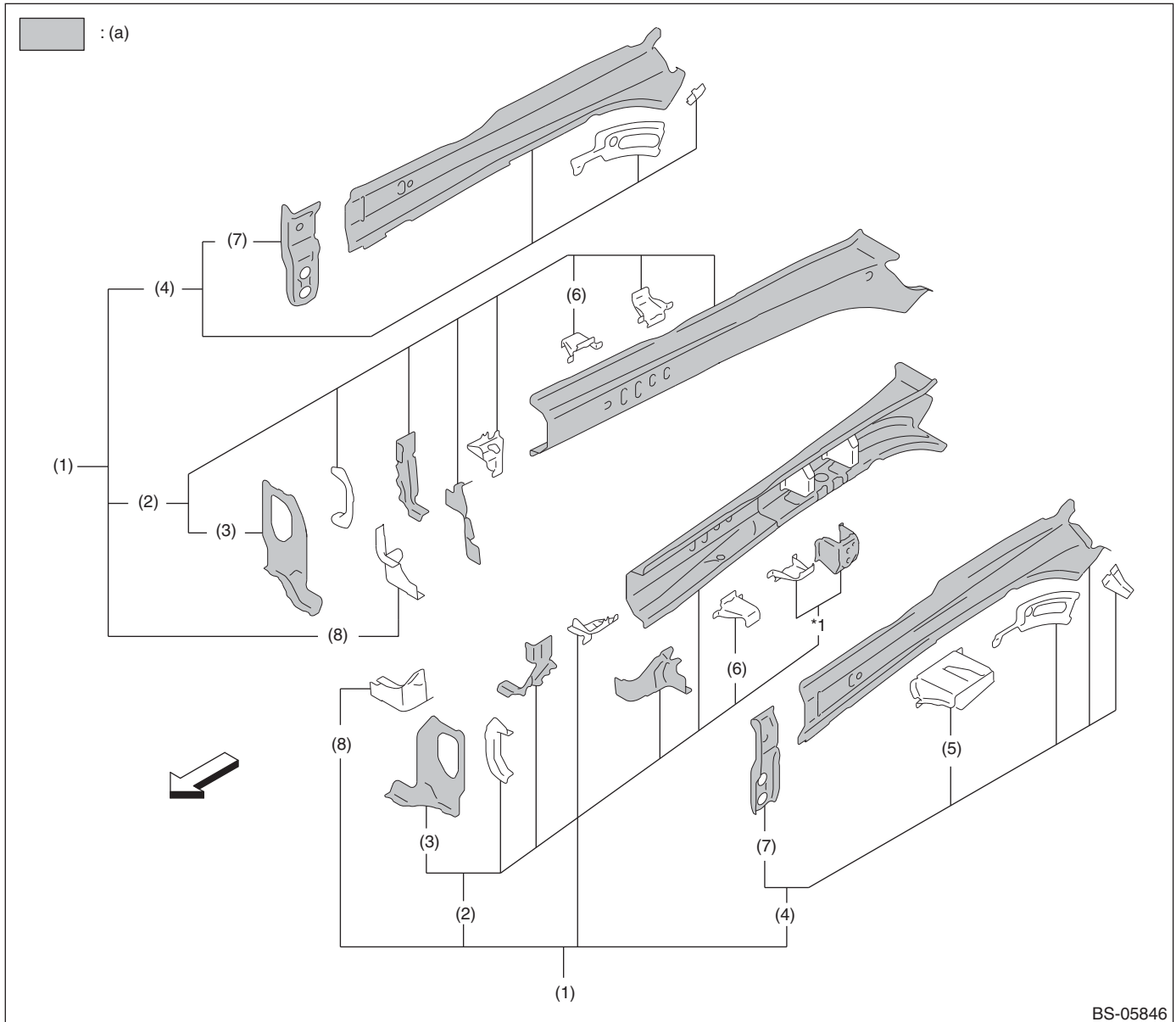
(a) High-strength tensile steel
(440-590 MPa class)

- | | | |
|--------------------------------|-----------------------------------|---------------------------------|
| (1) Front suspension bracket | (7) Upper rear fender bracket | (13) Front side frame front |
| (2) Wheel apron | (8) Side upper frame | (14) Pitching stopper bracket |
| (3) Wheel apron front upper | (9) Front side frame rear | (15) Toe board crossmember side |
| (4) Front wheel apron | (10) Toe board reinforcement | (16) VDC bracket |
| (5) Side fender bracket | (11) Toe board crossmember center | (17) Gusset compl. battery |
| (6) Upper front fender bracket | (12) Floor crossmember front | |

Panel Components

4. FRONT SIDE FRAME

• Up to the 13MY



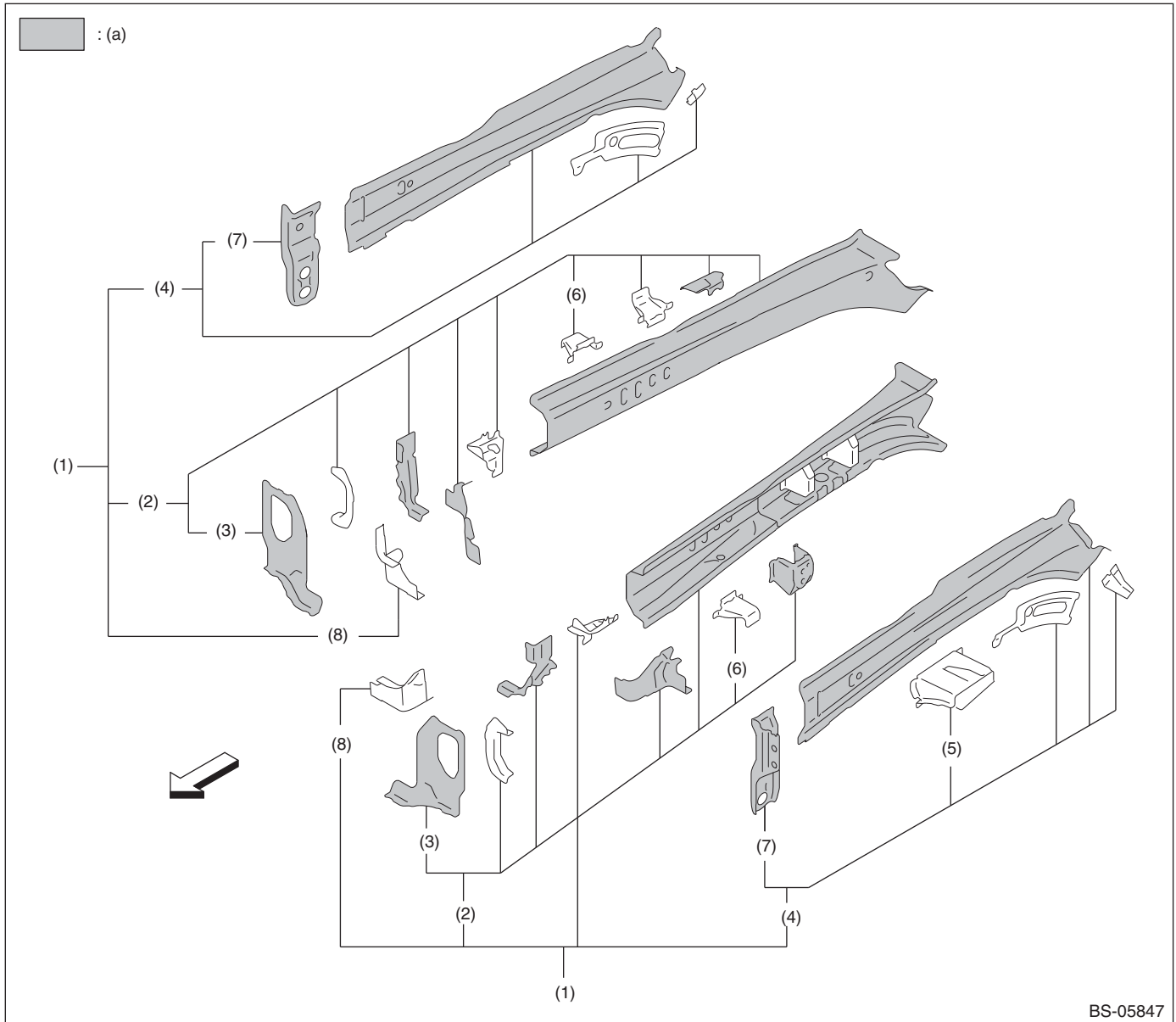
(a) High-strength tensile steel
(440-590 MPa class)

*1: The shape changes depending on the model year.

- | | | |
|-------------------------------|----------------------------------|------------------------------|
| (1) Front side frame front | (4) Closing plate | (7) Front hook reinforcement |
| (2) Front side subframe front | (5) Battery reinforcement gusset | (8) Front frame gusset |
| (3) Front frame plate front | (6) Separator | |

Panel Components

• 2014MY Except for Hybrid model



(a) High-strength tensile steel
(440-590 MPa class)

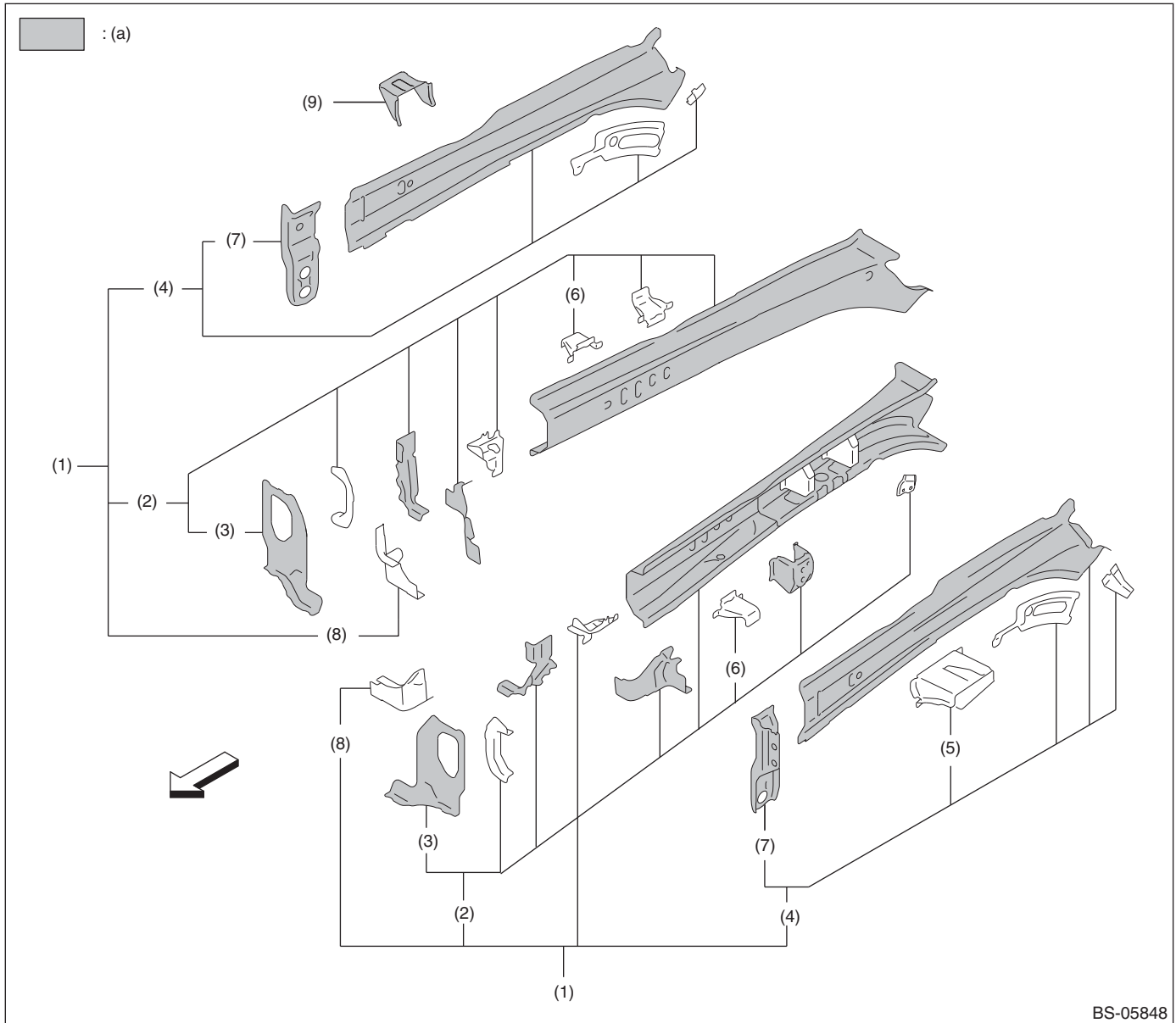
- (1) Front side frame front
- (2) Front side subframe front
- (3) Front frame plate front

- (4) Closing plate
- (5) Battery reinforcement gusset
- (6) Separator

- (7) Front hook reinforcement
- (8) Front frame gusset

Panel Components

• Hybrid model



(a) High-strength tensile steel
(440-590 MPa class)

- (1) Front side frame front
- (2) Front side subframe front
- (3) Front frame plate front

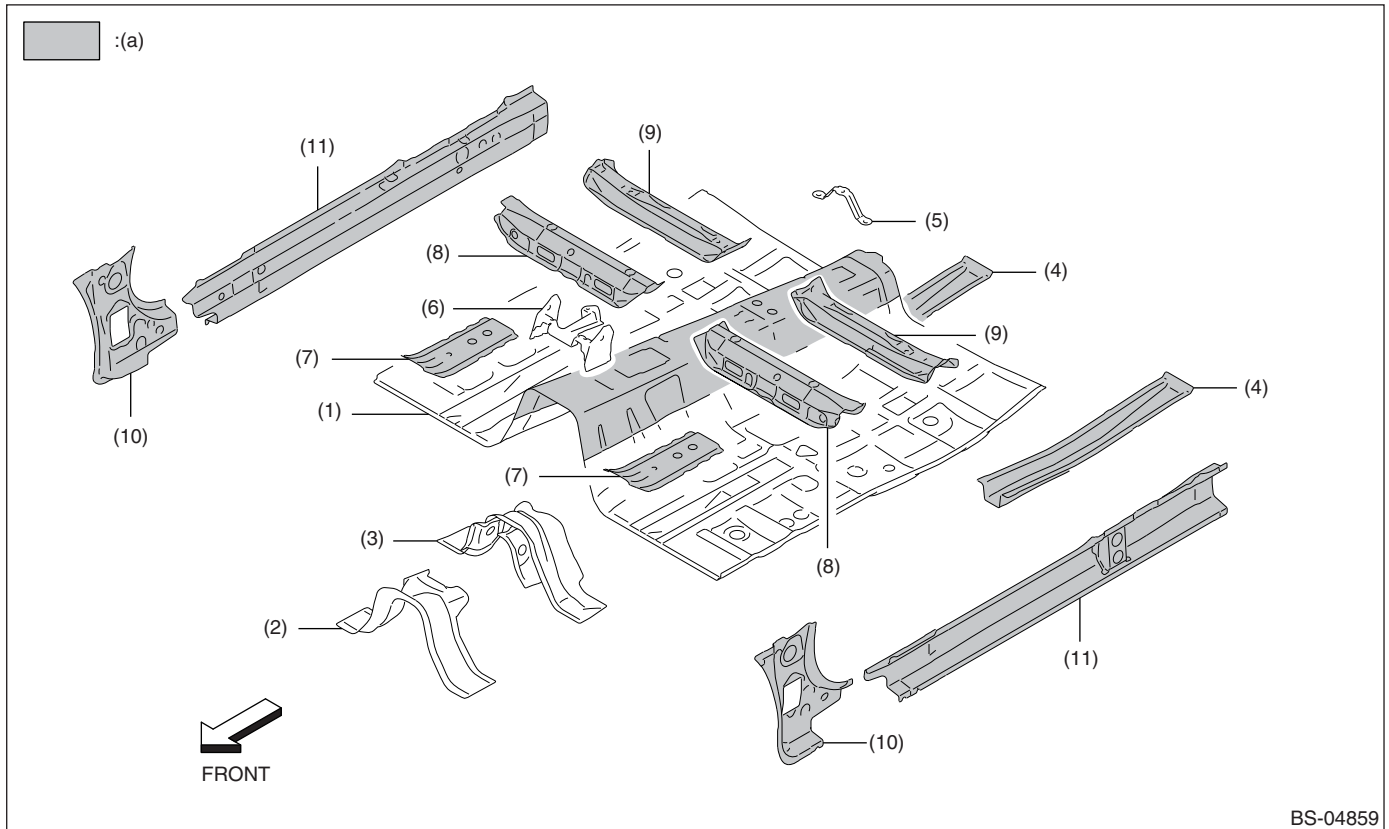
- (4) Closing plate
- (5) Battery reinforcement gusset
- (6) Separator

- (7) Front hook reinforcement
- (8) Front frame gusset
- (9) Gusset battery

Panel Components

5. FRONT FLOOR PANEL

• Except for Hybrid model (Up to the 13MY)

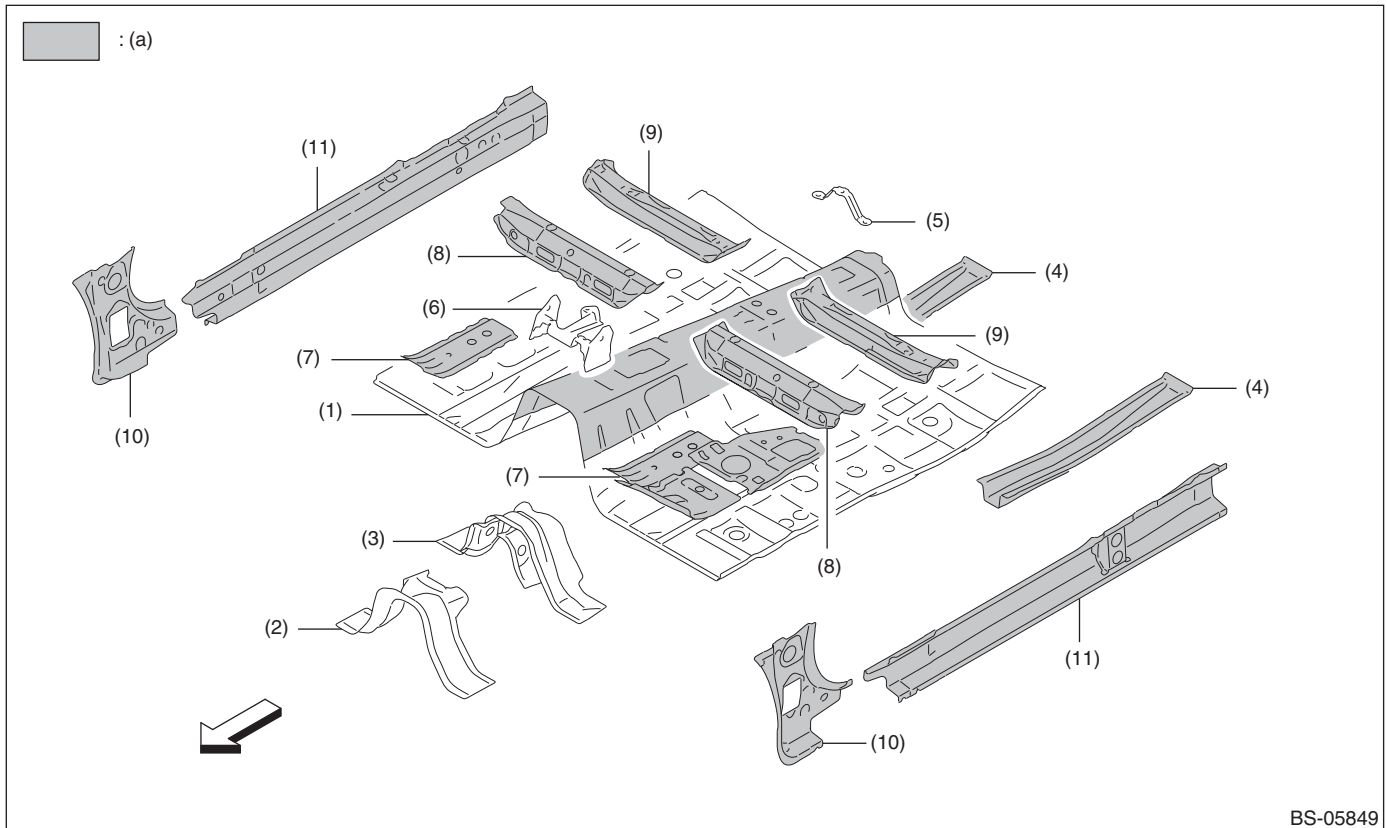


(a) High-strength tensile steel
(440-590 MPa class)

- | | | |
|------------------------------|----------------------------------|---------------------------------|
| (1) Front floor pan | (5) Harness bracket | (9) Front seat crossmember rear |
| (2) Floor crossmember center | (6) Instrument panel bracket | (10) Front pillar inner lower |
| (3) Floor crossmember rear | (7) Front floor frame front | (11) Side sill inner |
| (4) Front floor frame rear | (8) Front seat crossmember front | |

Panel Components

• Except for Hybrid model (14MY)

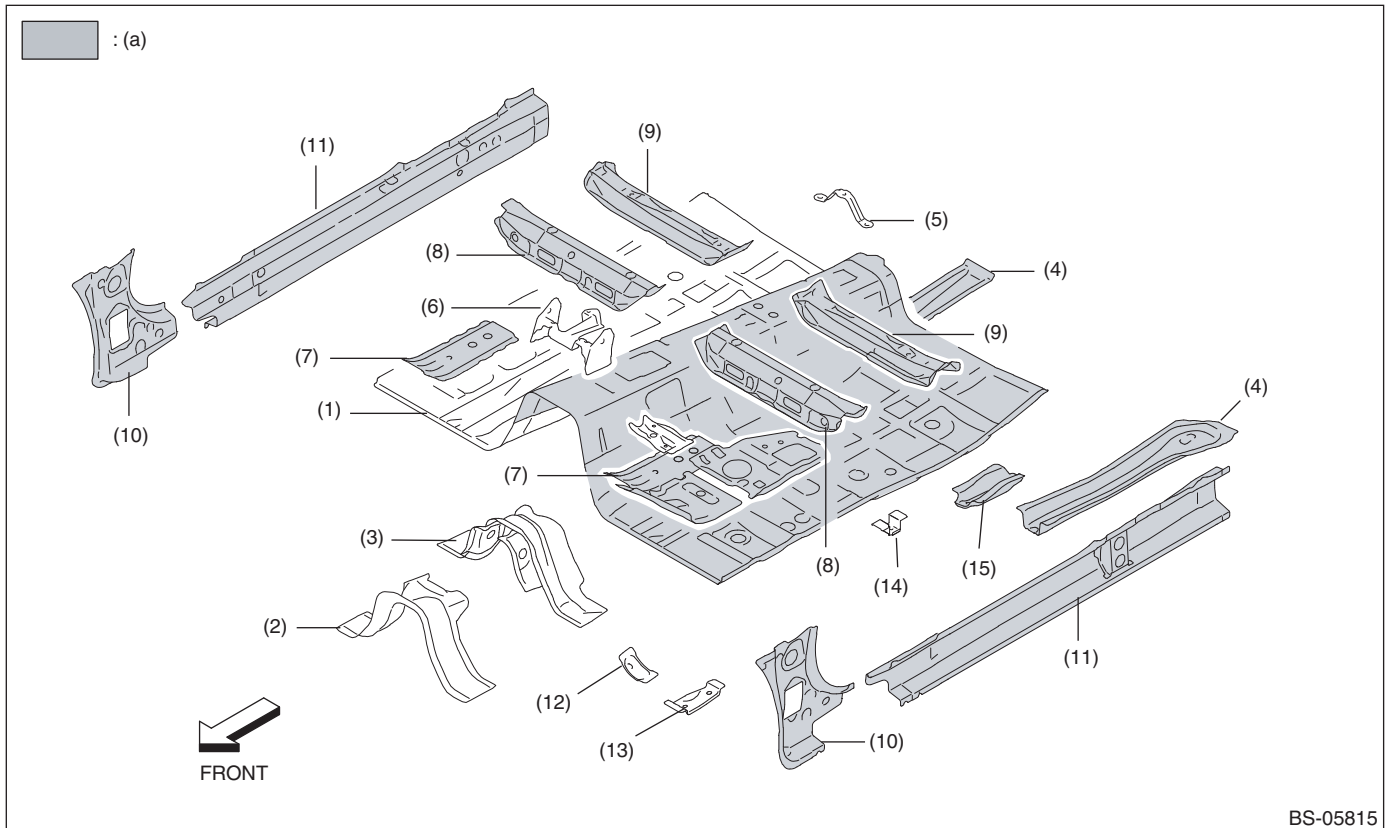


(a) High-strength tensile steel
(440-590 MPa class)

- | | | |
|------------------------------|----------------------------------|---------------------------------|
| (1) Front floor pan | (5) Harness bracket | (9) Front seat crossmember rear |
| (2) Floor crossmember center | (6) Instrument panel bracket | (10) Front pillar inner lower |
| (3) Floor crossmember rear | (7) Front floor frame front | (11) Side sill inner |
| (4) Front floor frame rear | (8) Front seat crossmember front | |

Panel Components

• Hybrid model



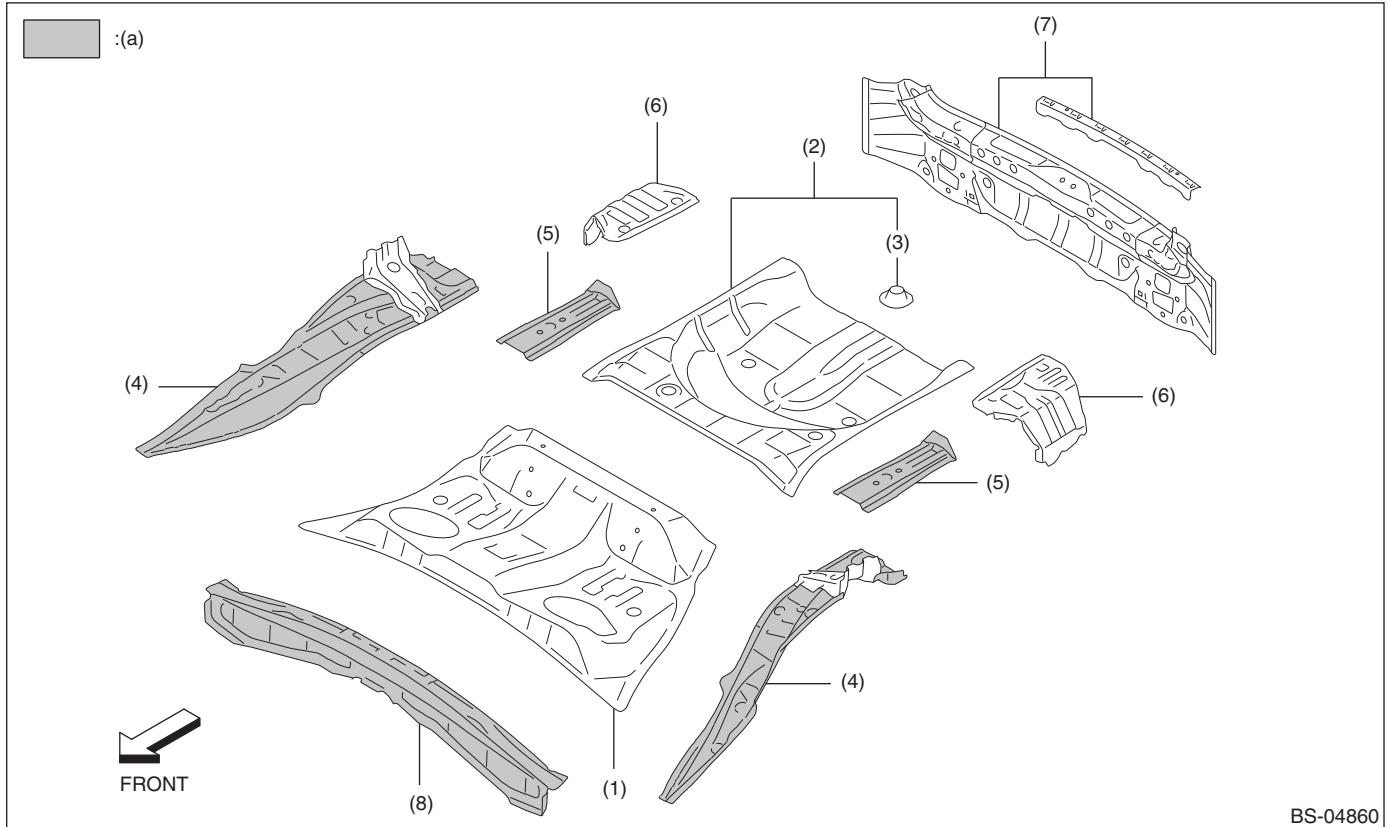
(a) High-strength tensile steel
(440-590 MPa class)

- | | | |
|------------------------------|----------------------------------|-------------------------------------|
| (1) Front floor pan | (6) Instrument panel bracket | (11) Side sill inner |
| (2) Floor crossmember center | (7) Front floor frame front | (12) Bracket |
| (3) Floor crossmember rear | (8) Front seat crossmember front | (13) Bracket |
| (4) Front floor frame rear | (9) Front seat crossmember rear | (14) Bracket |
| (5) Harness bracket | (10) Front pillar inner lower | (15) Reinforcement frame side floor |

Panel Components

6. REAR FLOOR PANEL & REAR SKIRT

• 5 Door (Except for Hybrid model)



(a) High-strength tensile steel
(440-590 MPa class)

(1) Rear floor pan front

(2) Rear floor pan rear

(3) Spare tire bracket

(4) Frame rear upper

(5) Rear side frame upper rear

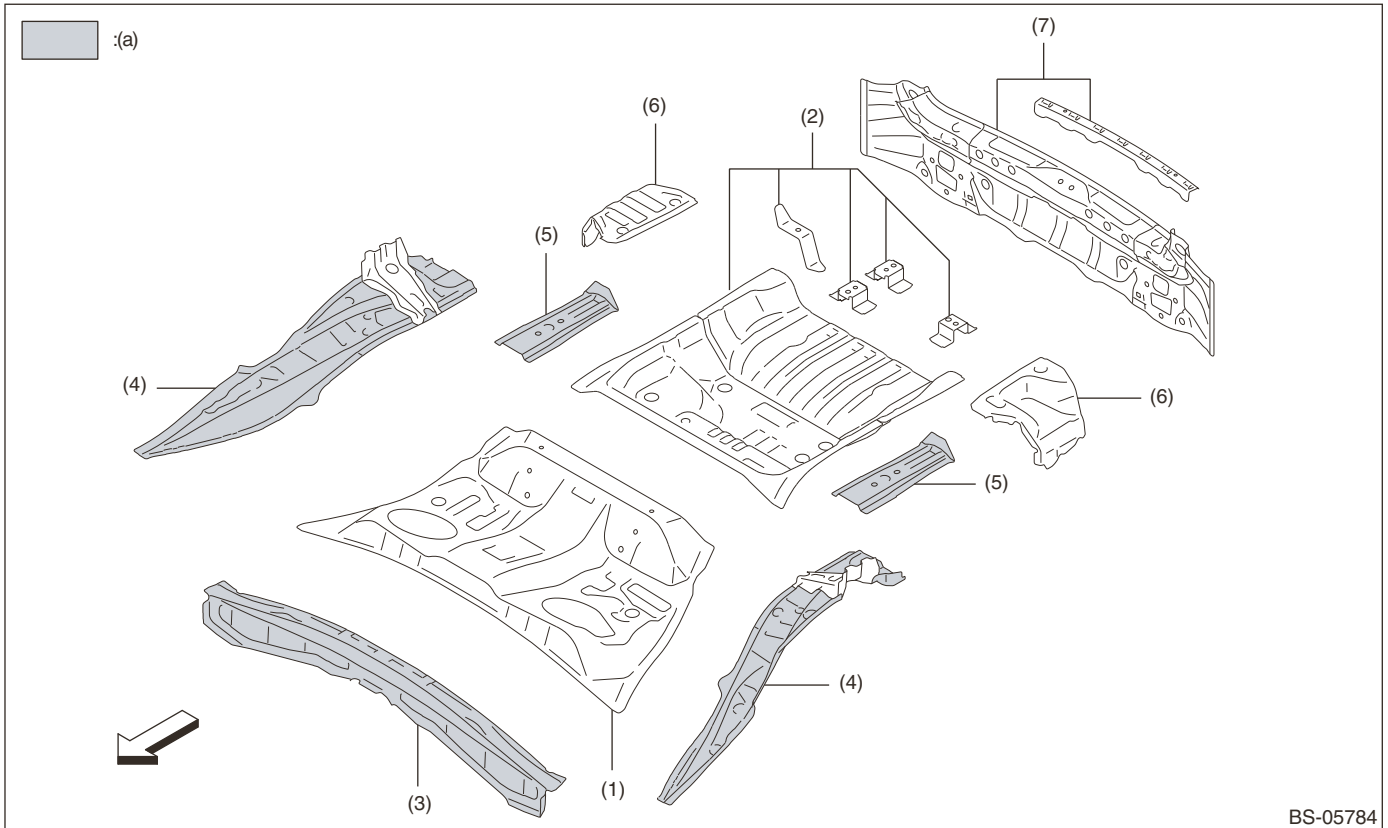
(6) Floor side rear

(7) Rear skirt

(8) Rear floor crossmember A front

Panel Components

• 5 Door (Hybrid model)



(a) High-strength tensile steel
(440-590 MPa class)

(1) Rear floor pan front

(2) Rear floor pan rear

(3) Spare tire bracket

(4) Frame rear upper

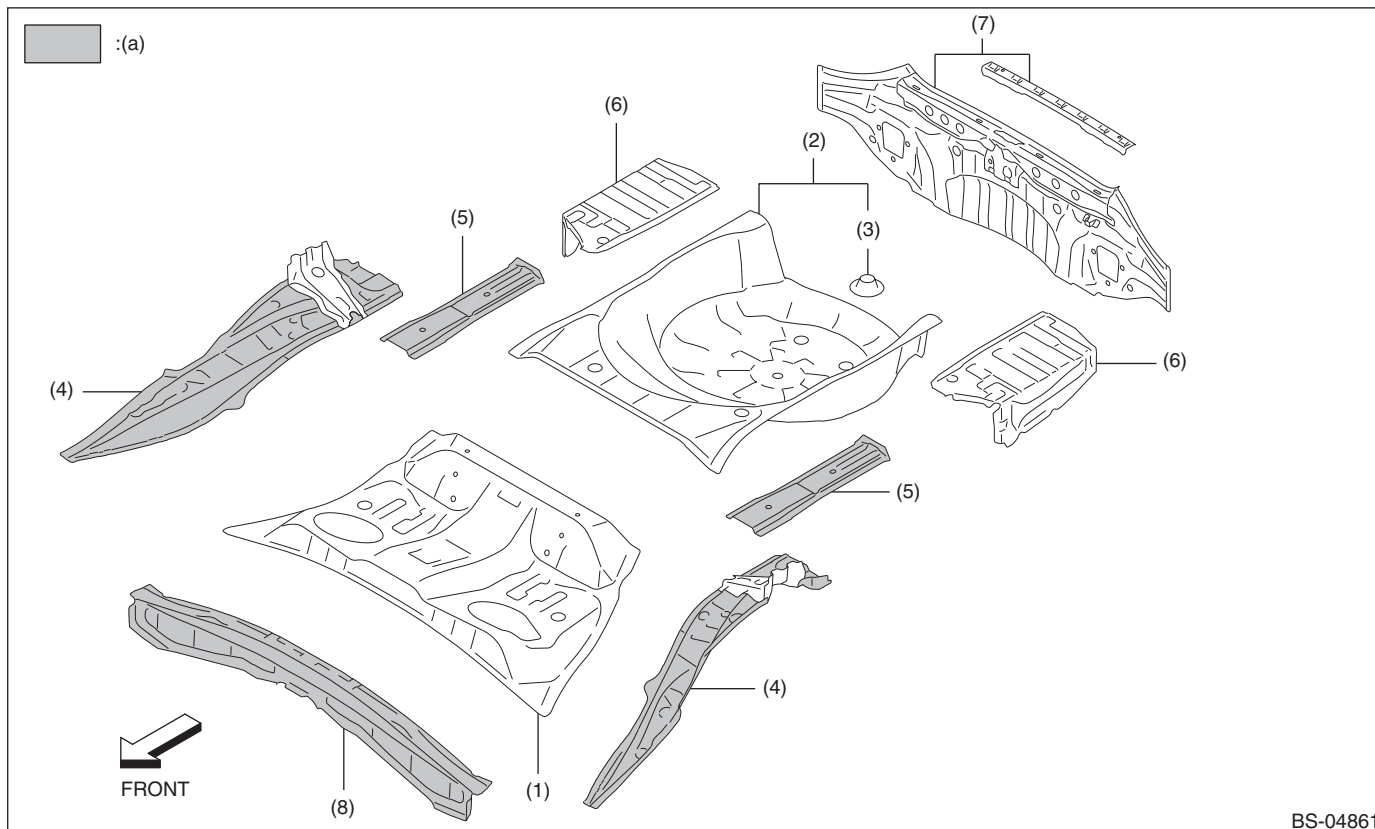
(5) Rear side frame upper rear

(6) Floor side rear

(7) Rear skirt

Panel Components

• 4 Door



(a) High-strength tensile steel
(440-590 MPa class)

(1) Rear floor pan front

(2) Rear floor pan rear

(3) Spare tire bracket

(4) Frame rear upper

(5) Rear side frame upper rear

(6) Floor side rear

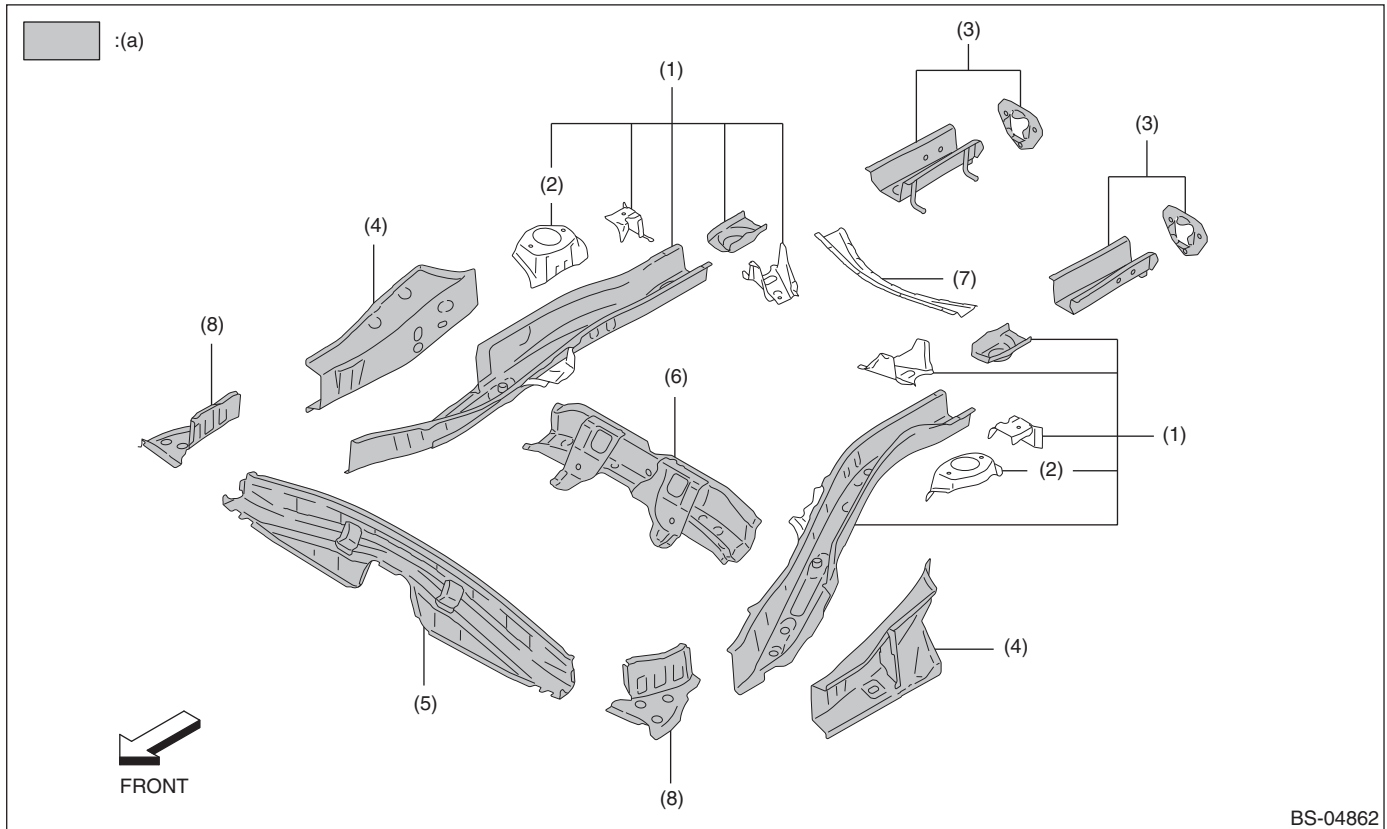
(7) Rear skirt

(8) Rear floor crossmember A front

Panel Components

7. REAR FLOOR SIDE FRAME

• 5 Door (Except for Hybrid model)



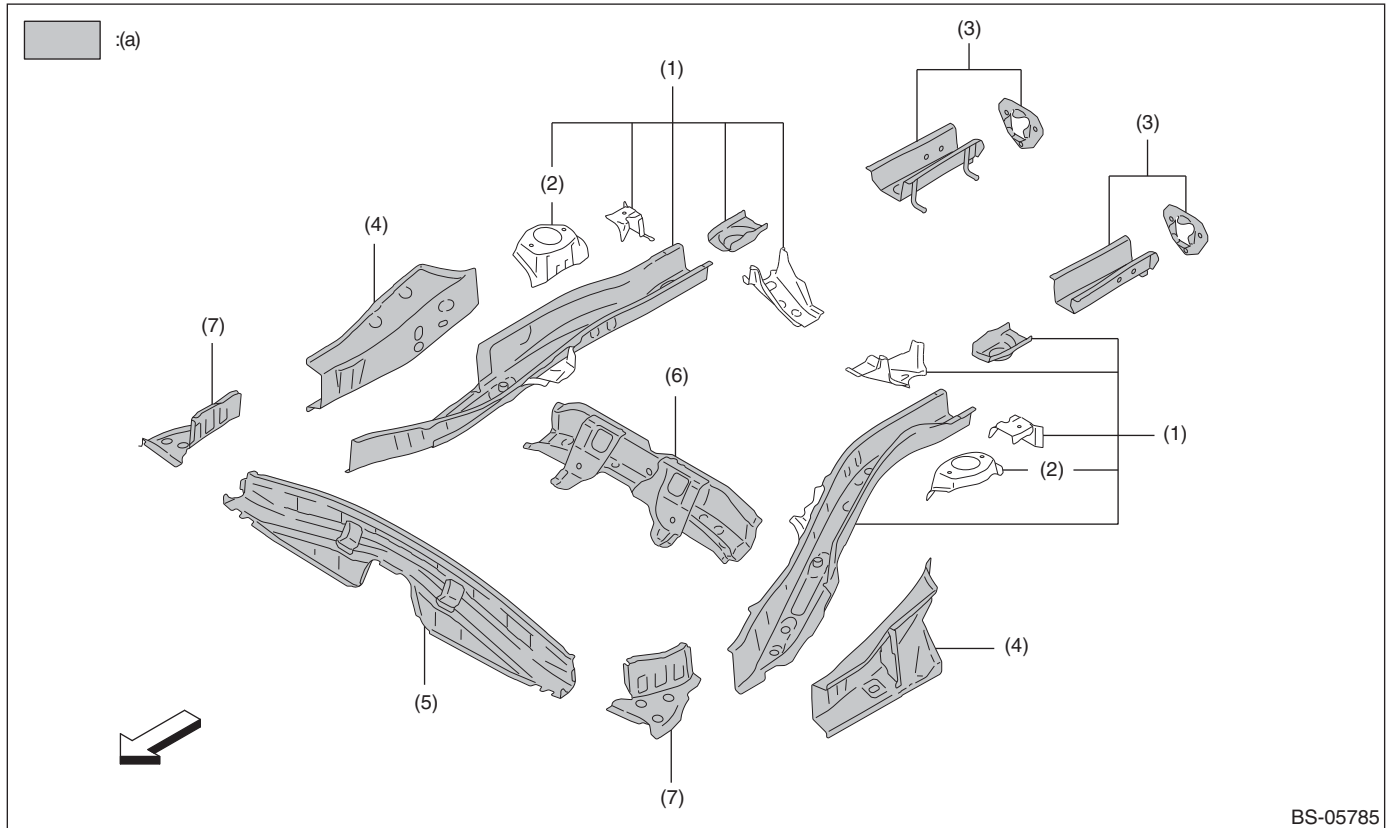
BS-04862

(a) High-strength tensile steel
(440-590 MPa class)

- | | | |
|--------------------------------------|-----------------------------------|------------------------------|
| (1) Floor side frame rear | (4) Side sill inner rear | (7) Rear floor crossmember C |
| (2) Rear suspension bracket | (5) Rear floor crossmember A rear | (8) Rear side frame gusset |
| (3) Floor side frame rear lower rear | (6) Rear floor crossmember B | |

Panel Components

• 5 Door (Hybrid model)



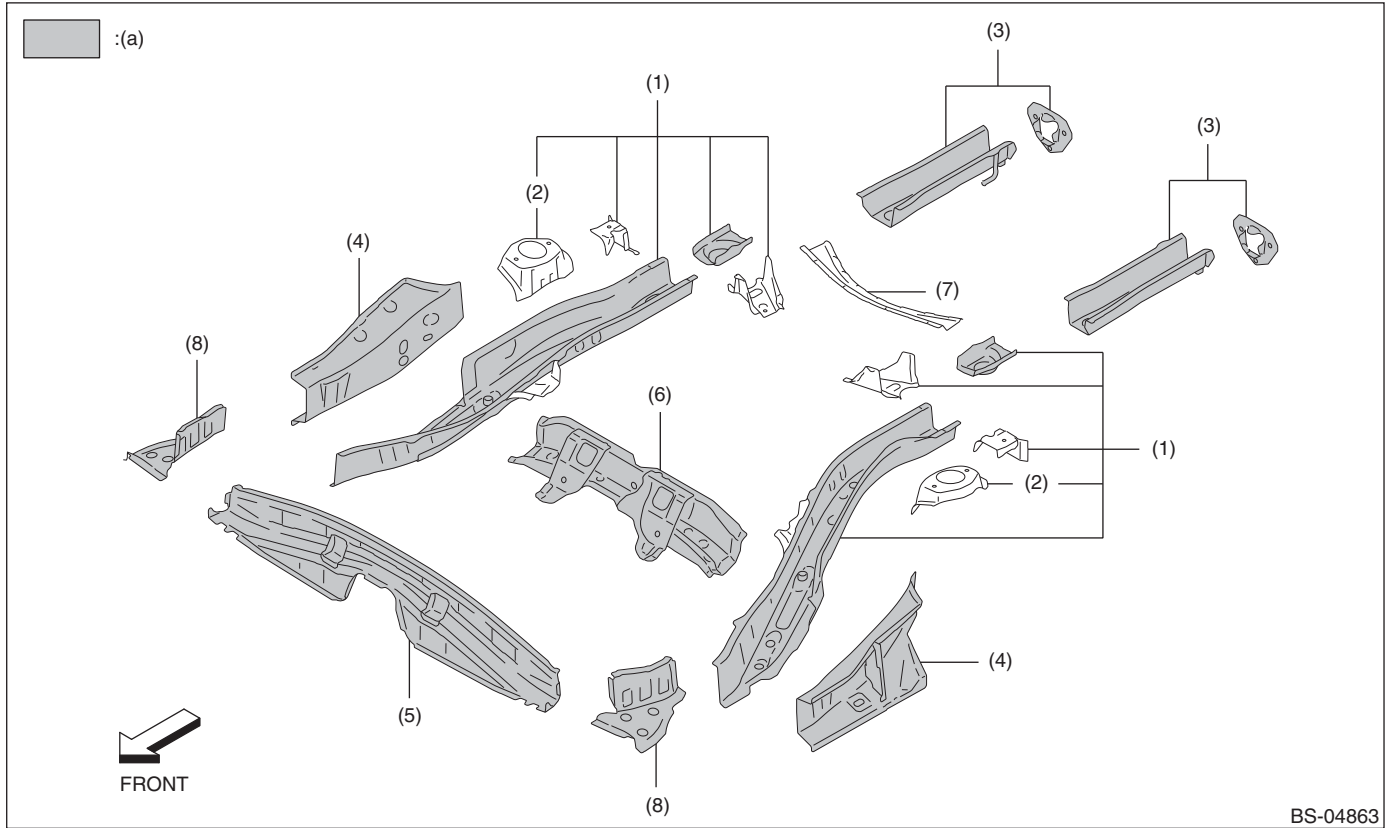
BS-05785

(a) High-strength tensile steel
(440-590 MPa class)

- | | | |
|--------------------------------------|-----------------------------------|----------------------------|
| (1) Floor side frame rear | (4) Side sill inner rear | (7) Rear side frame gusset |
| (2) Rear suspension bracket | (5) Rear floor crossmember A rear | |
| (3) Floor side frame rear lower rear | (6) Rear floor crossmember B | |

Panel Components

• 4 Door



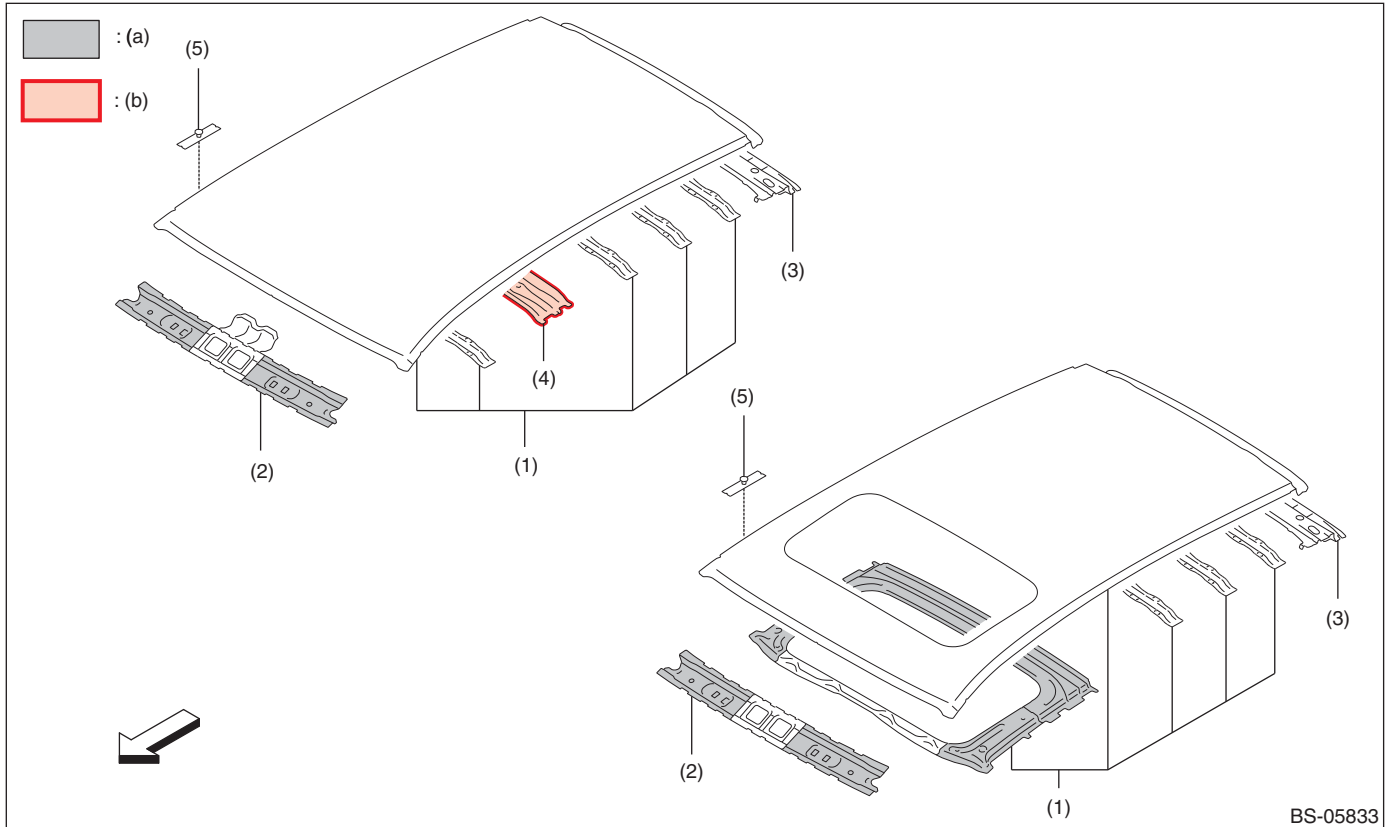
(a) High-strength tensile steel
(440-590 MPa class)

- | | | |
|--------------------------------------|-----------------------------------|------------------------------|
| (1) Floor side frame rear | (4) Side sill inner rear | (7) Rear floor crossmember C |
| (2) Rear suspension bracket | (5) Rear floor crossmember A rear | (8) Rear side frame gusset |
| (3) Floor side frame rear lower rear | (6) Rear floor crossmember B | |

Panel Components

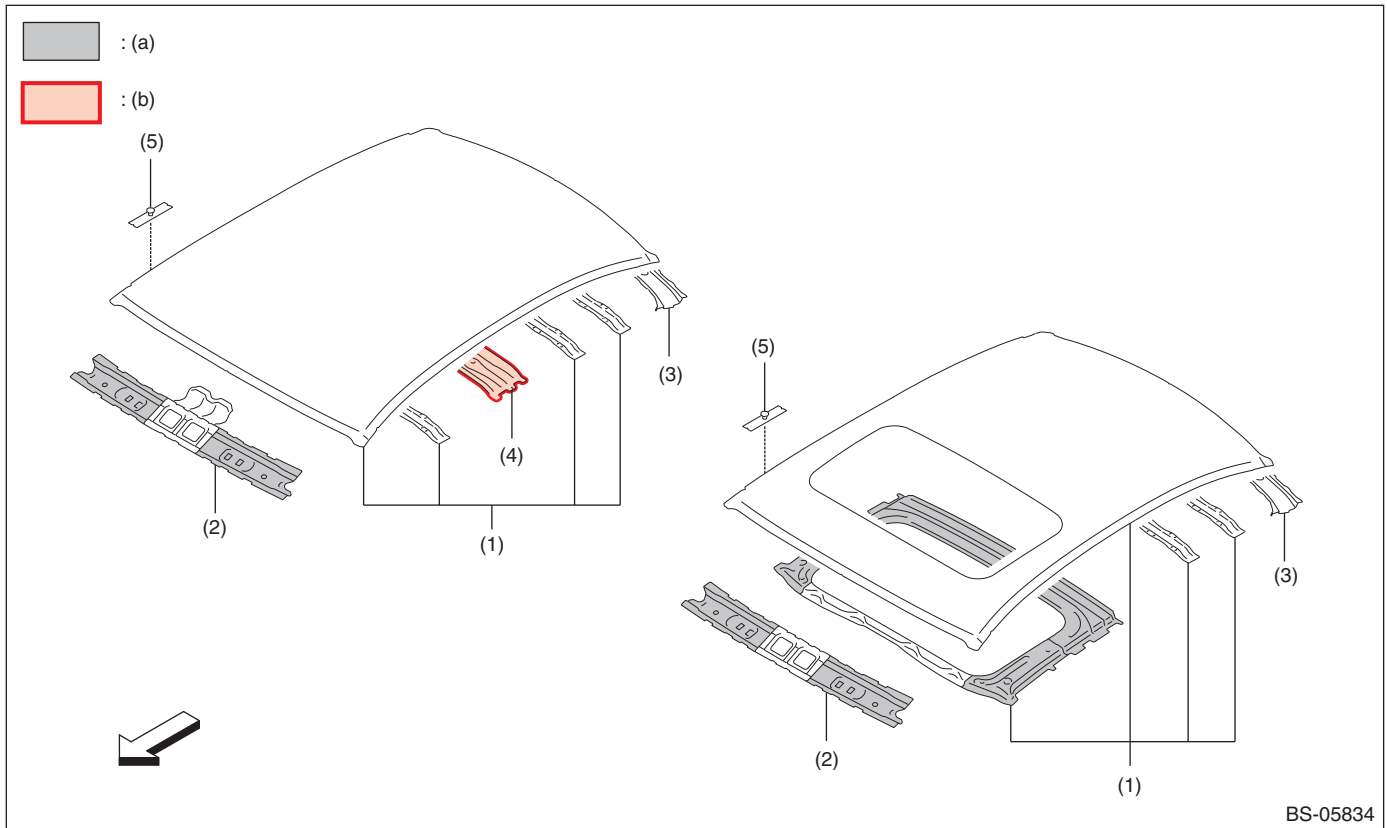
8. ROOF

• 5 Door



Panel Components

• 4 Door



(a) High-strength tensile steel
(440-590 MPa class)

(b) High-strength tensile steel
(1500 MPa class)

(1) Roof panel

(3) Rear roof rail

(5) T stud plate

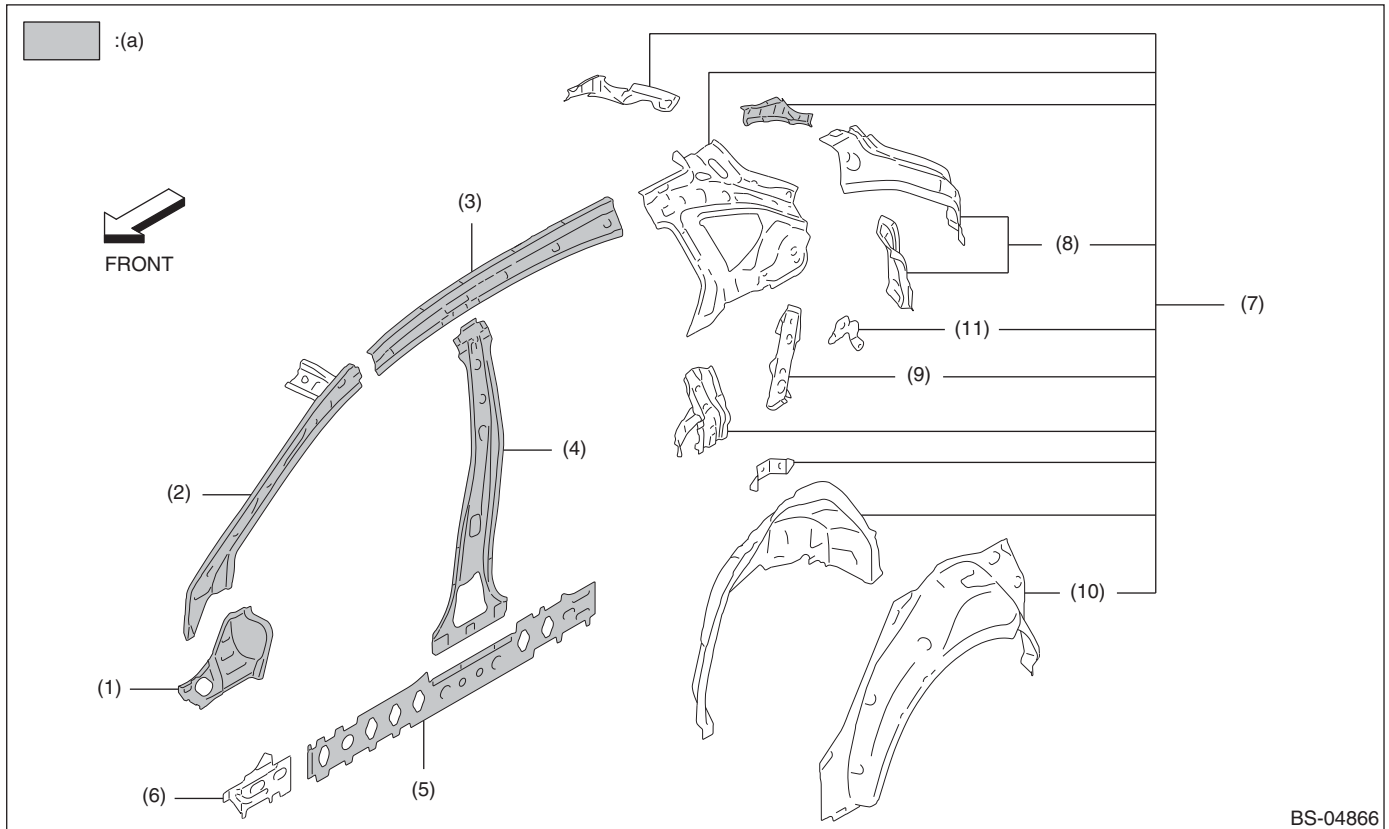
(2) Front roof rail

(4) Roof center brace

Panel Components

9. SIDE PANEL INNER

• 5 Door



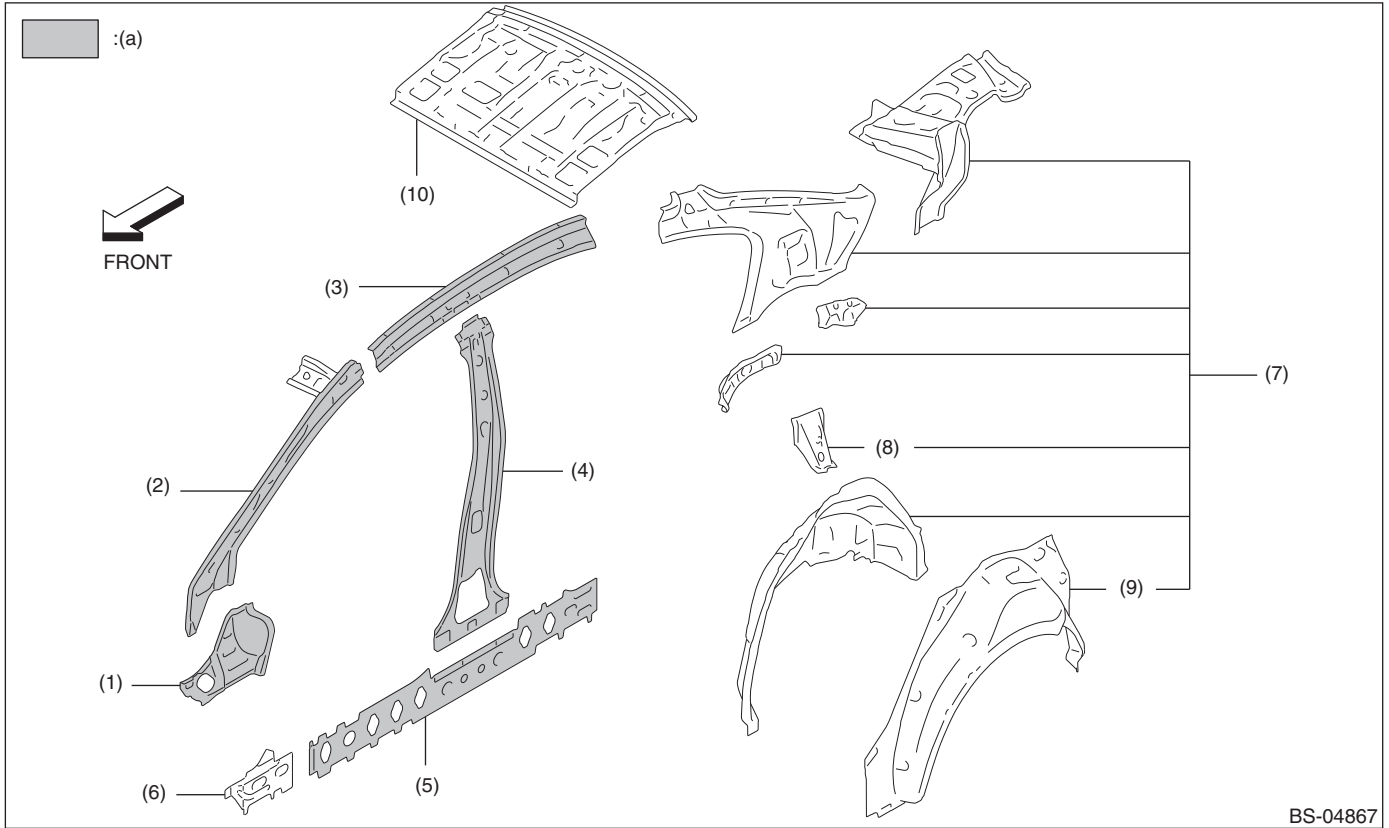
BS-04866

(a) High-strength tensile steel
(440-590 MPa class)

- | | | |
|-------------------------------|---|---------------------------------------|
| (1) Front pillar inner center | (5) Side sill reinforcement inner | (9) Rear quarter reinforcement center |
| (2) Front pillar inner upper | (6) Side sill reinforcement inner front | (10) Rear arch inner |
| (3) Side rail inner | (7) Rear quarter inner | (11) Retractor bracket rear |
| (4) Center pillar inner | (8) D-pillar reinforcement | |

Panel Components

• 4 Door



(a) High-strength tensile steel
(440-590 MPa class)

- (1) Front pillar inner center
- (2) Front pillar inner upper
- (3) Side rail inner
- (4) Center pillar inner

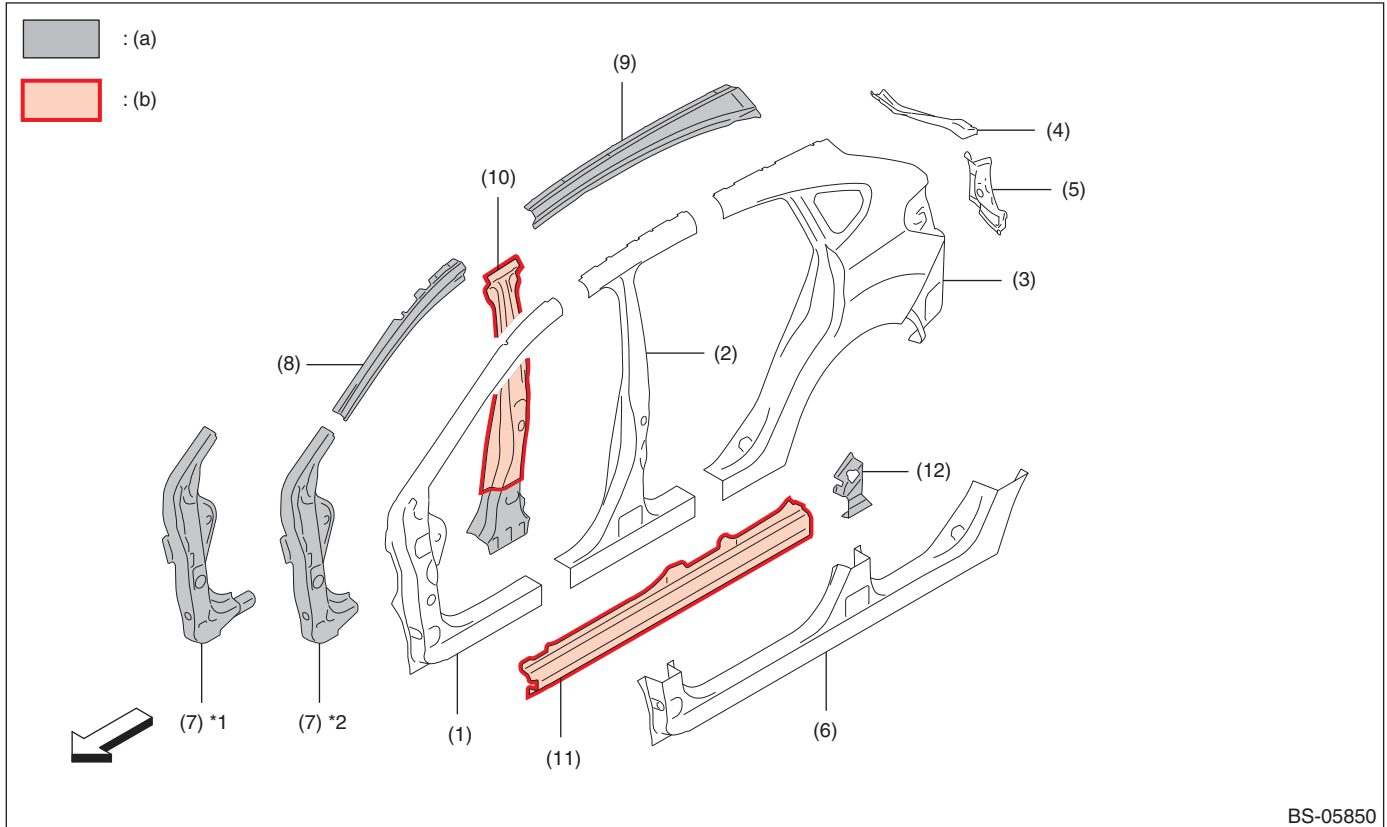
- (5) Side sill reinforcement inner
- (6) Side sill reinforcement inner front
- (7) Rear quarter inner
- (8) Rear pillar reinforcement

- (9) Rear arch inner
- (10) Rear panel

Panel Components

10. SIDE PANEL OUTER

• 5 Door



BS-05850

(a) High-strength tensile steel
(440-590 MPa class)

(b) High-strength tensile steel
(980 MPa class)

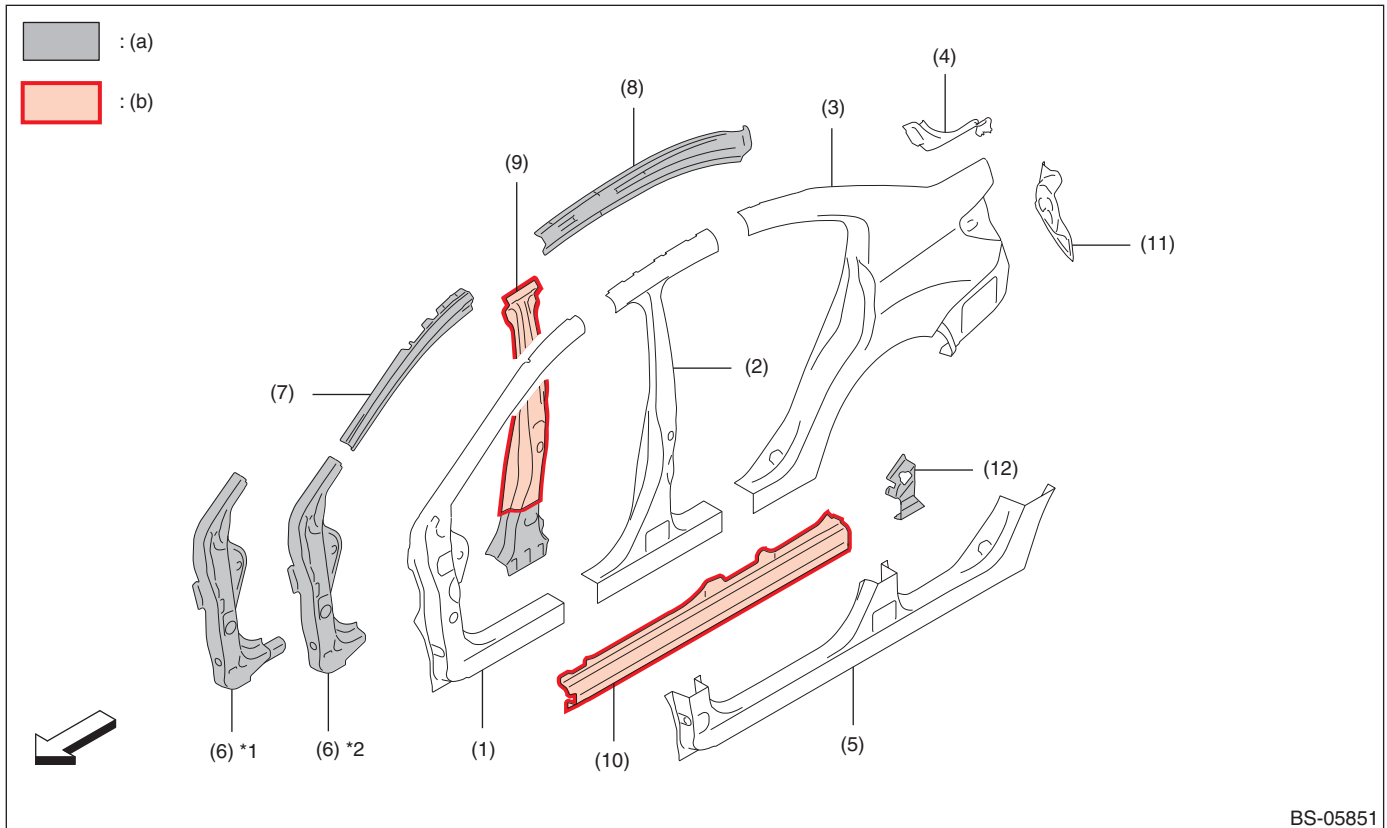
*1: LH of the 14MY

*2: Both sides of the model up to the 13MY and RH of the 14MY

- | | | |
|-------------------------|---|---|
| (1) Front pillar outer | (5) Rear quarter end | (9) Side rail reinforcement outer rear |
| (2) Center pillar outer | (6) Side sill outer | (10) Center pillar reinforcement |
| (3) Rear quarter outer | (7) Front pillar reinforcement lower | (11) Side sill reinforcement outer |
| (4) D-pillar extension | (8) Side rail reinforcement outer front | (12) Rear quarter catcher reinforcement |

Panel Components

• 4 Door



BS-05851

(a) High-strength tensile steel
(440-590 MPa class)

(b) High-strength tensile steel
(980 MPa class)

*1: LH in the 14MY

*2: Both sides of the model up to 13MY, and RH of the 14MY

- | | | |
|-------------------------|---|---|
| (1) Front pillar outer | (5) Side sill outer | (9) Center pillar reinforcement |
| (2) Center pillar outer | (6) Front pillar reinforcement lower | (10) Side sill reinforcement outer |
| (3) Rear quarter outer | (7) Side rail reinforcement outer front | (11) Rear quarter end |
| (4) Rear pillar patch | (8) Side rail reinforcement outer rear | (12) Rear quarter catcher reinforcement |

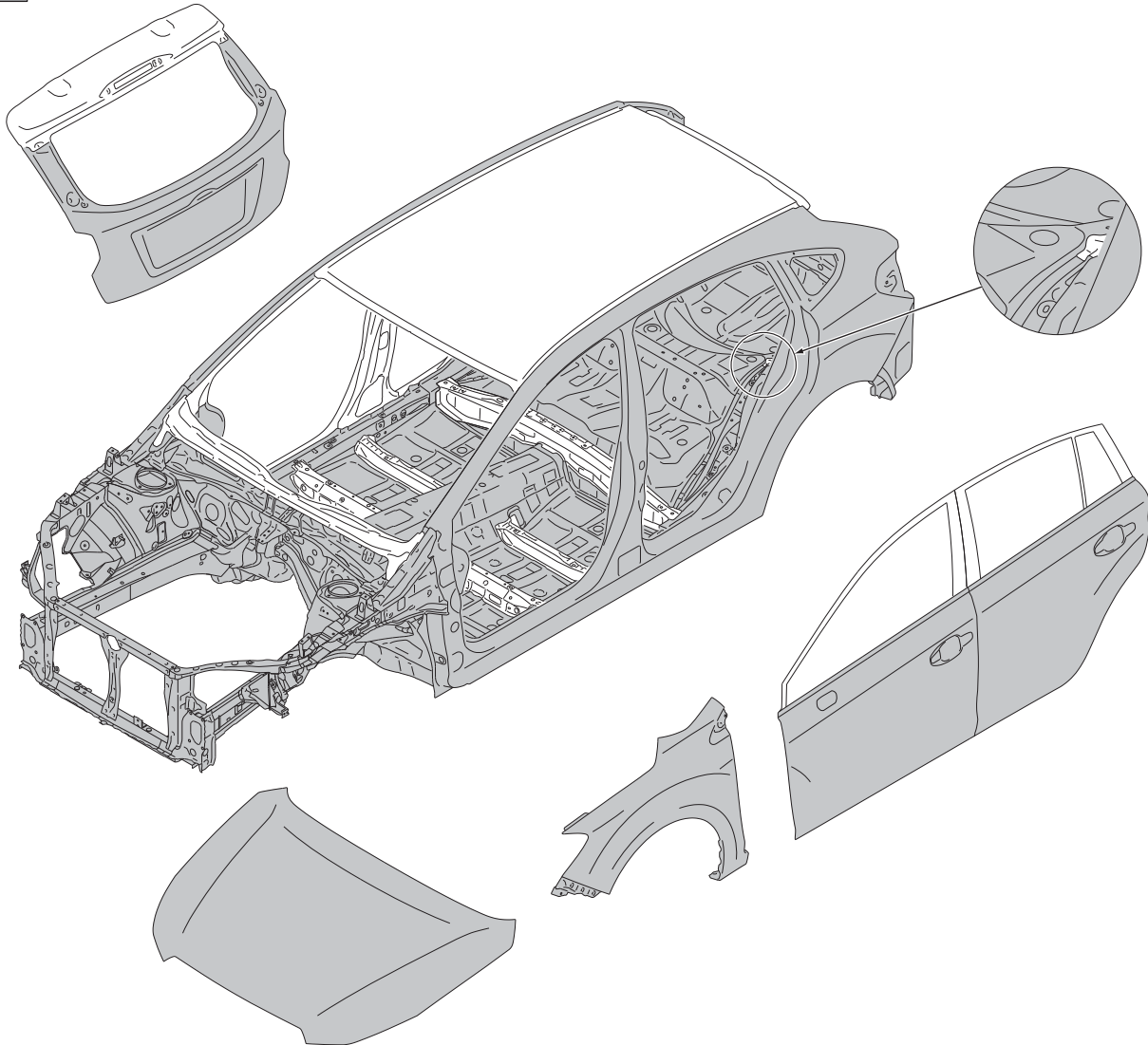
3. Galvanized Sheet Metal

A: SPECIFICATION

1. COMMON PARTS FOR 5 DOOR AND 4 DOOR

- Except for Hybrid model

■ : (1)



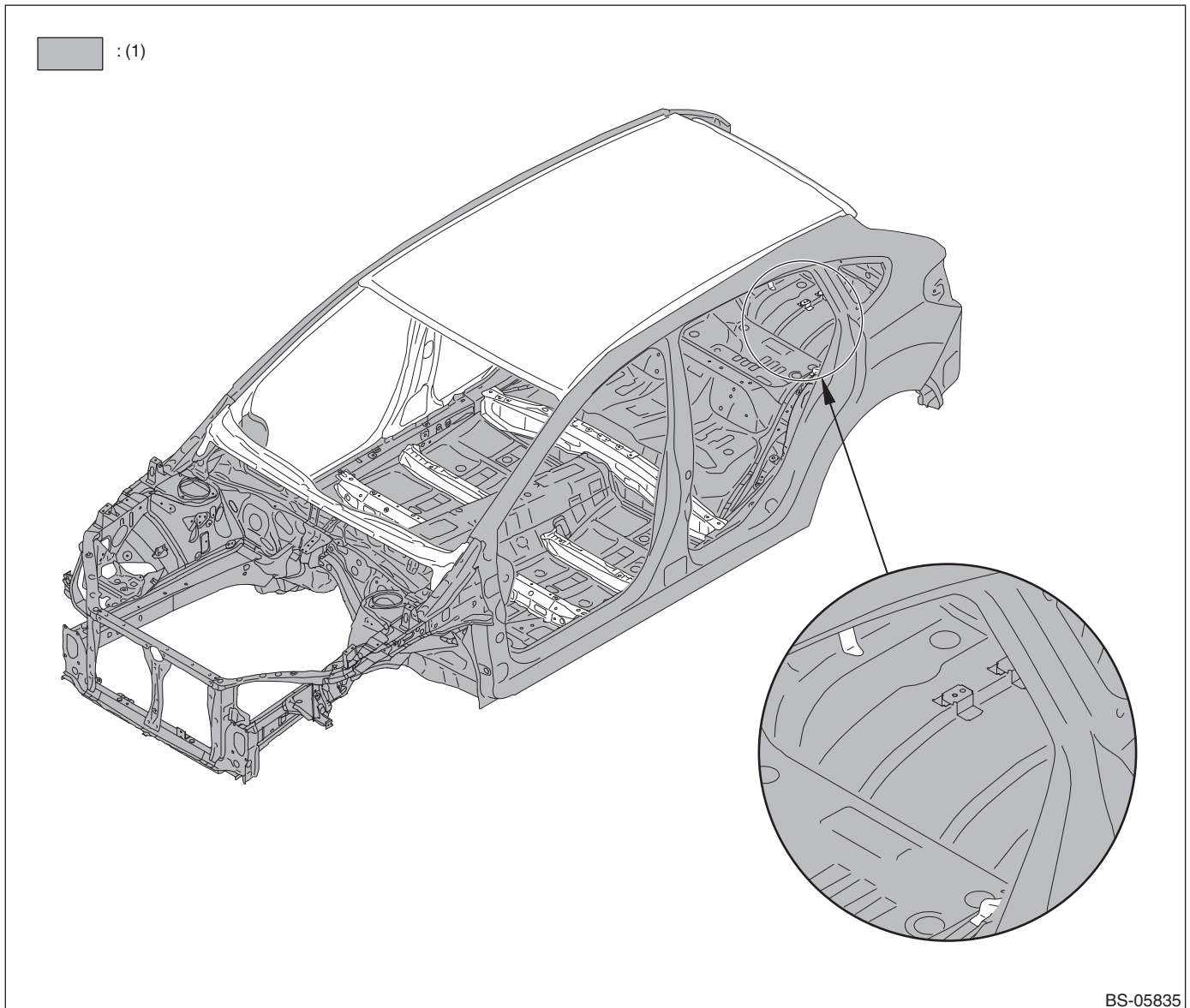
BS-05063

- (1) Galvanized sheet metal (Both sides)

The fuel flap consists of galvanized sheet metal.

Galvanized Sheet Metal

- Hybrid medel

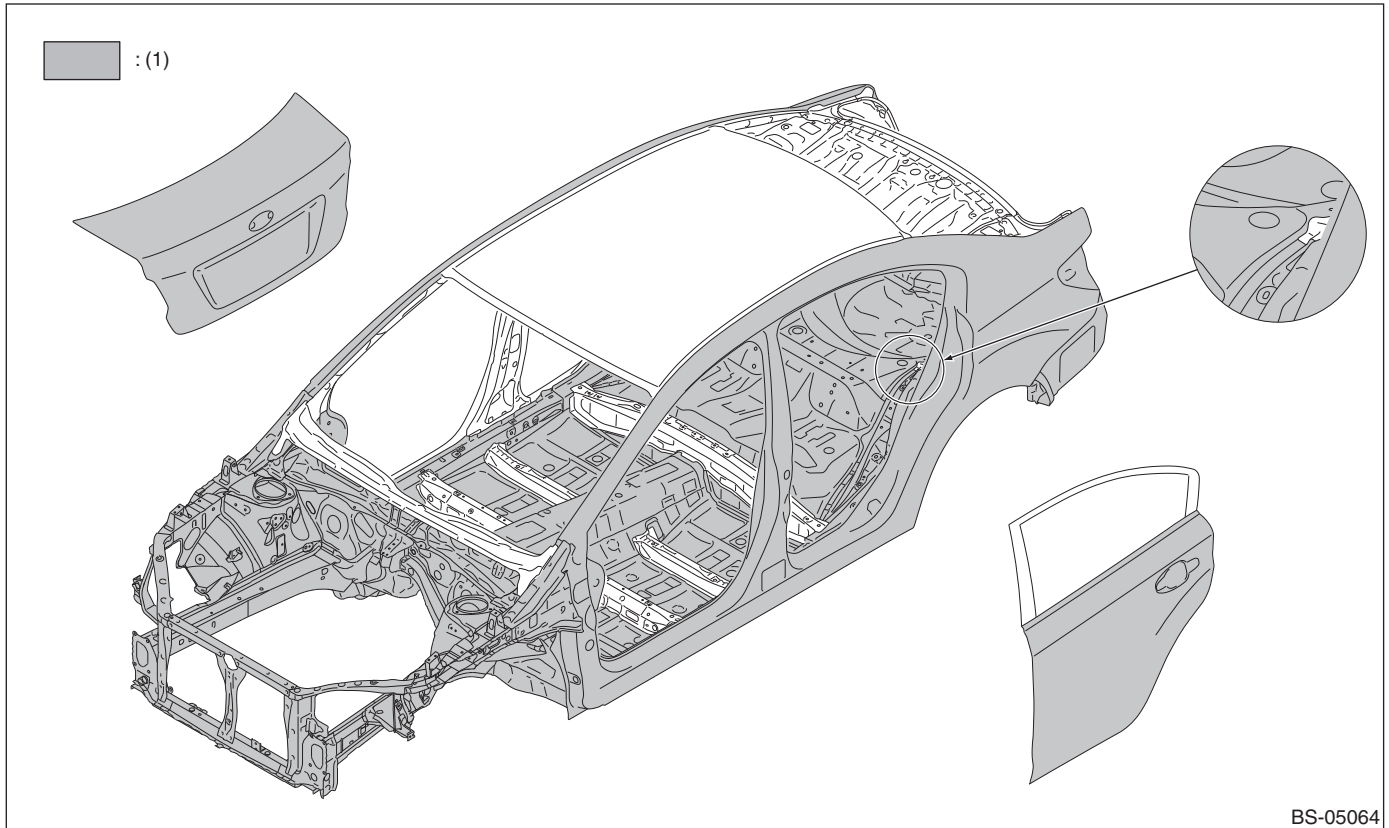


(1) Galvanized sheet metal (Both sides)

- The fuel flap consists of galvanized sheet metal.
- All models other than the 5-door hybrid models share the same parts, except for the vehicle body.

Galvanized Sheet Metal

2. SPECIAL 4 DOOR PARTS



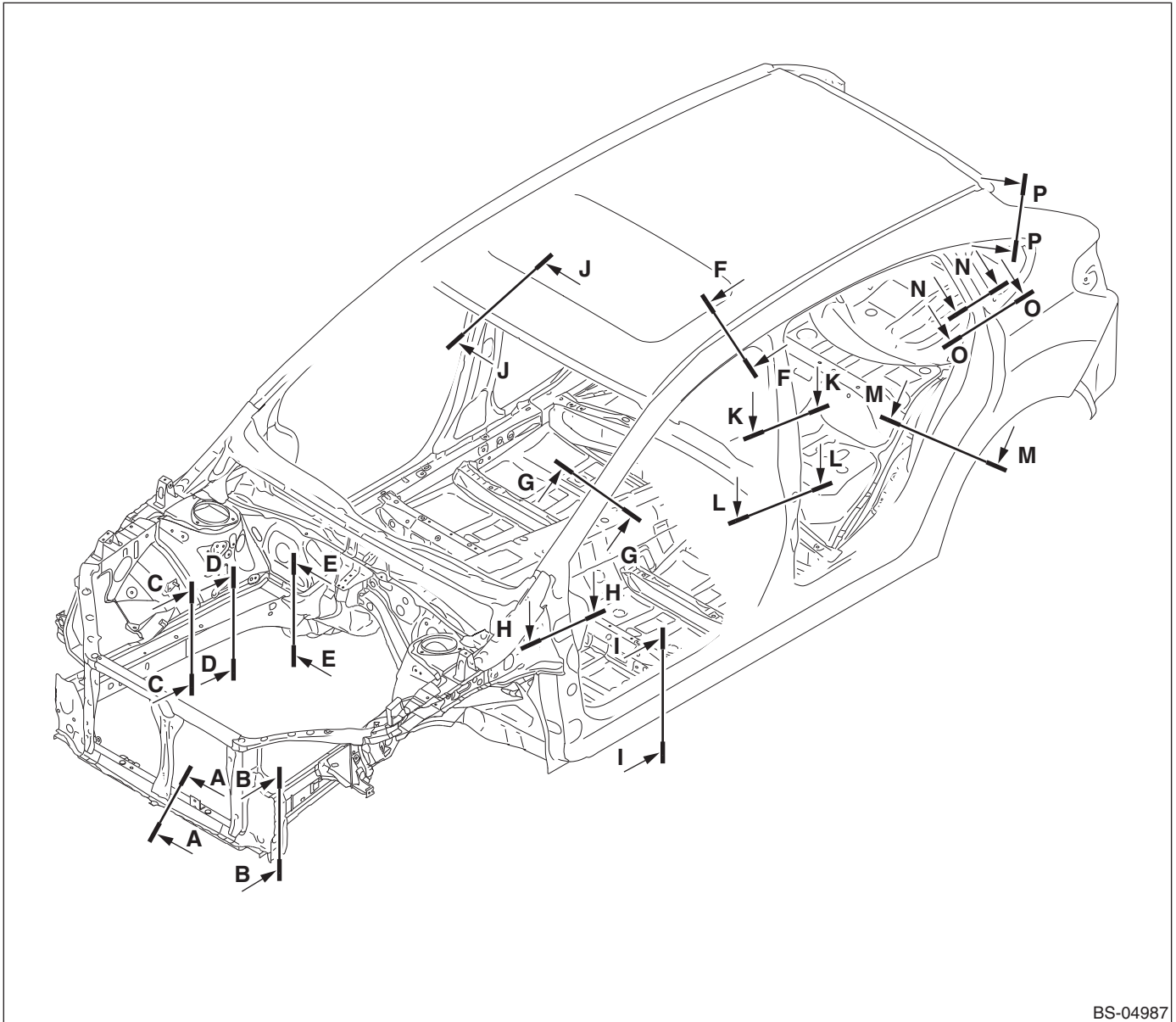
- (1) Galvanized sheet metal (Both sides)

The fuel flap consists of galvanized sheet metal.

4. Body Construction

A: SPECIFICATIONS

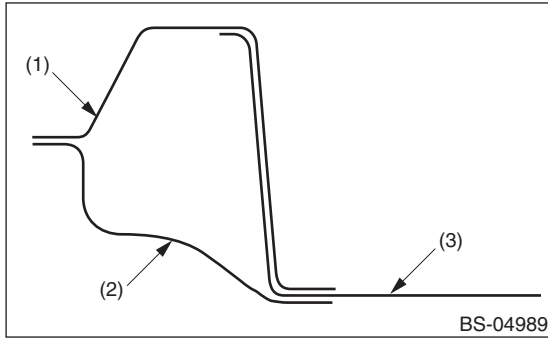
1. COMMON PARTS FOR 5 DOOR AND 4 DOOR



BS-04987

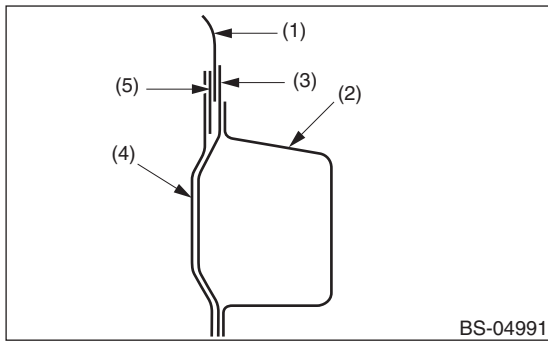
Body Construction

Cross section A — A



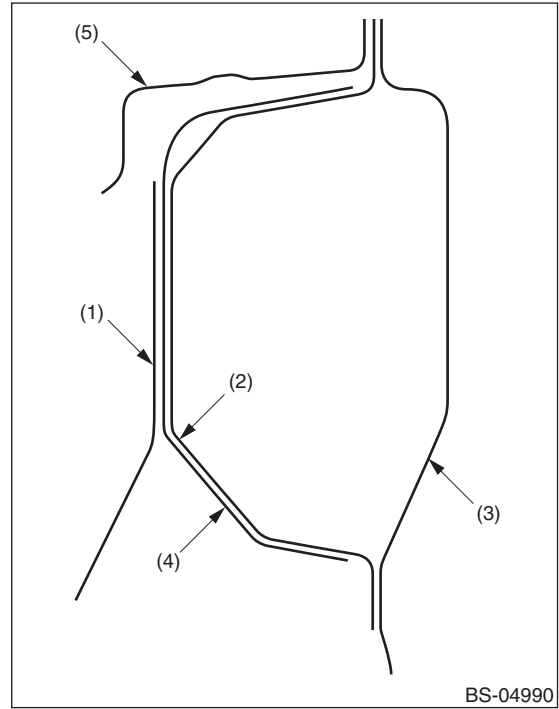
- (1) Radiator lower frame A
- (2) Radiator lower frame B
- (3) Radiator bracket

Cross section C — C



- (1) Front wheel apron
- (2) Frame side frame front
- (3) Closing plate front
- (4) Front suspension lower reinforcement
- (5) Front suspension lower bracket

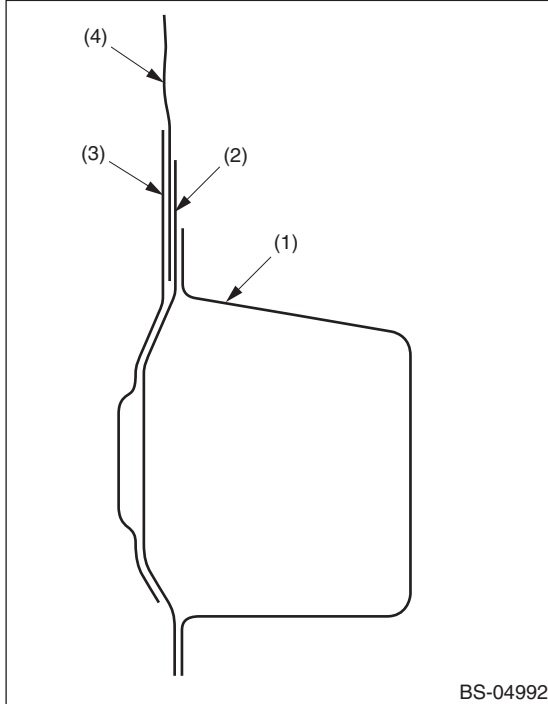
Cross section B — B



- (1) Front gusset front A
- (2) Front side frame front
- (3) Hook reinforce
- (4) Bumper bracket
- (5) Bumper bracket rear

Body Construction

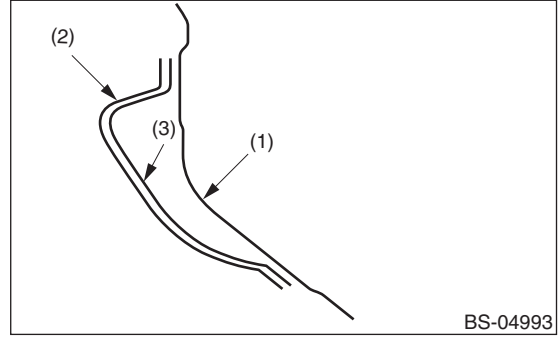
Cross section D — D



BS-04992

- (1) Front side frame front
- (2) Closing plate
- (3) Front suspension lower reinforcement
- (4) Front suspension lower bracket

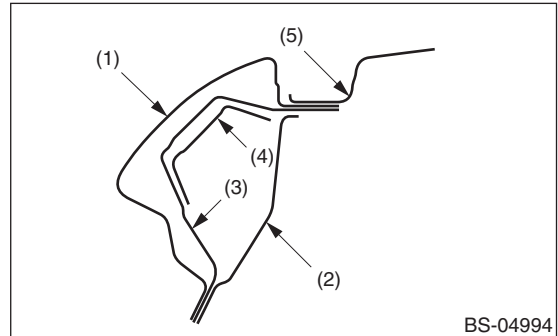
Cross section E — E



BS-04993

- (1) Toe board
- (2) Toe board center crossmember
- (3) Toe board side crossmember

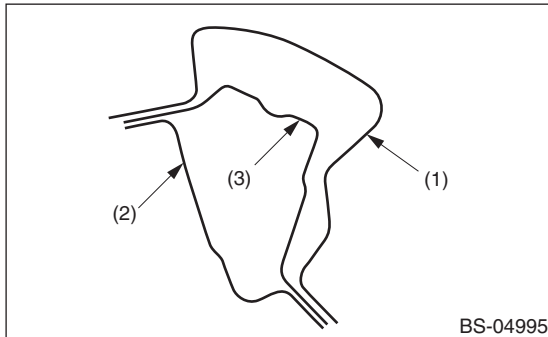
Cross section F — F



BS-04994

- (1) Panel side outer
- (2) Side rail inner
- (3) Side rail reinforcement rear
- (4) Side rail reinforcement A
- (5) Roof panel

Cross section G — G

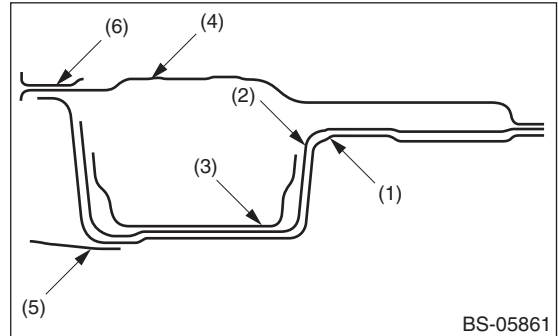


BS-04995

- (1) Panel side outer
- (2) Front pillar inner upper
- (3) Side rail reinforcement front outer

Cross section H — H

(Both sides of the model up to the 13MY, and RH of the 14MY)

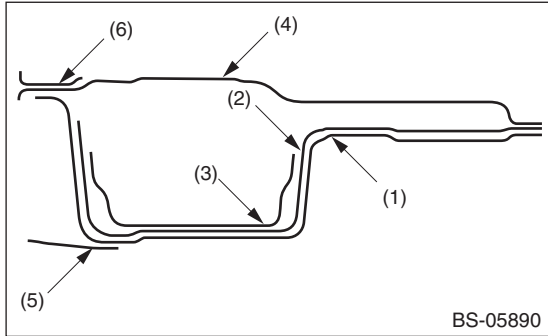


BS-05861

- (1) Panel side outer
- (2) Front pillar reinforcement
- (3) Front pillar hinge reinforcement
- (4) Front pillar inner upper
- (5) Side frame gusset upper
- (6) Front pillar inner upper (Only 14MY)

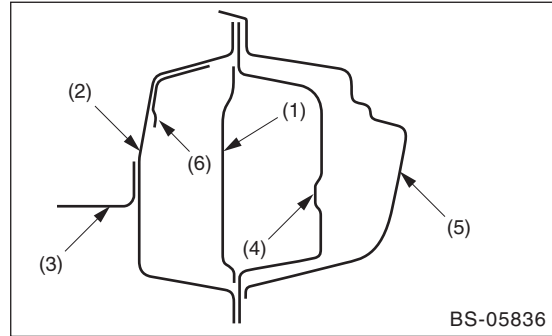
Body Construction

Cross section H — H (Only LH of the 14MY)



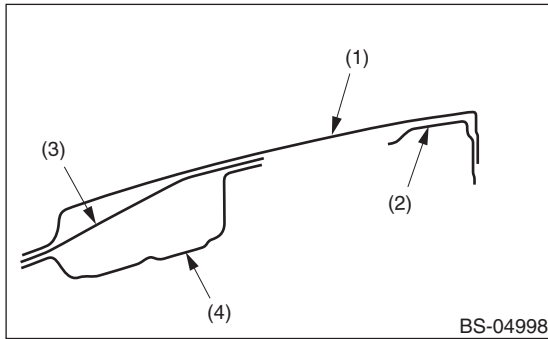
- (1) Panel side outer
- (2) Front pillar reinforcement
- (3) Front pillar hinge reinforcement
- (4) Front pillar inner upper
- (5) Side frame gusset upper
- (6) Front pillar inner upper

Cross section I — I



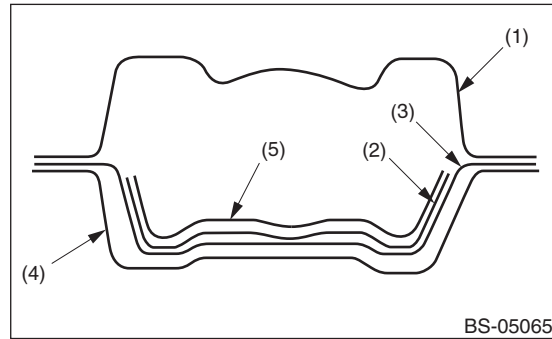
- (1) Reinforcement sill side
- (2) Side sill inner
- (3) Floor pan front
- (4) Reinforcement sill side outer
- (5) Panel side outer
- (6) Reinforcement sill side front (Only 14MY)

Cross section J — J



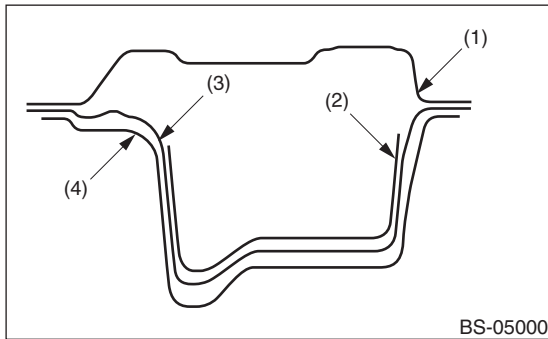
- (1) Roof panel
- (2) Frame sunroof
- (3) Front rail upper
- (4) Front rail lower

Cross section K — K



- (1) Pillar center inner
- (2) Reinforcement pillar center outer A
- (3) Reinforcement pillar center outer
- (4) Panel side outer
- (5) Reinforcement pillar center outer B

Cross section L — L

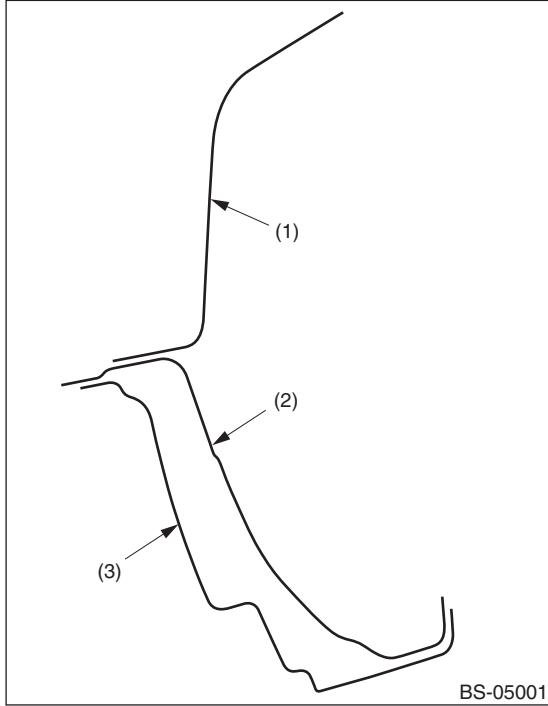


- (1) Pillar center inner
- (2) Reinforcement pillar center outer A
- (3) Reinforcement pillar center outer
- (4) Panel side outer

SUBARU.

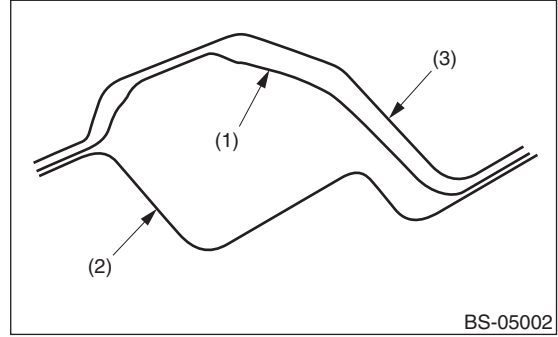
Body Construction

Cross section M — M



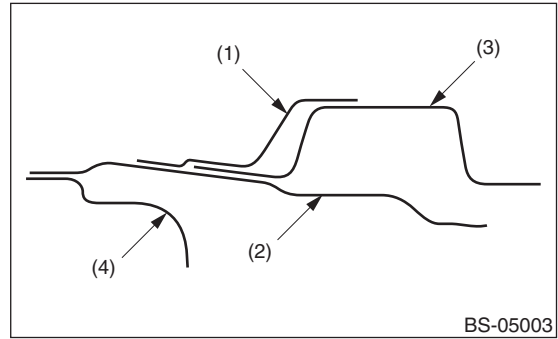
- (1) Wheel apron rear
- (2) Arch rear inner
- (3) Panel side outer

Cross section N — N



- (1) Quarter panel rear inner
- (2) Panel side outer
- (3) Reinforcement C-pillar

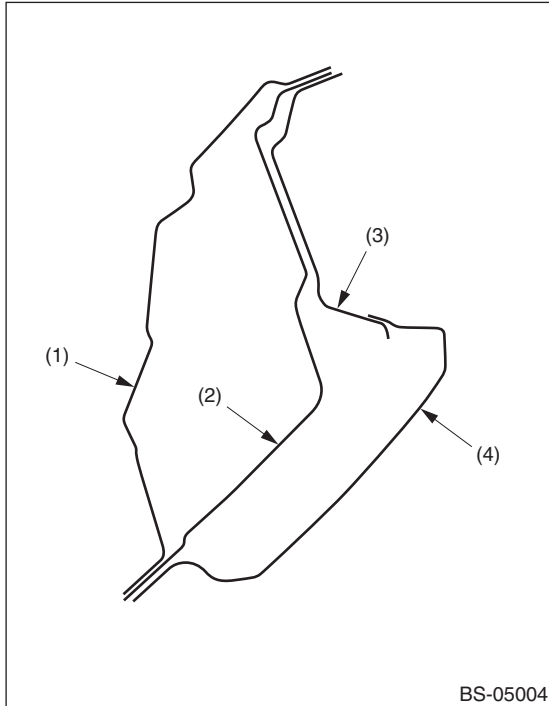
Cross section O — O



- (1) Reinforcement striker inner
- (2) Quarter panel rear inner
- (3) Reinforcement C-pillar
- (4) Panel side outer

Body Construction

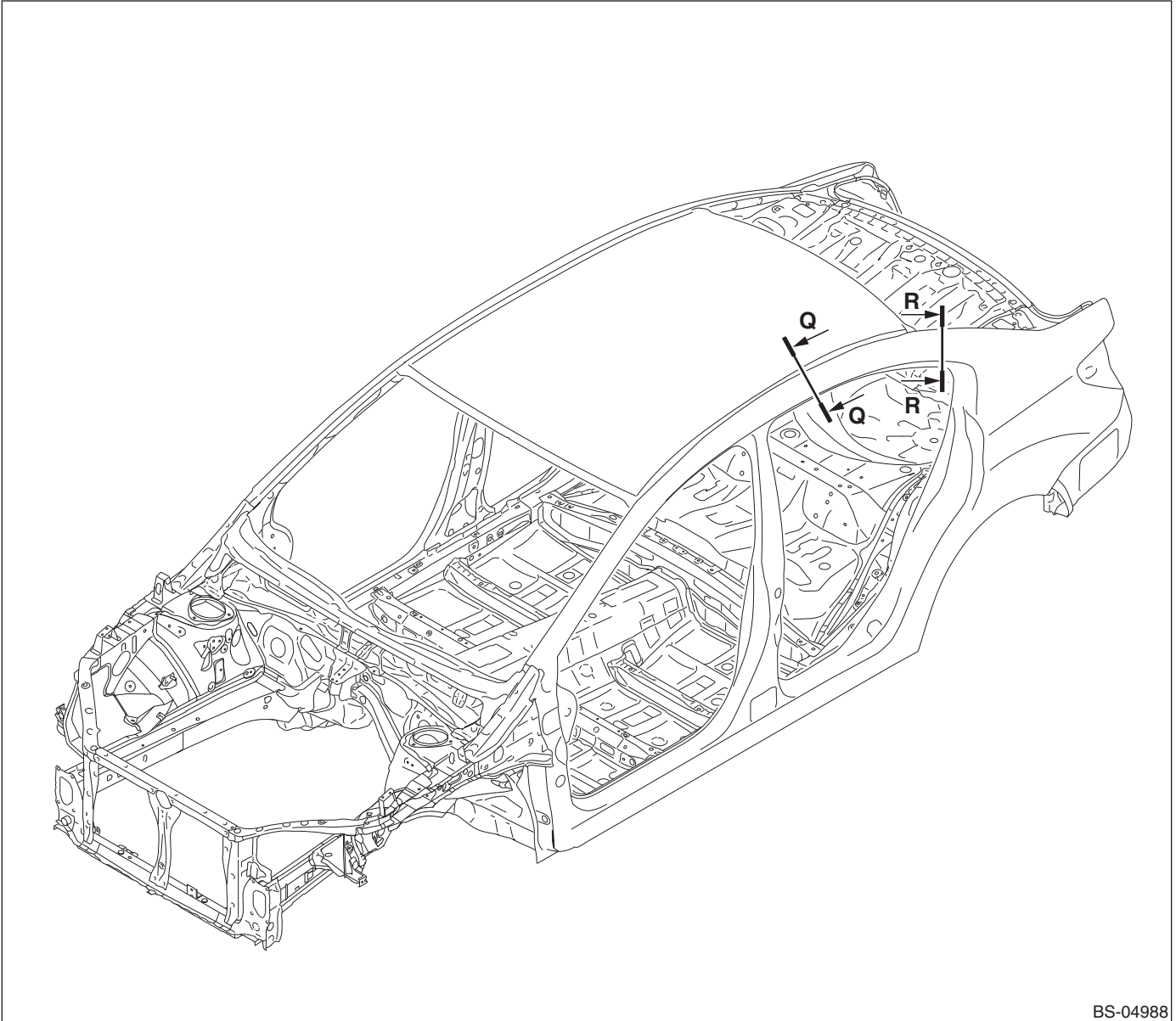
Cross section P — P



- (1) Quarter panel rear inner
- (2) Reinforcement D-pillar
- (3) Extension D-pillar
- (4) Panel side outer

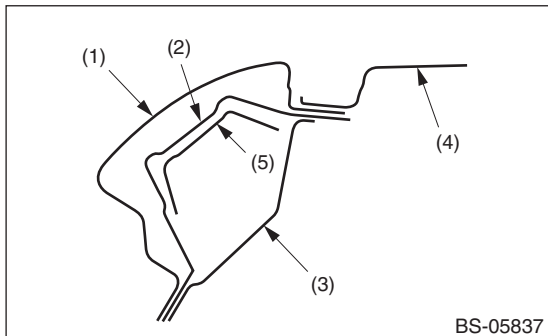
SUBARU.

2. SPECIAL 4 DOOR PARTS



BS-04988

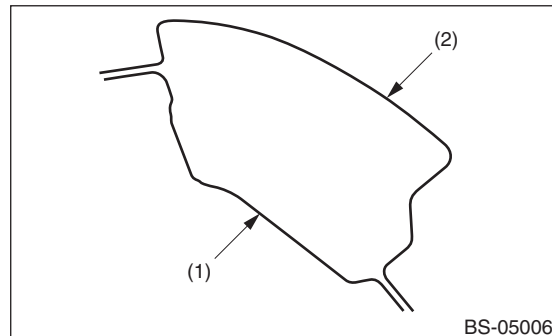
Cross section Q — Q



BS-05837

- (1) Panel side outer
- (2) Reinforcement rail side outer
- (3) Rail side inner
- (4) Roof panel
- (5) Side rail reinforcement

Cross section R — R



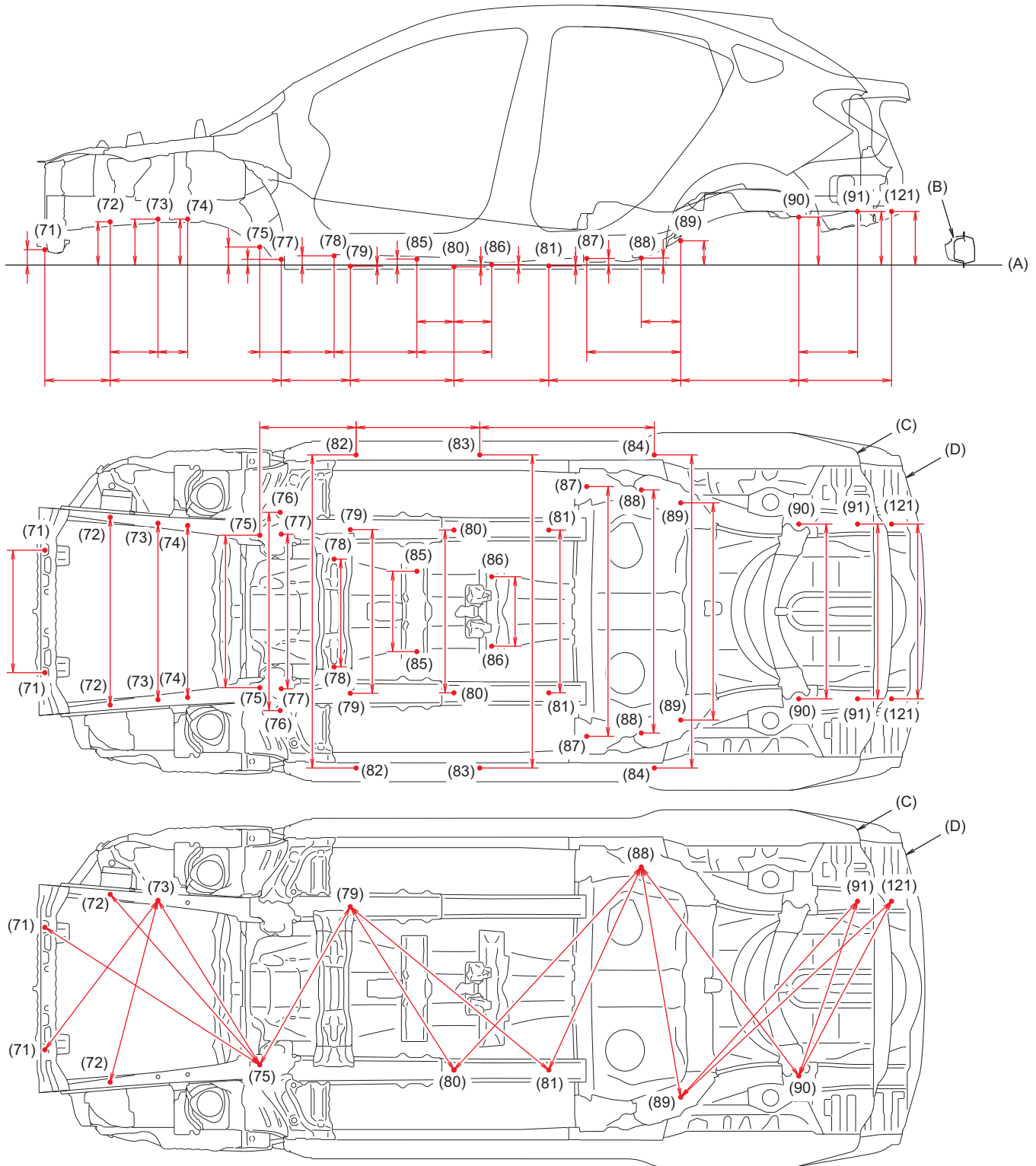
BS-05006

- (1) Pillar rear inner
- (2) Panel side outer

5. Body Reference Points

A: DIMENSIONS

1. LOWER SURFACE



BS-04822

- The longitudinal dimensions are projected dimensions.

Body Reference Points

- The figure shows models other than hybrid models. Hybrid models have a different rear floor shape, and the rear-front position of (78) and (79) is reversed.
- The 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.

(A) Standard line

(B) Side sill outer panel

(C) 5 Door

(D) 4 Door

(71) Front bumper bracket mounting hole (symmetrical)	(78) *2 CVT crossmember mounting hole (symmetrical)	(86) Exhaust cover mounting hole (symmetrical)
(72) Radio ground mounting hole (symmetrical)	(79) *1 Under cover mounting hole (symmetrical)	(87) Gauge hole (symmetrical)
(73) Front crossmember mounting hole (symmetrical), front	(79) *2 T/M under cover mounting hole (symmetrical)	(88) Rear suspension support sub frame mounting hole (symmetrical)
(74) Front crossmember mounting hole (symmetrical), rear	(80) Under cover mounting hole (symmetrical)	(89) Rear suspension crossmember mounting hole (symmetrical)
(75) Front suspension arm mounting hole (symmetrical)	(81) Under cover mounting hole (symmetrical)	(90) Rear suspension crossmember mounting hole (symmetrical)
(76) Front suspension plate mounting hole (symmetrical), outer side	(82) Side spoiler mounting hole (symmetrical)	(91) Gauge hole (symmetrical) 5 Door
(77) Front suspension plate mounting hole (symmetrical), inner side	(83) Side spoiler mounting hole (symmetrical)	(121) Gauge hole (symmetrical) 4 Door
(78) R *1 CVT crossmember mounting hole (right side)	(84) Side spoiler mounting hole (symmetrical)	
(78)L *1 CVT crossmember mounting hole (left side)	(85) Gauge hole (symmetrical)	

*1: Except for Hybrid model

*2: Hybrid model

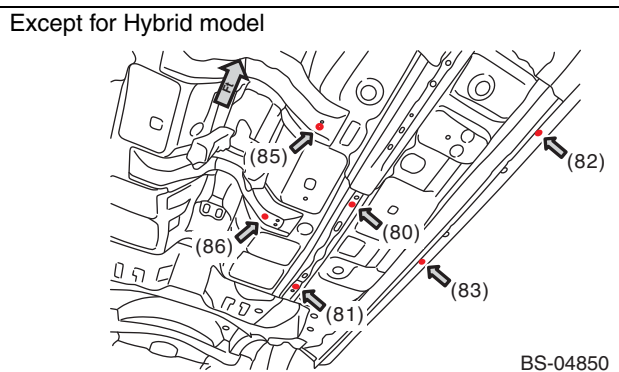
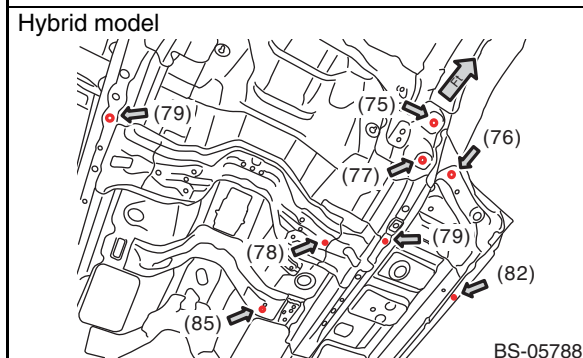
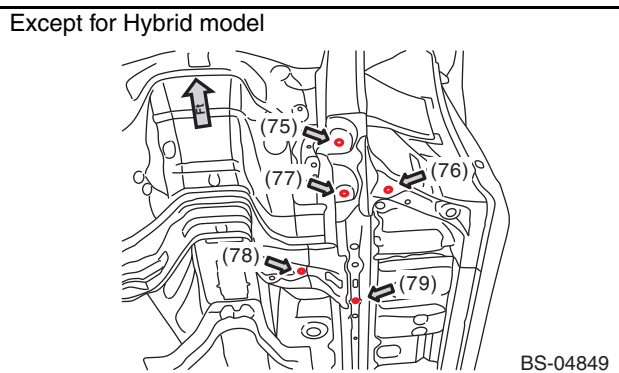
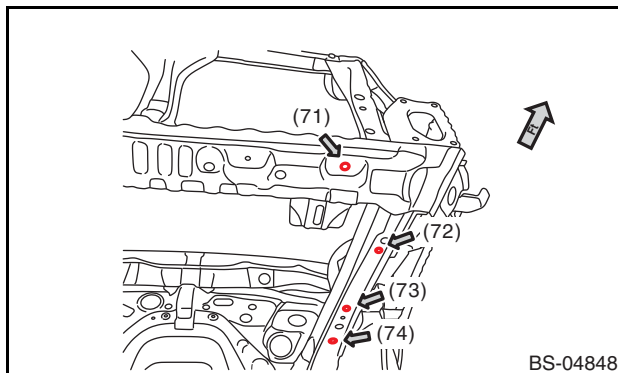
Measuring point	Datum dimension mm (in)	Projected dimensions mm (in)
Datum line — (71)	75 (2.95)	—
Datum line — (72)	210 (8.27)	—
Datum line — (73)	223 (8.78)	—
Datum line — (74)	223 (8.78)	—
Datum line — (75)	88 (3.46)	—
Datum line — (77)	28 (1.10)	—
*1 Datum line — (78) R	45 (1.77)	—
*2 Datum line — (78)	36 (1.41)	—
*1 Datum line — (79)	-6 (-0.24)	—
*2 Datum line — (79)	-6 (-0.24)	—
Datum line — (80)	-9 (-0.35)	—
Datum line — (81)	-4 (-0.16)	—
Datum line — (85)	29 (1.14)	—
Datum line — (86)	2 (0.08)	—
Datum line — (87)	32 (1.26)	—
Datum line — (88)	34 (1.34)	—
Datum line — (89)	118 (4.65)	—
Datum line — (90)	233 (9.17)	—
Datum line — (91)	260 (10.24)	—

Measuring point	Datum dimension mm (in)	Projected dimensions mm (in)
Datum line — (121)	260 (10.24)	—
(71) — (72)	317 (12.48)	—
(72) — (73)	232 (9.13)	—
(72) — (77)	830 (32.68)	—
(73) — (74)	144 (5.67)	—
(75) — (77)	104 (4.09)	—
(75) — (82)	467 (18.39)	—
*1 (77) — (78) R	257 (10.12)	—
*2 (77) — (79)	257 (10.12)	—
*1 (77) — (79)	335 (13.19)	—
*2 (77) — (78)	357 (14.06)	—
*1 (78)R — (85)	402 (15.83)	—
*2 (78) — (85)	302 (11.89)	—
*1 (79) — (80)	503 (19.80)	—
*2 (79) — (80)	581 (22.87)	—
(80) — (81)	460 (18.11)	—
(80) — (85)	180 (7.09)	—
(80) — (86)	183 (7.20)	—
(81) — (89)	640 (25.20)	—
(82) — (83)	600 (23.62)	—
(83) — (84)	847 (33.35)	—
(85) — (86)	363 (14.29)	—

Body Reference Points

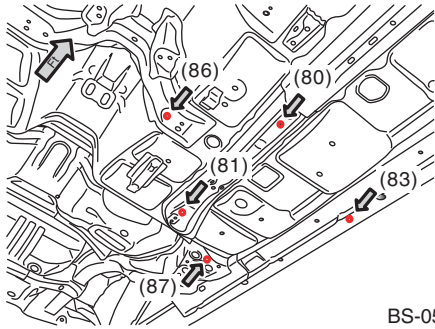
Measuring point	Datum dimension mm (in)	Projected dimen- sions mm (in)
(87) — (89)	456 (17.95)	—
(88) — (89)	191 (7.52)	—
(89) — (90)	573 (22.56)	—
(90) — (91)	285 (11.22)	—
(90) — (121)	450 (17.72)	—
(71) R — (71) L	600 (23.62)	—
(72) R — (72) L	914 (35.98)	—
(73) R — (73) L	862 (33.94)	—
(74) R — (74) L	840 (33.07)	—
(75) R — (75) L	746 (29.37)	—
(76) R — (76) L	968 (38.11)	—
(77) R — (77) L	756 (29.76)	—
*1 (78) R — (78) L	529 (20.83)	—
*2 (78) R — (78) L	504 (19.84)	—
*1 (79) R — (79) L	800 (31.50)	—
*2 (79) R — (79) L	803 (31.61)	—
(80) R — (80) L	796 (31.34)	—
(81) R — (81) L	796 (31.34)	—
(82) R — (82) L	1,525 (60.04)	—
(83) R — (83) L	1,525 (60.04)	—
(84) R — (84) L	1,525 (60.04)	—
(85) R — (85) L	396 (15.59)	—
(86) R — (86) L	343 (13.50)	—

Measuring point	Datum dimension mm (in)	Projected dimen- sions mm (in)
(87) R — (87) L	1,218 (47.95)	—
(88) R — (88) L	1,186 (46.69)	—
(89) R — (89) L	1,060 (41.73)	—
(90) R — (90) L	854 (33.62)	—
(91) R — (91) L	854 (33.62)	—
(121) R — (121) L	854 (33.62)	—
(71) R — (73) L	926 (36.46)	914 (35.98)
(71) L — (75) R	1,241 (48.86)	1,241 (48.86)
(72) R — (73) L	918 (36.14)	918 (36.14)
(72) L — (75) R	1,109 (43.66)	1,103 (43.43)
(73) L — (75) R	953 (37.52)	944 (37.17)
*1 (75) R — (79) L	894 (35.20)	889 (35.00)
*2 (75) R — (79) L	860 (33.84)	860 (33.64)
*1 (79) L — (80) R	943 (37.13)	943 (37.13)
*2 (79) L — (80) R	988 (38.91)	988 (38.91)
*1 (79) L — (81) R	1,251 (49.25)	1,251 (49.25)
*2 (79) L — (81) R	1,313 (51.68)	1,313 (51.68)
(80) R — (88) L	1,345 (52.95)	1,345 (52.95)
(81) R — (88) L	1,089 (42.87)	1,088 (42.83)
(88) L — (89) R	1,142 (44.96)	1,139 (44.84)
(88) L — (90) R	1,290 (50.79)	1,274 (50.16)
(89) R — (91) L	1,293 (50.91)	1,285 (50.59)
(89) R — (121) L	1,408 (55.43)	1,401 (55.16)
(90) R — (91) L	901 (35.47)	900 (35.43)
(90) R — (121) L	966 (38.03)	965 (37.99)



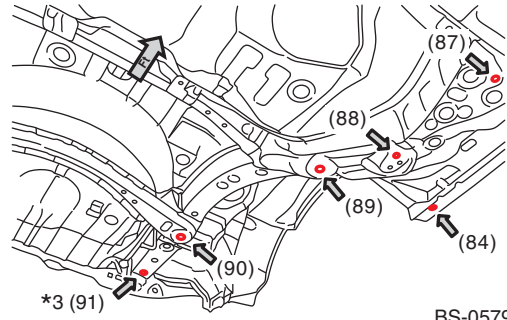
Body Reference Points

Hybrid model



BS-05789

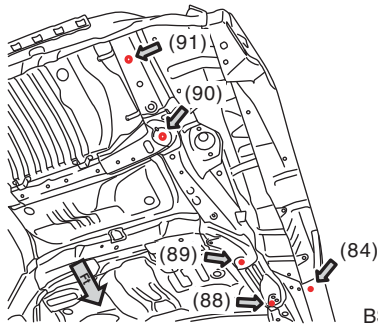
Except for Hybrid model



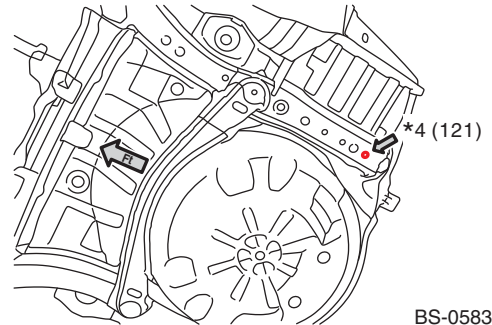
*3 (91)

BS-05797

Hybrid model



BS-05790



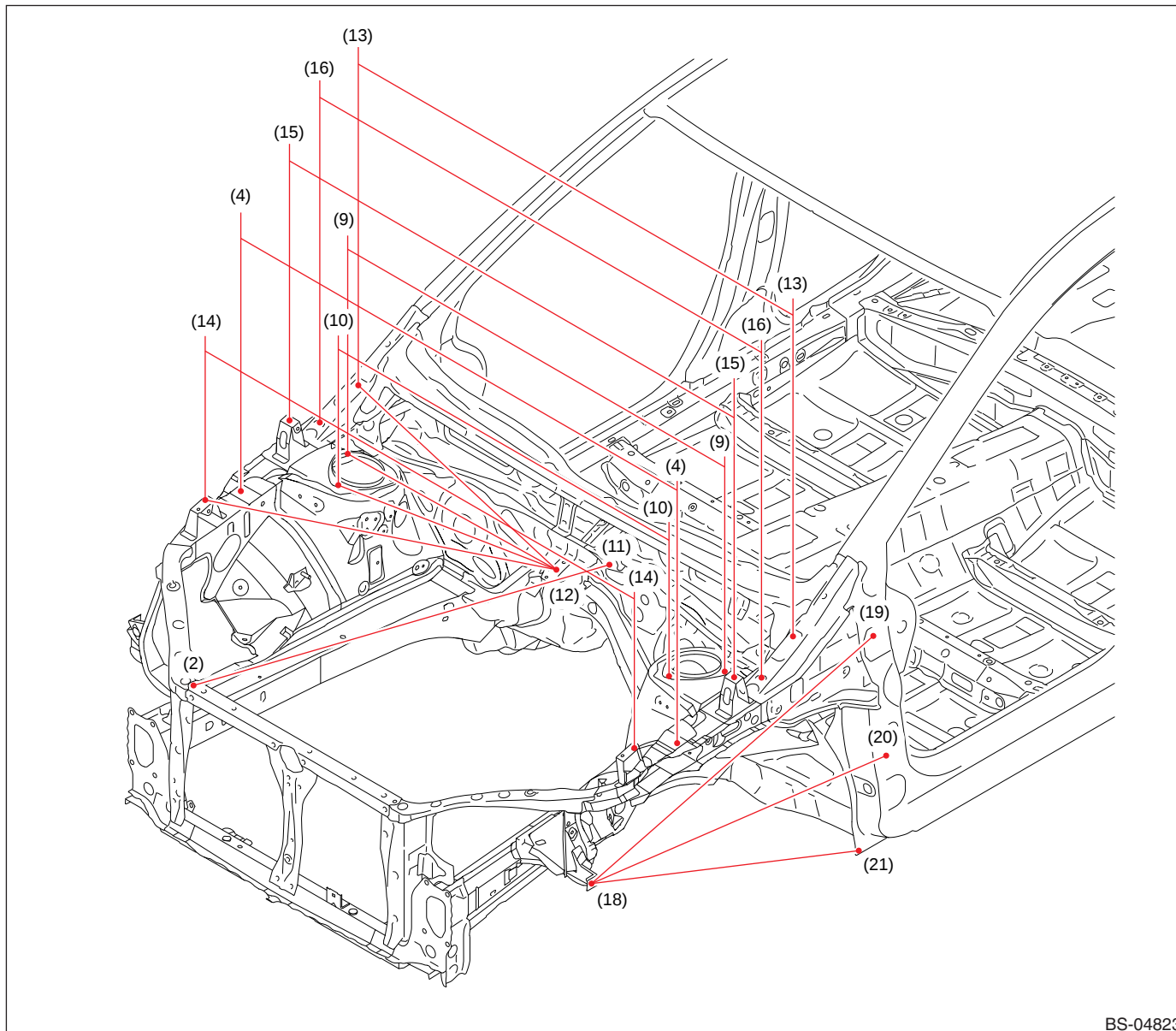
BS-05830

*3: 5 Door

*4: 4 Door

Body Reference Points

2. FRONT 1



BS-04823

- The reference points (12) is at the body center, while the other reference points are left-right symmetrical.
- The dimensions are the actual dimensions between the reference points.

(2) Radiator upper frame mounting hole (symmetrical)	(12) Harness clip mounting hole (body center)	(18) Fender mounting hole (symmetrical)
(4) Fender mounting hole (symmetrical)	(13) Hood hinge rear mounting hole (symmetrical)	(19) Front door hinge upper mounting hole (symmetrical), upper side
(9) Front suspension mounting hole (symmetrical), rear outside	(14) Fender mounting hole (symmetrical)	(20) Front door hinge lower mounting hole (symmetrical), upper side
(10) Front suspension mounting hole (symmetrical), front	(15) Fender mounting hole (symmetrical)	(21) Fender mounting hole (symmetrical)
(11) Bulkhead mounting hole (symmetrical)	(16) Gauge hole (symmetrical)	

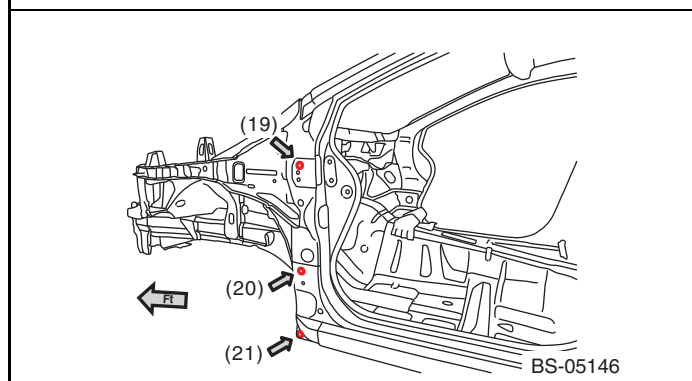
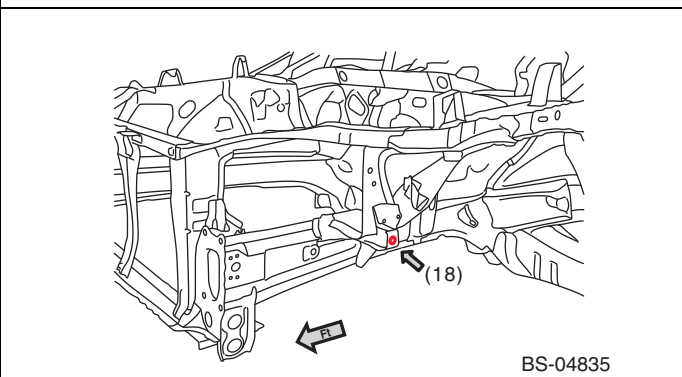
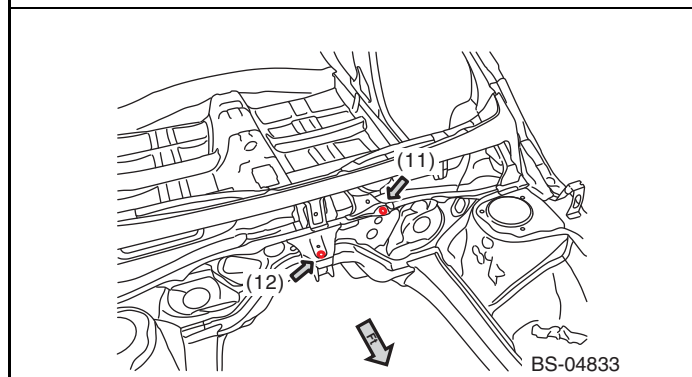
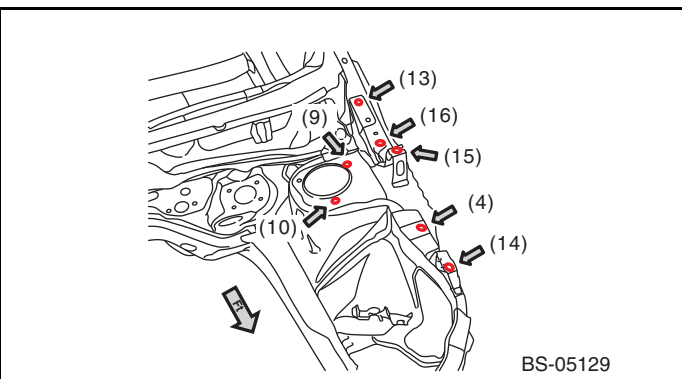
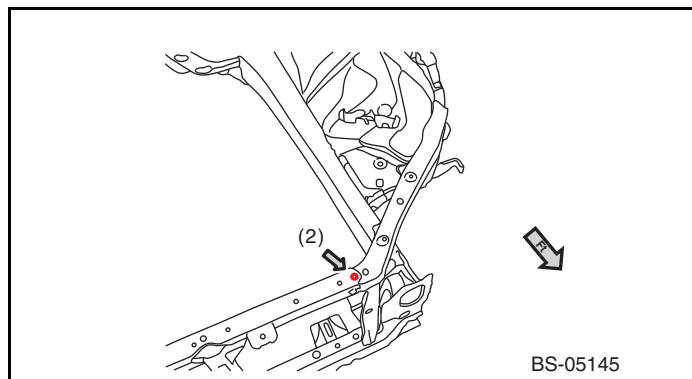
*1: Except for Hybrid model

*2: Hybrid model

Body Reference Points

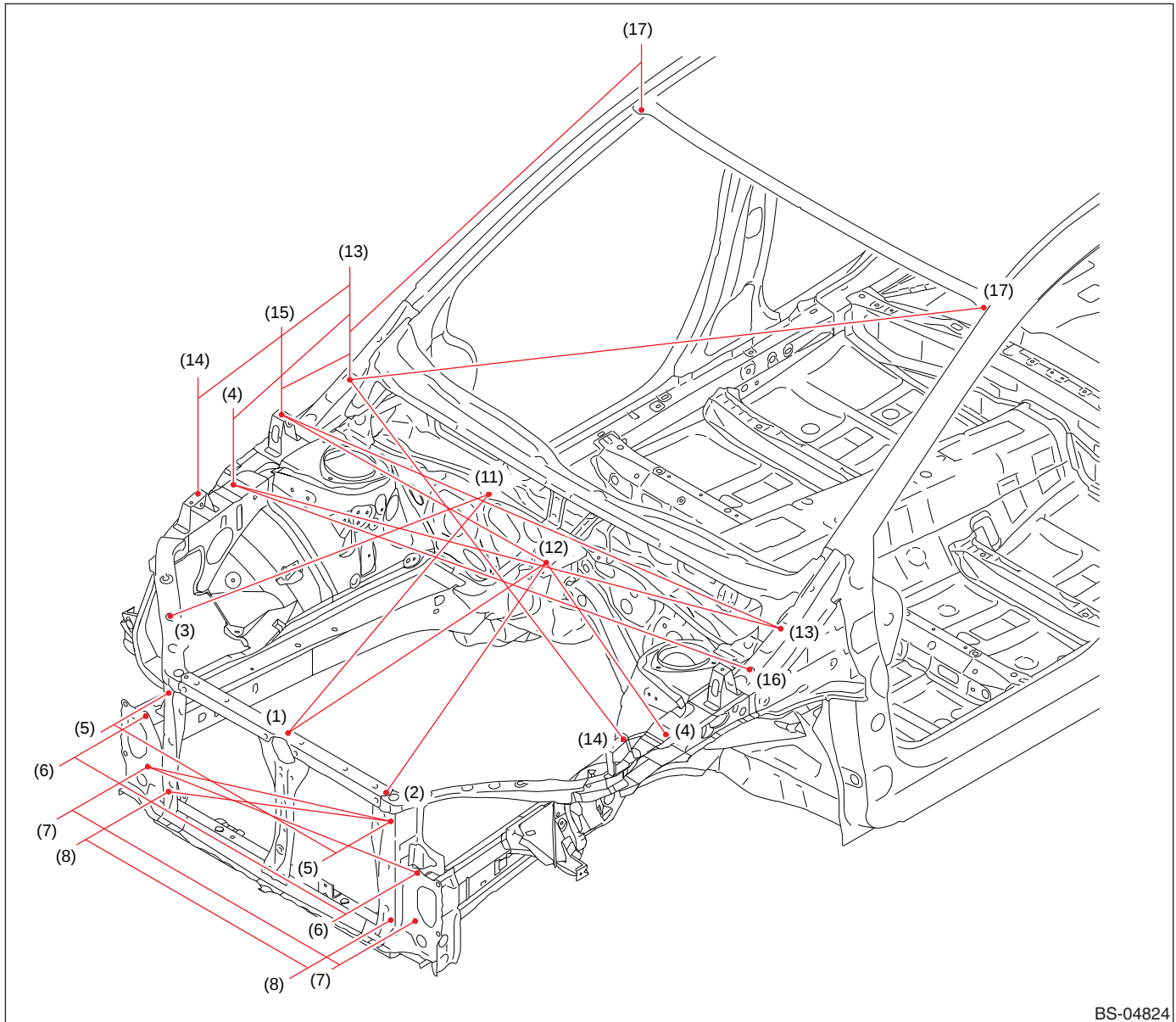
Measuring point	Datum dimension mm (in)
(2) R — (11) L	1,026 (40.39)
(4) R — (4) L	1,456 (57.32)
(9) R — (9) L	1,258 (49.53)
(9) R — (12) L	635 (25.00)
(10) R — (10) L	1,104 (43.46)
(10) R — (12)	582 (22.91)
(12) — (13) R	741 (29.17)
(12) — (14) R	852 (33.54)

Measuring point	Datum dimension mm (in)
(13) R — (13) L	1,451 (57.13)
(14) R — (14) L	1,432 (56.38)
(15) R — (15) L	1,484 (58.43)
(16) R — (16) L	1,474 (58.03)
(18) L — (19) L	961 (37.83)
*1 (18) L — (20) L	954 (37.56)
*2 (18) L — (20) L	952 (37.48)
(18) L — (21) L	987 (38.86)



Body Reference Points

3. FRONT 2



BS-04824

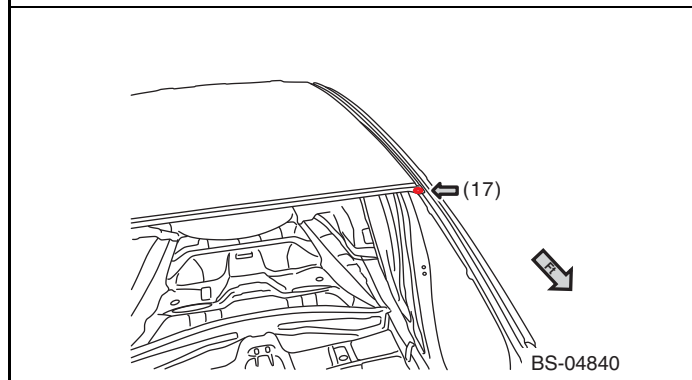
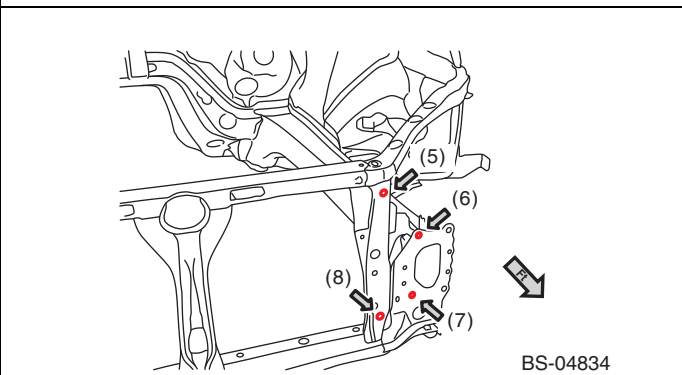
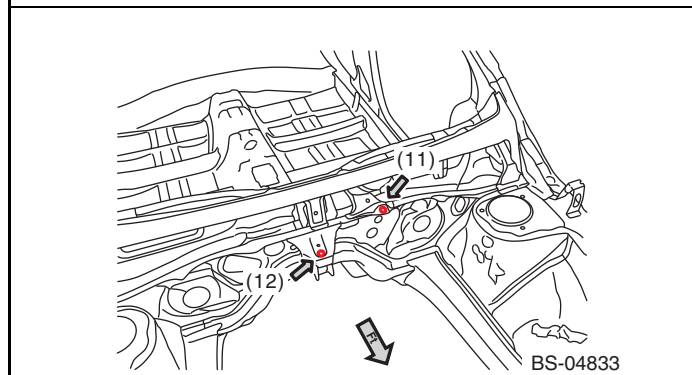
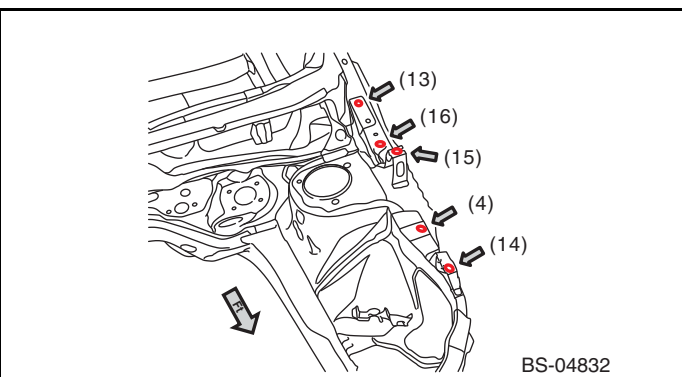
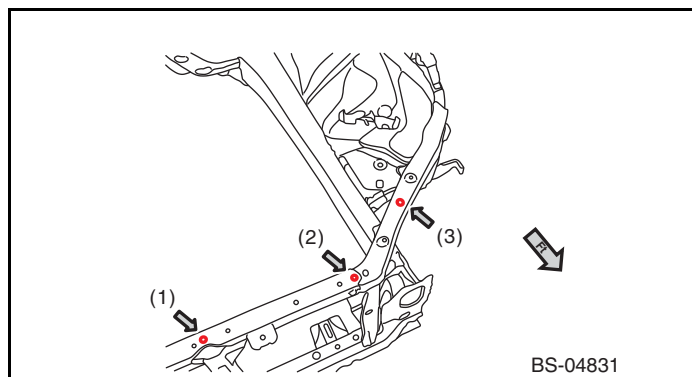
- The reference points (1) and (12) are at the body center, while the other reference points are left-right symmetrical.
- The dimensions are the actual dimensions between the reference points.

(1) Repair location hole (body center)	(6) Bumper bracket mounting hole (symmetrical), upper side	(13) Hood hinge rear mounting hole (symmetrical)
(2) Radiator upper frame mounting hole (symmetrical)	(7) Bumper bracket mounting hole (symmetrical), lower side	(14) Fender mounting hole (symmetrical)
(3) Headlight mounting hole (symmetrical)	(8) Front bumper bracket mounting hole (symmetrical)	(15) Fender mounting hole (symmetrical)
(4) Fender mounting hole (symmetrical)	(11) Bulkhead mounting hole (symmetrical)	(16) Gauge hole (symmetrical)
(5) Corner bracket mounting hole (symmetrical)	(12) Harness clip mounting hole (body center)	(17) Front glass installation reference hole (symmetrical)

Body Reference Points

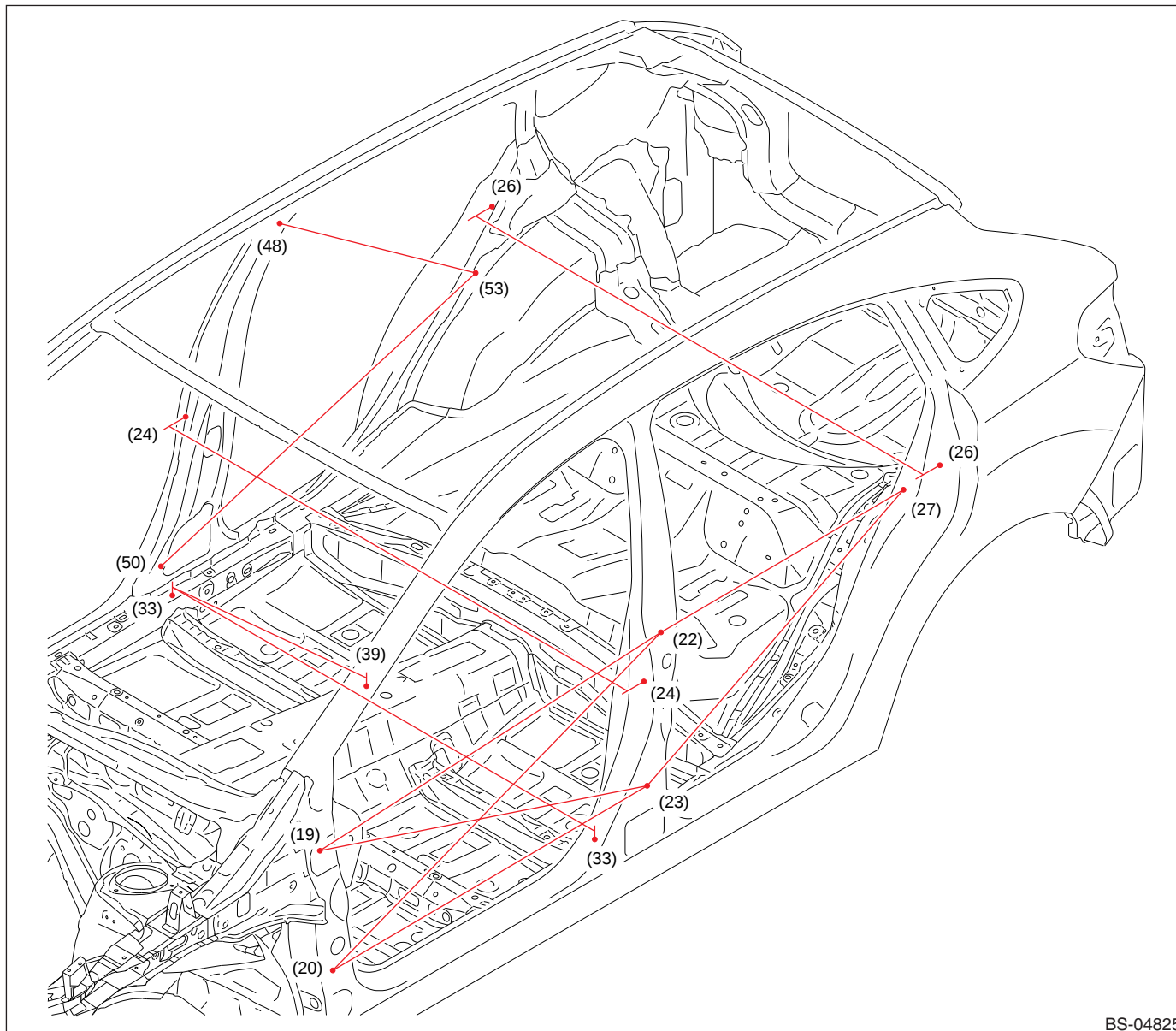
Measuring point	Datum dimension mm (in)
(1) — (11) R	898 (35.35)
(1) — (12)	871 (34.29)
(2) L — (12)	939 (36.97)
(3) R — (11) R	831 (32.72)
(4) L — (12)	798 (31.42)
(4) R — (13) R	405 (15.94)
(4) R — (13) L	1,509 (59.41)
(4) R — (16) L	1,491 (58.70)
(5) R — (5) L	748 (29.45)
(5) L — (7) R	863 (33.98)
(5) L — (8) R	801 (31.54)

Measuring point	Datum dimension mm (in)
(6) R — (6) L	914 (35.98)
(6) L — (7) R	918 (36.14)
(7) R — (7) L	900 (35.43)
(8) R — (8) L	748 (29.45)
(12) — (15) R	769 (30.28)
(13) R — (14) R	525 (20.67)
(13) R — (14) L	1,534 (60.39)
(13) R — (15) R	214 (8.43)
(13) L — (15) R	1,483 (58.39)
(13) R — (17) R	956 (37.64)
(13) R — (17) L	1,608 (63.31)



Body Reference Points

4. INSIDE COMMON PARTS 1 FOR 5 DOOR AND 4 DOOR



BS-04825

- The figure shows models other than hybrid models. Hybrid models have a different rear floor shape.
- All reference points are left-right symmetrical.
- The dimensions are the actual dimensions between the reference points.

(19) Front door hinge upper mounting hole (symmetrical), upper side	(24) Front door striker mounting hole (symmetrical), upper side	(39) Harness holding clip attachment hole (symmetrical)
(20) Front door hinge lower mounting hole (symmetrical), upper side	(26) Rear door striker mounting hole (symmetrical), upper side	(48) Trim mounting hole (symmetrical)
(22) Rear door hinge upper mounting hole (symmetrical), upper side	(27) Rear door switch mounting hole (symmetrical)	(50) Trim clip mounting hole (symmetrical)
(23) Rear door hinge lower mounting hole (symmetrical), front	(33) Harness clip mounting hole (symmetrical)	(53) Rear airbag sensor mounting hole (symmetrical)

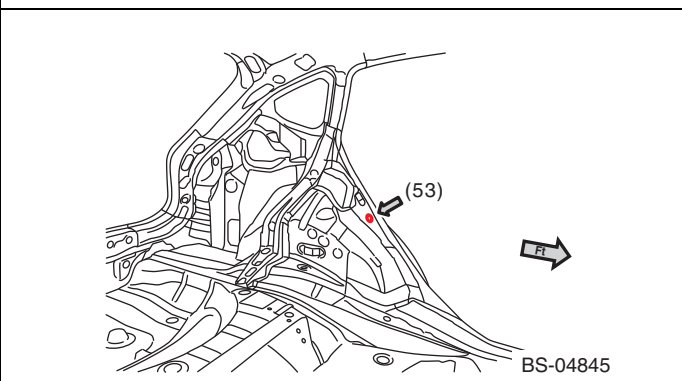
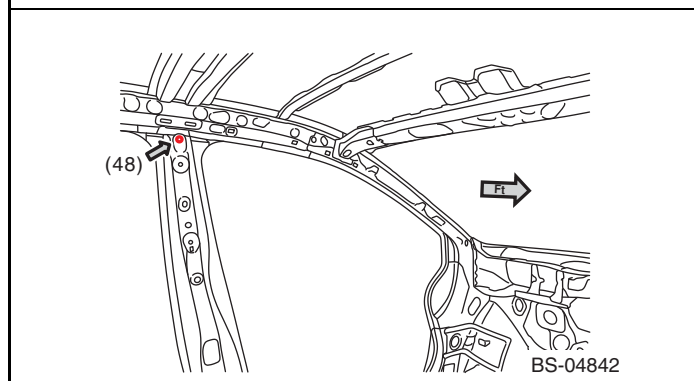
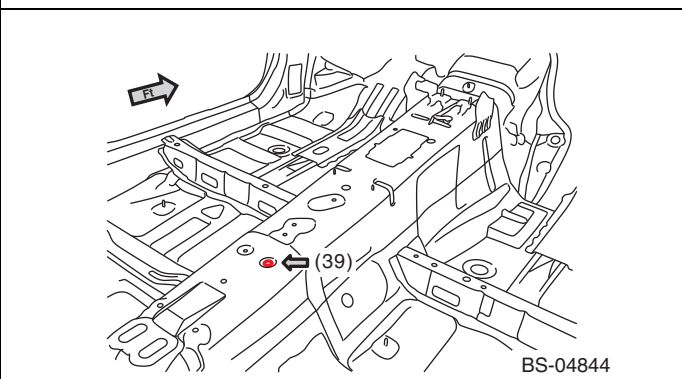
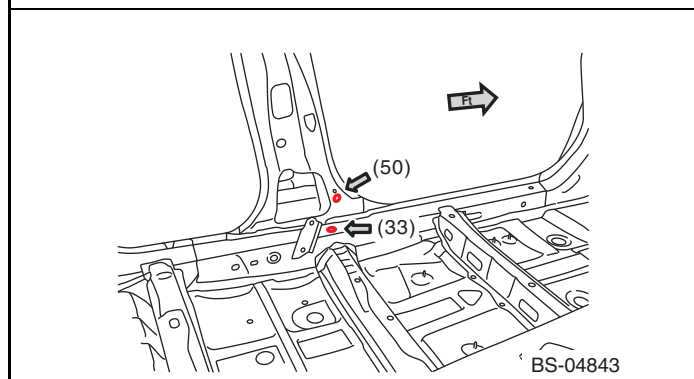
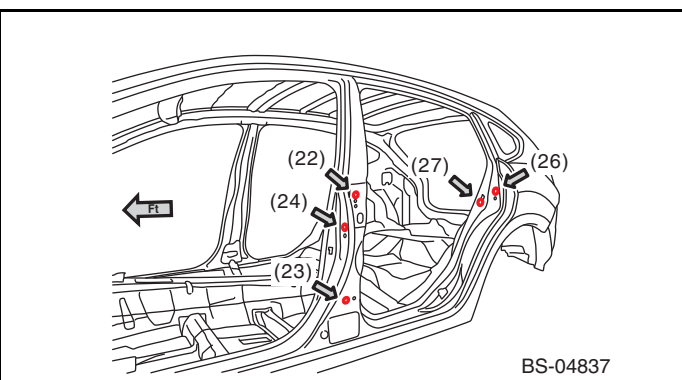
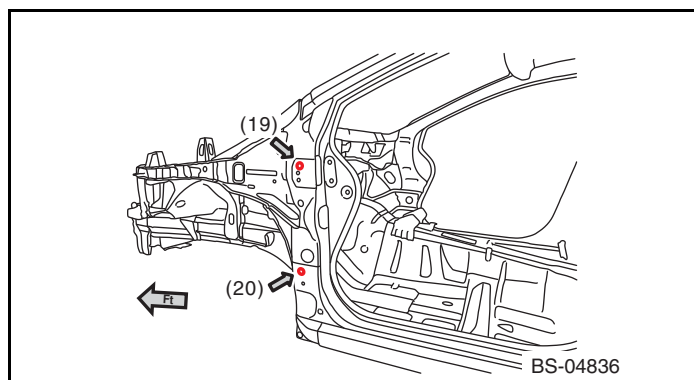
*1: Except for Hybrid model

*2: Hybrid model

Body Reference Points

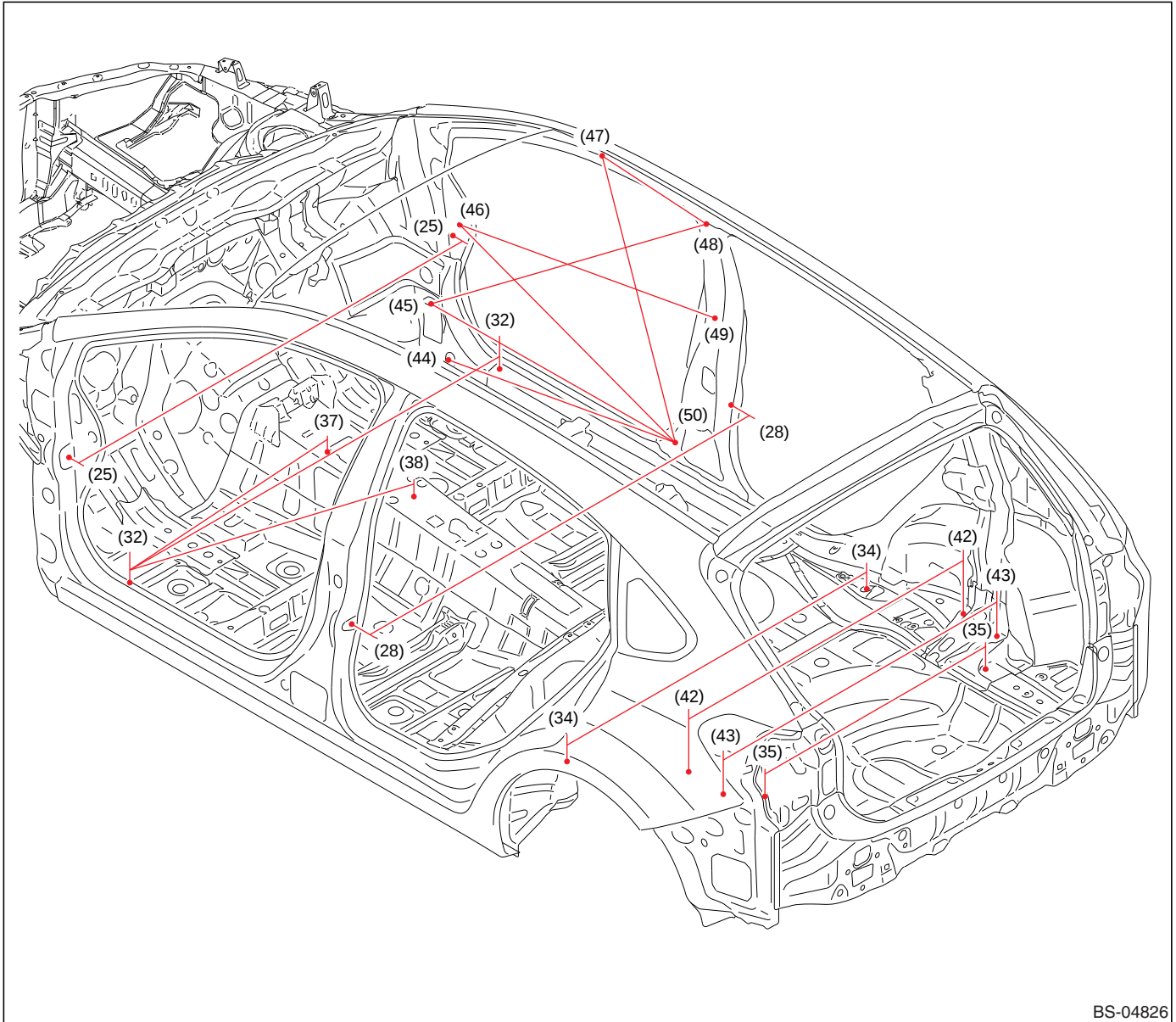
Measuring point	Datum dimension mm (in)
(19) L — (22) L	1,140 (44.88)
(19) L — (23) L	1,131 (44.53)
*1 (20) L — (22) L	1,187 (46.73)
*2 (20) L — (22) L	1,186 (46.69)
*1 (20) L — (23) L	1,053 (41.46)
*2 (20) L — (23) L	1,054 (41.51)
(22) L — (27) L	883 (34.76)

Measuring point	Datum dimension mm (in)
(23) L — (27) L	1,003 (39.49)
(24) R — (24) L	1,529 (60.20)
(26) R — (26) L	1,494 (58.82)
(33) R — (33) L	1,409 (55.47)
(33) R — (39) R	681 (26.81)
(48) R — (53) R	962 (37.87)
(50) R — (53) R	1,080 (42.52)



Body Reference Points

5. INSIDE COMMON PARTS 2 FOR 5 DOOR AND 4 DOOR



BS-04826

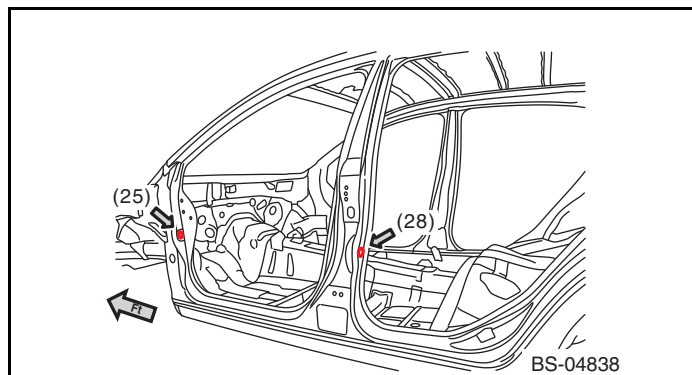
- The figure shows models other than hybrid models. Hybrid models have a different rear floor shape.
- The reference point (38) is at the body center, while the other reference points are left-right symmetrical.
- The dimensions are the actual dimensions between the reference points.

(25) Front door checker mounting hole (symmetrical)	(38) Hand brake mounting hole (body center)	(47) Assist bracket mounting hole (symmetrical)
(28) Rear door checker mounting hole (symmetrical)	(42) Rear suspension mounting hole (symmetrical), front	(48) Trim mounting hole (symmetrical)
(32) Harness clip mounting hole (symmetrical)	(43) Rear suspension mounting hole (symmetrical), rear	(49) Trim clip mounting hole (symmetrical)
(34) Belt anchor mounting hole (symmetrical)	(44) Gauge hole (symmetrical)	(50) Trim clip mounting hole (symmetrical)
(35) Gauge hole (symmetrical)	(45) Side sill cover mounting hole (symmetrical)	
(37) Shift case mounting hole (symmetrical)	(46) Steering beam mounting hole (symmetrical)	

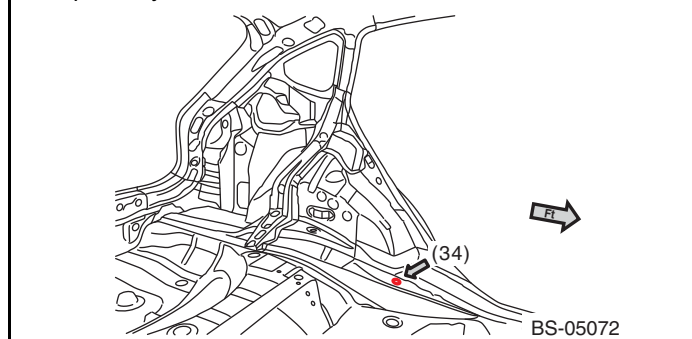
Body Reference Points

Measuring point	Datum dimension mm (in)
(25) R — (25) R	1,486 (58.50)
(28) R — (28) L	1,469 (57.83)
(32) R — (32) L	1,432 (56.38)
(32) L — (37) L	689 (27.13)
(32) L — (38)	821 (32.32)
(34) R — (34) L	1,160 (45.67)
(35) R — (35) L	854 (33.62)
(42) R — (42) L	1,059 (41.69)

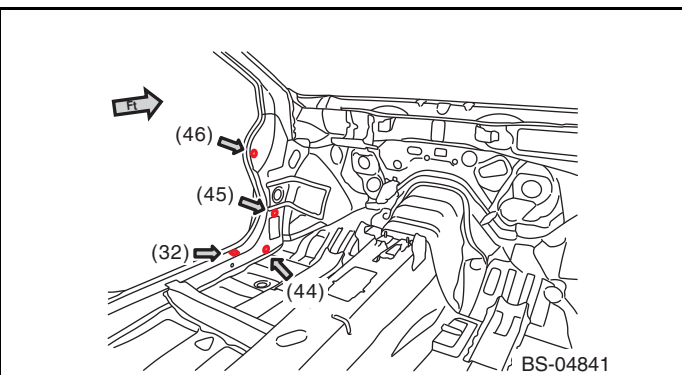
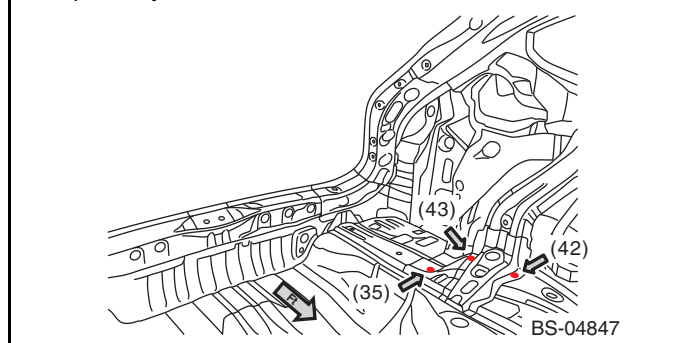
Measuring point	Datum dimension mm (in)
(43) R — (43) L	1,059 (41.69)
(44) R — (50) L	849 (33.43)
(45) R — (48) R	1,485 (58.46)
(45) R — (50) R	915 (36.02)
(46) R — (49) R	1,027 (40.43)
(46) R — (50) R	880 (34.65)
(47) R — (48) R	402 (15.83)
(47) R — (50) R	981 (38.62)



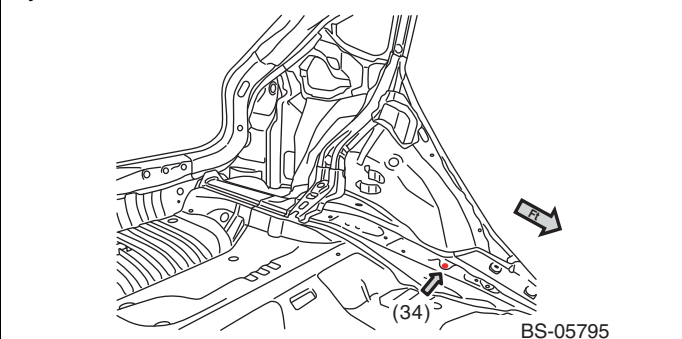
Except for Hybrid model



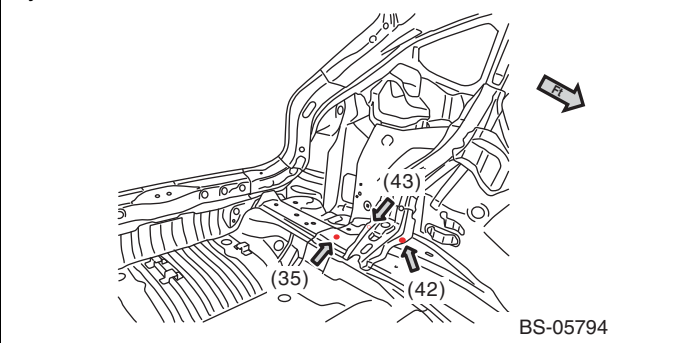
Except for Hybrid model



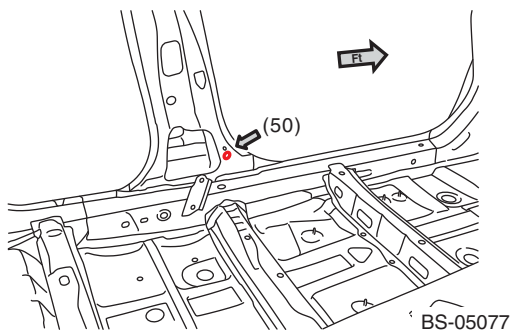
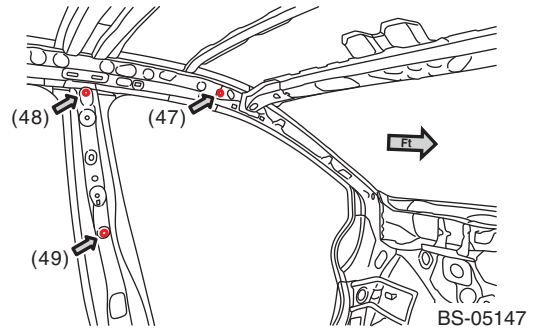
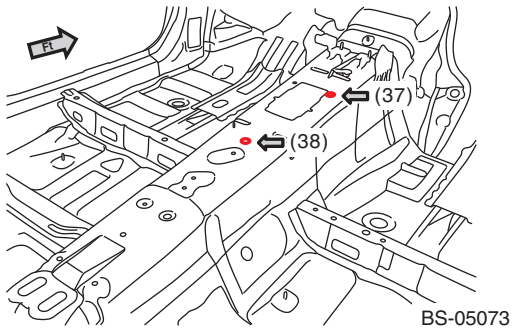
Hybrid model



Hybrid model



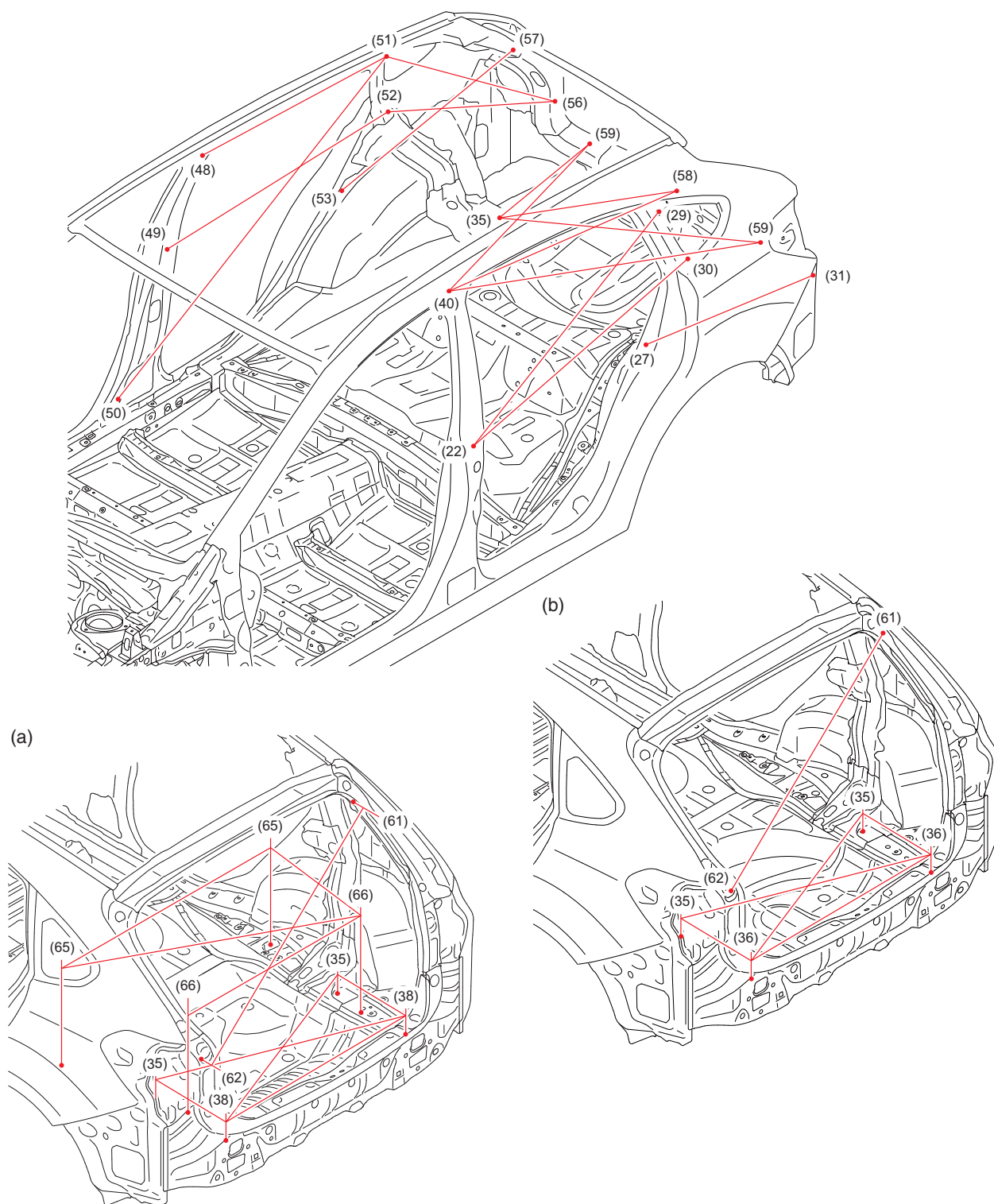
Body Reference Points



SUBARU.

Body Reference Points

6. INSIDE REAR, ONLY FOR 5 DOOR



BS-05796

(a) Hybrid model

(b) Except for Hybrid model

- All reference points are left-right symmetrical.
- The dimensions are the actual dimensions between the reference points.

Body Reference Points

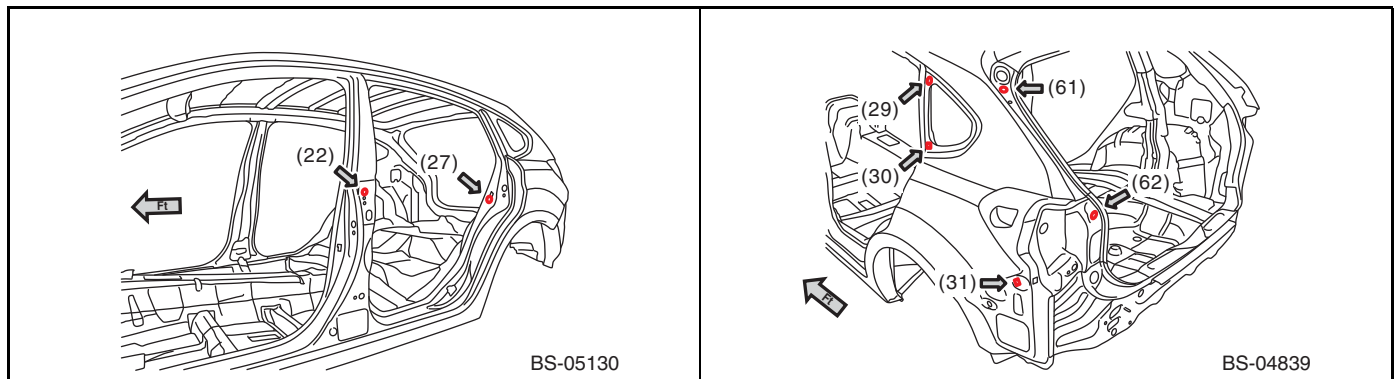
(22) Rear door hinge upper mounting hole (symmetrical), upper side	(40) Stay rear floor mounting hole (symmetrical)	(57) Trim clip mounting hole (symmetrical)
(27) Rear door switch mounting hole (symmetrical)	(48) Trim mounting hole (symmetrical)	(58) Striker mounting hole (symmetrical)
(29) Rear quarter glass mounting hole (symmetrical), front upper	(49) Trim clip mounting hole (symmetrical)	(59) Trim clip mounting hole (symmetrical)
(30) Rear quarter glass mounting hole (symmetrical), front lower	(50) Trim clip mounting hole (symmetrical)	(61) Rear gate stay mounting hole (symmetrical), upper side
(31) Rear bumper mounting hole (symmetrical)	(51) Gauge hole (symmetrical)	(62) Rear combination light mounting hole (symmetrical), upper side
(35) Gauge hole (symmetrical)	(52) Gauge hole (symmetrical)	(65) Battery frame mounting hole (symmetrical)
(36)R Gauge hole (right side)	(53) Rear airbag sensor mounting hole (symmetrical)	(66) Battery frame mounting hole (symmetrical)
(36)L Gauge hole (left side)	(56) Trim mounting hole (symmetrical)	

*1: Except for Hybrid model

*2: Hybrid model

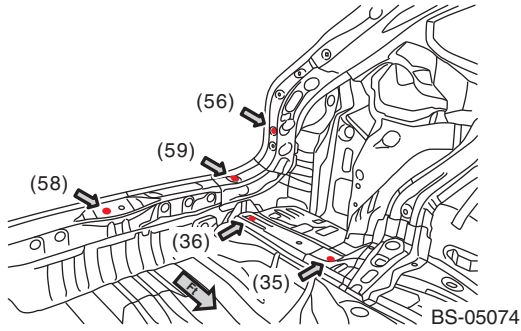
Measuring point	Datum dimension mm (in)
(22) L — (29) L	1,081 (42.56)
(22) L — (30) L	1,087 (42.80)
(27) L — (31) L	708 (27.87)
(35) R — (58) R	596 (23.46)
(35) R — (59) L	926 (36.46)
(35) R — (59) R	414 (16.30)
(35) R — (36) L	916 (36.06)
(35) L — (36) R	912 (35.91)
(35) R — (36) R	320 (12.60)
(35) L — (36) L	330 (12.99)
(36) R — (36) L	854 (33.62)
*1 (40) R — (58) R	878 (34.57)
*2 (40) R — (58) R	891 (35.08)
*1 (40) R — (59) R	836 (32.91)
*2 (40) R — (59) R	861 (33.91)

Measuring point	Datum dimension mm (in)
*1 (40) R — (59) L	1,047 (41.22)
*2 (40) R — (59) L	1,046 (41.18)
(48) R — (51) R	834 (32.83)
(49) R — (52) R	1,016 (40.00)
(50) R — (51) R	1,445 (56.89)
(51) R — (57) R	647 (25.47)
(52) R — (57) R	493 (19.41)
(53) R — (56) R	828 (32.60)
(61) R — (62) L	1,185 (46.65)
(65) R — (65) L	982 (38.66)
(65) R — (66) R	519 (20.43)
(65) L — (66) R	1,032 (40.63)
(66) R — (66) L	810 (31.89)



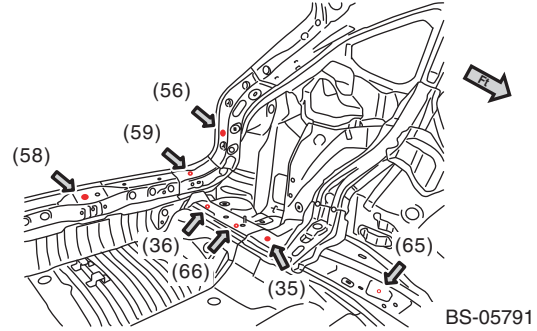
Body Reference Points

Except for Hybrid model



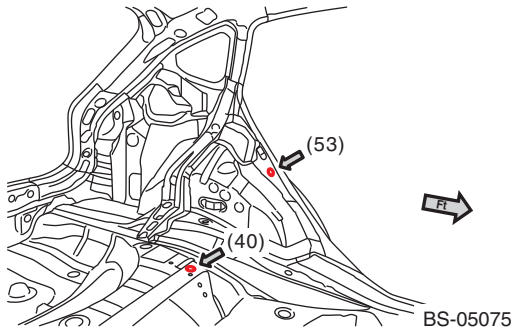
BS-05074

Hybrid model



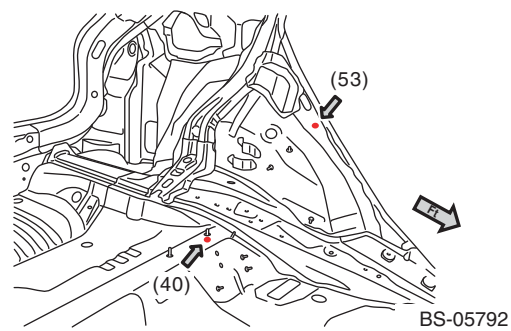
BS-05791

Except for Hybrid model

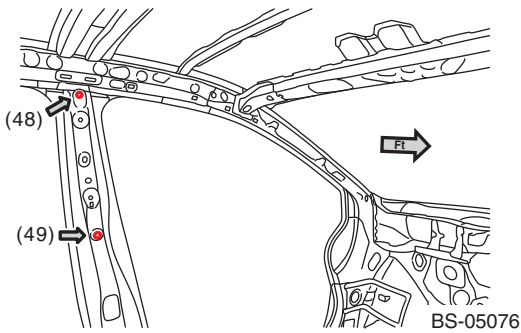


BS-05075

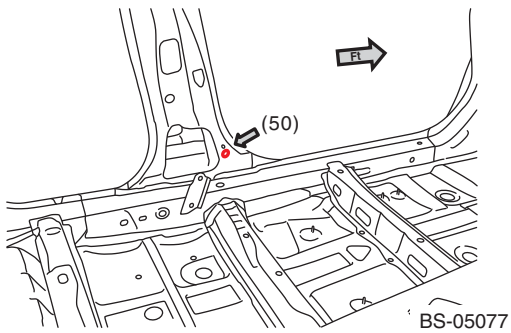
Hybrid model



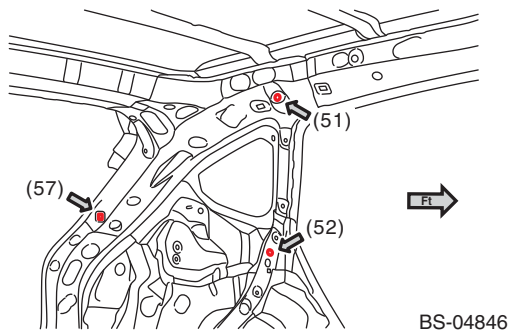
BS-05792



BS-05076



BS-05077

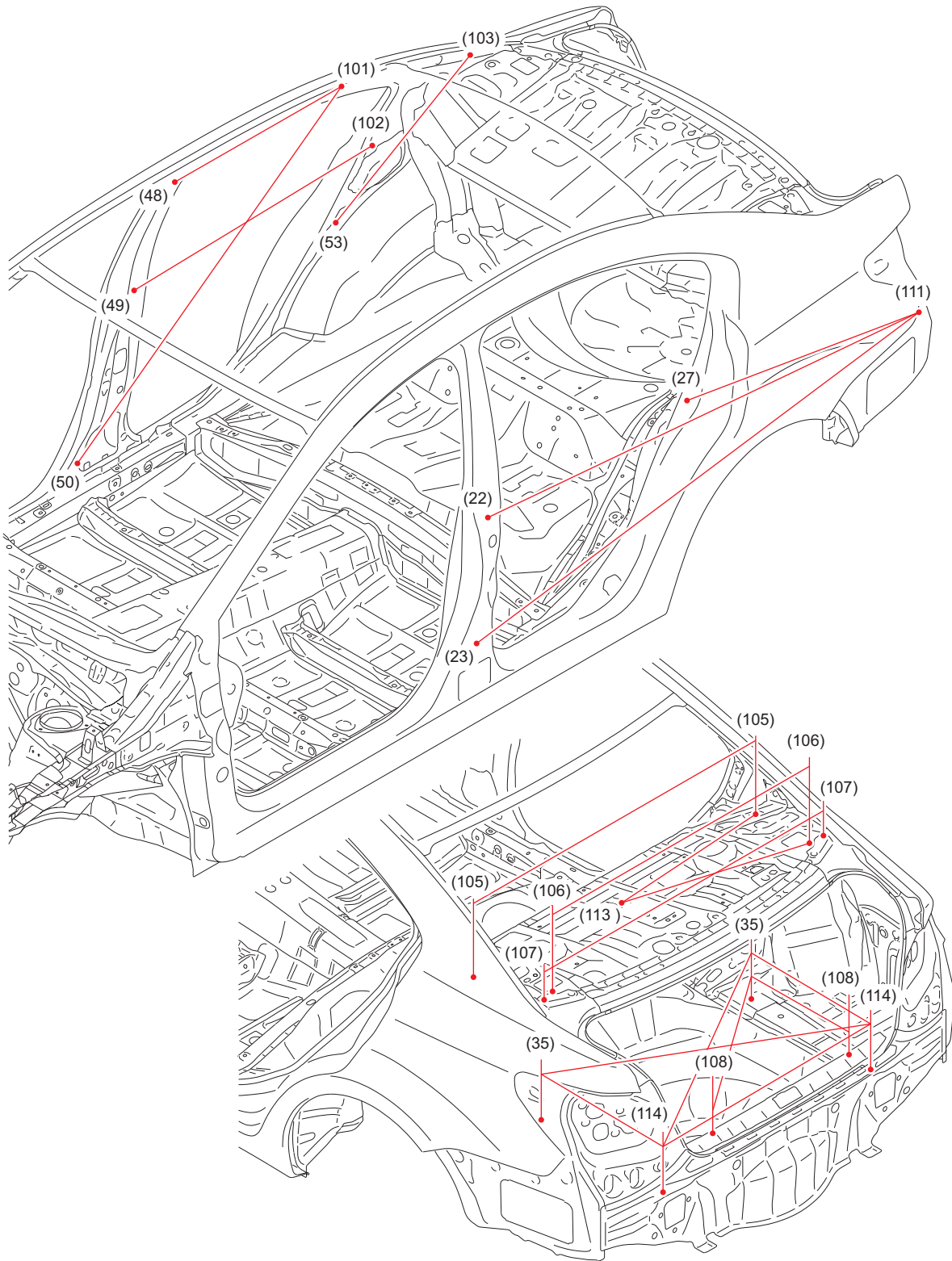


BS-04846

SUBARU.

Body Reference Points

7. INSIDE REAR, ONLY FOR 4 DOOR



BS-04828

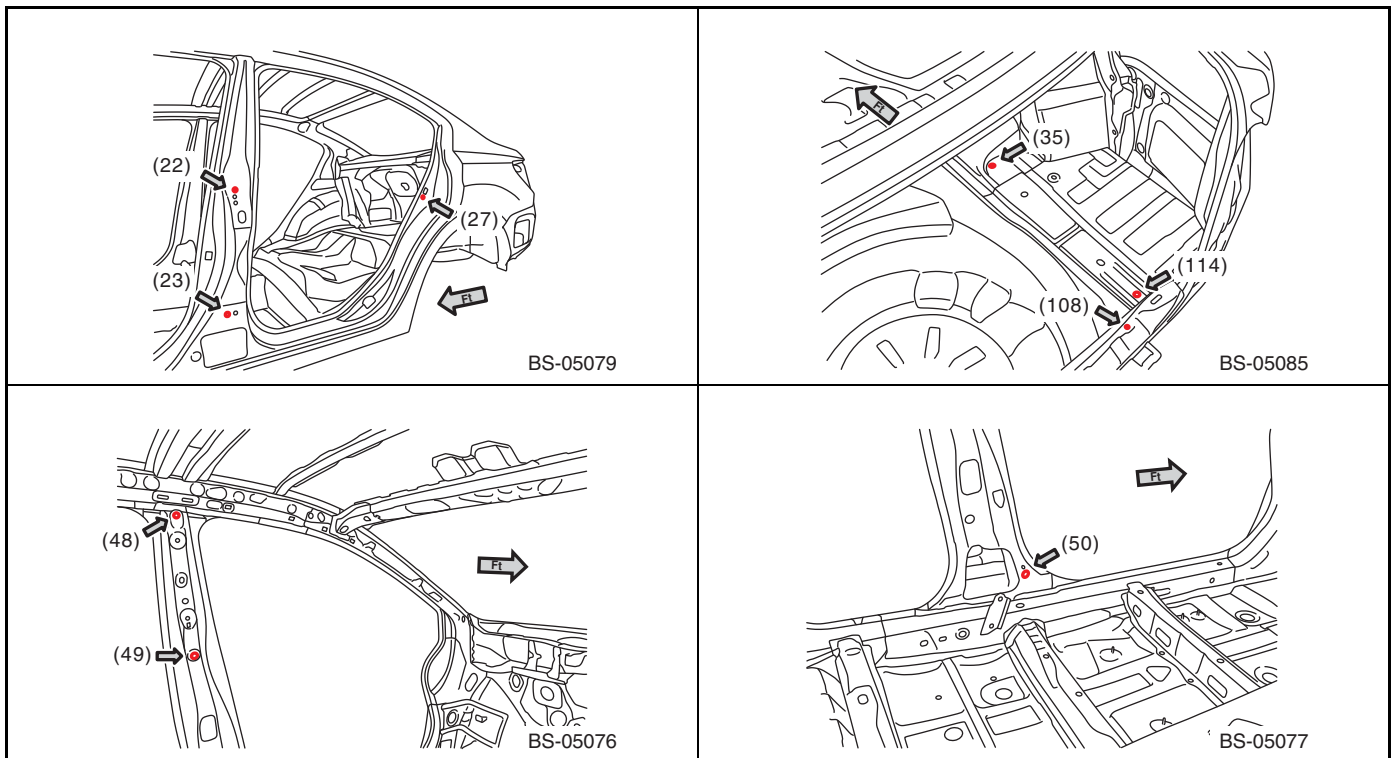
- The reference point (113) is at the body center, while the other reference points are left-right symmetrical.
- The dimensions are the actual dimensions between the reference points.

Body Reference Points

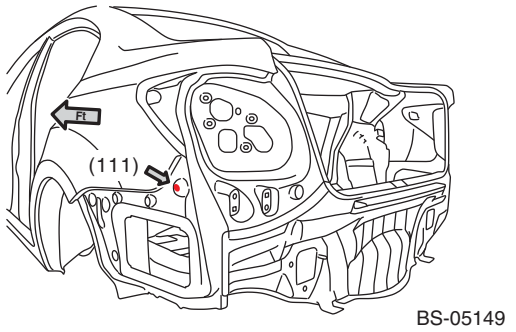
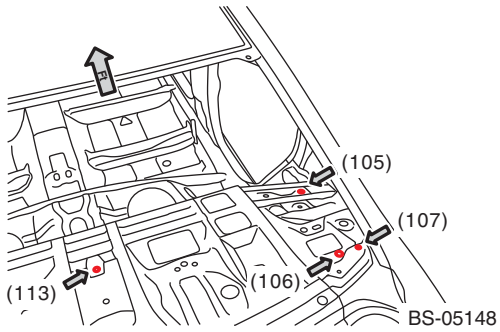
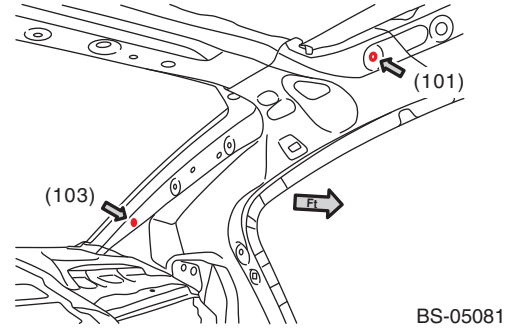
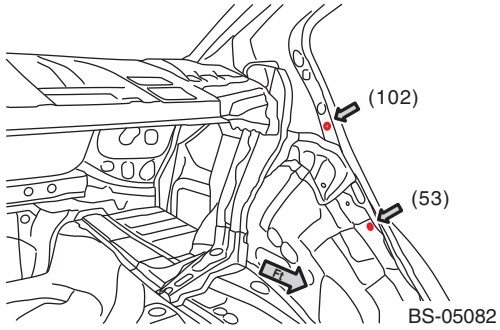
- | | | |
|--|---|--|
| (22) Rear door hinge upper mounting hole (symmetrical), upper side
(23) Rear door hinge lower mounting hole (symmetrical), front
(27) Rear door switch mounting hole (symmetrical)
(35) Gauge hole (symmetrical)
(48) Trim mounting hole (symmetrical)
(49) Trim clip mounting hole (symmetrical)
(50) Trim clip mounting hole (symmetrical) | (53) Rear airbag sensor mounting hole (symmetrical)
(101) Drain hose mounting hole (symmetrical)
(102) Gauge hole (symmetrical)
(103) Trim mounting hole (symmetrical)
(105) Rear shelf mounting hole (symmetrical)
(106) Rear shelf mounting hole (symmetrical)
(107) Gauge hole (symmetrical) | (108) Electrodeposition hole (symmetrical)
(111) Rear bumper mounting hole (symmetrical)
(113) Rear shelf mounting hole (symmetrical)
(114)R Gauge hole (right side)
(114)L Gauge hole (left side) |
|--|---|--|

Measuring point	Datum dimension mm (in)
(22) L — (111) L	1,763 (69.41)
(23) L — (111) L	1,836 (72.28)
(27) L — (111) L	886 (34.88)
(48) R — (101) R	642 (25.28)
(49) R — (102) R	964 (37.95)
(50) R — (101) R	1,331 (52.40)
(53) R — (103) R	618 (24.33)
(35) R — (108) R	610 (24.01)
(35) R — (108) L	920 (36.22)
(35) R — (114) R	485 (19.09)
(35) R — (114) L	987 (38.86)

Measuring point	Datum dimension mm (in)
(35) L — (114) R	982 (38.66)
(35) L — (114) L	495 (19.49)
(105) R — (105) L	1,147 (45.16)
(105) R — (113)	574 (22.60)
(106) R — (106) L	972 (38.27)
(106) R — (113)	546 (21.50)
(107) R — (107) L	1,146 (45.12)
(114) R — (114) L	854 (33.62)



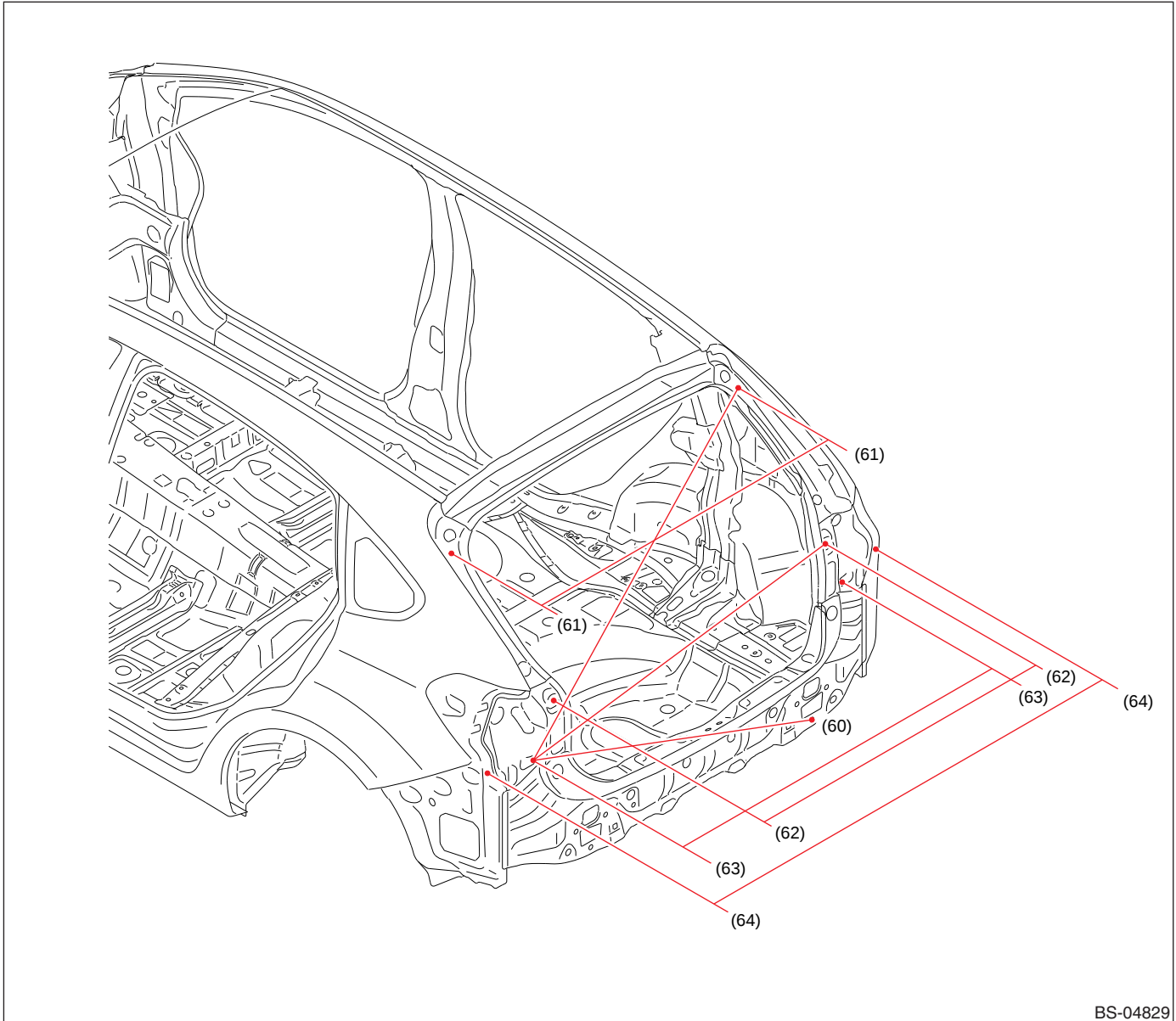
Body Reference Points



Body Reference Points

8. REAR 1

• 5 Door



- The figure shows models other than hybrid models. Hybrid models have a different rear floor shape.
- All reference points are left-right symmetrical.
- The dimensions are the actual dimensions between the reference points.

- (60) Bumper beam mounting hole (symmetrical)
- (61) Rear gate stay mounting hole (symmetrical), upper side

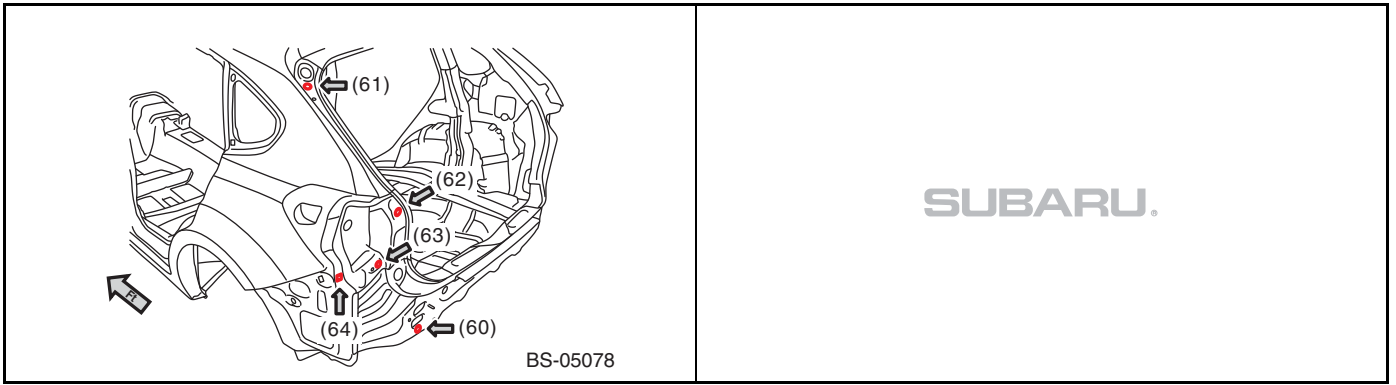
- (62) Rear combination light mounting hole (symmetrical), upper side
- (63) Rear bumper bracket mounting hole (symmetrical)

- (64) Rear bumper mounting hole (symmetrical)

Measuring point	Datum dimension mm (in)
(60) R — (63) L	1,083 (42.64)
(61) R — (61) L	1,109 (43.66)
(61) R — (63) L	1,303 (51.30)
(62) R — (62) L	1,050 (41.34)

Measuring point	Datum dimension mm (in)
(62) R — (63) L	1,135 (44.68)
(63) R — (63) L	1,194 (47.01)
(64) R — (64) L	1,501 (59.09)

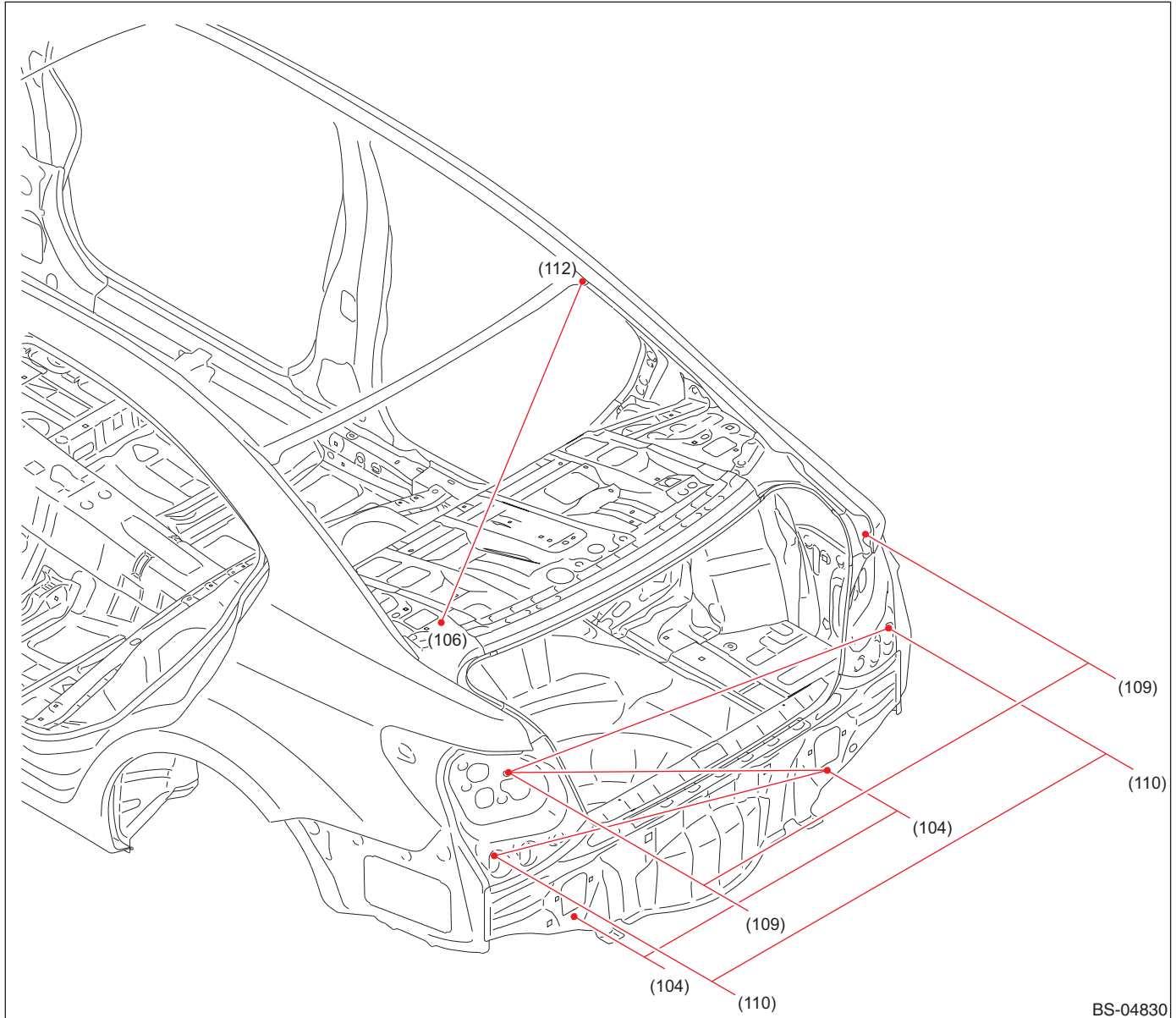
Body Reference Points



Body Reference Points

9. REAR2

• 4 Door



BS-04830

- All reference points are left-right symmetrical.
- The dimensions are the actual dimensions between the reference points.

(104) Harness pass-through hole
(symmetrical)

(106) Rear shelf mounting hole
(symmetrical)

(109) Rear combination light mounting
hole (symmetrical)

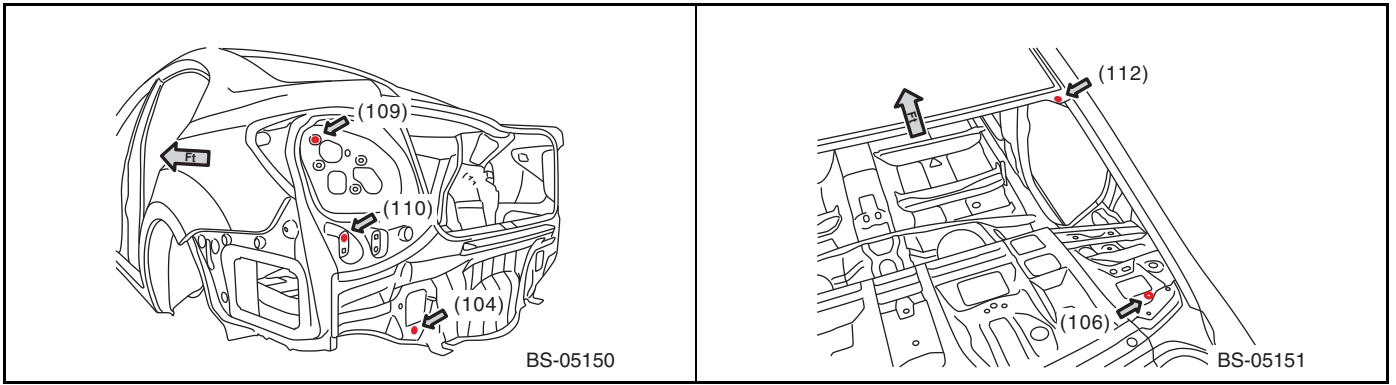
(110) Rear bumper mounting hole
(symmetrical)

(112) Rear glass installation reference
hole (symmetrical)

Measuring point	Datum dimension mm (in)
(104) R — (104) L	854 (33.62)
(104) R — (109) L	1,225 (48.23)
(104) R — (110) L	1,128 (44.41)
(106) L — (112) R	1,155 (45.47)

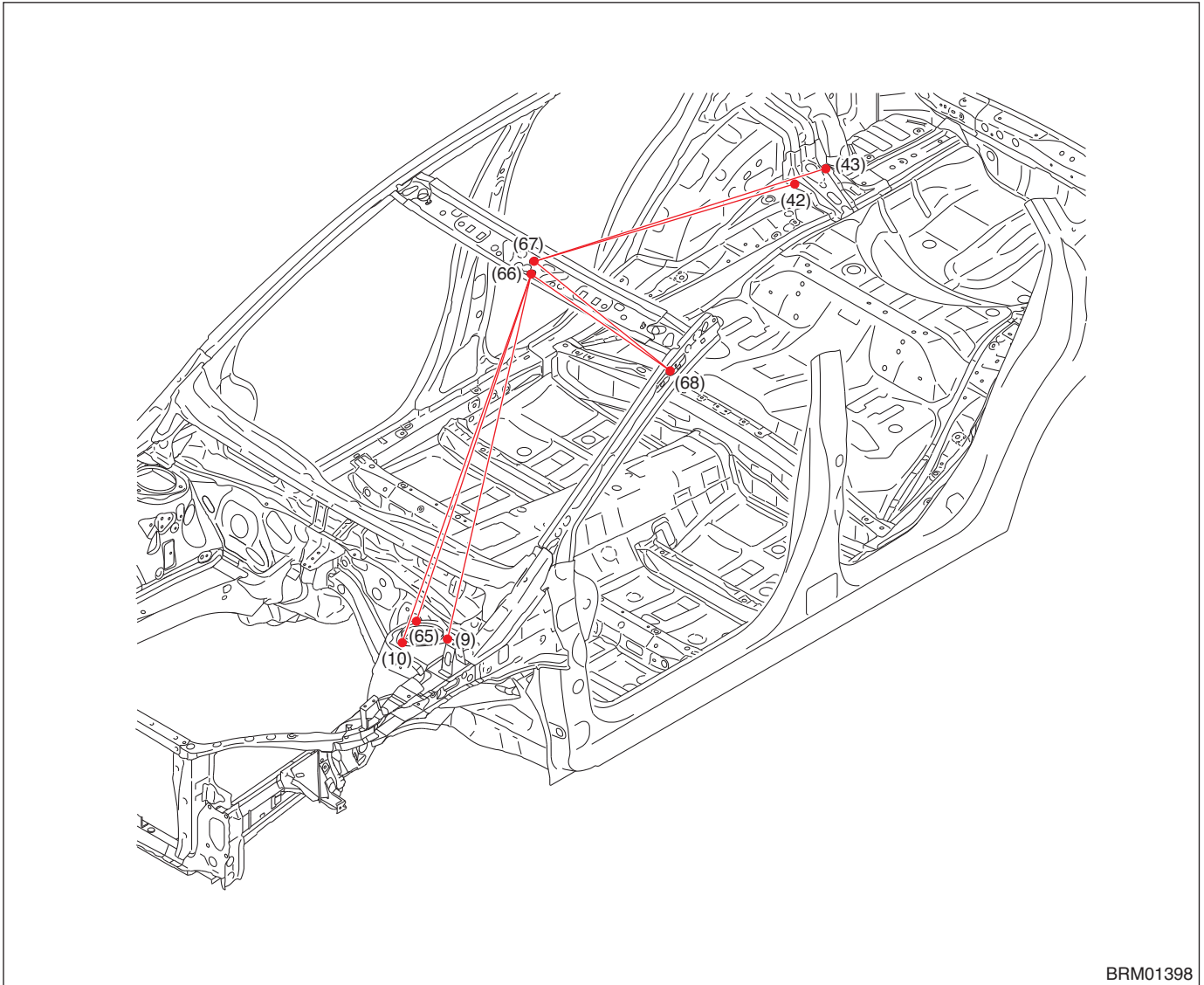
Measuring point	Datum dimension mm (in)
(109) R — (109) L	1,362 (53.62)
(109) L — (110) R	1,368 (53.85)
(110) R — (110) L	1,330 (52.36)

Body Reference Points



Body Reference Points

10.FRONT ROOF RAIL (CAMERA PLATE)



BRM01398

- Reference point (67) indicates a body center part. All other reference points indicate left-right symmetrical parts.
- The dimensions are the actual dimensions between the reference points.

(9) Front suspension mounting hole (symmetrical), rear outside

(43) Rear suspension mounting hole (symmetrical), rear

(67) Stereo camera (camera plate) mounting hole (body center), rear side

(10) Front suspension mounting hole (symmetrical), front

(65) Front suspension mounting hole (symmetrical), rear inside

(68) Curtain air bag mounting hole (symmetrical)

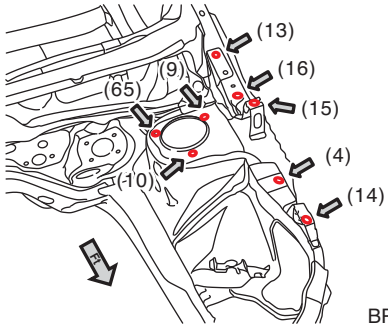
(42) Rear suspension mounting hole (symmetrical), front

(66) Stereo camera (camera plate) mounting hole (symmetrical), front side

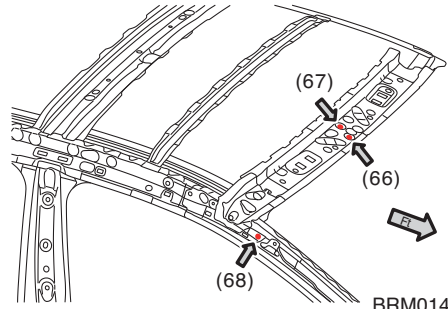
Measuring point	Datum dimension mm (in)
(9)L — (66)L	1,259 (49.57)
(10)L — (66)L	1,310 (51.57)
(42)R — (67)	1,884 (74.17)
(43)R — (67)	2,001 (78.78)

Measuring point	Datum dimension mm (in)
(65)L — (66)L	1,200 (47.24)
(66)L — (68)L	584 (22.99)
(67) — (68)L	613 (24.13)

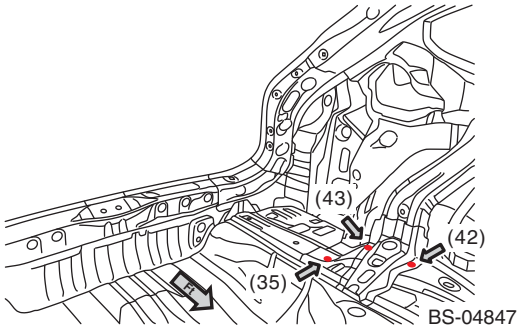
Body Reference Points



BRM01399



BRM01400



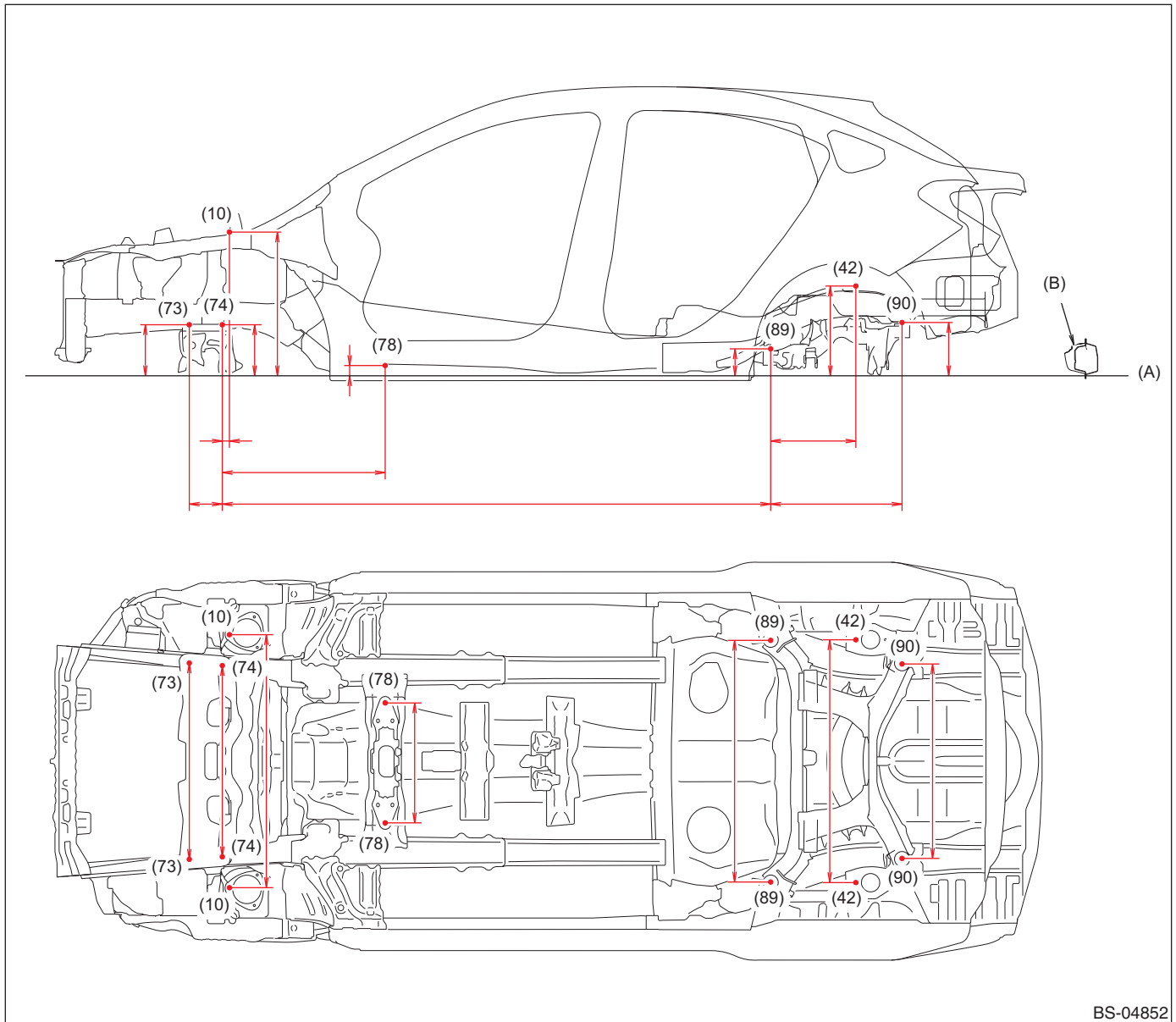
BS-04847

SUBARU.

6. Measurement for combined parts

A: DIMENSIONS

1. SUSPENSION MOUNT & ENGINE MOUNT



BS-04852

- The figure shows models other than hybrid models. Hybrid models have a different rear floor shape
- The longitudinal dimensions are projected dimensions.
- The height dimensions are the vertical distances from the gauge point on the assumed horizontal line through the side sill flange joint (bending angle point).

(A) Standard line

(B) Side sill outer panel

Measurement for combined parts

(10) Front suspension mounting hole (symmetrical), front	(74) Front crossmember mounting hole (symmetrical), rear	(78) *2 CVT crossmember mounting hole (symmetrical)
(42) Rear suspension mounting hole (symmetrical), front	(78)R *1 CVT crossmember mounting hole, right side	(89) Rear suspension crossmember mounting hole (symmetrical)
(73) Front crossmember mounting hole (symmetrical), front	(78)L *1 CVT crossmember mounting hole, left side	(90) Rear suspension crossmember mounting hole (symmetrical)

*1: Except for Hybrid model

*2: Hybrid model

Measuring point	Datum dimension mm (in)
Datum line — (10)	627 (24.68)
Datum line — (42)	391 (15.39)
Datum line — (73)	223 (8.78)
Datum line — (74)	223 (8.78)
*1 Datum line — (78)R	45 (1.77)
*2 Datum line — (78)	36 (1.42)
Datum line — (89)	118 (4.65)
Datum line — (90)	233 (9.17)
(10) — (74)	273 (10.75)
(42) — (89)	371 (14.61)
(73) — (74)	144 (5.67)
*1 (74) — (78)	711 (27.99)

Measuring point	Datum dimension mm (in)
*2 (74) — (78)	811 (31.93)
(74) — (89)	2,392 (94.17)
(89) — (90)	573 (22.56)
(10) R — (10) L	1,104 (43.46)
(42) R — (42) L	1,059 (41.69)
(73) R — (73) L	862 (33.94)
(74) R — (74) L	840 (33.07)
*1 (78) R — (78) L	529 (23.39)
*2 (78) R — (78) L	504 (19.84)
(89) R — (89) L	1,060 (41.73)
(90) R — (90) L	854 (33.62)

CAUTION:

For the reference points (10), refer to the figure "FRONT 1, DIMENSIONS, Body Reference Points" on page 53.

For the reference points (42), refer to the figure "INSIDE COMMON PARTS 2 FOR 5 DOOR AND 4 DOOR, DIMENSIONS, Body Reference Points" on page 59.

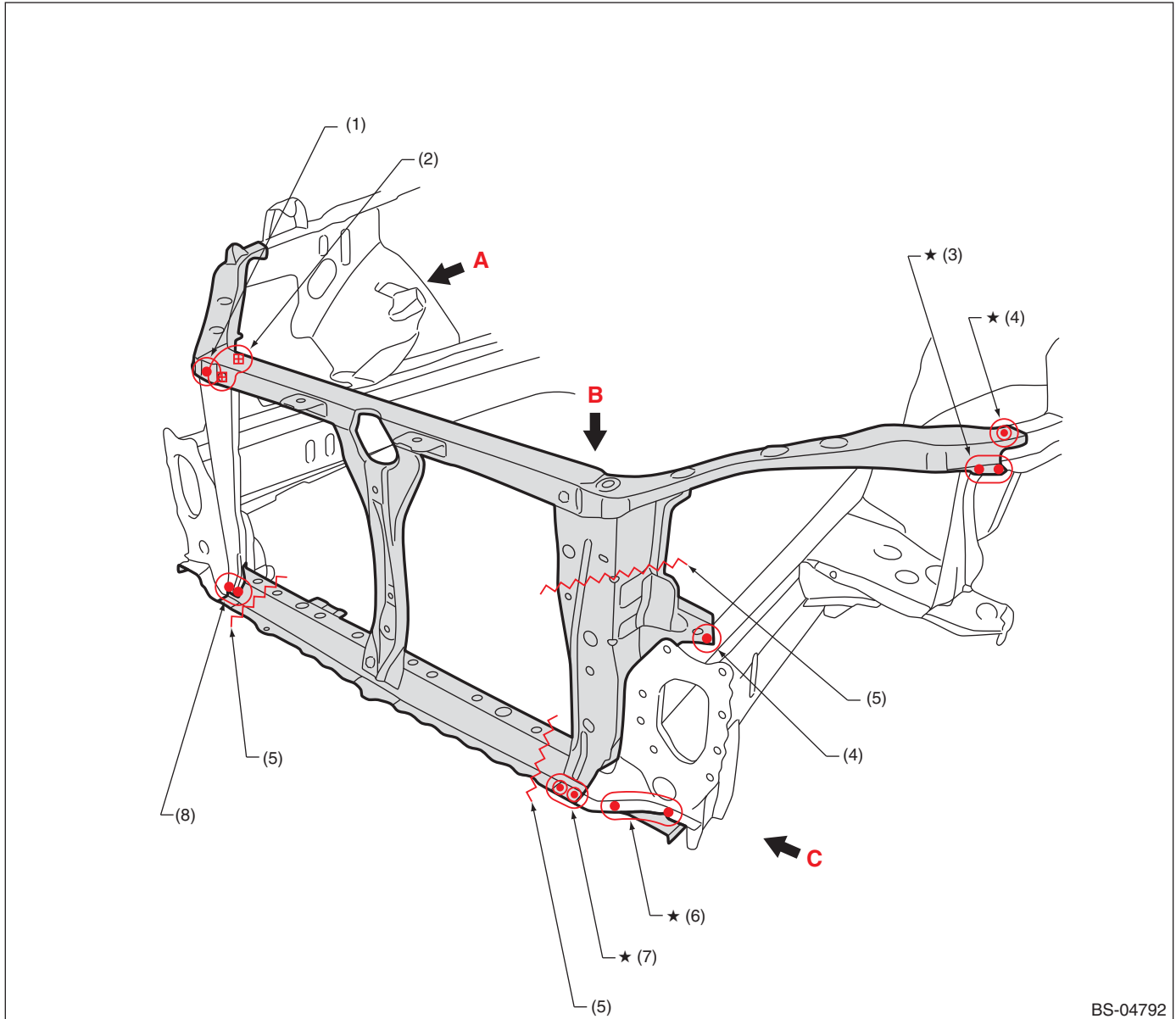
Except the reference points (10) and (42), refer to the figure "LOWER SURFACE, DIMENSIONS, Body Reference Points" on page 49.

7. Panel Replacement

7-1. Radiator Panel (total replacement)

A: REMOVAL

• Overall view

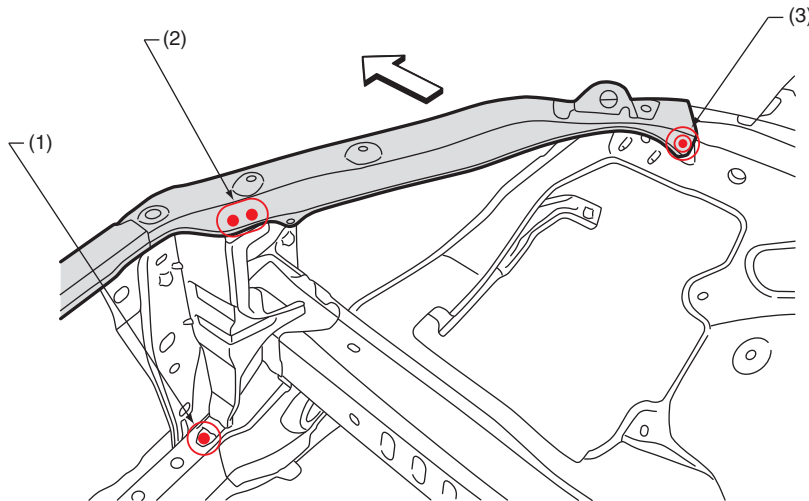


BS-04792

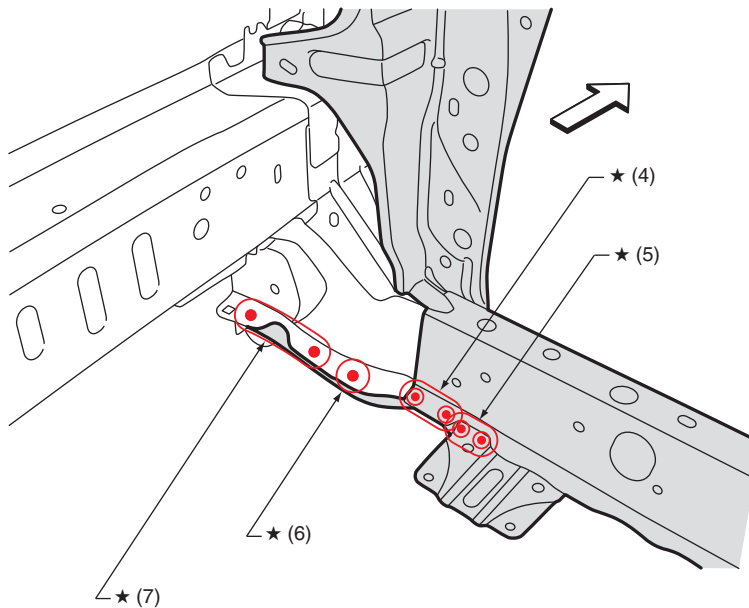
For locations marked by “★”: The welding method and the number of welding points are the same on the left and the right.

Panel Replacement

• Views 1



A



B

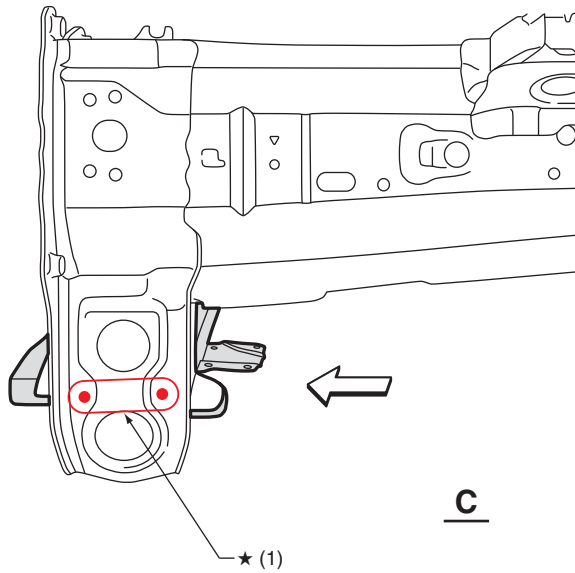
BS-04793

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

For locations marked by “★”: The welding method and the number of welding points are the same on the left and the right.

Panel Replacement

• Views 2



BS-04794

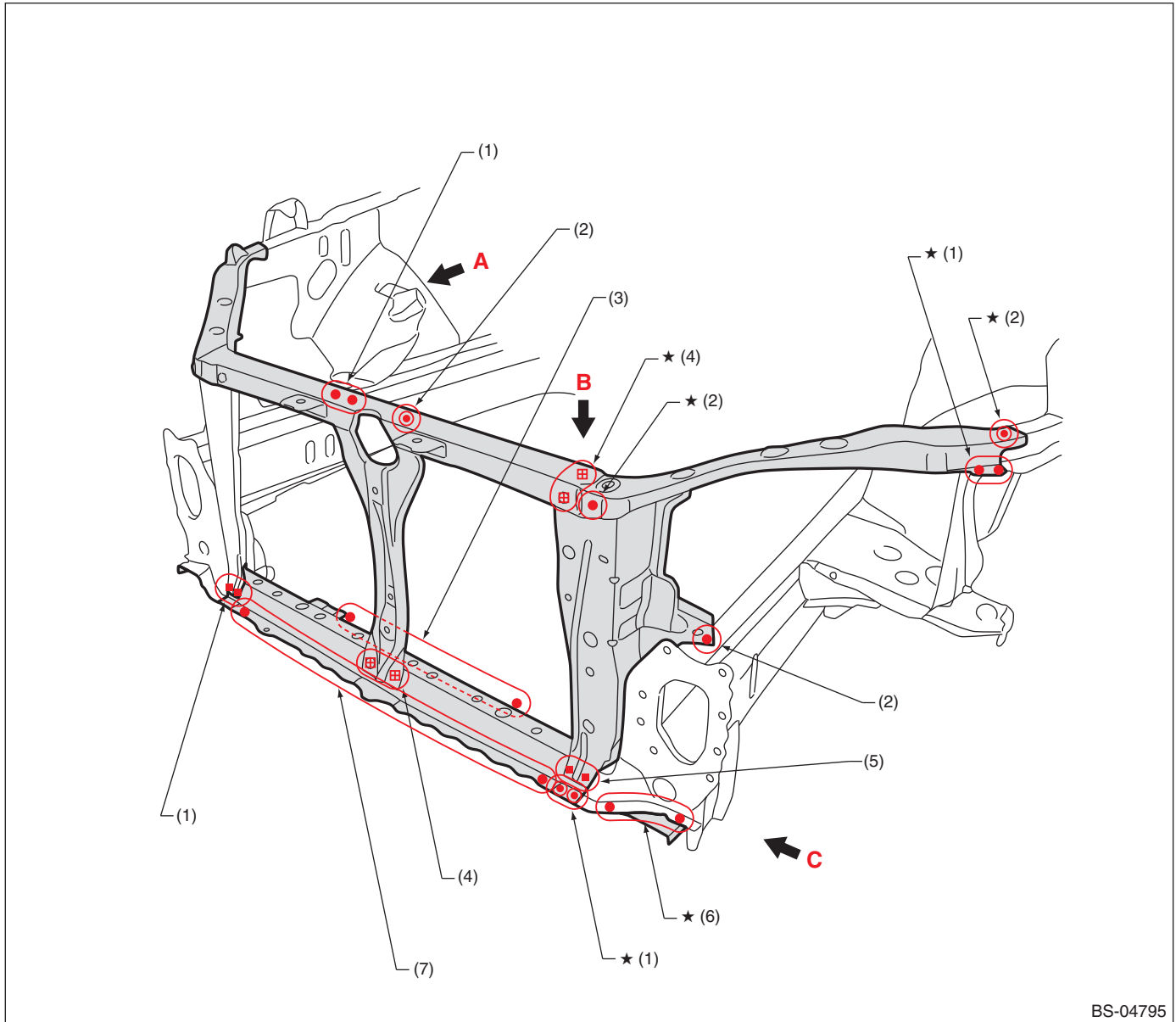
(1) 2 points (inside · 1, belt sander)

- For locations marked by “★”: The welding method and the number of welding points are the same on the left and the right.
- Some parts of the front side frame may have a different shape depending on the vehicle type and model year, but the number and location of welding points are the same in all models.

Panel Replacement

B: INSTALLATION

• Overall view



BS-04795

- (1) 2 points
- (2) 1 point
- (3) 9 points

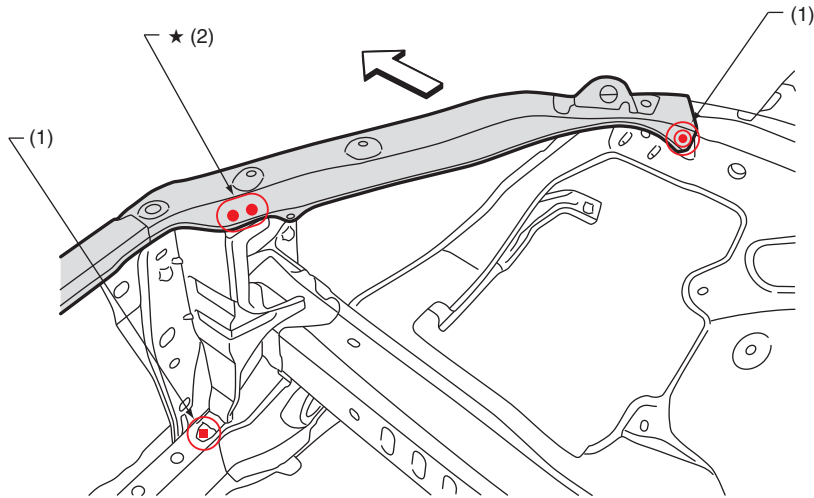
- (4) 2 points (bolt)
- (5) 2 points (service)
- (6) 4 points

- (7) 16 points

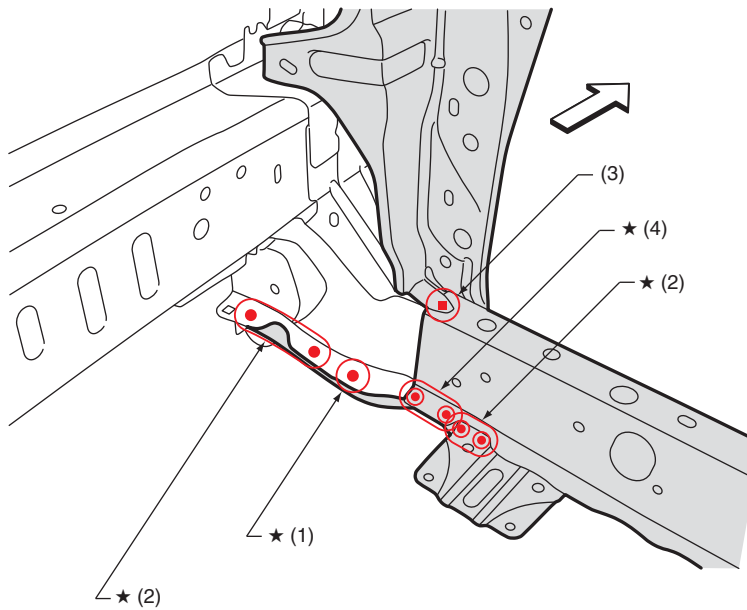
For locations marked by “★”: The welding method and the number of welding points are the same on the left and the right.

Panel Replacement

• Views 1



A



B

BS-04796

(1) 1 point
(2) 2 points

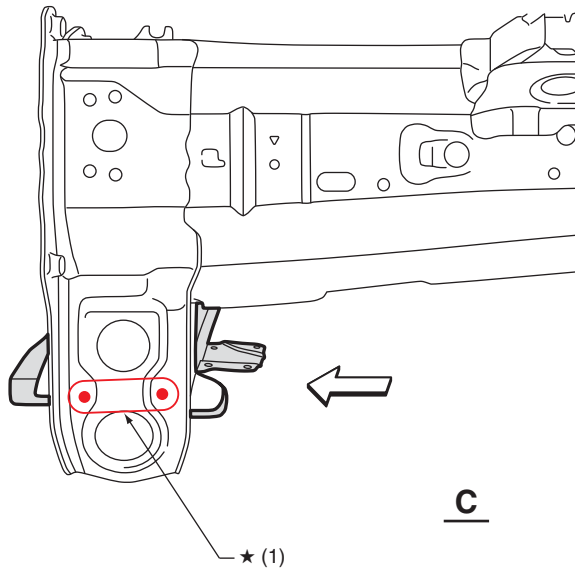
(3) 1 point (service)

(4) 3 points

For locations marked by “★”: The welding method and the number of welding points are the same on the left and the right.

Panel Replacement

• Views 2



BS-04797

(1) 2 points

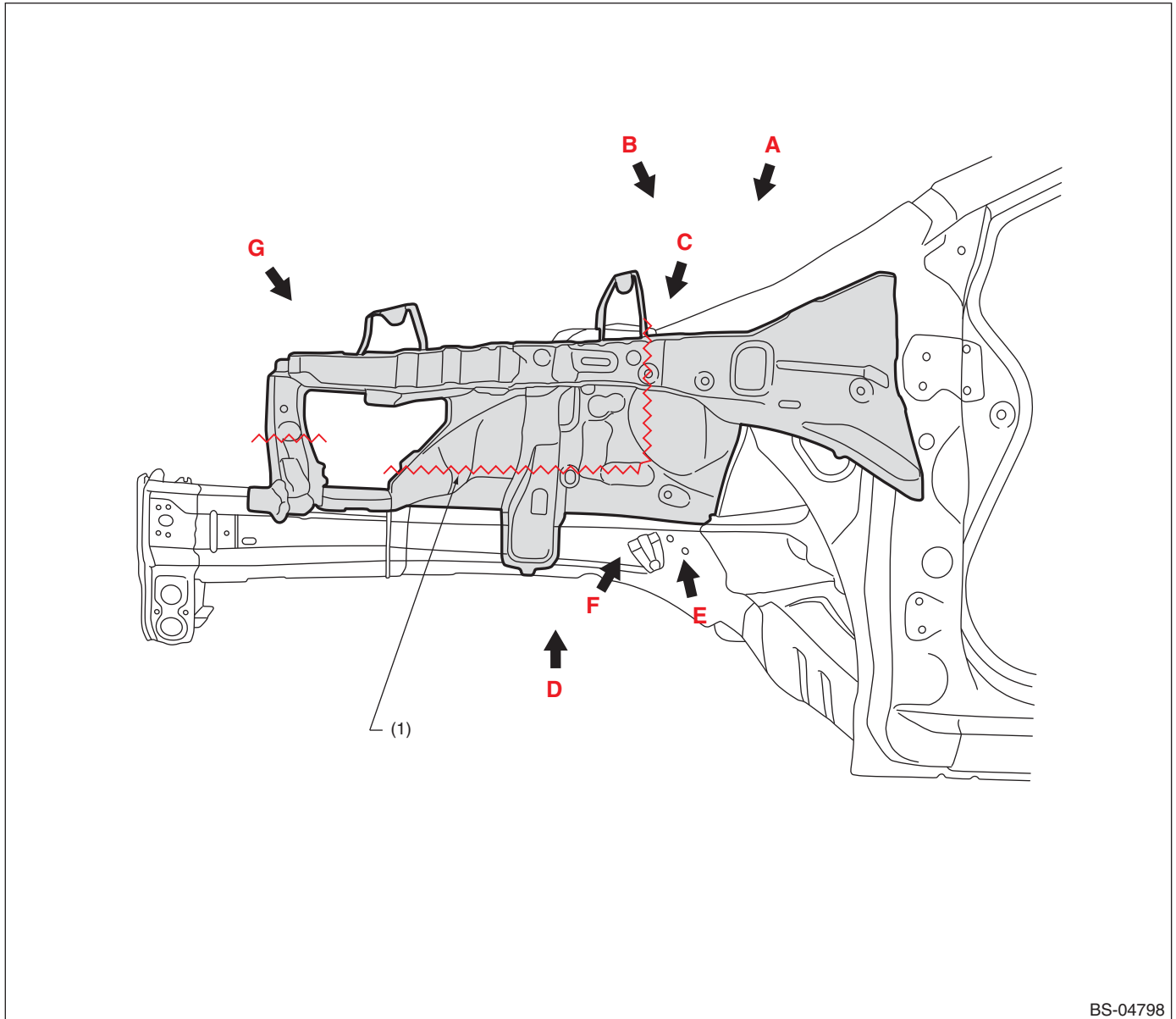
- For locations marked by “★”: The welding method and the number of welding points are the same on the left and the right.
- Some parts of the front side frame may have a different shape depending on the vehicle type and model year, but the number and location of welding points are the same in all models.

Panel Replacement

7-2. Front Wheel Apron (total replacement)

A: REMOVAL

• Overall view

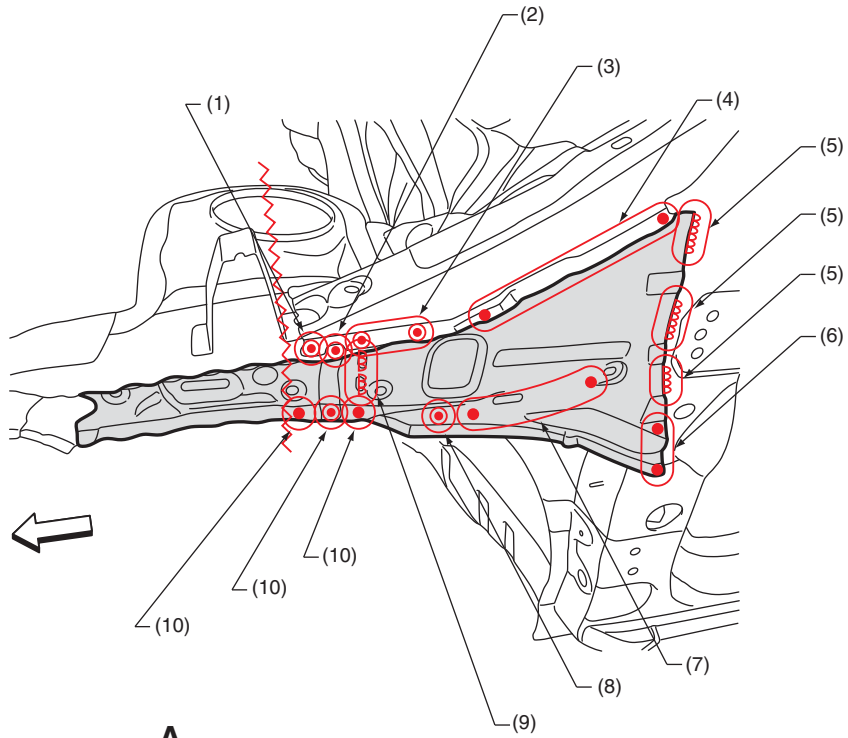


BS-04798

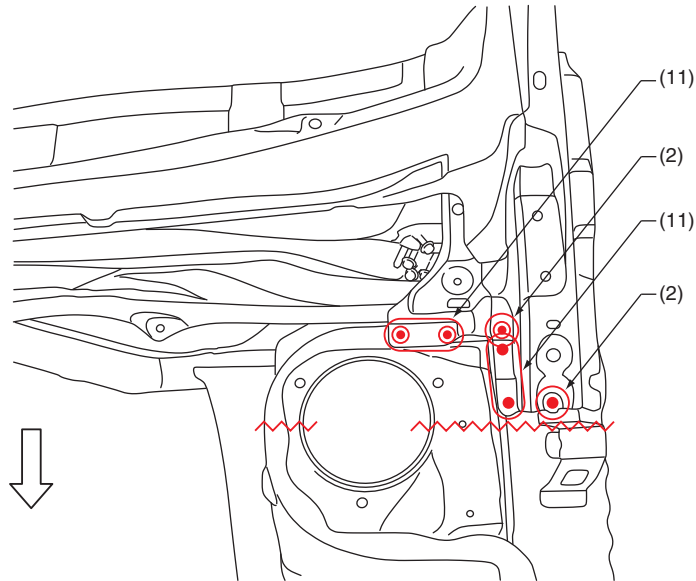
(1) Rough cutting

Panel Replacement

• Views 1



A



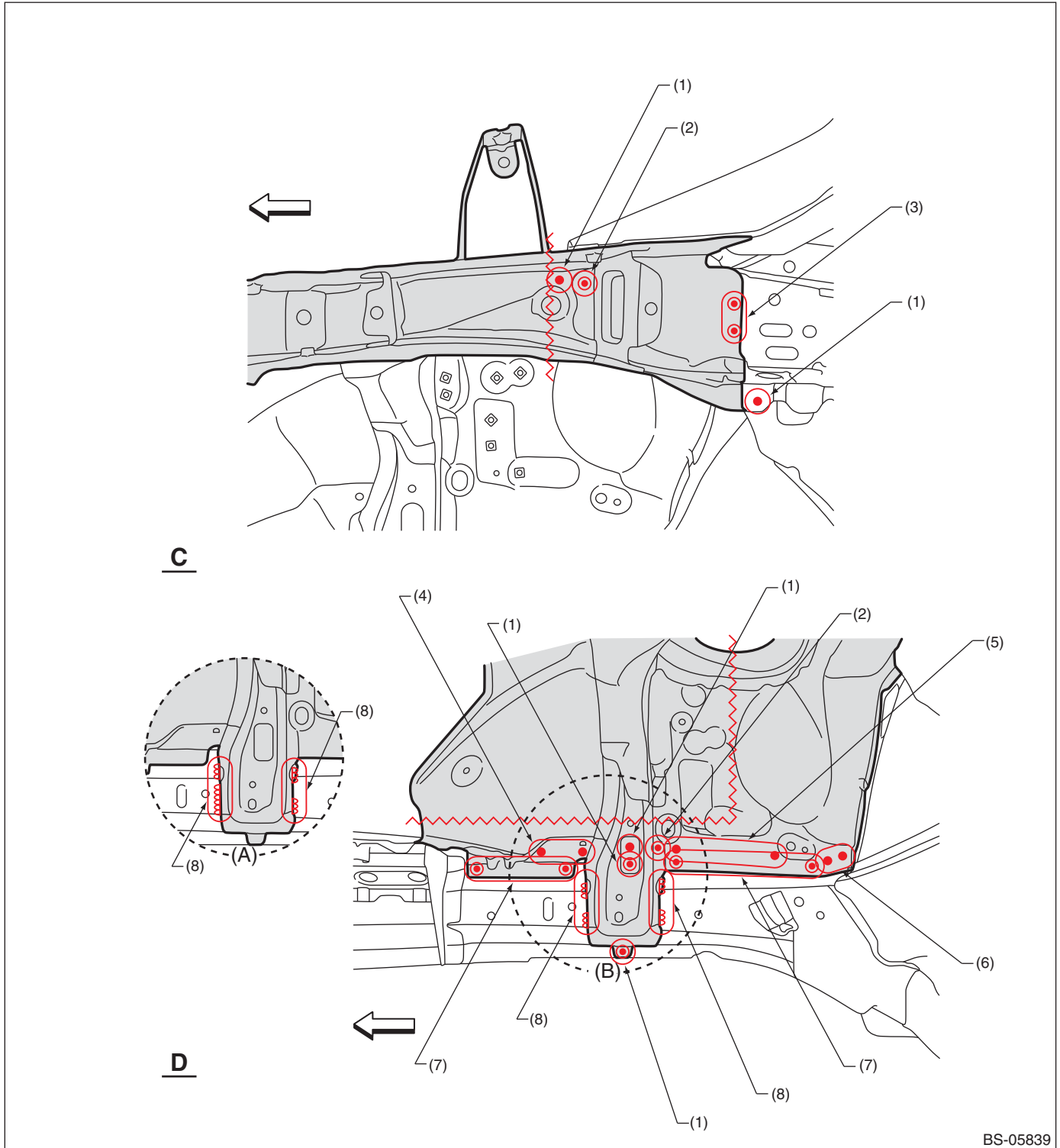
B

BS-04799

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

Panel Replacement

• Views 2



(A) LH of the 14MY

(B) Both sides of the model up to 13MY, and RH of the 14MY

(1) 1 point (outside · 1)

(4) 3 points (outside · 1)

(7) 4 points (outside · 1)

(2) 1 point (outside · 2)

(5) 6 points (outside · 1)

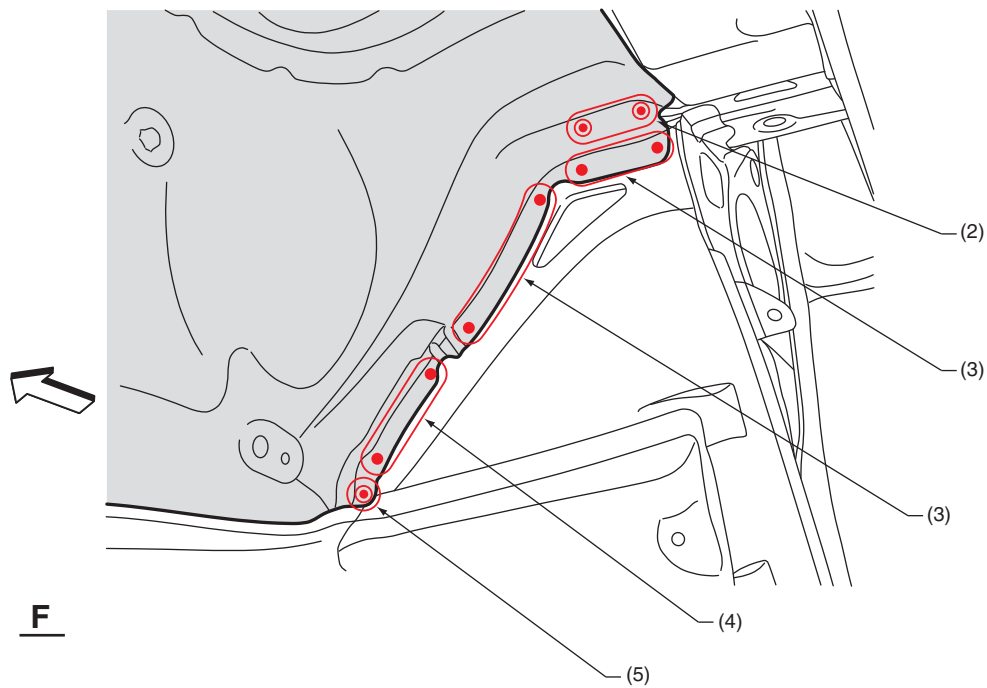
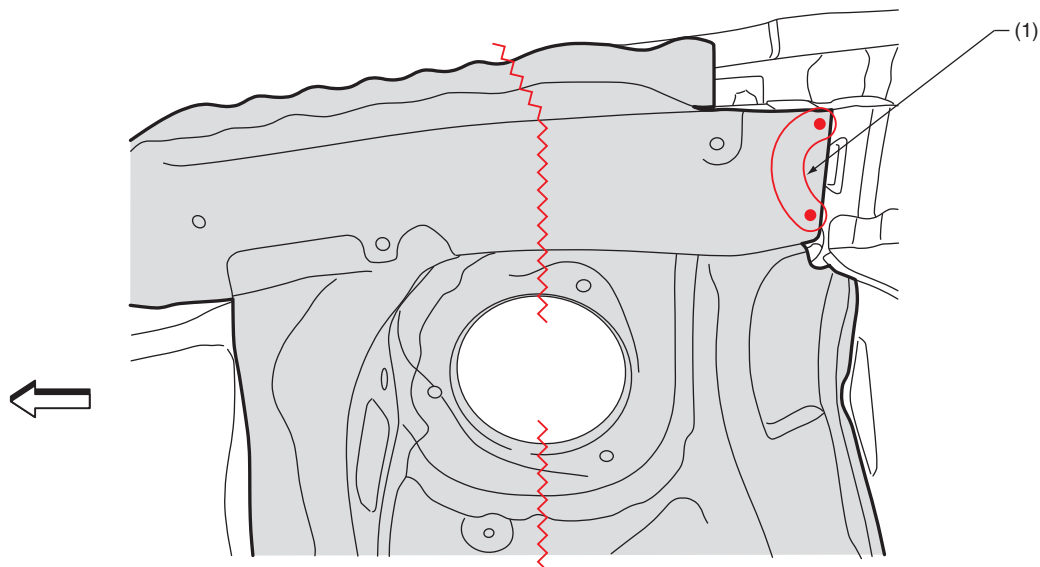
(8) 2 points (outside · 1, belt sander)

(3) 2 points (outside · 2)

(6) 2 points (outside · 1)

Panel Replacement

• Views 3



BS-04801

(1) 4 points (bottom · 1)

(2) 2 points (bottom · 1)

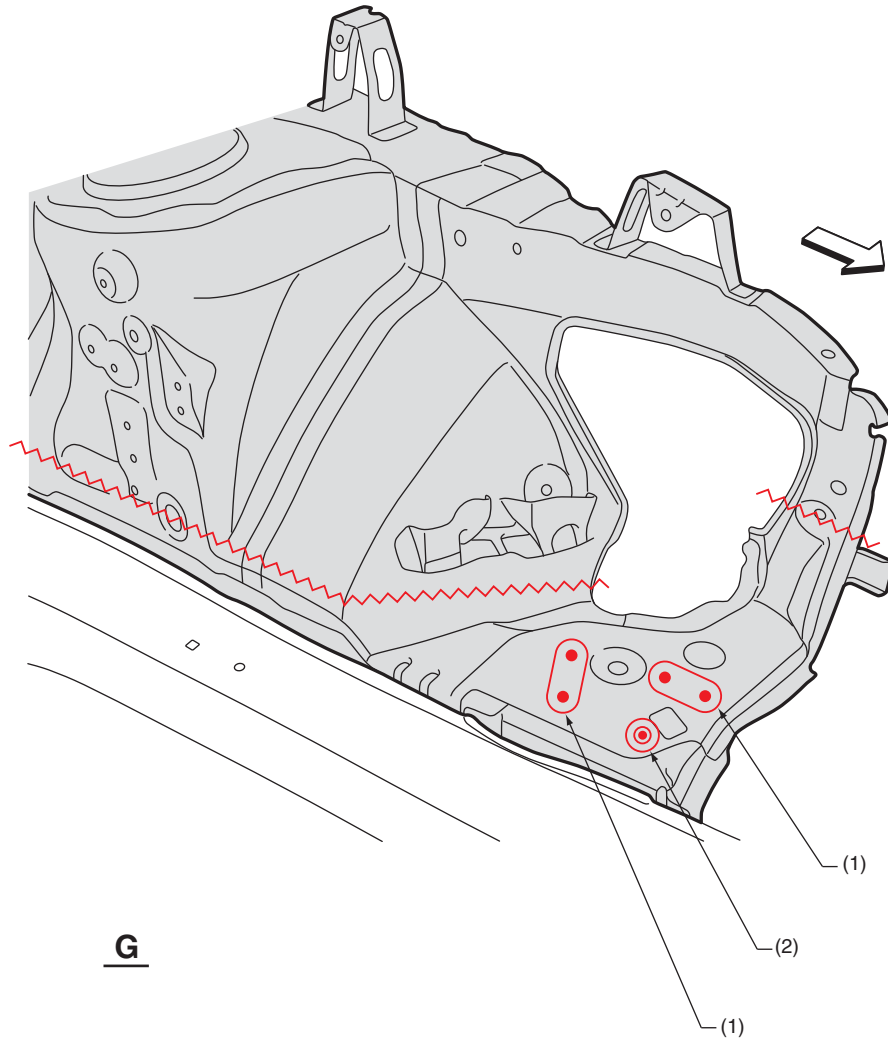
(3) 3 points (outside · 1)

(4) 2 points (outside · 1)

(5) 1 point (outside · 1)

Panel Replacement

• Views 4



BS-04802

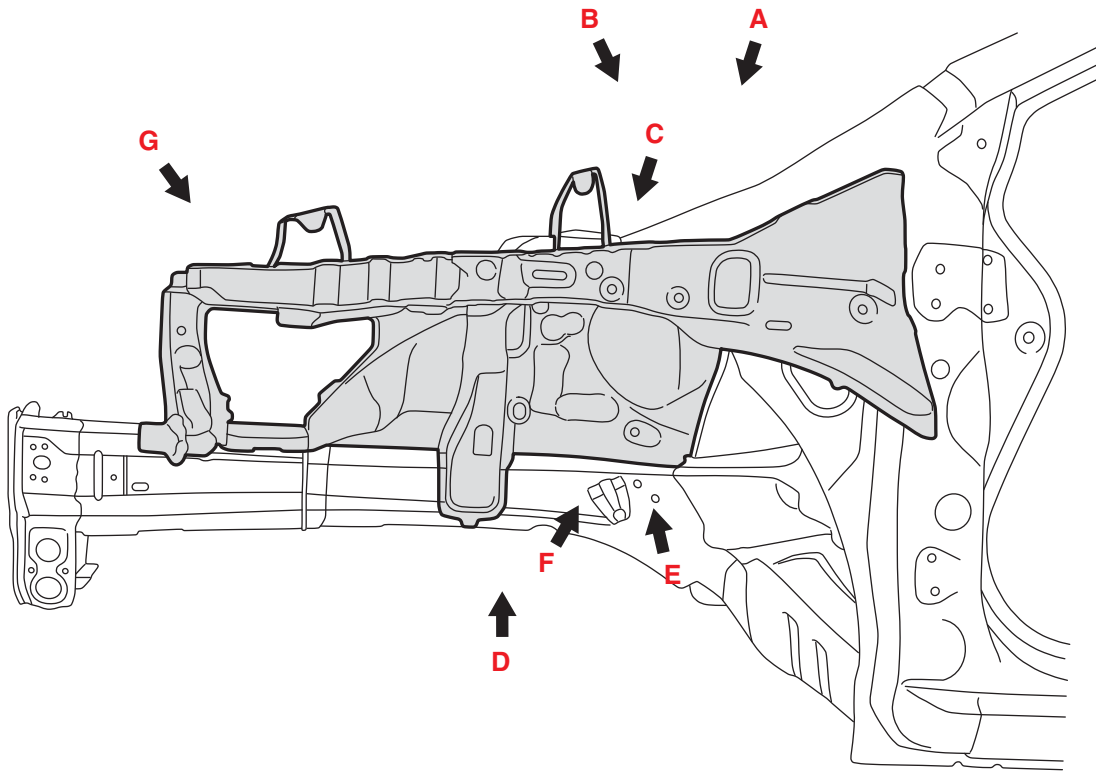
(1) 2 points (top · 1)

(2) 1 point (top · 1)

Panel Replacement

B: INSTALLATION

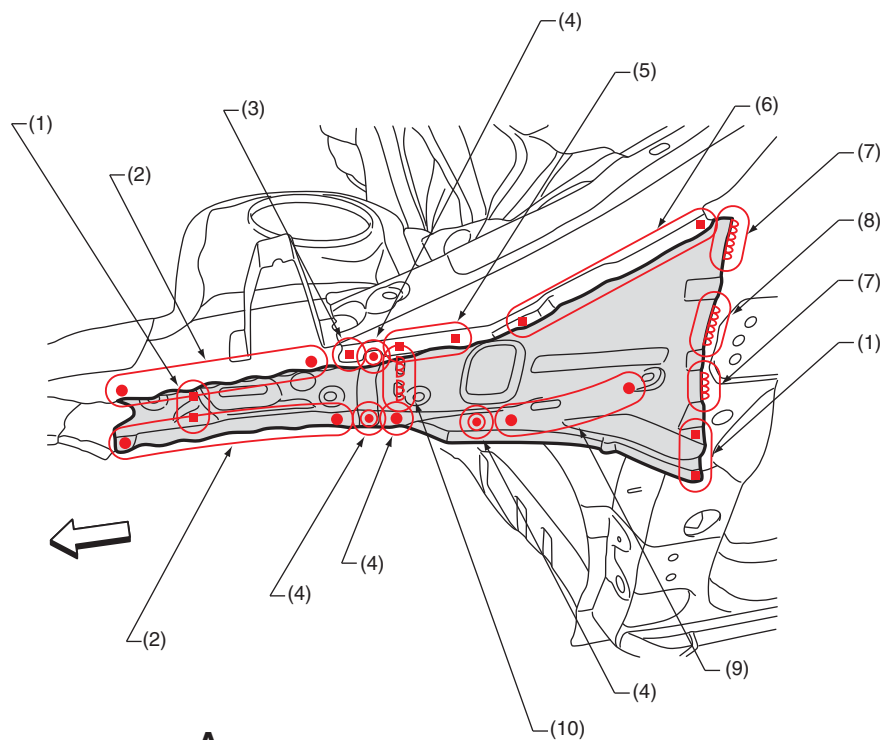
• Overall view



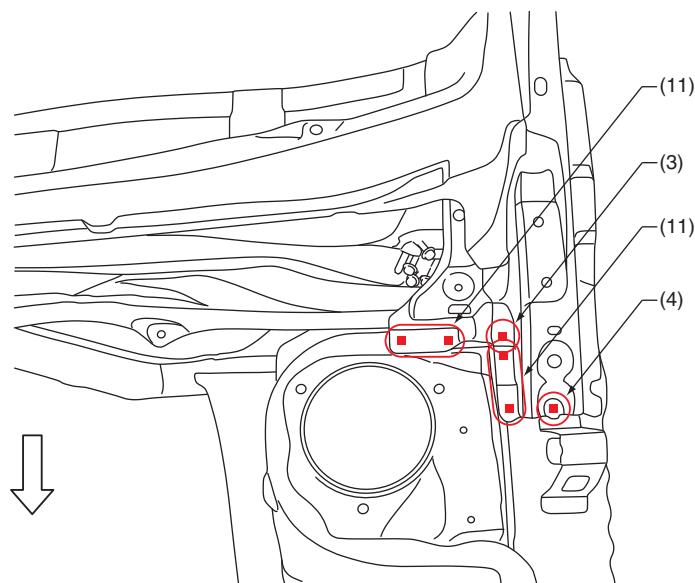
BS-04803

Panel Replacement

• Views 1



A



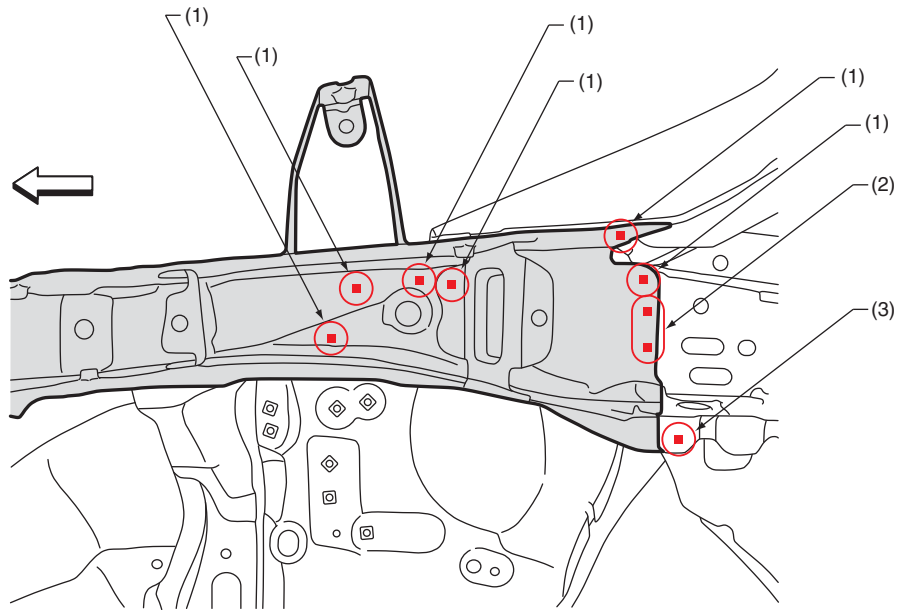
B

BS-04804

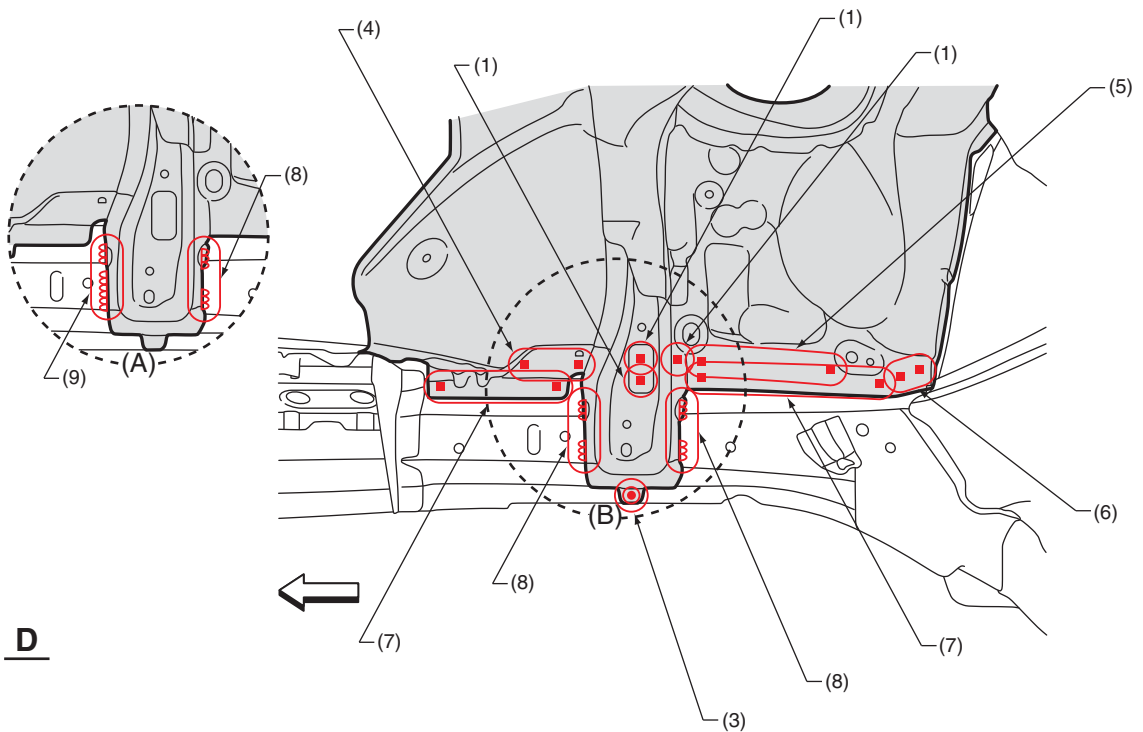
- | | | |
|----------------------------------|-----------------------------------|--------------------------------|
| (1) 2 points (service) | (5) 2 points (service · matching) | (9) 3 points |
| (2) 6 points | (6) 4 points | (10) 2 points [10mm (0.39 in)] |
| (3) 1 point (service · matching) | (7) 1 point [30mm (1.18 in)] | (11) 2 points |
| (4) 1 point | (8) 1 point [40mm (1.57 in)] | |

Panel Replacement

• Views 2



C



D

BS-05838

(A) LH of the 14MY

(B) Both sides of the model up to 13MY, and RH of the 14MY

(1) 1 point (service)

(4) 3 points (service)

(7) 4 points (service)

(2) 2 points (service · matching)

(5) 6 points (service)

(8) 2 points [20mm (0.79 in)]

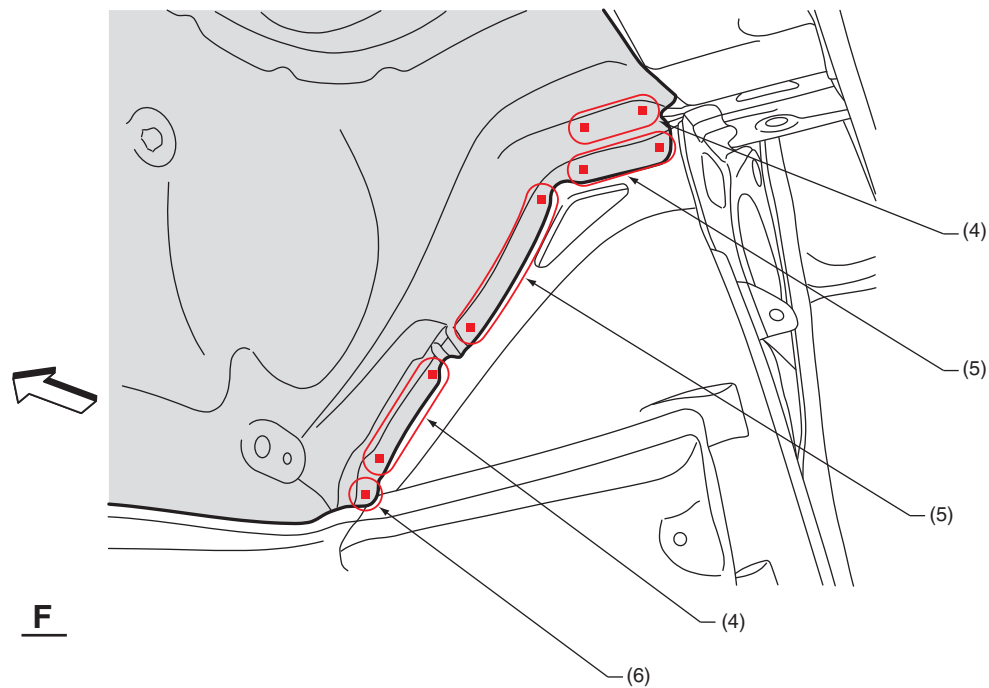
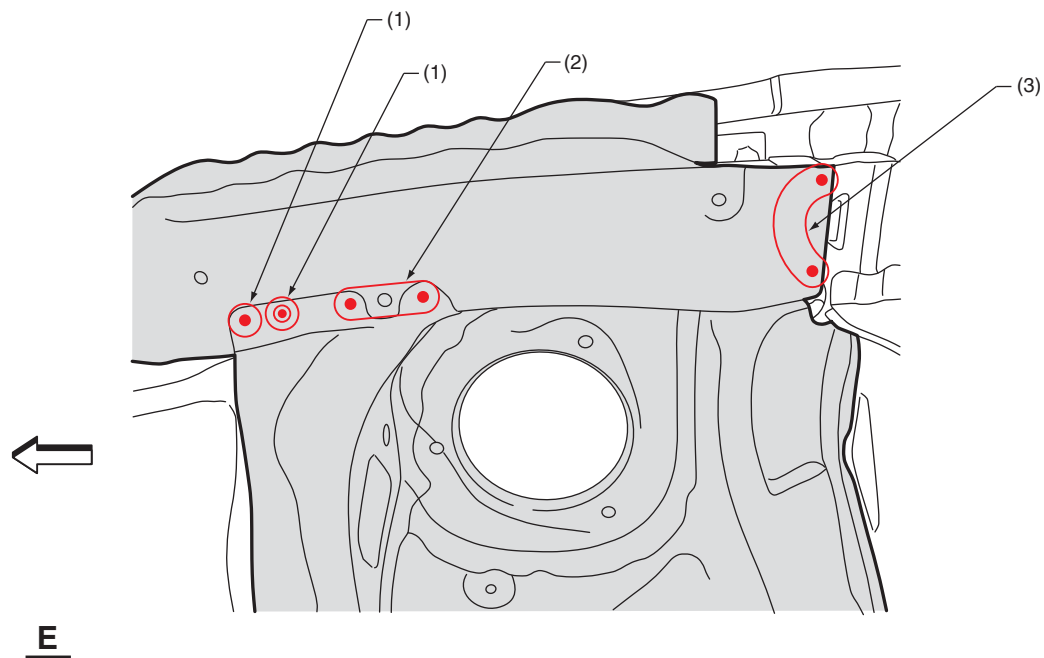
(3) 1 point

(6) 2 points (service)

(9) 2 points [10mm (0.39 in), 40 mm (1.57 in)]

Panel Replacement

• Views 3



BS-04806

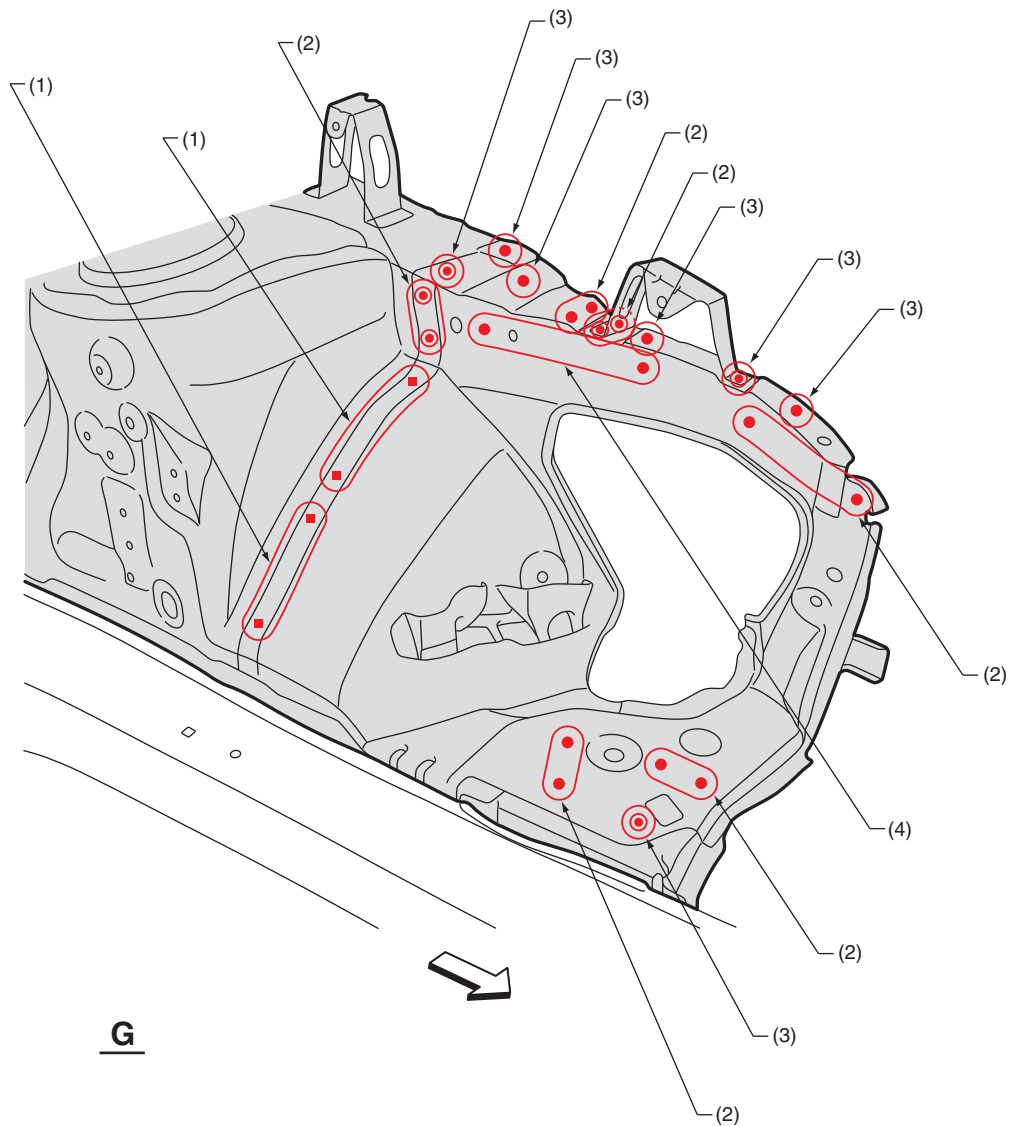
- (1) 1 point
- (2) 2 points

- (3) 4 points
- (4) 2 points (service)

- (5) 3 points (service)
- (6) 1 point (service)

Panel Replacement

• Views 4



BS-04807

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

(3) 1 point

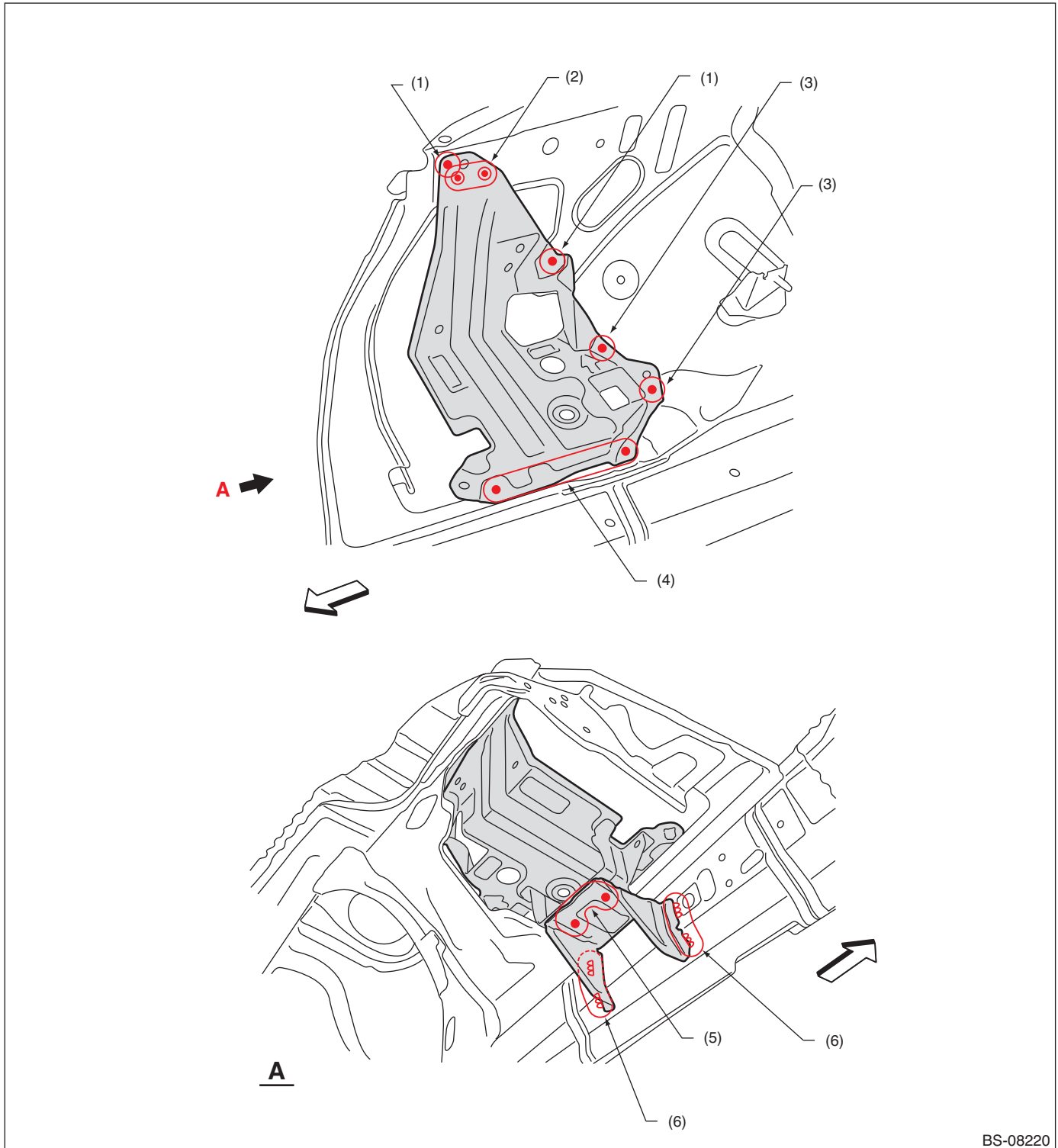
(4) 3 points

Panel Replacement

7-3. Front Wheel Apron RH (partial replacement)/Hybrid Model

A: REMOVAL

- Radiator panel removal condition

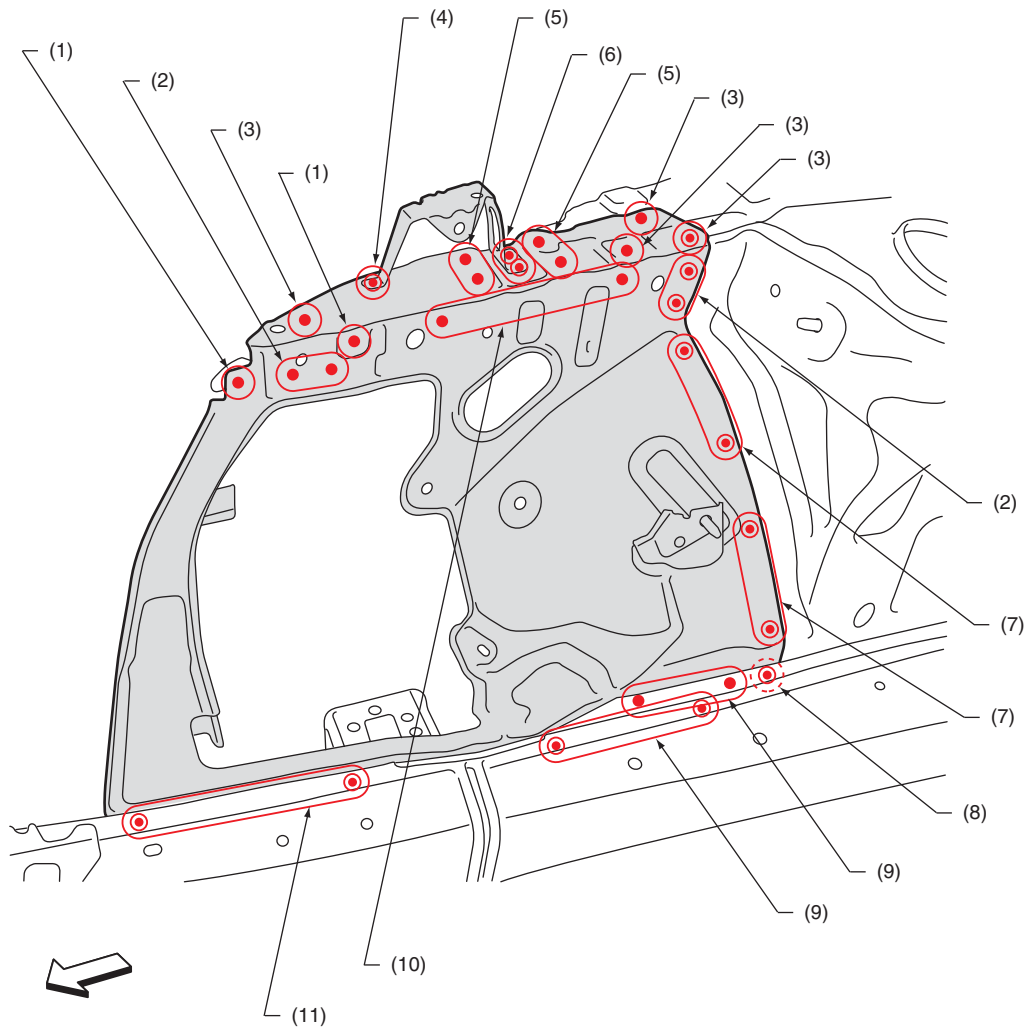


- (1) 1 point (inside · 1)
- (2) 2 points (inside · 1)

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

- (5) 3 points (bottom · 1)
- (6) 2 points (outside · 1 belt sander)

Panel Replacement

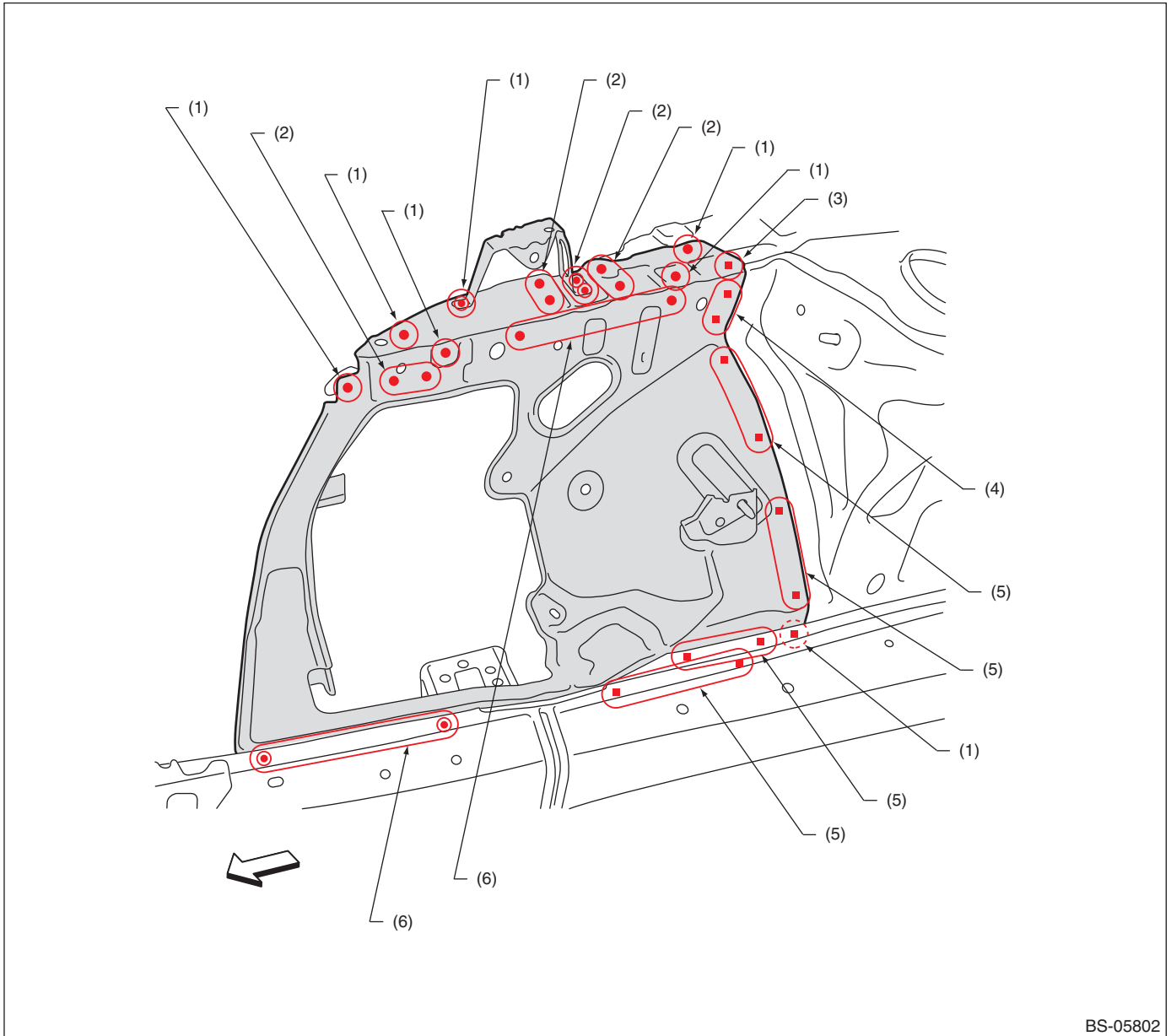


BS-05801

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

Panel Replacement

B: INSTALLATION

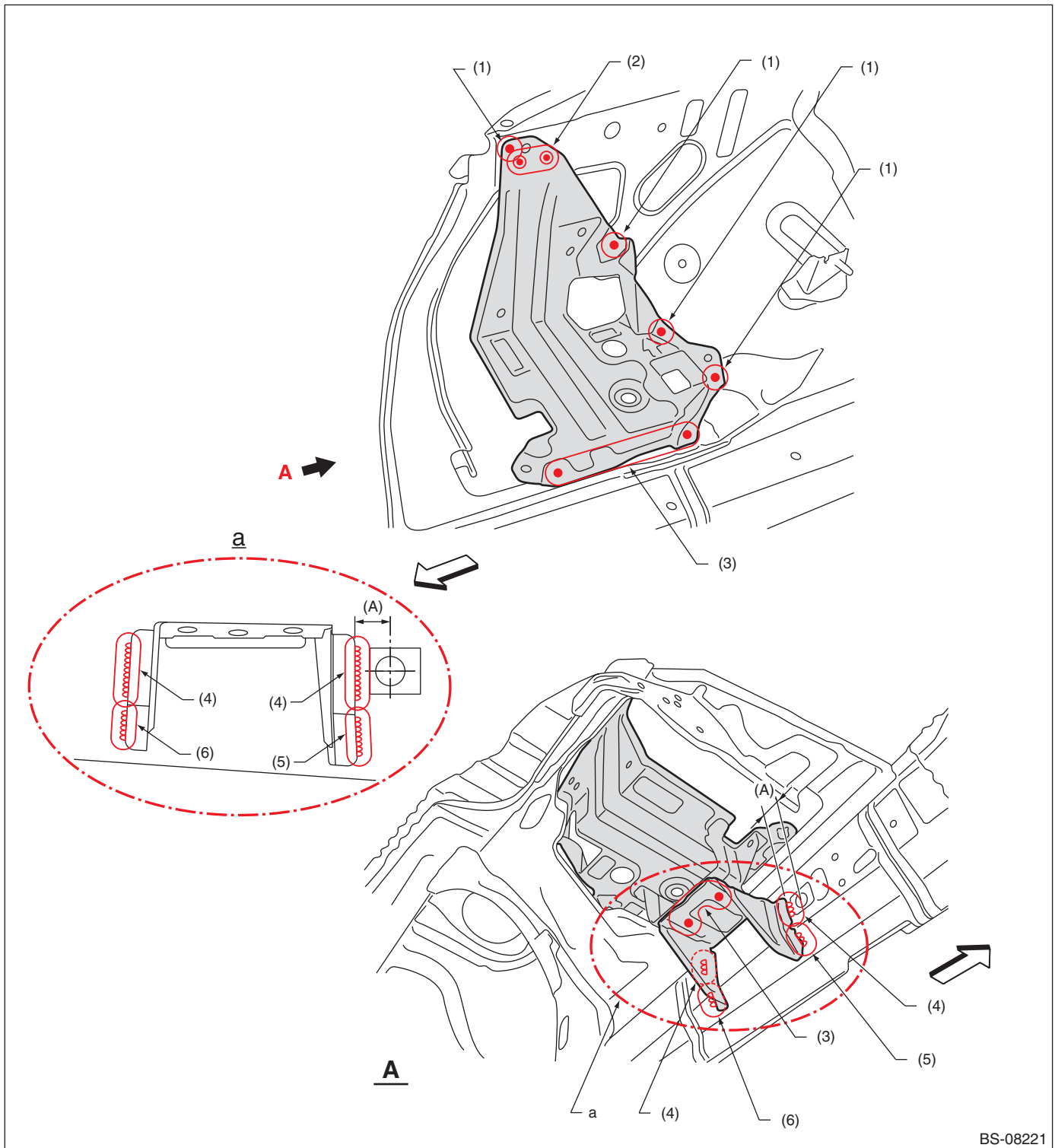


(1) 1 point
(2) 2 points

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

(5) 4 points (service)
(6) 3 points

Panel Replacement



BS-08221

(A) 17.9 mm (0.70 in)

(1) 1 point

(2) 2 points

(3) 3 points

(4) 1 point [30 mm (1.18 in)]

(5) 1 point [20 mm (0.79 in)]

(6) 1 point [15 mm (0.59 in)]

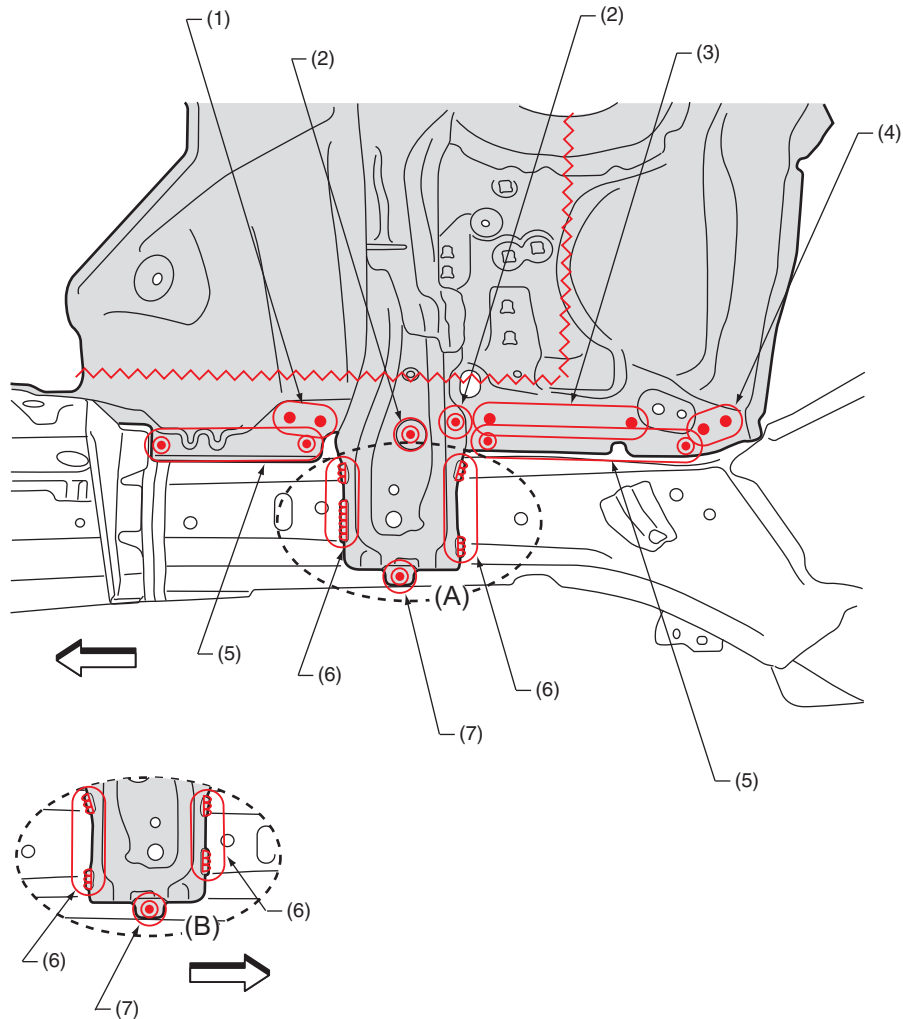
For the part marked by "a": The gusset shall be positioned vertically in a way that its bent part fits over that of the closing plate.

Panel Replacement

7-4. Front Wheel Apron RH (total replacement)/Hybrid Model

A: REMOVAL

• Radiator panel removal condition



BS-05888

(A) LH

(B) RH

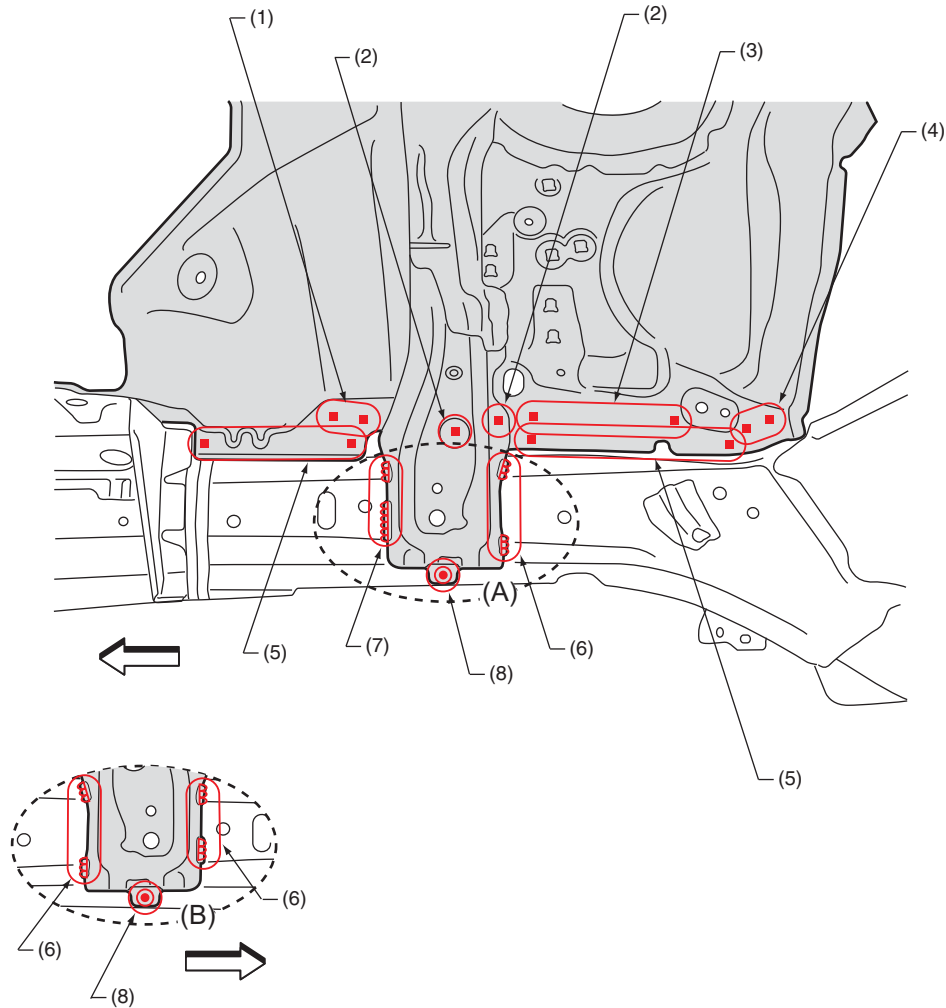
- (1) 3 points (outside · 1)
- (2) 1 point (outside · 2)
- (3) 6 points (outside · 1)

- (4) 2 points (outside · 1)
- (5) 4 points (outside · 1)
- (6) 2 points (outside · 1 belt sander)

- (7) 1 point (outside · 1)

Panel Replacement

B: INSTALLATION



BS-05889

(A) LH

(B) RH

(1) 3 points (service)

(4) 2 points (service)

(7) 2 points [10 mm (0.39 in), 40 mm (1.59 in)]

(2) 1 point (service)

(5) 4 points (service)

(8) 1 point

(3) 6 points (service)

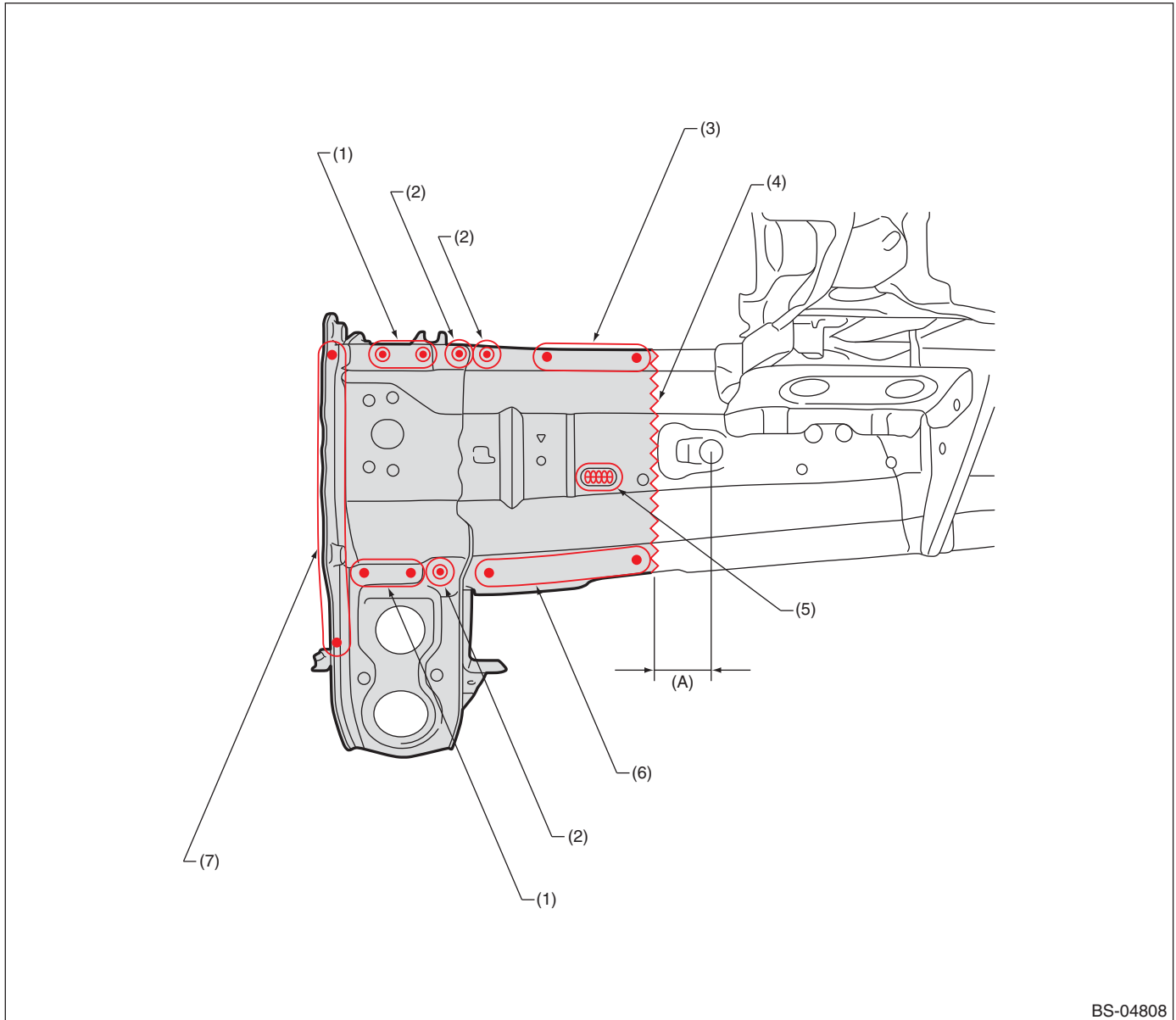
(6) 2 points [20 mm (0.39 in)]

Panel Replacement

7-5. Closing Plate (partial replacement)

A: REMOVAL

• LH



BS-04808

(A) 40 mm (1.57 in)

(1) 2 points (outside · 1)

(4) Cut position [160 mm (6.3 in)] For butt welding

(7) 6 points (outside · 1)

(2) 1 point (outside · 1)

(5) 1 point (outside · 1, belt sander)

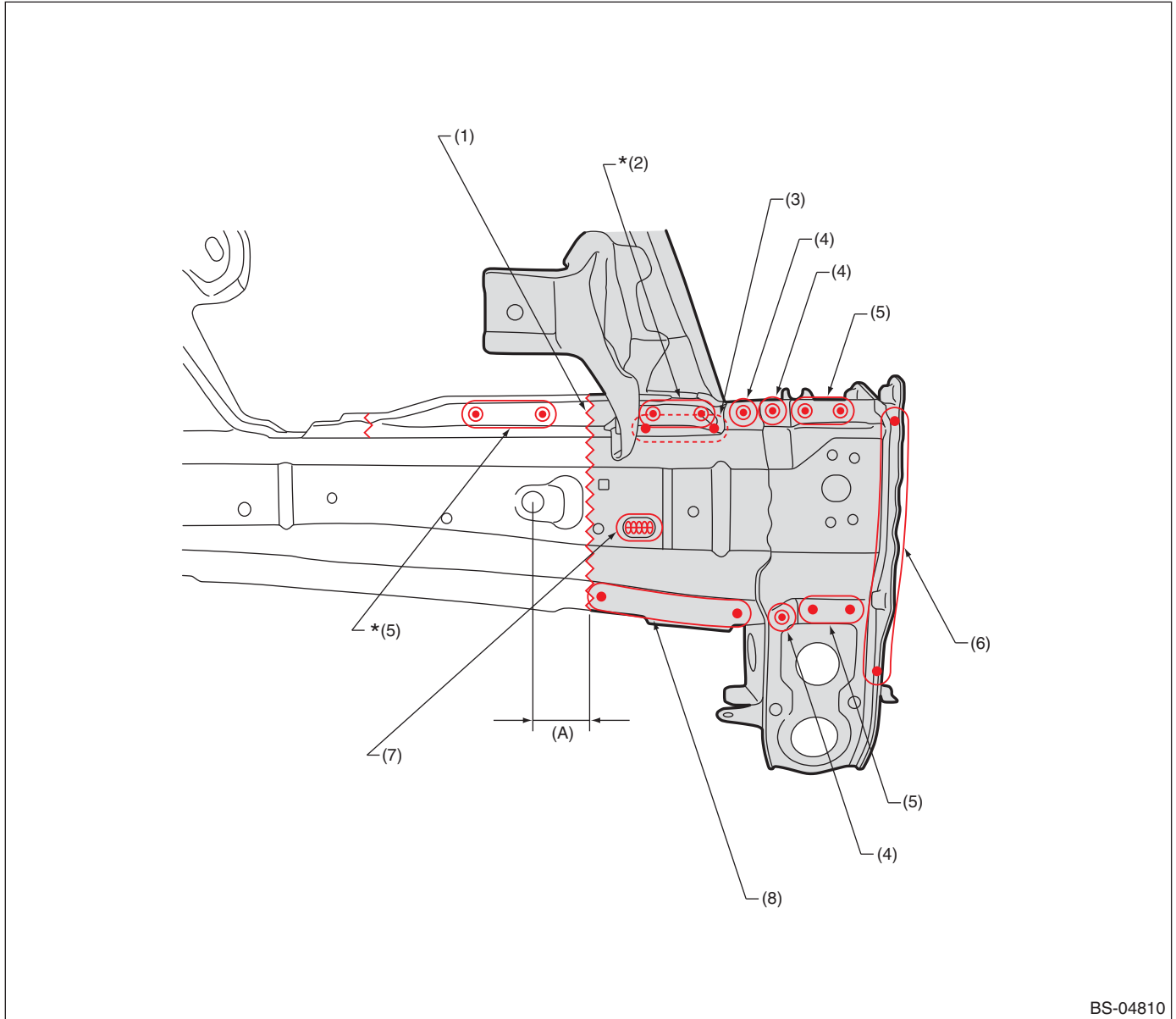
(3) 3 points (outside · 1)

(6) 5 points (outside · 1)

Some parts of the front side frame may have a different shape depending on the vehicle type and model year, but the number and location of welding points are the same in all models.

Panel Replacement

• RH



(A) 40 mm (1.57 in)

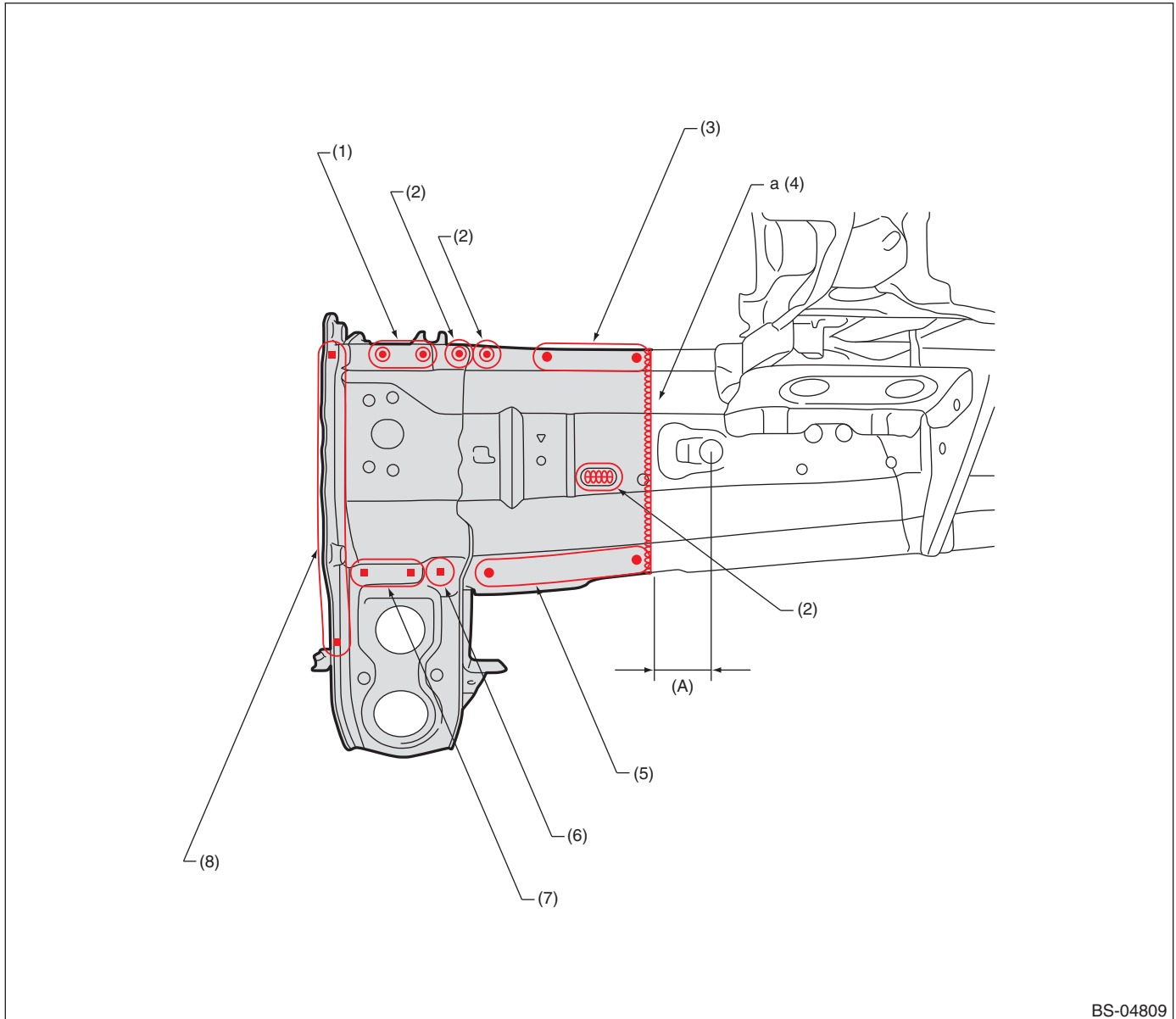
- | | | |
|---|----------------------------|--|
| (1) Closing plate cut position [160 mm (6.3 in)] For butt welding | (4) 1 point (outside · 1) | (7) 1 point (outside · 1, belt sander) |
| (2) 2 points (outside · 1, belt sander) | (5) 2 points (outside · 1) | (8) 5 points (outside · 1) |
| (3) 3 points (outside · 1) | (6) 6 points (outside · 1) | |

- For part marked by “*”: A part of the front wheel apron is raised to facilitate closing plate cutting.
- Some parts of the front side frame may have a different shape depending on the vehicle type and model year, but the number and location of welding points are the same in all models.

Panel Replacement

B: INSTALLATION

• LH



BS-04809

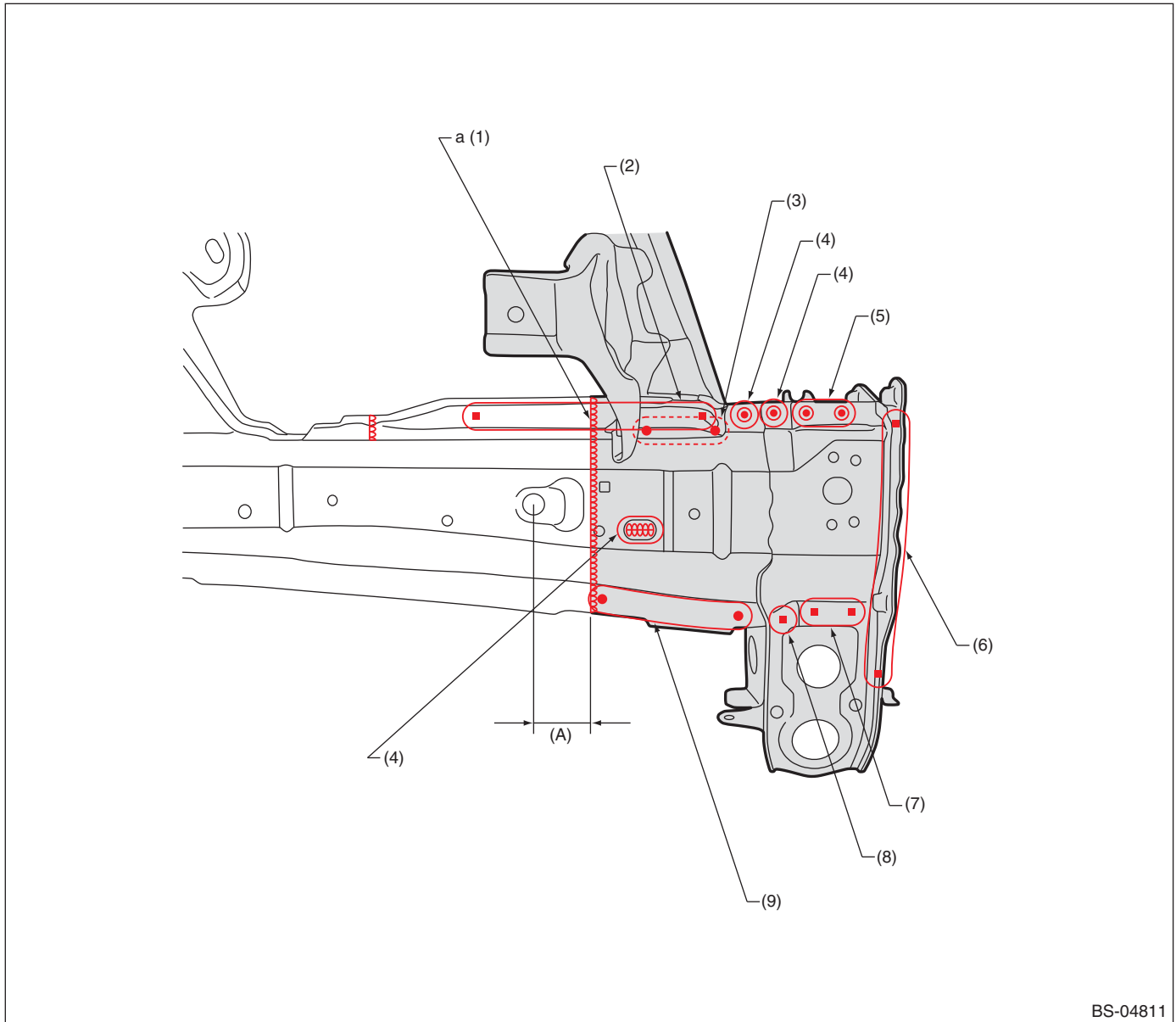
(A) 40 mm (1.57 in)

- | | | |
|--------------|-------------------------------|------------------------|
| (1) 2 points | (4) 1 point [160 mm (6.3 in)] | (7) 2 points (service) |
| (2) 1 point | (5) 5 points | (8) 6 points |
| (3) 3 points | (6) 1 point (service) | |

- For part marked by “a”: Anticorrosion wax shall be applied thoroughly on the back side of continuous welding portion.
- Some parts of the front side frame may have a different shape depending on the vehicle type and model year, but the number and location of welding points are the same in all models.

Panel Replacement

• RH



(A) 40 mm (1.57 in)

(1) 1 point [160 mm (6.3 in)]

(2) 4 points

(3) 3 points

(4) 1 point

(5) 2 points

(6) 6 points

(7) 2 points (service)

(8) 1 point (service)

(9) 5 points

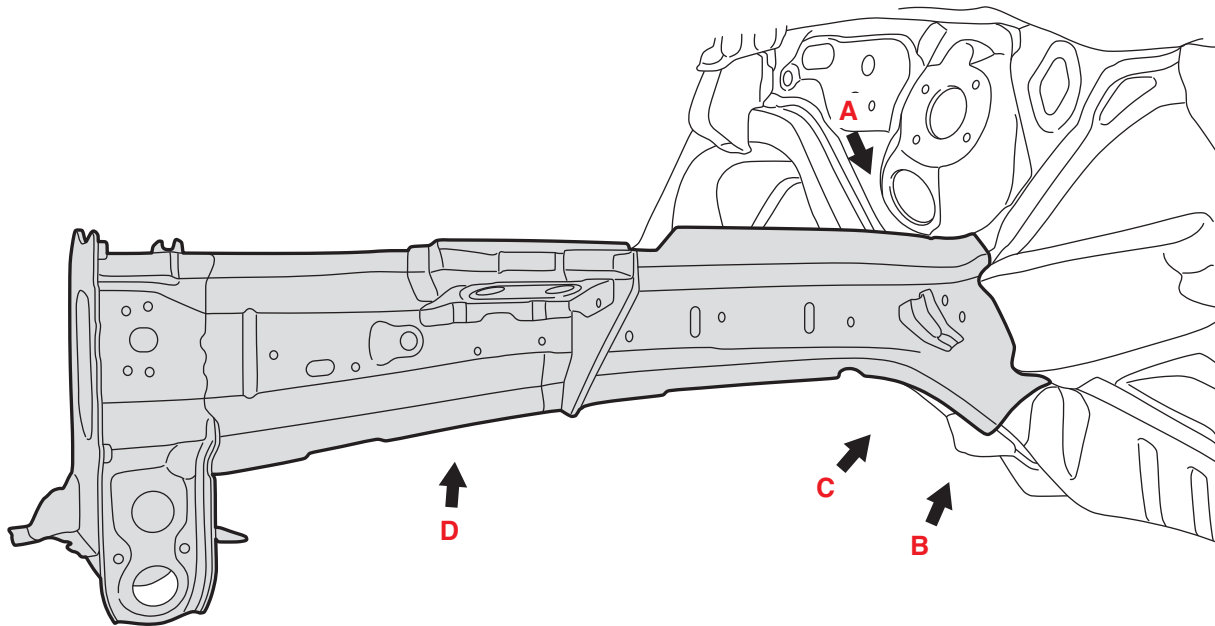
- For part marked by “a”: Anticorrosion wax shall be applied thoroughly on the back side of continuous welding portion.
- Some parts of the front side frame may have a different shape depending on the vehicle type and model year, but the number and location of welding points are the same in all models.

Panel Replacement

7-6. Front Side Frame (total replacement)

A: REMOVAL

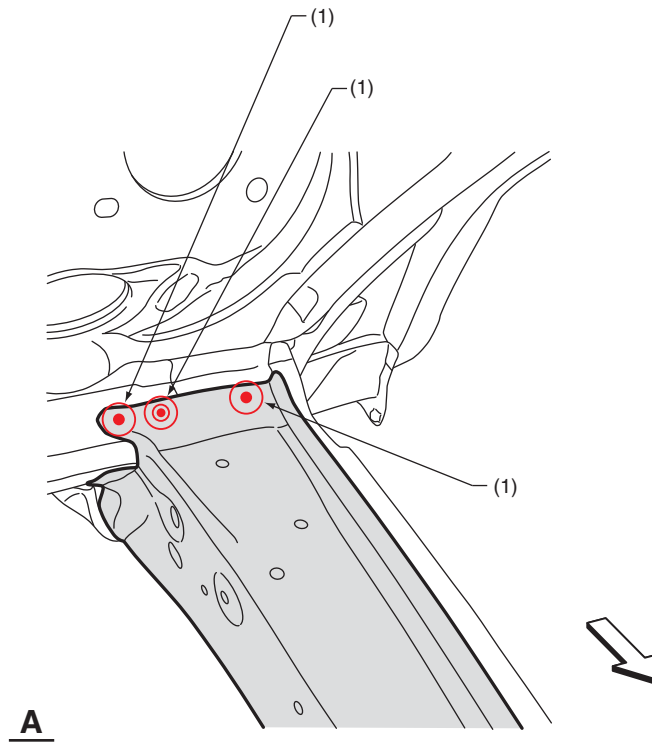
- Overall view (Radiator panel and front wheel apron removal condition)



BS-08222

Panel Replacement

• Views 1

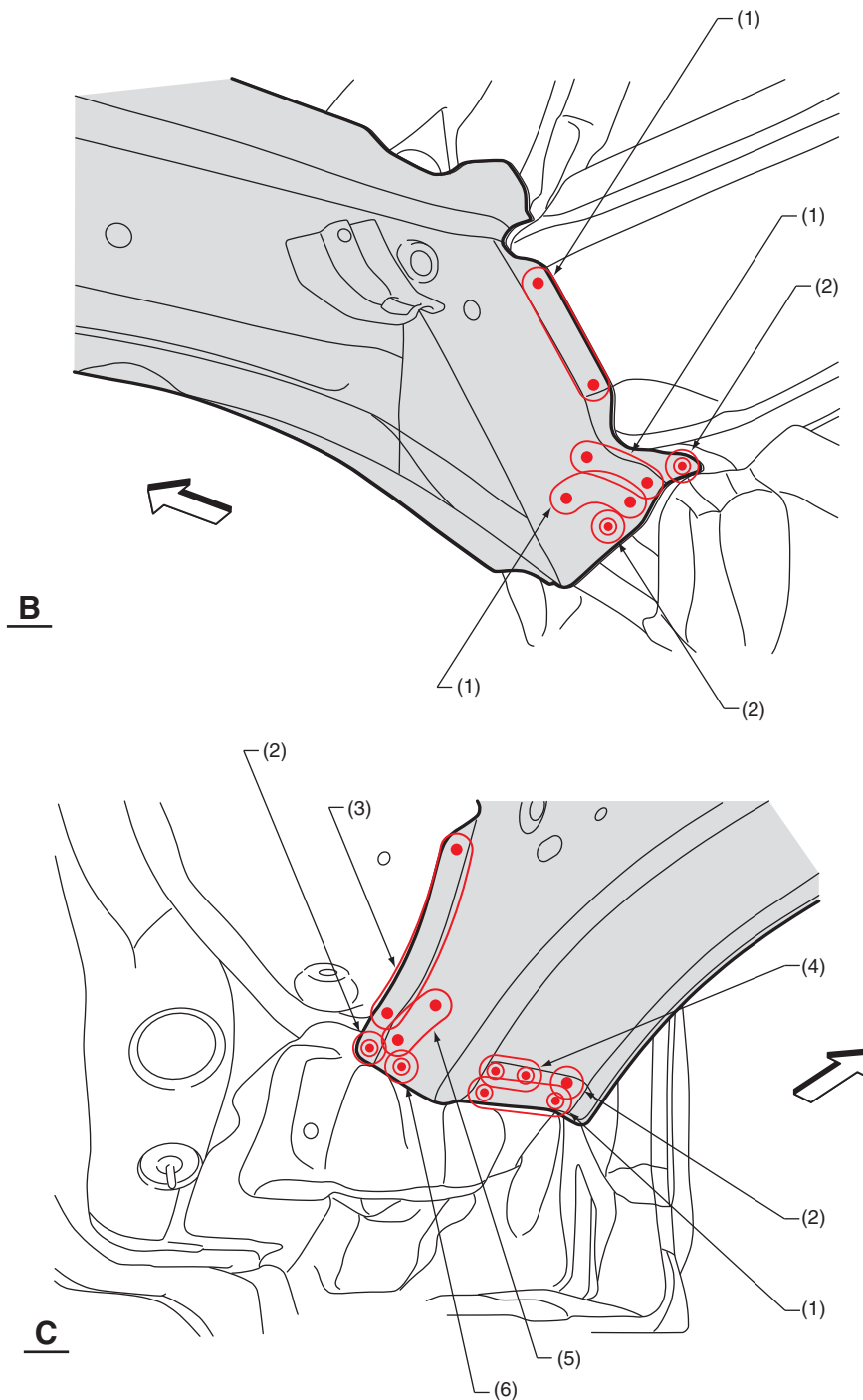


BS-04817

(1) 1 point (top · 1)

Panel Replacement

• Views 2



BS-04818

(1) 3 points (outside · 1)

(2) 1 point (outside · 1)

(3) 4 points (outside · 1)

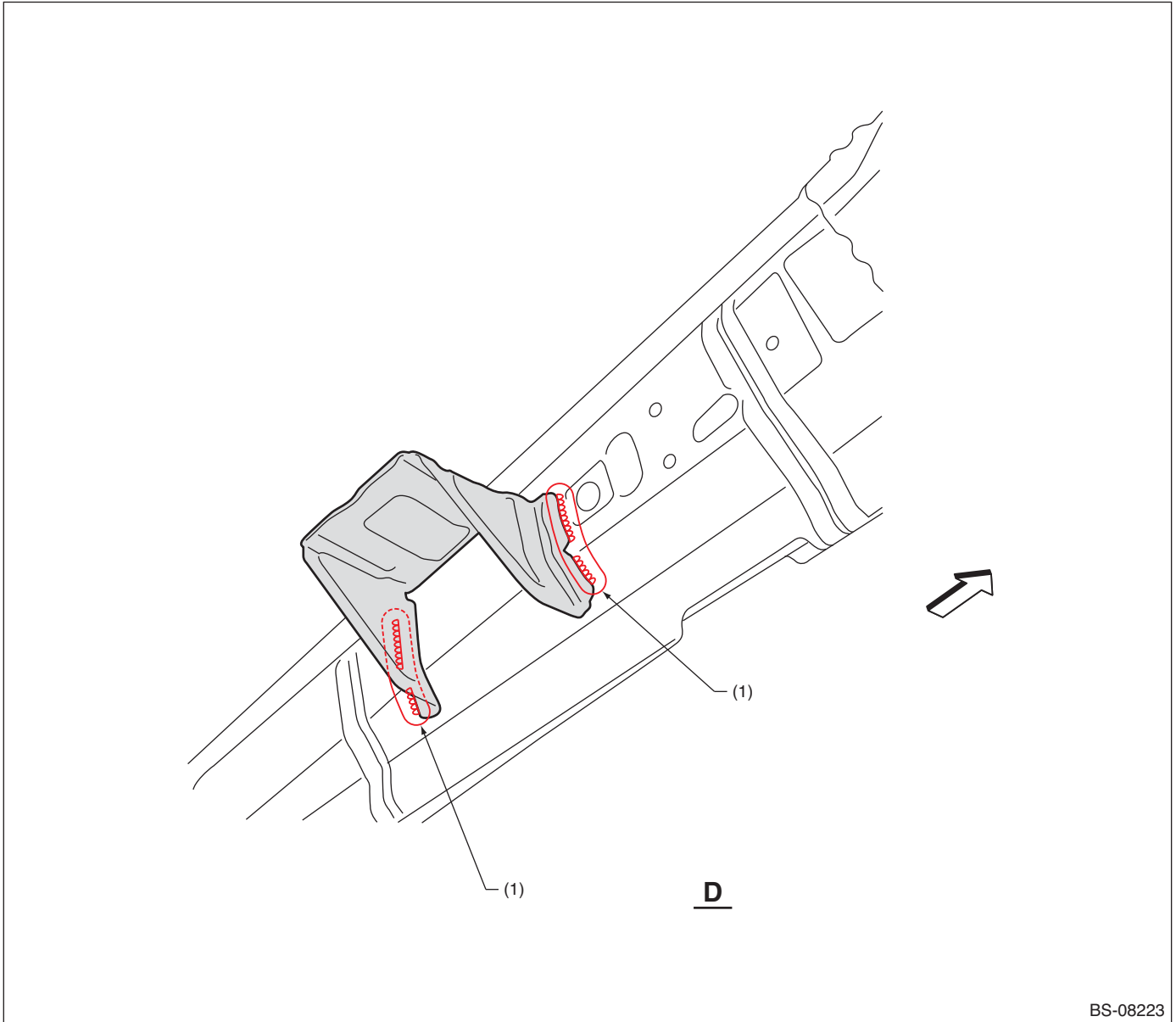
(4) 2 points (outside · 2)

(5) 3 points (inside · 1)

(6) 1 point (inside · 1)

Panel Replacement

- Views 3 (Hybrid Model RH)

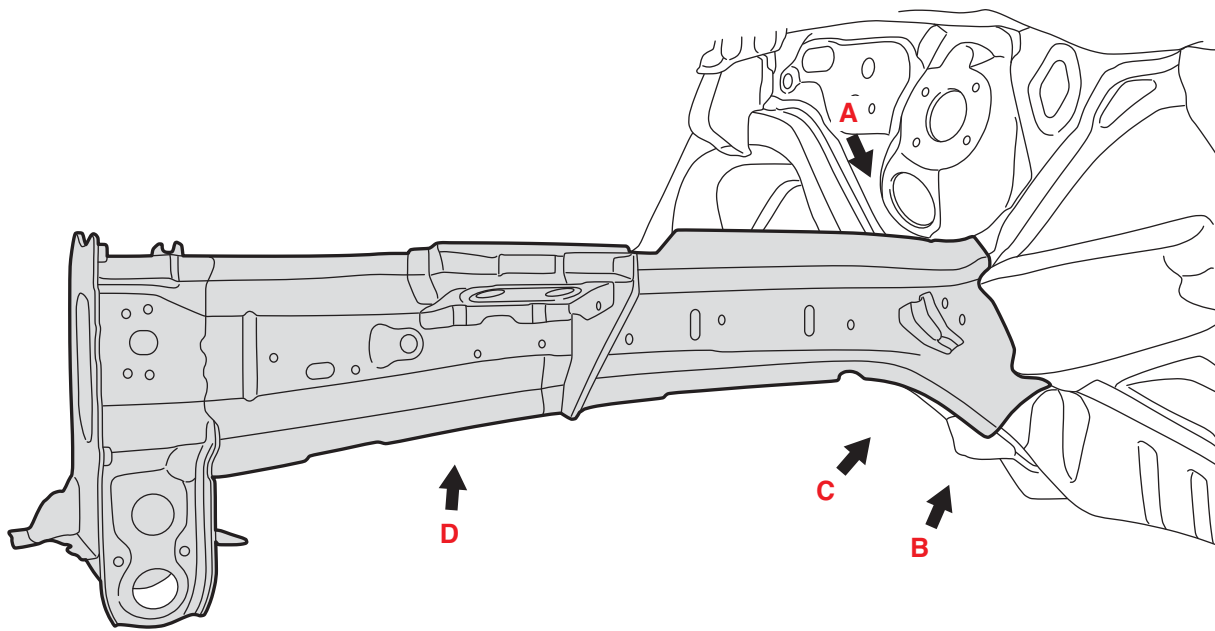


BS-08223

(1) 2 points (outside · 1, belt sander)

B: INSTALLATION

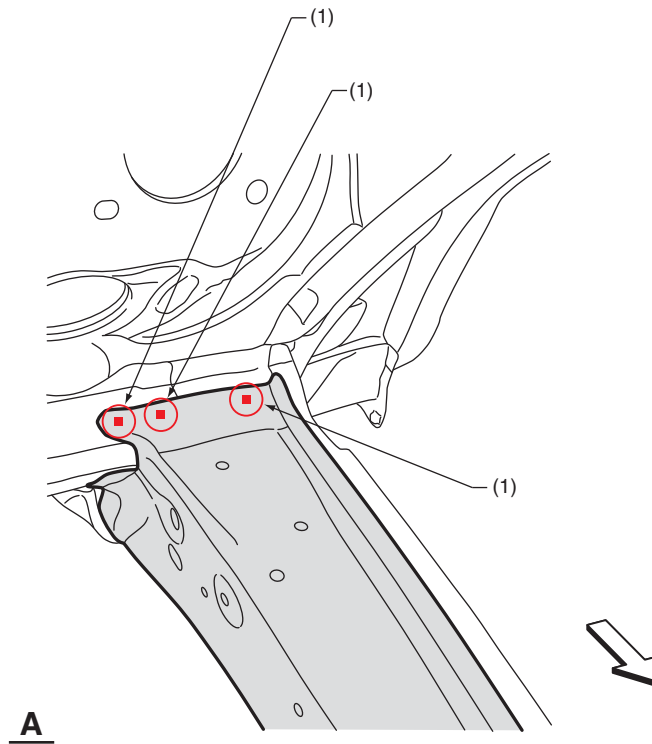
• Overall view



BS-08222

Panel Replacement

• Views 1

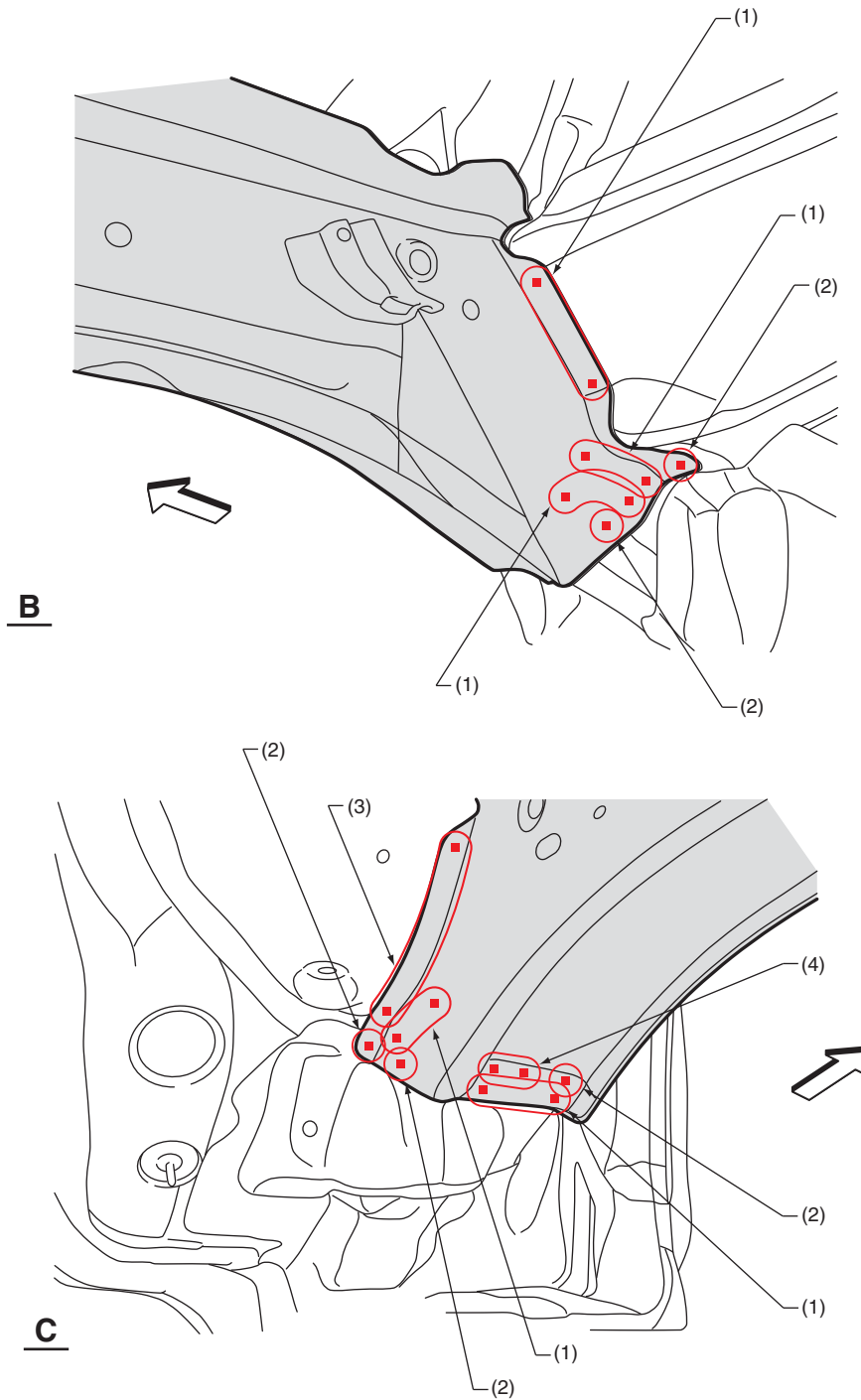


BS-04820

(1) 1 point (service)

Panel Replacement

• Views 2



BS-04821

(1) 3 points (service)

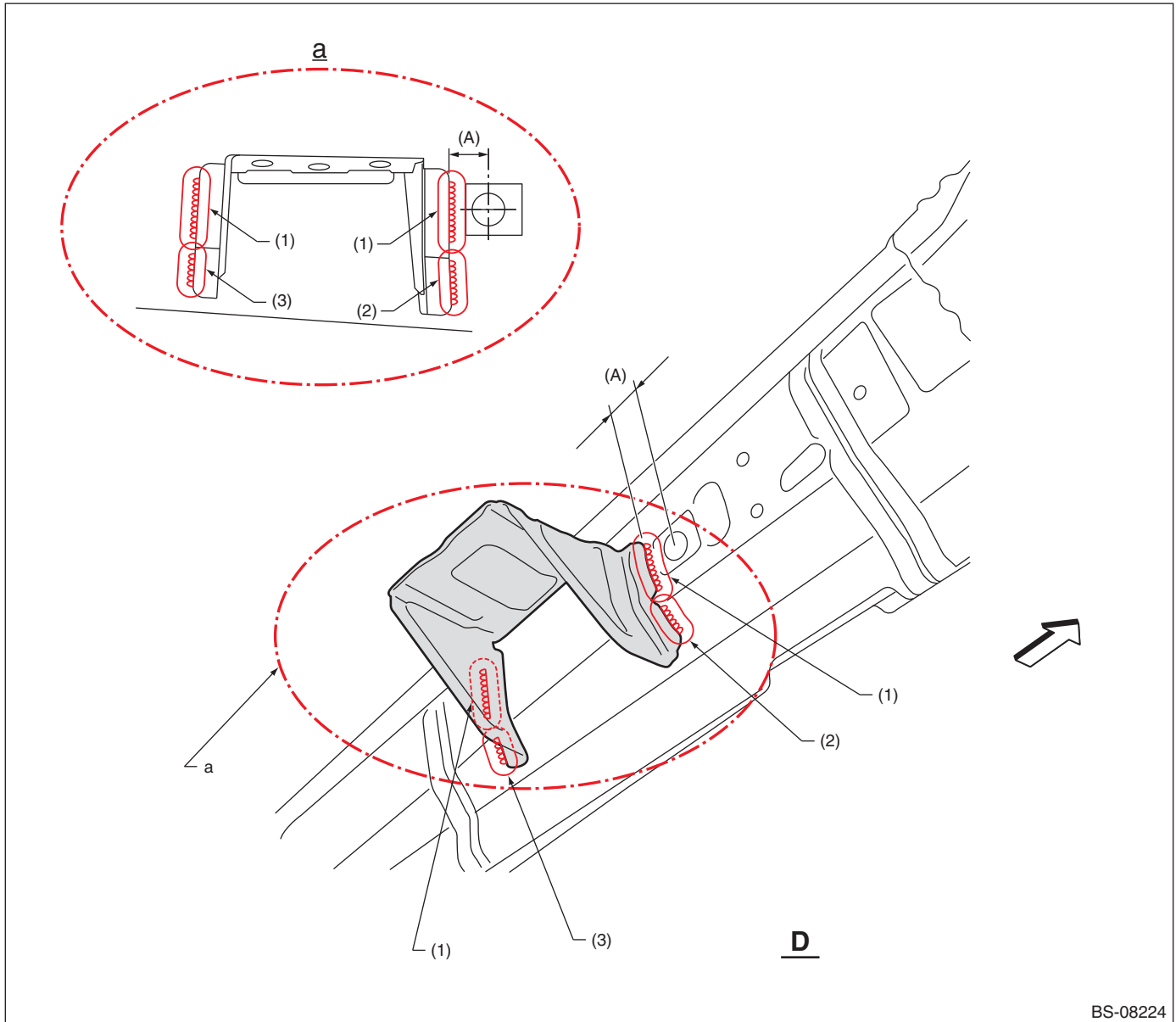
(2) 1 point (service)

(3) 4 points (service)

(4) 2 points (service)

Panel Replacement

• Views 3 (Hybrid Model RH)



BS-08224

(A) 17.9 mm (0.70 in)

(1) 1 point [30 mm (1.18 in)]

(2) 1 point [20 mm (0.79 in)]

(3) 1 point [15 mm (0.59 in)]

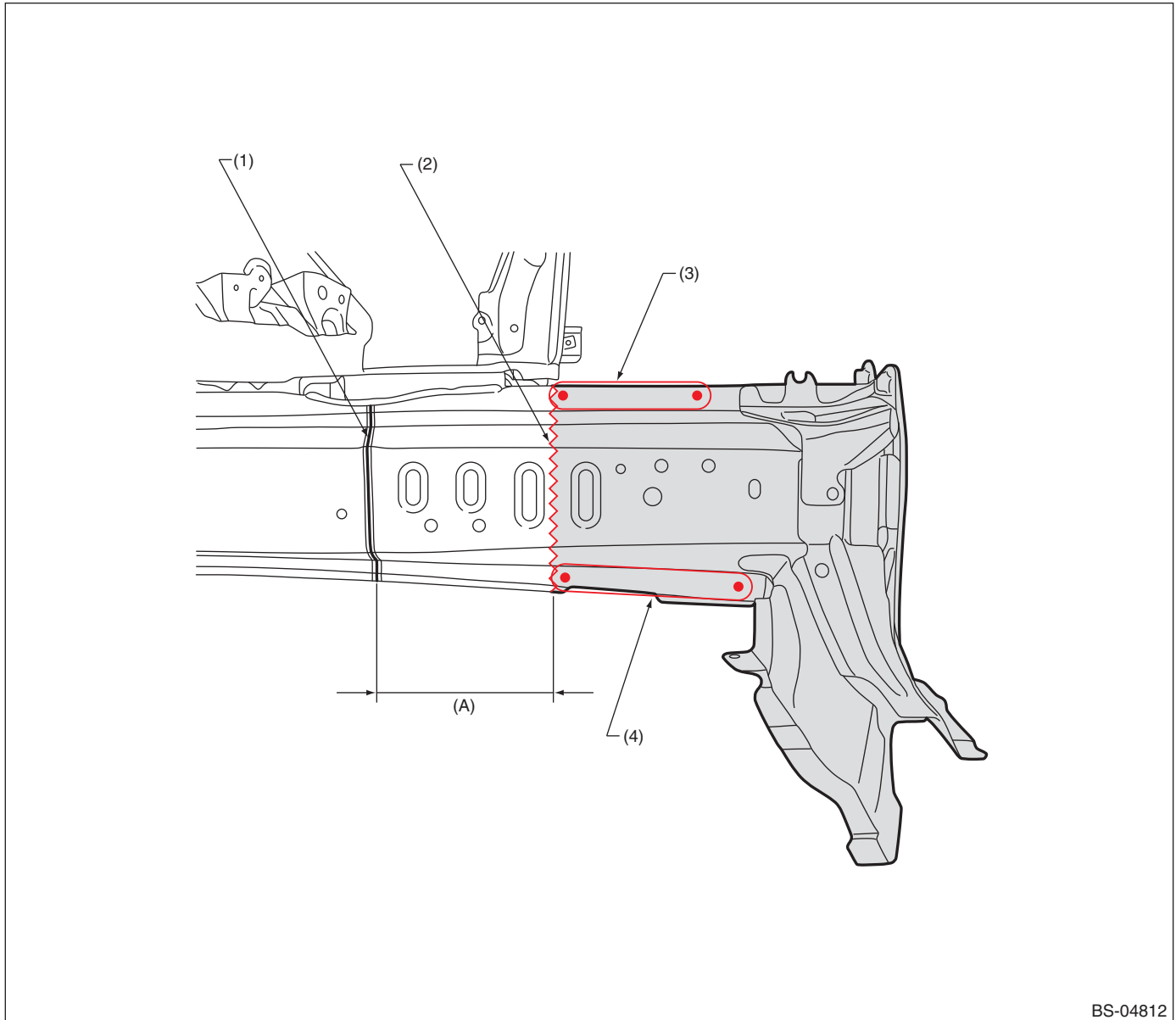
For the part marked by "a": The gusset shall be positioned vertically in a way that its bent part fits over that of the closing plate.

Panel Replacement

7-7. Front Side Frame (partial replacement)

A: REMOVAL

- LH (Radiator panel removal condition)



BS-04812

(A) 130 mm (5.12 in)

(1) Tailored line

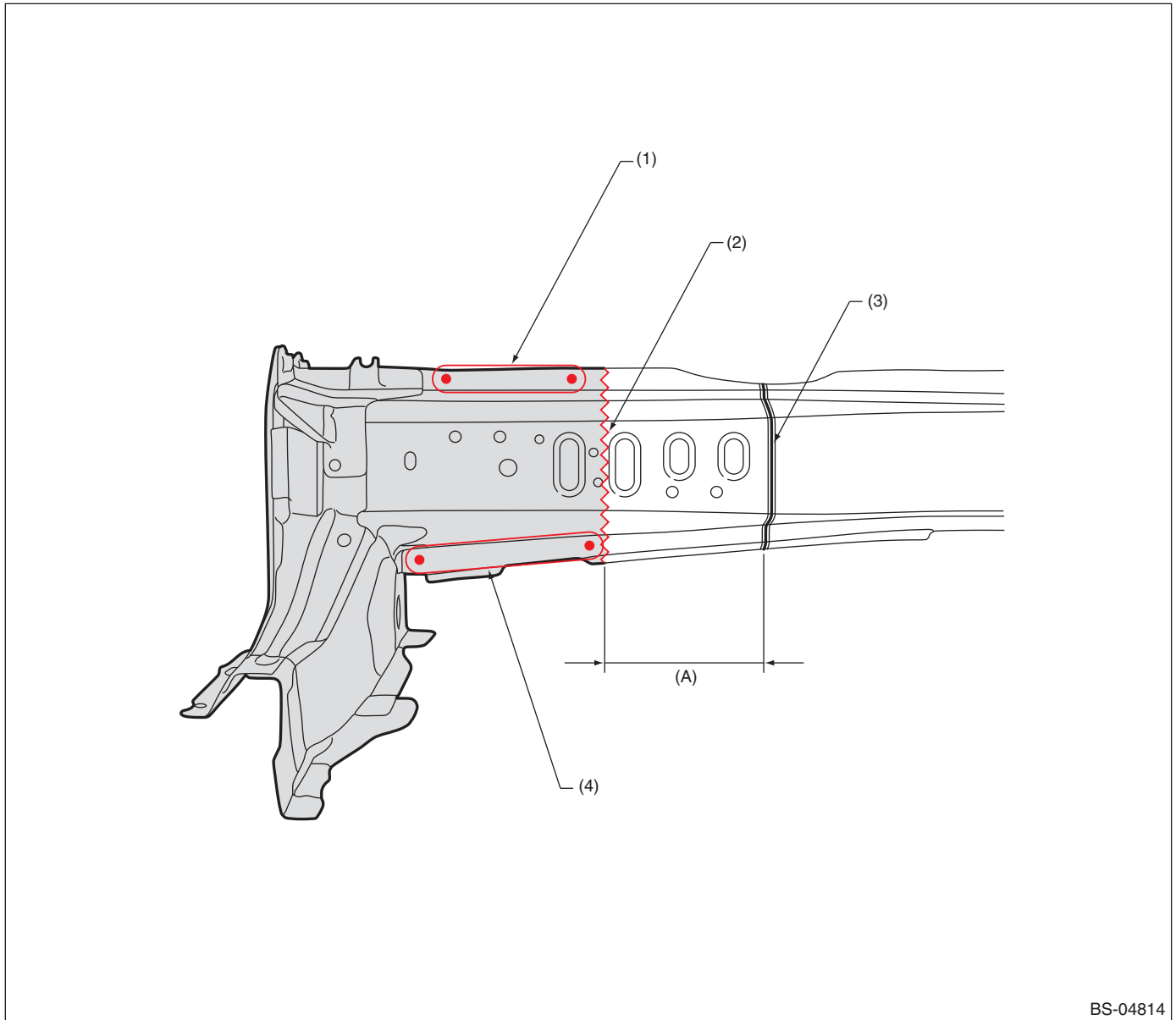
(2) Cut position [220 mm (8.66 in)]
For butt welding

(3) 5 points (inside · 1)

(4) 6 points (inside · 1)

Panel Replacement

• RH (Radiator panel removal condition)



BS-04814

(A) 120 mm (4.72 in)

(1) 5 points (inside · 1)

(3) Tailored line

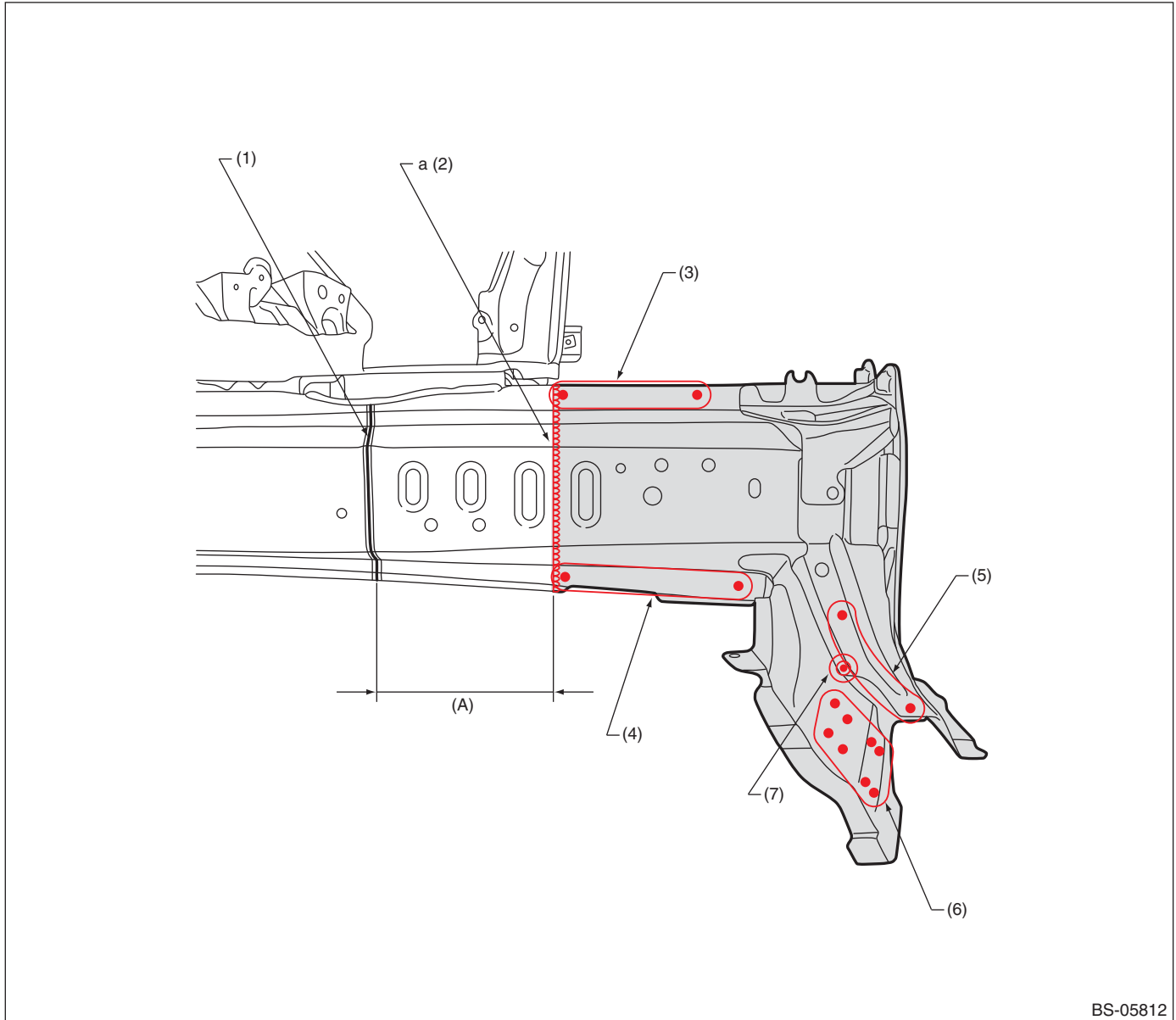
(4) 6 points (inside · 1)

(2) Cut position [220 mm (8.66 in)]
For butt welding

Panel Replacement

B: INSTALLATION

• LH



BS-05812

(A) 130 mm (5.12 in)

(1) Tailored line

(2) 1 point [220 mm (8.66 in)]

(3) 5 points

(4) 6 points

(5) 4 points

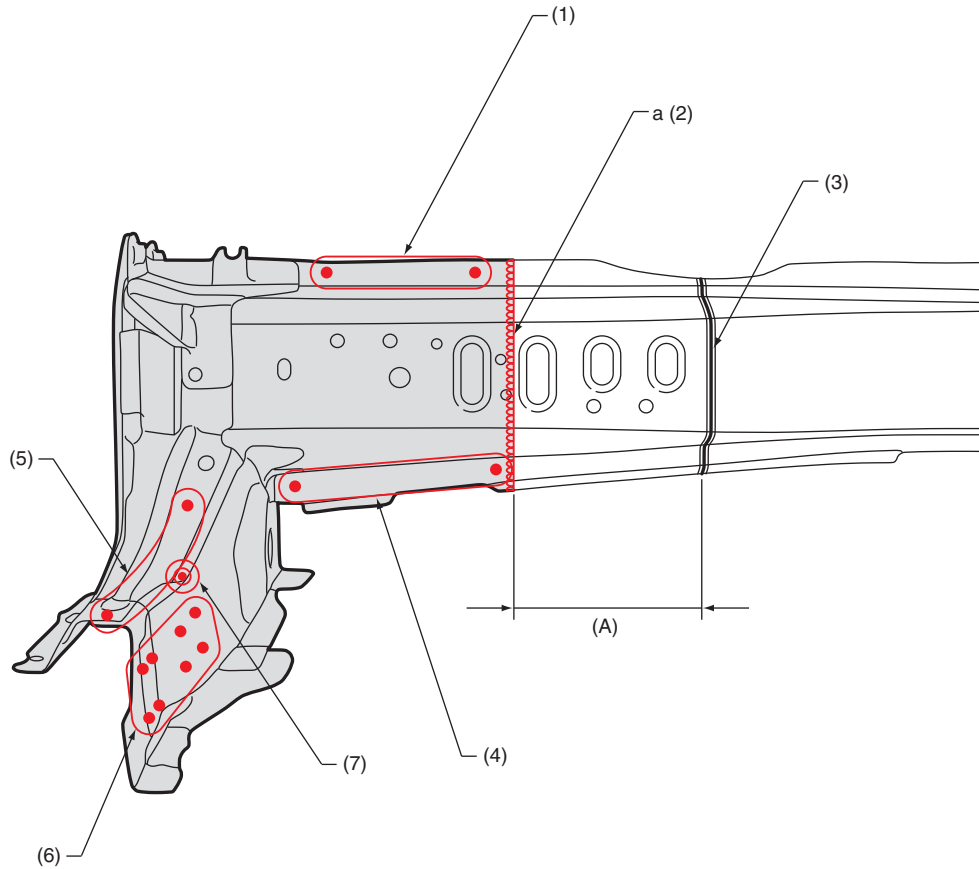
(6) 8 points

(7) 1 point

For part marked by “a”: Anticorrosion wax shall be applied thoroughly on the back side of continuous welding portion.

Panel Replacement

• RH



BS-05813

(A) 120 mm (5.12 in)

(1) 5 points

(4) 6 points

(7) 1 point

(2) 1 point [220 mm (8.66 in)]

(5) 4 points

(3) Tailored line

(6) 8 points

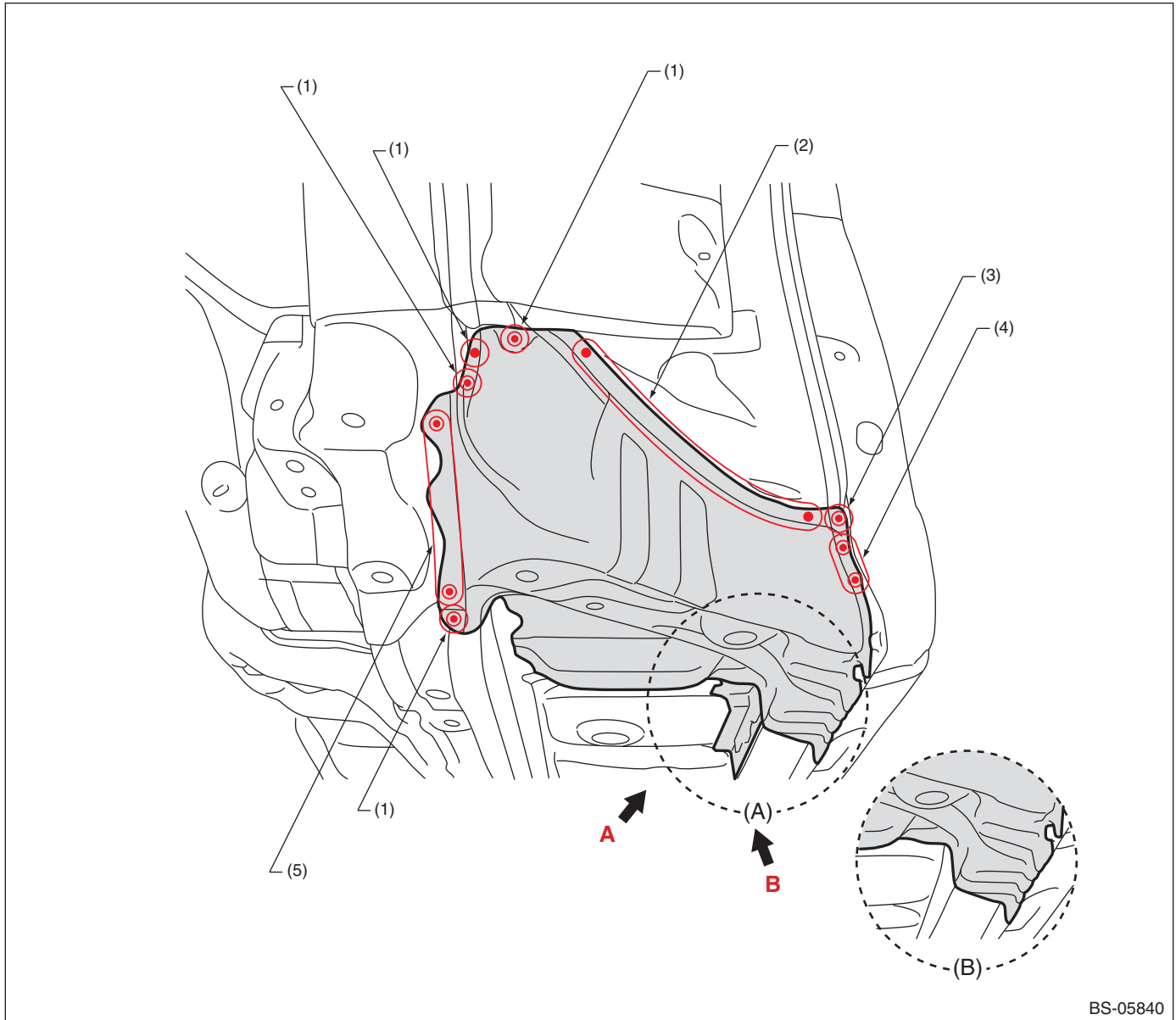
For part marked by “a”: Anticorrosion wax shall be applied thoroughly on the back side of continuous welding portion.

Panel Replacement

7-8. Toe Board Reinforcement (total replacement)

A: REMOVAL

• Overall view



BS-05840

(A) LH of the 13MY and subsequent

(B) RH of the 13MY and subsequent, and both sides of the model up to 12MY

(1) 1 point (inside · 1)

(3) 1 point (inside · 1, belt sander)

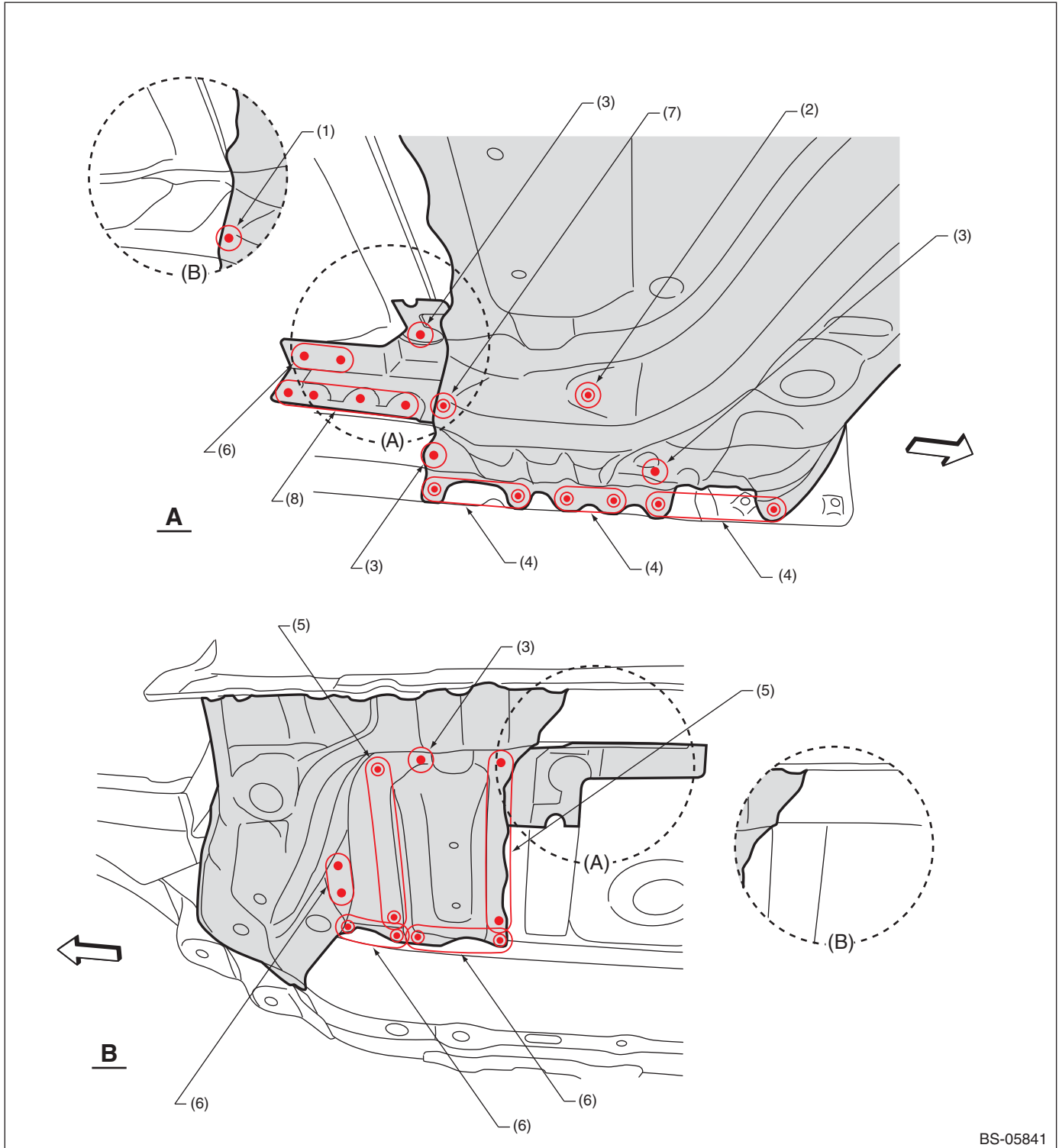
(5) 3 points (outside · 1)

(2) 6 points (outside · 1)

(4) 2 points (inside · 1, belt sander)

Panel Replacement

• Views



BS-05841

(A) LH of the 13MY and subsequent

(B) RH of the 13MY and subsequent, and both sides of the model up to 12MY

(1) 1 point (inside · 1)

(2) 1 point (inside · 1, belt sander)

(3) 1 point (bottom · 1)

(4) 2 points (inside · 1)

(5) 5 points (bottom · 1)

(6) 2 points (bottom · 1)

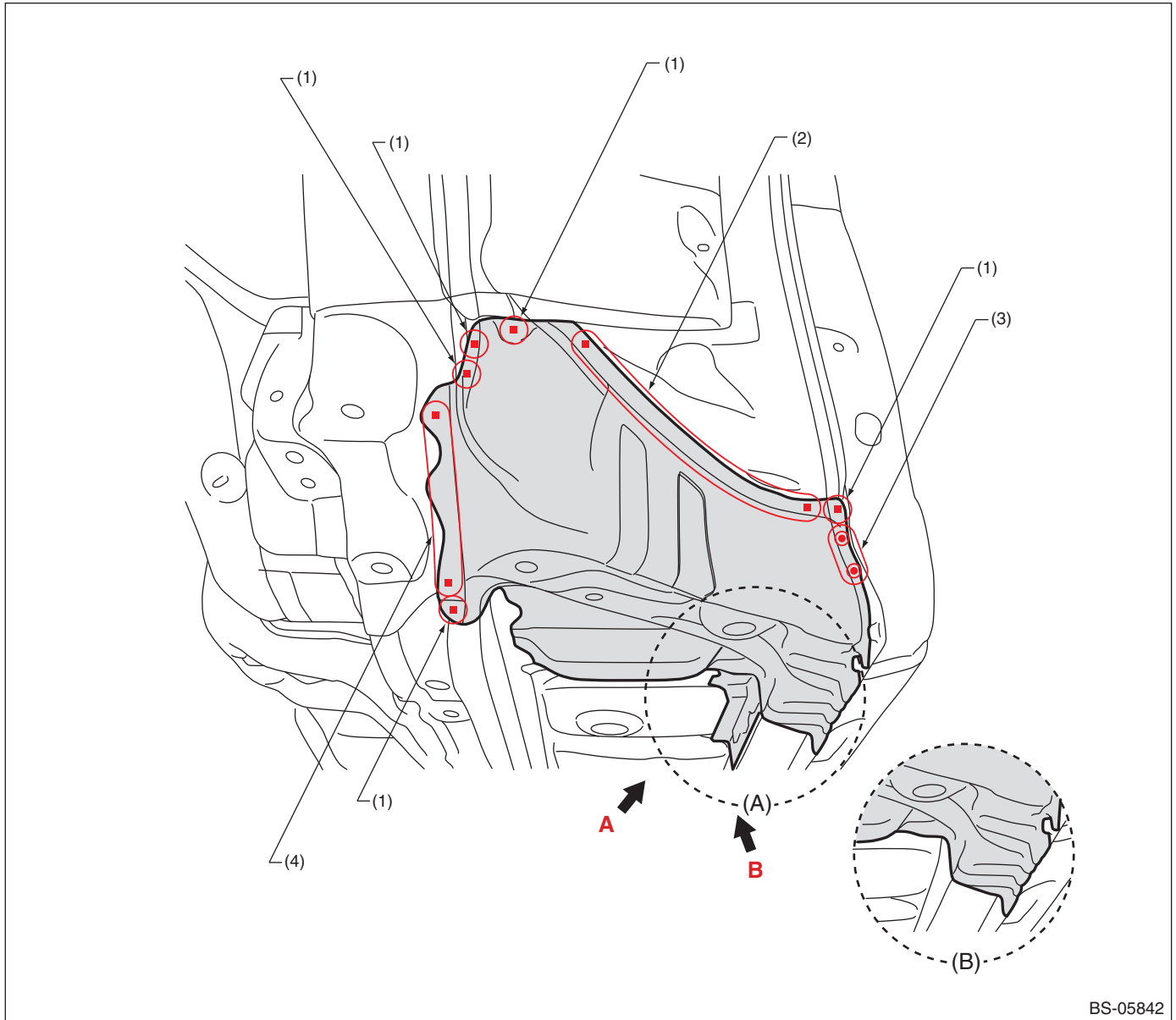
(7) 1 point (inside · 2)

(8) 4 points (inside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



(A) LH of the 13MY and subsequent

(B) RH of the 13MY and subsequent, and both sides of the model up to 12MY

(1) 1 point (service)

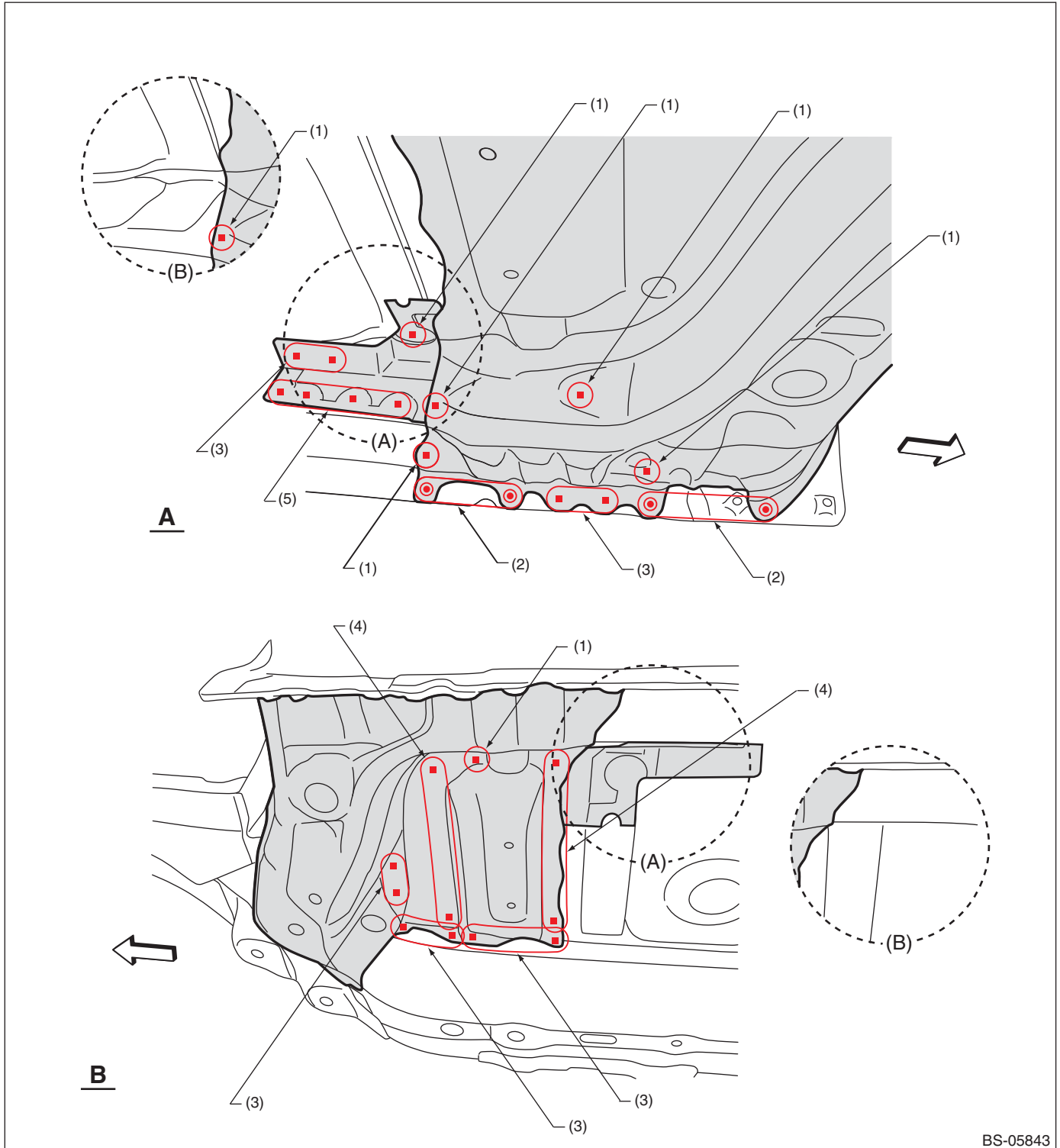
(3) 2 points

(4) 3 points (service)

(2) 6 points (service)

Panel Replacement

• Views



BS-05843

(A) LH of the 13MY and subsequent

(B) RH of the 13MY and subsequent, and both sides of the model up to 12MY

(1) 1 point (service)

(3) 2 points (service)

(5) 4 points (service)

(2) 2 points

(4) 5 points (service)

Panel Replacement

7-9. Front Pillar (partial replacement)

A: REMOVAL

• Overall view



(A) 65 mm (2.56 in)

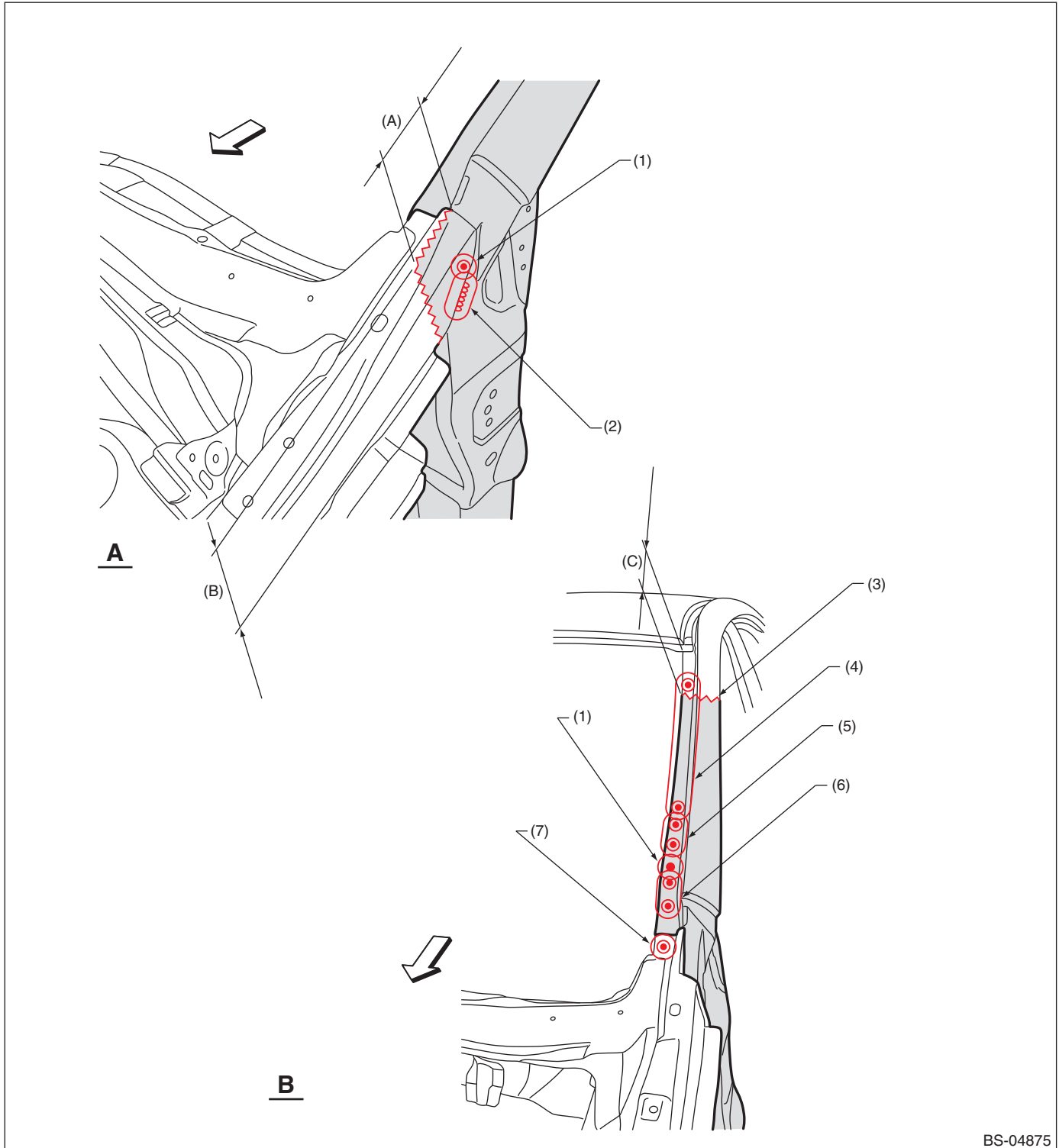
- (1) 1 point (outside · 1)
- (2) 2 points (outside · 1)
- (3) 4 points (outside · 1)

- (4) 8 points (outside · 1)
- (5) Rough cutting
- (6) 7 points (outside · 1)

- (7) 3 points (outside · 1)
- (8) 1 point (outside · 1, inside · 1)

Panel Replacement

• Views 1



BS-04875

(A) 60 mm (2.36 in)

(B) 80 mm (3.15 in)

(C) 100 mm (3.94 in)

(1) 1 point (outside · 1)

(4) 9 points (outside · 1)

(7) 1 point (outside · 2)

(2) 1 point (outside · 1, belt sander)

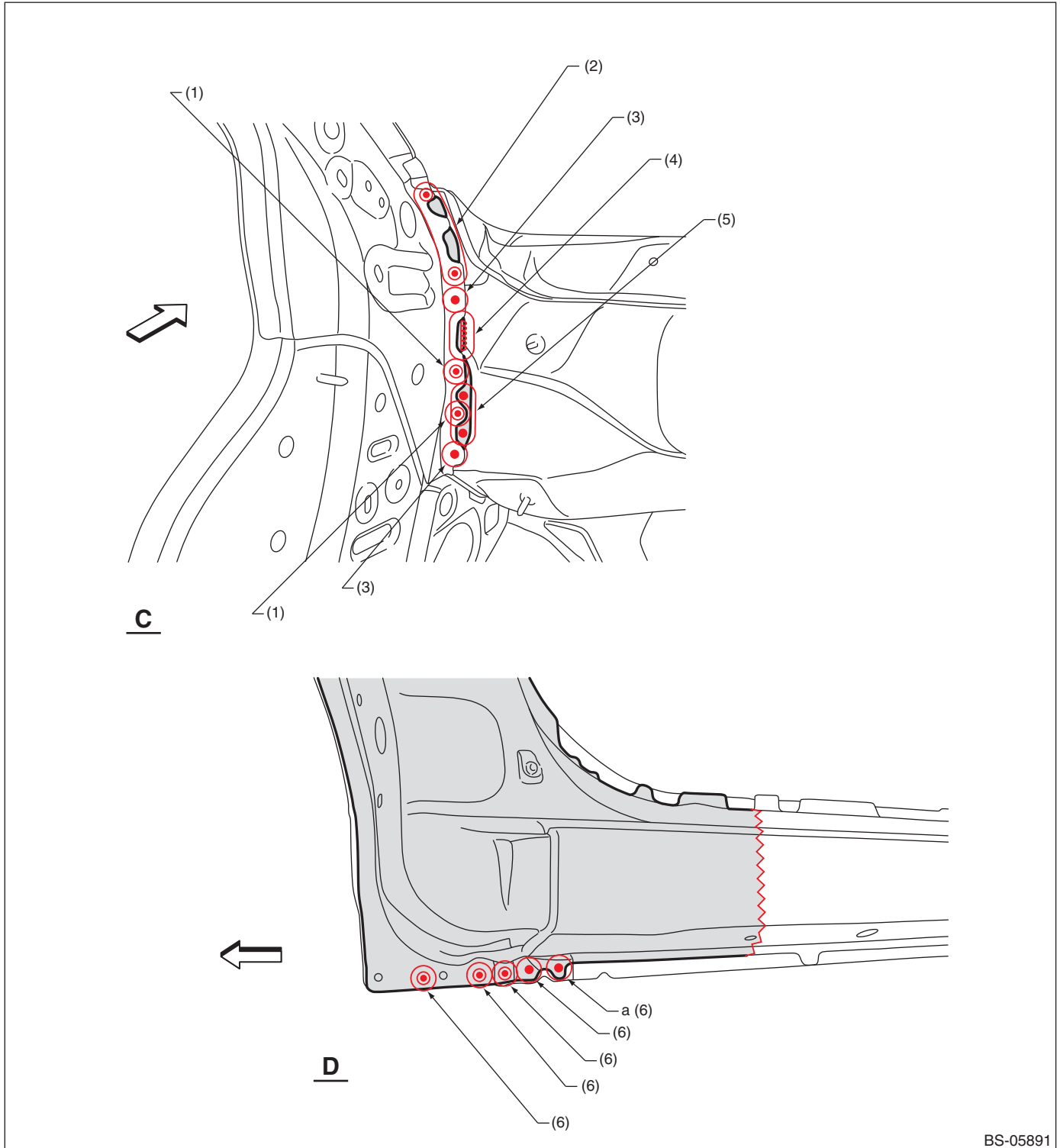
(5) 2 points (outside · 1)

(3) Rough cutting

(6) 3 points (outside · 1)

Panel Replacement

• Views 2



BS-05891

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

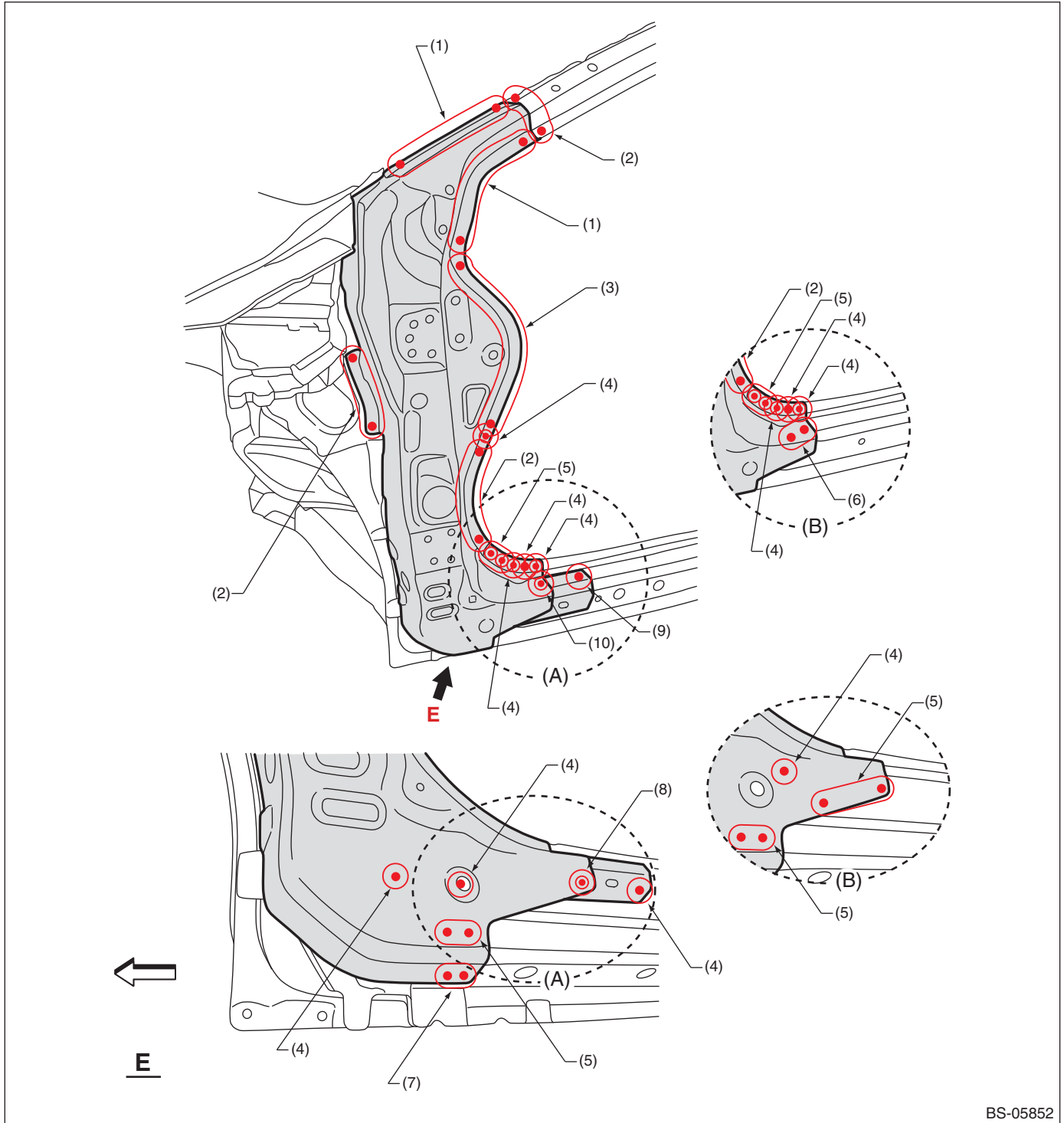
(3) 1 point (inside · 1)
(4) 1 point (inside · 1, belt sander)

(5) 2 points (inside · 1)
(6) 1 points (outside · 1)

If the "a" part doesn't have a flange shape on the panel's outer side, removing will not be necessary.

Panel Replacement

• Views 3



BS-05852

(A) LH of the 14MY

(B) RH of the 14MY and both side of the model up to the 13MY

- (1) 5 points (outside · 1)
- (2) 4 points (outside · 1)
- (3) 8 points (outside · 1)
- (4) 1 point (outside · 1)

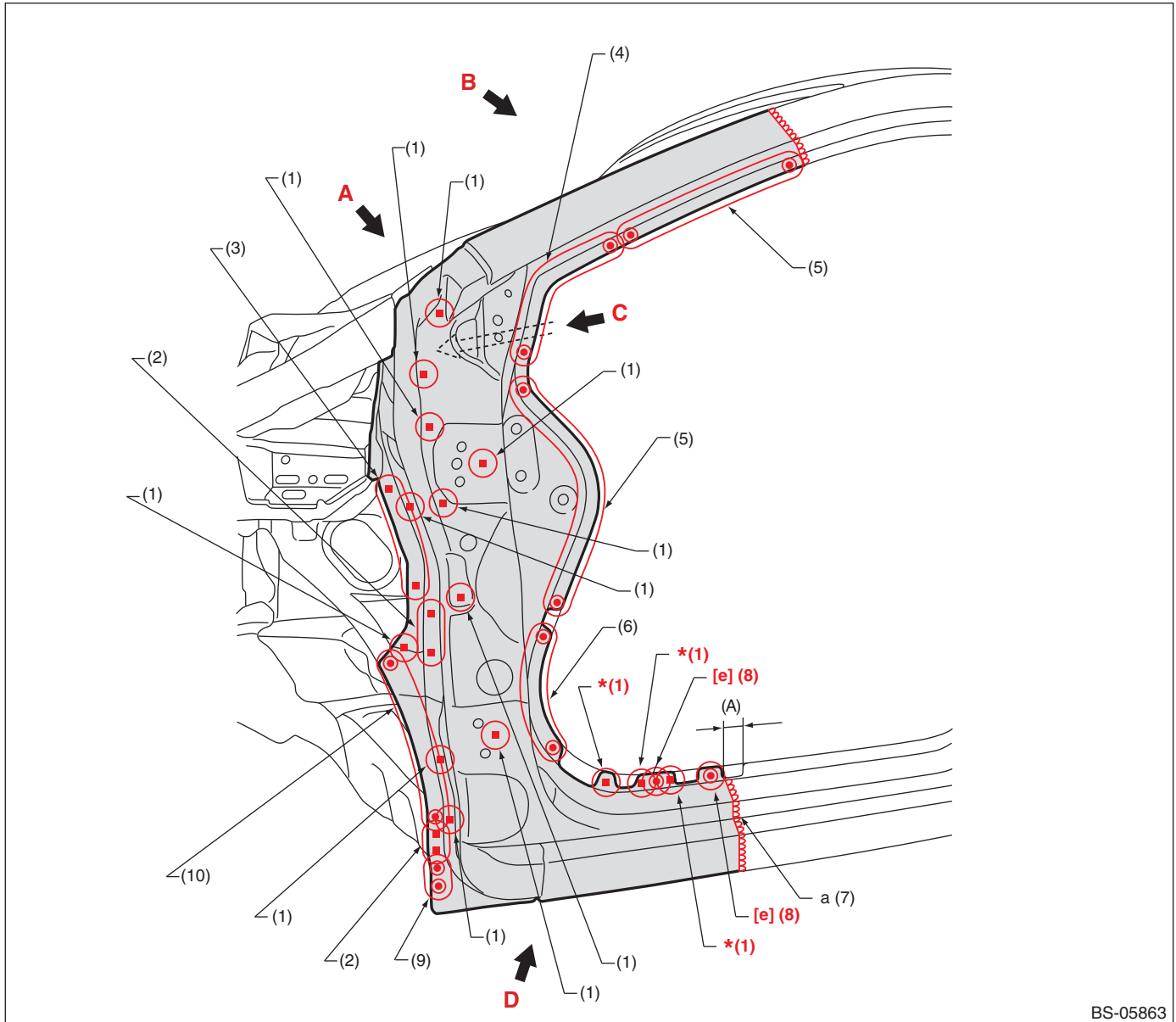
- (5) 2 points (outside · 1)
- (6) 2 points (top · 1)
- (7) 2 points (bottom · 1)
- (8) 1 point (outside · 1)

- (9) 1 point (top · 1)
- (10) 1 points (top · 2)

Panel Replacement

B: INSTALLATION

• Overall view



BS-05863

(A) 25 mm (0.98 in)

(1) 1 point (service)	(5) 8 points	(9) 2 points
(2) 2 points (service)	(6) 5 points	(10) 7 points
(3) 4 points (service)	(7) 1 point [280 mm (11.02 in)]	
(4) 6 points	(8) 1 point	

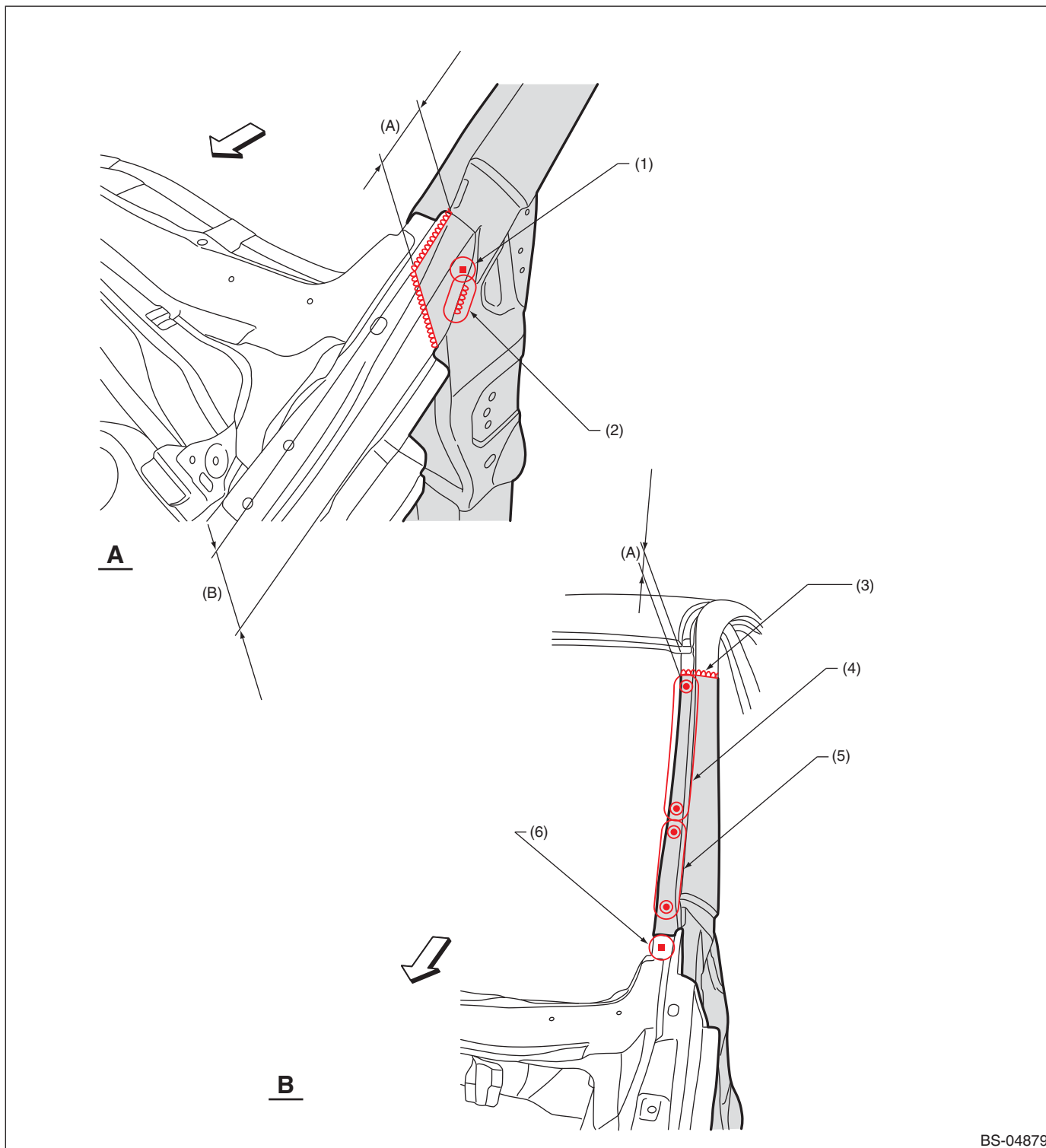
For part marked by “a”: Anticorrosion wax shall be applied thoroughly on the back side of continuous welding portion.

[e] Spot welding conditions	Compression: 3.5 kN, Current: 7.5 kA, Welding time: 16 cyc
-----------------------------	--

*: For 980MPa class High-strength tensile steel plug welding, refer to the conditions reported in (BS-15).

Panel Replacement

• Views 1



BS-04879

(A) 60 mm (2.36 in)

(B) 80 mm (3.15 in)

(1) 1 point

(3) 1 point [175 mm (6.89 in)]

(5) 5 points

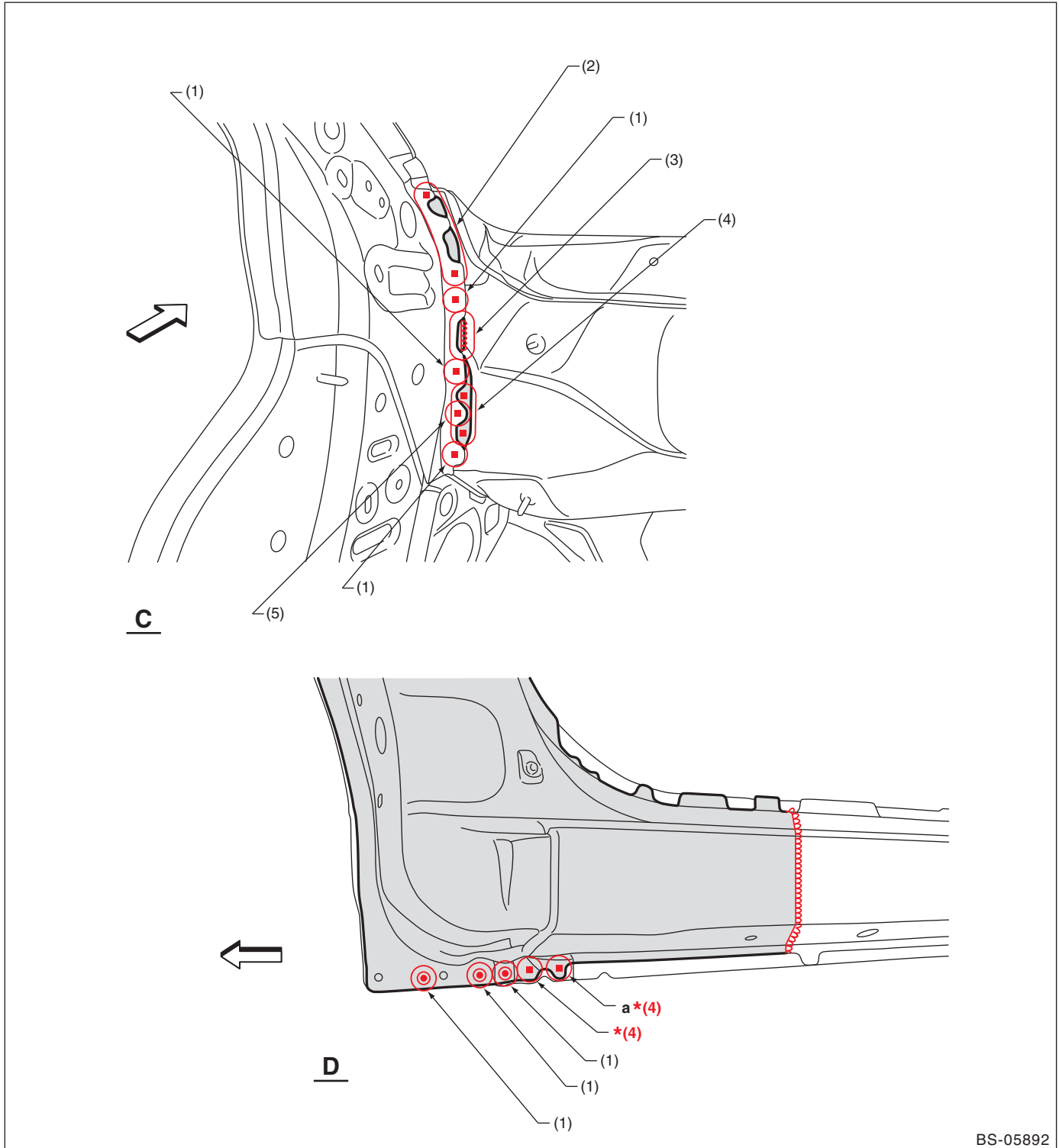
(2) 1 point [30 mm (1.18 in)]

(4) 9 points

(6) 1 point (service - matching)

Panel Replacement

• Views 2



BS-05892

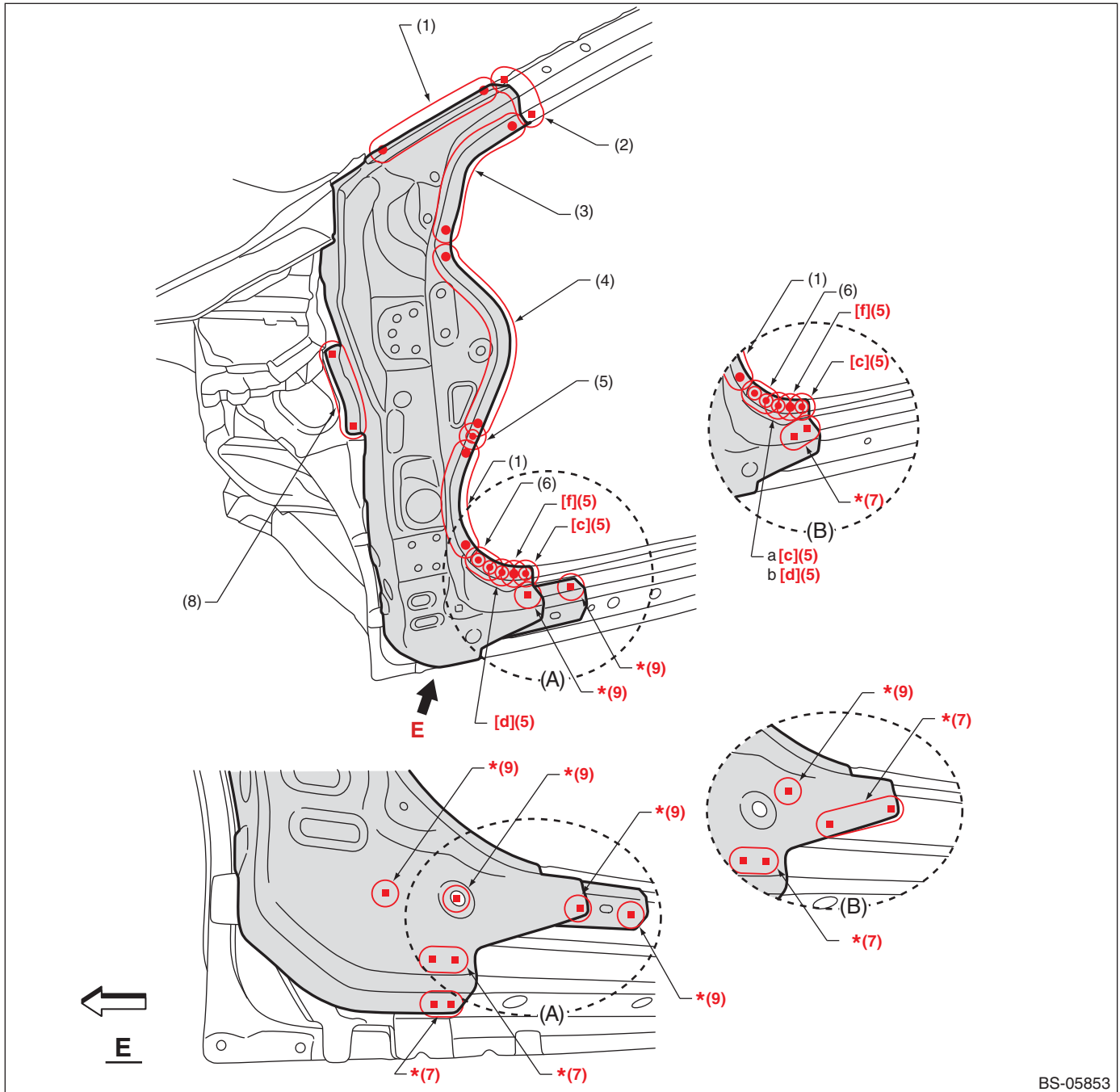
- | | | |
|--------------|-------------------------------|----------------------------------|
| (1) 1 point | (3) 1 point [15 mm (0.59 in)] | (5) 1 point (service - matching) |
| (2) 3 points | (4) 1 points (service) | |

If the "a" part doesn't have a flange shape on the panel's outer side, removing will not be necessary.

*: For 980MPa class High-strength tensile steel plug welding, refer to the conditions reported in (BS-15).

Panel Replacement

• Views 3



BS-05853

(A) Left side of 14MY

(B) Right side of 14MY, and Both sides of upto 13MY

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

- (4) 8 points
- (5) 1 point
- (6) 2 points

- (7) 2 points (service)
- (8) 4 points (service)
- (9) 1 point (service)

Part "a" applies to the 12MY and part "b" to the 13MY and subsequent model years.

[c] Spot welding conditions	Compression: 3.0 kN, Current: 6.5 kA, Welding time: 25 cyc
[d] Spot welding conditions	Compression: 3.5 kN, Current: 7.0 kA, Welding time: 25 cyc
[f] Spot welding conditions	Compression: 4.4 kN, Current: 8.0 kA, Welding time: 20 cyc

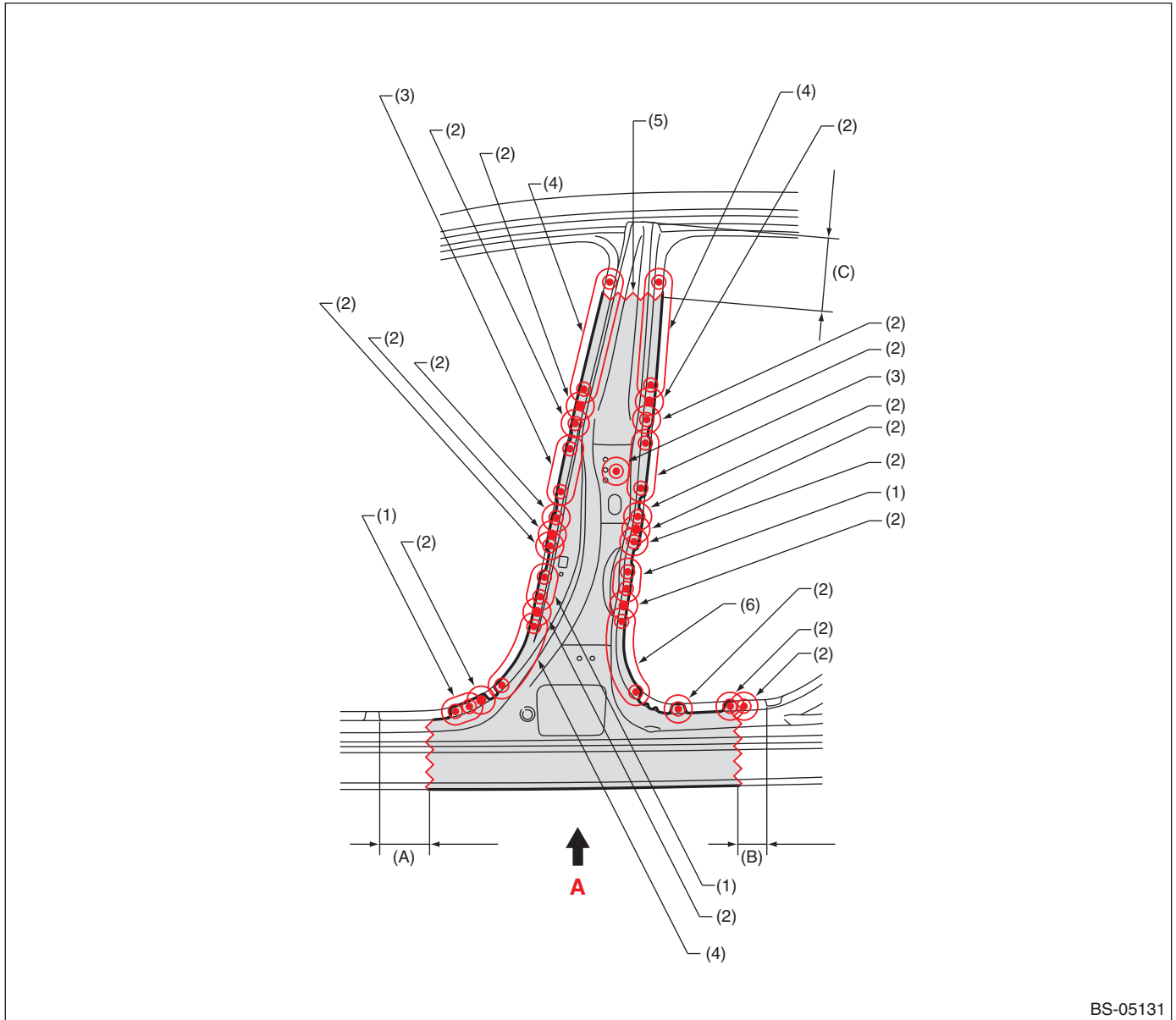
*: For 980MPa class High-strength tensile steel plug welding, refer to the conditions reported in (BS-15).

Panel Replacement

7-10. Center Pillar (partial replacement)

A: REMOVAL

• Overall view



BS-05131

(A) 100 mm (3.94 in)

(B) 80 mm (3.15 in)

(C) 140 mm (5.51 in)

(1) 2 points (outside · 1)

(3) 3 points (outside · 1)

(5) Rough cutting

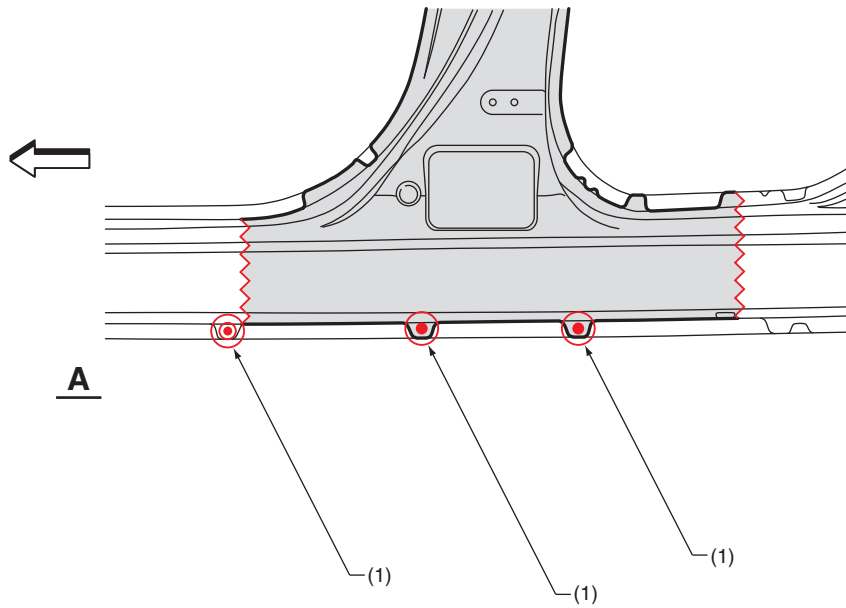
(2) 1 point (inside · 1)

(4) 7 points (outside · 1)

(6) 6 points (outside · 1)

Panel Replacement

• Views

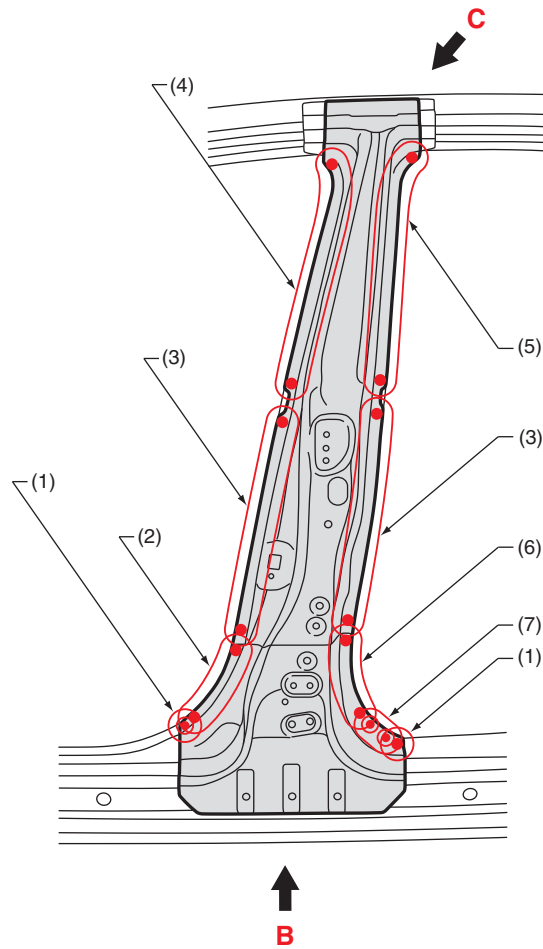


BS-05132

(1) 1 point (inside · 1)

Panel Replacement

• Overall view



BS-05133

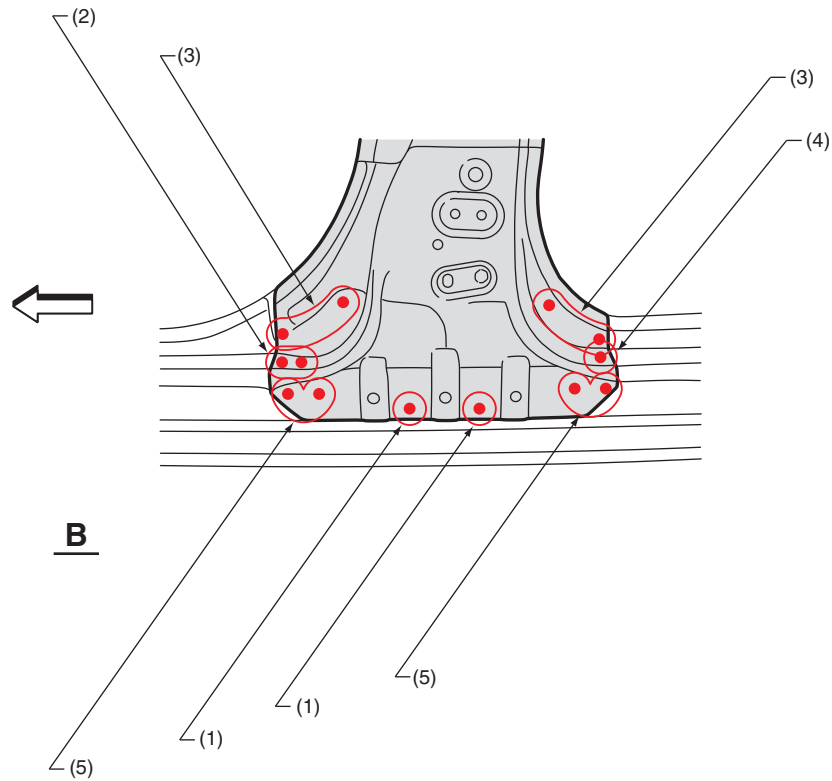
- (1) 1 point (outside · 1)
- (2) 6 points (outside · 1)
- (3) 8 points (outside · 1)

- (4) 10 points (outside · 1)
- (5) 11 point (outside · 1)
- (6) 5 points (outside · 1)

- (7) 2 points (outside · 1)

Panel Replacement

• Views 1



BS-05134

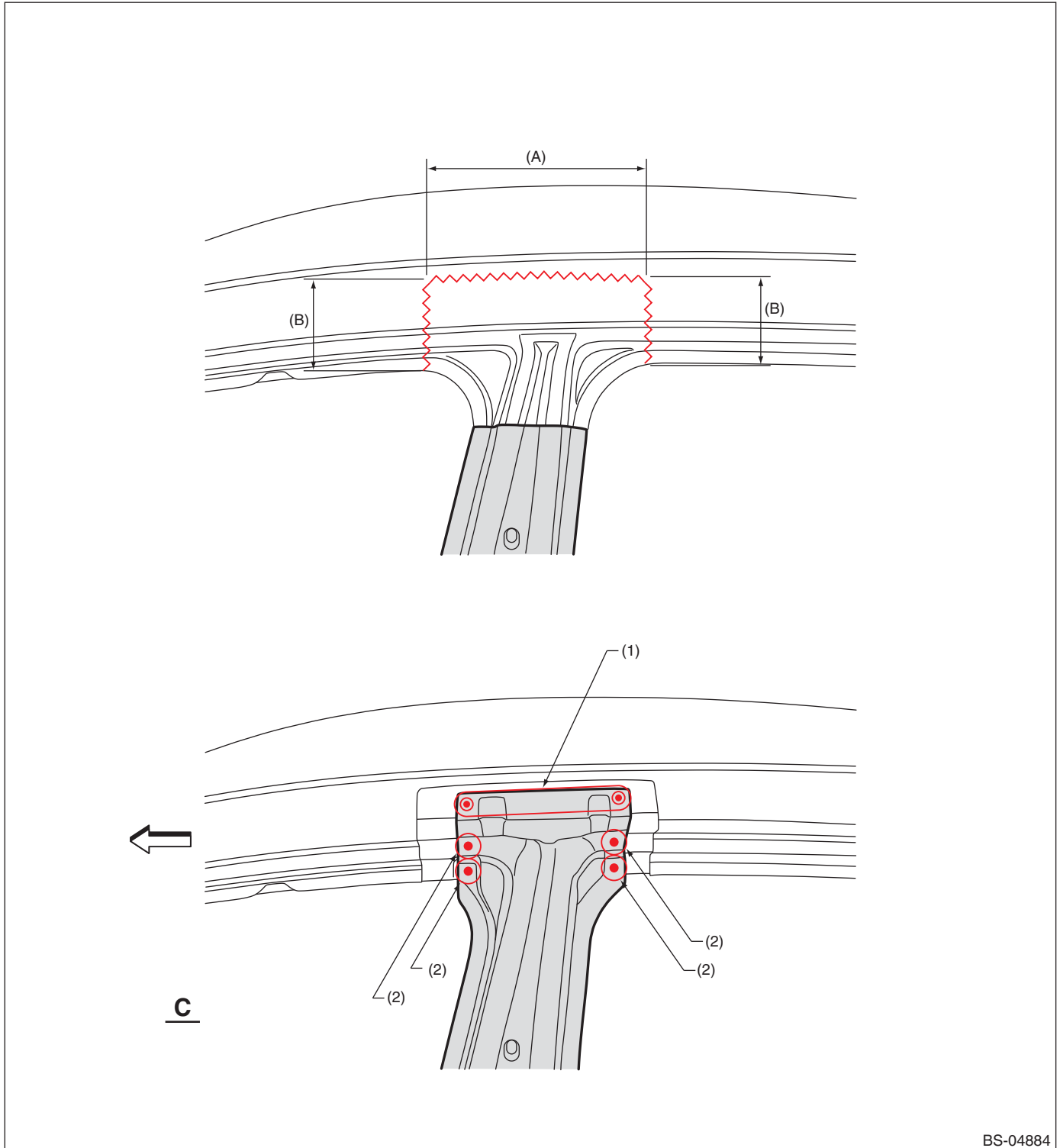
(1) 1 point (outside · 1)
(2) 2 points (top · 1)

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

(5) 3 points (outside · 1)

Panel Replacement

• Views 2



BS-04884

(A) 230 mm (9.06 in)

(B) 120 mm (4.72 in)

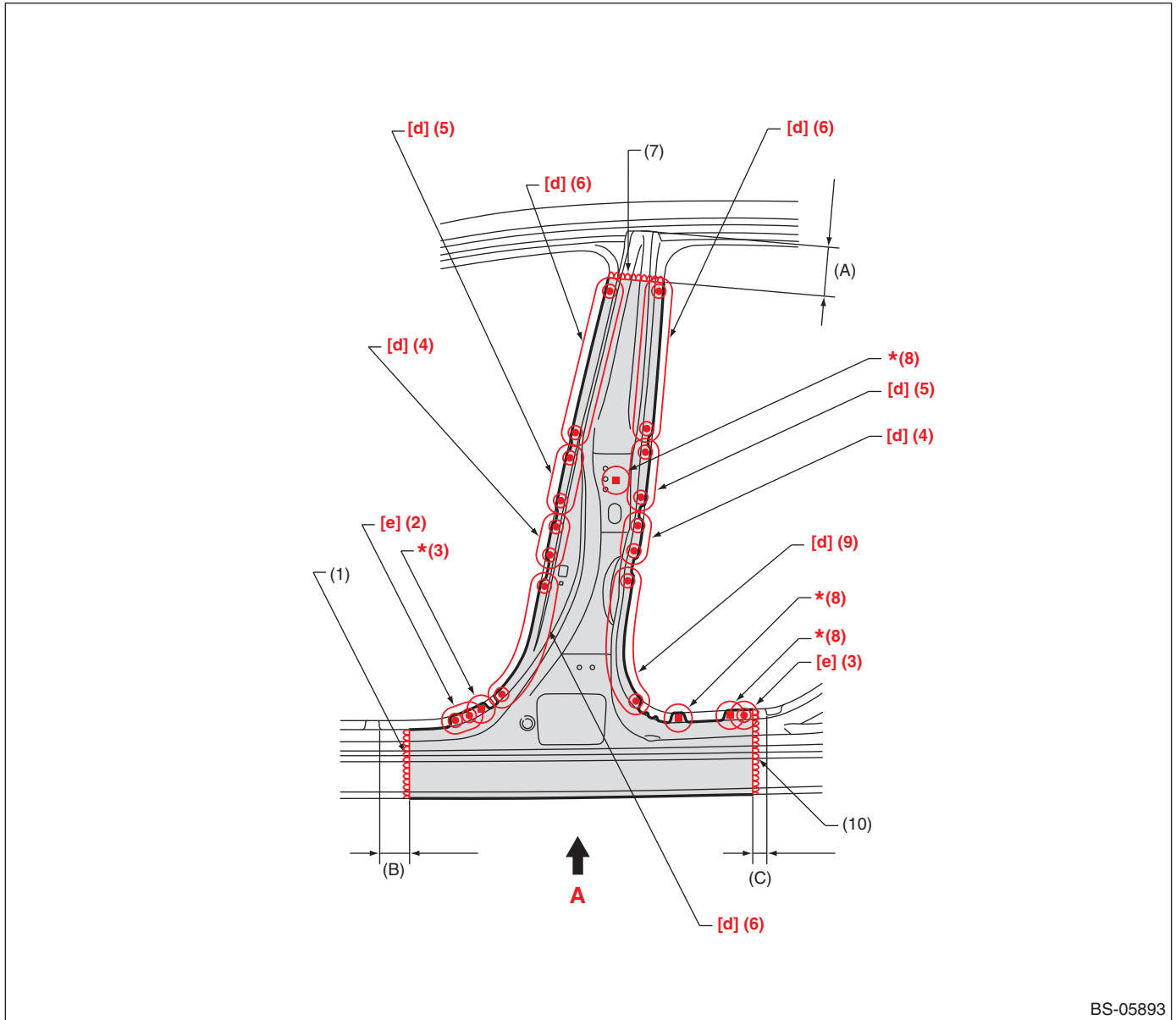
(1) 3 points (outside · 1)

(2) 1 point (outside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BS-05893

(A) 100 mm (3.94 in)

(B) 60 mm (2.36 in)

(C) 40 mm (1.57 in)

(1) 1 point [265 mm (10.43 in)]

(5) 4 points

(9) 9 points

(2) 2 points

(6) 10 points

(10) 1 point [290 mm (11.42 in)]

(3) 1 point

(7) 1 point [160 mm (6.3 in)]

(4) 3 points

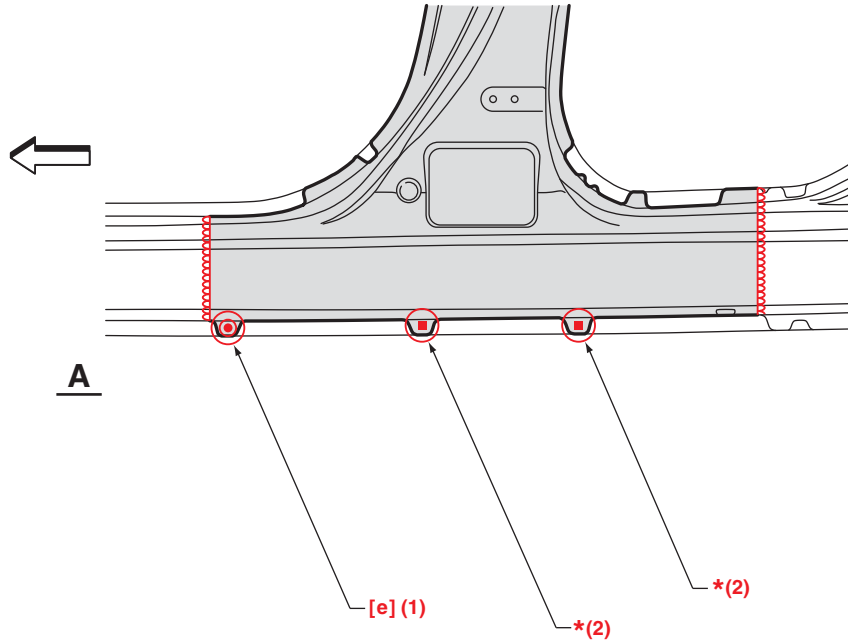
(8) 1 point (service)

[d] Spot welding conditions	Compression: 3.5 kN, Current: 7.0 kA, Welding time: 25 cyc
[e] Spot welding conditions	Compression: 3.5 kN, Current: 7.5 kA, Welding time: 16 cyc

*: For 980MPa class High-strength tensile steel plug welding, refer to the conditions reported in (BS-15).

Panel Replacement

• Views



BS-05894

(1) 1 point

(2) 1 point (service)

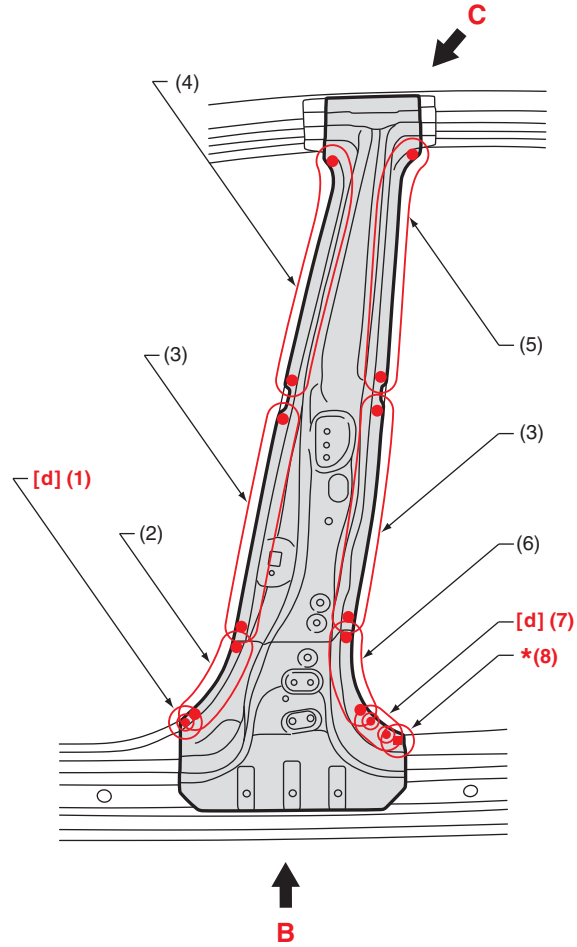
[e] Spot welding conditions

Compression: 3.5 kN, Current: 7.5 kA, Welding time: 16 cyc

*: For 980MPa class High-strength tensile steel plug welding, refer to the conditions reported in (BS-15).

Panel Replacement

• Overall view



BS-05895

- (1) 1 point
- (2) 6 points
- (3) 11 points

- (4) 12 points
- (5) 13 points
- (6) 5 points

- (7) 2 points
- (8) 1 point (service)

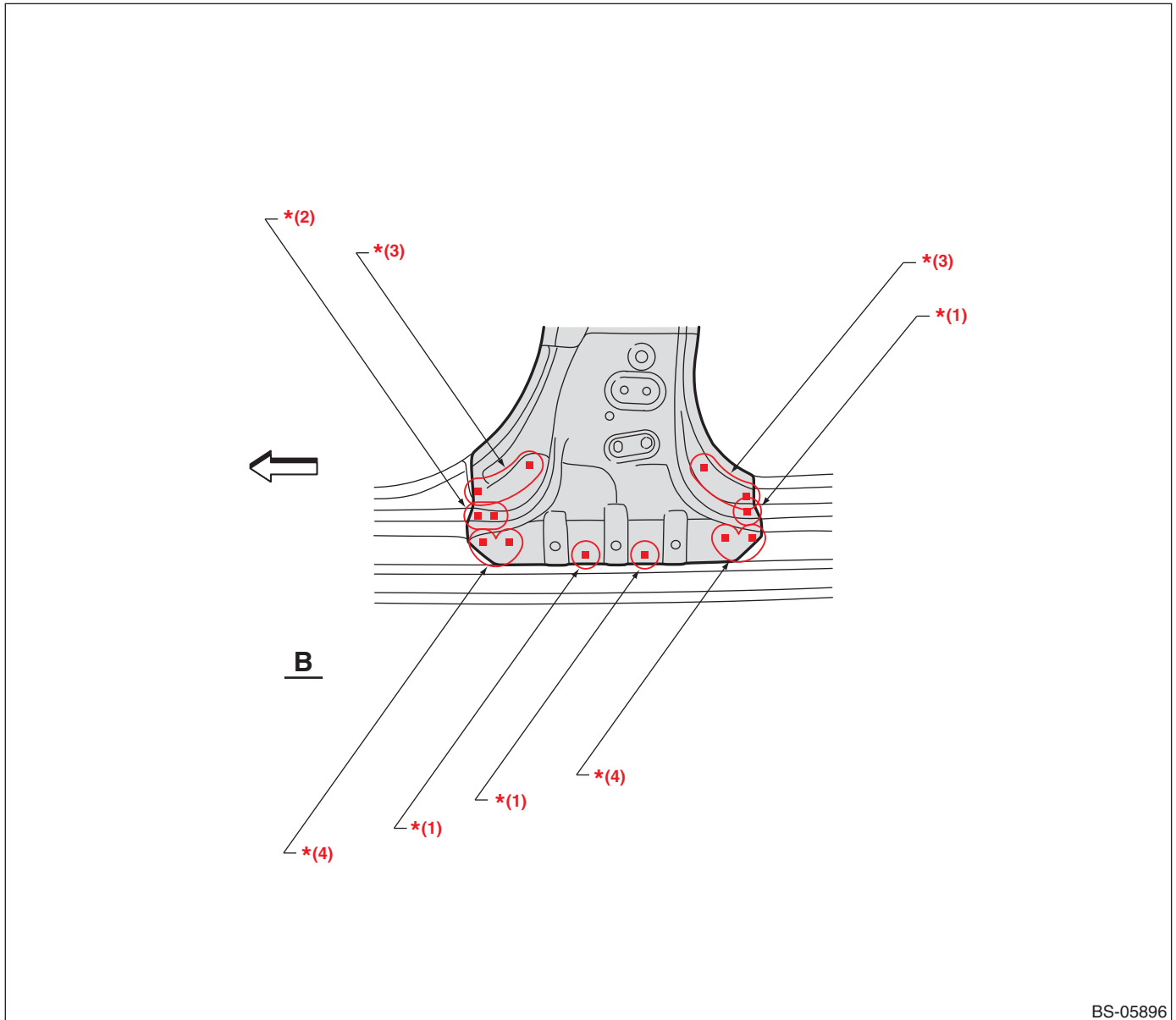
[d] Spot welding conditions

Compression: 3.5 kN, Current: 7.0 kA, Welding time: 25 cyc

*: For 980MPa class High-strength tensile steel plug welding, refer to the conditions reported in (BS-15).

Panel Replacement

• Views 1



BS-05896

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

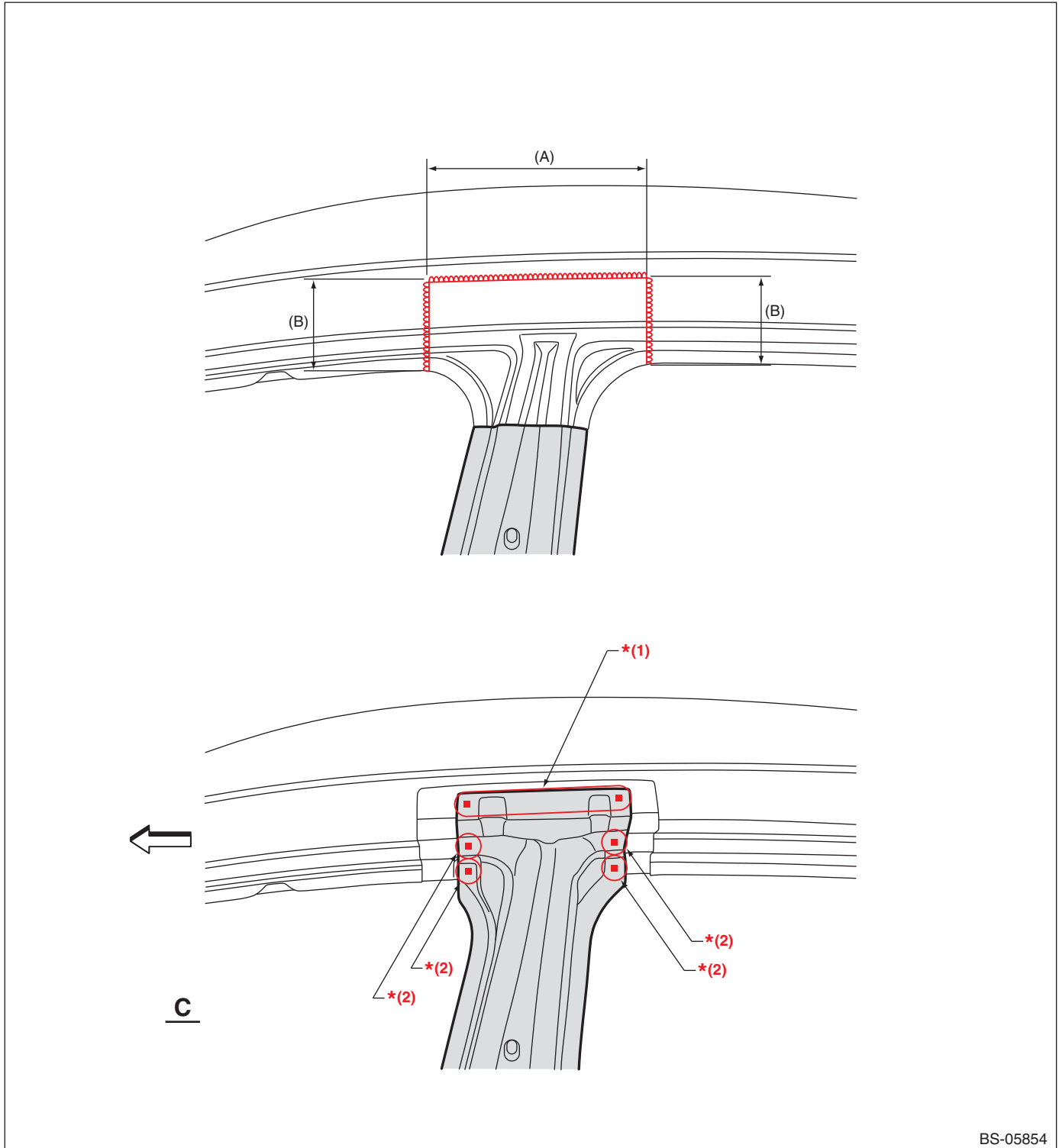
(3) 4 points (service)

(4) 3 points (service)

*: For 980MPa class High-strength tensile steel plug welding, refer to the conditions reported in (BS-15).

Panel Replacement

• Views 2



BS-05854

(A) 230 mm (9.06 in)

(B) 120 mm (4.72 in)

(1) 3 points (service)

(2) 1 point (service)

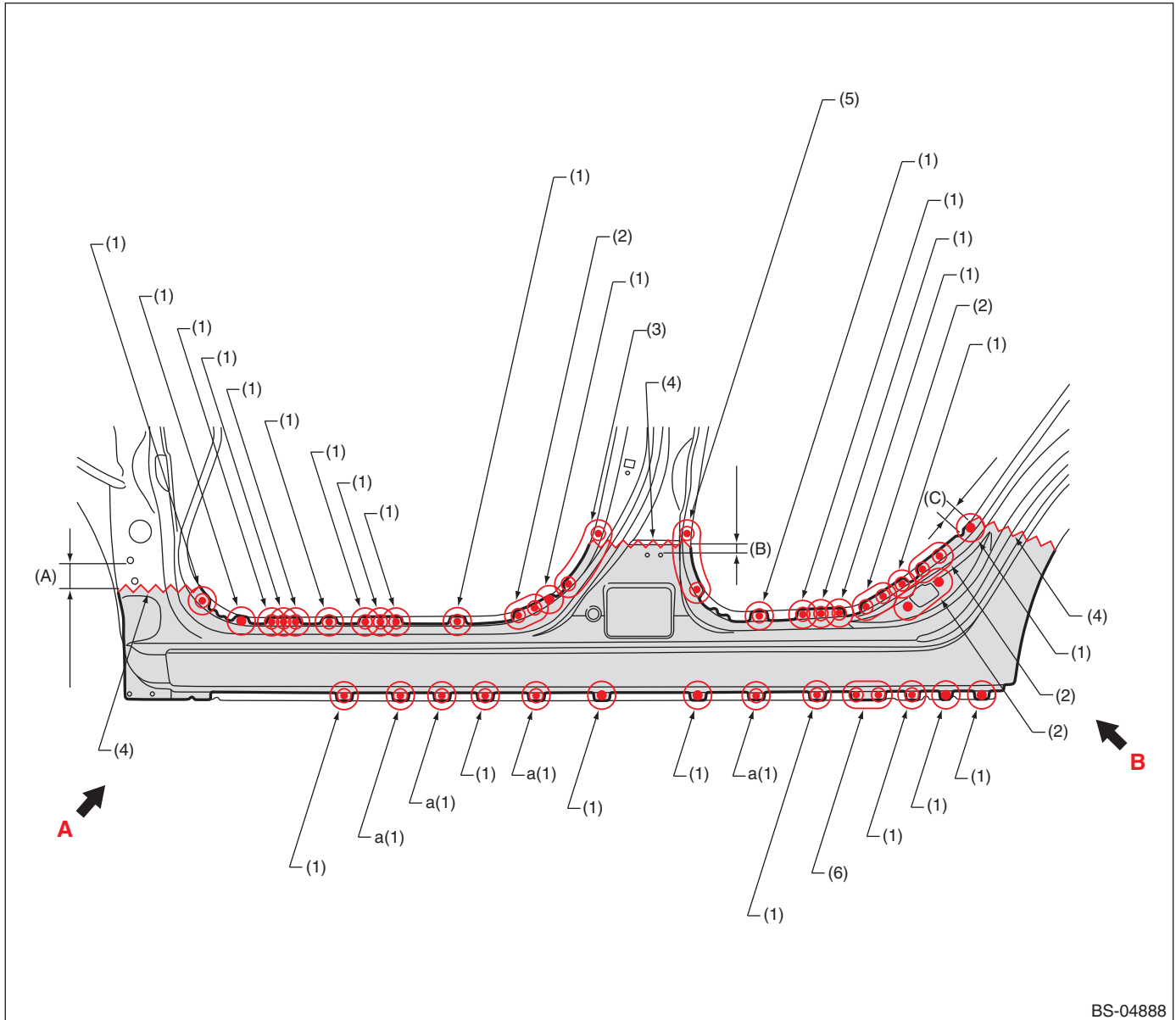
*: For 980MPa class High-strength tensile steel plug welding, refer to the conditions reported in (BS-15).

Panel Replacement

7-11. Side Sill (partial replacement)

A: REMOVAL

• Overall view



BS-04888

(A) 50 mm (1.97 in)

(B) 15 mm (0.59 in)

(C) 20 mm (0.79 in)

(1) 1 point (outside · 1)

(3) 5 points (outside · 1)

(5) 4 points (outside · 1)

(2) 2 points (outside · 1)

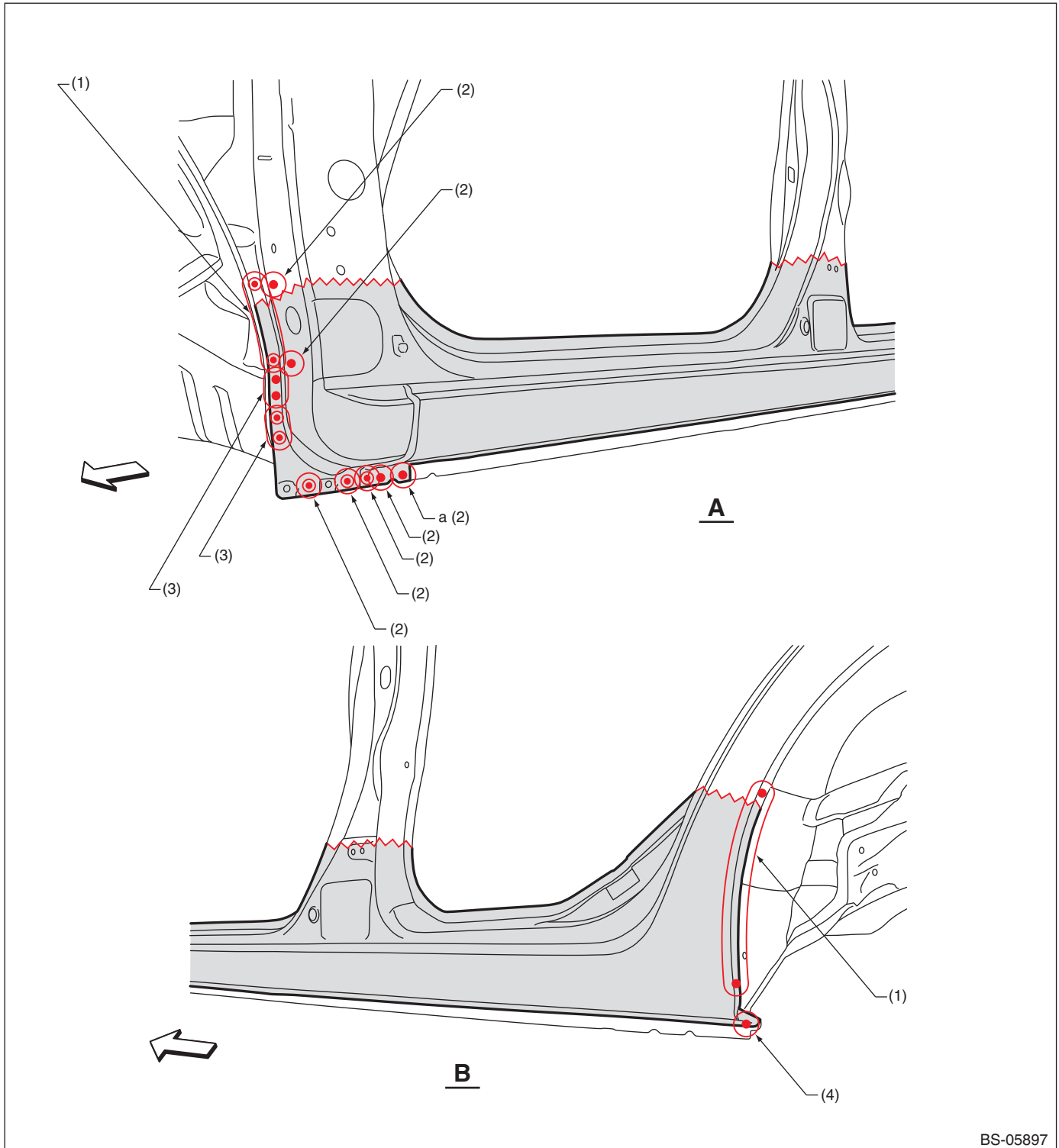
(4) Rough cutting

(6) 3 points (outside · 1)

If the "a" part doesn't have a flange shape on the panel's outer side, removing will not be necessary.

Panel Replacement

• Views



BS-05897

(1) 4 points (outside · 1)

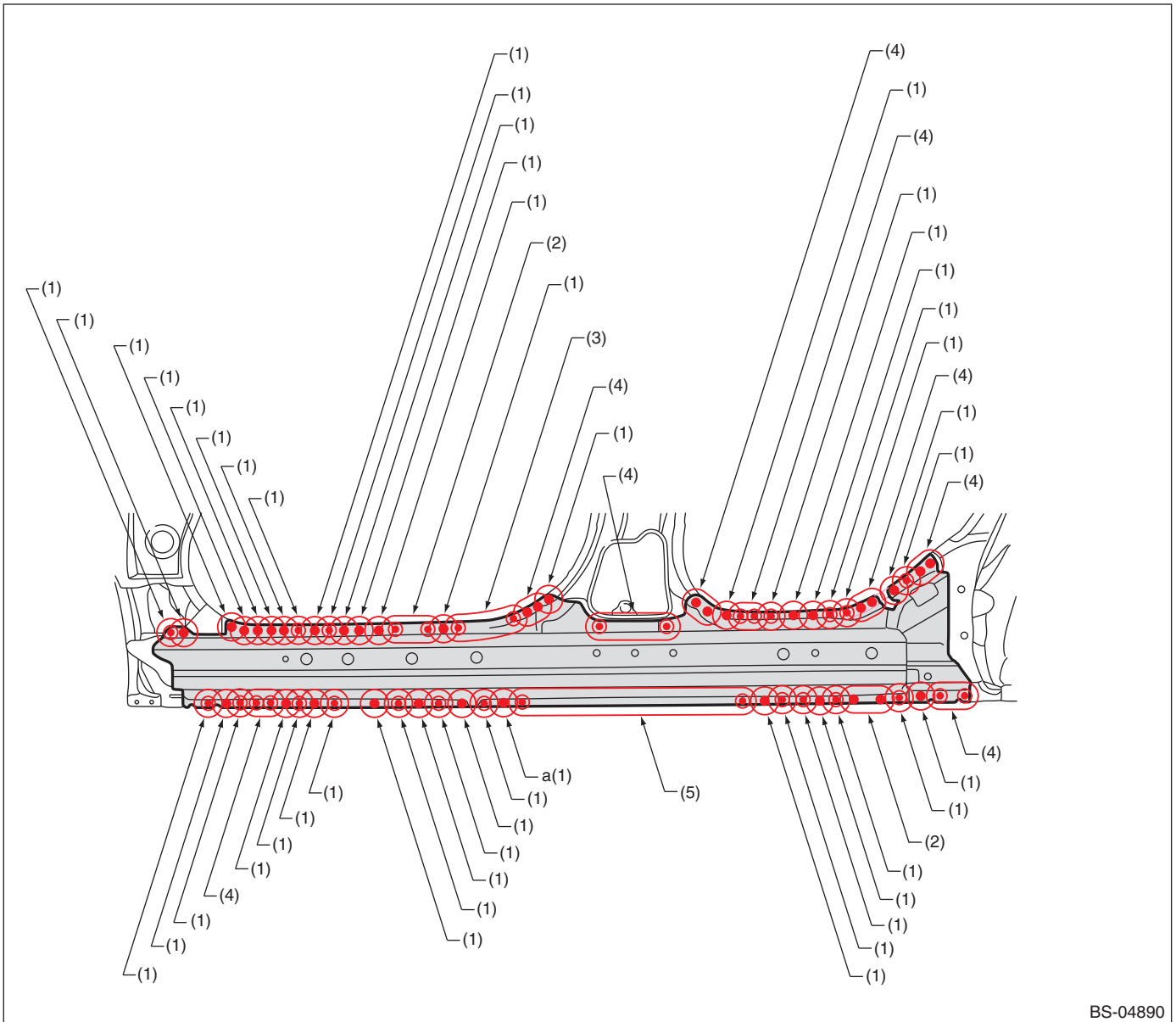
(3) 2 points (outside · 1)

(4) 1 point (bottom · 1)

(2) 1 point (outside · 1)

If the "a" part doesn't have a flange shape on the panel's outer side, removing will not be necessary.

Panel Replacement



BS-04890

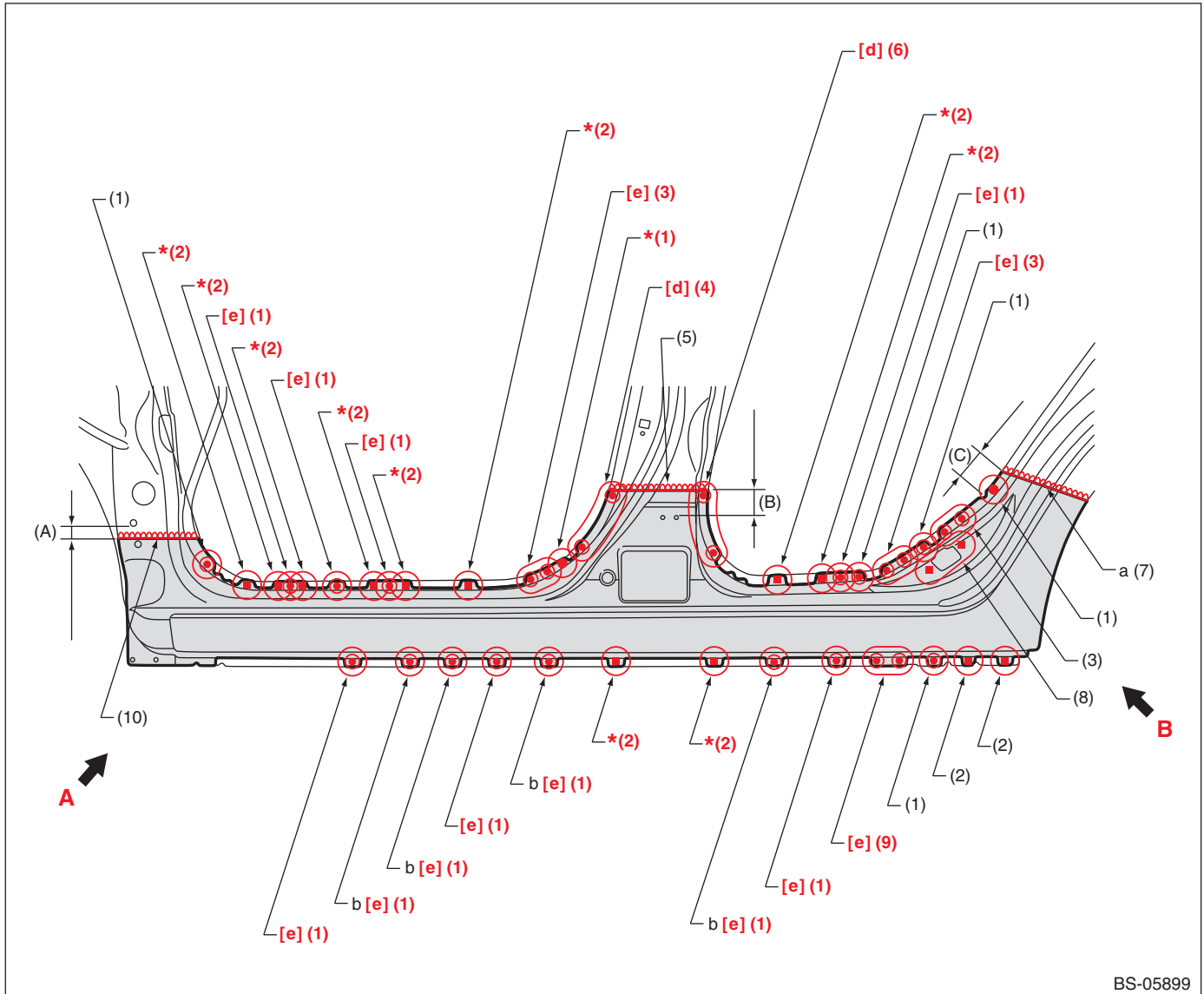
- | | | |
|----------------------------|----------------------------|----------------------------|
| (1) 1 point (outside · 1) | (3) 4 points (outside · 1) | (5) 9 points (outside · 1) |
| (2) 3 points (outside · 1) | (4) 2 points (outside · 1) | |

If the "a" part has a flange shape on the panel's outer side, removing will not be necessary.

Panel Replacement

B: INSTALLATION

• Overall view



BS-05899

(A) 20 mm (0.79 in)

(B) 35 mm (1.38 in)

(C) 50 mm (1.97 in)

(1) 1 point

(5) 1 point [300 mm (11.81 in)]

(9) 3 points

(2) 1 point (service)

(6) 4 points

(10) 1 point [280 mm (11.02 in)]

(3) 2 points

(7) 1 point [270 mm (10.63 in)]

(4) 5 points

(8) 2 points (service)

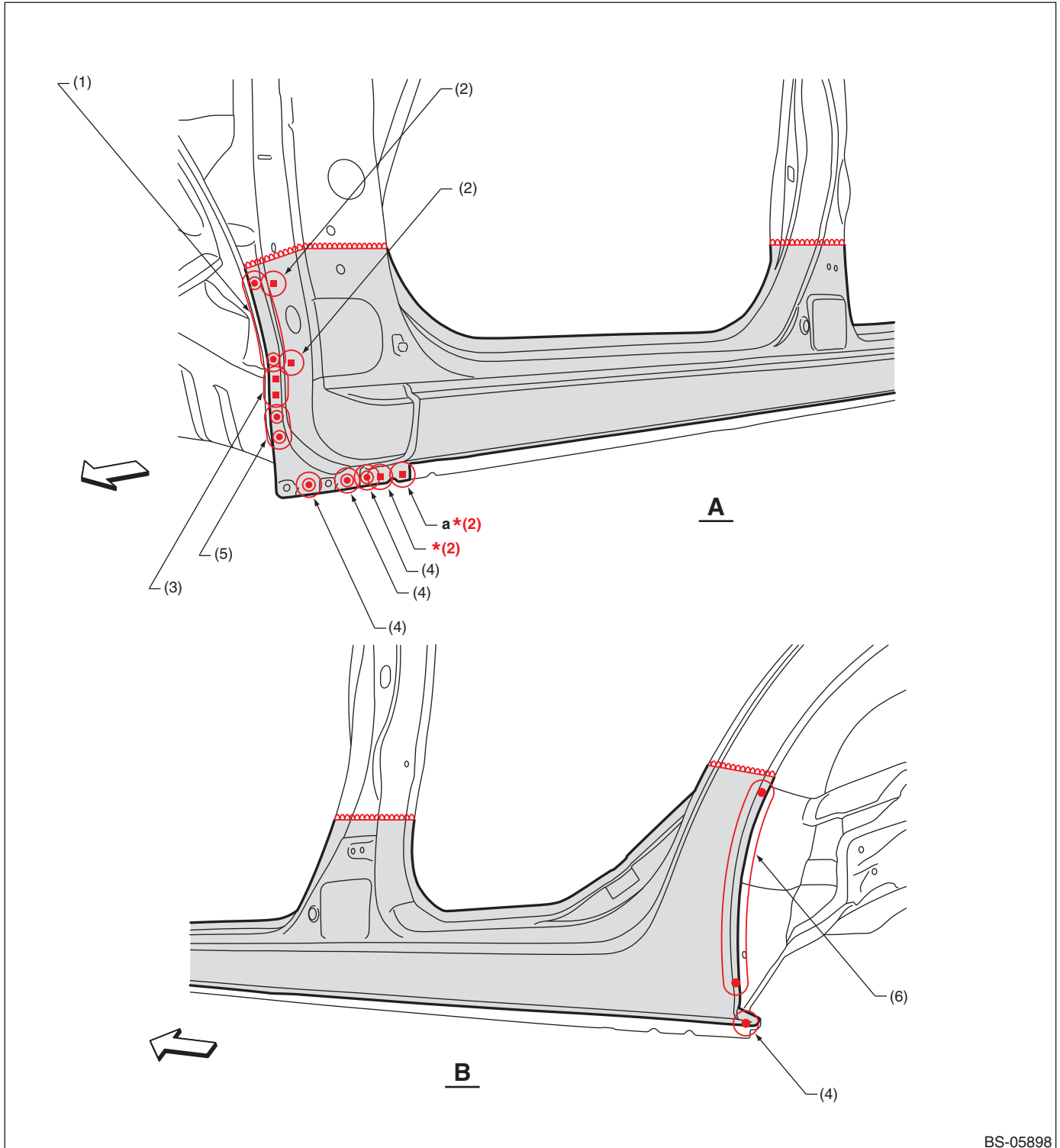
- For part marked by "a": Anticorrosion wax shall be applied thoroughly on the back side of continuous welding portion.
- If the "b" part has a flange shape on the panel's outer side, removing will not be necessary.

[d] Spot welding conditions	Compression: 3.5 kN, Current: 7.0 kA, Welding time: 25 cyc
[e] Spot welding conditions	Compression: 3.5 kN, Current: 7.5 kA, Welding time: 16 cyc

*: For 980MPa class High-strength tensile steel plug welding, refer to the conditions reported in (BS-15).

Panel Replacement

• Views



BS-05898

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

If the "a" part has a flange shape on the panel's outer side, removing will not be necessary.

*: For 980MPa class High-strength tensile steel plug welding, refer to the conditions reported in (BS-15).

This technical drawing illustrates a cross-section of a vehicle chassis, highlighting various components and their identification codes. The drawing includes a central longitudinal beam, side rails, and various mounting points. Red circles and arrows are used to identify specific parts, with labels such as [d] (1), [e] (1), [c] (1), [f] (1), [d] (2), [e] (2), [c] (2), [d] (3), [e] (3), [c] (3), [d] (4), [e] (4), [c] (4), [d] (5), [e] (5), [c] (5), [d] (6), [e] (6), [c] (6), [d] (7), [e] (7), [c] (7), [d] (8), [e] (8), [c] (8), [d] (9), [e] (9), [c] (9), [d] (10), [e] (10), [c] (10), [d] (11), [e] (11), [c] (11), [d] (12), [e] (12), [c] (12), [d] (13), [e] (13), [c] (13), [d] (14), [e] (14), [c] (14), [d] (15), [e] (15), [c] (15), [d] (16), [e] (16), [c] (16), [d] (17), [e] (17), [c] (17), [d] (18), [e] (18), [c] (18), [d] (19), [e] (19), [c] (19), [d] (20), [e] (20), [c] (20), [d] (21), [e] (21), [c] (21), [d] (22), [e] (22), [c] (22), [d] (23), [e] (23), [c] (23), [d] (24), [e] (24), [c] (24), [d] (25), [e] (25), [c] (25), [d] (26), [e] (26), [c] (26), [d] (27), [e] (27), [c] (27), [d] (28), [e] (28), [c] (28), [d] (29), [e] (29), [c] (29), [d] (30), [e] (30), [c] (30), [d] (31), [e] (31), [c] (31), [d] (32), [e] (32), [c] (32), [d] (33), [e] (33), [c] (33), [d] (34), [e] (34), [c] (34), [d] (35), [e] (35), [c] (35), [d] (36), [e] (36), [c] (36), [d] (37), [e] (37), [c] (37), [d] (38), [e] (38), [c] (38), [d] (39), [e] (39), [c] (39), [d] (40), [e] (40), [c] (40), [d] (41), [e] (41), [c] (41), [d] (42), [e] (42), [c] (42), [d] (43), [e] (43), [c] (43), [d] (44), [e] (44), [c] (44), [d] (45), [e] (45), [c] (45), [d] (46), [e] (46), [c] (46), [d] (47), [e] (47), [c] (47), [d] (48), [e] (48), [c] (48), [d] (49), [e] (49), [c] (49), [d] (50), [e] (50), [c] (50), [d] (51), [e] (51), [c] (51), [d] (52), [e] (52), [c] (52), [d] (53), [e] (53), [c] (53), [d] (54), [e] (54), [c] (54), [d] (55), [e] (55), [c] (55), [d] (56), [e] (56), [c] (56), [d] (57), [e] (57), [c] (57), [d] (58), [e] (58), [c] (58), [d] (59), [e] (59), [c] (59), [d] (60), [e] (60), [c] (60), [d] (61), [e] (61), [c] (61), [d] (62), [e] (62), [c] (62), [d] (63), [e] (63), [c] (63), [d] (64), [e] (64), [c] (64), [d] (65), [e] (65), [c] (65), [d] (66), [e] (66), [c] (66), [d] (67), [e] (67), [c] (67), [d] (68), [e] (68), [c] (68), [d] (69), [e] (69), [c] (69), [d] (70), [e] (70), [c] (70), [d] (71), [e] (71), [c] (71), [d] (72), [e] (72), [c] (72), [d] (73), [e] (73), [c] (73), [d] (74), [e] (74), [c] (74), [d] (75), [e] (75), [c] (75), [d] (76), [e] (76), [c] (76), [d] (77), [e] (77), [c] (77), [d] (78), [e] (78), [c] (78), [d] (79), [e] (79), [c] (79), [d] (80), [e] (80), [c] (80), [d] (81), [e] (81), [c] (81), [d] (82), [e] (82), [c] (82), [d] (83), [e] (83), [c] (83), [d] (84), [e] (84), [c] (84), [d] (85), [e] (85), [c] (85), [d] (86), [e] (86), [c] (86), [d] (87), [e] (87), [c] (87), [d] (88), [e] (88), [c] (88), [d] (89), [e] (89), [c] (89), [d] (90), [e] (90), [c] (90), [d] (91), [e] (91), [c] (91), [d] (92), [e] (92), [c] (92), [d] (93), [e] (93), [c] (93), [d] (94), [e] (94), [c] (94), [d] (95), [e] (95), [c] (95), [d] (96), [e] (96), [c] (96), [d] (97), [e] (97), [c] (97), [d] (98), [e] (98), [c] (98), [d] (99), [e] (99), [c] (99), [d] (100), [e] (100), [c] (100), [d] (101), [e] (101), [c] (101), [d] (102), [e] (102), [c] (102), [d] (103), [e] (103), [c] (103), [d] (104), [e] (104), [c] (104), [d] (105), [e] (105), [c] (105), [d] (106), [e] (106), [c] (106), [d] (107), [e] (107), [c] (107), [d] (108), [e] (108), [c] (108), [d] (109), [e] (109), [c] (109), [d] (110), [e] (110), [c] (110), [d] (111), [e] (111), [c] (111), [d] (112), [e] (112), [c] (112), [d] (113), [e] (113), [c] (113), [d] (114), [e] (114), [c] (114), [d] (115), [e] (115), [c] (115), [d] (116), [e] (116), [c] (116), [d] (117), [e] (117), [c] (117), [d] (118), [e] (118), [c] (118), [d] (119), [e] (119), [c] (119), [d] (120), [e] (120), [c] (120), [d] (121), [e] (121), [c] (121), [d] (122), [e] (122), [c] (122), [d] (123), [e] (123), [c] (123), [d] (124), [e] (124), [c] (124), [d] (125), [e] (125), [c] (125), [d] (126), [e] (126), [c] (126), [d] (127), [e] (127), [c] (127), [d] (128), [e] (128), [c] (128), [d] (129), [e] (129), [c] (129), [d] (130), [e] (130), [c] (130), [d] (131), [e] (131), [c] (131), [d] (132), [e] (132), [c] (132), [d] (133), [e] (133), [c] (133), [d] (134), [e] (134), [c] (134), [d] (135), [e] (135), [c] (135), [d] (136), [e] (136), [c] (136), [d] (137), [e] (137), [c] (137), [d] (138), [e] (138), [c] (138), [d] (139), [e] (139), [c] (139), [d] (140), [e] (140), [c] (140), [d] (141), [e] (141), [c] (141), [d] (142), [e] (142), [c] (142), [d] (143), [e] (143), [c] (143), [d] (144), [e] (144), [c] (144), [d] (145), [e] (145), [c] (145), [d] (146), [e] (146), [c] (146), [d] (147), [e] (147), [c] (147), [d] (148), [e] (148), [c] (148), [d] (149), [e] (149), [c] (149), [d] (150), [e] (150), [c] (150), [d] (151), [e] (151), [c] (151), [d] (152), [e] (152), [c] (152), [d] (153), [e] (153), [c] (153), [d] (154), [e] (154), [c] (154), [d] (155), [e] (155), [c] (155), [d] (156), [e] (156), [c] (156), [d] (157), [e] (157), [c] (157), [d] (158), [e] (158), [c] (158), [d] (159), [e] (159), [c] (159), [d] (160), [e] (160), [c] (160), [d] (161), [e] (161), [c] (161), [d] (162), [e] (162), [c] (162), [d] (163), [e] (163), [c] (163), [d] (164), [e] (164), [c] (164), [d] (165), [e] (165), [c] (165), [d] (166), [e] (166), [c] (166), [d] (167), [e] (167), [c] (167), [d] (168), [e] (168), [c] (168), [d] (169), [e] (169), [c] (169), [d] (170), [e] (170), [c] (170), [d] (171), [e] (171), [c] (171), [d] (172), [e] (172), [c] (172), [d] (173), [e] (173), [c] (173), [d] (174), [e] (174), [c] (174), [d] (175), [e] (175), [c] (175), [d] (176), [e] (176), [c] (176), [d] (177), [e] (177), [c] (177), [d] (178), [e] (178), [c] (178), [d] (179), [e] (179), [c] (179), [d] (180), [e] (180), [c] (180), [d] (181), [e] (181), [c] (1

(1) 1 point	(3) 3 points	(5) 2 points
(2) 1 point (service)	(4) 4 points	(6) 9 points

- | | |
|-----------------------------|--|
| [b] Spot welding conditions | Compression: 4.0 kN, Current: 6.5 kA, Welding time: 15 cyc |
| [c] Spot welding conditions | Compression: 3.0 kN, Current: 6.5 kA, Welding time: 25 cyc |
| [d] Spot welding conditions | Compression: 3.5 kN, Current: 7.0 kA, Welding time: 25 cyc |
| [e] Spot welding conditions | Compression: 3.5 kN, Current: 7.5 kA, Welding time: 16 cyc |
| [f] Spot welding conditions | Compression: 4.4 kN, Current: 8.0 kA, Welding time: 20 cyc |

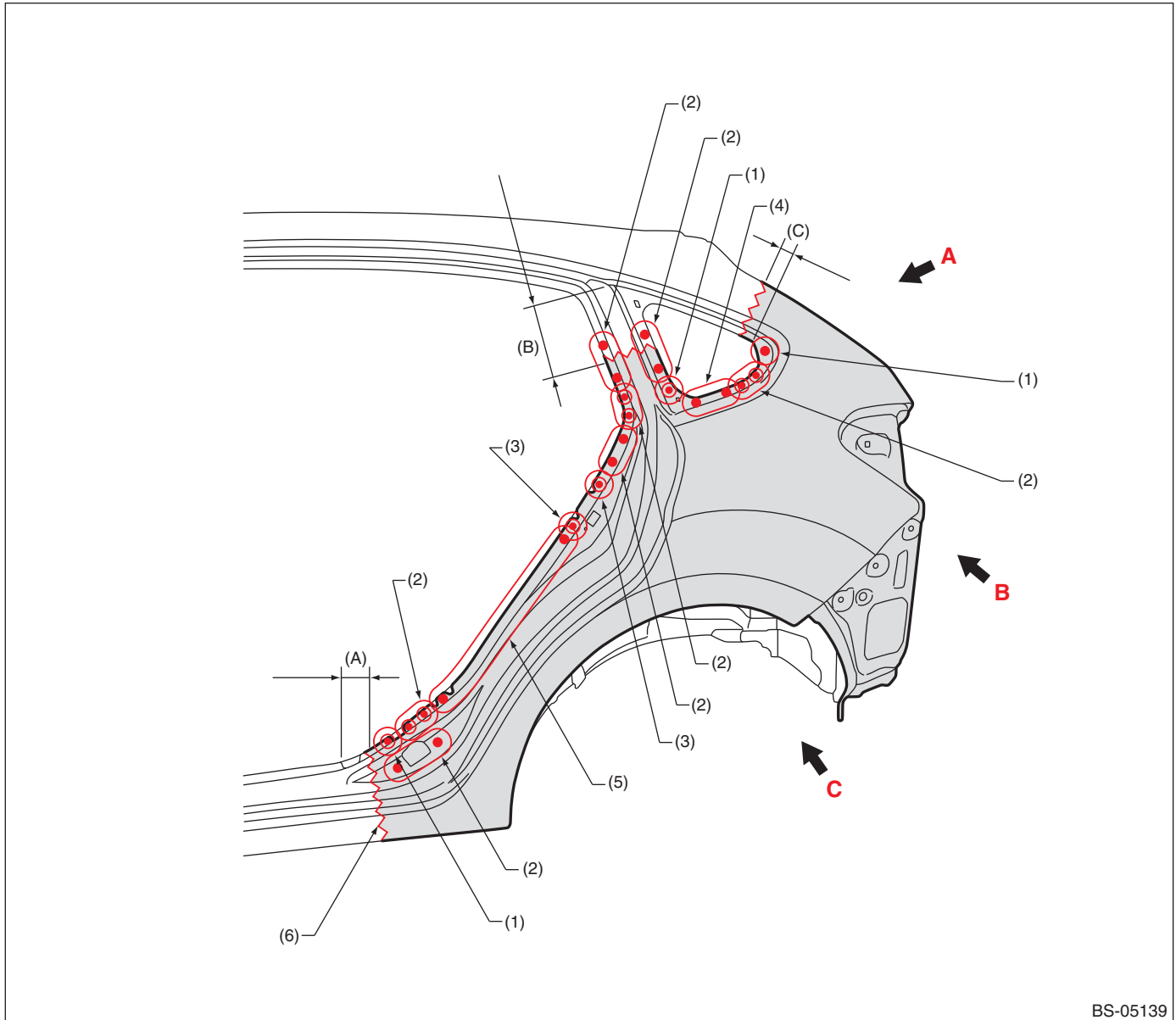
BS - 141

Panel Replacement

7-12. Rear Quarter (partial replacement)/5 Door

A: REMOVAL

• Overall view



BS-05139

(A) 60 mm (2.36 in)

(B) 150 mm (5.91 in)

(C) 10 mm (0.39 in)

(1) 1 point (outside · 1)

(3) 1 point (outside · 2)

(5) 7 points (outside · 1)

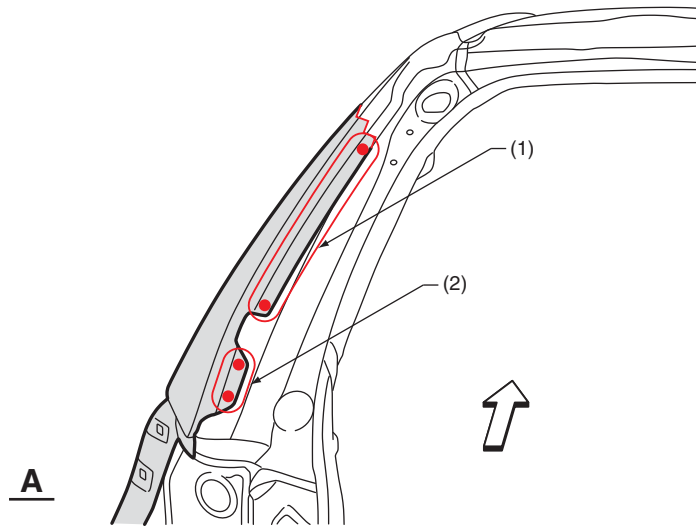
(2) 2 points (outside · 1)

(4) 3 points (outside · 1)

(6) Rough cutting

Panel Replacement

• Views 1



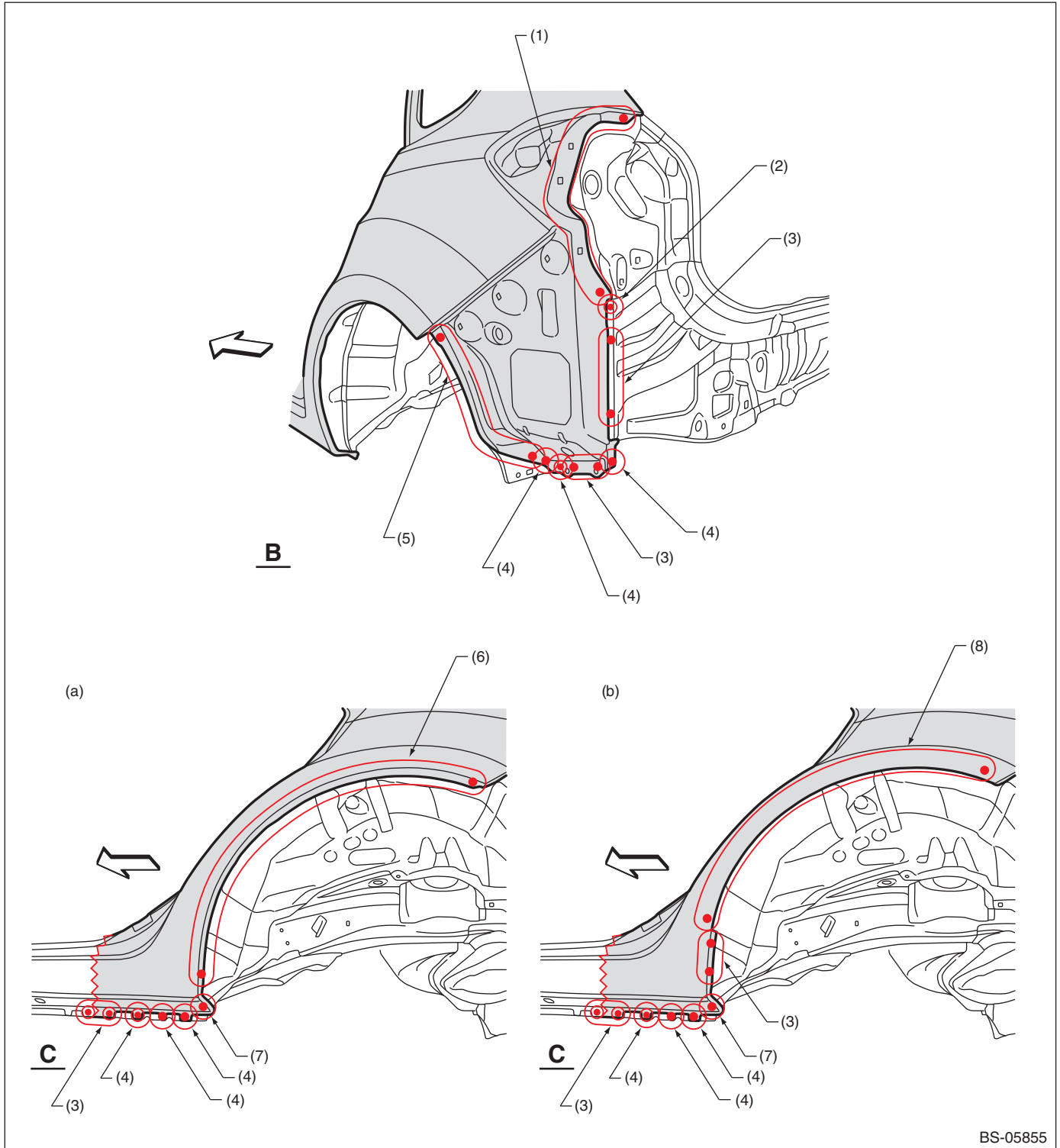
BS-05140

(1) 6 points (inside · 1)

(2) 2 points (inside · 1)

Panel Replacement

• Views 2



BS-05855

(a) Except for XV model

(b) XV model

(1) 8 points (outside · 1)

(2) 1 point (outside · 2)

(3) 3 points (outside · 1)

(4) 1 point (outside · 1)

(5) 7 points (outside · 1)

(6) 13 points (outside · 1)

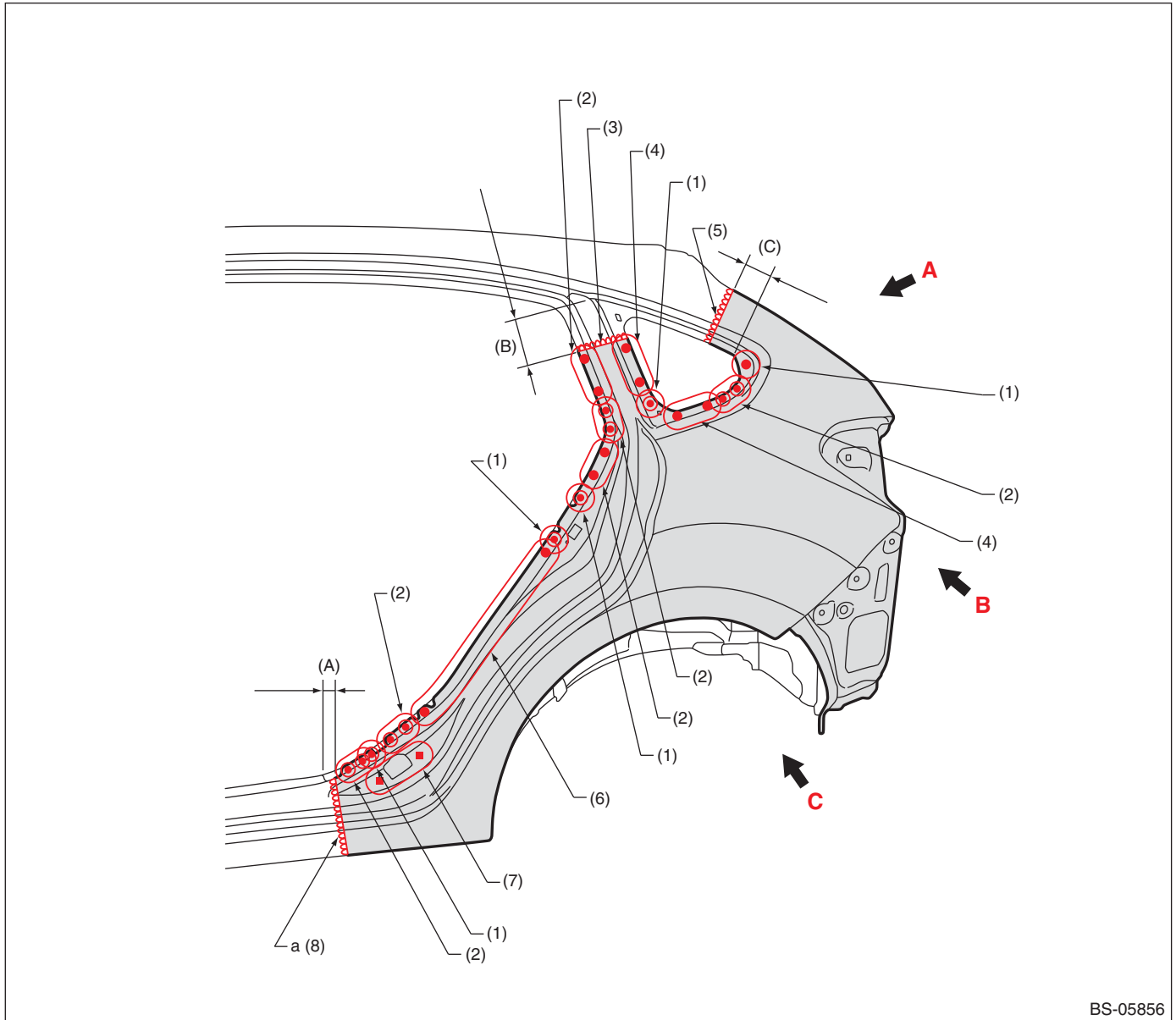
(7) 1 point (bottom · 1)

(8) 9 points (outside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BS-05856

(A) 20 mm (0.79 in)

(B) 110 mm (4.33 in)

(C) 40 mm (1.57 in)

(1) 1 point

(4) 3 points

(7) 2 points (service)

(2) 2 points

(5) 1 point [190 mm (7.48 in)]

(8) 1 point [290 mm (11.42 in)]

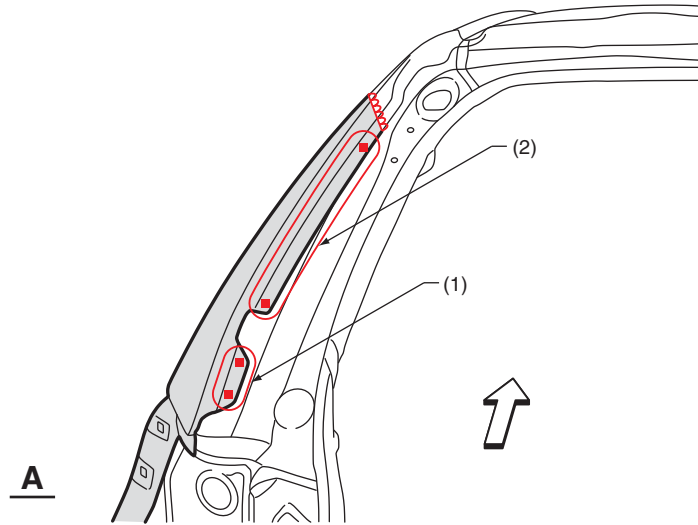
(3) 1 point [120 mm (4.72 in)]

(6) 7 points

For part marked by "a": Anticorrosion wax shall be applied thoroughly on the back side of continuous welding portion.

Panel Replacement

• Views 1



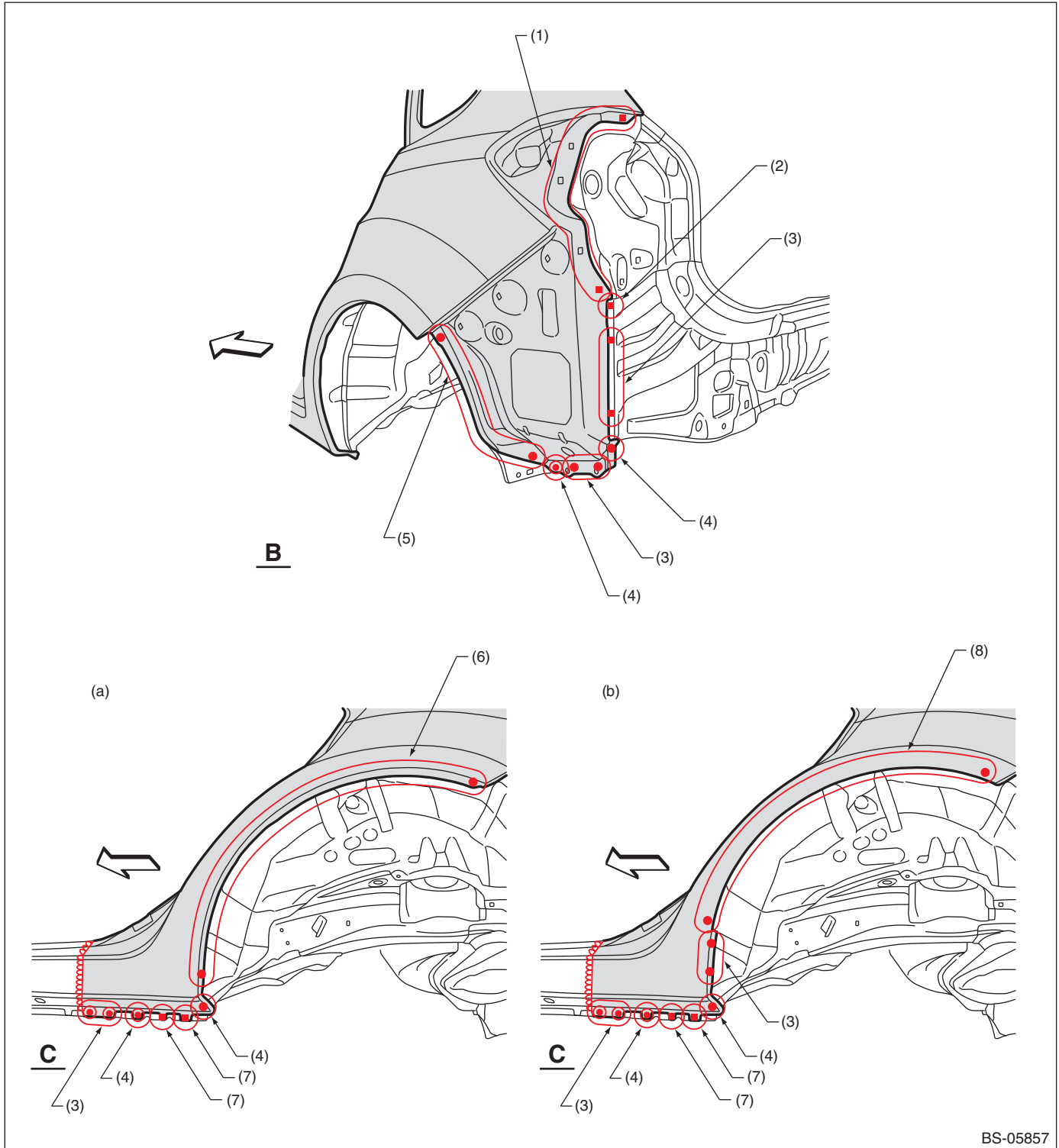
BS-05142

(1) 2 points (service)

(2) 6 points (service)

Panel Replacement

• Views 2



BS-05857

(a) Except for XV model

(b) XV model

(1) 8 points (service)

(4) 1 point

(7) 1 point (service)

(2) 1 point (service - matching)

(5) 8 points

(8) 9 points

(3) 3 points

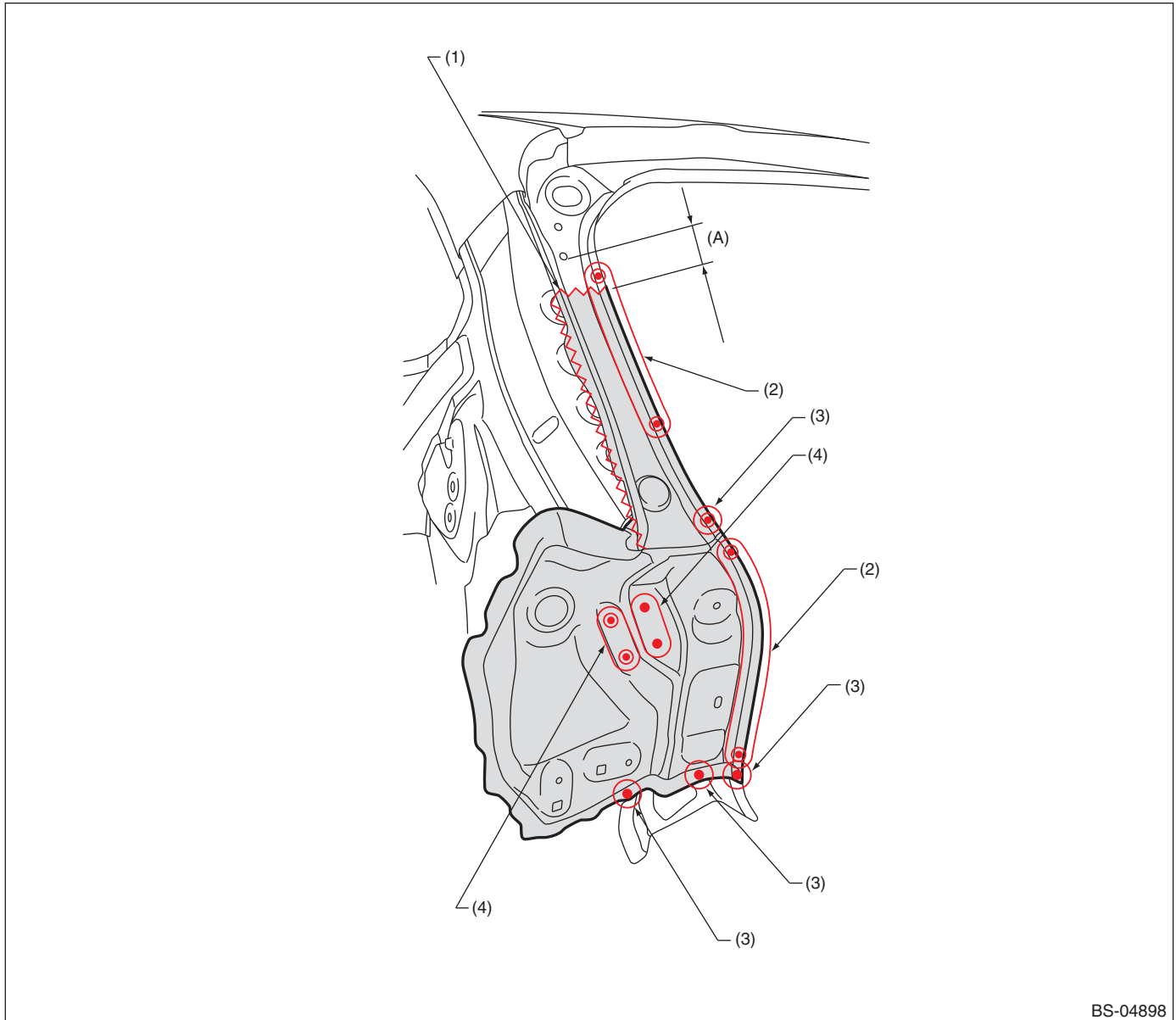
(6) 13 points

Panel Replacement

7-13. D-pillar Extension Quarter End (partial replacement) / 5 Door

A: REMOVAL

- Rear quarter outer and rear skirt removal condition



BS-04898

(A) 60 mm (2.36 in)

(1) Rough cutting

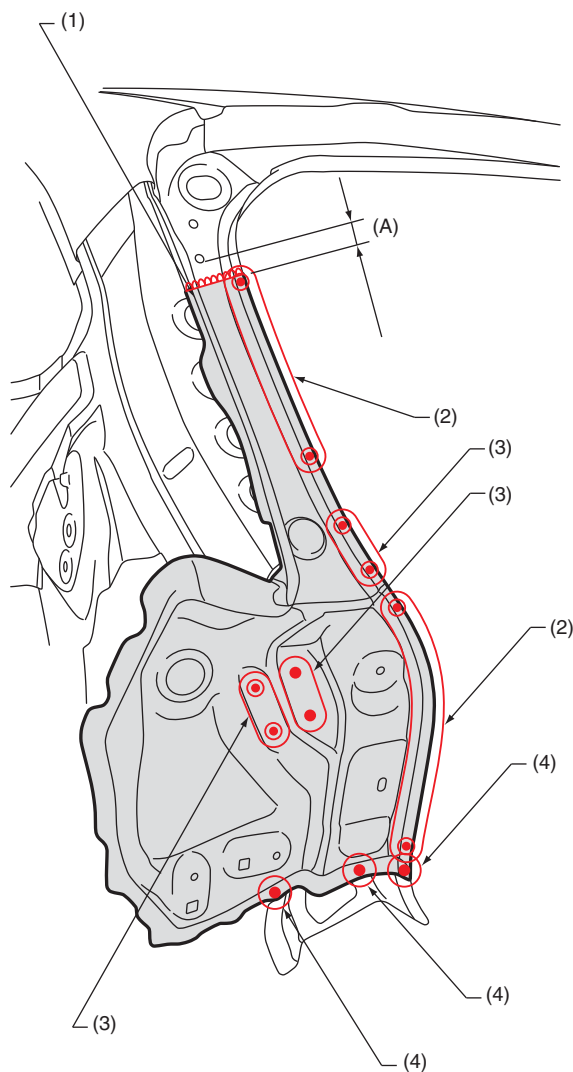
(2) 5 points (outside · 1)

(3) 1 point (outside · 1)

(4) 2 points (outside · 1)

Panel Replacement

B: INSTALLATION



BS-04899

(A) 30 mm (1.18 in)

(1) 1 point [110 mm (4.33 in)]

(2) 6 points

(3) 2 points

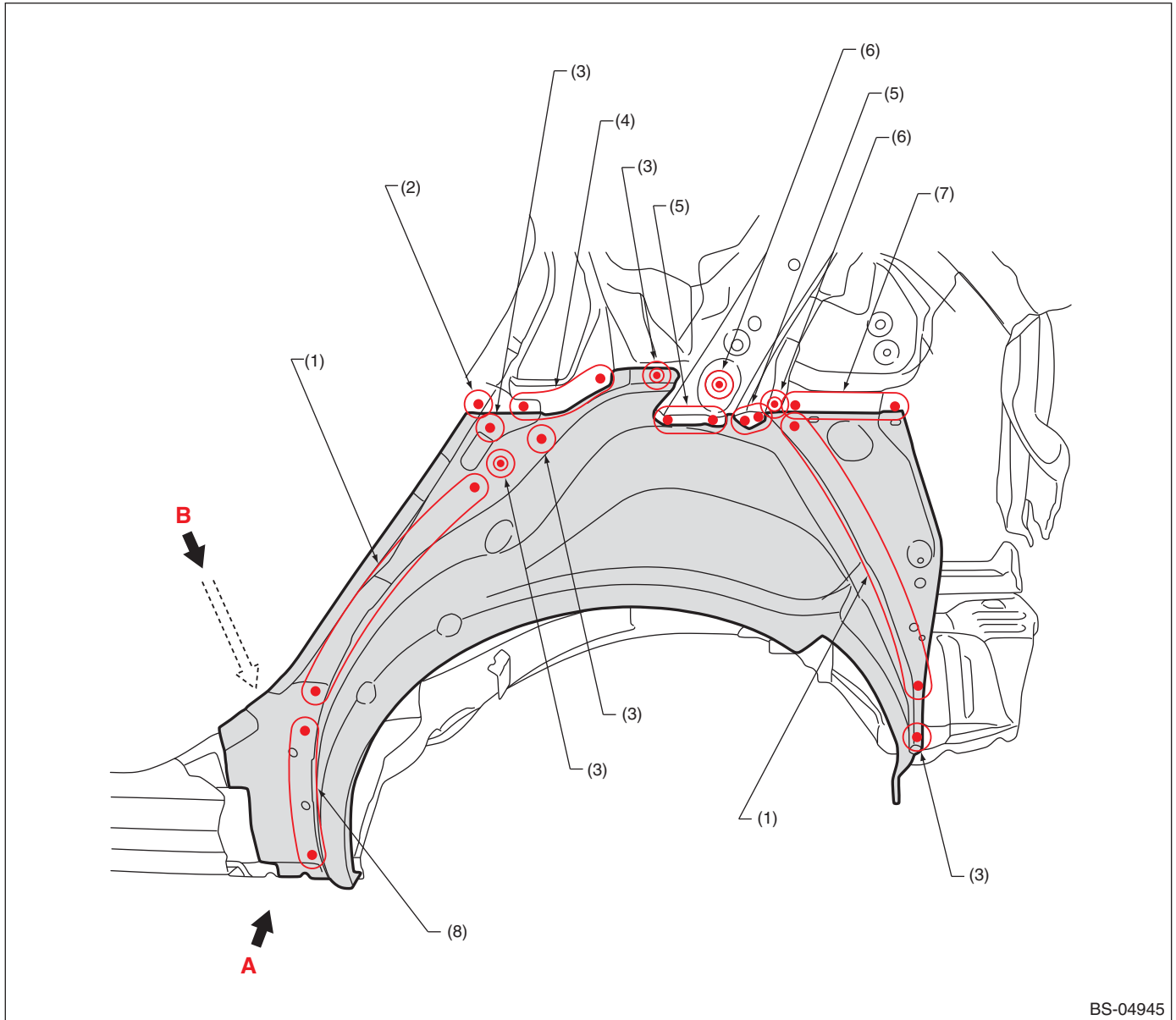
(4) 1 point

Panel Replacement

7-14. Rear Wheel Apron (total replacement)

A: REMOVAL

- Overall view (Rear quarter outer removal condition)

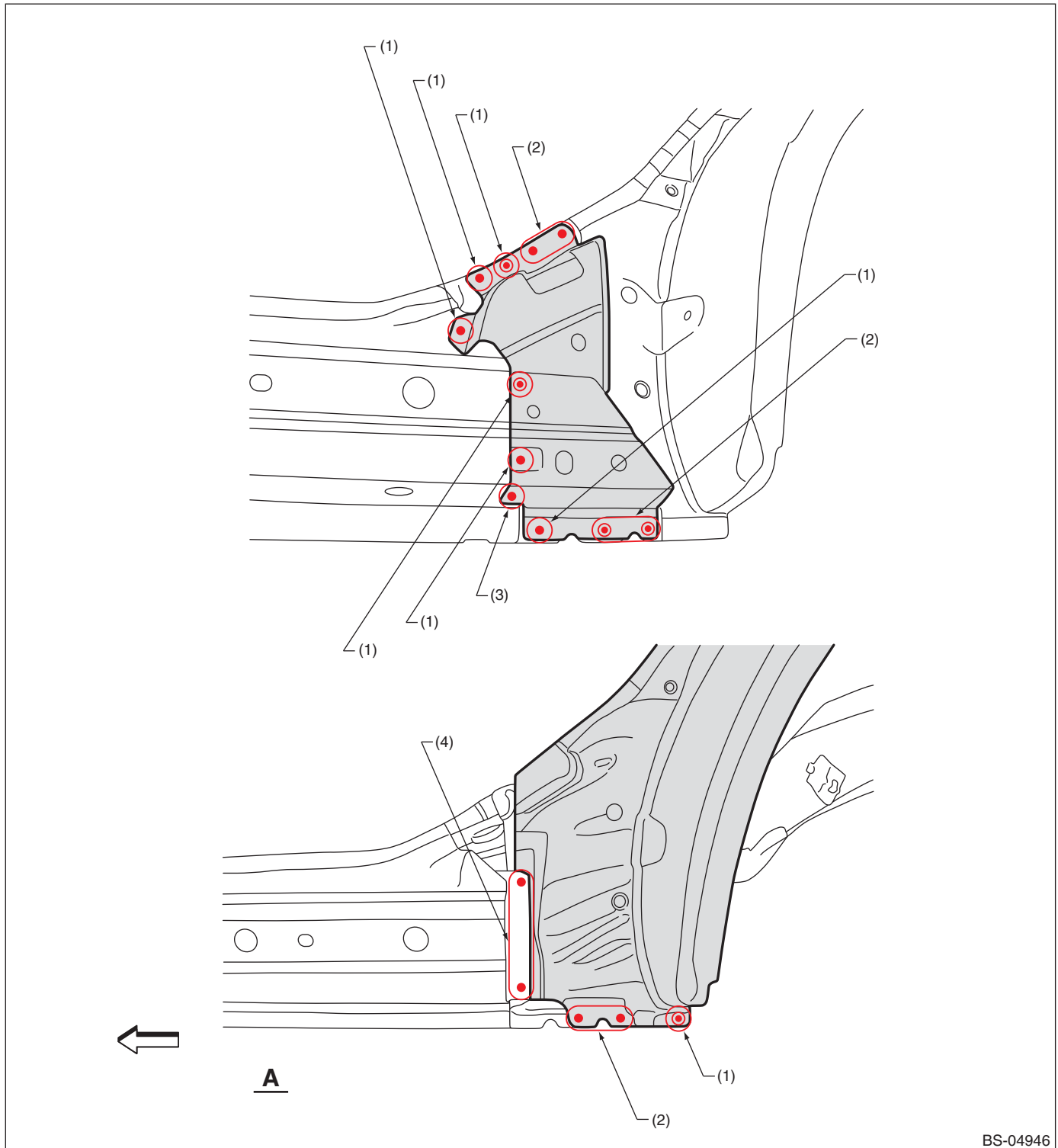


BS-04945

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

Panel Replacement

• Views 1



BS-04946

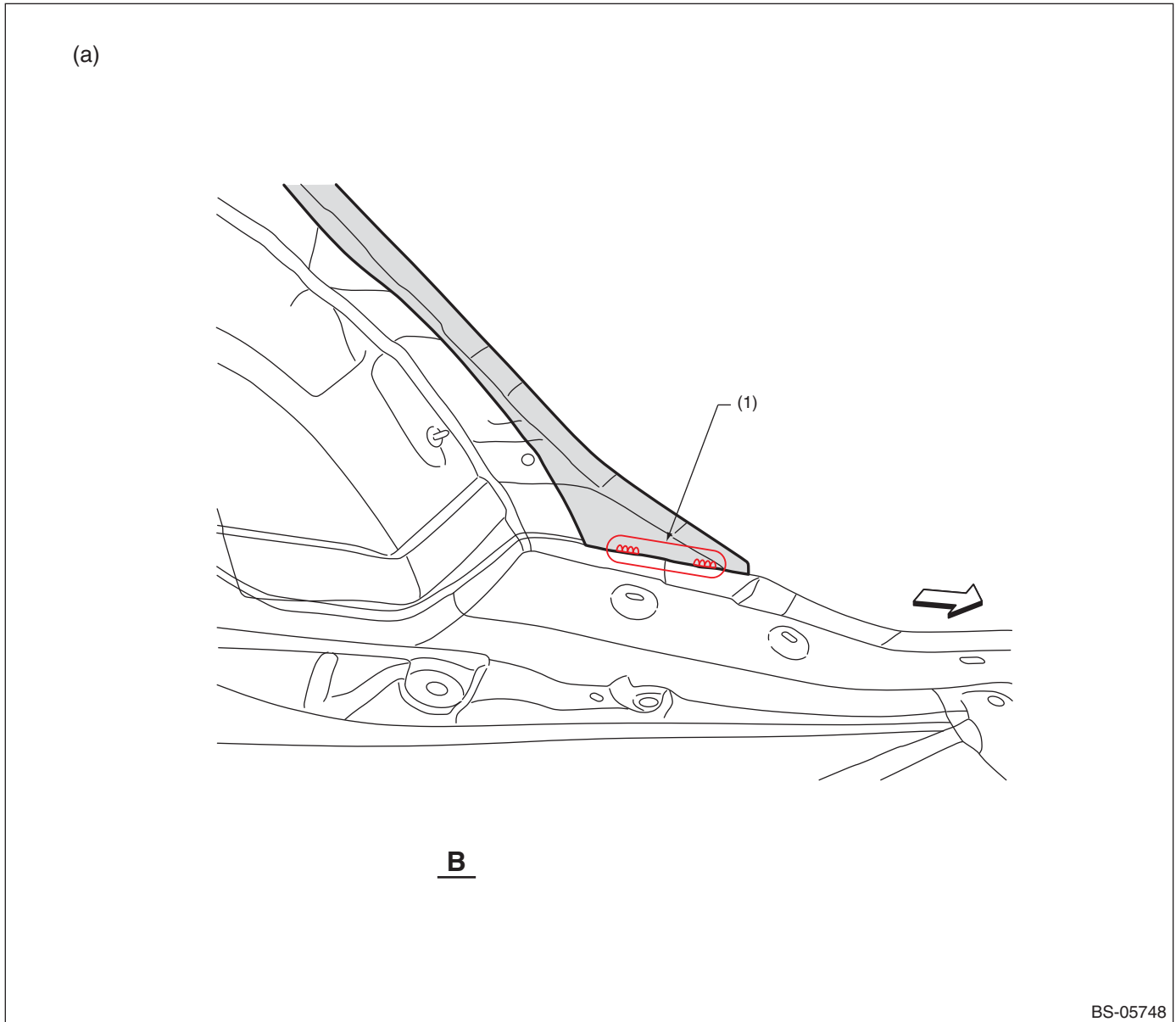
(1) 1 point (outside · 1)
(2) 2 points (outside · 1)

(3) 1 point (bottom · 1)

(4) 3 points (outside · 1)

Panel Replacement

• Views 2

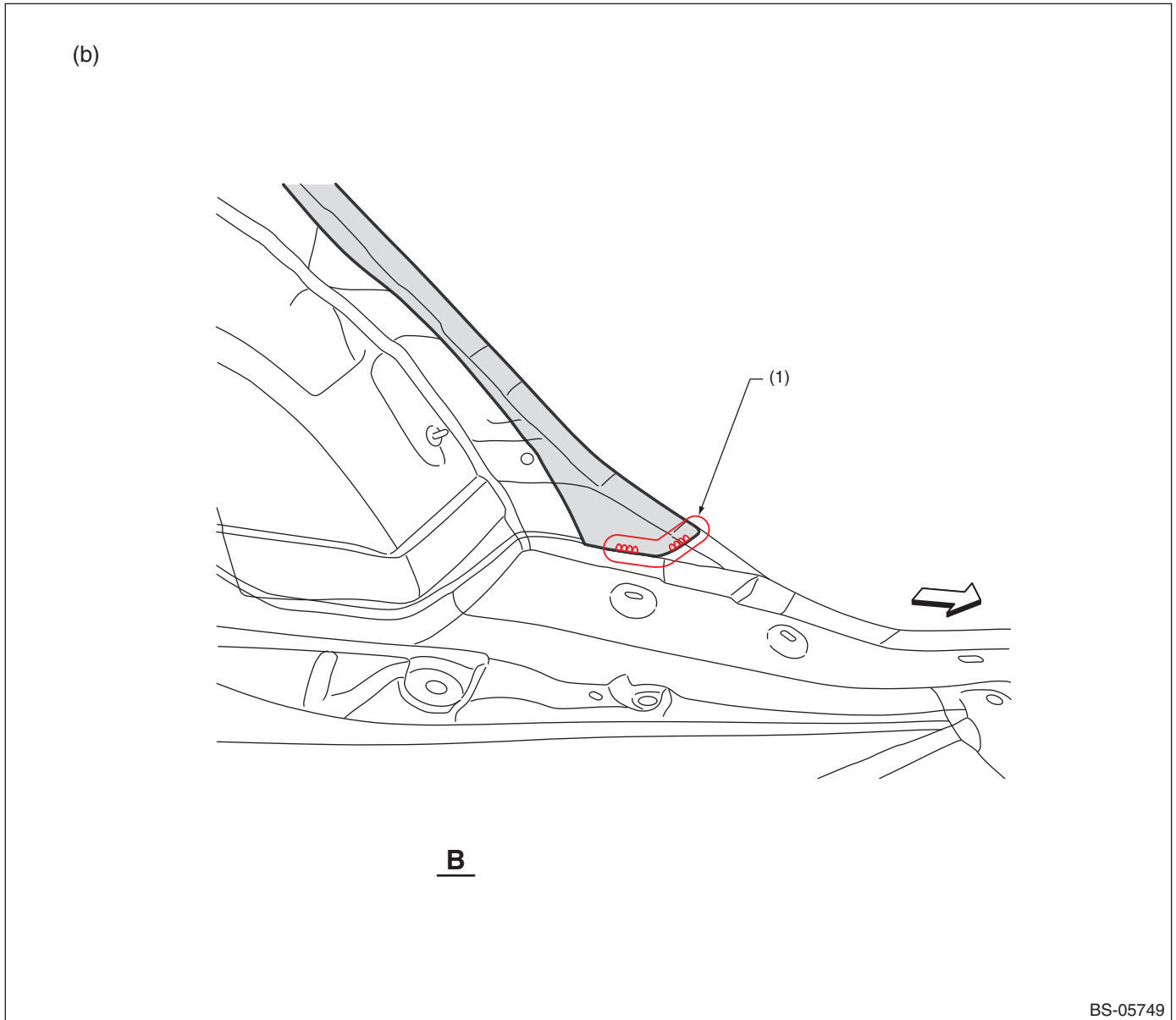


(a) Type A

(1) 2 points (inside · 1, belt sander)

Panel Replacement

• Views 2



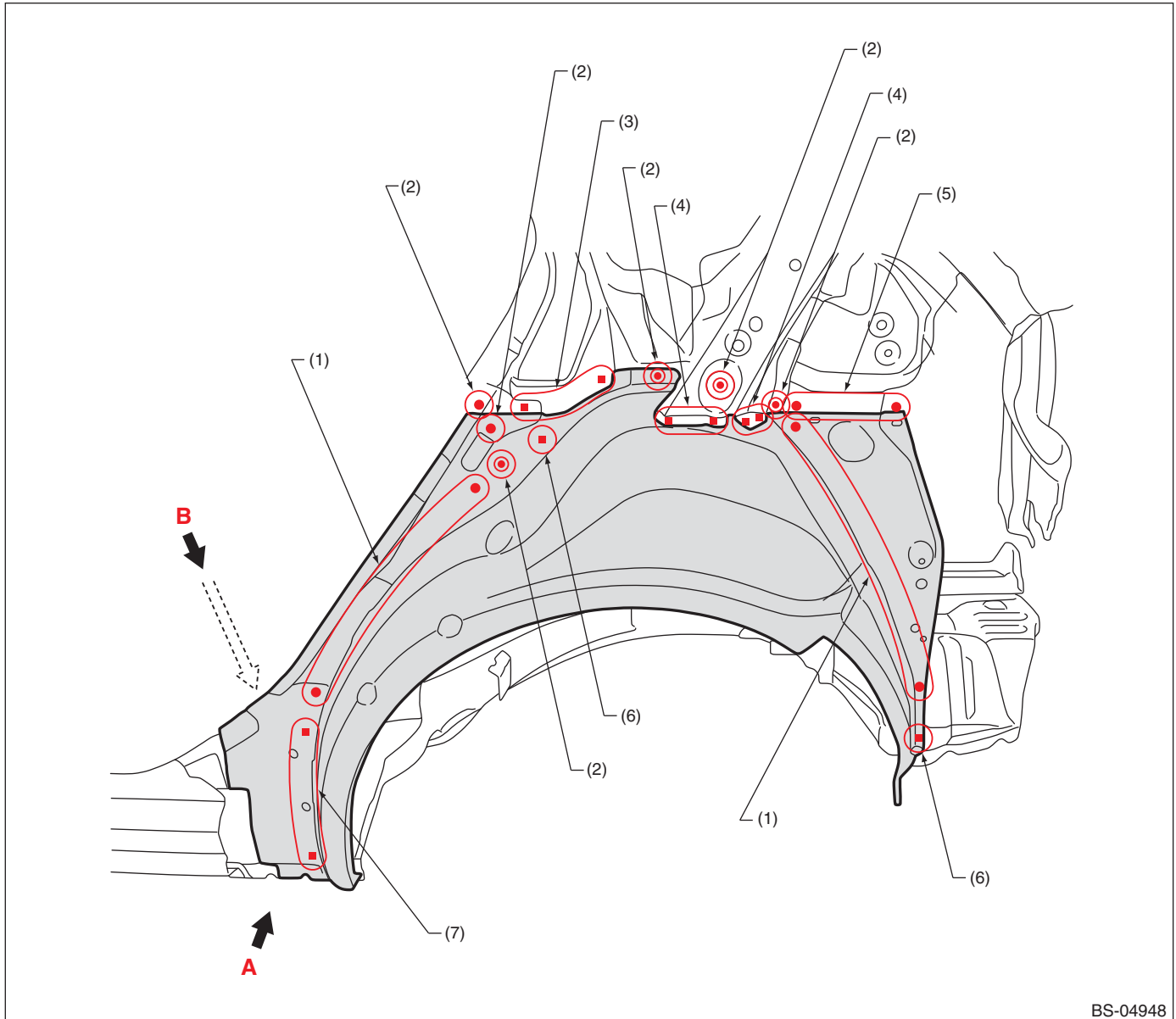
(b) Type B

(1) 2 points (inside · 1, belt sander)

Panel Replacement

B: INSTALLATION

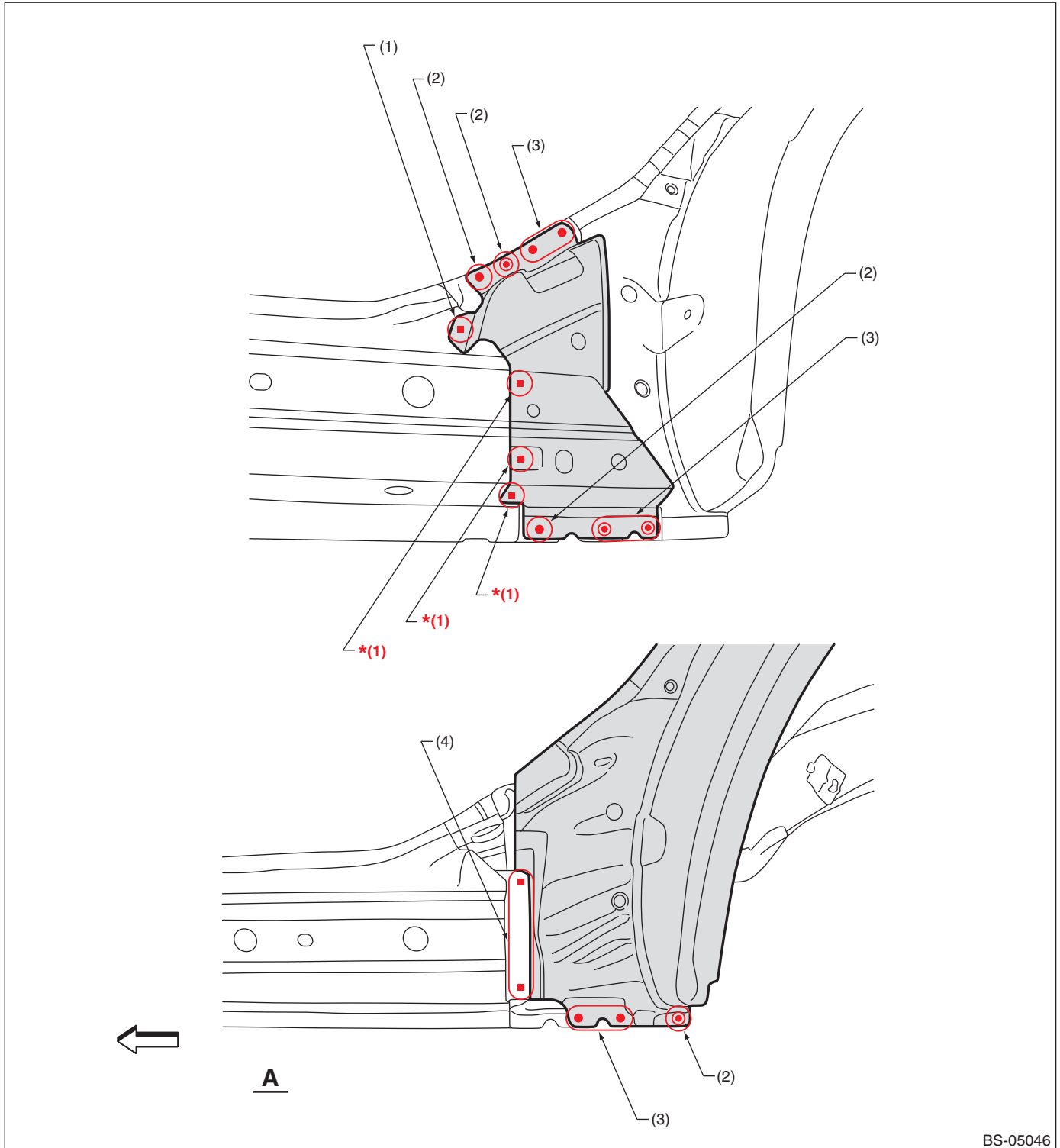
• Overall view



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

Panel Replacement

• Views 1



BS-05046

(1) 1 point (service)

(3) 2 points

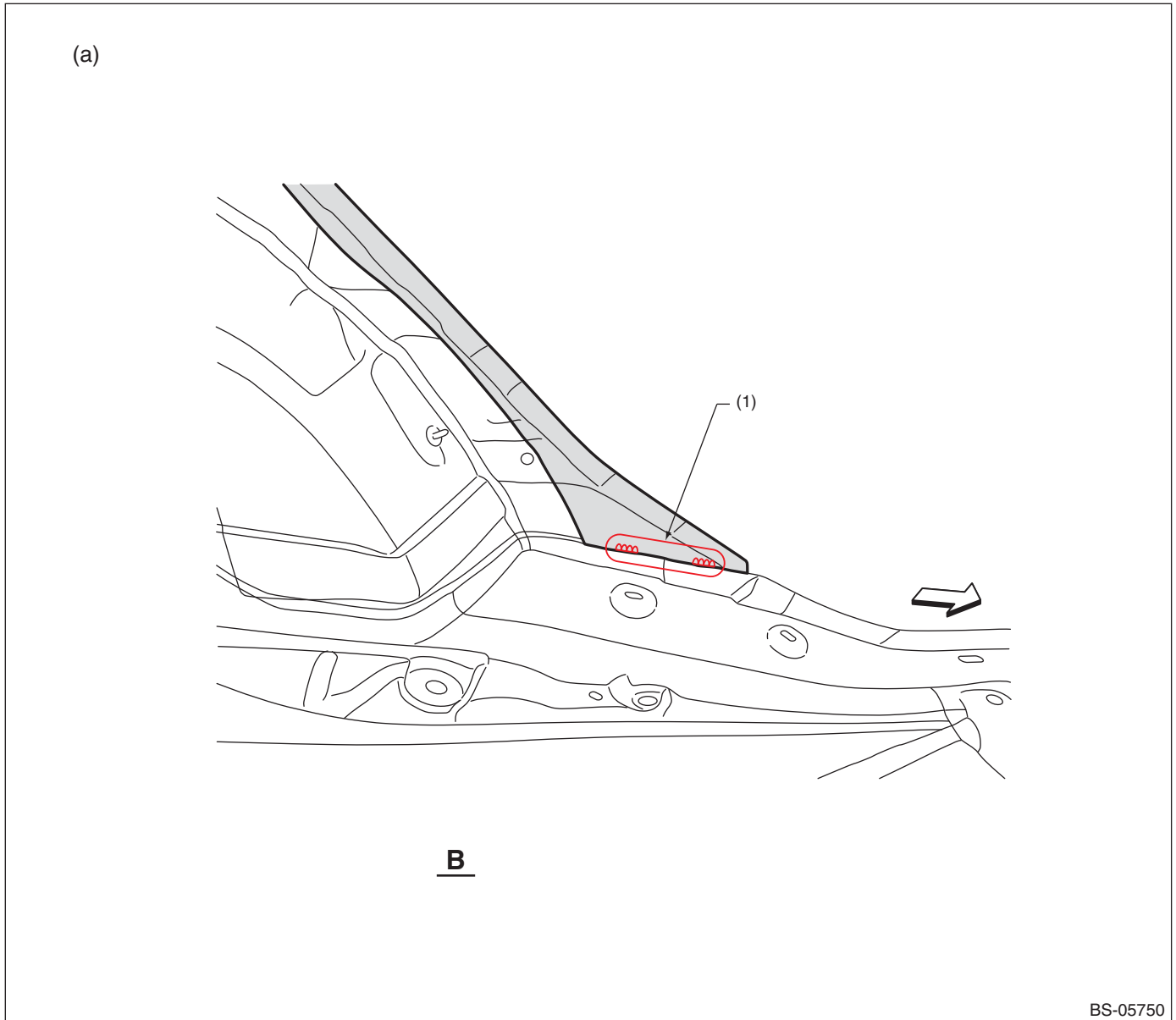
(4) 3 points

(2) 1 point

*: For 980MPa class High-strength tensile steel plug welding, refer to the conditions reported in (BS-8).

Panel Replacement

• Views 2

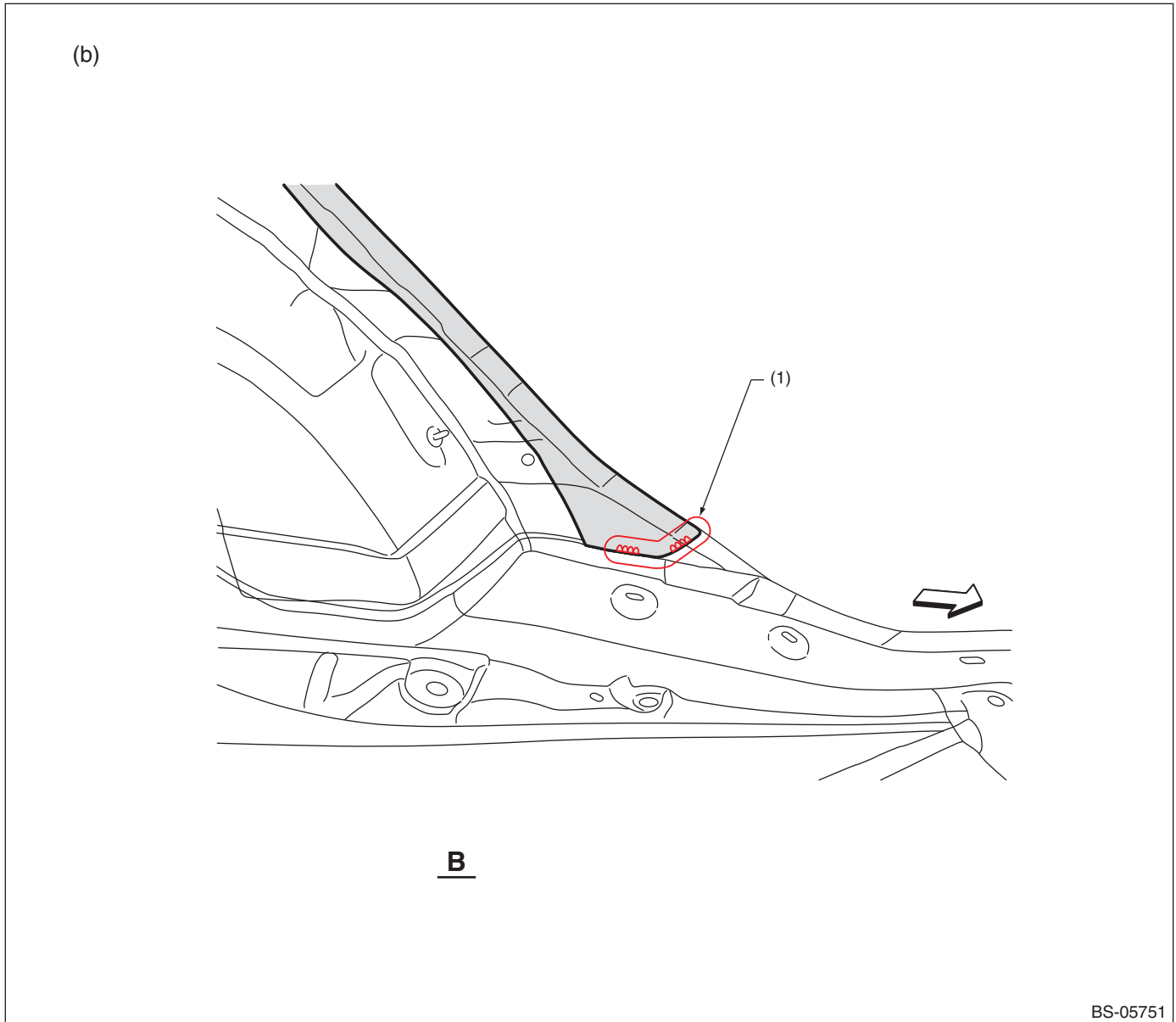


(a) Type A

(1) 2 points [20 mm (0.79 in)]

Panel Replacement

• Views 2



(b) Type B

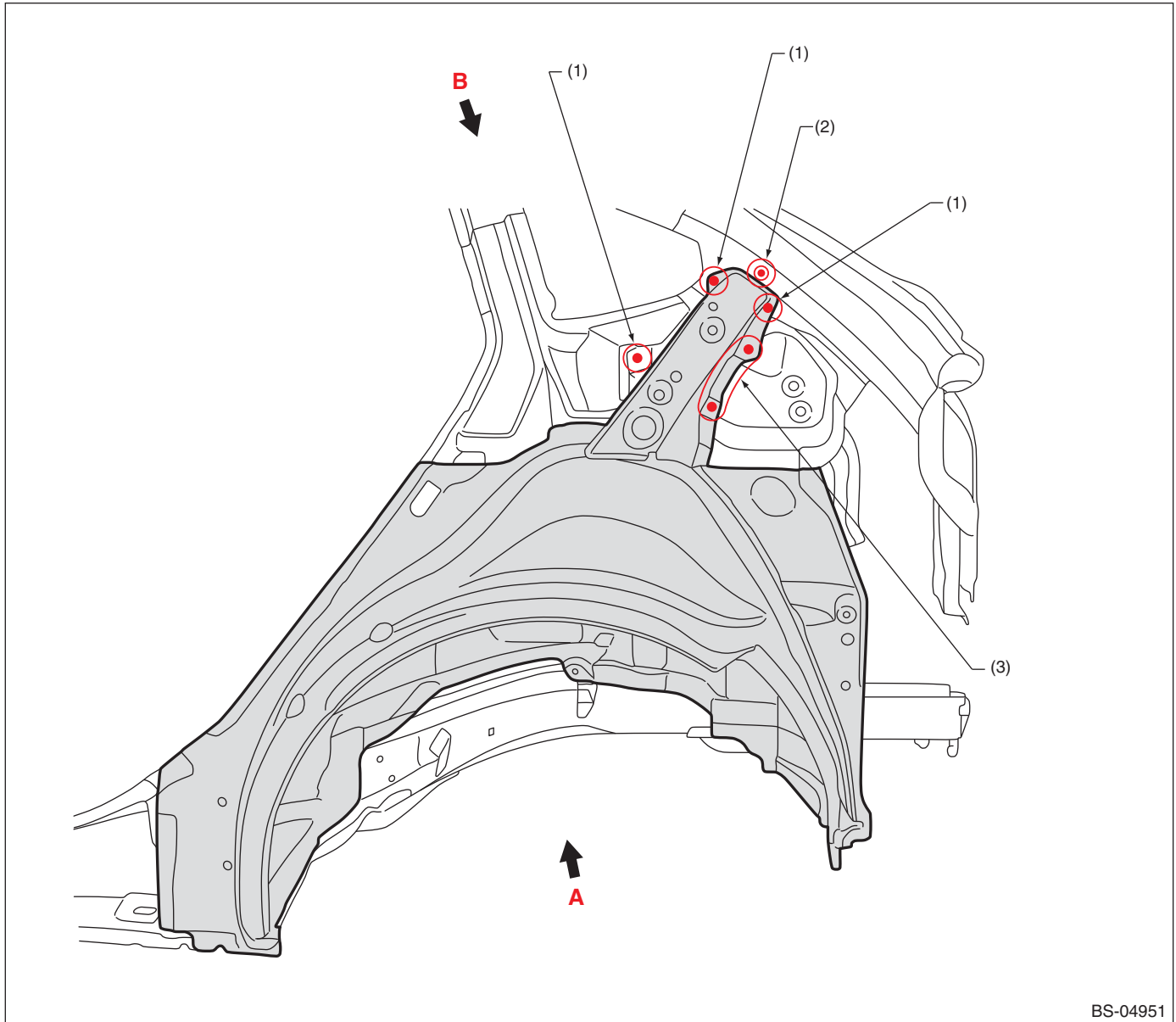
(1) 2 points [20 mm (0.79 in)]

Panel Replacement

7-15. Rear Quarter Inner (partial replacement)

A: REMOVAL

- Overall view (Rear quarter outer, side sill reinforcement and floor side rear skirt removal condition)



BS-04951

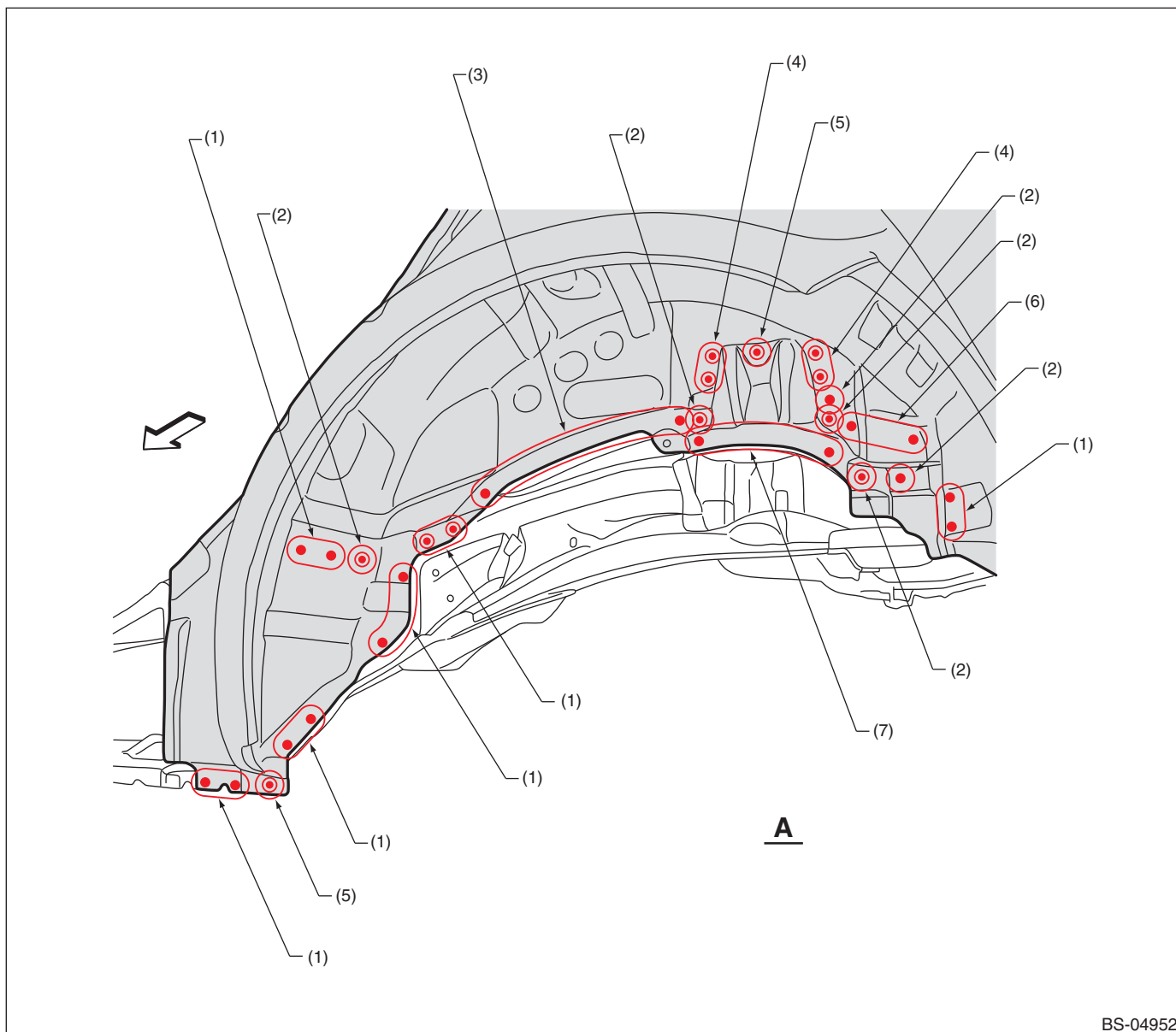
(1) 1 point (outside · 1)

(2) 1 point (outside · 2)

(3) 2 points (outside · 1)

Panel Replacement

• Views 1



BS-04952

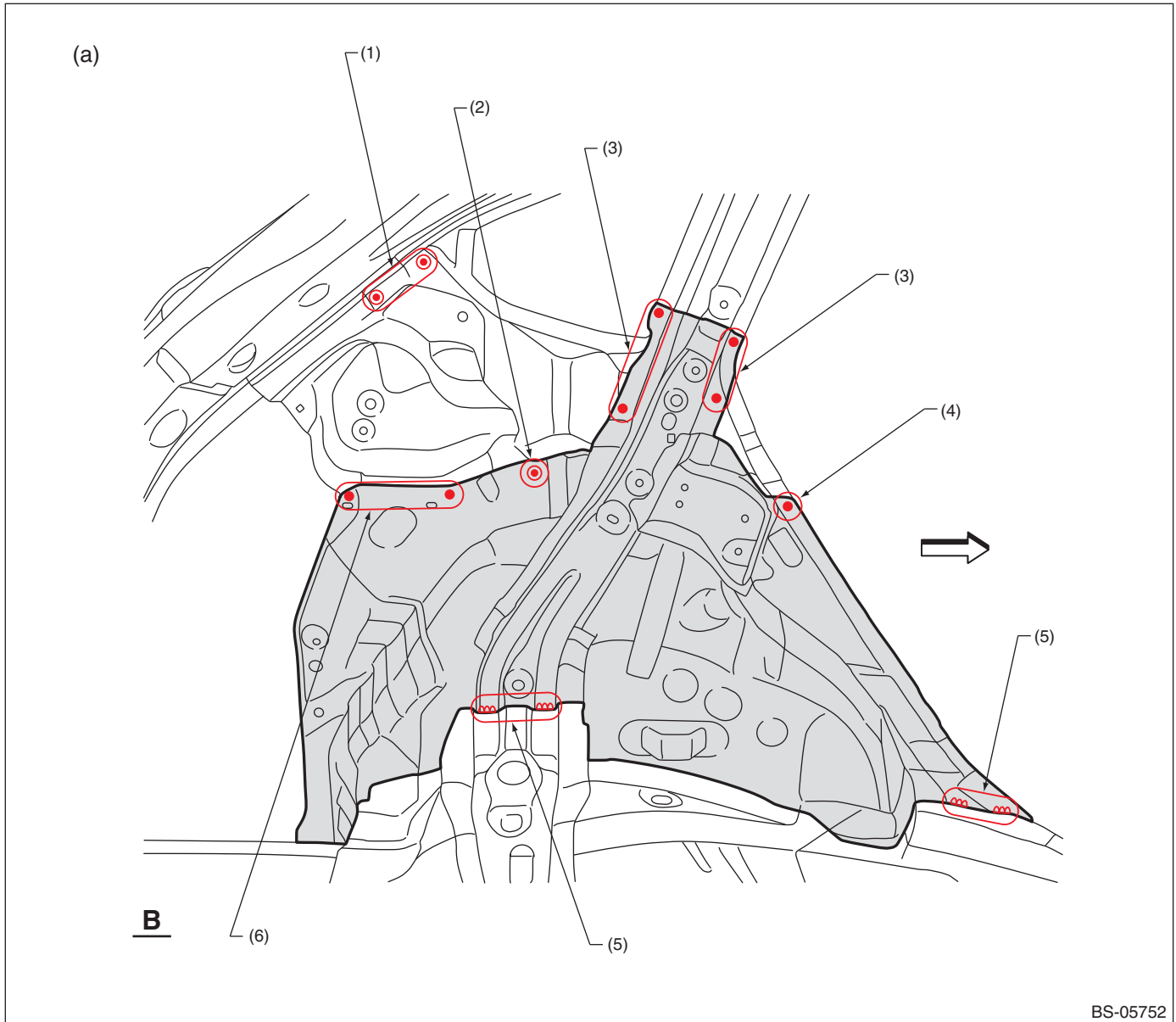
- (1) 2 points (outside · 1)
- (2) 1 point (outside · 1)
- (3) 6 points (outside · 1)

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

- (7) 5 points (outside · 1)

Panel Replacement

• Views 2



(a) Type A

(1) 2 points (inside · 2)

(2) 1 point (inside · 2)

(3) 3 points (inside · 1)

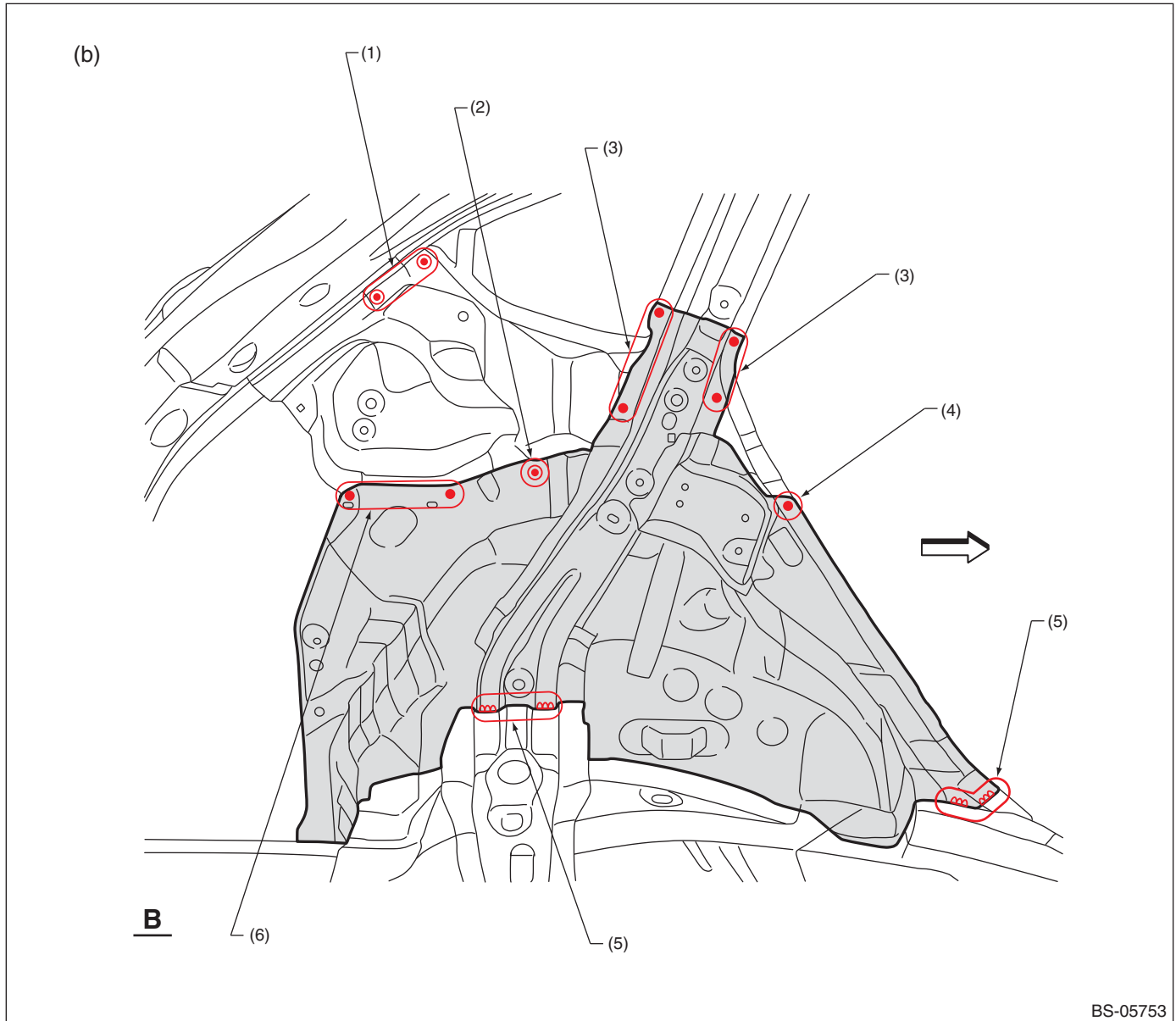
(4) 1 point (inside · 1)

(5) 2 points (inside · 1, belt sander)

(6) 5 points (inside · 1)

Panel Replacement

• Views 2



(b) Type B

(1) 2 points (inside · 2)

(2) 1 point (inside · 2)

(3) 3 points (inside · 1)

(4) 1 point (inside · 1)

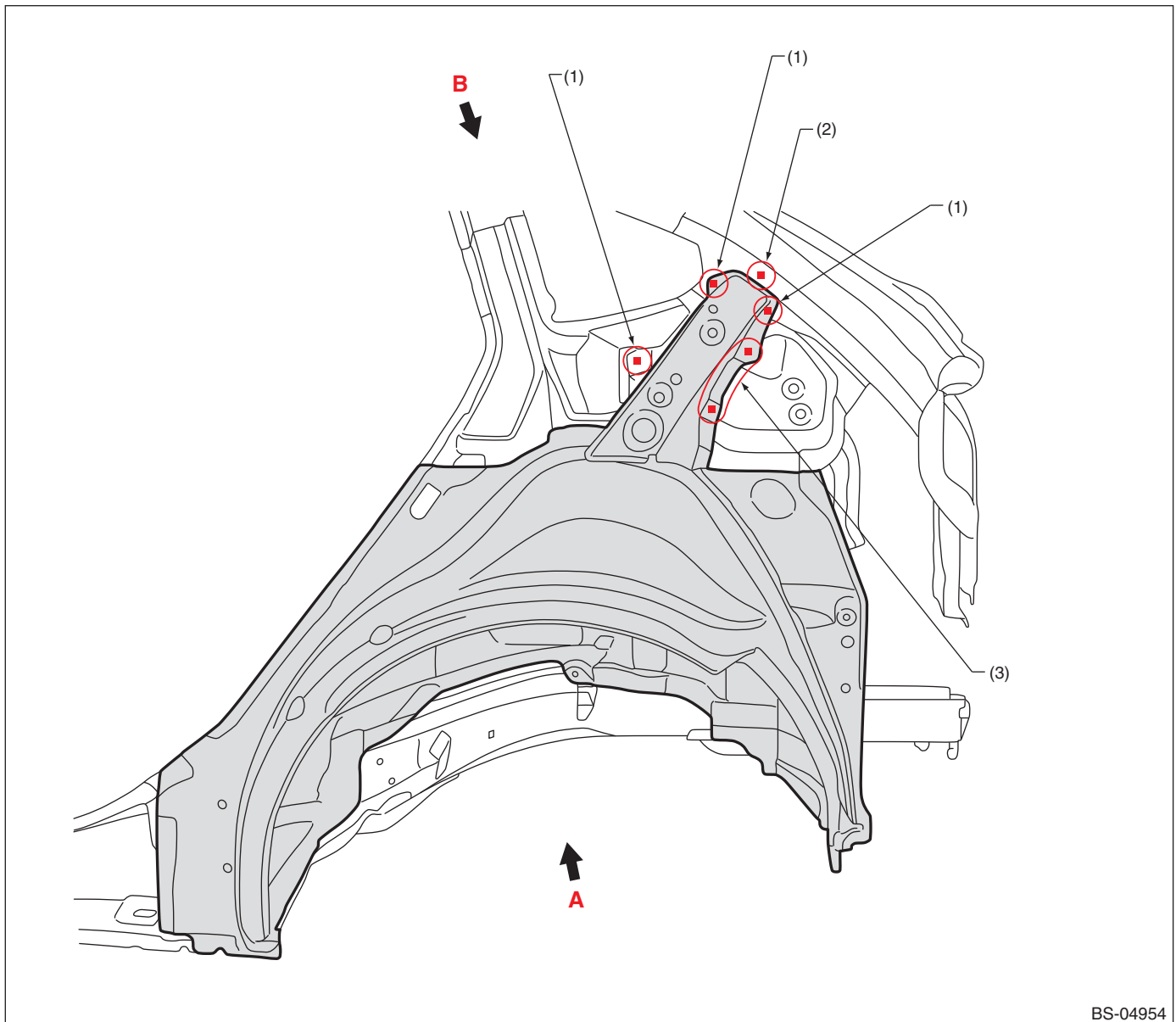
(5) 2 points (inside · 1, belt sander)

(6) 5 points (inside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BS-04954

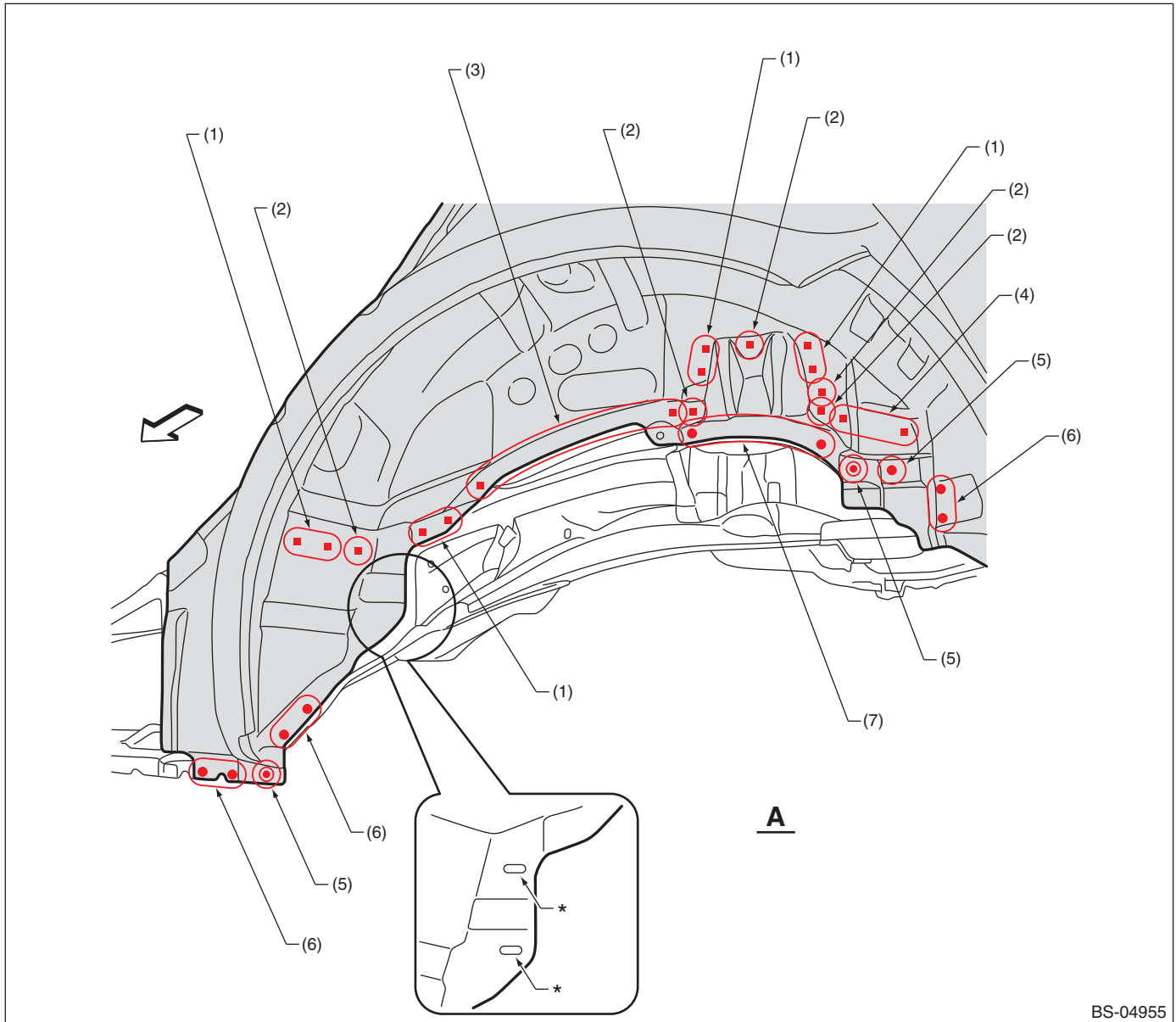
(1) 1 point (service)

(2) 1 point (service · matching)

(3) 2 points (service)

Panel Replacement

• Views 1



BS-04955

- (1) 2 points (service)
- (2) 1 point (service)
- (3) 6 points (service)

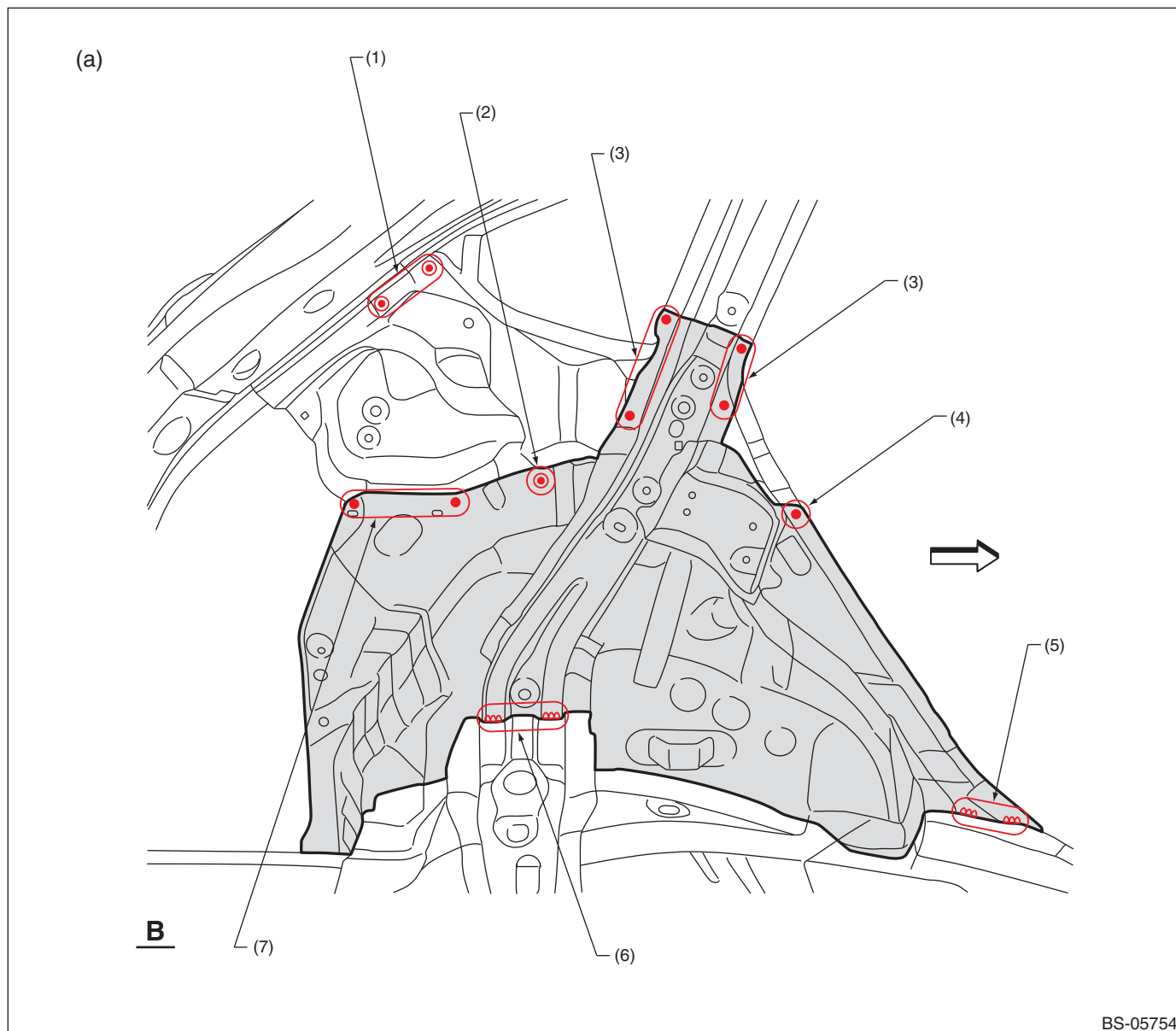
- (4) 3 points (service)
- (5) 1 point
- (6) 2 points

- (7) 5 points

*: Plug welding of a $\phi 7 \times 20$ mm (0.28 x 0.79 in) elongated hole

Panel Replacement

• Views 2



(a) Type A

(1) 2 points

(2) 1 point (service)

(3) 3 points

(4) 1 point

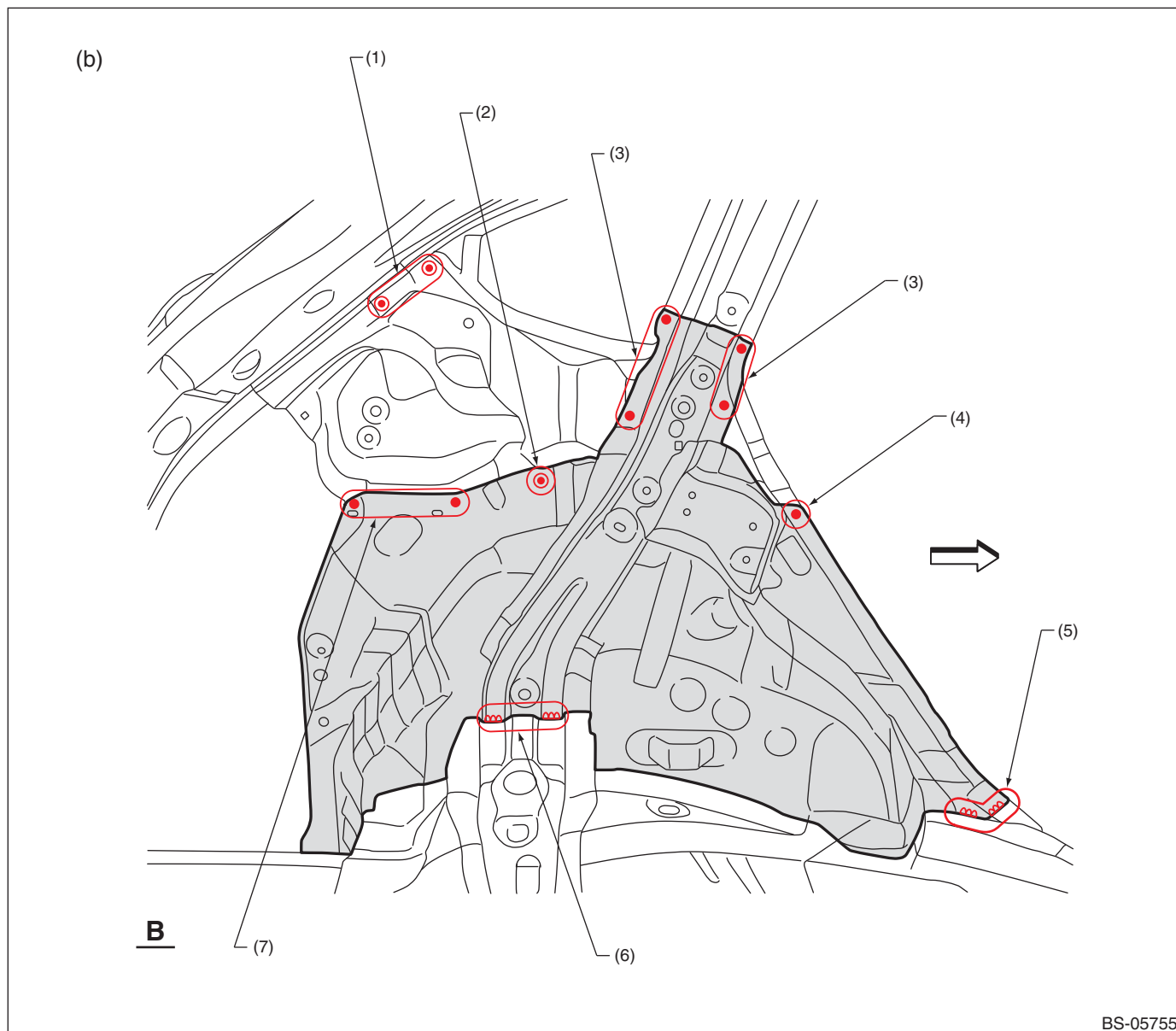
(5) 2 points [20 mm (0.79 in)]

(6) 2 points [15 mm (0.59 in)]

(7) 5 points

Panel Replacement

• Views 2



(b) Type B

(1) 2 points

(2) 1 point (service)

(3) 3 points

(4) 1 point

(5) 2 points [20 mm (0.79 in)]

(6) 2 points [15 mm (0.59 in)]

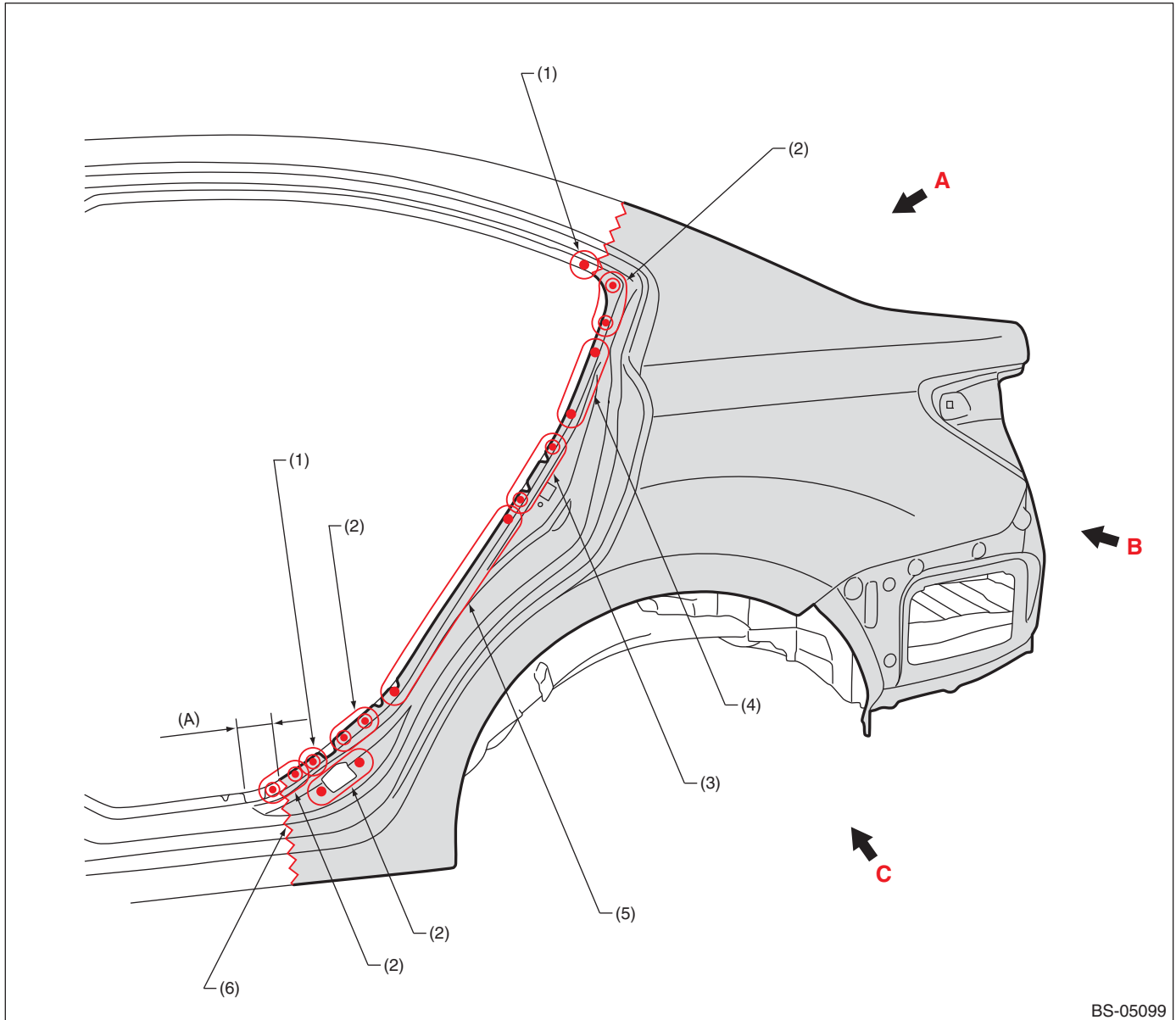
(7) 5 points

Panel Replacement

7-16. Rear Quarter (partial replacement) / 4 Door

A: REMOVAL

• Overall view



(A) 60 mm (2.36 in)

(1) 1 point (outside - 1)

(2) 2 points (outside - 1)

(3) 2 points (outside - 2)

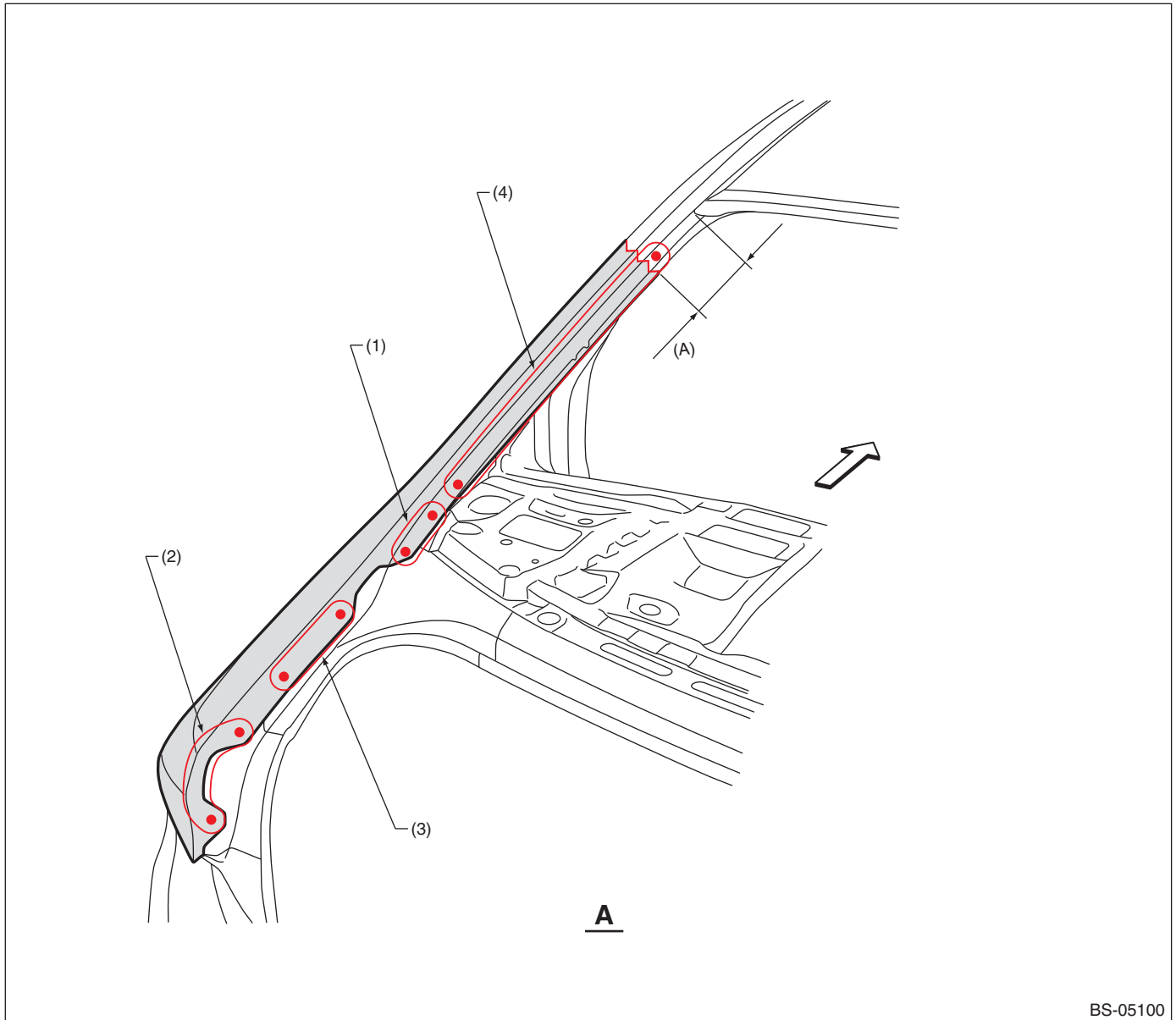
(4) 3 points (outside - 1)

(5) 7 points (outside - 1)

(6) Rough cutting

Panel Replacement

• Views 1



BS-05100

(A) 110 mm (4.33 in.)

(1) 2 points (outside · 1)

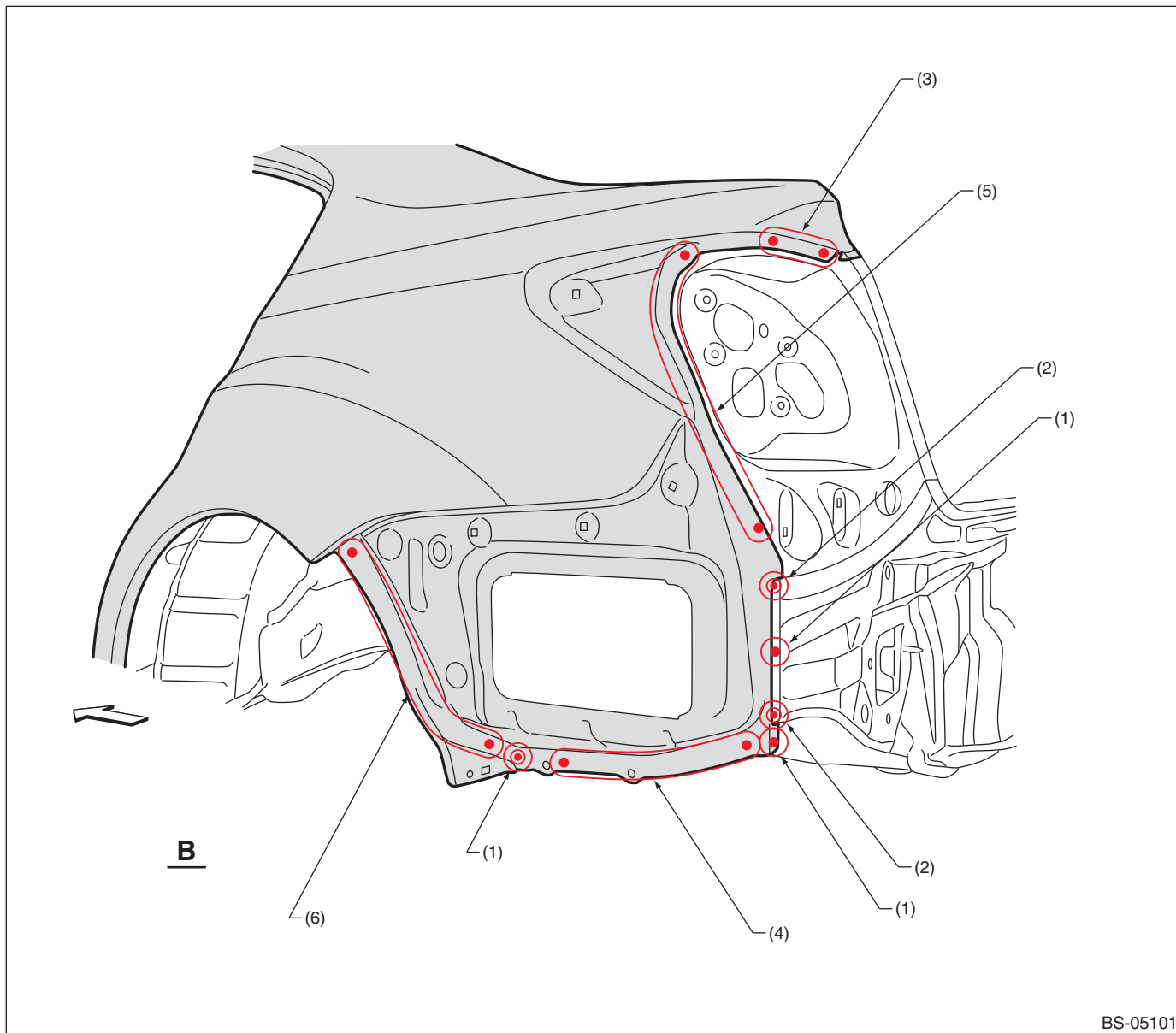
(2) 2 points (inside · 1)

(3) 3 points (inside · 1)

(4) 7 points (outside · 1)

Panel Replacement

• Views 2



BS-05101

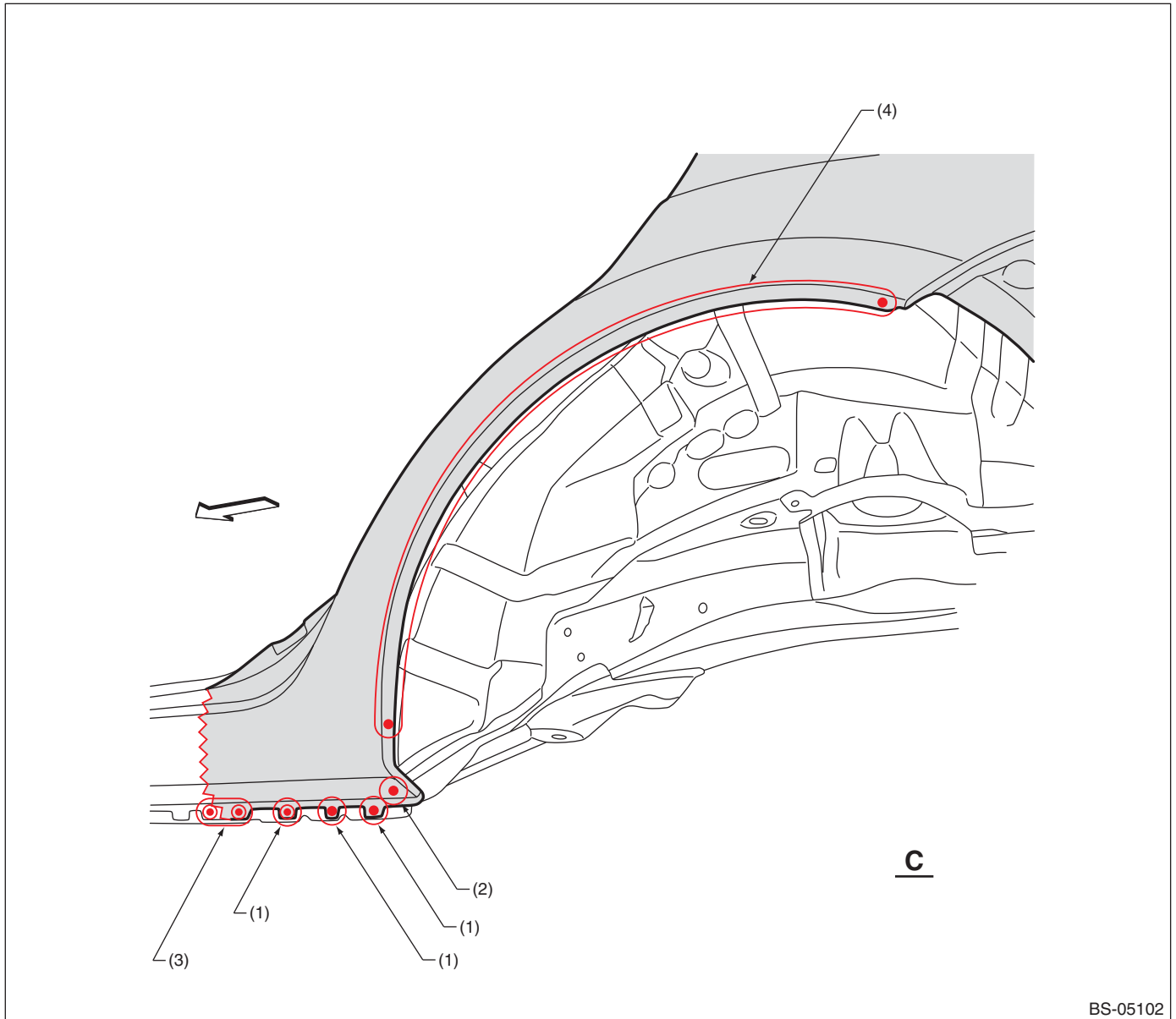
(1) 1 point (outside · 1)
(2) 1 point (outside · 2)

(3) 3 points (outside · 1)
(4) 5 points (outside · 1)

(5) 6 points (outside · 1)
(6) 7 points (outside · 1)

Panel Replacement

• Views 3



BS-05102

(1) 1 point (outside · 1)
(2) 1 point (bottom · 1)

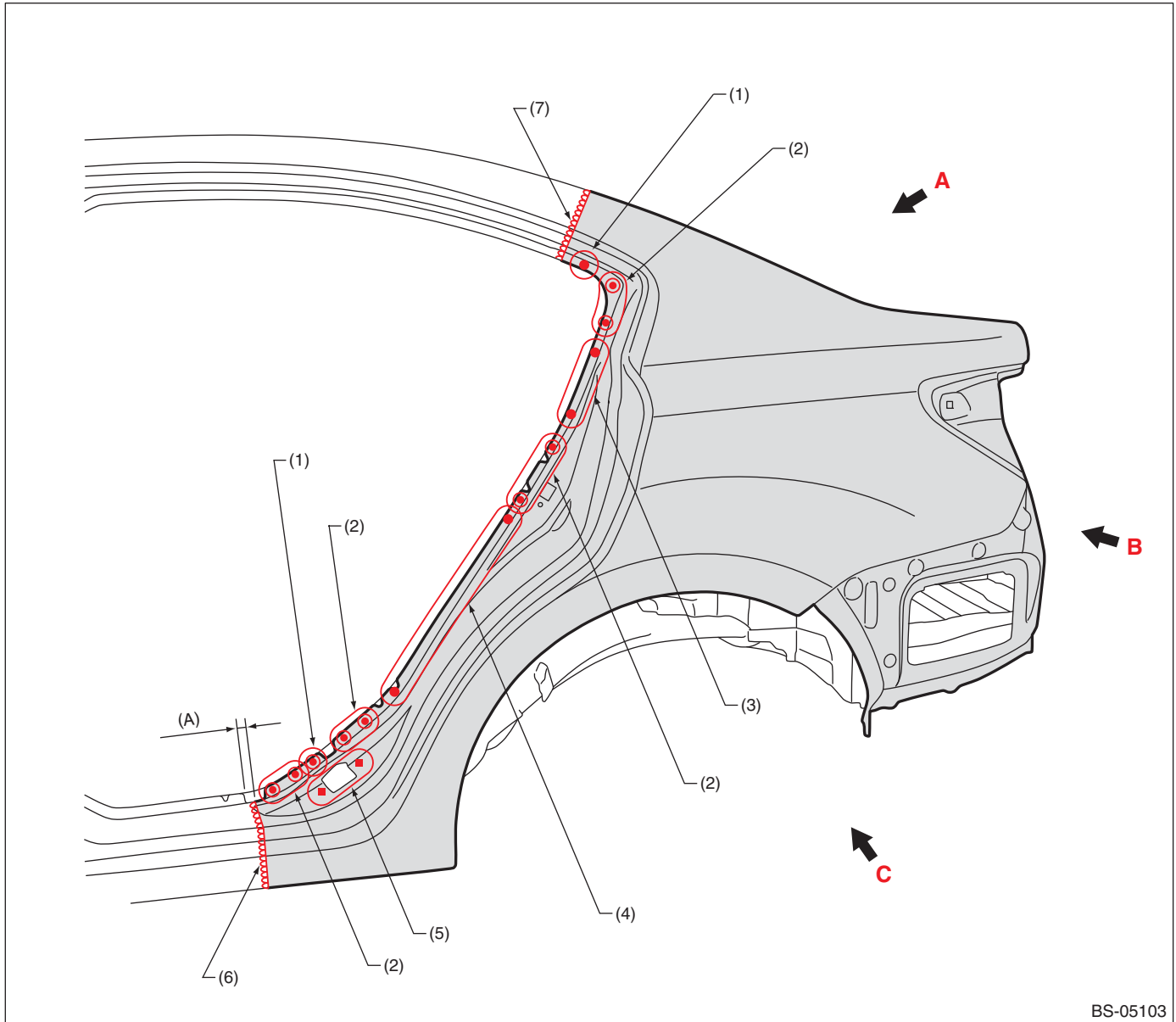
(3) 3 points (outside · 1)

(4) 13 points (outside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BS-05103

(A) 20 mm (0.79 in.)

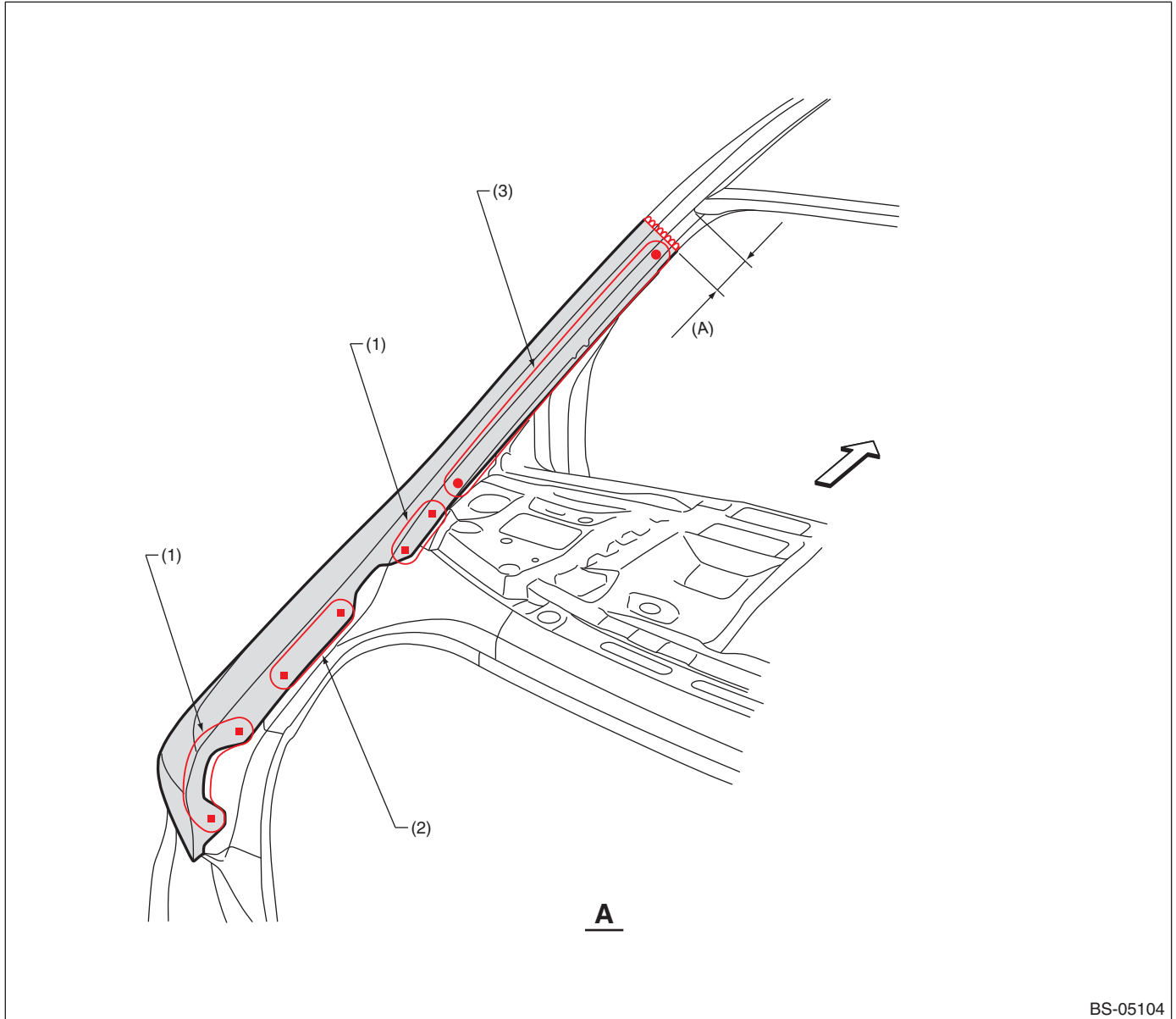
(1) 1 point
(2) 2 points
(3) 3 points

(4) 7 points
(5) 2 points (service)

(6) 1 point [275 mm (10.83 in.)]
(7) 1 point [230 mm (9.06 in.)]

Panel Replacement

• Views 1



BS-05104

(A) 70 mm (2.76 in.)

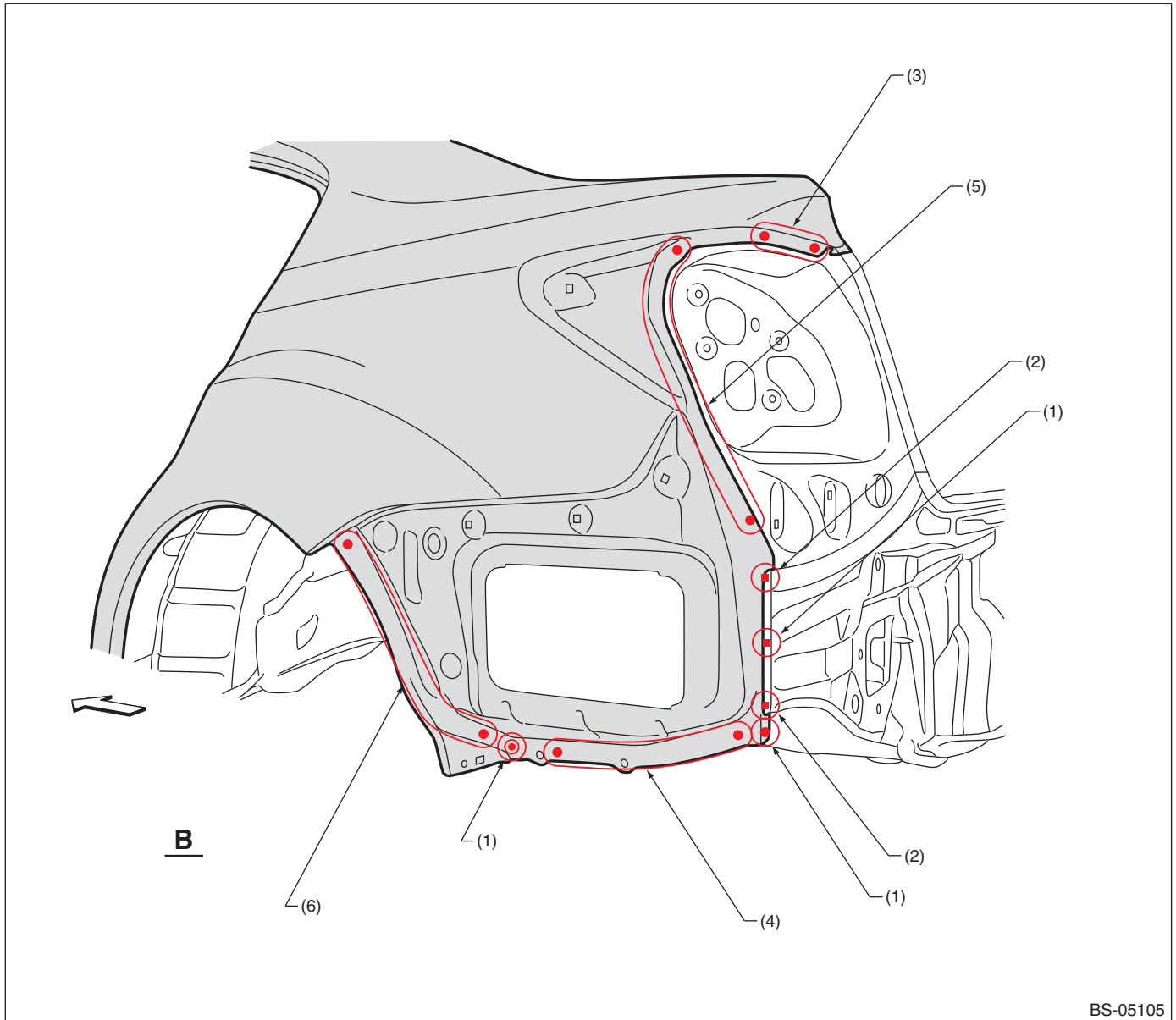
(1) 2 points (service)

(2) 3 points (service)

(3) 8 points

Panel Replacement

• Views 2



(1) 1 point

(2) 1 point (service · matching)

(3) 3 points

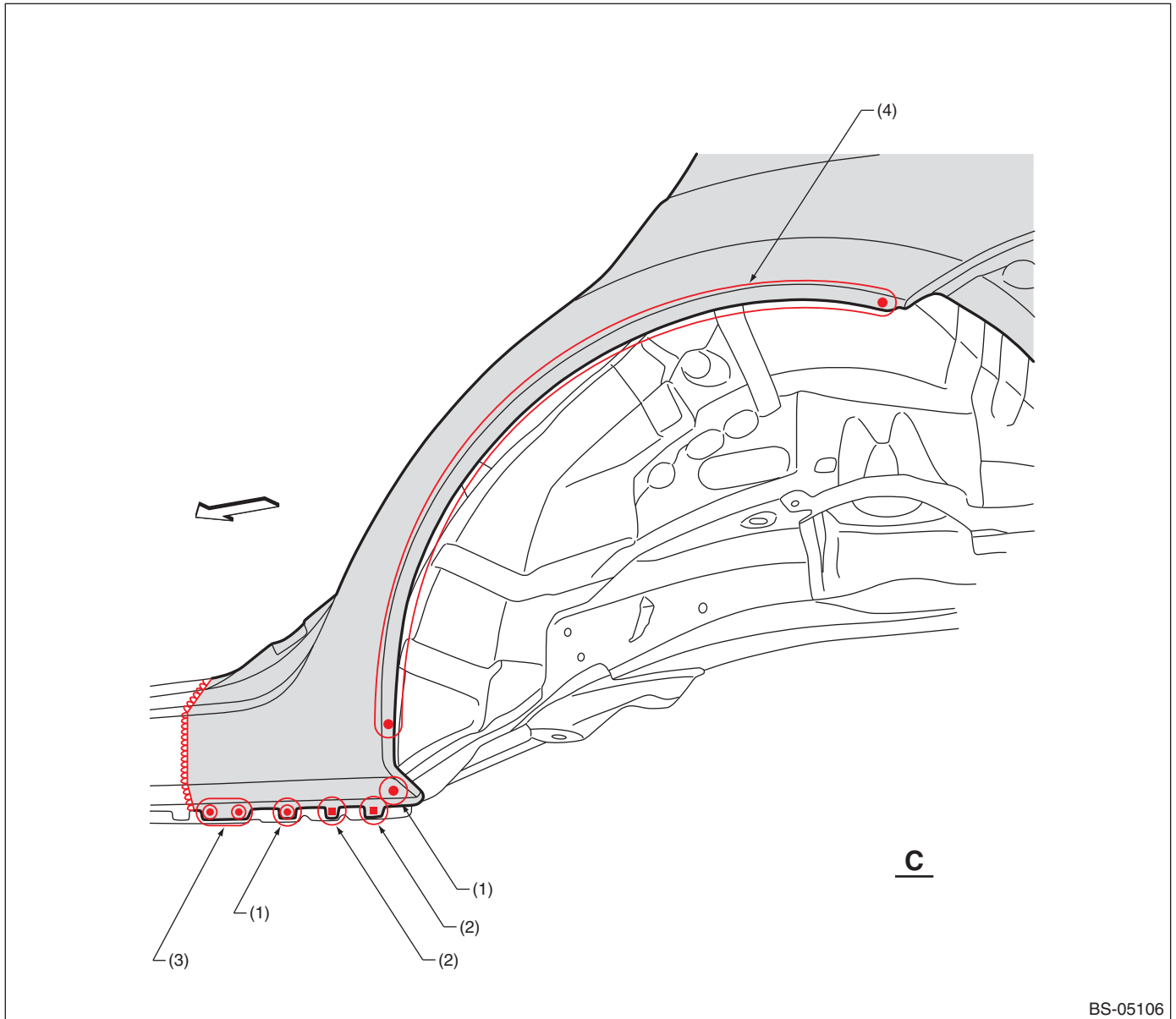
(4) 5 points

(5) 7 points

(6) 8 points

Panel Replacement

• Views 3



BS-05106

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

- (3) 3 points

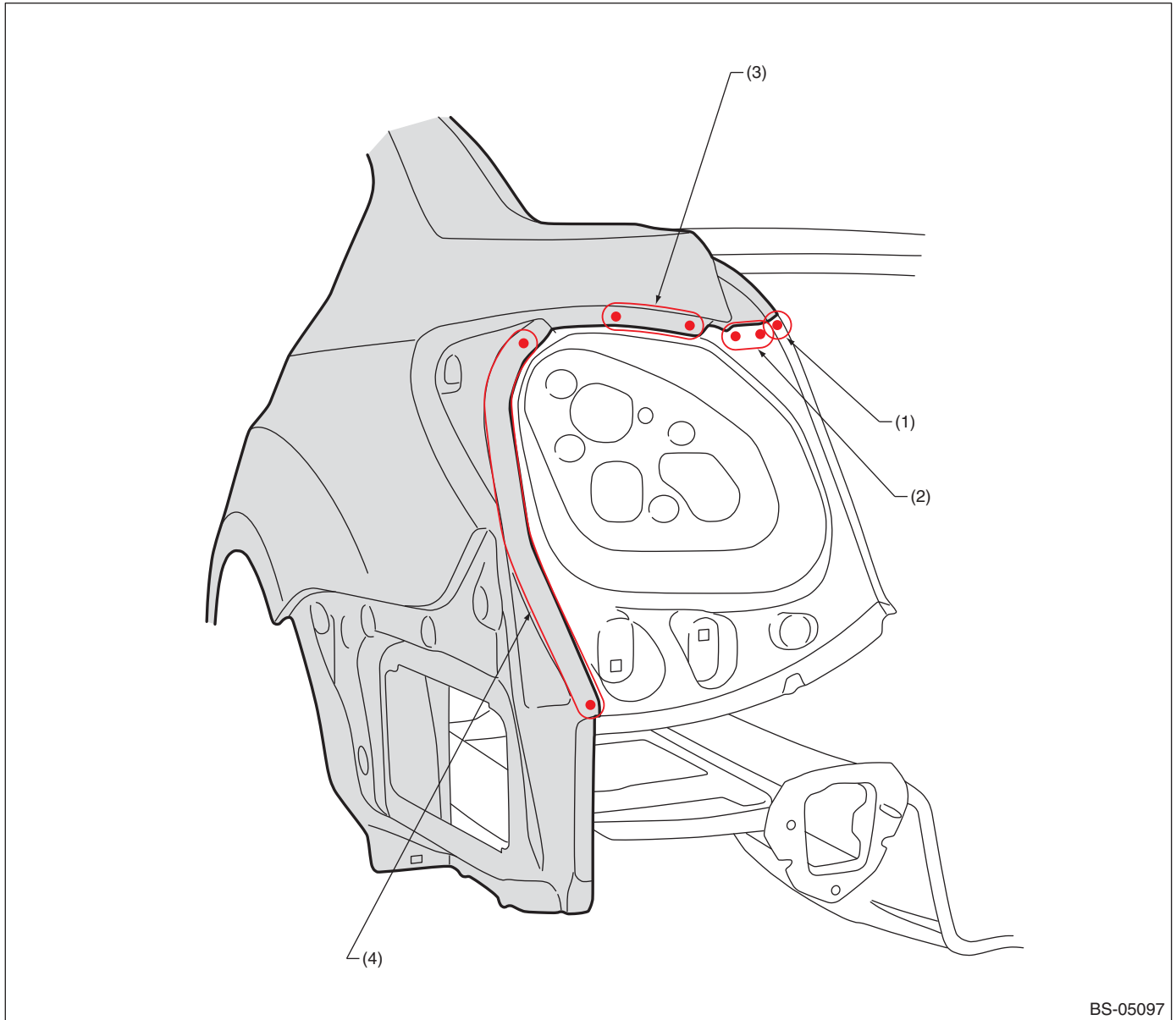
- (4) 13 points

Panel Replacement

7-17. Rear Quarter End Panel (total replacement) / 4 Door

A: REMOVAL

- Rear skirt removal condition



BS-05097

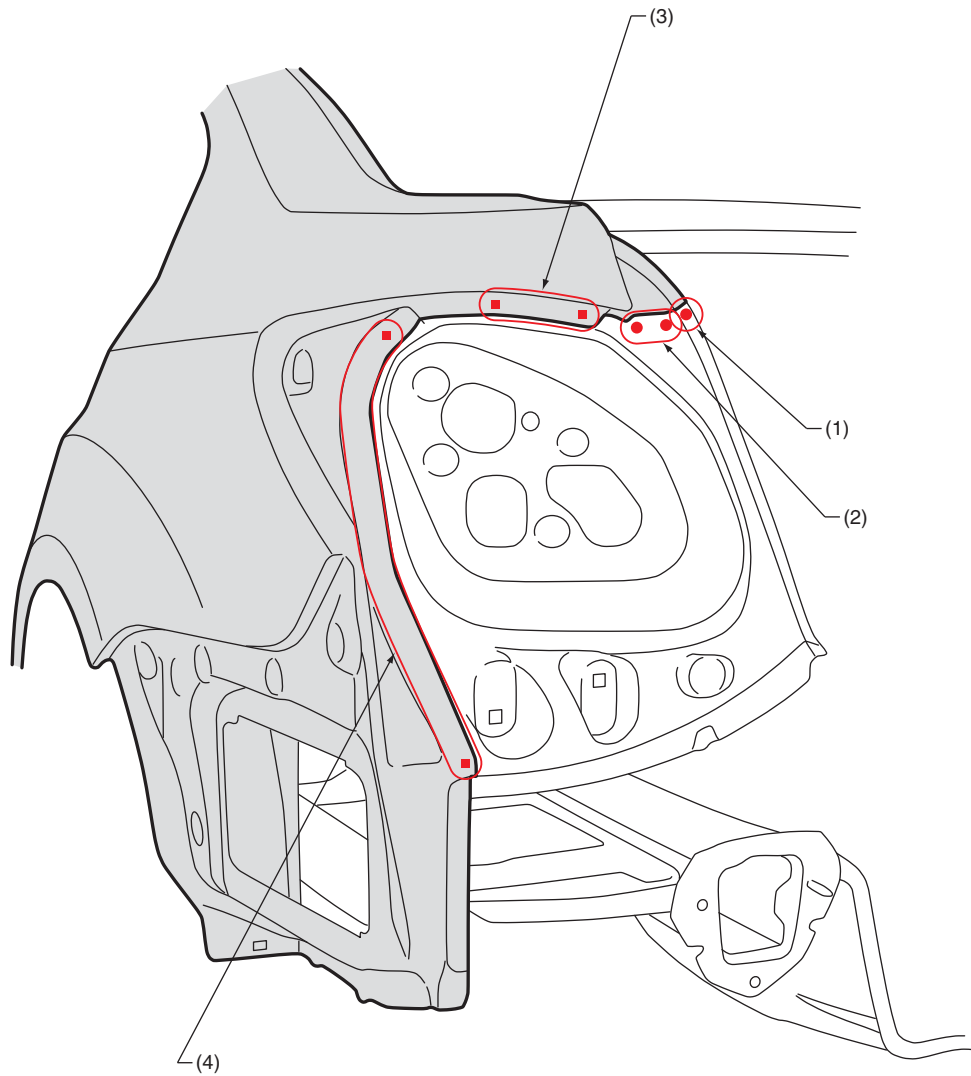
- (1) 1 point (outside · 1)
(2) 2 points (outside · 1)

- (3) 3 points (outside · 1)

- (4) 7 points (outside · 1)

Panel Replacement

B: INSTALLATION



BS-05098

(1) 1 point
(2) 2 points

(3) 3 points

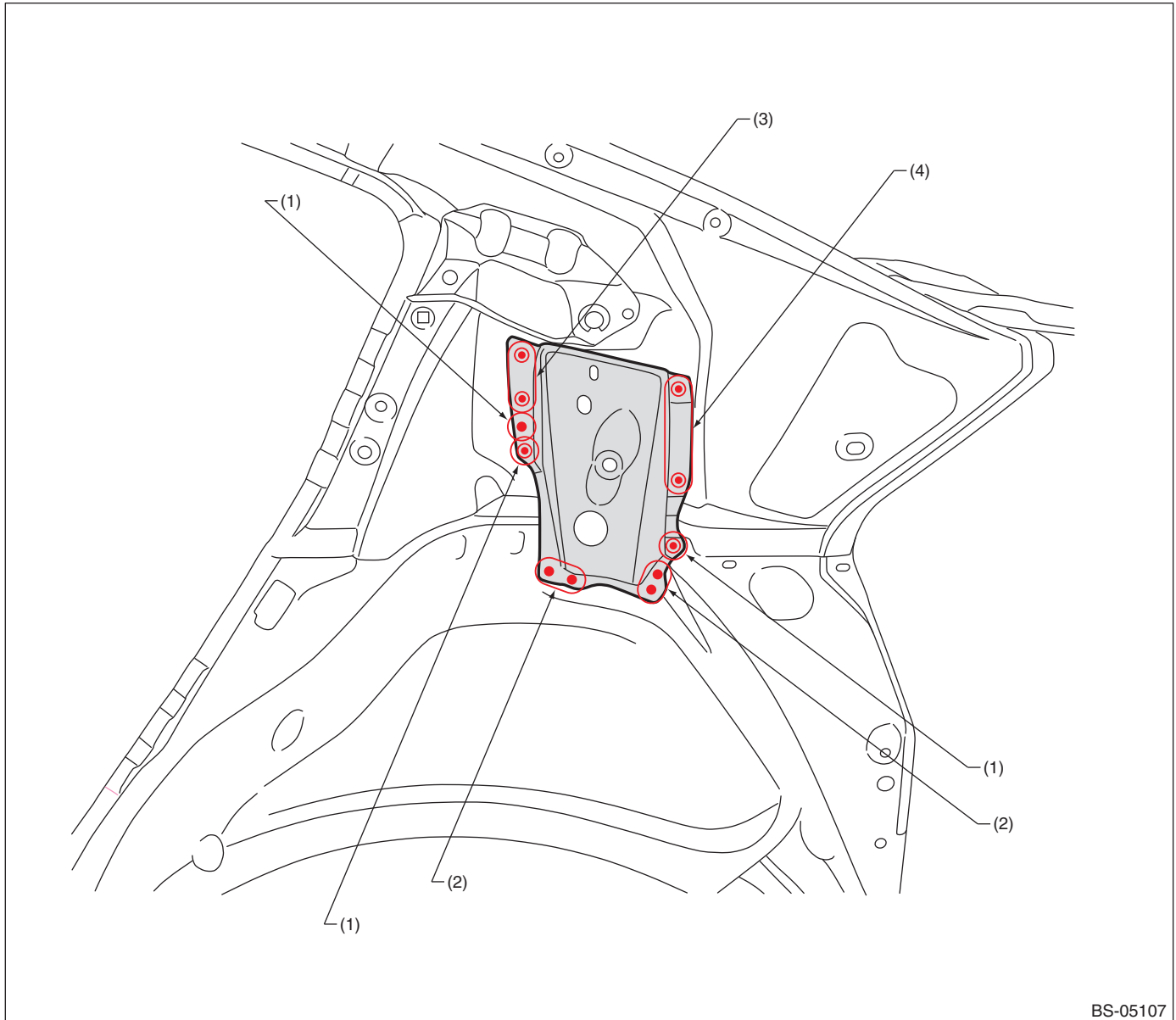
(4) 7 points

Panel Replacement

7-18. Rear Quarter Inner Reinforcement (total replacement) / 4 Door

A: REMOVAL

- Rear quarter removal condition



BS-05107

(1) 1 point (outside · 1)

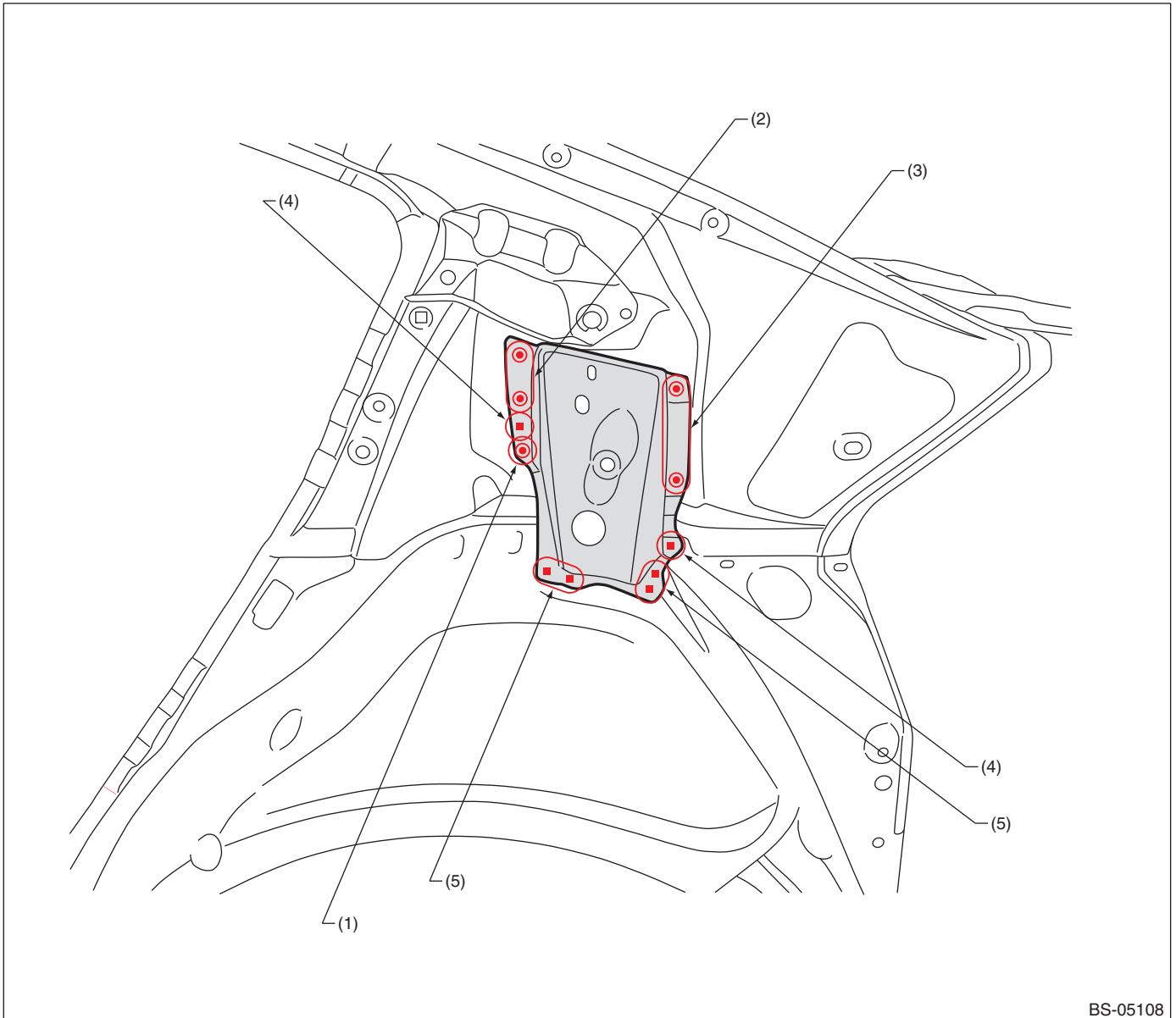
(2) 2 points (top · 1)

(3) 2 points (outside · 1)

(4) 3 points (outside · 1)

Panel Replacement

B: INSTALLATION



BS-05108

(1) 1 point
(2) 2 points

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

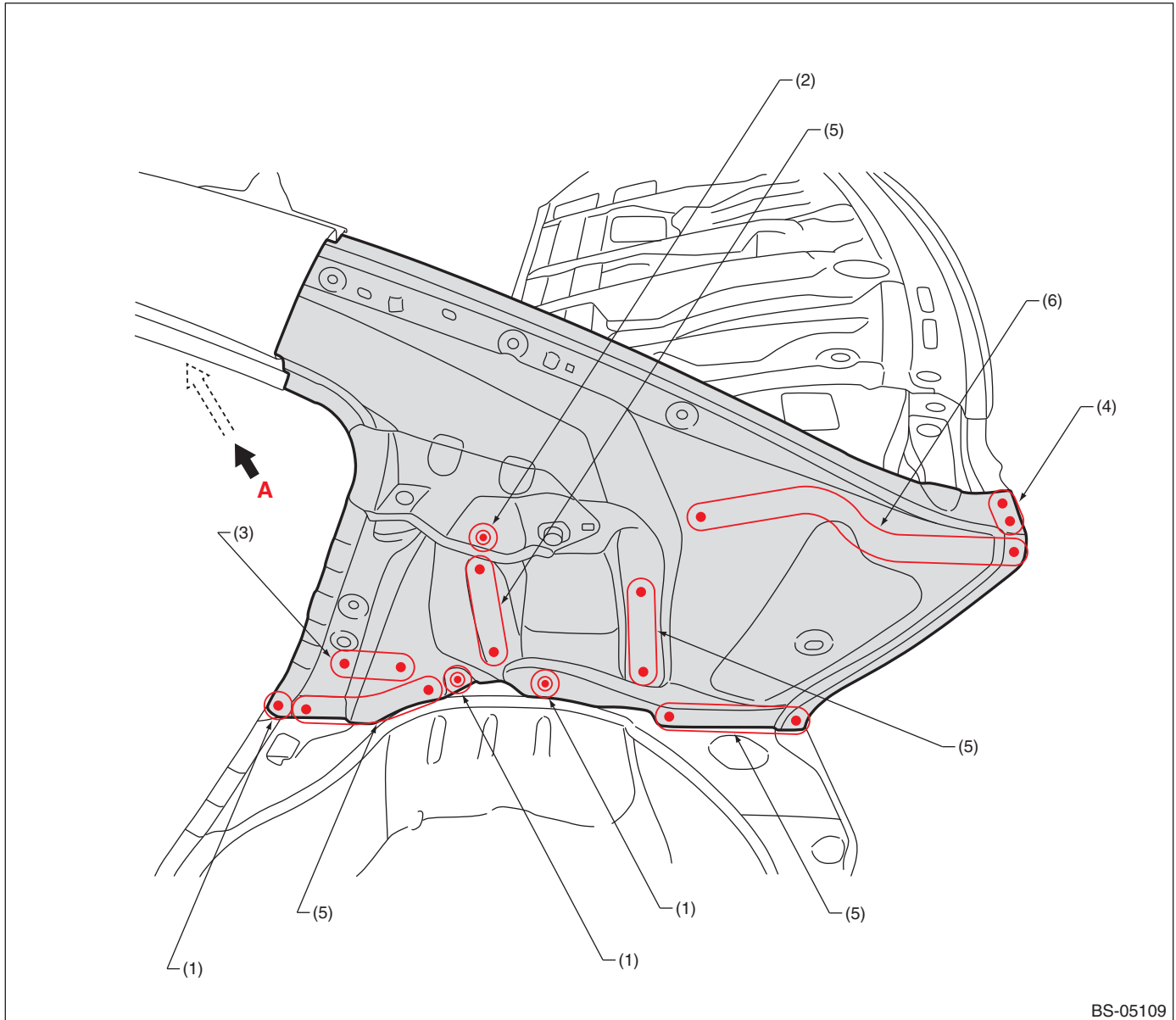
(5) 2 points (service)

Panel Replacement

7-19. Rear Quarter Inner Upper (total replacement) / 4 Door

A: REMOVAL

- Overall view (Rear quarter and reinforcement removal condition)

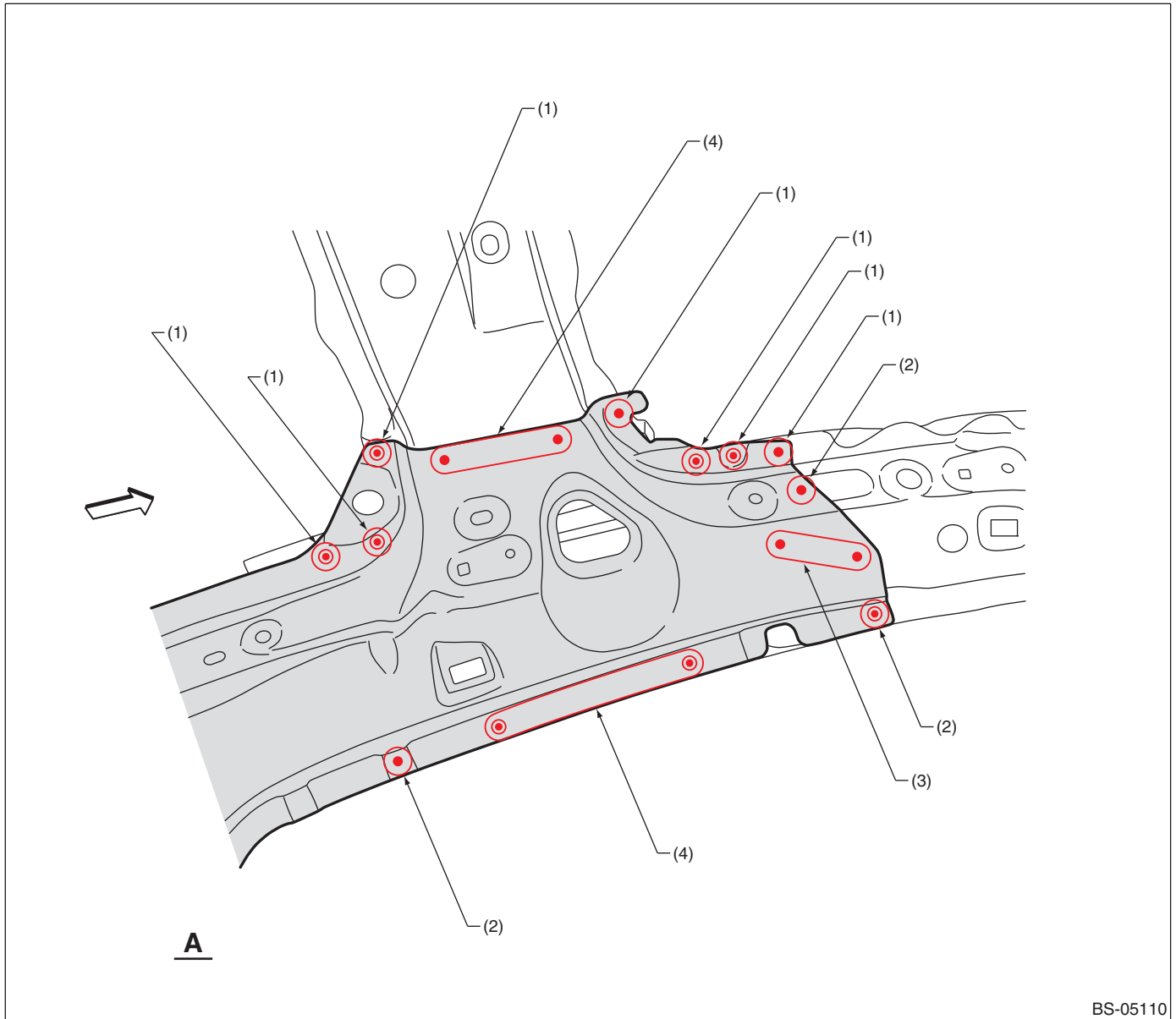


BS-05109

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

Panel Replacement

• Views



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

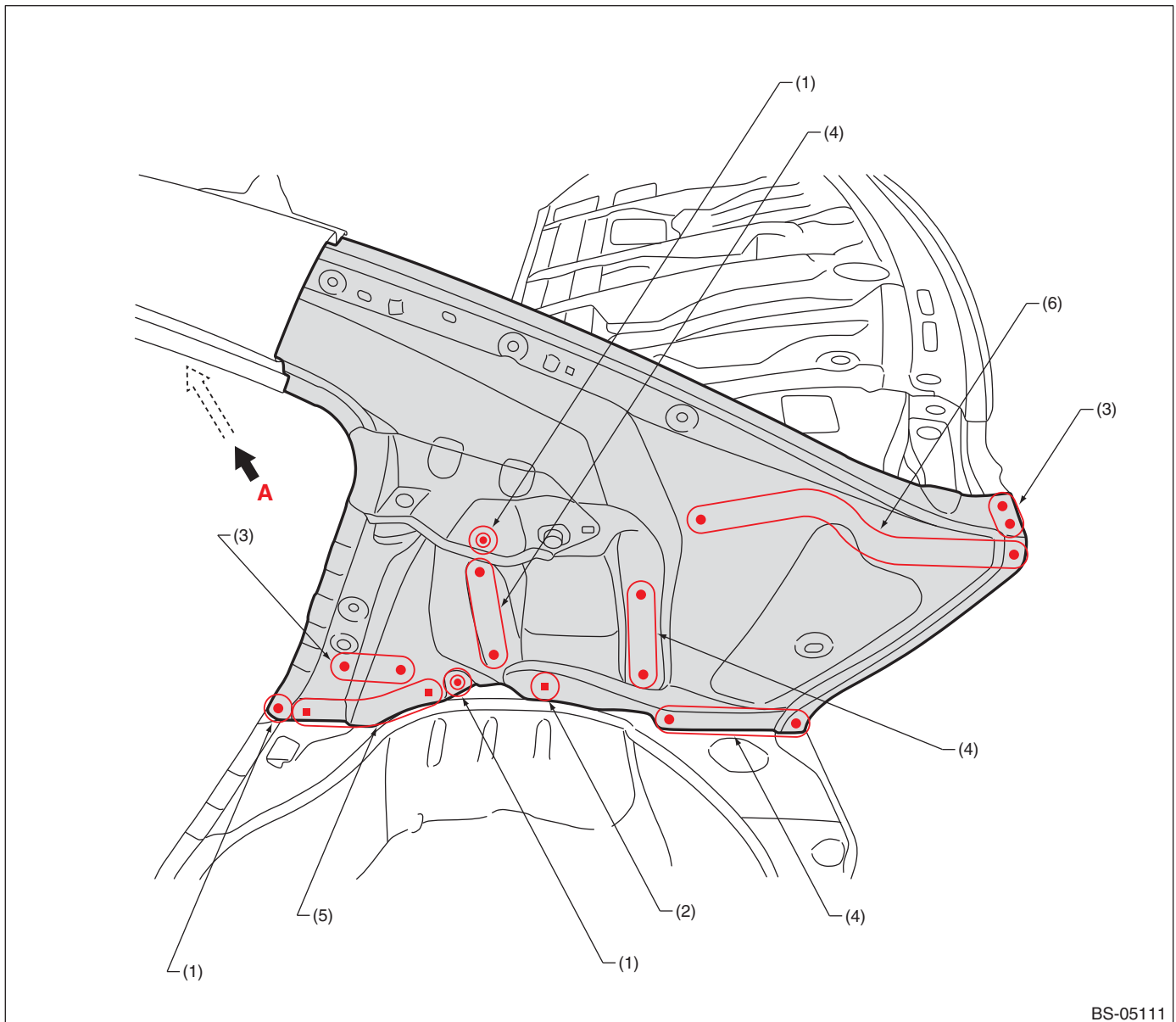
(3) 2 points (inside · 1)

(4) 3 points (inside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BS-05111

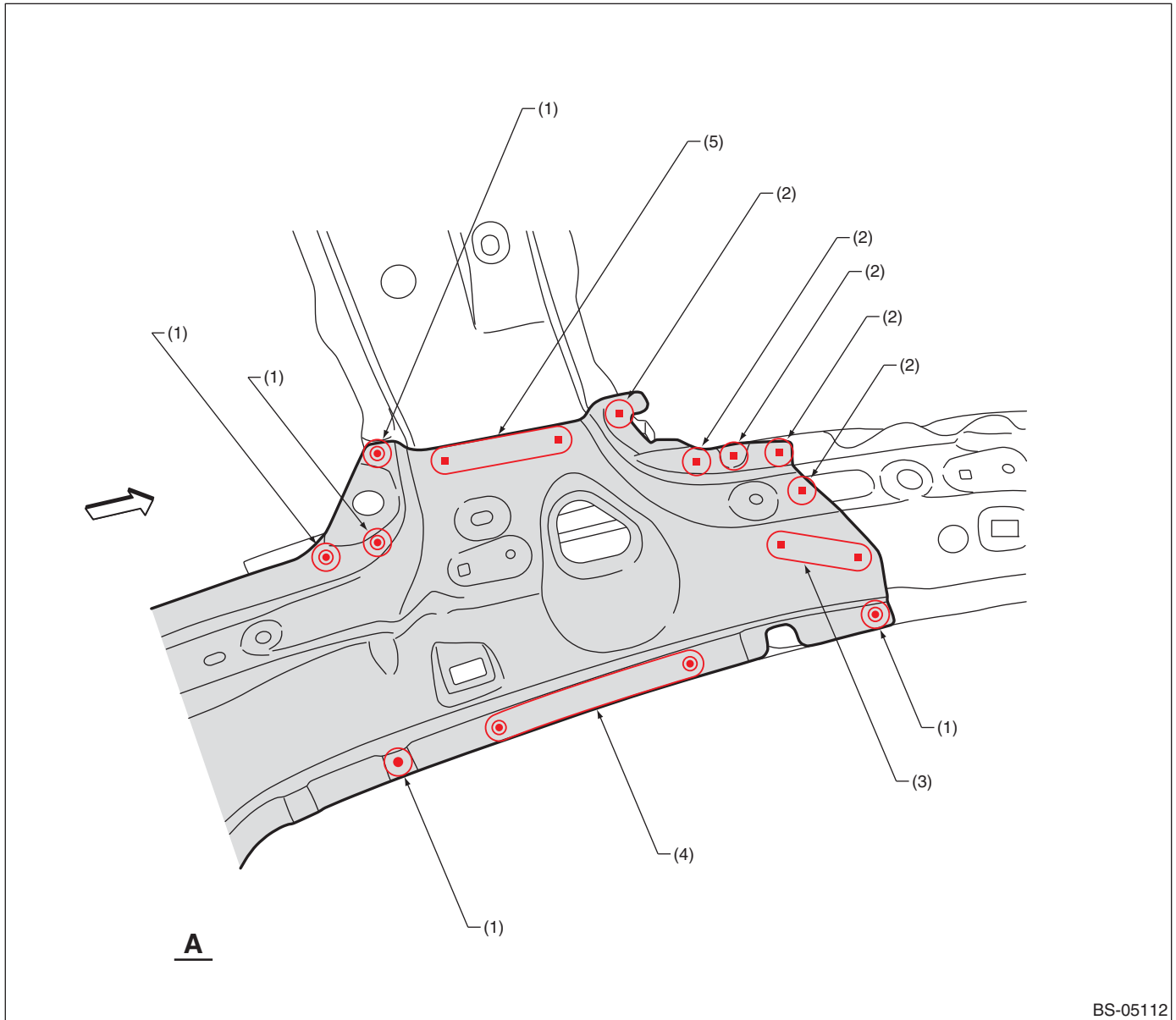
(1) 1 point
(2) 1 point (service)

(3) 2 points
(4) 3 points

(5) 3 points (service)
(6) 8 points

Panel Replacement

• Views



(1) 1 point
(2) 1 point (service)

(3) 2 points (service)
(4) 3 points

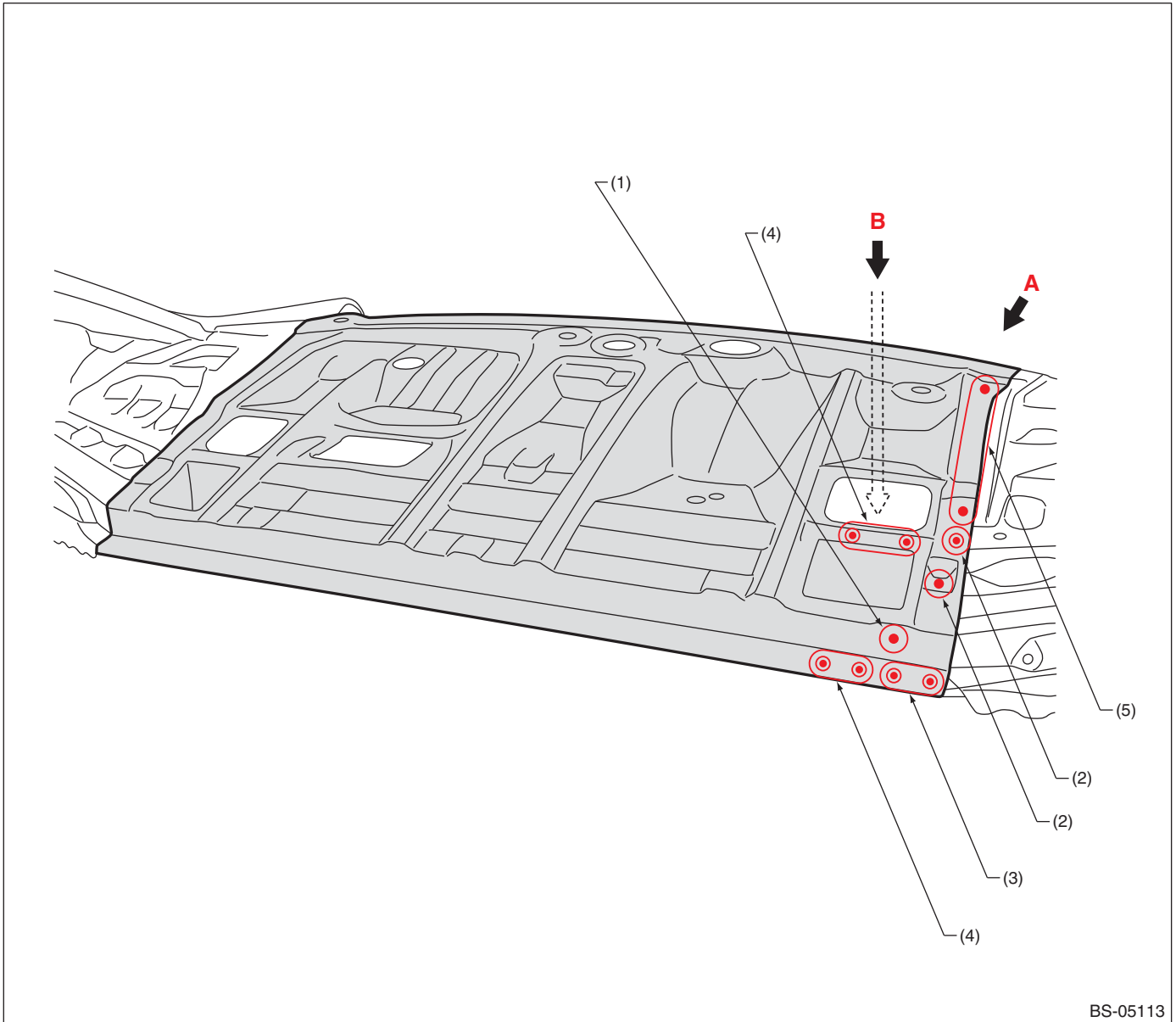
(5) 3 points (service)

Panel Replacement

7-20. Rear Panel (total replacement) / 4 Door

A: REMOVAL

• Overall view



(1) 1 point (inside · 1)

(2) 1 point (top · 1)

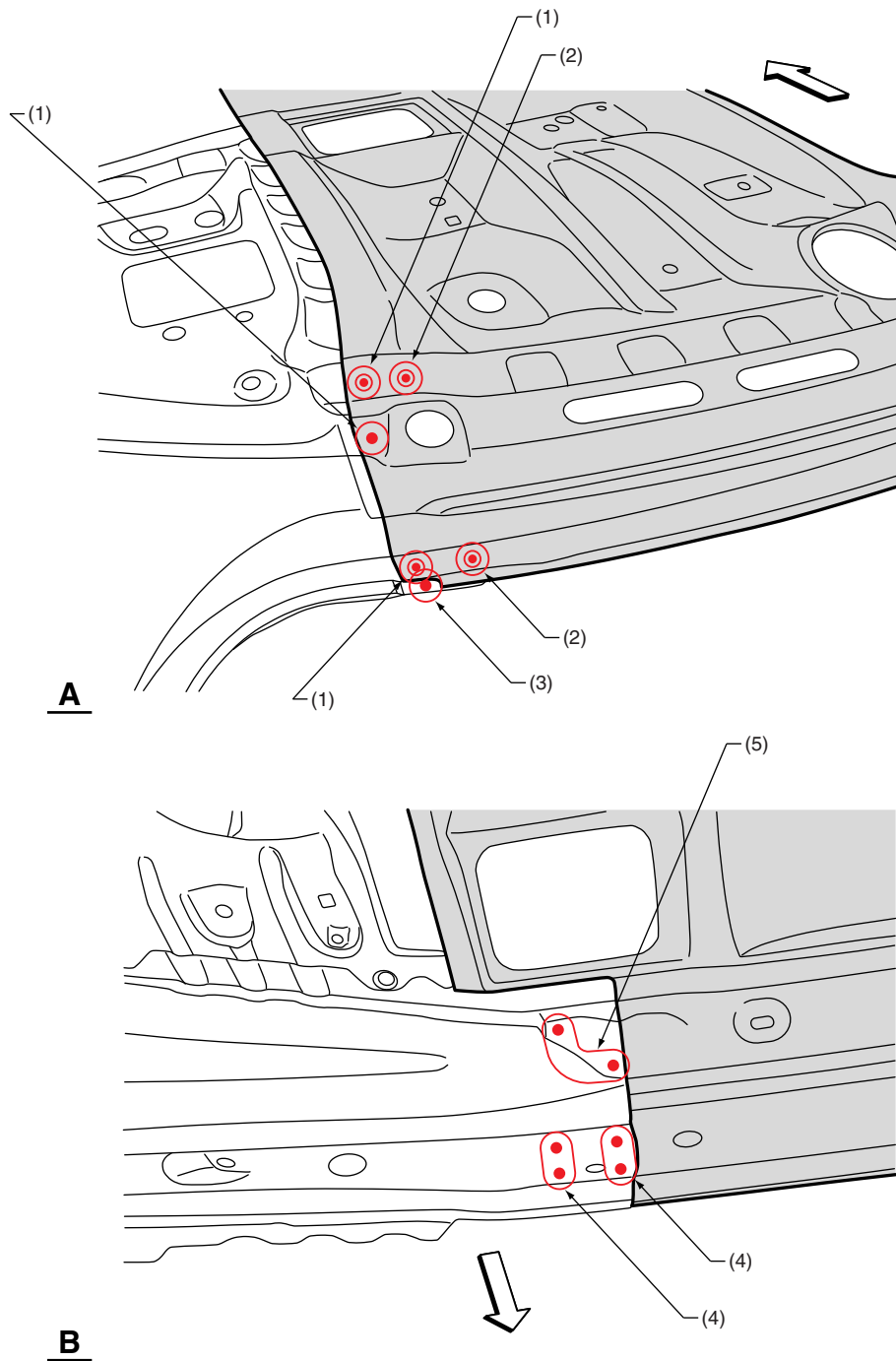
(3) 2 points (top · 1)

(4) 2 points (top · 2)

(5) 6 points (top · 1)

Panel Replacement

• Views



BS-05114

(1) 1 point (top · 1)
(2) 1 point (top · 2)

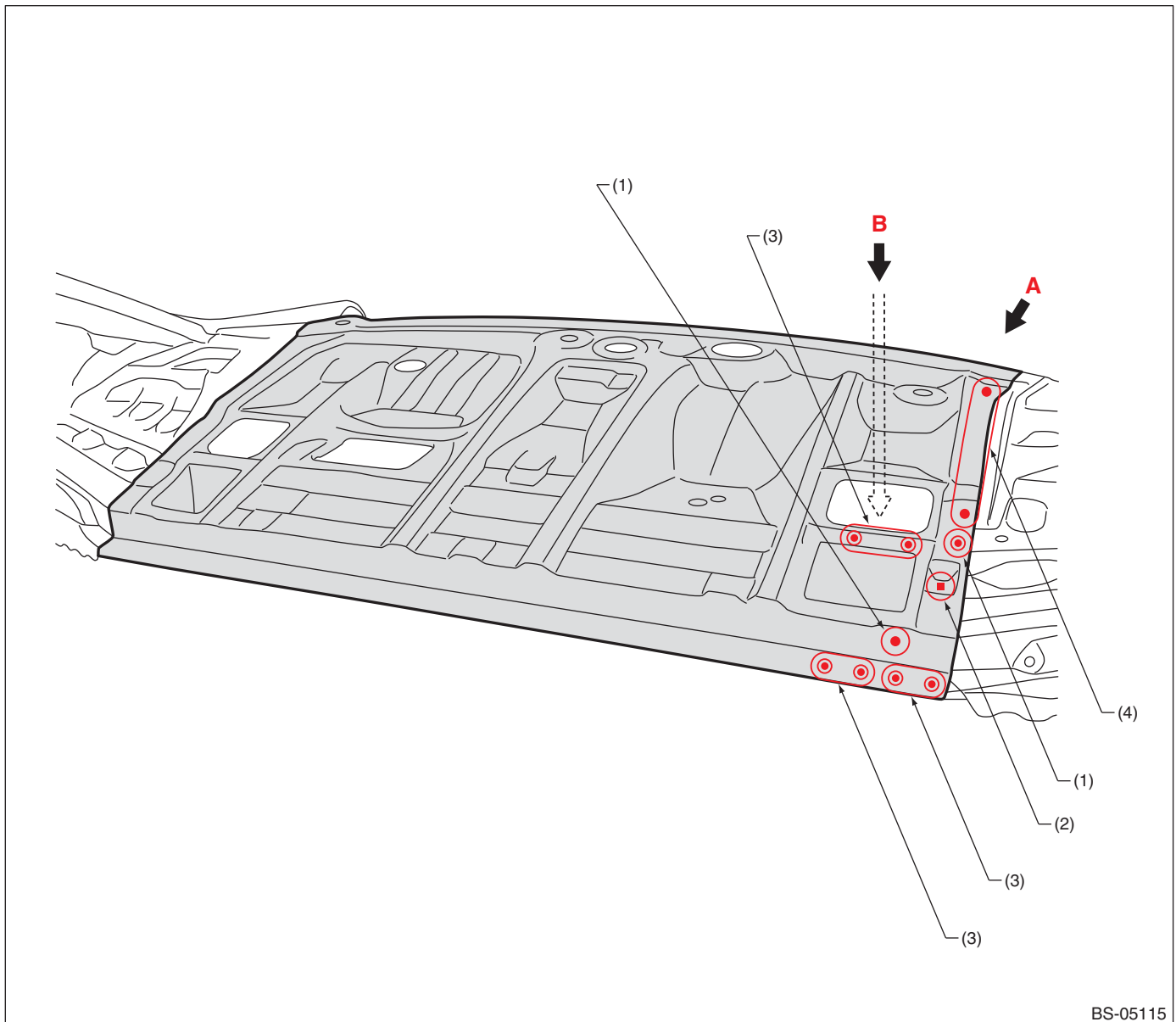
(3) 1 point (outside · 1)
(4) 2 points (top · 1)

(5) 3 points (outside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BS-05115

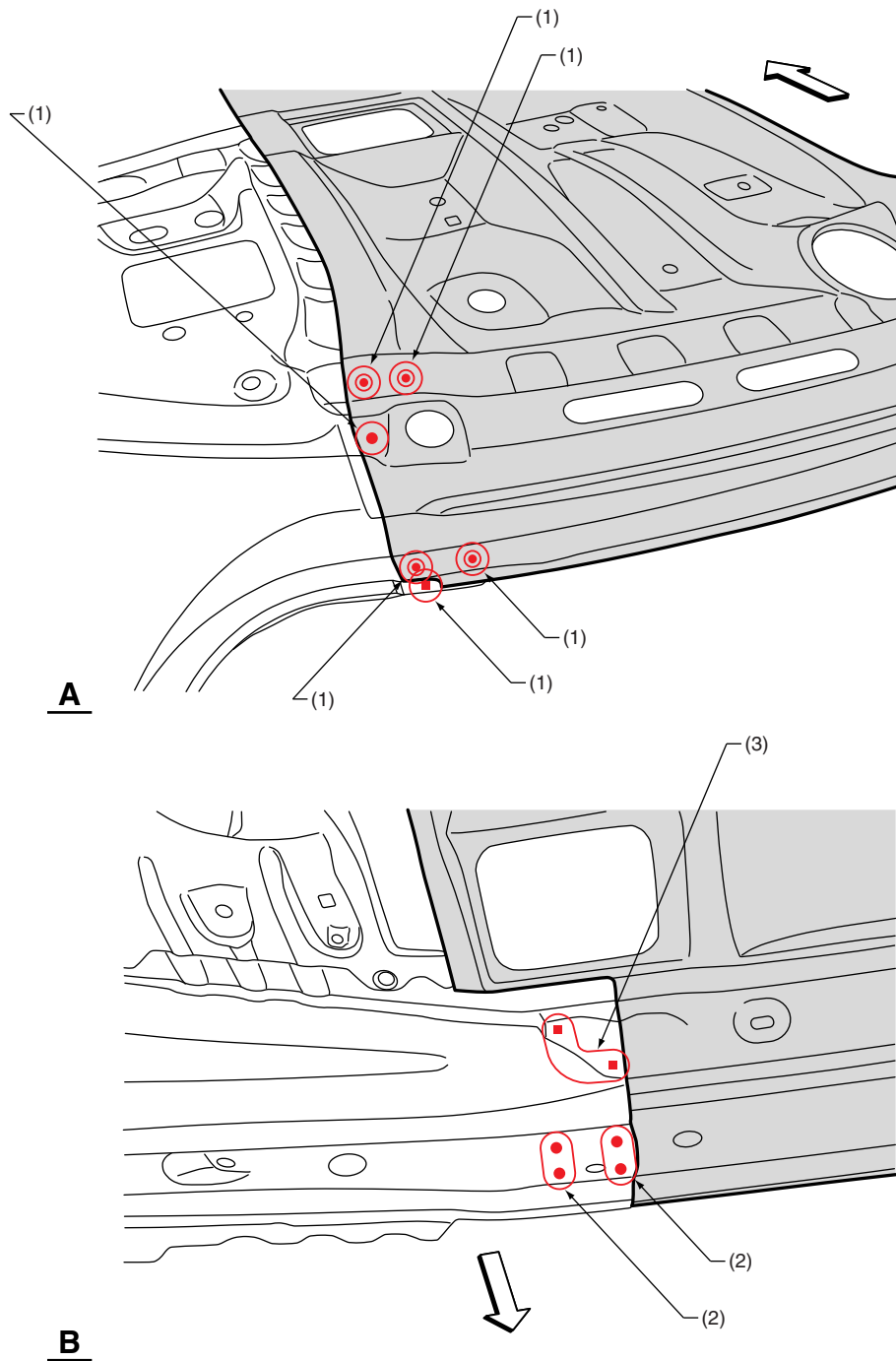
- (1) 1 point
- (2) 1 point (service)

- (3) 2 points

- (4) 6 points

Panel Replacement

• Views



BS-05116

(1) 1 point

(2) 2 points

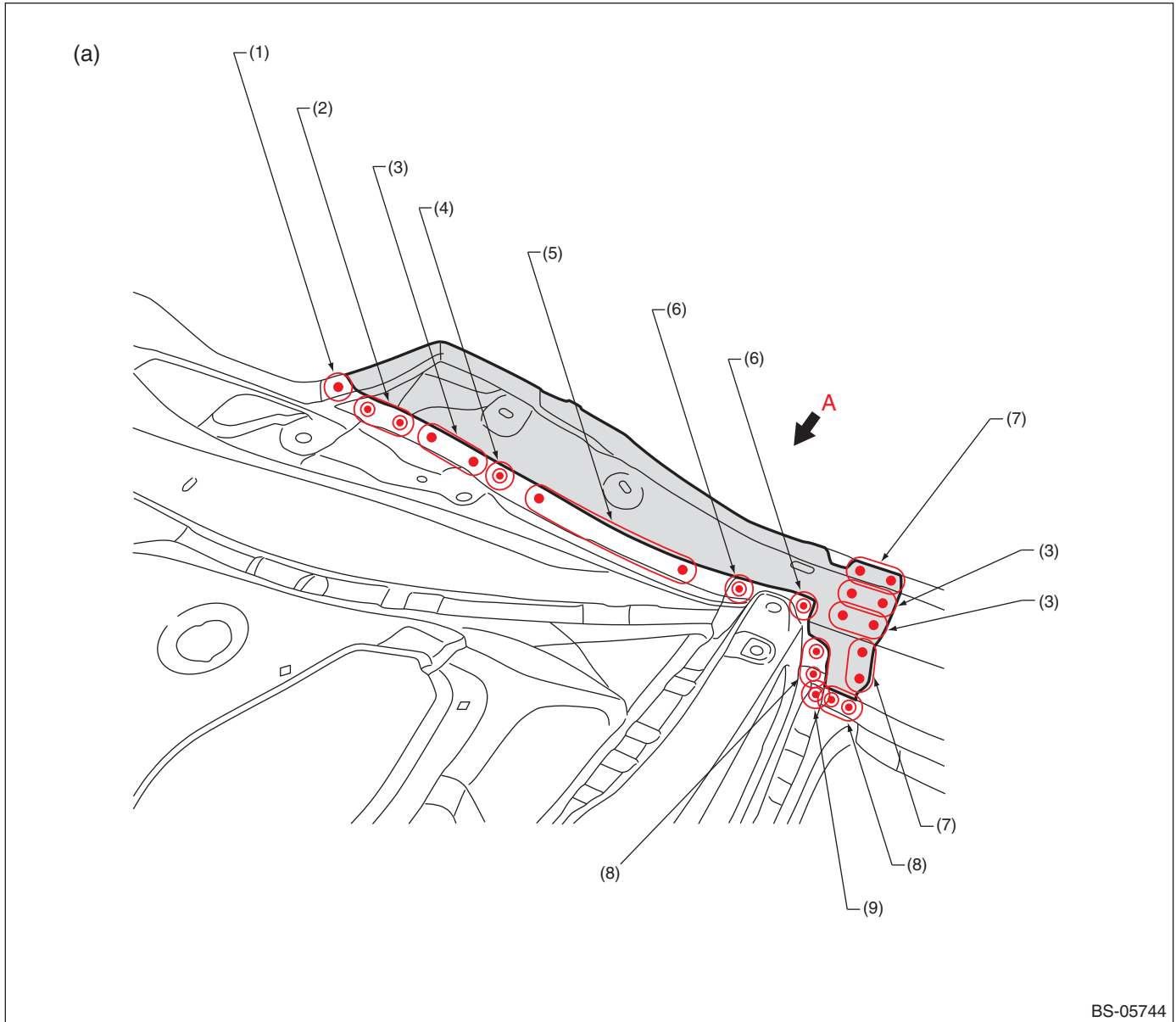
(3) 3 points

Panel Replacement

7-21. Side Sill Inner Rear (total replacement)

A: REMOVAL

- Overall view (Rear quarter outer & inner, side sill reinforcement removal condition)



BS-05744

(a) Except for XV model

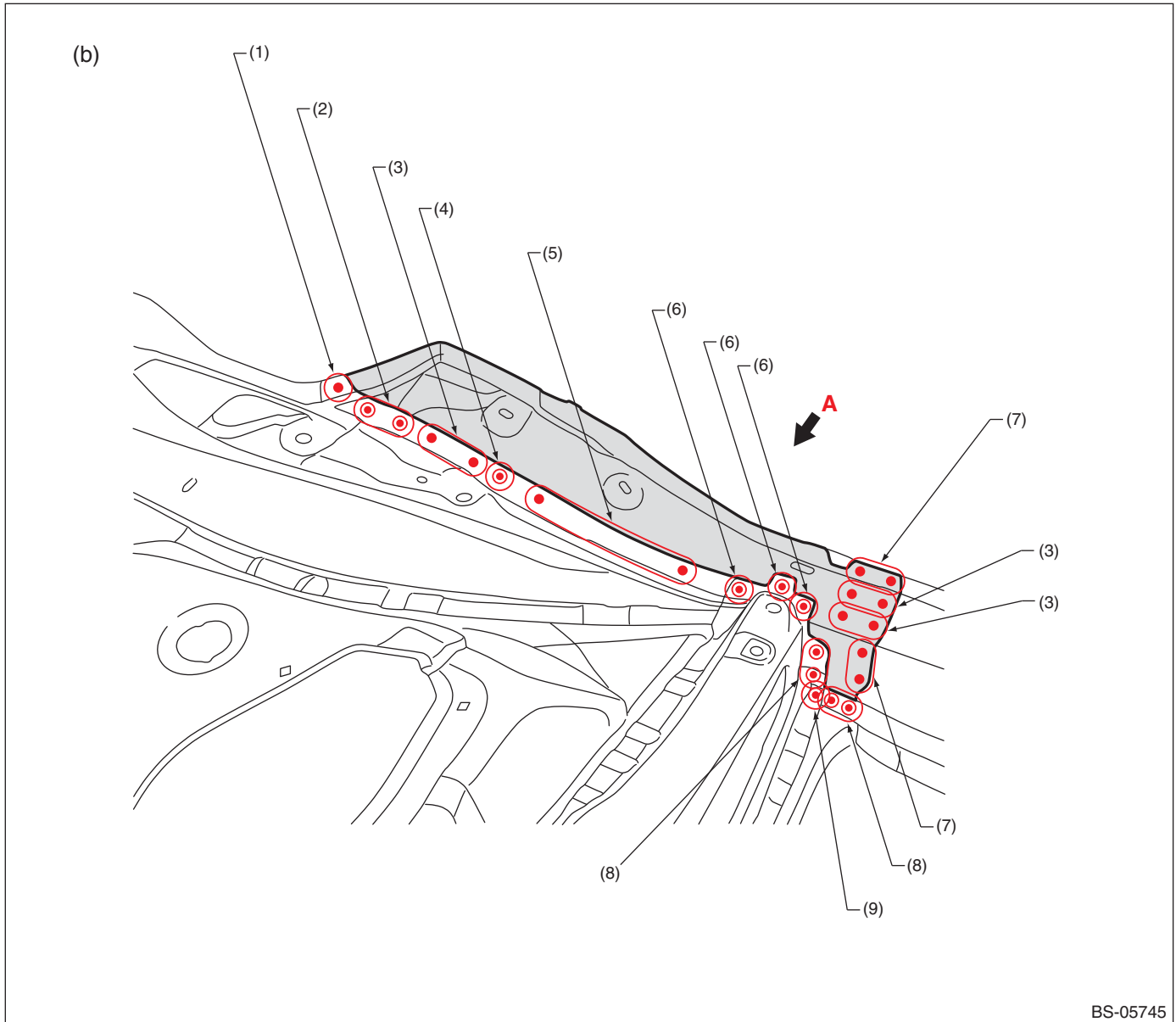
- (1) 1 point (outside · 1)
- (2) 2 points (bottom · 1)
- (3) 2 points (top · 1)

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

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

Panel Replacement

• Overall view (Rear quarter outer & inner, side sill reinforcement removal condition)



(b) XV model

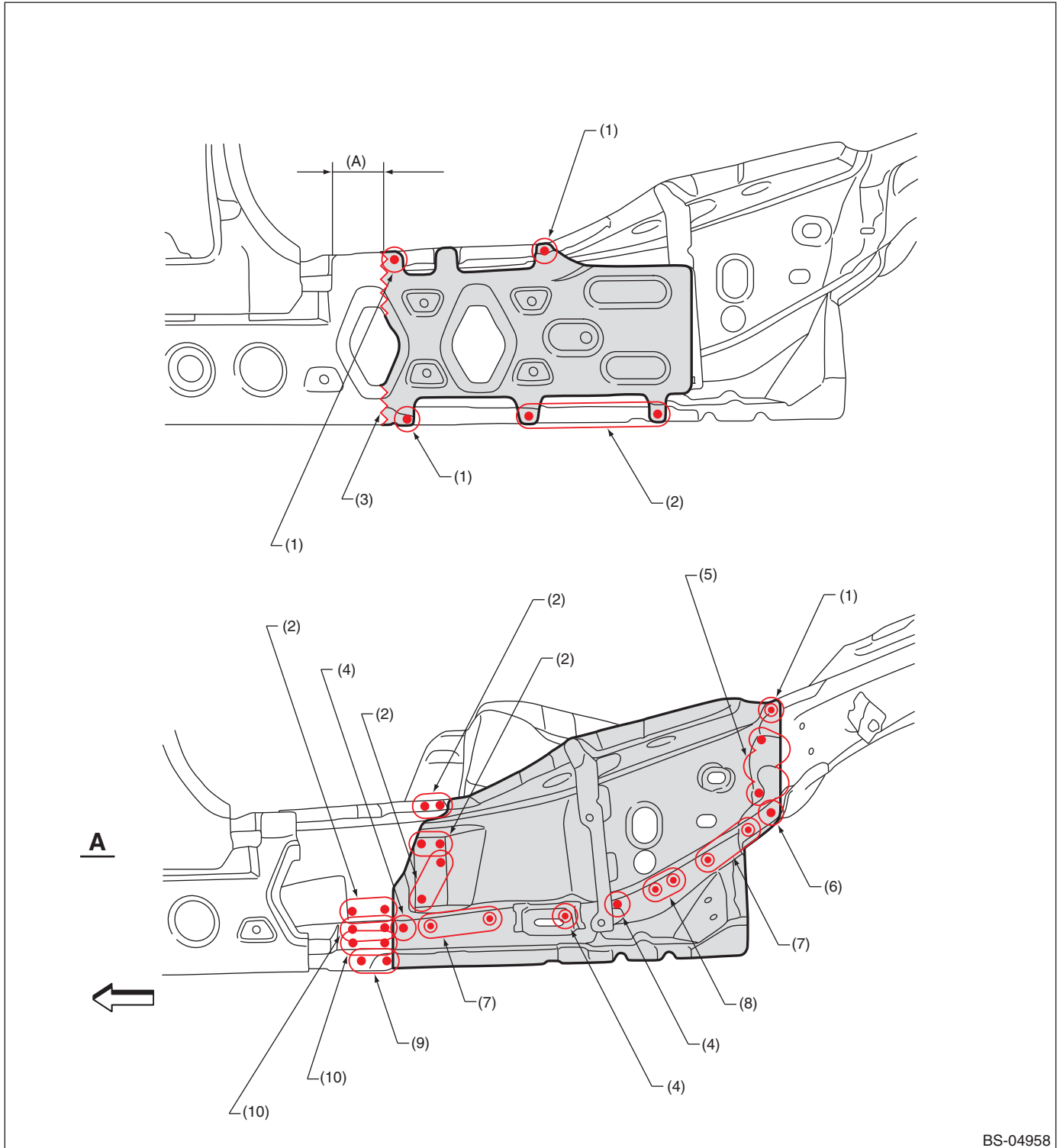
- (1) 1 point (outside · 1)
- (2) 2 points (bottom · 1)
- (3) 2 points (top · 1)

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

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

Panel Replacement

• Views



BS-04958

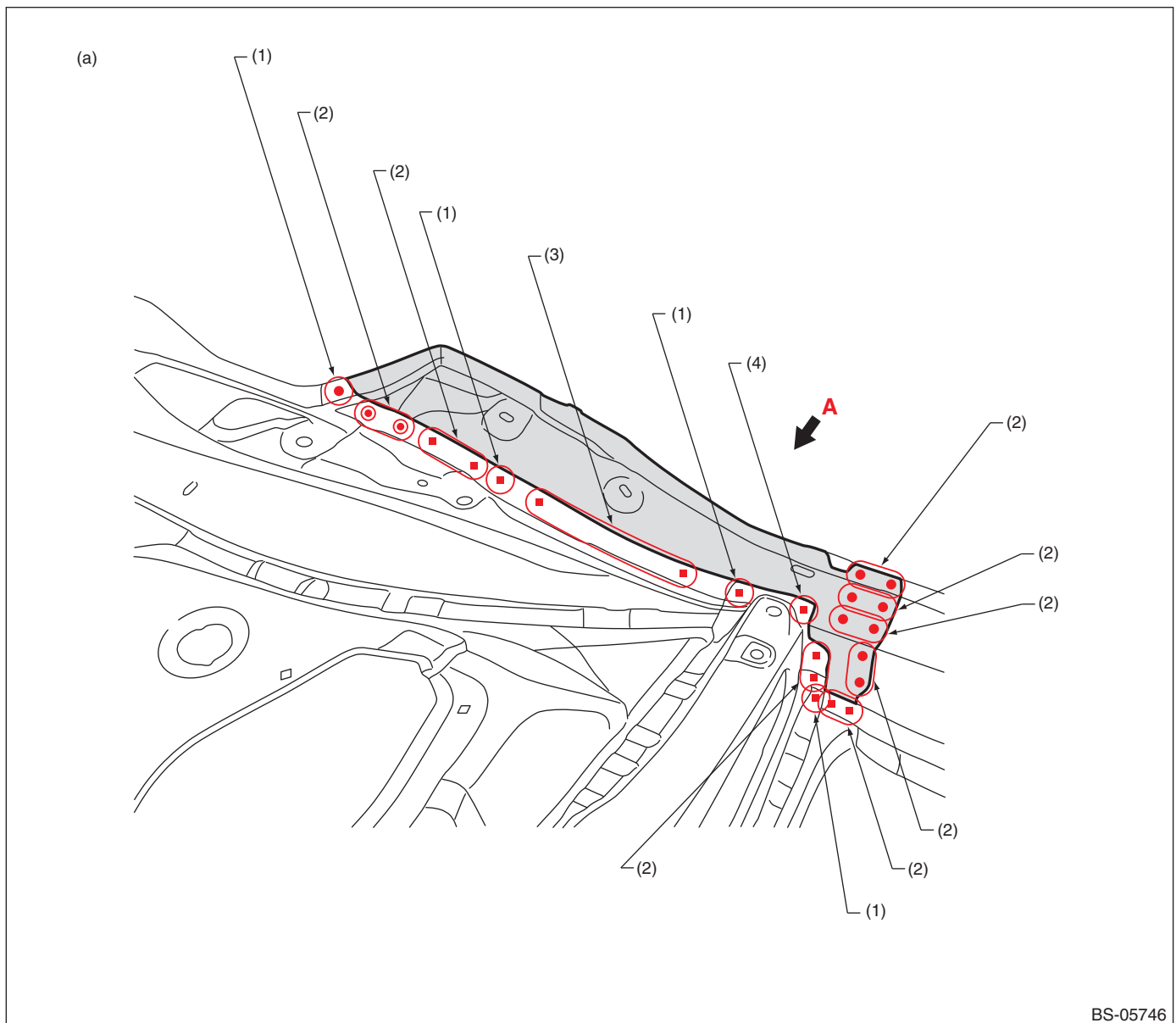
(A) 60 mm (2.36 in)

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

Panel Replacement

B: INSTALLATION

• Overall view



(a) Except for XV model

(1) 1 point

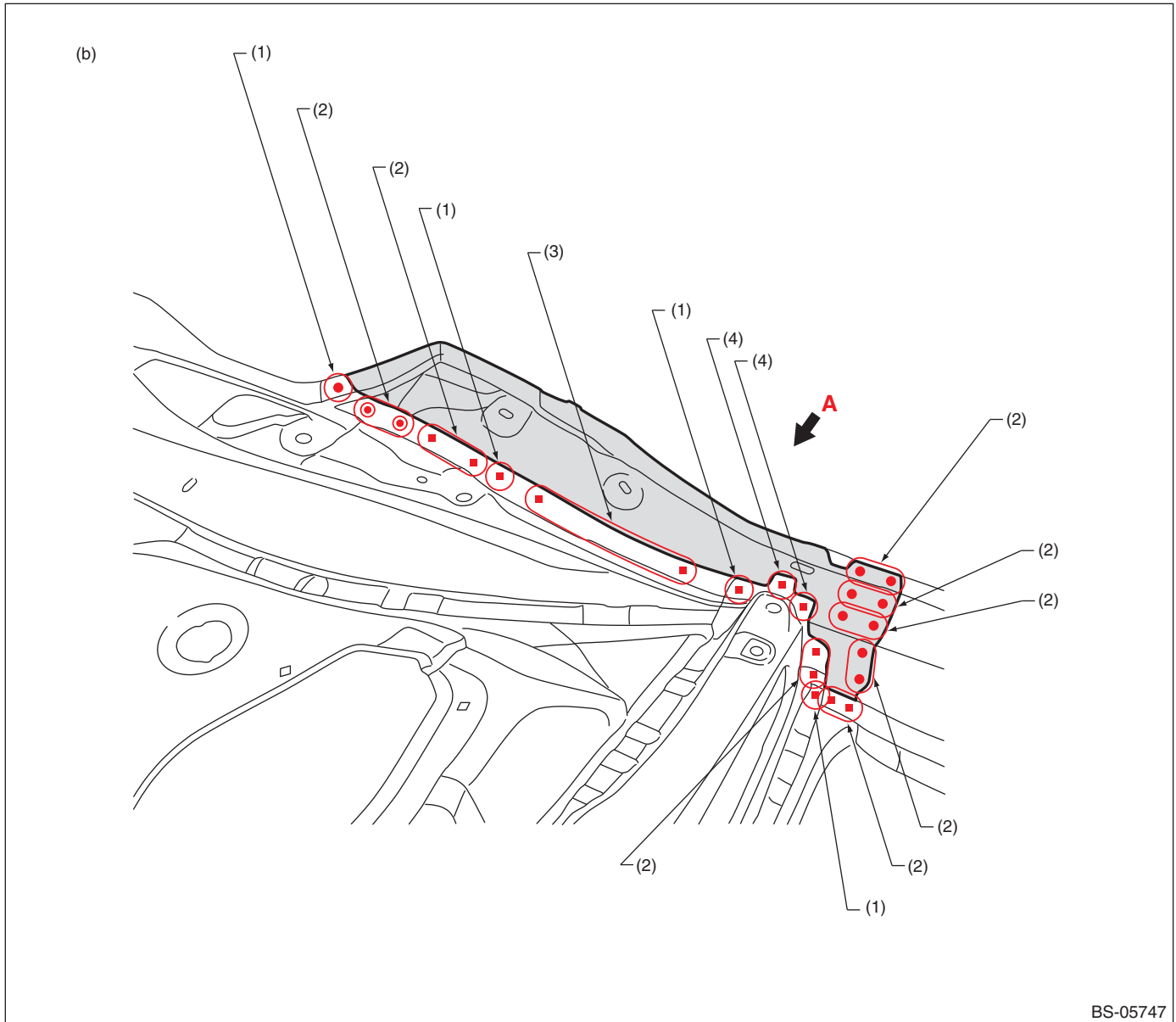
(2) 2 points

(3) 3 points

(4) 1 point (service - matching)

Panel Replacement

• Overall view



(b) XV model

(1) 1 point

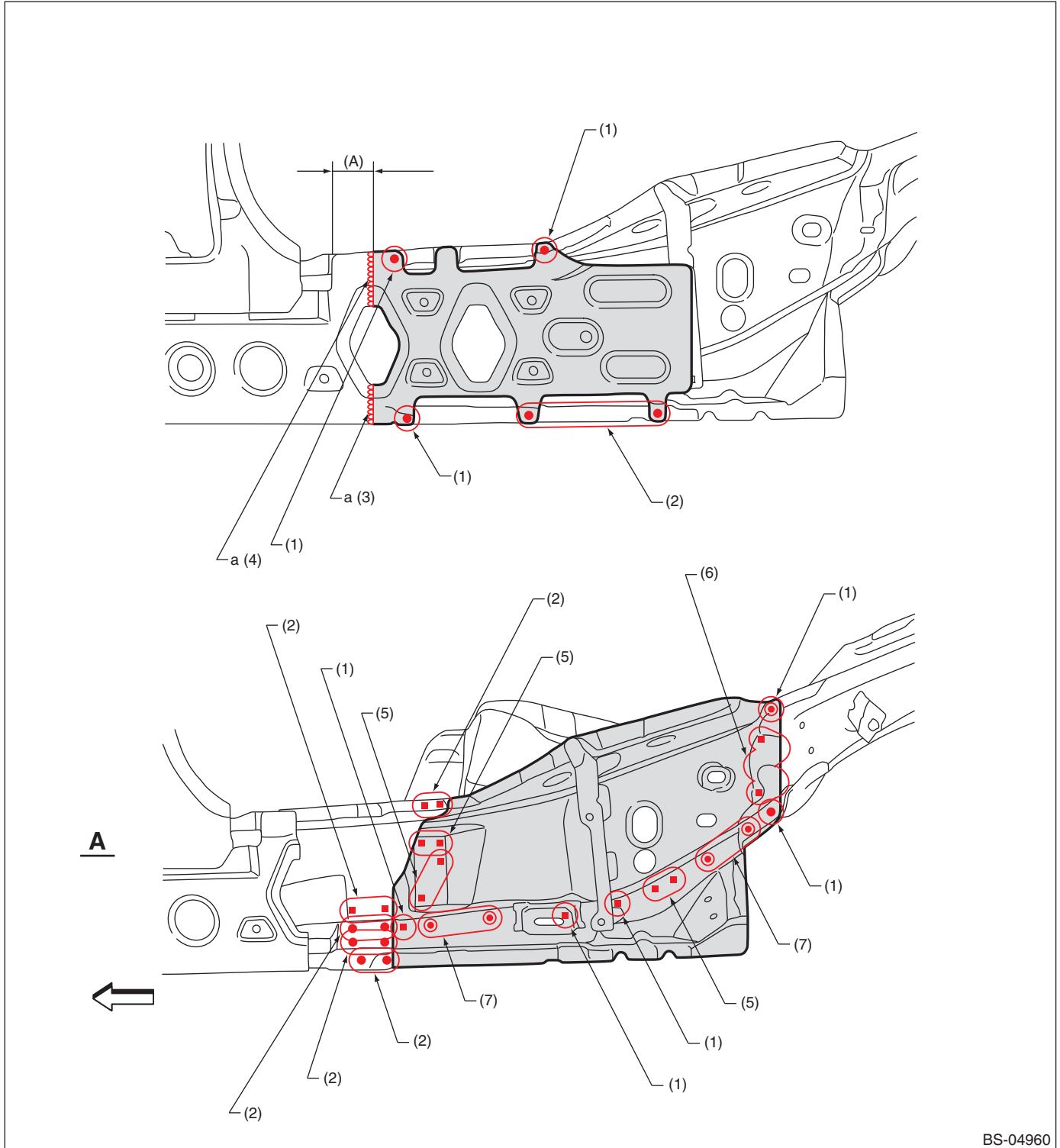
(2) 2 points

(3) 3 points

(4) 1 point (service · matching)

Panel Replacement

• Views



BS-04960

(A) 40 mm (1.57 in)

- | | | |
|-------------------------------|-------------------------------|--------------|
| (1) 1 point | (4) 1 point [60 mm (2.36 in)] | (7) 3 points |
| (2) 2 points | (5) 2 points (service) | |
| (3) 1 point [45 mm (1.77 in)] | (6) 5 points (service) | |

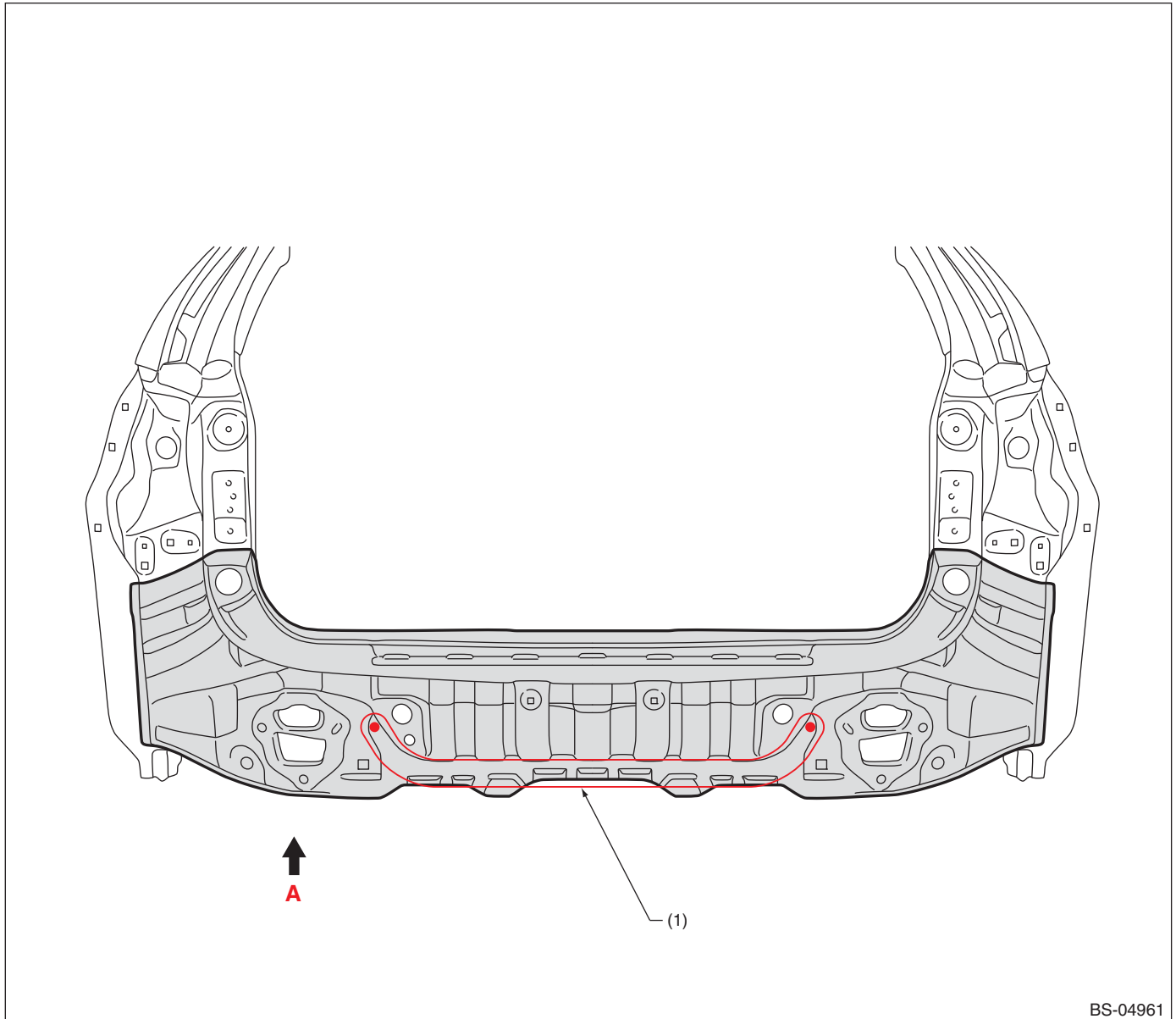
For part marked by “a”: Anticorrosion wax shall be applied thoroughly on the back side of continuous welding portion.

Panel Replacement

7-22. Rear Skirt (total replacement) / 5 Door

A: REMOVAL

• Overall view

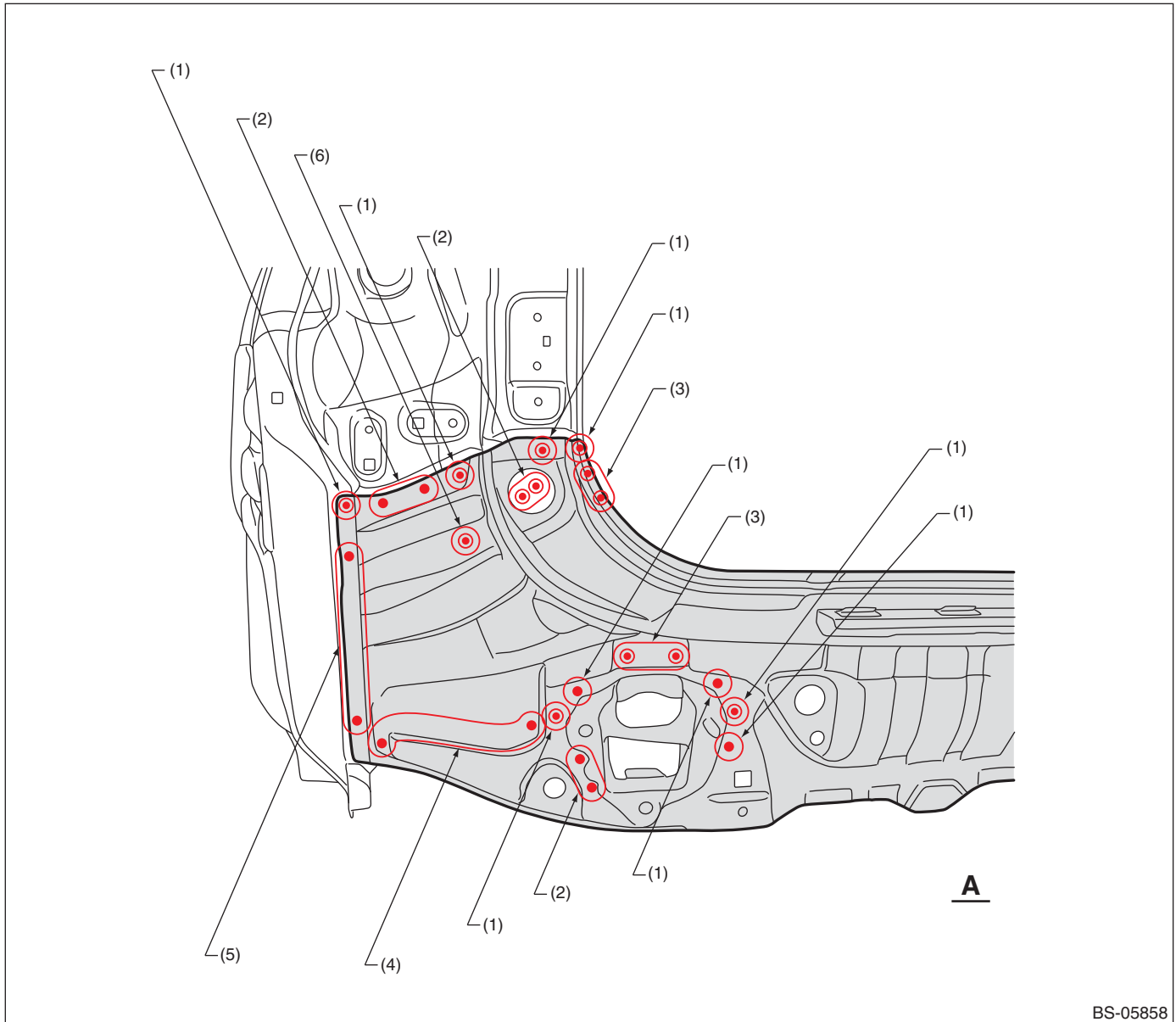


BS-04961

(1) 14 points (outside · 1)

Panel Replacement

• Views

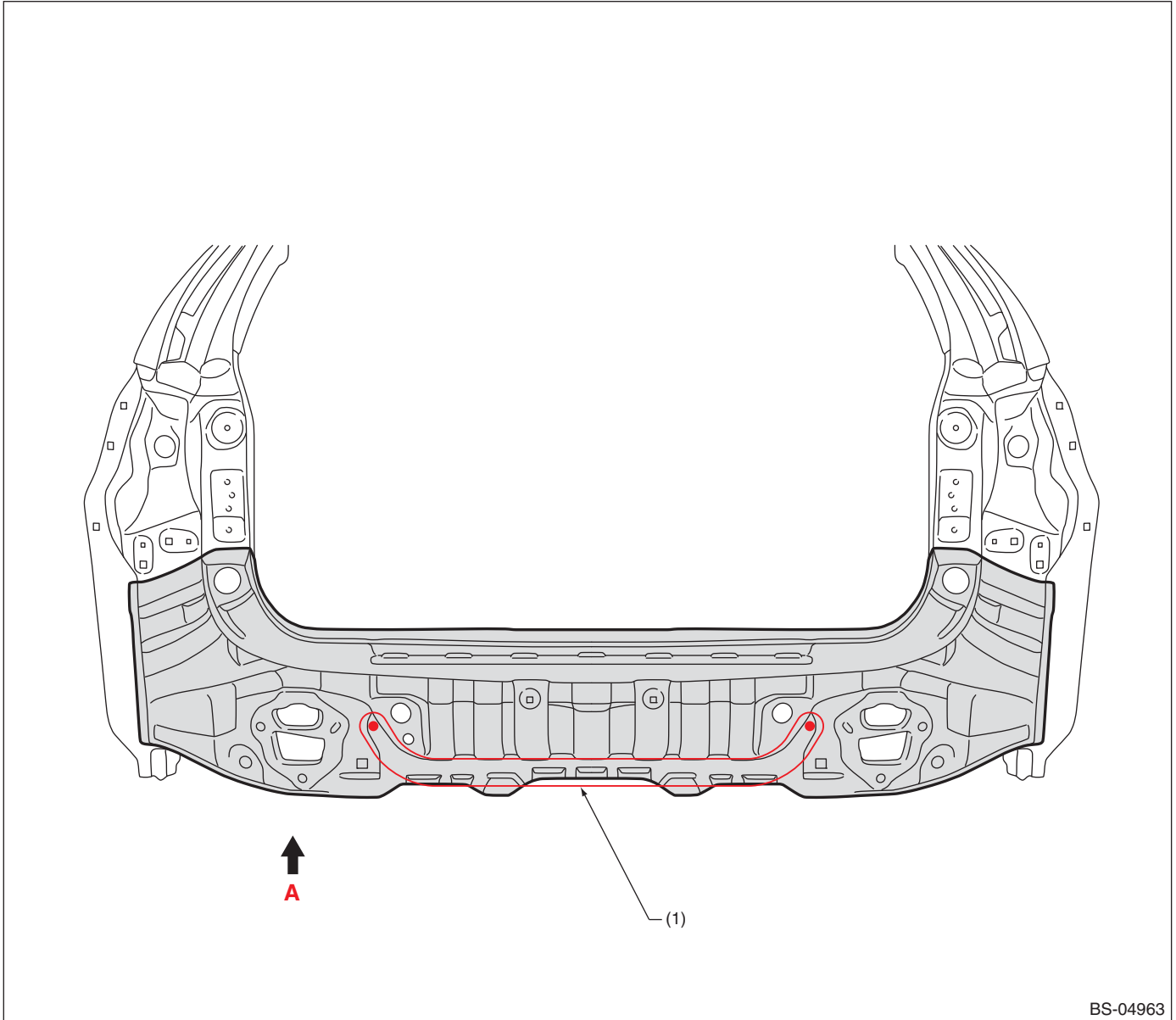


- | | | |
|----------------------------|----------------------------|----------------------------|
| (1) 1 point (outside · 1) | (3) 2 points (outside · 2) | (5) 3 points (outside · 1) |
| (2) 2 points (outside · 1) | (4) 5 points (outside · 1) | (6) 1 point (outside · 2) |

Panel Replacement

B: INSTALLATION

• Overall view

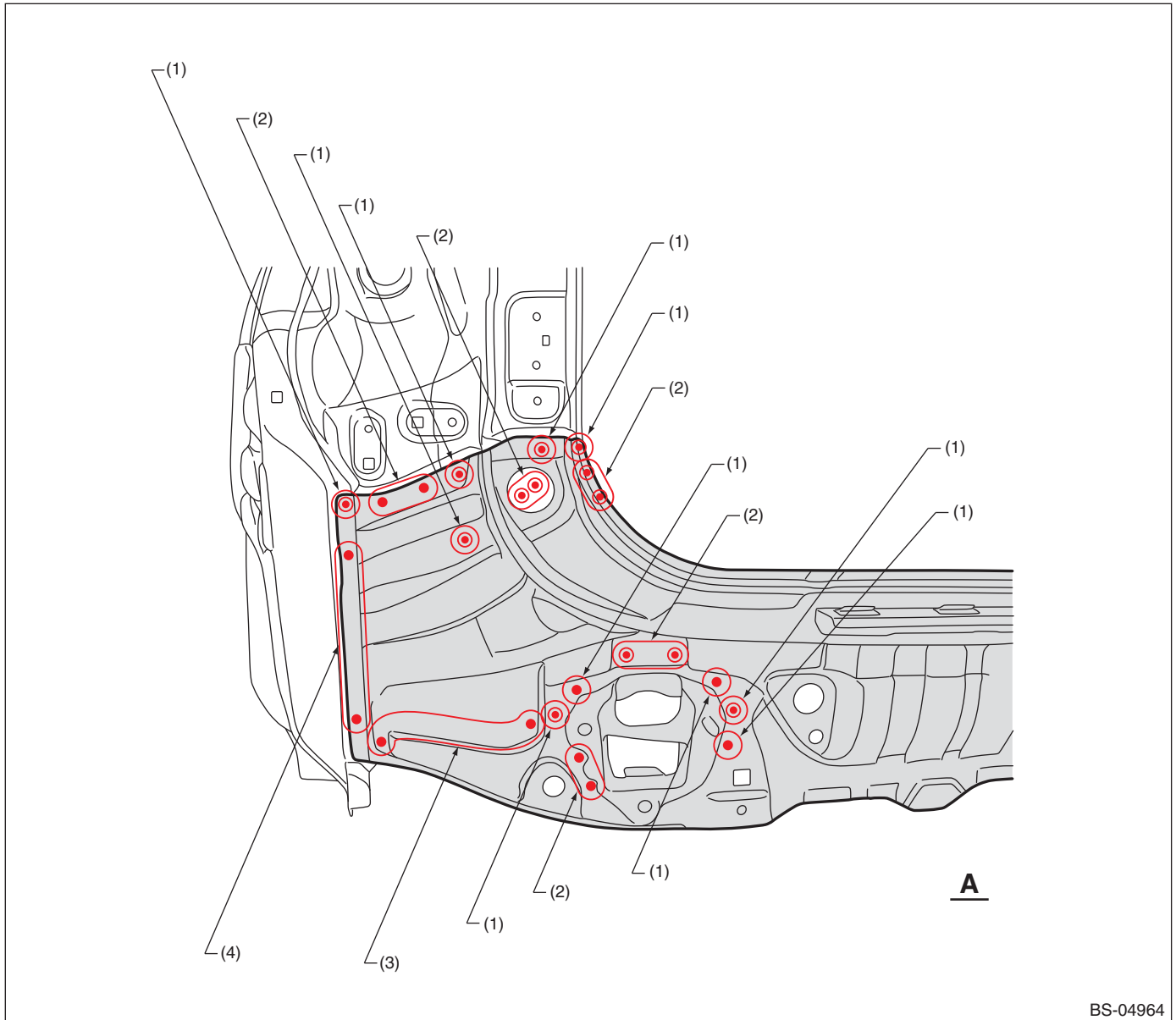


BS-04963

(1) 14 points

Panel Replacement

• Views



BS-04964

(1) 1 point
(2) 2 points

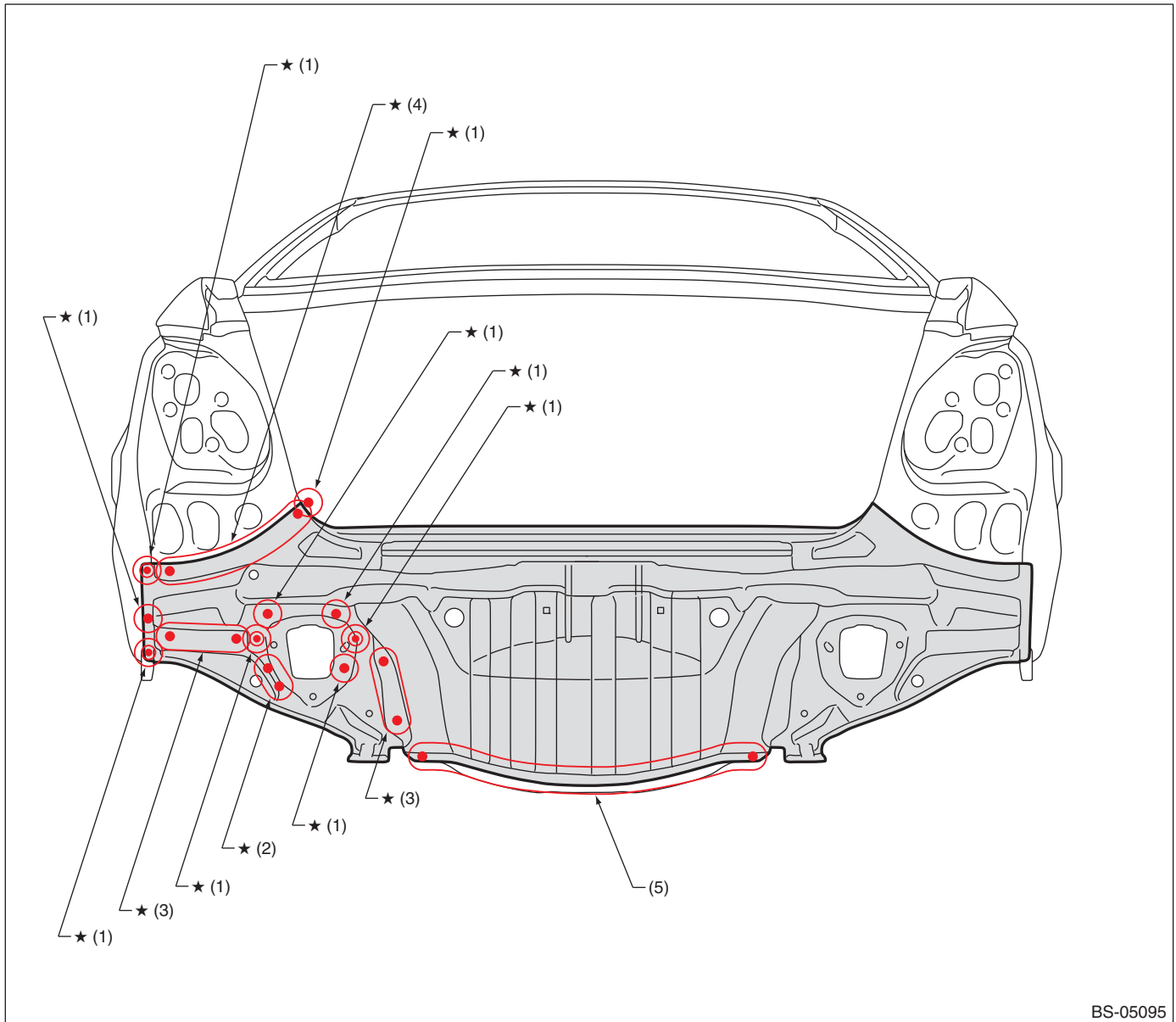
(3) 5 points

(4) 4 points

Panel Replacement

7-23. Rear Skirt (total replacement) / 4 Door

A: REMOVAL



BS-05095

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

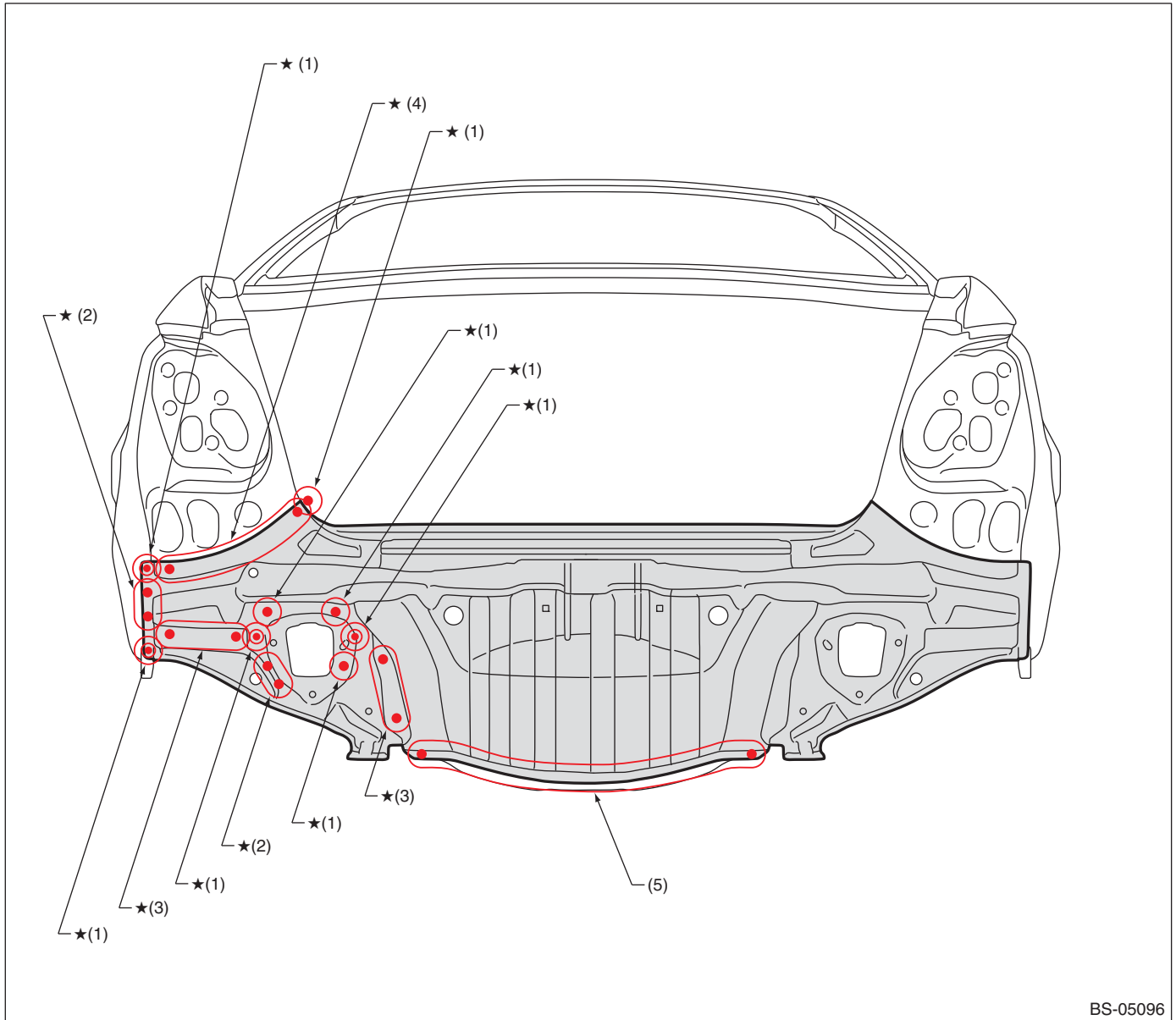
(3) 4 points (outside · 1)
(4) 9 points (outside · 1)

(5) 11 points (top · 1)

For locations marked by “★ ”: The welding method and the number of welding points are the same on the left and the right.

Panel Replacement

B: INSTALLATION



BS-05096

(1) 1 point
(2) 2 points

(3) 4 points
(4) 9 points

(5) 13 points

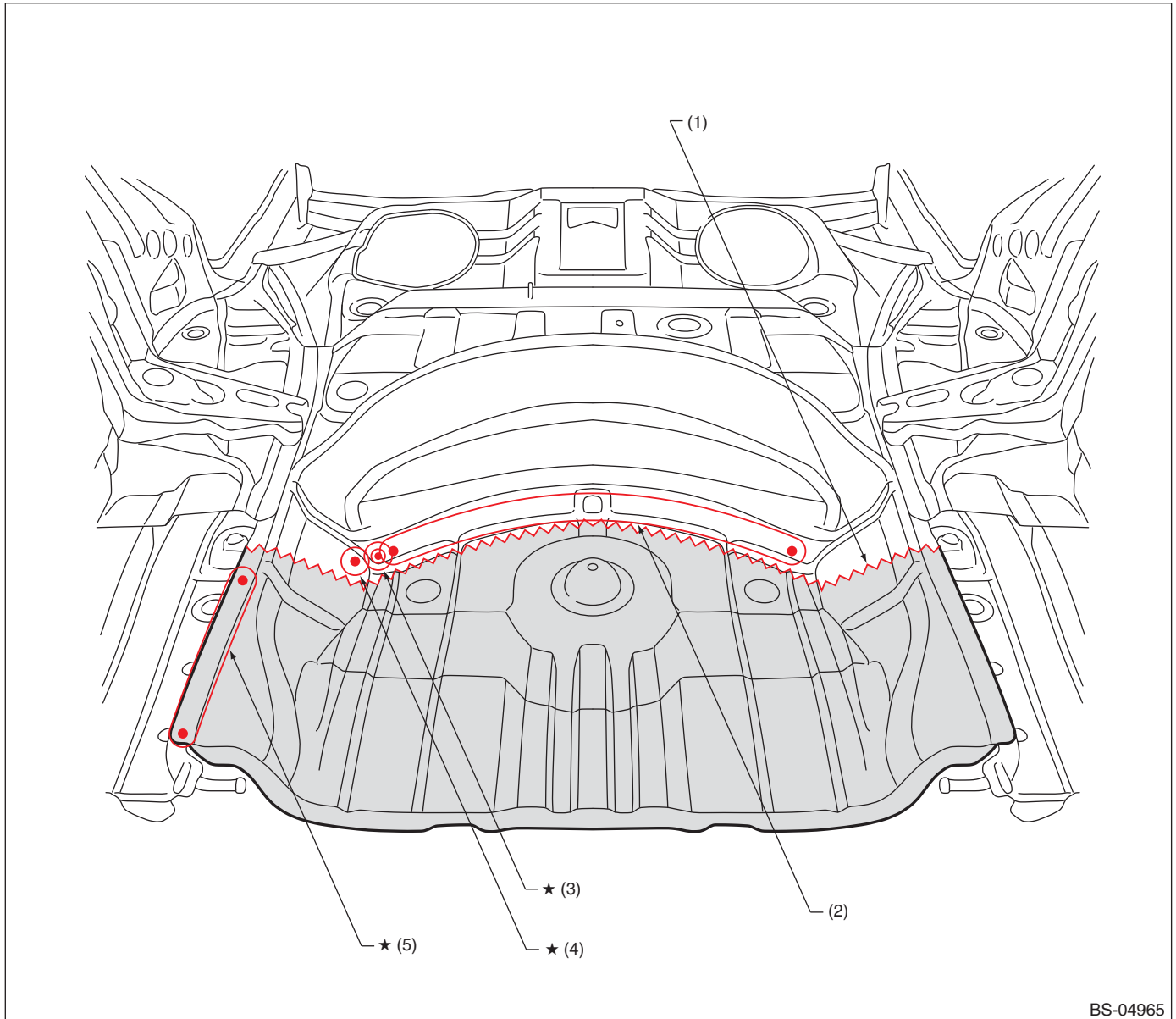
For locations marked by “★”: The welding method and the number of welding points are the same on the left and the right.

Panel Replacement

7-24. Rear Floor Pan (partial replacement)/5 Door/Except fro Hybrid Model

A: REMOVAL

- Rear skirt and rear side frame upper rear removal condition



(1) Rough cutting

(3) 1 point (outside · 1)

(5) 5 points (top · 1)

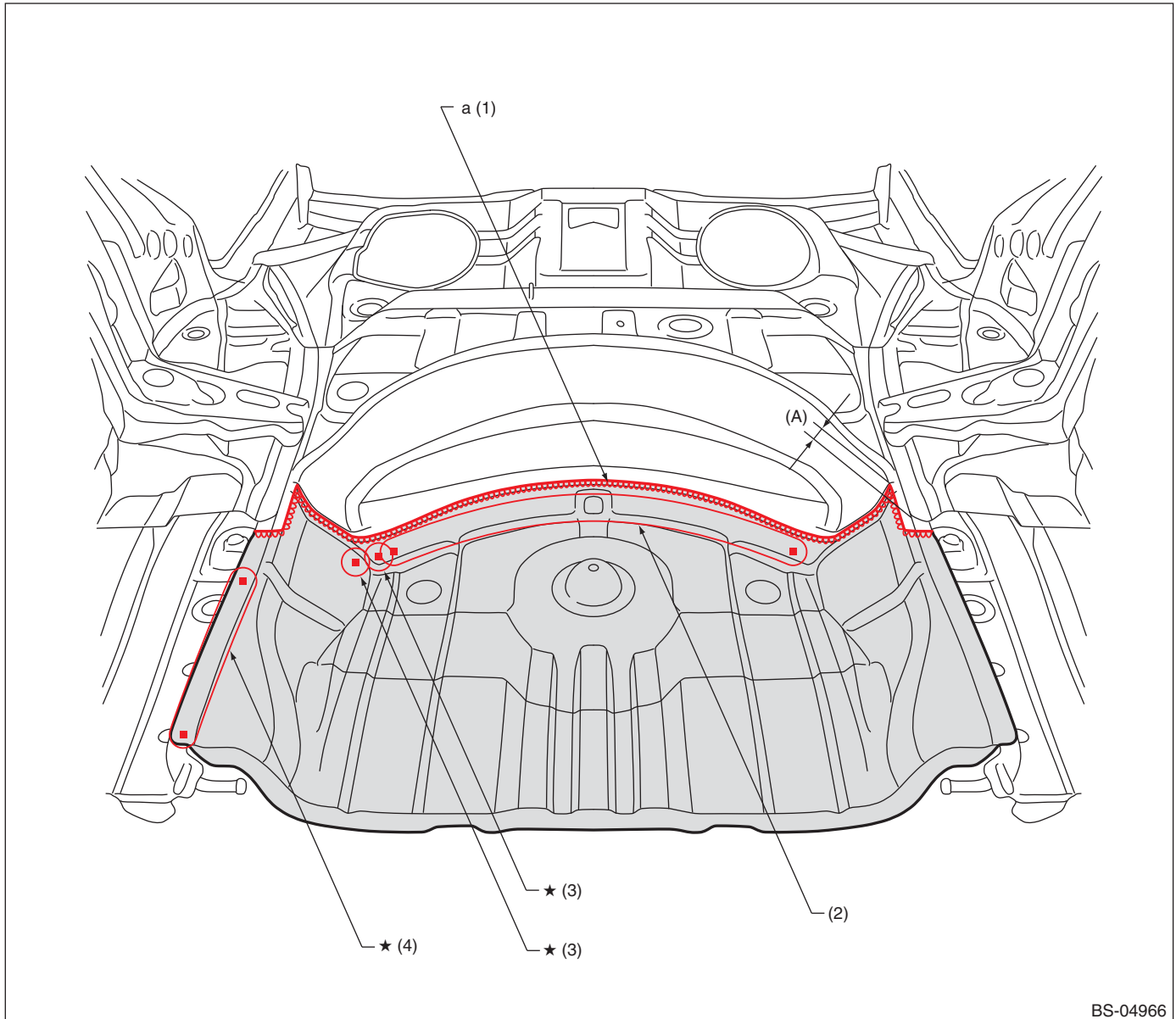
(2) 8 points (outside · 1)

(4) 1 point (inside · 1)

For locations marked by “★”: The welding method and the number of welding points are the same on the left and the right.

Panel Replacement

B: INSTALLATION



BS-04966

(A) 100 mm (3.94 in)

(1) 1 point [940 mm (37.01 in)]

(3) 1 point (service)

(4) 5 points (service)

(2) 8 points (service)

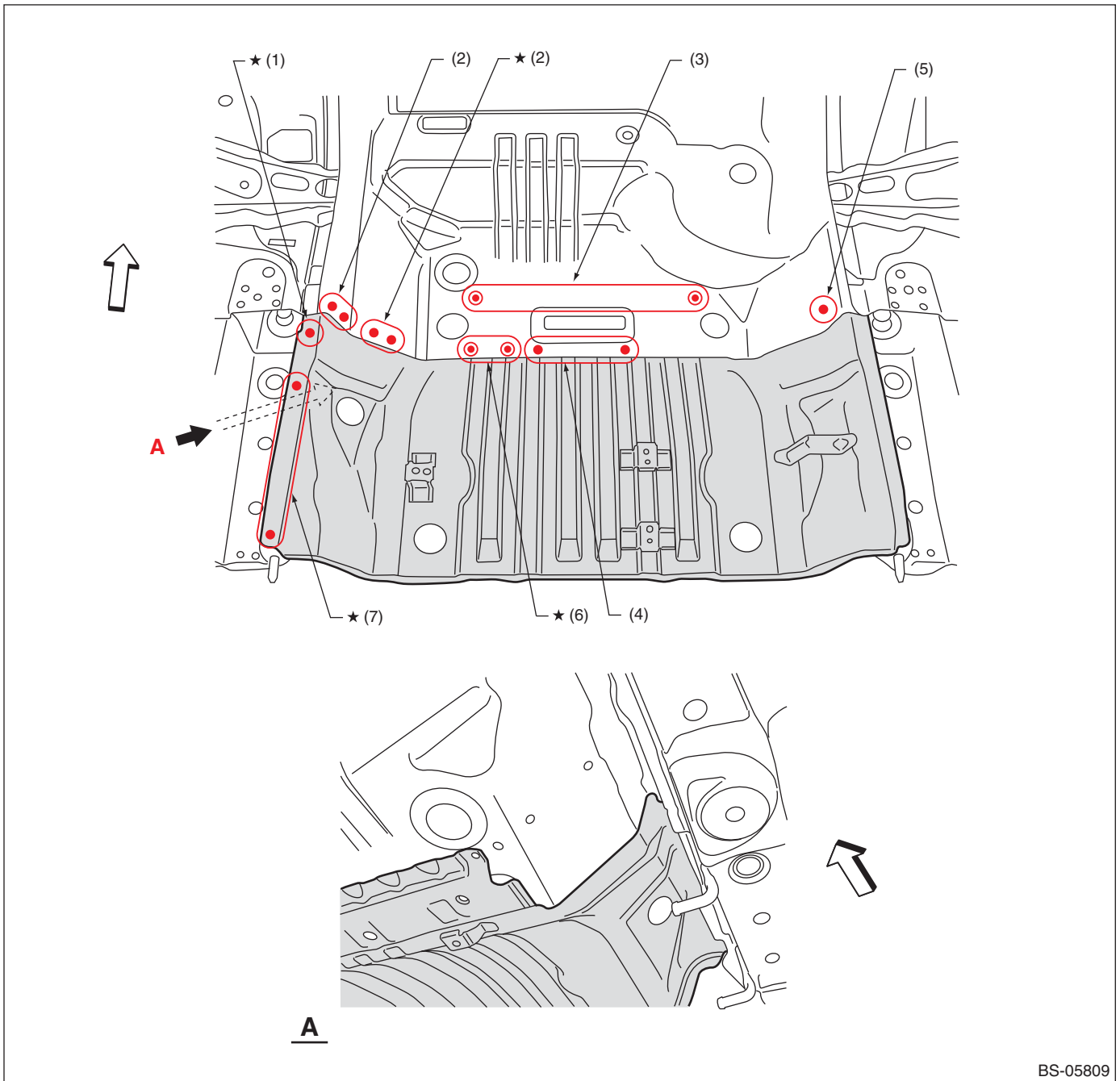
- For part marked by “a”: Anticorrosion wax shall be applied thoroughly on the back side of continuous welding portion.
- For locations marked by “★”: The welding method and the number of welding points are the same on the left and the right.

Panel Replacement

7-25. Rear Floor Pan (partial replacement)/5 Door/Hybrid Model

A: REMOVAL

• Rear skirt, bumper rear bracket, rear side upper frame and rear crossmember C bracket removal condition



BS-05809

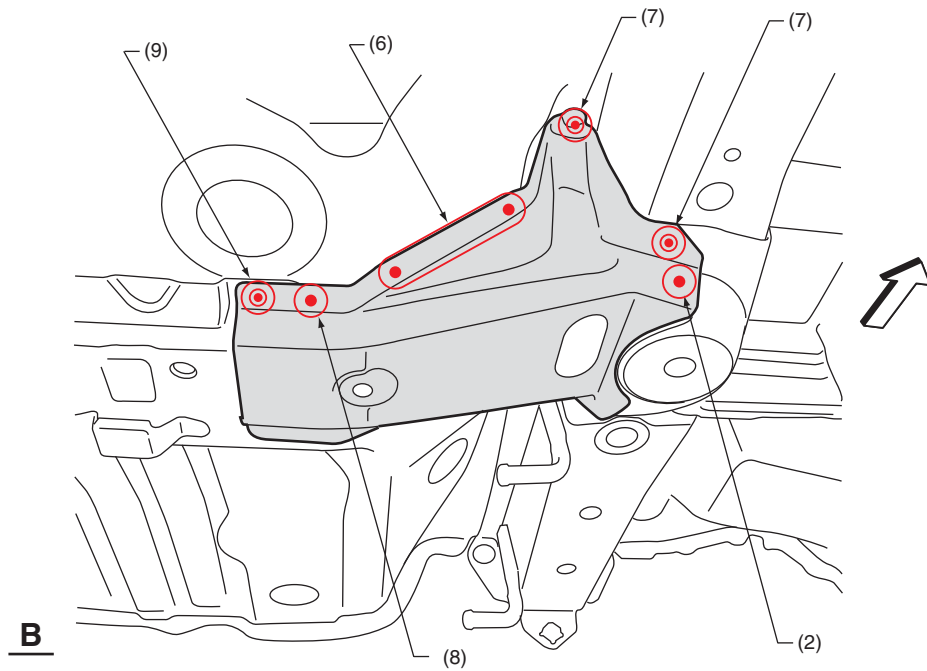
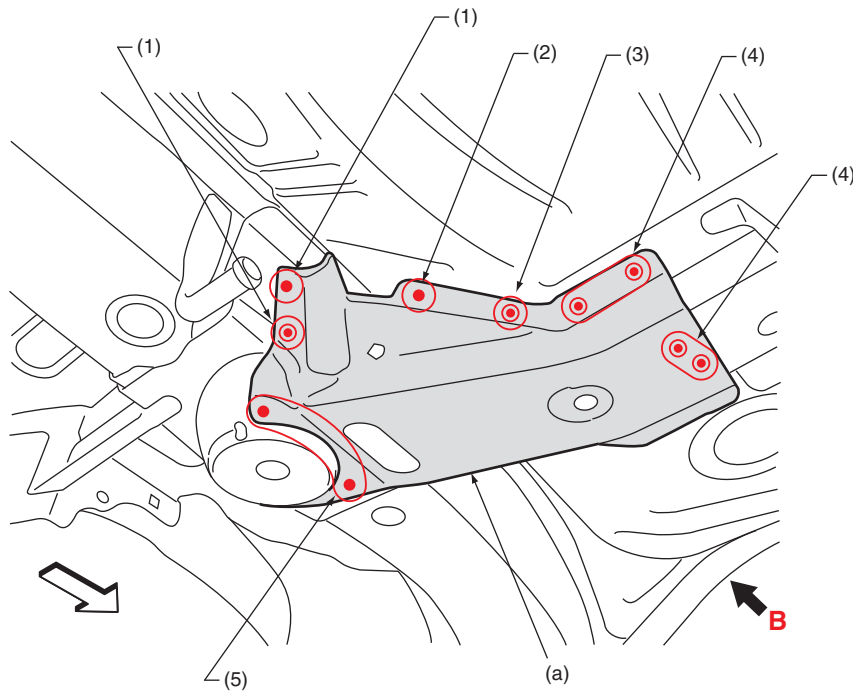
- (1) 1 point (top · 1)
- (2) 2 points (inside · 1)
- (3) 7 points (top · 1)

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

- (7) 5 points (top · 1)

For locations marked by “★”: The welding method and the number of welding points are the same on the left and the right.

Panel Replacement



BS-05808

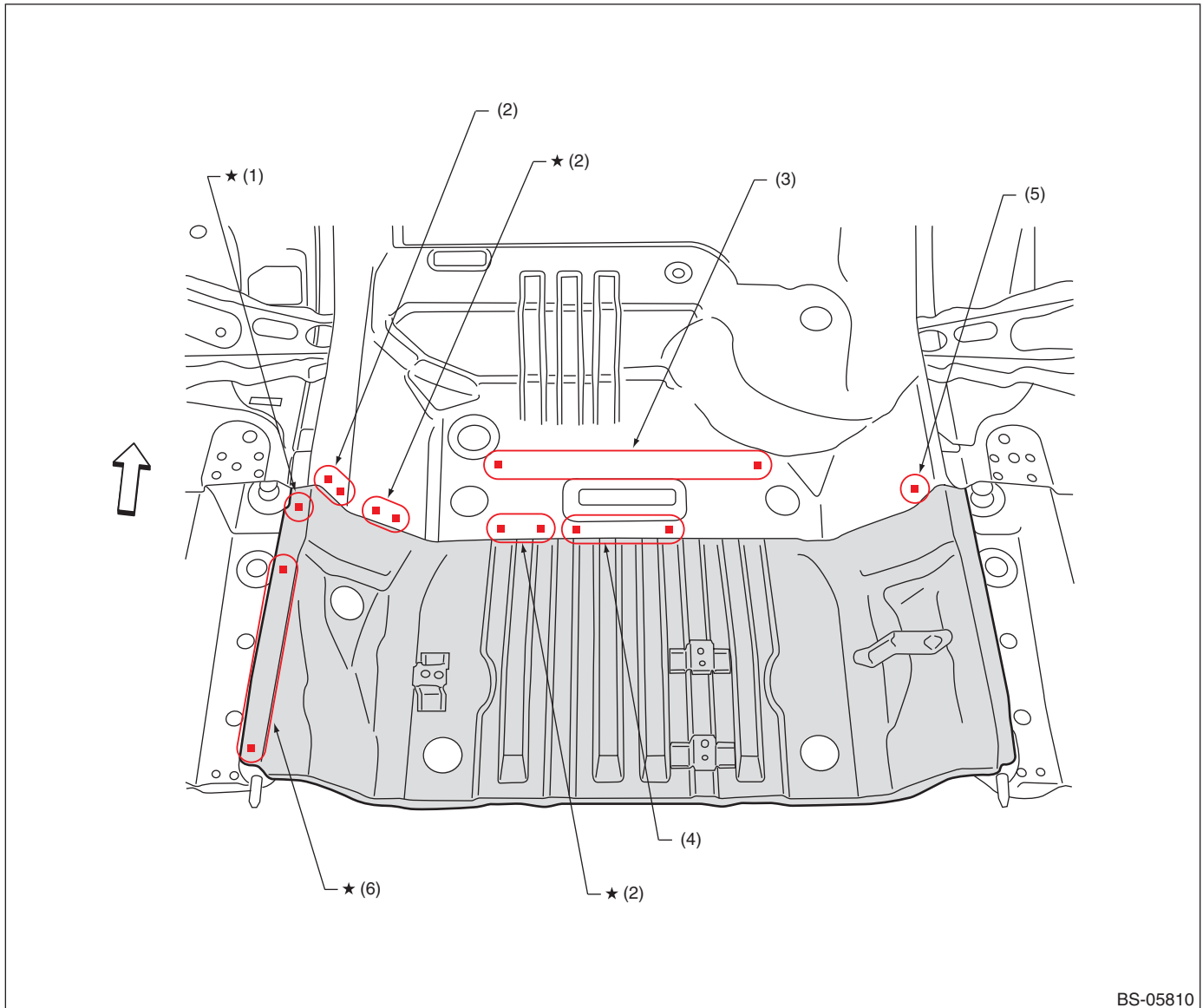
(a) Crossmember C bracket

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

Crossmember C bracket must be reused.

Panel Replacement

B: INSTALLATION



(1) 1 point (service)

(2) 2 points

(3) 7 points

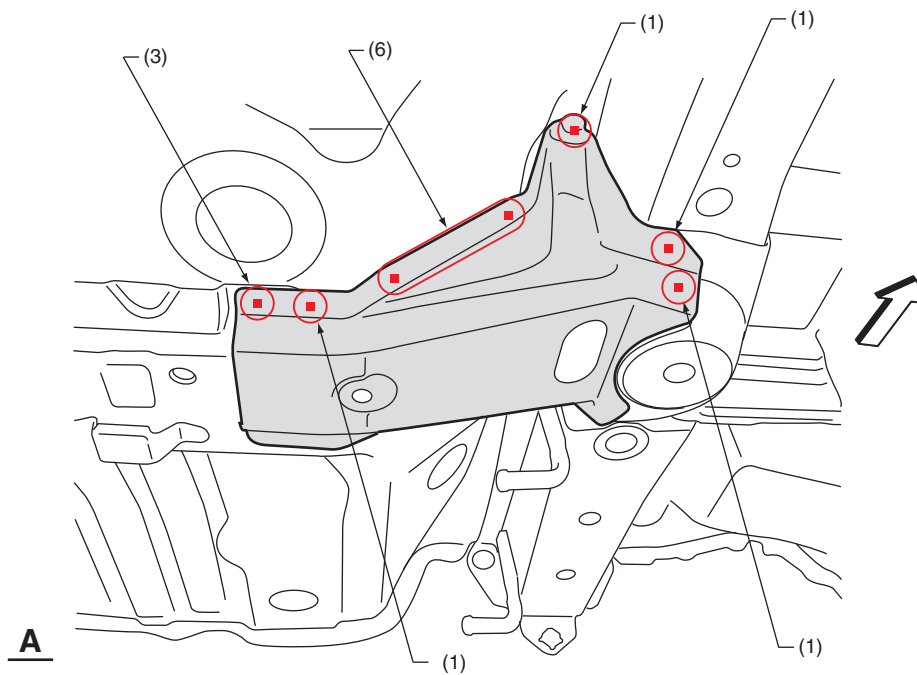
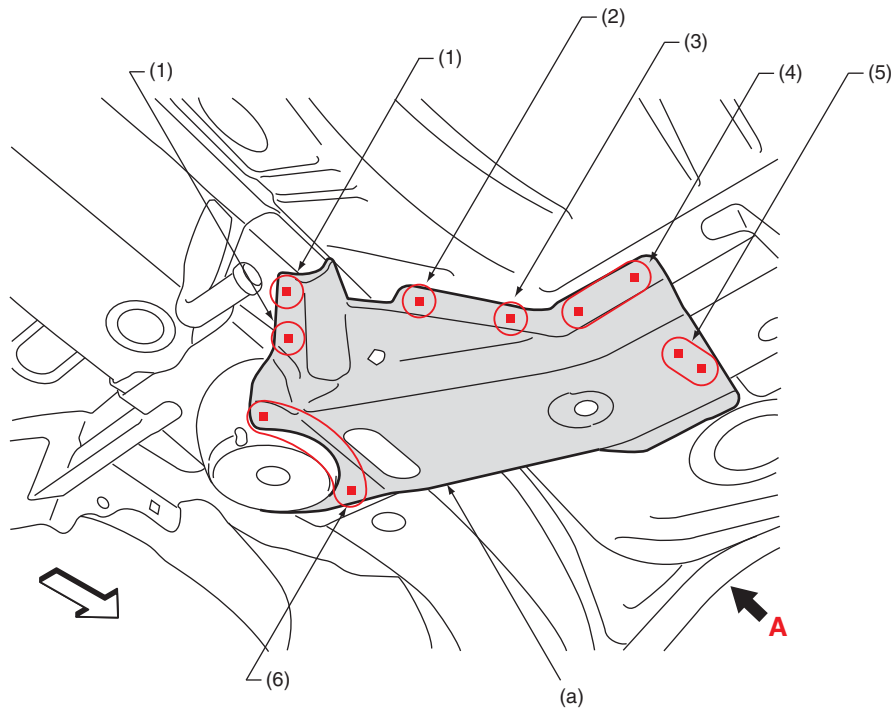
(4) 3 points

(5) 1 point

(6) 5 point (service)

For locations marked by “★”: The welding method and the number of welding points are the same on the left and the right.

Panel Replacement



BS-05811

(a) Crossmember C bracket

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

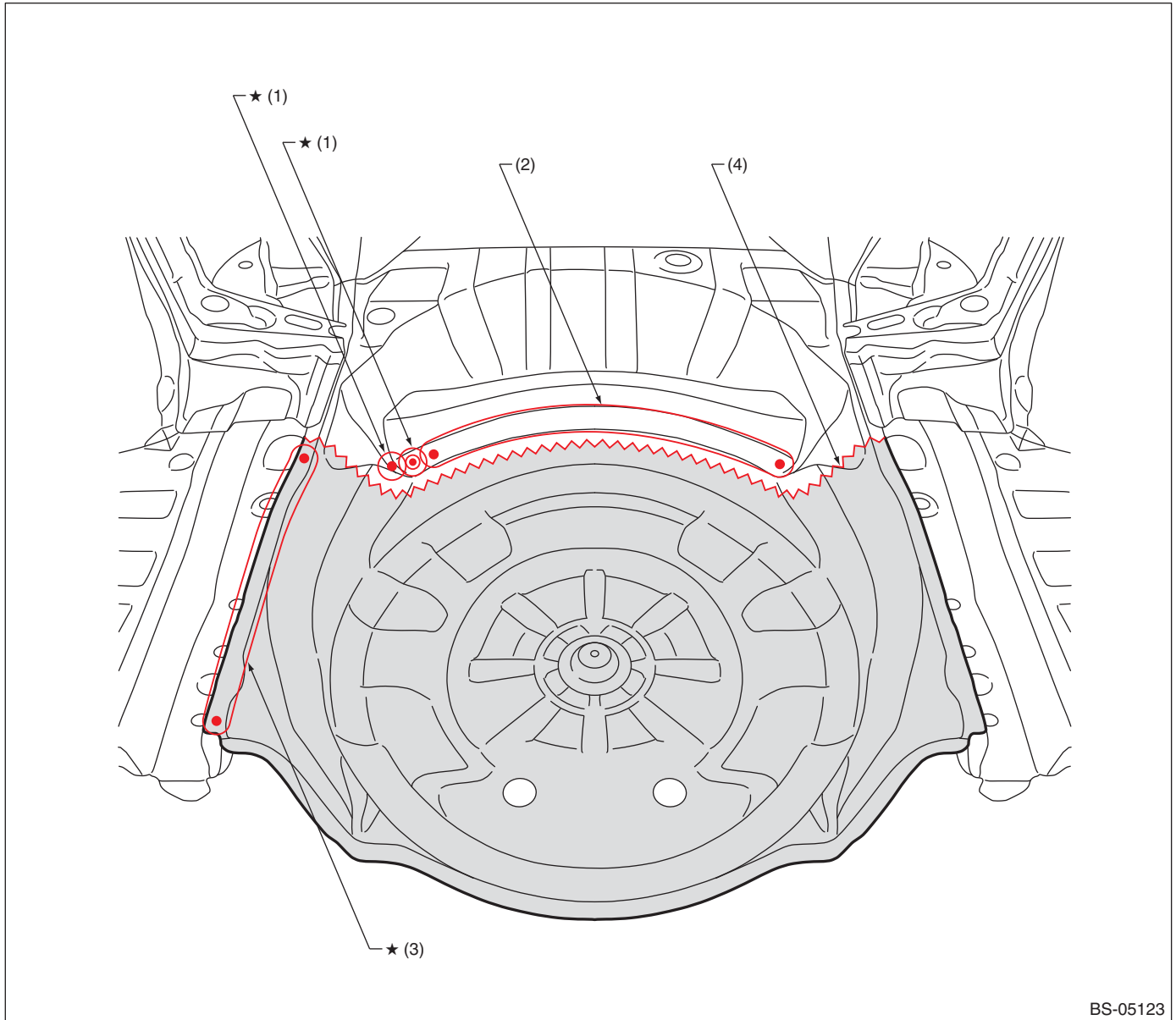
Crossmember C bracket must be reused.

Panel Replacement

7-26. Rear Floor Pan (partial replacement) / 4 Door

A: REMOVAL

- Rear skirt and rear side frame upper rear removal condition



(1) 1 point (outside · 1)

(2) 8 points (outside · 1)

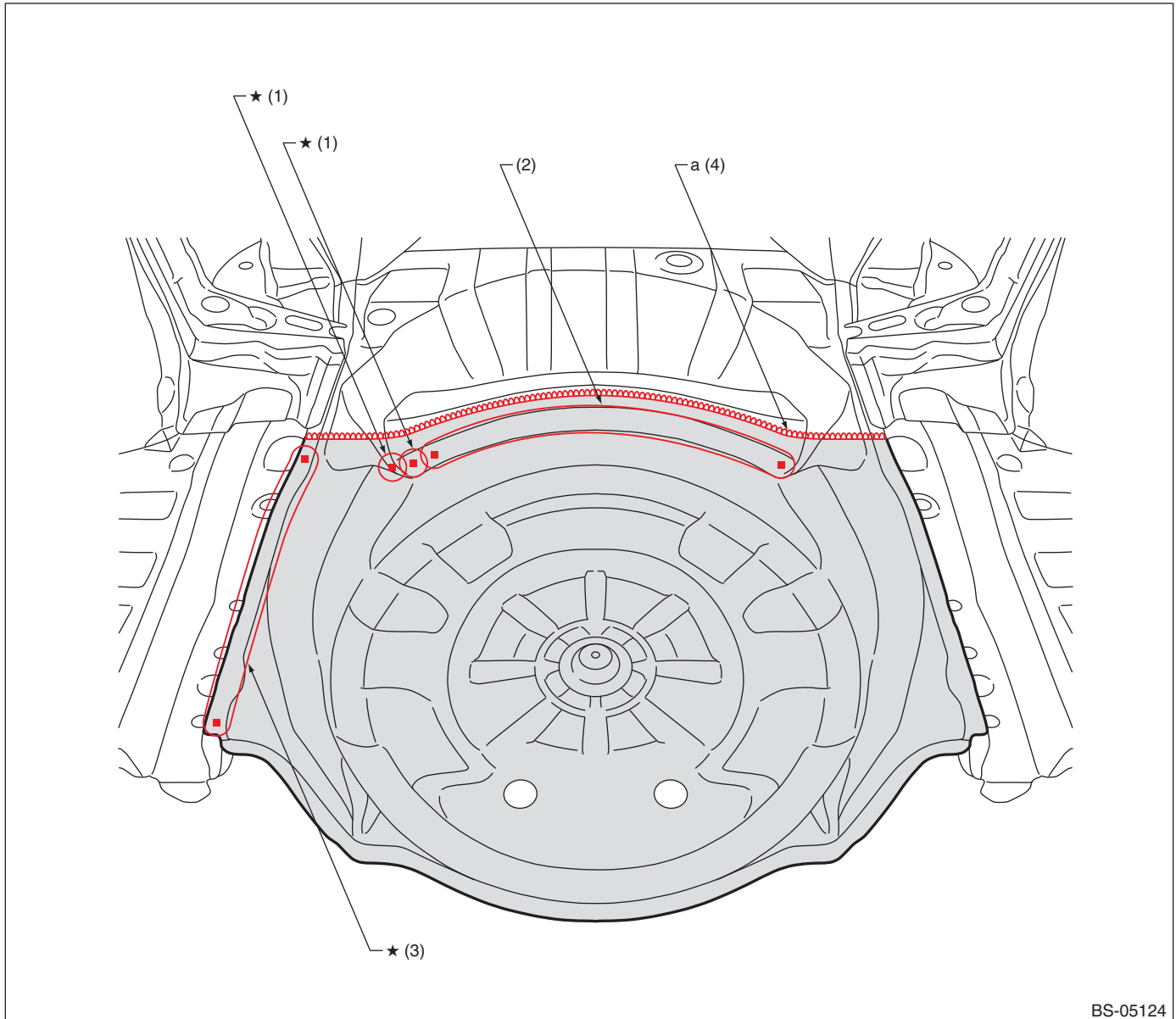
(3) 10 points (top · 1)

(4) Rough cutting

For locations marked by “★”: The welding method and the number of welding points are the same on the left and the right.

Panel Replacement

B: INSTALLATION



(1) 1 point (service)
(2) 8 points (service)

(3) 10 points (service)

(4) 1 point [920 mm (36.22 in.)]

For continuous welds marked by a, anticorrosion wax shall be applied thoroughly on the rear.

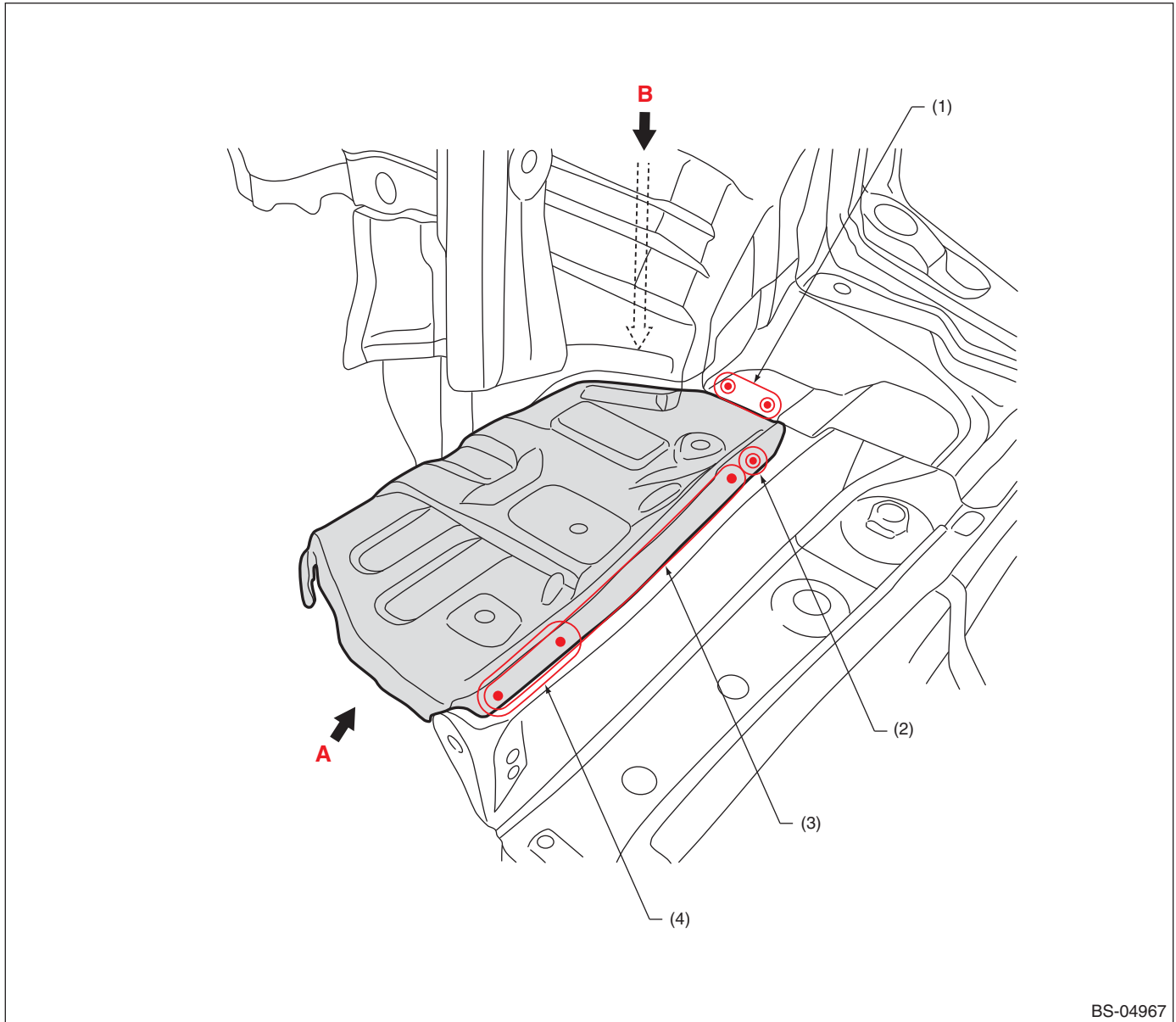
For locations marked by “★”: The welding method and the number of welding points are the same on the left and the right.

Panel Replacement

7-27. Rear Floor Side (total replacement) / 5 Door

A: REMOVAL

- Overall view (Rear skirt, rear side frame upper rear and quarter panel outer removal condition)



BS-04967

(1) LH: 2 points (top · 2)
RH: 1 point (top · 2)

(3) 7 points (top · 1)

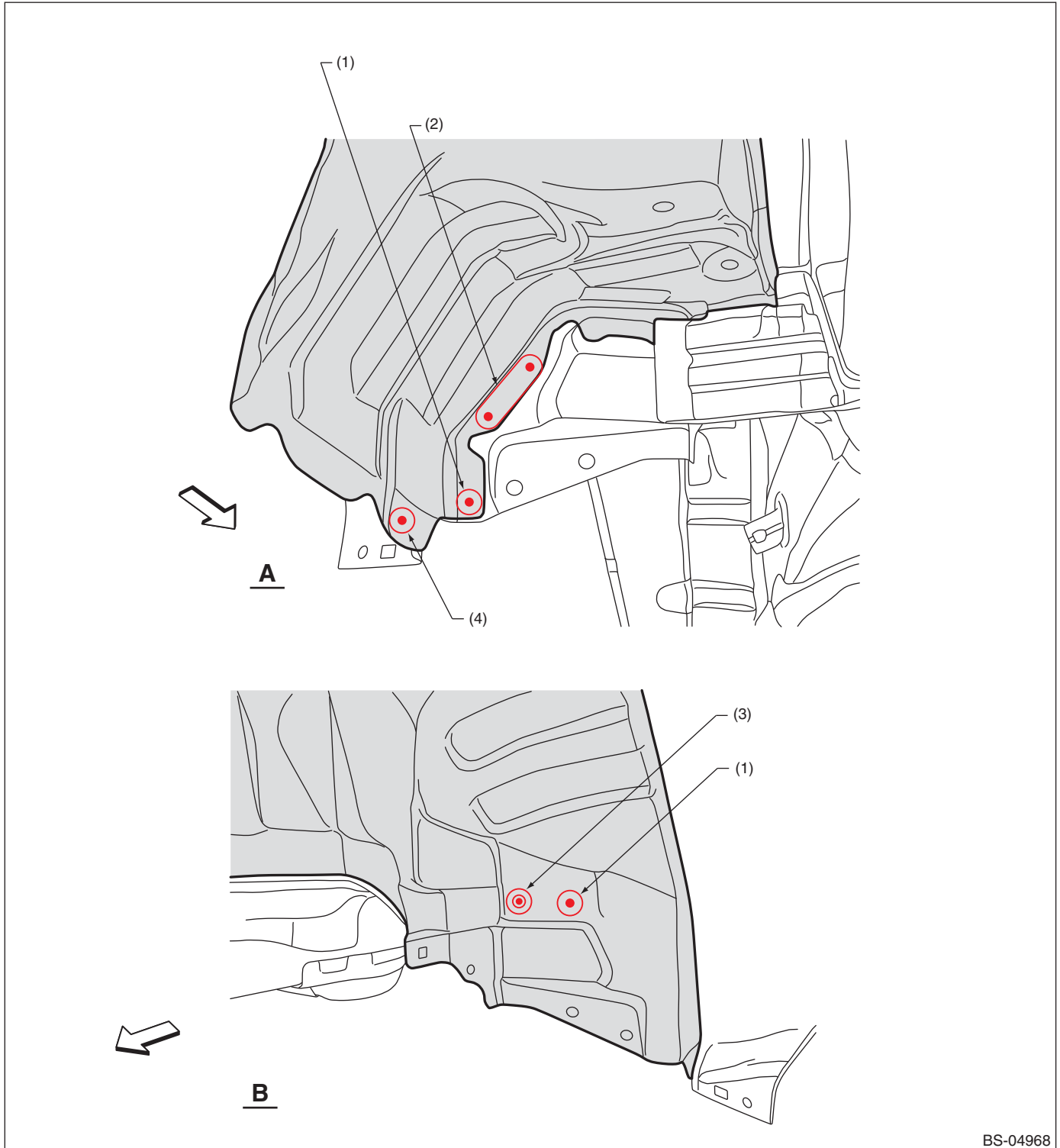
(4) 2 points (top · 1, belt sander)
(When the drill of the spot cutter
comes into contact with the D-pillar
reinforcement)

(2) 1 point (top · 1)

The figure shows models other than hybrid models. Hybrid models have a different floor shape, but the number and location of welding points are the same as those in gasoline models.

Panel Replacement

• Views



BS-04968

(1) 1 point (outside · 1)

(3) 1 point (outside · 2)

(4) 1 point (inside · 1)

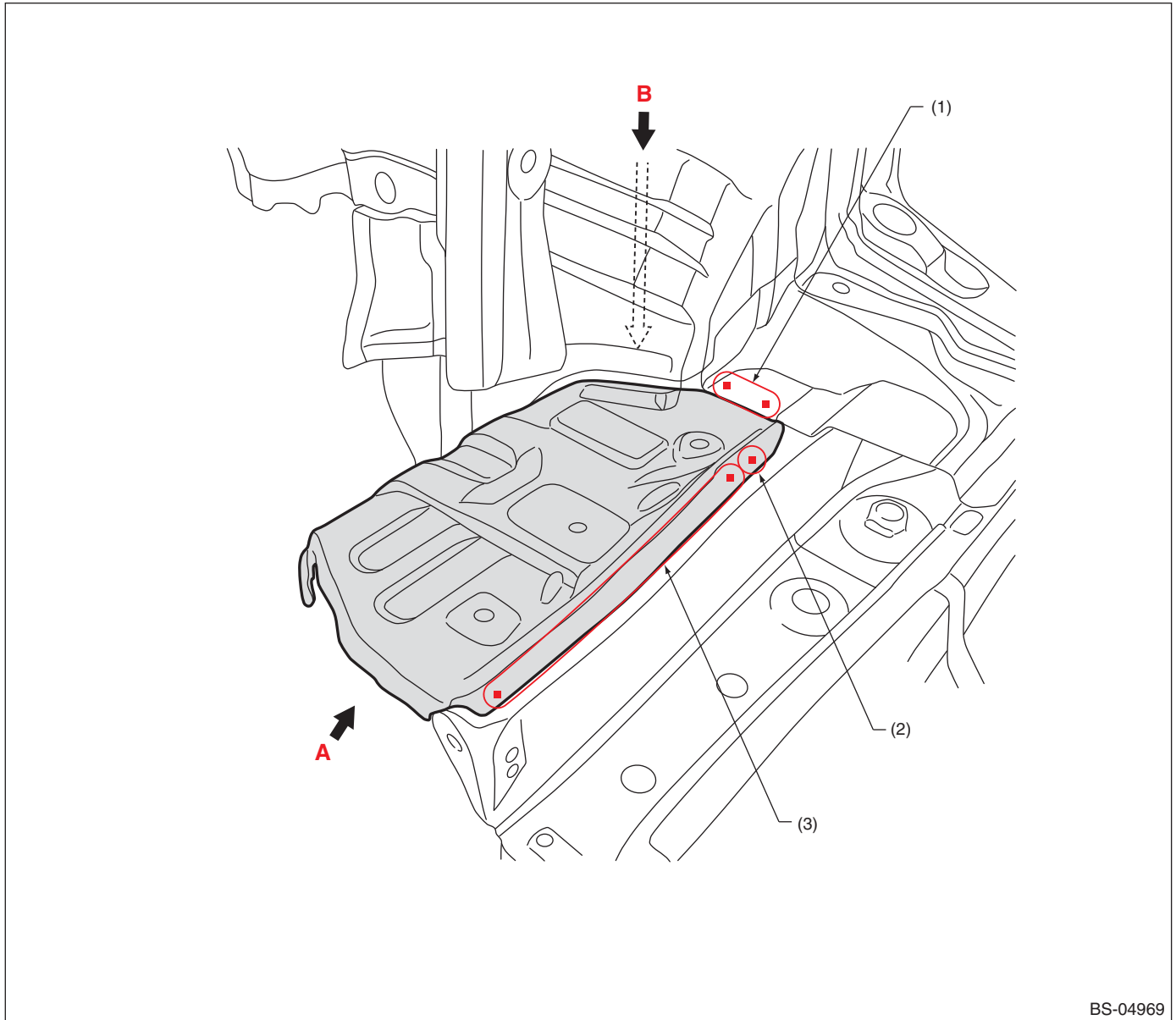
(2) 2 point (outside · 1)

The figure shows models other than hybrid models. Hybrid models have a different floor shape, but the number and location of welding points are the same as those in gasoline models.

Panel Replacement

B: INSTALLATION

• Overall view



BS-04969

(1) LH: 2 points (service · matching)
RH: 1 point (service · matching)

(2) 1 point (service)

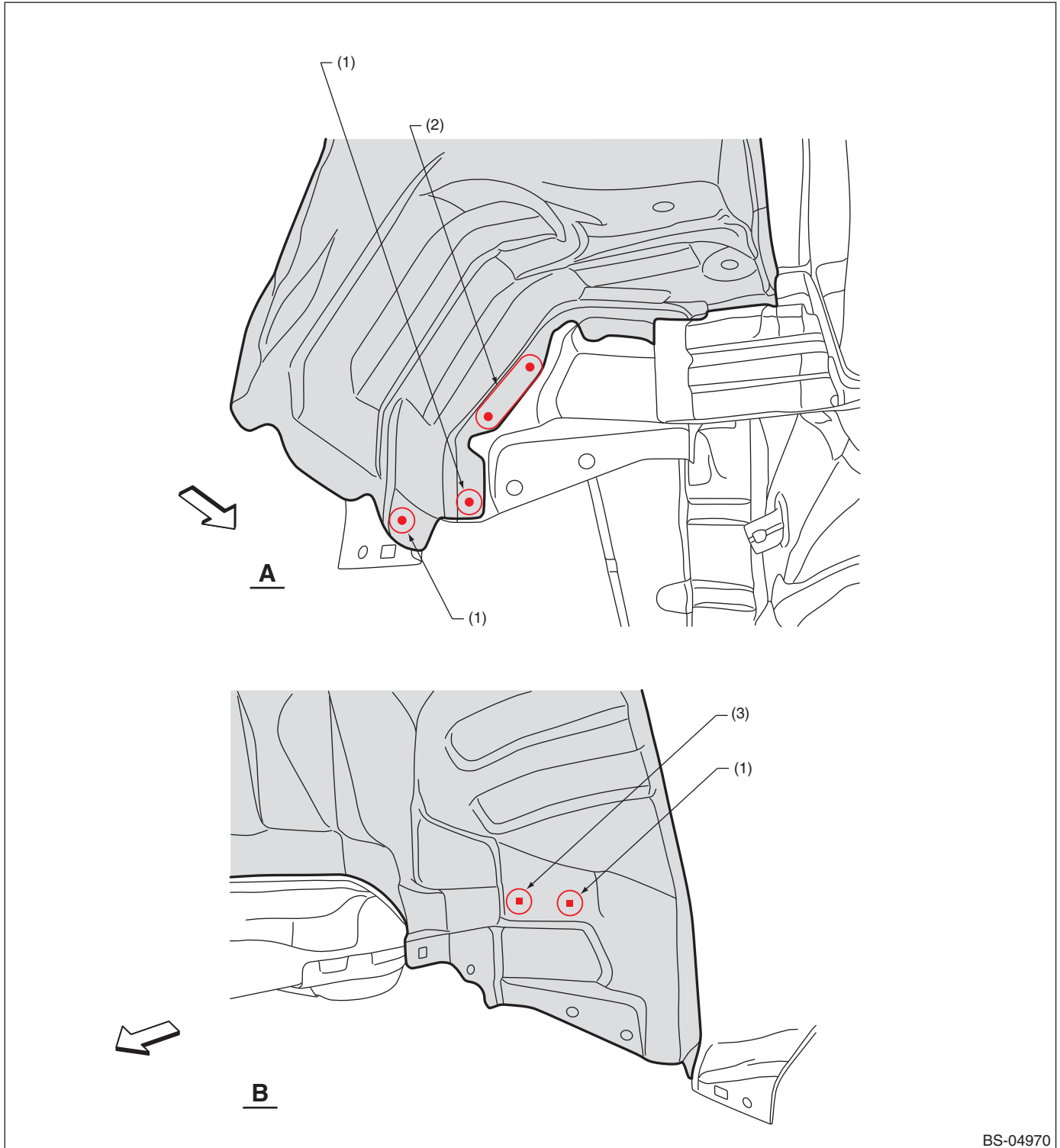
(3) 6 points (service)

The figure shows models other than hybrid models.
Hybrid models have a different floor shape, but the

number and location of welding points are the
same as those in gasoline models.

Panel Replacement

• Views



BS-04970

(1) 1 point

(2) 2 points

(3) 1 point (service · matching)

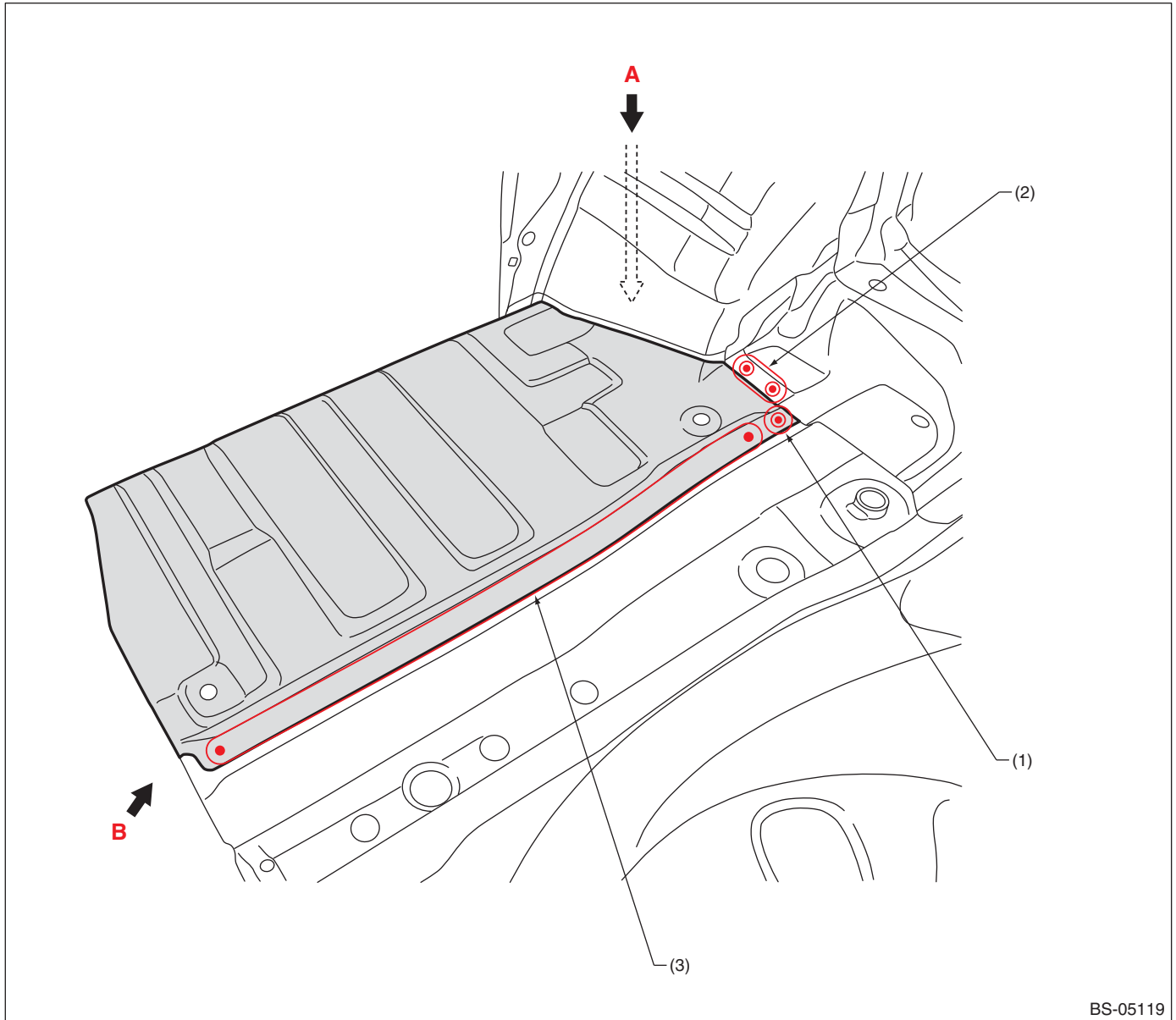
The figure shows models other than hybrid models. Hybrid models have a different floor shape, but the number and location of welding points are the same as those in gasoline models.

Panel Replacement

7-28. Rear Floor Side (total replacement) / 4 Door

A: REMOVAL

- Overall view (Rear skirt and rear quarter removal condition)



BS-05119

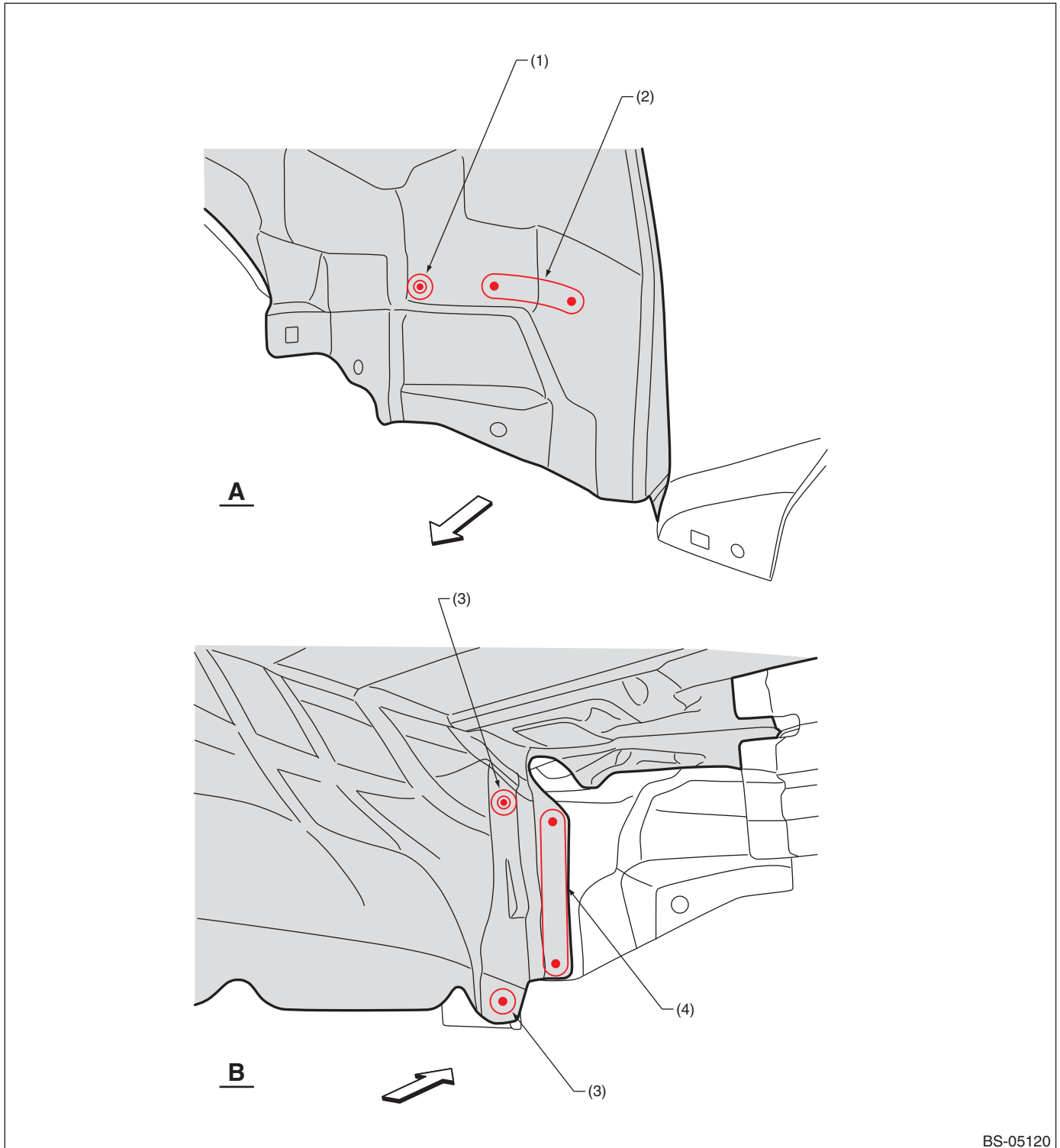
(1) 1 point (top · 1)

(2) LH: 2 points (top · 2)
RH: 1 point (top · 2)

(3) 11 points (top · 1)

Panel Replacement

• Views



BS-05120

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

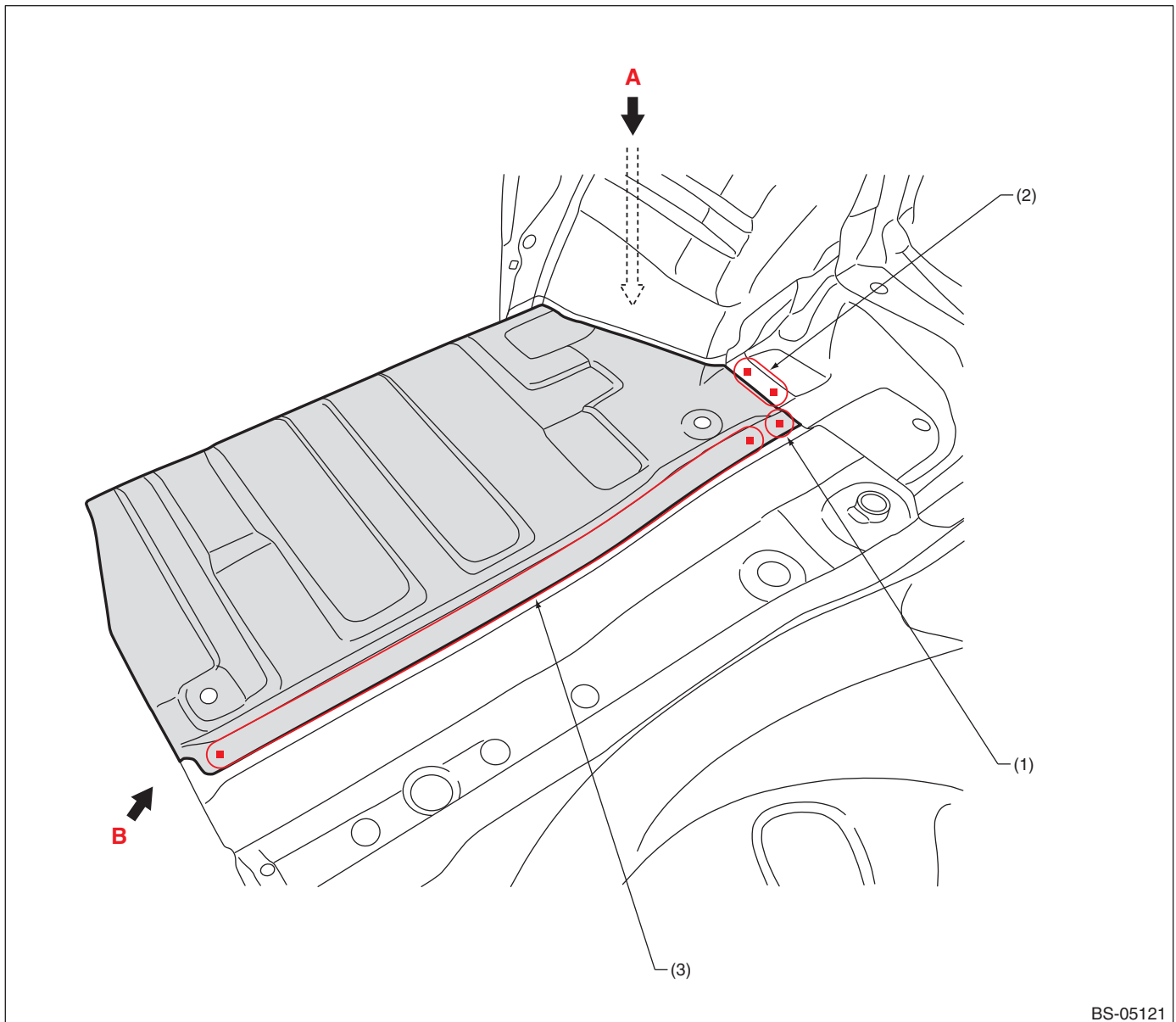
(3) 1 point (inside · 1)

(4) 3 points (outside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BS-05121

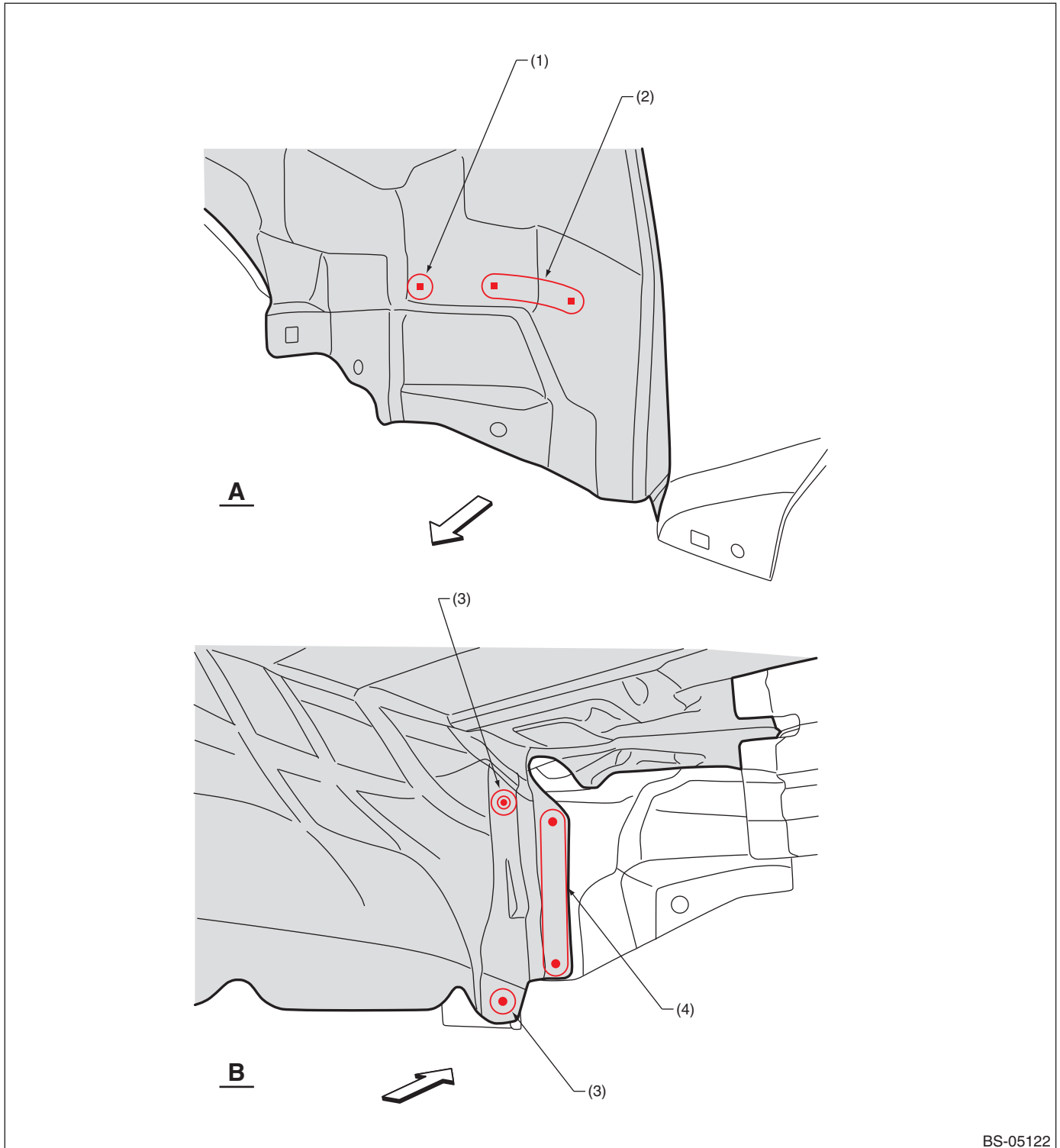
(1) 1 point (service)

(2) LH: 2 points (service · matching)
RH: 1 point (service · matching)

(3) 11 point (service)

Panel Replacement

• Views



BS-05122

(1) 1 point (service · matching)

(2) 2 points

(3) 1 point

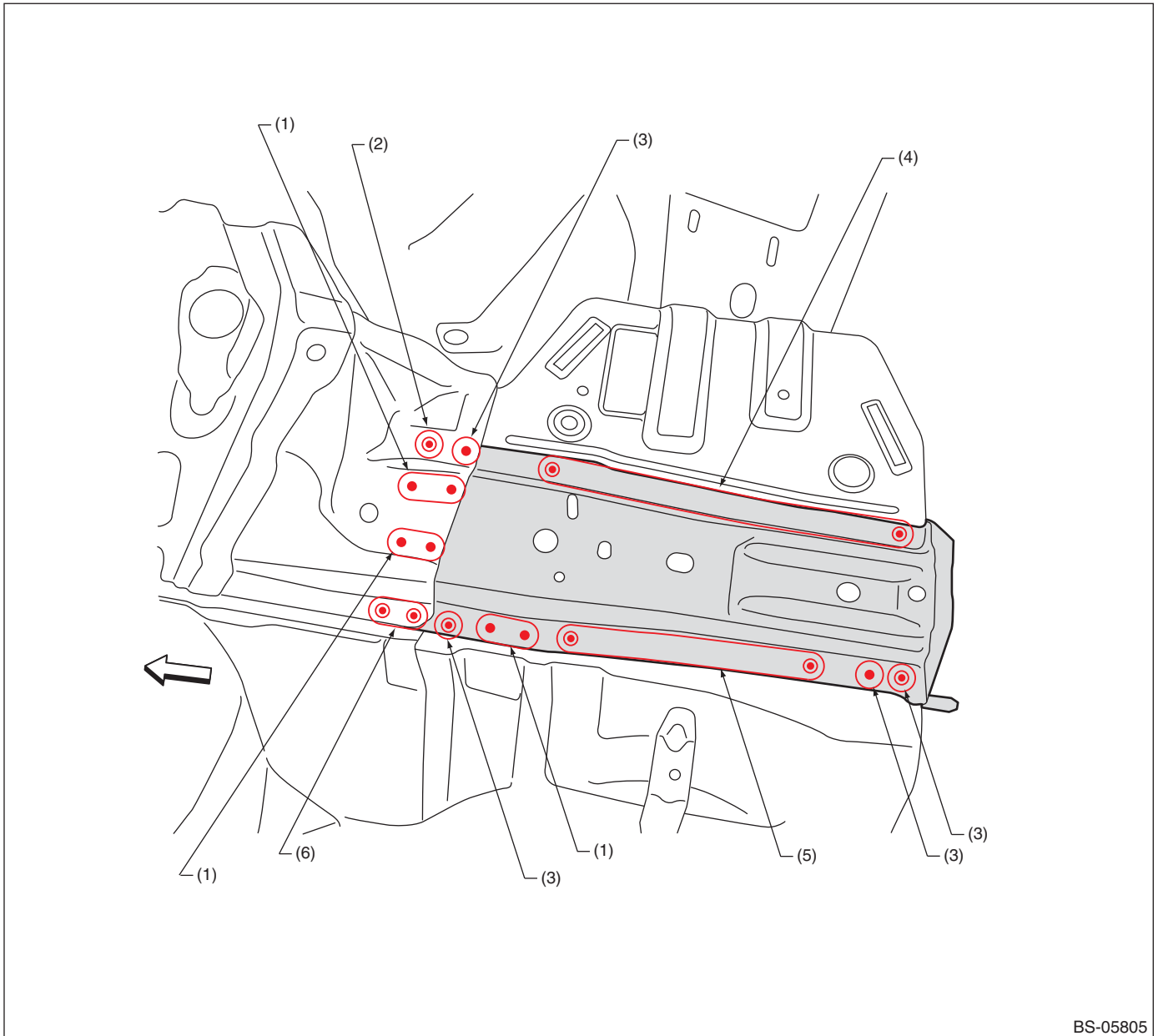
(4) 3 points

Panel Replacement

7-29. Rear Side Frame Upper RH / Hybreid Model

A: REMOVAL

- Rear skirt and bumper rear bracket removal condition



BS-05805

(1) 2 points (top · 1)

(2) 1 point (top · 2)

(3) 1 point (top · 1)

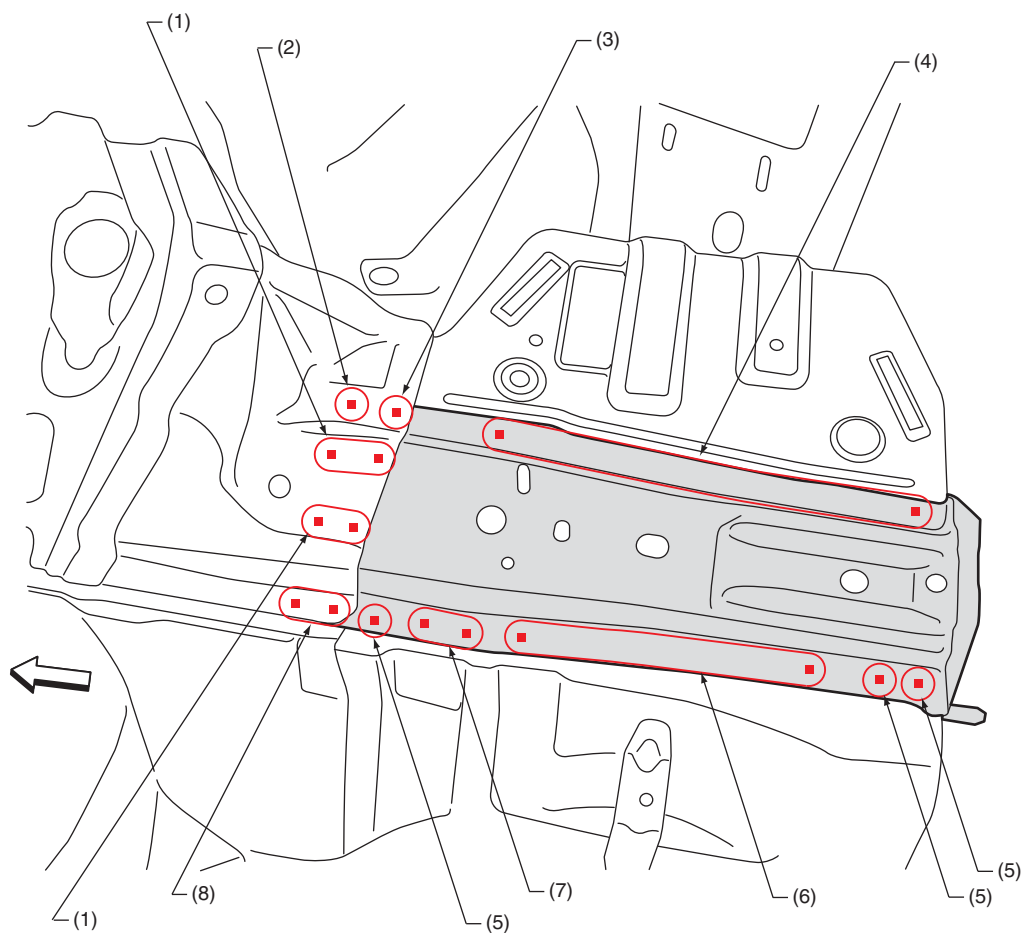
(4) 6 points (top · 1)

(5) 4 points (top · 1)

(6) 2 points (top · 2)

Panel Replacement

B: INSTALLATION



BS-05806

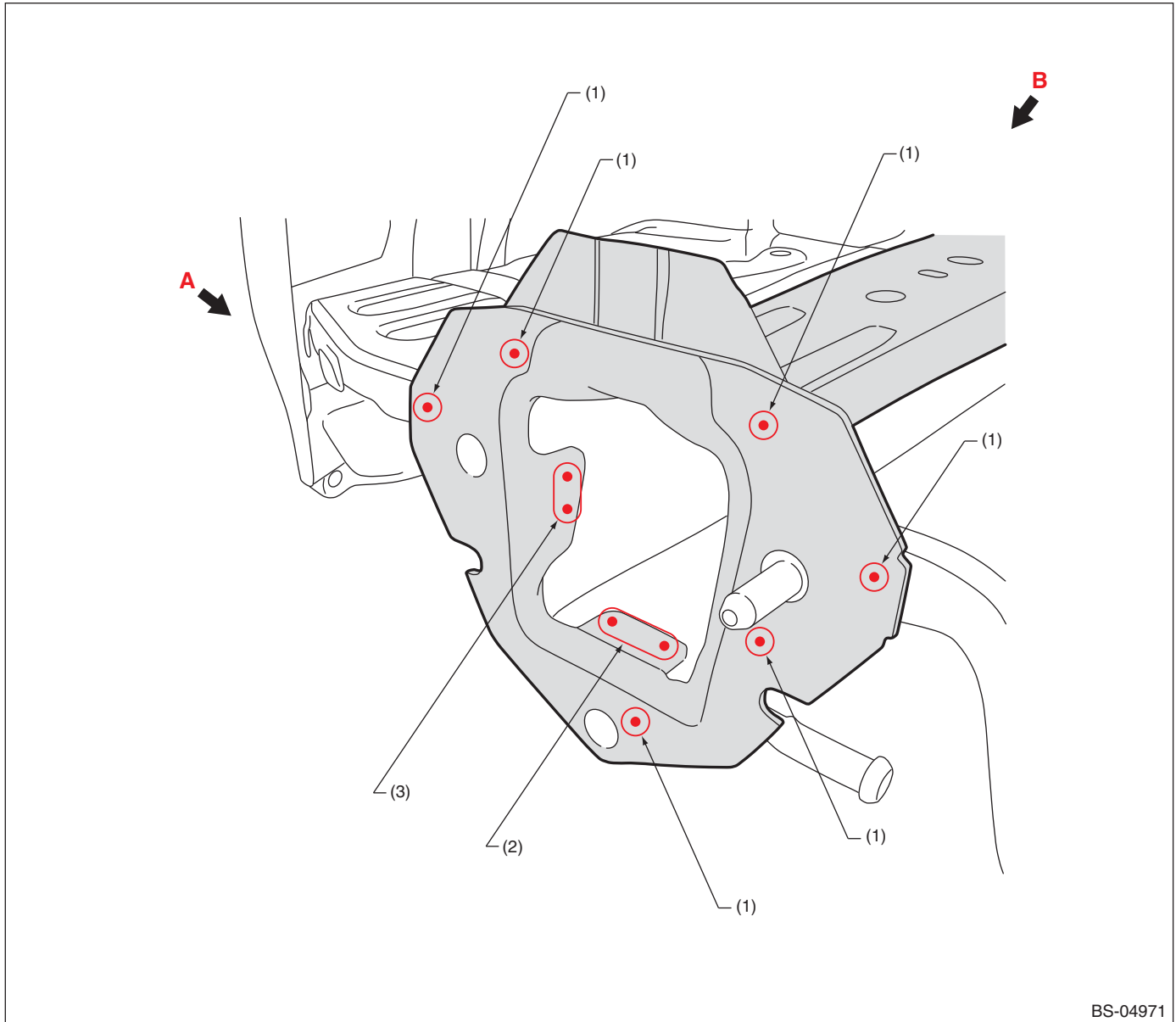
- | | | |
|----------------------------------|------------------------|-----------------------------------|
| (1) 2 points | (4) 6 points (service) | (7) 2 points (service) |
| (2) 1 point (service · matching) | (5) 1 point (service) | (8) 2 points (service · matching) |
| (3) 1 point | (6) 4 points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

Panel Replacement

7-30. Rear Side Frame Upper Rear (total replacement) / 5 Door

A: REMOVAL

- Overall view (Rear skirt removal condition)



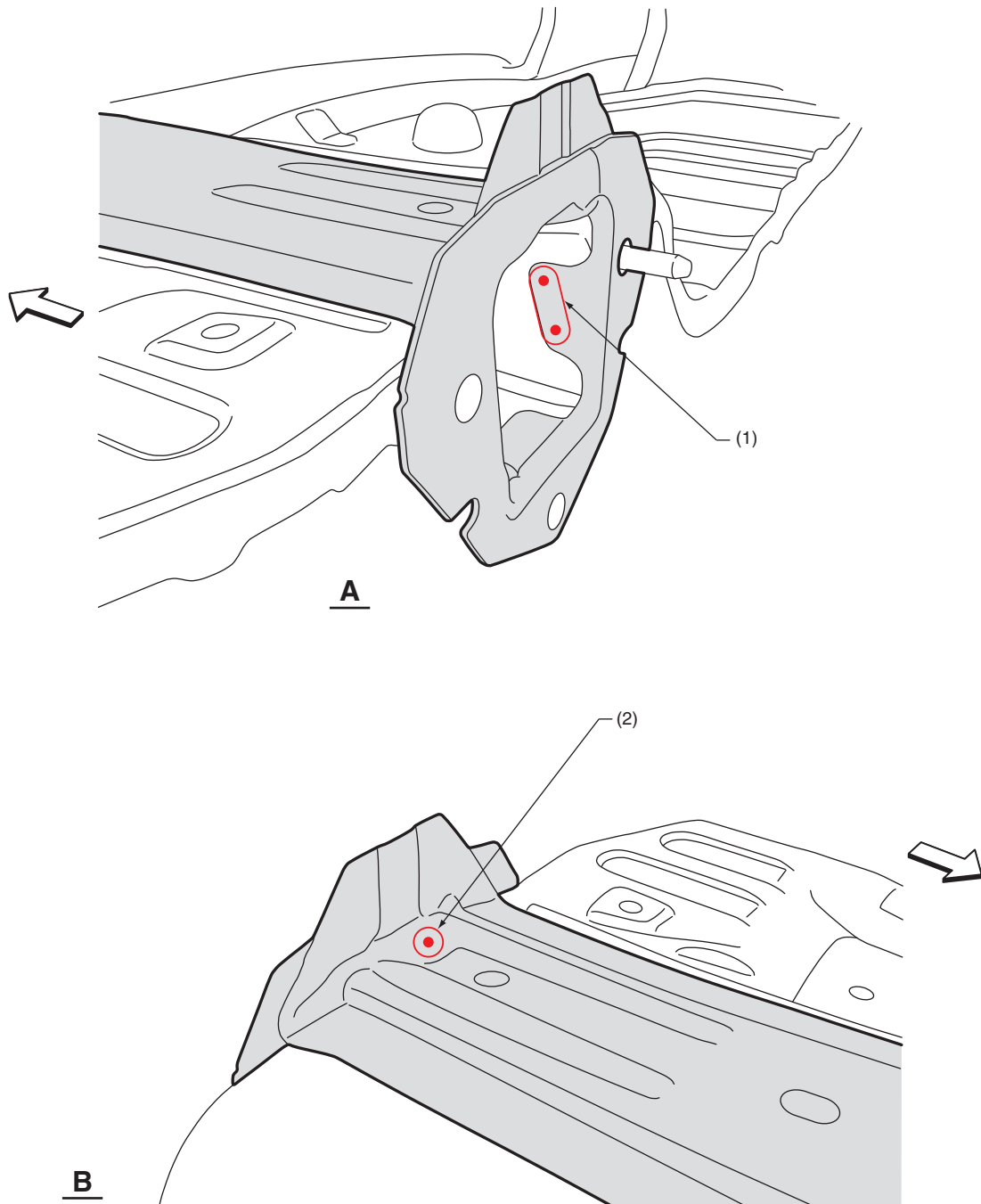
(1) 1 point (outside · 1)

(2) 2 points (bottom · 1)

(3) 2 points (outside · 1)

Panel Replacement

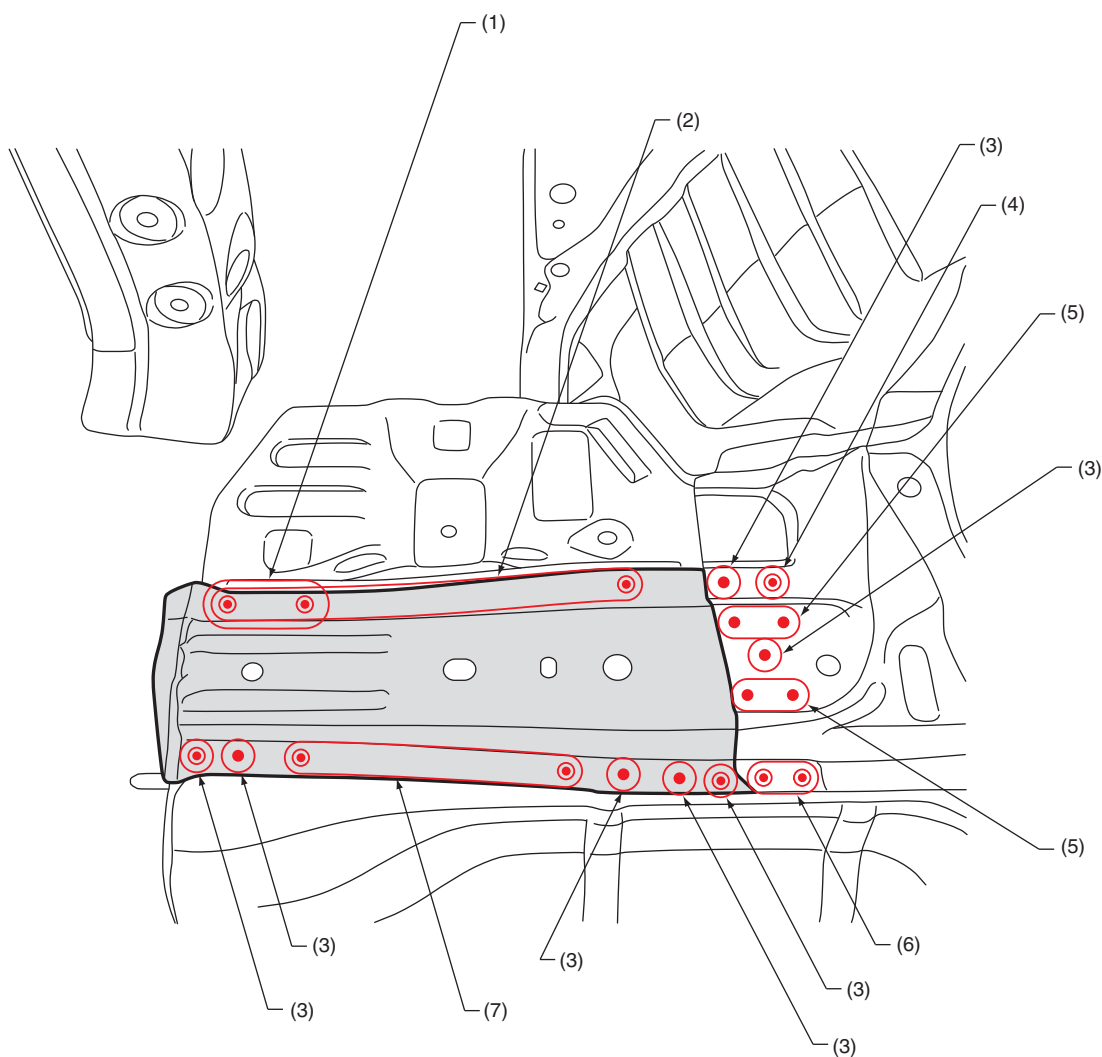
• Views



BS-04972

- (1) 2 points (inside · 1, belt sander) (2) 1 point (top · 1)

Panel Replacement



BS-04973

(1) 2 points (top · 1)
(When the drill of the spot cutter
comes into contact with the D-pillar
reinforcement)

(4) 1 point (top · 2)

(7) 4 points (top · 1)

(2) 6 points (top · 1)

(5) 2 points (top · 1)

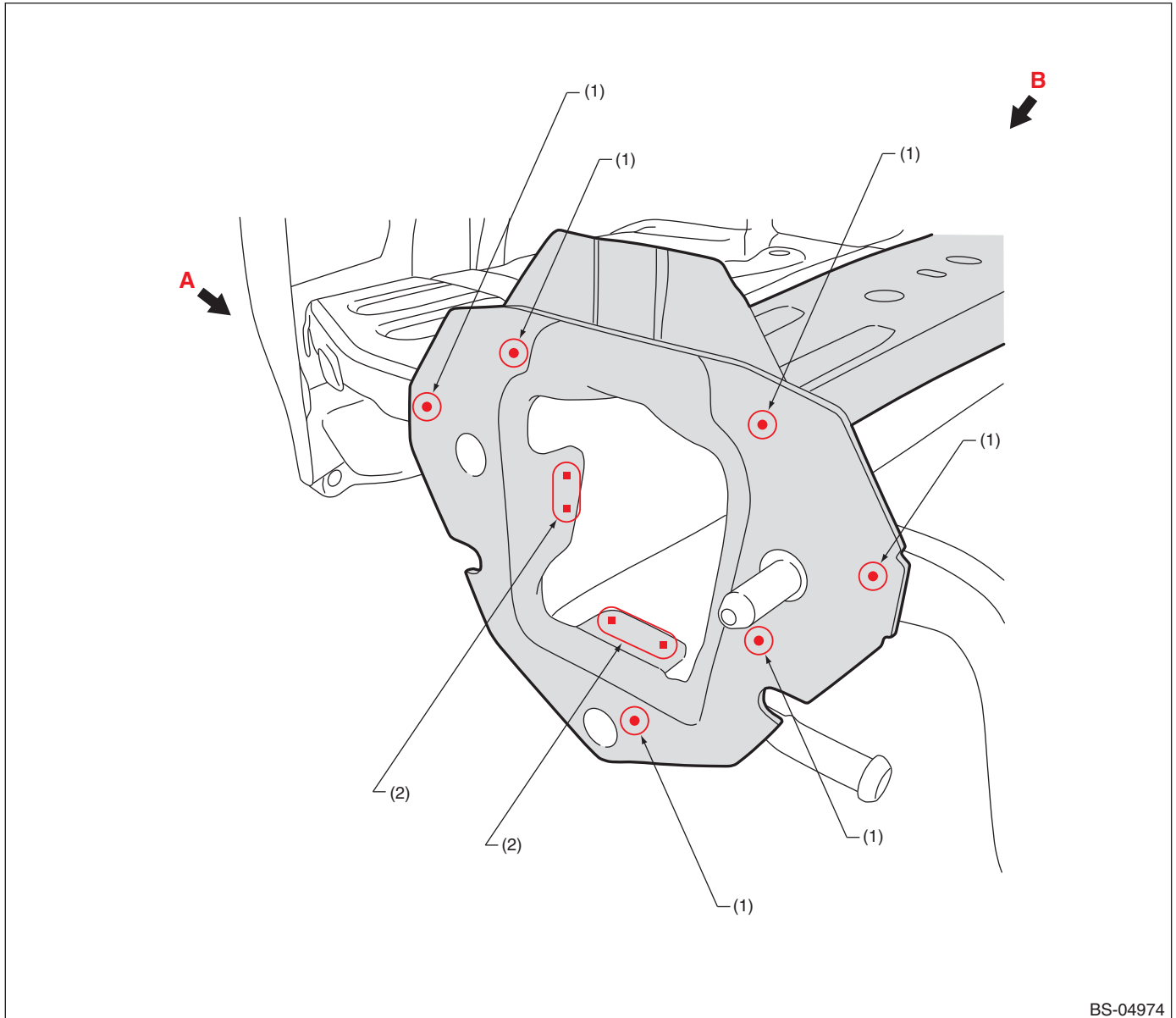
(3) 1 point (top · 1)

(6) 2 points (top · 2)

Panel Replacement

B: INSTALLATION

• Overall view



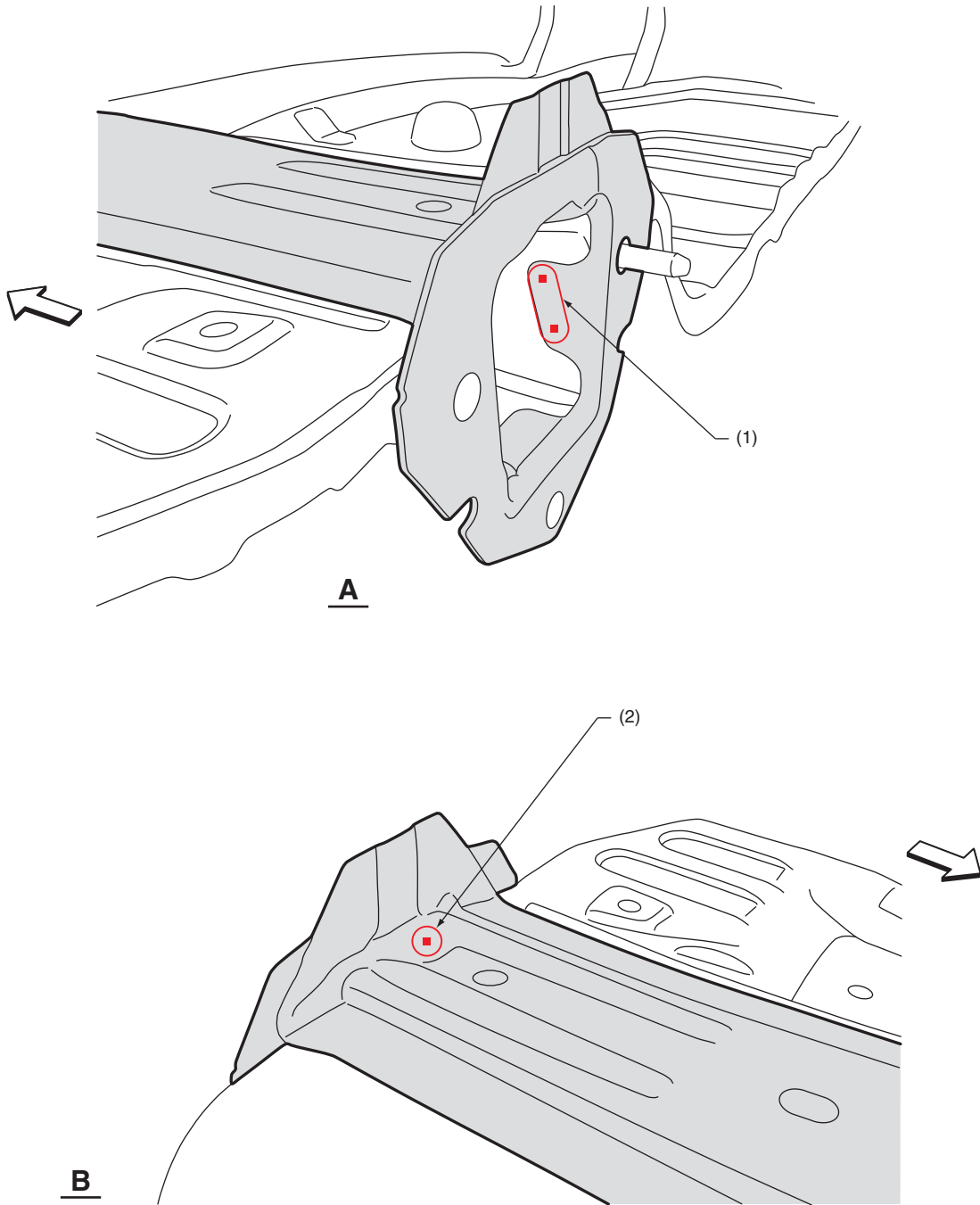
BS-04974

(1) 1 point

(2) 2 points

Panel Replacement

• Views

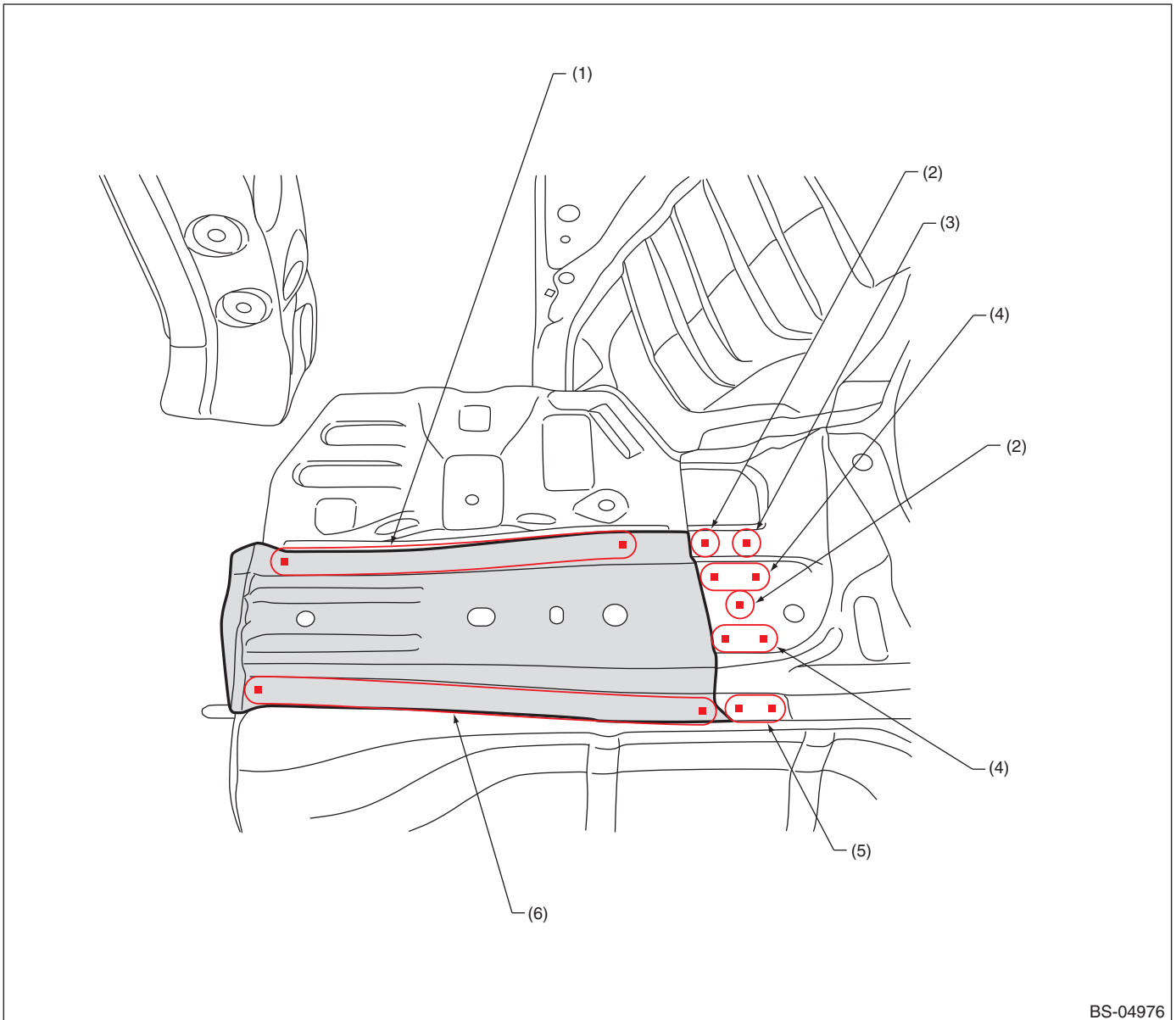


BS-04975

(1) 2 points (service)

(2) 1 point

Panel Replacement



BS-04976

(1) 6 points (service)

(2) 1 point

(3) 1 point (service · matching)

(4) 2 points

(5) 2 points (service · matching)

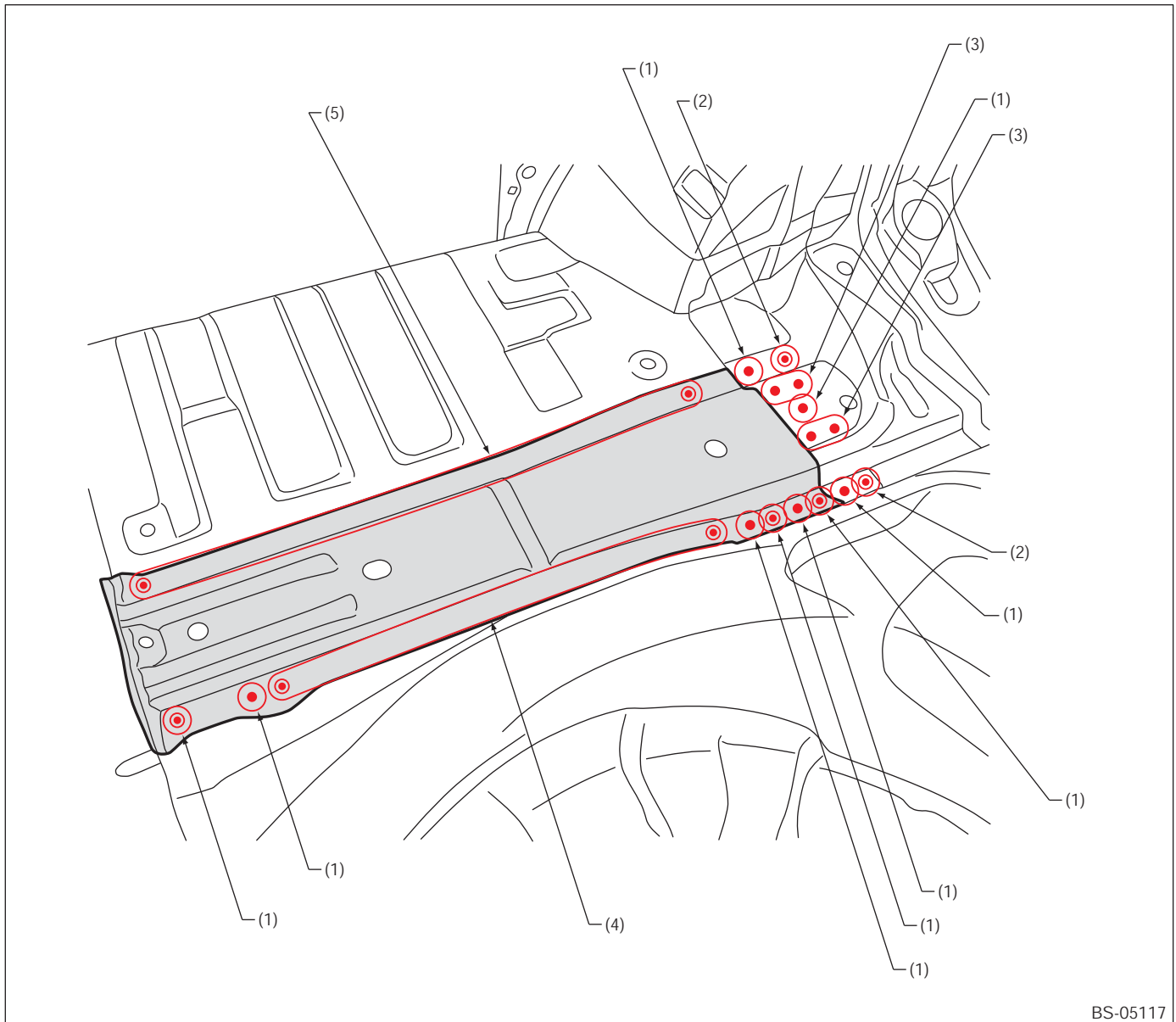
(6) 8 points (service)

Panel Replacement

7-31. Rear Side Frame Upper Rear (total replacement) / 4 Door

A: REMOVAL

- Rear skirt removal condition



BS-05117

(1) 1 point (top · 1)

(2) 1 point (top · 2)

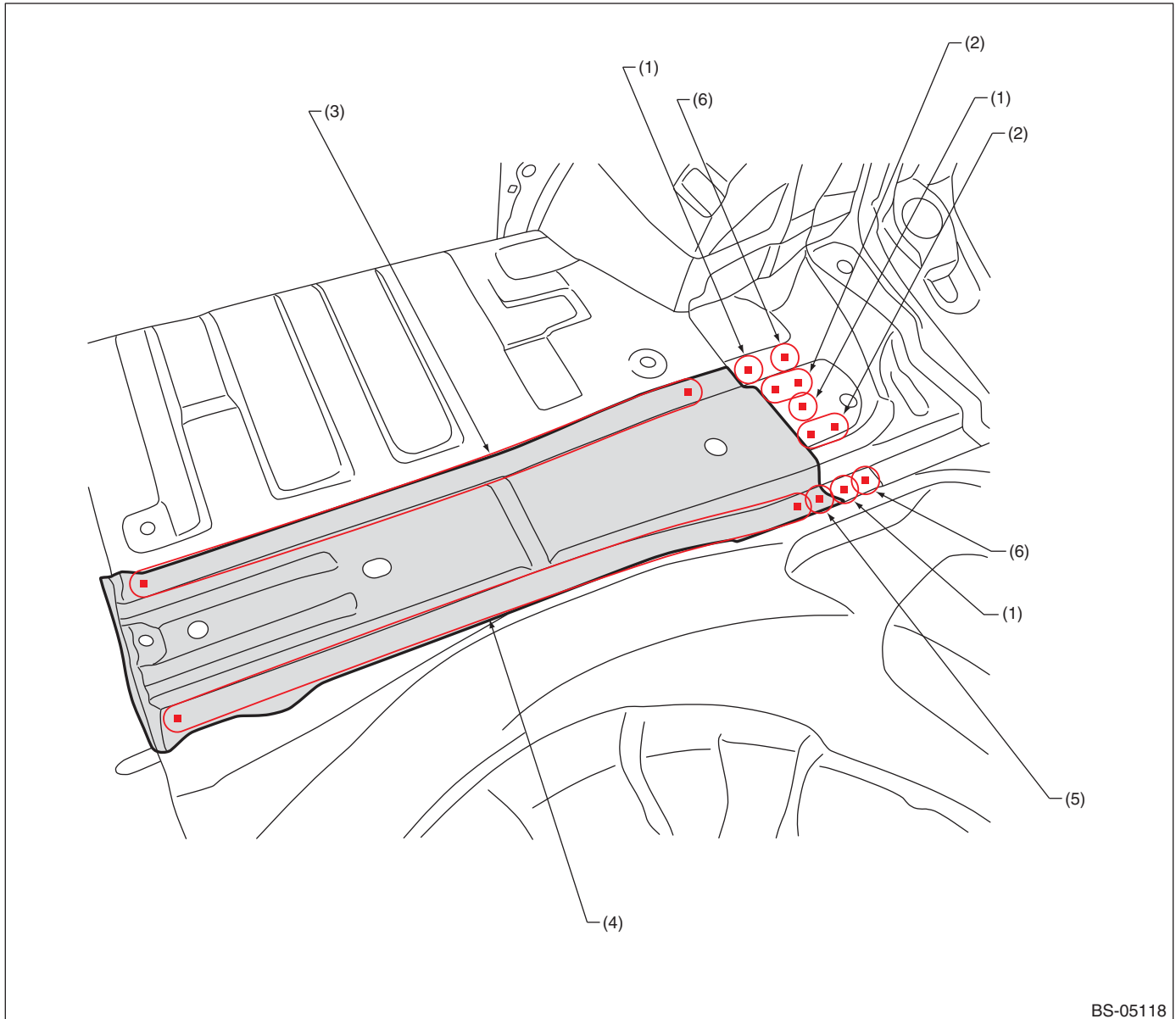
(3) 2 points (top · 1)

(4) 8 points (top · 1)

(5) 10 points (top · 1)

Panel Replacement

B: INSTALLATION



BS-05118

(1) 1 point
(2) 2 points

(3) 10 points (service)
(4) 12 points (service)

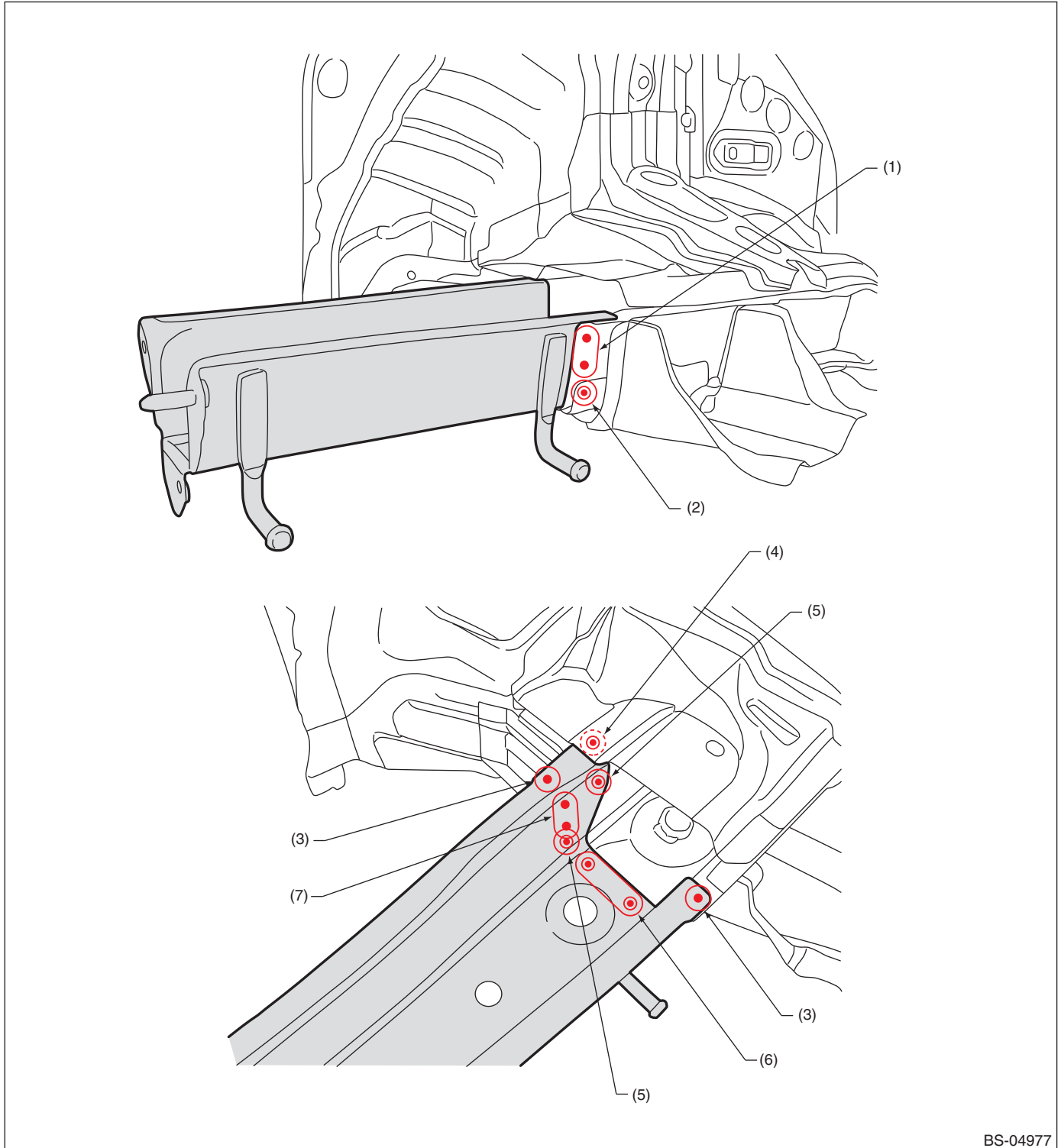
(5) 1 point (service)
(6) 1 point (service · matching)

Panel Replacement

7-32. Rear Side Frame Lower Rear (total replacement)

A: REMOVAL

- Rear skirt, rear side frame upper rear, rear floor pan and rear quarter outer removal condition



BS-04977

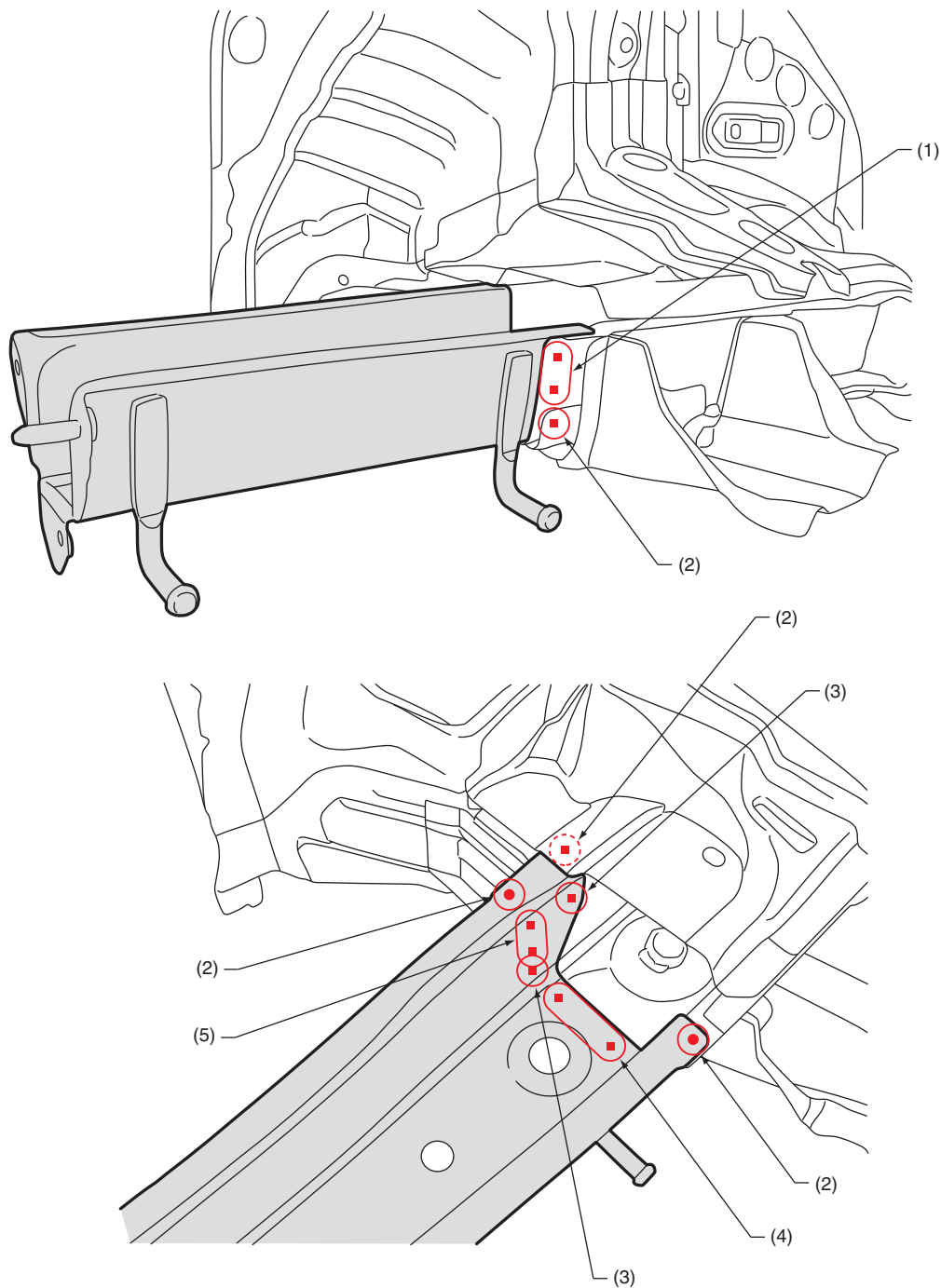
- (1) 2 points (inside · 1)
- (2) 1 point (inside · 2)
- (3) 1 point (top · 1)

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

- (7) 2 points (inside · 1, belt sander)

Panel Replacement

B: INSTALLATION



BS-04978

(1) 2 points
(2) 1 point

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

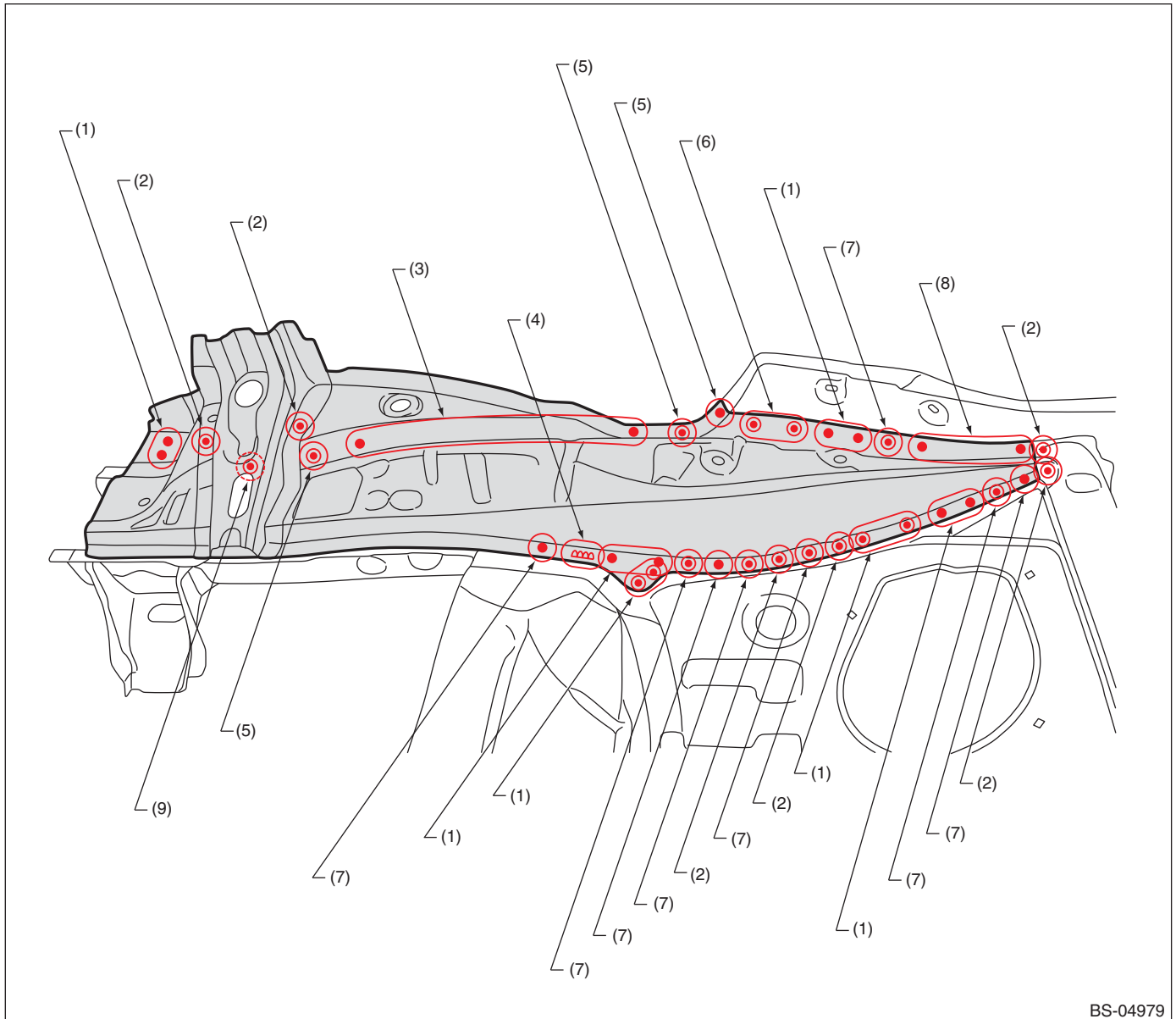
(5) 2 points (service)

Panel Replacement

7-33. Closing Plate (total replacement)

A: REMOVAL

- Rear skirt, rear floor pan, rear side frame upper rear and rear quarter outer & inner removal condition



BS-04979

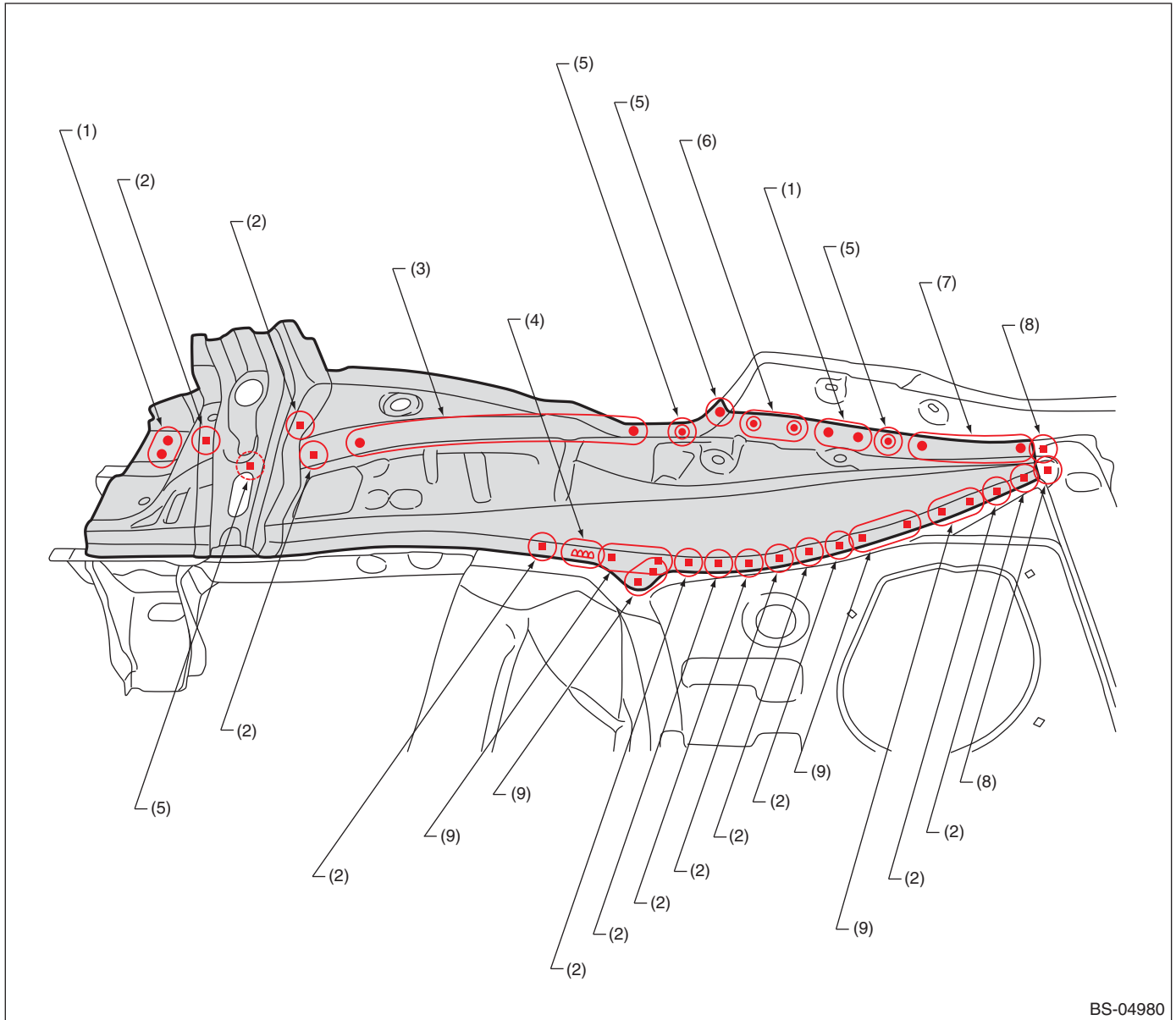
- (1) 2 points (top - 1)
- (2) 1 point (top - 2)
- (3) 8 points (inside - 1)

- (4) 1 point (top - 1, belt sander)
- (5) 1 point (inside - 1)
- (6) 2 points (top - 2)

- (7) 1 point (top - 1)
- (8) 3 points (top - 1)
- (9) 1 point (outside - 2)

Panel Replacement

B: INSTALLATION



BS-04980

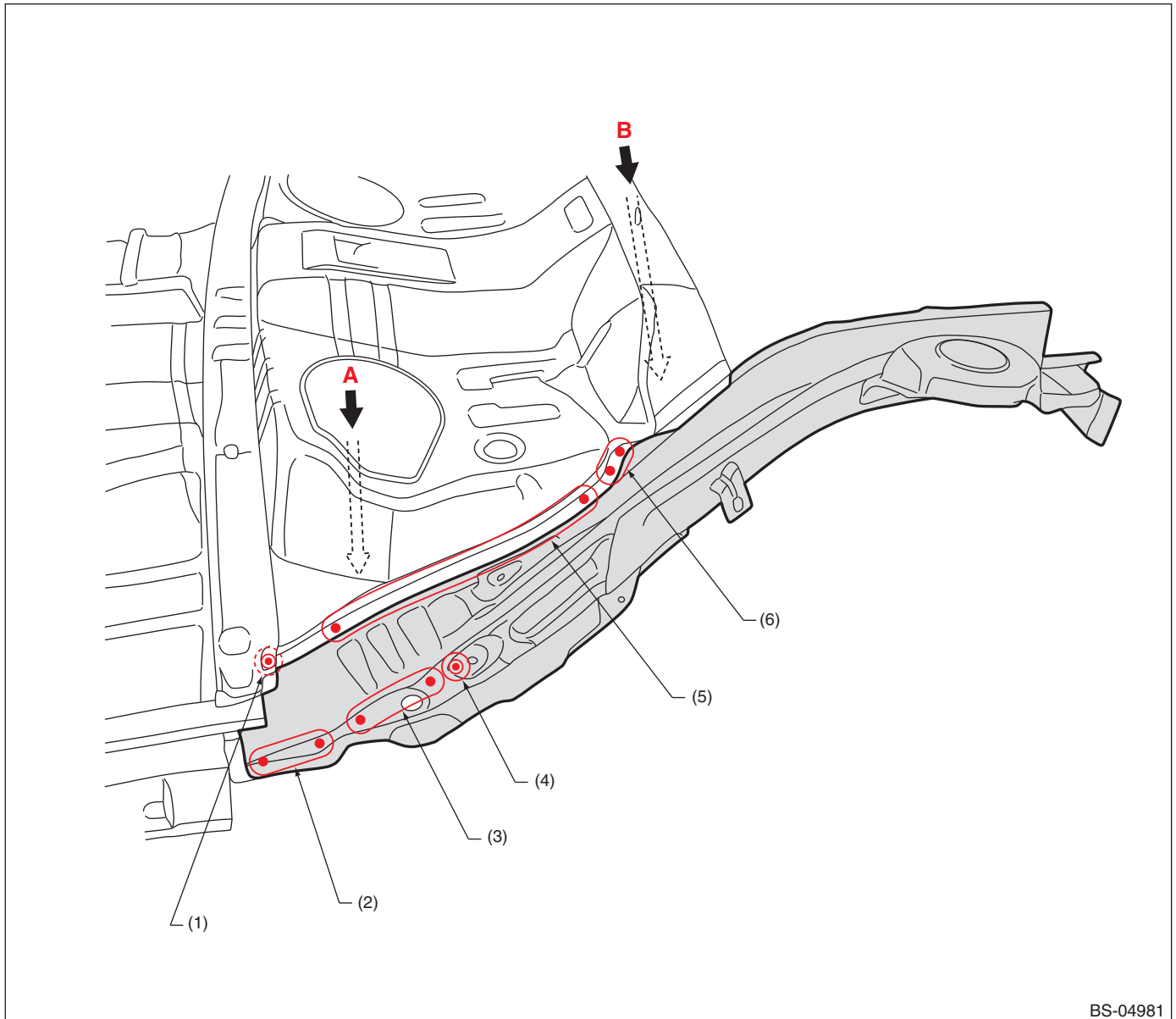
- | | | |
|-----------------------|-------------------------------|----------------------------------|
| (1) 2 points | (4) 1 point [20 mm (0.79 in)] | (7) 4 points |
| (2) 1 point (service) | (5) 1 point | (8) 1 point (service - matching) |
| (3) 9 points | (6) 3 points | (9) 2 points (service) |

Panel Replacement

7-34. Rear Frame (total replacement)

A: REMOVAL

• Overall view (Rear skirt, rear side frame upper rear, rear floor pan and quarter panel outer & inner, closing plate, side sill reinforcement and side sill inner rear removal condition)



BS-04981

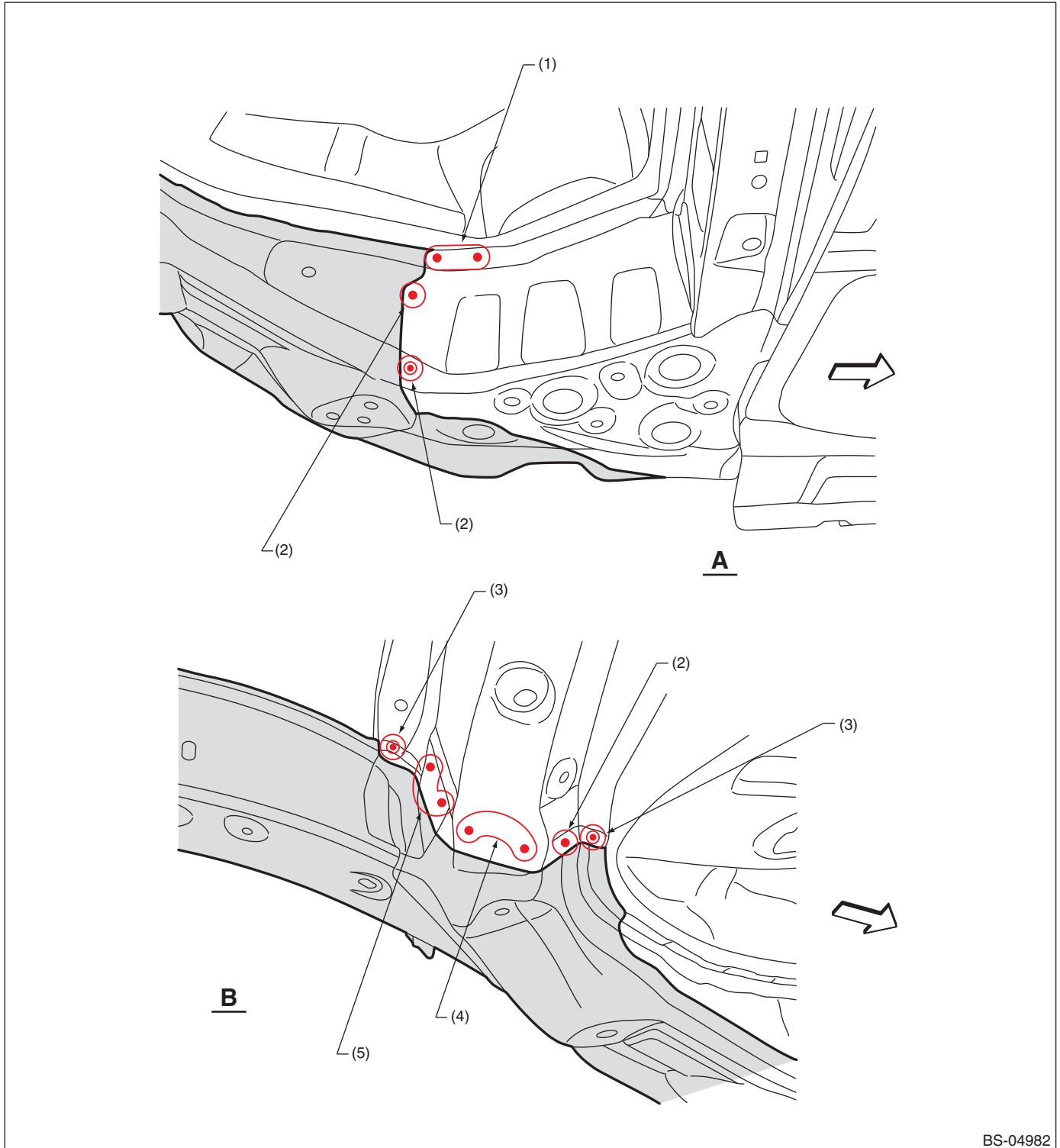
(1) 1 point (top · 1)
(2) 3 points (outside · 1)

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

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

Panel Replacement

• Views



BS-04982

(1) 2 points (bottom · 1)

(2) 1 point (inside · 1)

(3) 1 point (bottom · 1)

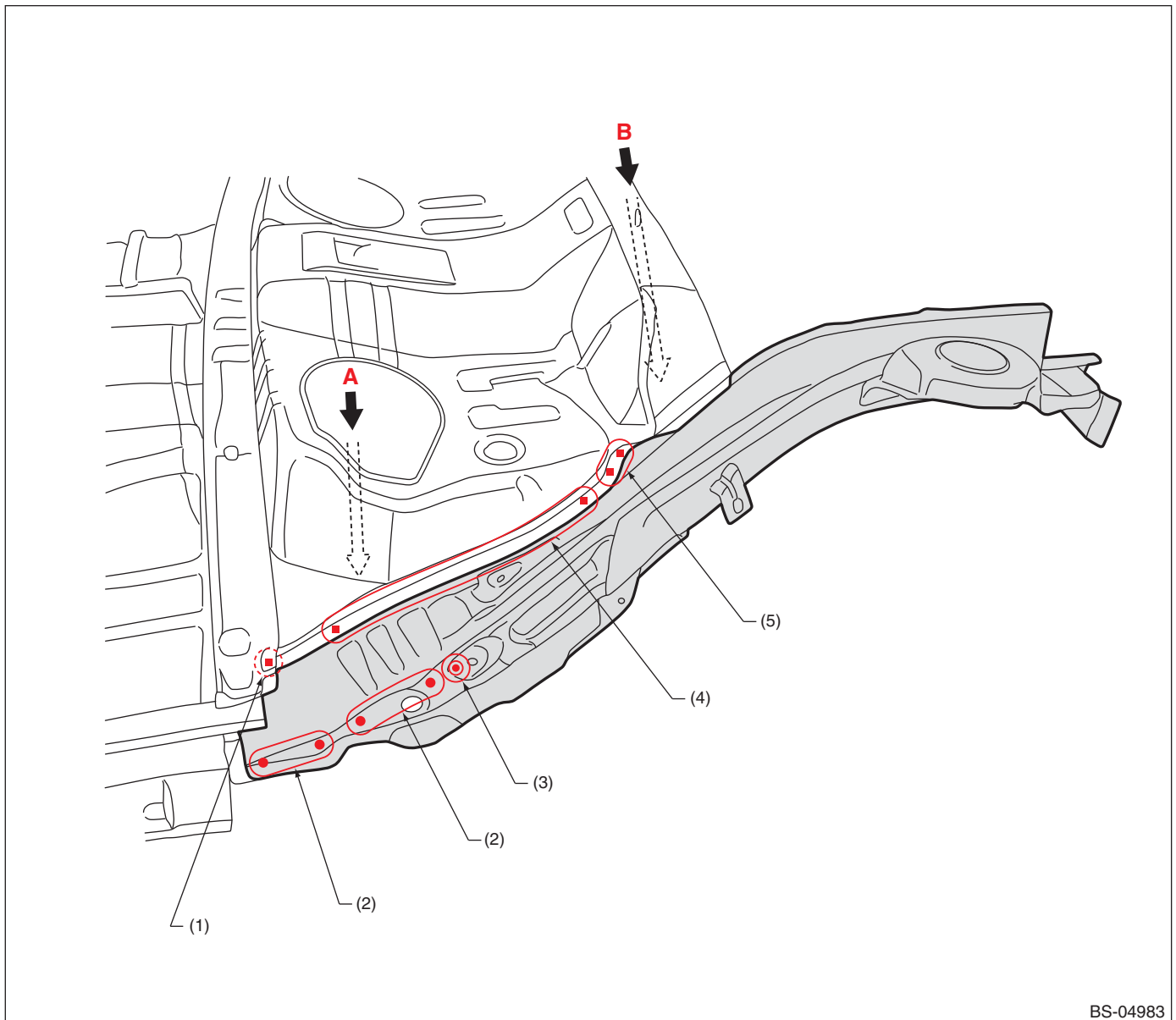
(4) 3 points (bottom · 1)

(5) 3 points (outside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



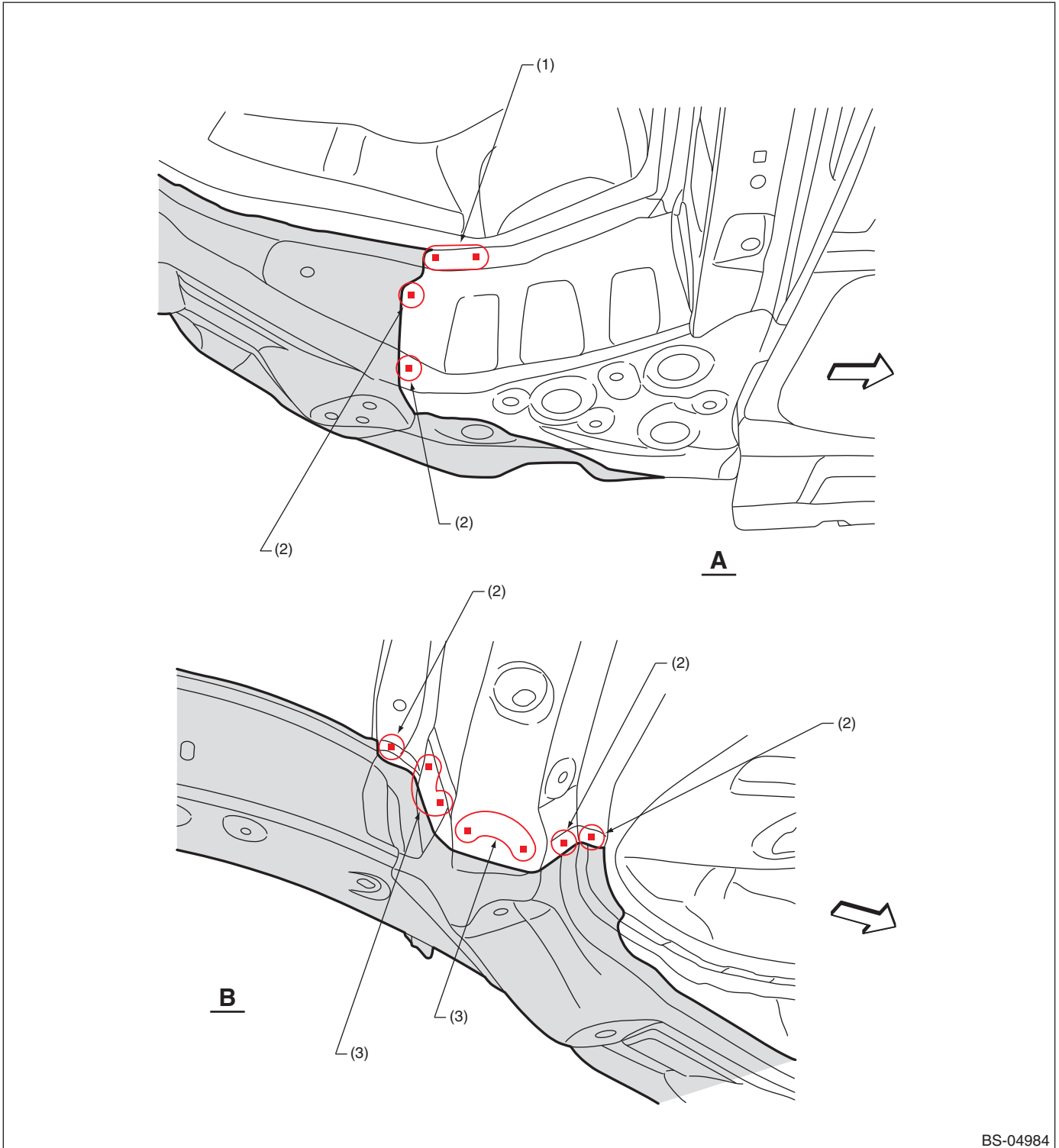
(1) 1 point (service)
(2) 3 points

(3) 1 point
(4) 5 points

(5) 2 points

Panel Replacement

• Views



BS-04984

(1) 2 points

(2) 1 point

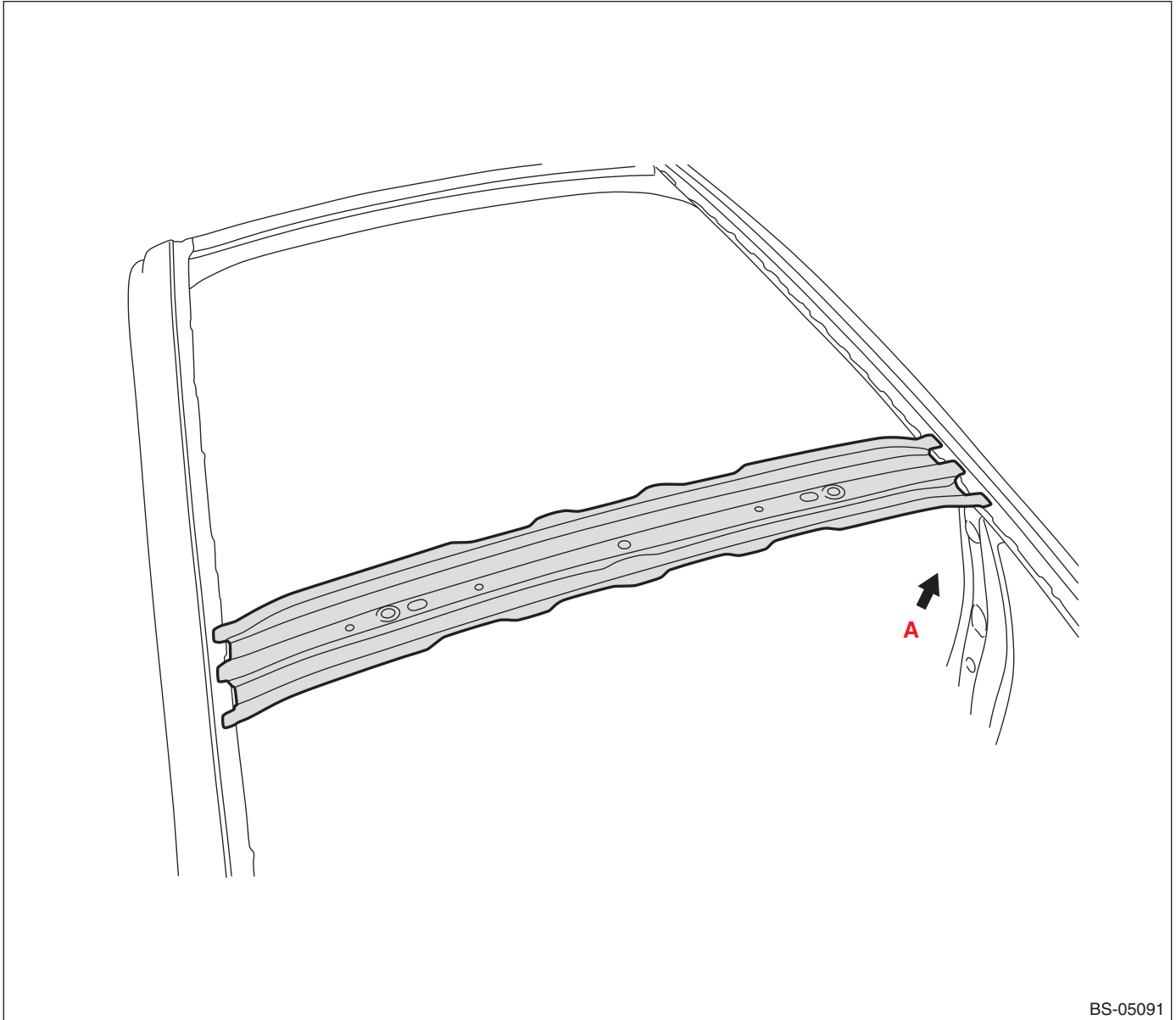
(3) 3 points

Panel Replacement

7-35. Roof Center Brace (total replacement)

A: REMOVAL

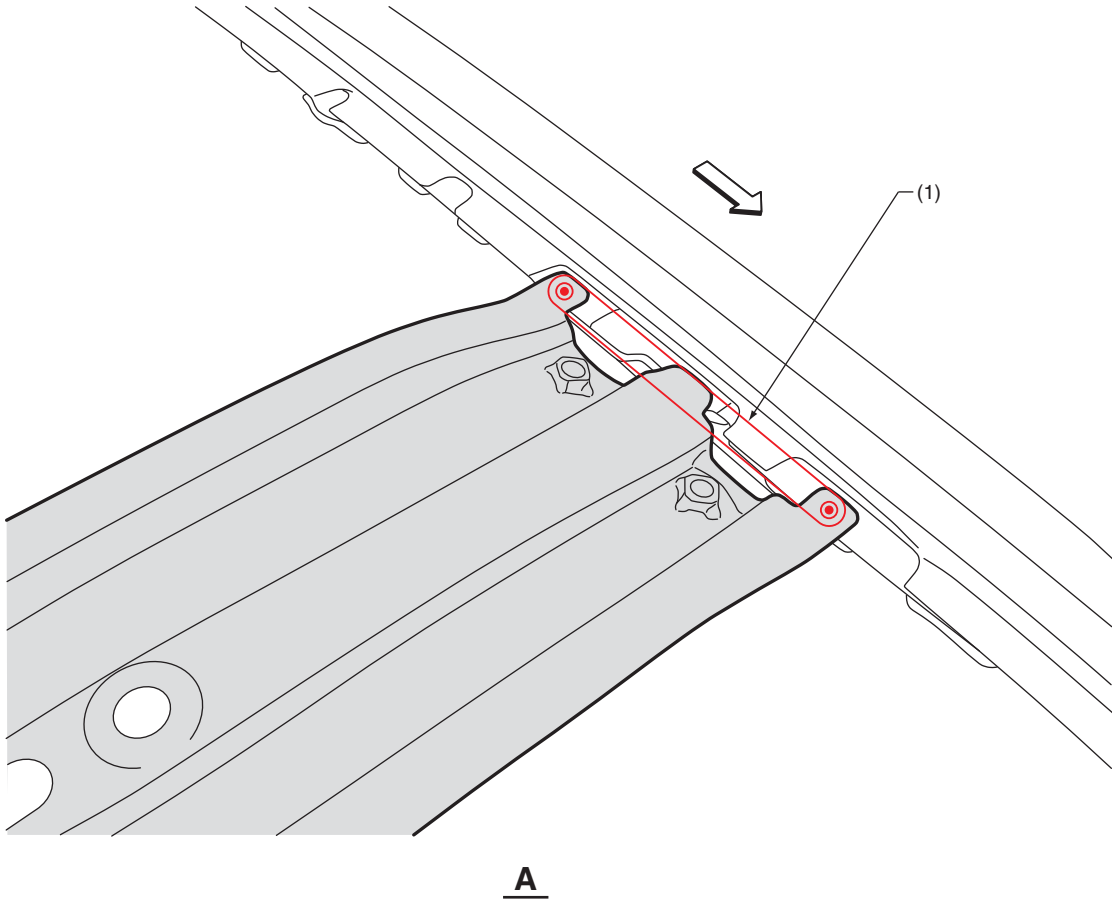
- Overall view (Roof panel removal condition)



BS-05091

Panel Replacement

• Views



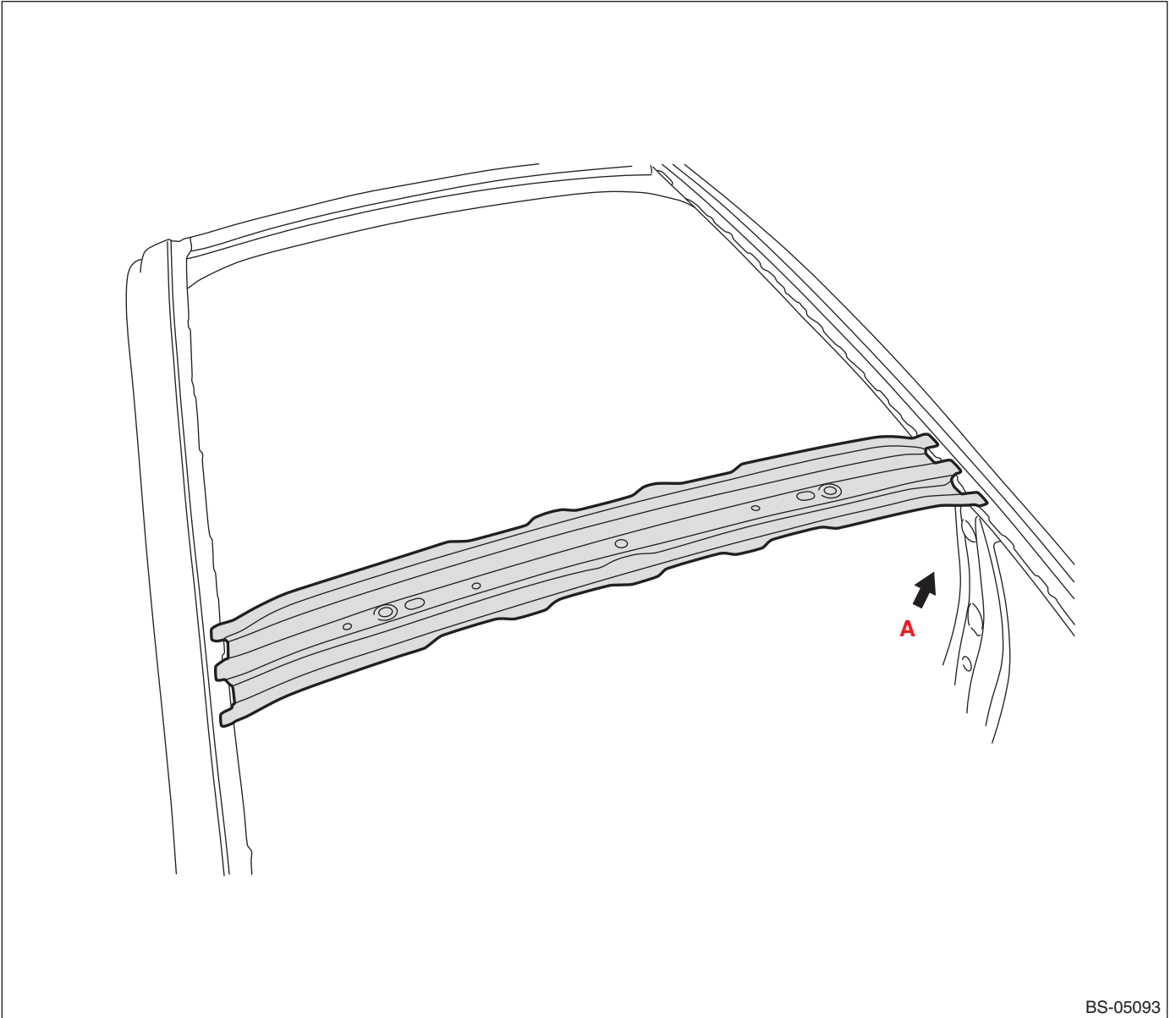
BS-05092

(1) 3 points (top · 1)

Panel Replacement

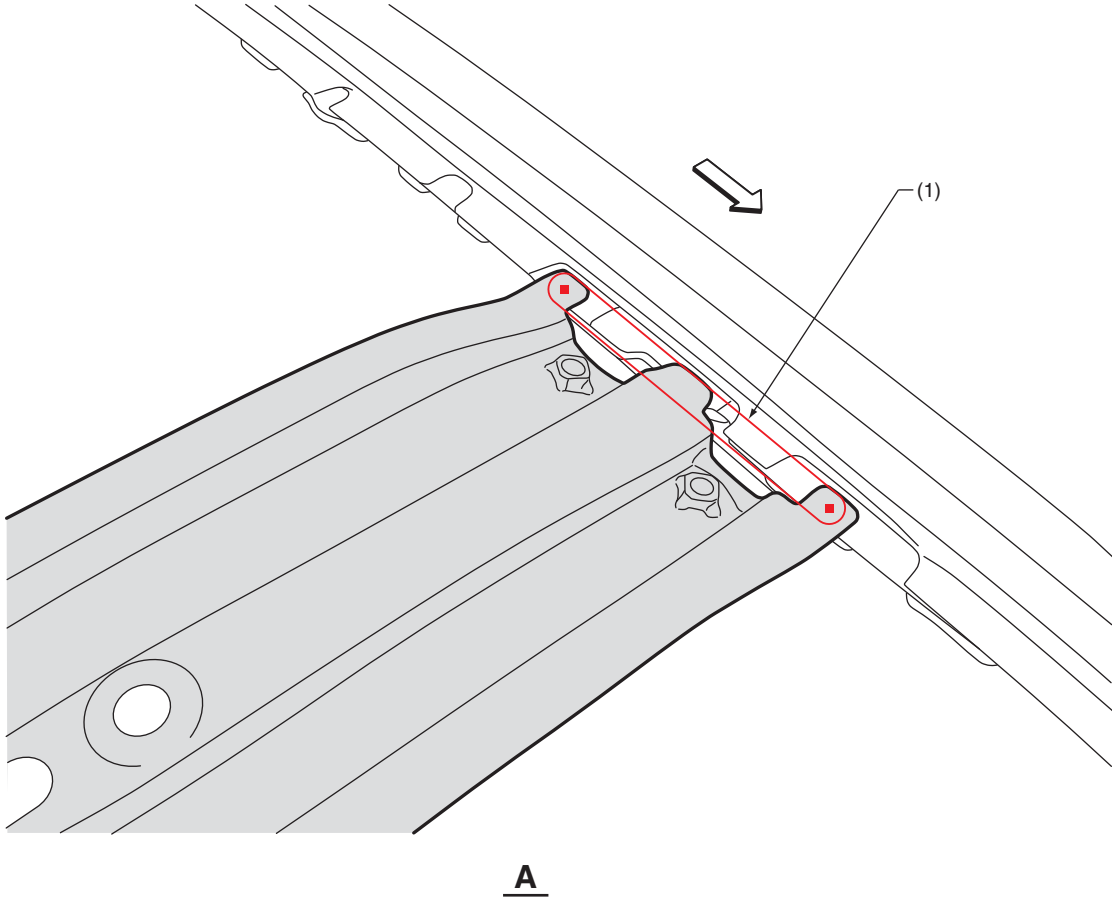
B: INSTALLATION

• Overall view



Panel Replacement

• Views



BS-05094

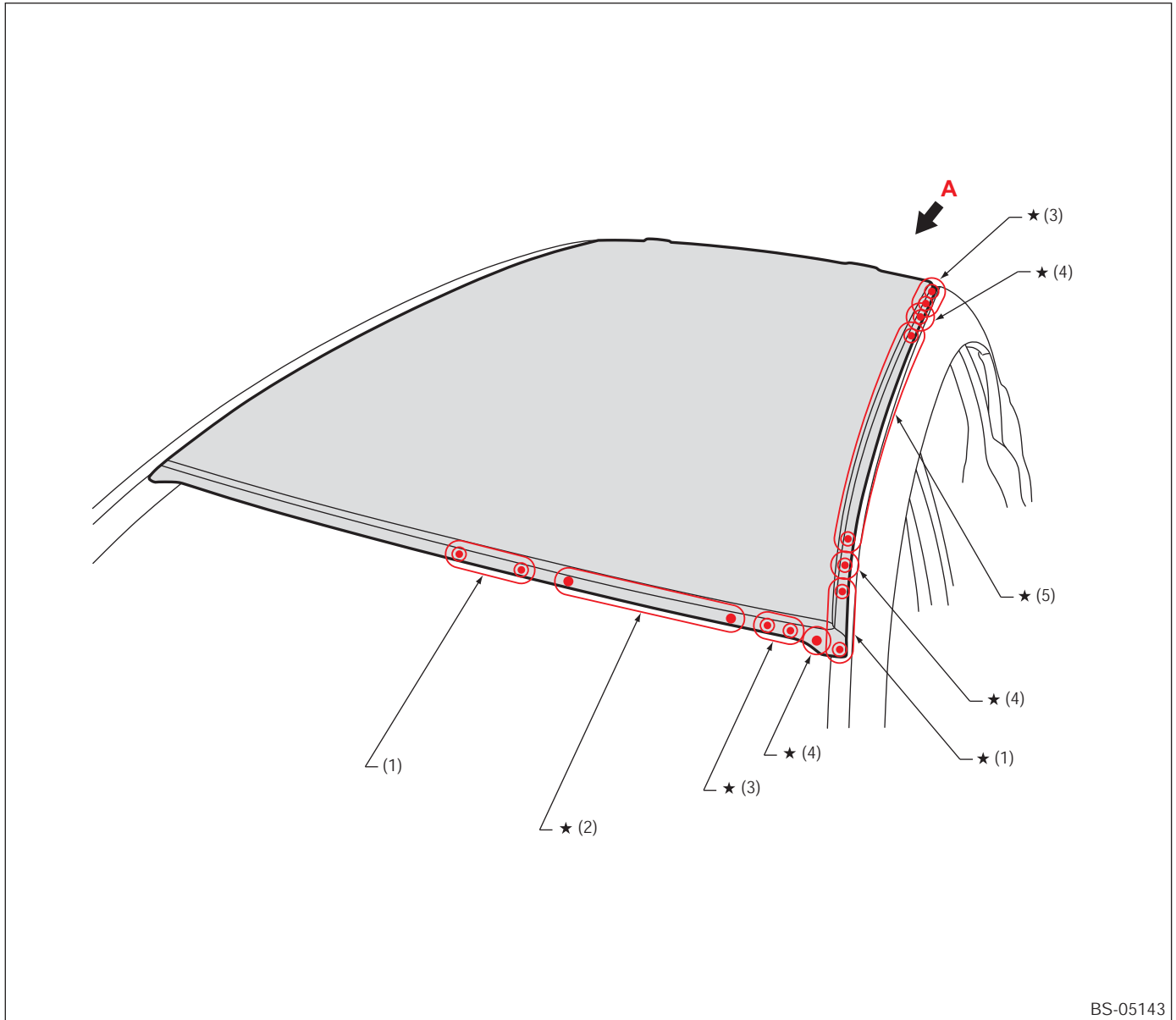
(1) 3 points

Panel Replacement

7-36. Roof Panel (total replacement) / 5 Door

A: REMOVAL

• Overall view



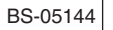
(1) 3 points (top · 1)
(2) 4 points (top · 1)

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

(5) 15 points (top · 1)

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

- **Views**

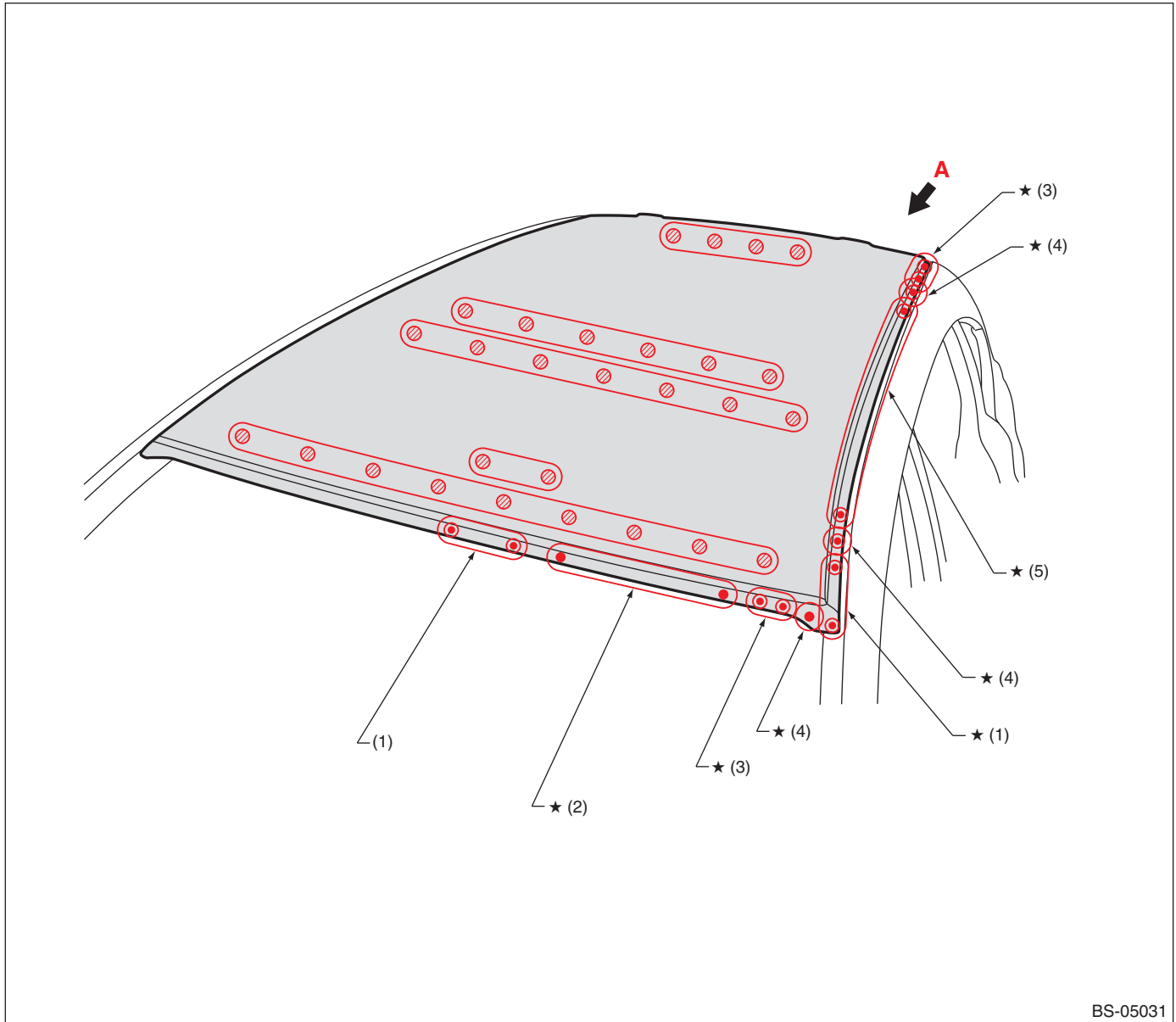


- For locations marked by “★”: The welding method and the number of welding points are the same on the left and the right.

Panel Replacement

B: INSTALLATION

• Overall view



BS-05031

(1) 3 points
(2) 4 points

(3) 2 points
(4) 1 point

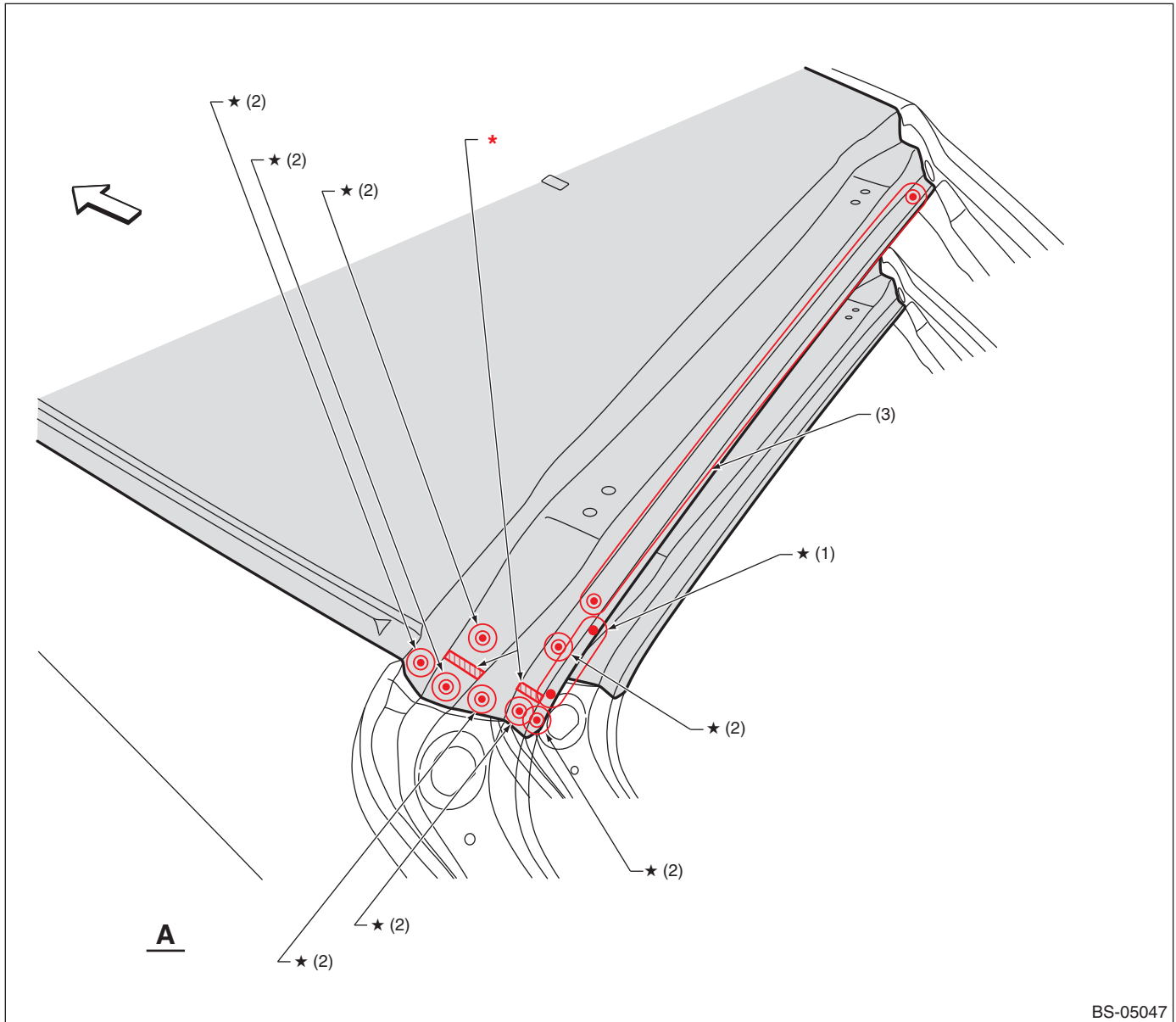
(5) 15 points

For locations marked by “★”: The welding method and the number of welding points are the same on the left and the right.

⊗ : Application of adhesive.

Panel Replacement

• Views



BS-05047

(1) 3 points

(2) 1 point

(3) 15 points

- For locations marked by “★”: The welding method and the number of welding points are the same on the left and the right.
- For the installation of the roof panel side rail. It is recommended to weld the base together with other three overlapping sheets.

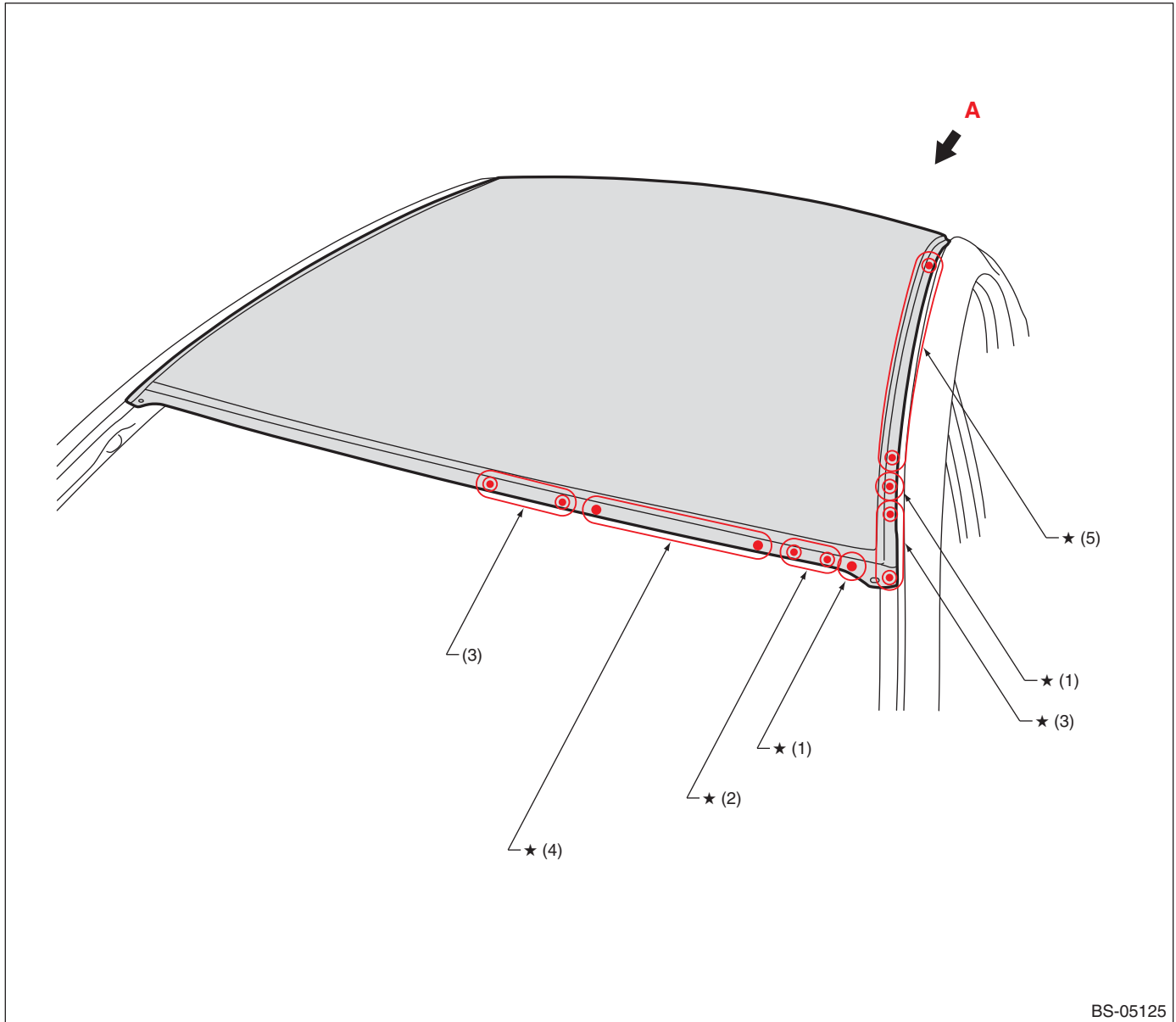
*: Panel bond 3M#8115 Auto mix. Same coating location for both left and right.

Panel Replacement

7-37. Roof Panel (total replacement) / 4 Door

A: REMOVAL

• Overall view



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

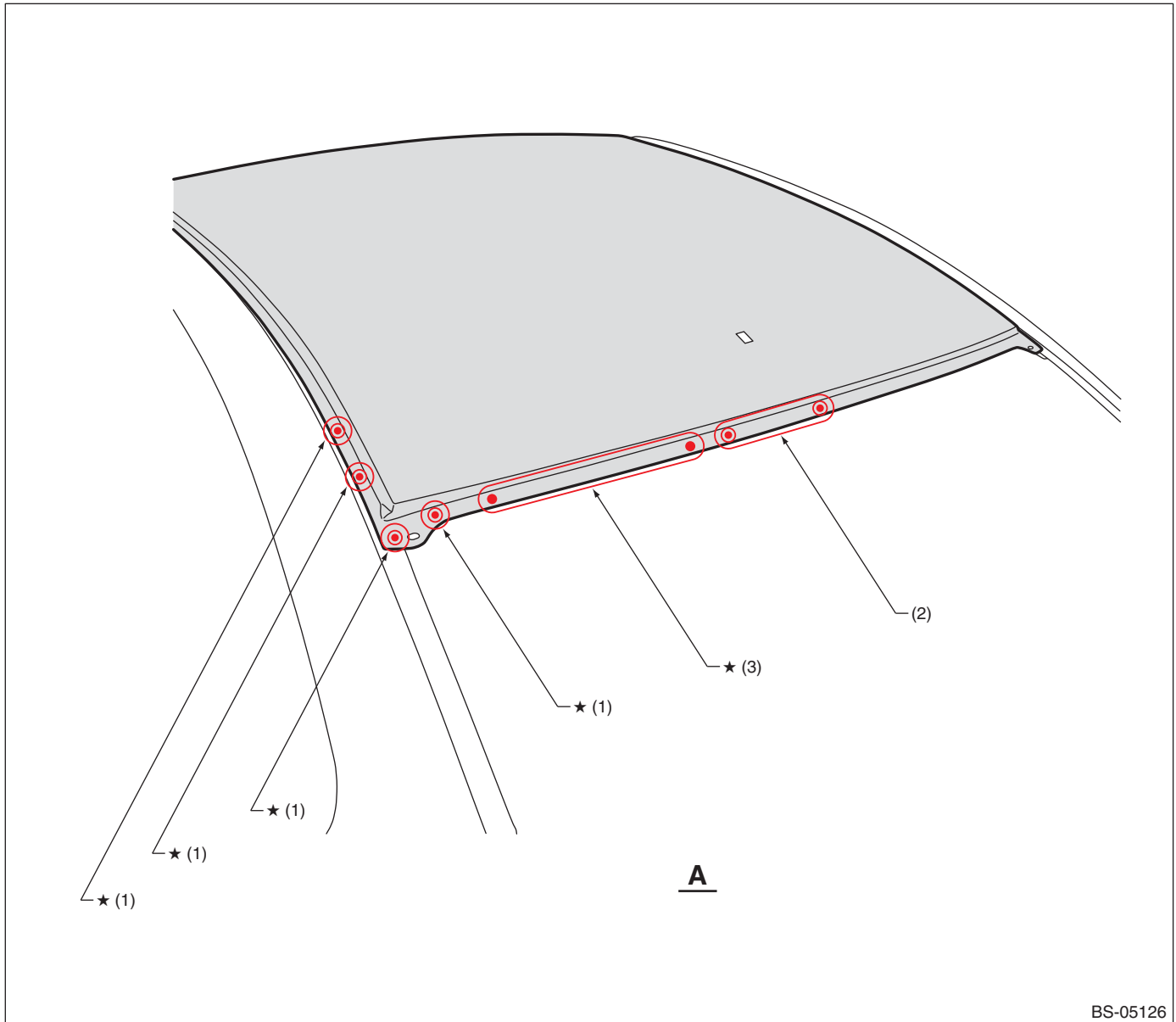
(3) 3 points (top · 1)
(4) 4 points (top · 1)

(5) 11 points (top · 1)

For locations marked by “★”: The welding method and the number of welding points are the same on the left and the right.

Panel Replacement

• Views



(1) 1 point (top · 1)

(2) 3 points (top · 1)

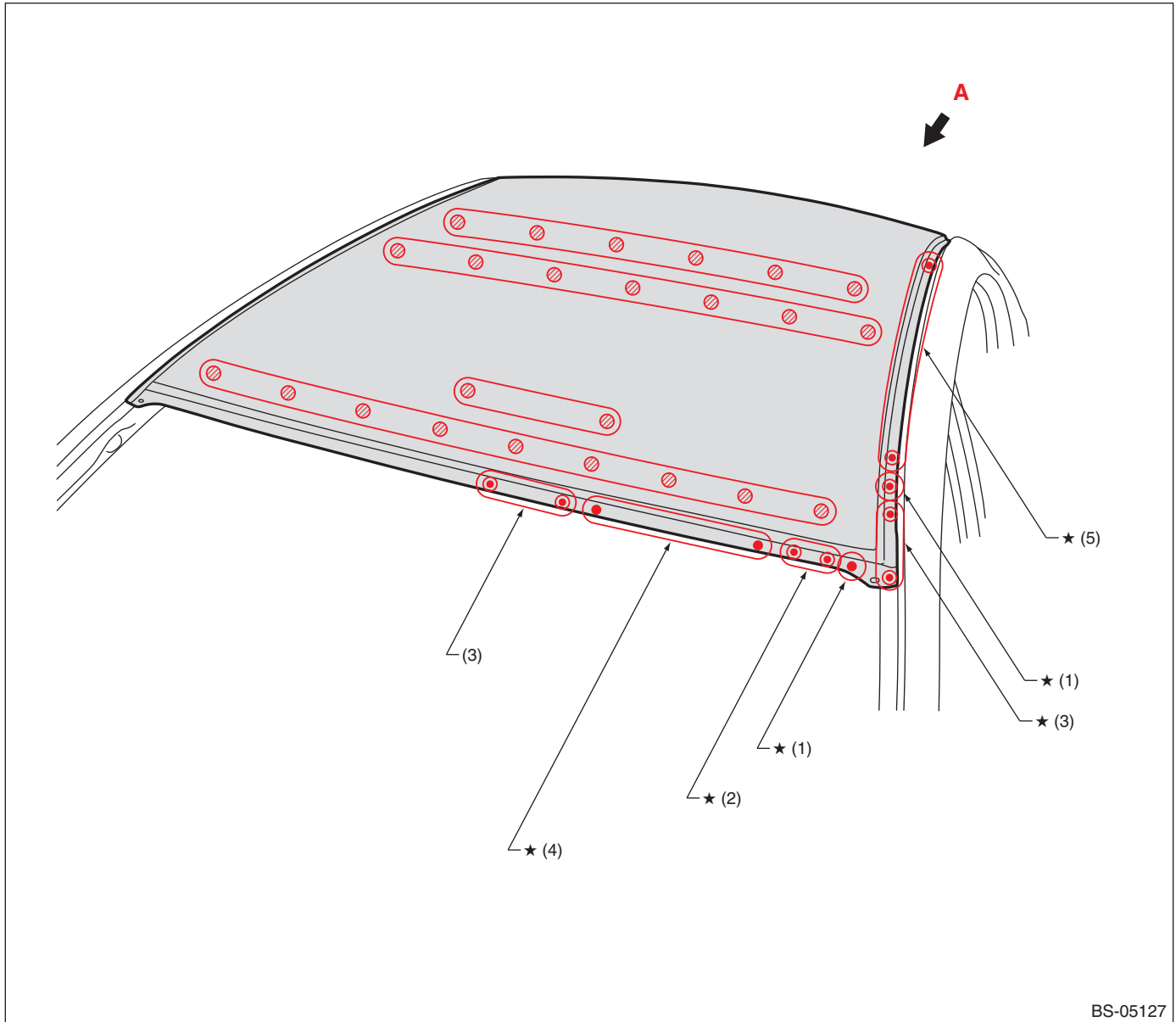
(3) 5 points (top · 1)

For locations marked by “★”: The welding method and the number of welding points are the same on the left and the right.

Panel Replacement

B: INSTALLATION

• Overall view



(1) 1 point
(2) 2 points

(3) 3 points
(4) 4 points

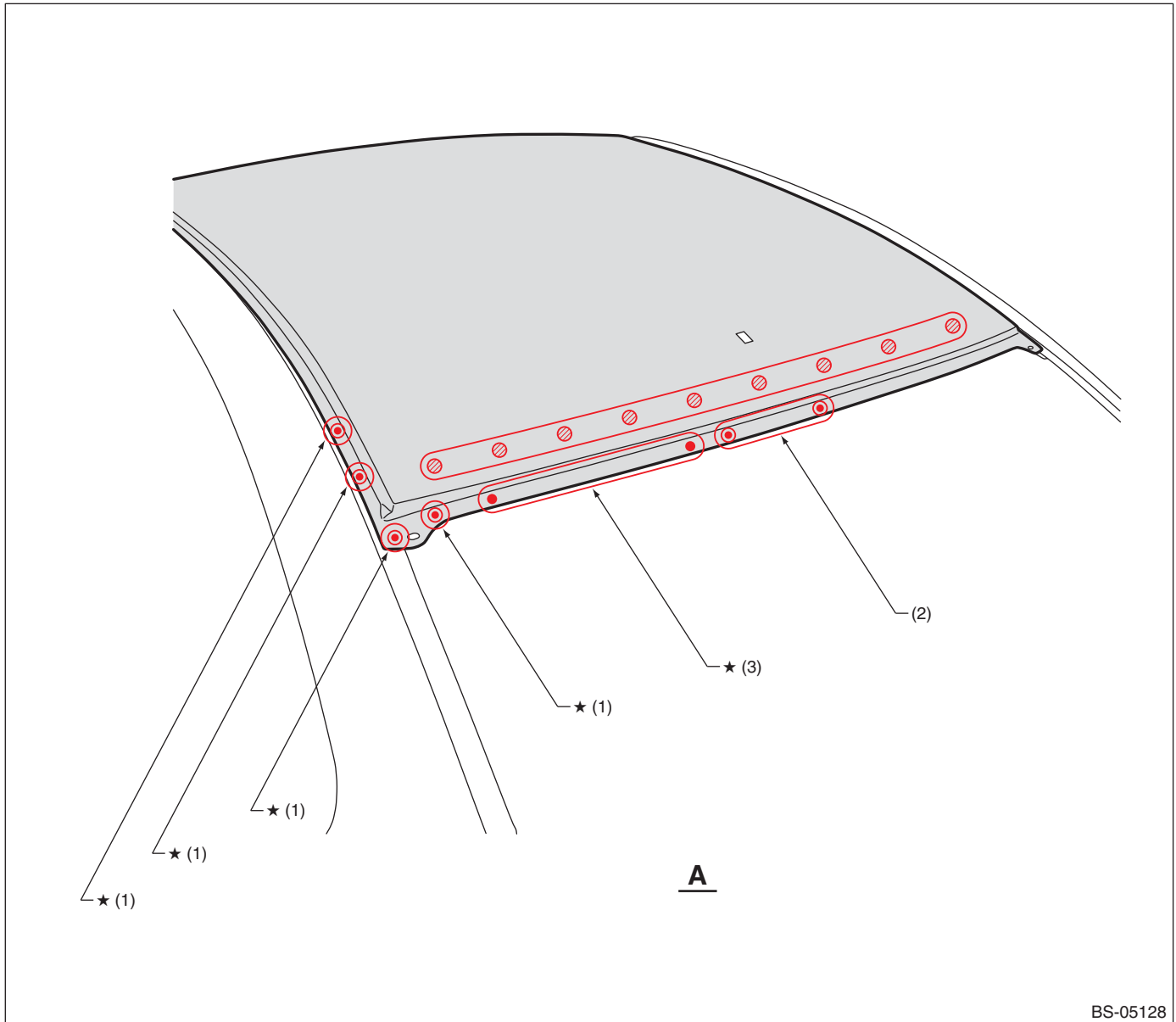
(5) 11 points

For locations marked by “★”: The welding method and the number of welding points are the same on the left and the right.

⊗ : Application of adhesive.

Panel Replacement

• Views



(1) 1 point

(2) 3 points

(3) 5 points

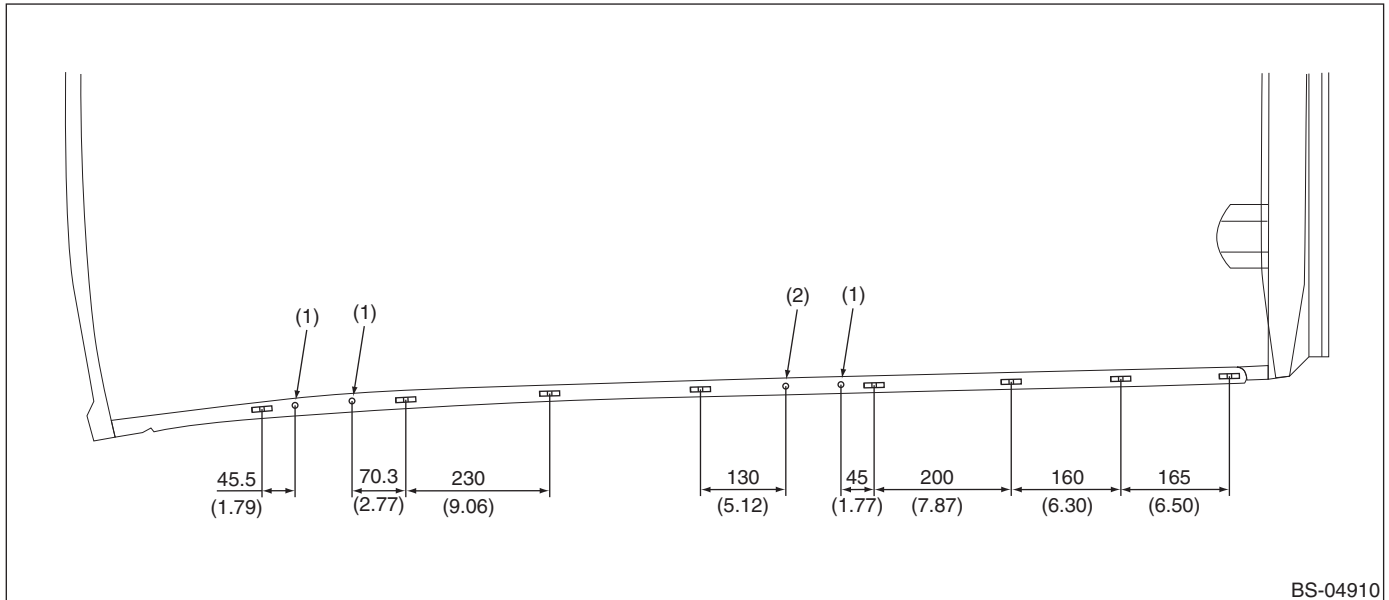
For locations marked by “★”: The welding method and the number of welding points are the same on the left and the right.

⊗ : Application of adhesive.

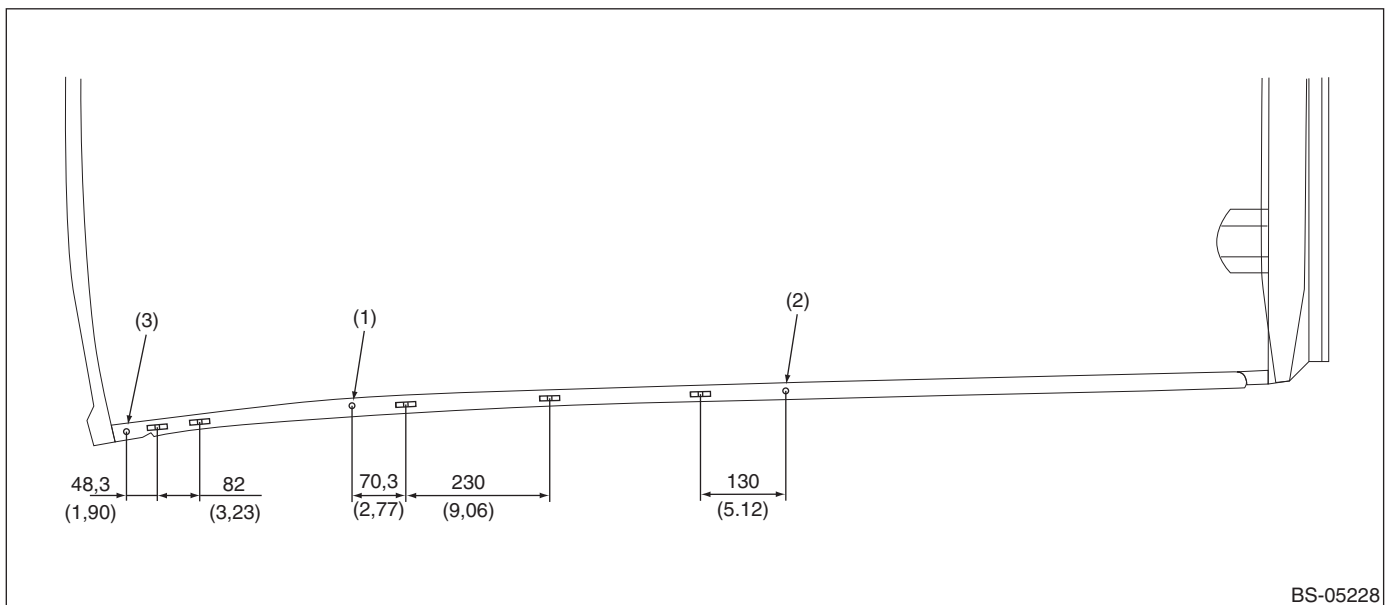
Panel Replacement

7-38. T Stud Installation

• 5 Door (Model without roof rail)

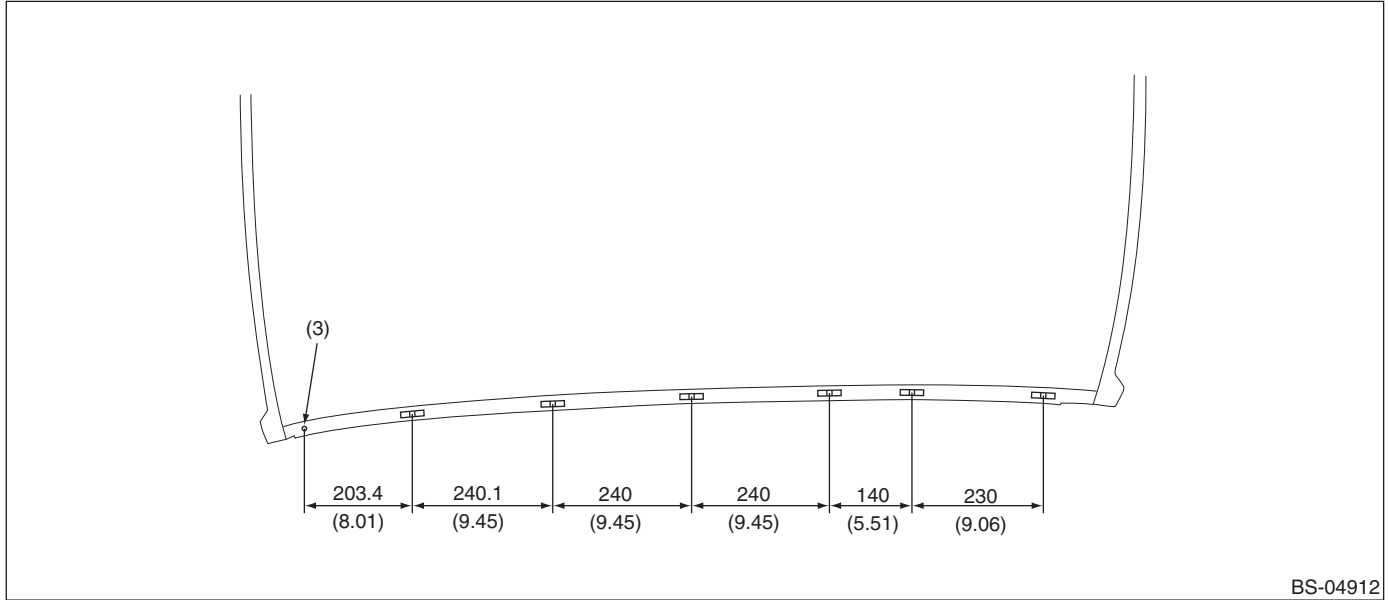


• 5 Door (Model with roof rail)

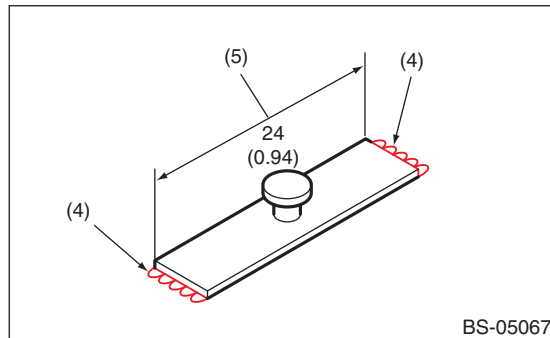


Panel Replacement

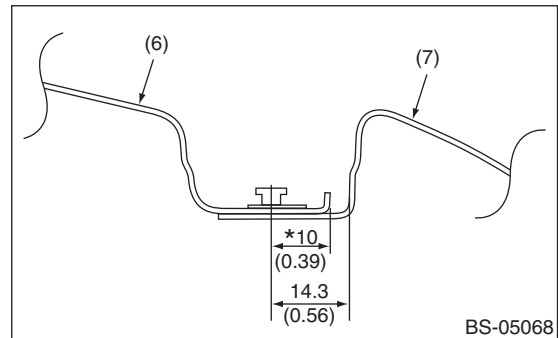
• 4 Door



• T stud welding



• T stud basic cross section



- | | | |
|---|--|----------------------|
| (1) 6.2×8.1 mm (0.24×0.32 in) elongated hole (for carrier bracket installation) | (4) Arc welding for both plate ends | (7) Side panel outer |
| (2) $\phi 6.2$ mm (0.24 in) hole (for carrier bracket installation) | (5) This surface shall be kept flat as it becomes the mating face with the clip. | |
| (3) $\phi 5.2$ mm (0.20 in) hole (for roof mole, standard pop rivet hole) | (6) Roof panel | |

* Indicates dimensions for reference.

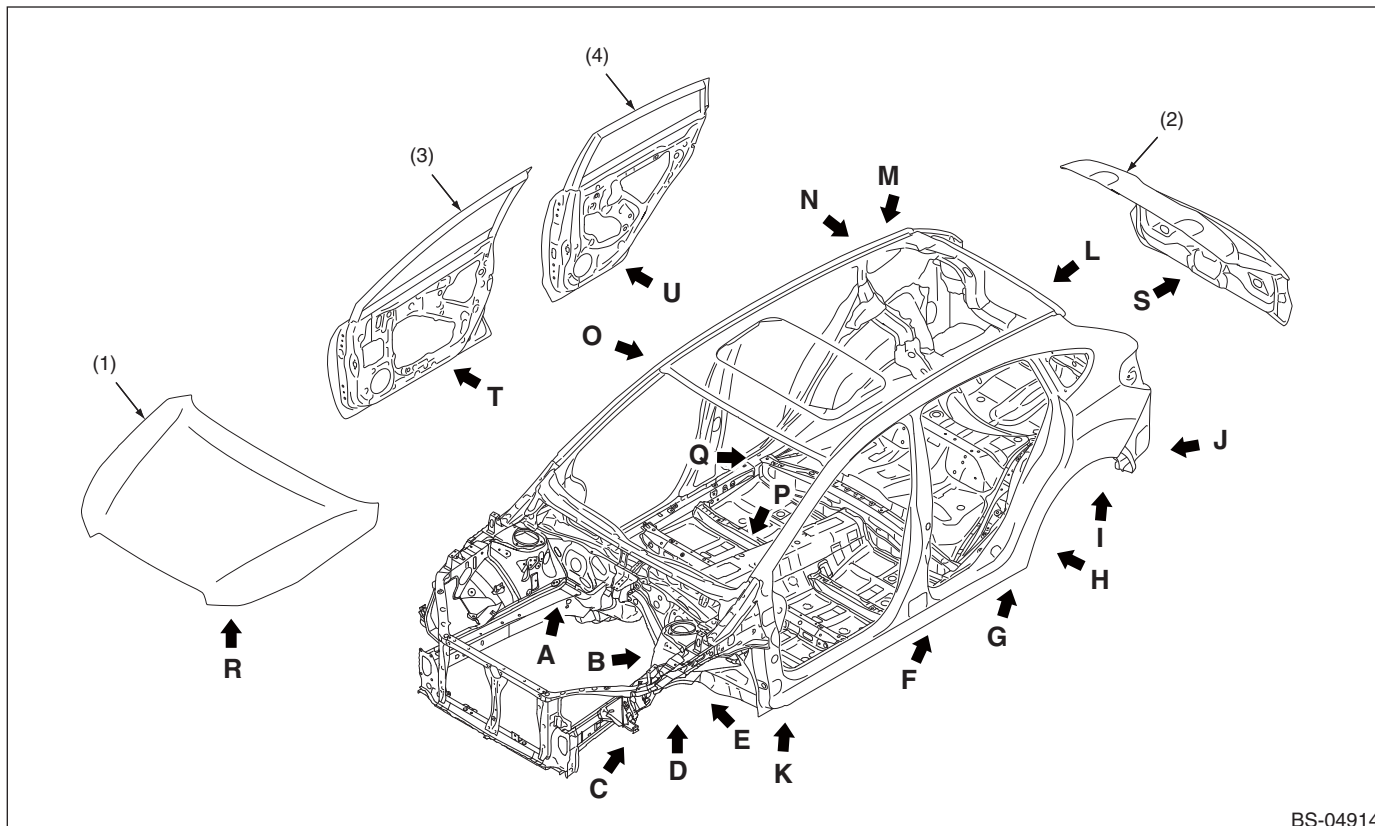
8. Body Sealing

A: SPECIFICATIONS

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

— : Sealer application location

1. COMMON PARTS FOR 5 DOOR AND 4 DOOR

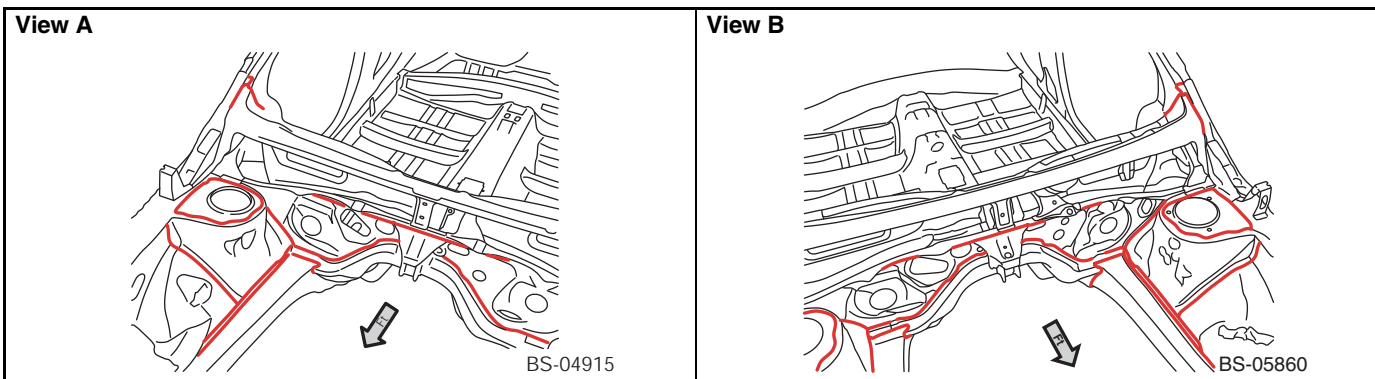


BS-04914

- (1) Front hood
- (2) Rear gate

- (3) Front door

- (4) Rear door

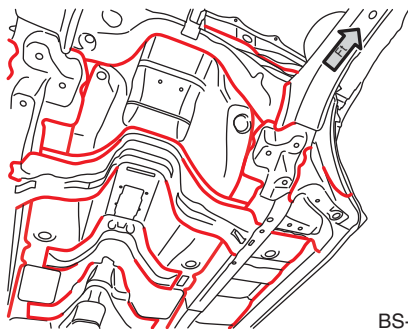


BS-04915

BS-05860

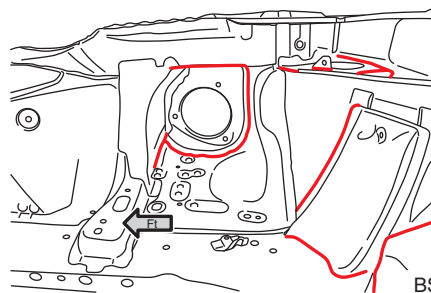
Body Sealing

View C



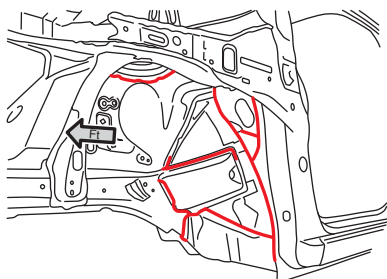
BS-05864

View D



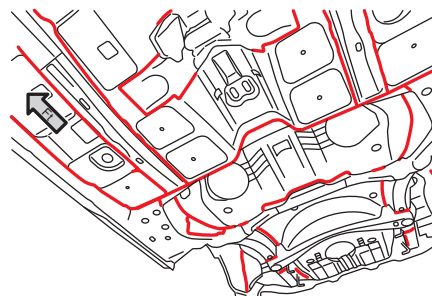
BS-05865

View E



BS-04919

View F



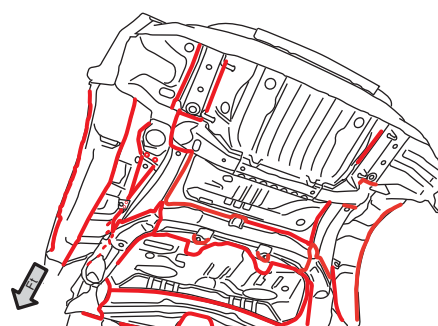
BS-05866

View G (Except for Hybrid model)



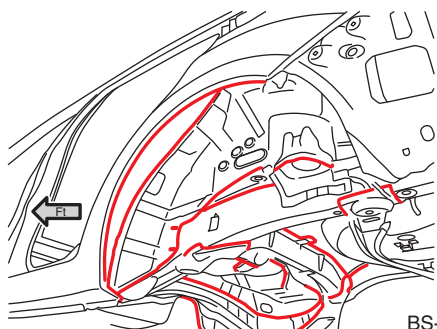
BS-05867

View G (Hybrid model)



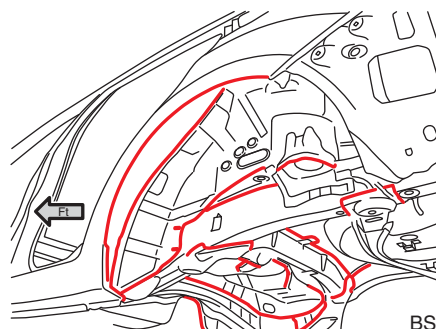
BS-05819

View H (Except for XV model)



BS-05868

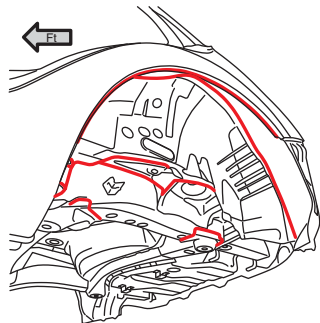
View H (XV model)



BS-05869

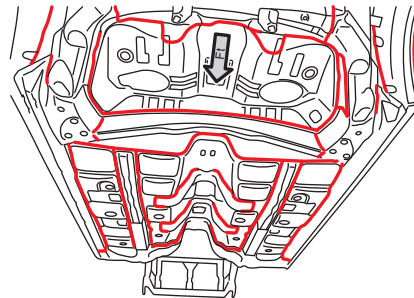
Body Sealing

View I



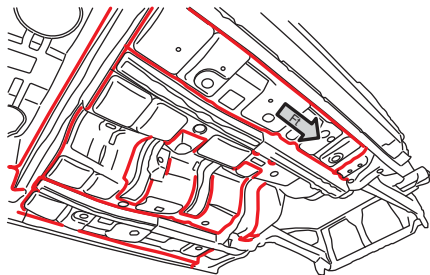
BS-05825

View J



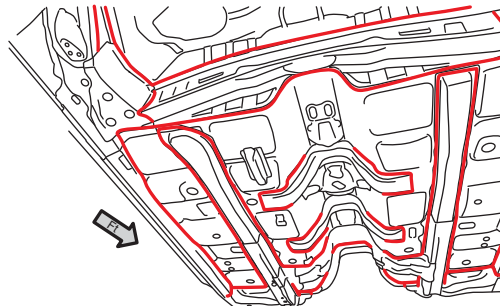
BS-05870

View K (Except for Hybrid model)



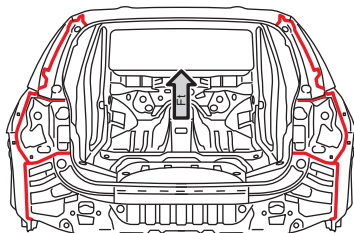
BS-05887

View K (Hybrid model)



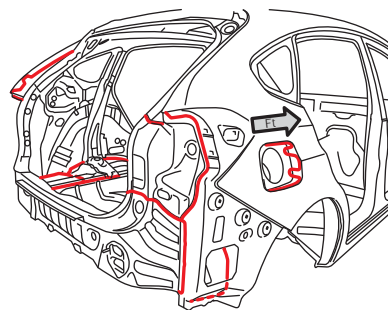
BS-05820

View L



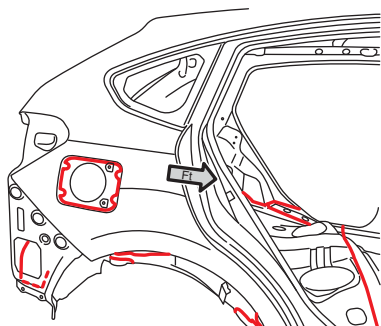
BS-04926

View M



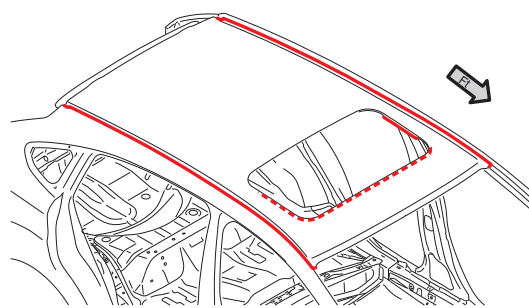
BS-04927

View N



BS-04928

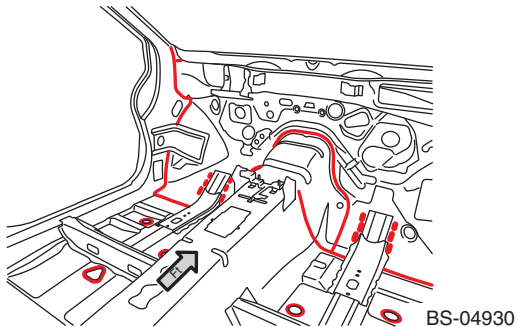
View O



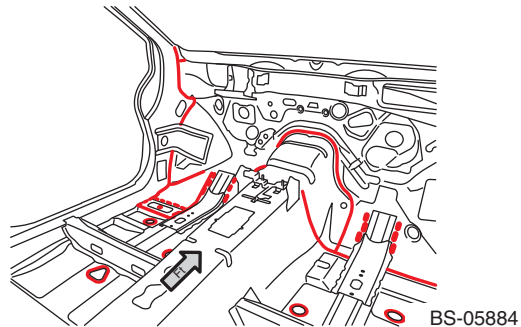
BS-04929

Body Sealing

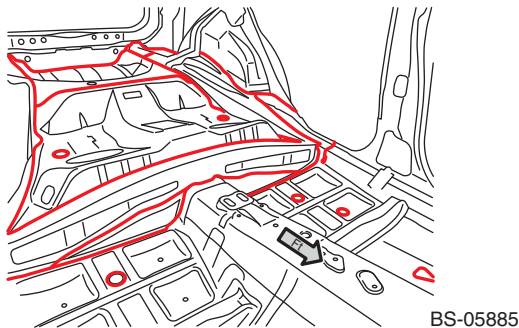
View P (12MY & 13MY)



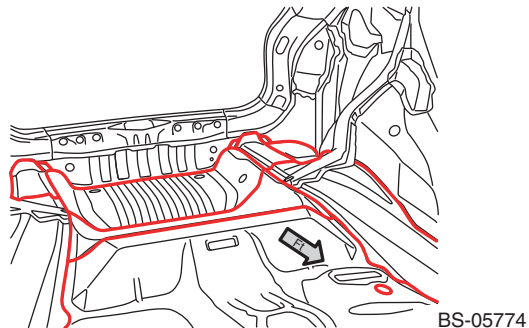
View P (14MY)



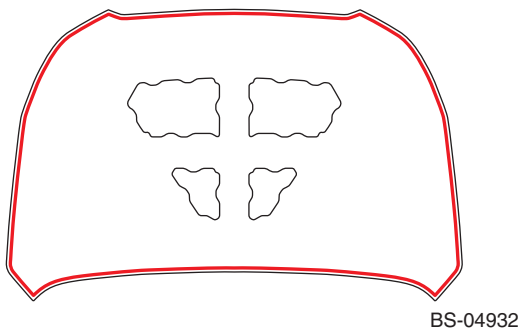
View Q (Except for Hybrid model)



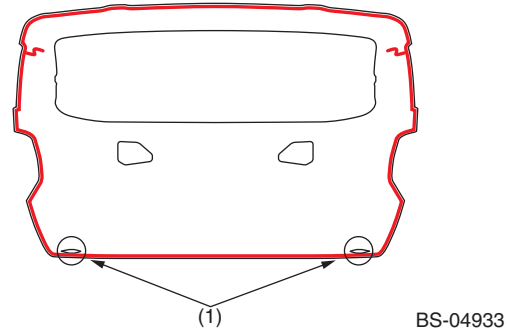
View Q (Hybrid model)



View R



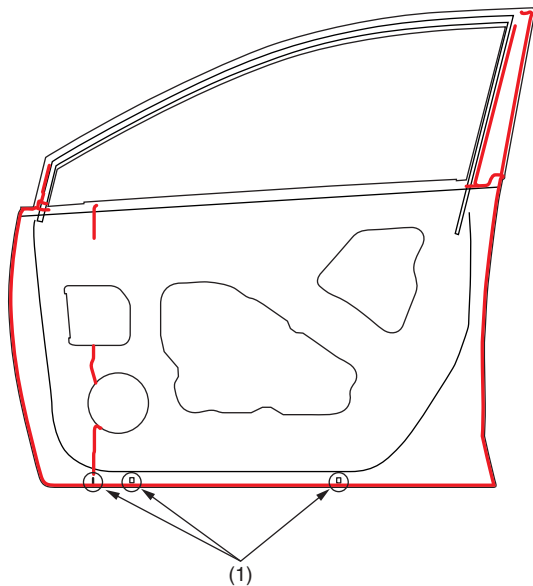
View S



(1) Do not block the water drain holes.

Body Sealing

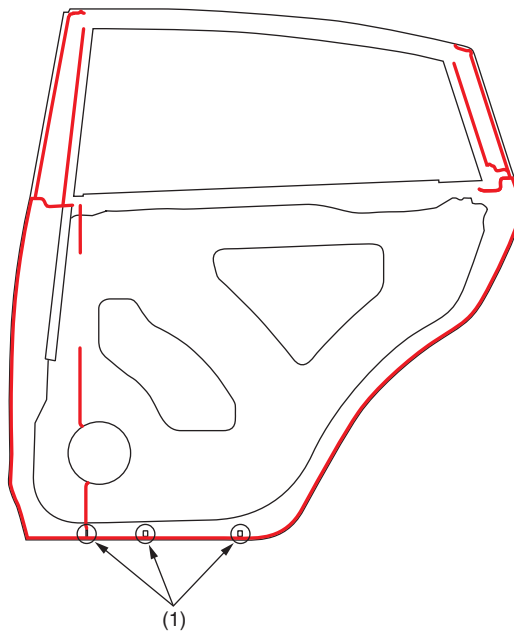
View T



BS-04934

(1) Do not block the water drain holes.

View U



BS-04935

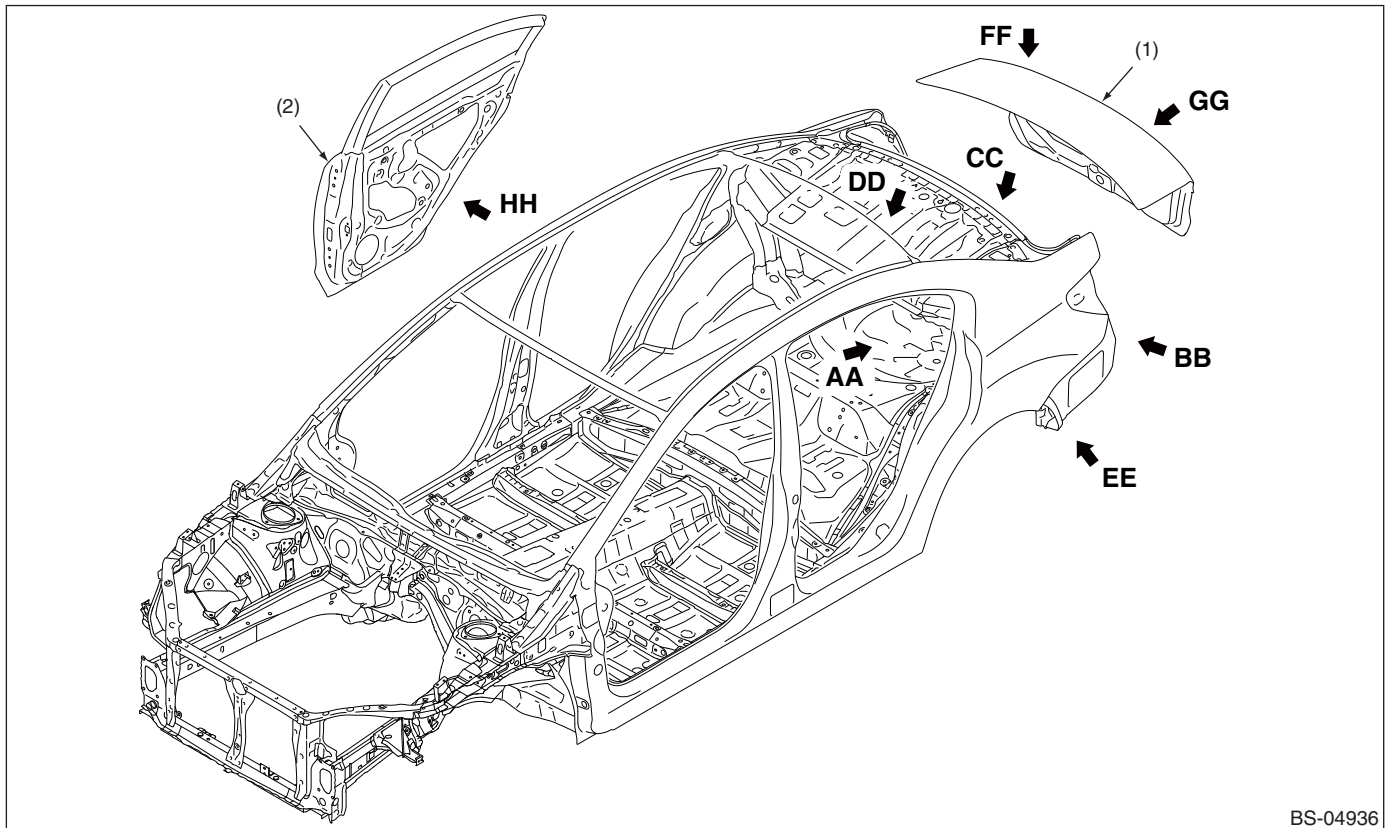
(1) Do not block the water drain holes.

CAUTION:

Sealer already applied to hood, door and rear gate in replacement condition.

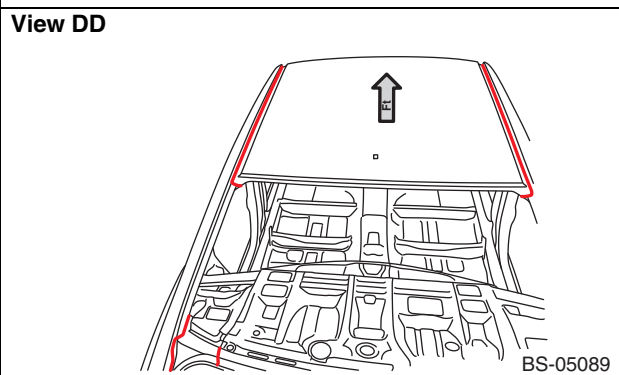
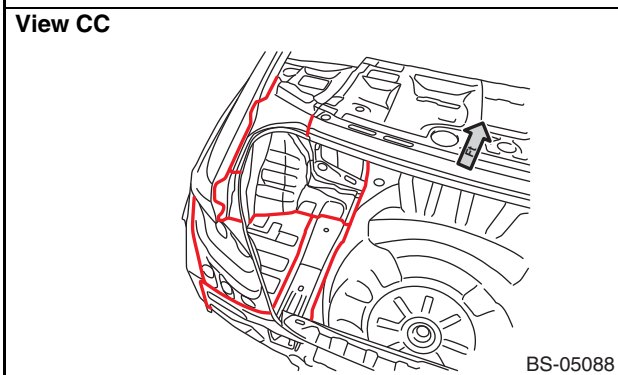
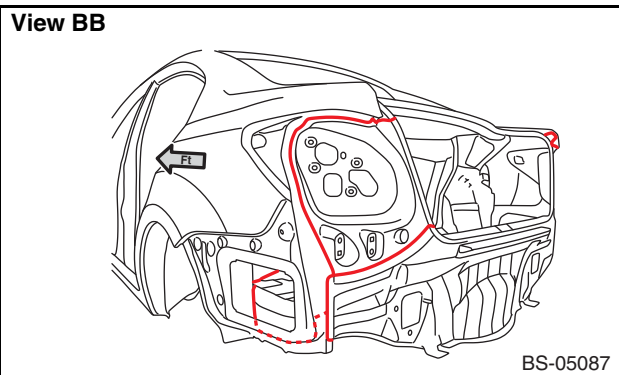
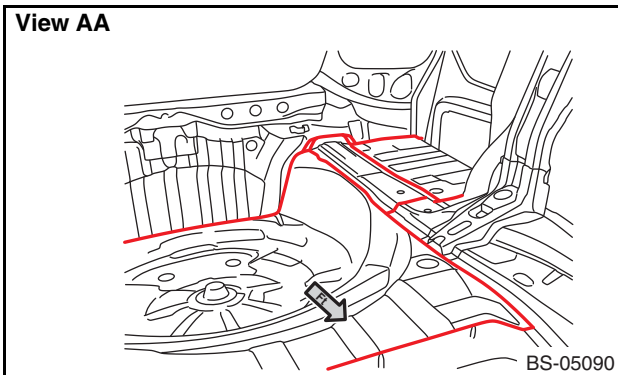
Body Sealing

2. SPECIAL 4 DOOR PARTS



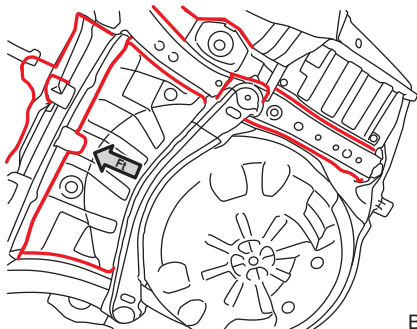
(1) Trunk

(2) Rear door



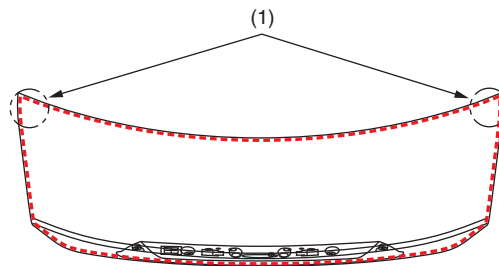
Body Sealing

View EE



BS-05886

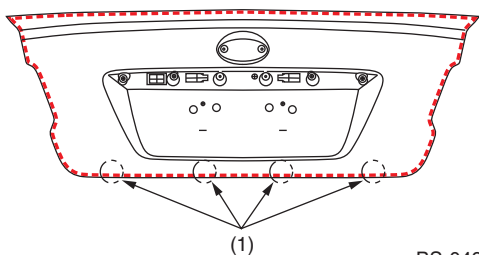
View FF



BS-04942

(1) The hole shall be blocked.

View GG

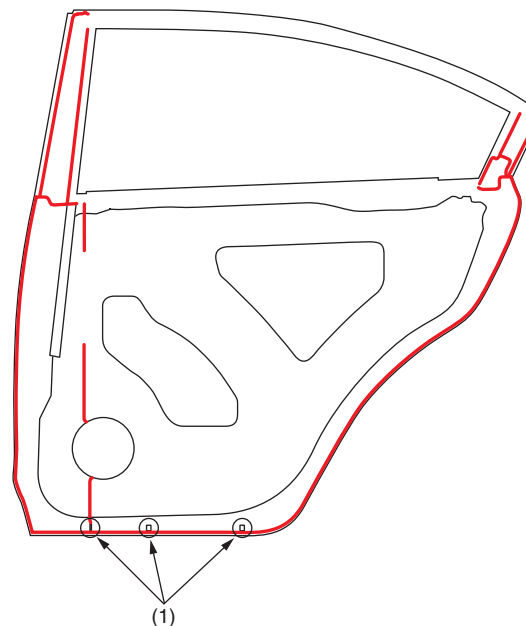


BS-04943

(1) Do not block the water drain holes.

SUBARU.

View HH



BS-04944

(1) Do not block the water drain holes.

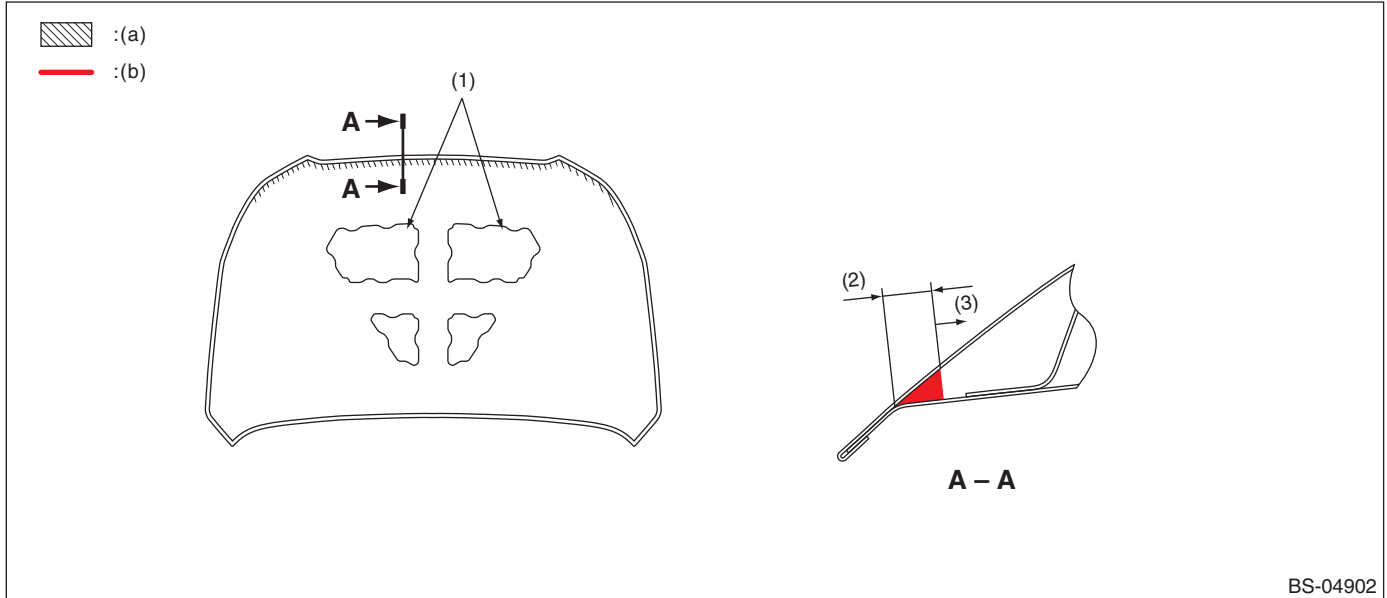
9. Anticorrosion Wax

A: SPECIFICATIONS

Used material: **Rust-stop aerosol (K0877YA015)**

— and ▨ ▩: **Application area**

- Front hood (Application thickness = 50 μm or more)



(a) Rust-stop aerosol

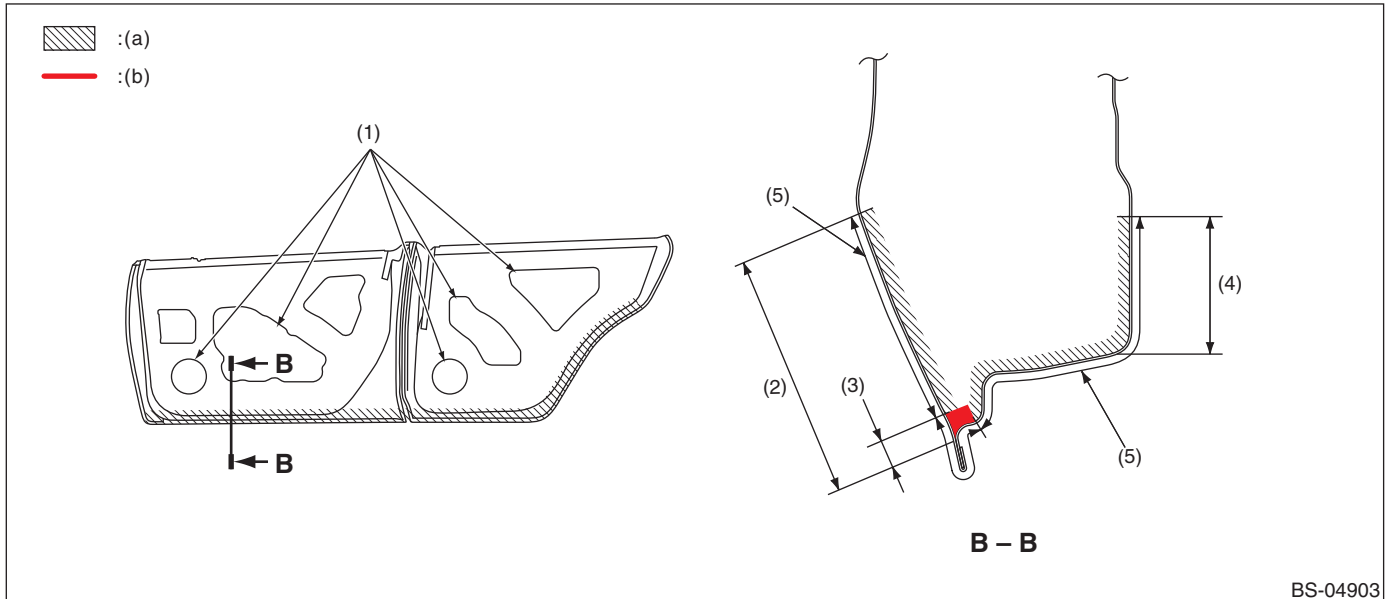
(b) To be filled into the plate joint.

(1) Wax application work openings

(2) 10 mm (0.39 in)

(3) Adherence of mist is allowable.

- Door (Application thickness = 50 μm or more)



(a) Rust-stop aerosol

(b) To be filled into the plate joint.

(1) Wax application work openings

(3) 10 mm (0.39 in)

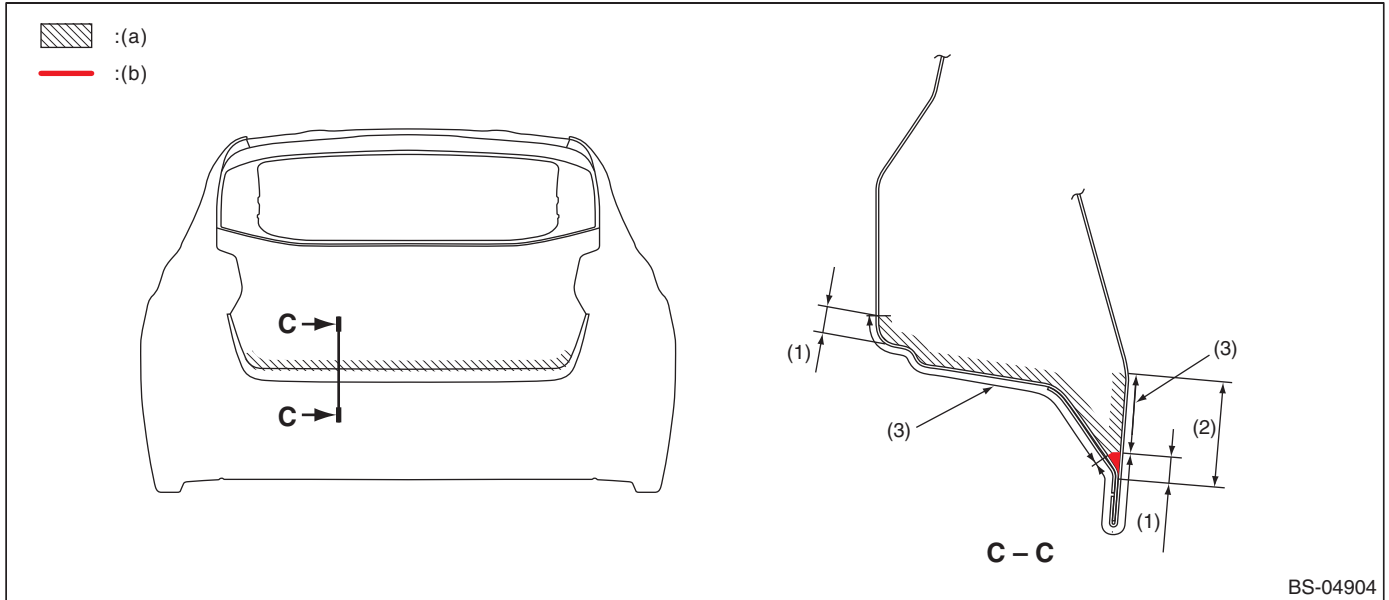
(5) Adherence of mist is allowable.

(2) 90 mm (3.54 in)

(4) 50 mm (1.97 in)

Anticorrosion Wax

- Rear gate (Application thickness = 50 μm or more)



(a) Rust-stop aerosol

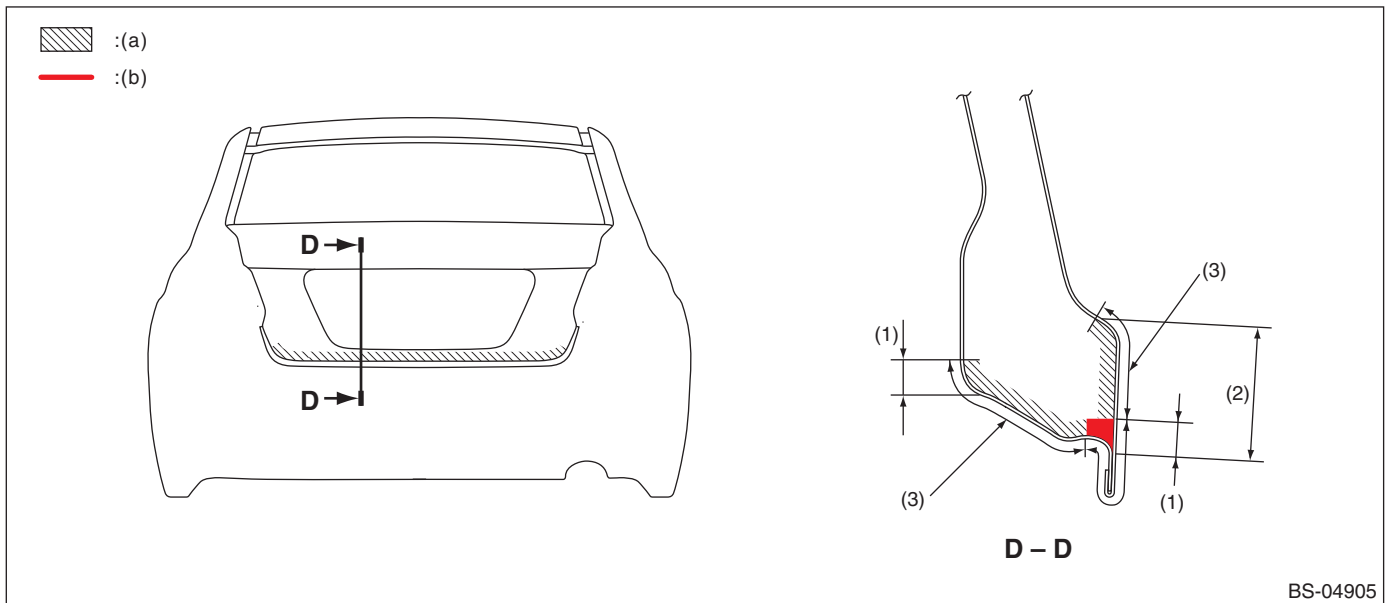
(b) To be filled into the plate joint.

(1) 10 mm (0.39 in)

(2) 40 mm (1.57 in)

(3) Adherence of mist is allowable.

- Trunk lid (Application thickness = 50 μm or more)



(a) Rust-stop aerosol

(b) To be filled into the plate joint.

(1) 10 mm (0.39 in)

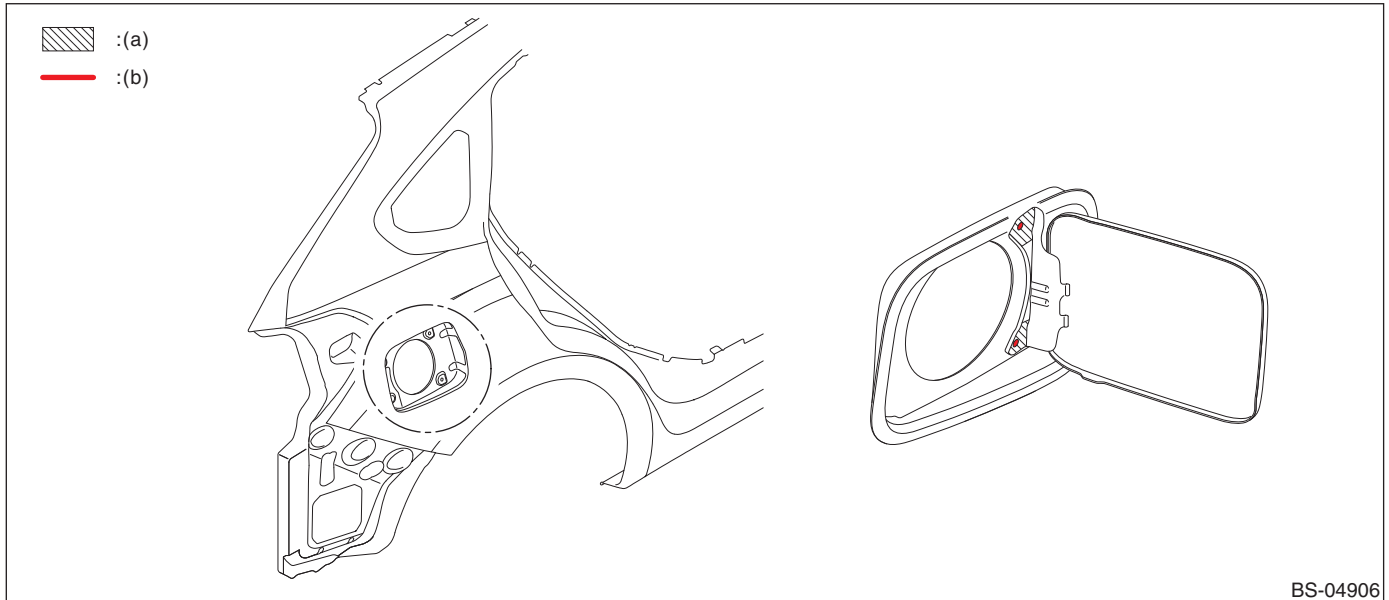
(2) 40 mm (1.57 in)

(3) Adherence of mist is allowable.

Anticorrosion Wax

- Fuel flap (Application thickness = 15 μm or more)

Fill in to the fuel flap installation surface (indicated range) and the rivet fracture surface.

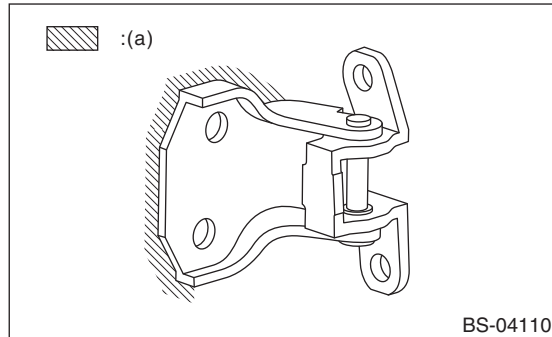


(a) Rust-stop aerosol

(b) To be filled into the fracture surface

- Rear door hinge (Application thickness = 15 μm or more)

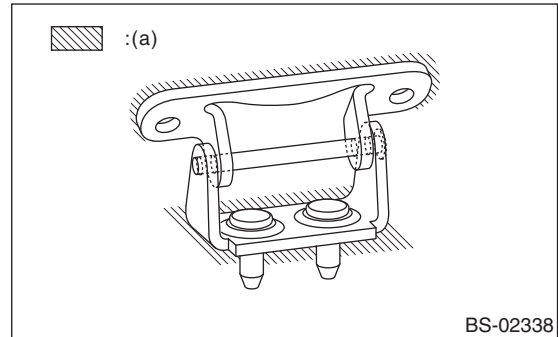
Apply to the contact surface (indicated range) on body side at two locations at the top and bottom (four locations in all), and to the installation outer circumference (plate edges) on the door side.



(a) Rust-stop aerosol

- Rear gate hinge (Application thickness = 15 μm or more)

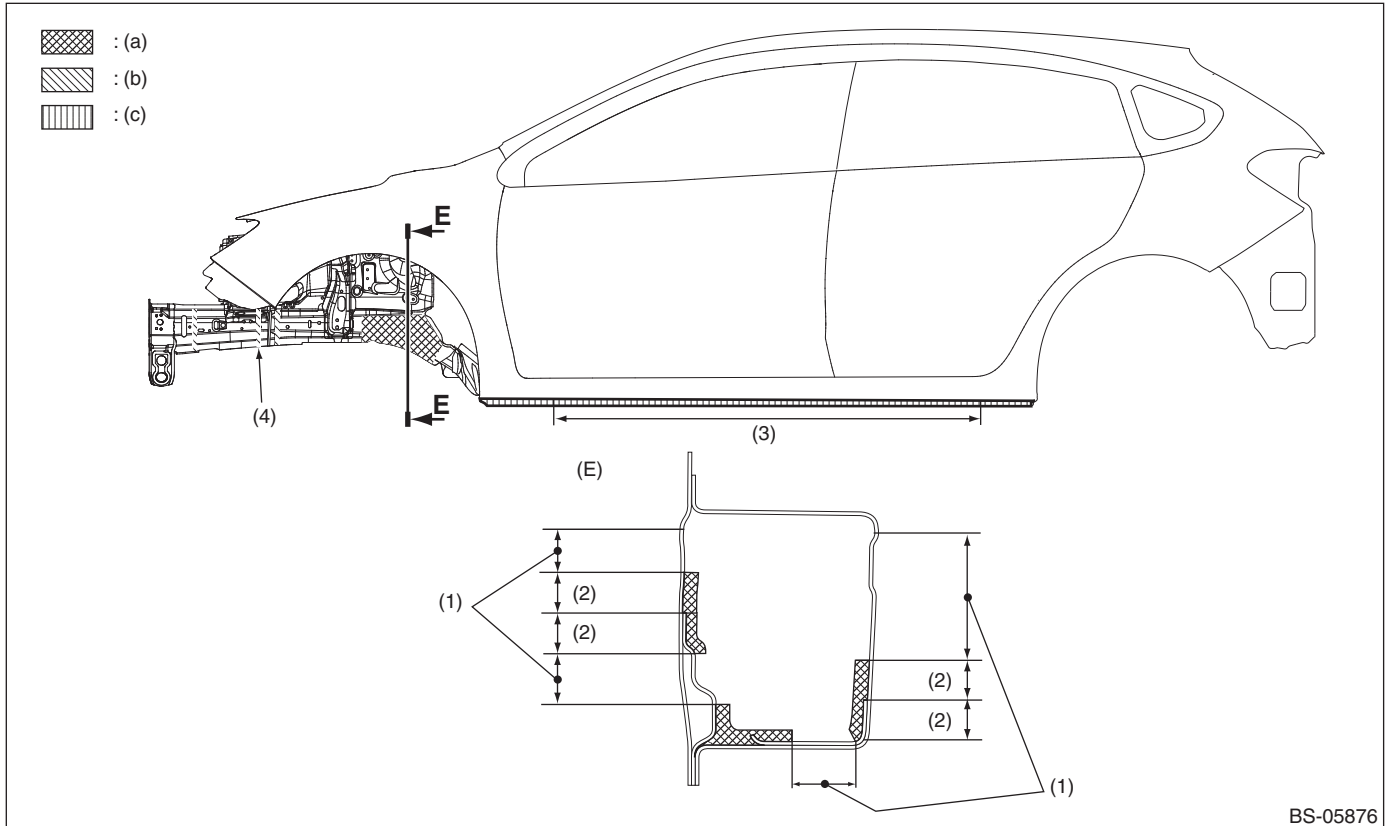
Apply to the contact surface on the body side at two locations on the left and right, and to installation outer circumference (indicated range, plate edges) on the rear gate side.



(a) Rust-stop aerosol

Anticorrosion Wax

- Overall view



(a) Application of rust-stop aerosol to the inside. (Application thickness = 50 μm or more)

(b) Rust-stop aerosol (Application thickness = 15 μm or more)

(c) Rust-stop aerosol (Application thickness = 150 μm or more)

(E) Cross section E — E

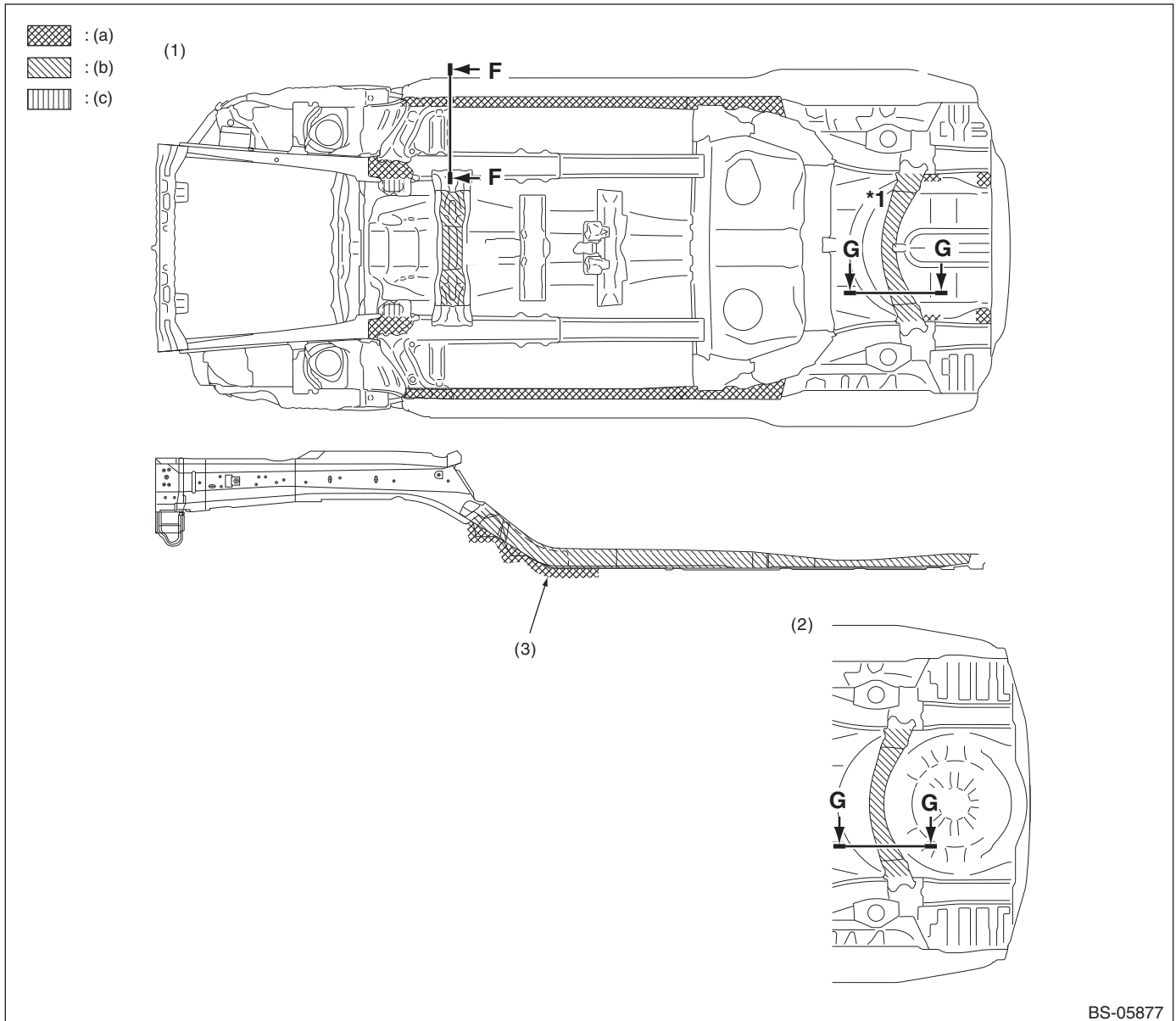
(1) Adherence of mist is allowable.
(2) 20 mm (0.79 in)

(3) Model without side sill spoiler

(4) Inside of the engine compartment

Anticorrosion Wax

• Bottom view



(a) Rust-stop aerosol (Application thickness = 150 μm or more).

(b) Rust-stop aerosol (Application thickness = 20 μm or more).

(c) Rust-stop aerosol (Application thickness = 50 μm or more).

*1: Except for Hybrid model

(1) 5 Door

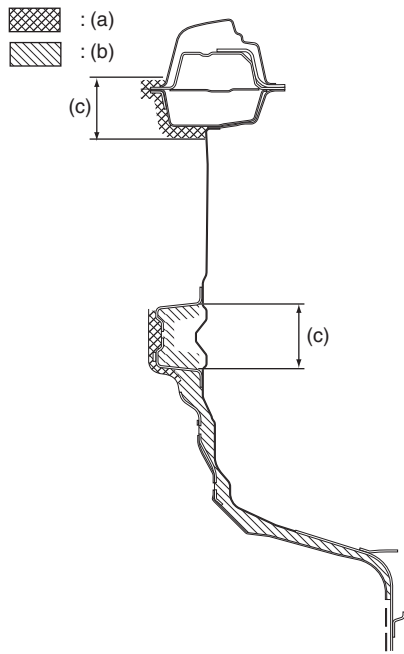
(2) 4 Door

(3) Coating application area does not include the transverse link bush.

The figure shows models other than hybrid models. Hybrid models have a different floor shape, but except for part "*1", the areas where anti-rust wax is applied are the same as in the other models.

Anticorrosion Wax

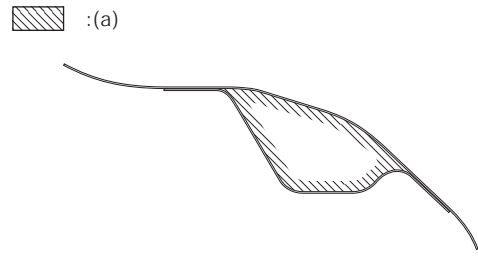
Cross section F — F



BS-05878

- (a) 150 μm or more
- (b) 20 μm or more
- (c) Only type without floor under cover

Cross section H — H (Except for Hybrid model)



BS-05200

- (a) 20 μm or more

SUBARU.

10.Undercoat

A: SPECIFICATIONS

Repair material: PVC (NT guardvoat 5900FL)

CAUTION:

Perform warning so that under the coat will not become attached to locations other than shown and to the following locations.

High-temperature parts related to the exhaust pipe

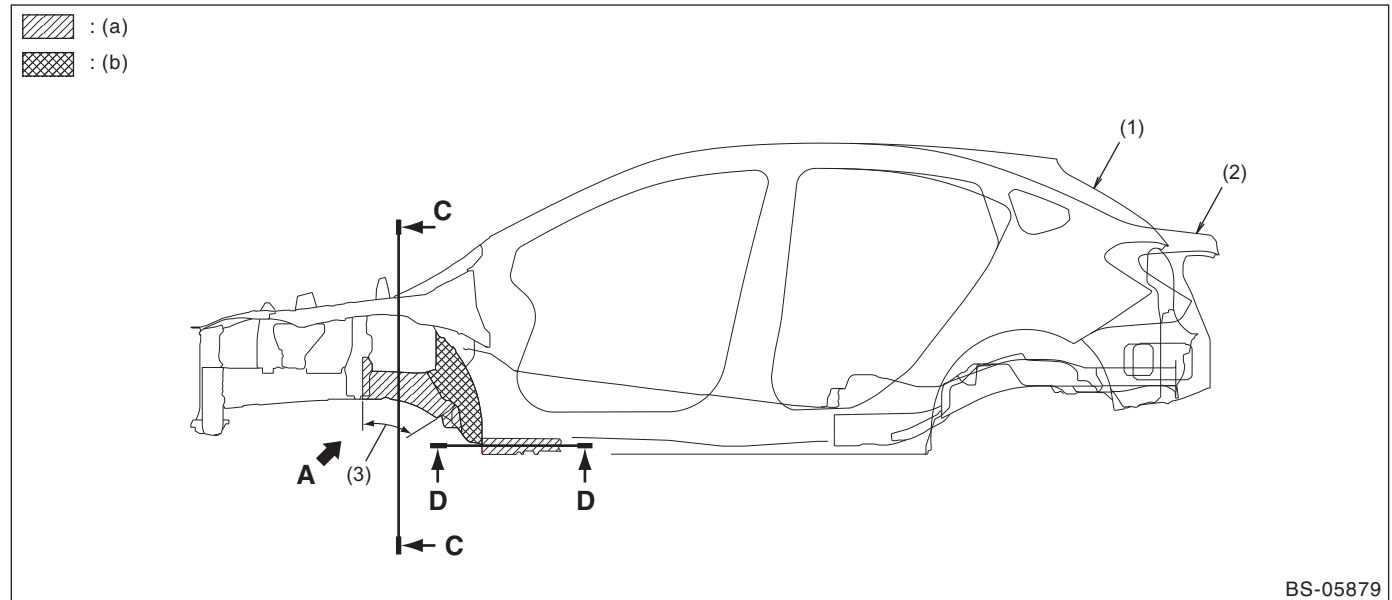
Hoses, tubes and harness parts

Installation surfaces of rear suspension, transmission, subframe,etc.

1) Application area and application thickness

	300 μm or more
	600 μm or more
	The panel gap shall be filled.

• Side view



(a) 300 μm or more

(b) 600 μm or more

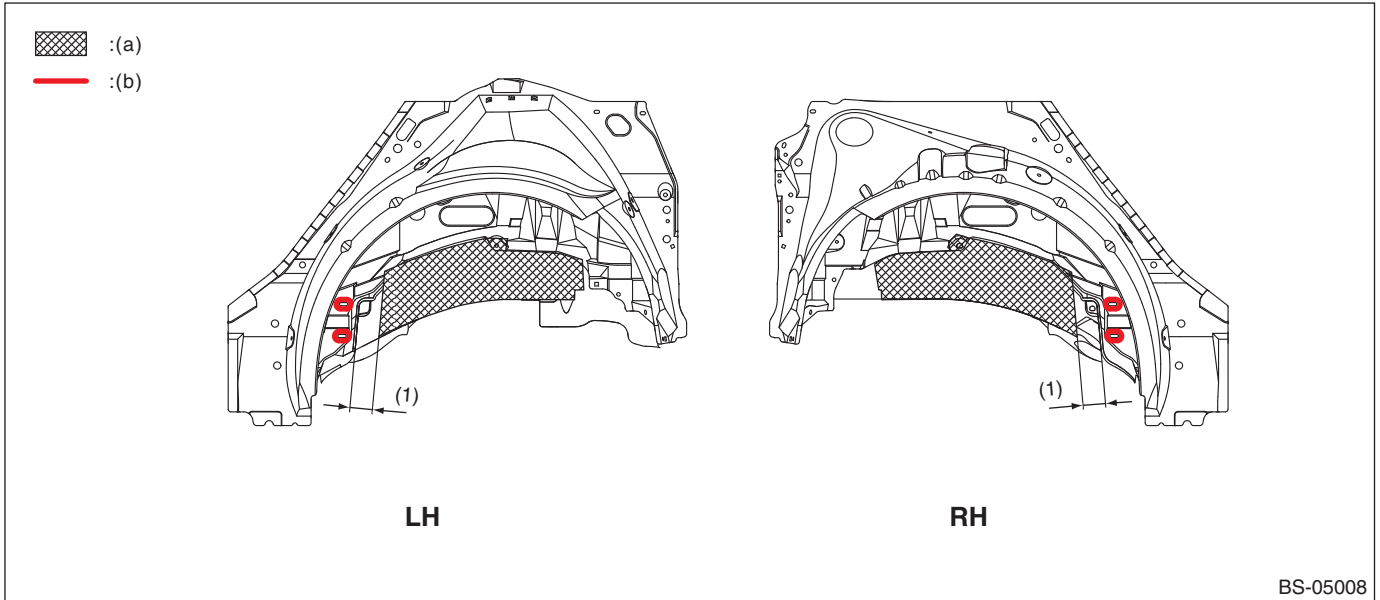
(1) 5 Door

(2) 4 Door

(3) 10 mm (0.39 in) (Adherence of mist is allowable.)

Undercoat

- Rear wheel apron side view



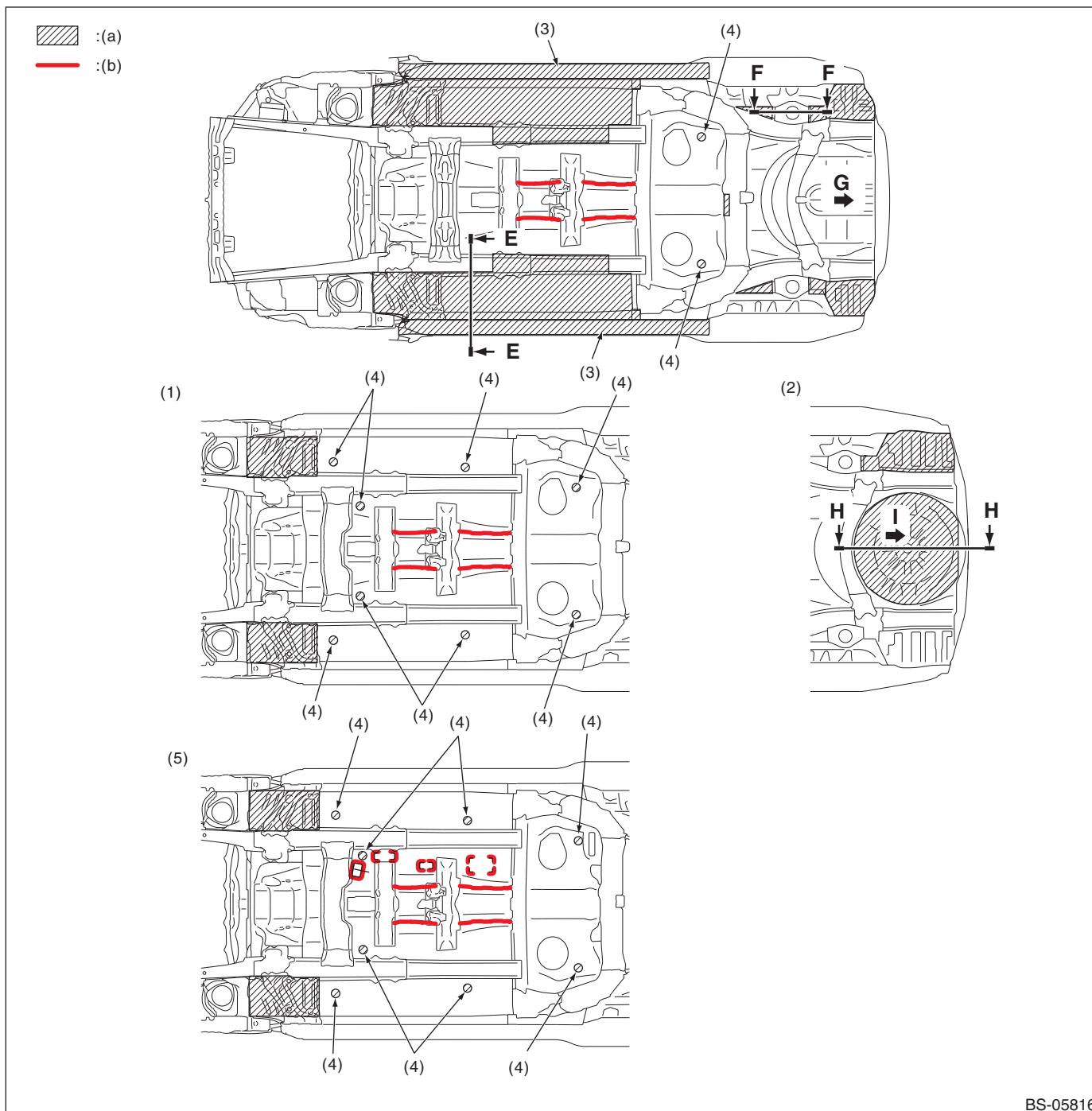
(a) 600 μm or more

(b) The panel gap shall be filled.

(1) 50 mm (1.97 in.)

Undercoat

• Bottom view



BS-05816

(a) 300 μ m or more

(b) The panel joint shall be filled.

(1) Model with under cover

(3) Model without side sill spoiler

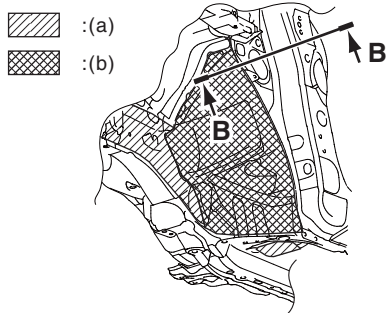
(5) Hybrid model

(2) 4 Door

(4) Plug must be covered with under-coat.

Undercoat

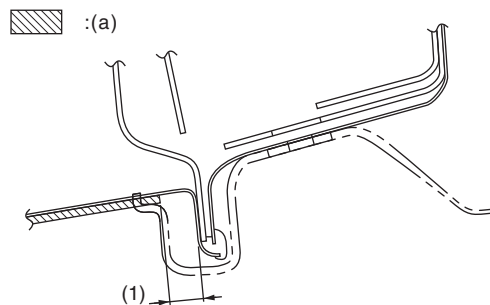
View A



BS-05010

- (a) 300 μm or more
- (b) 600 μm or more

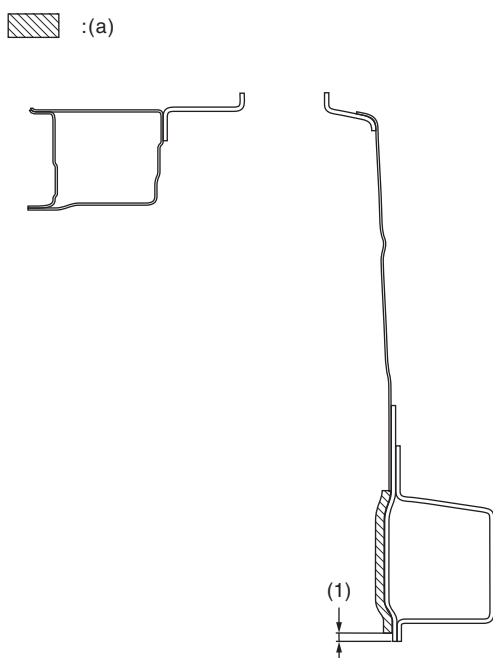
Cross section B — B



BS-05011

- (a) 600 μm or more
- (1) 10 mm (0.39 in) (Adherence of mist is allowable.)

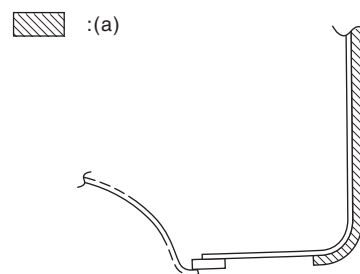
Cross section C — C



BS-05012

- (a) 300 μm or more
- (1) 5 mm (0.20 in) (Adherence of mist is allowable.)

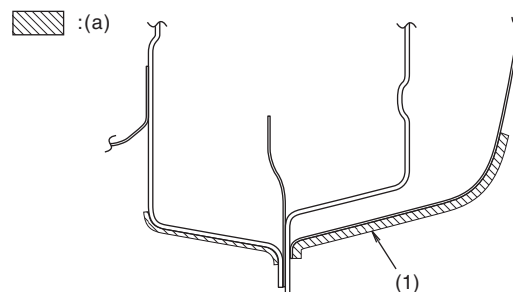
Cross section D — D



BS-05013

- (a) 600 μm or more

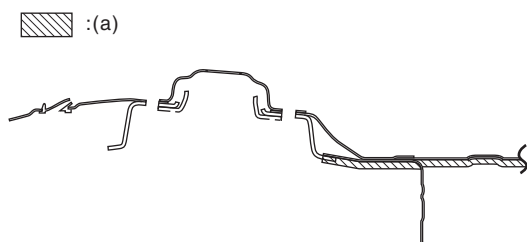
Cross section E — E



BS-05881

- (a) 300 μm or more
- (1) Model without side sill spoiler

Cross section F — F (Model without floor under cover)



BS-05880

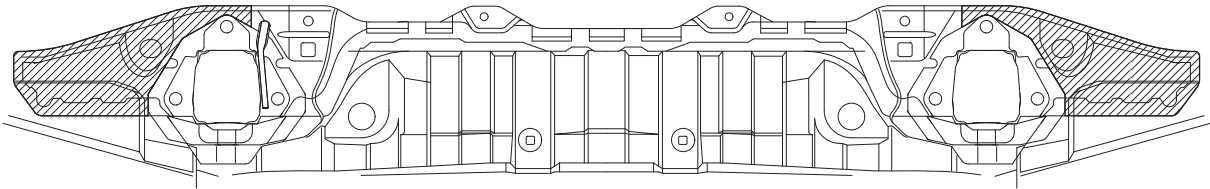
- (a) 300 μm or more

SUBARU.

Undercoat

View G

 : (a)

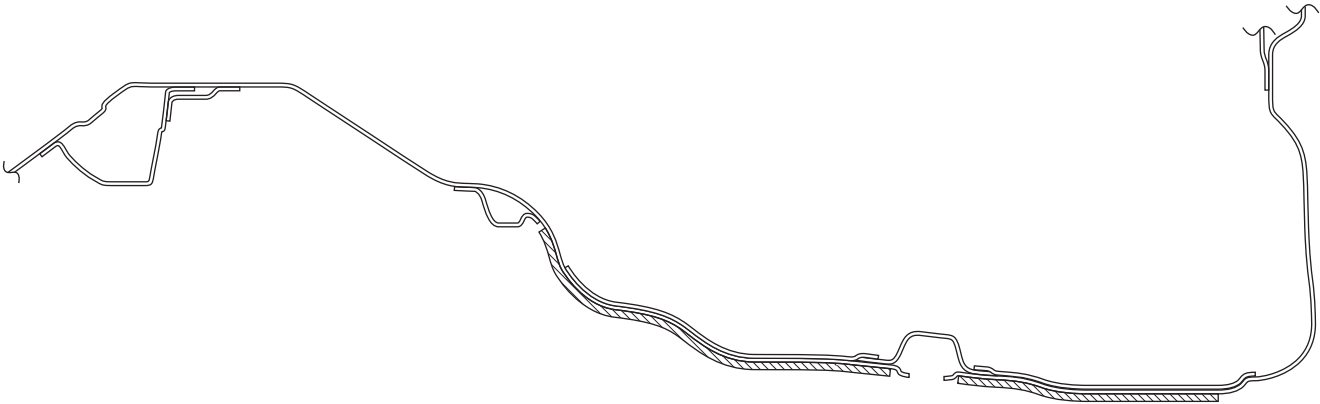


BS-05016

(a) 300 μm or more

Cross section H — H

 : (a)



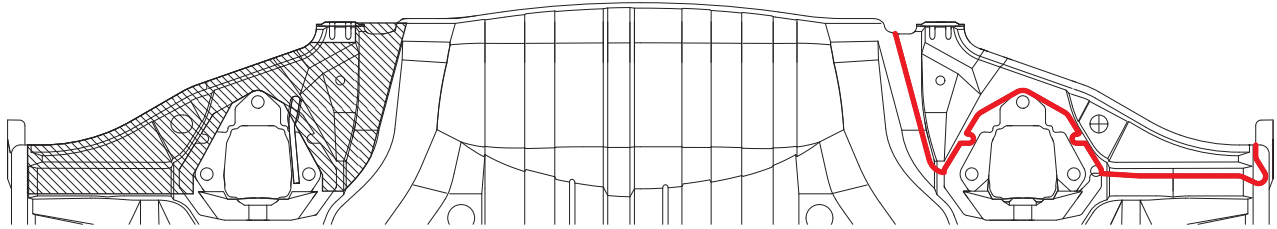
BS-05017

(a) 300 μm or more

Undercoat

View I

-  : (a)
 : (b)



BS-05018

- (a) 300 µm or more
(b) The panel gap shall be filled.

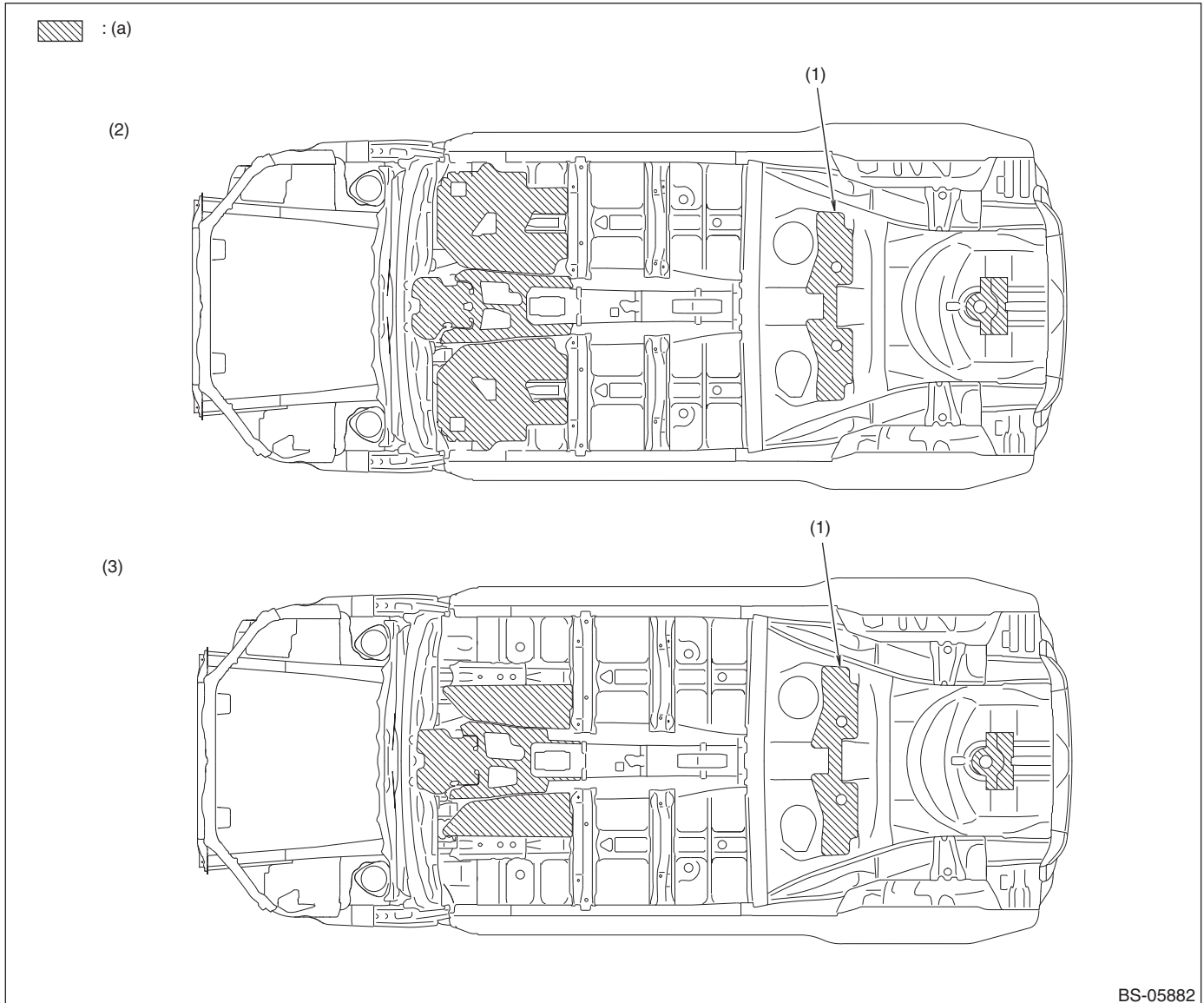
Damping seat

11.Damping seat

A: SPECIFICATIONS

1. UPPER VIEW

- Except for Hybrid model



BS-05882

(a) Silencer

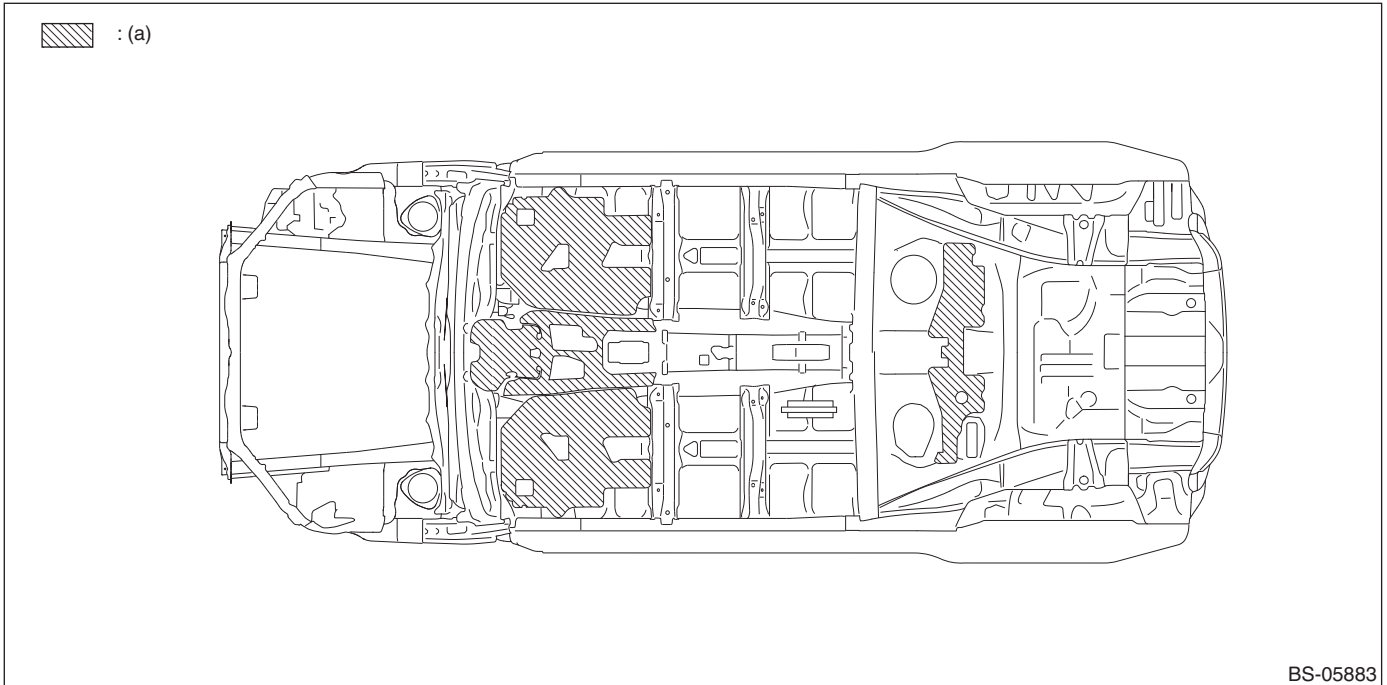
(1) 4WD model only

(2) CVT models except for 2.0i models

(3) MT models and 2.0i CVT models

Damping seat

- Hybrid model

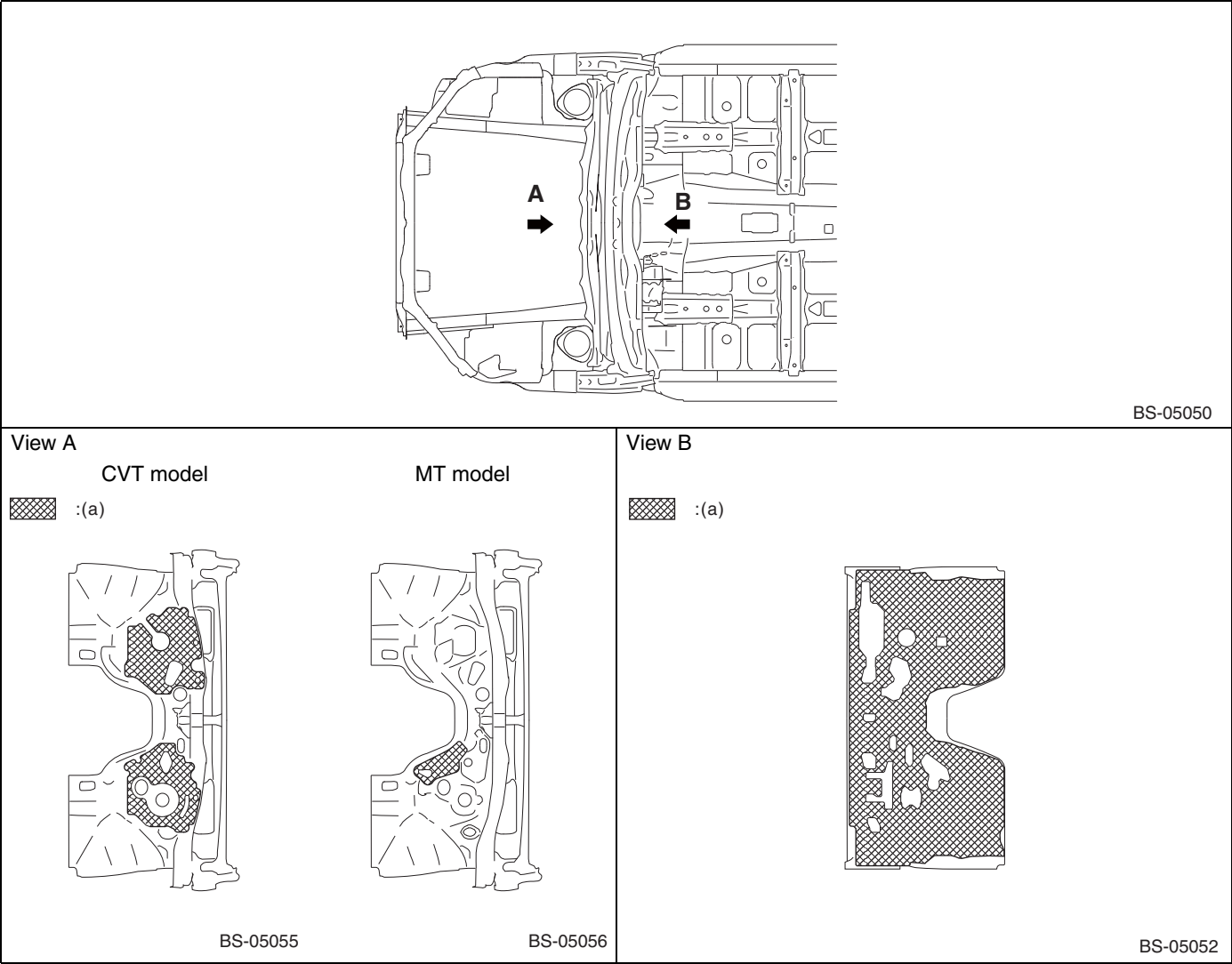


(a) Silencer

12.Insulator

A: SPECIFICATIONS

1. UPPER VIEW



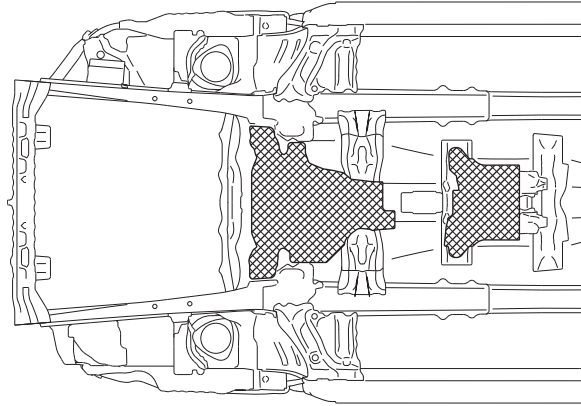
(a) Insulater

Insulator

2. BOTTOM VIEW (ONLY CVT MODEL)

Except for Hybrid model

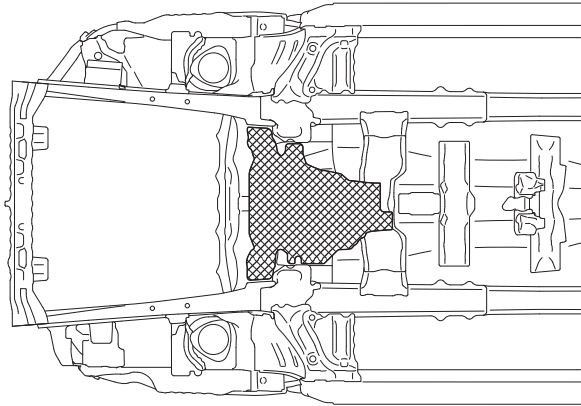
 : (a)



BS-05053

Hybrid mode

 : (a)

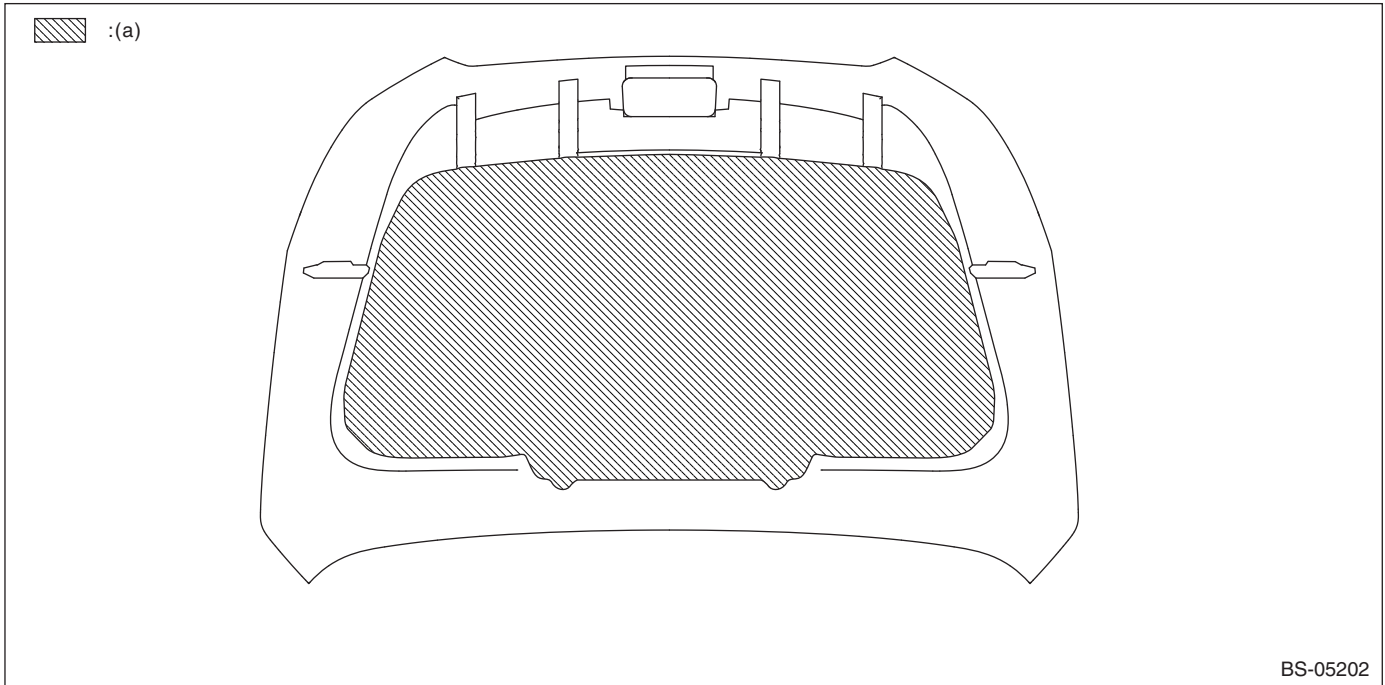


BS-05786

(a) Insulator

Insulator

3. FRONT HOOD

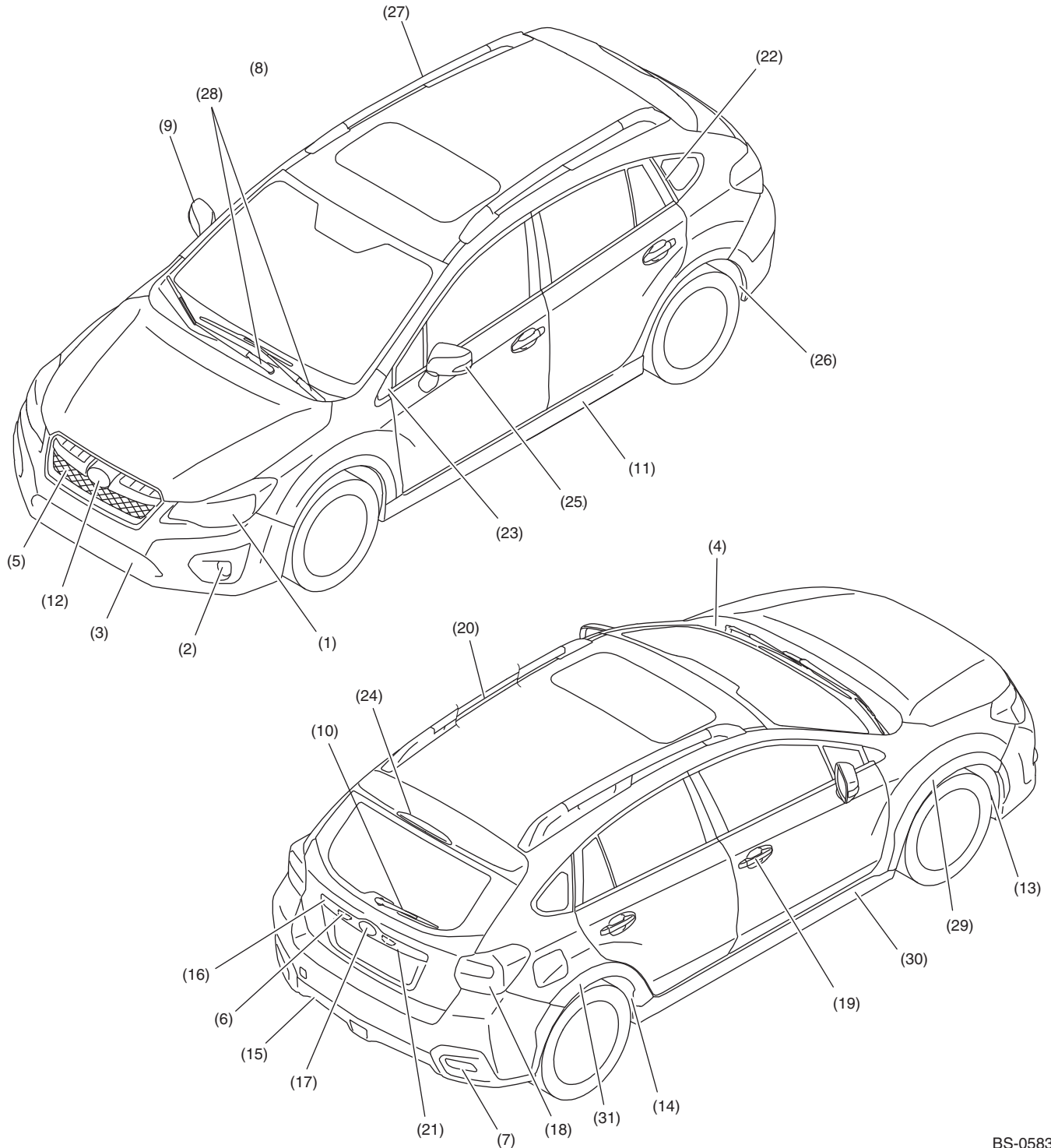


(a) Insulator

13. Plastic Parts and Materials

A: SPECIFICATIONS

1. COMMON PARTS FOR 5 DOOR AND 4 DOOR



BS-05832

Plastic Parts and Materials

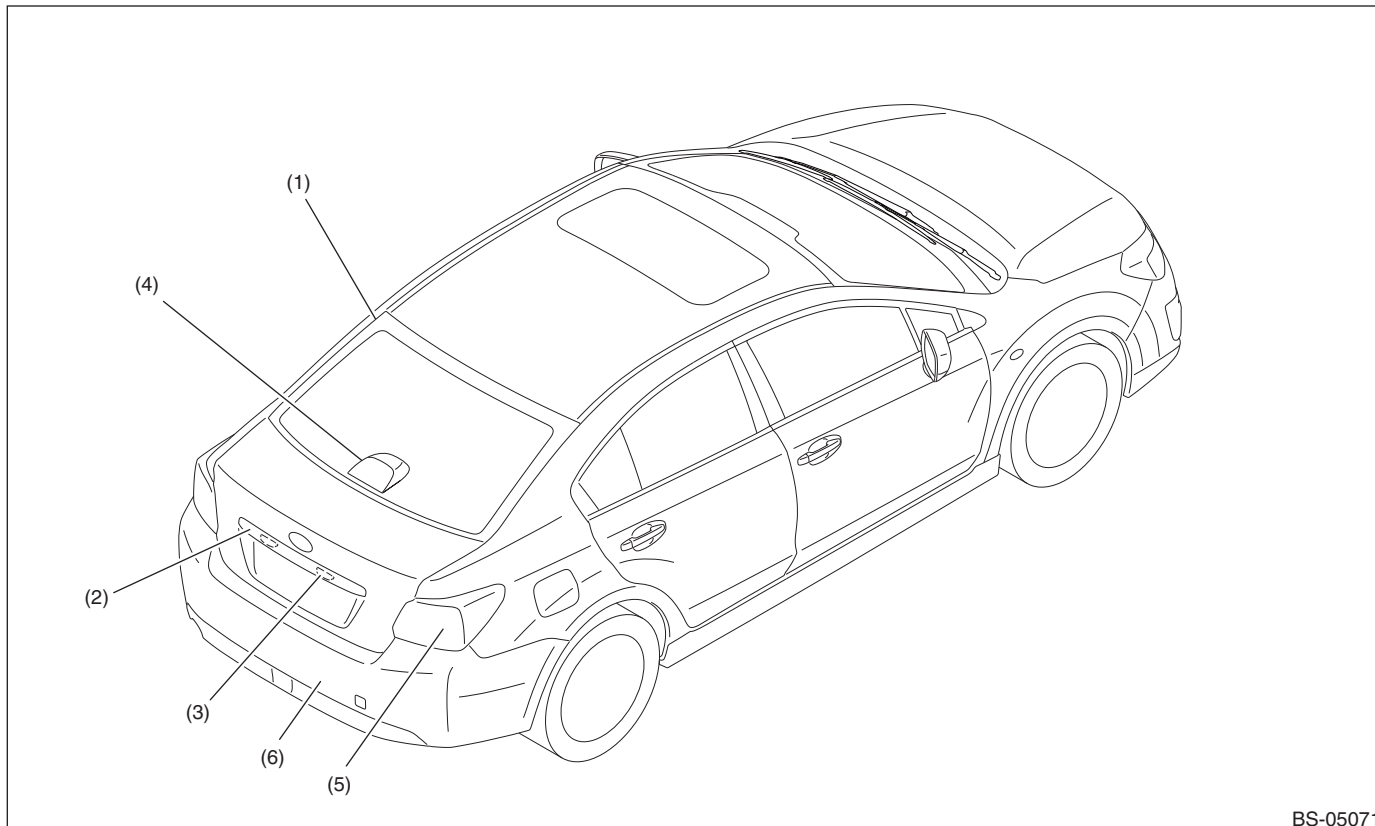
(1) Headlight	(12) Ornament front	(23) A-pillar cover
(2) Front fog light	(13) Front mudguard	(24) High mount stop light
(3) Front bumper	(14) Air flap rear	(25) Side turn light
(4) Cowl panel	(15) Rear bumper	(26) Rear mudguard
(5) Front grille	(16) Rear gate garnish	(27) Roof rail
(6) License light	(17) Ornament rear	(28) Front wiper
(7) Rear reflex reflector	(18) Rear combination light	(29) Fender garnish
(8) Front window moulding	(19) Door handle	(30) Side sill garnish
(9) Door mirror	(20) Roof moulding	(31) Rear quarter garnish
(10) Rear wiper	(21) Rear gate opener switch	Under cover
(11) Side spoiler	(22) Rear quarter moulding	Splash board

No.	Part name		Material
(1)	Headlight	Lens	PC
		Housing	PP
		Extension	PBT+PET
		Reflector	BMC
(2)	Front fog light	Lens	PC
		Housing	PC
		Bracket	PP+GF30
(3)	Front bumper	Face	PP
		Fog light cover	PP
		Hook cover	PP
		Center lower bracket	PP
		Side bracket	POM
		Corner bracket	PP+GF30
(4)	Cowl panel	Body, Side	PP
(5)	Front grille	Grille part	AES
		Moulding	ABS
(6)	License light	Lens	PC
		Housing	PC
(7)	Rear reflex reflector	Lens	PMMA
		Housing	PC
(8)	Front window moulding		PVC
(9)	Door mirror	Body	AES
		Outer cover	ABS
		Mirror holder	PP
(10)	Rear wiper	Blade	PBT+GF30
		Arm	PBT+GF45
		Arm cover	PBT
(11)	Side spoiler (Except for XV model)		PP
(12)	Ornament front		ABS+PMMA
(13)	Front mudguard (Except for Hybrid model)	Body	PE
		Air flap	PE
	Front mudguard (Hybrid model)	Body	PE
		Air flap	PE+EPDM
(14)	Air flap rear		PP+EPDM

Plastic Parts and Materials

No.	Part name			Material
(15)	Rear bumper	Face		PP
		Cover bumper rear		PP
		Hook cover		PP
		Side bracket		POM
		Corner bracket		POM
		Bracket lower rear		PP+GF30
		Cover side lower		PP
(16)	Rear gate garnish			ABS
(17)	Ornament rear			ABS+PMMA
(18)	Rear combination light (Except for Hybrid model)	Lens		PMMA
		Housing		ASA
		Inner lens side reflex reflector		PMMA
	Rear combination light (Hybrid model)	Lens		PMMA
		Housing		ASA
		Inner lens (Tail)	Red	PC
		Inner lens (Stop)	Clear	PMMA
		Inner lens side reflex reflector		PMMA
(19)	Door handle	Handle	Painting	PC+PBT-MD10
			Plating	PC+PBT-MD10, PC+ABS
		Handle cover	Painting	PC+PBT-MD10
			Plating	PC+PBT-MD10, PC+ABS
(20)	Roof moulding			PVC
(21)	Rear gate opener switch	Operation part		TPE
		Resin part		PP-F35
(22)	Rear quarter moulding			AES
(23)	A-pillar cover			AES
(24)	High mount stop light	Lens		PMMA
		Housing		ABS
(25)	Side turn light	Lens		PMMA
		Housing		PC
(26)	Rear mudguard			PE
(27)	Roof rail	Front cover		PC+PET
		Rear cover		PC+PET
(28)	Front wiper	Arm cover		PC
(29)	Fender garnish (Only XV model)			PP
(30)	Side sill garnish (Only XV model)			PP
(31)	Rear quater garnish (Only XV model)			PP
	Under cover	Body		PP
	Splash board			PP

2. SPECIAL 4 DOOR PARTS



BS-05071

- | | | |
|--------------------------|---|----------------------------|
| (1) Rear window moulding | (3) License light | (5) Rear combination light |
| (2) Trunk garnish | (4) High mount stop light (Inside type) | (6) Rear bumper |

No.	Part name		Material
(1)	Rear window moulding		PVC
(2)	Trunk garnish		ABS
(3)	License light	Lens	PC
		Housing	PC
(4)	High mount stop light (Inside type)	Lens	PC
		Case	PP
		Reflector	PBT+PET
(5)	Rear combination light	Lens	PMMA
		Housing	ASA
		Inner lens rear reflex reflector	PC
		Inner lens side reflex reflector	PMMA
(6)	Rear bumper	Face	PP
		Cover bumper rear	PP
		Hook cover	PP
		Side bracket	POM
		Corner bracket	POM
		Cover side lower	PP

List of Plastic Material Notations

14. List of Plastic Material Notations

A: SPECIFICATIONS

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	PET+GF45	Polyethylene terephthalate (45% glass fiber content)
BMC	Unsaturated polyester resin	PMMA	Polymethyl methacrylate
EPDM	Ethylene/propylene/dien rubber	POM	Polyacetal
PBT	Polybutylene terephthalate	PP	Polypropylene
PBT-MD10	Polybutylene terephthalate (10% mineral powder content)	PP-F35	Polypropylene (35% inorganic fillers)
PBT+GF30	Polybutylene terephthalate(30% glass fiber content)	PP+GF30	Polypropylene (30% glass fiber content)
PBT+GF45	Polybutylene terephthalate(45% glass fiber content)	PVC	Polyvinyl chloride
PC	Polycarbonate	TPE	Thermoplastic elastomer