

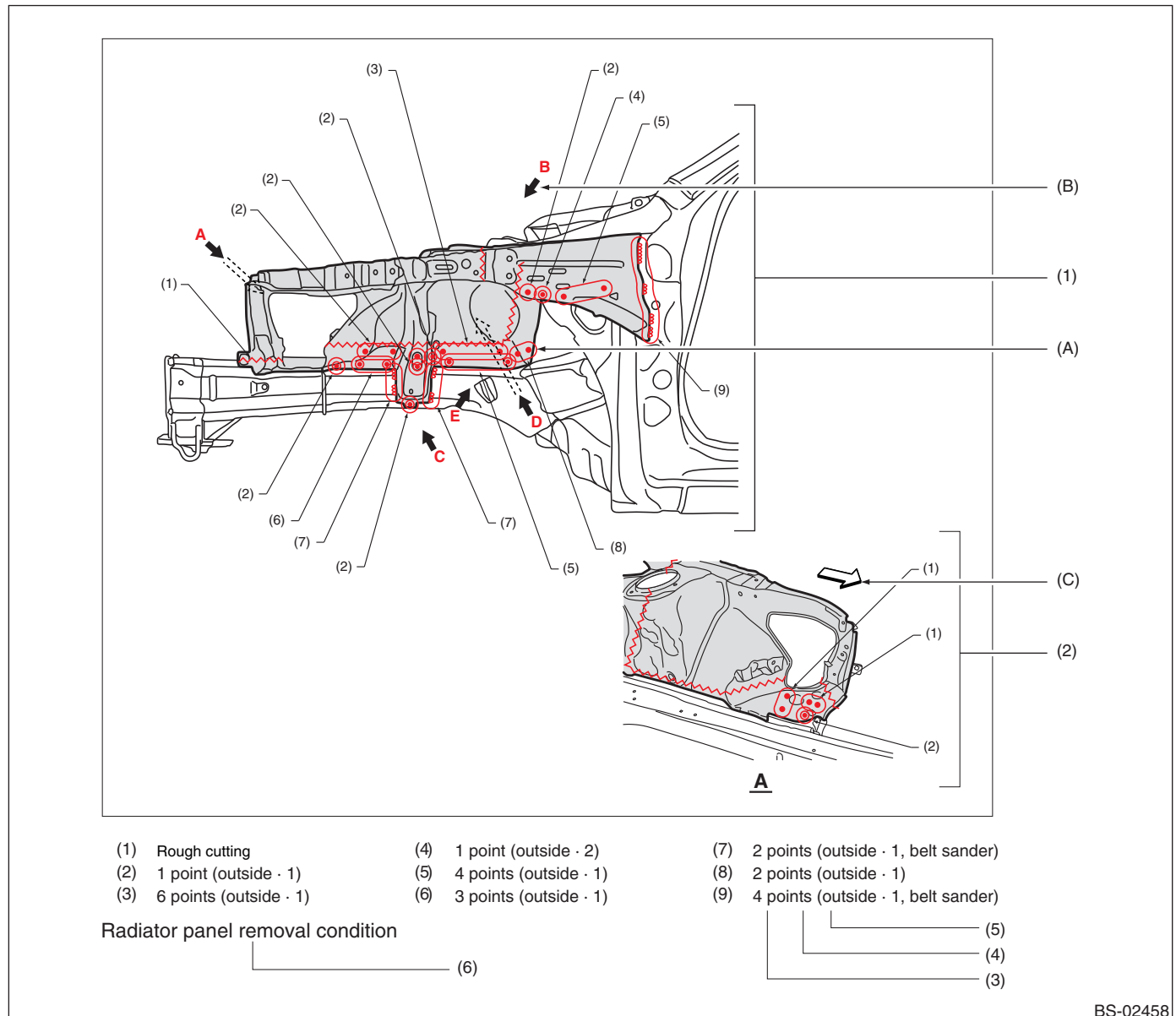
1. Foreword

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

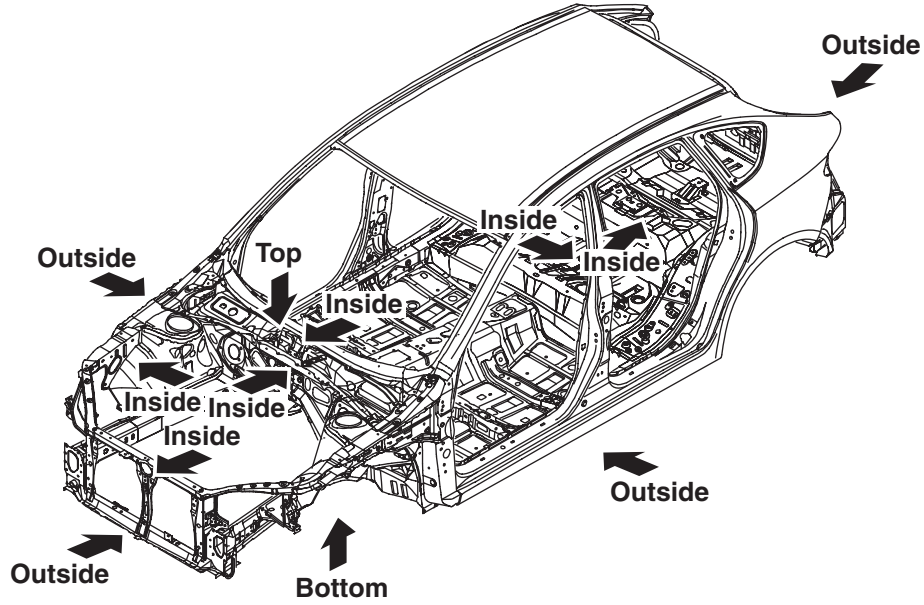
- Symbols and number of points indicate the welding method and the number of welding points. Text in brackets indicates the direction for removal of welded parts, and numbers indicate the number of plates to be drilled in panels of welded parts to be removed.
- An enclosure by a broken line indicates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

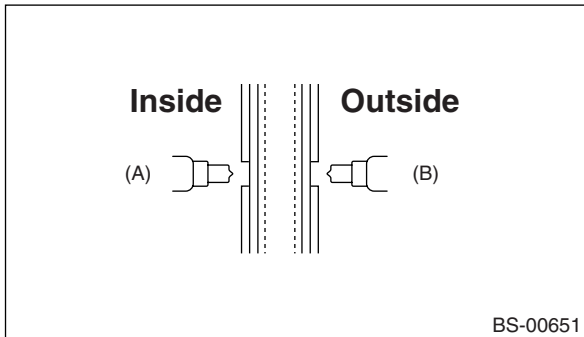


BS-02459

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.

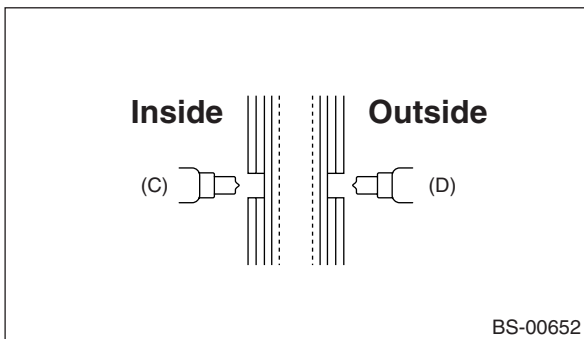
(1) Drilling through one plate



(A) (Inside · 1)

(B) (Outside · 1)

(2) Drilling through two plates

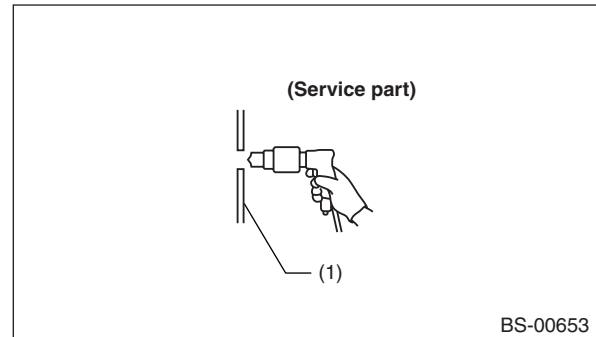


(C) (Inside · 2)

(D) (Outside · 2)

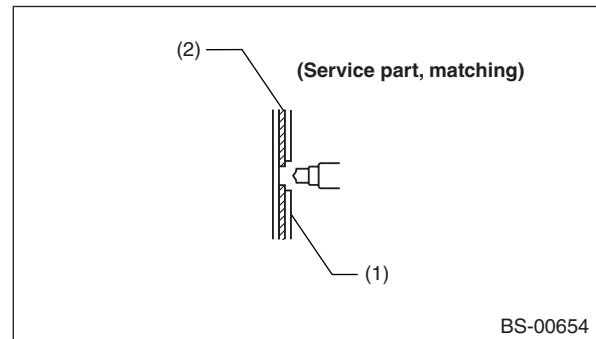
4. HOLE DRILLING FOR PLUG WELDING

(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

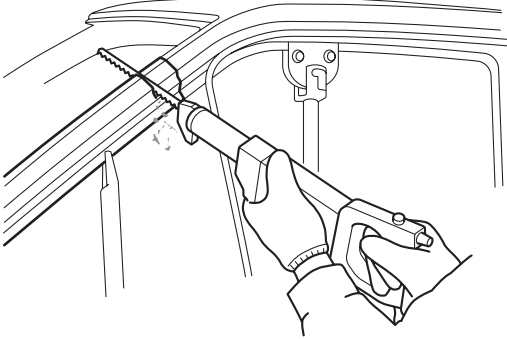


(1) Vehicle side

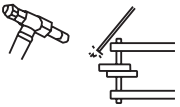
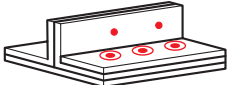
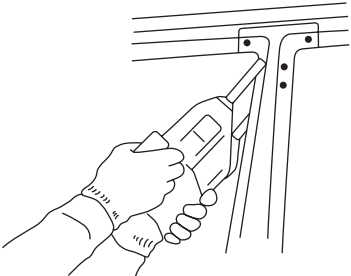
(2) Service part

5. MEANING OF SYMBOLS

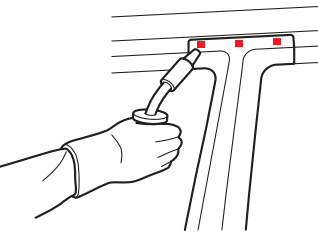
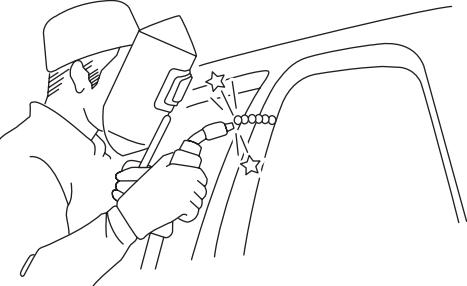
• Cutting

 BS-00352	 BS-00267
---	--

• Spot welding

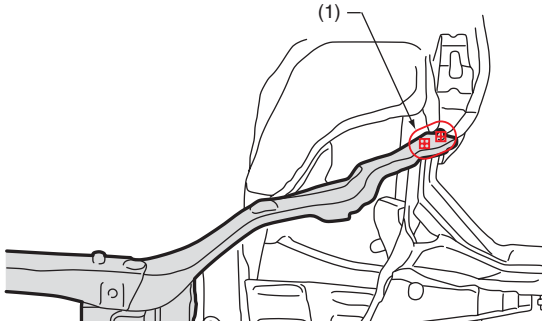
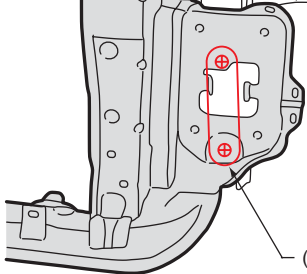
Two overlapping parts	 BS-00655	 BS-00656	 BS-00657	 BS-00658
Three or more overlapping parts	 BS-00659	 BS-00660		

• 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	 (1)
Nut	 BS-04482	 (2) BS-04483

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: NOTE

1. About high-tensile steel sheets of 980 MPa Class or more

The usable parts of high-tensile steel sheets of 980 MPa Class or more should be welded 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 spot welding conditions cannot be met, plug weld 980 MPa class following [g] or [h] conditions, and 1,500 MPa class following below [i] or [j] conditions.

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 or more	Total number of 2 or 3 overlapping sheets
		Wire	YGW12	
		Gas	CO2	
	[h]	Plug diameter	8 mm or more	
		Wire	YGW16	
		Gas	Gas mixture (argon: 80 %, CO2: 20 %)	
	[i]	Plug diameter	8.5 mm	
		Wire	YGW12	
		Gas	CO2	
	[j]	Plug diameter	8.5 mm	
		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.
- To avoid loss of strength, do not use heat repair or patch welding to repair the usable parts of high-tensile steel sheets of 980 MPa class or more.

Foreword

2. Hole drilling for plug welding

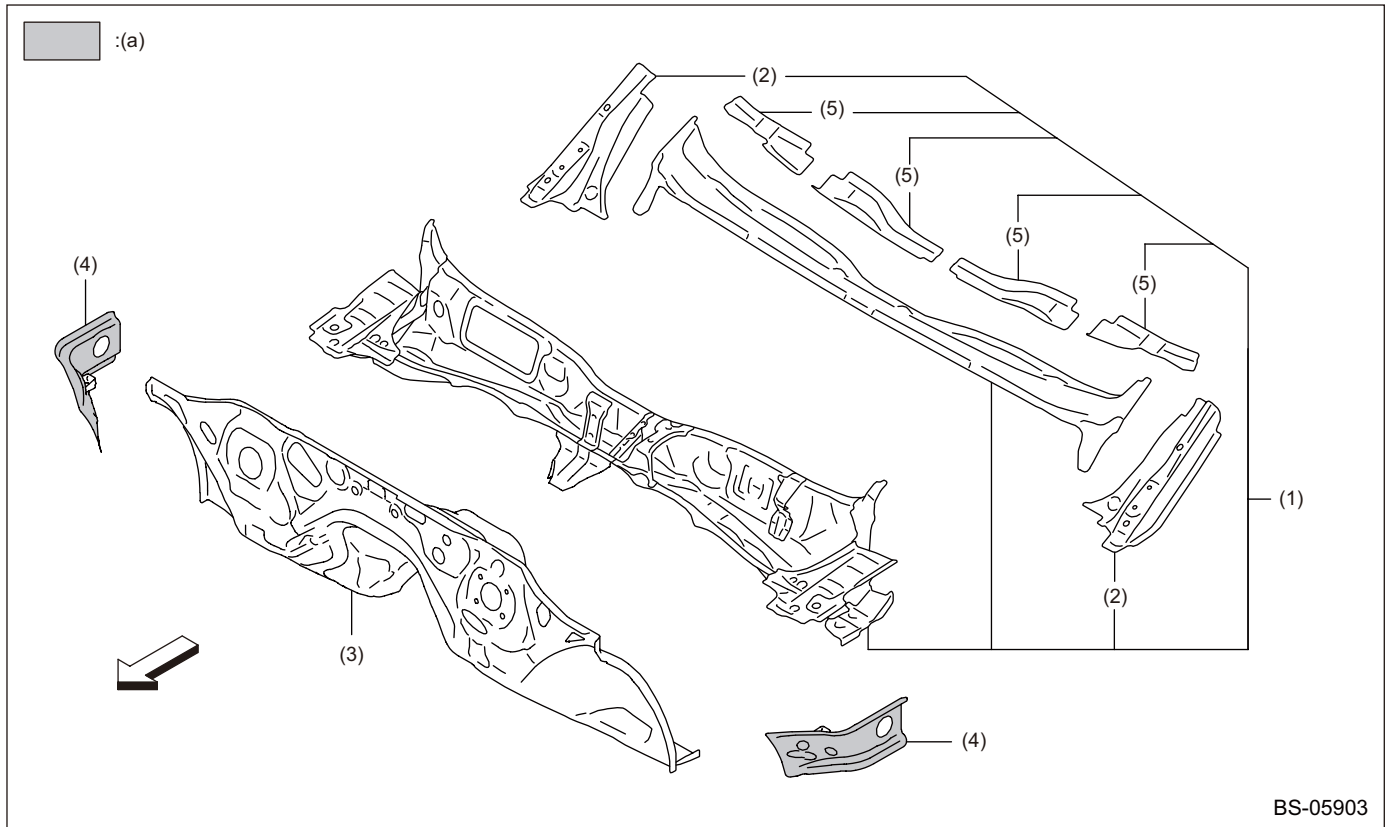
At locations where spot welding is not possible, use a punch or a drill to open holes for plug welding according to the following table.

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 & Duct

(3) Toe board

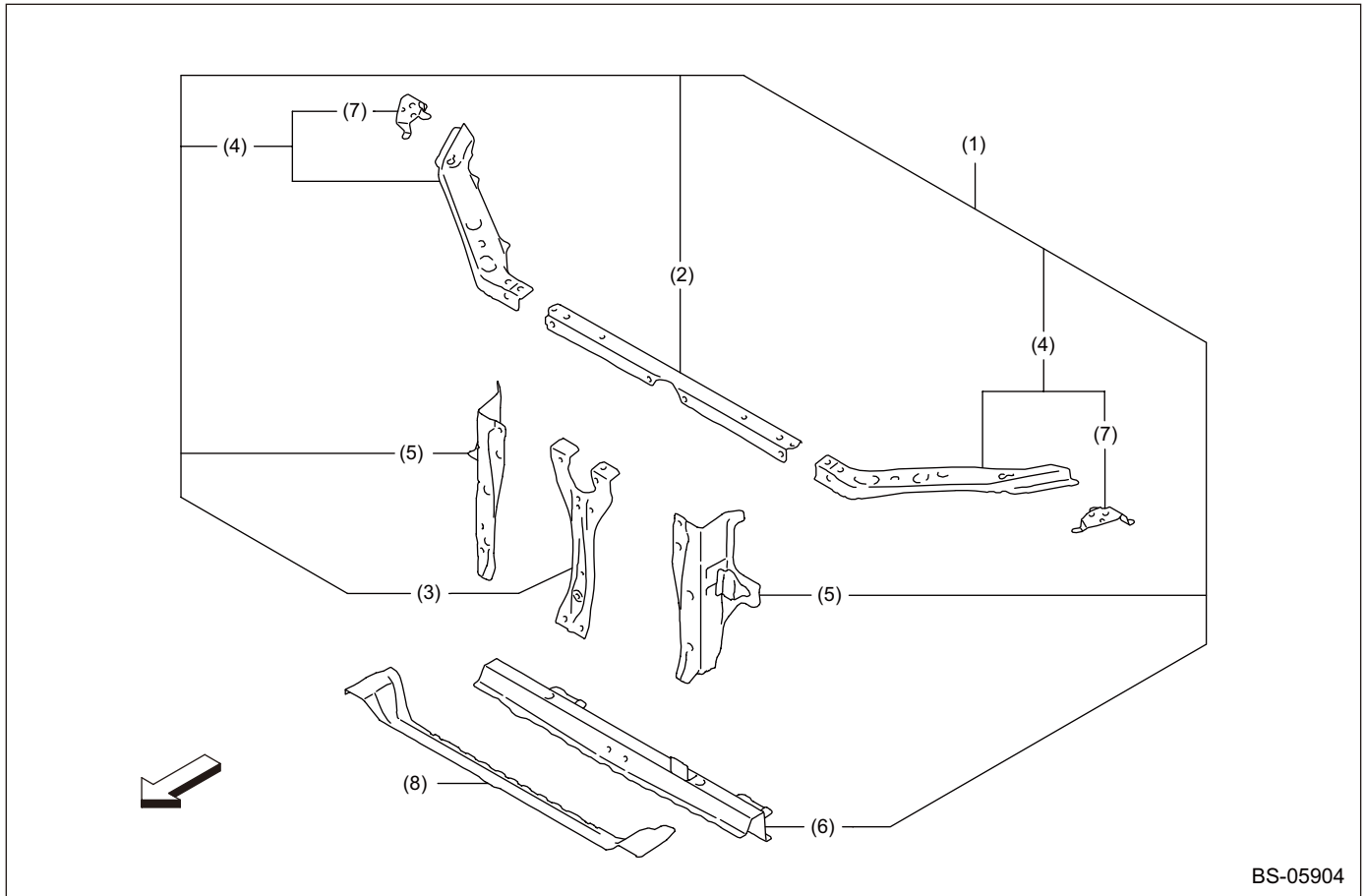
(5) Front panel cover

(2) Front panel side reinforcement

(4) Gusset

Panel Components

2. RADIATOR PANEL

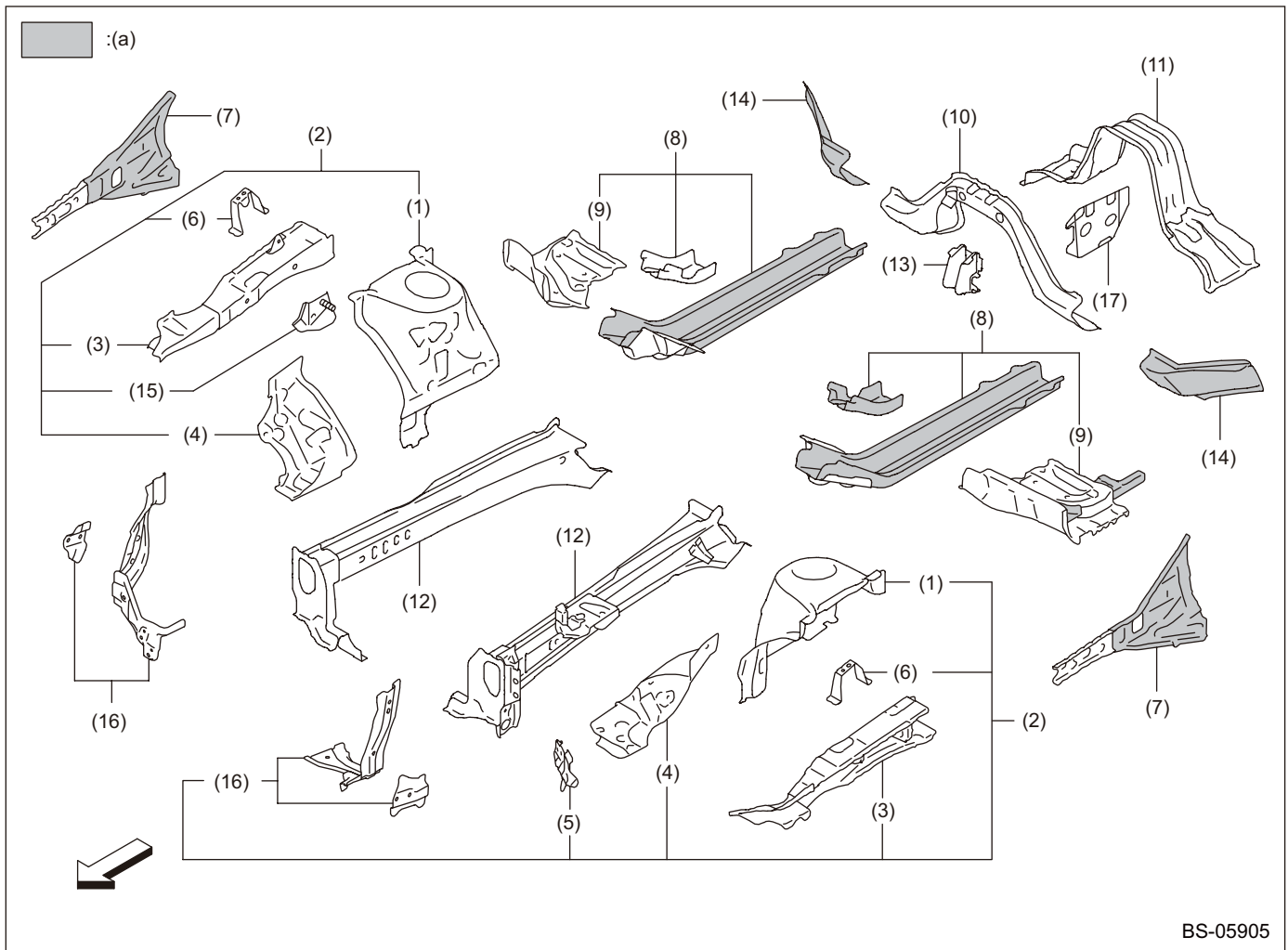


BS-05904

- | | | |
|--------------------------|-------------------------------|----------------------------|
| (1) Radiator panel | (4) Radiator side frame upper | (7) Front fender bracket |
| (2) Radiator frame upper | (5) Radiator panel side | (8) Radiator frame lower B |
| (3) Hood lock stay | (6) Radiator frame lower A | |

Panel Components

3. FRONT WHEEL APRON



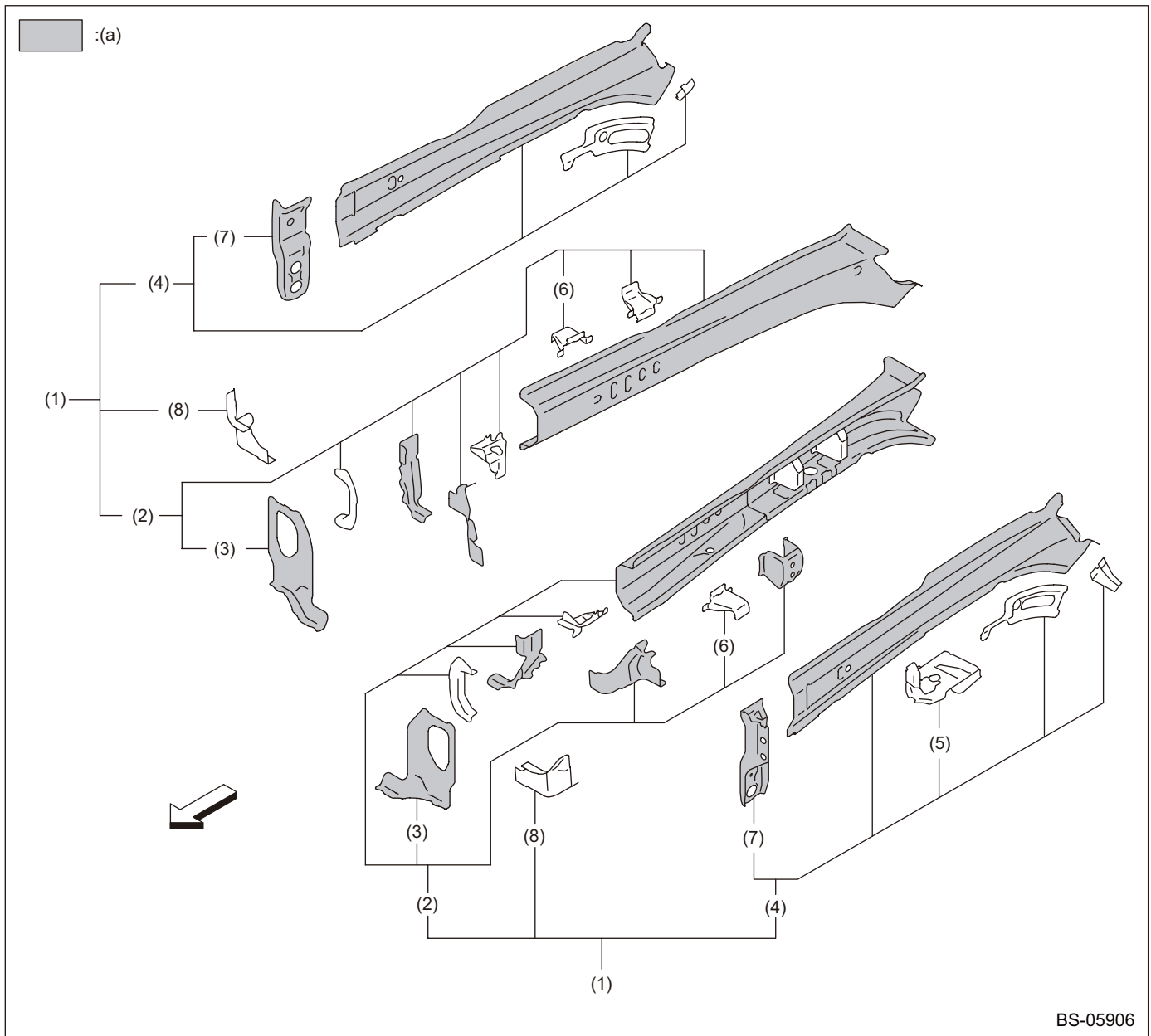
BS-05905

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

- | | | |
|-------------------------------|------------------------------------|------------------------------------|
| (1) Front suspension bracket | (7) Side upper frame | (13) Pitching stopper bracket |
| (2) Wheel apron | (8) Front side frame rear | (14) Toe board cross member side |
| (3) Side upper inner frame | (9) Toe board reinforcement | (15) VDC bracket |
| (4) Front wheel apron | (10) Toe board cross member center | (16) Front wheel apron front |
| (5) Battery rod bracket | (11) Floor cross member front | (17) Reinforcement floor pan front |
| (6) Upper rear fender bracket | (12) Front side frame front | |

Panel Components

4. FRONT SIDE FRAME



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

(1) Front side frame front

(2) Front side sub frame front

(3) Front frame plate front

(4) Closing plate

(5) Battery reinforcement gusset

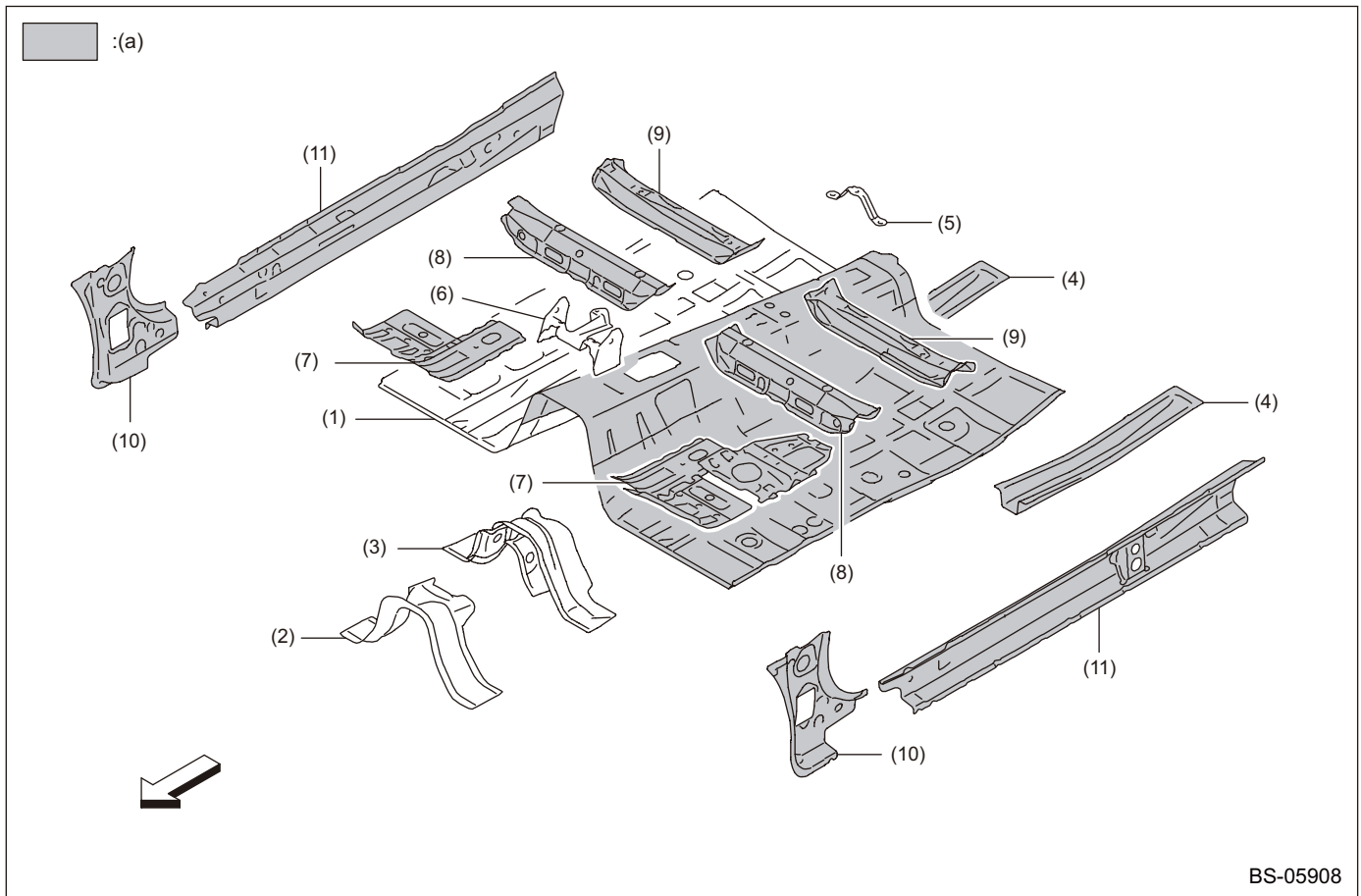
(6) Separator

(7) Front hook reinforcement

(8) Front frame gusset

Panel Components

5. FRONT FLOOR PANEL

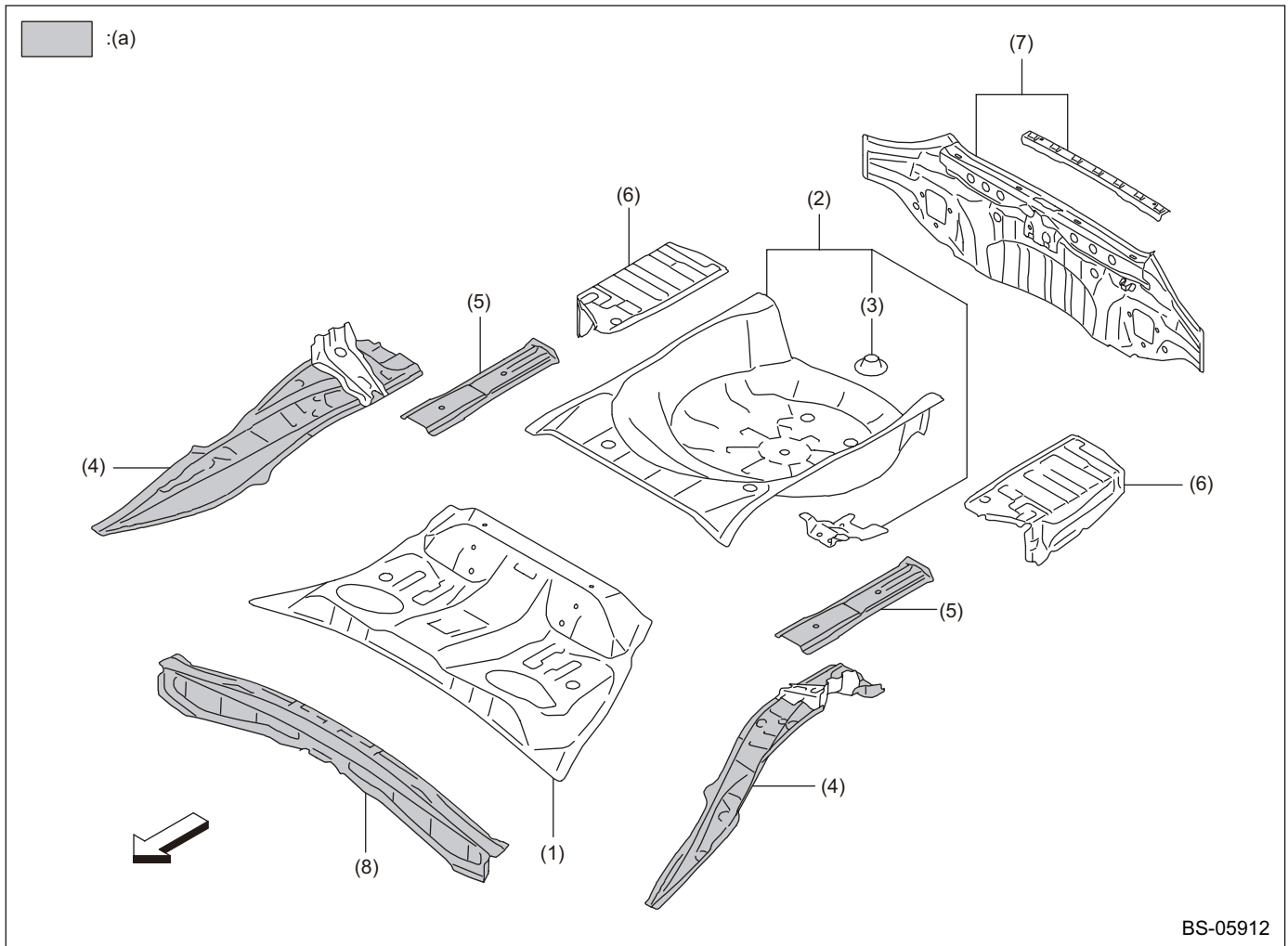


(a) High-strength tensile steel
(440-590 MPa class)

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

Panel Components

6. REAR FLOOR PANEL & REAR SKIRT



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

(1) Rear floor pan front

(2) Rear floor pan rear

(3) Spare tire bracket

(4) Damper bracket floor upper

(5) Rear side frame upper rear

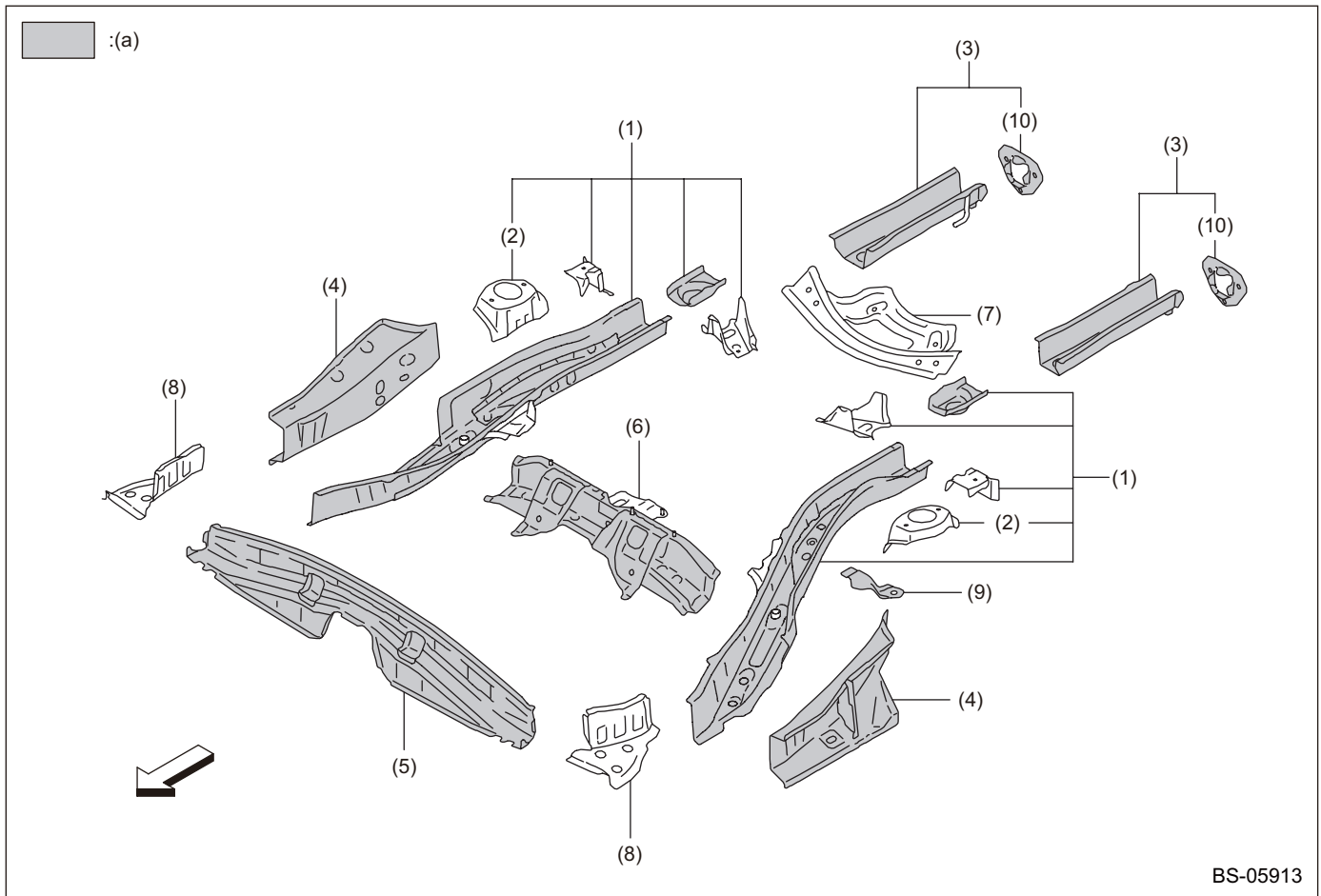
(6) Floor side rear

(7) Rear skirt

(8) Rear floor cross member A front

Panel Components

7. REAR FLOOR SIDE FRAME



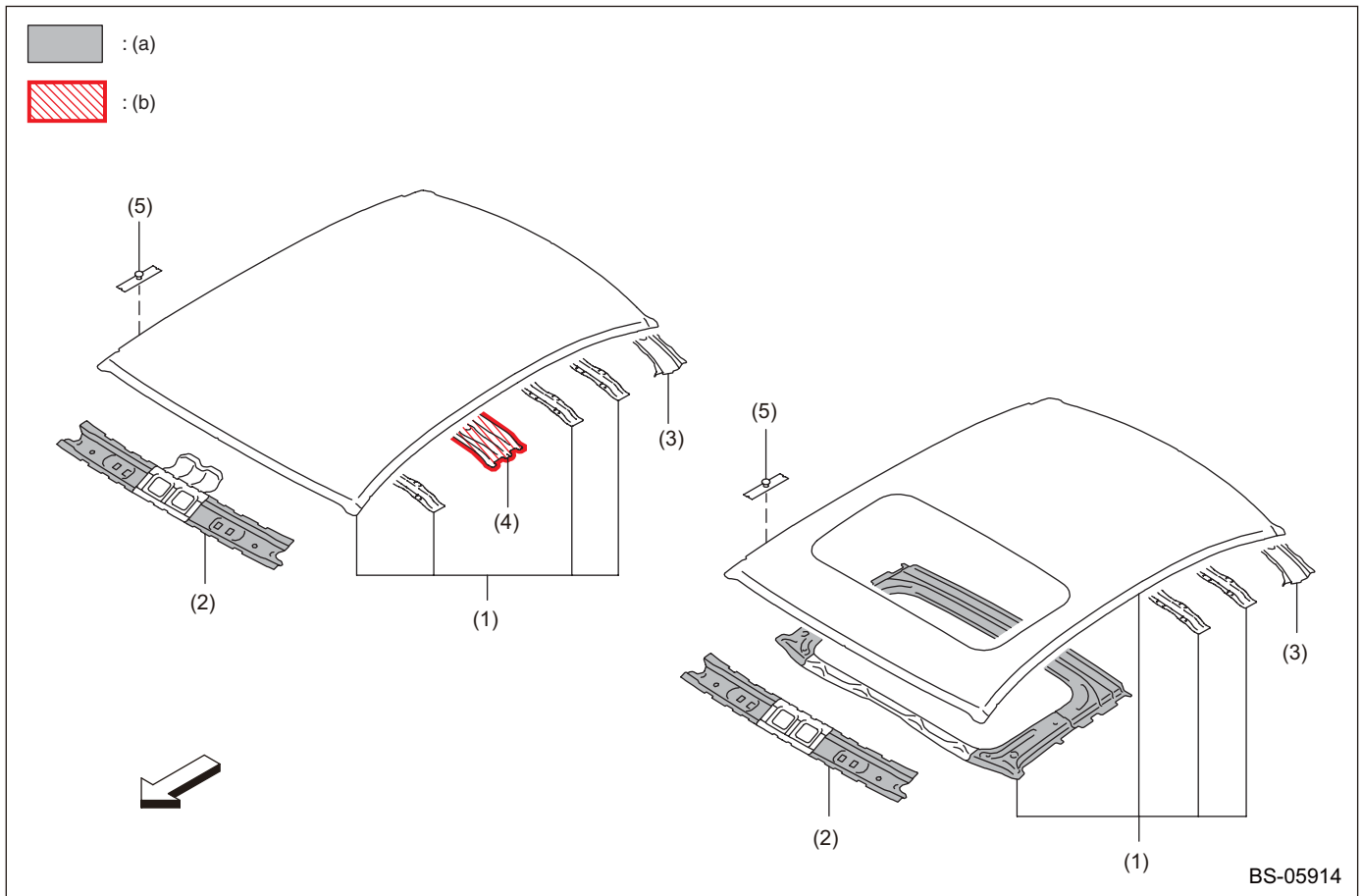
BS-05913

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

- | | | |
|--------------------------------------|------------------------------------|--------------------------|
| (1) Floor side frame rear | (5) Rear floor cross member A rear | (9) Drain hose bracket |
| (2) Rear suspension bracket | (6) Rear floor cross member B | (10) Rear bumper bracket |
| (3) Floor side frame rear lower rear | (7) Rear floor cross member C | |
| (4) Side sill inner rear | (8) Rear side frame gusset | |

Panel Components

8. ROOF



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

(b) High-strength tensile steel
(1,500 MPa class)

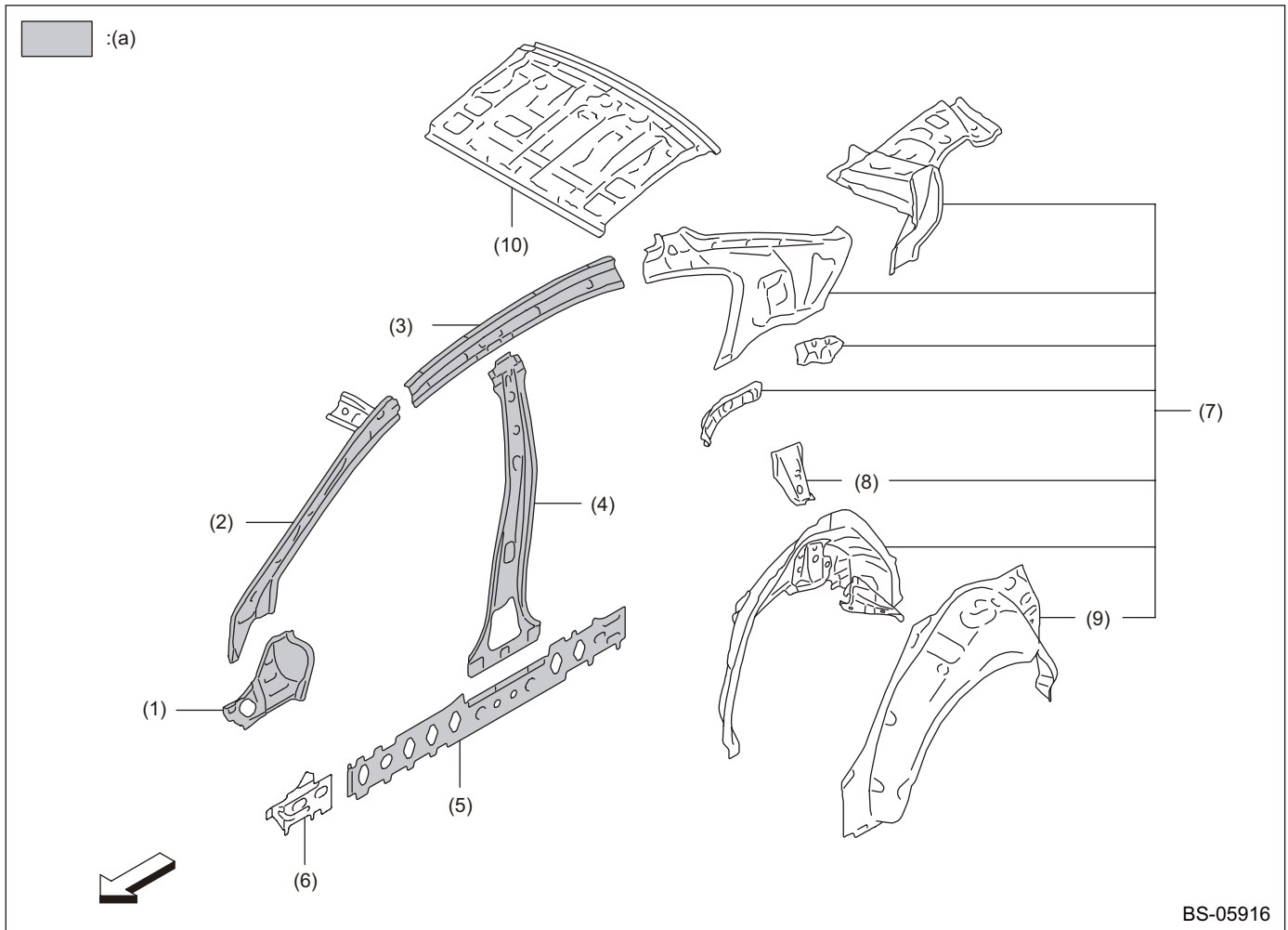
(1) Roof panel
(2) Front roof rail

(3) Rear roof rail
(4) Roof center brace

(5) T stud plate

Panel Components

9. SIDE PANEL INNER

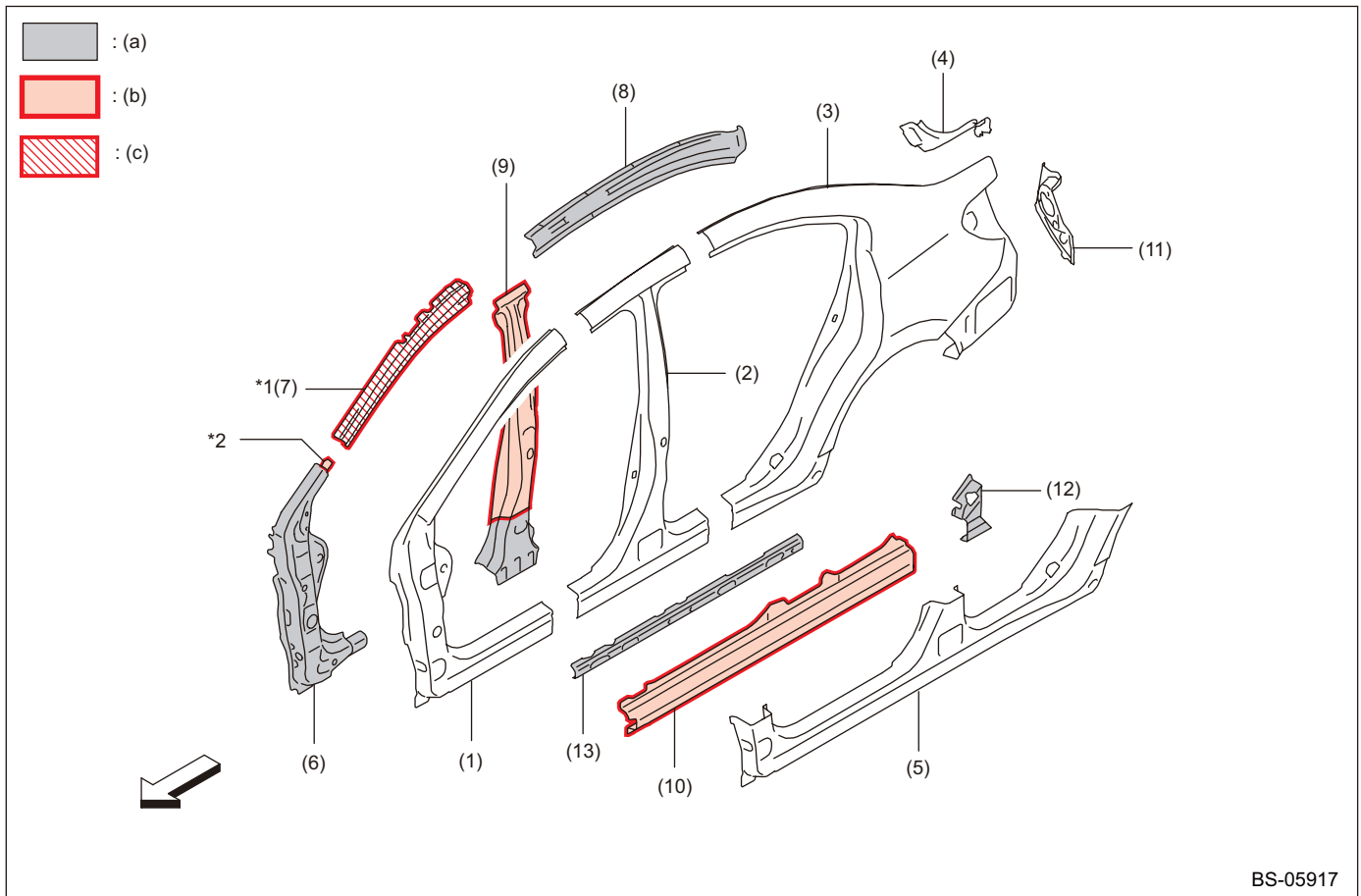


(a) High-strength tensile steel
(440-590 MPa class)

- | | | |
|-------------------------------|-------------------------------------|---------------------|
| (1) Front pillar inner center | (5) Reinforcement sill side rear | (9) Arch rear inner |
| (2) Front pillar inner upper | (6) Reinforcement sill side front | (10) Rear panel |
| (3) Side rail inner | (7) Rear quarter inner | |
| (4) Pillar center inner | (8) Rear pillar reinforcement outer | |

Panel Components

10.SIDE PANEL OUTER



*1: High-tensile tensile steel RH side
(440-590 MPa class)

*2: Parts of the LH side only

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

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

(c) High-strength tensile steel
(1,500 MPa class)

(1) Front pillar outer

(2) Center pillar outer

(3) Rear quarter outer

(4) Rear pillar patch

(5) Side sill outer

(6) Front pillar reinforcement lower

(7) Side rail reinforcement outer front

(8) Reinforcement rail side rear

(9) Center pillar reinforcement

(10) Reinforcement sill side outer

(11) Rear quarter end

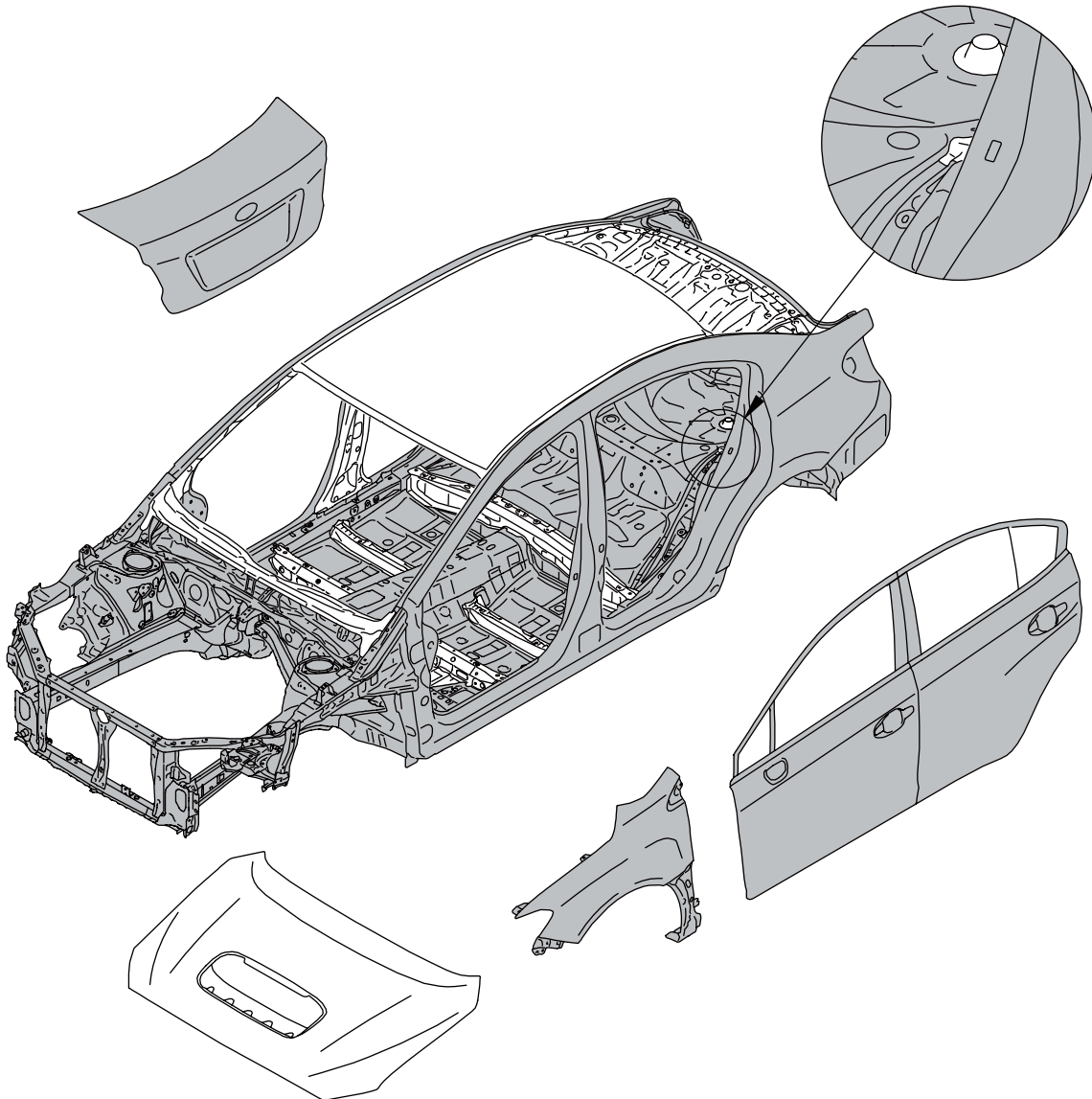
(12) Rear quarter catcher reinforcement

(13) Reinforcement sill side outer A

3. Galvanized Sheet Metal

A: SPECIFICATION

■ : (1)



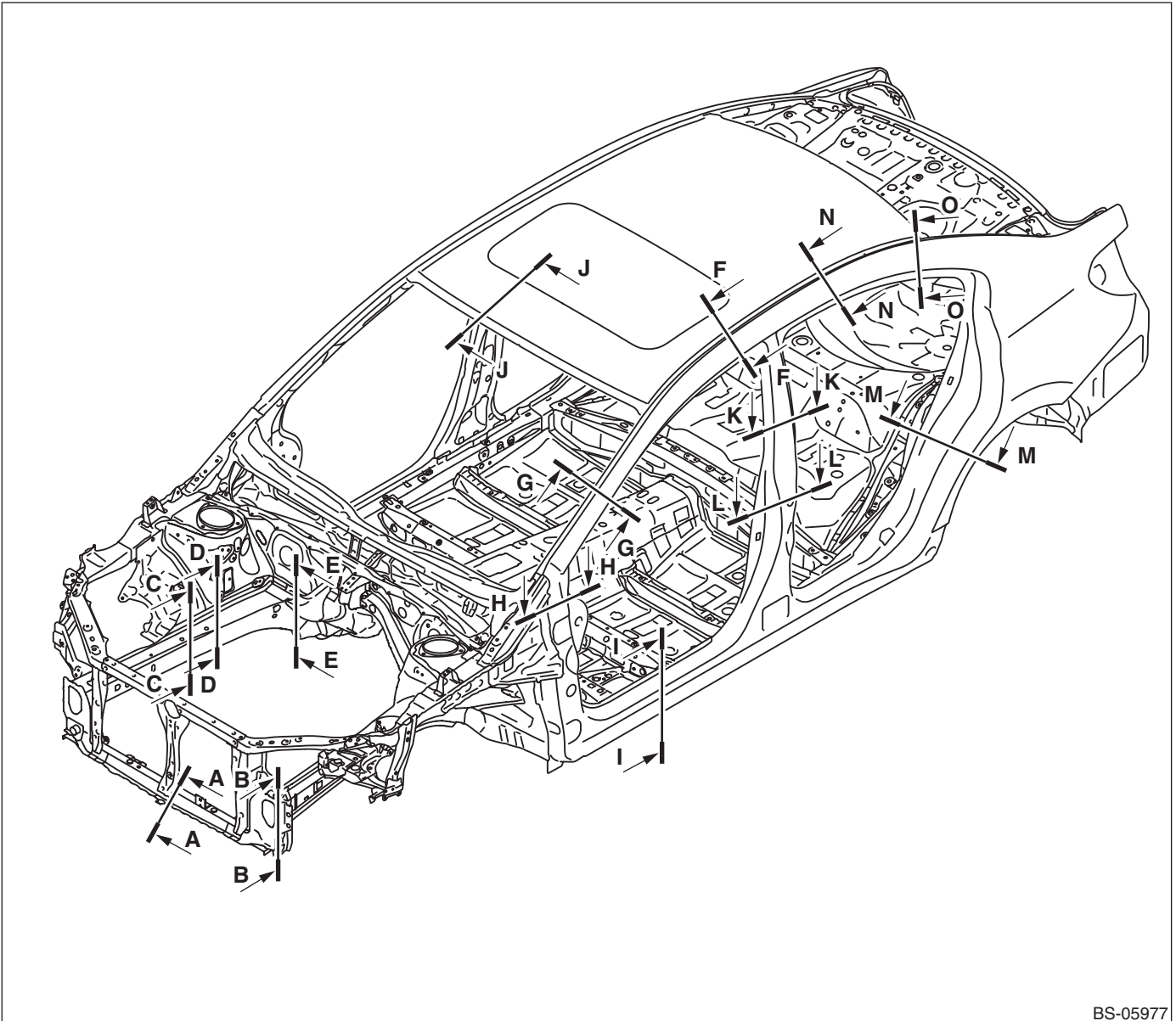
BS-05901

- (1) Galvanized sheet metal (Both sides)

The fuel flap consists of galvanized sheet metal.

4. Body Construction

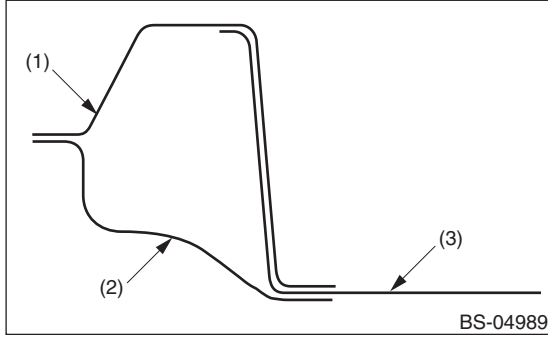
A: SPECIFICATIONS



BS-05977

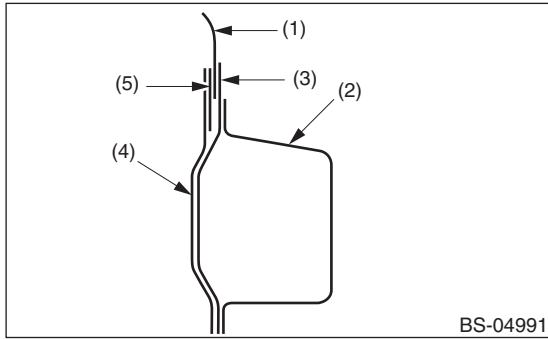
Body Construction

Cross section A — A



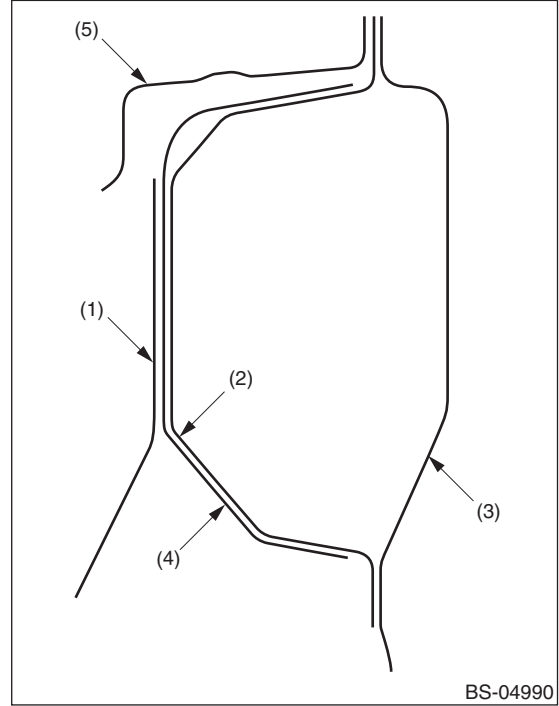
- (1) Radiator frame lower A
- (2) Radiator frame lower B
- (3) Radiator bracket

Cross section C — C



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

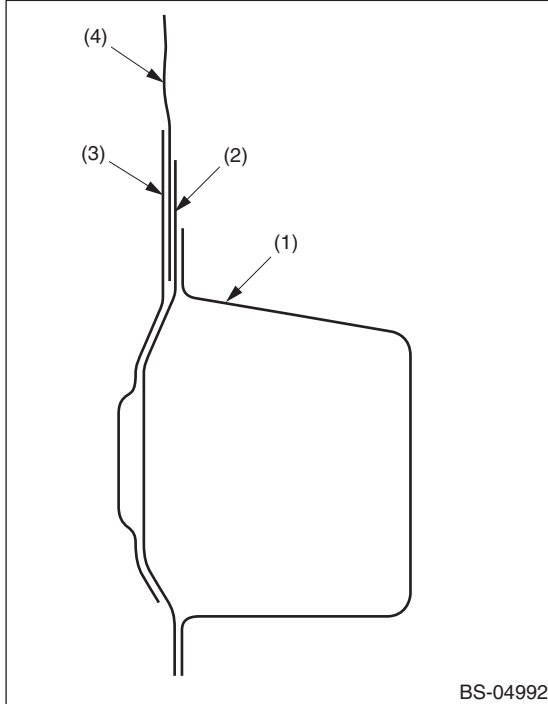
Cross section B — B



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

Body Construction

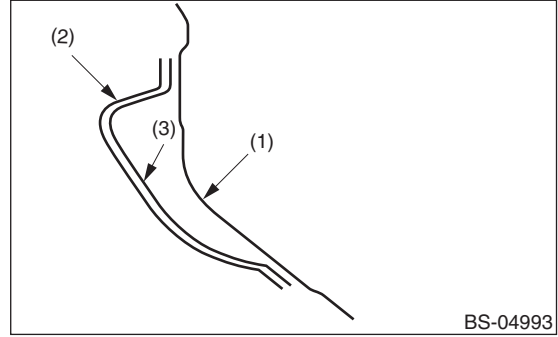
Cross section D — D



BS-04992

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

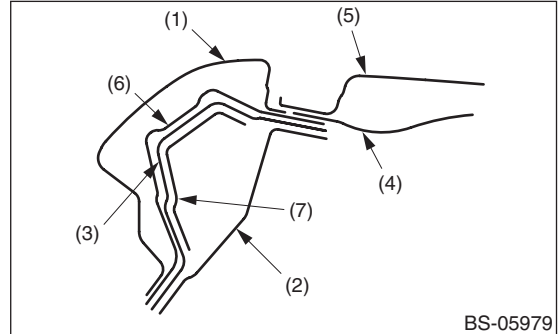
Cross section E — E



BS-04993

- (1) Toe board
- (2) Toe board center cross member
- (3) Toe board side cross member

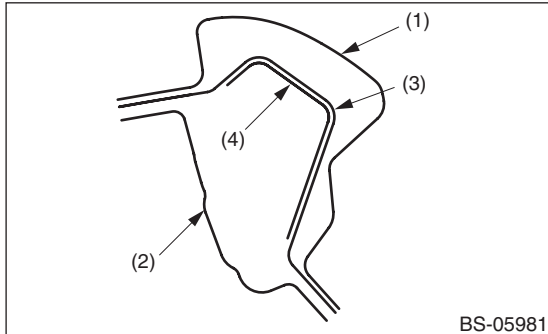
Cross section F — F



BS-05979

- (1) Panel side outer
- (2) Side rail inner
- (3) Reinforcement rail side outer
- (4) Brace front
- (5) Roof panel
- (6) Reinforcement rail side rear
- (7) Reinforcement rail side A (only LH)

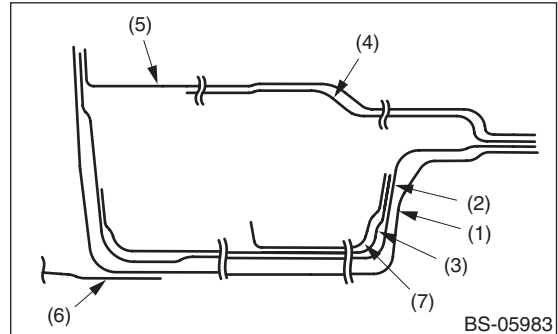
Cross section G — G



BS-05981

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

Cross section H — H

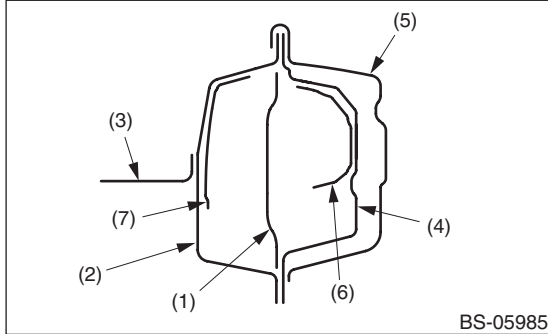


BS-05983

- (1) Panel side outer
- (2) Front pillar reinforcement outer
- (3) Front pillar reinforcement Center A, B
- (4) Front pillar inner Center
- (5) Front pillar inner upper
- (6) Side frame gusset upper
- (7) front pillar reinforcement upper (only LH)

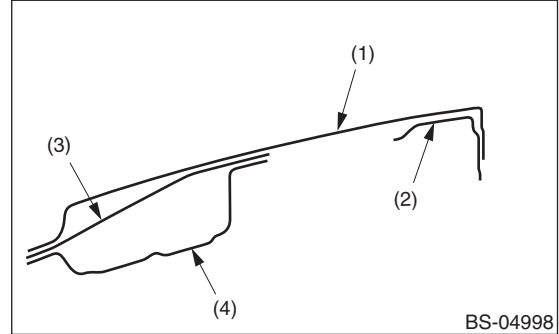
Body Construction

Cross section I — I



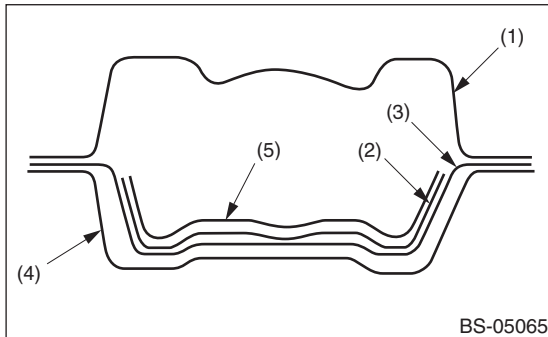
- (1) Reinforcement sill side rear
- (2) Side sill inner front
- (3) Floor pan front
- (4) Reinforcement sill side outer
- (5) Panel side outer
- (6) Reinforcement sill side outer A
- (7) Reinforcement sill side front

Cross section J — J



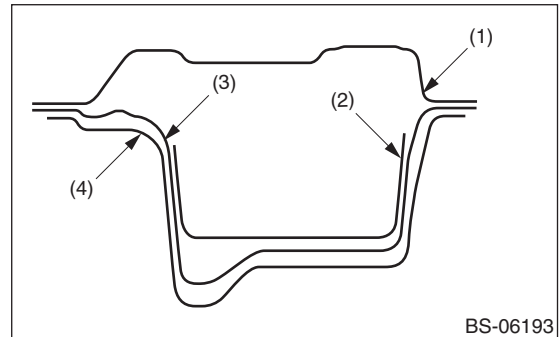
- (1) Roof panel
- (2) Frame sunroof
- (3) Front rail upper
- (4) Front rail lower

Cross section K — K



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

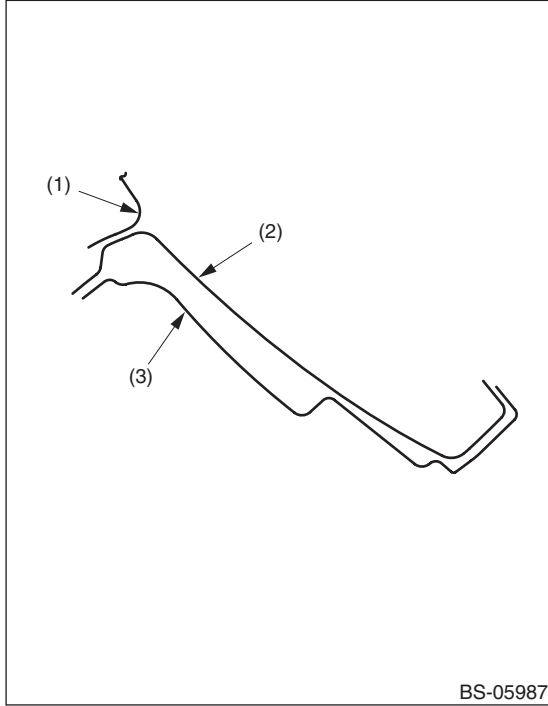
Cross section L — L



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

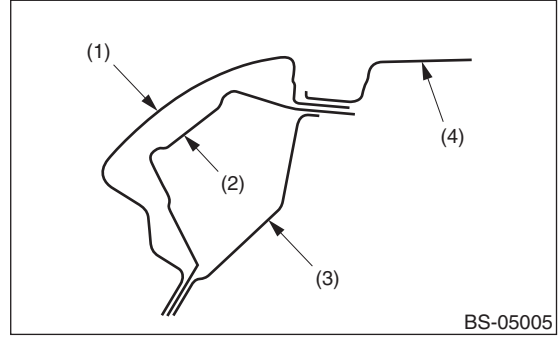
Body Construction

Cross section M — M



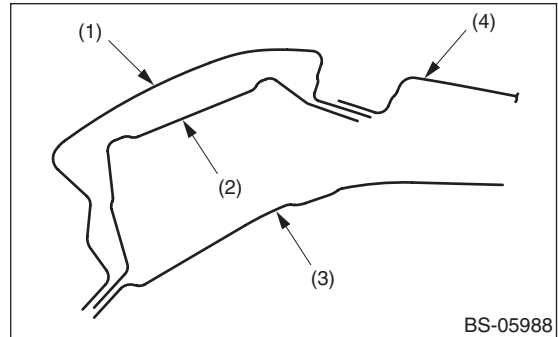
- (1) Wheel apron rear
- (2) Arch rear inner
- (3) Panel side outer

Cross section N — N



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

Cross section O — O

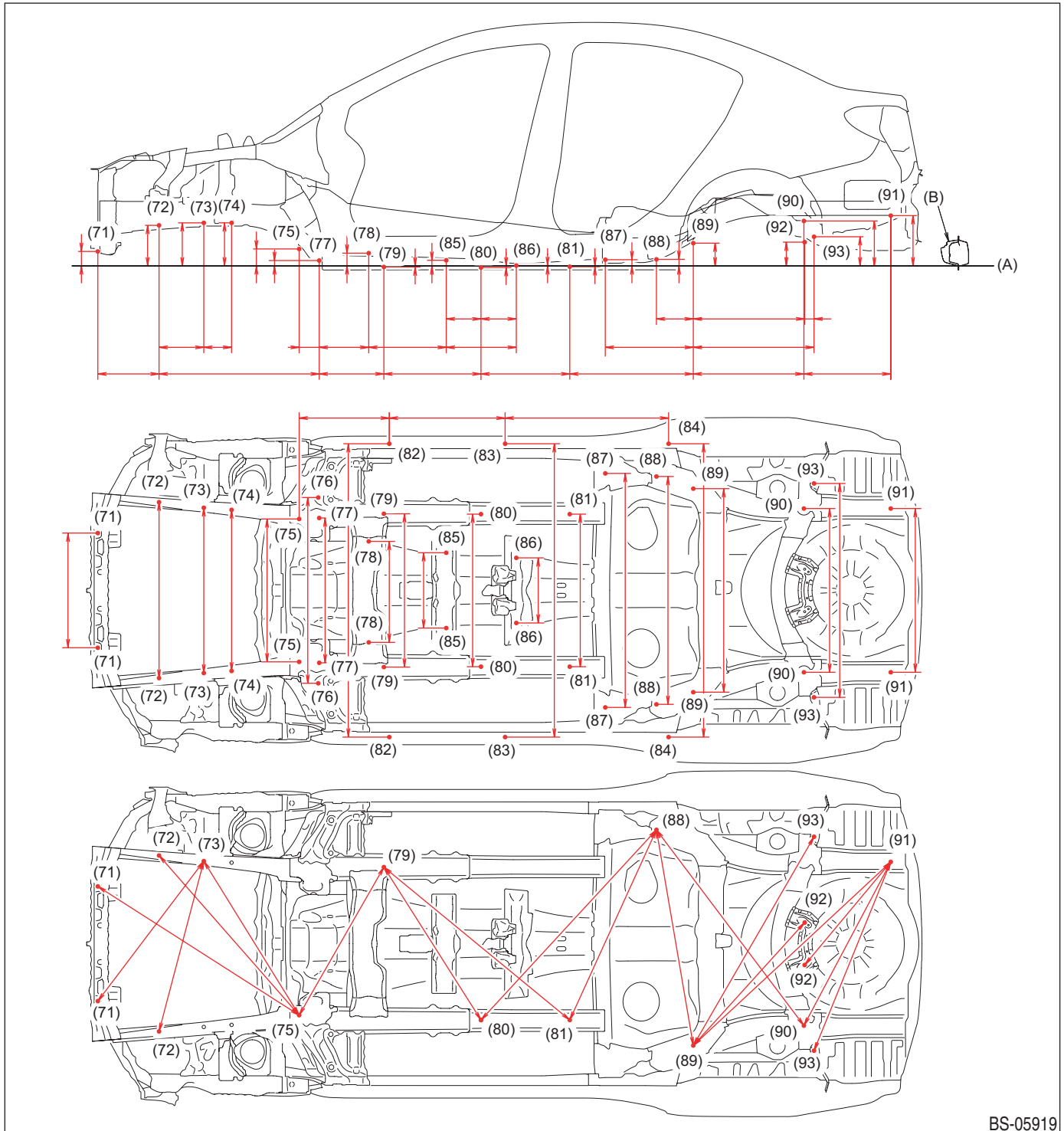


- (1) Panel side outer
- (2) Reinforcement rail side rear
- (3) Pillar rear inner
- (4) Roof panel

5. Body Reference Points

A: DIMENSIONS

1. LOWER SURFACE



BS-05919

- 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).
- Diagonal dimensions are the actual dimensions between reference points.

Body Reference Points

(A) Standard line

- (71) Bracket center lower mounting hole (symmetrical)
- (72) Radio ground mounting hole (symmetrical)
- (73) Front cross member mounting hole (symmetrical), front
- (74) Front cross member mounting hole (symmetrical), rear
- (75) Front suspension arm mounting hole (symmetrical)
- (76) Front suspension plate mounting hole (symmetrical), outer side
- (77) Front suspension plate mounting hole (symmetrical), inner side
- (78) MT cross member mounting hole aR (right side)
- (78) MT cross member mounting hole aL (left side)

(B) Side sill outer panel

- (78) CVT cross member mounting hole bR (right side)
- (78) CVT cross member mounting hole bL (left side)
- (79) Under cover mounting hole (symmetrical)
- (80) Under cover mounting hole (symmetrical)
- (81) Under cover mounting hole (symmetrical)
- (82) Side spoiler mounting hole (symmetrical)
- (83) Side spoiler mounting hole (symmetrical)
- (84) Air flap mounting hole (symmetrical)
- (85) Gauge hole (symmetrical)
- (86) Exhaust cover mounting hole (symmetrical)
- (87) Gauge hole (symmetrical)
- (88) Rear suspension support sub frame mounting hole (symmetrical)
- (89) Rear suspension cross member mounting hole (symmetrical)
- (90) Rear suspension cross member mounting hole (symmetrical)
- (91) Gauge hole (symmetrical)
- (92) Support sub frame mounting hole (symmetrical)
- (93) Support sub frame mounting hole (symmetrical)

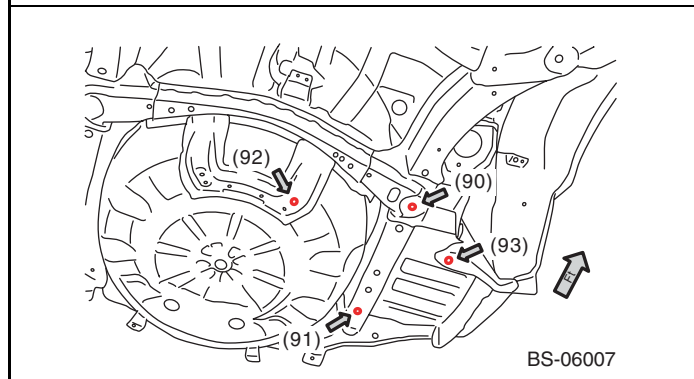
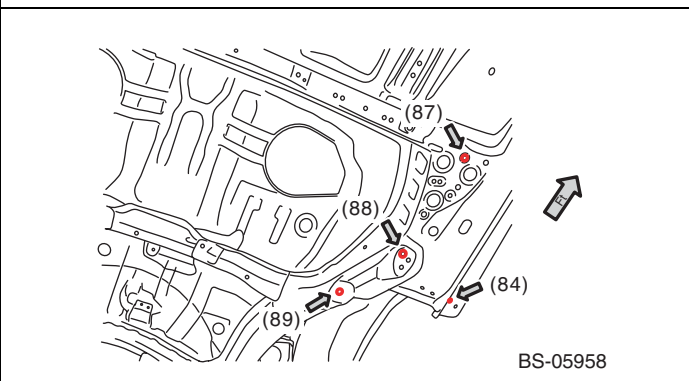
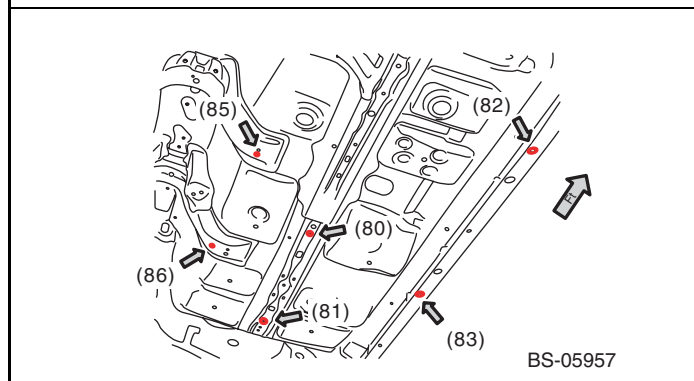
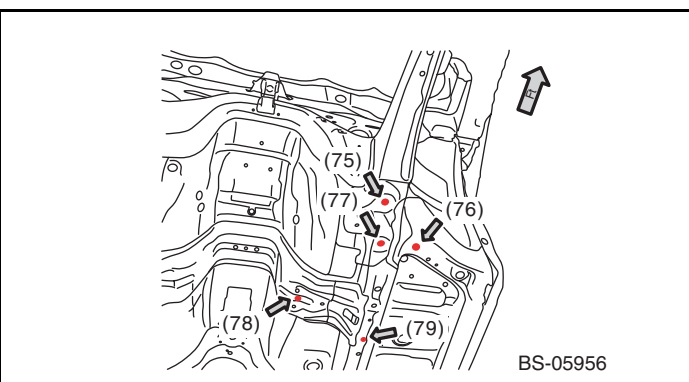
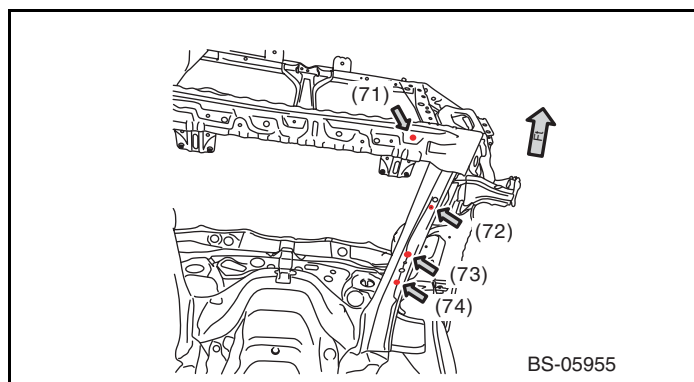
Measuring point	Datum dimension mm (in)	Projected dimensions mm (in)
Datum line — (71)	75(2.95)	—
Datum line — (72)	210(8.27)	—
Datum line — (73)	223(8.78)	—
Datum line — (74)	223(8.78)	—
Datum line — (75)	88(3.46)	—
Datum line — (77)	28(1.10)	—
Datum line — (78)aR	66(2.60)	—
Datum line — (78)aL	60(2.36)	—
Datum line — (78)bR	66(2.60)	—
Datum line — (78)bL	60(2.36)	—
Datum line — (79)	-6(-0.24)	—
Datum line — (80)	-9(-0.35)	—
Datum line — (81)	-5(-0.20)	—
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)	—
Datum line — (92)	123(4.84)	—
Datum line — (93)	151(5.94)	—
(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)	—
(77) — (78)aR	257(10.12)	—
(77) — (78)bR	357(14.06)	—

Measuring point	Datum dimension mm (in)	Projected dimensions mm (in)
(77) — (79)	335(13.19)	—
(78)aR — (85)	402(15.83)	—
(78)bR — (85)	302(11.89)	—
(79) — (80)	503(19.80)	—
(80) — (81)	460(18.11)	—
(80) — (85)	180(7.09)	—
(80) — (86)	183(7.20)	—
(81) — (89)	640(25.20)	—
(85) — (86)	363(14.29)	—
(87) — (89)	456(17.95)	—
(88) — (89)	191(7.52)	—
(89) — (90)	573(22.56)	—
(89) — (92)	577(22.72)	—
(89) — (93)	625(24.61)	—
(90) — (91)	450(17.72)	—
(92) — (93)	48(1.89)	—
(75) — (82)	467(18.39)	—
(82) — (83)	600(23.62)	—
(83) — (84)	847(33.35)	—
(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)	—
(78)aR — (78)aL	376(14.80)	—
(78)bR — (78)bL	361(14.21)	—
(79)R — (79)L	800(31.50)	—

Body Reference Points

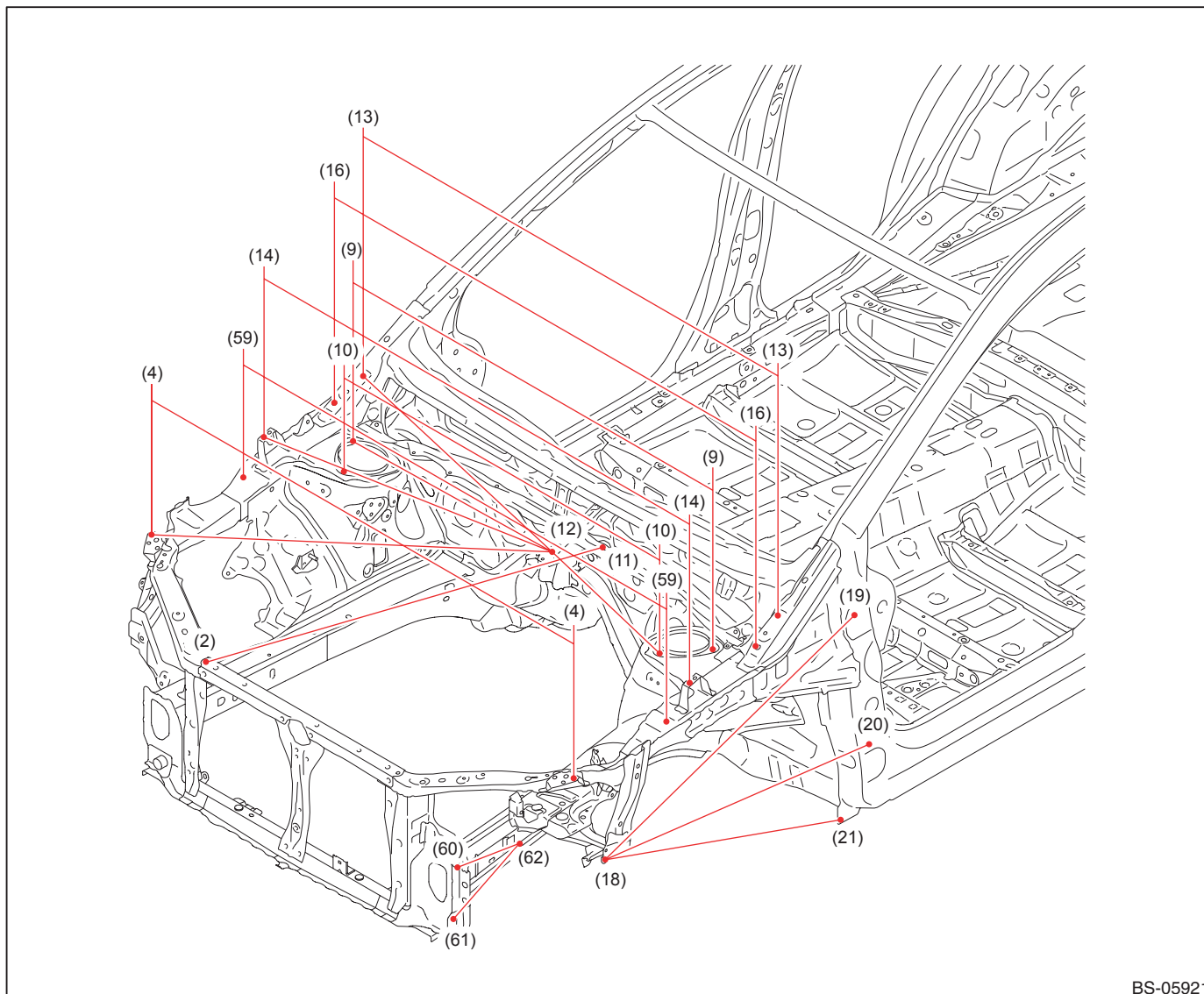
Measuring point	Datum dimension mm (in)	Projected dimen- sions mm (in)
(80)R — (80)L	796(31.34)	—
(81)R — (81)L	796(31.34)	—
(82)R — (82)L	1,525(60.04)	—
(83)R — (83)L	1,525(60.04)	—
(84)R — (84)L	1,516(59.68)	—
(85)R — (85)L	396(15.59)	—
(86)R — (86)L	343(13.50)	—
(87)R — (87)L	1,220(48.03)	—
(88)R — (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)	—
(93)R — (93)L	1,108(43.62)	—
(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)

Measuring point	Datum dimension mm (in)	Projected dimen- sions mm (in)
(72)L — (75)R	1,109(43.66)	1,103(43.43)
(73)L — (75)R	953(37.52)	944(37.17)
(75)R — (79)L	894(35.20)	889(35.00)
(79)L — (80)R	943(37.13)	943(37.13)
(79)L — (81)R	1,251(49.25)	1,251(49.25)
(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	1,408(55.43)	1,401(55.16)
(90)R — (91)L	966(38.03)	965(37.99)
(89)R — (92)L	862(33.94)	862(33.94)
(89)R — (93)L	1,252(49.29)	1,251(49.25)
(91)L — (92)R	711(27.99)	698(27.48)
(91)L — (93)R	1,064(41.89)	1,058(41.65)



Body Reference Points

2. FRONT 1



BS-05921

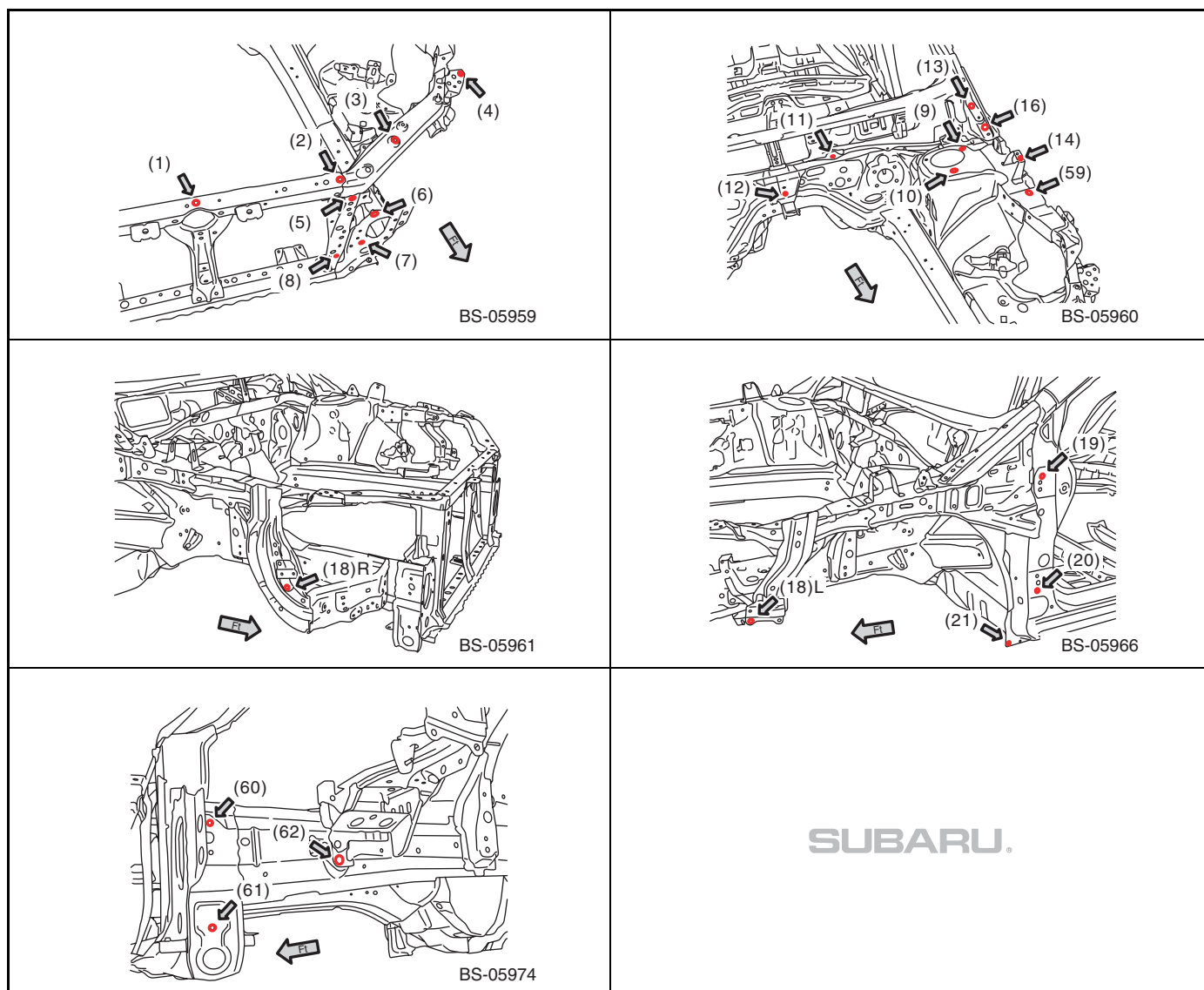
- | | | |
|--|---|---|
| (2) Radiator upper frame mounting hole (symmetrical) | (13) Hood hinge rear mounting hole (symmetrical) | (20) Front door hinge lower mounting hole (symmetrical), upper side |
| (4) Fender mounting hole (symmetrical) | (14) Fender mounting hole (symmetrical) | (21) Fender mounting hole (symmetrical) |
| (9) Front suspension mounting hole (symmetrical), rear outside | (16) Gauge hole (symmetrical) | (59) Frame upper regulation hole (symmetrical) |
| (10) Front suspension mounting hole (symmetrical), front | (18) Gauge hole (right side) R | (60) Keyless buzzer mounting hole (only LH) |
| (11) Bulkhead mounting hole (symmetrical) | (18) Gauge hole (left side) L | (61) Bracket intake duct mounting hole (only LH) |
| (12) Harness clip mounting hole (body center) | (19) front door hinge upper mounting hole (symmetrical), upper side | (62) Gusset front side mounting hole (only LH) |

Body Reference Points

Measuring point	Datum dimension mm (in)
(2)R — (11)L	1,026(40.39)
(4)R — (4)L	1,477(58.15)
(4)R — (12)	992(39.06)
(9)R — (9)L	1,258(49.53)
(9)R — (12)	635(25.00)
(10)R — (10)L	1,103(43.43)
(10)L — (12)	582(22.91)
(12) — (13)R	741(29.17)
(12) — (14)L	797(31.38)
(13)R — (13)L	1,451(57.13)
(14)R — (14)L	1,488(58.58)

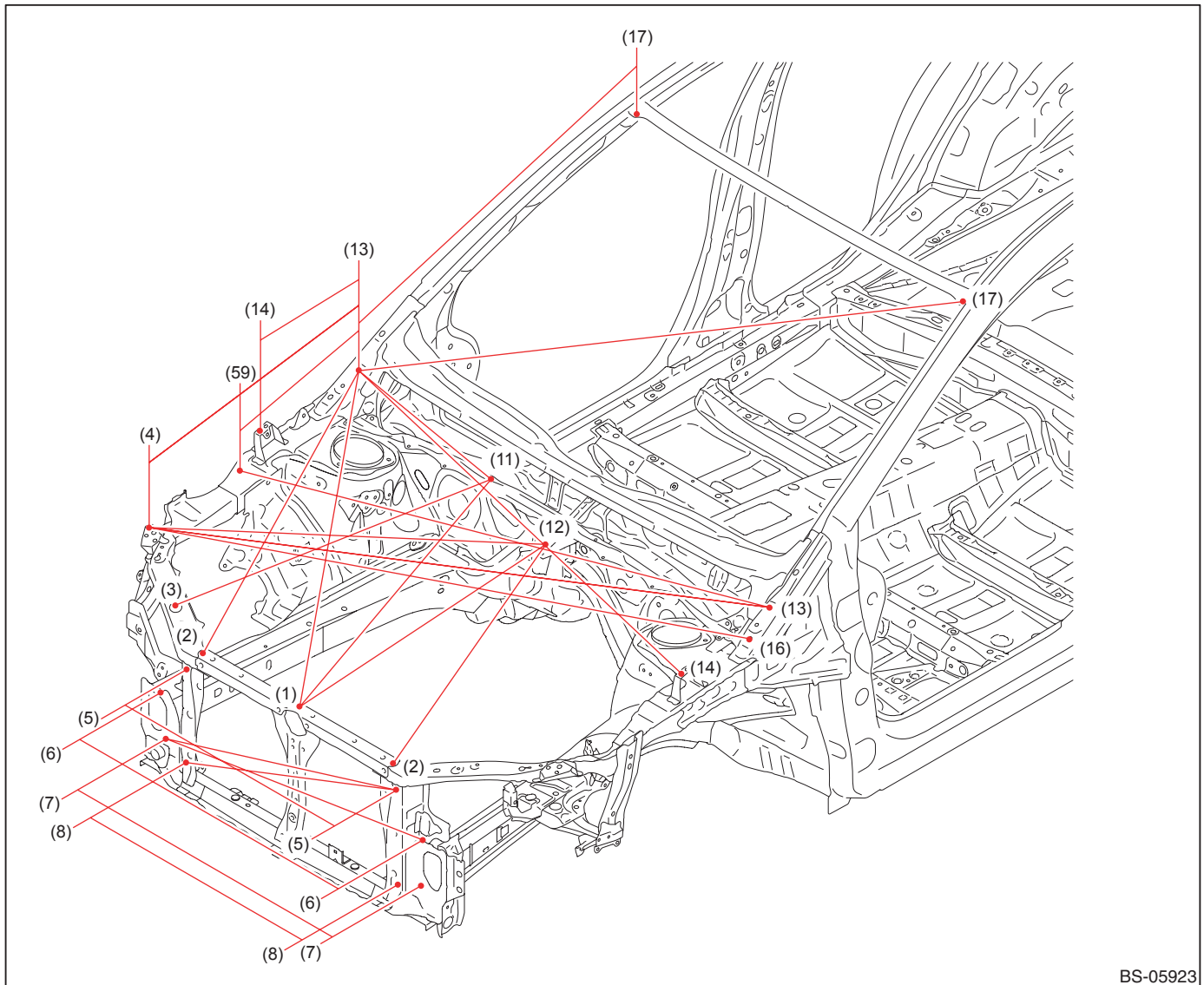
Measuring point	Datum dimension mm (in)
(16)R — (16)L	1,480(58.27)
(18)R — (19)R	932(36.69)
(18)L — (19)L	947(37.28)
(18)R — (20)R	922(36.30)
(18)L — (20)L	944(37.17)
(18)R — (21)R	941(37.05)
(18)L — (21)L	967(38.07)
(59)R — (59)L	1,480(58.27)
(60)L — (62)L	247(9.72)
(61)L — (62)L	261(10.28)

- Reference point (12) is the vehicle midpoint; reference point (18) is a right-left asymmetrical point; reference points (60), (61) and (62) are left side only points; and all other reference points are right-left symmetrical points.
- The dimensions are the actual dimensions between the reference points.



Body Reference Points

3. FRONT 2



BS-05923

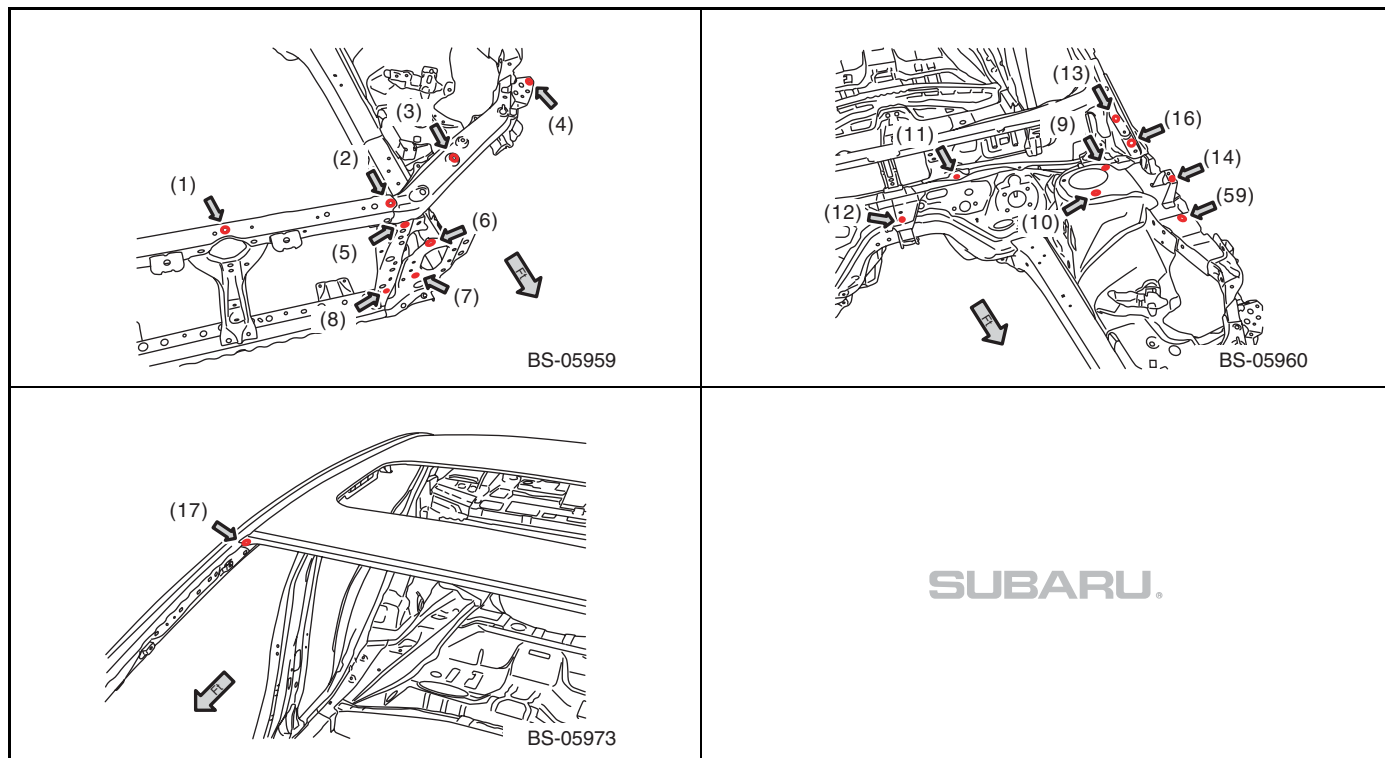
- | | | |
|--|--|--|
| (1) Repair location hole (body center) | (6) Bumper bracket mounting hole (symmetrical), upper side | (13) Hood hinge rear mounting hole (symmetrical) |
| (2) Radiator upper frame mounting hole (symmetrical) | (7) Bumper bracket mounting hole (symmetrical), lower | (14) Fender mounting hole (symmetrical) |
| (3) Headlight mounting hole (symmetrical) | (8) Bulkhead center lower mounting hole (symmetrical) | (16) Gauge hole (symmetrical) |
| (4) Fender mounting hole (symmetrical) | (11) Bulkhead mounting hole (symmetrical) | (17) Front glass installation reference hole (symmetrical) |
| (5) EA plate mounting hole (symmetrical) | (12) Harness clip mounting hole (body center) | (59) Frame upper regulation hole (symmetrical) |

Body Reference Points

Measuring point	Datum dimension mm (in)
(1) — (11)R	898(35.35)
(1) — (12)	871(34.29)
(1) — (13)R	1,199(47.20)
(2)L — (12)	939(36.97)
(2)R — (13)R	1,037(40.83)
(3)R — (11)R	872(34.33)
(4)R — (12)	992(39.06)
(4)R — (13)R	738(29.06)
(4)R — (13)L	1,639(64.53)
(4)R — (16)L	1,613(63.50)
(5)R — (5)L	740(29.13)
(5)L — (7)R	859(33.82)

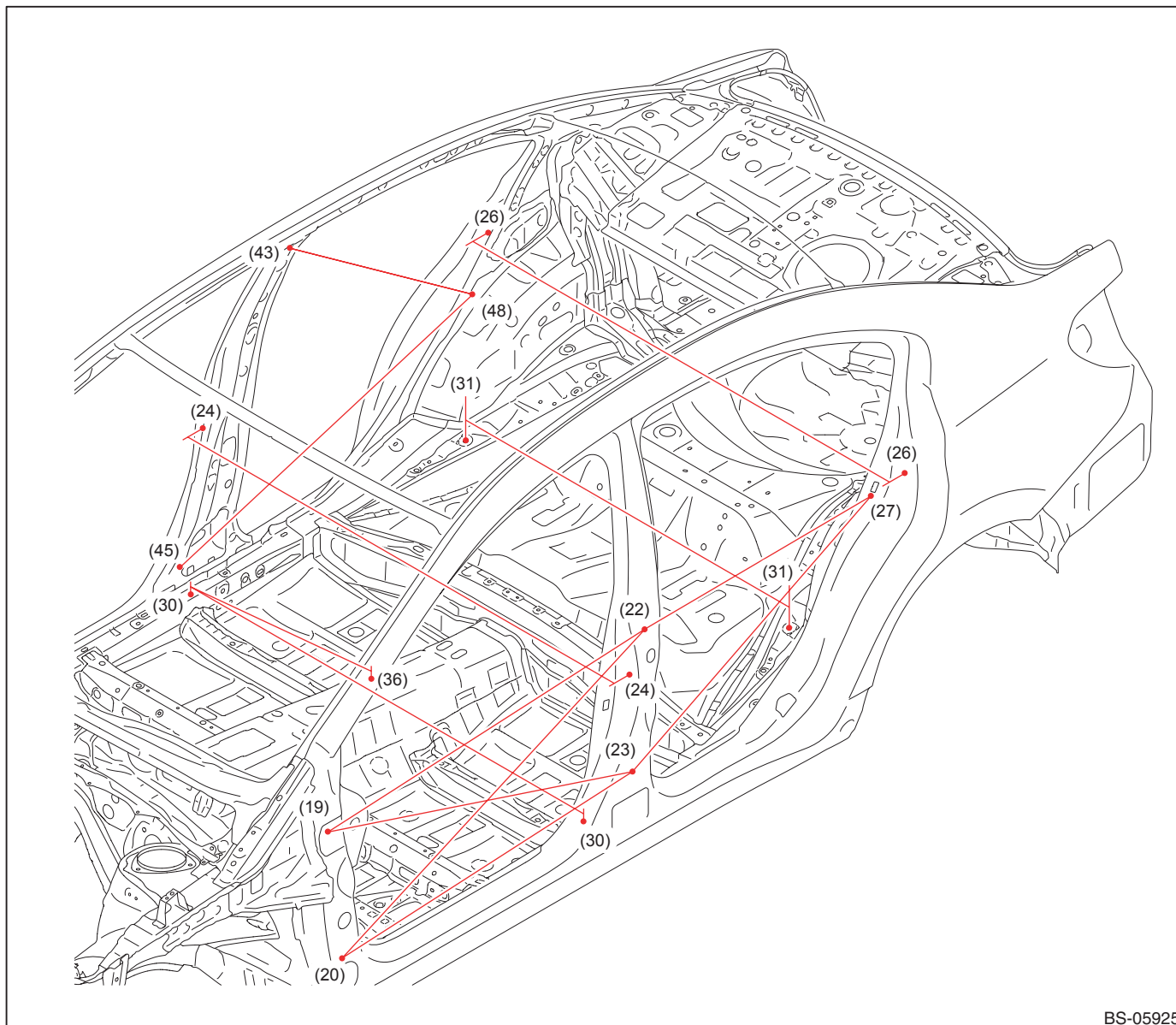
Measuring point	Datum dimension mm (in)
(5)L — (8)R	798(31.42)
(6)R — (6)L	914(35.98)
(6)L — (7)R	918(36.14)
(7)R — (7)L	900(35.43)
(8)R — (8)L	748(29.45)
(11)R — (13)R	546(21.50)
(13)R — (14)R	330(12.99)
(13)R — (14)L	1,506(59.29)
(13)R — (17)R	956(37.64)
(13)R — (17)L	1,608(63.31)
(13)R — (59)R	420(16.54)
(13)L — (59)R	1,524(60.00)

- 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.



Body Reference Points

4. INSIDE COMMON PARTS 1



BS-05925

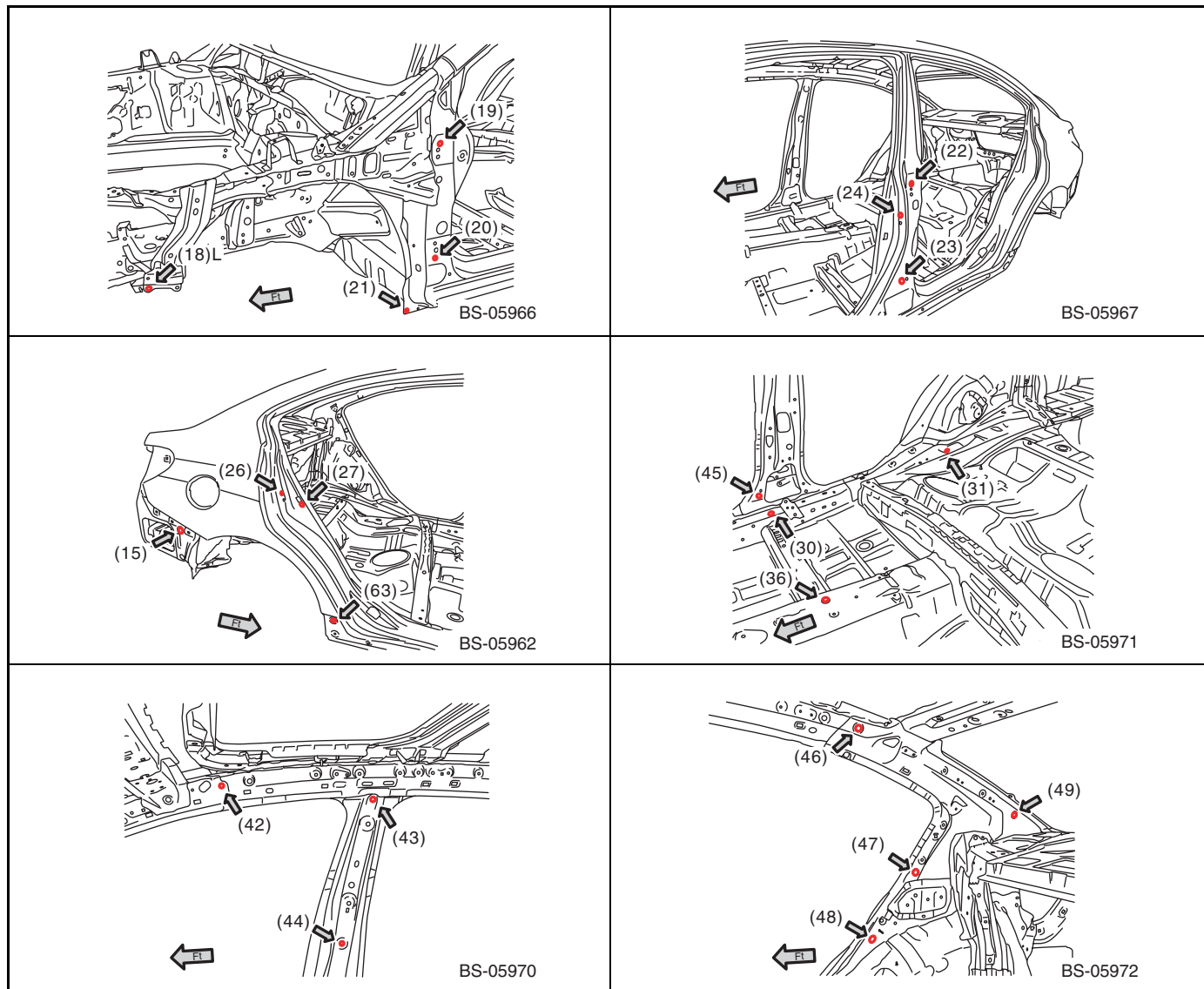
- | | | |
|---|--|---|
| (19) Front door hinge upper mounting hole (symmetrical), upper side | (26) Rear door striker mounting hole (symmetrical), upper side | (43) Trim clip mounting hole (symmetrical) |
| (20) Front door hinge lower mounting hole (symmetrical), upper side | (27) Rear door switch mounting hole (symmetrical) | (45) Trim Clip mounting hole (symmetrical) |
| (22) Rear door hinge upper mounting hole (symmetrical), upper side | (30) Harness clip mounting hole (symmetrical) | (48) Rear Airbag sensor mounting hole (symmetrical) |
| (23) Rear door hinge lower mounting hole (symmetrical), front | (31) Belt anchor mounting hole (symmetrical) | |
| (24) Front door striker mounting hole (symmetrical), upper side | (36) Harness holding Clip mounting hole (symmetrical) | |

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)
(20)L — (22)L	1,199(47.20)
(20)L — (23)L	1,048(41.26)
(22)L — (27)L	883(34.76)
(23)L — (27)L	1,003(39.49)
(24)R — (24)L	1,529(60.20)

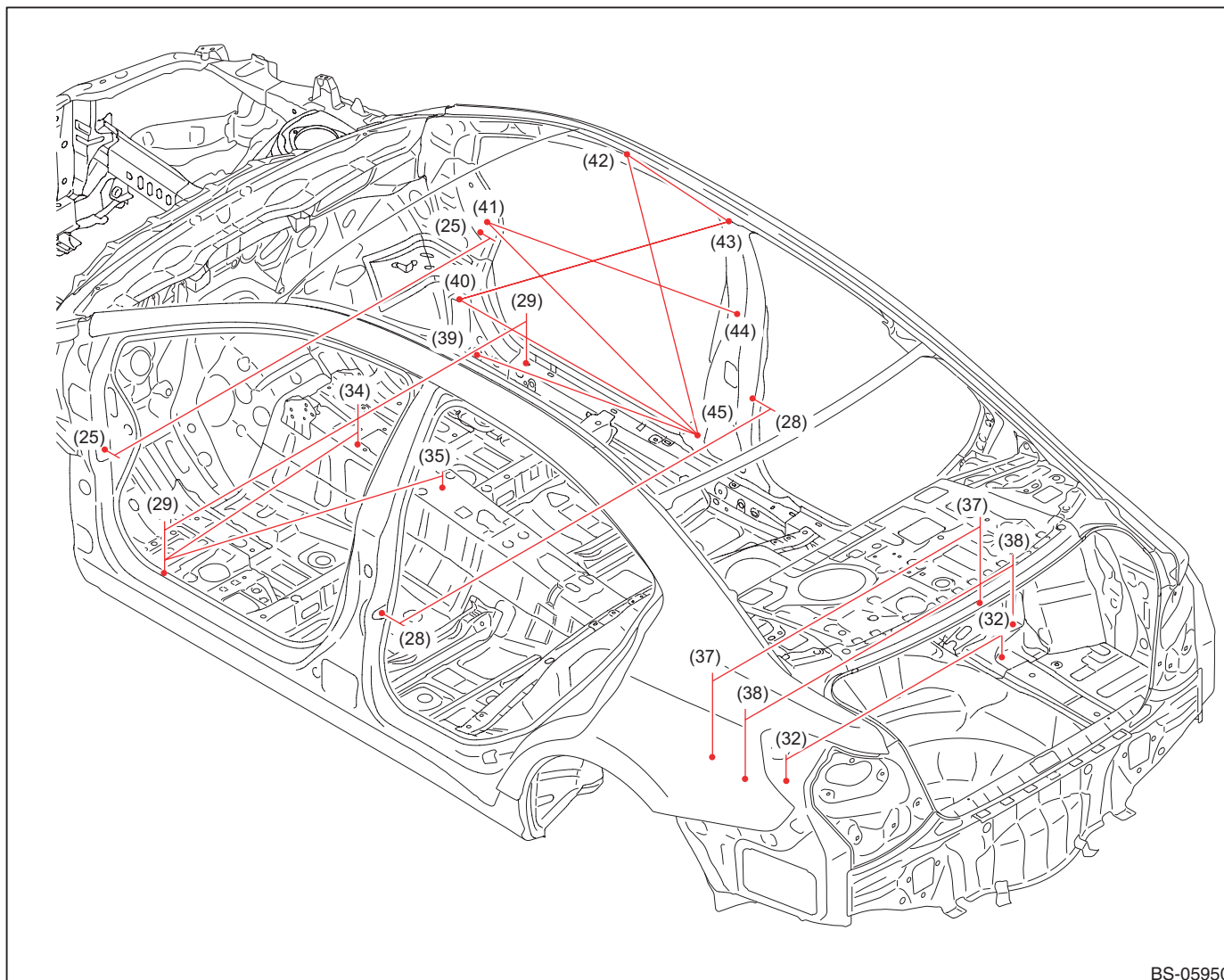
Measuring point	Datum dimension mm (in)
(26)R — (26)L	1,494(58.82)
(30)R — (30)L	1,409(55.47)
(30)R — (36)R	681(26.81)
(31)R — (31)L	1,160(45.67)
(43)R — (48)R	962(37.87)
(45)R — (48)R	1,080(42.52)

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



Body Reference Points

5. INSIDE COMMON PARTS 2



BS-05950

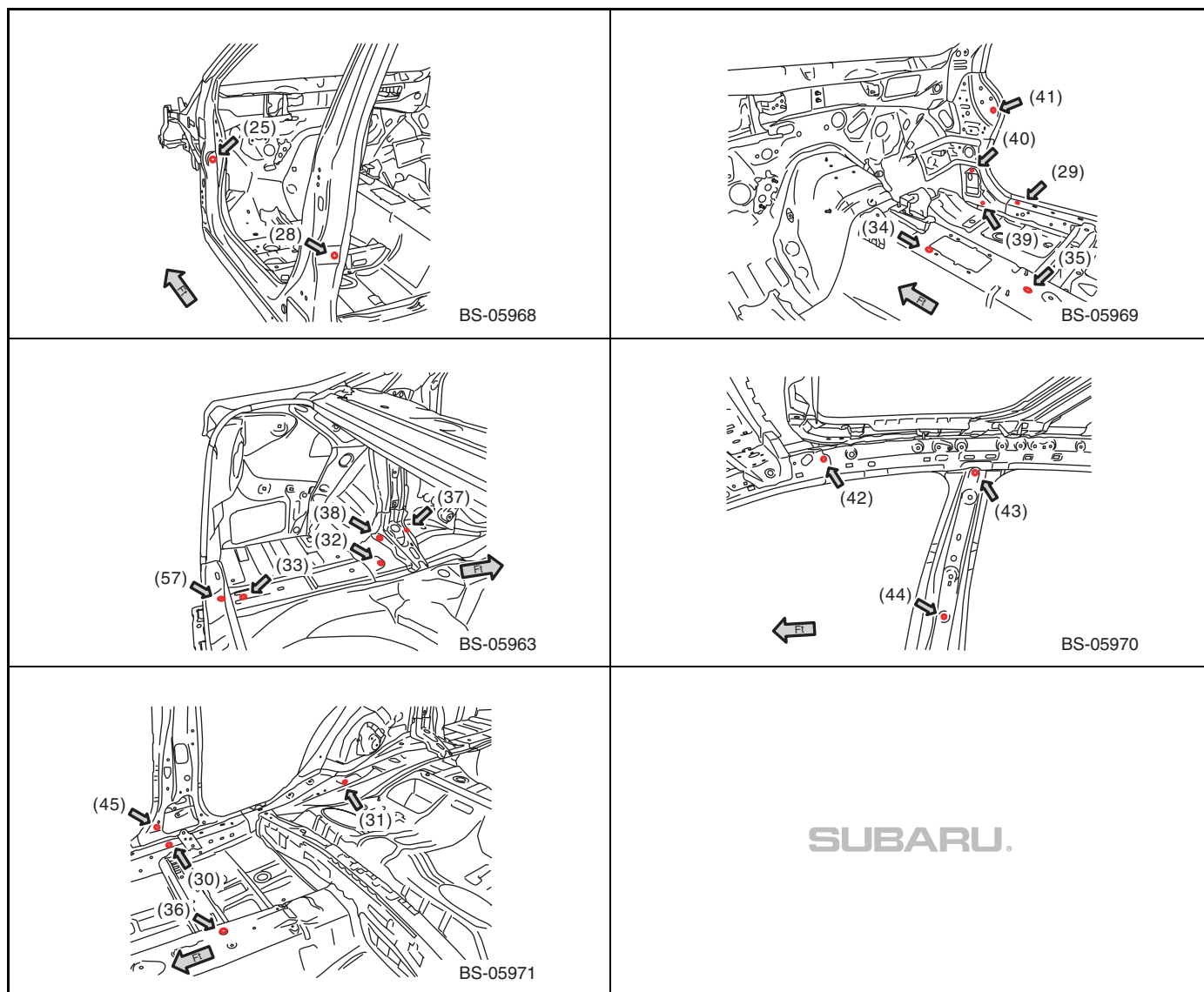
- | | | |
|---|---|---|
| (25) Front door checker mounting hole (symmetrical) | (37) Rear suspension mounting hole (symmetrical), front | (42) Assist bracket mounting hole (symmetrical) |
| (28) Rear door checker mounting hole (symmetrical) | (38) Rear suspension mounting hole (symmetrical), rear | (43) Trim clip mounting hole (symmetrical) |
| (29) Harness clip mounting hole (symmetrical) | (39) Gauge hole/Brake pipe mounting hole R | (44) Trim mounting hole (symmetrical) |
| (32) Gauge hole (symmetrical) | (39) Gauge hole/Fuel pipe mounting hole L | (45) Trim Clip mounting hole (symmetrical) |
| (34) Shift case mounting hole (symmetrical) | (40) Harness connectors mounting hole (symmetrical) | |
| (35) Hand brake mounting hole (body center) | (41) Steering beam mounting hole (symmetrical) | |

Body Reference Points

Measuring point	Datum dimension mm (in)
(25)R — (25)L	1,486(58.50)
(28)R — (28)L	1,469(57.83)
(29)R — (29)L	1,432(56.38)
(29)L — (34)L	689(27.13)
(29)L — (35)	821(32.32)
(32)R — (32)L	854(33.62)
(37)R — (37)L	1,059(41.69)
(38)R — (38)L	1,059(41.69)
(39)R — (45)R	849(33.43)

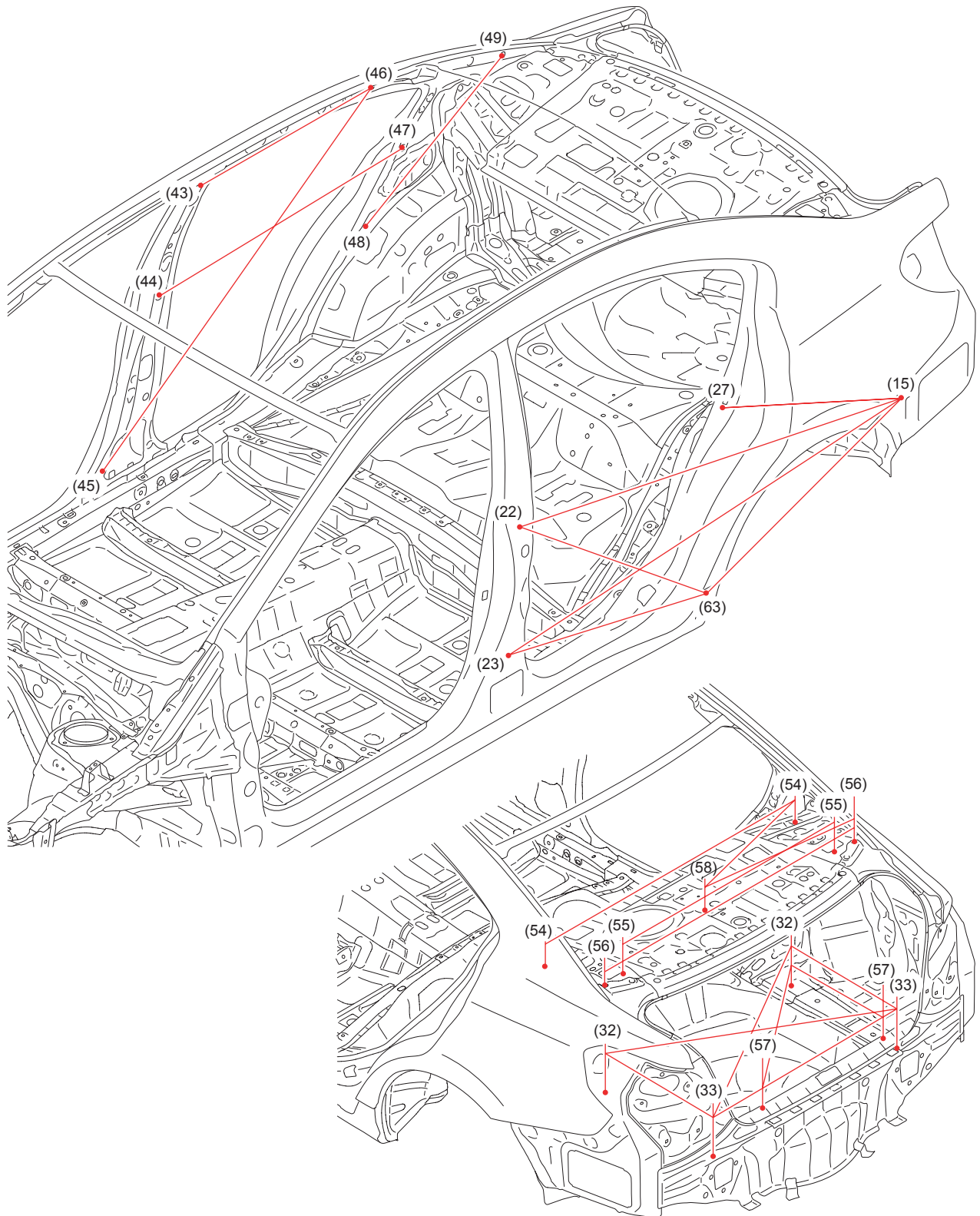
Measuring point	Datum dimension mm (in)
(40)R — (43)R	1,485(58.46)
(40)R — (45)R	915(36.02)
(41)R — (44)R	1,027(40.43)
(41)L — (44)L	1,027(40.43)
(41)R — (45)R	880(34.65)
(41)L — (45)L	880(34.65)
(42)R — (43)R	402(15.83)
(42)R — (45)R	981(38.62)

- Reference point (35) is the vehicle midpoint; and all other reference points are right-left symmetrical points.
- The dimensions are the actual dimensions between the reference points.



Body Reference Points

6. INSIDE REAR



BS-05952

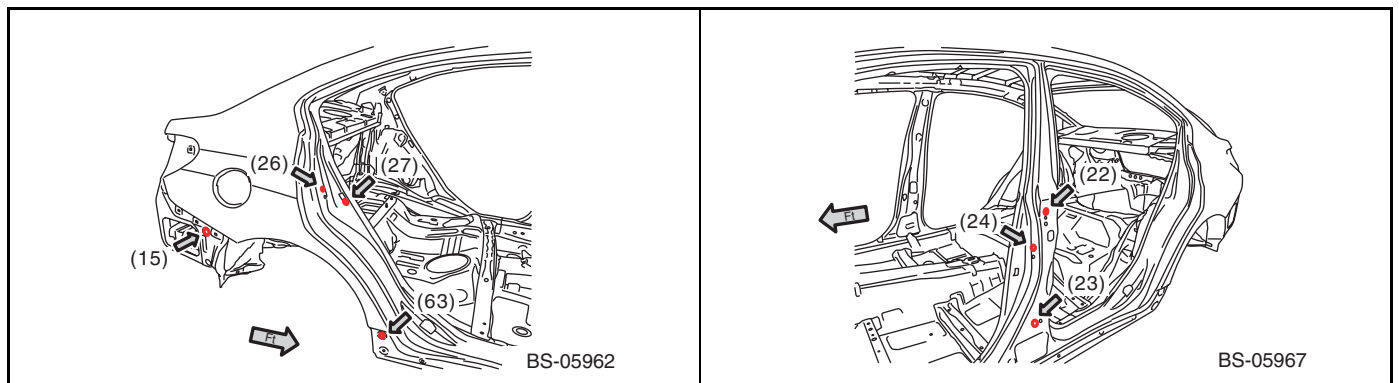
Body Reference Points

(15) Gauge hole (right side) R	(33) Gauge hole (left side) L	(49) Trim clip mounting hole (symmetrical)
(15) Gauge hole (left side) L	(43) Trim clip mounting hole (symmetrical)	(54) Rear shelf mounting hole (symmetrical)
(22) Rear door hinge upper mounting hole (symmetrical), upper side	(44) Trim clip mounting hole (symmetrical)	(55) Rear shelf mounting hole (symmetrical)
(23) Rear door hinge lower mounting hole (symmetrical), front	(45) Trim clip mounting hole (symmetrical)	(56) Gauge hole (symmetrical)
(27) Rear door switch mounting hole (symmetrical)	(46) Drain hose mounting hole (symmetrical)	(57) Electrode position hole (symmetrical)
(32) Gauge hole (symmetrical)	(47) Gauge hole (symmetrical)	(58) Child anchor mounting hole (body center)
(33) Gauge hole (right side) R	(48) Rear Airbag sensor mounting hole (symmetrical)	(63) Side spoiler mounting hole (symmetrical)

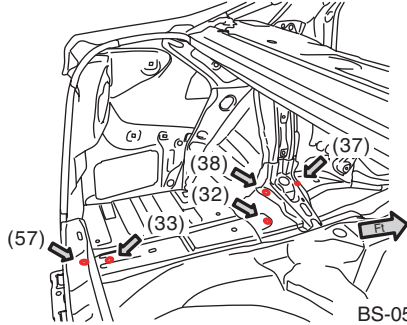
Measuring point	Datum dimension mm (in)
(15)R — (63)R	853(33.58)
(15)L — (63)L	840(33.07)
(22)R — (15)R	1,484(58.43)
(22)L — (15)L	1,473(57.99)
(23)R — (15)R	1,534(60.39)
(23)L — (15)L	1,521(59.88)
(27)R — (15)R	627(24.68)
(27)L — (15)L	618(24.33)
(43)R — (46)R	642(25.28)
(44)R — (47)R	964(37.95)
(45)R — (46)R	1,331(52.40)
(48)R — (49)R	618(24.33)
(22)L — (63)L	838(32.99)

Measuring point	Datum dimension mm (in)
(23)L — (63)L	729(28.70)
(32)R — (57)R	610(24.02)
(32)R — (57)L	920(36.22)
(32)R — (33)R	485(19.09)
(32)R — (33)L	987(38.86)
(32)L — (33)R	982(38.66)
(32)L — (33)L	495(19.49)
(33)R — (33)L	854(33.62)
(54)R — (54)L	1,147(45.16)
(54)R — (58)	595(23.43)
(55)R — (55)L	972(38.27)
(56)R — (56)L	1,146(45.12)
(56)R — (58)	585(23.03)

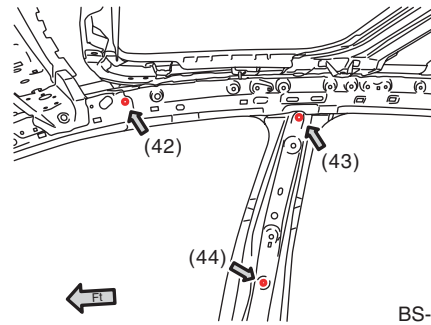
- Reference point (58) is the vehicle midpoint; reference point (15), (33) is a right-left asymmetrical point; and all other reference points are right-left symmetrical points.
- The dimensions are the actual dimensions between the reference points.



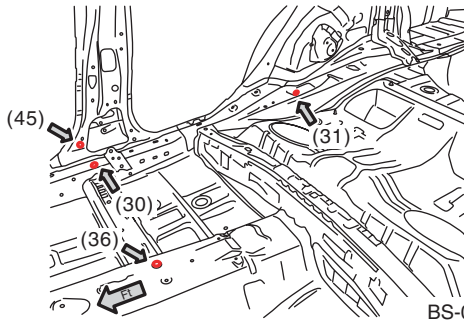
Body Reference Points



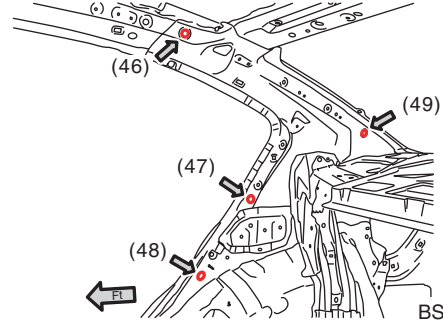
BS-05963



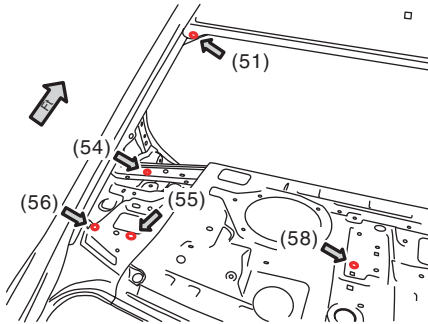
BS-05970



BS-05971



BS-05972

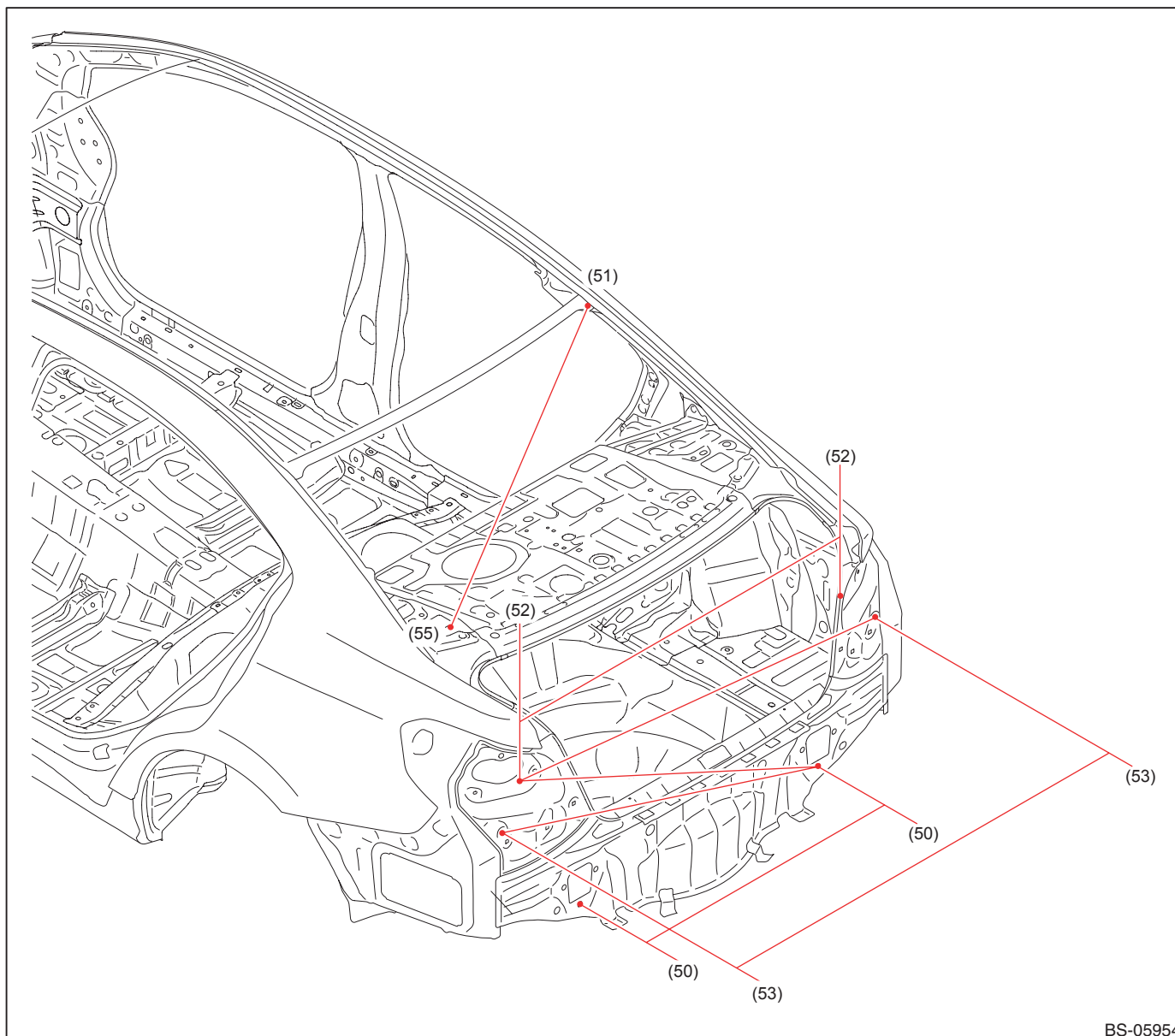


BS-05964

SUBARU.

Body Reference Points

7. REAR



BS-05954

(50) Bumper beam mounting hole
(symmetrical)

(52) Rear combination light mounting
hole (symmetrical)

(55) Rear shelf mounting hole
(symmetrical)

(51) Rear glass installation reference
hole (symmetrical)

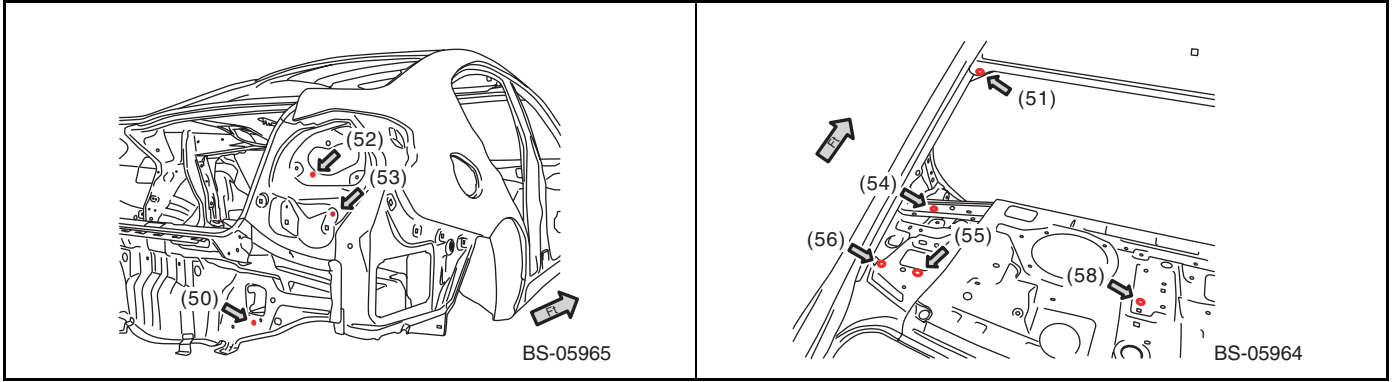
(53) Rear bumper mounting hole
(symmetrical)

Measuring point	Datum dimension mm (in)
(50)R — (50)L	854(33.62)
(50)R — (52)L	1,088(42.83)
(50)R — (53)L	1,142(44.96)
(51)R — (55)L	1,155(45.47)

Measuring point	Datum dimension mm (in)
(52)R — (52)L	1,148(45.20)
(52)L — (53)R	1,246(49.06)
(53)R — (53)L	1,335(52.56)

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

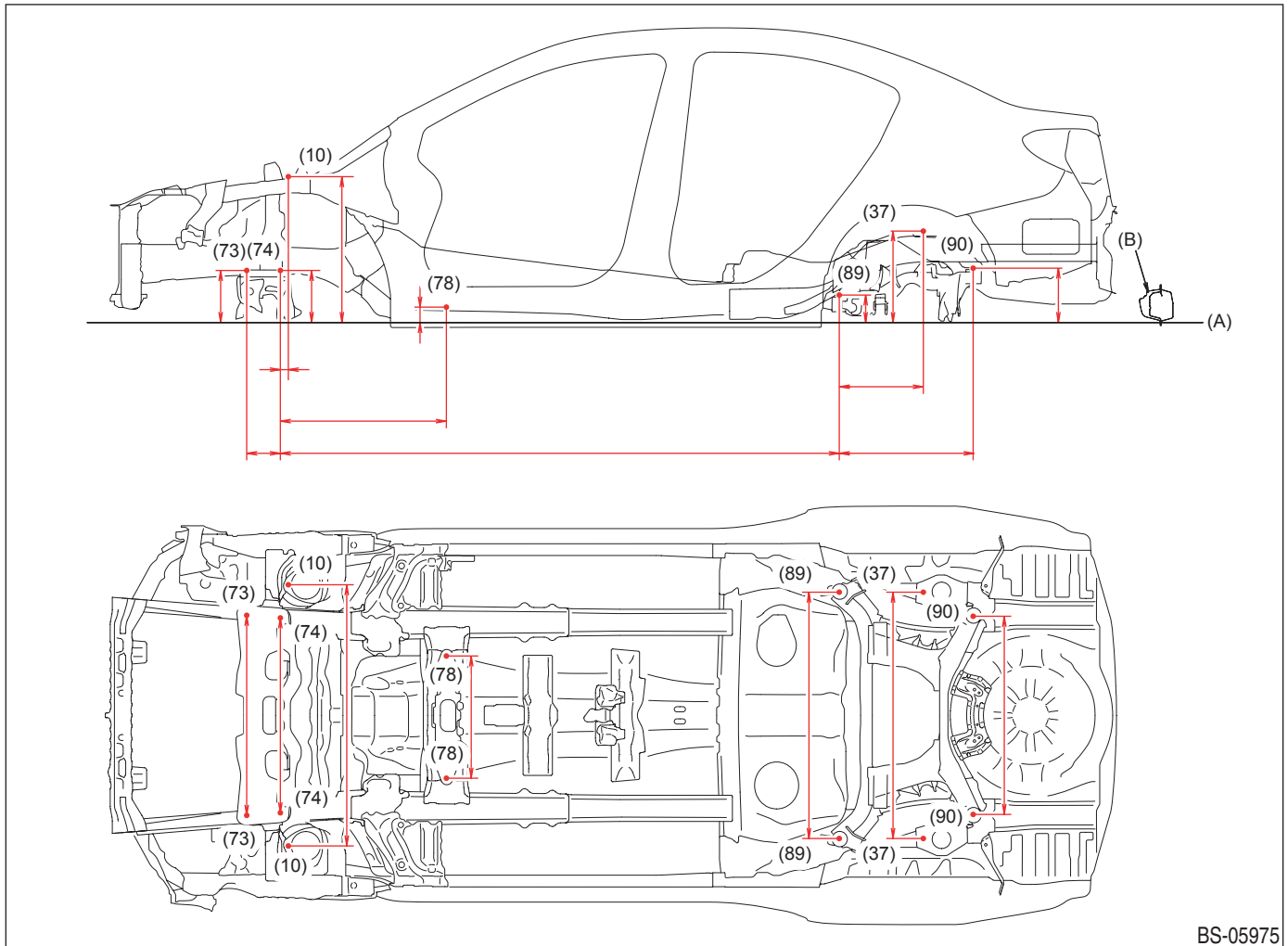
Body Reference Points



6. Measurement for combined parts

A: DIMENSIONS

1. SUSPENSION MOUNT & ENGINE MOUNT



BS-05975

- 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

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

(73) Front cross member mounting hole (symmetrical), front

(89) Rear suspension cross member mounting hole (symmetrical)

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

(74) Front cross member mounting hole (symmetrical), rear

(90) Rear suspension cross member mounting hole (symmetrical)

Measurement for combined parts

Measuring point	Datum dimension mm (in)
Datum line — (10)	628(24.72)
Datum line — (37)	392(15.43)
Datum line — (73)	223(8.78)
Datum line — (74)	223(8.78)
Datum line — (78)aR	66(2.60)
Datum line — (78)aL	60(2.36)
Datum line — (78)bR	66(2.60)
Datum line — (78)bL	60(2.36)
Datum line — (89)	118(4.65)
Datum line — (90)	233(9.17)
(10)R — (74)R	31(1.22)
(37)R — (89)R	372(14.65)
(73)R — (74)R	144(5.67)

Measuring point	Datum dimension mm (in)
(74)R — (78)aR	711(27.99)
(74)R — (78)bR	811(31.93)
(74)R — (89)R	2,392(94.17)
(89)R — (90)R	573(22.56)
(10)R — (10)L	1,103(43.43)
(37)R — (37)L	1,059(41.69)
(73)R — (73)L	862(33.94)
(74)R — (74)L	840(33.07)
(78)aR — (78)aL	376(14.80)
(78)bR — (78)bL	361(14.21)
(89)R — (89)L	1,060(41.73)
(90)R — (90)L	854(33.62)

CAUTION:

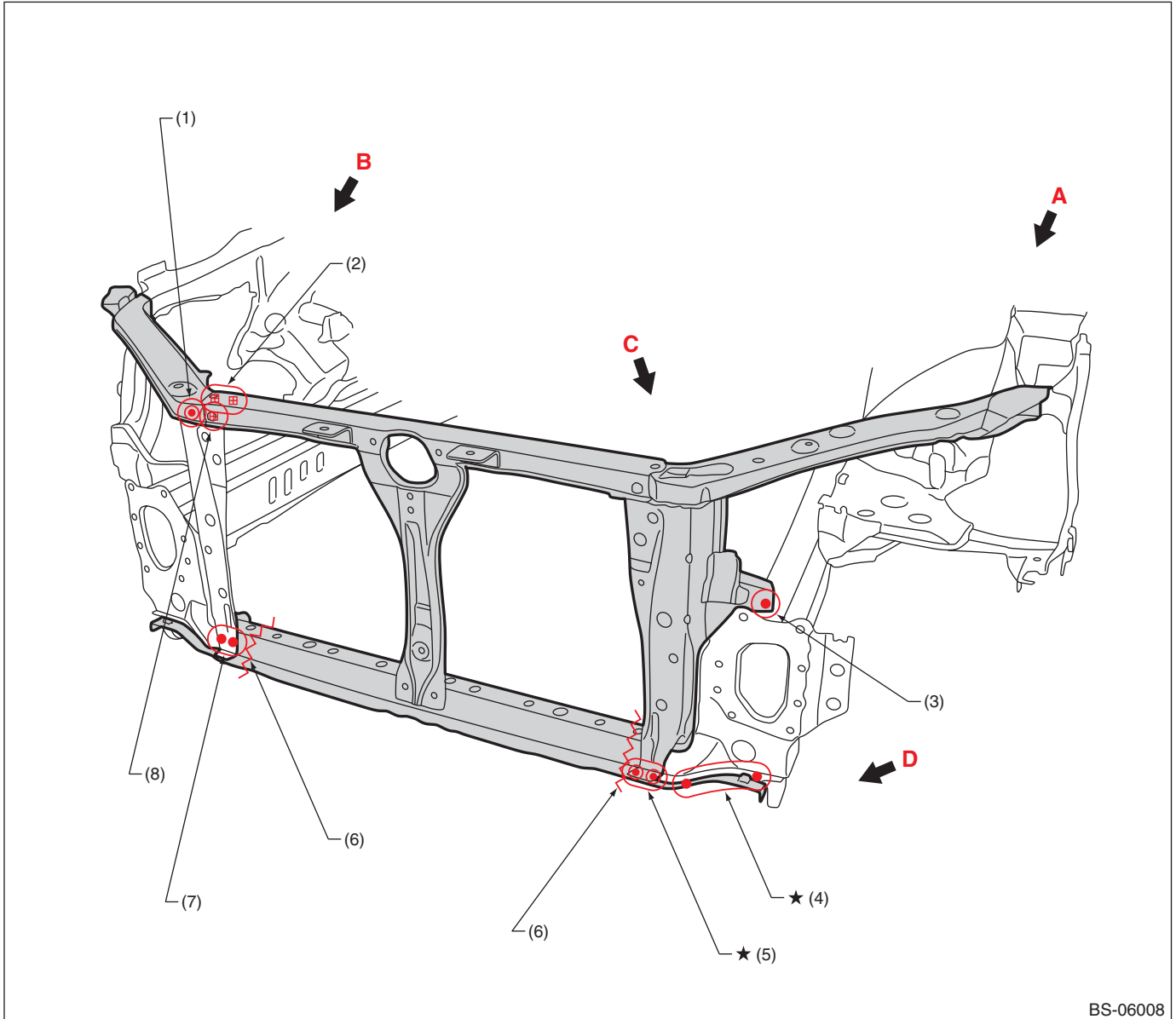
- For the reference points (10), refer to the figure "FRONT 1, DIMENSIONS, Body Reference Points" on page 28.
- For the reference points (37), refer to the figure "INSIDE COMMON PARTS 2, DIMENSIONS, Body Reference Points" on page 34.
- Except the reference points (10) and (37), refer to the figure "LOWER SURFACE, DIMENSIONS, Body Reference Points" on page 25.

7. Panel Replacement

7-1. Radiator Panel (total replacement)

A: REMOVAL

• Overall view



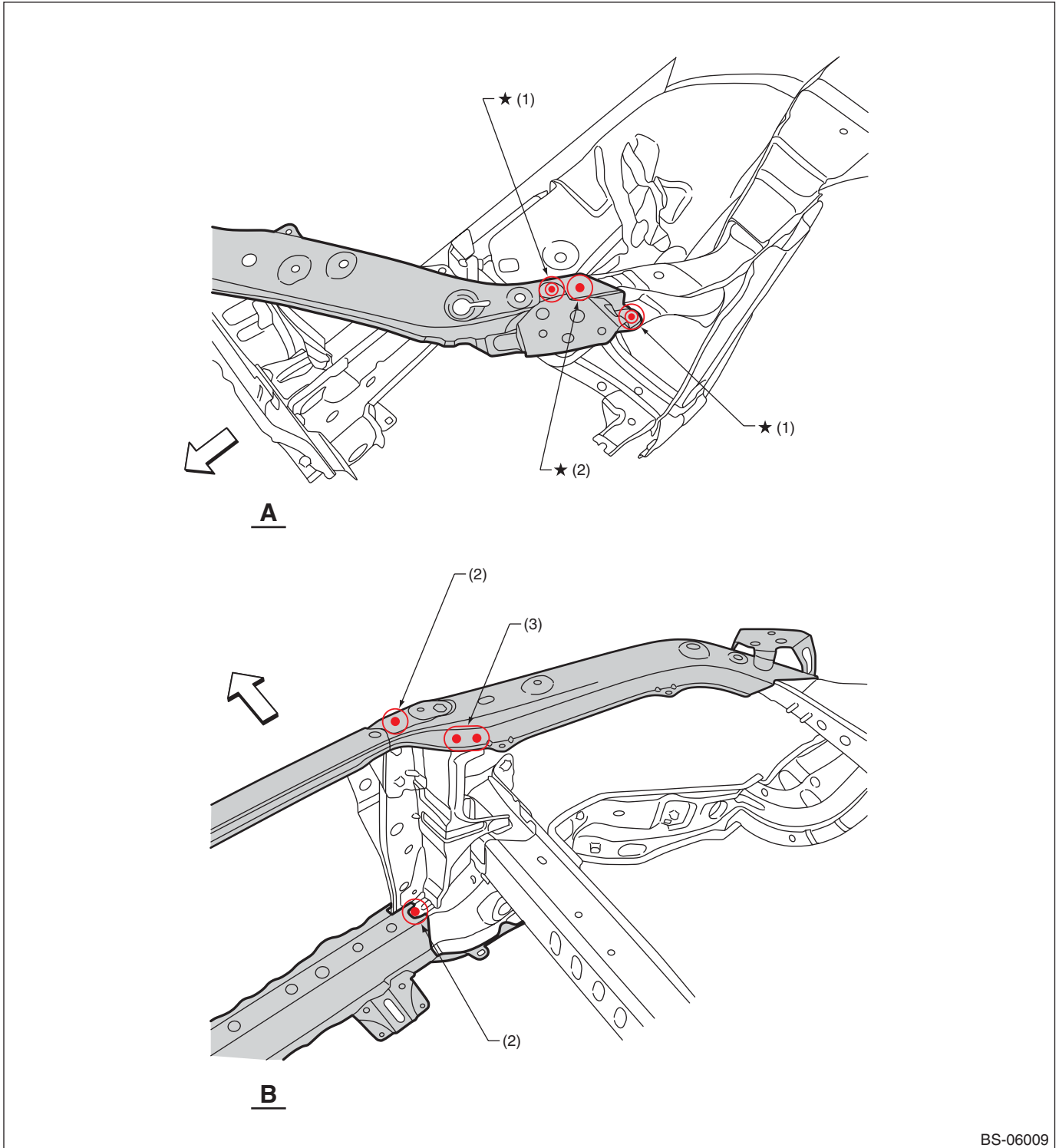
BS-06008

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

• Views 1



BS-06009

(1) 1 point (top · 2)

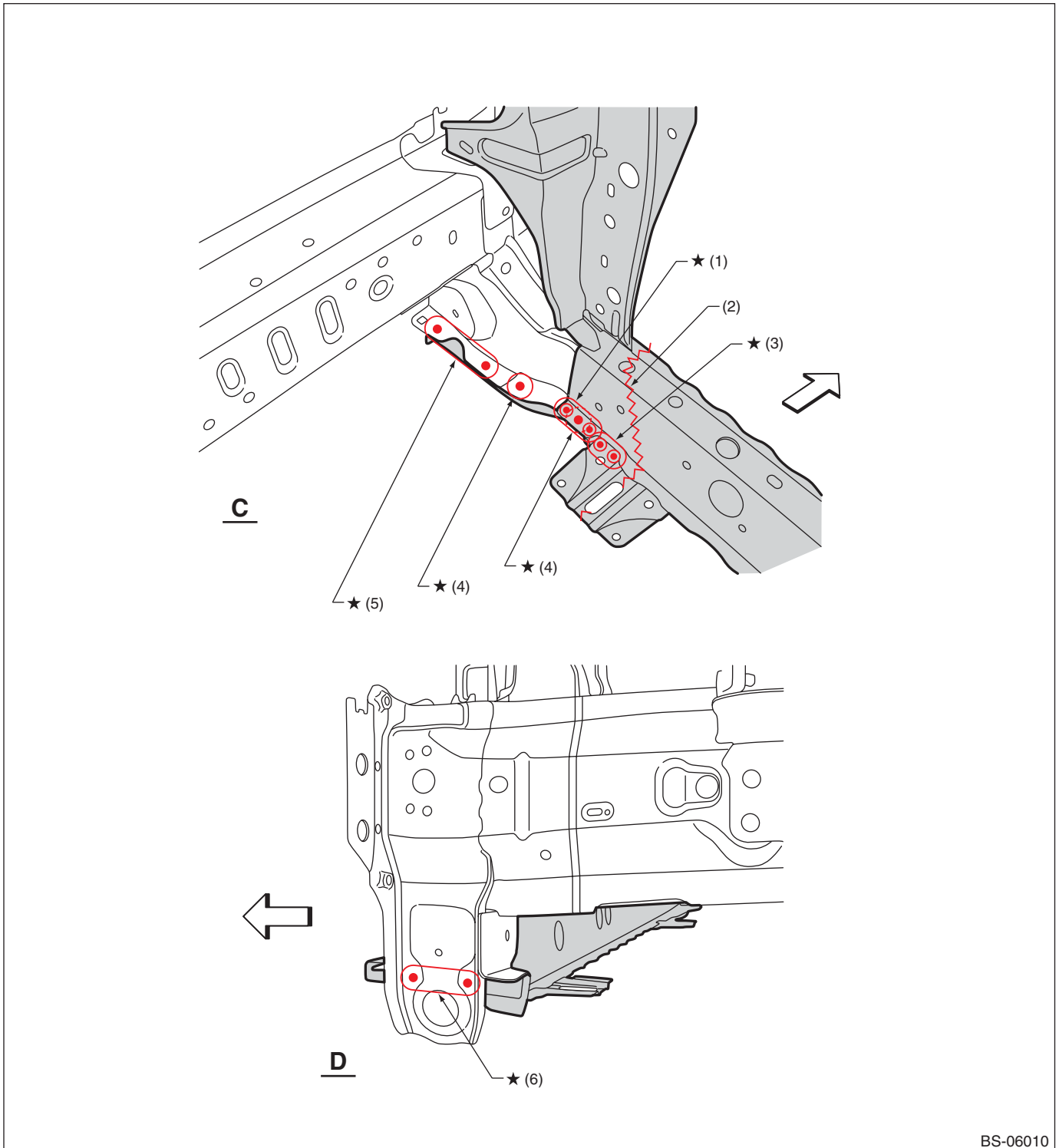
(2) 1 point (top · 1)

(3) 2 points (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

• Views 2



BS-06010

(1) 3 points (top · 1, bottom · 1)

(2) Rough cutting

(3) 2 points (top · 1, bottom · 1)

(4) 1 point (bottom · 1)

(5) 2 points (bottom · 1)

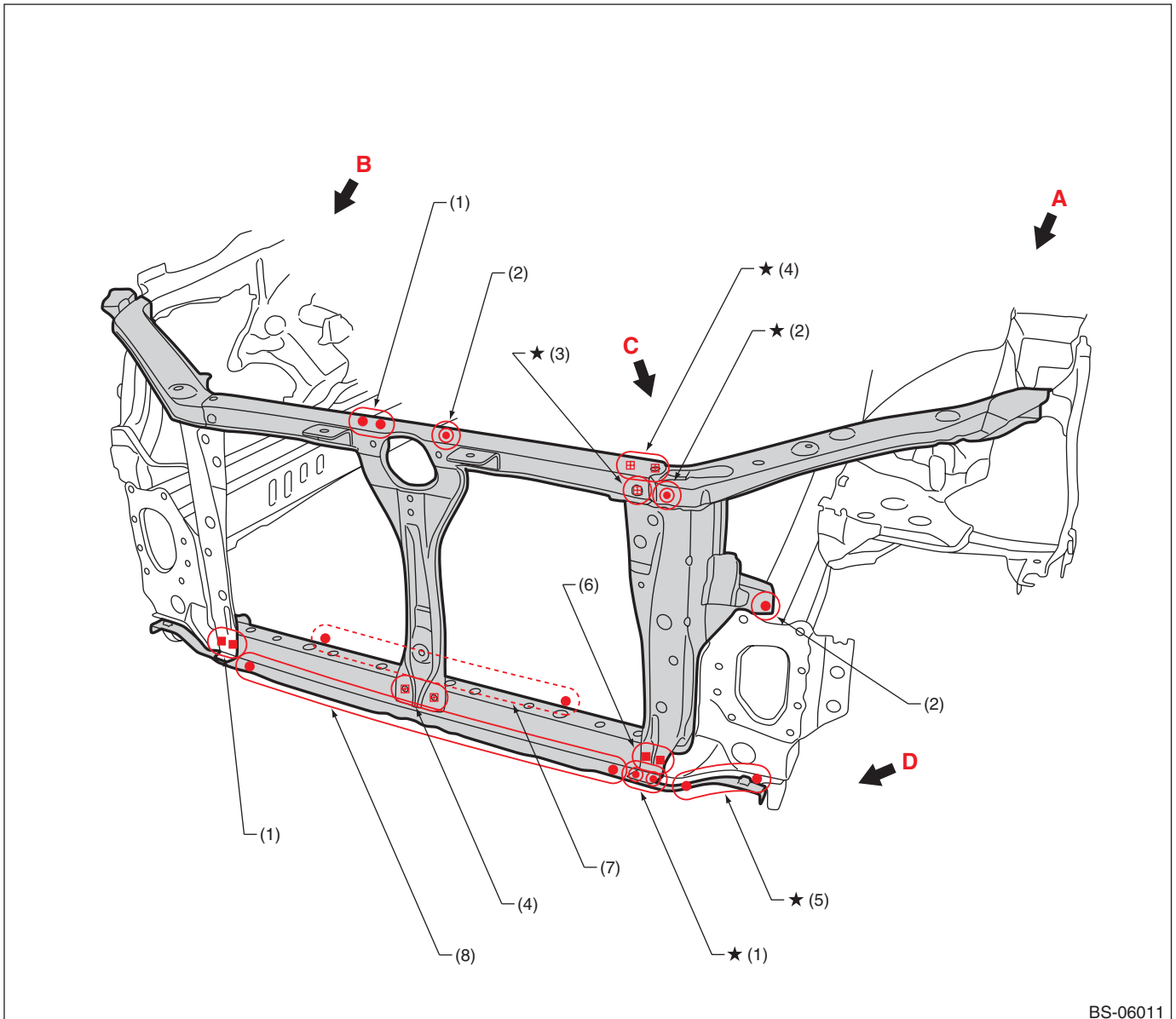
(6) 2 points (inside · 1 belt sander)

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

Panel Replacement

B: INSTALLATION

• Overall view

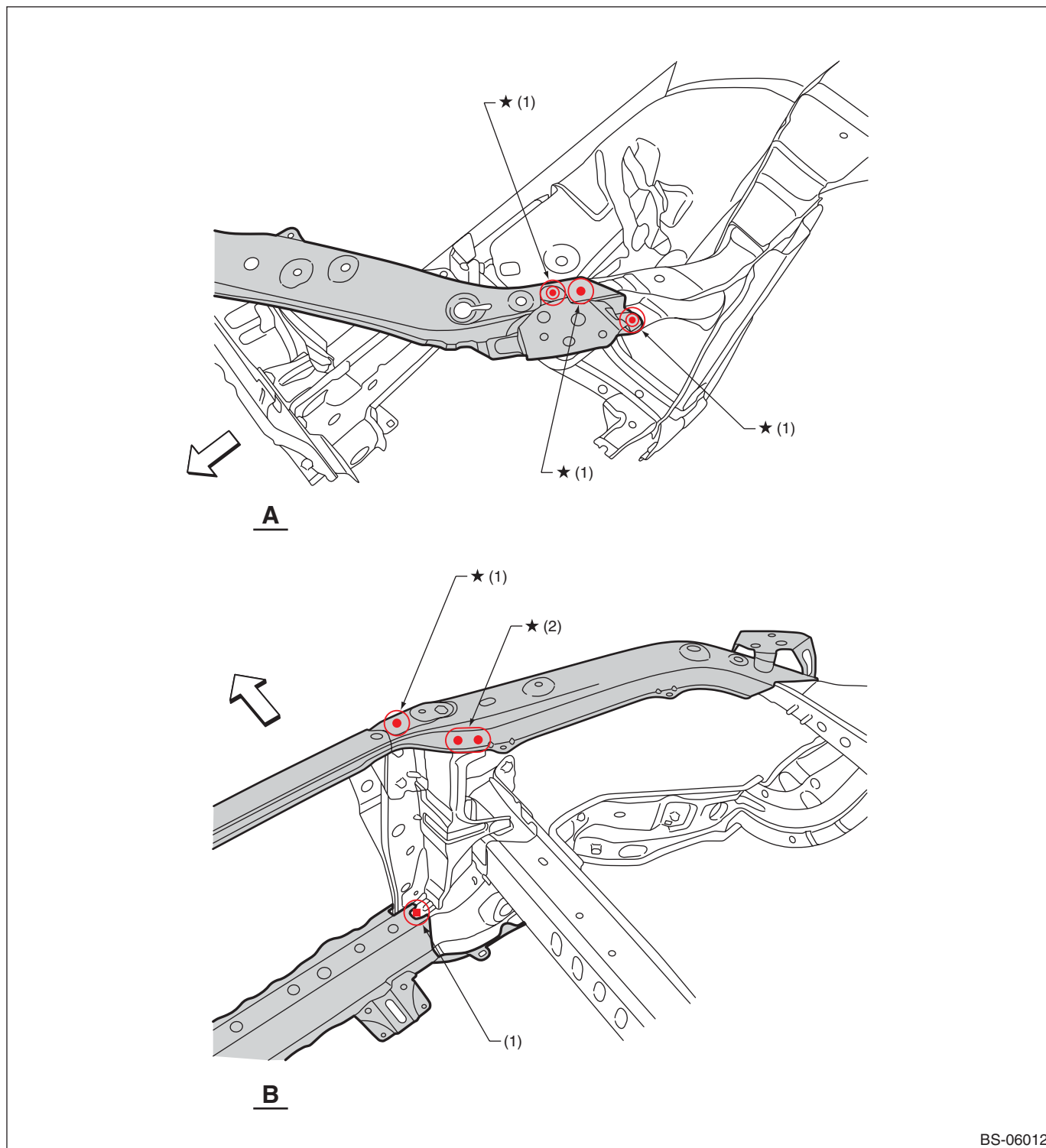


- | | | |
|--------------------|------------------------|---------------|
| (1) 2 points | (4) 2 points (bolt) | (7) 9 points |
| (2) 1 point | (5) 3 points | (8) 17 points |
| (3) 1 point (bolt) | (6) 2 points (service) | |

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

Panel Replacement

• Views 1



BS-06012

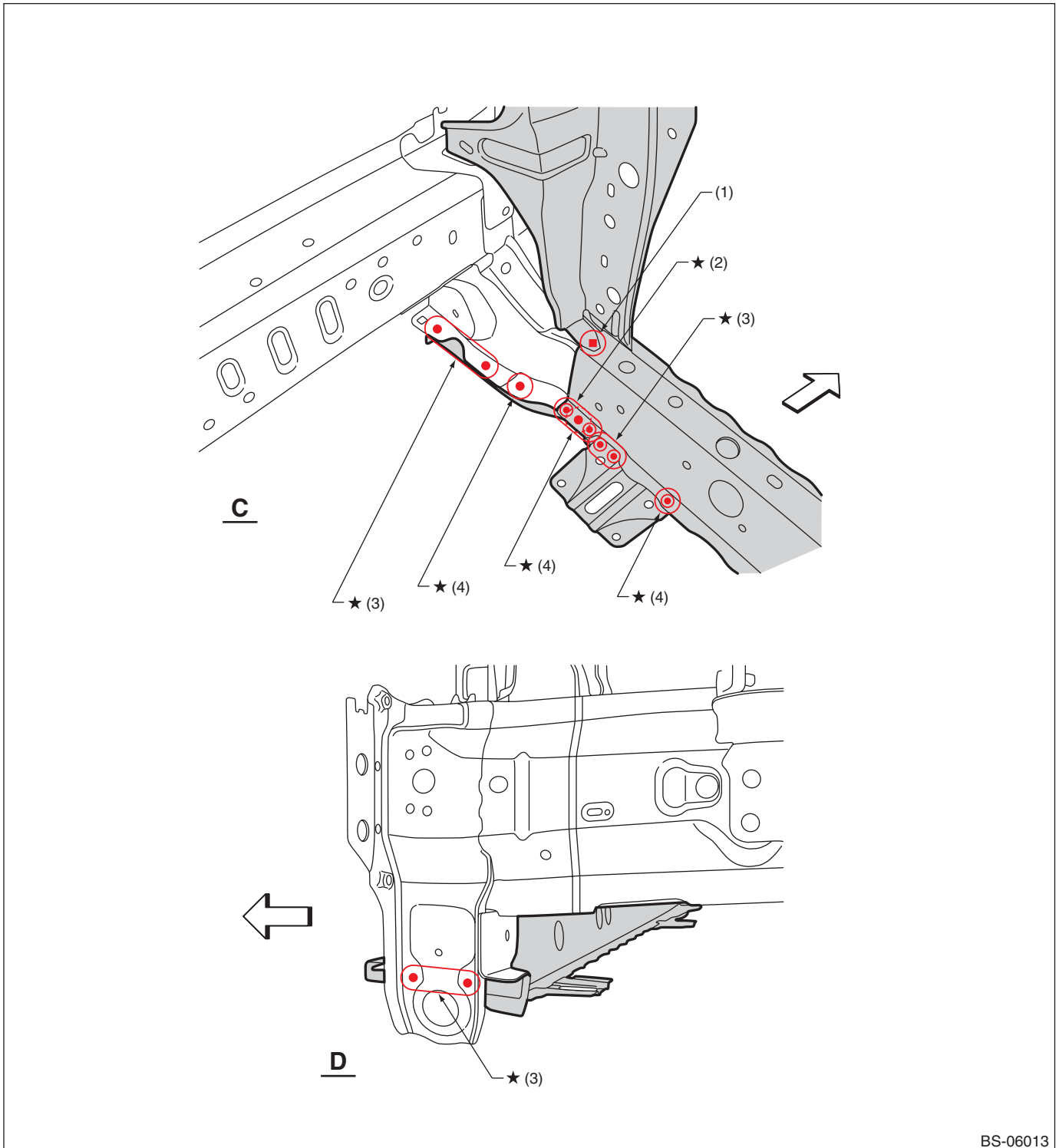
(1) 1 point

(2) 2 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-06013

(1) 1 point (service)

(2) 3 points

(3) 2 points

(4) 1 point

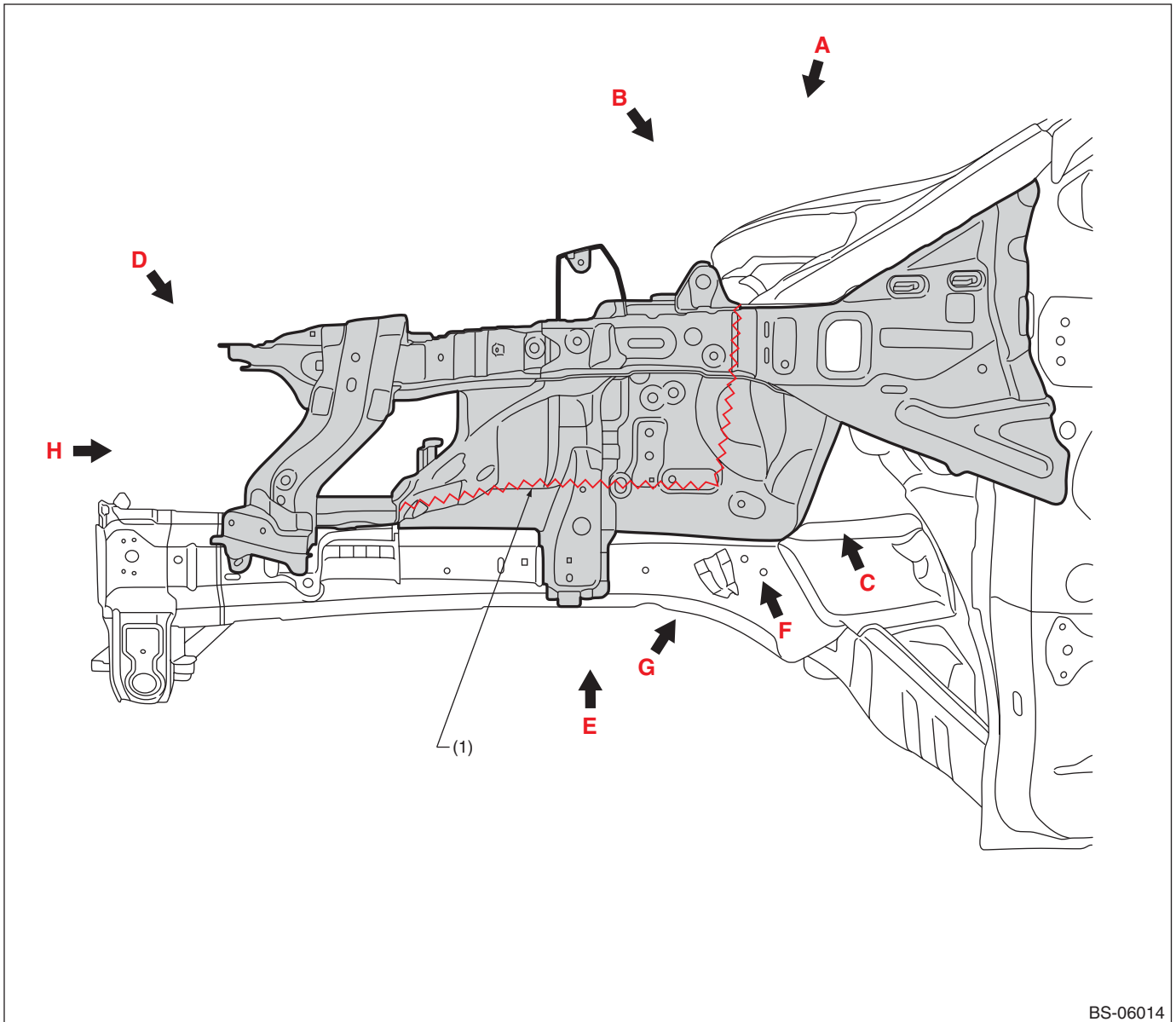
For locations marked by “★”: the welding method and the number of welding points are the same on the left and the right.

Panel Replacement

7-2. Front Wheel Apron (total replacement)

A: REMOVAL

- Overall view (Radiator panel removal condition)

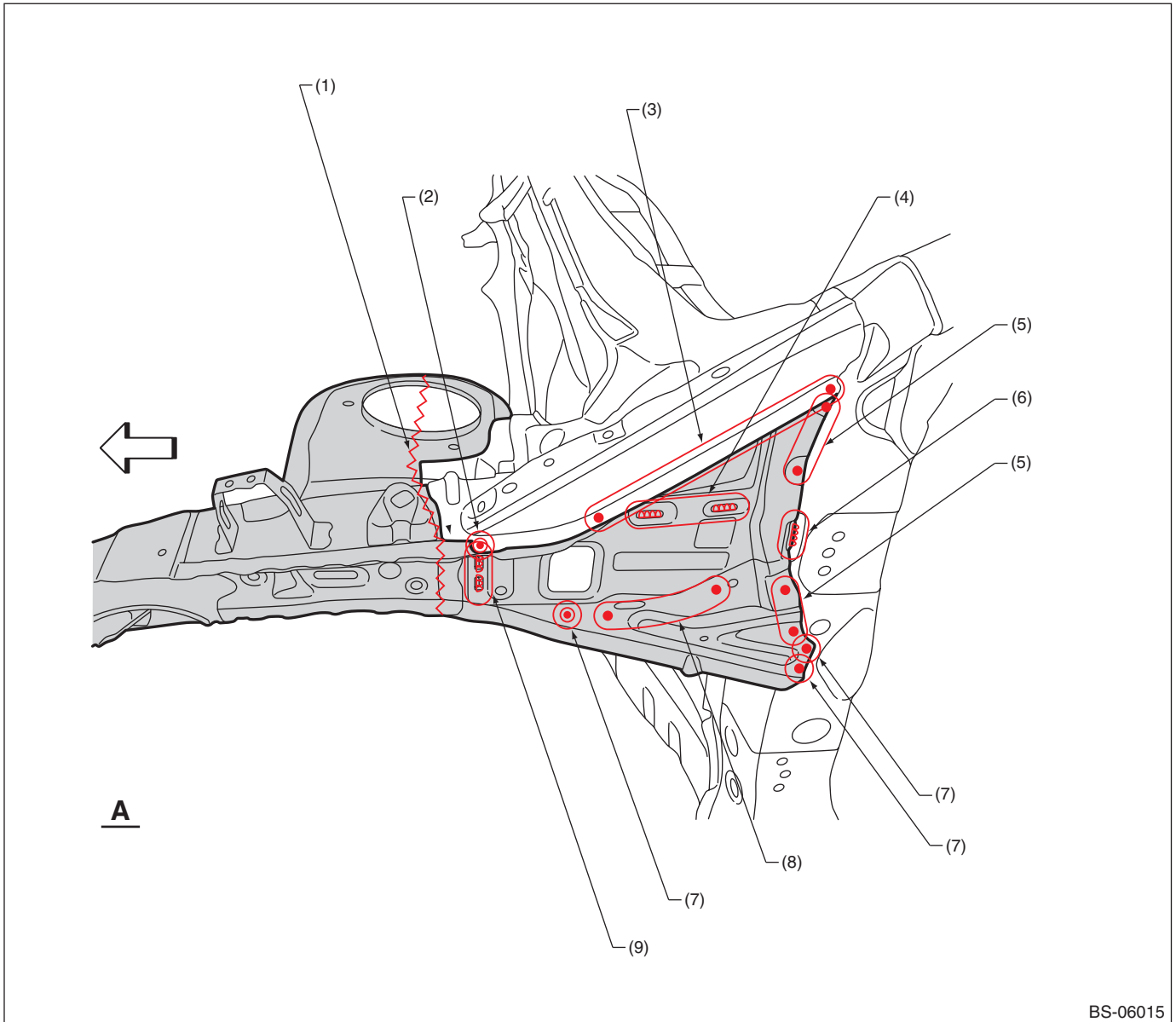


BS-06014

(1) Rough cutting

Panel Replacement

• Views 1

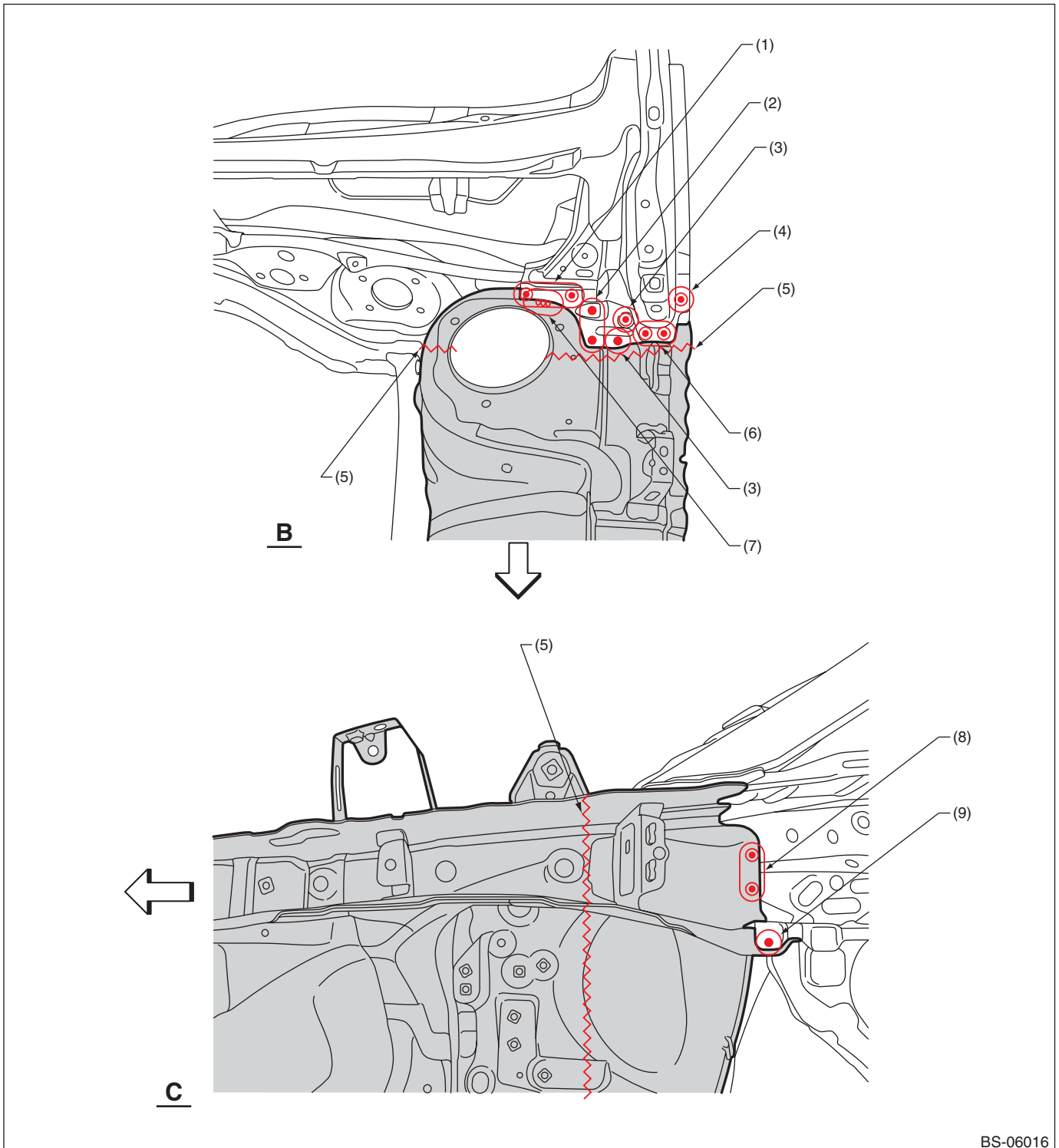


BS-06015

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

Panel Replacement

• Views 2

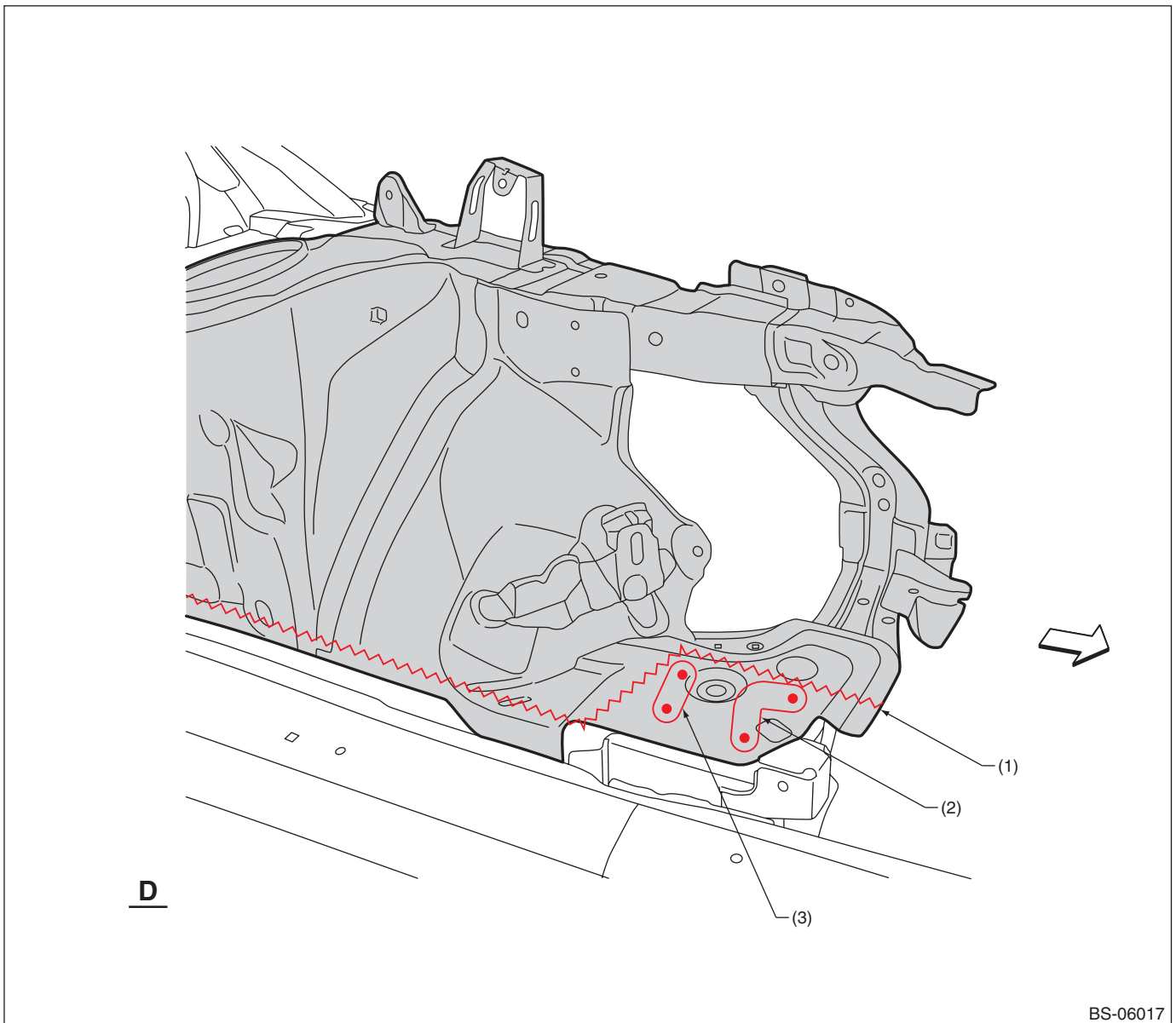


BS-06016

- | | | |
|--|---|---------------------------|
| (1) 2 points (top · 1) (only LH)
3 points (top · 1) (only RH) | (5) Rough cutting | (9) 1 point (outside · 1) |
| (2) 3 points (top · 1) | (6) 2 points (top · 2) | |
| (3) 1 point (top · 1) | (7) 1 point (top · 1, belt sander)
(only LH) | |
| (4) 1 point (top · 2) | (8) 2 points (outside · 2) | |

Panel Replacement

• Views 3



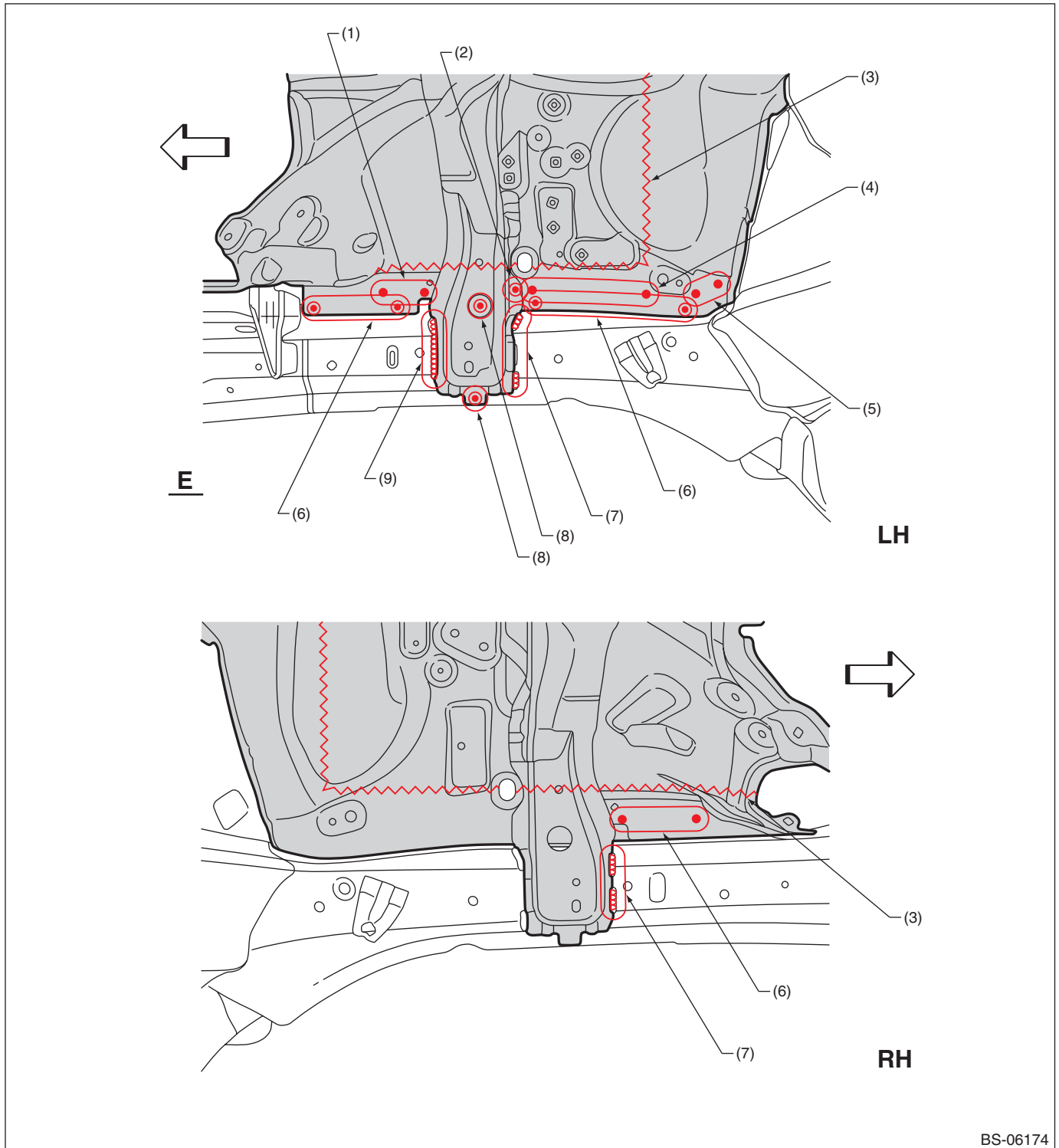
(1) Rough cutting

(2) 3 points (top · 1)

(3) 2 points (top · 1)

Panel Replacement

• Views 4

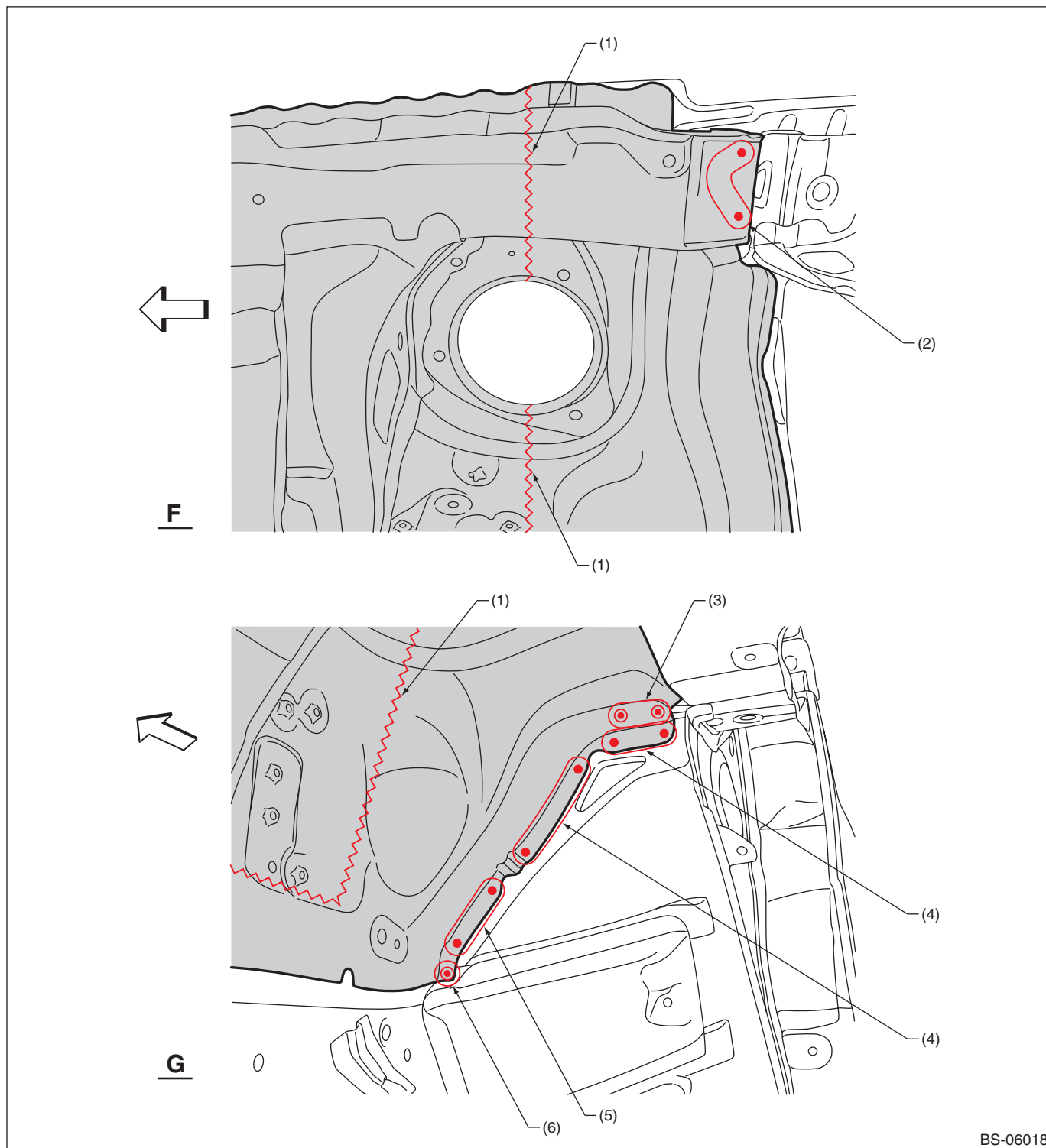


- | | | |
|----------------------------|----------------------------|---|
| (1) 3 points (outside · 1) | (4) 6 points (outside · 1) | (7) 2 points (outside · 1, belt sander) |
| (2) 1 point (outside · 2) | (5) 2 points (outside · 1) | (8) 1 point (outside · 1) |
| (3) Rough cutting | (6) 4 points (outside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

Note: Designations in the RH diagram are the same as in the LH diagram, except for the indicated points.

Panel Replacement

• Views 5



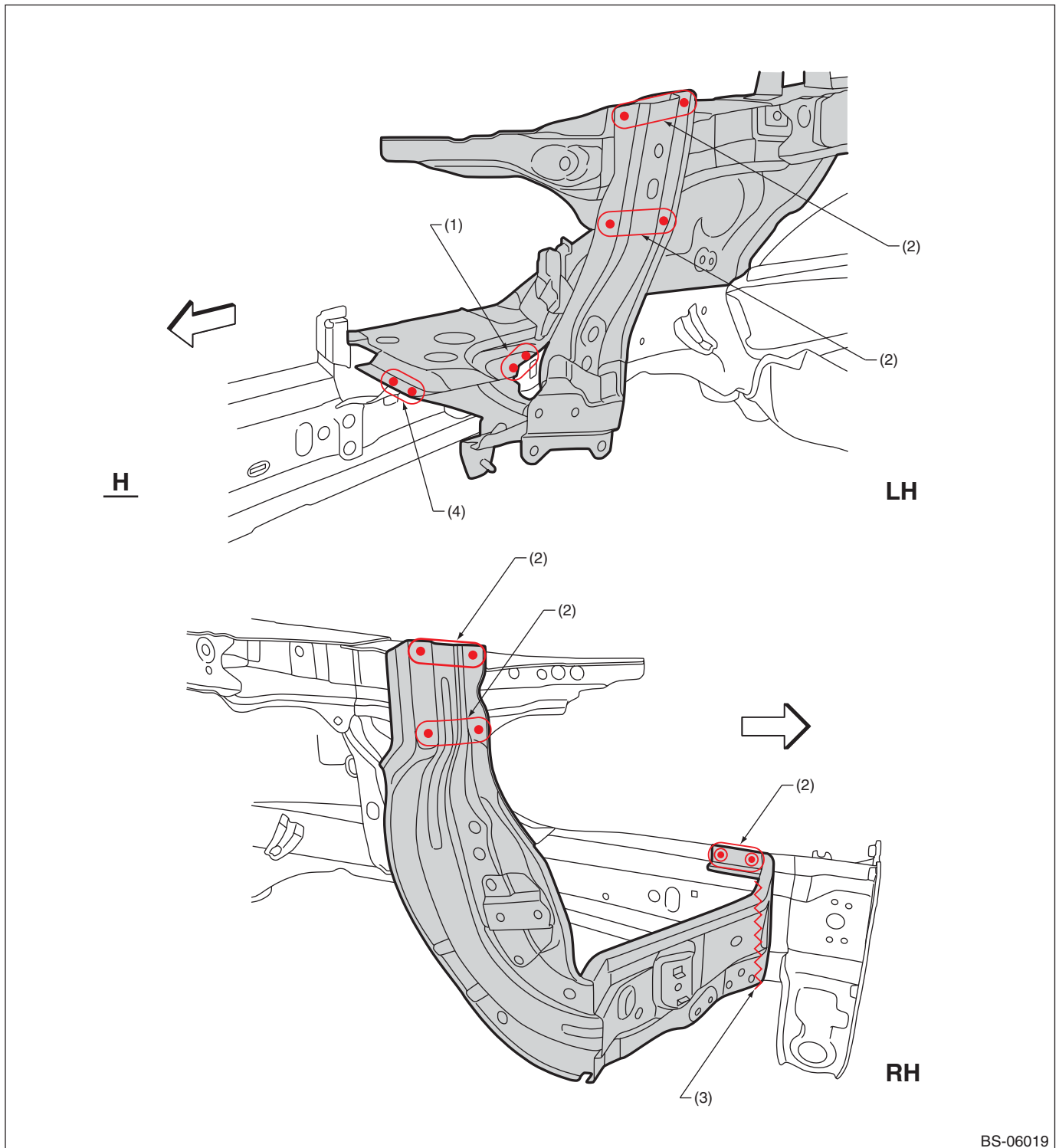
(1) Rough cutting
(2) 4 points (bottom · 1)

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

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

Panel Replacement

• Views 6



BS-06019

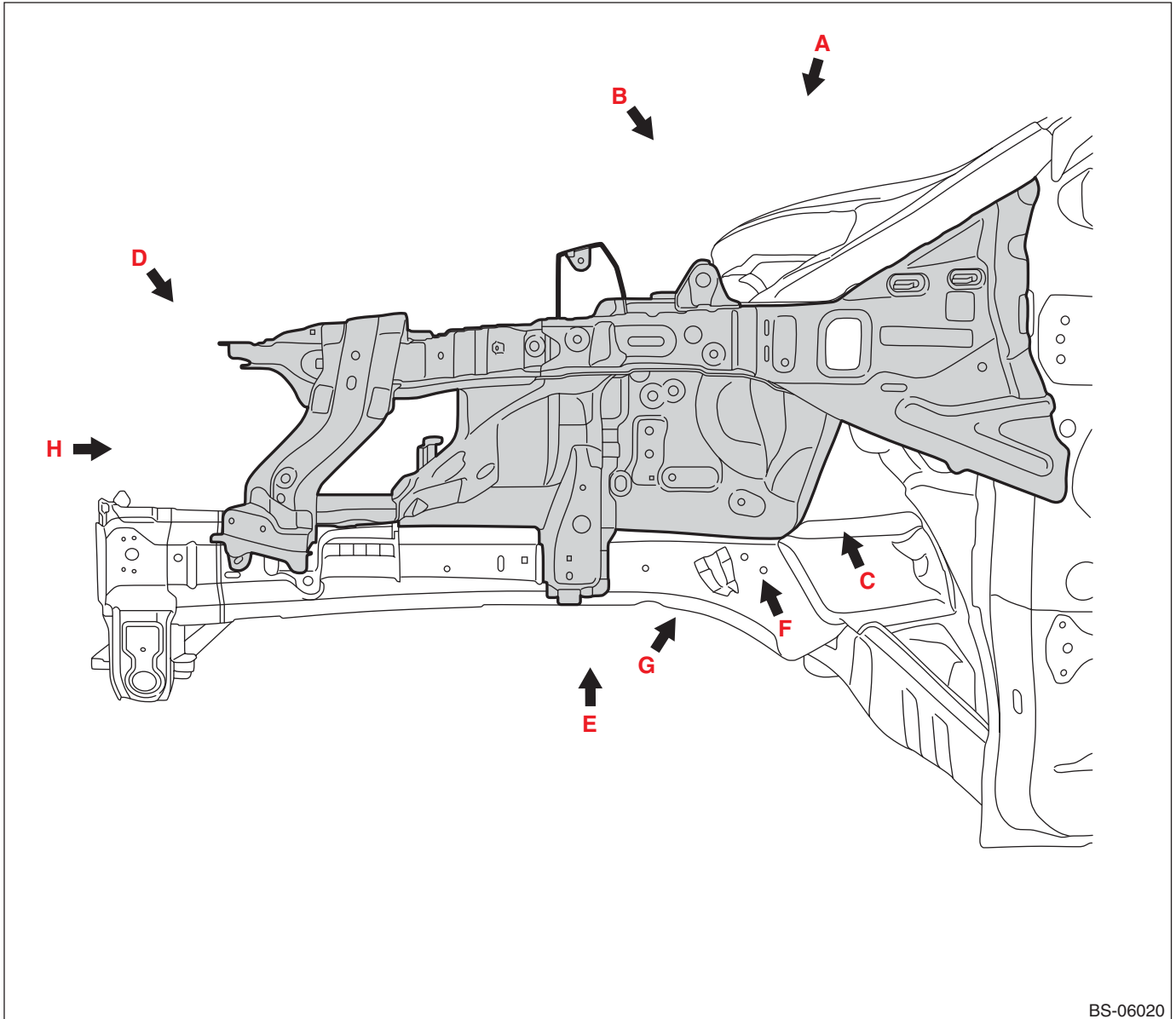
- (1) 2 points (bottom · 1)
- (2) 2 points (outside · 1)

- (3) Rough cutting

- (4) 3 points (bottom · 1)

B: INSTALLATION

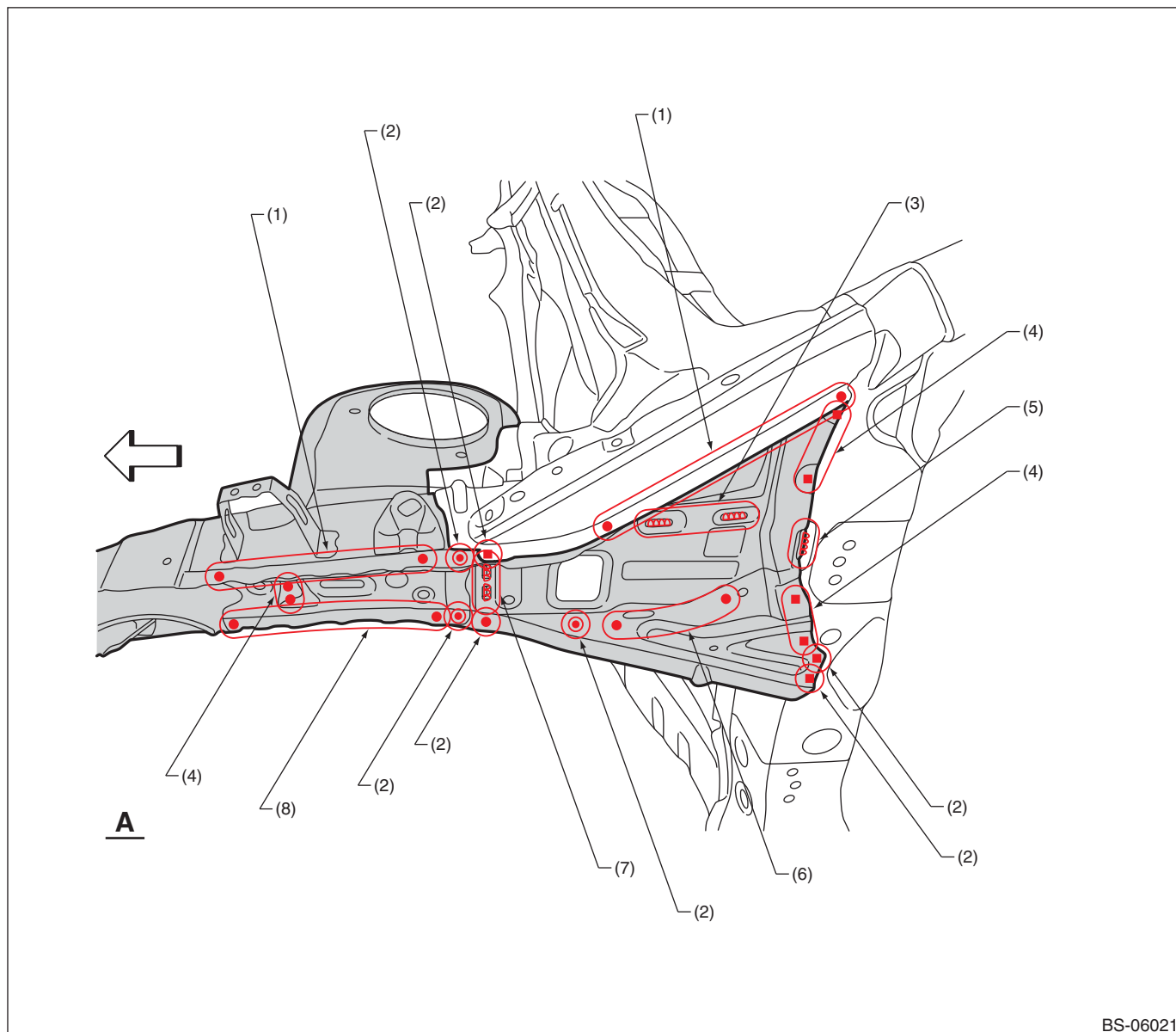
• Overall view



BS-06020

Panel Replacement

• Views 1

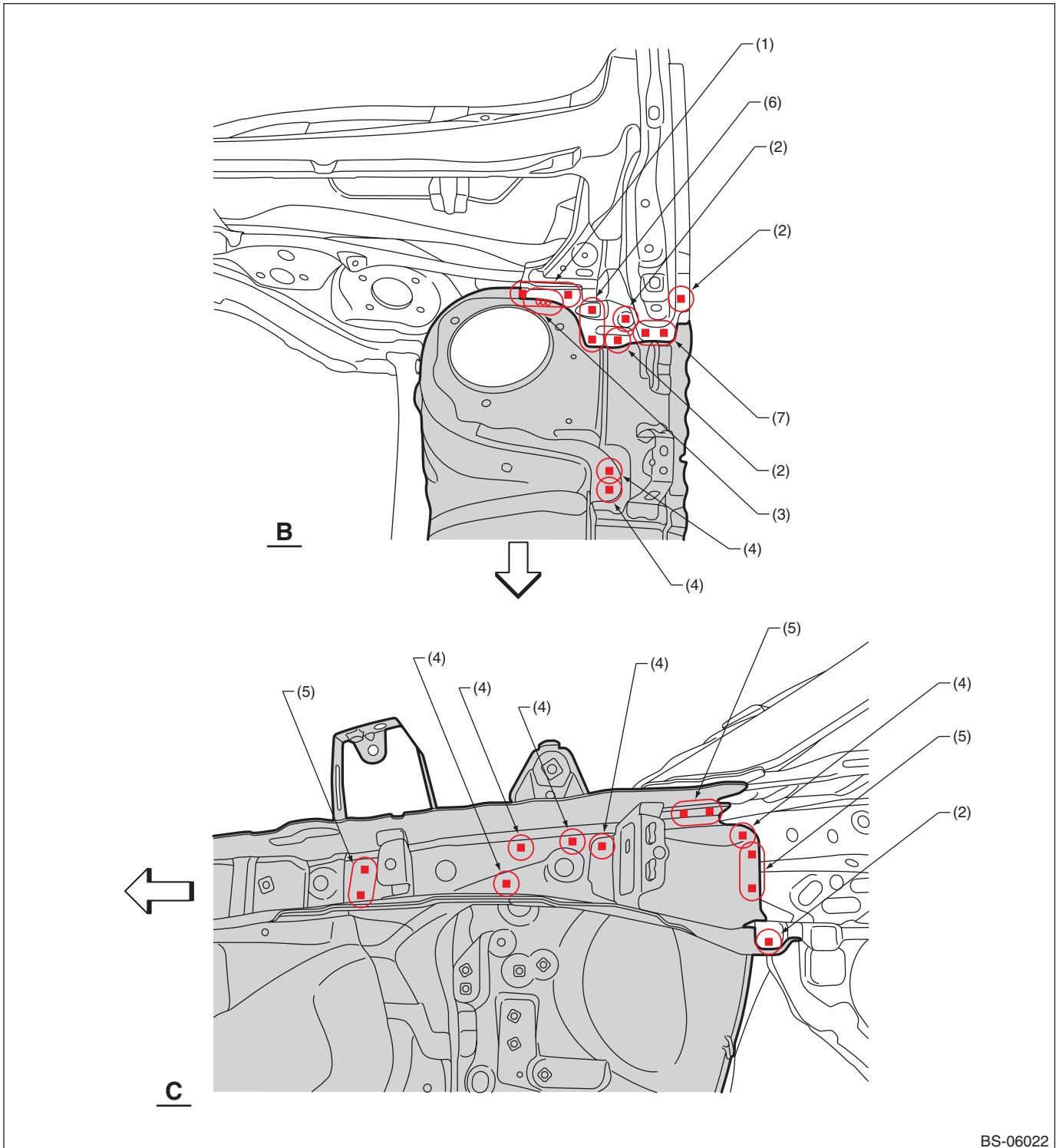


BS-06021

- | | | |
|--------------------------------|-------------------------------|--------------------------------|
| (1) 7 points | (4) 2 points | (7) 2 points [15 mm (0.59 in)] |
| (2) 1 point | (5) 1 point [35 mm (1.38 in)] | (8) 6 points |
| (3) 2 points [20 mm (0.79 in)] | (6) 3 points | |

Panel Replacement

• Views 2



BS-06022

(1) 2 points (only LH)
3 points (only RH)

(2) 1 point

(3) 1 point [20 mm (0.79 in)] (only LH)

(4) 1 point (service)

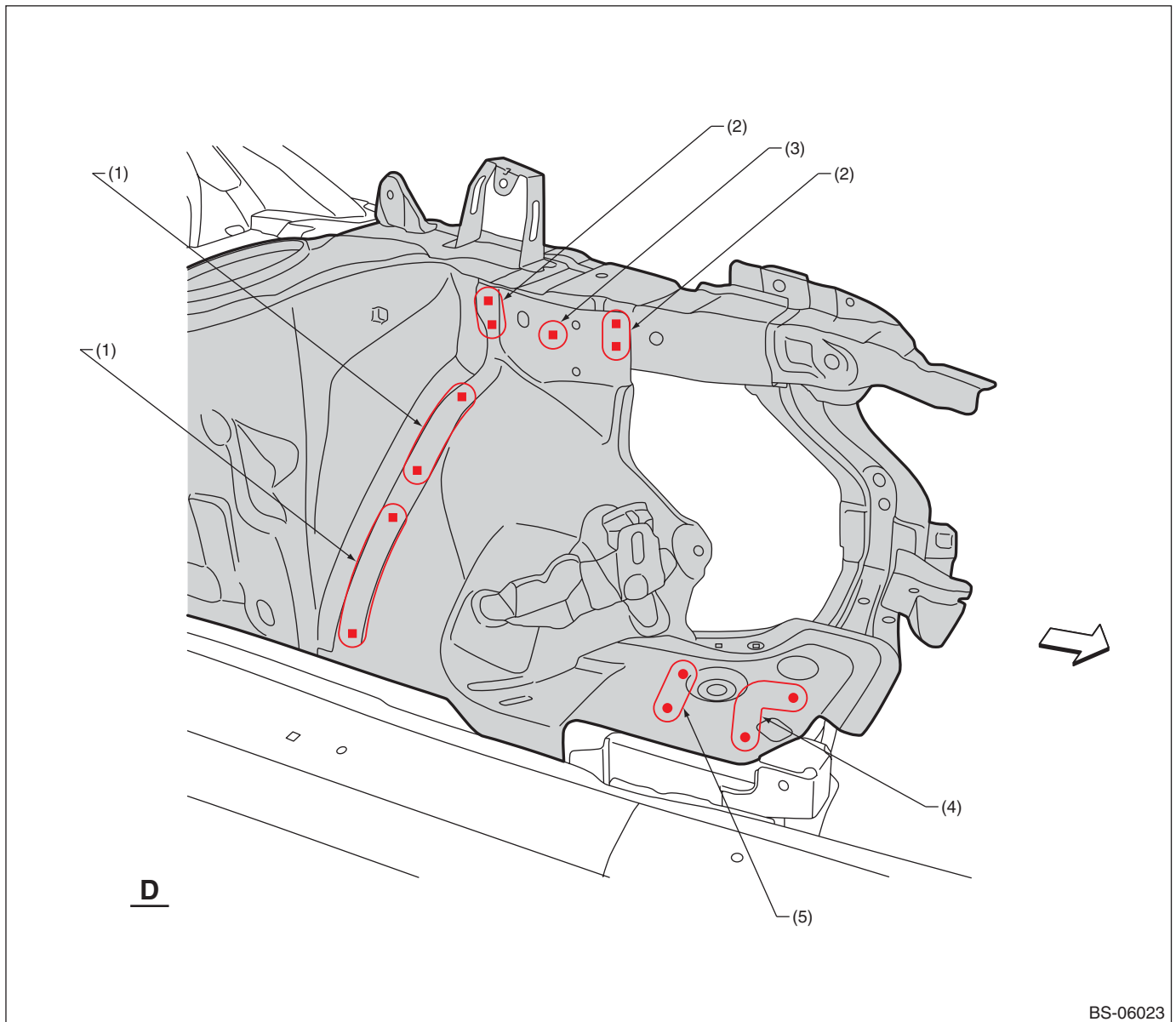
(5) 2 points (service)

(6) 3 points

(7) 2 points

Panel Replacement

• Views 3



(1) 4 points (service)

(2) 2 points (service)

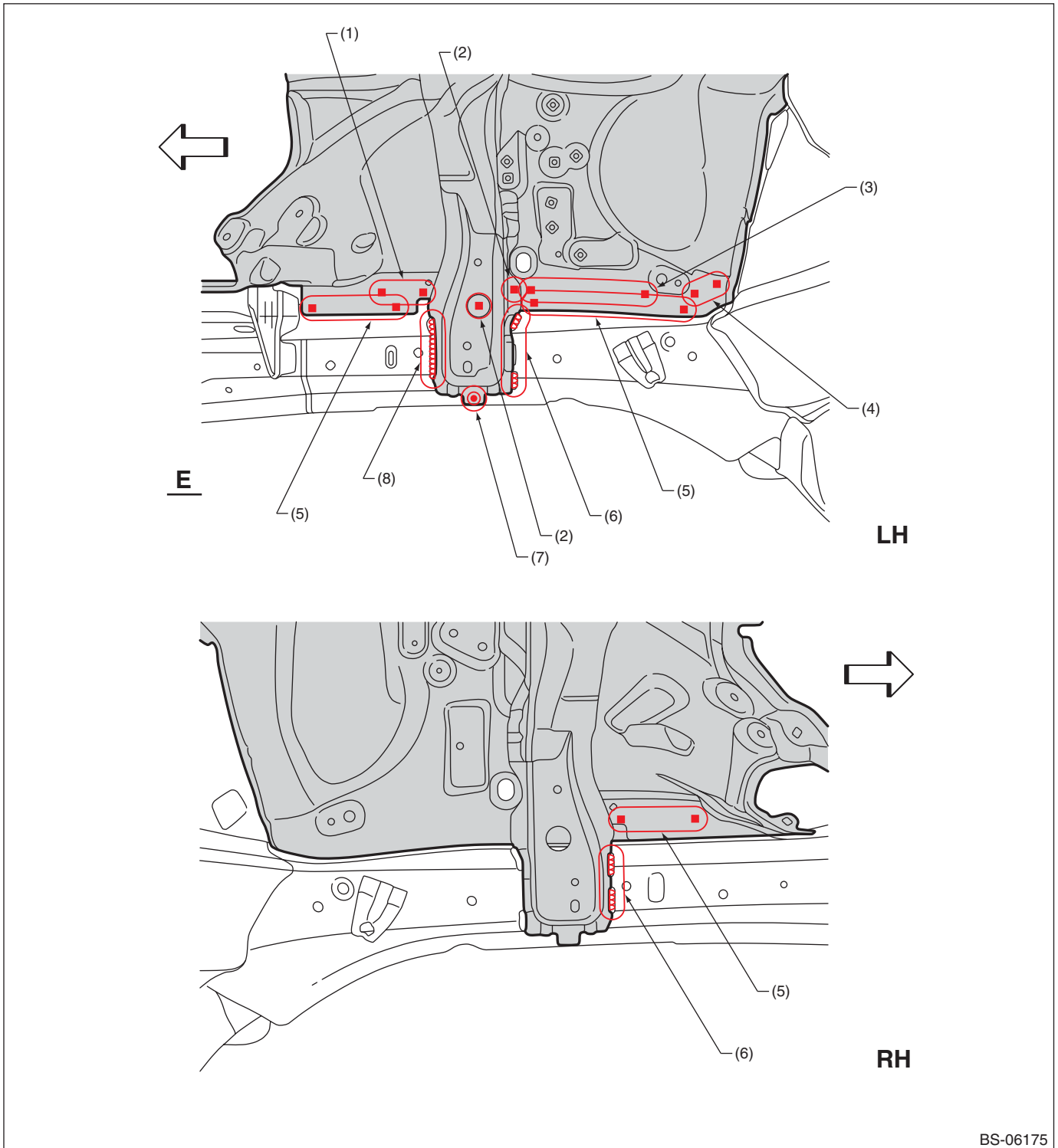
(3) 1 point (service)

(4) 3 points

(5) 2 points

Panel Replacement

• Views 4

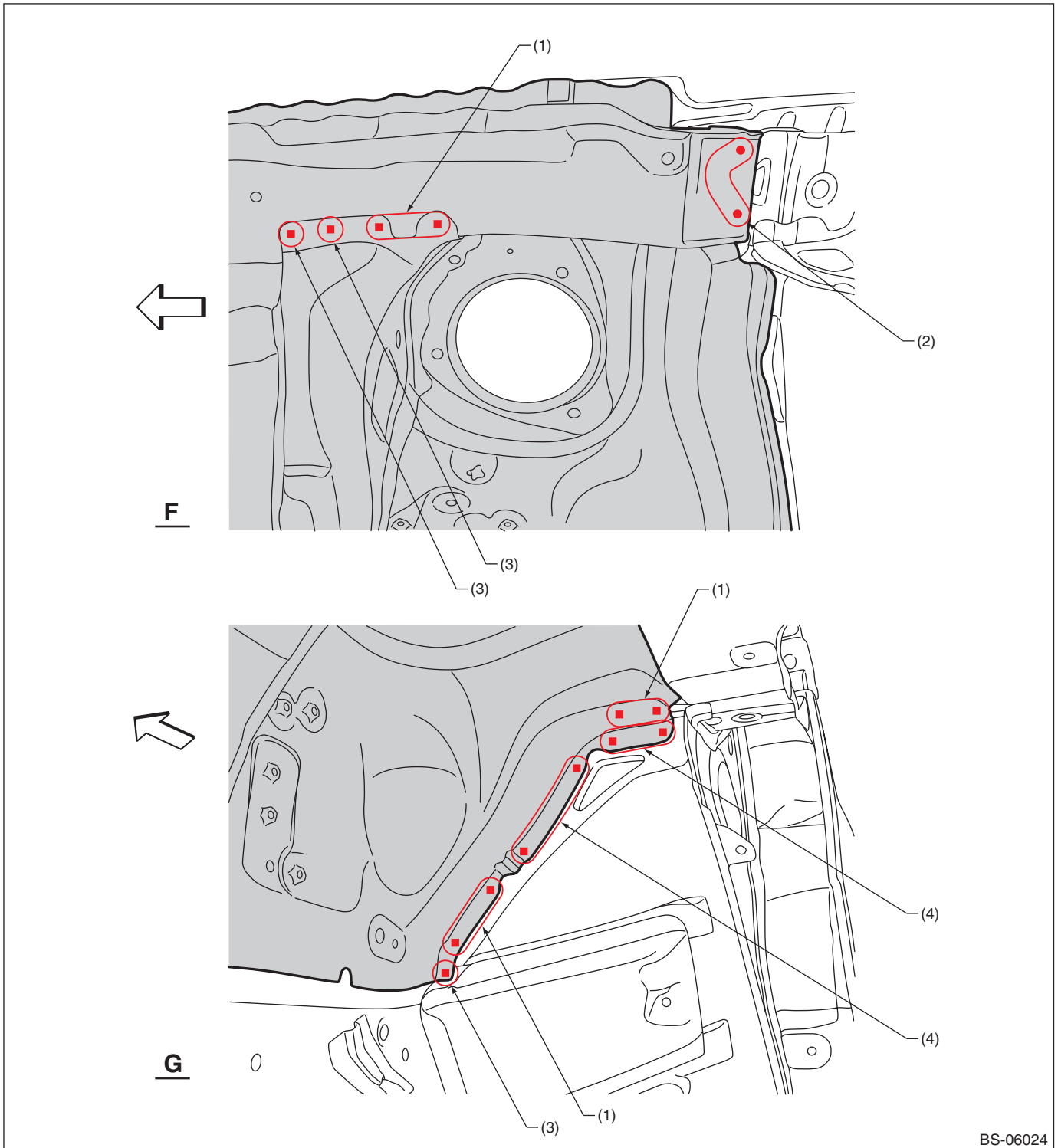


- | | | |
|------------------------|--------------------------------|-------------------------------|
| (1) 3 points (service) | (4) 2 points (service) | (7) 1 point |
| (2) 1 point (service) | (5) 4 points (service) | (8) 1 point [80 mm (3.15 in)] |
| (3) 6 points (service) | (6) 2 points [25 mm (0.98 in)] | |

Note: Designations in the RH diagram are the same as in the LH diagram, except for the indicated points.

Panel Replacement

• Views 5



BS-06024

(1) 2 points (service)

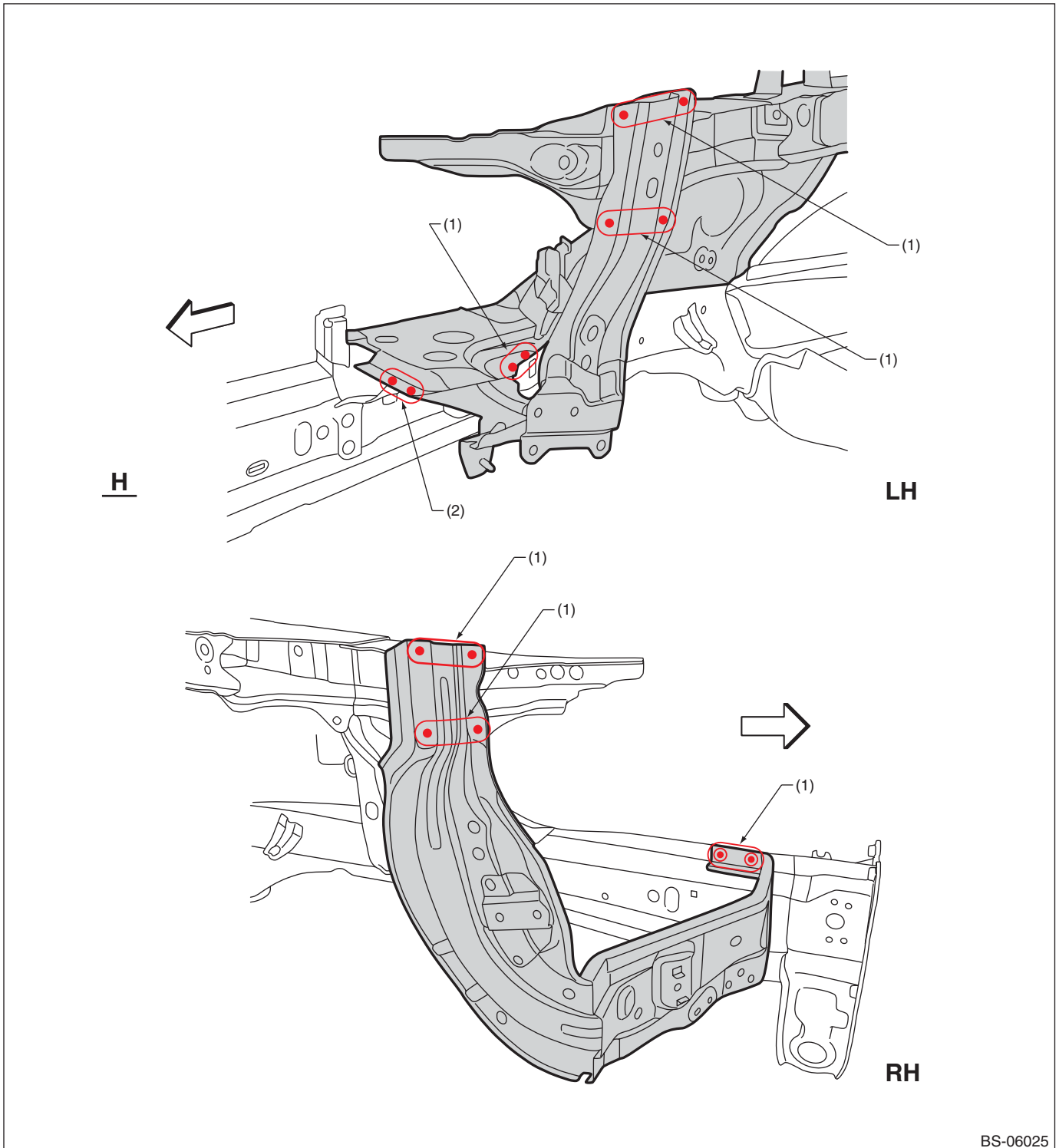
(3) 1 point (service)

(4) 3 points (service)

(2) 4 points

Panel Replacement

• Views 6



BS-06025

(1) 2 points

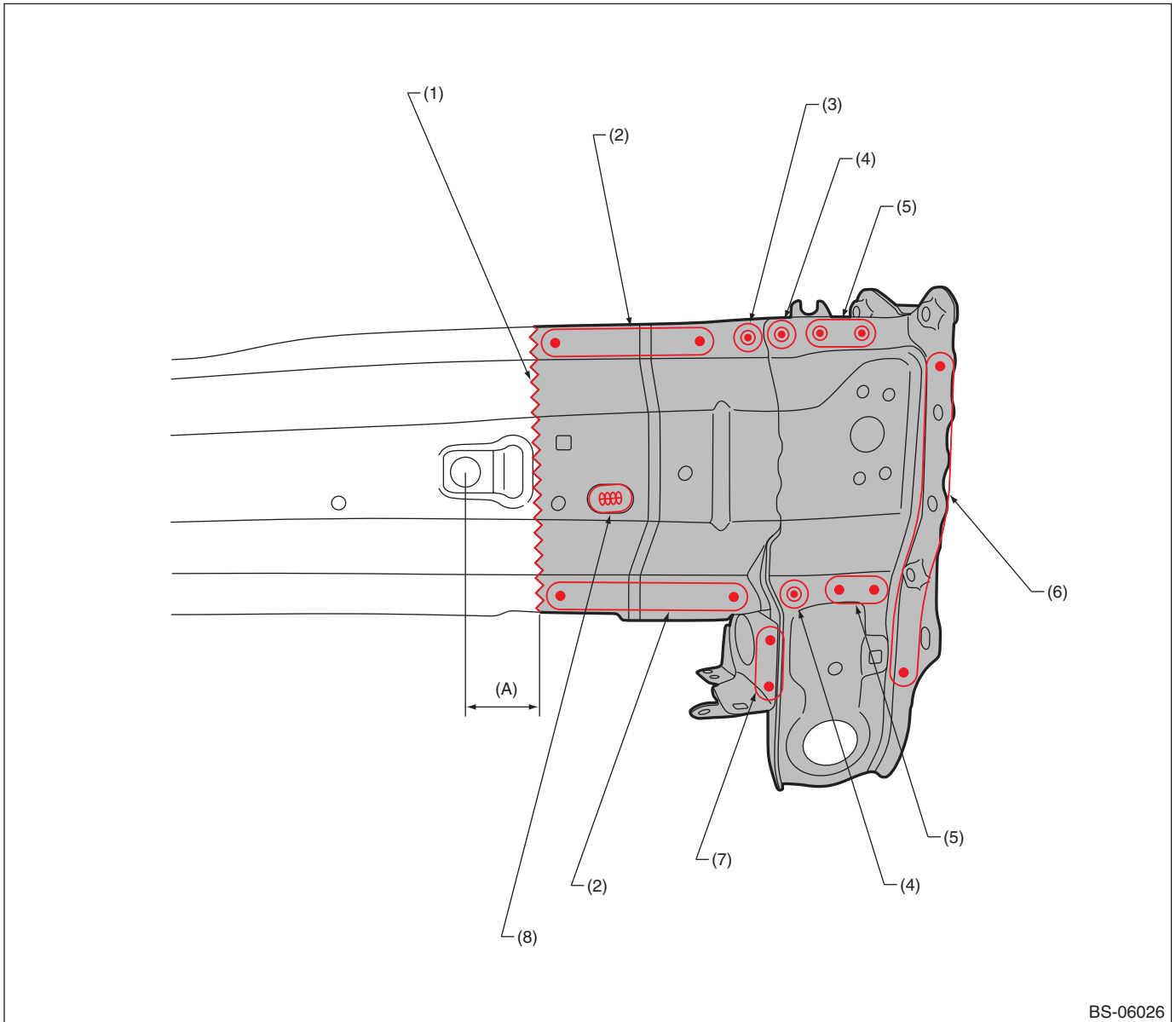
(2) 3 points

Panel Replacement

7-3. Closing Plate (partial replacement)

A: REMOVAL

- RH (Radiator panel and front wheel apron front removal condition)



(A) 40 mm (1.57 in)

- (1) Cut position
- (2) 5 points (outside · 1)
- (3) 1 point (outside · 1)

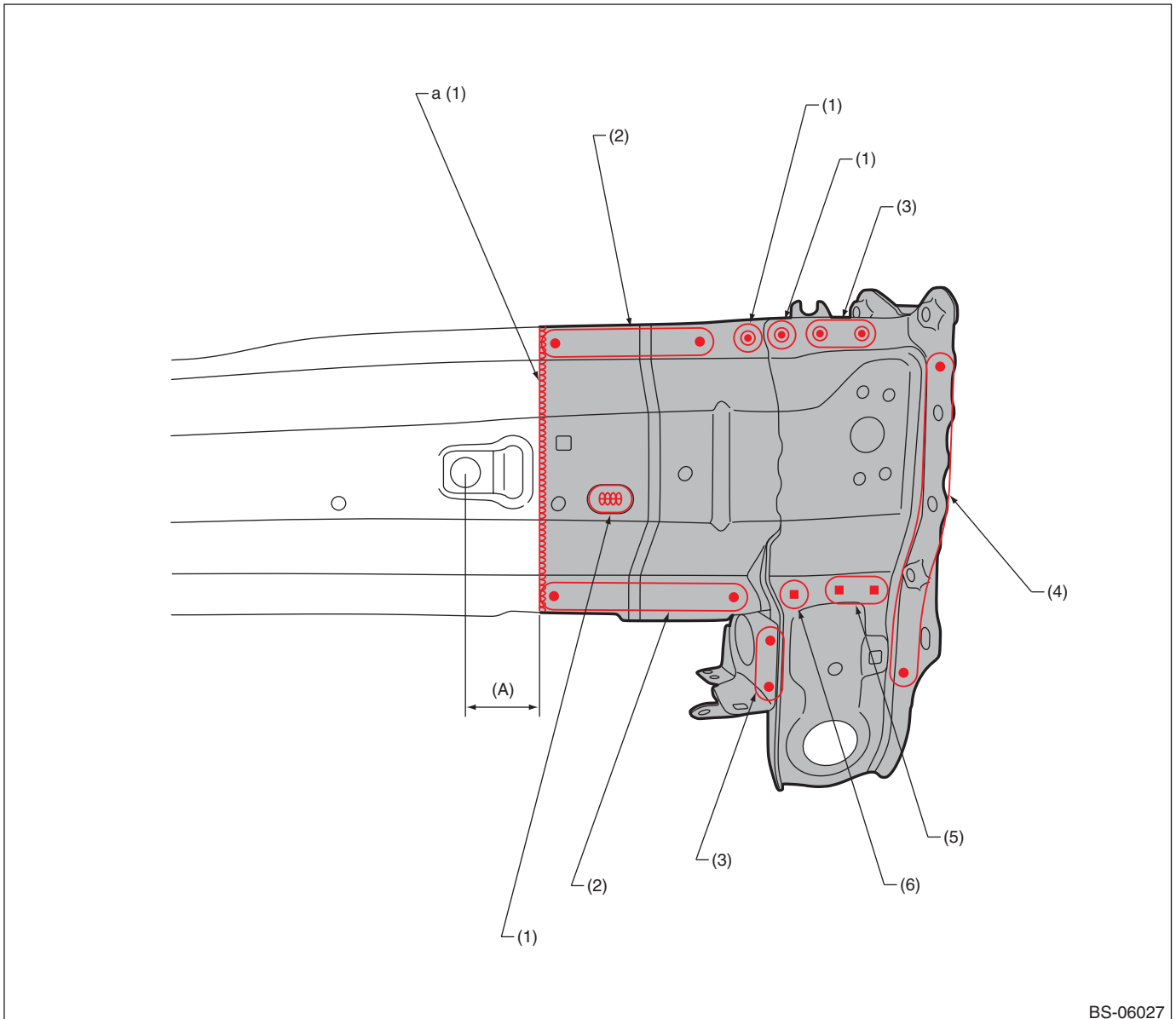
- (4) 1 point (outside · 2)
- (5) 2 points (outside · 1)
- (6) 6 points (outside · 1)

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

Panel Replacement

B: INSTALLATION

• RH



BS-06027

(A) 40 mm (1.57 in)

(1) 1 point

(2) 5 points

(3) 2 points

(4) 6 points

(5) 2 points (service)

(6) 1 point (service)

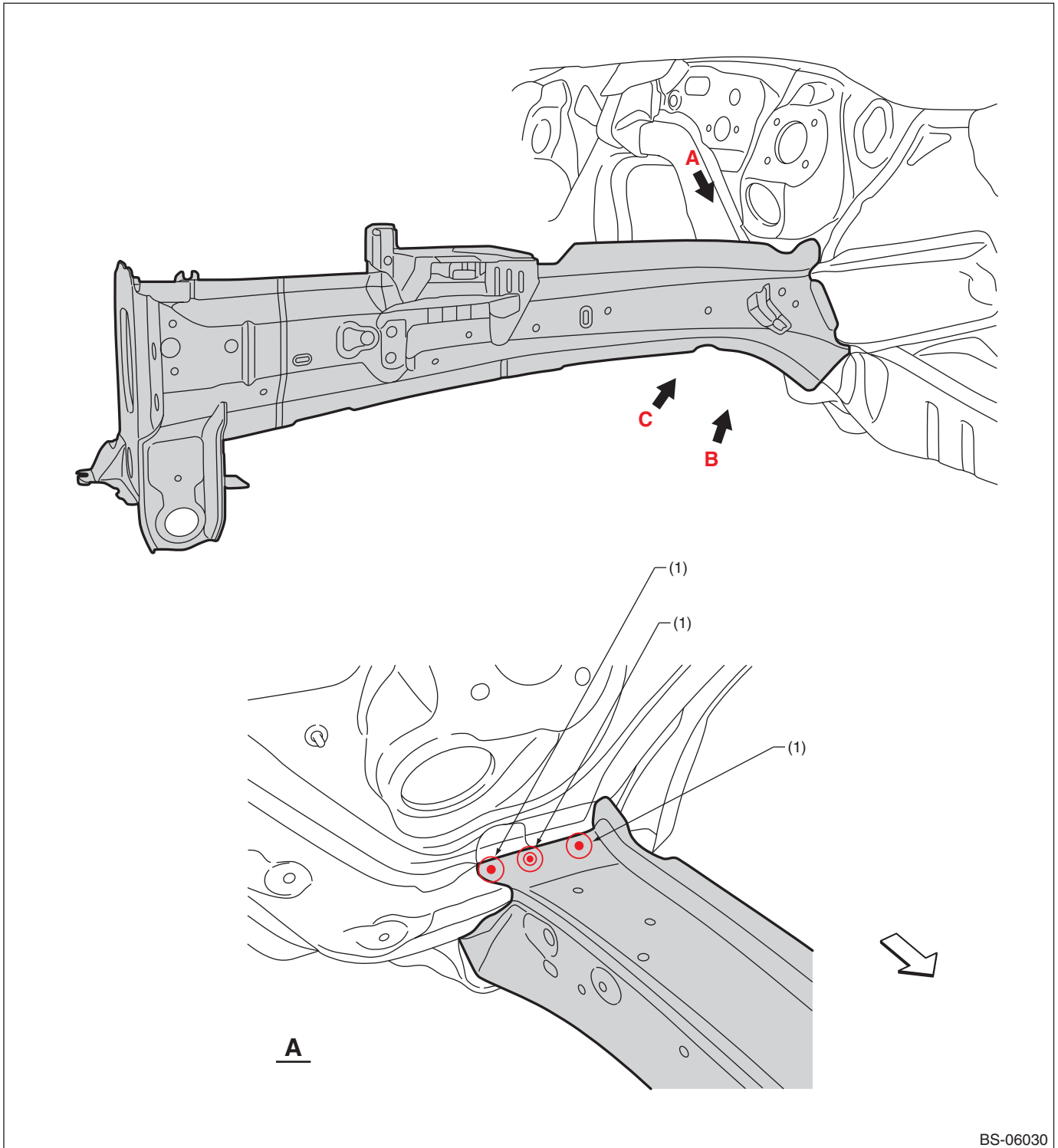
For part marked by “a”: Anticorrosion wax shall be applied thoroughly on the back side of continuous welding portion.

Panel Replacement

7-4. Front Side Frame (total replacement)

A: REMOVAL

- Radiator panel and front wheel apron removal condition

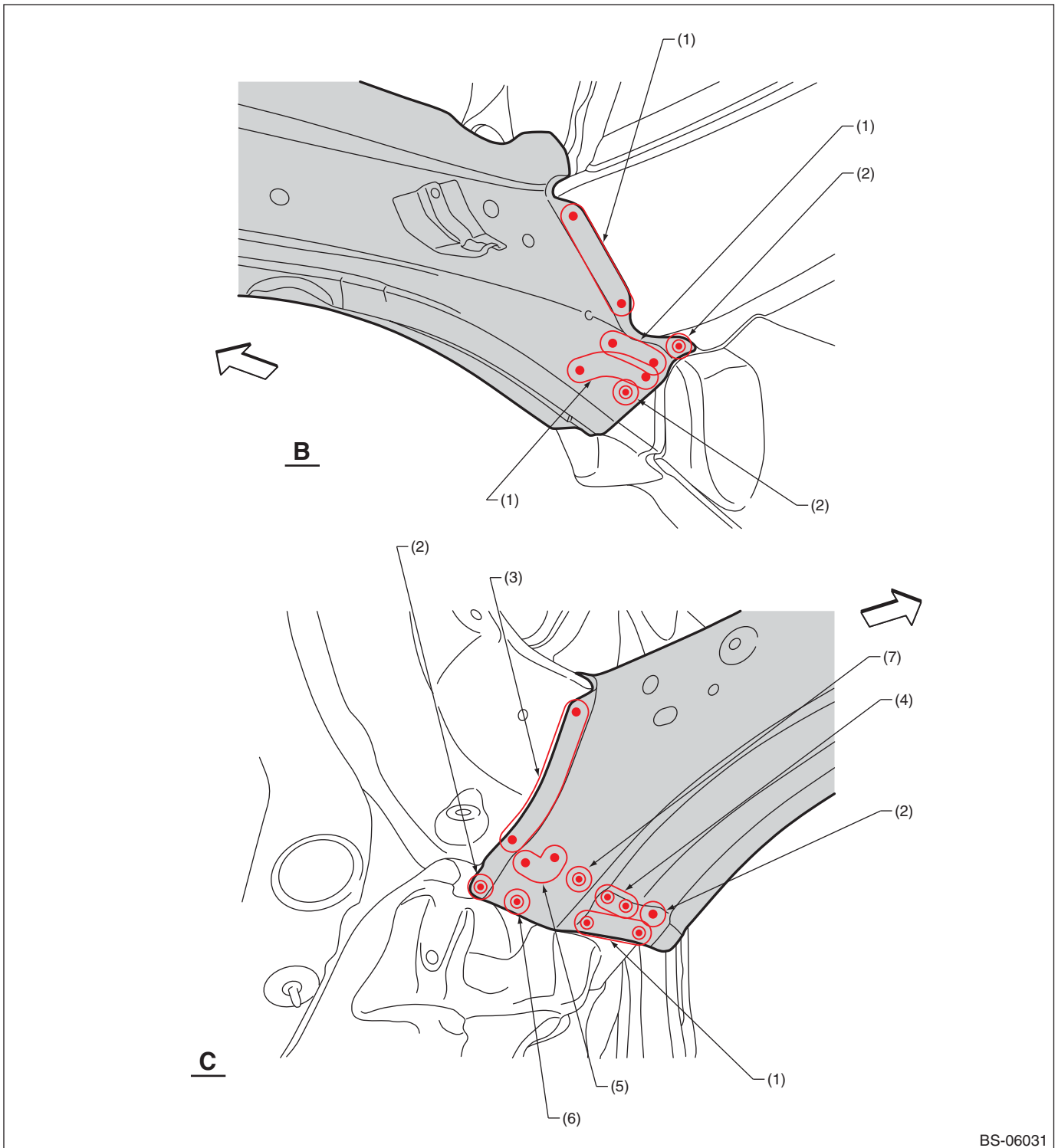


BS-06030

(1) 1 point (top · 1)

Panel Replacement

• Views

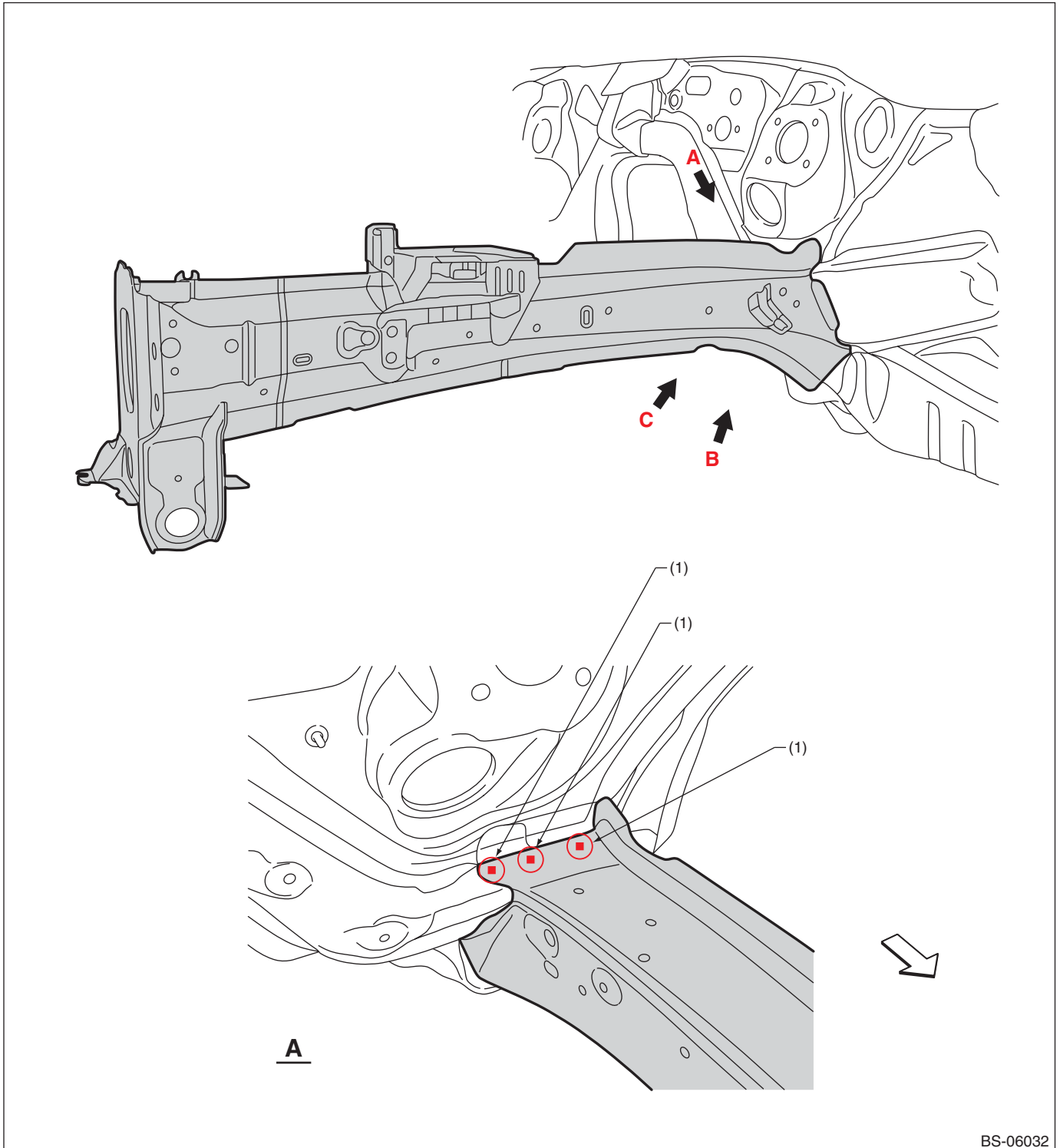


BS-06031

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

Panel Replacement

B: INSTALLATION

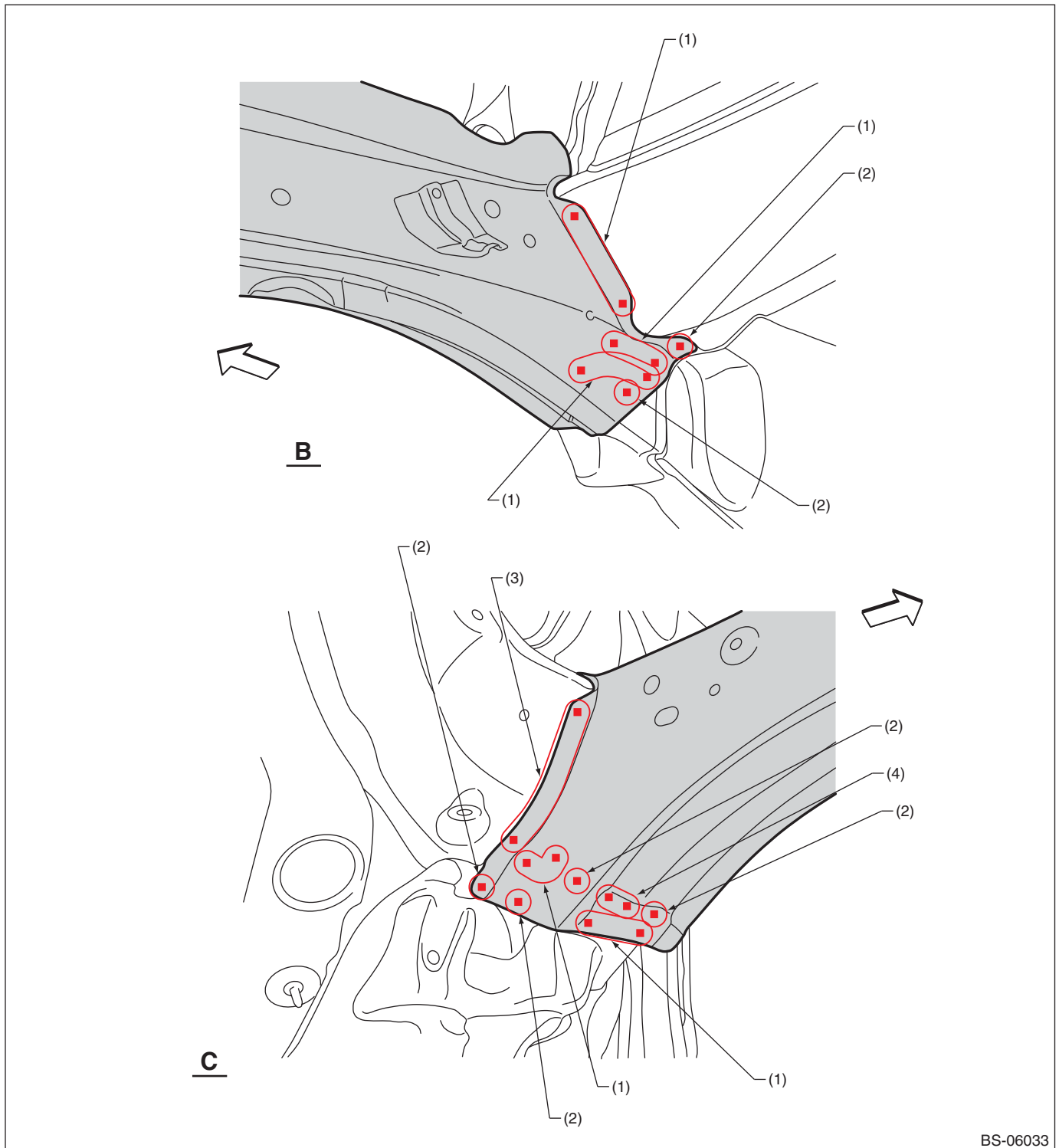


BS-06032

(1) 1 point (service)

Panel Replacement

• Views



BS-06033

(1) 3 points (service)

(2) 1 point (service)

(3) 4 points (service)

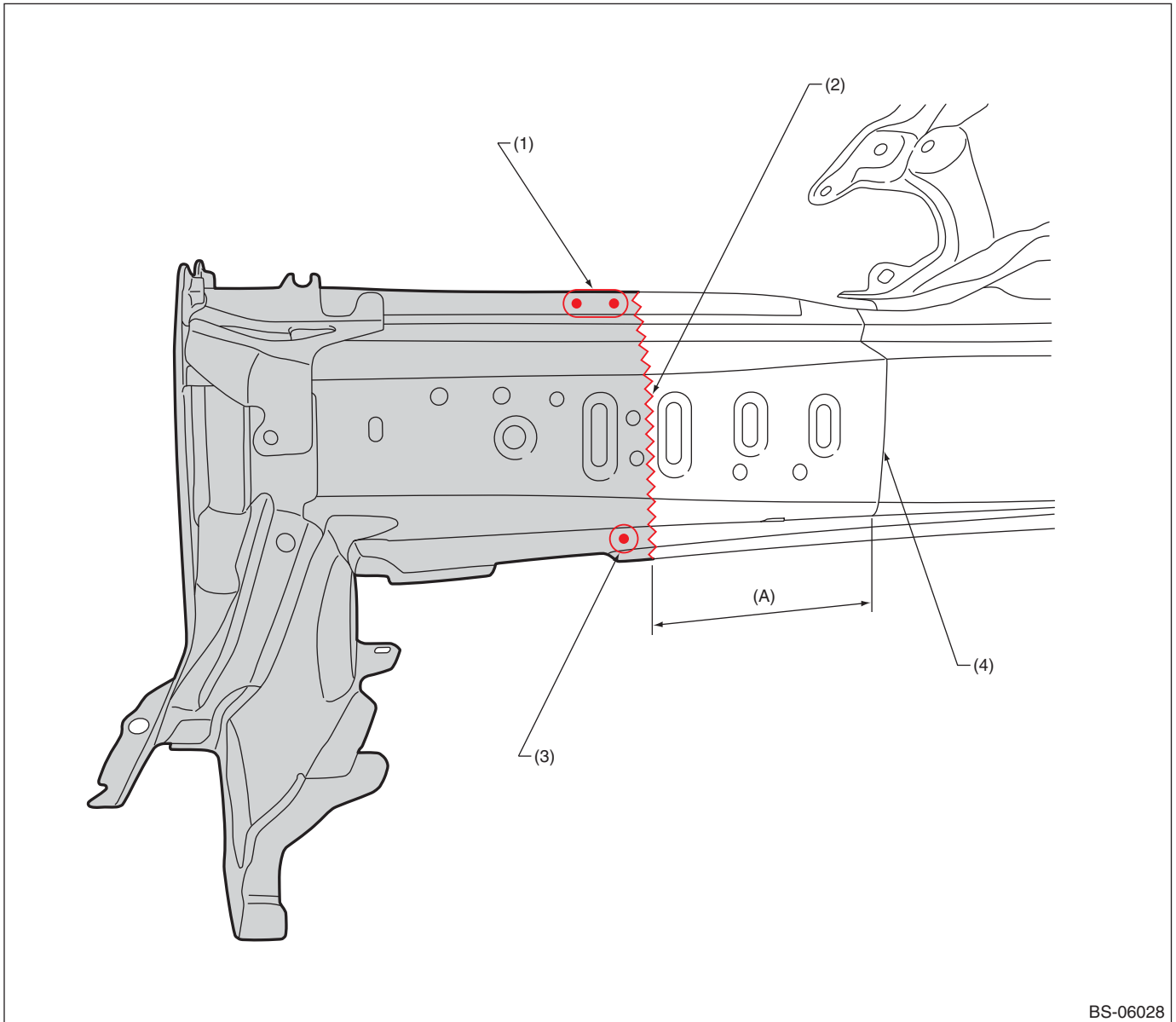
(4) 2 points (service)

Panel Replacement

7-5. Front Side Frame (partial replacement)

A: REMOVAL

- RH (Radiator panel, front wheel apron front and closing plate (half-cut position) removed condition)



BS-06028

(A) 120 mm (4.72 in)

(1) 2 points (inside · 1)

(3) 1 point (inside · 1)

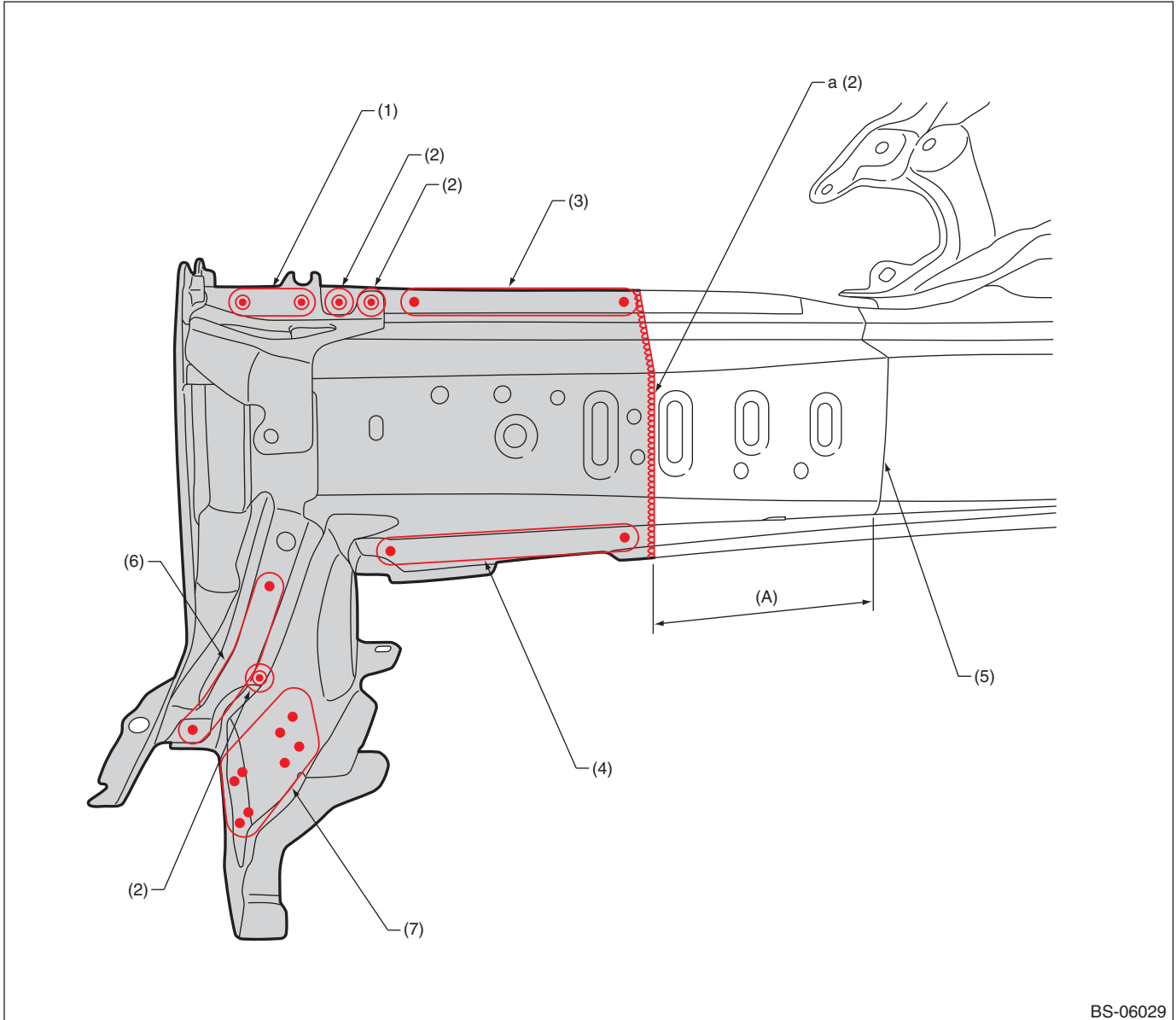
(4) Tailored line

(2) Cut position

Panel Replacement

B: INSTALLATION

• RH



BS-06029

(A) 120 mm (4.72 in)

(1) 2 points

(2) 1 point

(3) 7 points

(4) 6 points

(5) Tailored line

(6) 4 points

(7) 8 points

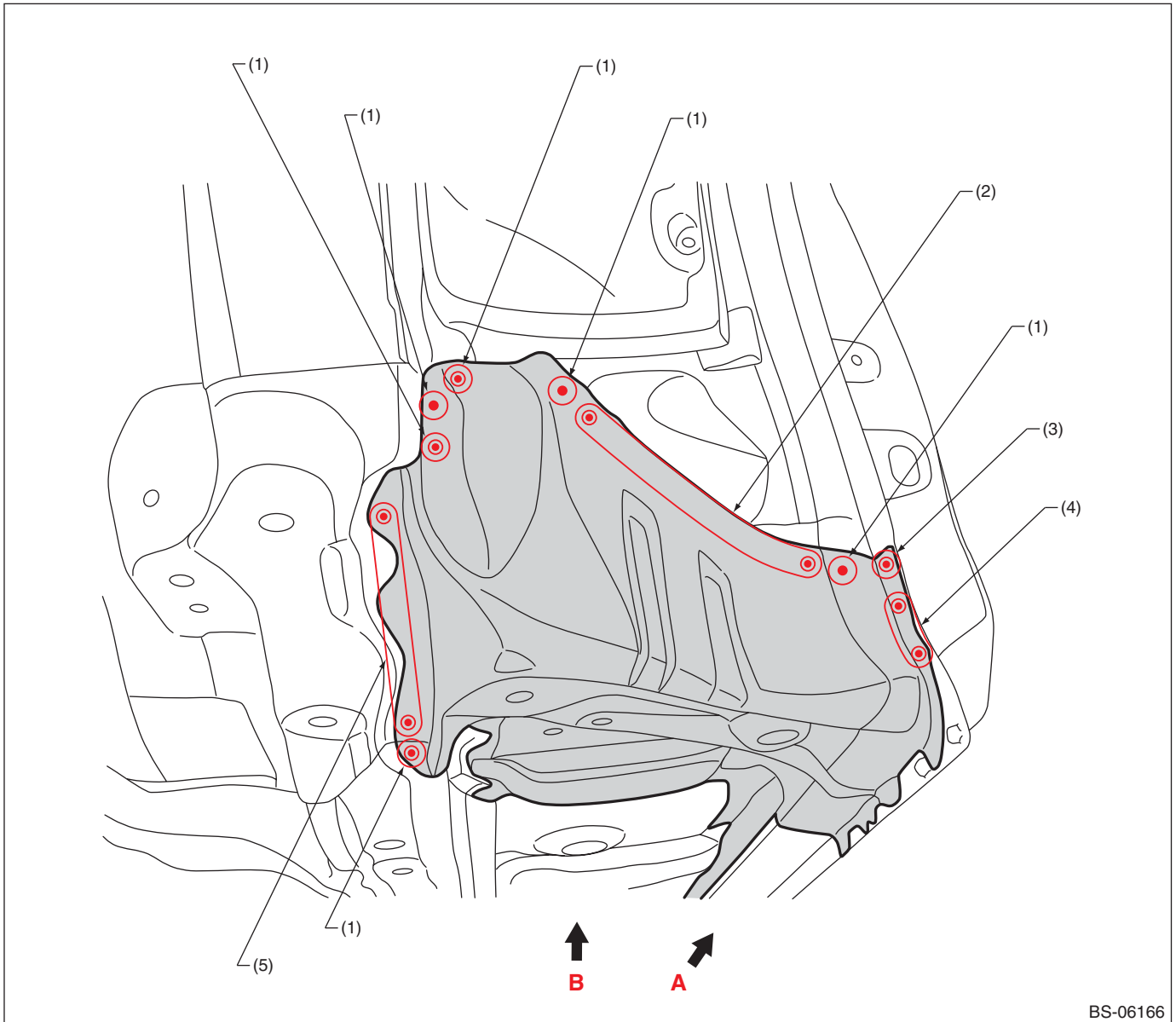
For part marked by "a": Anticorrosion wax shall be applied thoroughly on the back side of continuous welding portion.

Panel Replacement

7-6. Toe Board Reinforcement (total replacement)

A: REMOVAL

• Overall view (LH)



BS-06166

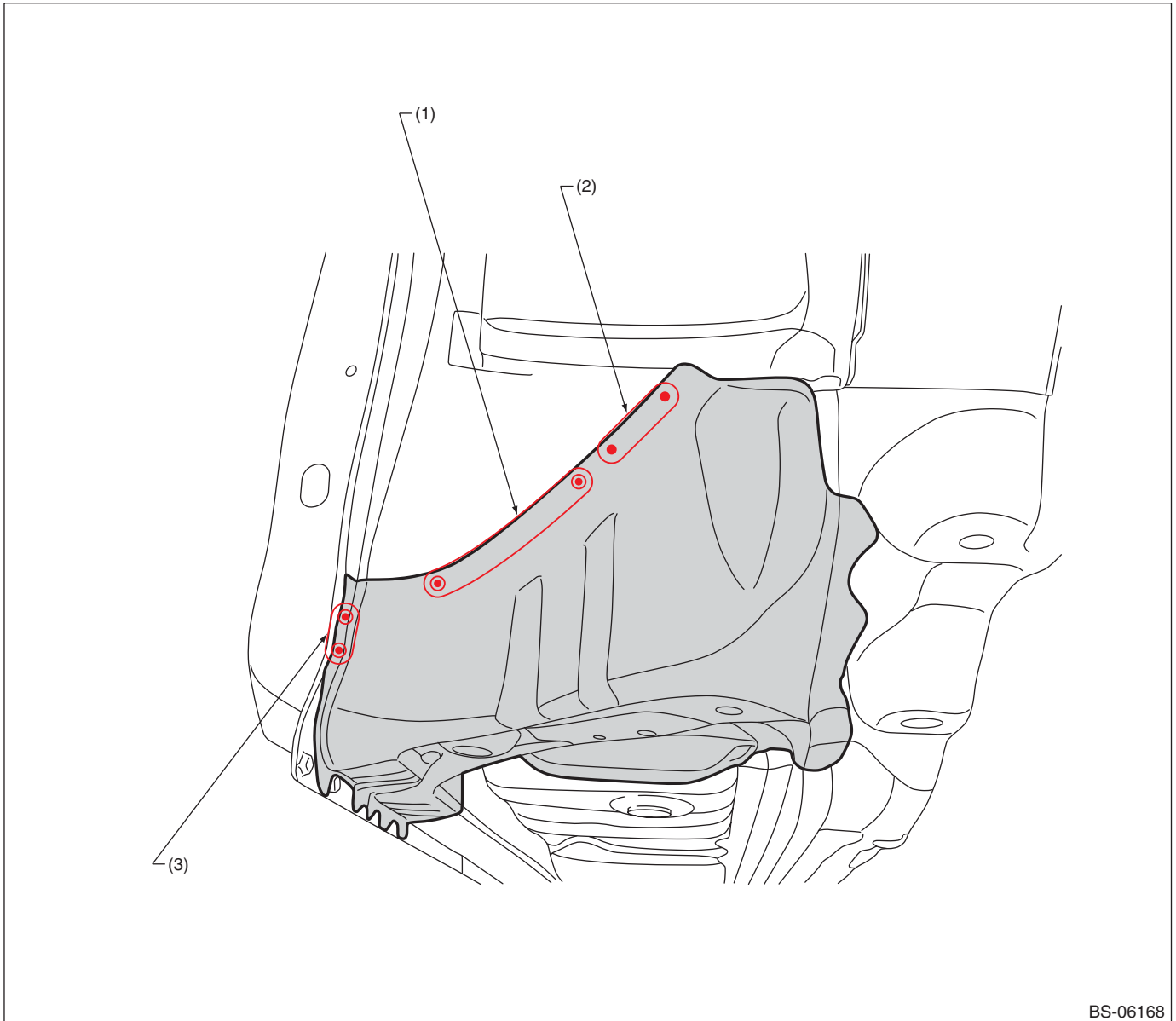
(1) 1 point (outside · 1)
(2) 6 points (outside · 1)

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

(5) 3 points (outside · 1)

Panel Replacement

- (RH)



BS-06168

(1) 4 points (outside · 1)

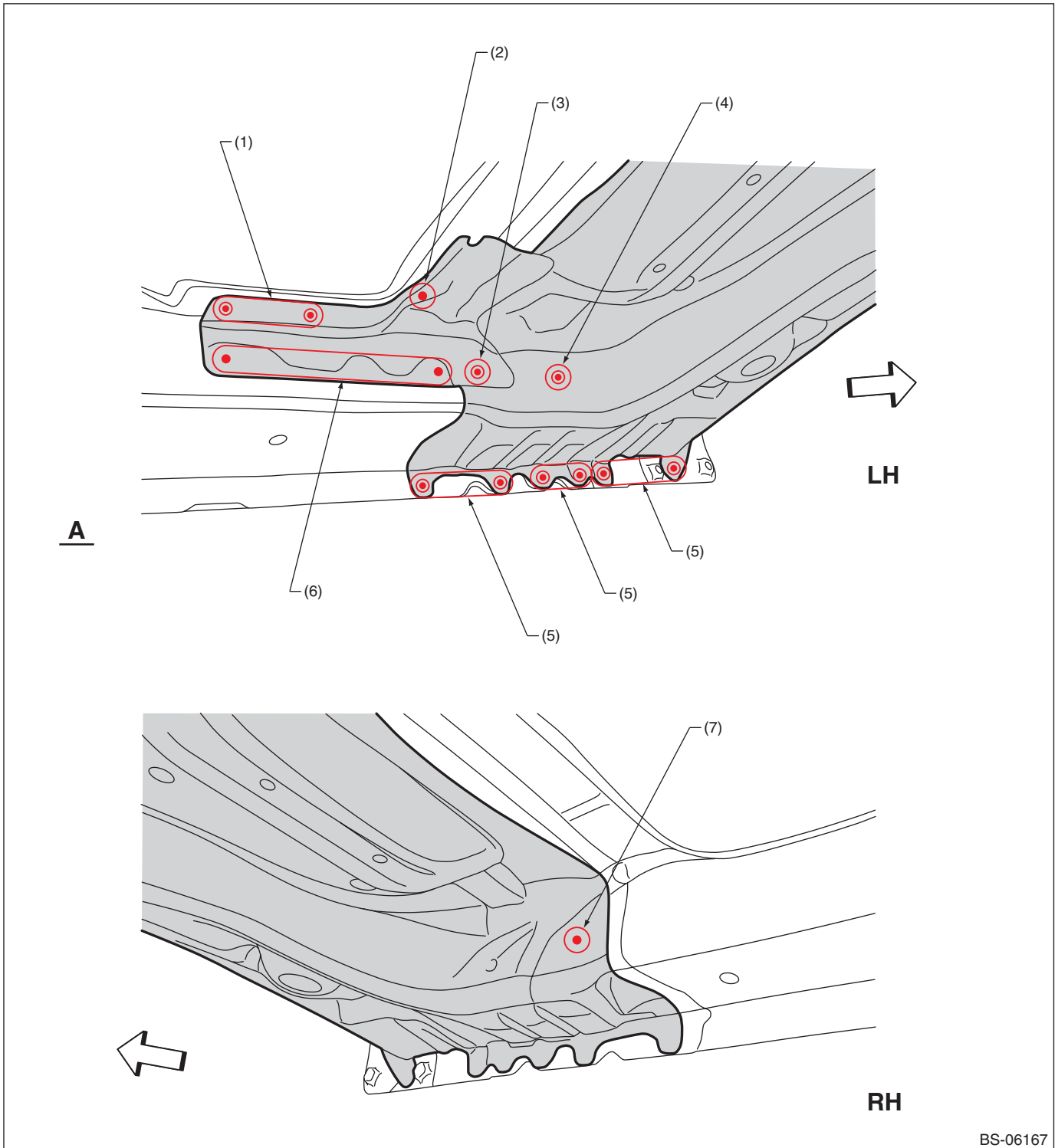
(2) 3 points (outside · 1)

(3) 2 points (inside · 1, belt sander)

Note: Designations in the RH diagram are the same as in the LH diagram, except for the indicated points.

Panel Replacement

• Views 1



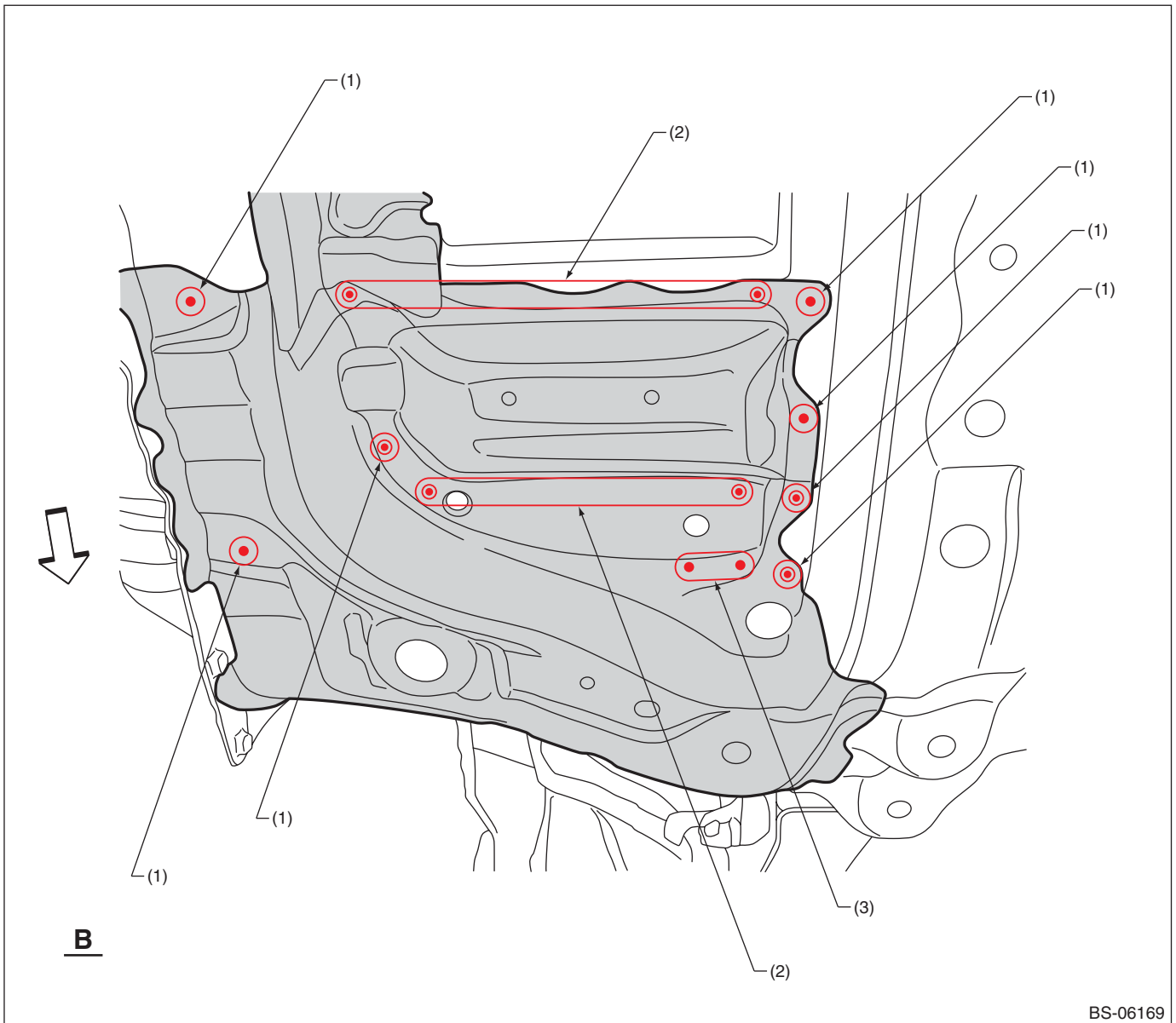
BS-06167

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

Note: Designations in the RH diagram are the same as in the LH diagram, except for the indicated points.

Panel Replacement

• Views 2



(1) 1 point (bottom · 1)

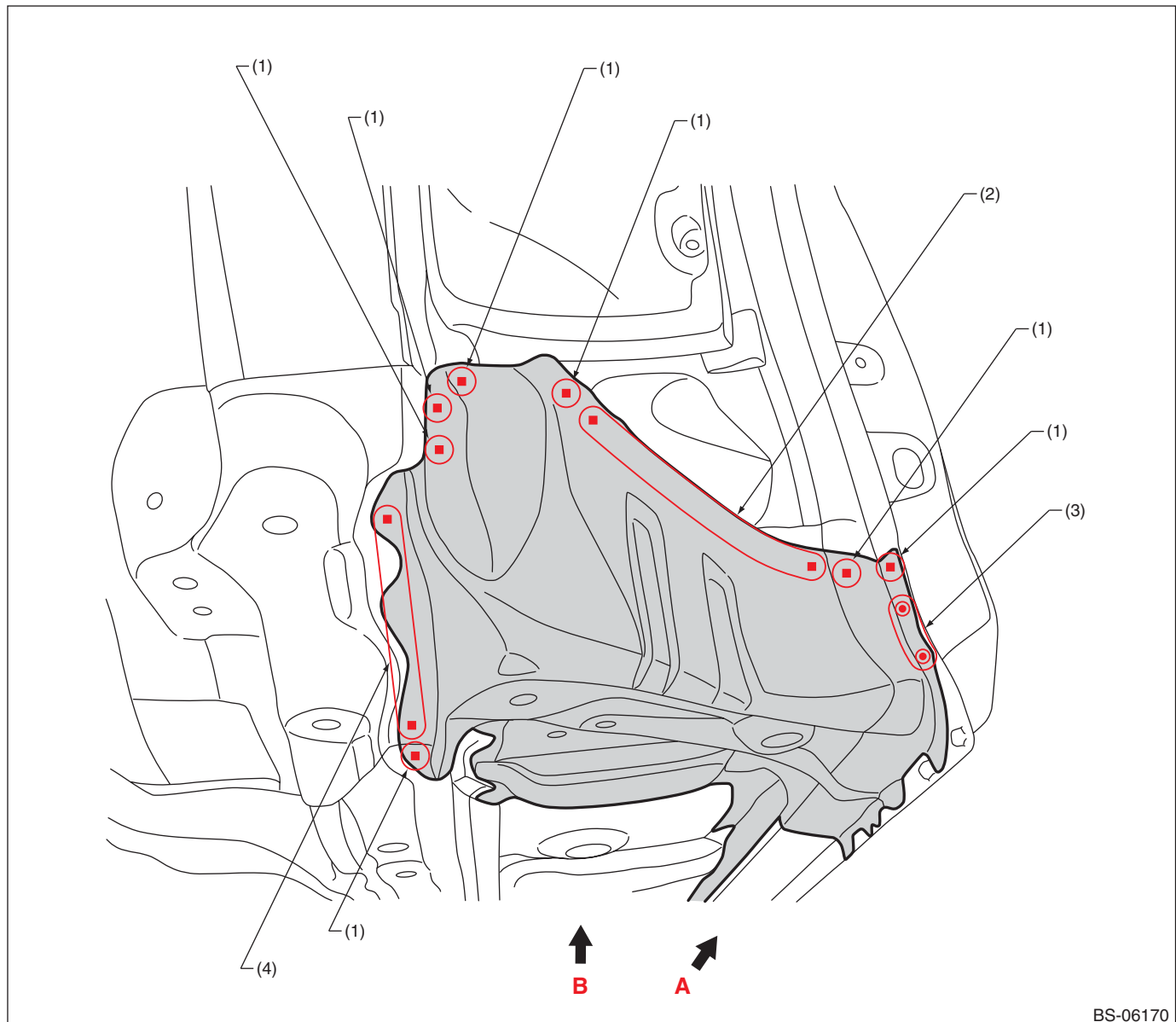
(2) 5 points (bottom · 1)

(3) 2 points (bottom · 1)

Panel Replacement

B: INSTALLATION

• Overall view (LH)



BS-06170

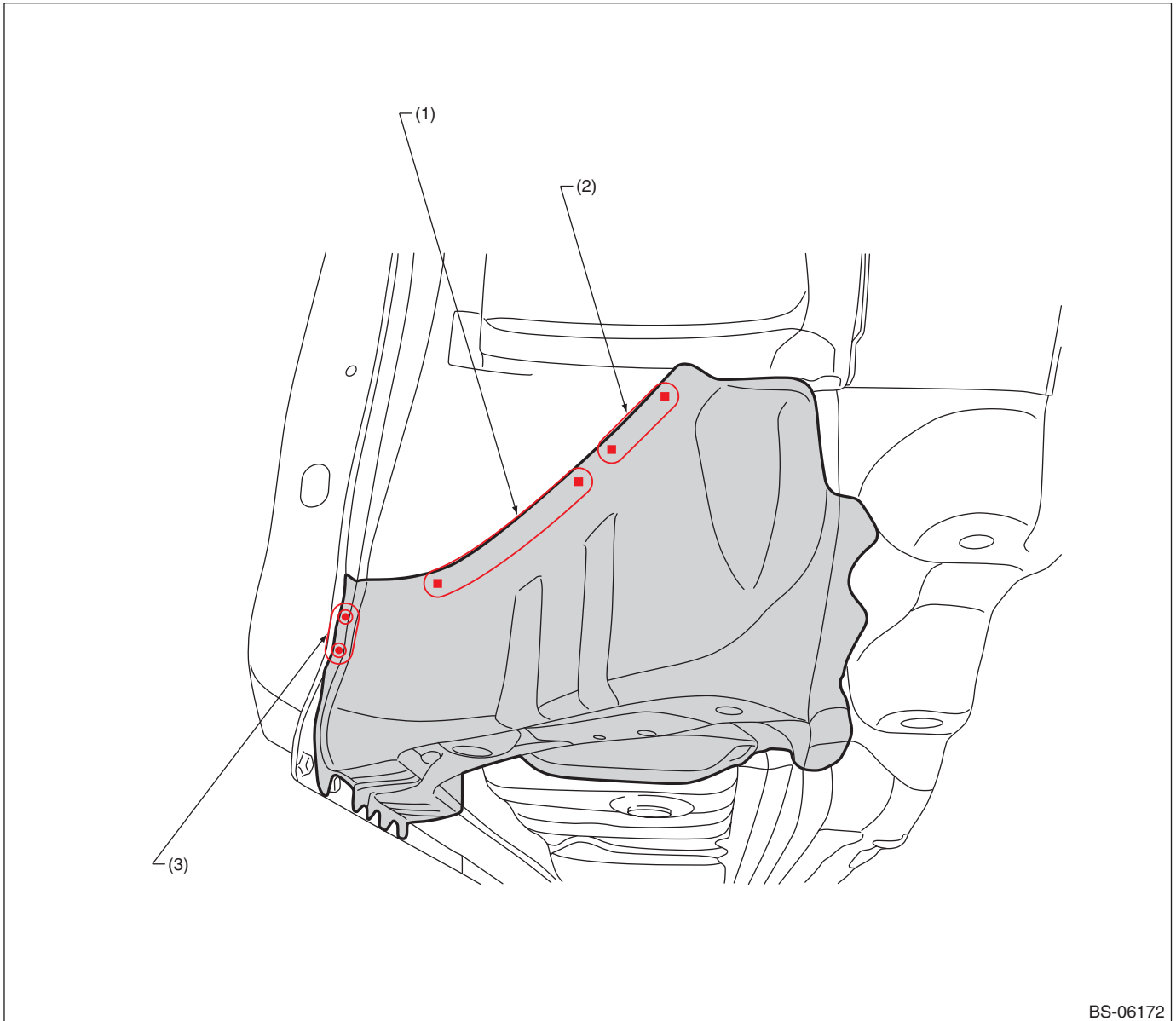
- (1) 1 point (service)
(2) 6 points (service)

- (3) 3 points

- (4) 3 points (service)

Panel Replacement

- (RH)



BS-06172

(1) 4 points (service)

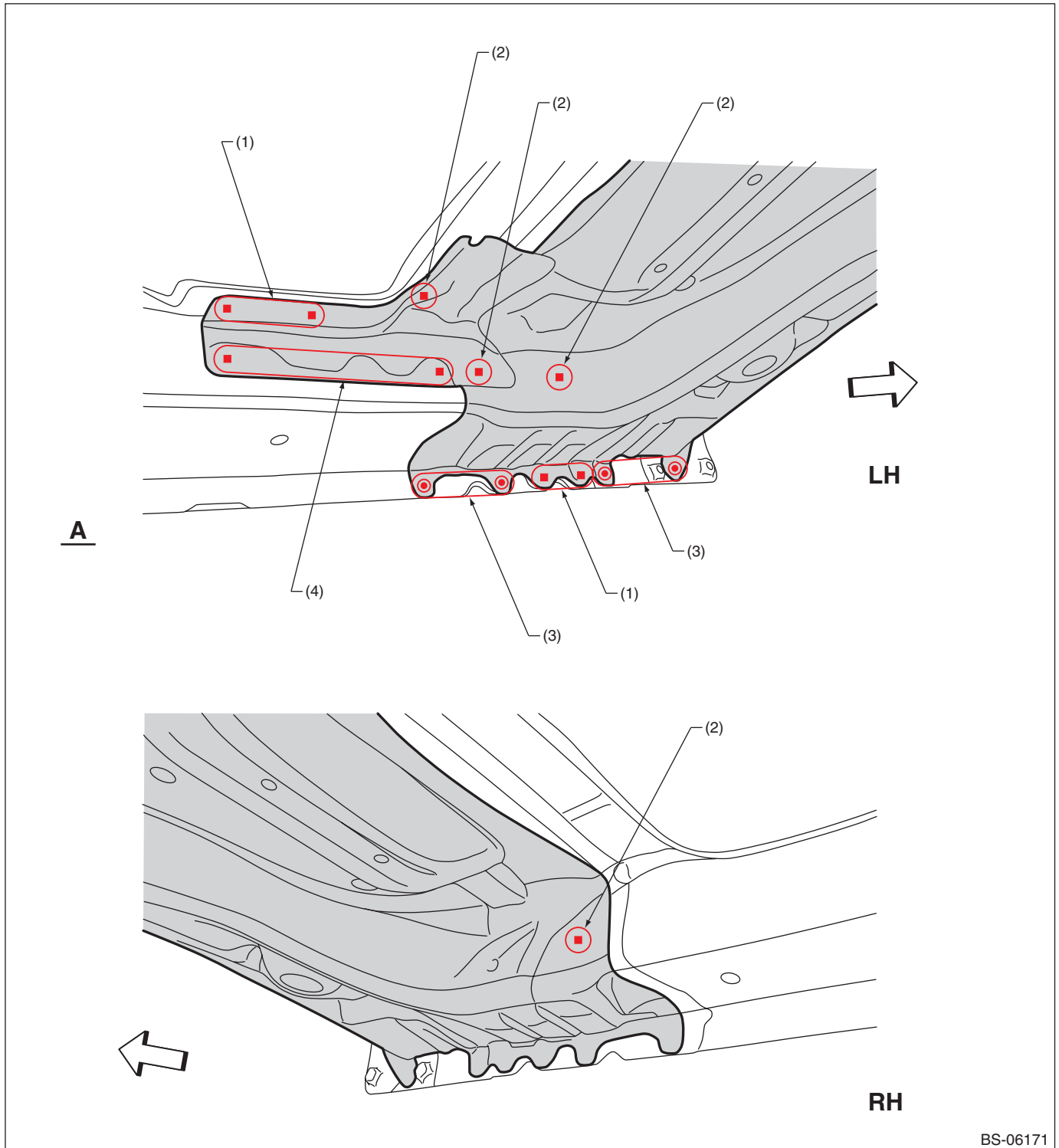
(2) 3 points (service)

(3) 2 points

Note: Designations in the RH diagram are the same as in the LH diagram, except for the indicated points.

Panel Replacement

• Views 1



BS-06171

(1) 2 points (service)

(3) 2 points

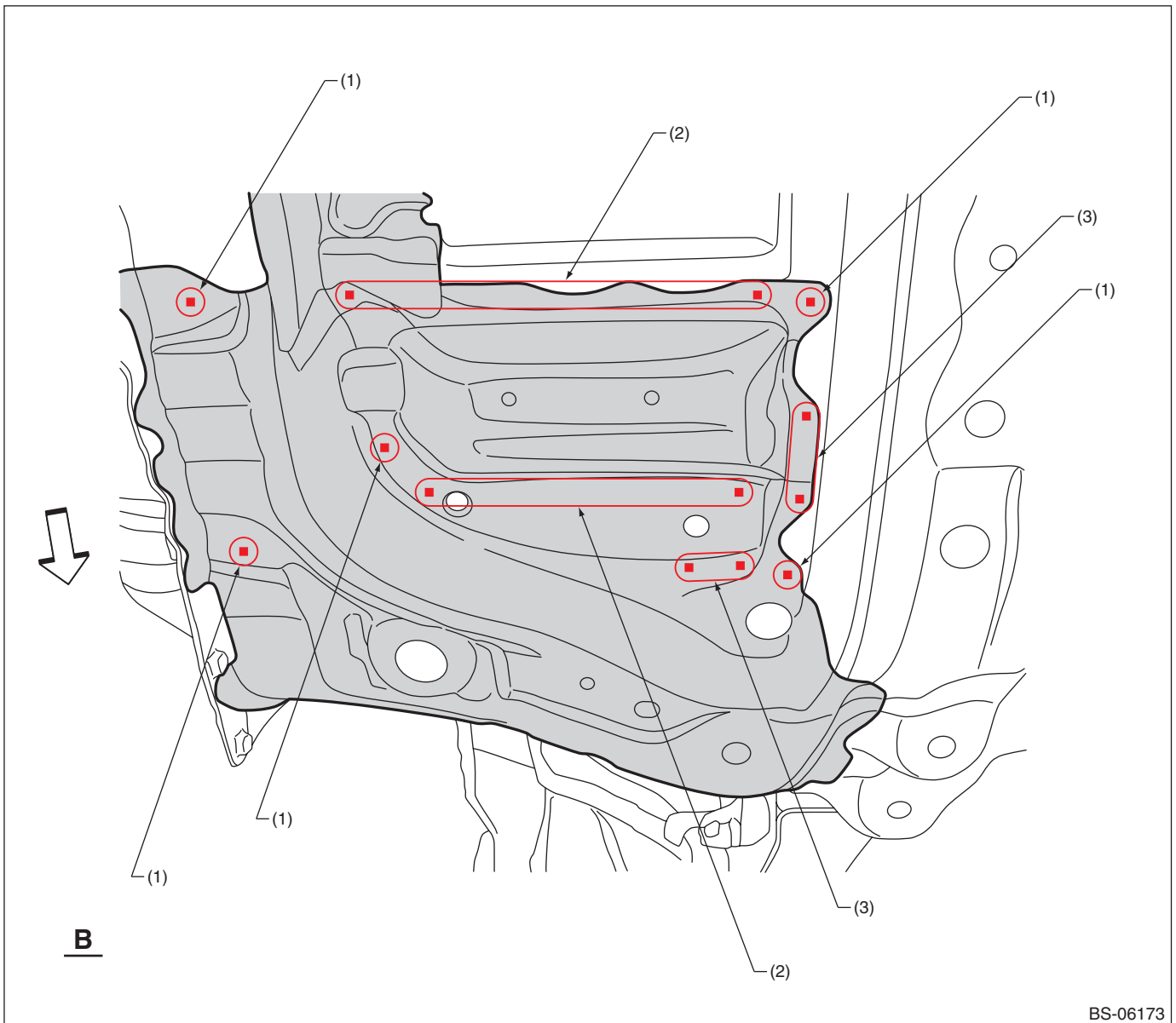
(4) 4 points (service)

(2) 1 point (service)

Note: Designations in the RH diagram are the same as in the LH diagram, except for the indicated points.

Panel Replacement

• Views 2



BS-06173

(1) 1 point (service)

(2) 5 points (service)

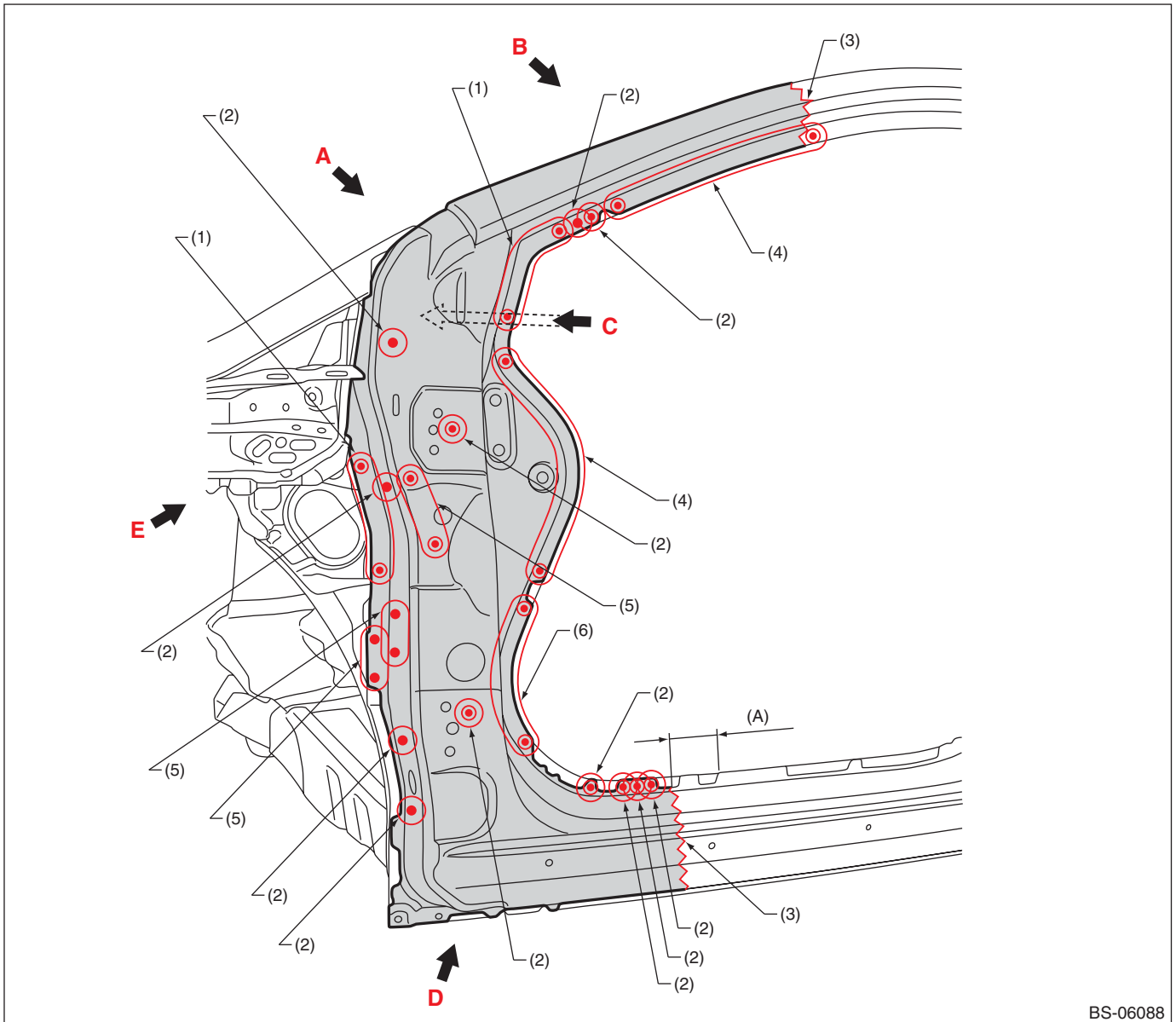
(3) 2 points (service)

Panel Replacement

7-7. Front Pillar (partial replacement)

A: REMOVAL

• Overall view



BS-06088

(A) 65 mm (2.56 in)

(1) 4 points (outside · 1)

(2) 1 point (outside · 1)

(3) Rough cutting

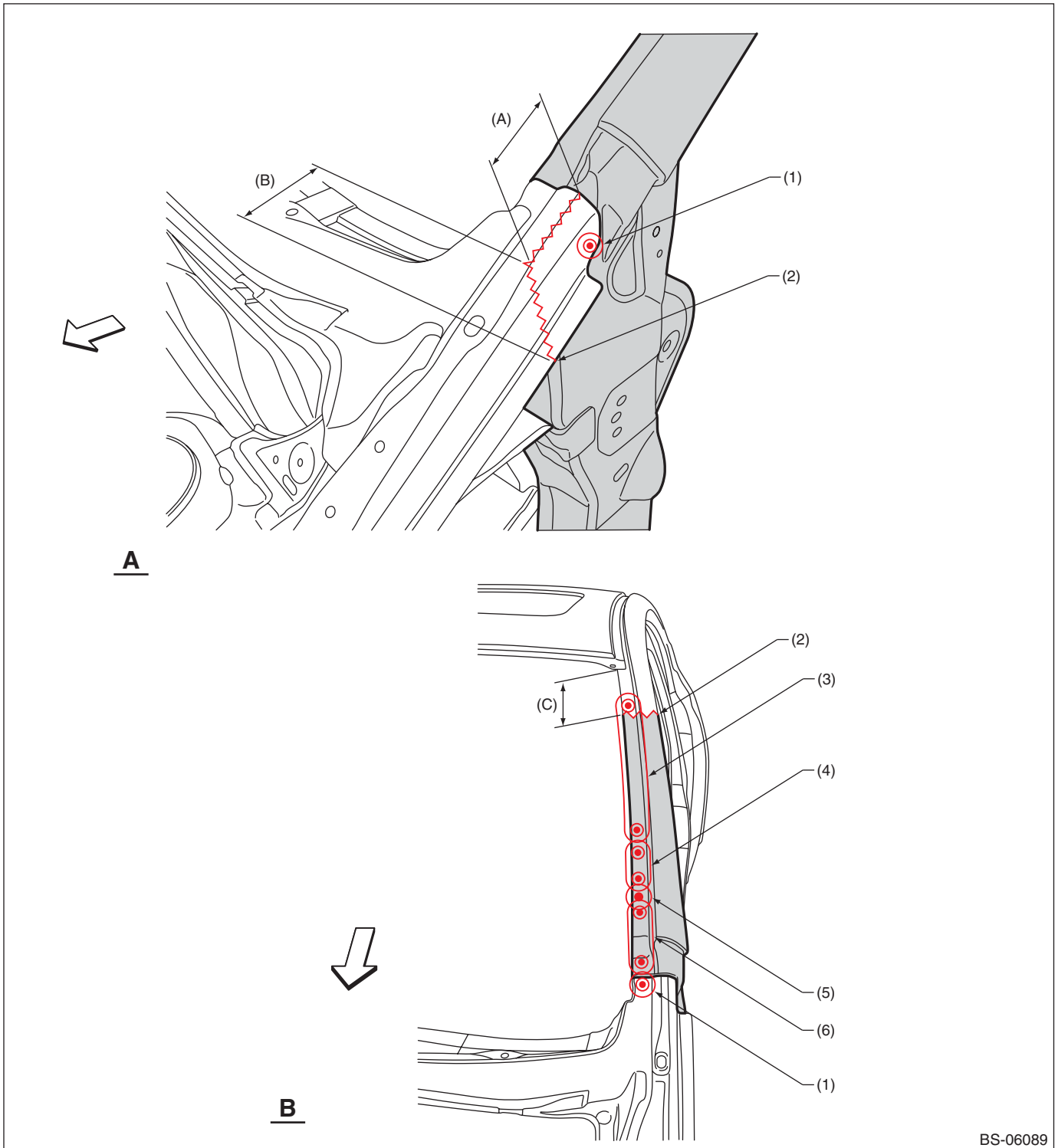
(4) 8 points (outside · 1)

(5) 2 points (outside · 1)

(6) 7 points (outside · 1) (only LH)
4 points (outside · 1) (only RH)

Panel Replacement

• Views 1



(A) 60 mm (2.36 in)

(B) 80 mm (3.15 in)

(C) 100 mm (3.94 in)

(1) 1 point (outside · 2)

(3) 9 points (outside · 1)

(5) 1 point (outside · 1)

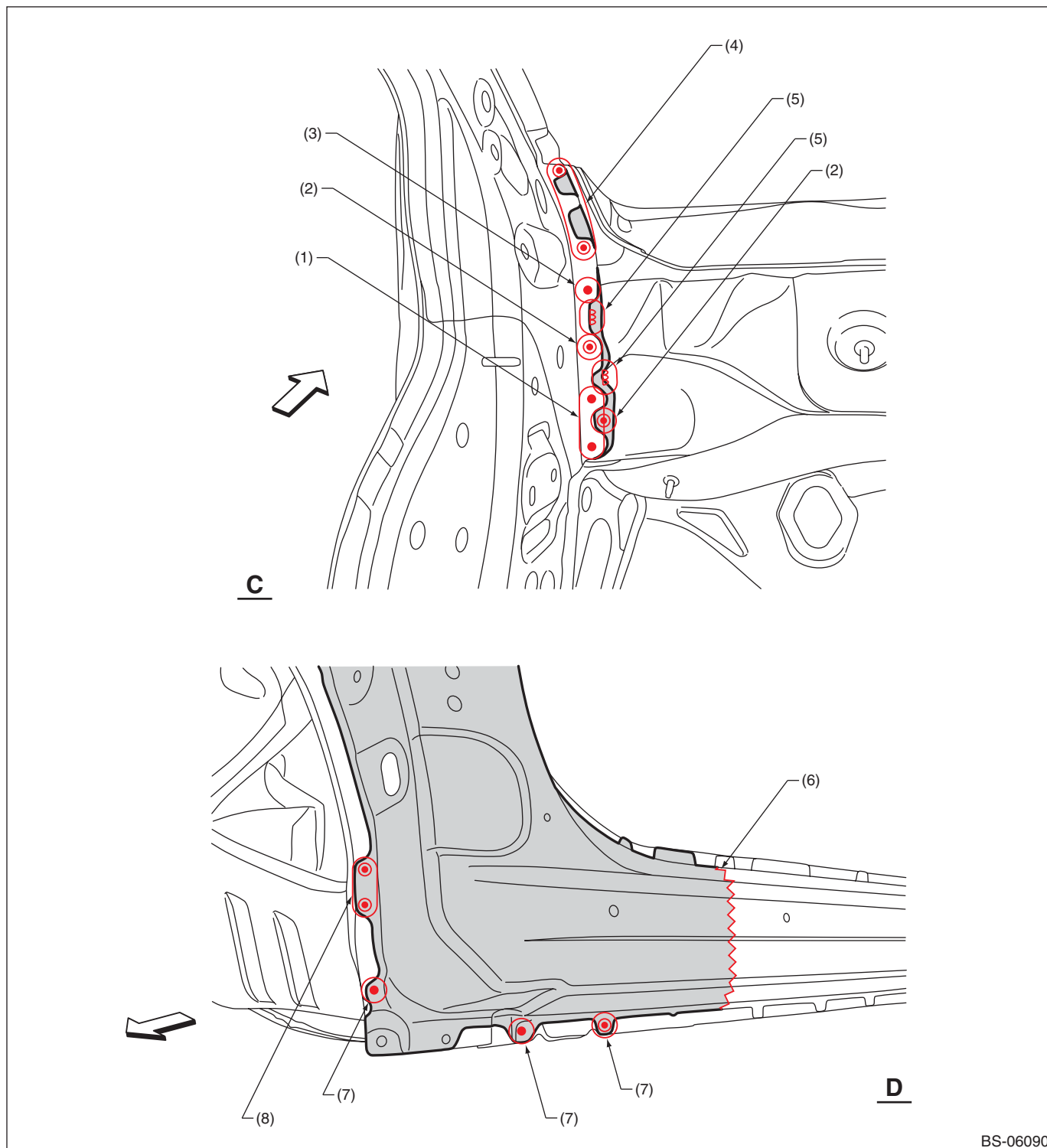
(2) Rough cutting

(4) 2 points (outside · 1)

(6) 3 points (outside · 1)

Panel Replacement

• Views 2

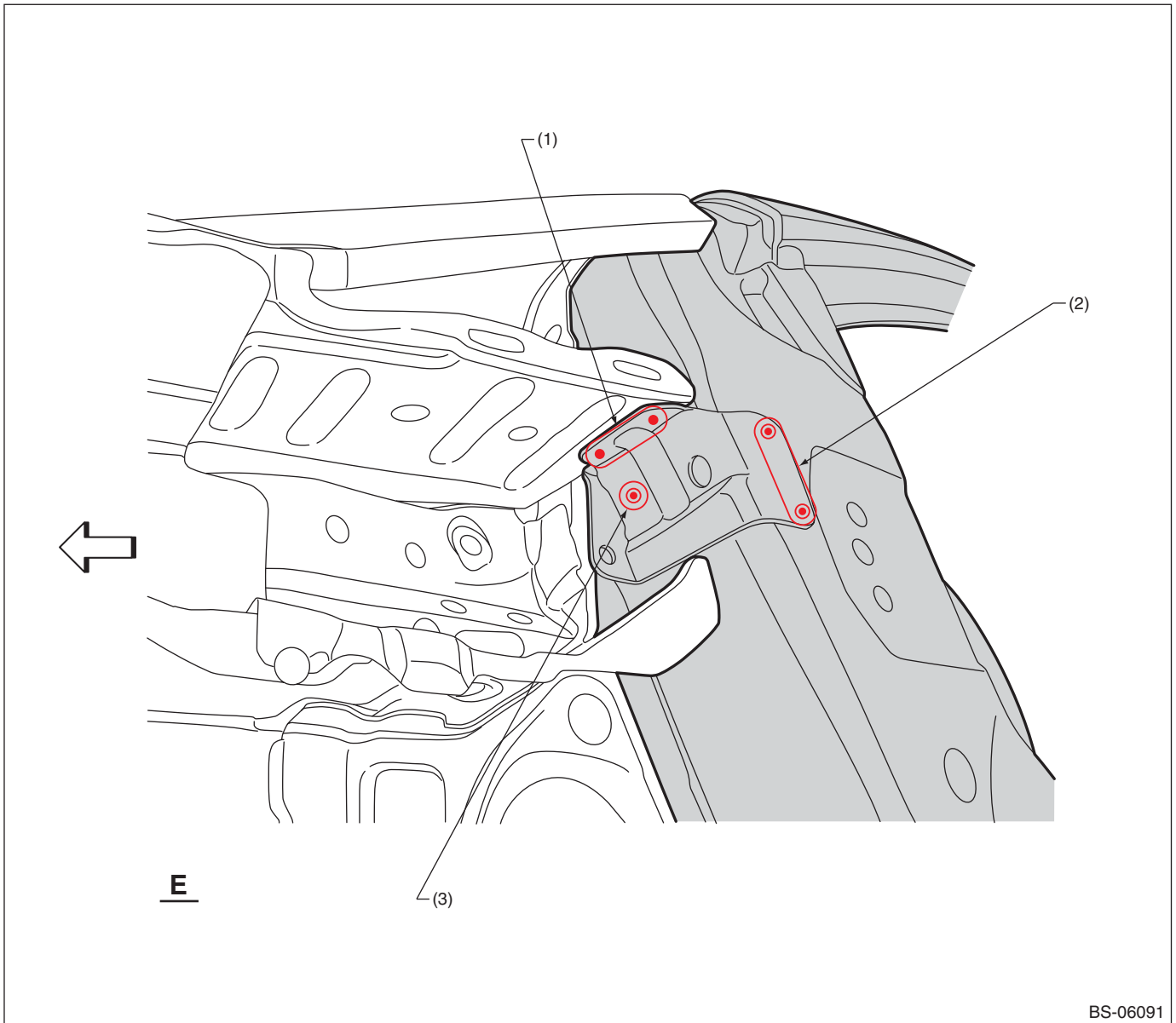


BS-06090

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

Panel Replacement

• Views 3



BS-06091

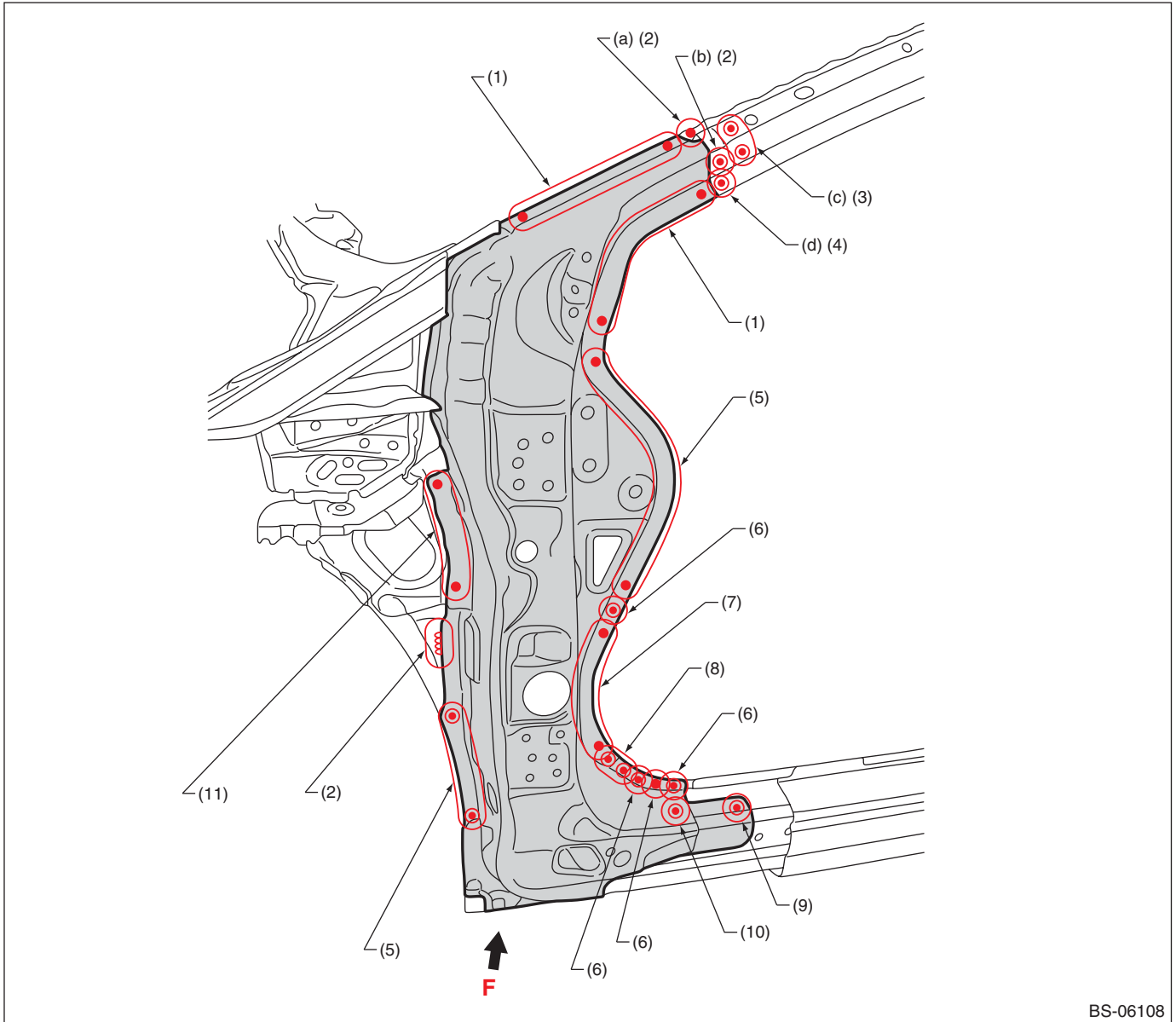
(1) 2 points (bottom · 1)

(2) 2 points (outside · 2)

(3) 1 point (outside · 2)

Panel Replacement

• Overall view (LH)



BS-06108

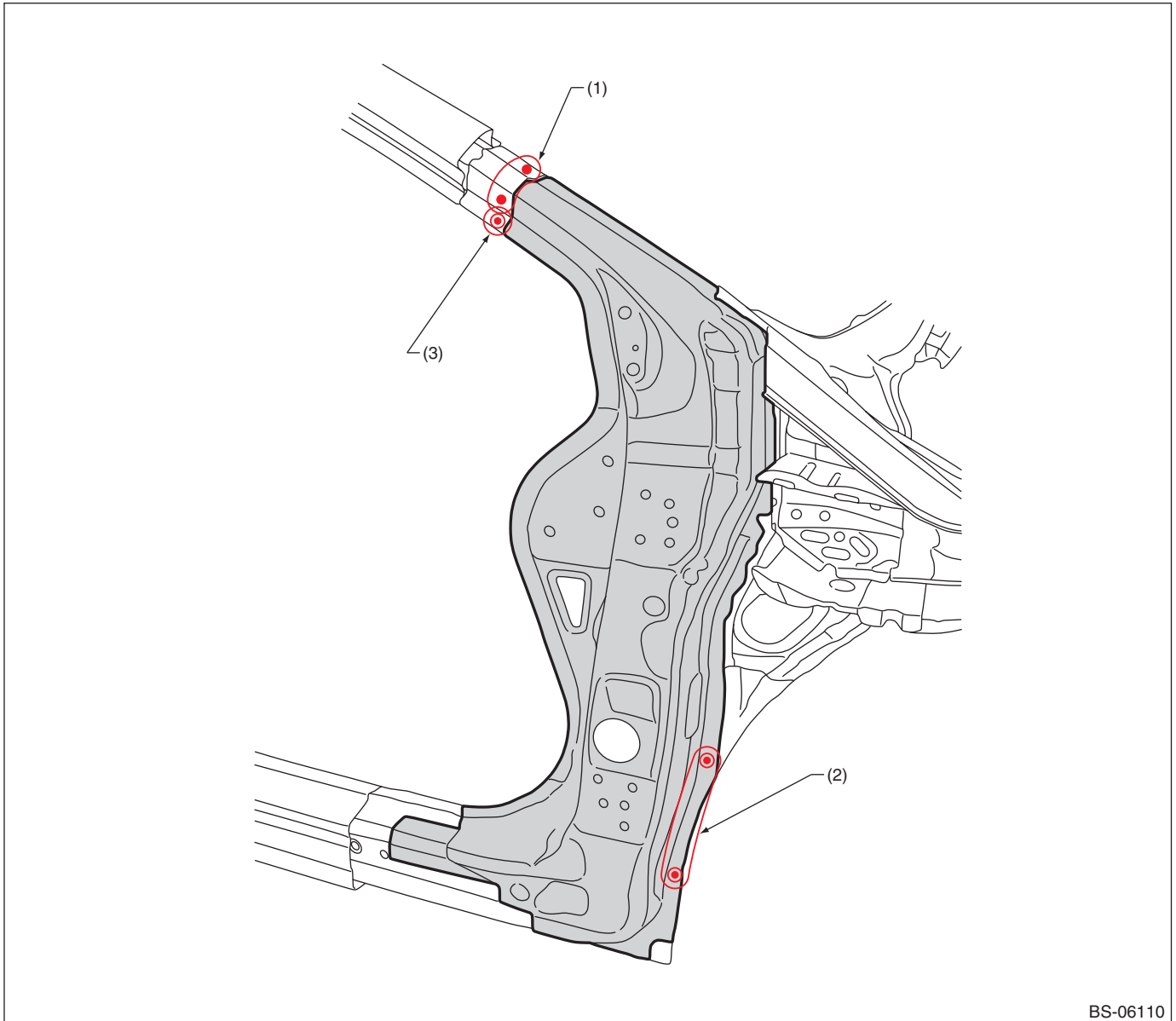
- | | | |
|---|----------------------------|-----------------------------|
| (1) 5 points (outside · 1) | (5) 8 points (outside · 1) | (9) 1 point (top · 1) |
| (2) 1 point (outside · 1, belt sander) | (6) 1 point (outside · 1) | (10) 1 point (top · 2) |
| (3) 2 points (outside · 2, belt sander) | (7)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

Note: When using a 1,500 MPa Class-compatible spot cutter

- (a): 1 point (outside · 1)
- (b): 1 point (outside · 1)
- (c): 2 points (outside · 2)
- (d): 1 point (outside · 2)

Panel Replacement

- (RH)



BS-06110

(1) 3 points (outside · 1)

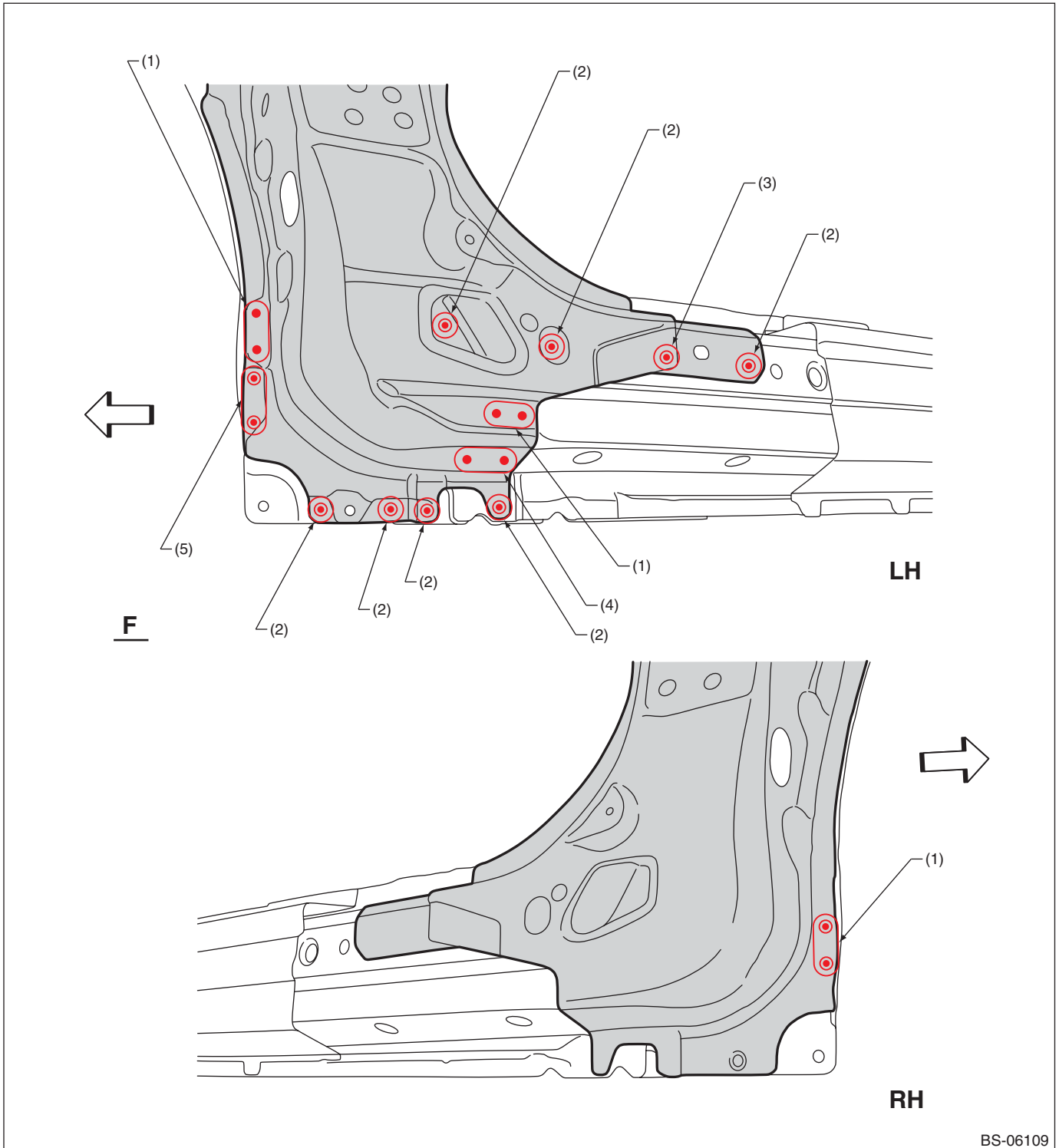
(2) 5 points (outside · 1)

(3) 1 point (outside · 2)

Note: Designations in the RH diagram are the same as in the LH diagram, except for the indicated points.

Panel Replacement

• Views



BS-06109

(1) 2 points (outside · 1)

(2) 1 point (outside · 1)

(3) 1 point (outside · 2)

(4) 2 points (bottom · 1)

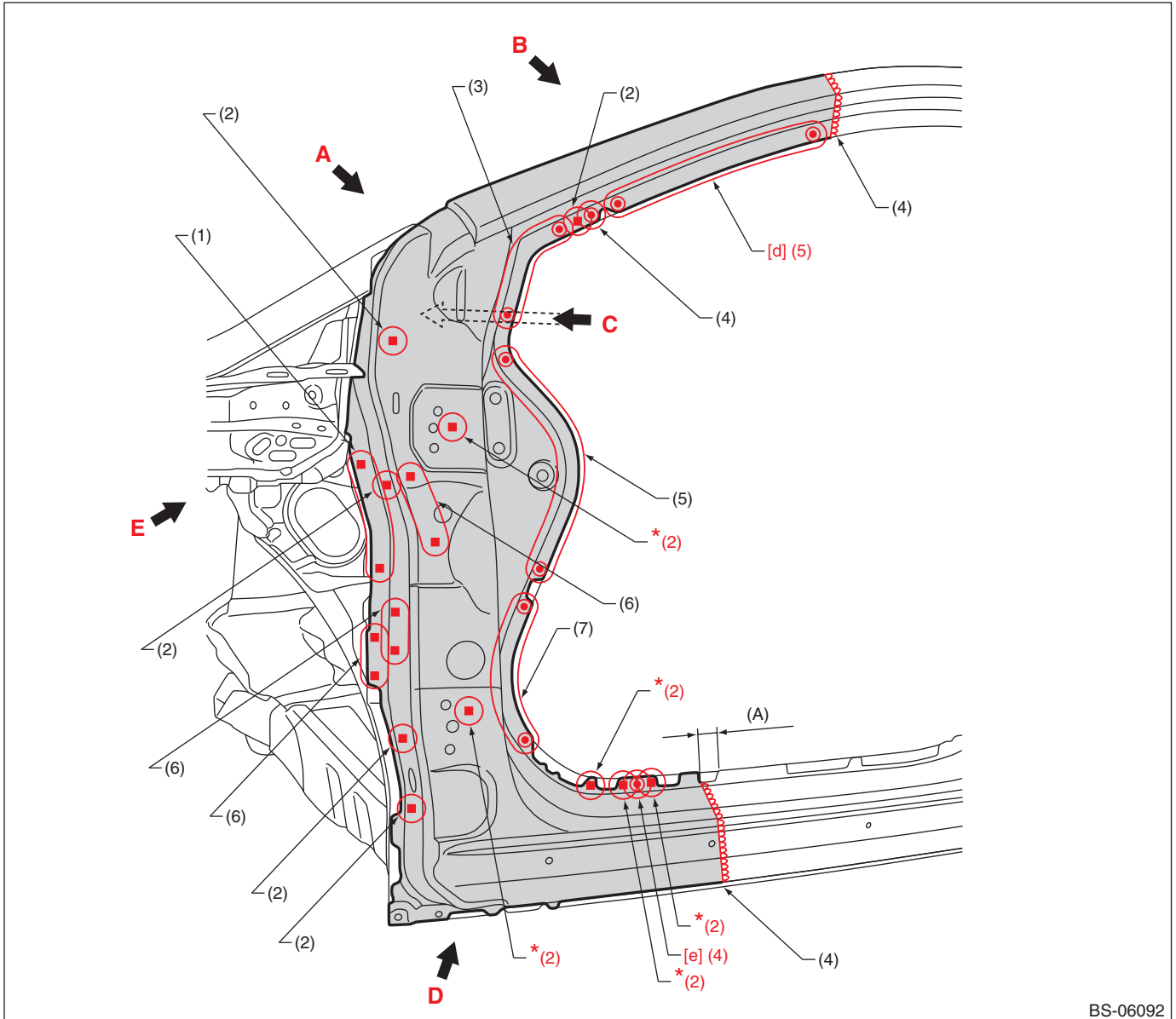
(5) 3 points (outside · 1)

Note: Designations in the RH diagram are the same as in the LH diagram, except for the indicated points.

Panel Replacement

B: INSTALLATION

• Overall view



BS-06092

(A) 25 mm (0.98 in)

(1) 4 points (service)

(4) 1 point

(7) 7 points (only LH)
4 points (only RH)

(2) 1 point (service)

(5) 8 points

(3) 4 points

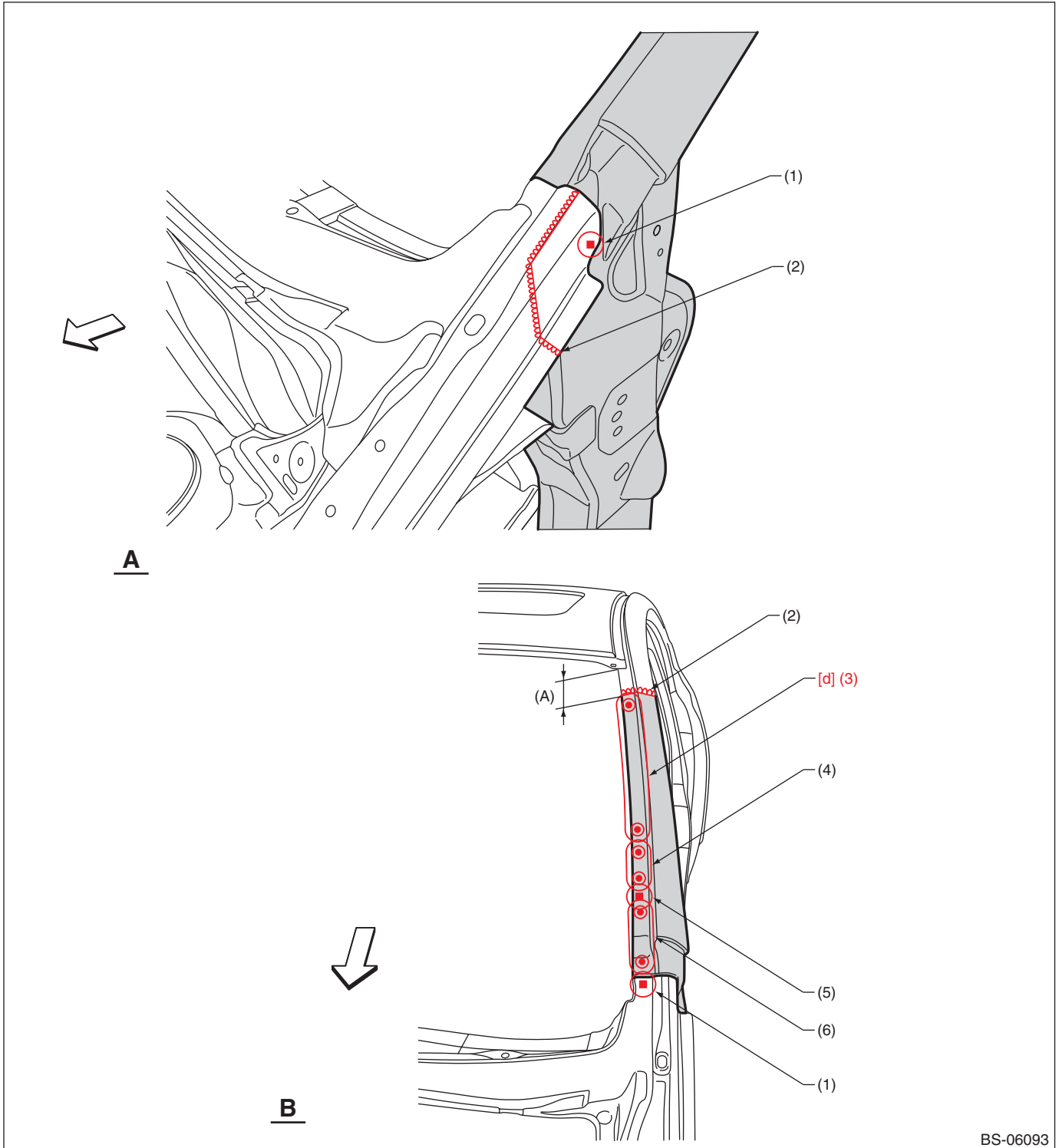
(6) 2 points (service)

[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

*: When plug welding a high-tensile steel sheet of 980 MPa Class or more, refer to "NOTE, Foreword" on page 7.

Panel Replacement

• Views 1



(A) 60 mm (2.36 in)

(1) 1 point (service · matching)

(3) 9 points

(5) 1 point (service)

(2) 1 point

(4) 2 points

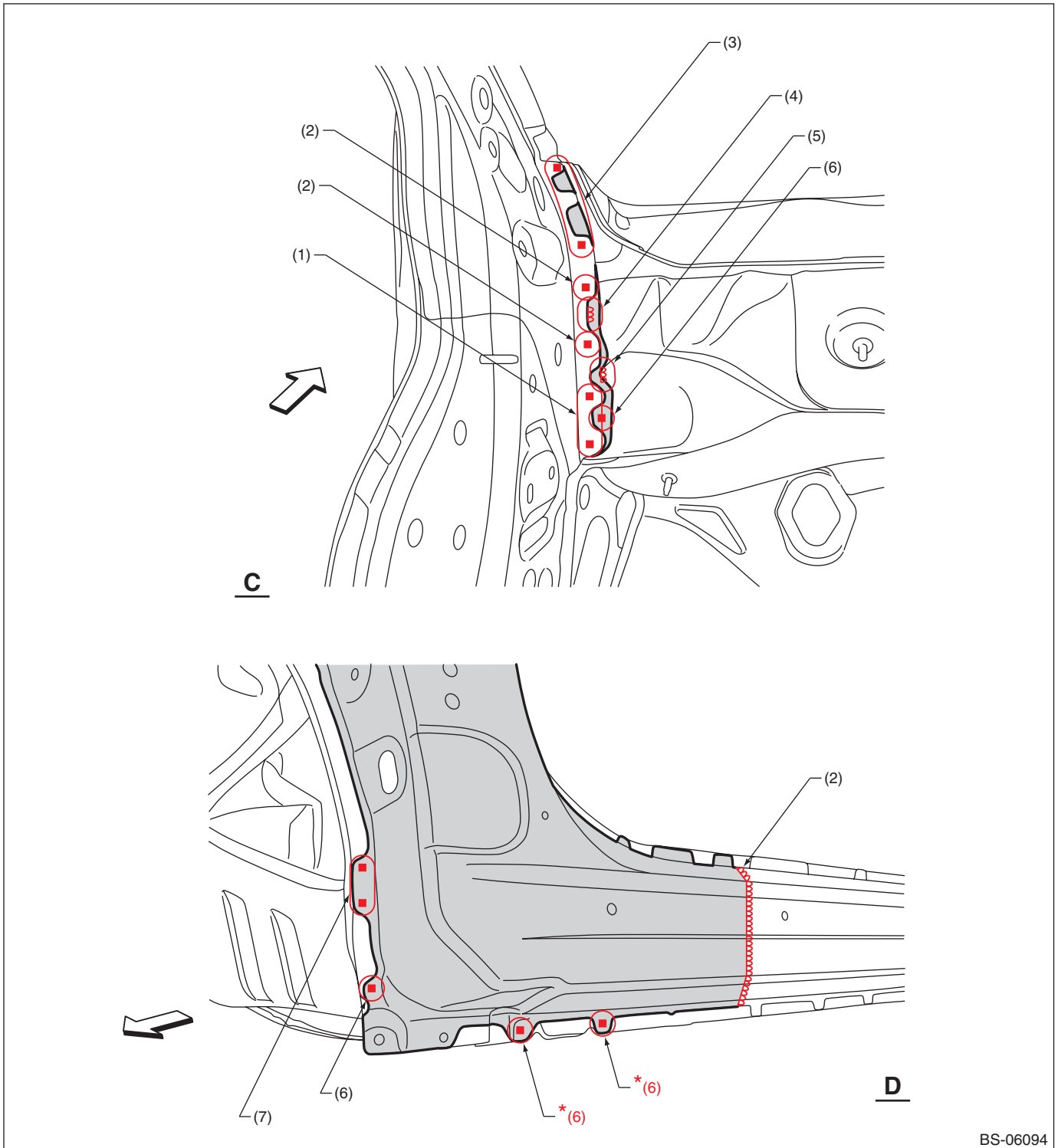
(6) 3 points

[d] Spot welding conditions

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

Panel Replacement

• Views 2



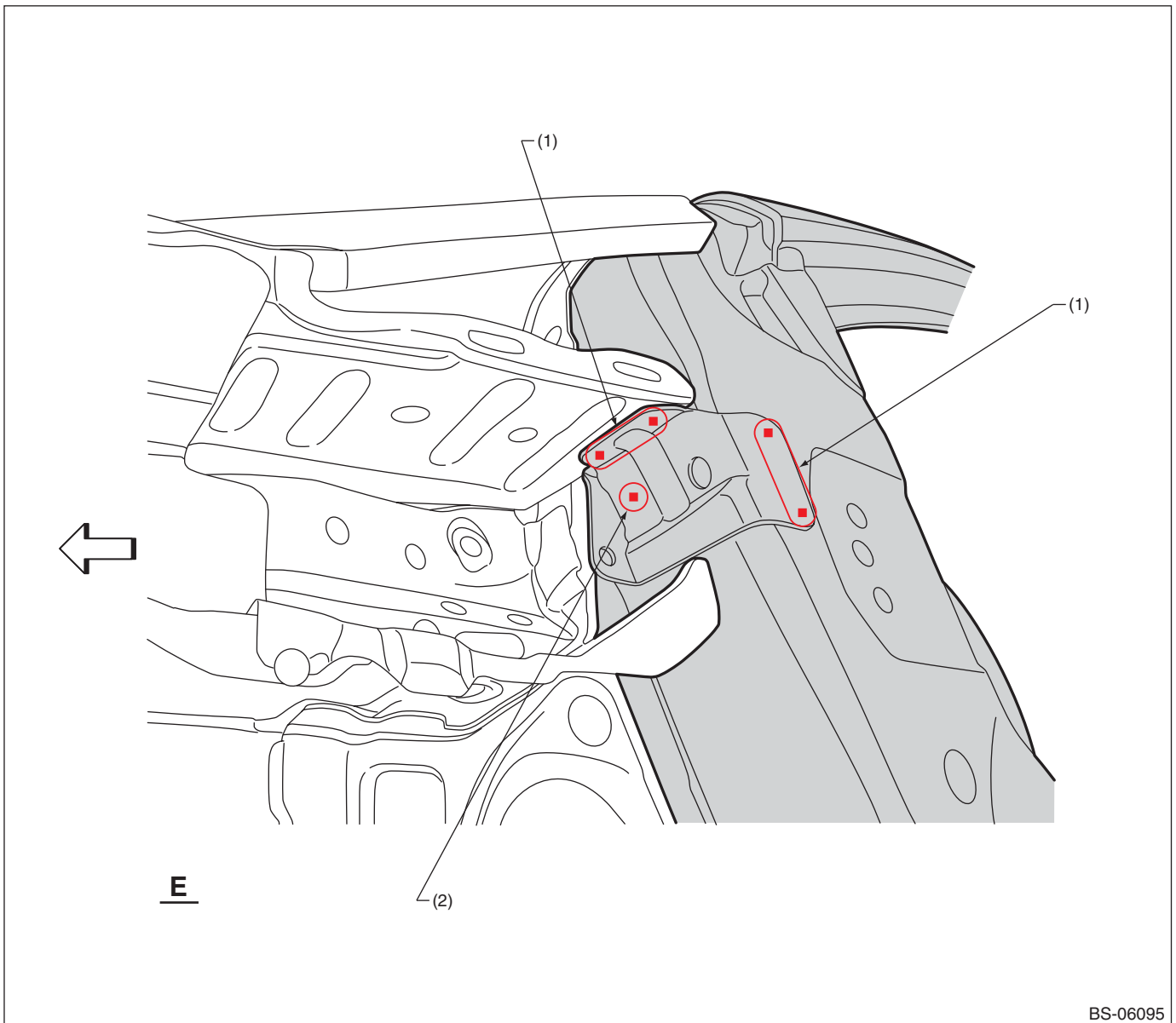
BS-06094

- | | | |
|--------------|-------------------------------|------------------------|
| (1) 2 points | (4) 1 point [15 mm (0.59 in)] | (7) 2 points (service) |
| (2) 1 point | (5) 1 point [10 mm (0.39 in)] | |
| (3) 3 points | (6) 1 point (service) | |

*: When plug welding a high-tensile steel sheet of 980 MPa Class or more, refer to "NOTE, Foreword" on page 7.

Panel Replacement

• Views 3

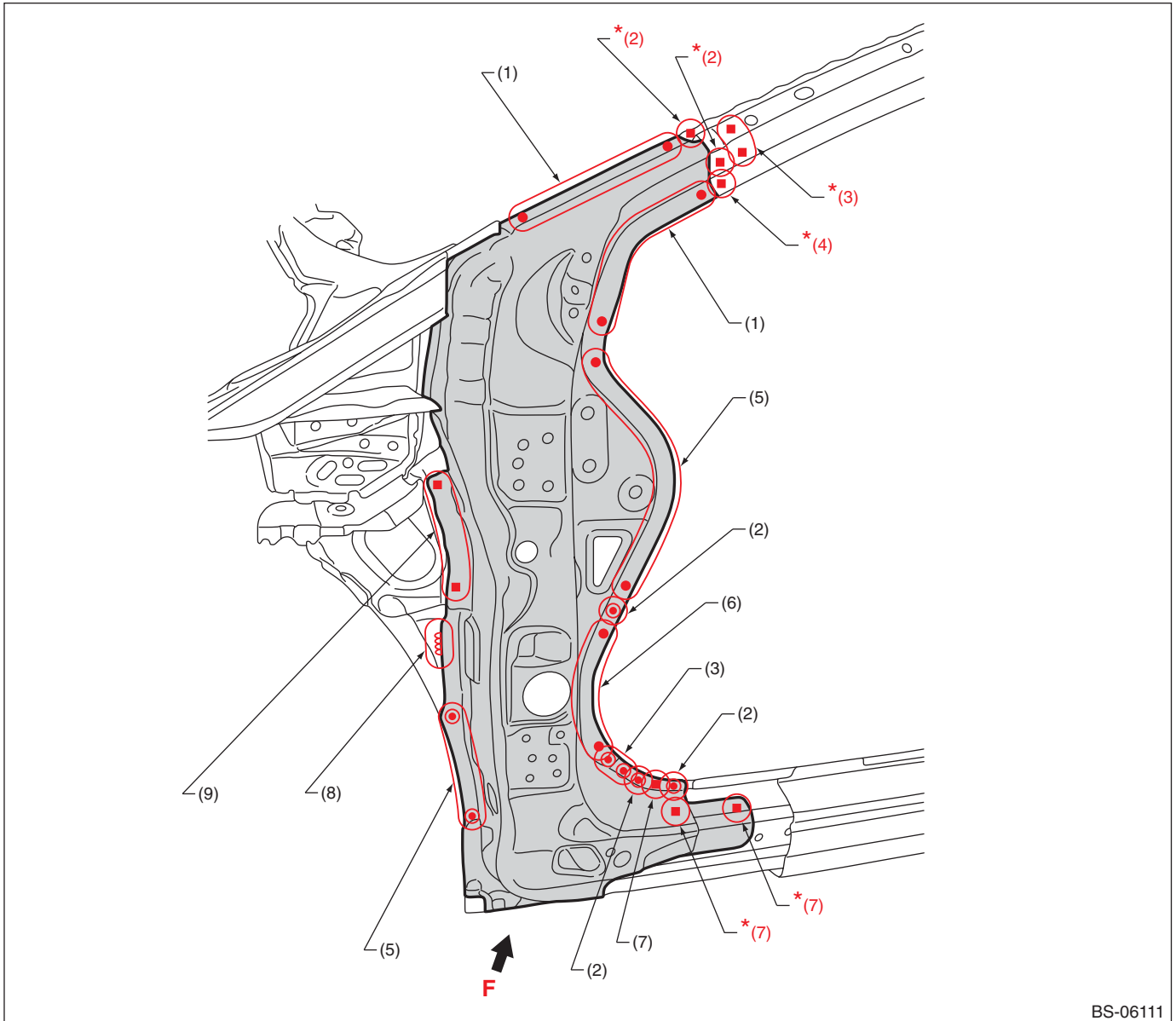


(1) 2 points (service)

(2) 1 point (service)

Panel Replacement

• Overall view (LH)

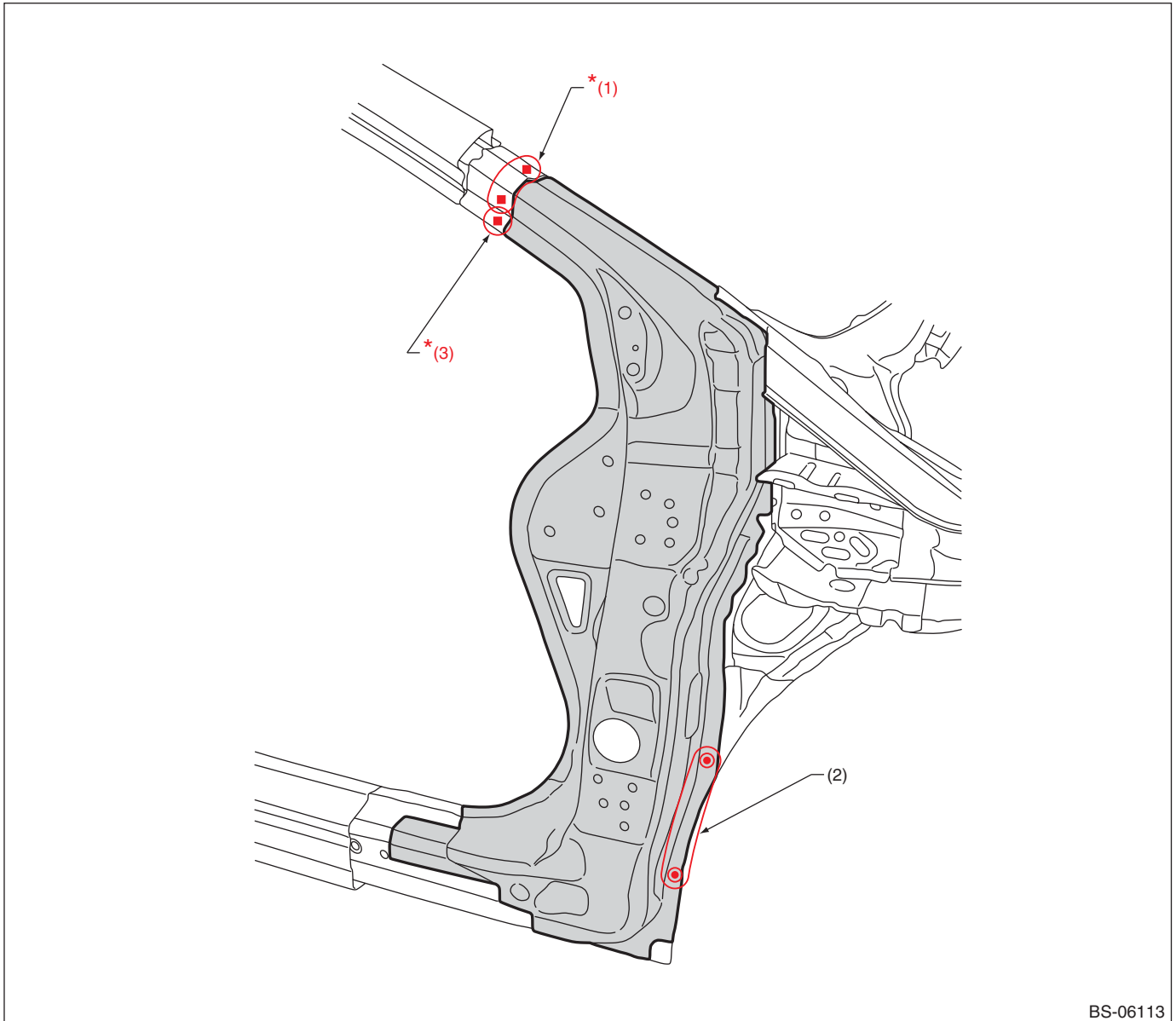


- | | | |
|--------------|--|-------------------------------|
| (1) 5 points | (4) 1 point (service · matching) | (7) 1 point (service) |
| (2) 1 point | (5) 8 points | (8) 1 point [25 mm (0.98 in)] |
| (3) 2 points | (6) 7 points (only LH)
4 points (only RH) | (9) 4 points (service) |

*: When plug welding a high-tensile steel sheet of 980 MPa Class or more, refer to "NOTE, Foreword" on page 7.

Panel Replacement

- (RH)



(1) 3 points

(2) 5 points

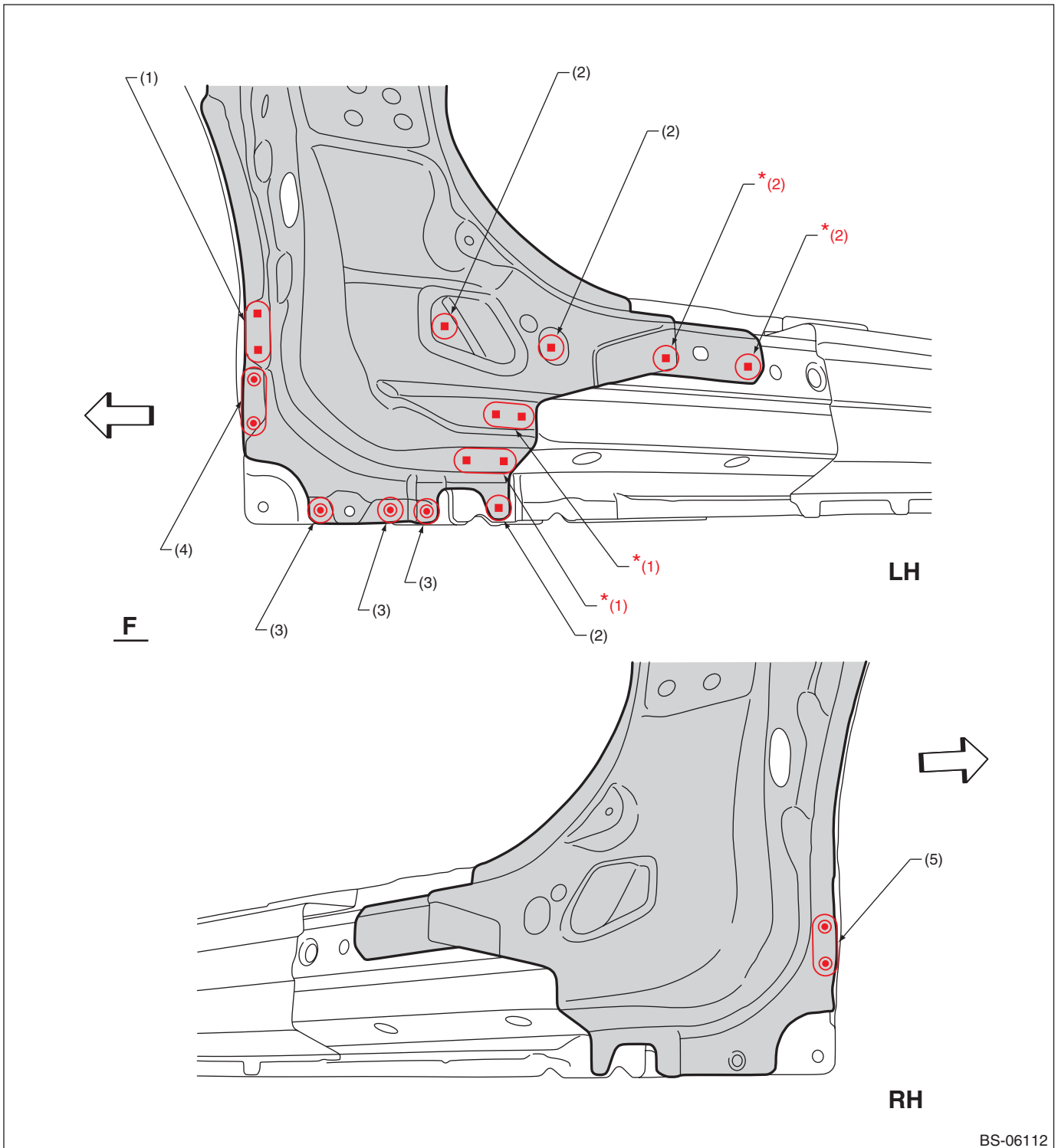
(3) 1 point (service · matching)

Note: Designations in the RH diagram are the same as in the LH diagram, except for the indicated points.

*: When plug welding a high-tensile steel sheet of 980 MPa Class or more, refer to "NOTE, Foreword" on page 7.

Panel Replacement

• Views



BS-06112

(1) 2 points (service)

(2) 1 point (service)

(3) 1 point

(4) 3 points

(5) 2 points

Note: Designations in the RH diagram are the same as in the LH diagram, except for the indicated points.

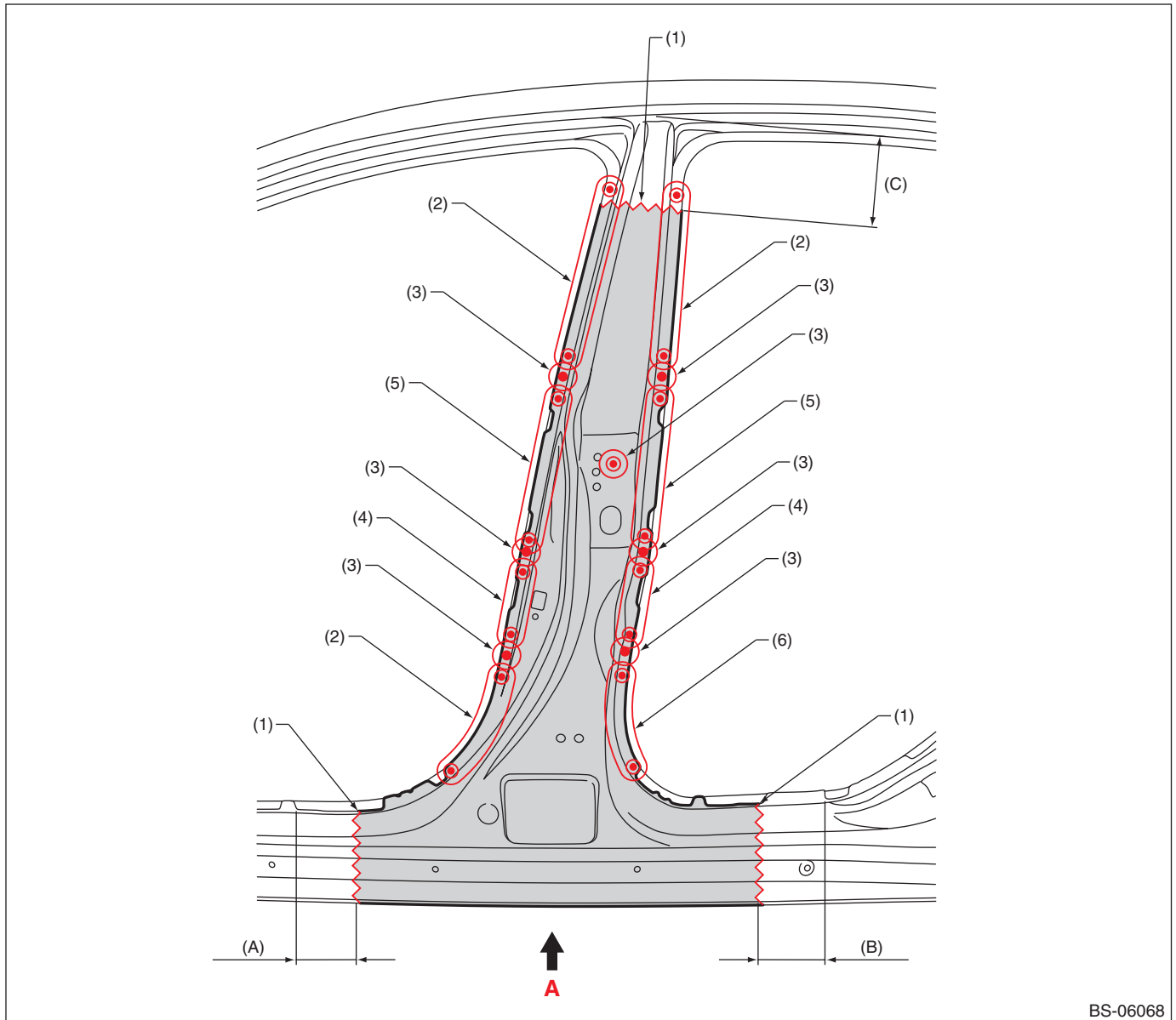
*: When plug welding a high-tensile steel sheet of 980 MPa Class or more, refer to "NOTE, Foreword" on page 7.

Panel Replacement

7-8. Center Pillar (partial replacement)

A: REMOVAL

• Overall view



BS-06068

(A) 100 mm (3.94 in)

(B) 110 mm (4.33 in)

(C) 140 mm (5.51 in)

(1) Rough cutting

(3) 1 point (outside · 1)

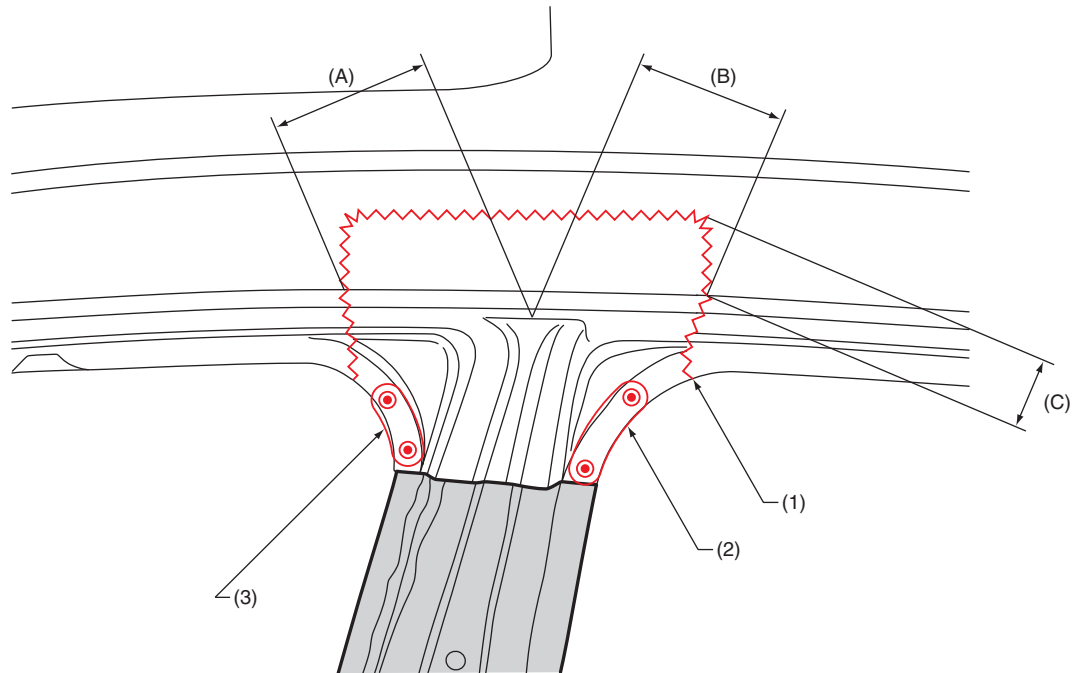
(5) 5 points (outside · 1)

(2) 7 points (outside · 1)

(4) 3 points (outside · 1)

(6) 6 points (outside · 1)

Panel Replacement



BS-06191

(A) 100 mm (3.94 in)

(B) 90 mm (3.54 in)

(C) 50 mm (1.97 in)

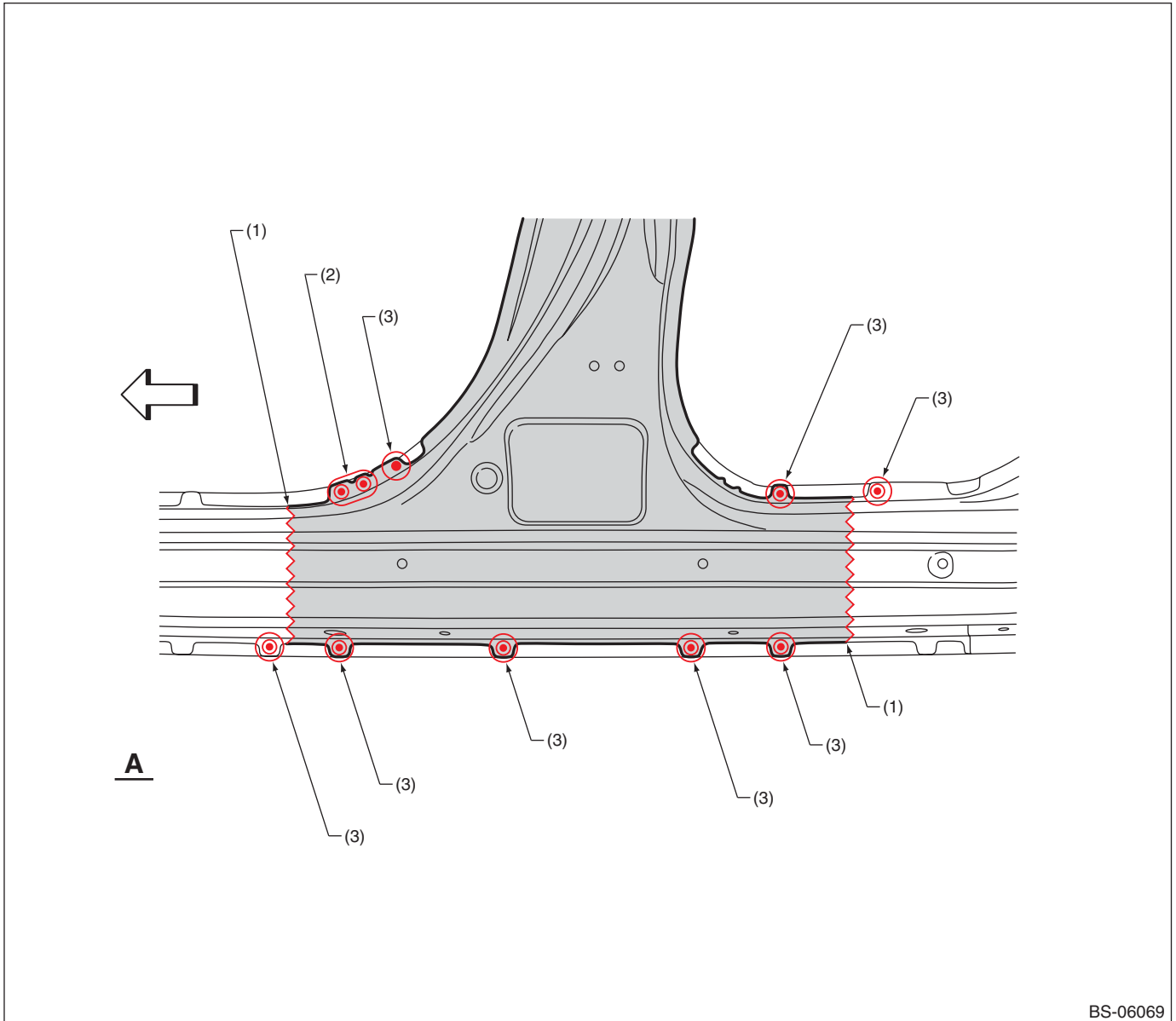
(1) Rough cutting

(2) 3 points (outside · 1)

(3) 2 points (outside · 1)

Panel Replacement

• Views



BS-06069

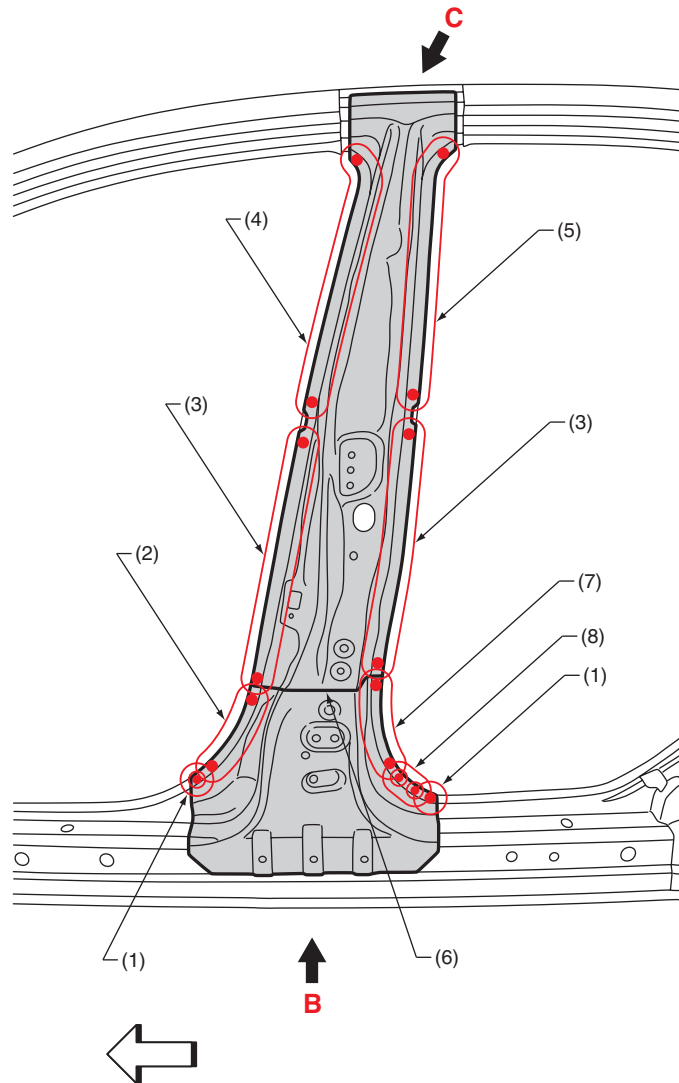
(1) Rough cutting

(2) 2 points (outside · 1)

(3) 1 point (outside · 1)

Panel Replacement

• Overall view



BS-06114

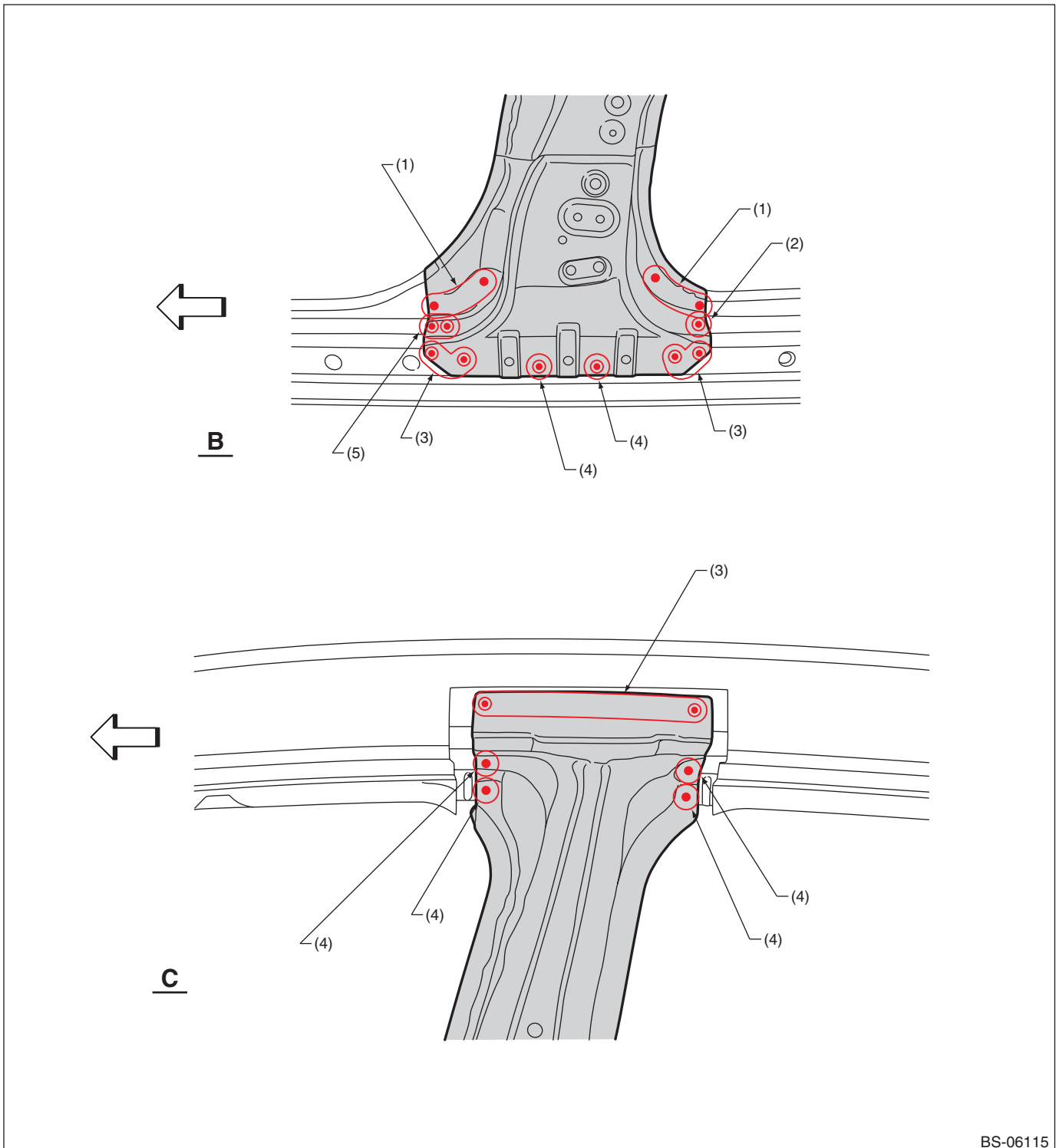
- (1) 1 point (outside · 1)
- (2) 6 points (outside · 1)
- (3) 8 points (outside · 1)

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

- (7) 5 points (outside · 1)
- (8) 2 points (outside · 1)

Panel Replacement

• Views



BS-06115

(1) 4 points (outside · 1)

(2) 1 point (top · 1)

(3) 3 points (outside · 1)

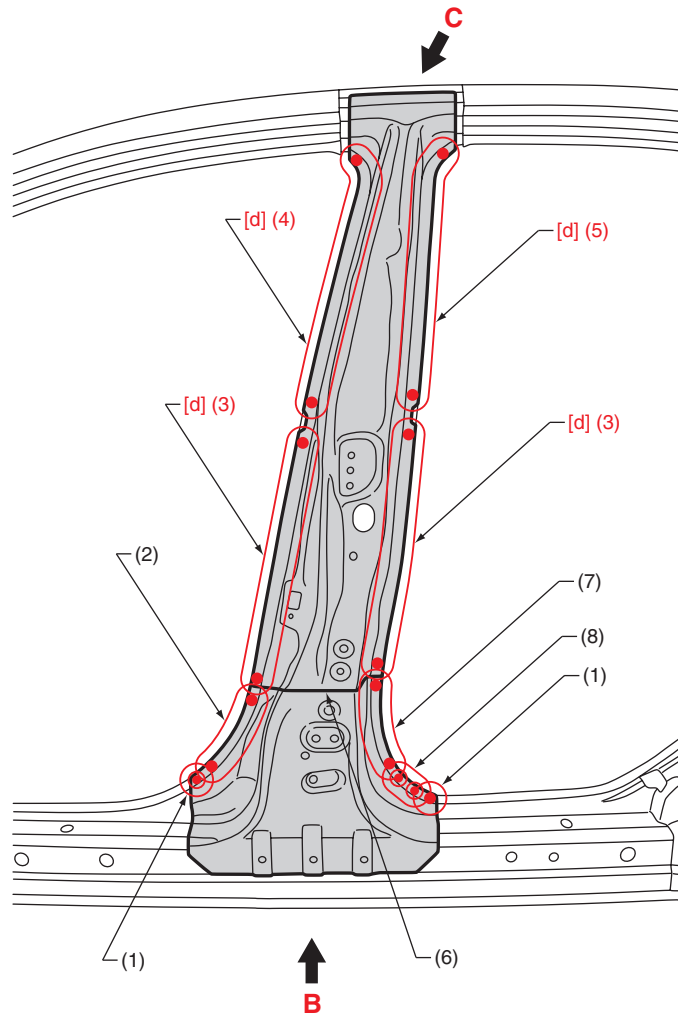
(4) 1 point (outside · 1)

(5) 2 points (top · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BS-06116

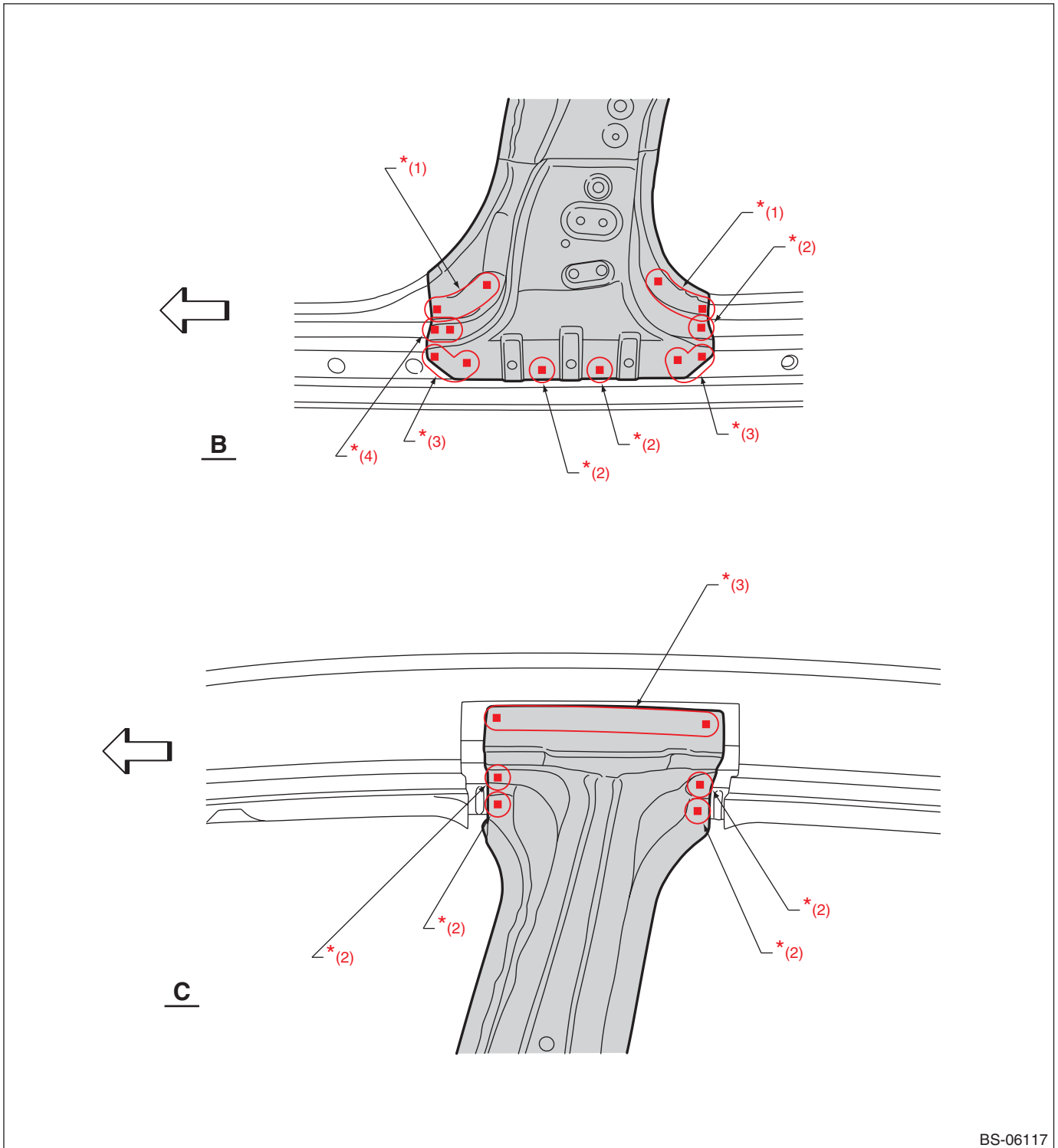
(1) 1 point	(4) 10 points	(7) 5 points
(2) 6 points	(5) 11 point	(8) 2 points
(3) 8 points	(6) Tailored line	

[d] Spot welding conditions

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

Panel Replacement

• Views



BS-06117

(1) 4 points (service)

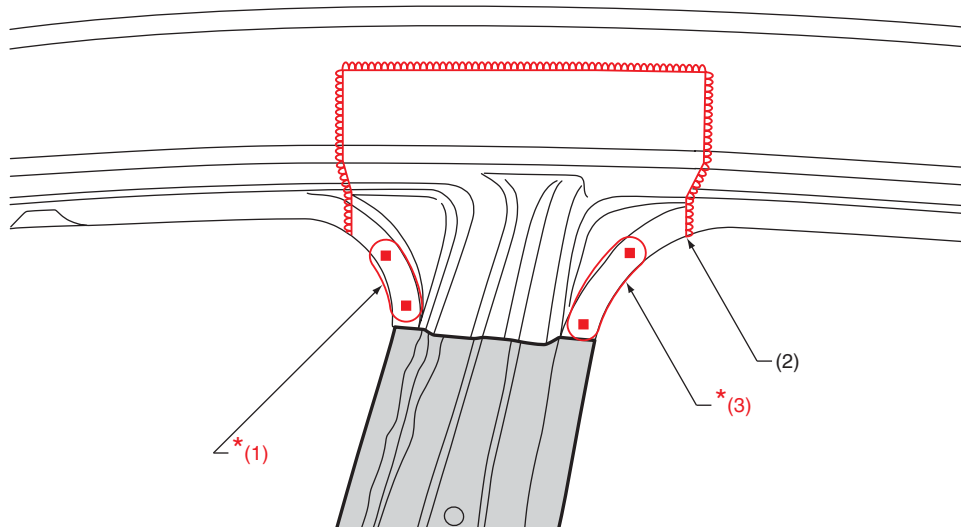
(3) 3 points (service)

(4) 2 points (service)

(2) 1 point (service)

*: When plug welding a high-tensile steel sheet of 980 MPa Class or more, refer to "NOTE, Foreword" on page 7.

Panel Replacement



BS-06192

(1) 2 points

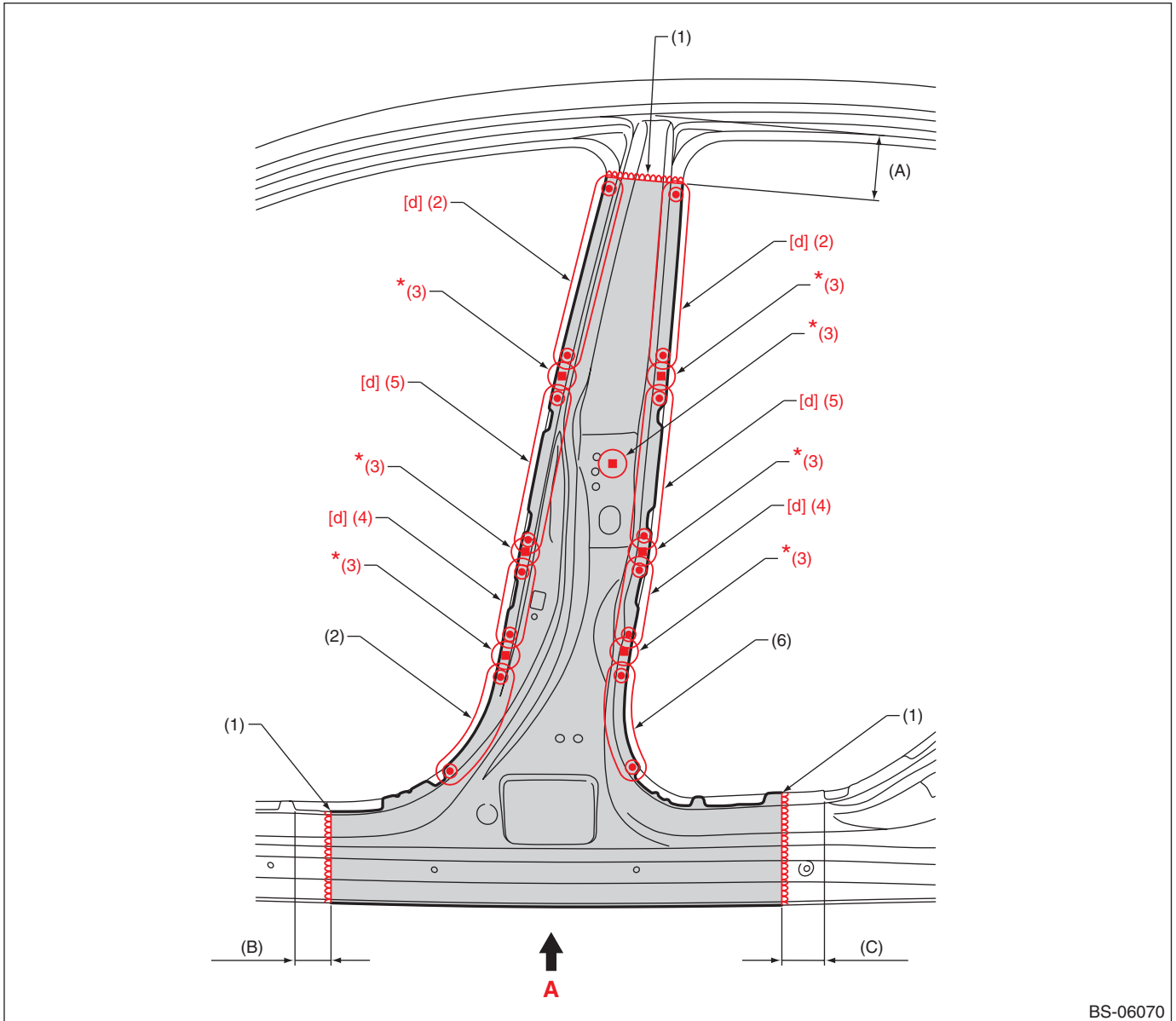
(2) 1 point

(3) 3 points

^{*}: When plug welding a high-tensile steel sheet of 980 MPa Class or more, refer to "NOTE, Foreword" on page 7.

Panel Replacement

• Overall view



(A) 100 mm (3.94 in)

(B) 60 mm (2.36 in)

(C) 70 mm (2.76 in)

(1) 1 point

(3) 1 point (service)

(5) 5 points

(2) 7 points

(4) 3 points

(6) 6 points

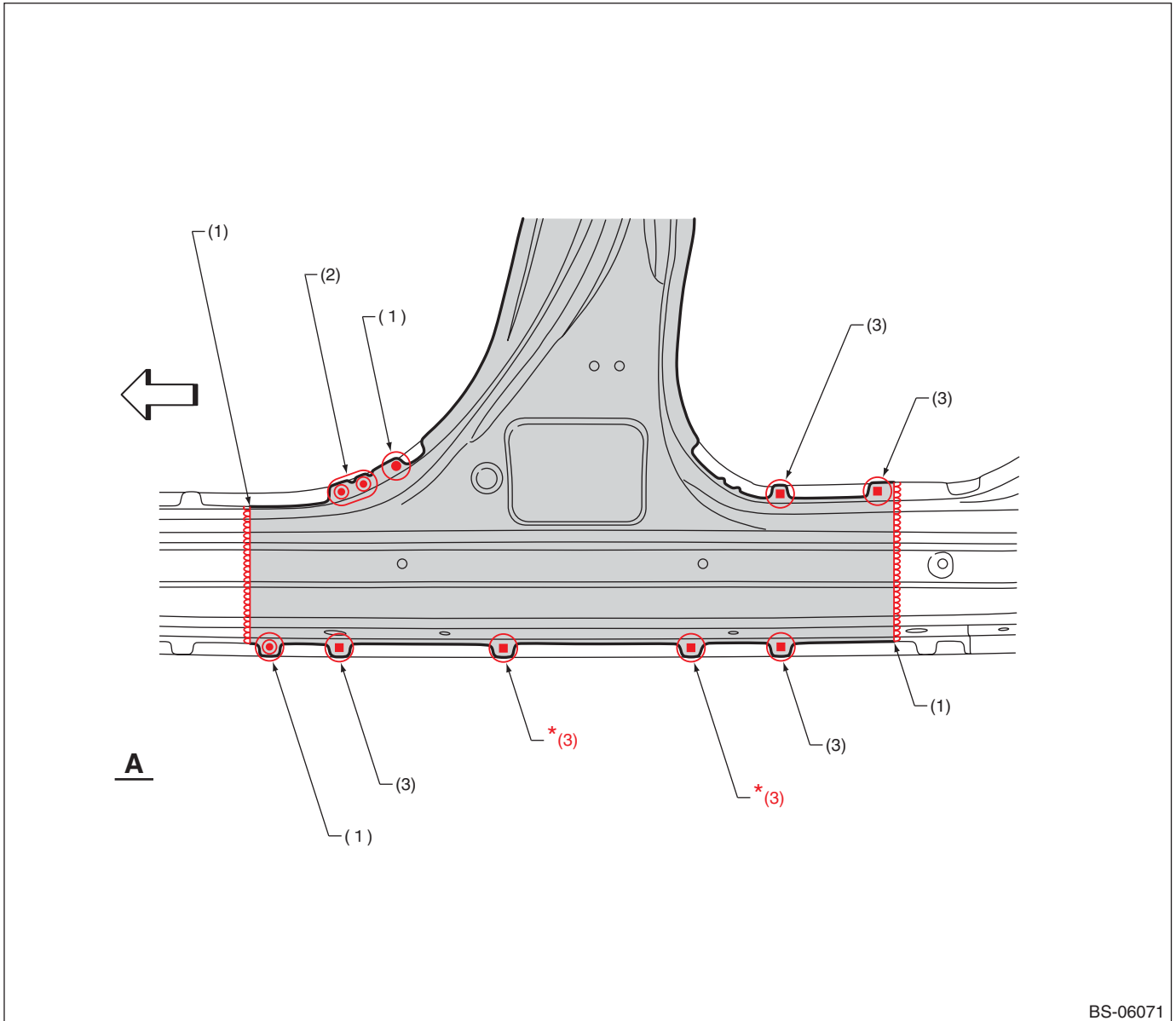
[d] Spot welding conditions

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

*: When plug welding a high-tensile steel sheet of 980 MPa Class or more, refer to "NOTE, Foreword" on page 7.

Panel Replacement

• Views



(1) 1 point

(2) 2 points

(3) 1 point (service)

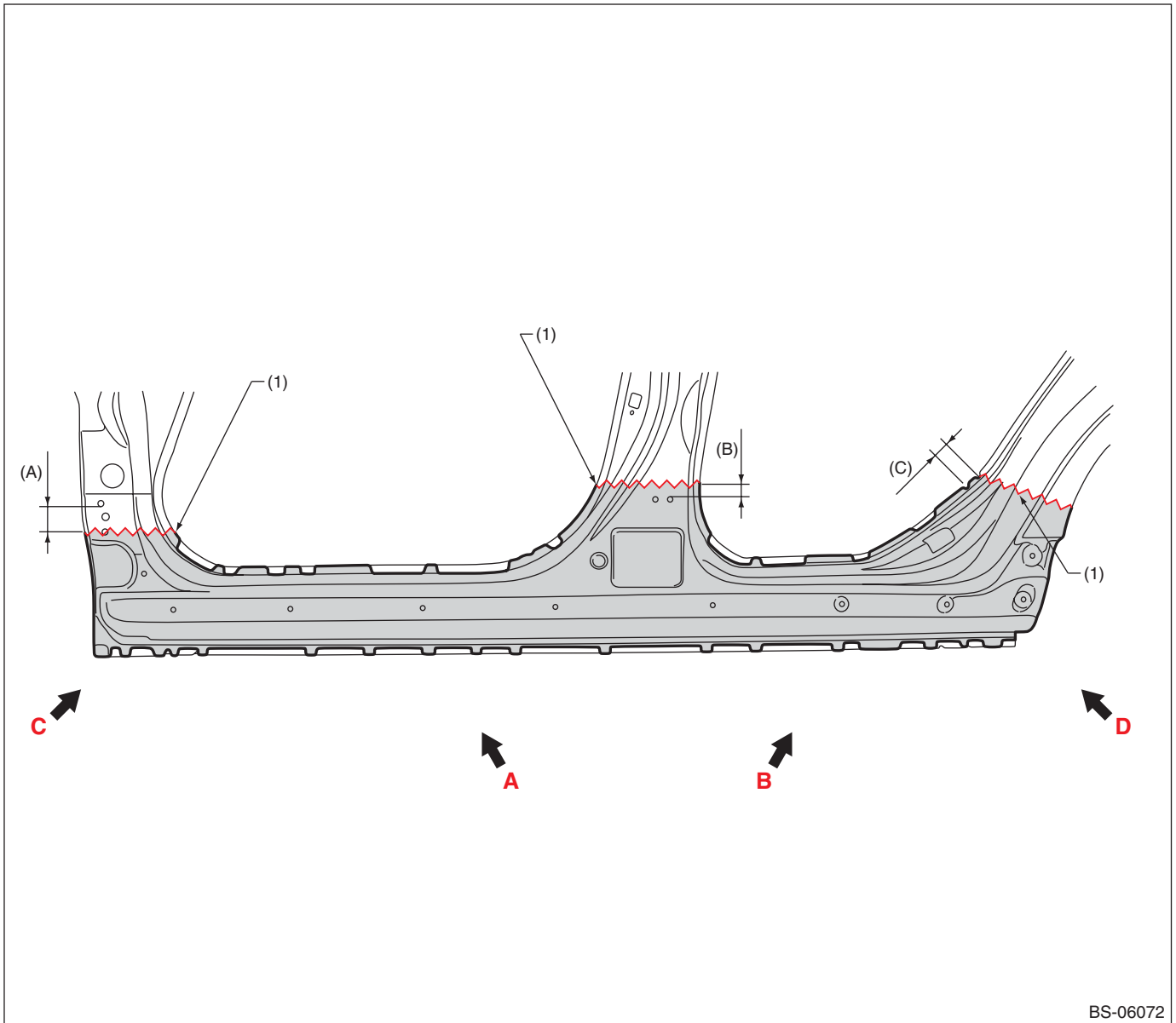
*: When plug welding a high-tensile steel sheet of 980 MPa Class or more, refer to "NOTE, Foreword" on page 7.

Panel Replacement

7-9. Side Sill (partial replacement)

A: REMOVAL

• Overall view



(A) 60 mm (2.36 in)

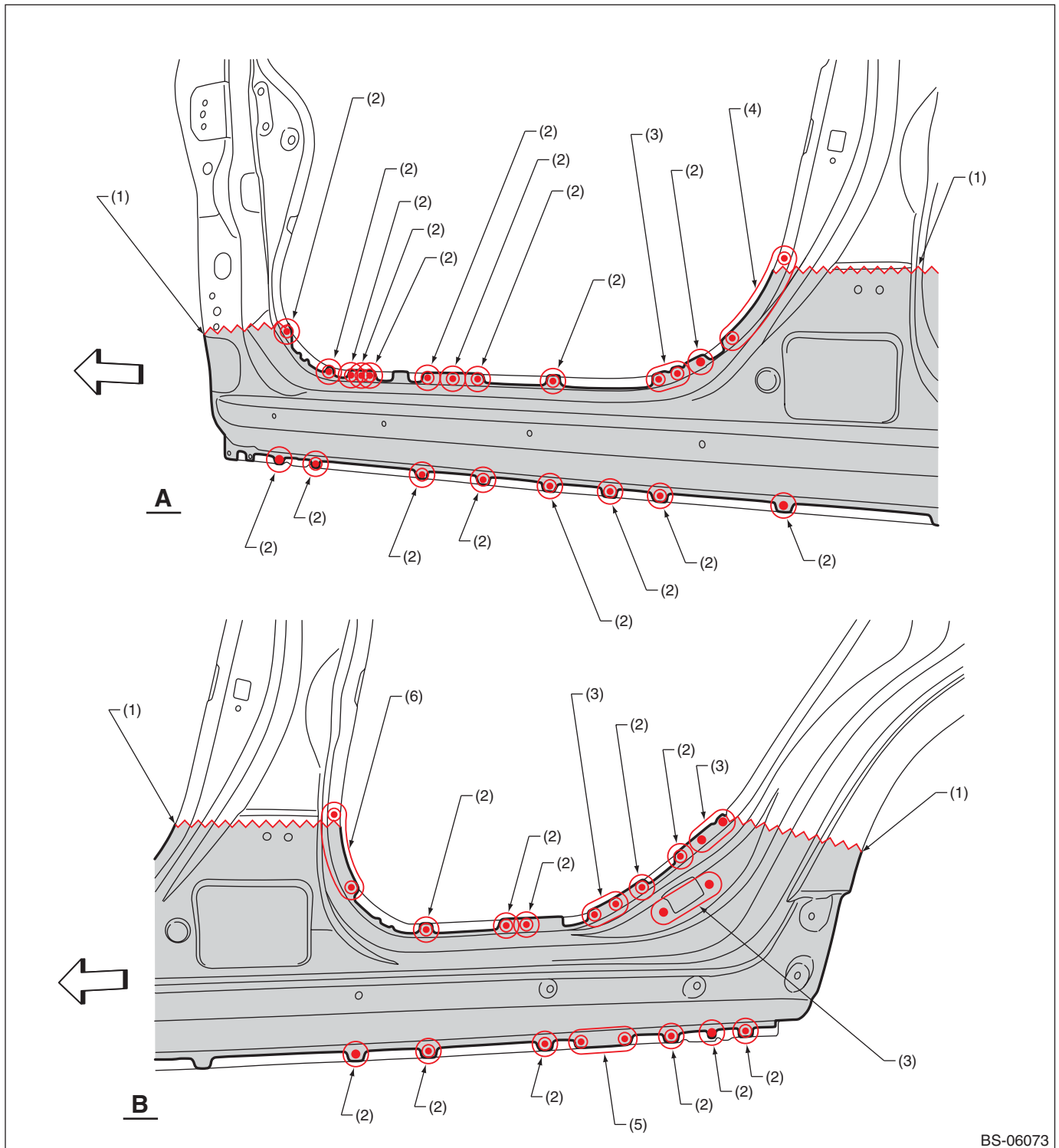
(B) 15 mm (0.59 in)

(C) 20 mm (0.79 in)

(1) Rough cutting

Panel Replacement

• Views 1

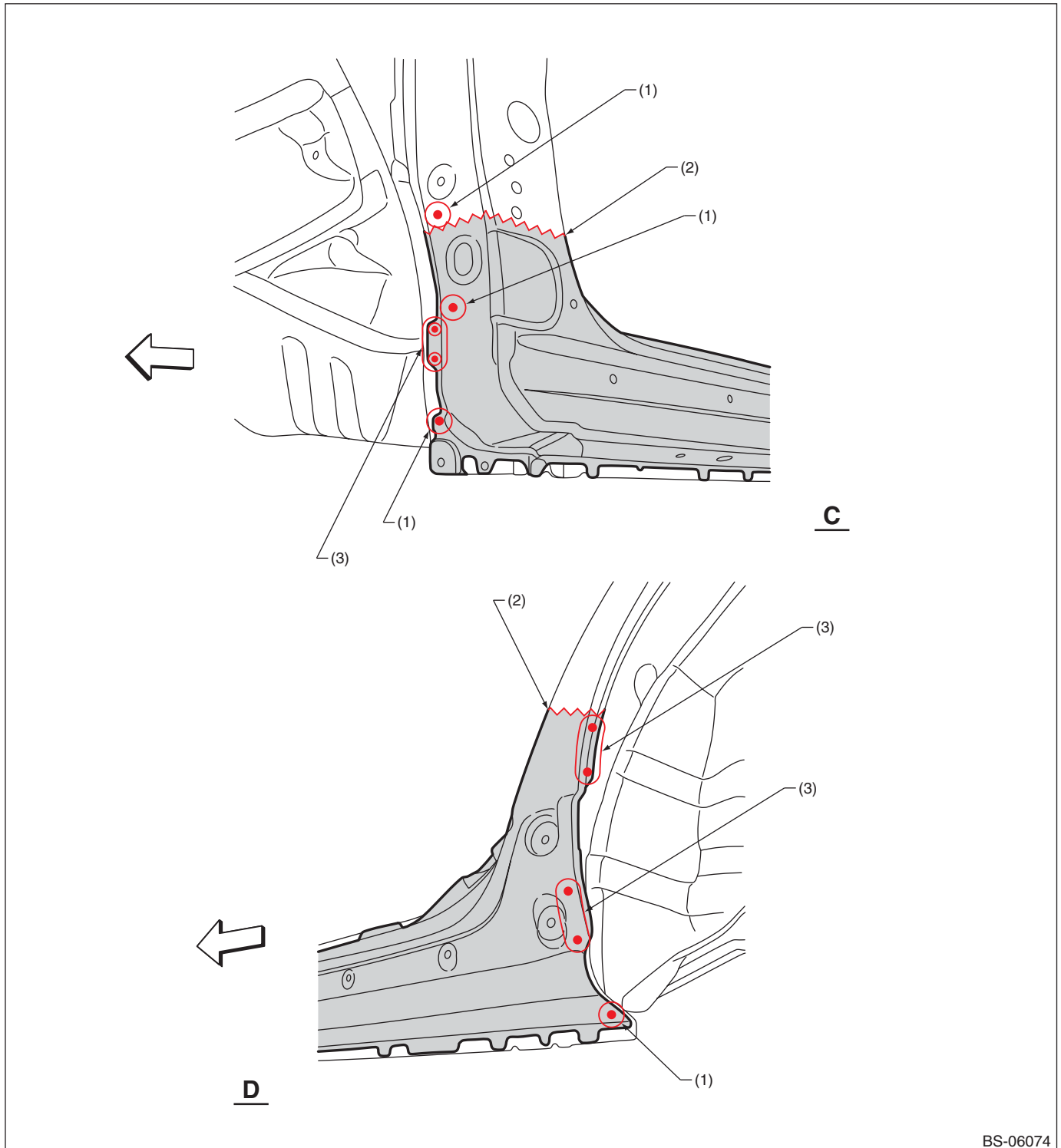


BS-06073

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

Panel Replacement

• Views 2



BS-06074

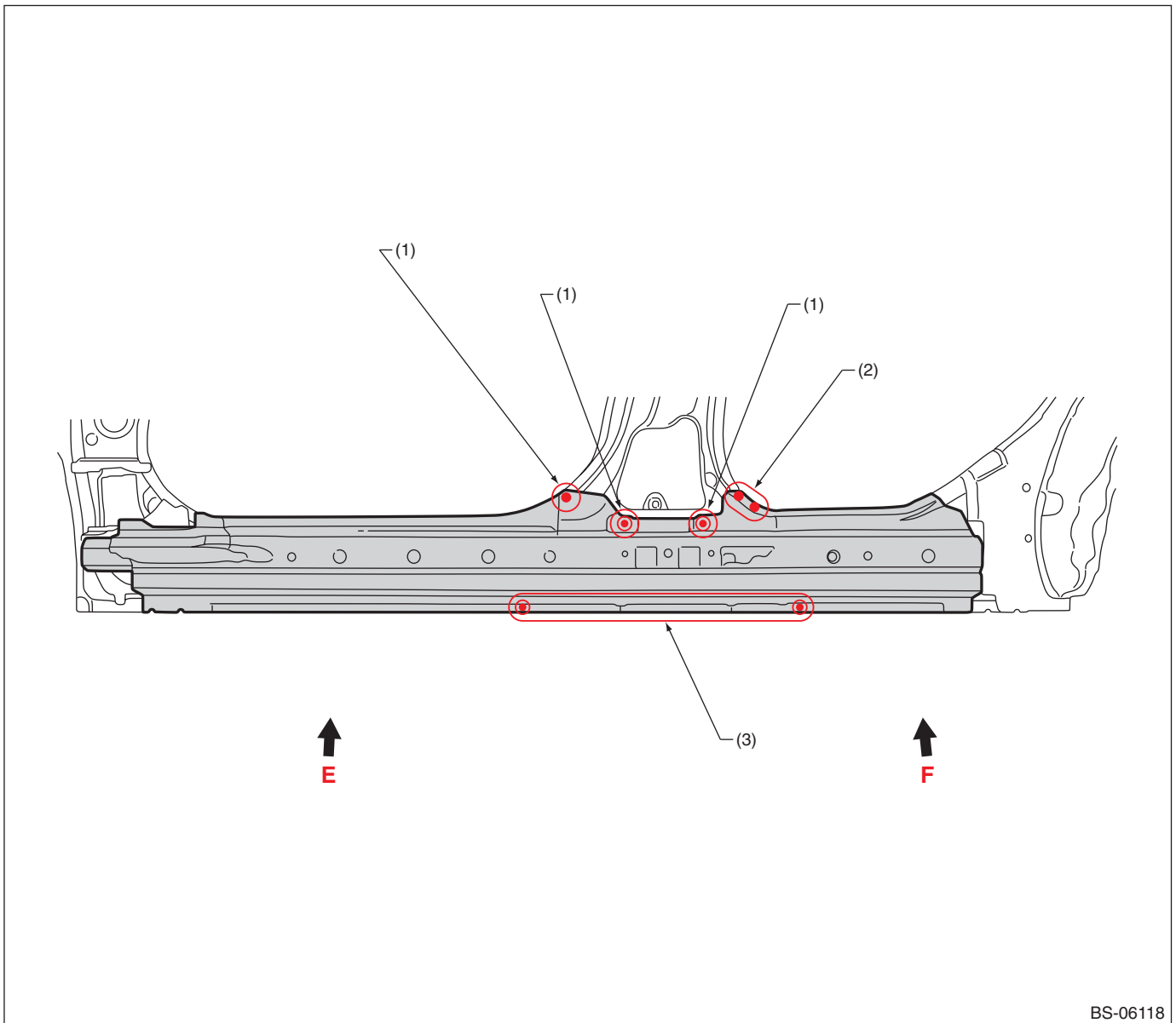
(1) 1 point (outside · 1)

(2) Rough cutting

(3) 2 points (outside · 1)

Panel Replacement

• Overall view



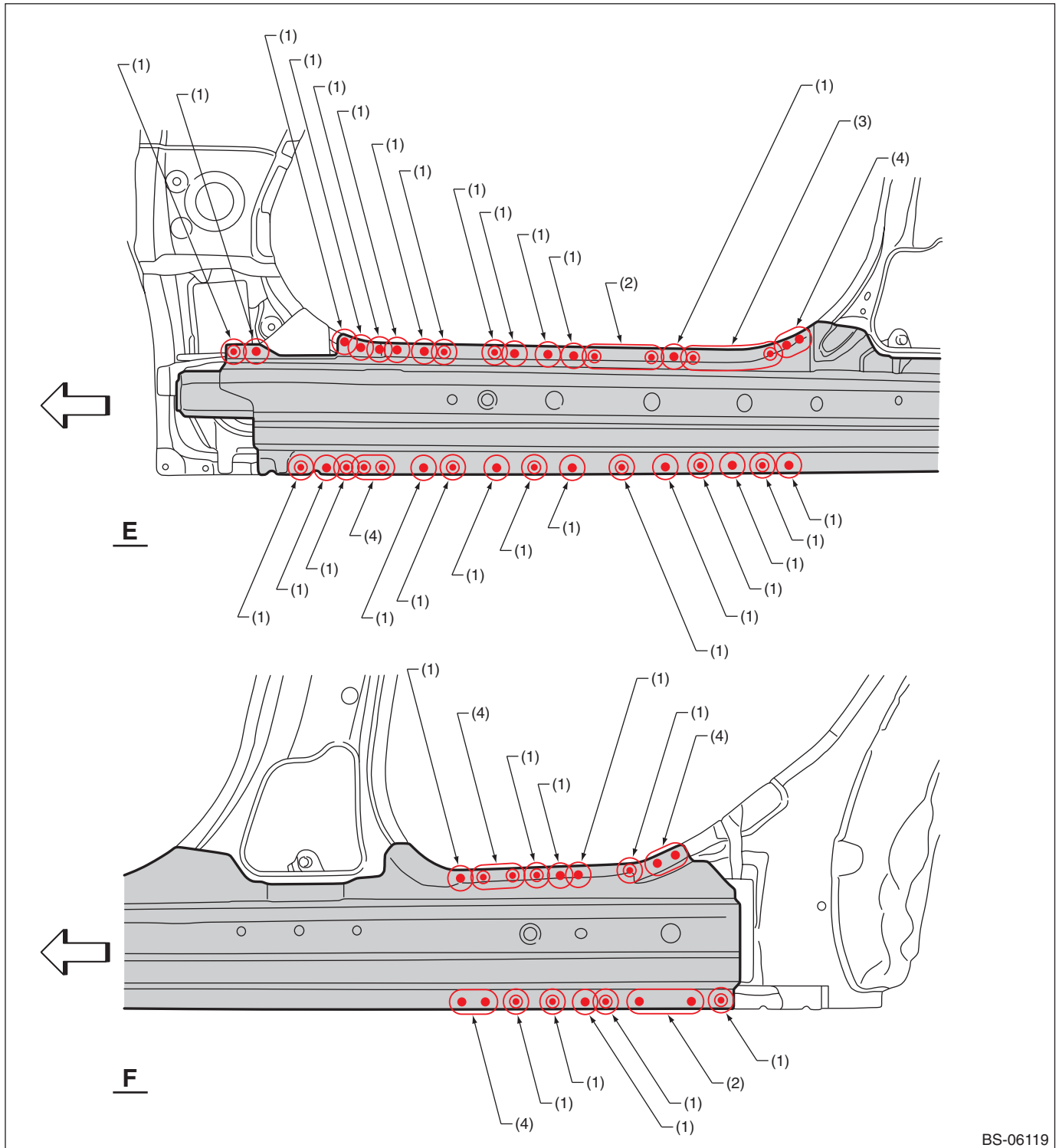
(1) 1 point (outside · 1)

(2) 2 points (outside · 1)

(3) 10 points (outside · 1)

Panel Replacement

• Views



BS-06119

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

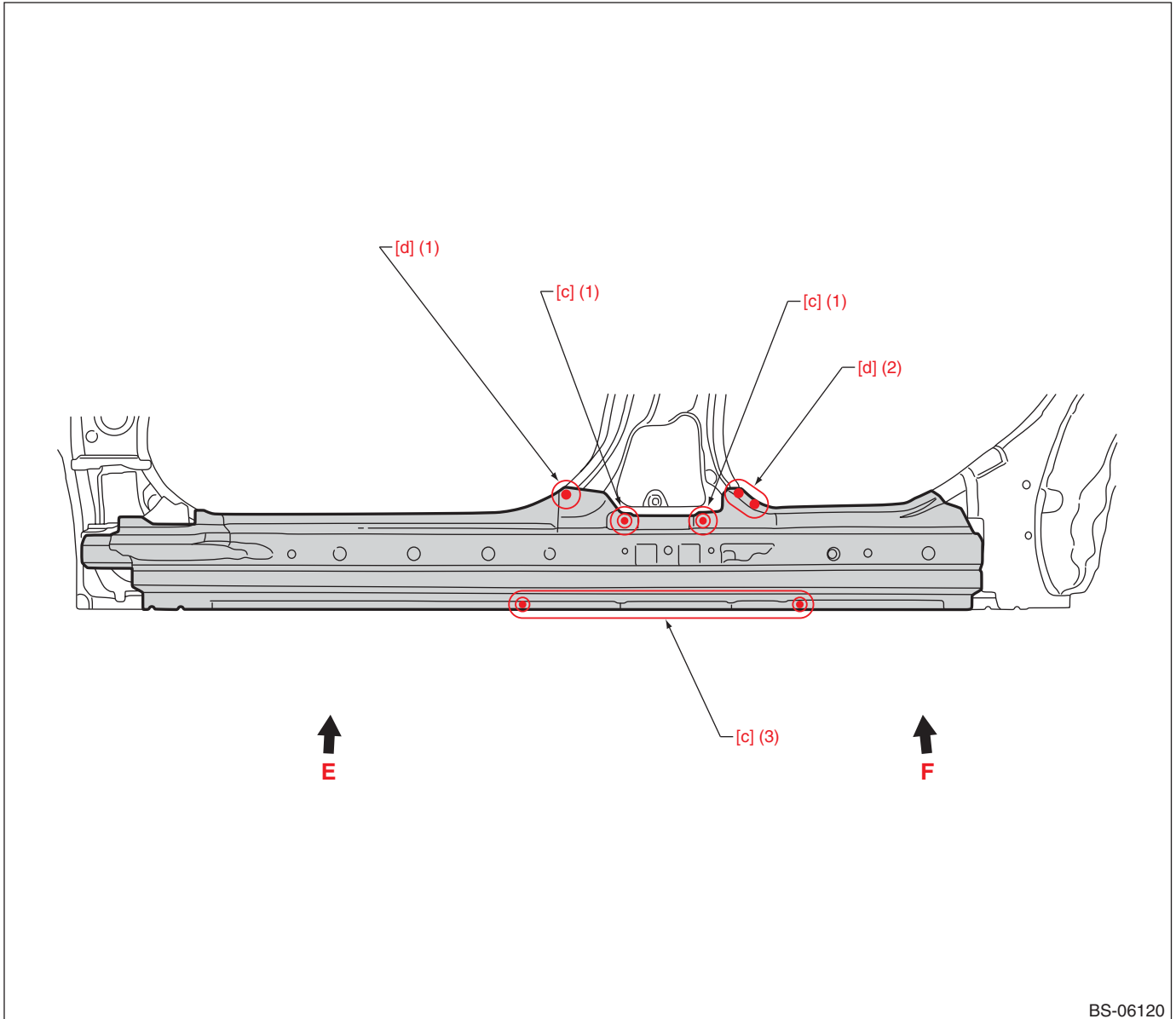
(3) 6 points (outside - 1)

(4) 2 points (outside - 1)

Panel Replacement

B: INSTALLATION

• Overall view



(1) 1 point

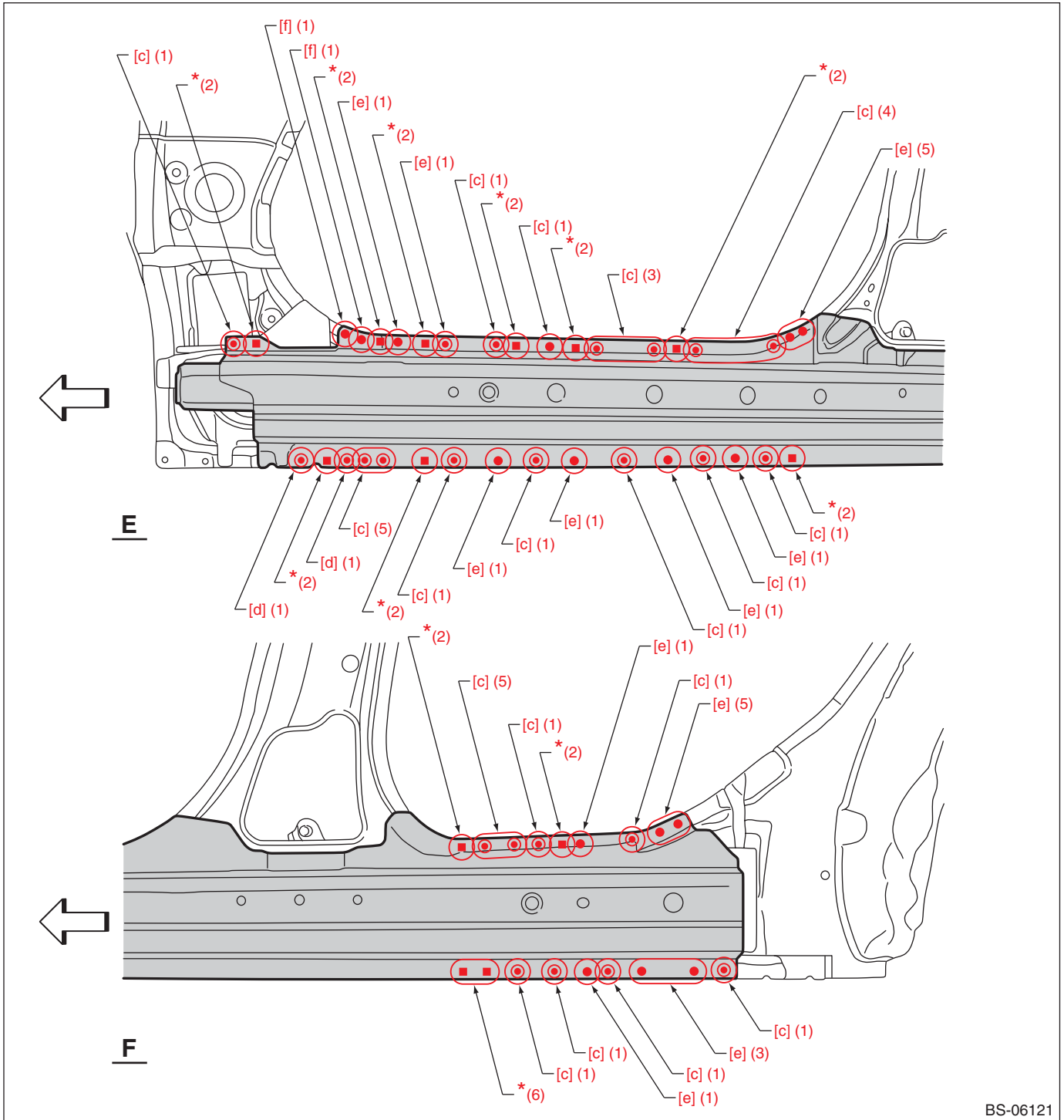
(2) 2 points

(3) 10 points

[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

Panel Replacement

• Views



BS-06121

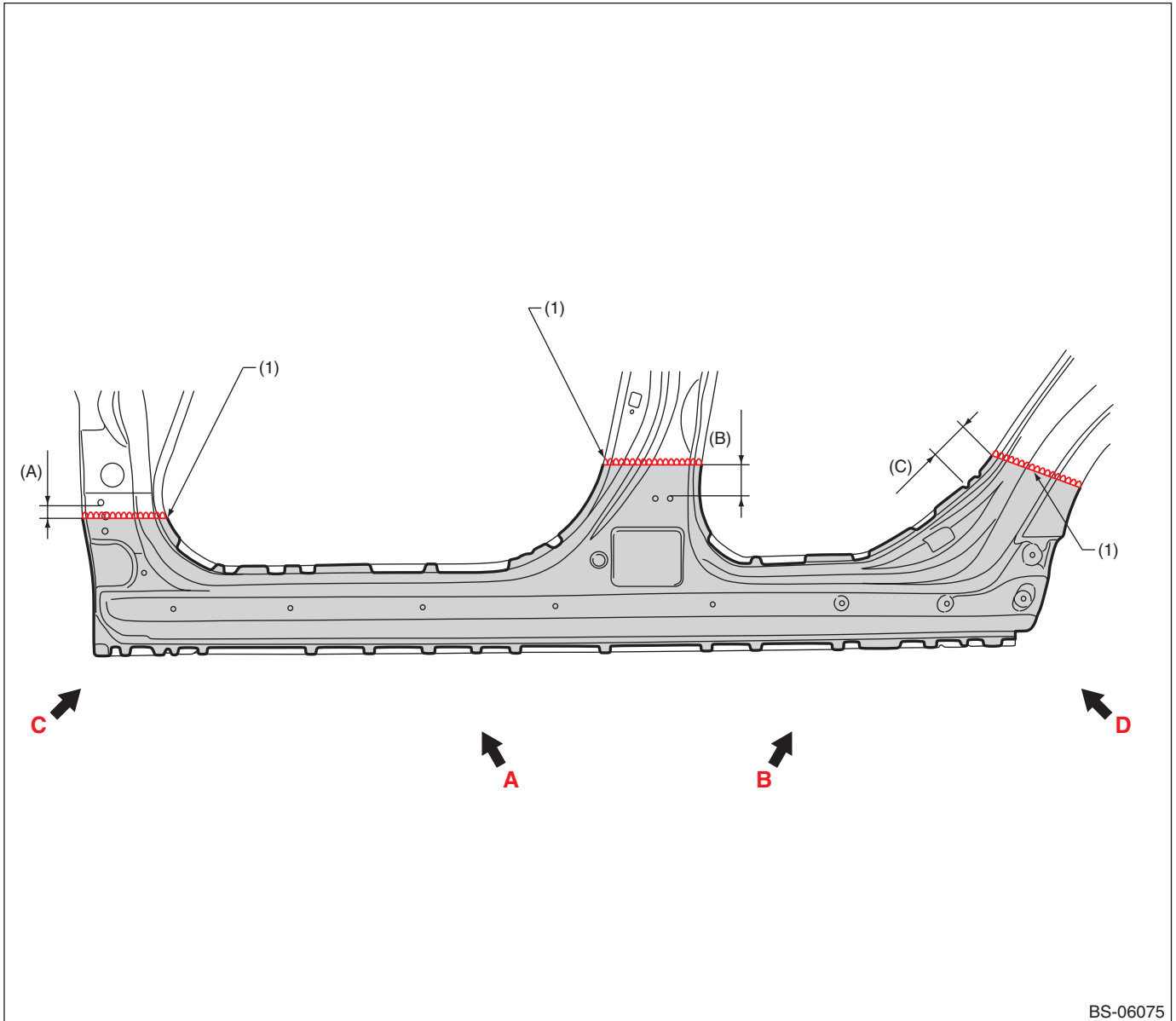
- | | | |
|-----------------------|--------------|------------------------|
| (1) 1 point | (3) 3 points | (5) 2 points |
| (2) 1 point (service) | (4) 6 points | (6) 2 points (service) |

[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

*: When plug welding a high-tensile steel sheet of 980 MPa Class or more, refer to "NOTE, Foreword" on page 7.

Panel Replacement

- Overall view



(A) 30 mm (1.18 in)

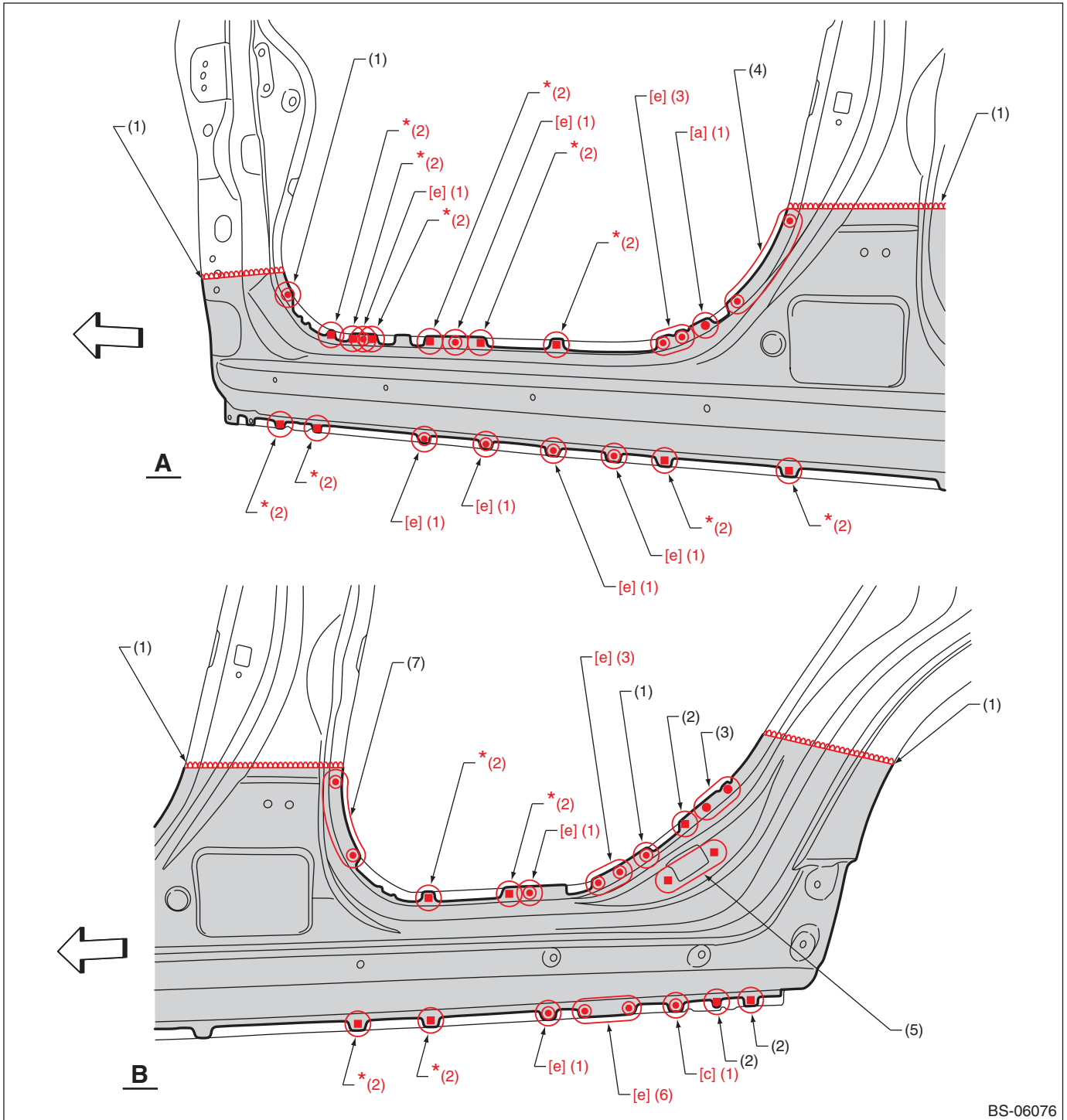
(B) 35 mm (1.38 in)

(C) 50 mm (1.97 in)

(1) 1 point

Panel Replacement

• Views 1



BS-06076

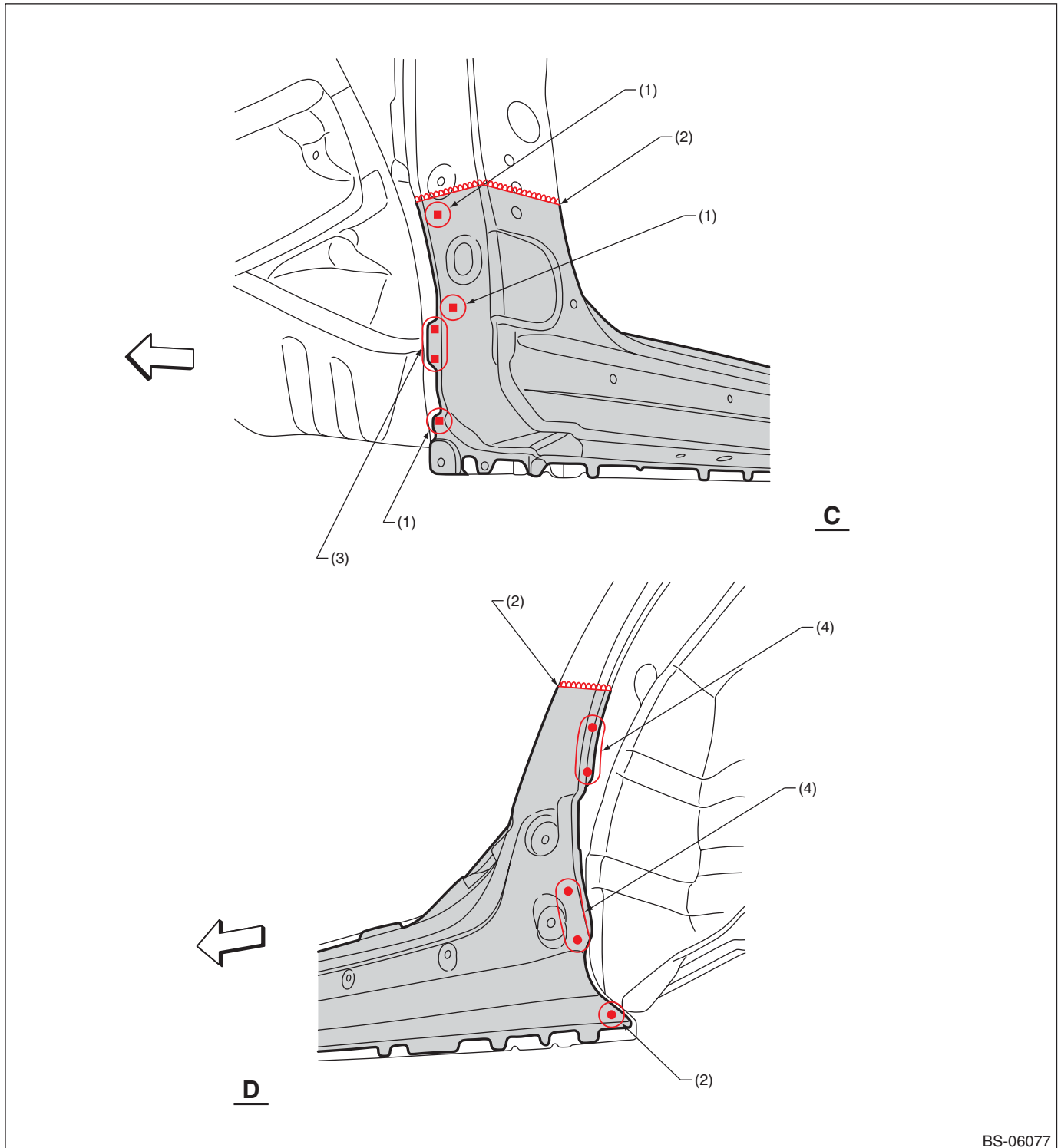
- | | | |
|-----------------------|------------------------|--------------|
| (1) 1 point | (4) 6 points | (7) 4 points |
| (2) 1 point (service) | (5) 2 points (service) | |
| (3) 2 points | (6) 3 points | |

[a] Spot welding conditions	Compression: 3.0 kN, Current: 6.0 kA, Welding time: 15 cyc
[c] Spot welding conditions	Compression: 3.0 kN, Current: 6.5 kA, Welding time: 25 cyc
[e] Spot welding conditions	Compression: 3.5 kN, Current: 7.5 kA, Welding time: 16 cyc

*: When plug welding a high-tensile steel sheet of 980 MPa Class or more, refer to "NOTE, Foreword" on page 7.

Panel Replacement

• Views 2



BS-06077

(1) 1 point (service)

(3) 2 points (service)

(4) 2 points

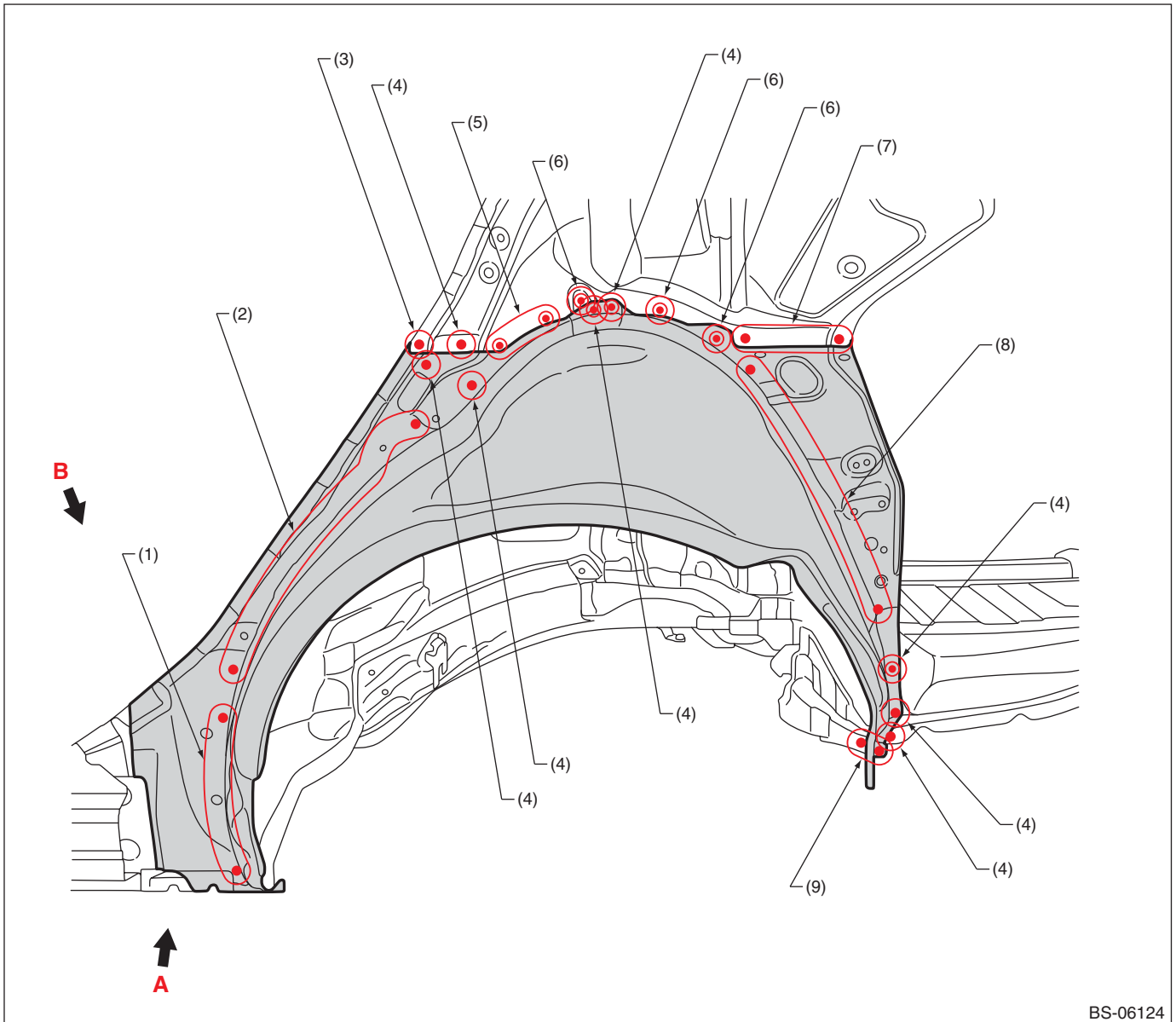
(2) 1 point

Panel Replacement

7-10. Rear Wheel Apron (partial replacement)

A: REMOVAL

- Overall view (LH) (Rear quarter outer removal condition)



BS-06124

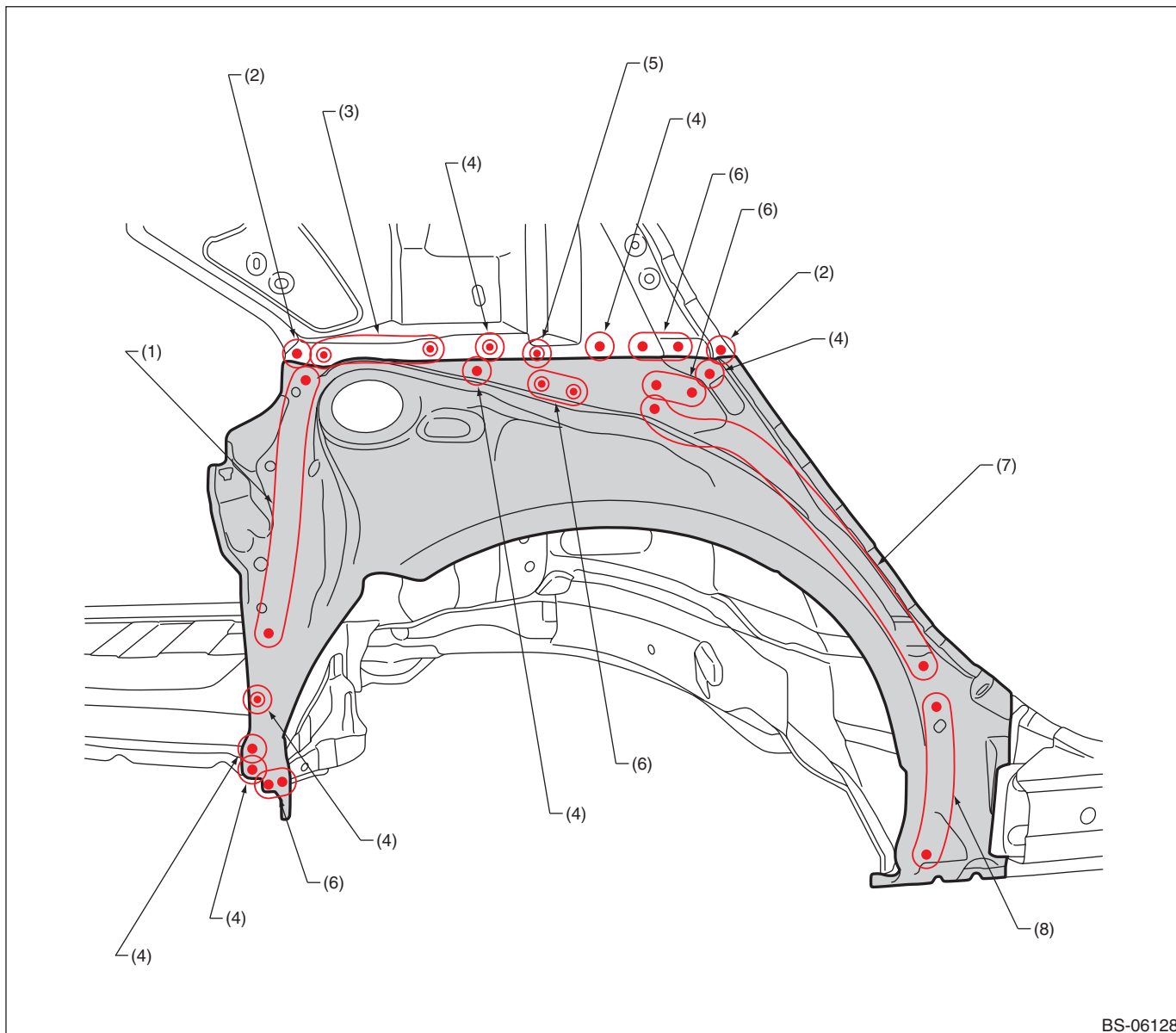
- (1) 4 points (outside · 1)
- (2) 8 points (outside · 1)
- (3) 1 point (inside · 1)

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

- (7) 3 points (inside · 1)
- (8) 7 points (outside · 1)
- (9) 3 points (outside · 1)

Panel Replacement

• (RH)



BS-06128

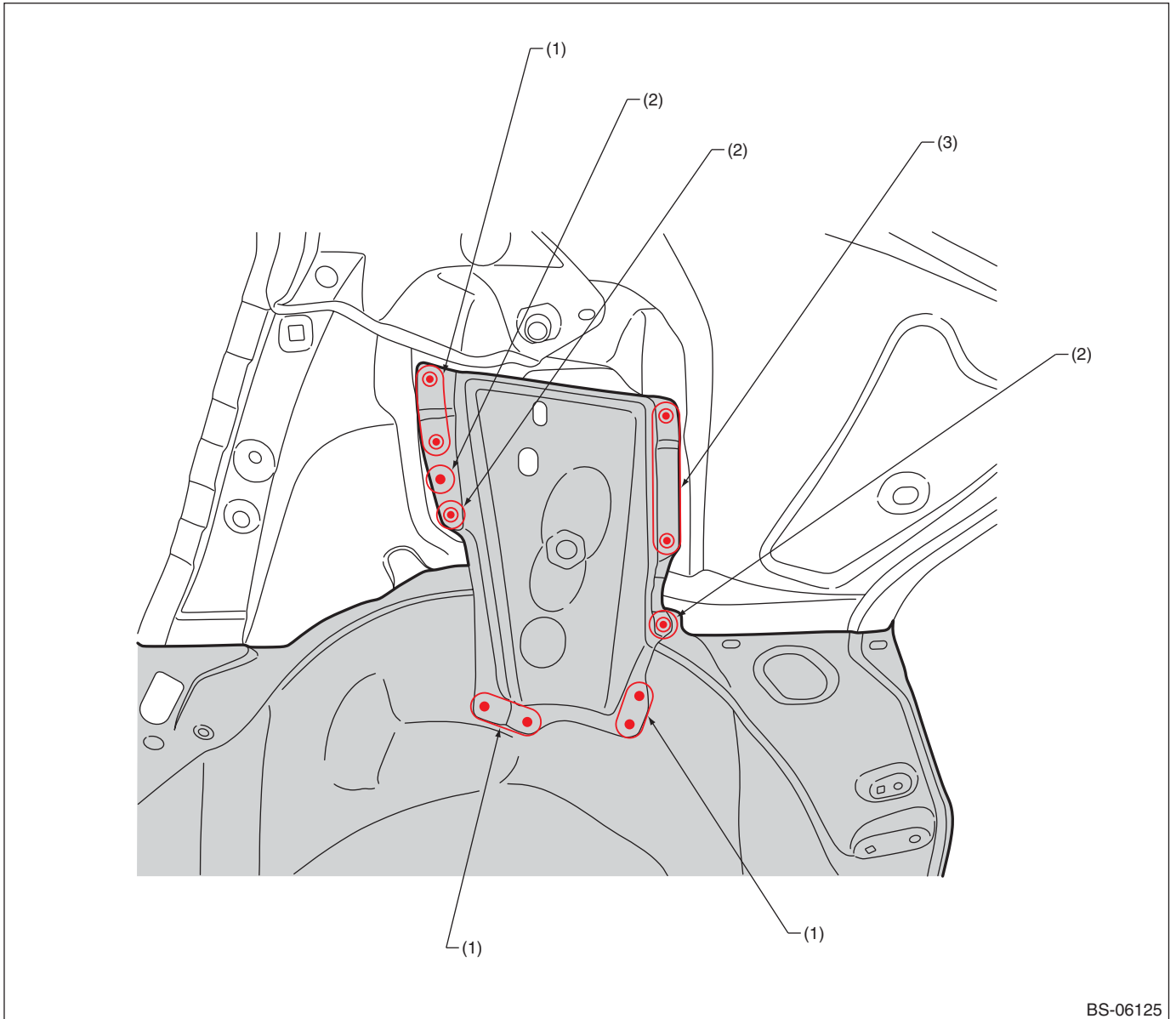
- (1) 6 points (outside · 1)
- (2) 1 point (inside · 1)
- (3) 3 points (outside · 2)

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

- (7) 10 points (outside · 1)
- (8) 4 points (outside · 1)

Panel Replacement

• LH



BS-06125

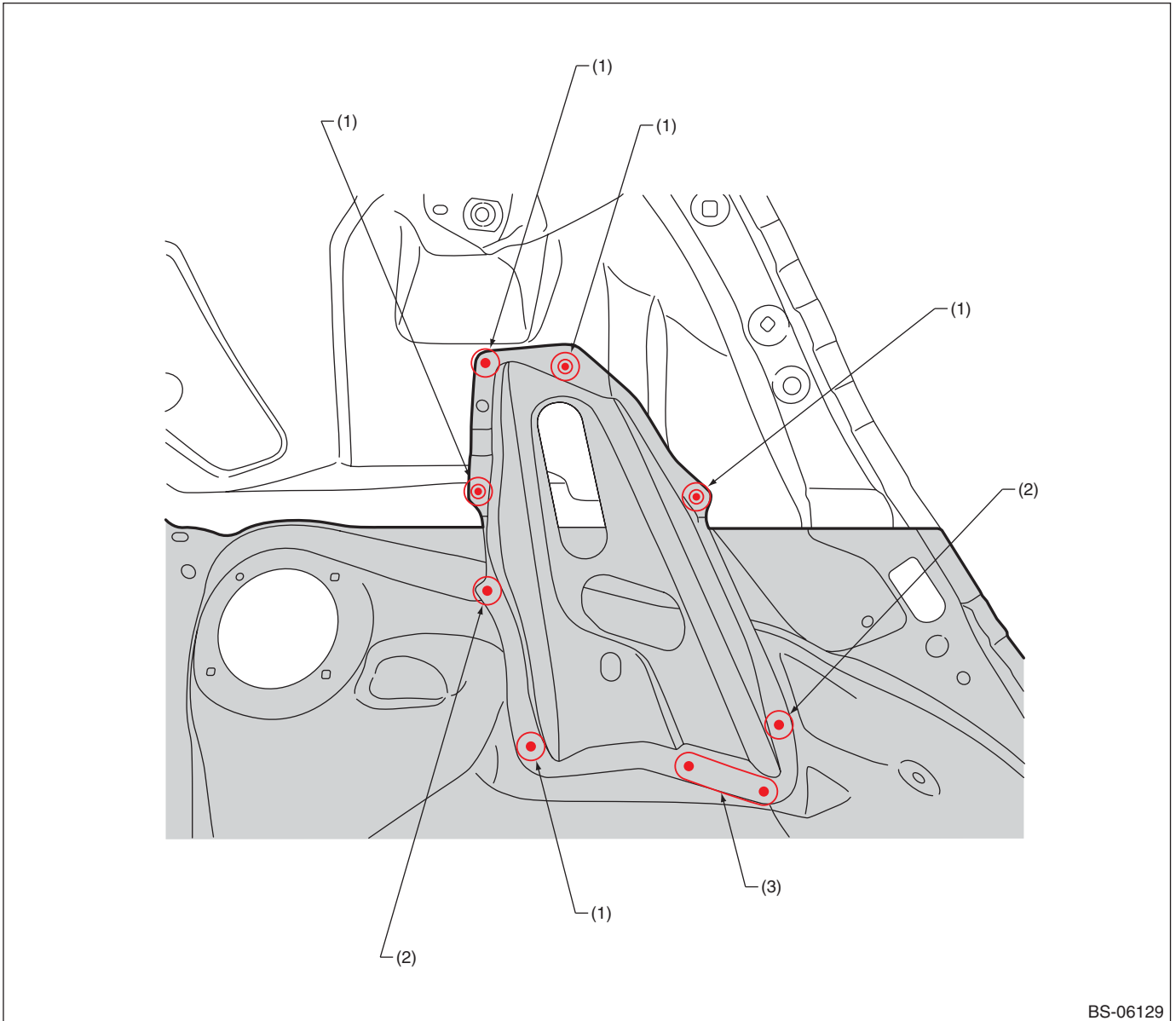
(1) 2 points (outside · 1)

(2) 1 point (outside · 1)

(3) 3 points (outside · 1)

Panel Replacement

• RH

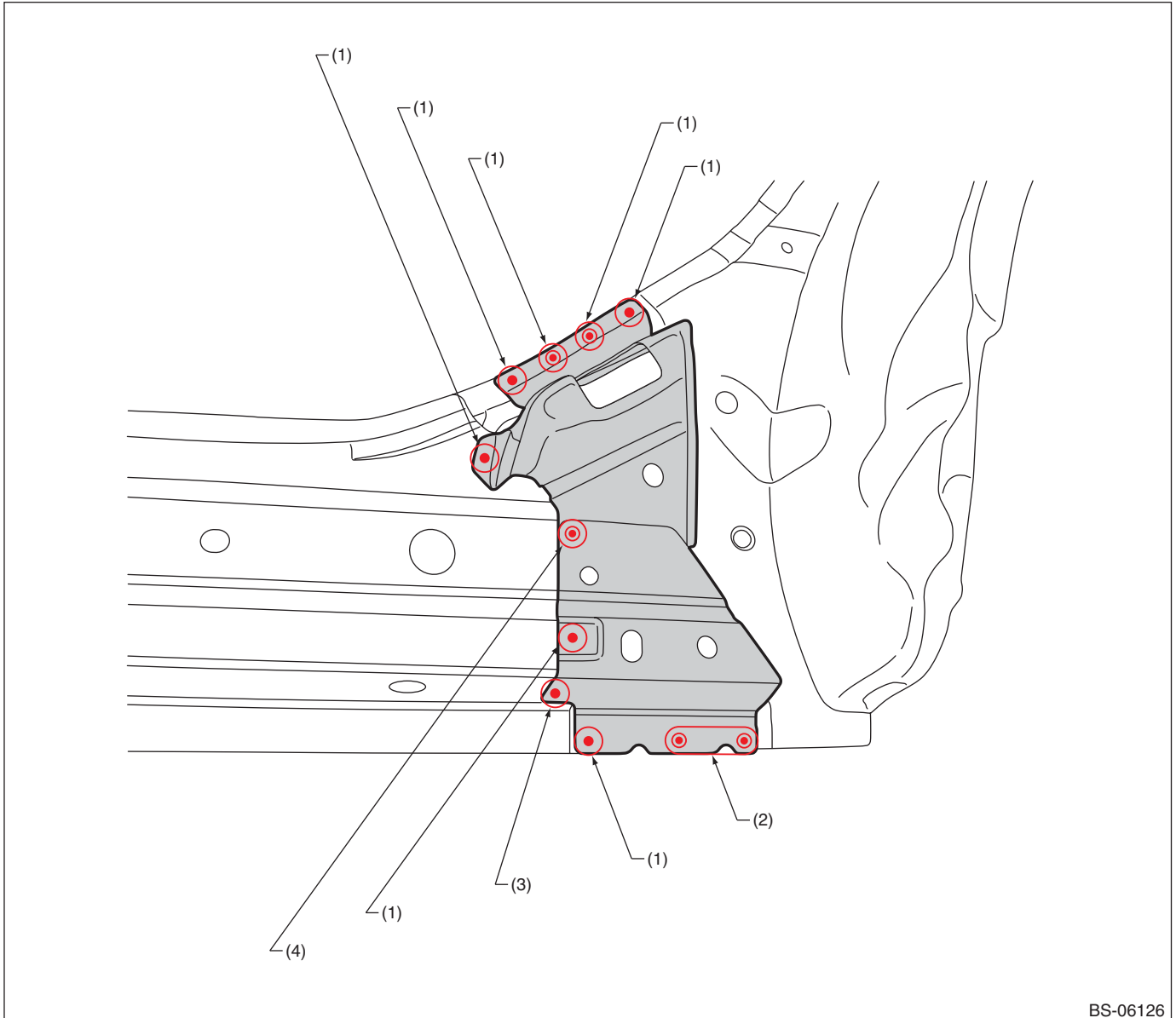


(1) 1 point (outside · 1)

(2) 1 point (top · 1)

(3) 2 points (outside · 1)

Panel Replacement



BS-06126

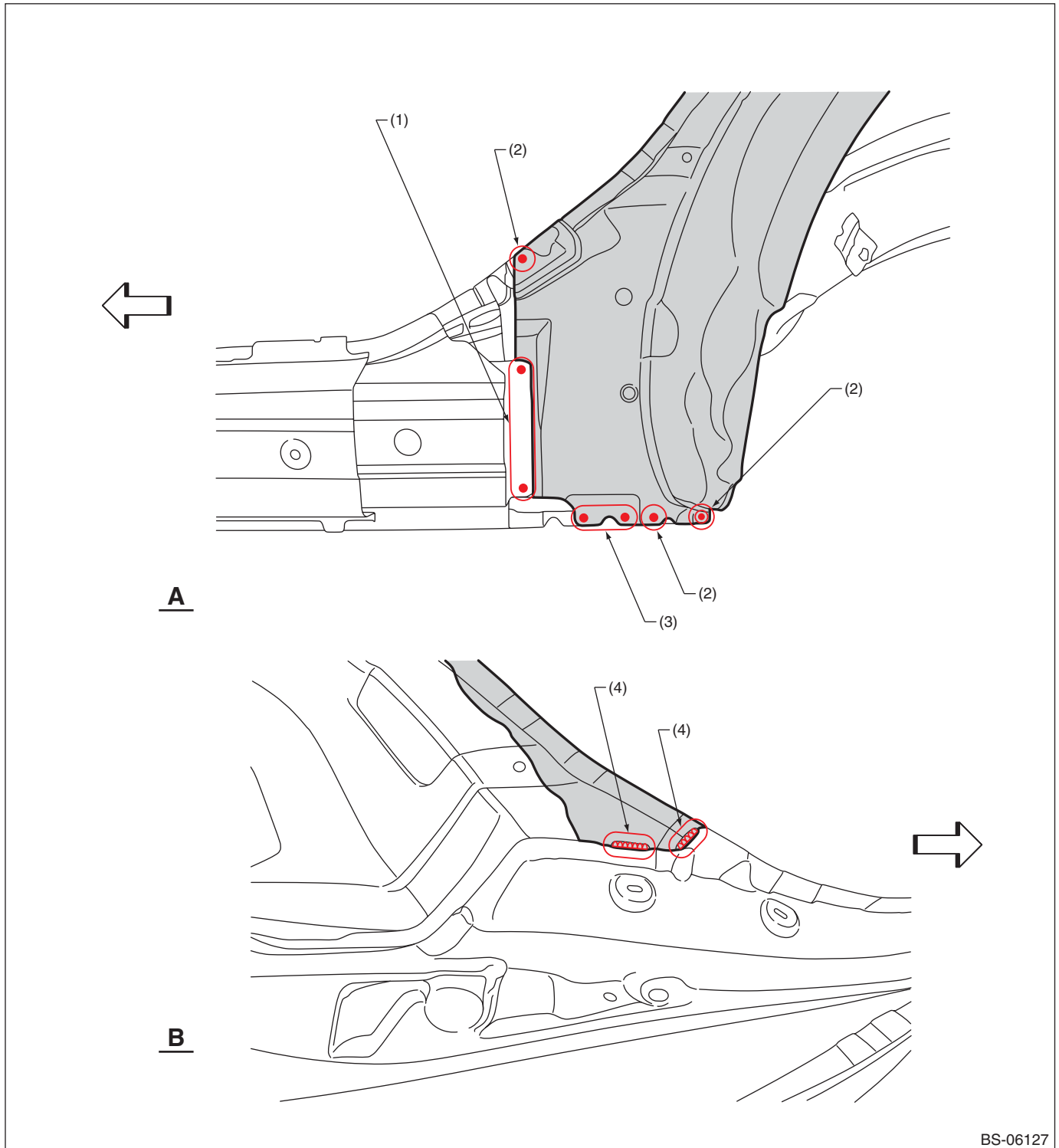
(1) 1 point (outside · 1)
(2) 2 points (outside · 1)

(3) 1 point (bottom · 1)

(4) 1 point (outside · 2)

Panel Replacement

• Views



(1) 3 points (outside · 1)

(2) 1 point (outside · 1)

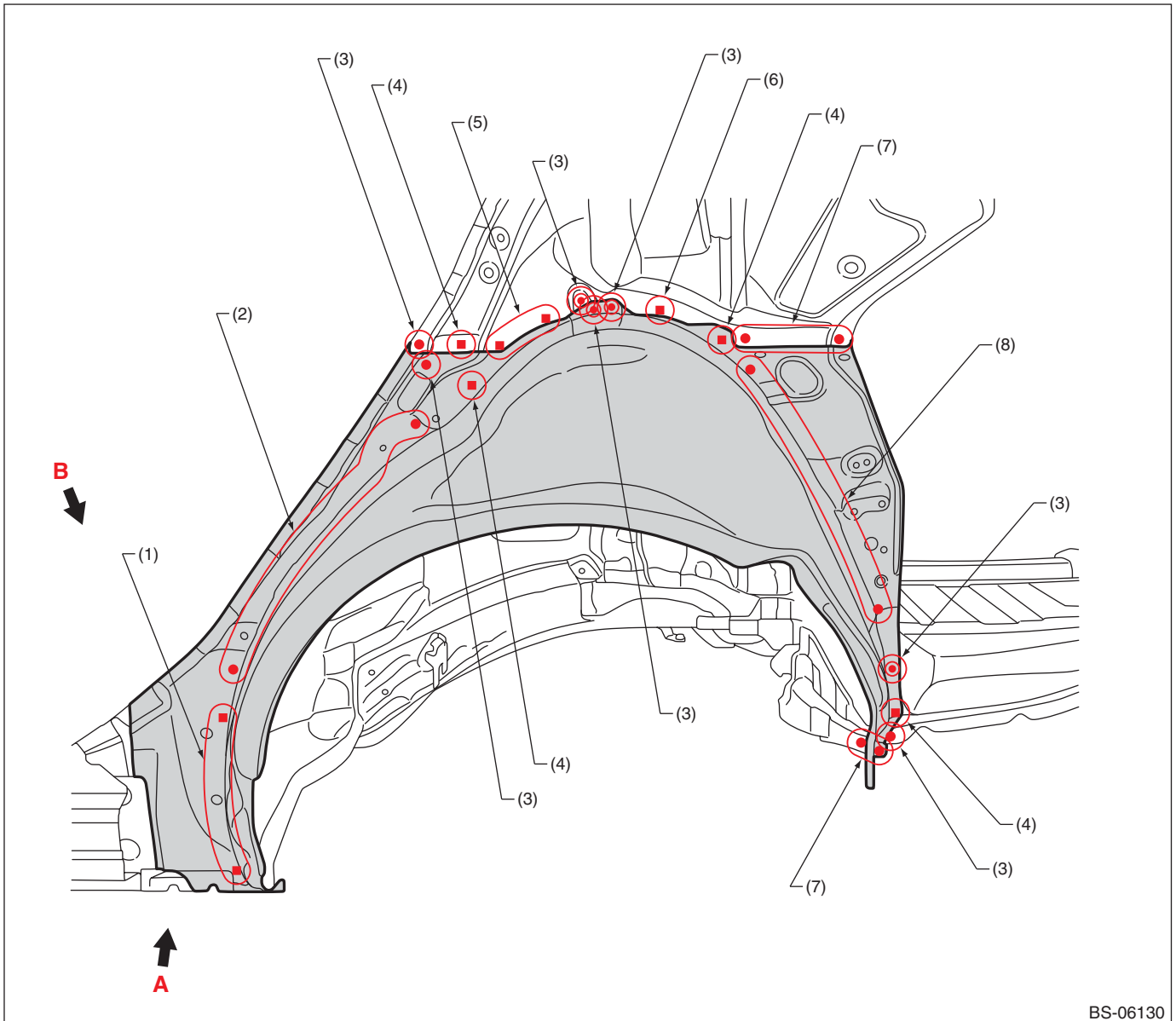
(3) 2 points (outside · 1)

(4) 1 point (inside · 1, belt sander)

Panel Replacement

B: INSTALLATION

• Overall view (LH)



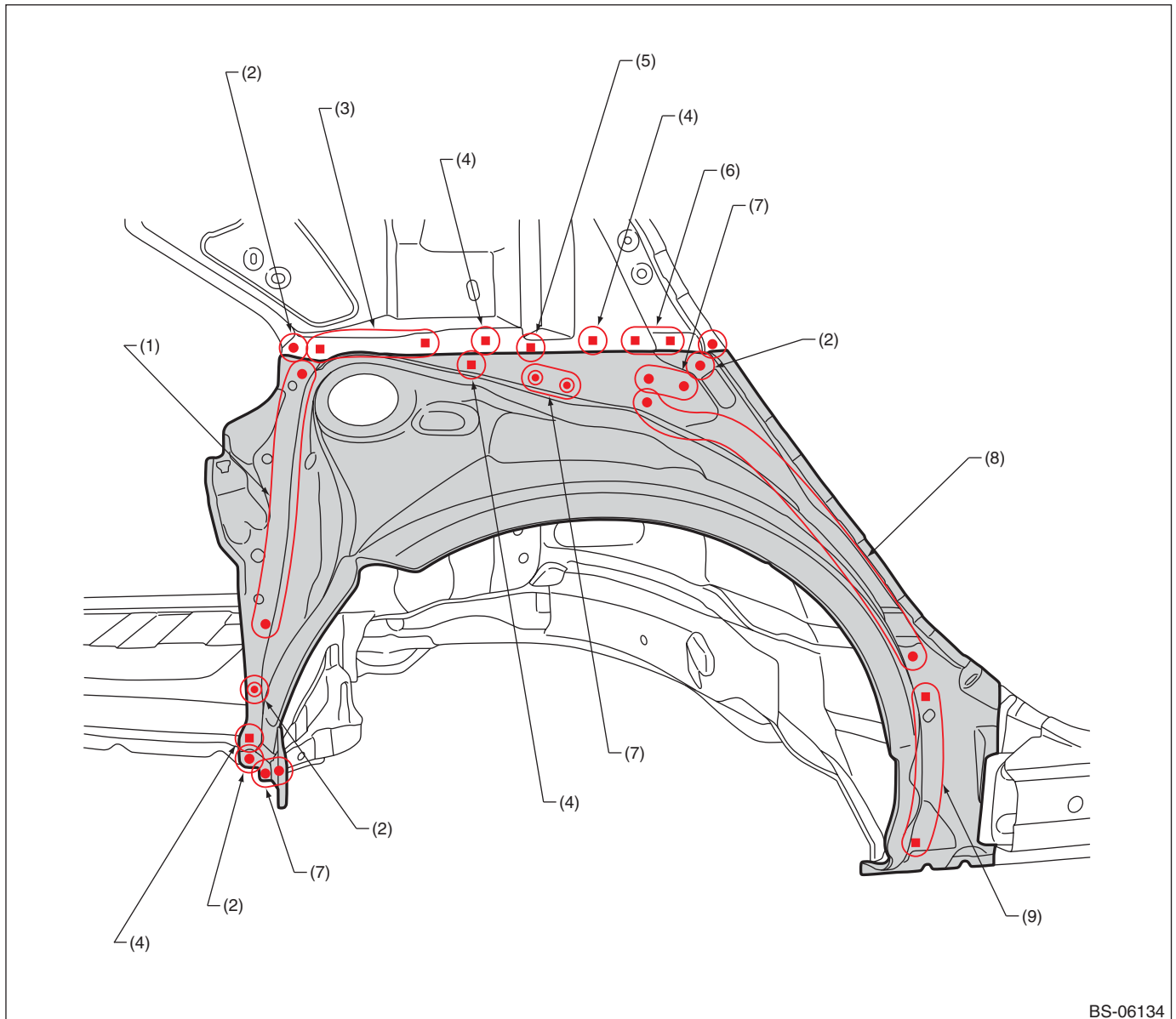
(1) 4 points (service)
(2) 8 points
(3) 1 point

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

(7) 3 points
(8) 7 points

Panel Replacement

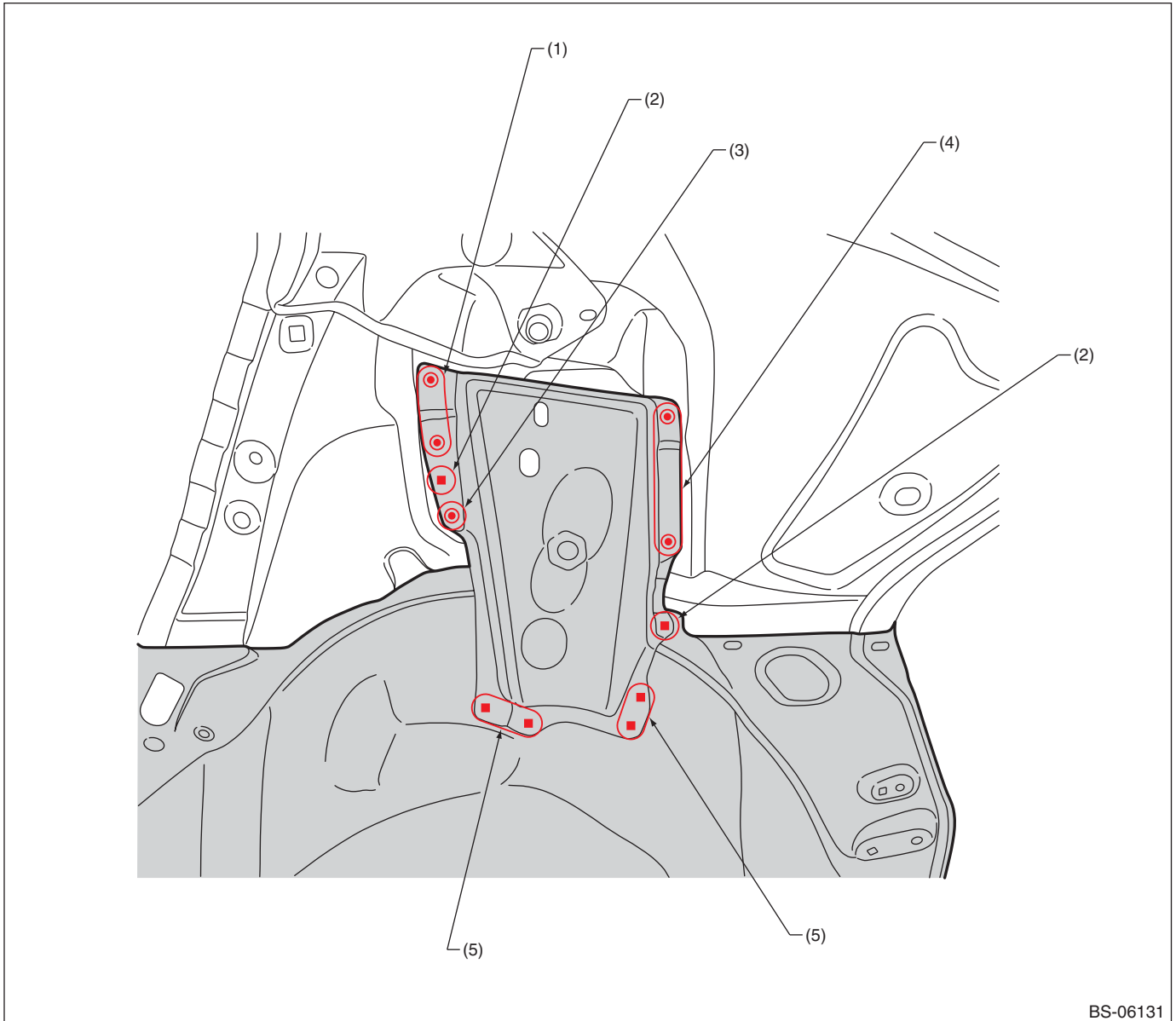
• (RH)



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

Panel Replacement

• LH



BS-06131

(1) 2 points

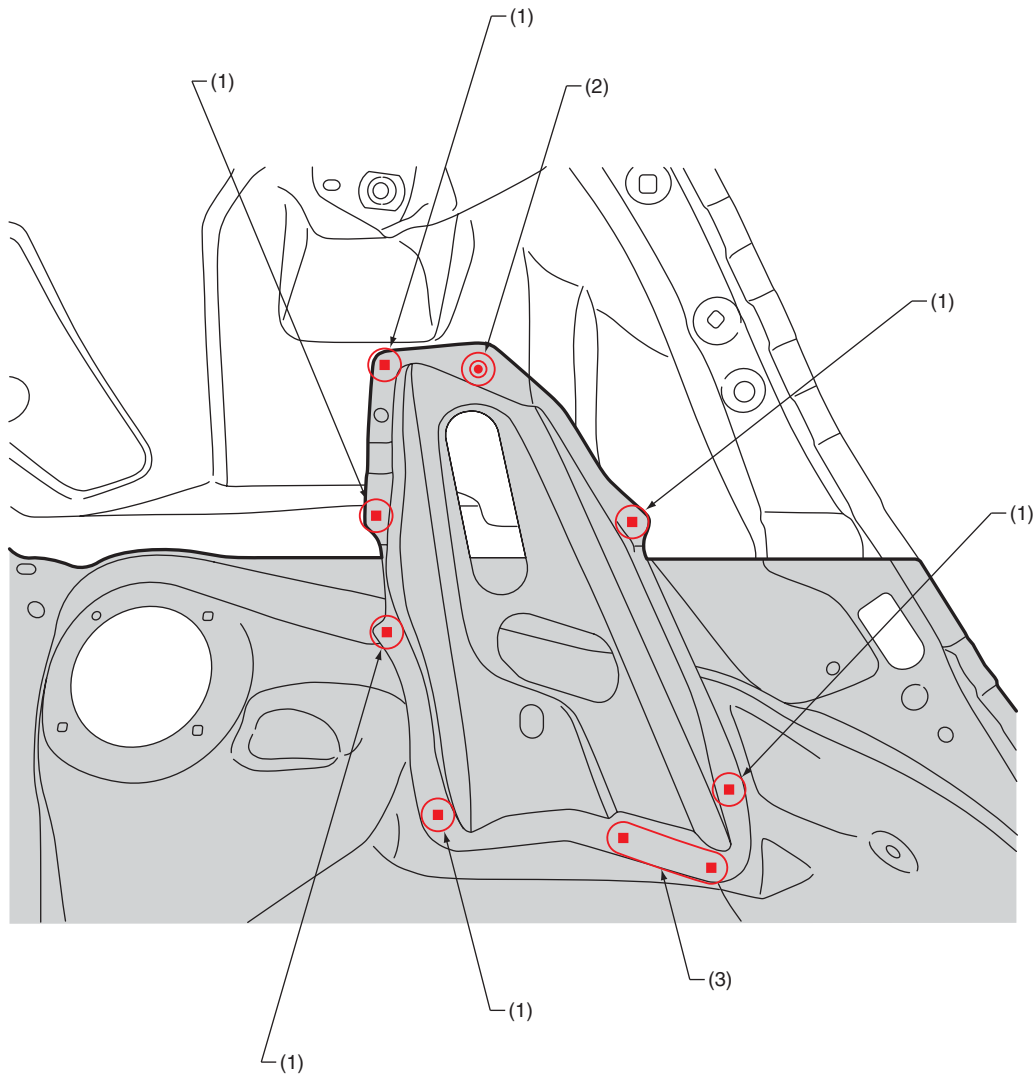
(2) 1 point (service)

(3) 1 point

(4) 3 points

(5) 2 points (service)

- RH



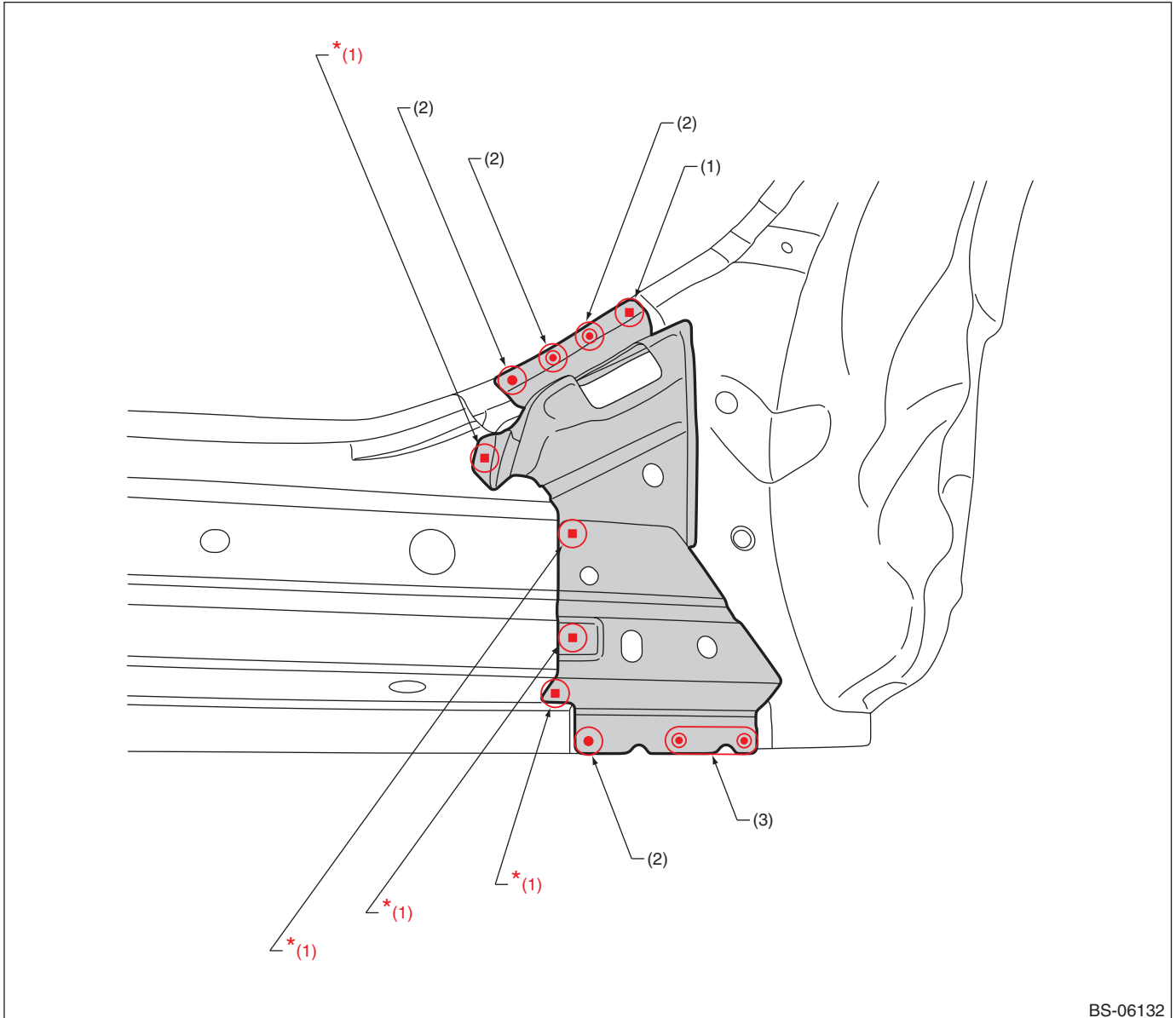
BS-06135

(1) 1 point (service)

(2) 1 point

(3) 2 points (service)

Panel Replacement



BS-06132

(1) 1 point (service)

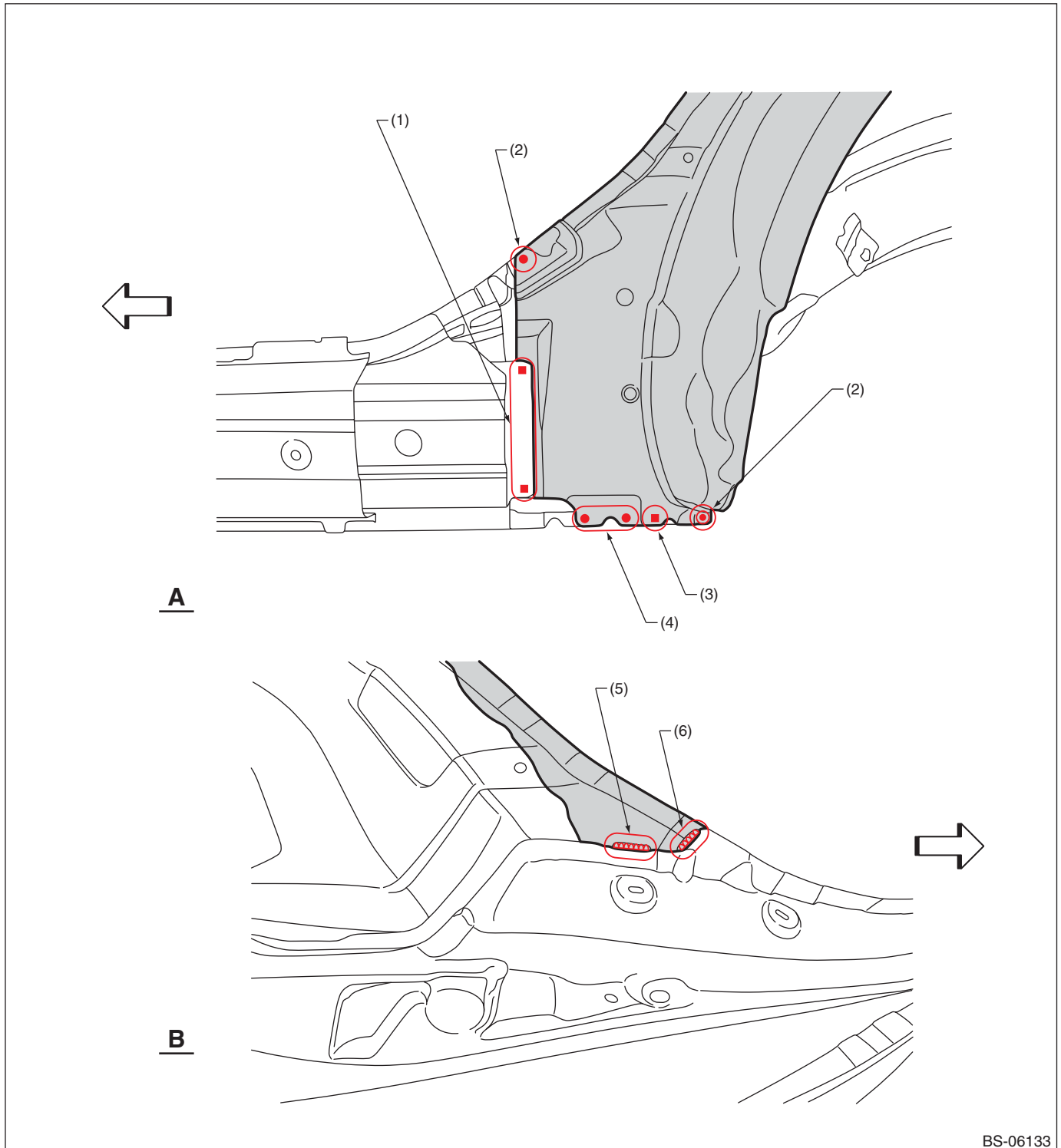
(2) 1 point

(3) 2 points

*: When plug welding a high-tensile steel sheet of 980 MPa Class or more, refer to "NOTE, Foreword" on page 7.

Panel Replacement

• Views



(1) 3 points
(2) 1 point

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

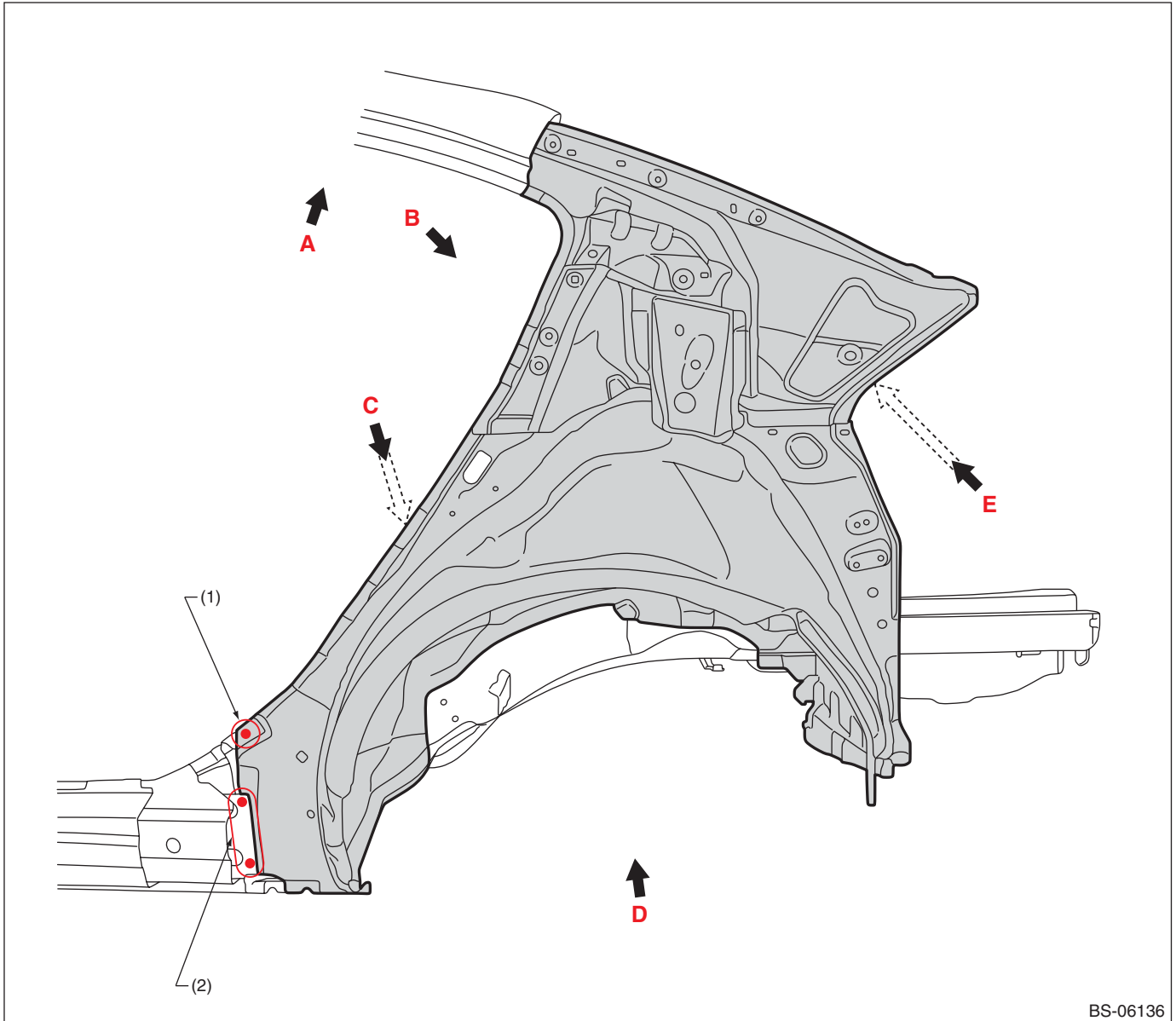
(5) 1 point [30 mm (1.18 in)]
(6) 1 point [25 mm (0.98 in)]

Panel Replacement

7-11. Rear Quarter Inner (total replacement)

A: REMOVAL

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

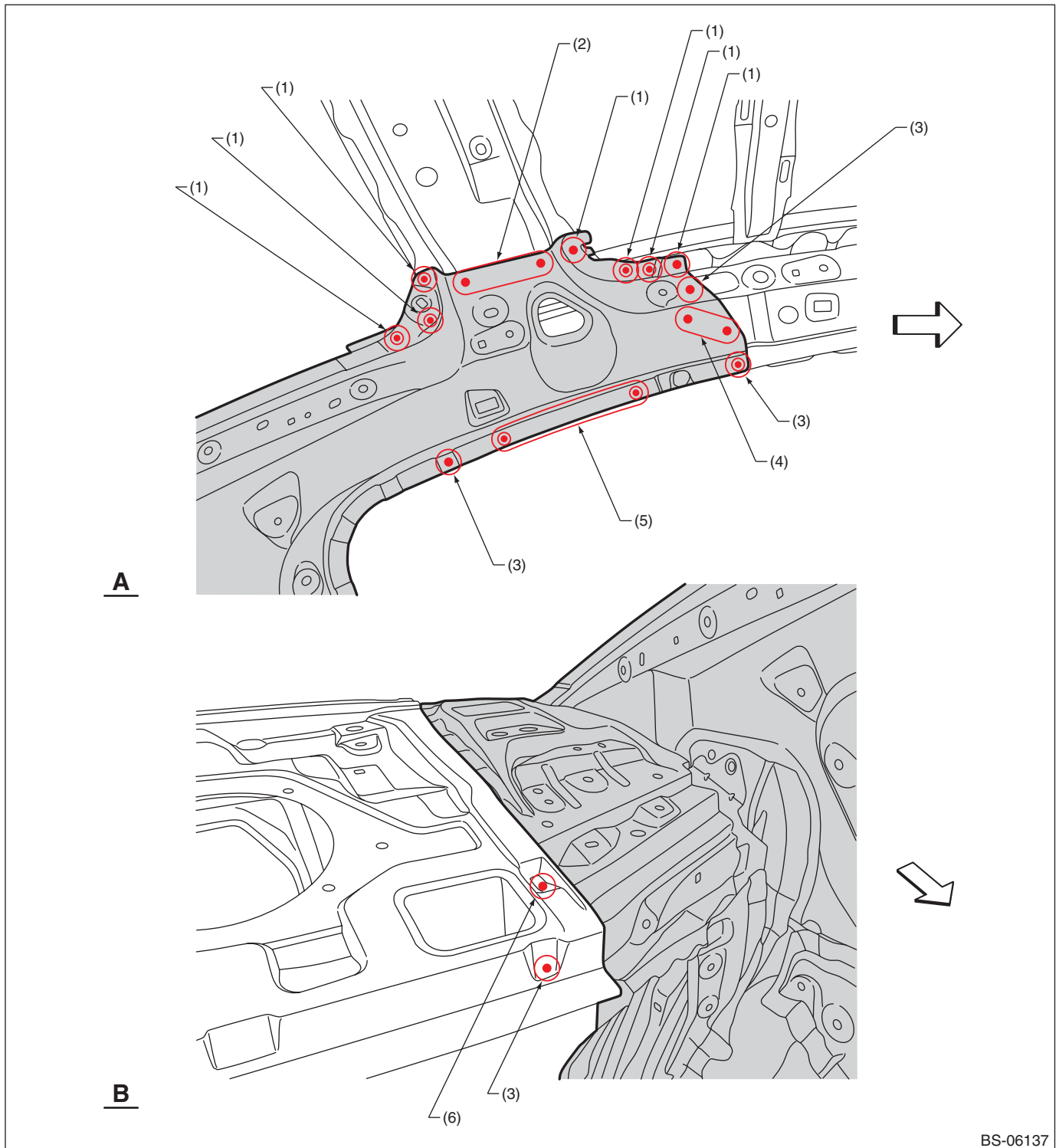


(1) 1 point (outside · 1)

(2) 3 points (outside · 1)

Panel Replacement

• Views 1



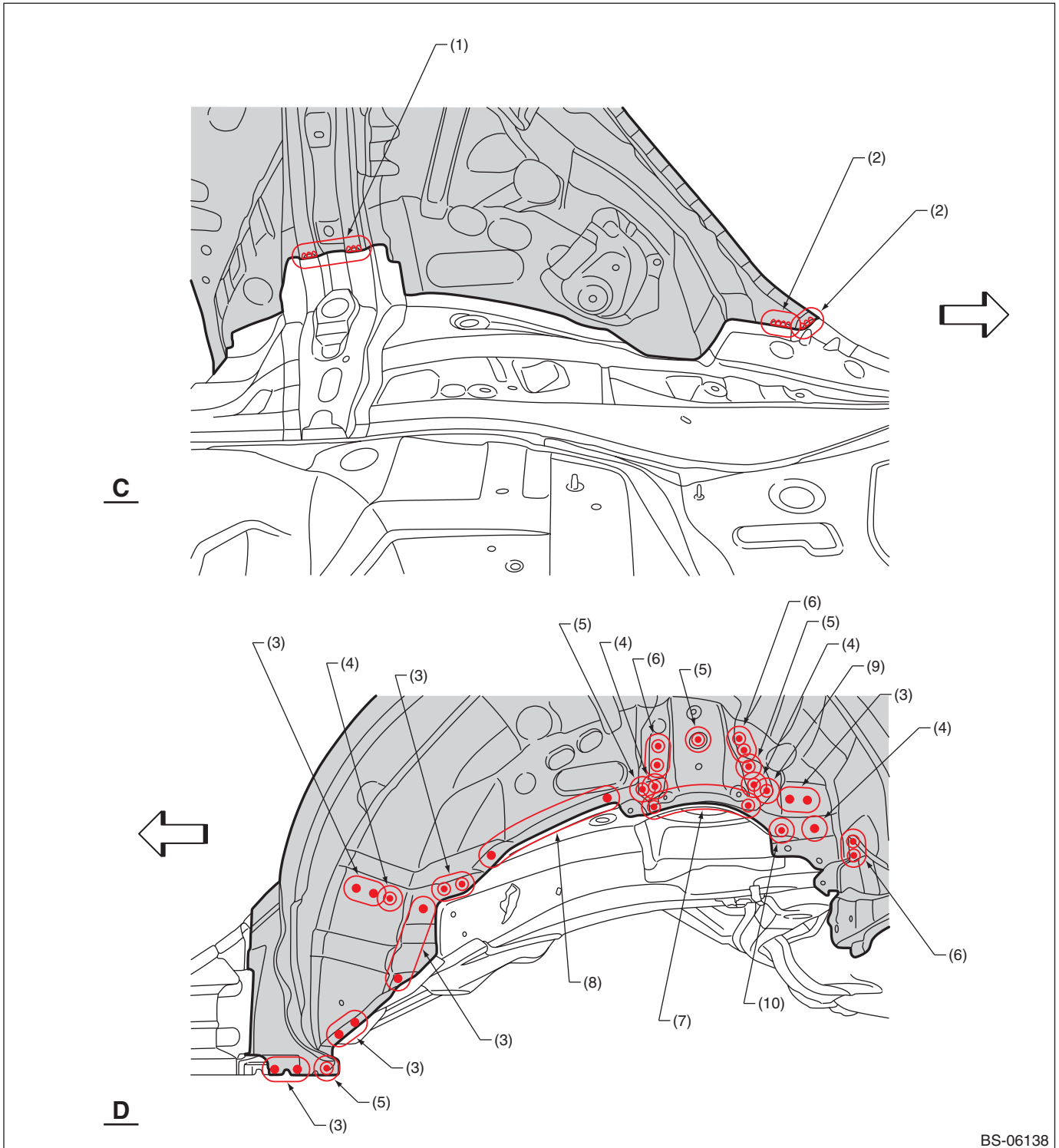
(1) 1 point (bottom · 1)
(2) 3 points (bottom · 1)

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

(5) 3 points (inside · 1)
(6) 1 point (top · 1)

Panel Replacement

• Views 2



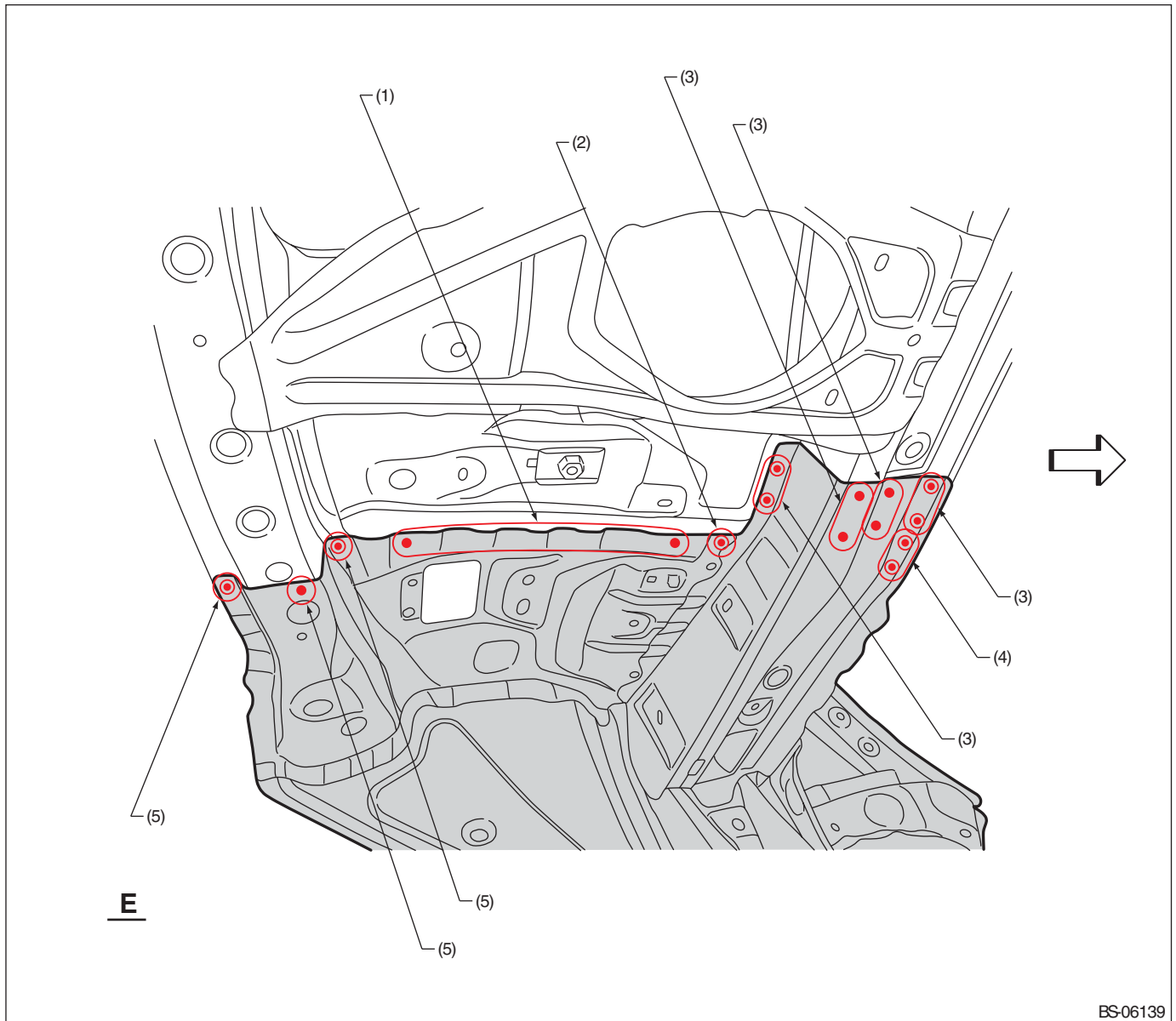
- (1) 2 points (inside · 1, belt sander)
- (2) 1 point (inside · 1, belt sander)
- (3) 2 points (outside · 1)
- (4) 1 point (outside · 1)

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

- (9) 1 point (outside · 2) (only LH)
- (10) 1 point (outside · 1) (only LH)

Panel Replacement

• Views 3



BS-06139

(1) 6 points (bottom · 1)
(2) 1 point (bottom · 2)

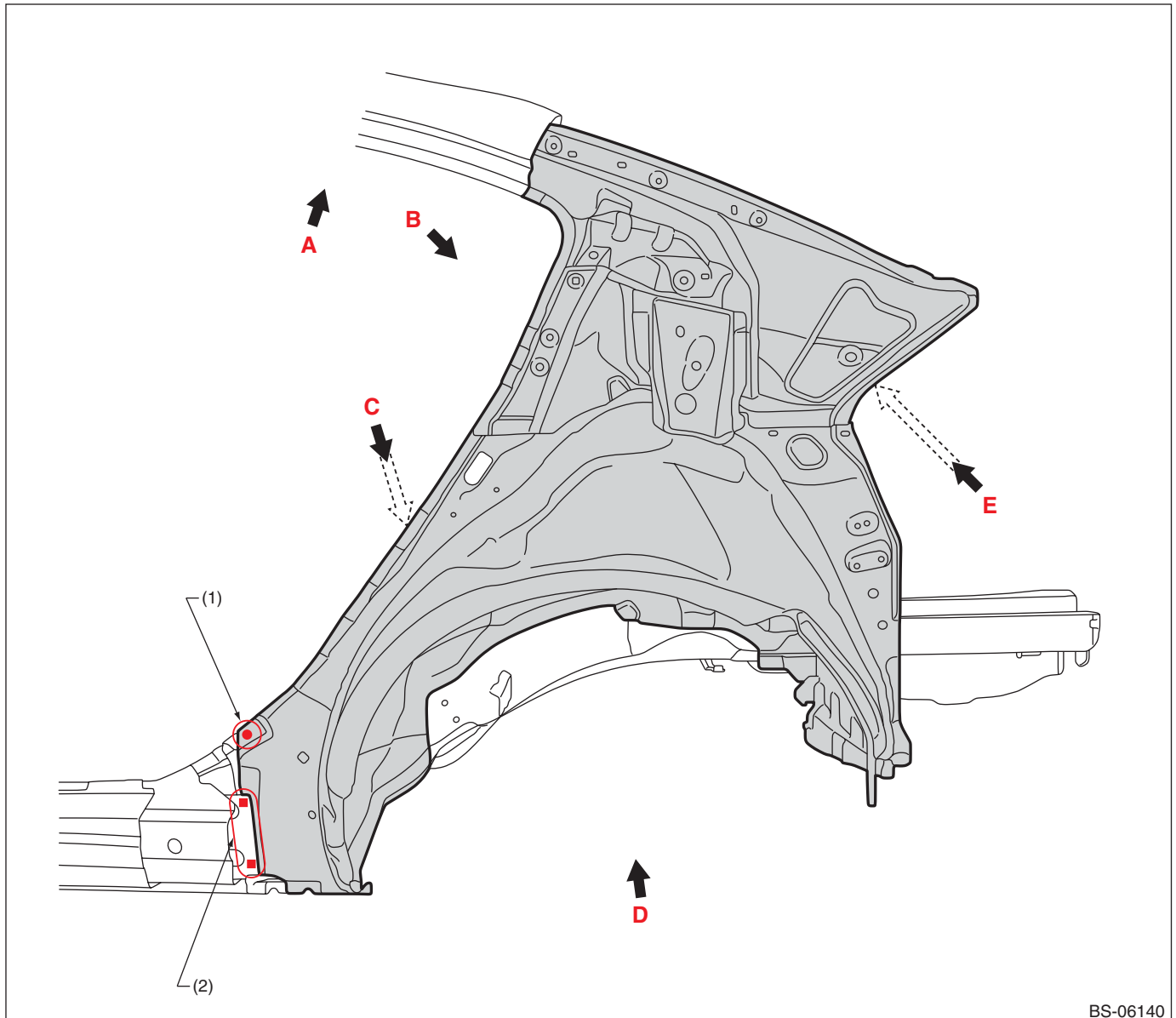
(3) 2 points (bottom · 1)
(4) 2 points (bottom · 2)

(5) 1 point (bottom · 1)

Panel Replacement

B: INSTALLATION

• Overall view

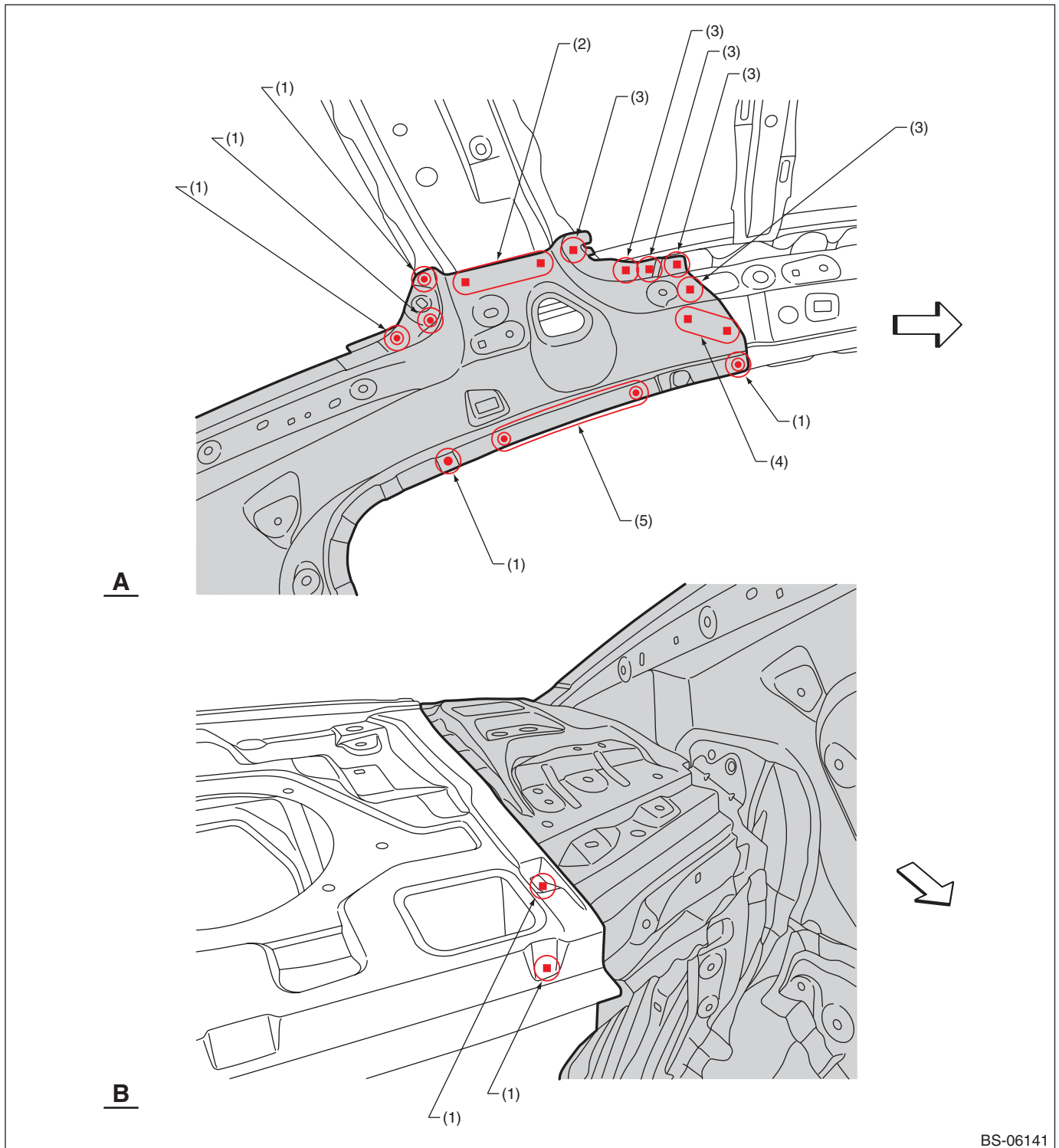


(1) 1 point

(2) 3 points

Panel Replacement

• Views 1

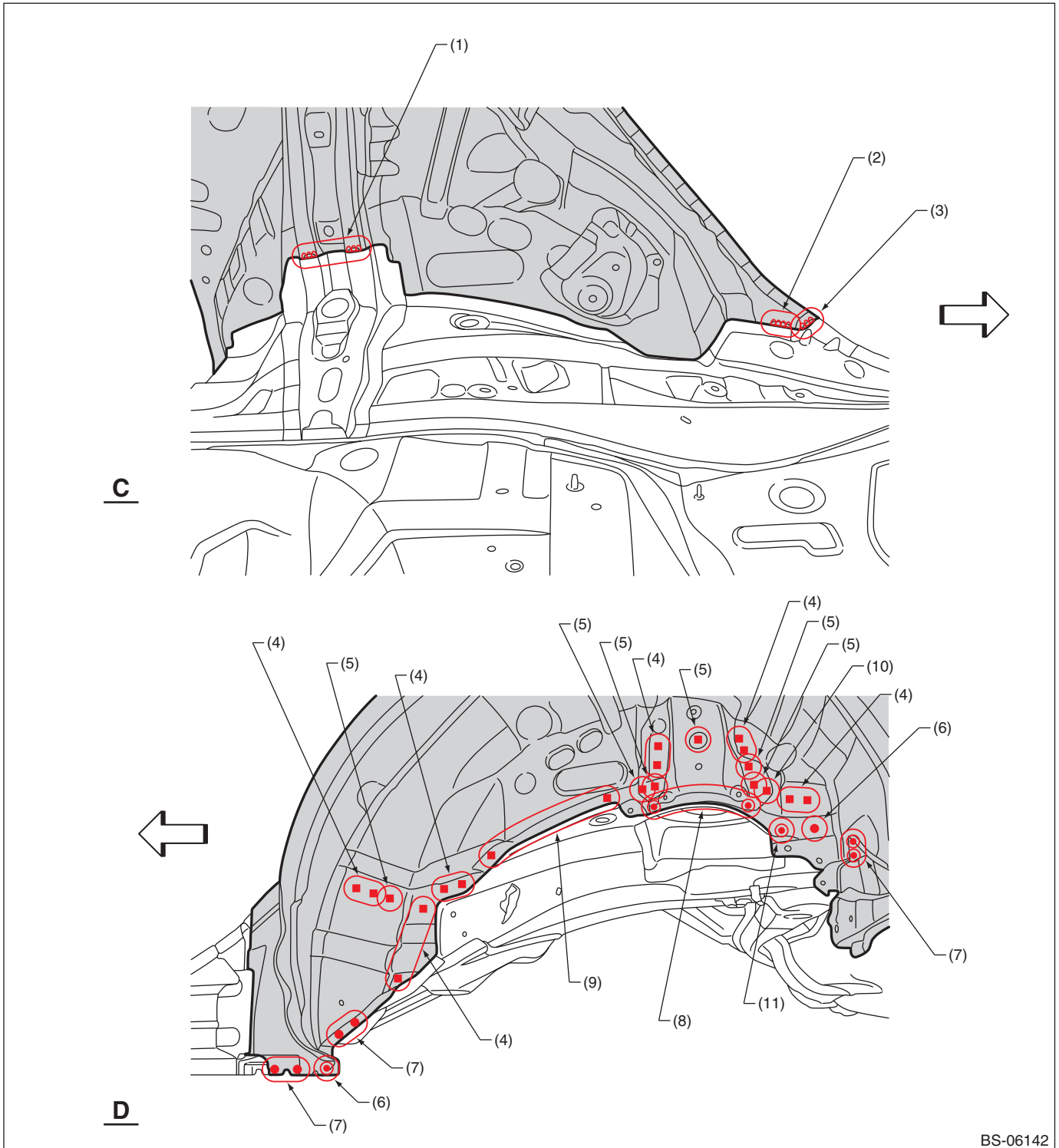


BS-06141

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

Panel Replacement

• Views 2

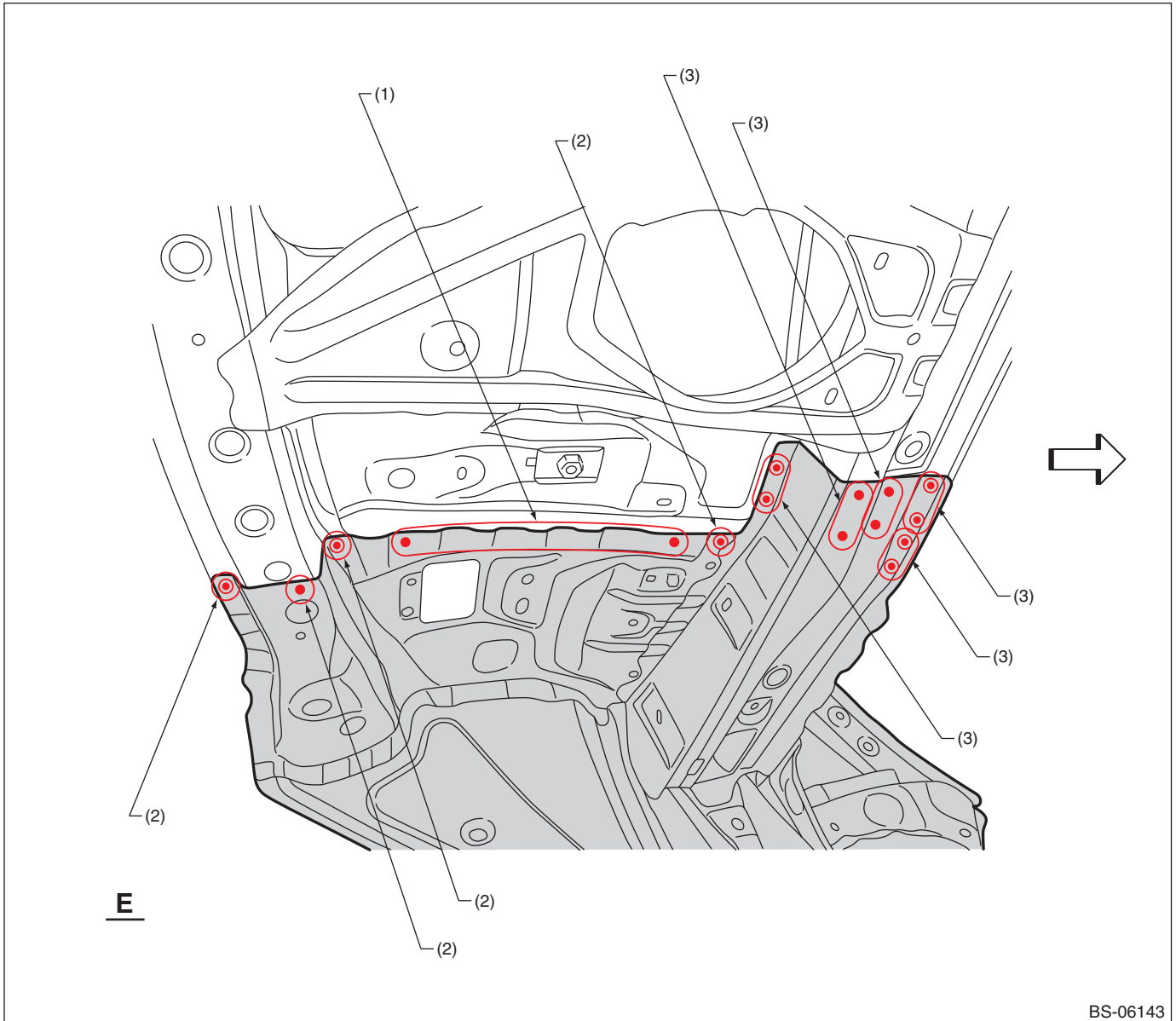


BS-06142

- | | | |
|--------------------------------|-----------------------|----------------------------------|
| (1) 2 points [20 mm (0.79 in)] | (5) 1 point (service) | (9) 5 points (service) |
| (2) 1 point [30 mm (1.18 in)] | (6) 1 point | (10) 1 point (service) (only LH) |
| (3) 1 point [25 mm (0.98 in)] | (7) 2 points | (11) 1 point (only LH) |
| (4) 2 points (service) | (8) 5 points | |

Panel Replacement

• Views 3



(1) 6 points

(2) 1 point

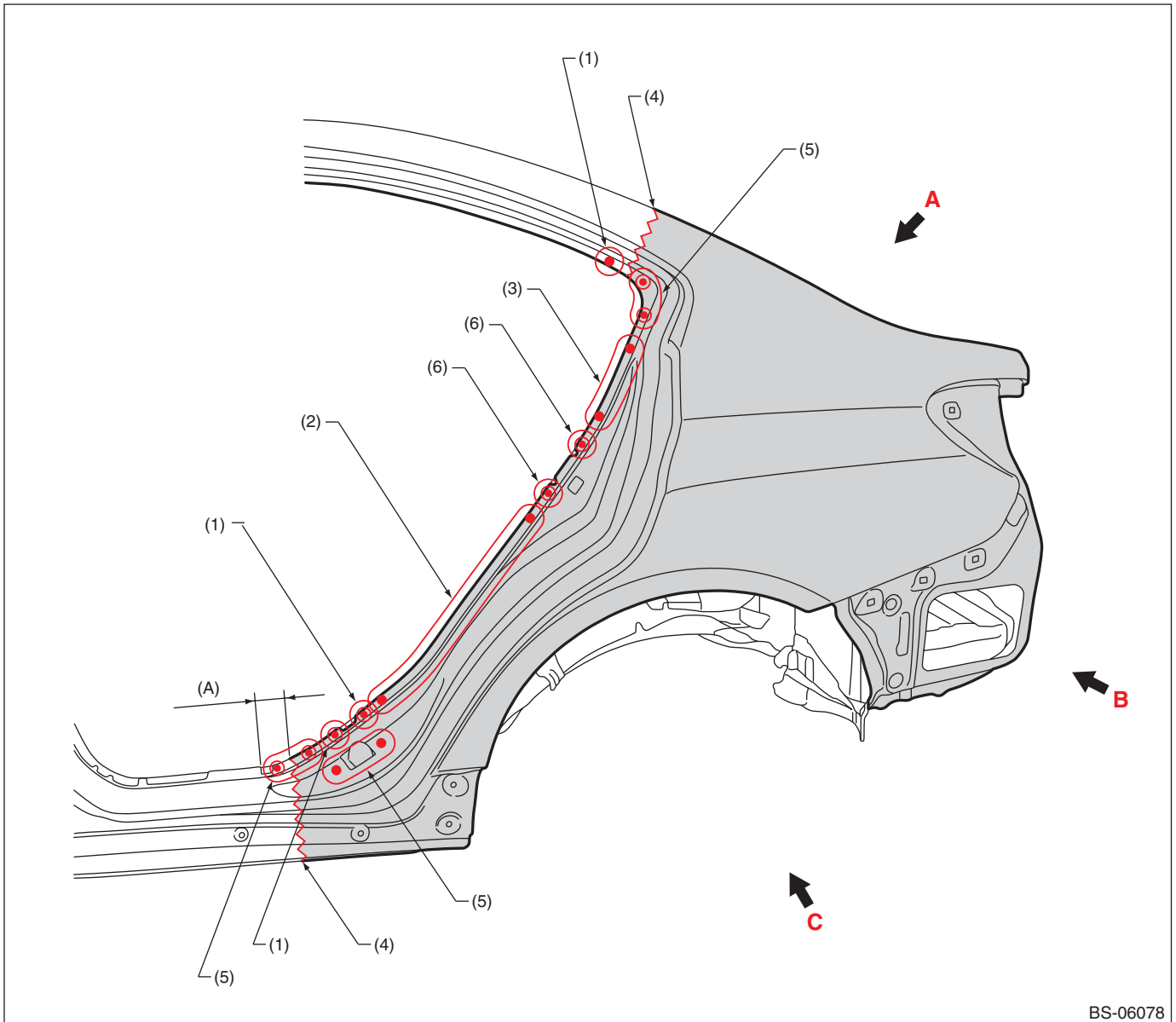
(3) 2 points

Panel Replacement

7-12. Rear Quarter (partial replacement)

A: REMOVAL

• Overall view



(A) 60 mm (2.36 in)

(1) 1 point (outside · 1)

(2) 8 points (outside · 1)

(3) 3 points (outside · 1)

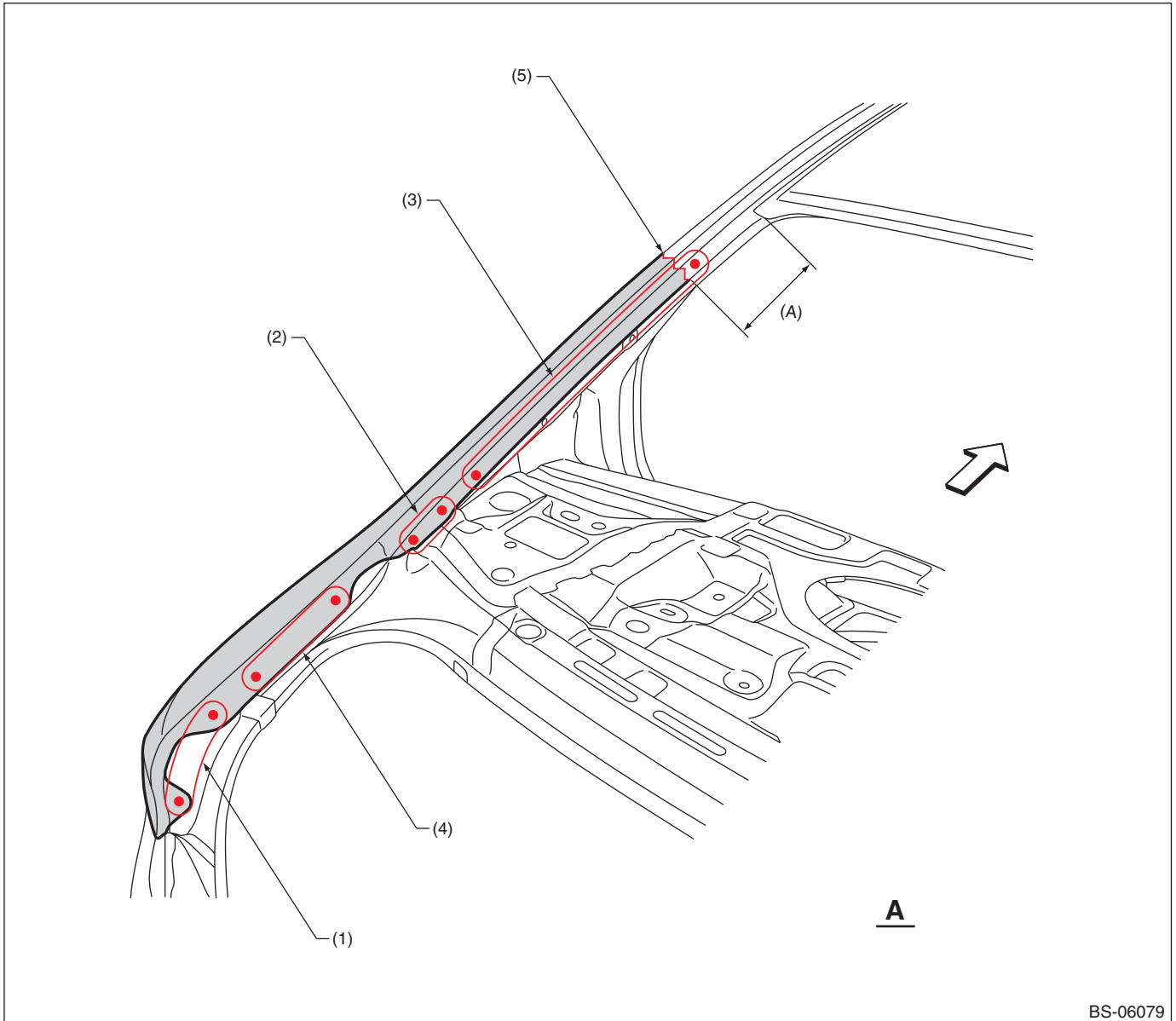
(4) Rough cutting

(5) 2 points (outside · 1)

(6) 1 point (outside · 2)

Panel Replacement

• Views 1



BS-06079

(A) 110 mm (4.33 in)

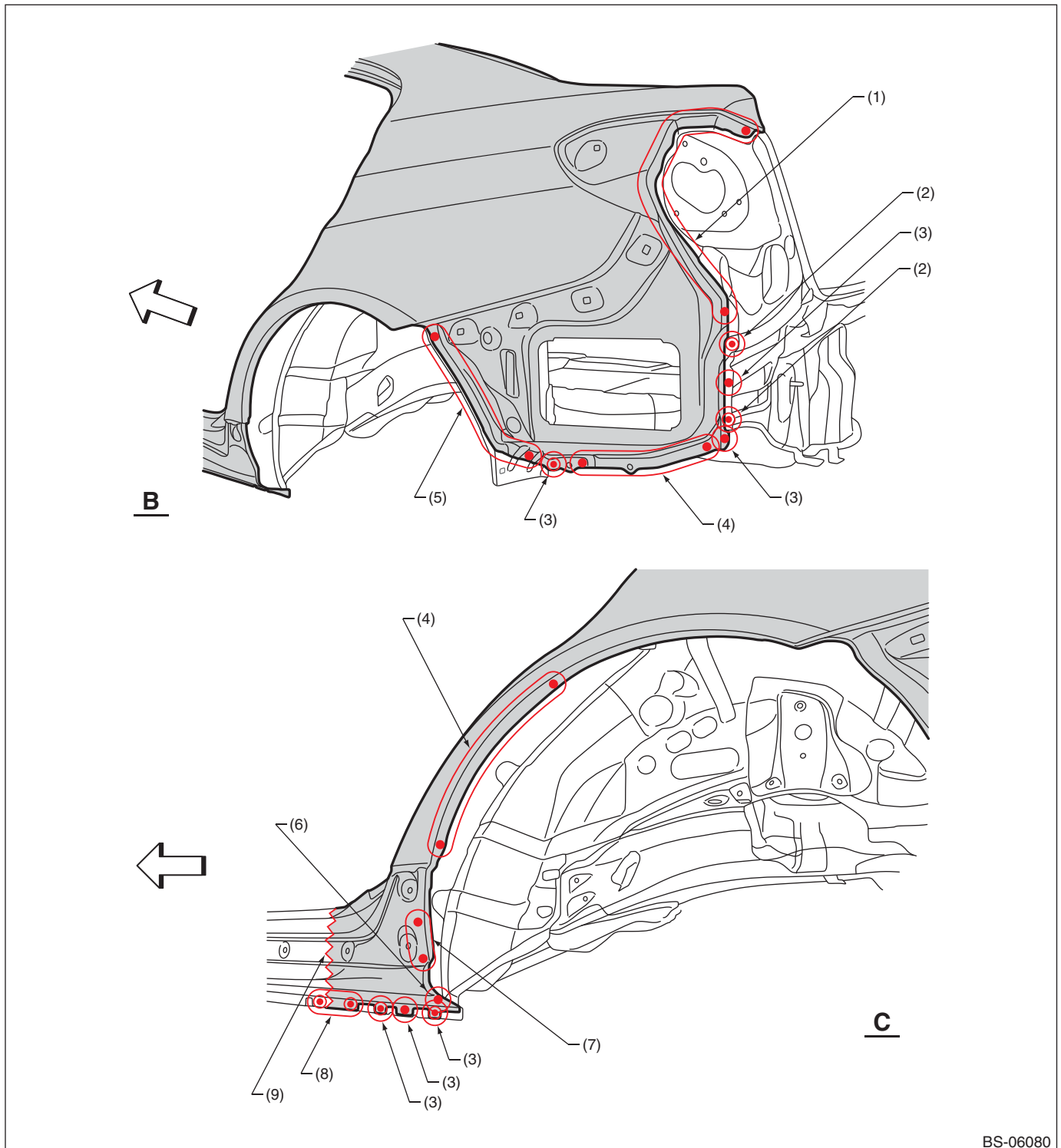
(1) 2 points (inside · 1)
(2) 2 points (outside · 1)

(3) 7 points (outside · 1)
(4) 3 points (inside · 1)

(5) Rough cutting

Panel Replacement

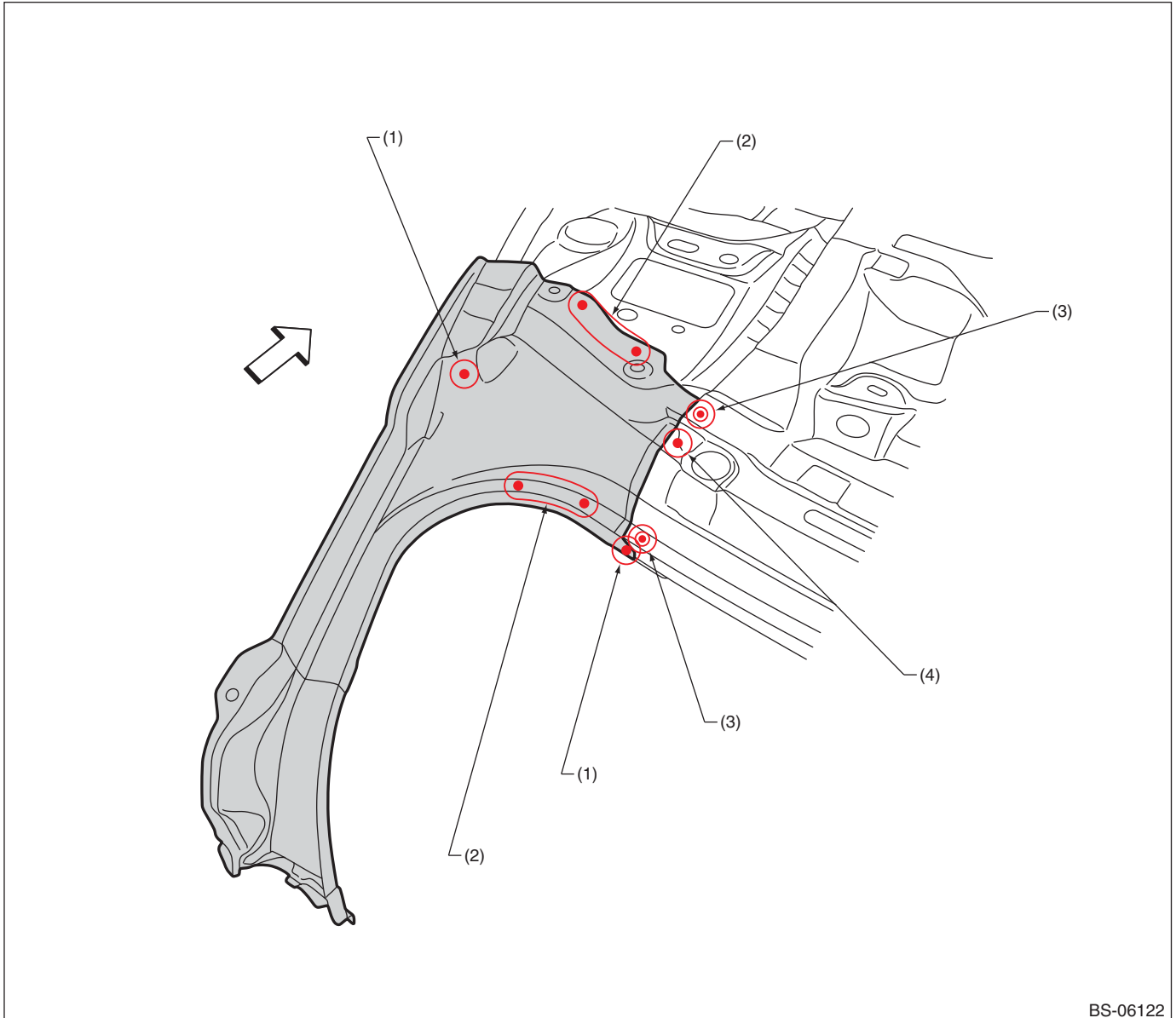
• Views 2



BS-06080

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

Panel Replacement



BS-06122

(1) 1 point (outside · 1)

(2) 2 points (top · 1)

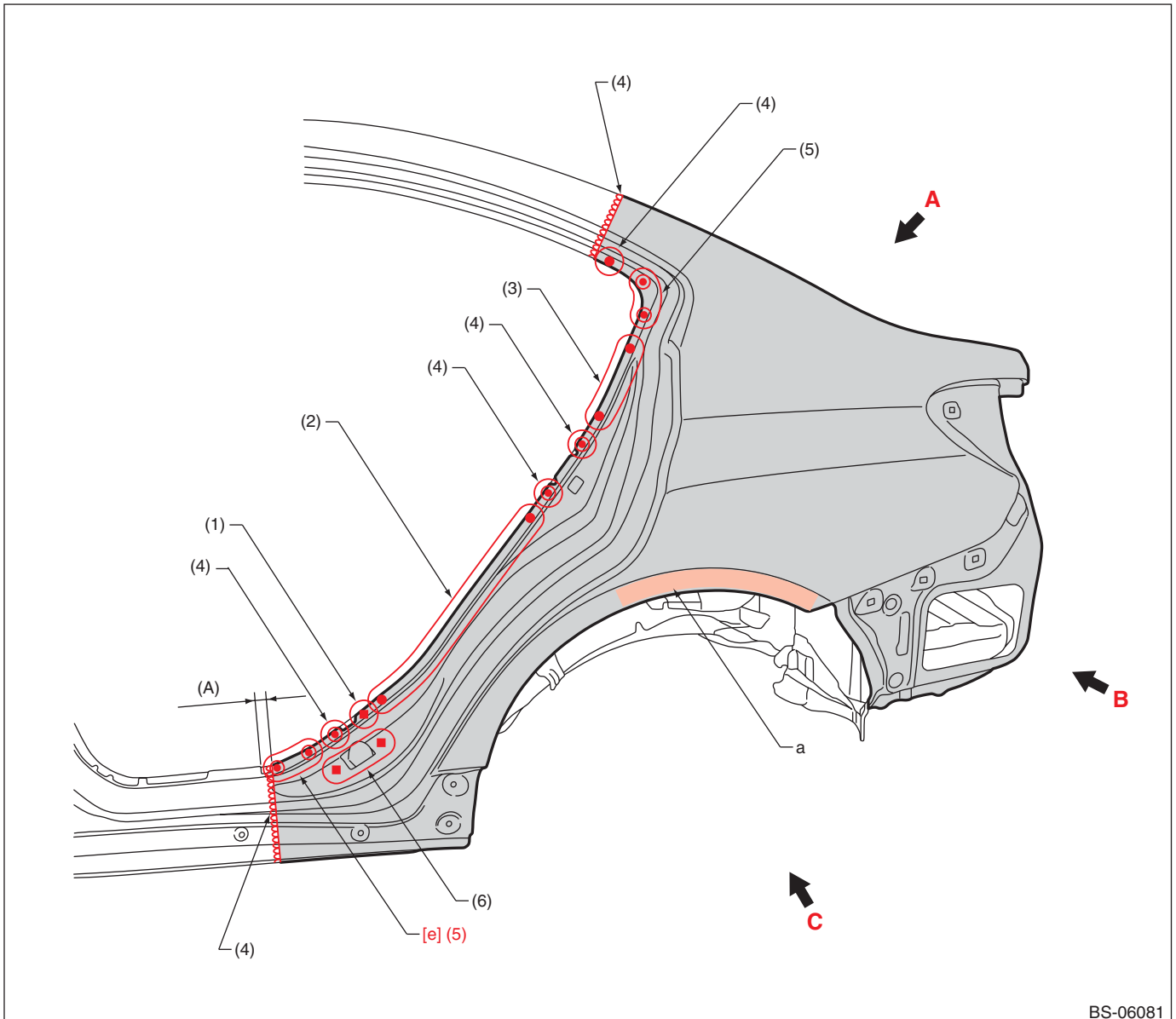
(3) 1 point (top · 2)

(4) 1 point (top · 1)

Panel Replacement

B: INSTALLATION

• Overall view



(A) 20 mm (0.79 in)

(1) 1 point (service)

(3) 3 points

(5) 2 points

(2) 8 points

(4) 1 point

(6) 2 points (service)

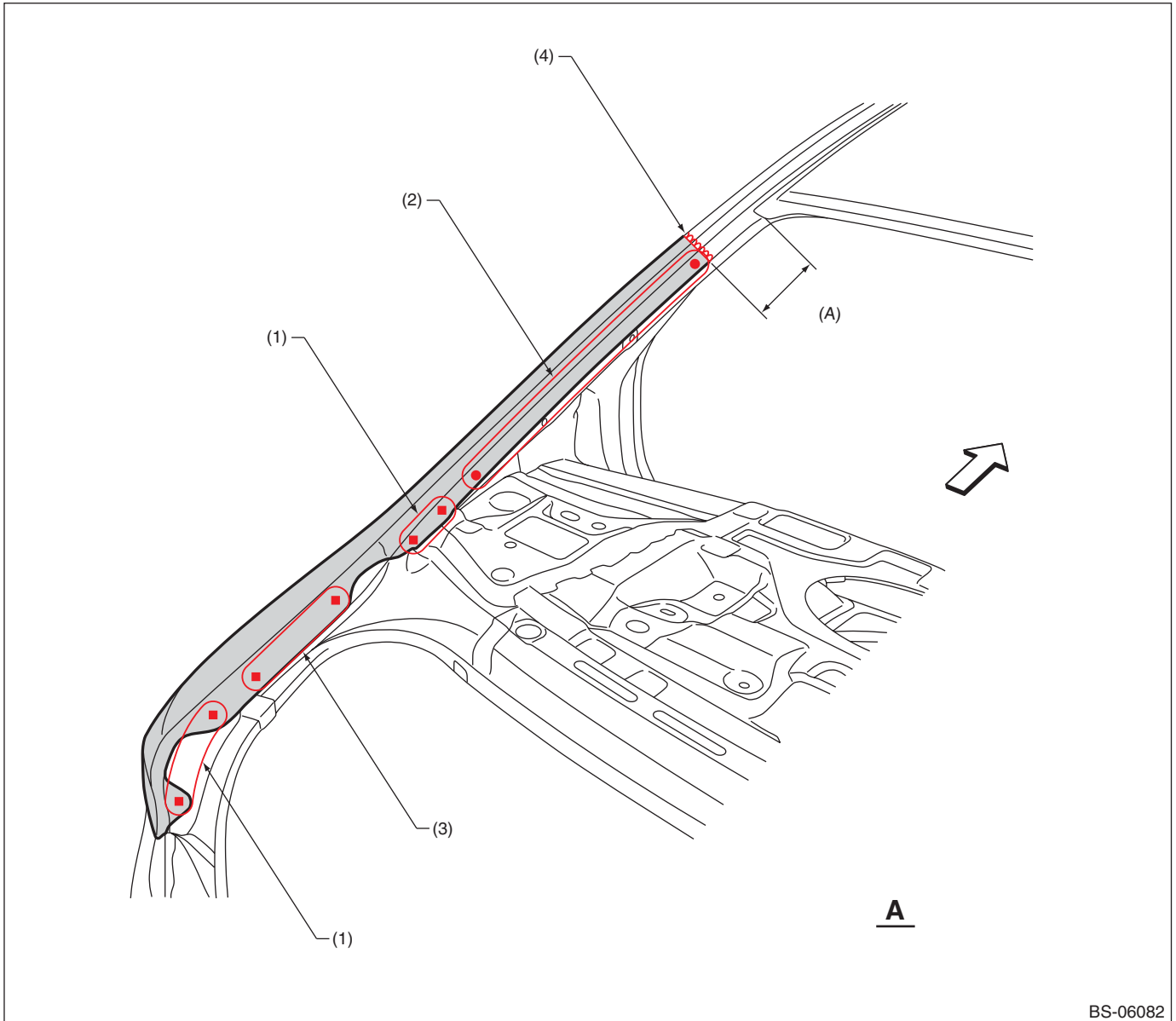
Note: Apply a panel bonding adhesive to part "a".

[e] Spot welding conditions

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

Panel Replacement

• Views 1



(A) 70 mm (2.76 in)

(1) 2 points (service)

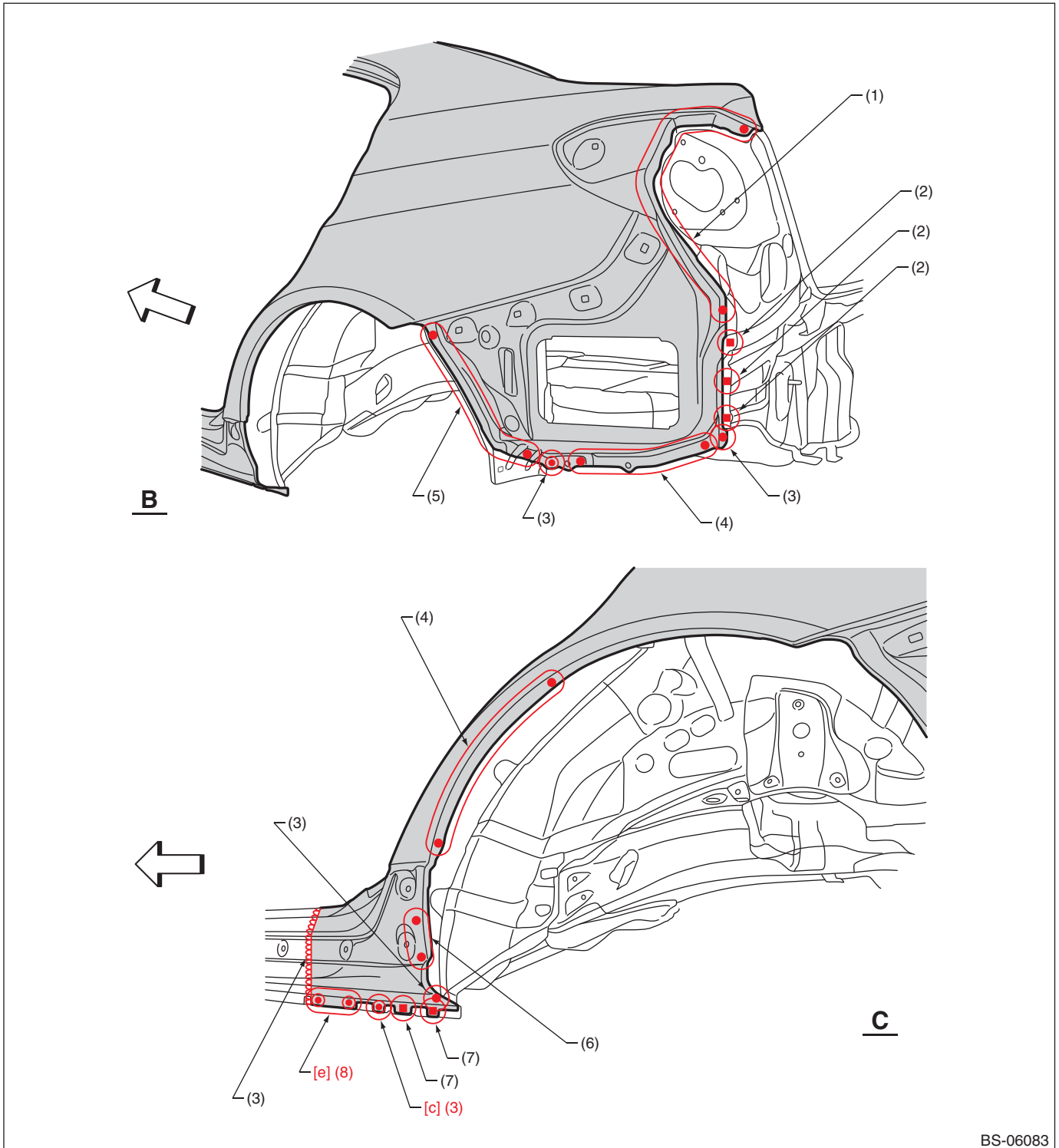
(2) 7 points

(3) 3 points (service)

(4) 1 point

Panel Replacement

• Views 2

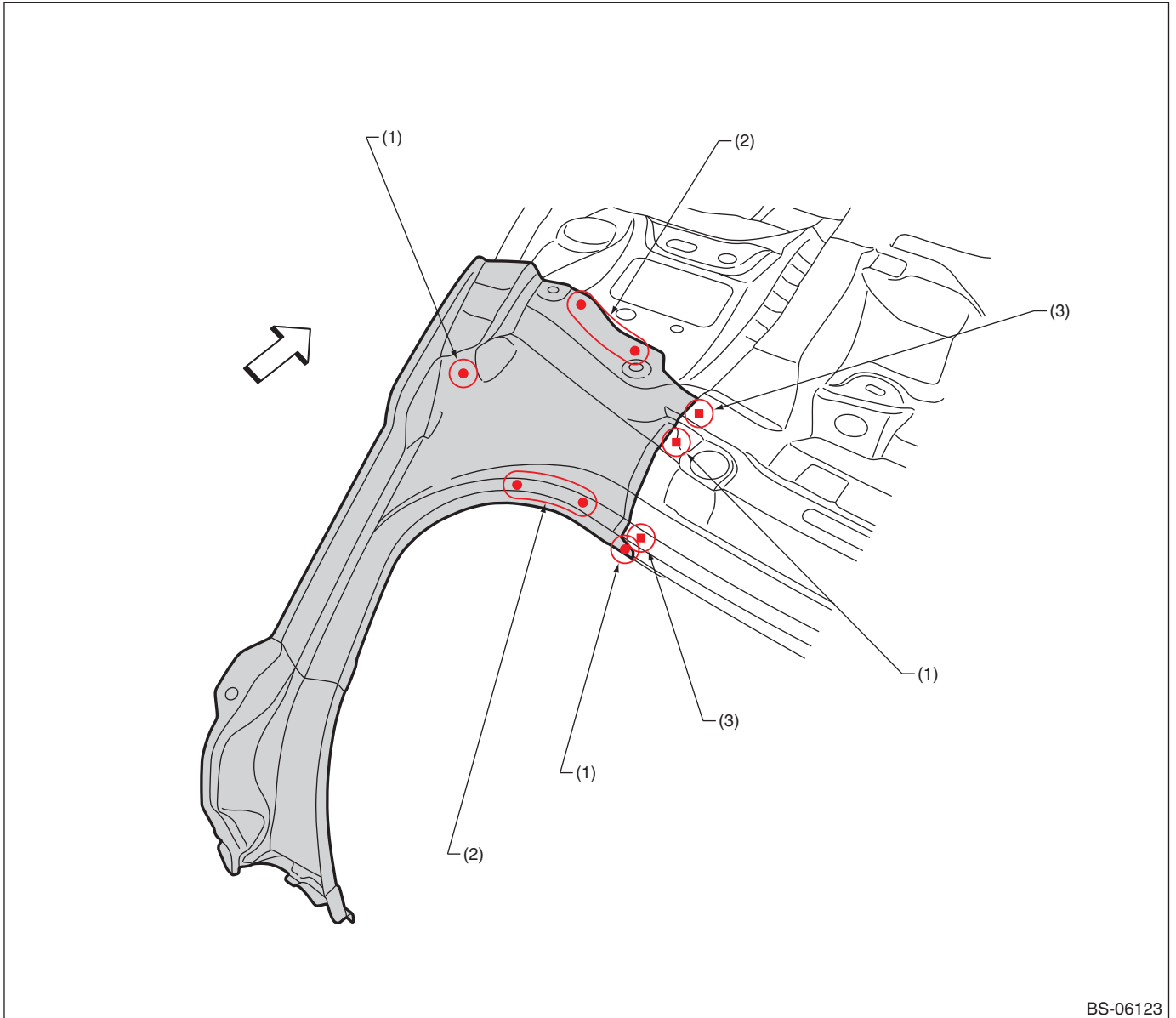


BS-06083

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

[c] Spot welding conditions	Compression: 3.0 kN, Current: 6.5 kA, Welding time: 25 cyc
[e] Spot welding conditions	Compression: 3.5 kN, Current: 7.5 kA, Welding time: 16 cyc

Panel Replacement



(1) 1 point

(2) 2 points

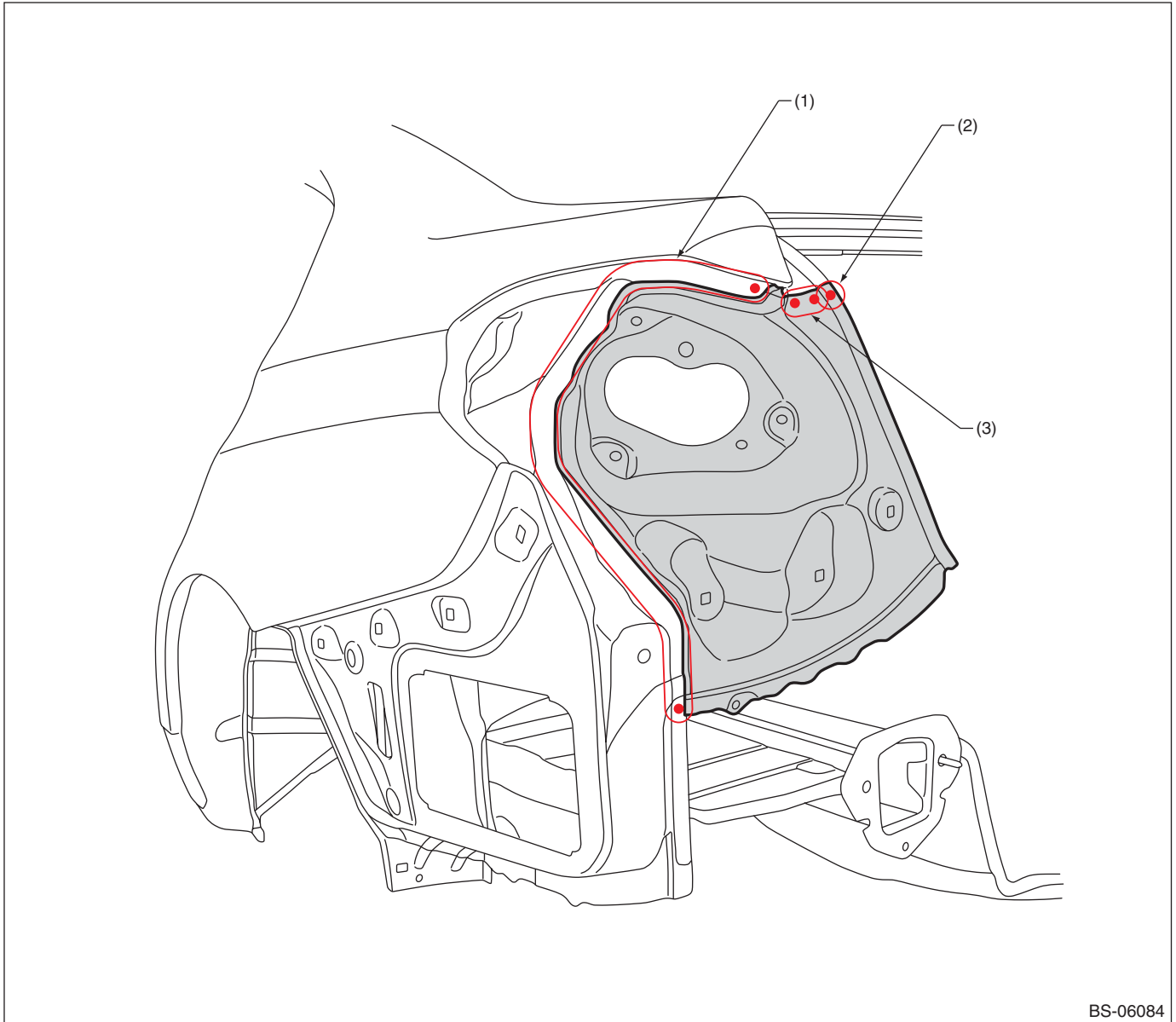
(3) 1 point (service · matching)

Panel Replacement

7-13. Rear Quarter End Panel (total replacement)

A: REMOVAL

- Rear skirt removal condition



BS-06084

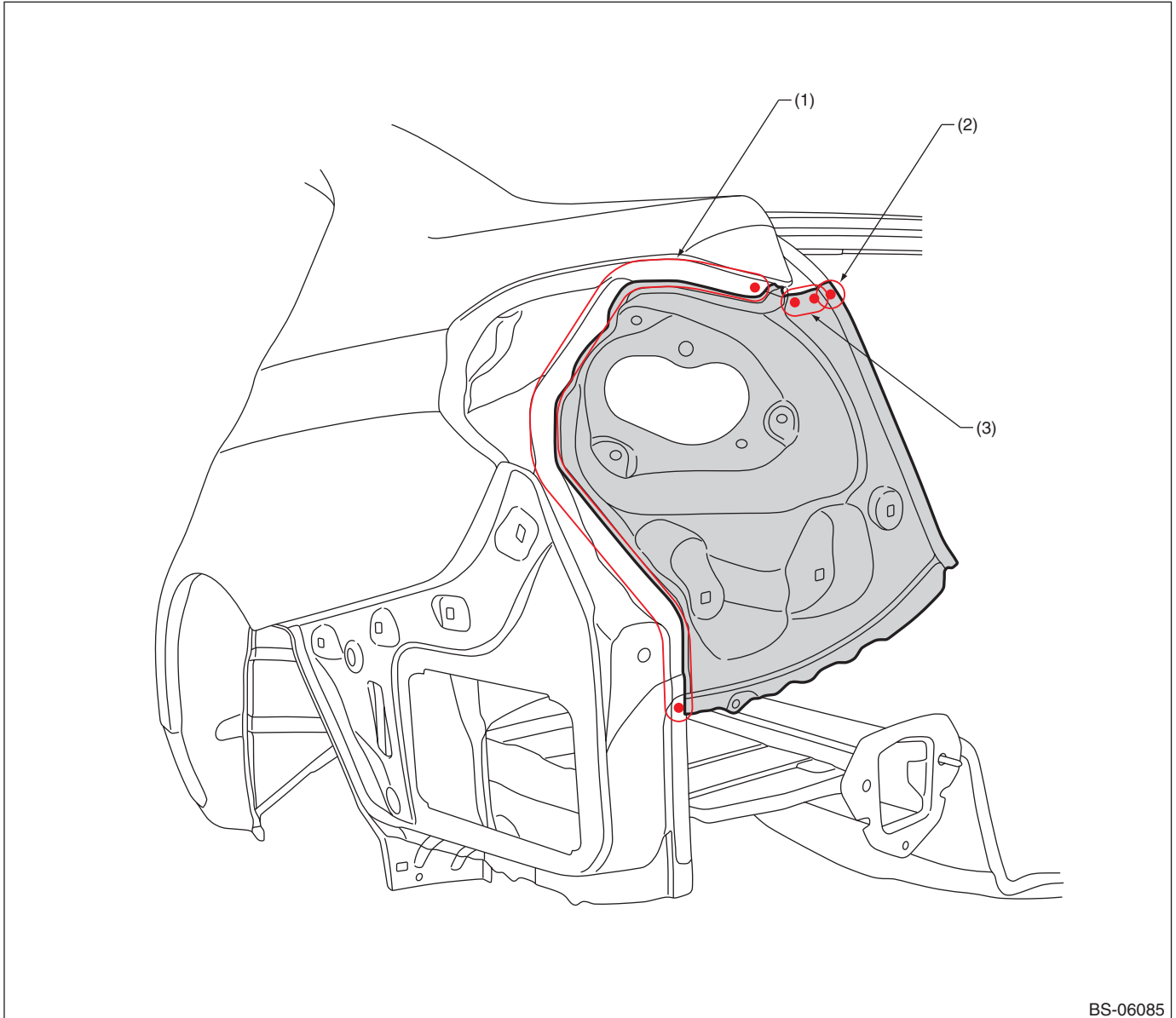
(1) 11 point (inside · 1)

(2) 1 point (outside · 1)

(3) 2 points (outside · 1)

Panel Replacement

B: INSTALLATION



BS-06085

(1) 11 point

(2) 1 point

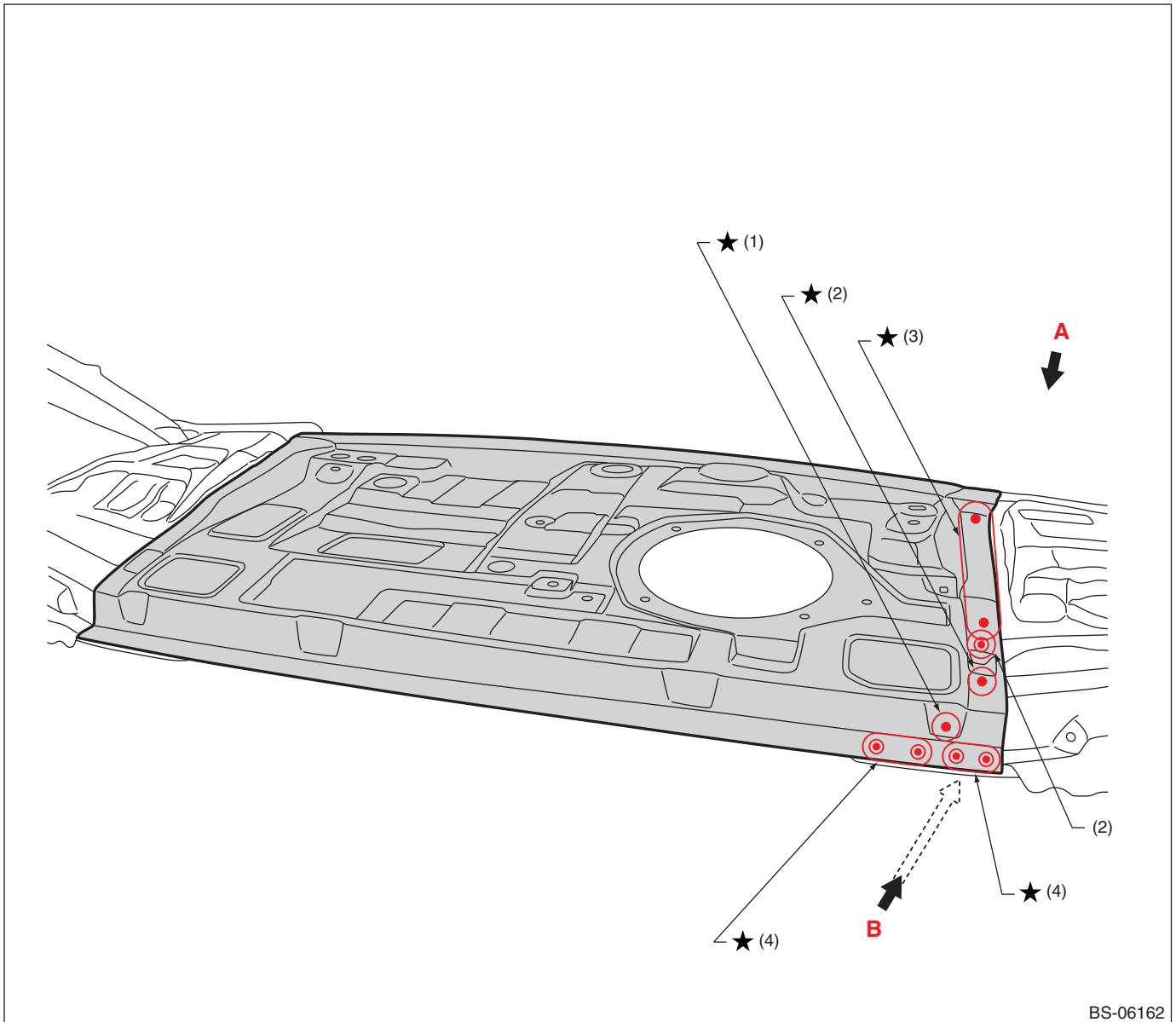
(3) 2 points

Panel Replacement

7-14. Rear Panel (total replacement)

A: REMOVAL

• Overall view



(1) 1 point (inside · 1)

(3) 6 points (top · 1)

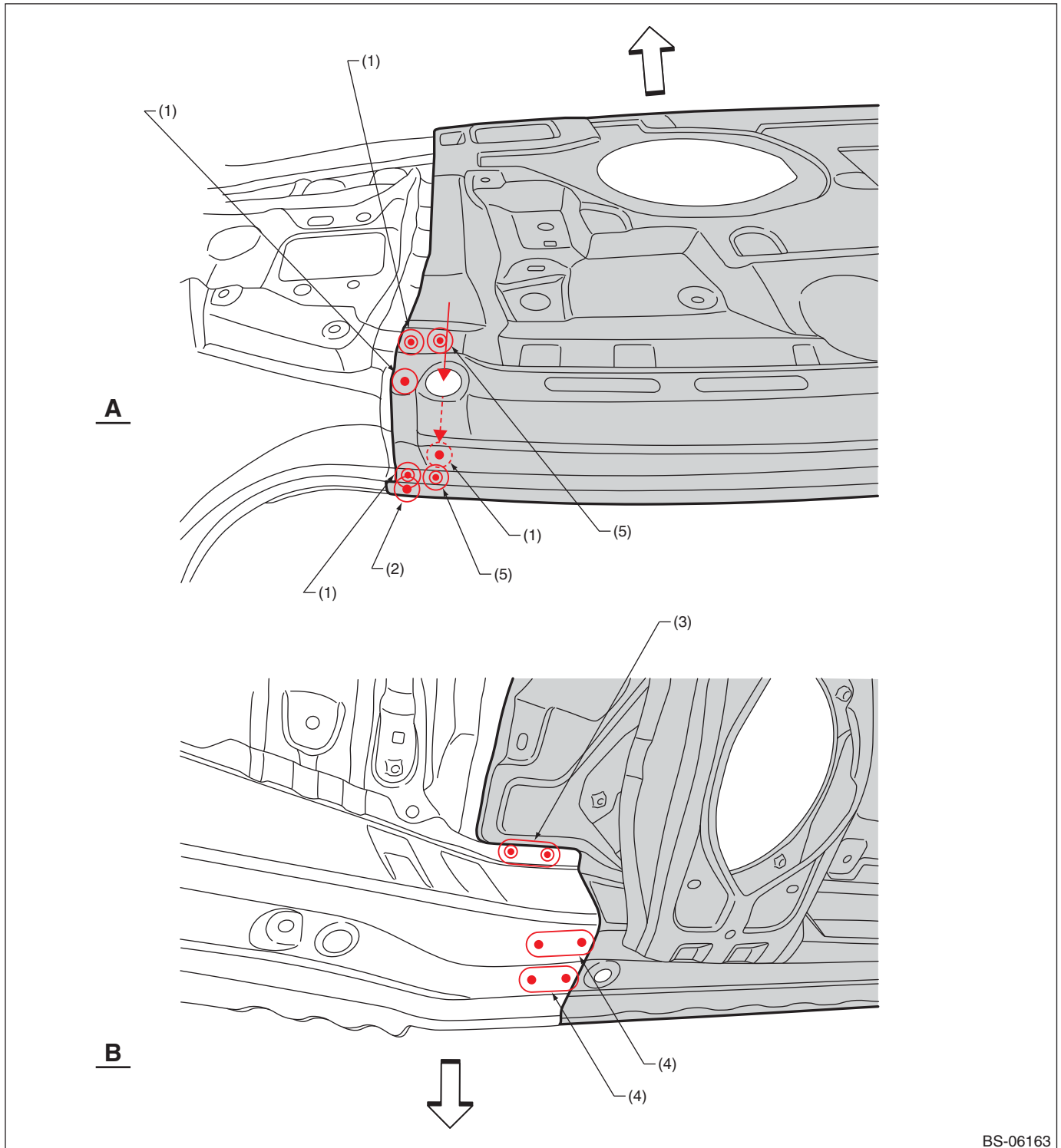
(4) 2 points (top · 1)

(2) 1 point (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



BS-06163

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

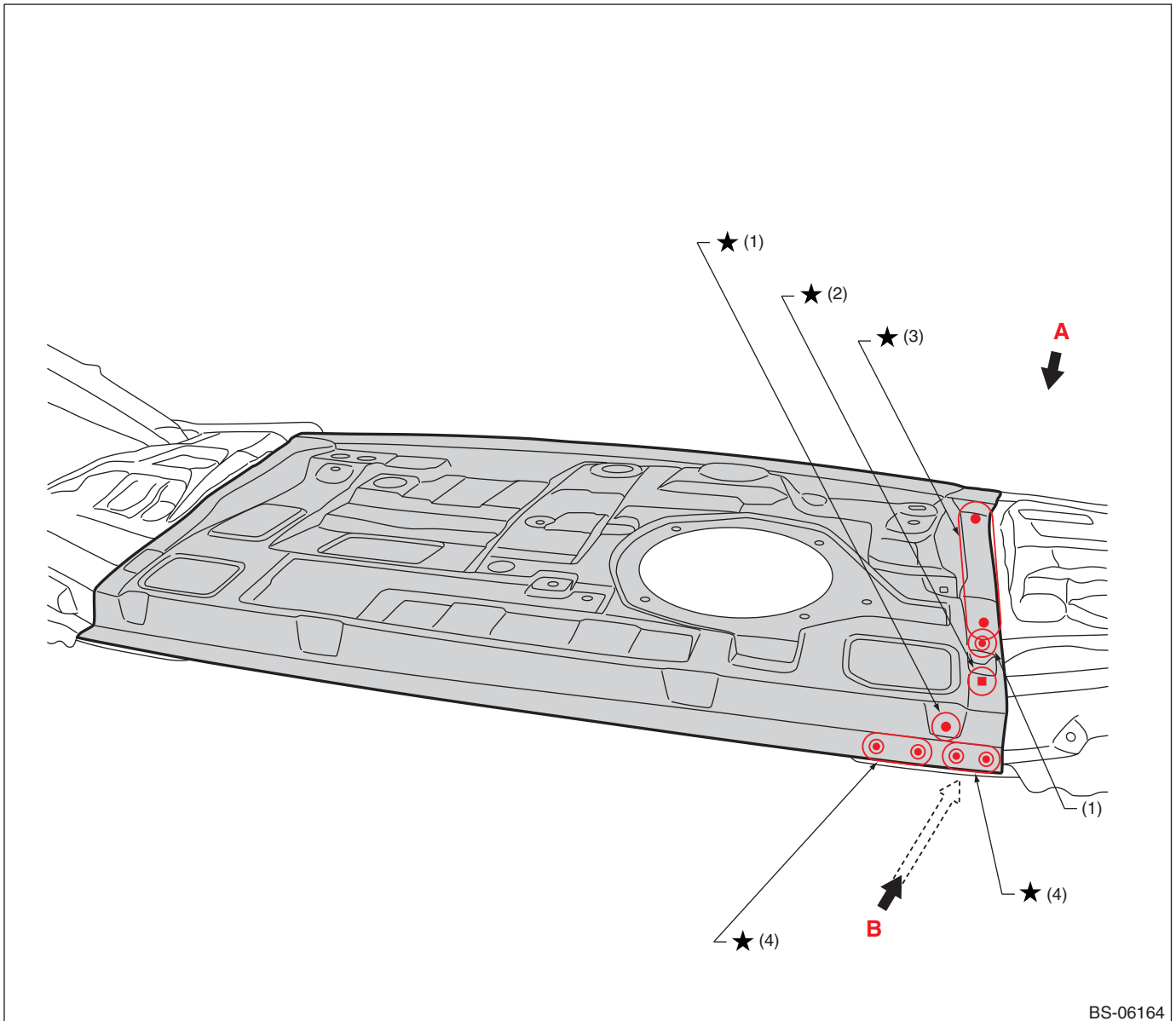
- (3) 2 points (top · 2)
(4) 2 points (top · 1)

- (5) 1 point (top · 2)

Panel Replacement

B: INSTALLATION

• Overall view



(1) 1 point

(2) 1 point (service)

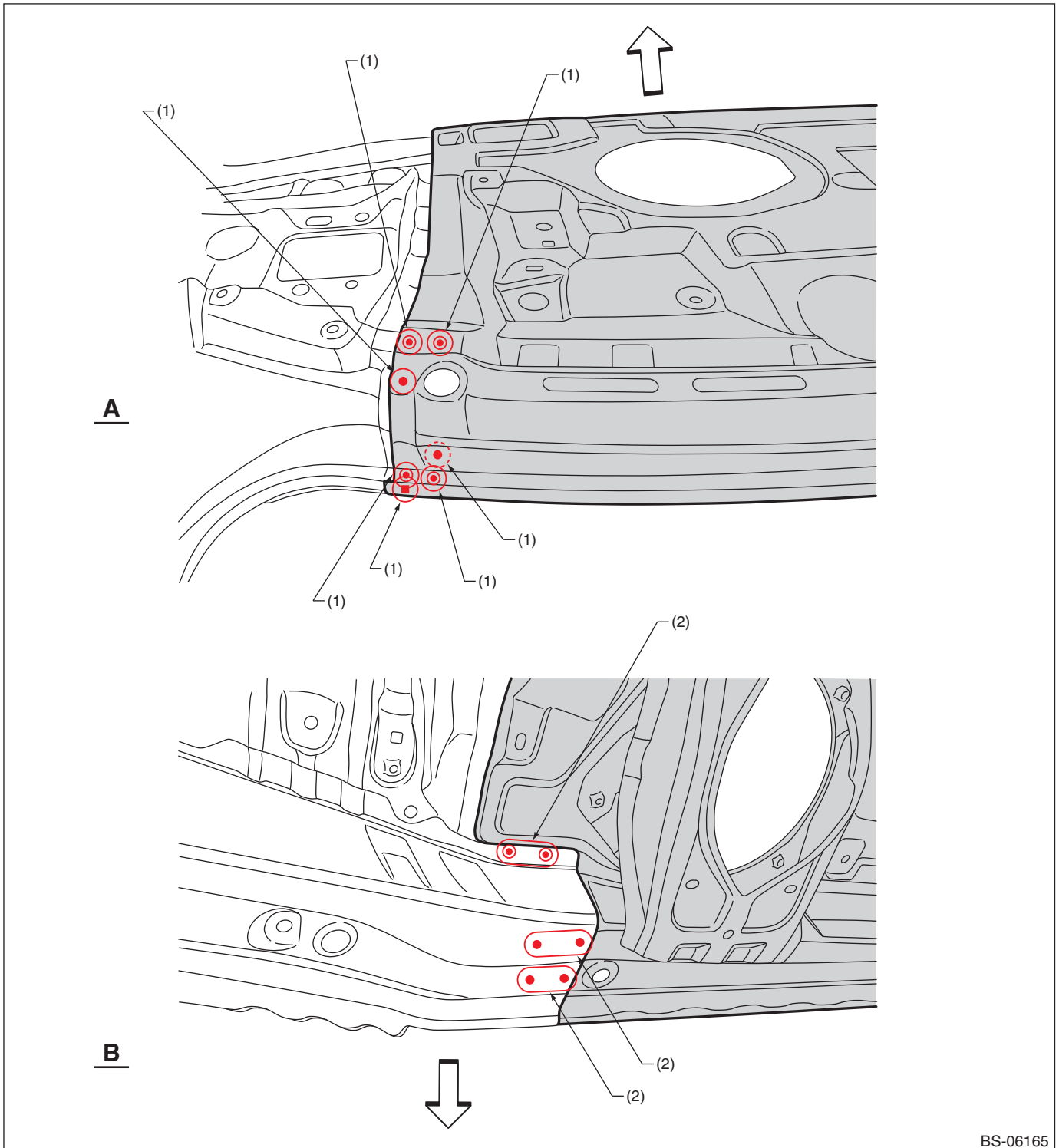
(3) 6 points

(4) 2 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



BS-06165

(1) 1 point

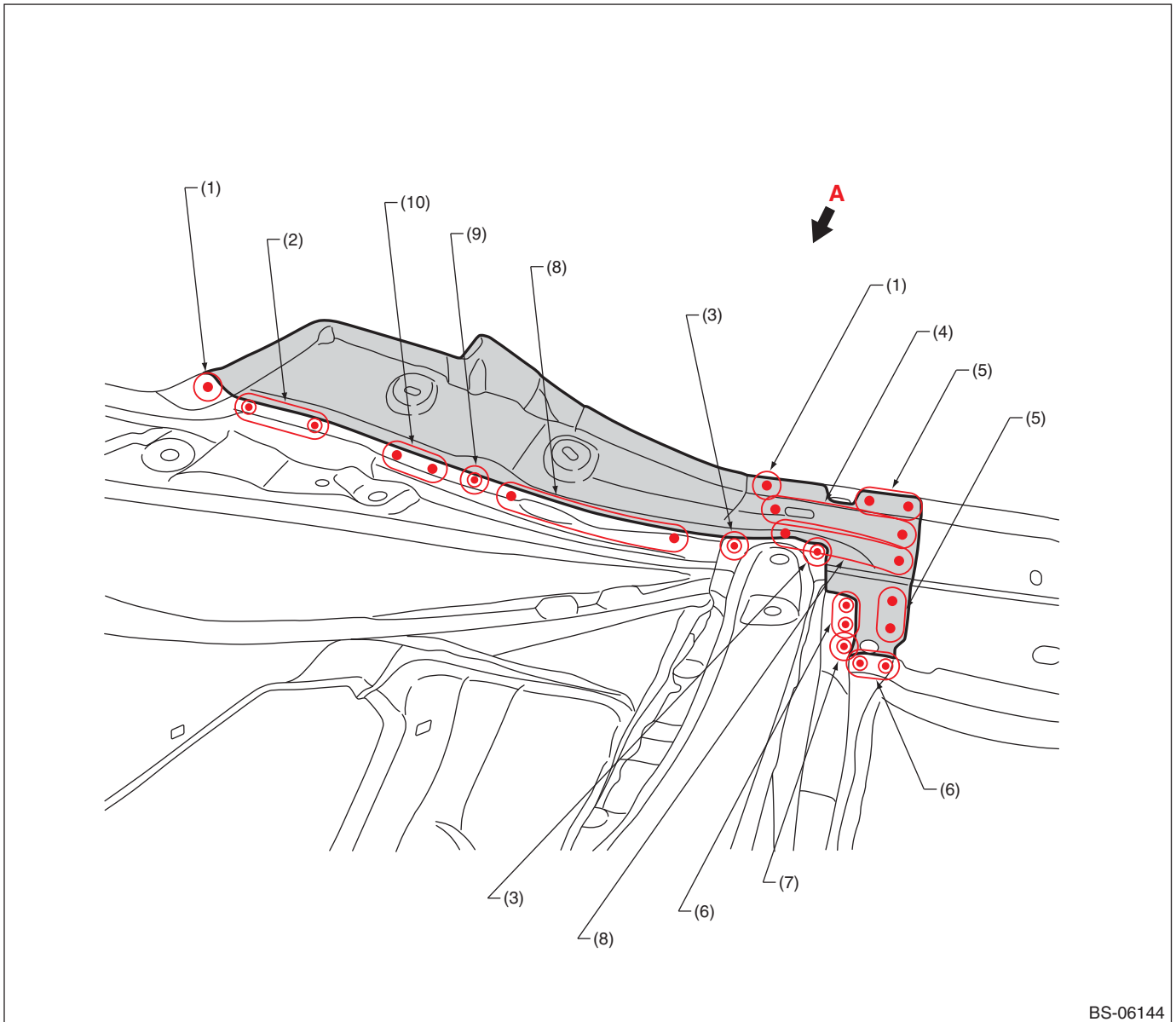
(2) 2 points

Panel Replacement

7-15. Side Sill Inner Rear (total replacement)

A: REMOVAL

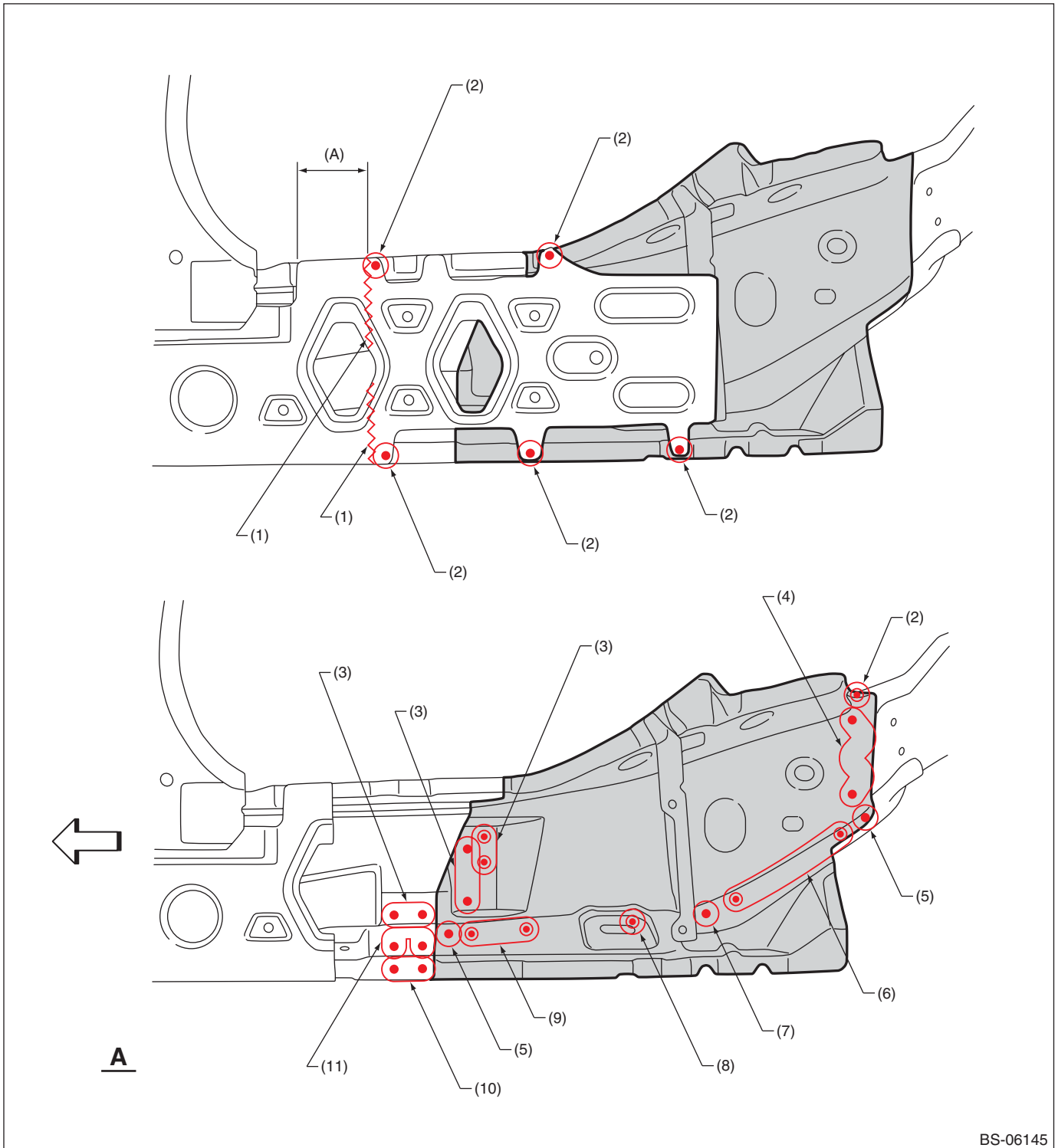
- Overall view (Rear quarter outer & inner and side sill reinforcement outer removal condition)



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

Panel Replacement

• Views



BS-06145

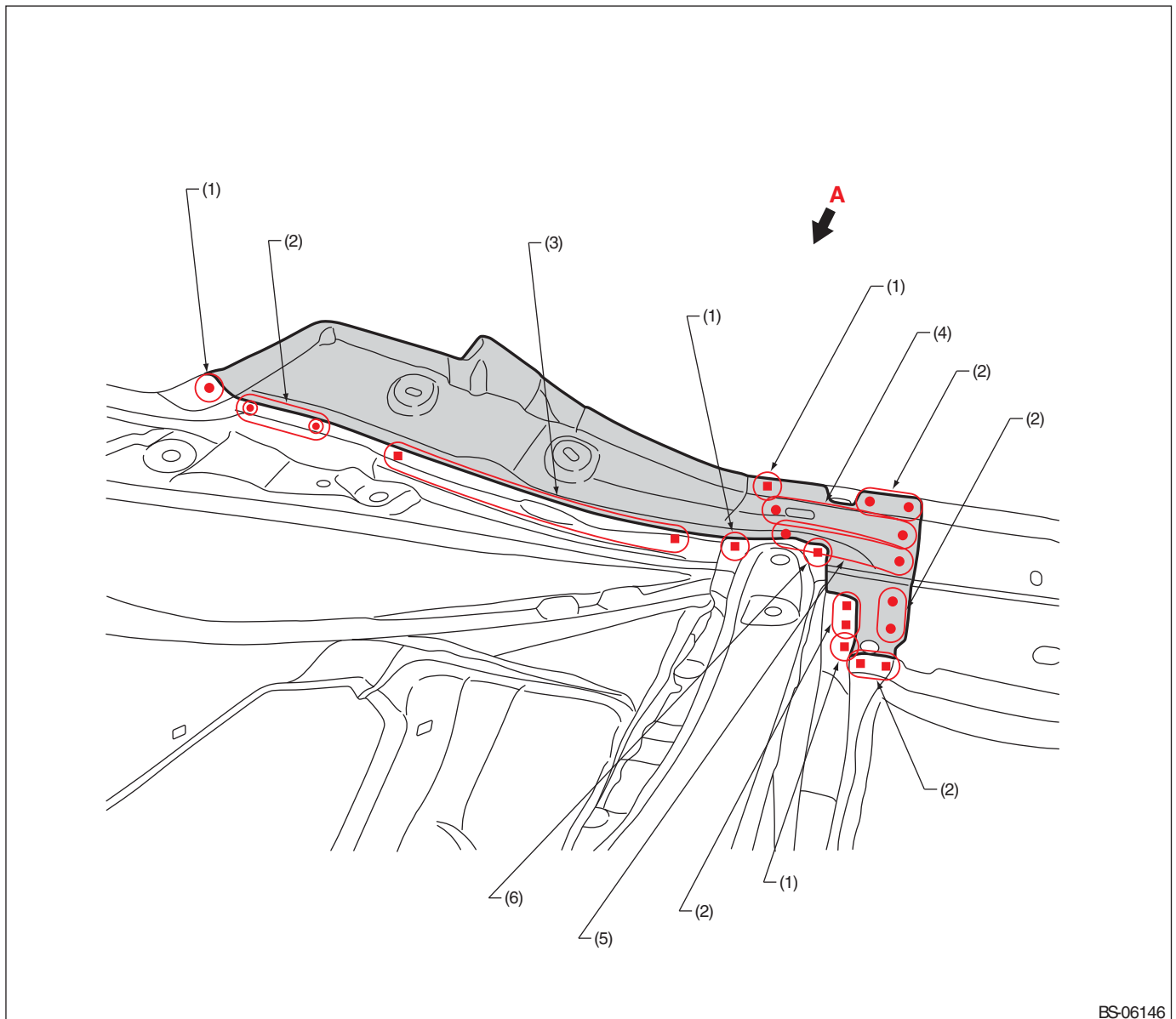
(A) 60 mm (2.36 in)

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

Panel Replacement

B: INSTALLATION

• Overall view



BS-06146

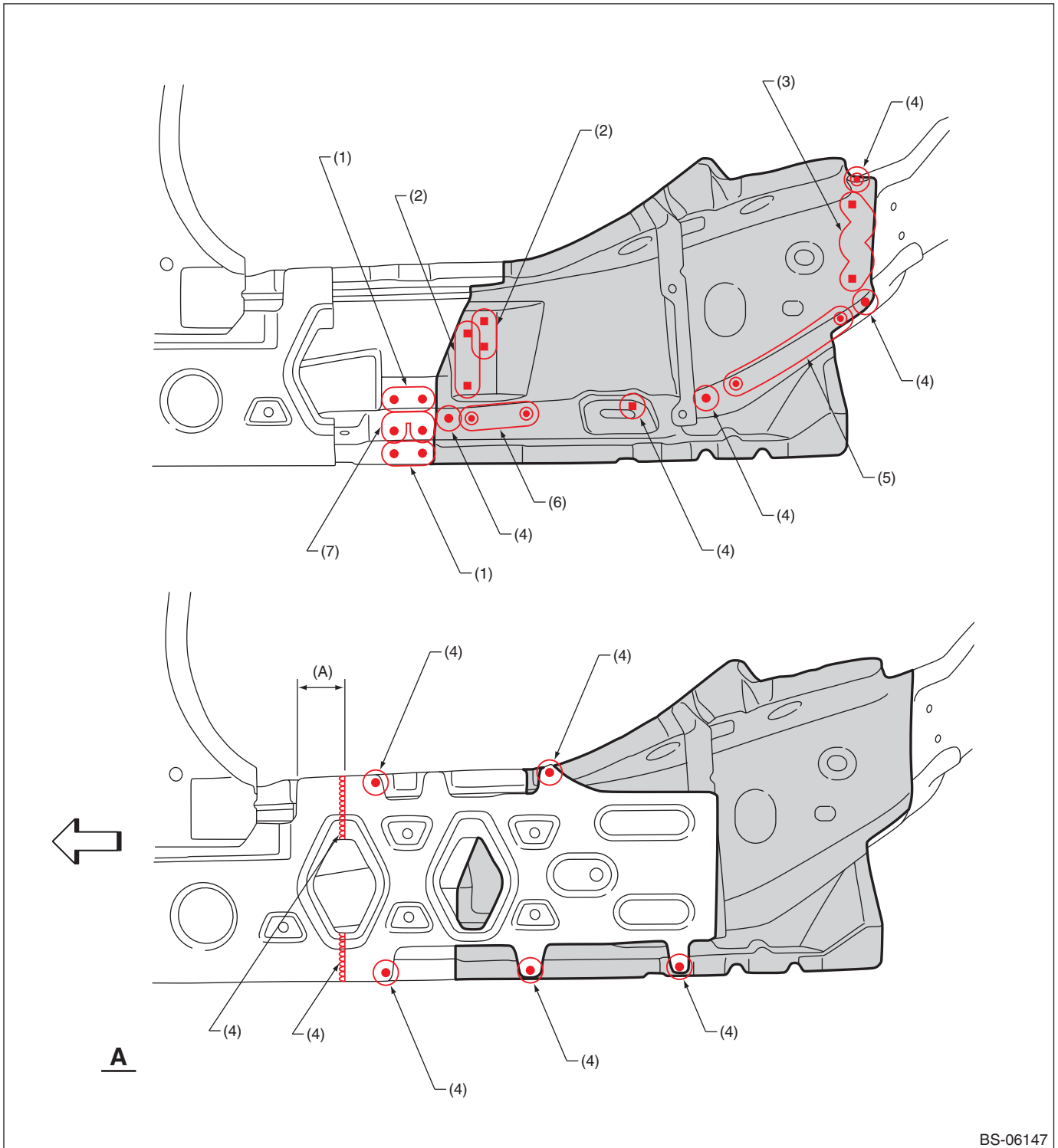
(1) 1 point
(2) 2 points

(3) 6 points
(4) 4 points

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

Panel Replacement

• Views



BS-06147

(A) 40 mm (1.57 in)

(1) 2 points

(2) 2 points (service)

(3) 5 points (service)

(4) 1 point

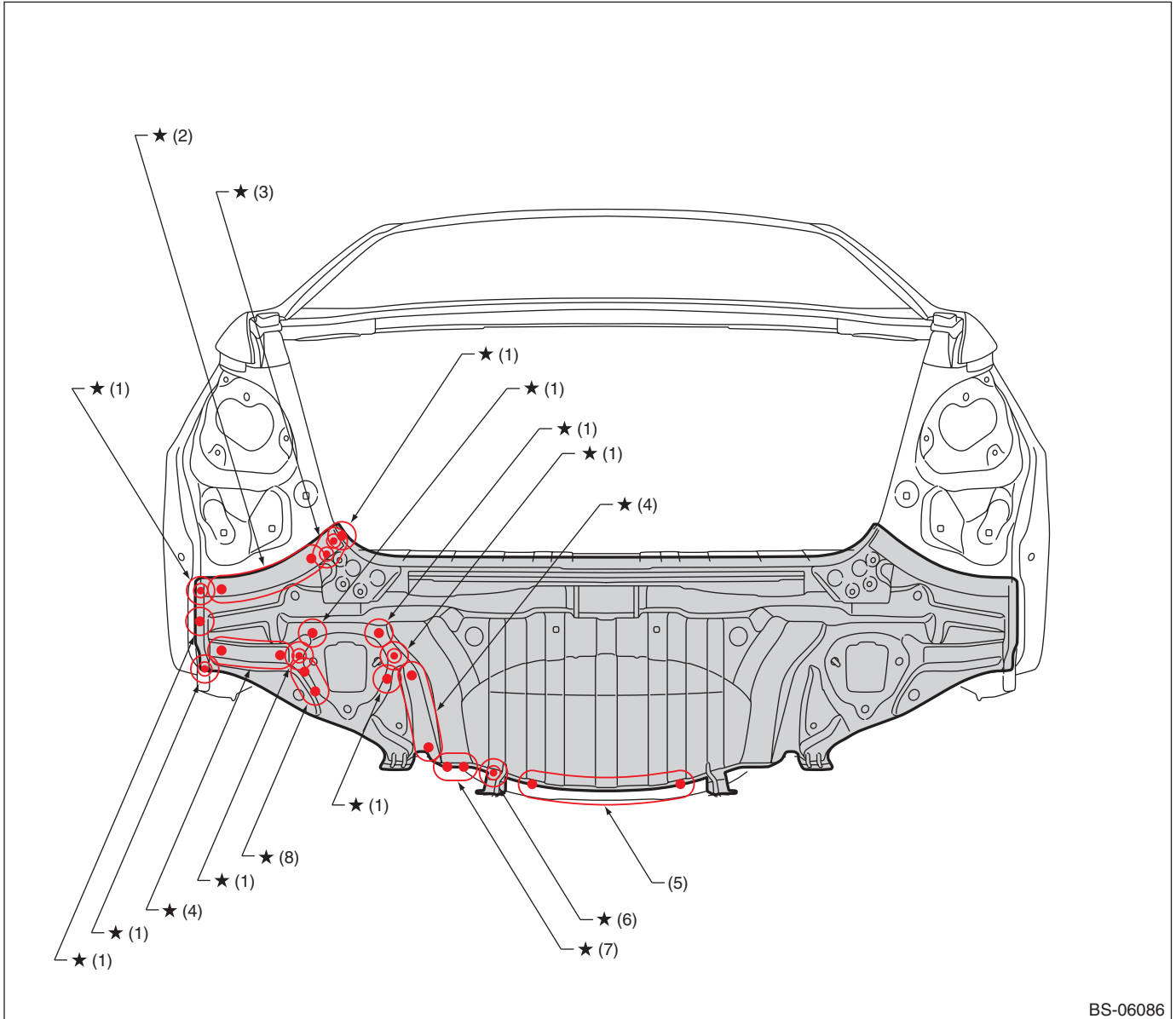
(5) 5 points

(6) 3 points

(7) 4 points

7-16. Rear Skirt (total replacement)

A: REMOVAL



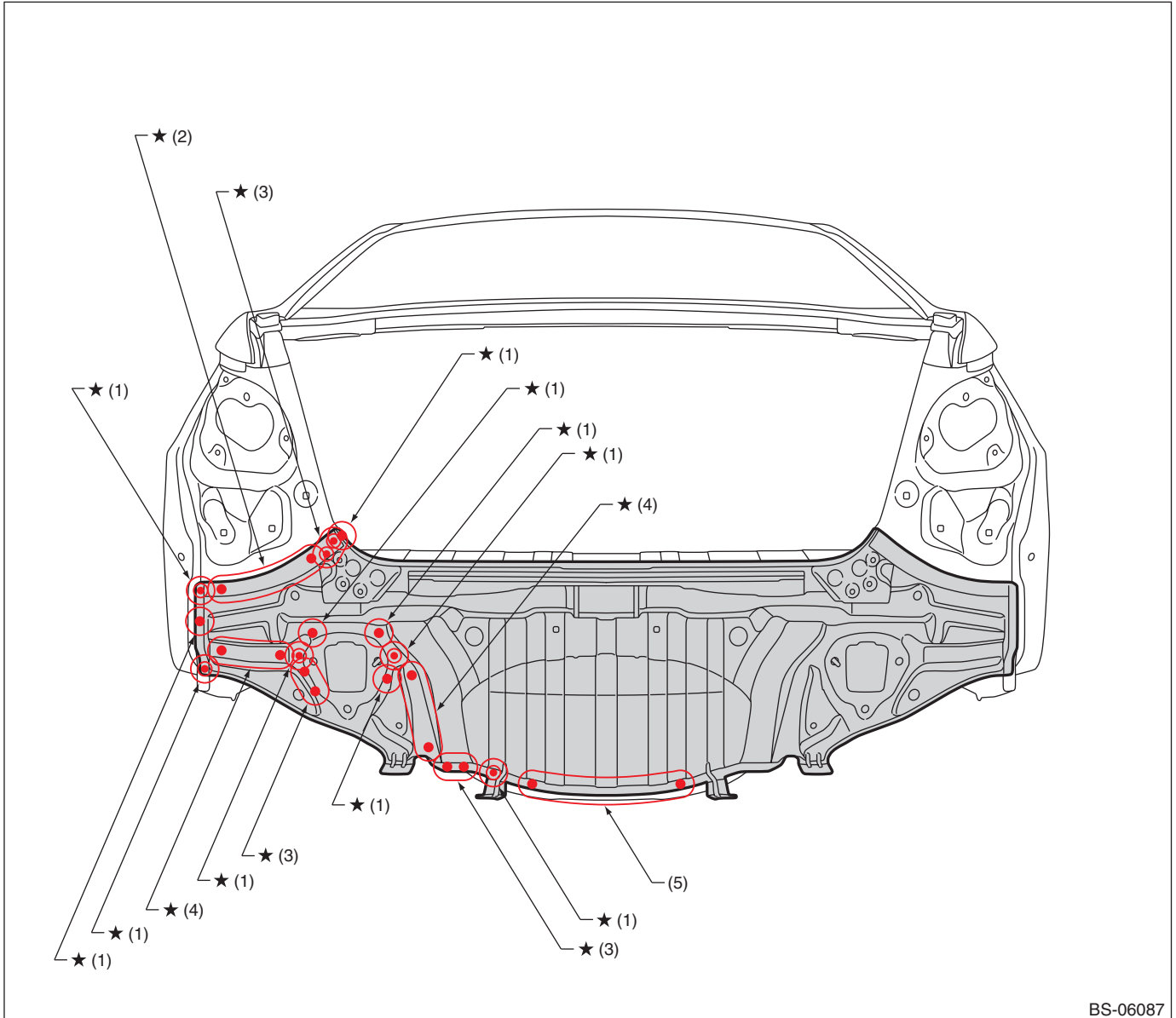
- (1) 1 point (outside · 1)
- (2) 7 points (outside · 1)
- (3) 2 points (outside · 2)

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

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

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

B: INSTALLATION



(1) 1 point
(2) 7 points

(3) 2 points
(4) 4 points

(5) 5 points

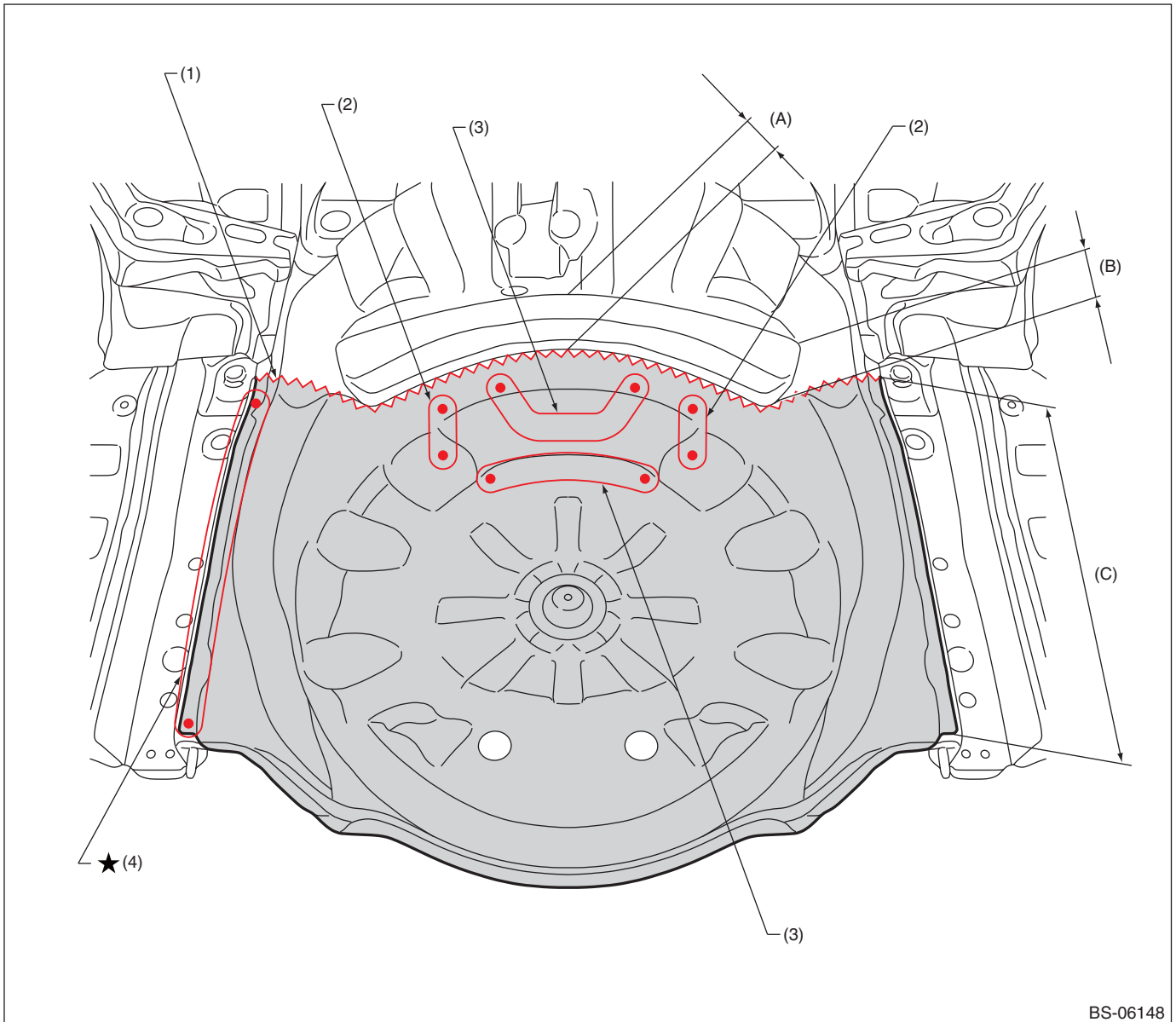
For locations marked by “★”: the welding method and the number of welding points are the same on the left and the right.

Panel Replacement

7-17. Rear Floor Pan (partial replacement)

A: REMOVAL

- Rear skirt and rear side frame upper rear removal condition



BS-06148

(A) 70 mm (2.76 in)

(B) 90 mm (3.54 in)

(C) 455 mm (17.91 in)

(1) Rough cutting

(3) 4 points (outside · 1)

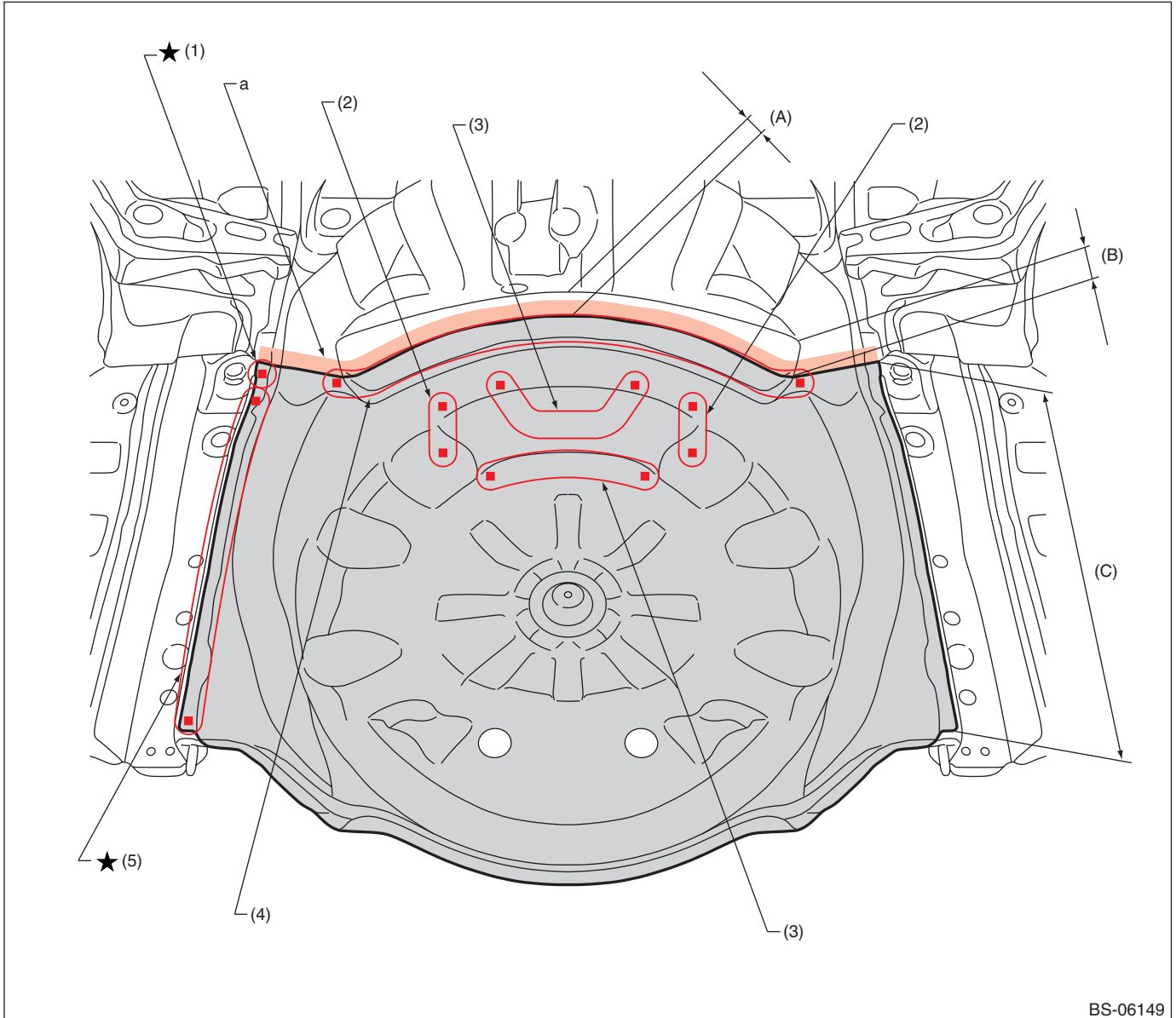
(4) 9 points (top · 1)

(2) 2 points (outside · 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



(A) 30 mm (1.18 in)

(B) 60 mm (2.36 in)

(C) 470 mm (18.50 in)

(1) 1 point (service)

(3) 4 points (service)

(5) 9 points (service)

(2) 2 points (service)

(4) 12 points (service)

Note: Apply a sealing agent to the floor pan panel fitting parts of part “a”.

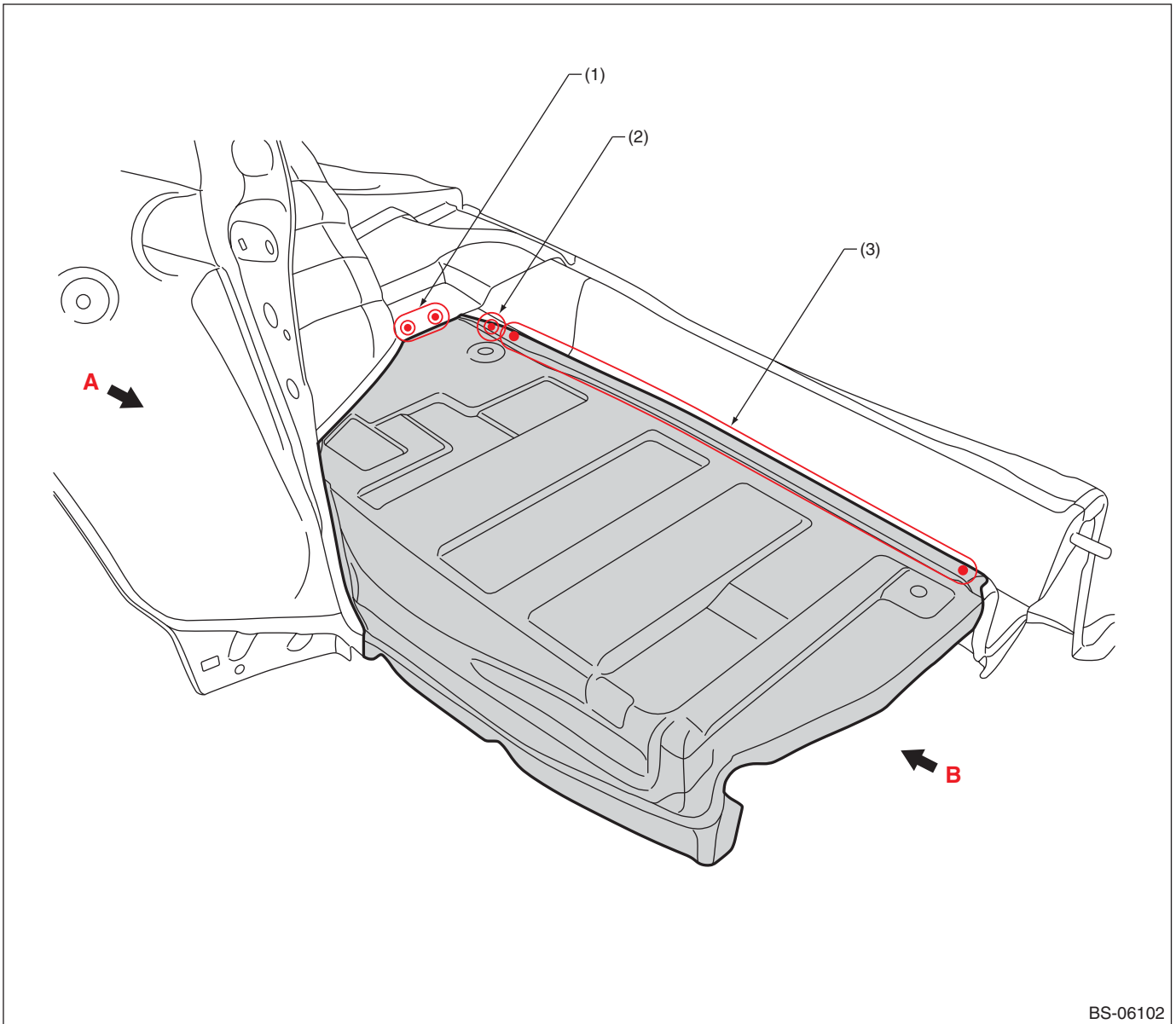
For locations marked by “★”: the welding method and the number of welding points are the same on the left and the right.

Panel Replacement

7-18. Rear Floor Side (total replacement)

A: REMOVAL

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



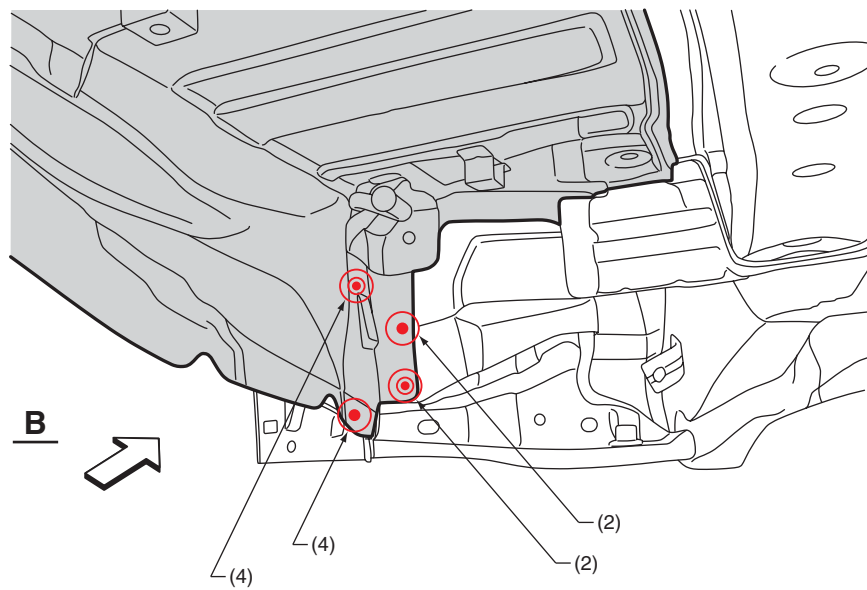
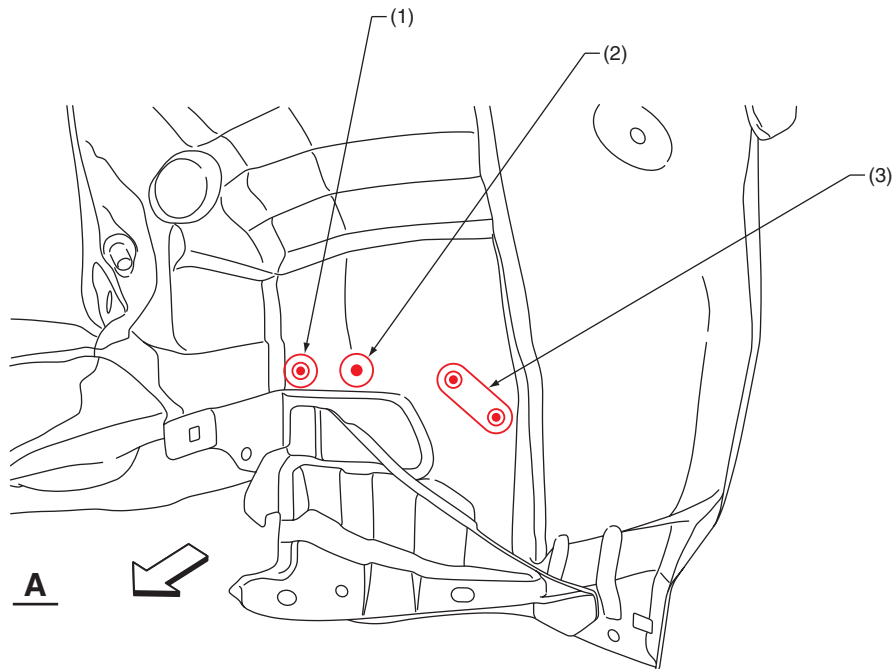
(1) 2 points (top · 2)

(2) 1 point (top · 1)

(3) 10 points (top · 1)

Panel Replacement

• Views



BS-06103

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

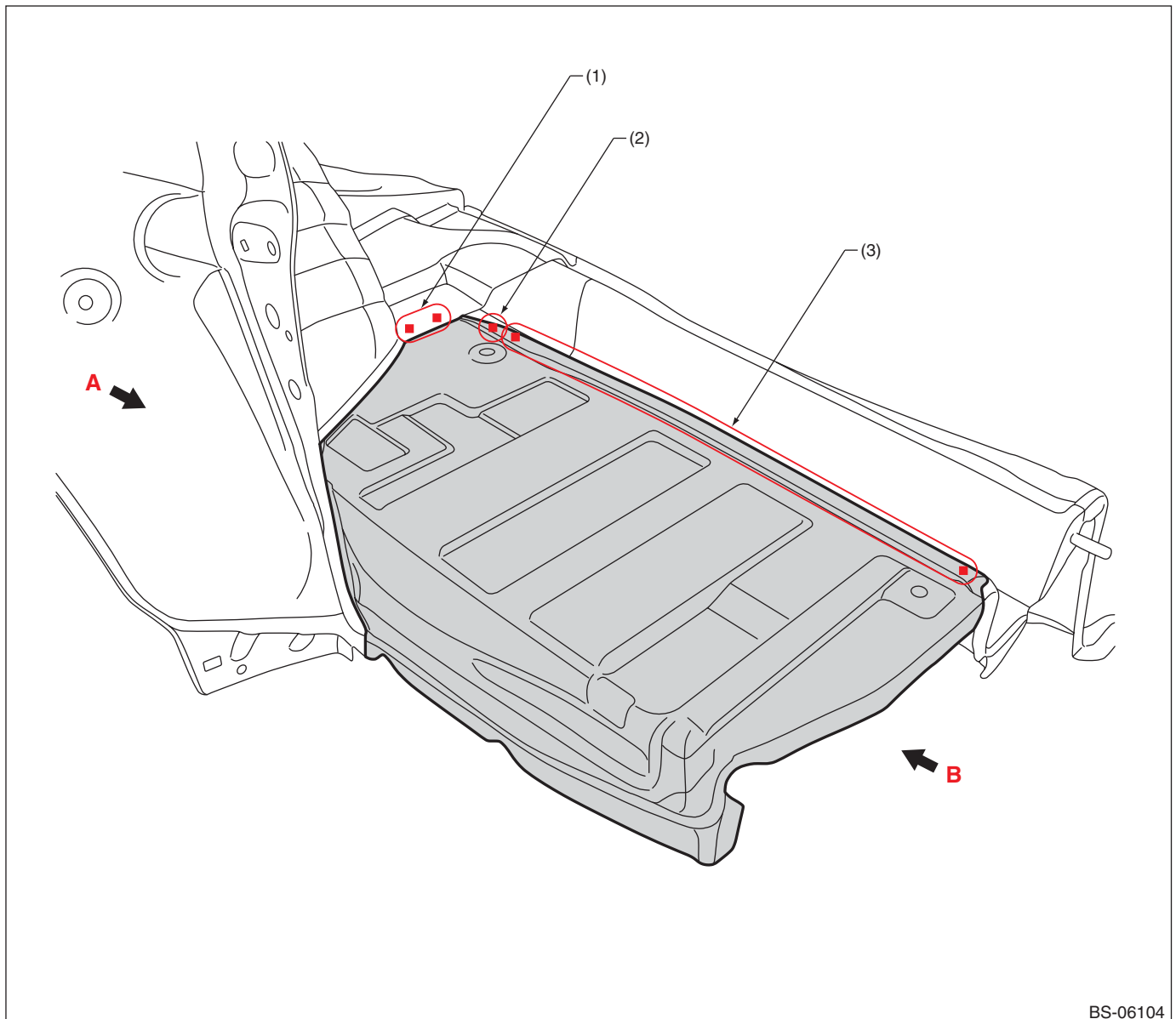
(3) 2 points (outside · 1)

(4) 1 point (inside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



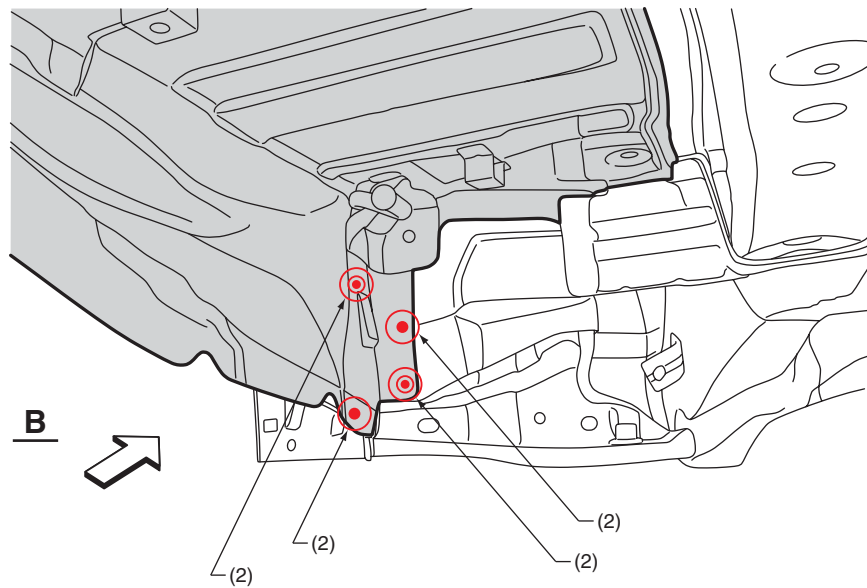
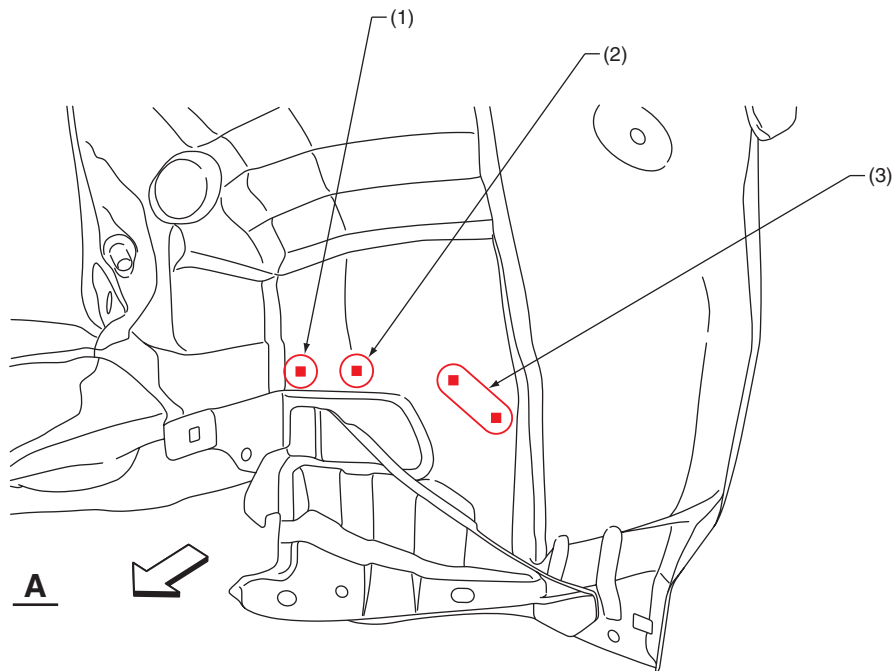
(1) 2 points (service · matching)

(2) 1 point (service)

(3) 10 points (service)

Panel Replacement

• Views



BS-06105

(1) 1 point (service · matching)

(2) 1 point

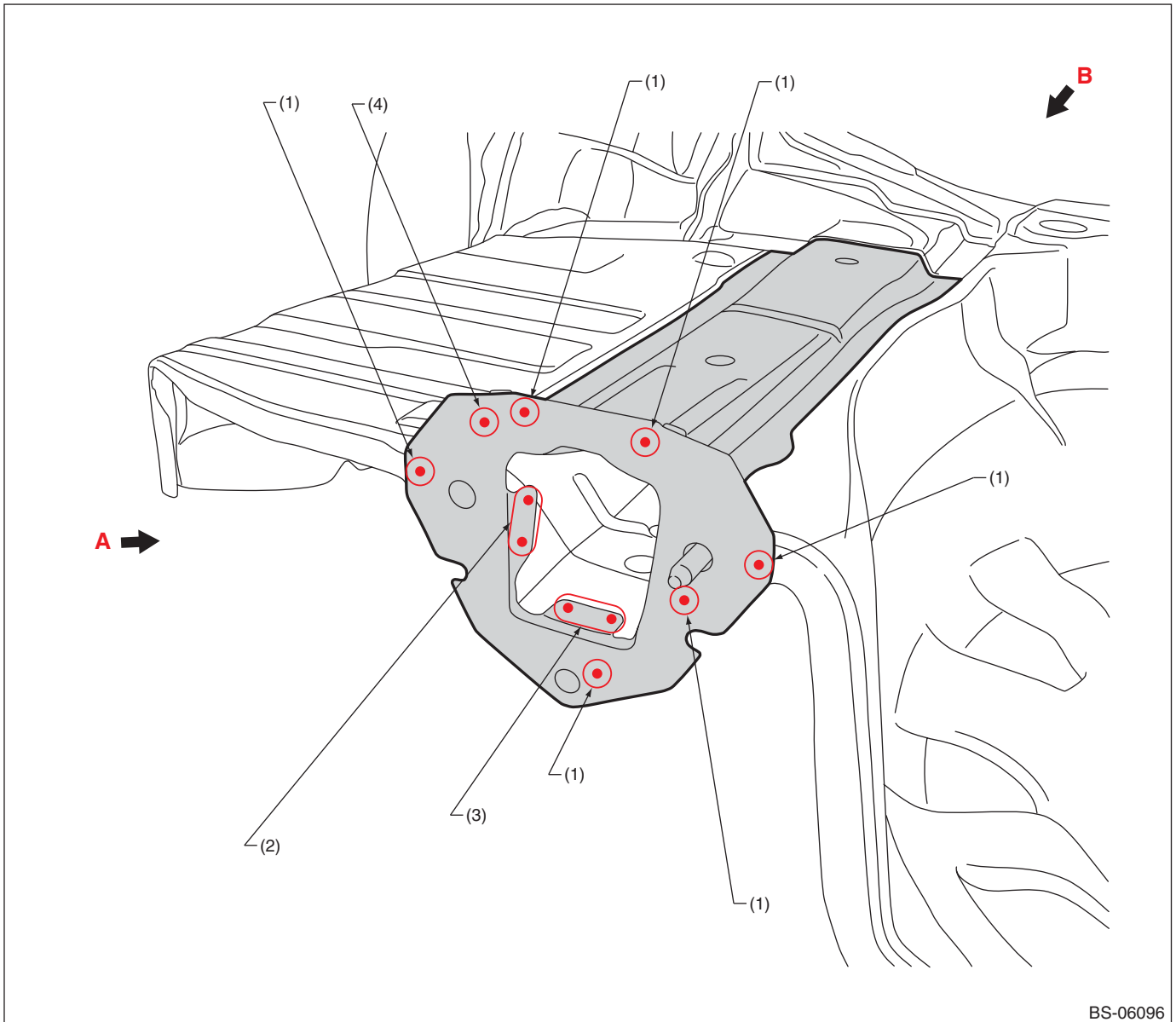
(3) 2 points

Panel Replacement

7-19. Rear Side Frame Upper Rear (total replacement)

A: REMOVAL

- Overall view (Rear skirt removal condition)



BS-06096

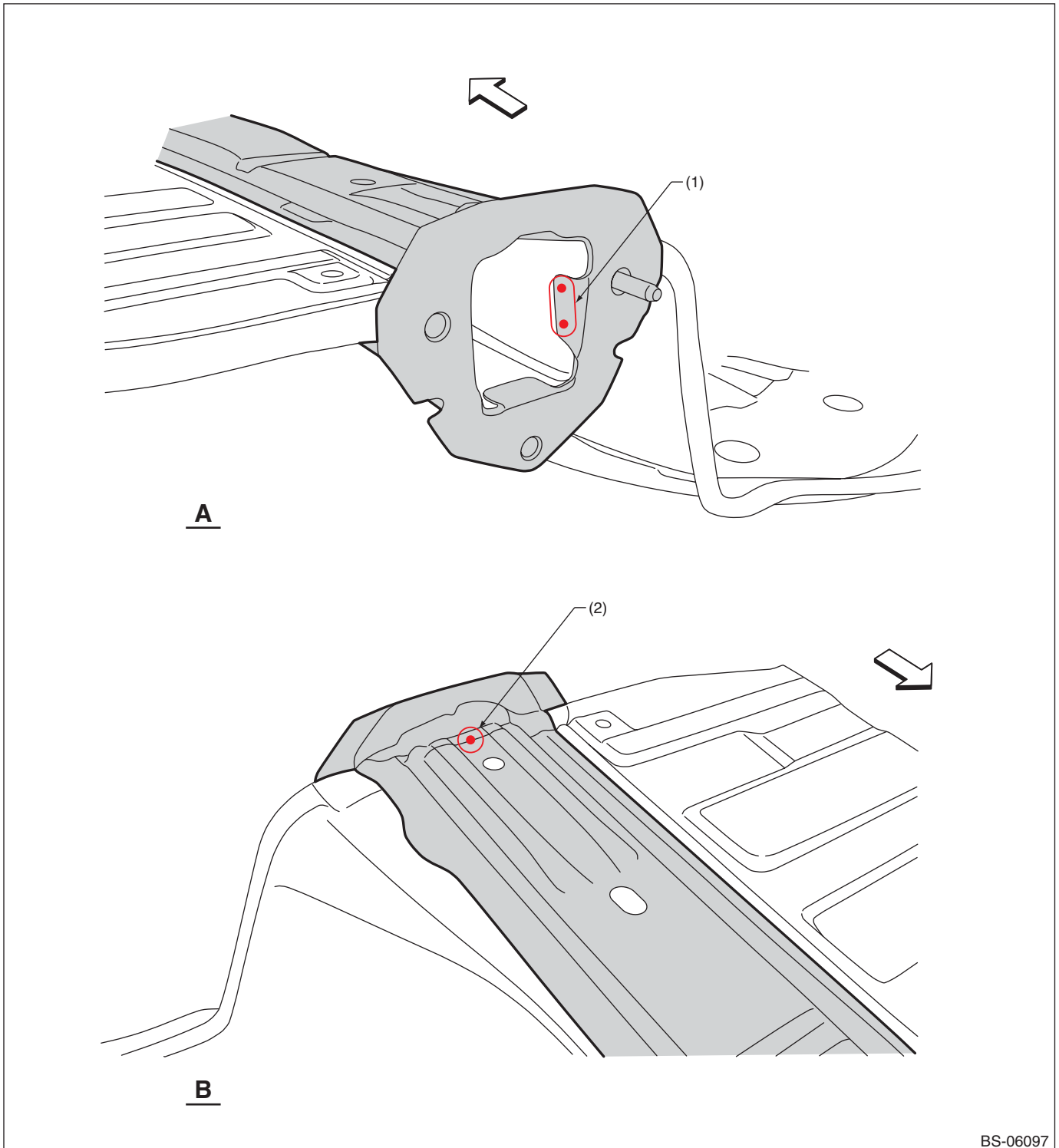
- (1) 1 point (outside · 1)
(2) 2 points (outside · 1)

- (3) 2 points (bottom · 1)

- (4) 1 point (outside · 1) (only LH)

Panel Replacement

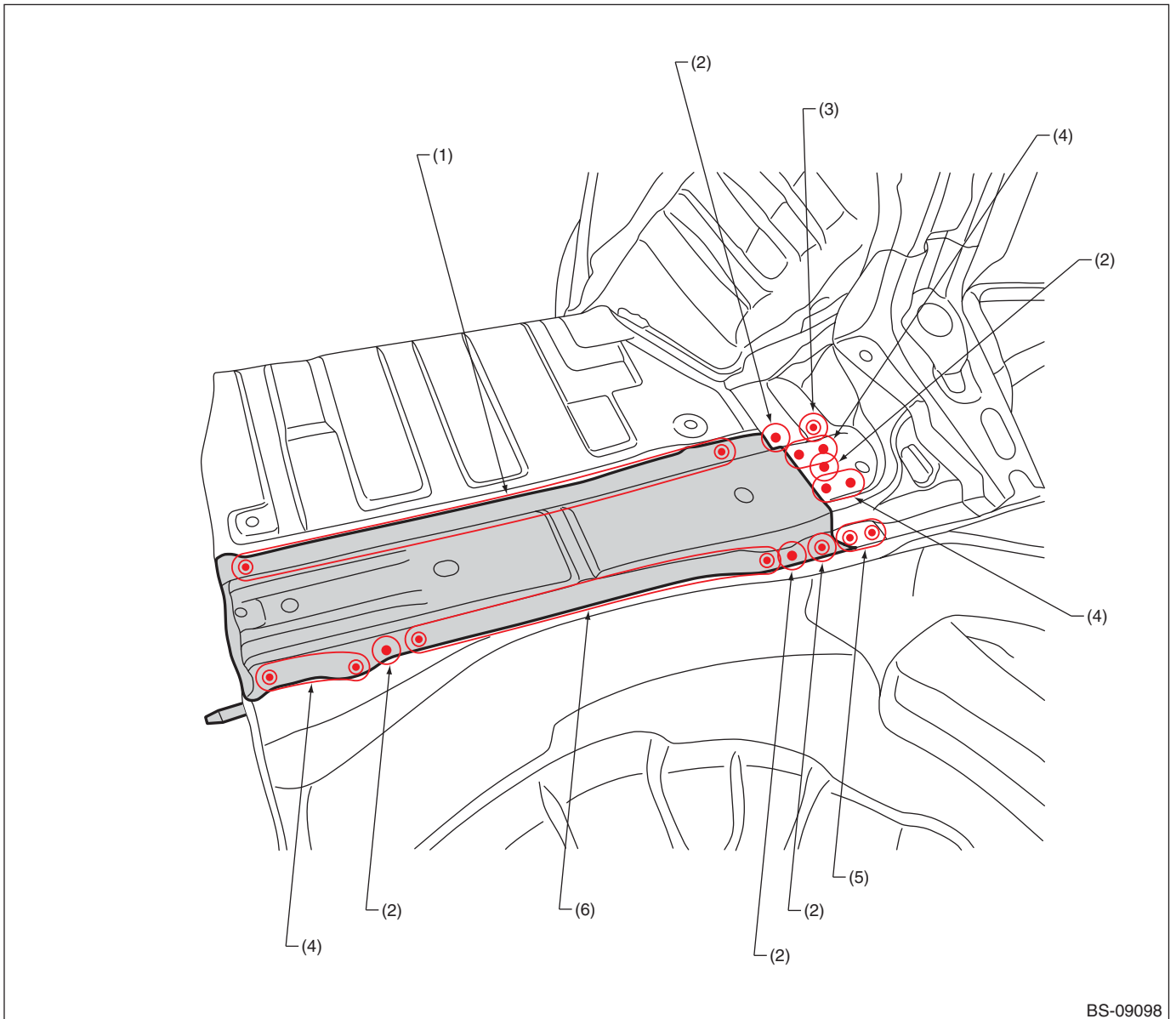
• Views



BS-06097

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

Panel Replacement



BS-09098

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

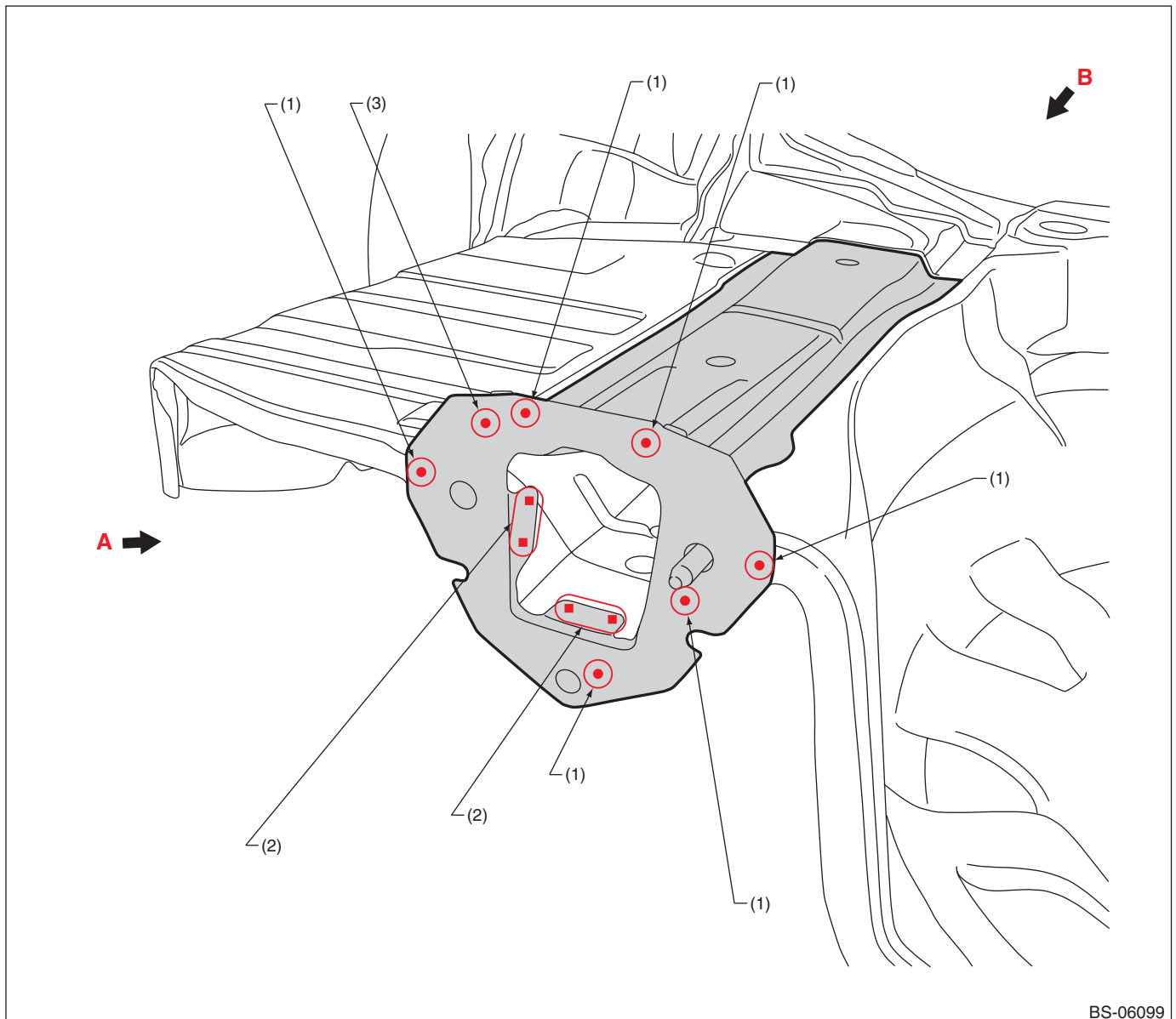
(3) 1 point (top · 2)
(4) 2 points (top · 1)

(5) 2 points (top · 2)
(6) 7 points (top · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BS-06099

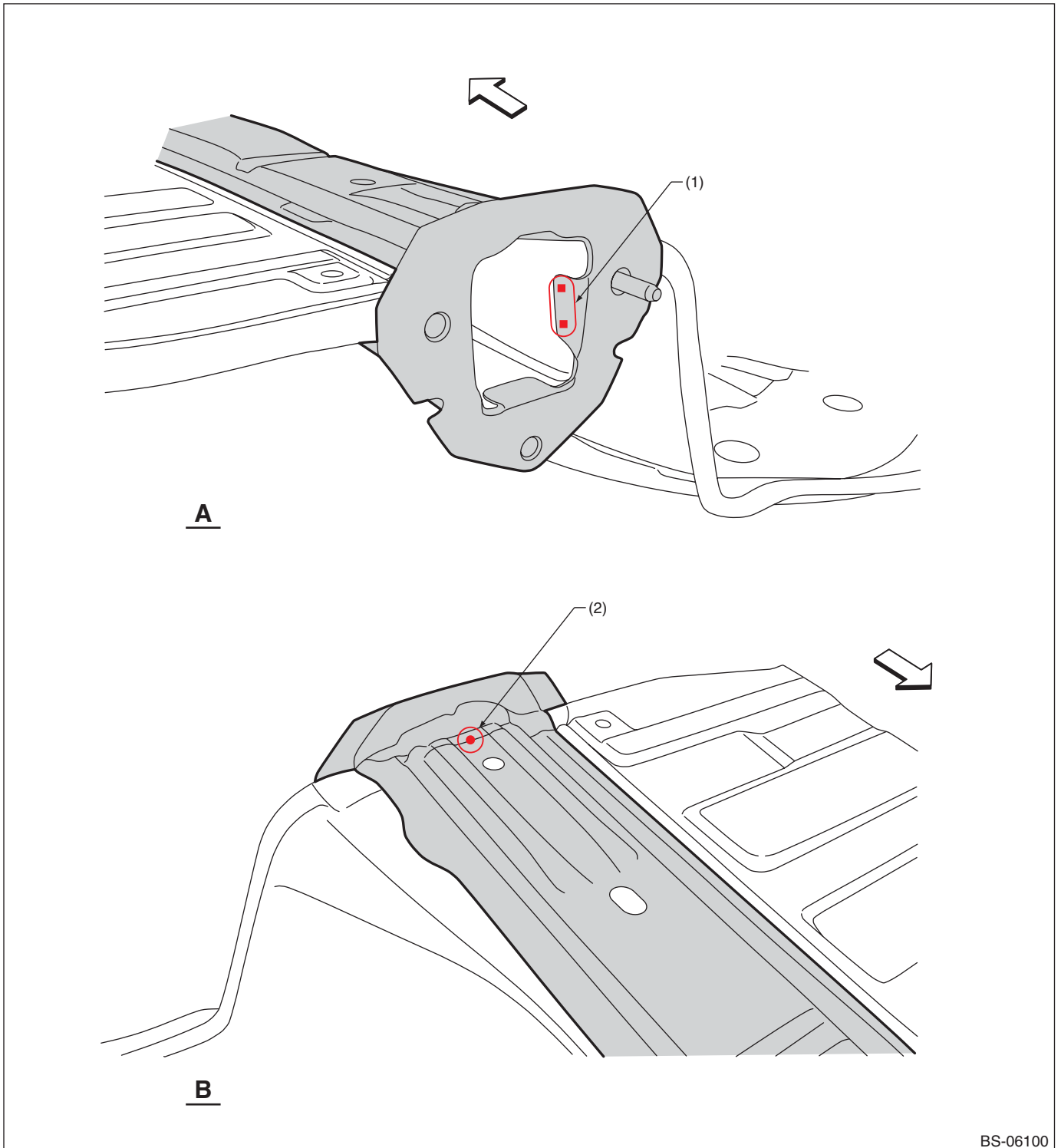
(1) 1 point

(2) 2 points

(3) 1 point (only LH)

Panel Replacement

• Views

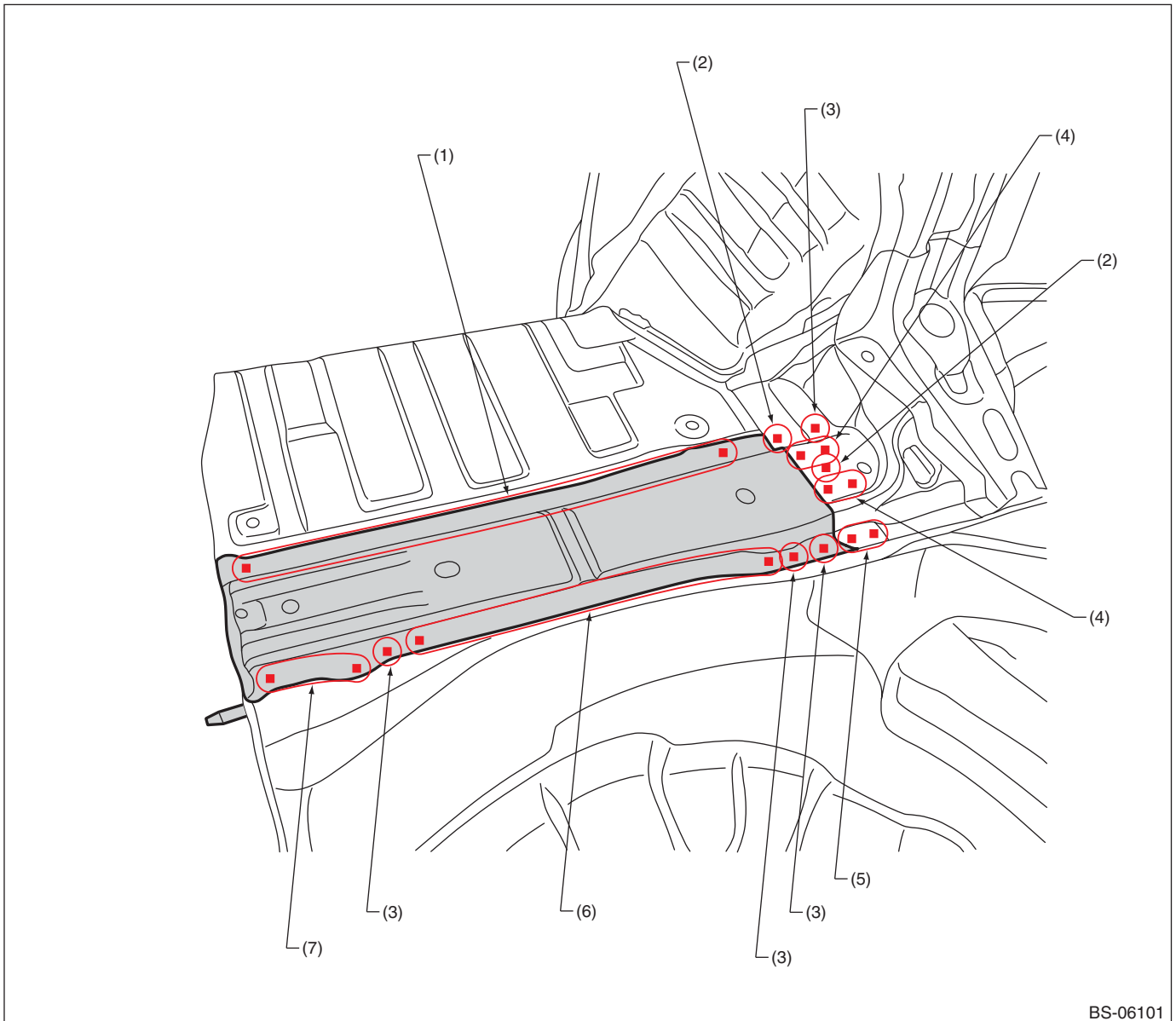


BS-06100

(1) 2 points (service)

(2) 1 point

Panel Replacement



BS-06101

(1) 9 points (service)

(2) 1 point

(3) 1 point (service)

(4) 2 points

(5) 2 points (service · matching)

(6) 7 points (service)

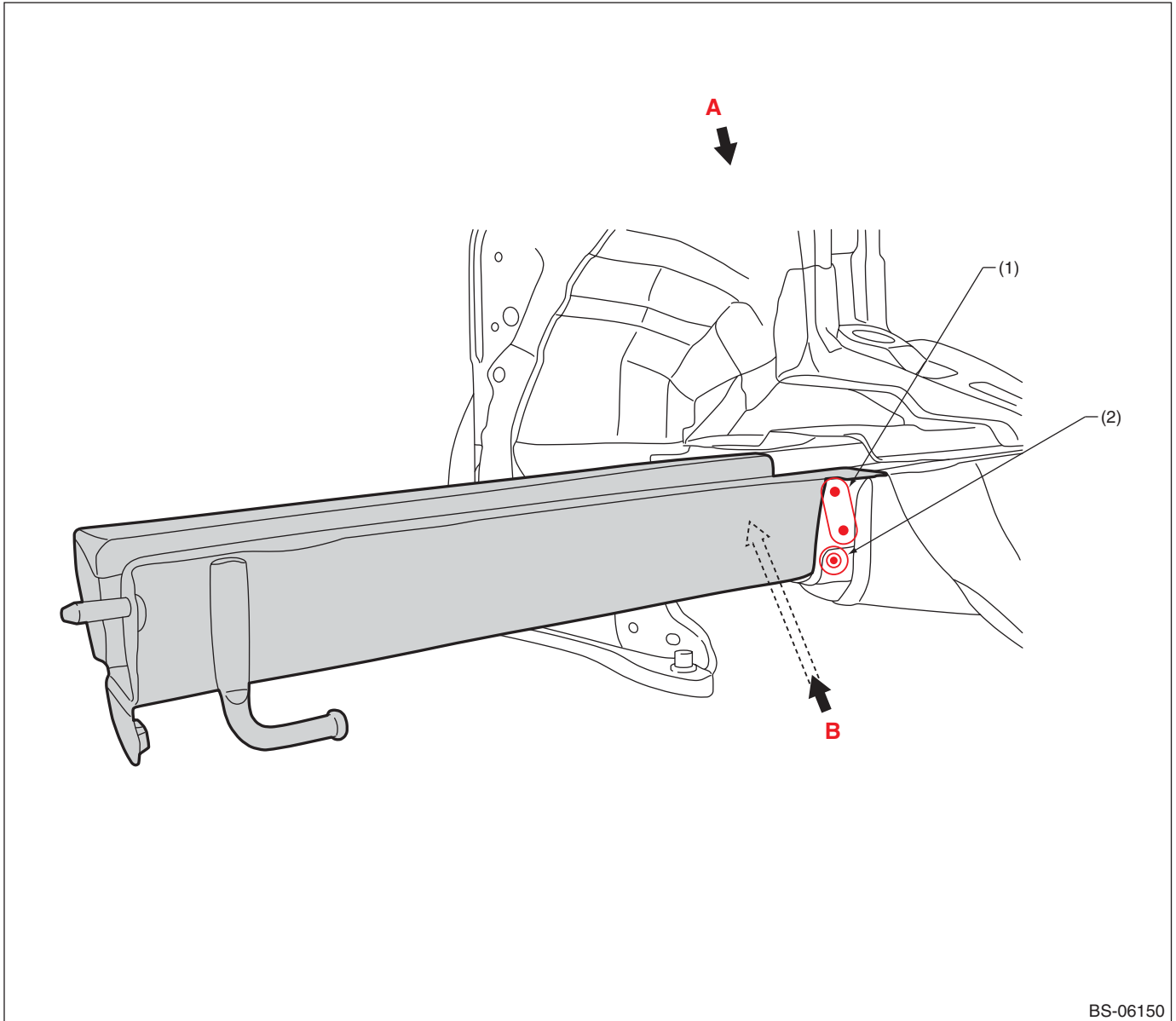
(7) 2 points (service)

Panel Replacement

7-20. Rear Side Frame Lower Rear (total replacement)

A: REMOVAL

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



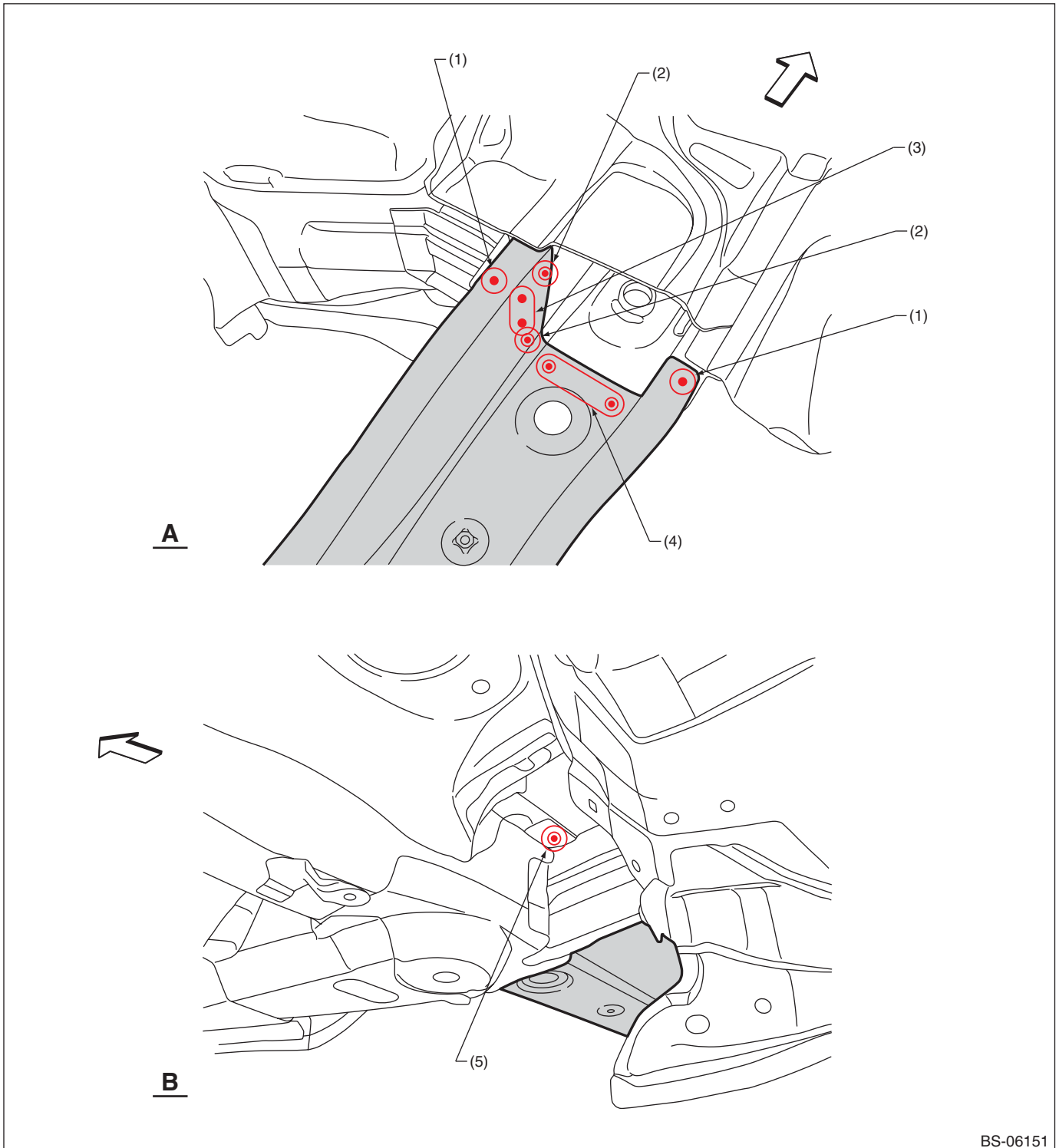
BS-06150

(1) 2 points (inside · 1)

(2) 1 point (inside · 2)

Panel Replacement

• Views



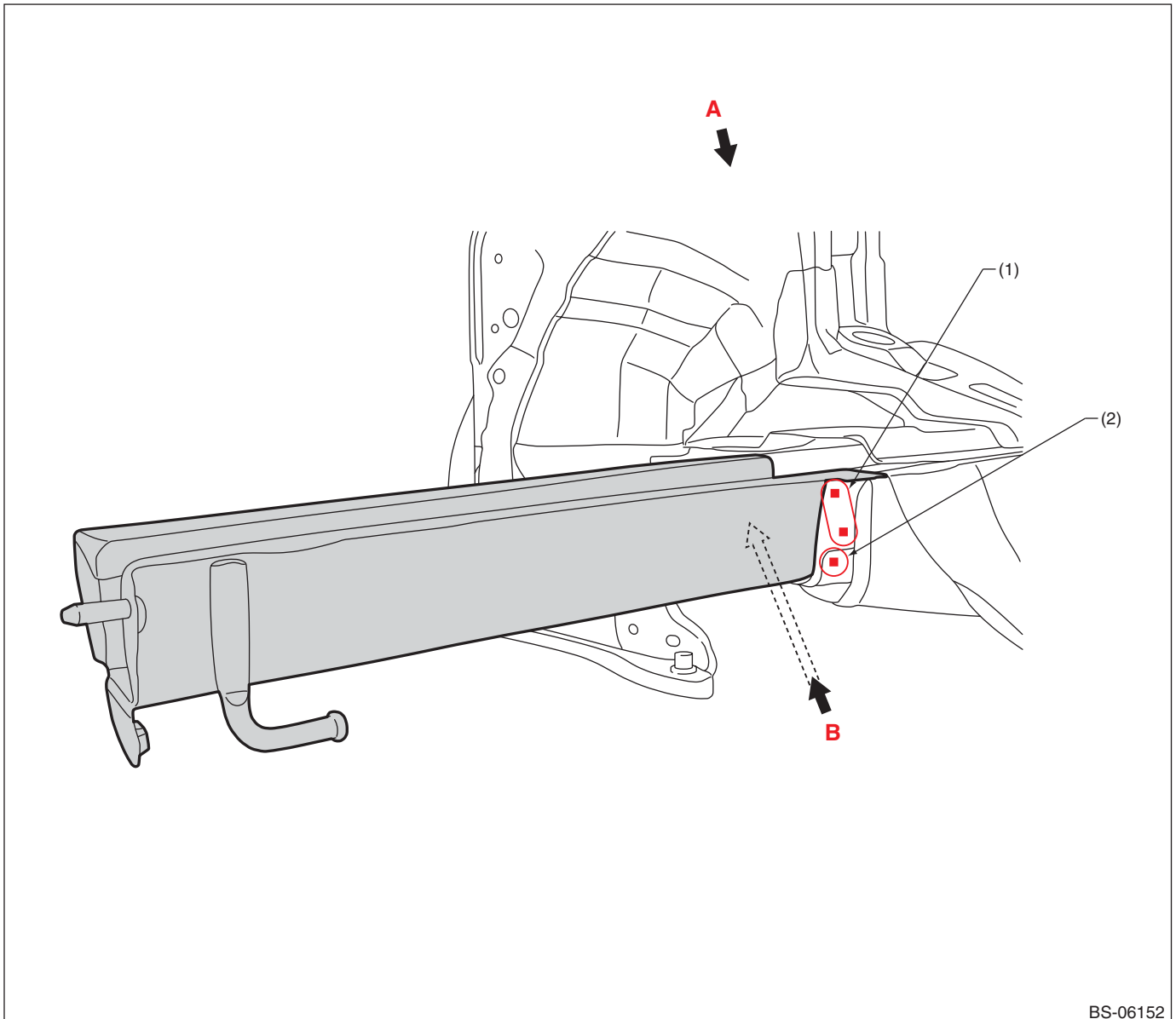
BS-06151

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

Panel Replacement

B: INSTALLATION

• Overall view



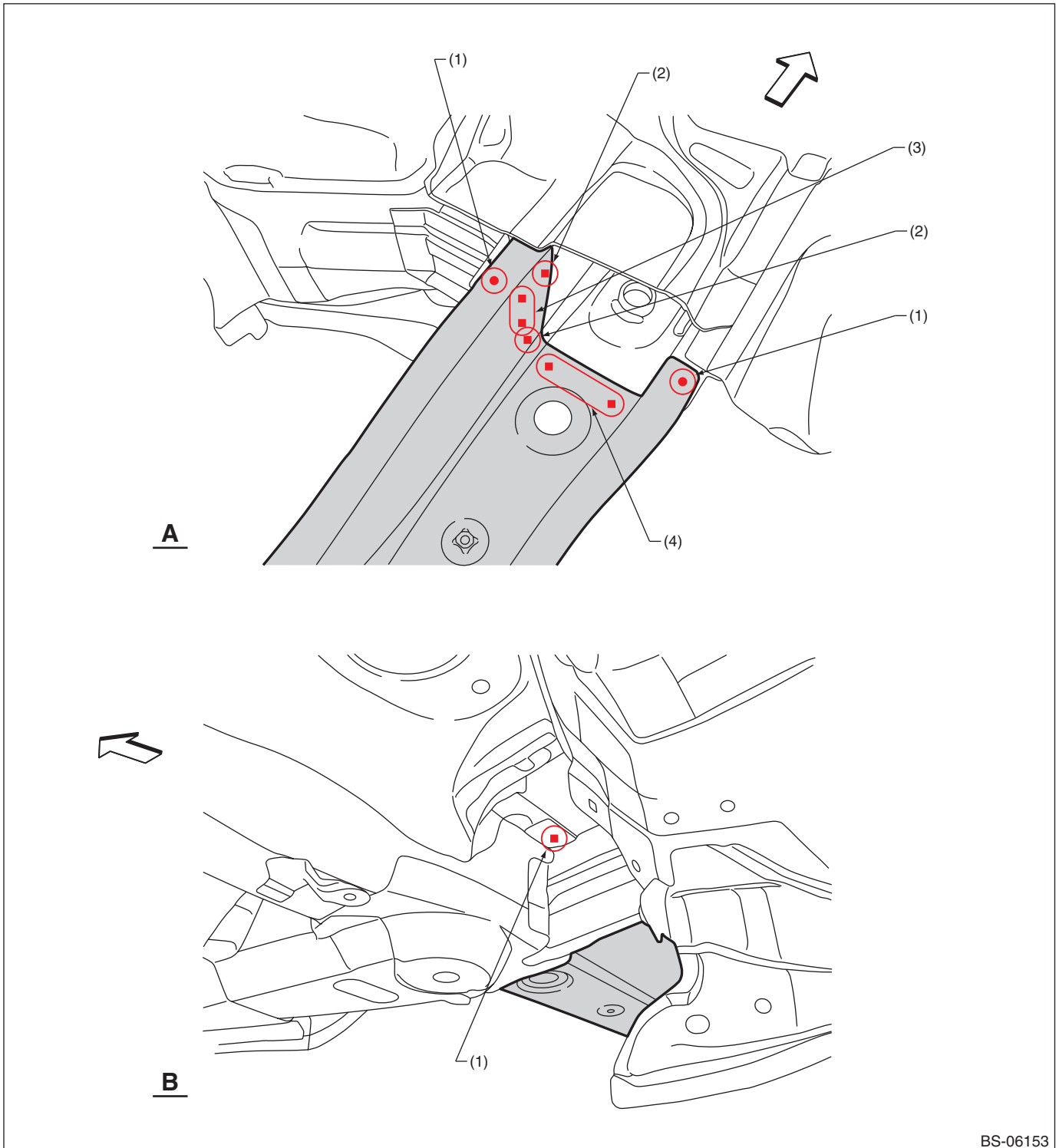
BS-06152

(1) 2 points

(2) 1 point

Panel Replacement

• Views



BS-06153

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

- (3) 2 points (service)

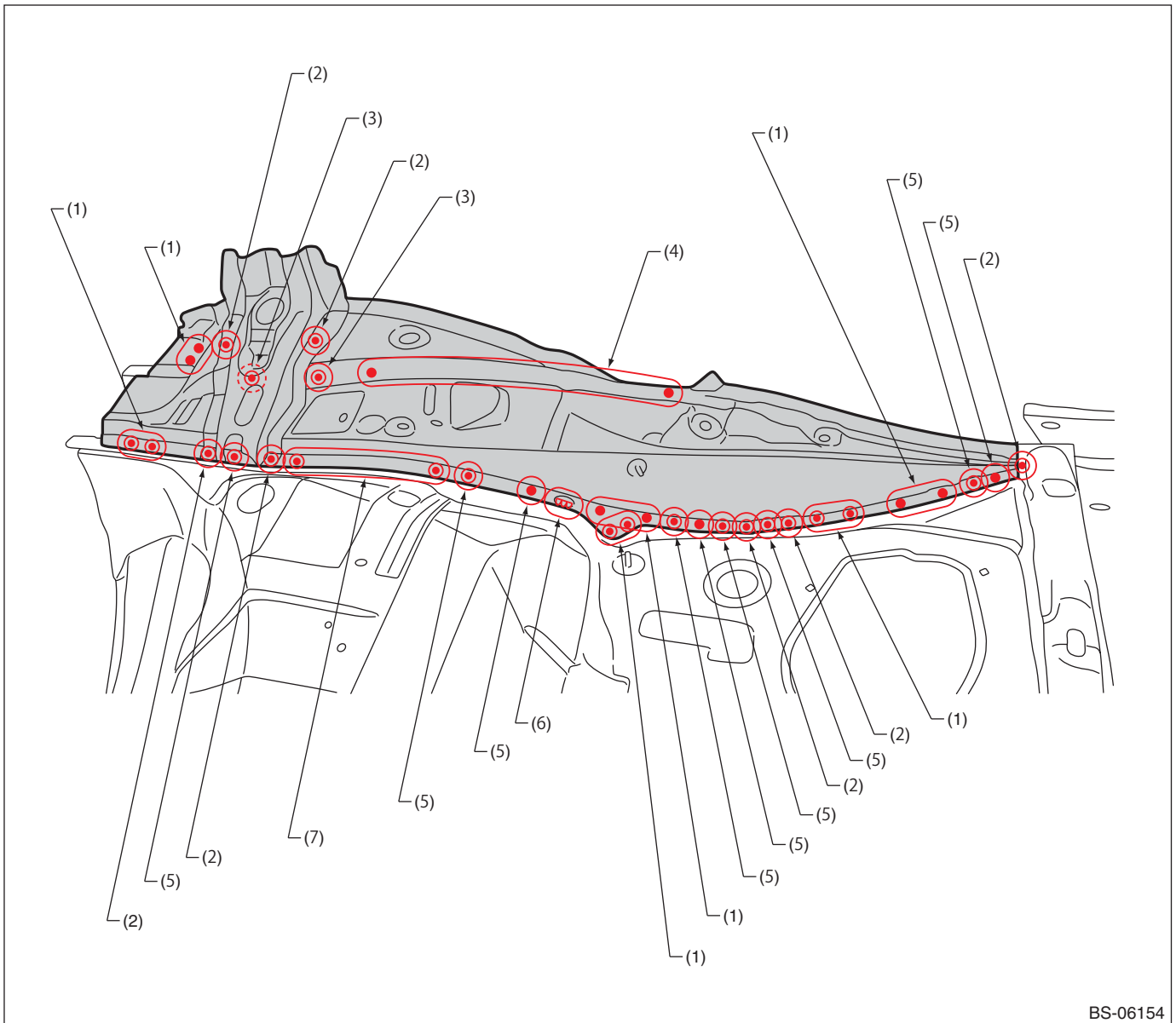
- (4) 3 points (service)

Panel Replacement

7-21. Closing Plate (total replacement)

A: REMOVAL

• Rear skirt, rear floor pan, rear side frame rear, quarter panel outer & inner and side sill inner rear removal condition



BS-06154

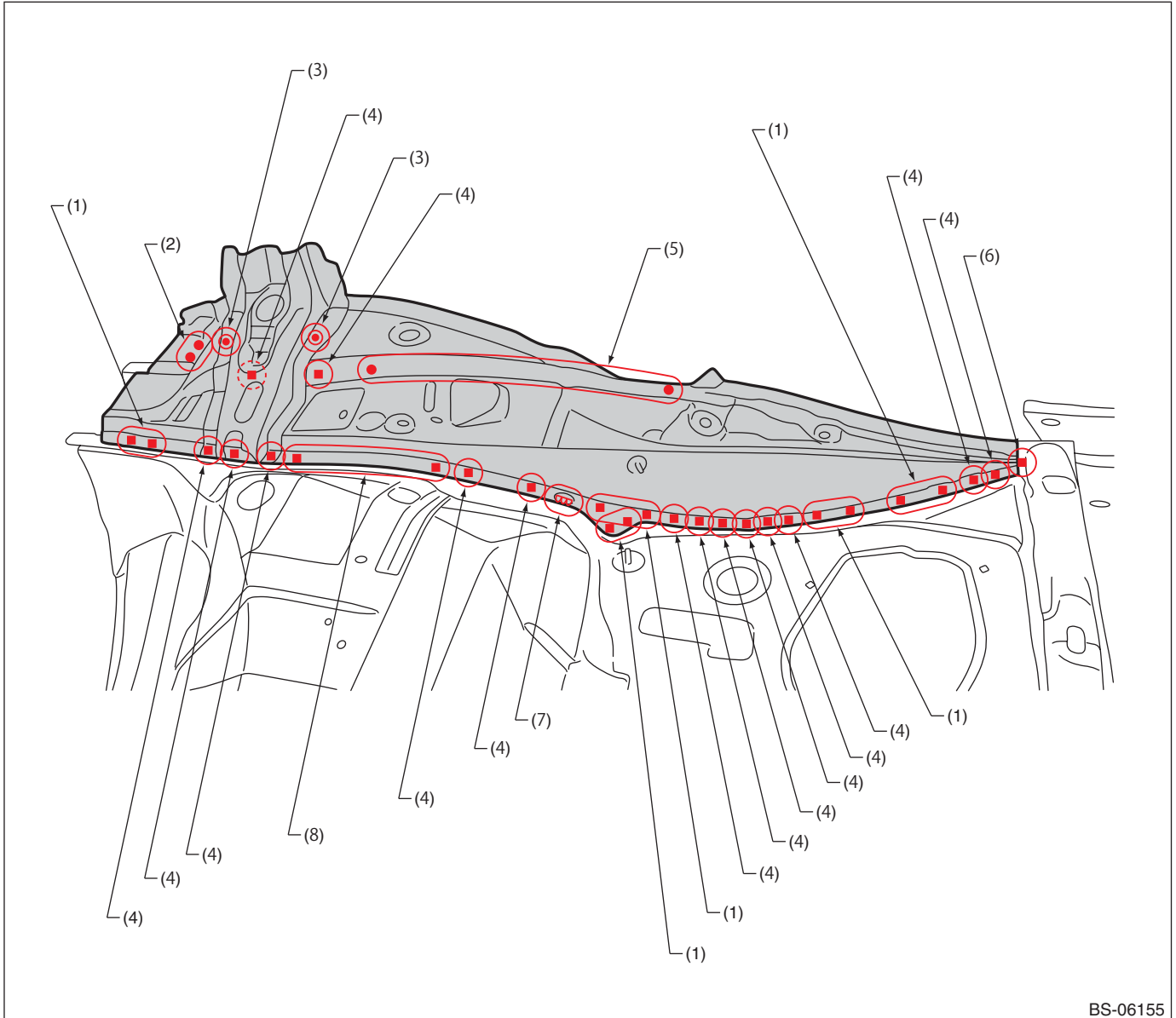
- (1) 2 points (top · 1)
- (2) 1 point (top · 2)
- (3) 1 point (inside · 1)

- (4) 9 points (inside · 1)
- (5) 1 point (top · 1)

- (6) 1 point (top · 1, belt sander)
- (7) 5 points (top · 1)

Panel Replacement

B: INSTALLATION



BS-06155

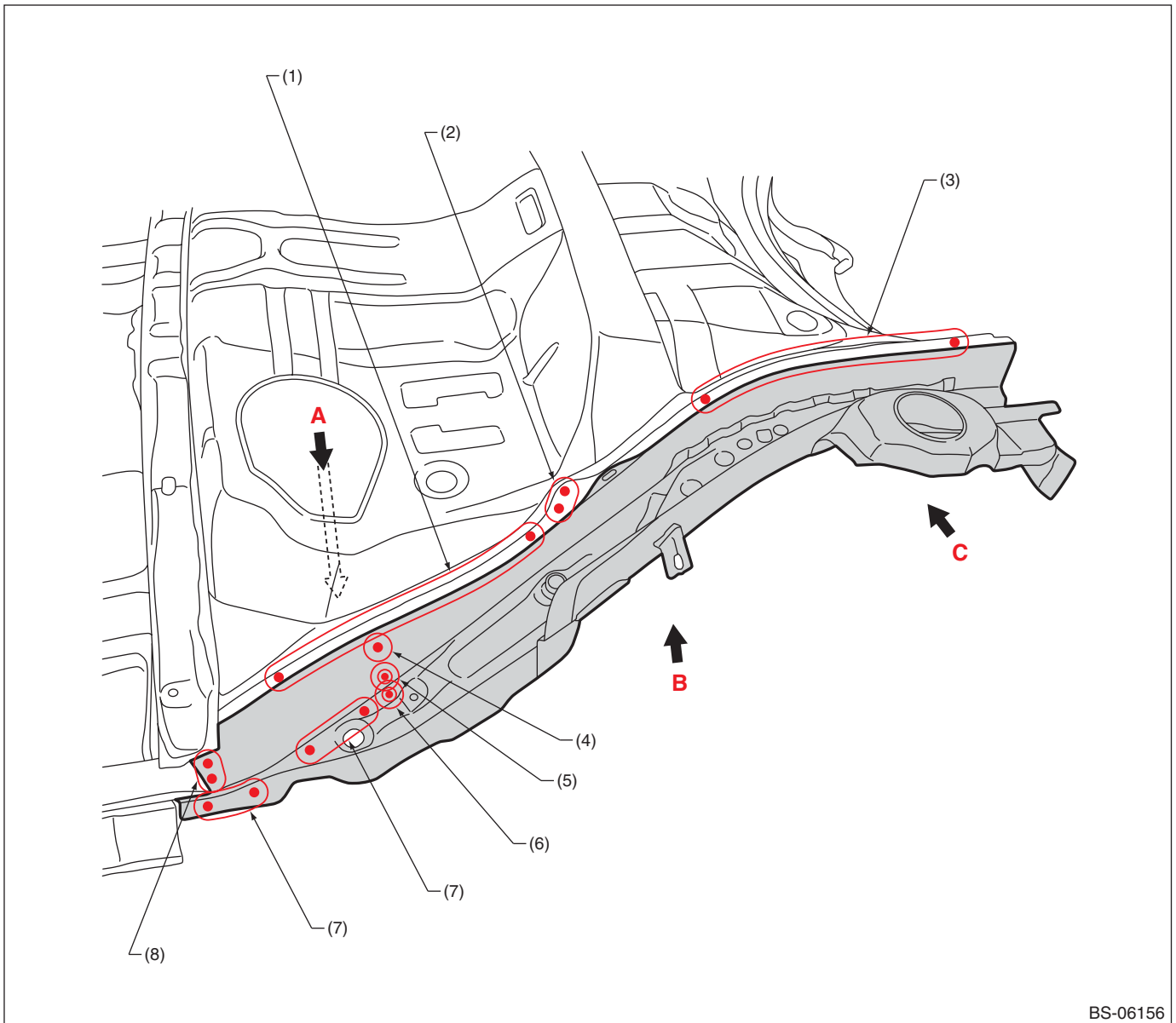
- | | | |
|------------------------|----------------------------------|-------------------------------|
| (1) 2 points (service) | (4) 1 point (service) | (7) 1 point [15 mm (0.59 in)] |
| (2) 2 points | (5) 9 points | (8) 5 points (service) |
| (3) 1 point | (6) 1 point (service · matching) | |

Panel Replacement

7-22. Rear Frame (total replacement)

A: REMOVAL

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



BS-06156

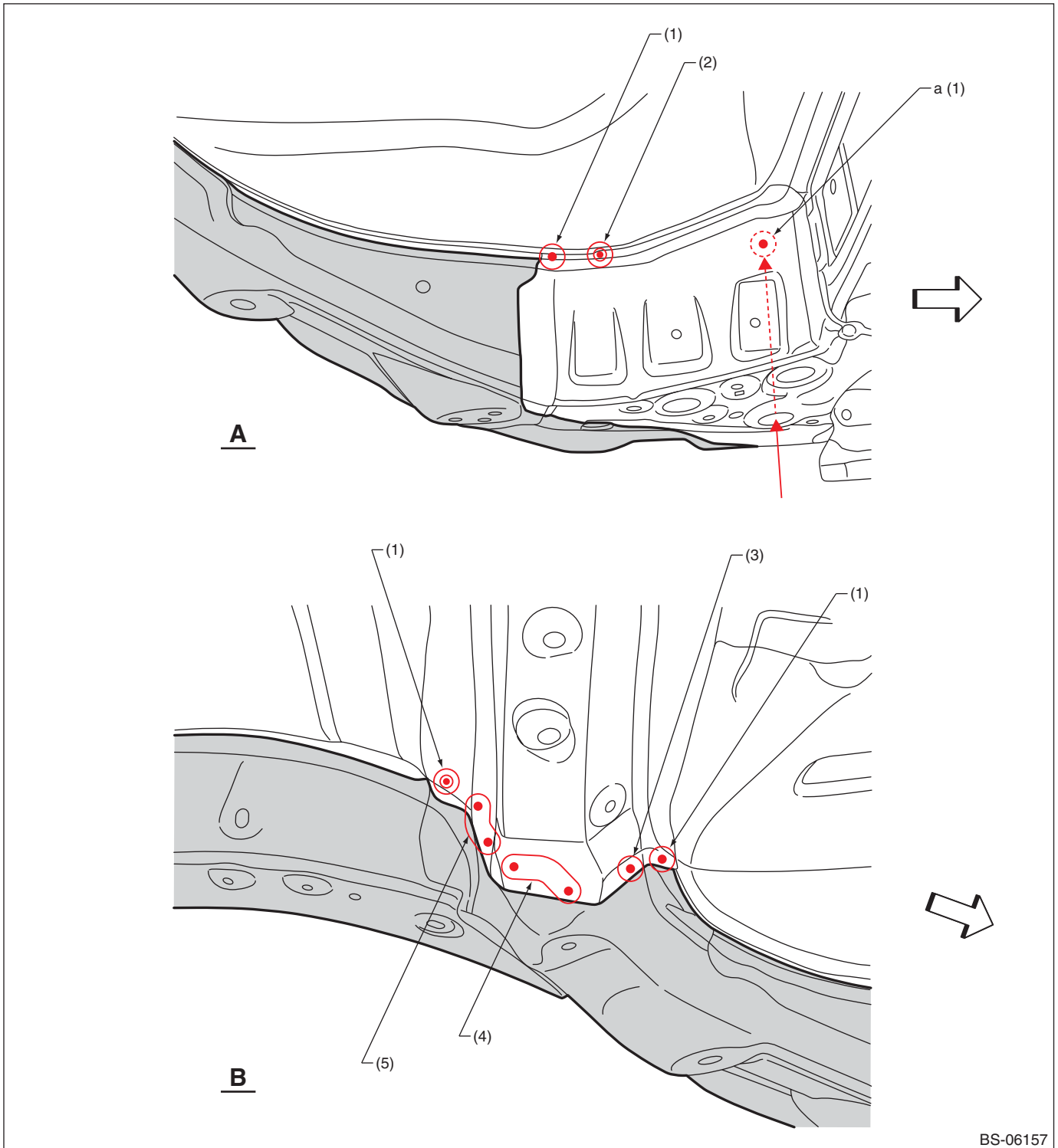
- (1) 6 points (top · 1)
- (2) 2 points (top · 1)
- (3) 8 points (top · 1)

- (4) 1 point (outside · 1)
- (5) 1 point (outside · 2)
- (6) 1 point (top · 2)

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

Panel Replacement

• Views 1



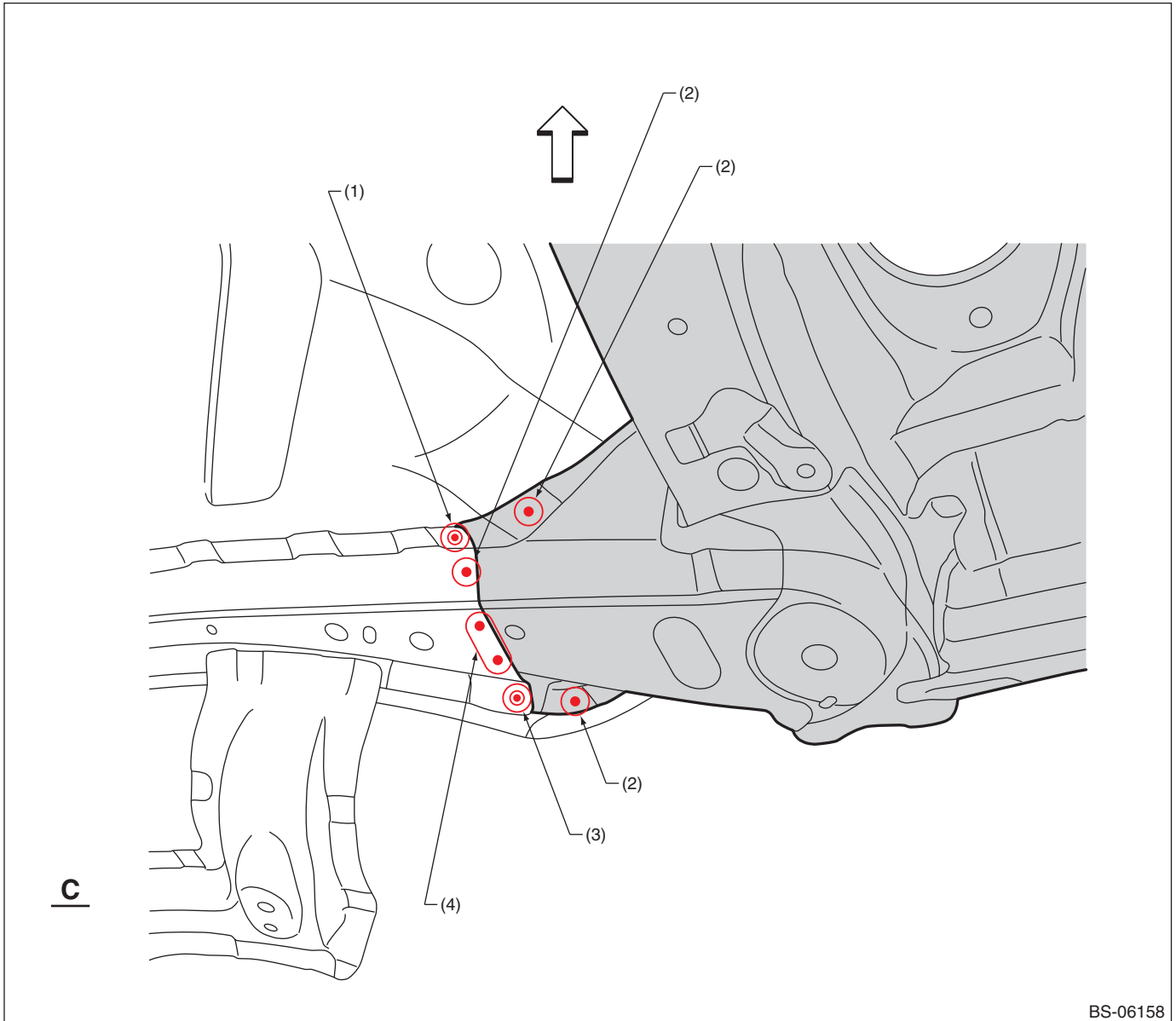
BS-06157

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

Note: Remove part “a” with a long spot cutter inserted through the hole indicated by the red arrow.

Panel Replacement

• Views 2



(1) 1 point (top · 1, bottom · 1)

(2) 1 point (inside · 1)

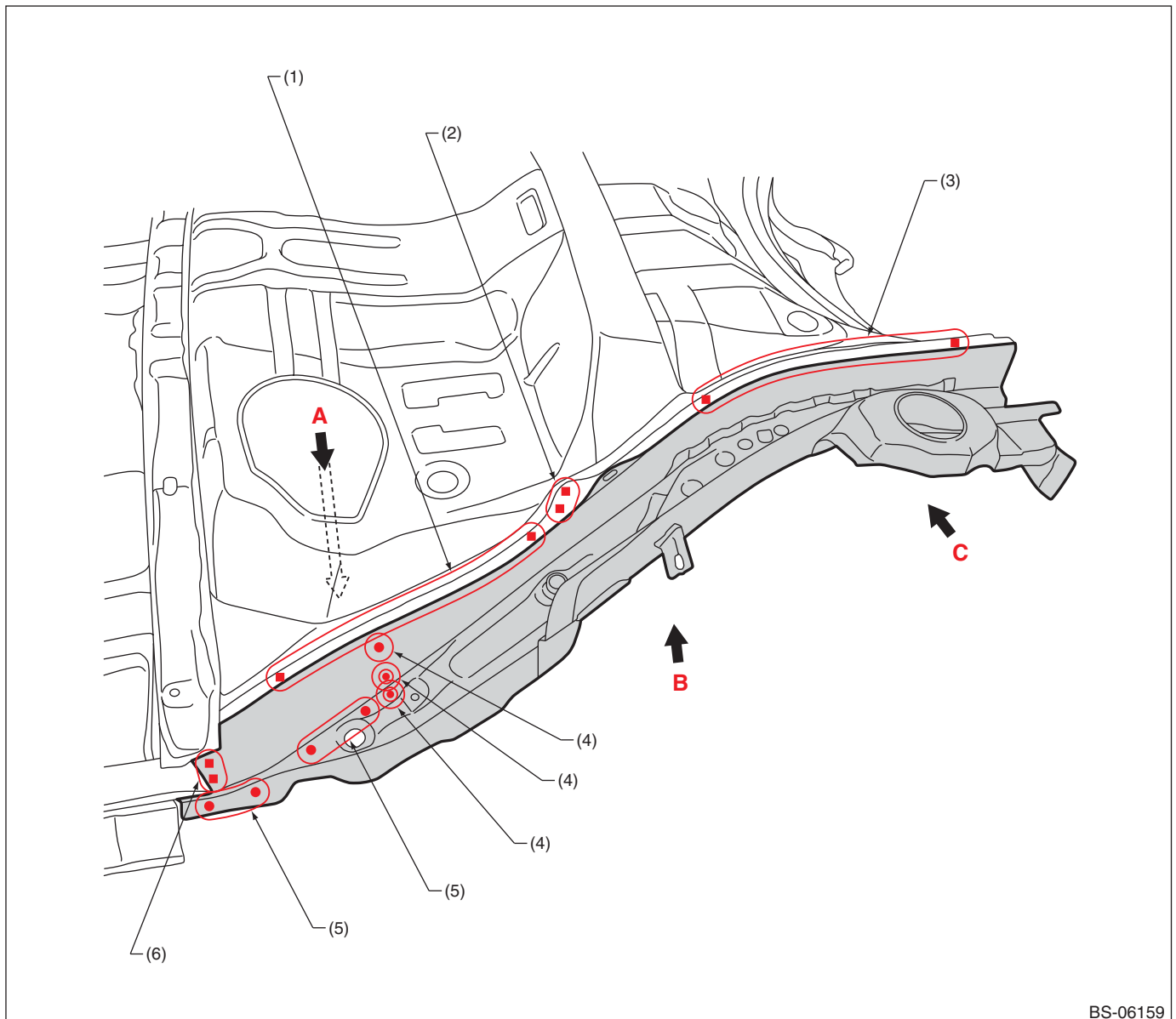
(3) 1 point (outside · 1, inside · 1)

(4) 2 points (bottom · 1)

Panel Replacement

B: INSTALLATION

• Overall view



(1) 6 points

(2) 2 points

(3) 8 points

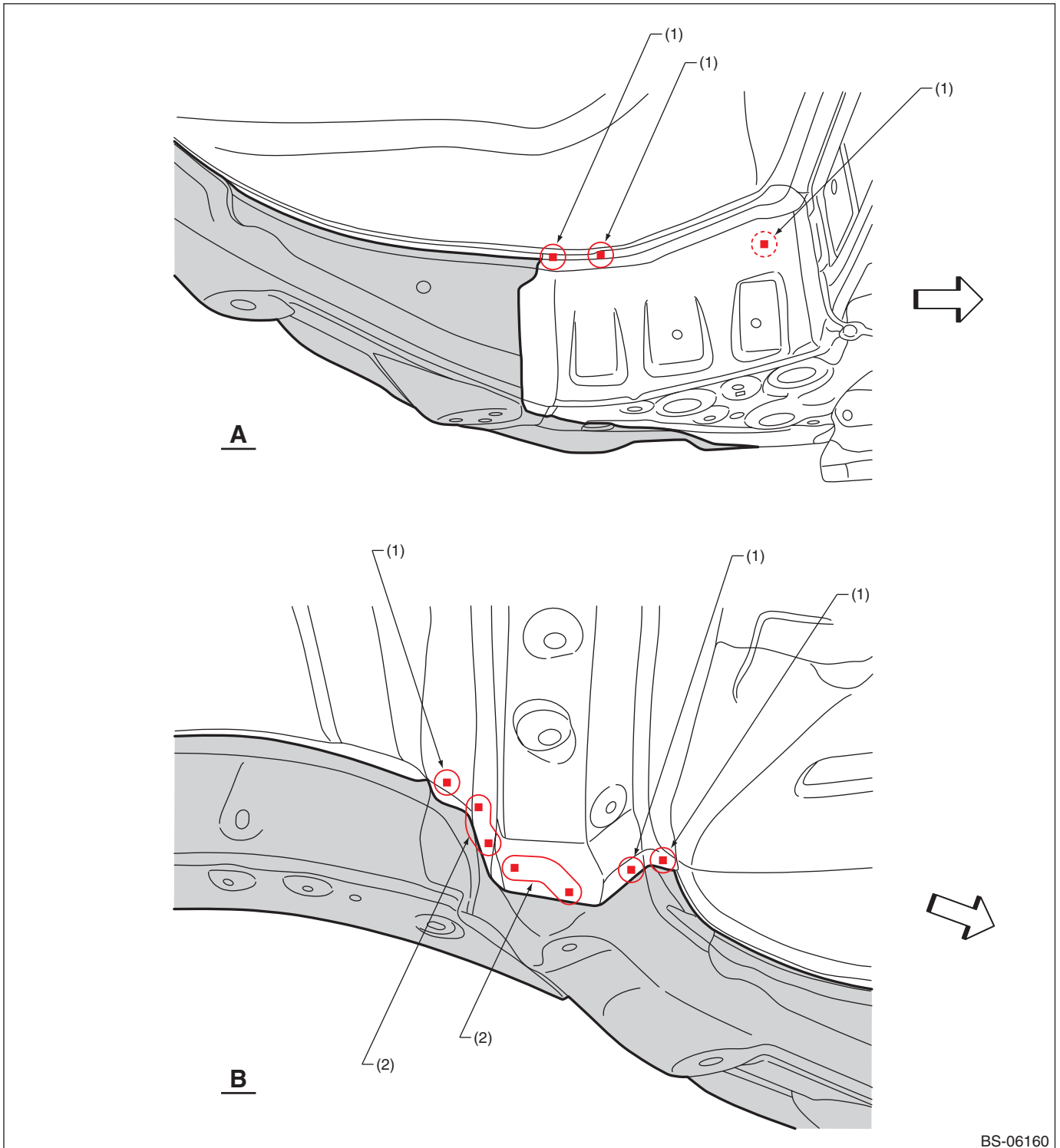
(4) 1 point

(5) 3 points

(6) 2 points (service)

Panel Replacement

• Views 1



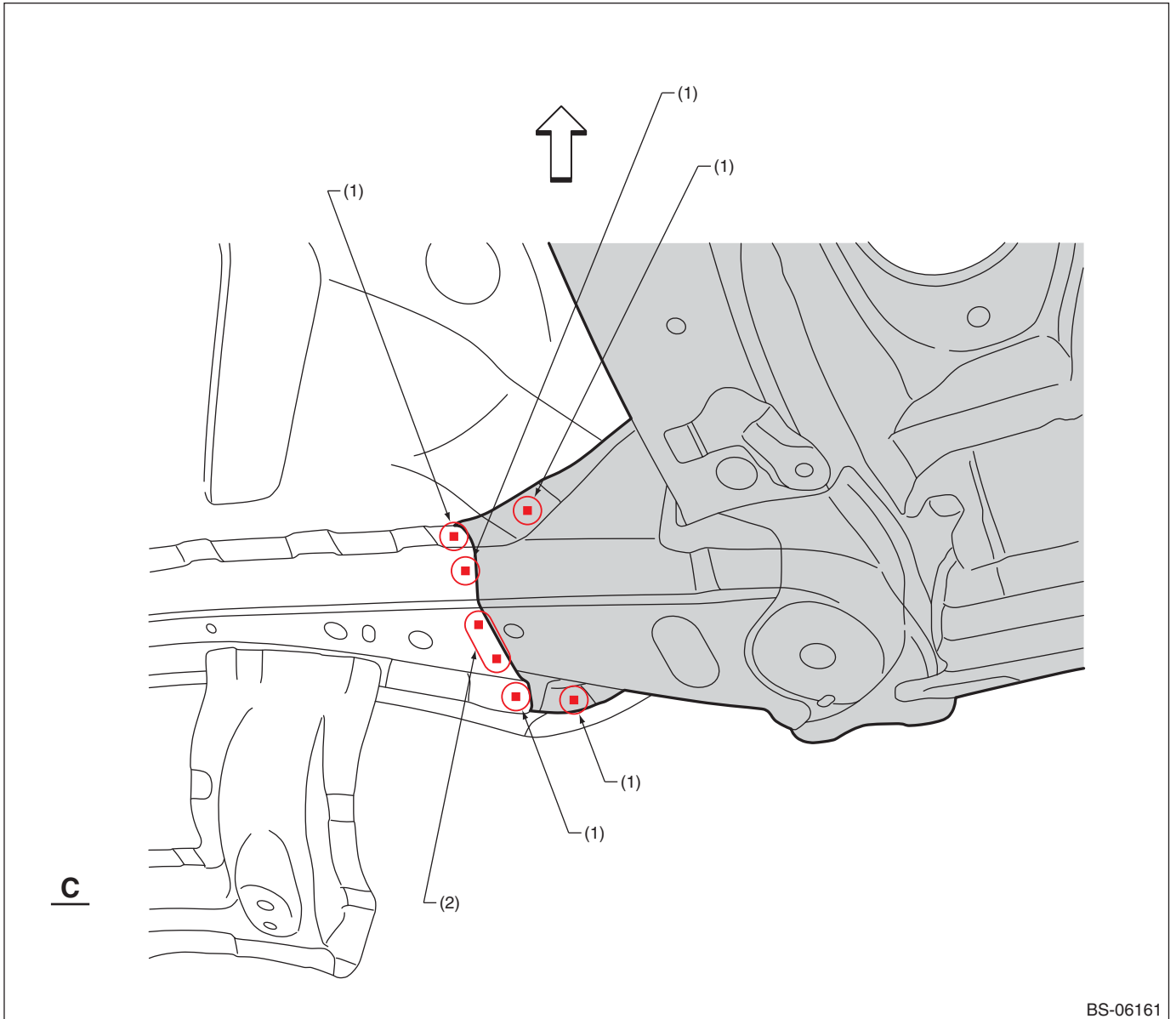
BS-06160

(1) 1 point

(2) 3 points

Panel Replacement

• Views 2



(1) 1 point

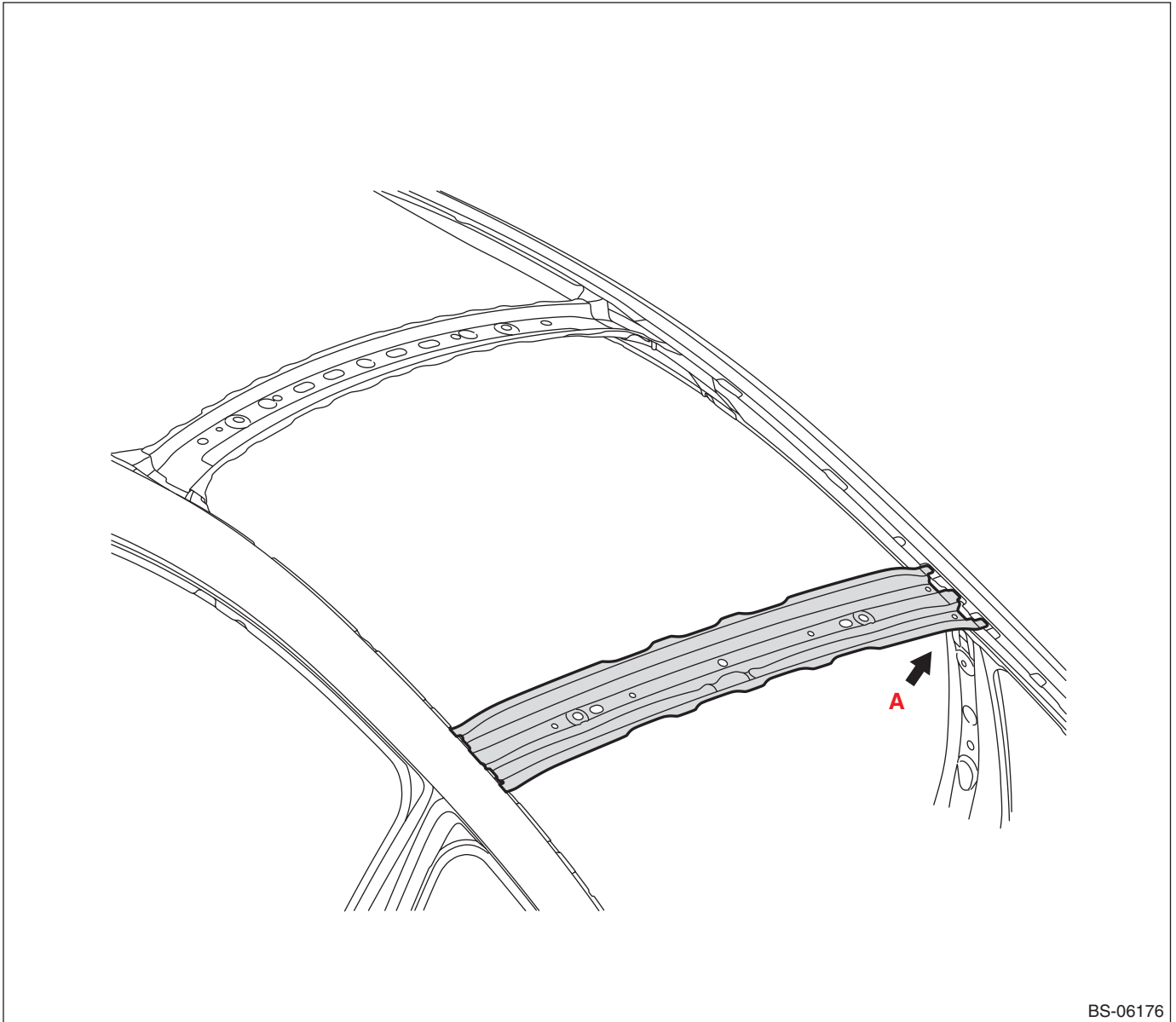
(2) 2 points

Panel Replacement

7-23. Roof Center Brace (total replacement)

A: REMOVAL

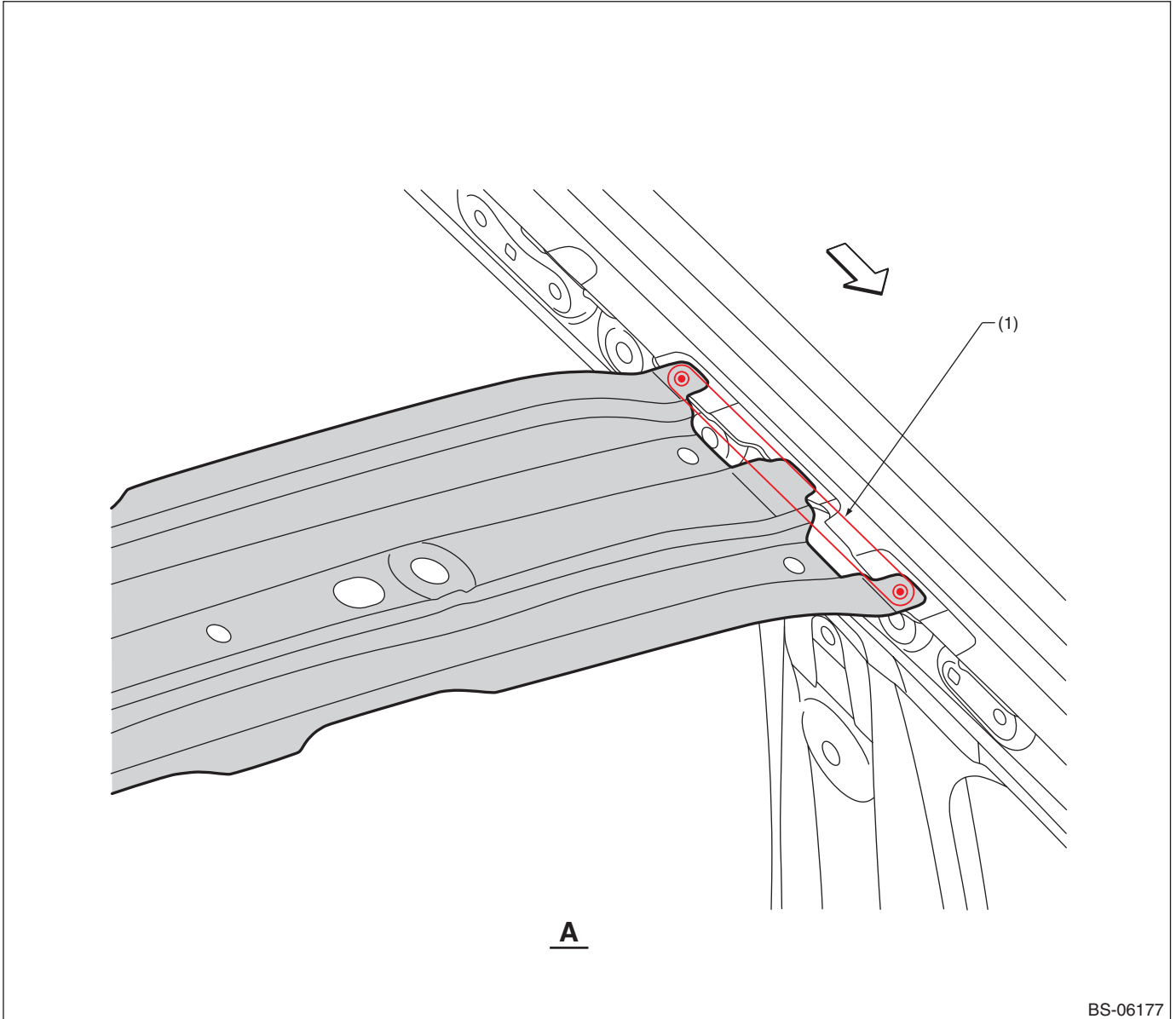
- Overall view (Roof panel removal condition)



BS-06176

Panel Replacement

- Views



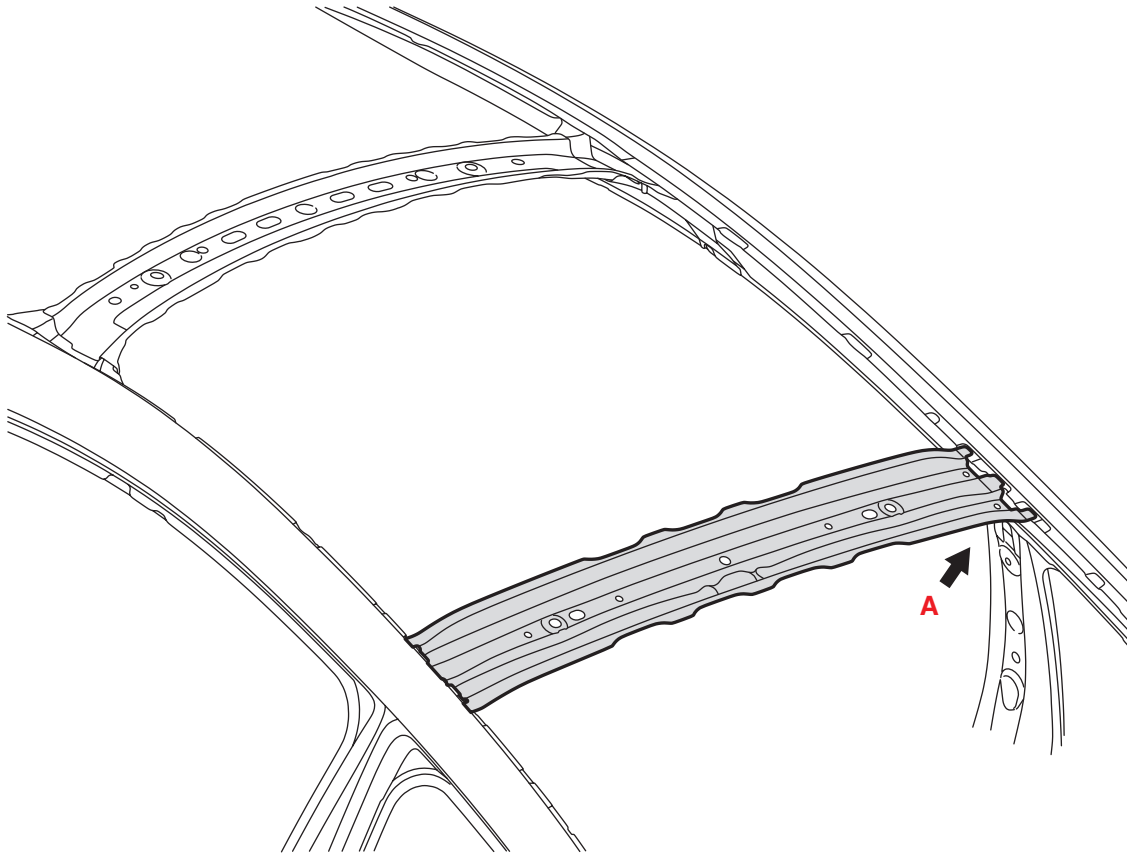
BS-06177

(1) 3 points (top · 1)

Panel Replacement

B: INSTALLATION

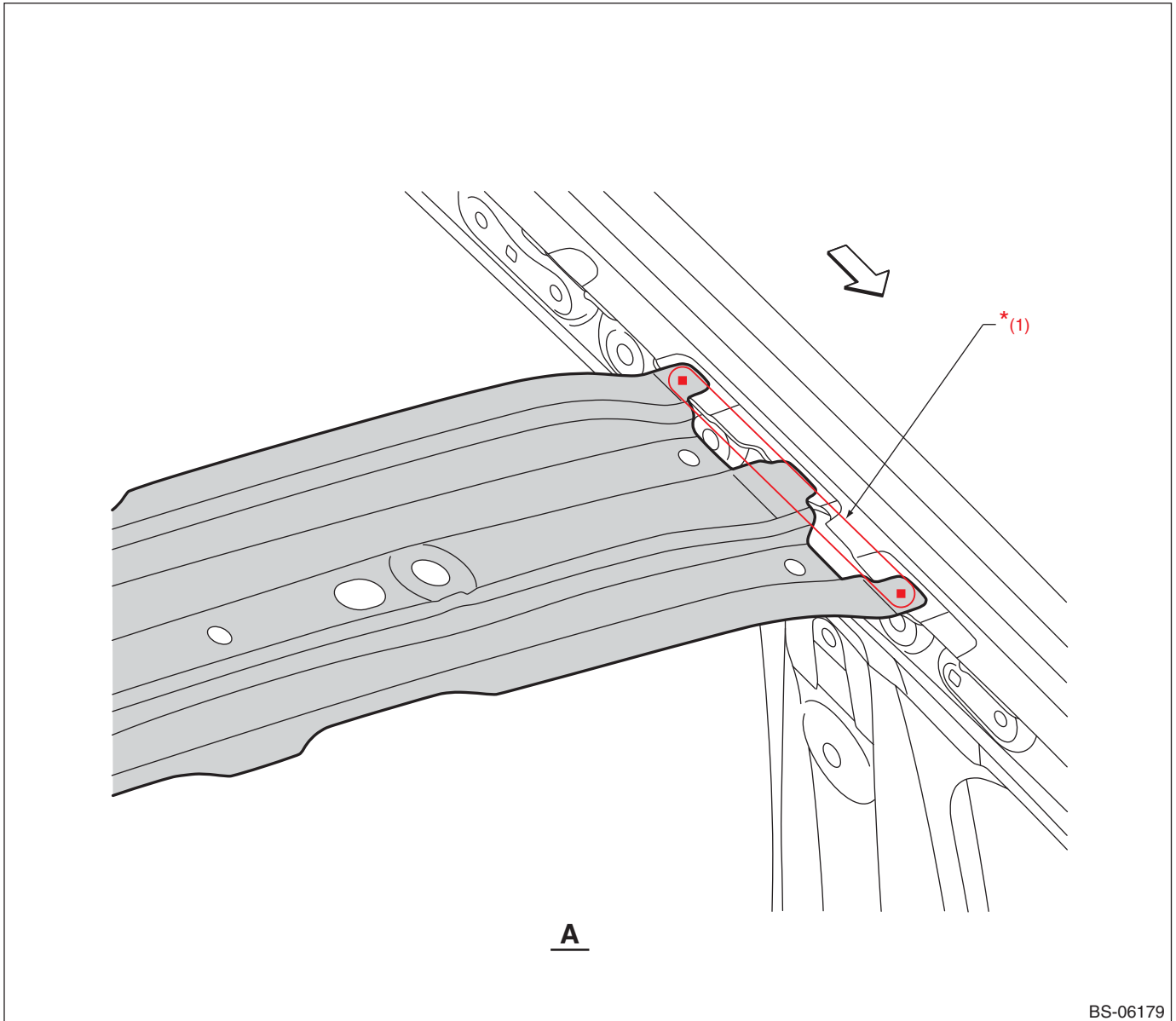
• Overall view



BS-06178

Panel Replacement

• Views



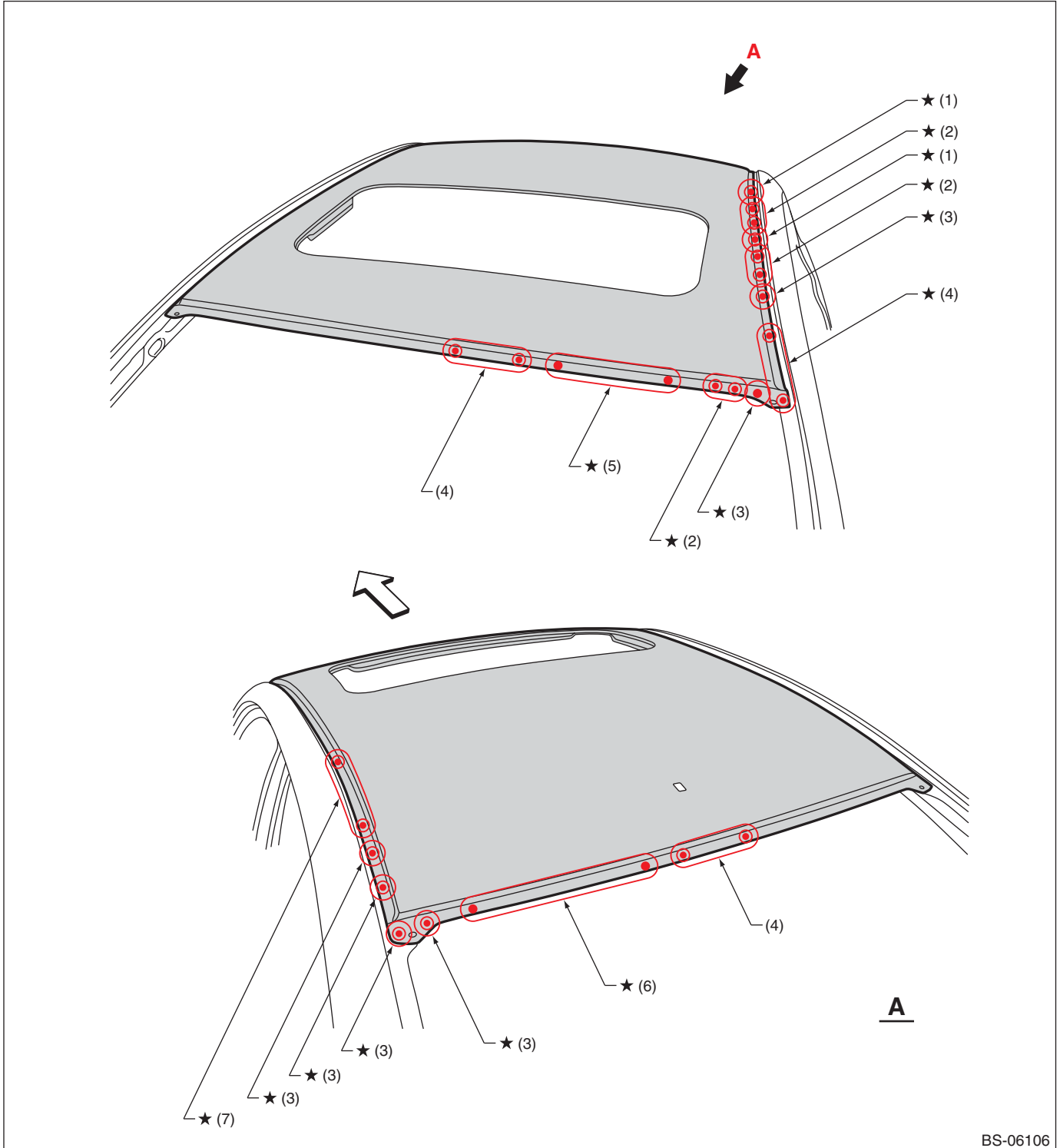
(1) 3 points

*: When plug welding a high-tensile steel sheet of 980 MPa Class or more, refer to "NOTE, Foreword" on page 7.

Panel Replacement

7-24. Roof Panel (total replacement)

A: REMOVAL



BS-06106

(1) 1 point (top · 2)
(only sunroof models)

(2) 2 points (top · 1)

(3) 1 point (top · 1)

(4) 3 points (top · 1)

(5) 4 points (top · 1)

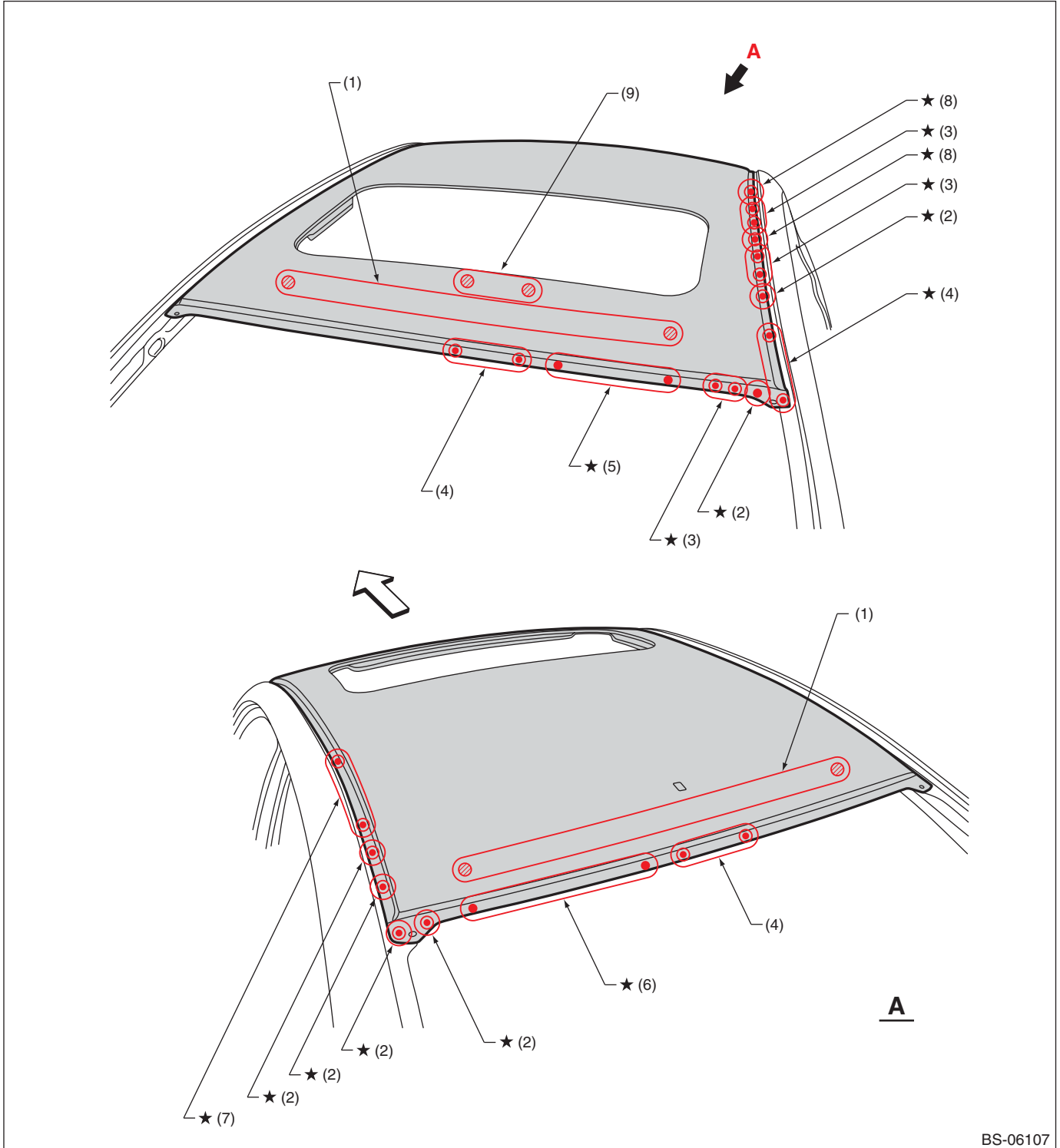
(6) 5 points (top · 1)

(7) 7 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-06107

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

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

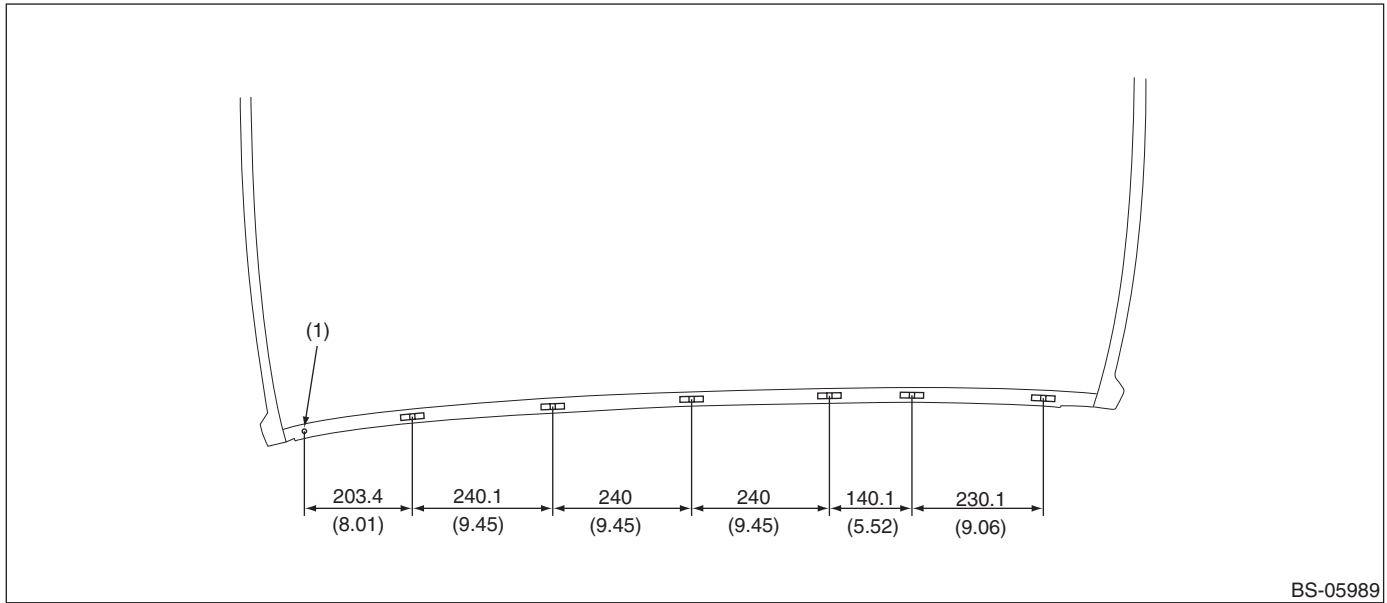
- (7) 7 points
- (8) 1 point (only sunroof models)
- (9) 2 points (only normal roof models)

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

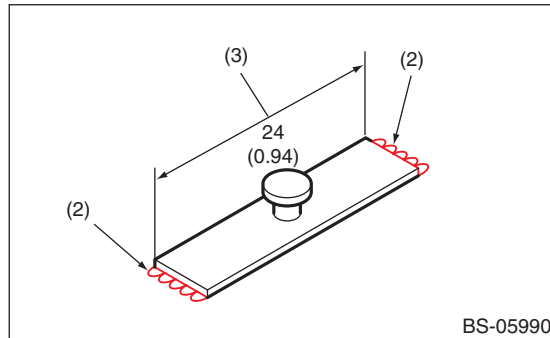
⊗ : Application of adhesive.

Panel Replacement

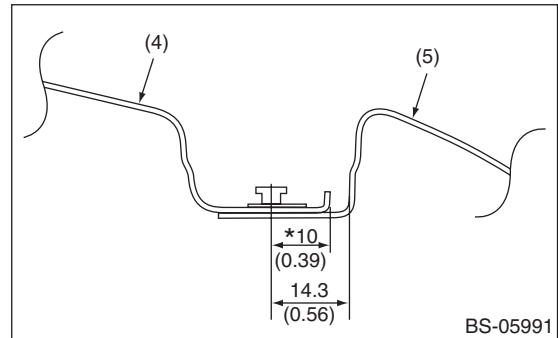
7-25. T Stud Installation



• T stud welding



• T stud basic cross section



(1) $\phi 5.2$ mm (0.20 in) hole (for roof mole, standard pop rivet hole)

(2) Arc welding for both plate ends

(3) This surface shall be kept flat as it becomes the mating face with the clip.

(4) Roof panel

(5) Side panel outer

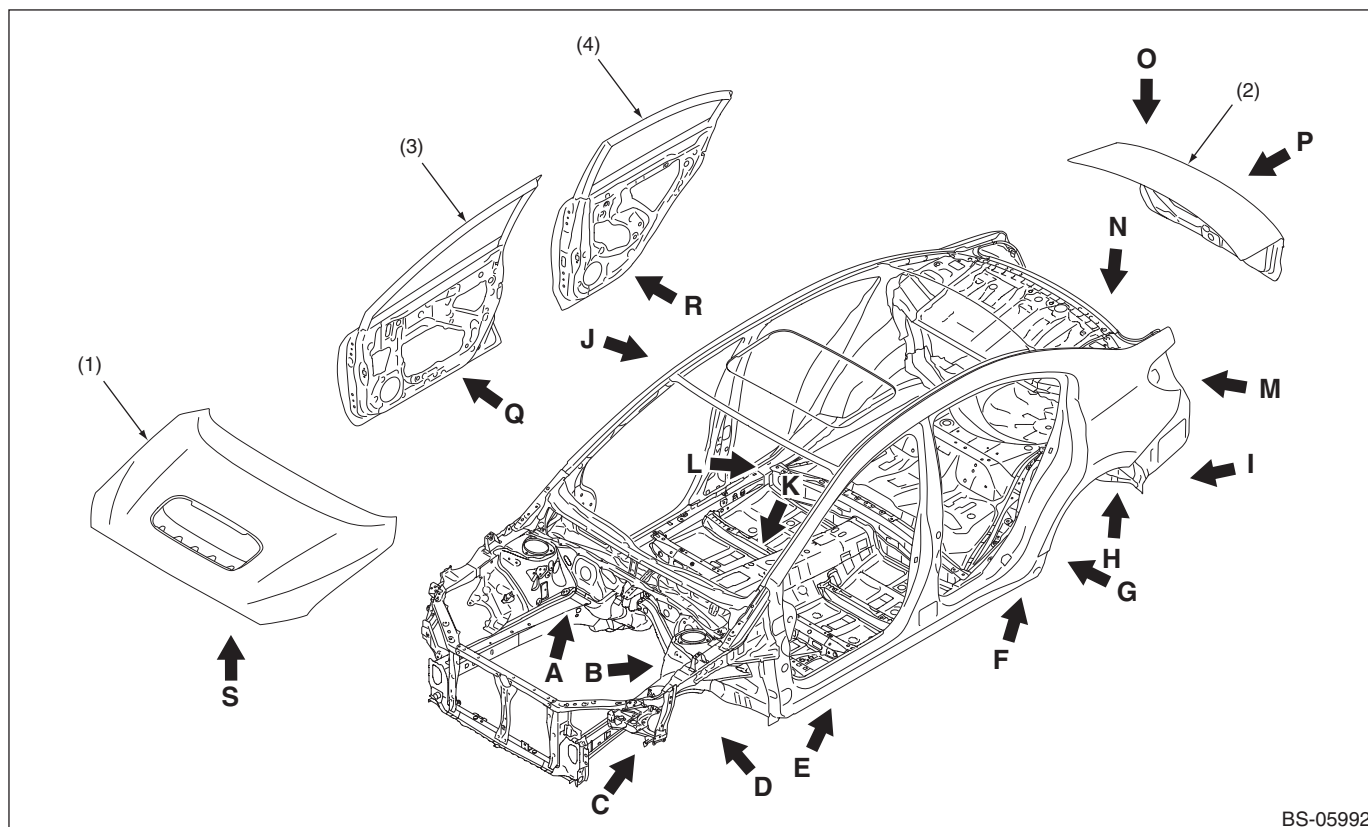
* Indicates dimensions for reference.

8. Body Sealing

A: SPECIFICATION

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

— : Sealer application location



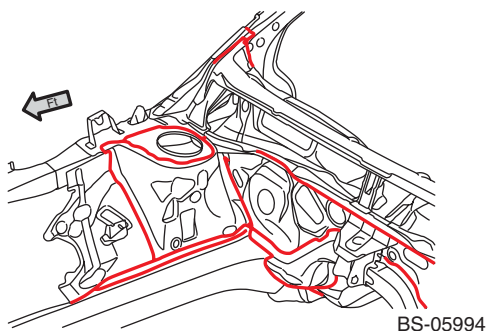
BS-05992

- (1) Front hood
- (2) Trunk

- (3) Front door

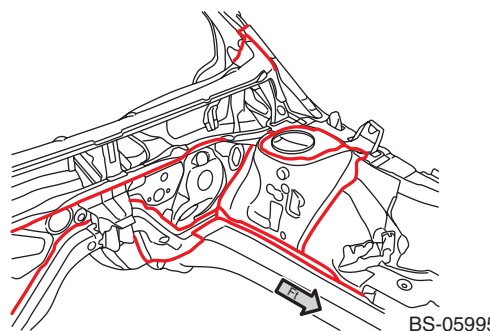
- (4) Rear door

ViewA



BS-05994

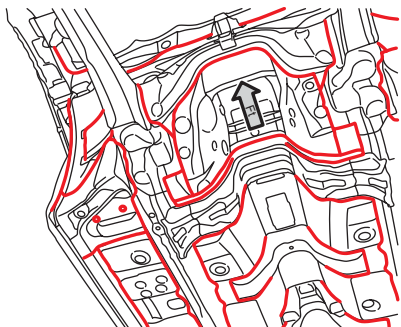
ViewB



BS-05995

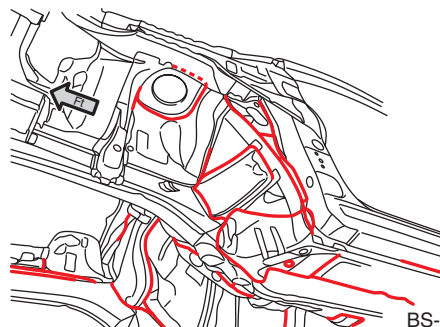
Body Sealing

ViewC



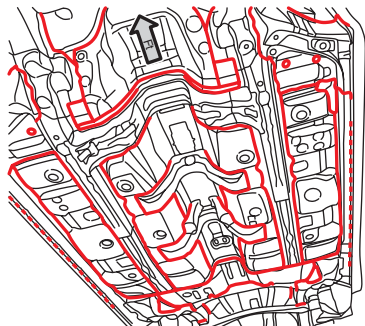
BS-06195

ViewD



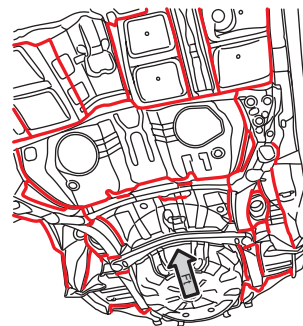
BS-05997

ViewE



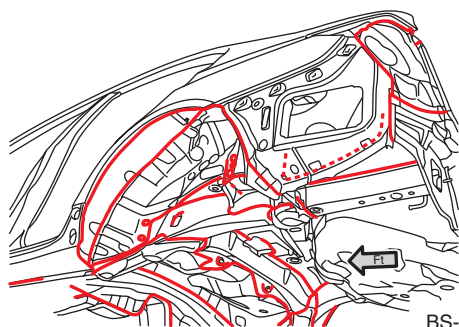
BS-05998

ViewF



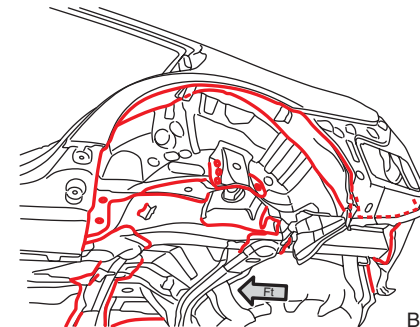
BS-06000

ViewG



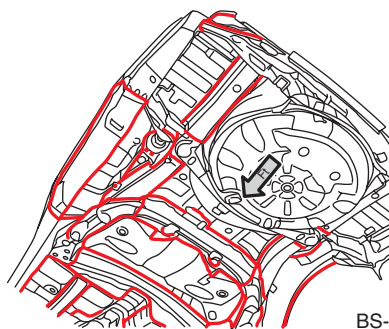
BS-06001

ViewH



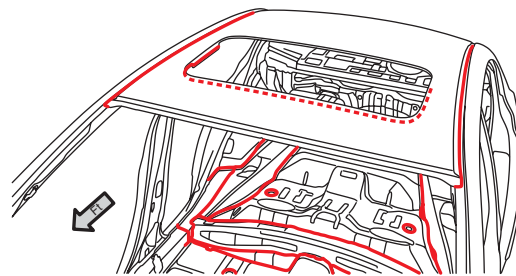
BS-06002

ViewI



BS-06003

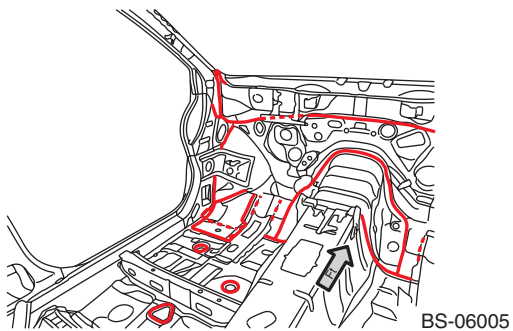
ViewJ



BS-06004

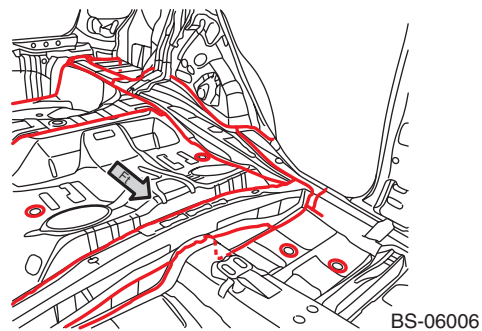
Body Sealing

ViewK



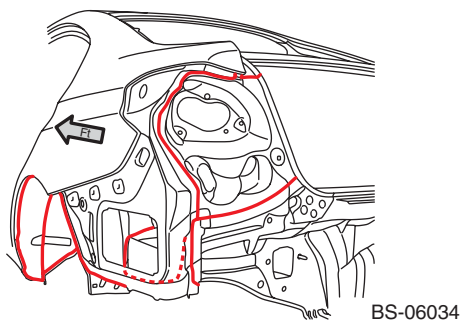
BS-06005

ViewL



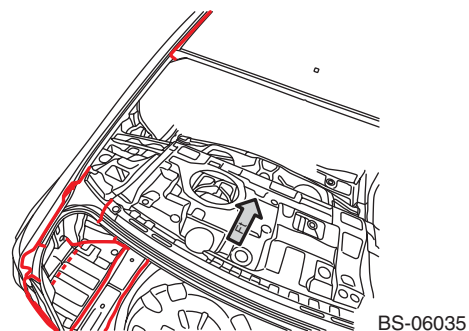
BS-06006

ViewM



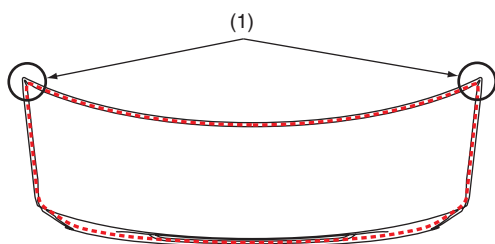
BS-06034

ViewN



BS-06035

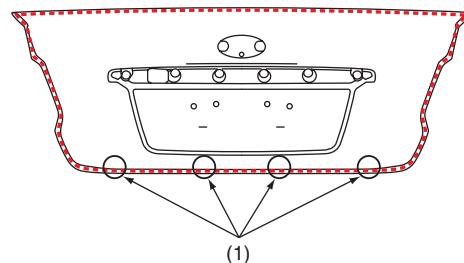
ViewO



BS-06036

(1) Plug the ED drain hole with PS and then make it smooth and even.

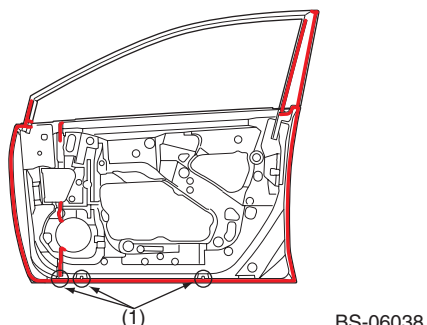
ViewP



BS-06037

(1) Do not block the water drain holes.

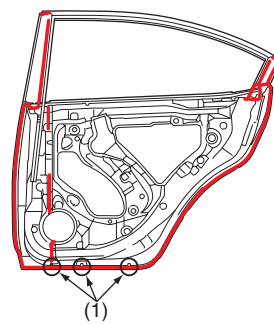
ViewQ



BS-06038

(1) Do not block the water drain holes.

ViewR

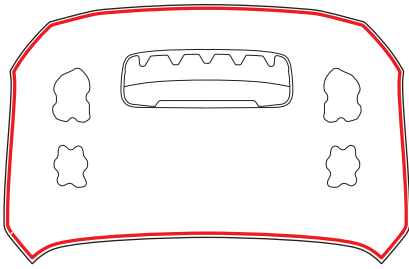


BS-06039

(1) Do not block the water drain holes.

Body Sealing

ViewS



BS-06040

SUBARU.

CAUTION:

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

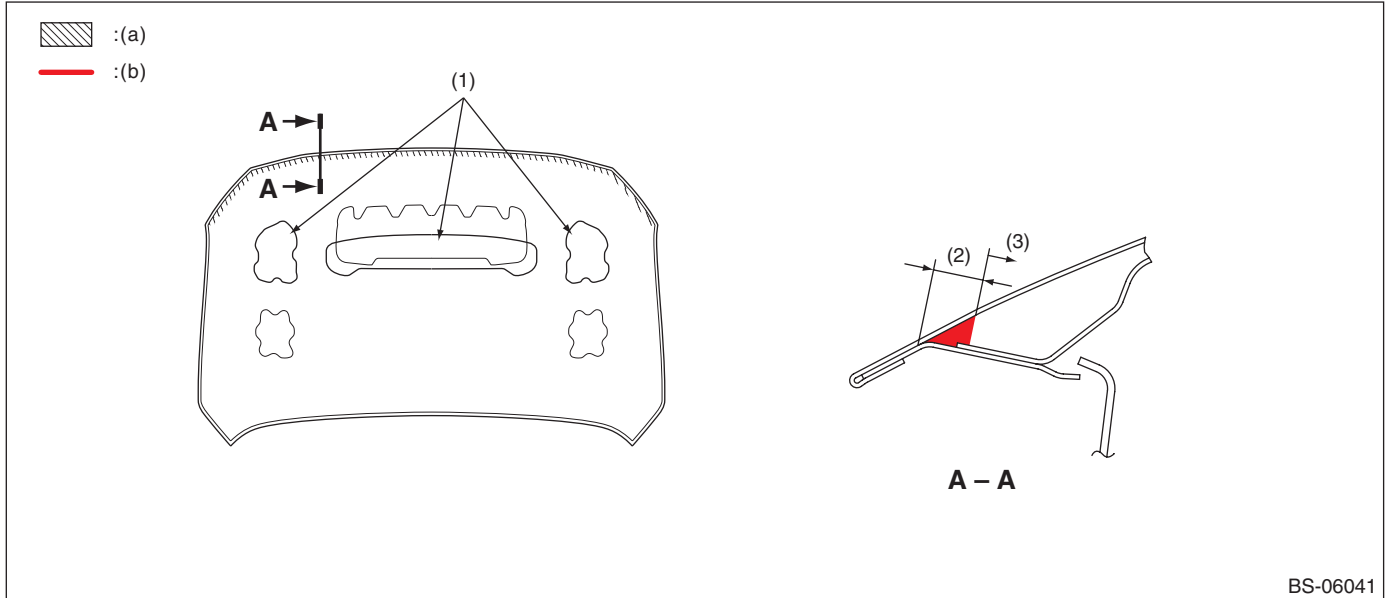
9. Anticorrosion Wax

A: SPECIFICATION

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

— and   : Application area

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



(a) Rust-stop aerosol

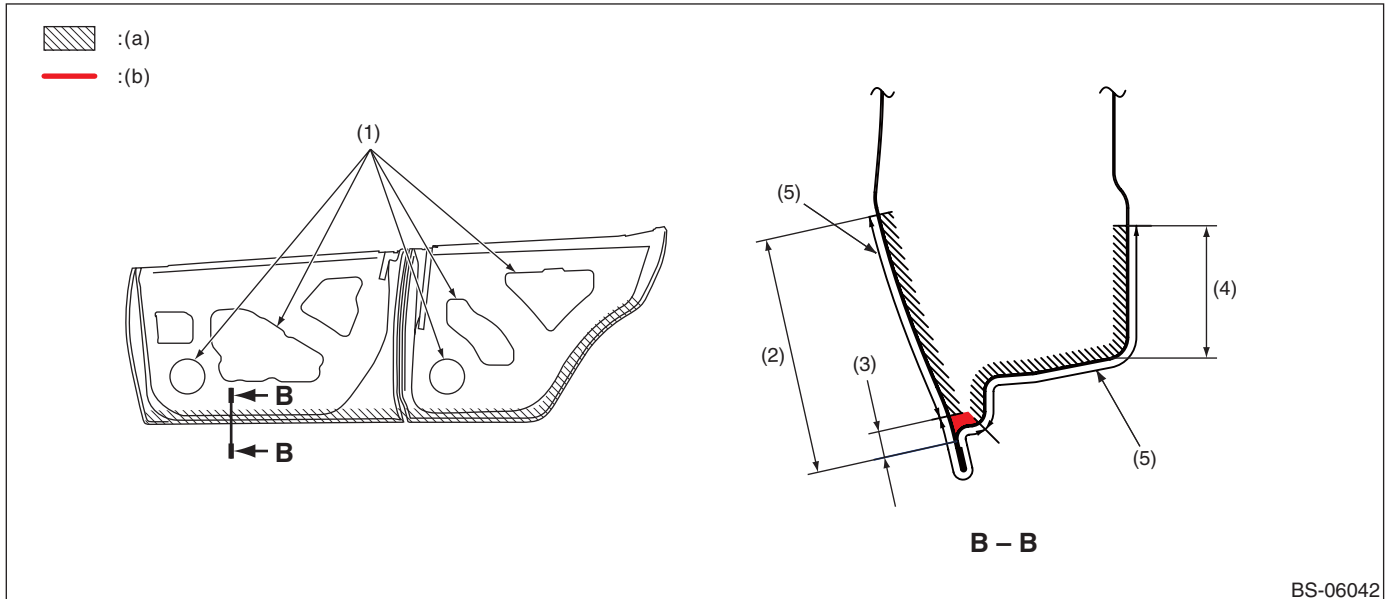
(b) To be filled into the plate joint.

(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)

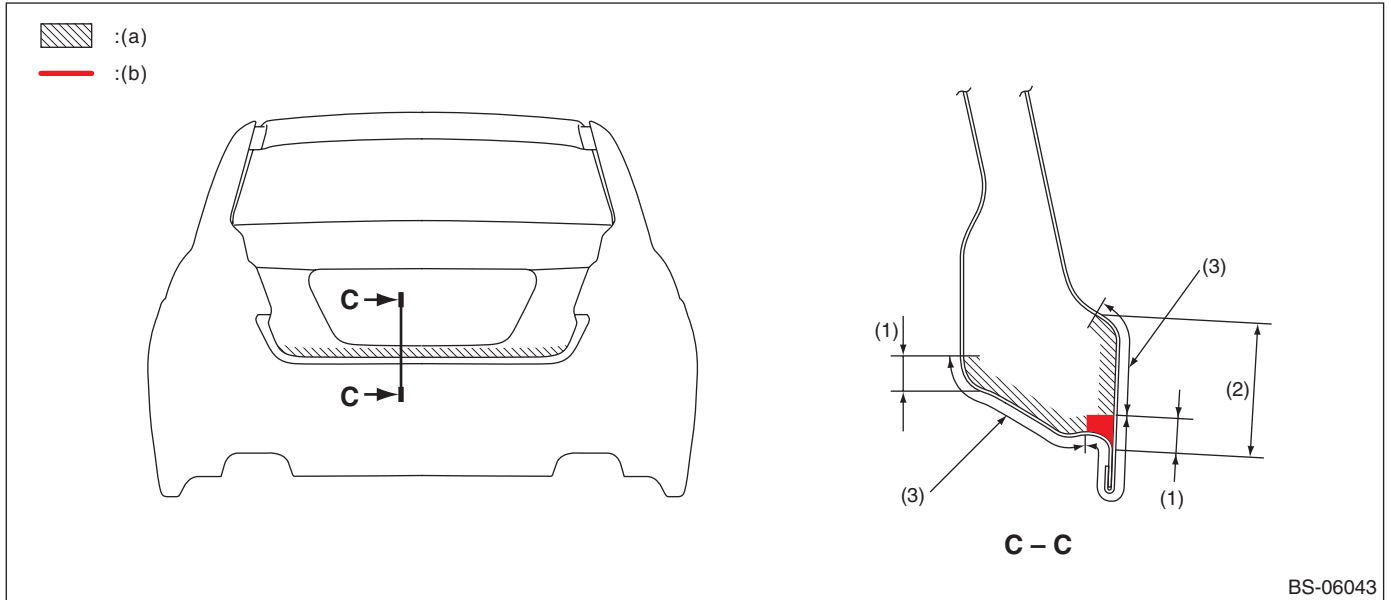
(5) Adherence of mist is allowable.

(2) 90 mm (3.54 in)

(4) 50 mm (1.97 in)

Anticorrosion Wax

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



(a) Rust-stop aerosol

(b) To be filled into the plate joint.

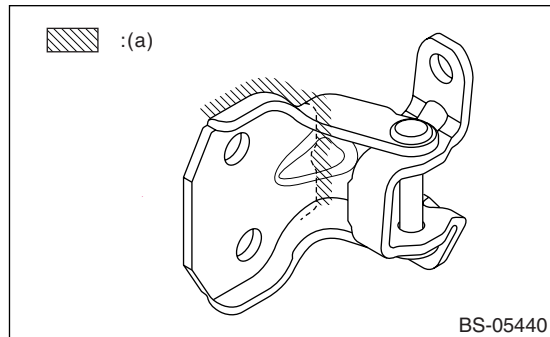
(1) 10 mm (0.39 in)

(2) 40 mm (1.57 in)

(3) Adherence of mist is allowable.

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

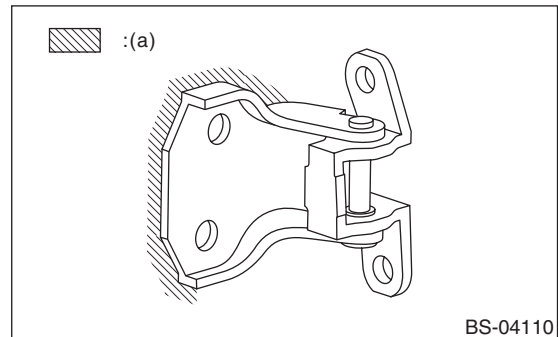
Apply to the contact surface (indicated range) on body side at two locations at the top and bottom (four locations in all), and to the installation outer circumference (plate edges) on the door side.



(a) Rust-stop aerosol

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

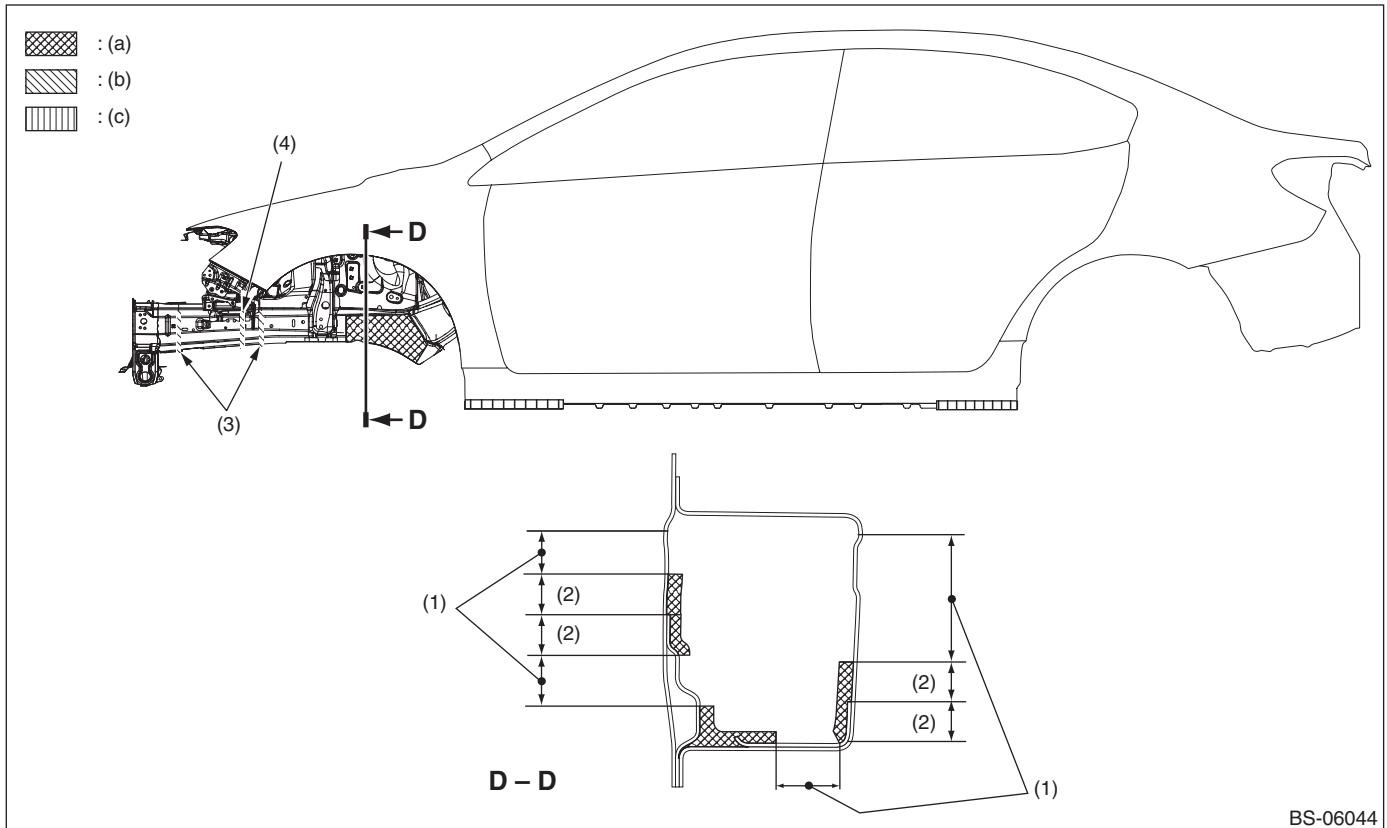
Apply to the contact surface (indicated range) on body side at two locations at the top and bottom (four locations in all), and to the installation outer circumference (plate edges) on the door side.



(a) Rust-stop aerosol

Anticorrosion Wax

• Overall view



BS-06044

(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)

(1) Adherence of mist is allowable.

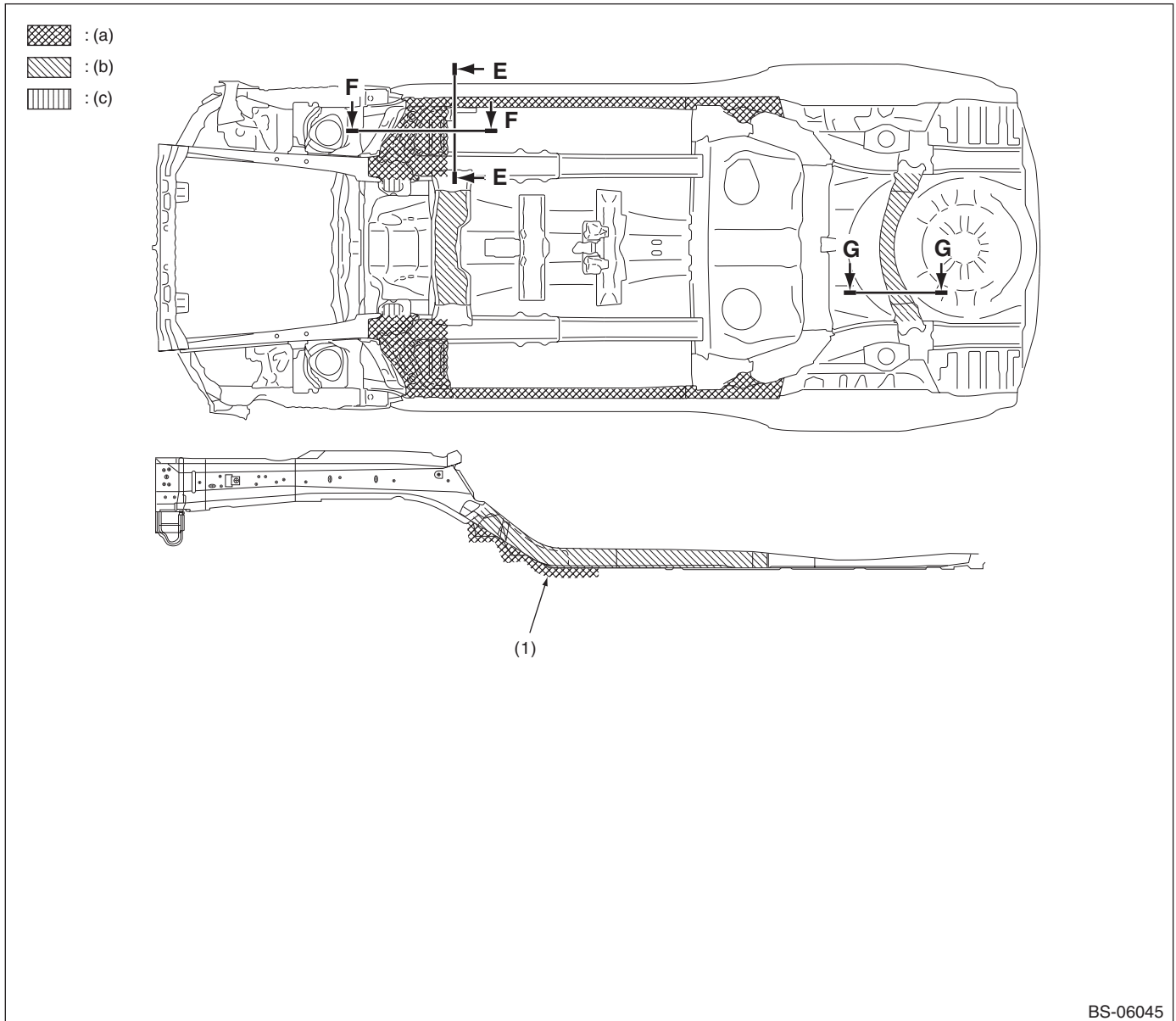
(3) The panel joints are covered.

(4) The panel joints on the inside of the engine compartment are covered.

(2) 20 mm (0.79 in)

Anticorrosion Wax

- Bottom view



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

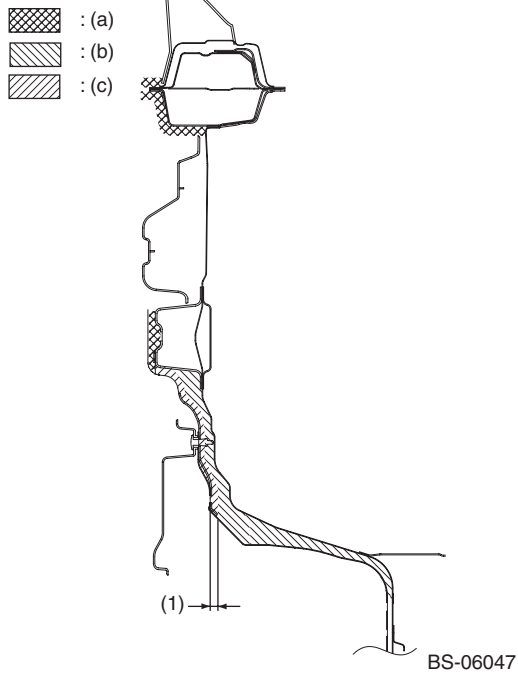
(b) Rust-stop aerosol (Application thickness = 20 μm or more).

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

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

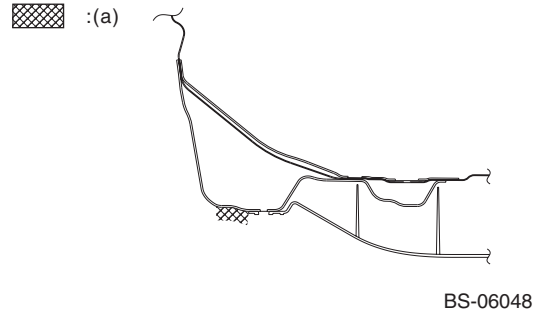
Anticorrosion Wax

Cross section E — E



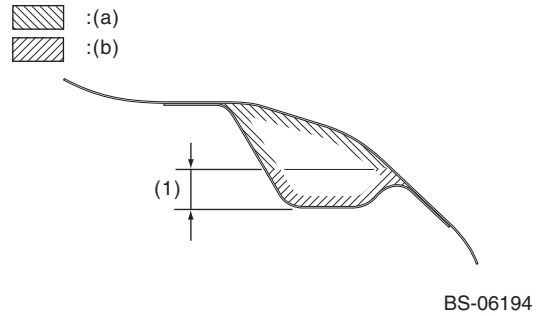
- (a) 150 μm or more
- (b) 20 μm or more
- (c) 50 μm or more
- (1) 10 mm (0.39 in)

Cross section F — F



- (a) 150 μm or more

Cross section G — G



- (a) 20 μm or more
- (b) 50 μm or more
- (1) 10 mm (0.39 in)

10.Undercoat

A: SPECIFICATION

Repair material: PVC (NT guardcoat 5900FL)

CAUTION:

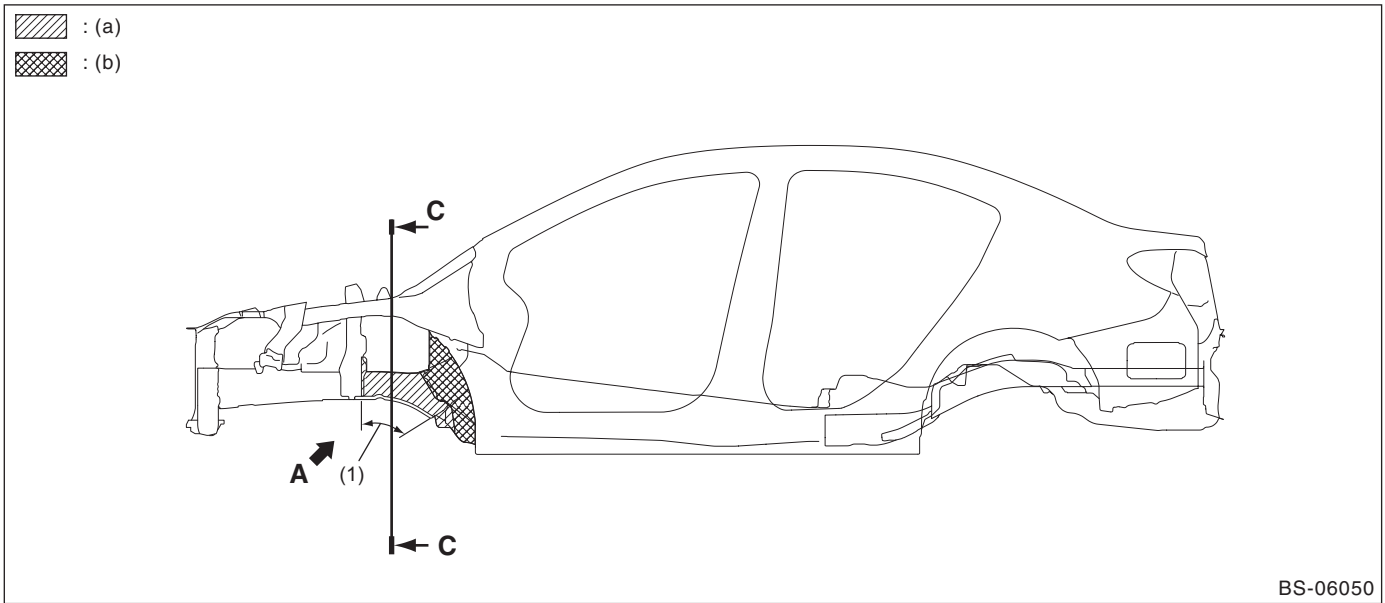
Perform warning so that under the coat will not become attached to locations other than shown and to the following locations.

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

(1) Application area and application thickness

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

- Side view



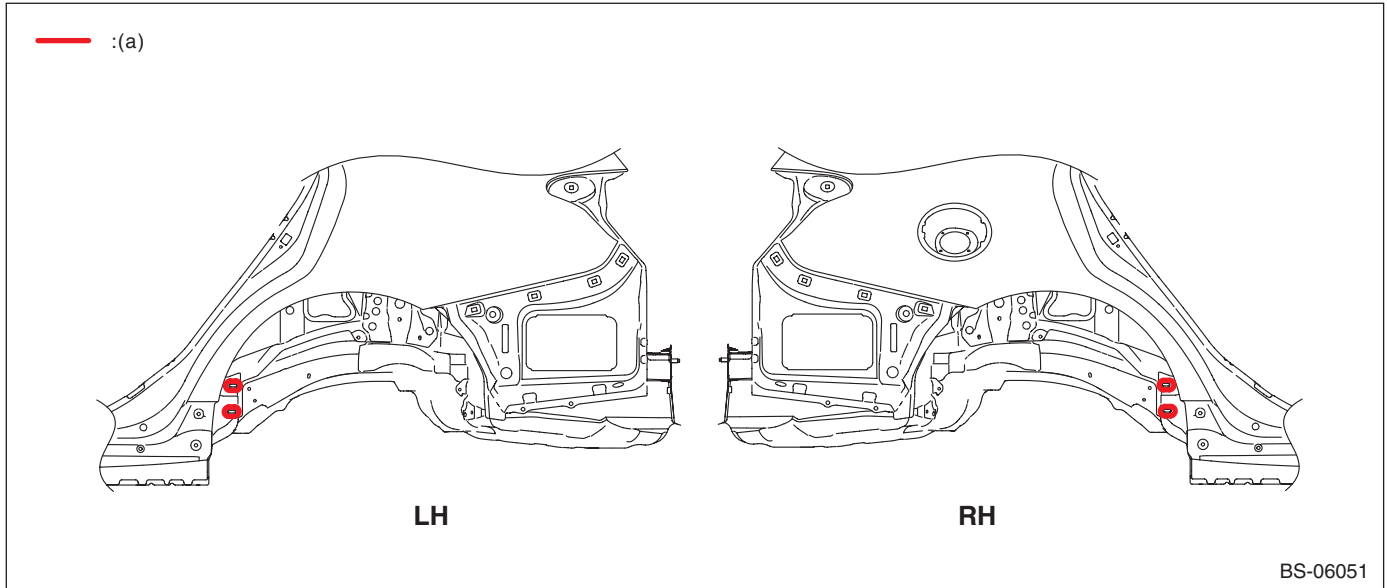
(a) 300 μm or more

(b) 600 μm or more

(1) 10 mm (0.39 in) (Adherence of mist is allowable.)

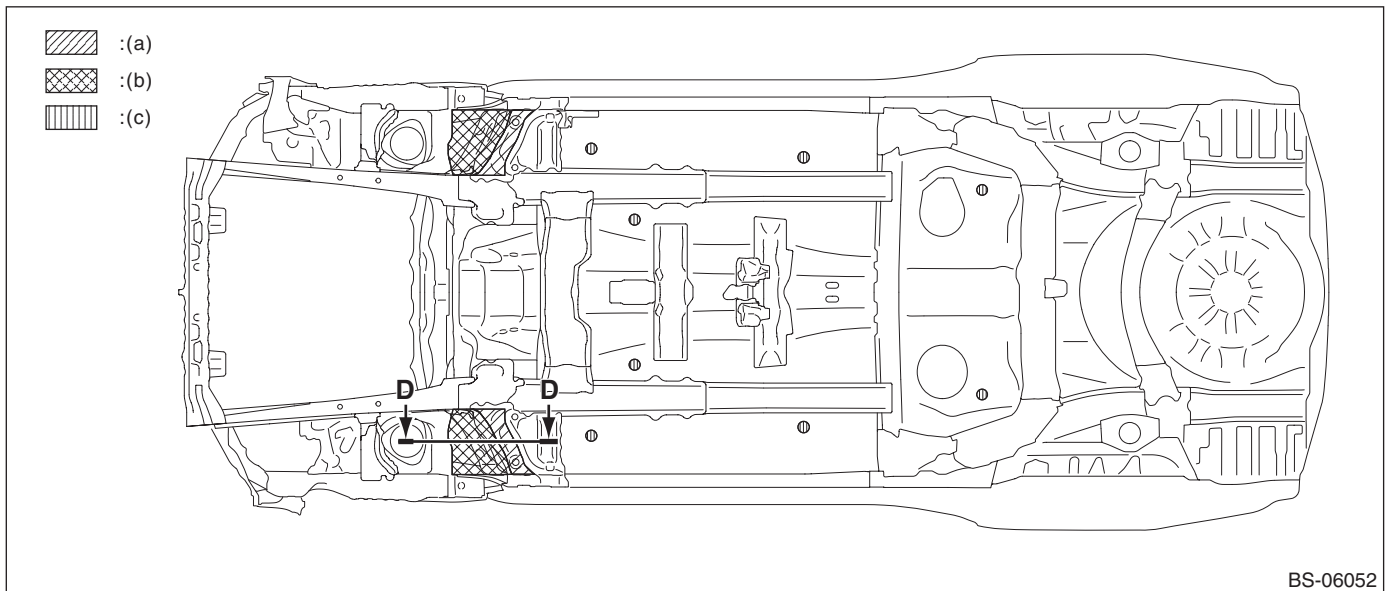
Undercoat

- Rear wheel apron side view



- (a) The panel gap shall be filled.

- Bottom view



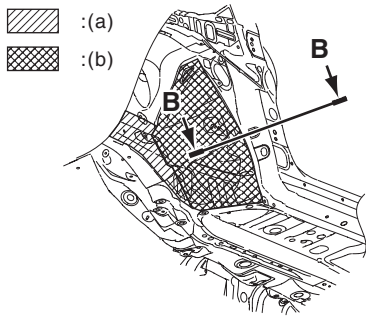
- (a) 300 μm or more

- (b) 600 μm or more

- (c) 200 μm or more

Undercoat

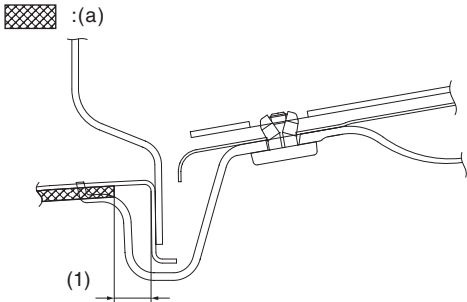
View A



BS-06054

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

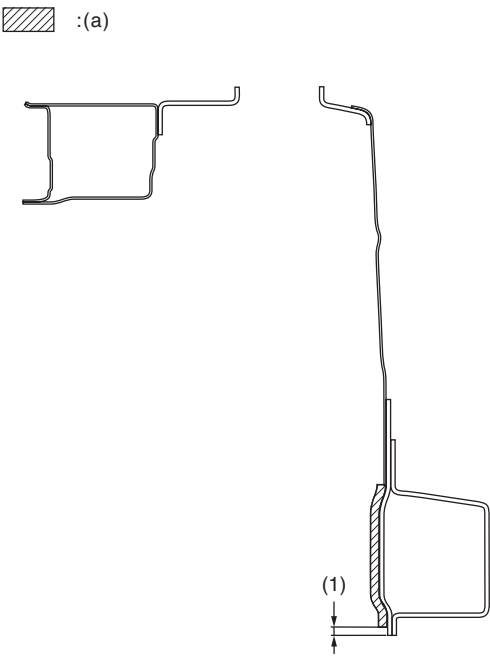
Cross section B — B



BS-06055

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

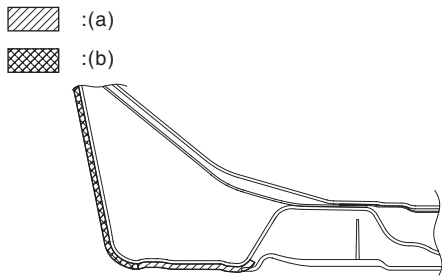
Cross section C — C



BS-06189

- (a) 300 μm or more
- (1) 10 mm (0.39 in) (Adherence of mist is allowable.)

Cross section D — D



BS-06056

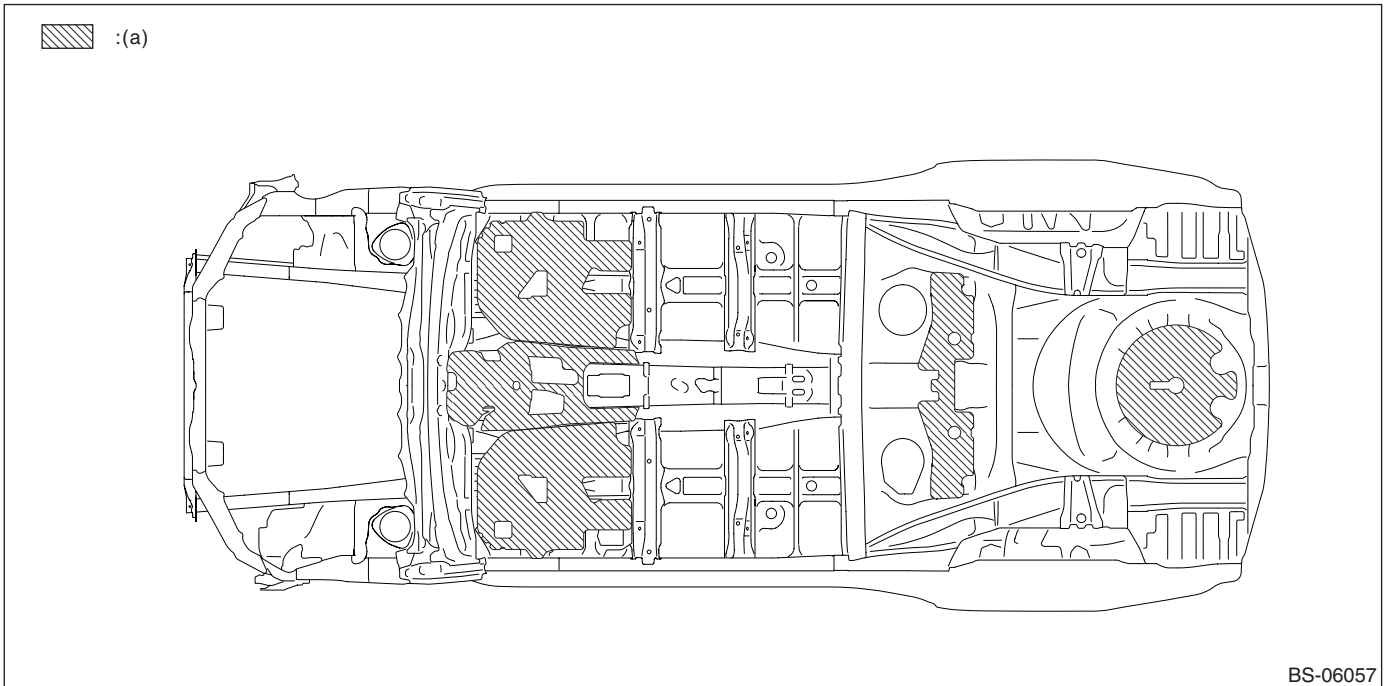
- (a) 300 μm or more
- (b) 600 μm or more

SUBARU.

11.Damping seat

A: SPECIFICATION

1. UPPER VIEW

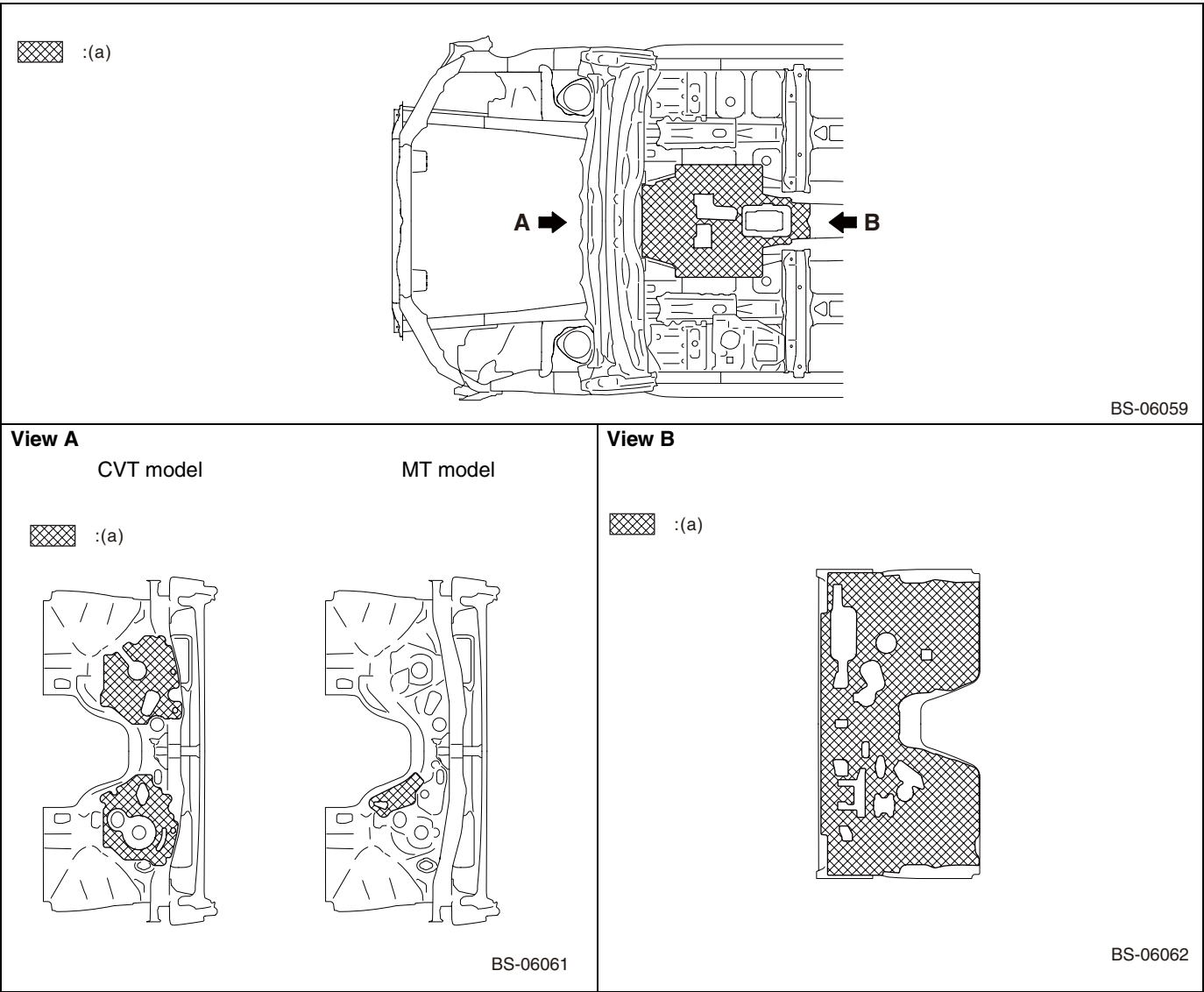


(a) Silencer

12.Insulator

A: SPECIFICATION

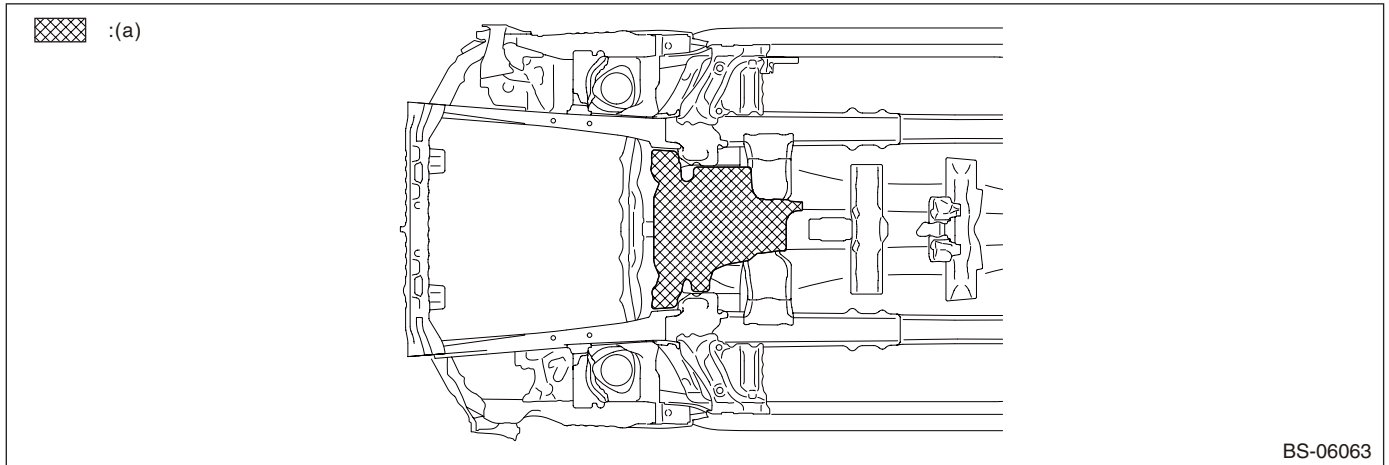
1. UPPER VIEW



(a) Insulator

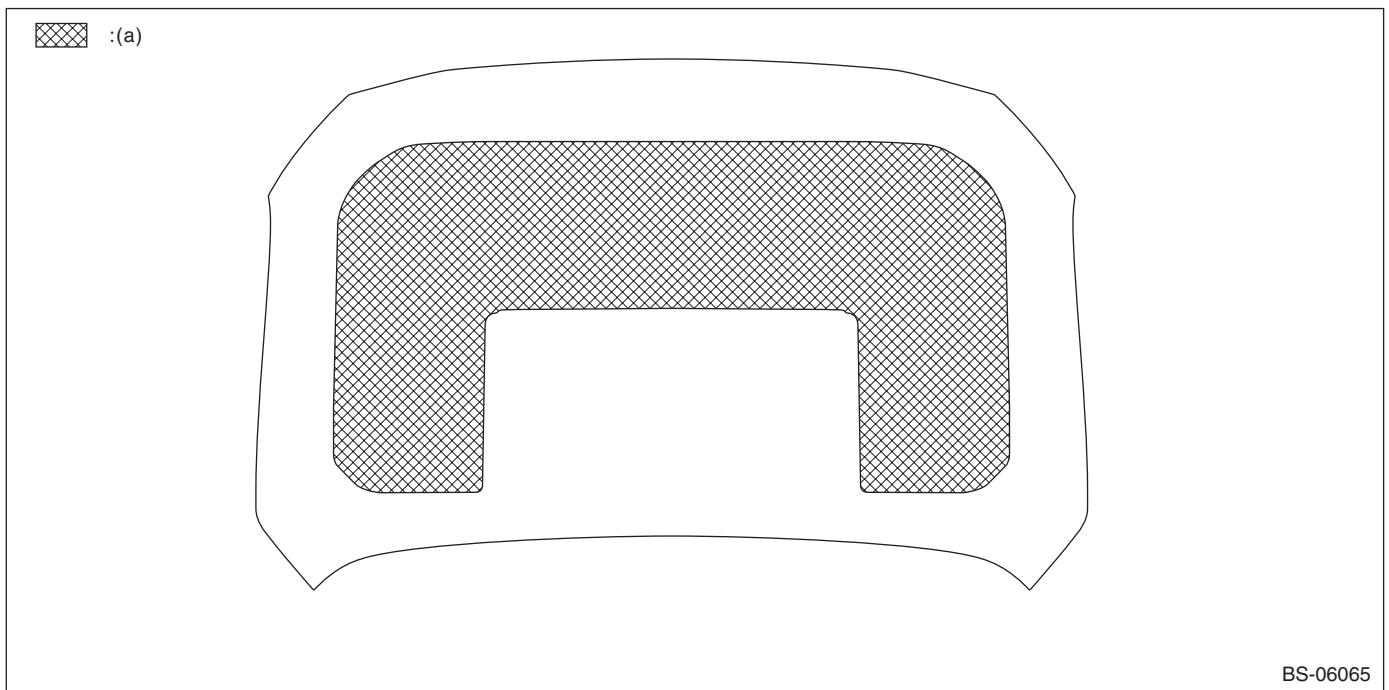
Insulator

2. BOTTOM VIEW



(a) Insulator

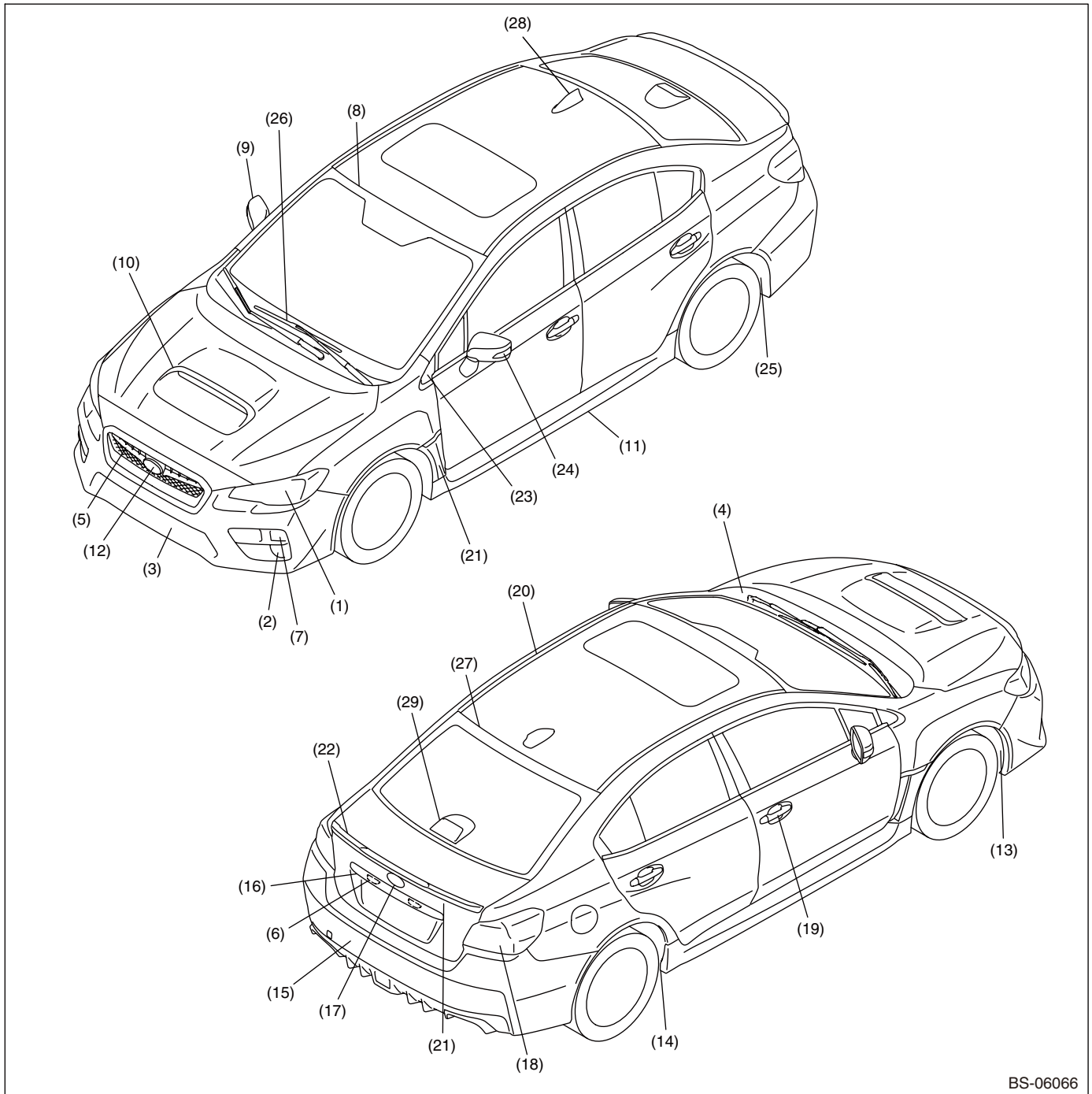
3. FRONT HOOD



(a) Insulator

13. Plastic Parts and Materials

A: SPECIFICATION



BS-06066

Plastic Parts and Materials

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

No.	Part name		Material
(1)	Headlight (halogen)	Lens	PC
		Housing	PP+TD20
		Inner panel	PBT+PET+TD20
		Reflector	BMC
		Reflex reflector	PC
		Inner Lens	PC
	Headlight (LED)	Lens	PC
		Housing	PP+TD20
		Inner panel	PBT+PET+TD20
		Reflector	BMC
		Reflex reflector	PC
		Inner Lens A	PC
		Inner Lens B	PC
(2)	Front fog light	Lens	PC
		Reflector	PC
		Bracket	PP+TD30
(3)	Front bumper	Face	PP
		Fog light cover	PP
		Hook cover	PP
		Cover side lower	PP
		Side bracket	POM
		Corner bracket	PP+GF30
(4)	Cowl panel	Body, Side	PP+TD10
		Side	PP
(5)	Front grille	Grille	AES
		Spacer	PP+GF30
(6)	License light	Lens	PC
		Housing	PC
(7)	Front turn light	Lens	PC
		Housing	PP+TD30
(8)	Front window moulding		PVC
(9)	Door mirror	Body	AES
		Body cover	AES
		Stay cover	AES
		Cover	ABS
(10)	Hood grille	Grille	PPE/PA6-MD10
		Packing A	EPDM
		Packing B	EPDM
		Protector	EPDM

Plastic Parts and Materials

No.	Part name		Material
(11)	Side spoiler		PP
(12)	Ornament front		ABS+PMMA
(13)	Front mudguard	Body	PE
		Air flap	PE
(14)	Air flap rear		PP+EPDM
(15)	Rear bumper	Face	PP
		Hook cover	PP
		Side bracket	POM
		Corner bracket	PP+GF30
		Cover side lower	PP
		Cover fog Rear	PP
(16)	Trunk garnish		ABS
(17)	Ornament rear		ABS+PMMA
(18)	Rear combination light	Lens	PMMA
		Housing	ASA
		Inner Housing A	PC
		Inner Housing B	PC
		Inner Lens A	PC
		Inner Lens B	PMMA
		Inner Lens C	PMMA
(19)	Door handle	Handle	PC+PBT-MD10
		Handle cover	PC+PBT-MD10
(20)	Roof moulding		PVC
(21)	Fendergarnish	Garnish	PP
		Moulding	ABS
(22)	Rear spoiler (small size)	Body	ABS
	Rear spoiler (large size)	Body	ABS
		Cover	ABS
(23)	A-pillar cover		AES
(24)	Side turn light	Lens	PMMA
		Housing	PC
(25)	Rear mudguard		PE
(26)	Front wiper	Blade	PBT
(27)	Rear window moulding		PVC
(28)	Antenna		PC+ASA
(29)	High mount stop light	Lens	PC
		Housing	PP
		Cover	PP
	Under cover	Body	PP
	Splash board		PP

List of Plastic Material Notations

14. List of Plastic Material Notations

A: SPECIFICATION

Notation symbol	Material name	Notation symbol	Material name
ABS	ABS resin (acrylonitrile/butadiene/styrene/resin)	PET+TD20	Polyethylene terephthalate (20 % talc)
AES	Acrylonitrile/ethylene/styrene	PMMA	Polymethyl methacrylate
ASA	Acrylonitrile/styrene/acrylate	POM	Polyacetal
BMC	Premixed bulk molding compound	PP	Polypropylene
EPDM	Ethylene/propylene/dien rubber	PP+GF30	Polypropylene (30 % glass fiber content)
PA6-MD10	Nylon 6 (10 % mineral powder content)	PPE	Polyphenylene ether
PBT	Polybutylene terephthalate	PP+TD10	Polypropylene (10 % talc)
PBT-MD10	Polybutylene terephthalate (10 % mineral powder content)	PP+TD20	Polypropylene (20 % talc)
PC	Polycarbonate	PP+TD30	Polypropylene (30 % talc)
PE	Polyethylene	PVC	Polyvinyl chloride
PET	Polyethylene terephthalate		