

BODY REPAIR MANUAL

BS

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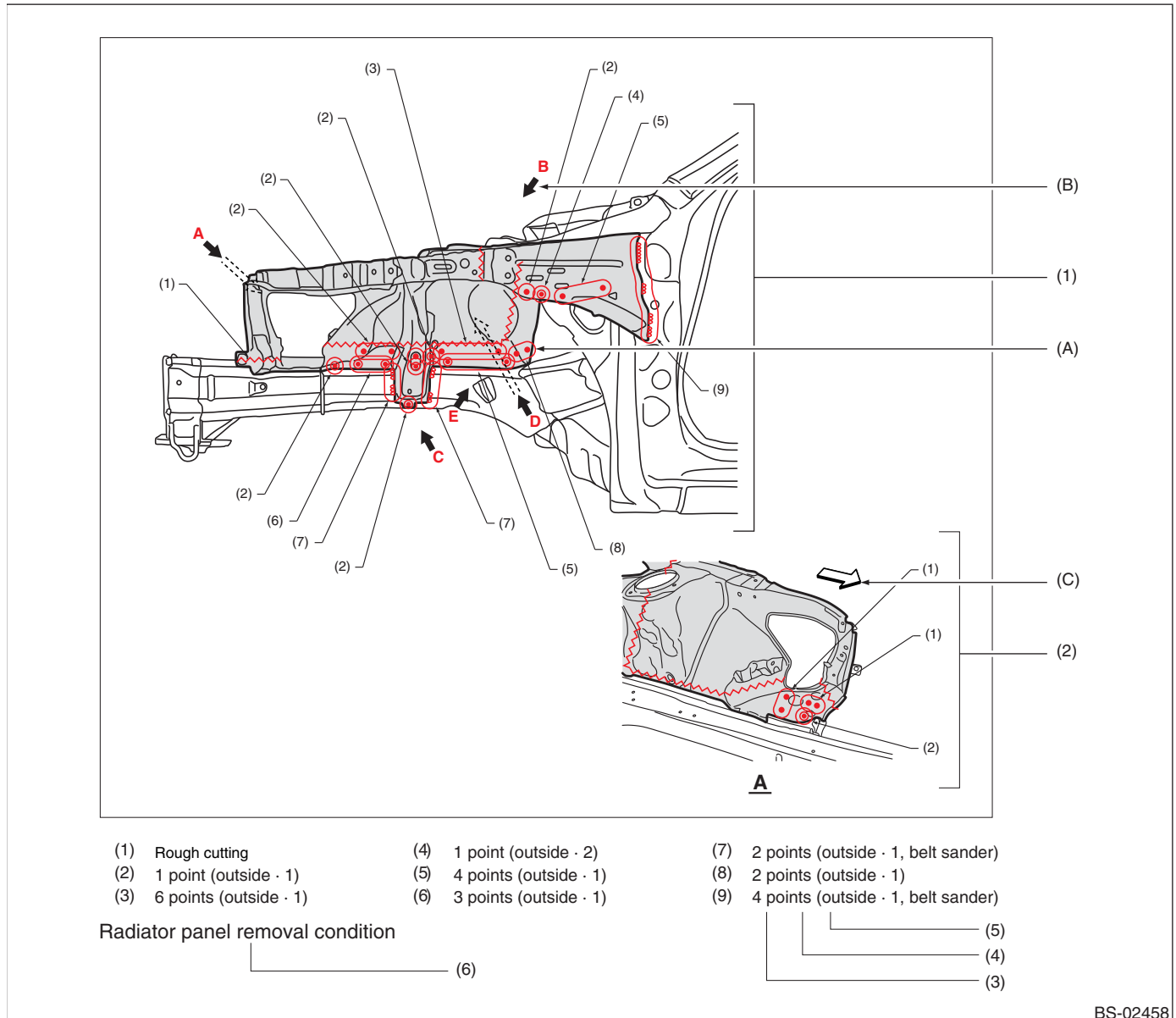
1. Foreword

A: USE OF THIS MANUAL

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

1. ILLUSTRATION EXAMPLE

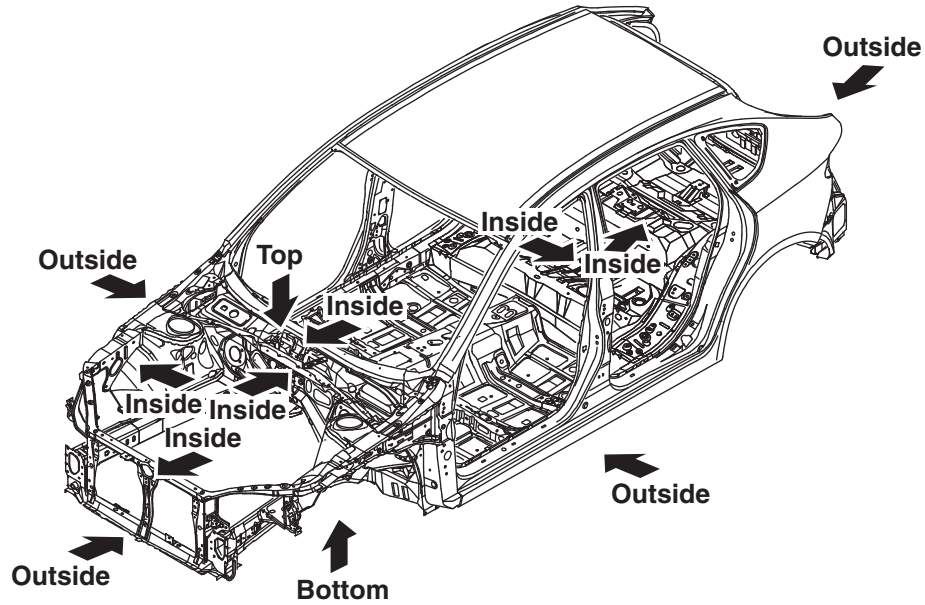
- Symbols and number of points indicate the welding method and the number of welding points. Text in brackets indicates the direction for removal of welded parts, and numbers indicate the number of plates to be drilled in panels of welded parts to be removed.
- An enclosure by a broken line indicates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



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

2. REMOVAL DIRECTION

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

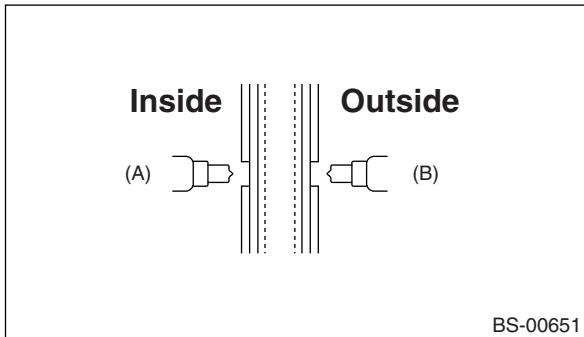


BS-02459

3. NUMBER OF PANELS TO BE DRILLED

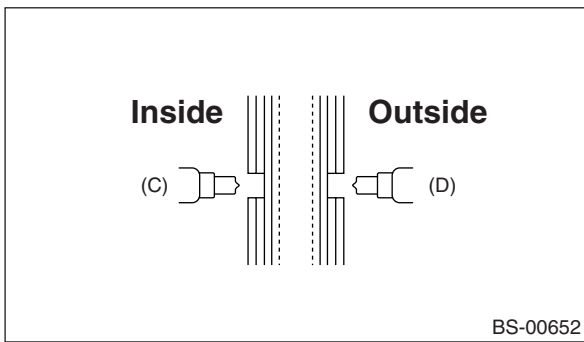
Depending on the number of panels, drilling is done through one panel or two panels, and this number is listed together with the removal direction.

(1) Drilling through one plate



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

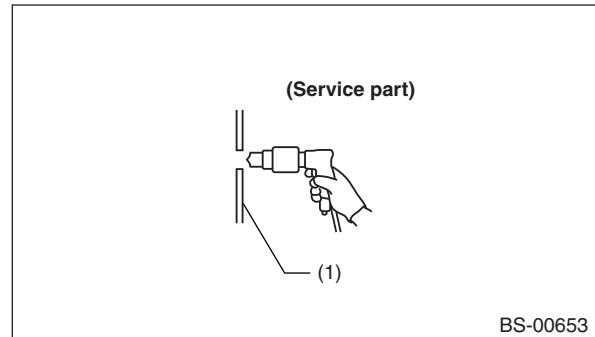
(2) Drilling through two plates



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

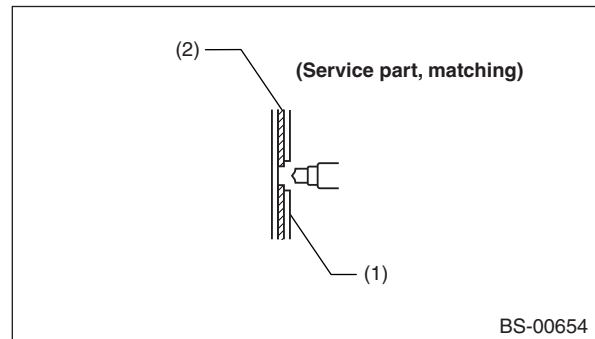
4. HOLE DRILLING FOR PLUG WELDING

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



- (1) Service part

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

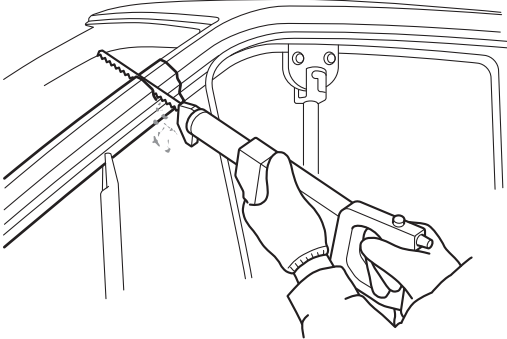


- (1) Vehicle side
- (2) Service part

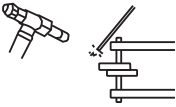
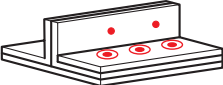
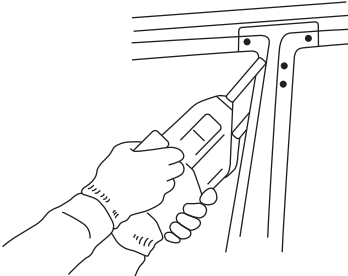
Foreword

5. MEANING OF SYMBOLS

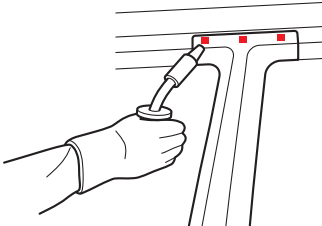
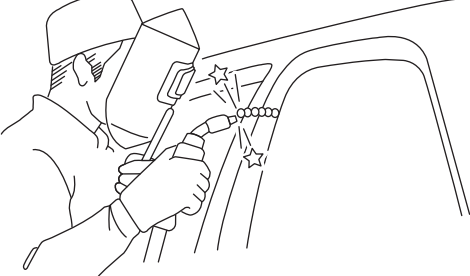
• Cutting

	
BS-00352	BS-00267

• Spot welding

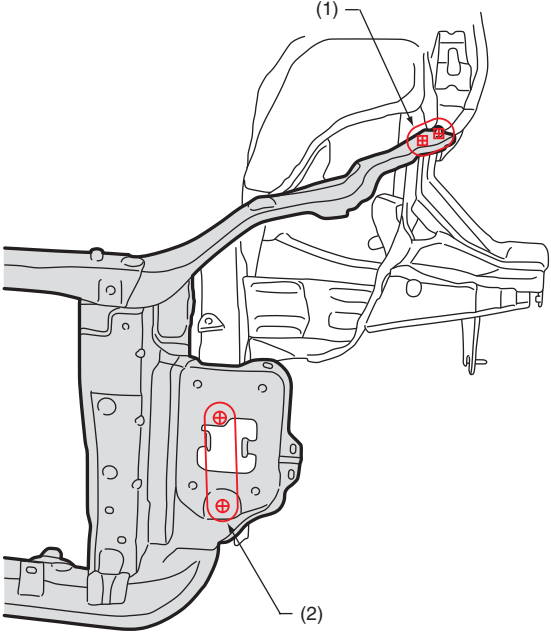
Two overlapping parts	 BS-00655	 BS-00656	 BS-00657	 BS-00658
Three or more overlapping parts	 BS-00659	 BS-00660		

• Carbon dioxide gas arc welding (MIG welding)

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

Foreword

- Bolt, nut tightening portion

Bolt	 BS-04481	 BS-04483
Nut	 BS-04482	

(1) Bolt
(2) Nut

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

To drill high-strength steel sheets of 980 MPa class and 1,500 MPa class, use a tool that can machine objects of 500 Hv or more hardness (e.g., Cyutokenzai: C-20VR).

It is recommended to perform the weldings using 980 MPa class and 1,500 MPa class high-strength steel under the following conditions.

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

Spot welding	[a]	Compression	3.5 kN	Total number of 2 overlapping sheets	
		Current	7.0 kA		
		Welding time	25 cyc		
	[b]	Compression	3.5 kN		
		Current	7.5 kA		
		Welding time	25 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	7.5 kA		
		Welding time	25 cyc		
	[e]	Compression	4.4 kN		
		Current	8.0 kA		
		Welding time	20 cyc		
[f]	Compression	4.4 kN	Total number of 2 or 3 overlapping sheets		
	Current	8.0 kA			
	Welding time	25 cyc			
Plug welding	[g]	A		Plug diameter	8.5 mm (0.33 in) or more
				Wire	YGW12
				Gas	CO2
		B	Plug diameter	8.5 mm (0.33 in) or more	
			Wire	YGW16	
			Gas	Gas mixture (argon: 80%, CO2: 20%)	

CAUTION:

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

2. Drill holes for plug welding of steel sheet

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)	φ 5.0 mm (0.20 in) or more
1.0 — 1.6 mm (0.04 — 0.06 in)	φ 6.5 mm (0.26 in) or more
1.7 — 2.3 mm (0.07 — 0.09 in)	φ 8.0 mm (0.31 in) or more
2.4 mm (0.09 in) or more	φ 10.0 mm (0.39 in) or more

Foreword

3. Repair work using foam

CAUTION:

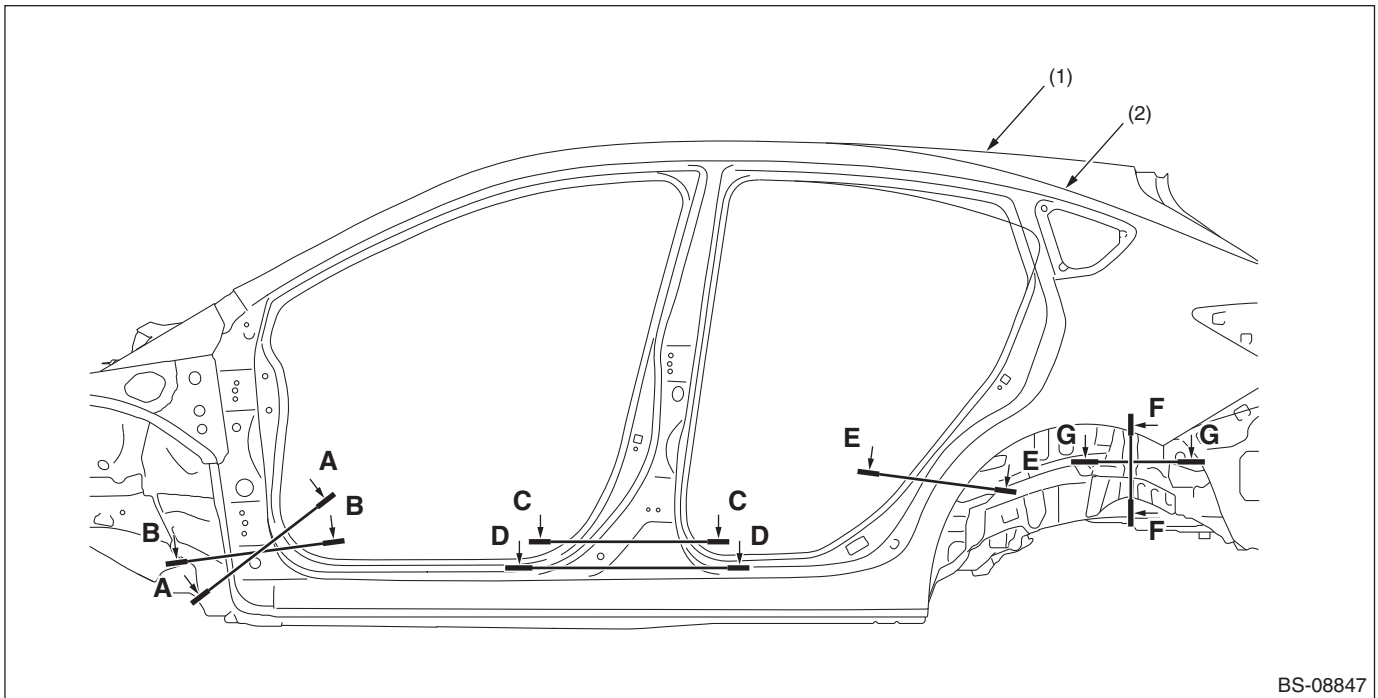
- Do not perform welding or other work involving high temperatures.
- Do not use an open flame at the time of disassembly.
- Remove residual foam before injecting the new material.
- After completion of work, confirm that there is no danger of igniting the material.
- Spray cans that have been used once cannot be used again.
- Use a narrow nozzle.

Recommended materials: Equivalent to High Span Foam made by Cemedine

For a clip plate, reuse the plate and inject cold-setting foam.

If the part cannot be reused due to damage or deterioration, replace the part with a new one.

• COMMON PARTS FOR 5 DOOR AND 4 DOOR

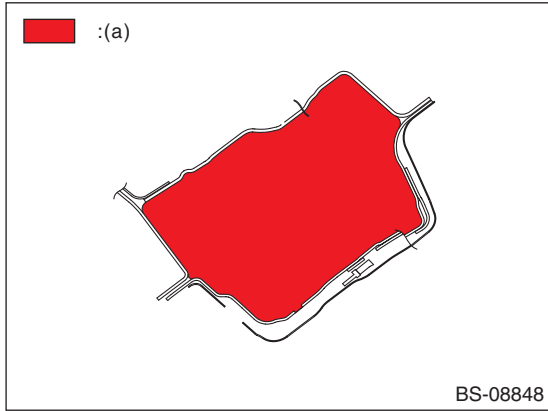


BS-08847

(1) 5 Door

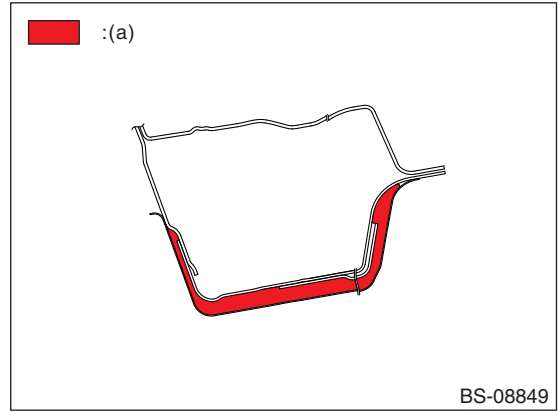
(2) 4 Door

Cross section A — A



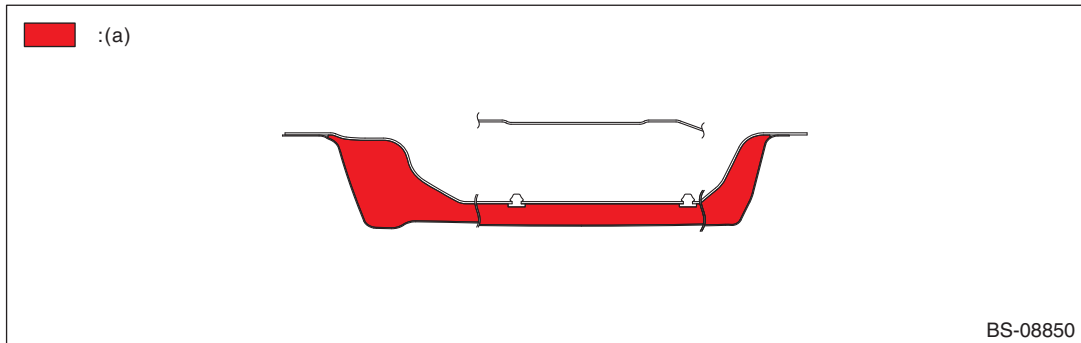
(a) Urethane foam injection locations

Cross section B — B



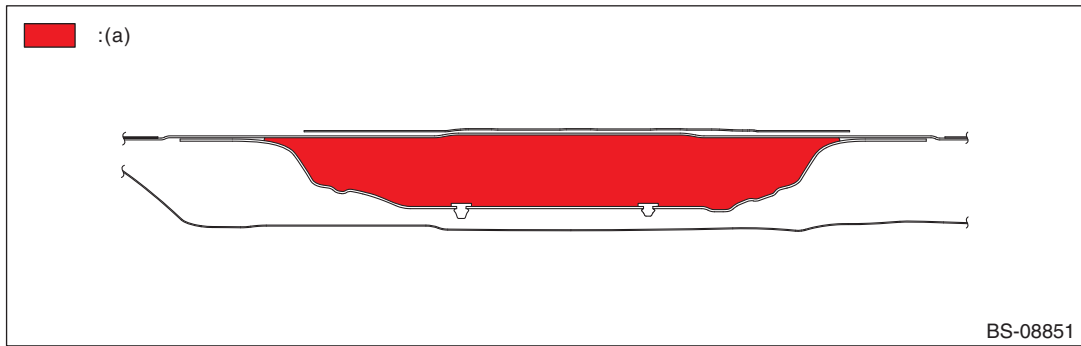
(a) Urethane foam injection locations

Cross section C — C



(a) Urethane foam injection locations

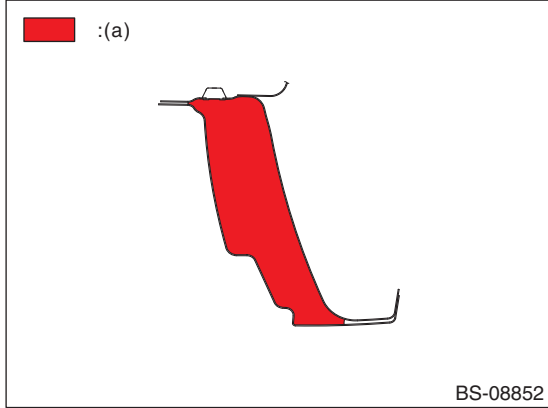
Cross section D — D



(a) Urethane foam injection locations

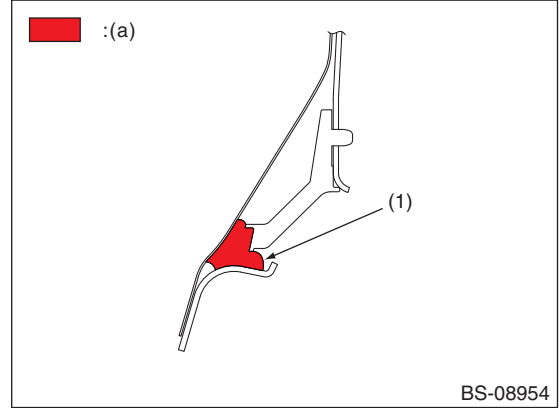
Foreword

Cross section E — E



(a) Urethane foam injection locations

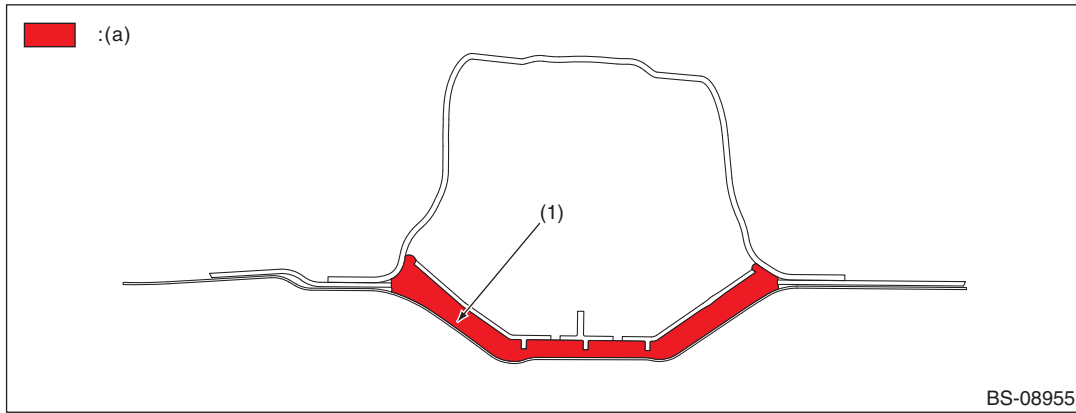
Cross section F — F



(a) Urethane foam injection locations

(1) Cut the foam to the shape of the body.

Cross section G — G

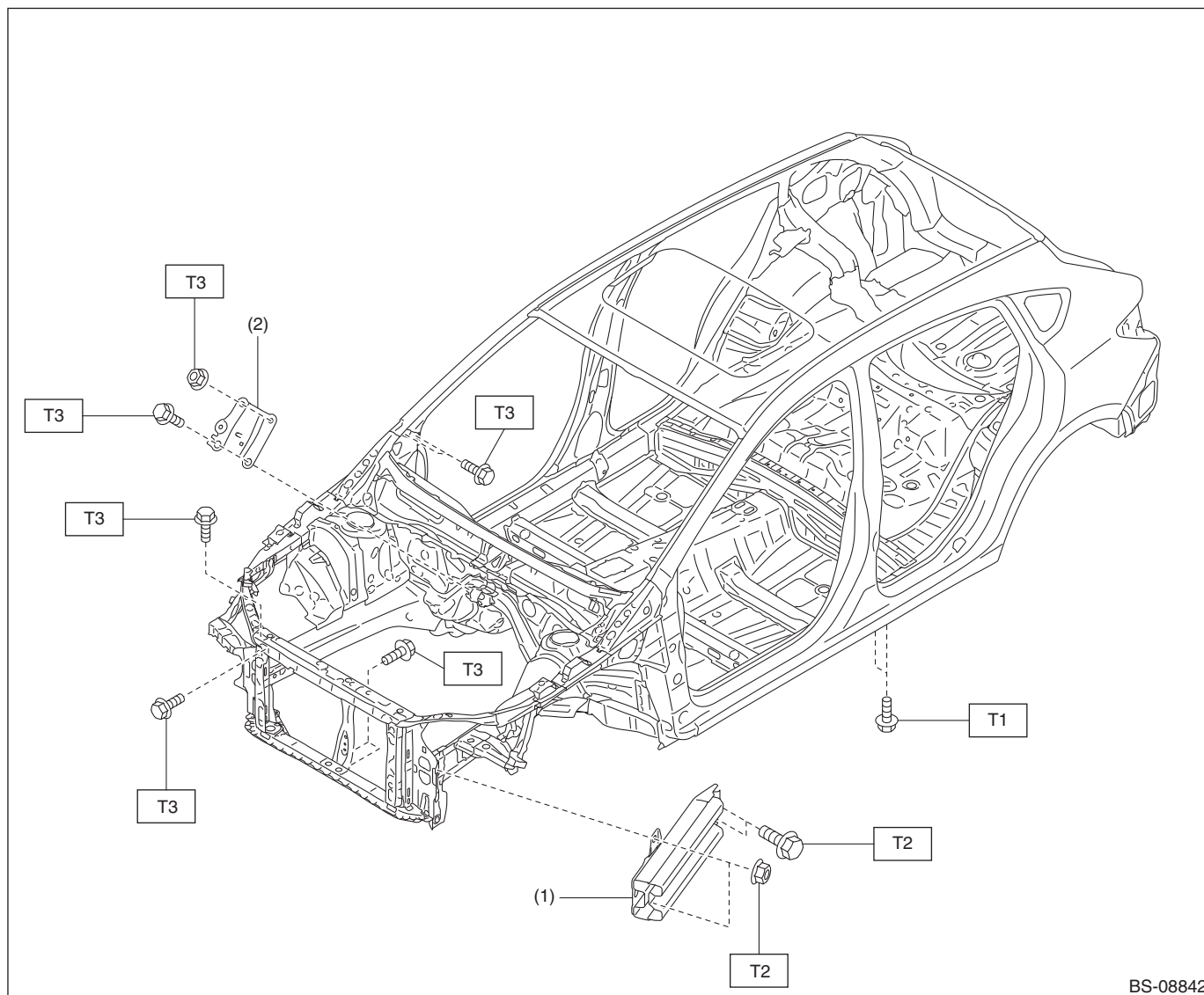


(a) Urethane foam injection locations

(1) Cut the foam to the shape of the body.

2. Assembly of Exterior Parts

A: BODY REINFORCING PARTS



BS-08842

(1) GUSSET CP FT SD

(2) PLT PTG STPR CP

Tightening torque: N·m (kgf-m, ft-lb)

T1: 45 (4.59, 33.19)

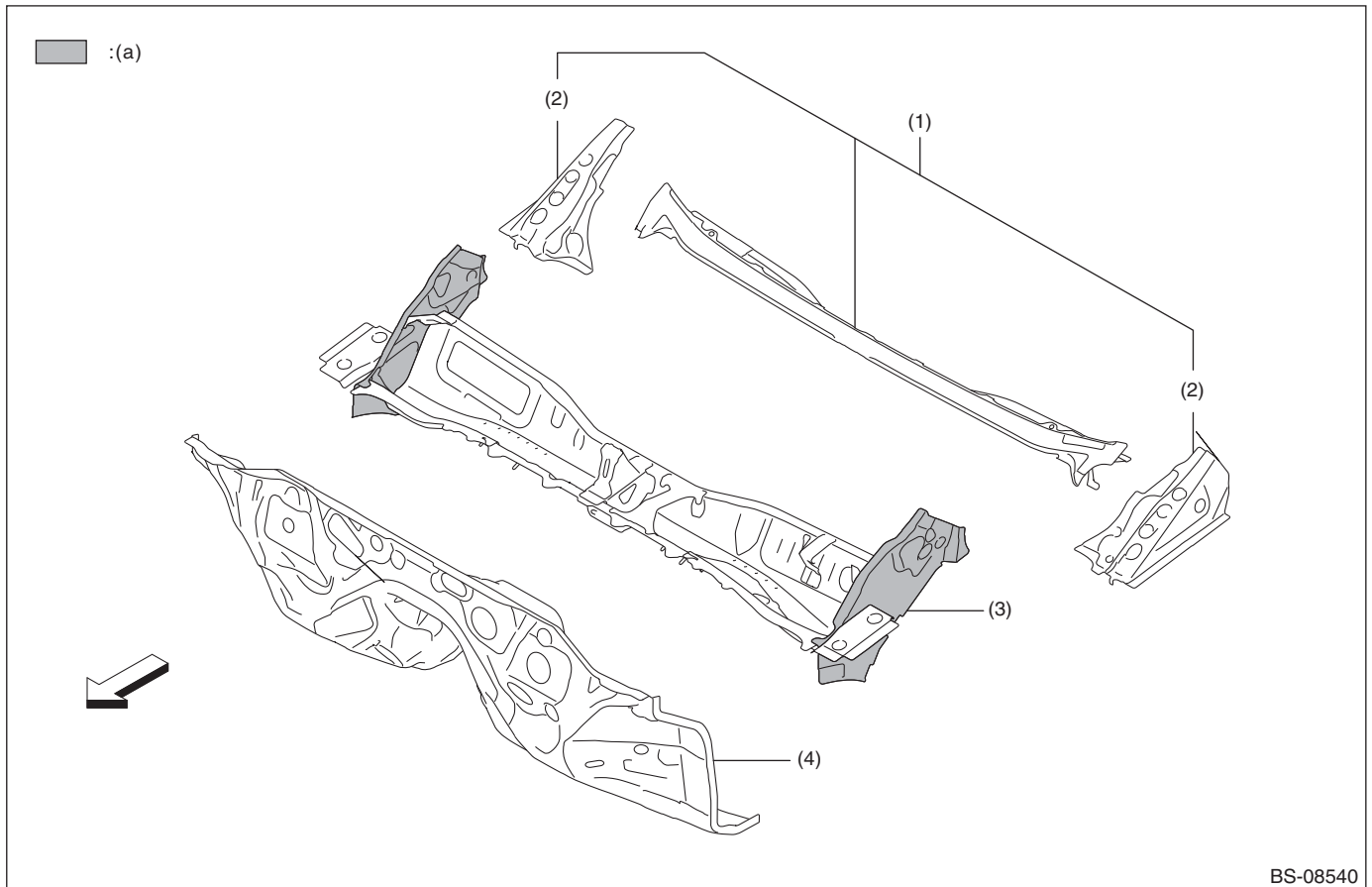
T2: 37 (3.77, 27.3)

T3: 18 (1.84, 13.28)

3. Panel Components

A: COMPONENTS

1. TOE BOARD & FRONT PANEL



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

(1) Front panel

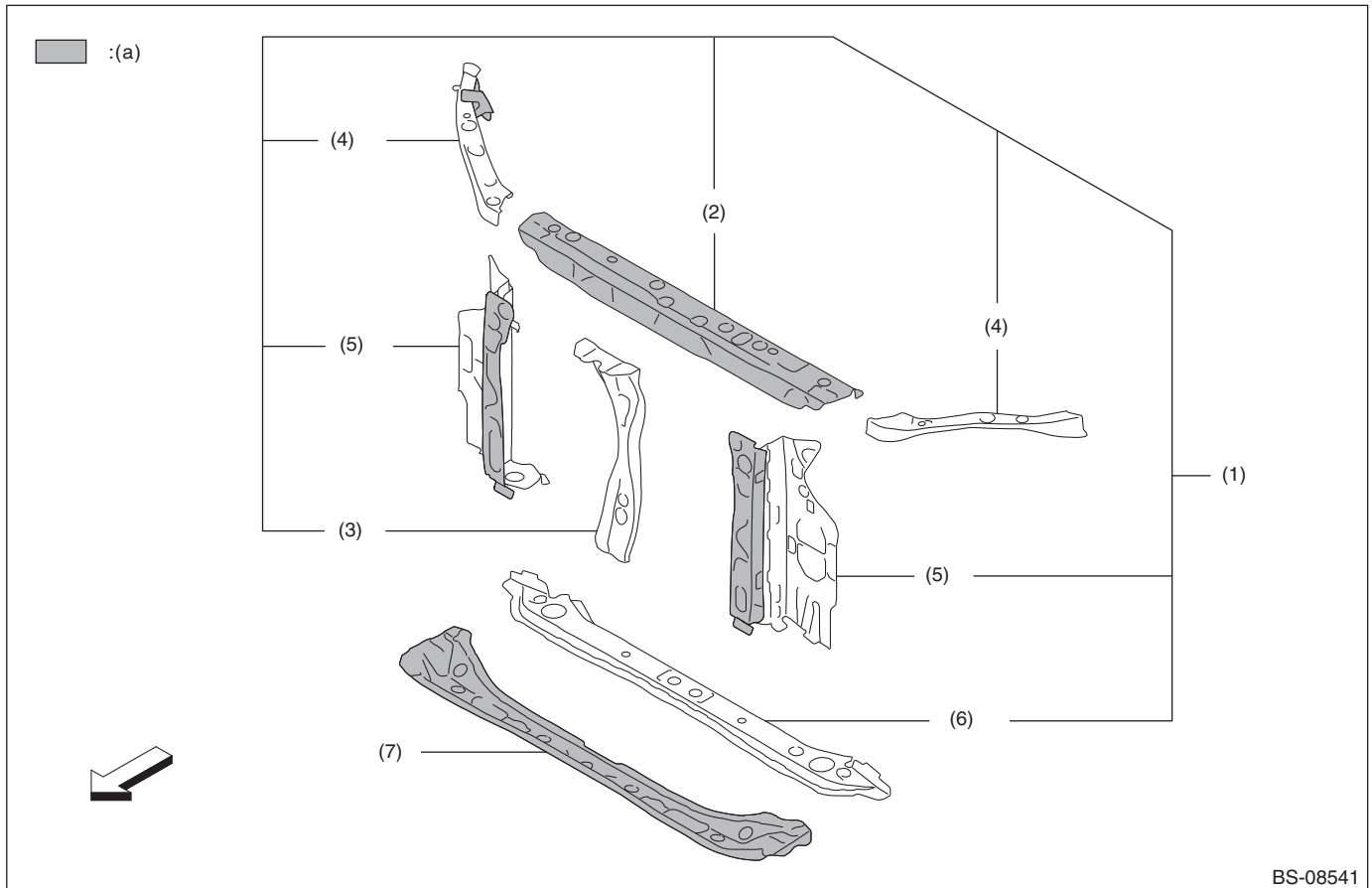
(3) Duct

(4) Toe board

(2) Front panel side reinforcement

Panel Components

2. RADIATOR PANEL



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

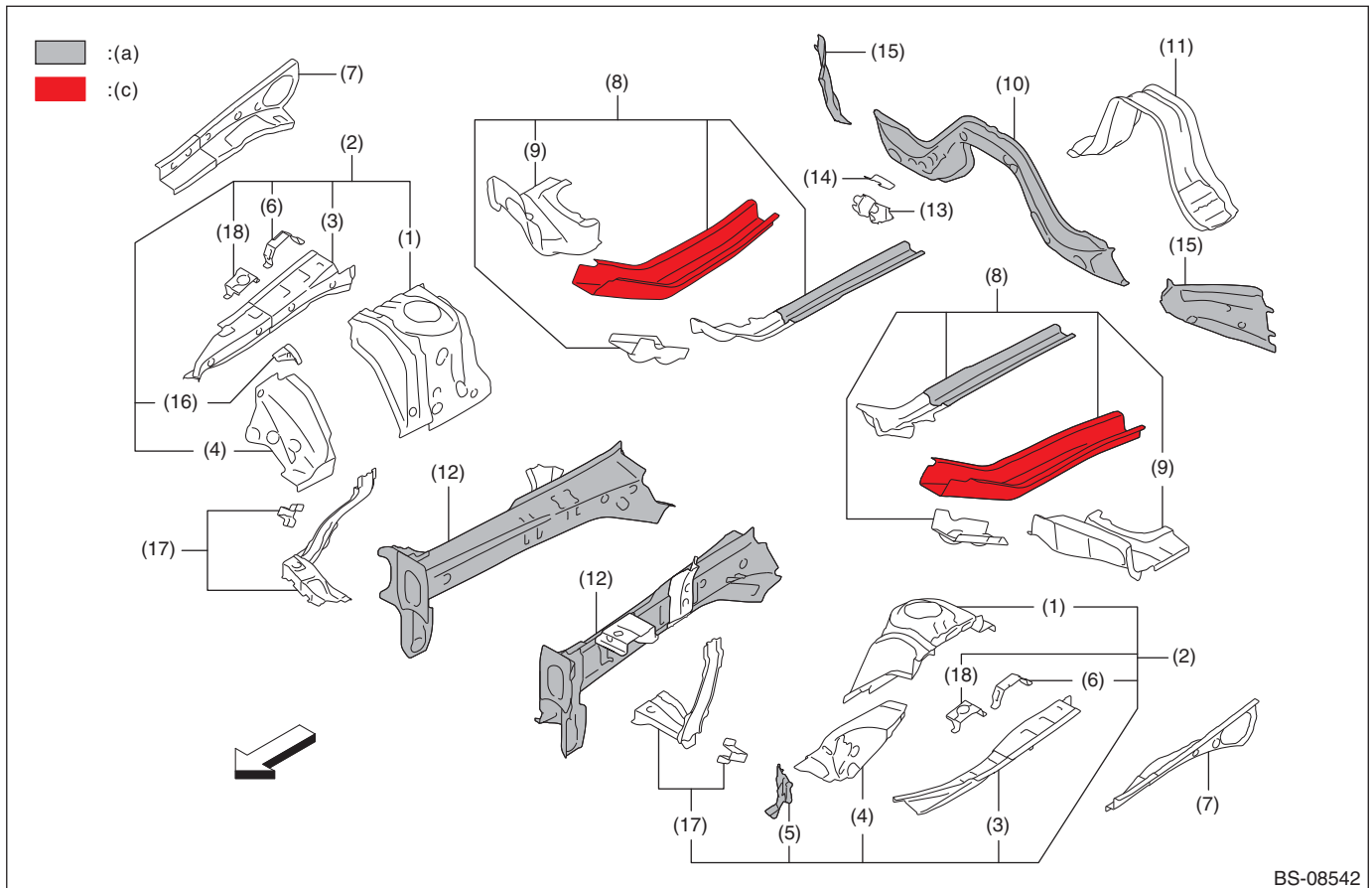
(1) Radiator panel
(2) Radiator frame upper
(3) Hood lock stay

(4) Radiator side frame upper
(5) Radiator panel side
(6) Radiator frame lower A

(7) Radiator frame lower B

Panel Components

3. FRONT WHEEL APRON



BS-08542

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

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

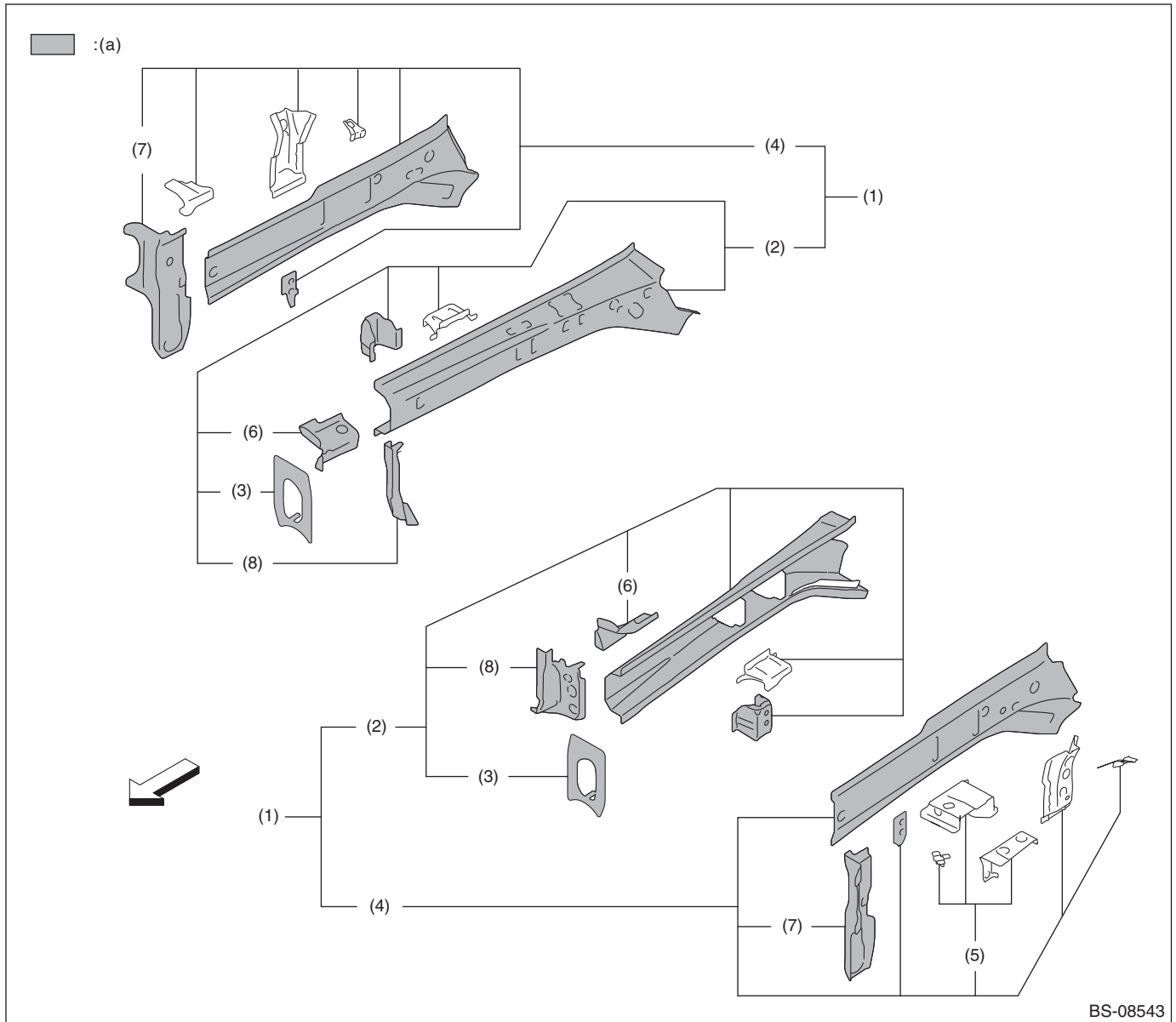
- (1) Front suspension bracket
- (2) Wheel apron
- (3) Side upper inner frame
- (4) Front wheel apron
- (5) Battery rod bracket
- (6) Bracket fender upper front

- (7) Side upper frame
- (8) Front side frame rear
- (9) Toe board reinforcement
- (10) Toe board crossmember center
- (11) Floor crossmember front
- (12) Front side frame front

- (13) Pitching stopper bracket
- (14) Pitching stopper plate
- (15) Toe board crossmember side
- (16) VDC bracket
- (17) Front wheel apron front
- (18) Bracket fender upper rear

Panel Components

4. FRONT SIDE FRAME



BS-08543

(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 bracket

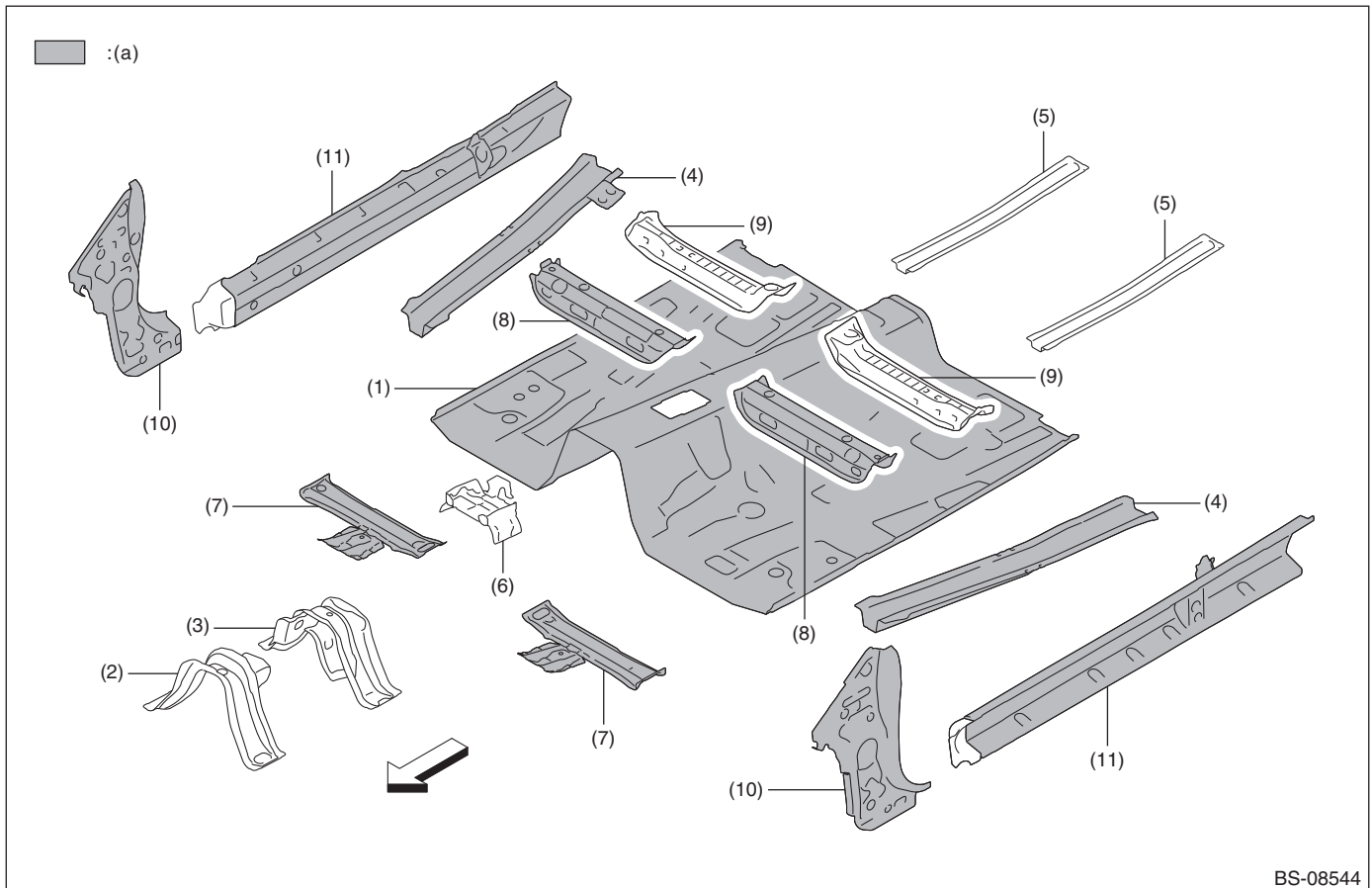
(6) Beam bracket

(7) Front hook reinforcement

(8) Front frame gusset

Panel Components

5. FRONT FLOOR PANEL



BS-08544

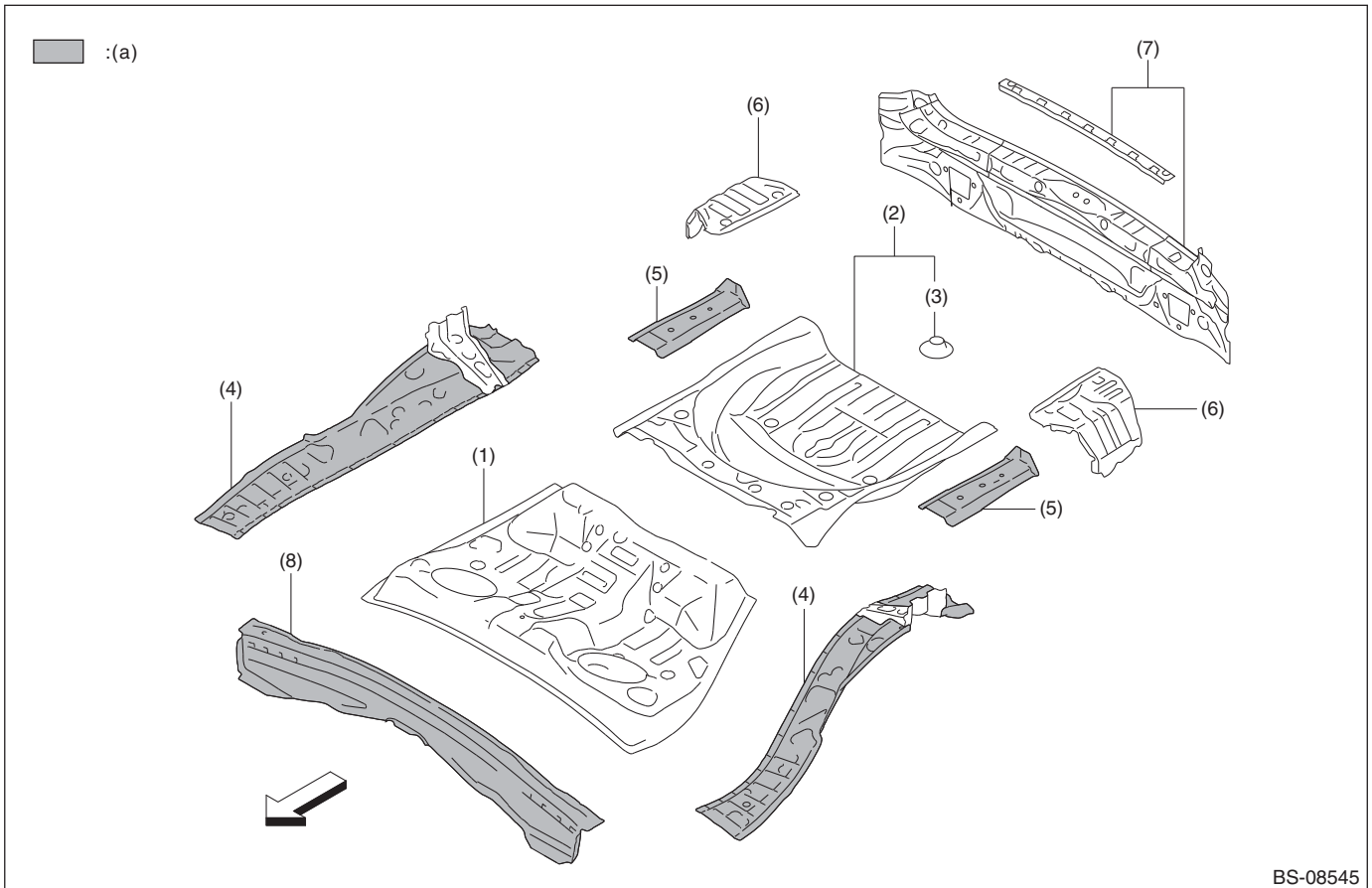
(a) High-strength tensile steel
(440 — 590 MPa class)

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

Panel Components

6. REAR FLOOR PANEL & REAR SKIRT

• 5 Door



BS-08545

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

(1) Rear floor pan front

(2) Rear floor pan rear

(3) Spare tire bracket

(4) Dumper bracket floor upper

(5) Rear side frame upper rear

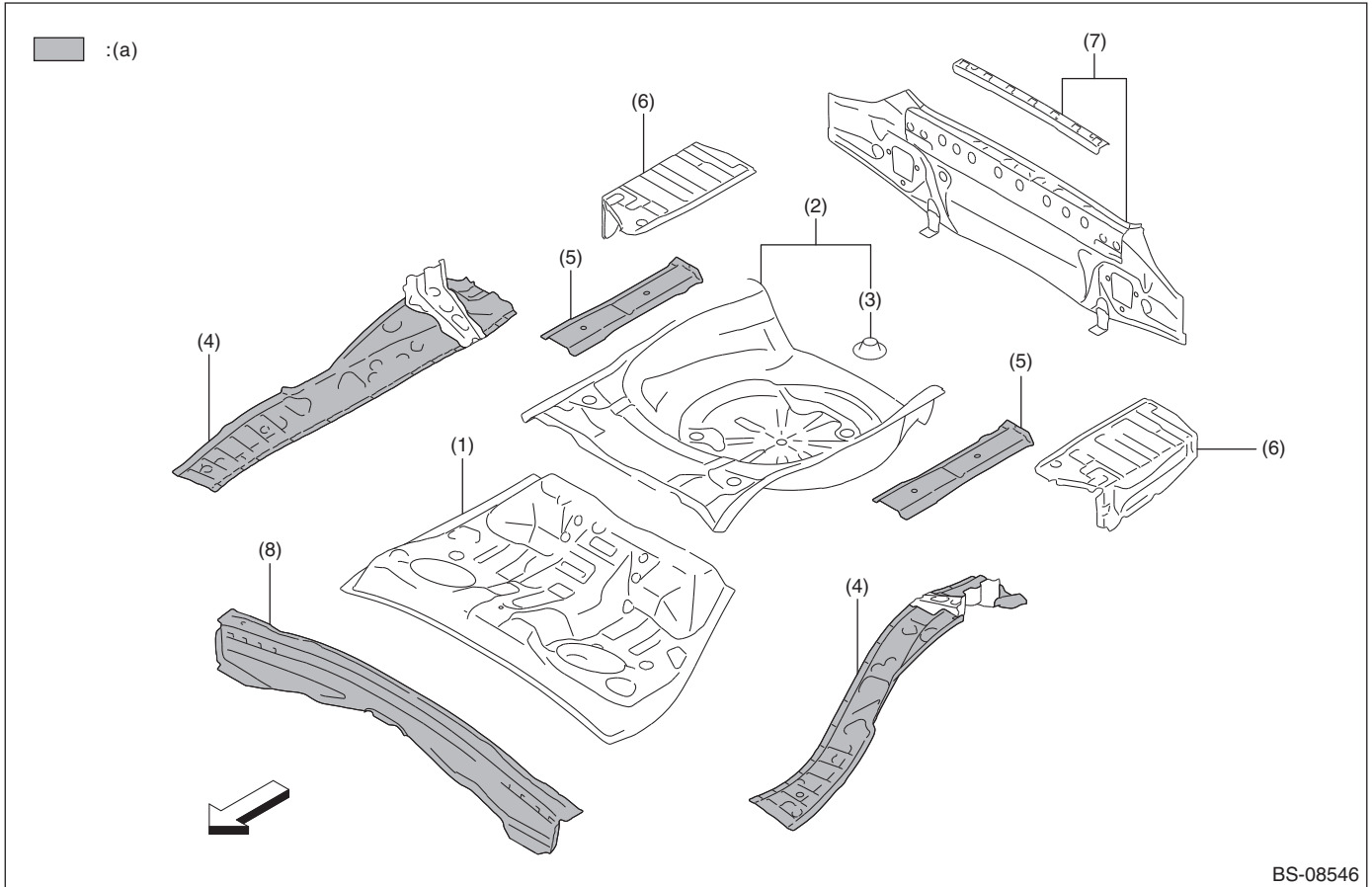
(6) Floor side rear

(7) Rear skirt

(8) Rear floor crossmember A front

Panel Components

• 4 Door



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

(1) Rear floor pan front

(2) Rear floor pan rear

(3) Spare tire bracket

(4) Dumper bracket floor upper

(5) Rear side frame upper rear

(6) Floor side rear

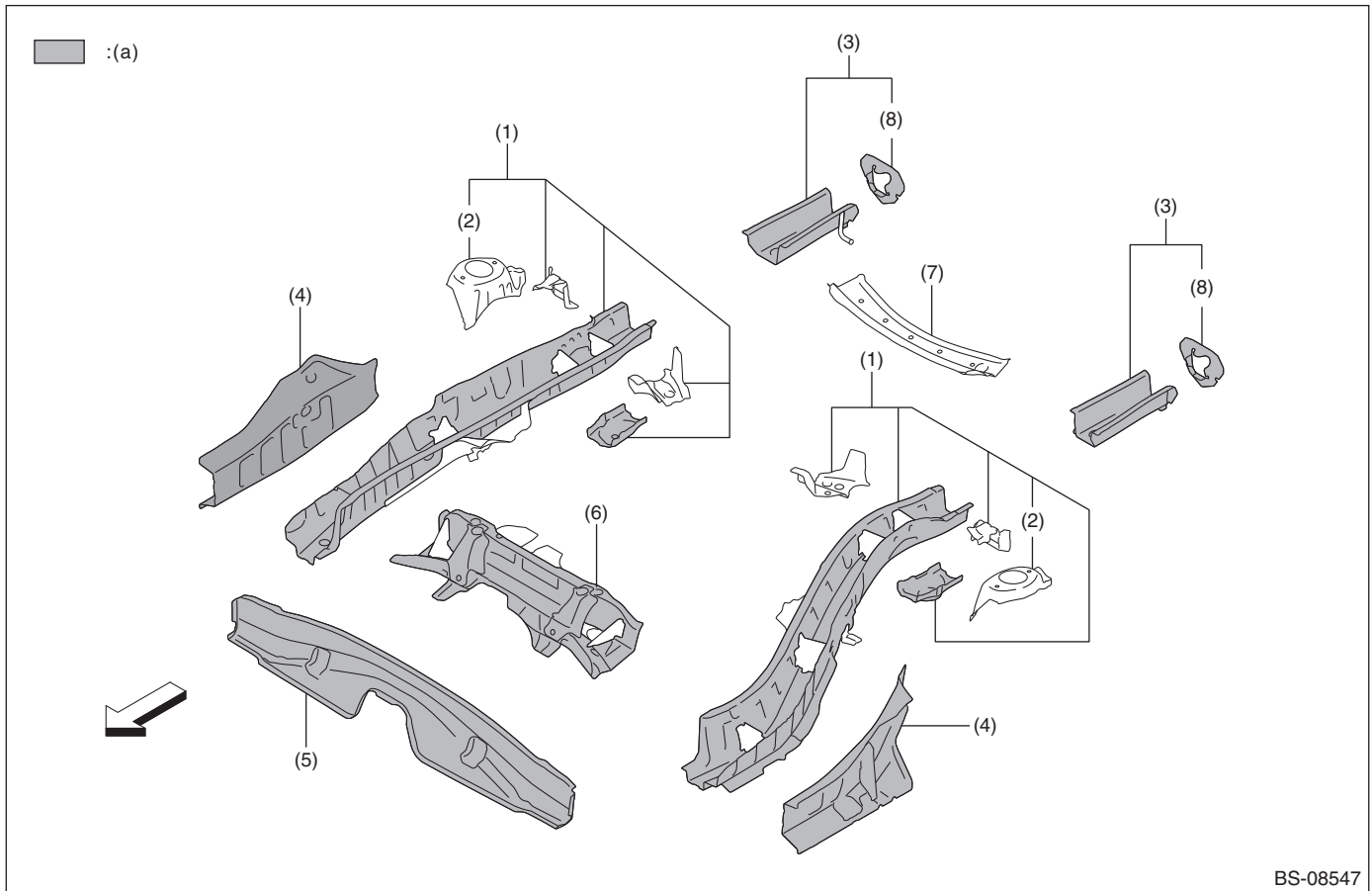
(7) Rear skirt

(8) Rear floor crossmember A front

Panel Components

7. REAR FLOOR SIDE FRAME

• 5 Door



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

(1) Floor side frame rear

(2) Rear suspension bracket

(3) Floor side frame rear lower rear

(4) Side sill inner rear

(5) Rear floor crossmember A rear

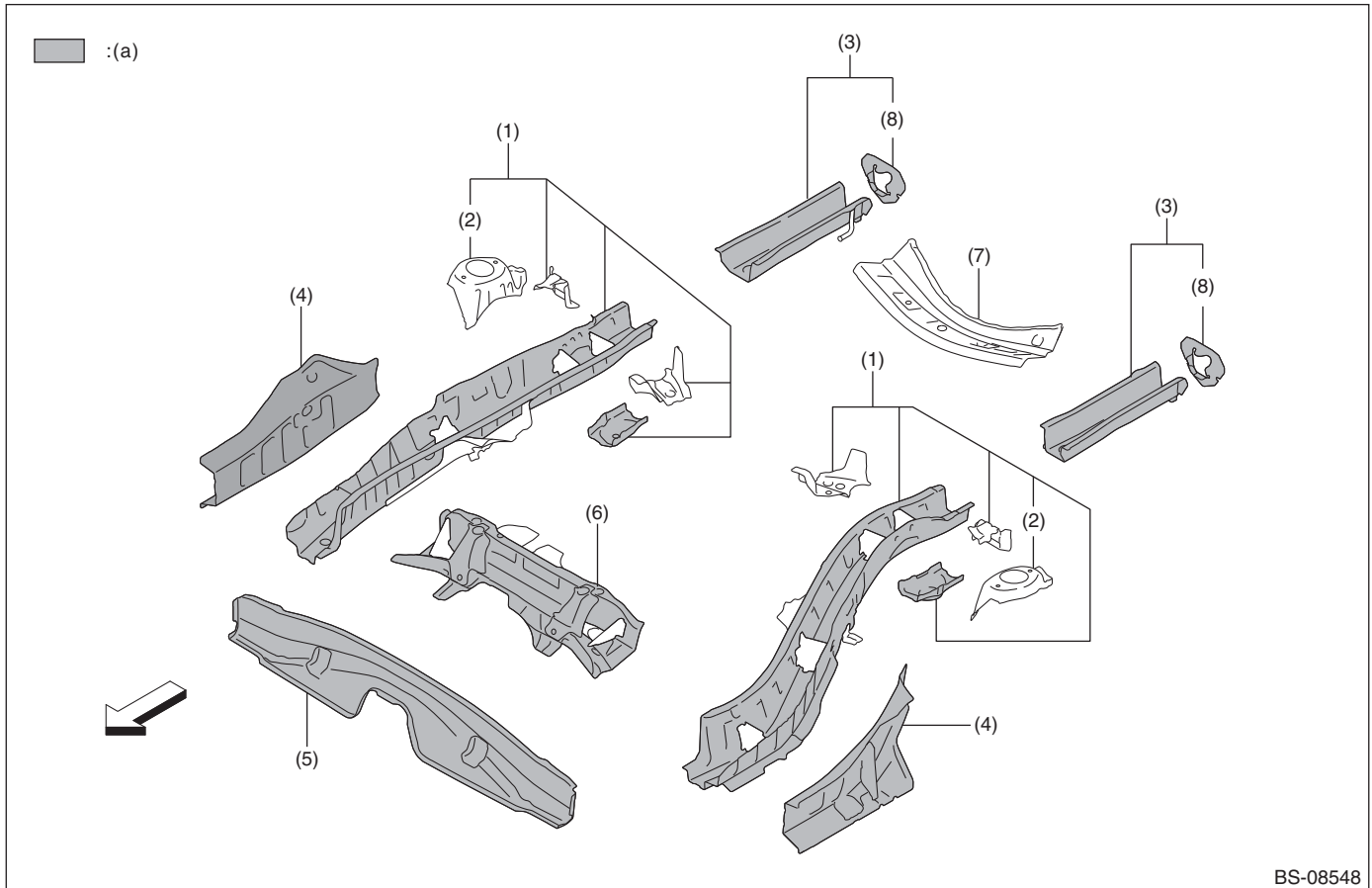
(6) Rear floor crossmember B

(7) Rear floor crossmember C

(8) Rear bumper bracket

Panel Components

• 4 Door



BS-08548

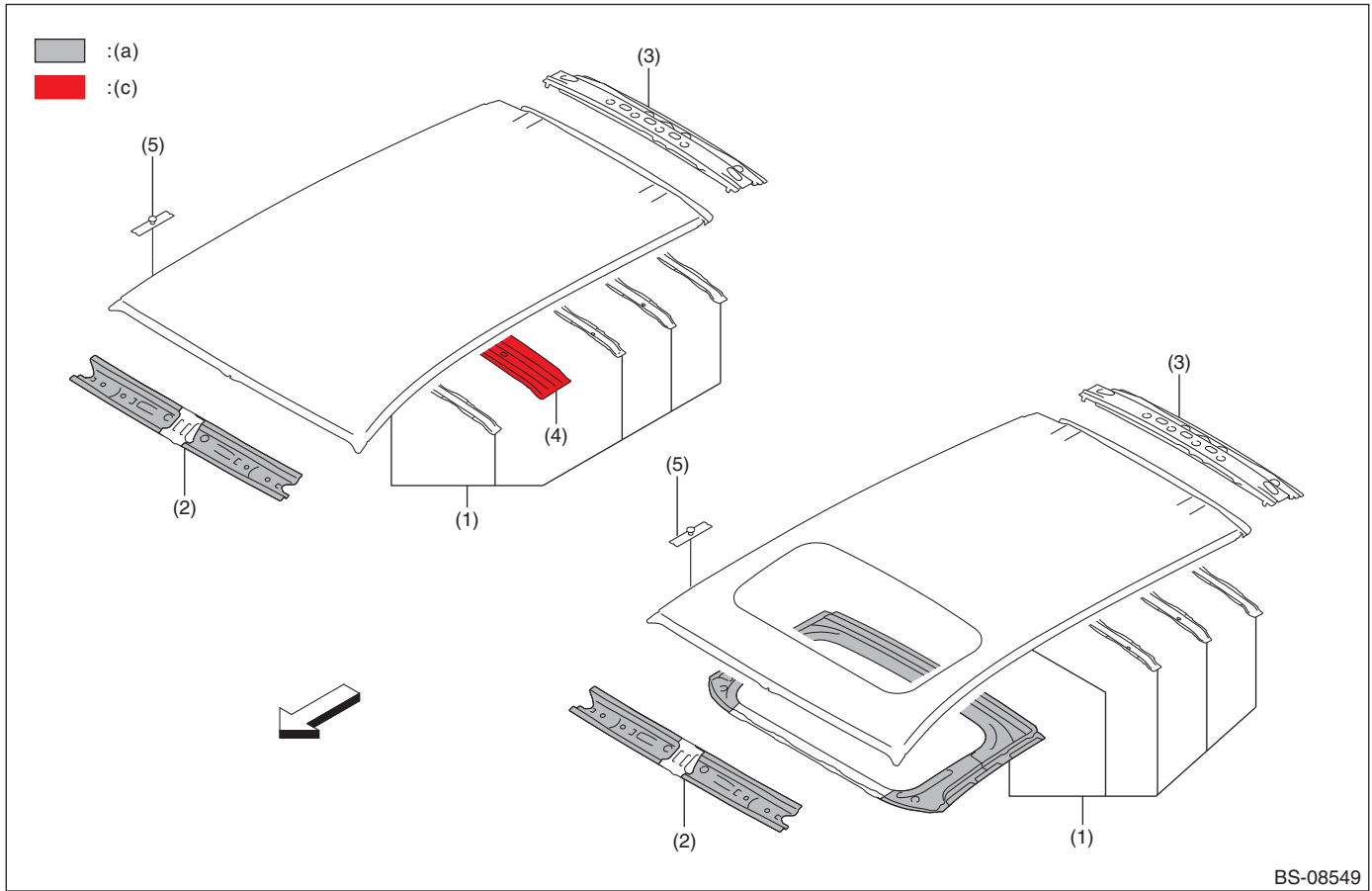
(a) High-strength tensile steel
(440 — 590 MPa class)

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

Panel Components

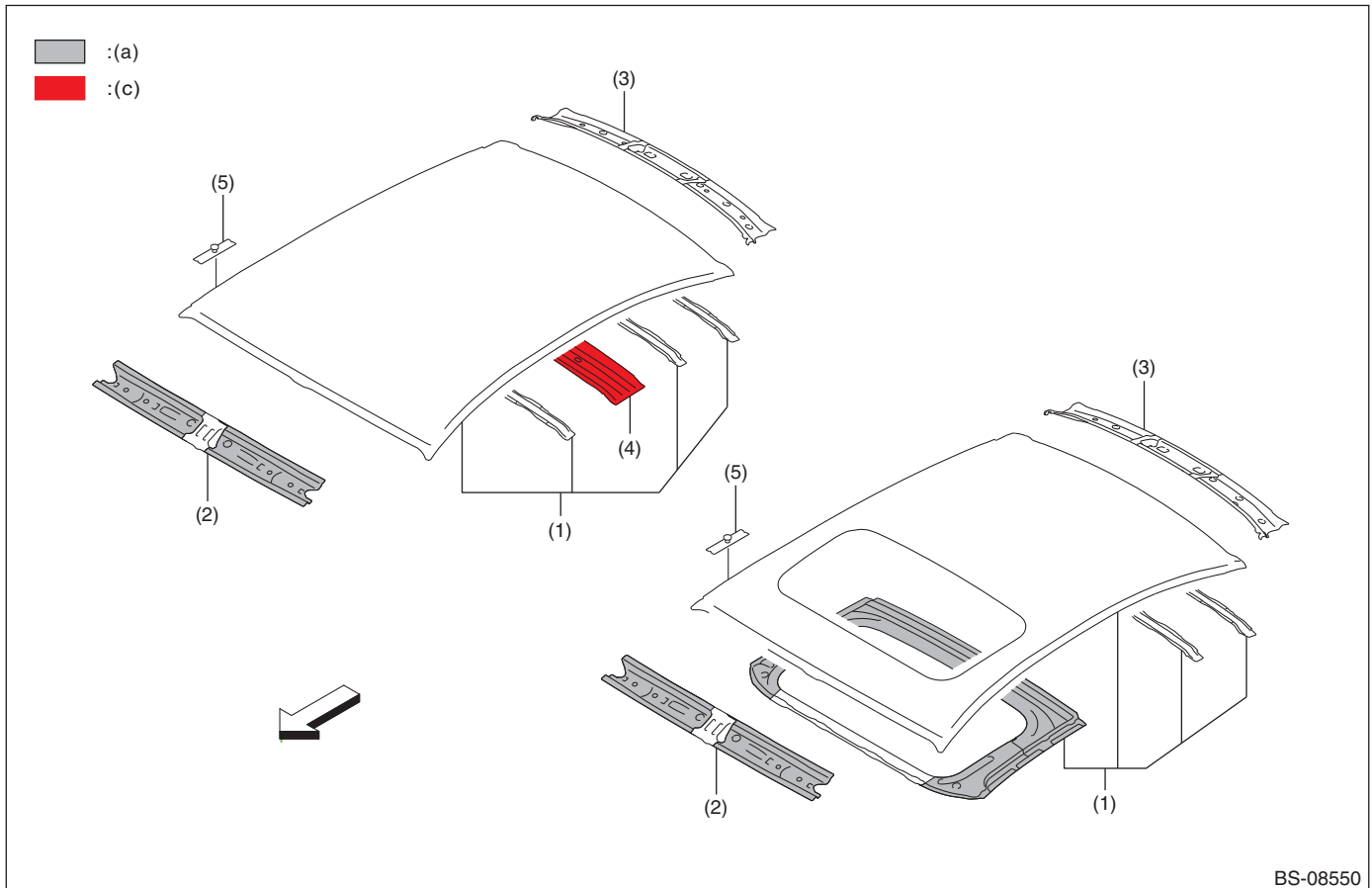
8. ROOF

• 5 Door



Panel Components

• 4 Door



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

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

(1) Roof panel

(3) Rear roof rail

(5) T stud plate

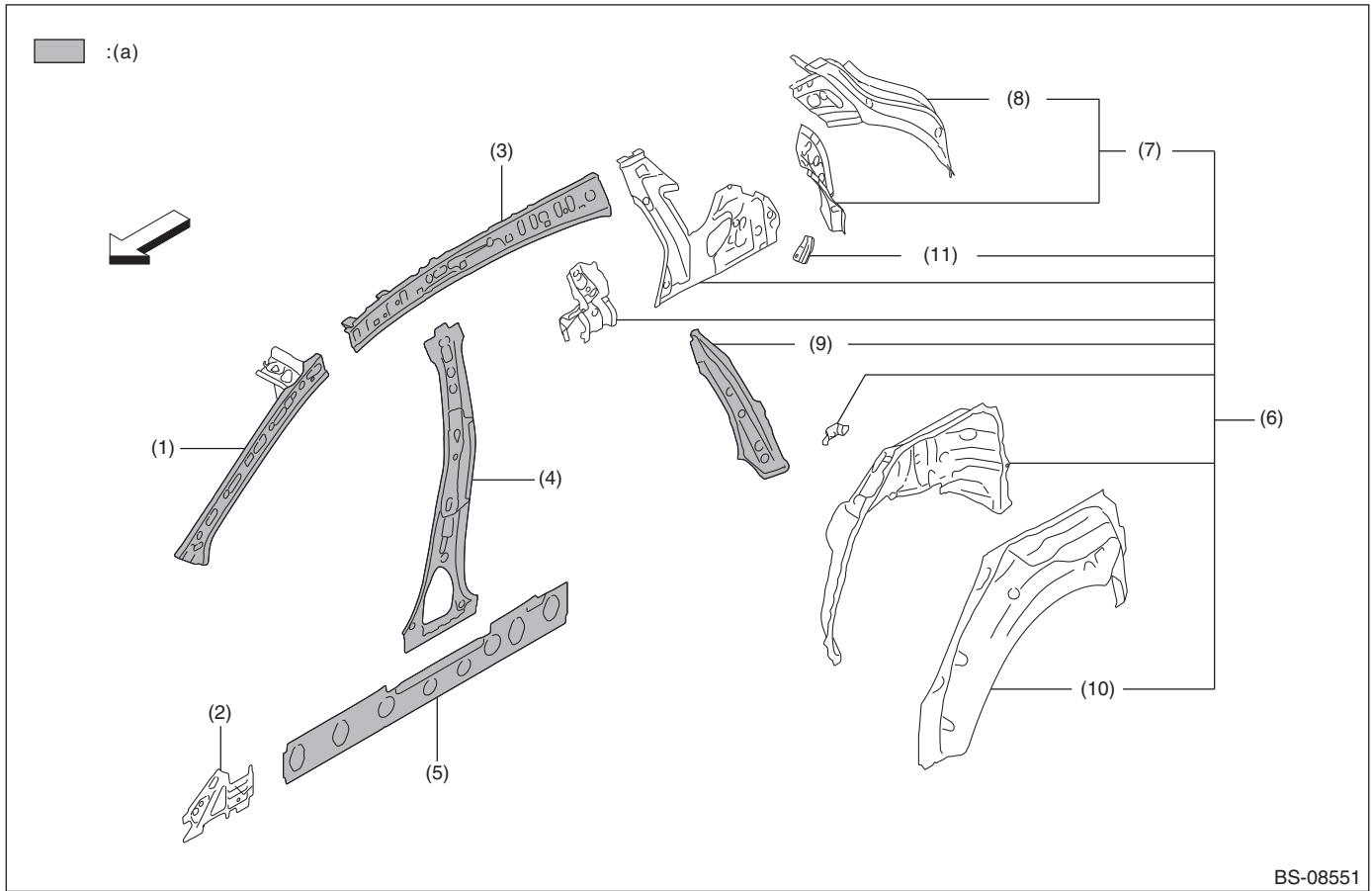
(2) Front roof rail

(4) Roof center brace

Panel Components

9. SIDE PANEL INNER

• 5 Door



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

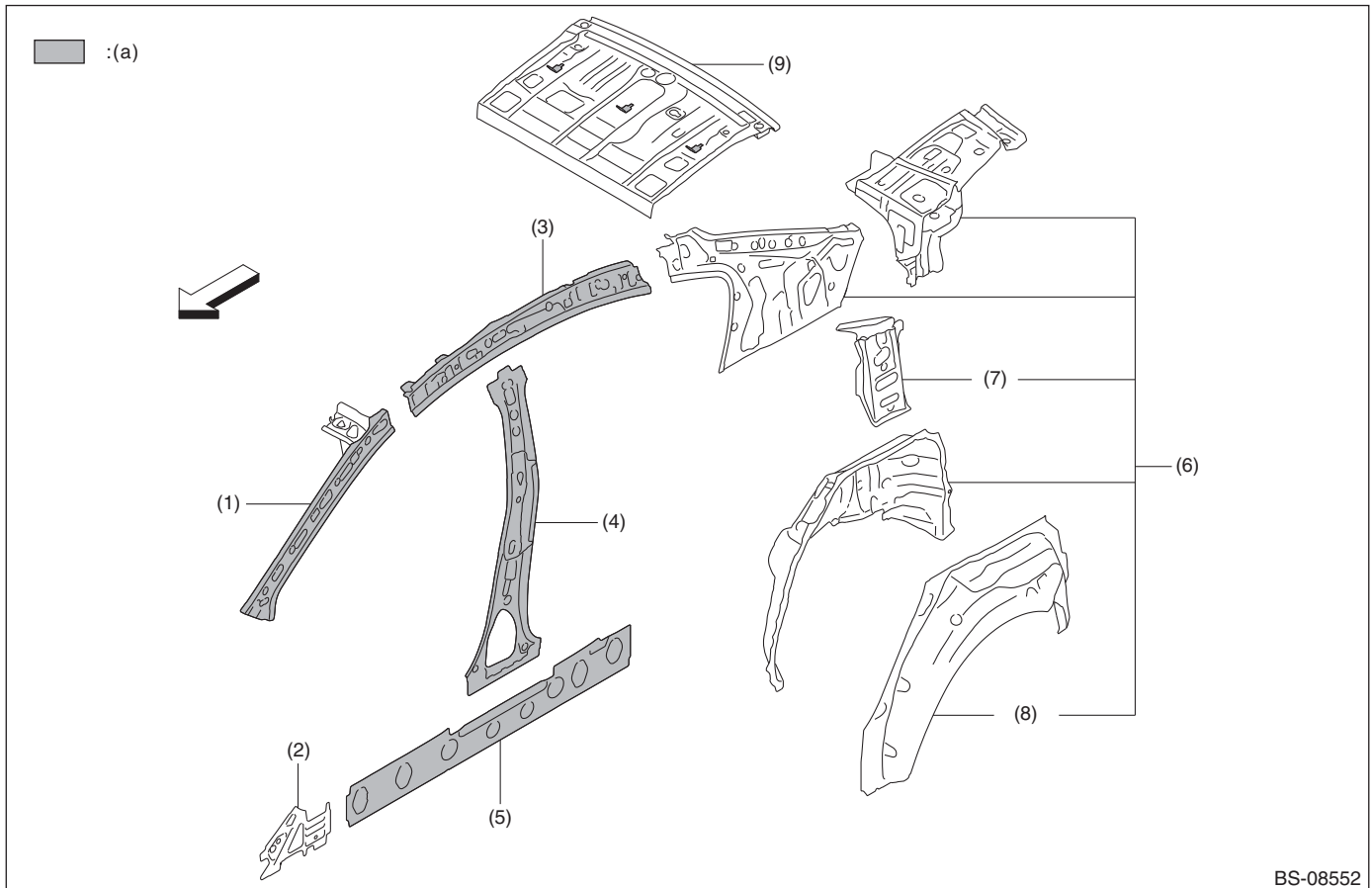
- (1) Pillar front inner upper
- (2) Reinforcement sill side front
- (3) Rail side inner
- (4) Pillar center inner

- (5) Reinforcement sill side rear
- (6) Rear quarter inner
- (7) Reinforcement compl. D pillar
- (8) Reinforcement D pillar

- (9) Reinforcement C pillar outer
- (10) Arch rear inner
- (11) Bracket retractor

Panel Components

• 4 Door



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

- (1) Pillar front inner upper
- (2) Reinforcement sill side front
- (3) Rail side inner

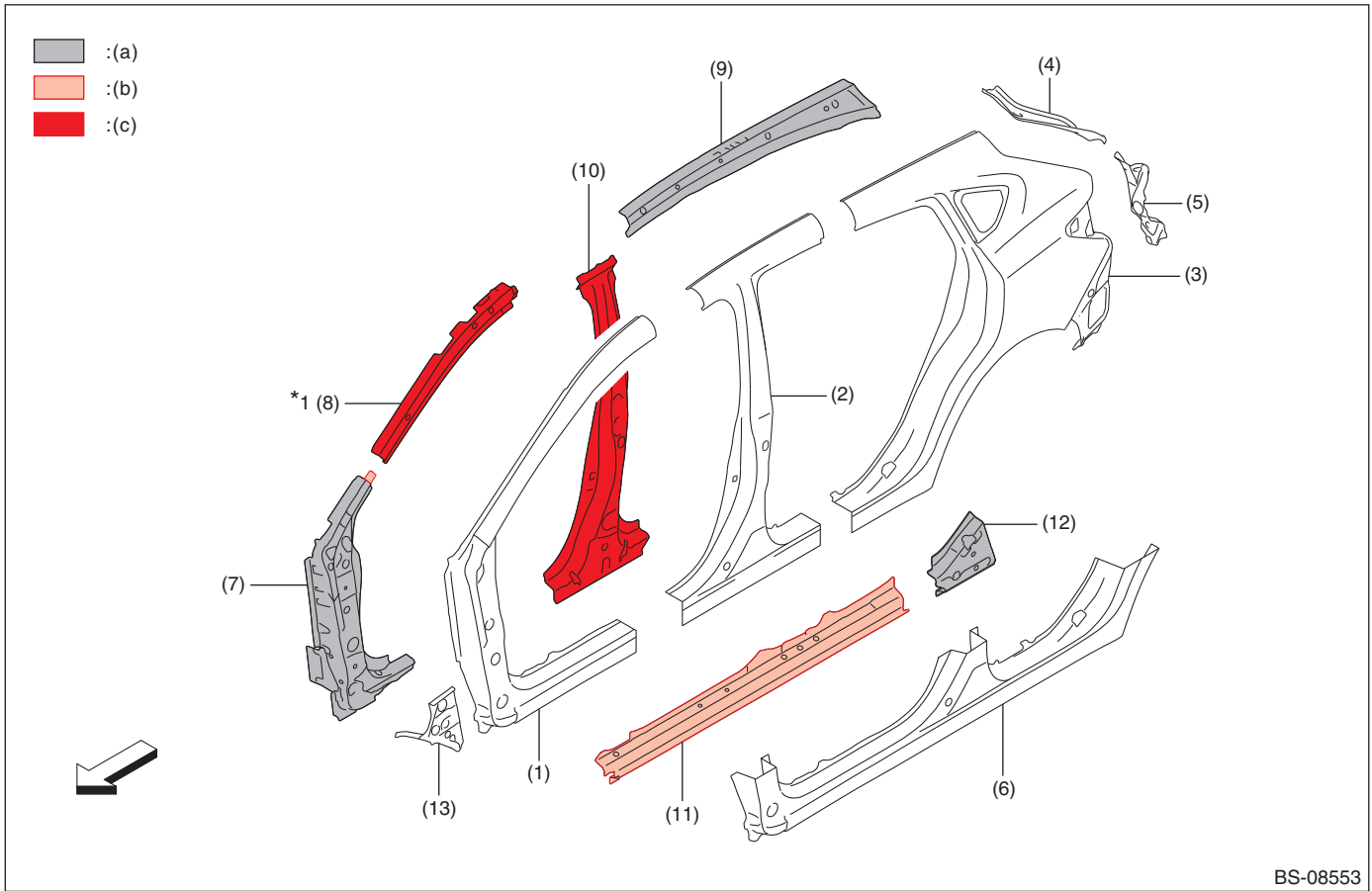
- (4) Pillar center inner
- (5) Reinforcement sill side rear
- (6) Rear quarter inner

- (7) Reinforcement rear pillar outer
- (8) Arch rear inner
- (9) Rear panel

Panel Components

10.SIDE PANEL OUTER

• 5 Door



BS-08553

(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: High-strength tensile steel (440 — 590 Mpa class) is used at RH

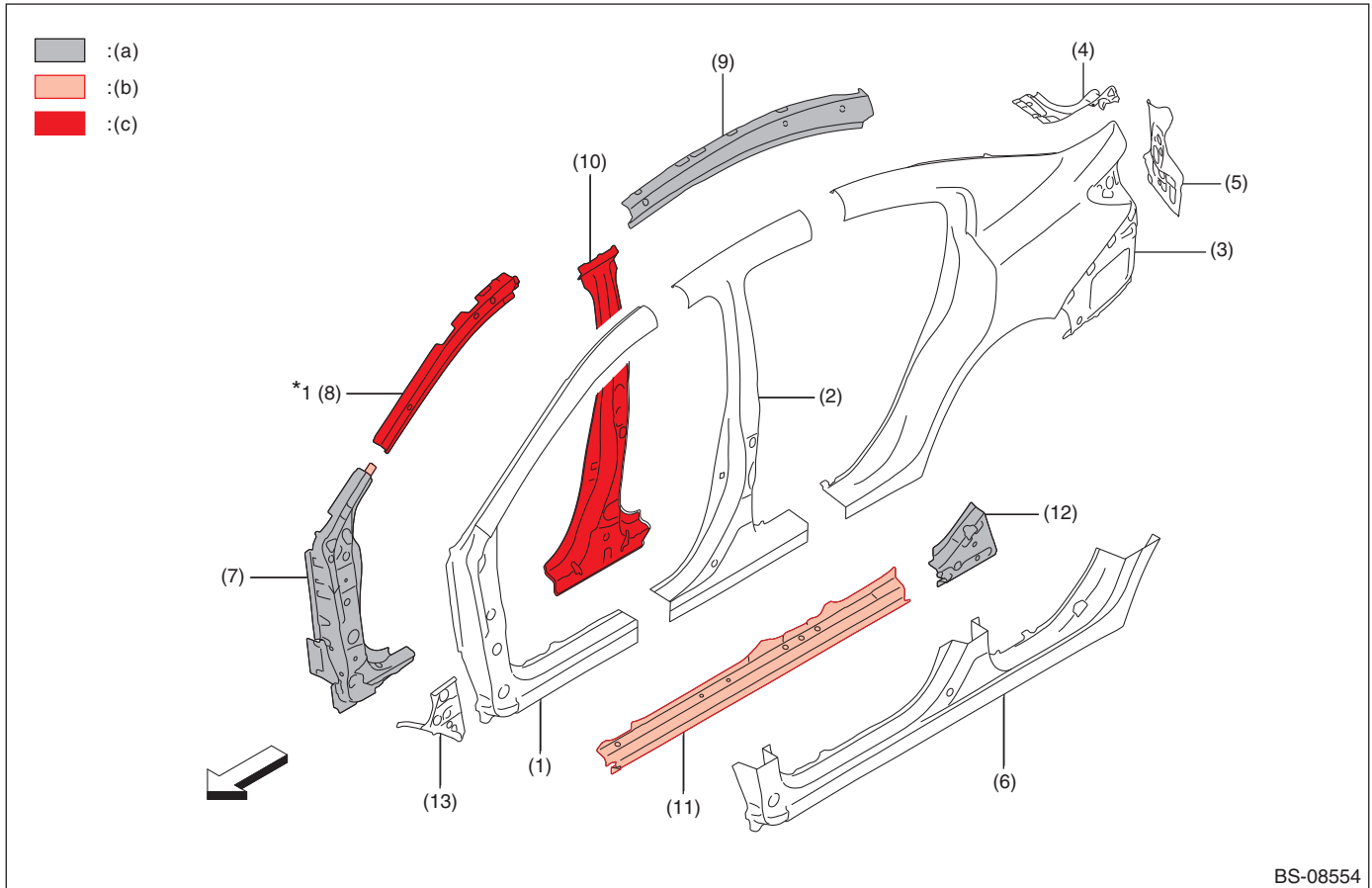
(1) Front pillar outer
(2) Center pillar outer
(3) Rear quarter outer
(4) Extension D pillar
(5) Rear quarter end

(6) Side sill outer
(7) Reinforcement pillar front outer
(8) Reinforcement rail side outer front
(9) Reinforcement rail side outer rear

(10) Reinforcement pillar center outer
(11) Reinforcement sill side outer front
(12) Reinforcement sill side outer rear
(13) Gusset frame side upper

Panel Components

• 4 Door



BS-08554

(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: High-strength tensile steel (440 — 590 Mpa class) is used at RH

(1) Front pillar outer
(2) Center pillar outer
(3) Rear quarter outer
(4) Rear pillar patch
(5) Rear quarter end

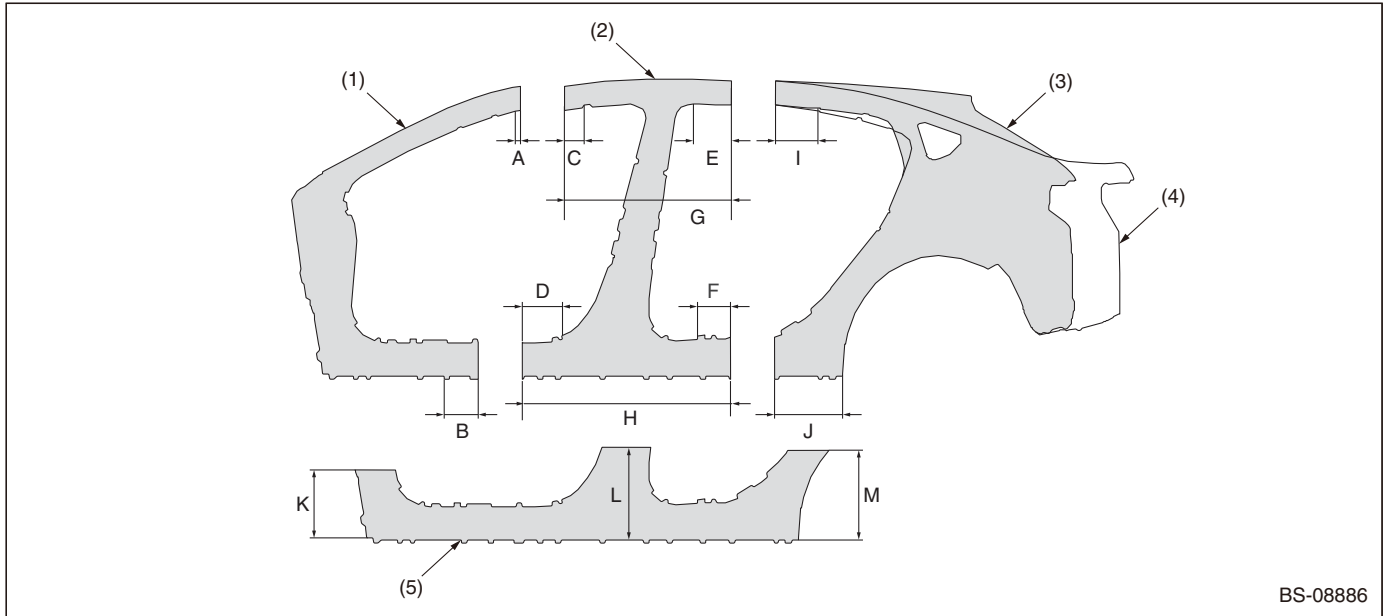
(6) Side sill outer
(7) Reinforcement pillar front outer
(8) Reinforcement rail side outer front
(9) Reinforcement rail side outer rear

(10) Reinforcement pillar center outer
(11) Reinforcement sill side outer front
(12) Reinforcement sill side outer rear
(13) Gusset frame side upper

Panel Components

B: REPAIR PART SIZE

1. SIDE PANEL OUTER

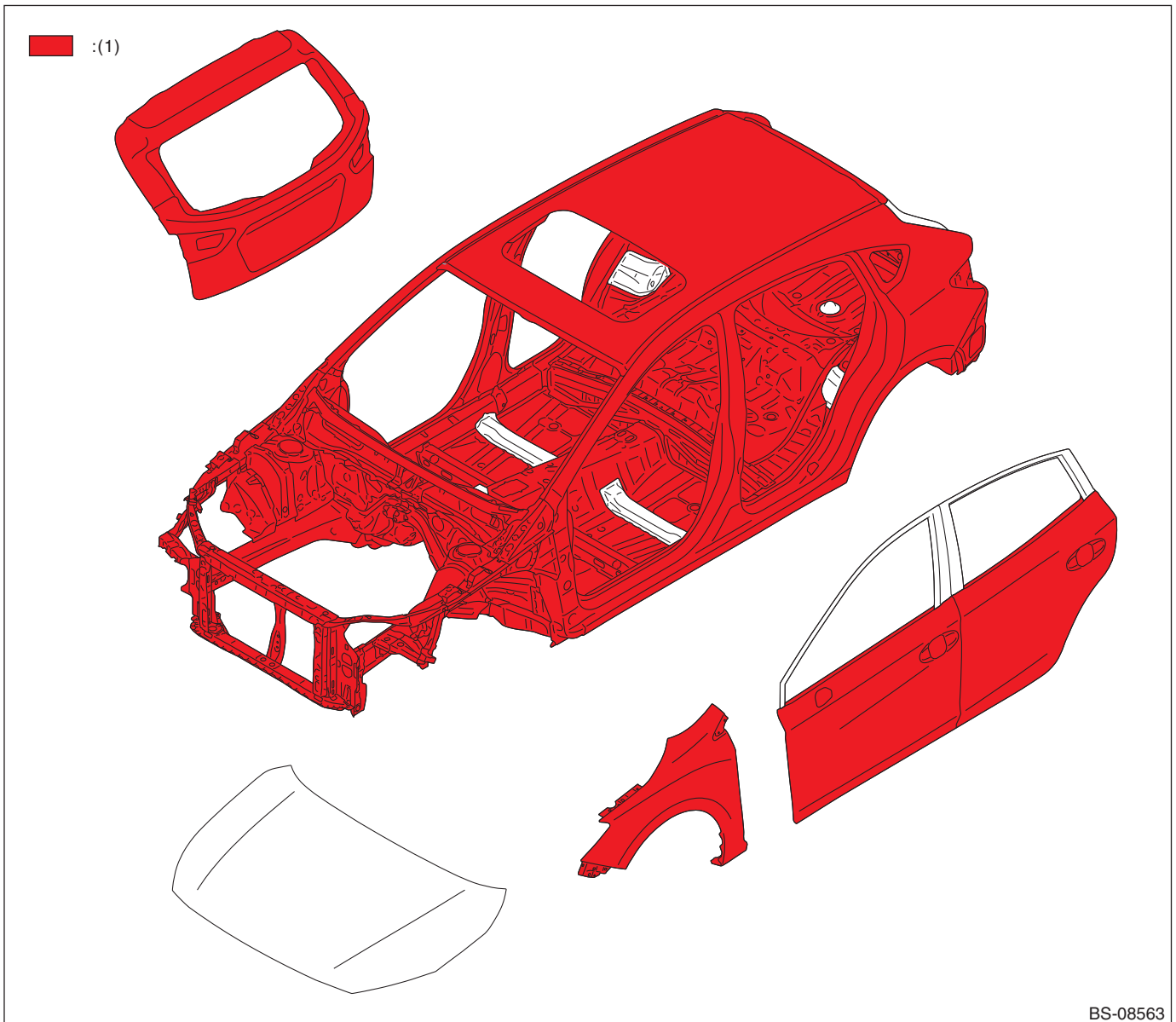


No	Part name	Measuring point	Datum dimension mm (In)
(1)	Front Pillar Outer	A	24 (0.94)
		B	146 (5.75)
(2)	Center Pillar Outer	C	81 (3.19)
		D	168 (6.61)
		E	159 (6.26)
		F	140 (5.51)
		G	705 (27.76)
		H	880 (34.65)
		I	179 (7.05)
(3)	Rear quarter outer (5 Door)	J	289 (11.38)
		I	184 (7.24)
(4)	Rear quarter outer (4 Door)	J	289 (11.38)
		K	292 (11.50)
(5)	Side sill outer	L	392 (15.43)
		M	379 (14.92)

4. Galvanized Sheet Metal

A: SPECIFICATION

• COMMON PARTS FOR 5 DOOR AND 4 DOOR



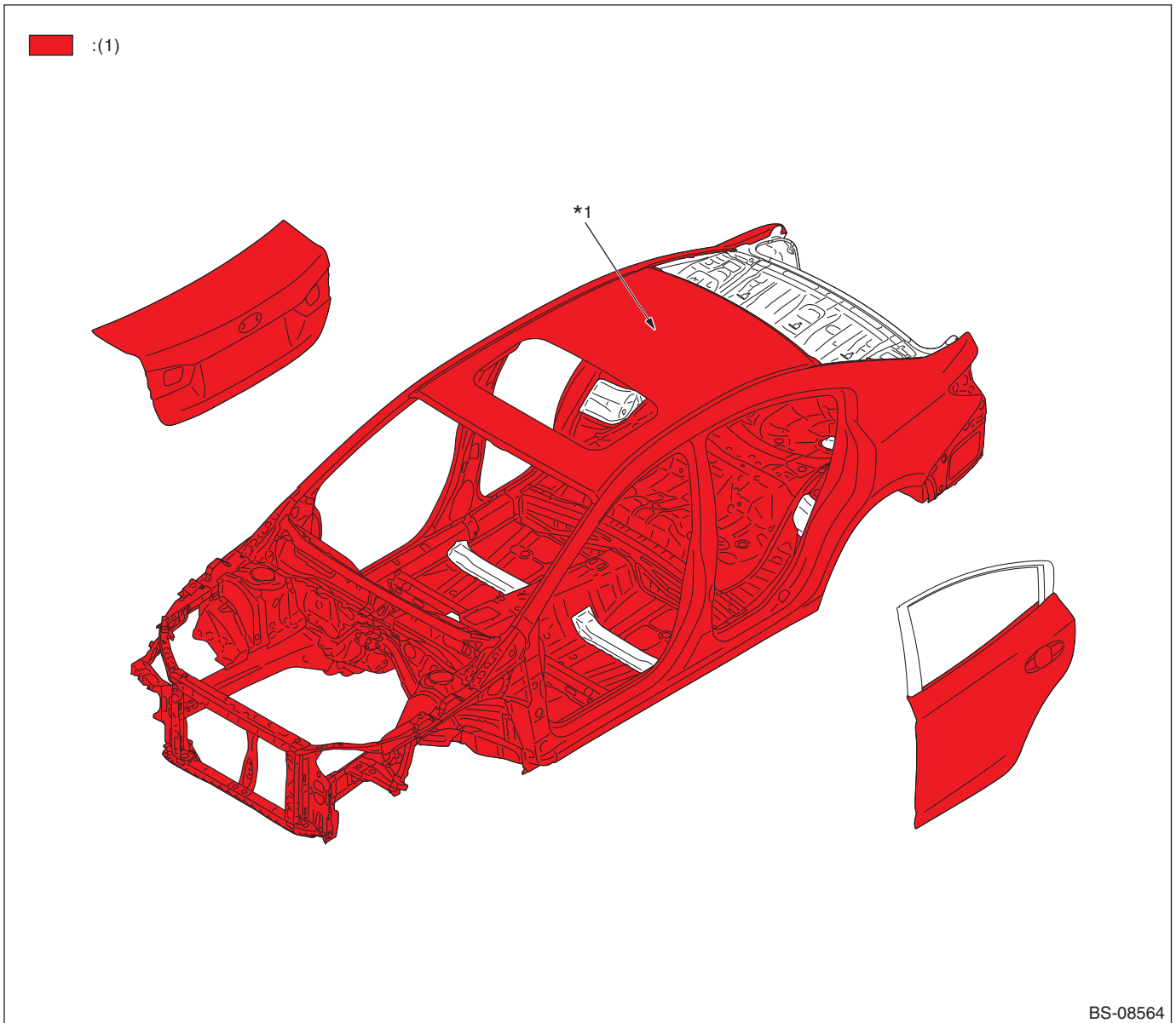
BS-08563

- (1) Galvanized sheet metal
(both sides)

The fuel flap consists of galvanized sheet metal.

Galvanized Sheet Metal

• SPECIAL 4 DOOR PARTS



- (1) Galvanized sheet metal
(both sides)

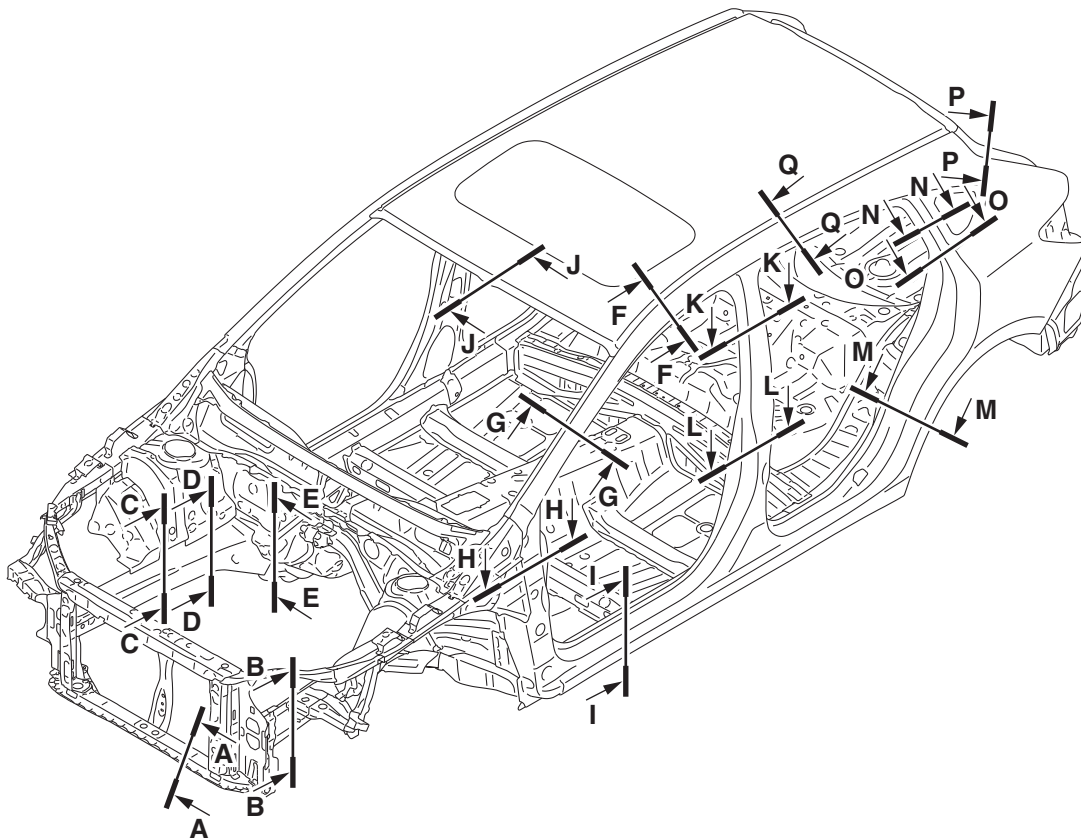
The fuel flap consists of galvanized sheet metal.

*1: The roof panel for the model without sunroof is not galvanized.

5. Body Construction

A: SPECIFICATION

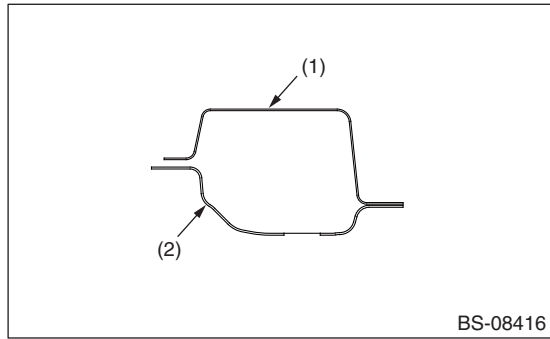
• COMMON PARTS FOR 5 DOOR AND 4 DOOR



BS-08414

Body Construction

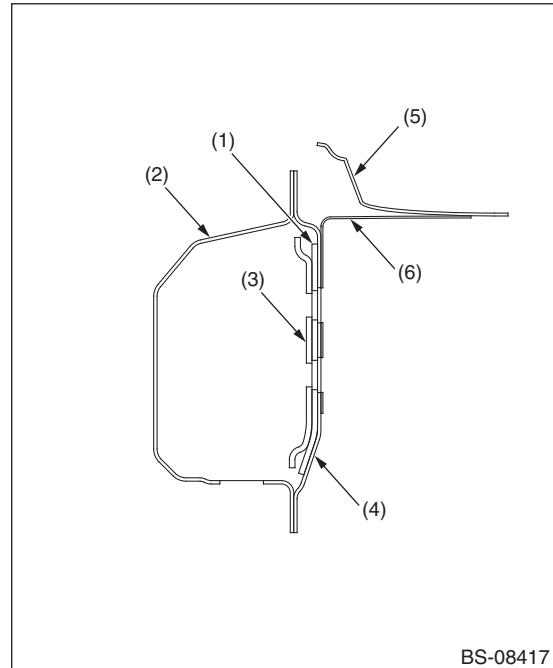
Cross section A — A



BS-08416

- (1) Frame lower A
- (2) Frame lower B

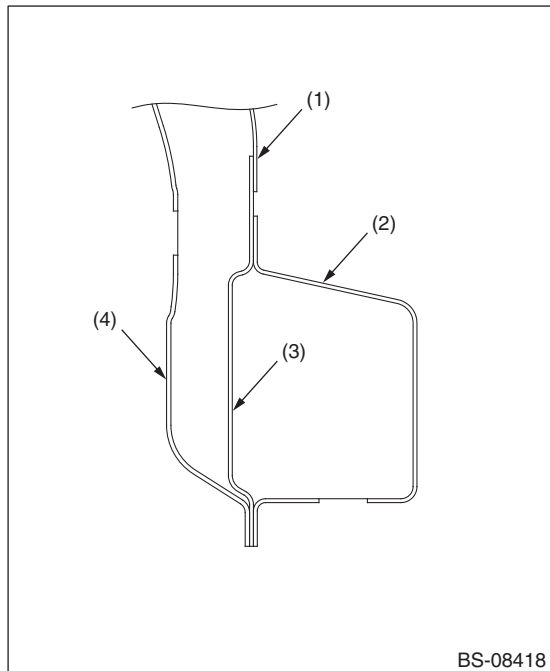
Cross section B — B



BS-08417

- (1) Plate closing plate FF
- (2) Frame side FF
- (3) Separator FF A
- (4) Closing plate FF
- (5) Battery gusset
- (6) Battery gusset lower

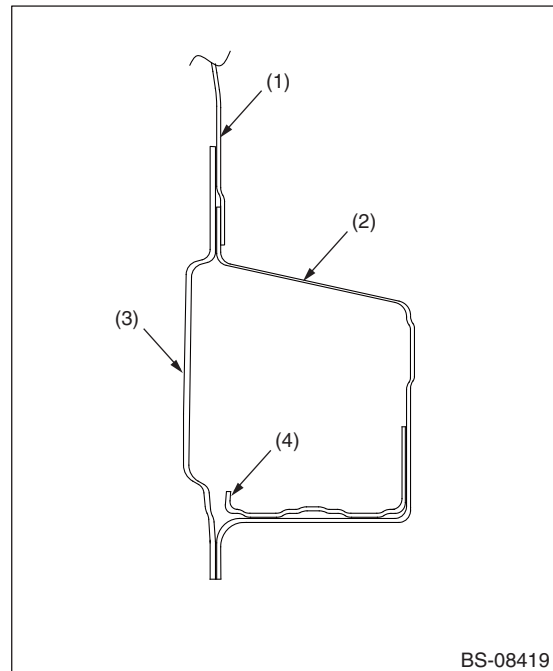
Cross section C — C



BS-08418

- (1) Reinforcement front suspension upper
- (2) Frame side FF
- (3) Closing plate FF
- (4) Reinforcement front suspension lower

Cross section D — D

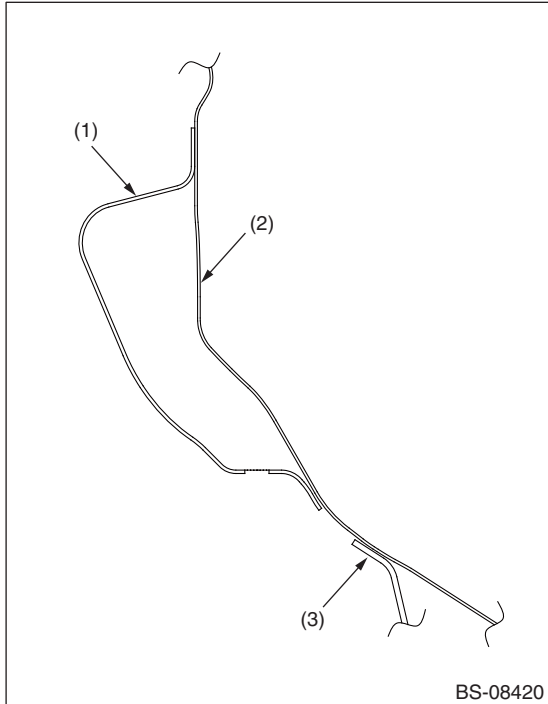


BS-08419

- (1) Bracket front suspension lower
- (2) Frame side FF
- (3) Closing plate FF
- (4) Reinforcement FF rear

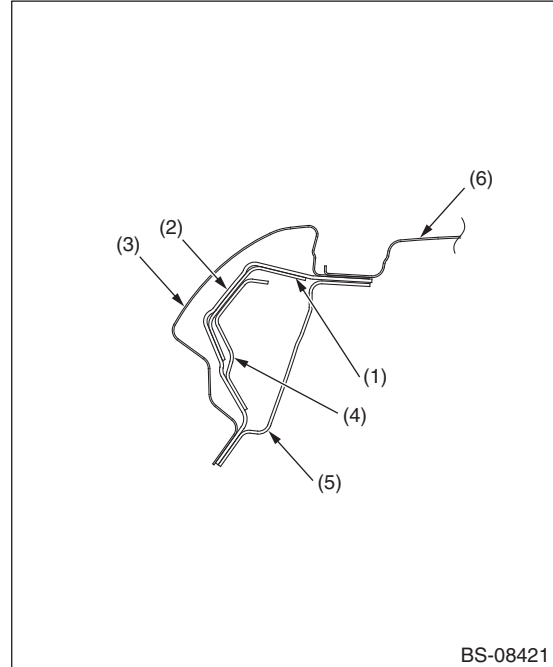
Body Construction

Cross section E — E



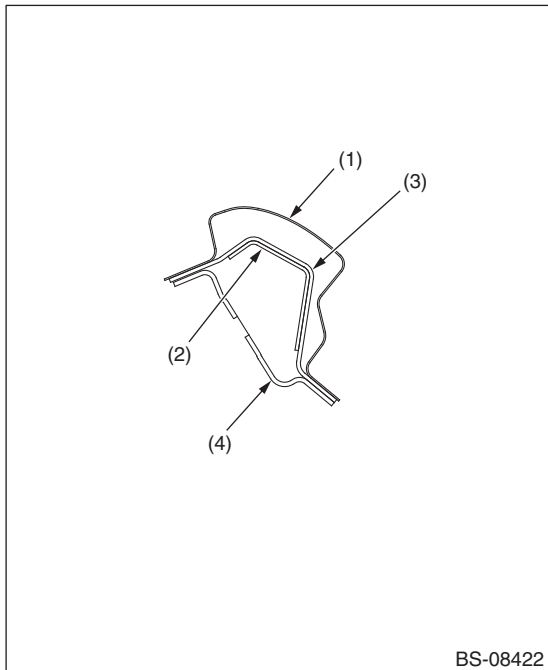
- (1) Crossmember toe board center
- (2) Toe board
- (3) Frame tunnel front

Cross section F — F



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

Cross section G — G

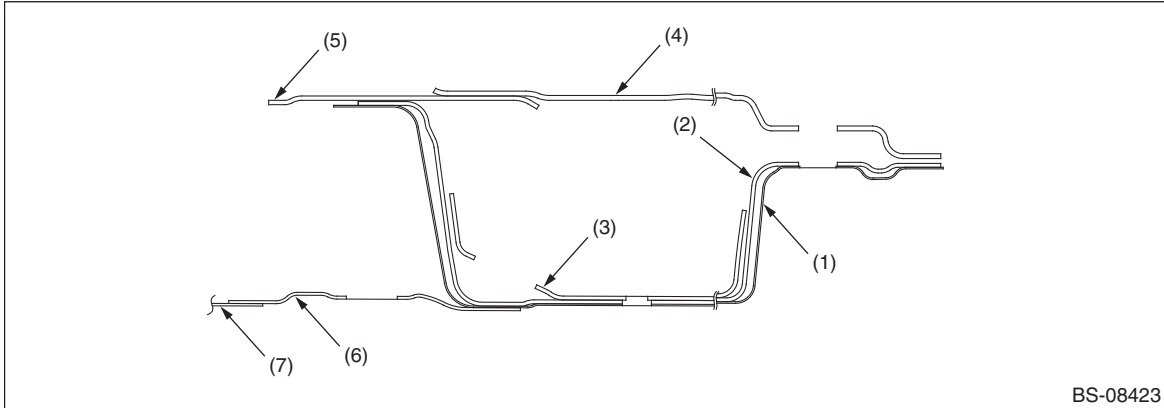


- (1) Panel side outer
- (2) Reinforcement rail side outer front A
- (3) Reinforcement rail side outer front
- (4) Pillar front inner upper

SUBARU.

Body Construction

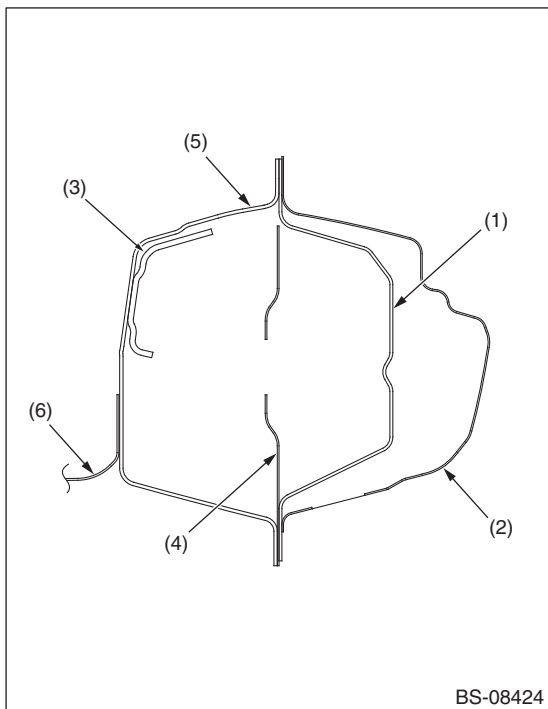
Cross section H — H



BS-08423

- (1) Panel side outer
- (2) Reinforcement pillar front outer
- (3) Reinforcement pillar front center
- (4) Pillar front inner lower
- (5) Pillar front inner center
- (6) Gusset frame side
- (7) Frame side upper

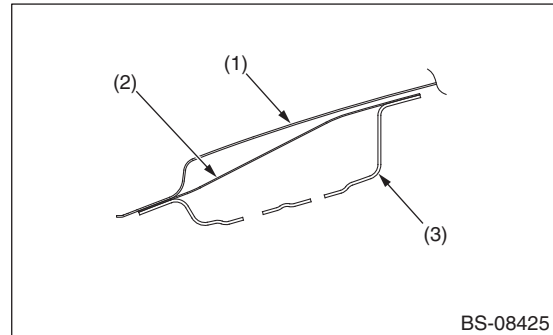
Cross section I — I



BS-08424

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

Cross section J — J

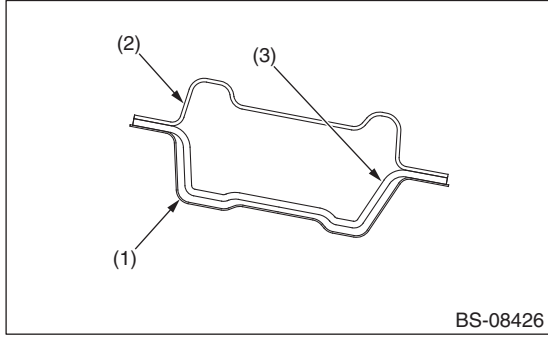


BS-08425

- (1) Roof panel
- (2) Rail front upper
- (3) Rail front lower

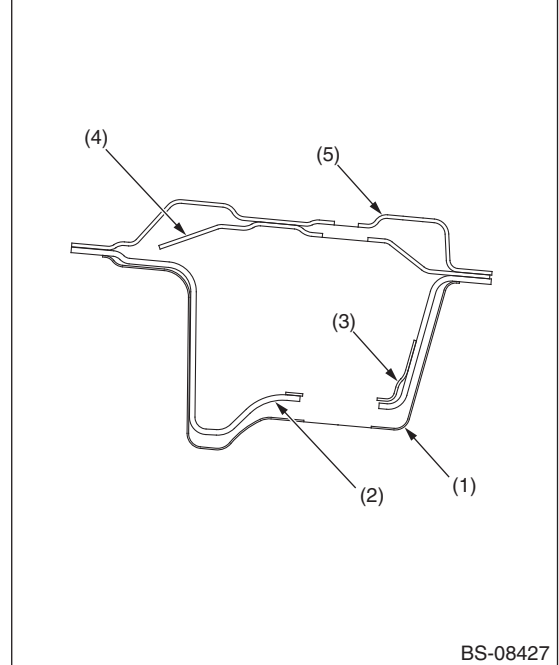
Body Construction

Cross section K—K



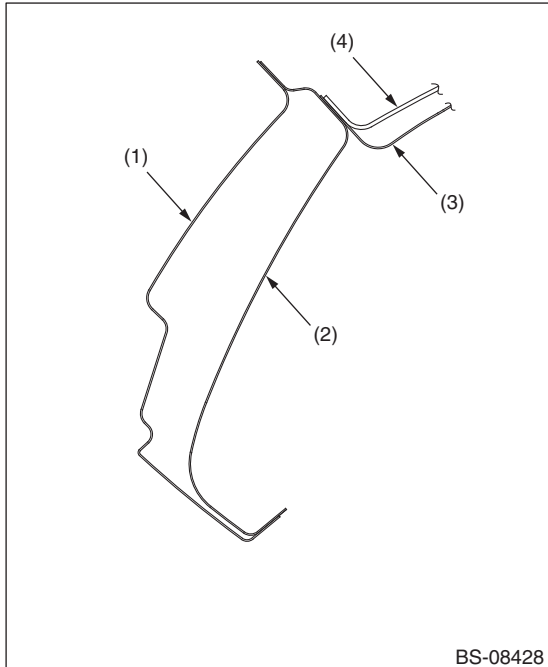
- (1) Panel side outer
- (2) Pillar center inner
- (3) Reinforcement pillar center outer

Cross section L — L



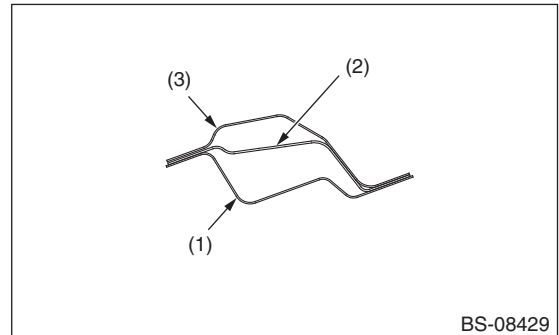
- (1) Panel side outer
- (2) Reinforcement pillar center outer
- (3) Reinforcement pillar center outer upper
- (4) Doubler pillar center
- (5) Pillar center inner

Cross section M —M



- (1) Panel side outer
- (2) Arch rear inner
- (3) Wheel apron rear
- (4) Bracket stay rear floor

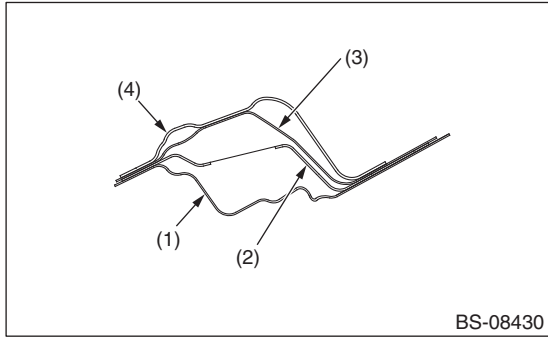
Cross section N — N



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

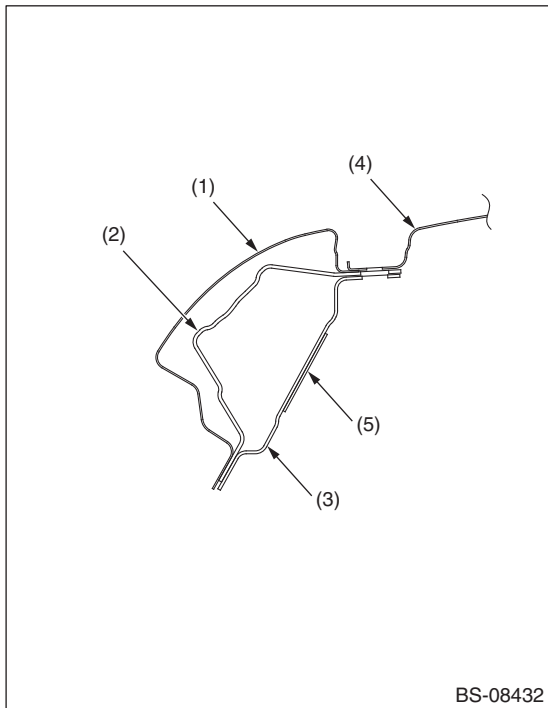
Body Construction

Cross section O — O



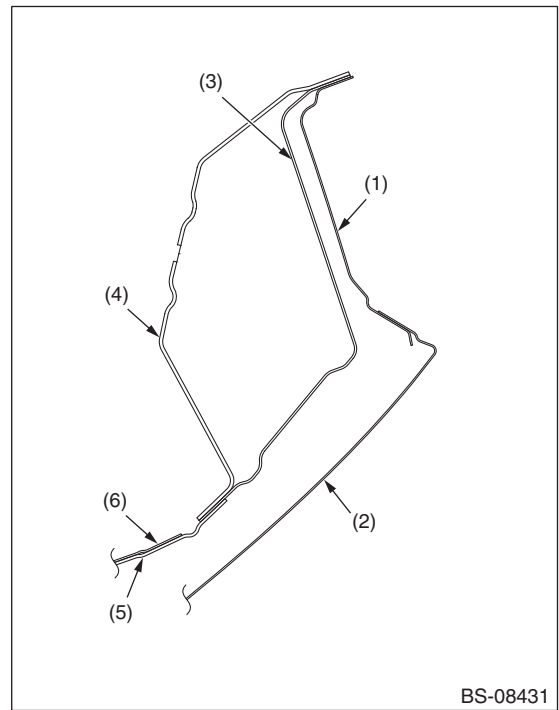
- (1) Panel side outer
- (2) Reinforcement C pillar outer
- (3) Quarter panel rear inner
- (4) Reinforcement rear apron

Cross section Q — Q



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

Cross section P — P

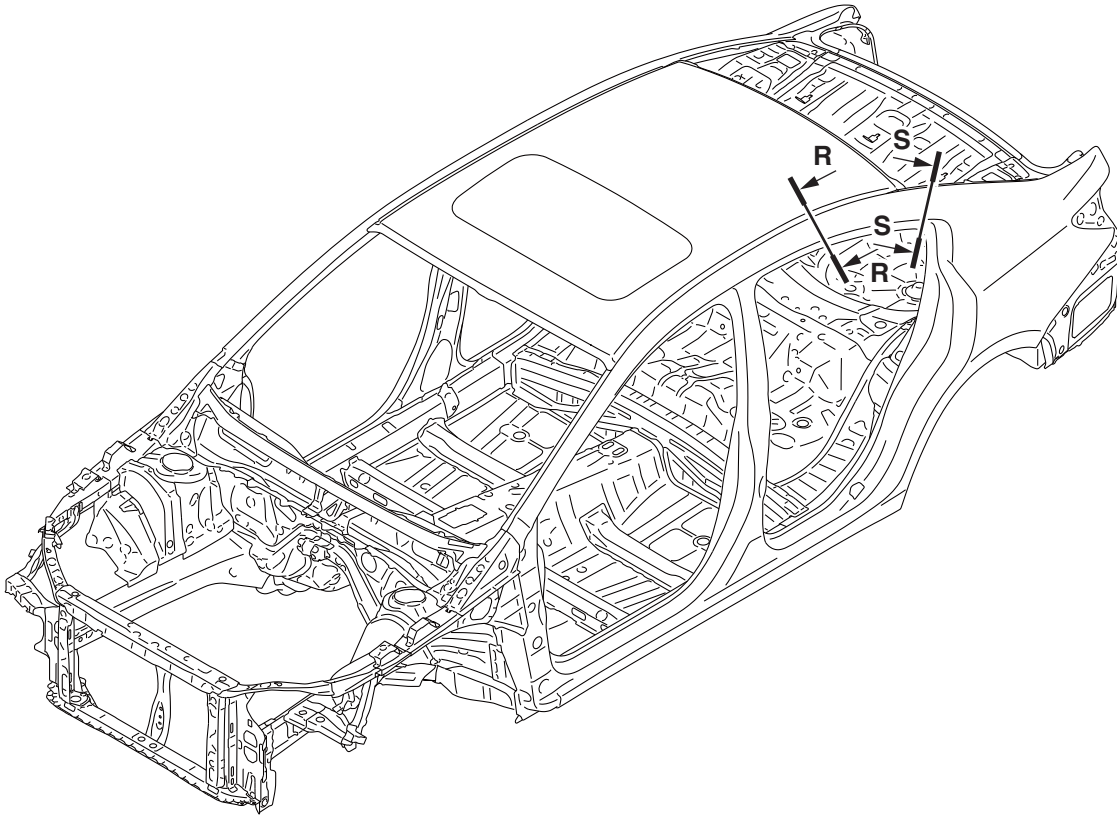


- (1) Extension D pillar
- (2) Panel side outer
- (3) Reinforcement D pillar
- (4) Pillar D inner upper
- (5) Plate retractor
- (6) Quarter panel rear inner

SUBARU.

Body Construction

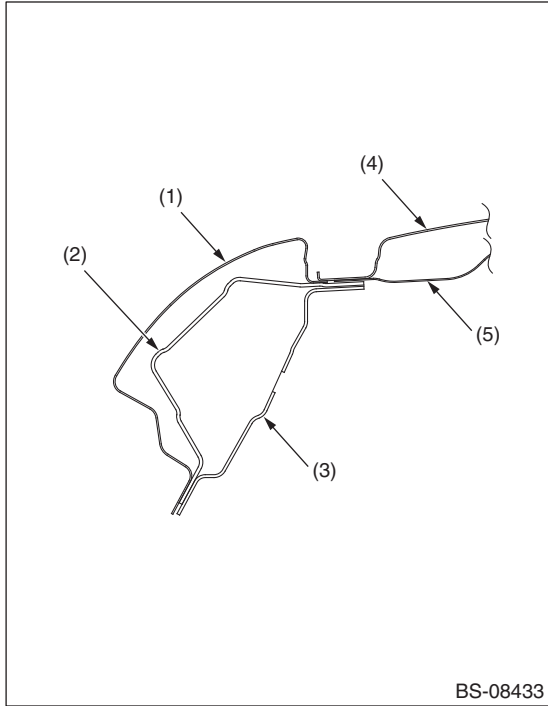
- SPECIAL 4 DOOR PARTS



BS-08415

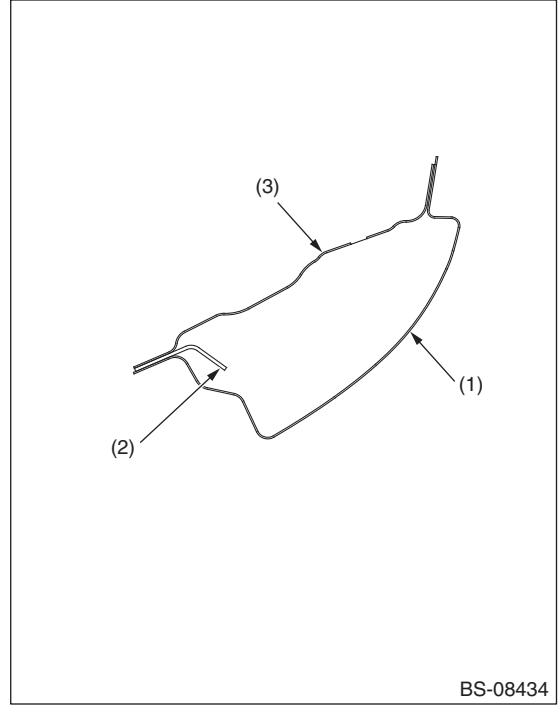
Body Construction

Cross section R — R



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

Cross section S — S

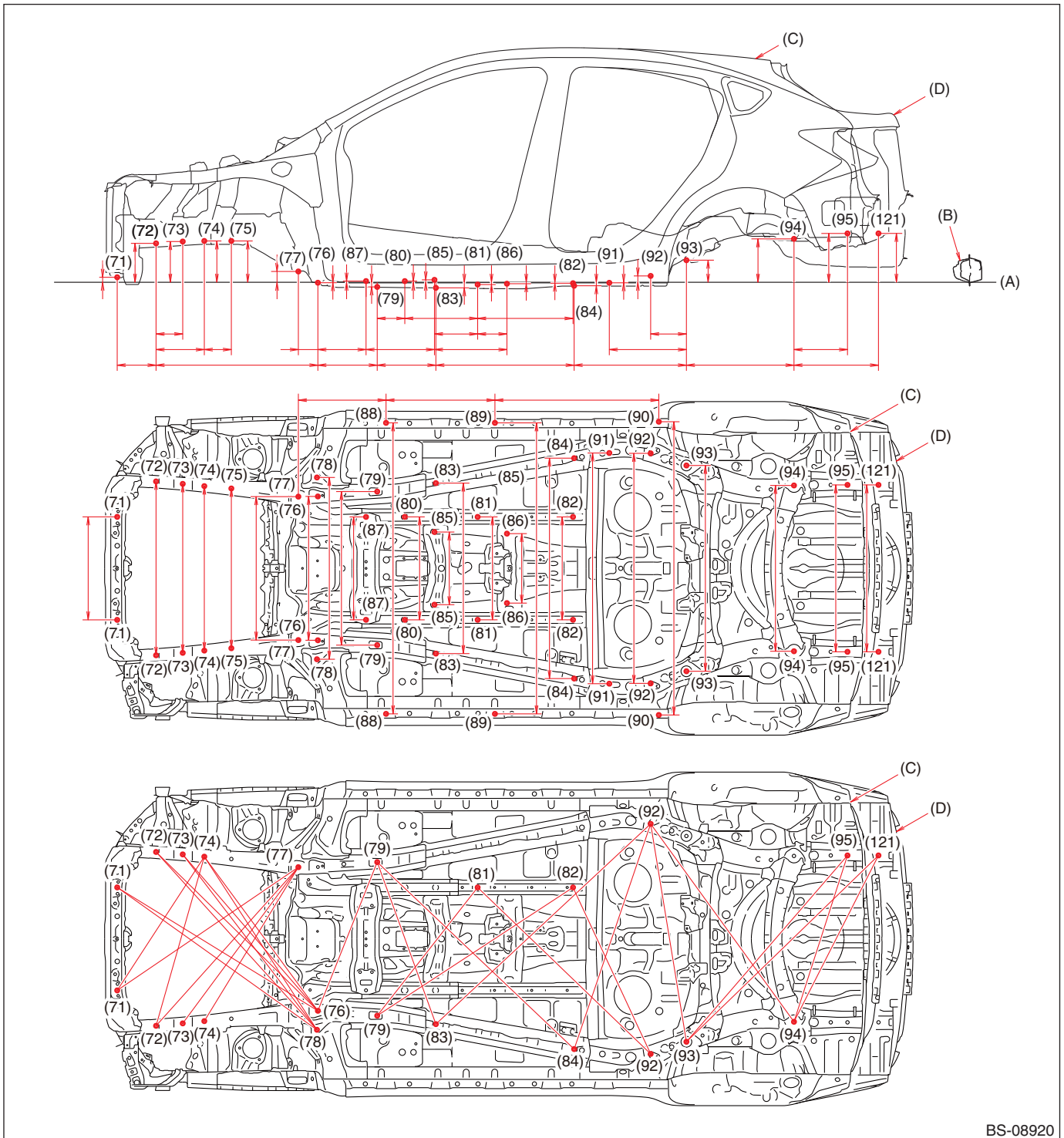


- (1) Panel side outer
- (2) Reinforcement rail side outer rear
- (3) Pillar rear inner

6. Body Reference Points

A: DIMENSIONS

1. LOWER SURFACE



- 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
(B) Side sill outer panel

(C) 5 Door

(D) 4 Door

- | | | |
|---|--|---|
| (71) Under cover front mounting hole (symmetrical) | (80) Under cover rear mounting hole (symmetrical) | (89) Side spoiler mounting hole (symmetrical) |
| (72) Gauge hole (symmetrical) | (81) Under cover rear fixing hole (symmetrical) | (90) Side spoiler mounting hole (symmetrical) |
| (73) Radio ground mounting hole (symmetrical) | (82) Protector tank mounting hole (symmetrical) | (91) Harness bracket mounting holes (symmetric) |
| (74) Front crossmember mounting hole (symmetrical), front | (83) Under cover rear fixing hole (symmetrical) | (92) Rear suspension support sub frame mounting hole (symmetrical) |
| (75) Front crossmember mounting hole (symmetrical), rear | (84) Protector tank mounting hole (symmetrical) | (93) Rear suspension crossmember mounting hole (symmetrical), front |
| (76) Front suspension plate mounting hole (symmetrical), inner side | (85) Exhaust cover mounting hole (symmetrical) | (94) Rear suspension crossmember mounting hole (symmetrical), rear |
| (77) Front suspension arm mounting hole (symmetrical) | (86) Exhaust cover mounting hole (symmetrical) | (95) Gauge hole (symmetrical) |
| (78) Front suspension plate mounting hole (symmetrical), outer side | (87) Crossmember upper mounting hole (symmetrical) | (121) Gauge hole (symmetrical) |
| (79) Under cover rear mounting hole (symmetrical) | (88) Side spoiler mounting hole (symmetrical) | |

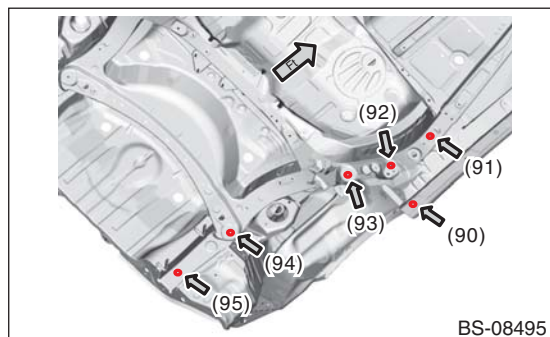
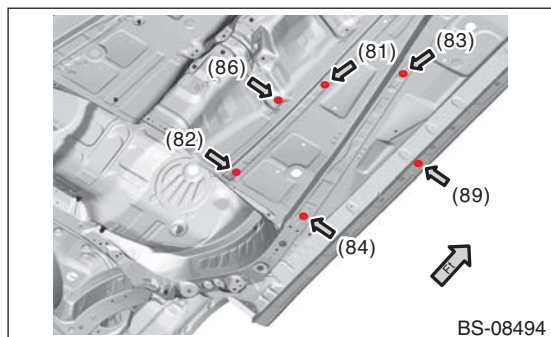
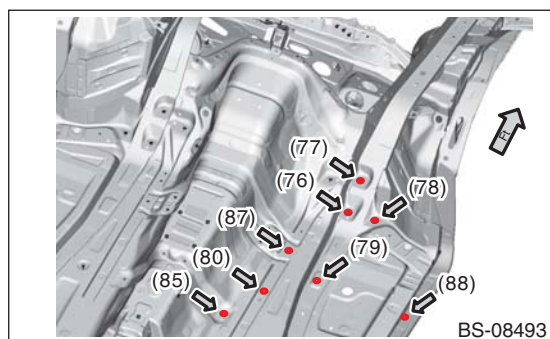
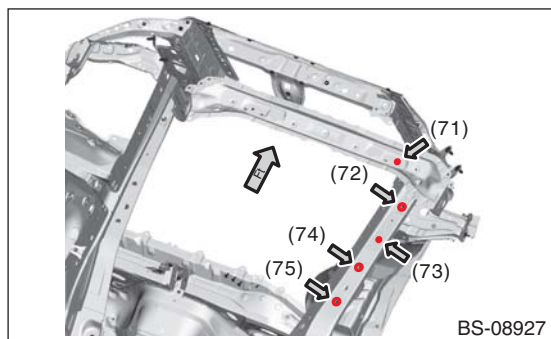
Measuring point	Datum dimension mm (in)	Projected dimensions for reference mm (in)
Datum line — (71)	24 (0.94)	—
Datum line — (72)	207 (8.15)	—
Datum line — (73)	217 (8.54)	—
Datum line — (74)	220 (8.66)	—
Datum line — (75)	220 (8.66)	—
Datum line — (76)	-2 (-0.08)	—
Datum line — (77)	58 (2.28)	—
Datum line — (79)	-25 (-0.98)	—
Datum line — (80)	6 (0.24)	—
Datum line — (81)	-12 (-0.47)	—
Datum line — (82)	-5 (-0.2)	—
Datum line — (83)	-30 (-1.18)	—
Datum line — (84)	-19 (-0.75)	—
Datum line — (85)	13 (0.51)	—
Datum line — (86)	-8 (-0.31)	—
Datum line — (87)	6 (0.24)	—
Datum line — (91)	-3 (-0.12)	—
Datum line — (92)	34 (1.34)	—
Datum line — (93)	118 (4.65)	—
Datum line — (94)	231 (9.09)	—
Datum line — (95)	260 (10.24)	—
Datum line — (121)	260 (10.24)	—
(71) — (72)	209 (8.23)	—
(72) — (73)	142 (5.59)	—
(72) — (74)	257 (10.12)	—
(72) — (76)	862 (33.94)	—
(74) — (75)	144 (5.67)	—

Measuring point	Datum dimension mm (in)	Projected dimensions for reference mm (in)
(76) — (77)	104 (4.09)	—
(76) — (79)	316 (12.44)	—
(76) — (87)	257 (10.12)	—
(79) — (80)	147 (5.79)	—
(79) — (83)	313 (12.32)	—
(80) — (81)	388 (15.28)	—
(81) — (82)	508 (20.00)	—
(81) — (85)	230 (9.06)	—
(81) — (86)	156 (6.14)	—
(83) — (84)	737 (29.02)	—
(84) — (93)	598 (23.54)	—
(85) — (86)	386 (15.20)	—
(85) — (87)	365 (14.37)	—
(91) — (93)	411 (16.18)	—
(92) — (93)	190 (7.48)	—
(93) — (94)	573 (22.56)	—
(94) — (95)	285 (11.22)	—
(94) — (121)	450 (17.72)	—
(77) — (88)	467 (18.39)	—
(88) — (89)	580 (22.83)	—
(89) — (90)	873 (34.37)	—
(71)R — (71)L	560 (22.05)	—
(72)R — (72)L	926 (36.46)	—
(73)R — (73)L	900 (35.43)	—
(74)R — (74)L	876 (34.49)	—
(75)R — (75)L	851 (33.50)	—
(76)R — (76)L	766 (30.16)	—

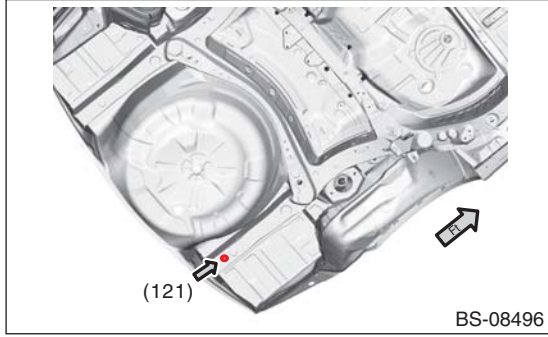
Body Reference Points

Measuring point	Datum dimension mm (in)	Projected dimensions for reference mm (in)
(77)R — (77)L	764 (30.08)	—
(78)R — (78)L	968 (38.11)	—
(79)R — (79)L	818 (32.20)	—
(80)R — (80)L	548 (21.57)	—
(81)R — (81)L	548 (21.57)	—
(82)R — (82)L	548 (21.57)	—
(83)R — (83)L	908 (35.75)	—
(84)R — (84)L	1,174 (46.22)	—
(85)R — (85)L	387 (15.24)	—
(86)R — (86)L	370 (14.57)	—
(87)R — (87)L	548 (21.57)	—
(88)R — (88)L	1,550 (61.02)	—
(89)R — (89)L	1,550 (61.02)	—
(90)R — (90)L	1,562 (61.50)	—
(91)R — (91)L	1,229 (48.39)	—
(92)R — (92)L	1,225 (48.23)	—
(93)R — (93)L	1,096 (43.15)	—
(94)R — (94)L	883 (34.76)	—
(95)R — (95)L	889 (35.00)	—
(121)R — (121)L	889 (35.00)	—
(71)R — (74)L	878 (34.57)	856 (33.70)
(71)L — (76)R	1,260 (49.61)	1,260 (49.61)
(71)R — (77)L	1,172 (46.14)	1,172 (46.14)
(71)L — (78)R	1,312 (51.65)	1,312 (51.65)
(72)R — (74)L	937 (36.89)	937 (36.89)

Measuring point	Datum dimension mm (in)	Projected dimensions for reference mm (in)
(72)L — (76)R	1,226 (48.27)	1,208 (47.56)
(72)R — (77)L	1,145 (45.08)	1,135 (44.68)
(72)L — (78)R	1,294 (50.94)	1,277 (50.28)
(73)L — (76)R	1,123 (44.21)	1,101 (43.35)
(73)R — (77)L	1,047 (41.22)	1,035 (40.75)
(73)L — (78)R	1,197 (47.13)	1,176 (46.3)
(74)L — (76)R	1,044 (41.10)	1,020 (40.16)
(74)R — (77)L	975 (38.39)	961 (37.83)
(74)L — (78)R	1,122 (44.17)	1,100 (43.31)
(76)R — (79)L	853 (33.58)	853 (33.58)
(79)R — (81)L	868 (34.17)	868 (34.17)
(79)R — (82)L	1,247 (49.09)	1,247 (49.09)
(79)L — (83)R	918 (36.14)	918 (36.14)
(79)L — (84)R	1,447 (56.97)	1,447 (56.97)
(81)L — (92)R	1,280 (50.39)	1,279 (50.35)
(82)L — (92)R	979 (38.54)	978 (38.5)
(83)R — (92)L	1,565 (61.61)	1,564 (61.57)
(84)R — (92)L	1,268 (49.92)	1,267 (49.88)
(92)L — (93)R	1,179 (46.42)	1,176 (46.3)
(92)L — (94)R	1,316 (51.81)	1,302 (51.26)
(93)R — (95)L	1,320 (51.97)	1,312 (51.65)
(93)R — (121)L	1,432 (56.38)	1,425 (56.1)
(94)R — (95)L	931 (36.65)	931 (36.65)
(94)R — (121)L	994 (39.13)	994 (39.13)



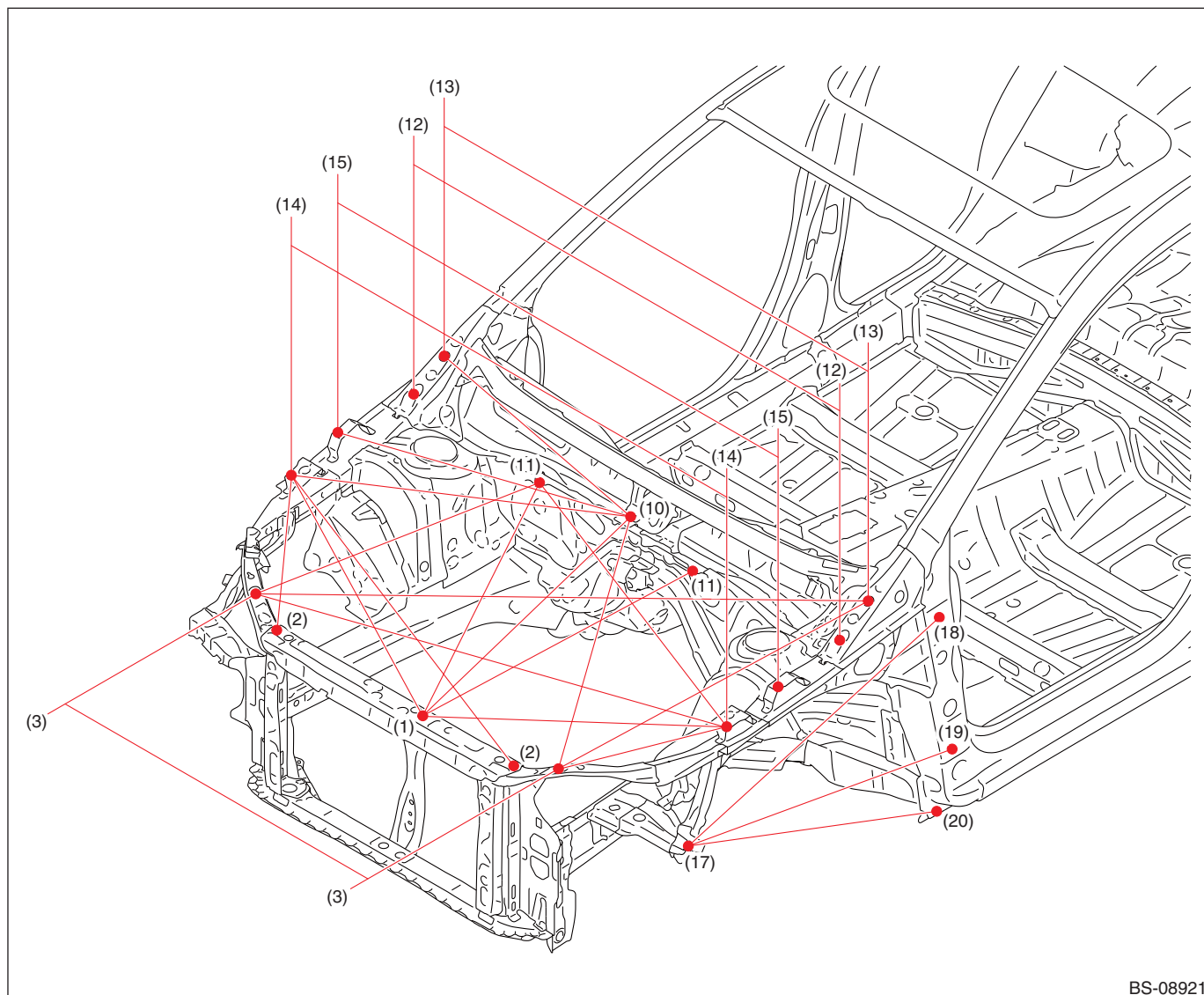
Body Reference Points



SUBARU.

Body Reference Points

2. FRONT 1



BS-08921

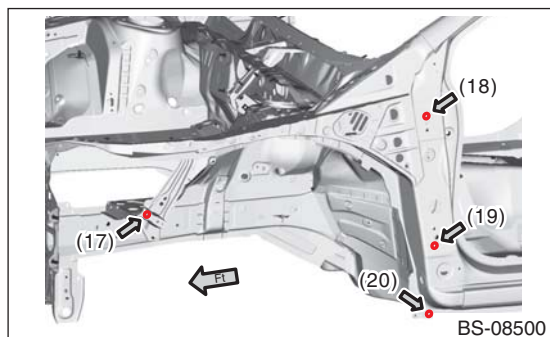
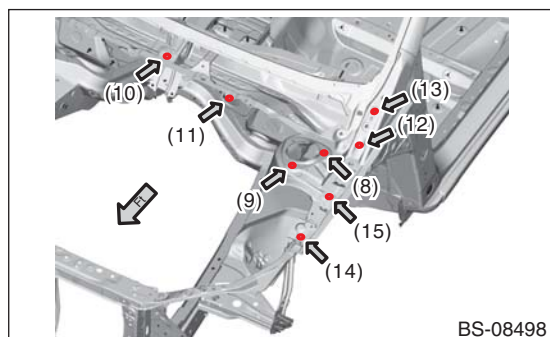
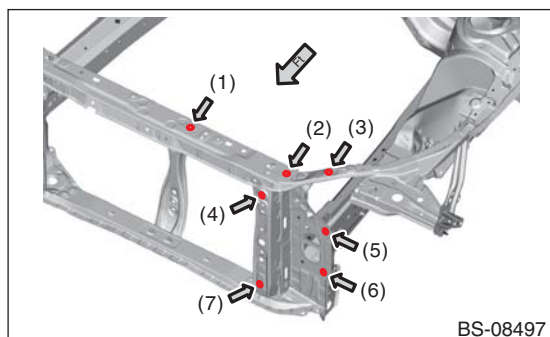
- | | | |
|--|--|---|
| (1) Cover upper mounting hole (left side) | (12) Gauge hole (symmetrical) | (18) Front door hinge upper mounting hole (symmetrical), upper side |
| (2) Radiator upper frame mounting hole (symmetrical) | (13) Hood hinge rear mounting hole (symmetrical) | (19) Front door hinge lower mounting hole (symmetrical), lower side |
| (3) Headlight mounting hole (symmetrical) | (14) Headlight mounting hole (symmetrical) | (20) Fender mounting hole rear (symmetrical) |
| (10) Gauge hole (body center) | (15) Fender mounting hole (symmetrical) | |
| (11) Cowl panel mounting hole (symmetrical) | (17) Fender mounting hole front (symmetrical) | |

Body Reference Points

Measuring point	Datum dimension mm (in)
(1)L — (10)	844 (33.23)
(1)L — (11)R	868 (34.17)
(1)L — (11)L	805 (31.69)
(1)L — (14)R	954 (37.56)
(1)L — (14)L	781 (30.75)
(2)R — (14)R	534 (21.02)
(2)L — (14)R	1,251 (49.25)
(3)R — (3)L	1,060 (41.73)
(3)L — (10)	951 (37.44)
(3)R — (11)R	784 (30.87)
(3)R — (13)L	1,552 (61.10)
(3)L — (13)L	915 (36.02)
(3)R — (14)L	1,342 (52.83)

Measuring point	Datum dimension mm (in)
(3)L — (14)L	431 (16.97)
(10) — (13)R	751 (29.57)
(10) — (14)R	874 (34.41)
(10) — (15)R	811 (31.93)
(11)R — (14)L	1,097 (43.19)
(12)R — (12)L	1,491 (58.70)
(13)R — (13)L	1,484 (58.43)
(14)R — (14)L	1,524 (60.00)
(15)R — (15)L	1,541 (60.67)
(17)L — (18)L	929 (36.57)
(17)L — (19)L	933 (36.73)
(17)L — (20)L	1,008 (39.68)

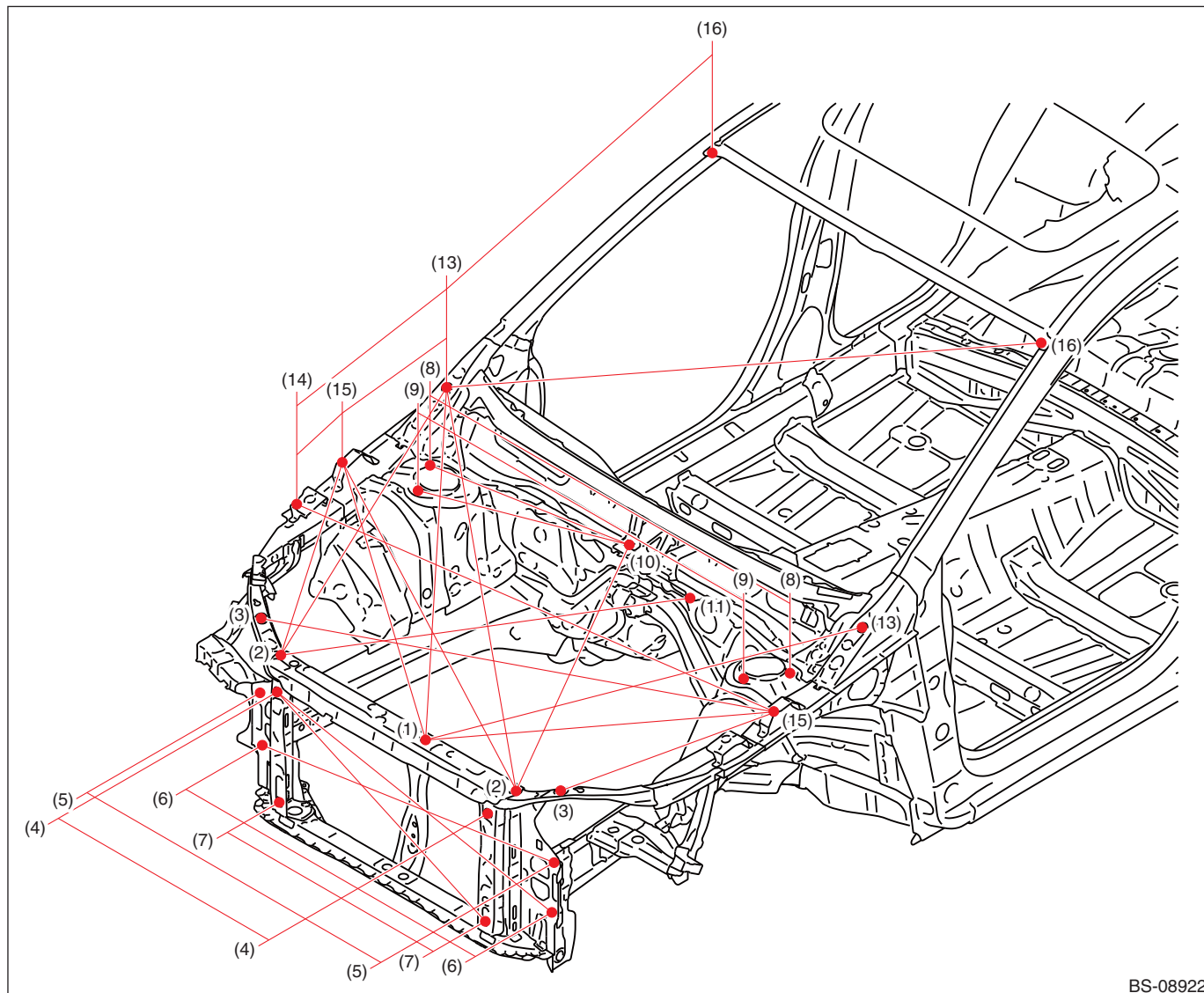
- Reference point (1) indicates a left side part. Reference point (10) indicates a body center part. All other reference points indicate left-right symmetrical parts.
- The dimensions are the actual dimensions between the reference points.



SUBARU.

Body Reference Points

3. FRONT 2



BS-08922

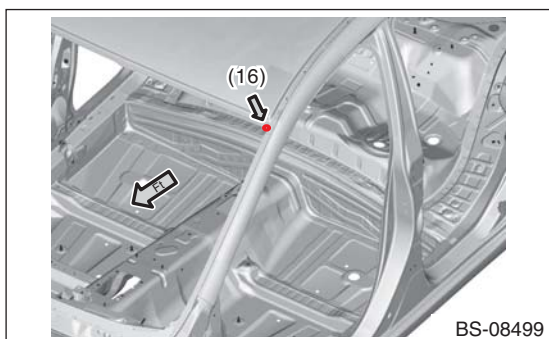
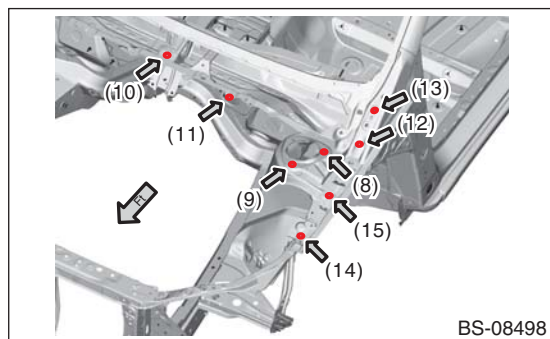
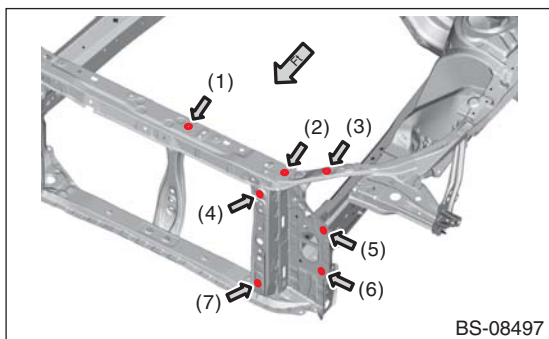
- | | | |
|---|--|--|
| (1) Cover upper mounting hole (left side) | (6) Bumper beam mounting hole (symmetrical), lower side | (11) Cowl panel mounting hole (symmetrical) |
| (2) Radiator upper frame mounting hole (symmetrical) | (7) Gauge hole (symmetrical) | (13) Hood hinge rear mounting hole (symmetrical) |
| (3) Headlight mounting hole (symmetrical) | (8) Front suspension mounting hole (symmetrical), rear outside | (14) Headlight mounting hole (symmetrical) |
| (4) Plate EA mounting hole (symmetrical) | (9) Front suspension mounting hole (symmetrical), front | (15) Fender mounting hole (symmetrical) |
| (5) Bumper beam mounting hole (symmetrical), upper side | (10) Gauge hole (body center) | (16) Front glass installation reference hole (symmetrical) |

Body Reference Points

Measuring point	Datum dimension mm (in)
(1)L — (13)R	1,261 (49.65)
(1)L — (13)L	1,139 (44.84)
(1)L — (15)R	1,049 (41.30)
(1)L — ((15)L	893 (35.16)
(2)L — (10)	936 (36.85)
(2)R — (11)L	1,044 (41.10)
(2)R — (13)R	991 (39.02)
(2)L — (13)R	1,493 (58.78)
(2)R — ((15)R	683 (26.89)
(2)L — (15)R	1,327 (52.24)
(3)R — (15)L	1,407 (55.39)
(3)L — (15)L	590 (23.23)
(4)R — (4)L	752 (29.61)
(4)R — (6)L	940 (37.01)
(4)R — (7)L	817 (32.17)

Measuring point	Datum dimension mm (in)
(5)R — (5)L	1,050 (41.34)
(5)L — (6)R	1,054 (41.50)
(6)R — (6)L	1,034 (40.71)
(7)R — (7)L	736 (28.98)
(8)R — (8)L	1,285 (50.59)
(8)R — (10)	648 (25.51)
(9)R — (9)L	1,163 (45.79)
(9)R — (10)	608 (23.94)
(13)R — (14)R	528 (20.79)
(13)R — (15)R	353 (13.90)
(13)R — (16)R	905 (35.63)
(13)R — (16)L	1,601 (63.03)
(14)R — (15)R	176 (6.93)
(14)R — (15)L	1,543 (60.75)

- Reference point (1) indicates a left side part. Reference point (10) indicates a body center part. All other reference points indicate left-right symmetrical parts.
- The dimensions are the actual dimensions between the reference points.

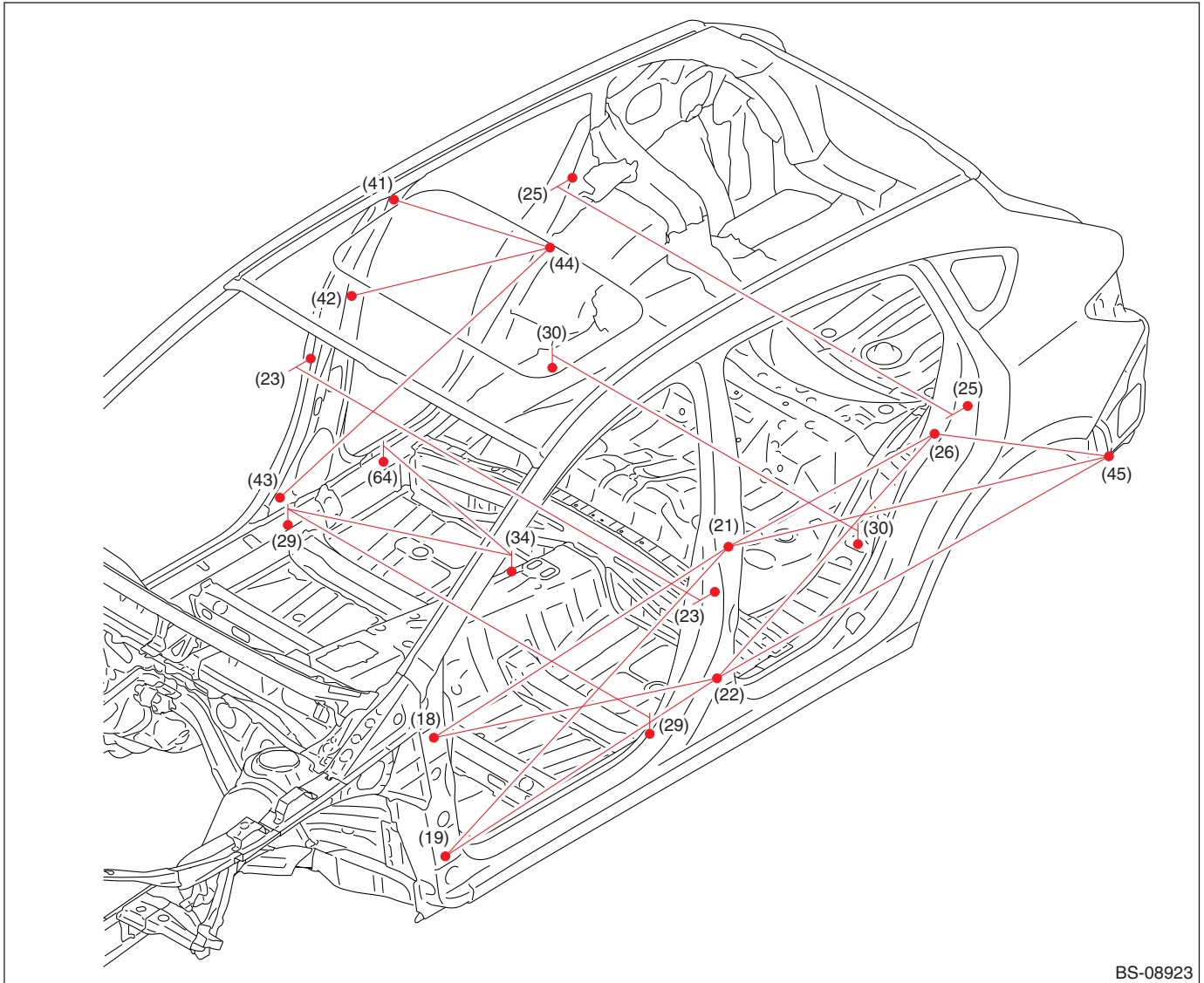


SUBARU.

Body Reference Points

4. INSIDE 1

• COMMON PARTS FOR 5 DOOR AND 4 DOOR



BS-08923

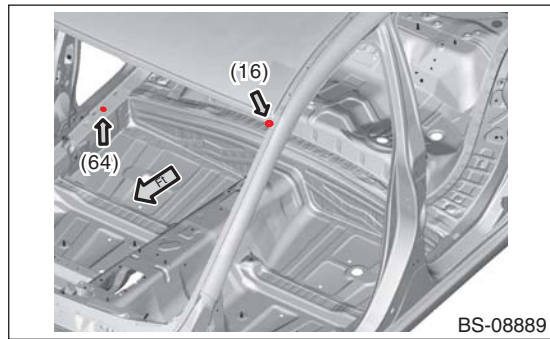
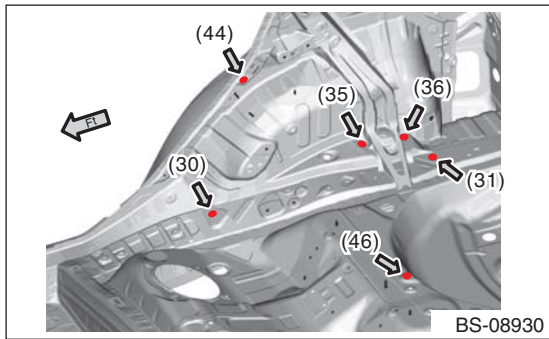
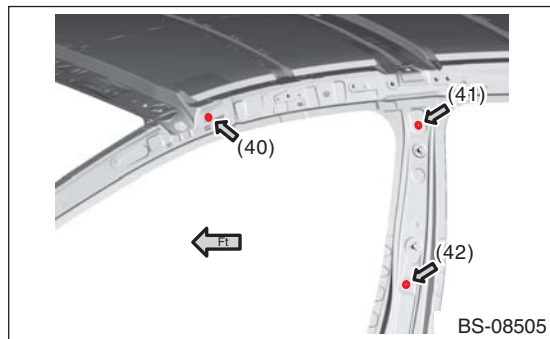
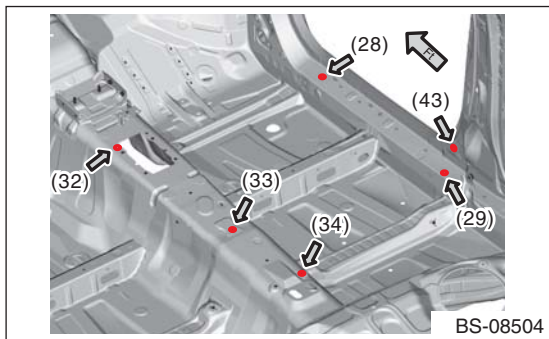
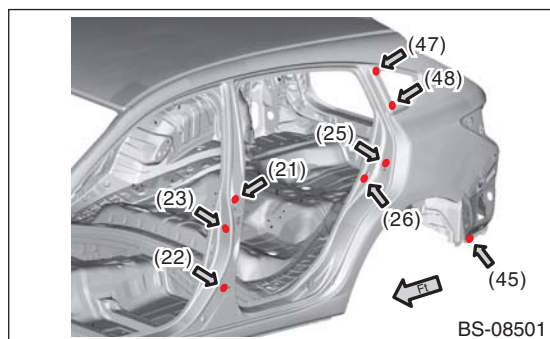
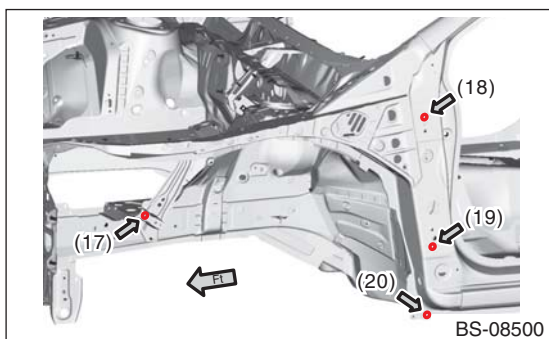
- | | | |
|---|---|---|
| (18) Front door hinge upper mounting hole (symmetrical), upper side | (26) Rear door switch mounting hole (symmetrical) | (43) Trim mounting hole (symmetrical) |
| (19) Front door hinge lower mounting hole (symmetrical), lower side | (29) Harness clip mounting hole (symmetrical) | (44) Apron trim mounting hole (symmetrical) |
| (21) Rear door hinge upper mounting hole (symmetrical), upper side | (30) Belt anchor mounting hole (symmetrical) | (45) Cover side lower mounting hole (symmetrical) |
| (22) Rear door hinge lower mounting hole (symmetrical), front | (34) Console bracket mounting hole (symmetrical) | (64) Harness clip mounting hole (symmetrical) |
| (23) Front door striker mounting hole (symmetrical), upper side | (41) Trim mounting hole (symmetrical) | |
| (25) Rear door striker mounting hole (symmetrical), upper side | (42) Trim mounting hole (symmetrical) | |

Body Reference Points

Measuring point	Datum dimension mm (in)
(18)L — (21)L	1,145 (45.08)
(18)L — (22)L	1,133 (44.61)
(19)L — (21)L	1,217 (47.91)
(19)L — (22)L	1,065 (41.93)
(21)L — (26)L	872 (34.33)
(21)L — (45)L	1,624 (63.94)
(22)L — (26)L	982 (38.66)
(22)L — (45)L	1,608 (63.31)
(23)R — (23)L	1,570 (61.81)

Measuring point	Datum dimension mm (in)
(25)R — (25)L	1,535 (60.43)
(26)L — (45)L	795 (31.30)
(29)R — (29)L	1,406 (55.35)
(29)R — (34)R	693 (27.28)
(30)R — (30)L	1,187 (46.73)
(34)R — (64)R	701 (27.60)
(41)R — (44)R	924 (36.38)
(42)R — (44)R	842 (33.15)
(43)R — (44)R	1,136 (44.72)

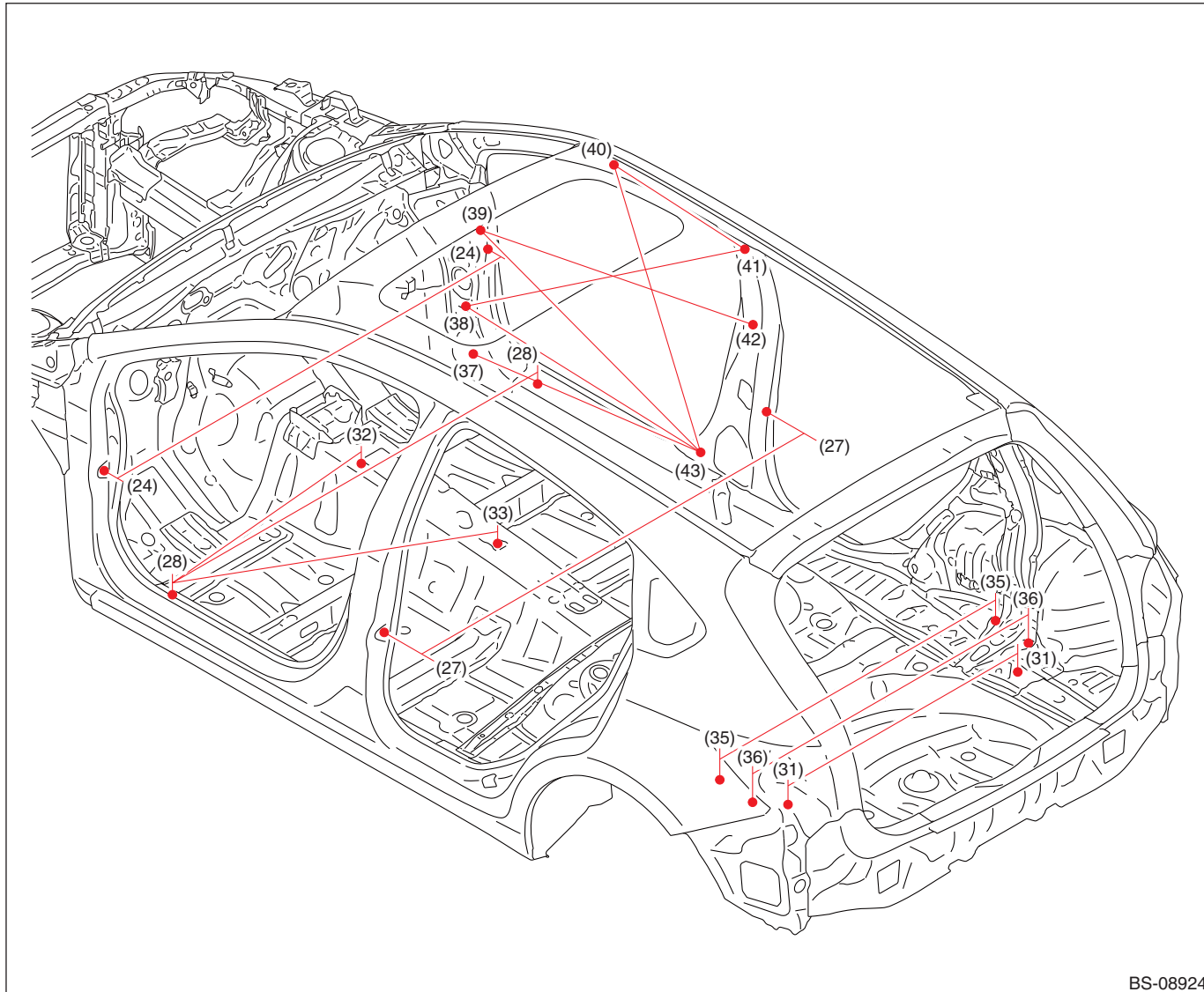
- All reference points are left-right symmetrical.
- The dimensions are the actual dimensions between the reference points.



Body Reference Points

5. INSIDE 2

• COMMON PARTS FOR 5 DOOR AND 4 DOOR



BS-08924

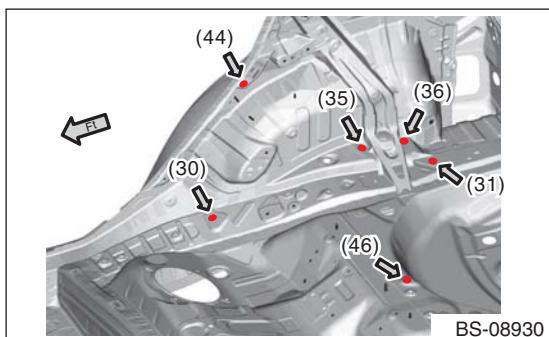
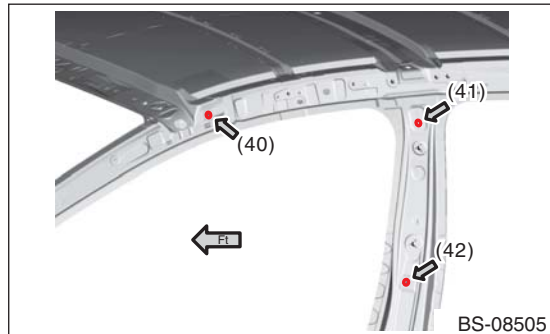
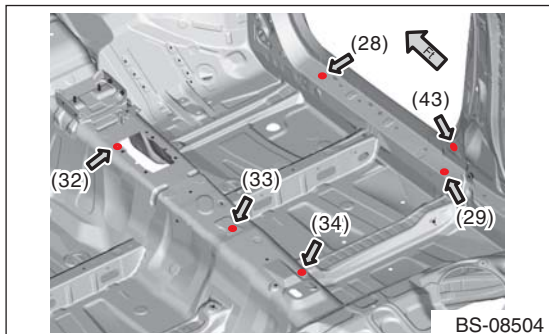
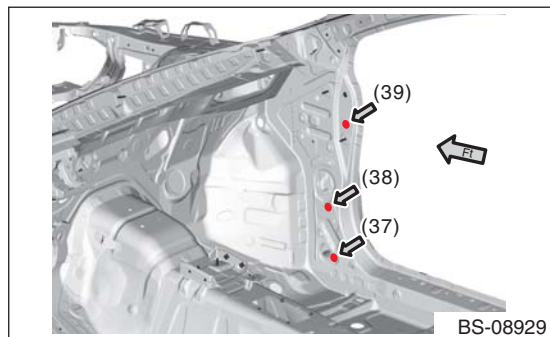
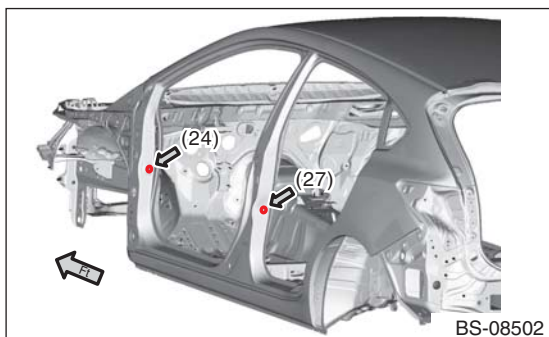
(24) Front door checker mounting hole (symmetrical)	(33) Hand brake mounting hole (body center)	(39) Steering beam mounting hole (symmetrical) lower side
(27) Rear door checker mounting hole (symmetrical)	(35) Rear suspension mounting hole (symmetrical), front	(40) Pad A-pillar mounting hole (symmetrical)
(28) Harness clip mounting hole (symmetrical)	(36) Rear suspension mounting hole (symmetrical), rear	(41) Trim mounting hole (symmetrical)
(31) Gauge hole (symmetrical)	(37) Harness holding clip mounting hole (symmetrical)	(42) Trim mounting hole (symmetrical)
(32) Shift case mounting hole (symmetrical)	(38) Ground mounting hole (symmetrical)	(43) Trim mounting hole (symmetrical)

Body Reference Points

Measuring point	Datum dimension mm (in)
(24)R — (24)L	1,513 (59.57)
(27)R — (27)L	1,508 (59.37)
(28)R — (28)L	1,440 (56.69)
(28)L — (32)L	689 (27.13)
(28)L — (33)	919 (36.18)
(31)R — (31)L	906 (35.67)
(35)R — (35)L	1,087 (42.8)
(36)R — (36)L	1,088 (42.83)

Measuring point	Datum dimension mm (in)
(37)R — (43)R	853 (33.58)
(38)R — (41)R	1,457 (57.36)
(38)R — (43)R	890 (35.04)
(39)R — (42)R	1,111 (43.74)
(39)R — (43)R	914 (35.98)
(40)R — (41)R	505 (19.88)
(40)R — (43)R	989 (38.94)

- Reference point (33) indicates a body center part. All other reference points indicate left-right symmetrical parts.
- The dimensions are the actual dimensions between the reference points.

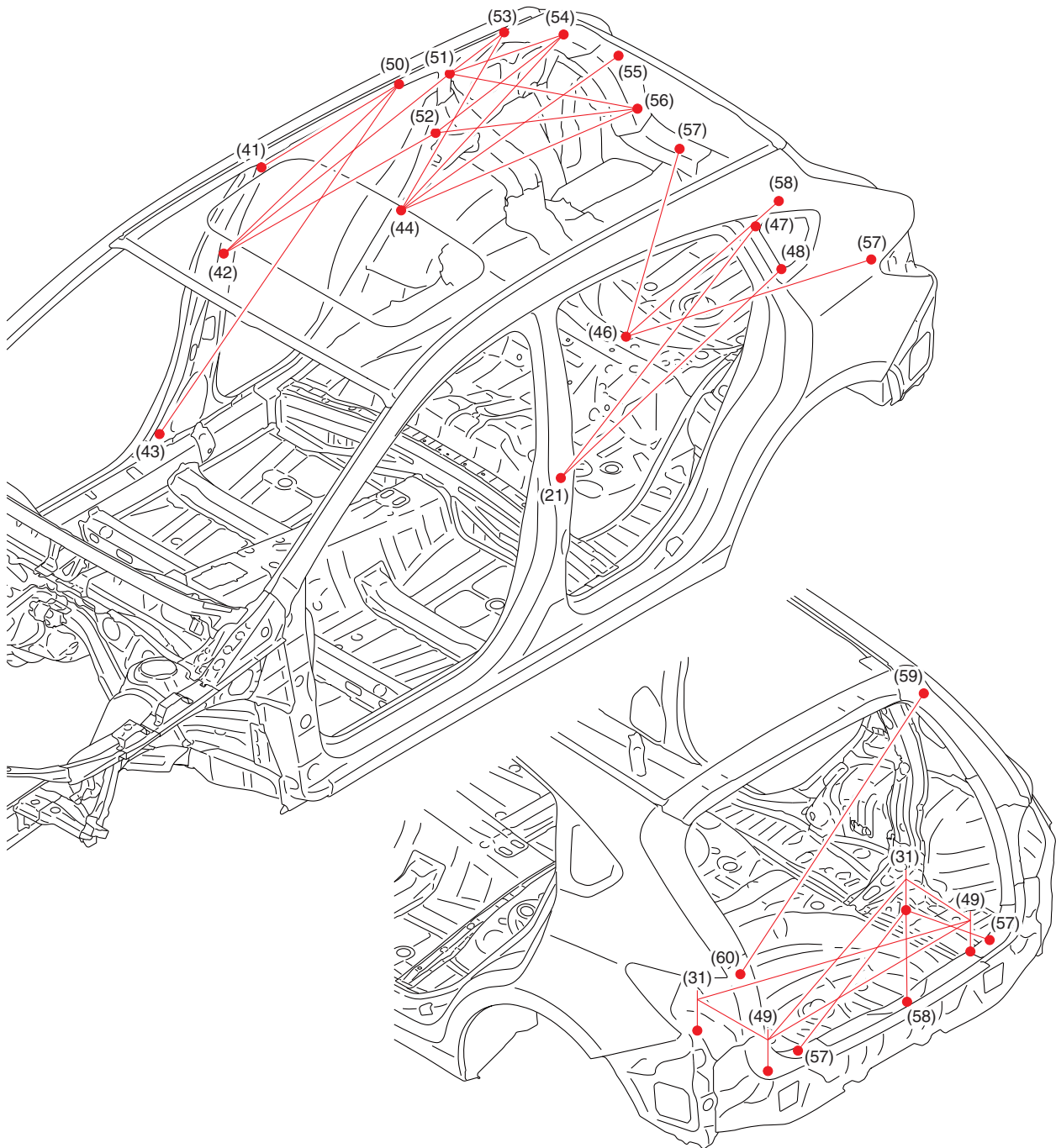


SUBARU.

Body Reference Points

6. INSIDE & REAR 1

• SPECIAL 5 DOOR PARTS



BS-08487

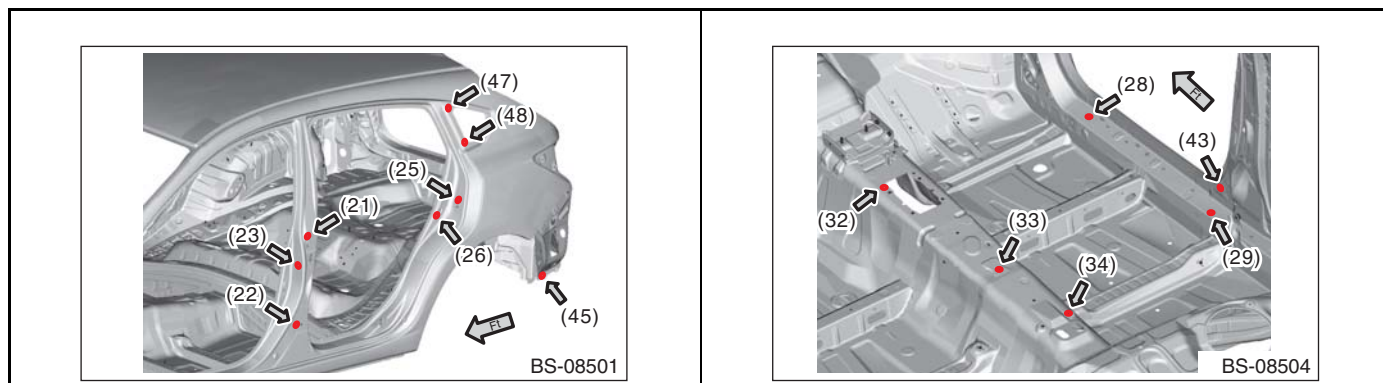
Body Reference Points

(21) Rear door hinge upper mounting hole (symmetrical), upper side	(48) Rear quarter glass mounting hole (symmetrical), front lower side	(55) Trim clip mounting hole (symmetrical)
(31) Gauge hole (symmetrical)	(49) Gauge hole (right side) R	(56) Gauge hole (symmetrical)
(41) Trim mounting hole (symmetrical)	(49) Gauge hole (left side) L	(57) Trim mounting hole (symmetrical)
(42) Trim mounting hole (symmetrical)	(50) Gauge hole (symmetrical)	(58) Striker mounting hole (symmetrical)
(43) Trim mounting hole (symmetrical)	(51) Trim D-pillar mounting hole (symmetrical)	(59) Rear gate stay mounting hole (symmetrical), upper side
(44) Apron trim mounting hole (symmetrical)	(52) Apron trim mounting hole (symmetrical)	(60) Rear combination light mounting hole (symmetrical), upper side
(46) Spacer front mounting hole (symmetrical)	(53) Gauge hole (symmetrical)	
(47) Rear quarter glass mounting hole (symmetrical), front upper side	(54) Trim clip mounting hole (symmetrical)	

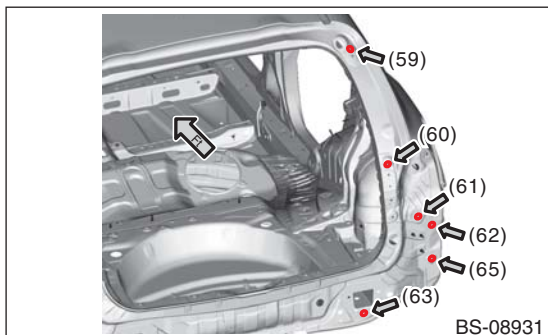
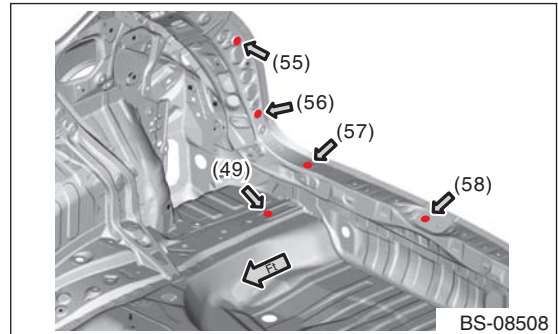
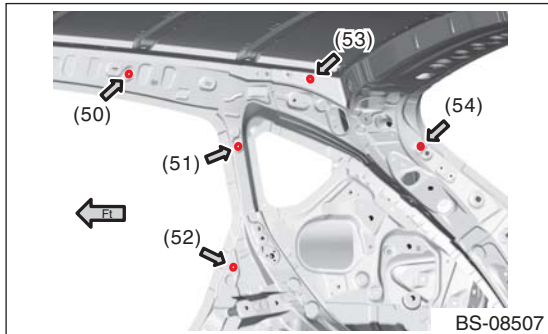
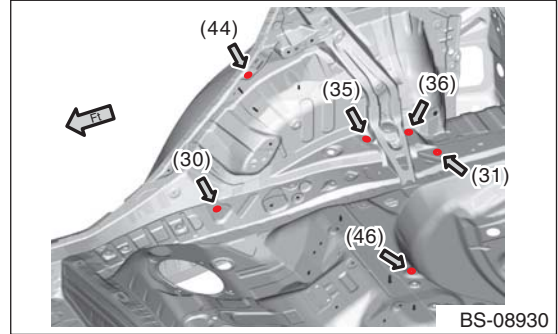
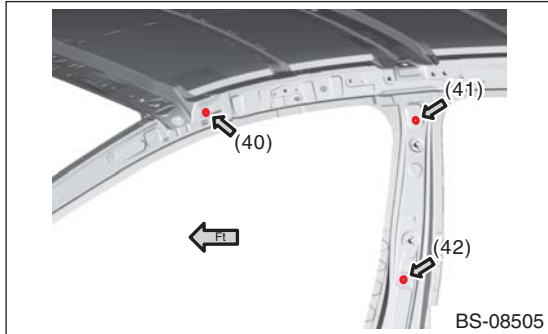
Measuring point	Datum dimension mm (in)
(21)L — (47)L	1,064 (41.89)
(21)L — (48)L	1,060 (41.73)
(31)R — (49)R	288 (11.34)
(31)L — (49)R	943 (37.13)
(31)R — (49)L	946 (37.24)
(31)L — (49)L	298 (11.73)
(31)R — (57)R	415 (16.34)
(31)R — (57)L	963 (37.91)
(31)R — (58)R	620 (24.41)
(41)R — (50)R	555 (21.85)
(42)R — (50)R	750 (29.53)
(42)R — (51)R	945 (37.20)
(42)R — (52)R	914 (35.98)
(43)R — (50)R	1,313 (51.69)

Measuring point	Datum dimension mm (in)
(44)R — (53)R	647 (25.47)
(44)R — (54)R	675 (26.57)
(44)R — (55)R	784 (30.87)
(44)R — (56)R	828 (32.60)
(46)L — (57)R	877 (34.53)
(46)L — (57)L	805 (31.69)
(46)L — (58)R	768 (30.24)
(49)R — (49)L	889 (35.00)
(51)R — (53)R	218 (8.58)
(51)R — (54)R	410 (16.14)
(51)R — (56)R	862 (33.94)
(52)R — (54)R	496 (19.53)
(52)R — (56)R	760 (29.92)
(59)R — (60)L	1,244 (48.98)

- Reference point (46) indicates a left side part. Reference point (49) indicates a right-left asymmetrical part. All other reference points indicate left-right symmetrical parts.
- The dimensions are the actual dimensions between the reference points.



Body Reference Points

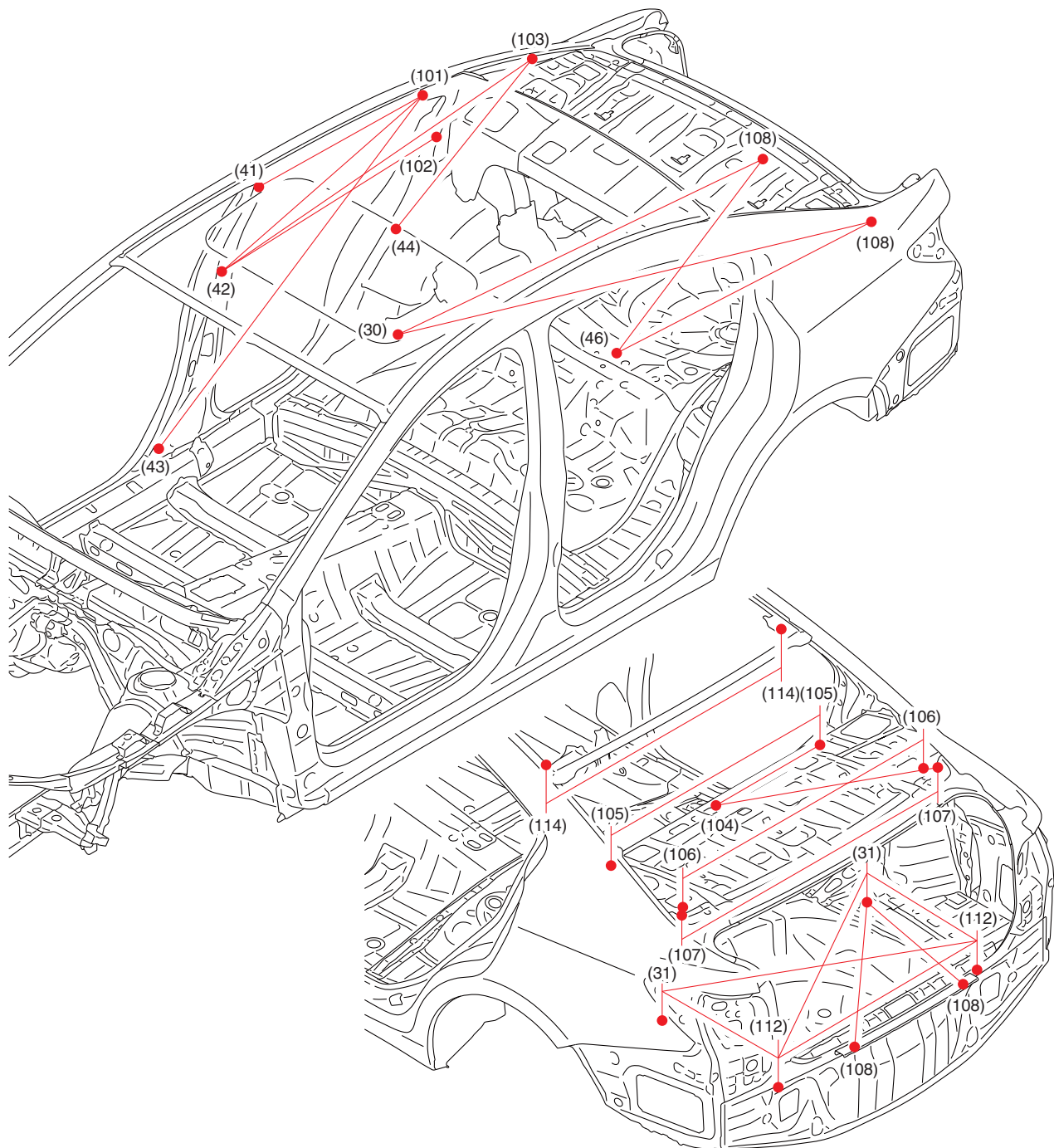


SUBARU.

Body Reference Points

7. INSIDE & REAR 2

• SPECIAL 4 DOOR PARTS



BS-08488

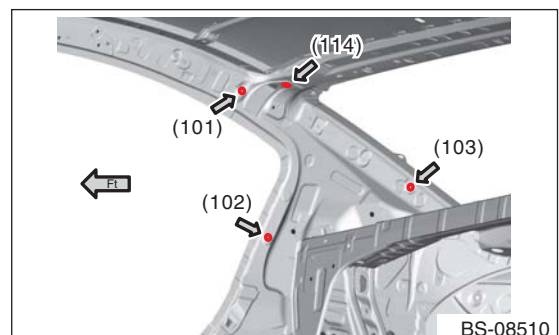
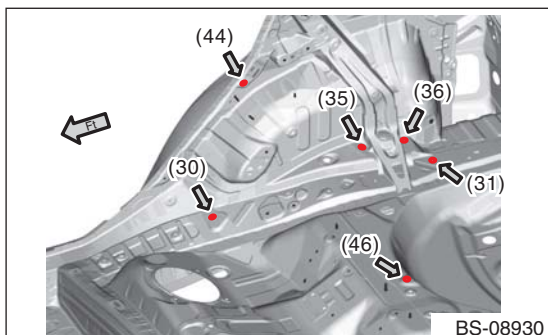
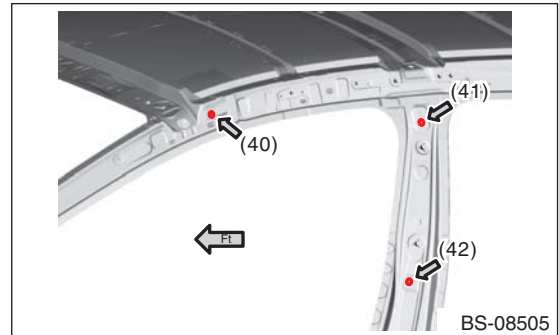
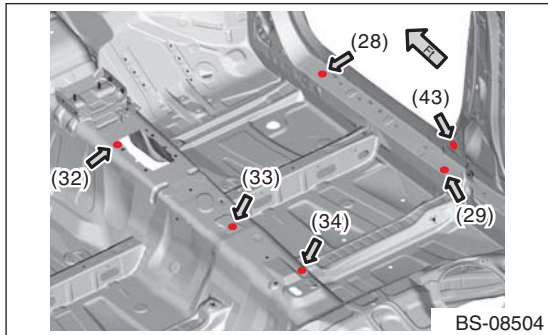
Body Reference Points

(30) Belt anchor mounting hole (symmetrical)	(46) Spacer front mounting hole	(106) Trunk hinge mounting hole (symmetrical)
(31) Gauge hole (symmetrical)	(101) Gauge hole (symmetrical)	(107) Gauge hole (symmetrical)
(41) Trim mounting hole (symmetrical)	(102) Trim mounting hole (symmetrical)	(108) Gauge hole (symmetrical)
(42) Trim mounting hole (symmetrical)	(103) Trim mounting hole (symmetrical)	(112) Gauge hole (right side) R
(43) Trim mounting hole (symmetrical)	(104) Rear shelf mounting hole (body center)	(112) Gauge hole (left side) L
(44) Apron trim mounting hole (symmetrical)	(105) Rear shelf mounting hole (symmetrical)	(114) Harness mounting hole (symmetrical)

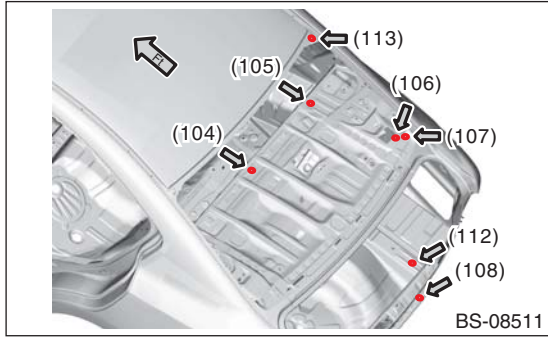
Measuring point	Datum dimension mm (in)
(30)R — (108)R	1,327 (52.24)
(30)R — (108)L	1,527 (60.12)
(31)R — (108)R	682 (26.85)
(31)R — (108)L	949 (37.36)
(31)R — (112)R	495 (19.49)
(31)L — (112)R	1,025 (40.35)
(31)R — (112)L	1,030 (40.55)
(31)L — (112)L	505 (19.88)
(41)R — (101)R	698 (27.48)
(42)R — (101)R	851 (33.50)
(42)R — (102)R	937 (36.89)
(42)R — (103)R	1,311 (51.61)

Measuring point	Datum dimension mm (in)
(43)R — (101)R	1,380 (54.33)
(44)R — (103)R	616 (24.25)
(46)L — (108)R	1,015 (39.96)
(46)L — (108)L	980 (38.58)
(104) — (105)R	462 (18.19)
(104) — (107)R	705 (27.76)
(105)R — (105)L	924 (36.38)
(106)R — (106)L	1,064 (41.89)
(107)R — (107)L	1,132 (44.57)
(112)R — (112)L	889 (35.00)
(114)R — (114)L	1,040 (40.94)

- Reference point (46) indicates a left side part. Reference point (104) indicates a body center part. Reference point (112) indicates a right-left asymmetrical part. All other reference points indicate left-right symmetrical parts.
- The dimensions are the actual dimensions between the reference points.



Body Reference Points

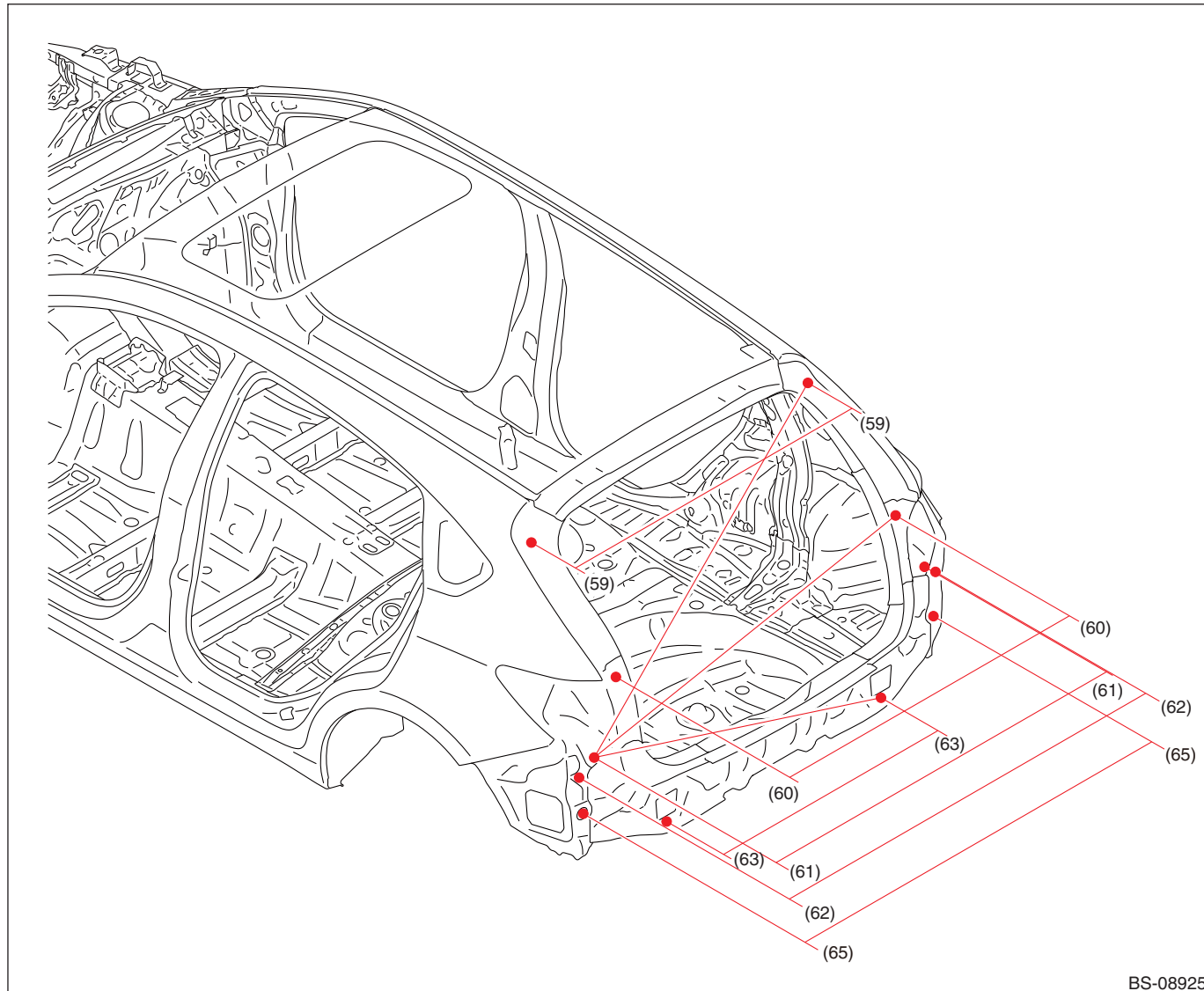


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Body Reference Points

8. REAR 1

• SPECIAL 5 DOOR PARTS



BS-08925

(59) Rear gate stay mounting hole (symmetrical), upper side

(60) Rear combination light mounting hole (symmetrical), upper side

(61) Rear bumper bracket mounting hole (symmetrical)

(62) Gauge hole (symmetrical)

(63) Bumper beam mounting hole (symmetrical)

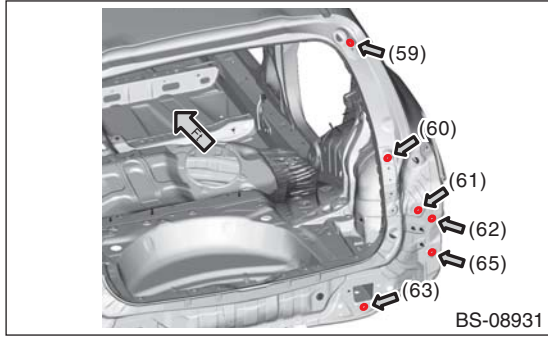
(65) Harness grommet mounting hole (symmetrical)

Measuring point	Datum dimension mm (in)
(59)R — (59)L	1,147 (45.16)
(59)R — (61)L	1,415 (55.71)
(60)R — (60)L	1,160 (45.67)
(60)R — (61)L	1,286 (50.63)
(61)R — (61)L	1,370 (53.94)

Measuring point	Datum dimension mm (in)
(61)L — (63)R	1,175 (46.26)
(62)R — (62)L	1,478 (58.19)
(63)R — (63)L	889 (35.00)
(65)R — (65)L	1,458 (57.40)

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

Body Reference Points

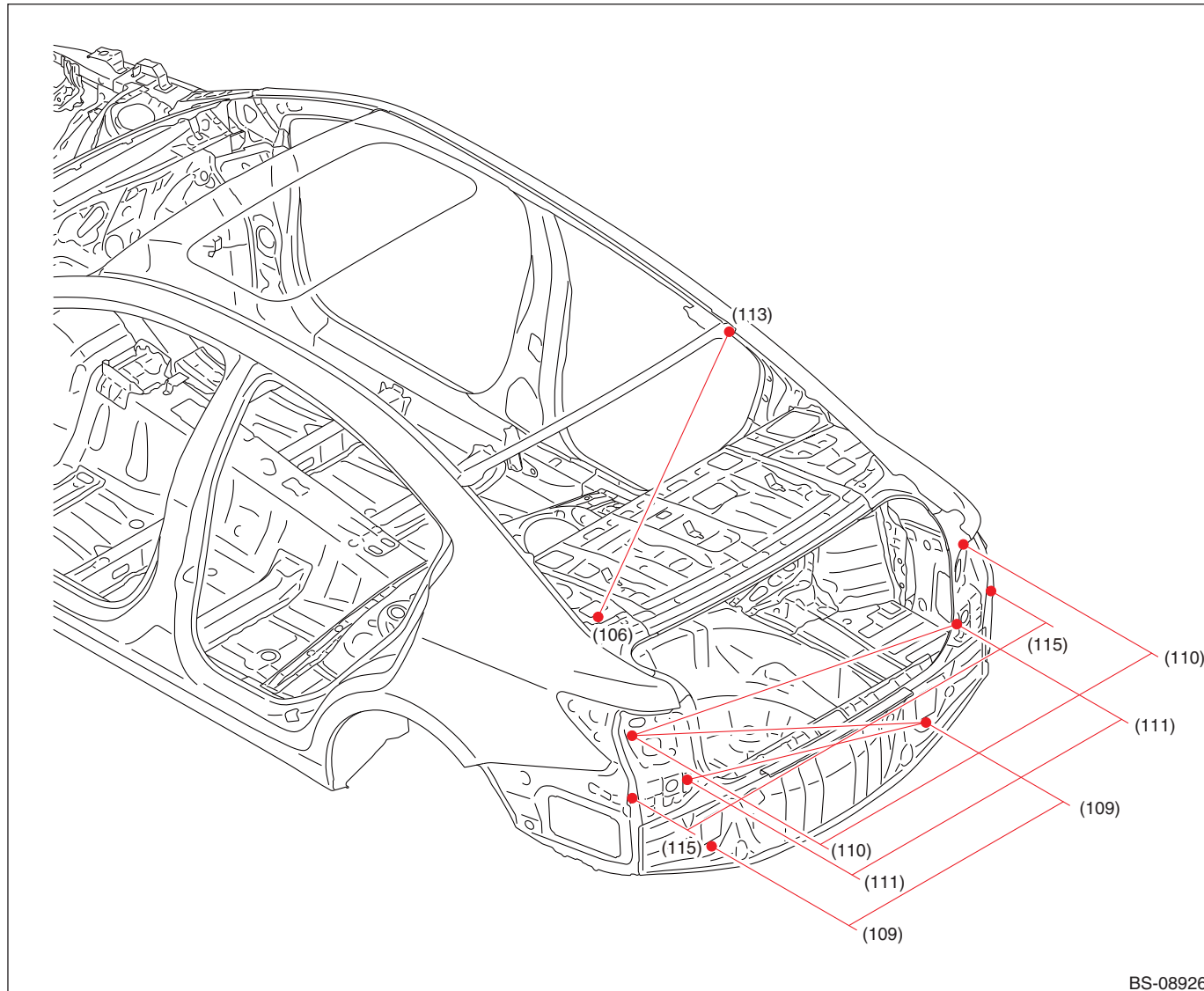


SUBARU.

Body Reference Points

9. REAR 2

• SPECIAL 4 DOOR PARTS



BS-08926

(106) Trunk hinge mounting hole (symmetrical)

(109) Bumper beam mounting hole (symmetrical)

(110) Rear combination light mounting hole (symmetrical), outside

(111) Bracket corner rear mounting hole (symmetrical)

(113) Rear glass installation reference hole (symmetrical)

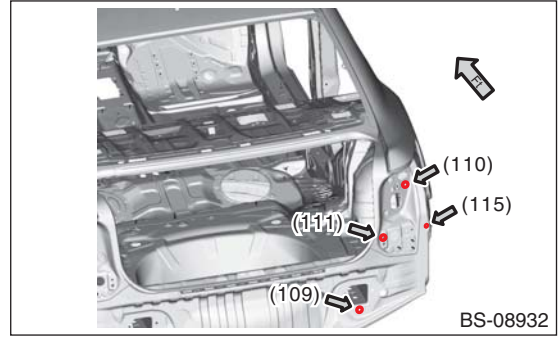
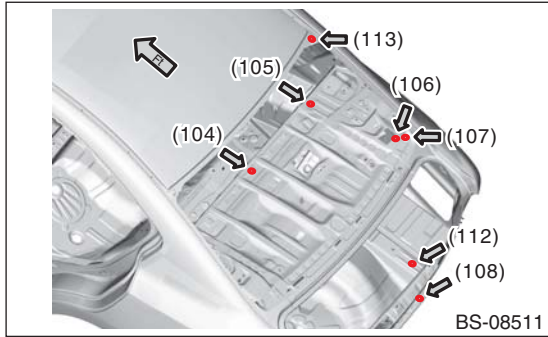
(115) Gauge hole (symmetrical)

Measuring point	Datum dimension mm (in)
(106)L — (113)R	1,212 (47.72)
(109)R — (109)L	889 (35.00)
(109)R — (110)L	1,230 (48.43)
(109)R — (111)L	1,048 (41.26)

Measuring point	Datum dimension mm (in)
(110)R — (110)L	1,374 (54.09)
(110)L — (111)R	1,262 (49.68)
(111)R — (111)L	1,118 (44.02)
(115)R — (115)L	1,489 (58.62)

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

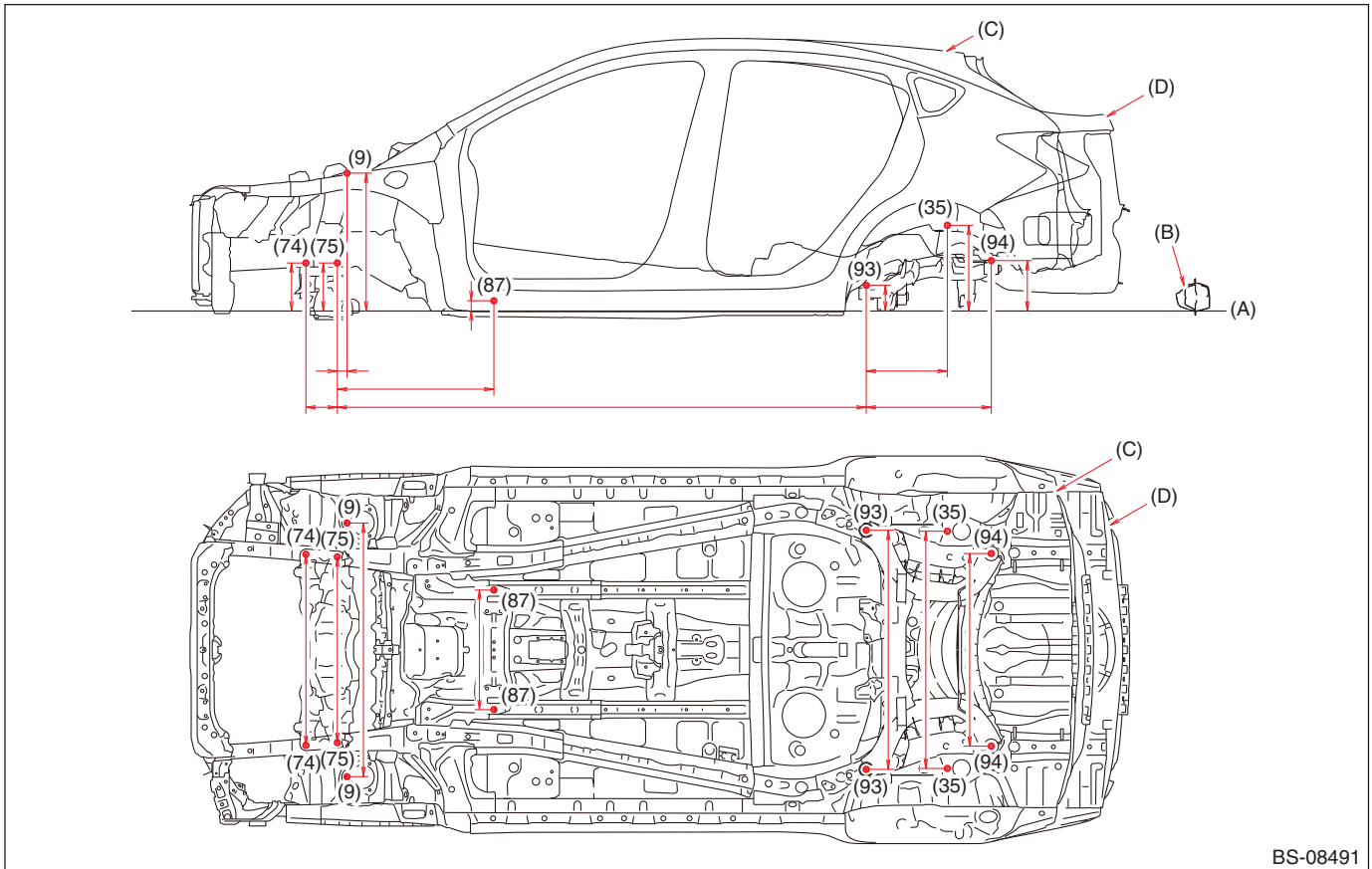
Body Reference Points



7. Measurement for Combined Parts

A: DIMENSIONS

1. SUSPENSION MOUNT & ENGINE MOUNT



BS-08491

- 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

(C) 5 Door

(D) 4 Door

(9) Front suspension mounting hole (symmetrical), front	(75) Front crossmember mounting hole (symmetrical), rear	(94) Rear suspension crossmember mounting hole (symmetrical), rear
(35) Rear suspension mounting hole (symmetrical), front	(87) Crossmember upper mounting hole (symmetrical)	
(74) Front crossmember mounting hole (symmetrical), front	(93) Rear suspension crossmember mounting hole (symmetrical), front	

Measurement for Combined Parts

Measuring point	Datum dimension mm (in)
Datum line — (9)	632 (24.88)
Datum line — (35)	393 (15.47)
Datum line — (74)	220 (8.66)
Datum line — (75)	220 (8.66)
Datum line — (87)	6 (0.24)
Datum line — (93)	118 (4.65)
Datum line — (94)	231 (9.09)
(9) — (75)	45 (1.77)
(35) — (93)	372 (14.65)
(74) — (75)	144 (5.67)

Measuring point	Datum dimension mm (in)
(75) — (87)	718 (28.27)
(75) — (93)	2,424 (95.43)
(93) — (94)	573 (22.56)
(9) — (9)	1,163 (45.79)
(35) — (35)	1,087 (42.80)
(74) — (74)	876 (34.49)
(75) — (75)	851 (33.50)
(87) — (87)	548 (21.57)
(93) — (93)	1,096 (43.15)
(94) — (94)	883 (34.76)

CAUTION:

For the reference points (9), refer to the figure "FRONT 2, DIMENSIONS, Body Reference Points" on page 45.

For the reference points (35), refer to the figure "INSIDE 2, DIMENSIONS, Body Reference Points" on page 49.

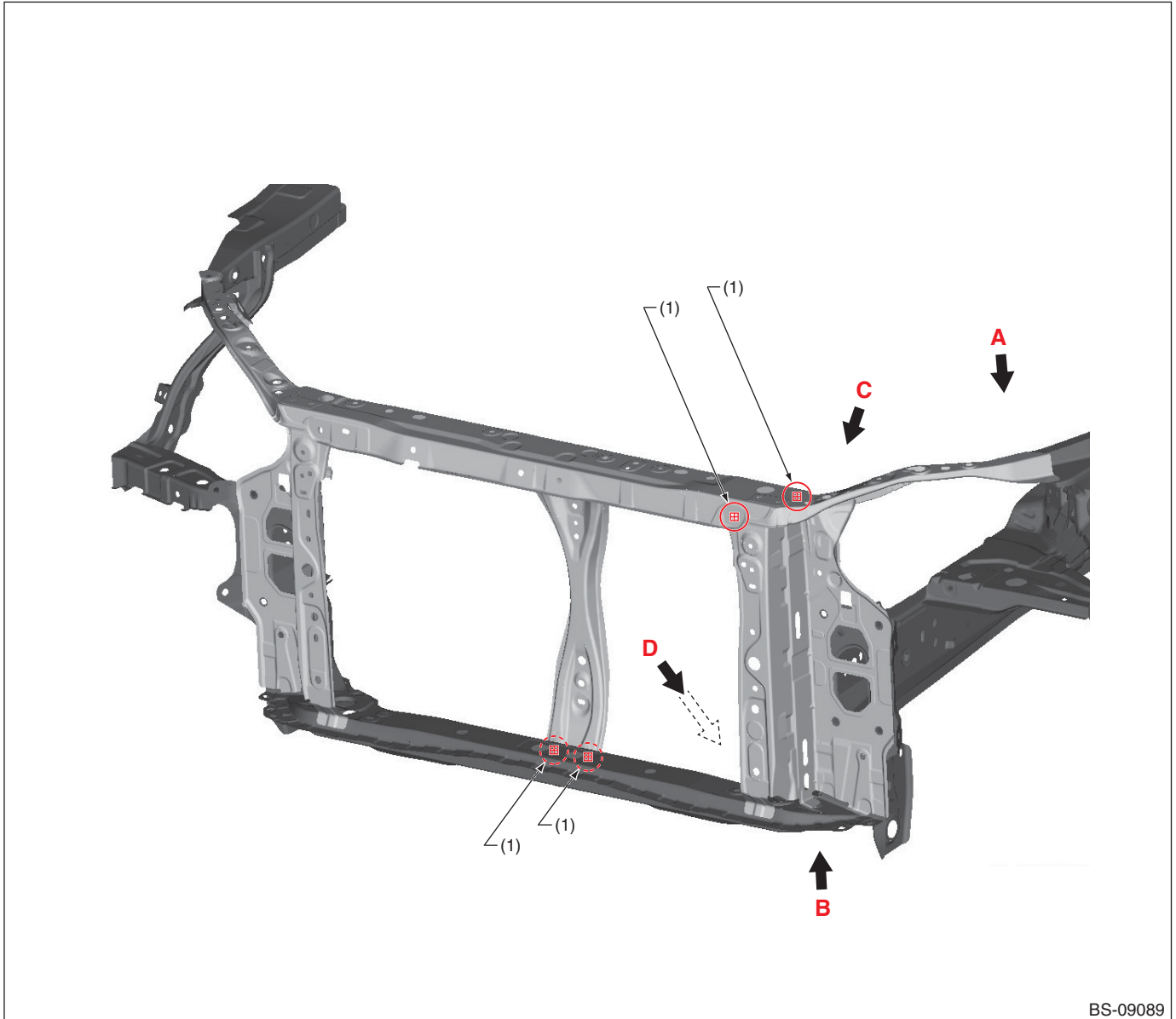
Except the reference points (9) and (35), refer to the figure "LOWER SURFACE, DIMENSIONS, Body Reference Points" on page 39.

8. Panel Replacement

8-1. Radiator Panel (Total replacement)

A: REMOVAL

• Overall view

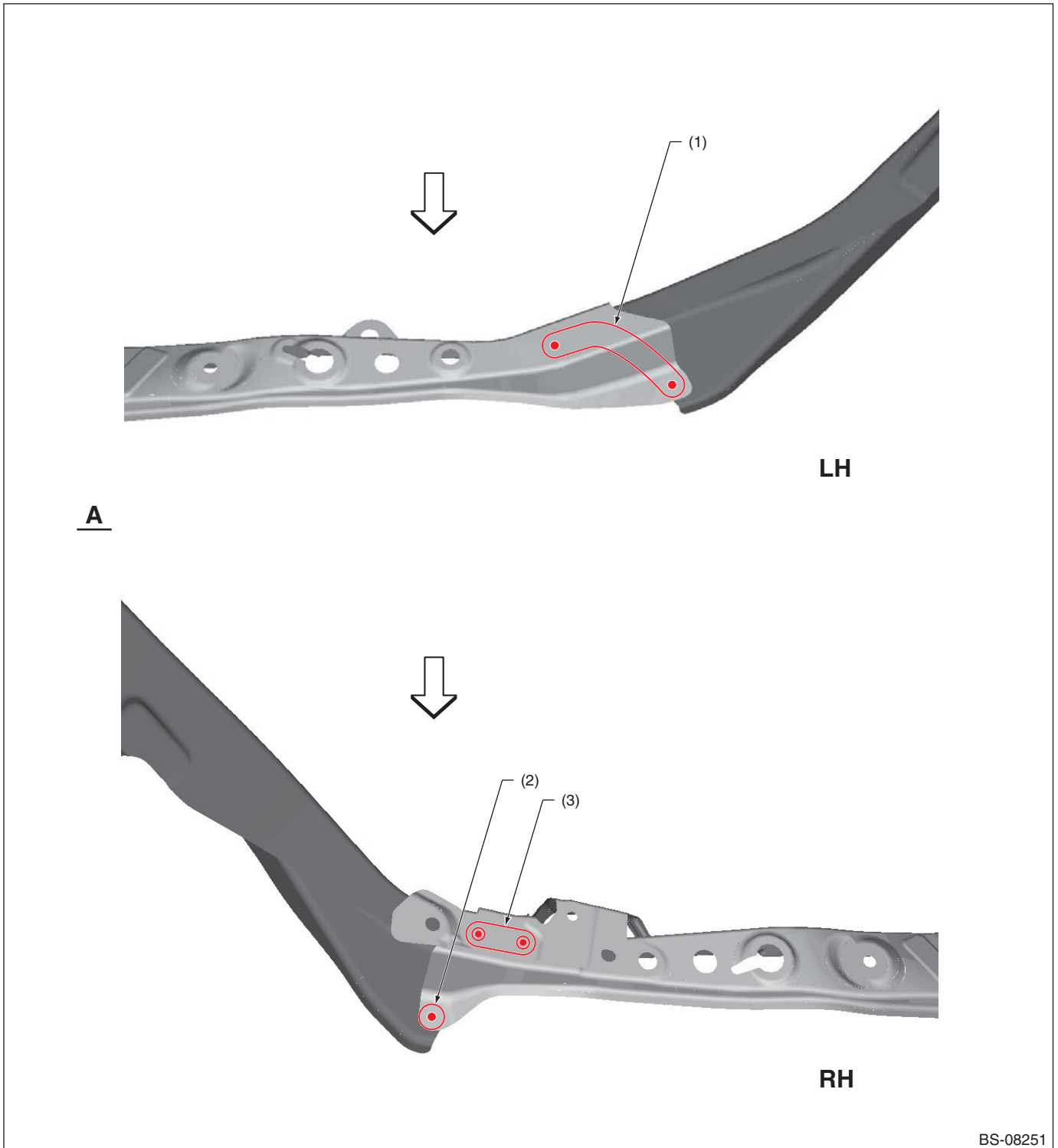


BS-09089

(1) 1 point (bolt)

Panel Replacement

• View A



BS-08251

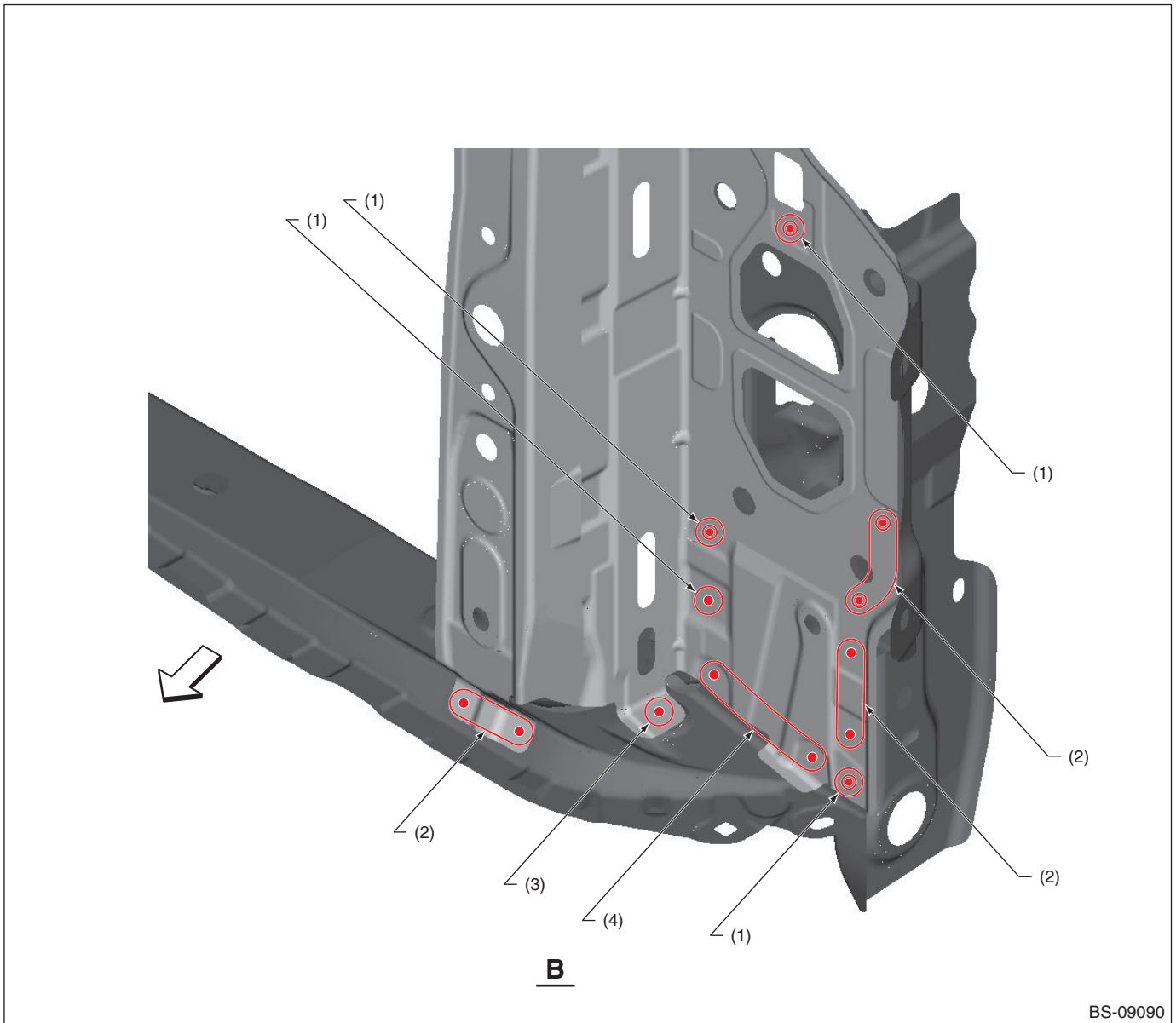
(1) 3 points (top · 1)

(2) 1 point (top · 1)

(3) 2 points (top · 2)

Panel Replacement

• View B



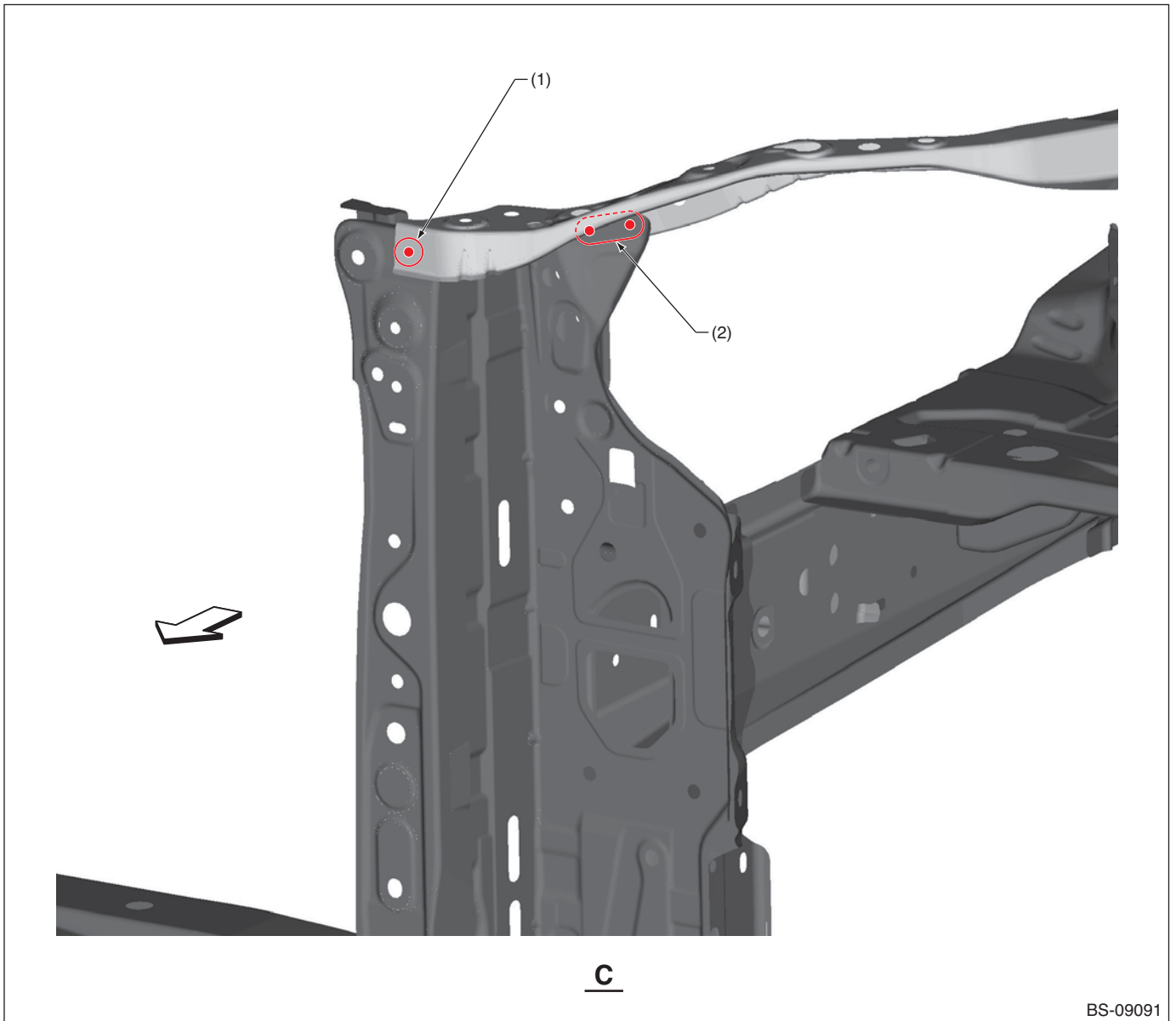
(1) 1 point (outside · 1)
(2) 2 points (outside · 1)

(3) 1 point (top · 1)

(4) 3 points (outside · 1)

Panel Replacement

• View C

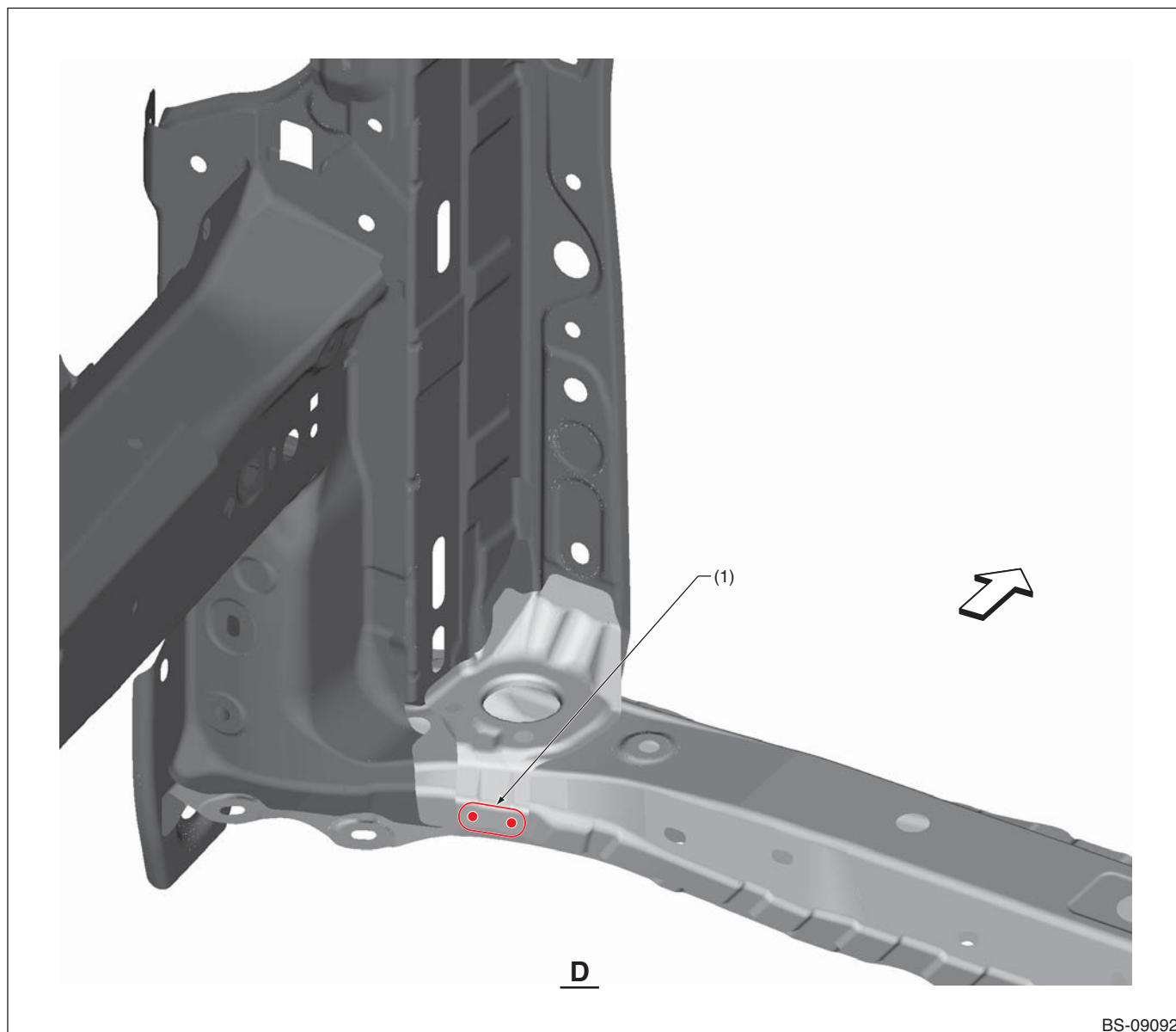


(1) 1 point (outside · 1)

(2) 2 points (inside · 1)

Panel Replacement

- View D



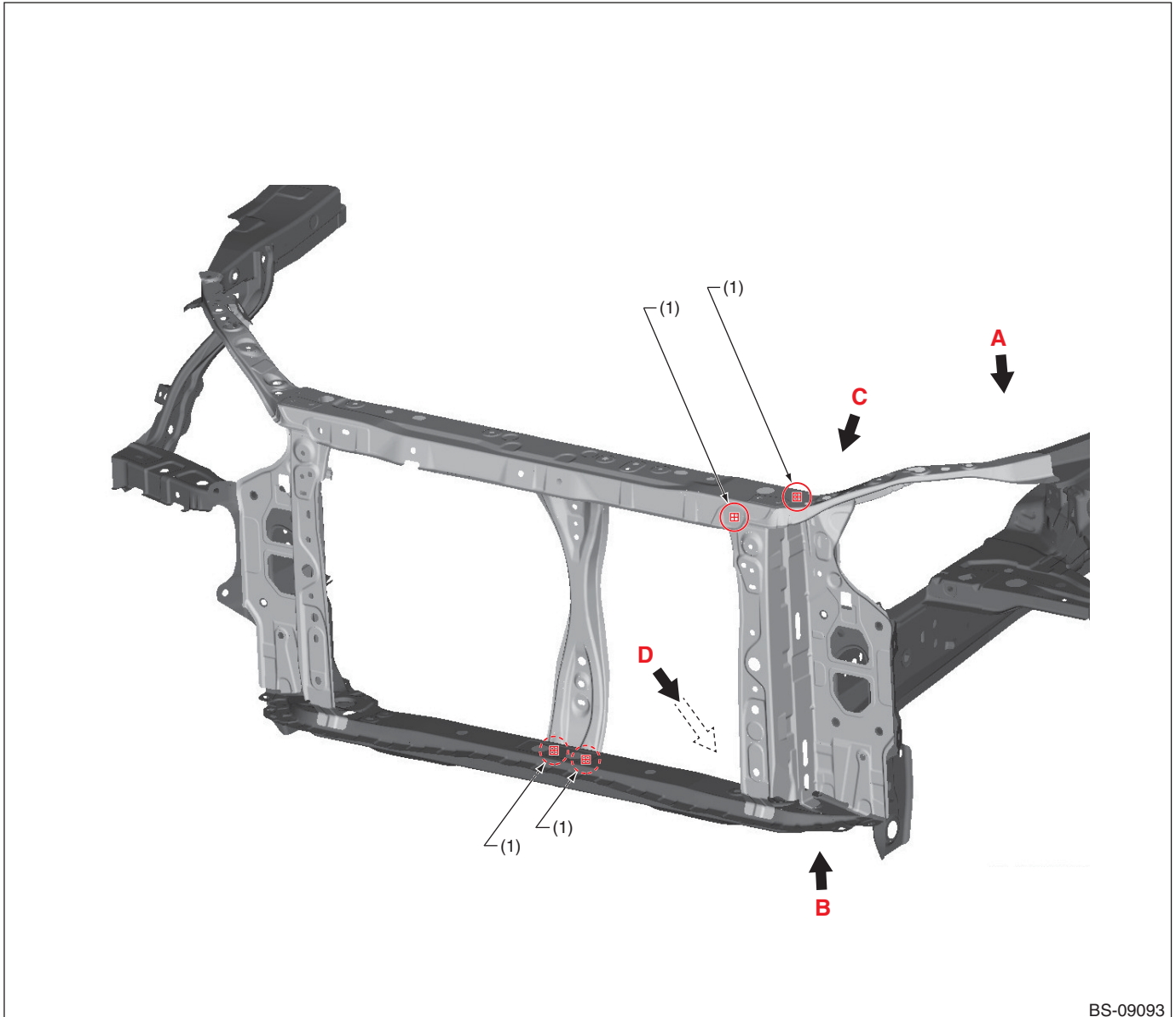
BS-09092

(1) 2 points (top - 1)

Panel Replacement

B: INSTALLATION

• Overall view

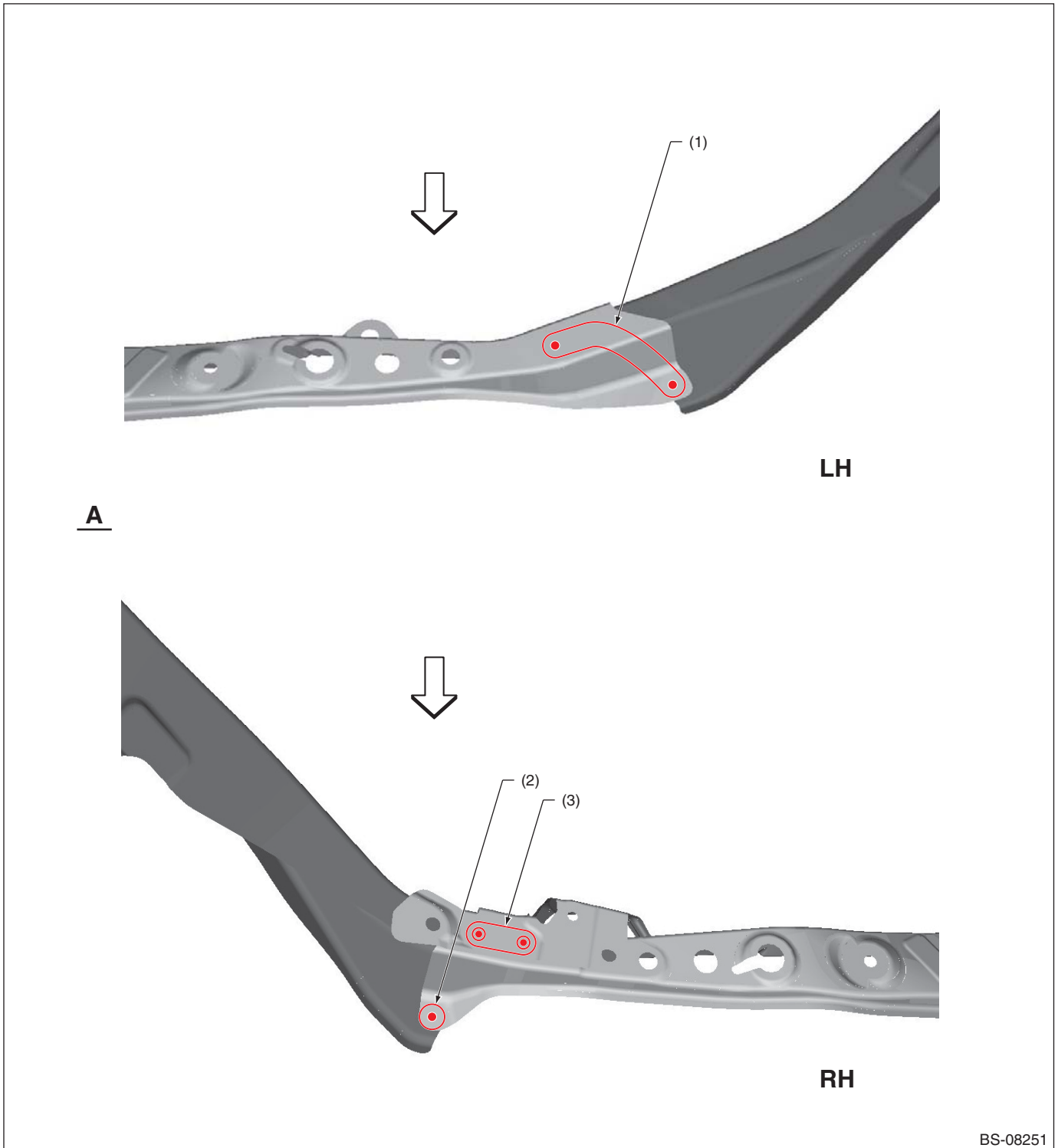


BS-09093

(1) 1 point (bolt)

Panel Replacement

• View A



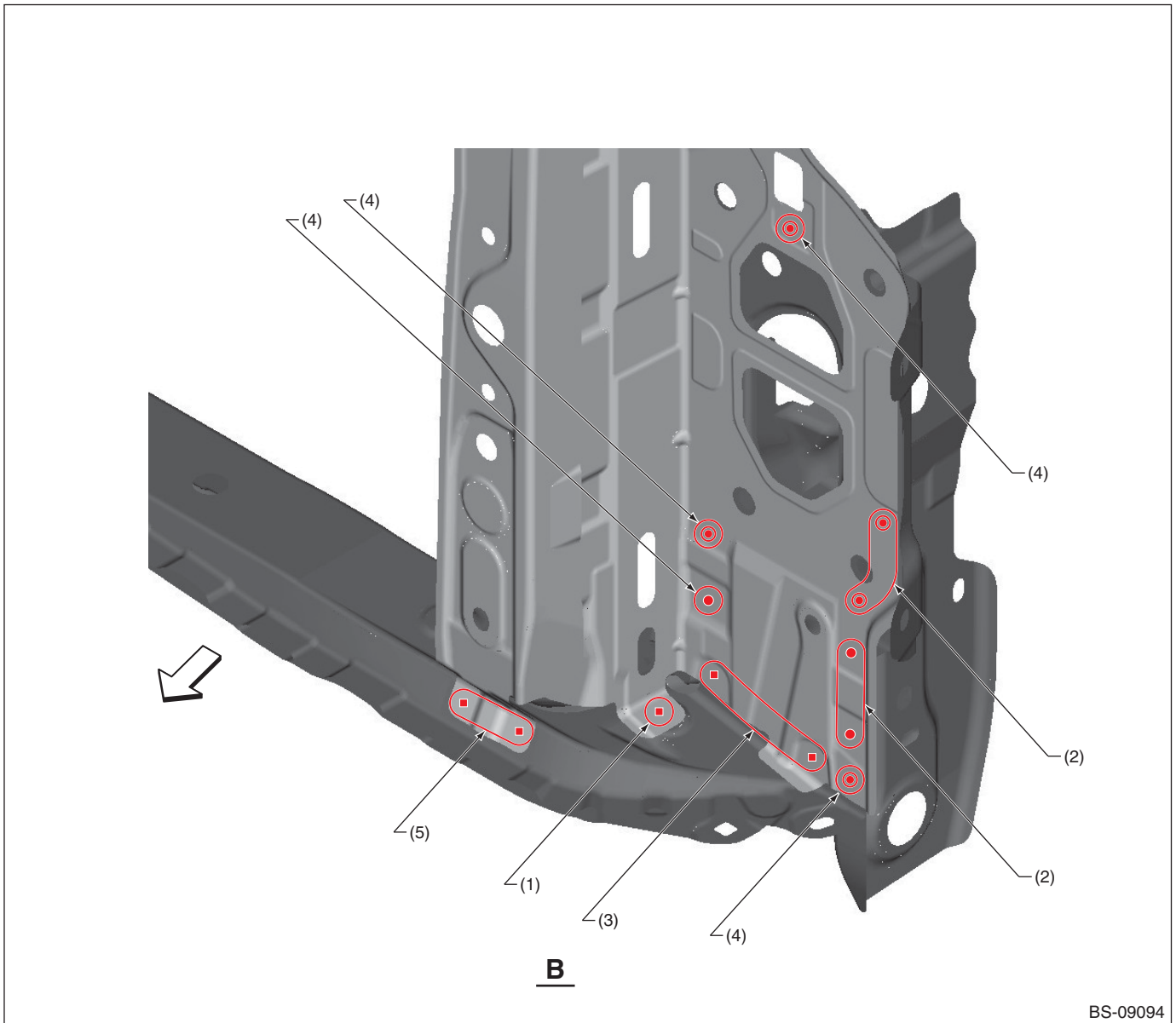
(1) 3 points

(2) 1 point

(3) 2 points

Panel Replacement

• View B



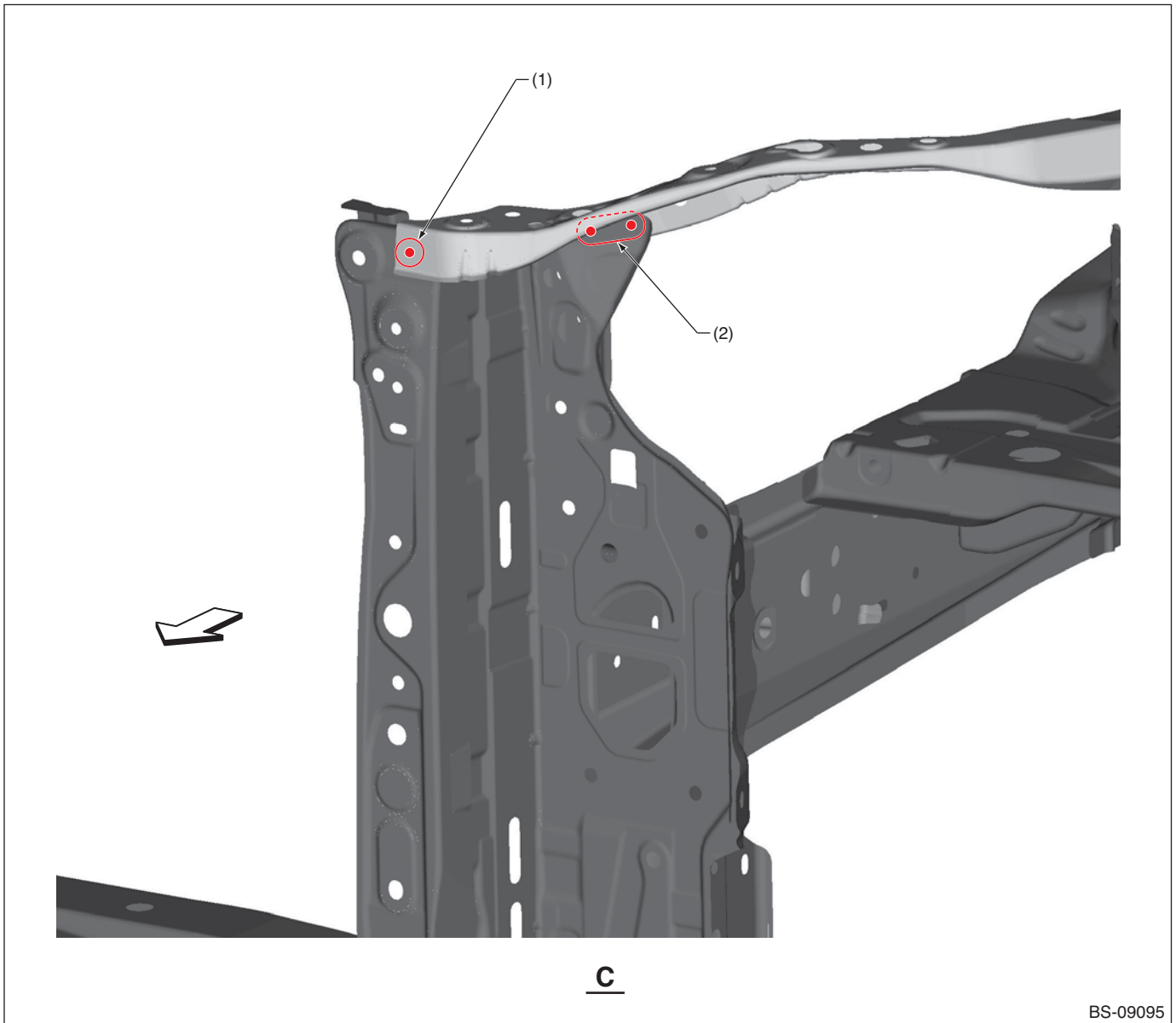
(1) 1 point (service)
(2) 2 points

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

(5) 2 points (service)

Panel Replacement

• View C

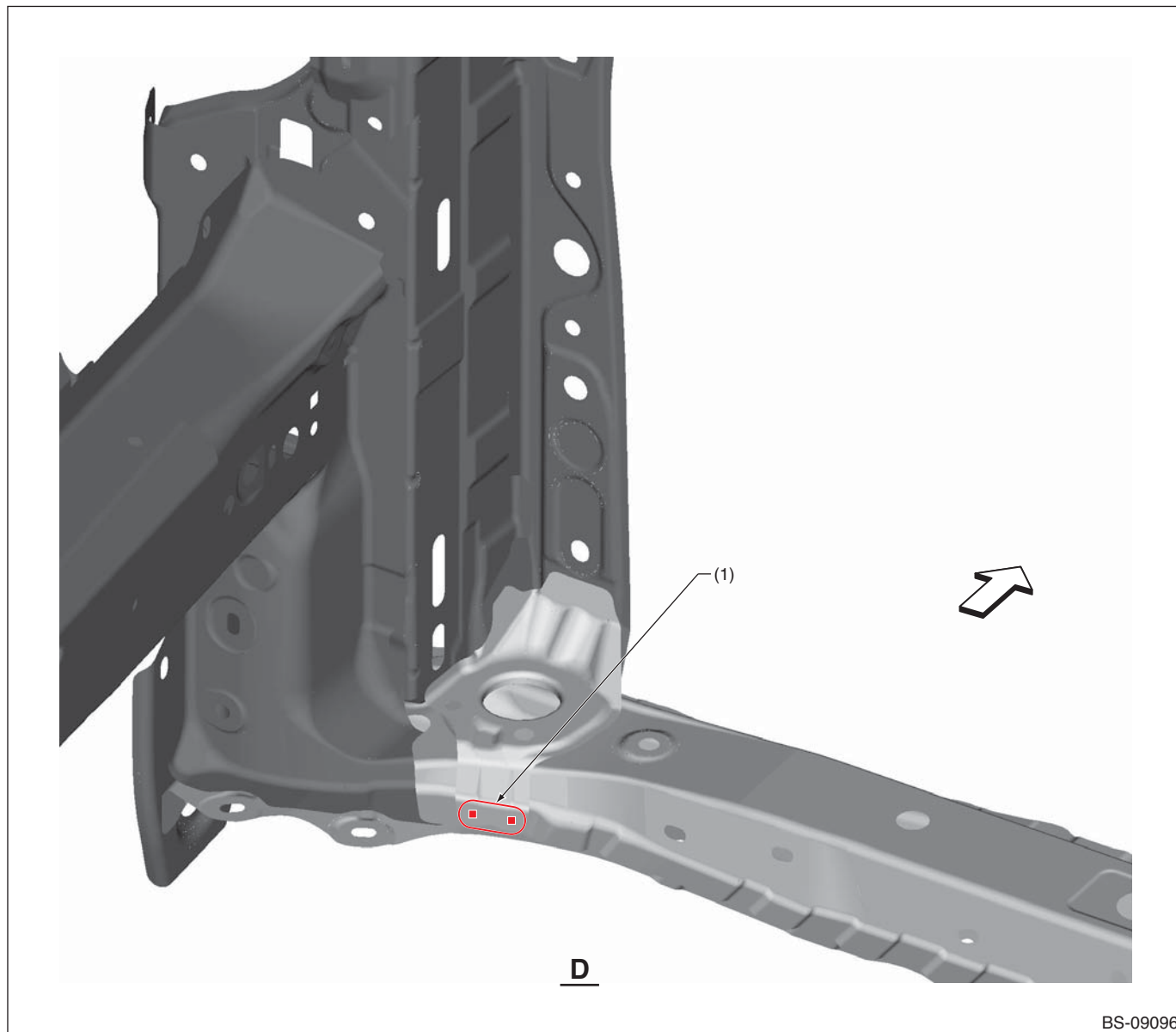


(1) 1 point

(2) 2 points

Panel Replacement

- View D

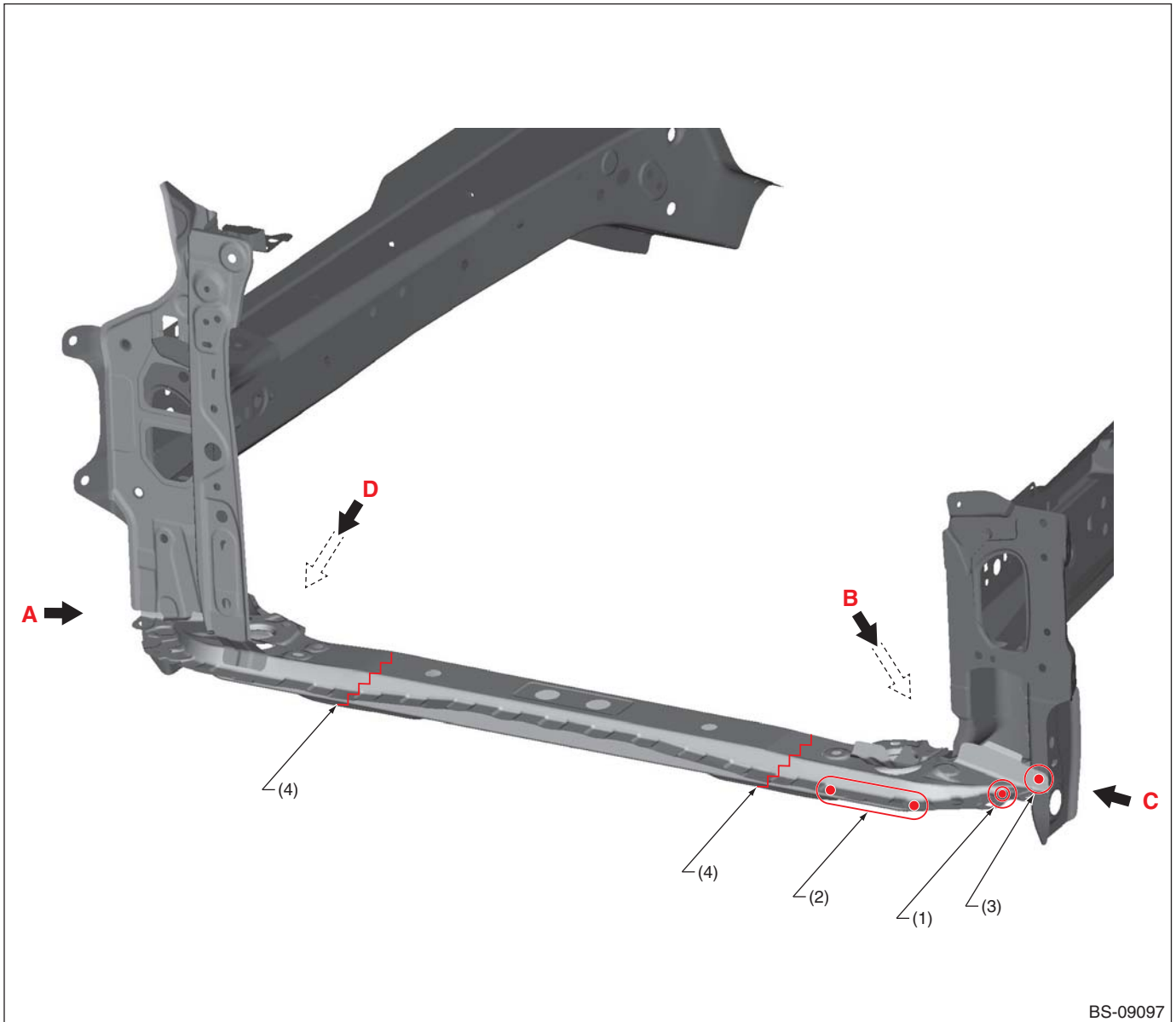


(1) 2 points (service)

8-2. Radiator Core Support (Total replacement)

A: REMOVAL

• Overall view



BS-09097

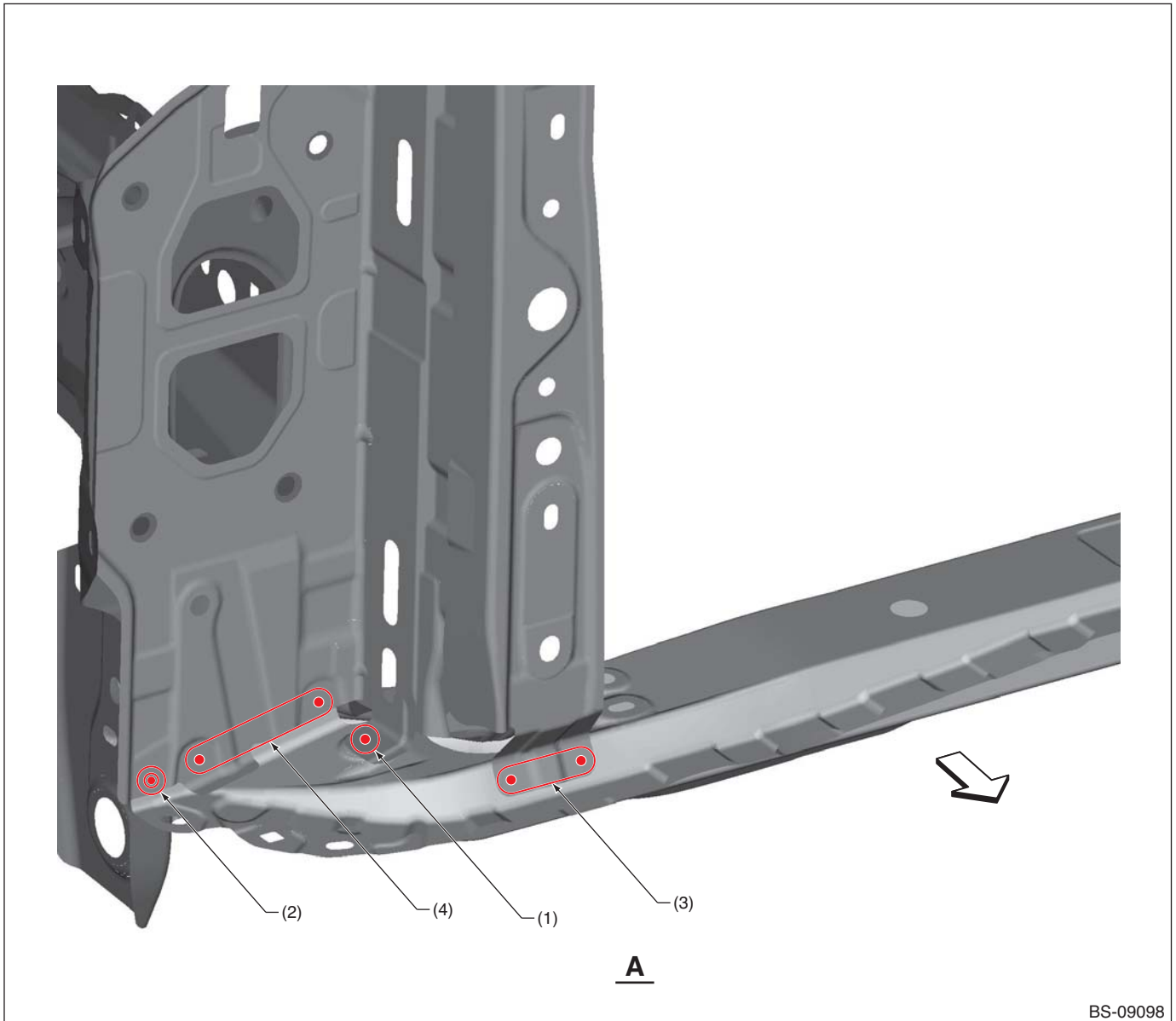
- (1) 1 point (top · 1)
(2) 3 points (top · 1)

- (3) 1 point (outside · 1)

- (4) Rough cutting

Panel Replacement

• View A



BS-09098

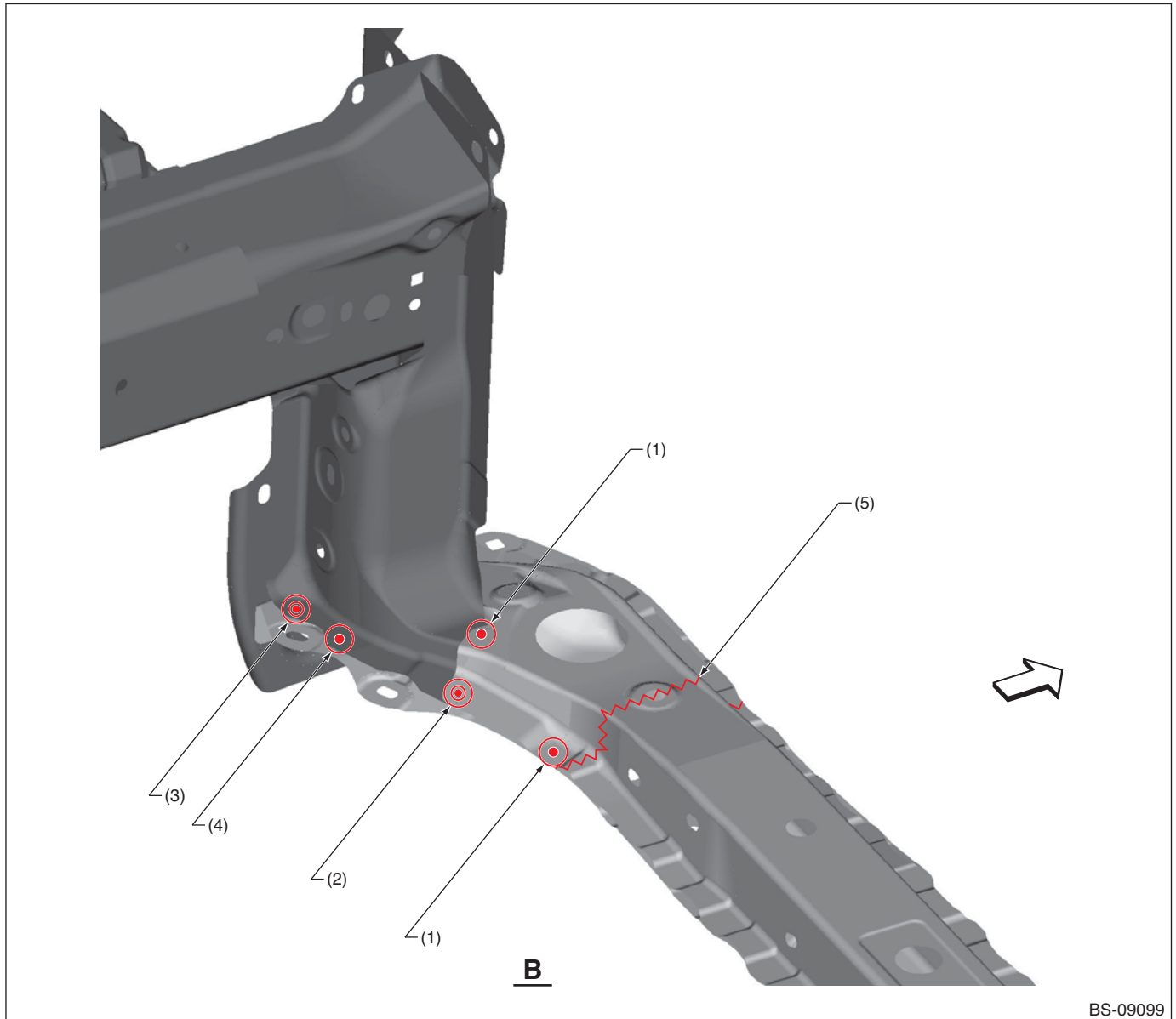
(1) 1 point (top · 1)
(2) 1 point (outside · 2)

(3) 2 points (outside · 1)

(4) 3 points (outside · 1)

Panel Replacement

• View B



(1) 1 point (top · 1)

(2) 1 point (top · 1, bottom · 1)

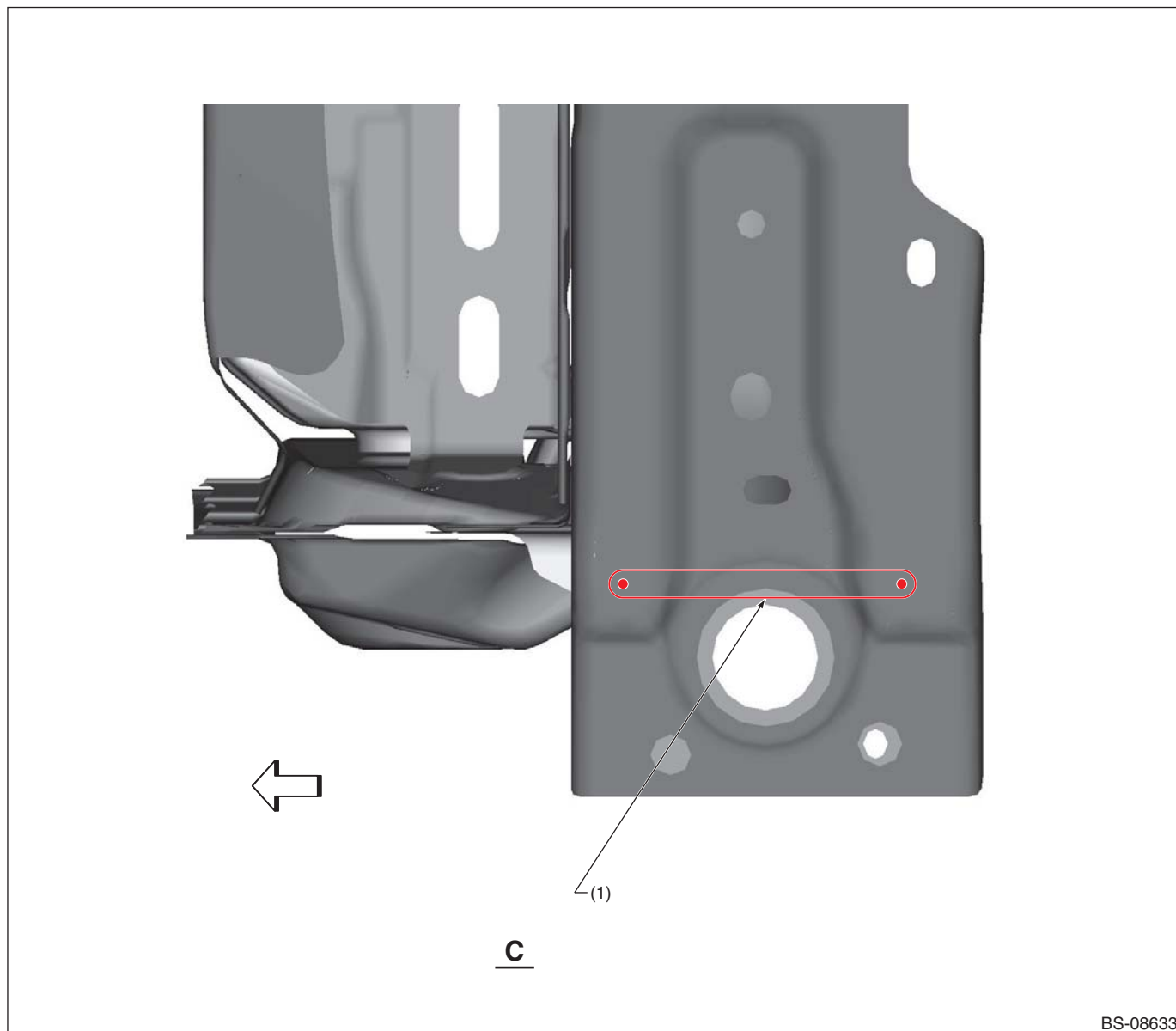
(3) 1 point (bottom · 2)

(4) 1 point (top · 1, belt sander)

(5) Rough cutting

Panel Replacement

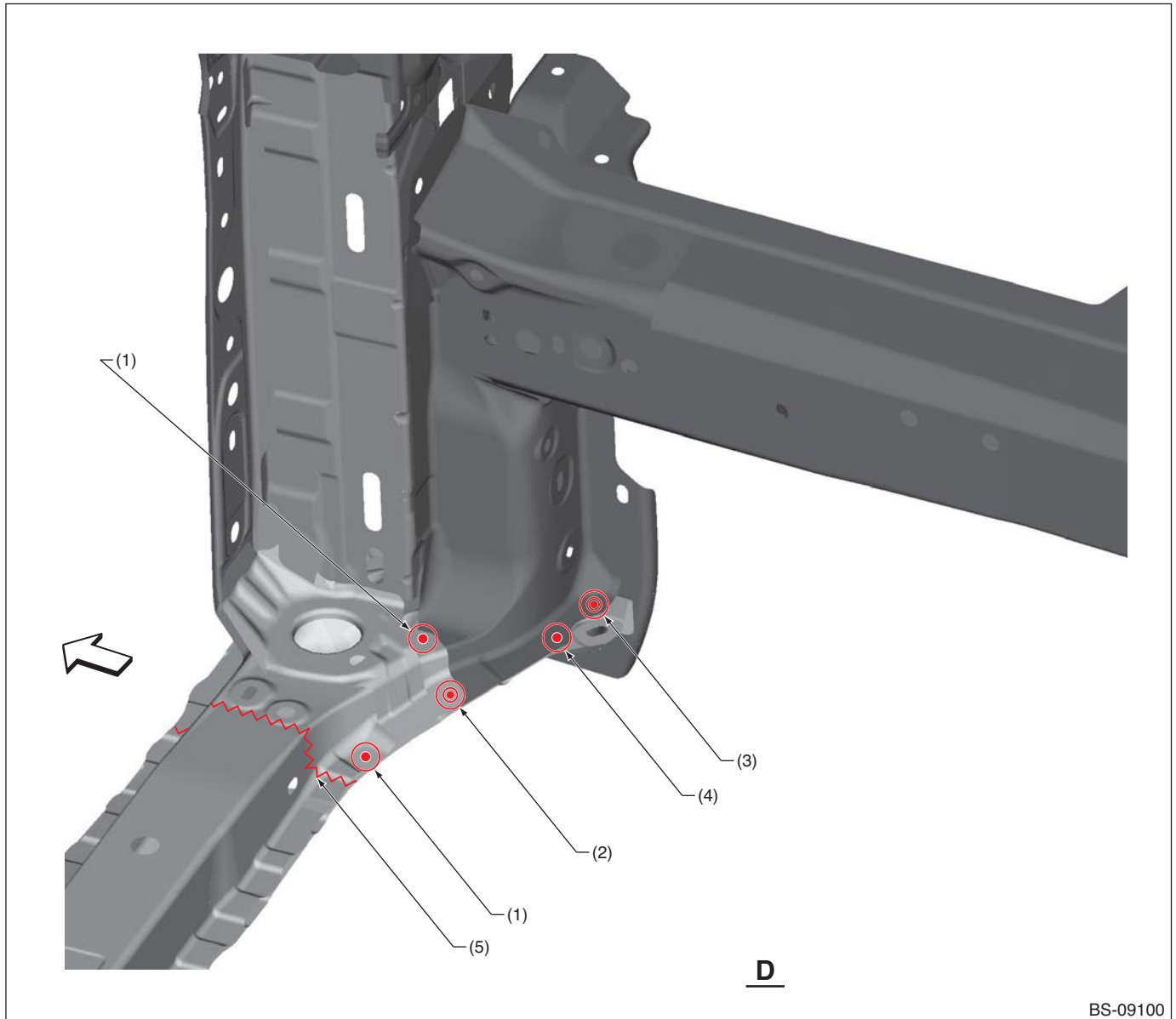
- View C



(1) 2 points (outside · 1)

Panel Replacement

• View D



BS-09100

(1) 1 point (top · 1)

(2) 1 point (top · 1, bottom · 1)

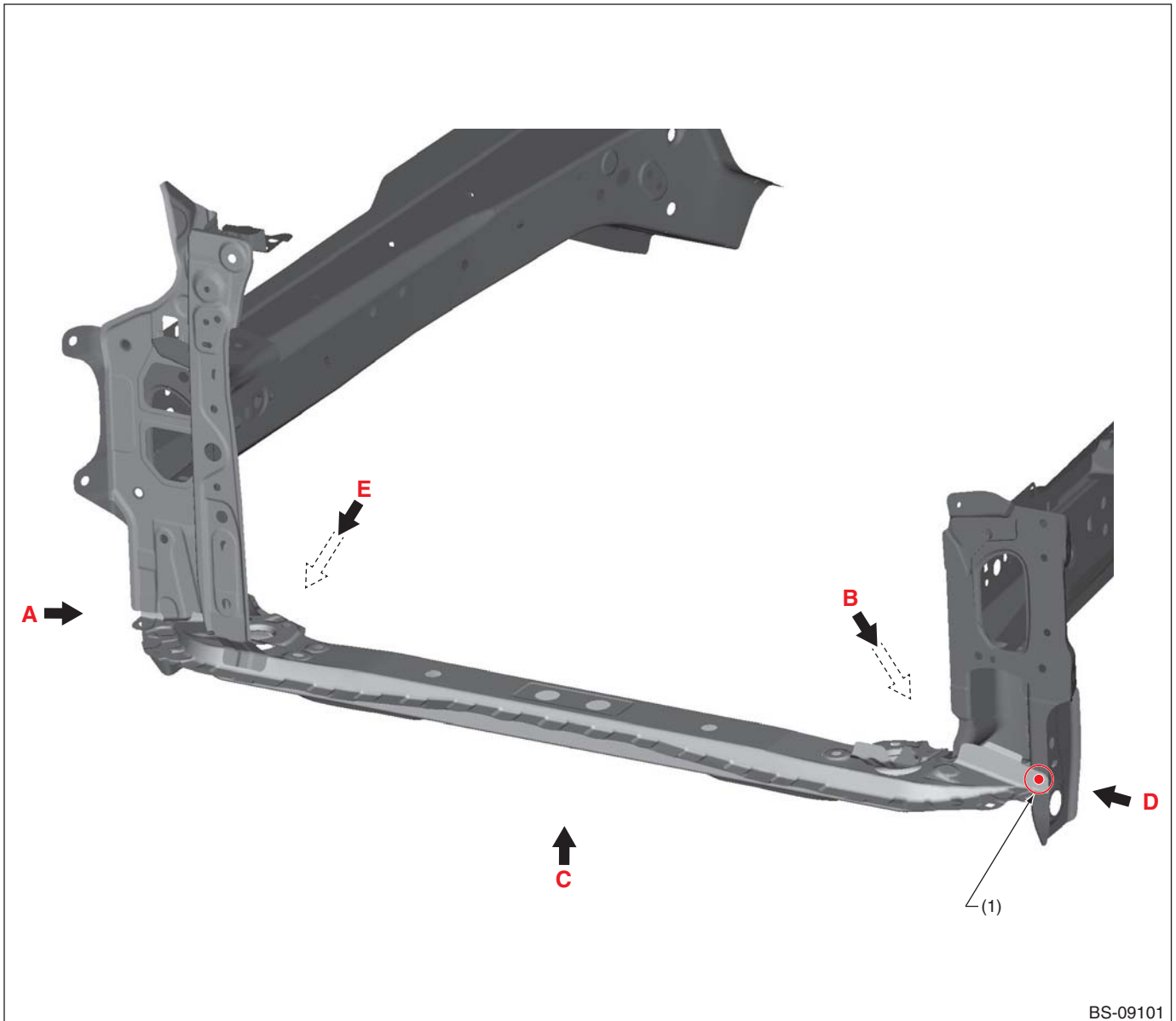
(3) 1 point (bottom · 2)

(4) 1 point (top · 1, belt sander)

(5) Rough cutting

B: INSTALLATION

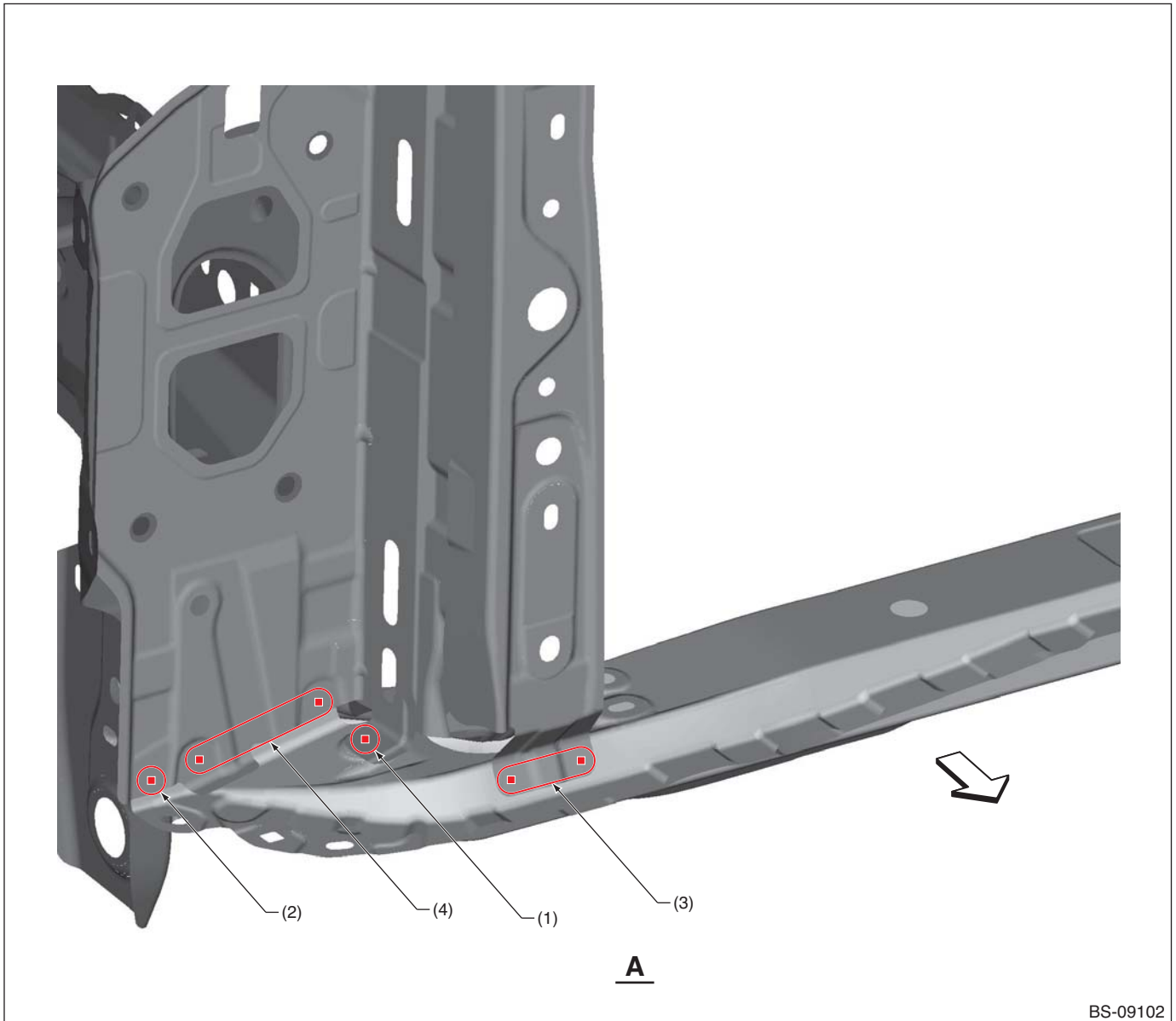
• Overall view



(1) 1 point

Panel Replacement

• View A



BS-09102

(1) 1 point (service)

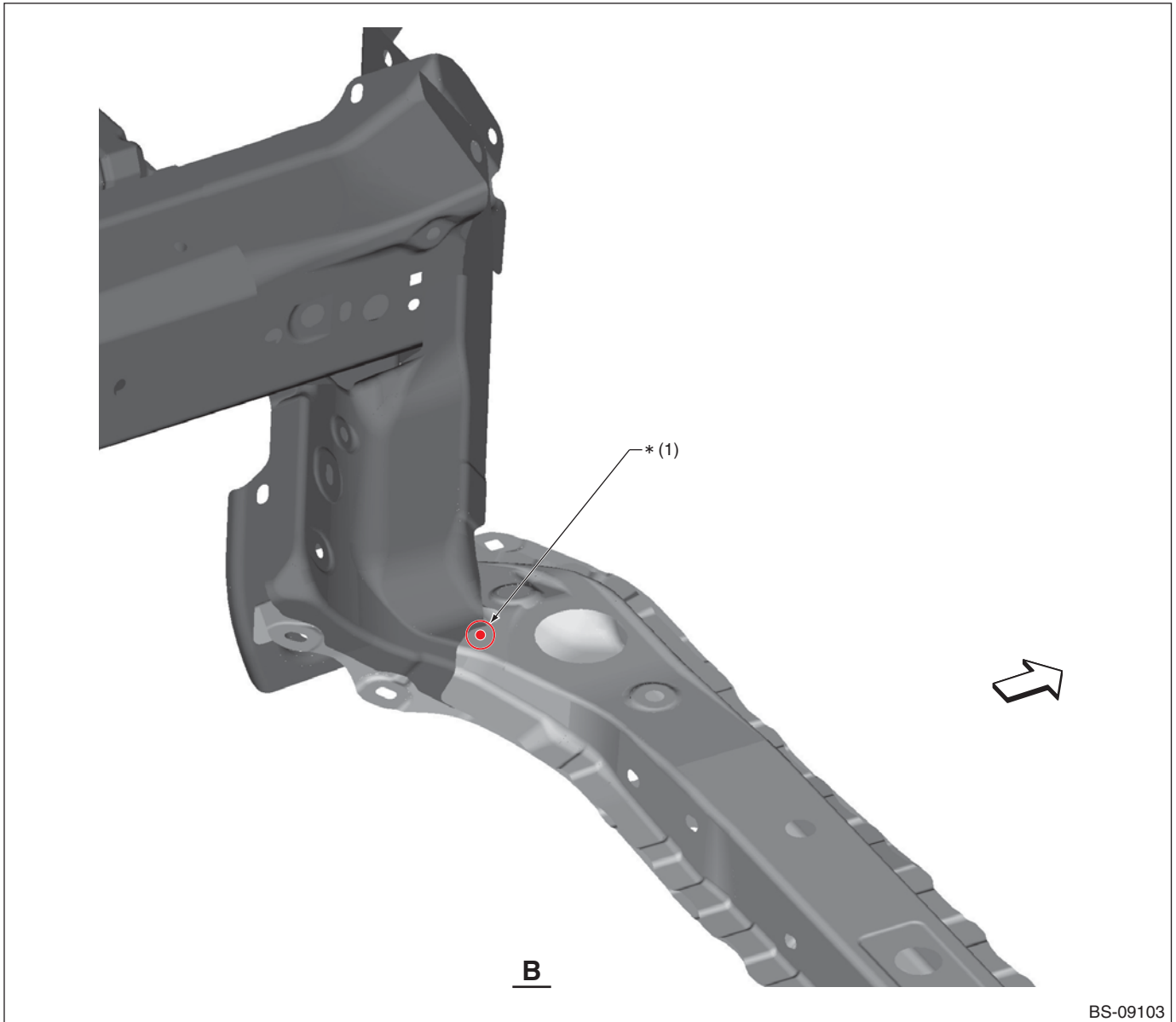
(3) 2 points (service)

(4) 3 points (service)

(2) 1 point (service · matching)

Panel Replacement

• View B



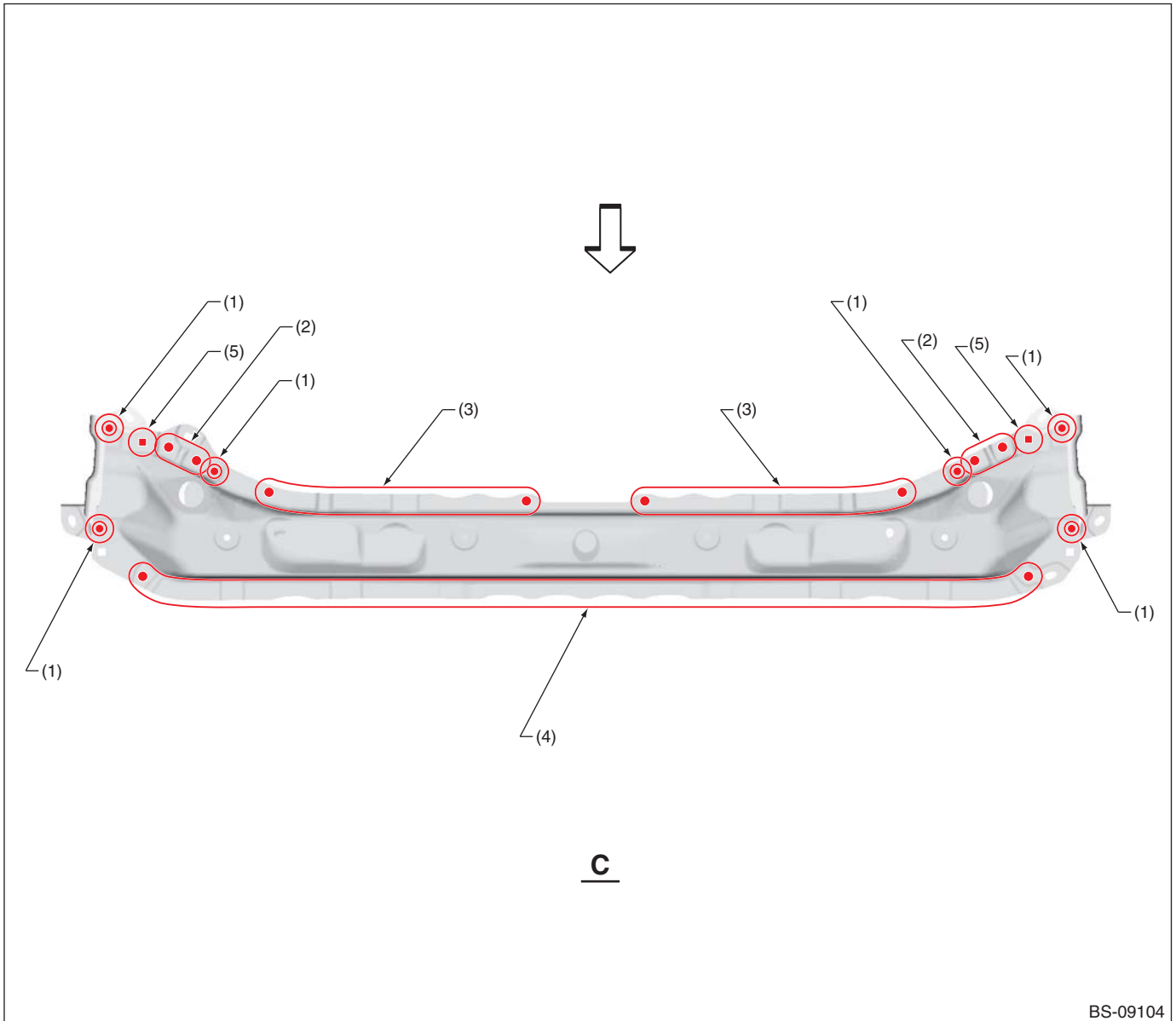
BS-09103

(1) 1 point

* : Before radiator B is installed, this point is welded.

Panel Replacement

• View C



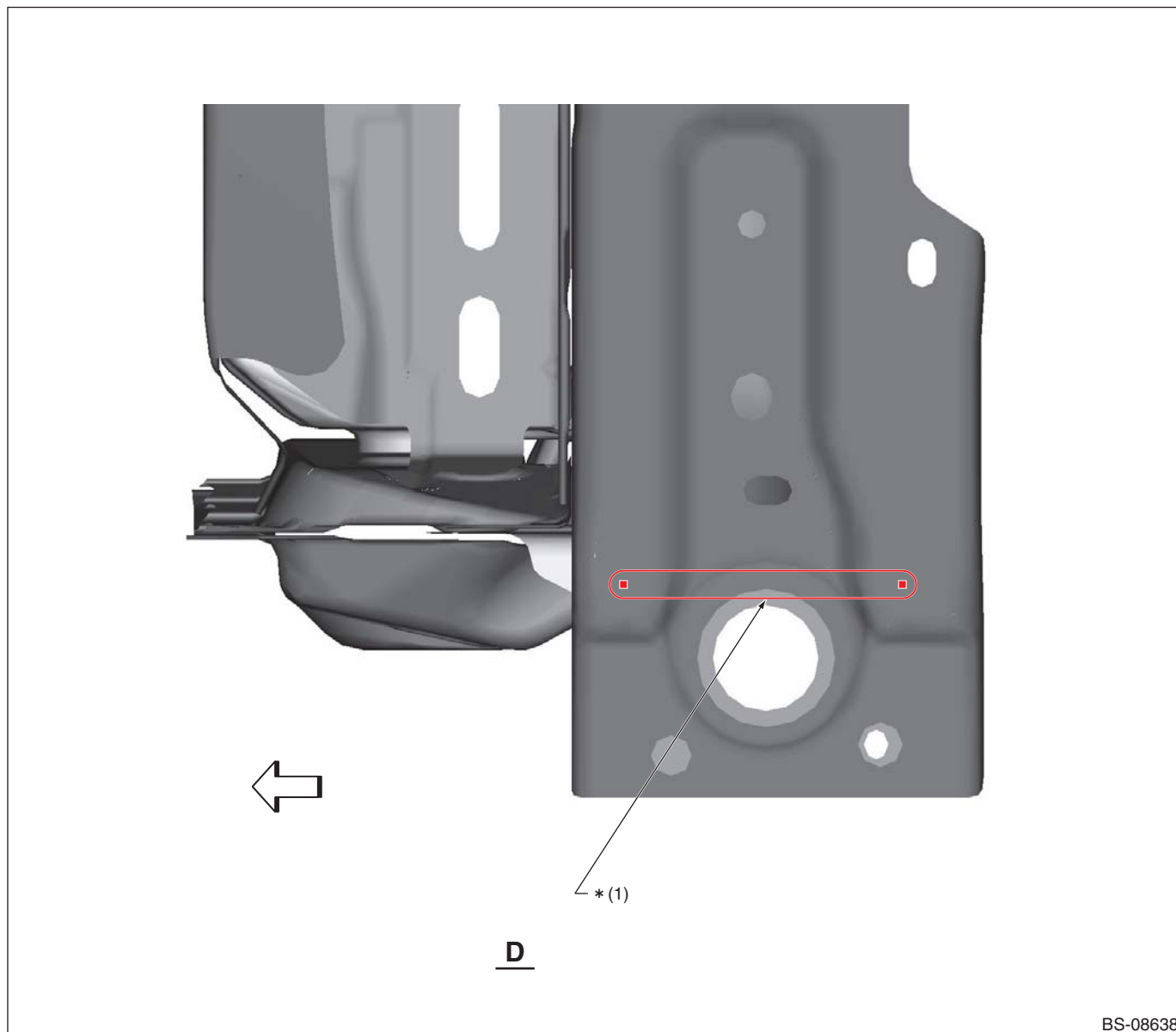
(1) 1 point
(2) 2 points

(3) 7 points
(4) 17 points

(5) 1 point (service)

Panel Replacement

• View D



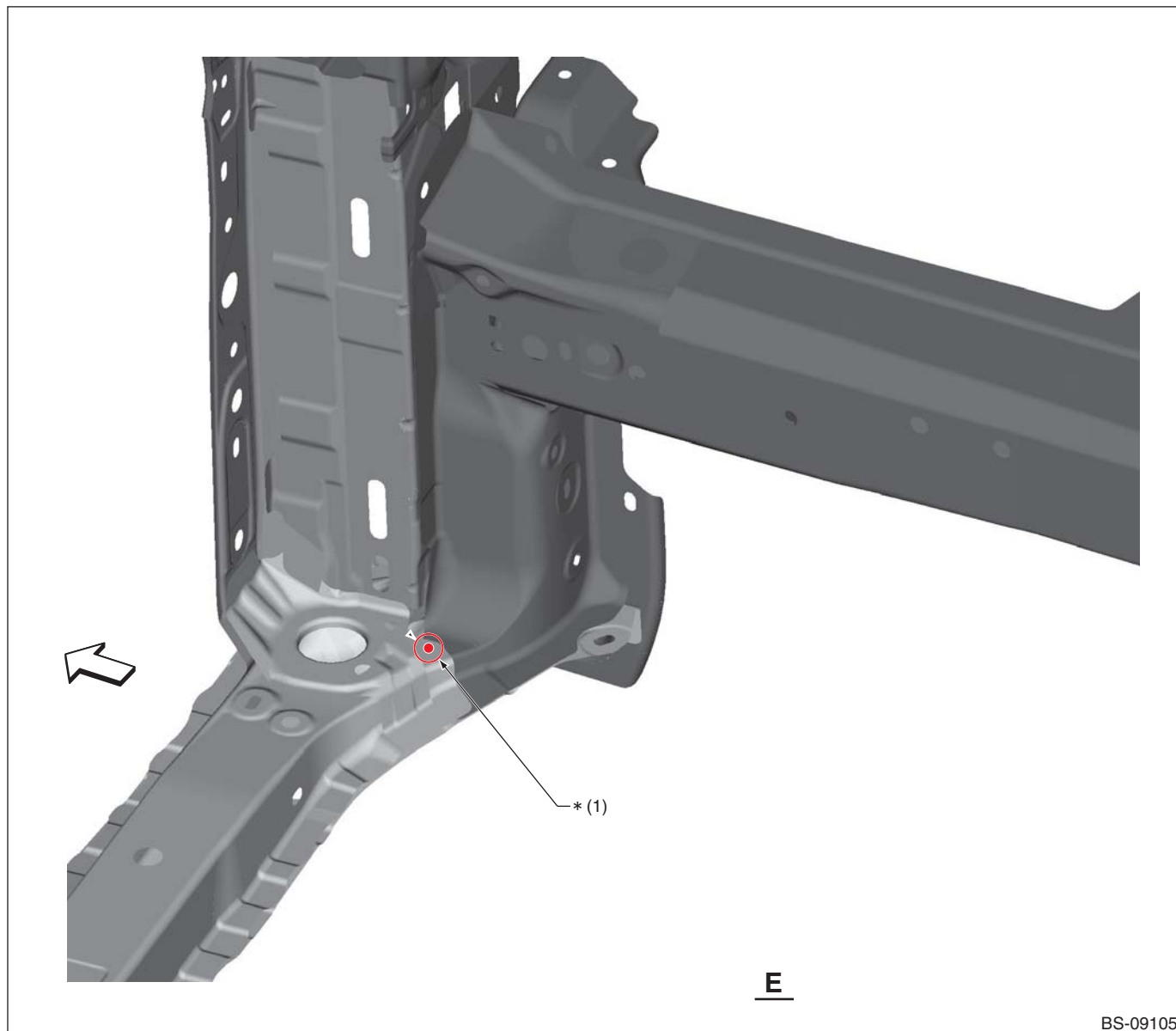
BS-08638

(1) 2 points

* : After radiator B is installed, these points are welded.

Panel Replacement

• View E



BS-09105

(1) 1 point

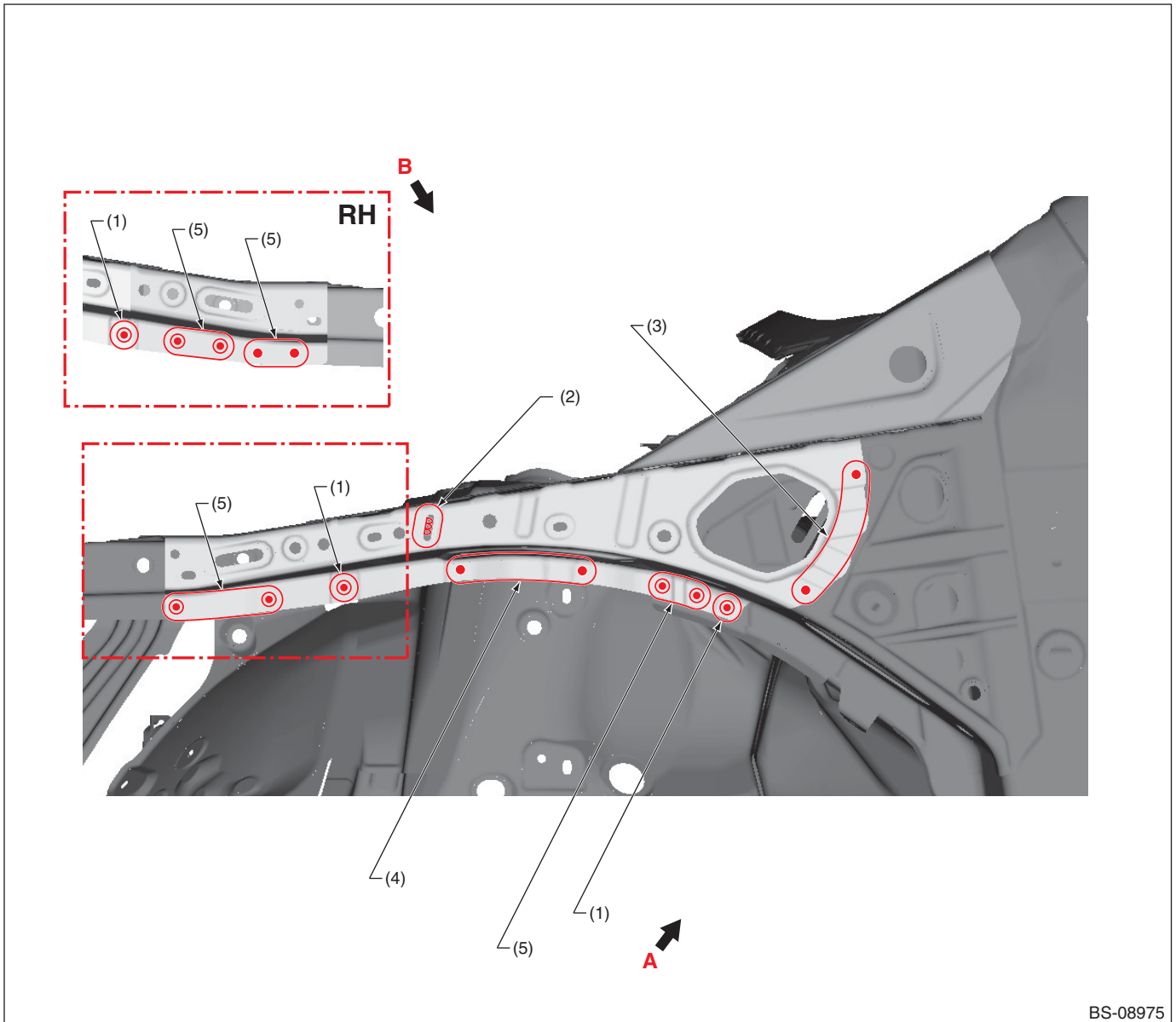
* : Before radiator B is installed, this point is welded.

Panel Replacement

8-3. Side Upper Frame (Total replacement)

A: REMOVAL

• Overall view



(1) 1 point (outside · 2)

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

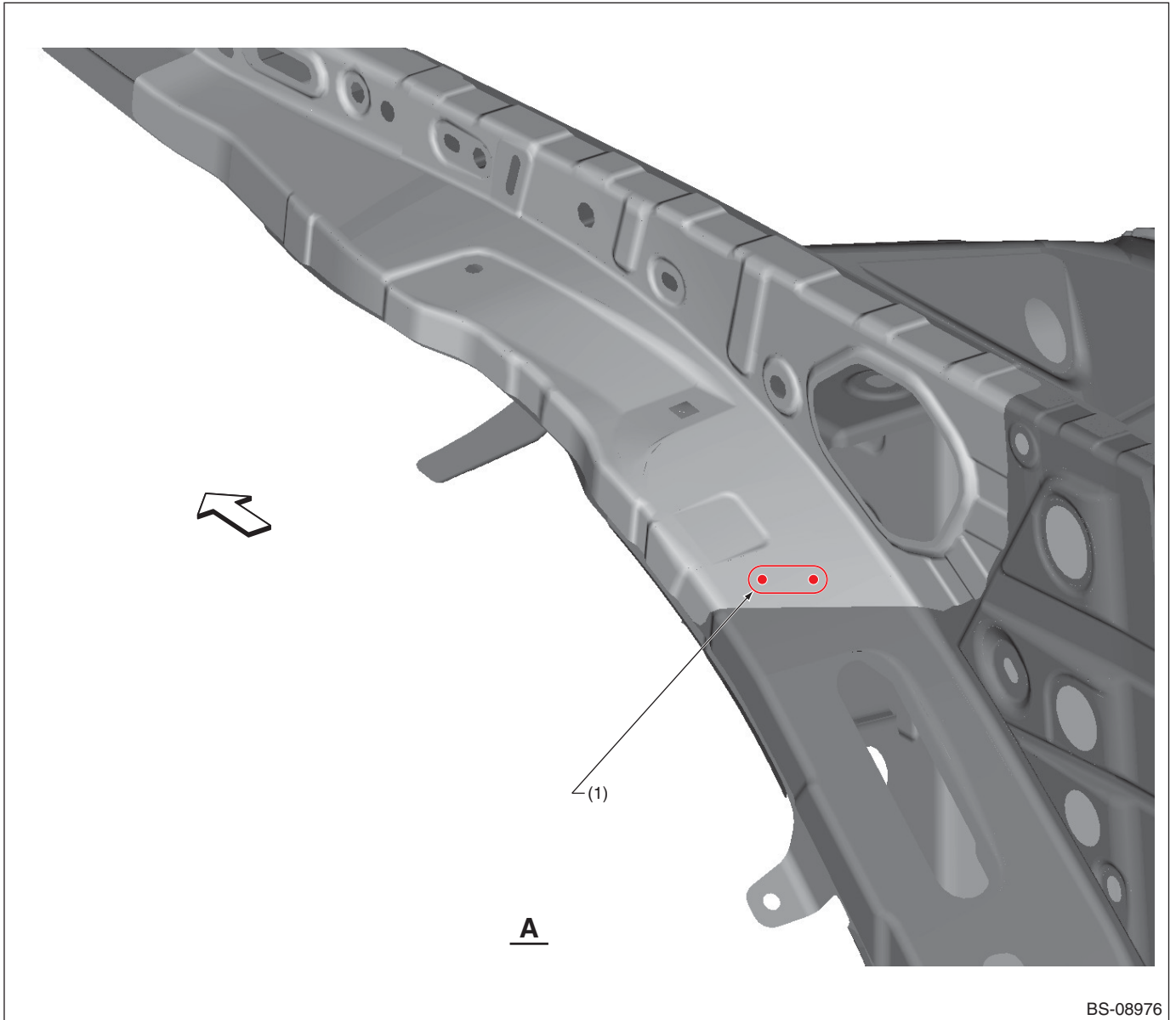
(3) 4 points (outside · 1)

(4) 3 points (outside · 1)

(5) 2 points (outside · 1)

Panel Replacement

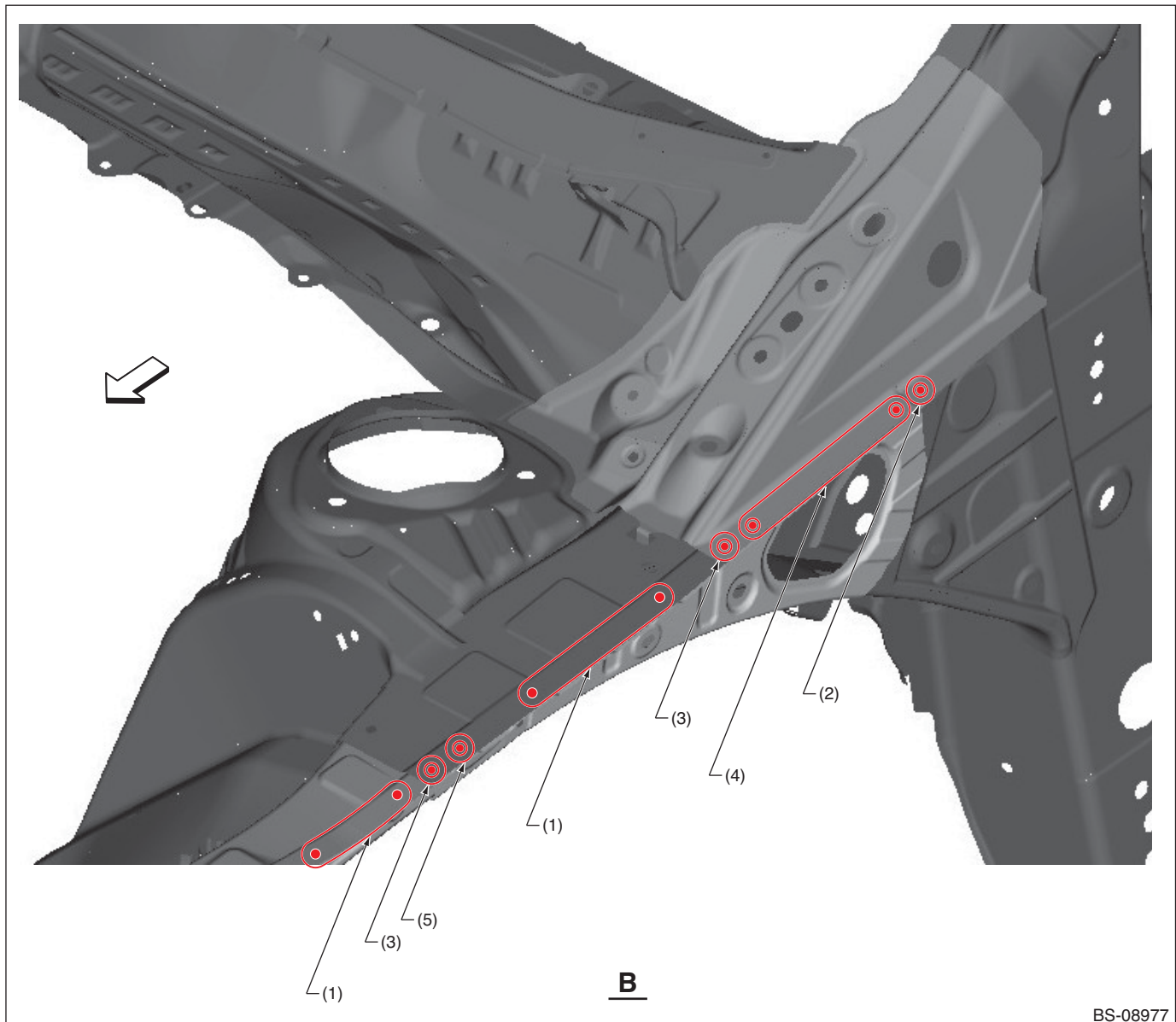
• View A



(1) 2 points (outside · 1)

Panel Replacement

• View B

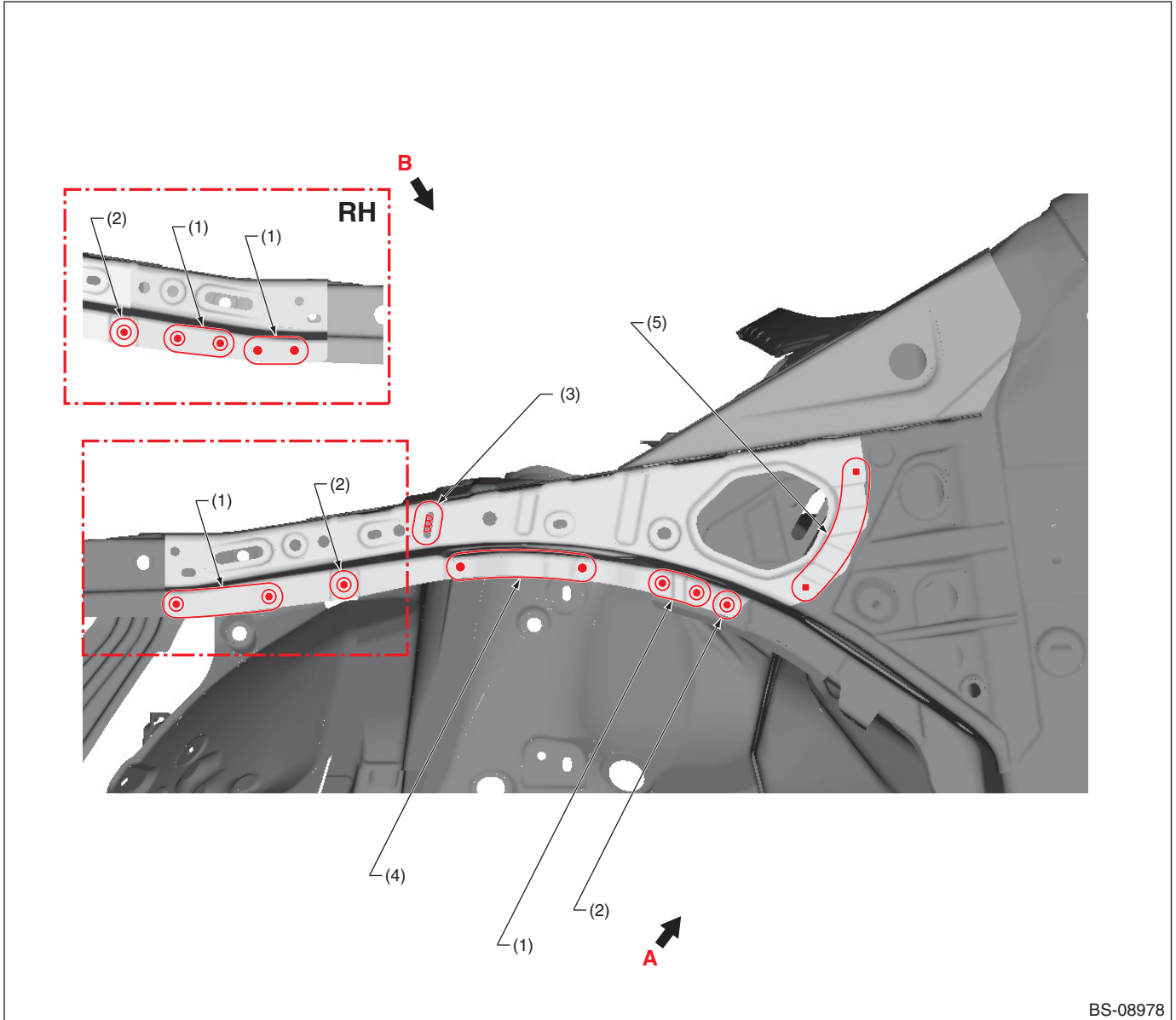


- | | | |
|---------------------------------------|--|--------------------------|
| (1) 3 points (bottom · 1) | (3) 1 point (bottom · 1) | (5) 1 point (bottom · 2) |
| (2) 1 point (bottom · 1, belt sander) | (4) 3 points (bottom · 1, belt sander) | |

Panel Replacement

B: INSTALLATION

• Overall view



(1) 2 points

(2) 1 point

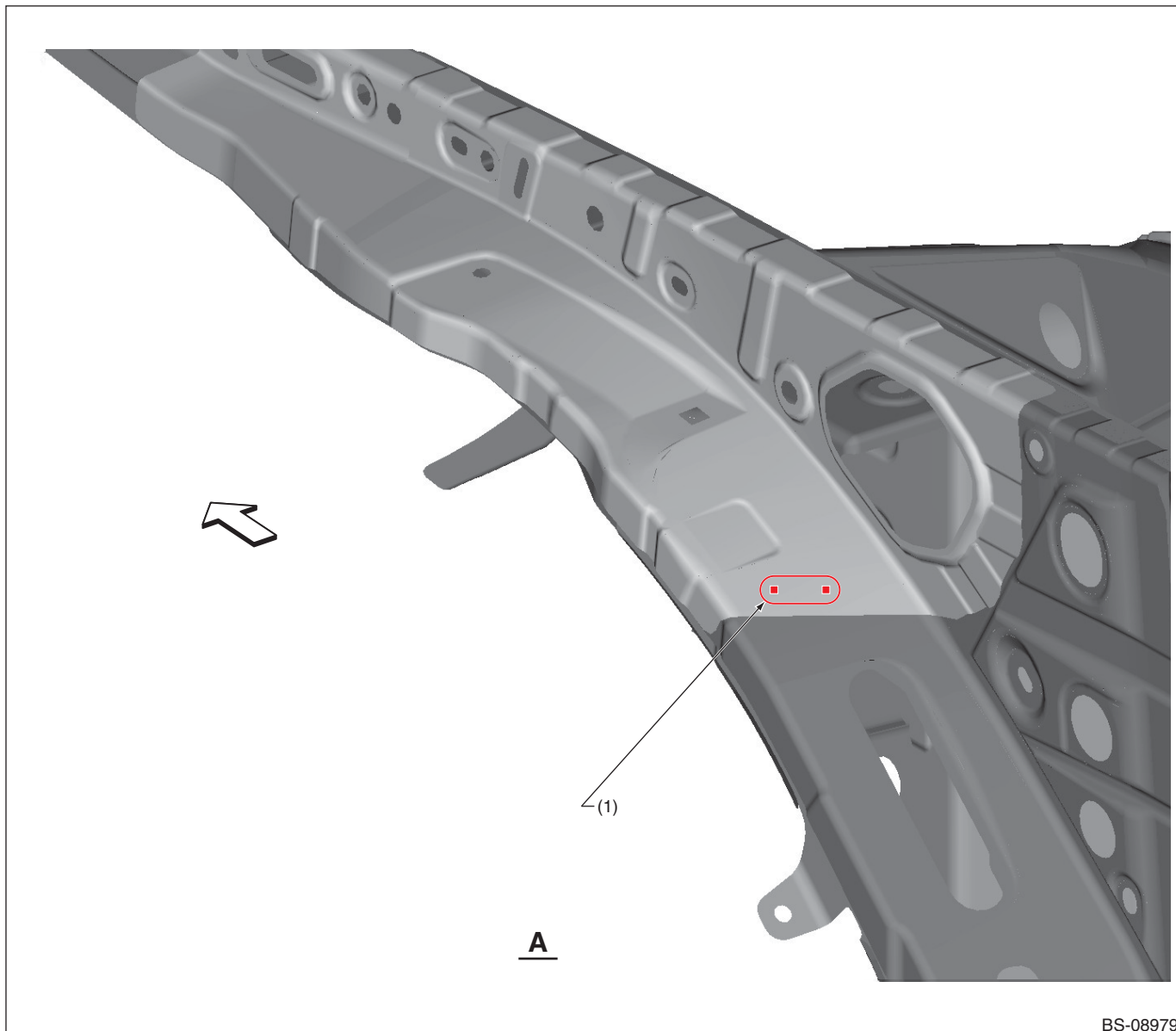
(3) 1 point (Continuous welding)
[20 mm (0.79 in)]

(4) 3 points

(5) 4 points (service)

Panel Replacement

- View A

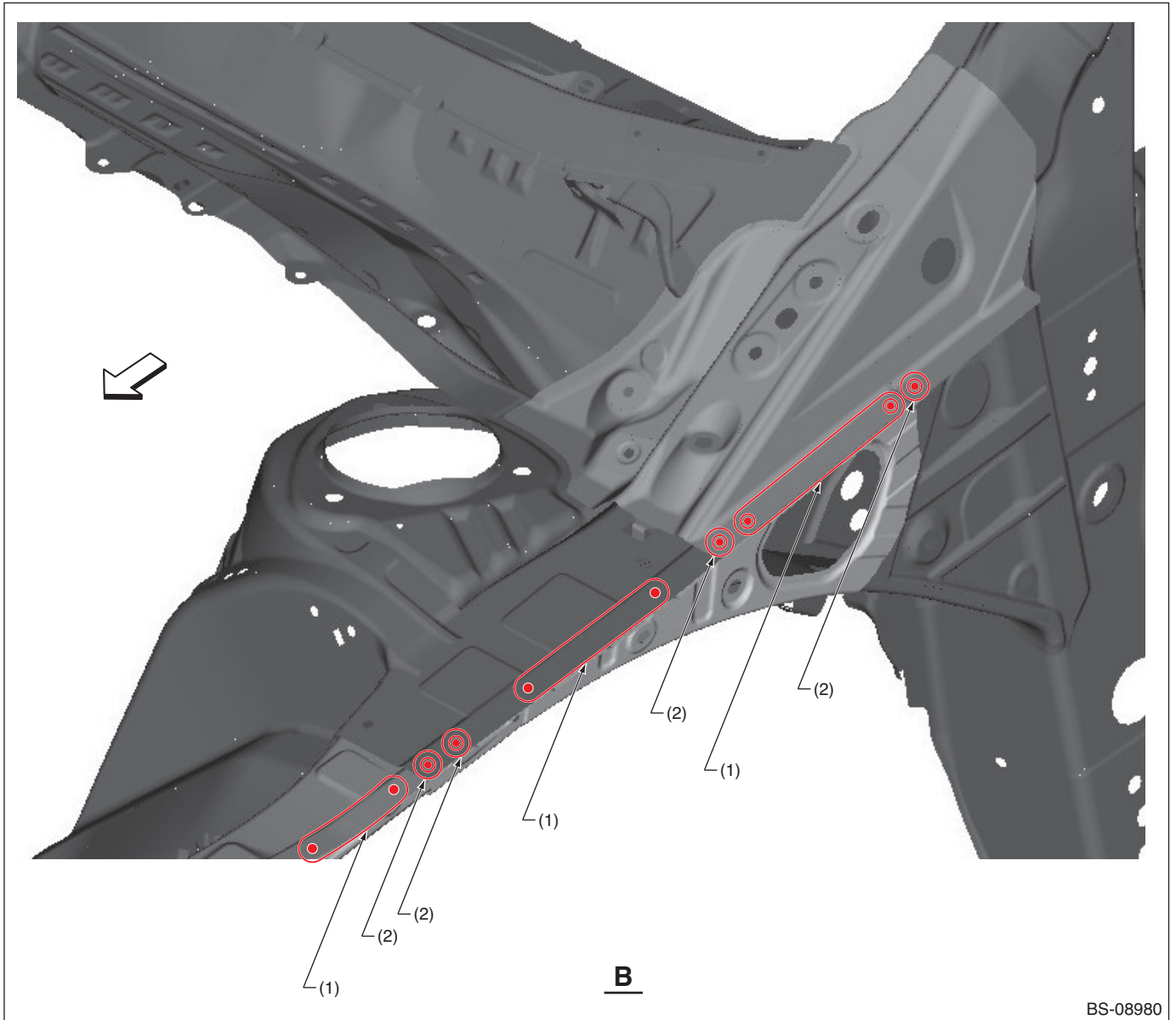


BS-08979

(1) 2 points (service)

Panel Replacement

• View B



BS-08980

(1) 3 points

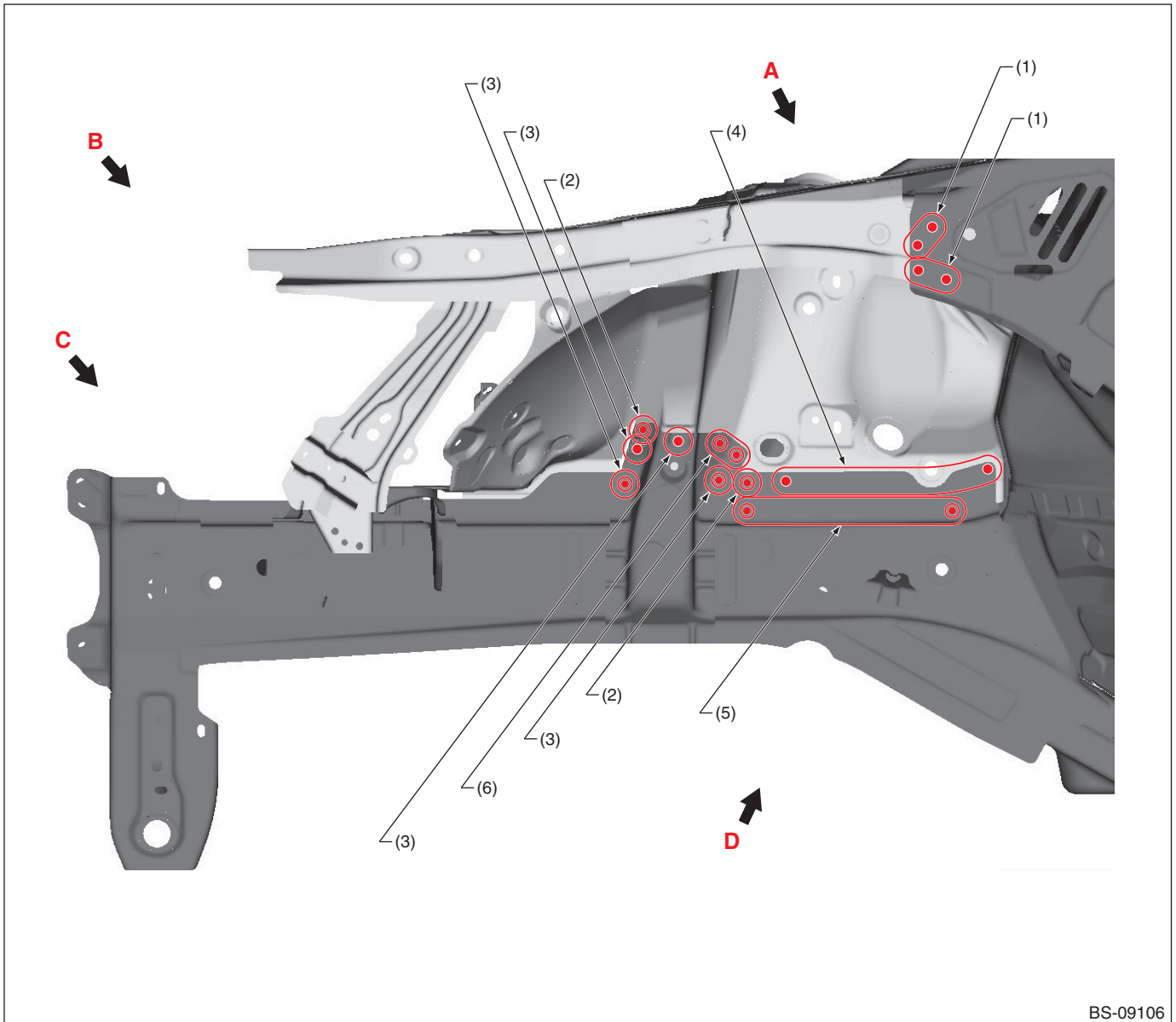
(2) 1 point

Panel Replacement

8-4. Front Wheel Apron (Total replacement)

A: REMOVAL

• Overall view



(1) 2 points (outside · 1)

(2) 1 point (inside · 2)

(3) 1 point (inside · 1)

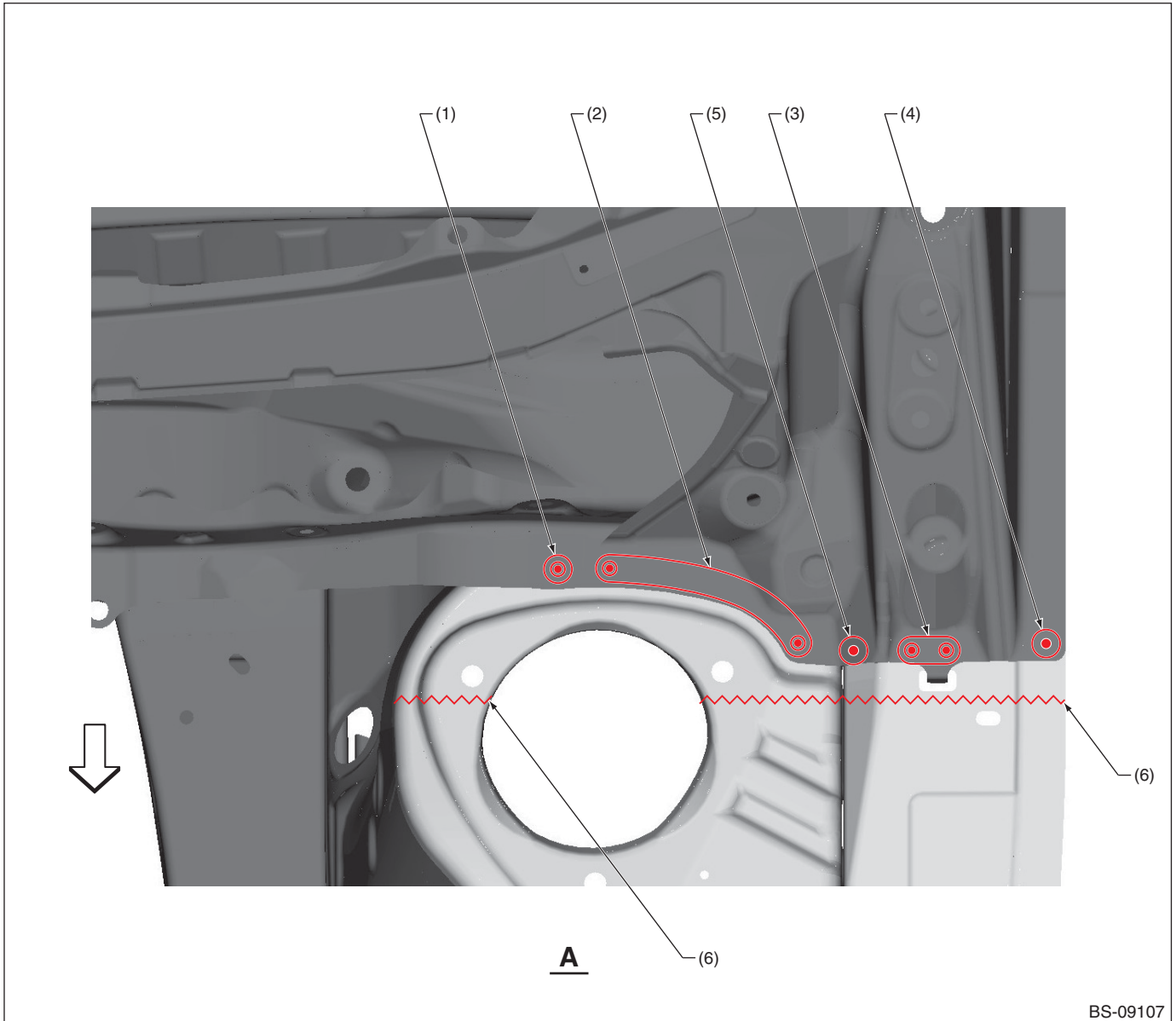
(4) 6 points (inside · 1)

(5) 4 points (inside · 1)

(6) 2 points (inside · 2)

Panel Replacement

• View A



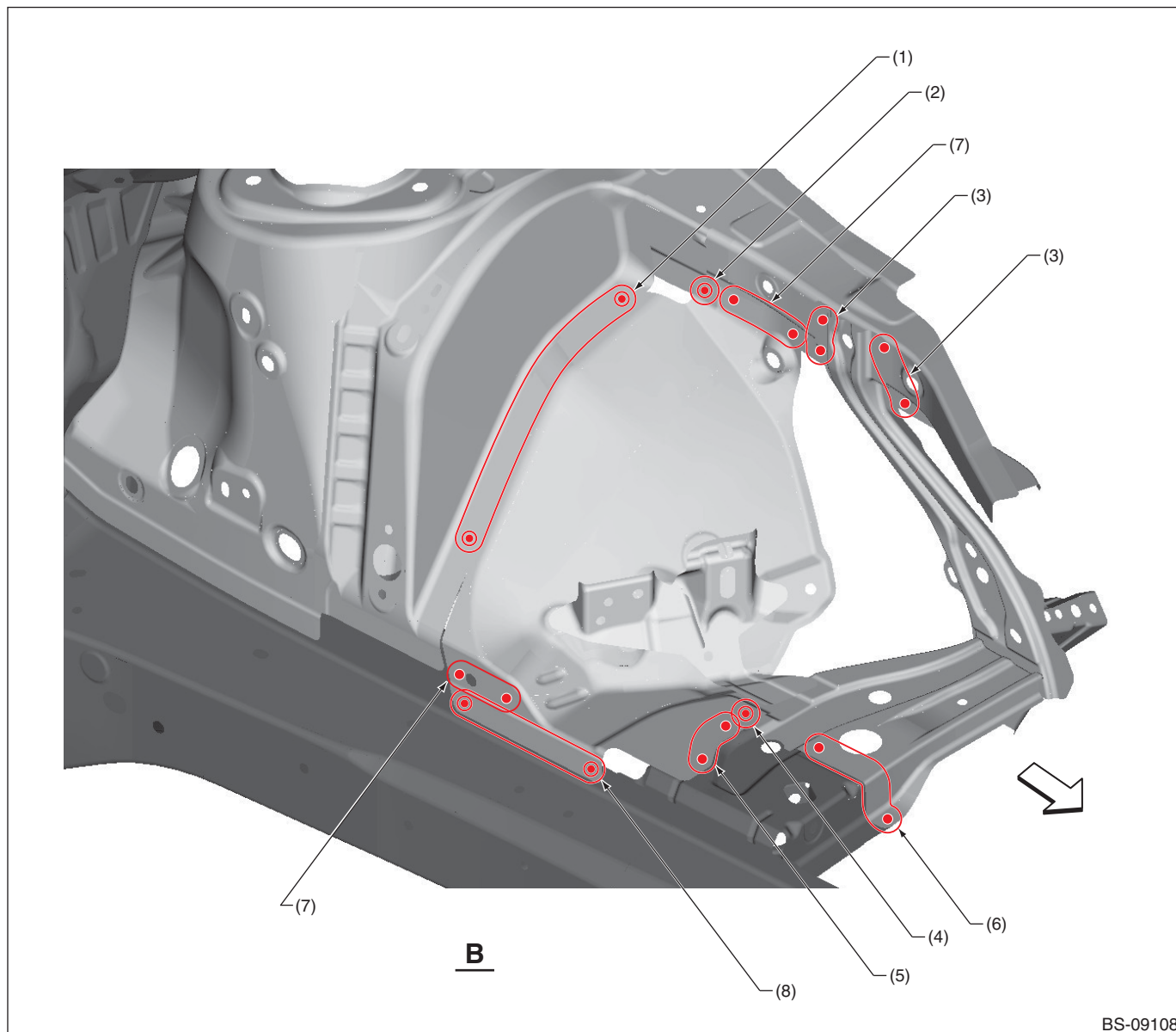
(1) 1 point (top · 2)
(2) 4 points (top · 2)

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

(5) 1 point (inside · 1)
(6) Rough cutting

Panel Replacement

• View B (LH)



BS-09108

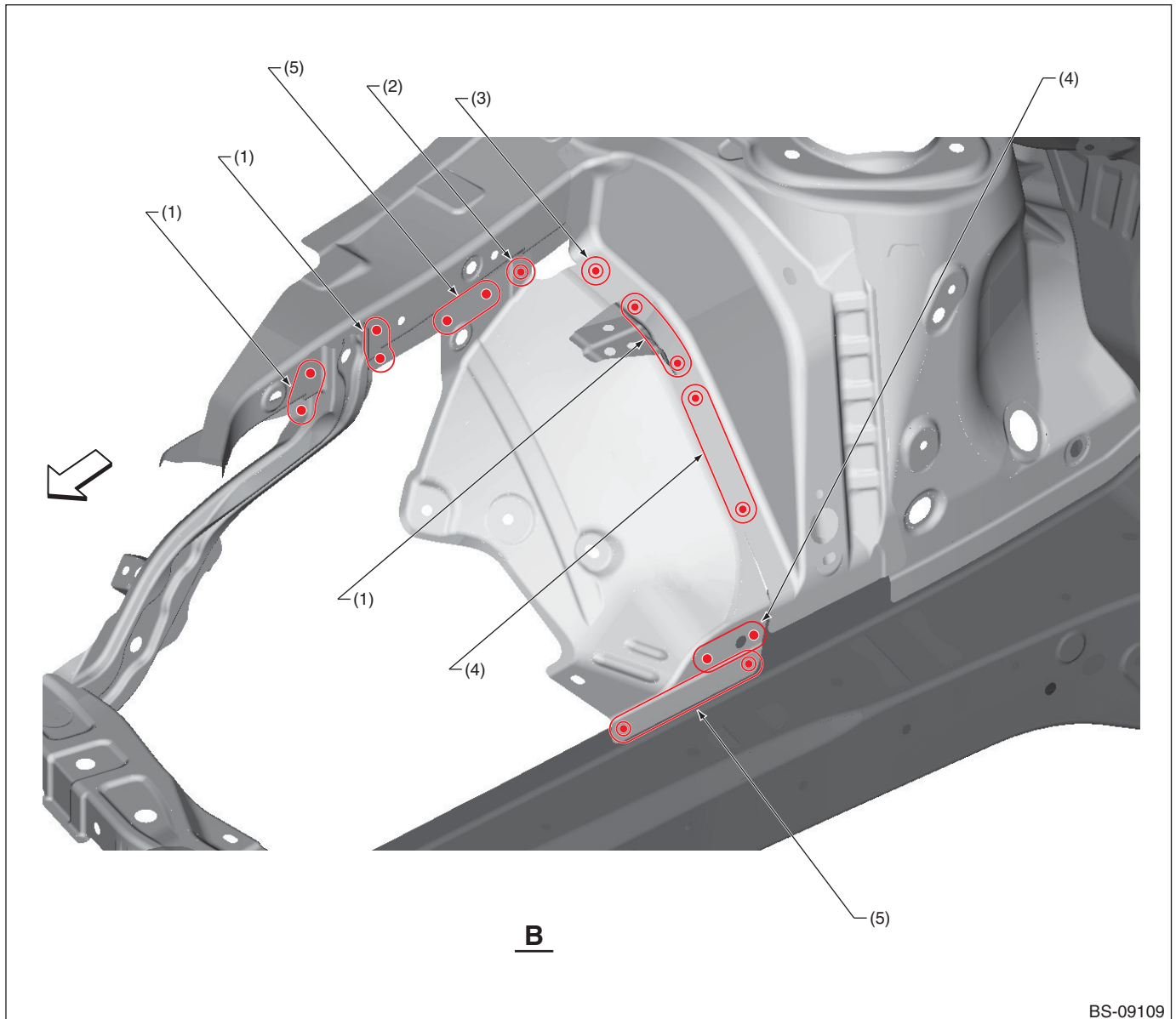
- (1) 5 points (top · 1)
- (2) 1 point (inside · 1)
- (3) 2 points (inside · 1)

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

- (7) 3 points (inside · 1)
- (8) 4 points (inside · 1)

Panel Replacement

• View B (RH)



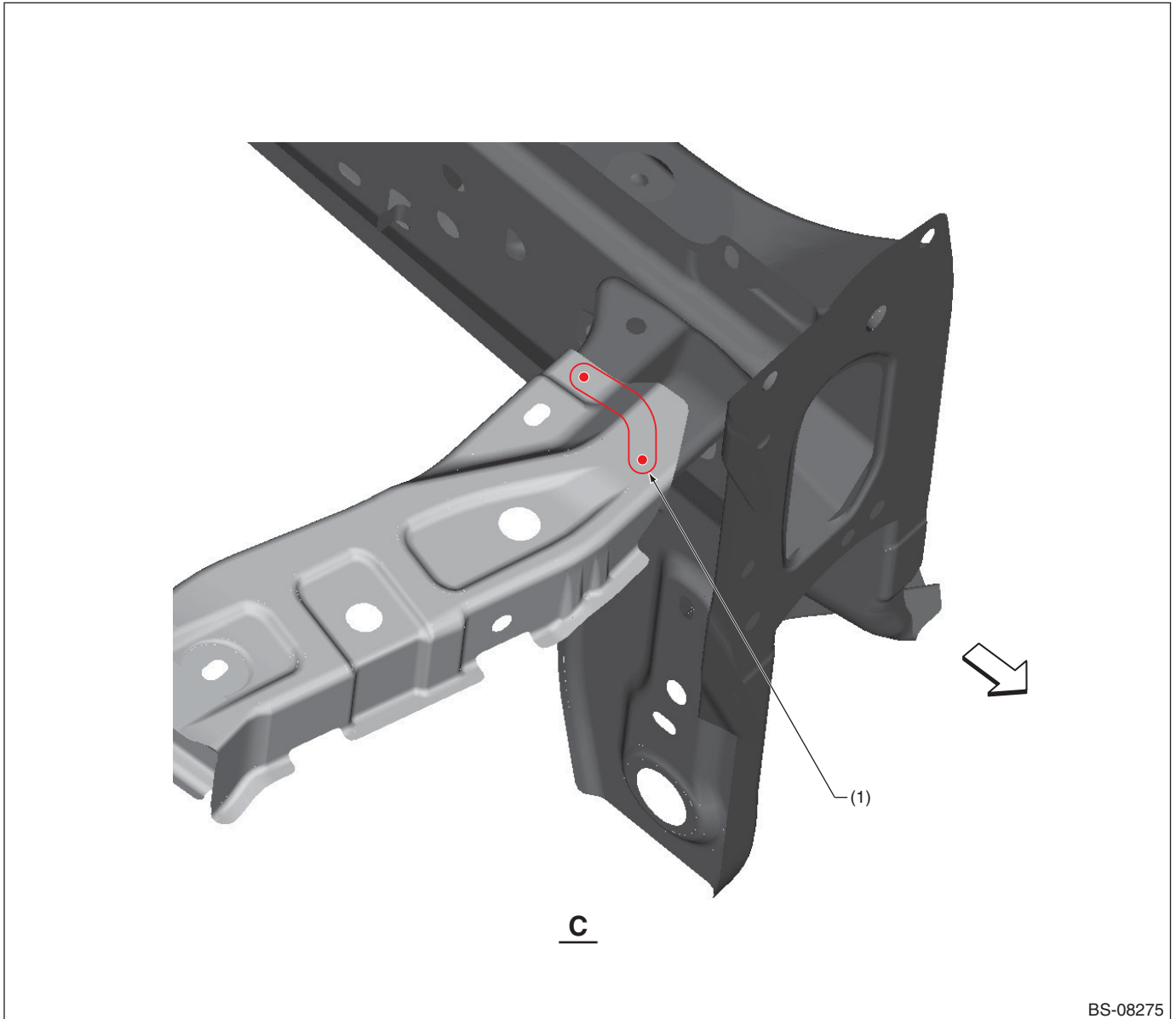
(1) 2 points (inside · 1)
(2) 1 point (inside · 1)

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

(5) 4 points (inside · 1)

Panel Replacement

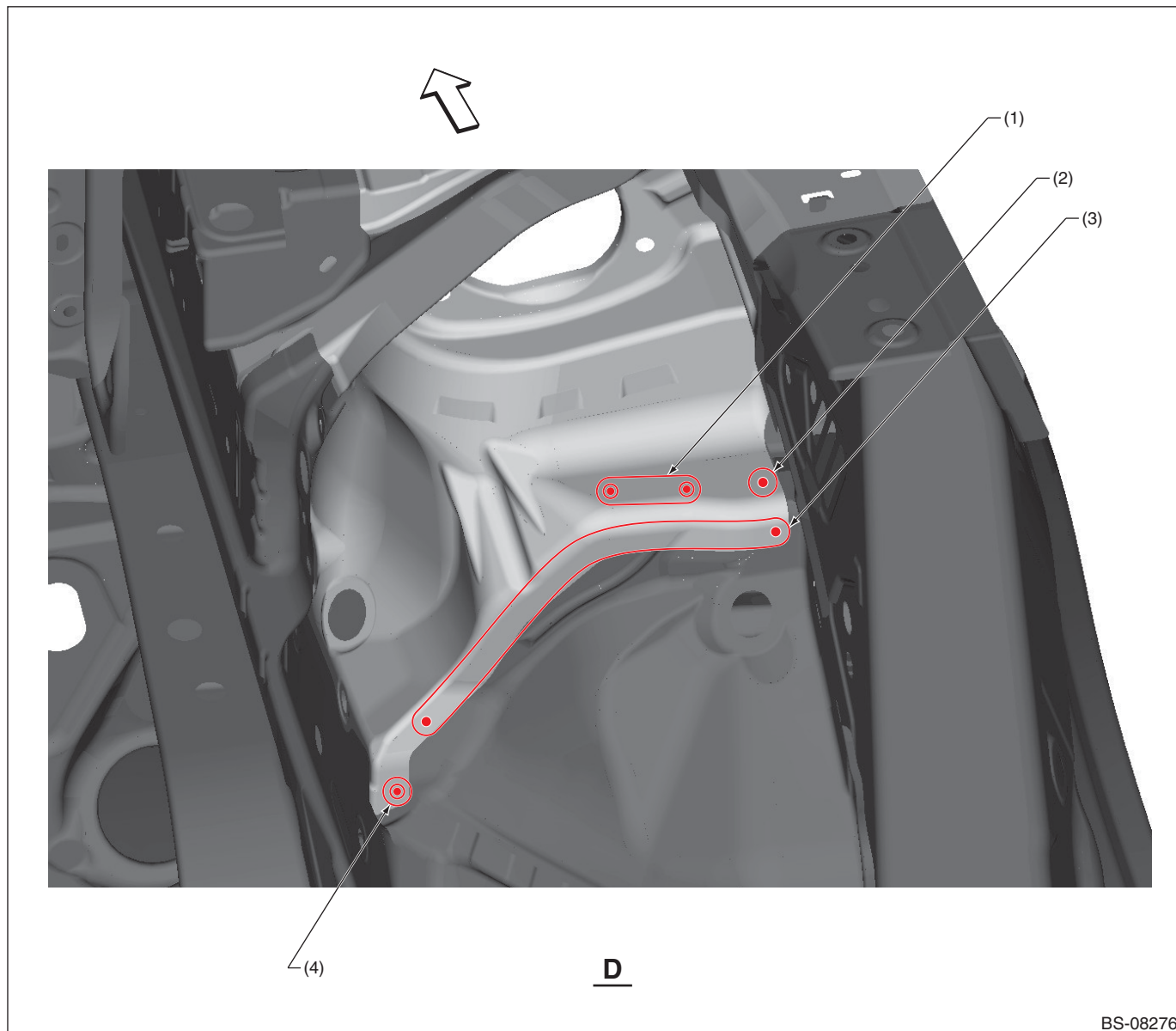
- View C (RH only)



(1) 3 points (top - 1)

Panel Replacement

• View D



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

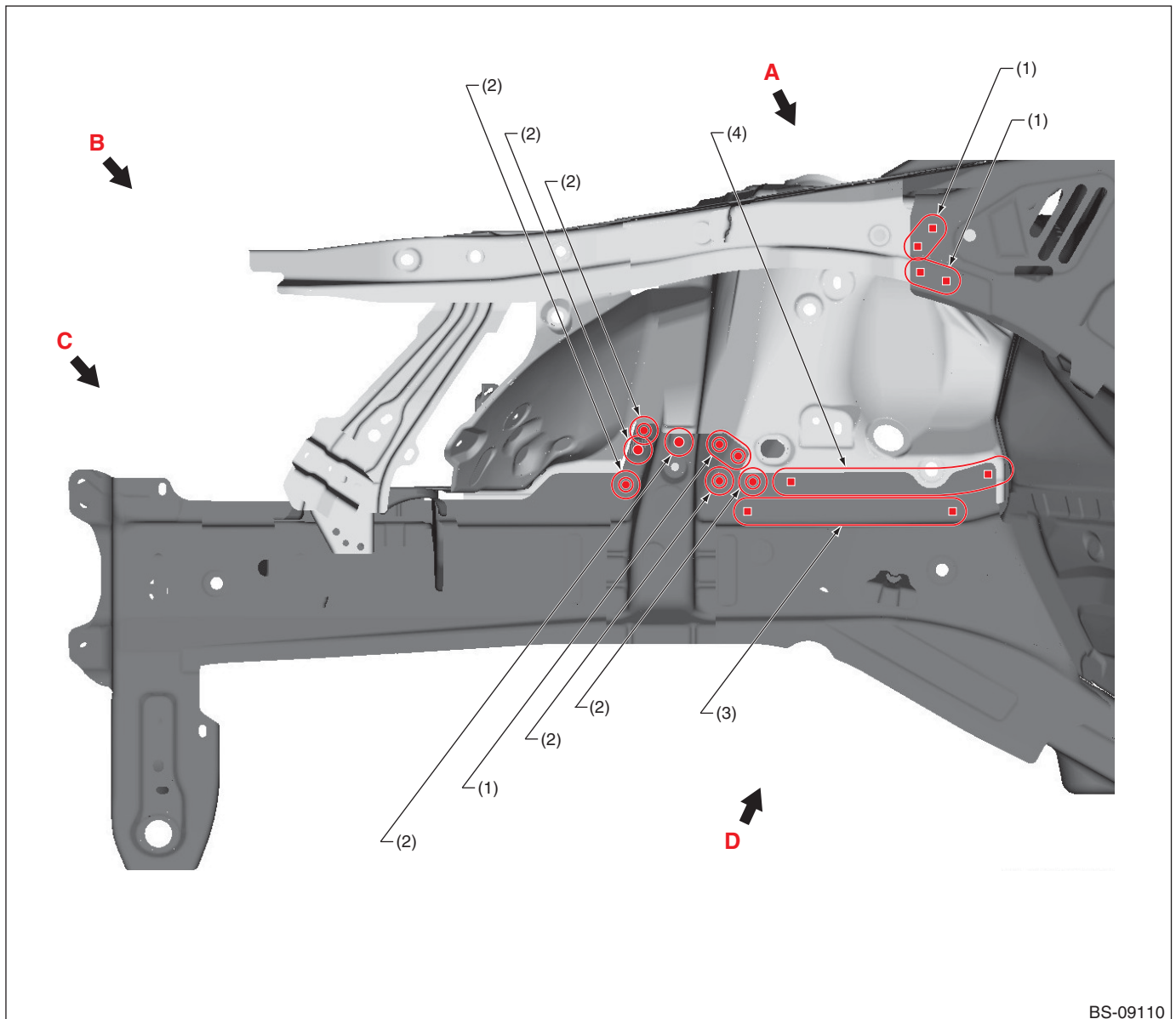
(3) 8 points (outside · 1)

(4) 1 point (outside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BS-09110

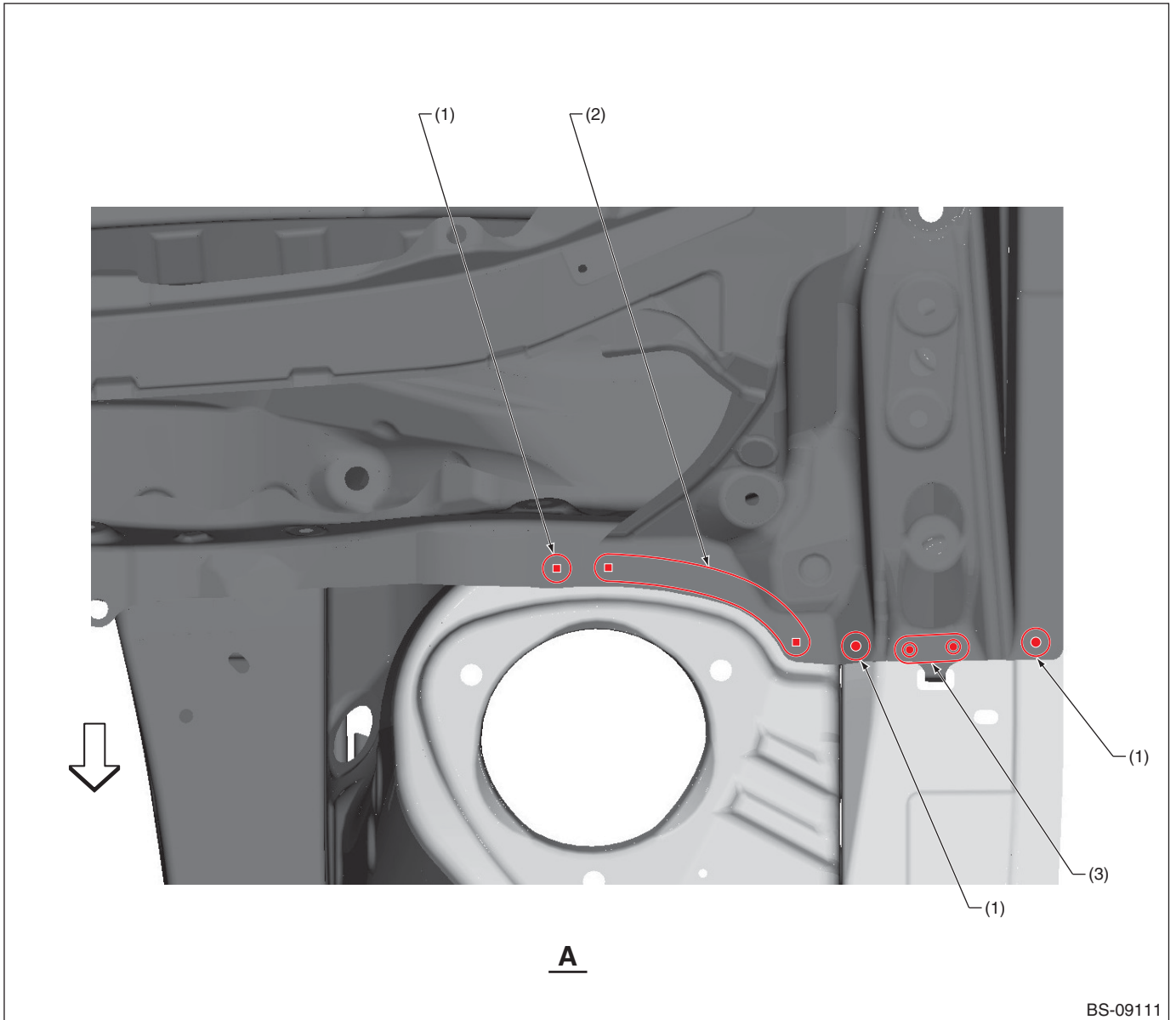
- (1) 2 points
- (2) 1 point

- (3) 4 points (service)

- (4) 6 points (service)

Panel Replacement

• View A



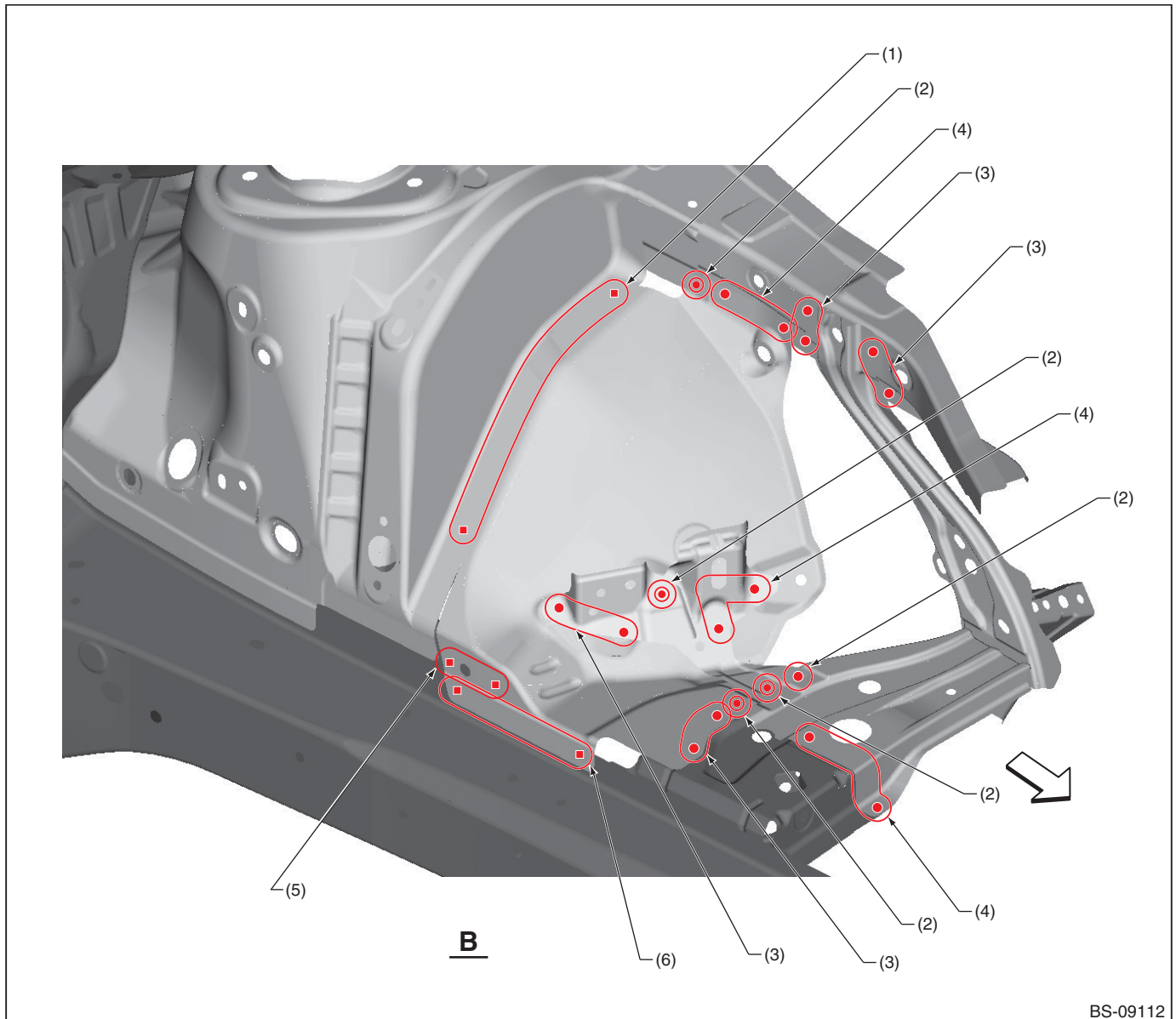
(1) 1 point

(2) 4 points

(3) 2 points

Panel Replacement

• View B (LH)



BS-09112

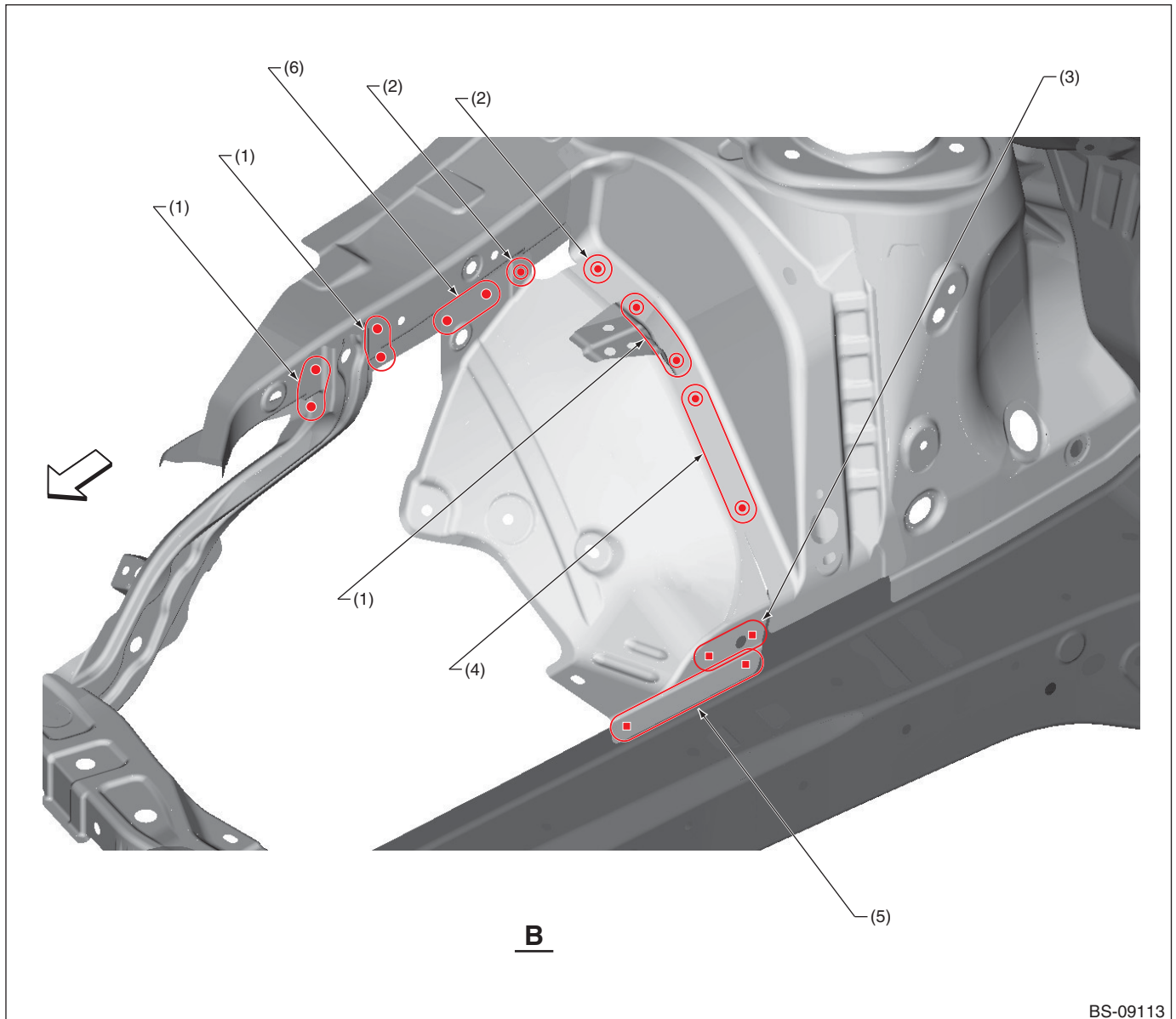
(1) 5 points (service)
(2) 1 point

(3) 2 points
(4) 3 points

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

Panel Replacement

• View B (RH)



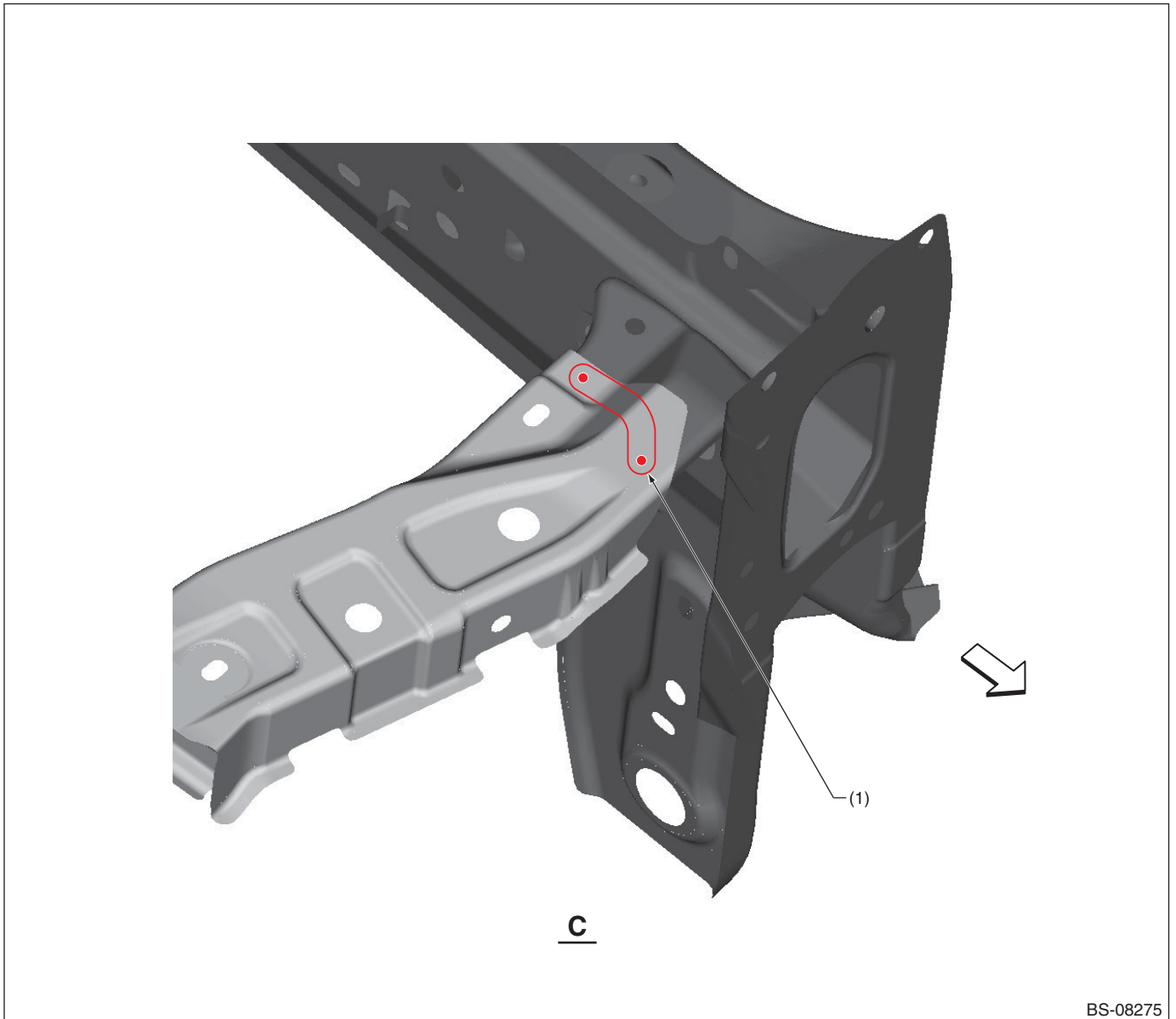
(1) 2 points
(2) 1 point

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

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

Panel Replacement

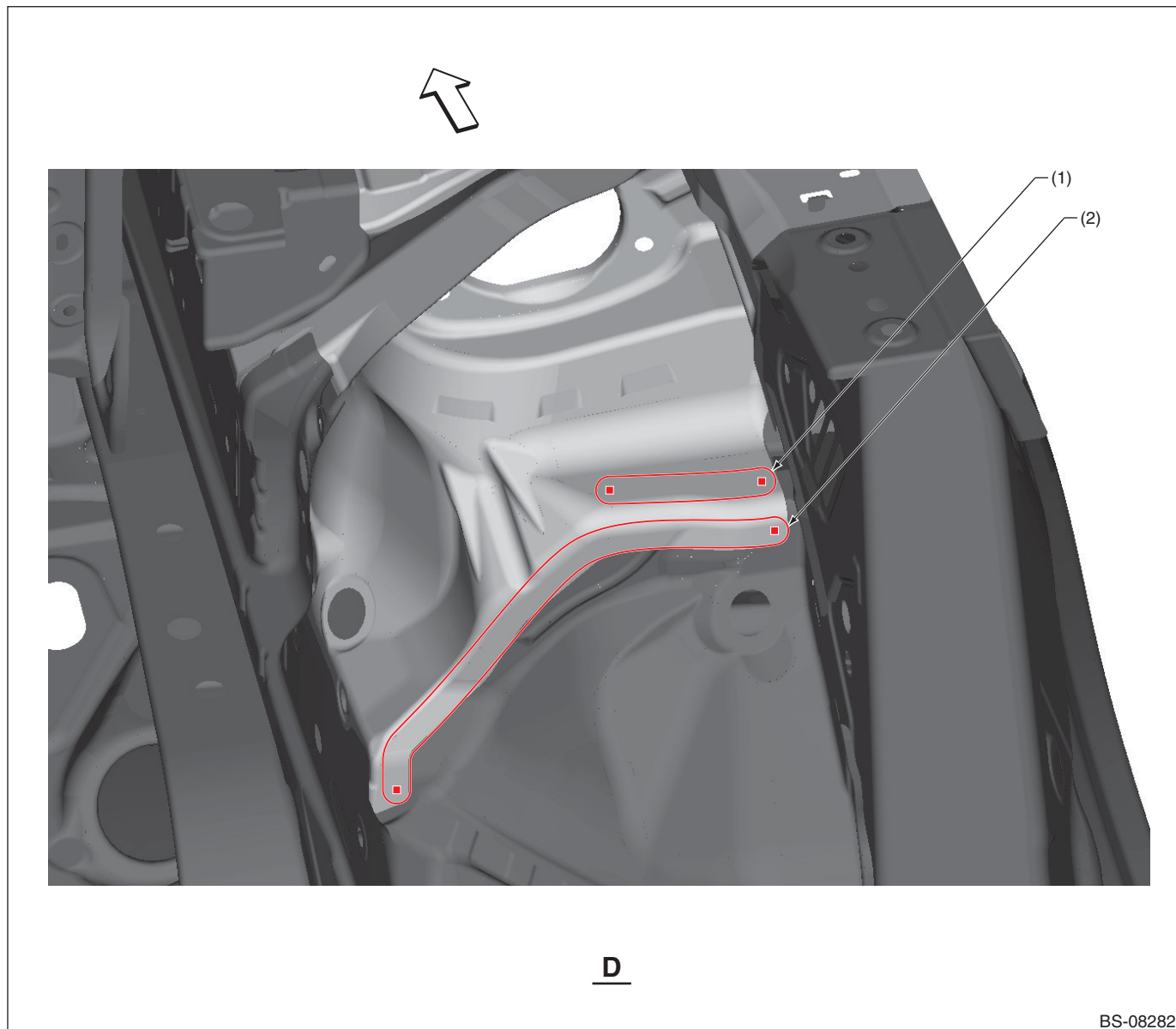
- View C (RH)



(1) 3 points

Panel Replacement

• View D



(1) 4 points (service)

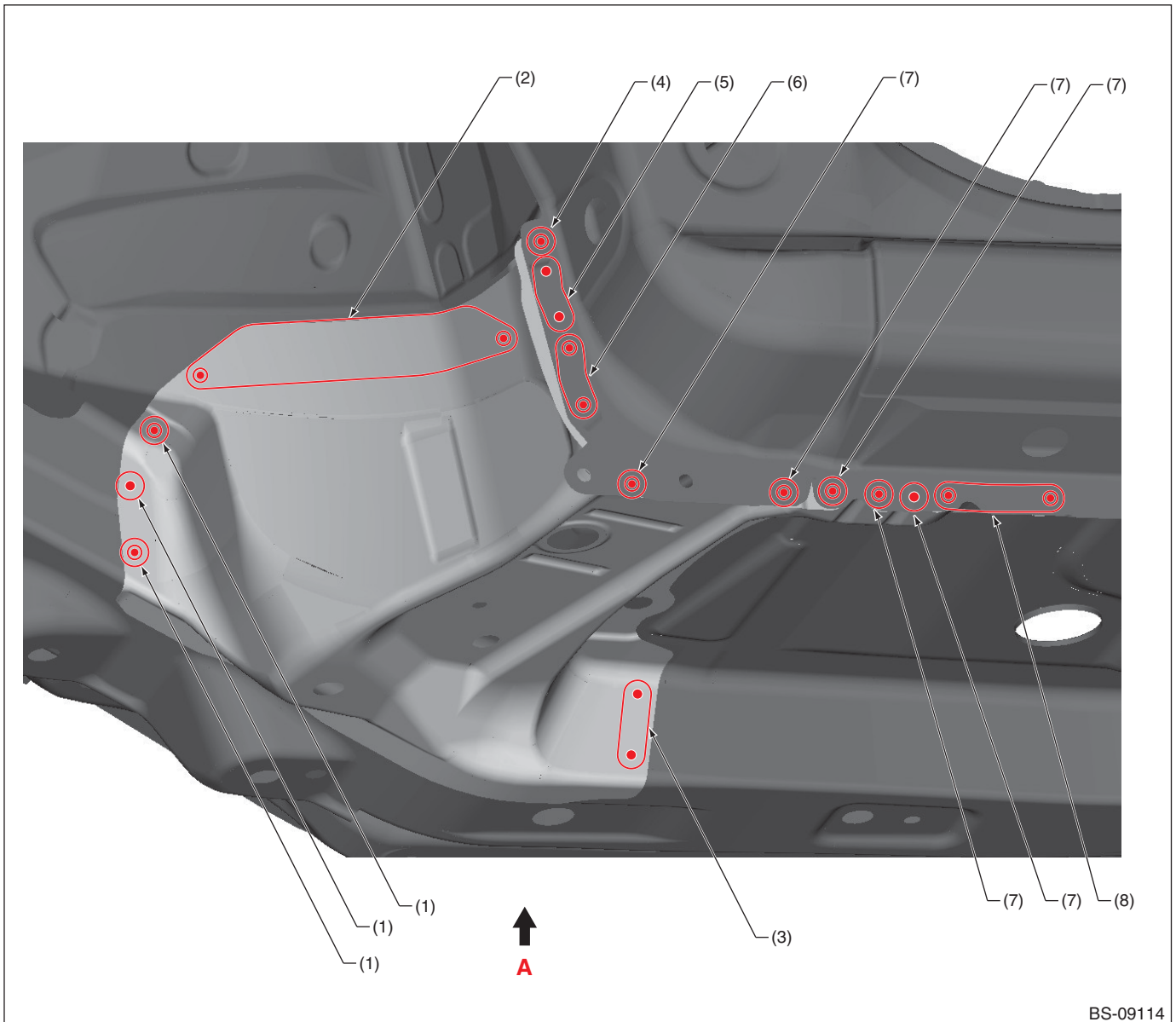
(2) 9 points (service)

Panel Replacement

8-5. Toe board reinforcement (Total replacement)

A: REMOVAL

• Overall view



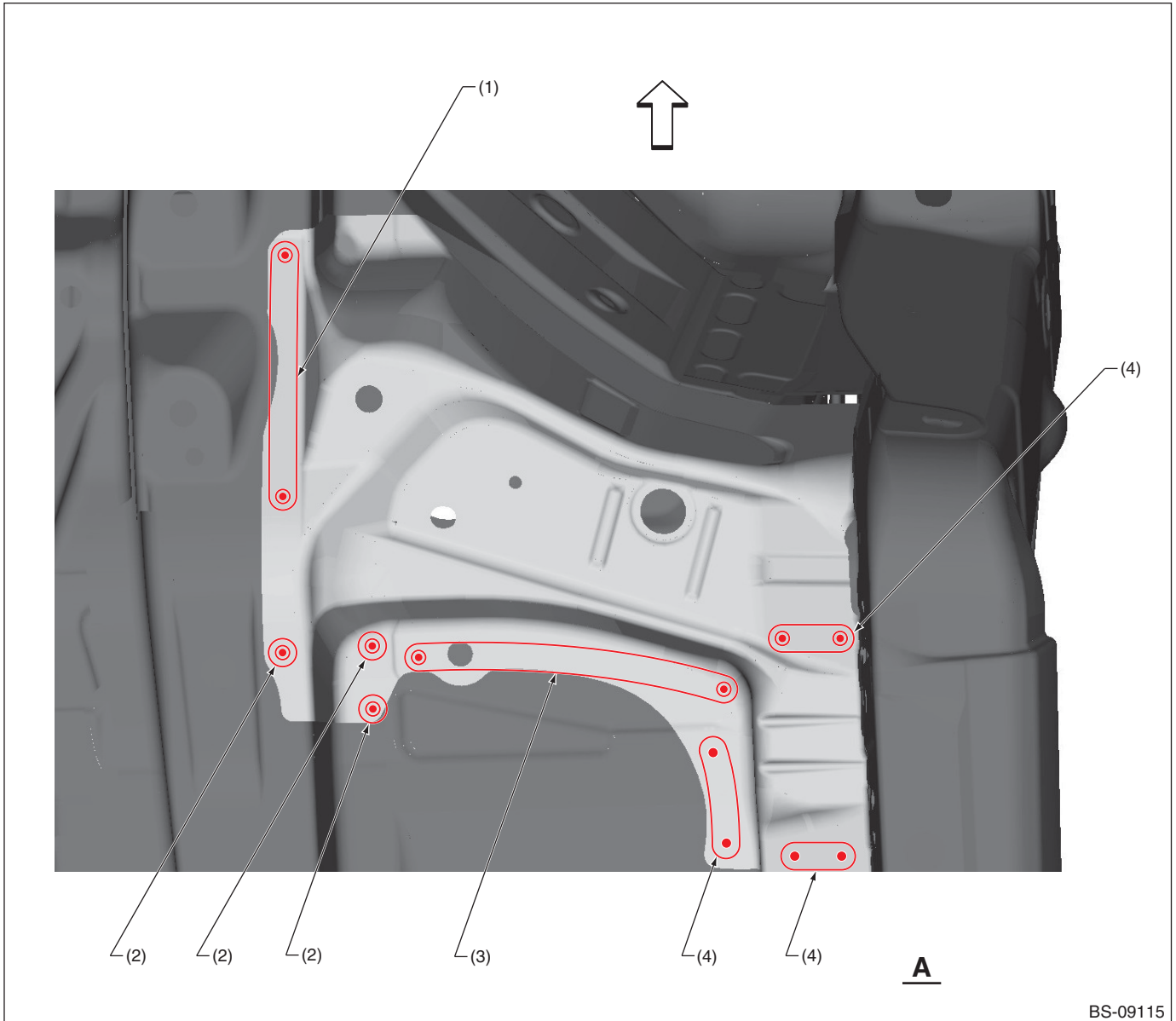
- (1) 1 point (outside - 1)
- (2) 9 points (outside - 1)
- (3) 2 points (outside - 1)

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

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

Panel Replacement

• View A



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

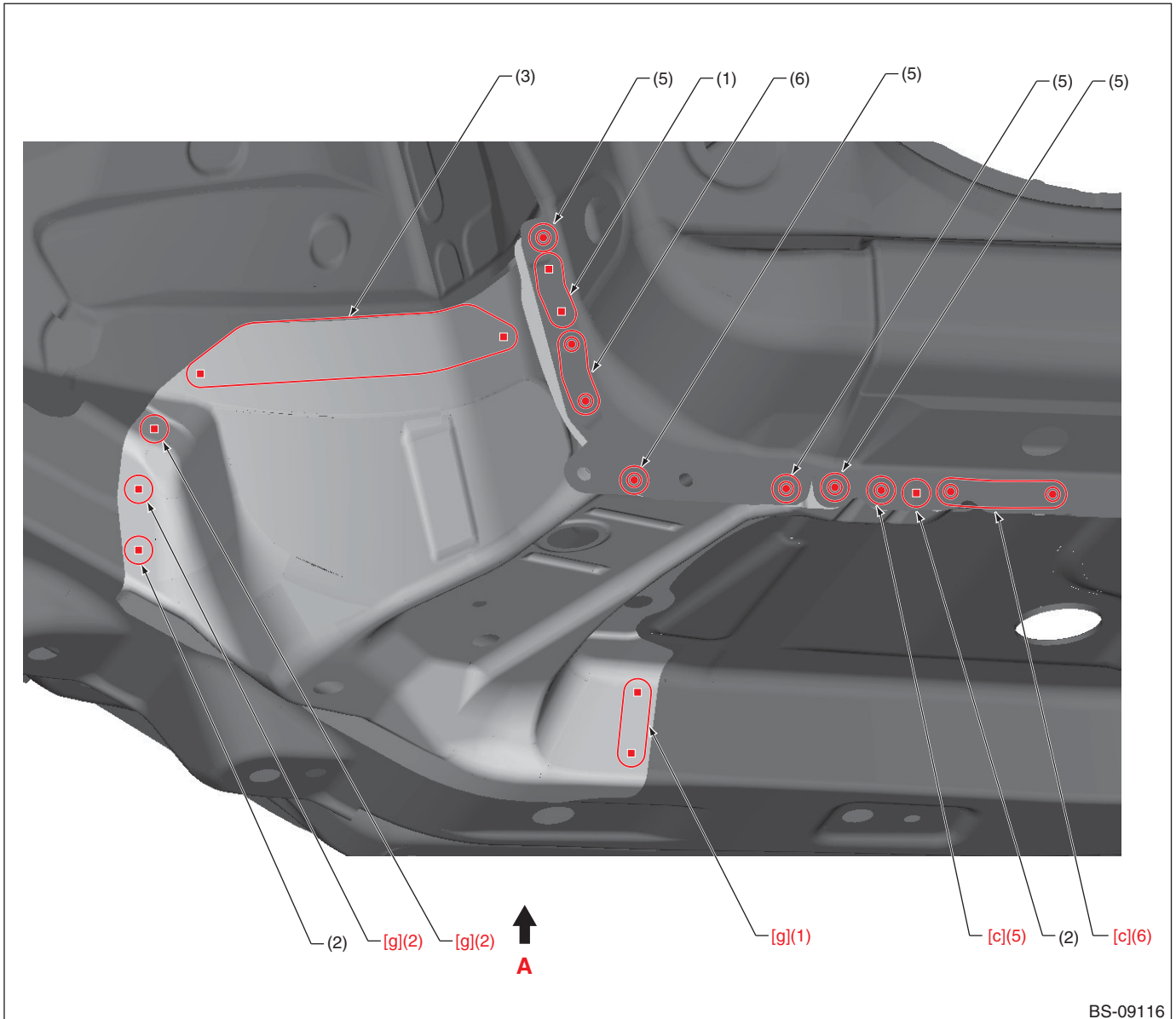
(3) 5 points (bottom · 1)

(4) 2 points (bottom · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BS-09116

(1) 2 points (service)

(2) 1 point (service)

(3) 9 points (service)

(4) 3 points

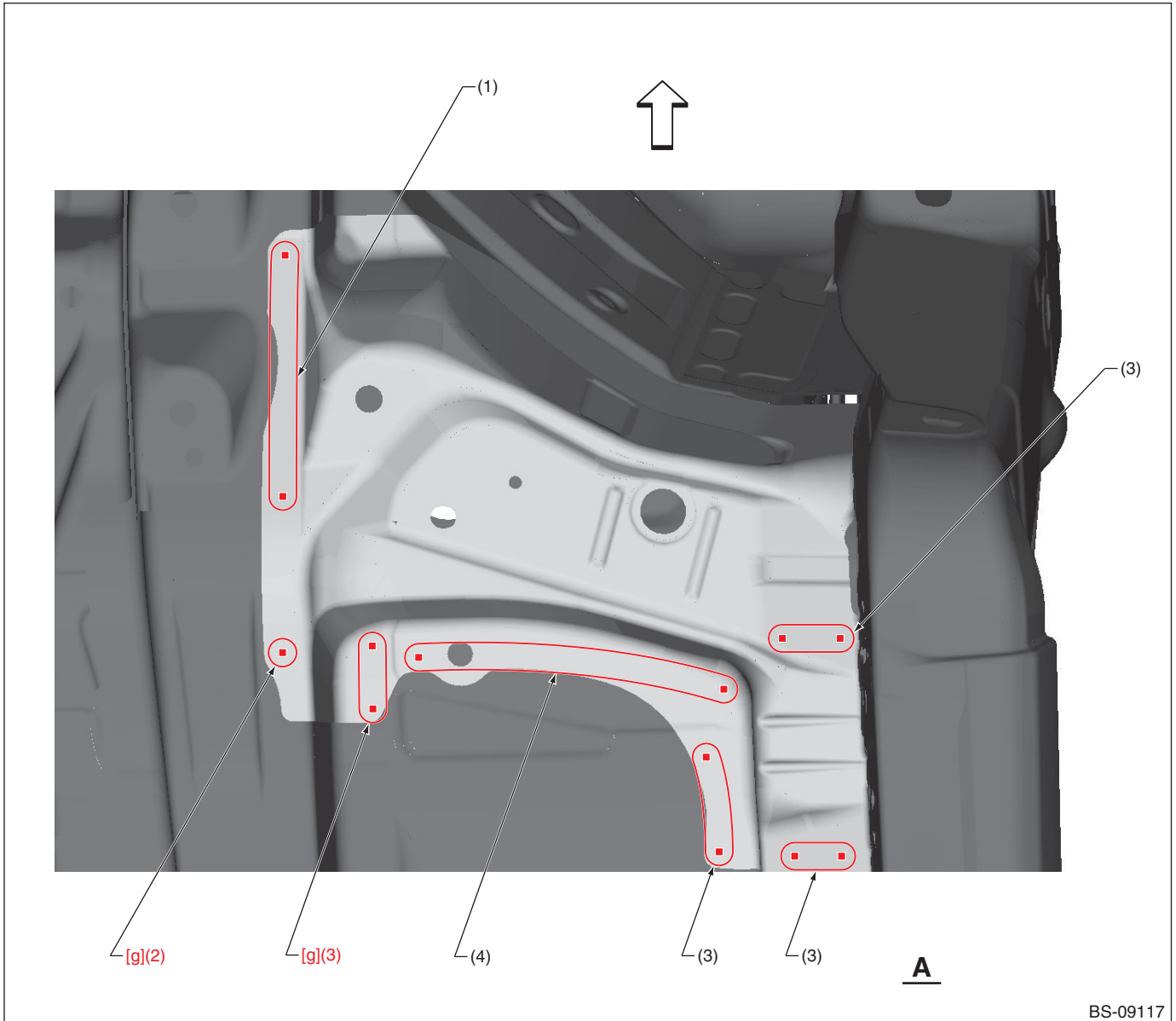
(5) 1 point

(6) 2 points

[c] Spot welding	Compression: 3.0 kN, Current: 6.5 kA, Welding time: 25 cyc
[g] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2 B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

• View A



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

(3) 2 points (service)

(4) 5 points (service)

[g] Plug welding

A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2

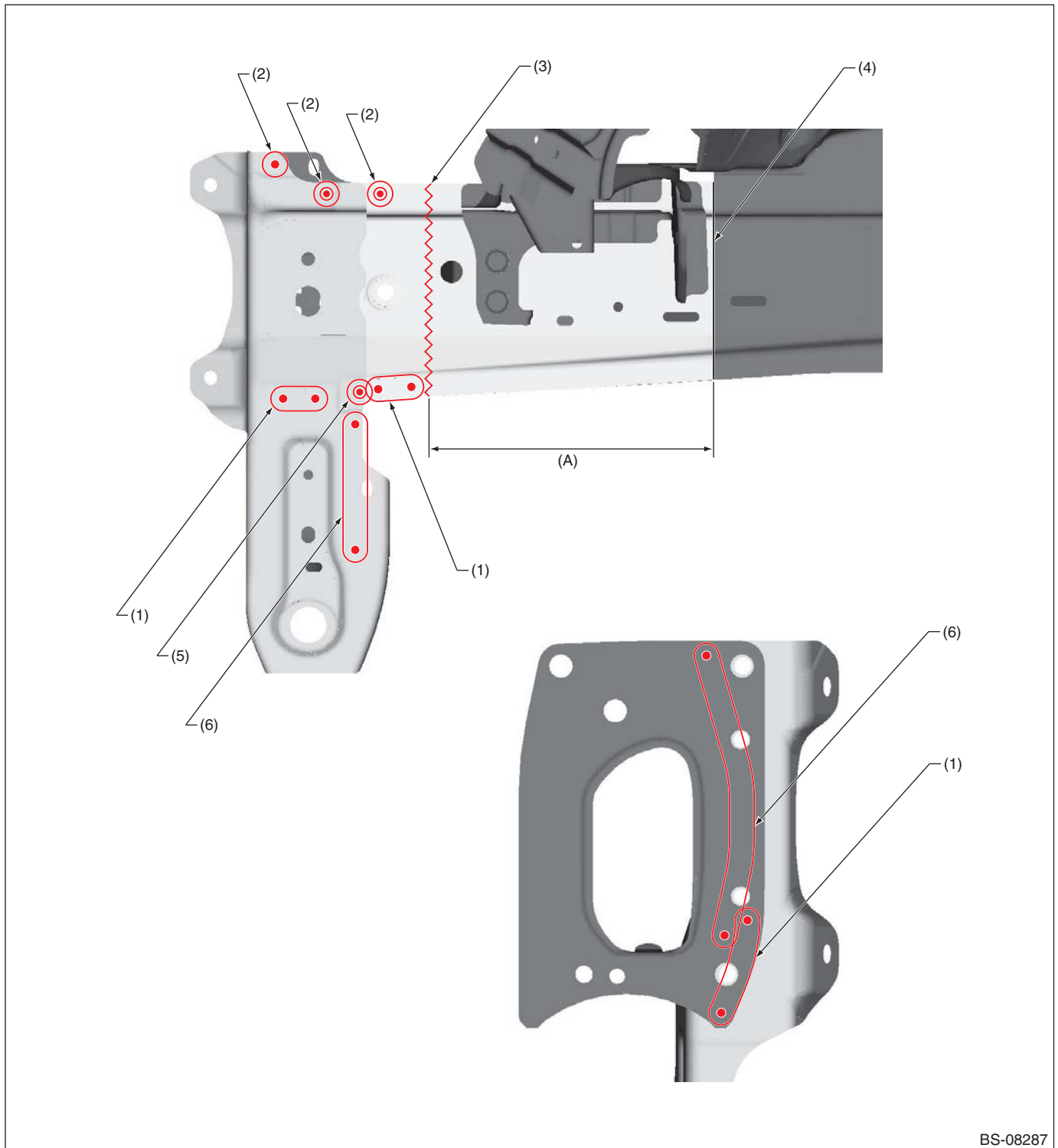
B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

8-6. Closing Plate LH (Partial replacement) Pattern 1

A: REMOVAL

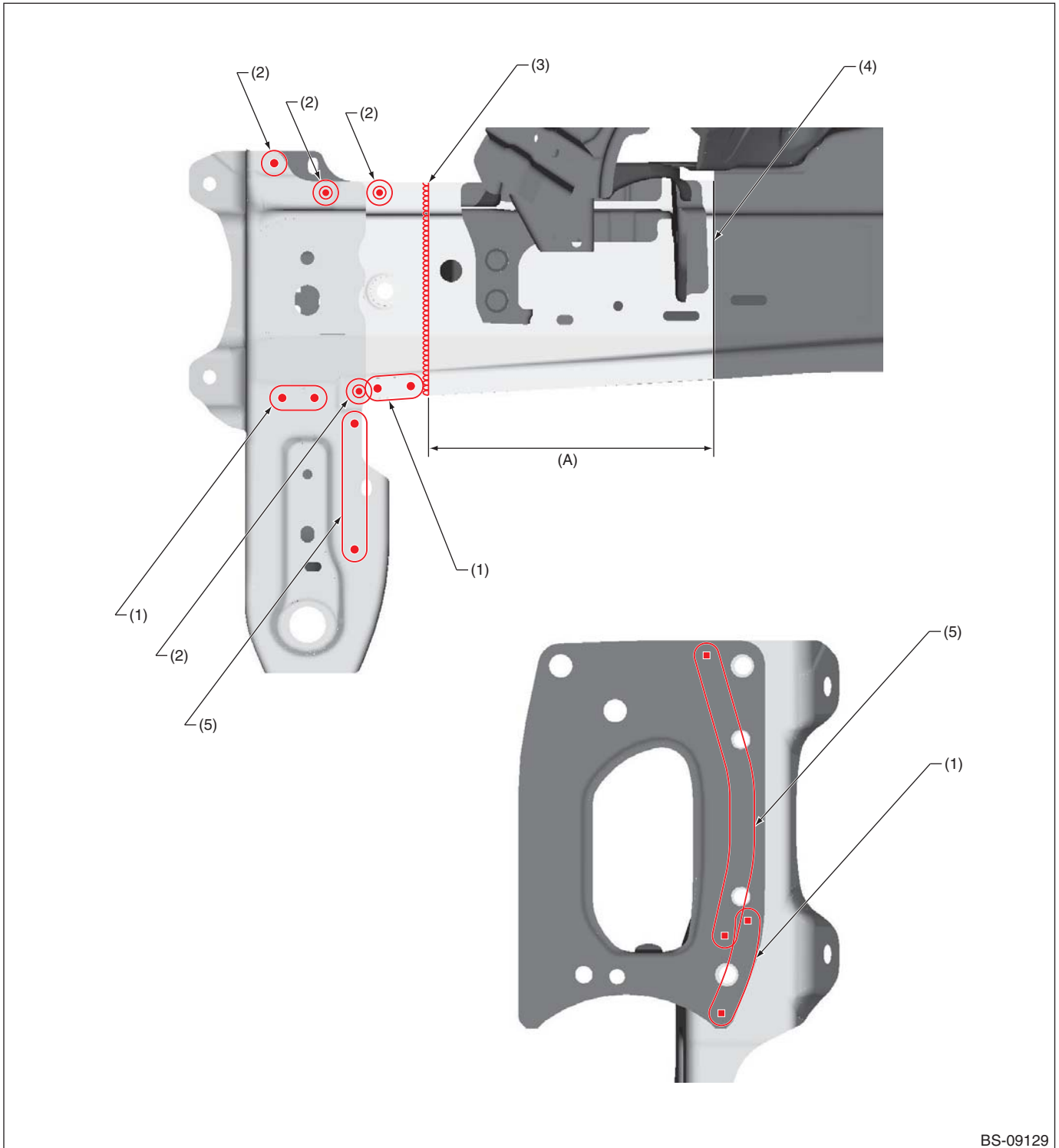
• Overall view



Panel Replacement

B: INSTALLATION

• Overall view



BS-09129

(A) 210 mm [8.27 in]

(1) 2 points
(2) 1 point

(3) 1 point (Continuous welding)
(4) Tailored line

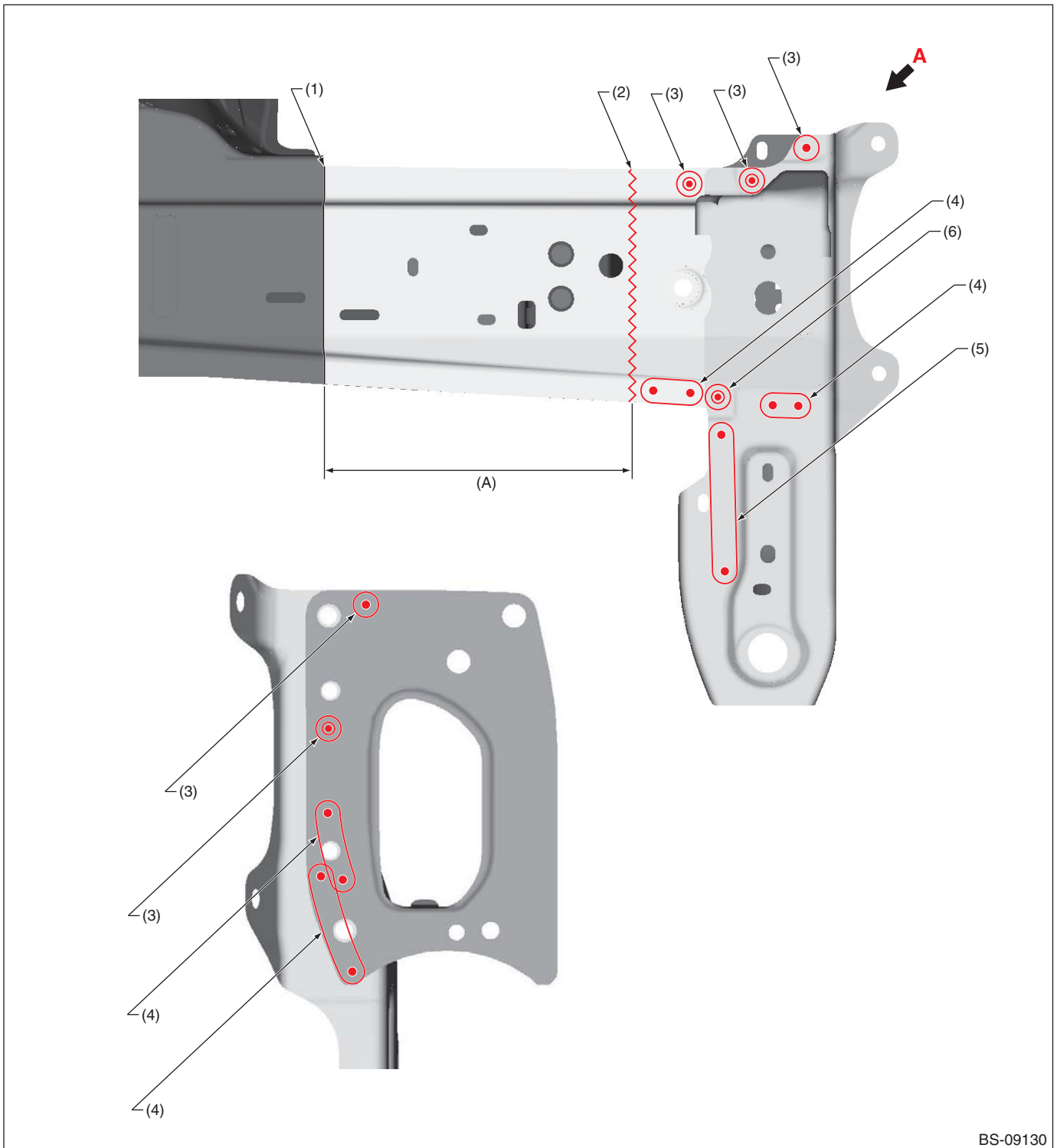
(5) 4 points

Panel Replacement

8-7. Closing Plate RH (Partial replacement) Pattern 1

A: REMOVAL

• Overall view



BS-09130

(A) 210 mm [8.27 in]

(1) Tailored line

(2) Cut position

(3) 1 point (outside - 1)

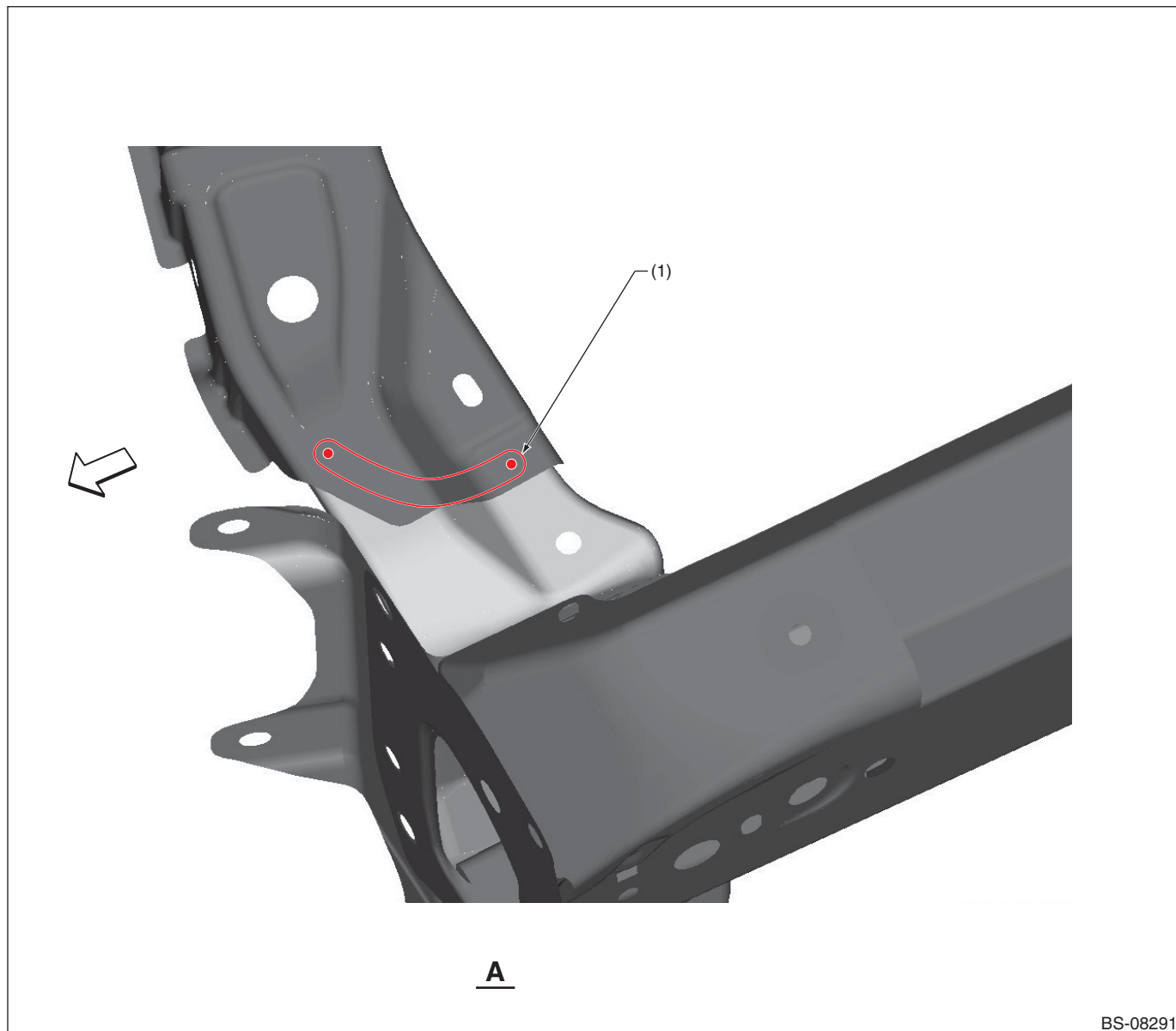
(4) 2 points (outside - 1)

(5) 4 points (outside - 1)

(6) 1 point (outside - 2)

Panel Replacement

• View A

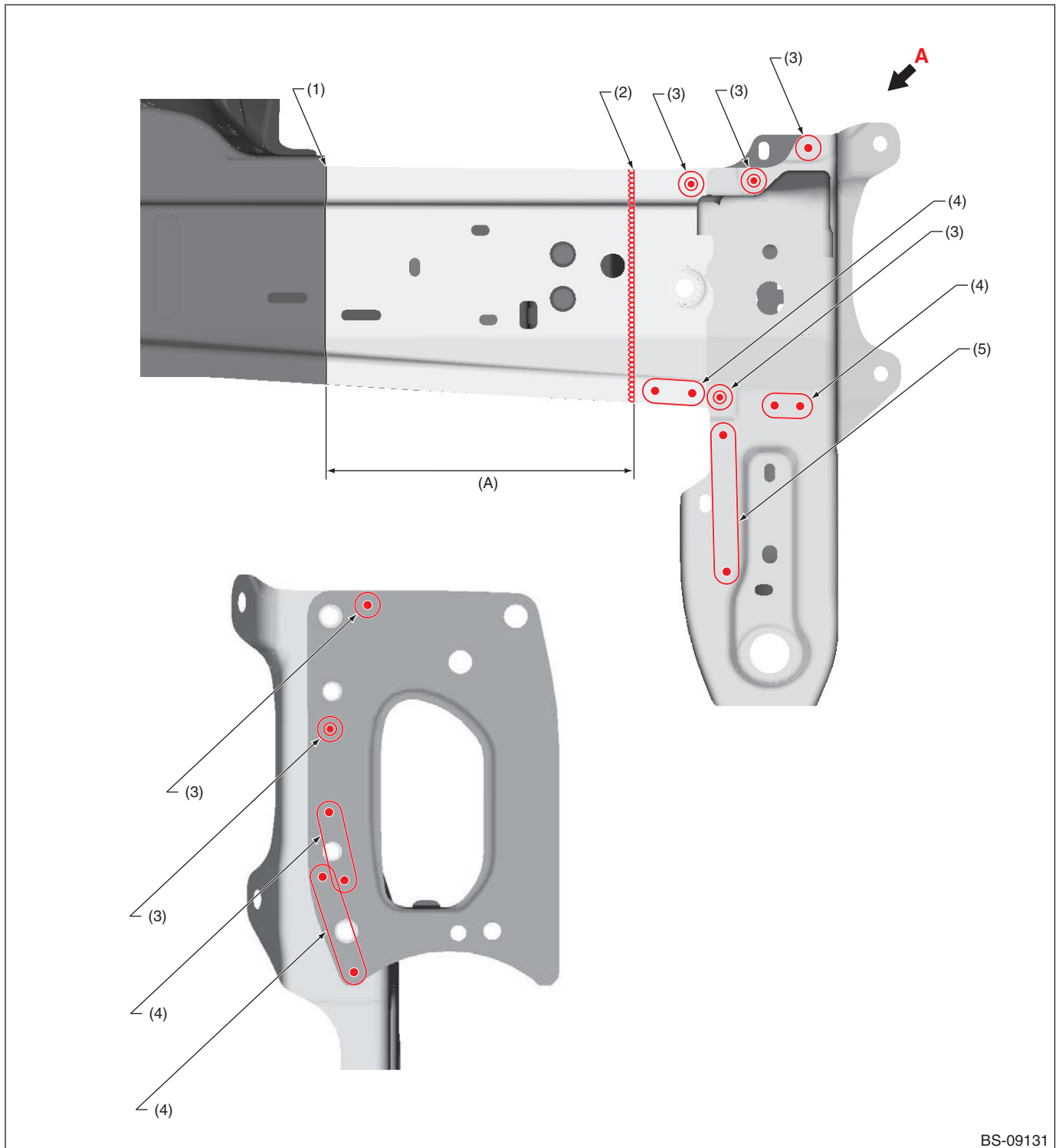


(1) 3 points (top · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BS-09131

(A) 210 mm [8.27 in]

(1) Tailored line

(2) 1 point (Continuous welding)

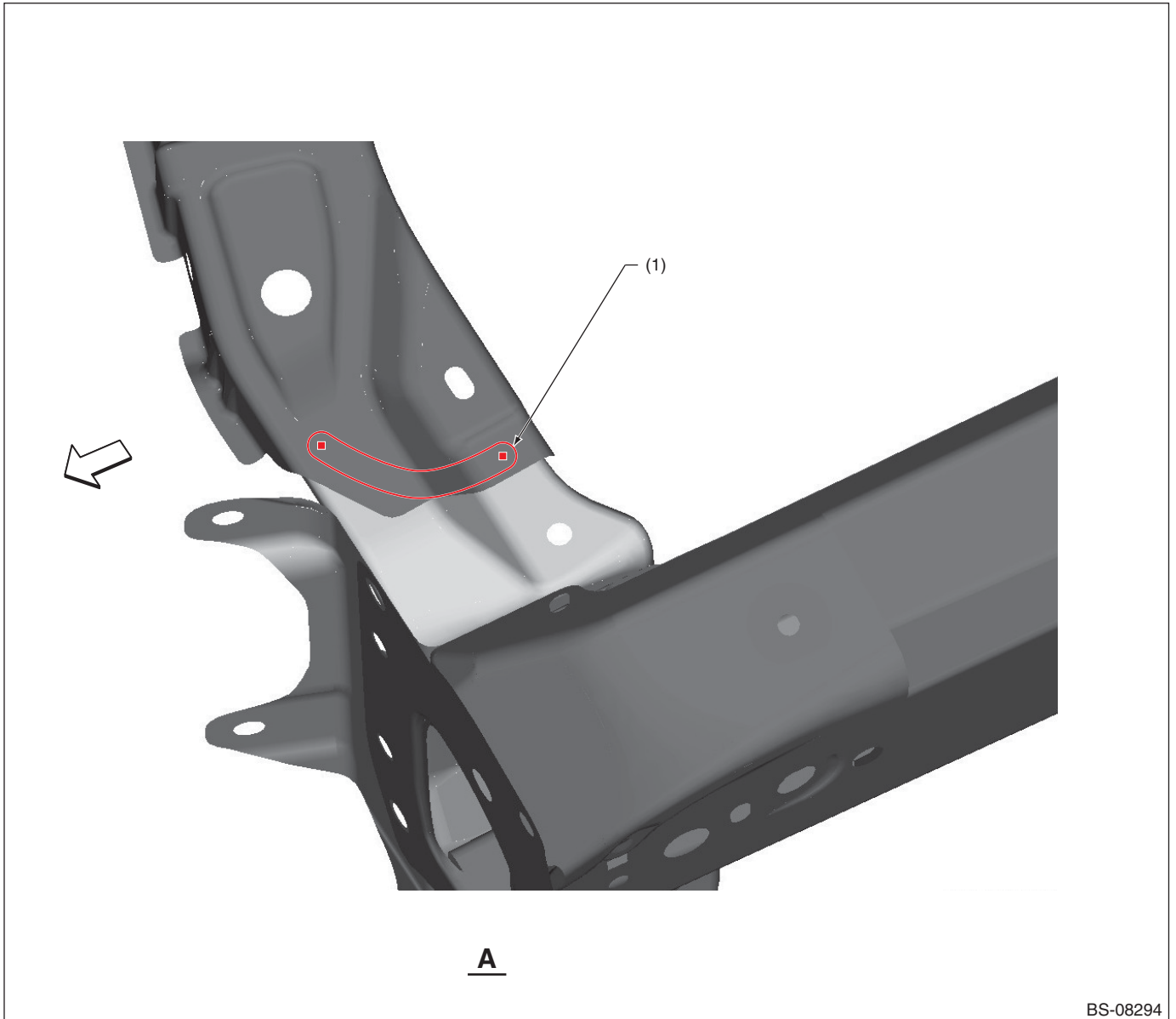
(3) 1 point

(4) 2 points

(5) 4 points

Panel Replacement

• View A



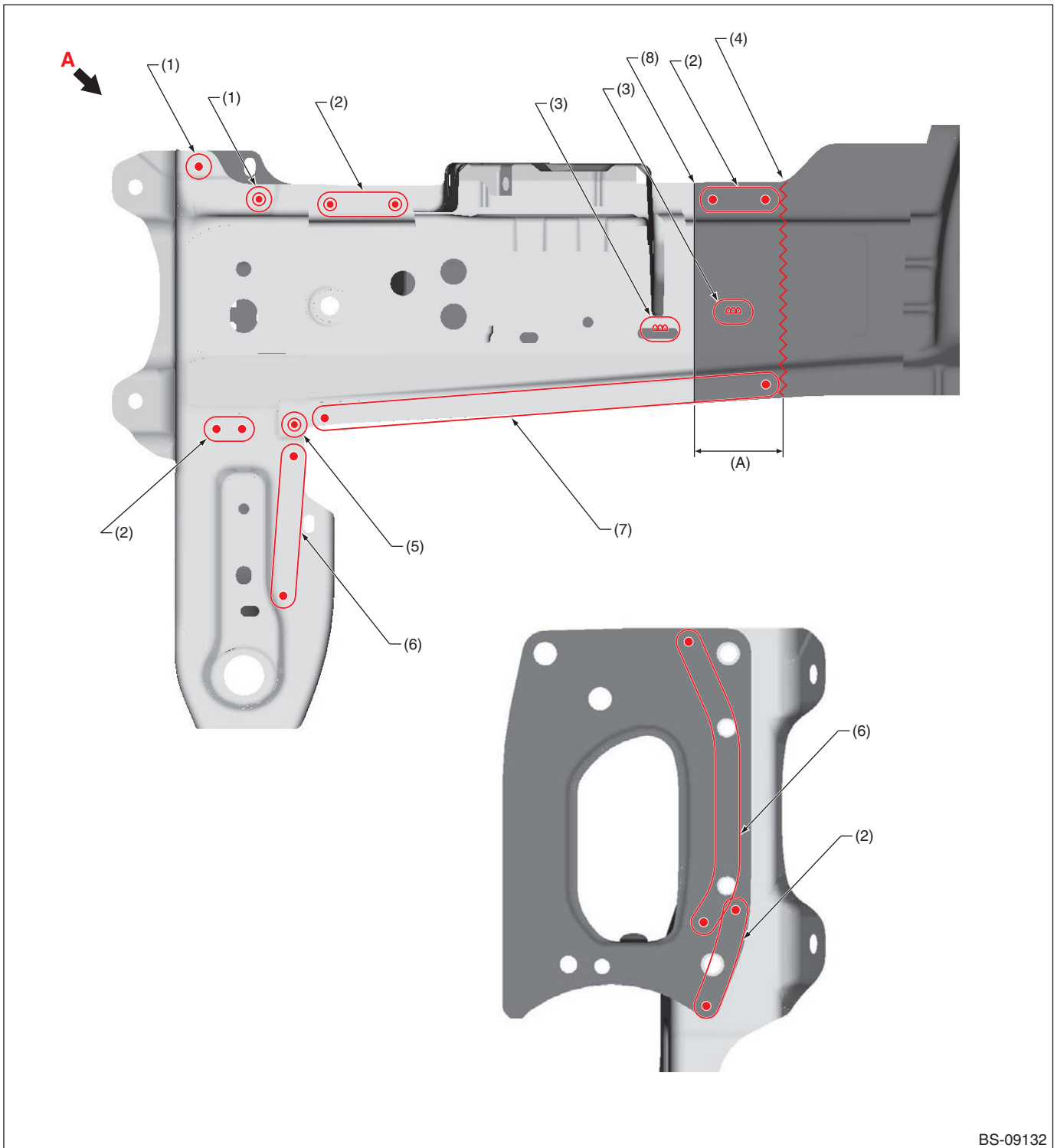
(1) 3 points

Panel Replacement

8-8. Closing Plate LH (Partial replacement) Pattern 2

A: REMOVAL

- Overall view (The front wheel apron should be removed depending on level of damage.)



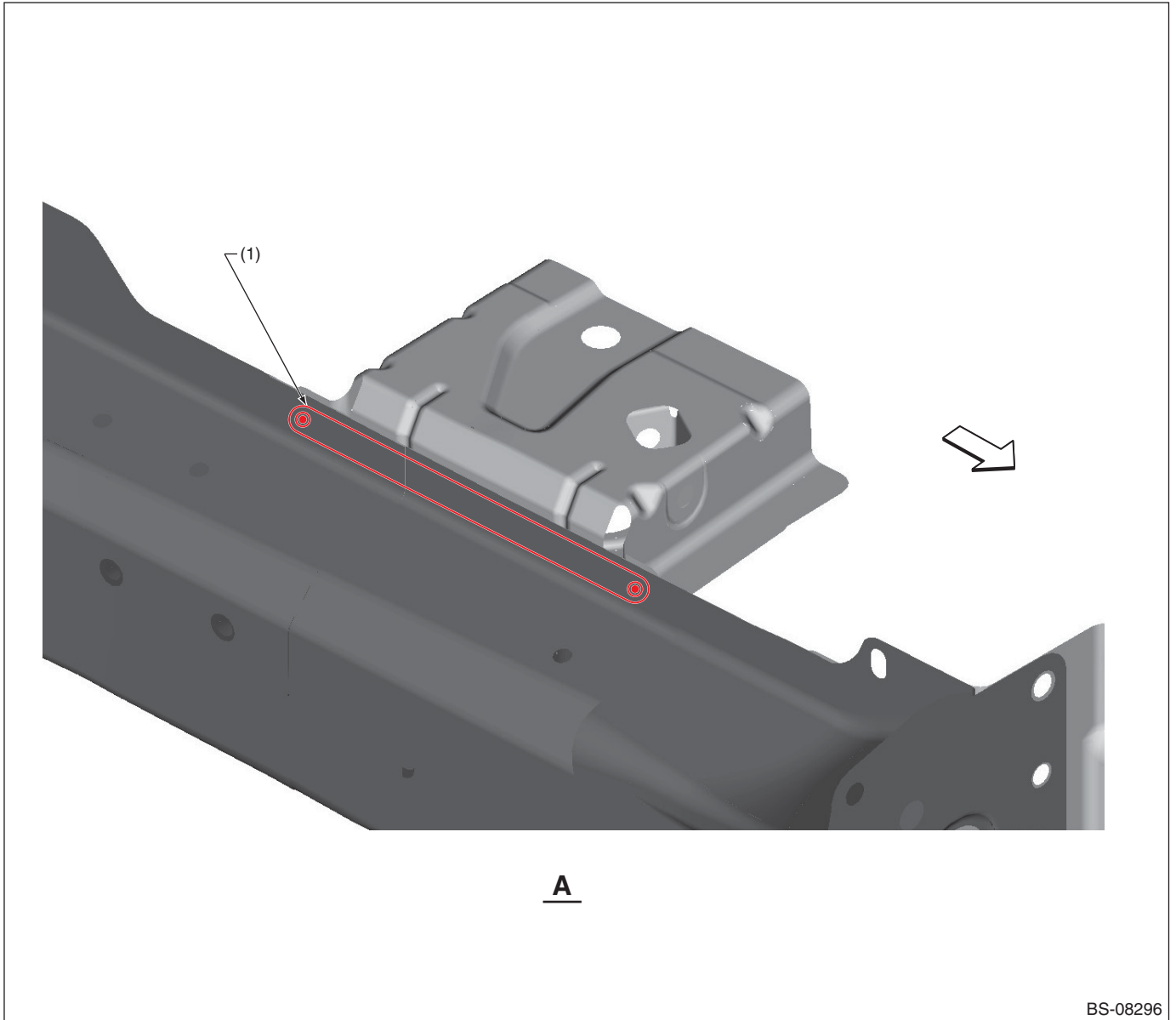
BS-09132

(A) 55 mm [2.17 in]

- | | | |
|--|----------------------------|-----------------------------|
| (1) 1 point (outside · 1) | (4) Cut position | (7) 12 points (outside · 1) |
| (2) 2 points (outside · 1) | (5) 1 point (outside · 2) | (8) Tailored line |
| (3) 1 point (outside · 1, belt sander) | (6) 4 points (outside · 1) | |

Panel Replacement

• View A

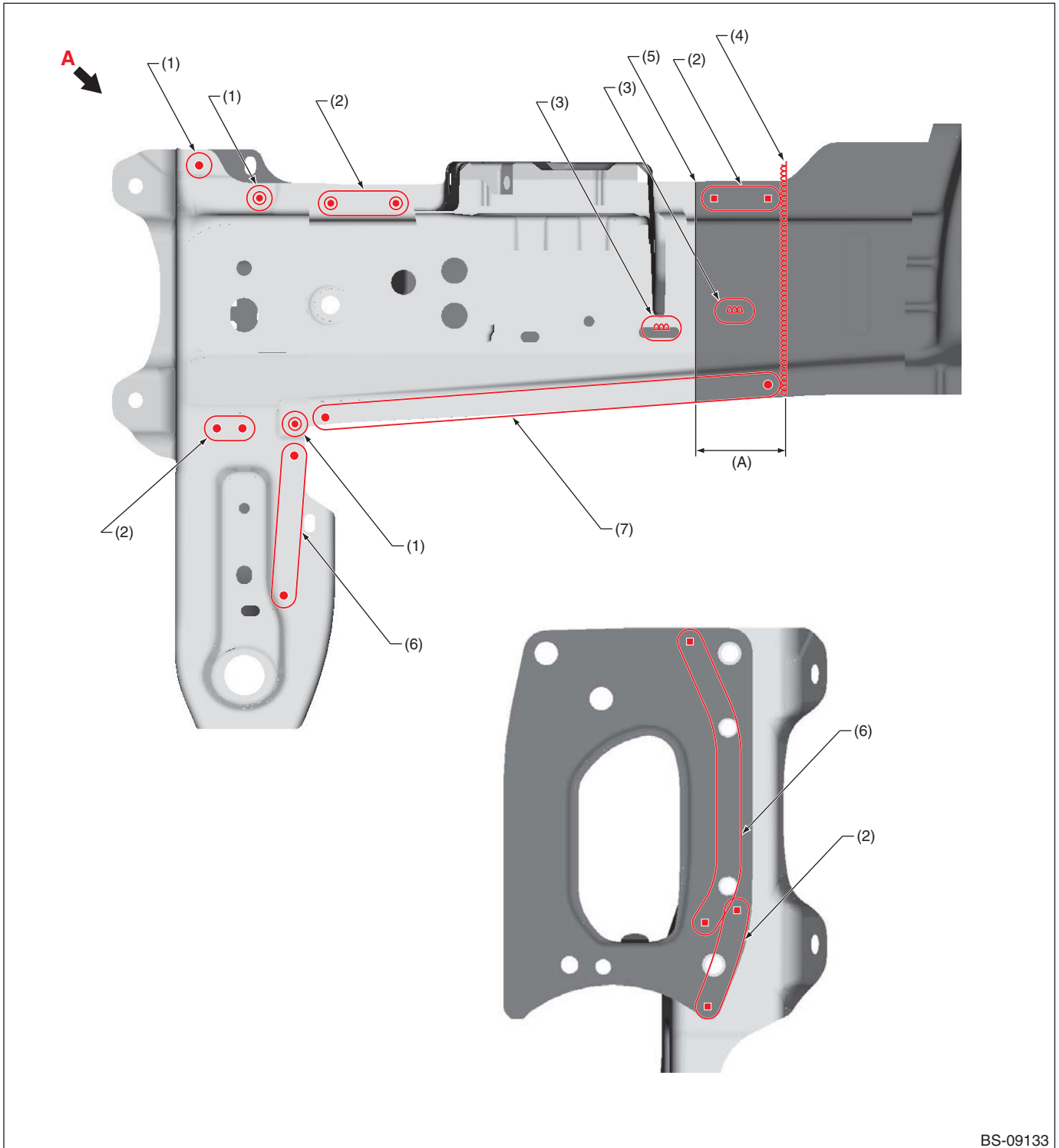


(1) 6 points (inside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BS-09133

(A) 55 mm [2.17 in]

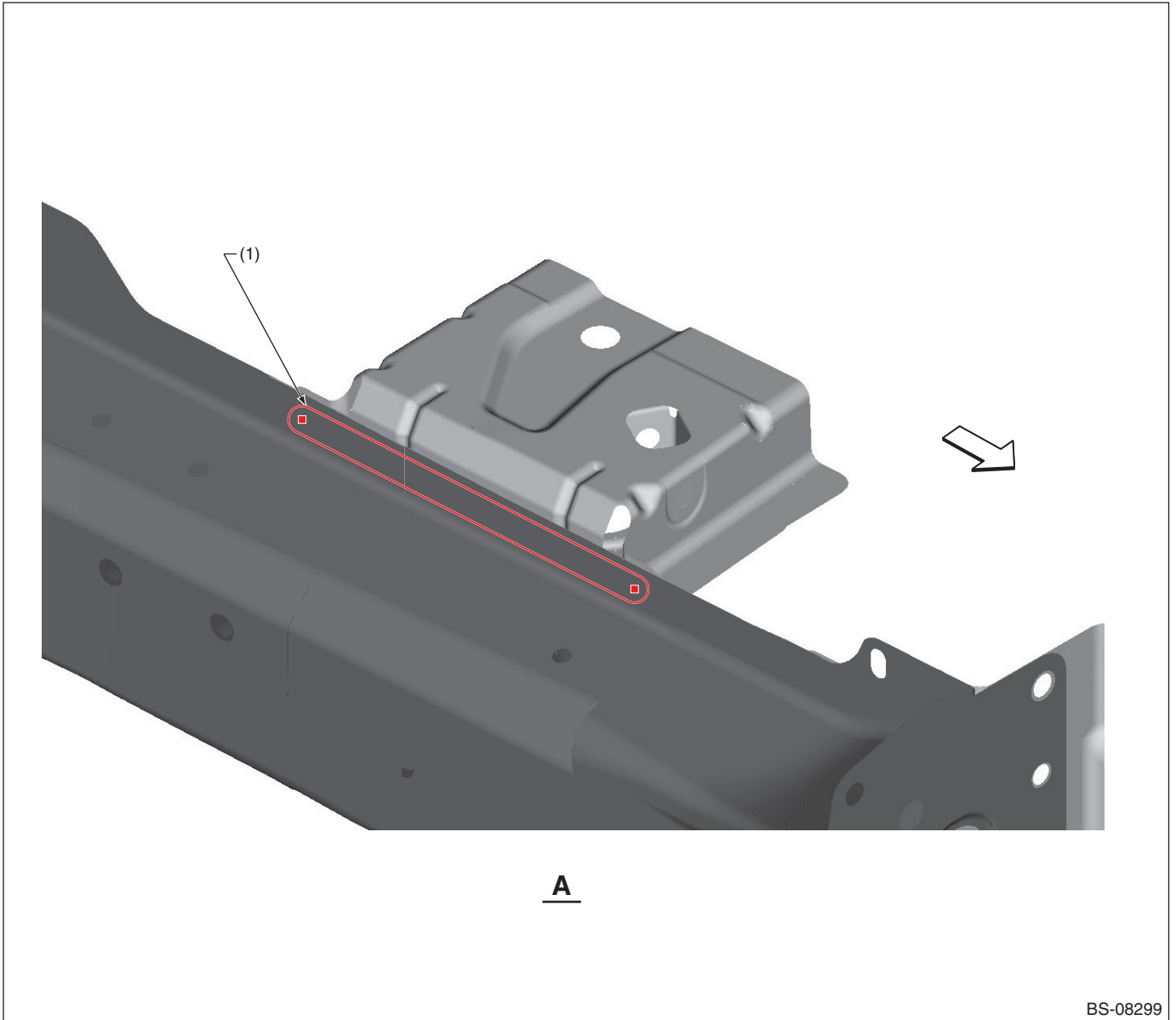
- (1) 1 point
- (2) 2 points
- (3) 1 point (Continuous welding)
(10 mm [0.39 in])

- (4) 1 point (Continuous welding)
- (5) Tailored line
- (6) 4 points

- (7) 12 points

Panel Replacement

• View A



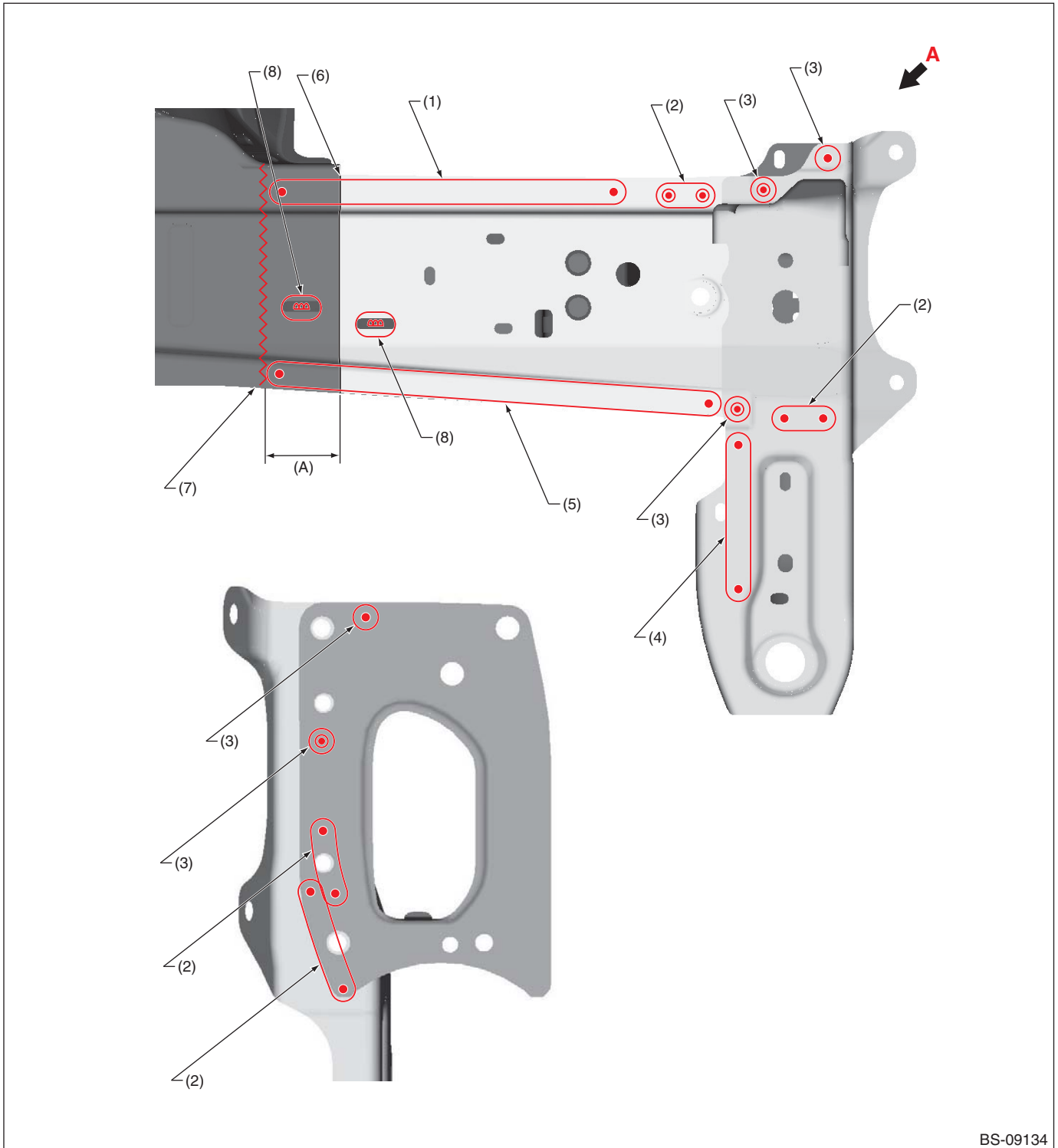
(1) 6 points

Panel Replacement

8-9. Closing Plate RH (Partial replacement) Pattern 2

A: REMOVAL

- Overall view (The front wheel apron should be removed depending on level of damage.)



BS-09134

(A) 55 mm [2.17 in]

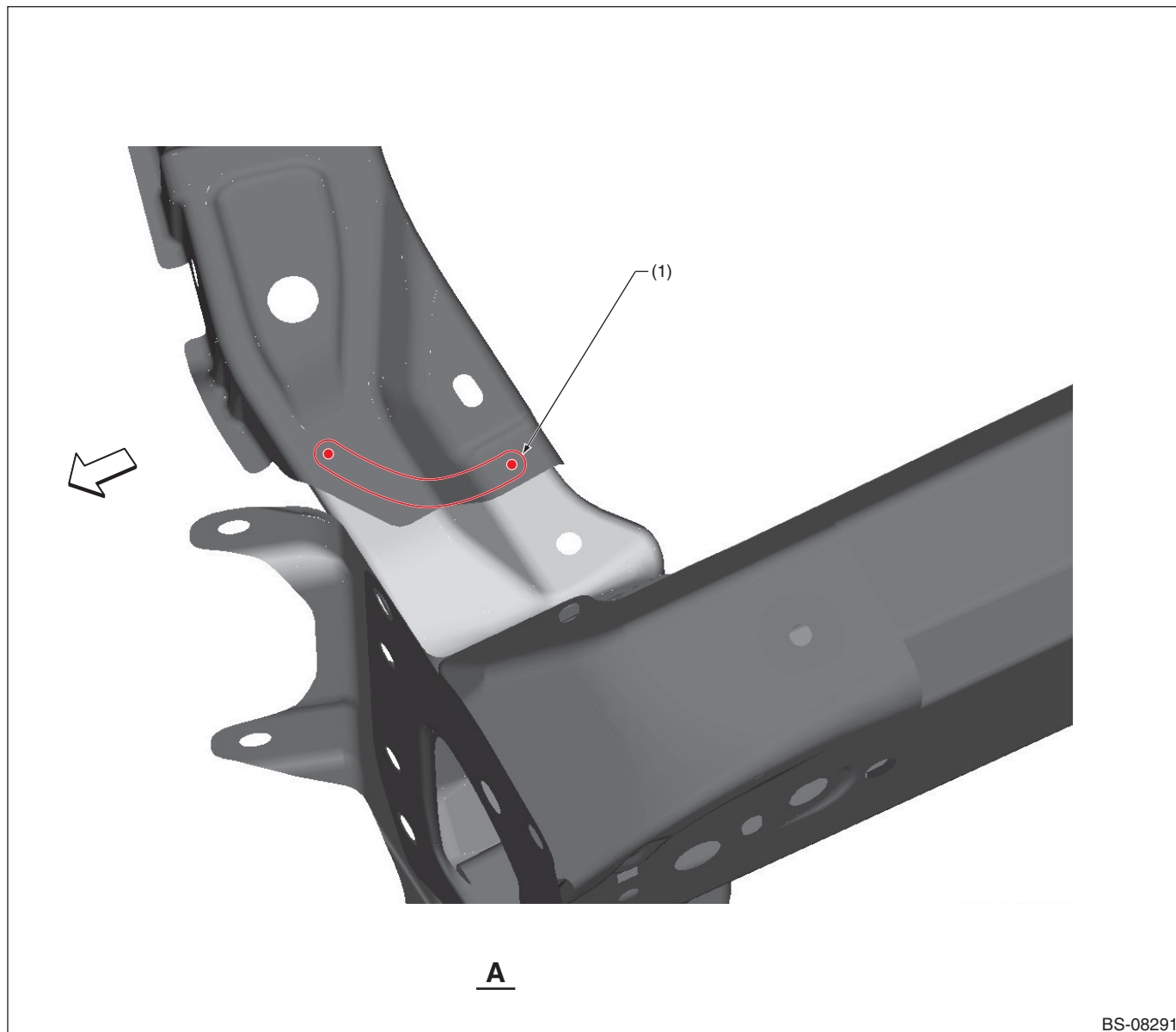
- (1) 8 points (outside · 1)
(2) 2 points (outside · 1)
(3) 1 point (outside · 2)

- (4) 4 points (outside · 1)
(5) 12 points (outside · 1)
(6) Tailored line

- (7) Cut position
(8) 1 point (outside · 1, belt sander)

Panel Replacement

• View A

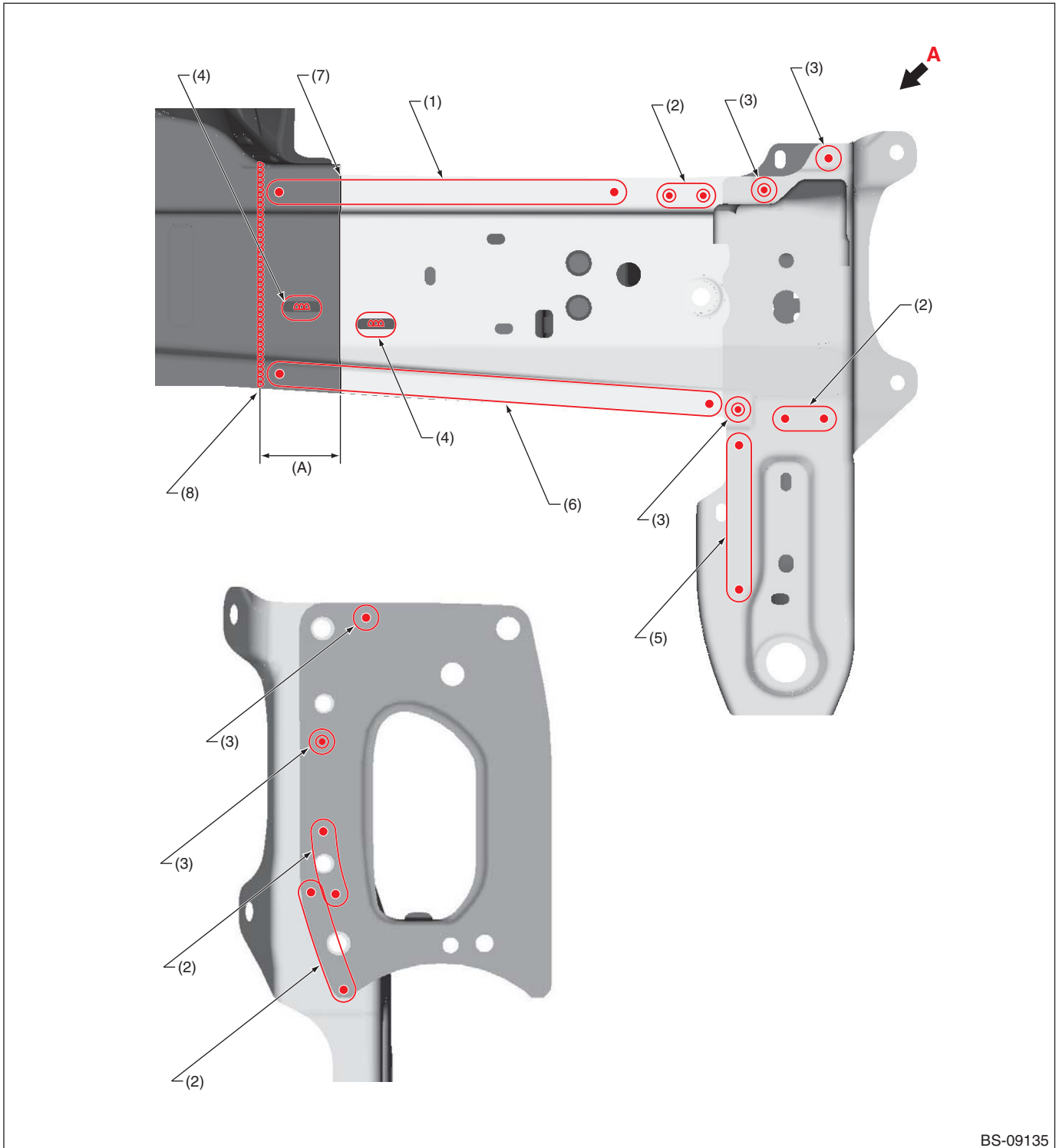


(1) 3 points (top · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BS-09135

(A) 55 mm [2.17 in]

(1) 8 points

(2) 2 points

(3) 1 point

(4) 1 point (Continuous welding)
(10 mm [0.39 in])

(5) 4 points

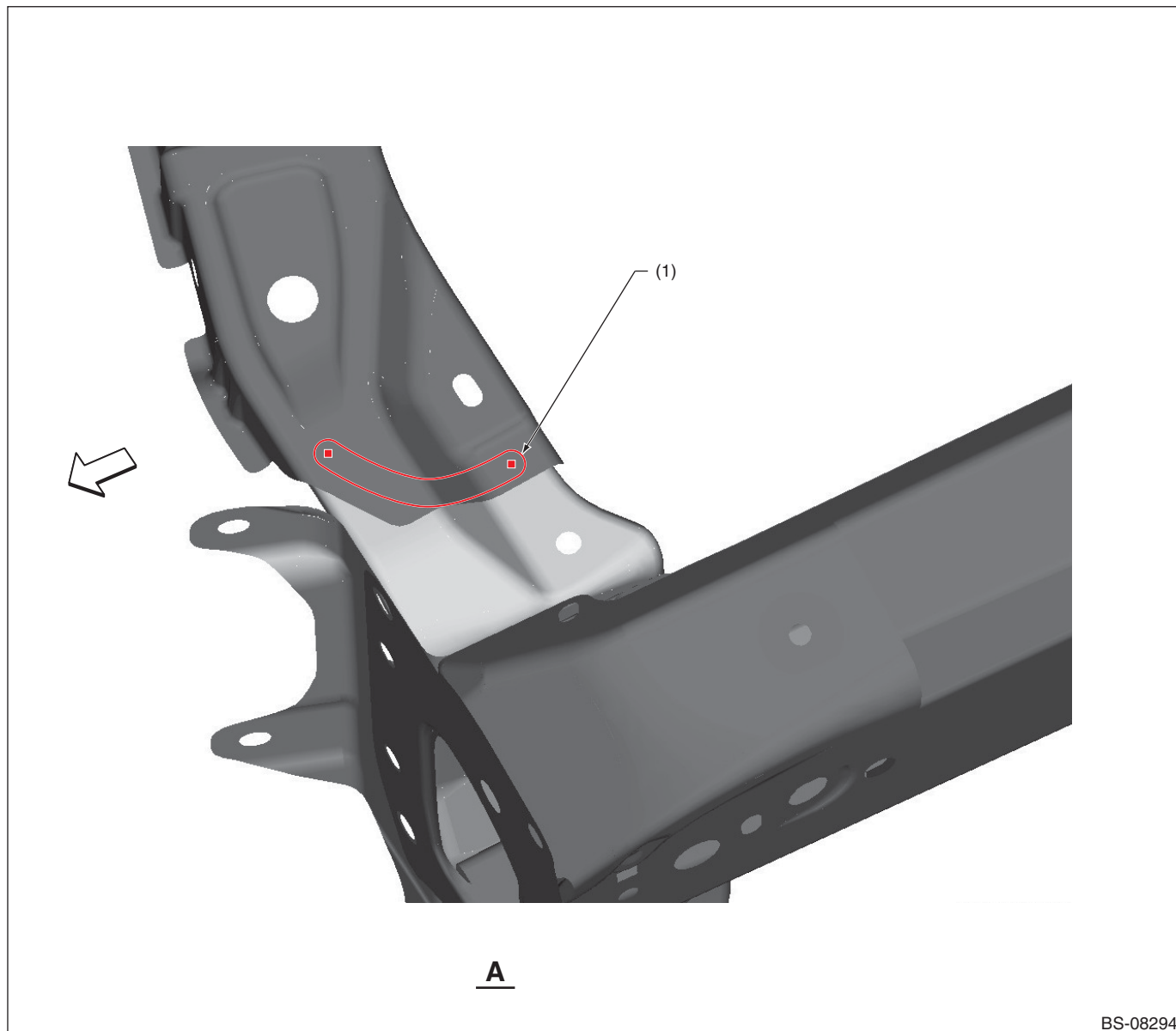
(6) 12 points

(7) Tailored line

(8) 1 point (Continuous welding)

Panel Replacement

• View A



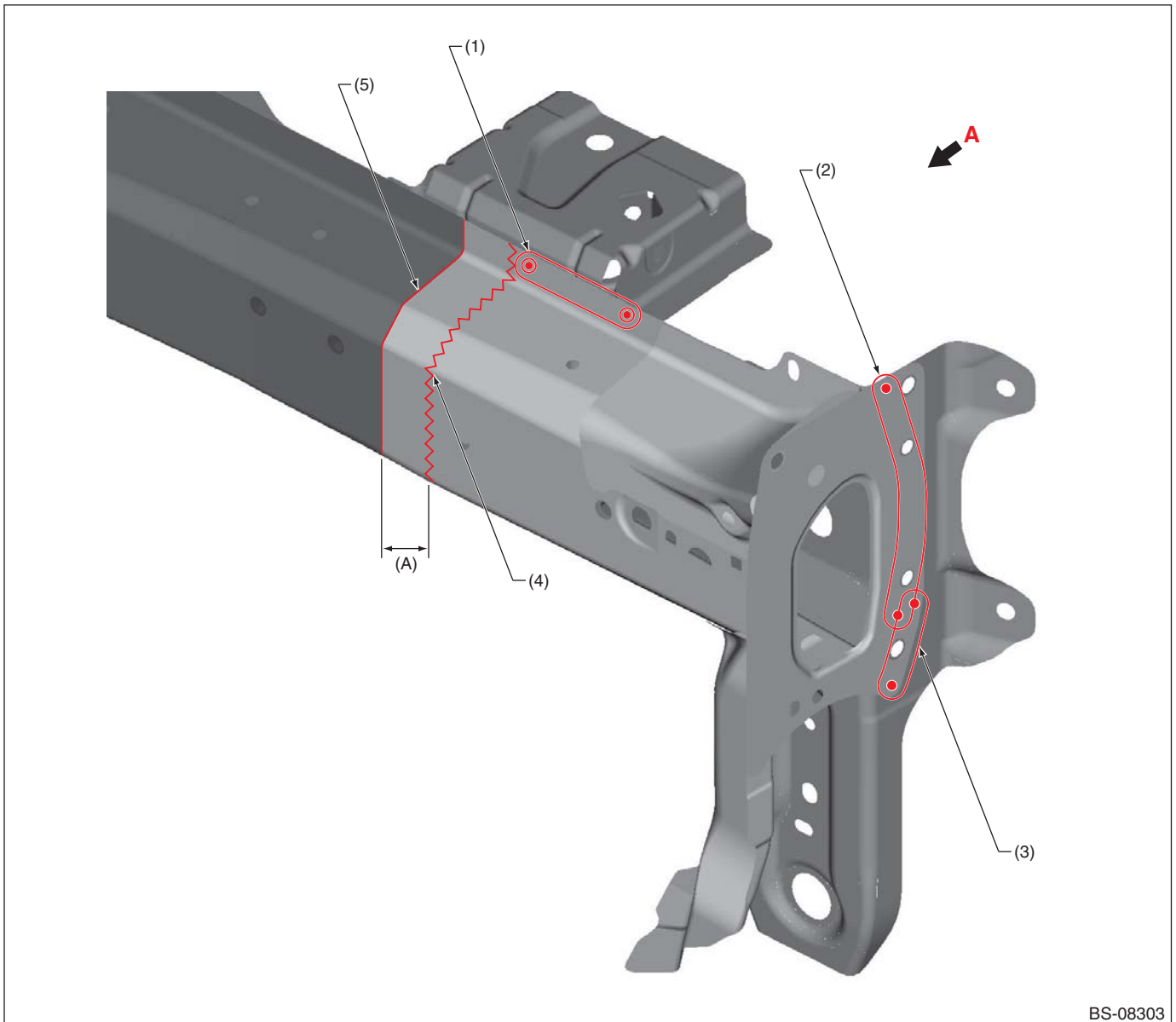
(1) 3 points

Panel Replacement

8-10. Front Side Frame (Partial replacement)

A: REMOVAL

- Overall view (The front wheel apron should be removed depending on level of damage.)



BS-08303

(A) 35 mm [1.38 in]

(1) 3 points (inside · 1)

(2) 4 points (outside · 1)

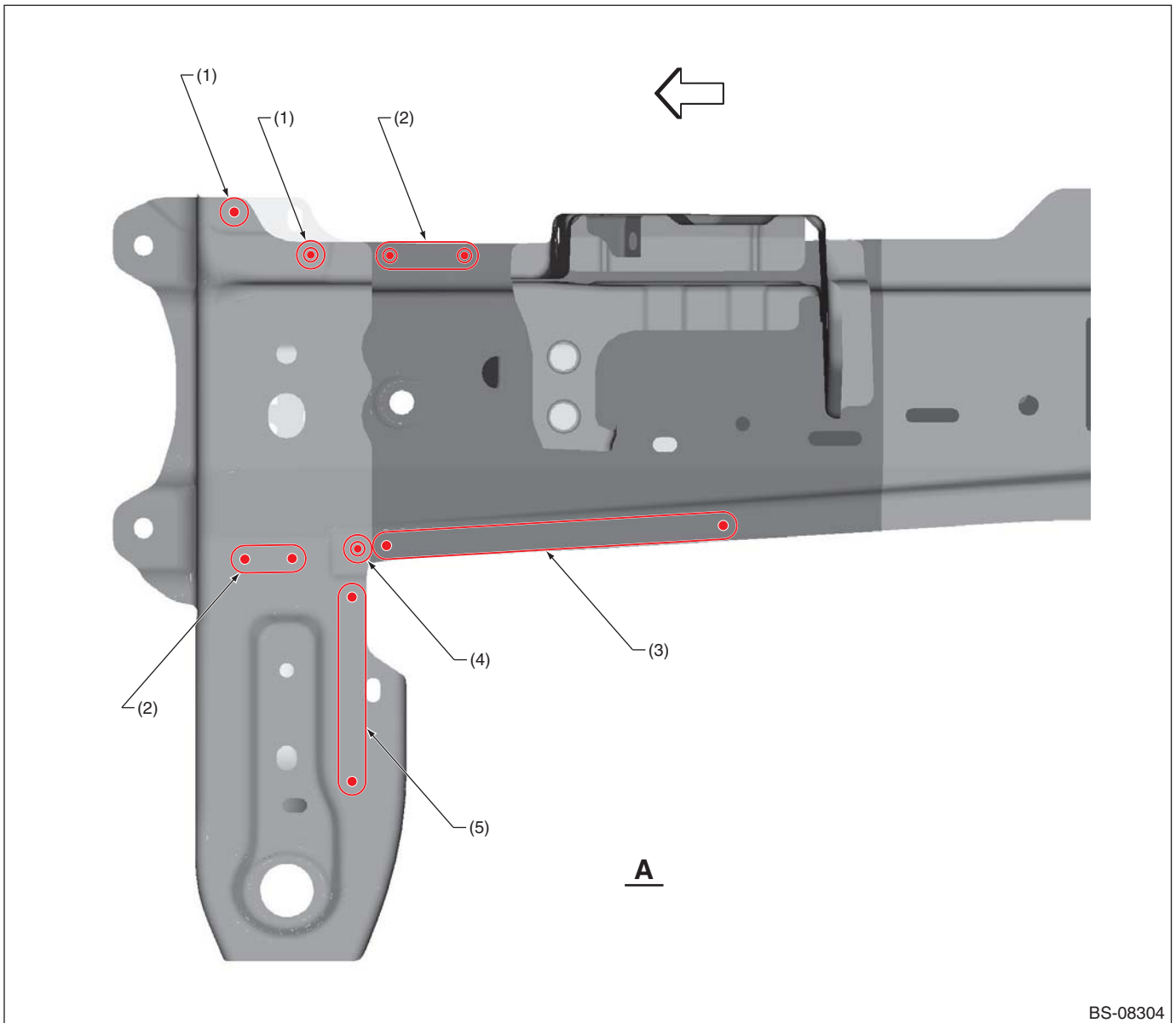
(3) 2 points (outside · 1)

(4) Cut position

(5) Tailored line

Panel Replacement

• View A



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

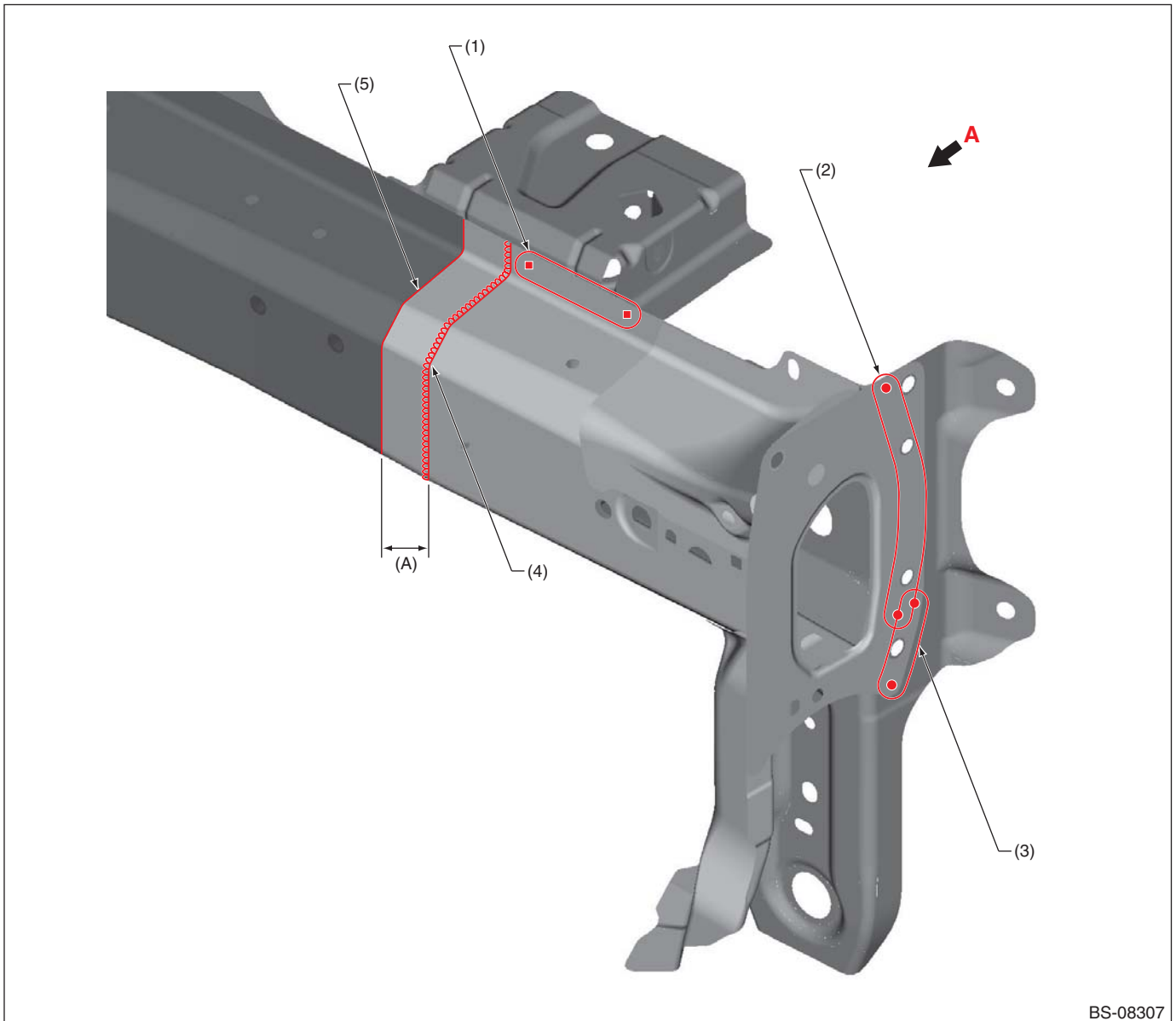
(3) 7 points (outside · 1)
(4) 1 point (outside · 2)

(5) 4 points (outside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



(A) 35 mm [1.38 in]

(1) 3 points (service)

(2) 4 points

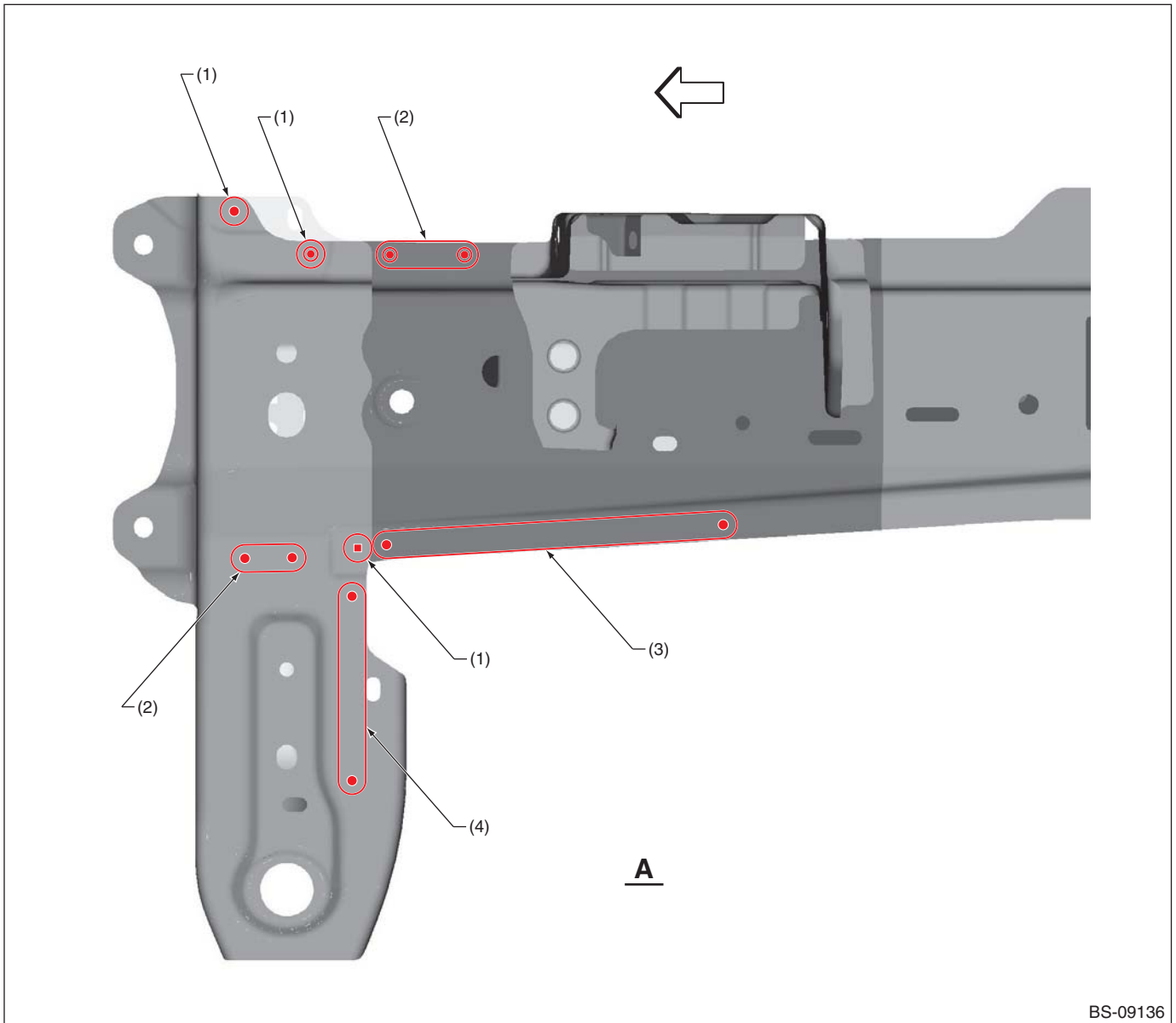
(3) 2 points

(4) 1 point (Continuous welding)

(5) Tailored line

Panel Replacement

• View A



(1) 1 point
(2) 2 points

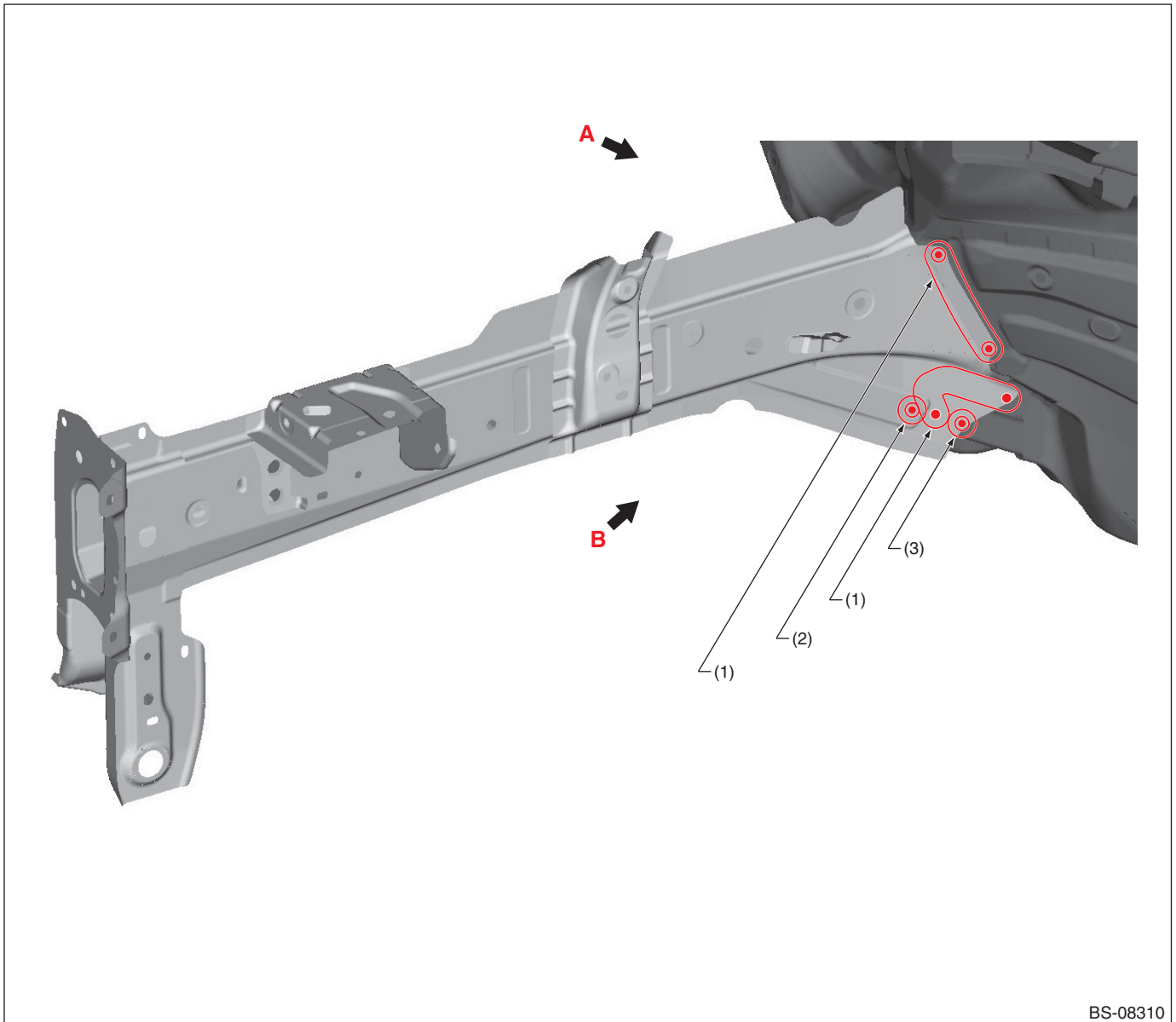
(3) 7 points

(4) 4 points

8-11. Front Side Frame (Total replacement)

A: REMOVAL

- Overall view (The front wheel apron should be removed depending on level of damage.)



BS-08310

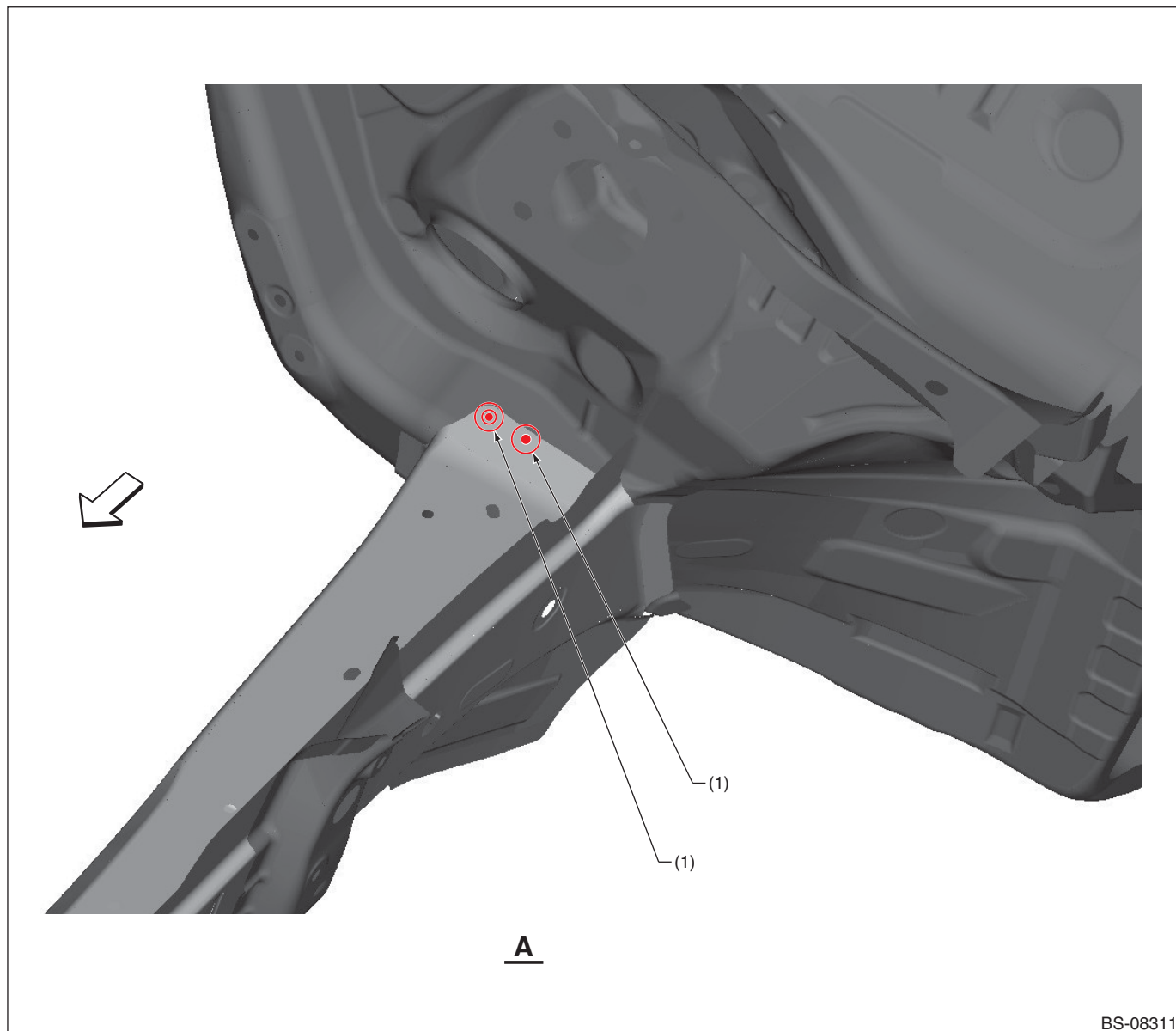
(1) 5 points (outside · 1)

(2) 1 point (outside · 2)

(3) 1 point (outside · 1)

Panel Replacement

• View A

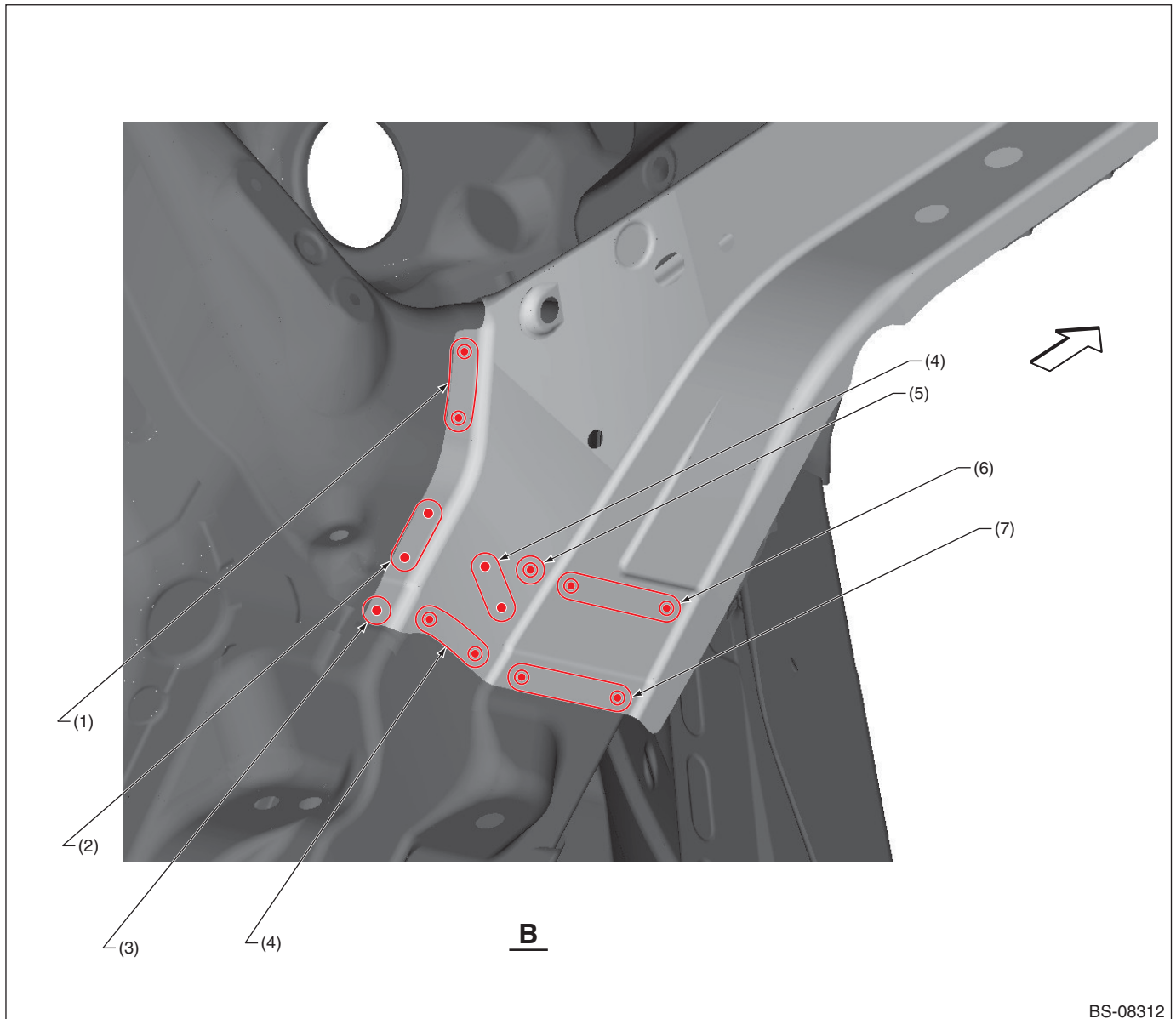


BS-08311

(1) 1 point (top · 1)

Panel Replacement

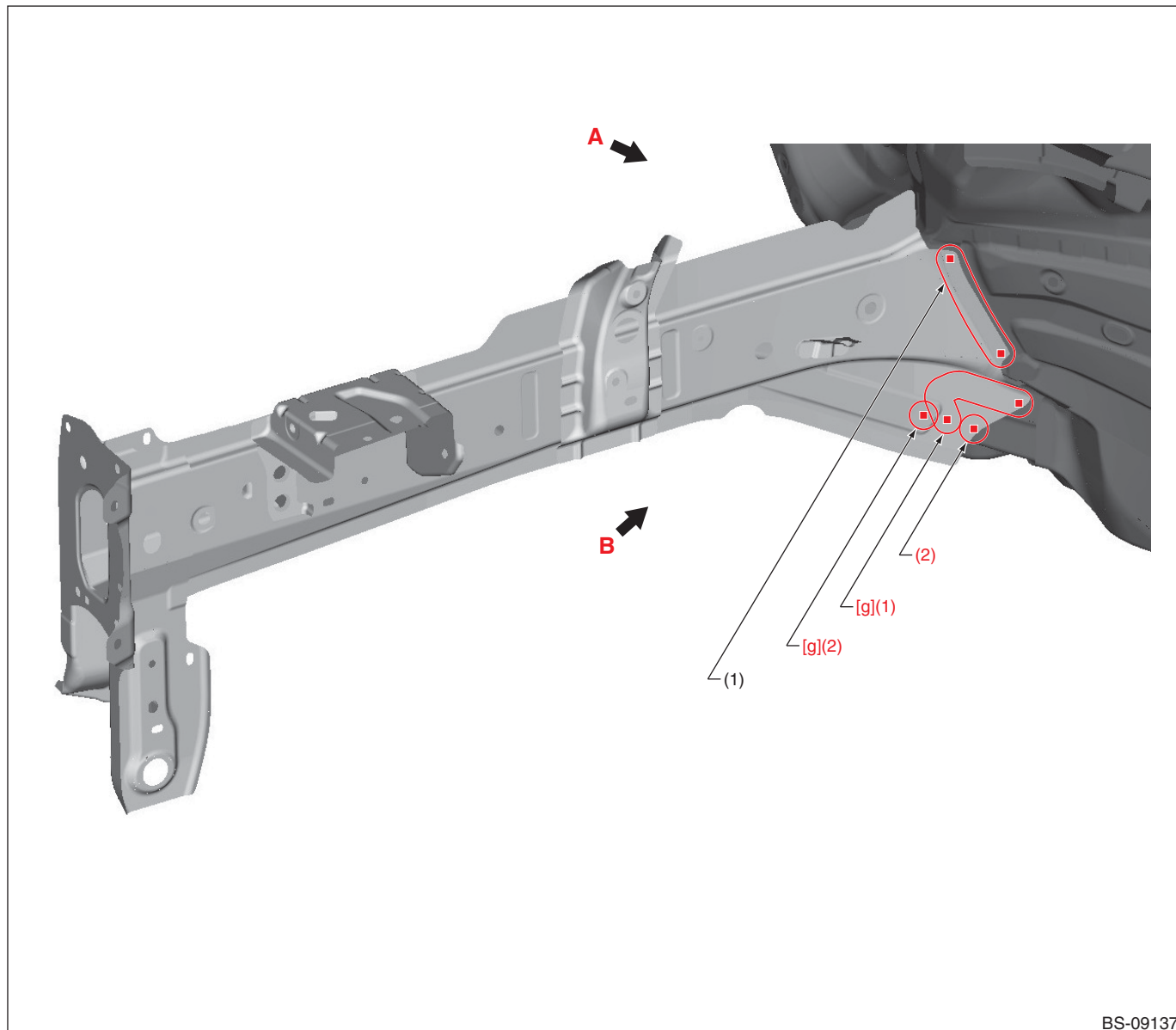
• View B



Panel Replacement

B: INSTALLATION

• Overall view



BS-09137

(1) 5 points (service)

(2) 1 point (service)

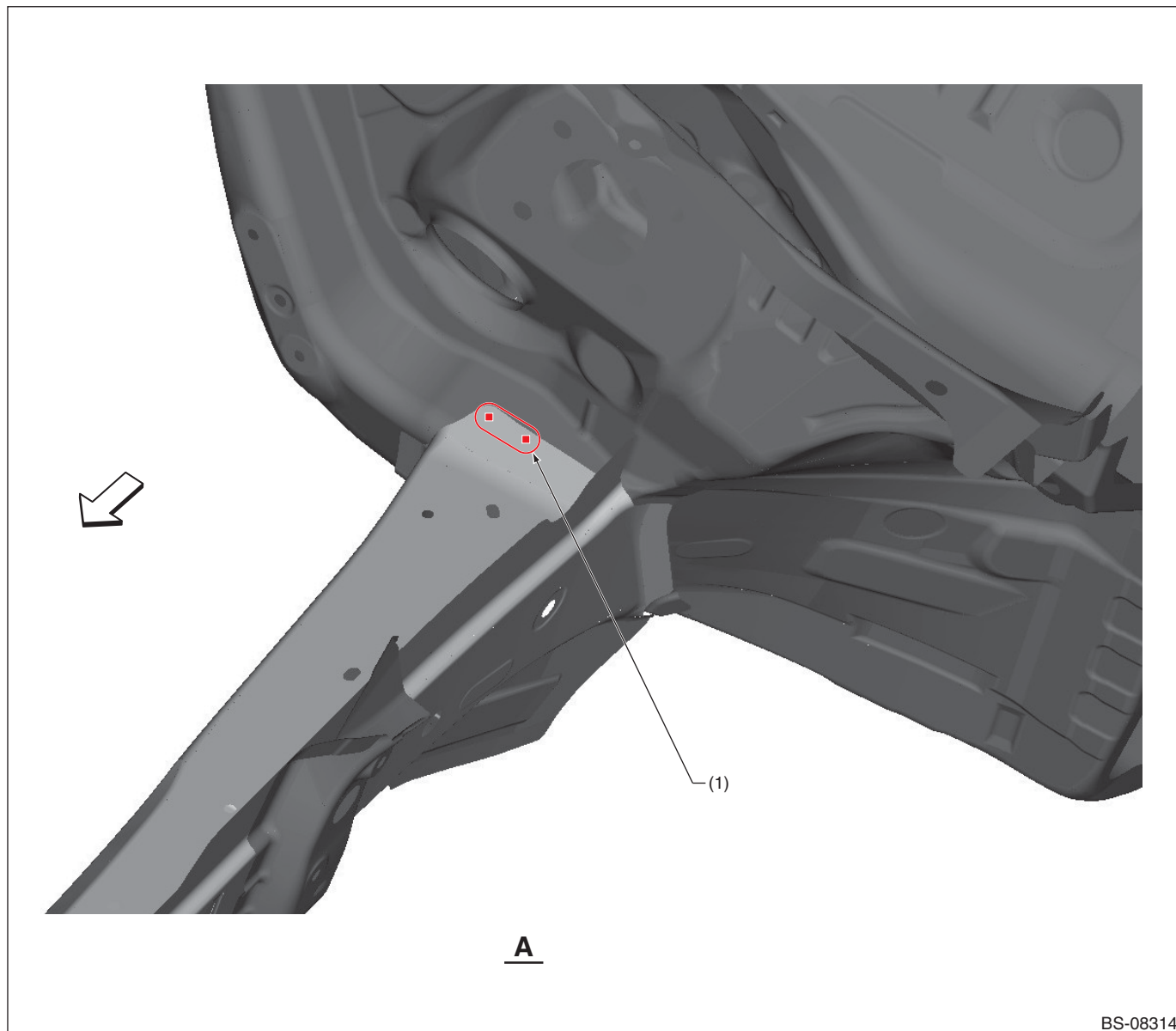
[g] Plug welding

A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2

B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

- View A

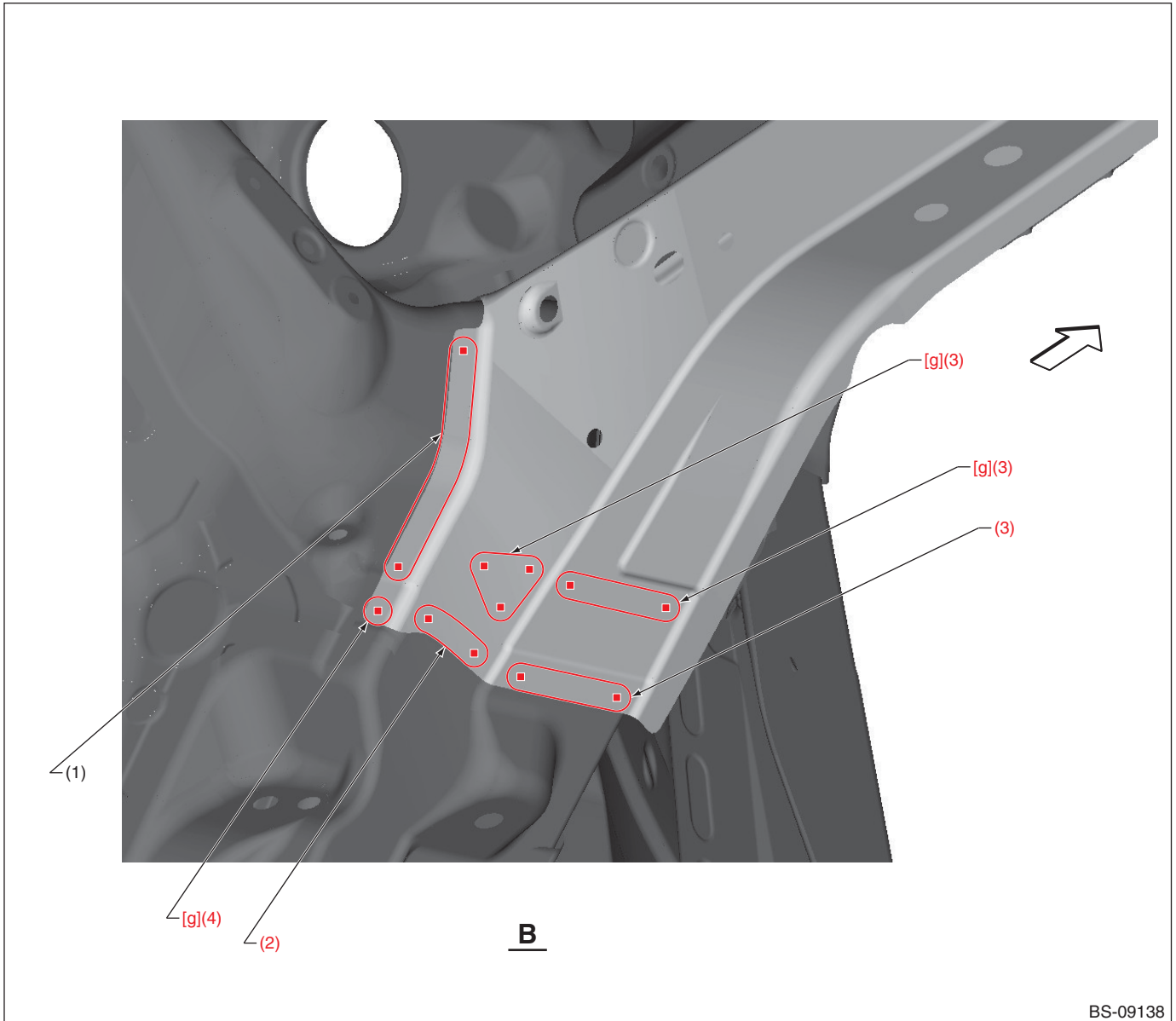


BS-08314

(1) 2 points (service)

Panel Replacement

• View B



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

(3) 3 points (service)

(4) 1 point (service)

[g] Plug welding

A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2

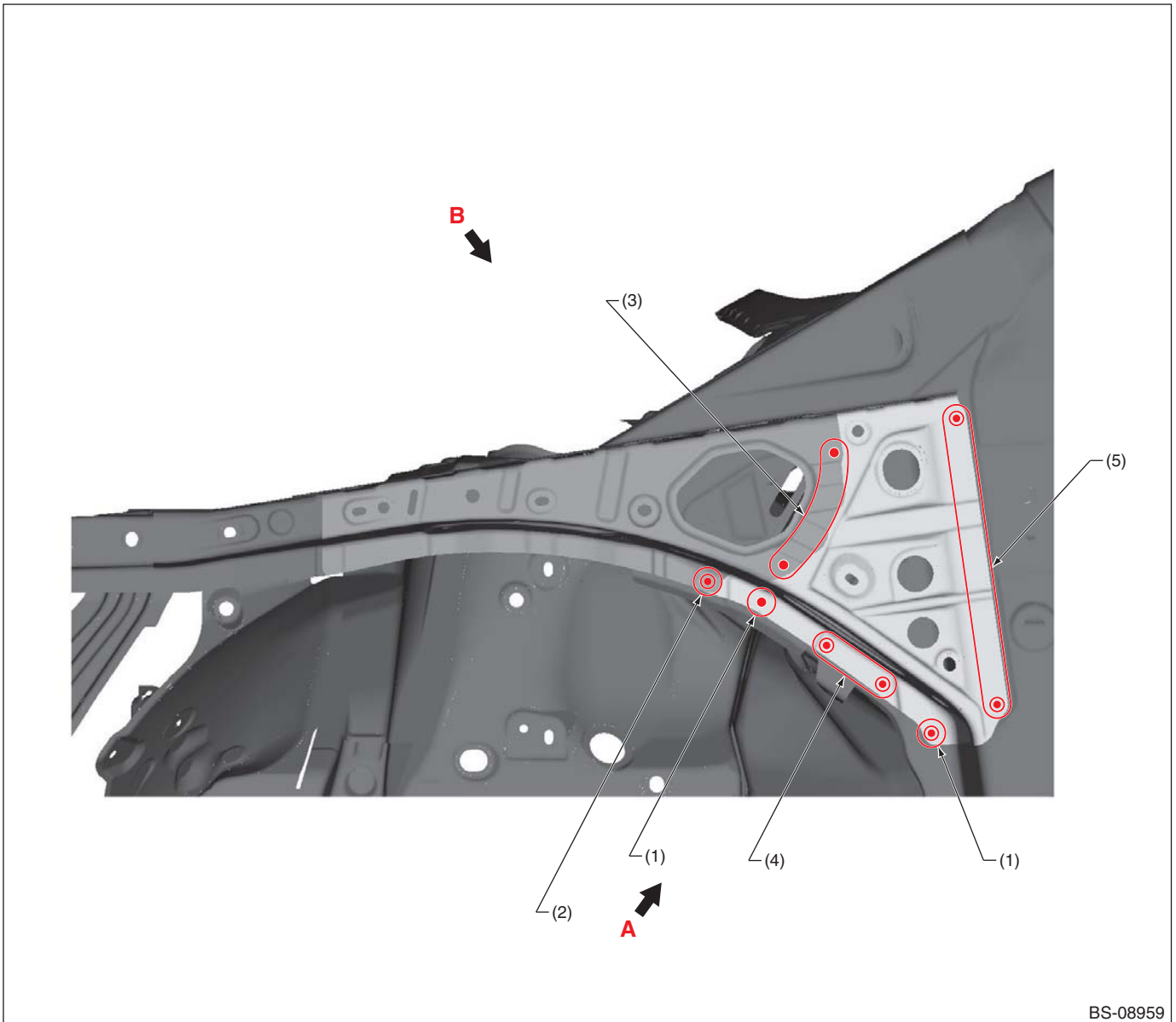
B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

8-12. Front Pillar Outer (Partial replacement)

A: REMOVAL

• Overall view 1



BS-08959

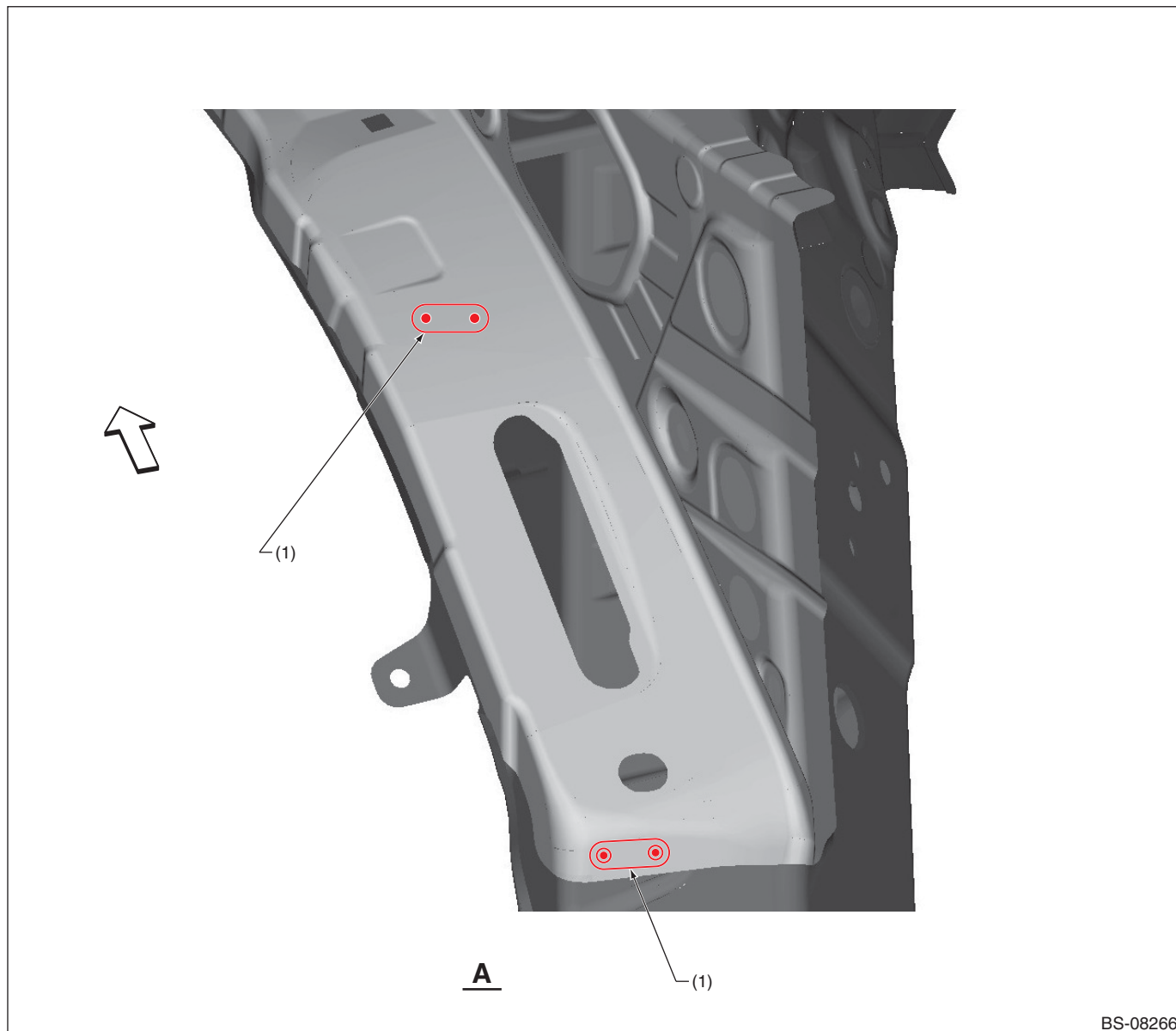
(1) 1 point (outside · 1)
(2) 1 point (outside · 2)

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

(5) 5 points (outside · 1)

Panel Replacement

• View A

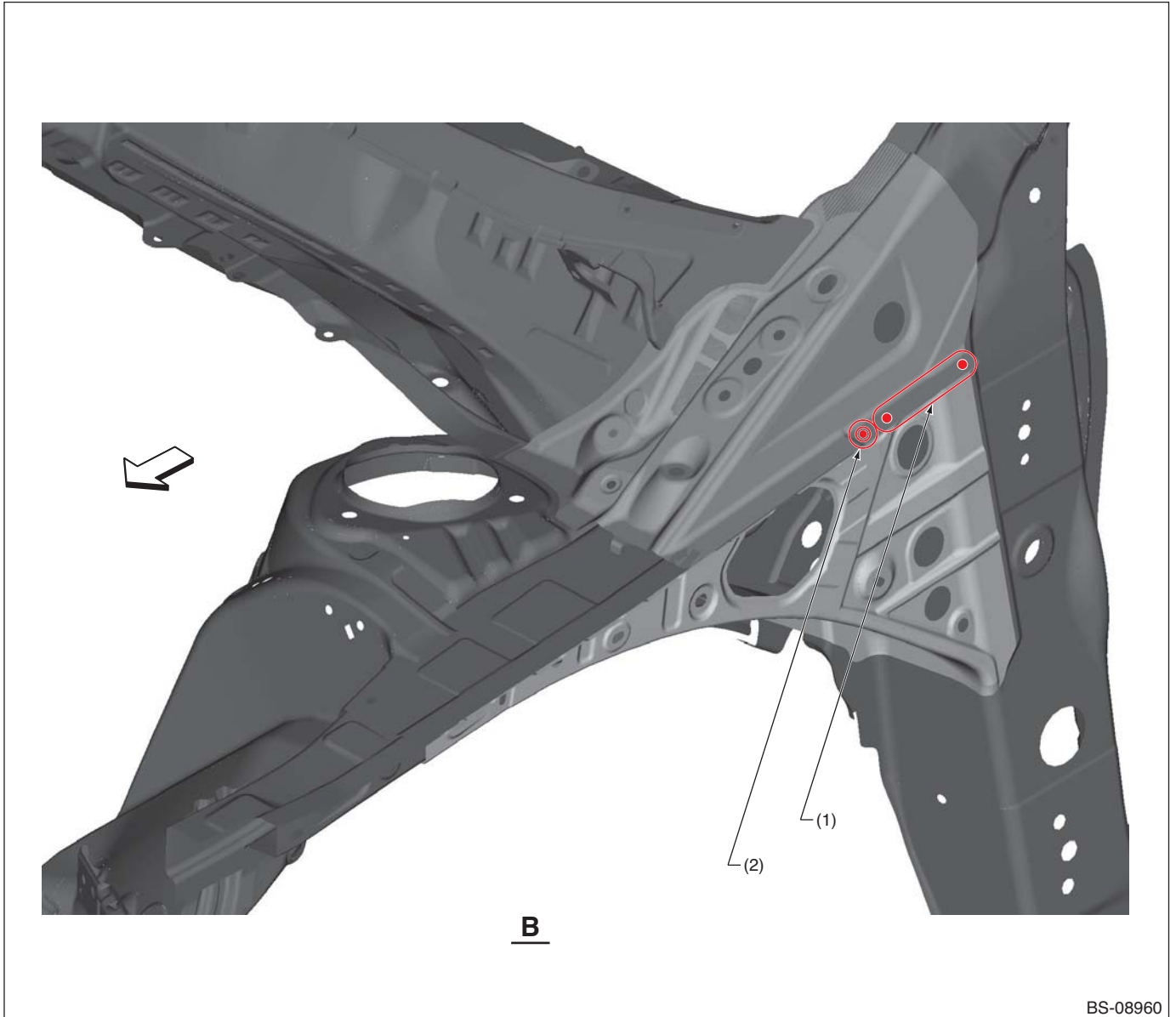


BS-08266

(1) 2 points (outside · 1)

Panel Replacement

• View B

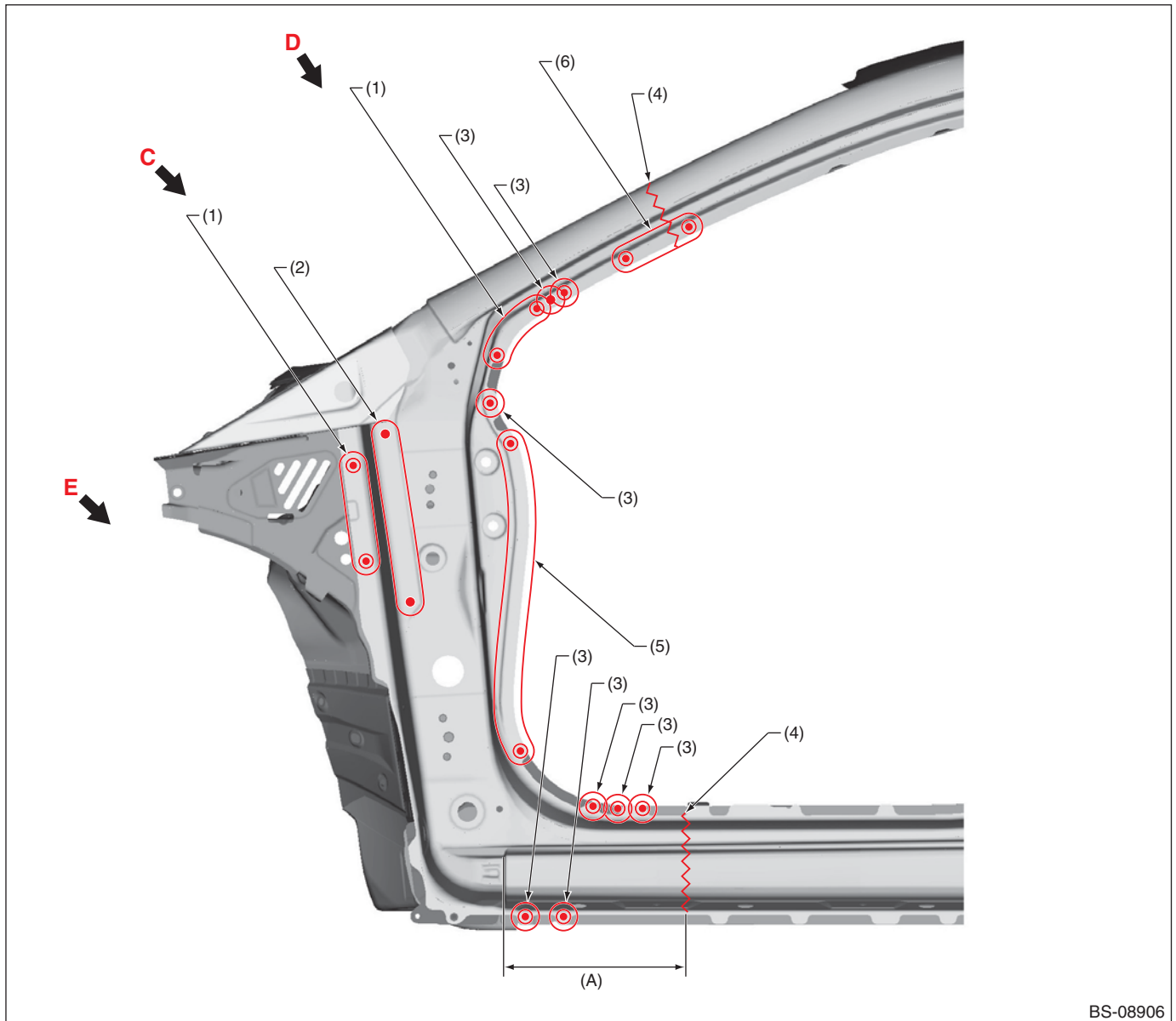


(1) 3 points (top · 1)

(2) 1 point (top · 2)

Panel Replacement

• Overall view 2



BS-08906

(A) 260 mm [10.24 in]

(1) 3 points (outside · 1)

(2) 5 points (outside · 1)

(3) 1 point (outside · 1)

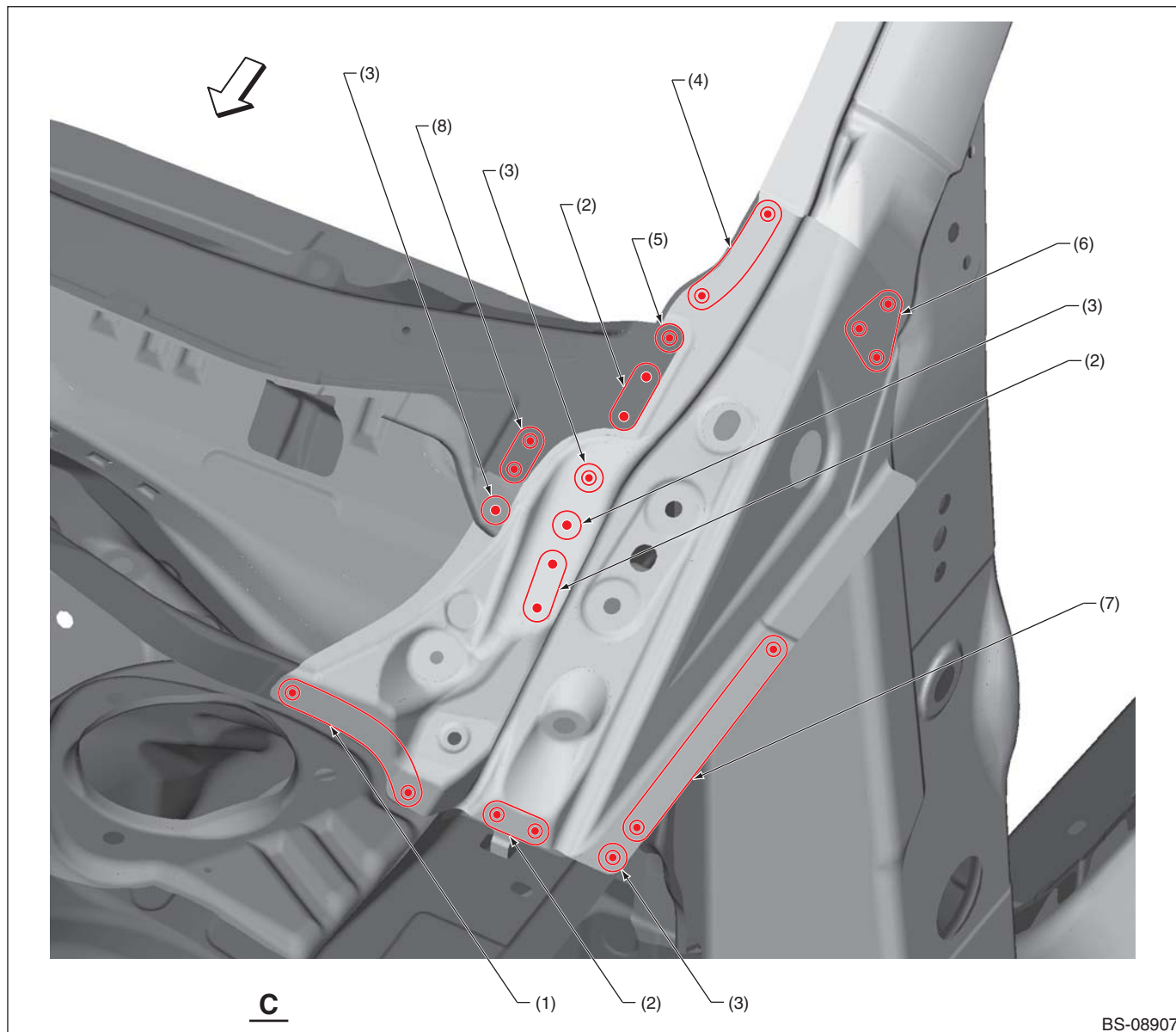
(4) Cut position

(5) 15 points (outside · 1)

(6) 4 points (outside · 1)

Panel Replacement

• View C



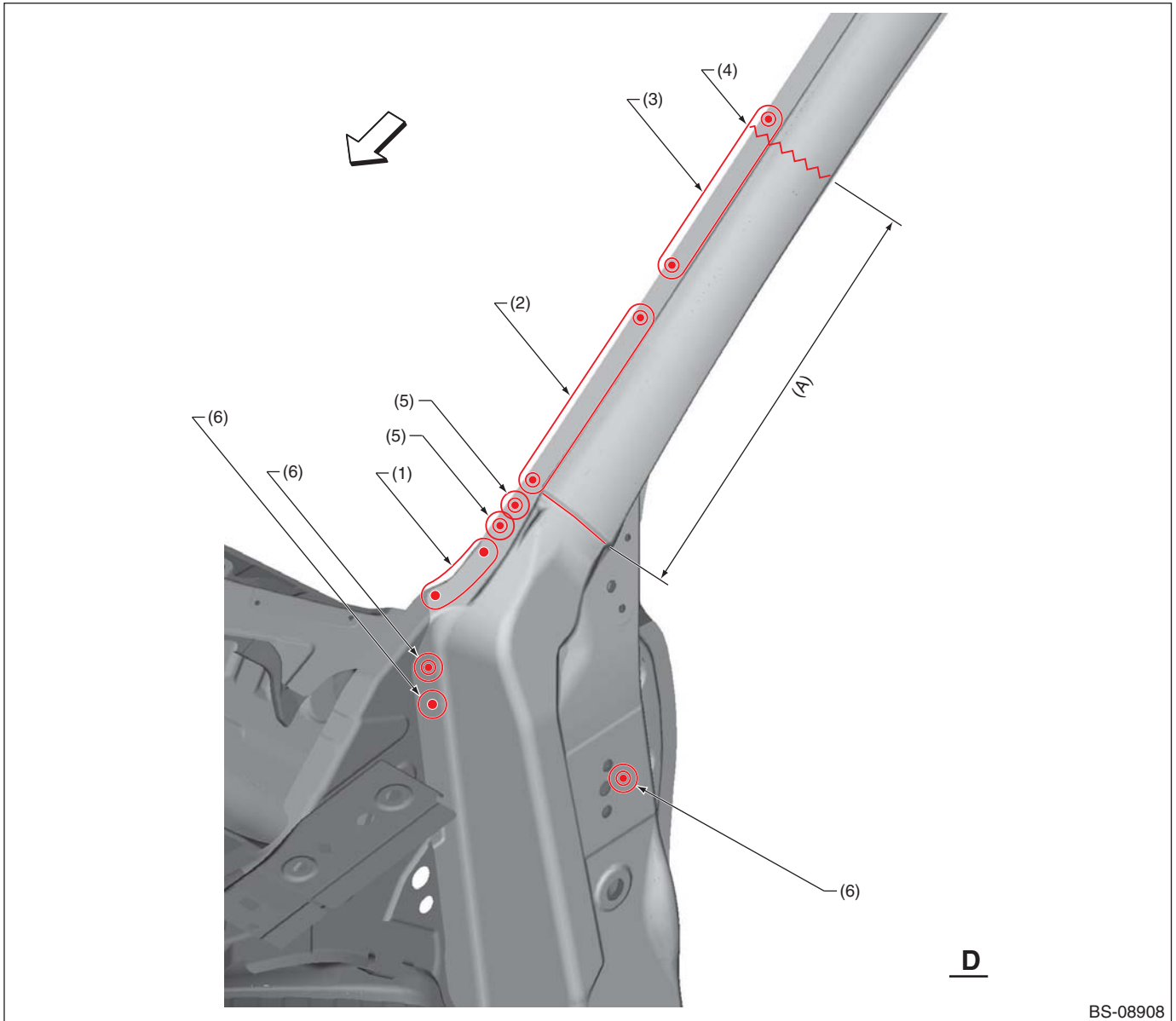
(1) 4 points (top · 1)
(2) 2 points (top · 1)
(3) 1 point (top · 1)

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

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

Panel Replacement

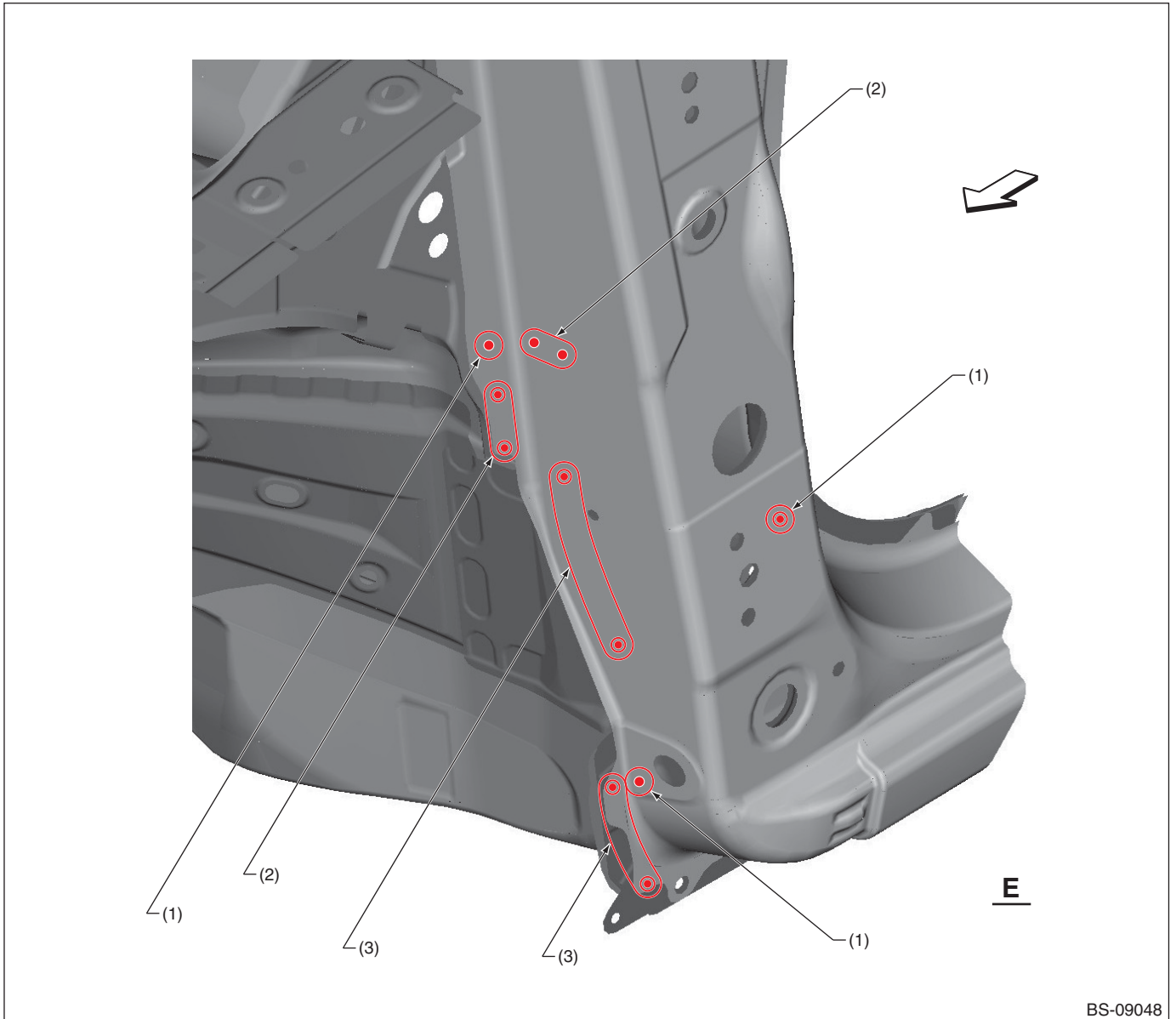
• View D



BS-08908

Panel Replacement

• View E



BS-09048

(1) 1 point (outside · 1)

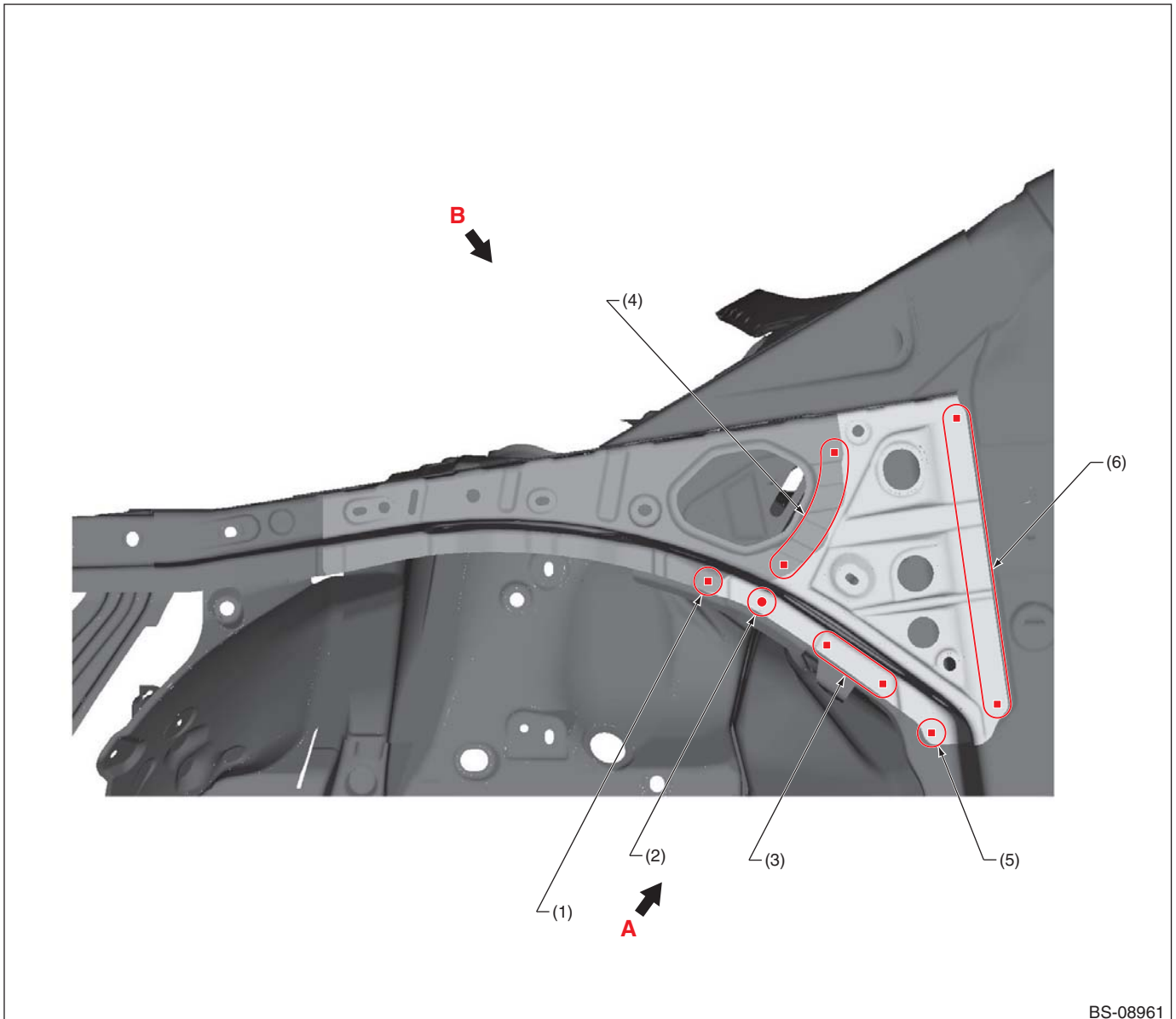
(2) 2 points (outside · 1)

(3) 3 points (outside · 1)

Panel Replacement

B: INSTALLATION

• Overall view 1



BS-08961

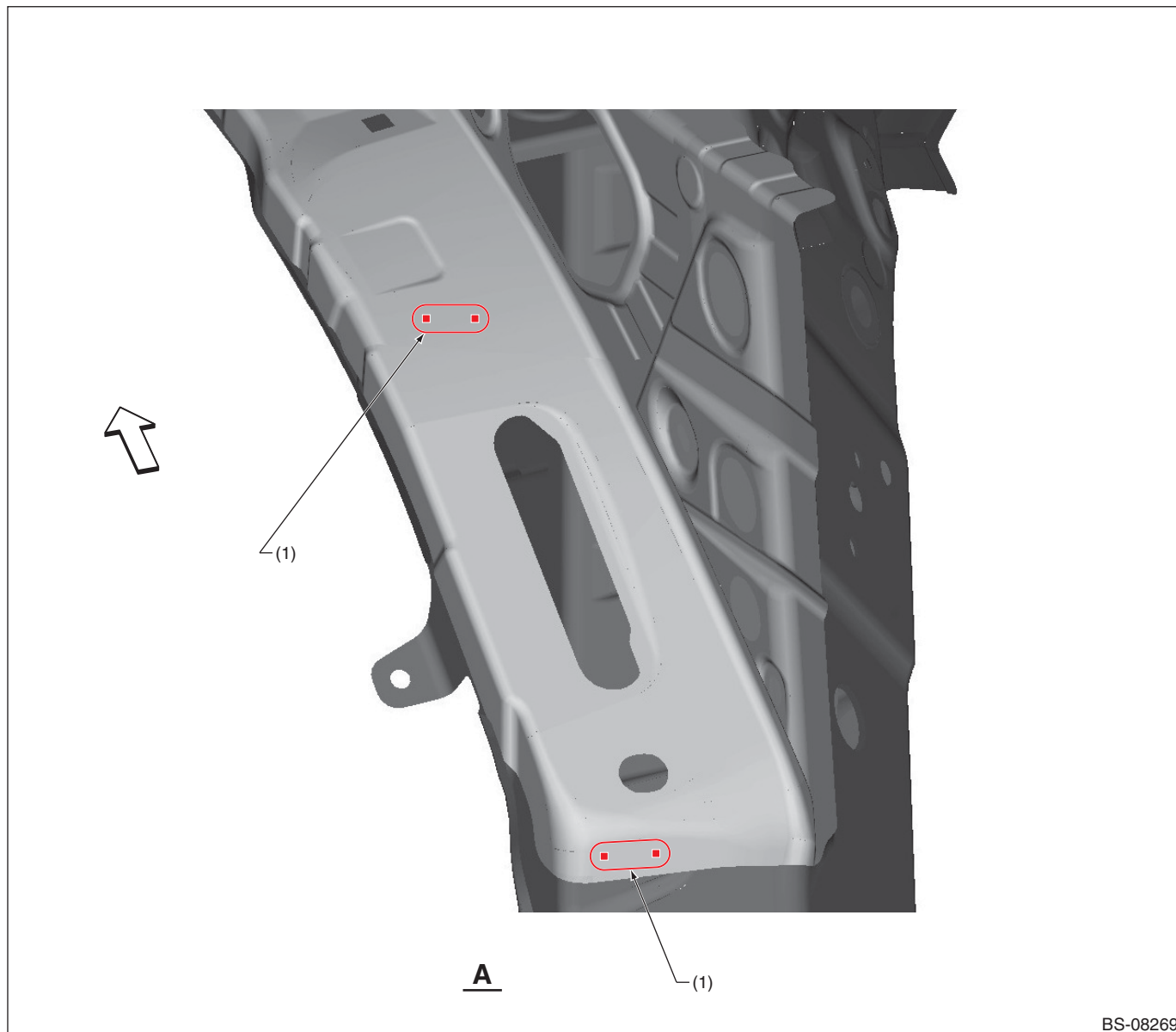
(1) 1 point (service · matching)
(2) 1 point

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

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

Panel Replacement

• View A

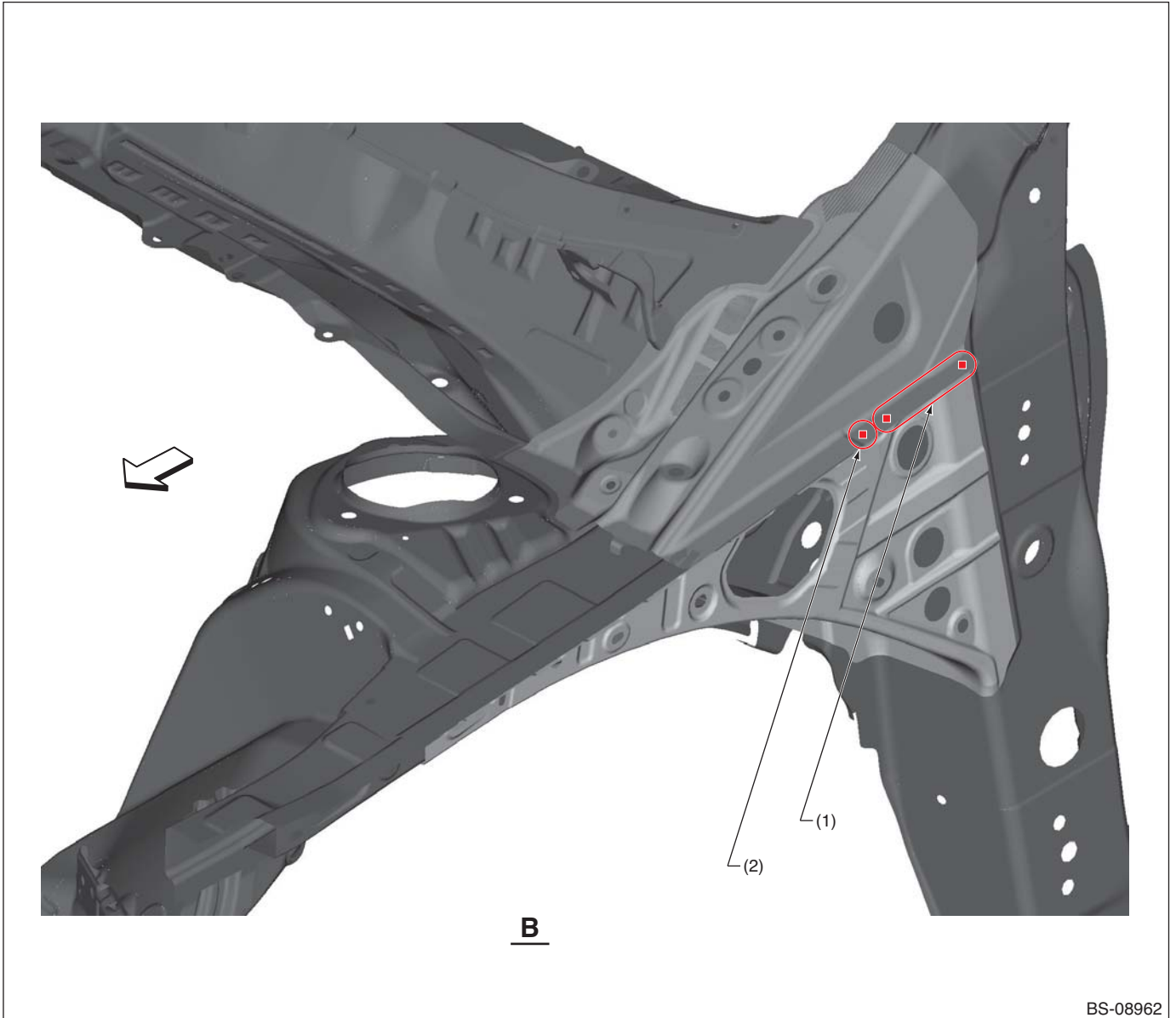


BS-08269

(1) 2 points (service)

Panel Replacement

- View B

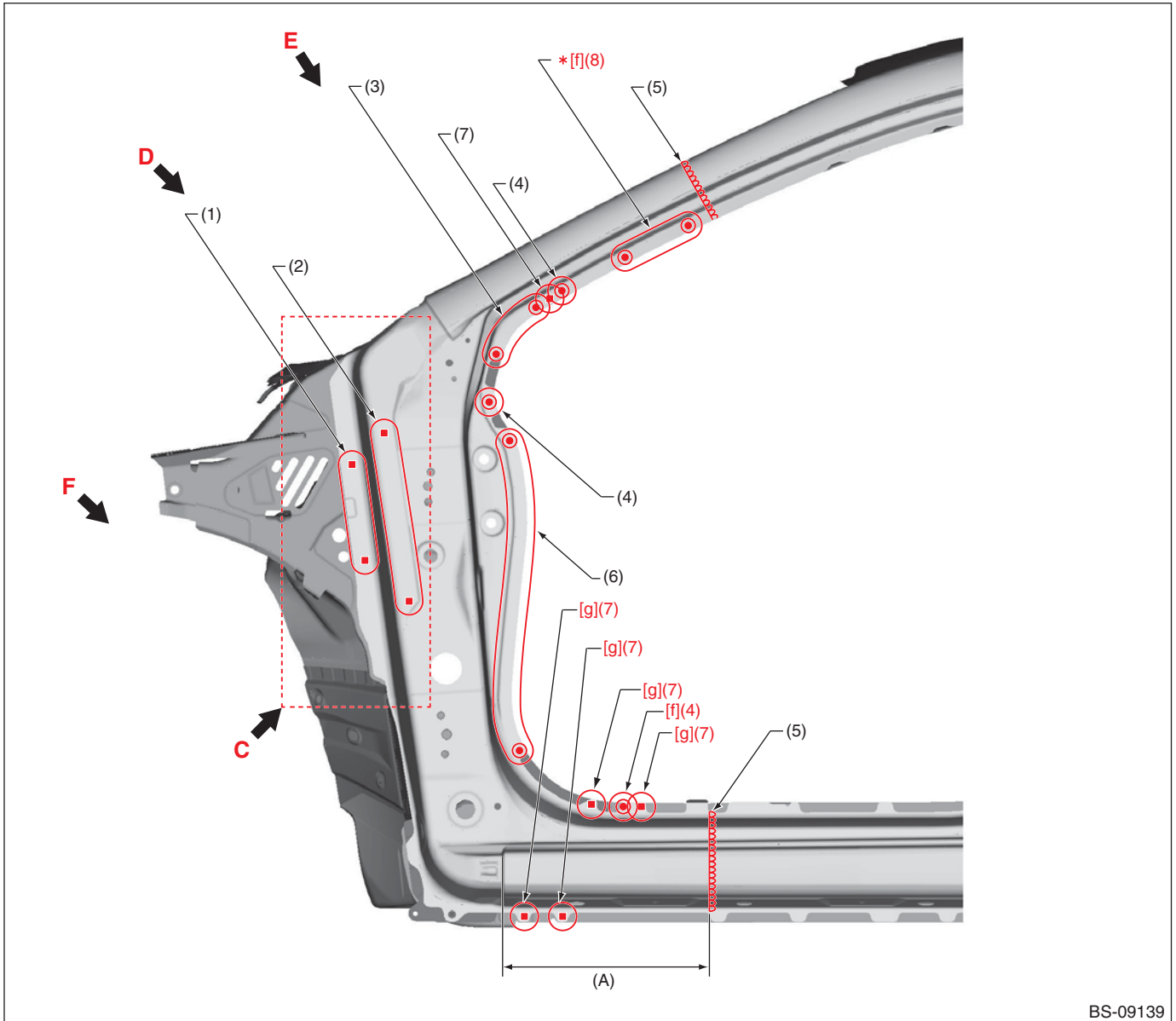


(1) 3 points

(2) 1 point

Panel Replacement

• Overall view 2



(A) 290 mm [11.42 in]

(1) 3 points (service)

(2) 5 points (service)

(3) 3 points

(4) 1 point

(5) 1 point (Continuous welding)

(6) 15 points

(7) 1 point (service)

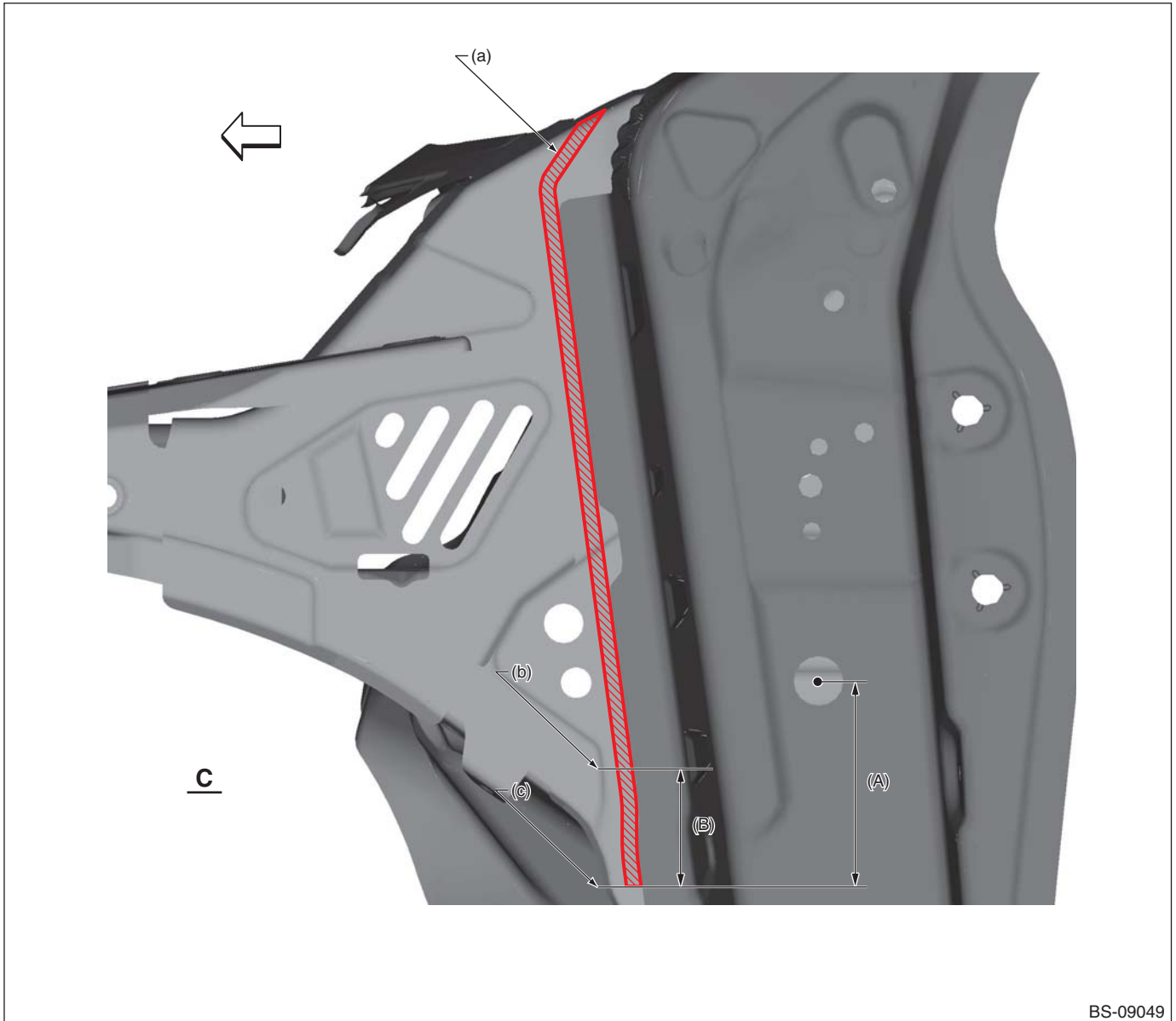
(8) 4 points

* : LH only has welding condition.

[f] Spot welding	Compression: 4.4 kN, Current: 8.0 kA, Welding time: 25 cyc
[g] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2 B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

• View C



BS-09049

(A) 104 mm [4.09 in]

(B) 55 mm [2.17 in]

(a) A point

(b) B point

(c) C point

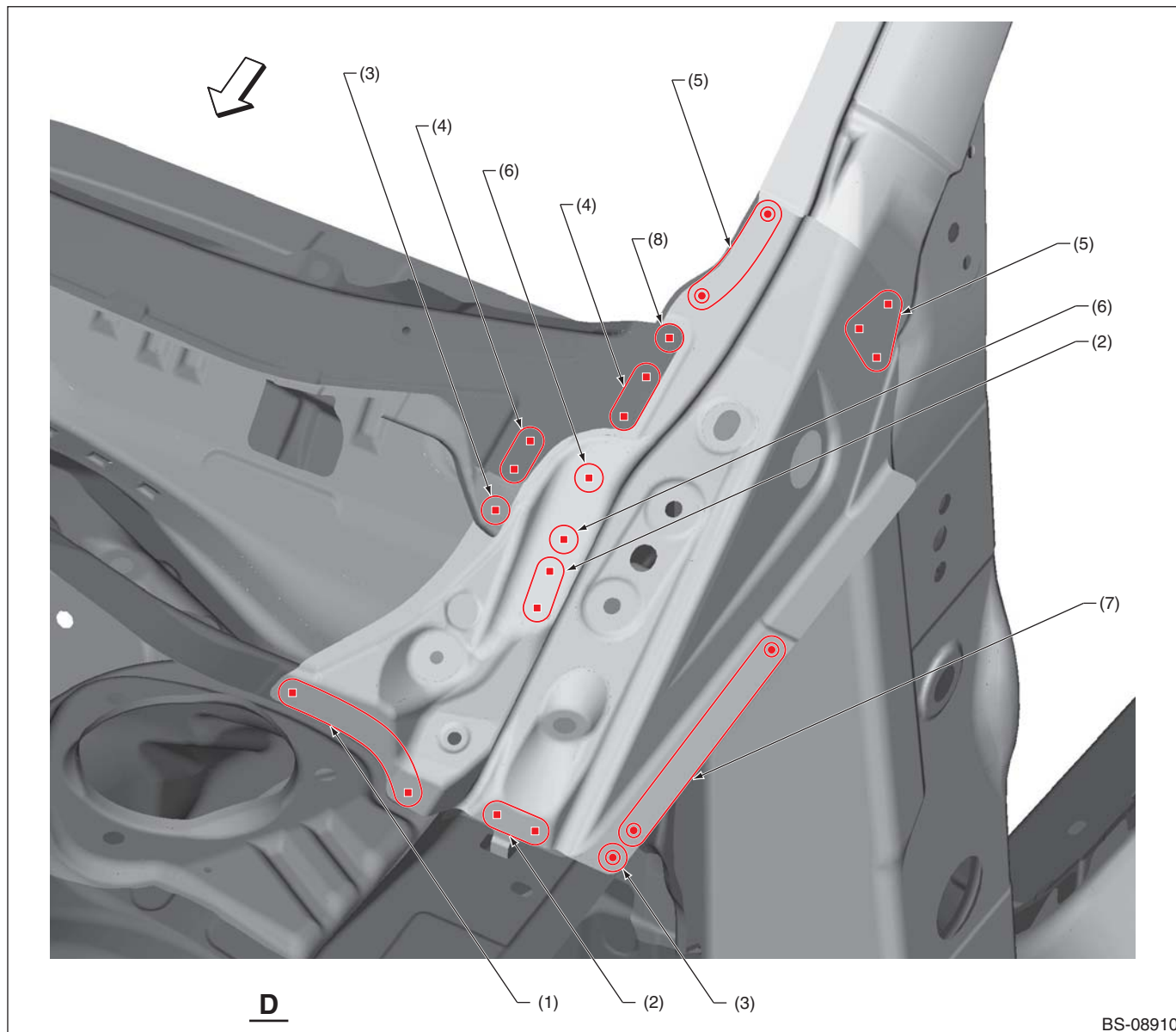
 : Spotting sealer application location (Spotting sealer or sealing [Three Bond 4101 (004403063)])

Note:

- (a) is radius curve end of the side outer panel.
- Apply sealer between (a) and (c).
- Check for stray sealer in any point between (b) and (c).

Panel Replacement

• View D



BS-08910

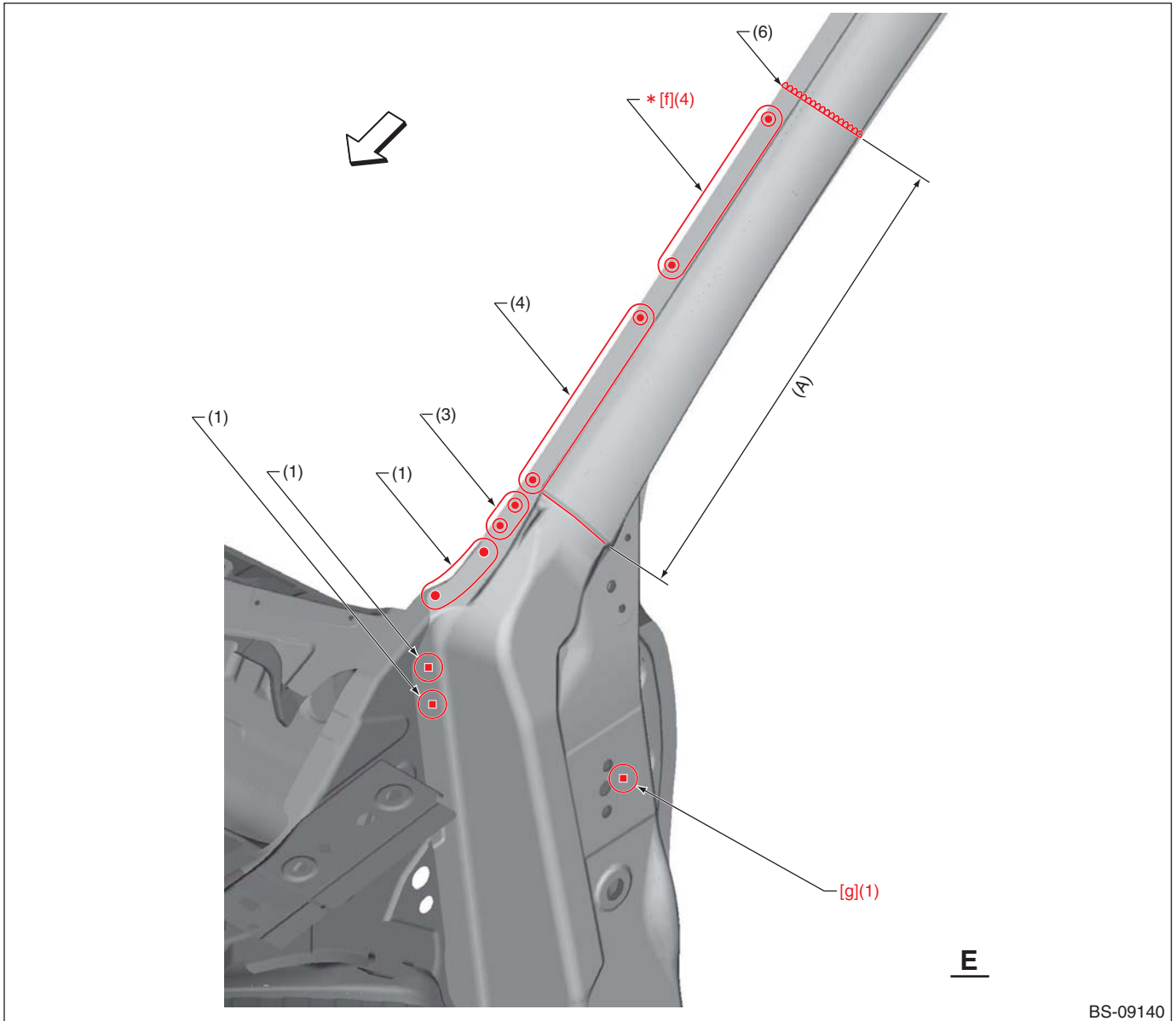
- (1) 4 points (service)
- (2) 2 points (service)
- (3) 1 point

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

- (7) 3 points
- (8) 1 point (service · matching)

Panel Replacement

• View E



BS-09140

(A) 400 mm [15.75 in]

(1) 1 point (service)

(2) 3 points

(3) 5 points

(4) 4 points

(5) 1 point (Continuous welding)

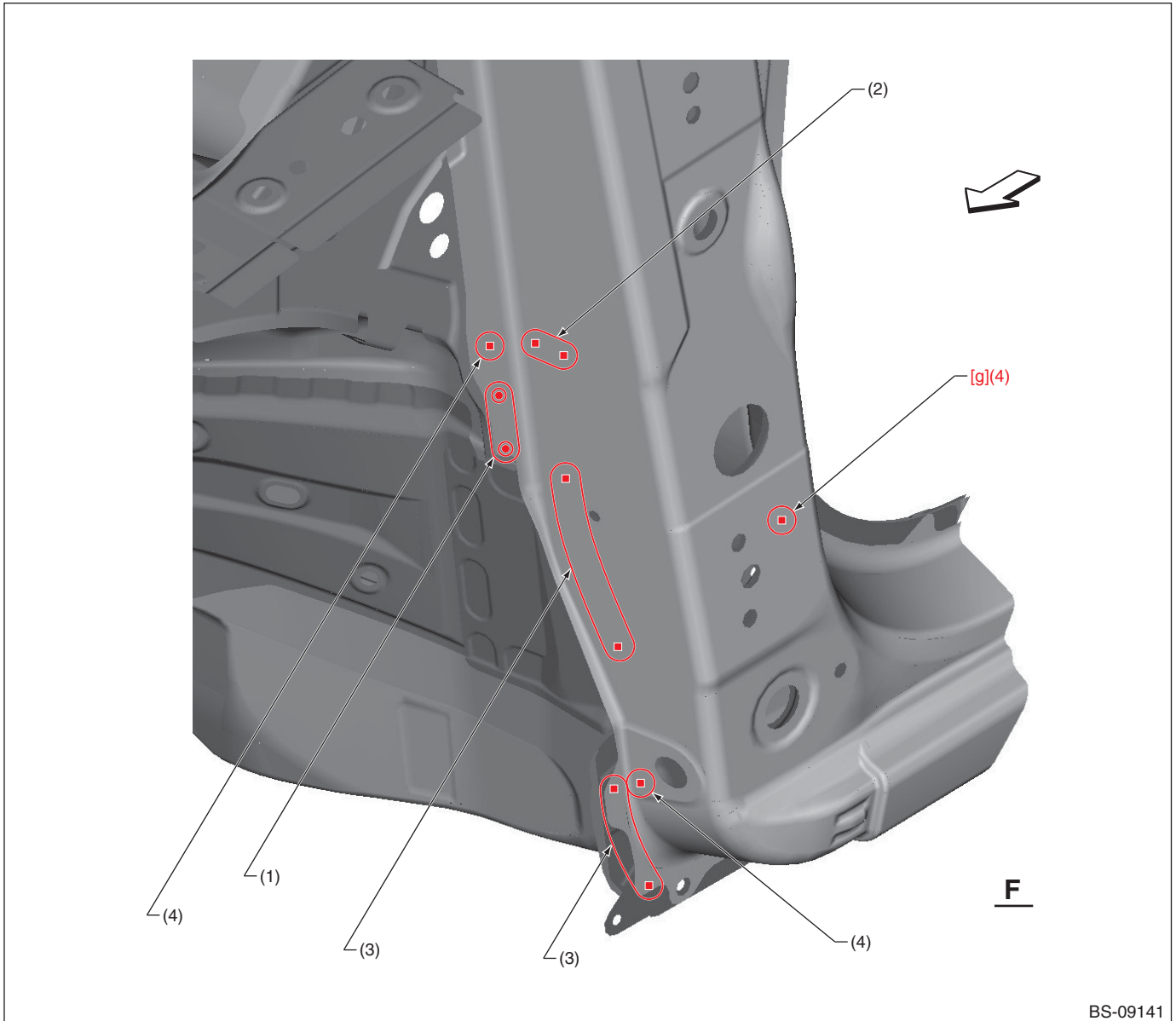
(6) 1 point

* : LH only has welding condition.

[f] Spot welding	Compression: 4.4 kN, Current: 8.0 kA, Welding time: 25 cyc
[g] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2 B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

• View F



BS-09141

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

(3) 3 points (service)

(4) 1 point (service)

[g] Plug welding

A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2

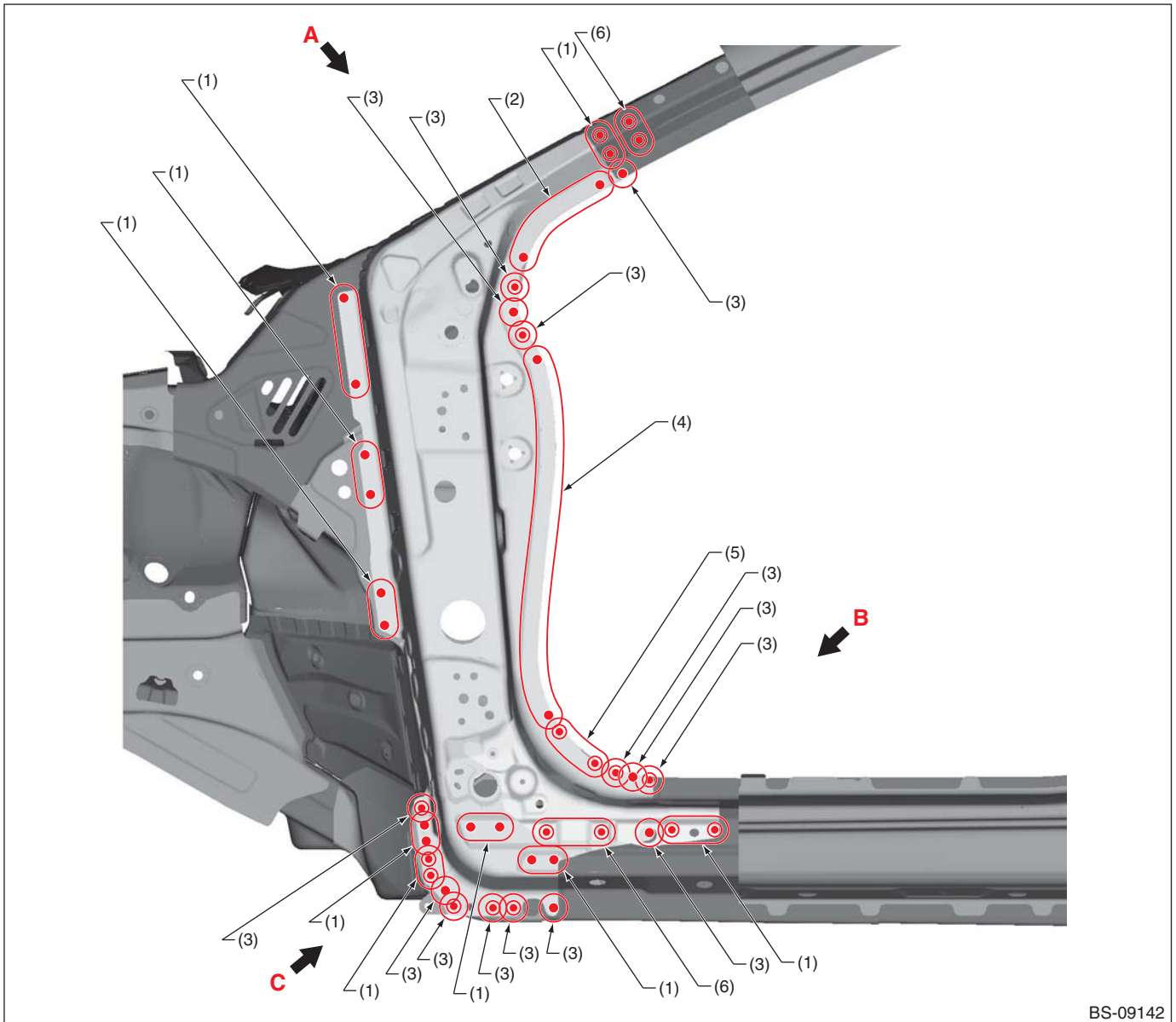
B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

8-13. Front Pillar Reinforcement (Total replacement)

A: REMOVAL

• Overall view



BS-09142

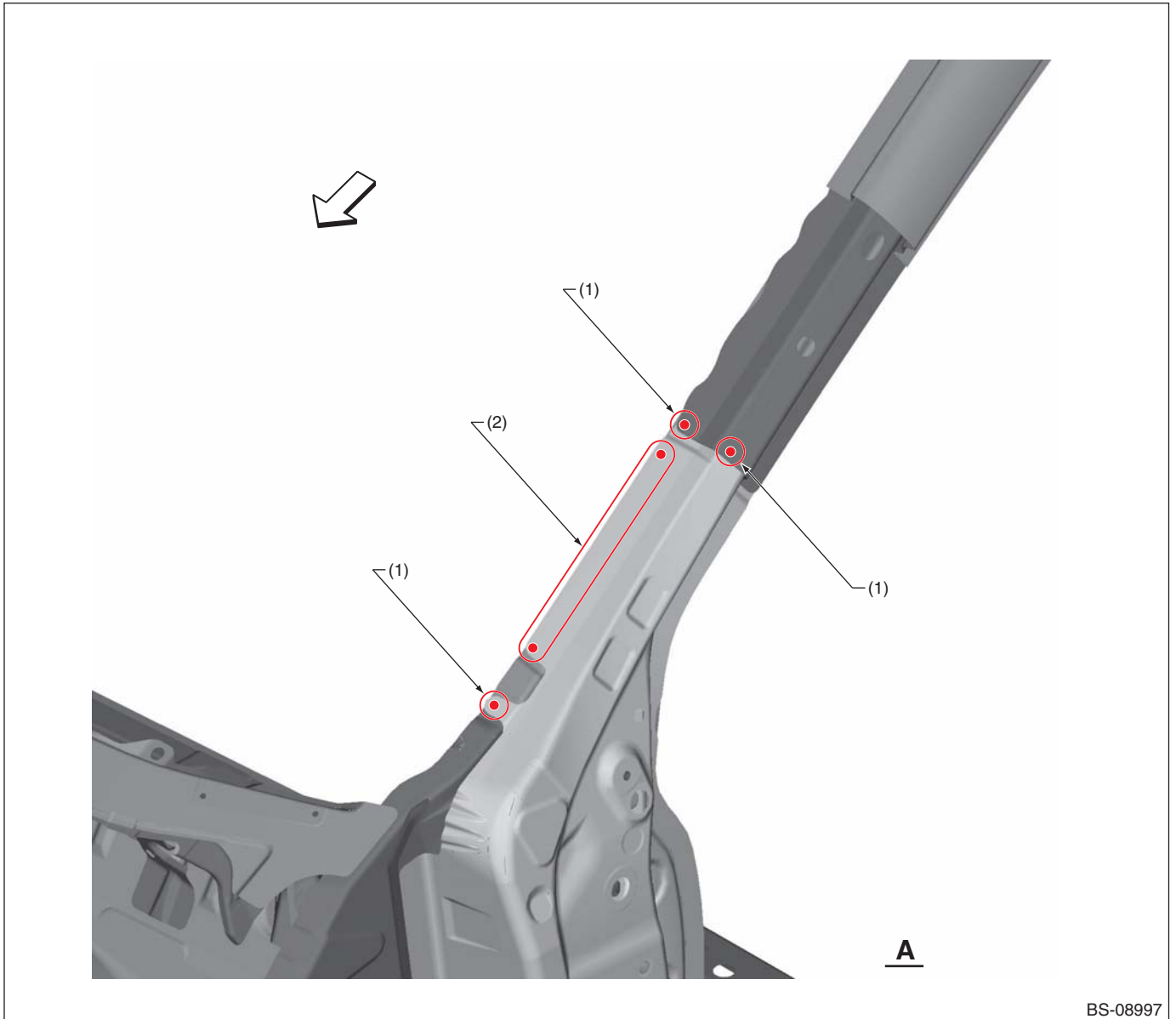
(1) 2 points (outside · 1)
(2) 4 points (outside · 1)

(3) 1 point (outside · 1)
(4) 15 points (outside · 1)

(5) 3 points (outside · 1)
(6) 2 points (outside · 2)

Panel Replacement

• View A



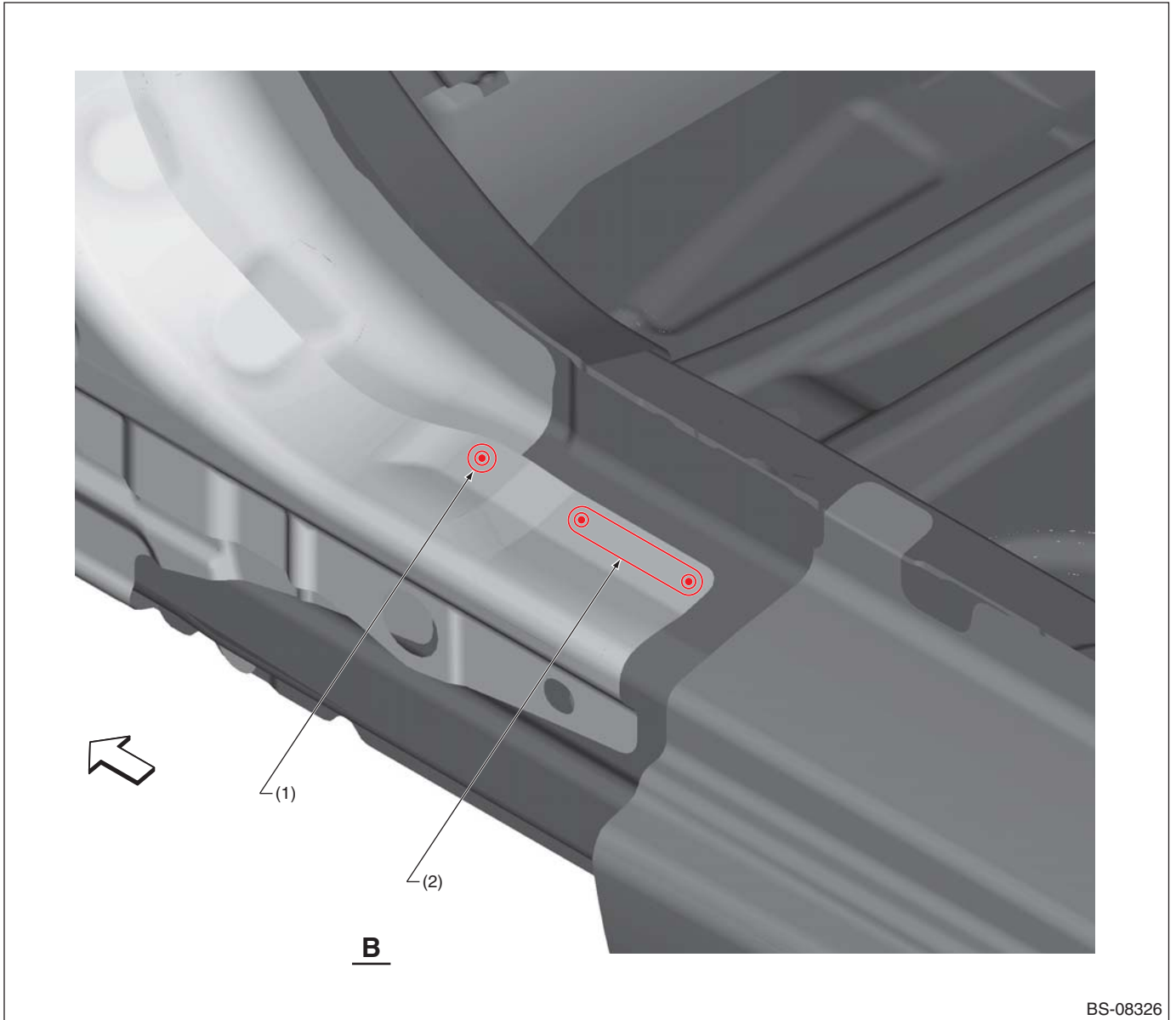
BS-08997

(1) 1 point (outside · 1)

(2) 5 points (top · 1)

Panel Replacement

• View B

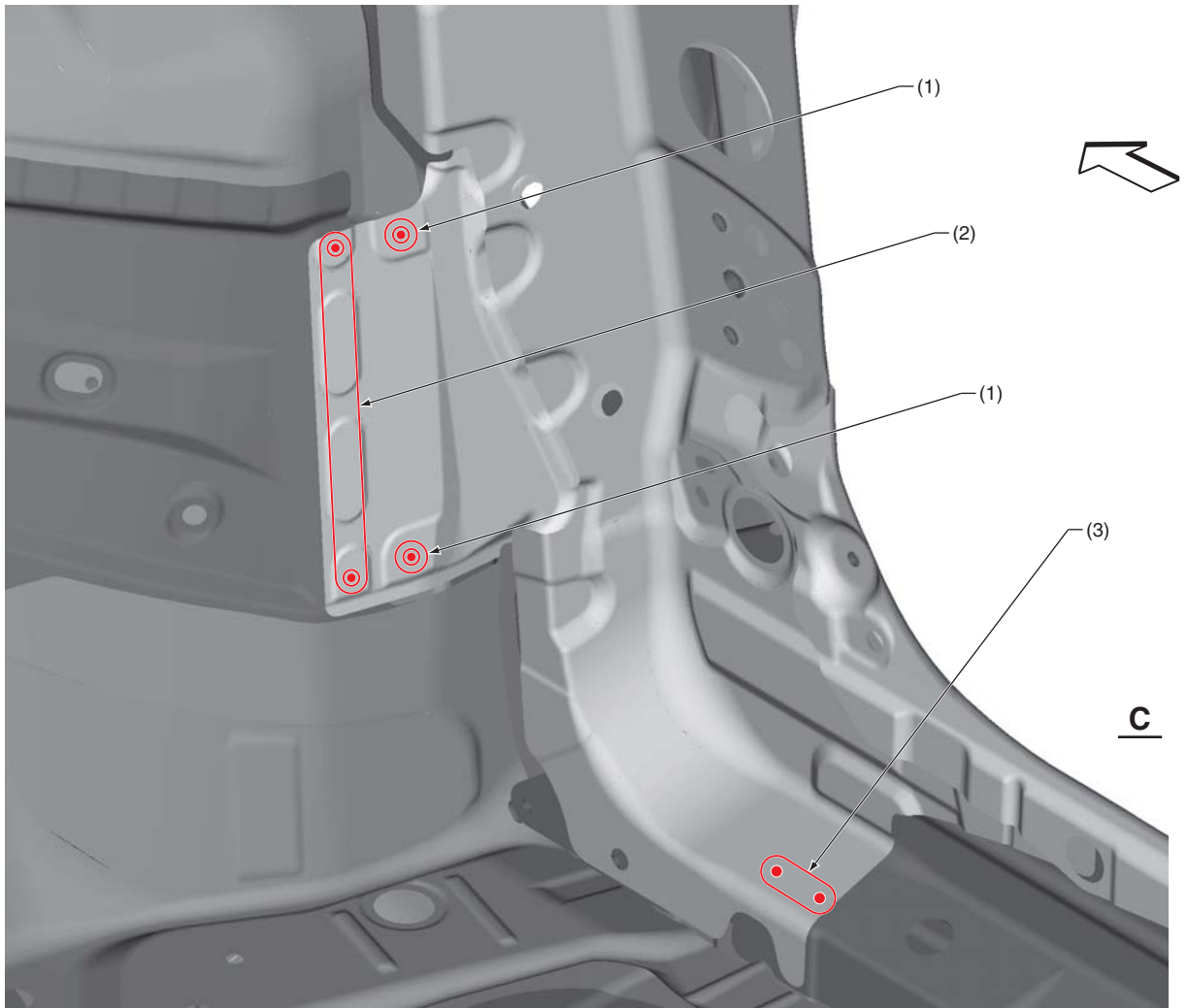


(1) 1 point (top · 2)

(2) 2 points (top · 1)

Panel Replacement

• View C



BS-08327

(1) 1 point (outside · 1)

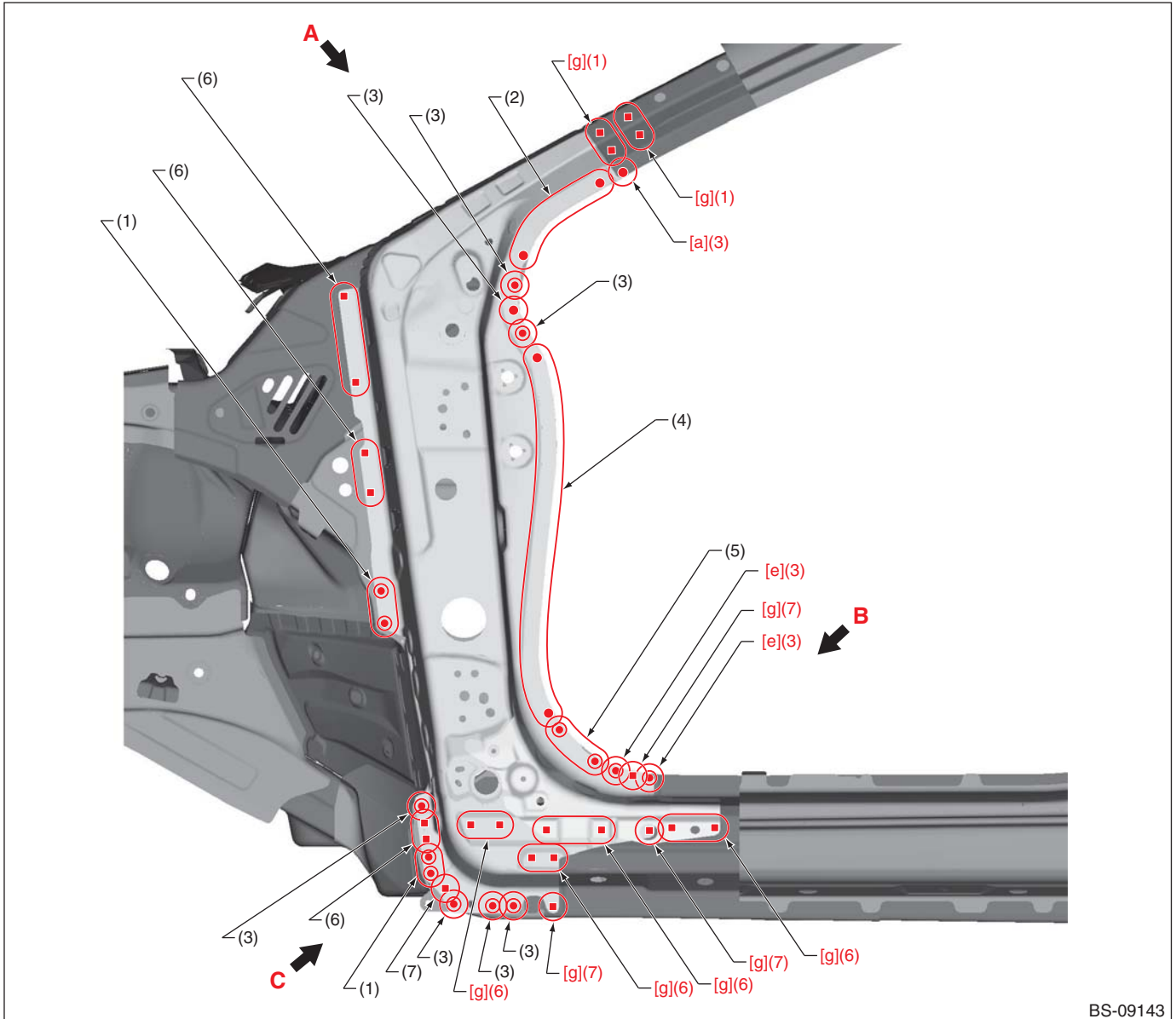
(2) 6 points (outside · 1)

(3) 2 points (bottom · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BS-09143

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

- (4) 15 points
- (5) 3 points
- (6) 2 points (service)

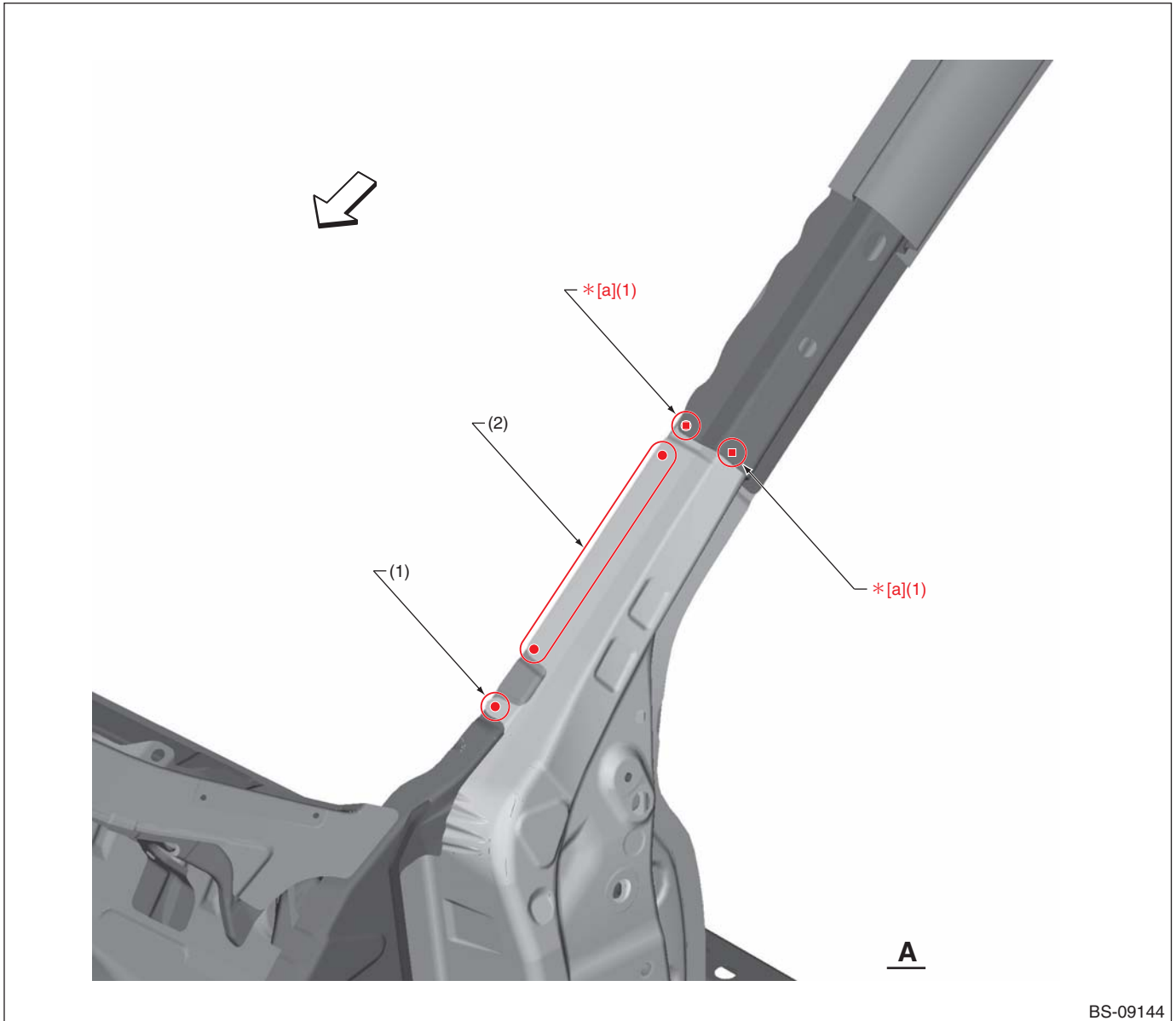
- (7) 1 point (service)

* : LH only has welding condition.

[a] Spot welding	Compression: 3.5 kN, Current: 7.0 kA, Welding time: 25 cyc
[e] Spot welding	Compression: 4.4 kN, Current: 8.0 kA, Welding time: 20 cyc
[g] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2 B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

• View A



(1) 1 point

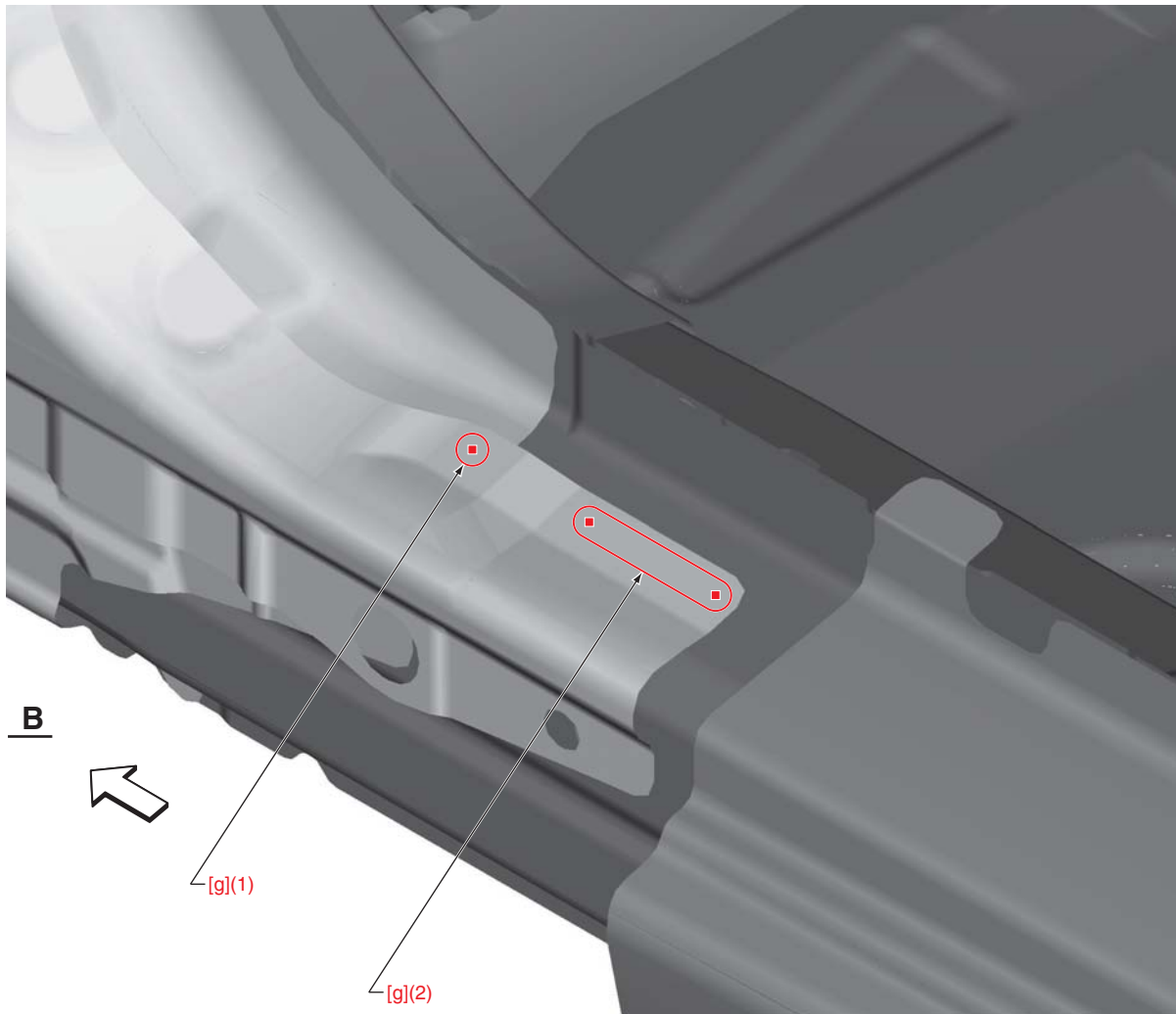
(2) 5 points

* : LH only has welding condition.

[a] Spot welding	Compression: 3.5 kN, Current: 7.0 kA, Welding time: 25 cyc
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Panel Replacement

• View B



BS-08735

(1) 1 point (service)

(2) 2 points (service)

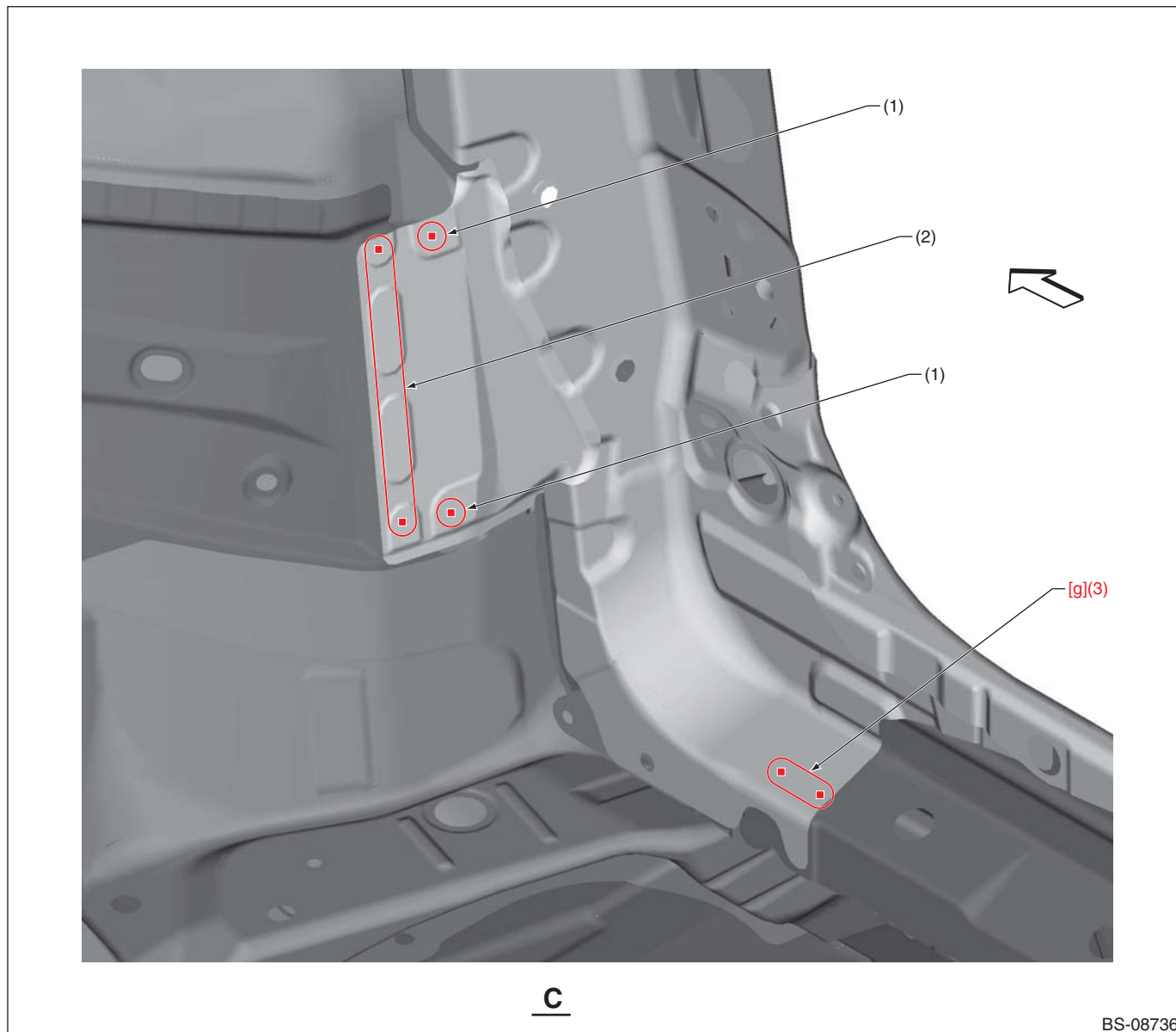
[g] Plug welding

A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2

B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

• View C



(1) 1 point (service)

(2) 6 points (service)

(3) 2 points (service)

[g] Plug welding

A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2

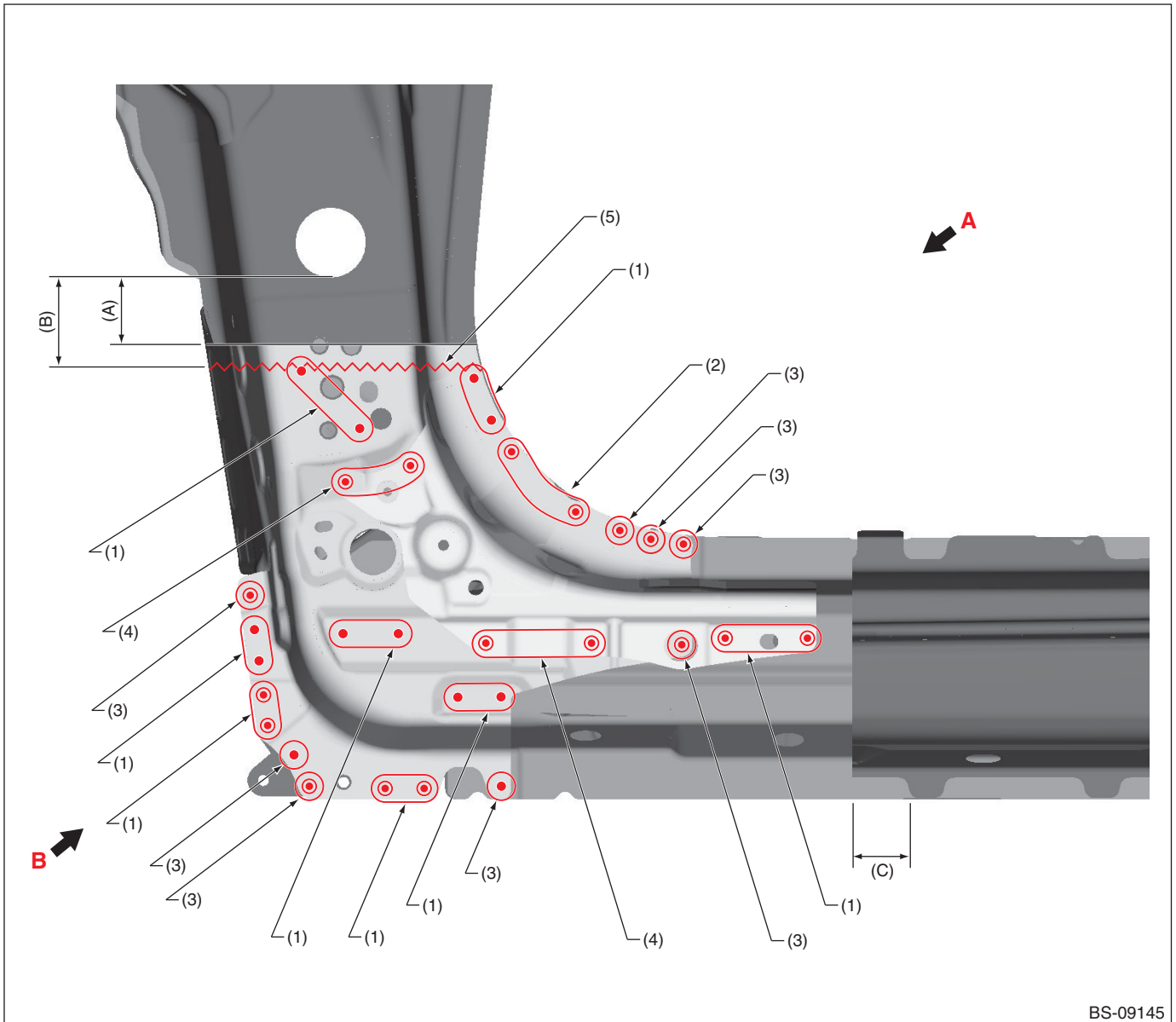
B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

8-14. Front Pillar Reinforcement (Partial replacement)

A: REMOVAL

• Overall view



(A) 40 mm [1.57 in]

(B) 60 mm [2.36 in]

(C) 35 mm [1.38 in]

(1) 2 points (outside · 1)

(3) 1 point (outside · 1)

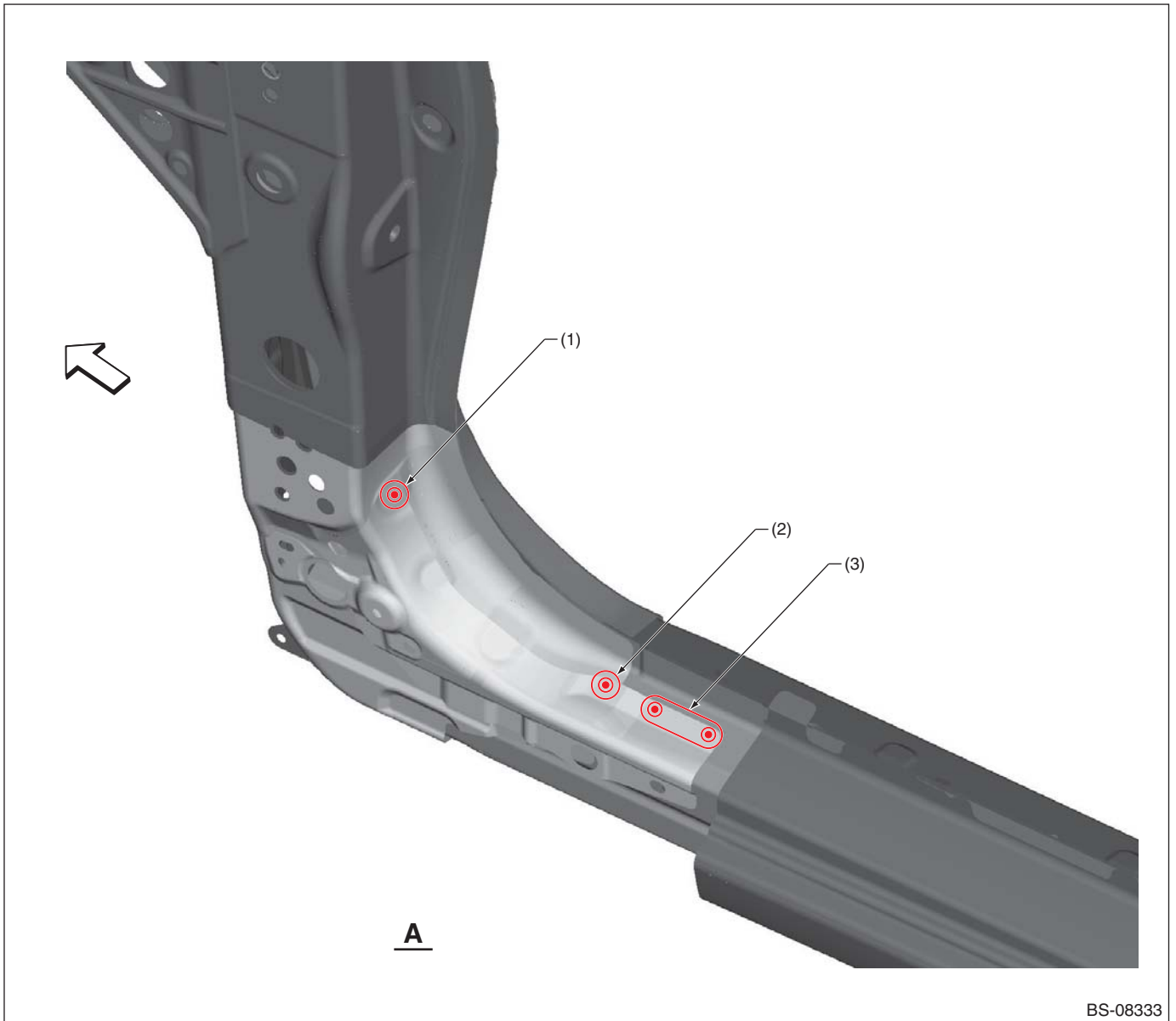
(5) Cut position

(2) 3 points (outside · 1)

(4) 2 points (outside · 2)

Panel Replacement

• View A



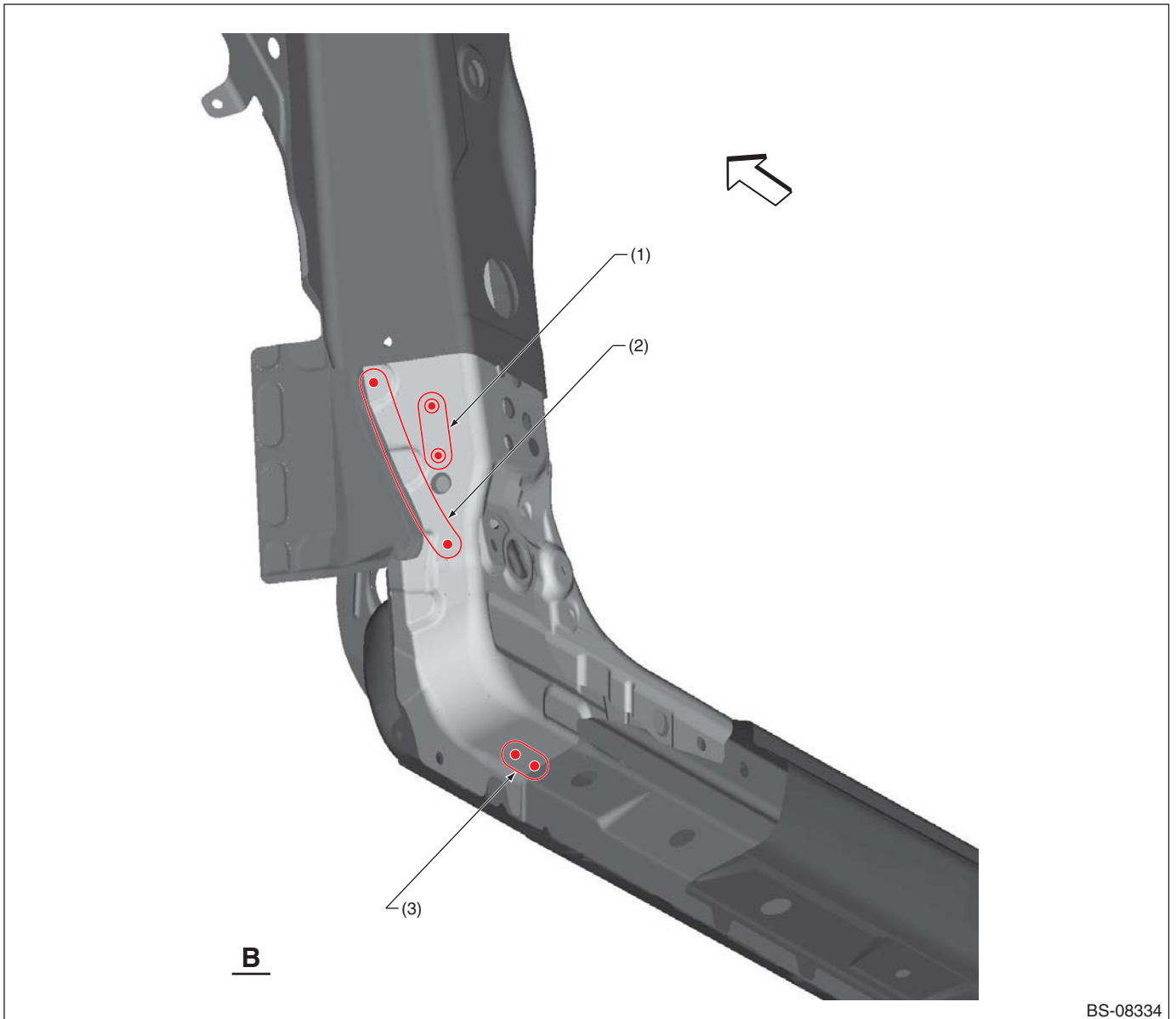
(1) 1 point (outside · 2)

(2) 1 point (top · 2)

(3) 2 points (top · 1)

Panel Replacement

• View B



(1) 2 points (outside · 1)

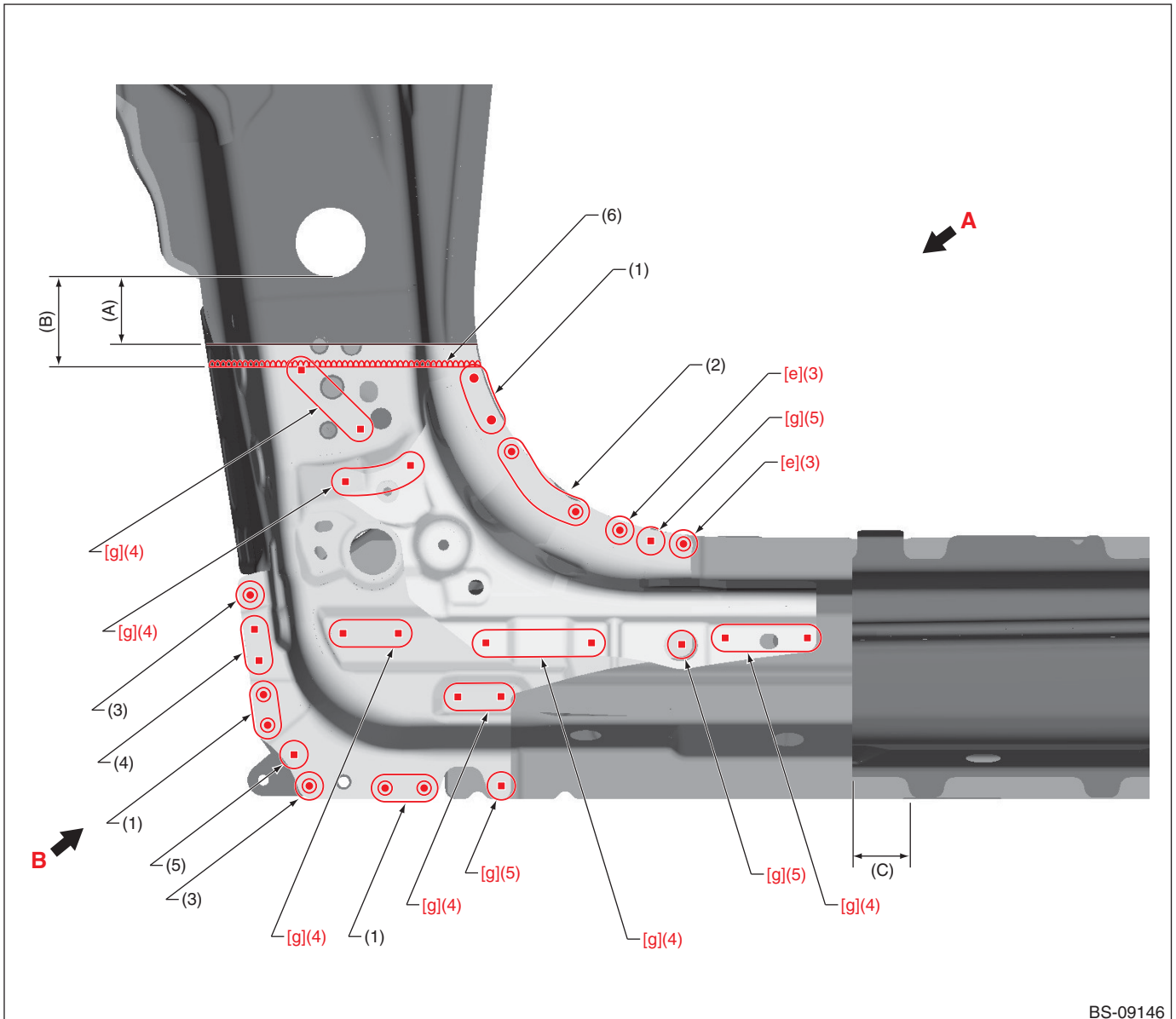
(2) 3 points (outside · 1)

(3) 2 points (bottom · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BS-09146

(A) 40 mm [1.57 in]

(B) 60 mm [2.36 in]

(C) 35 mm [1.38 in]

(1) 2 points

(3) 1 point

(5) 1 point (service)

(2) 3 points

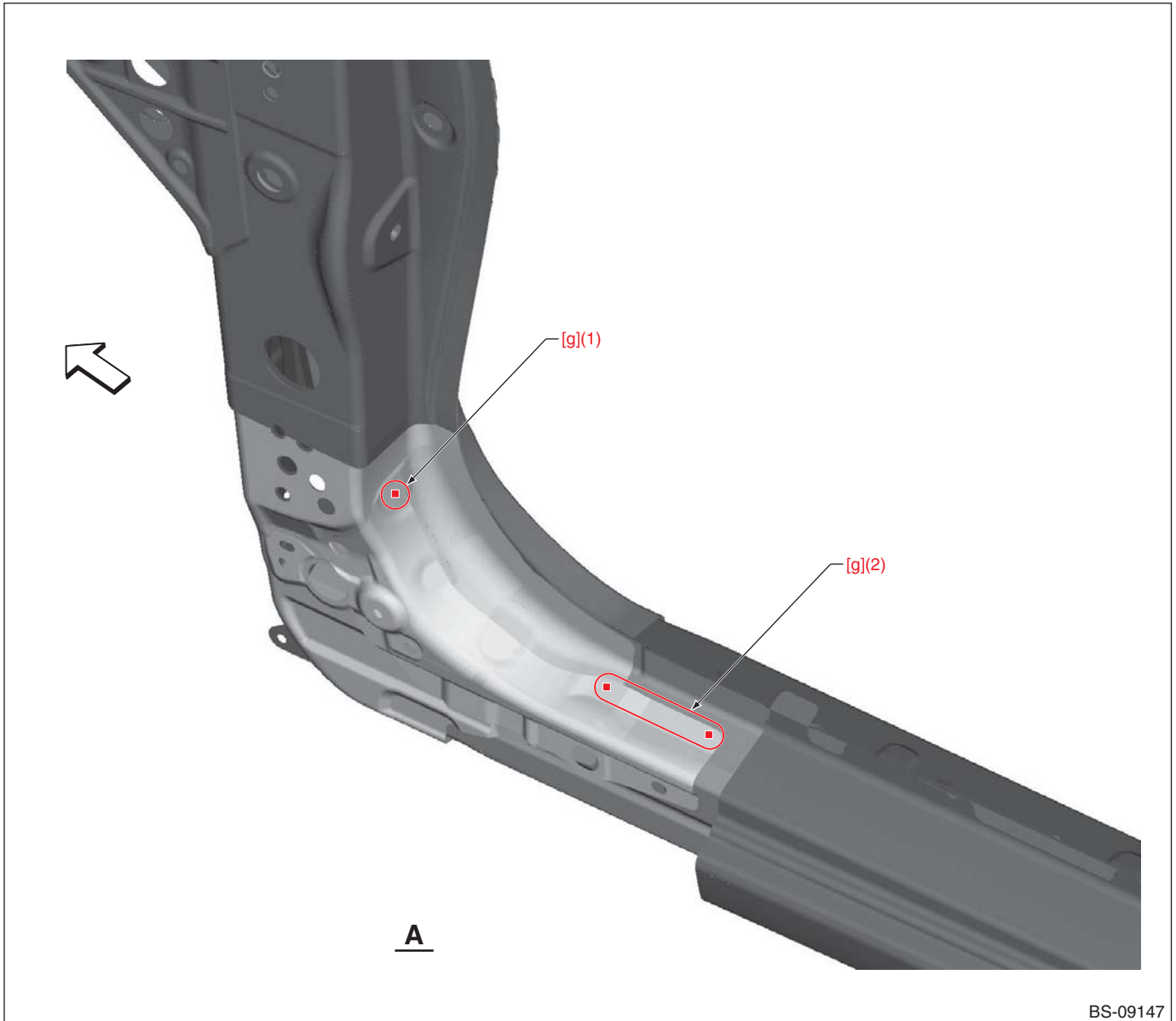
(4) 2 points (service)

(6) 1 point (Continuous welding)

[e] Spot welding	Compression: 4.4 kN, Current: 8.0 kA, Welding time: 20 cyc
[g] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2 B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

• View A



(1) 1 point (service)

(2) 3 points (service)

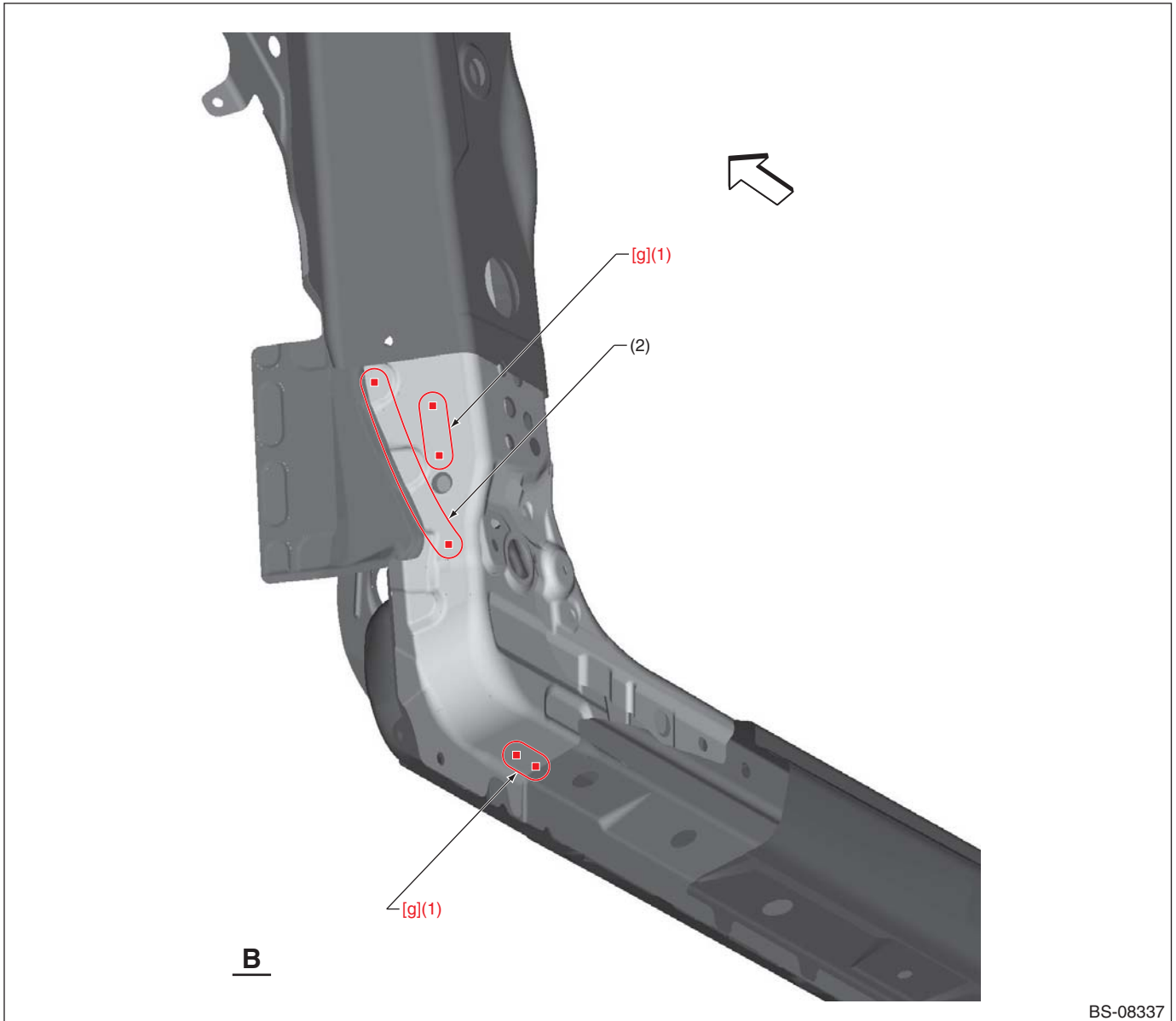
[g] Plug welding

A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2

B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

• View B



BS-08337

(1) 2 points (service)

(2) 3 points (service)

[g] Plug welding

A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2

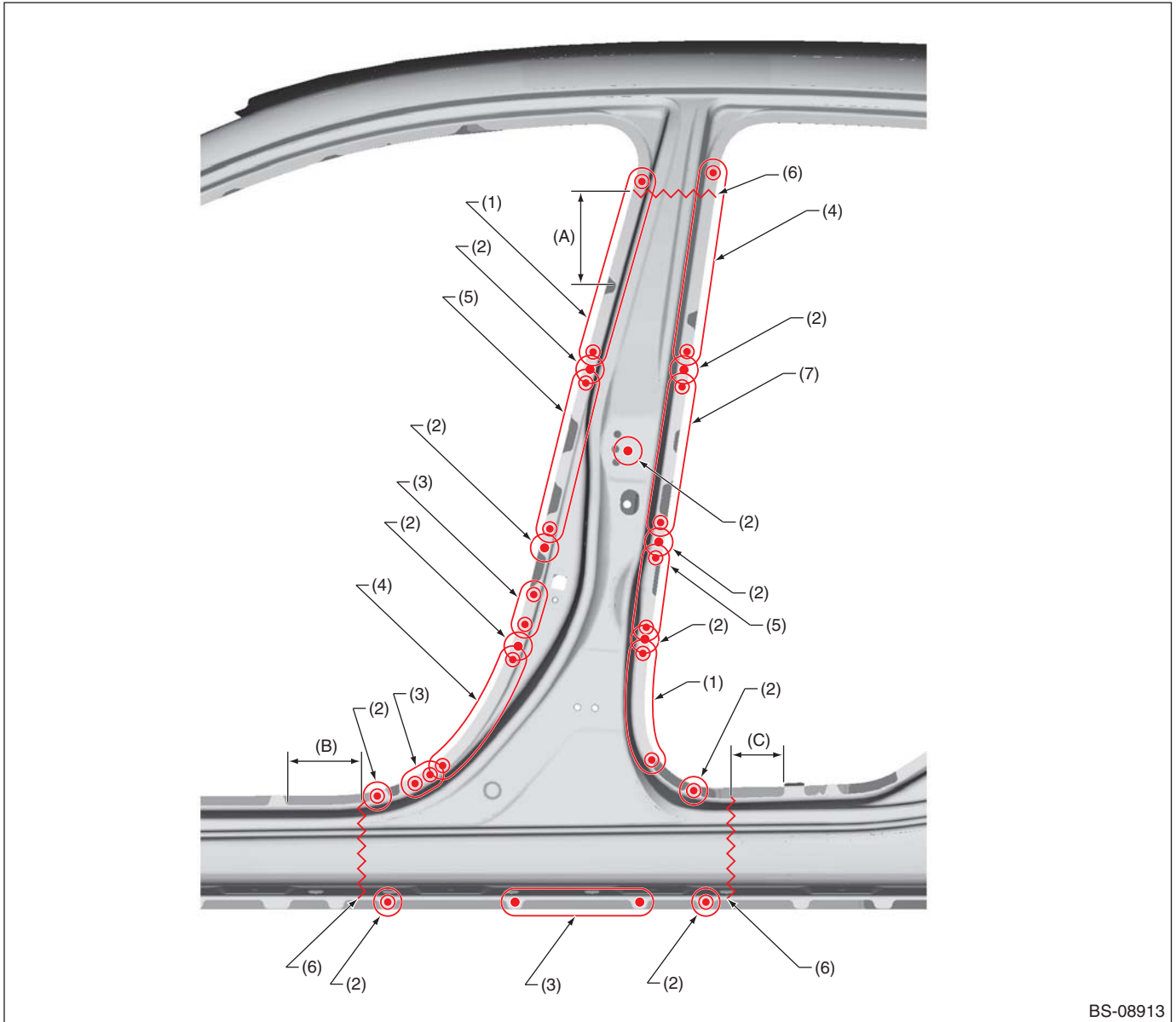
B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

8-15. Center Pillar Outer Panel (Partial replacement)

A: REMOVAL

• Overall view



BS-08913

(A) 170 mm [6.69 in]

(B) 120 mm [4.72 in]

(C) 80 mm [3.15 in]

(1) 8 points (outside · 1)

(4) 7 points (outside · 1)

(7) 4 points (outside · 1)

(2) 1 point (outside · 1)

(5) 3 points (outside · 1)

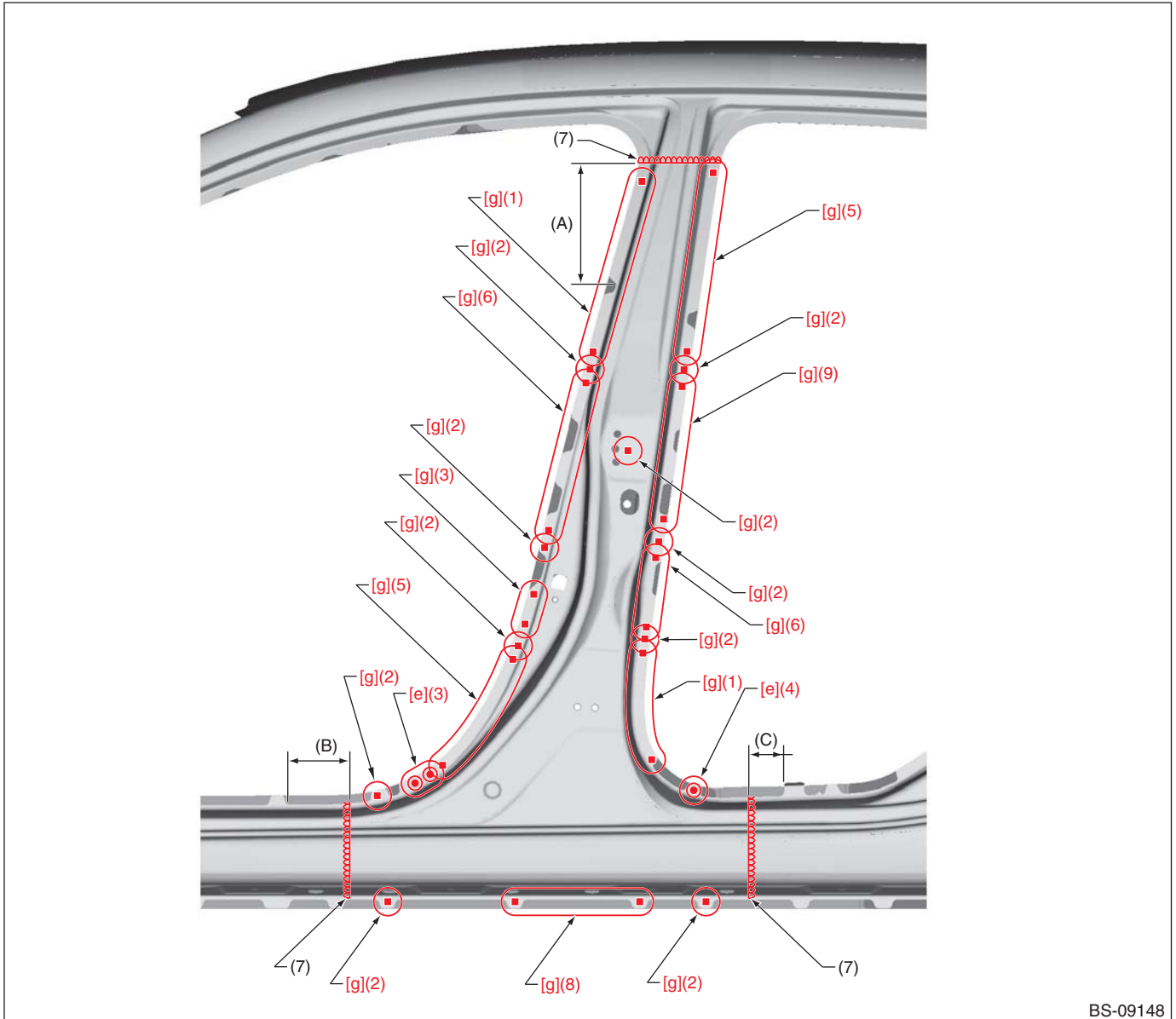
(3) 2 points (outside · 1)

(6) Cut position

Panel Replacement

B: INSTALLATION

• Overall view



BS-09148

(A) 200 mm [7.87 in]

(B) 90 mm [3.54 in]

(C) 50 mm [1.97 in]

(1) 8 points

(2) 1 point (service)

(3) 2 points

(4) 1 point

(5) 7 points

(6) 3 points

(7) 1 point (Continuous welding)

(8) 2 points (service)

(9) 4 points

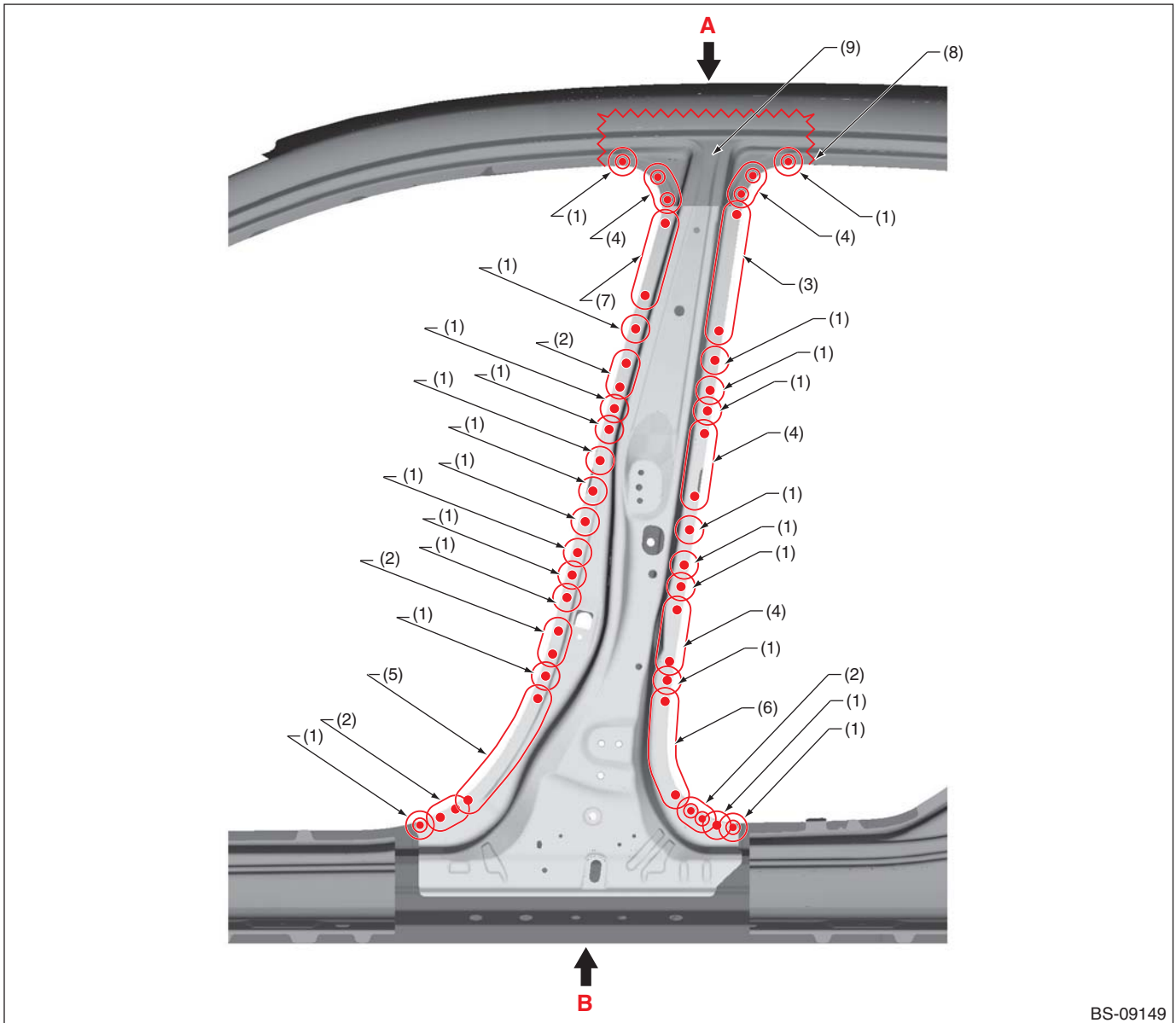
[e] Spot welding	Compression: 4.4 kN, Current: 8.0 kA, Welding time: 20 cyc
[g] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2 B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

8-16. Center Pillar Reinforcement Outer (Total replacement)

A: REMOVAL

• Overall view

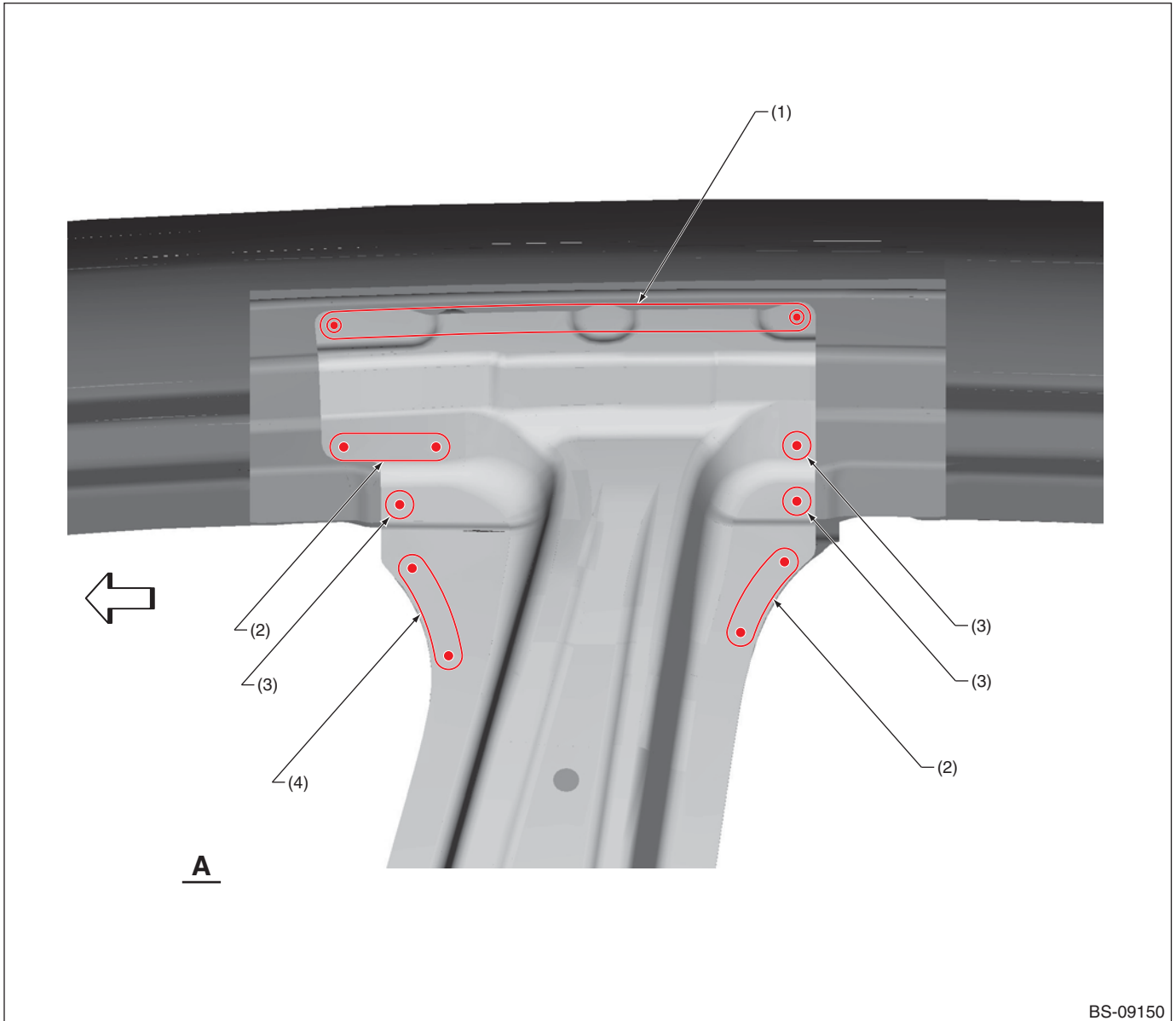


- | | | |
|----------------------------|----------------------------|----------------------------------|
| (1) 1 point (outside · 1) | (4) 3 points (outside · 1) | (7) 6 points (outside · 1) |
| (2) 2 points (outside · 1) | (5) 7 points (outside · 1) | (8) Rough cutting |
| (3) 5 points (outside · 1) | (6) 8 points (outside · 1) | (9) The part that can be reused. |

Note: The cut part can be reused depending on level of damage.

Panel Replacement

• View A



BS-09150

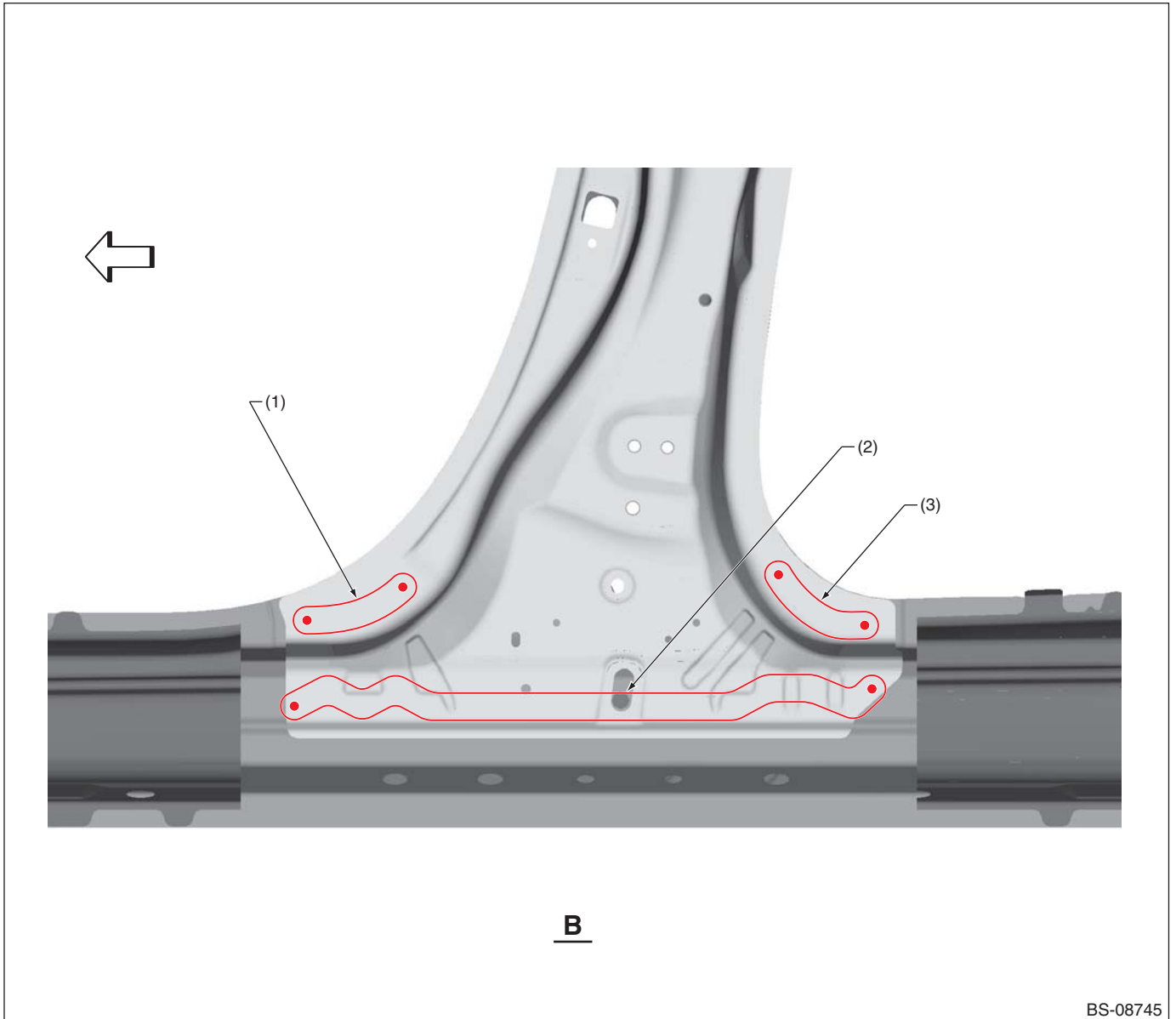
(1) 4 points (outside · 1)
(2) 2 points (outside · 1)

(3) 1 point (outside · 1)

(4) 3 points (outside · 1)

Panel Replacement

• View B



(1) 5 points (outside · 1)

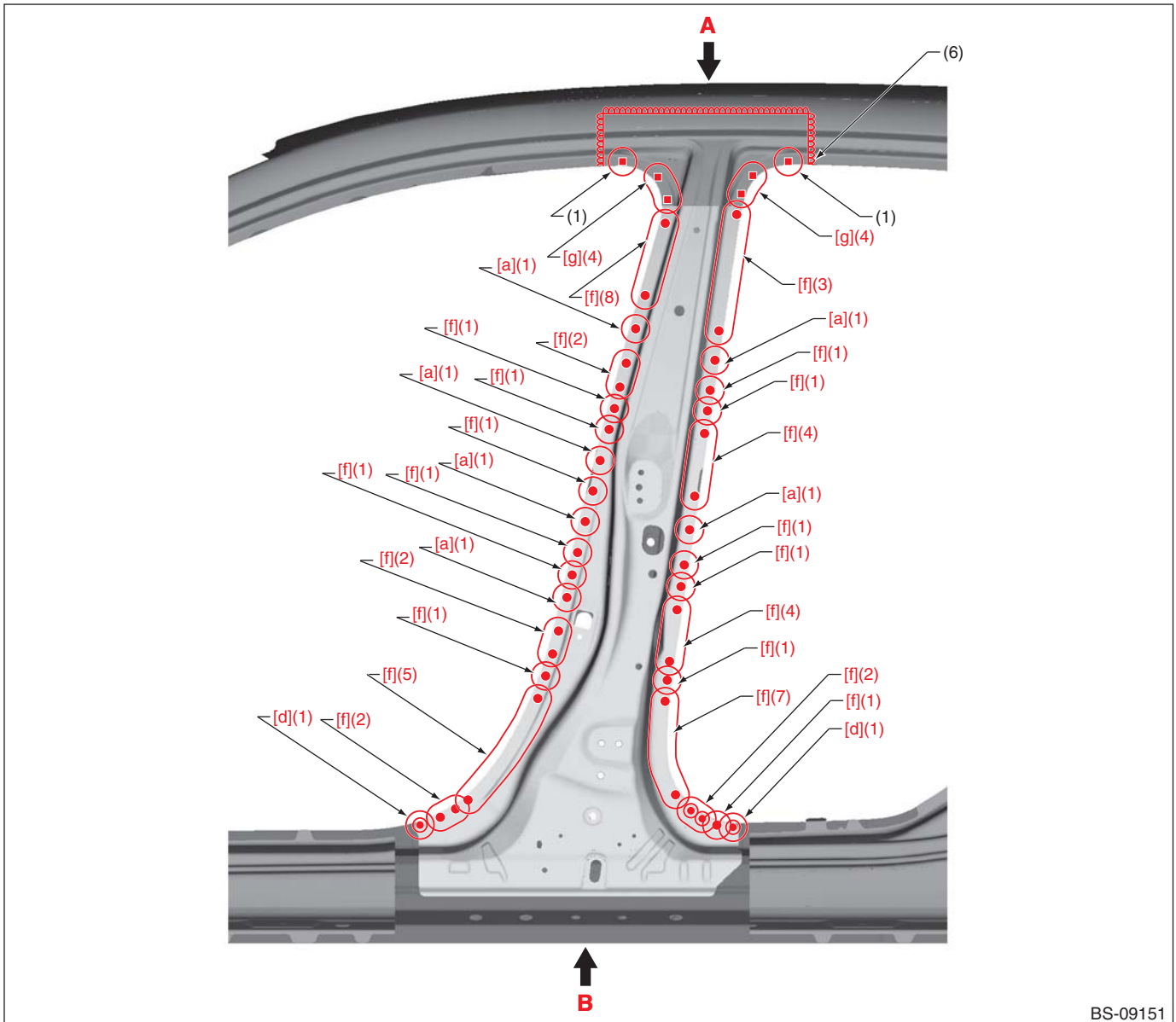
(2) 16 points (outside · 1)

(3) 4 points (outside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



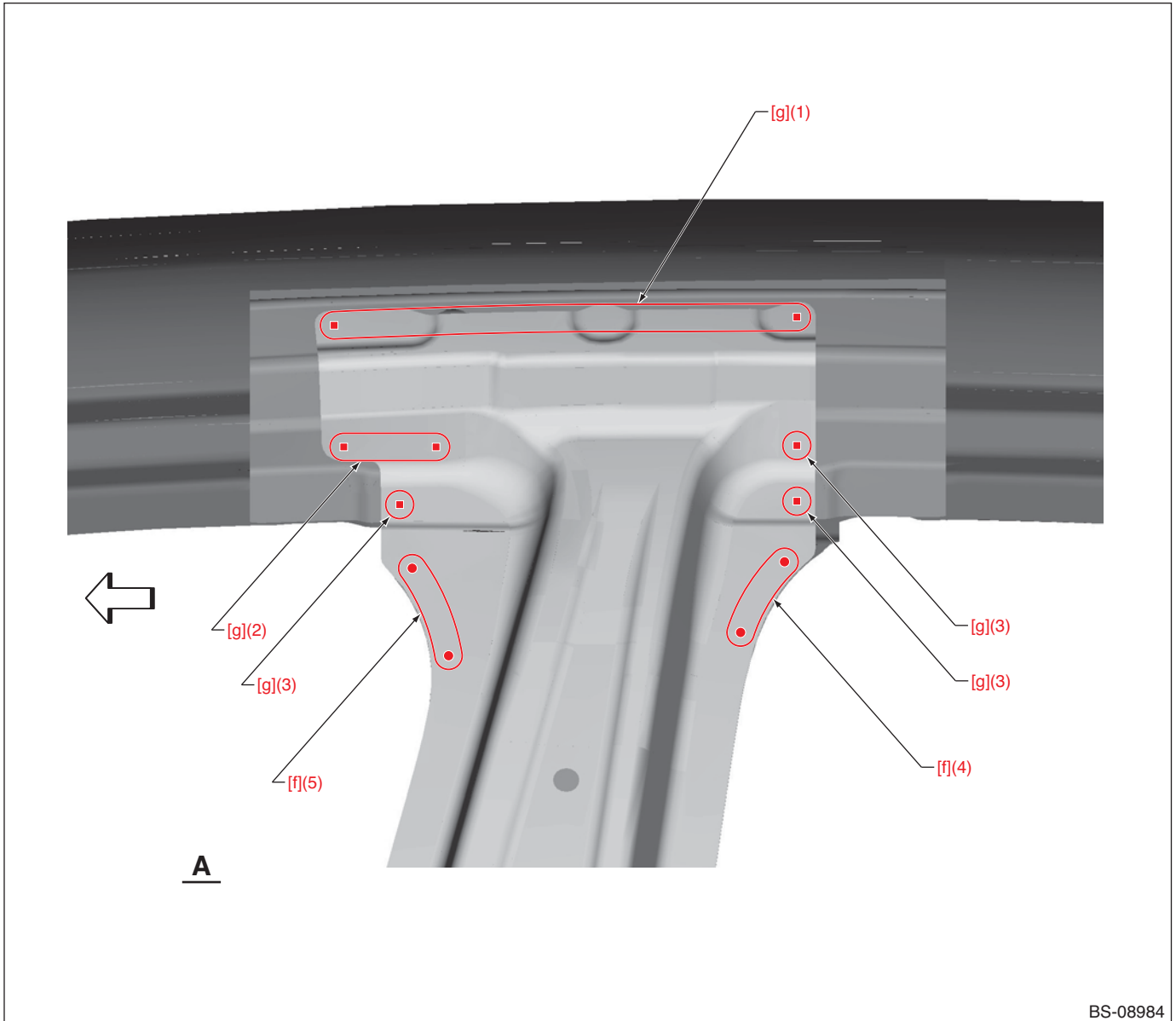
BS-09151

- | | | |
|--------------|----------------------------------|--------------|
| (1) 1 point | (4) 3 points | (7) 8 points |
| (2) 2 points | (5) 7 points | (8) 6 points |
| (3) 5 points | (6) 1 point (Continuous welding) | |

[a] Spot welding	Compression: 3.5 kN, Current: 7.0 kA, Welding time: 25 cyc
[d] Spot welding	Compression: 3.5 kN, Current: 7.5 kA, Welding time: 25 cyc
[f] Spot welding	Compression: 4.4 kN, Current: 8.0 kA, Welding time: 25 cyc
[g] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2 B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

• View A



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

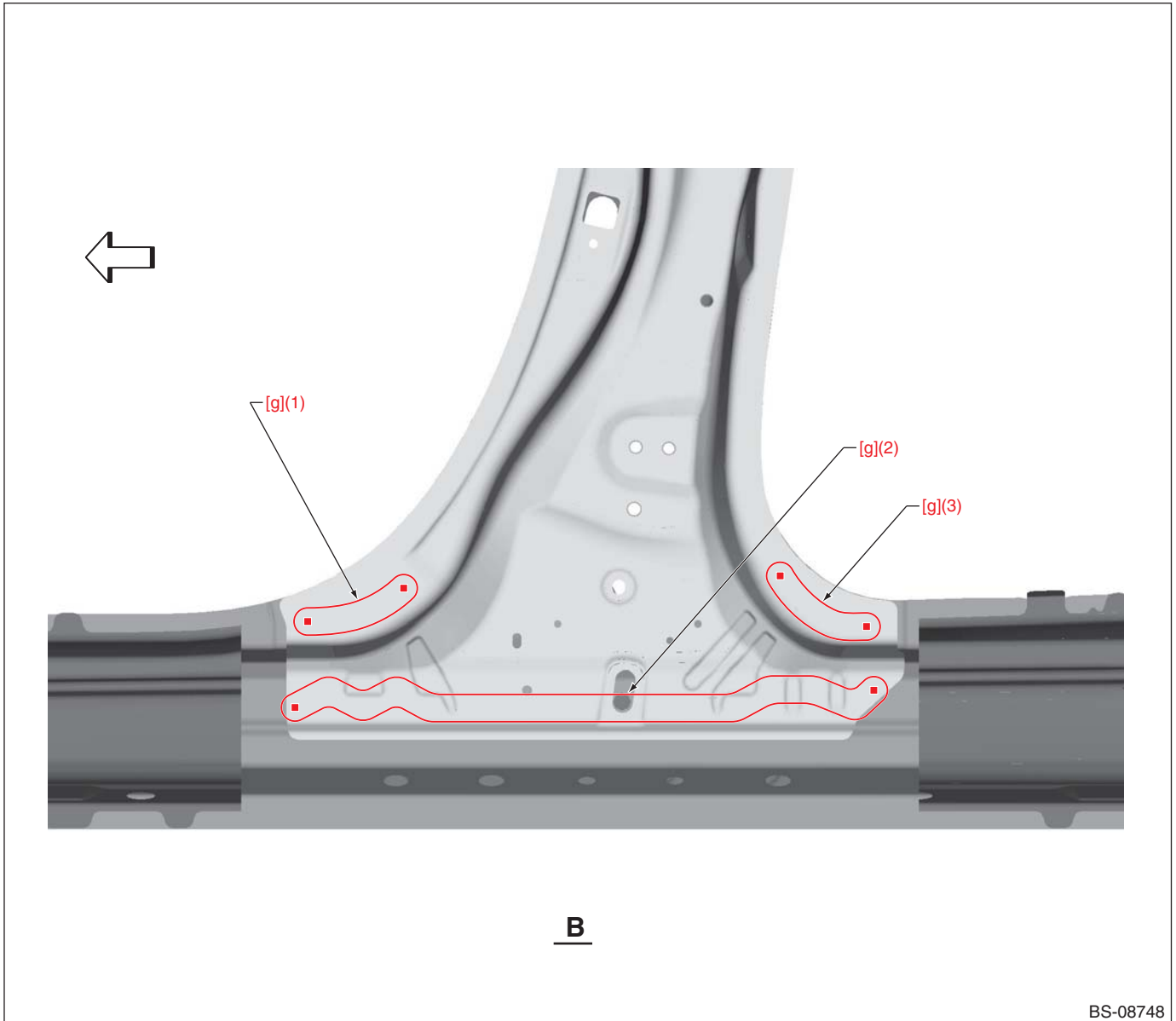
(3) 1 point (service)
(4) 2 points

(5) 3 points

[f] Spot welding	Compression: 4.4 kN, Current: 8.0 kA, Welding time: 25 cyc
[g] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2 B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

• View B



(1) 5 points (service)

(2) 16 points (service)

(3) 4 points (service)

[g] Plug welding

A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2

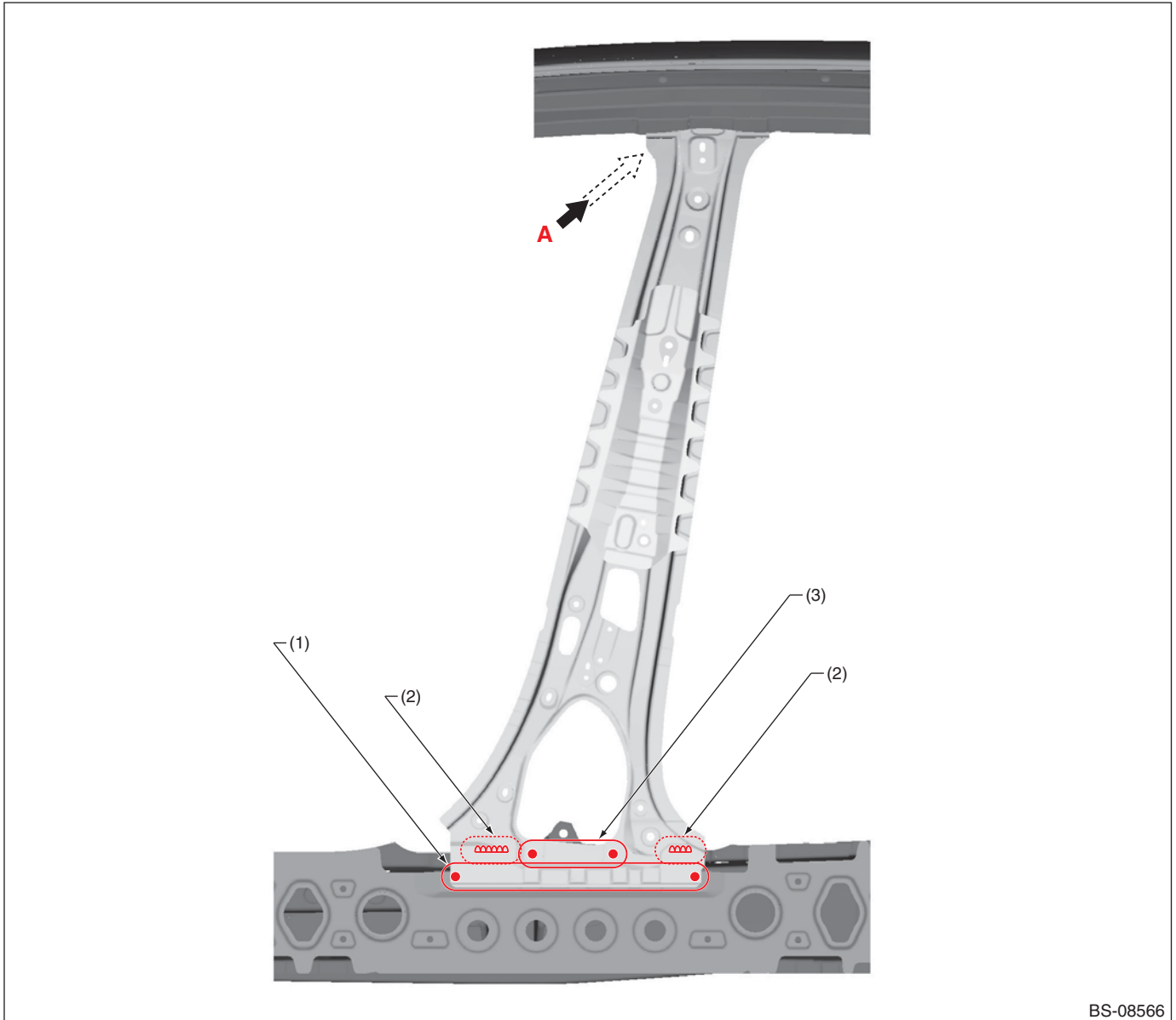
B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

8-17. Center Pillar Inner (Total replacement)

A: REMOVAL

• Overall view



BS-08566

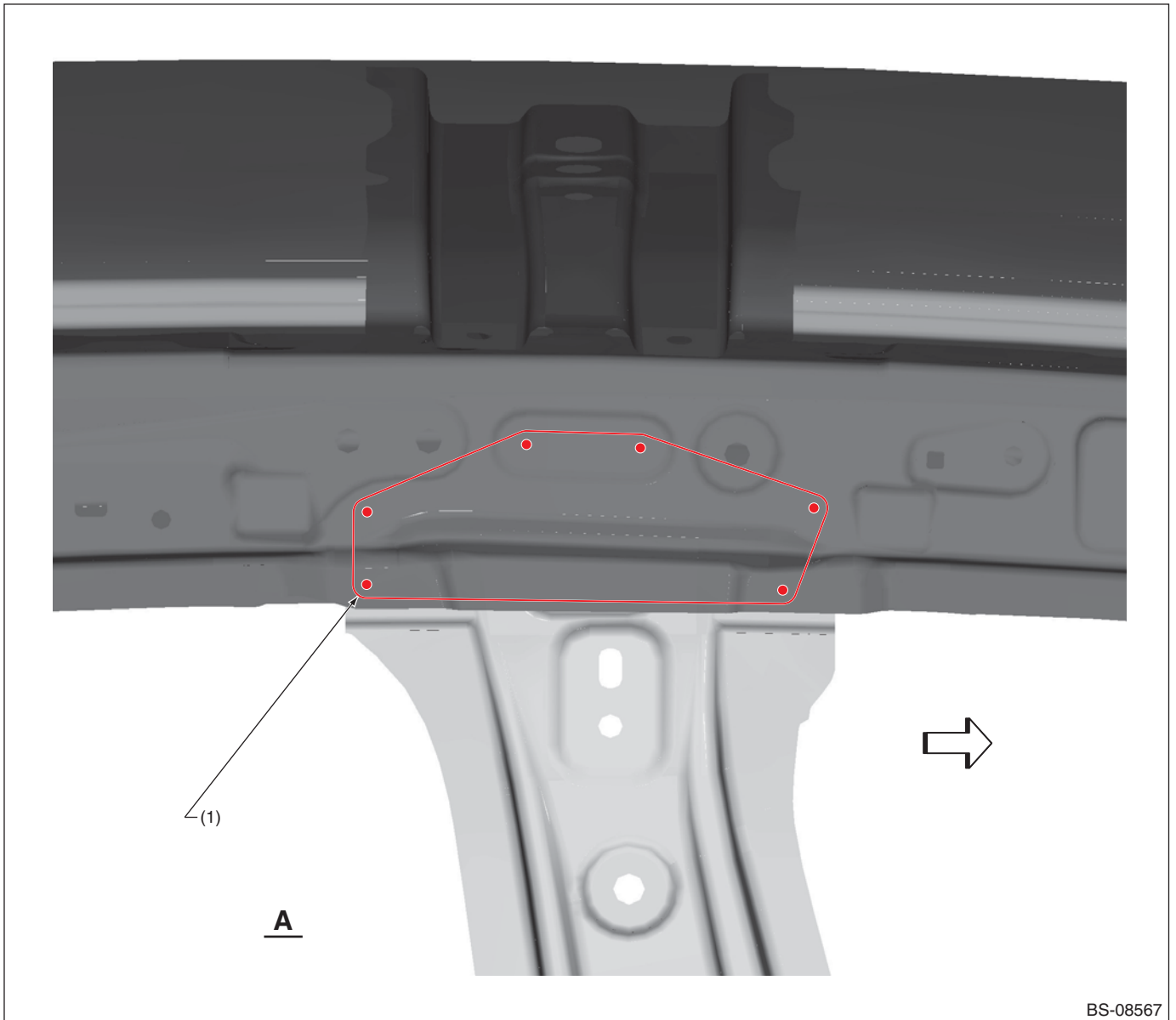
(1) 9 points (outside · 1)

(2) 1 point (inside · 1, belt sander)

(3) 2 points (outside · 1)

Panel Replacement

- View A

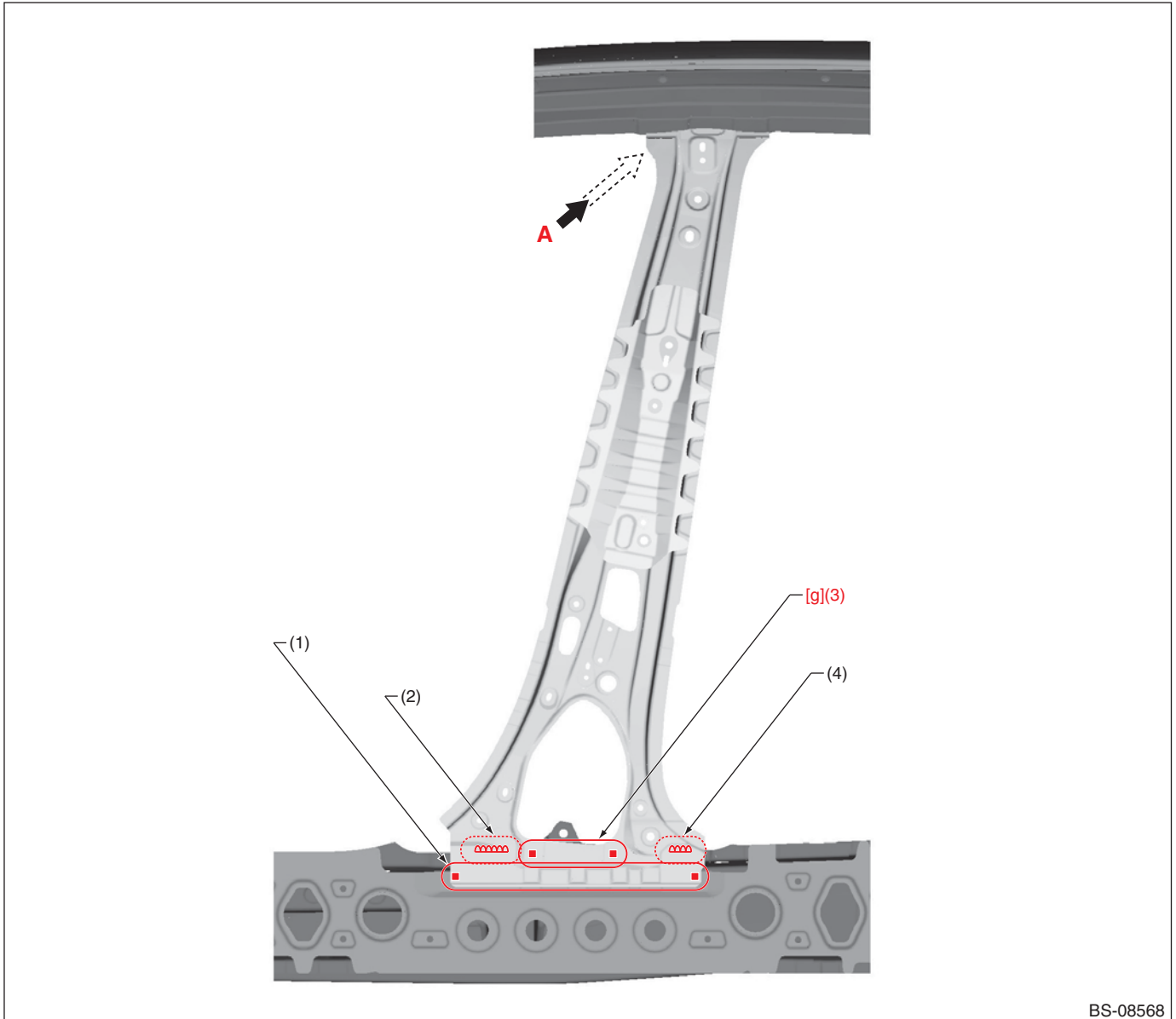


(1) 7 points (inside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



(1) 9 points (service)

(3) 2 points (service)

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

(2) 1 point (Continuous welding)
(55 mm [2.17 in])

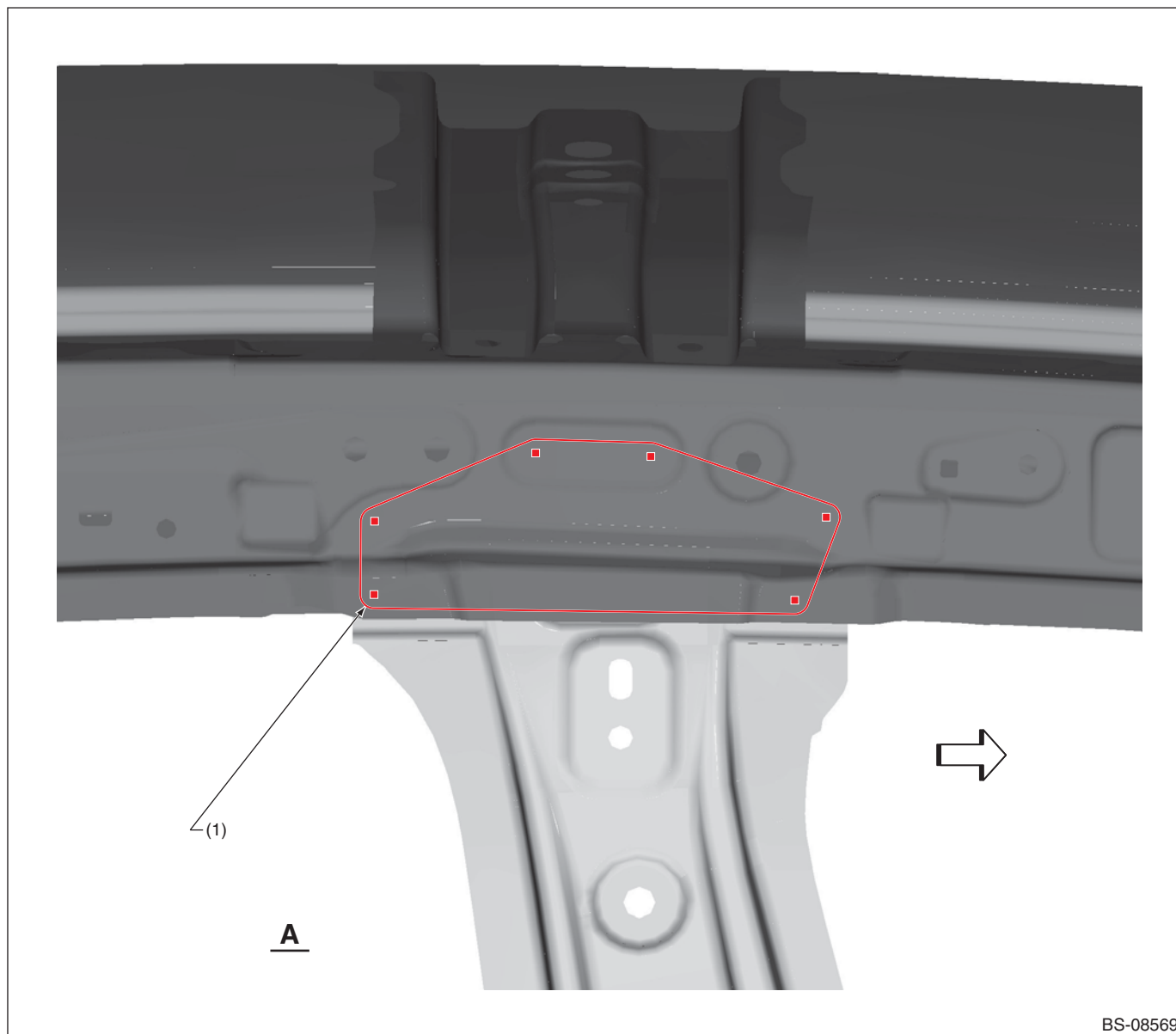
[g] Plug welding

A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2

B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

- View A

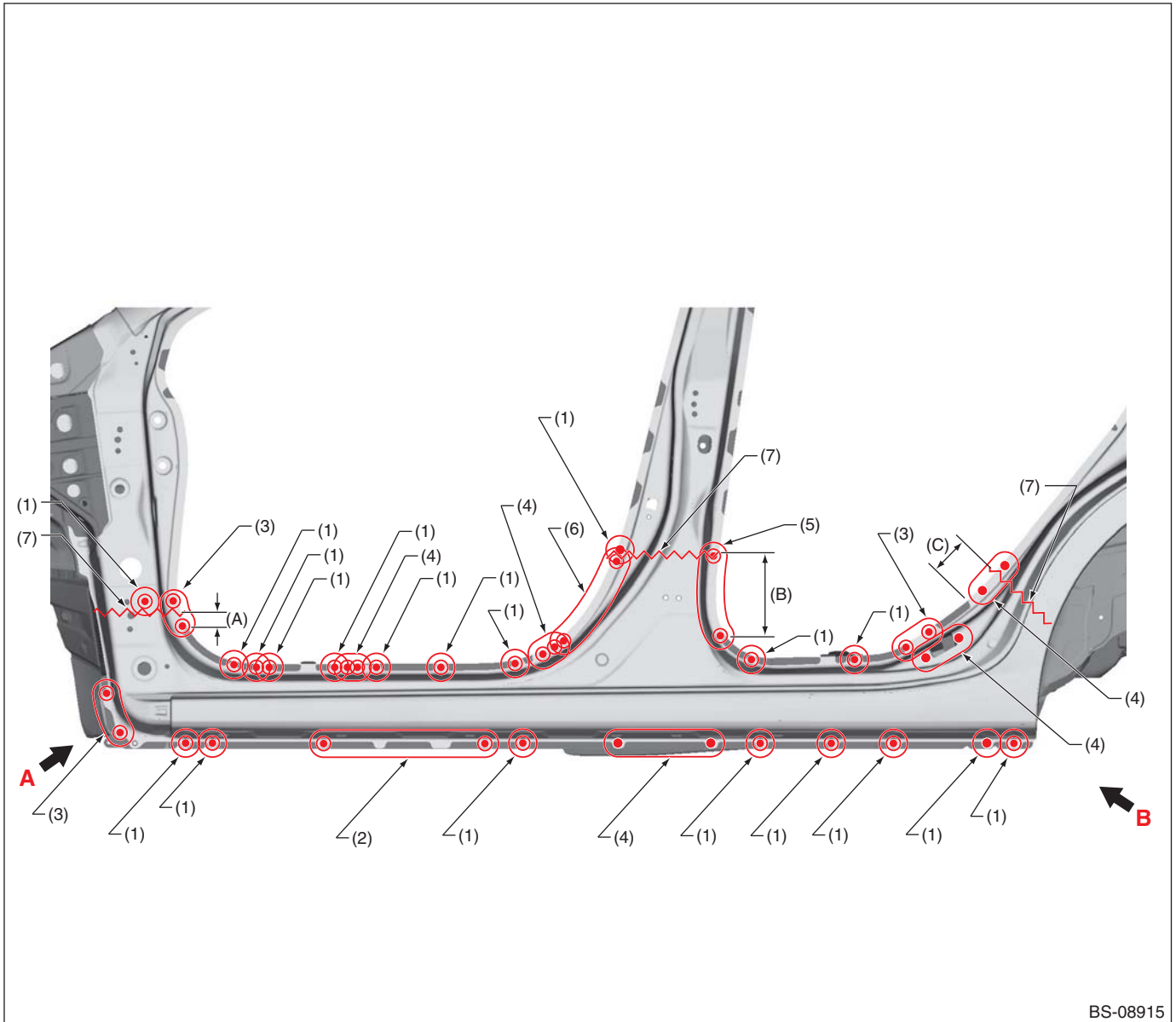


(1) 7 points

8-18. Side Sill Outer Panel (Partial replacement)

A: REMOVAL

• Overall view



BS-08915

(A) 50 mm [1.97 in]

(B) 150 mm [5.91 in]

(C) 90 mm [3.54 in]

(1) 1 point (outside · 1)

(4) 2 points (outside · 1)

(7) Cut position

(2) 4 points (outside · 1)

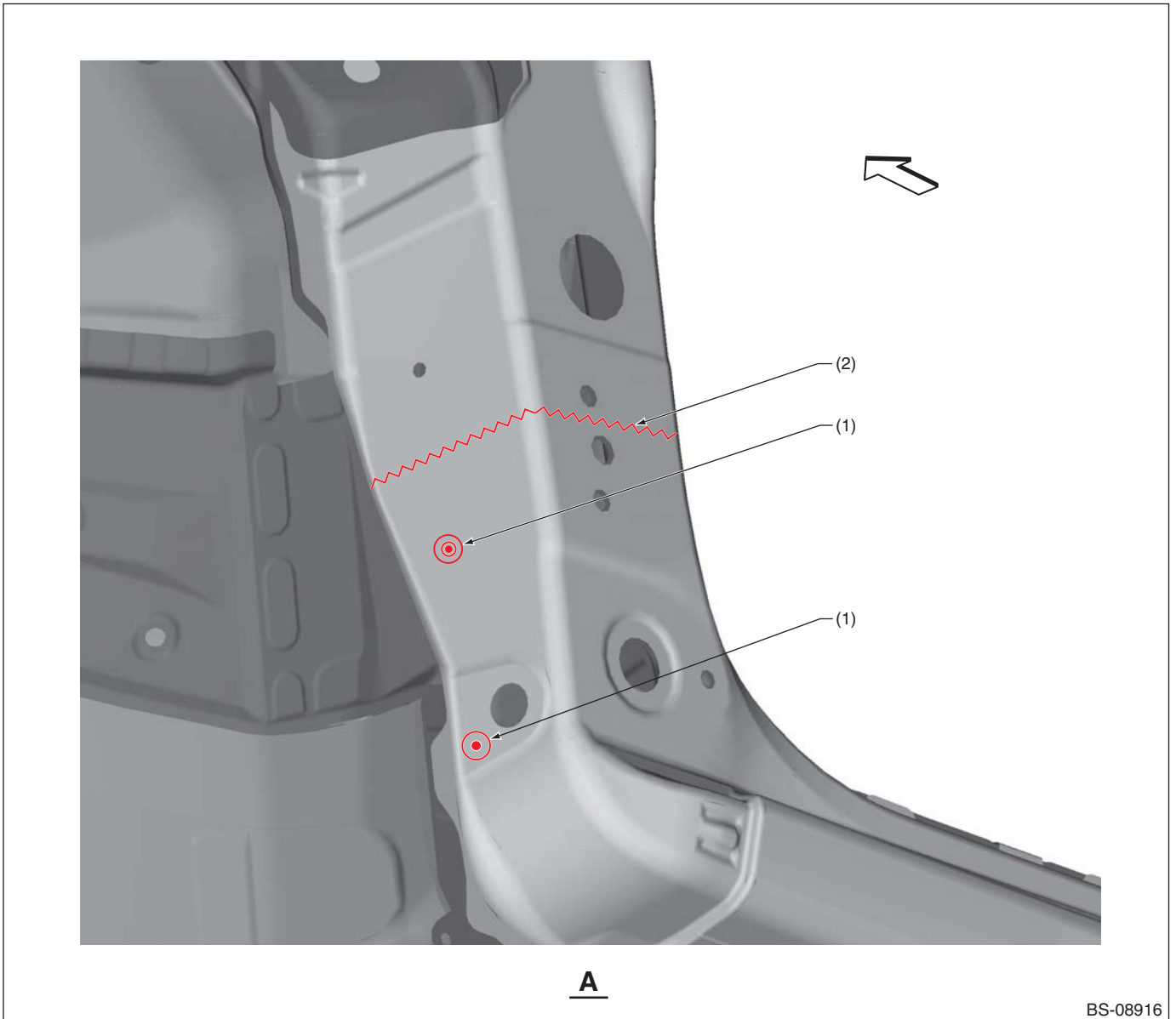
(5) 6 points (outside · 1)

(3) 3 points (outside · 1)

(6) 7 points (outside · 1)

Panel Replacement

• View A

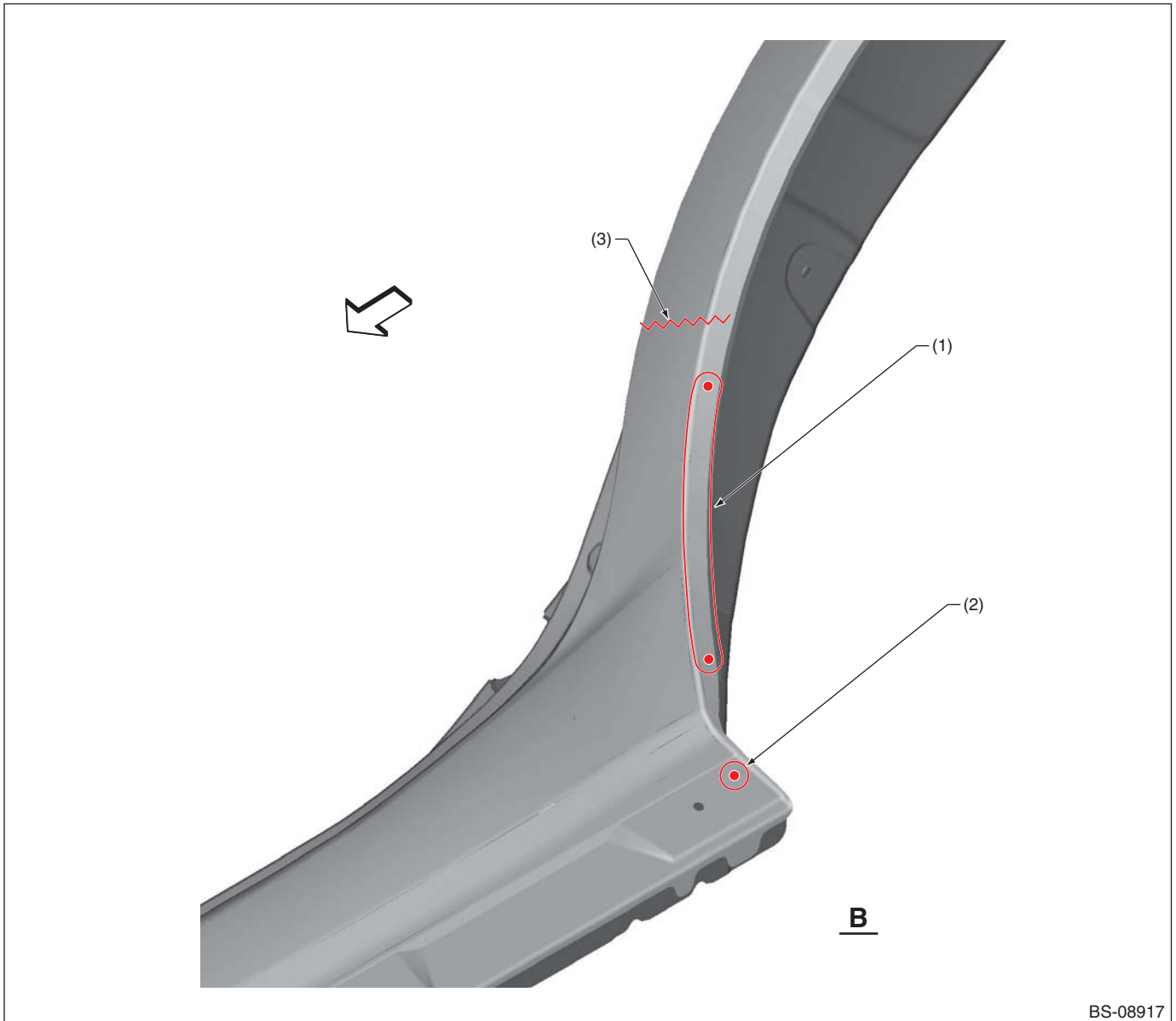


(1) 1 point (outside · 1)

(2) Cut position

Panel Replacement

• View B



BS-08917

(1) 3 points (outside · 1)

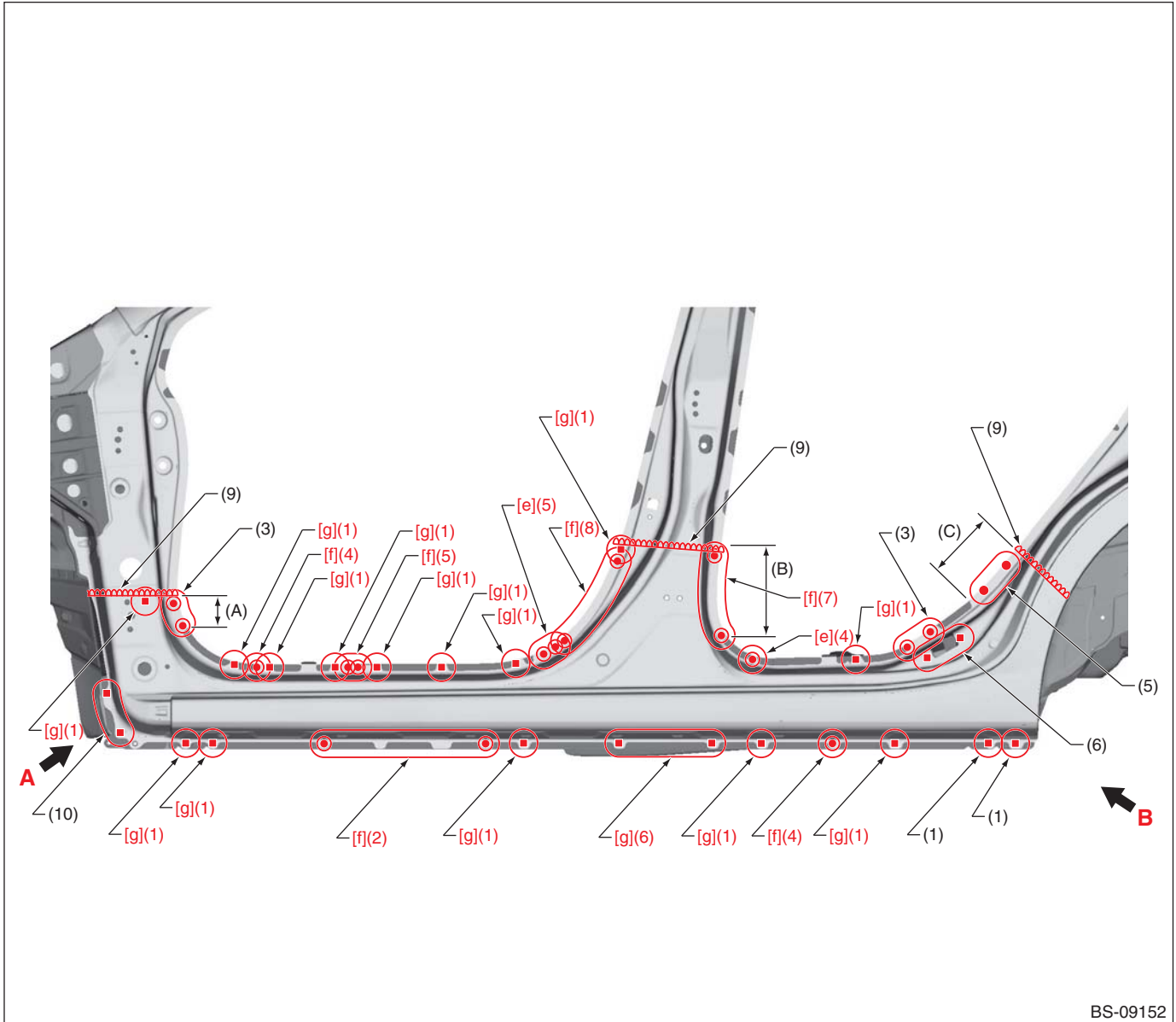
(2) 1 point (bottom · 1)

(3) Cut position

Panel Replacement

B: INSTALLATION

• Overall view



(A) 70 mm [2.76 in]

(B) 170 mm [6.69 in]

(C) 120 mm [4.72 in]

(1) 1 point (service)

(5) 2 points

(9) 1 point (Continuous welding)

(2) 4 points

(6) 2 points (service)

(10) 3 points (service)

(3) 3 points

(7) 6 points

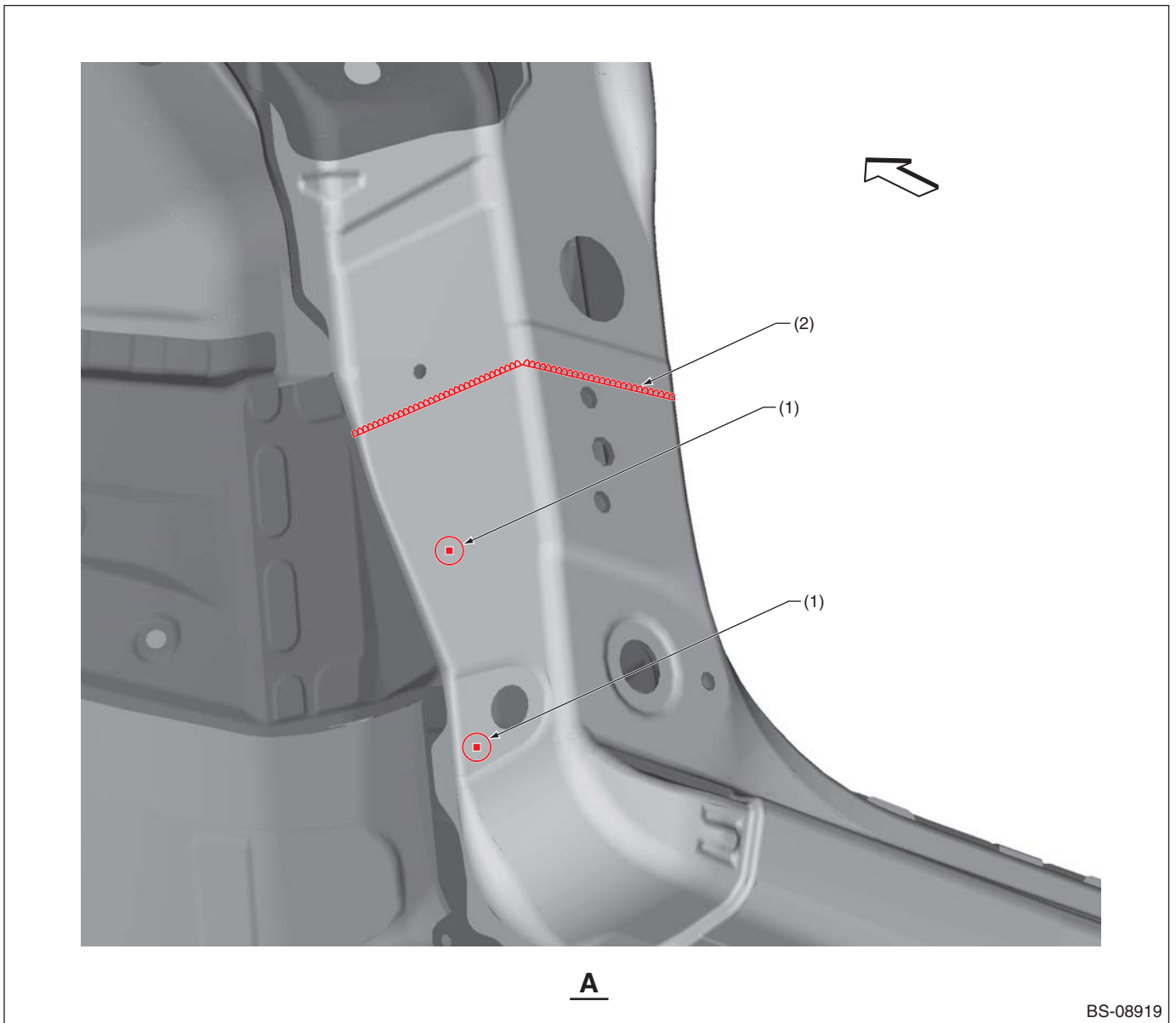
(4) 1 point

(8) 7 points

[e] Spot welding	Compression: 4.4 kN, Current: 8.0 kA, Welding time: 20 cyc
[f] Spot welding	Compression: 4.4 kN, Current: 8.0 kA, Welding time: 25 cyc
[g] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2 B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

• View A

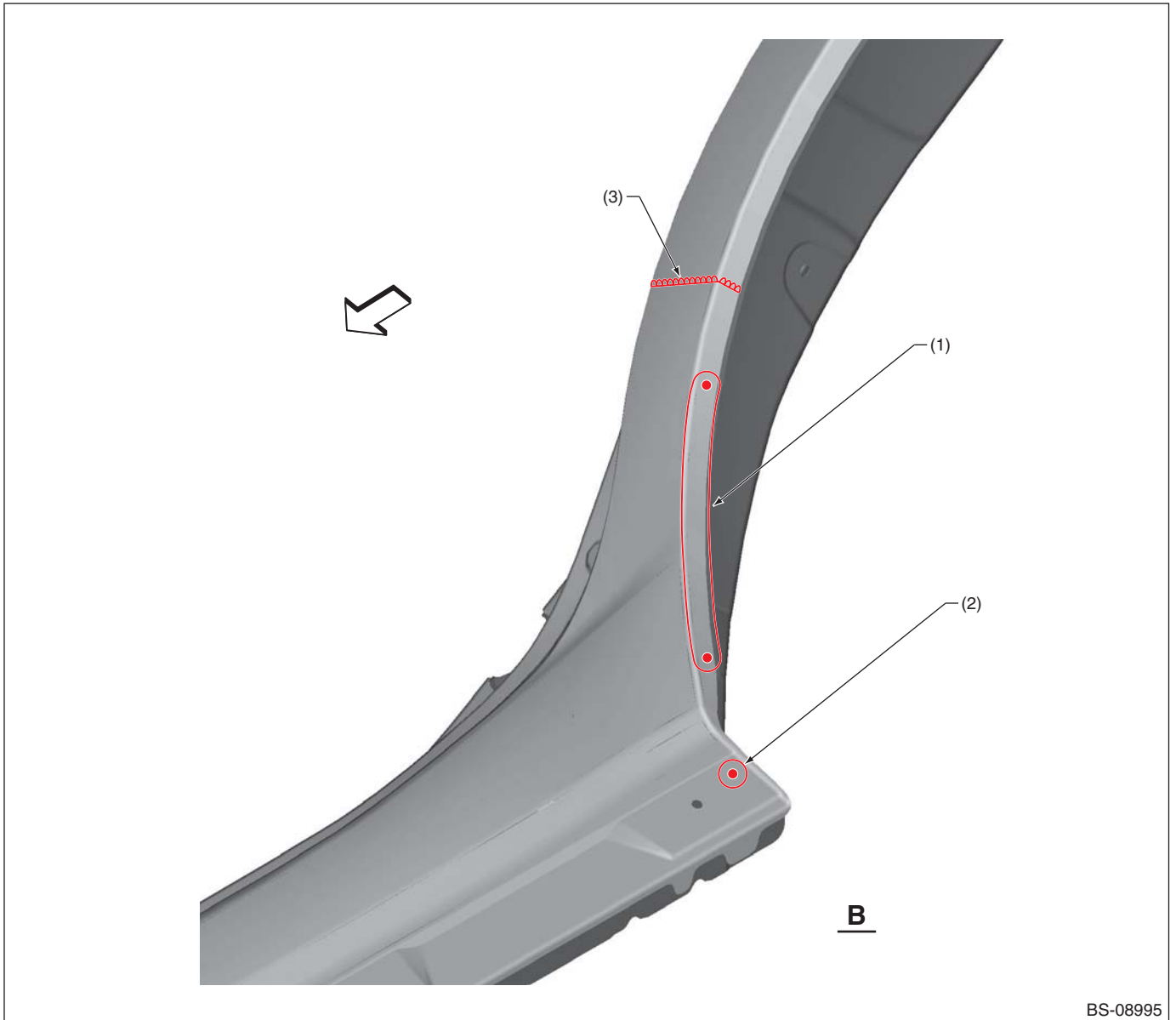


(1) 1 point (service)

(2) 1 point (Continuous welding)

Panel Replacement

• View B



(1) 3 points

(2) 1 point

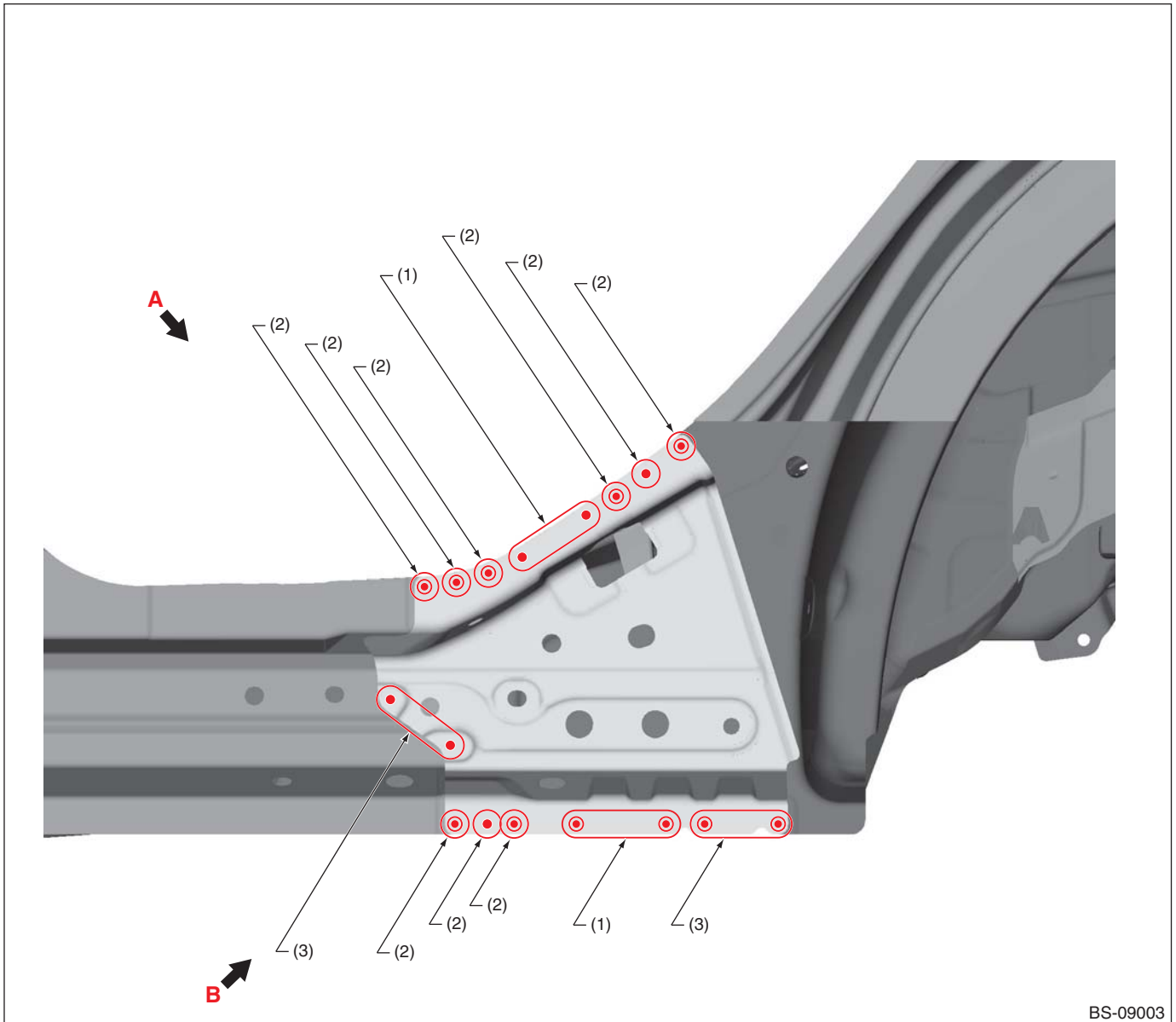
(3) 1 point (Continuous welding)

Panel Replacement

8-19. Side Sill Reinforcement Outer Rear (Total replacement)

A: REMOVAL

• Overall view



BS-09003

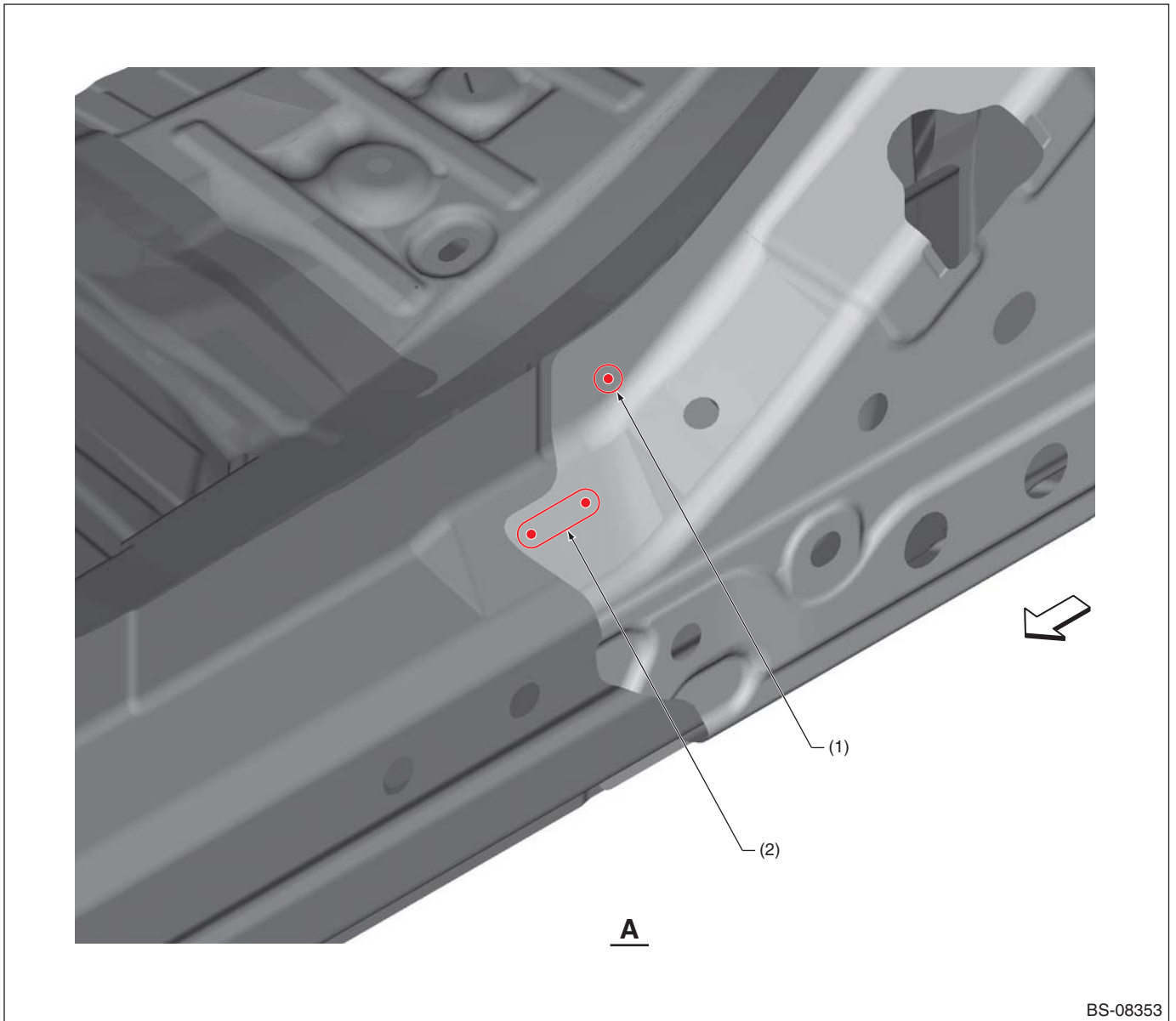
(1) 3 points (outside · 1)

(2) 1 point (outside · 1)

(3) 2 points (outside · 1)

Panel Replacement

• View A

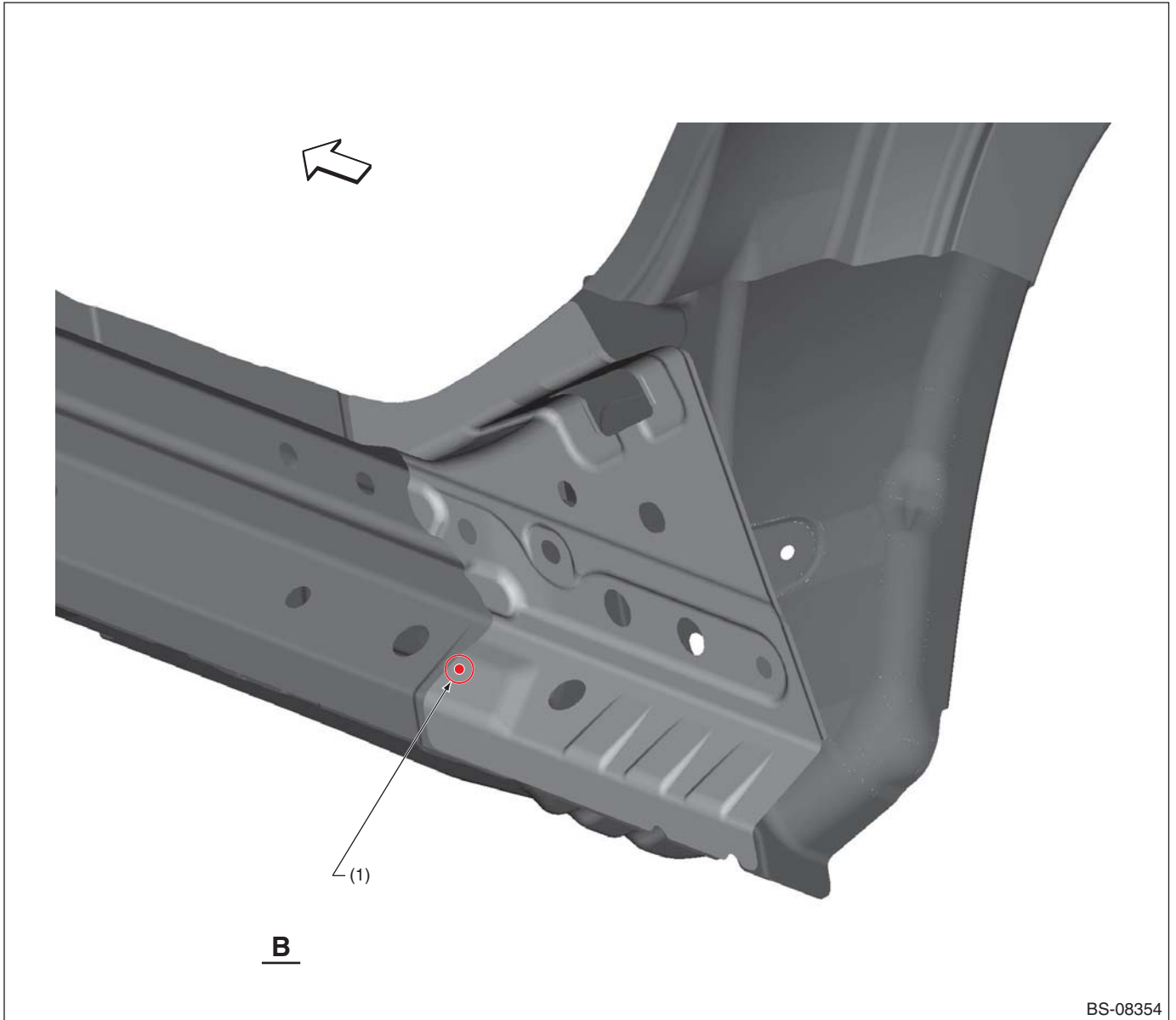


(1) 1 point (outside · 1)

(2) 2 points (top · 1)

Panel Replacement

- View B

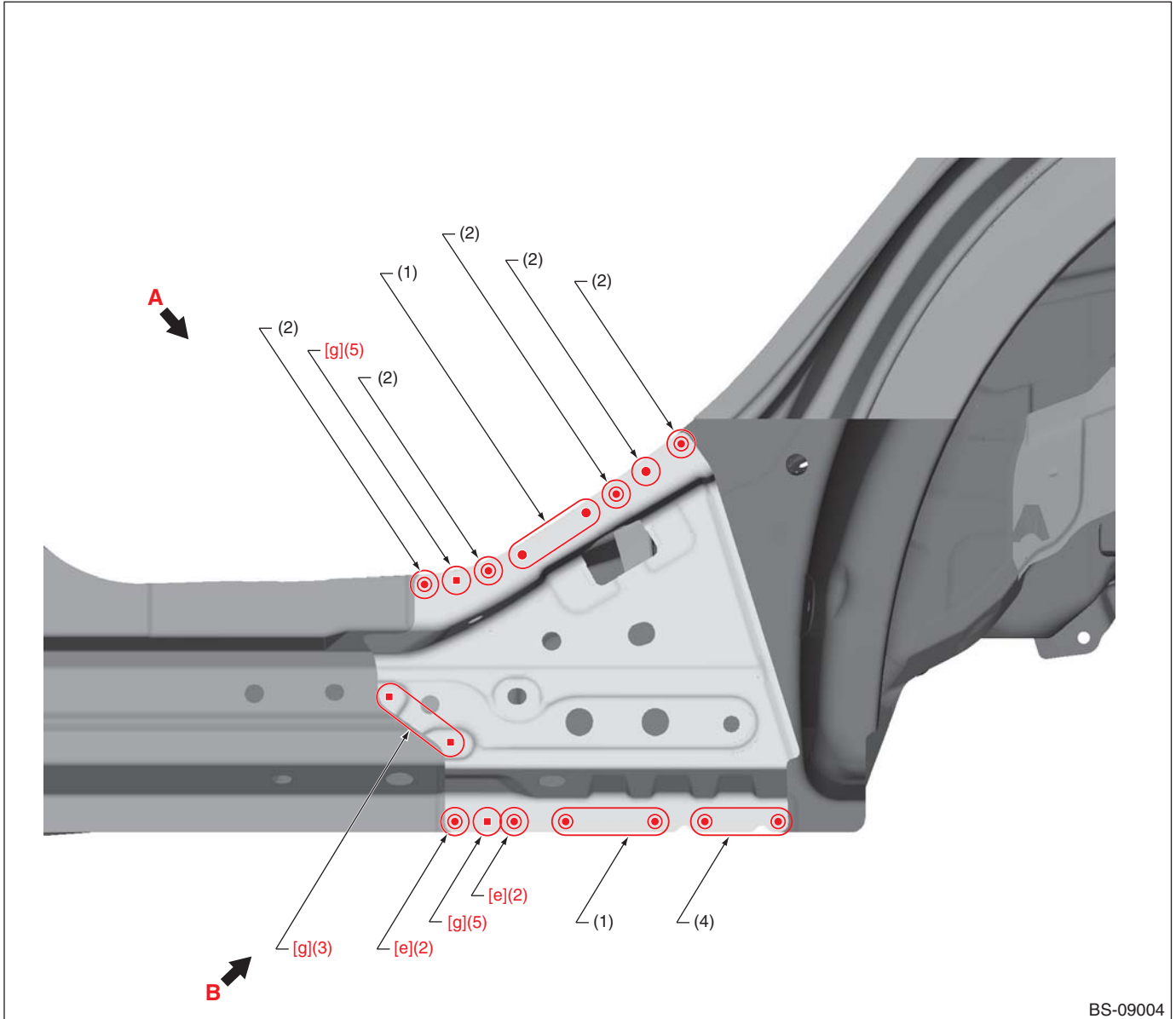


(1) 1 point (bottom · 1)

Panel Replacement

B: INSTALLATION

• Overall view



(1) 3 points
(2) 1 point

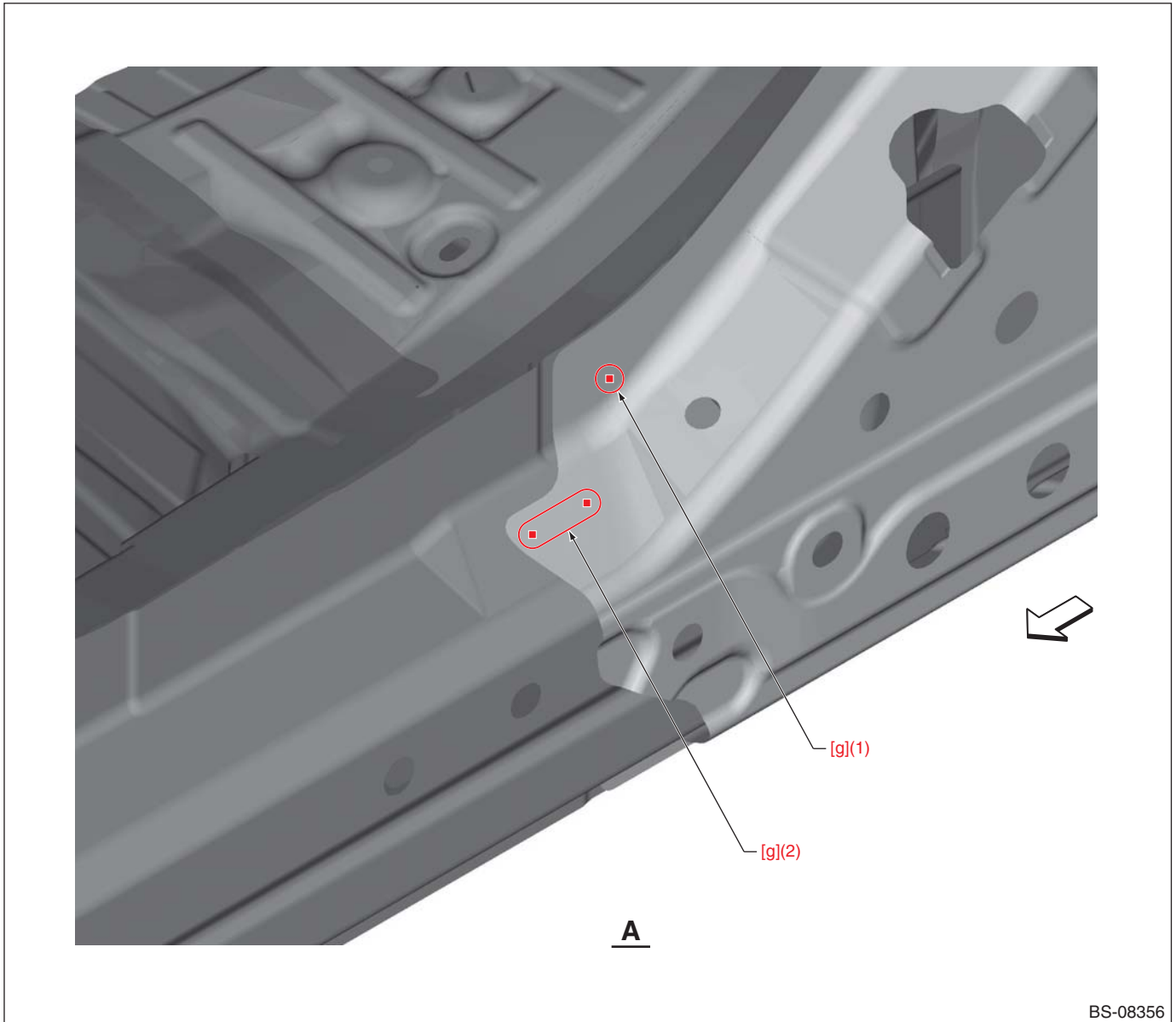
(3) 2 points (service)
(4) 2 points

(5) 1 point (service)

[e] Spot welding	Compression: 4.4 kN, Current: 8.0 kA, Welding time: 20 cyc
[g] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2 B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

• View A



(1) 1 point (service)

(2) 2 points (service)

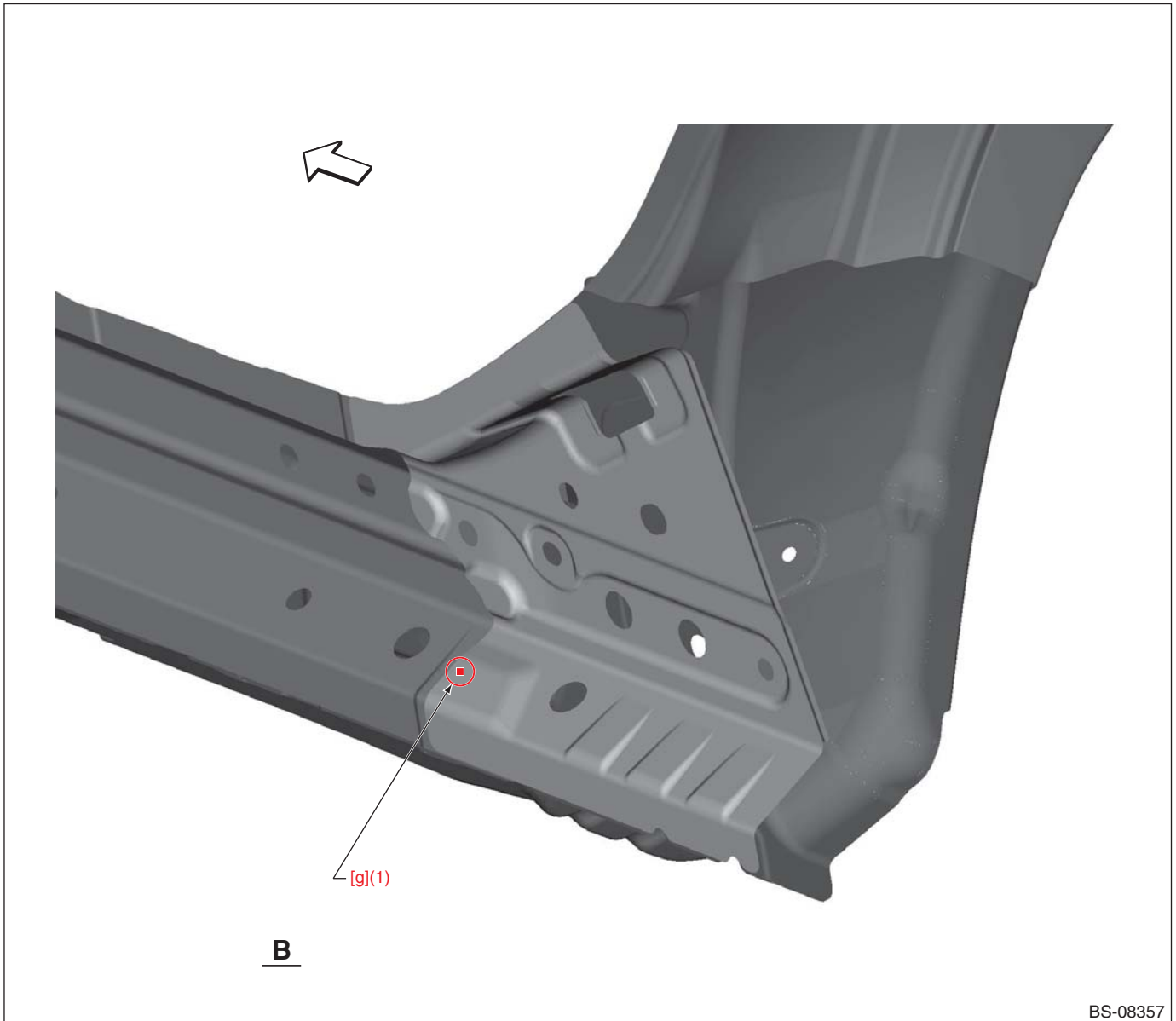
[g] Plug welding

A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2

B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

• View B



(1) 1 point (service)

[g] Plug welding

A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2

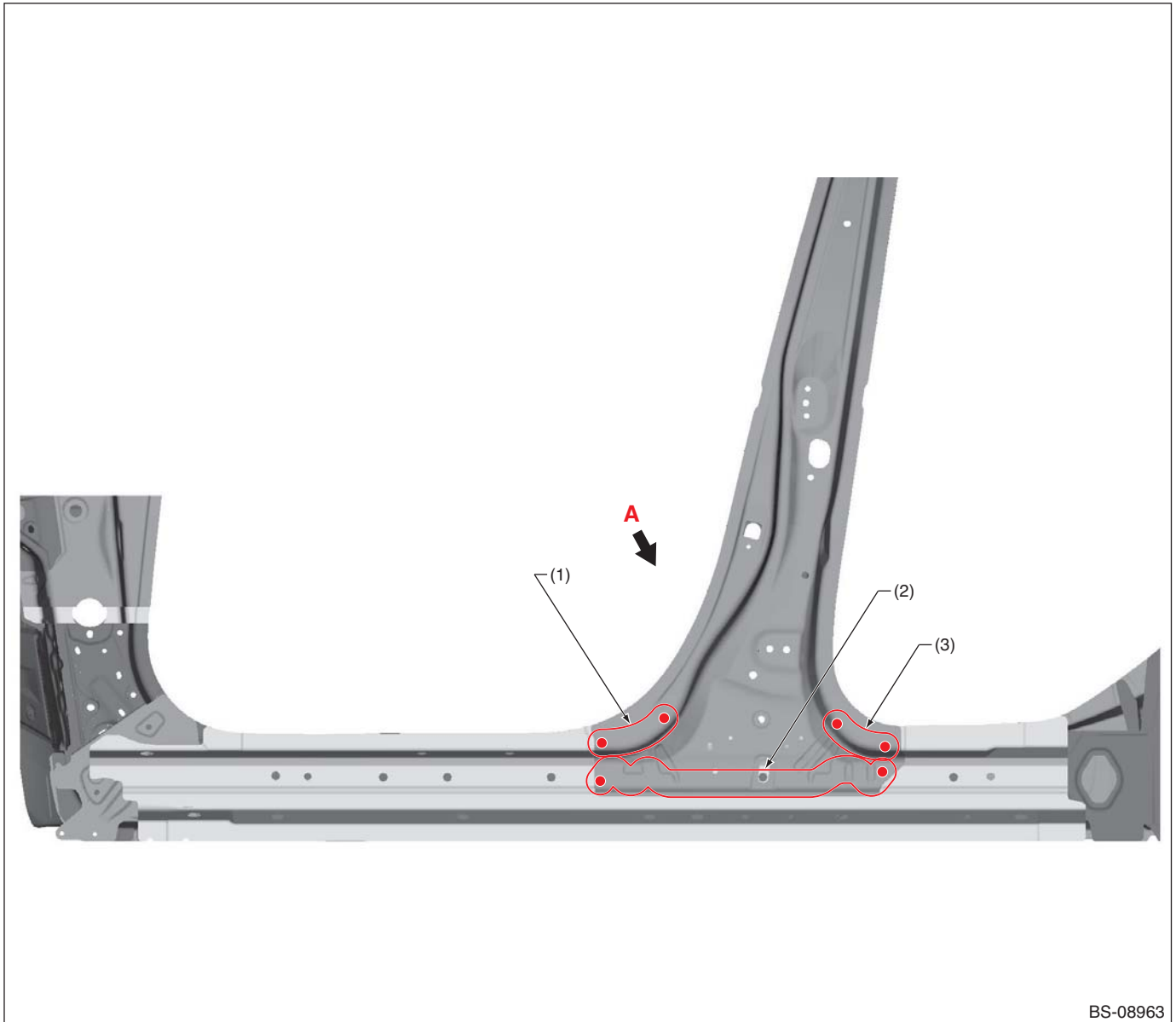
B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

8-20. Side Sill Reinforcement Outer (Total replacement)

A: REMOVAL

- Overall view 1



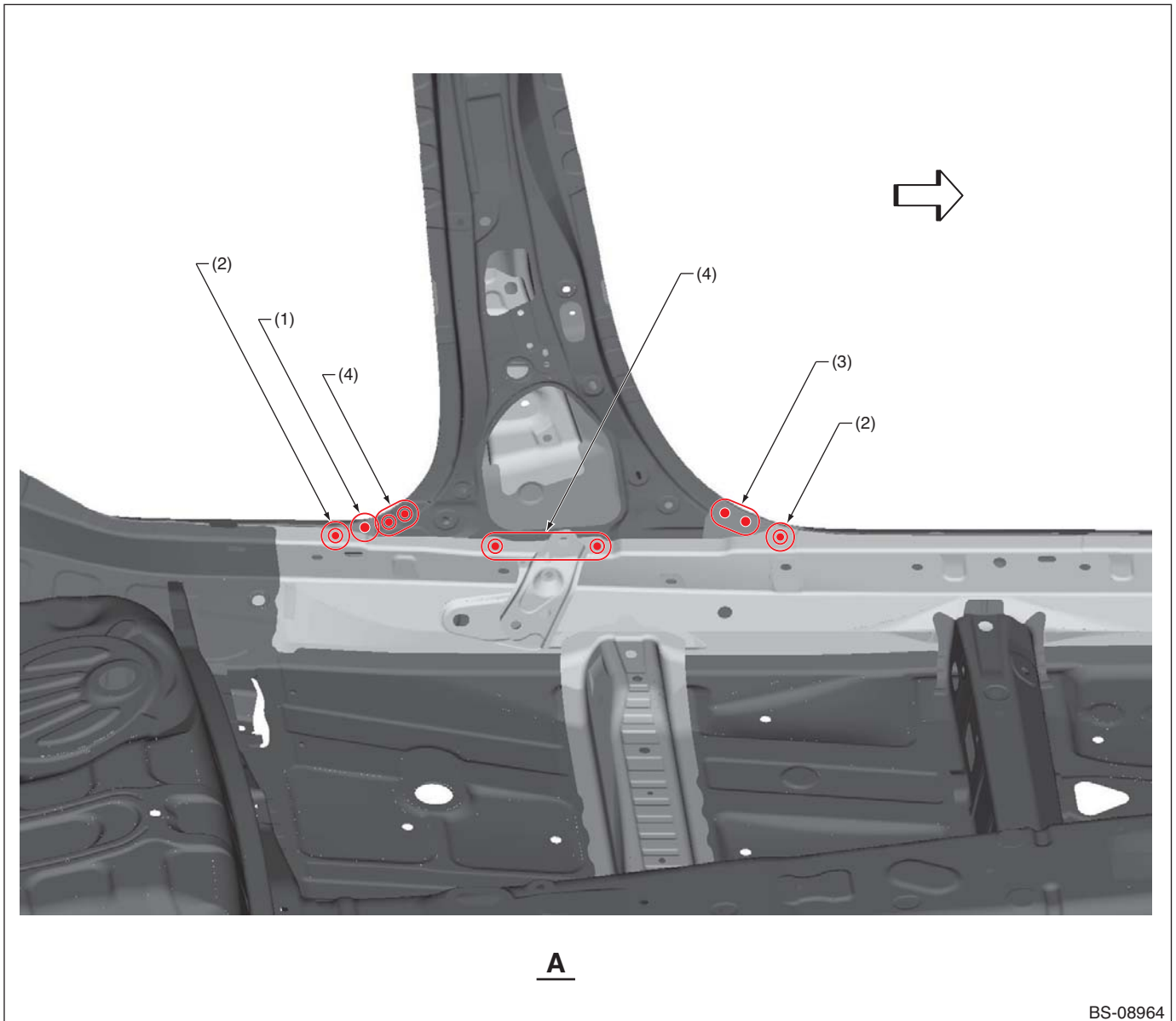
(1) 5 points (outside · 1)

(2) 16 points (outside · 1)

(3) 4 points (outside · 1)

Panel Replacement

• View A



BS-08964

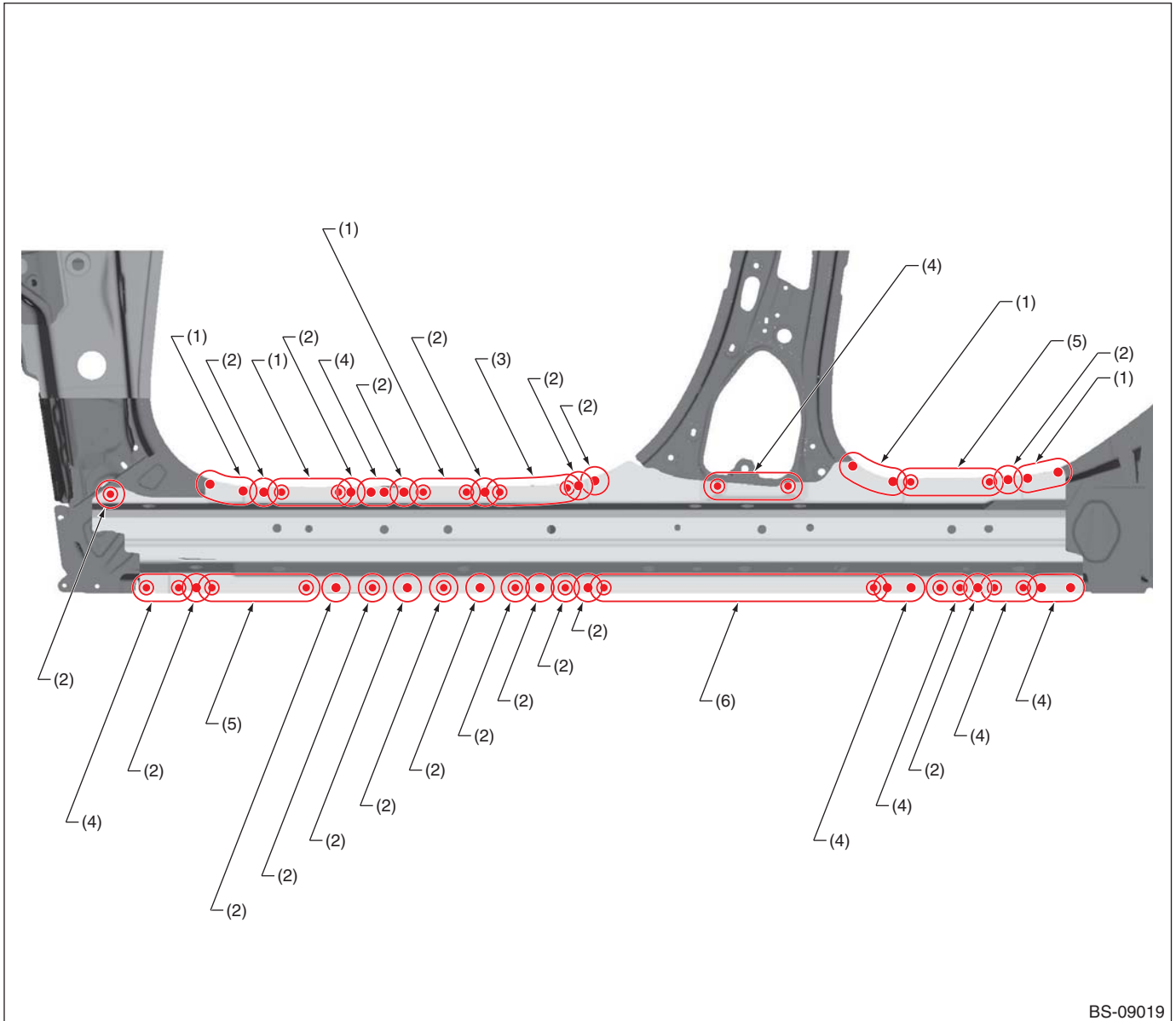
(1) 1 point (inside · 1)
(2) 1 point (inside · 2)

(3) 2 points (inside · 1)

(4) 2 points (inside · 2)

Panel Replacement

• Overall view 2



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

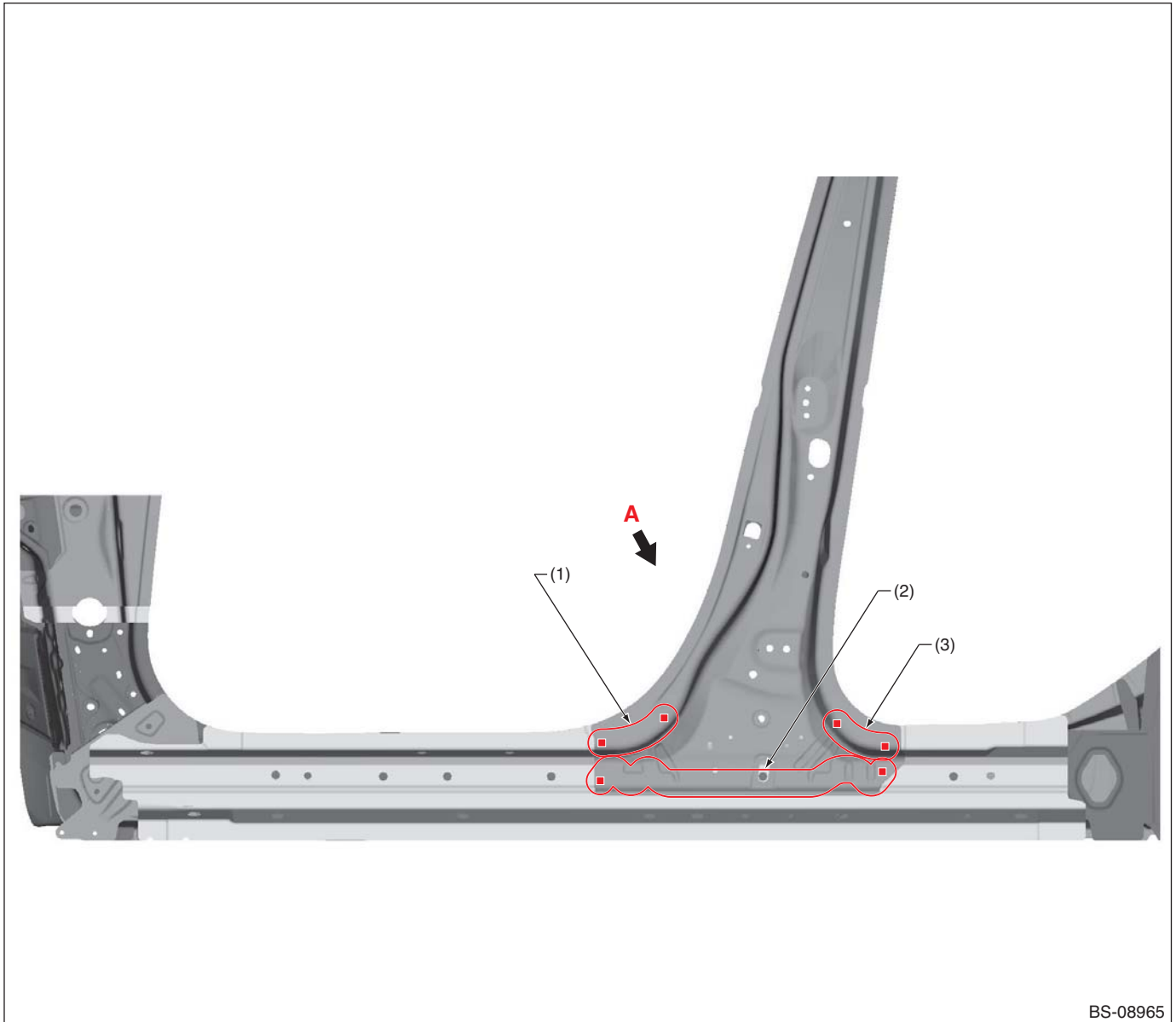
(3) 7 points (outside · 1)
(4) 2 points (outside · 1)

(5) 5 points (outside · 1)
(6) 11 points (outside · 1)

Panel Replacement

B: INSTALLATION

• Overall view 1



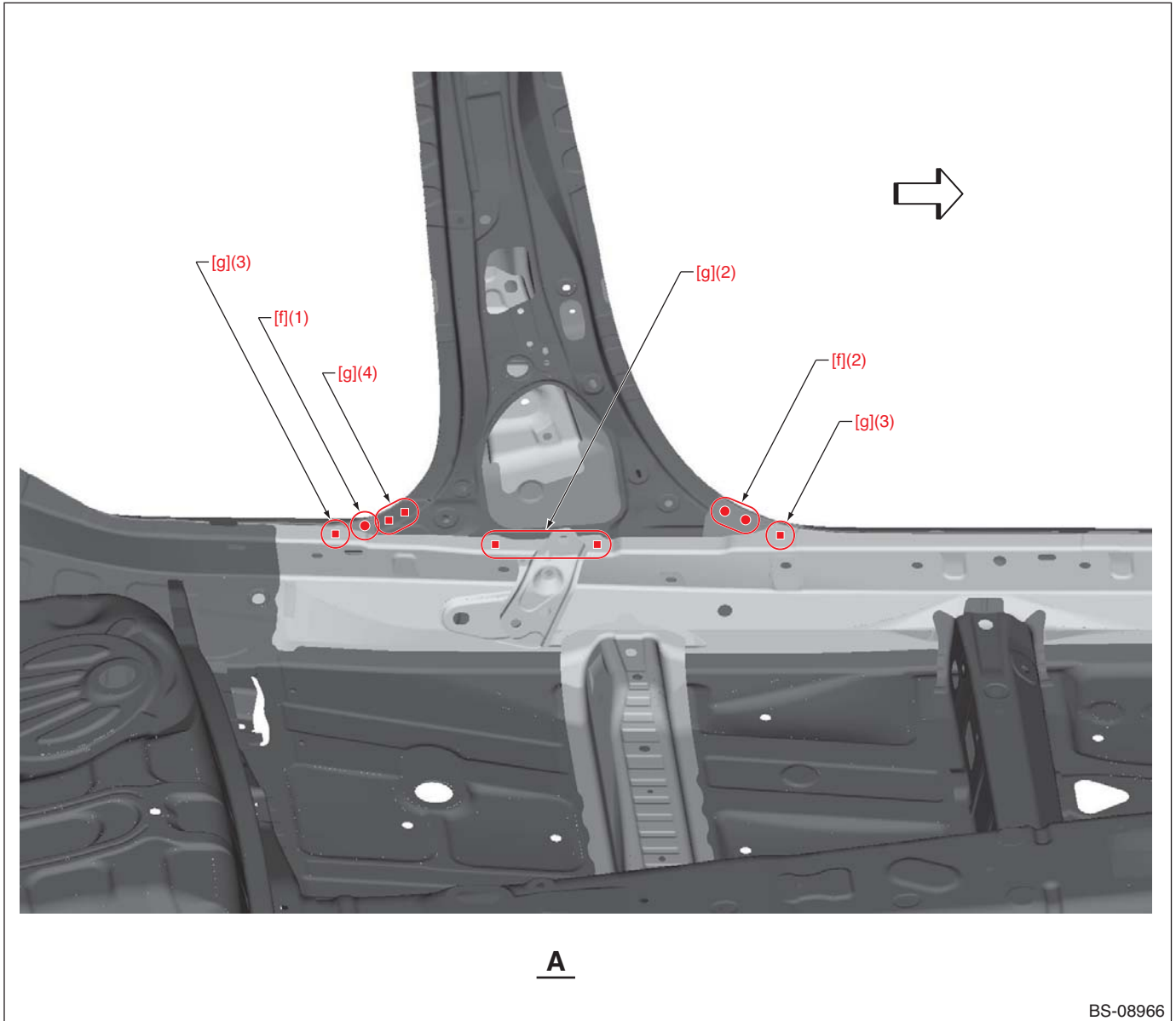
(1) 5 points

(2) 16 points

(3) 4 points

Panel Replacement

• View A



(1) 1 point
(2) 2 points

(3) 1 point (service · matching)

(4) 2 points (service · matching)

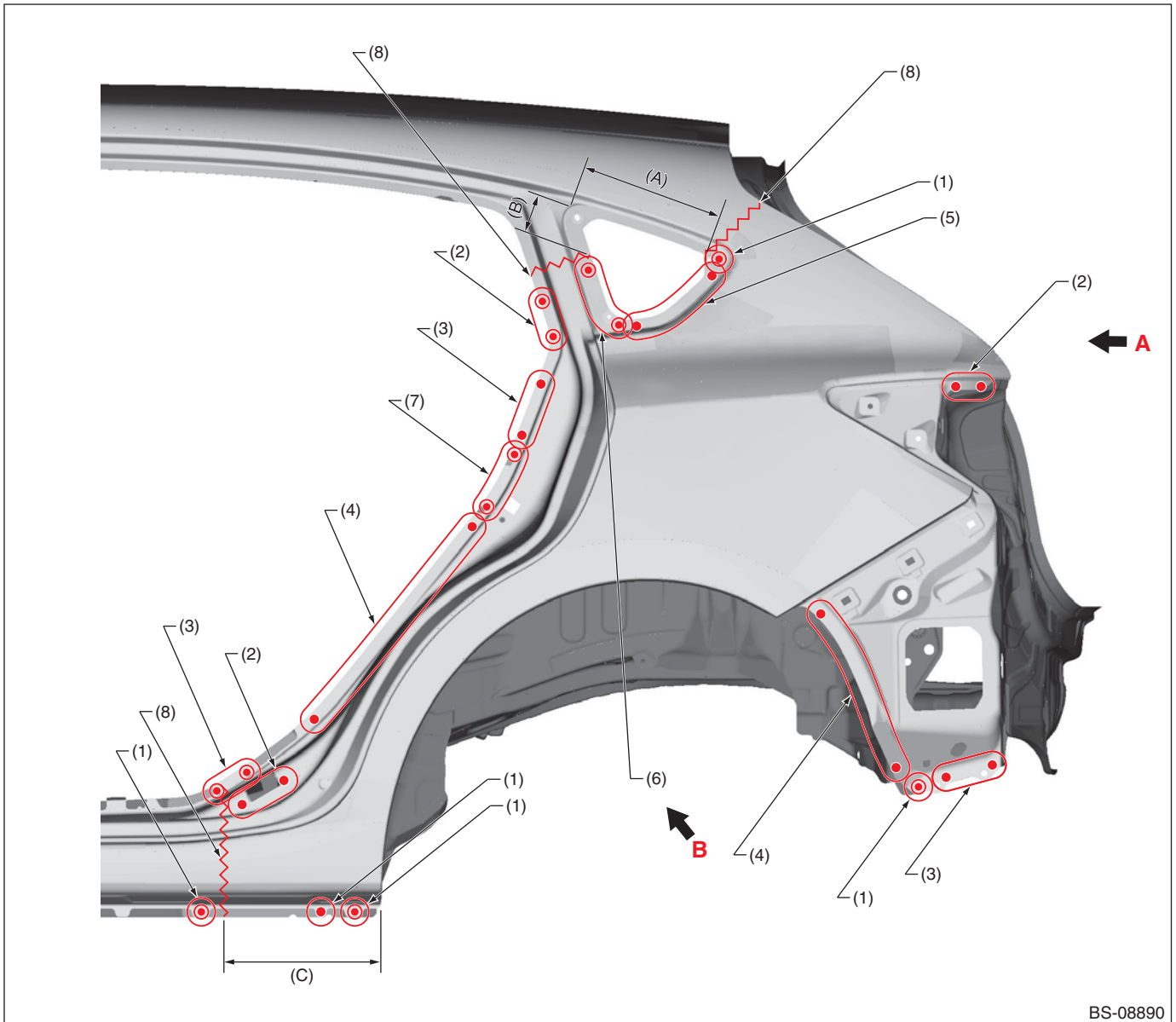
[f] Spot welding	Compression: 4.4 kN, Current: 8.0 kA, Welding time: 25 cyc
[g] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2 B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

8-21. Rear Quarter Panel (Partial replacement) / 5D

A: REMOVAL

• Overall view



(A) 250 mm [9.84 in]

(B) 130 mm [5.12 in]

(C) 250 mm [9.84 in]

(1) 1 point (outside · 1)

(4) 7 points (outside · 1)

(7) 2 points (outside · 2)

(2) 2 points (outside · 1)

(5) 5 points (outside · 1)

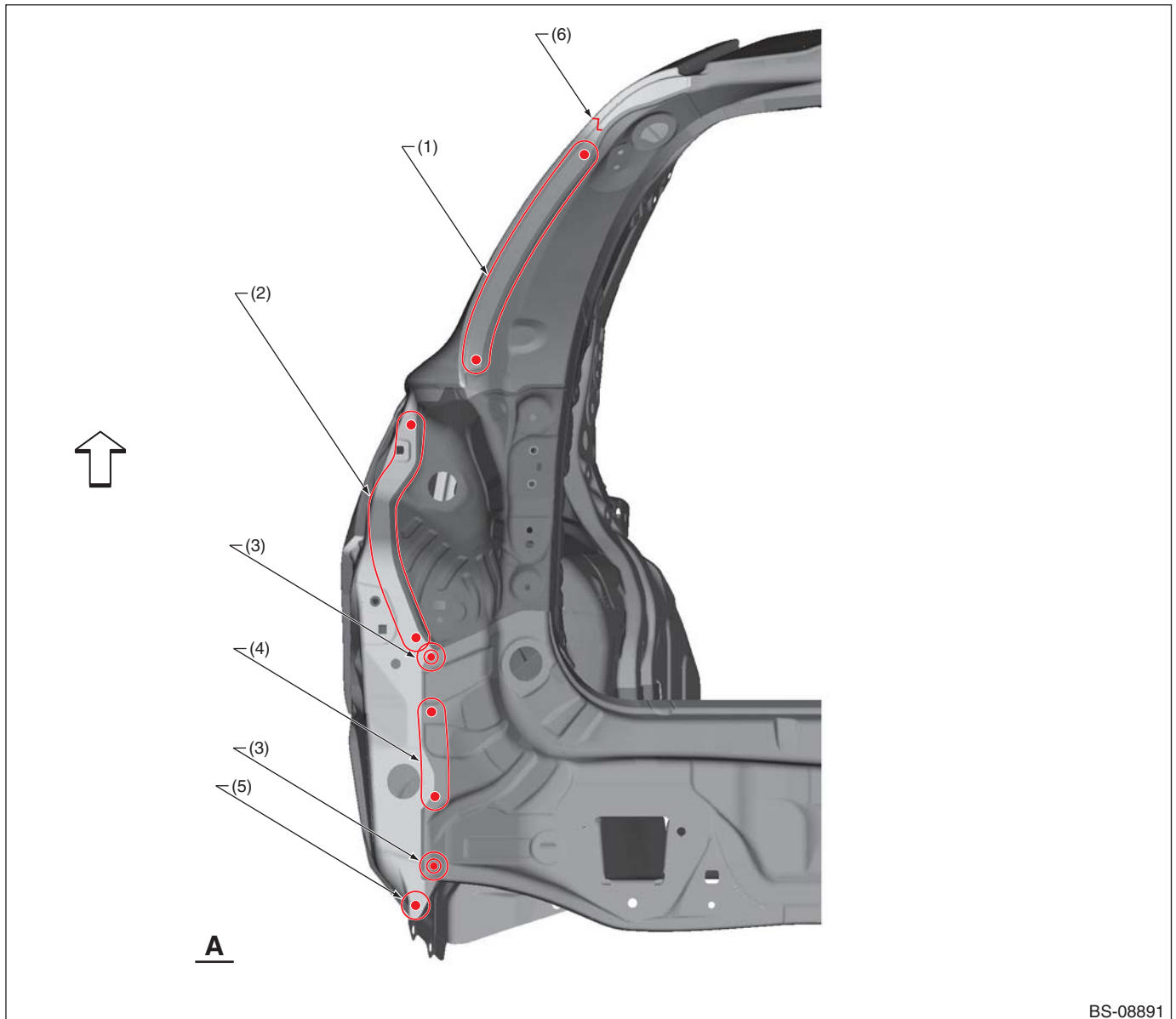
(8) Cut position

(3) 3 points (outside · 1)

(6) 4 points (outside · 1)

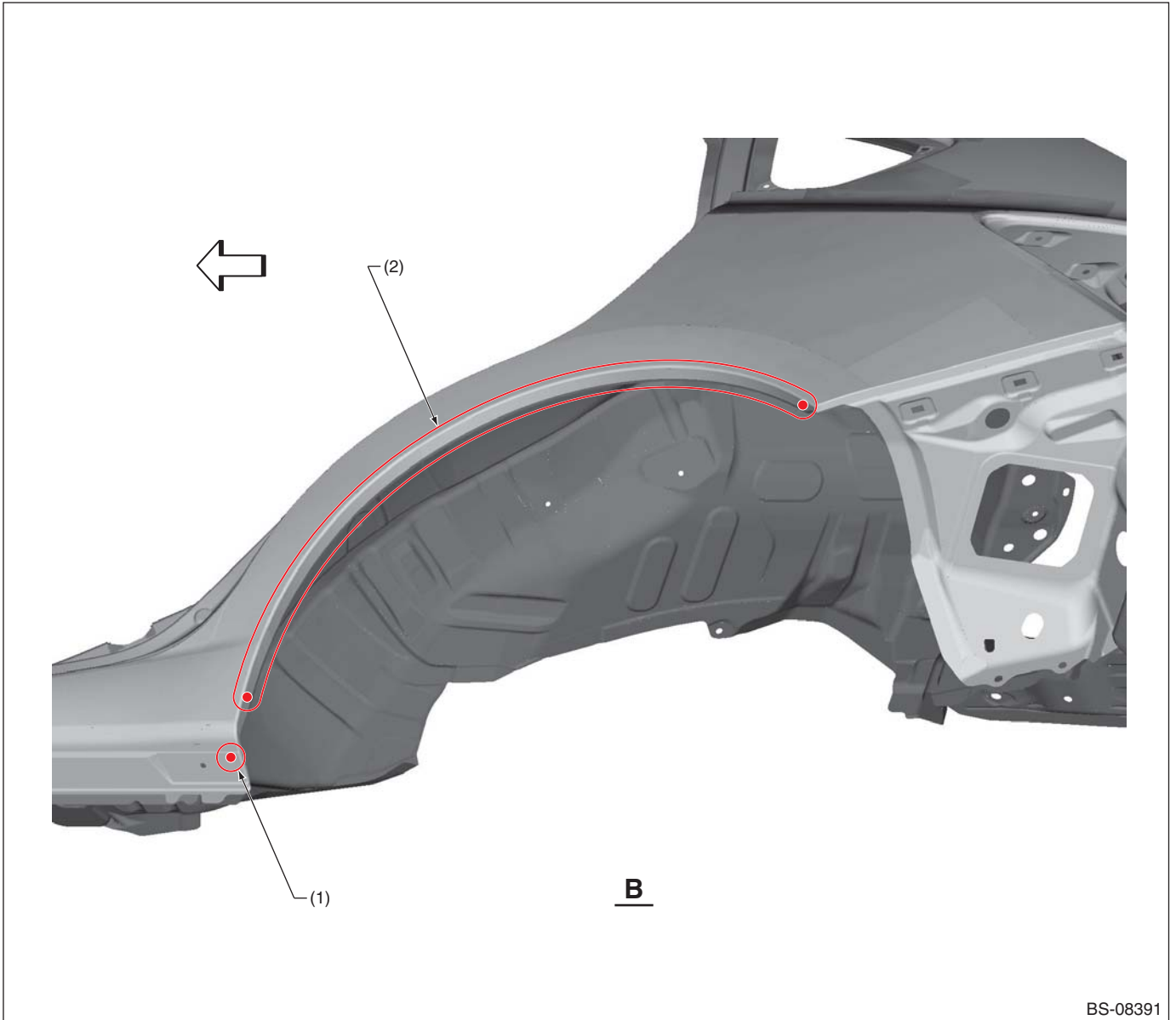
Panel Replacement

• View A



Panel Replacement

• View B



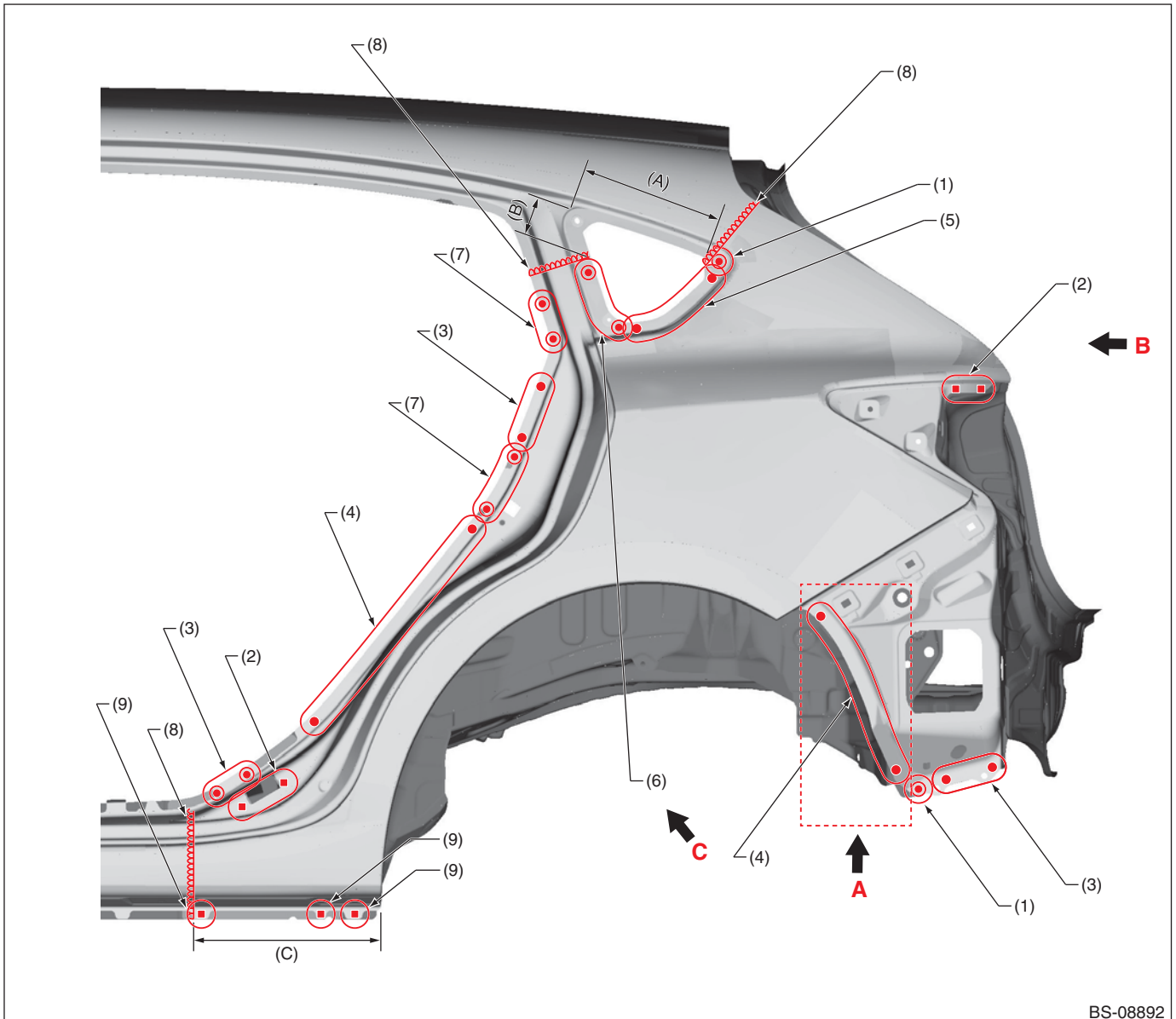
(1) 1 point (bottom · 1)

(2) 14 points (bottom · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BS-08892

(A) 230 mm [9.06 in]

(B) 110 mm [4.33 in]

(C) 289 mm [11.38 in]

(1) 1 point

(4) 7 points

(7) 2 points

(2) 2 points (service)

(5) 5 points

(8) 1 point (Continuous welding)

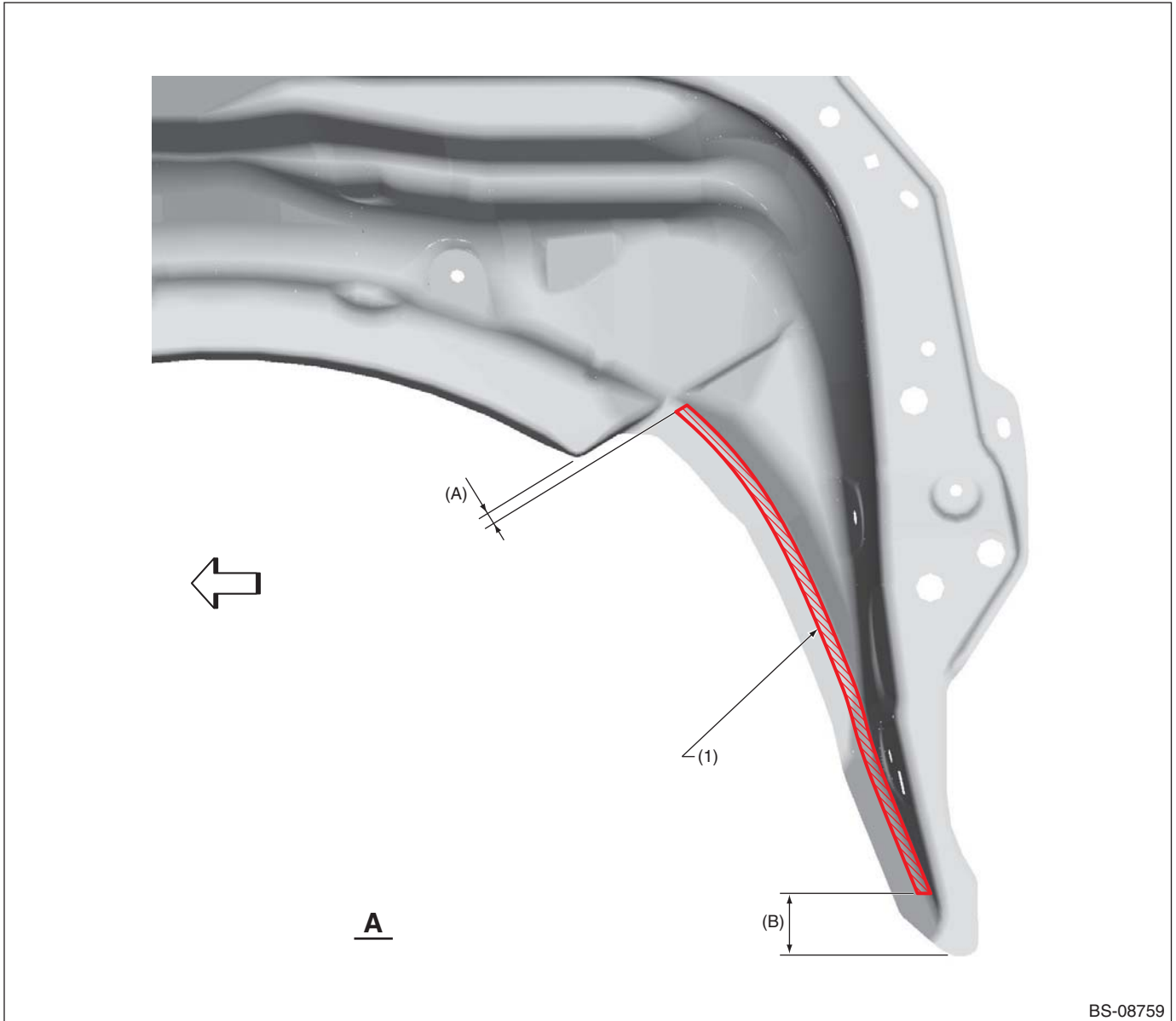
(3) 3 points

(6) 4 points

(9) 1 point (service)

Panel Replacement

• View A



BS-08759

(A) 5 mm [0.02 in]

(B) 34 mm [1.34 in]

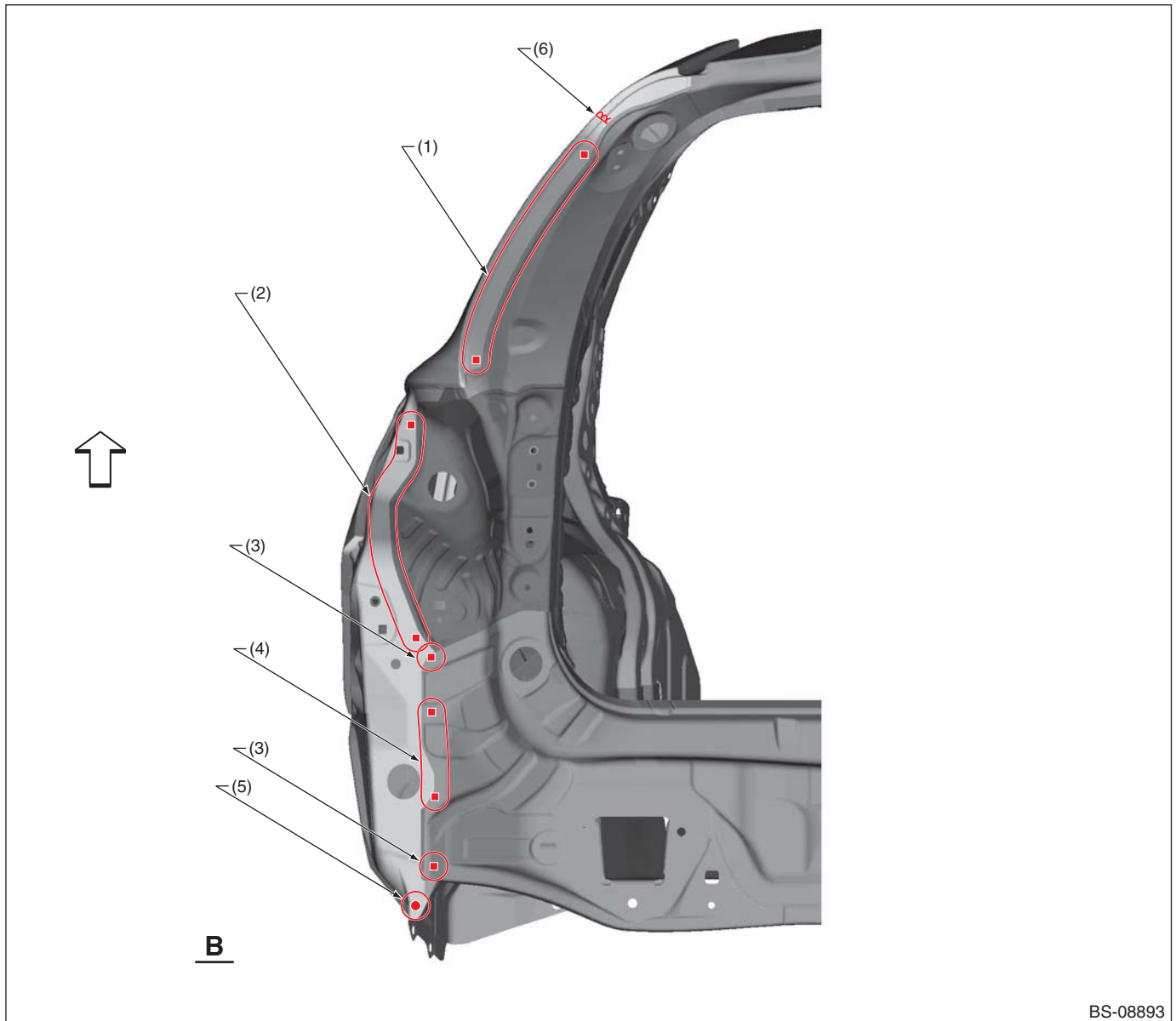
(1) Spotting sealer

 : Spotting sealer application location (Spotting sealer or sealing [Three Bond 4101 (004403063)])

Note: Fill spotting sealer between the panel side out and arch rear inner.

Panel Replacement

• View B



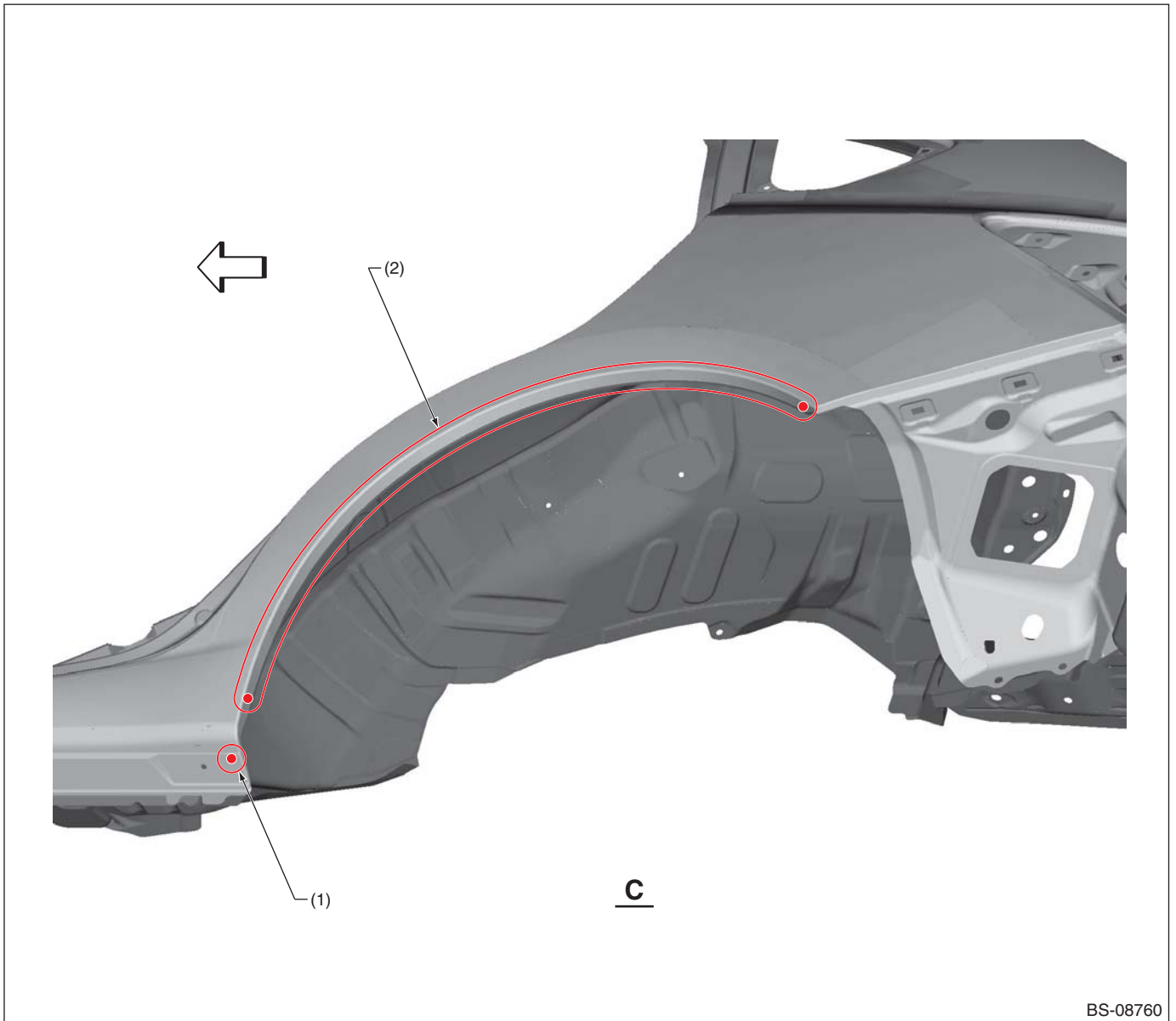
(1) 8 points (service)
(2) 6 points (service)

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

(5) 1 point
(6) 1 point (Continuous welding)

Panel Replacement

- View C



(1) 1 point

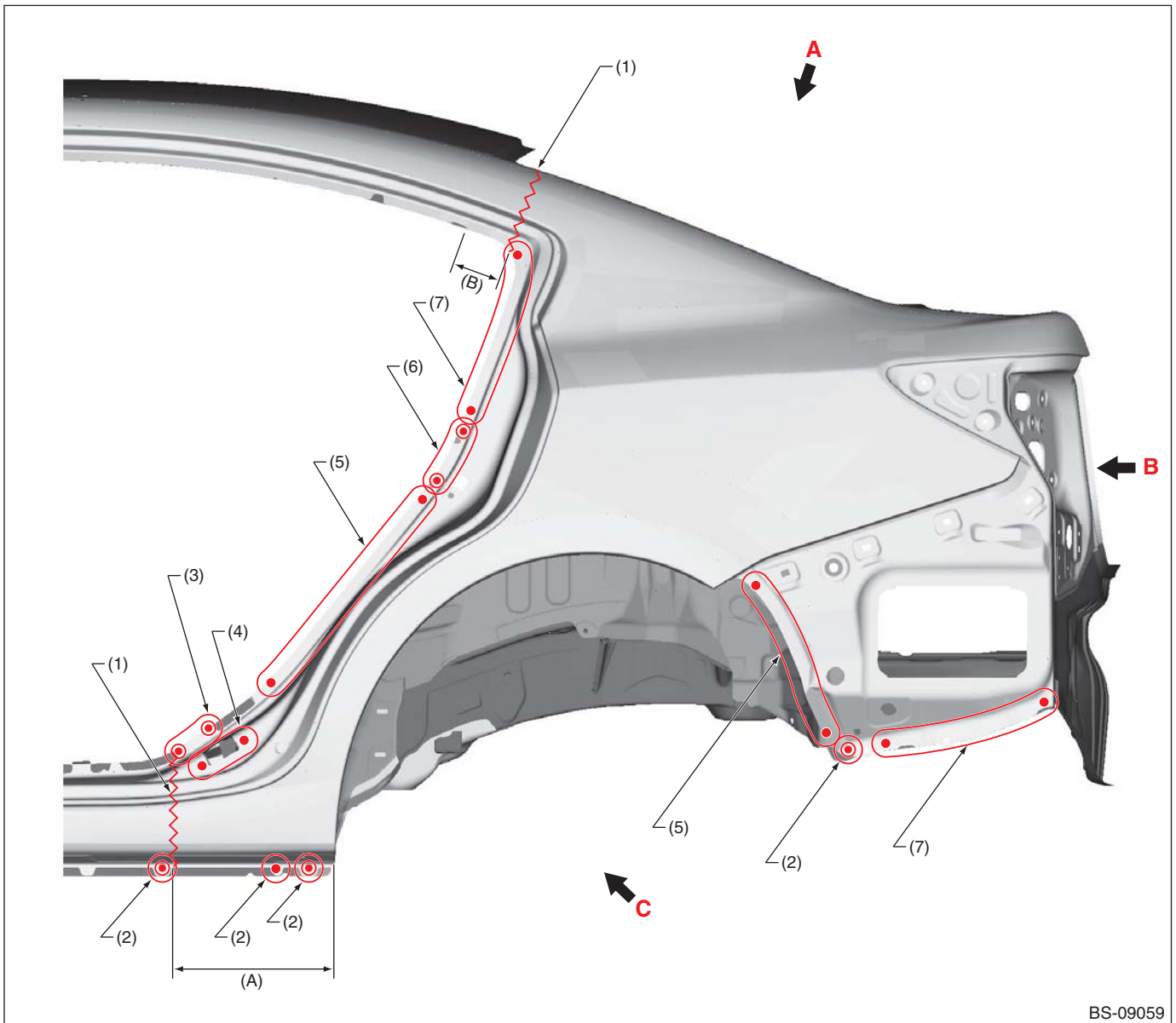
(2) 14 points

Panel Replacement

8-22. Rear Quarter Panel (Partial replacement) / 4D

A: REMOVAL

• Overall view



BS-09059

(A) 260 mm [10.24 in]

(B) 90 mm [3.54 in]

(1) Cut position

(2) 1 point (outside · 1)

(3) 3 points (outside · 1)

(4) 2 points (outside · 1)

(5) 7 points (outside · 1)

(6) 2 points (outside · 2)

(7) 6 points (outside · 1)

Panel Replacement

• View A



BS-09060

(A) 55 mm [2.17 in]

(1) 2 points (outside · 1)

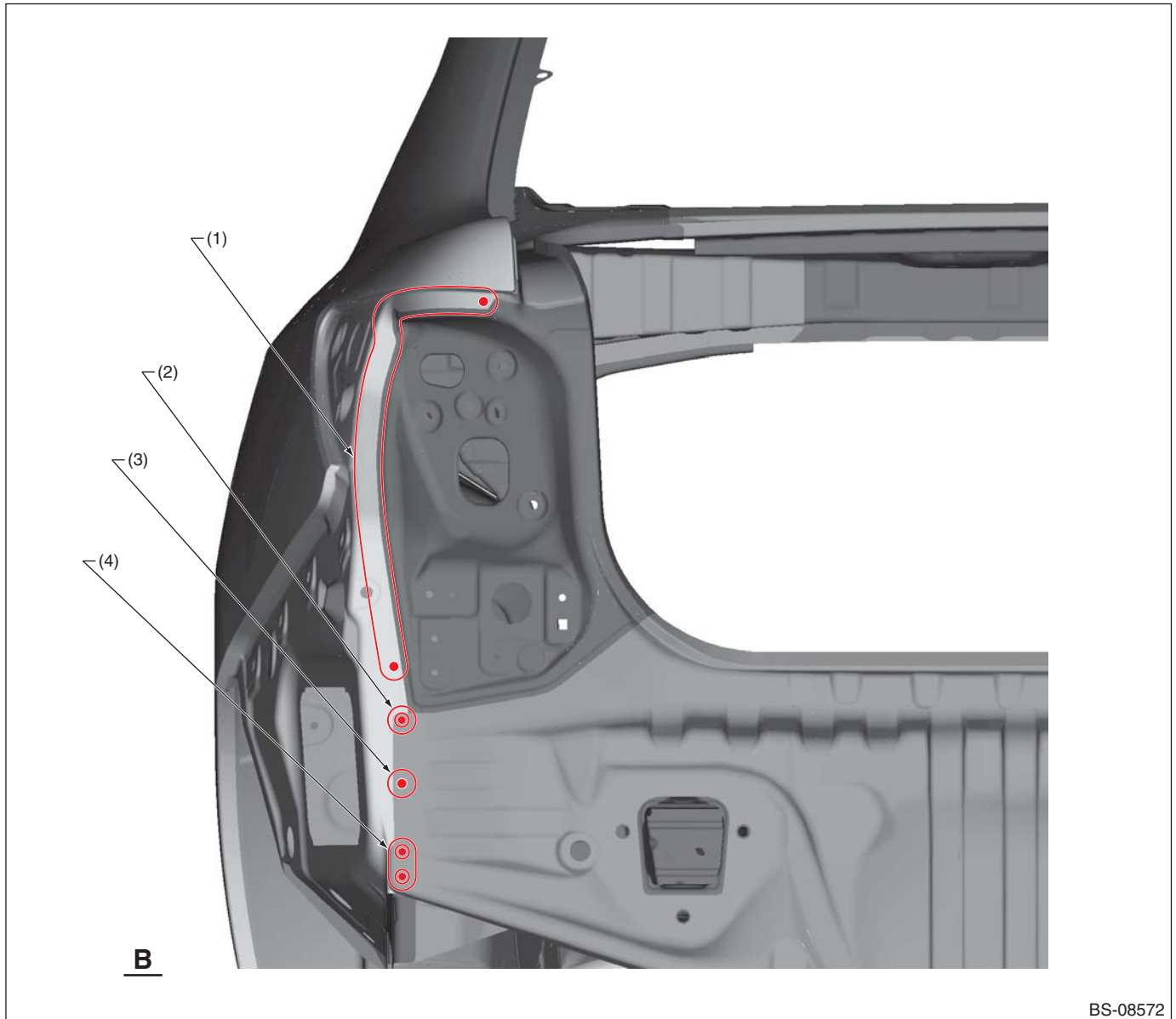
(3) 8 points (outside · 1)

(4) Cut position

(2) 1 point (outside · 1)

Panel Replacement

• View B



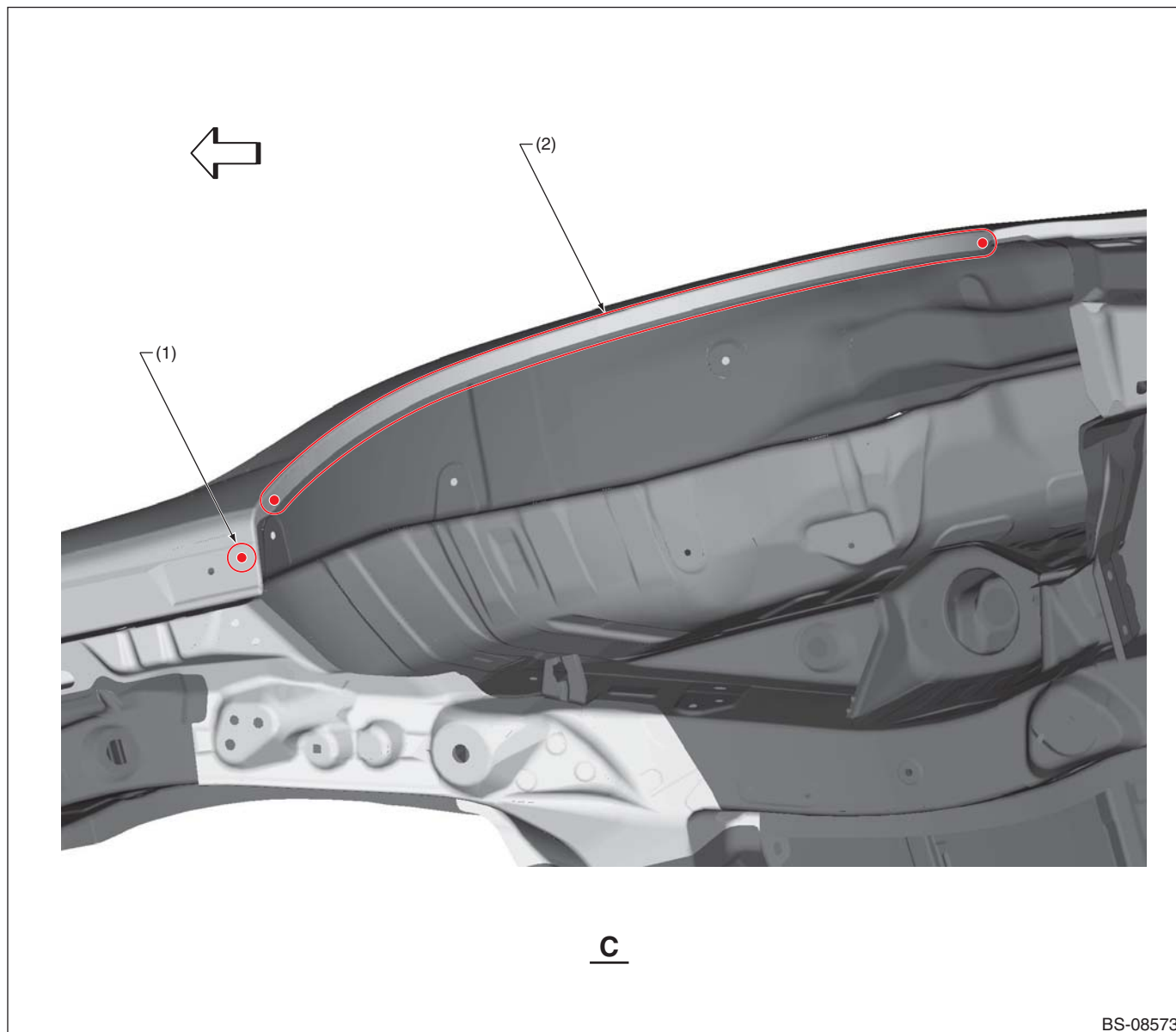
(1) 11 points (outside · 1)
(2) 1 point (outside · 2)

(3) 1 point (outside · 1)

(4) 2 points (outside · 2)

Panel Replacement

• View C



BS-08573

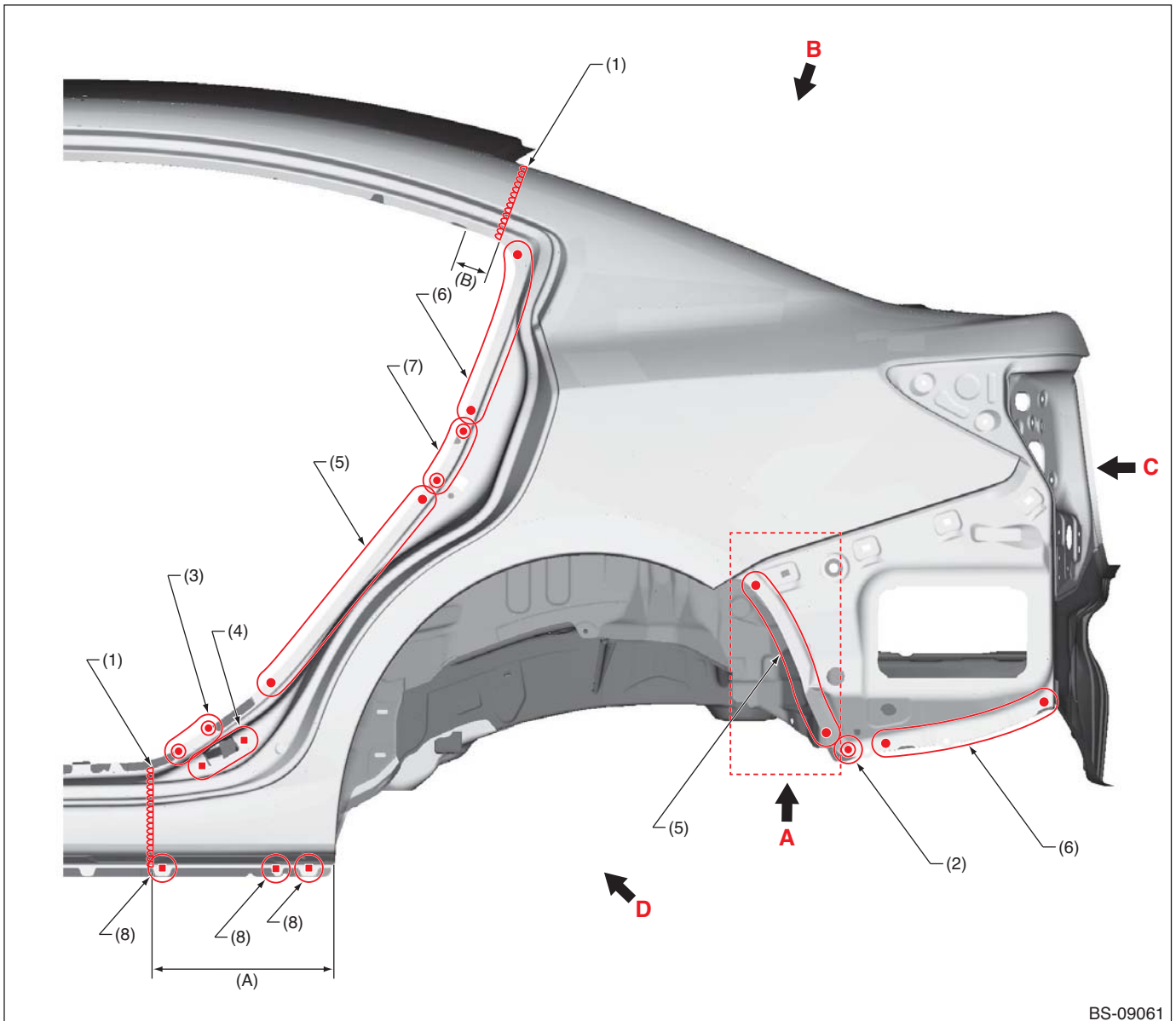
(1) 1 point (bottom · 1)

(2) 14 points (outside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BS-09061

(A) 289 mm [11.38 in]

(B) 60 mm [2.36 in]

(1) 1 point (Continuous welding)

(4) 2 points (service)

(7) 2 points

(2) 1 point

(5) 7 points

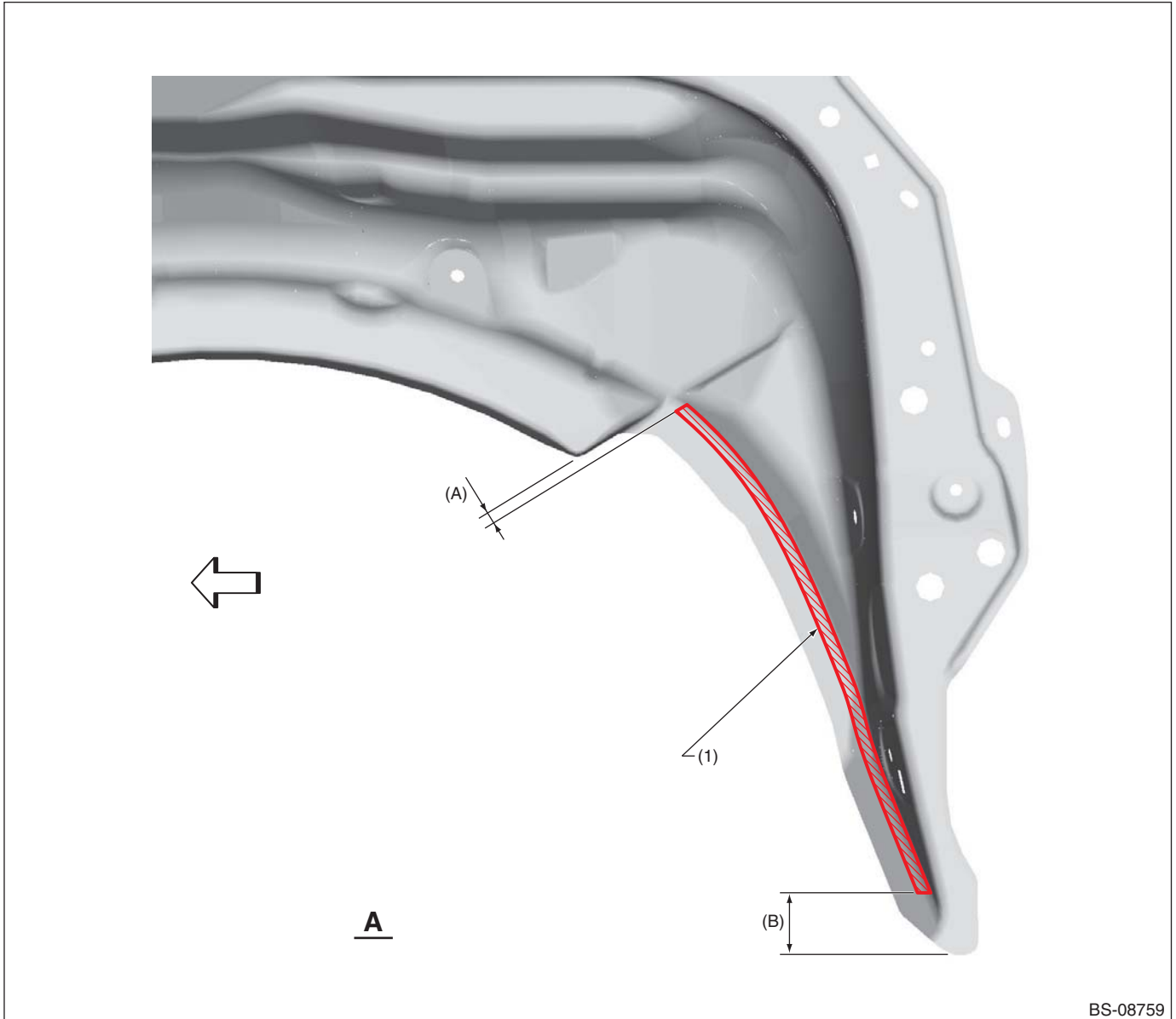
(8) 1 point (service)

(3) 3 points

(6) 6 points

Panel Replacement

• View A



BS-08759

(A) 5 mm [0.02 in]

(B) 34 mm [1.34 in]

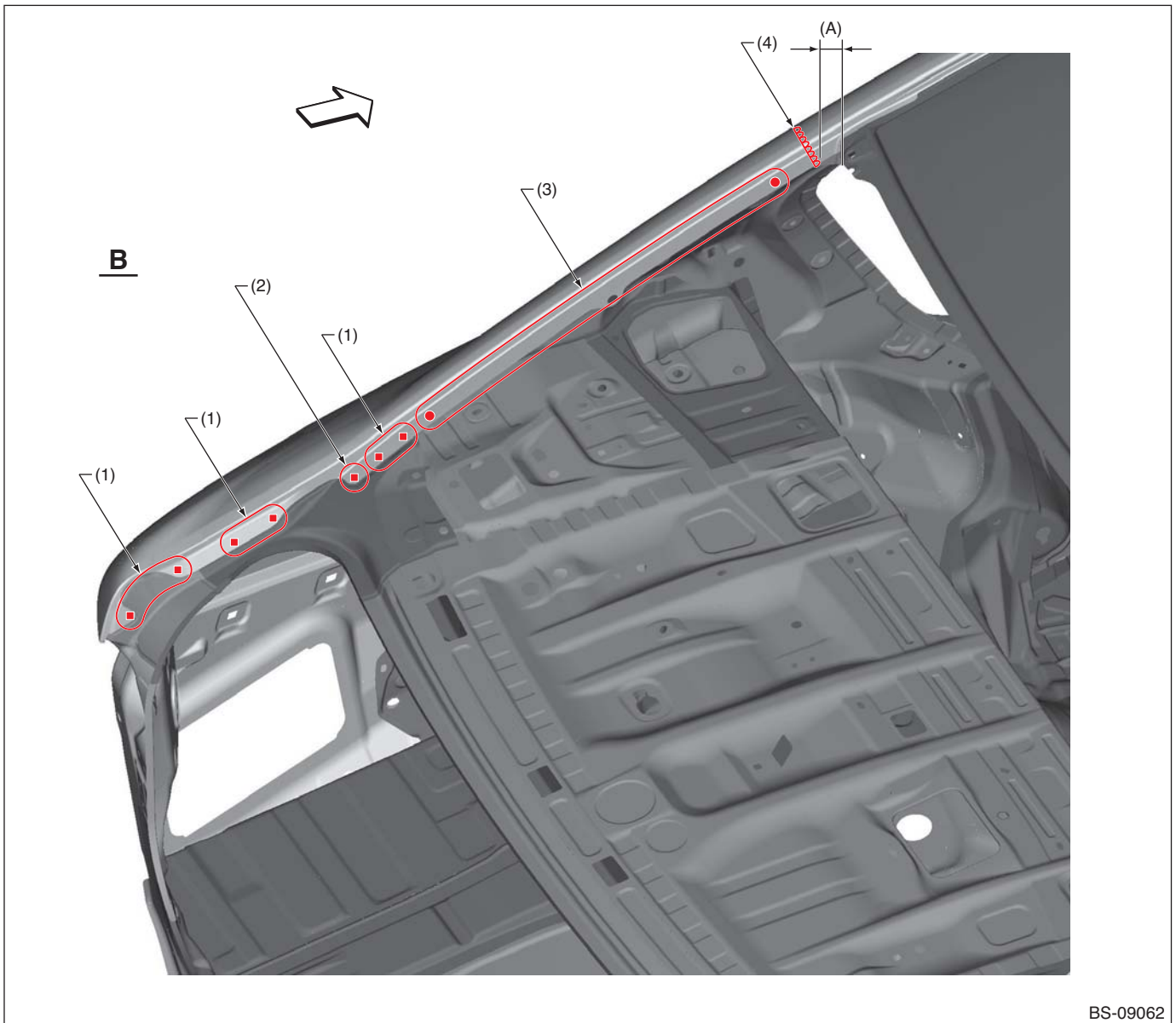
(1) Spotting sealer

 : Spotting sealer application location (Spotting sealer or sealing [Three Bond 4101 (004403063)])

Note: Fill spotting sealer between the panel side out and arch rear inner.

Panel Replacement

• View B



(A) 25 mm [0.98 in]

(1) 2 points (service)

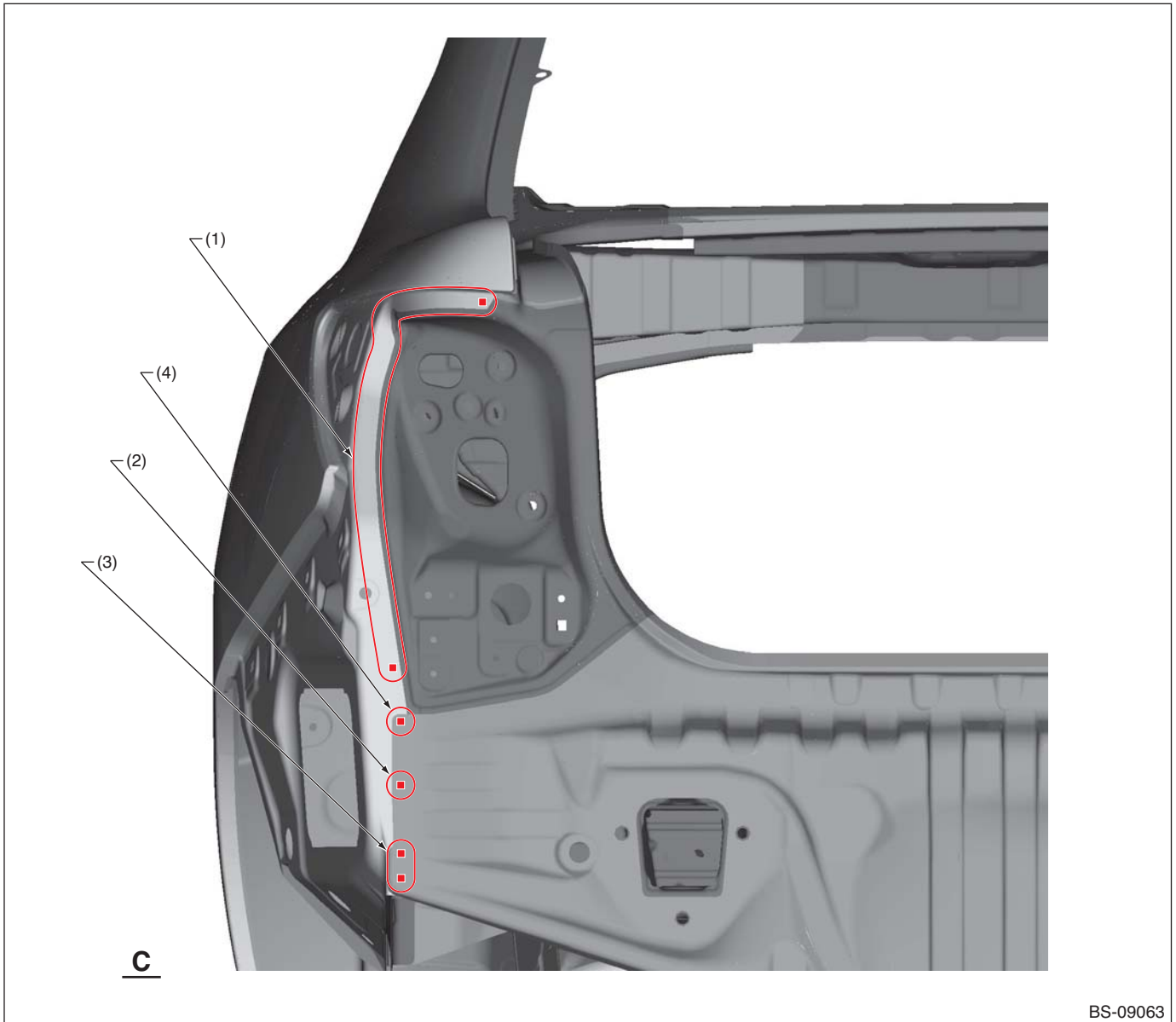
(2) 1 point (service)

(3) 8 points

(4) 1 point (Continuous welding)

Panel Replacement

• View C



(1) 11 points (service)

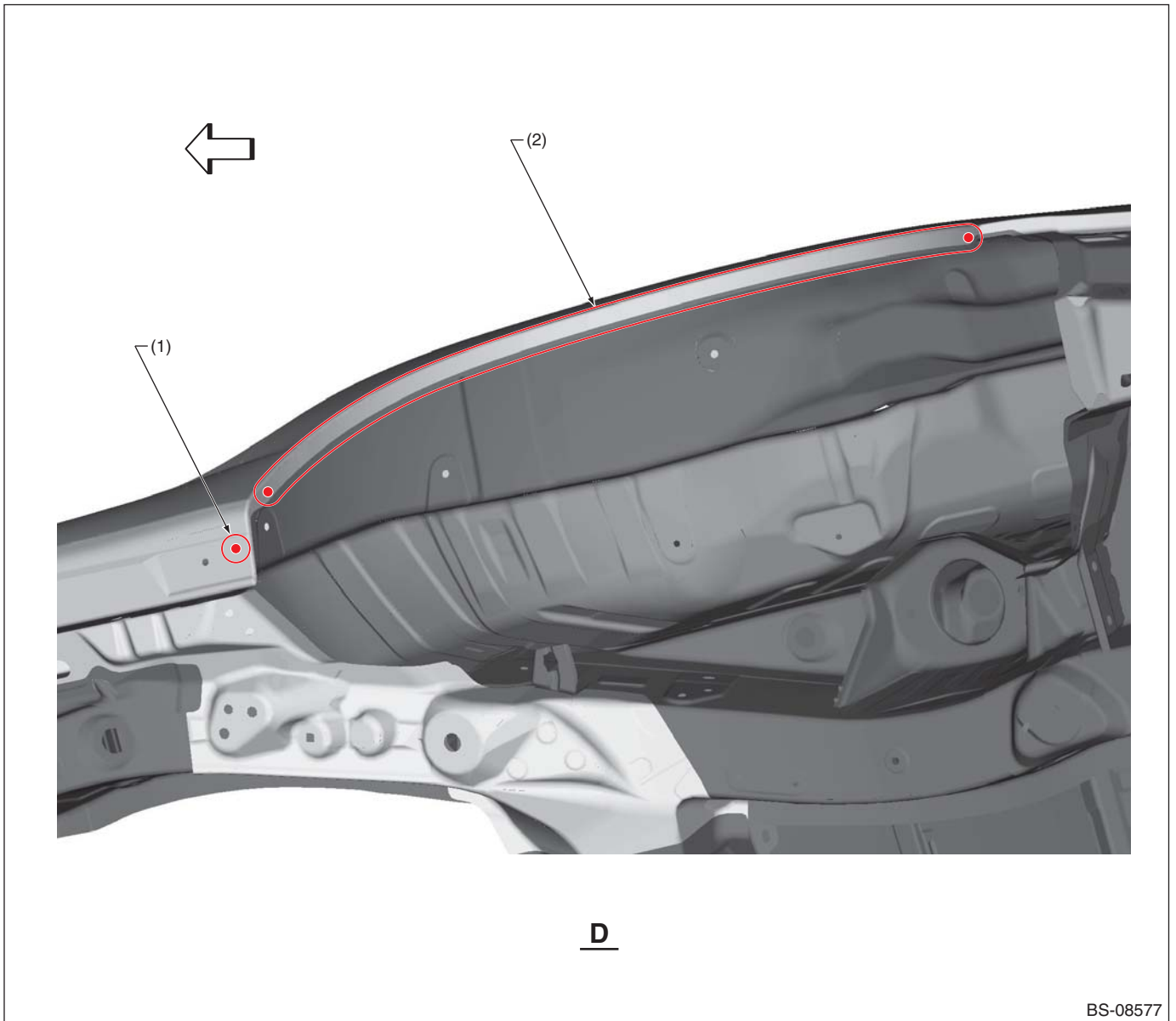
(2) 1 point

(3) 2 points (service · matching)

(4) 1 point (service · matching)

Panel Replacement

• View D



(1) 1 point

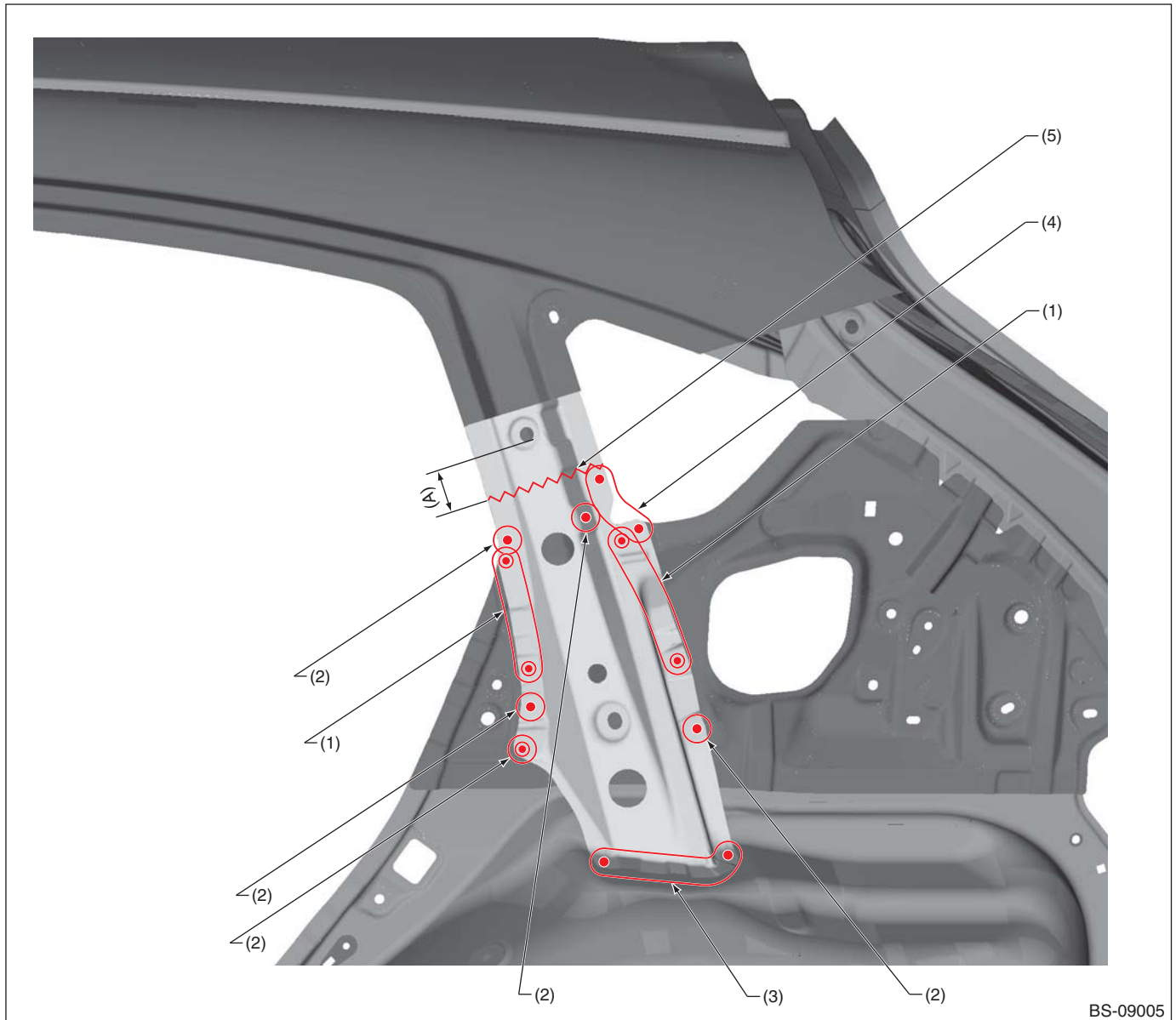
(2) 14 points

Panel Replacement

8-23. Rear Pillar Reinforcement Outer LH (Partial replacement) / 5D

A: REMOVAL

• Overall view



(A) 55 mm [2.17 in]

(1) 3 points (outside · 1)

(2) 1 point (outside · 1)

(3) 4 points (top · 1)

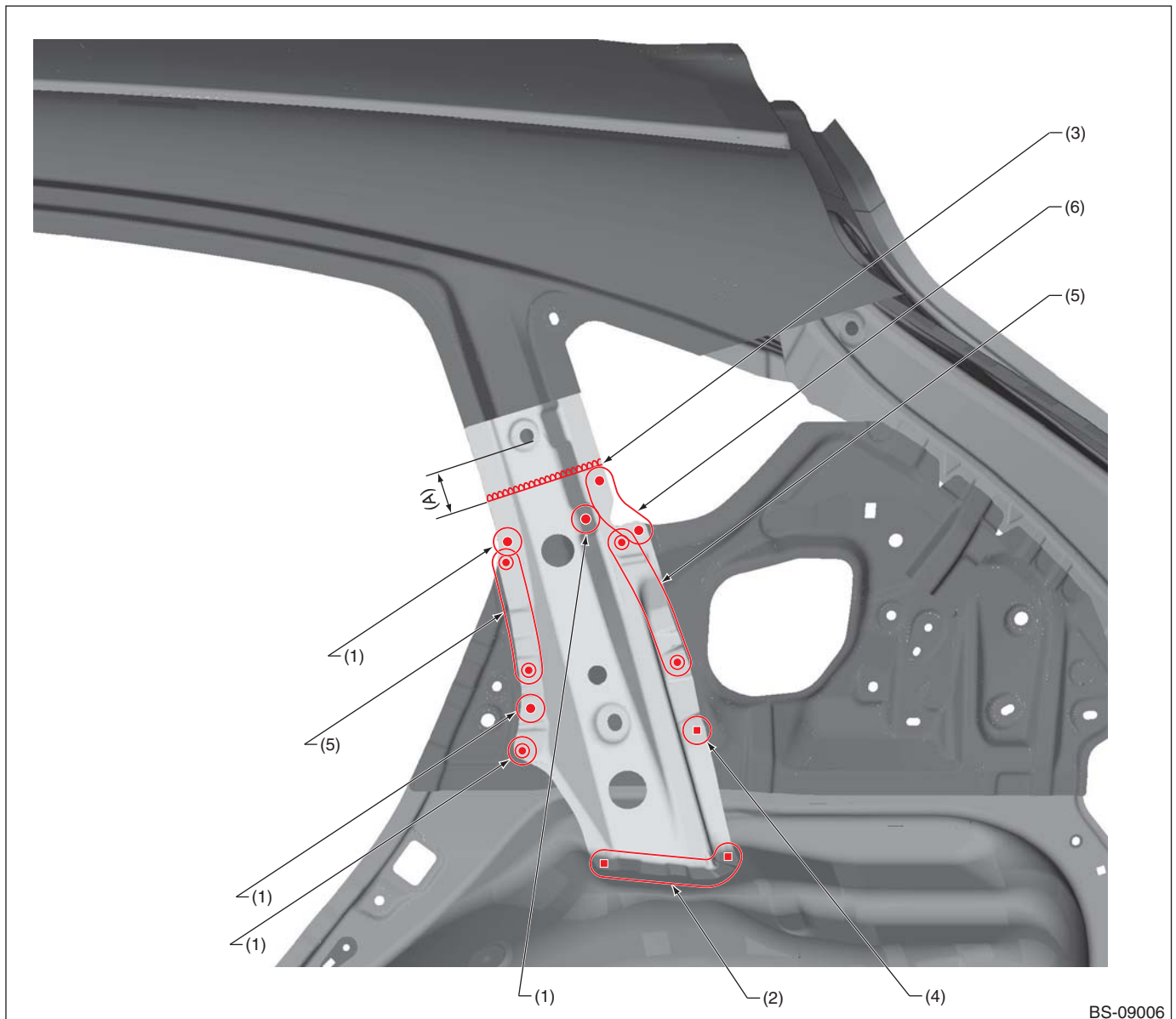
(4) 2 points (outside · 1)

(5) Cut position

Panel Replacement

B: INSTALLATION

• Overall view



(A) 40 mm [1.57 in]

(1) 1 point

(2) 4 points (service)

(3) 1 point (Continuous welding)

(4) 1 point (service)

(5) 3 points

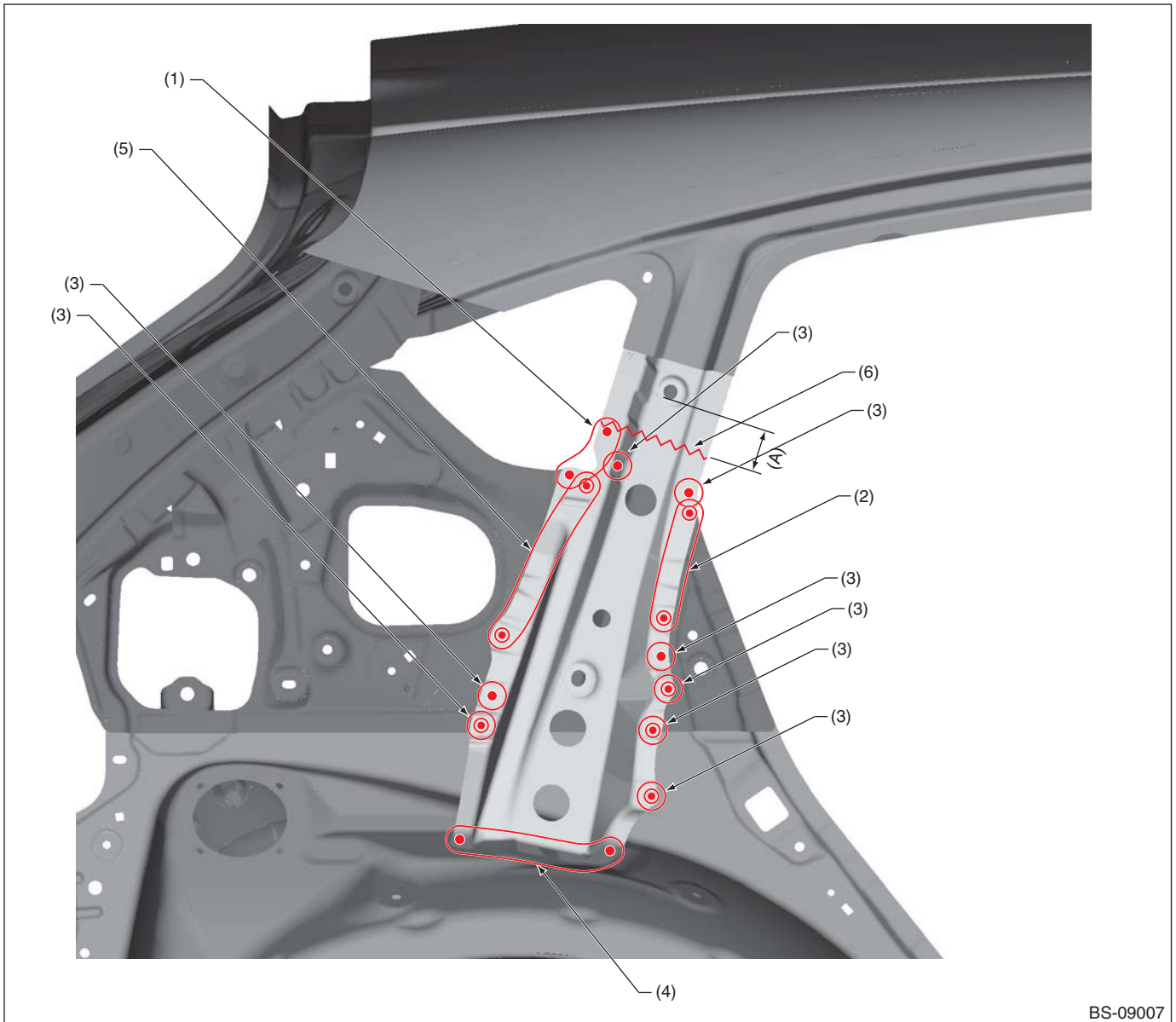
(6) 2 points

Panel Replacement

8-24. Rear Pillar Reinforcement Outer RH (Partial replacement) / 5D

A: REMOVAL

• Overall view



BS-09007

(A) 55 mm [2.17 in]

(1) 2 points (outside · 1)

(2) 3 points (outside · 1)

(3) 1 point (outside · 1)

(4) 4 points (top · 1)

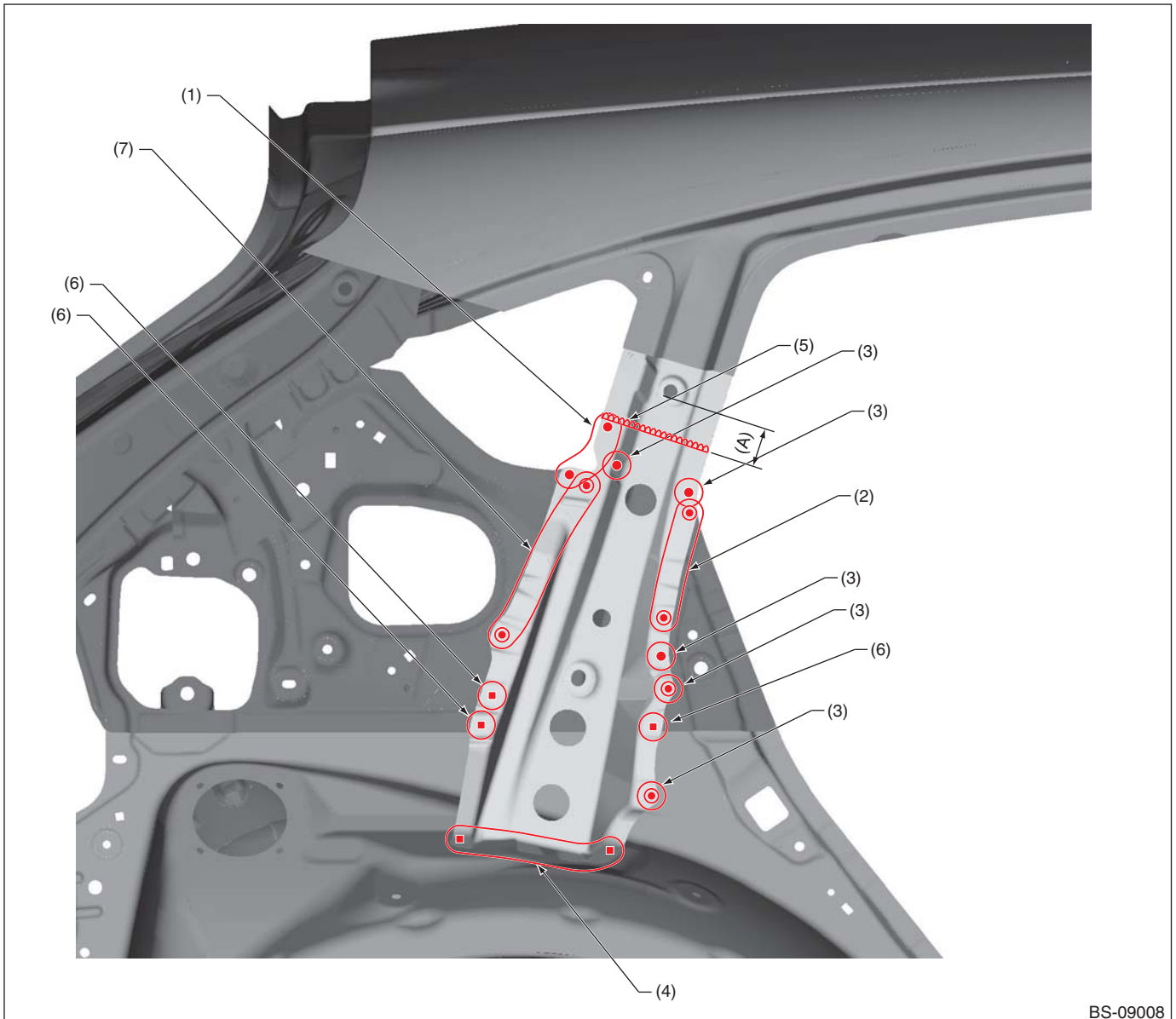
(5) 4 points (outside · 1)

(6) Cut position

Panel Replacement

B: INSTALLATION

• Overall view



BS-09008

(A) 40 mm [1.57 in]

(1) 2 points

(2) 3 points

(3) 1 point

(4) 4 points (service)

(5) 1 point (Continuous welding)

(6) 1 point (service)

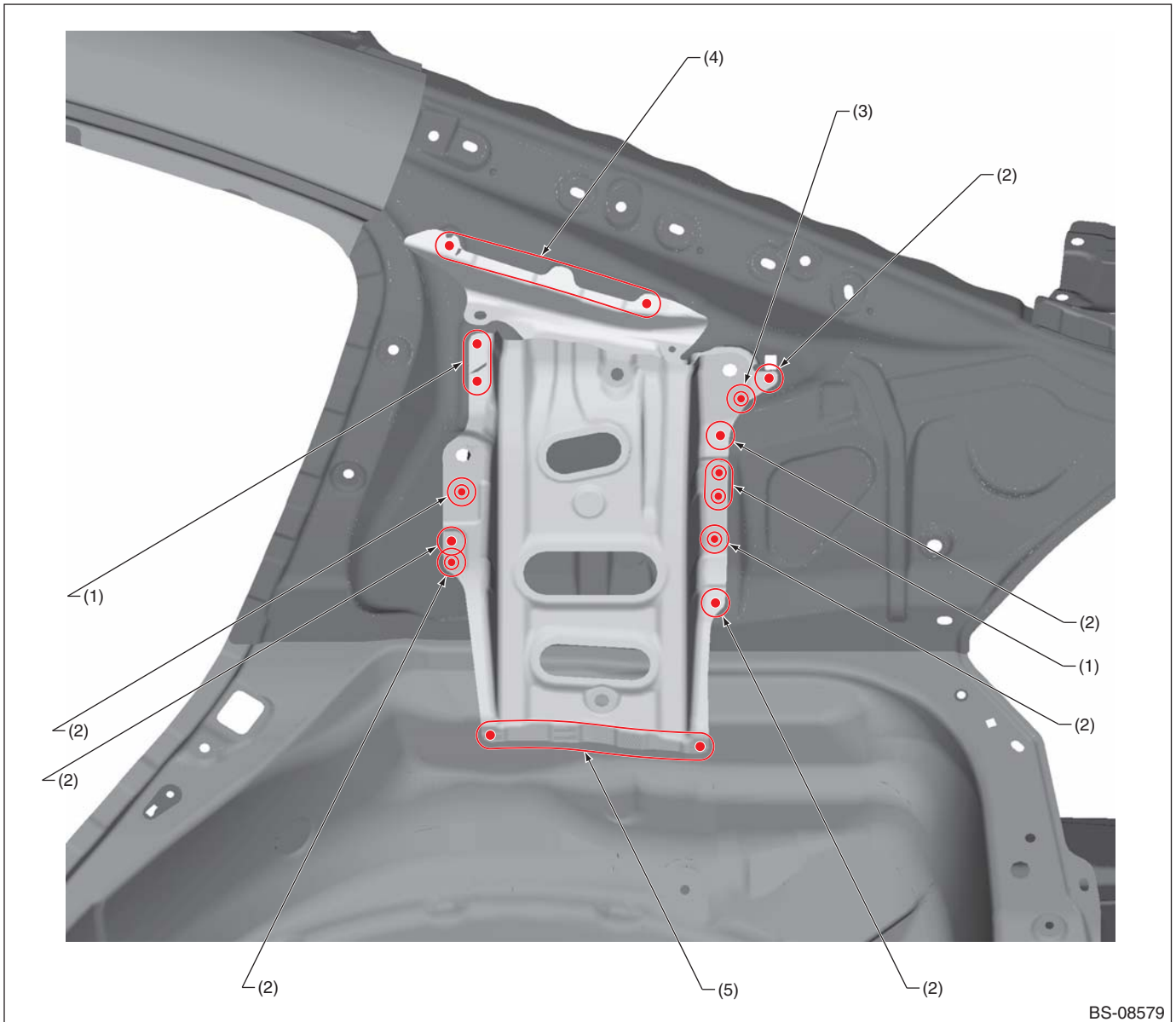
(7) 4 points

Panel Replacement

8-25. Rear Pillar Reinforcement Outer (Total replacement) / 4D

A: REMOVAL

• Overall view



(1) 2 points (outside · 1)

(2) 1 point (outside · 1)

(3) 1 point (outside · 2)

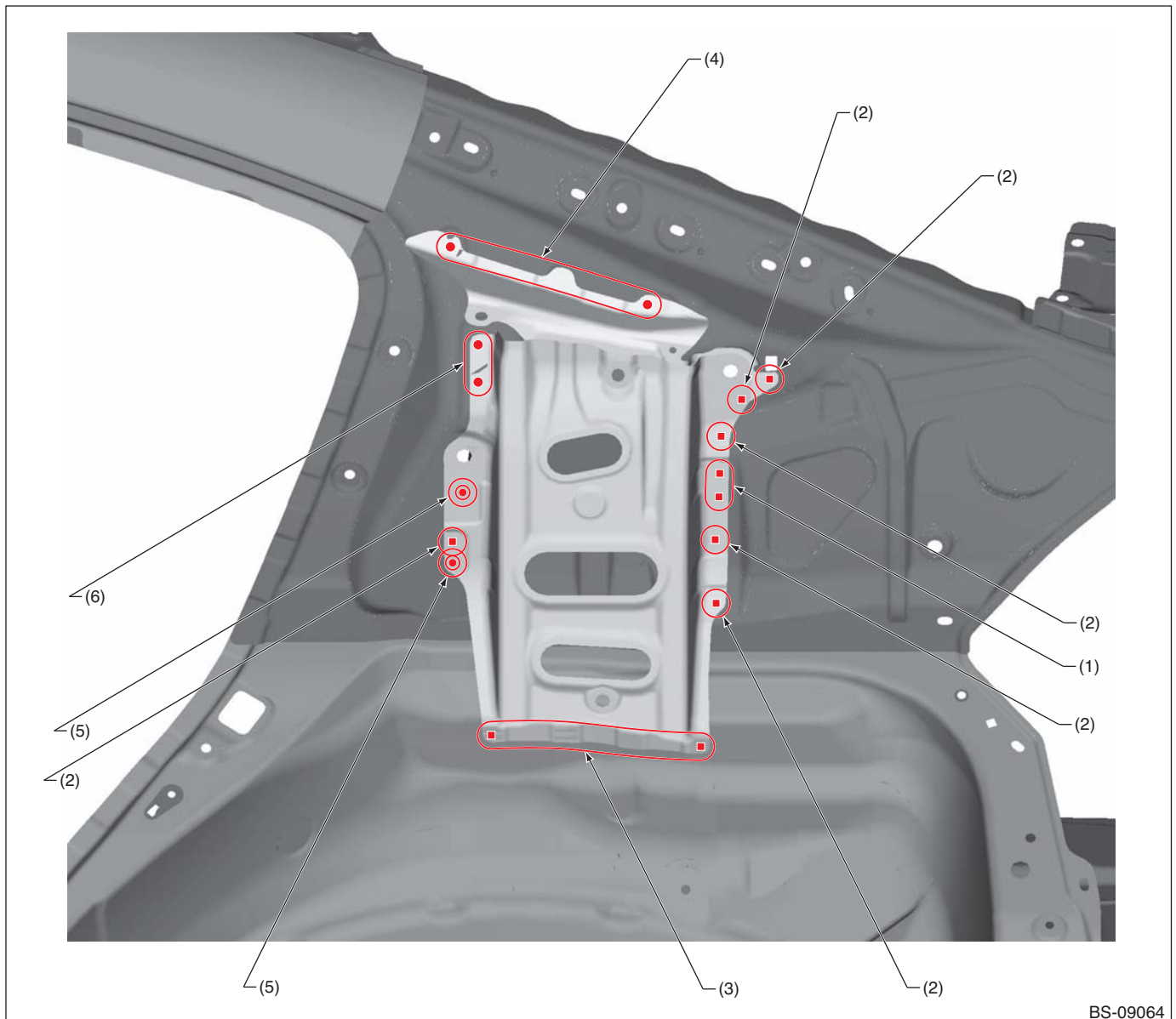
(4) 3 points (outside · 1)

(5) 4 points (top · 1)

Panel Replacement

B: INSTALLATION

• Overall view

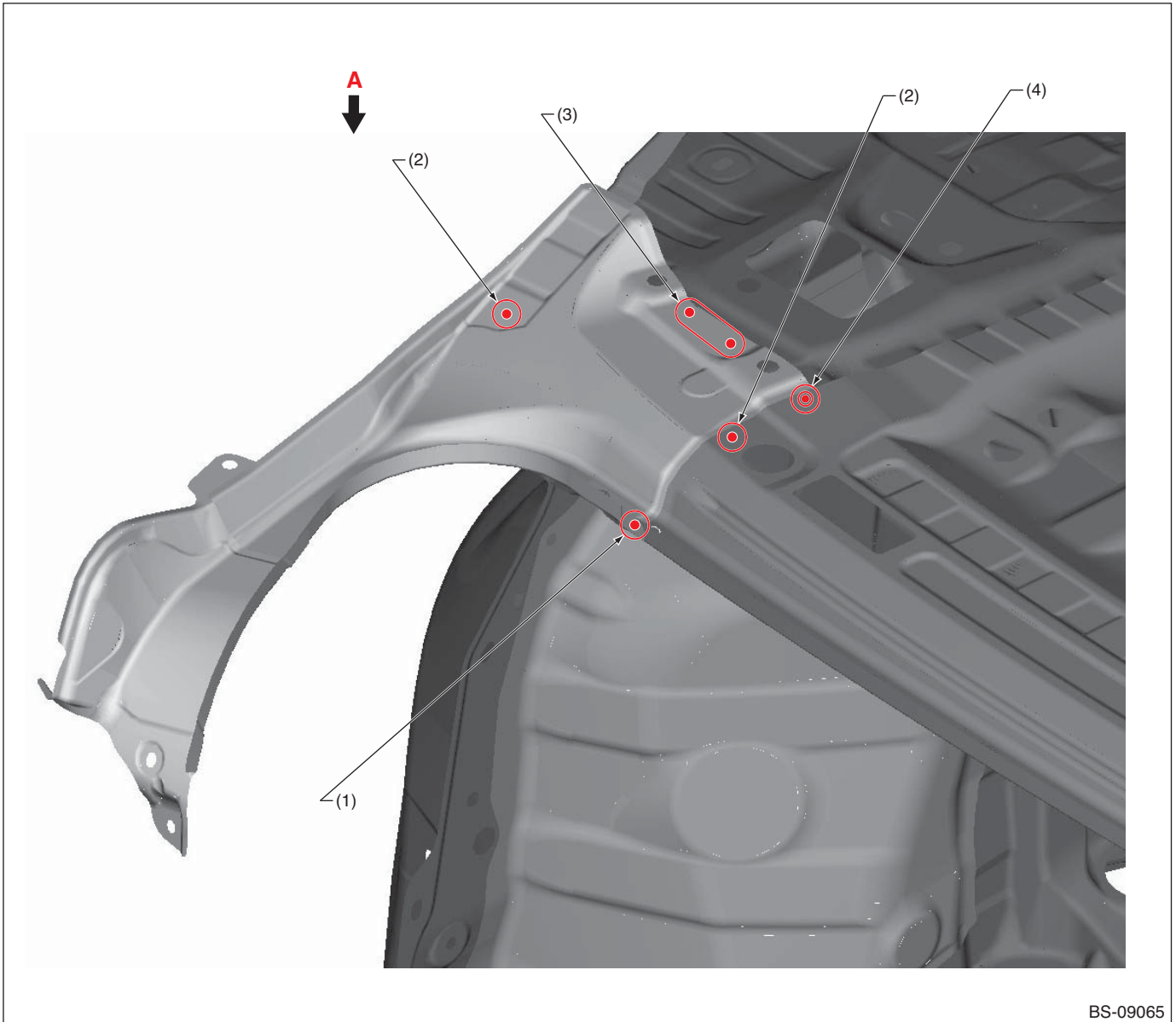


Panel Replacement

8-26. Patch Rear Pillar · Corner Patch (Total replacement) / 4D

A: REMOVAL

• Overall view



(1) 1 point (outside · 1)

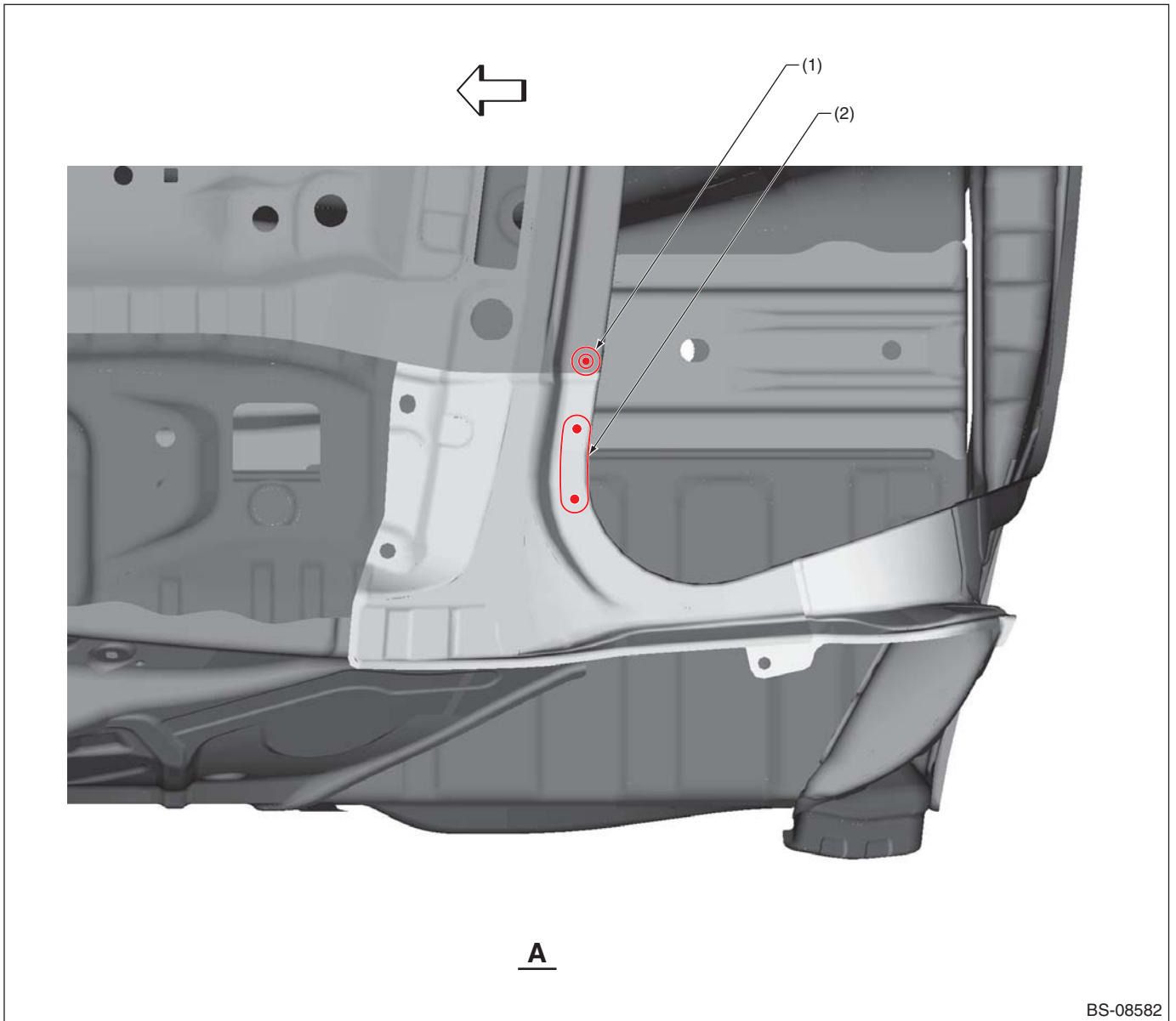
(2) 1 point (top · 1)

(3) 2 points (top · 1)

(4) 1 point (top · 2)

Panel Replacement

• View A



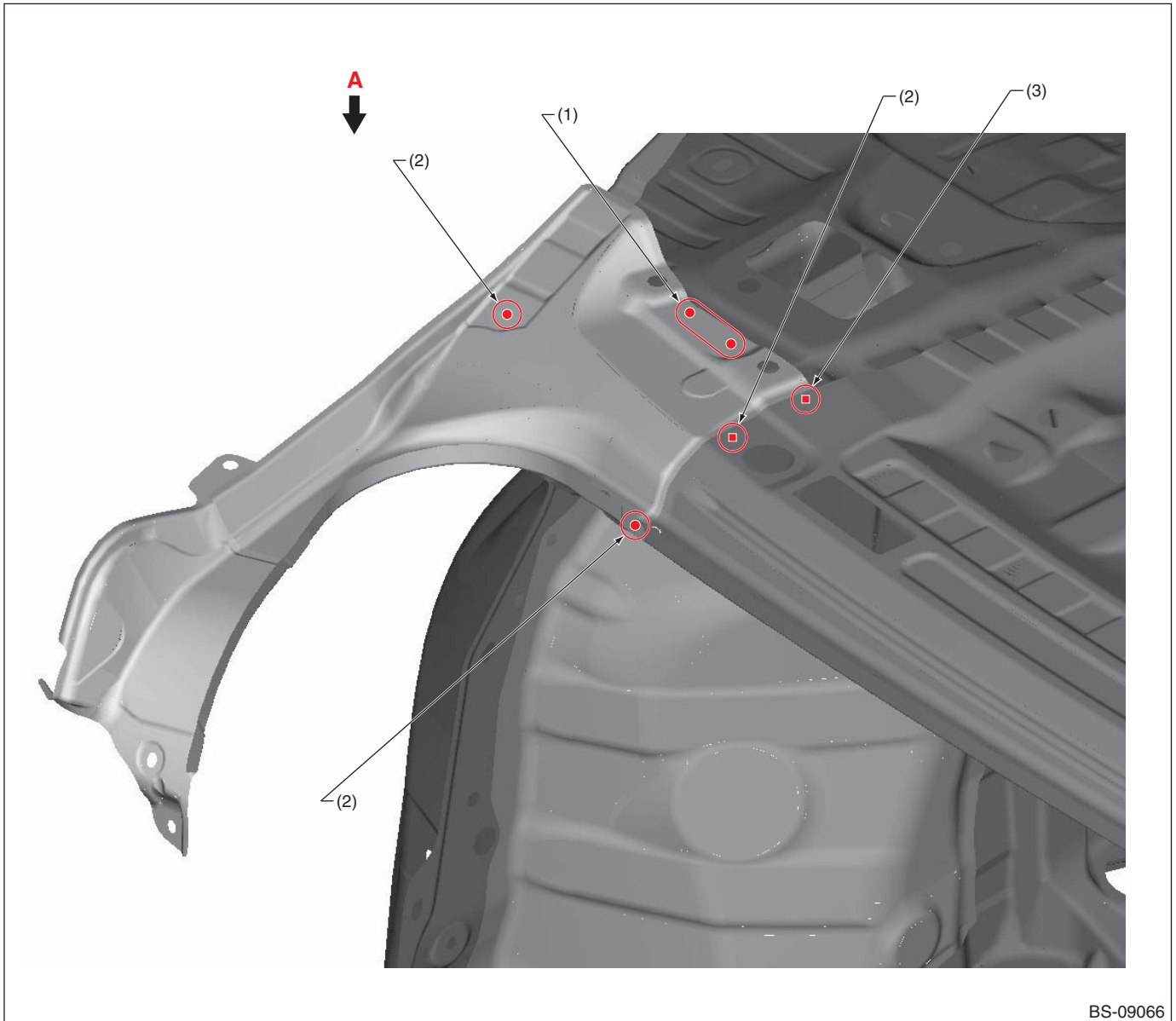
(1) 1 point (top · 2)

(2) 2 points (top · 1)

Panel Replacement

B: INSTALLATION

• Overall view



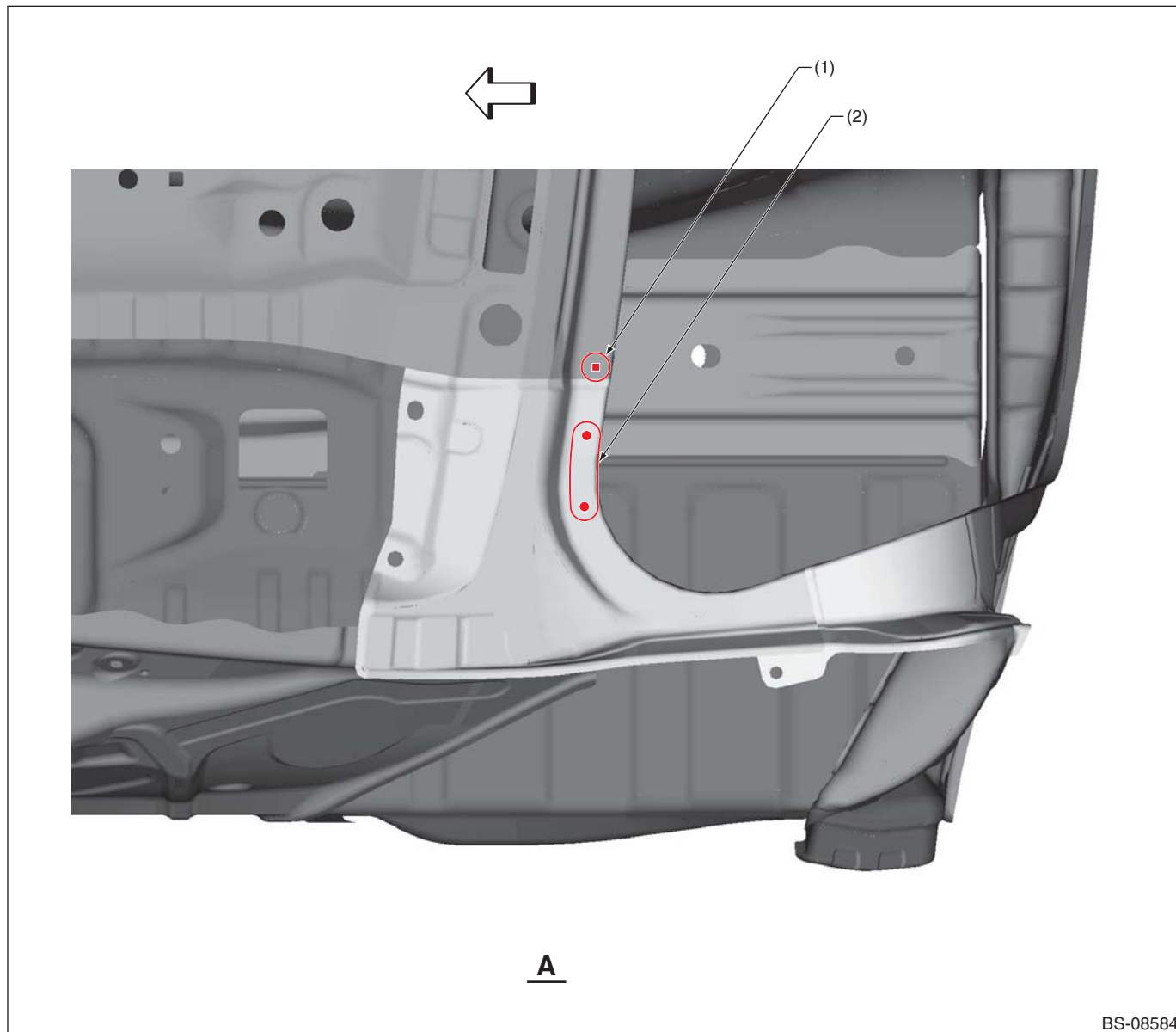
(1) 2 points

(2) 1 point

(3) 1 point (service · matching)

Panel Replacement

• View A



(1) 1 point (service · matching)

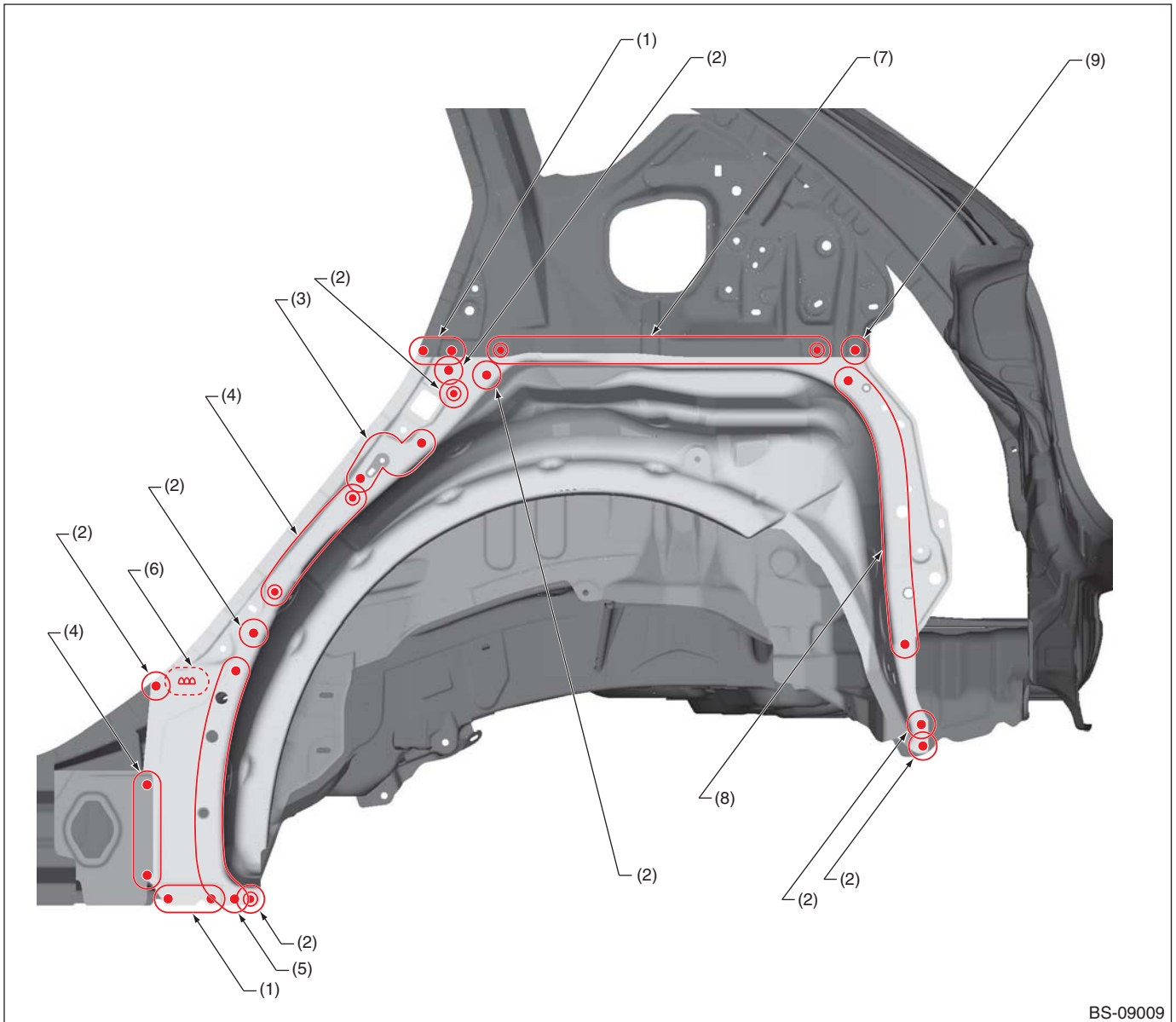
(2) 2 points

Panel Replacement

8-27. Arch Rear Inner LH (Total replacement) / 5D

A: REMOVAL

• Overall view



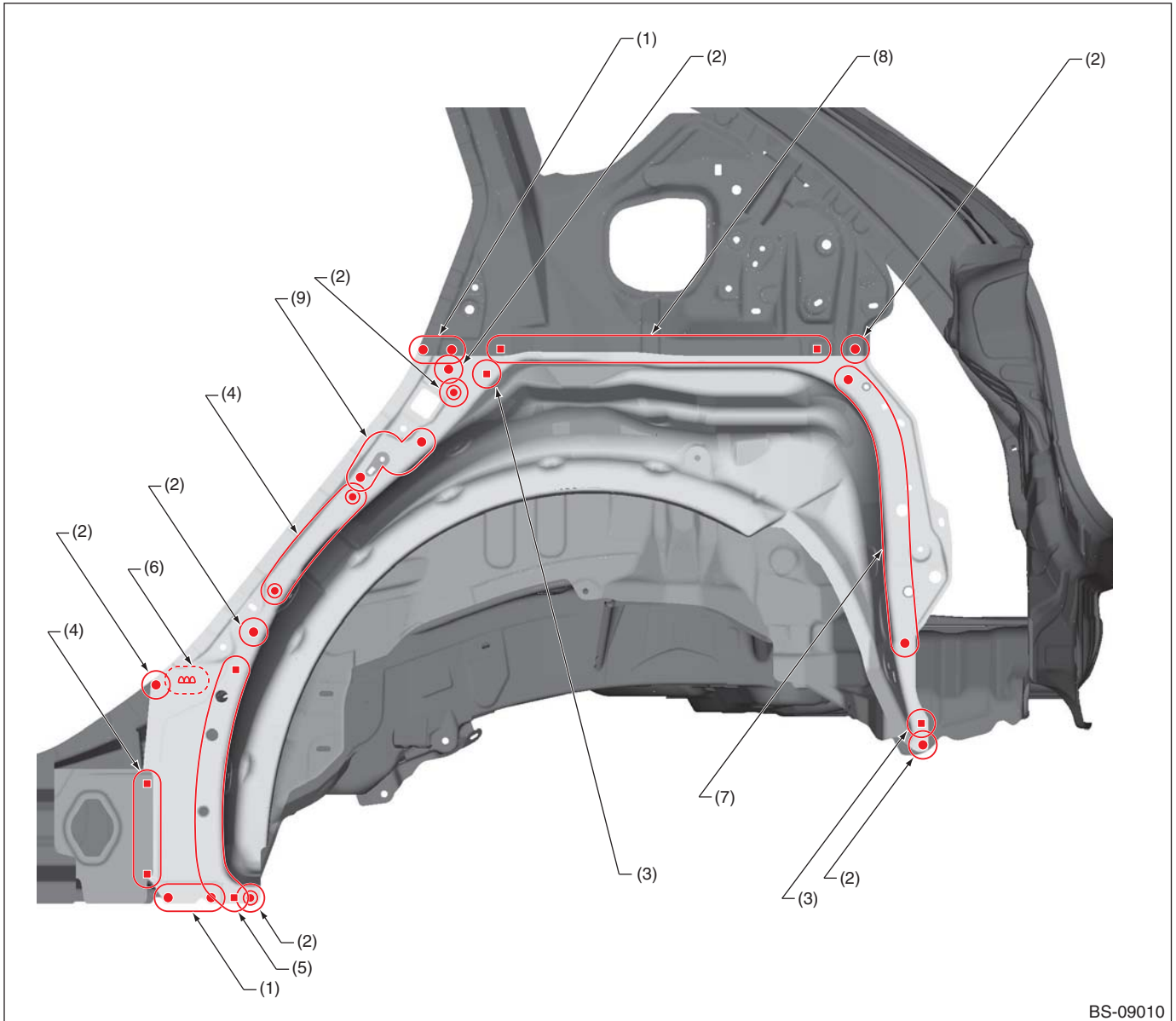
BS-09009

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

Panel Replacement

B: INSTALLATION

• Overall view

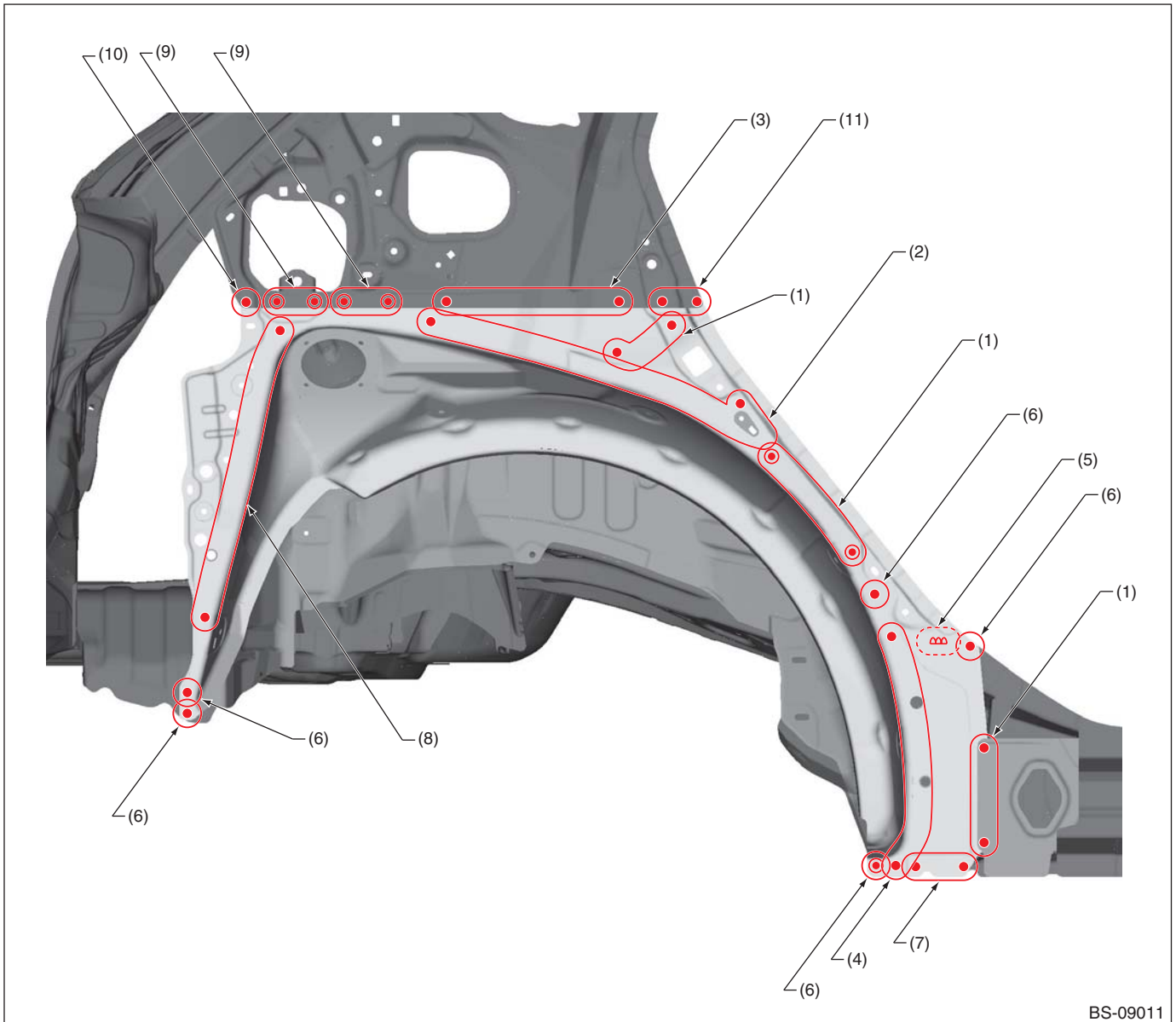


- | | | |
|-----------------------|---|-----------------------------------|
| (1) 2 points | (4) 3 points | (7) 7 points |
| (2) 1 point | (5) 6 points (service) | (8) 7 points (service · matching) |
| (3) 1 point (service) | (6) 1 point (Continuous welding)
[22 mm (0.87 in)] | (9) 4 points |

8-28. Arch Rear Inner RH (Total replacement) / 5D

A: REMOVAL

• Overall view



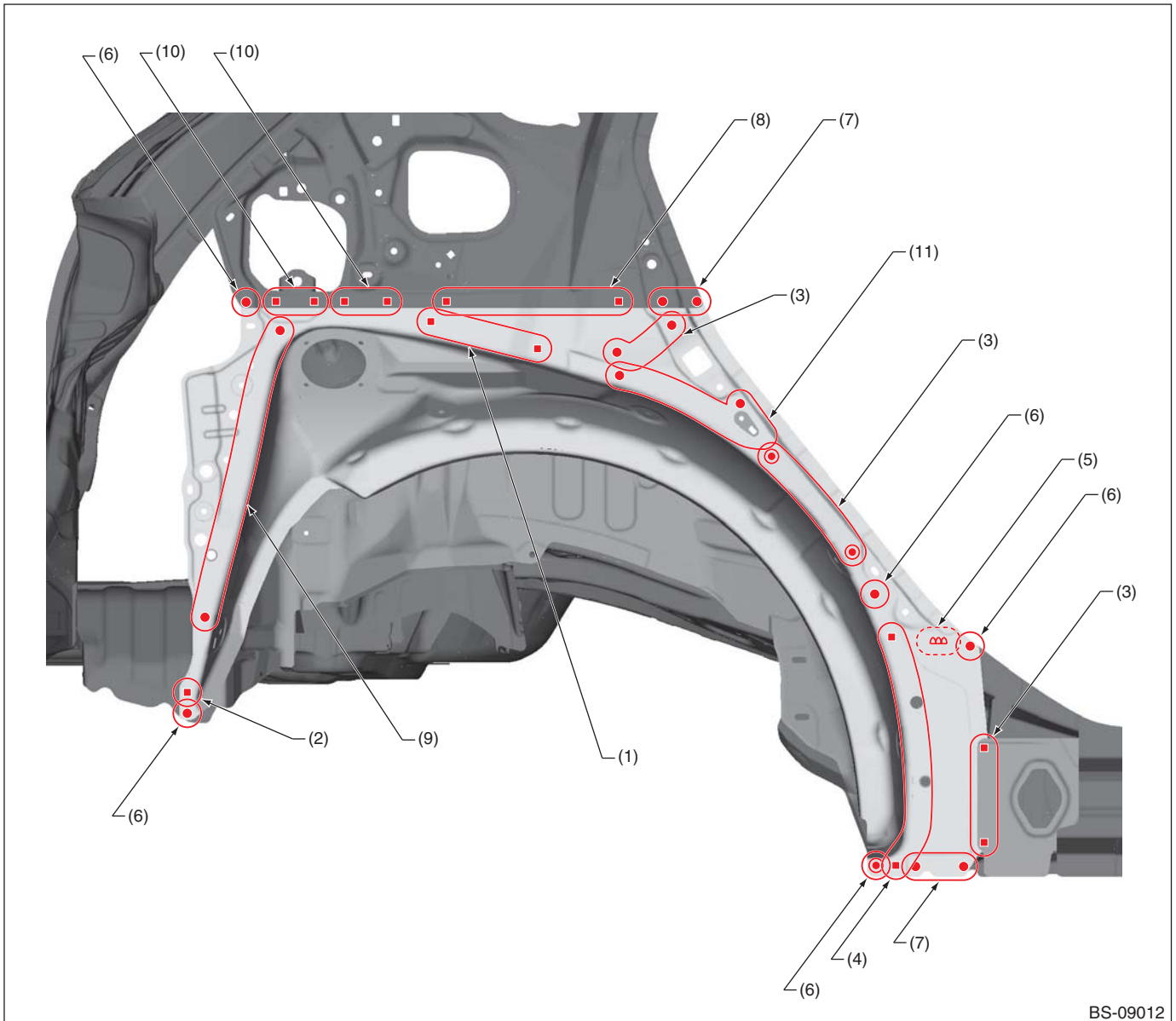
BS-09011

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

Panel Replacement

B: INSTALLATION

• Overall view

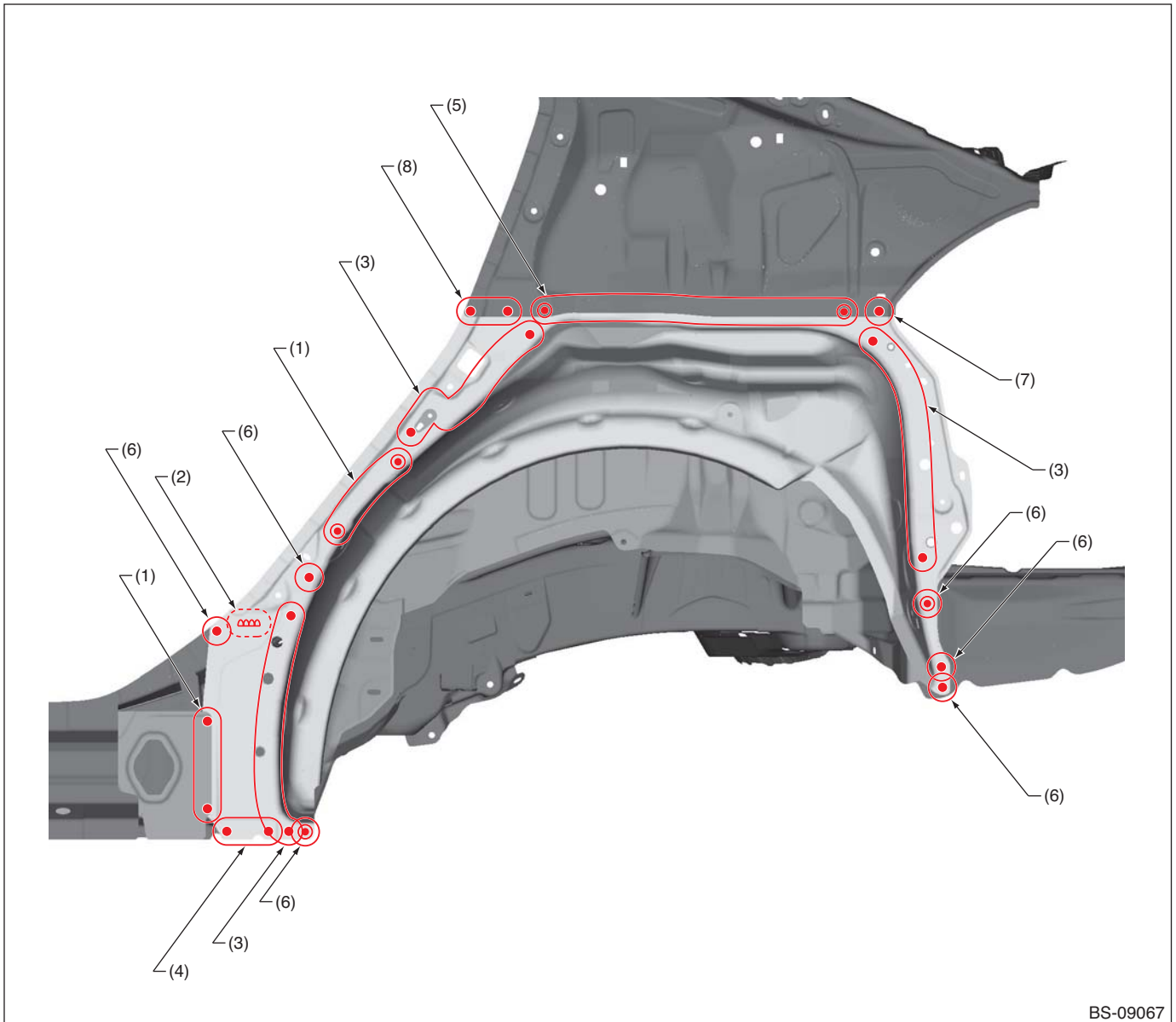


- | | | |
|------------------------|--|------------------------------------|
| (1) 3 points (service) | (5) 1 point (Continuous welding [22 mm (0.87 in)]) | (9) 7 points |
| (2) 1 point (service) | (6) 1 point | (10) 2 points (service - matching) |
| (3) 3 points | (7) 2 points | (11) 5 points |
| (4) 6 points (service) | (8) 4 points | |

8-29. Arch Rear Inner LH (Total replacement) / 4D

A: REMOVAL

• Overall view



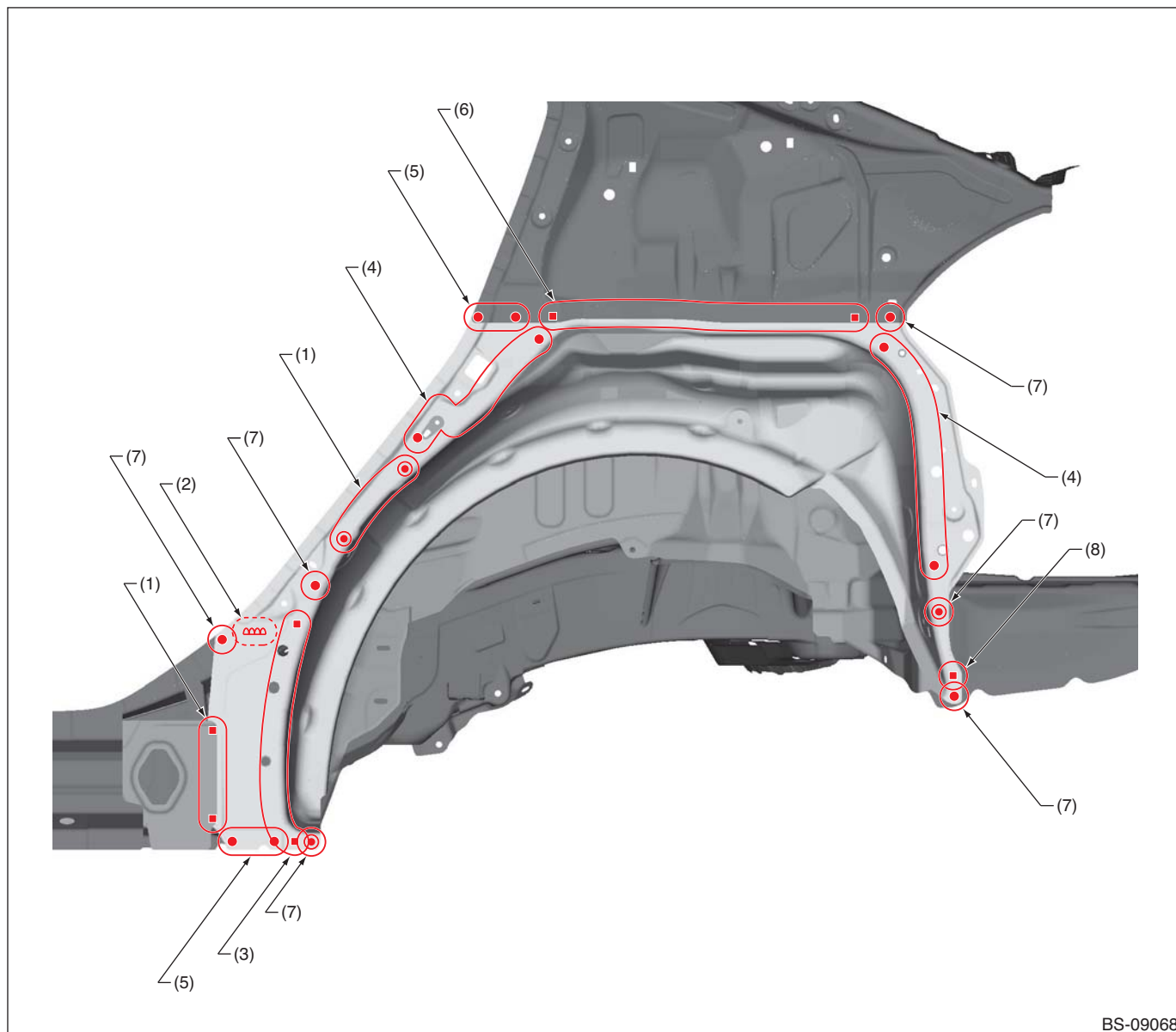
BS-09067

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

Panel Replacement

B: INSTALLATION

• Overall view



BS-09068

- (1) 3 points
- (2) 1 point (Continuous welding)
(30 mm [1.18 in])
- (3) 6 points (service)

- (4) 6 points
- (5) 2 points
- (6) 7 points (service · matching)

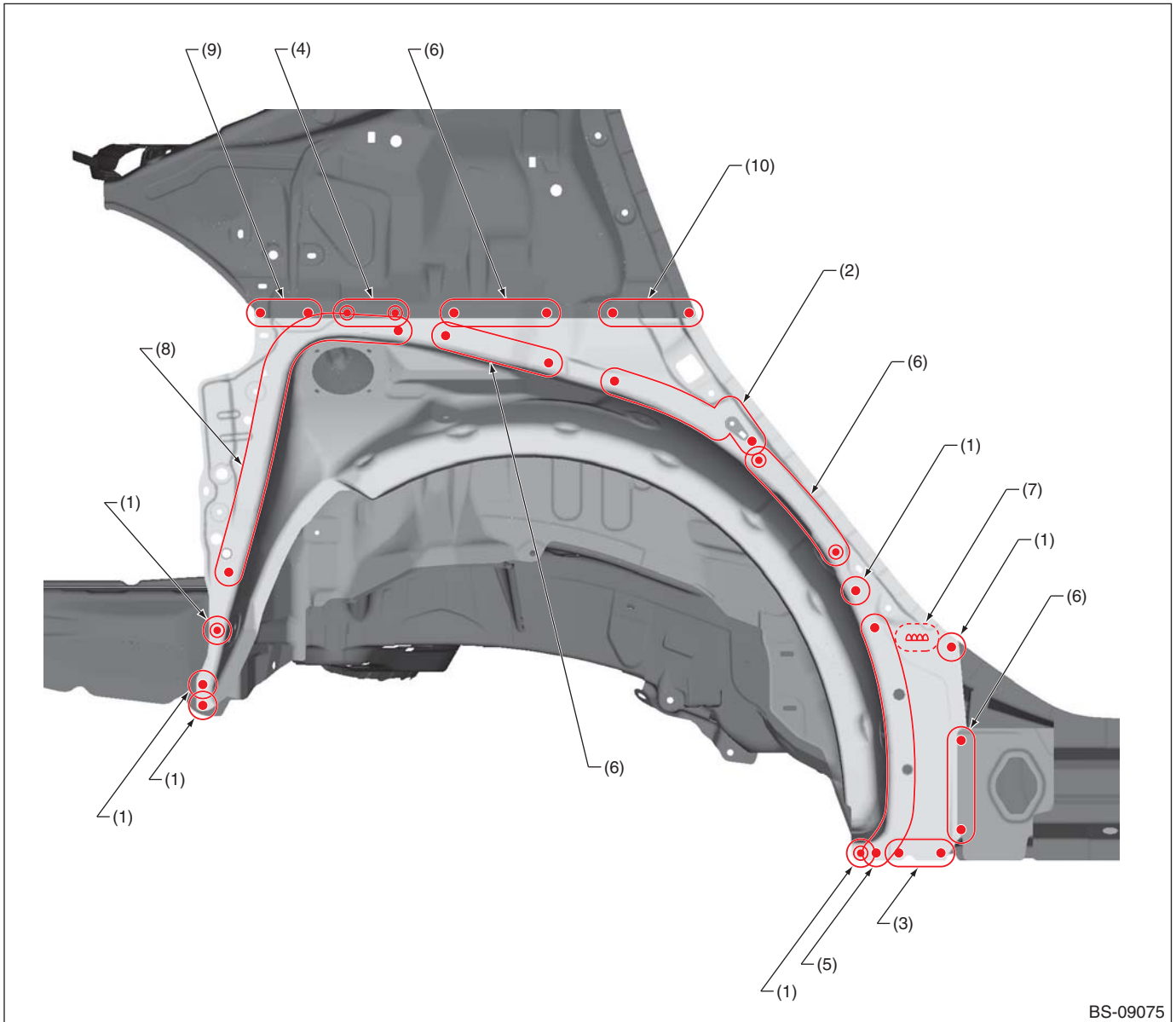
- (7) 1 point
- (8) 1 point (service)

Panel Replacement

8-30. Arch Rear Inner RH (Total replacement) / 4D

A: REMOVAL

• Overall view



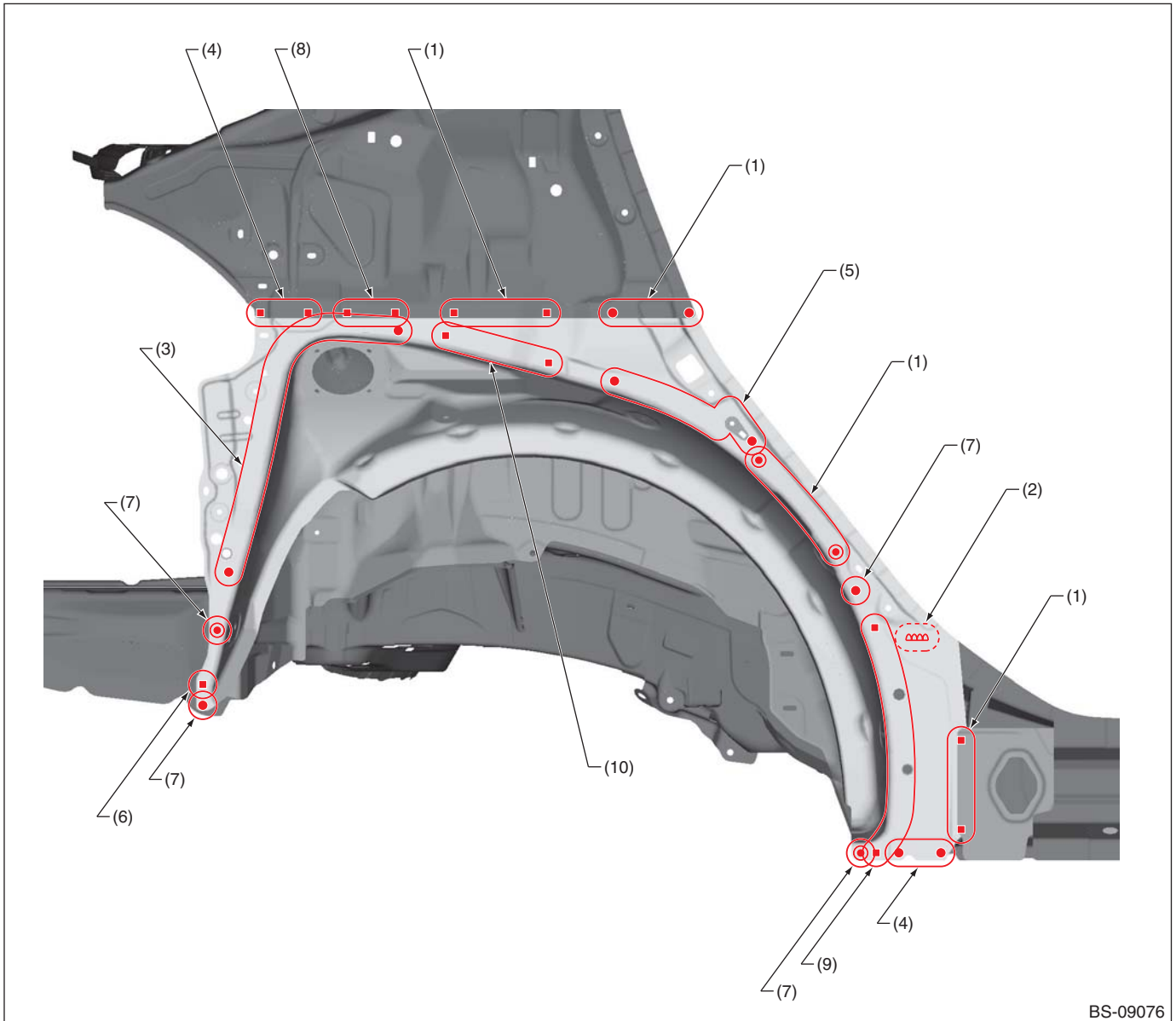
BS-09075

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

Panel Replacement

B: INSTALLATION

• Overall view



BS-09076

- (1) 3 points
- (2) 1 point (Continuous welding)
(30 mm [1.18 in])
- (3) 8 points
- (4) 2 points

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

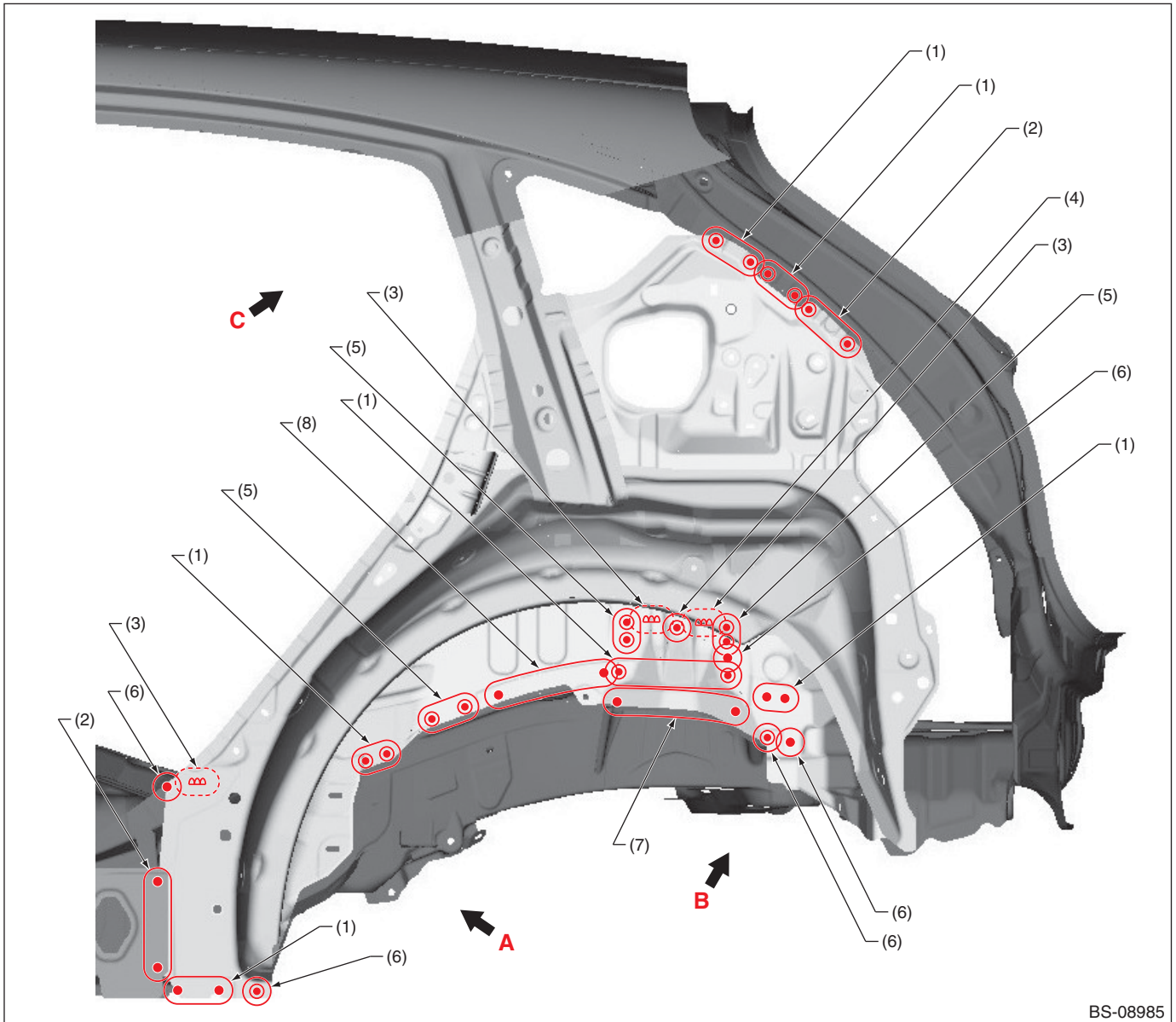
- (9) 6 points (service)
- (10) 3 points (service)

Panel Replacement

8-31. Rear Quarter Inner LH (Total replacement) / 5D

A: REMOVAL

• Overall view

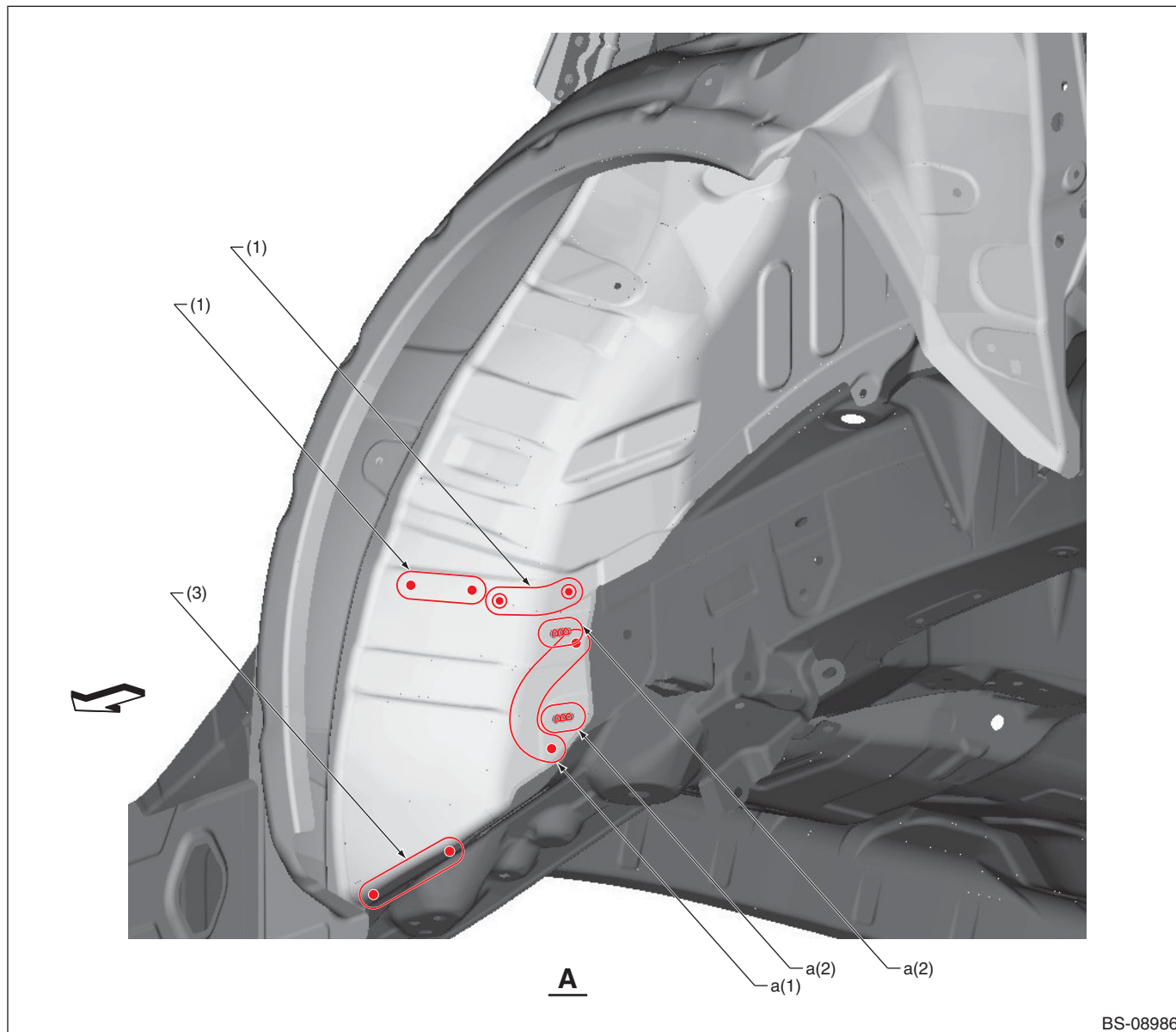


BS-08985

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

Panel Replacement

• View A



BS-08986

(1) 2 points (outside · 1)

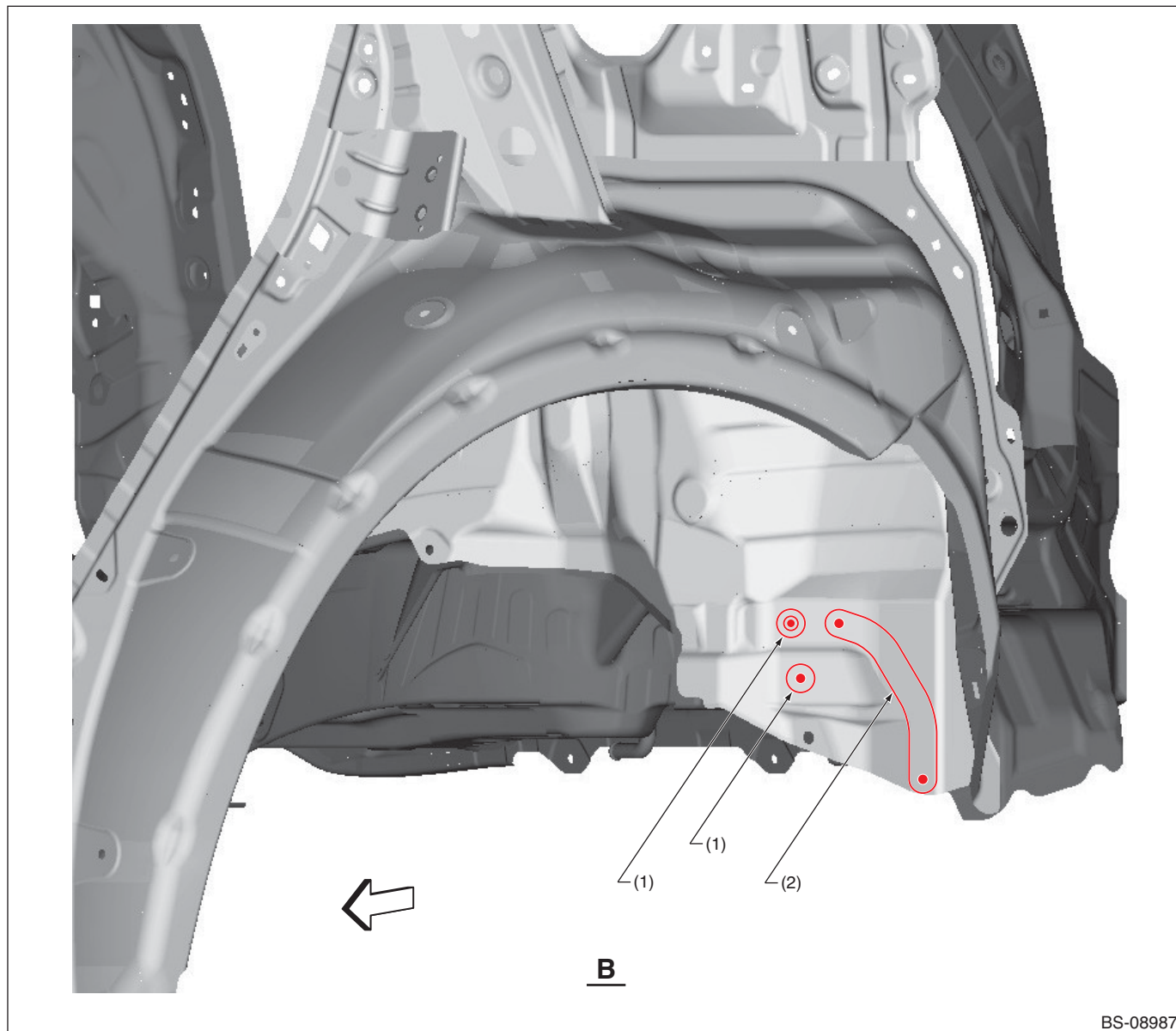
(2) 1 point (outside · 1, belt sander)

(3) 2 points (top · 1)

Note: Welding points in part "a" vary depending on each vehicle model (spot or arc welding).

Panel Replacement

• View B

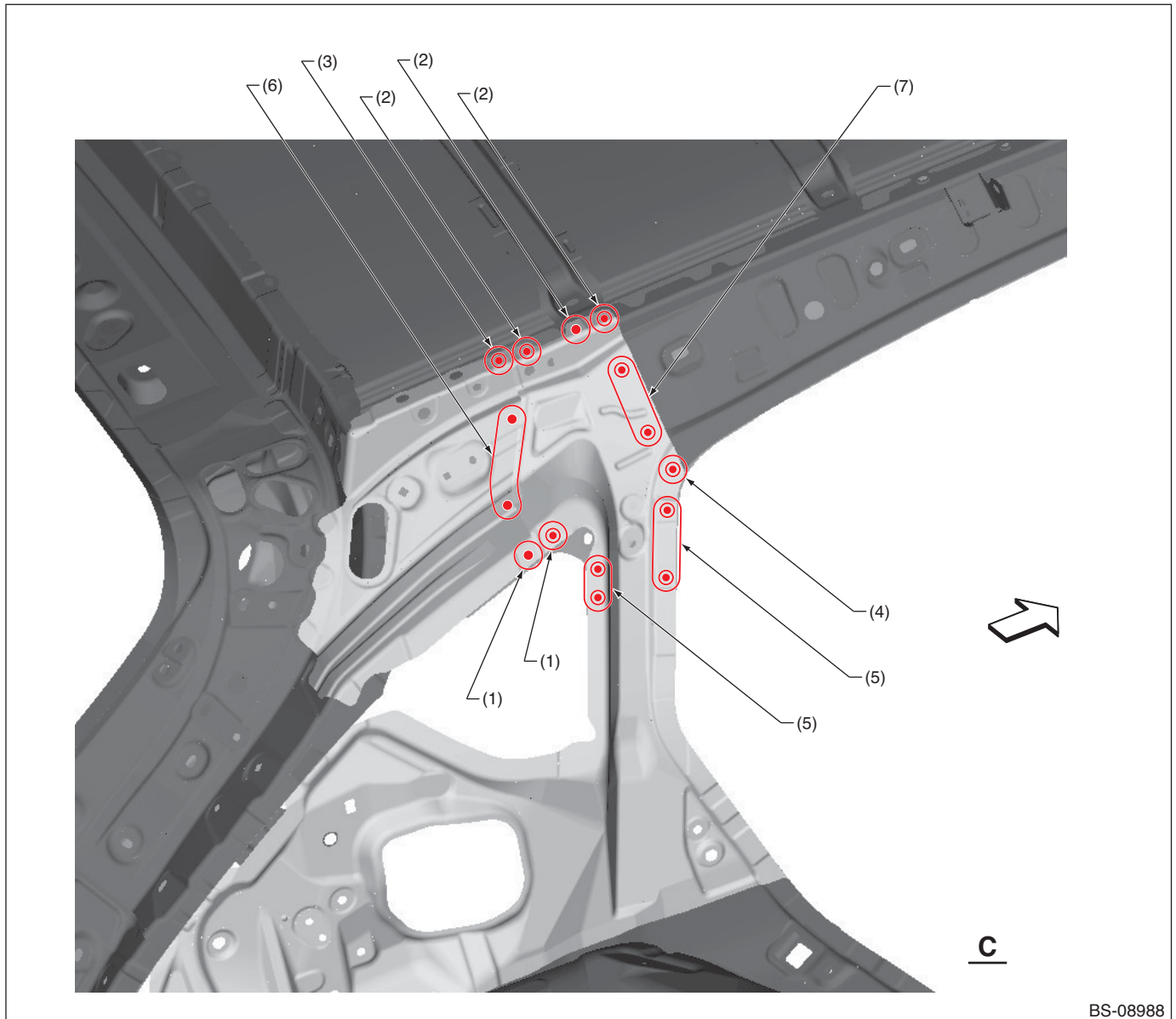


(1) 1 point (outside · 1)

(2) 5 points (outside · 1)

Panel Replacement

• View C



BS-08988

- (1) 1 point (inside · 1)
- (2) 1 point (bottom · 1)
- (3) 1 point (bottom · 2)

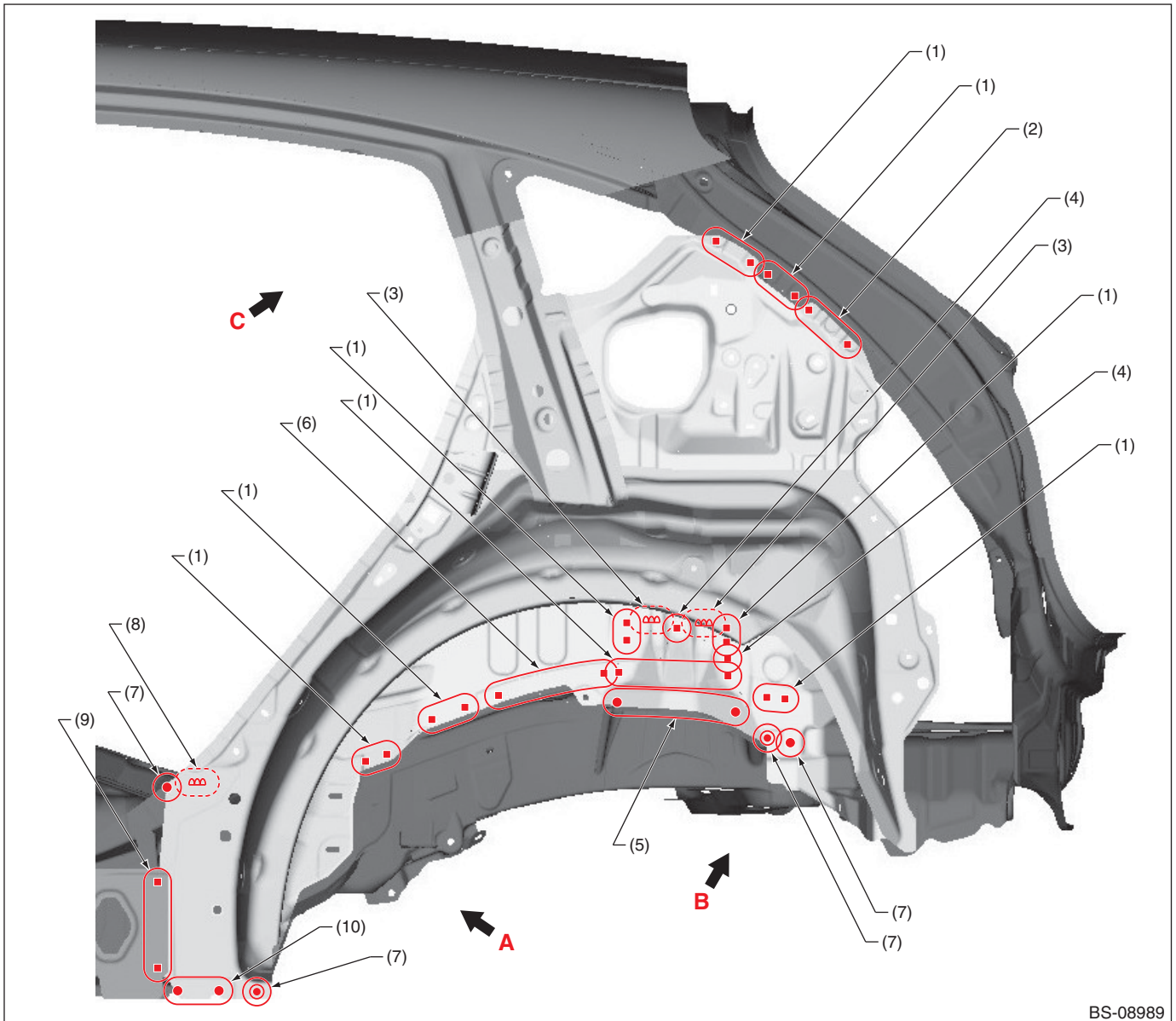
- (4) 1 point (inside · 2)
- (5) 2 points (inside · 2)
- (6) 3 points (inside · 1)

- (7) 3 points (inside · 2)

Panel Replacement

B: INSTALLATION

• Overall view

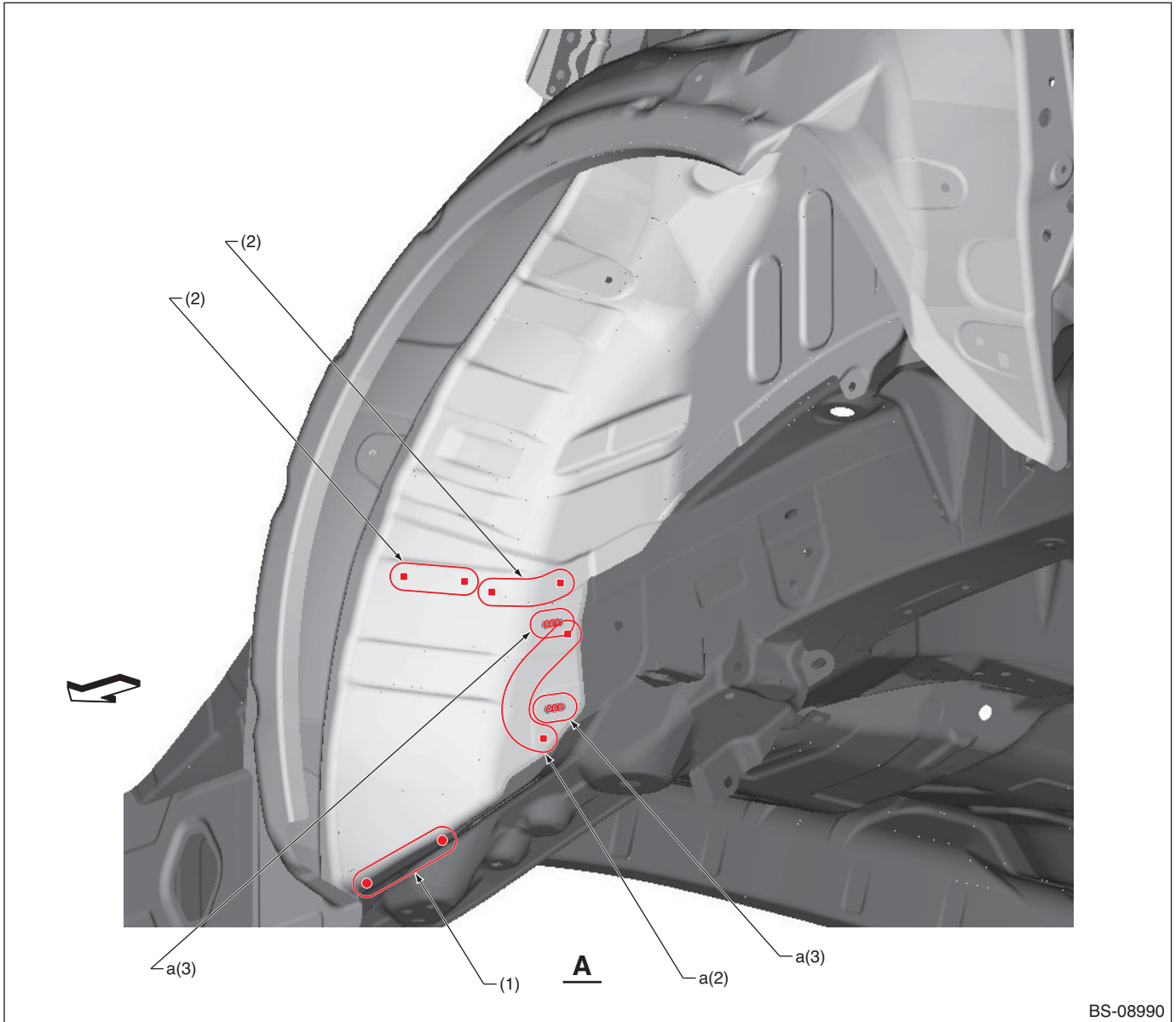


BS-08989

- | | | |
|---|---|---------------|
| (1) 2 points (service) | (5) 5 points | (9) 3 points |
| (2) 3 points (service) | (6) 4 points (service) | (10) 2 points |
| (3) 1 point (Continuous welding)
(5 mm [0.2 in]) | (7) 1 point | |
| (4) 1 point (service) | (8) 1 point (Continuous welding)
(30 mm [1.18 in]) | |

Panel Replacement

• View A



(1) 2 points

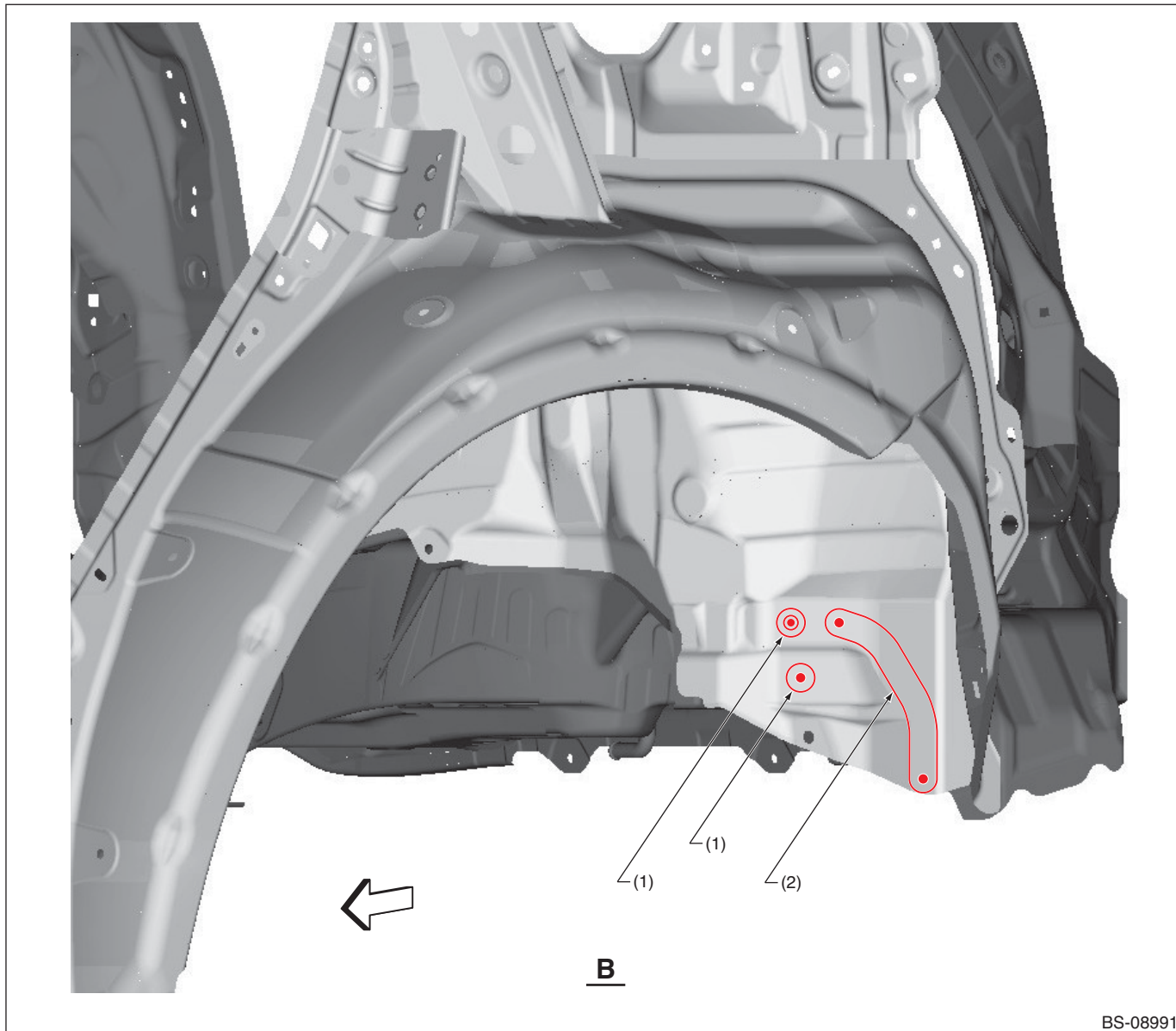
(2) 2 points (service)

(3) 1 point (Continuous welding)
(5 mm [0.2 in])

Note: Welding points in part "a" vary depending on each vehicle model (spot or arc welding).

Panel Replacement

• View B



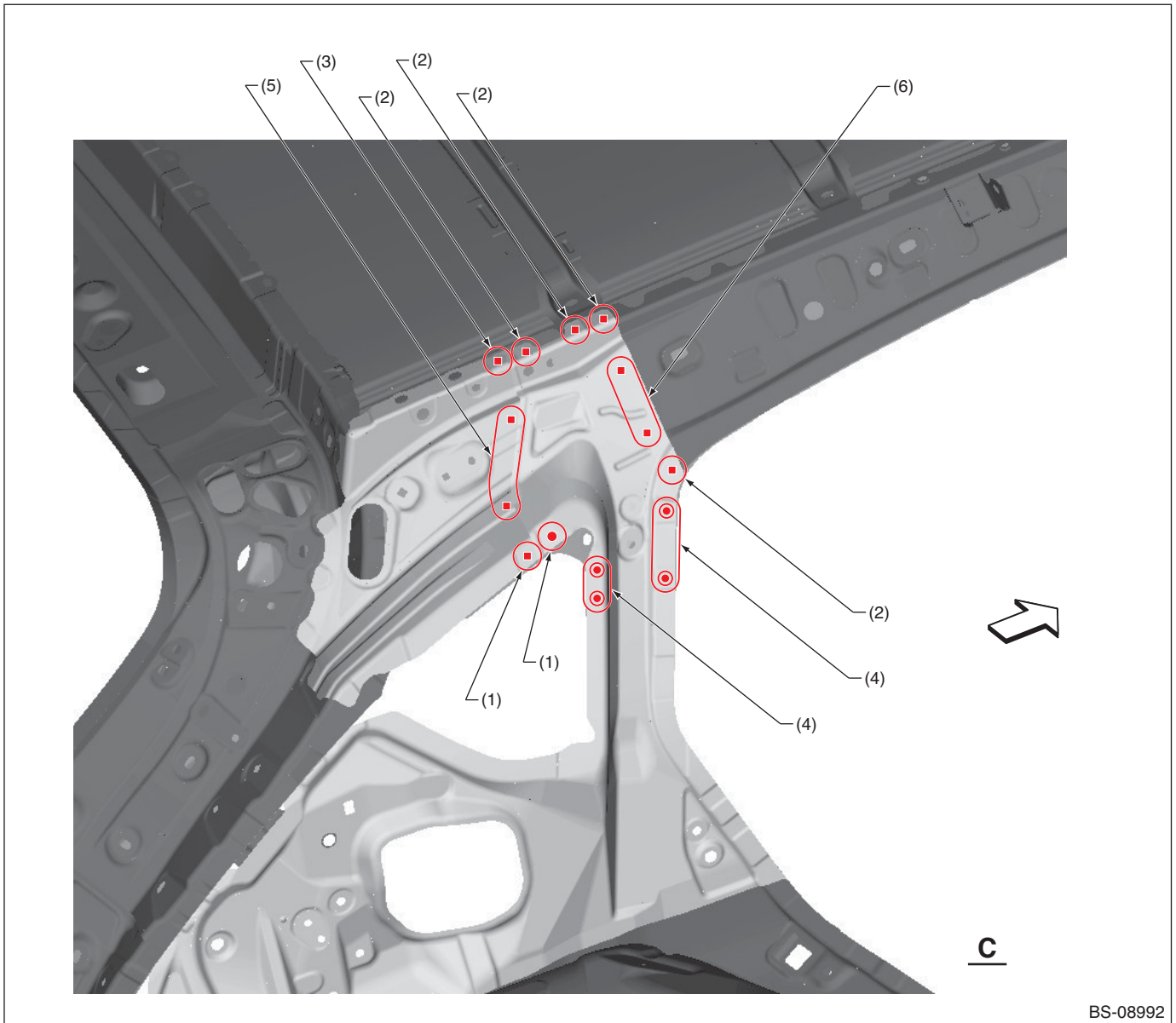
BS-08991

(1) 1 point

(2) 5 points

Panel Replacement

• View C



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

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

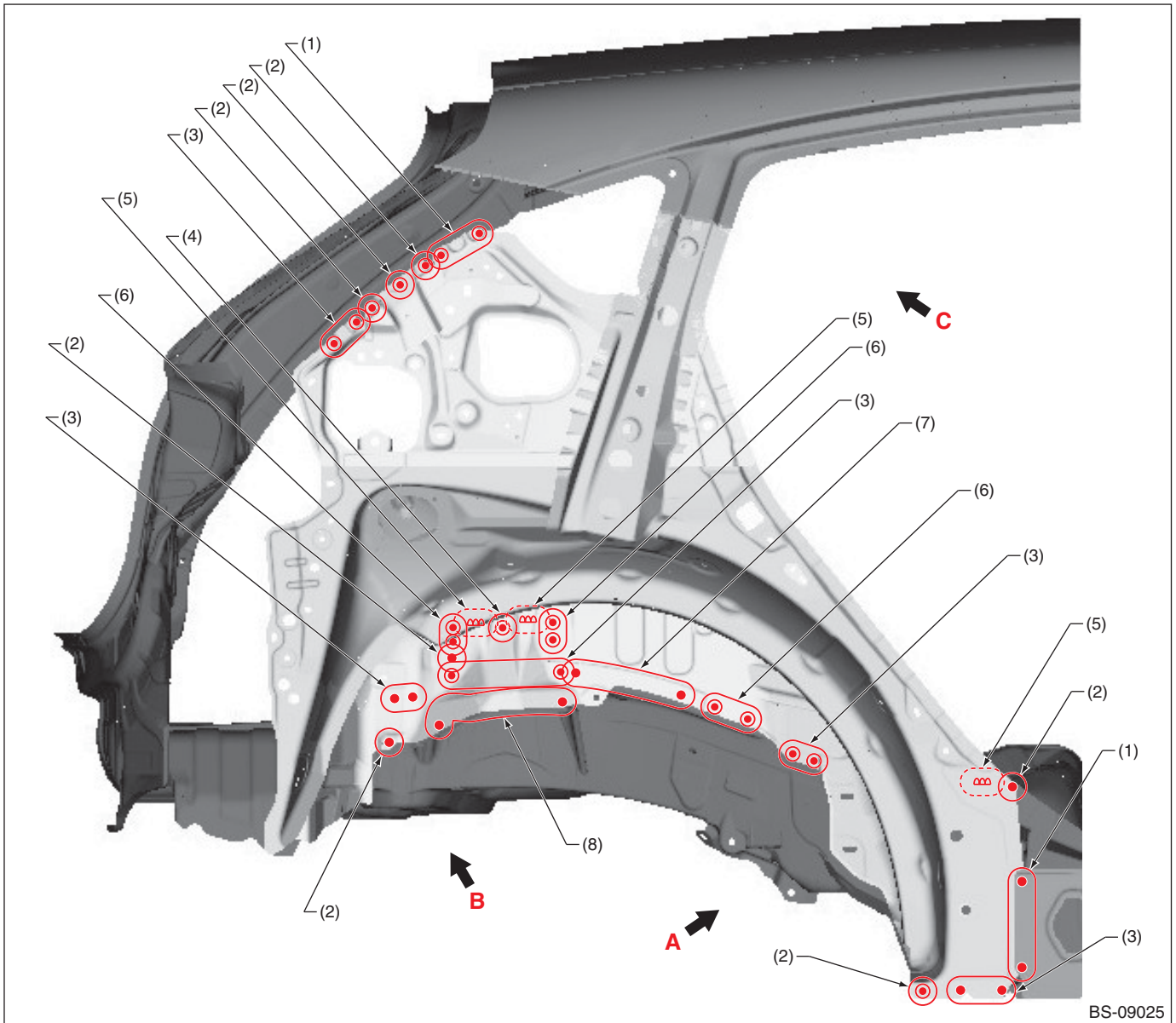
(5) 3 points
(6) 3 points (service)

Panel Replacement

8-32. Rear Quarter Inner RH (Total replacement) / 5D

A: REMOVAL

• Overall view



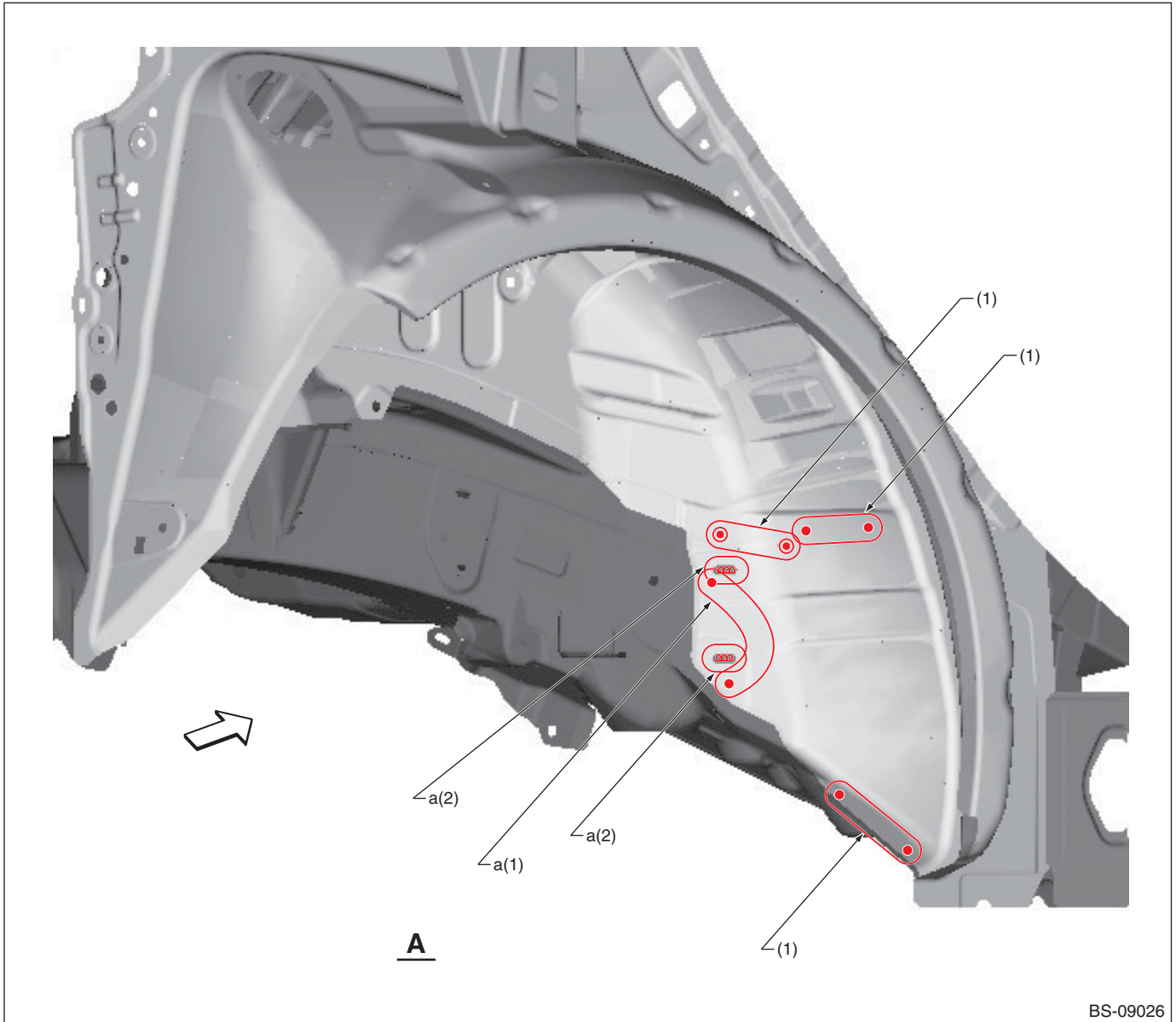
- (1) 3 points (outside · 1)
- (2) 1 point (outside · 1)
- (3) 2 points (outside · 1)

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

- (7) 4 points (outside · 1)
- (8) 6 points (outside · 1)

Panel Replacement

• View A



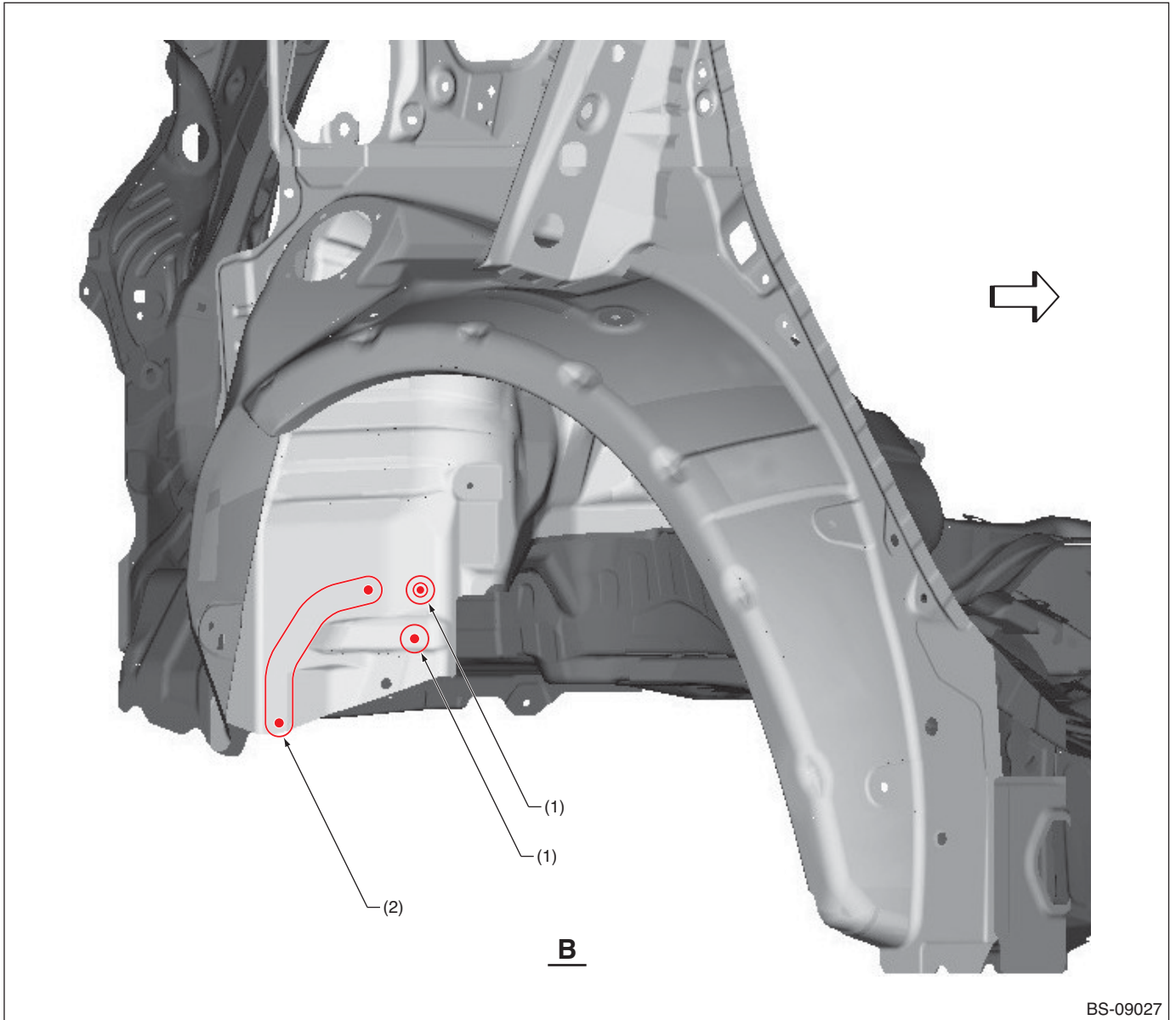
(1) 2 points (outside · 1)

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

Note: Welding points in part "a" vary depending on each vehicle model (spot or arc welding).

Panel Replacement

• View B

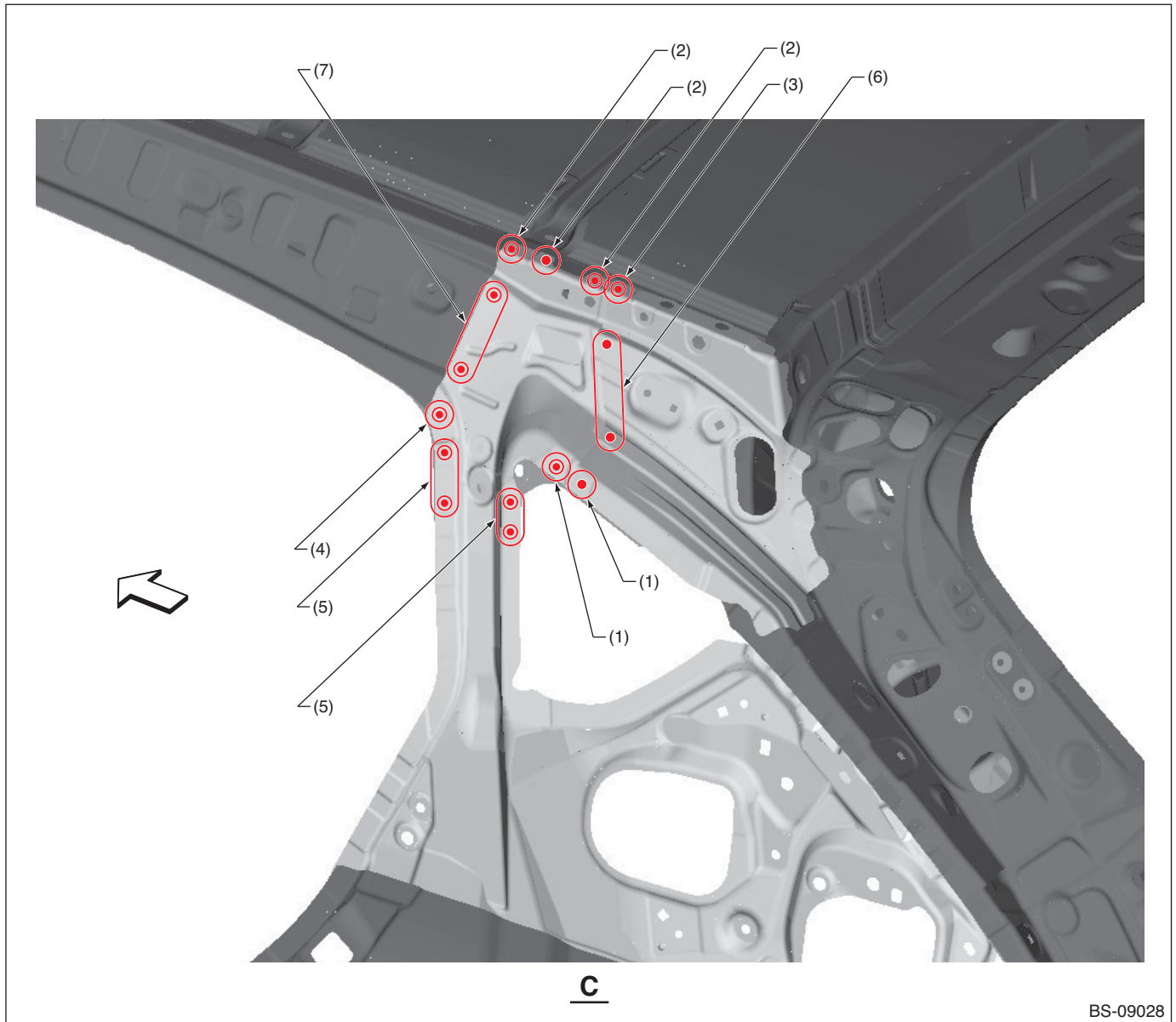


(1) 1 point (outside · 1)

(2) 5 points (outside · 1)

Panel Replacement

• View C



- (1) 1 point (inside · 1)
- (2) 1 point (bottom · 1)
- (3) 1 point (bottom · 2)

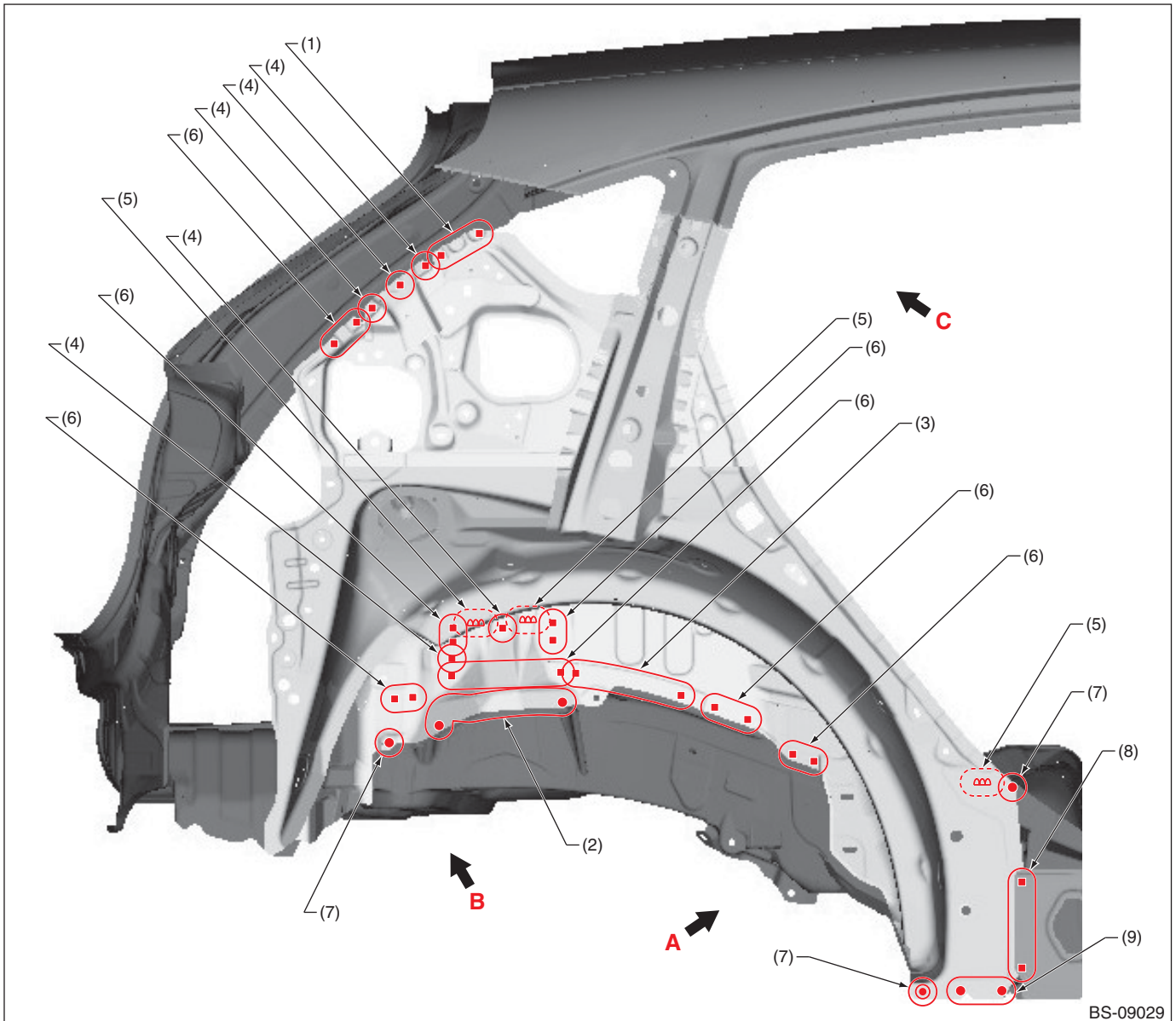
- (4) 1 point (inside · 2)
- (5) 2 points (inside · 2)
- (6) 3 points (inside · 1)

- (7) 3 points (inside · 2)

Panel Replacement

B: INSTALLATION

• Overall view



BS-09029

(1) 3 points (service)

(2) 6 points

(3) 4 points (service)

(4) 1 point (service)

(5) 1 point (Continuous welding)
(5 mm [0.2 in])

(6) 2 points (service)

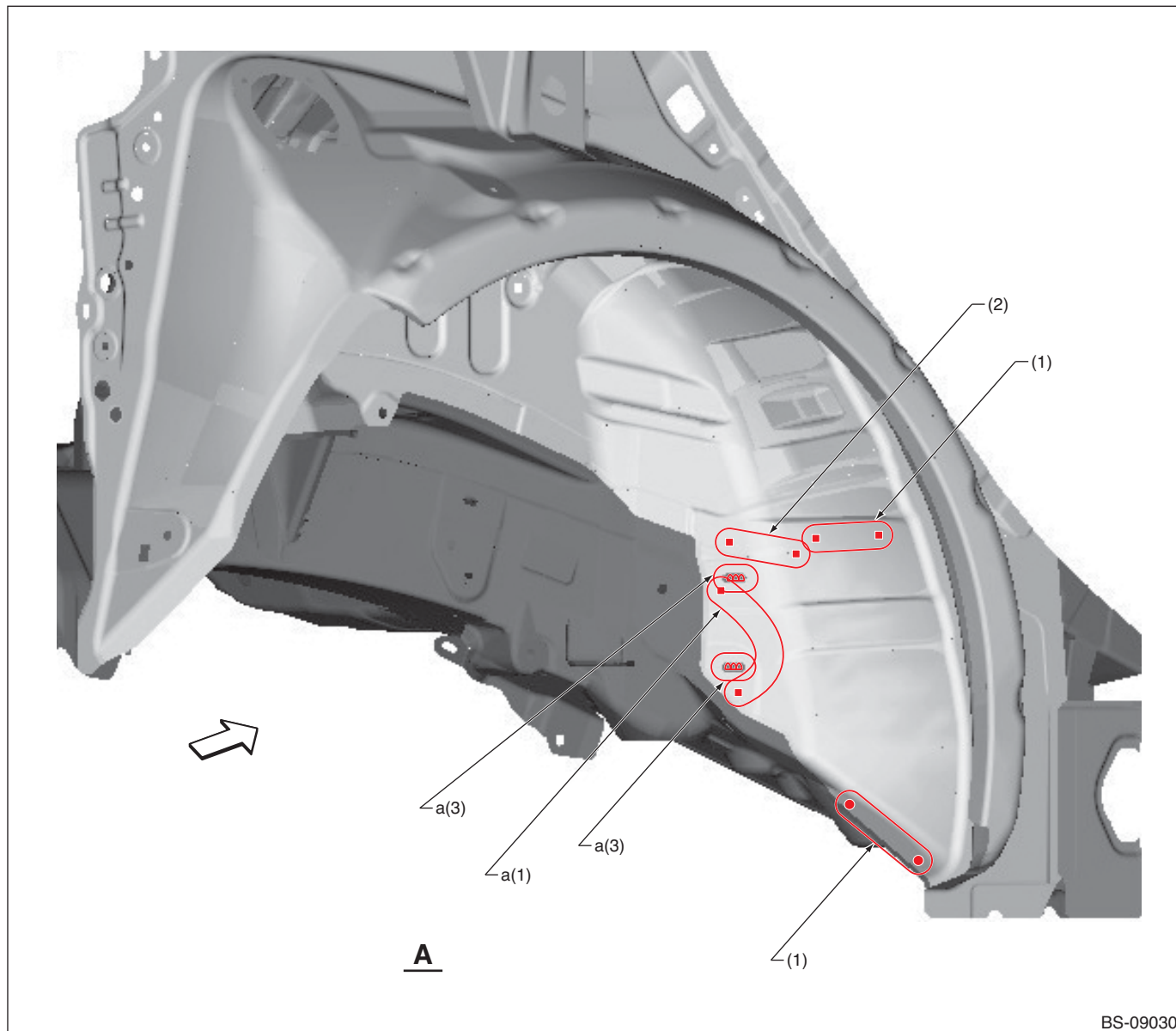
(7) 1 point

(8) 3 points

(9) 2 points

Panel Replacement

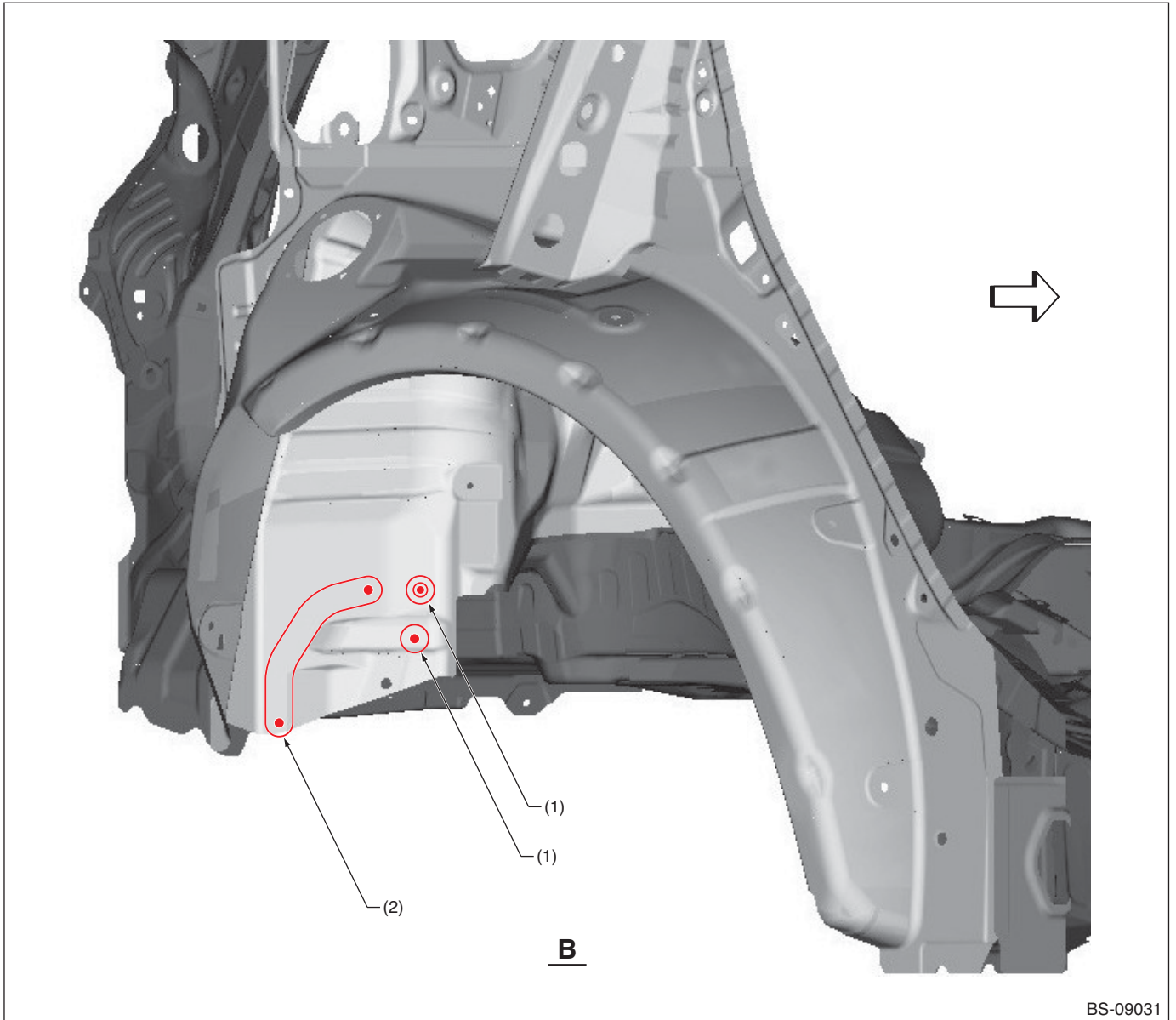
• View A



Note: Welding points in part "a" vary depending on each vehicle model (spot or arc welding).

Panel Replacement

• View B

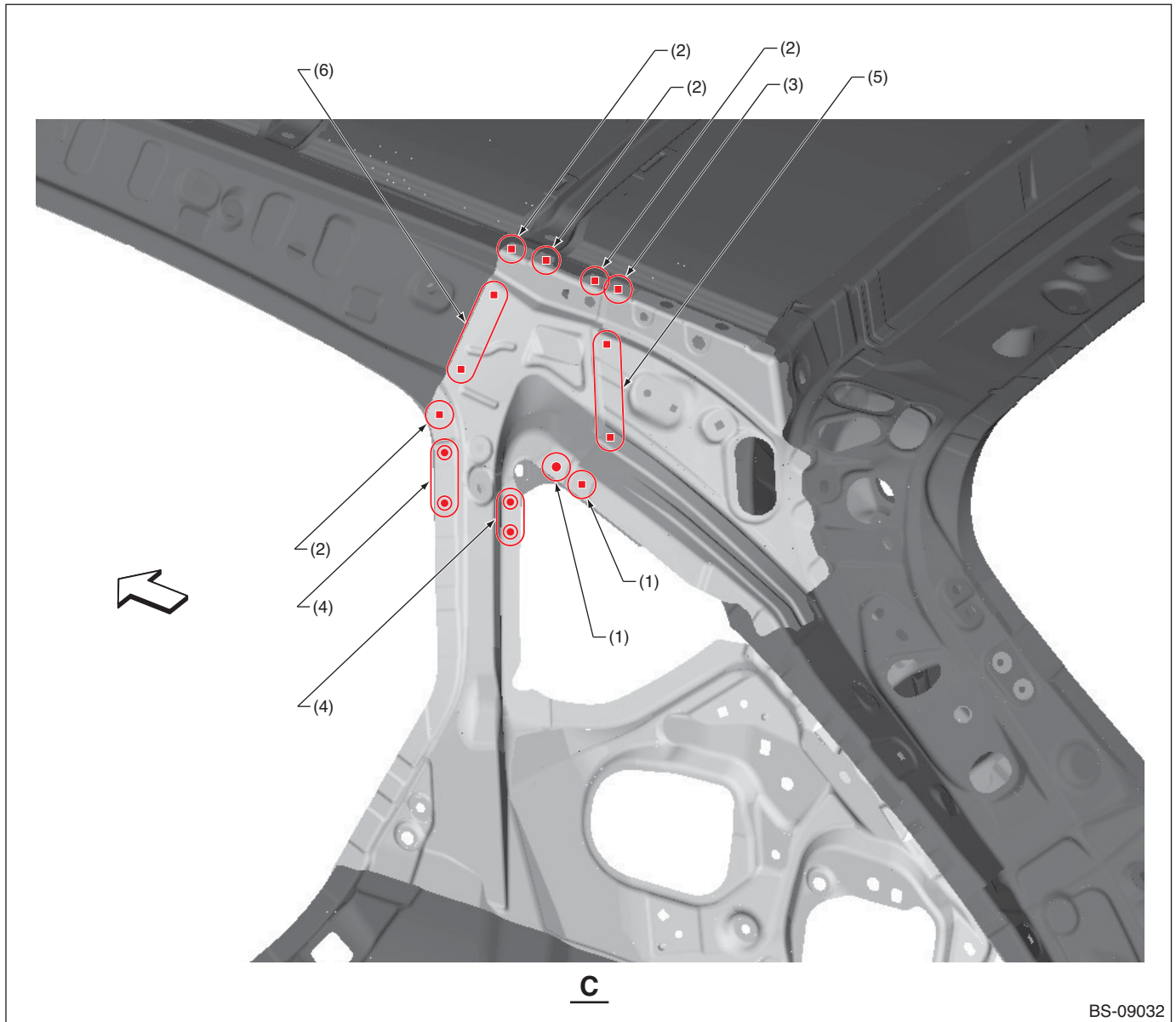


(1) 1 point

(2) 5 points

Panel Replacement

• View C



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

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

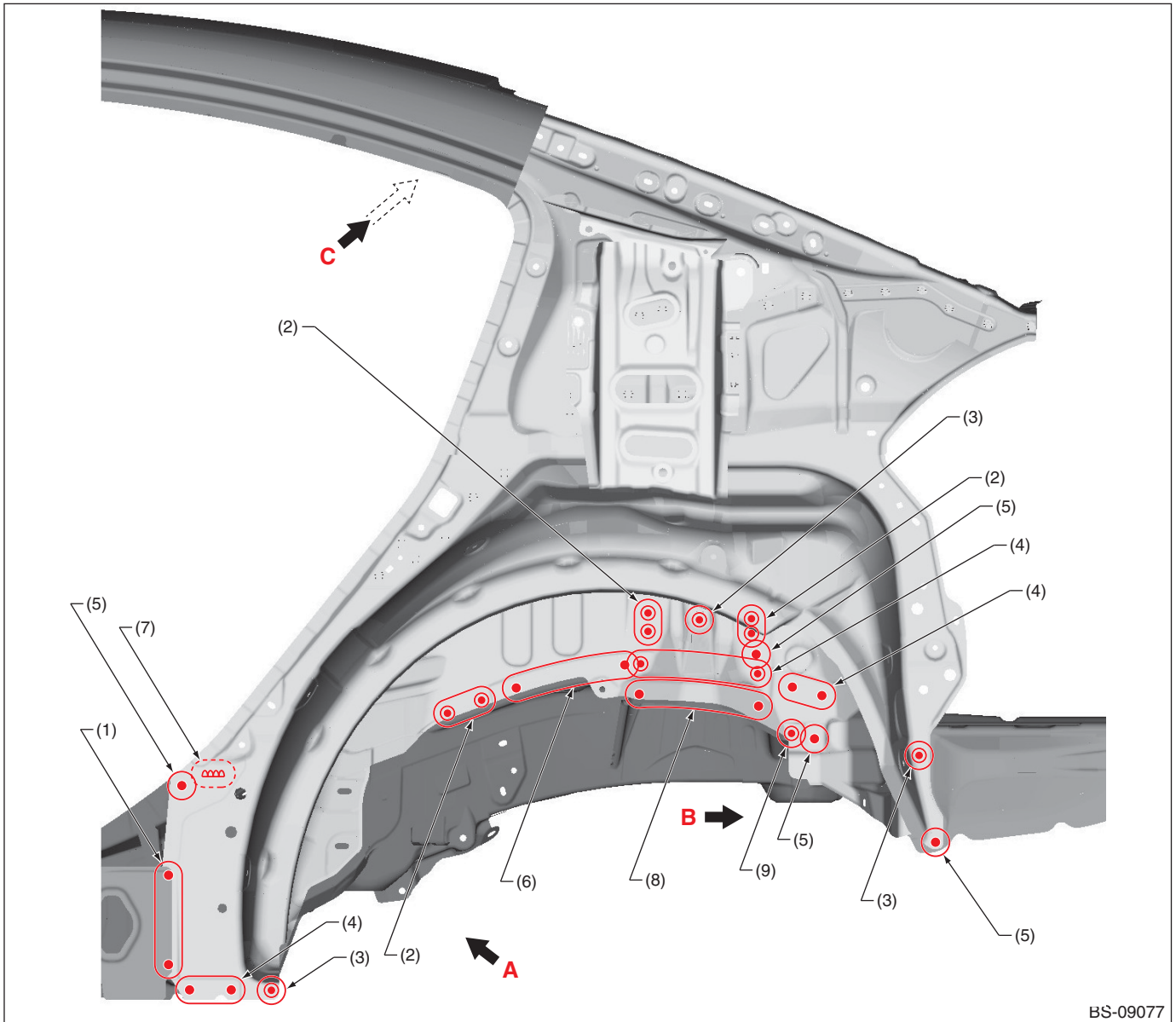
(5) 3 points
(6) 3 points (service)

Panel Replacement

8-33. Rear Quarter Inner (Total replacement) / 4D

A: REMOVAL

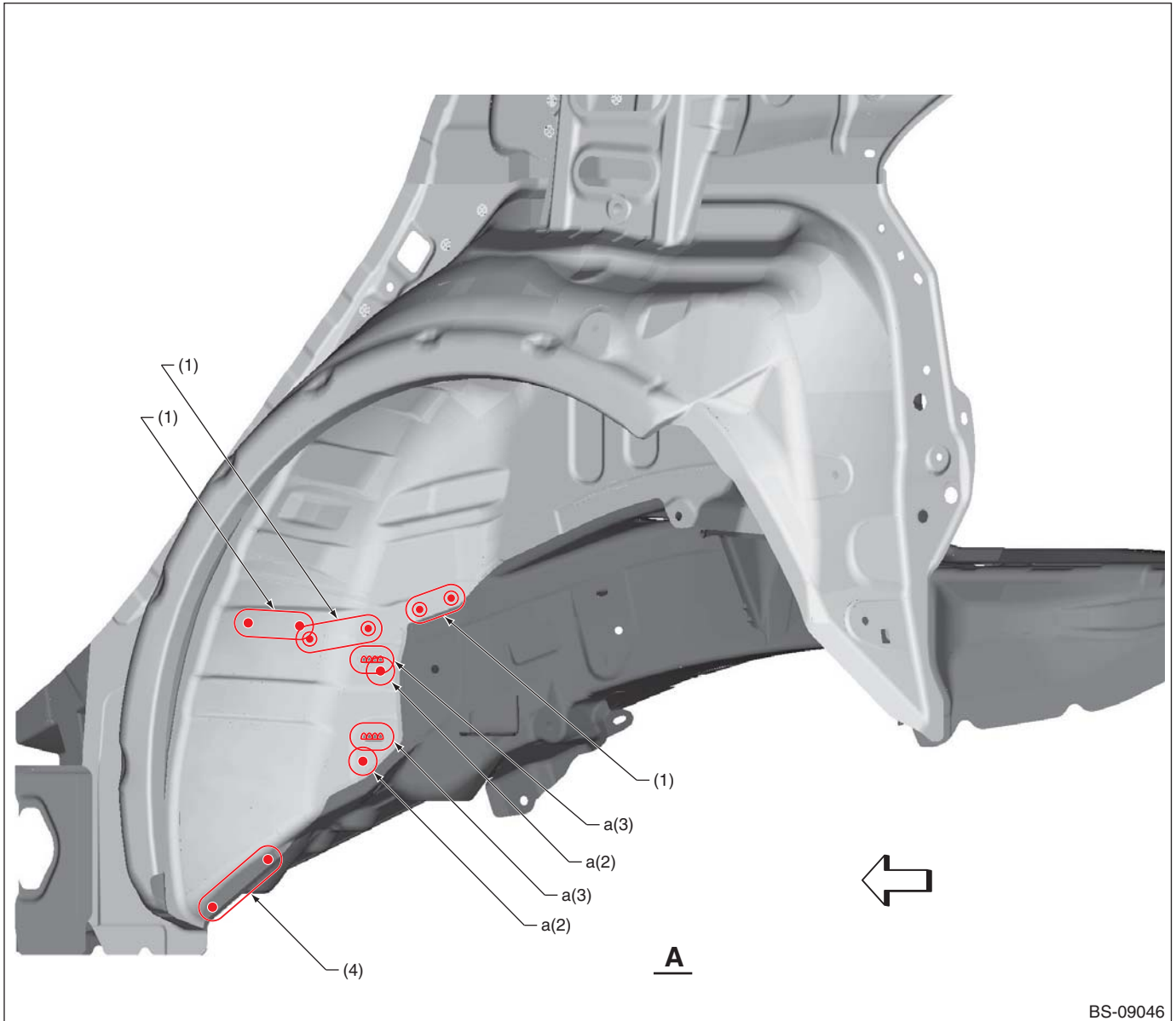
• Overall view



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

Panel Replacement

• View A



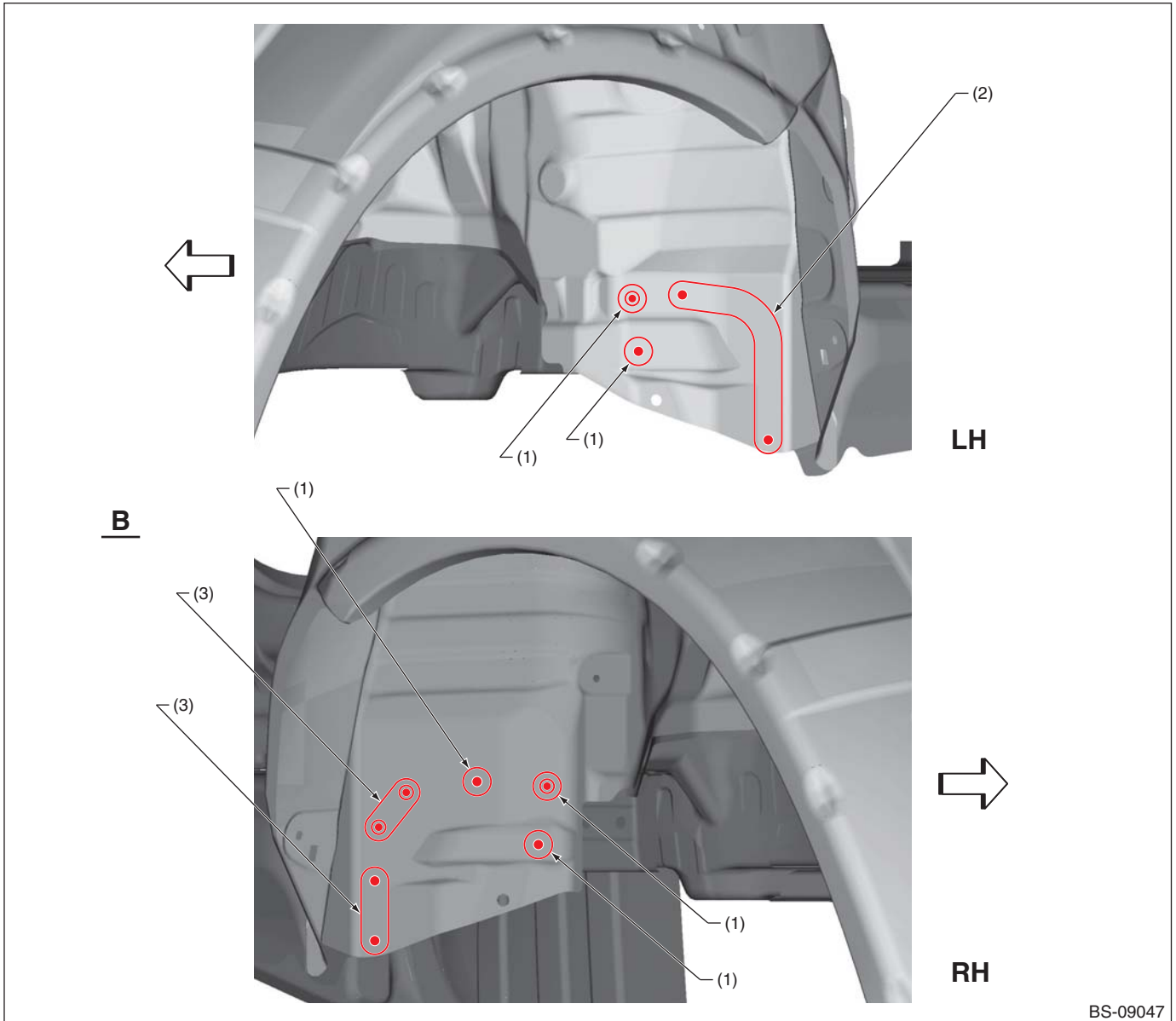
BS-09046

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

Note: Welding points in part "a" vary depending on each vehicle model (spot or arc welding).

Panel Replacement

• View B



BS-09047

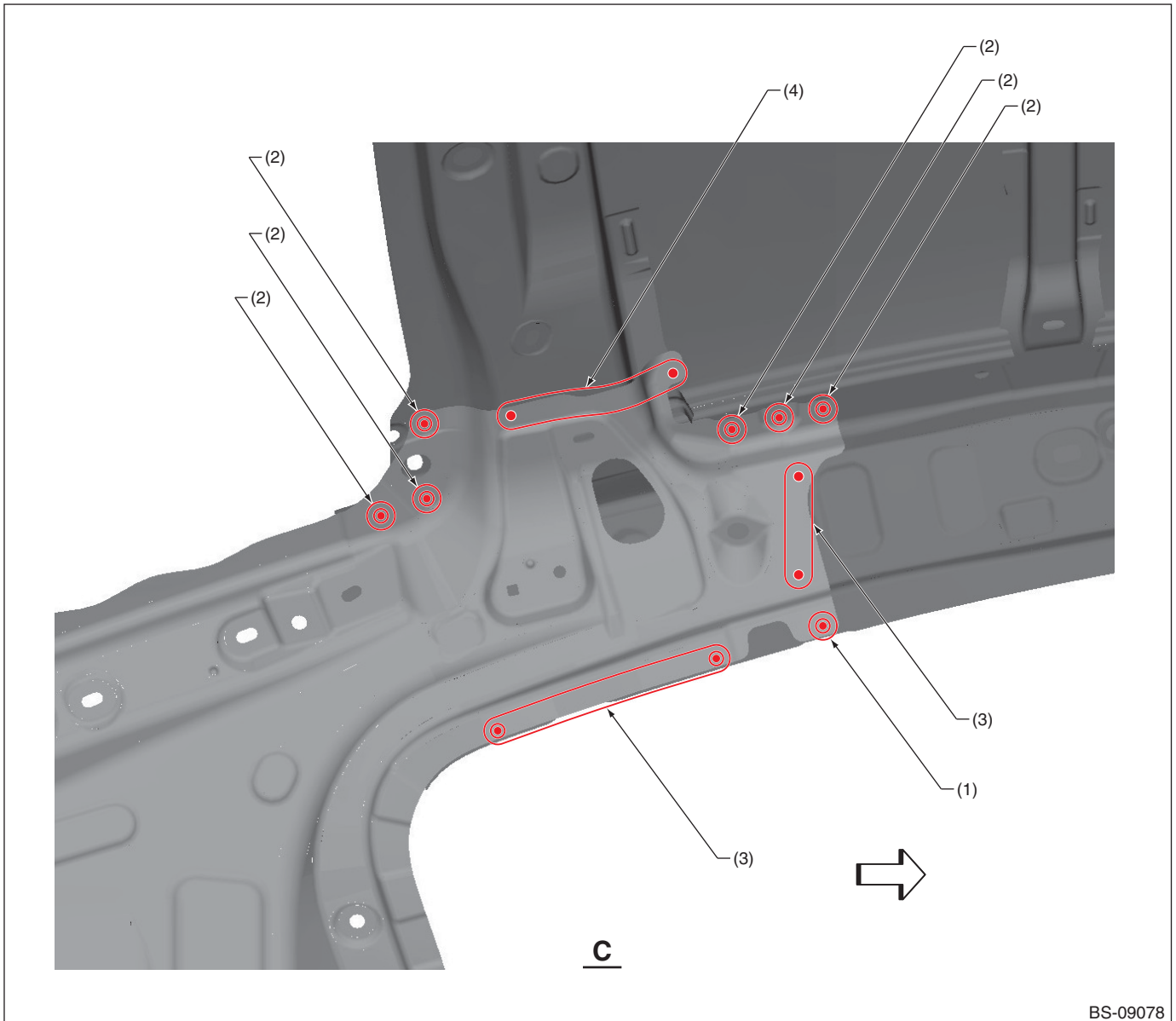
(1) 1 point (outside · 1)

(2) 5 points (outside · 1)

(3) 2 points (outside · 1)

Panel Replacement

• View C



BS-09078

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

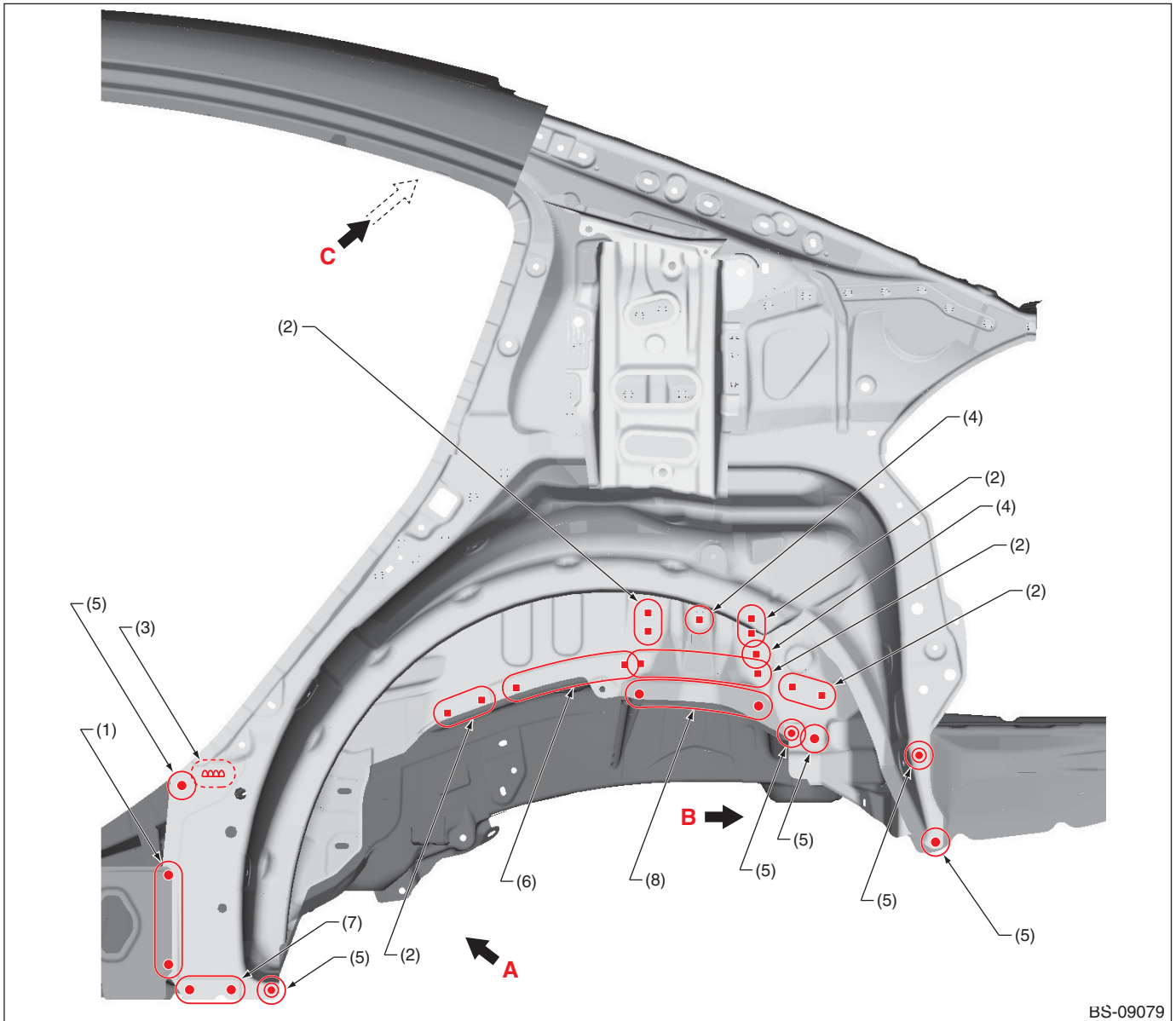
- (3) 3 points (inside · 1)

- (4) 4 points (bottom · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BS-09079

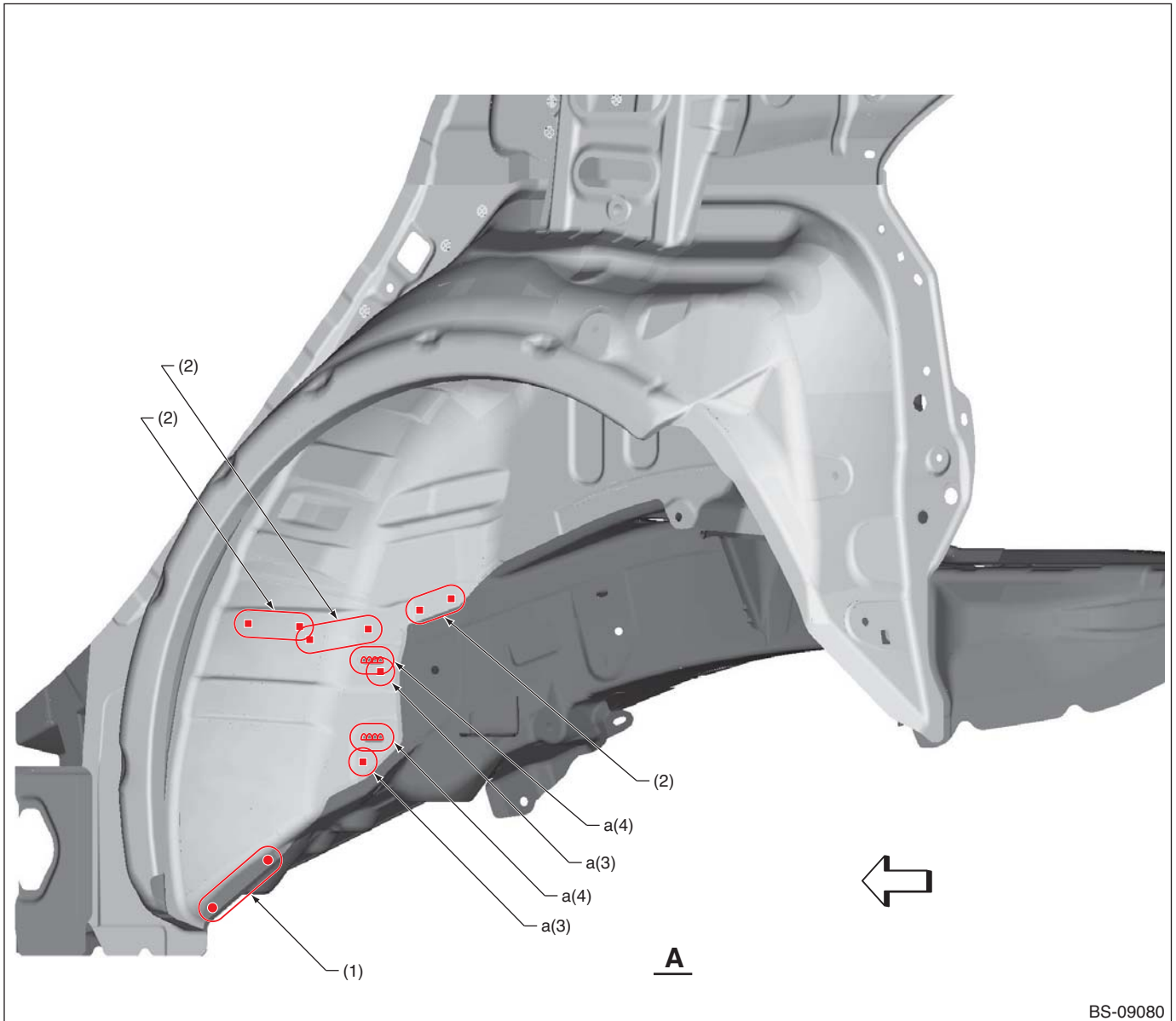
- (1) 3 points
- (2) 2 points (service)
- (3) 1 point (Continuous welding)
(30 mm [1.18 in])

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

- (7) 2 points
- (8) LH: 5 points
RH: 6 points

Panel Replacement

• View A



BS-09080

(1) 2 points

(3) 1 point (service)

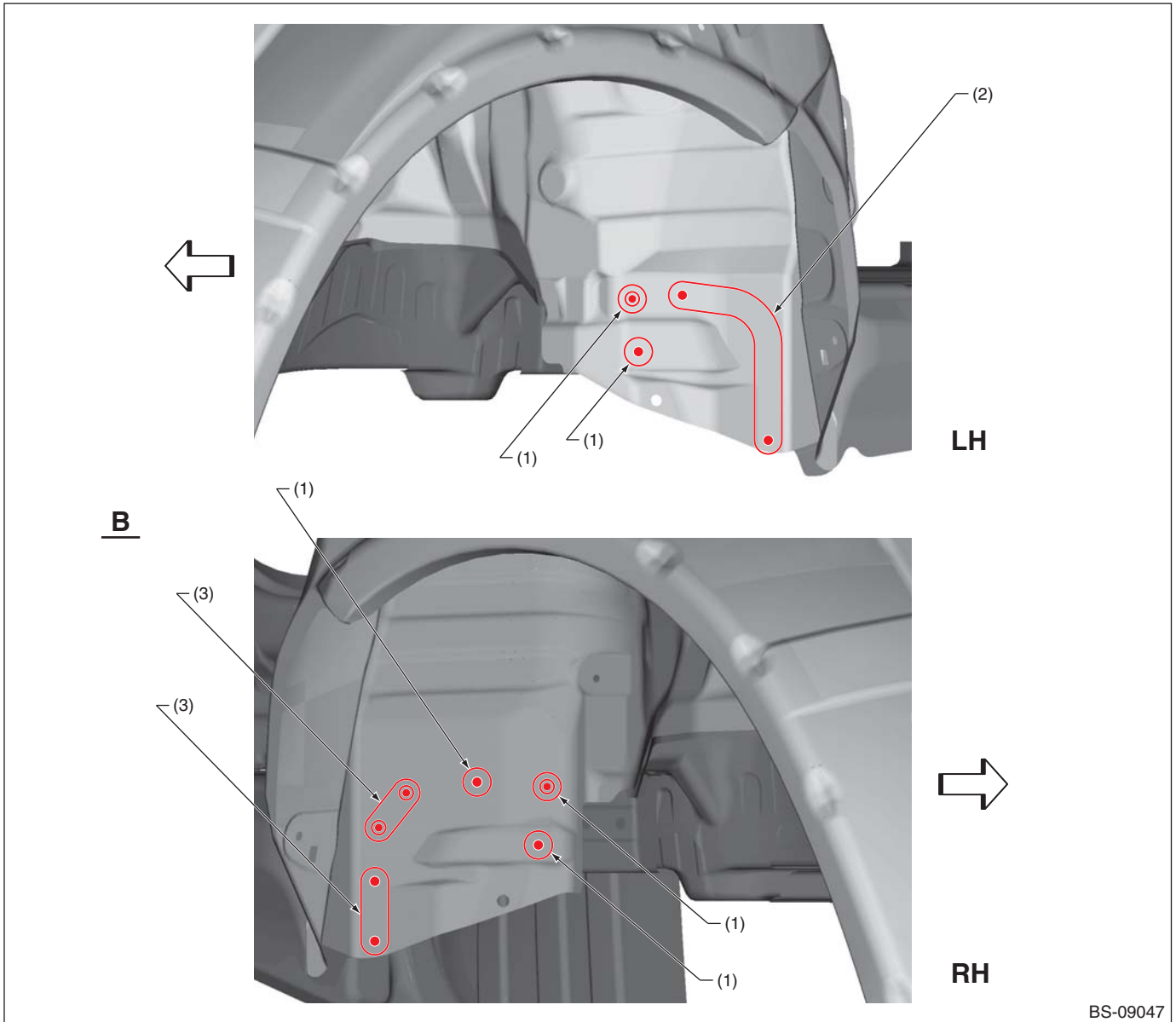
(4) 1 point (Continuous welding)
(5 mm [0.2 in])

(2) 2 points (service)

Note: Welding points in part "a" vary depending on each vehicle model (spot or arc welding).

Panel Replacement

• View B



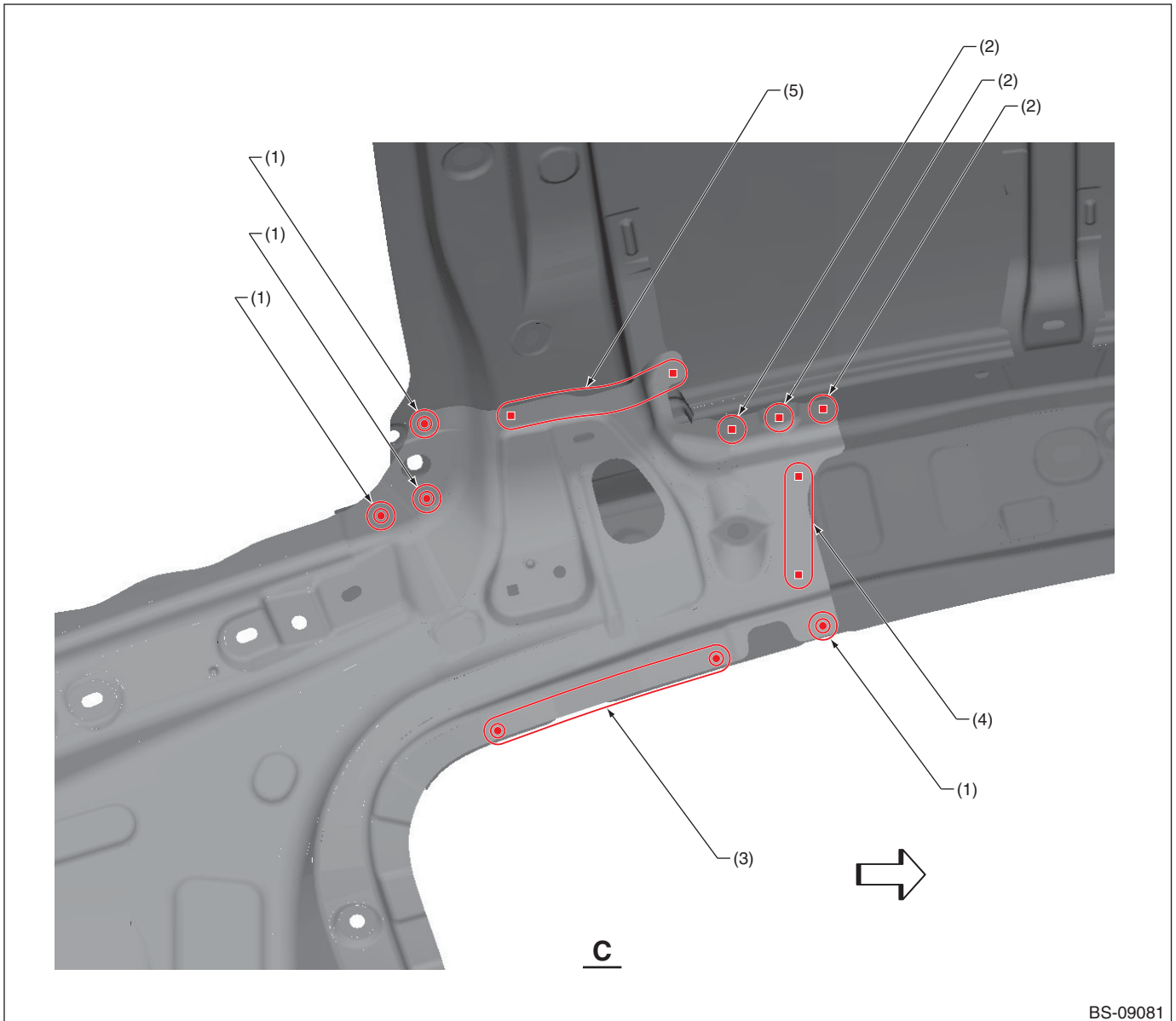
(1) 1 point

(2) 5 points

(3) 2 points

Panel Replacement

• View C



(1) 1 point

(2) 1 point (service)

(3) 3 points

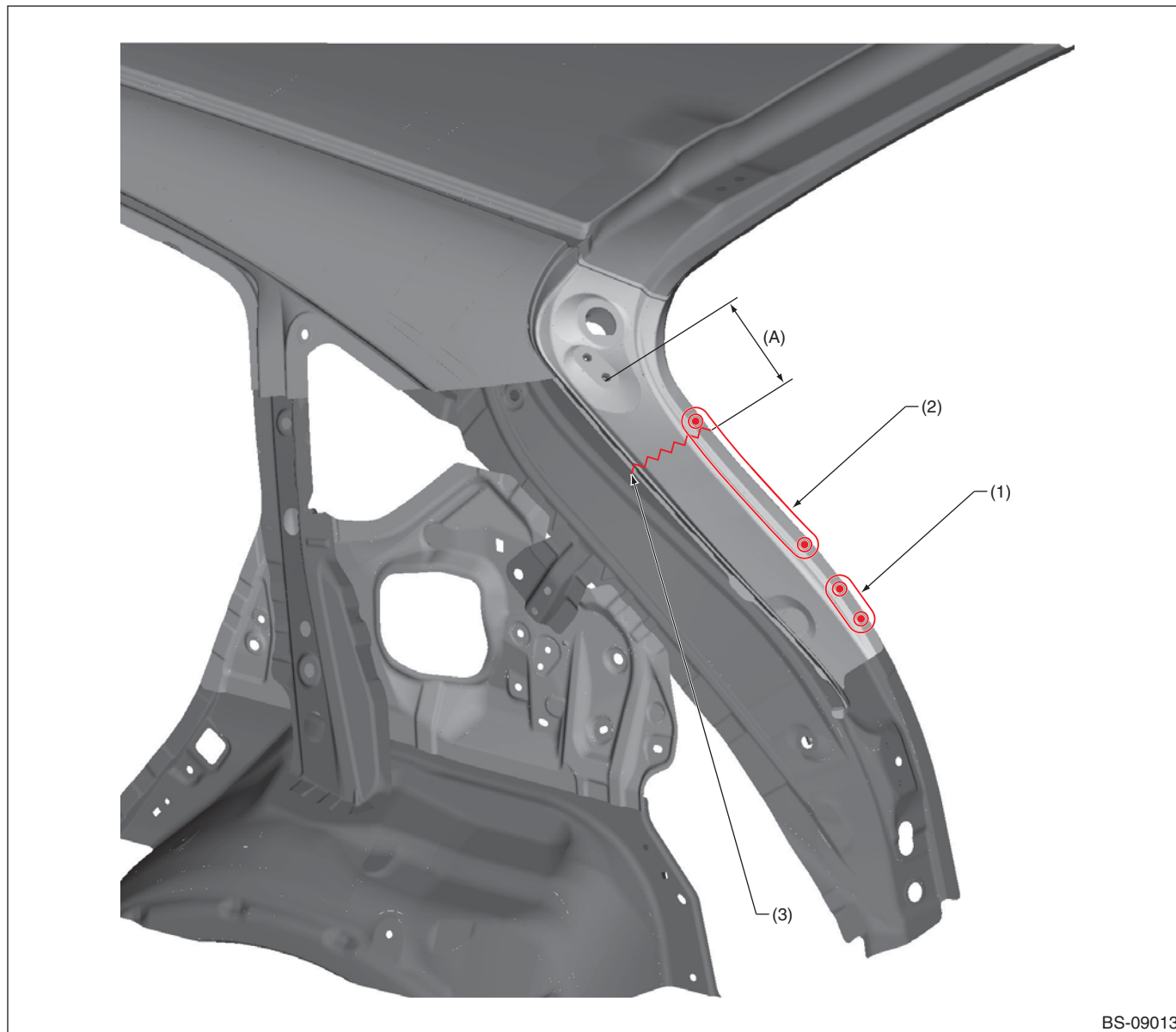
(4) 3 points (service)

(5) 4 points (service)

8-34. D Pillar Extension (Partial replacement) / 5D

A: REMOVAL

• Overall view



BS-09013

(A) 90 mm [3.54 in]

(1) 2 points (outside · 1)

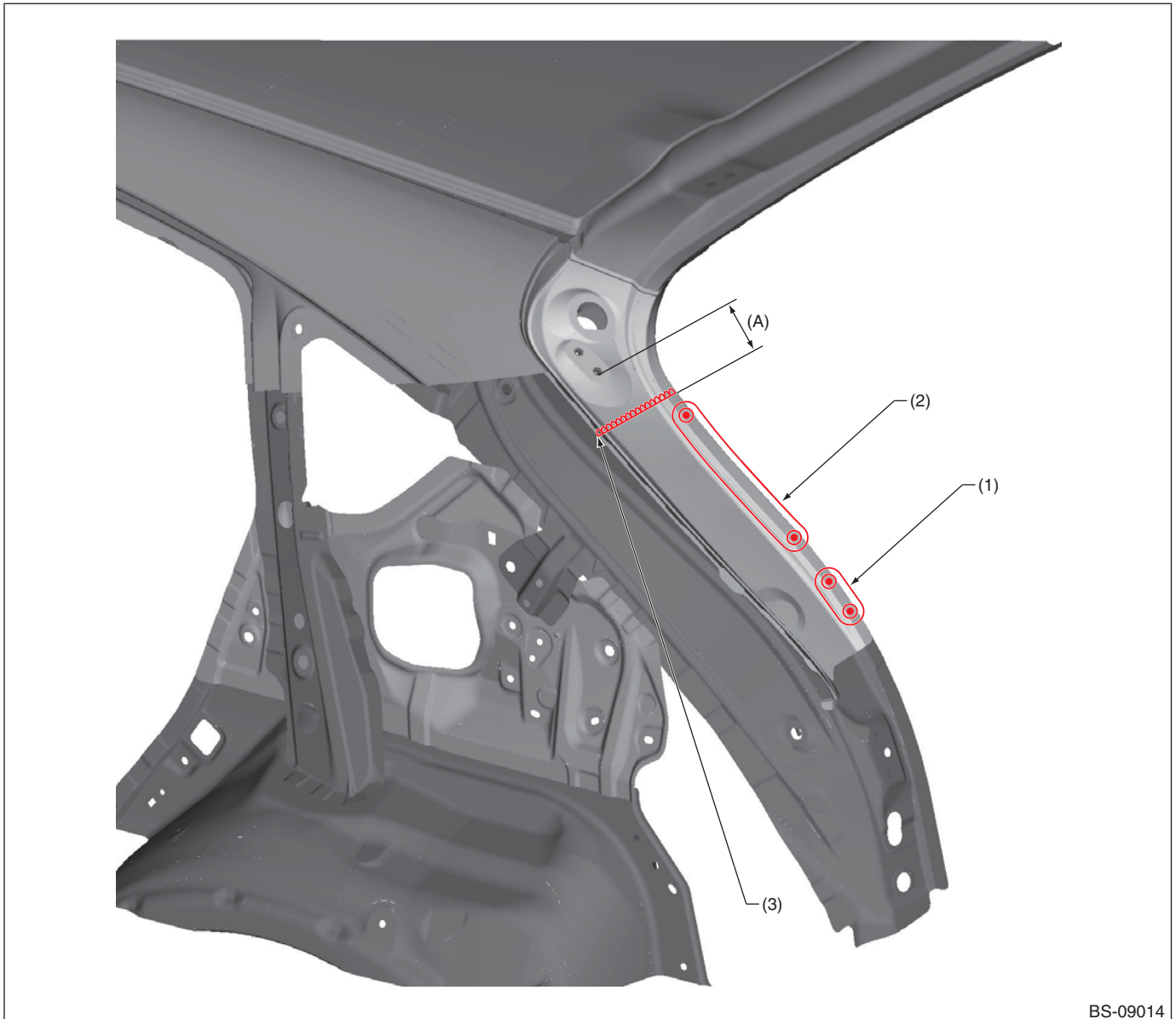
(2) LH: 5 points (outside · 1)
RH: 4 points (outside · 1)

(3) Cut position

Panel Replacement

B: INSTALLATION

• Overall view



(A) 70 mm [2.76 in]

(1) 2 points

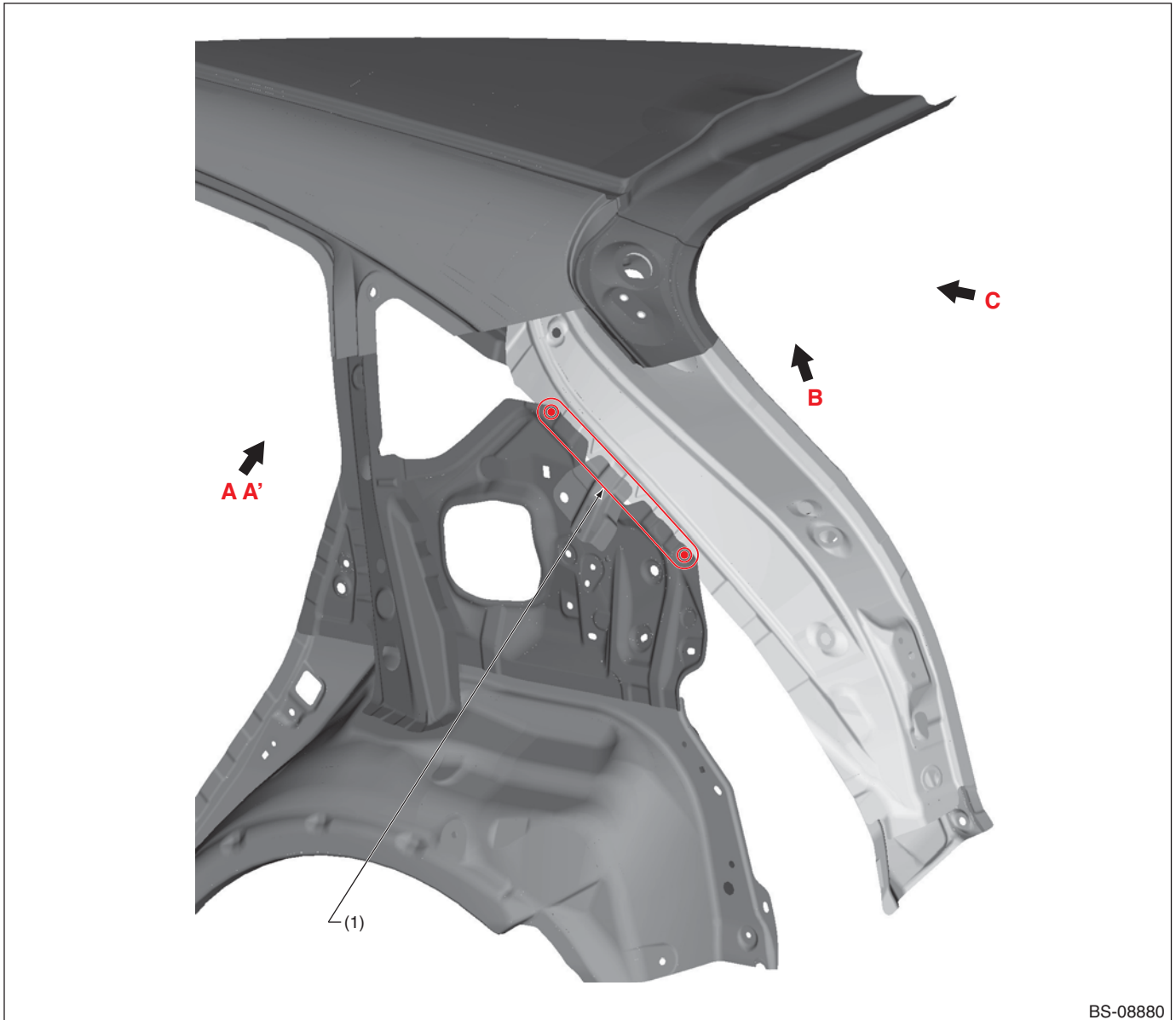
(2) LH: 5 points
RH: 4 points

(3) 1 point (Continuous welding)

8-35. D Pillar Reinforcement (Total replacement) / 5D

A: REMOVAL

- Overall view

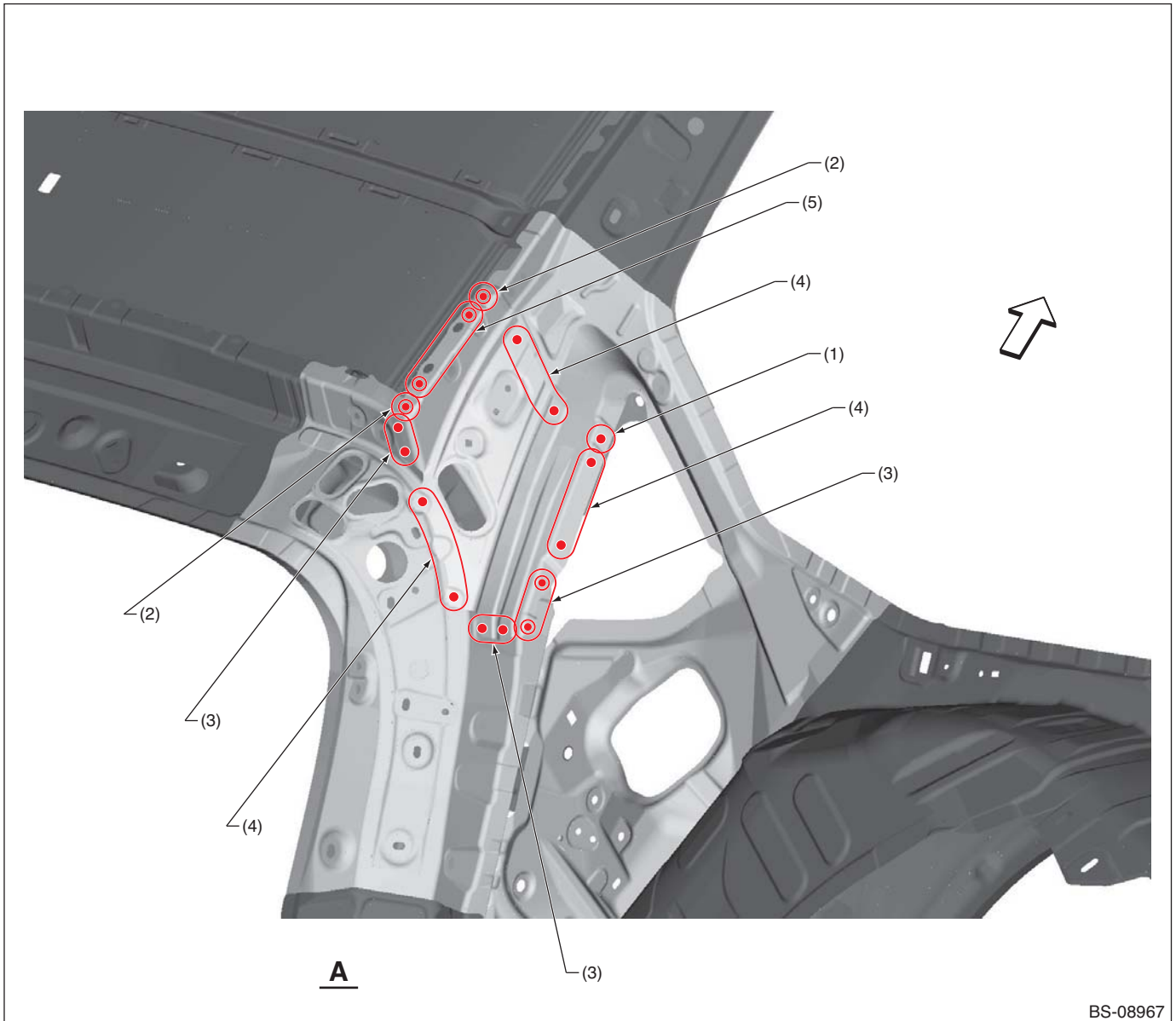


BS-08880

- (1) LH: 7 points (inside · 2)
RH: 8 points (inside · 2)

Panel Replacement

• View A



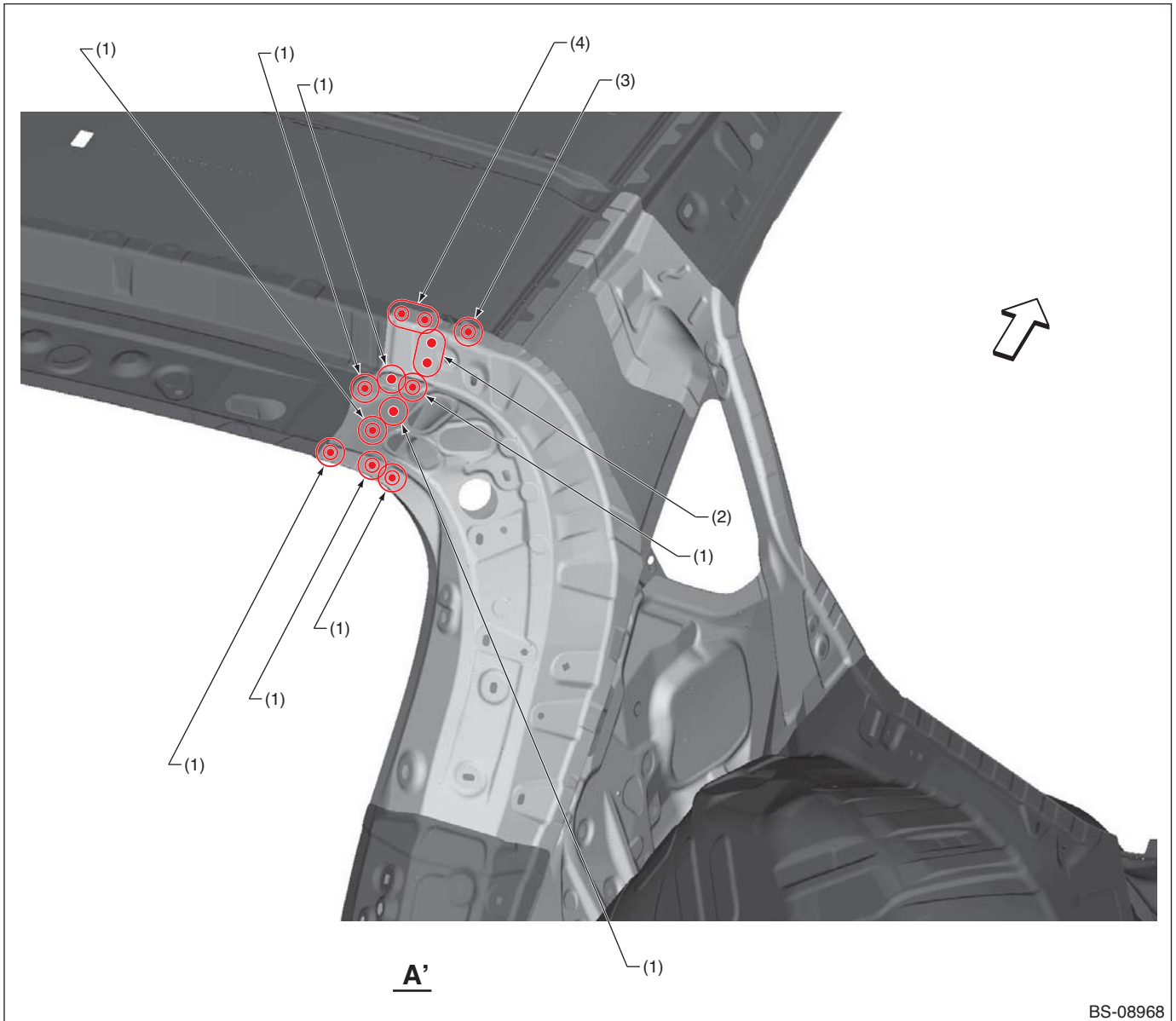
(1) 1 point (inside · 1)
(2) 1 point (bottom · 1)

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

(5) 3 points (bottom · 1)

Panel Replacement

• View A'



BS-08968

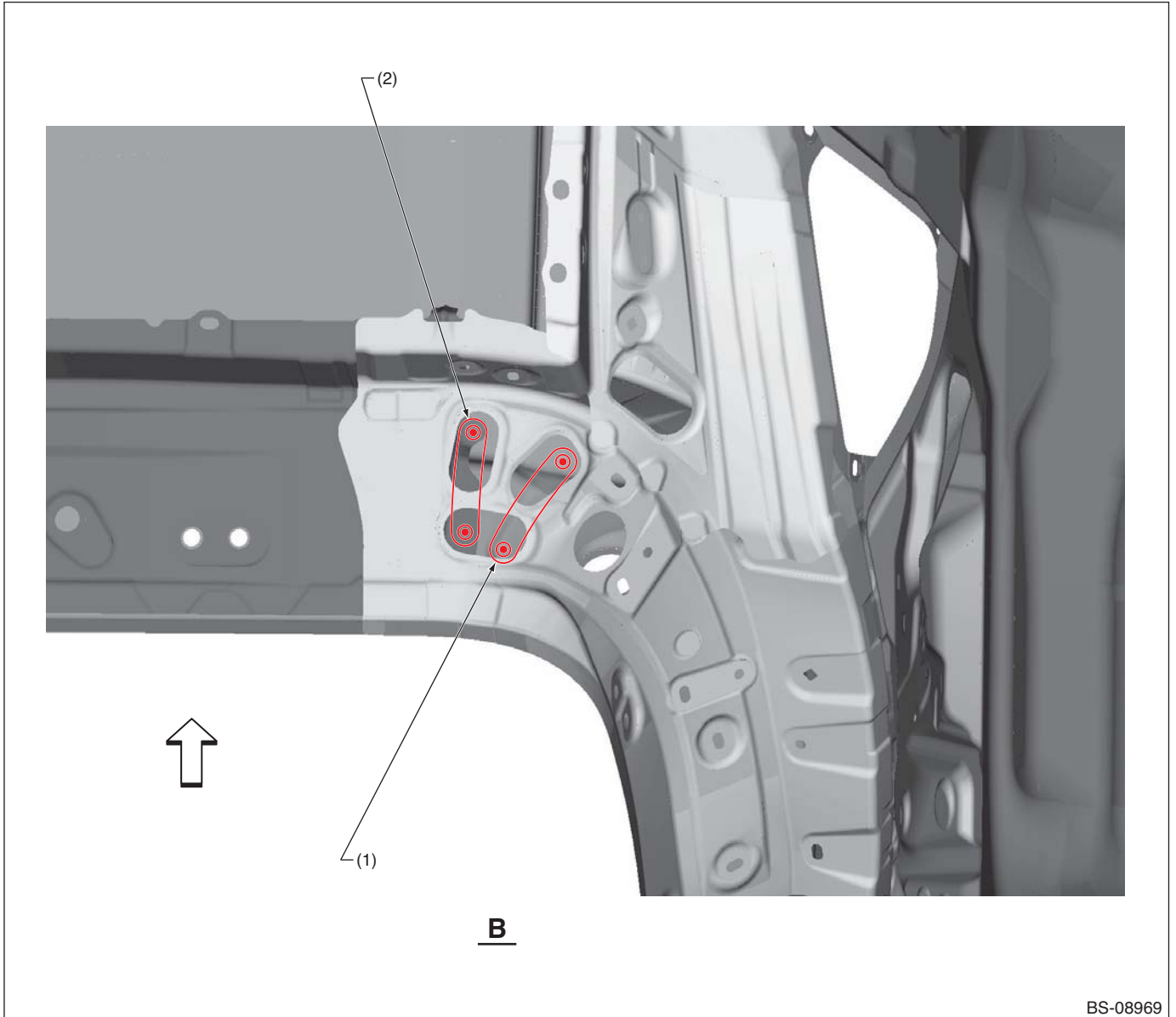
(1) 1 point (bottom · 1)
(2) 2 points (inside · 1)

(3) 1 point (bottom · 2)

(4) 2 points (bottom · 1)

Panel Replacement

• View B

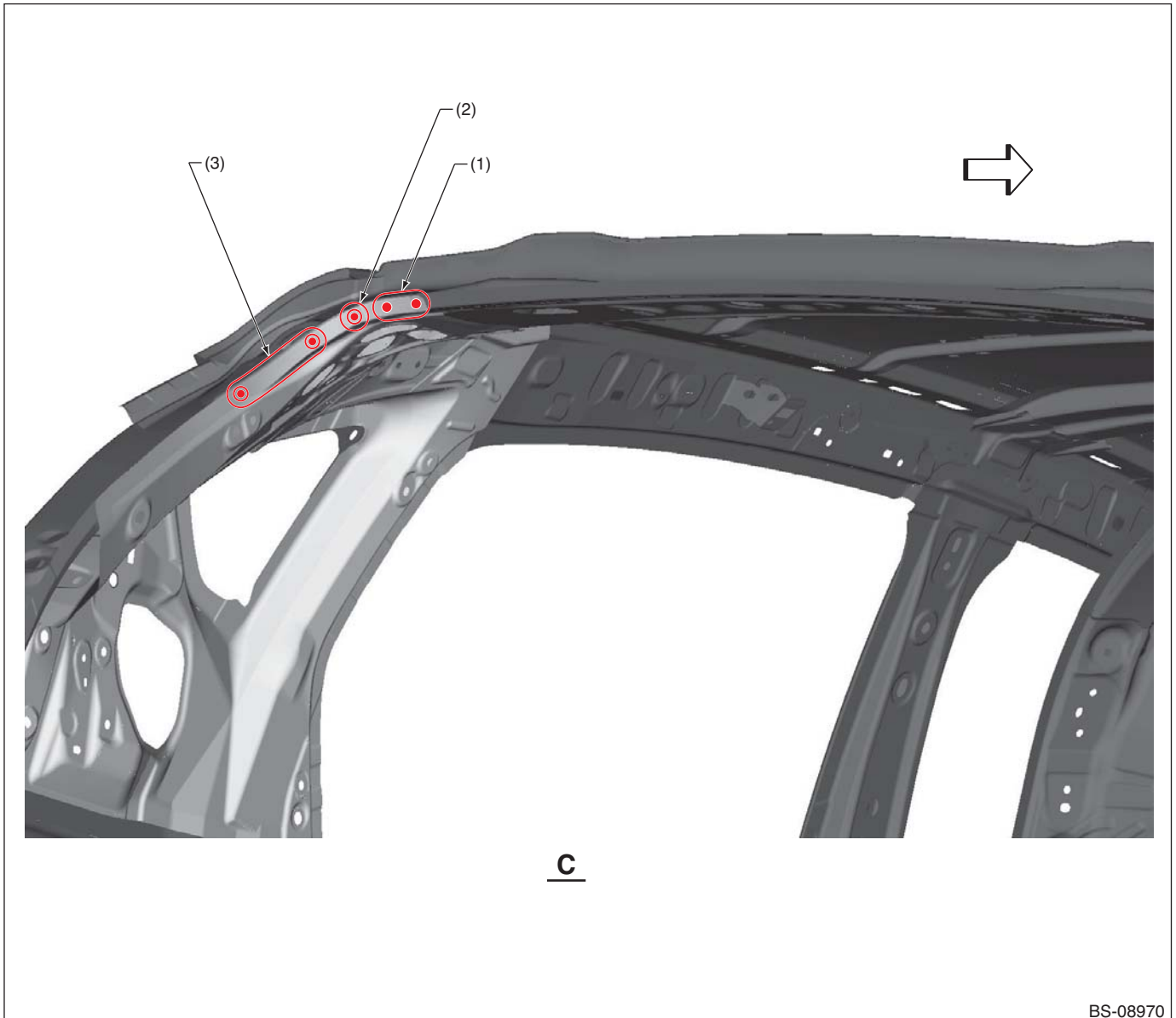


(1) 3 points (bottom · 1)

(2) 3 points (bottom · 2)

Panel Replacement

• View C



BS-08970

(1) 3 points (outside · 1)

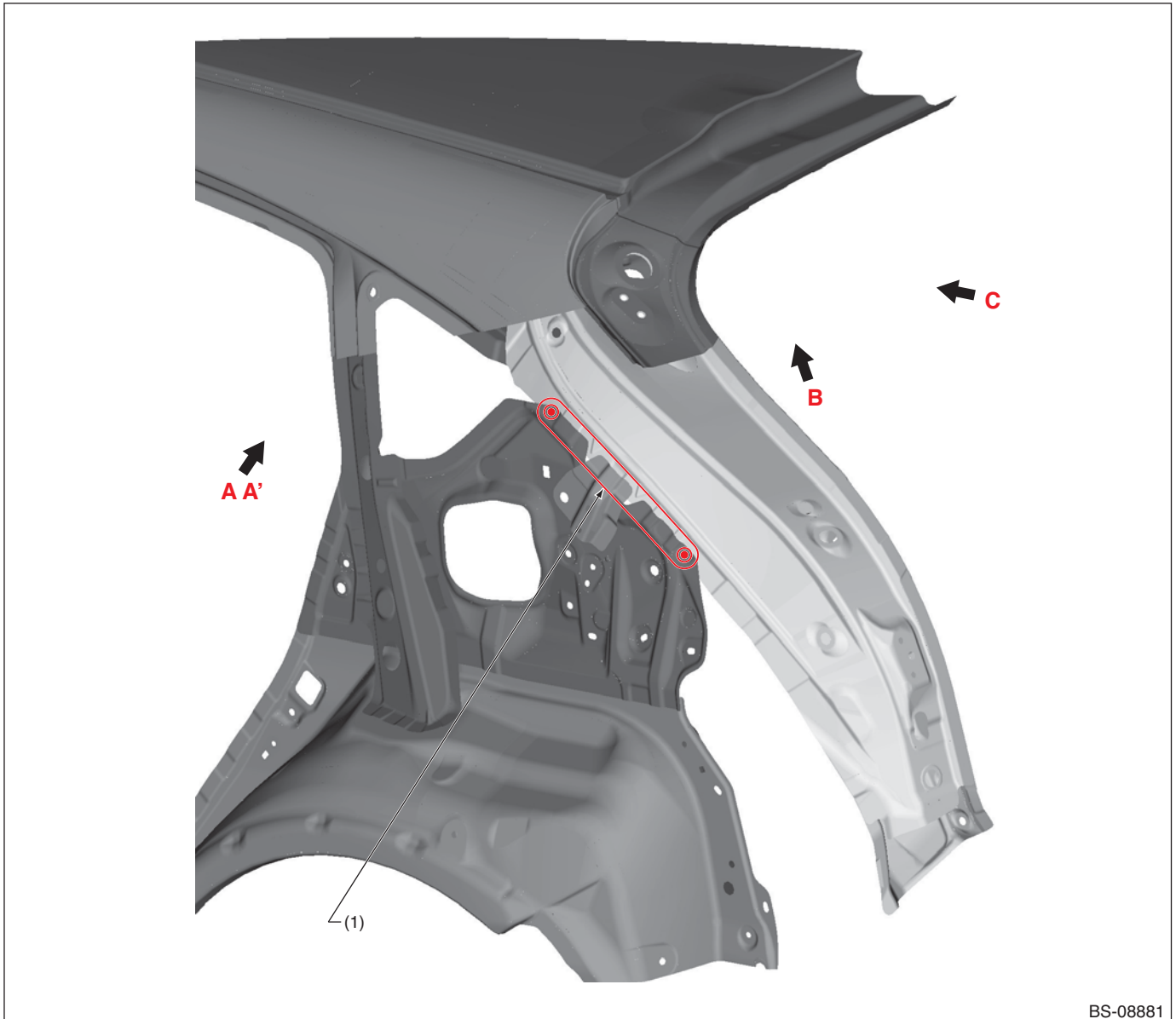
(2) 1 point (outside · 1)

(3) 3 points (inside · 2)

Panel Replacement

B: INSTALLATION

• Overall view

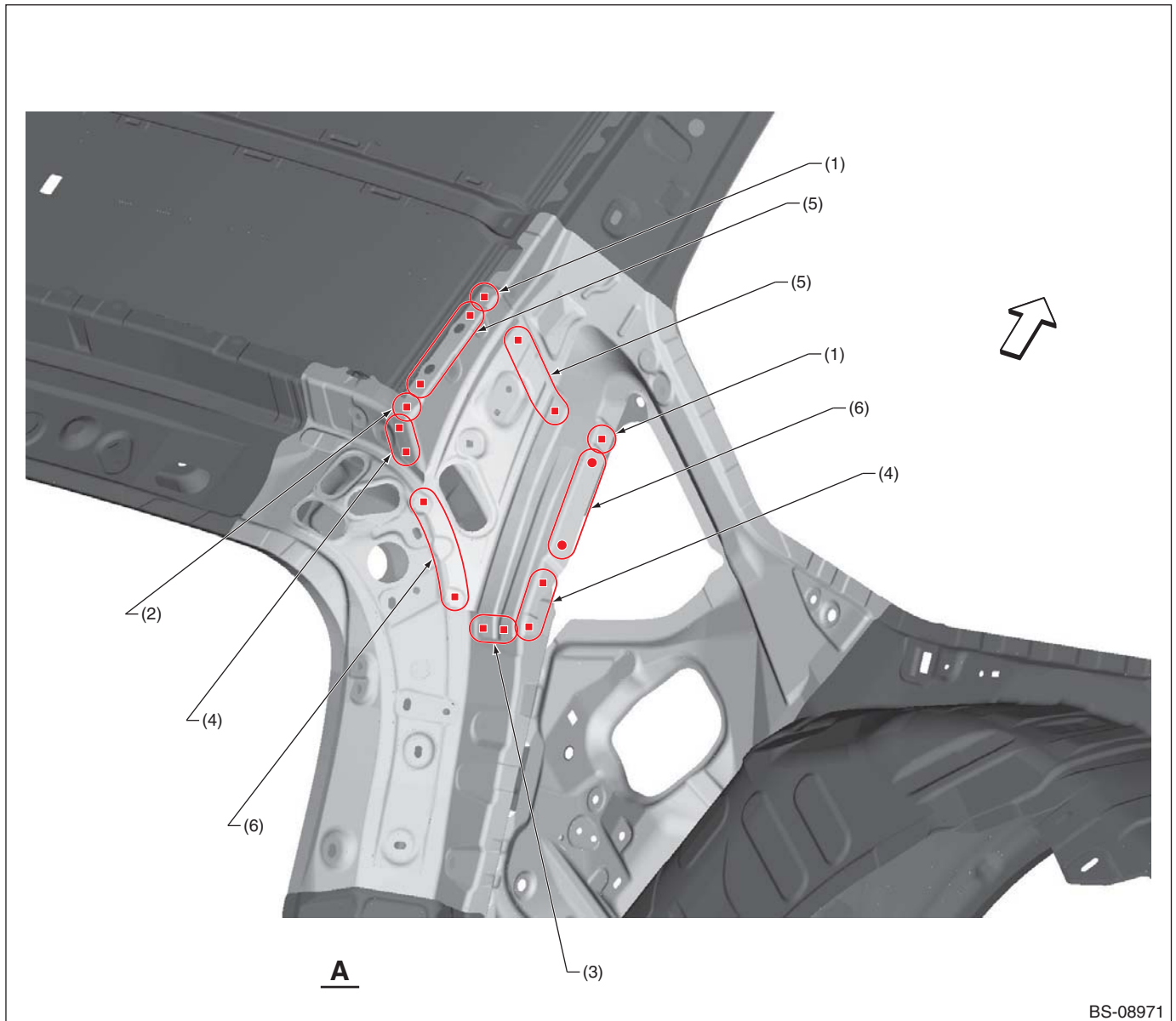


BS-08881

- (1) LH: 7 points
RH: 8 points

Panel Replacement

• View A



BS-08971

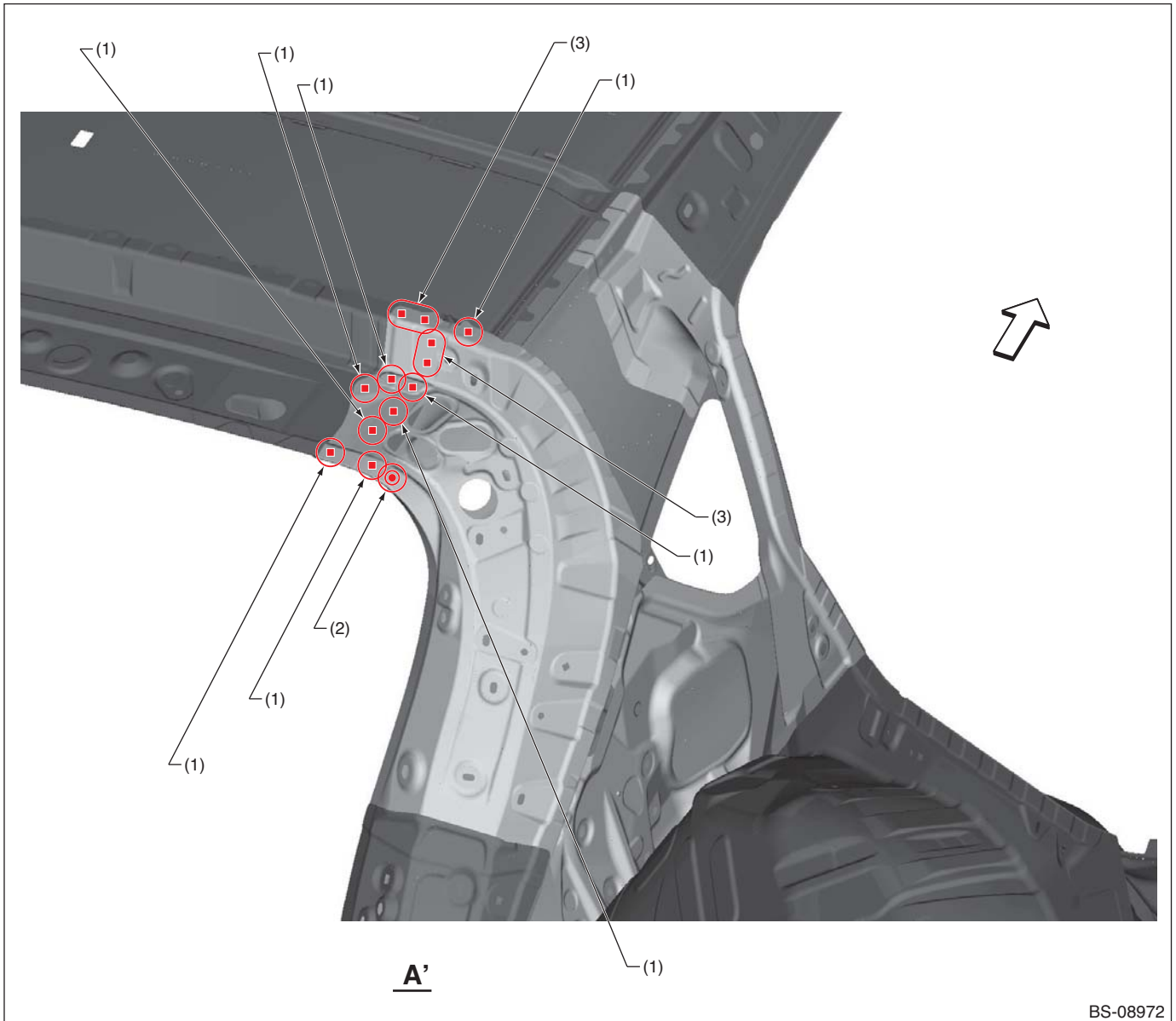
(1) 1 point (service)
(2) 1 point

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

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

Panel Replacement

• View A'



BS-08972

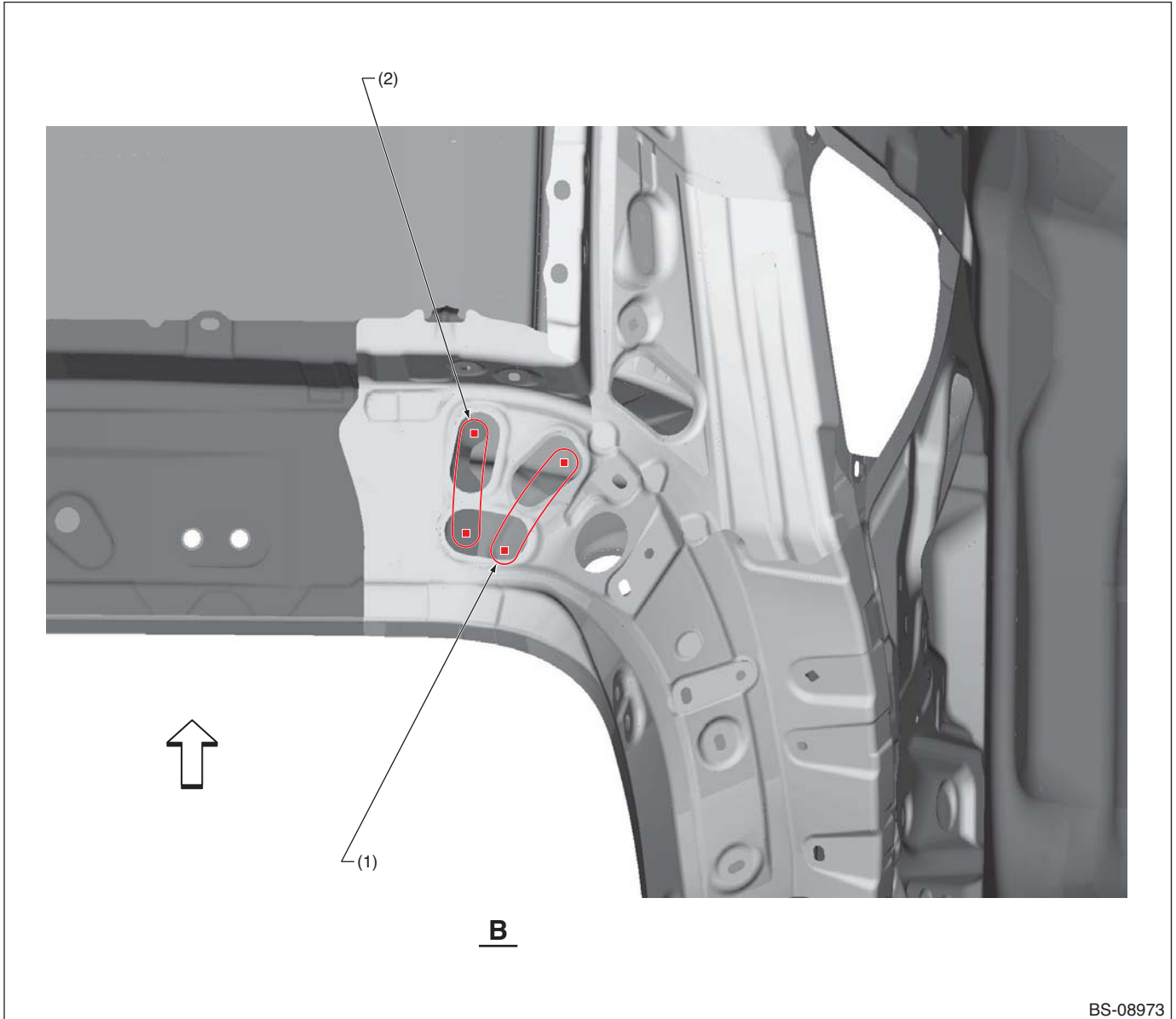
(1) 1 point (service)

(2) 1 point

(3) 2 points (service)

Panel Replacement

• View B

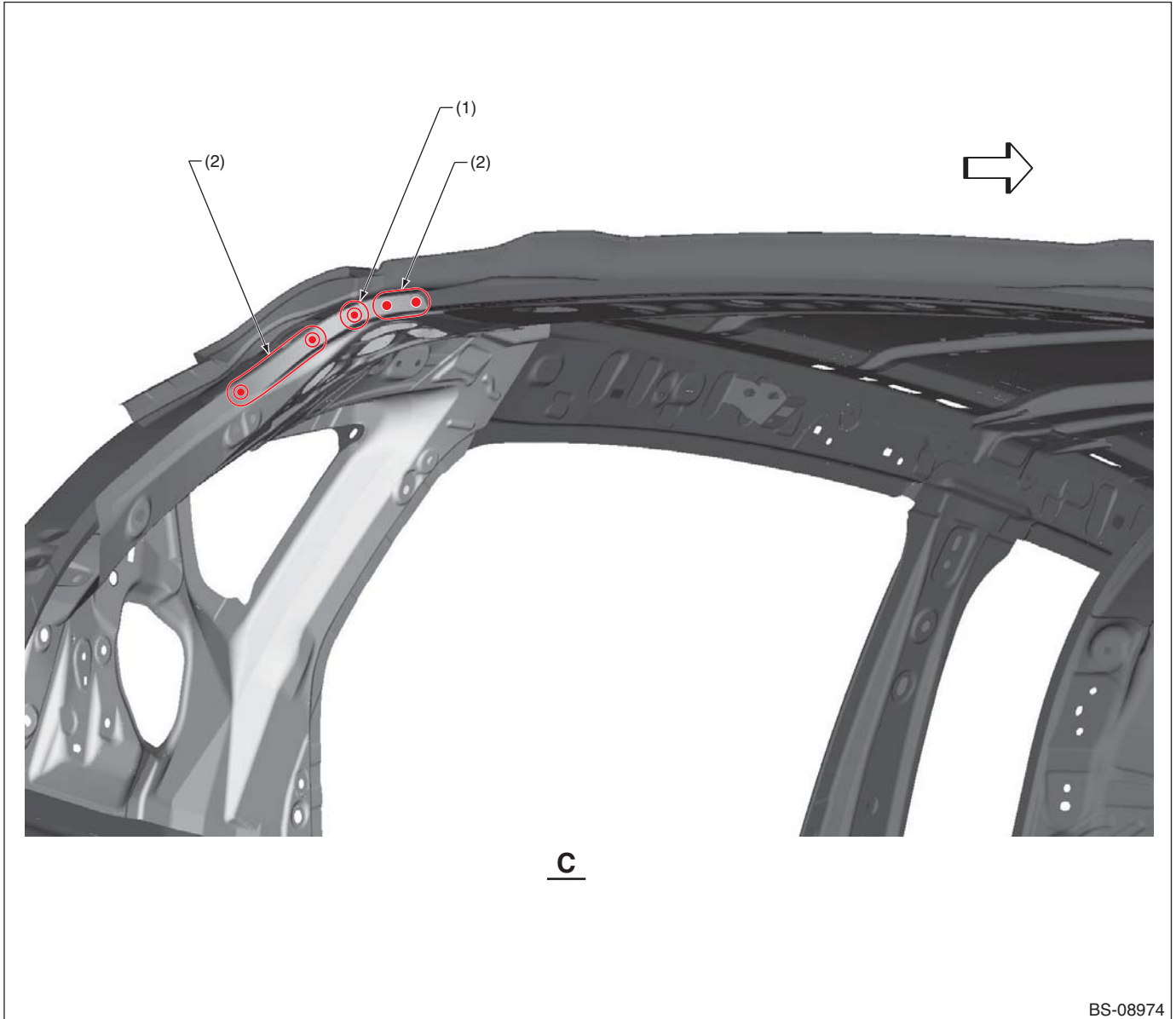


(1) 3 points (service)

(2) 3 points (service · matching)

Panel Replacement

• View C



(1) 1 point

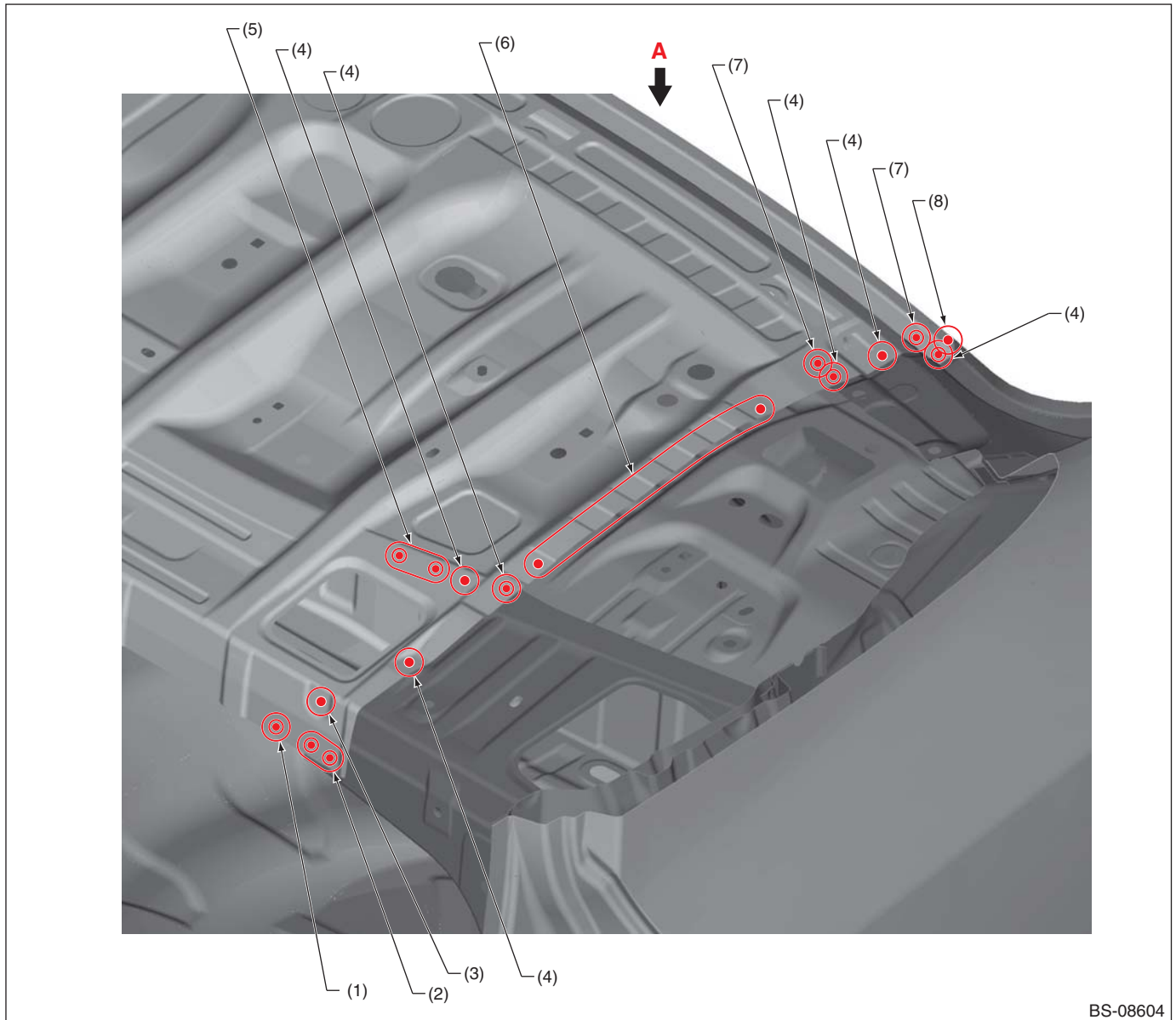
(2) 3 points

Panel Replacement

8-36. Rear Panel (Total replacement) / 4D

A: REMOVAL

• Overall view



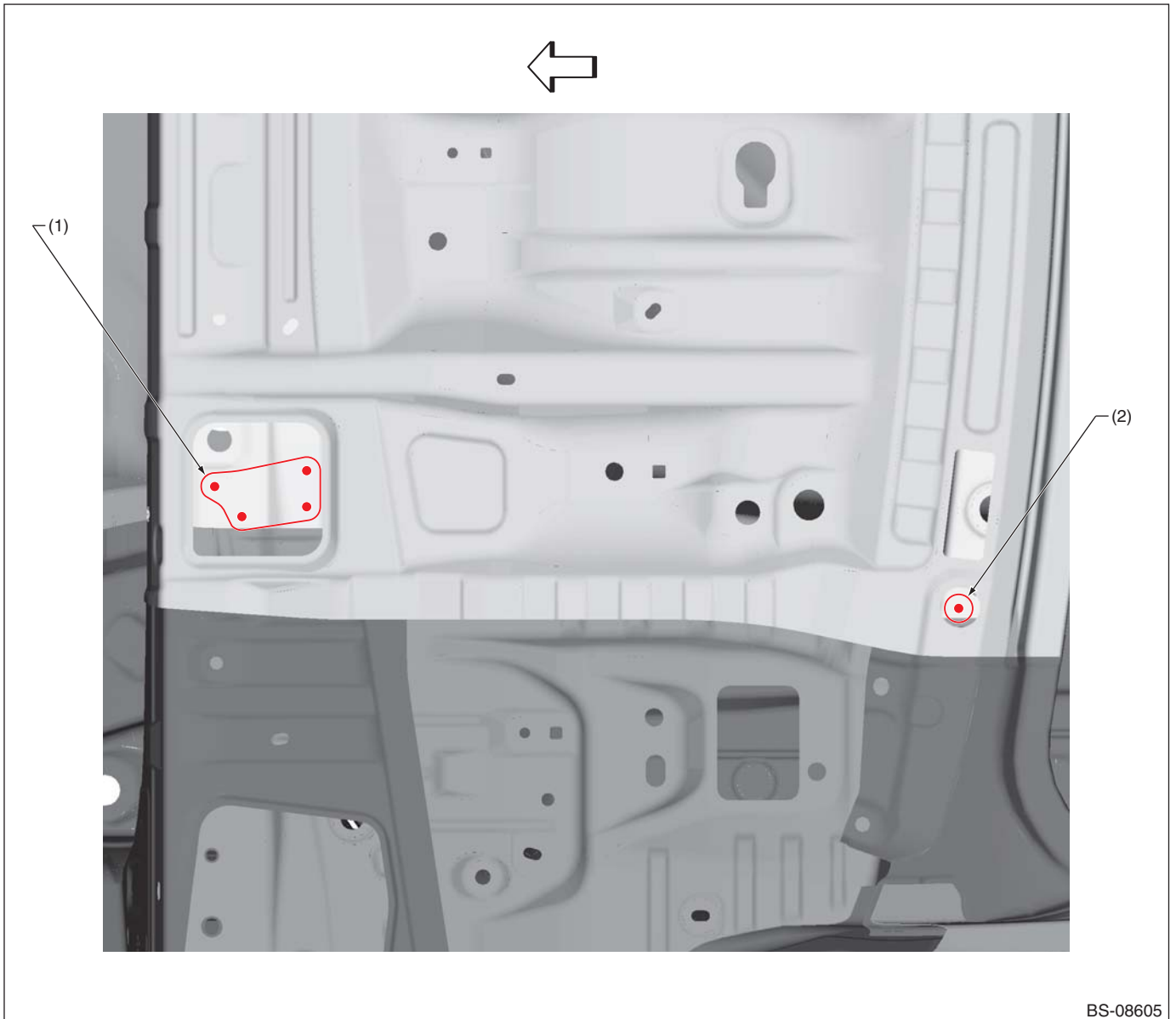
- (1) 1 point (inside · 2)
- (2) 2 points (inside · 1)
- (3) 1 point (inside · 1)

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

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

Panel Replacement

• View A



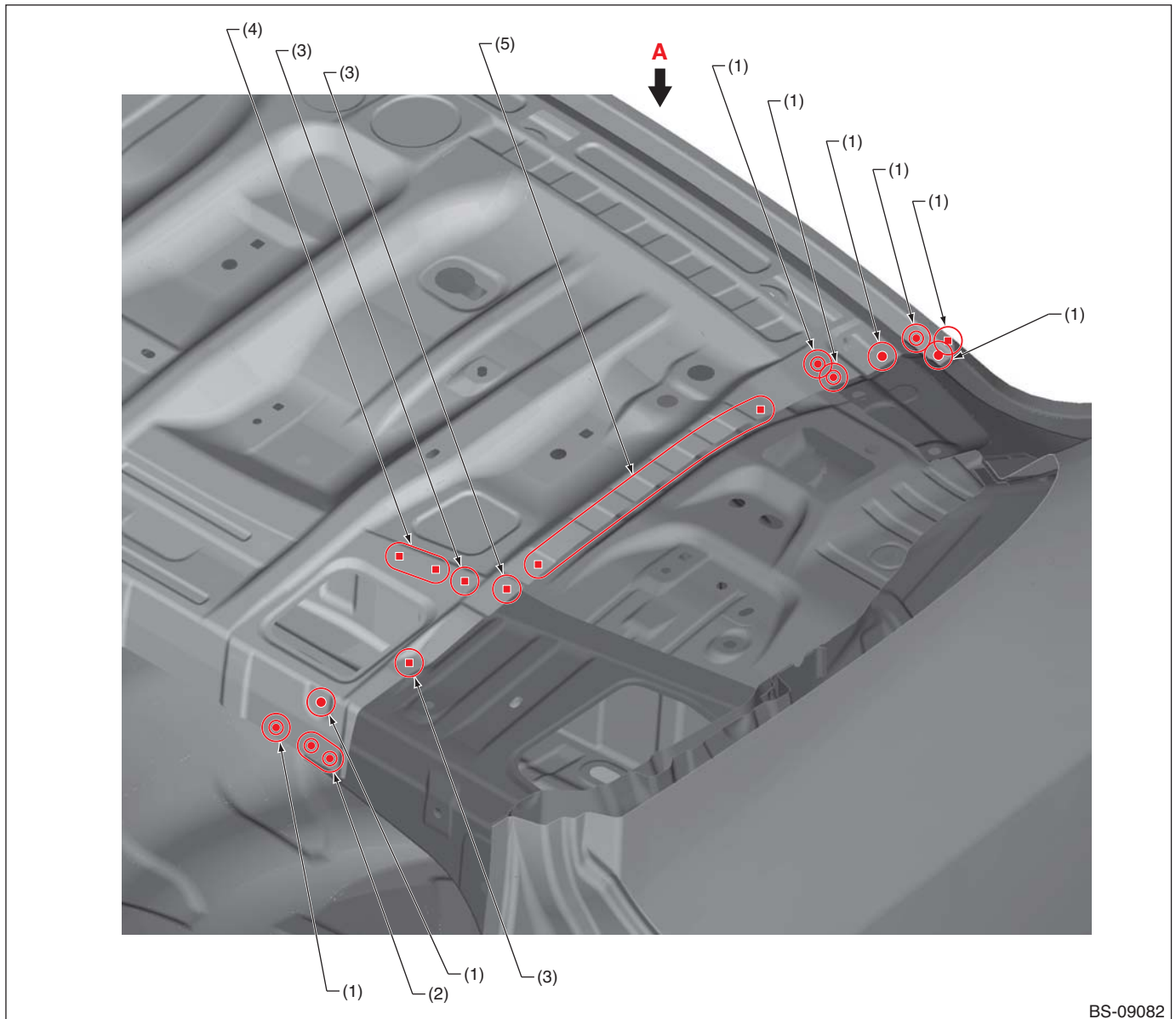
(1) 5 points (top · 1)

(2) 1 point (top · 1)

Panel Replacement

B: INSTALLATION

• Overall view



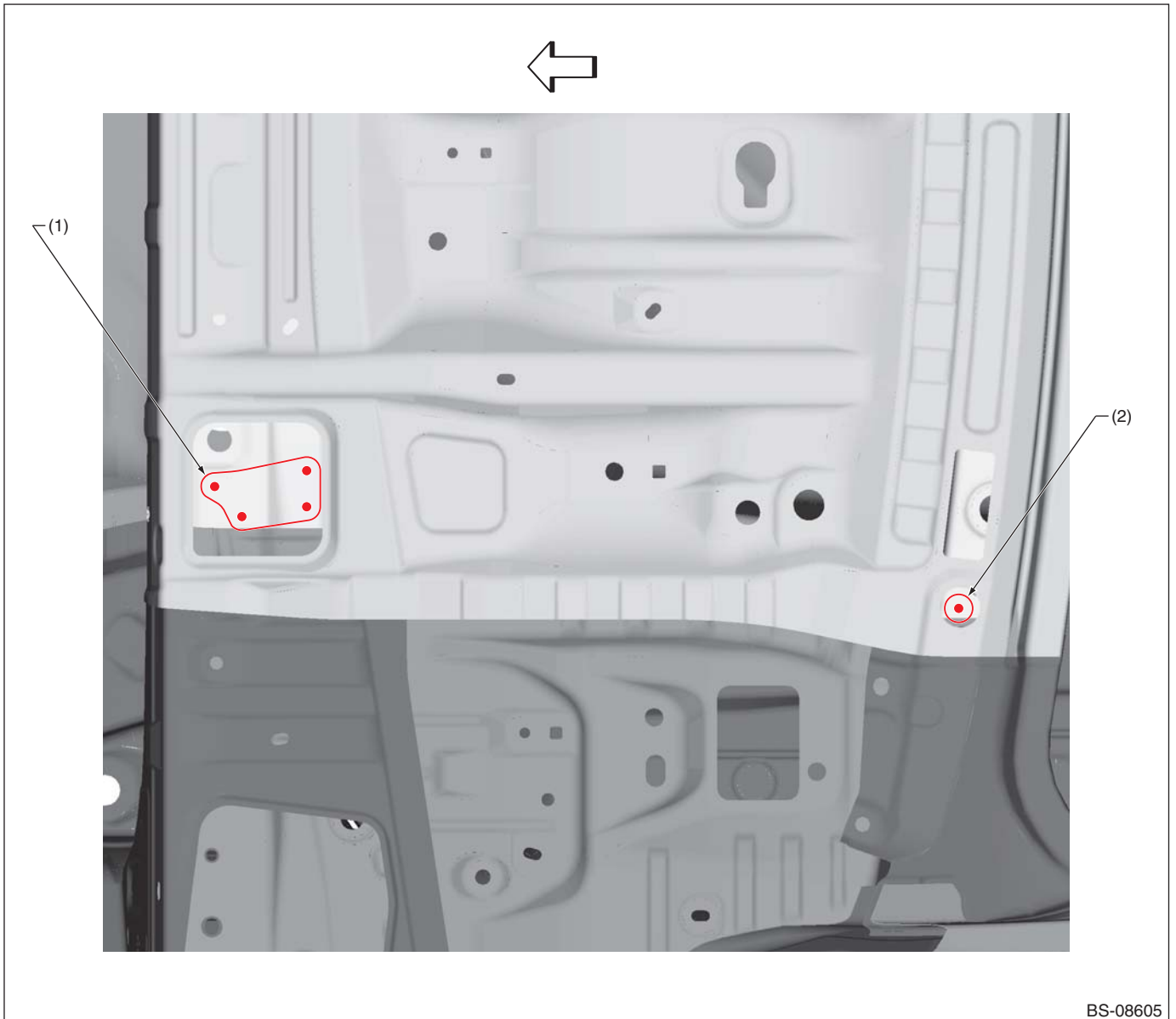
(1) 1 point
(2) 2 points

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

(5) 6 points (service)

Panel Replacement

• View A



(1) 5 points

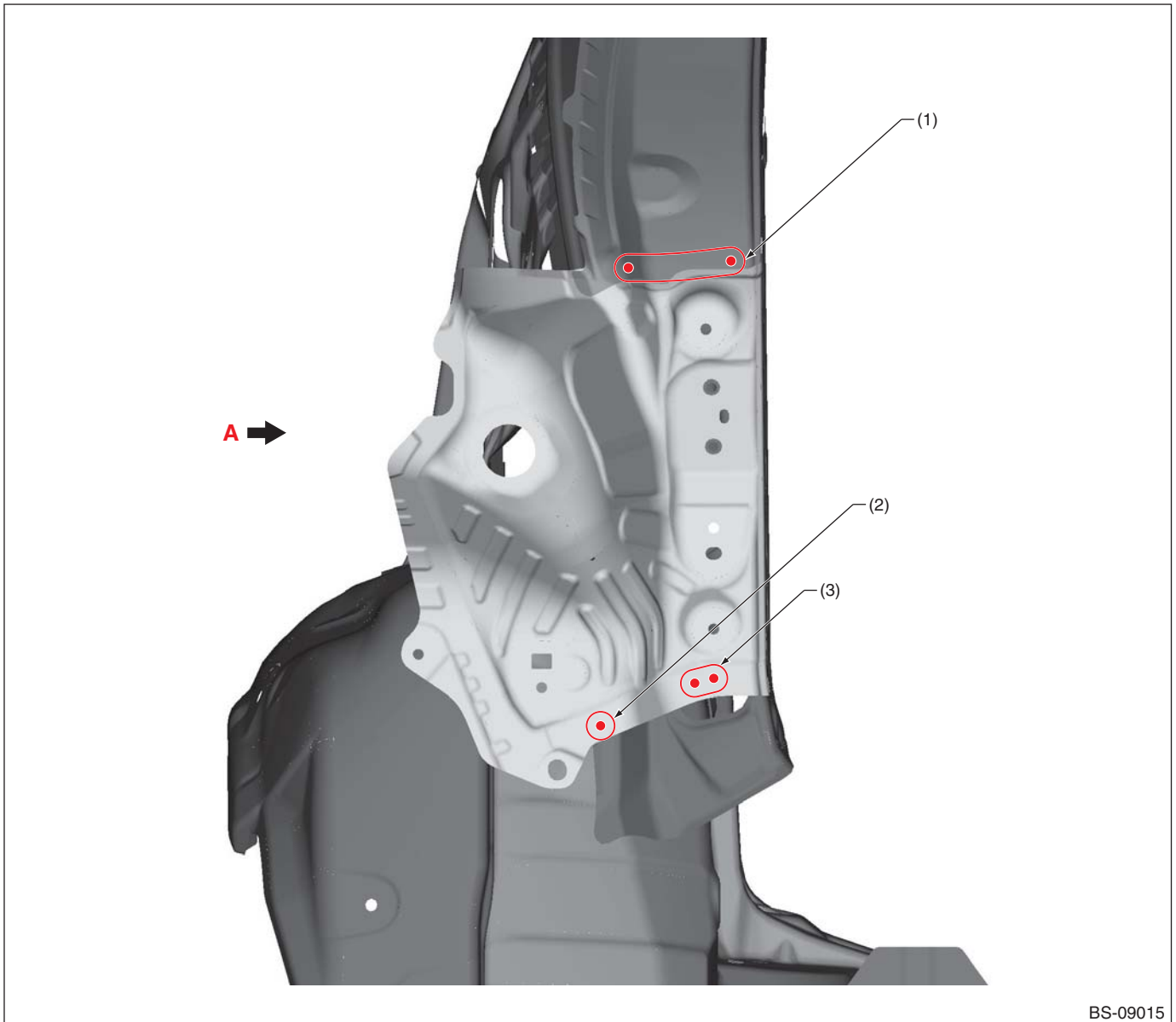
(2) 1 point

Panel Replacement

8-37. Rear Quarter End Panel (Total replacement) / 5D

A: REMOVAL

- Overall view



BS-09015

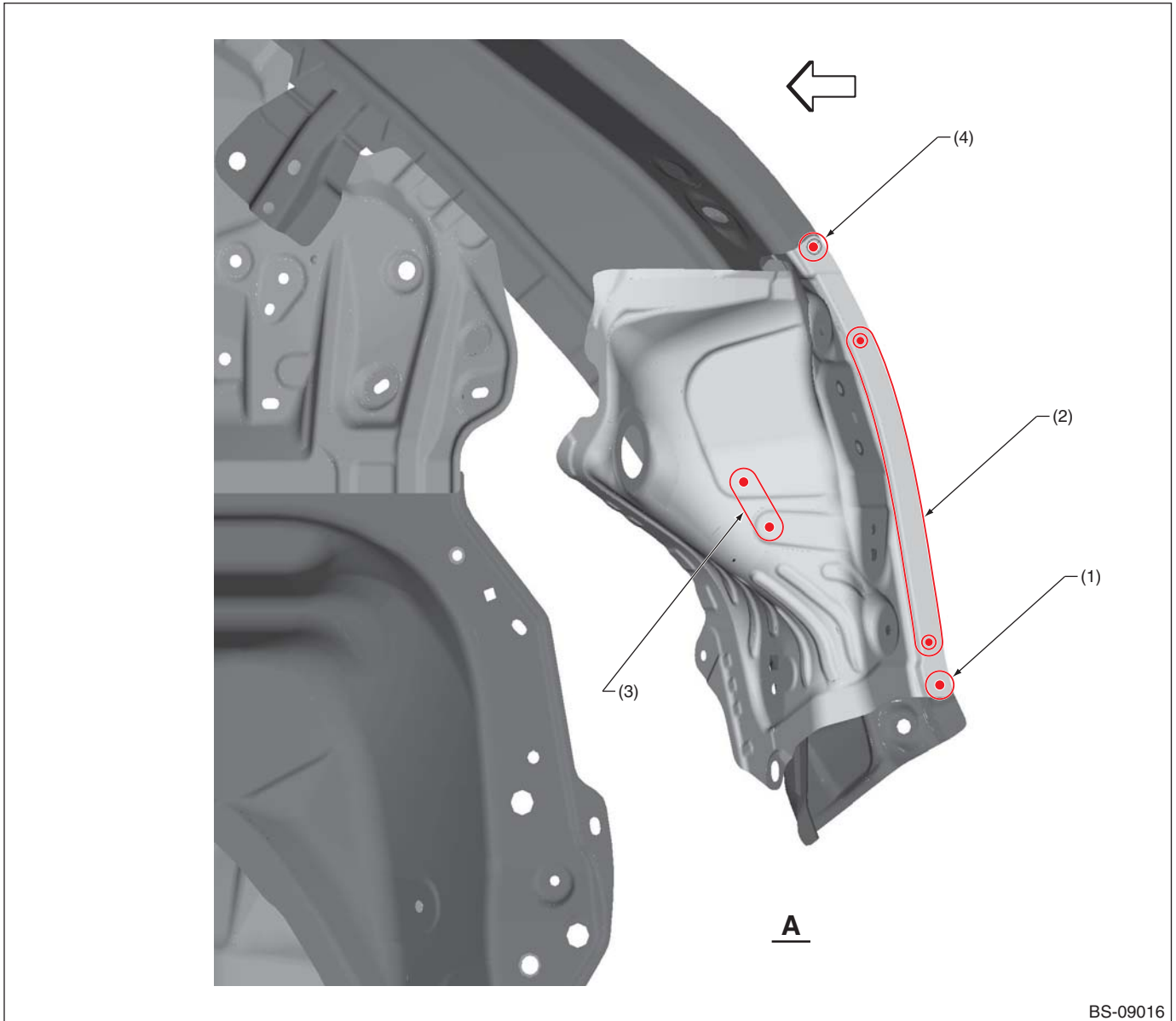
(1) 3 points (outside · 1)

(2) 1 point (outside · 1)

(3) 2 points (outside · 1)

Panel Replacement

• View A



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

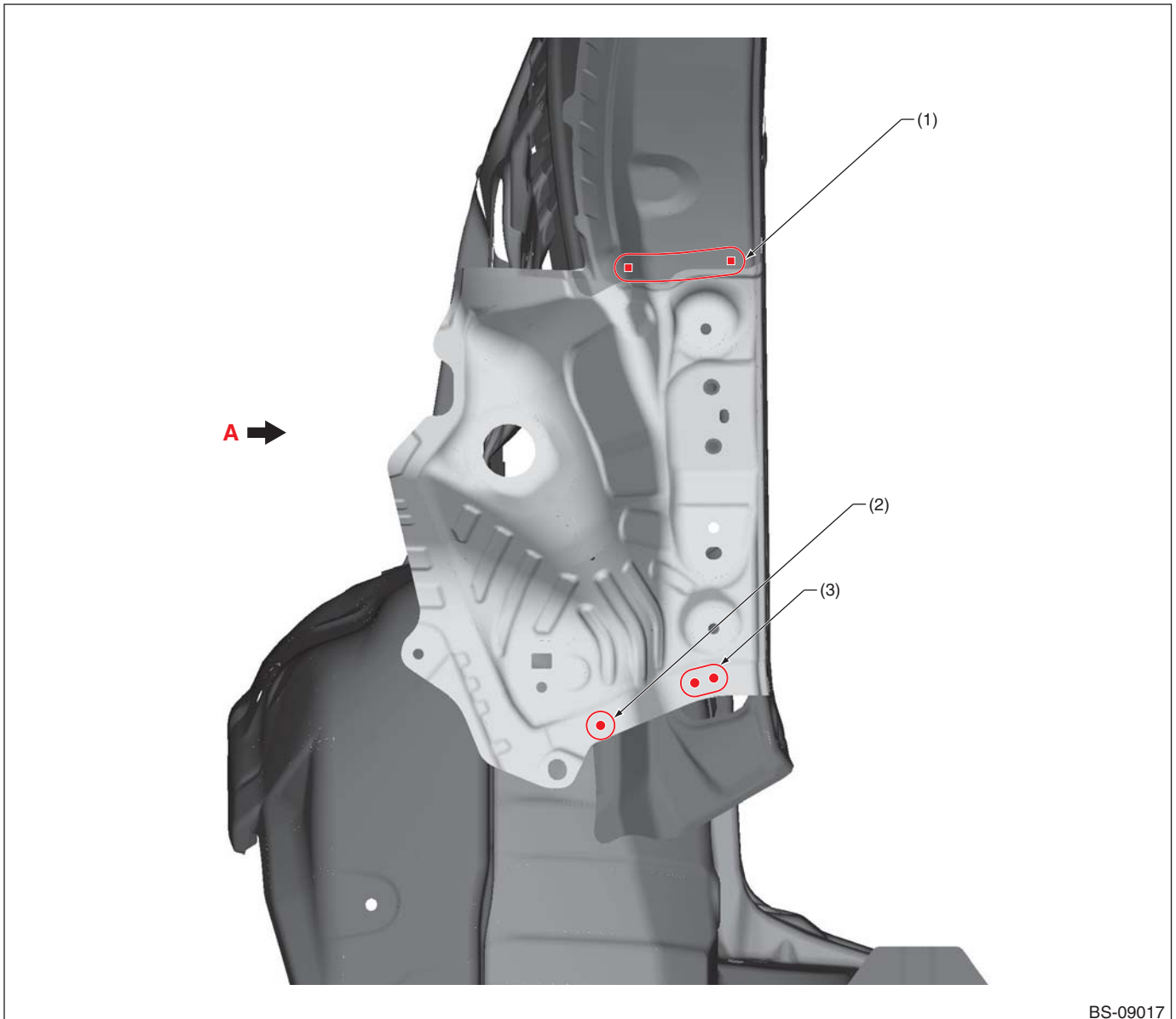
(3) 2 points (outside · 1)

(4) 1 point (outside · 1, belt sander)

Panel Replacement

B: INSTALLATION

• Overall view



BS-09017

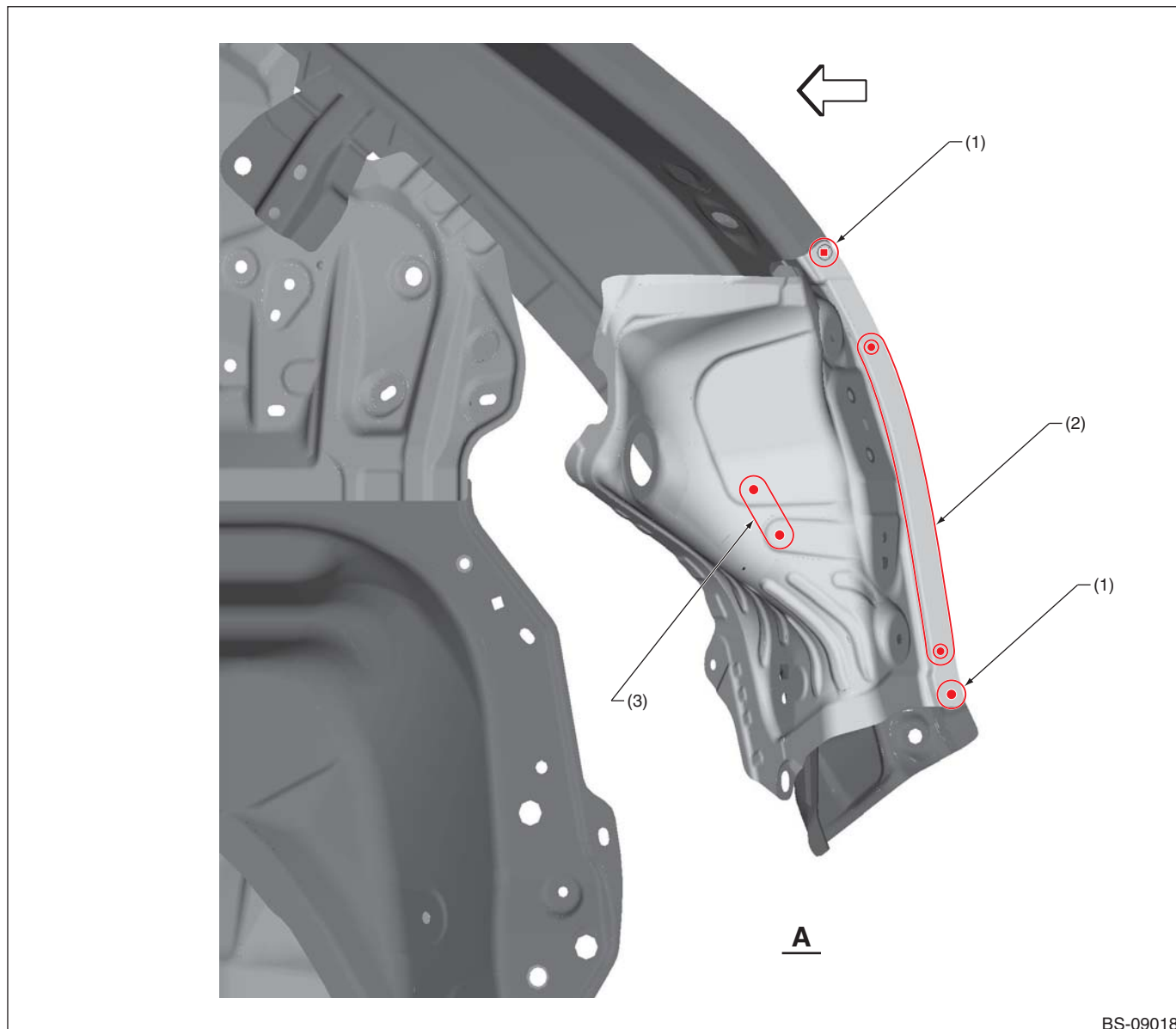
(1) 3 points

(2) 1 point

(3) 2 points

Panel Replacement

• View A



(1) 1 point

(2) 5 points

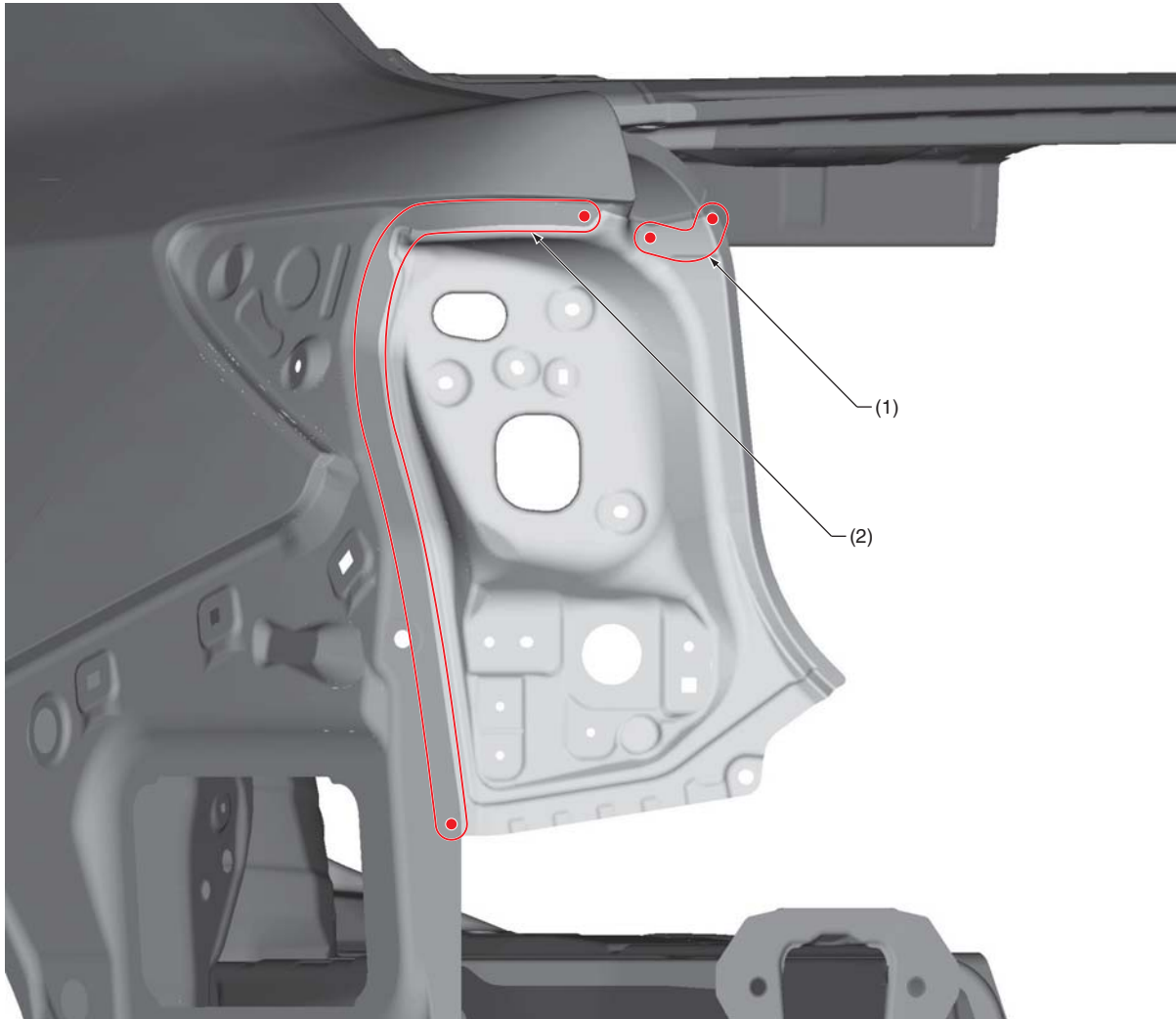
(3) 2 points

Panel Replacement

8-38. Rear Quarter End Panel (Total replacement) / 4D

A: REMOVAL

• Overall view



BS-08602

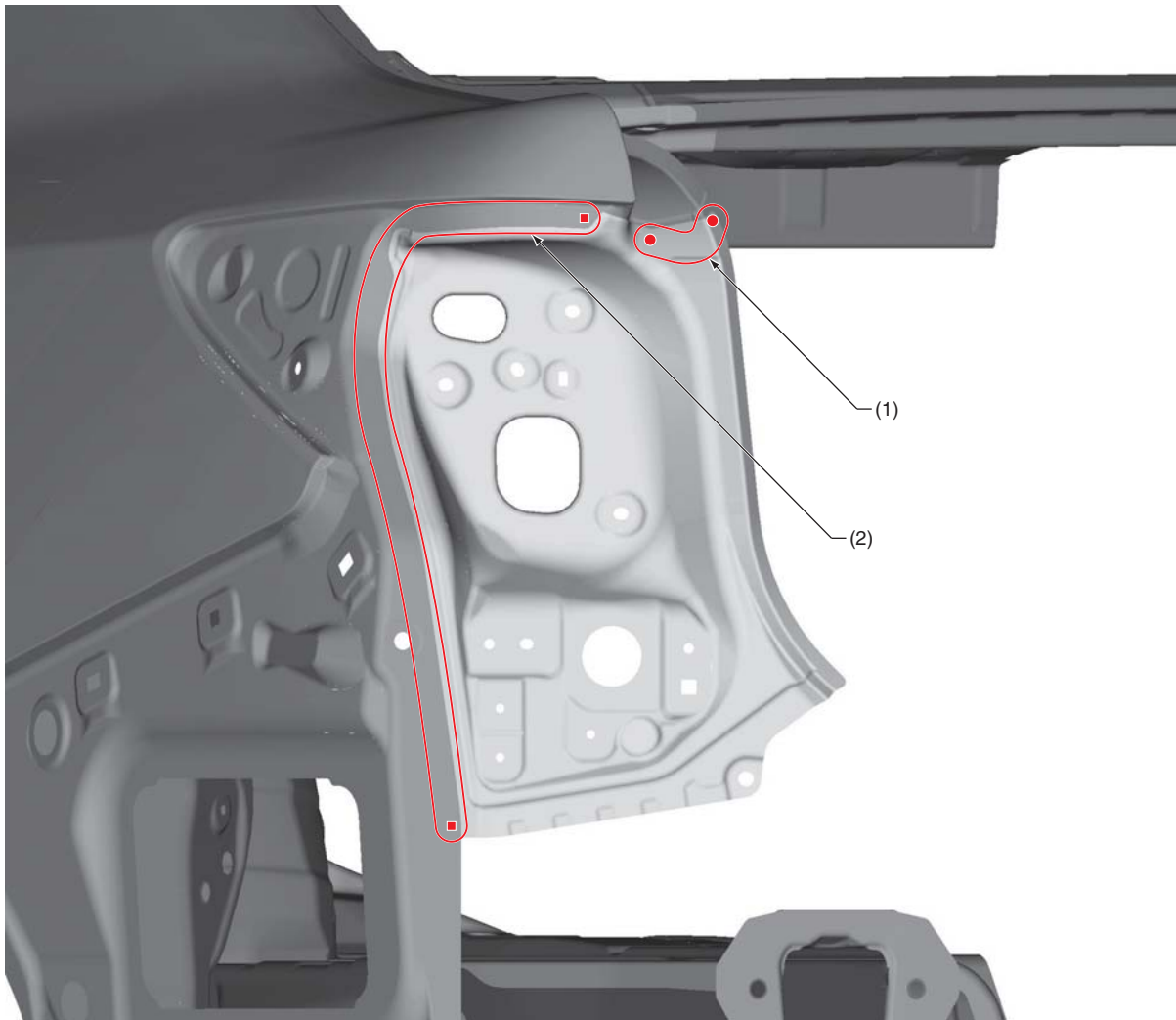
(1) 3 points (outside · 1)

(2) 12 points (outside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BS-08603

(1) 3 points

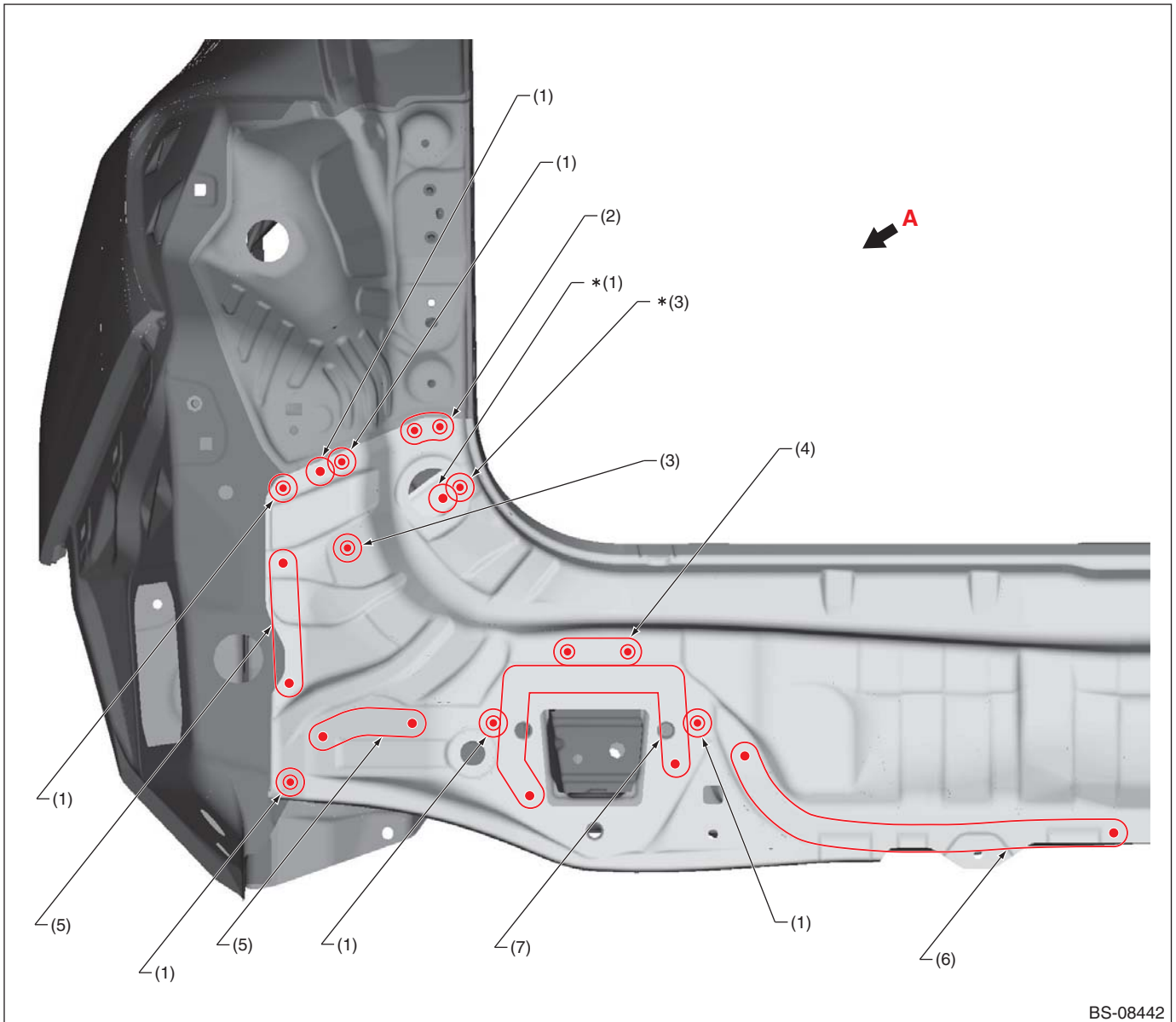
(2) 12 points

Panel Replacement

8-39. Rear Skirt (Total replacement) / 5D

A: REMOVAL

• Overall view



(1) 1 point (outside · 1)

(2) 2 points (outside · 1)

(3) 1 point (outside · 2)

(4) 2 points (outside · 2)

(5) 3 points (outside · 1)

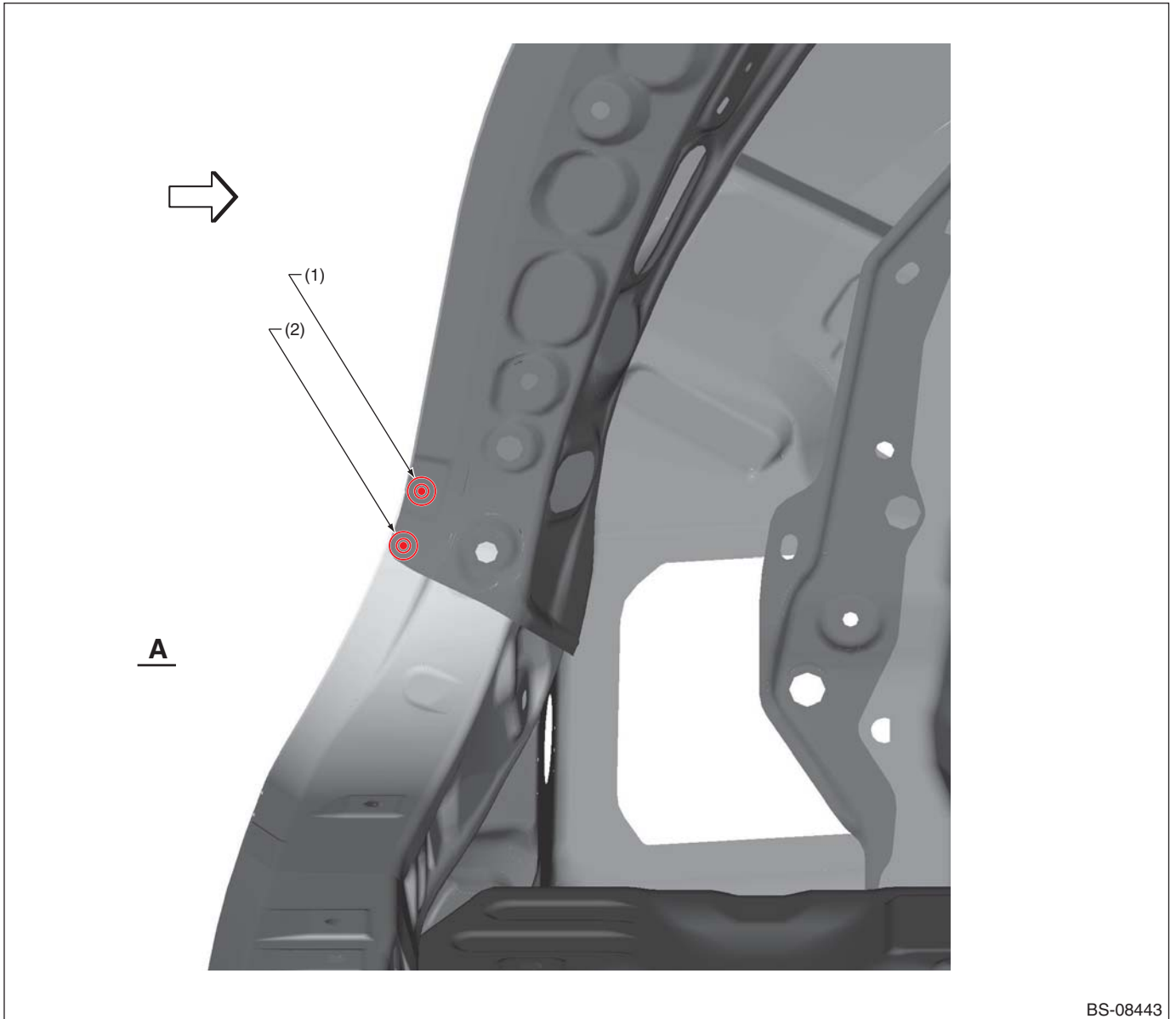
(6) 7 points (outside · 1)

(7) 5 points (outside · 1)

* : Spots are provided in the back.

Panel Replacement

• View A



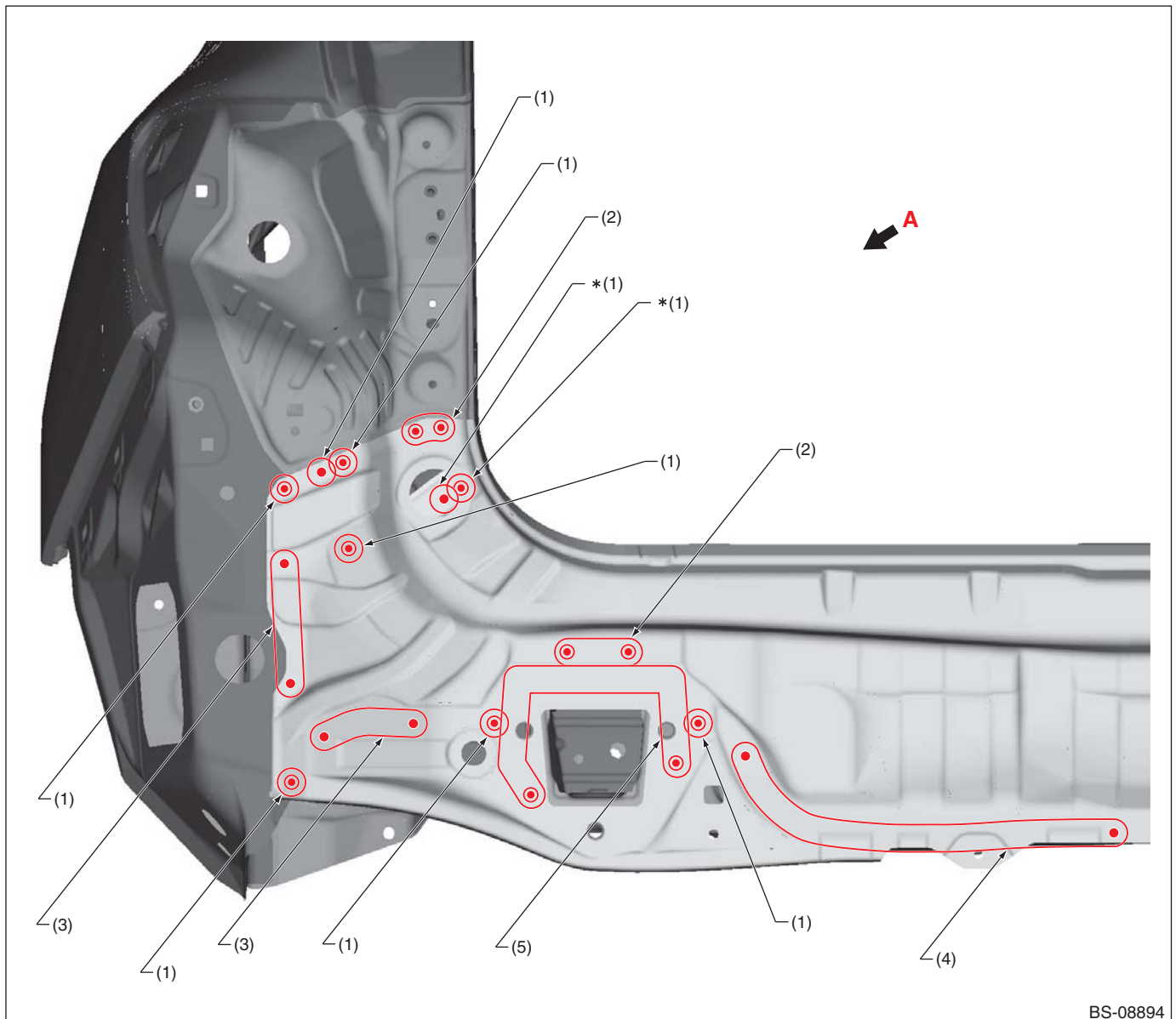
(1) 1 point (outside · 1)

(2) 1 point (outside · 2)

Panel Replacement

B: INSTALLATION

• Overall view



BS-08894

(1) 1 point
(2) 2 points

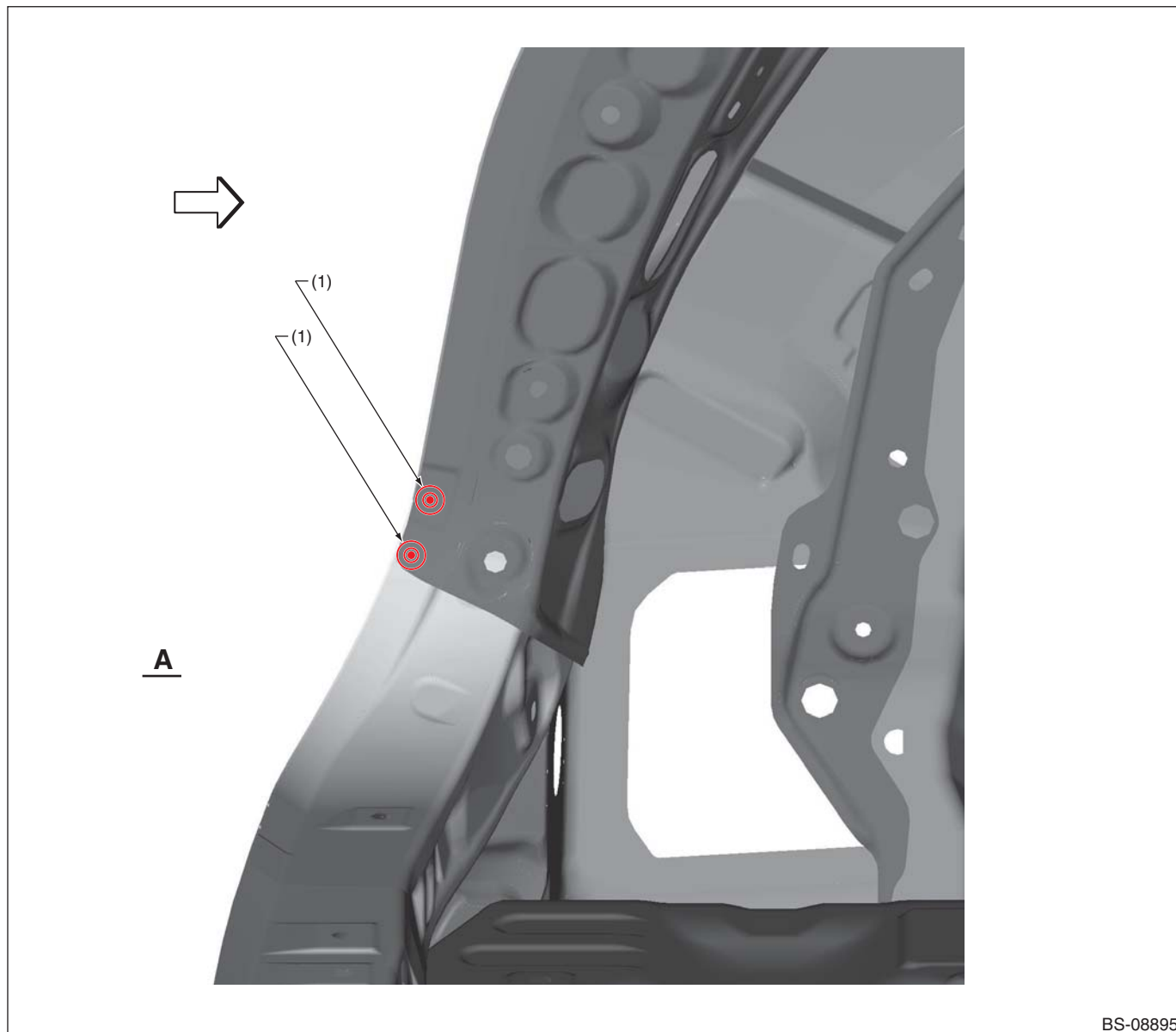
(3) 3 points
(4) 7 points

(5) 5 points

* : Spots are provided in the back.

Panel Replacement

• View A



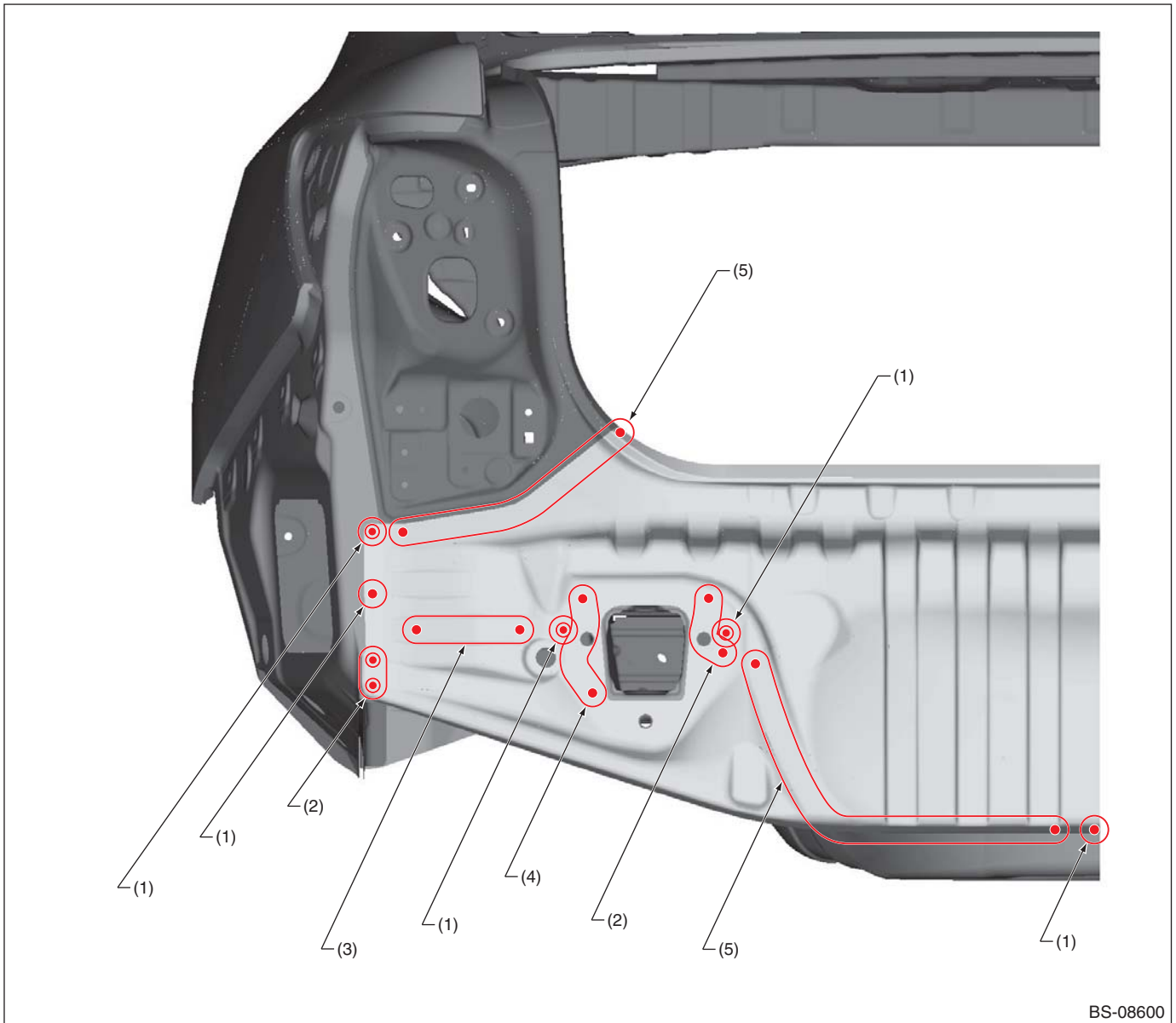
(1) 1 point

Panel Replacement

8-40. Rear Skirt (Total replacement) / 4D

A: REMOVAL

• Overall view



(1) 1 point (outside · 1)

(2) 2 points (outside · 1)

(3) 4 points (outside · 1)

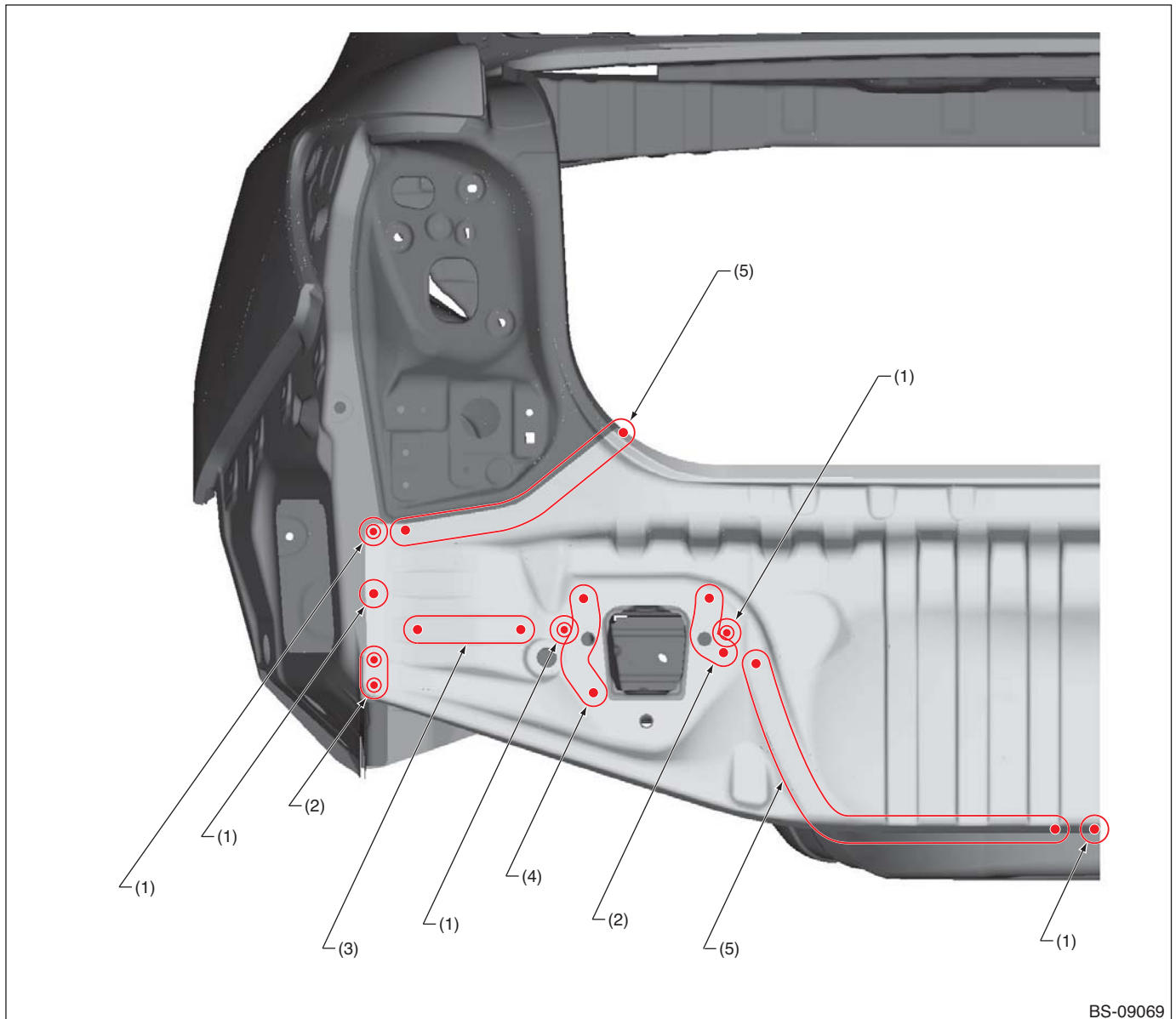
(4) 3 points (outside · 1)

(5) 9 points (outside · 1)

Panel Replacement

B: INSTALLATION

• Overall view

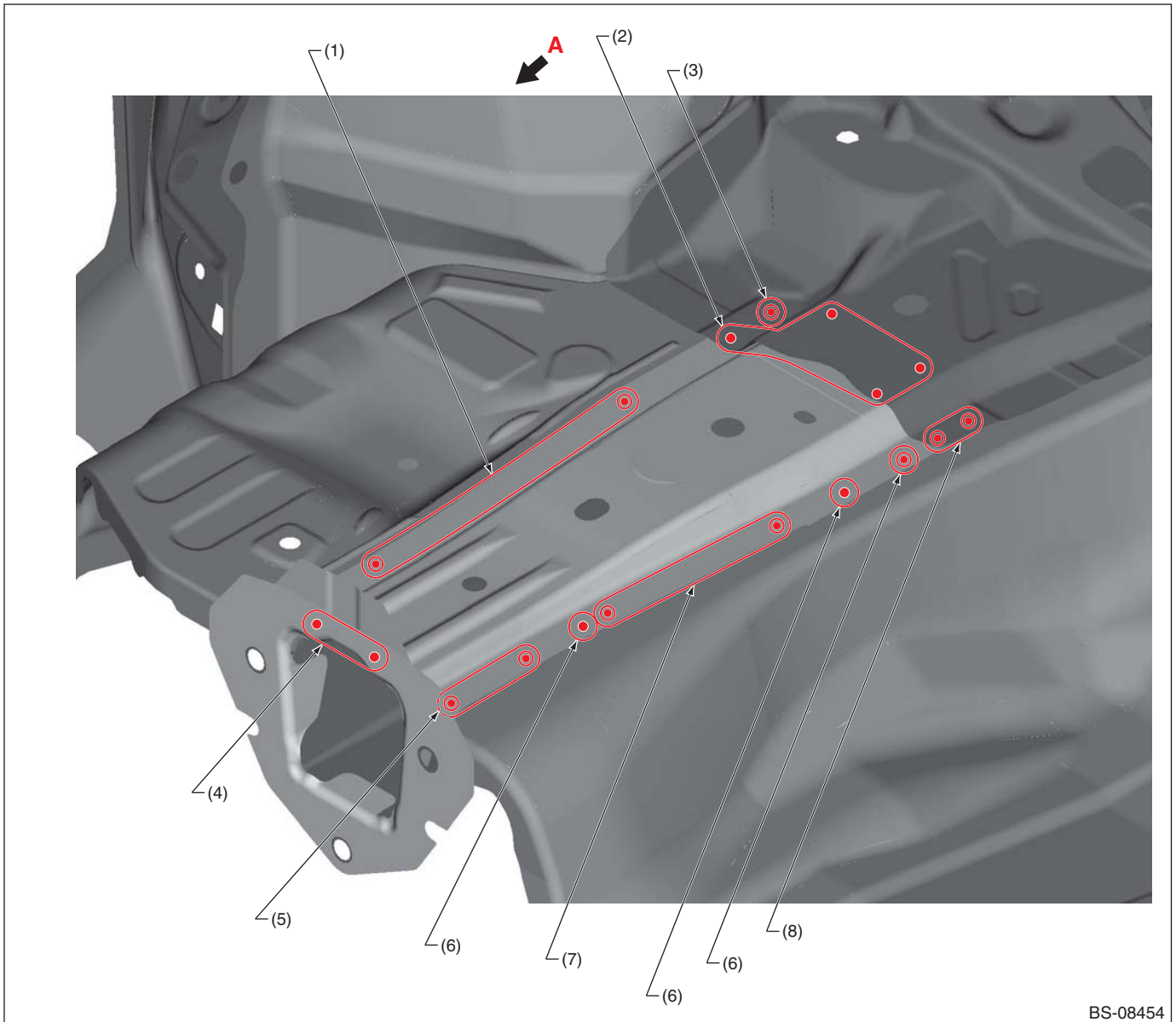


Panel Replacement

8-41. Rear Side Frame Upper Rear (Total replacement) / 5D

A: REMOVAL

• Overall view



BS-08454

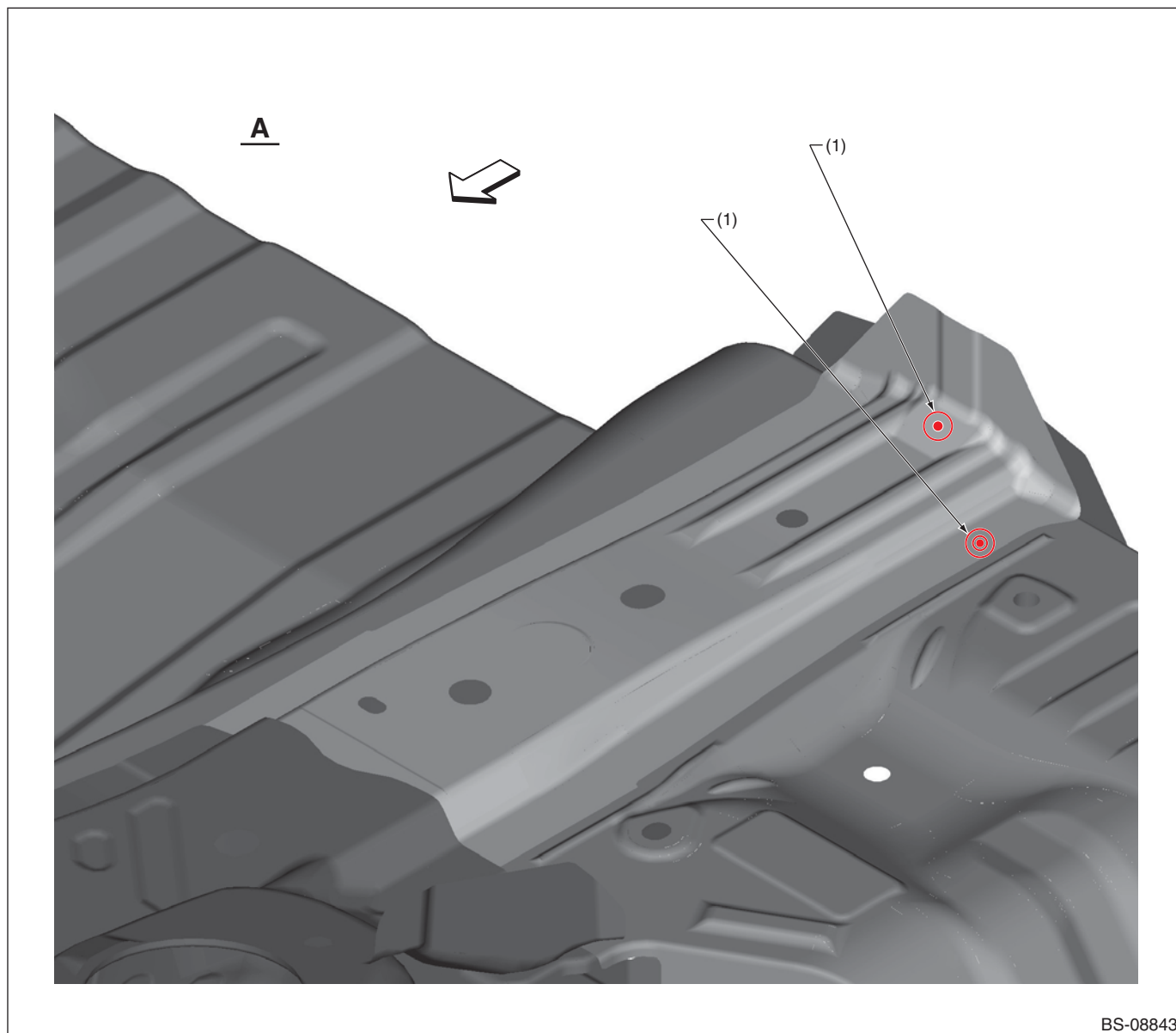
- (1) 5 points (top · 1)
- (2) 6 points (top · 1)
- (3) 1 point (top · 2)

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

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

Panel Replacement

• View A



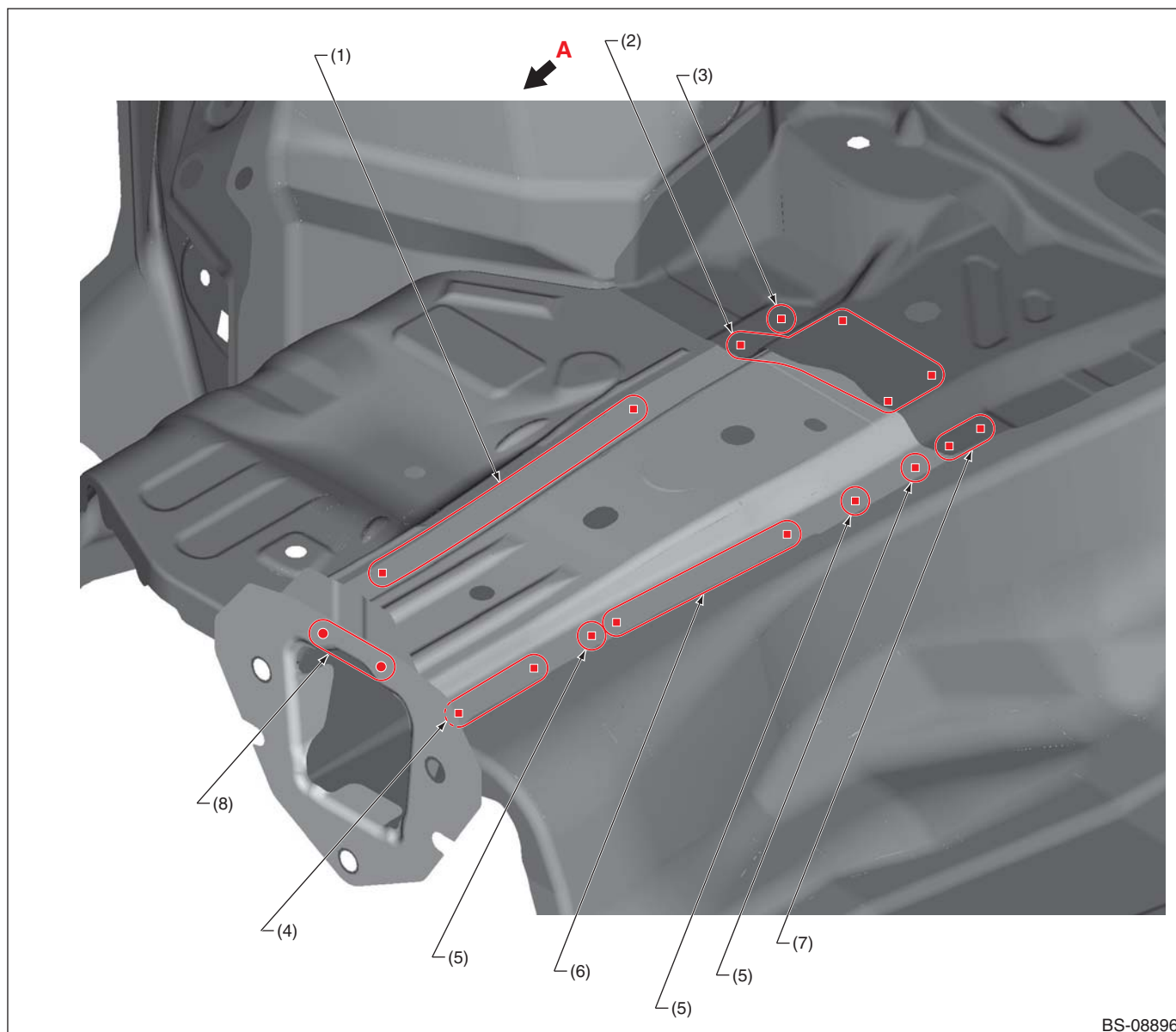
BS-08843

(1) 1 point (top · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BS-08896

(1) 5 points (service)

(2) 6 points

(3) 1 point (service · matching)

(4) 2 points (service)

(5) 1 point (service)

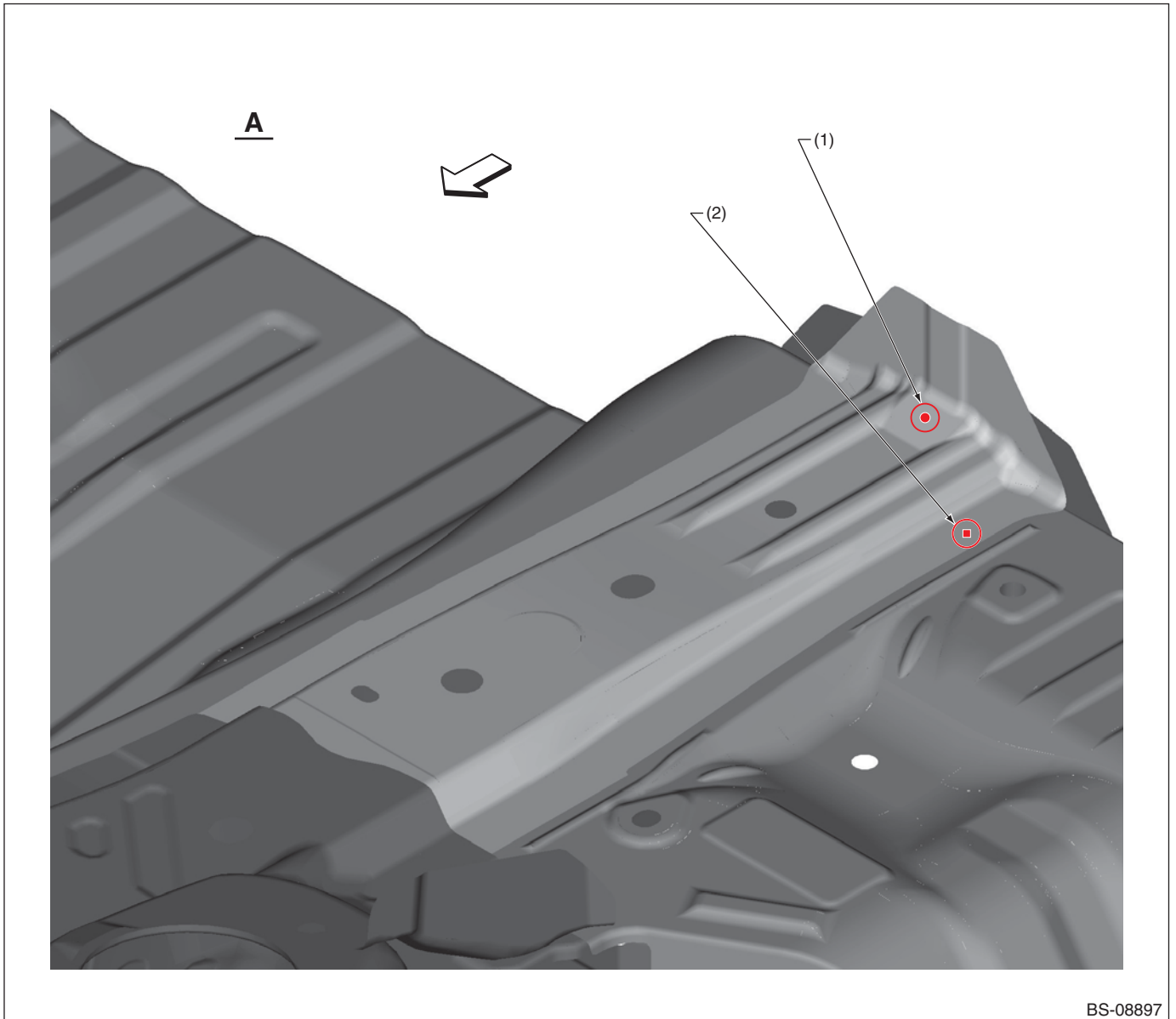
(6) 3 points (service)

(7) 2 points (service · matching)

(8) 2 points

Panel Replacement

• View A



BS-08897

(1) 1 point

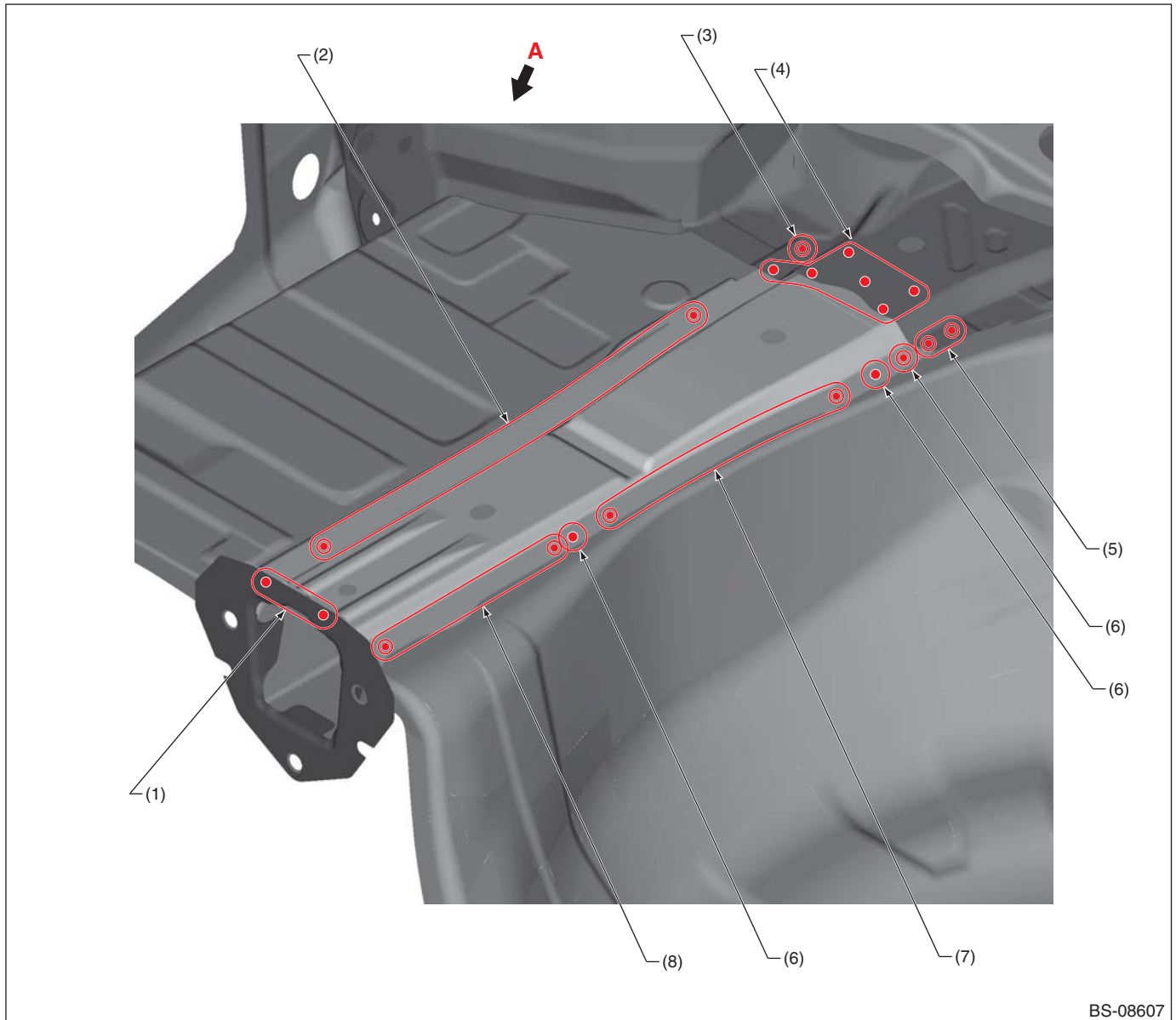
(2) 1 point (service)

Panel Replacement

8-42. Rear Side Frame Upper Rear (Total replacement) / 4D

A: REMOVAL

• Overall view



BS-08607

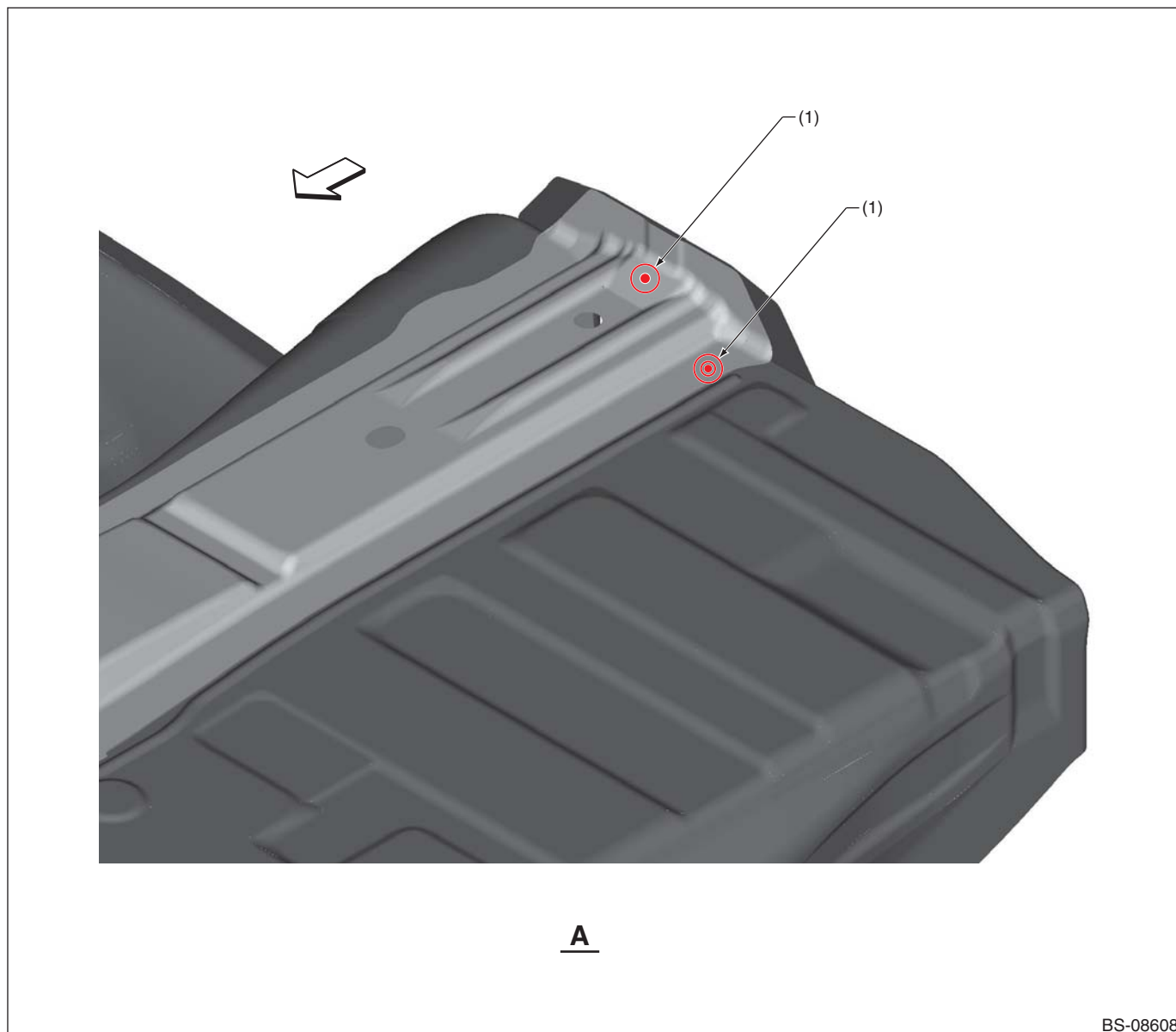
- (1) 2 points (inside · 1)
- (2) 8 points (top · 1)
- (3) 1 point (top · 2)

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

- (7) 5 points (top · 1)
- (8) 4 points (top · 1)

Panel Replacement

• View A

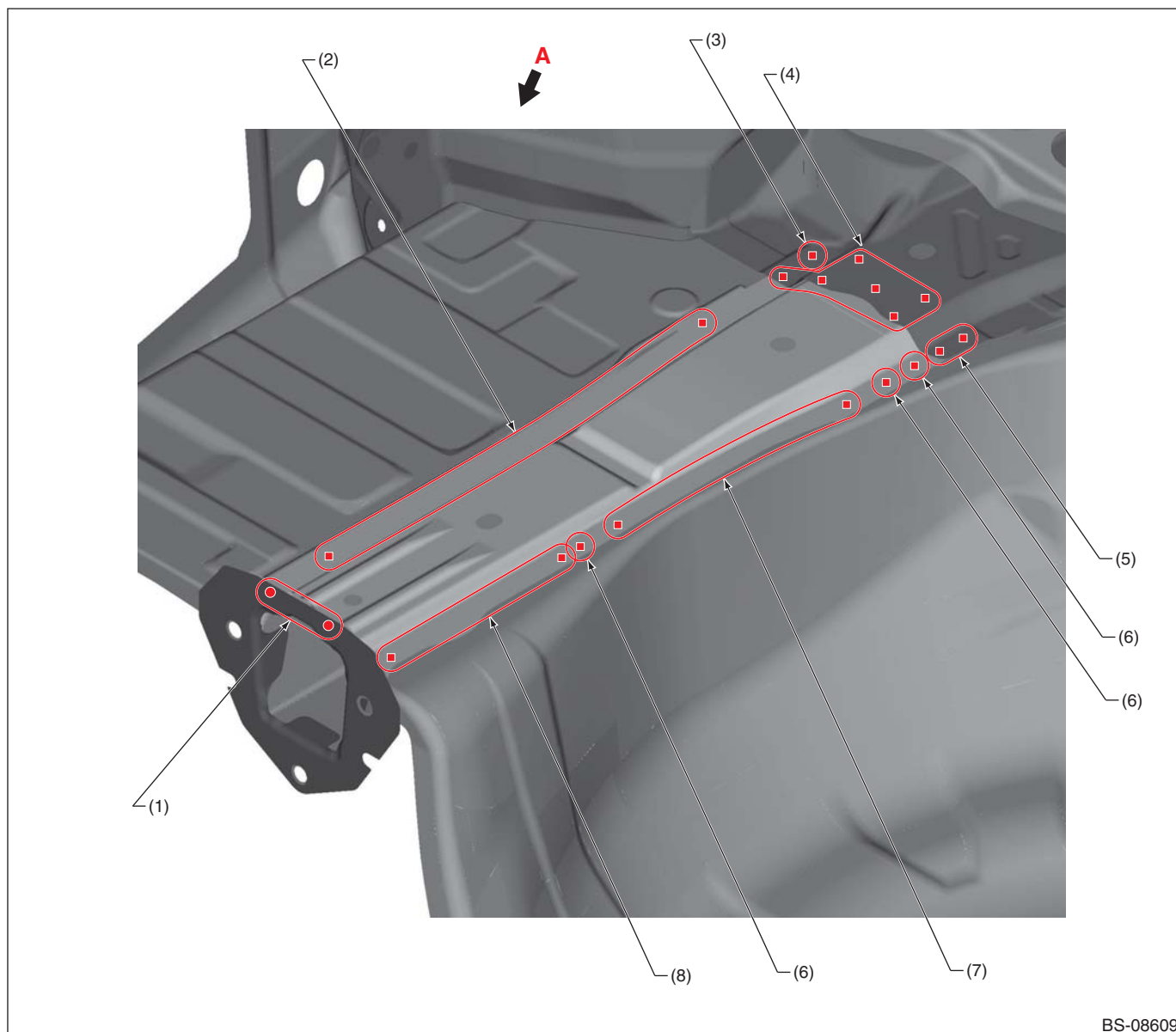


(1) 1 point (top · 1)

Panel Replacement

B: INSTALLATION

• Overall view



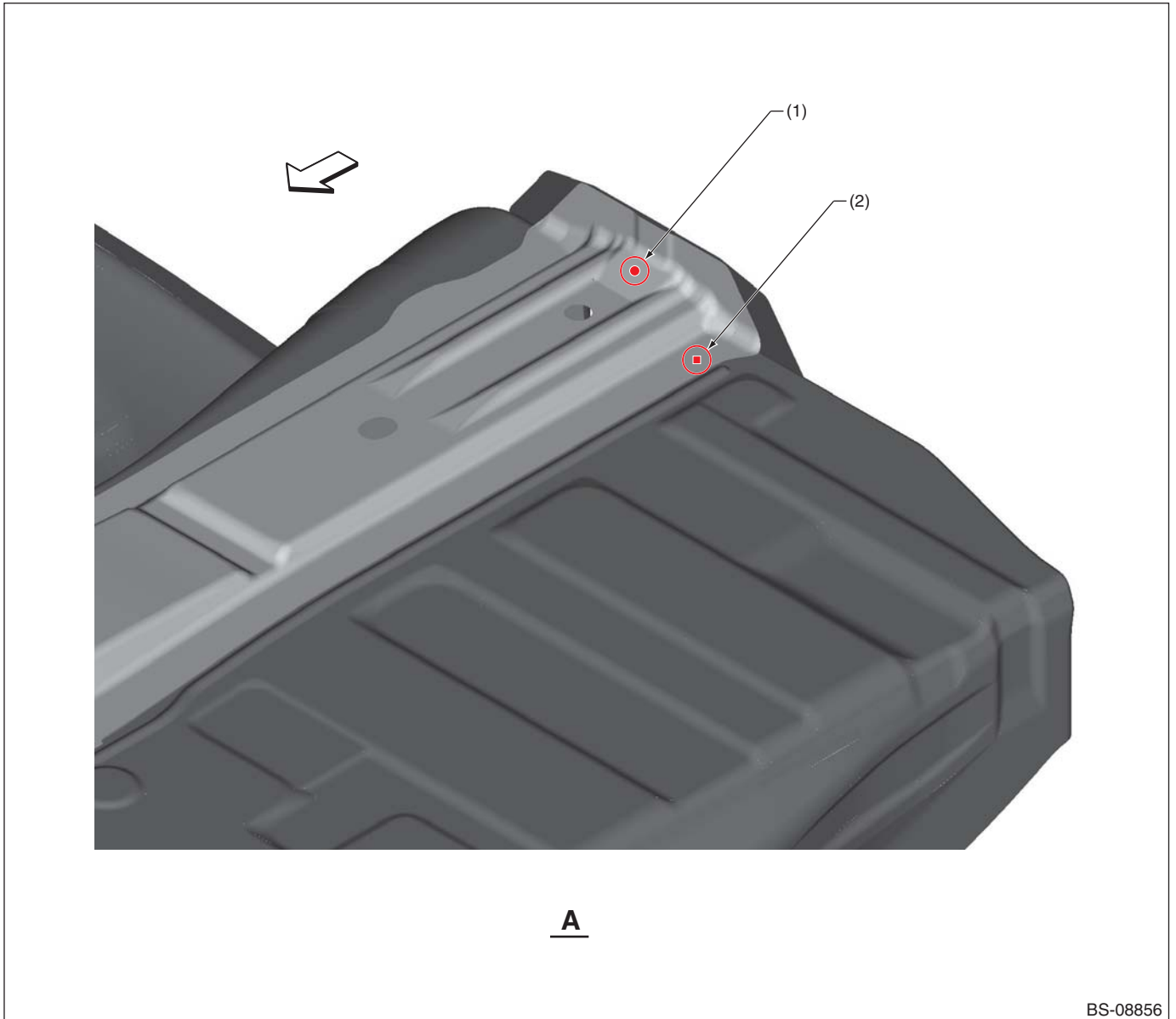
- (1) 2 points
- (2) 8 points (service)
- (3) 1 point (service · matching)

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

- (7) 5 points (service)
- (8) 4 points (service)

Panel Replacement

• View A



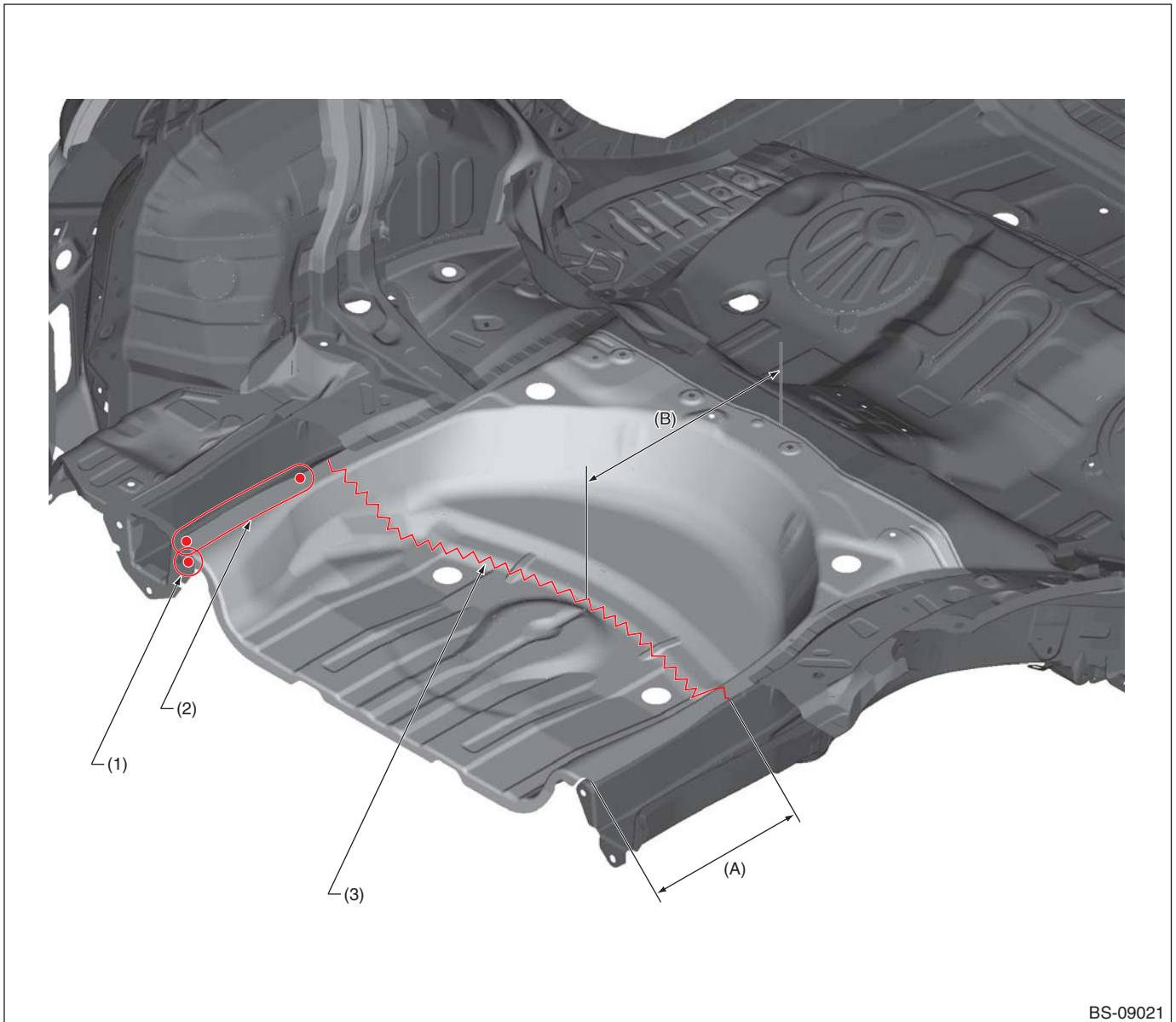
(1) 1 point

(2) 1 point (service)

8-43. Rear Floor Pan (Partial replacement) / 5D

A: REMOVAL

• Overall view



BS-09021

(A) 290 mm [11.42 in]

(B) 350 mm [13.78 in]

(1) 1 point (inside · 1, belt sander)

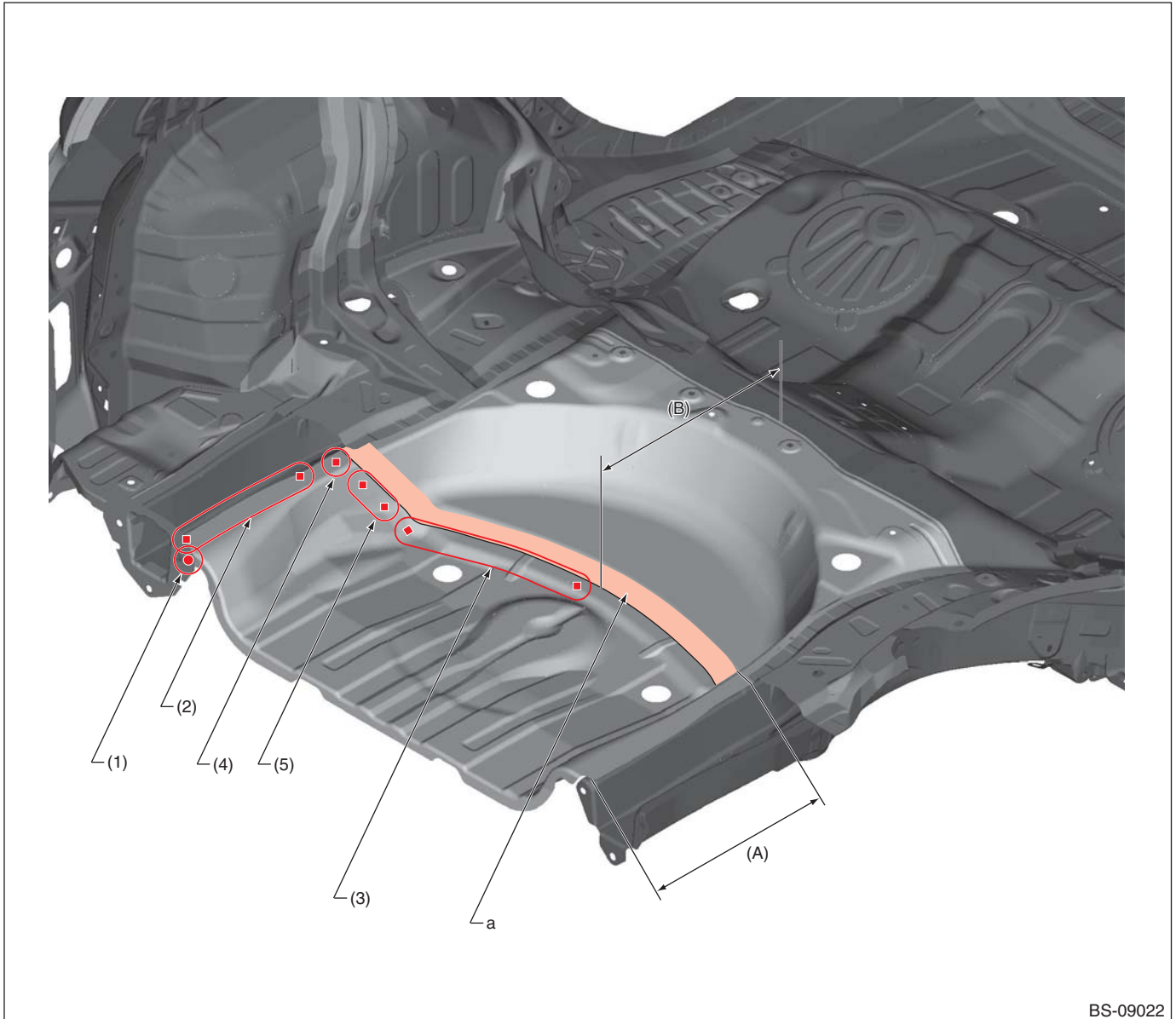
(2) 5 points (top · 1)

(3) Cut position
(Cut along the rear end of the rear
floor cross member C.)

Panel Replacement

B: INSTALLATION

• Overall view



BS-09022

(A) 310 mm [12.20 in]

(B) 325 mm [12.80 in]

(1) 1 point

(3) 6 points (service)

(5) 2 points (service)

(2) 5 points (service)

(4) 1 point (service)

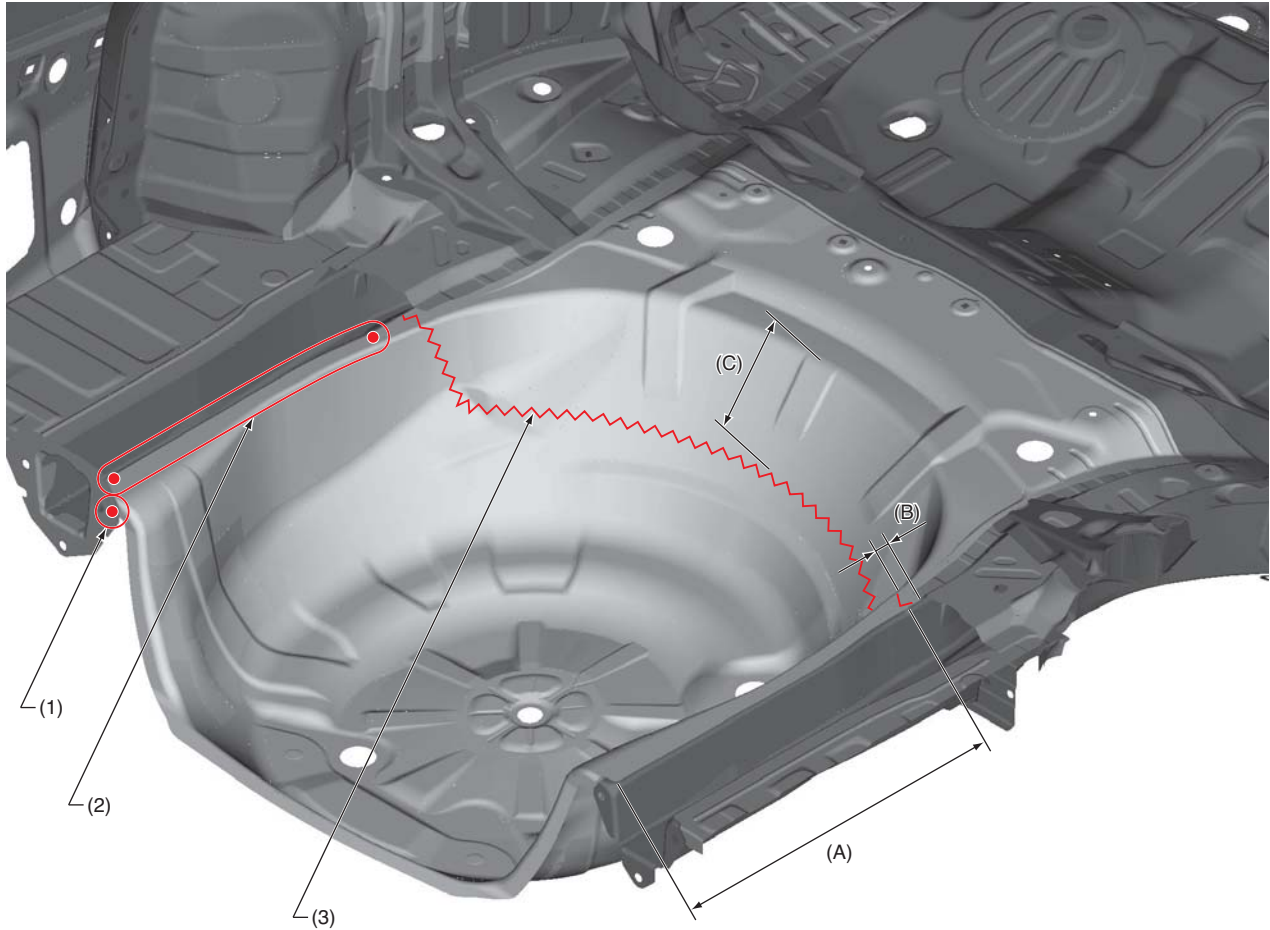
Note: Apply sealing agent to the floor pan fitting parts (front and rear) of section "a".

Panel Replacement

8-44. Rear Floor Pan (Partial replacement) / 4D

A: REMOVAL

• Overall view



BS-09070

(A) 455 mm [17.91 in]

(B) 25 mm [0.98 in]

(C) 160 mm [6.3 in]

(1) 1 point (inside · 1, belt sander)

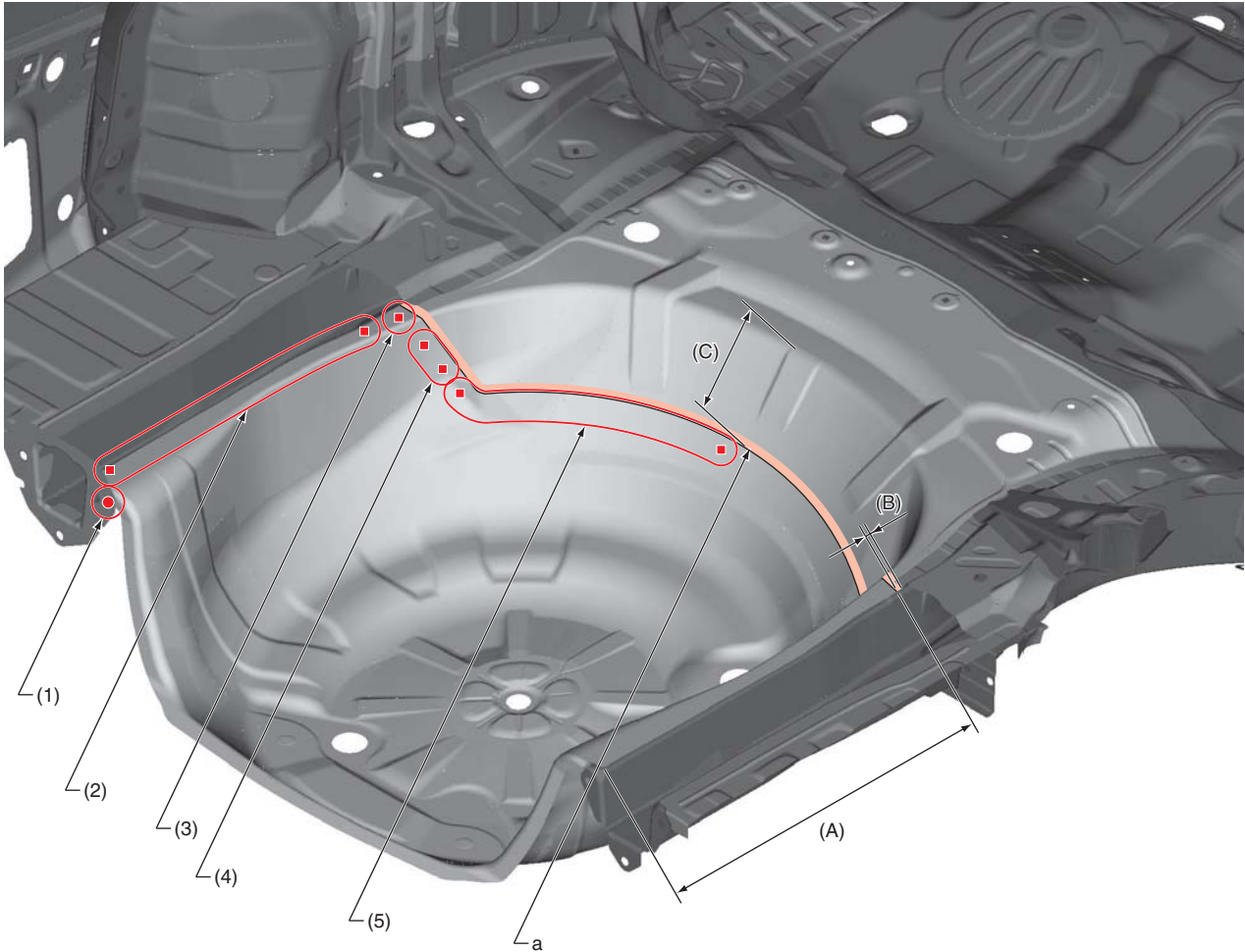
(2) 9 points (top · 1)

(3) Cut position

Panel Replacement

B: INSTALLATION

• Overall view



BS-09071

(A) 475 mm [18.7 in]

(B) 5 mm [0.2 in]

(C) 140 mm [5.51 in]

(1) 1 point

(3) 1 point (service)

(5) 6 points (service)

(2) 9 points (service)

(4) 2 points (service)

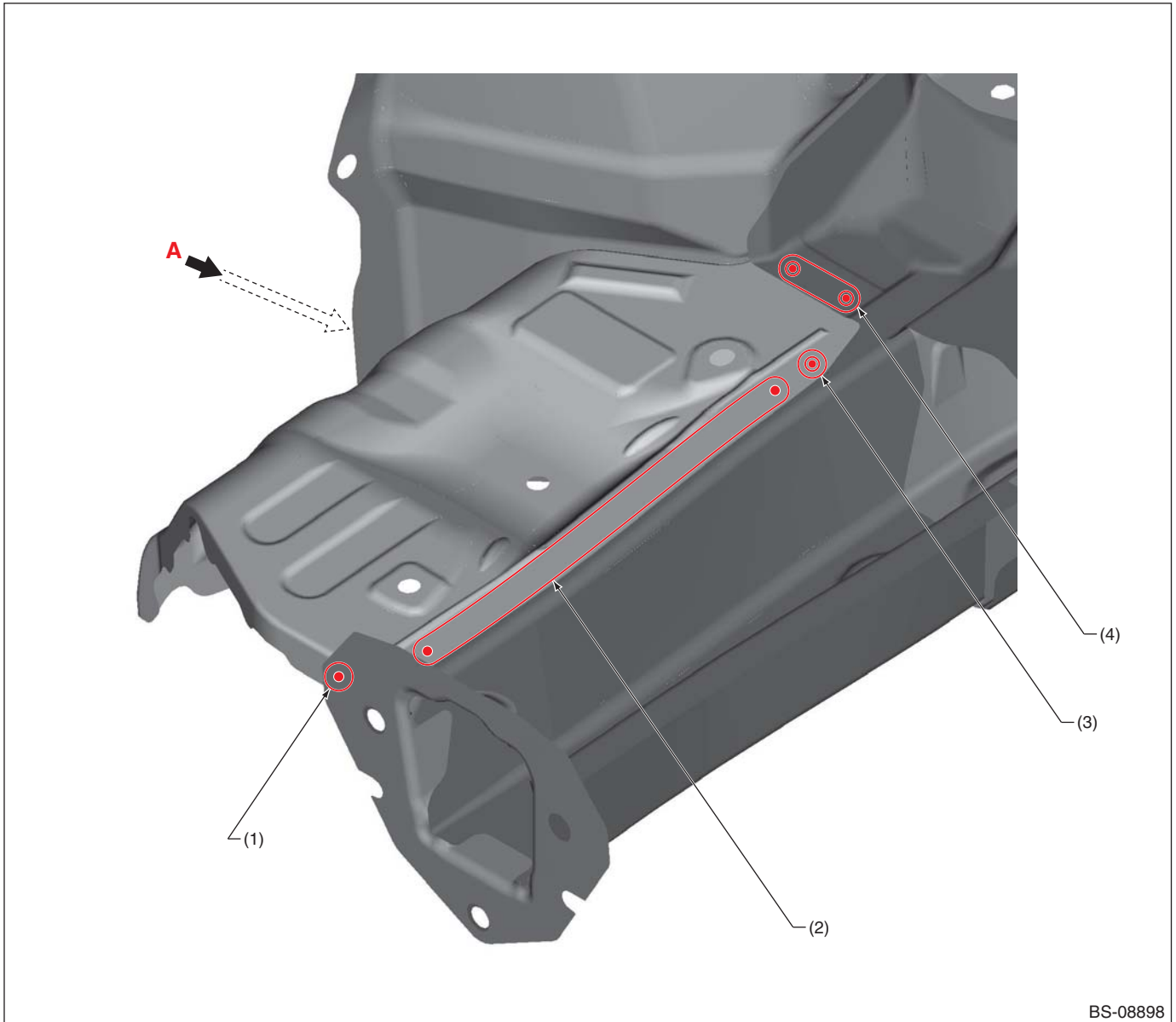
Note: Apply sealing agent to the floor pan fitting parts (front and rear) of section "a".

Panel Replacement

8-45. Rear Floor Side (Total replacement) / 5D

A: REMOVAL

• Overall view



BS-08898

(1) 1 point (inside · 1, belt sander)

(3) 1 point (top · 1)

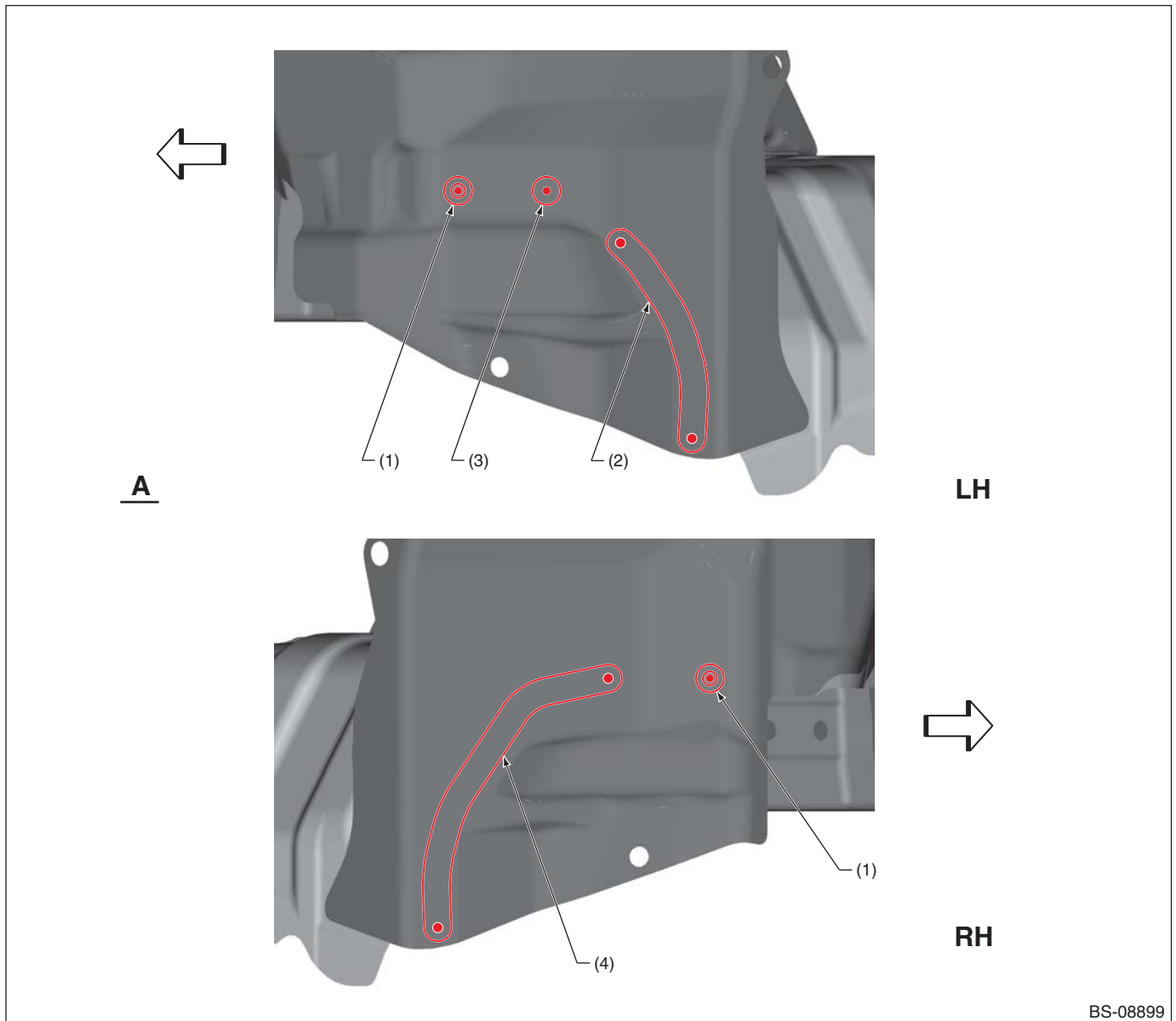
(4) LH: 2 points (top · 2)

(2) 7 points (top · 1)

RH: 1 point (top · 2)

Panel Replacement

• View A



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

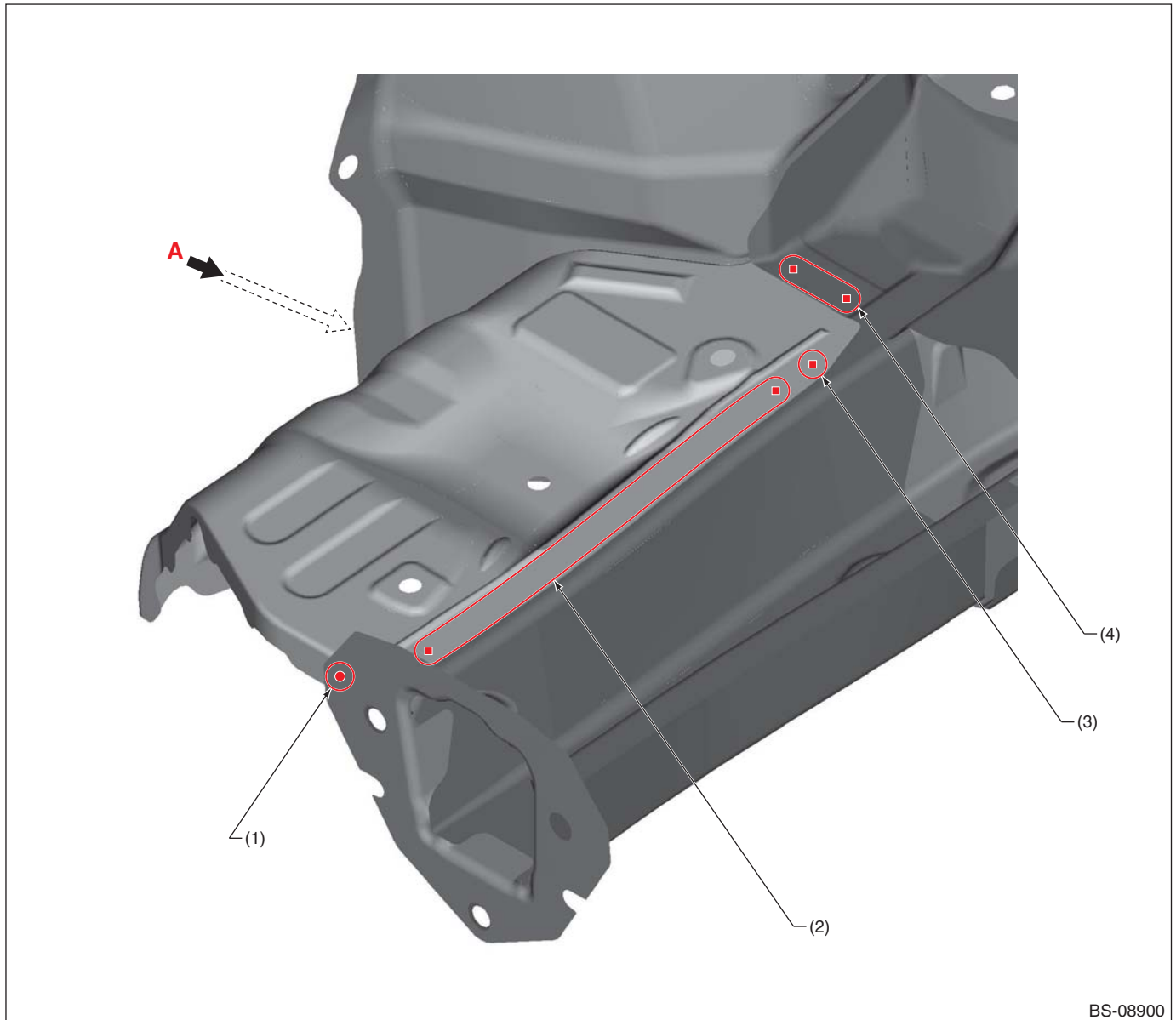
(3) 1 point (outside · 1)

(4) 5 points (inside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



(1) 1 point

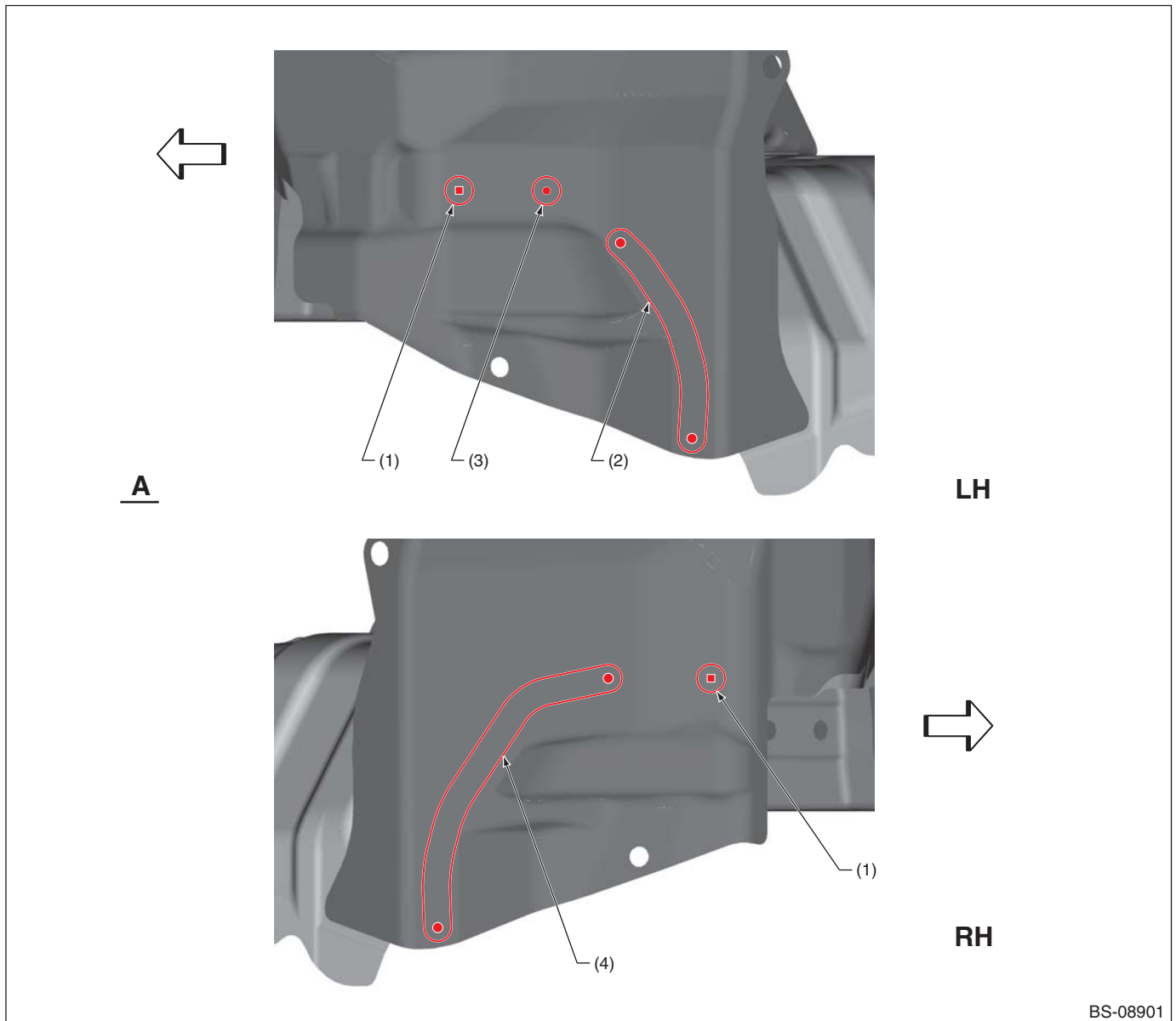
(2) 7 points (service)

(3) 1 point (service)

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

Panel Replacement

• View A

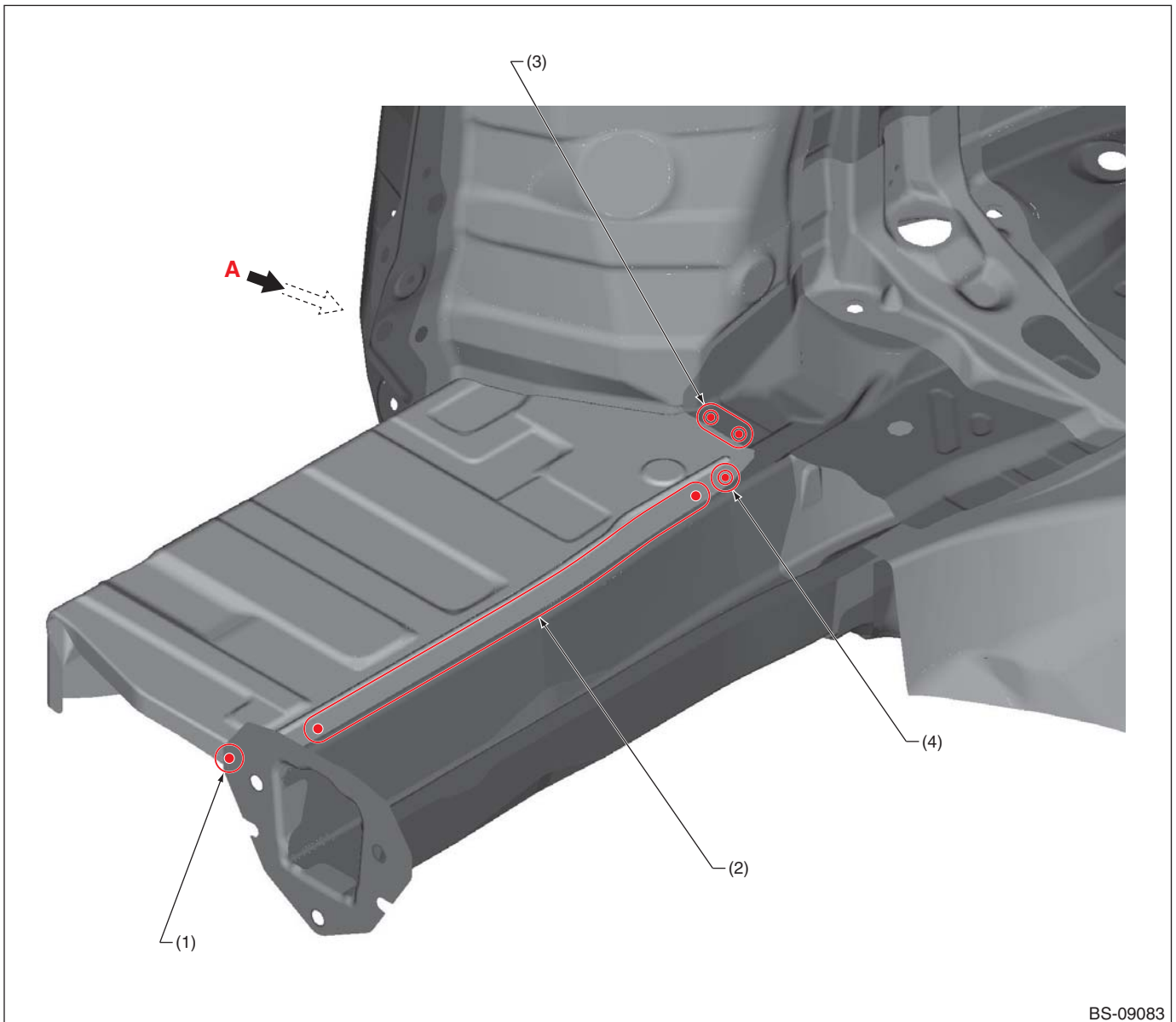


Panel Replacement

8-46. Rear Floor Side (Total replacement) / 4D

A: REMOVAL

• Overall view



BS-09083

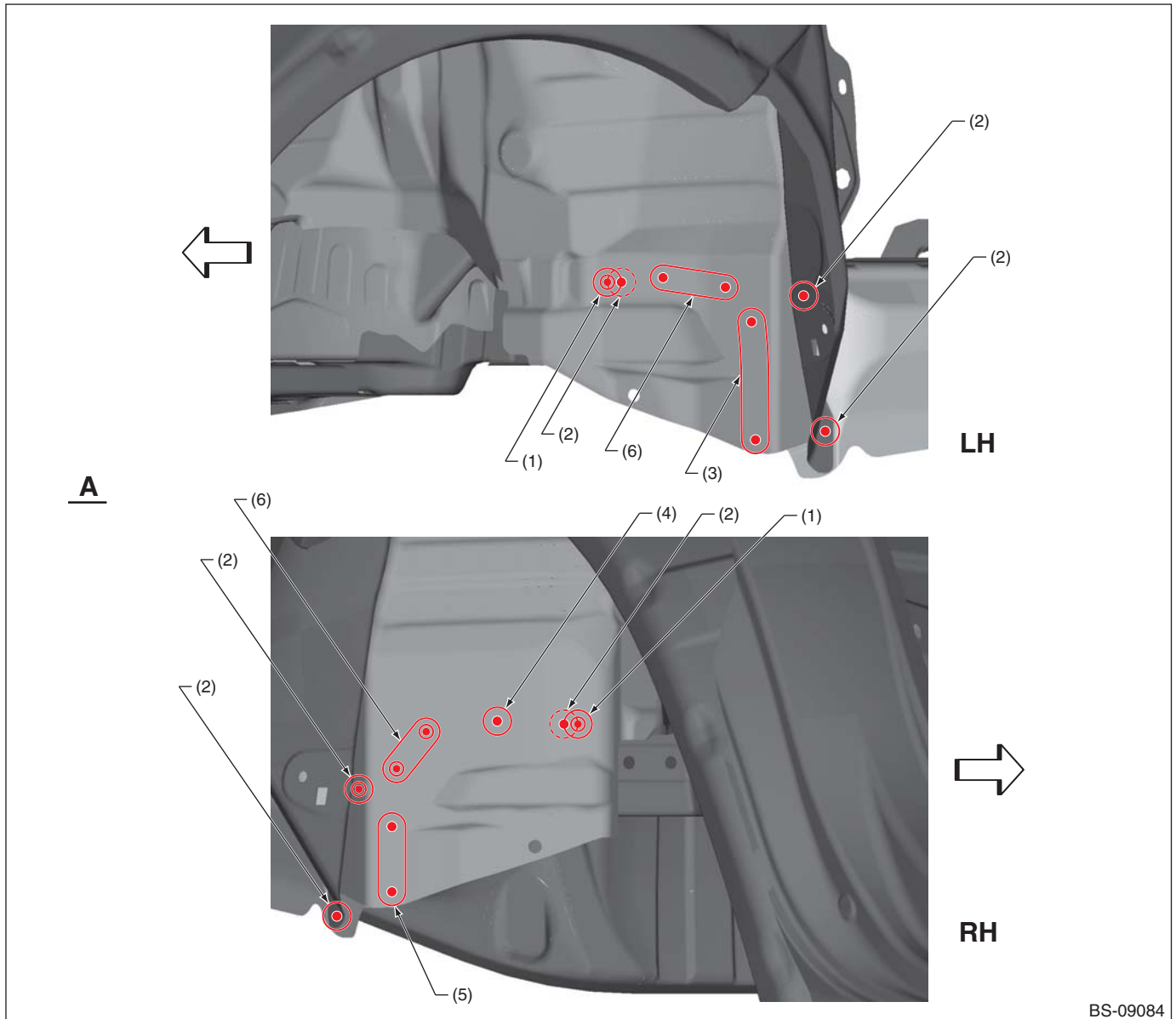
(1) 1 point (inside · 1, belt sander)
(2) 10 points (top · 1)

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

(4) 1 point (top · 1)

Panel Replacement

• View A



BS-09084

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

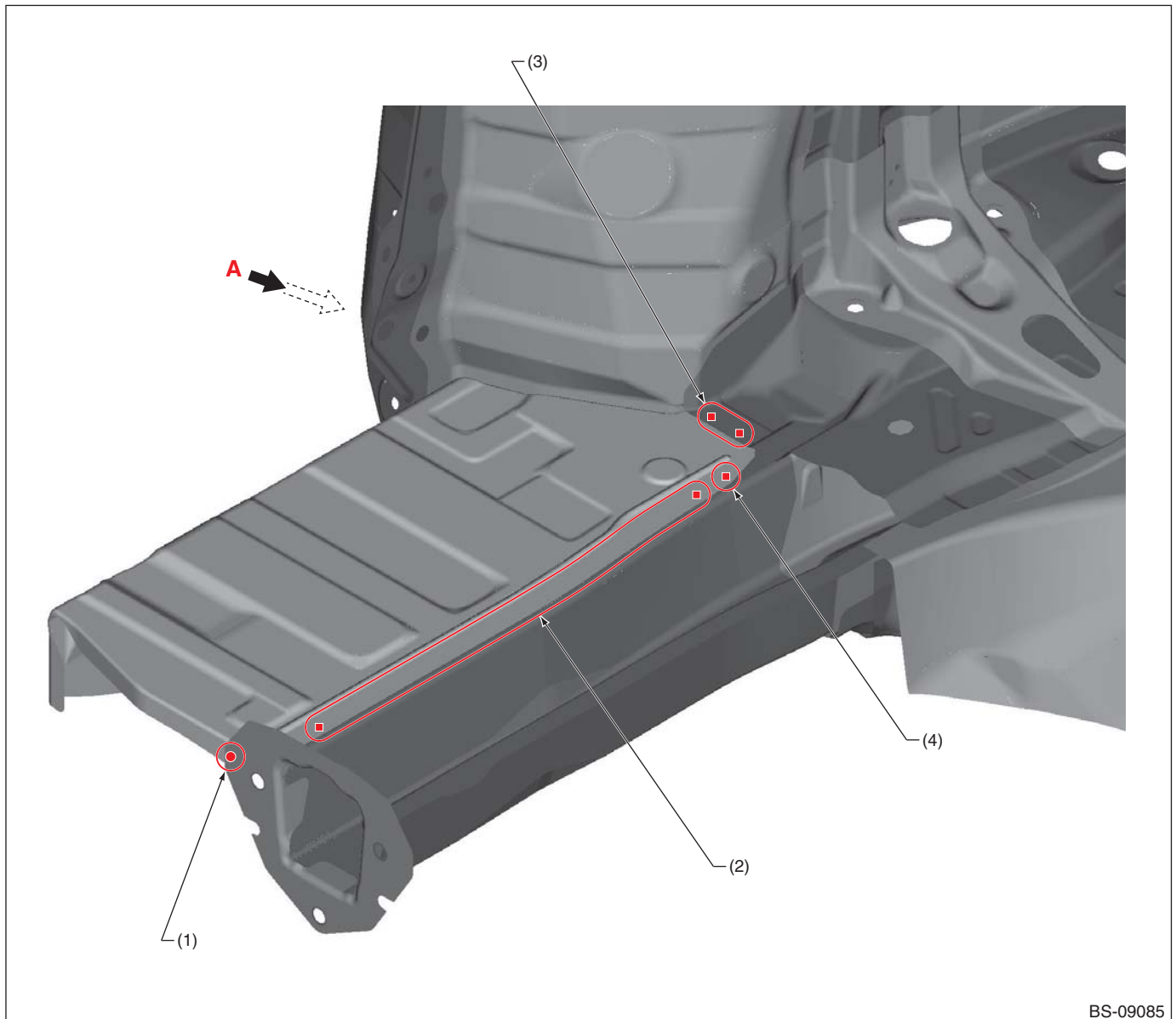
(3) 3 points (inside · 1)
(4) 1 point (outside · 1)

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

Panel Replacement

B: INSTALLATION

• Overall view



BS-09085

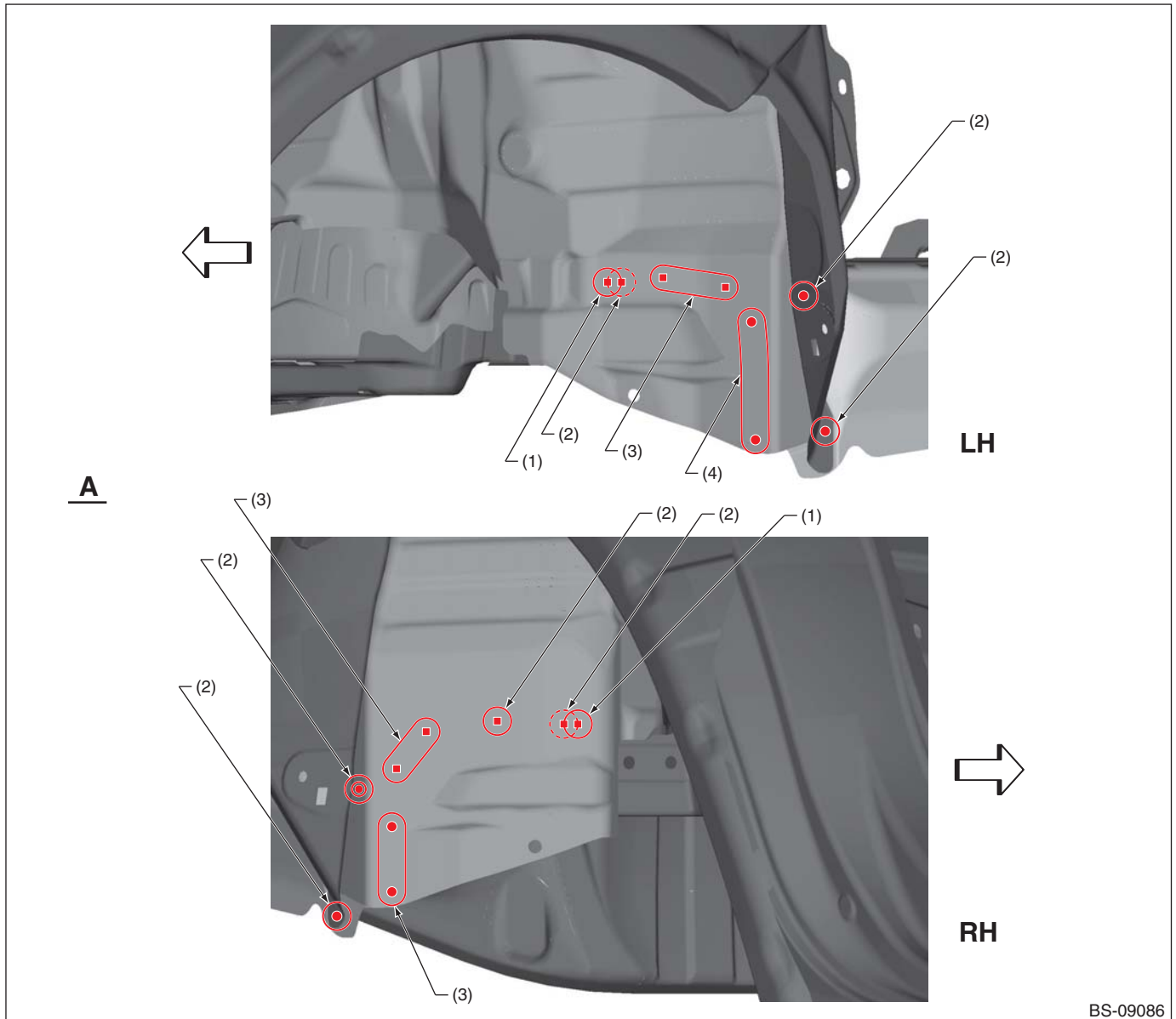
- (1) 1 point
- (2) 10 points (service)

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

- (4) 1 point (service)

Panel Replacement

• View A



BS-09086

(1) 1 point (service · matching)
(2) 1 point

(3) 2 points

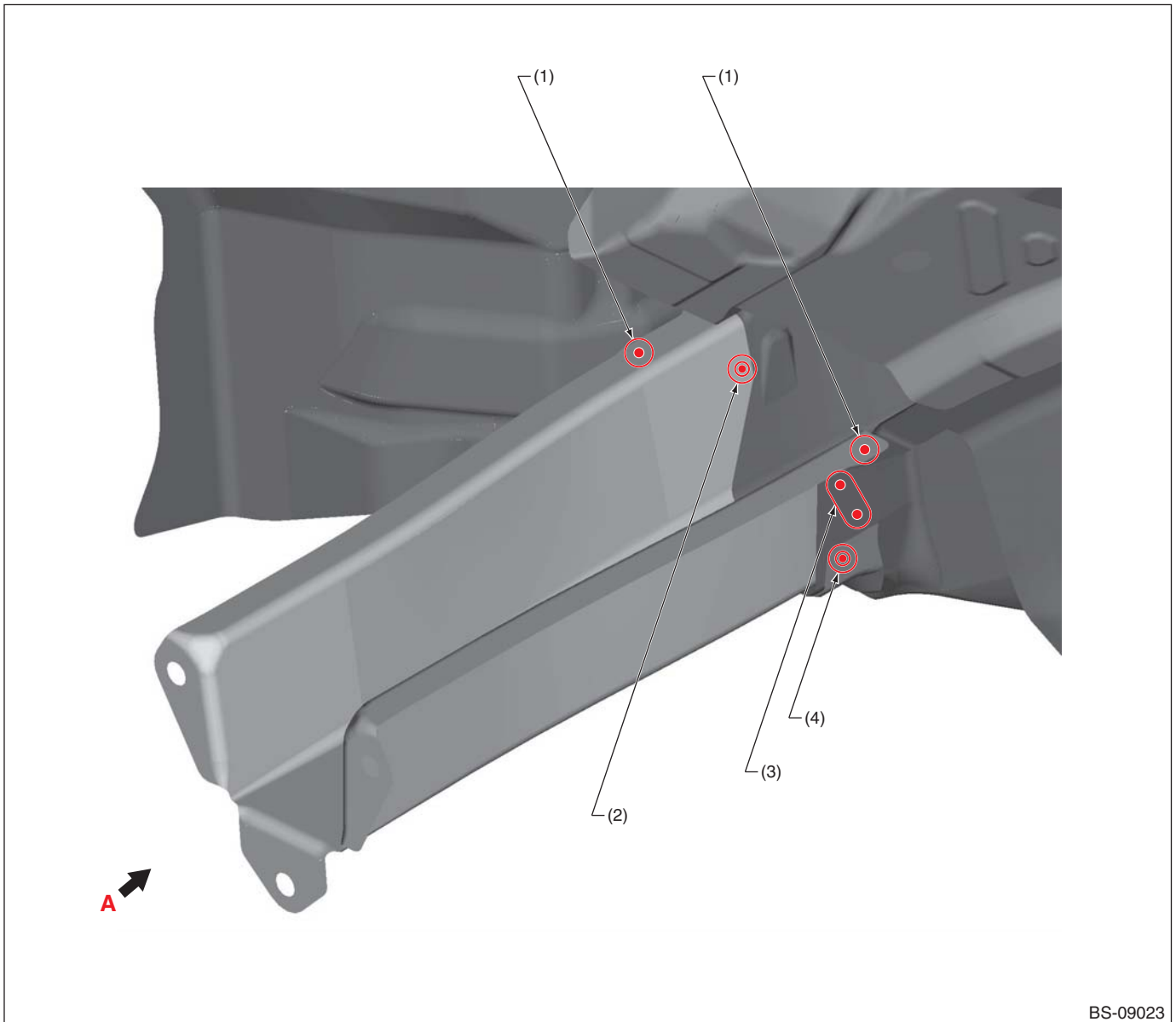
(4) 3 points

Panel Replacement

8-47. Rear Side Frame Lower Rear (Total replacement) / 5D

A: REMOVAL

• Overall view



BS-09023

(1) 1 point (top · 1)

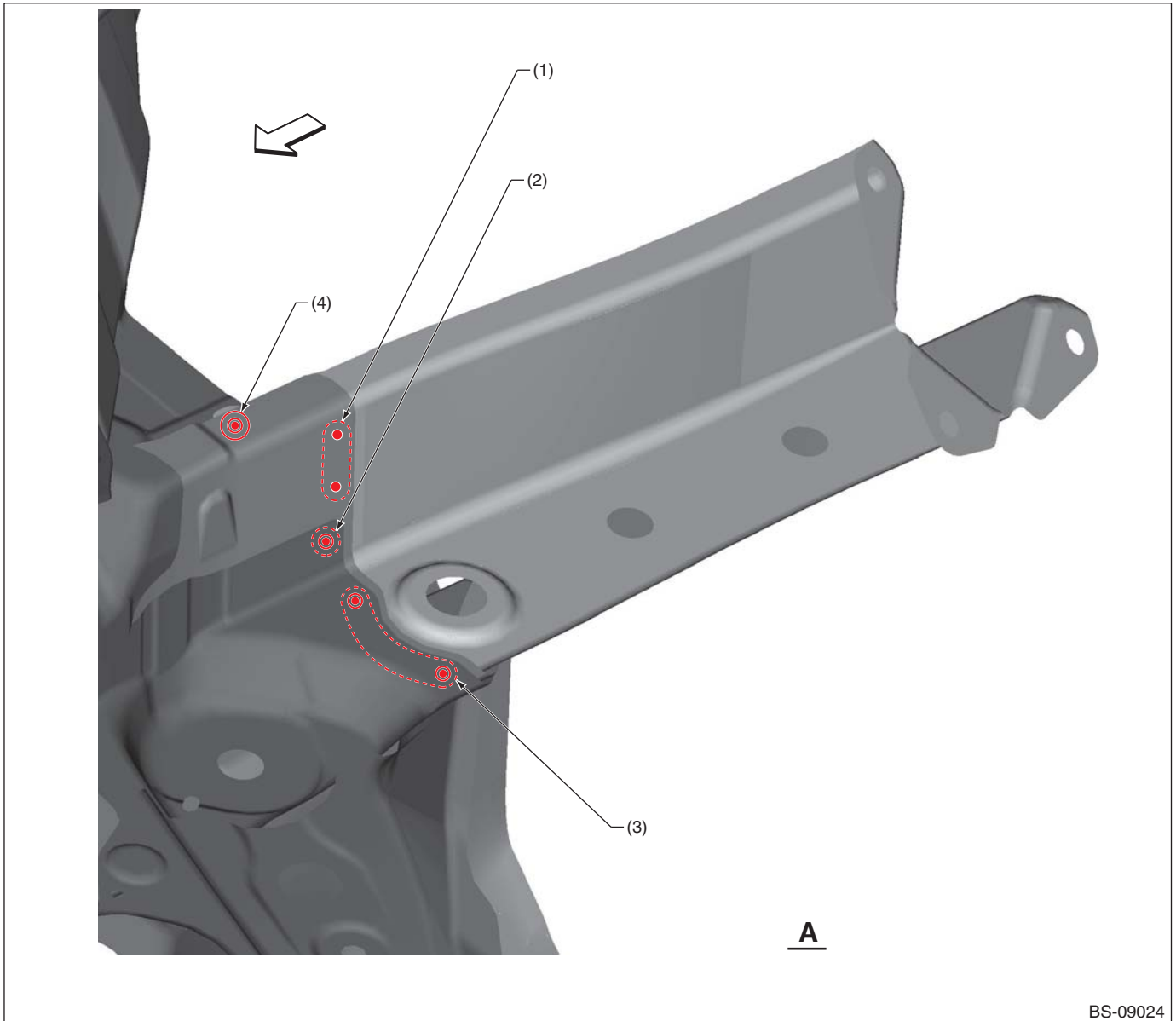
(2) 1 point (inside · 1, belt sander)

(3) 2 points (inside · 1)

(4) 1 point (inside · 2)

Panel Replacement

• View A



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

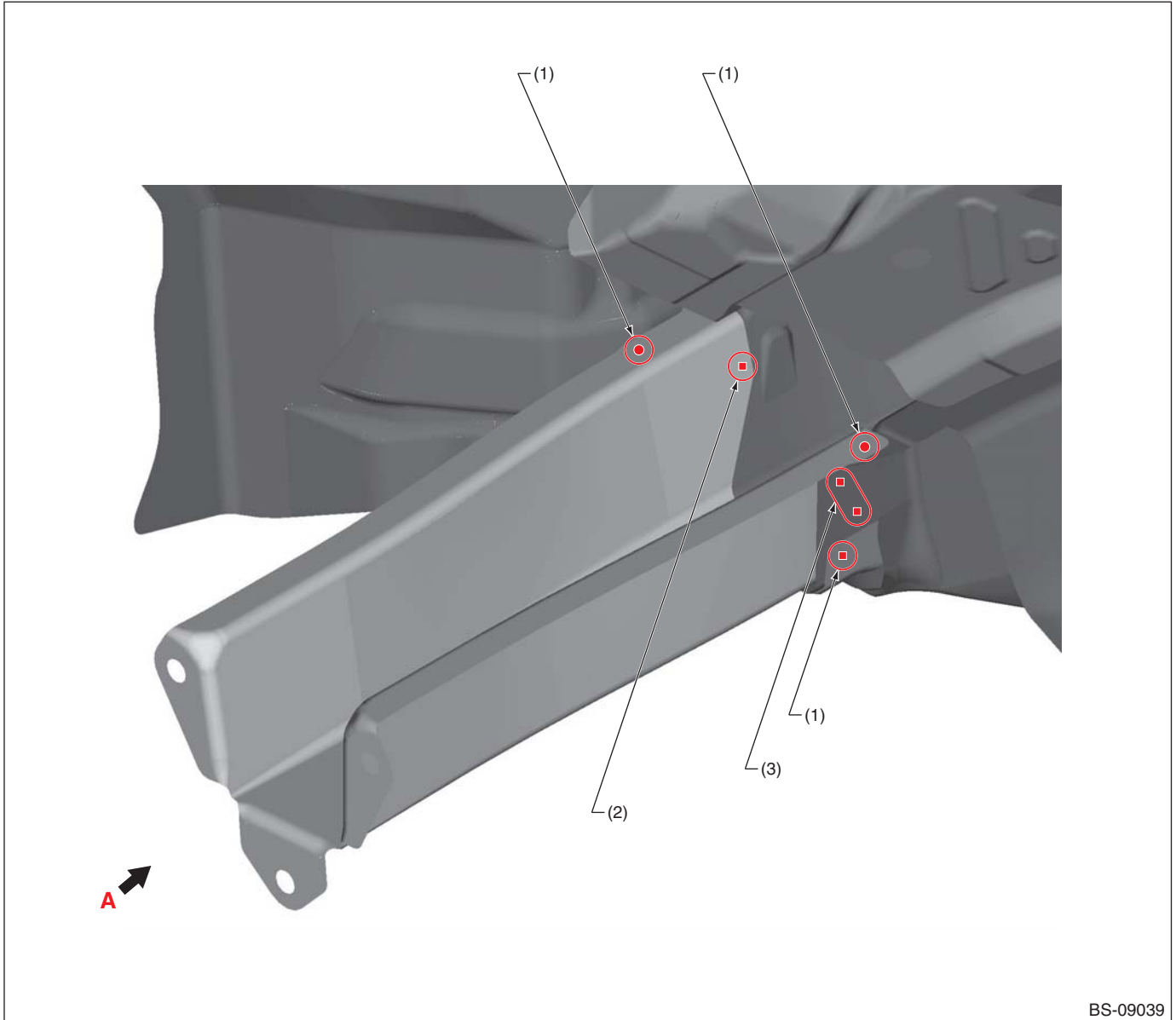
(3) 3 points (top · 1)

(4) 1 point (bottom · 2)

Panel Replacement

B: INSTALLATION

• Overall view



BS-09039

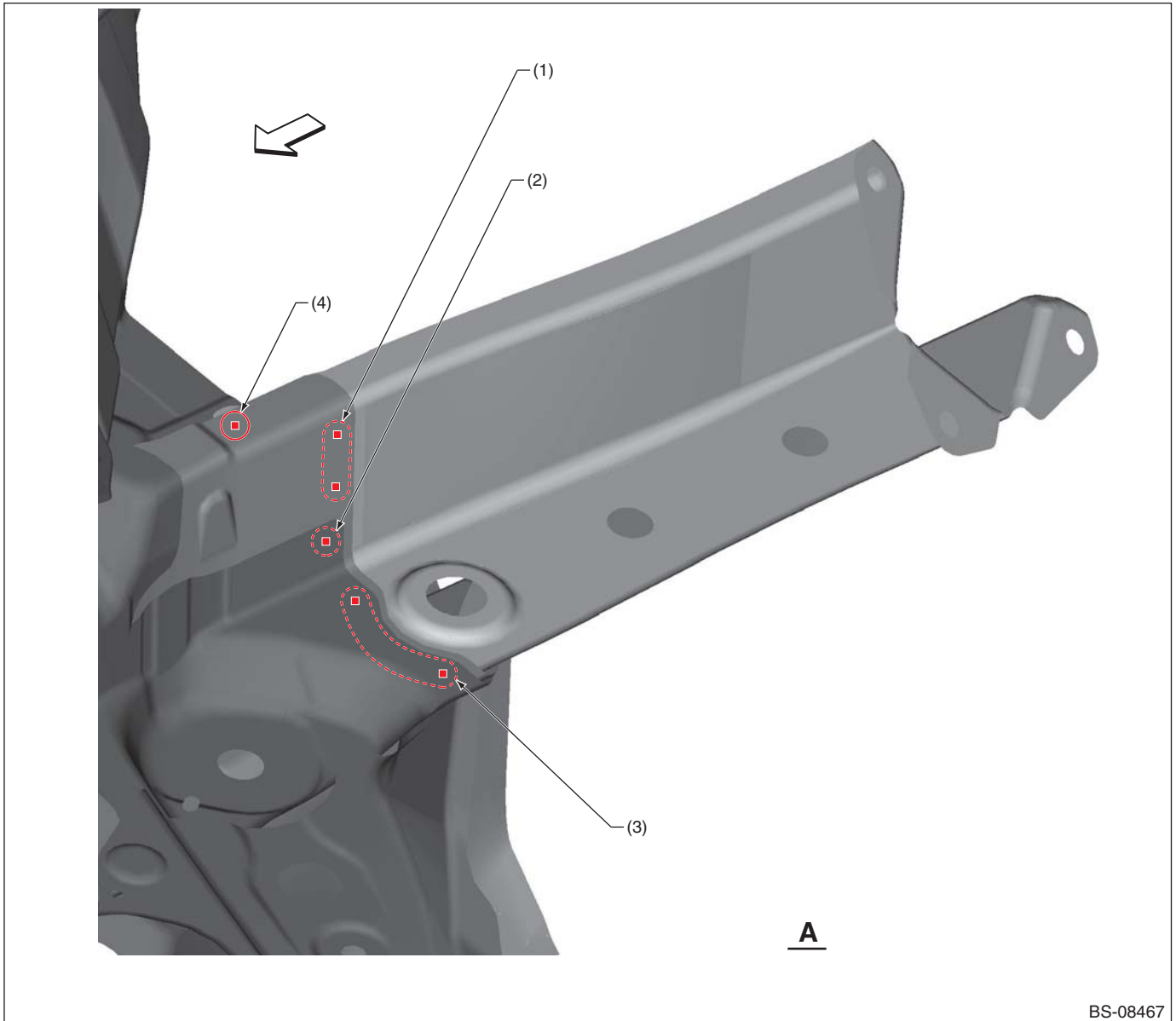
(1) 1 point

(2) 1 point (service)

(3) 2 points

Panel Replacement

• View A



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

(3) 3 points (service)

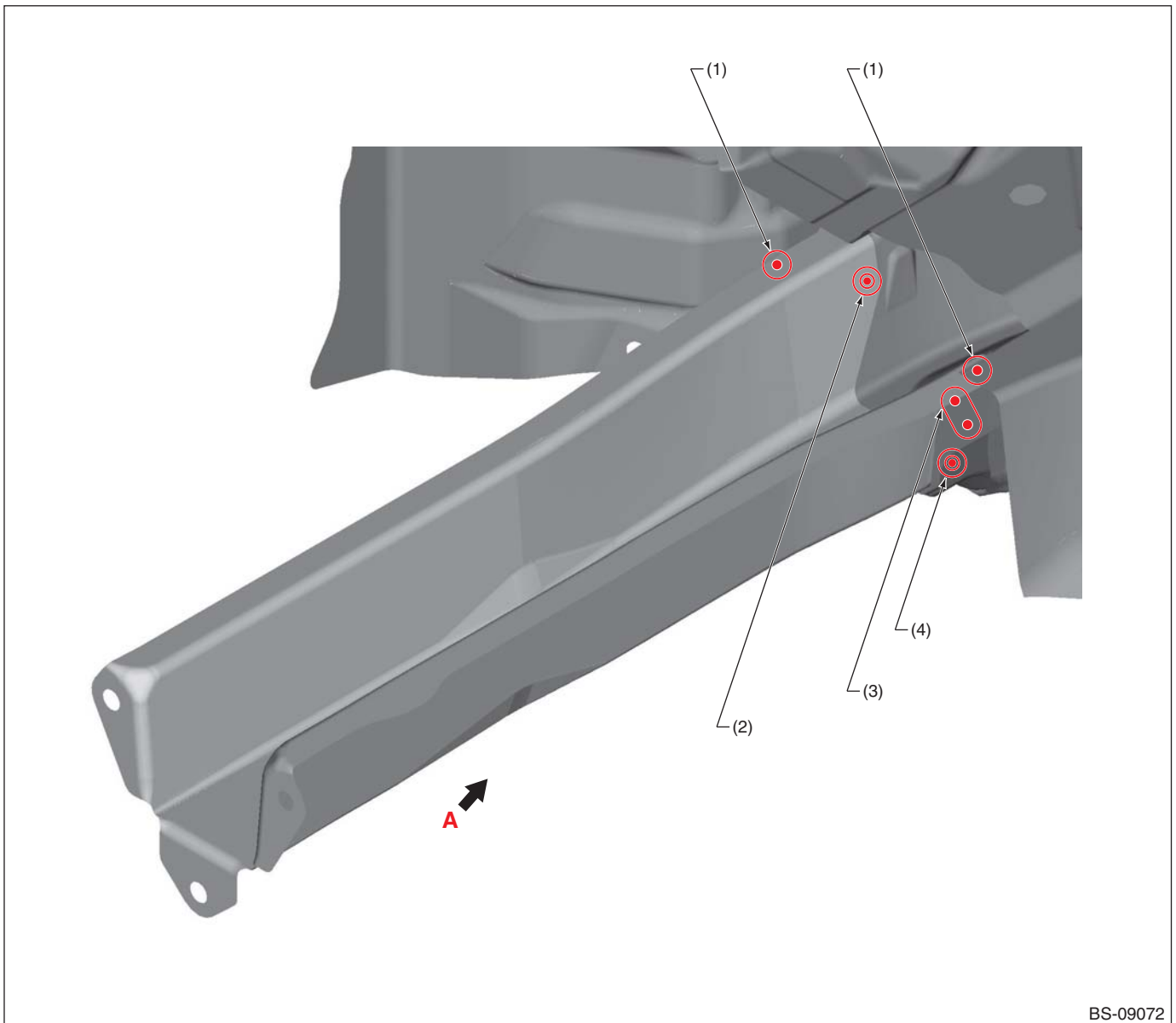
(4) 1 point

Panel Replacement

8-48. Rear Side Frame Lower Rear (Total replacement) / 4D

A: REMOVAL

• Overall view



BS-09072

(1) 1 point (top · 1)

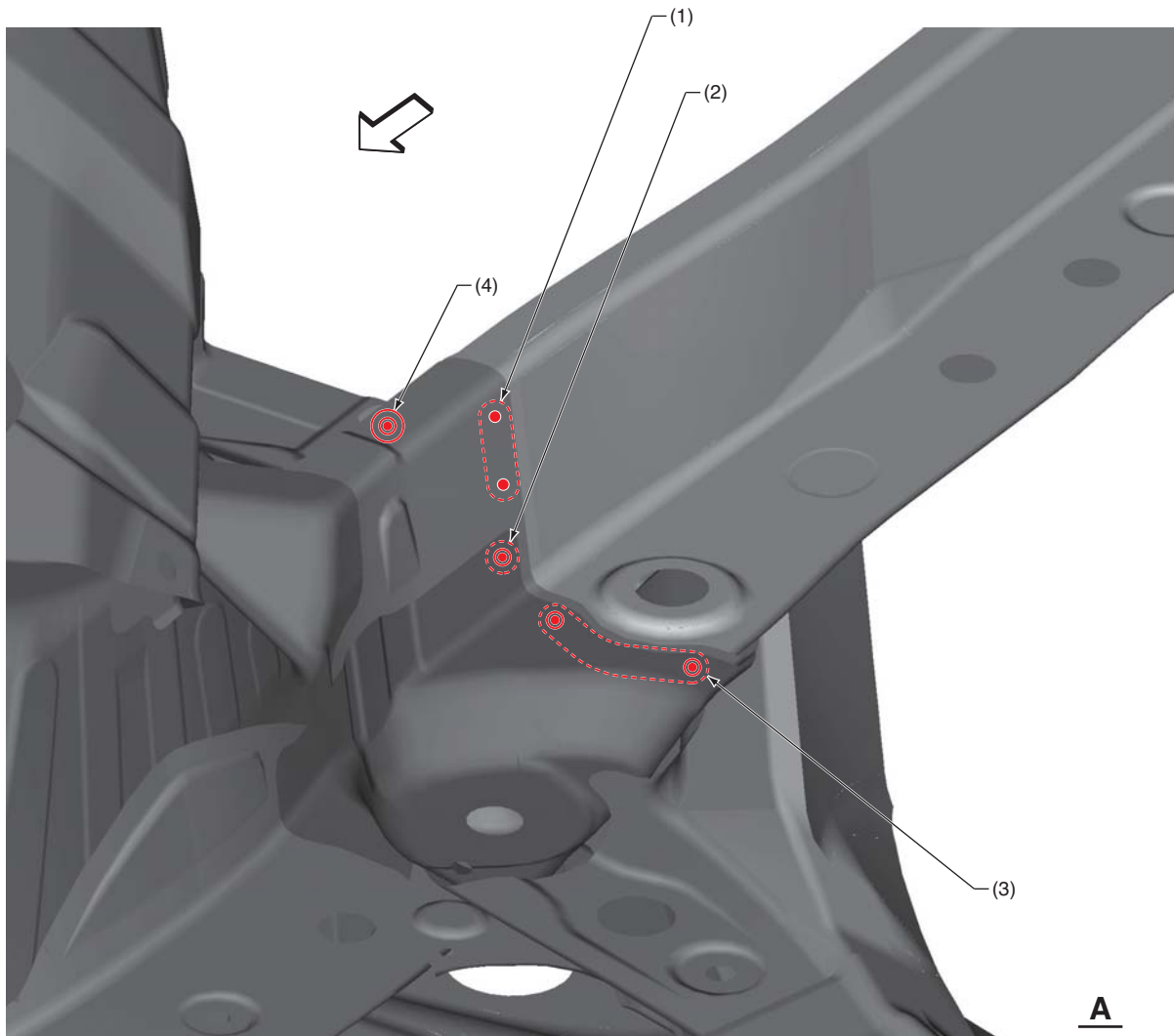
(2) 1 point (inside · 1, belt sander)

(3) 2 points (inside · 1)

(4) 1 point (inside · 2)

Panel Replacement

• View A



BS-09073

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

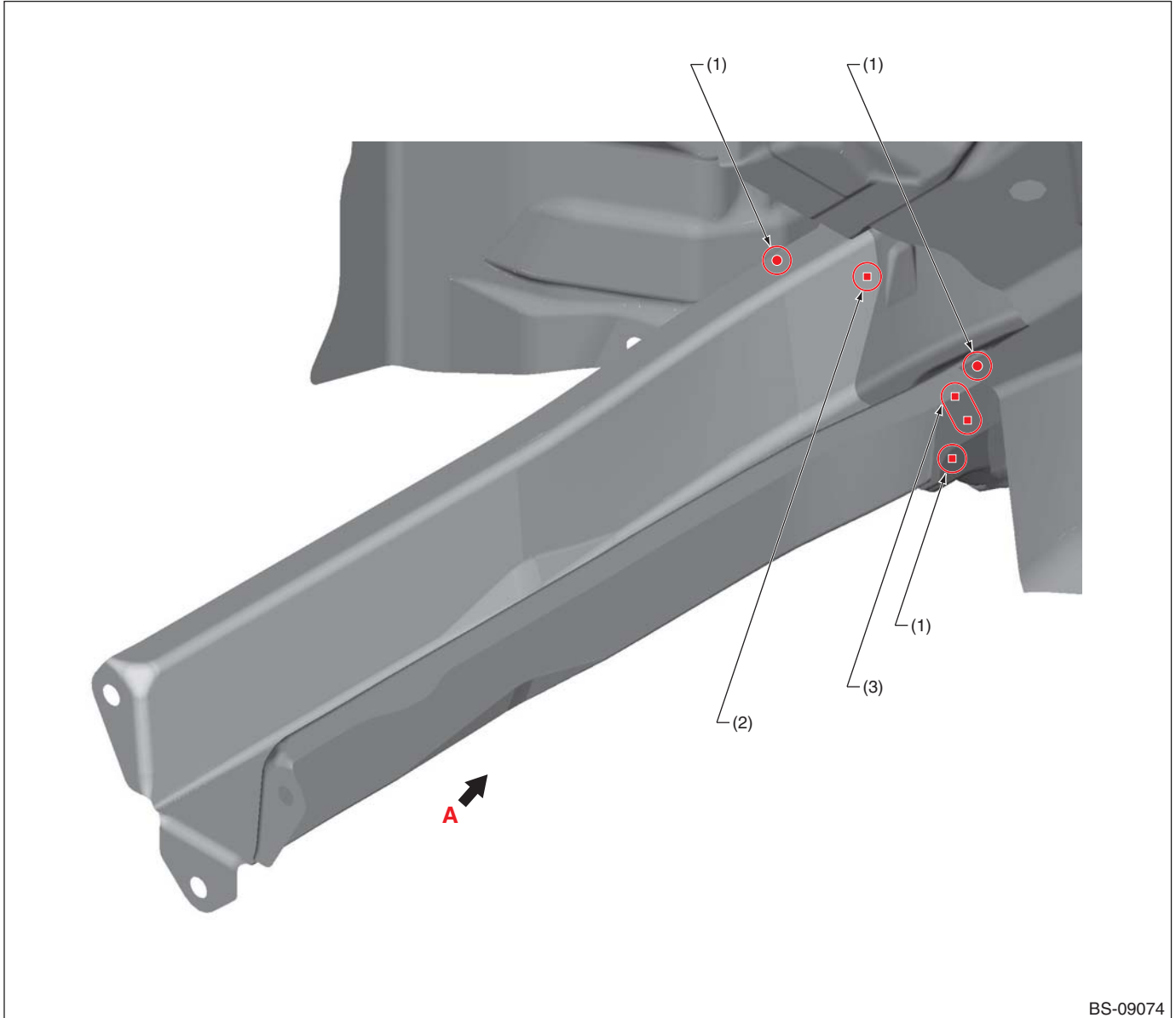
(3) 3 points (top · 1)

(4) 1 point (bottom · 2)

Panel Replacement

B: INSTALLATION

• Overall view



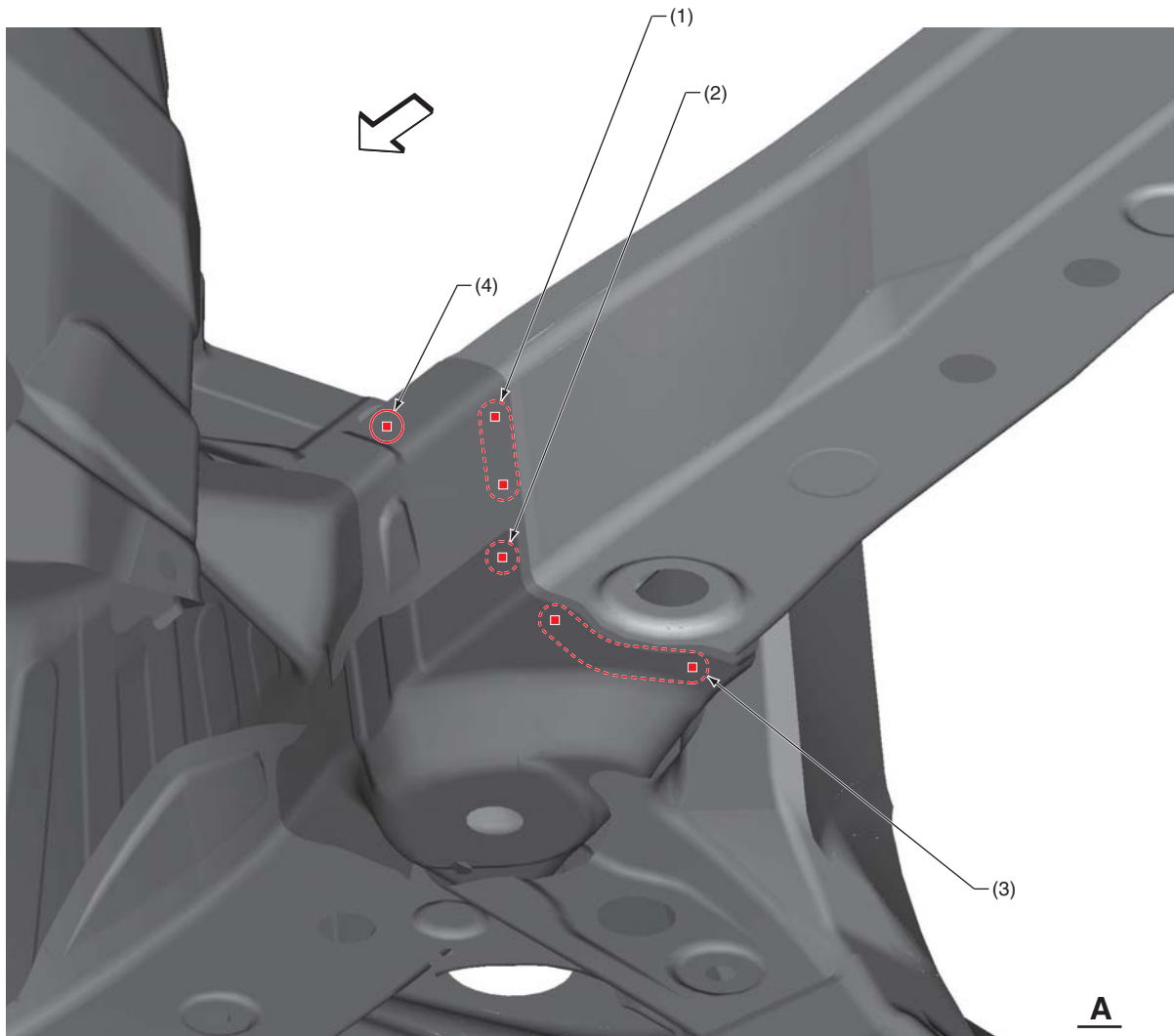
(1) 1 point

(2) 1 point (service)

(3) 2 points

Panel Replacement

• View A



BS-08621

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

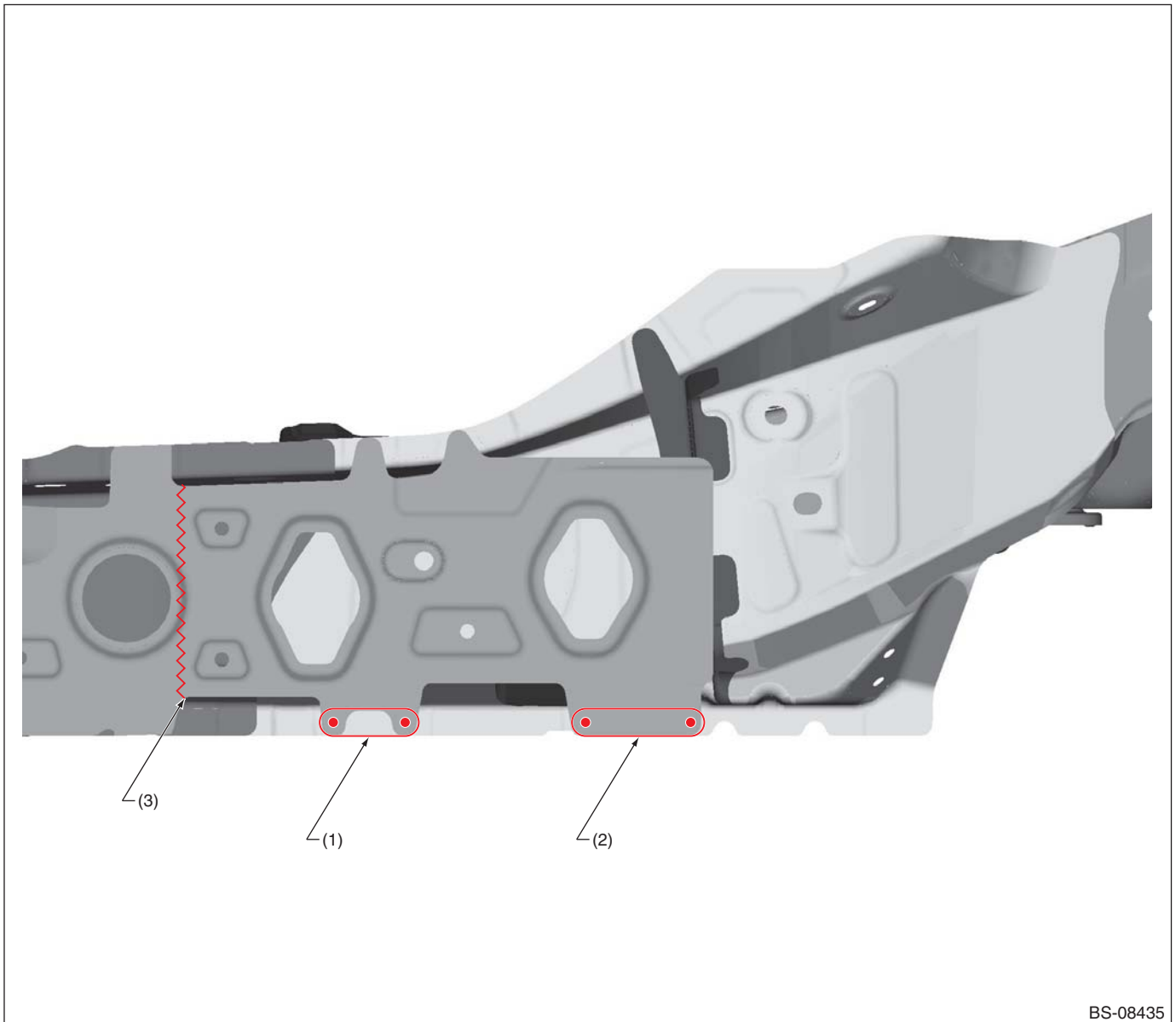
(3) 3 points (service)

(4) 1 point

8-49. Side Sill Inner Rear (Total replacement)

A: REMOVAL

• Overall view 1



BS-08435

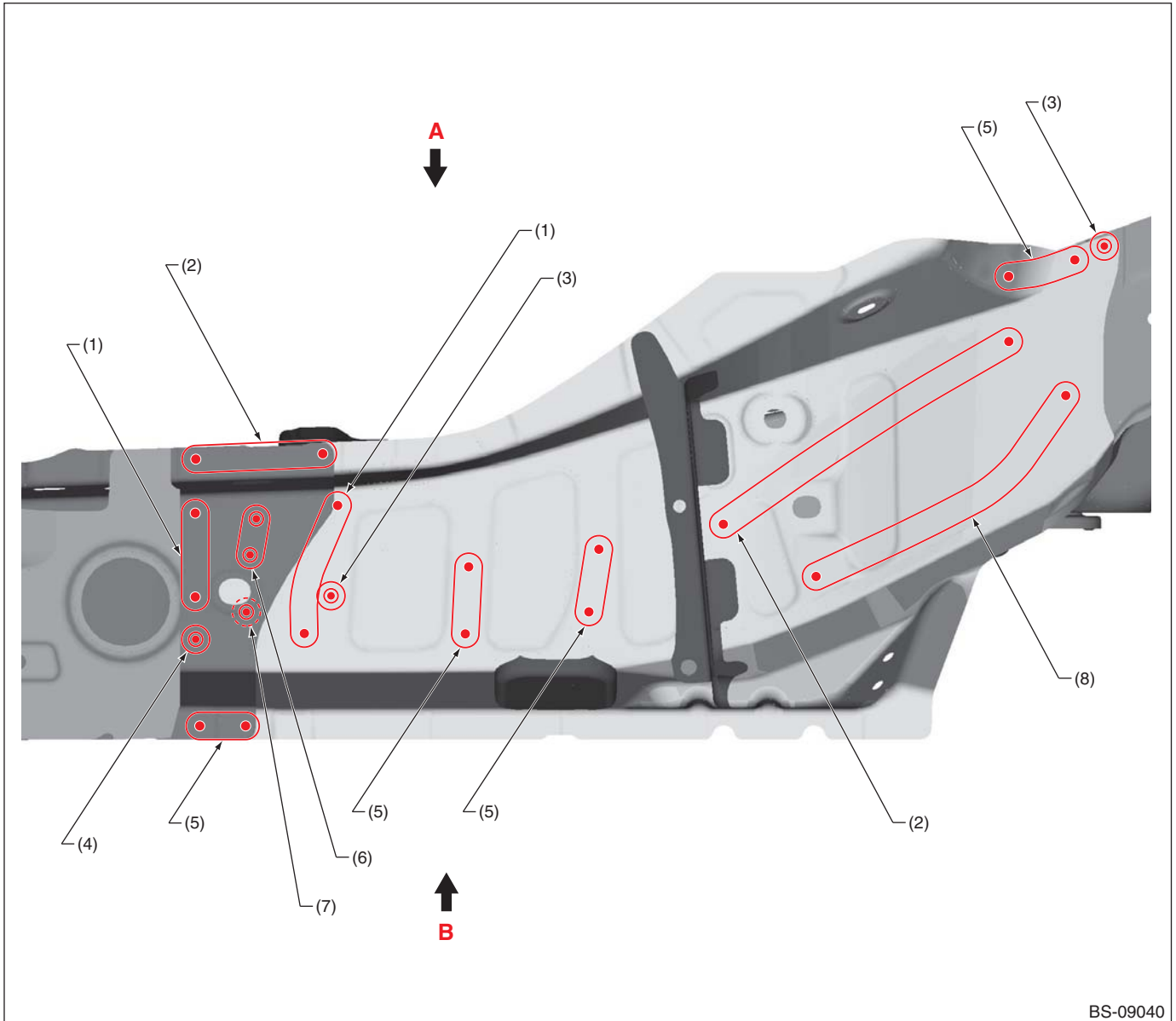
(1) 2 points (outside · 1)

(2) 3 points (outside · 1)

(3) Rough cutting

Panel Replacement

• Overall view 2



BS-09040

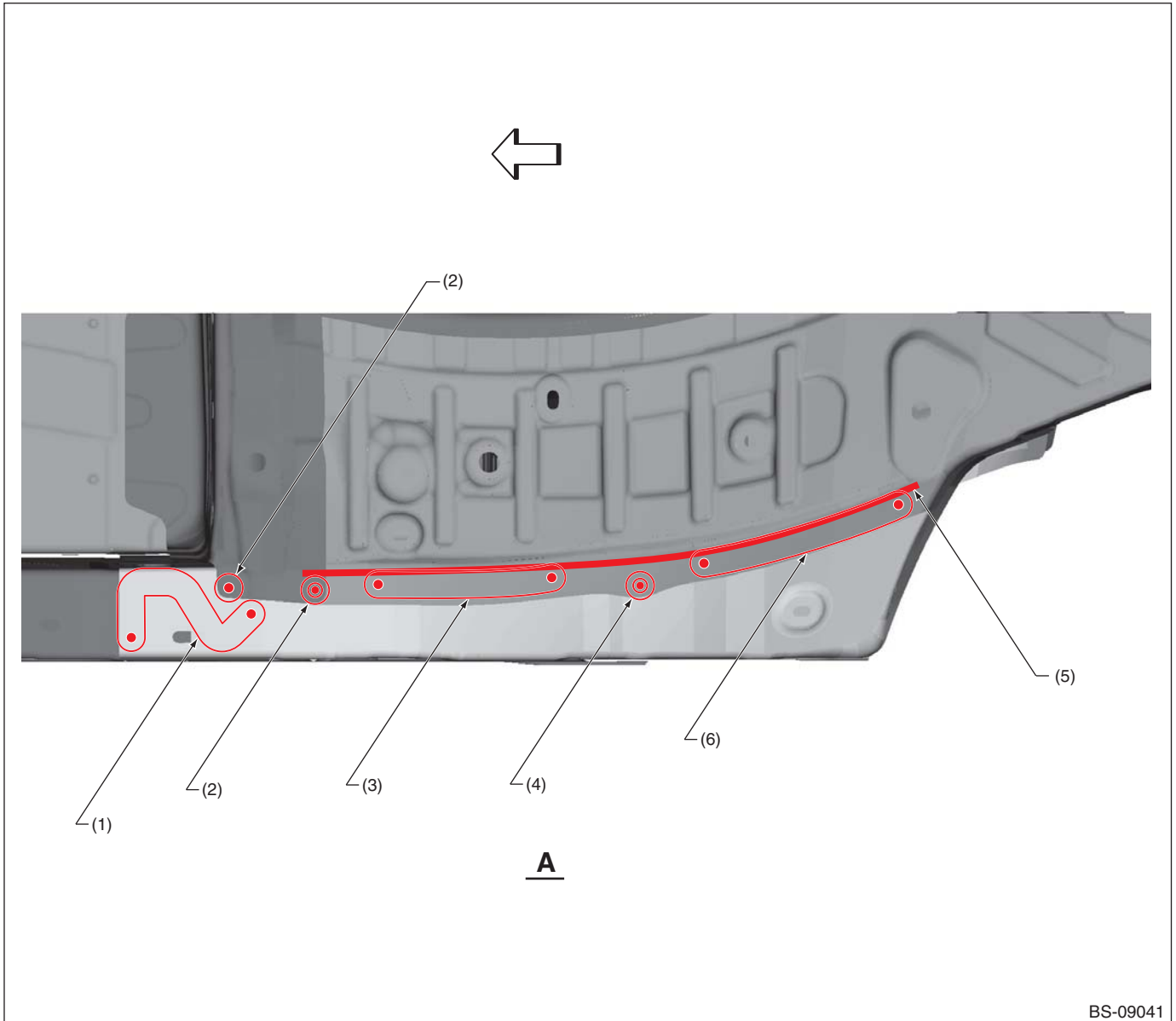
- (1) 3 points (outside · 1)
- (2) 4 points (outside · 1)
- (3) 1 point (outside · 1)

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

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

Panel Replacement

• View A



(1) 5 points (top · 1)

(2) 1 point (top · 2)

(3) 4 points (top · 1)

(4) 1 point (bottom · 2)

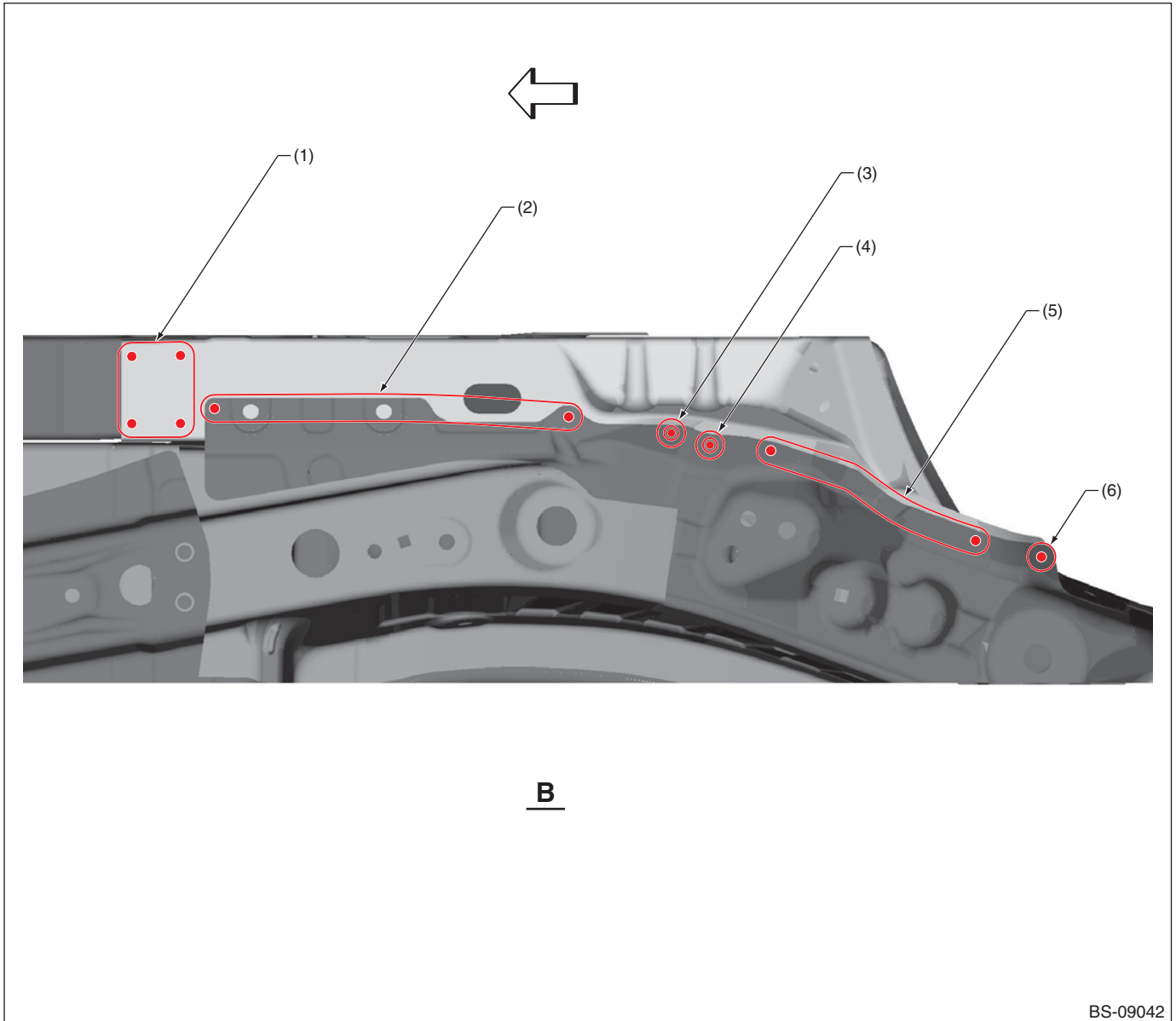
(5) Structural adhesive

(6) 4 points (bottom · 1)

— : Structural adhesive application location

Panel Replacement

• View B



(1) 4 points (bottom · 1)
(2) 5 points (bottom · 1)

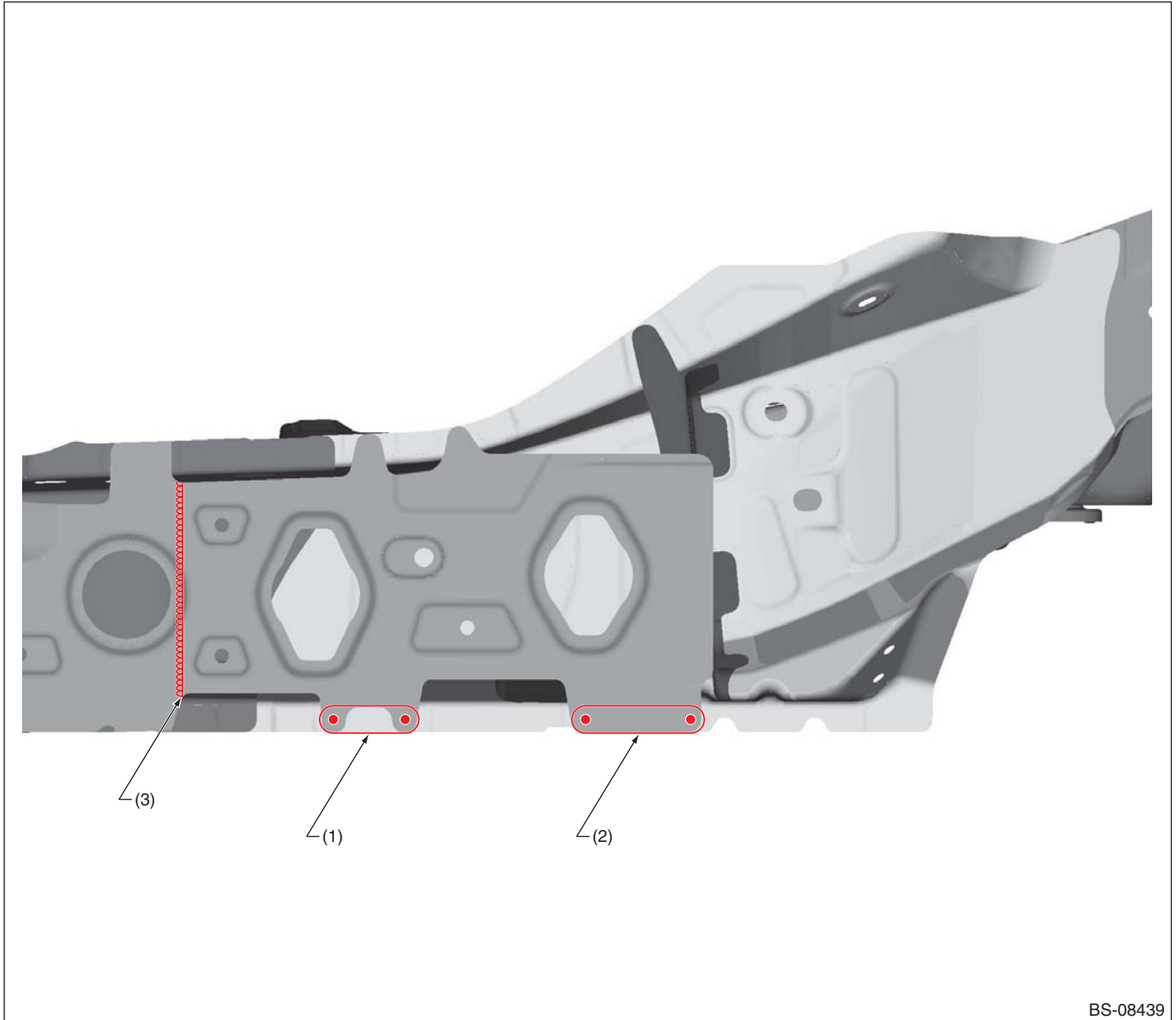
(3) 1 point (top · 2)
(4) 1 point (top · 1)

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

Panel Replacement

B: INSTALLATION

• Overall view 1



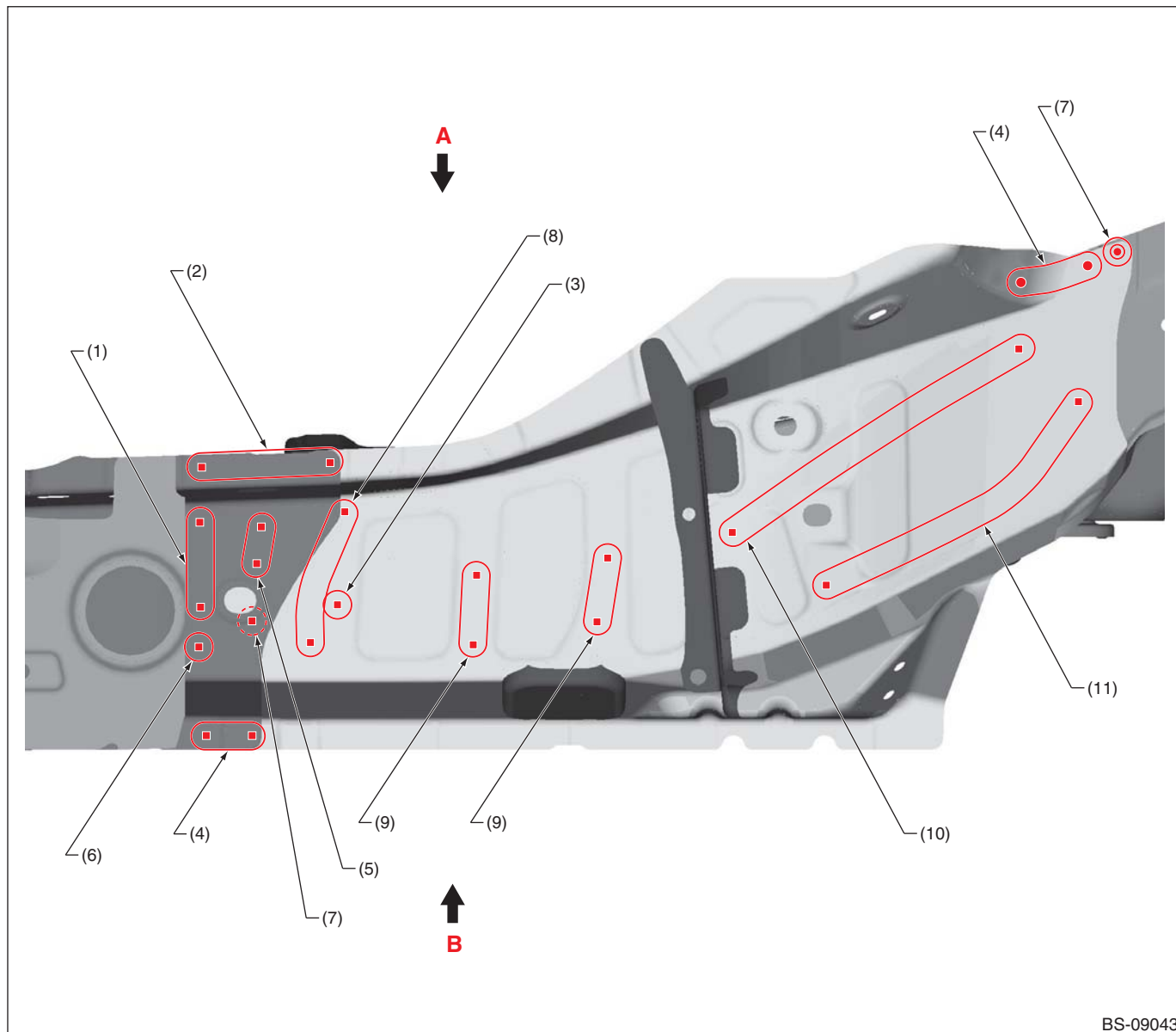
(1) 2 points

(2) 3 points

(3) 1 point (Continuous welding)

Panel Replacement

• Overall view 2

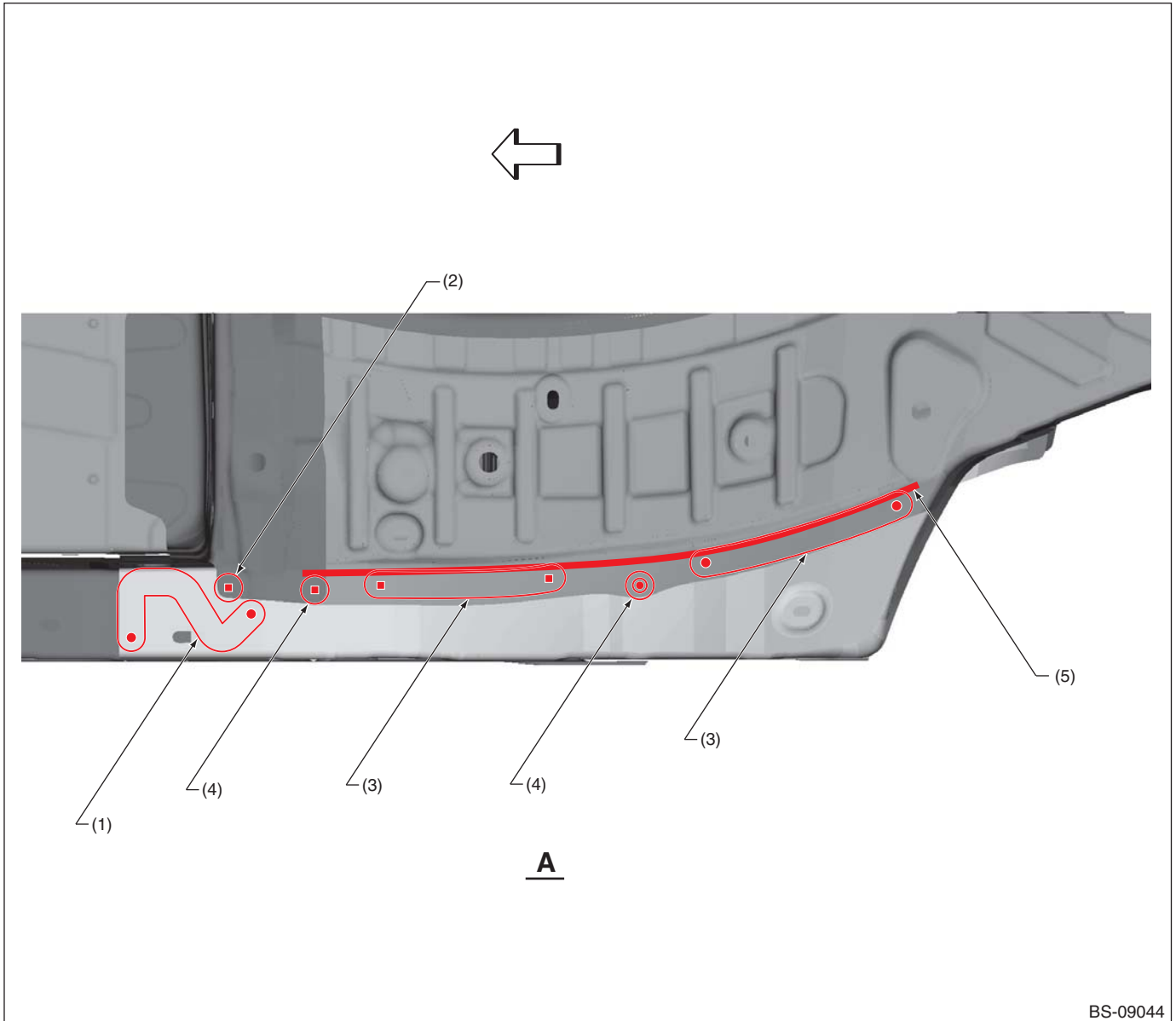


BS-09043

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

Panel Replacement

• View A



BS-09044

(1) 5 points

(3) 4 points

(5) Structural adhesive

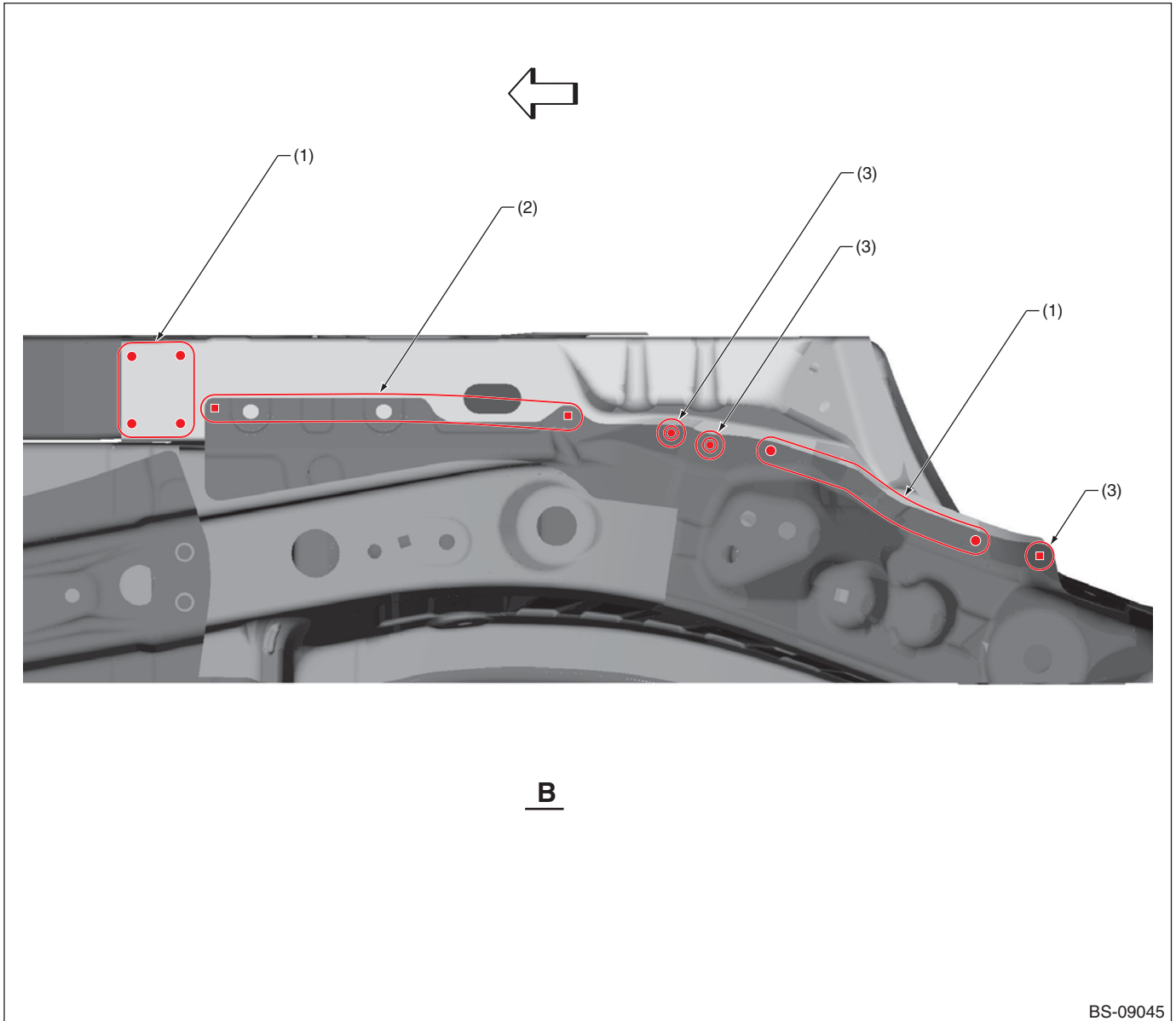
(2) 1 point (service · matching)

(4) 1 point

— : Structural adhesive application location

Panel Replacement

• View B



(1) 4 points

(2) 5 points

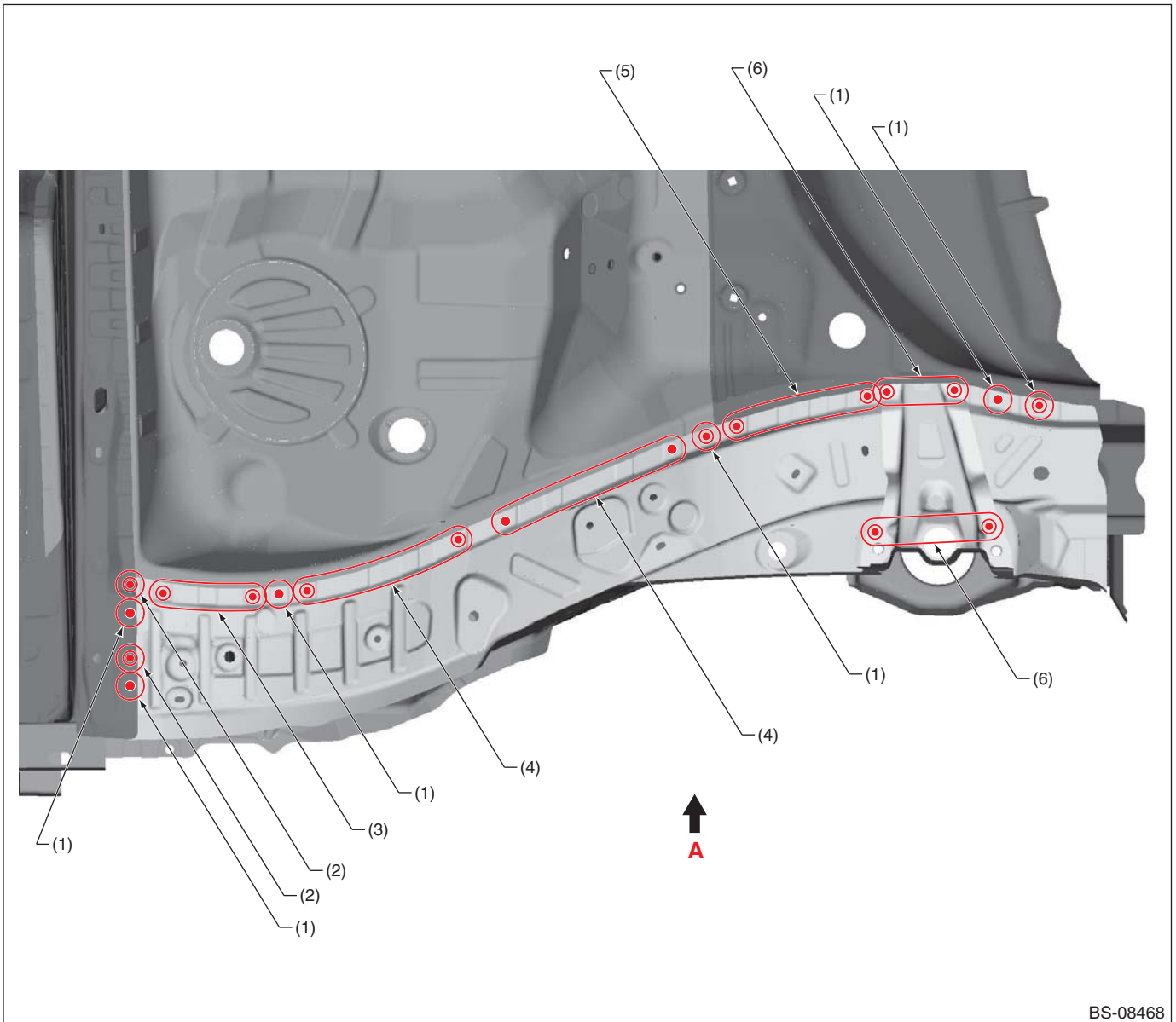
(3) 1 point

Panel Replacement

8-50. Rear Side Frame Upper (Total replacement)

A: REMOVAL

• Overall view



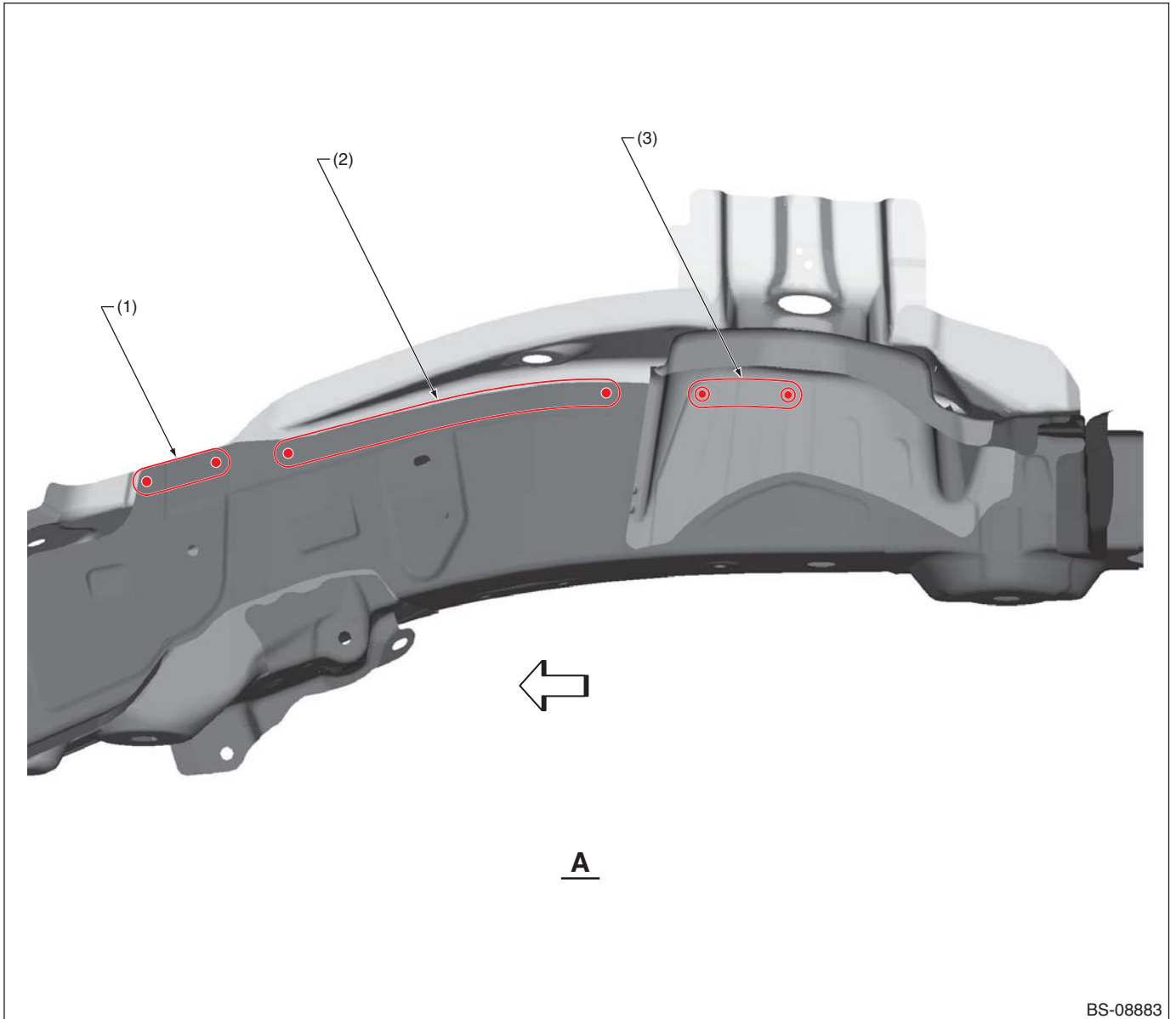
(1) 1 point (top - 1)
(2) 1 point (top - 2)

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

(5) 5 points (top - 1)
(6) 2 points (top - 2)

Panel Replacement

• View A



BS-08883

(1) 3 points (inside · 1)

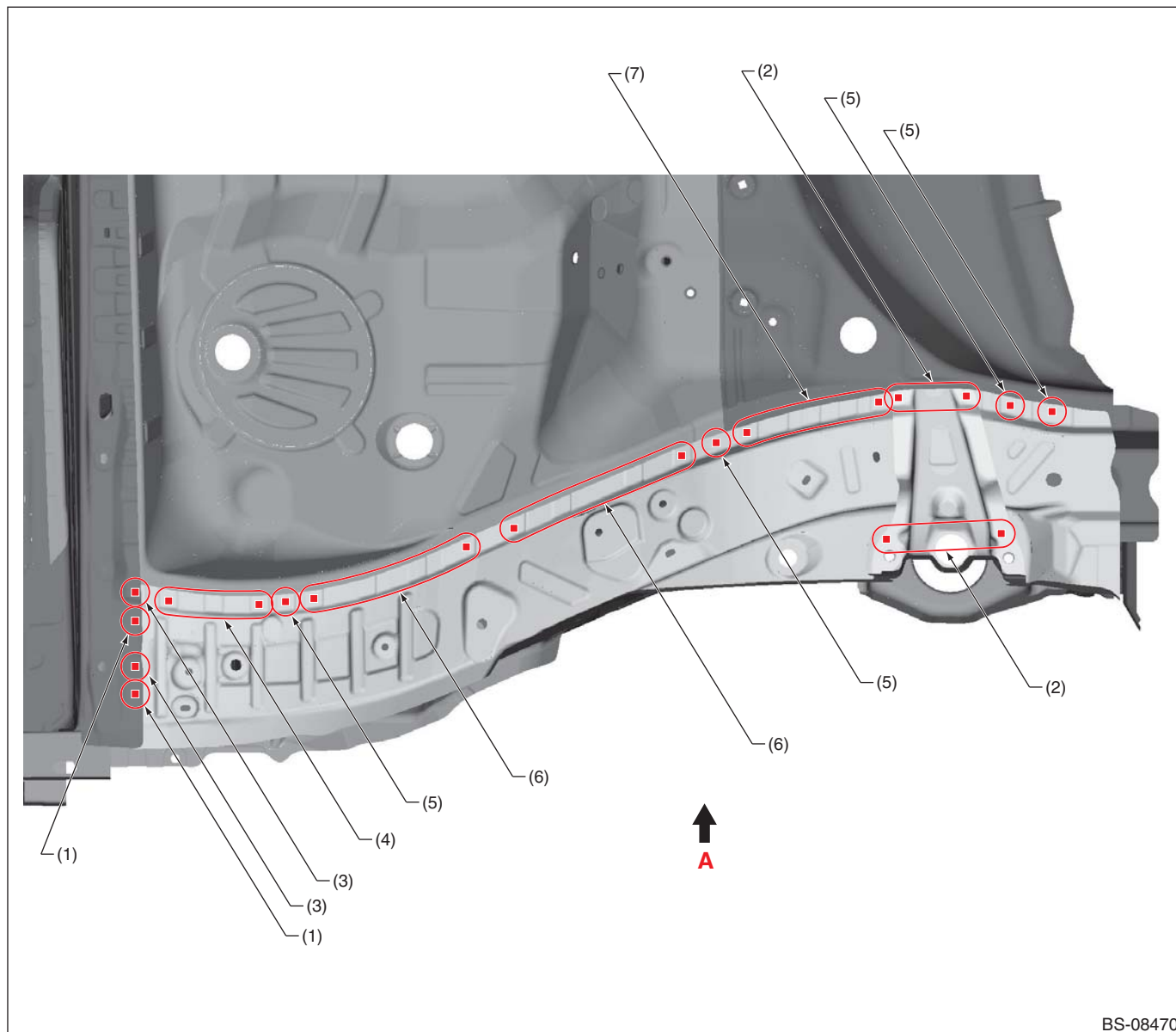
(2) 6 points (outside · 1)

(3) 2 points (outside · 2)

Panel Replacement

B: INSTALLATION

• Overall view

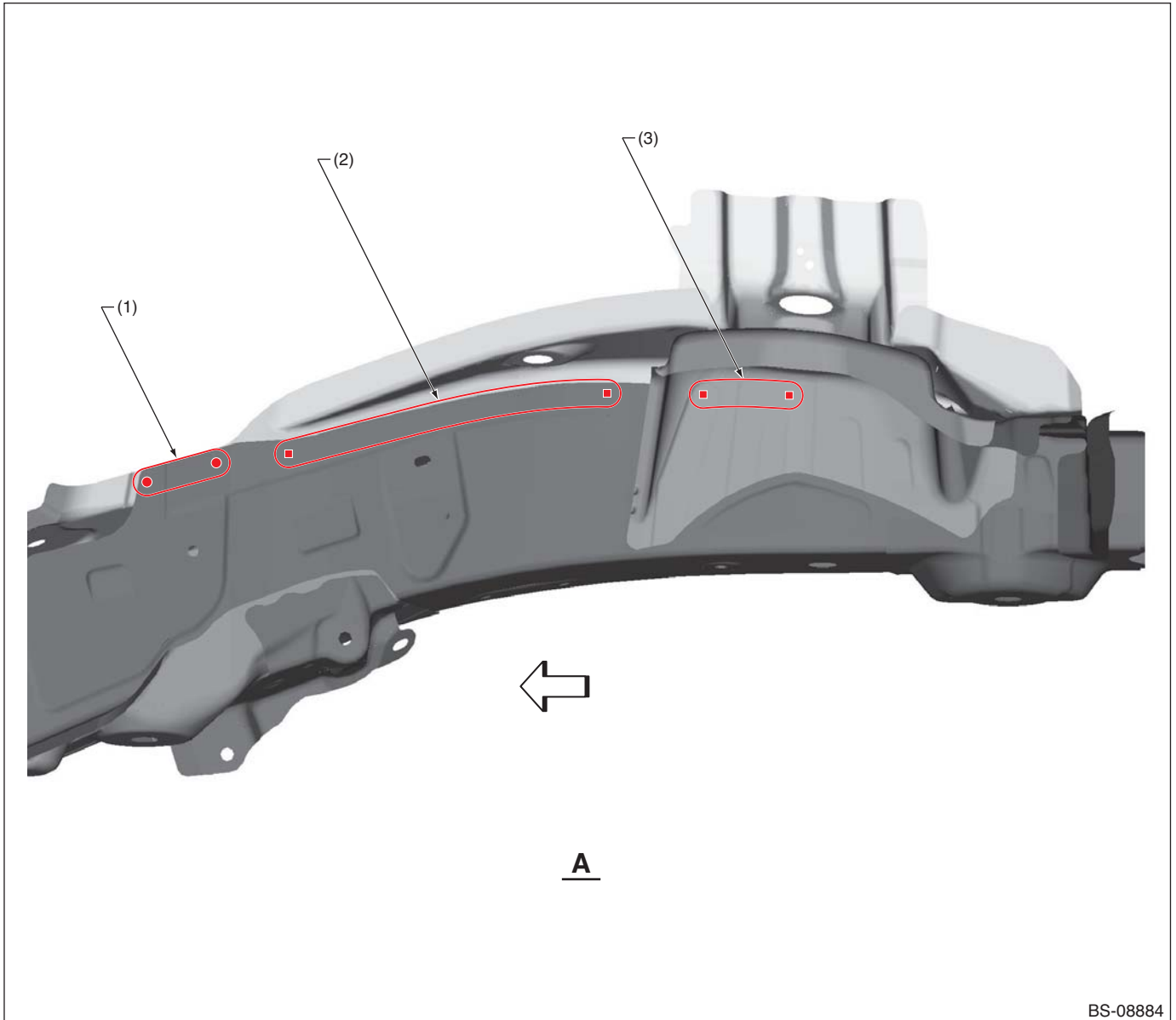


BS-08470

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

Panel Replacement

• View A



(1) 3 points

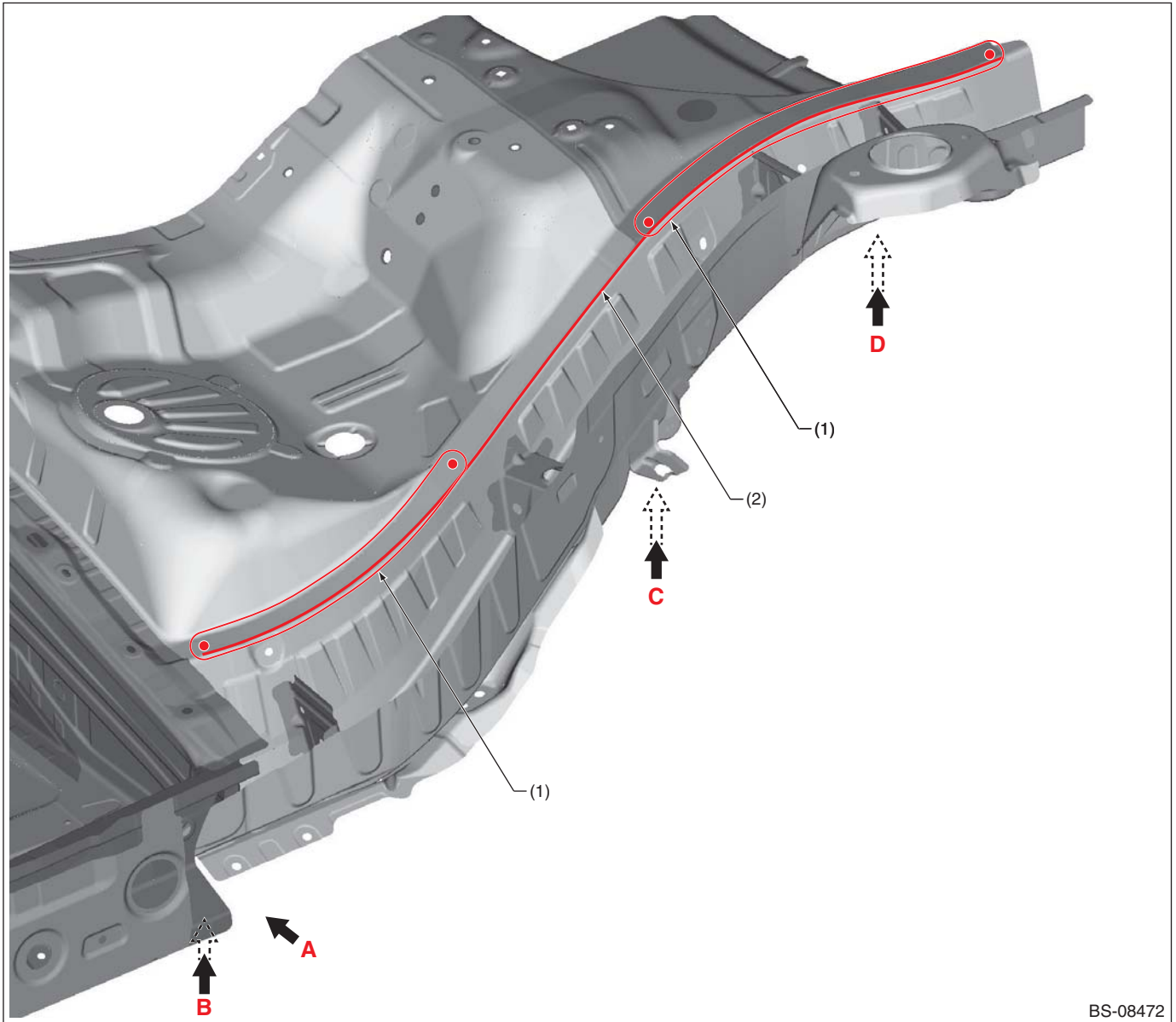
(2) 6 points

(3) 2 points

8-51. Rear Side Frame

A: REMOVAL

• Overall view



BS-08472

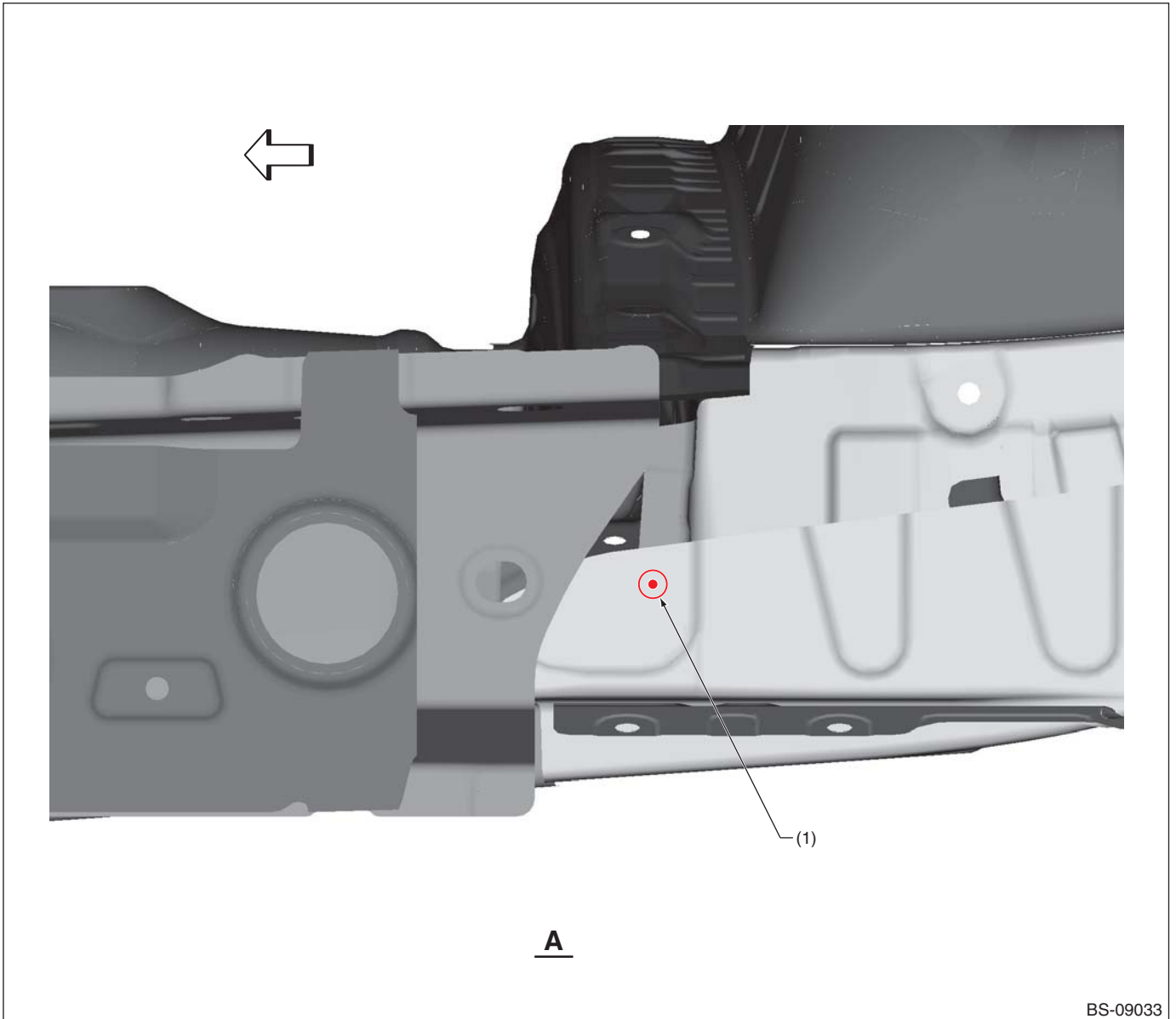
(1) 7 points (top · 1)

(2) Structural adhesive

— : Structural adhesive application location

Panel Replacement

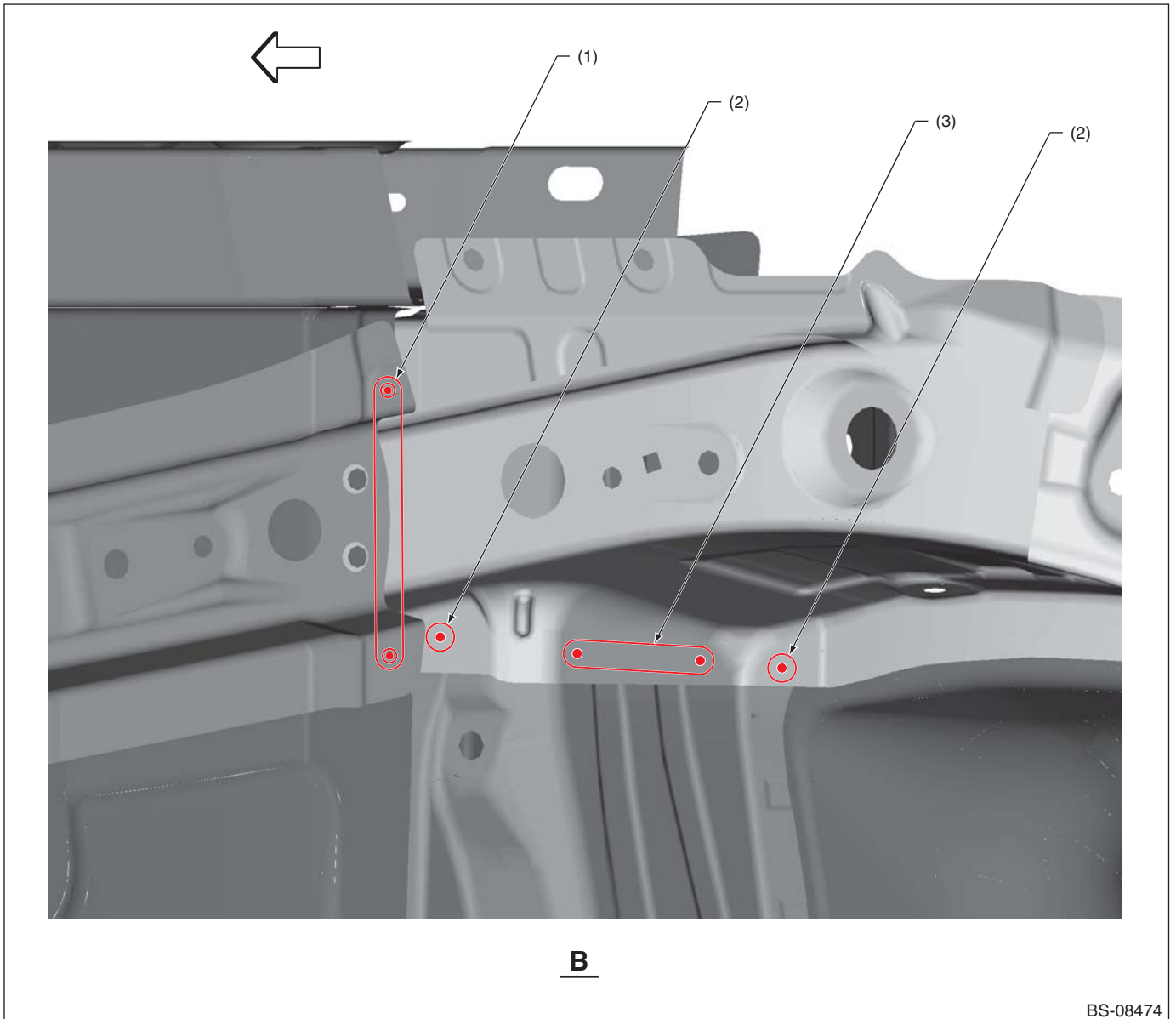
• View A



(1) 1 point (outside · 1)

Panel Replacement

• View B



BS-08474

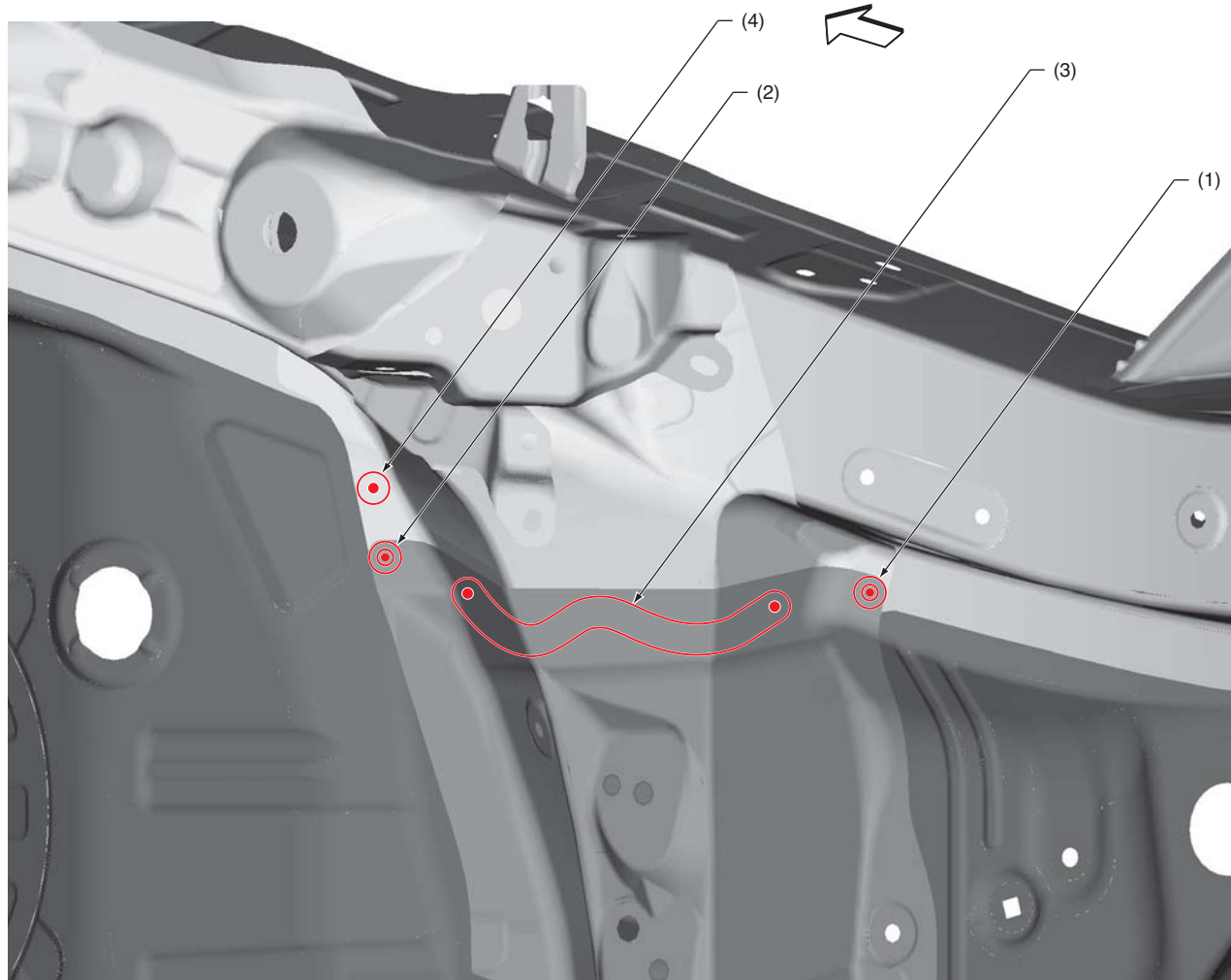
(1) 2 points (bottom · 2)

(2) 1 point (bottom · 1)

(3) 3 points (outside · 1)

Panel Replacement

• View C



C

BS-09034

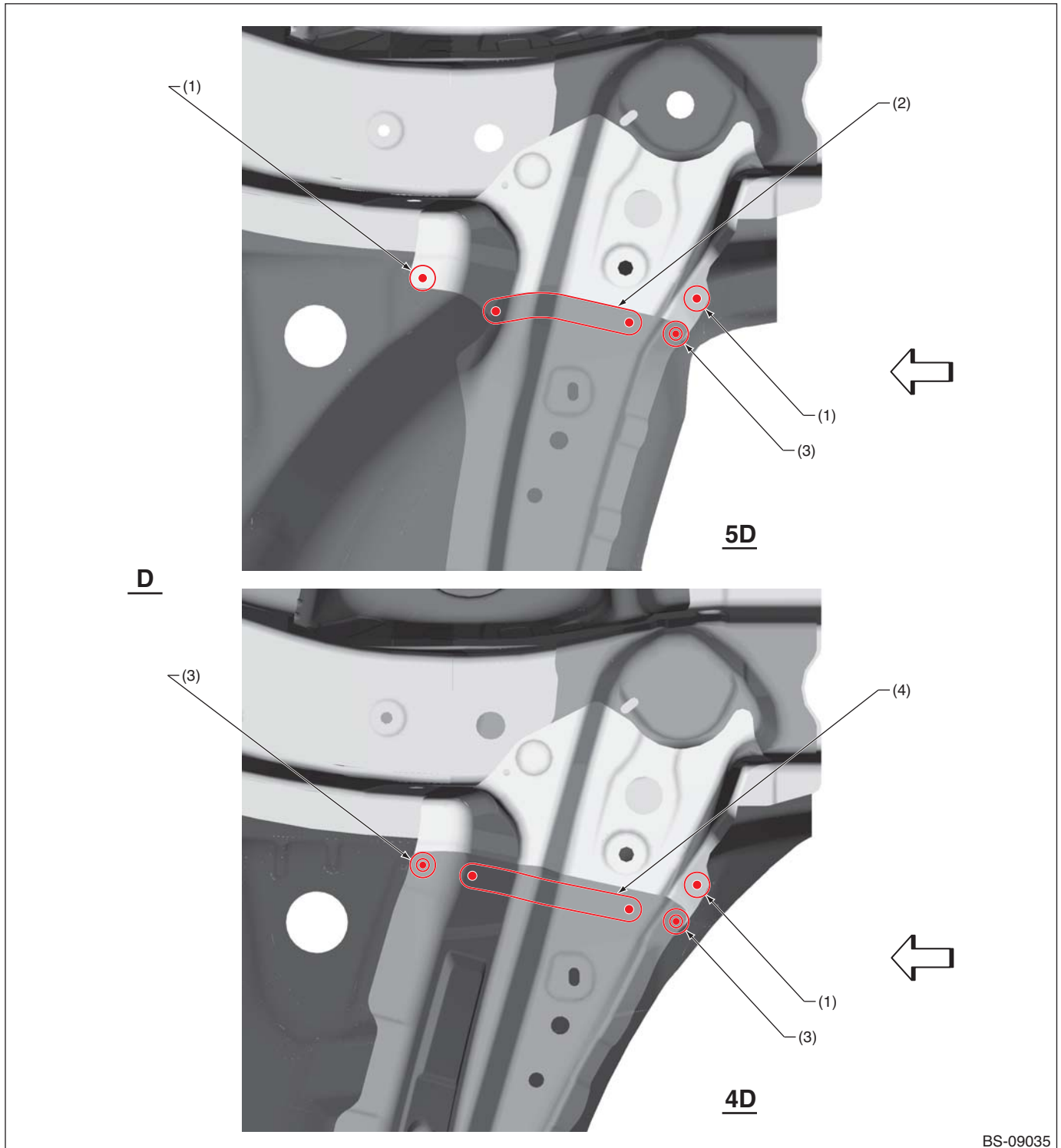
(1) 1 point (bottom · 1)
(2) 1 point (top · 2)

(3) 7 points (bottom · 1)

(4) 1 point (top · 1)

Panel Replacement

• View D



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

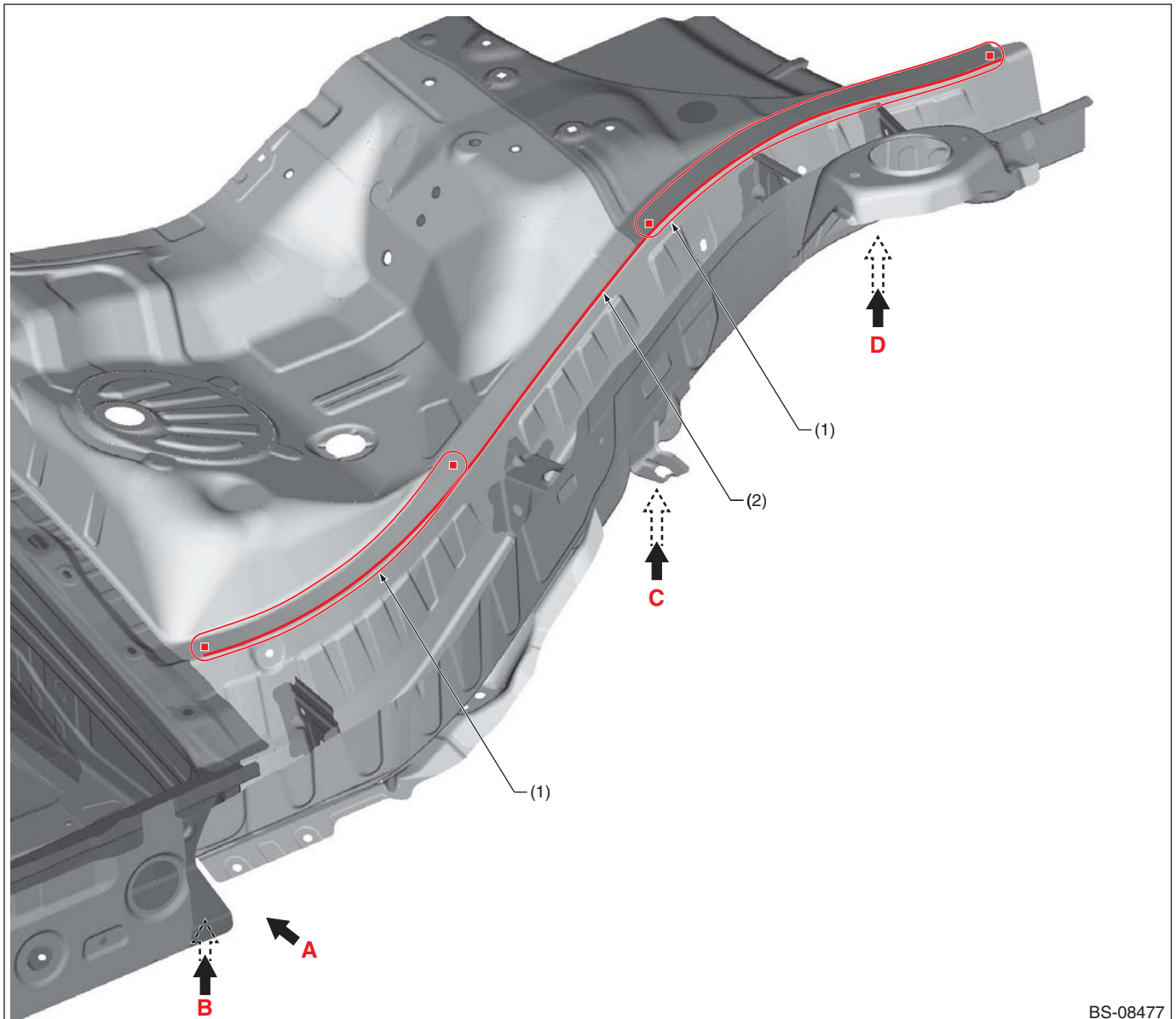
- (3) 1 point (top · 1, bottom · 1)

- (4) 5 points (bottom · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BS-08477

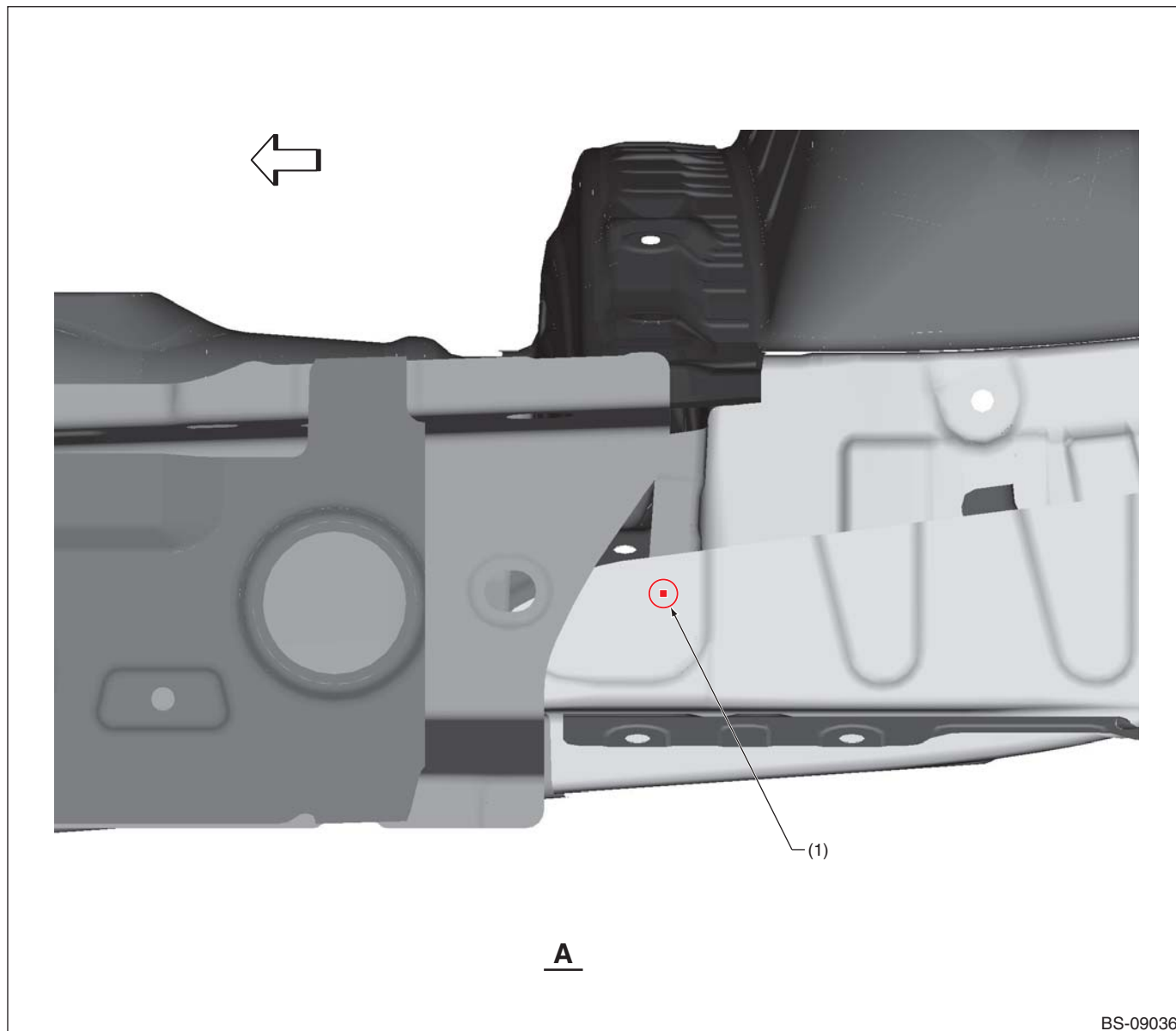
(1) 7 points

(2) Structural adhesive

— : Structural adhesive application location

Panel Replacement

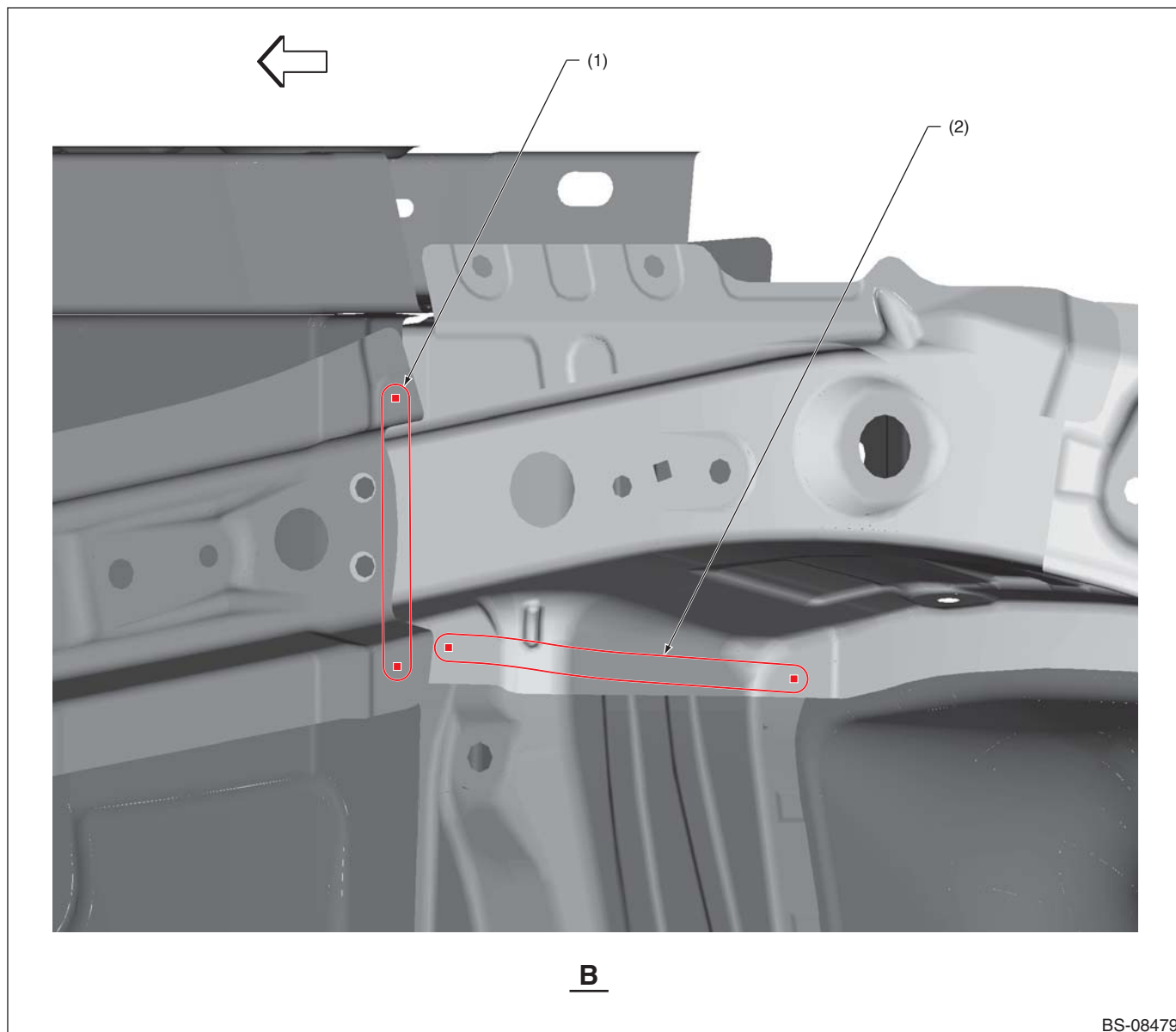
• View A



(1) 1 point (service)

Panel Replacement

• View B



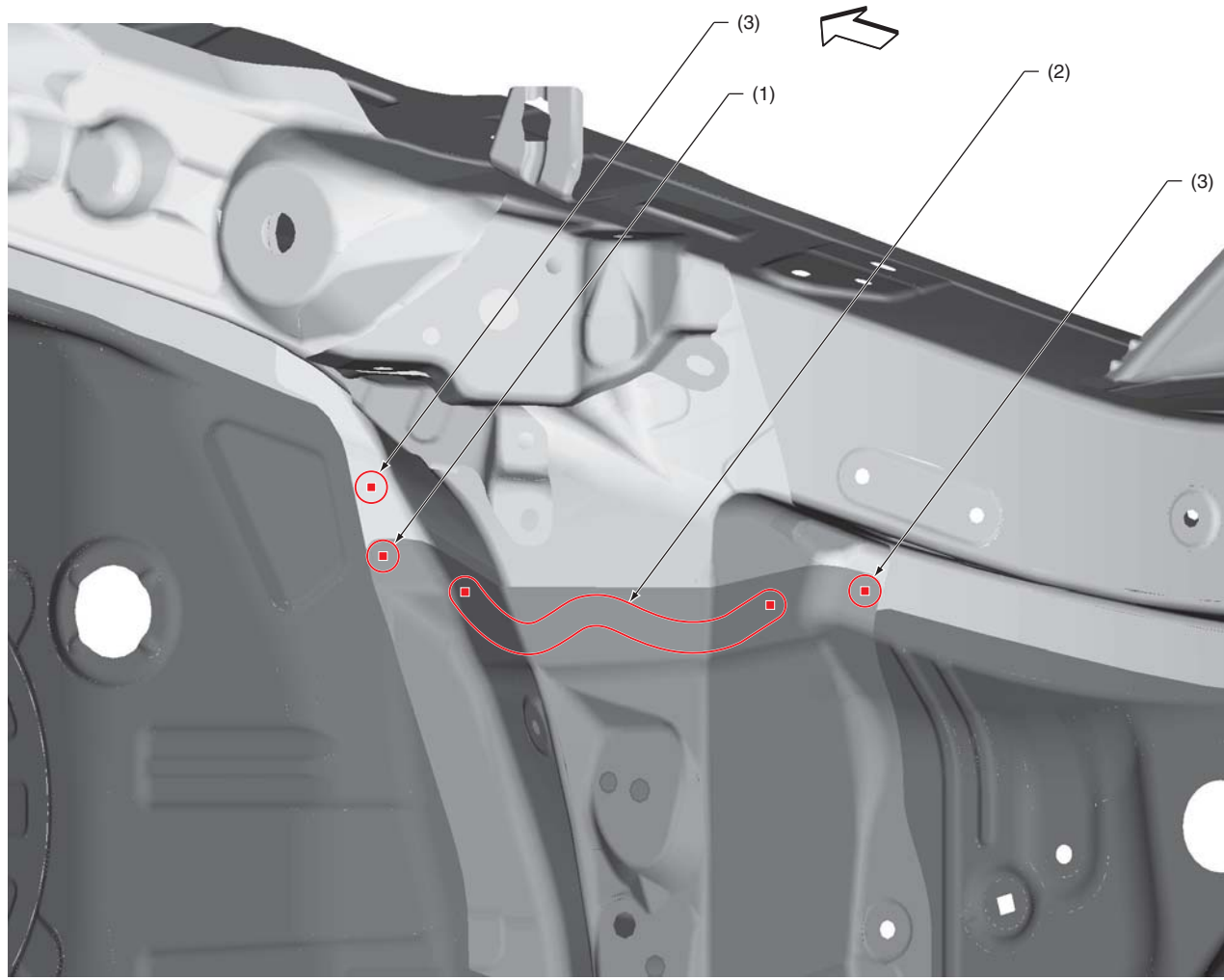
BS-08479

(1) 2 points (service · matching)

(2) 5 points (service)

Panel Replacement

• View C



C

BS-09037

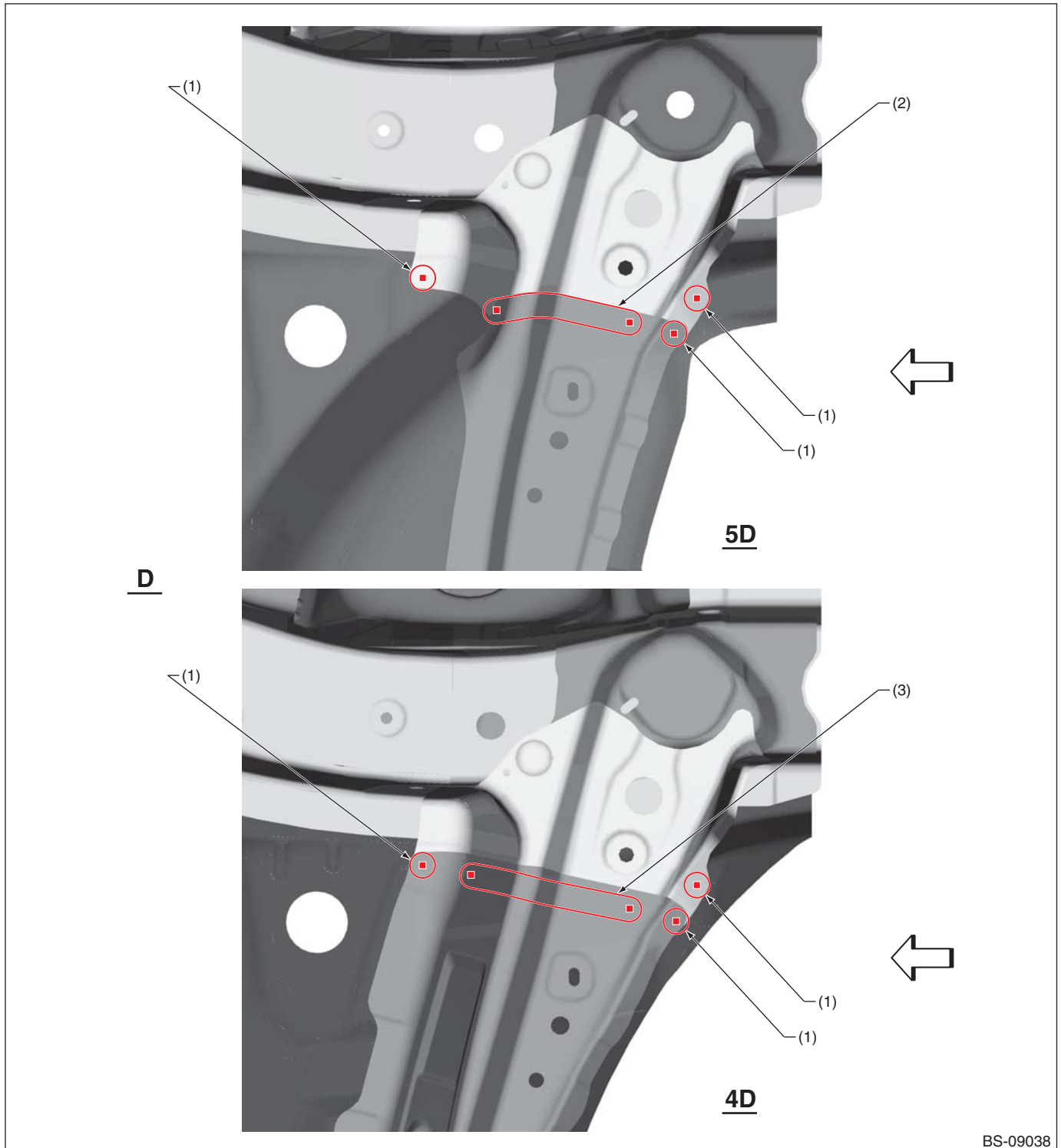
(1) 1 point (service · matching)

(2) 7 points

(3) 1 point

Panel Replacement

• View D



(1) 1 point

(2) 4 points

(3) 5 points

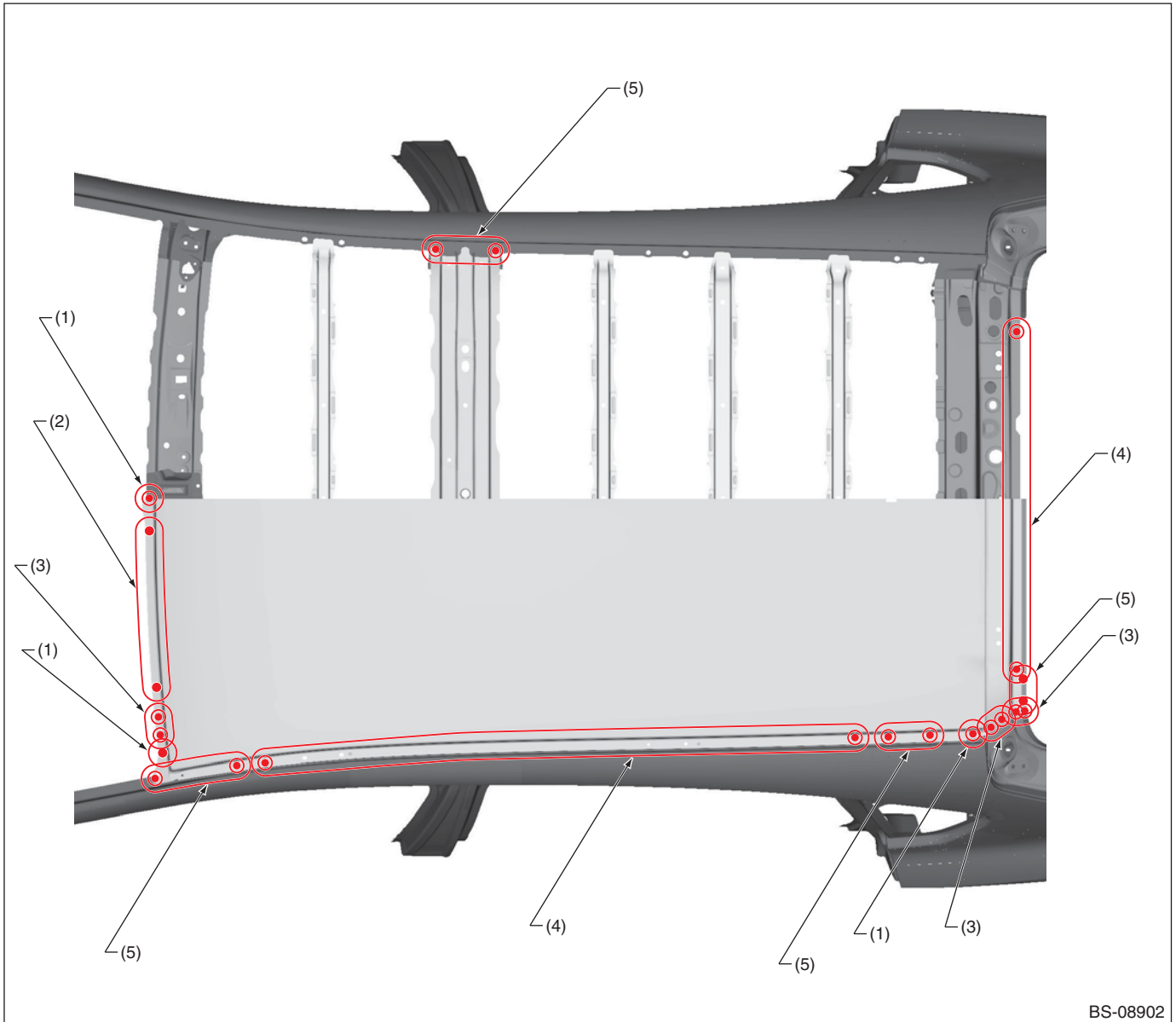
Panel Replacement

8-52. Roof Panel (Total replacement) / 5D

Model without sunroof

A: REMOVAL

• Overall view



BS-08902

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

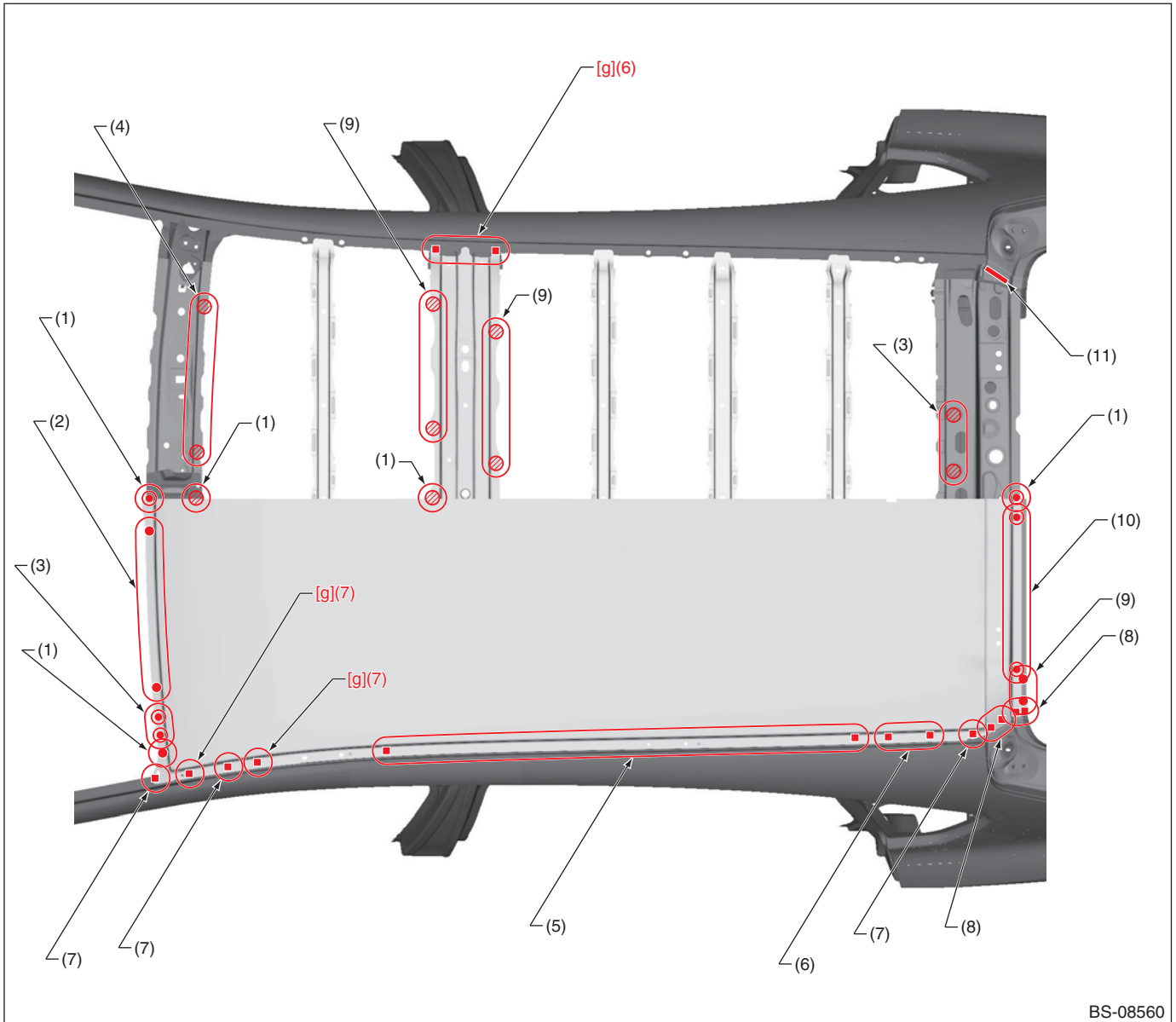
(3) 2 points (top · 1)
(4) 13 points (top · 1)

(5) 3 points (top · 1)

Panel Replacement

B: INSTALLATION

• Overall view



- | | | |
|--------------|-------------------------|--------------------------------|
| (1) 1 point | (5) 12 points (service) | (9) 3 points |
| (2) 5 points | (6) 3 points (service) | (10) 6 points |
| (3) 2 points | (7) 1 point (service) | (11) 1 point (55 mm [2.17 in]) |
| (4) 4 points | (8) 2 points (service) | |

 : Spotting sealer application location
 : Structural adhesive application location

[g] Plug welding

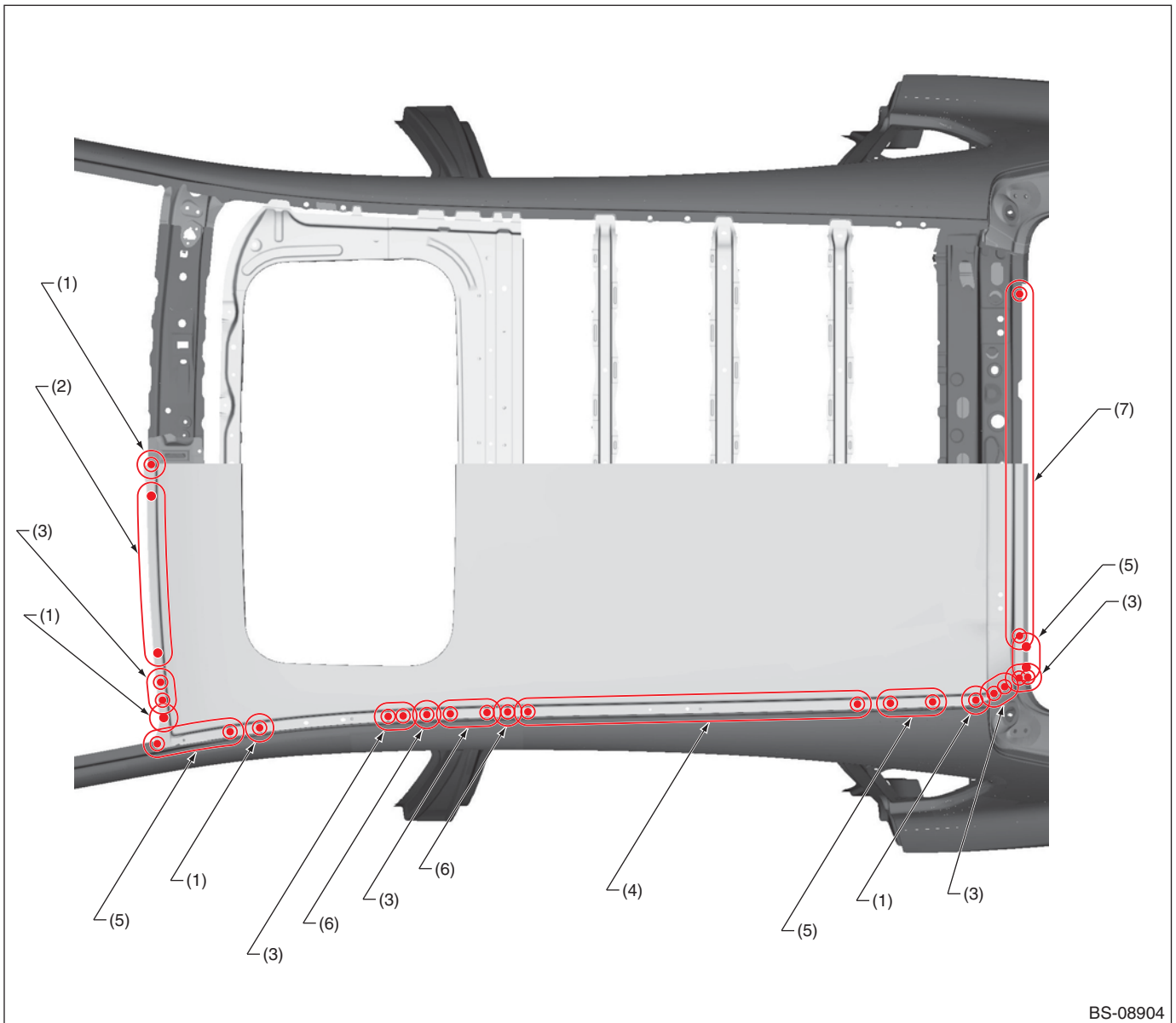
A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2
 B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

Panel Replacement

Model with sunroof

A: REMOVAL

• Overall view



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

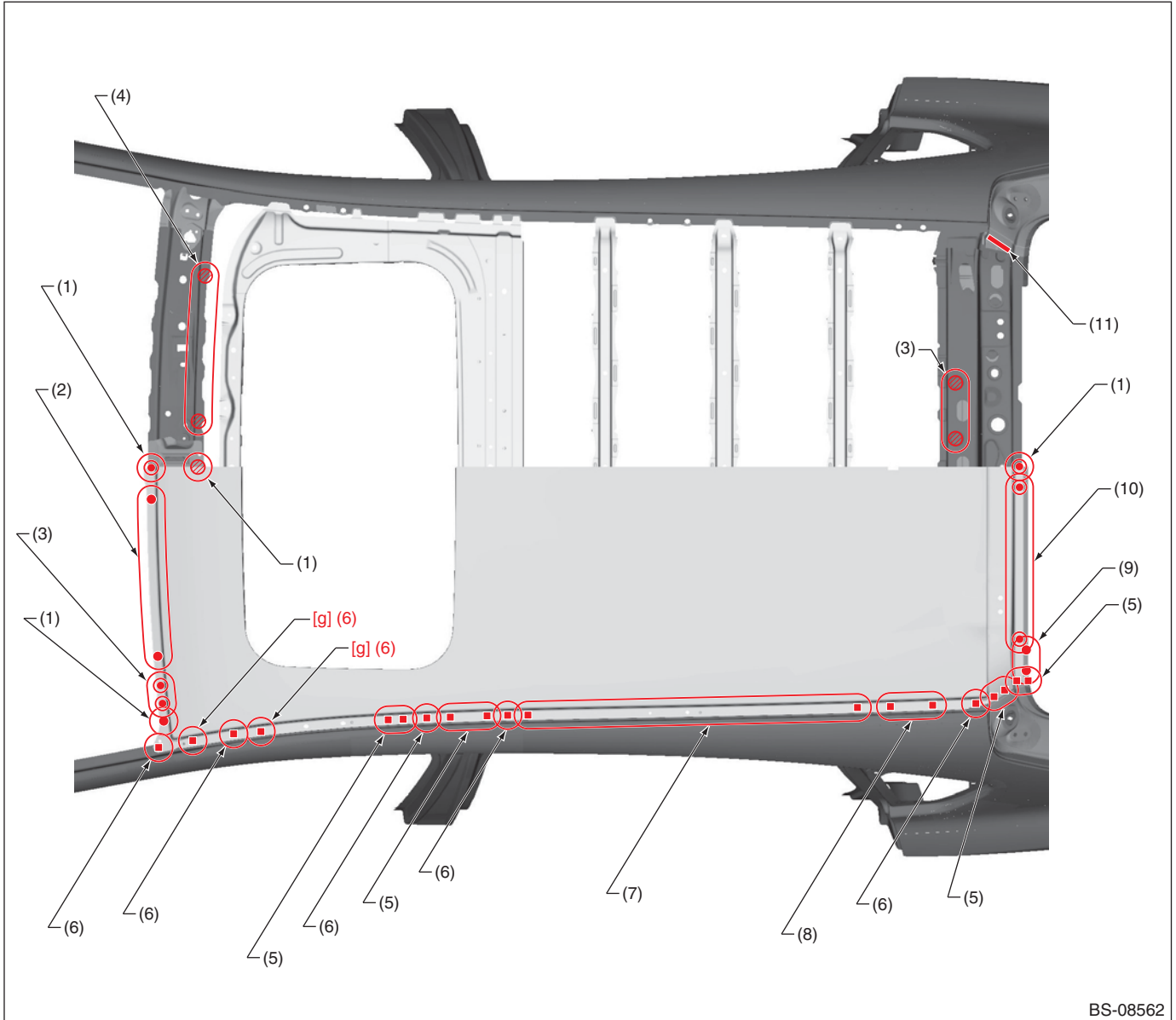
- (4) 8 points (top · 1)
- (5) 3 points (top · 1)

- (6) 1 point (top · 2)
- (7) 13 points (top · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BS-08562

- | | | |
|--------------|------------------------|--------------------------------|
| (1) 1 point | (5) 2 points (service) | (9) 3 points |
| (2) 5 points | (6) 1 point (service) | (10) 6 points |
| (3) 2 points | (7) 8 points (service) | (11) 1 point (55 mm [2.17 in]) |
| (4) 4 points | (8) 3 points (service) | |

 : Spotting sealer application location
 : Structural adhesive application location

[g] Plug welding

A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2

B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

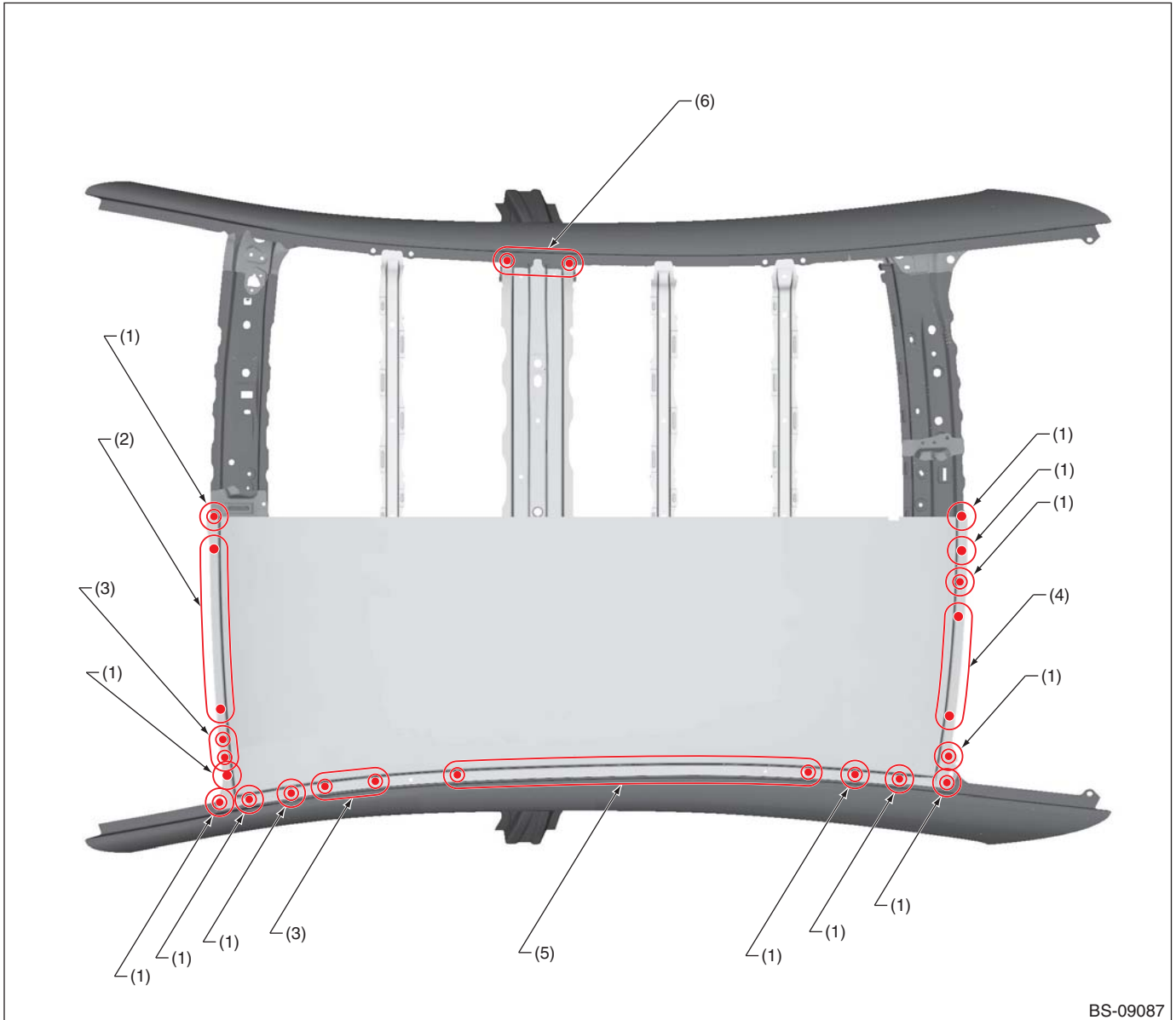
Panel Replacement

8-53. Roof Panel (Total replacement) / 4D

Model without sunroof

A: REMOVAL

• Overall view



BS-09087

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

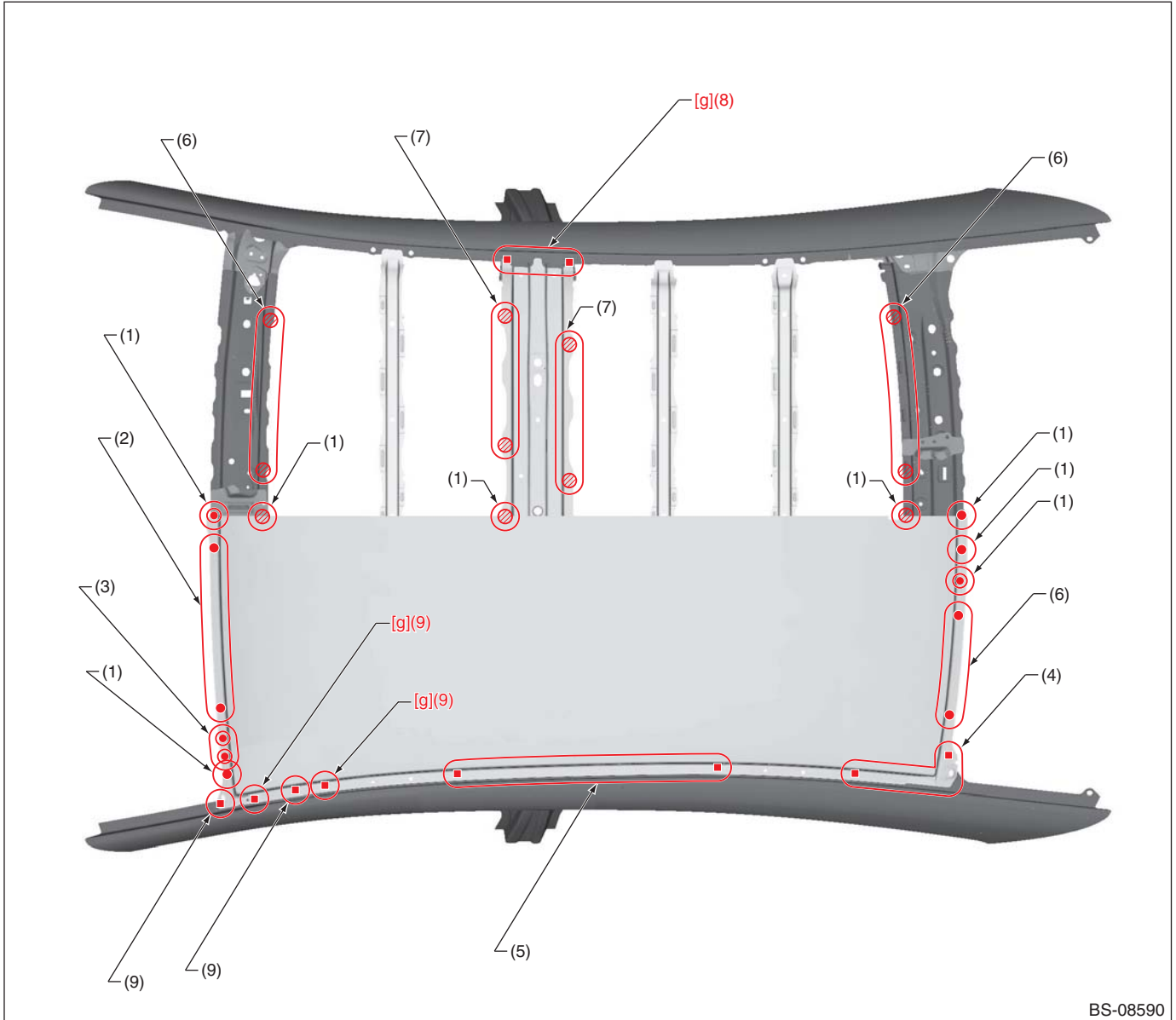
(3) 2 points (top · 1)
(4) 4 points (top · 1)

(5) 12 points (top · 1)
(6) 3 points (top · 1)

Panel Replacement

B: INSTALLATION

• Overall view



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

 : Spotting sealer application location

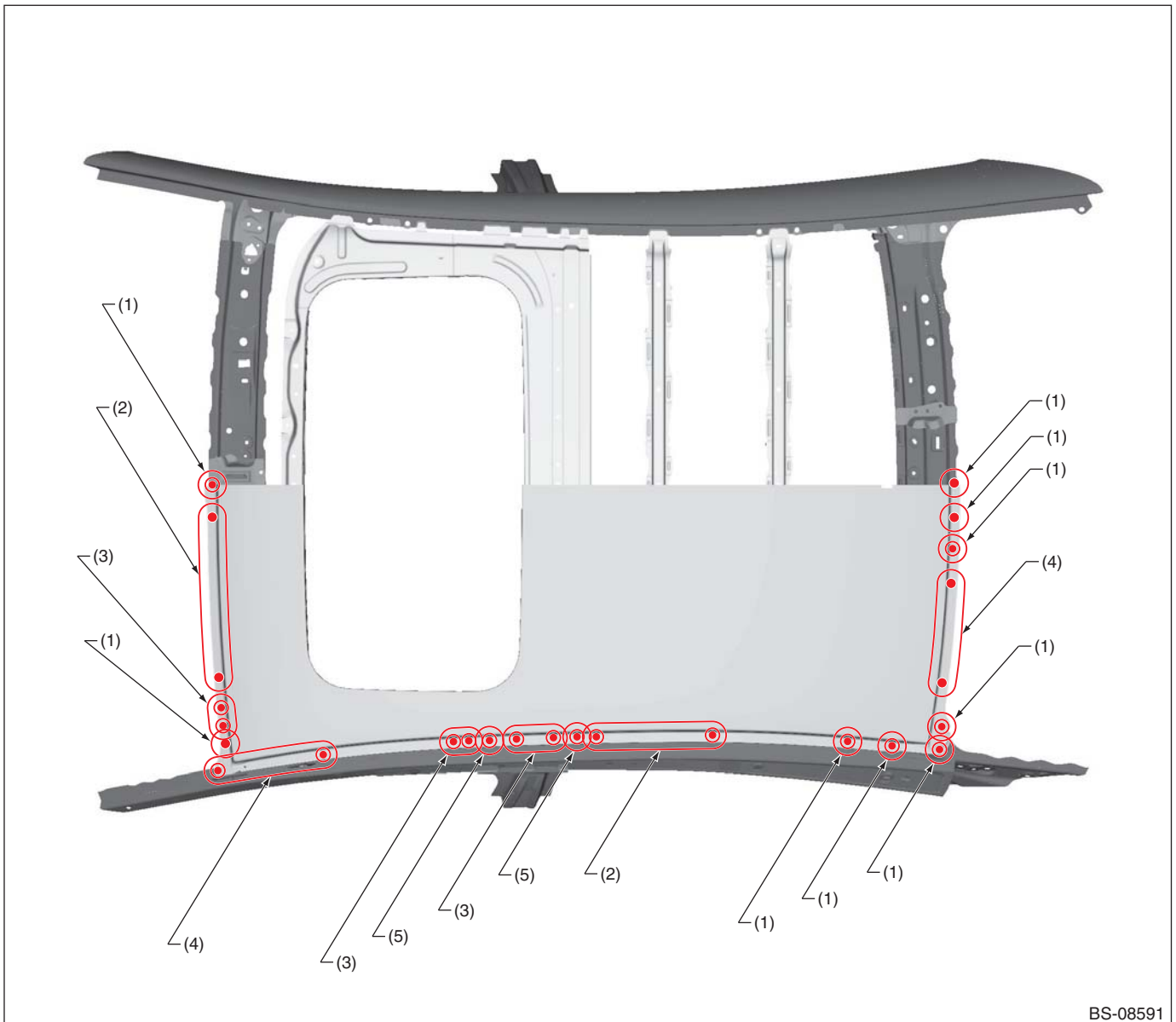
[g] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2 B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)
------------------	---

Panel Replacement

Model with sunroof

A: REMOVAL

• Overall view



BS-08591

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

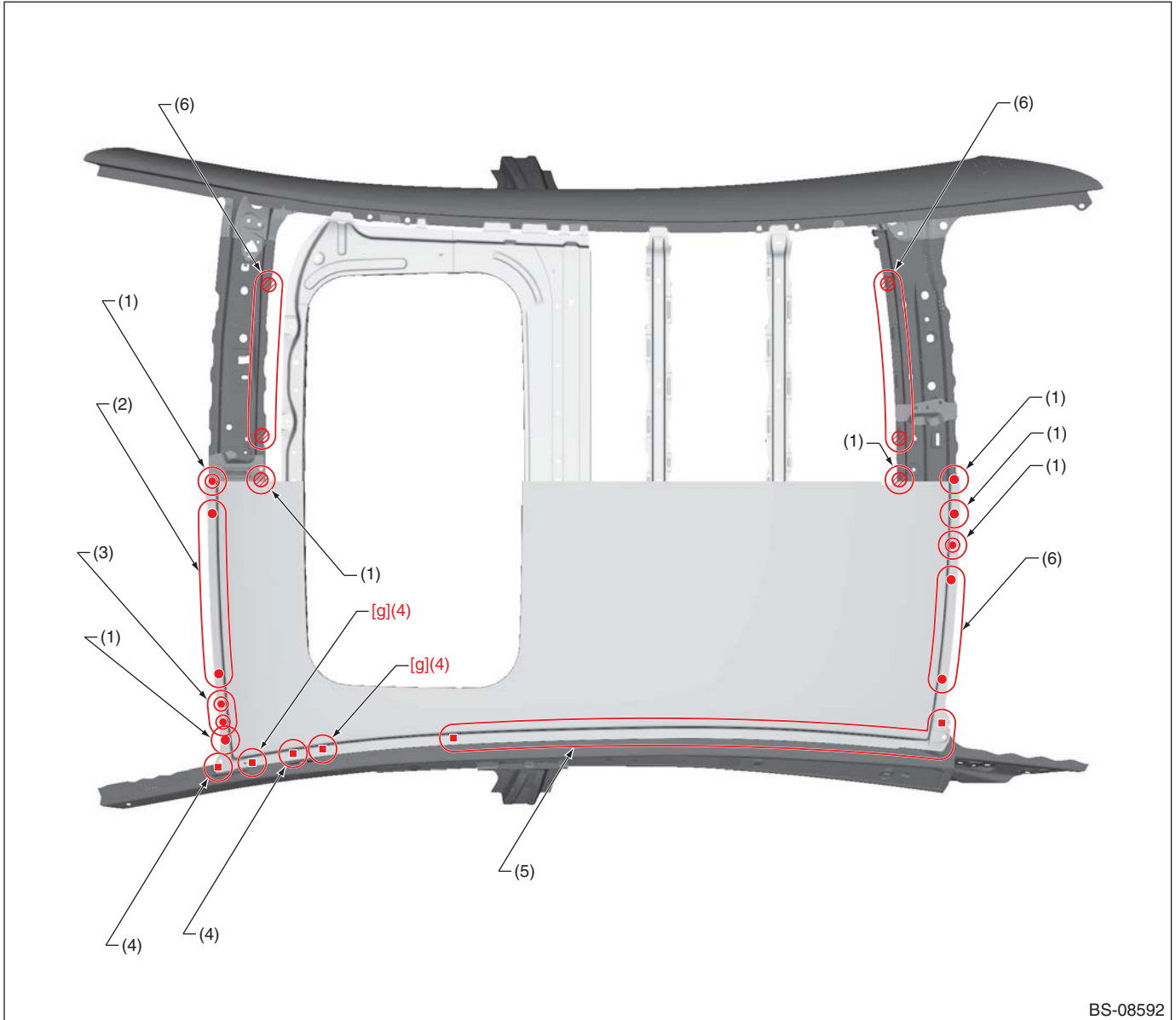
(3) 2 points (top · 1)
(4) 4 points (top · 1)

(5) 1 point (top · 2)

Panel Replacement

B: INSTALLATION

• Overall view



(1) 1 point

(2) 5 points

(3) 2 points

(4) 1 point (service)

(5) 15 points (service)

(6) 4 points

 : Spotting sealer application location

 : Structural adhesive application location

[g] Plug welding

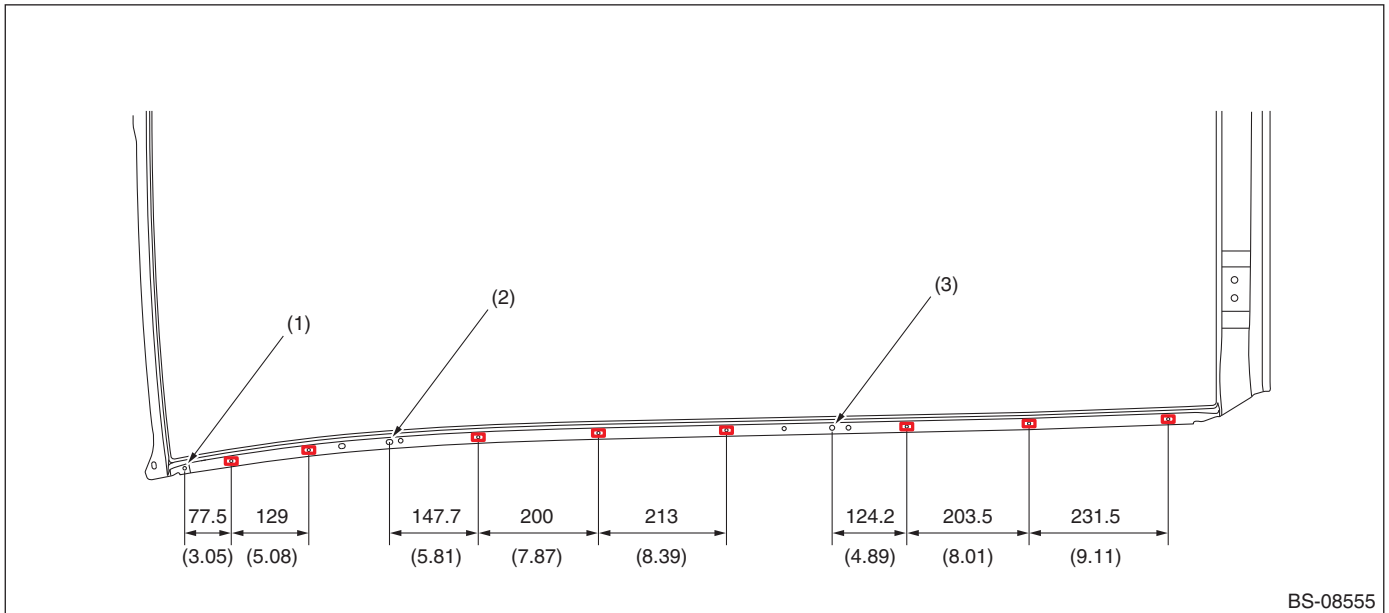
A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO2

B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO2: 20 %)

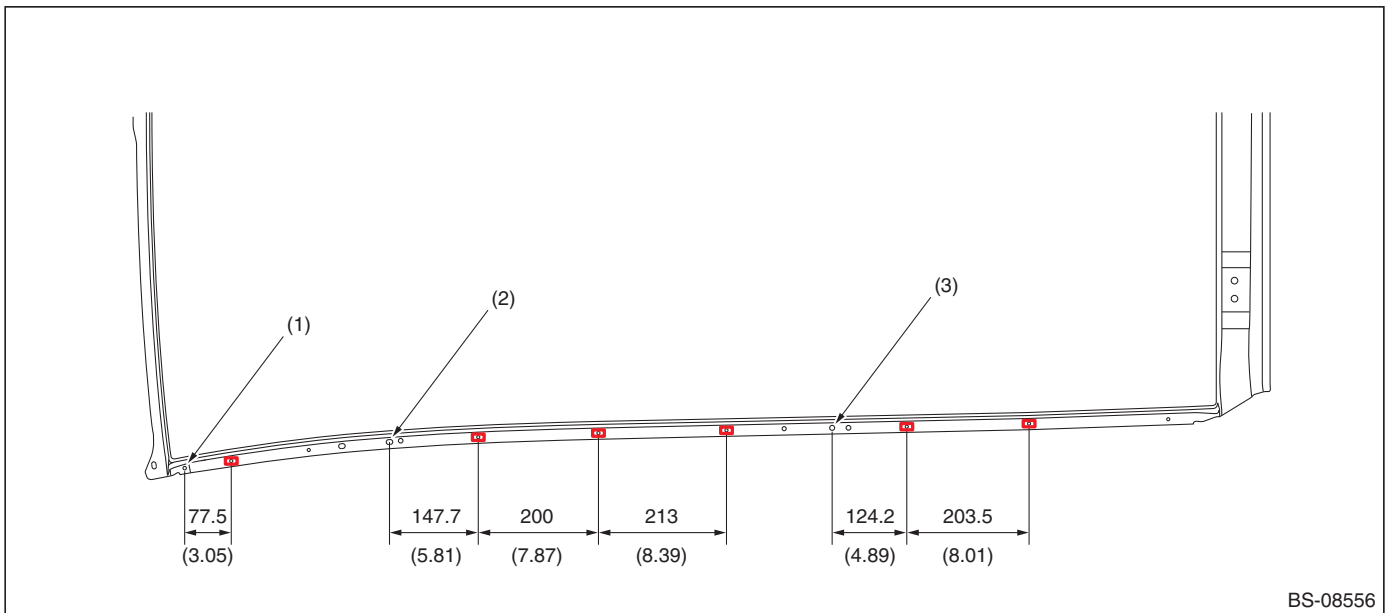
Panel Replacement

8-54. T Stud Installation

• 5 Door (Model without roof rail)

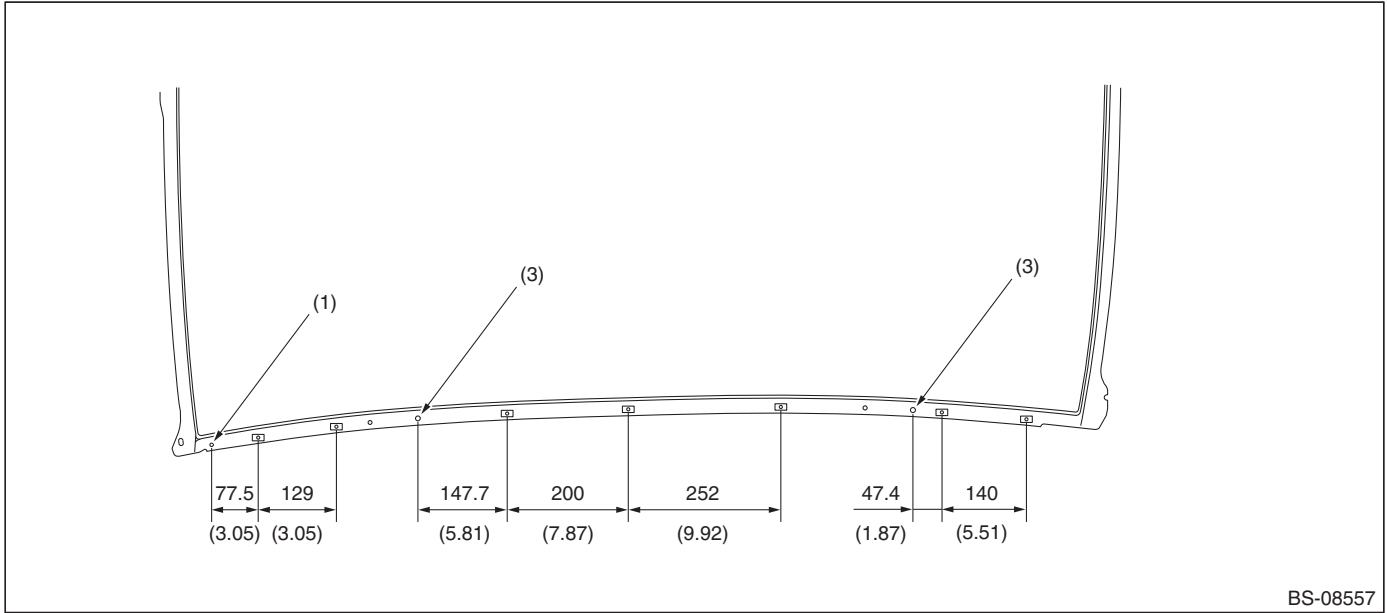


• 5 Door (Model with roof rail)

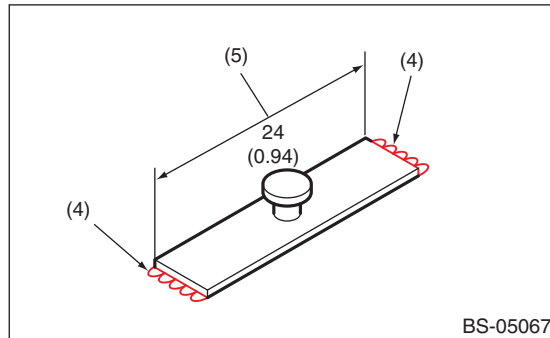


Panel Replacement

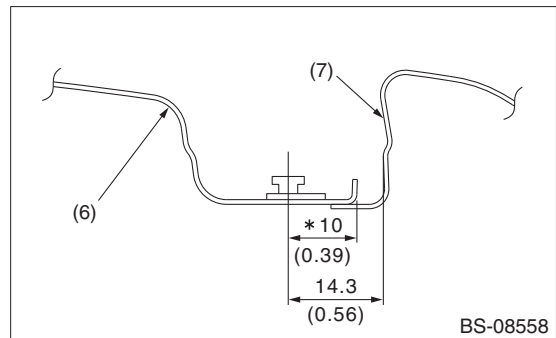
• 4 Door



• T stud welding



• T stud basic cross section



- | | | |
|---|--|----------------------|
| (1) $\phi 5.2$ mm (0.20 in) hole (for roof mole, standard pop rivet hole) | (4) Arc welding for both plate ends | (7) Panel side outer |
| (2) $\phi 8.1 \times 11$ mm (3.51 in) elongated hole (for carrier bracket installation) | (5) This surface shall be kept flat as it becomes the mating face with the clip. | |
| (3) $\phi 8.1$ mm (0.32 in) hole (for carrier bracket installation) | (6) Roof panel | |

* : Indicates dimensions for reference.

9. Body Sealing

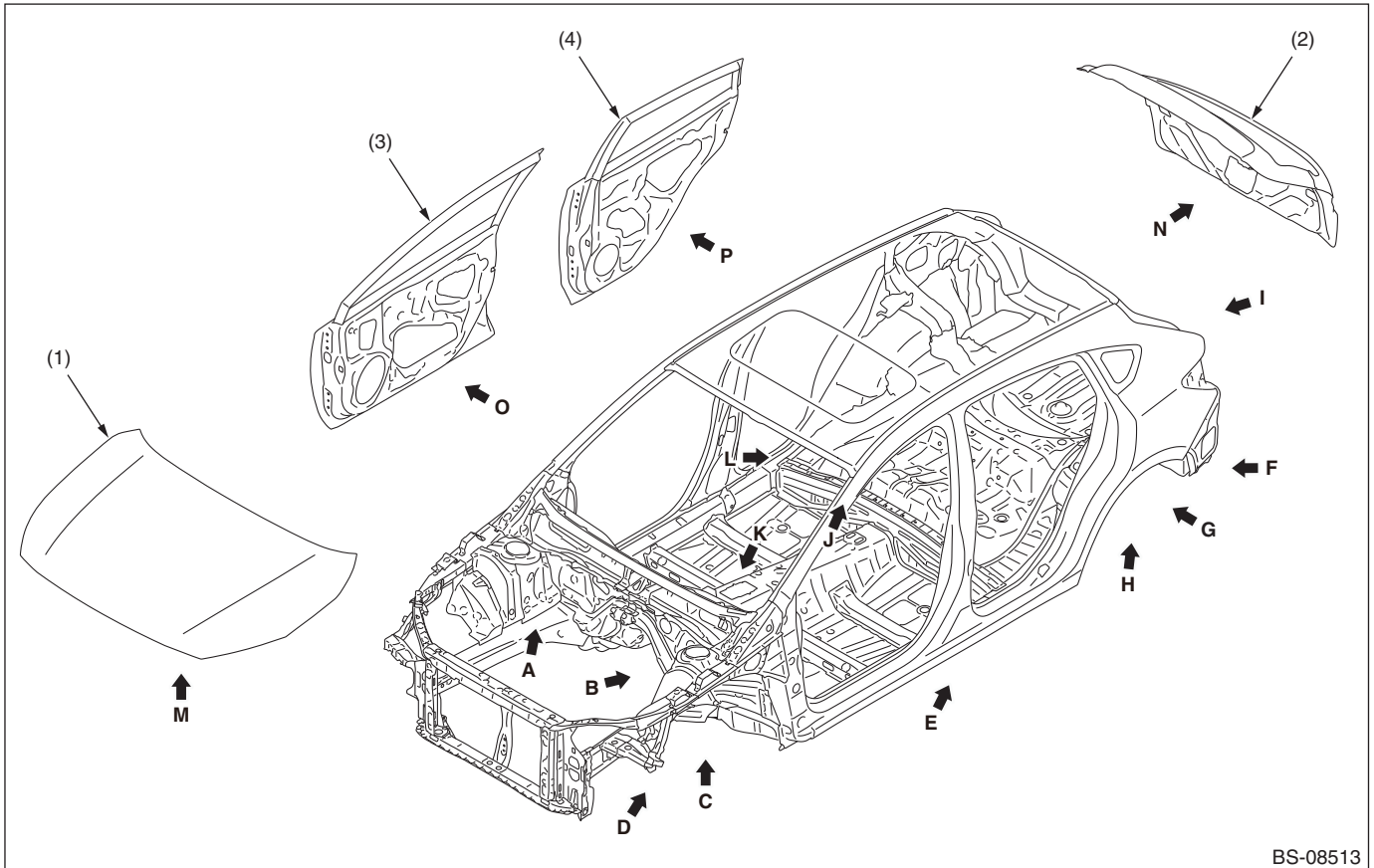
A: SPECIFICATIONS

Used material: Three Bond 4101 (004403063)

— : Sealer application location

▨ : Sealer application location (Application of 50 μm thick wax is allowable.)

• COMMON PARTS FOR 5 DOOR AND 4 DOOR



BS-08513

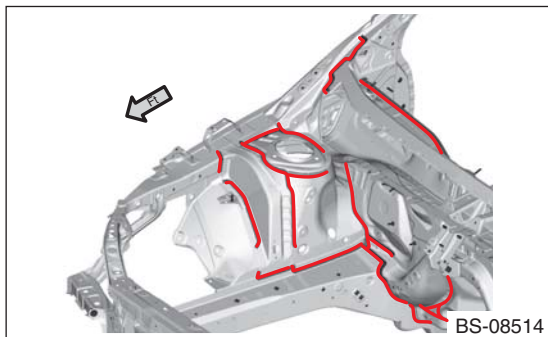
(1) Front hood

(3) Front door

(4) Rear door

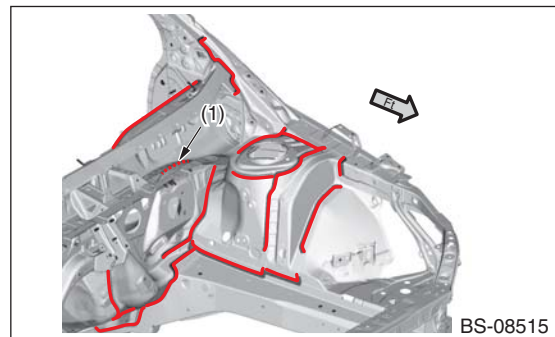
(2) Rear gate

View A



BS-08514

View B

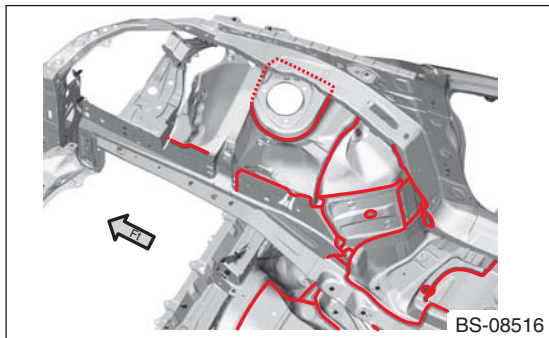


BS-08515

(1) LH only

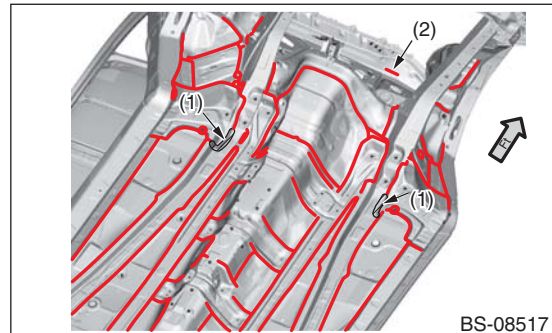
Body Sealing

View C



BS-08516

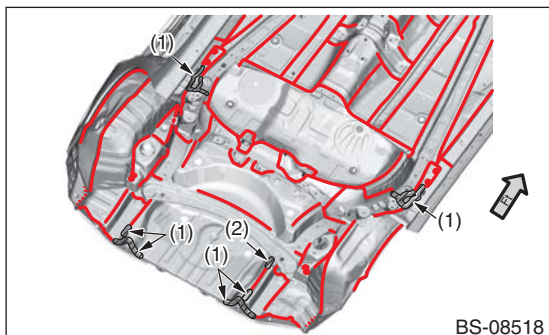
View D



BS-08517

- (1) Adherence of anticorrosion wax is allowable.
- (2) LH only

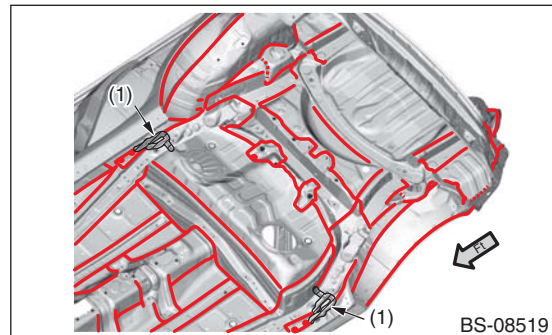
View E



BS-08518

- (1) Adherence of anticorrosion wax is allowable.
- (2) Adherence of anticorrosion wax is allowable. (LH only)

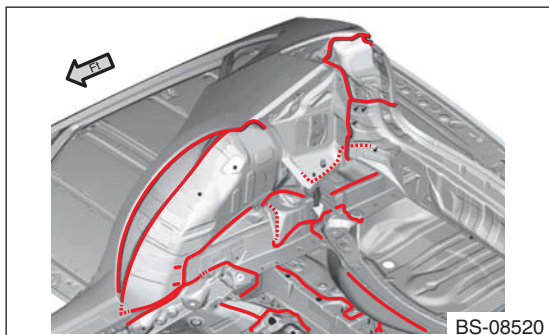
View F



BS-08519

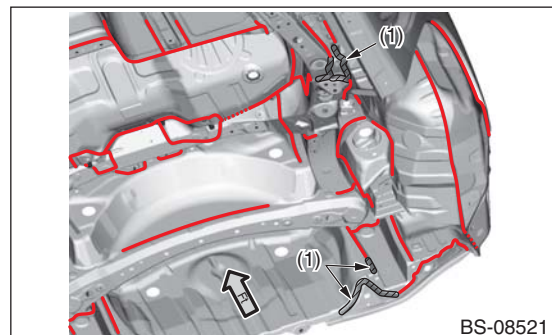
- (1) Adherence of anticorrosion wax is allowable.

View G



BS-08520

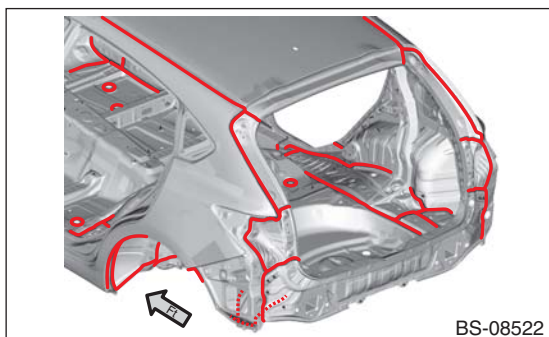
View H



BS-08521

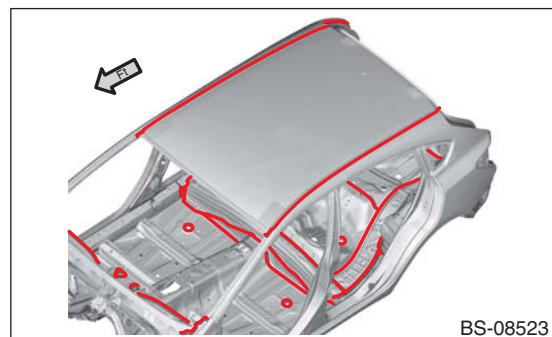
- (1) Adherence of anticorrosion wax is allowable.

View I



BS-08522

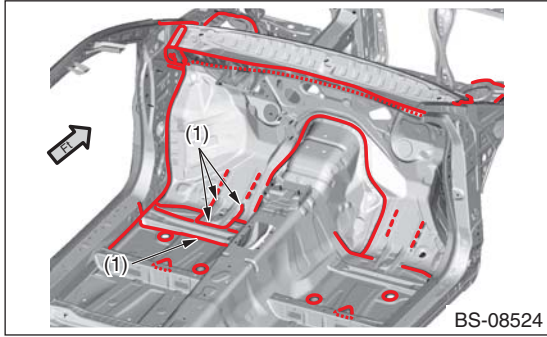
View J



BS-08523

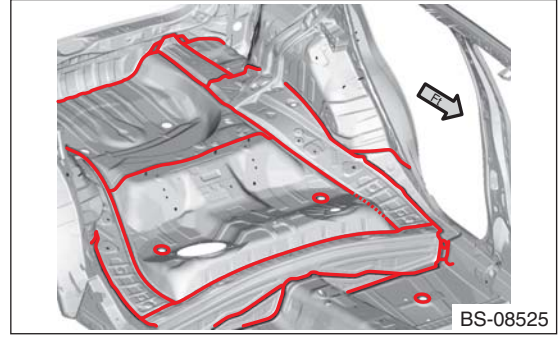
Body Sealing

View K

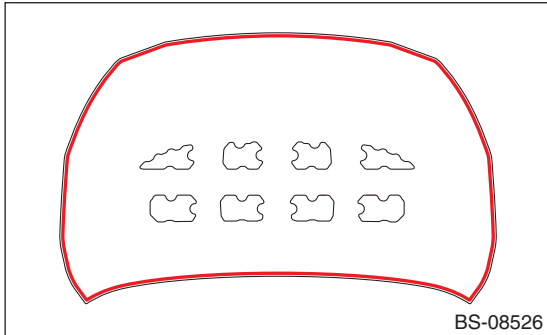


(1) LH only

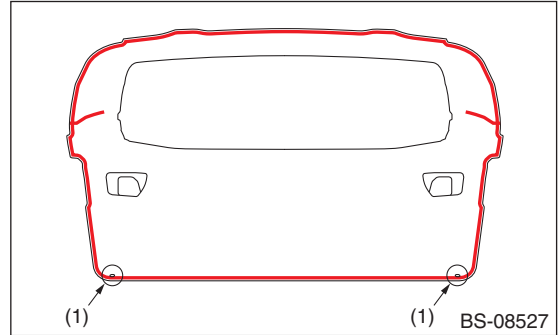
View L



View M

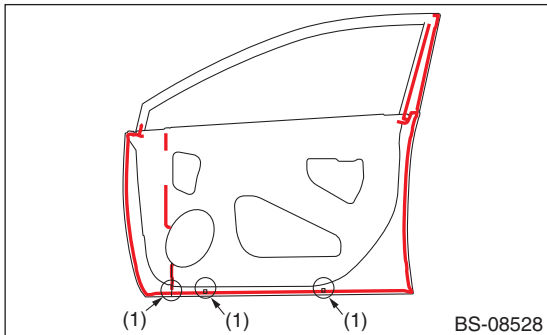


View N



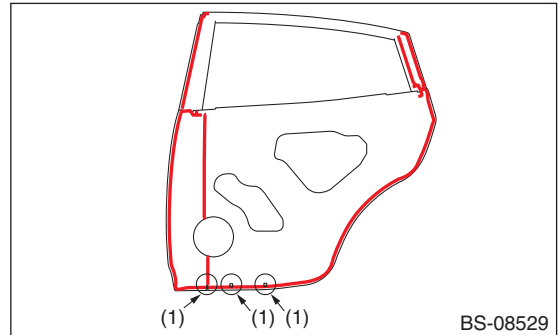
(1) Do not block the water drain holes.

View O



(1) Do not block the water drain holes.

View P



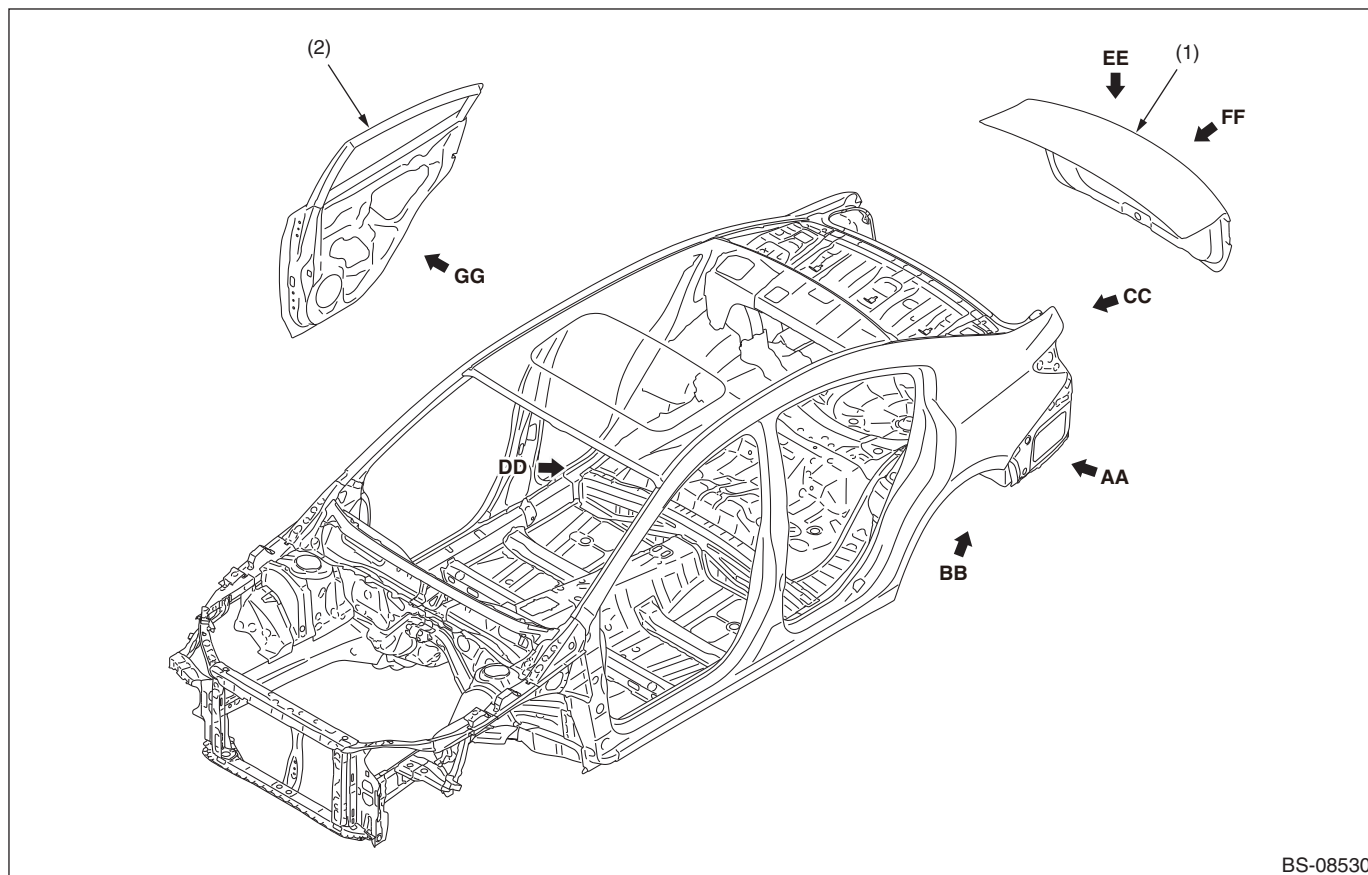
(1) Do not block the water drain holes.

CAUTION:

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

Body Sealing

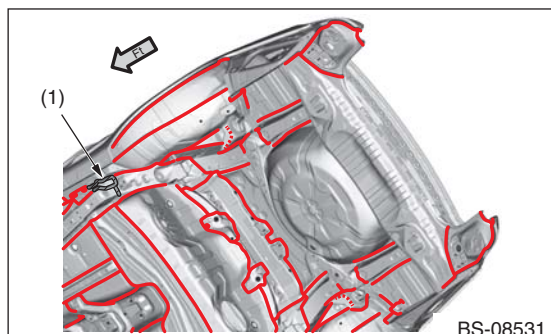
• SPECIAL 4 DOOR PARTS



(1) Trunk

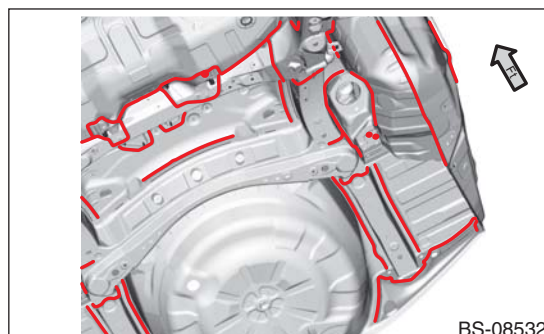
(2) Rear door

View AA



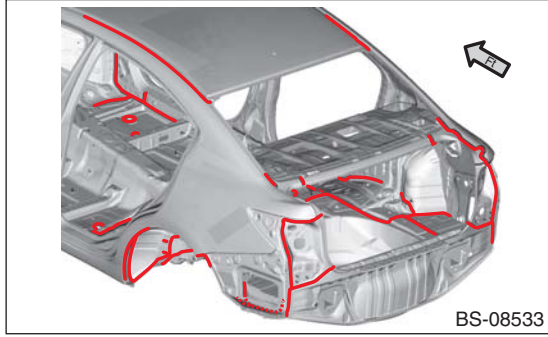
(1) Adherence of anticorrosion wax is allowable.

View BB

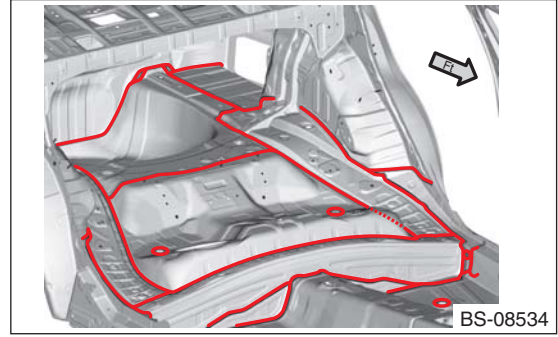


Body Sealing

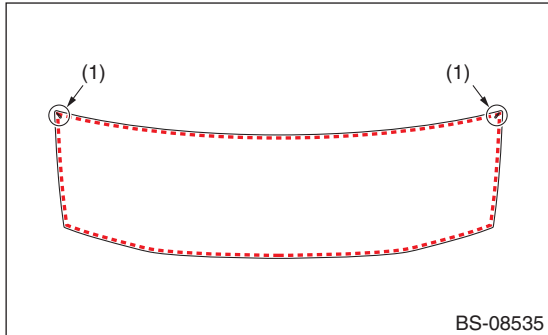
View CC



View DD

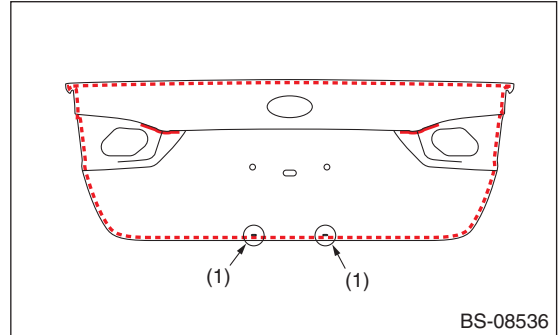


View EE



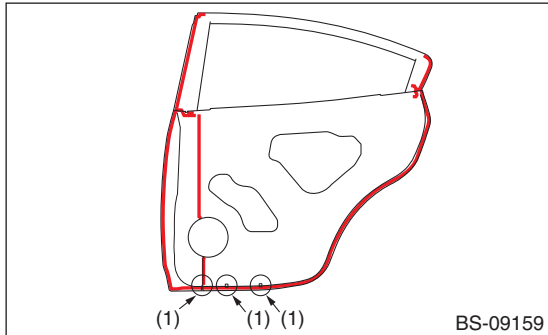
(1) The hole shall be blocked.

View FF



(1) Do not block the water drain holes.

View GG



(1) Do not block the water drain holes.

SUBARU.

CAUTION:

Sealer has already been applied to trunk and door that are in replacement condition.

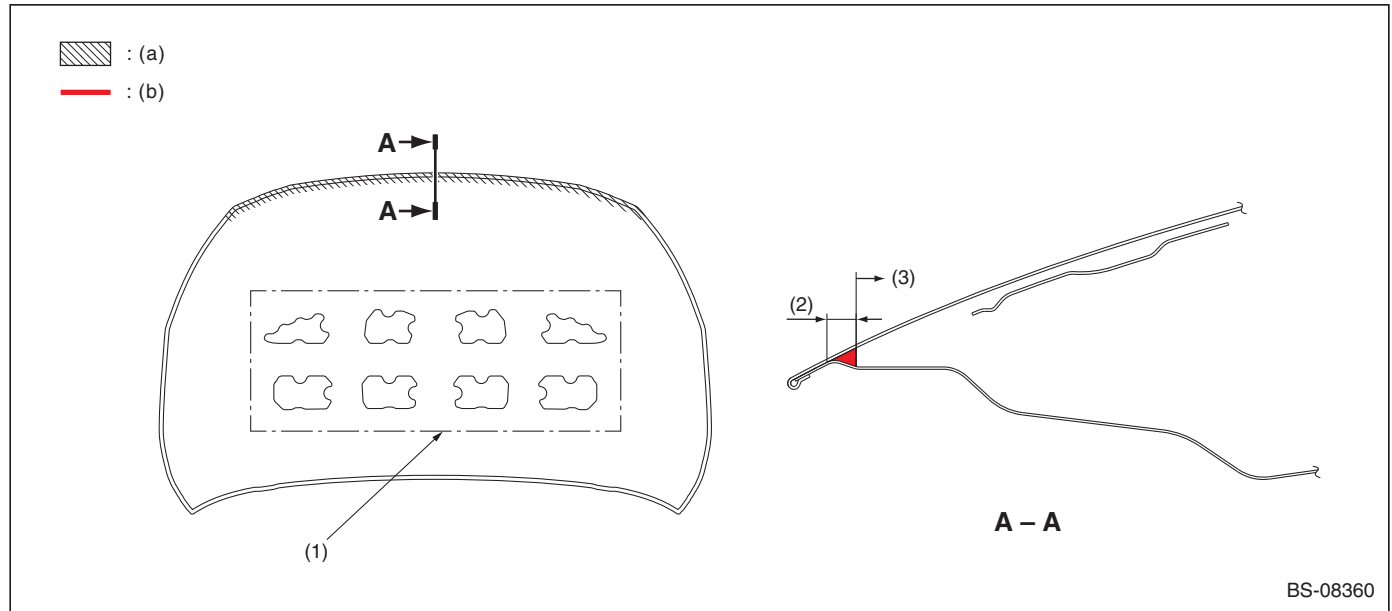
10. Anticorrosion Wax

A: SPECIFICATIONS

Used material: Rust-stop aerosol (K0877YA015)

— and ▨ : Application area

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



(a) Rust-stop aerosol

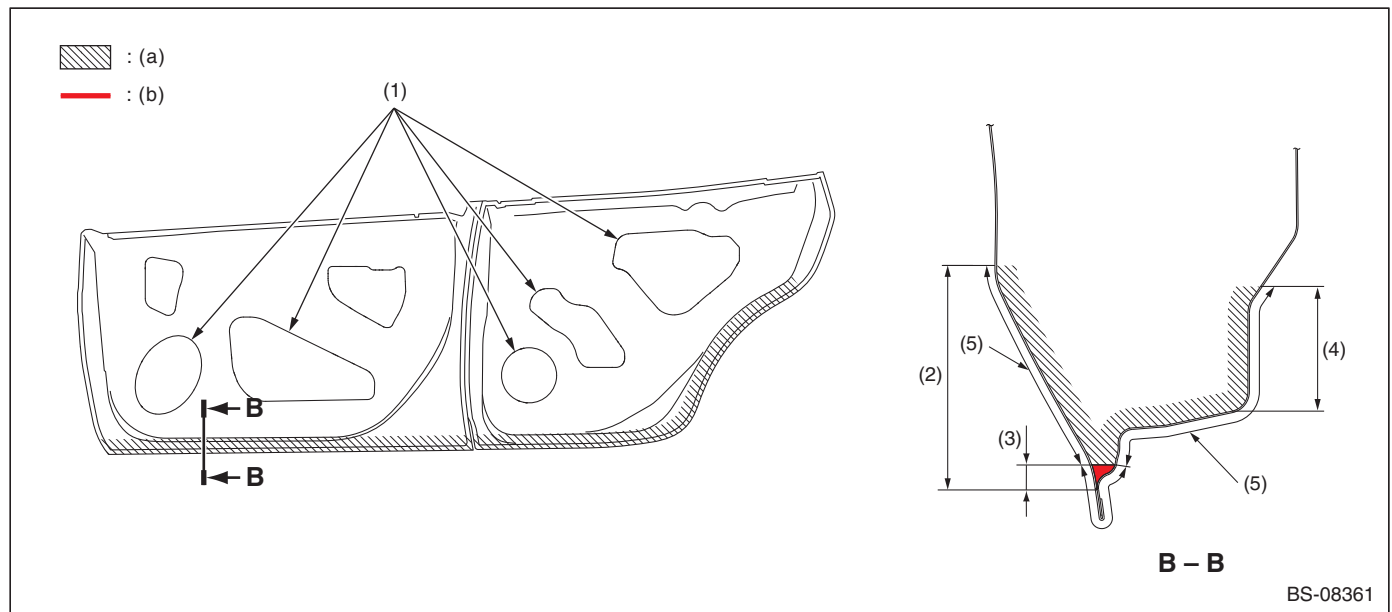
(b) To be filled into the plate joint.

(1) Wax application work openings

(2) 10 mm (0.39 in)

(3) Adherence of mist is allowable.

- Door (Application thickness = 50 μm or more)



(a) Rust-stop aerosol

(b) To be filled into the plate joint.

(1) Wax application work openings

(3) 10 mm (0.39 in)

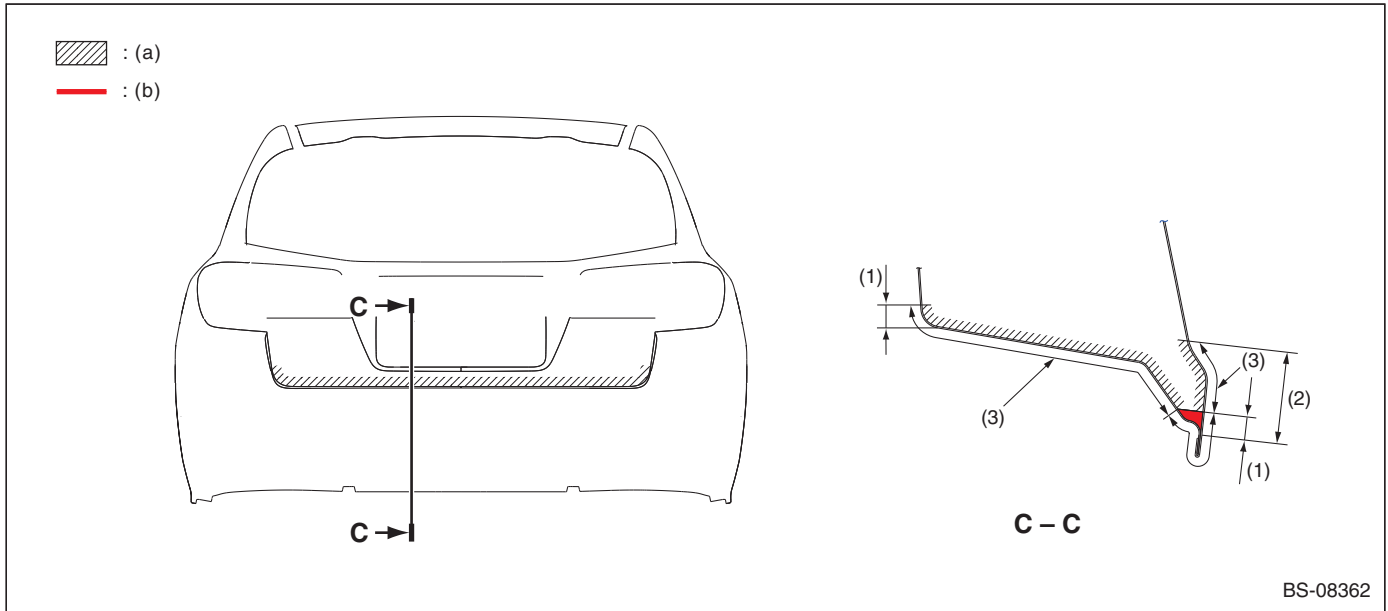
(5) Adherence of mist is allowable.

(2) 90 mm (3.54 in)

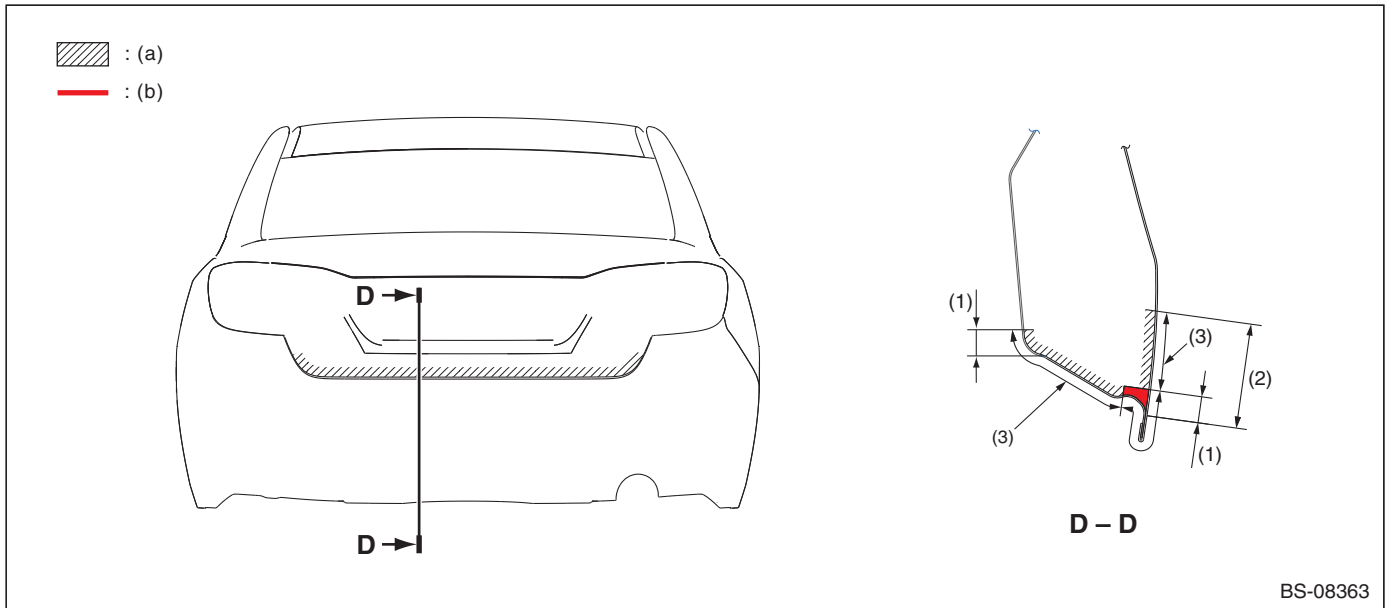
(4) 50 mm (1.97 in)

Anticorrosion Wax

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



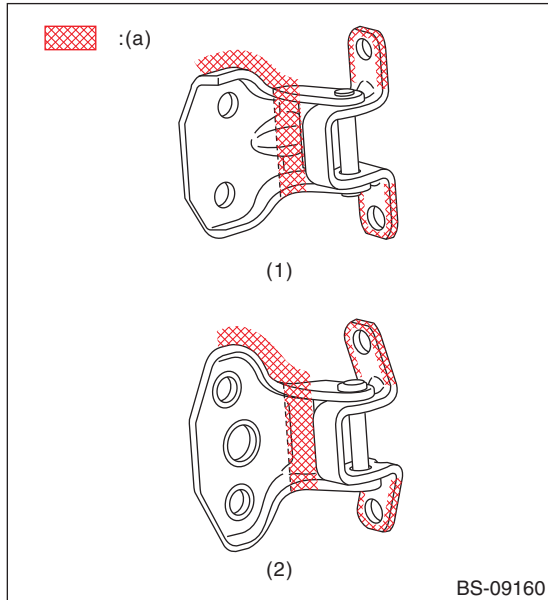
- Trunk lid (Application thickness = 50 μm or more)



Anticorrosion Wax

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

Apply to the contact surface on the body side in two locations on the left and right, to the outer edges (application range, plate edges) on the door side and to the head of the bolts.

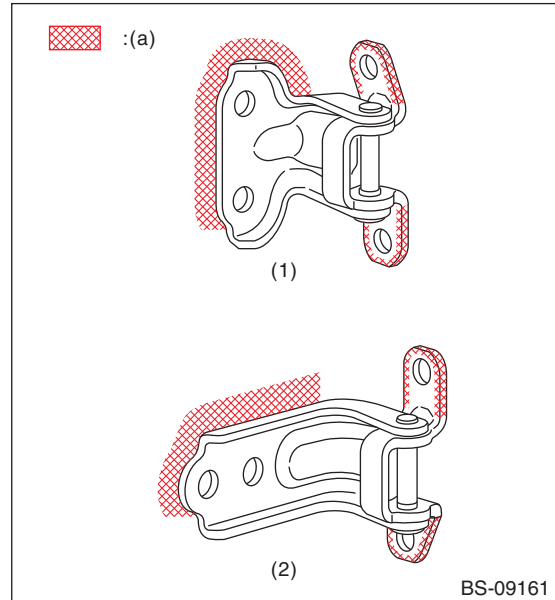


(a) Rust-stop aerosol

- (1) Upper side
- (2) Lower side

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

Apply to the contact surface on the body side in two locations on the left and right, to the outer edges (application range, plate edges) on the door side and to the head of the bolts.



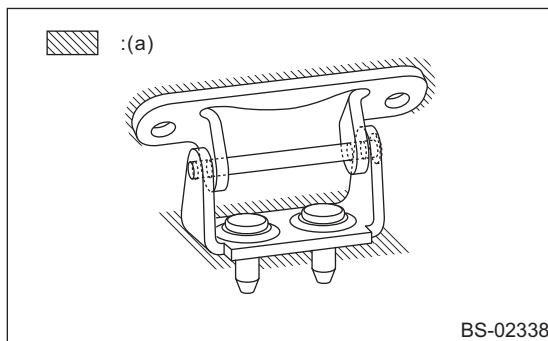
(a) Rust-stop aerosol

- (1) Upper side
- (2) Lower side

- Rear gate hinge

(Application thickness = 50 μm or more)

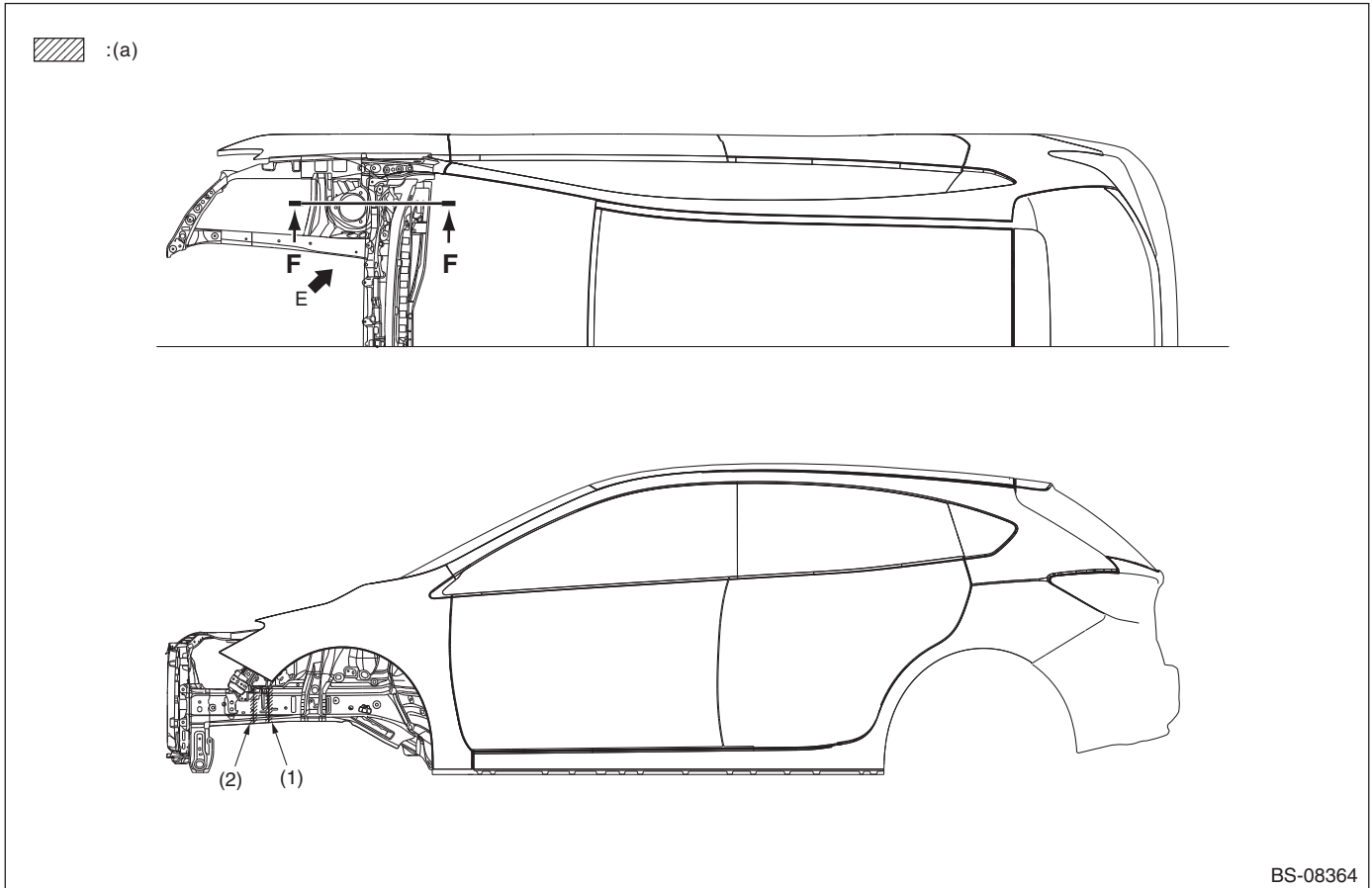
Apply to the contact surface on the body side at two locations on the left and right, and to installation outer circumference (indicated range, plate edges) on the rear gate side.



(a) Rust-stop aerosol

Anticorrosion Wax

• Overall view



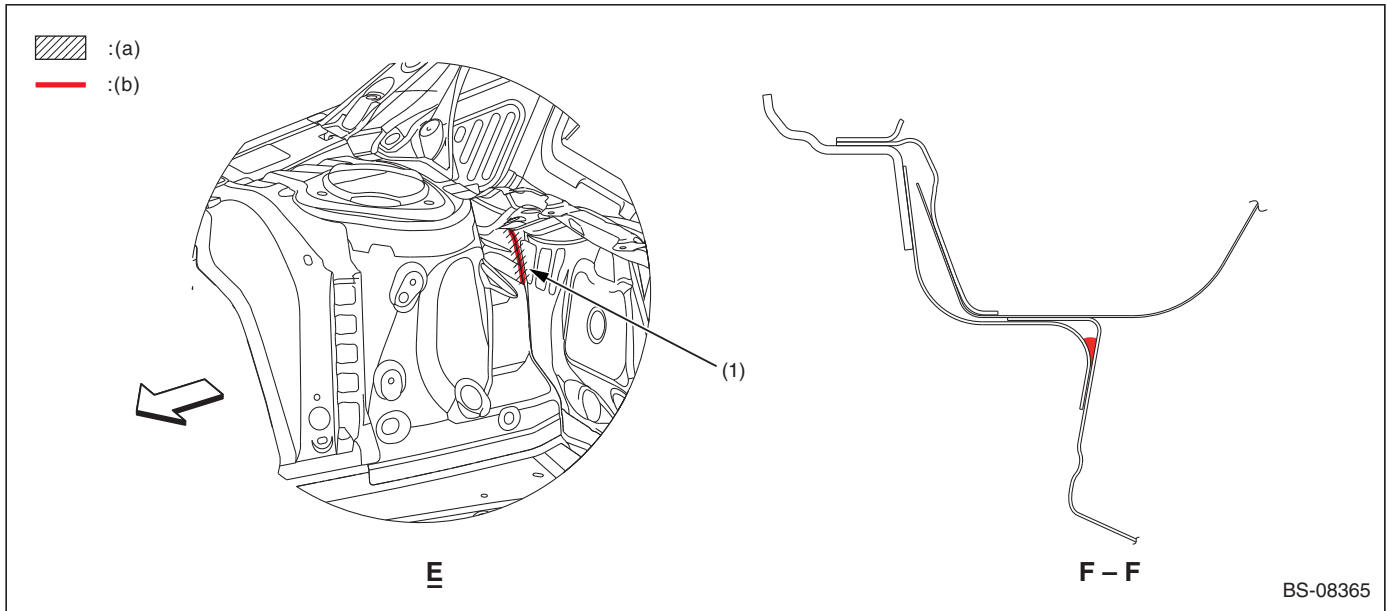
BS-08364

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

(1) The panel joints shall be covered. (2) The panel joints on the inside of the engine compartment shall be covered.

Anticorrosion Wax

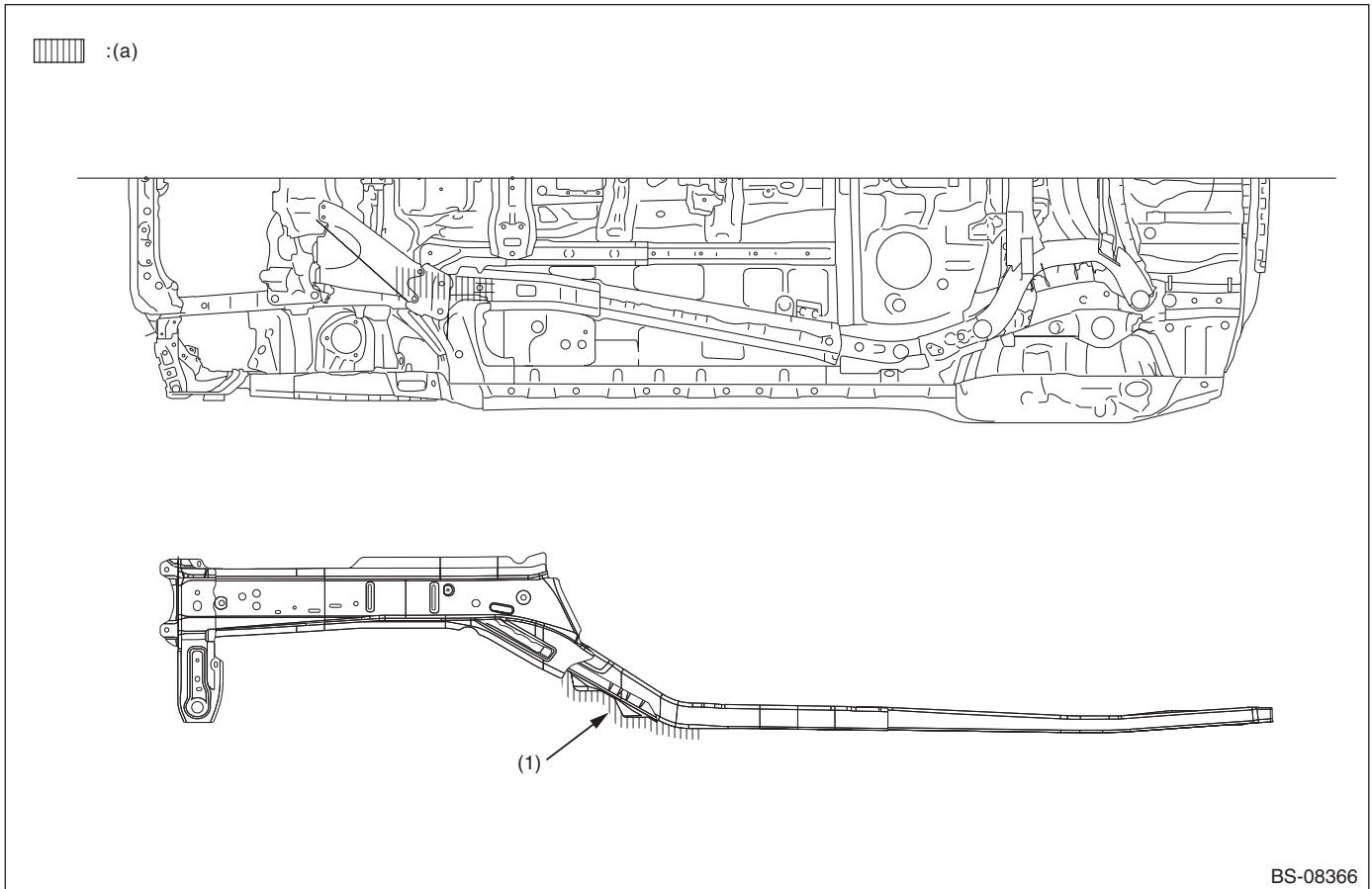
• View / Cross section



- (a) Rust-stop aerosol
(Application thickness = 50 μm or more)
- (b) To be filled into the plate joint.
- (1) Securely cover the contact surface of the toe board, front suspension bracket.

Anticorrosion Wax

• Bottom view 1

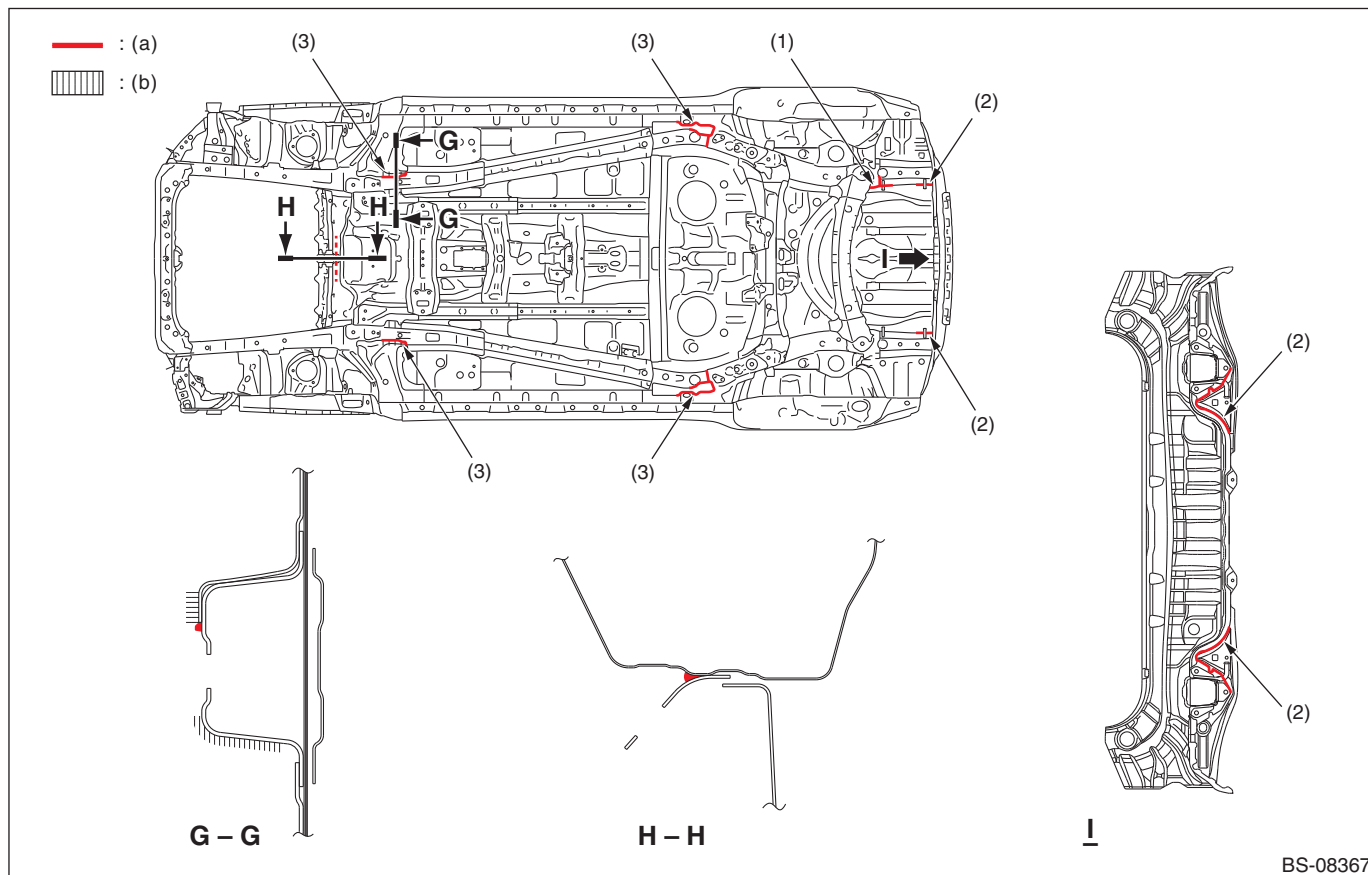


BS-08366

- (a) Rust-stop aerosol
(Application thickness = 150 μm or more).
- (1) Application shall be done without the transverse link bush coated.

Anticorrosion Wax

• Bottom view 2



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

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

(1) Only for LH of 5 Door
(Sealer is allowable)

(2) 5 Door Only (Sealer is allowable)

(3) Commonly used in 5 Door and 4 Door (Sealer is allowable)

11.Undercoat

A: SPECIFICATIONS

Repair material: PVC (NT guardcoat 5900FL)

CAUTION:

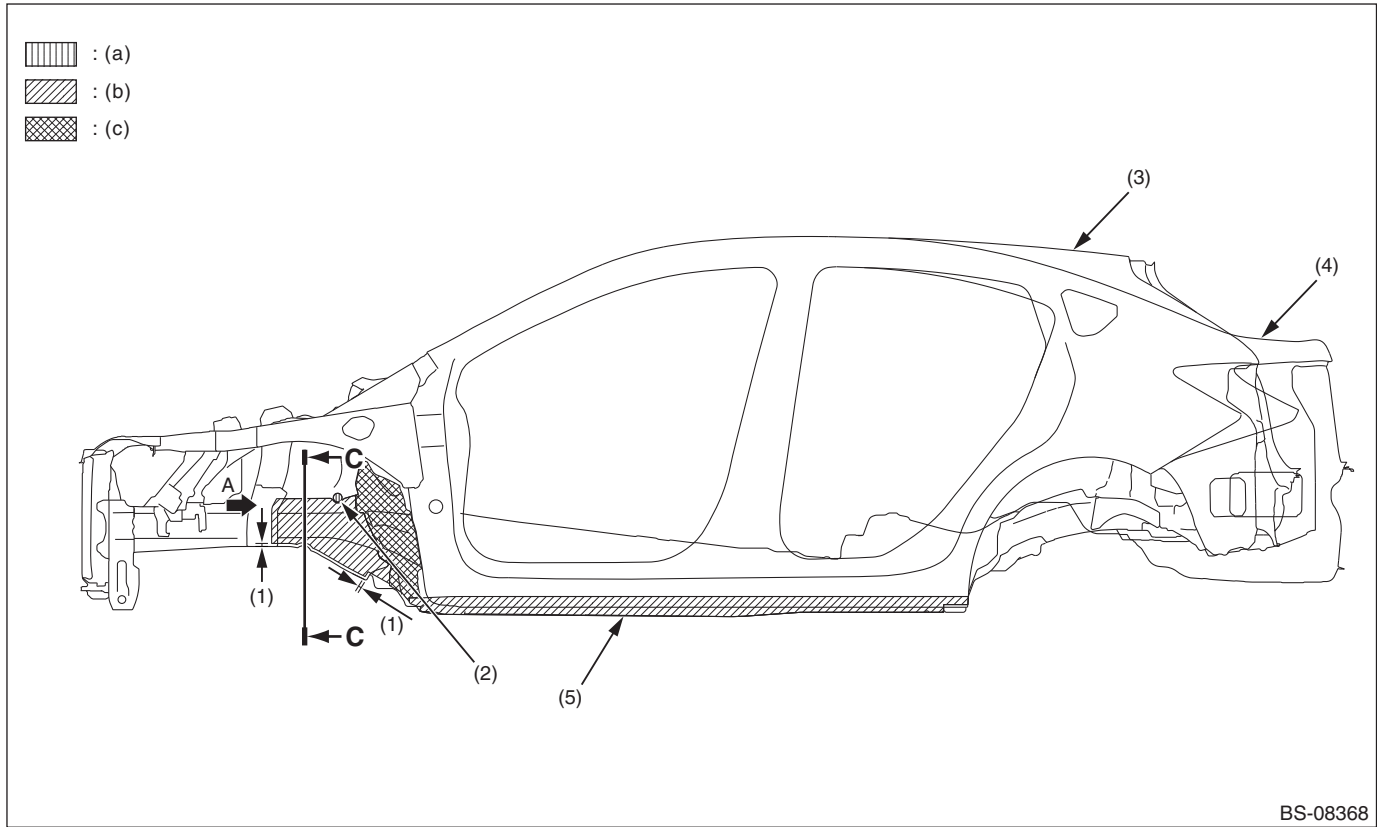
Be careful not to let the undercoating be attached to any parts not indicated below and to the following locations.

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

1) Application area and application thickness

	200 μm or more
	Dry: 340 μm or more, Wet: 330 μm or more
	Dry: 780 μm or more, Wet: 630 μm or more

• Side view



(a) 200 μm or more

(b) Dry: 340 μm or more
Wet: 330 μm or more

(c) Dry: 780 μm or more
Wet: 630 μm or more

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

(3) 5 Door

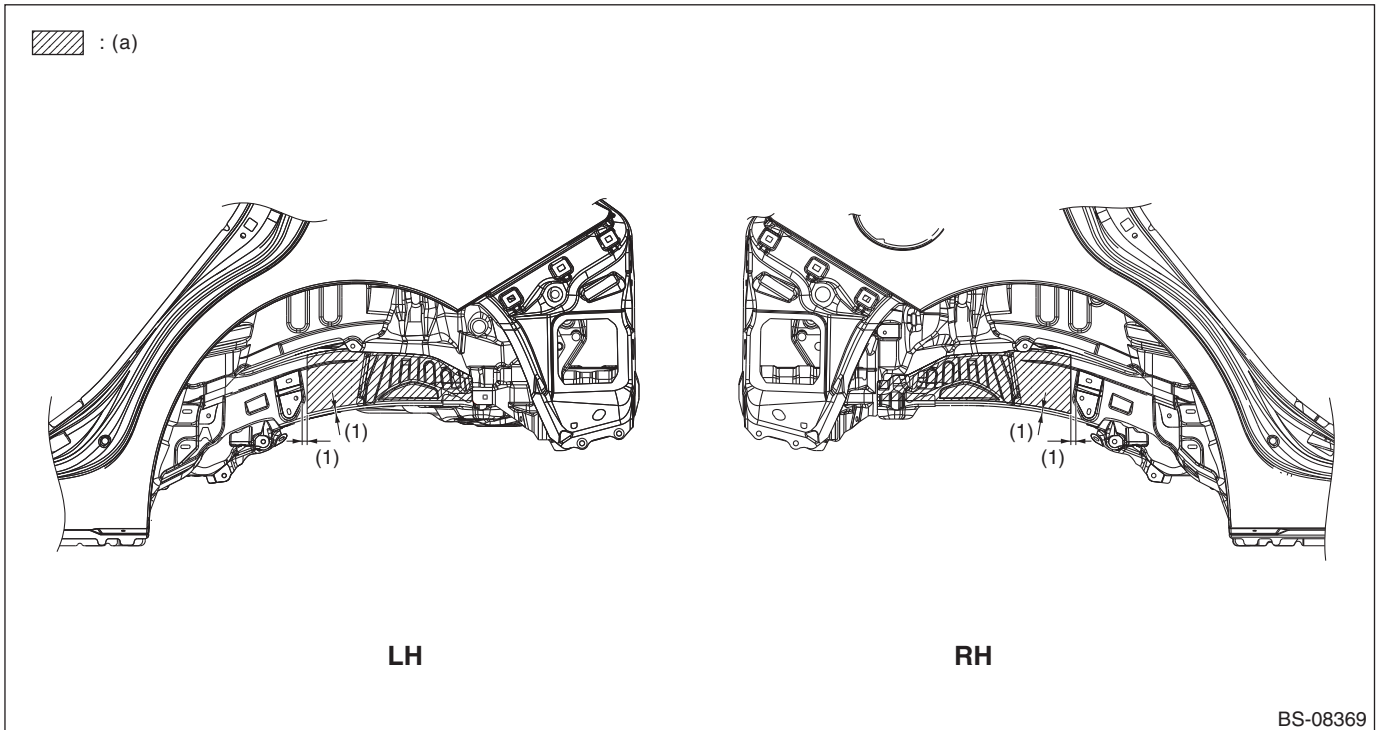
(5) Only for the models without under
cover, and the models with under
cover and without side sill spoiler

(2) Plug must be covered with PVC

(4) 4 Door

Undercoat

- Rear wheel apron side view

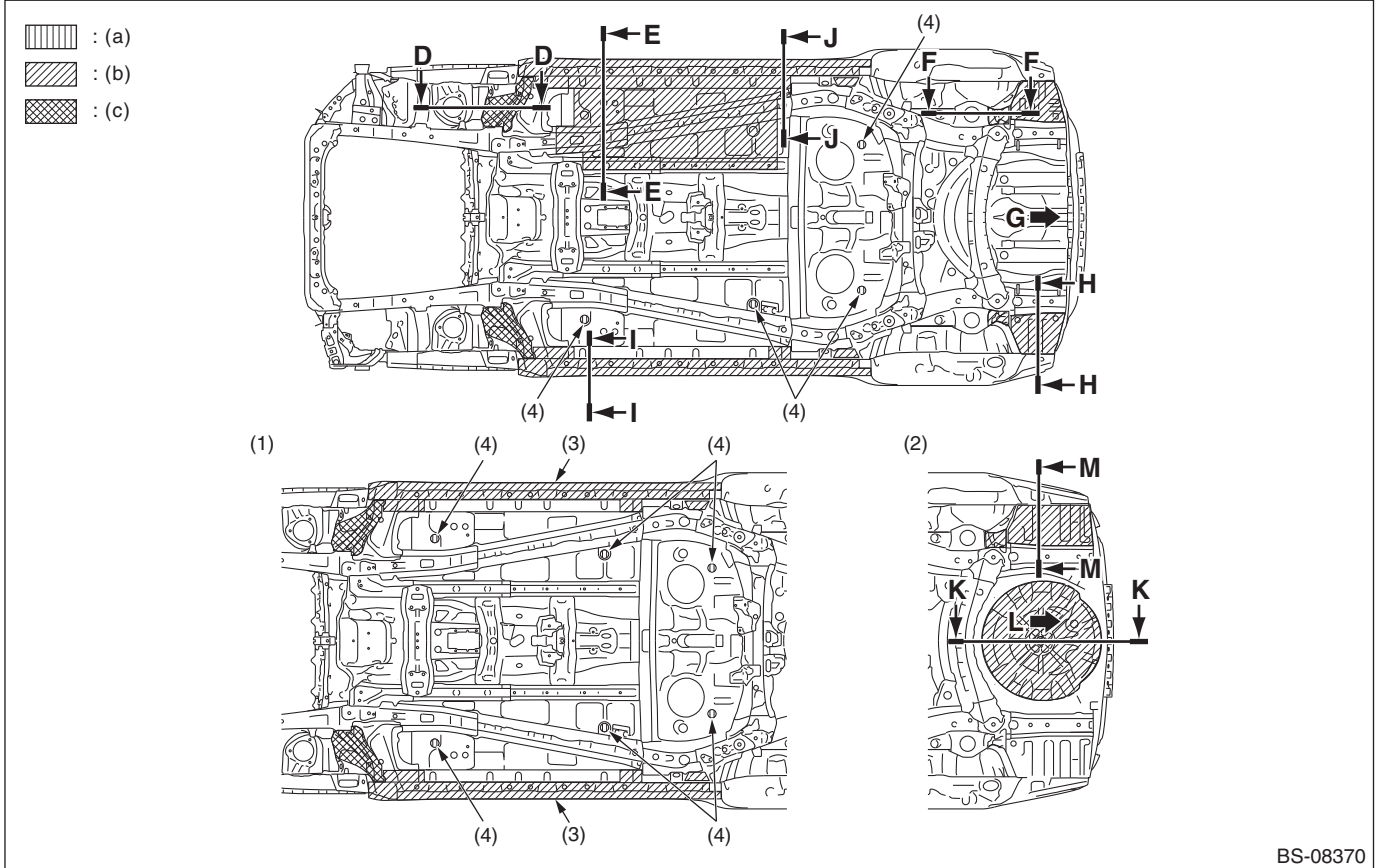


- (a) Dry: 340 μm or more
Wet: 330 μm or more

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

Undercoat

• Bottom view



BS-08370

(a) 200 μm or more

(b) Dry: 340 μm or more
Wet: 330 μm or more

(c) Dry: 780 μm or more
Wet: 630 μm or more

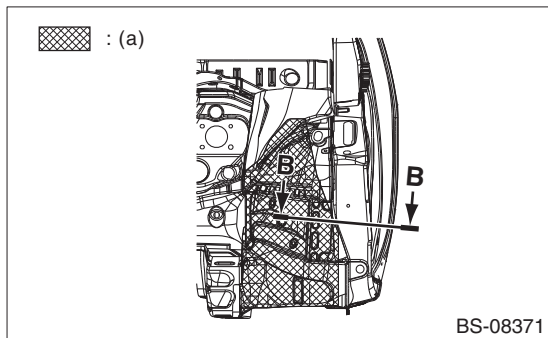
(1) Model with under cover

(3) Model without side sill spoiler

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

(2) 4 Door

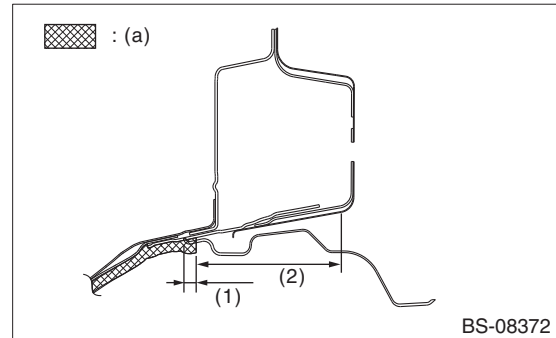
View A



BS-08371

(a) Dry: 780 μm or more, Wet: 630 μm or more

Cross section B — B



BS-08372

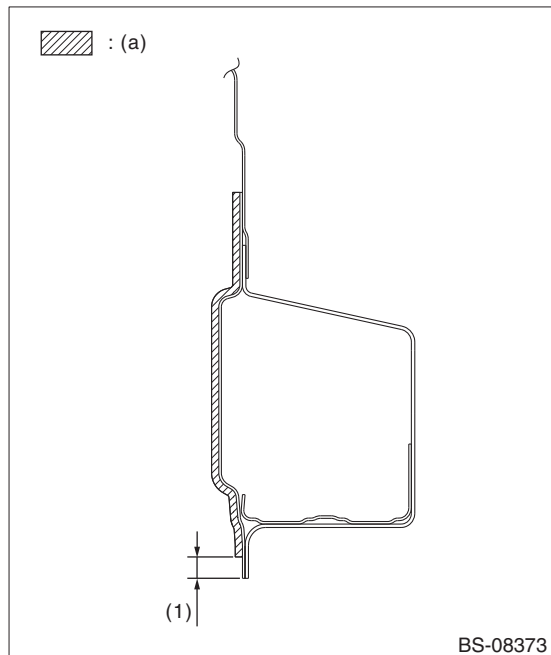
(a) Dry: 780 μm or more, Wet: 630 μm or more

(1) 10 mm (0.39 in)

(2) Adherence of mist is allowable.

Undercoat

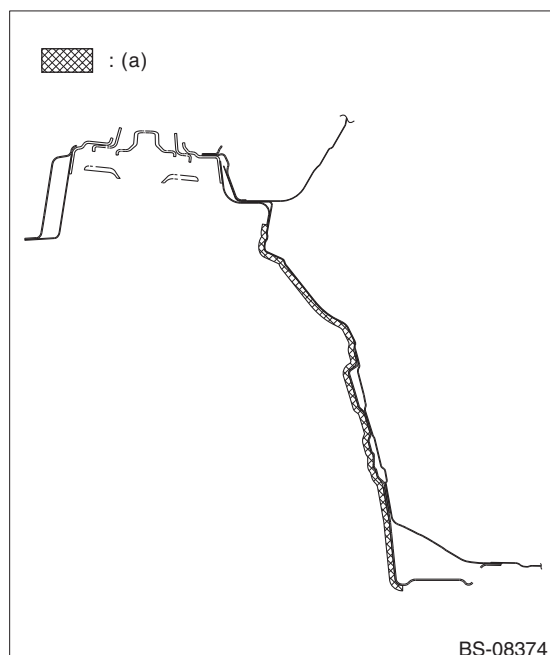
Cross section C — C



(a) Dry: 340 μm or more, Wet: 330 μm or more

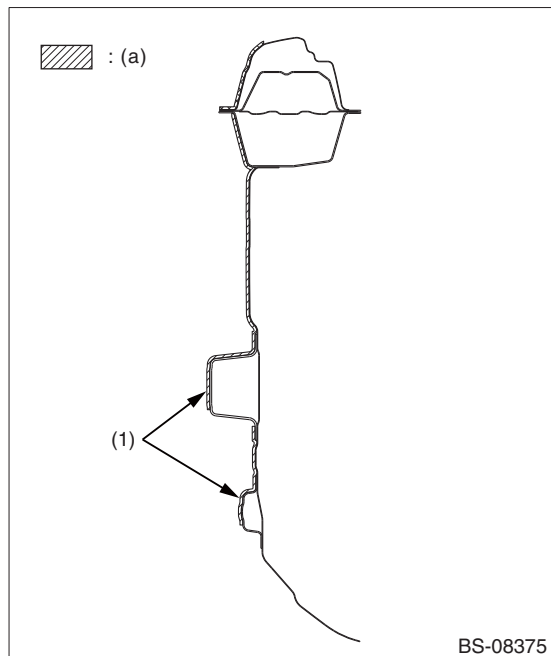
(1) 10 mm (0.39 in) (Adherence of mist is allowable)

Cross section D — D



(a) Dry: 780 μm or more, Wet: 630 μm or more

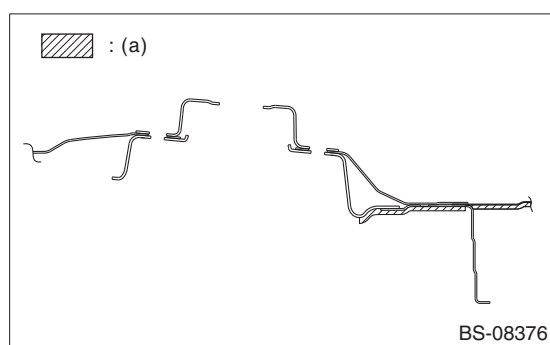
Cross section E — E



(a) Dry: 340 μm or more, Wet: 330 μm or more

(1) Model without under cover : LH only

Cross section F — F

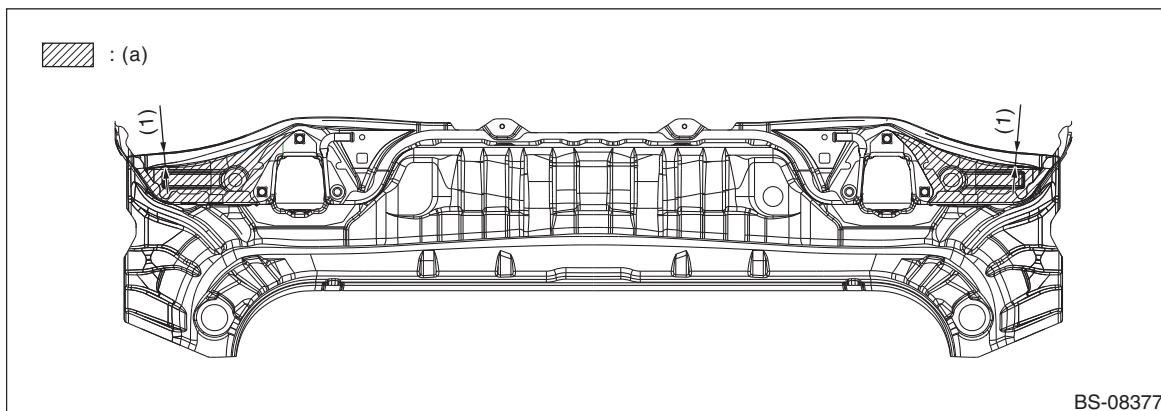


(a) Dry: 340 μm or more, Wet: 330 μm or more

SUBARU.

Undercoat

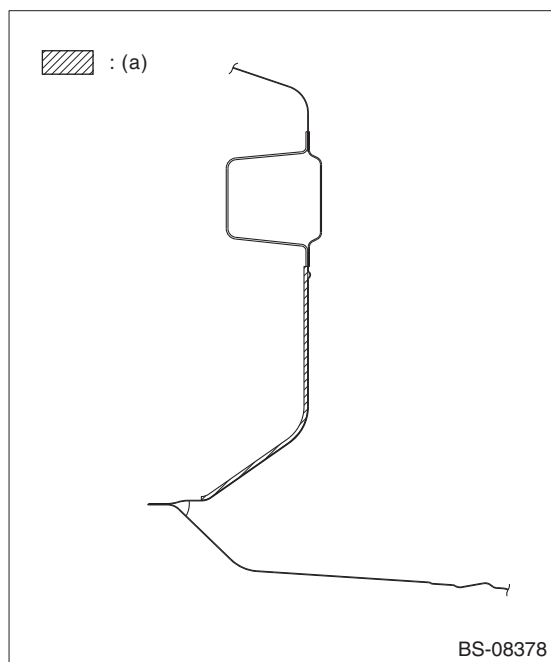
View G



(a) Dry: 340 μm or more, Wet: 330 μm or more

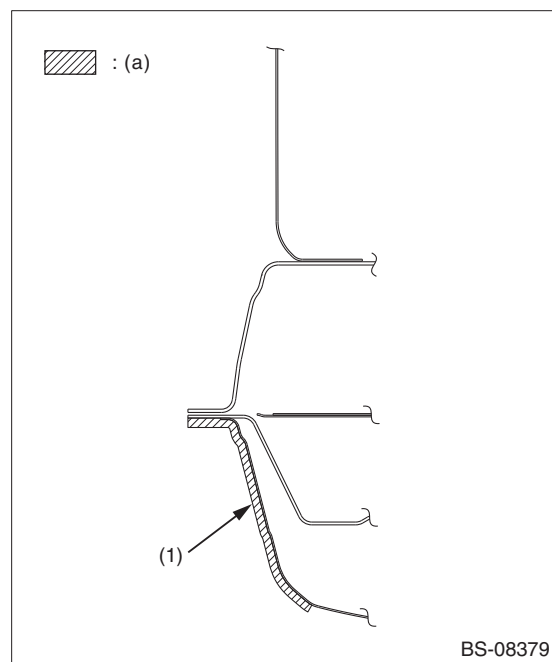
(1) 20 mm (0.79 in)

Cross section H — H



(a) Dry: 340 μm or more, Wet: 330 μm or more

Cross section I — I

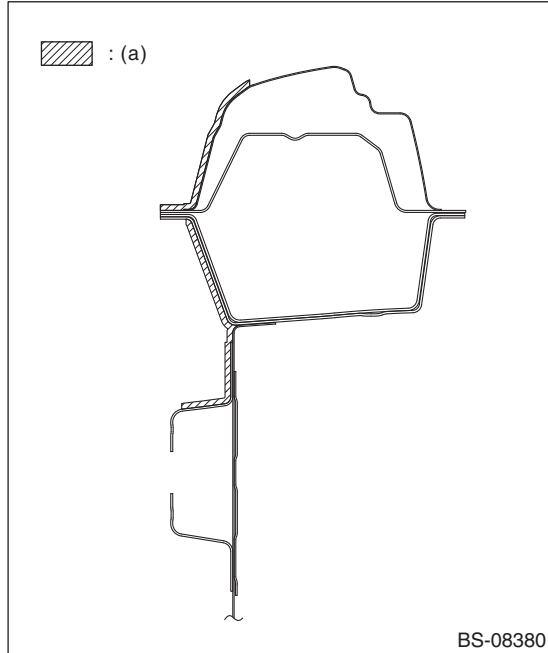


(a) Dry: 340 μm or more, Wet: 330 μm or more

(1) Only for the models without under cover, and the models with under cover and without side sill spoiler

Undercoat

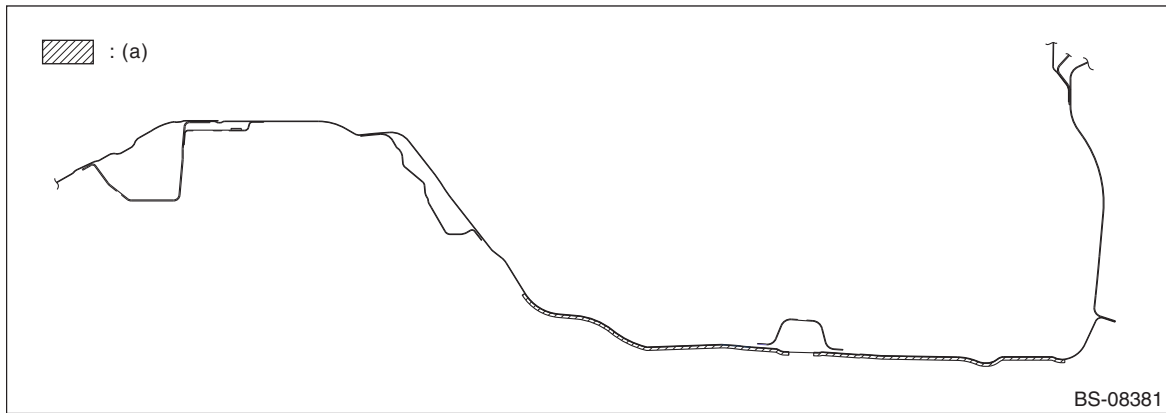
Cross section J — J



(a) Dry: 340 μm or more, Wet: 330 μm or more

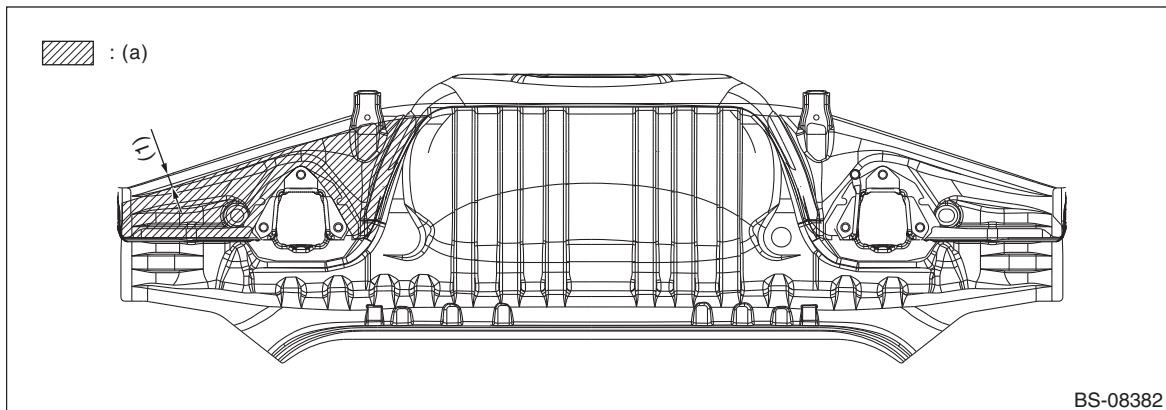
SUBARU.

Cross section K — K



(a) Dry: 340 μm or more, Wet: 330 μm or more

View L

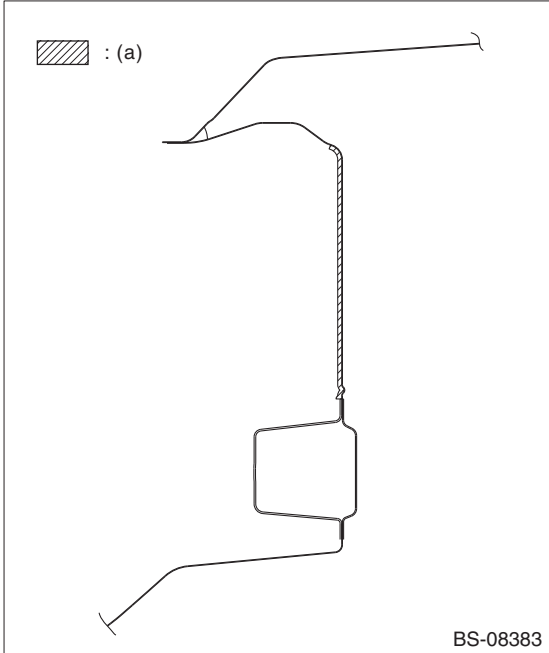


(a) Dry: 340 μm or more, Wet: 330 μm or more

(1) 20 mm (0.79 in)

Undercoat

Cross section M — M



(a) Dry: 340 μm or more, Wet: 330 μm or more

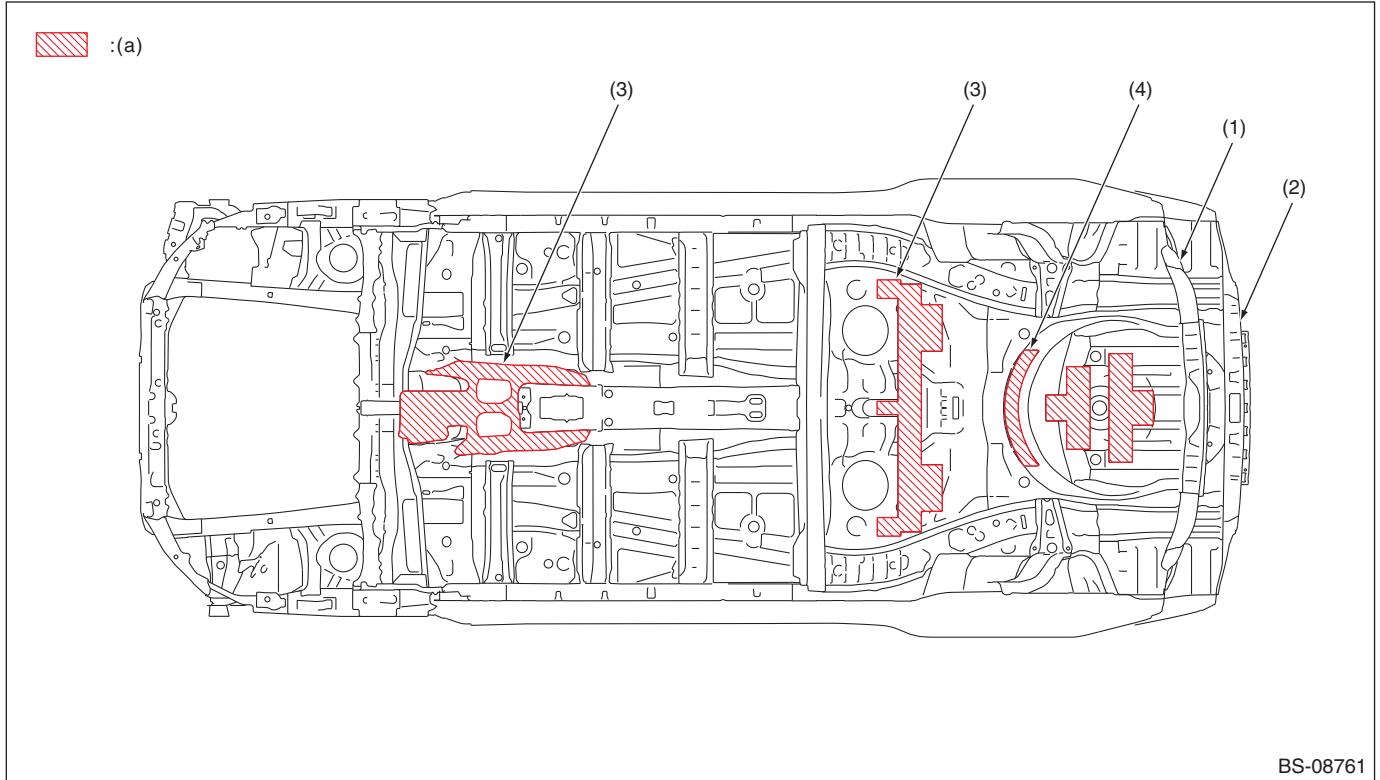
SUBARU.

12.Damping Seat

A: SPECIFICATIONS

1. Common for models with 4 or 5 doors

• Upper view



(a) Silencer

(1) 5 Door

(2) 4 Door

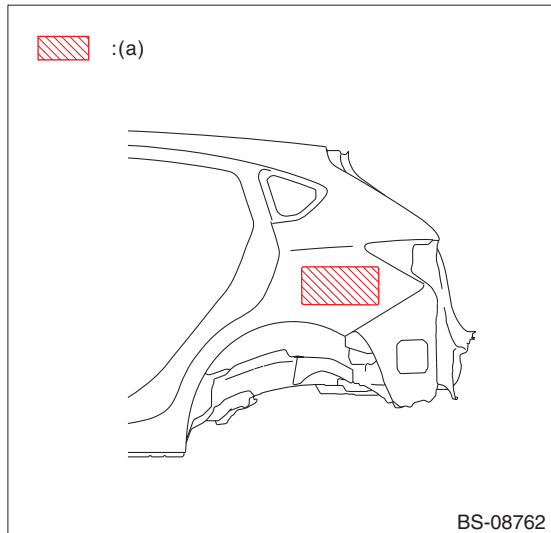
(3) Except for 2.0 L model

(4) 5 Door only except for 2.0 L model

Damping Seat

2. Special Parts for 5 Door

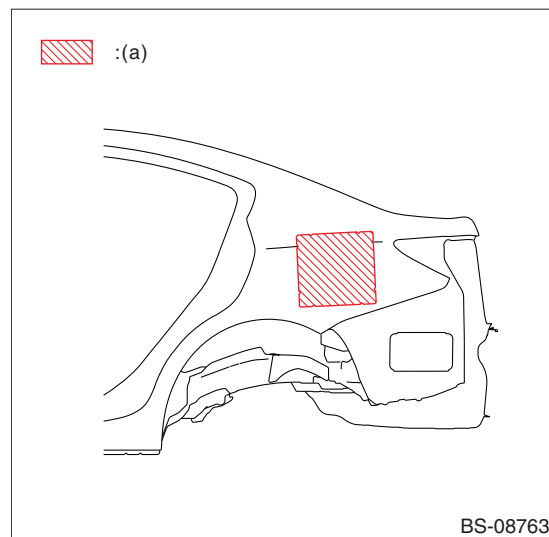
• Side view



(a) Damping seat

3. Special Parts for 4 Door

• Side view

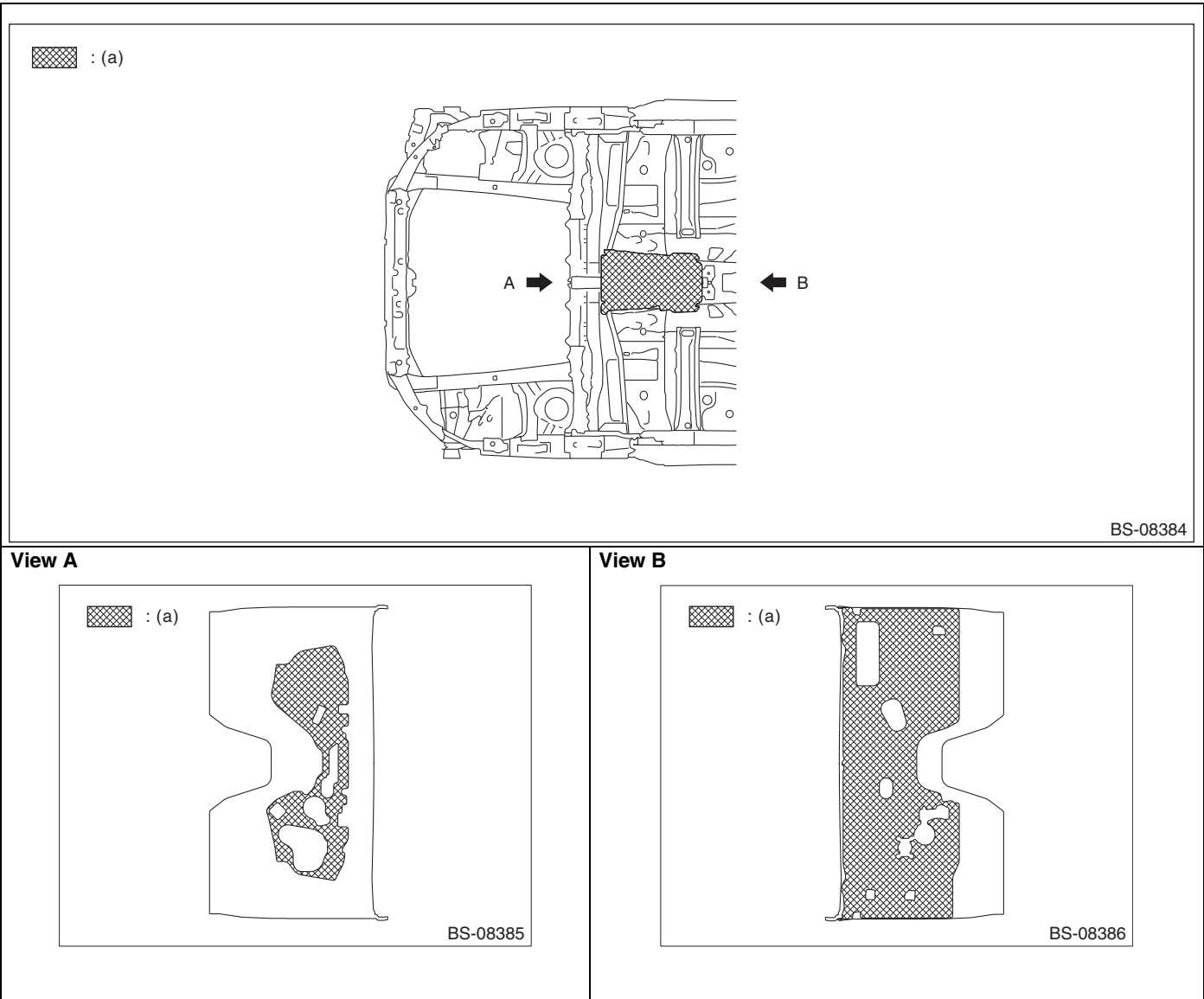


(a) Damping seat

13.Insulator

A: SPECIFICATIONS

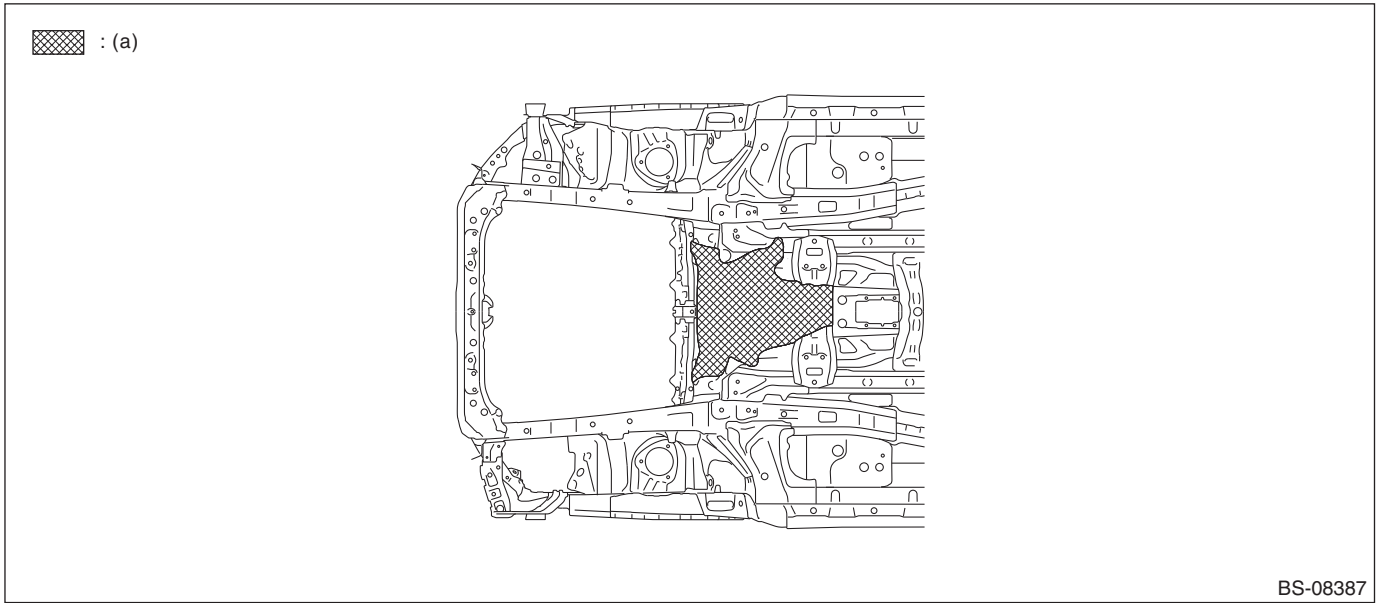
1. Upper view



(a) Insulator

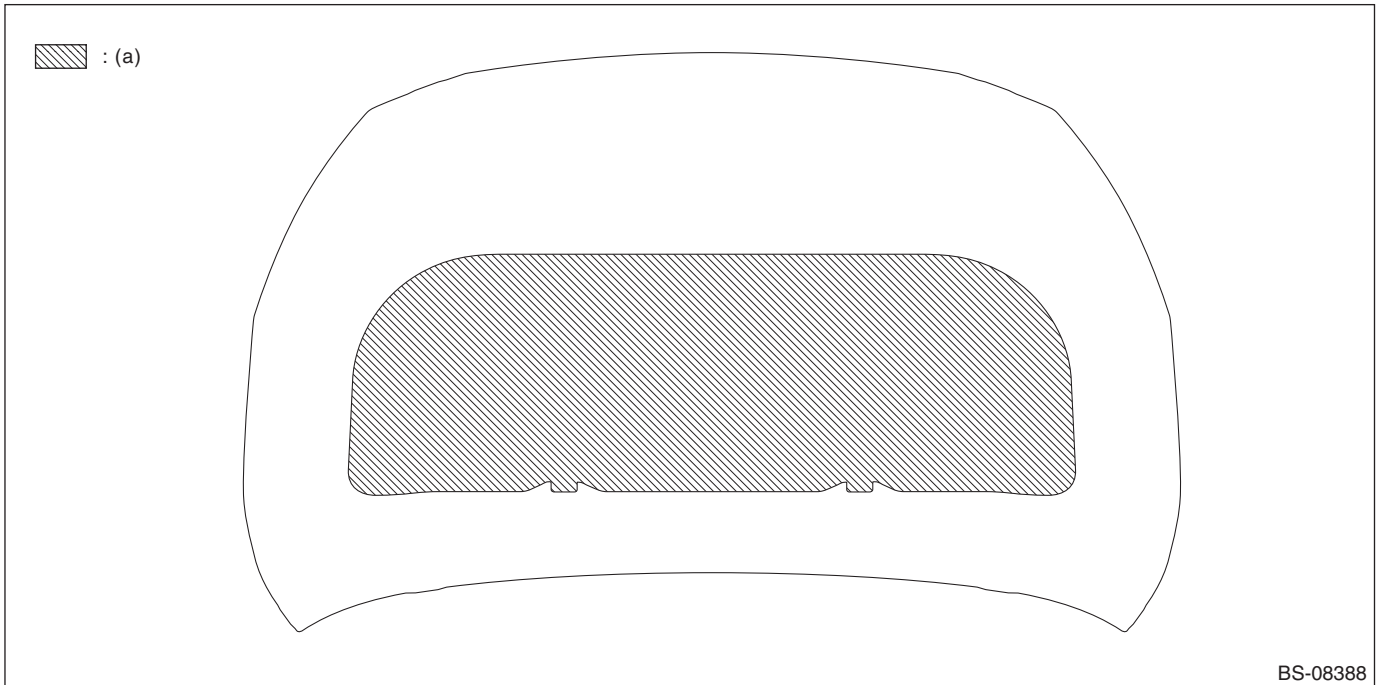
Insulator

2. BOTTOM VIEW (Except for 2.0 L model)



(a) Insulator

3. FRONT HOOD

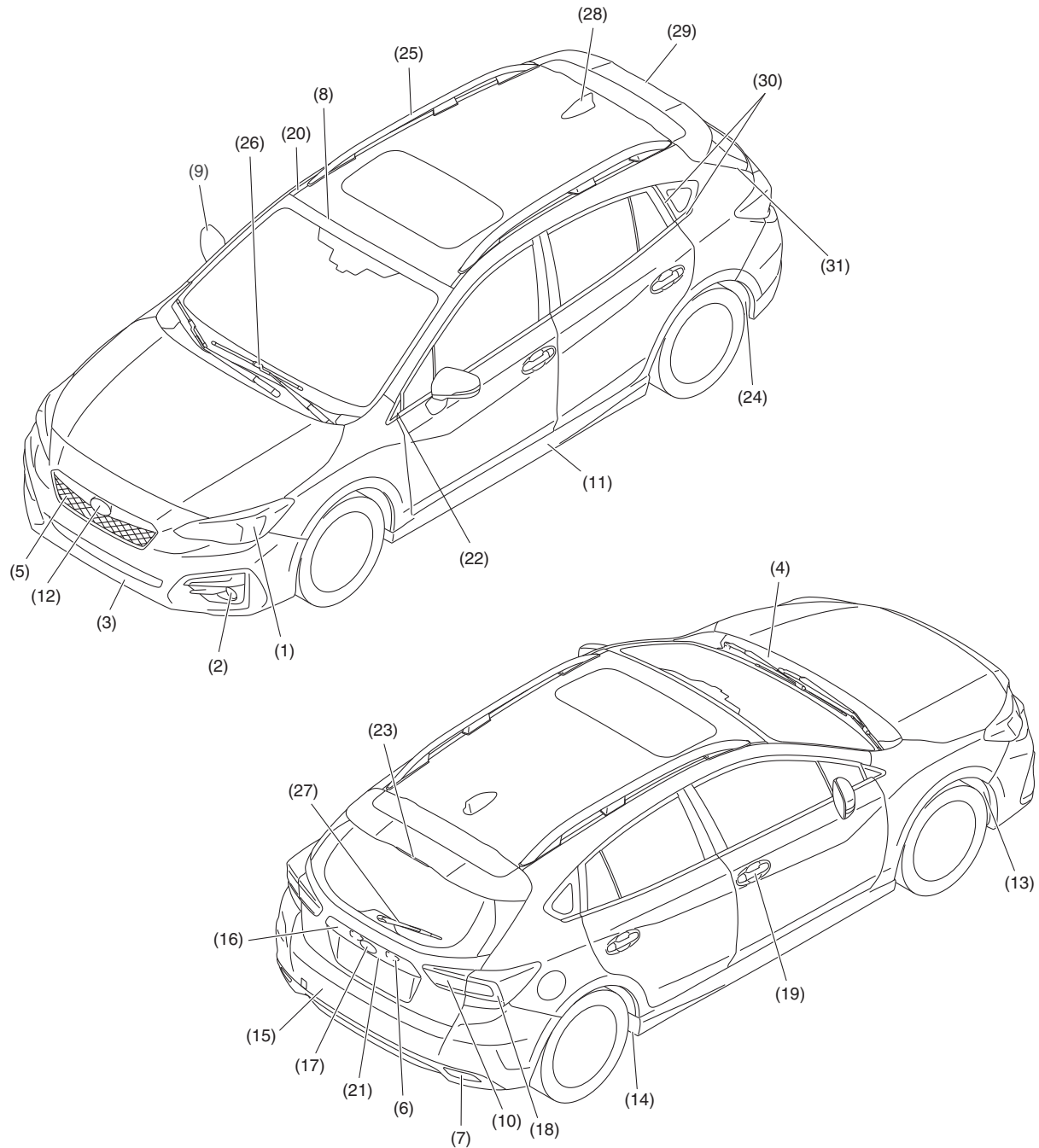


(a) Insulator

14. Plastic Parts and Materials

A: SPECIFICATIONS

1. SPECIAL 5 DOOR PARTS AND COMMON PARTS FOR 5 DOOR & 4 DOOR



BS-09155

Plastic Parts and Materials

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

No.	Part name		Material	
(1)	Headlight (Halogen)	Lens	PC	
		Housing	PP-TD20	
		Inner panel A	PC-HT	
		Inner panel B	PC-HT	
		Reflector A	UP-(MD+GF)80	
		Reflector B	PC-HT	
		Inner lens	PC	
	Headlight (LED)	Lens	PC	
		Housing	PP-TD40	
		Reflector A	PBT	
		Reflector B	PC	
		Bezel	PBT	
		Inner panel A	PBT	
		Inner panel B	PC	
		Inner lens A, B	PC	
		Bracket A, B, D	PA6-GF35	
	Bracket C	PC		
(2)	Front fog light	Lens	PC	
		Reflector	PC	
		Bracket (Housing)	PP-TD30	
	Front fog light (SRF)	Bracket (Housing)	PP-GF40	
(3)	Front bumper	Face		PP
		Fog light cover	Standard	PP
			High grade	Base: PP Mole: ABS
		DRL cover		Base: PP Mole: ABS
		Hook cover		PP
		Center lower bracket		PP
		Side bracket		POM
		Corner bracket		PP-GF30
		Upper cover		PP
		Sealing bumper		EPDM
		EA form		PP+PS
		EA lower		PP
		Intake cover		PP
(4)	Cowl panel		PP-TD10	

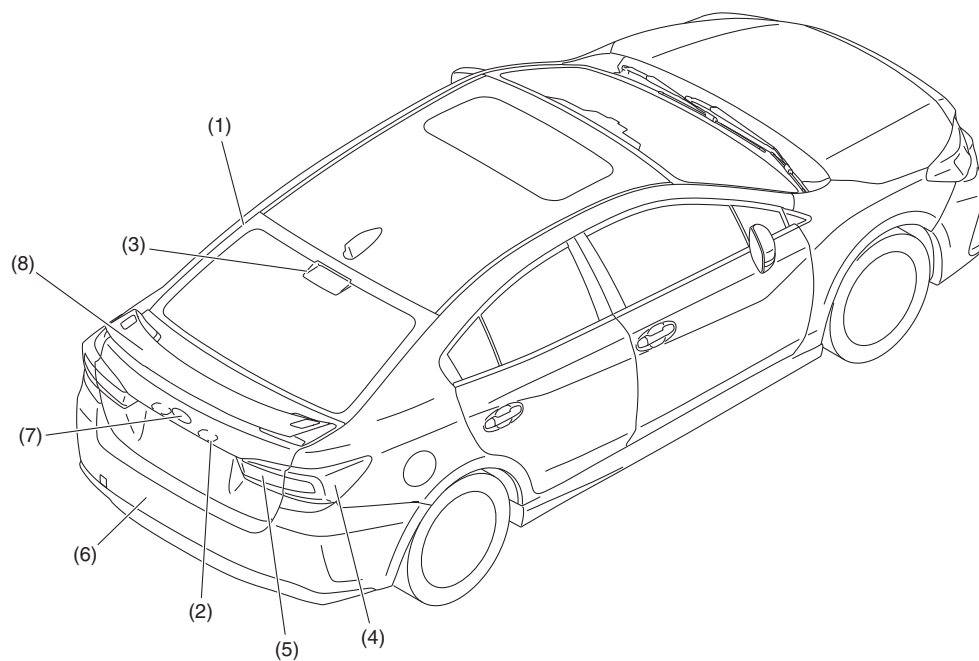
Plastic Parts and Materials

No.	Part name			Material
(5)	Front grill	Grille part		ASA
		Moulding	Ring	ABS
			Wing	ABS
(6)	License light	Lens		PC
		Housing		PC
(7)	Rear reflex reflector	Lens		PMMA
		Housing		PC
(8)	Front window moulding			PVC
(9)	Door mirror	Body		ASA
		Cover body		ASA
		Cover front		ABS
		Cover stay A		ASA
		Cover stay B		ASA
		Side turn light	Housing	ABS
			Lens	PMMA
			Inner lens	PMMA
Packing stay		TPO		
(10)	Rear finisher light	Outer lens		PMMA
		Housing		ASA
(11)	Side spoiler			PP
(12)	Ornament front			ABS+PMMA
(13)	Front mudguard	Body		PE
		Air flap		PE
		Insulator		POM
(14)	Air flap Rear			PP+EPDM
(15)	Rear bumper	Face		PP
		Hook cover		PP
		Side bracket		POM
		Corner bracket		PP-GF30
		Bracket lower rear (5 Door only)		PP-GF30
		Cover side lower		PP
(16)	Rear gate garnish			ABS
(17)	Ornament rear			ABS+PMMA
(18)	Rear combination light	Outer lens		PMMA
		Inner lens	Stop light	PMMA
			Side reflex reflector	PMMA
			Tail light	PC
		Extension		PC
		Housing		ASA
(19)	Door handle	Handle	Paint	PC+PBT
			Paint (Model with smart entry)	PC+PBT-MD10
			Plating	PC+PBT-MD10
		Handle cover	Paint	PC+PBT
			Paint (Model with smart entry)	PC+PBT-MD10
			Plating	PC+ABS
(20)	Roof moulding	Body		PVC
		End cap		POM
		Carrier cover		AES
(21)	Rear gate opener switch	Operation part		TPE
		Resin part		PP-F35

Plastic Parts and Materials

No.	Part name			Material
(22)	A pillar cover	Body		AES
		Protector		TPO
(23)	High mount stop light	Lens		PMMA
		Housing		ABS
(24)	Rear mudguard	Body		PET+PP
		Protector		PP
(25)	Roof rail	Leg	Front & Center & Rear	PA66-GF50
		Leg cover	Front & Center & Rear	ASA
		Protector	Front & Center & Rear	TPO
(26)	Front wiper	Blade		PBT
				PBT-GF45
				PP+ELASTOMER
(27)	Rear wiper	Blade		PBT-GF30
		Arm		PET-GF45
		Arm cover		PBT
(28)	Antenna	Shark fin type		PC+ASA
		Fixed pole type	Cover	ASA
			Rod	ELASTOMER
(29)	Roof spoiler			ASA
(30)	Rear quarter mall	Front		PVC
		Lower		PVC
(31)	Roof spoiler side	No painting		ABS
		With paint		ASA+ABS
	Undercover			PP
	Splash board			TPO

2. SPECIAL 4 DOOR PARTS



BS-09162

- | | | |
|--|----------------------------|-------------------|
| (1) Rear window moulding | (4) Rear combination light | (7) Ornament rear |
| (2) License light | (5) Rear finisher light | (8) Spoiler rear |
| (3) High mount stop light
(Indoor type) | (6) Rear bumper | |

Plastic Parts and Materials

No.	Part name			Material
(1)	Rear window moulding			PVC
(2)	License light	Lens		PC
		Housing		PC
(3)	High mount stop light (Indoor type)	Lens		PC
		Housing		PP+TPO
		Cover		PP
(4)	Rear combination light	Outer lens		PMMA
		Inner lens	Stop light	PMMA
			Side reflex reflector	PMMA
			Rear reflex reflector	PMMA
			Tail light	PC
		Extension		PC
		Housing		ASA
(5)	Rear finisher light	Outer lens		PMMA
		Housing		ASA
(6)	Rear bumper	Face		PP
		Hook cover		PP
		Side bracket		POM
		Corner bracket		PP-GF30
		Corner side lower		PP
(7)	Ornament rear			ABS+PMMA
(8)	Spoiler rear	Body		ABS
		Mounting section		PC+PET

List of Plastic Material Notations

15.List of Plastic Material Notations

A: SPECIFICATIONS

Notation symbol	Material name	Notation symbol	Material name
ABS	ABS resin (acrylonitrile/butadiene/styrene resin)	PET-TD25	Polyethylene terephthalate (25 % talc content)
AES	Acrylonitrile/ethylene/styrene	PMMA	Polymethyl methacrylate
ASA	Acrylonitrile/strene/acrylate	POM	Polyacetal
ELAS-TOMER	Elastomer	PP	Polypropylene
EPDM	Ethylene/propylene/dien rubber	PP-F35	Polypropylene (35 % Inorganic filler)
PC-HT	Heat resisting Polycarbonate	PP-GF30	Polypropylene (30 % glass fiber content)
PA6-GF35	Polyamide (nylon) (35 % glass fiber content)	PP-GF40	Polypropylene (40 % glass fiber content)
PA66-GF50	Polyamide (nylon) (50 % glass fiber content)	PP-TD10	Polypropylene (10 % talc content)
PBT	Polybutylene terephthalate	PP-TD20	Polypropylene (20 % talc content)
PBT-GF30	Polybutylene terephthalate (30 % glass fiber content)	PP-TD30	Polypropylene (30 % talc content)
PBT-GF45	Polybutylene terephthalate (45 % glass fiber content)	PP-TD40	Polypropylene (40 % talc content)
PBT+MD10	Polybutylene terephthalate (10 % mineral poder)	PS	PolyStyrene
PC	Polycarbonate	PVC	Polyvinyl chloride
PE	Polyethylene	TPE	Thermoplastic elastomer
PEI	Polyetherimide	TPO	Thermo polyolefin
PET	Polyethylene terephthalate	UP-(MD+GF)80	Unsaturated polyester (Mineral powder + glass fiber) 80 %
PET-GF45	Polyethylene terephthalate (45 % glass fiber content)		