

BODY REPAIR MANUAL

BS

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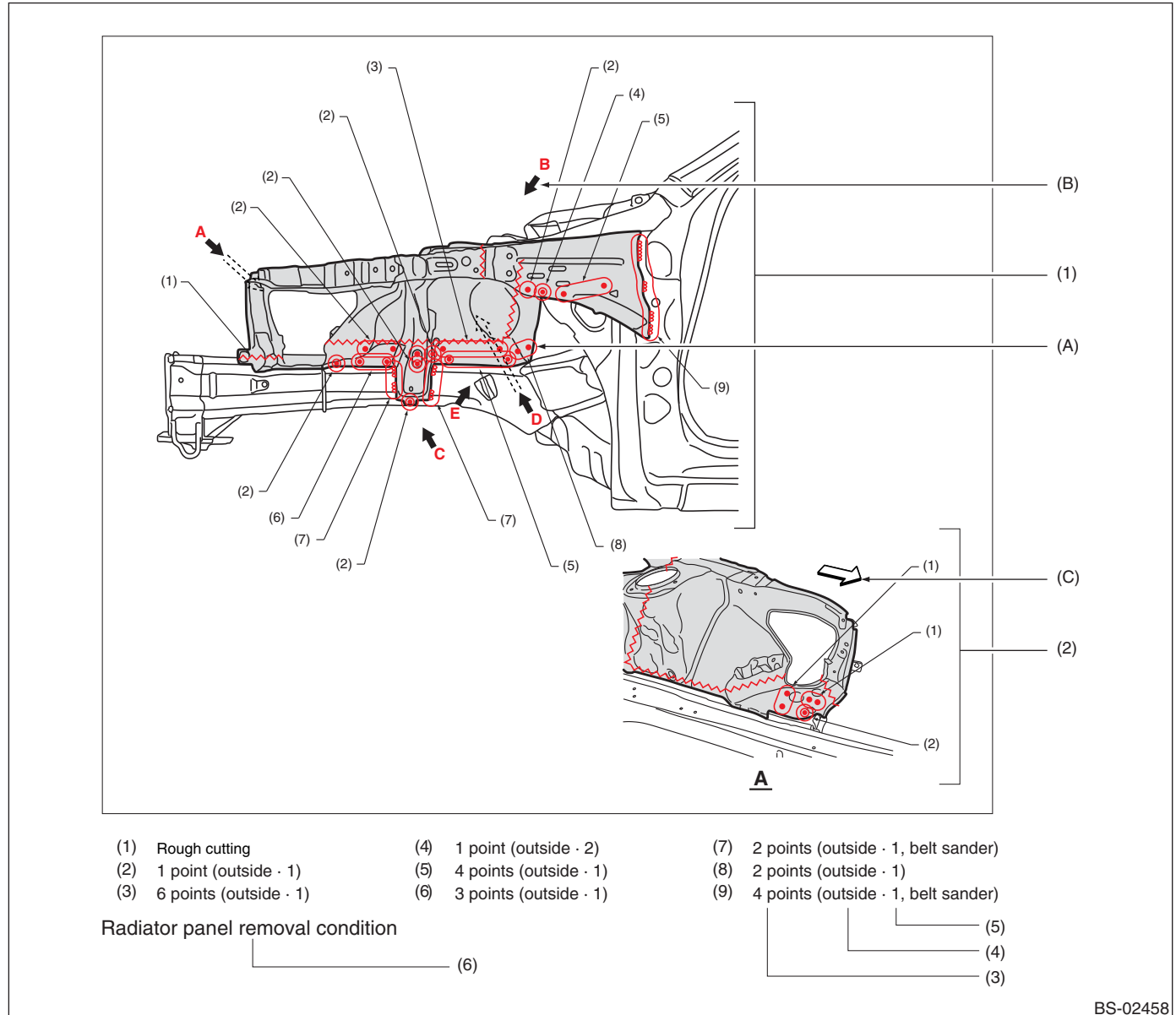
1. Foreword

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

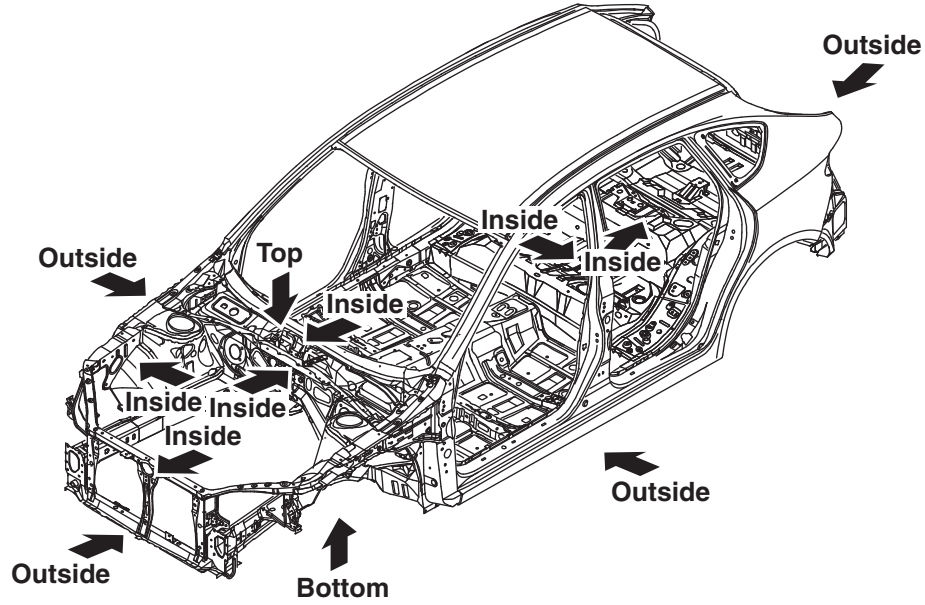
- Symbols and number of points indicate the welding method and the number of welding points. Text in brackets indicates the direction for removal of welded parts, and numbers indicate the number of plates to be drilled in panels of welded parts to be removed.
- An enclosure by a broken line indicates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

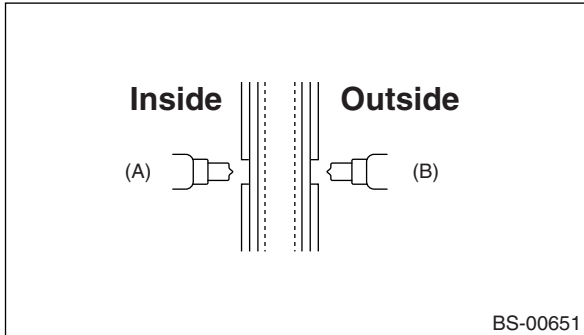


BS-02459

3. NUMBER OF PANELS TO BE DRILLED

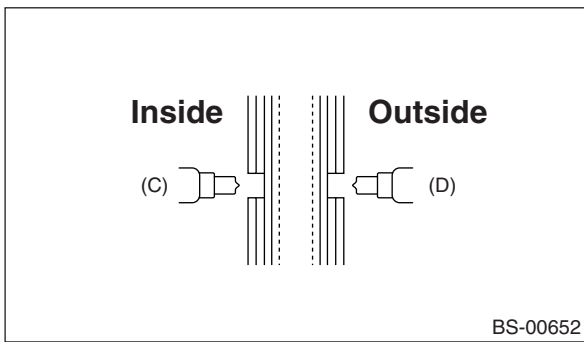
Depending on the number of panels, drilling is done through one panel or two panels, and this number is listed together with the removal direction.

(1) Drilling through one plate



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

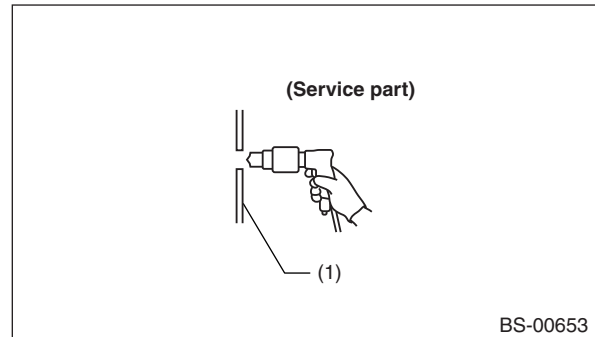
(2) Drilling through two plates



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

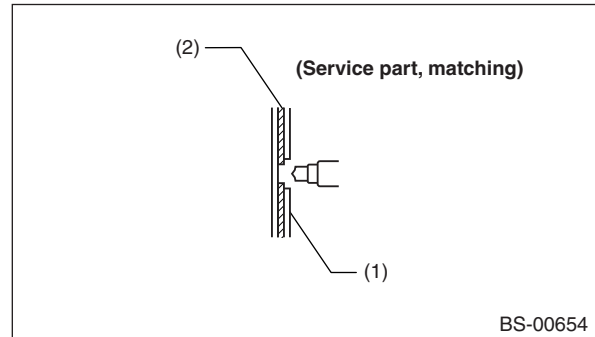
4. HOLE DRILLING FOR PLUG WELDING

(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

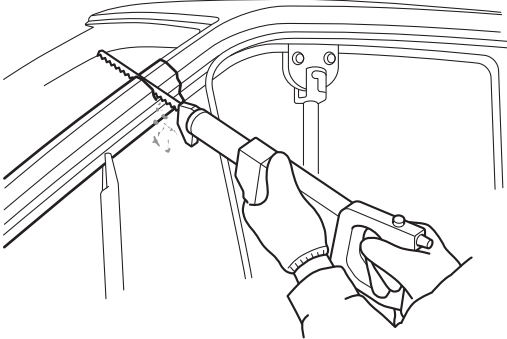


- (1) Vehicle side
- (2) Service part

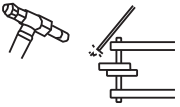
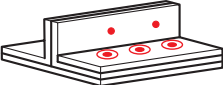
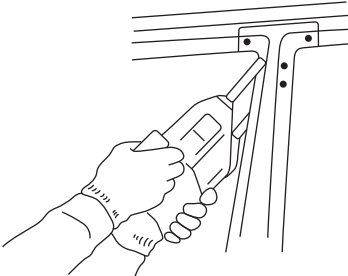
Foreword

5. MEANING OF SYMBOLS

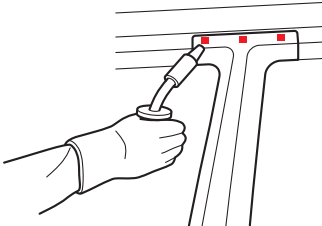
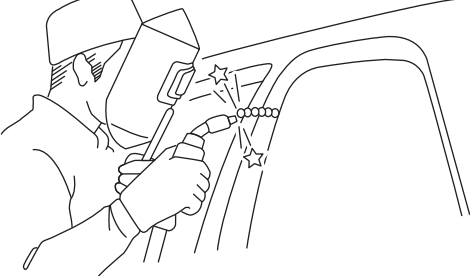
• Cutting

	
BS-00352	BS-00267

• Spot welding

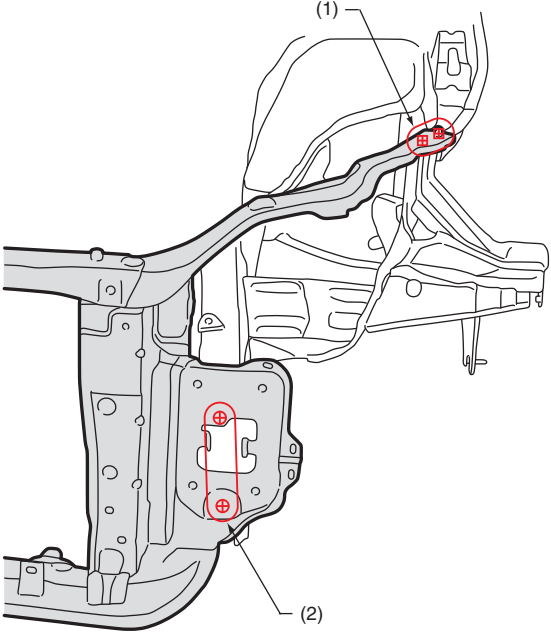
Two overlapping parts	 BS-00655	 BS-00656	 BS-00657	 BS-00658
Three or more overlapping parts	 BS-00659	 BS-00660		

• 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	

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., C-20VR made by Cyuotokenzai).

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] — [e])
- When conditions can't be met, it is recommended to use the plug welding method [f] or [g] as described below.

Spot welding	[a]	Compression	4.0 kN	Total number of 2 overlapping sheets
		Current	8.0 kA	
		Welding time	15 cyc	
	[b]	Compression	4.0 kN	
		Current	6.5 kA	
		Welding time	15 cyc	
	[c]	Compression	3.5 kN	Total number of 3 overlapping sheets
		Current	7.5 kA	
		Welding time	25 cyc	
	[d]	Compression	4.4 kN	
		Current	8.0 kA	
		Welding time	25 cyc	
	[e]	Compression	4.4 kN	
		Current	8.0 kA	
		Welding time	20 cyc	
Plug welding	[f]	Plug diameter	8.5 mm (0.31 in) or more	Total number of 2 or 3 overlapping sheets
		Wire	YGW12	
		Gas	CO2	
	[g]	Plug diameter	8.5 mm (0.31 in) or more	
		Wire	YGW16	
		Gas	Gas mixture (argon: 80%, CO2: 20%)	

CAUTION:

- For new spot welding, avoid previously welded locations.
- After spot welding, inspect the welding locations, and if the weld appears to be insufficient, perform plug welding.
- Shape correction by heating and splice welding shall not be performed for components using 980 MPa class 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)	φ5.0 mm (0.20 in) or more
1.0 — 1.6 mm (0.04 — 0.06 in)	φ6.5 mm (0.26 in) or more
1.7 — 2.3 mm (0.07 — 0.09 in)	φ8.0 mm (0.31 in) or more
2.4 mm (0.09 in) or more	φ10.0 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

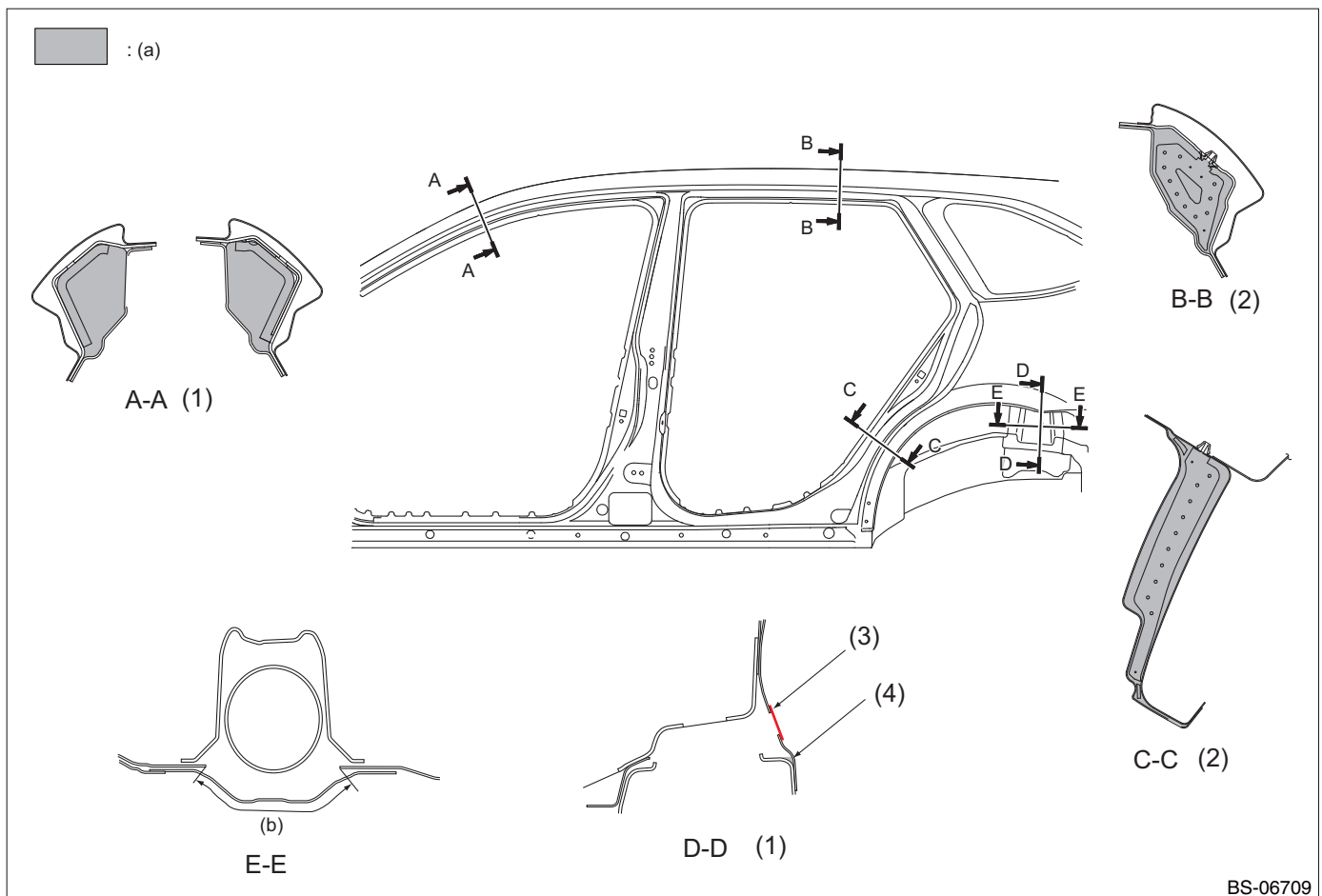
For a clip type plate, reuse the plate and inject cold-setting foam.

For a clipless type, inject cold-setting foam as is.

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

• Foam injection locations

OUTBACK



(a) Urethane foam injection locations (b) Application area of forming agent

(1) Clipless type

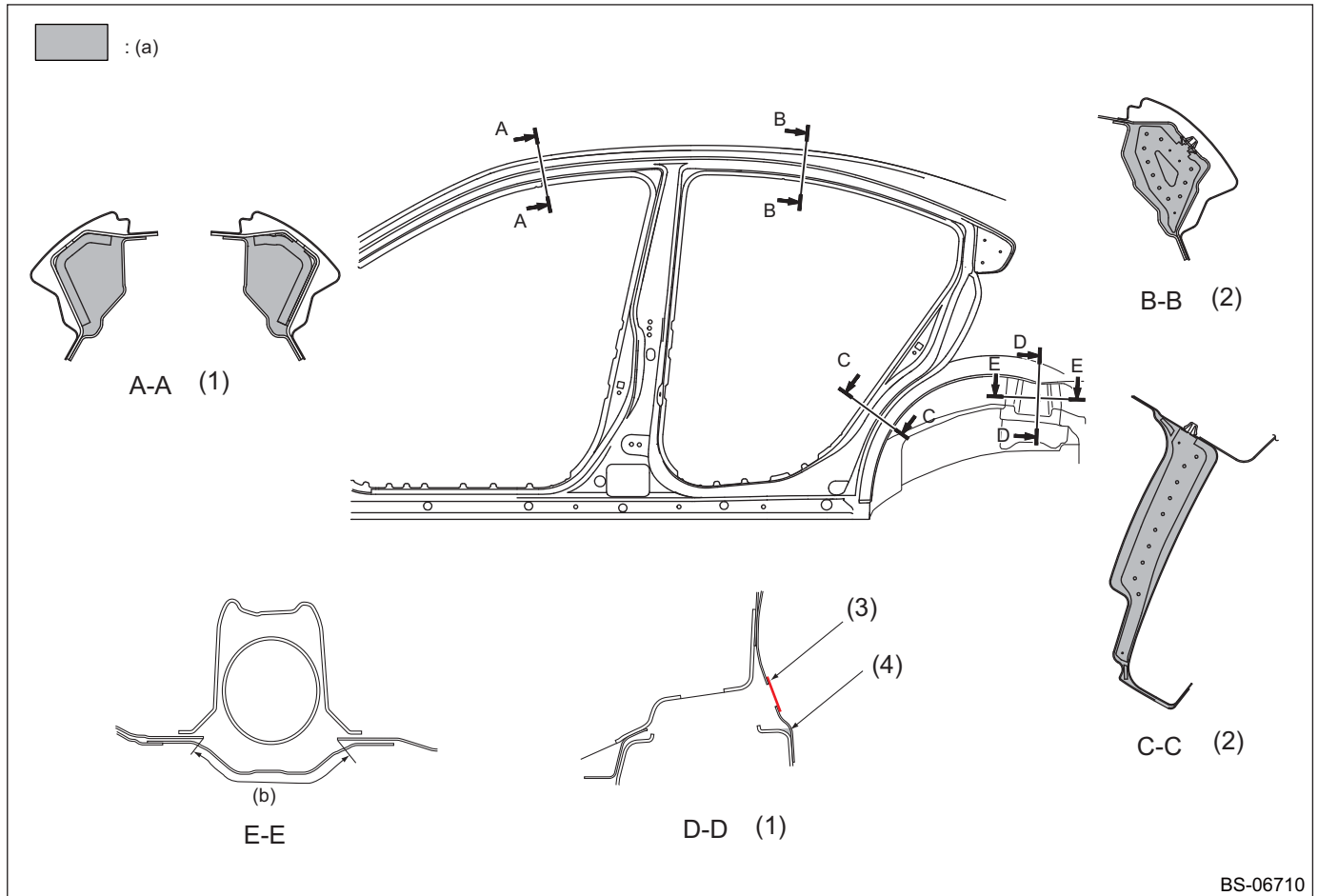
(3) After applying the foaming agent, cover this hole with a grommet sheet.

(4) Apply foaming agent in area (b) of figure E - E.

(2) Clip type

Foreword

SEDAN



(a) Urethane foam injection locations

(b) Application area of forming agent

(1) Clipless type

(3) After applying the foaming agent, cover this hole with a grommet sheet.

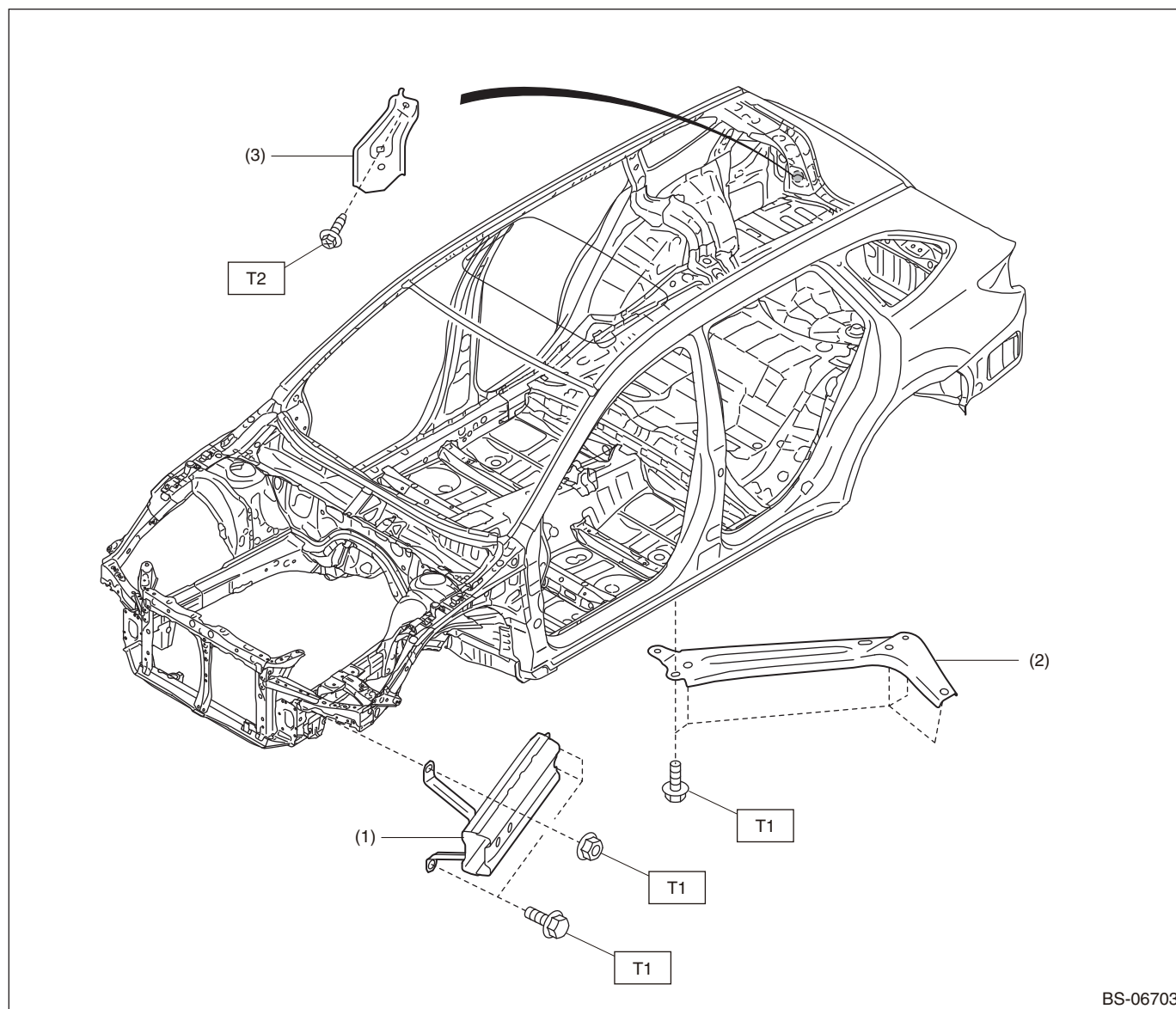
(4) Apply foaming agent in area (b) of figure E - E.

(2) Clip type

2. Structure of Installed Exterior Parts

A: BODY REINFORCING PARTS

• — '17 MY



BS-06703

(1) GUSSET CP FT SD

(3) BRACKET LJGG HK D CP
(OUTBACK)

(2) STAY R FRAME CP

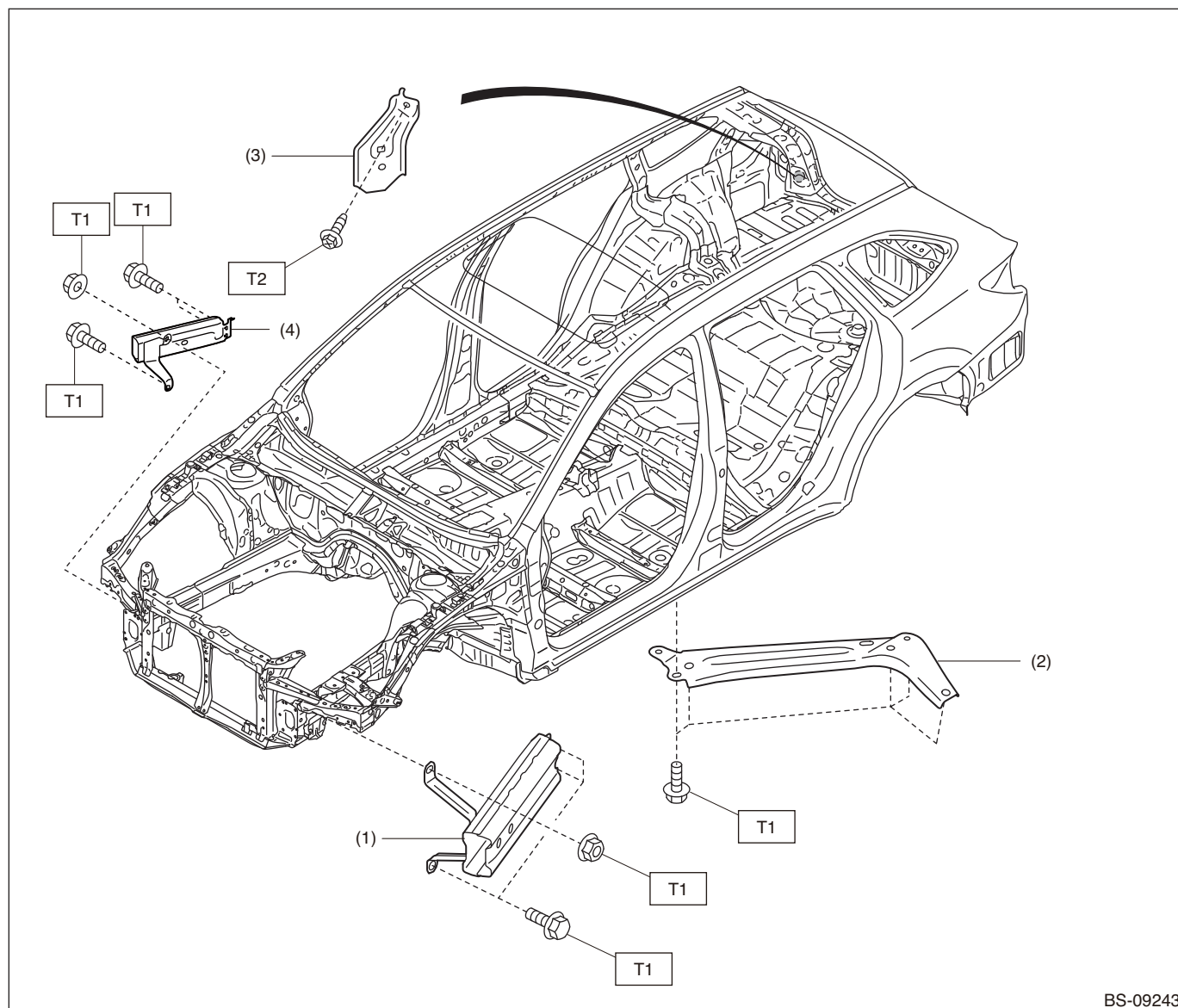
Tightening torque: N·m (kgf-m, ft-lb)

T1: 37 (3.77, 27.3)

T2: 7.5 (0.76, 5.5)

Structure of Installed Exterior Parts

• '18 MY —



BS-09243

(1) GUSSET CP FT SD LH

(3) BRACKET LJGG HK D CP
(OUTBACK)

(2) STAY R FRAME CP

(4) GUSSET CP FT SD RH

Tightening torque: N·m (kgf-m, ft-lb)

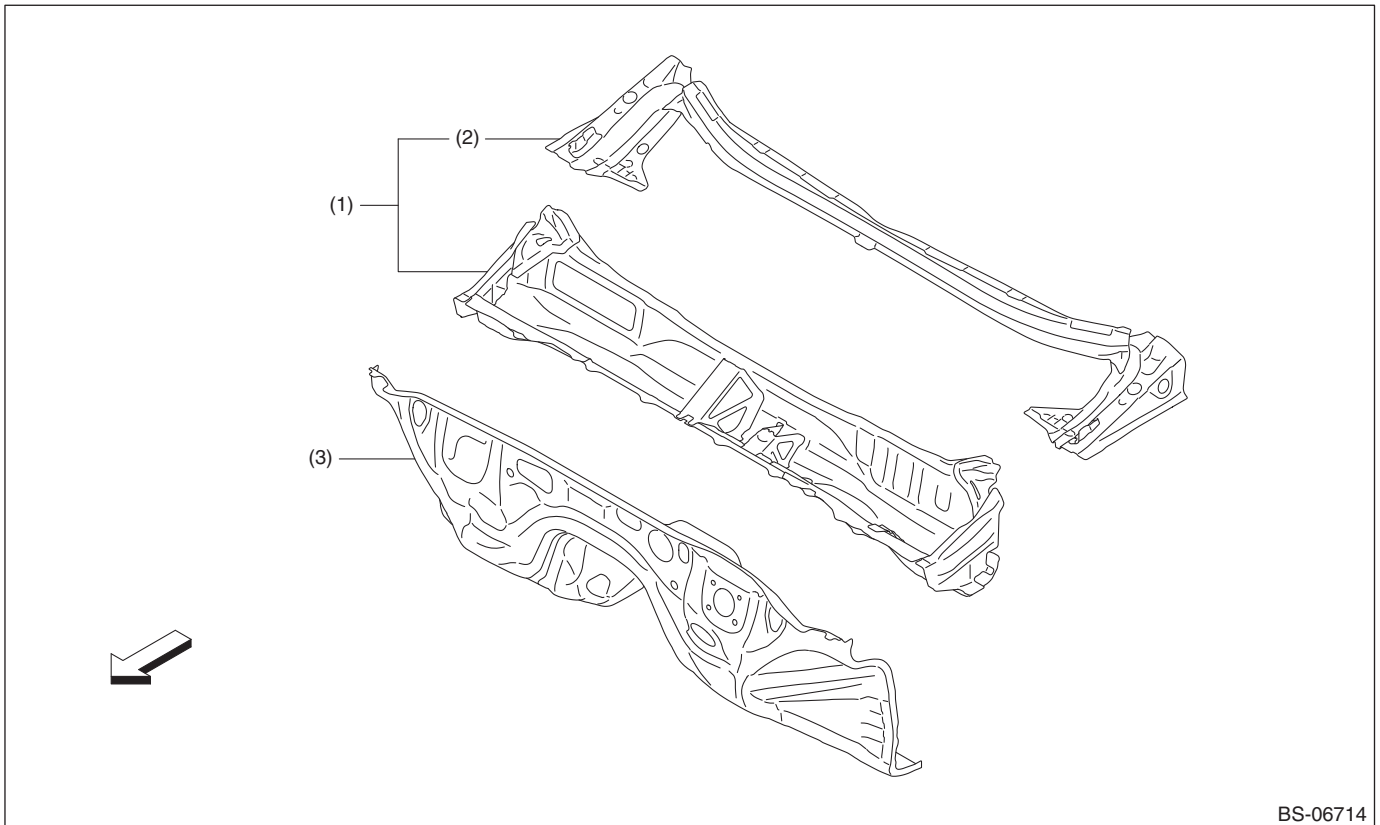
T1: 37 (3.77, 27.3)

T2: 7.5 (0.76, 5.5)

3. Panel Components

A: COMPONENTS

1. TOE BOARD & FRONT PANEL



BS-06714

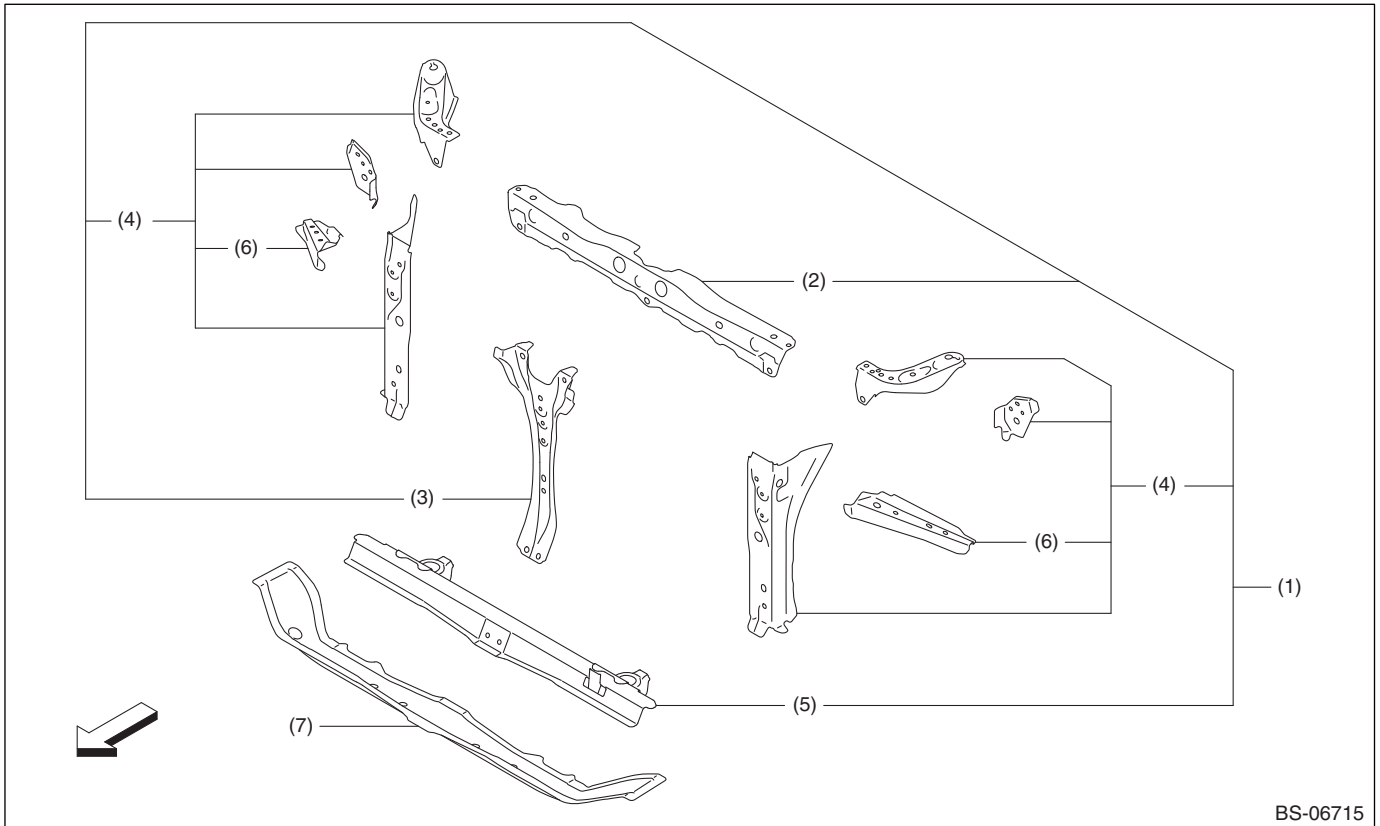
(1) Front panel & Duct

(2) Front panel side reinforcement

(3) Toe board

Panel Components

2. RADIATOR PANEL

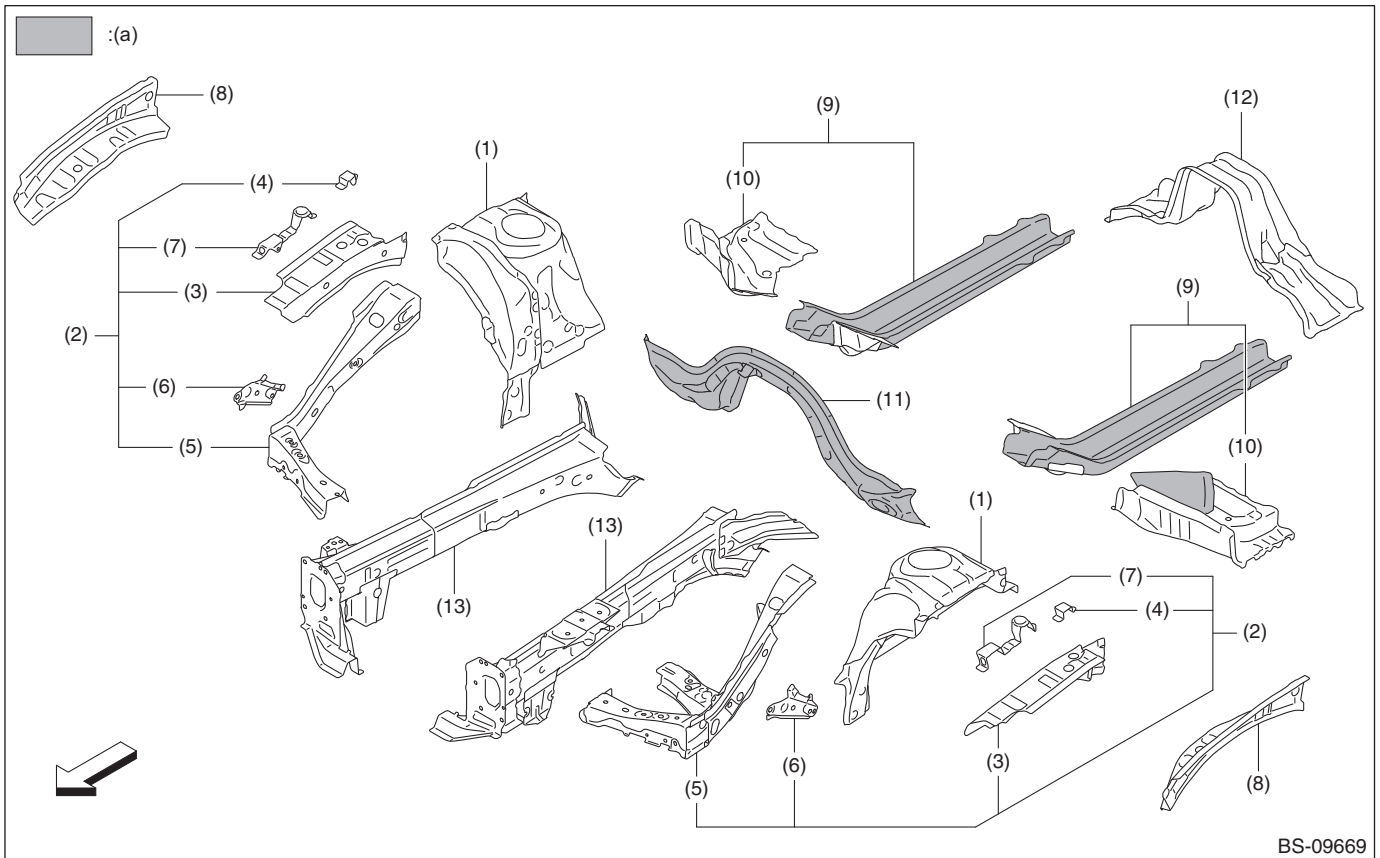


BS-06715

- | | | |
|--------------------------|-------------------------------|--------------------------------|
| (1) Radiator panel | (4) Radiator panel side | (7) Frame radiator lower lower |
| (2) Frame radiator upper | (5) Frame radiator lower A | |
| (3) Stay hood lock | (6) Frame radiator panel side | |

Panel Components

3. FRONT WHEEL APRON

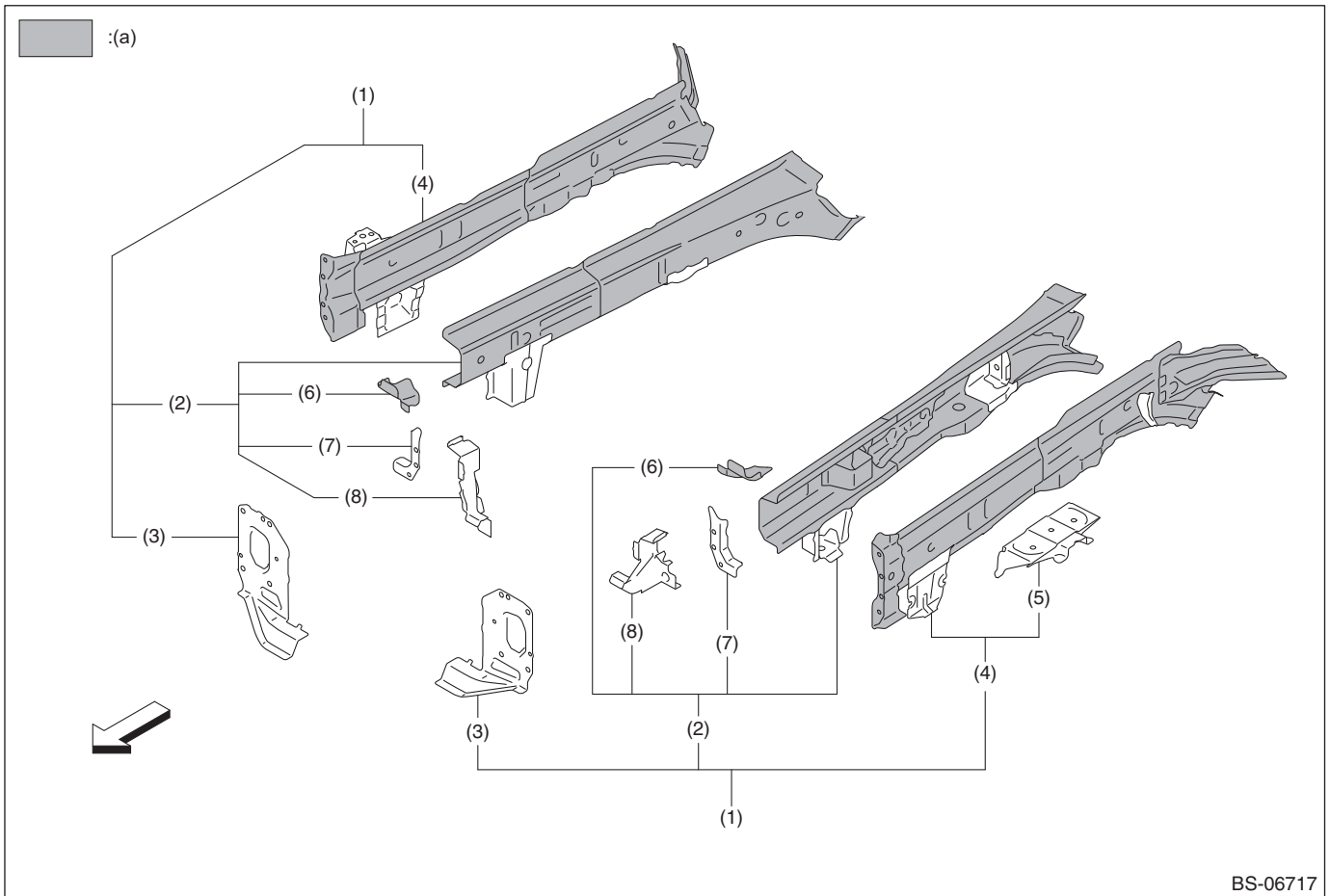


(a) High-strength tensile steel
(440 - 590 MPa class)

- | | | |
|-------------------------------|--------------------------------|-----------------------------------|
| (1) Front suspension bracket | (6) Bracket headlight side | (11) Crossmember toe board center |
| (2) Wheel apron | (7) Bracket fender upper front | (12) Floor crossmember front |
| (3) Side upper inner frame | (8) Frame side upper outer | (13) Front side frame front |
| (4) Bracket fender upper rear | (9) Front side frame rear | |
| (5) Front apron reinforcement | (10) Toe board reinforcement | |

Panel Components

4. FRONT SIDE FRAME



BS-06717

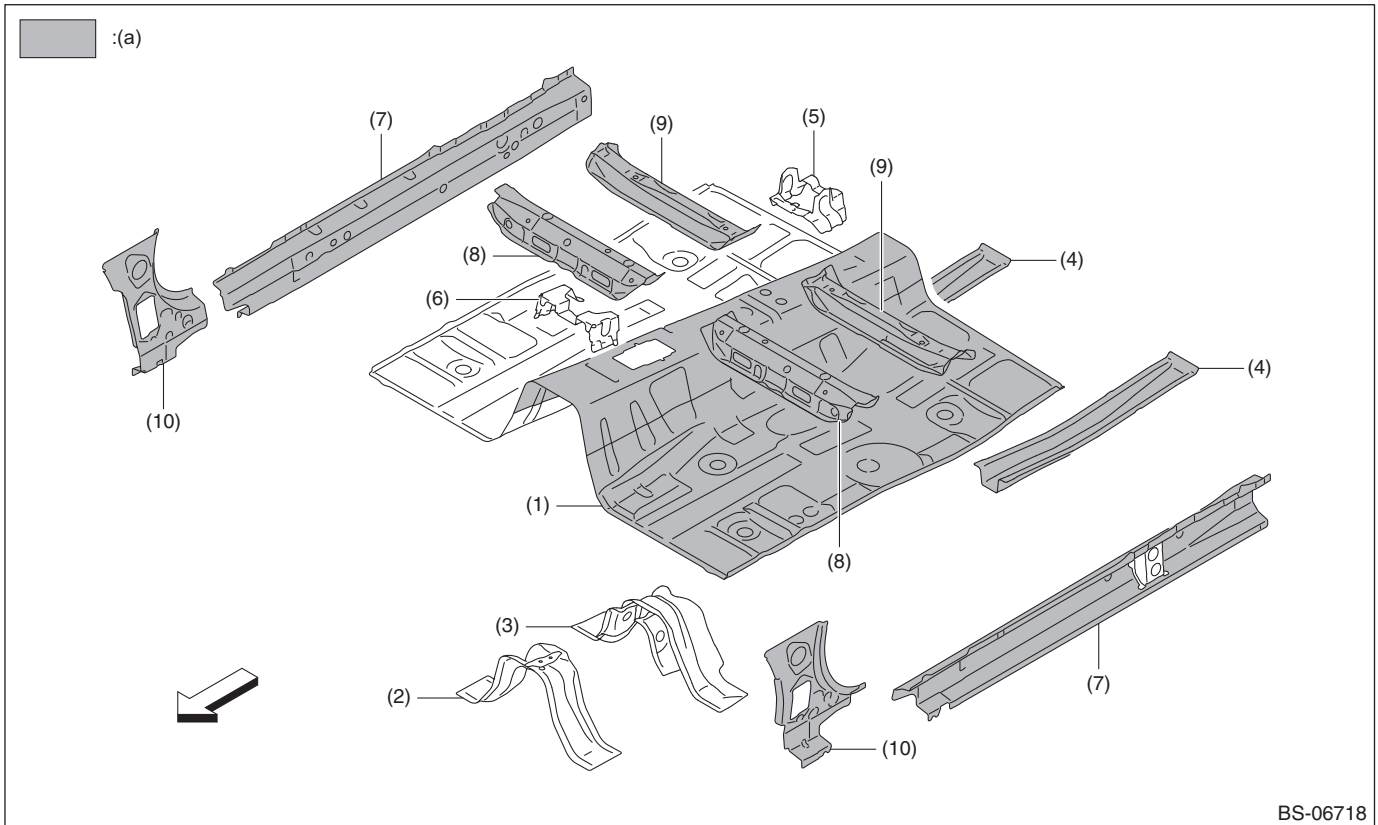
(a) High-strength tensile steel
(440 - 590 MPa class)

- | | | |
|--------------------------------|------------------------------------|------------------------------|
| (1) Front side frame front | (4) Closing plate | (7) Bracket beam front inner |
| (2) Front side sub frame front | (5) Battery reinforcement gusset | (8) Gusset FF A |
| (3) Plate FF | (6) Bracket beam front inner upper | |

Panel Components

5. FRONT FLOOR PANEL

- — '17 MY

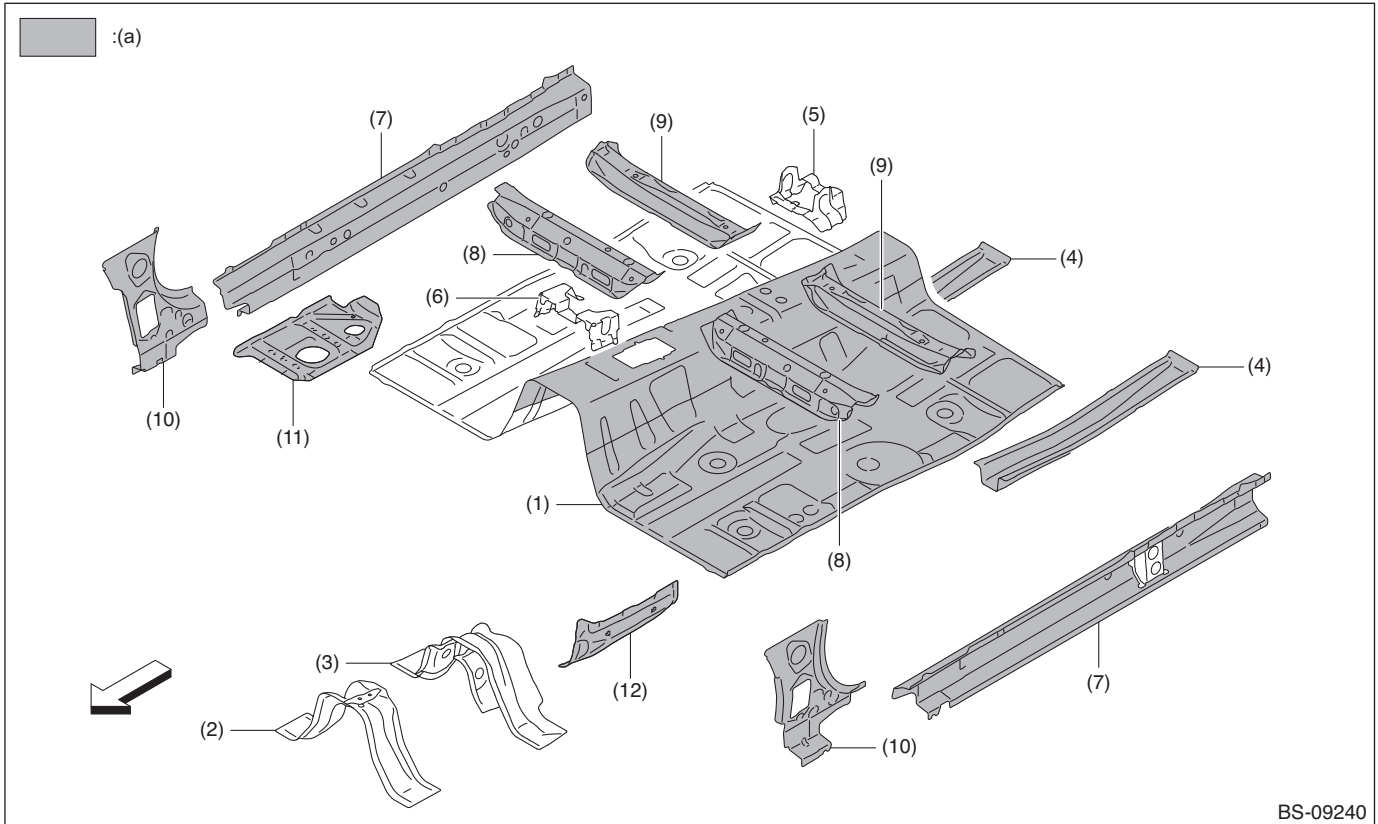


(a) High-strength tensile steel
(440 - 590 MPa class)

- | | | |
|------------------------------|----------------------------------|---------------------------------|
| (1) Floor pan front | (5) Bracket Air bag | (9) Crossmember front seat rear |
| (2) Crossmember floor center | (6) Bracket Instrument panel | (10) Pillar front inner lower |
| (3) Crossmember floor rear | (7) Side sill inner front | |
| (4) Frame side F rear rear | (8) Crossmember front seat front | |

Panel Components

• '18 MY —



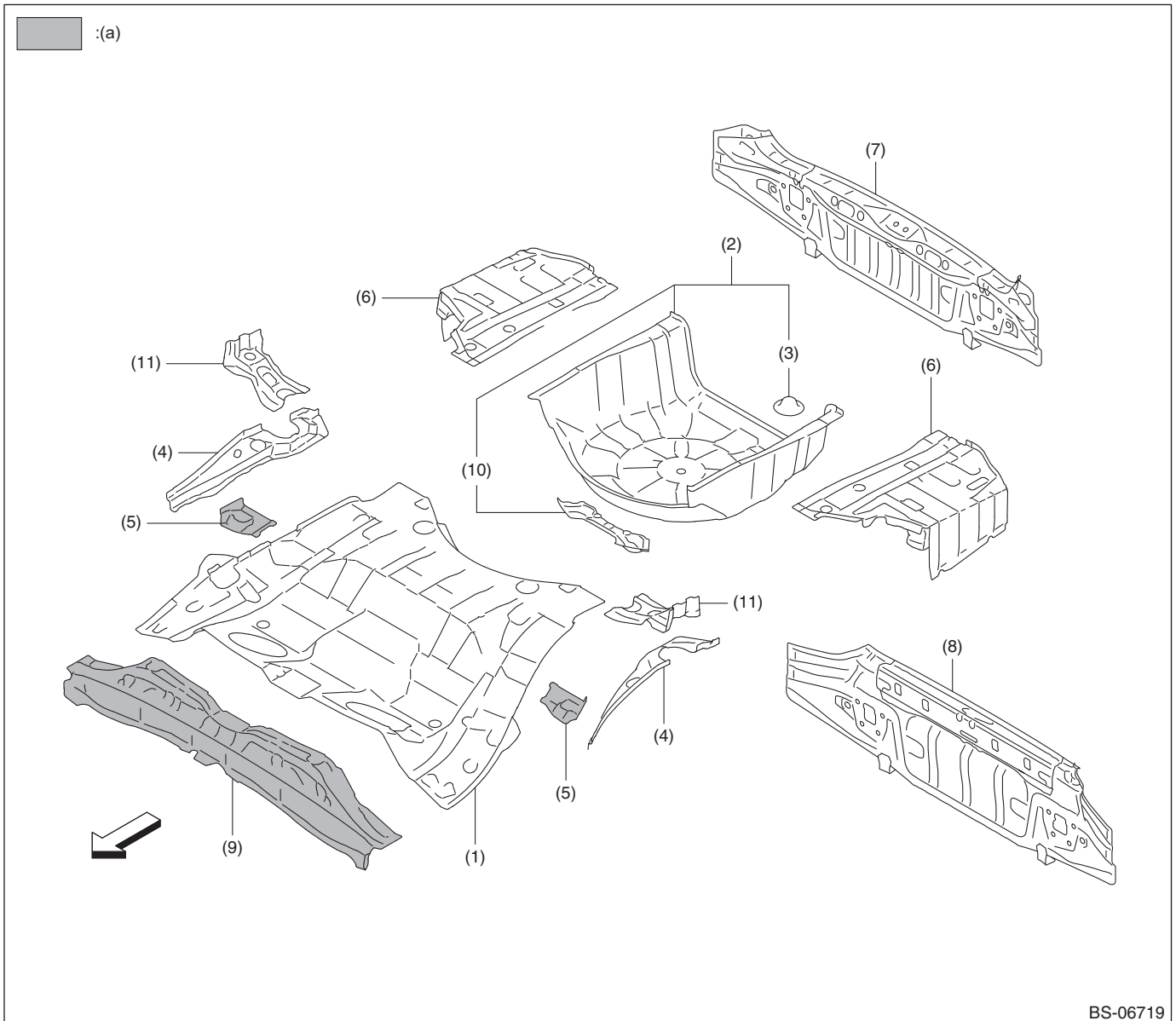
BS-09240

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

- | | | |
|------------------------------|----------------------------------|---------------------------------|
| (1) Floor pan front | (5) Bracket Air bag | (9) Crossmember front seat rear |
| (2) Crossmember floor center | (6) Bracket Instrument panel | (10) Pillar front inner lower |
| (3) Crossmember floor rear | (7) Side sill inner front | (11) Doubler floor front |
| (4) Frame side F rear rear | (8) Crossmember front seat front | (12) Doubler floor rear |

Panel Components

6. REAR FLOOR PANEL & REAR SKIRT



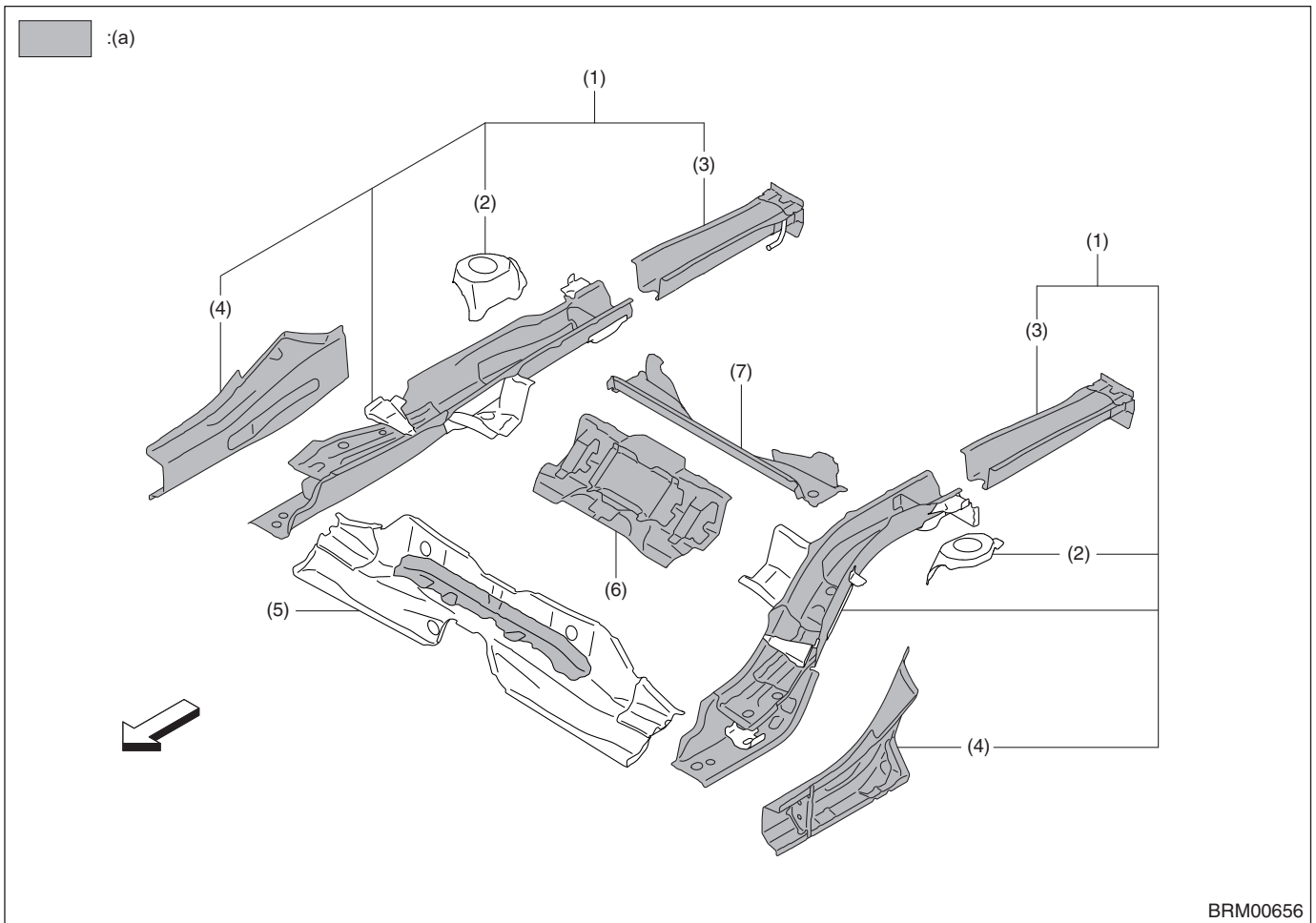
BS-06719

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

- | | | |
|--------------------------|--------------------------------|---------------------------|
| (1) Floor pan rear front | (5) Bracket rear seat side | (9) Crossmember A front |
| (2) Floor pan rear rear | (6) Floor side rear | (10) Bracket support rear |
| (3) Bracket spare tire | (7) Skirt rear outer (OUTBACK) | (11) Gusset rear apron |
| (4) Bracket damper floor | (8) Skirt rear outer (SEDAN) | |

Panel Components

7. REAR FLOOR SIDE FRAME



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

- (1) Frame rear floor side COMPL.
- (2) Bracket damper lower
- (3) Frame side rear lower rear

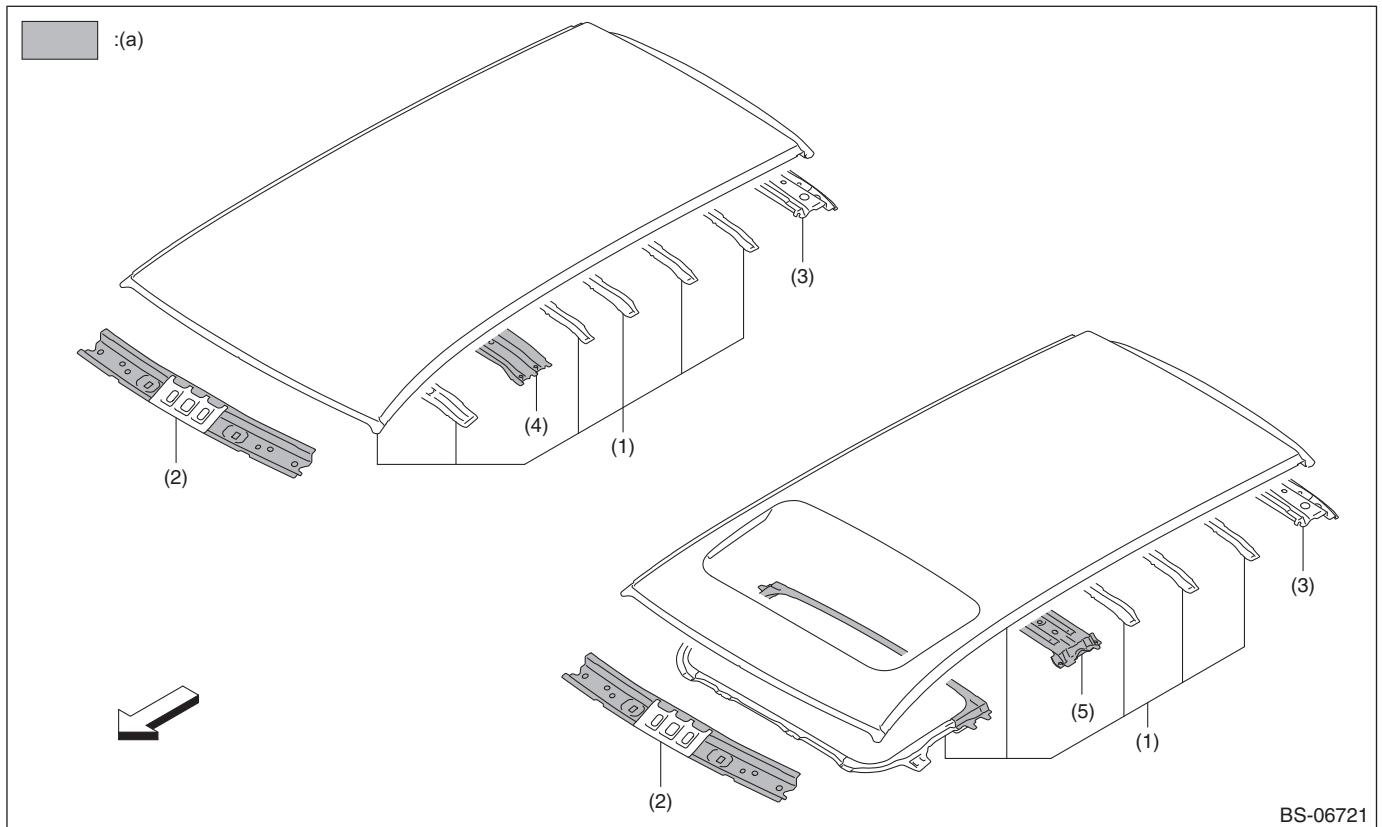
- (4) Side sill inner rear
- (5) Crossmember A rear
- (6) Crossmember B

- (7) Crossmember C

Panel Components

8. ROOF

• OUTBACK



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

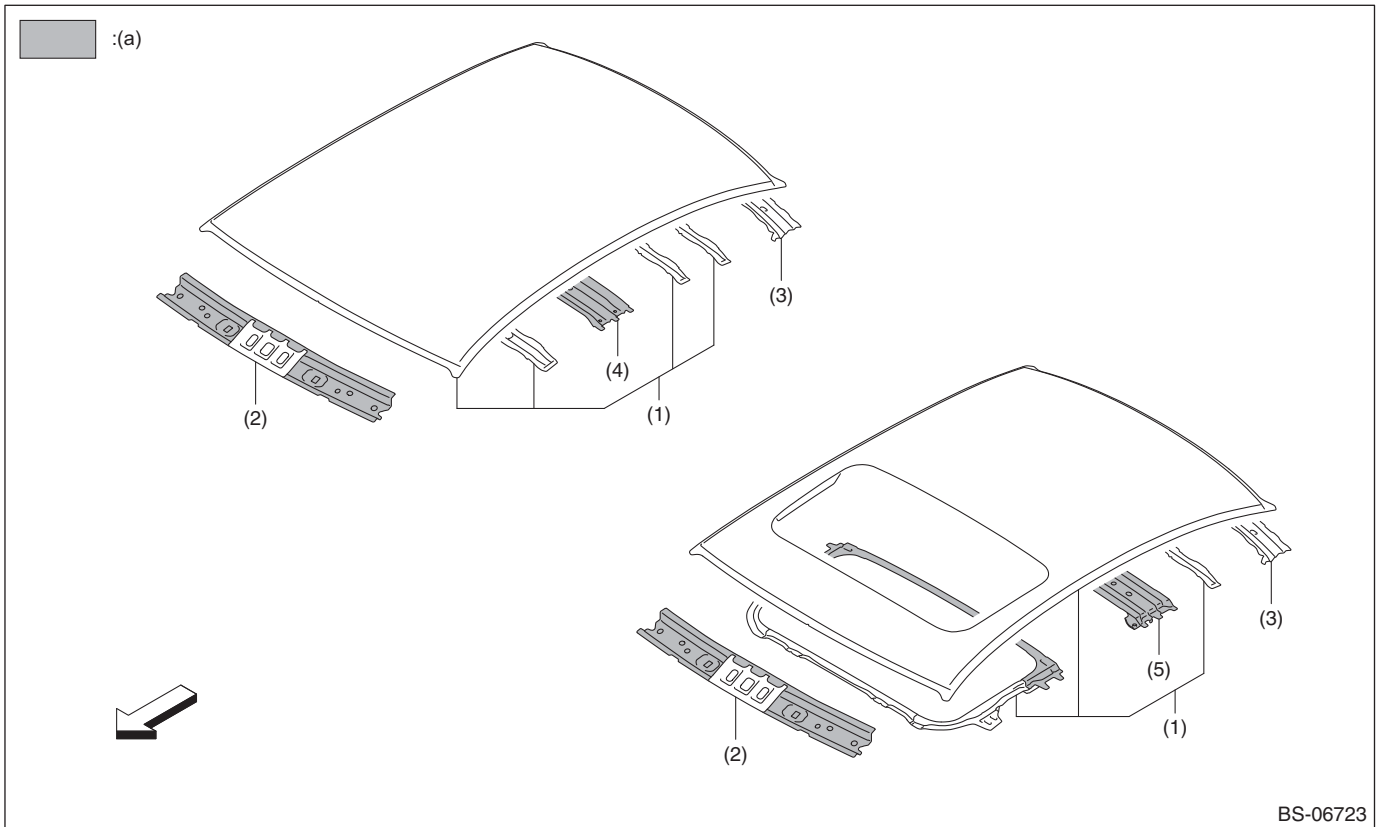
(1) Roof panel
(2) Rail front

(3) Rail rear
(4) Brace center

(5) Brace center (sunroof)

Panel Components

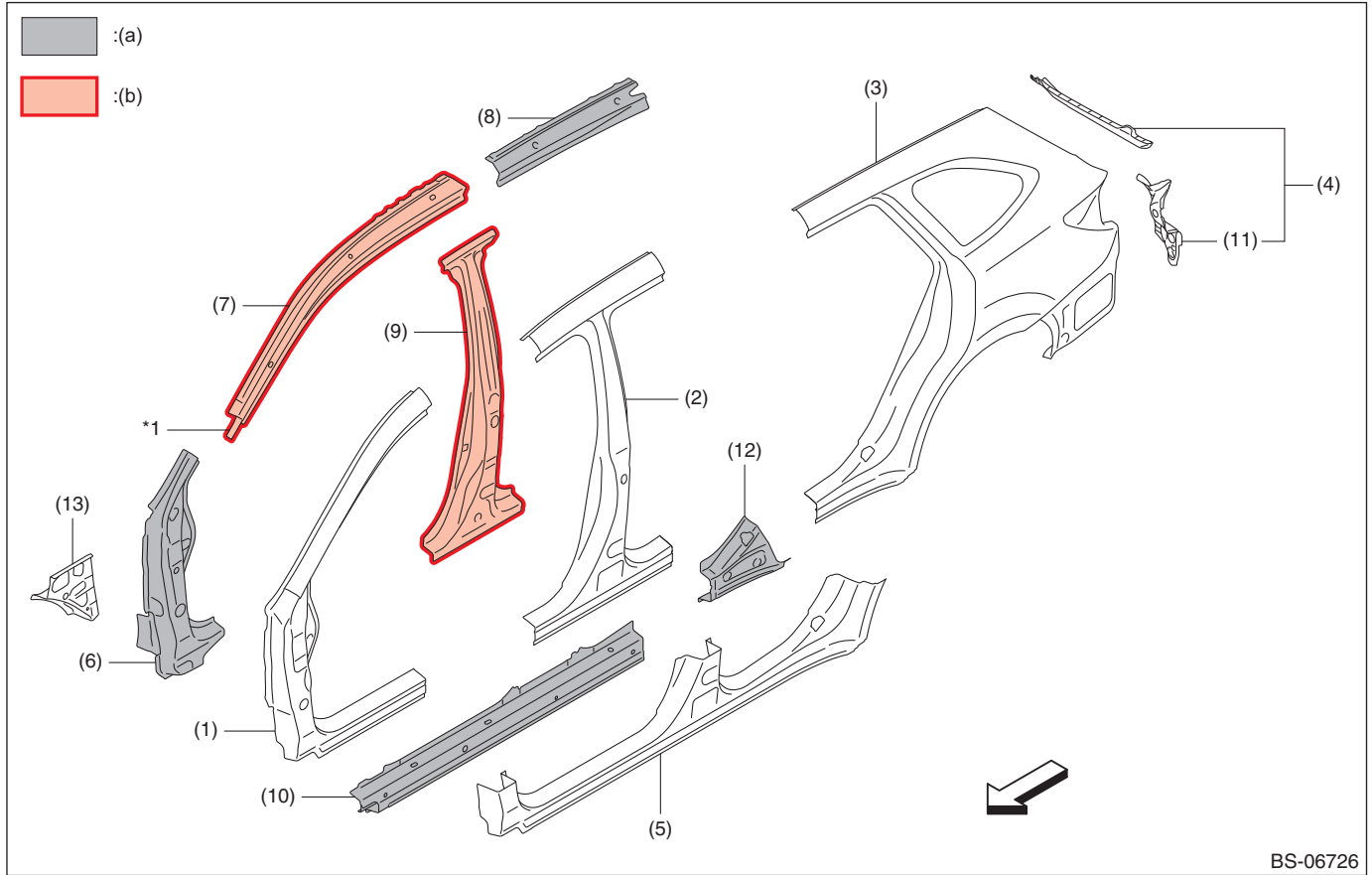
• SEDAN



Panel Components

9. SIDE PANEL OUTER

- OUTBACK
- — '17 MY



BS-06726

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

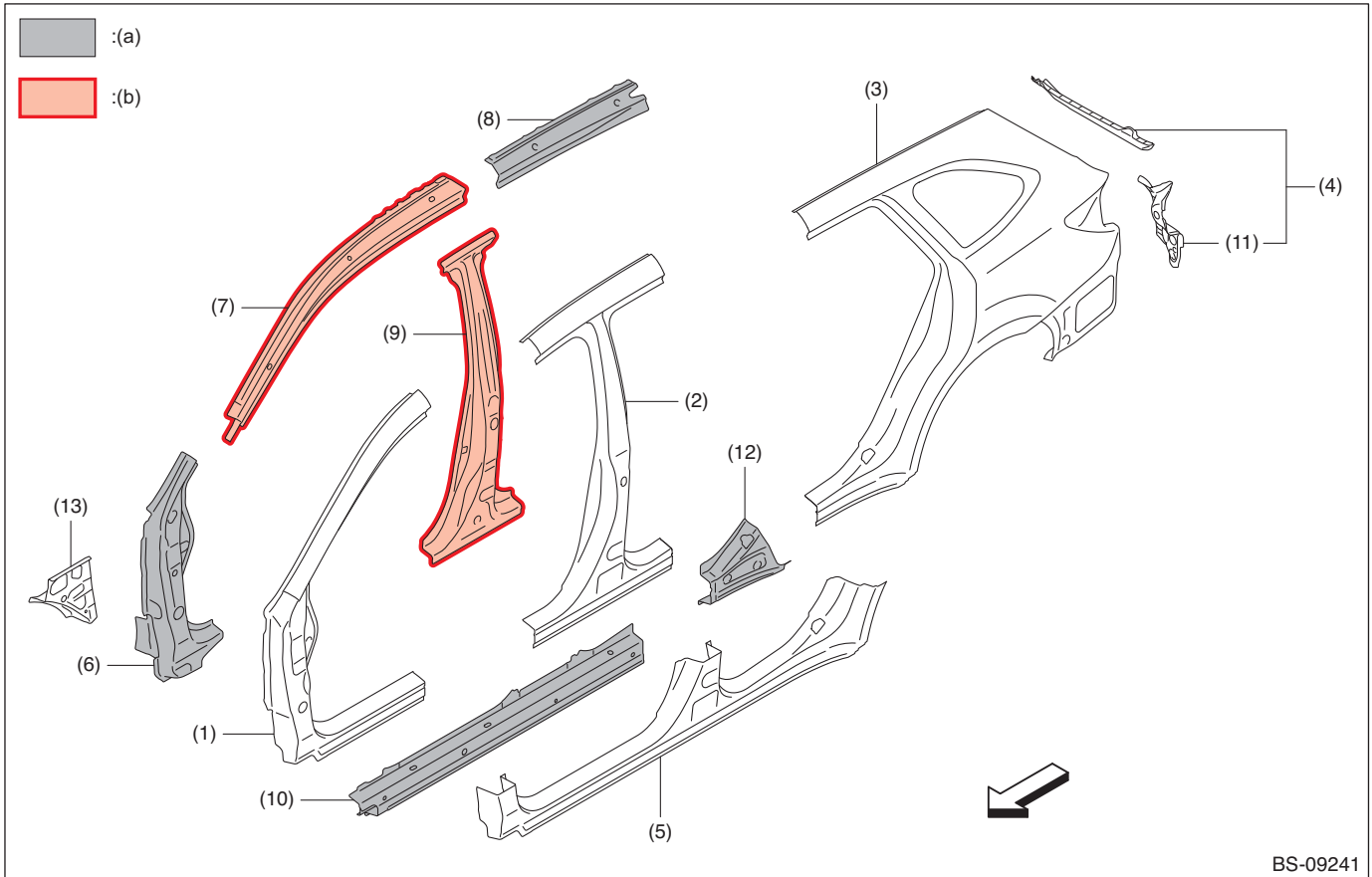
(b) High-strength tensile steel
(1,500 MPa class)

*1: Only LH

- | | | |
|-----------------------------|---|--|
| (1) Front pillar outer | (6) Reinforcement pillar front outer | (10) Reinforcement sill side outer front |
| (2) Center pillar outer | (7) Reinforcement rail side outer front | (11) Quarter panel rear end |
| (3) Rear quarter outer | (8) Reinforcement rail side outer rear | (12) Reinforcement sill side outer rear |
| (4) Rear quarter end COMPL. | (9) Reinforcement pillar center outer | (13) Gusset frame side upper A |
| (5) Side sill outer | | |

Panel Components

• '18 MY —



BS-09241

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

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

(1) Front pillar outer

(2) Center pillar outer

(3) Rear quarter outer

(4) Rear quarter end COMPL.

(5) Side sill outer

(6) Reinforcement pillar front outer

(7) Reinforcement rail side outer front

(8) Reinforcement rail side outer rear

(9) Reinforcement pillar center outer

(10) Reinforcement sill side outer front

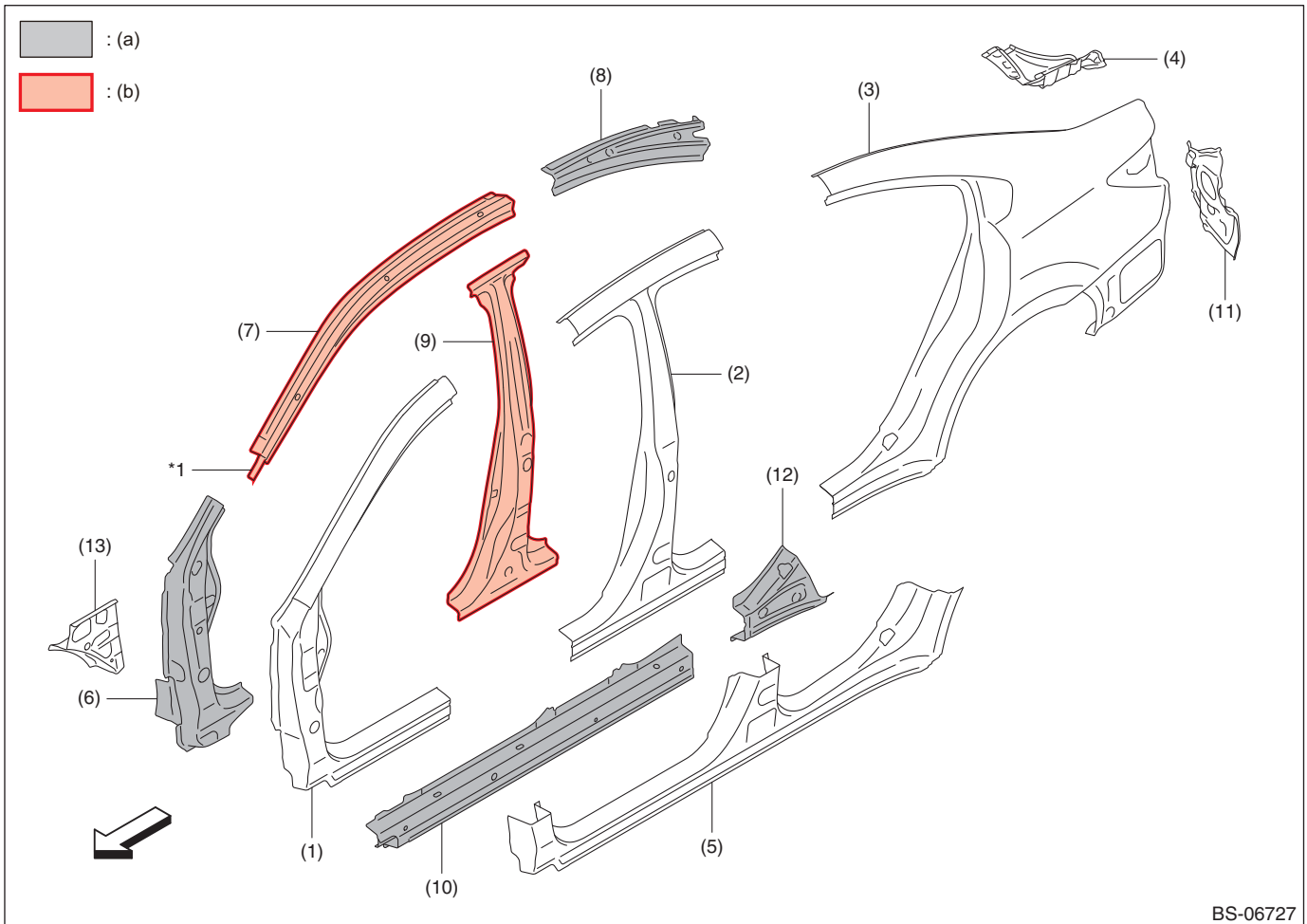
(11) Quarter panel rear end

(12) Reinforcement sill side outer rear

(13) Gusset frame side upper A

Panel Components

- SEDAN
- — '17 MY



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

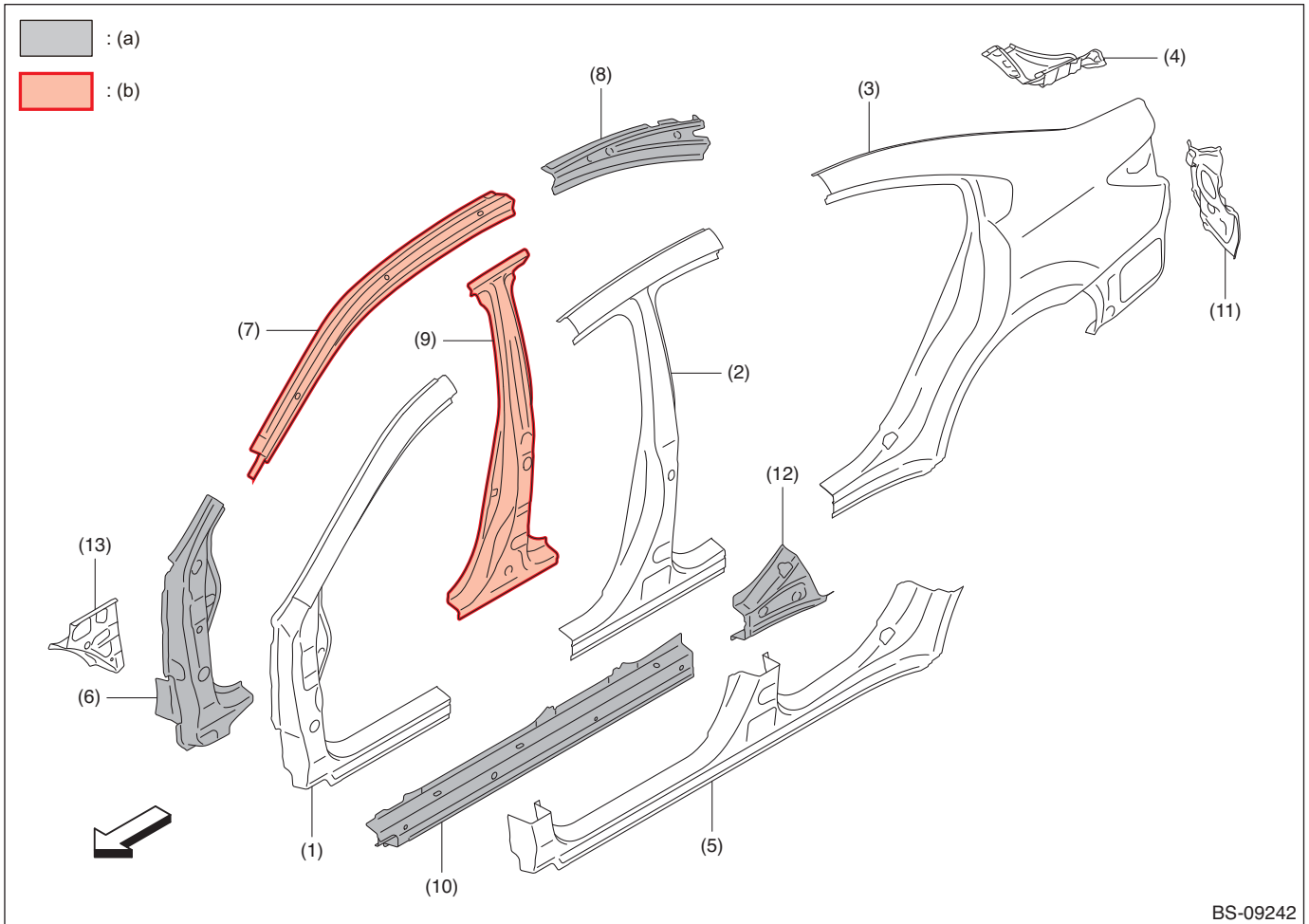
(b) High-strength tensile steel
(1,500 MPa class)

*1: Only LH

- | | | |
|-------------------------|---|--|
| (1) Front pillar outer | (6) Reinforcement pillar front outer | (10) Reinforcement sill side outer front |
| (2) Center pillar outer | (7) Reinforcement rail side outer front | (11) Quarter panel rear end |
| (3) Rear quarter outer | (8) Reinforcement rail side outer rear | (12) Reinforcement sill side outer rear |
| (4) Patch rear pillar | (9) Reinforcement pillar center outer | (13) Gusset frame side upper A |
| (5) Side sill outer | | |

Panel Components

• '18 MY —



BS-09242

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

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

- (1) Front pillar outer
- (2) Center pillar outer
- (3) Rear quarter outer
- (4) Patch rear pillar
- (5) Side sill outer

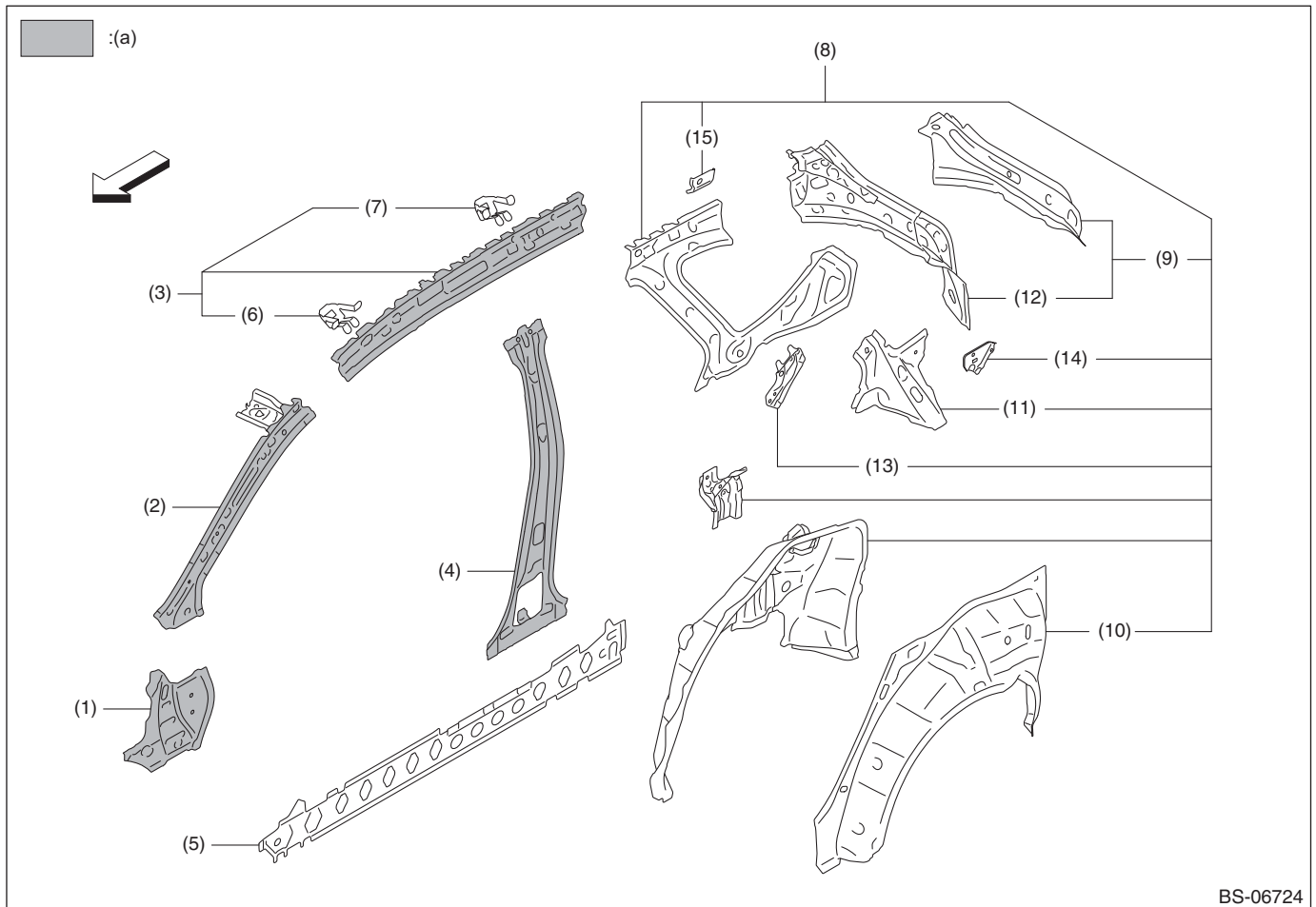
- (6) Reinforcement pillar front outer
- (7) Reinforcement rail side outer front
- (8) Reinforcement rail side outer rear
- (9) Reinforcement pillar center outer

- (10) Reinforcement sill side outer front
- (11) Quarter panel rear end
- (12) Reinforcement sill side outer rear
- (13) Gusset frame side upper A

Panel Components

10.SIDE PANEL INNER

• OUTBACK



BS-06724

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

(1) Pillar front inner center
(2) Pillar front inner upper
(3) Rail side inner

(4) Pillar center inner

(5) Reinforcement sill side

(6) Bracket assist front
(7) Bracket assist rear
(8) Rear quarter inner

(9) Reinforcement D pillar

(10) Arch rear inner

(11) Reinforcement C pillar

(12) Pillar D inner

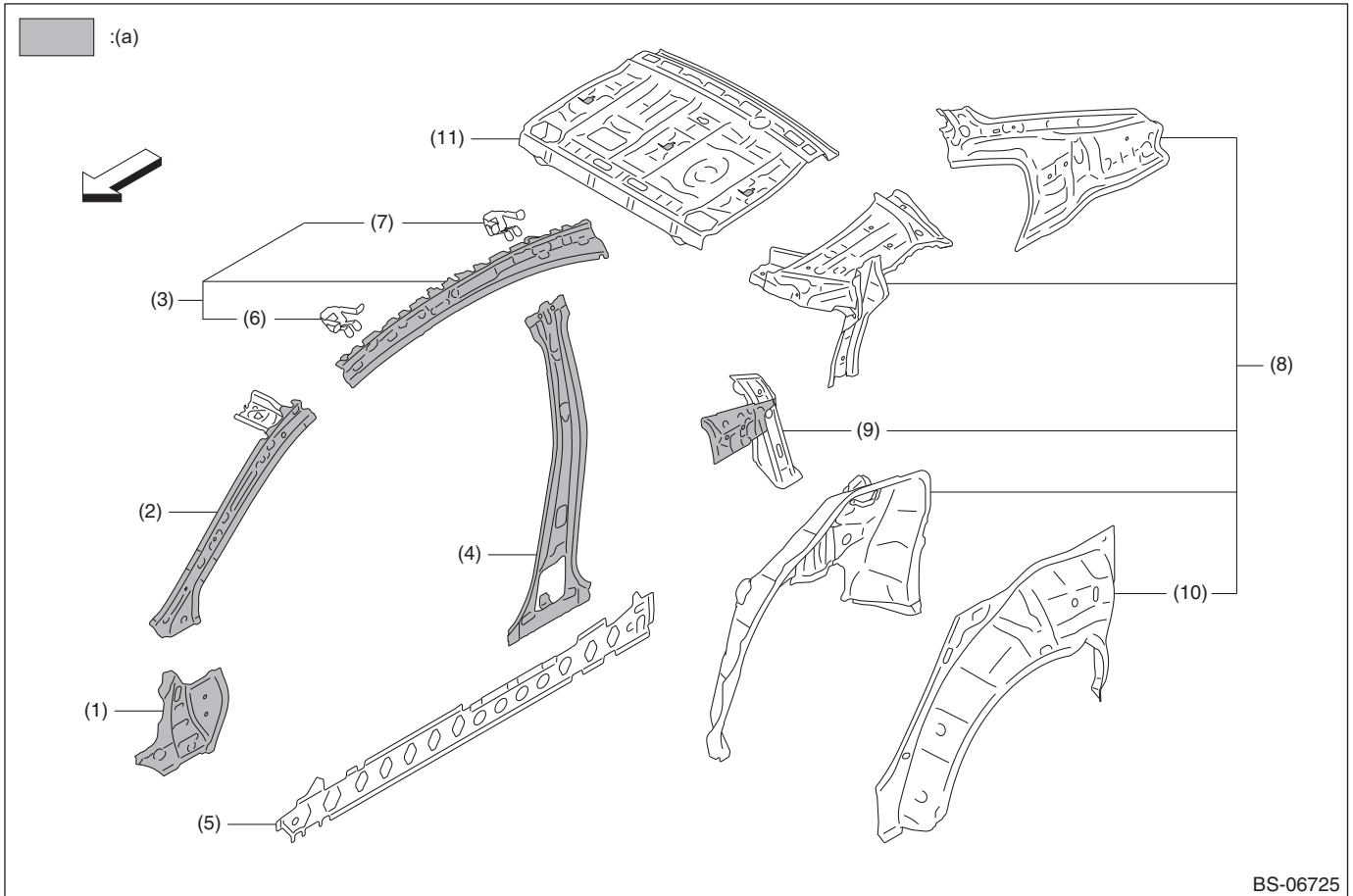
(13) Reinforcement power rear gate
front

(14) Reinforcement power rear gate
rear

(15) Plate nut rear belt

Panel Components

• SEDAN



BS-06725

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

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

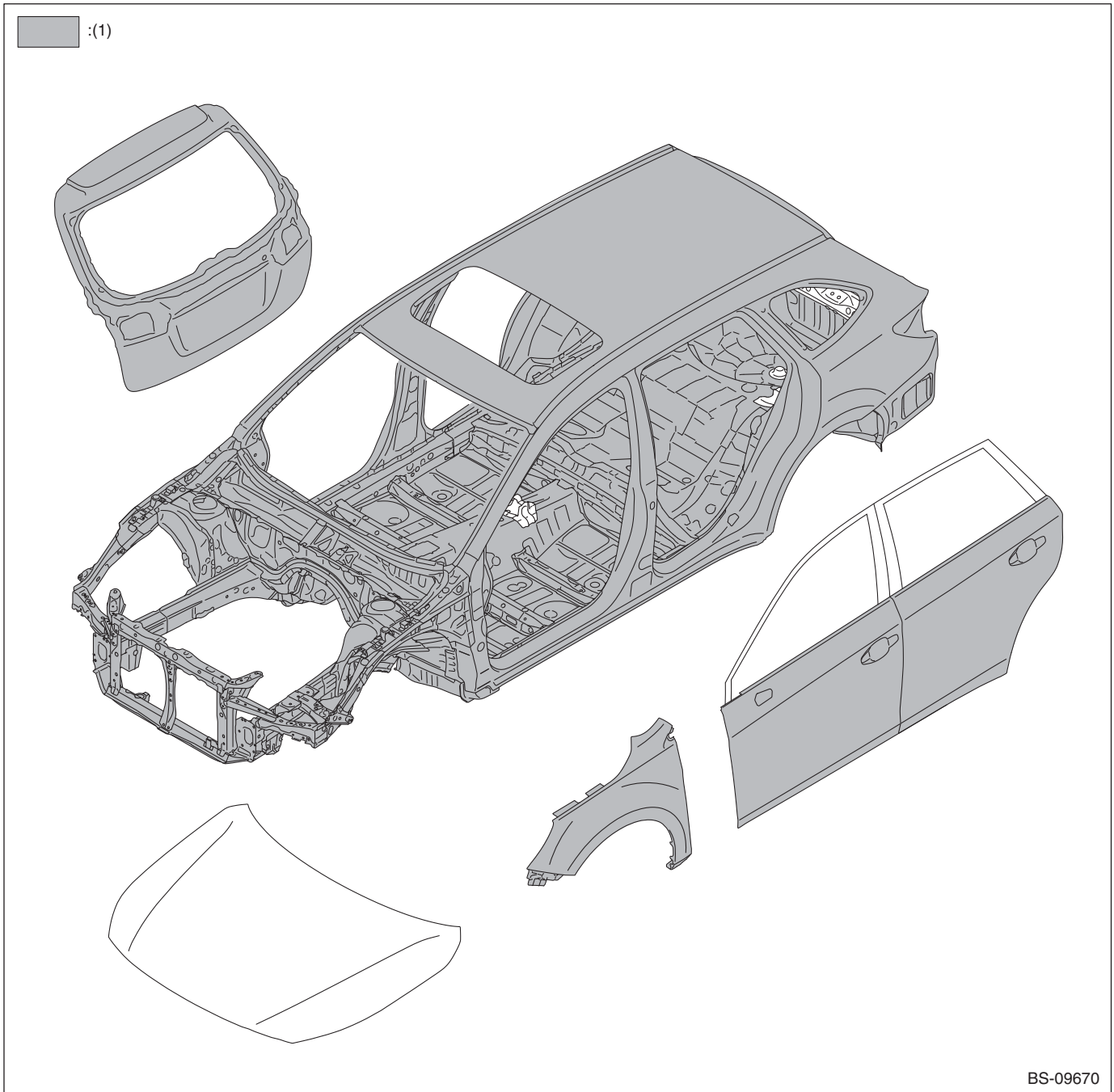
- (5) Reinforcement sill side
- (6) Bracket assist front
- (7) Bracket assist rear
- (8) Rear quarter inner

- (9) Reinforcement rear pillar
- (10) Arch rear inner
- (11) Panel rear

4. Galvanized Sheet Metal

A: SPECIFICATION

- COMMON PARTS FOR OUTBACK AND SEDAN

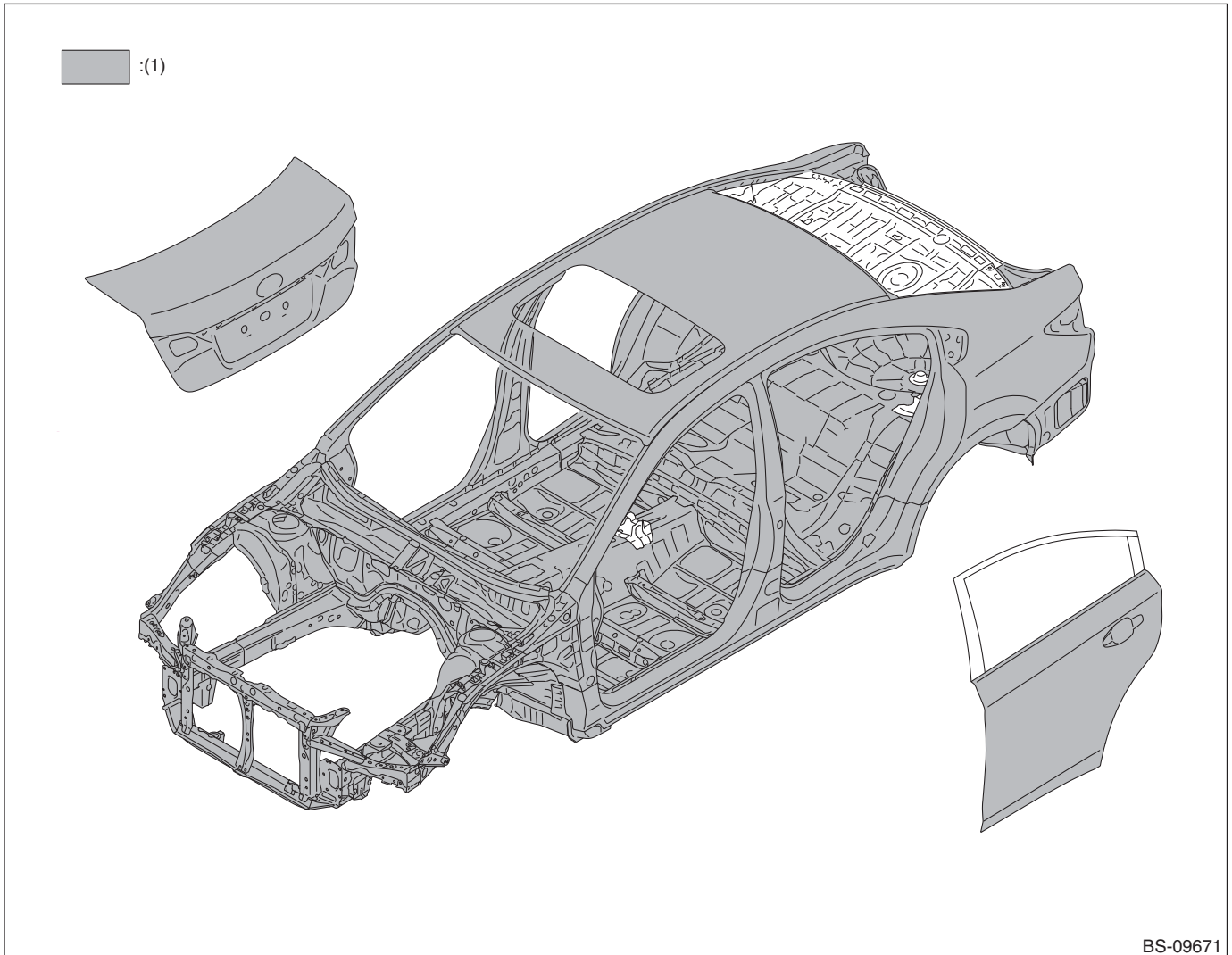


- (1) Galvanized sheet metal
(both sides)

The fuel flap consists of galvanized sheet metal.

Galvanized Sheet Metal

- SPECIAL SEDAN PARTS



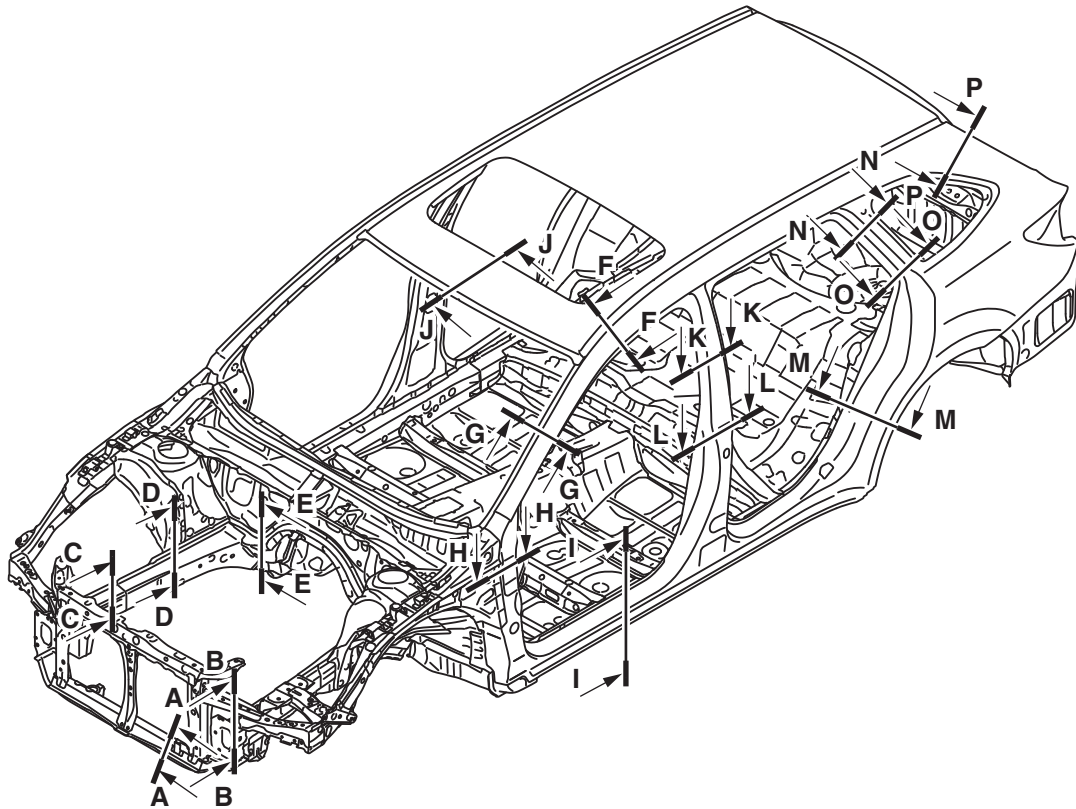
- (1) Galvanized sheet metal
(both sides)

The fuel flap consists of galvanized sheet metal.

5. Body Construction

A: SPECIFICATIONS

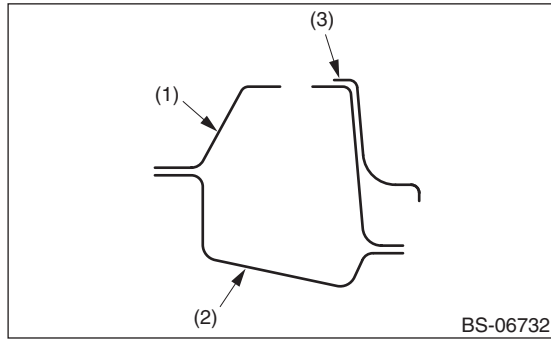
- Common parts for OUTBACK and SEDAN



BS-06730

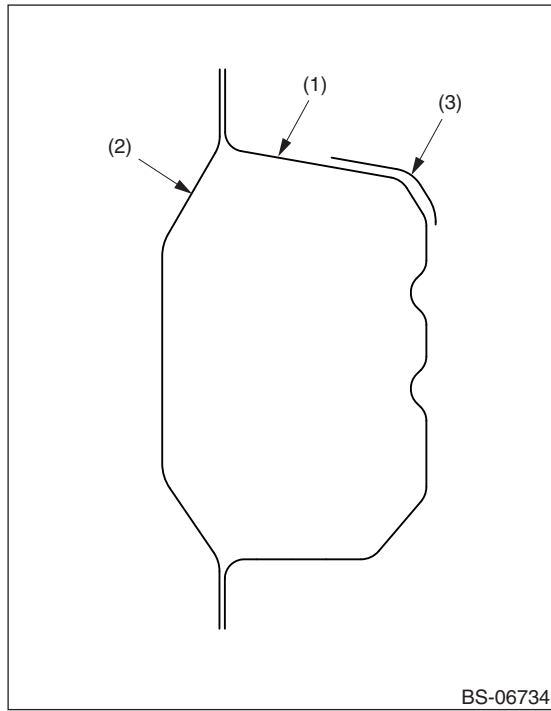
Body Construction

Cross section A — A



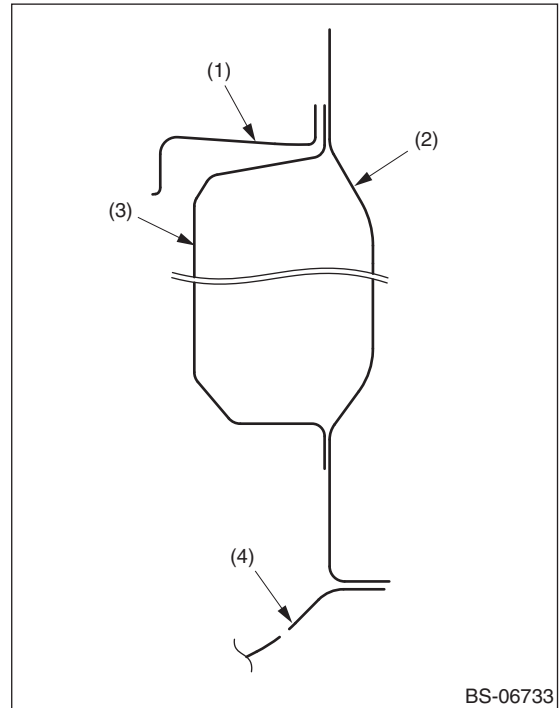
- (1) Frame radiator lower A
- (2) Frame radiator lower lower
- (3) Bracket radiator

Cross section C — C



- (1) Frame side FF A
- (2) Closing plate FF A
- (3) Bracket battery rod (Only LH)

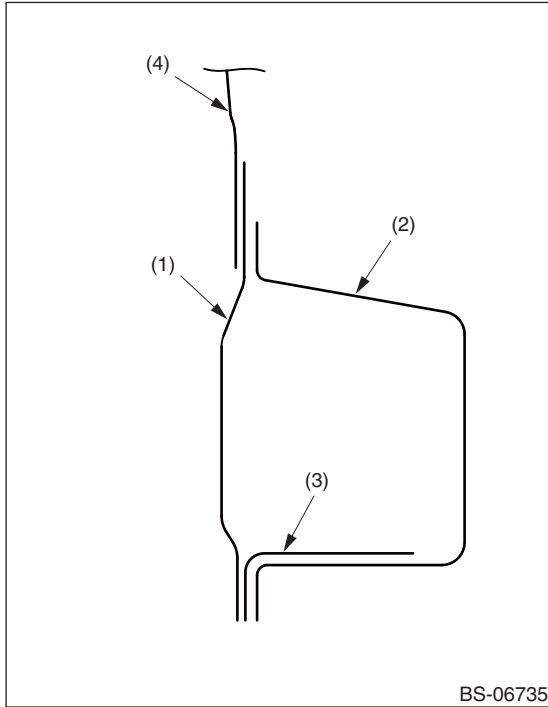
Cross section B — B



- (1) Bracket beam front inner upper
- (2) Bracket beam front outer
- (3) Frame side FF A
- (4) Frame radiator lower lower

Body Construction

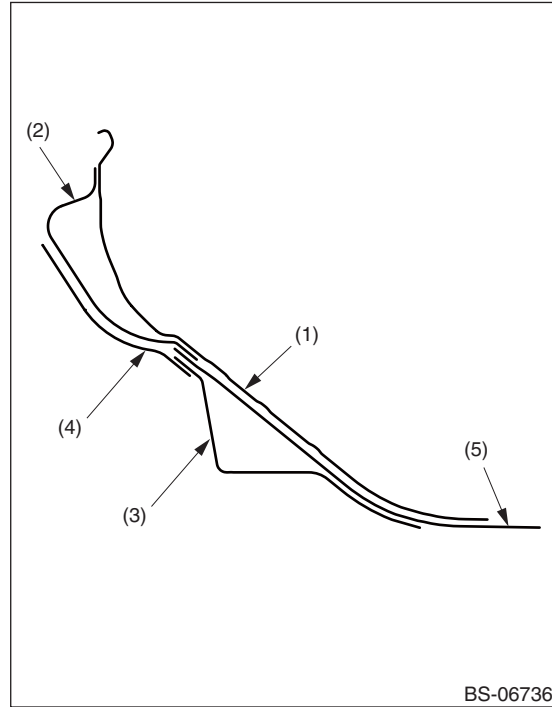
Cross section D — D



BS-06735

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

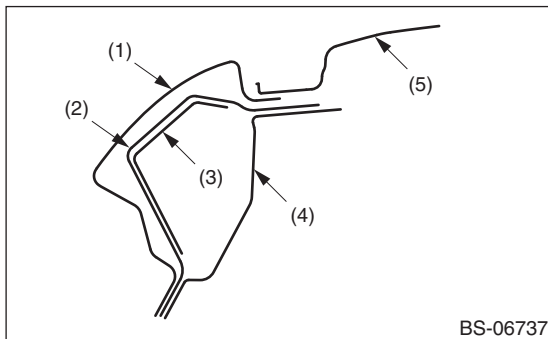
Cross section E — E



BS-06736

- (1) Toe board
- (2) Crossmember toe board center
- (3) Bracket cradle rear
- (4) Frame side FF B
- (5) Frame side F rear

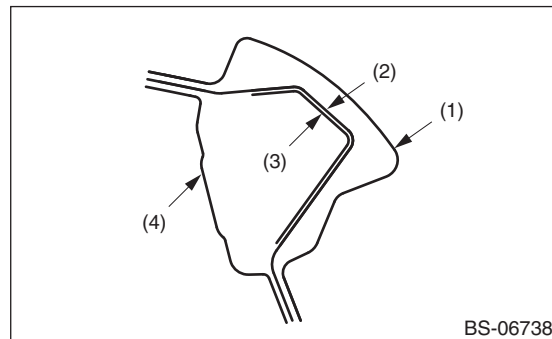
Cross section F — F



BS-06737

- (1) Panel side outer
- (2) Reinforcement rail side outer front
- (3) Patch rail side outer front
- (4) Pillar front inner upper
- (5) Roof panel

Cross section G — G

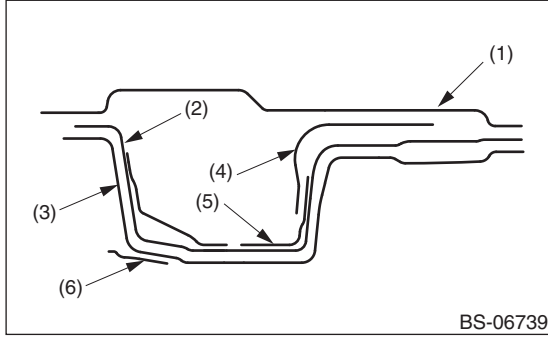


BS-06738

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

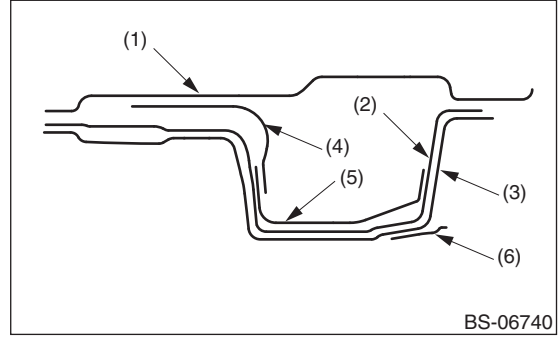
Body Construction

Cross section H — H (LH)



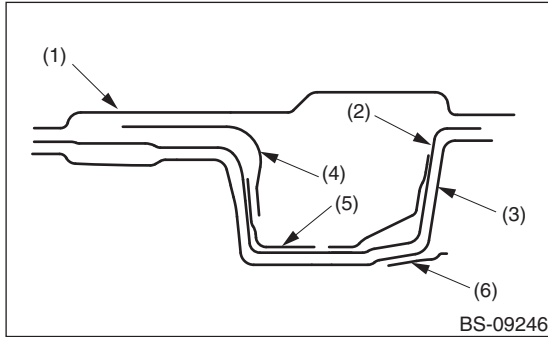
- (1) Pillar front inner center
- (2) Reinforcement pillar front outer
- (3) Panel side outer
- (4) Reinforcement steering support
- (5) Reinforcement pillar front outer A
- (6) Gusset frame side upper A

Cross section H — H (RH) (— '17 MY)



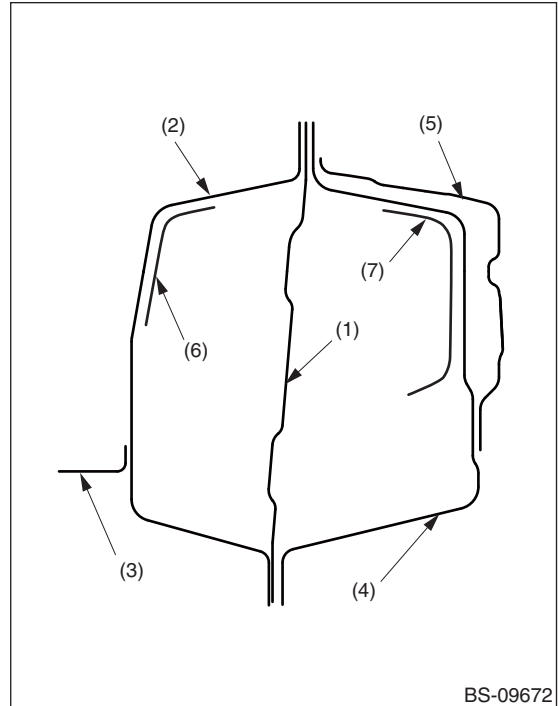
- (1) Pillar front inner center
- (2) Reinforcement pillar front outer
- (3) Panel side outer
- (4) Reinforcement steering support
- (5) Reinforcement hinge front pillar upper
- (6) Gusset frame side upper A

Cross section H — H (RH) ('18 MY —)



- (1) Pillar front inner center
- (2) Reinforcement pillar front outer
- (3) Panel side outer
- (4) Reinforcement steering support
- (5) Reinforcement pillar front outer A
- (6) Gusset frame side upper A

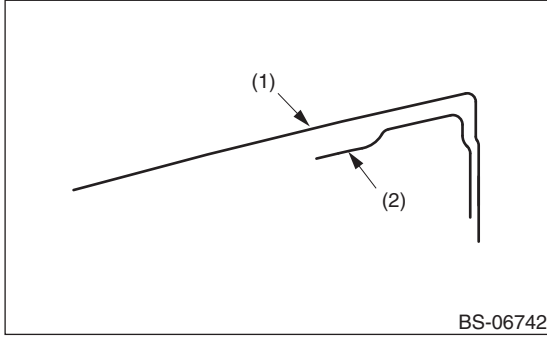
Cross section I — I



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

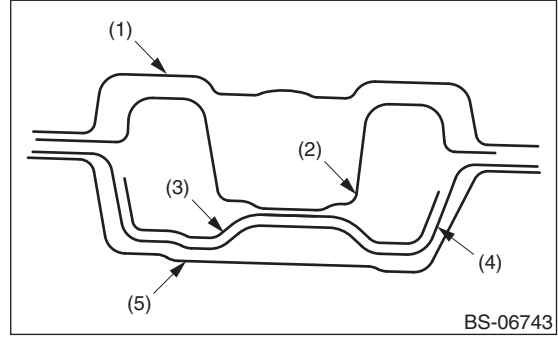
Body Construction

Cross section J — J



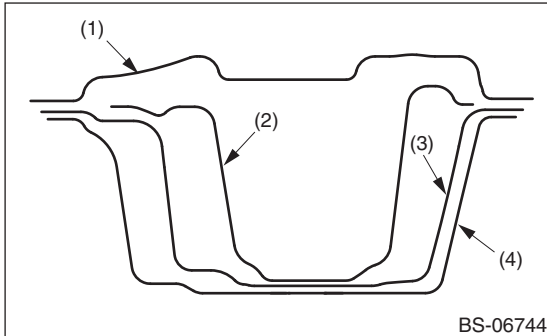
- (1) Roof panel
- (2) Frame sunroof front

Cross section K— K



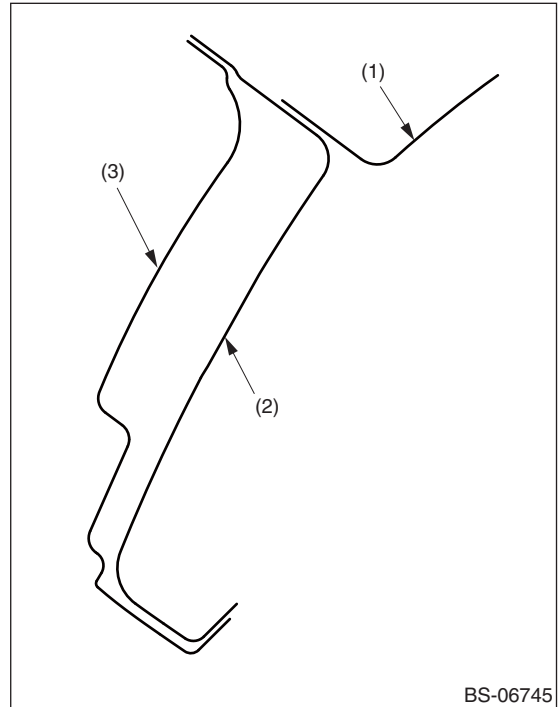
- (1) Pillar center inner
- (2) Reinforcement pillar center outer upper A
- (3) Reinforcement pillar center outer B
- (4) Reinforcement pillar center outer
- (5) Panel side outer

Cross section L — L



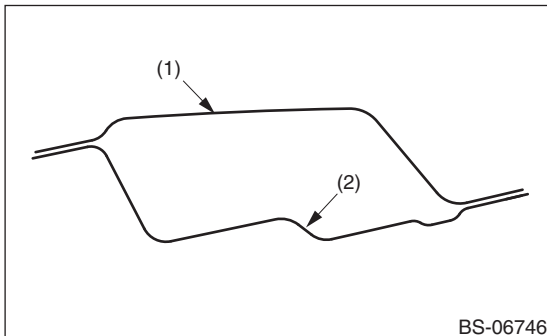
- (1) Pillar center inner
- (2) Reinforcement pillar center outer upper A
- (3) Reinforcement pillar center outer
- (4) Panel side outer

Cross section M —M



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

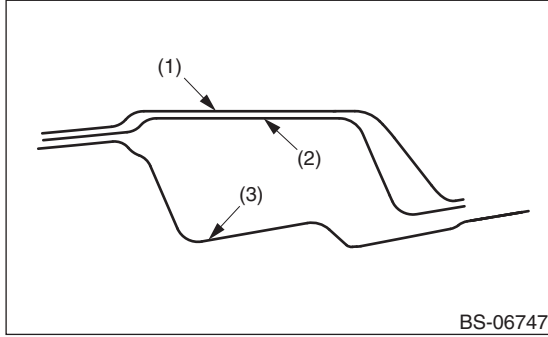
Cross section N — N



- (1) Quarter panel rear inner
- (2) Panel side outer

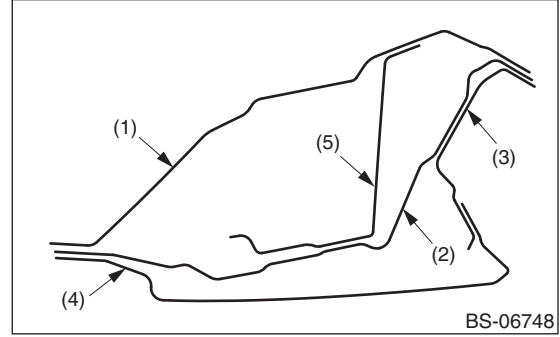
Body Construction

Cross section O — O



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

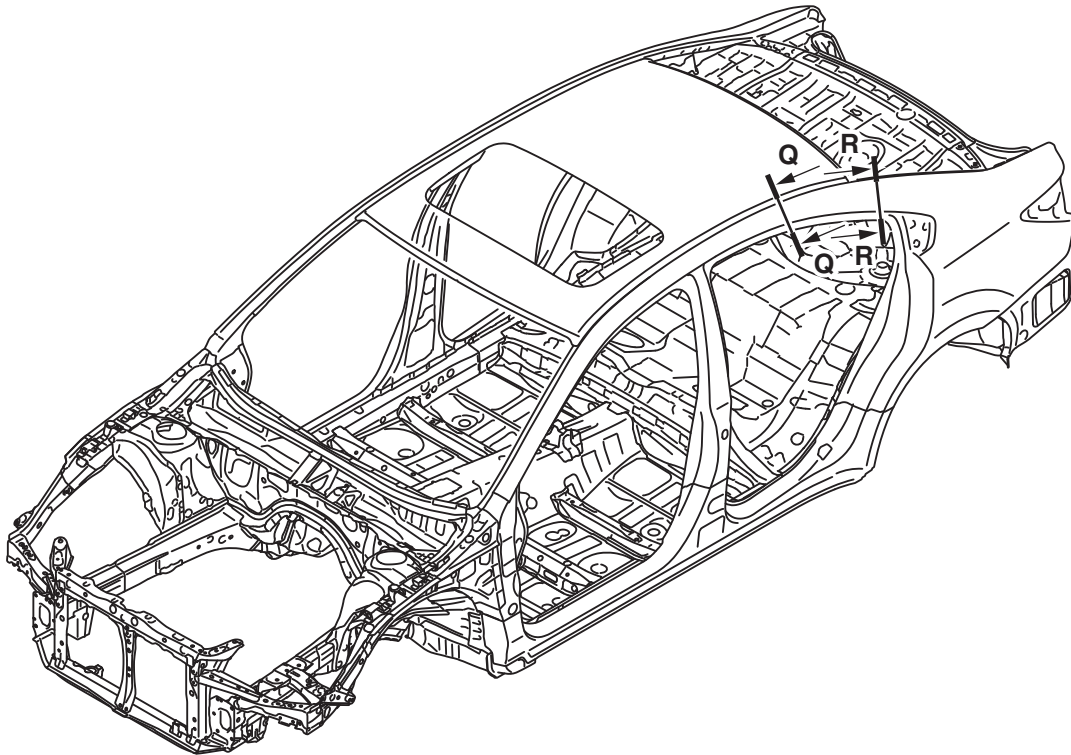
Cross section P — P



- (1) Pillar D inner upper
- (2) Reinforcement D pillar
- (3) Extension D pillar
- (4) Panel side outer
- (5) Separator D pillar

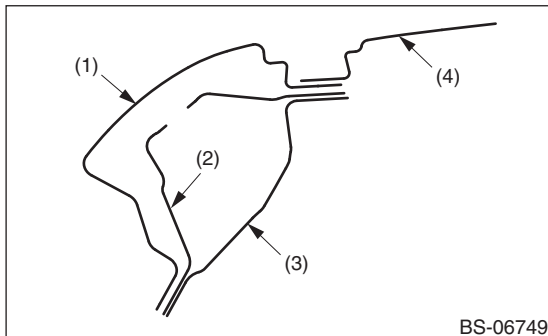
Body Construction

- Special SEDAN parts



BS-06731

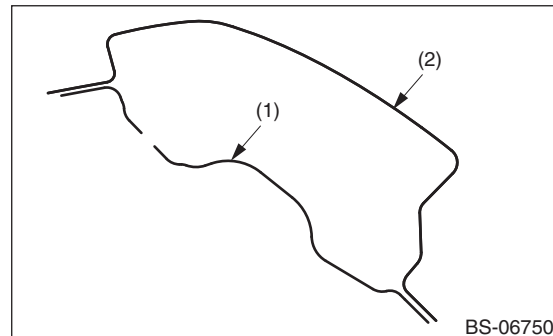
Cross section Q — Q



BS-06749

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

Cross section R — R



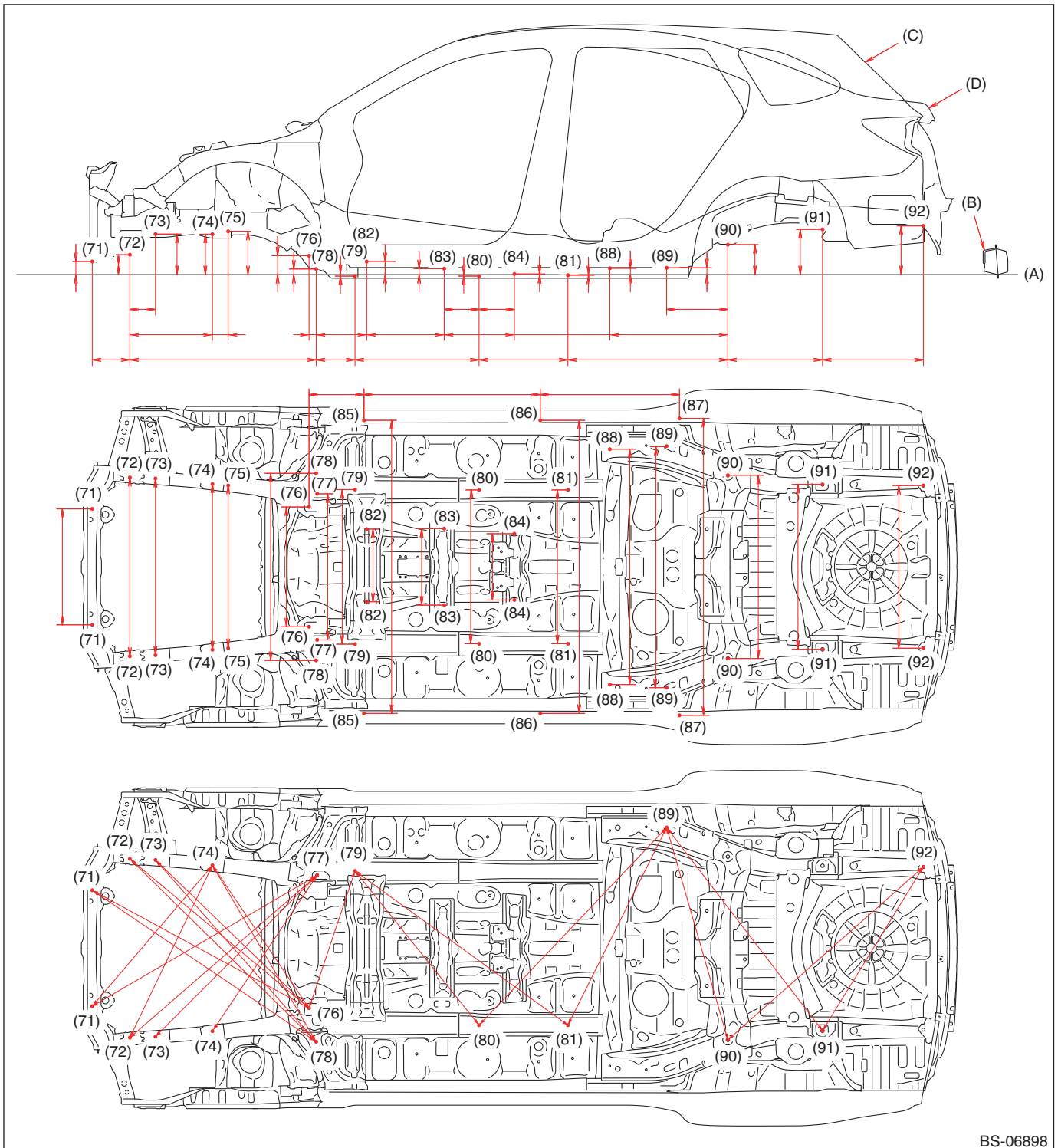
BS-06750

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

6. Body Reference Points

A: DIMENSIONS

1. LOWER SURFACE



BS-06898

- 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 reinforcement flange joint (bending angle point).
- Diagonal dimensions are the actual dimensions between reference points.

Body Reference Points

(A) Standard line
(B) Side sill reinforcement

(C) OUTBACK

(D) SEDAN

(71) Bracket center lower mounting hole (symmetrical)	(80) Under cover mounting hole (symmetrical)	(86) Side sill spoiler mounting hole (symmetrical)
(72) Cradleframe mounting hole (symmetrical), front	(81) Under cover mounting hole (symmetrical)	(87) Garnish side mounting hole (symmetrical)
(73) Earth mounting hole (symmetrical)	(82) MT & CFT-CVT crossmember mounting hole, right side	(88) Fuel tank Protector mounting hole (symmetrical)
(74) Engine mounting bracket mounting hole (symmetrical), front	(82) MT & CFT-CVT crossmember mounting hole, left side	(89) Rear suspension support sub frame mounting hole (symmetrical), front
(75) Engine mounting bracket mounting hole (symmetrical), rear	(82) HT-CVT crossmember mounting hole, right side	(90) Rear suspension crossmember mounting hole (symmetrical), front
(76) Crossmember mounting hole (symmetrical)	(82) HT-CVT crossmember mounting hole, left side	(91) Rear suspension crossmember mounting hole (symmetrical), rear
(77) Cradleframe mounting hole (symmetrical), rear inside	(83) Gauge hole (symmetrical)	(92) Gauge hole (symmetrical)
(78) Cradleframe mounting hole (symmetrical), rear outside	(84) Exhaust cover mounting hole (symmetrical)	
(79) Stiffener mounting hole (symmetrical)	(85) Side sill spoiler mounting hole (symmetrical)	

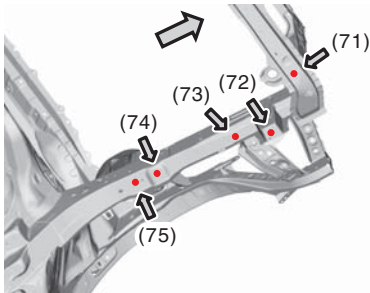
Measuring point	Datum dimension mm (in)	Projected dimensions for reference mm (in)
Datum line — (71)	68 (2.67)	—
Datum line — (72)	103 (4.05)	—
Datum line — (73)	210 (8.25)	—
Datum line — (74)	209 (8.23)	—
Datum line — (75)	224 (8.82)	—
Datum line — (76)	98 (3.84)	—
Datum line — (78)	29 (1.14)	—
Datum line — (79)	-8 (-0.31)	—
Datum line — (80)	-8 (-0.31)	—
Datum line — (81)	-3 (-0.12)	—
Datum line — (82)aR	67 (2.65)	—
Datum line — (82)aL	62 (2.43)	—
Datum line — (82)bR	67 (2.65)	—
Datum line — (82)bL	62 (2.43)	—
Datum line — (83)	30 (1.19)	—
Datum line — (84)	3 (0.13)	—
Datum line — (88)	33 (1.29)	—
Datum line — (89)	35 (1.39)	—
Datum line — (90)	155 (6.10)	—
Datum line — (91)	234 (9.21)	—
Datum line — (92)	252 (9.91)	—
(71) — (72)	195 (7.68)	—
(72) — (73)	133 (5.24)	—
(72) — (74)	428 (16.85)	—
(72) — (78)	965 (37.99)	—
(74) — (75)	82 (3.23)	—
(76) — (78)	37 (1.46)	—

Measuring point	Datum dimension mm (in)	Projected dimensions for reference mm (in)
(76) — (85)	284 (11.18)	—
(78) — (79)	201 (7.91)	—
(78) — (82)aR	262 (10.31)	—
(78) — (82)aL	262 (10.31)	—
(78) — (82)bR	362 (14.25)	—
(78) — (82)bL	362 (14.25)	—
(79) — (80)	642 (25.28)	—
(80) — (81)	460 (18.11)	—
(80) — (83)	180 (7.09)	—
(80) — (84)	183 (7.20)	—
(82)aR — (83)	402 (15.83)	—
(82)aL — (83)	402 (15.83)	—
(82)bR — (83)	302 (11.89)	—
(82)bL — (83)	302 (11.89)	—
(83) — (84)	363 (14.29)	—
(81) — (90)	828 (32.60)	—
(85) — (86)	913 (35.94)	—
(86) — (87)	721 (28.37)	—
(88) — (90)	611 (24.06)	—
(89) — (90)	317 (12.48)	—
(90) — (91)	490 (19.29)	—
(91) — (92)	522 (20.55)	—
(71)R — (71)L	600 (23.62)	—
(72)R — (72)L	914 (35.98)	—
(73)R — (73)L	862 (33.94)	—
(74)R — (74)L	840 (33.07)	—
(75)R — (75)L	746 (29.37)	—

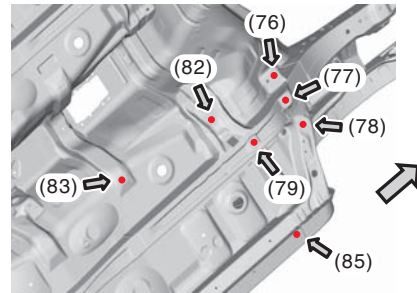
Body Reference Points

Measuring point	Datum dimension mm (in)	Projected dimensions for reference mm (in)
(76)R — (76)L	968 (38.11)	—
(77)R — (77)L	756 (29.76)	—
(78)R — (78)L	376 (14.80)	—
(79)R — (79)L	361 (14.21)	—
(80)R — (80)L	800 (31.50)	—
(81)R — (81)L	796 (31.34)	—
(82)aR — (82)aL	796 (31.34)	—
(82)bR — (82)bL	1,525 (60.05)	—
(83)R — (83)L	1,525 (60.05)	—
(84)R — (84)L	1,516 (59.67)	—
(85)R — (85)L	396 (15.59)	—
(86)R — (86)L	343 (13.51)	—
(87)R — (87)L	1,220 (48.02)	—
(88)R — (88)L	1,186 (46.69)	—
(89)R — (89)L	1,060 (41.73)	—
(90)R — (90)L	854 (33.62)	—
(91)R — (91)L	854 (33.62)	—
(92)R — (92)L	1,108 (43.61)	—
(71)R — (74)L	969 (38.14)	958 (37.73)
(71)L — (76)R	1,278 (50.30)	1,277 (50.29)
(72)R — (74)L	994 (39.15)	989 (38.93)

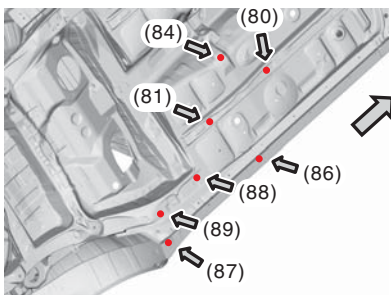
Measuring point	Datum dimension mm (in)	Projected dimensions for reference mm (in)
(72)L — (76)R	1,207 (47.52)	1,207 (47.52)
(73)L — (76)R	1,110 (43.71)	1,105 (43.49)
(74)L — (76)R	899 (35.40)	892 (35.13)
(76)R — (79)L	756 (29.77)	749 (29.48)
(79)L — (80)R	1024 (40.32)	1024 (40.32)
(79)L — (81)R	1,361 (53.57)	1,361 (53.57)
(80)R — (89)L	1,411 (55.55)	1,410 (55.53)
(81)R — (89)L	1,144 (45.04)	1,144 (45.04)
(89)L — (90)R	1,150 (45.28)	1,144 (45.04)
(89)L — (91)R	1,341 (52.78)	1,326 (52.20)
(90)R — (92)L	1,354 (53.32)	1,351 (53.19)
(91)R — (92)L	996 (39.21)	996 (39.21)
(71)R — (77)L	1,348 (53.07)	1,347 (53.03)
(71)L — (78)R	1,400 (55.12)	1,399 (55.08)
(72)R — (77)L	1,285 (50.59)	1,283 (50.51)
(72)L — (78)R	1,353 (53.27)	1,351 (53.19)
(73)R — (77)L	1,196 (47.09)	1,182 (46.54)
(73)L — (78)R	1,269 (49.96)	1,256 (49.45)
(74)R — (77)L	989 (38.94)	972 (38.27)
(74)L — (78)R	1,074 (42.28)	1,059 (41.69)



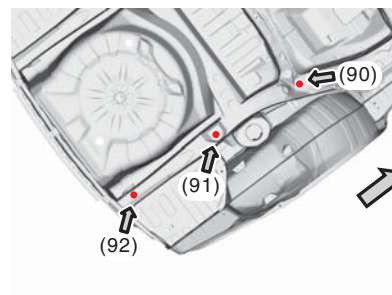
BS-06657



BS-06658



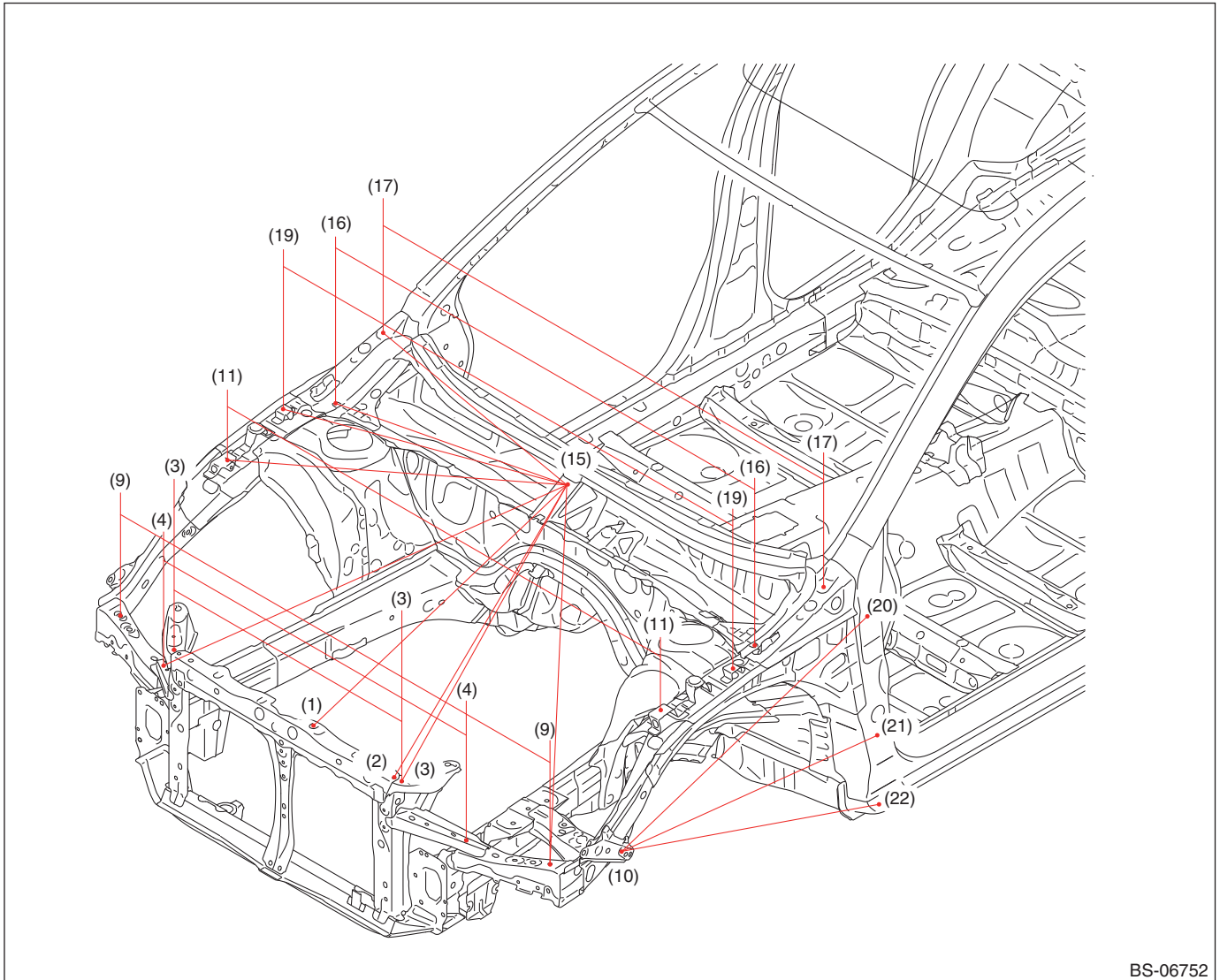
BS-06659



BS-06660

Body Reference Points

2. FRONT 1



BS-06752

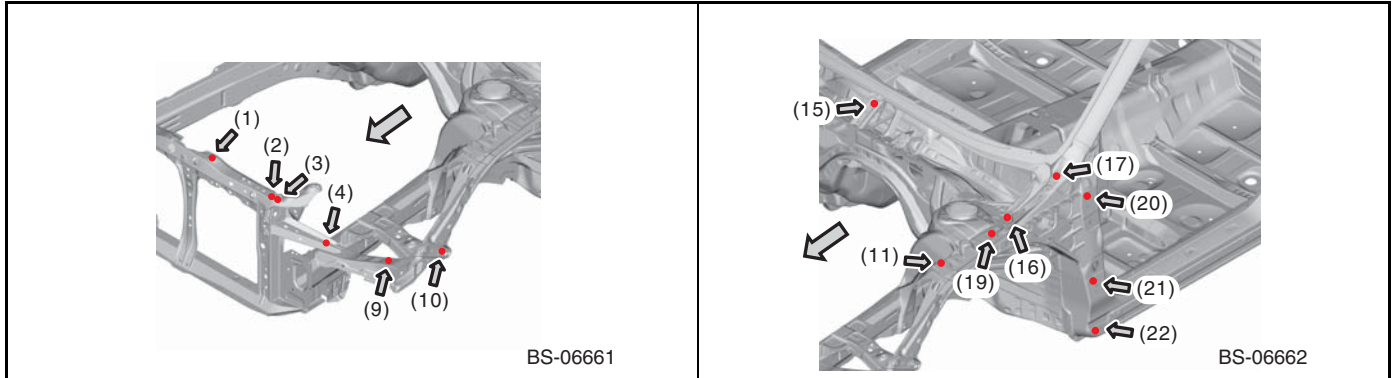
- | | | |
|--|---|---|
| (1) Bracket grill mounting hole (body left side) | (10) Fender front mounting hole (symmetrical) | (19) Fender front mounting hole (symmetrical) |
| (2) Radiator panel sub COMPL mounting hole (symmetrical) | (11) Gauge hole (symmetrical) | (20) Front door hinge upper mounting hole (symmetrical), upper side |
| (3) Manufacturer's collection hole (symmetrical) | (15) Manufacturer's collection hole (body center) | (21) Front door hinge lower mounting hole (symmetrical), upper side |
| (4) Manufacturer's collection hole (symmetrical) | (16) Cowl clip mounting hole (symmetrical) | (22) Fender mounting hole (symmetrical), front side |
| (9) Manufacturer's collection hole (symmetrical) | (17) Hood hinge rear mounting hole (symmetrical) | |

Body Reference Points

Measuring point	Datum dimension mm (in)
(1)L — (15)	999 (39.32)
(2)L — (15)	1,062 (41.80)
(3)L — (15)	1,065 (41.95)
(3)R — (3)L	790 (31.10)
(4)R — (4)L	1,050 (41.34)
(4)R — (15)	1,084 (42.67)
(9)R — (9)L	1,490 (58.66)
(9)L — (15)	1,154 (45.45)
(10)L — (20)L	909 (35.79)
(10)L — (21)L	896 (35.26)

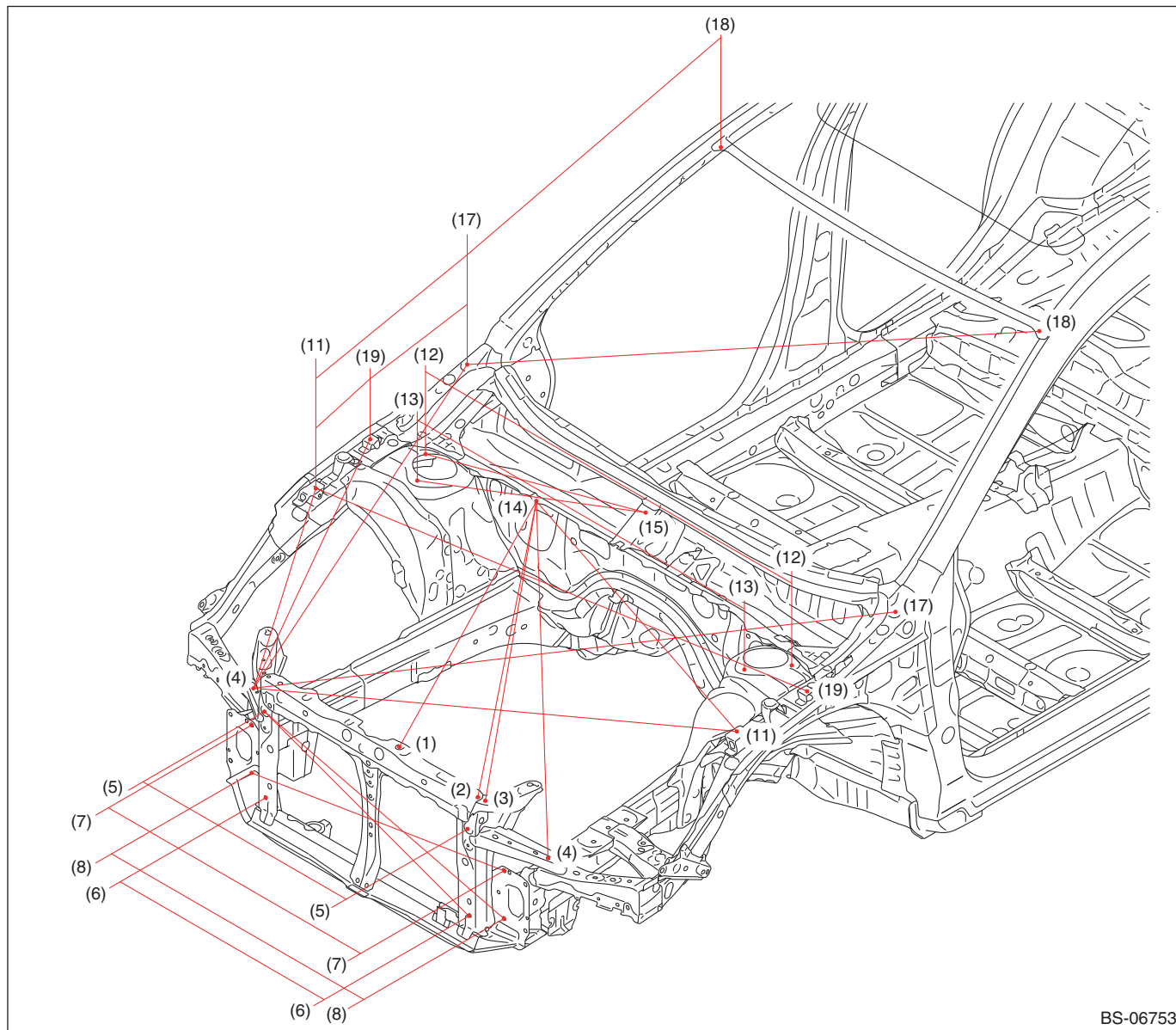
Measuring point	Datum dimension mm (in)
(10)L — (22)L	974 (38.33)
(11)R — (11)L	1,502 (59.13)
(11)R — (15)	868 (34.17)
(15) — (16)R	735 (28.95)
(15) — (17)R	775 (30.49)
(15) — (19)R	808 (31.81)
(16)R — (16)L	1,454 (57.24)
(17)R — (17)L	1,528 (60.16)
(19)R — (19)L	1,559 (61.38)

- Reference point (1) indicates a left-side part. Reference point (15) indicates a body center part. All other reference points indicate left-right symmetrical parts.
- The dimensions are the actual dimensions between the reference points.



Body Reference Points

3. FRONT 2



BS-06753

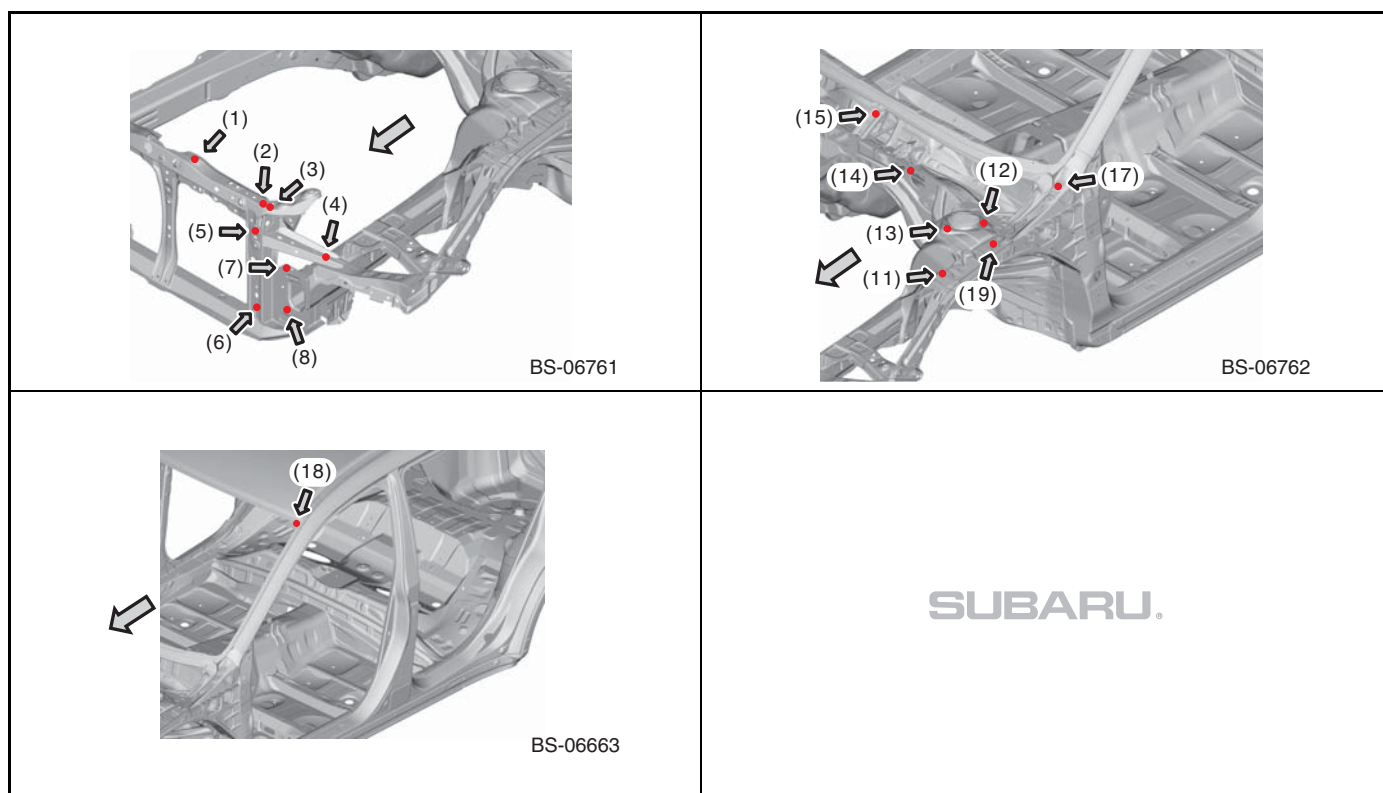
- | | | |
|--|---|--|
| (1) Bracket grill mounting hole (body left side) | (7) Beam front mounting hole (symmetrical), upper side | (15) Manufacturer's collection hole (body center) |
| (2) Radiator panel sub COMPL mounting hole (symmetrical) | (8) Beam front mounting hole (symmetrical), lower side | (17) Hood hinge rear mounting hole (symmetrical) |
| (3) Manufacturer's collection hole (symmetrical) | (11) Gauge hole (symmetrical) | (18) Front glass installation reference hole (symmetrical) |
| (4) Manufacturer's collection hole (symmetrical) | (12) Front suspension mounting hole (symmetrical), rear outside | (19) Fender front mounting hole (symmetrical) |
| (5) Headlight mounting hole (symmetrical) | (13) Front suspension mounting hole (symmetrical), front | |
| (6) Manufacturer's collection hole (symmetrical) | (14) Cowl clip mounting hole (symmetrical) | |

Body Reference Points

Measuring point	Datum dimension mm (in)
(1)L — (14)R	896 (35.26)
(2)L — (14)R	1,093 (43.02)
(3)L — (14)R	1,102 (43.40)
(4)L — (14)R	1,154 (45.44)
(4)R — (11)R	575 (22.62)
(4)R — (11)L	1,381 (54.37)
(4)R — (17)R	1,097 (43.18)
(4)R — (17)L	1,675 (65.96)
(4)R — (19)R	780 (30.71)
(5)R — (5)L	725 (28.54)
(5)R — (7)L	820 (32.30)
(5)R — (8)L	852 (33.55)
(6)R — (6)L	728 (28.66)
(6)L — (7)R	831 (32.72)

Measuring point	Datum dimension mm (in)
(7)R — (7)L	900 (35.43)
(8)R — (8)L	900 (35.43)
(11)L — (14)R	1,079 (42.48)
(11)R — (17)R	562 (22.13)
(11)R — (19)R	226 (8.90)
(11)R — (19)L	1,547 (60.90)
(12)R — (12)L	1,307 (51.44)
(12)R — (15)	671 (26.43)
(13)R — (13)L	1,167 (45.95)
(13)R — (15)	633 (24.91)
(17)R — (18)L	1,565 (61.62)
(17)R — (18)R	844 (33.24)
(17)R — (19)R	339 (13.34)

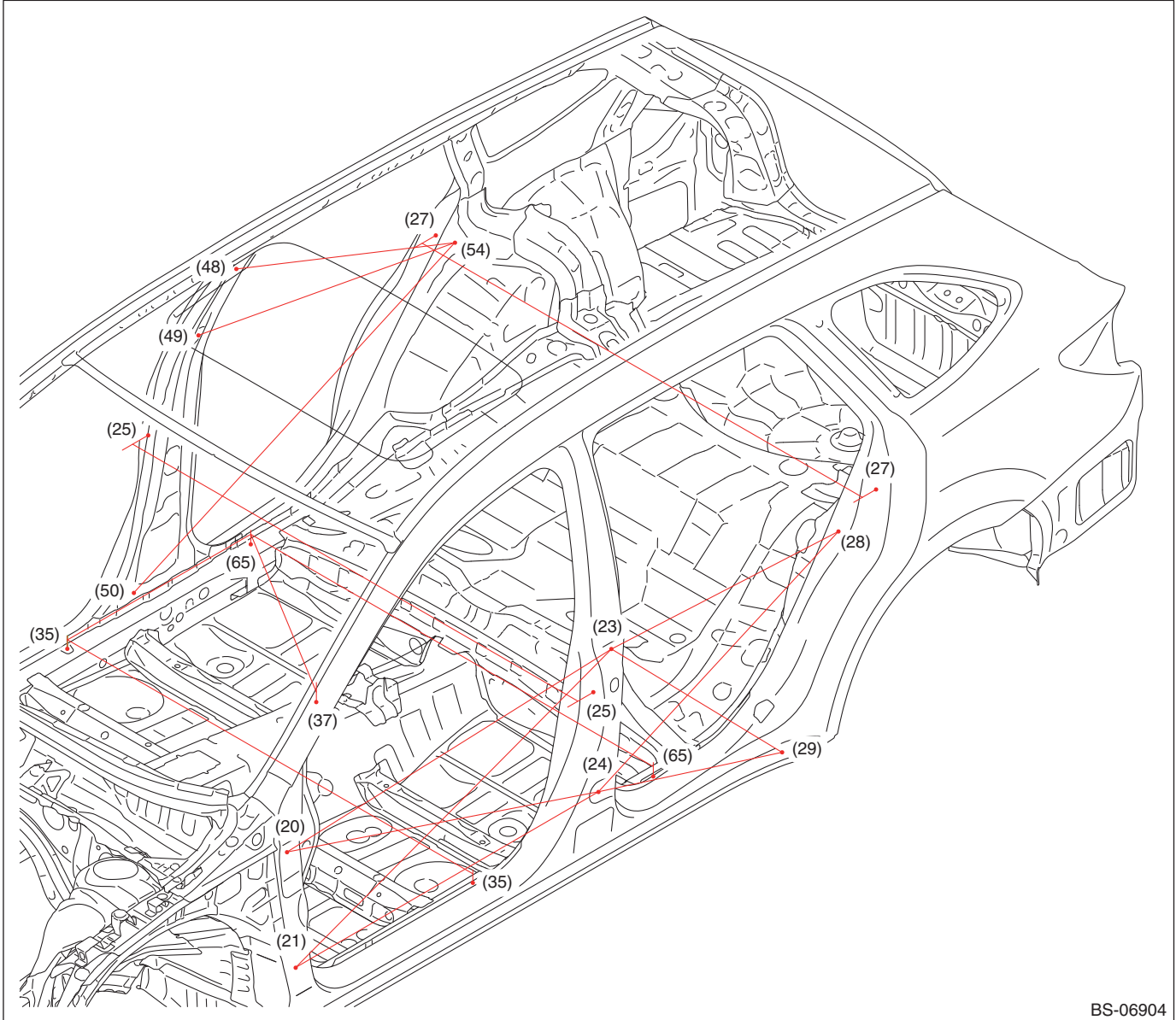
- Reference point (1) indicates a left-side part. Reference point (15) indicates a body center part. All other reference points indicate left-right symmetrical parts.
- The dimensions are the actual dimensions between the reference points.



Body Reference Points

4. INSIDE 1

- Common for OUTBACK and SEDAN



BS-06904

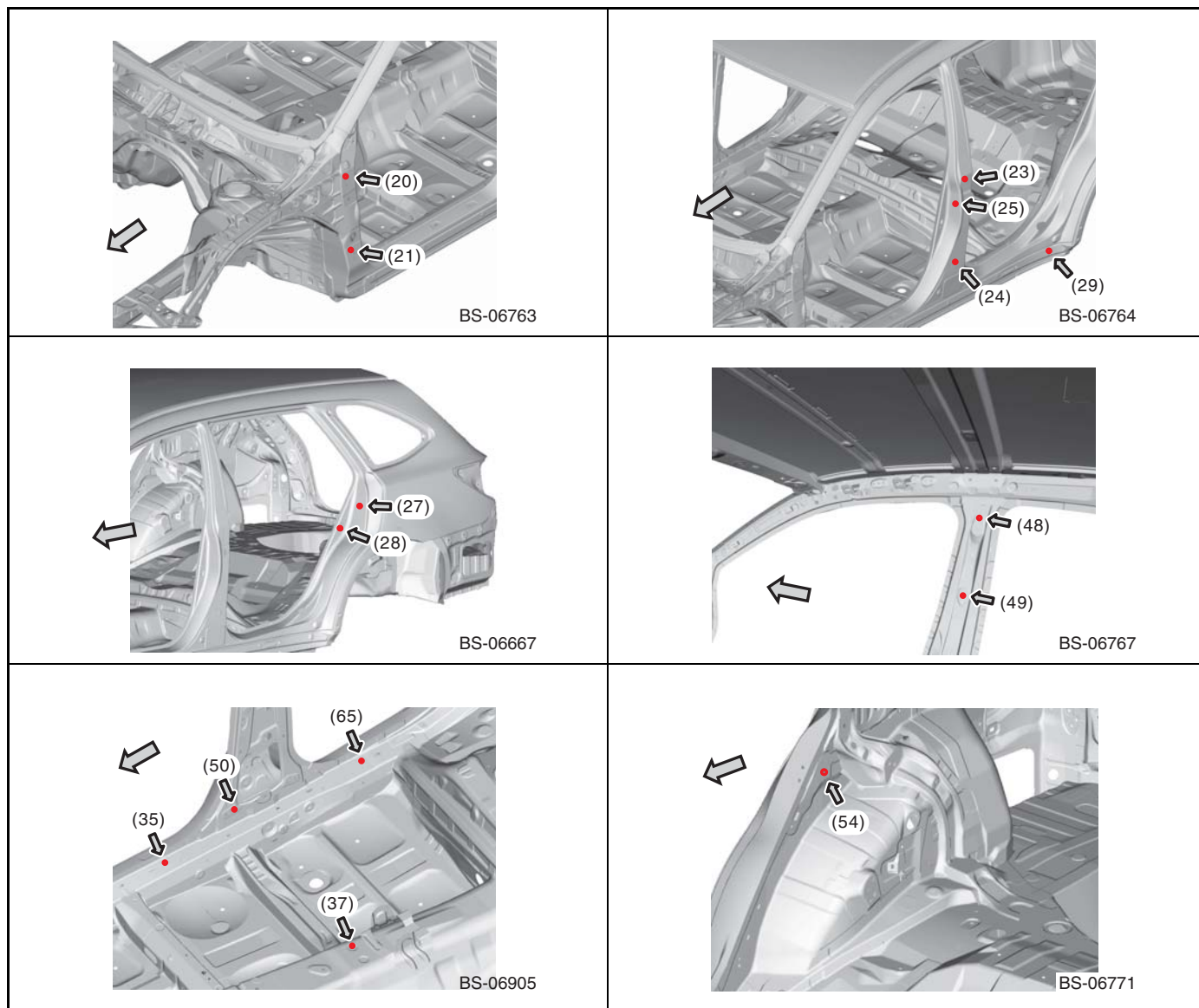
- | | | |
|---|--|--|
| (20) Front door hinge upper mounting hole (symmetrical), upper side | (27) Rear door striker mounting hole (symmetrical), upper side | (48) Trim mounting hole (symmetrical) |
| (21) Front door hinge lower mounting hole (symmetrical), upper side | (28) Rear door switch mounting hole (symmetrical) | (49) Adjust rail mounting hole (symmetrical) |
| (23) Rear door hinge upper mounting hole (symmetrical), upper side | (29) Side sill spoiler mounting hole (symmetrical) | (50) Trim mounting hole (symmetrical) |
| (24) Rear door hinge lower mounting hole (symmetrical), front | (35) Cover sill side mounting hole (symmetrical) | (54) Striker bracket mounting hole (symmetrical) |
| (25) Front door striker mounting hole (symmetrical), upper side | (37) Harness holding clip attachment hole (symmetrical) | (65) Cover sill side mounting hole (symmetrical) |

Body Reference Points

Measuring point	Datum dimension mm (in)
(20)L — (23)L	1,167 (45.94)
(20)L — (24)L	1,161 (45.71)
(21)L — (23)L	1,218 (47.94)
(21)L — (24)L	1,085 (42.71)
(23)L — (28)L	883 (34.78)
(23)L — (29)L	844 (33.22)
(24)L — (28)L	988 (38.88)
(24)L — (29)L	680 (26.77)
(25)R — (25)L	1,598 (62.91)

Measuring point	Datum dimension mm (in)
(27)R — (27)L	1580 (62.20)
(35)R — (35)L	1,456 (57.32)
(48)R — (54)R	1,020 (40.18)
(49)R — (54)R	974 (38.36)
(50)R — (54)R	1,259 (49.55)
(35)R — (65)R	653 (25.71)
(37)R — (65)R	834 (32.83)
(65)R — (65)L	1,444 (56.85)

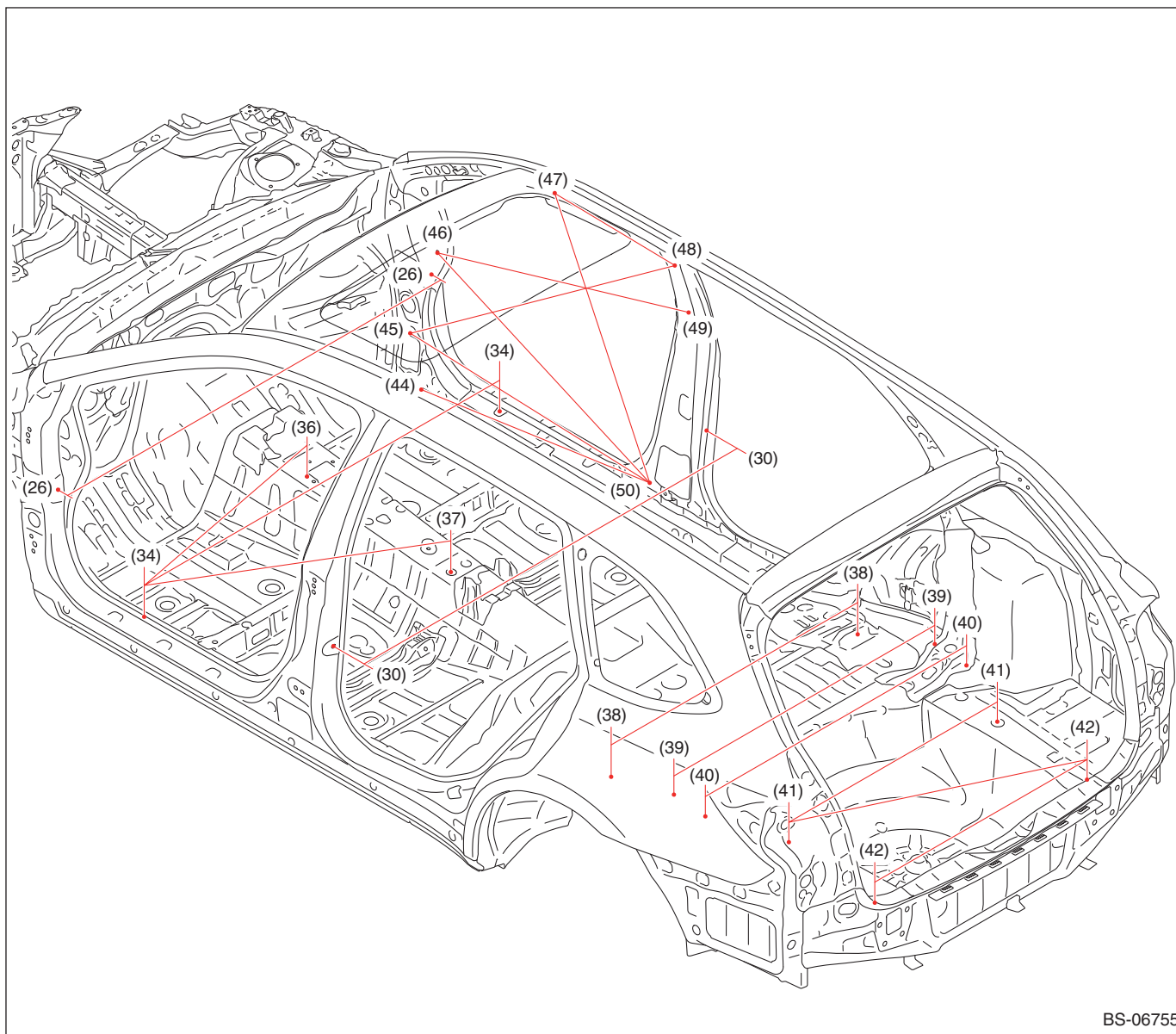
- All reference points are left-right symmetrical.
- The dimensions are the actual dimensions between the reference points.



Body Reference Points

5. INSIDE 2

- Common for OUTBACK and SEDAN



BS-06755

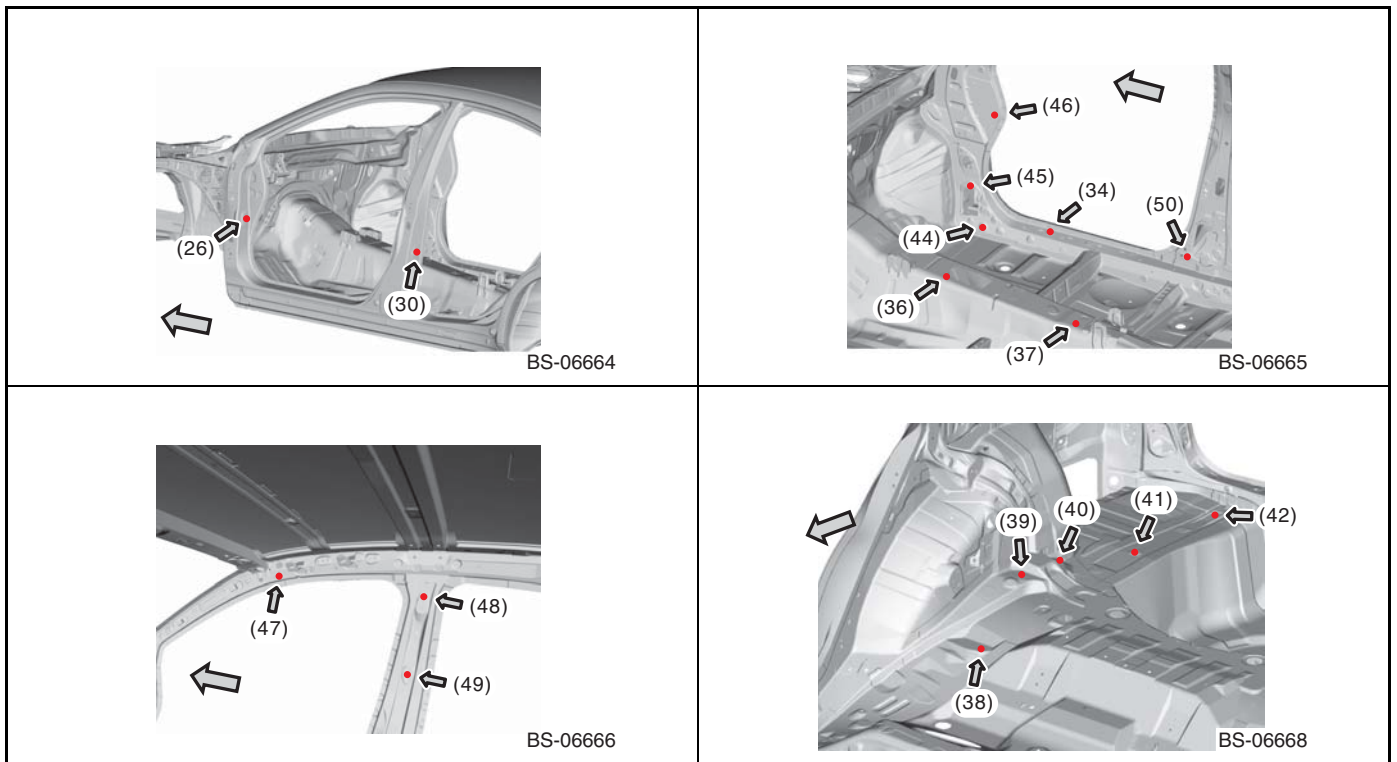
(26) Front door checker mounting hole (symmetrical)	(39) Rear suspension mounting hole (symmetrical), front	(46) Steering support beam mounting hole (symmetrical)
(30) Rear door checker mounting hole (symmetrical)	(40) Rear suspension mounting hole (symmetrical), rear	(47) Gauge hole mounting hole (symmetrical)
(34) Cover sill side mounting hole (symmetrical)	(41) Gauge hole (symmetrical)	(48) Trim mounting hole (symmetrical)
(36) Shift case mounting hole (symmetrical)	(42) Gauge hole (symmetrical)	(49) Adjust rail mounting hole (symmetrical)
(37) Harness holding clip mounting hole (symmetrical)	(44) Fuel pipe mounting hole (symmetrical)	(50) Trim mounting hole (symmetrical)
(38) Seat hinge mounting hole (symmetrical)	(45) Connector box mounting hole (symmetrical)	

Body Reference Points

Measuring point	Datum dimension mm (in)
(26)R — (26)L	1,529 (60.20)
(30)R — (30)L	1,529 (60.20)
(34)R — (34)L	1,457 (57.36)
(34)L — (36)L	693 (27.28)
(34)L — (37)L	898 (35.36)
(38)R — (38)L	1,010 (39.76)
(39)R — (39)L	1,069 (42.07)
(40)R — (40)L	1,070 (42.13)
(41)R — (41)L	854 (33.62)

Measuring point	Datum dimension mm (in)
(41)L — (42)R	935 (36.79)
(42)R — (42)L	870 (34.25)
(44)R — (50)R	889 (34.99)
(45)R — (48)R	1,487 (58.54)
(45)R — (50)R	956 (37.62)
(46)R — (49)R	1,112 (43.78)
(46)R — (50)R	947 (37.27)
(47)R — (48)R	478 (18.81)
(47)R — (50)R	1,021 (40.21)

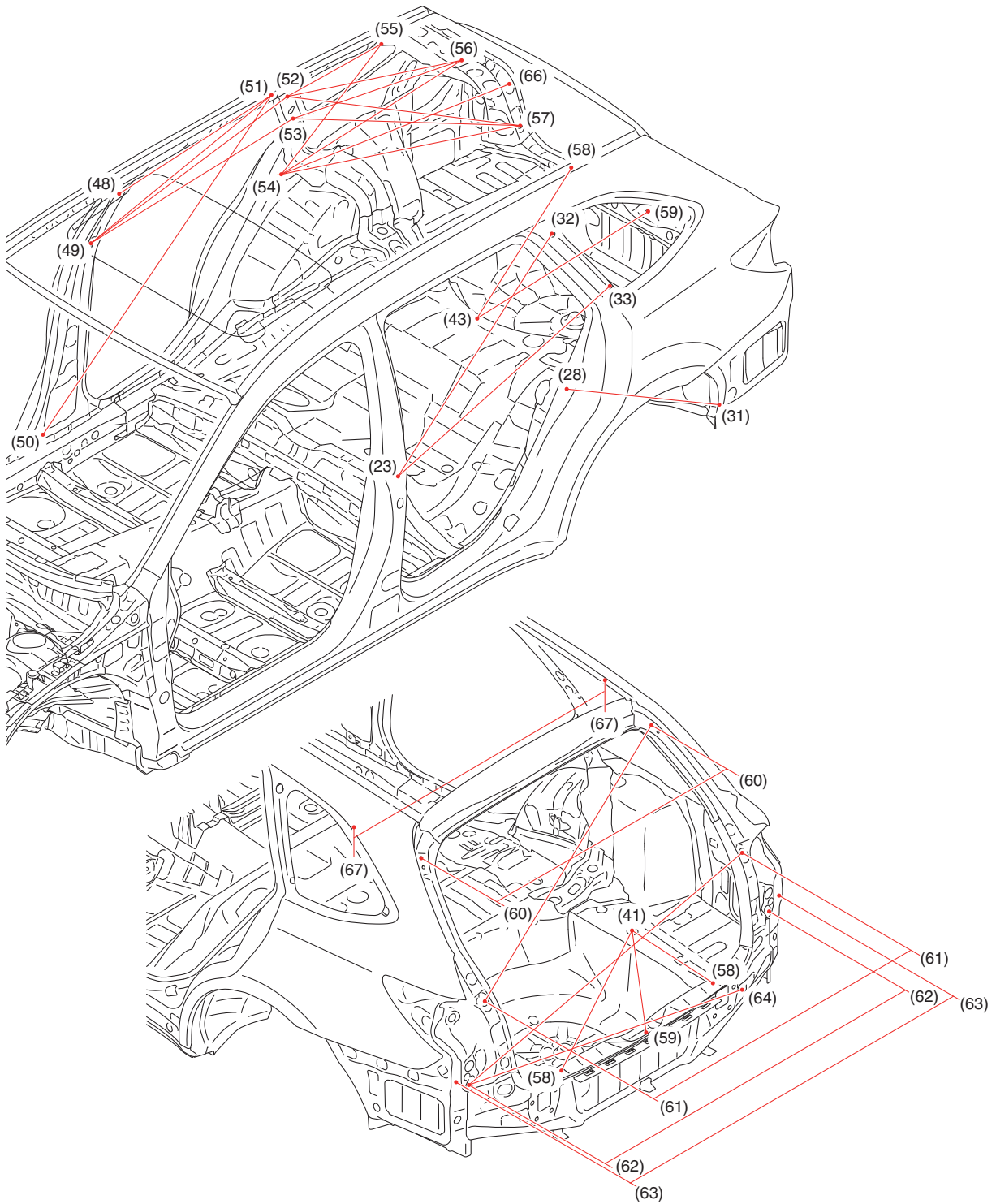
- All reference points are left-right symmetrical.
- The dimensions are the actual dimensions between the reference points.



Body Reference Points

6. INSIDE & REAR 1

- Special for OUTBACK



BS-06899

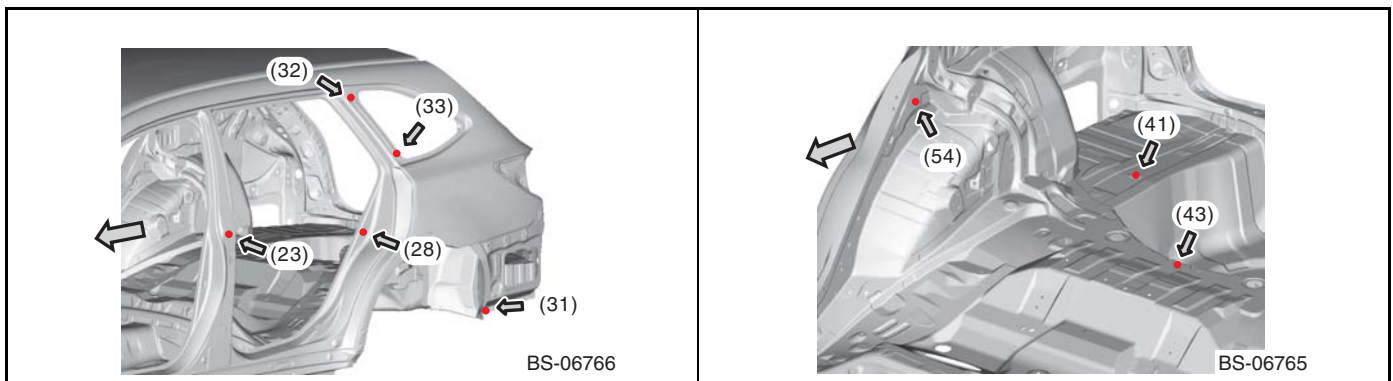
Body Reference Points

(23) Rear door hinge upper mounting hole (symmetrical), upper side	(50) Trim mounting hole (symmetrical)	(59) Striker mounting hole (symmetrical)
(28) Rear door switch mounting hole (symmetrical)	(51) Sunroof drain hose mounting hole (symmetrical)	(60) Rear gate stay mounting hole (symmetrical), upper side
(31) Mudguard mounting hole (symmetrical)	(52) Trim mounting hole (symmetrical)	(61) Rear combination light mounting hole (symmetrical), upper side
(32) Rear quarter glass mounting hole (symmetrical), front upper side	(53) Trim mounting hole (symmetrical)	(62) Radar bracket mounting hole (symmetrical)
(33) Rear quarter glass mounting hole (symmetrical), front lower side	(54) Striker bracket mounting hole (symmetrical)	(63) Gauge hole (symmetrical)
(41) Gauge hole (symmetrical)	(55) Gauge hole (symmetrical)	(64) Gauge hole (symmetrical)
(43) Smart antenna mounting hole (body center)	(56) Gauge hole (symmetrical)	(66) Folding lever bracket mounting hole (symmetrical)
(48) Trim mounting hole (symmetrical)	(57) Manufacturer's collection hole (symmetrical)	(67) Trim mounting hole (symmetrical)
(49) Adjust rail mounting hole (symmetrical)	(58) Edge floor mounting hole (symmetrical)	

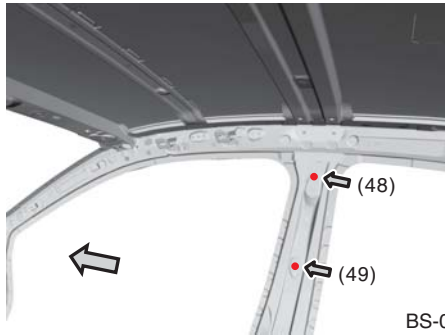
Measuring point	Datum dimension mm (in)
(23)L — (32)L	1,048 (41.24)
(23)L — (33)L	1,115 (43.88)
(28)L — (31)L	868 (34.19)
(43)R — (58)R	902 (35.52)
(43)R — (59)R	846 (33.30)
(48)R — (51)R	679 (26.75)
(49)R — (51)R	804 (31.66)
(49)R — (52)R	889 (34.99)
(49)R — (53)R	967 (38.07)
(50)R — (51)R	1,413 (55.63)
(52)R — (55)R	406 (15.97)
(52)R — (56)R	899 (35.39)
(52)R — (57)R	1,270 (50.02)
(53)R — (56)R	749 (29.48)
(53)R — (57)R	1,086 (42.75)

Measuring point	Datum dimension mm (in)
(54)R — (55)R	601 (23.66)
(54)R — (56)R	779 (30.68)
(54)R — (57)R	1,026 (40.40)
(41)R — (58)R	458 (18.01)
(41)R — (58)L	914 (35.97)
(41)R — (59)R	624 (24.55)
(60)R — (60)L	1,110 (43.70)
(60)R — (61)L	1,291 (50.84)
(61)R — (61)L	1,243 (48.92)
(61)R — (62)L	1,376 (54.18)
(62)R — (62)L	1,450 (57.09)
(62)L — (64)R	1,270 (49.99)
(63)R — (63)L	1,562 (61.50)
(54)R — (66)R	956 (37.64)
(67)R — (67)L	1,212 (47.72)

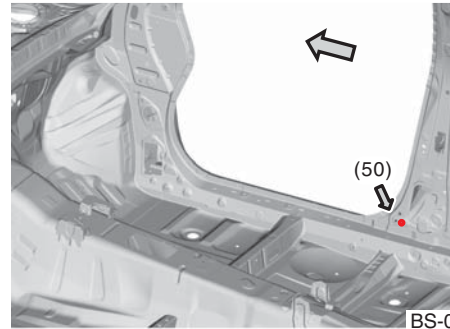
- The reference point (43) is at the body center, while the other reference points are left-right symmetrical.
- The dimensions are the actual dimensions between the reference points.



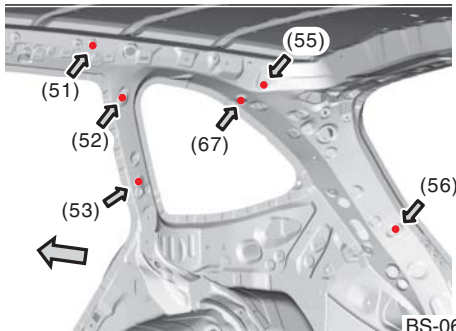
Body Reference Points



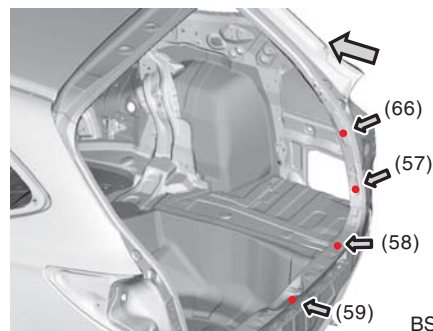
BS-06767



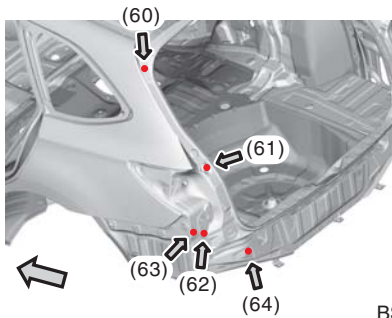
BS-06768



BS-06900



BS-06901



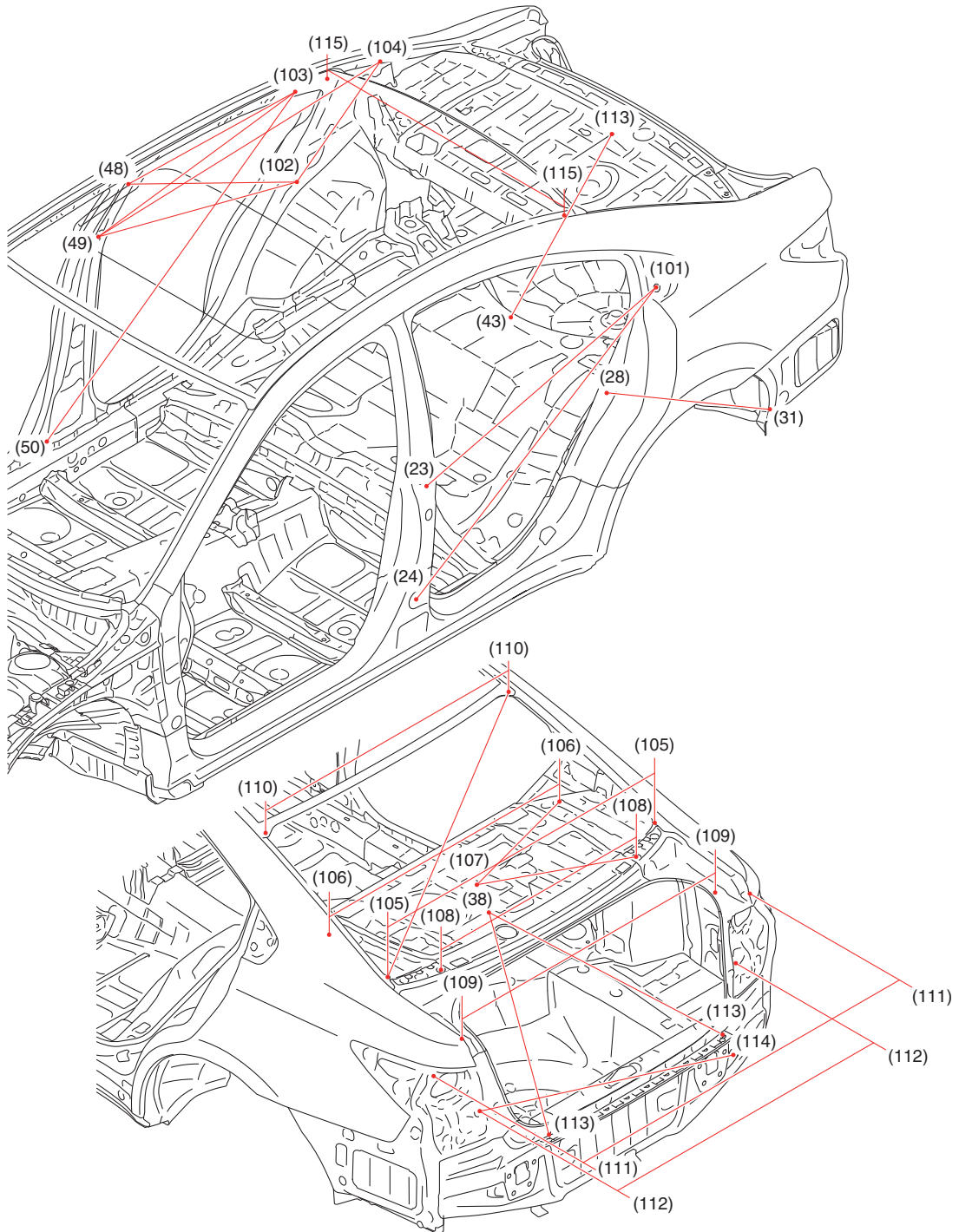
BS-06669

SUBARU.

Body Reference Points

7. INSIDE & REAR 2

- Special for SEDAN



BS-06902

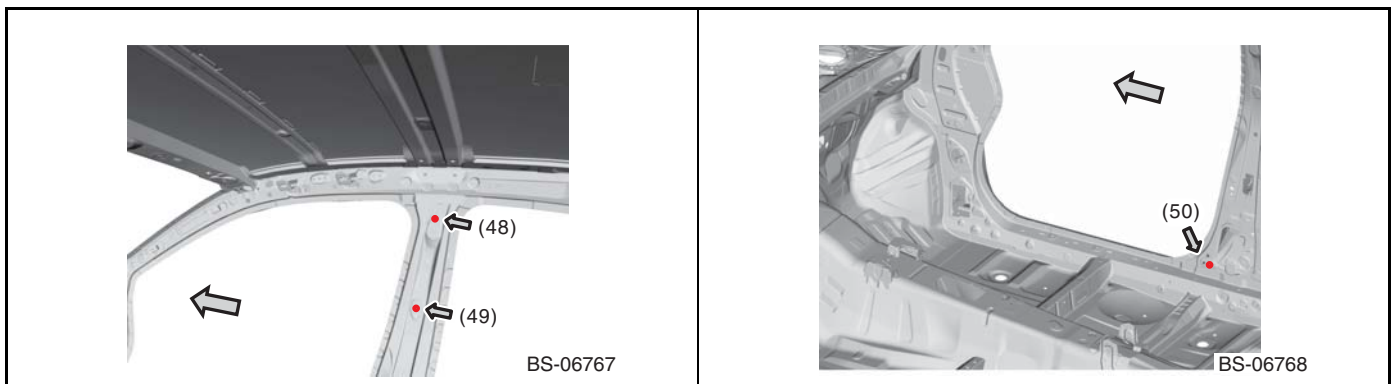
Body Reference Points

(23) Rear door hinge upper mounting hole (symmetrical), upper side	(50) Trim mounting hole (symmetrical)	(108) Gauge hole (symmetrical)
(24) Rear door hinge lower mounting hole (symmetrical), front	(101) Cover C pillar mounting hole (symmetrical)	(109) Trunk hinge mounting hole (symmetrical)
(28) Rear door switch mounting hole (symmetrical)	(102) Seat bracket relief hole (symmetrical)	(110) Rear glass installation reference hole (symmetrical)
(31) Mudguard mounting hole (symmetrical)	(103) Gauge hole (symmetrical)	(111) Rear combination light mounting hole (symmetrical)
(38) Seat hinge mounting hole (symmetrical)	(104) Trim mounting hole (symmetrical)	(112) Bracket corner rear mounting hole (symmetrical)
(43) Smart antenna mounting hole (body center)	(105) Trunk mounting hole (symmetrical)	(113) Manufacturer's collection hole (symmetrical)
(48) Trim mounting hole (symmetrical)	(106) Rear shelf mounting hole (symmetrical)	(114) Gauge hole (symmetrical)
(49) Adjust rail mounting hole (symmetrical)	(107) Child anchor mounting hole (body center)	(115) Harness mounting hole (symmetrical)

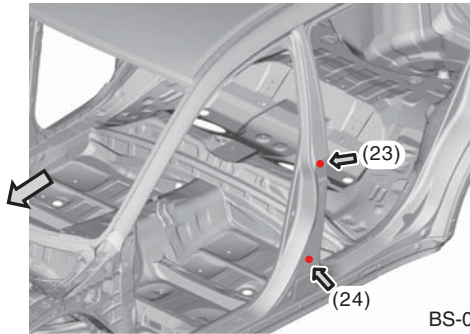
Measuring point	Datum dimension mm (in)
(23)L — (101)L	1,120 (44.09)
(24)L — (101)L	1,311 (51.62)
(28)L — (31)L	868 (34.19)
(38)R — (113)R	1,170(46.06)
(38)R — (113)L	1,469(57.83)
(43)R — (113)R	964 (37.95)
(48)R — (102)R	1,042 (41.01)
(48)R — (103)R	762 (29.98)
(49)R — (102)R	979 (38.54)
(49)R — (103)R	833 (32.80)
(49)R — (104)R	1,197 (47.11)
(50)R — (103)R	1,371 (53.96)
(102)R — (104)R	497(19.58)

Measuring point	Datum dimension mm (in)
(105)R — (105)L	1,205 (47.44)
(105)L — (110)R	1,319 (51.93)
(106)R — (106)L	1,040 (40.94)
(106)R — (107)	540 (21.27)
(107) — (108)R	523 (20.59)
(108)R — (108)L	882 (34.72)
(109)R — (109)L	1,144 (45.04)
(110)R — (110)L	1,093 (43.02)
(111)R — (111)L	1,428 (56.22)
(112)R — (112)L	1,157 (45.55)
(112)L — (114)R	1,151 (45.30)
(115)R — (115)L	1,071 (42.17)

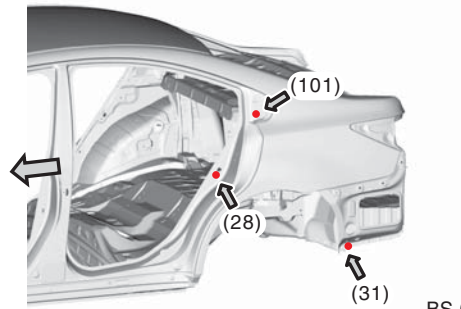
- The reference points (43) and (107) are at the body center, while the other reference points are left-right symmetrical.
- The dimensions are the actual dimensions between the reference points.



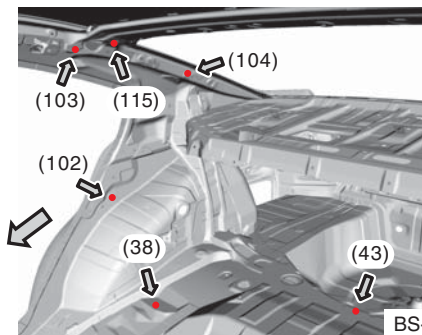
Body Reference Points



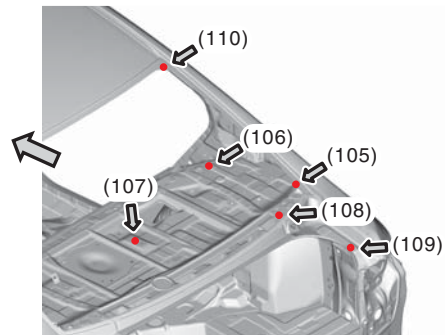
BS-06769



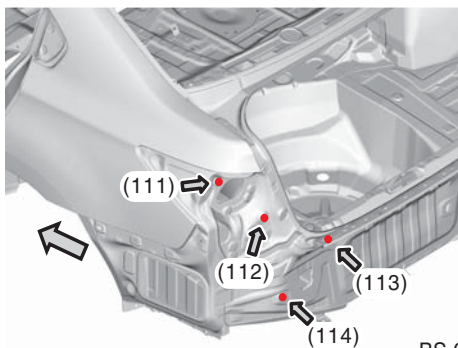
BS-06672



BS-06903



BS-06674

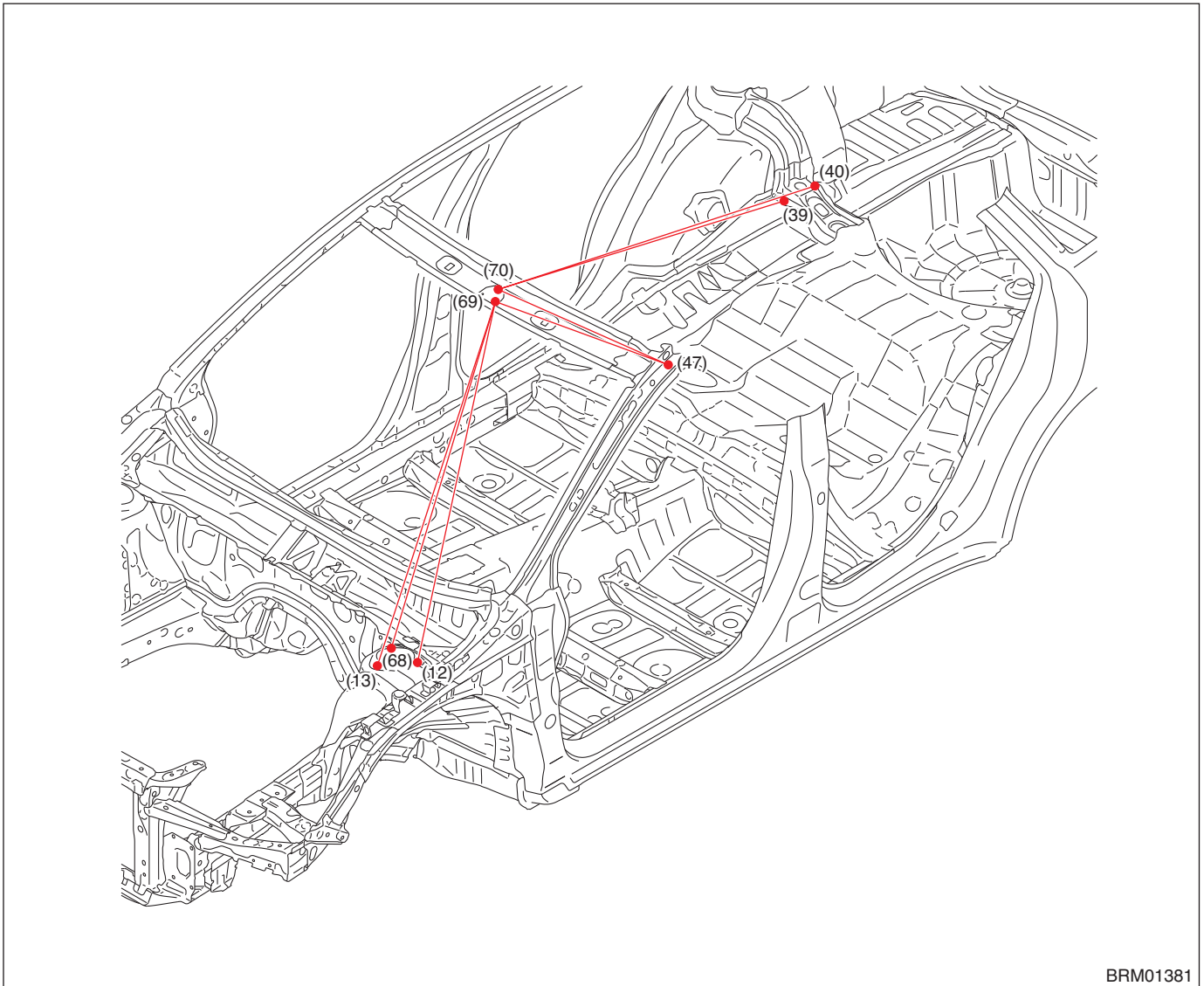


BS-06675

SUBARU.

Body Reference Points

8. FRONT ROOF RAIL (CAMERA PLATE)



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

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

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

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

(47) Gauge hole mounting hole (symmetrical)

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

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

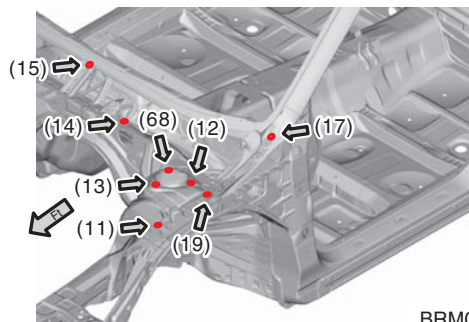
(68) Front suspension mounting hole (symmetrical), rear inside

Measuring point	Datum dimension mm (in)
(12)L — (69)L	1,255 (49.41)
(13)L — (69)L	1,299 (51.14)
(39)R — (70)	1,990 (78.35)
(40)R — (70)	2,108 (82.99)

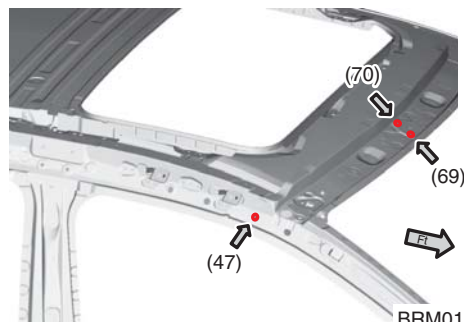
Measuring point	Datum dimension mm (in)
(47)L — (69)L	585 (23.03)
(47)L — (70)	602 (23.70)
(68)L — (69)L	1,197 (47.13)

- Reference point (70) indicates a body center part. All other reference points indicate left-right symmetrical parts.
- The dimensions are the actual dimensions between the reference points.

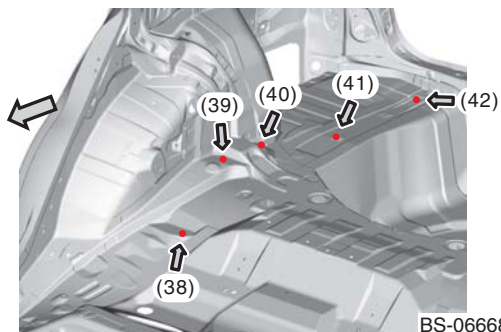
Body Reference Points



BRM01382



BRM01383



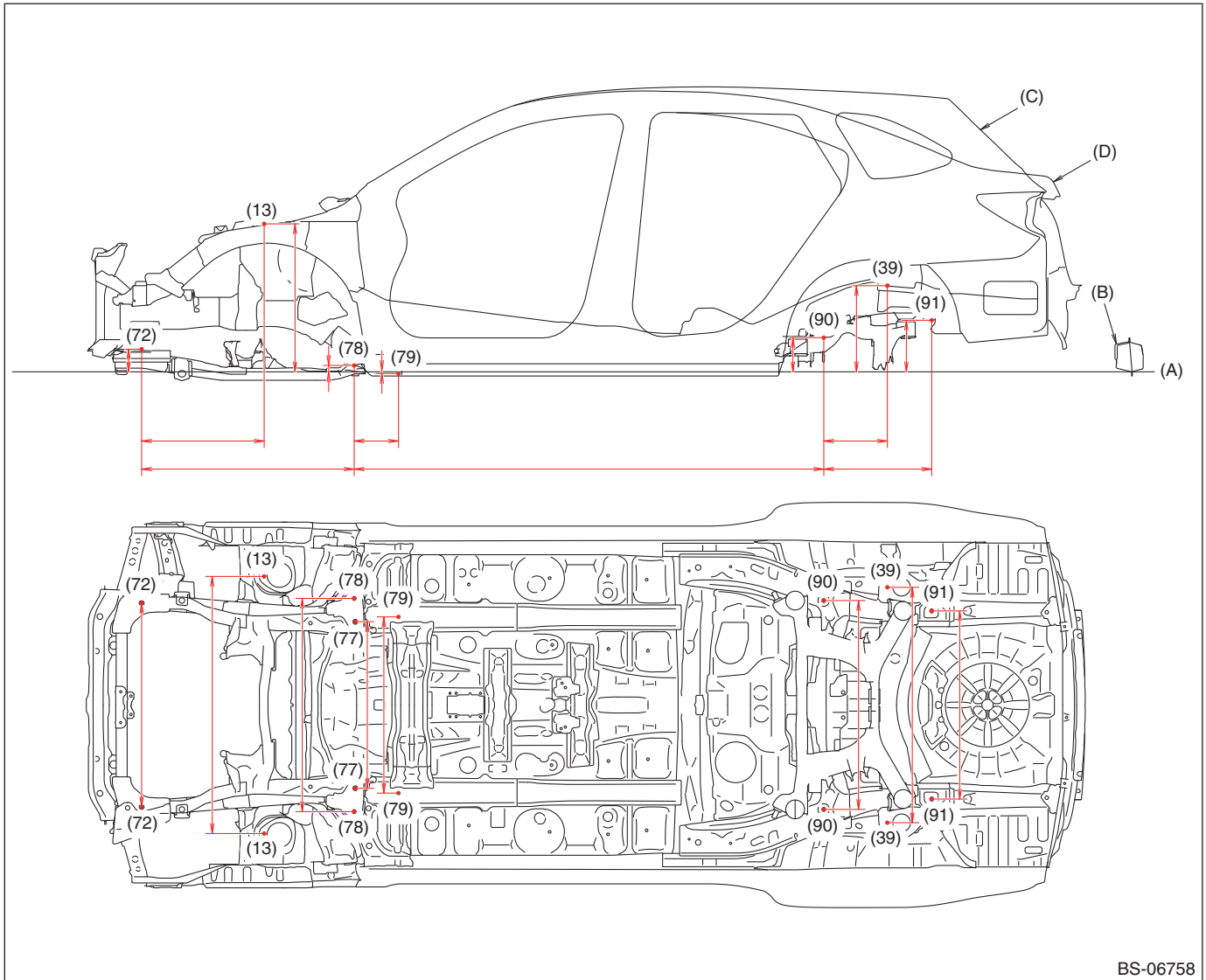
BS-06668

SUBARU.

7. Measurement for Combined Parts

A: DIMENSIONS

1. SUSPENSION MOUNT (CRADLE FRAME, SUSPENSION MOUNT)



BS-06758

- 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 reinforcement flange joint (bending angle point).

(A) Standard line
(B) Side sill reinforcement

(C) OUTBACK

(D) SEDAN

(13) Front suspension mounting hole (symmetrical), front
(39) Rear suspension mounting hole (symmetrical), front
(72) Cradleframe mounting hole (symmetrical), front

(77) Cradleframe mounting hole (symmetrical), rear inside
(78) Cradleframe mounting hole (symmetrical), rear outside
(79) Stiffener mounting hole (symmetrical)

(90) Rear suspension crossmember mounting hole (symmetrical), front
(91) Rear suspension crossmember mounting hole (symmetrical), rear

Measurement for Combined Parts

Measuring point	Datum dimension mm (in)
Datum line — (13)	672 (26.44)
Datum line — (39)	391 (15.39)
Datum line — (72)	103 (4.05)
Datum line — (78)	29 (1.14)
Datum line — (79)	-8 (-0.31)
Datum line — (90)	155 (6.10)
Datum line — (91)	234 (9.21)
(13)R — (72)R	556 (21.89)
(39)R — (90)R	288 (11.35)
(72)R — (78)R	965 (37.97)
(78)R — (79)R	201 (7.91)

Measuring point	Datum dimension mm (in)
(78)R — (90)R	2,131 (83.90)
(90)R — (91)R	490 (19.29)
(13)R — (13)L	1,167 (45.95)
(39)R — (39)L	1,069 (42.07)
(72)R — (72)L	925 (36.42)
(77)R — (77)L	756 (29.76)
(78)R — (78)L	968 (38.11)
(79)R — (79)L	800 (31.50)
(90)R — (90)L	948 (37.32)
(91)R — (91)L	854 (33.62)

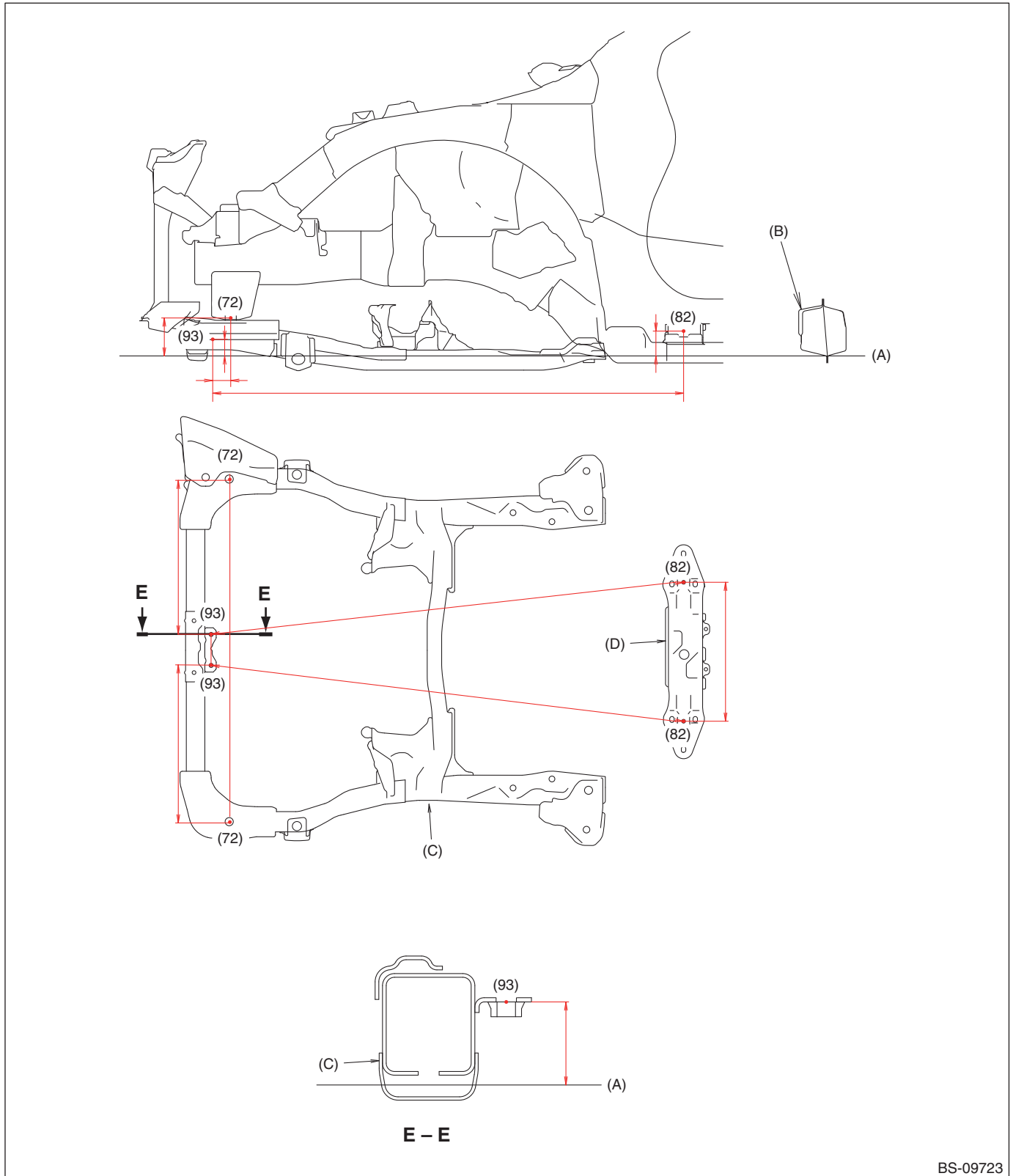
CAUTION:

- For the reference points (13), refer to the figure "FRONT 1, DIMENSIONS, Body Reference Points" on page 41.
- For the reference points (39), refer to the figure "INSIDE 2, DIMENSIONS, Body Reference Points" on page 47.
- Except the reference points (13) and (39), refer to the figure "LOWER SURFACE, DIMENSIONS, Body Reference Points" on page 38.

Measurement for Combined Parts

2. ENGINE MOUNTING

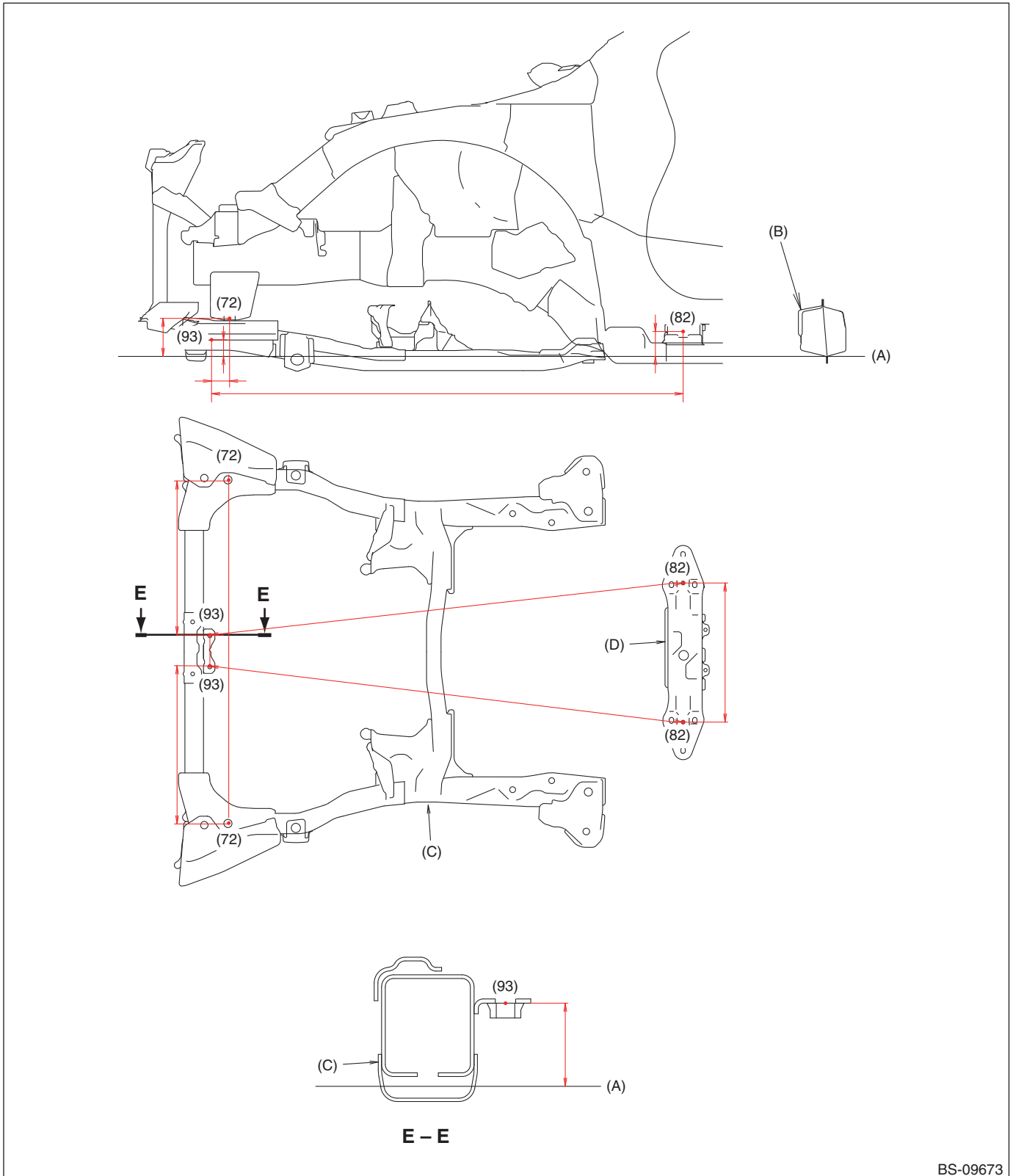
• — '17 MY



BS-09723

Measurement for Combined Parts

• '18 MY —



BS-09673

Measurement for Combined Parts

- Front-rear dimensions and left-right dimensions are projected dimensions.
- The height dimensions are the vertical distances from the gauge point on the assumed horizontal line through the side sill reinforcement flange joint (bending angle point).
- Diagonal dimensions are the actual dimensions between reference points.

(A) Standard line
(B) Side sill reinforcement

(C) Cradle frame

(D) Rear crossmember rear

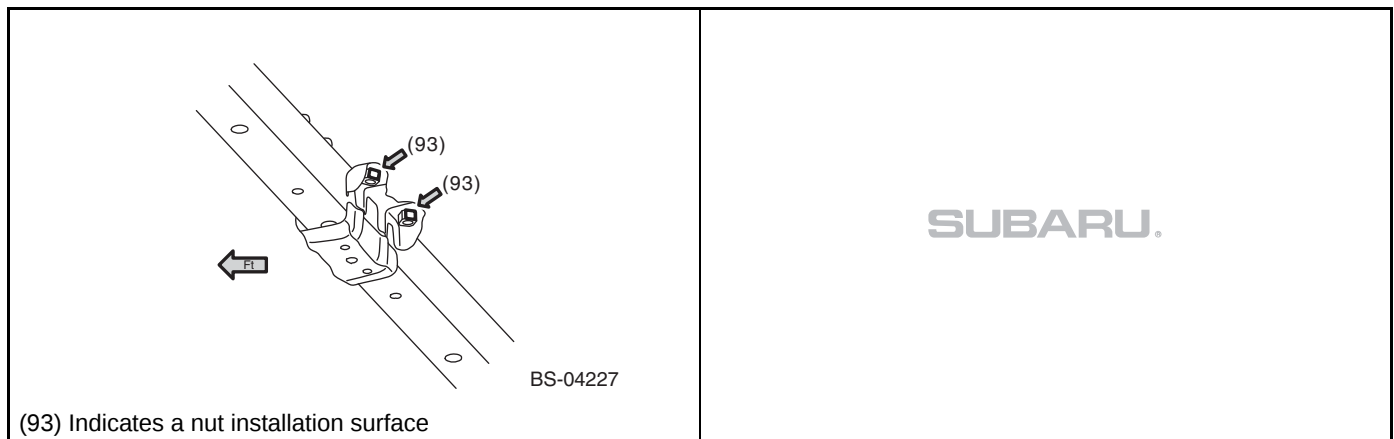
(72) Cradle frame mounting hole (symmetrical), front
(82) MT & CFT-CVT crossmember aR mounting hole, right side
(82) MT & CFT-CVT crossmember aL mounting hole, left side

(82) HT-CVT crossmember mounting bR hole, right side
(82) HT-CVT crossmember mounting bL hole, left side

(93) Front engine mounting bracket mounting hole, right side
(93) Front engine mounting bracket mounting hole, left side

Measuring point	Datum dimension mm (in)	Projected dimensions for reference mm (in)
Datum line — (72)	103 (4.05)	—
Datum line — (82)aR	67 (2.65)	—
Datum line — (82)aL	62 (2.43)	—
Datum line — (82)bR	67 (2.65)	—
Datum line — (82)bL	62 (2.43)	—
Datum line — (93)R	45 (1.77)	—
(72)R — (93)R	49 (1.92)	—
(82)aR — (93)R	1,275 (50.19)	—
(82)bR — (93)R	1,375 (54.12)	—

Measuring point	Datum dimension mm (in)	Projected dimensions for reference mm (in)
(72)R — (93)R	422 (16.61)	—
(72)L — (93)L	420 (16.54)	—
(82)aR — (82)aL	376 (14.80)	—
(82)bR — (82)bL	361 (14.21)	—
(82)aR — (93)R	1,284 (50.56)	1,284 (50.55)
(82)bR — (93)R	1,382 (54.41)	1,382 (54.40)
(82)aL — (93)L	1,294 (50.95)	1,282 (50.48)
(82)bL — (93)L	1,382 (54.40)	1,382 (54.39)



CAUTION:

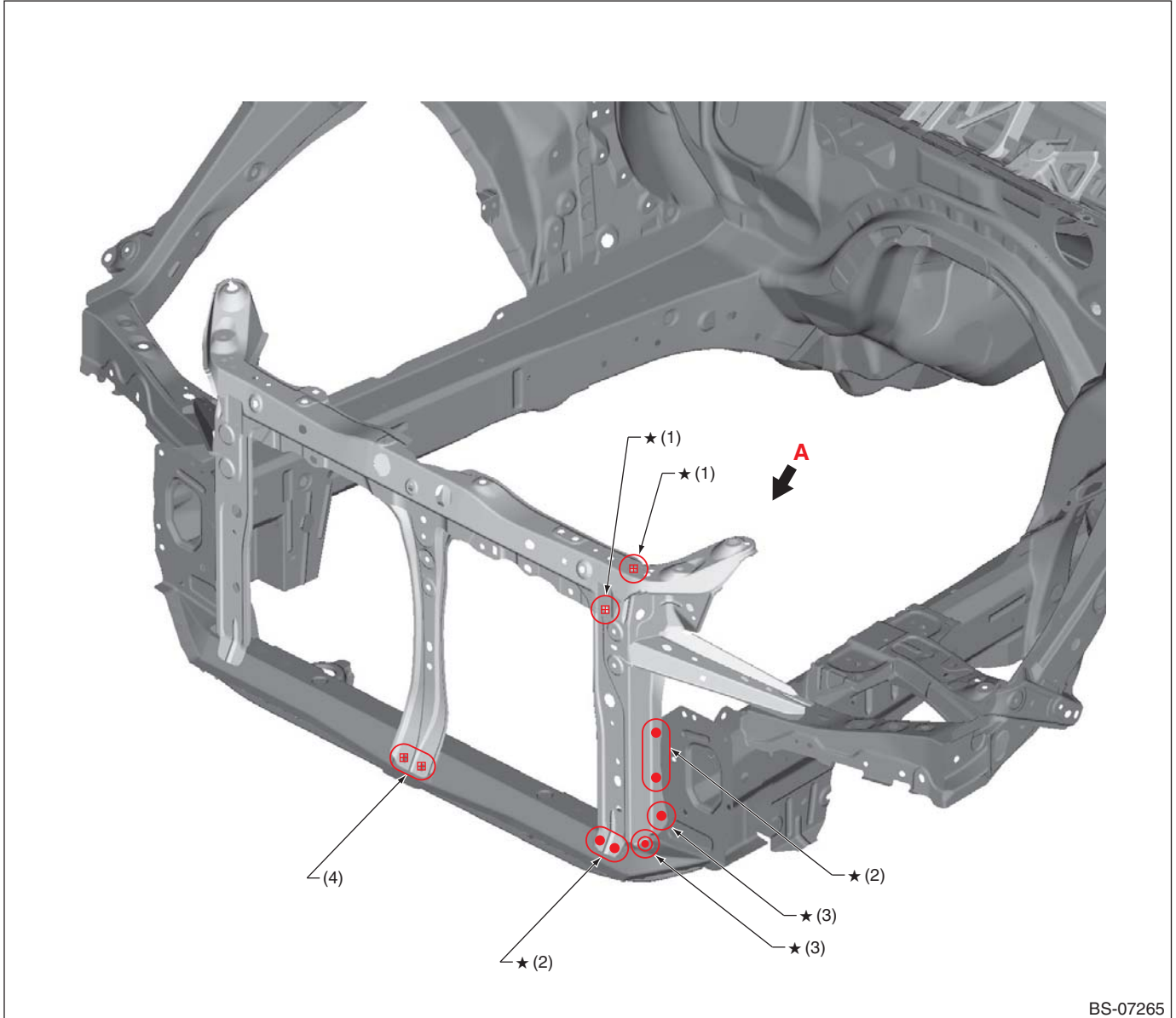
For the reference points (72) and (82), refer to the figure "LOWER SURFACE, DIMENSIONS, Body Reference Points" on page 38.

8. Panel Replacement

8-1. Radiator Panel (Total replacement)

A: REMOVAL

- Overall view



(1) 1 point (bolt)

(3) 1 point

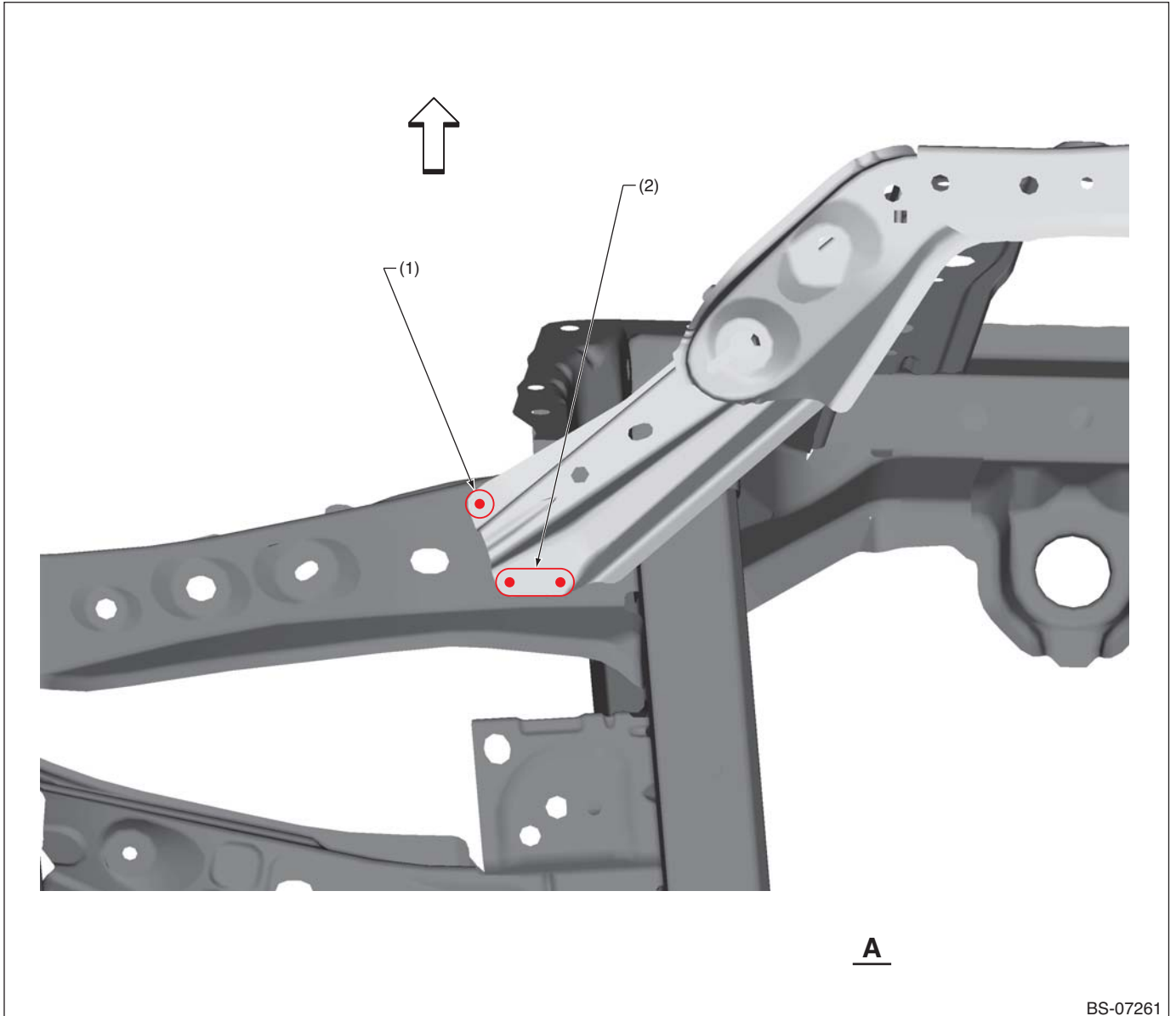
(4) 2 points (bolt)

(2) 2 points

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

Panel Replacement

- View A



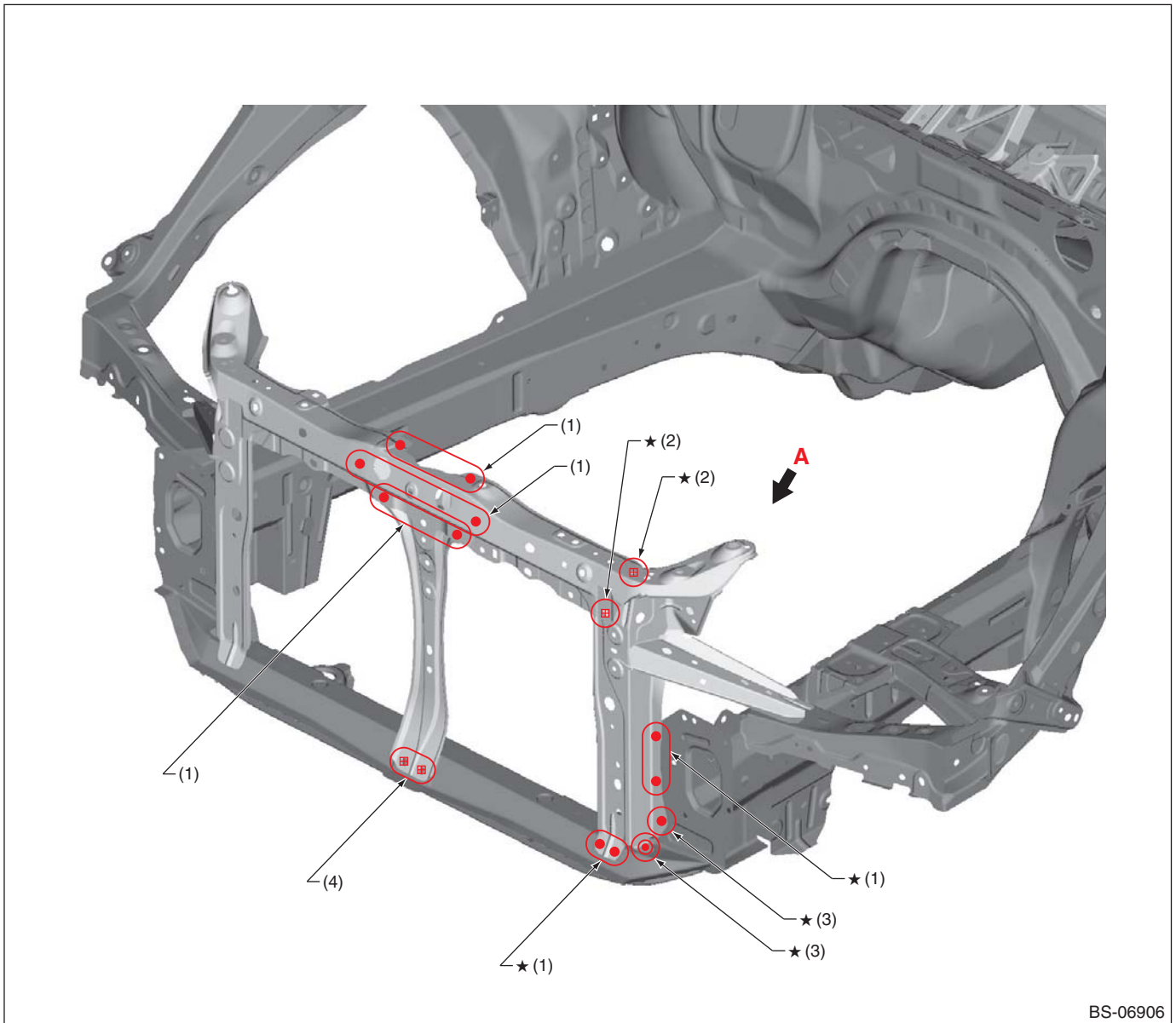
(1) 1 point

(2) 2 points

Panel Replacement

B: INSTALLATION

- Overall view



(1) 2 points

(2) 1 point (bolt)

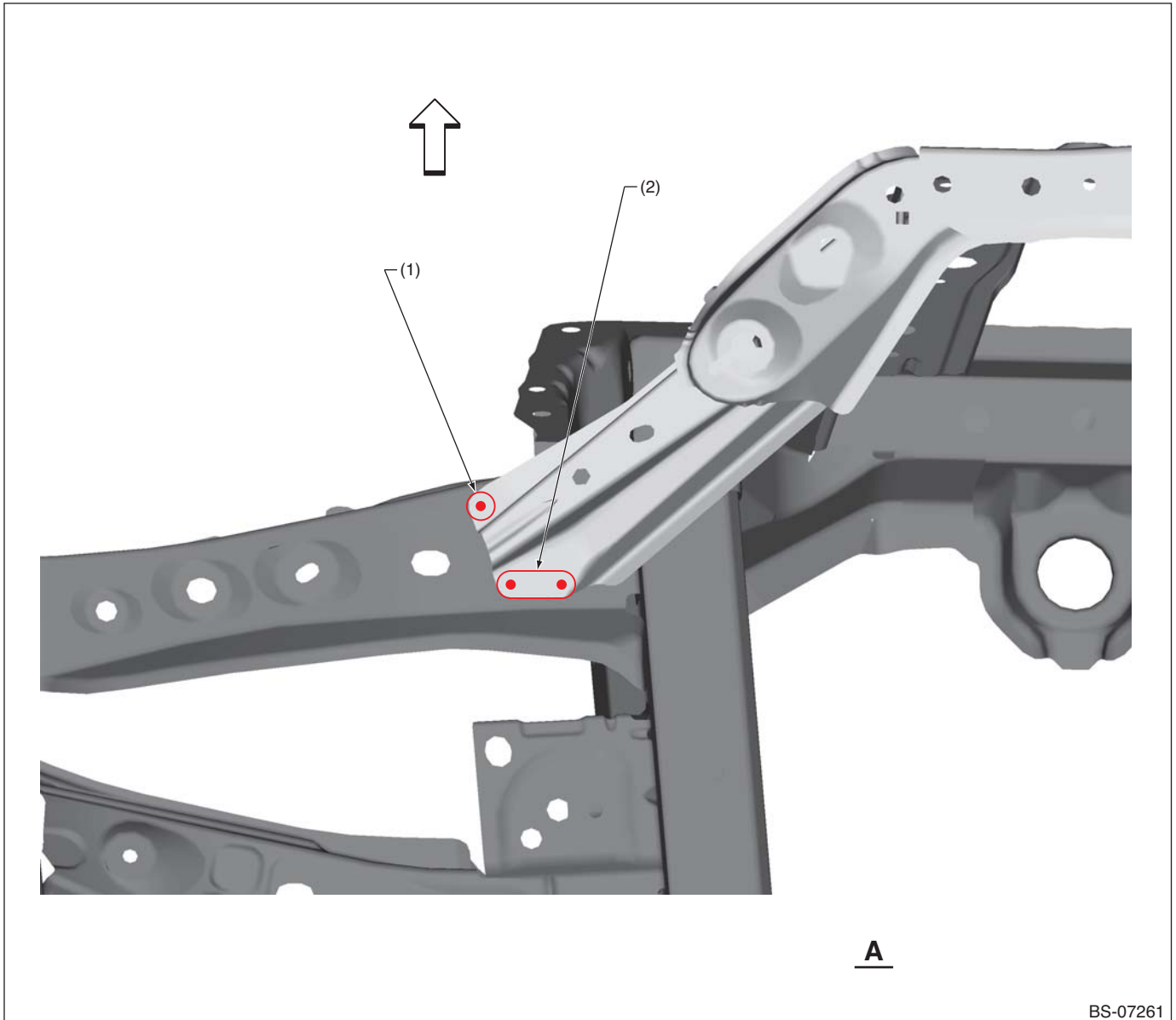
(3) 1 point

(4) 2 points (bolt)

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

Panel Replacement

- View A



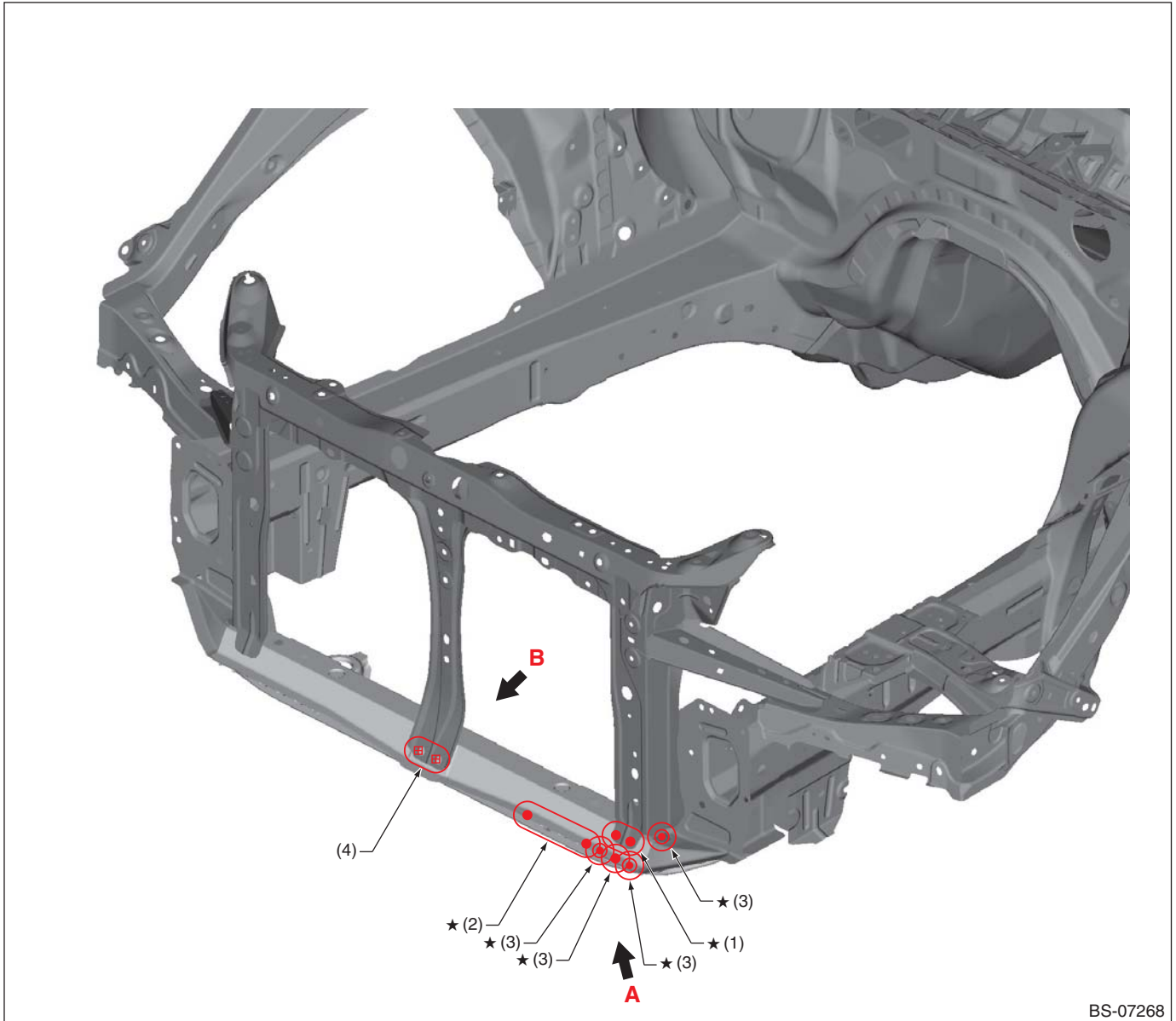
(1) 1 point

(2) 2 points

8-2. Radiator Core Support (Total replacement)

A: REMOVAL

- Overall view



BS-07268

- (1) 2 points
(2) 4 points

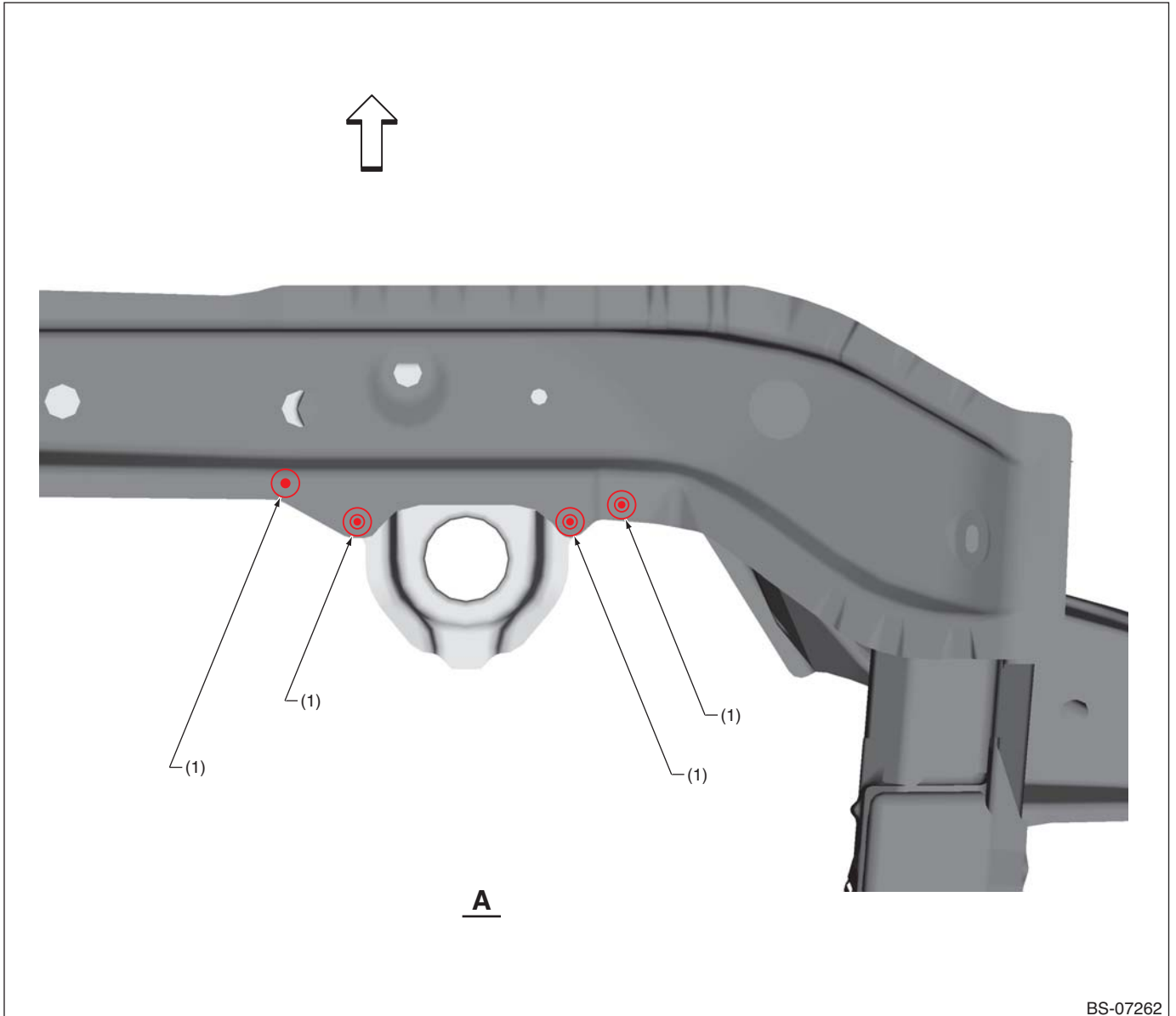
- (3) 1 point

- (4) 2 points (bolt)

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

Panel Replacement

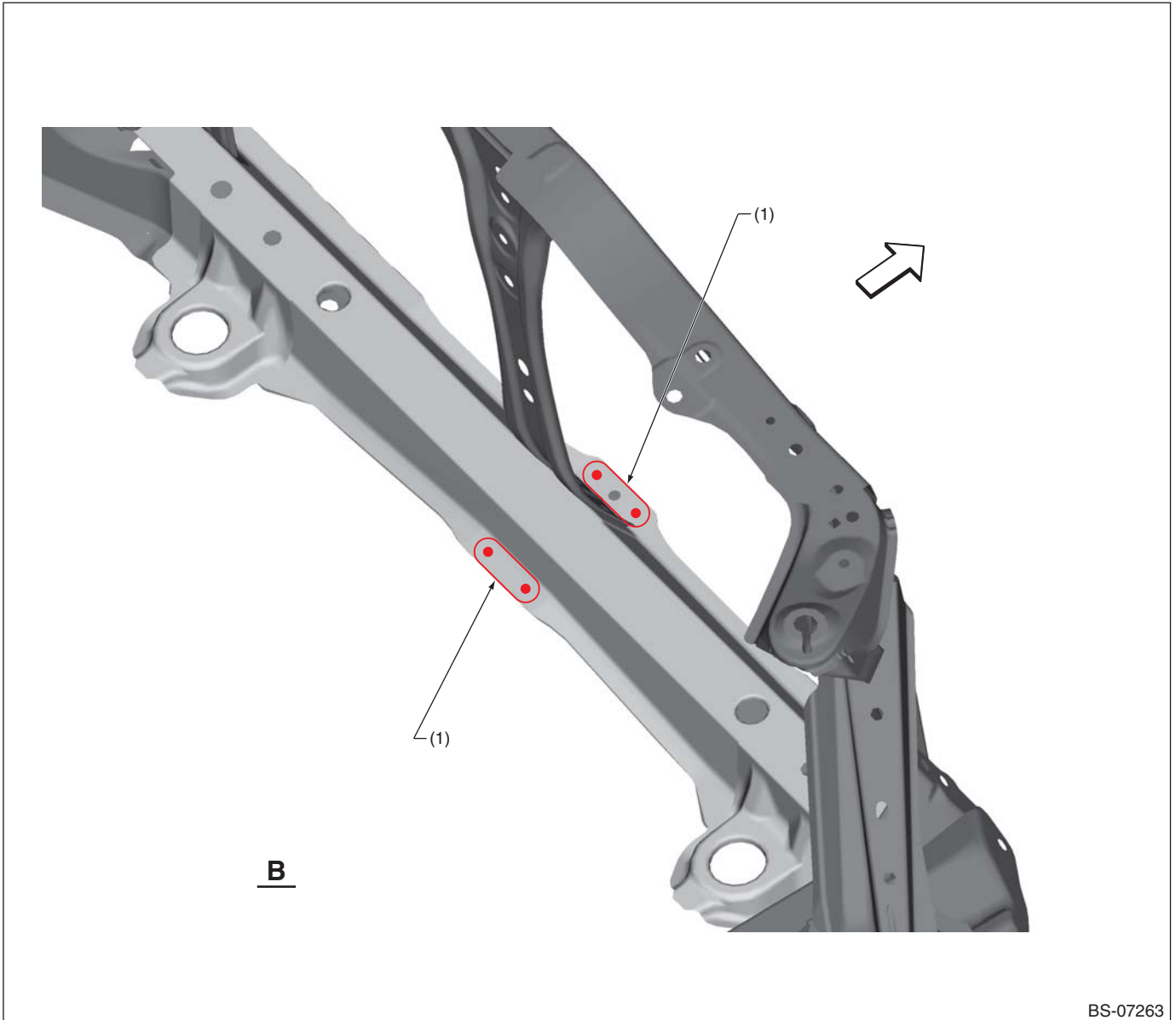
- View A



(1) 1 point

Panel Replacement

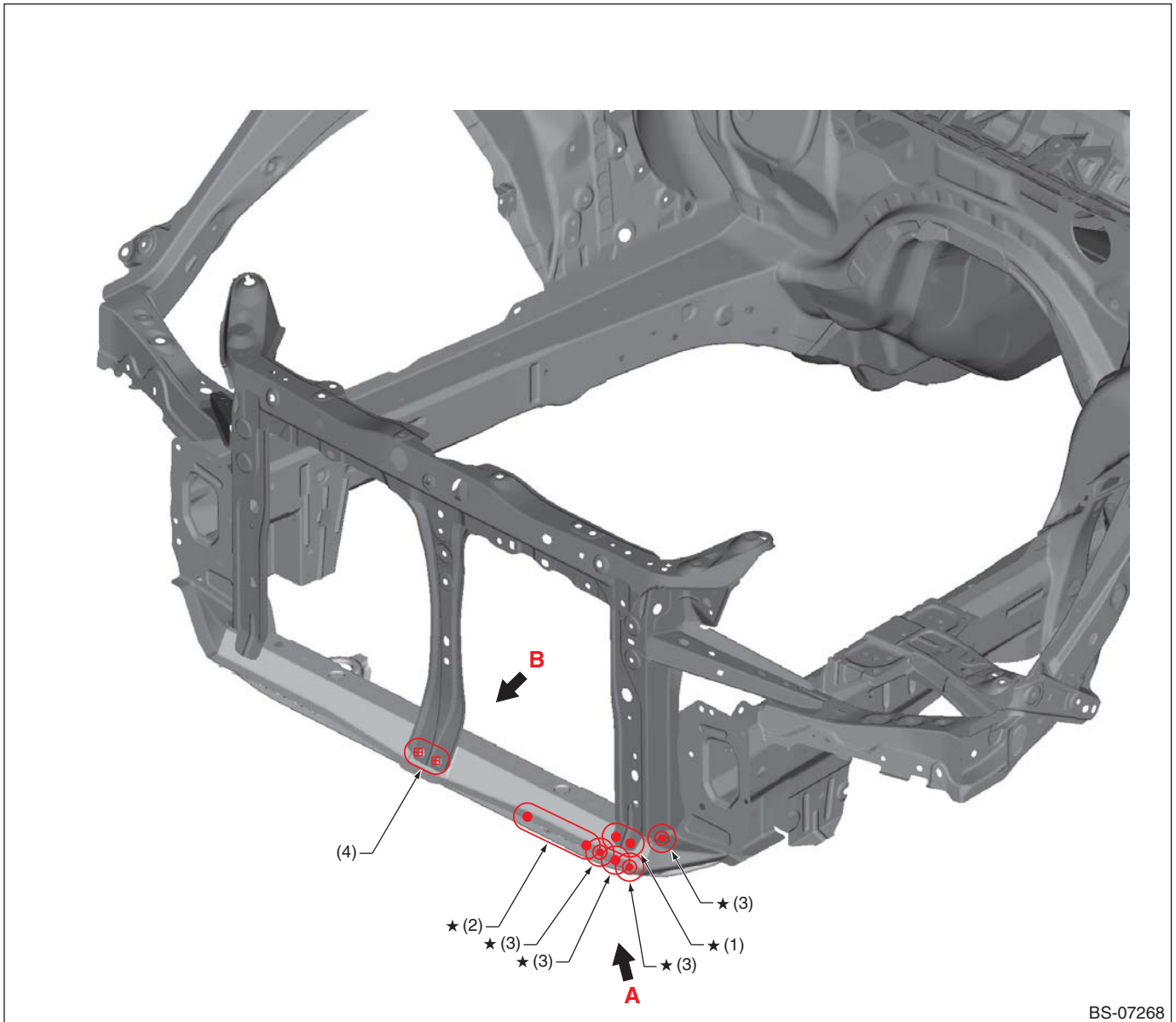
- View B



(1) 2 points

B: INSTALLATION

- Overall view



(1) 2 points

(3) 1 point

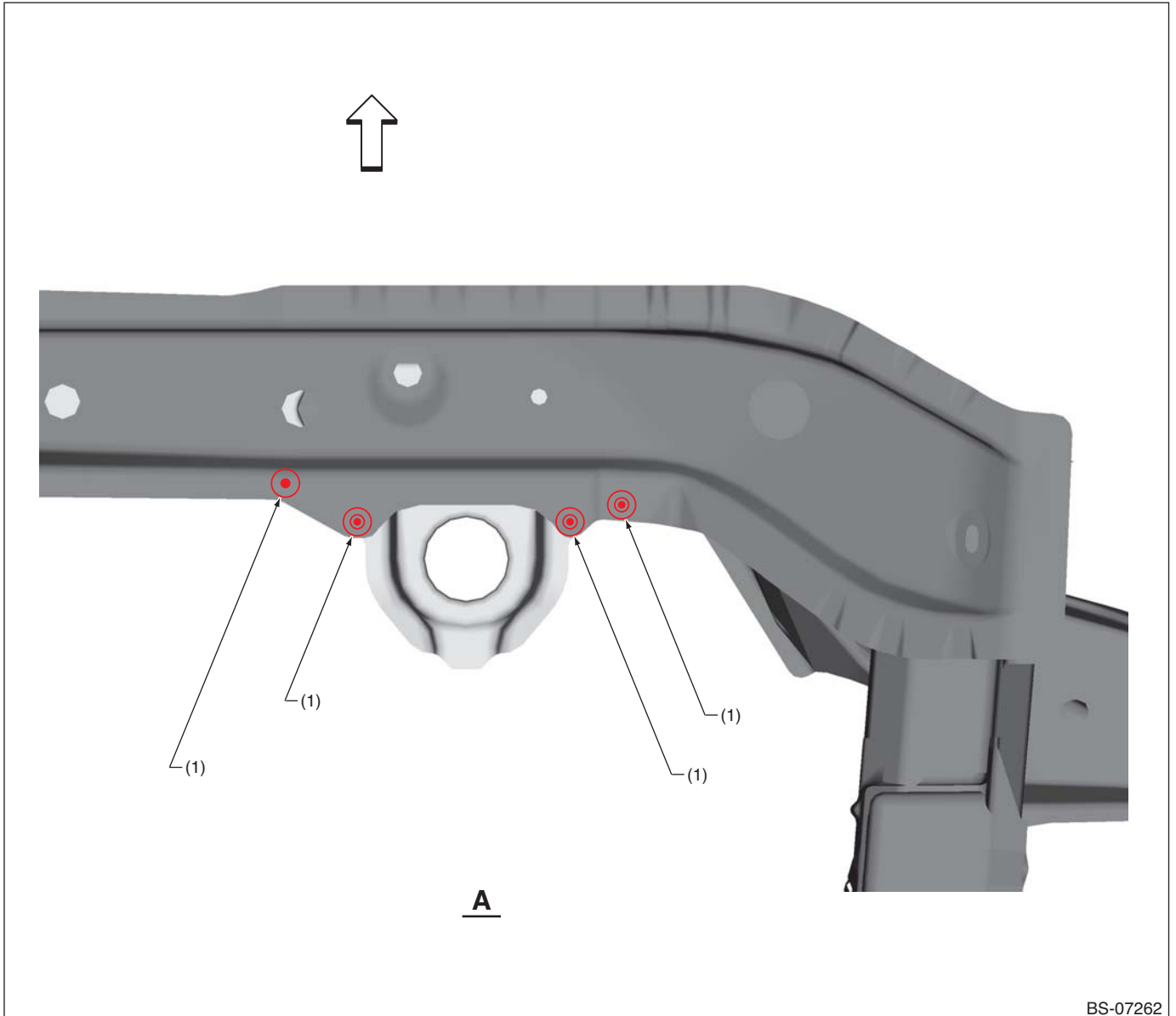
(4) 2 points (bolt)

(2) 4 points

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

Panel Replacement

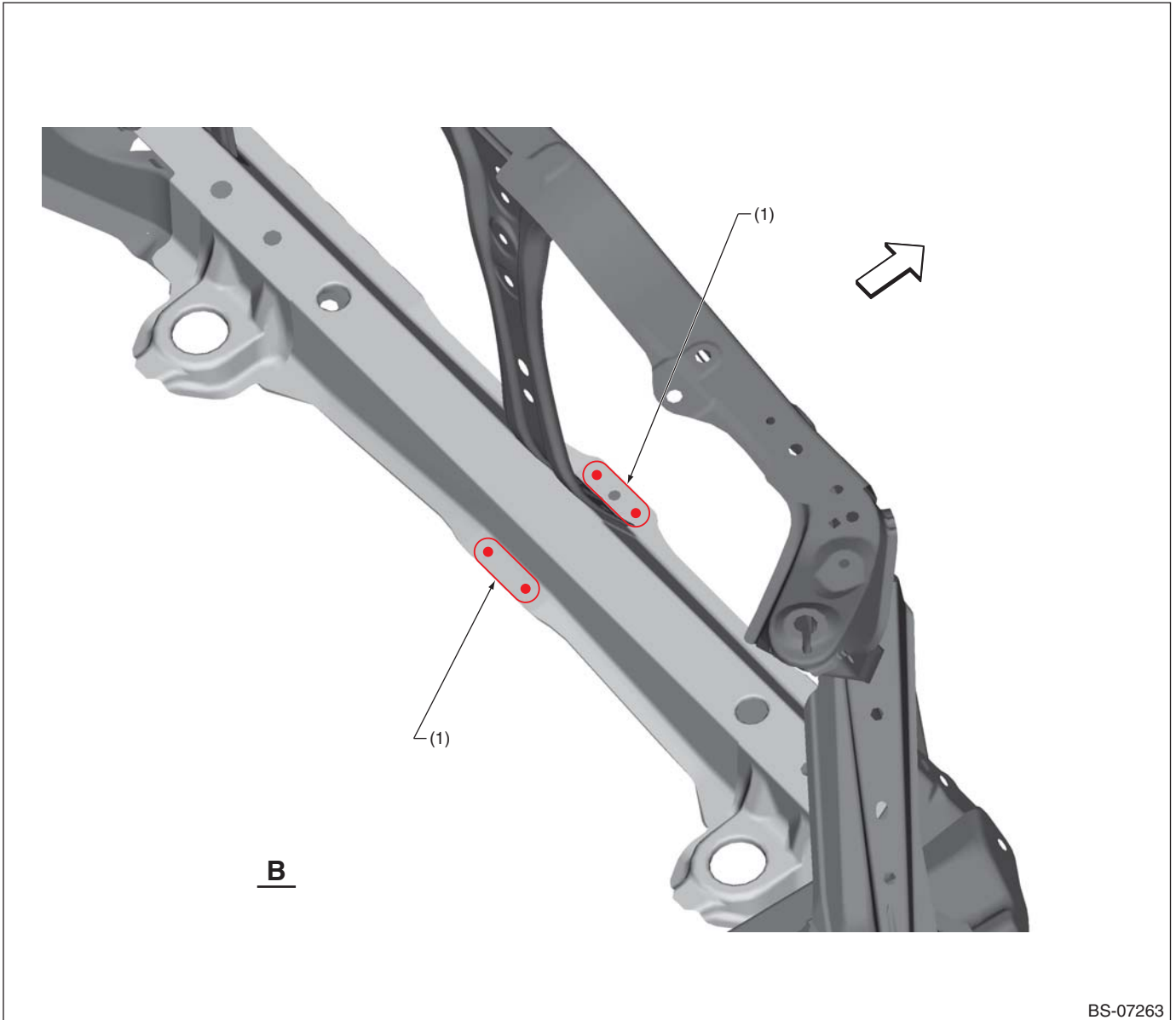
- View A



(1) 1 point

Panel Replacement

- View B



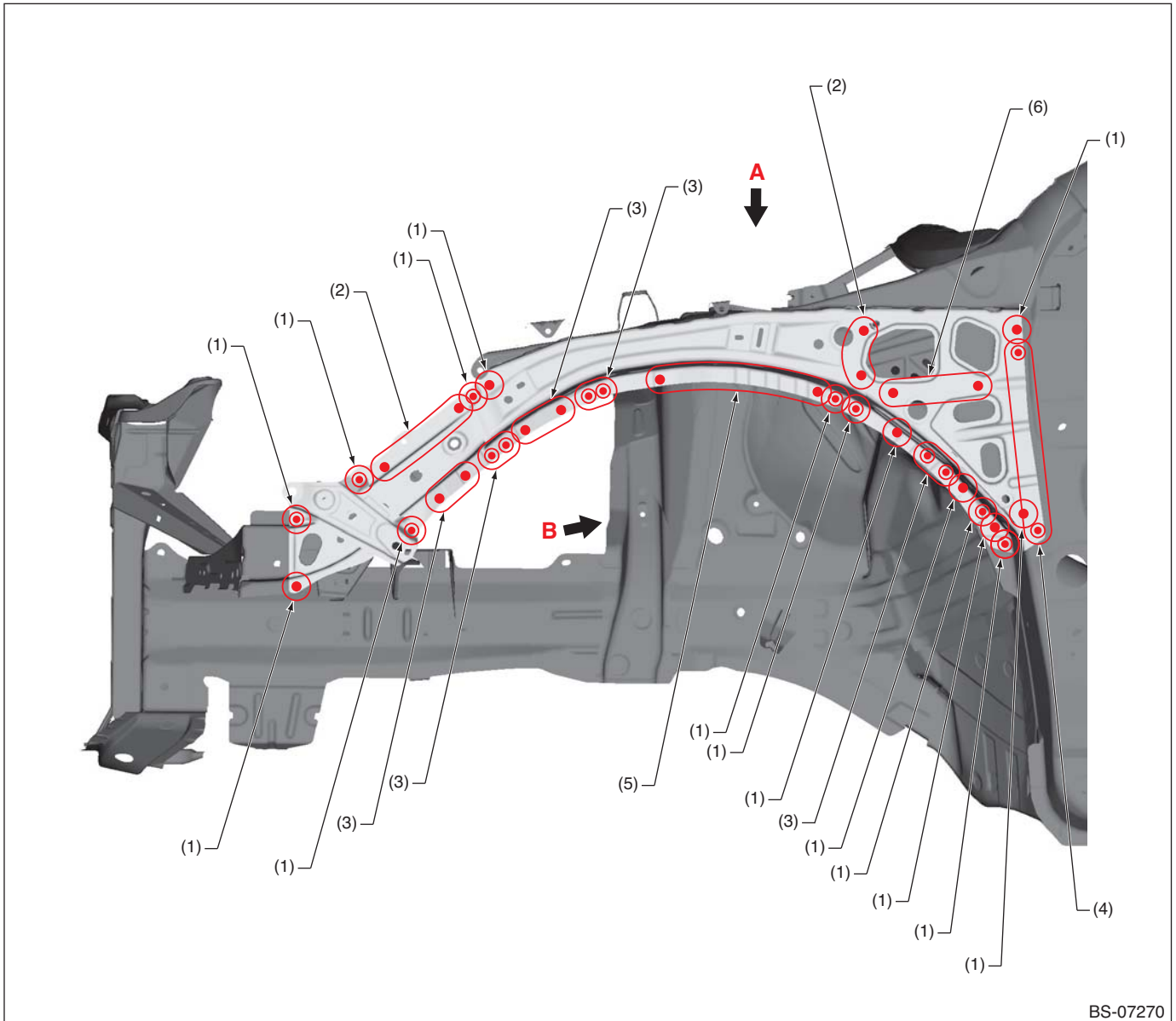
(1) 2 points

Panel Replacement

8-3. Side Upper Frame (Total replacement)

A: REMOVAL

- Overall view



BS-07270

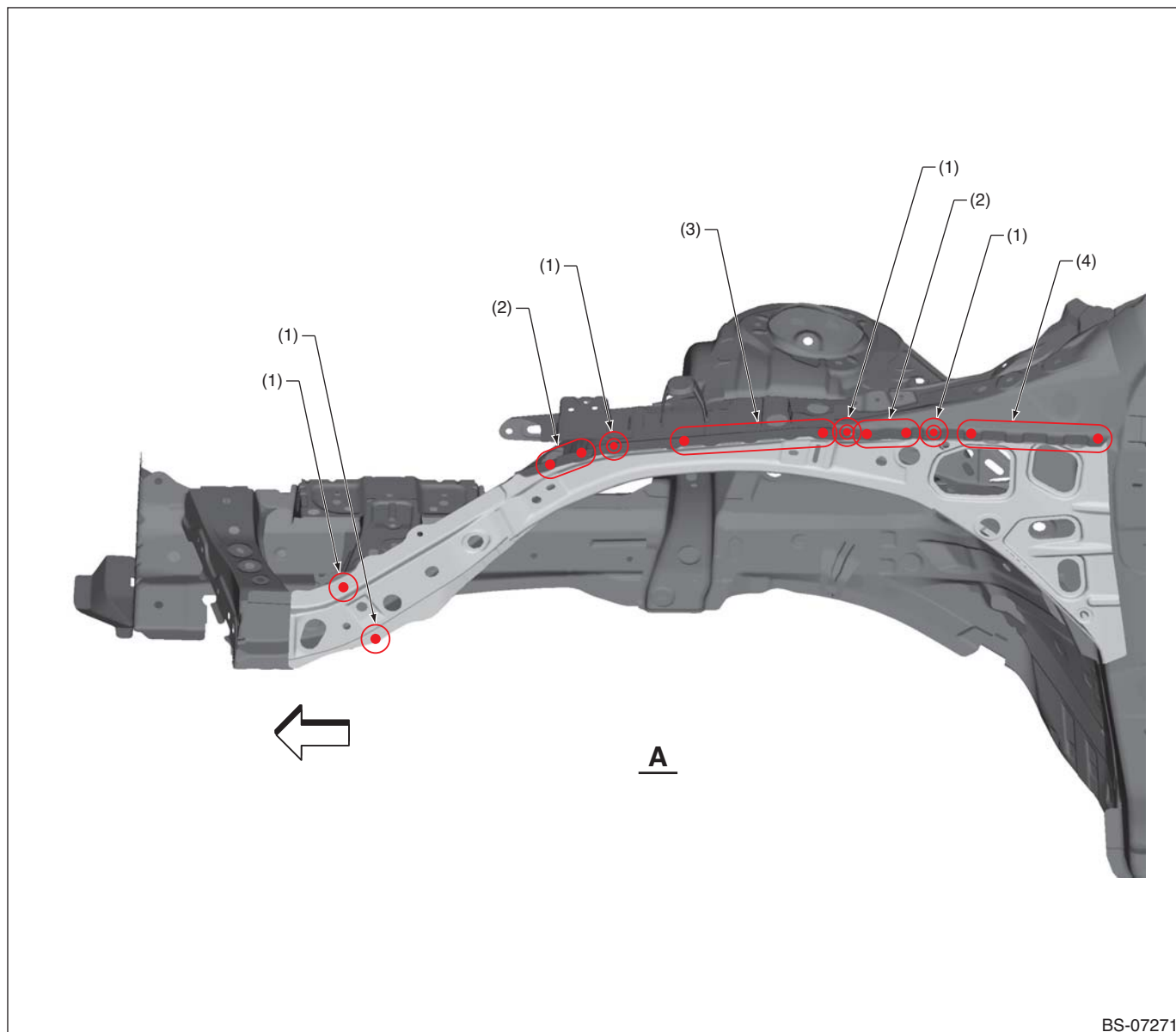
(1) 1 point
(2) 3 points

(3) 2 points
(4) 7 points

(5) 5 points
(6) 4 points

Panel Replacement

- View A



BS-07271

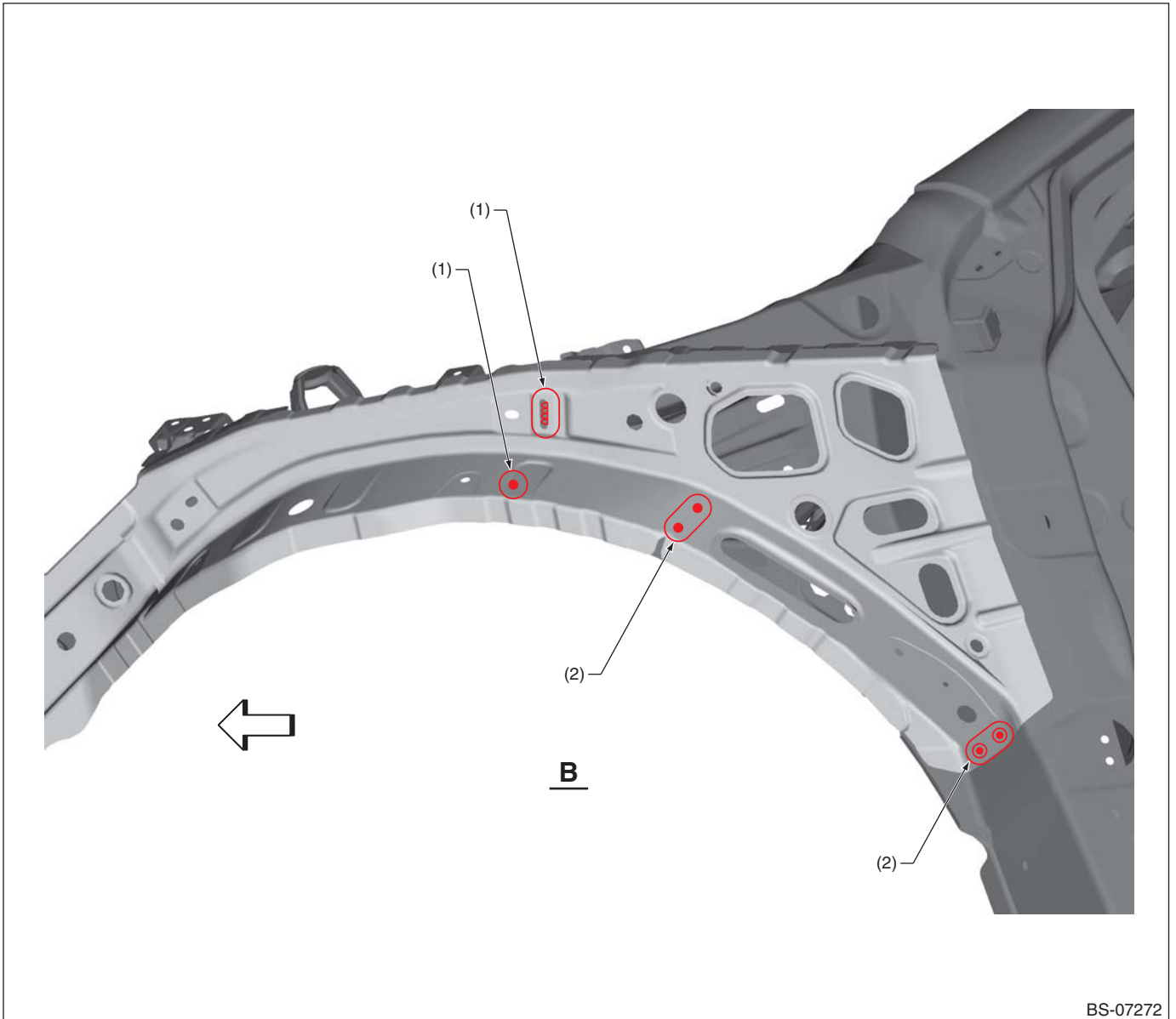
(1) 1 point
(2) 2 points

(3) 5 points

(4) 4 points

Panel Replacement

- View B



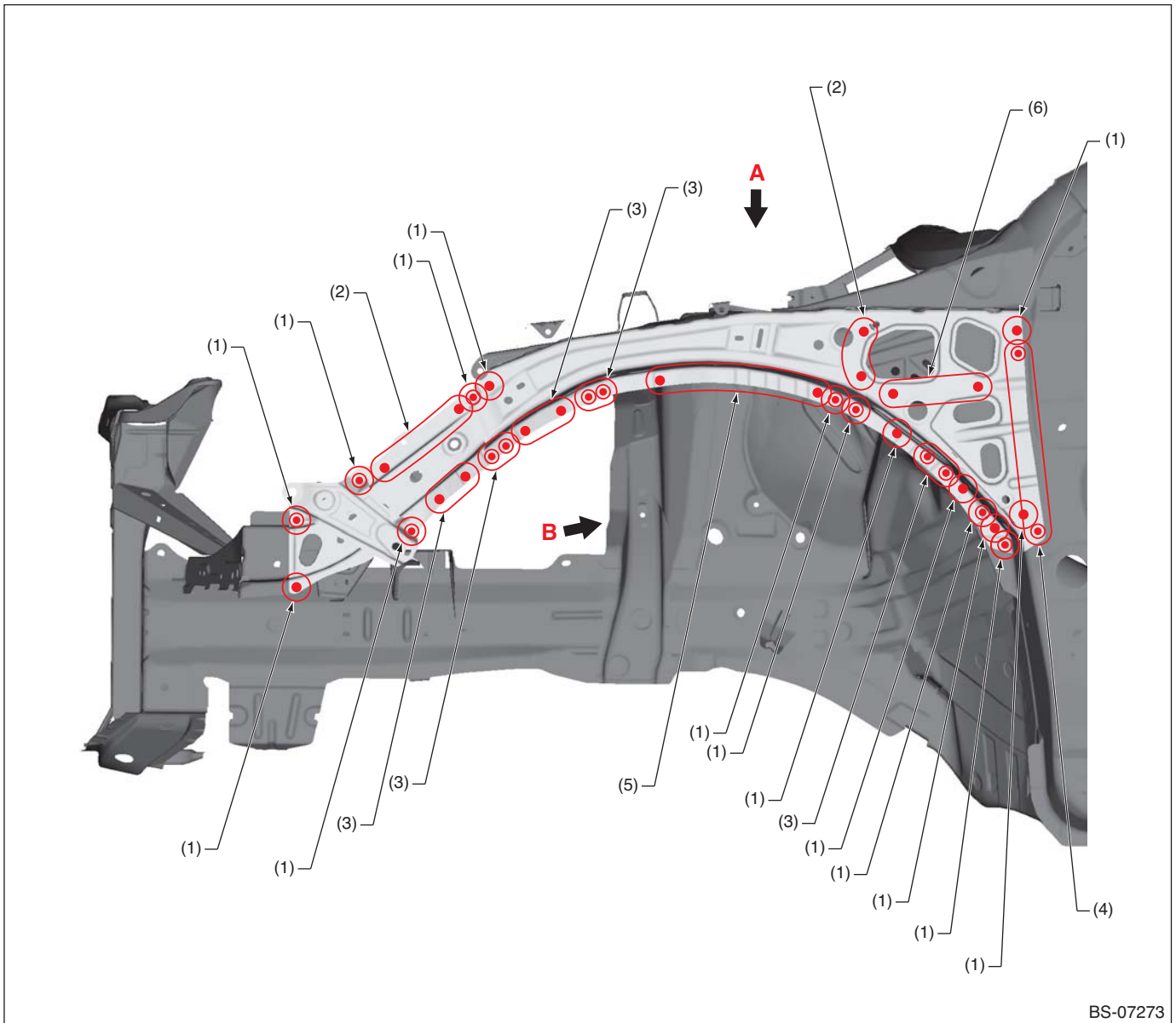
(1) 1 point

(2) 2 points

Panel Replacement

B: INSTALLATION

• Overall view



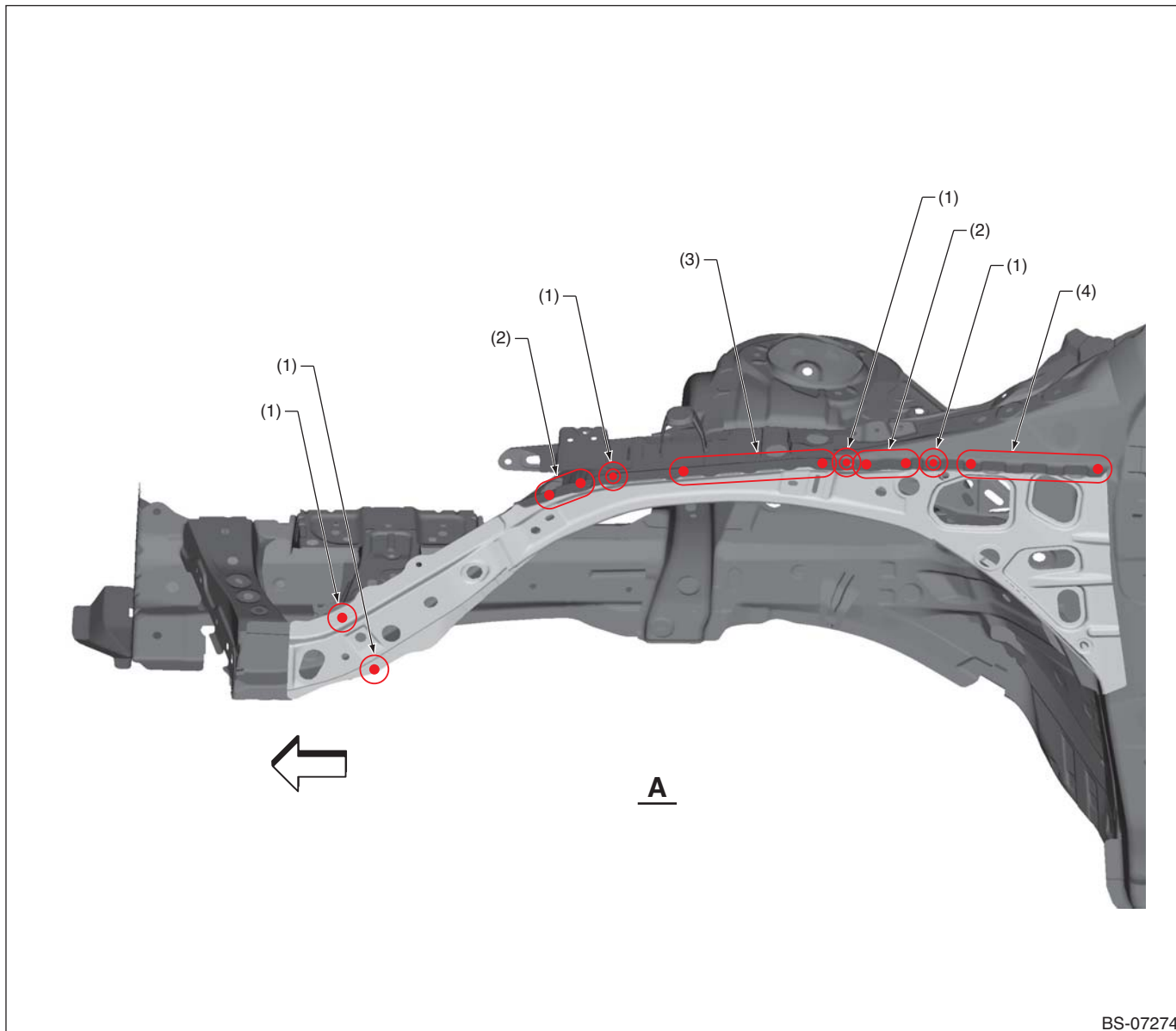
(1) 1 point
(2) 3 points

(3) 2 points
(4) 7 points

(5) 5 points
(6) 4 points

Panel Replacement

- View A



BS-07274

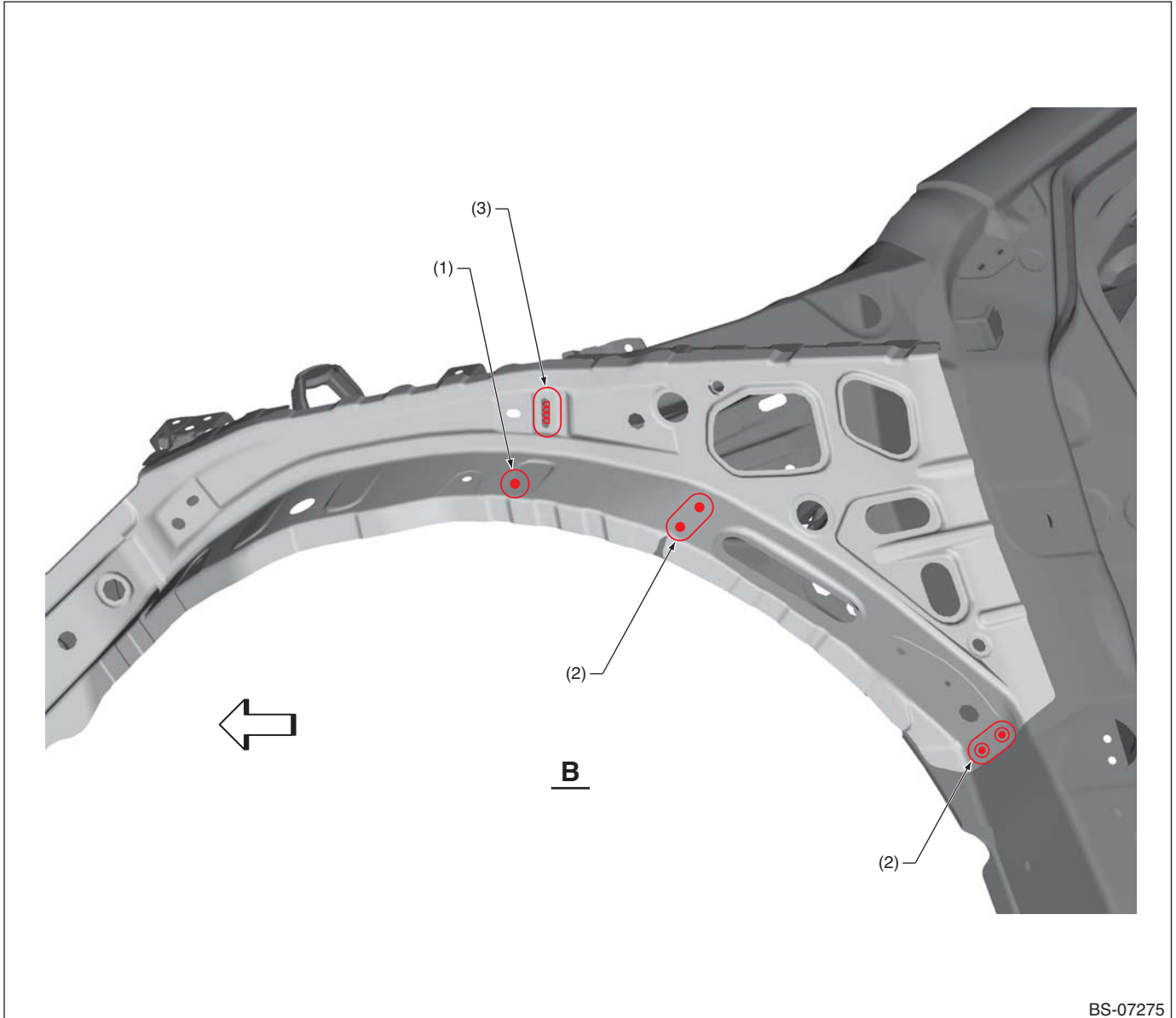
(1) 1 point
(2) 2 points

(3) 5 points

(4) 4 points

Panel Replacement

- View B



(1) 1 point

(2) 2 points

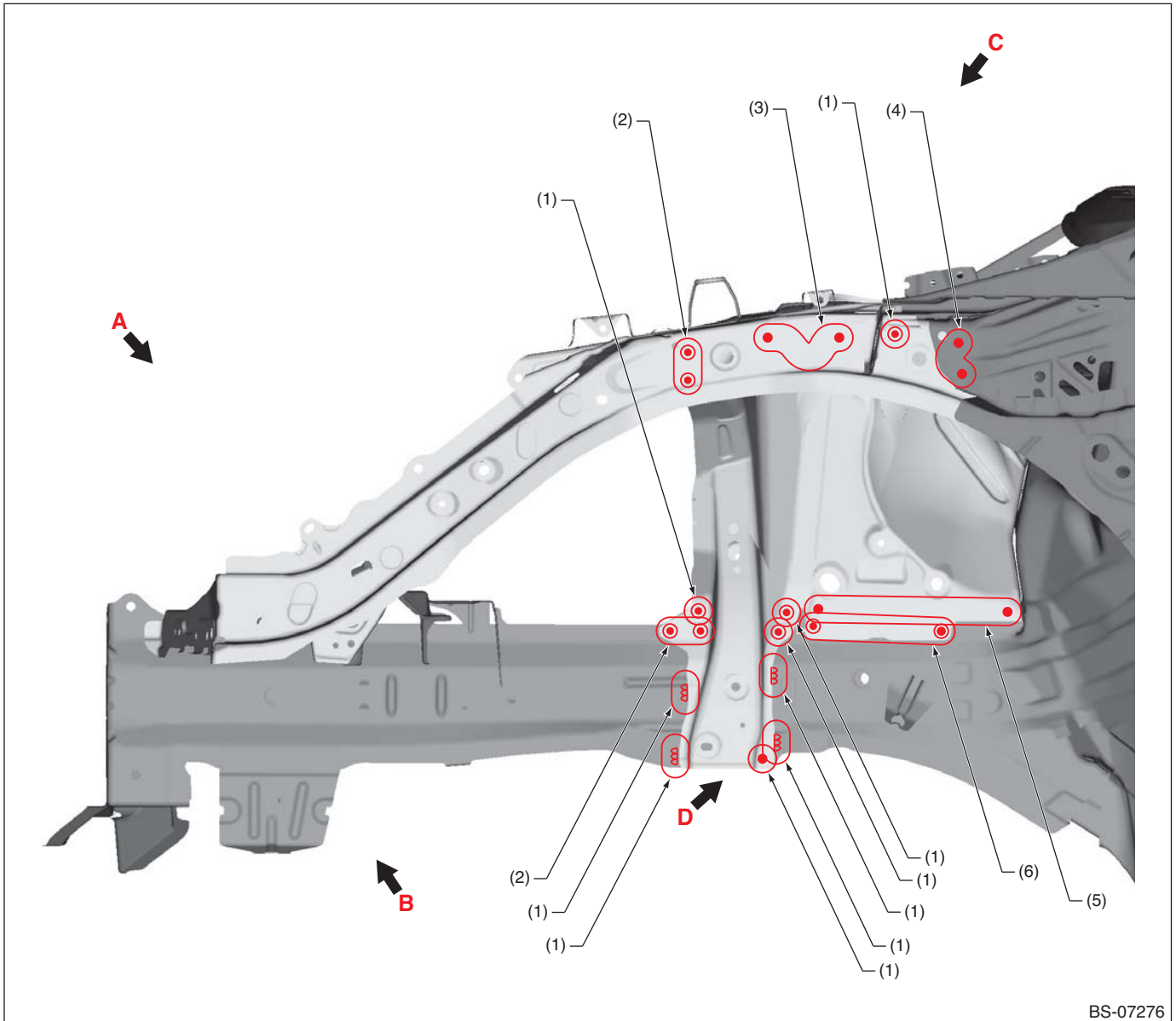
(3) 1 point [20 mm (0.79 in)]

Panel Replacement

8-4. Front Wheel Apron (Total replacement)

A: REMOVAL

- Overall view (Radiator panel, side upper frame removal condition)



BS-07276

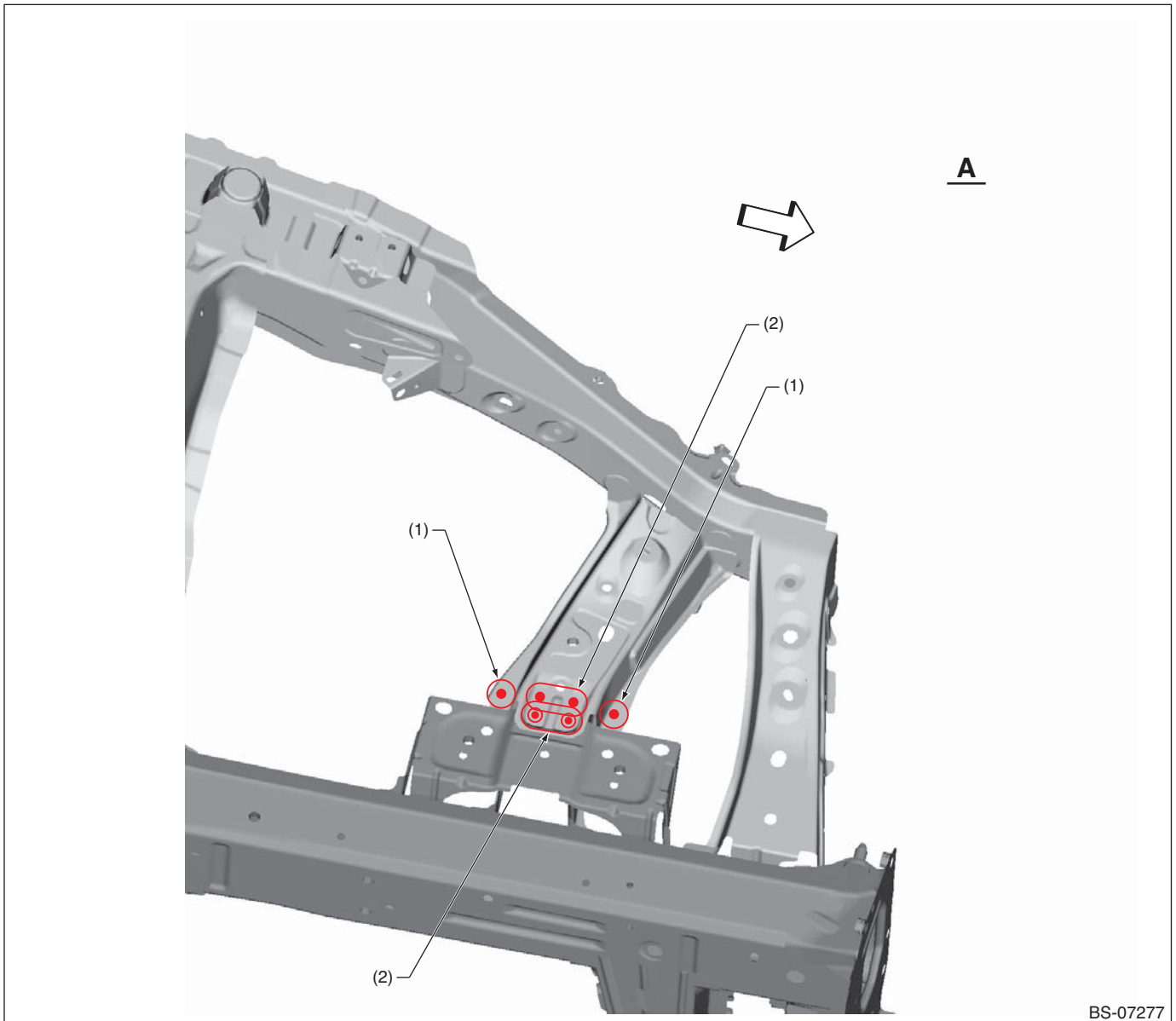
- (1) 1 point
(2) 2 points

- (3) 4 points
(4) 3 points

- (5) 8 points
(6) 6 points

Panel Replacement

- View A (LH)

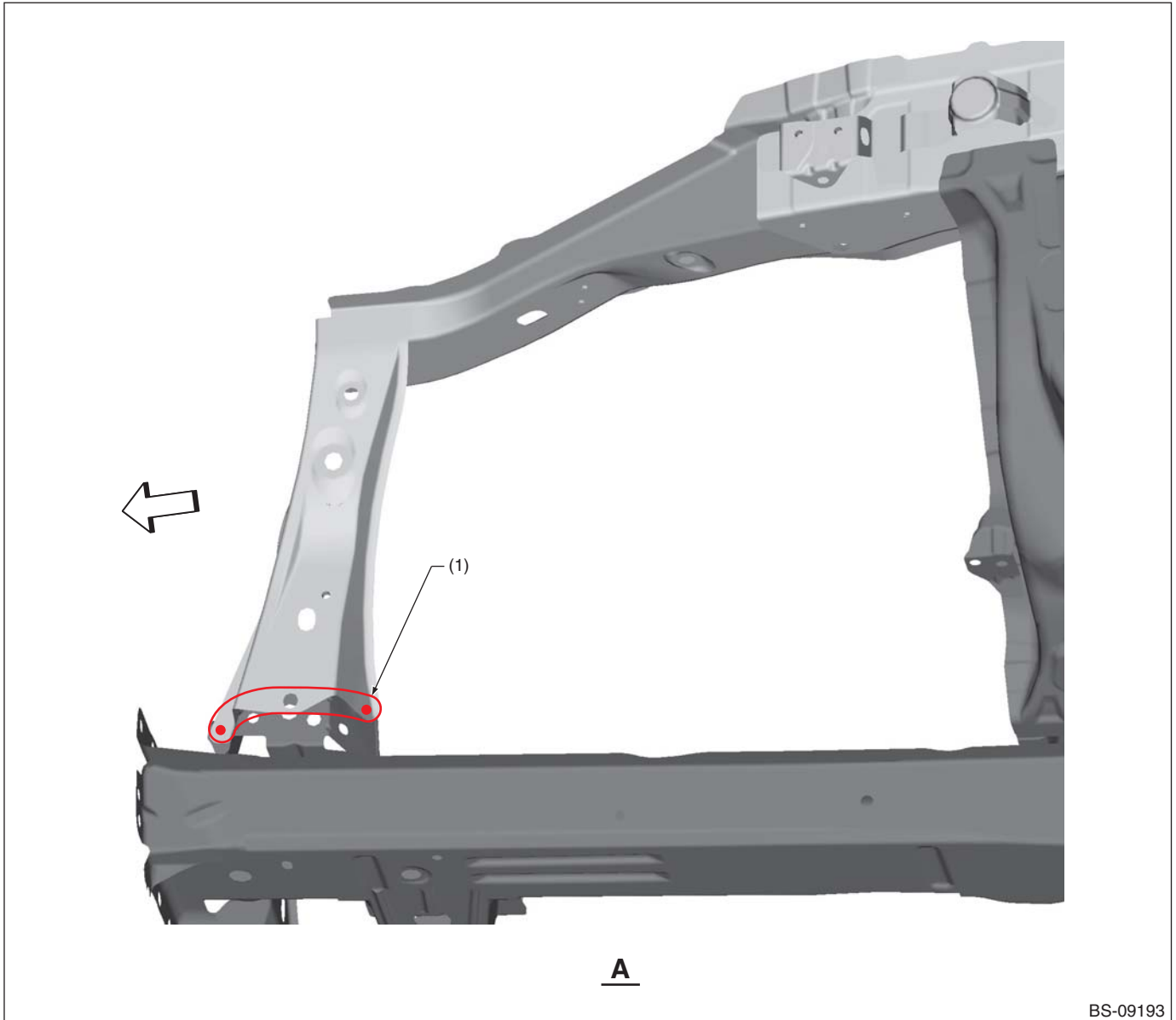


(1) 1 point

(2) 2 points

Panel Replacement

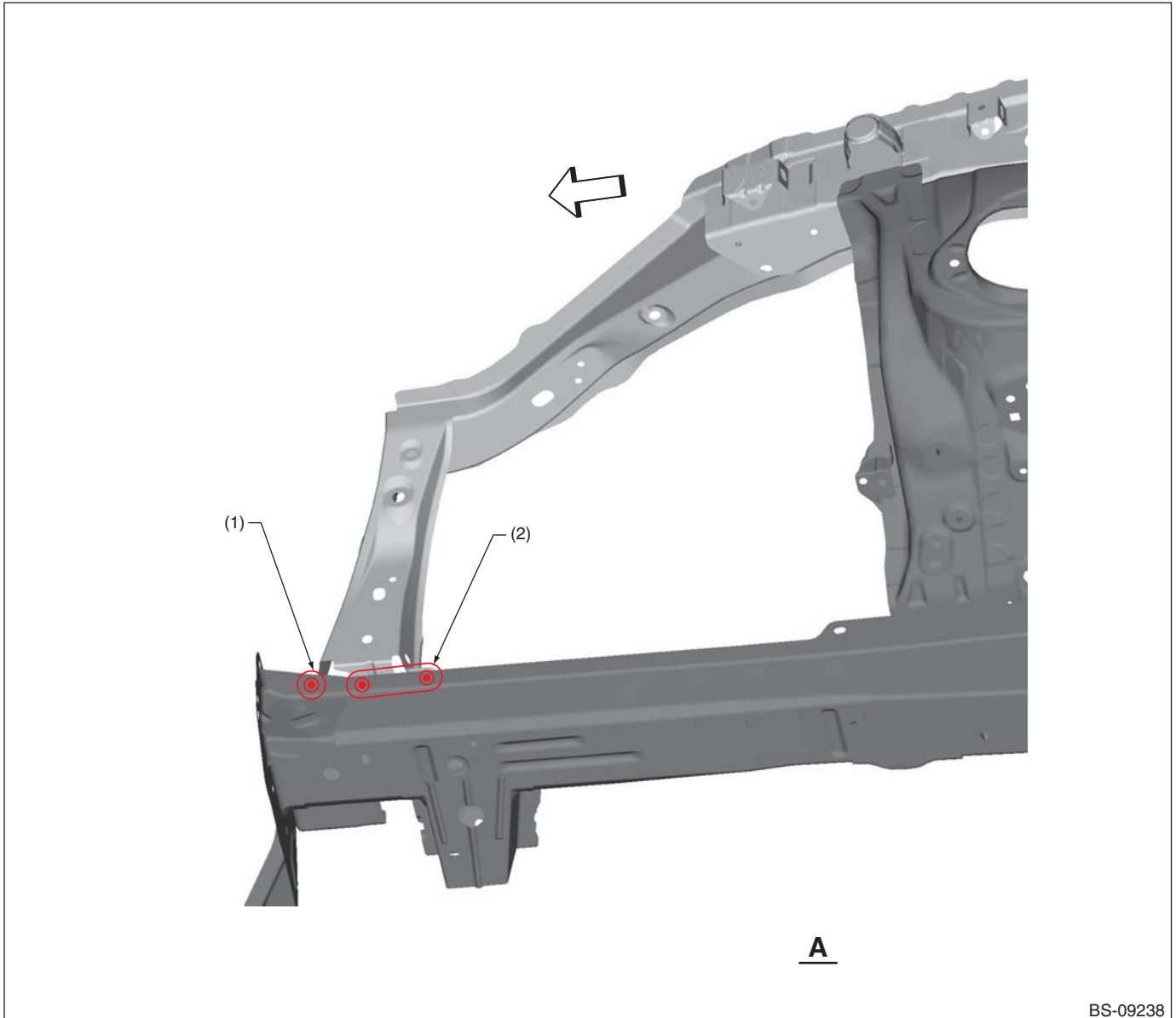
- View A (RH) (— '17 MY)



(1) 3 points

Panel Replacement

- View A (RH) ('18 MY —)

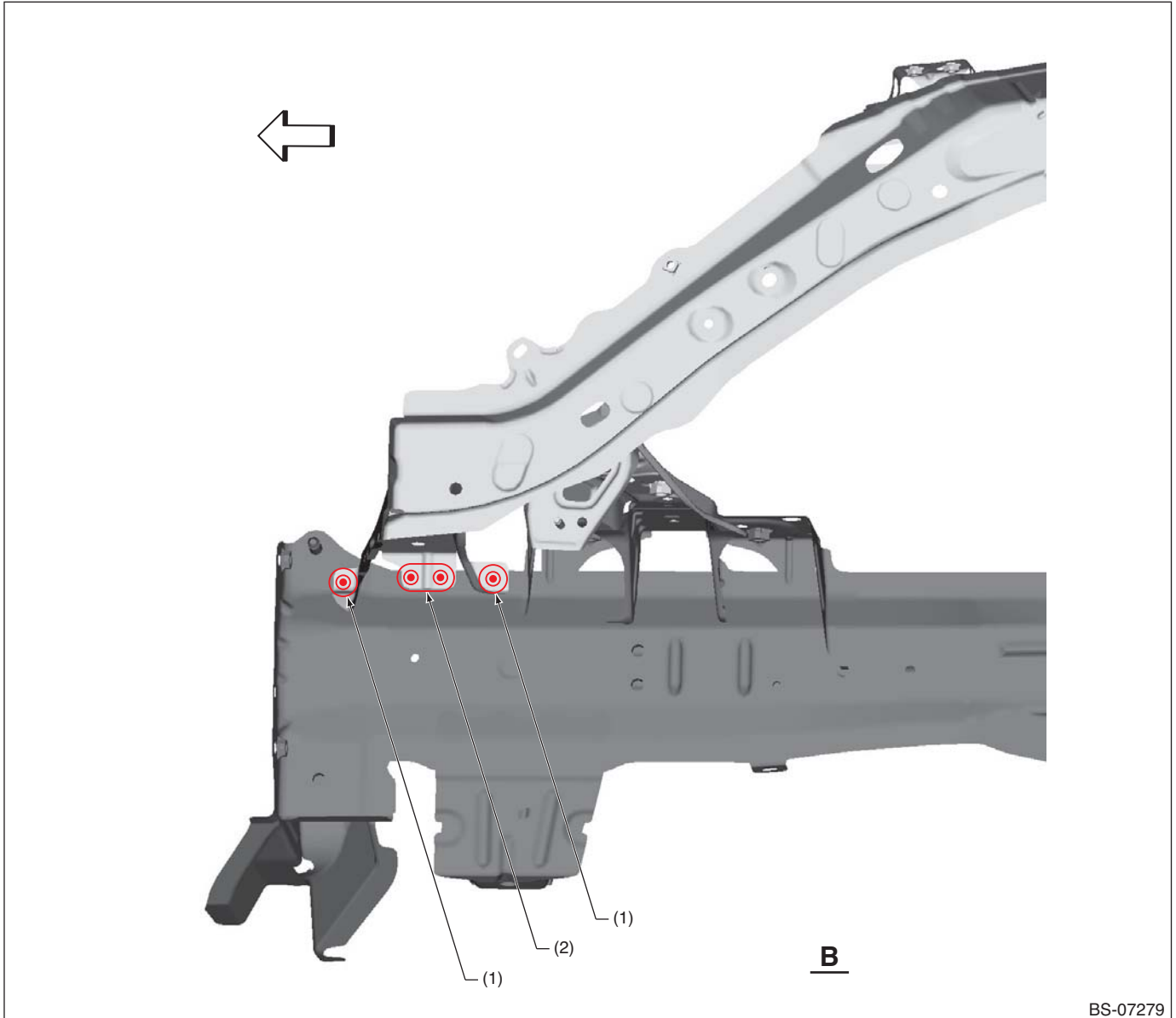


(1) 1 point

(2) 3 points

Panel Replacement

- View B (LH)



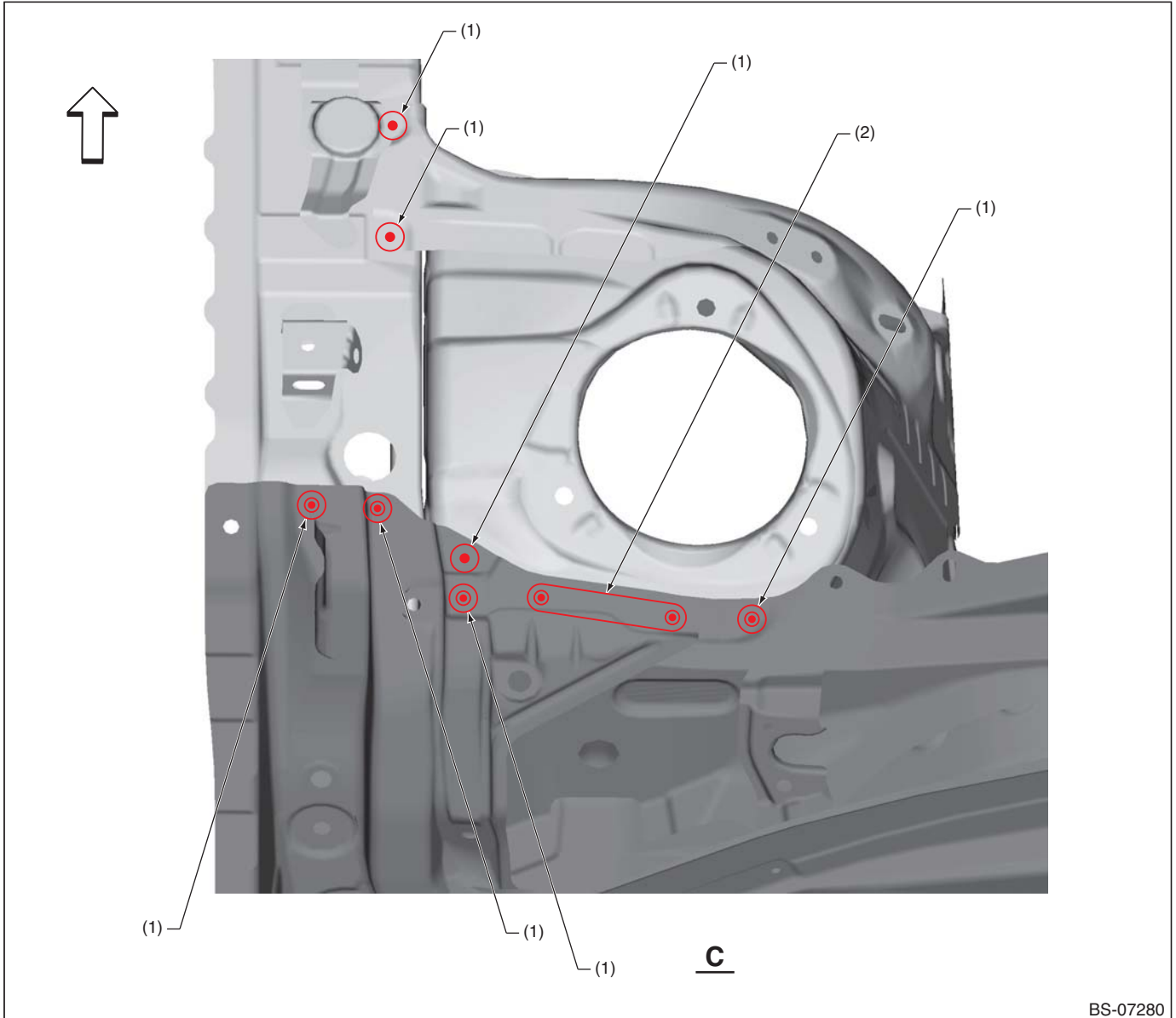
BS-07279

(1) 1 point

(2) 2 points

Panel Replacement

- View C



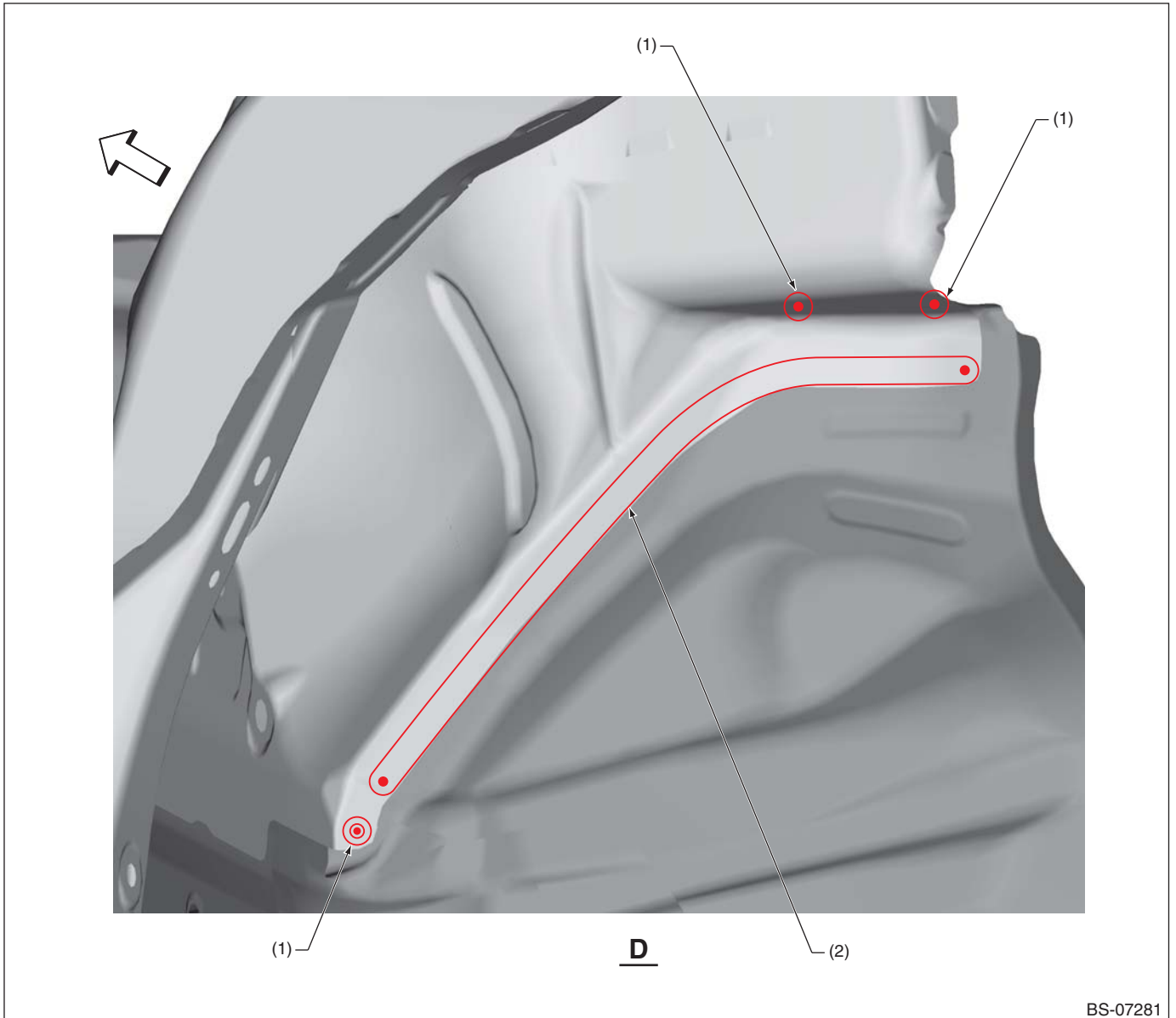
BS-07280

(1) 1 point

(2) 3 points

Panel Replacement

- View D



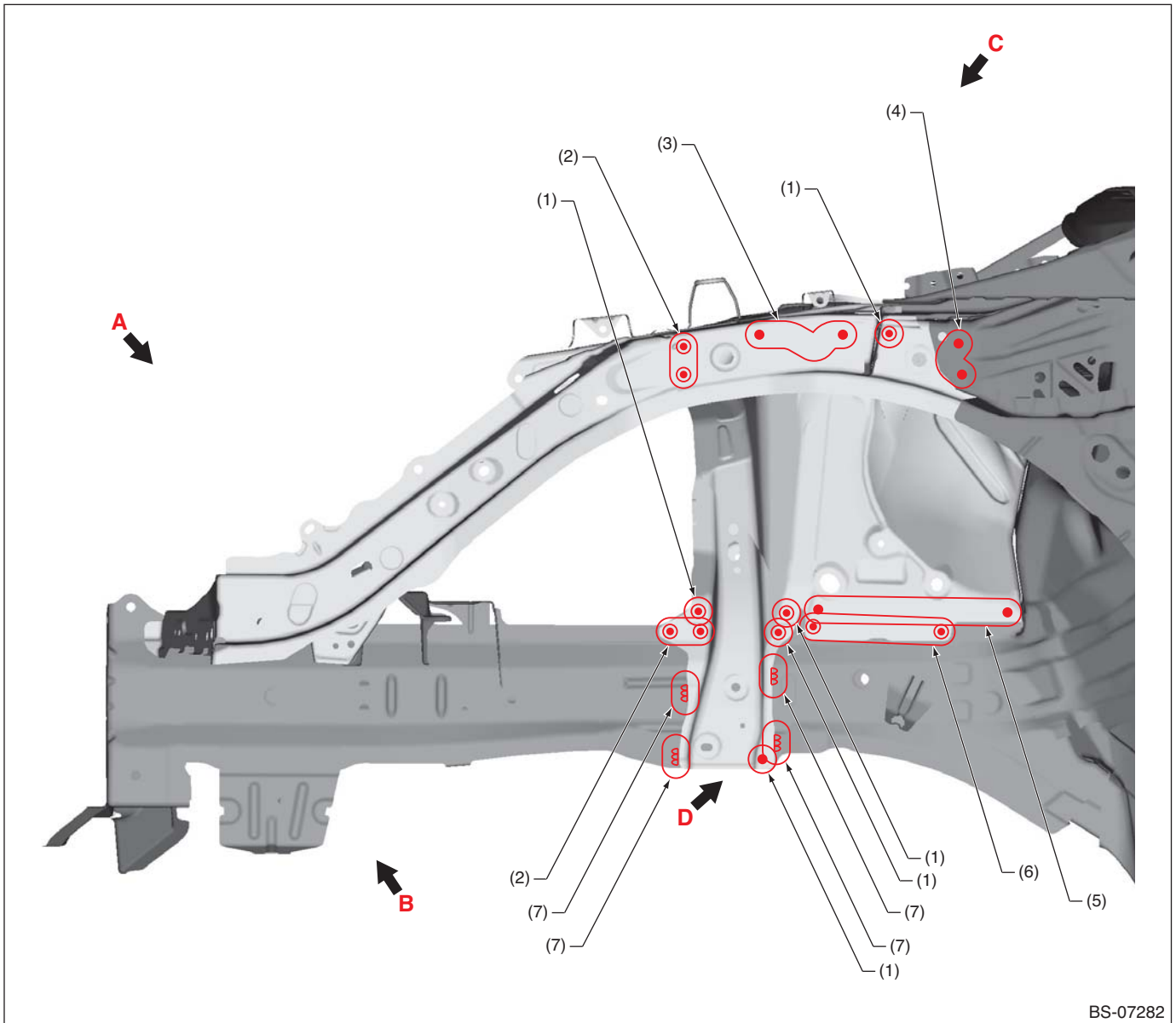
(1) 1 point

(2) 10 points

Panel Replacement

B: INSTALLATION

• Overall view



BS-07282

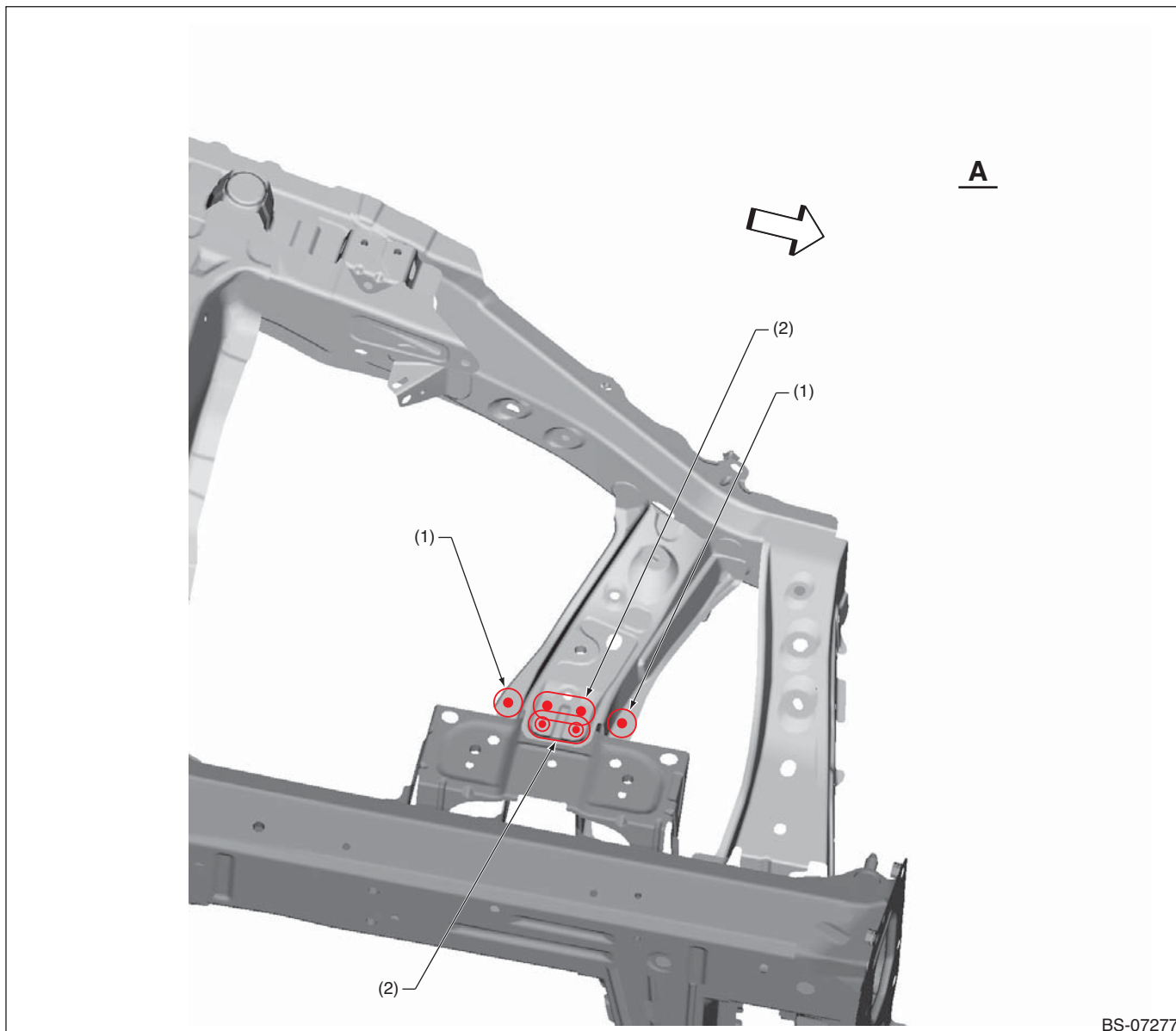
- (1) 1 point
- (2) 2 points
- (3) 4 points

- (4) 3 points
- (5) 8 points
- (6) 6 points

- (7) 1 point [20 mm (0.79 in)]

Panel Replacement

- View A (LH)

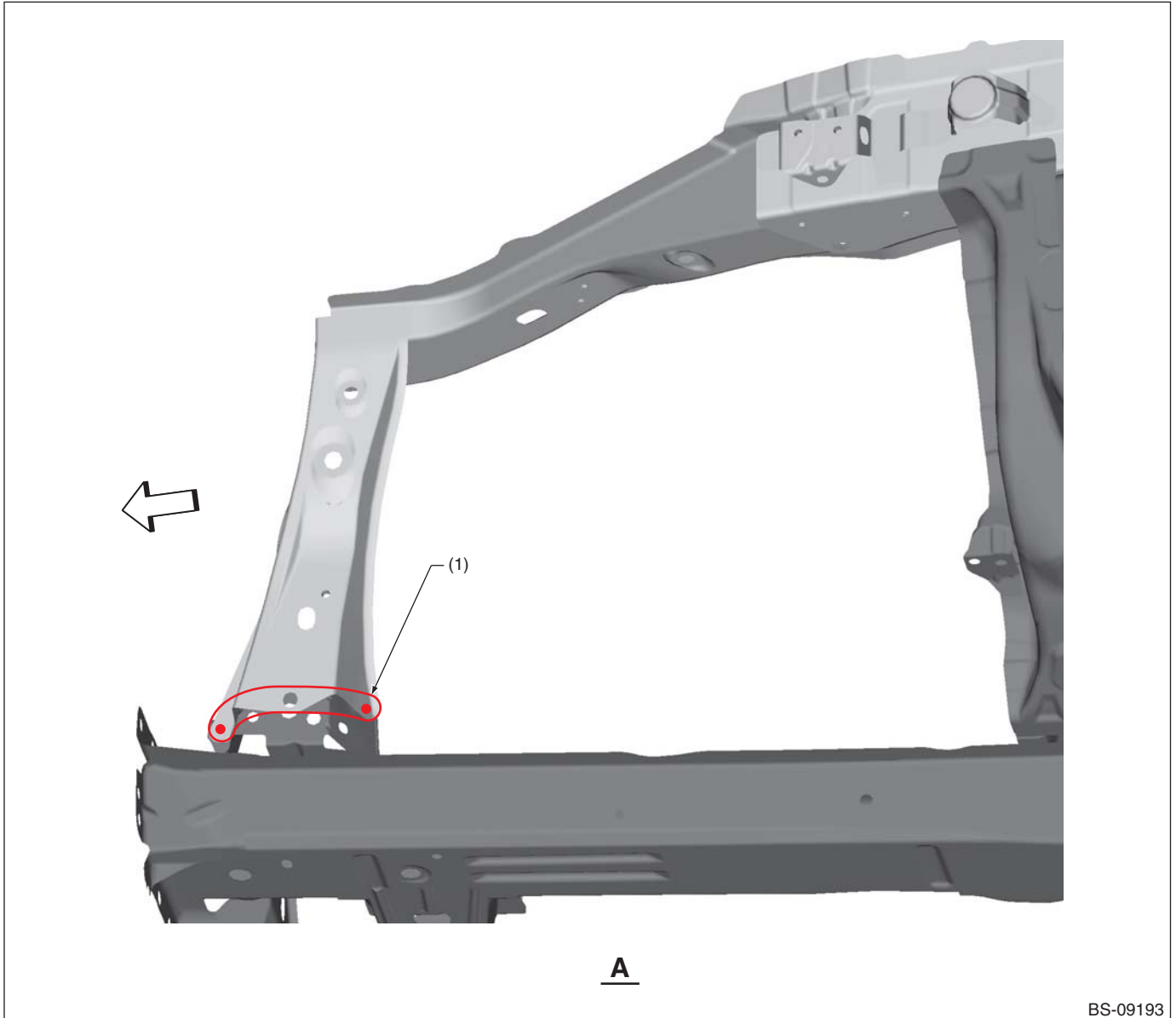


(1) 1 point

(2) 2 points

Panel Replacement

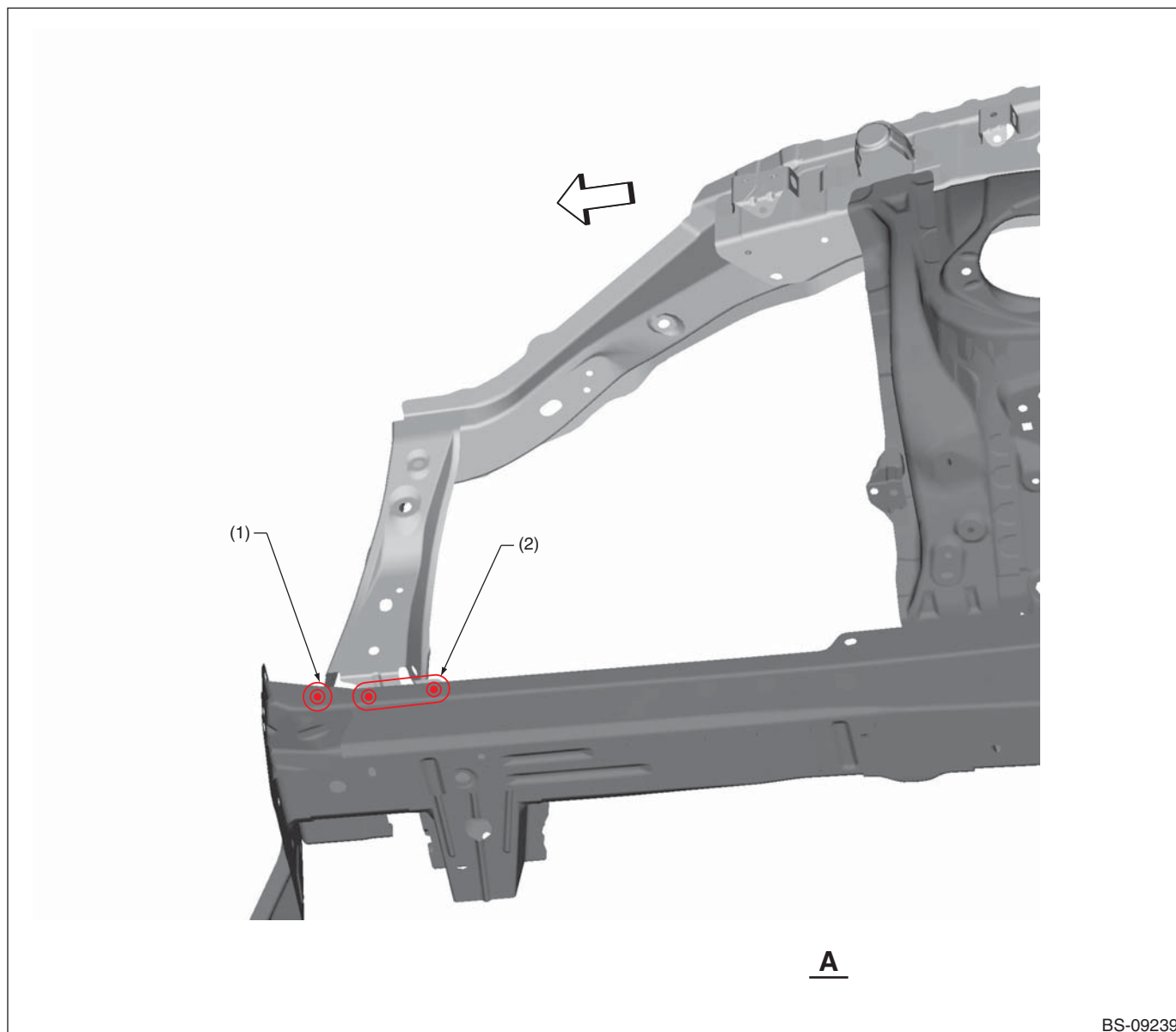
- View A (RH) (— '17 MY)



(1) 3 points

Panel Replacement

- View A (RH) ('18 MY —)

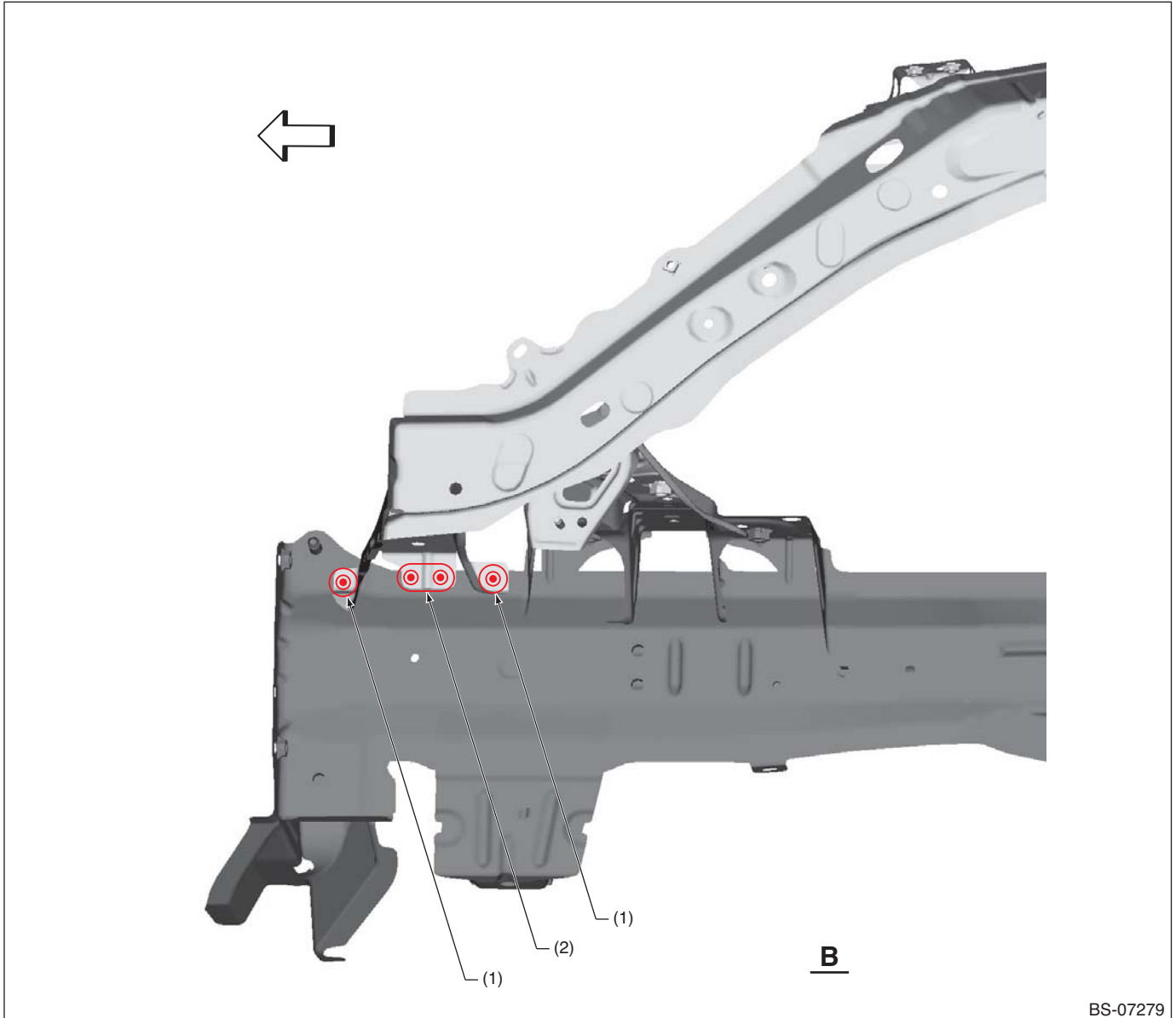


(1) 1 point

(2) 3 points

Panel Replacement

- View B (LH)

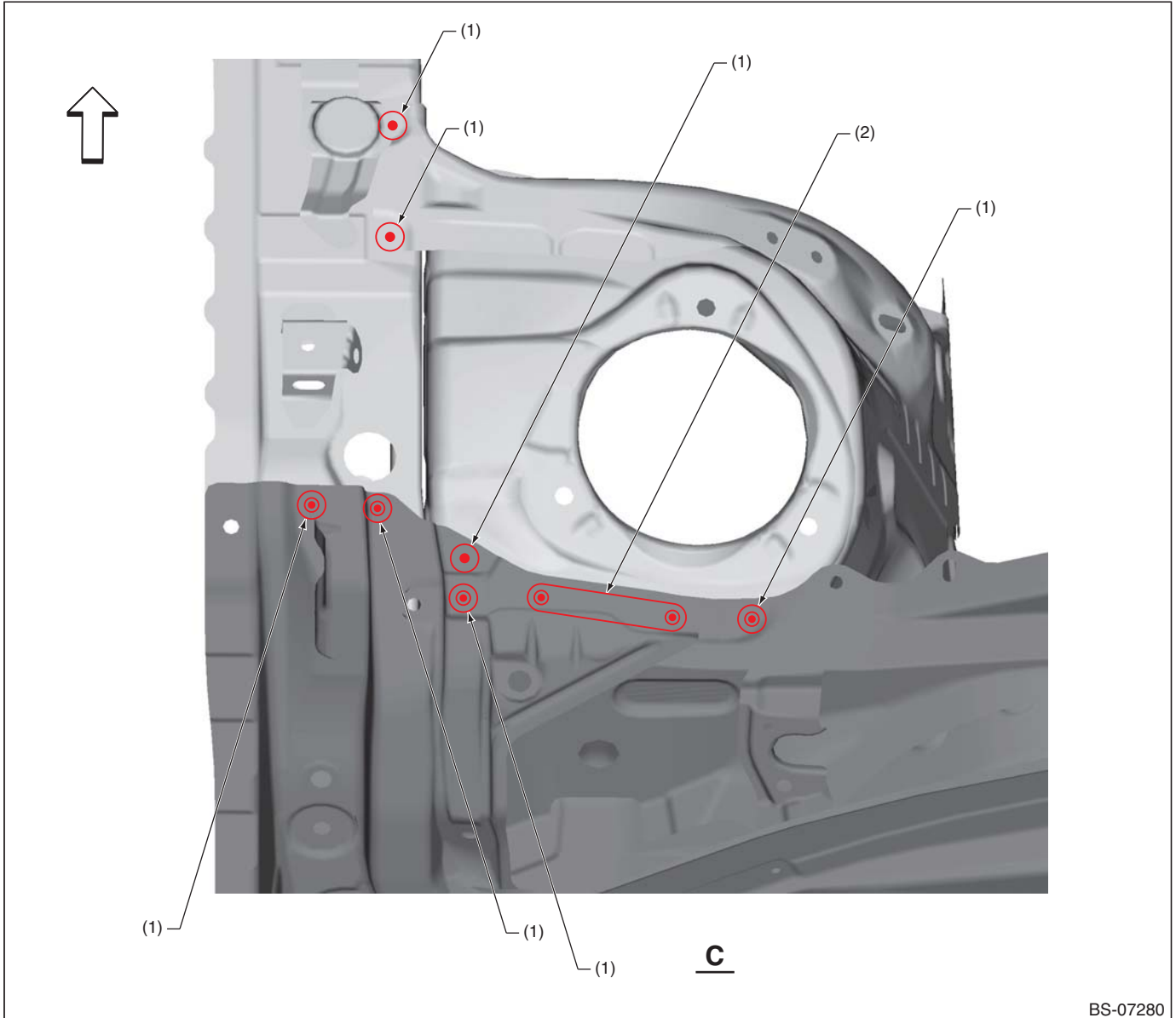


(1) 1 point

(2) 2 points

Panel Replacement

- View C



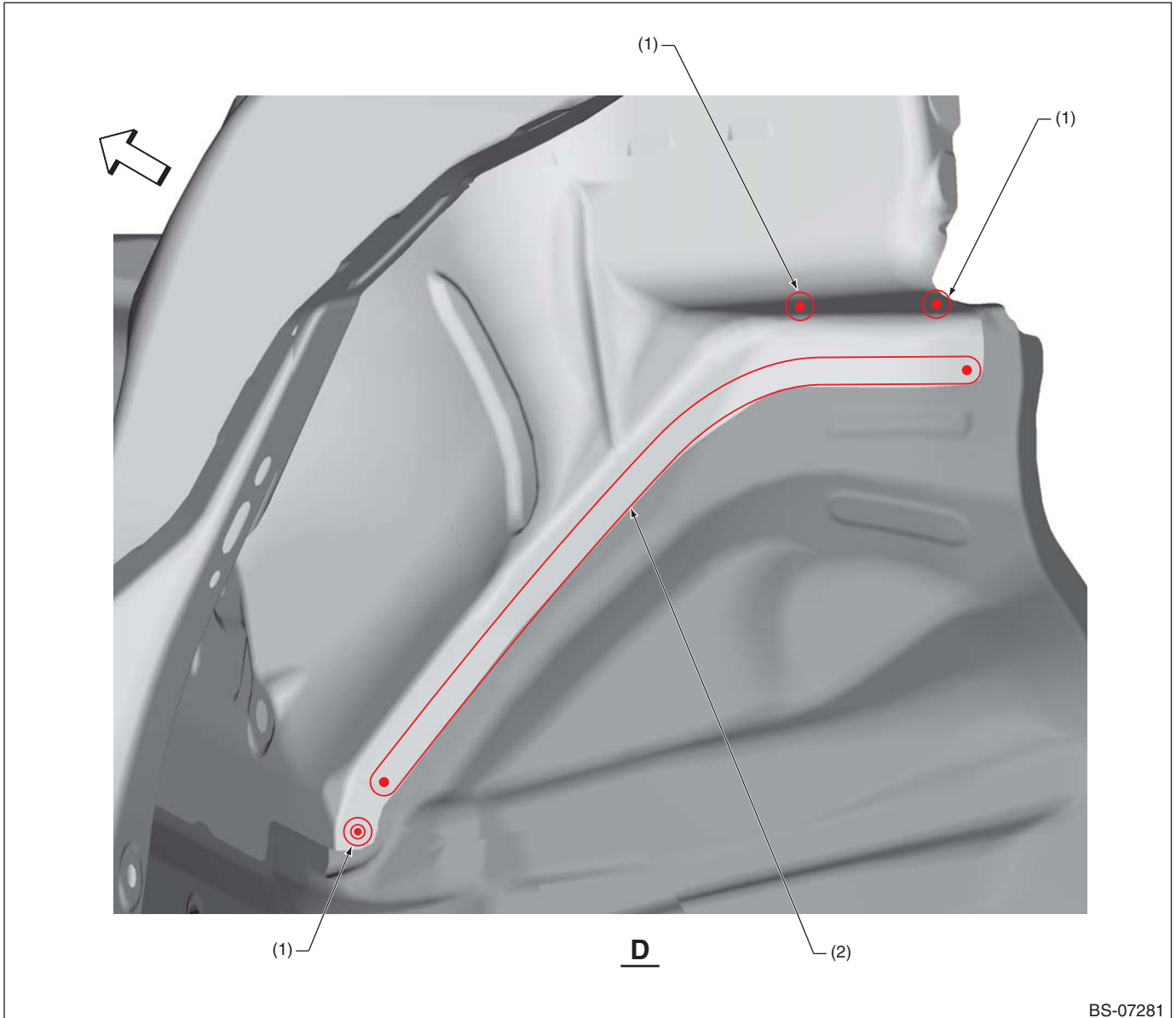
BS-07280

(1) 1 point

(2) 3 points

Panel Replacement

- View D



(1) 1 point

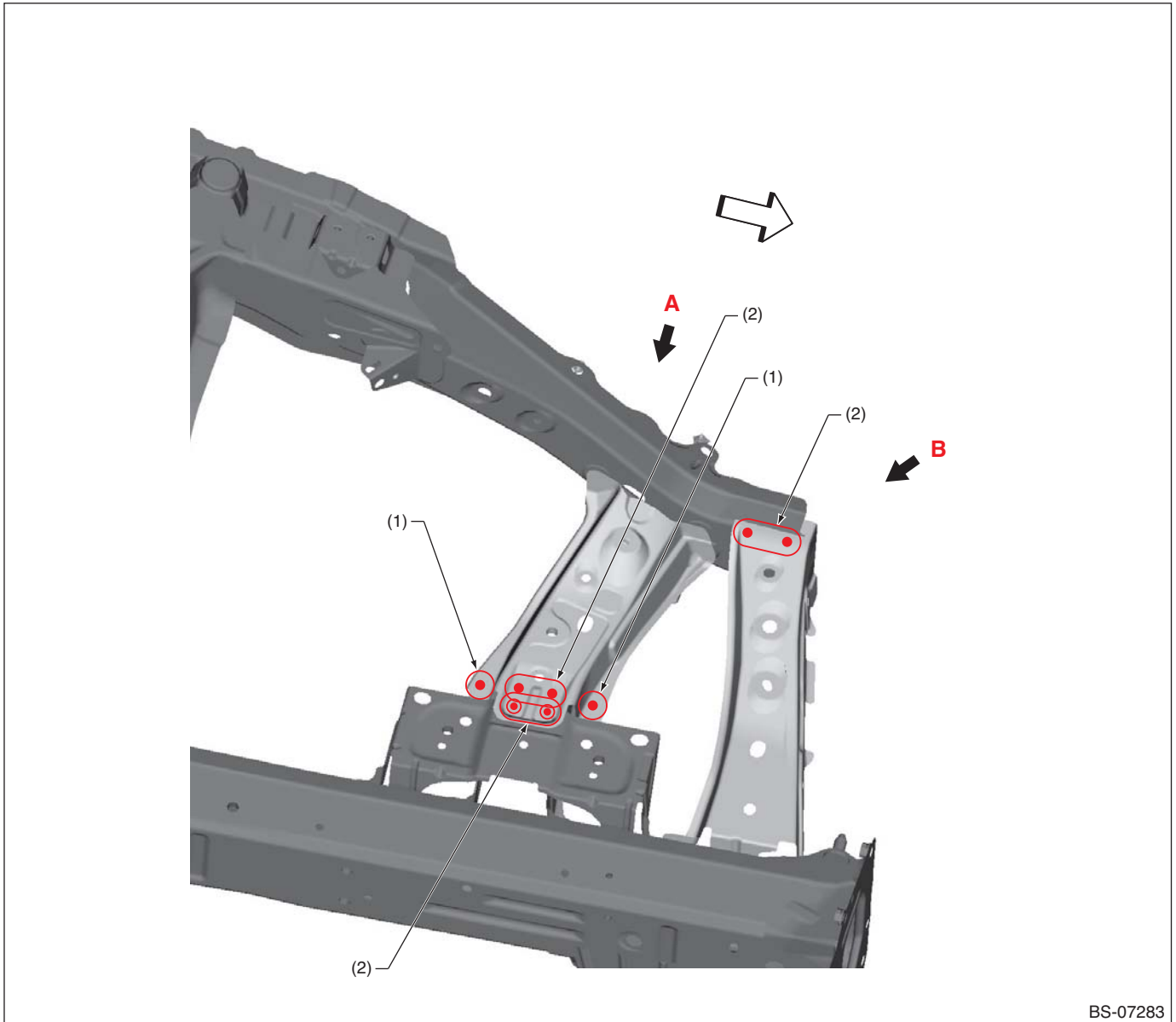
(2) 10 points

Panel Replacement

8-5. Front Wheel Apron LH (Partial replacement)

A: REMOVAL

- Overall view (Radiator panel removal condition)



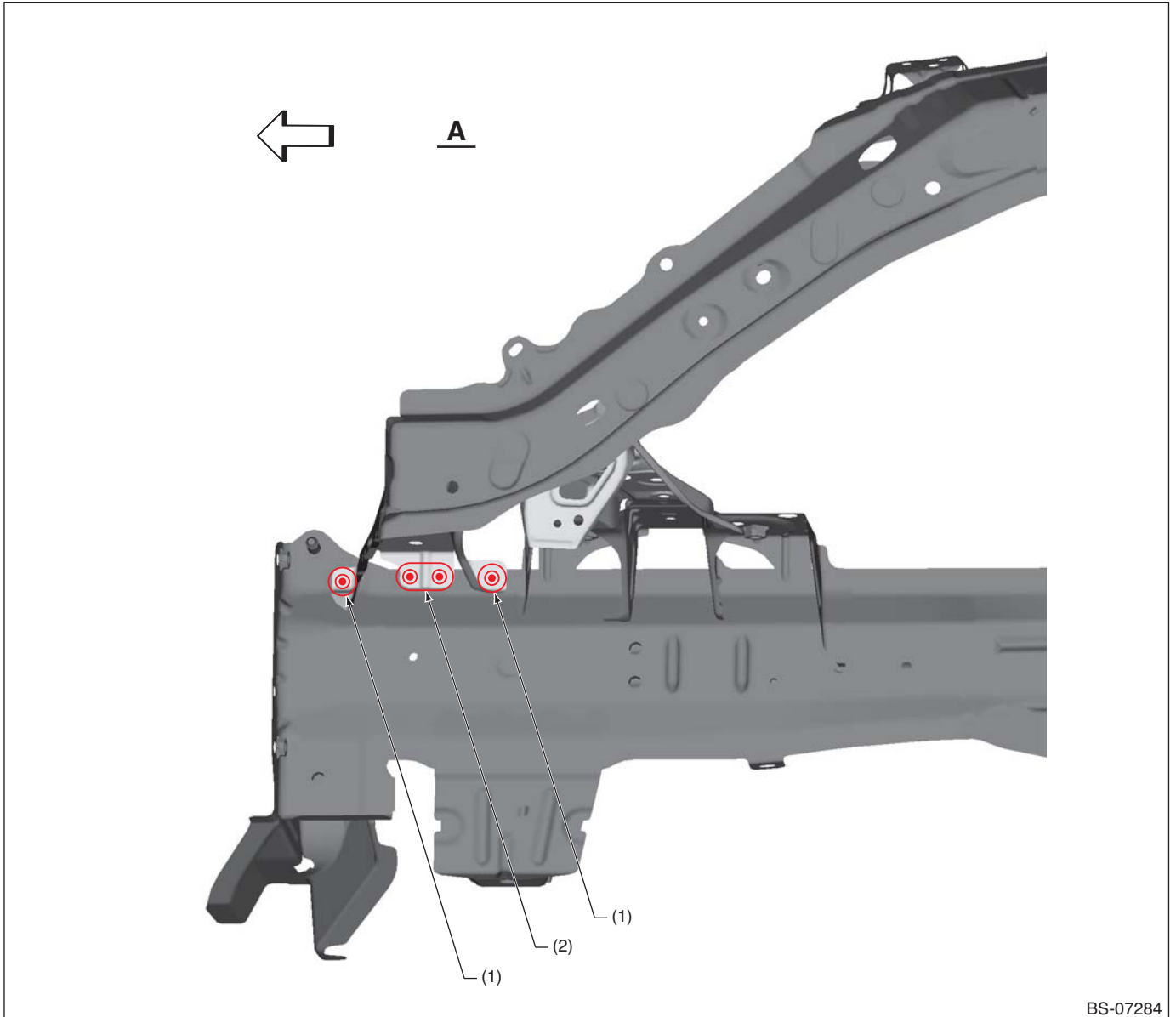
BS-07283

(1) 1 point

(2) 2 points

Panel Replacement

- View A

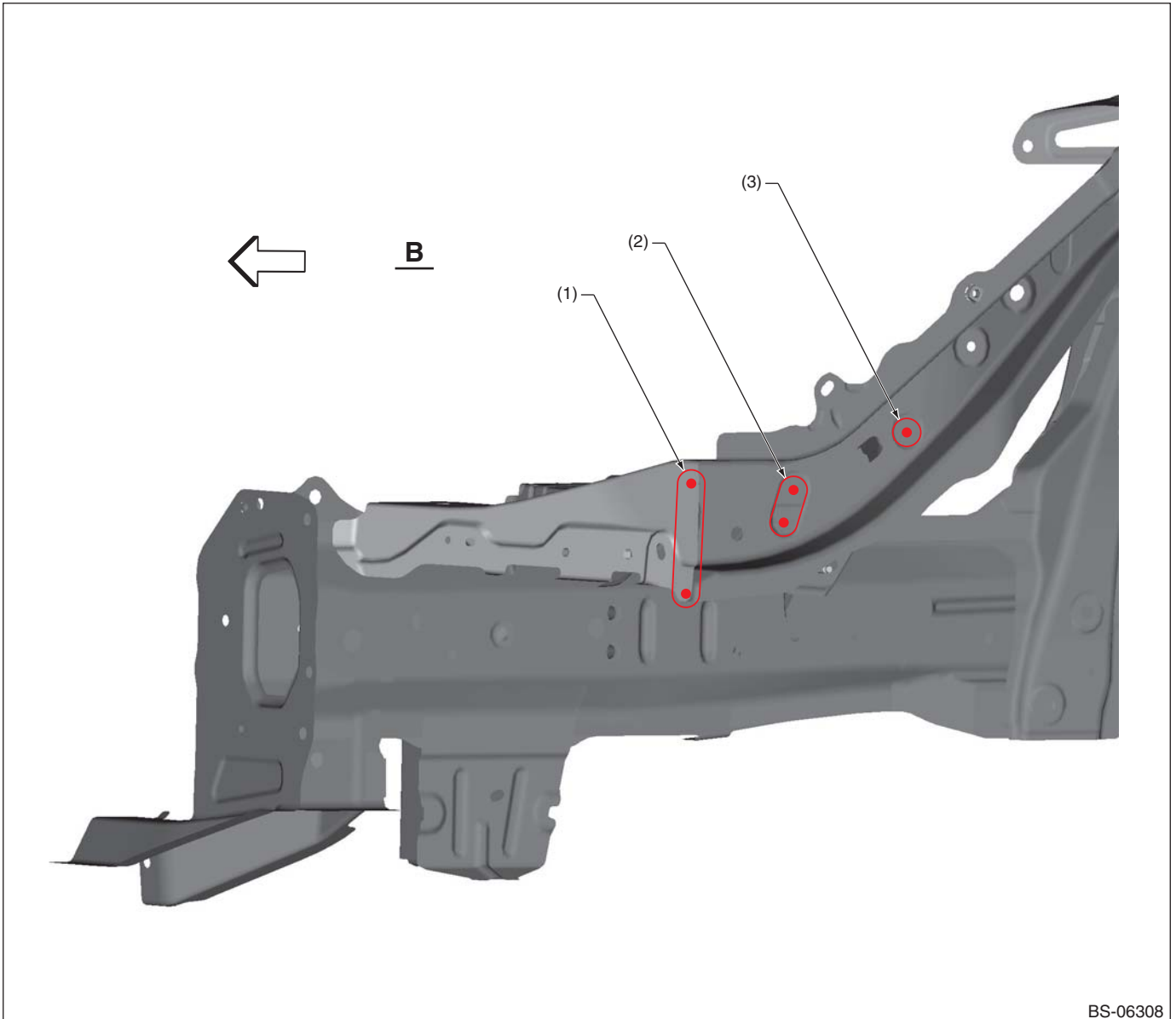


(1) 1 point

(2) 2 points

Panel Replacement

- View B



(1) 3 points

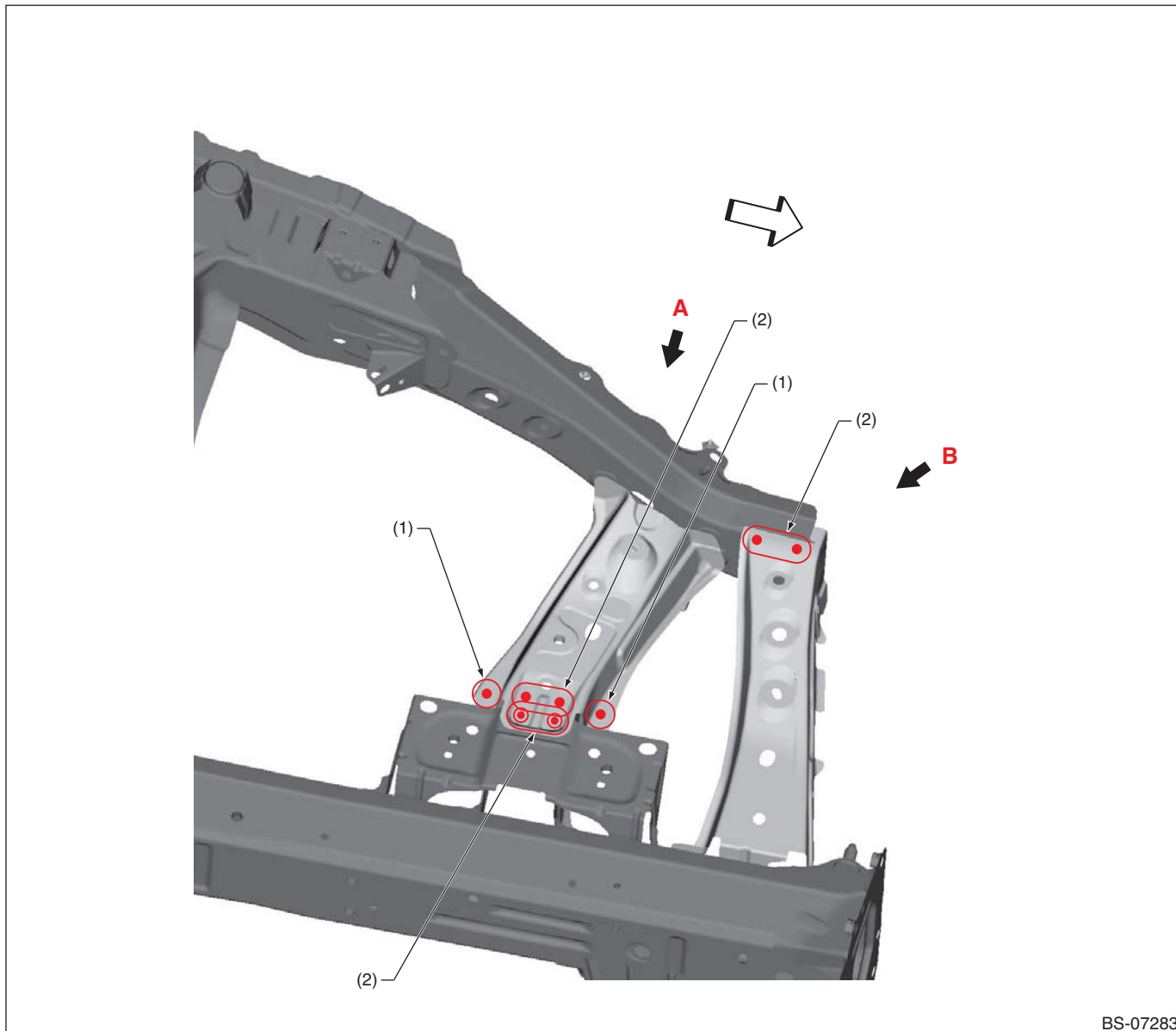
(2) 2 points

(3) 1 point

Panel Replacement

B: INSTALLATION

• Overall view



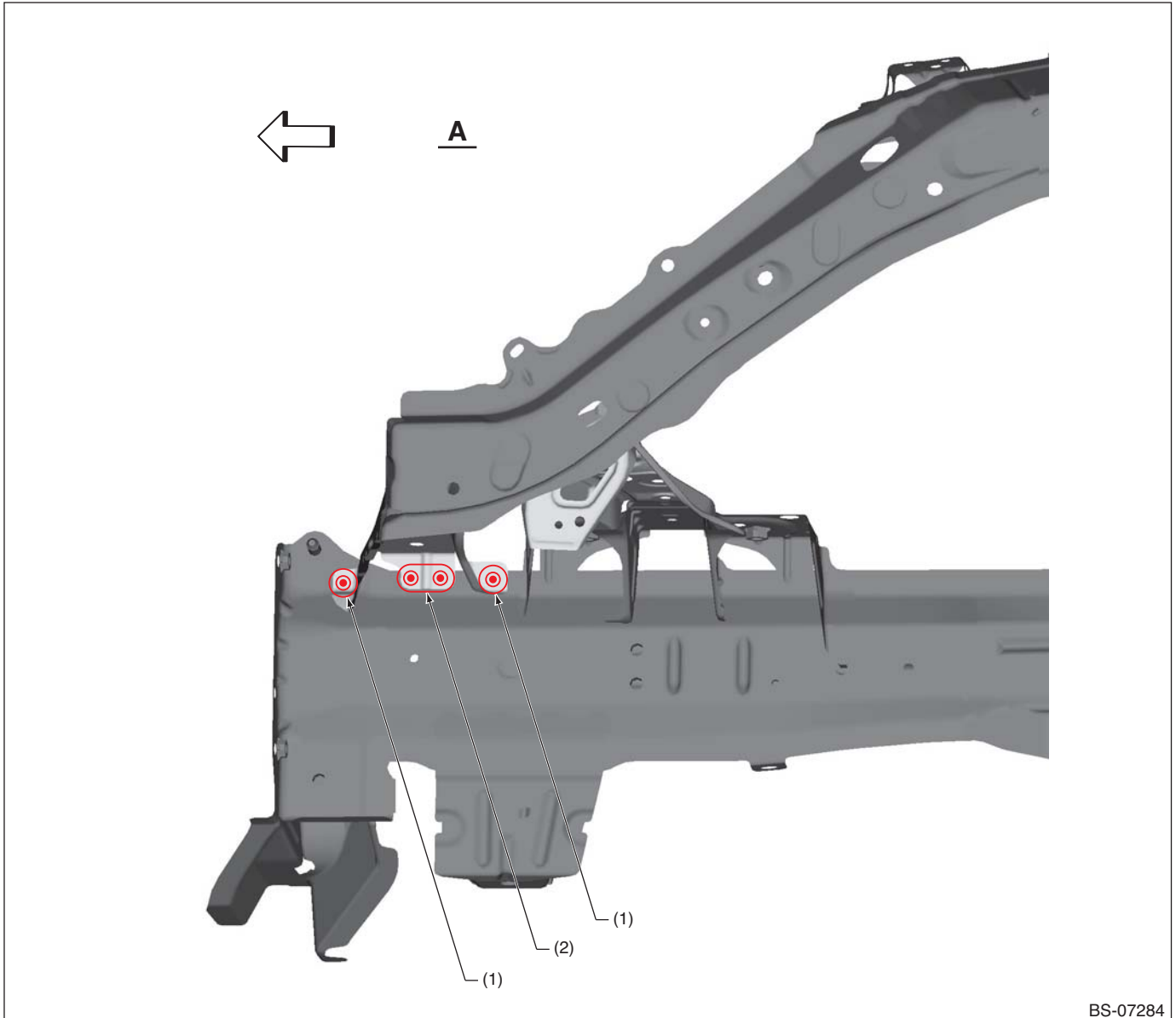
(1) 1 point

(2) 2 points

BS-07283

Panel Replacement

- View A

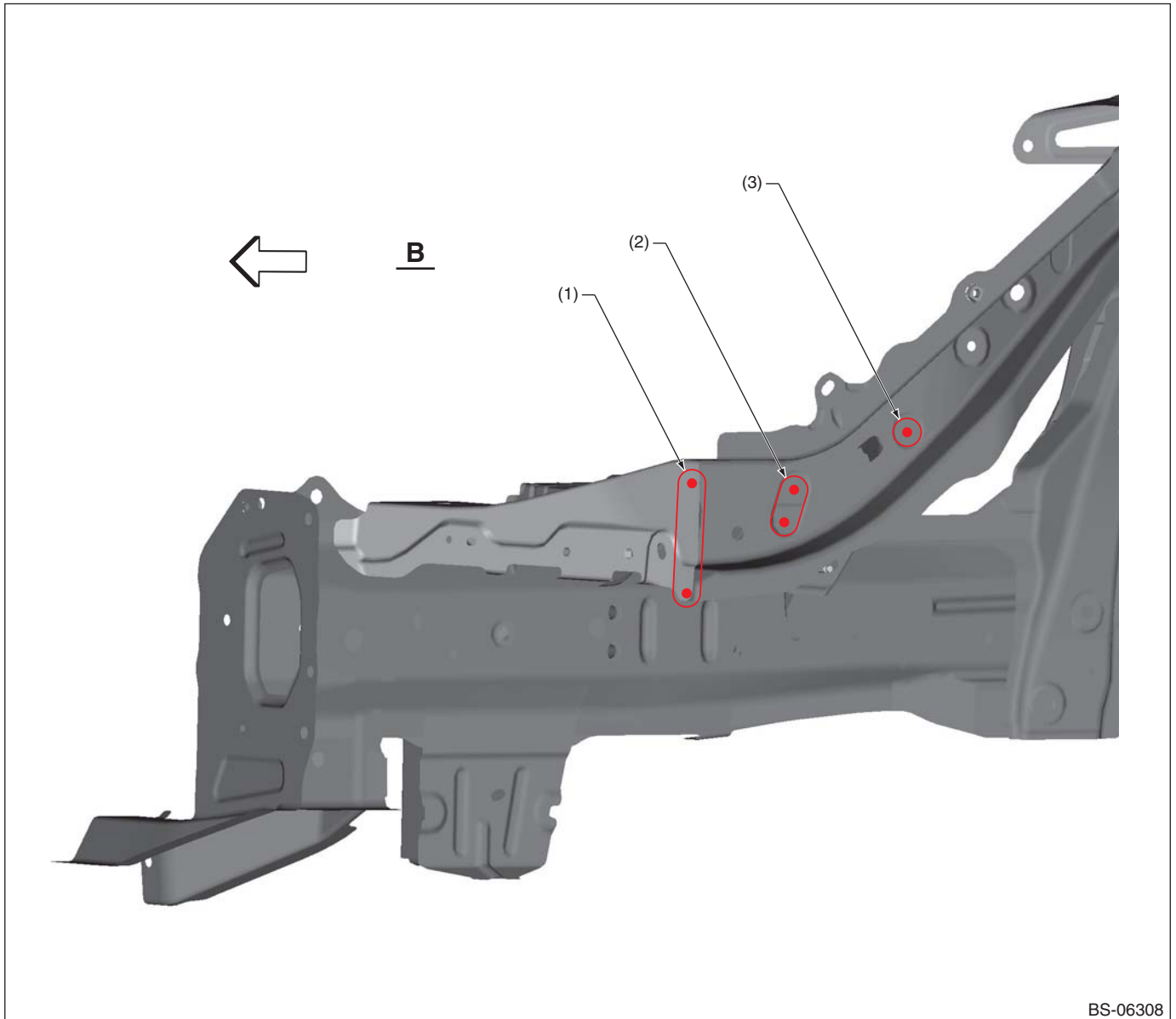


(1) 1 point

(2) 2 points

Panel Replacement

- View B



BS-06308

(1) 3 points

(2) 2 points

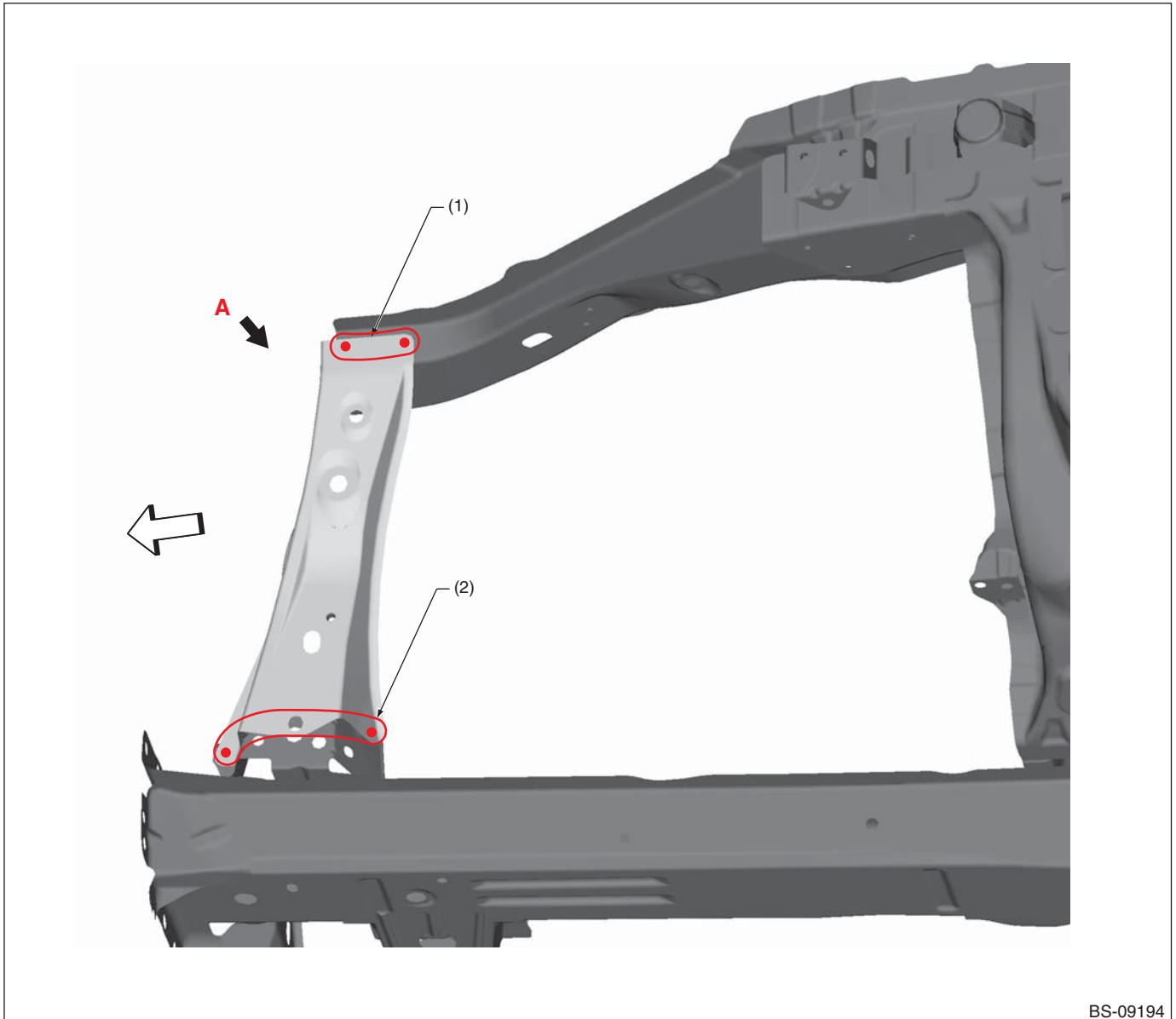
(3) 1 point

Panel Replacement

8-6. Front Wheel Apron RH (Partial replacement)

A: REMOVAL

- Overall view (Radiator panel removal condition) (— '17 MY)



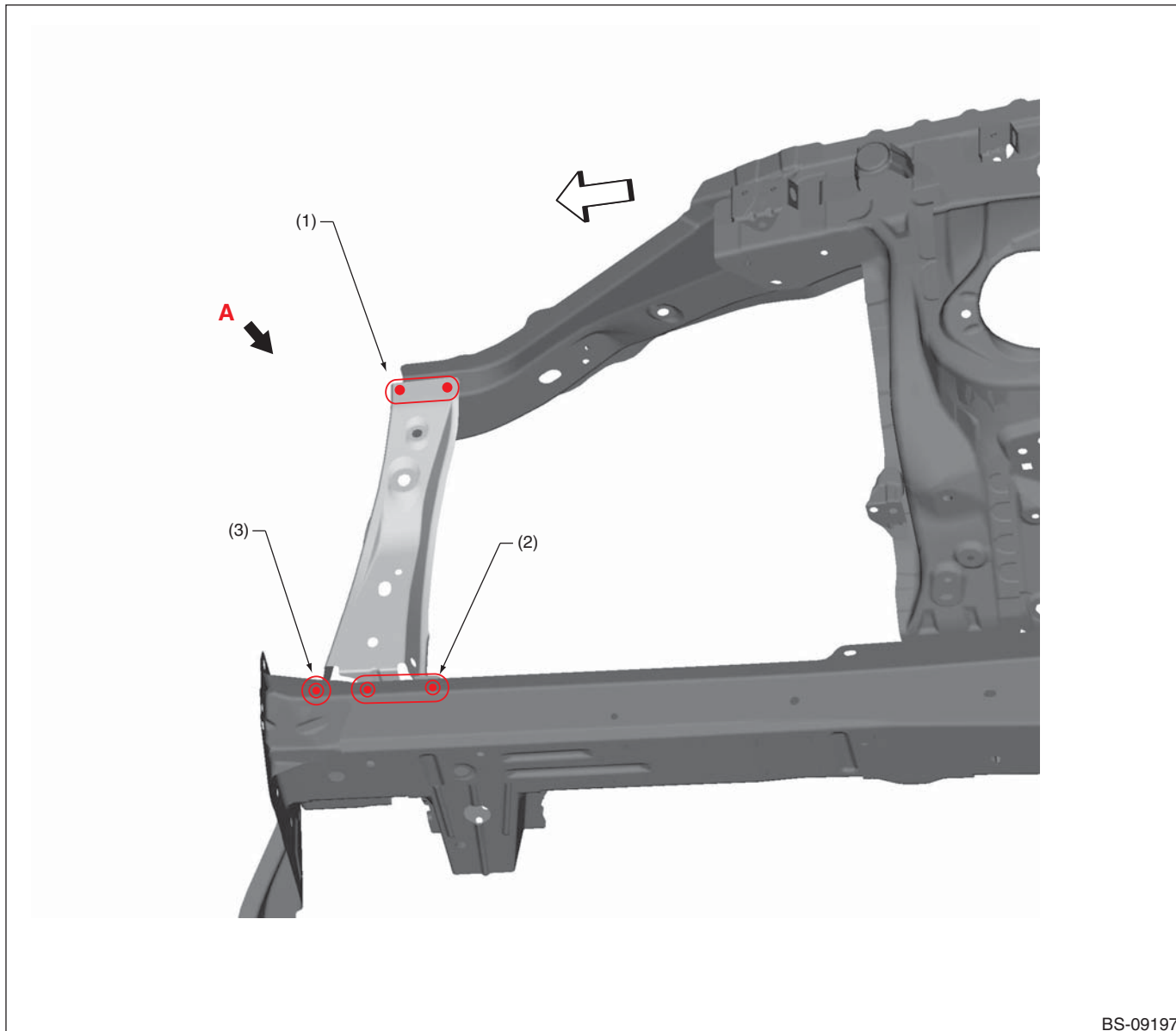
BS-09194

(1) 2 points

(2) 3 points

Panel Replacement

- Overall view (Radiator panel removal condition) ('18 MY —)



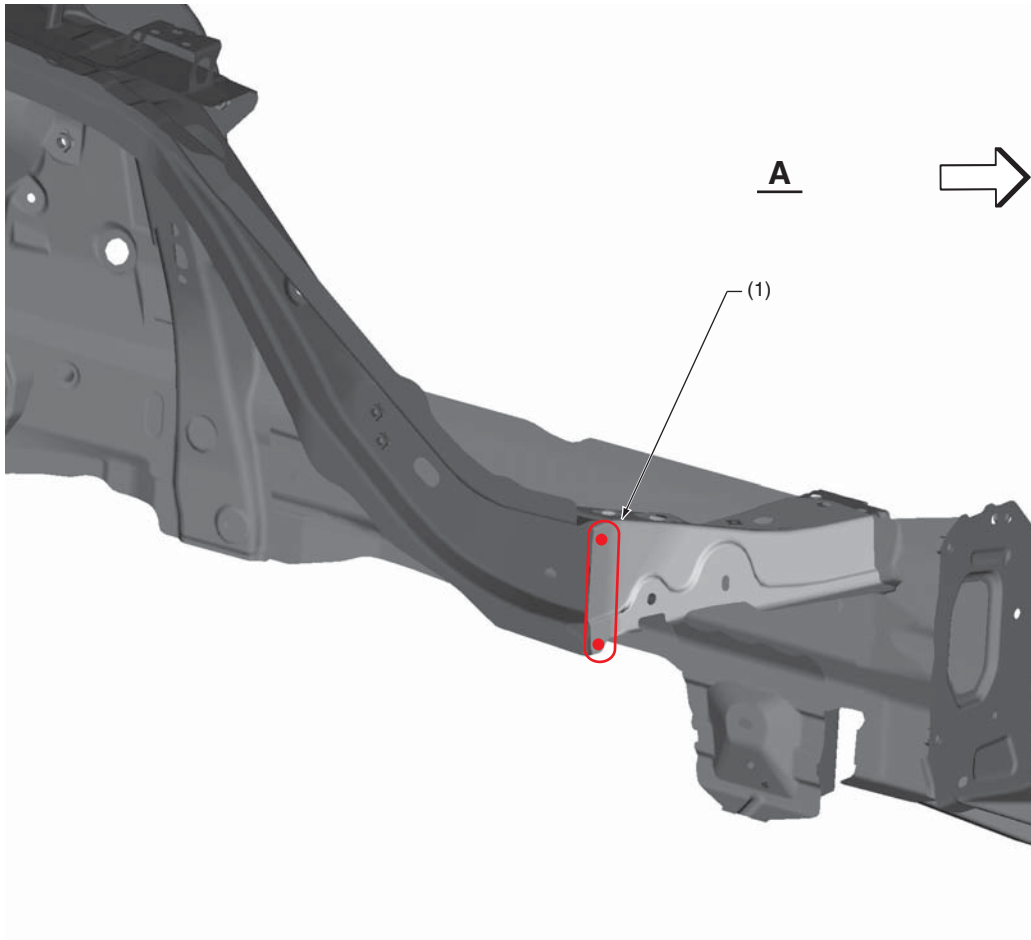
(1) 2 points

(2) 3 points

(3) 1 point

Panel Replacement

- View A (— '17 MY)

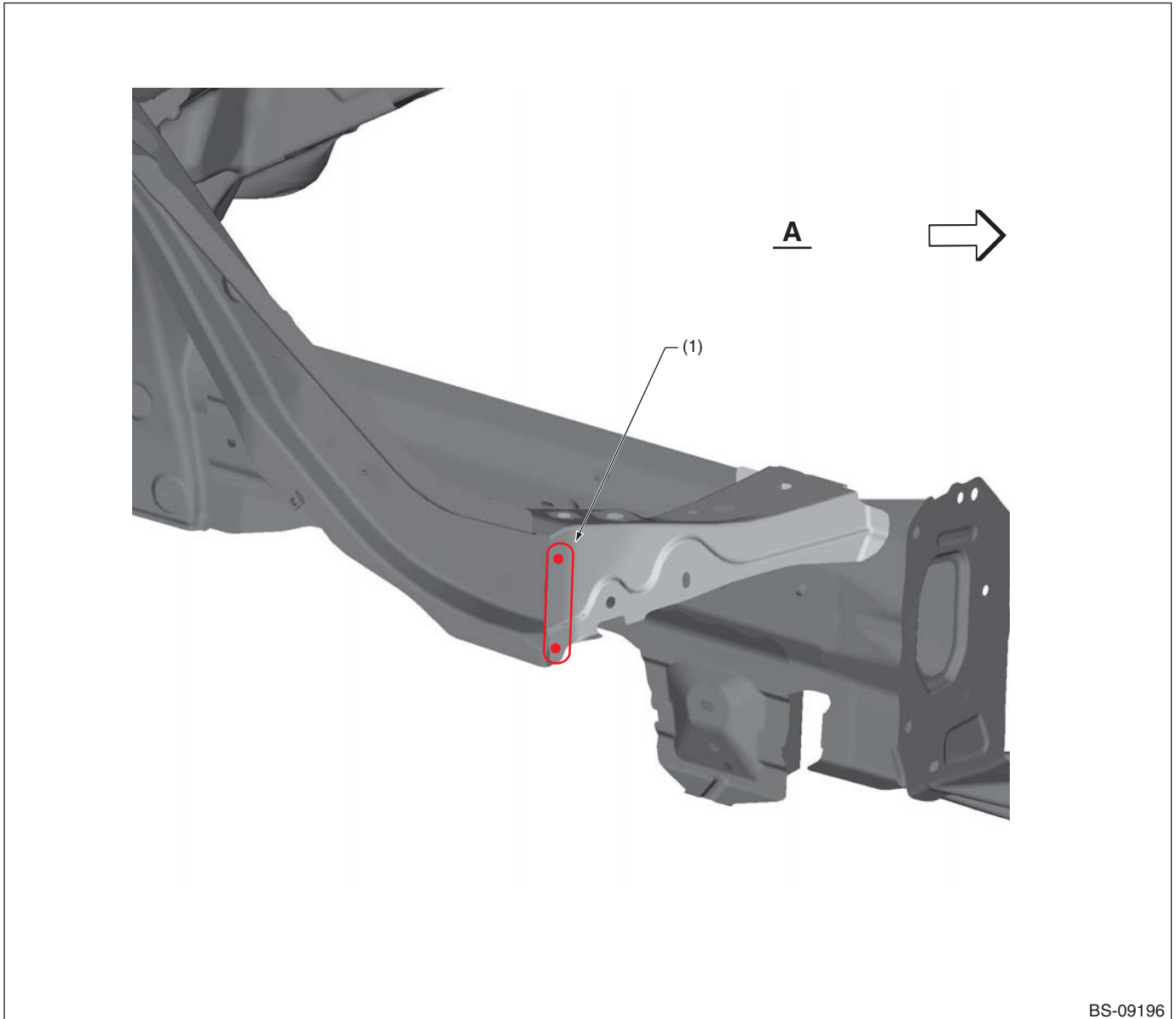


BS-09195

(1) 3 points

Panel Replacement

- View A ('18 MY —)



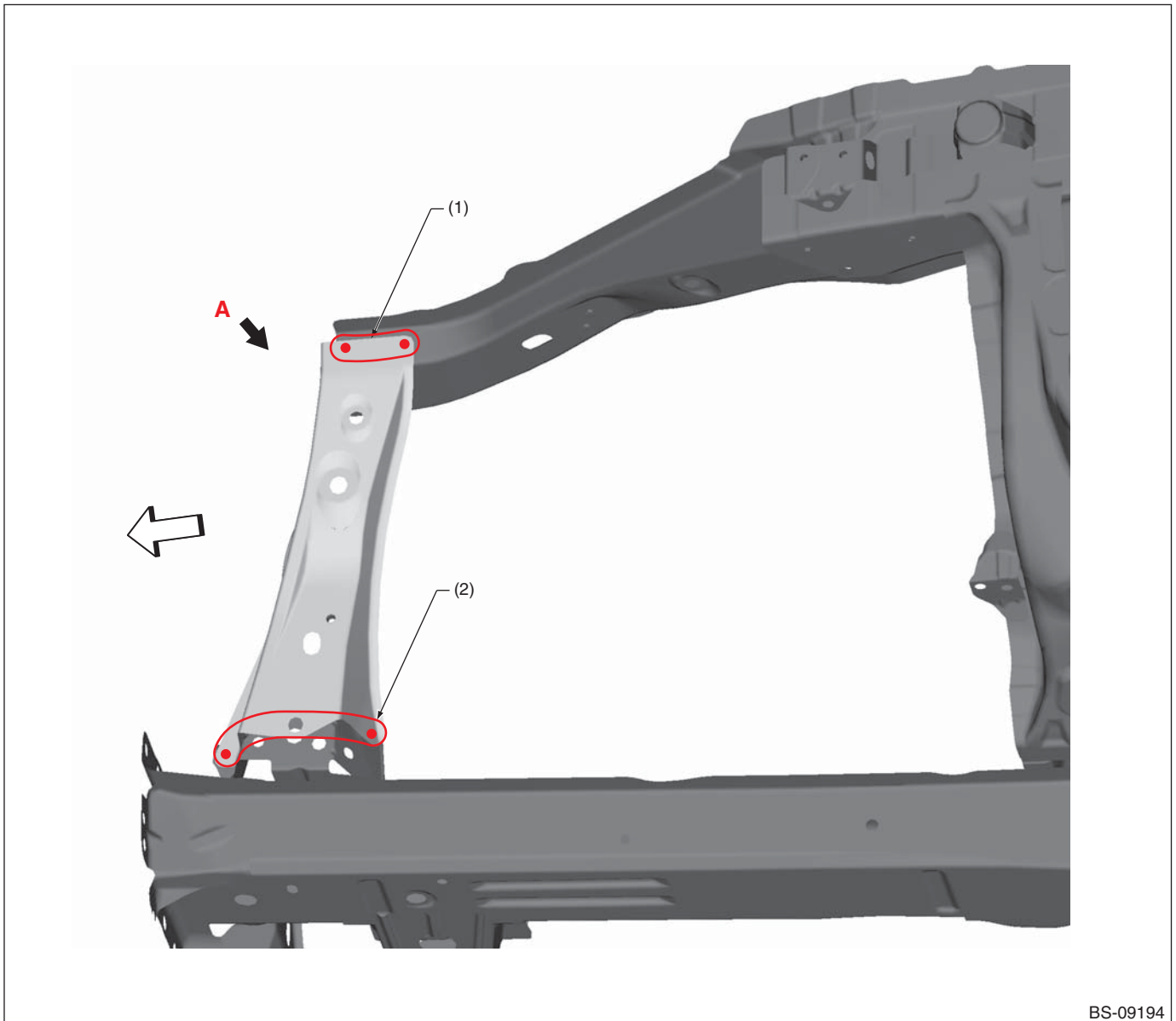
BS-09196

(1) 3 points

Panel Replacement

B: INSTALLATION

• Overall view (— '17 MY)



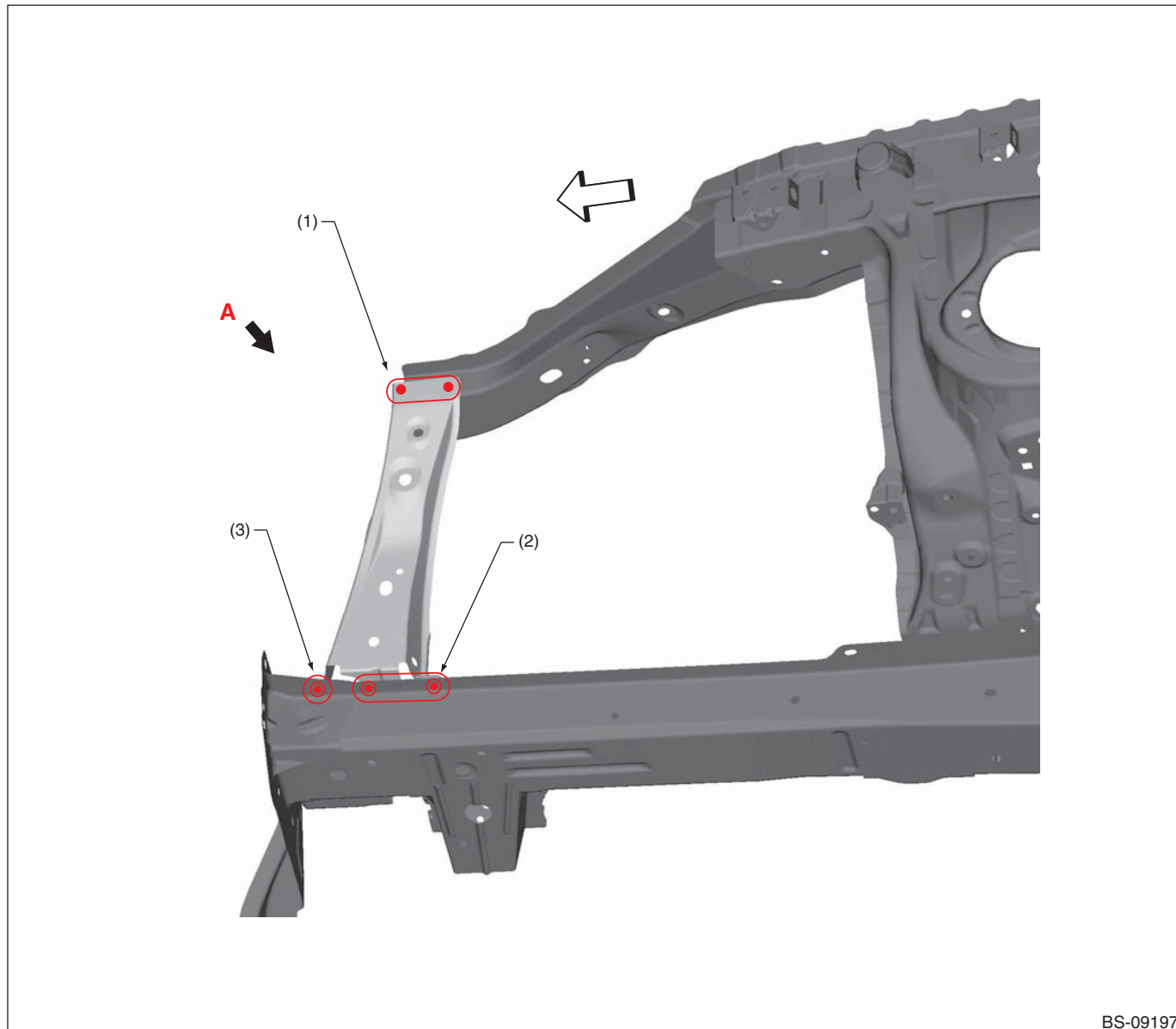
BS-09194

(1) 2 points

(2) 3 points

Panel Replacement

- Overall view ('18 MY —)



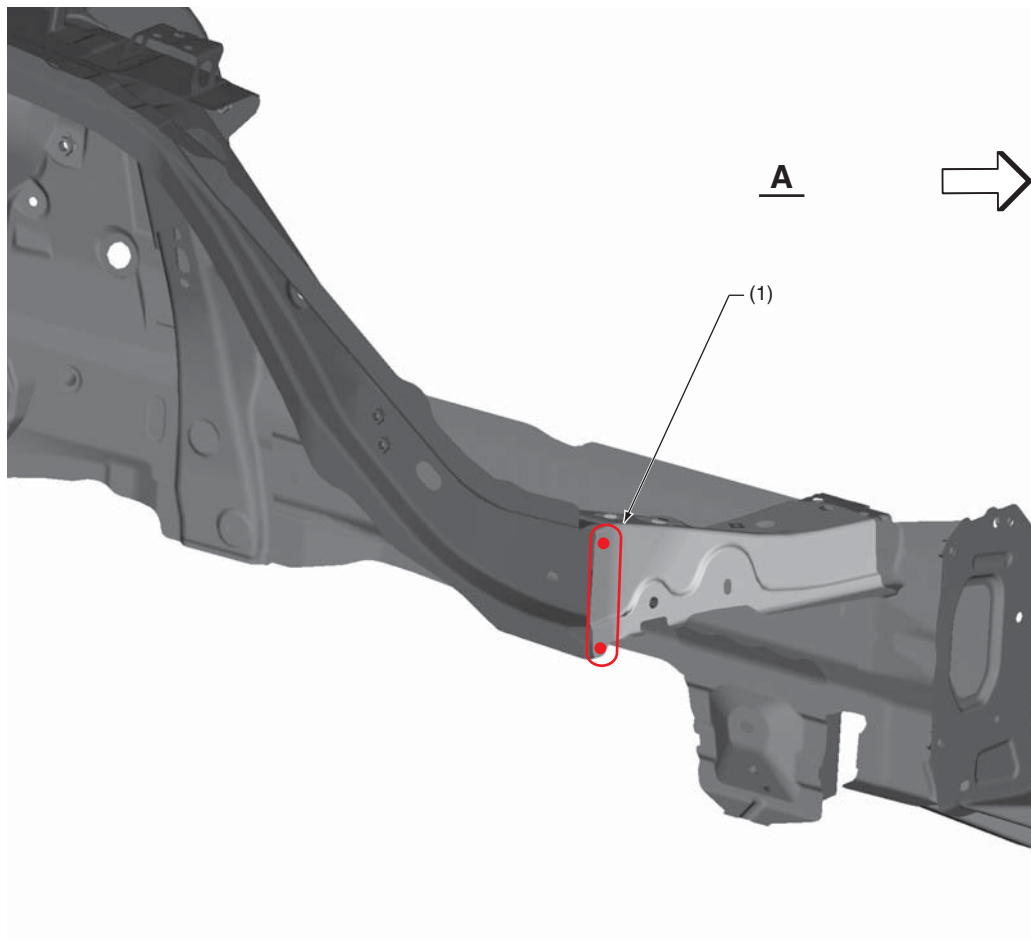
(1) 2 points

(2) 3 points

(3) 1 point

Panel Replacement

- View A (— '17 MY)

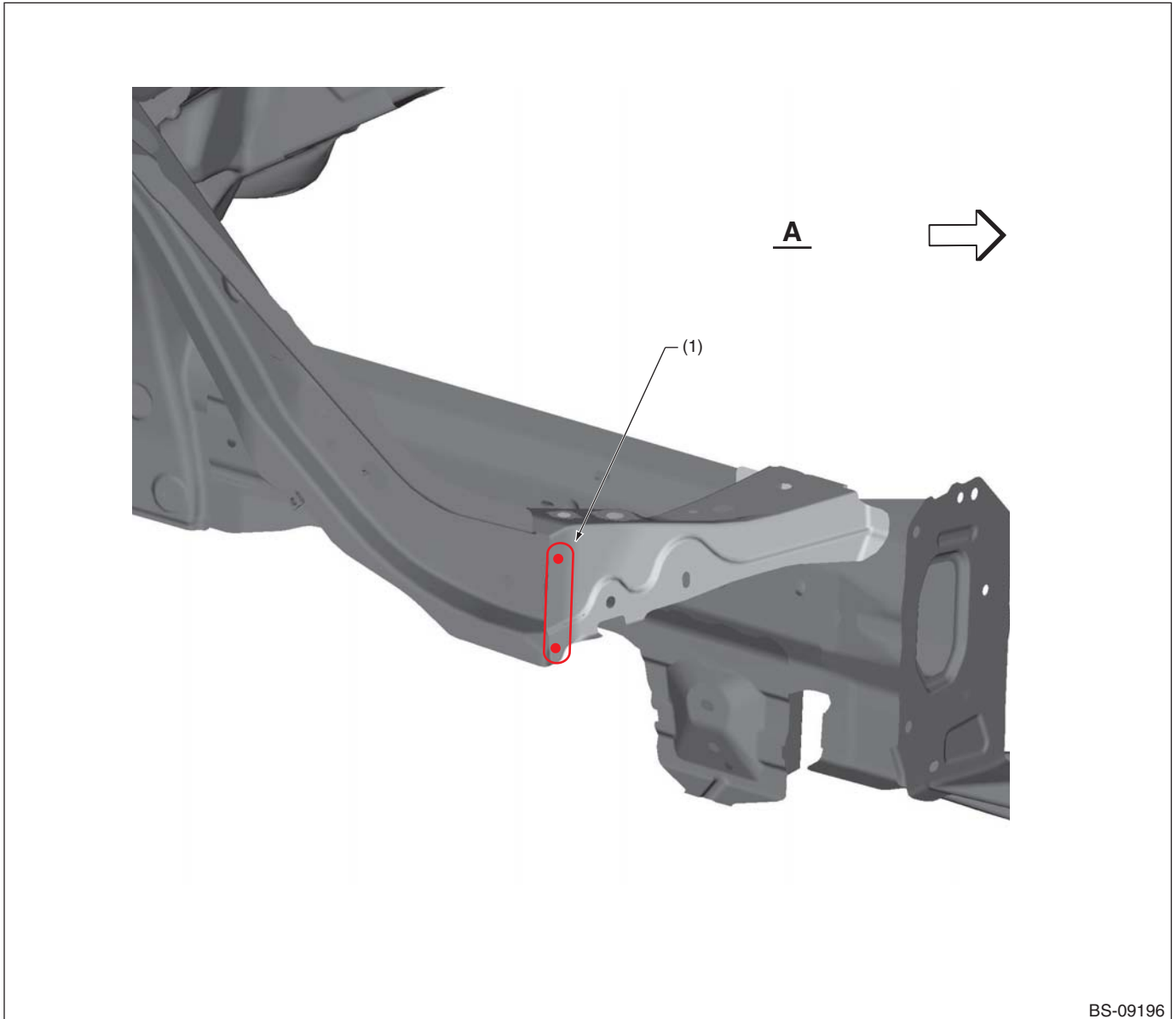


BS-09195

(1) 3 points

Panel Replacement

- View A ('18 MY —)



BS-09196

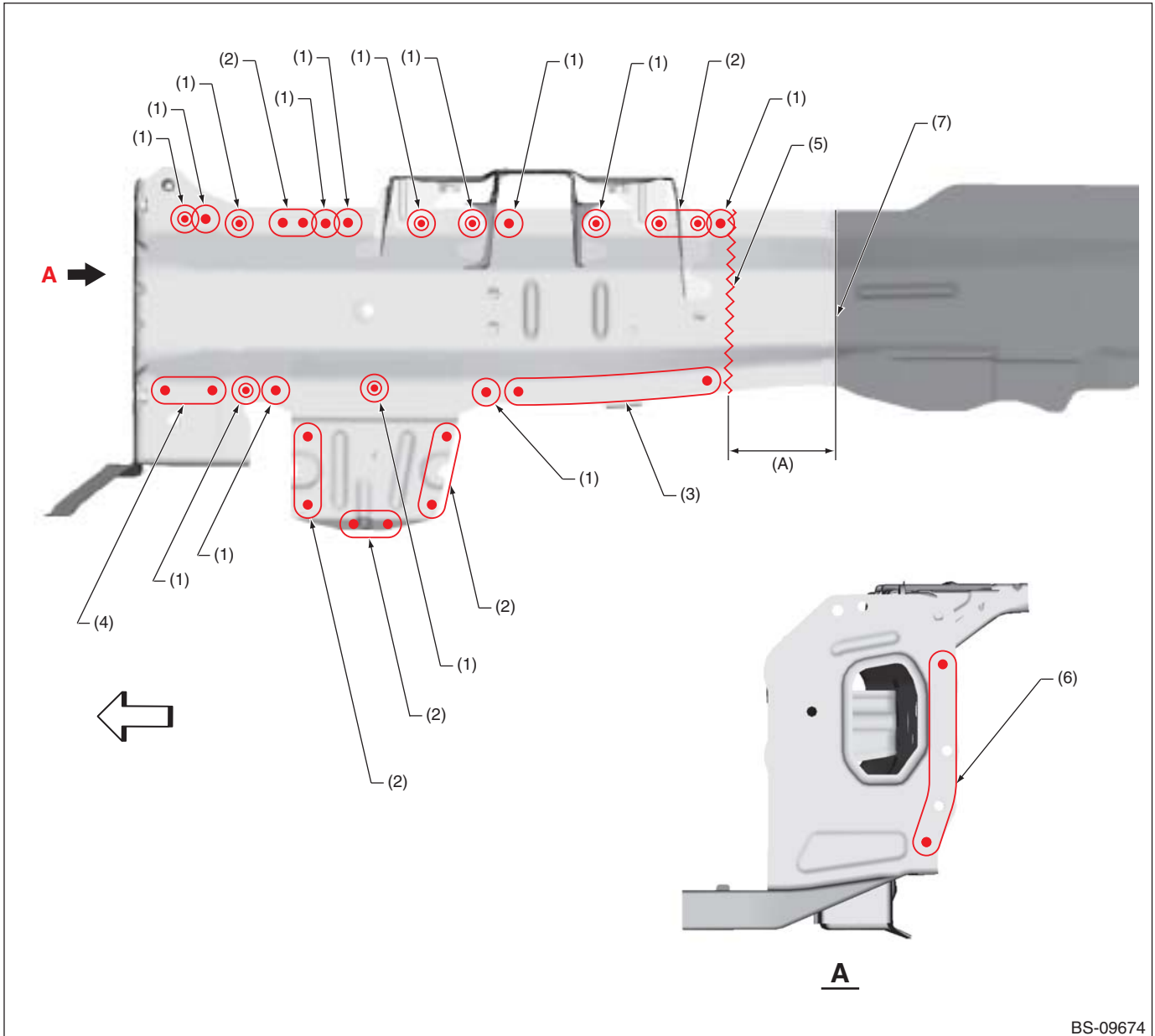
(1) 3 points

Panel Replacement

8-7. Closing Plate LH (Partial replacement)

A: REMOVAL

- Radiator panel and front wheel apron removal condition



BS-09674

(A) 85 mm (3.35 in)

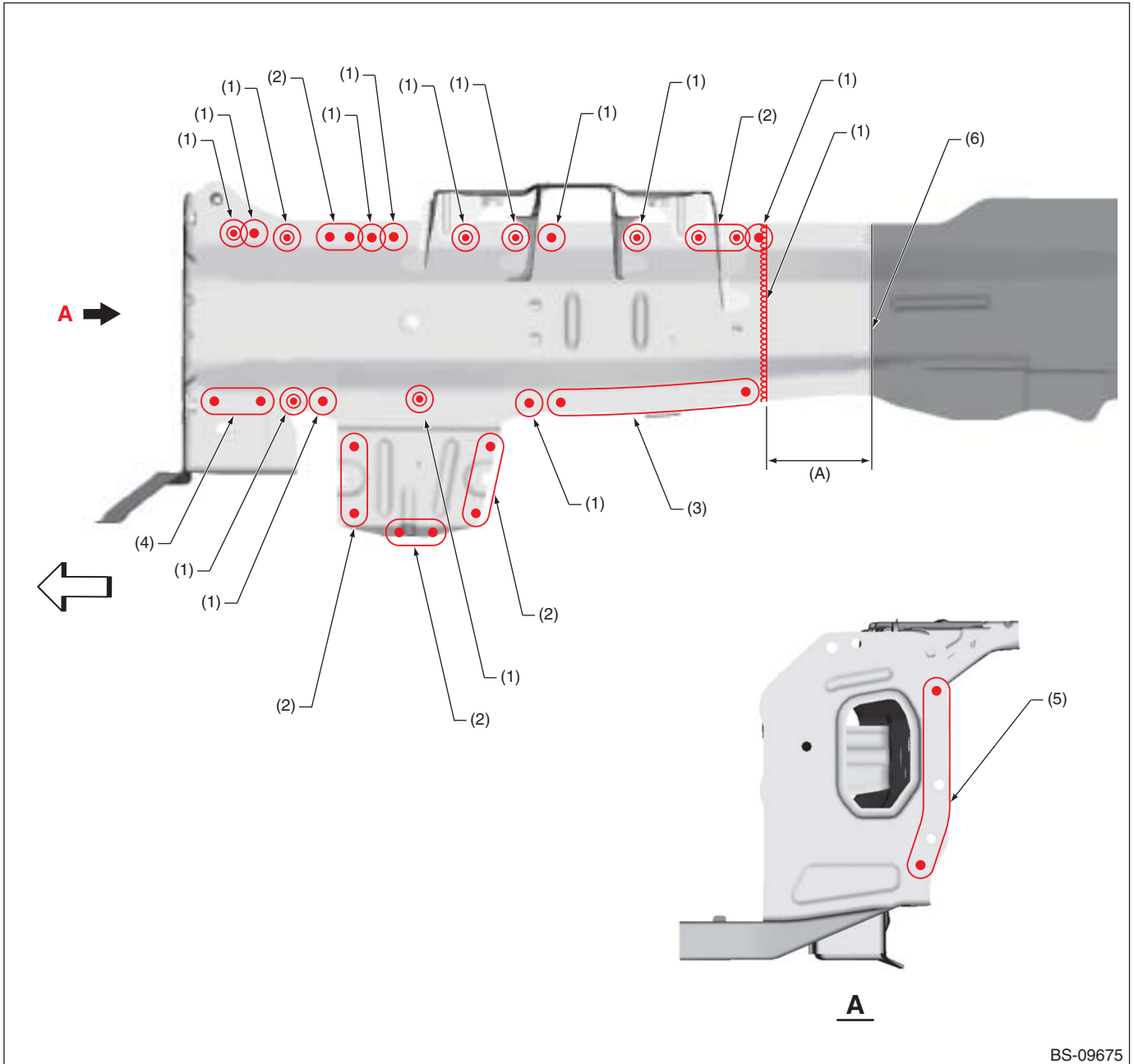
- (1) 1 point
- (2) 2 points
- (3) 5 points

- (4) 3 points
- (5) Cut position

- (6) 4 points
- (7) Tailored line

Panel Replacement

B: INSTALLATION



BS-09675

(A) 85 mm (3.35 in)

(1) 1 point
(2) 2 points

(3) 5 points
(4) 3 points

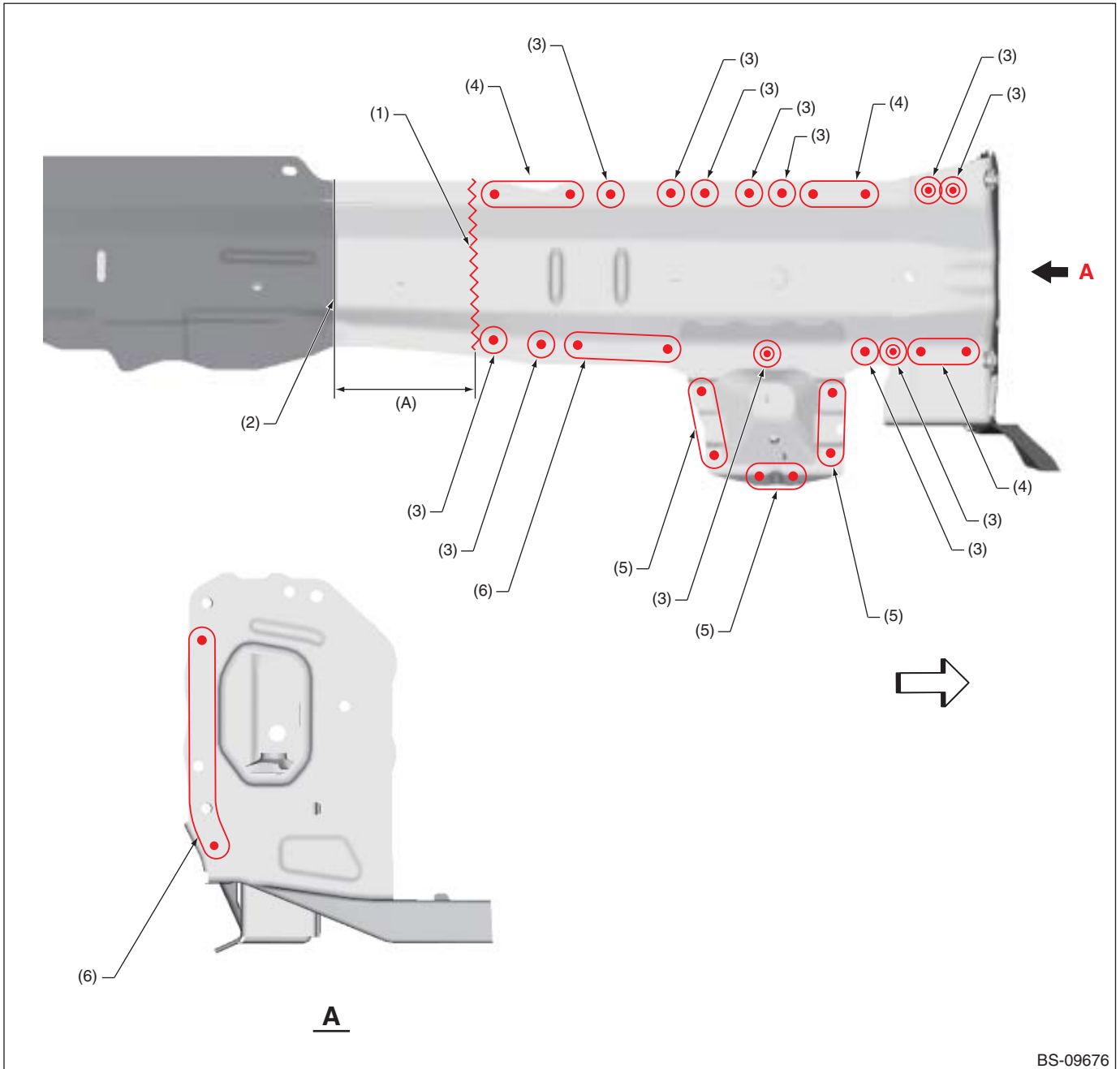
(5) 4 points
(6) Tailored line

Panel Replacement

8-8. Closing Plate RH (Partial replacement)

A: REMOVAL

- Radiator panel and front wheel apron removal condition (— '17 MY)



BS-09676

(A) 110 mm (4.33 in)

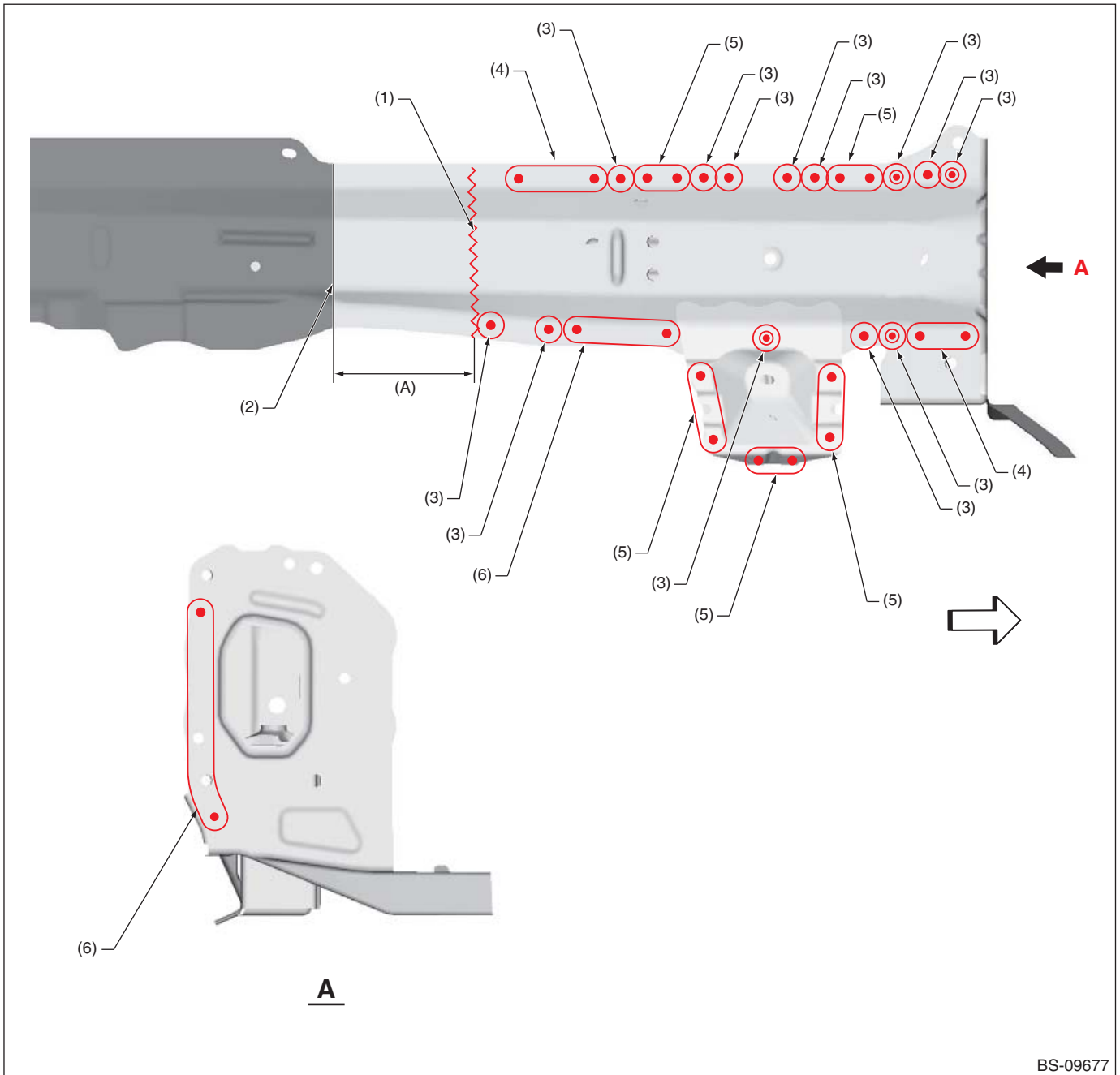
(1) Cut position
(2) Tailored line

(3) 1 point
(4) 3 points

(5) 2 points
(6) 4 points

Panel Replacement

- Radiator panel and front wheel apron removal condition ('18 MY —)



(A) 110 mm (4.33 in)

(1) Cut position
(2) Tailored line

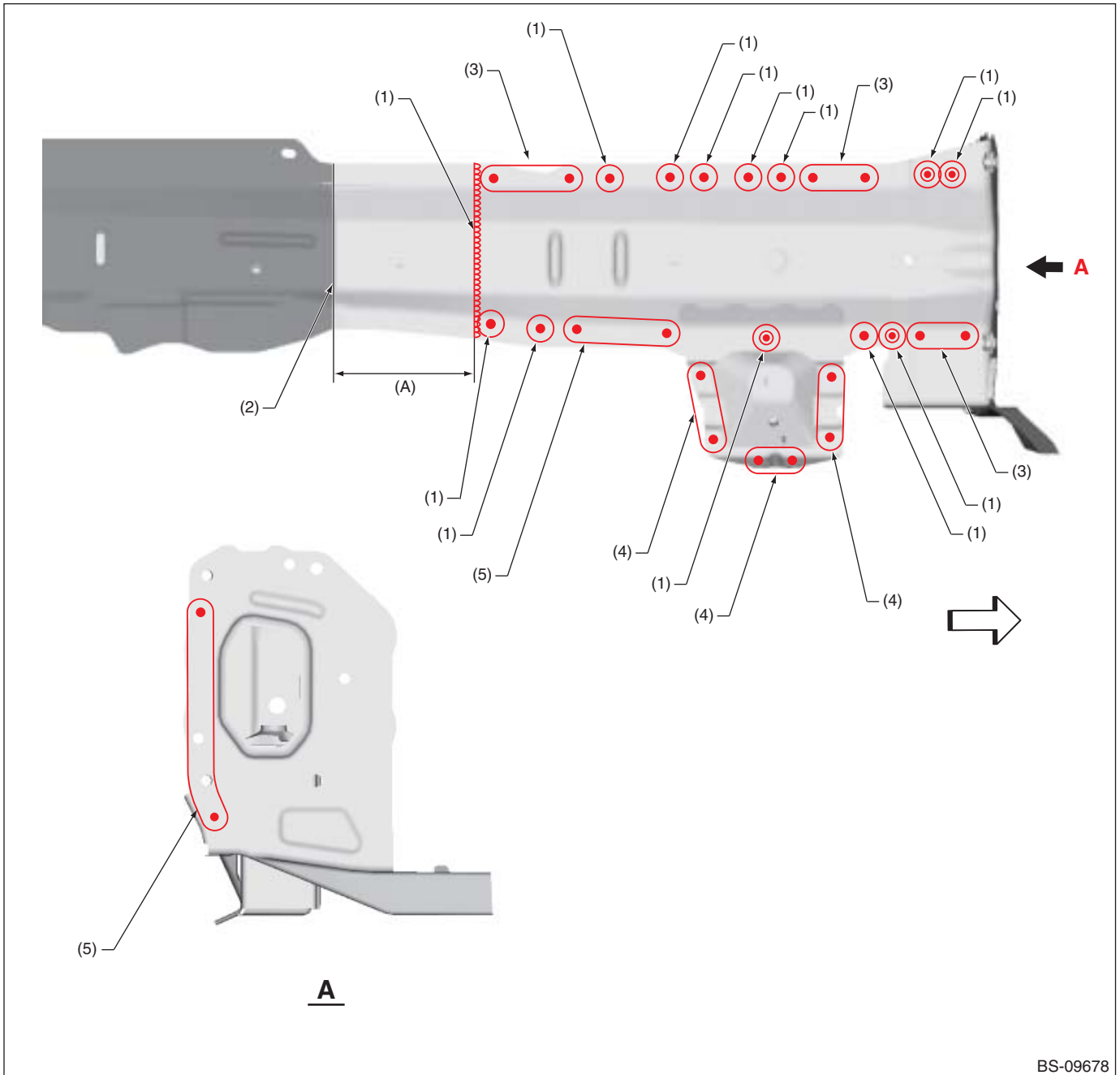
(3) 1 point
(4) 3 points

(5) 2 points
(6) 4 points

Panel Replacement

B: INSTALLATION

• — '17 MY



BS-09678

(A) 110 mm (4.33 in)

(1) 1 point

(2) Tailored line

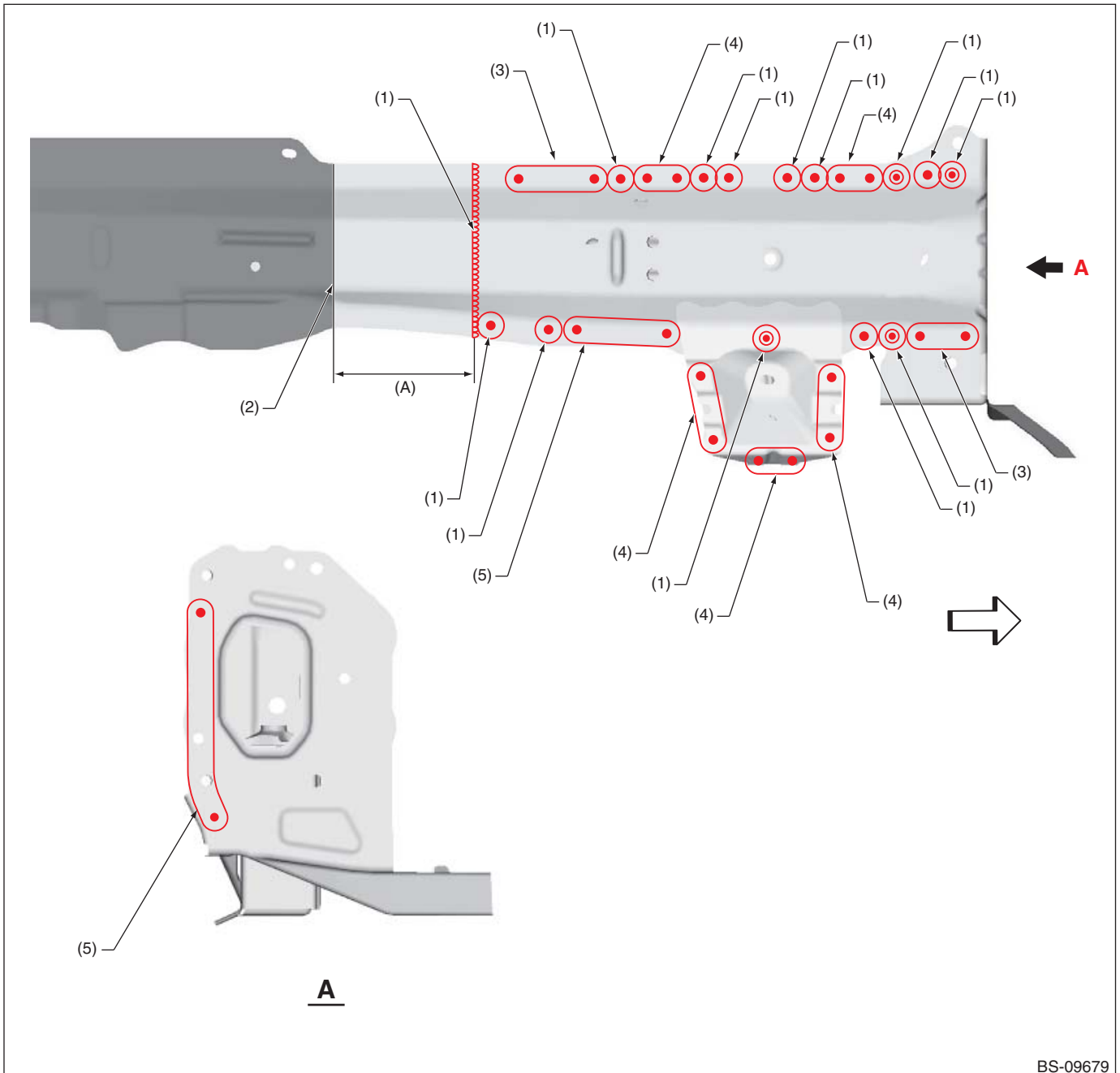
(3) 3 points

(4) 2 points

(5) 4 points

Panel Replacement

• '18 MY —



(A) 110 mm (4.33 in)

(1) 1 point

(2) Tailored line

(3) 3 points

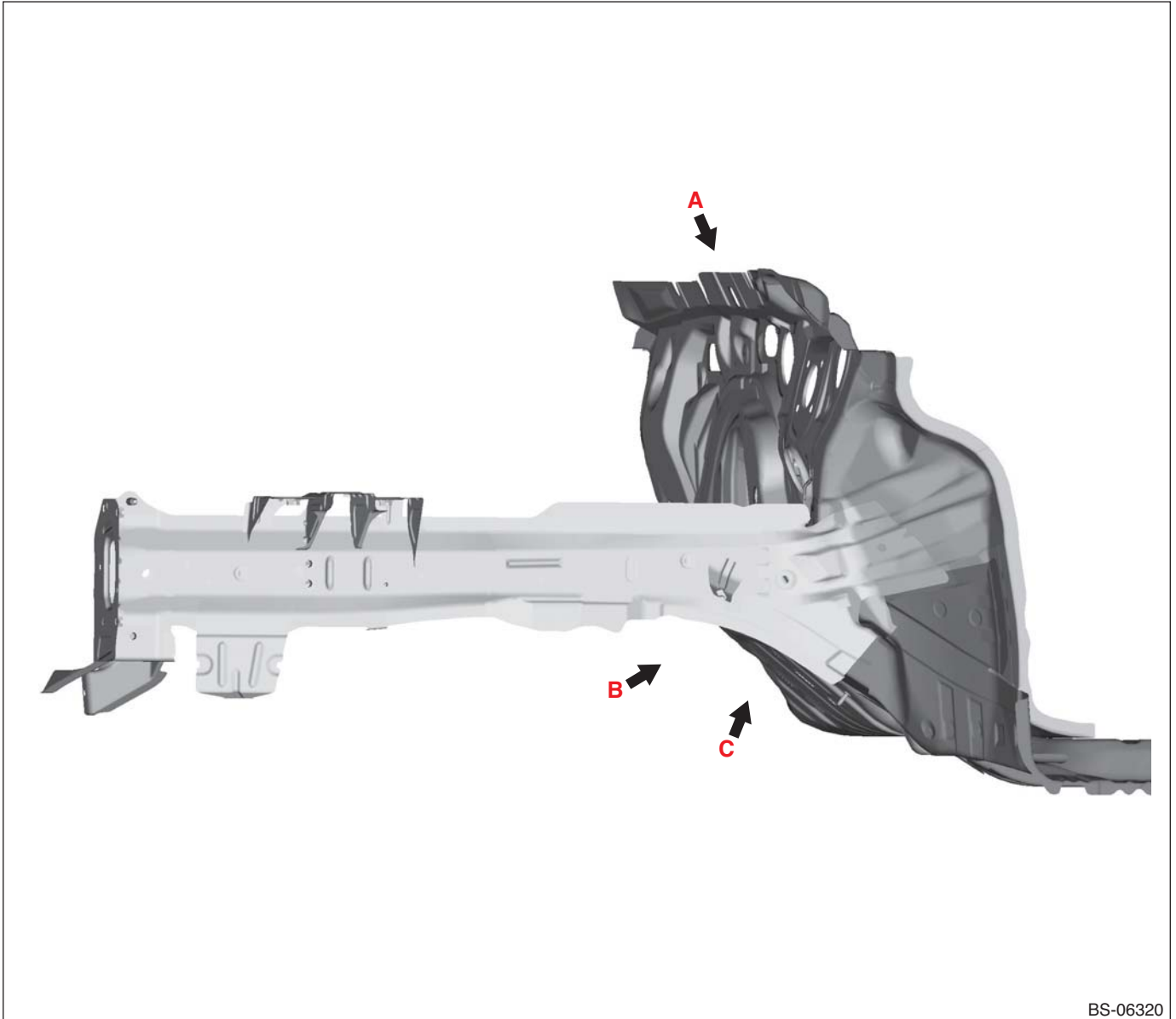
(4) 2 points

(5) 4 points

8-9. Front Side Frame (Total replacement)

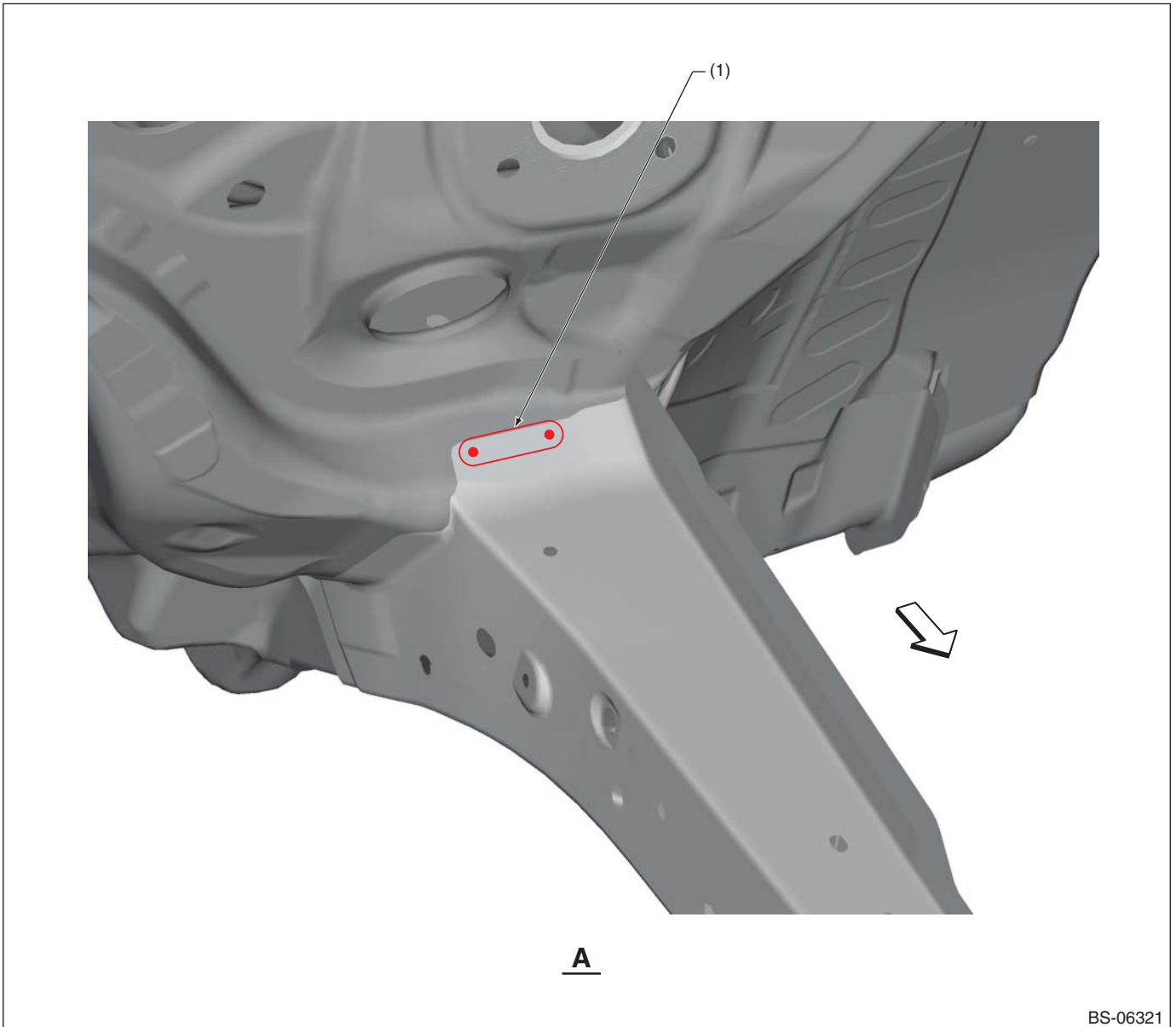
A: REMOVAL

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



Panel Replacement

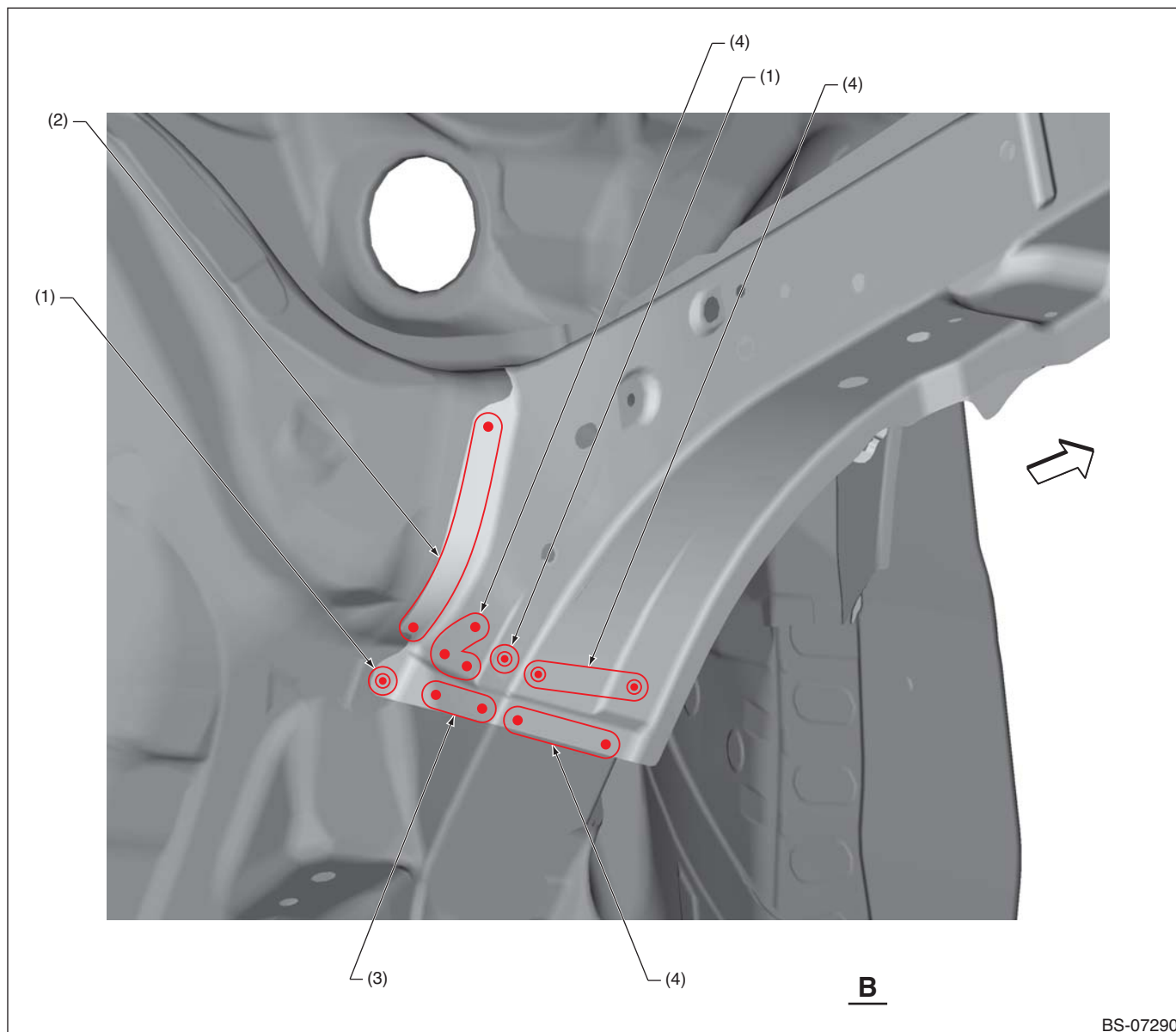
- View A



(1) 2 points

Panel Replacement

- View B



BS-07290

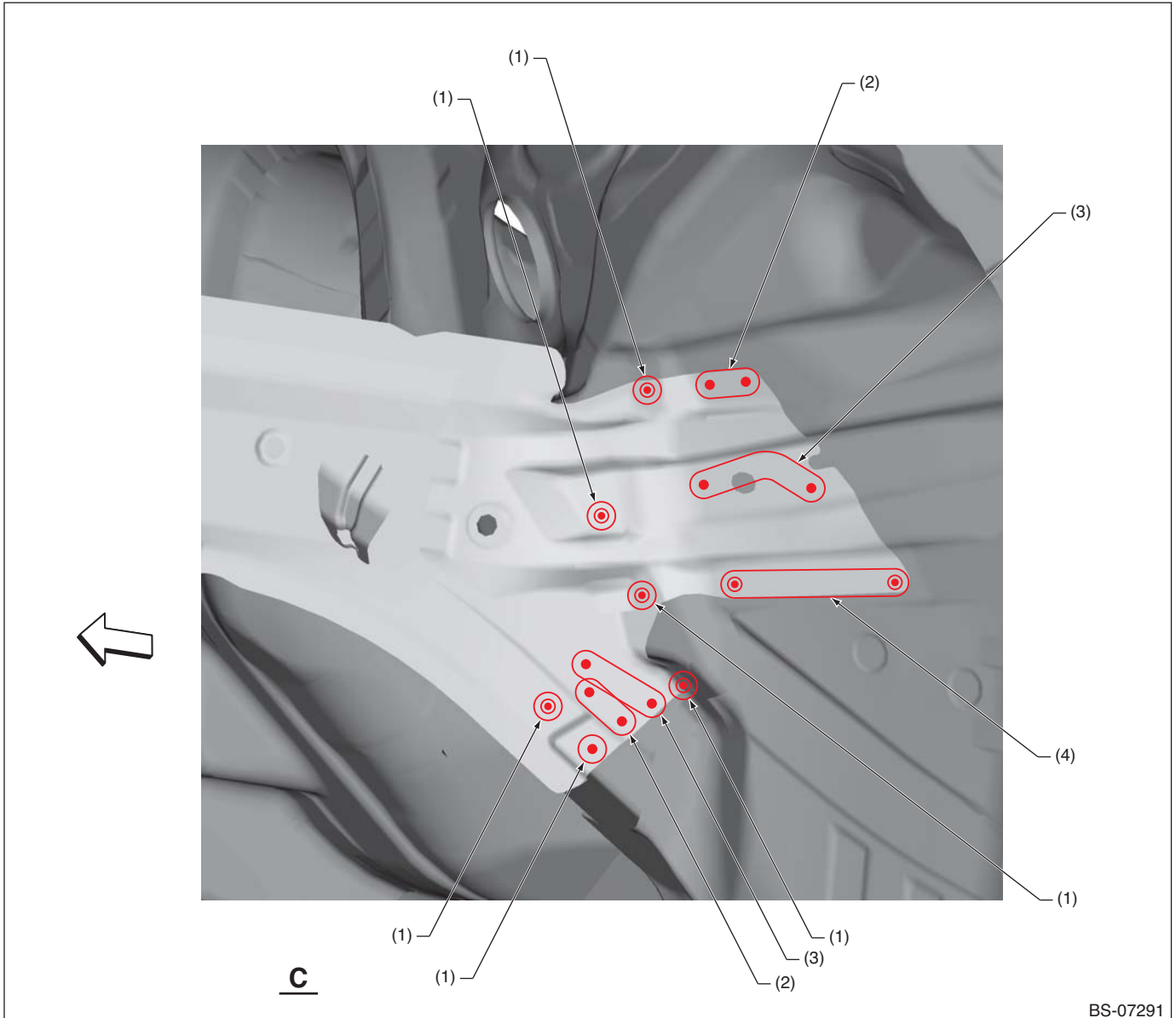
(1) 1 point
(2) 5 points

(3) 2 points

(4) 3 points

Panel Replacement

- View C



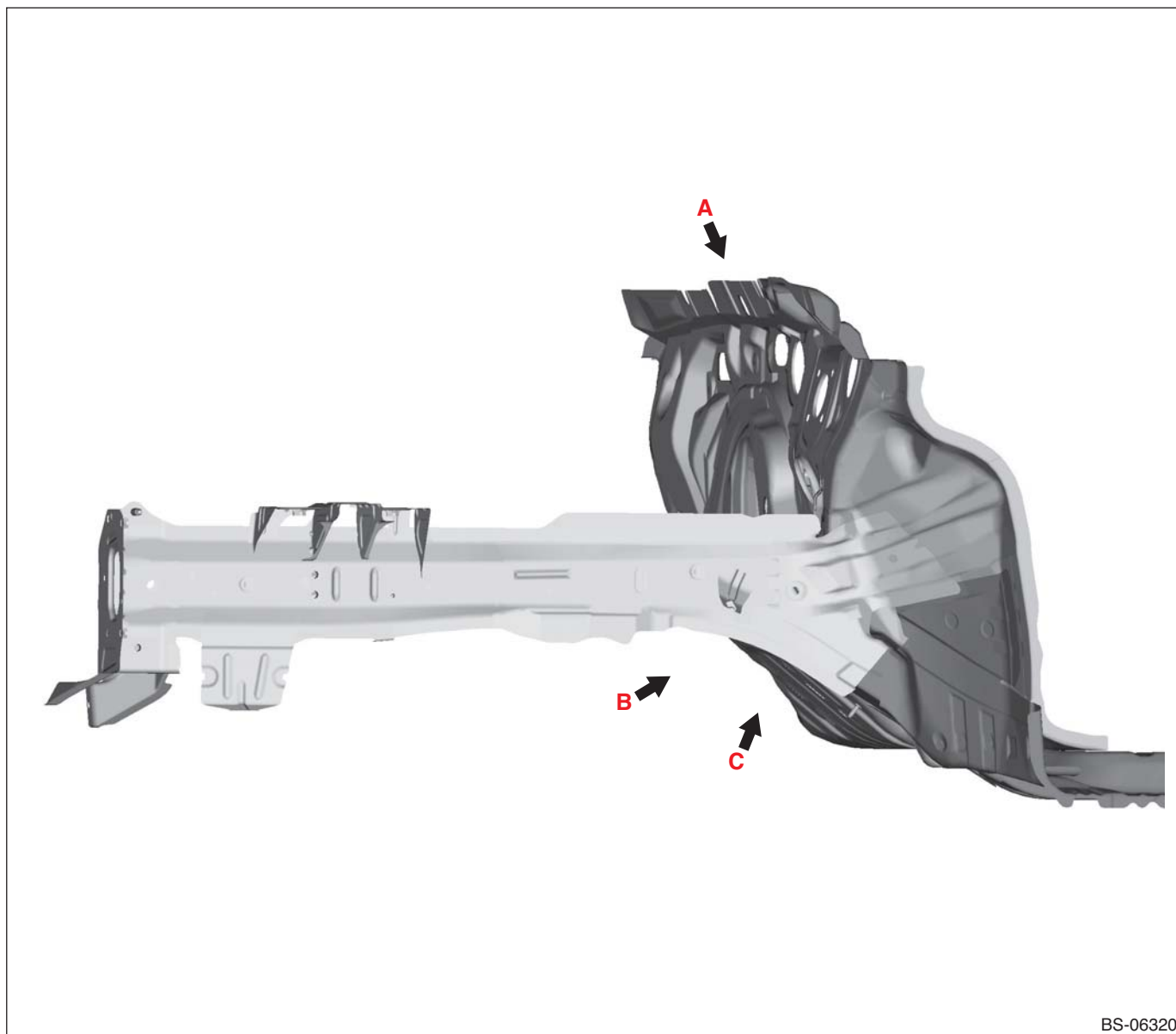
(1) 1 point
(2) 2 points

(3) 3 points

(4) 4 points

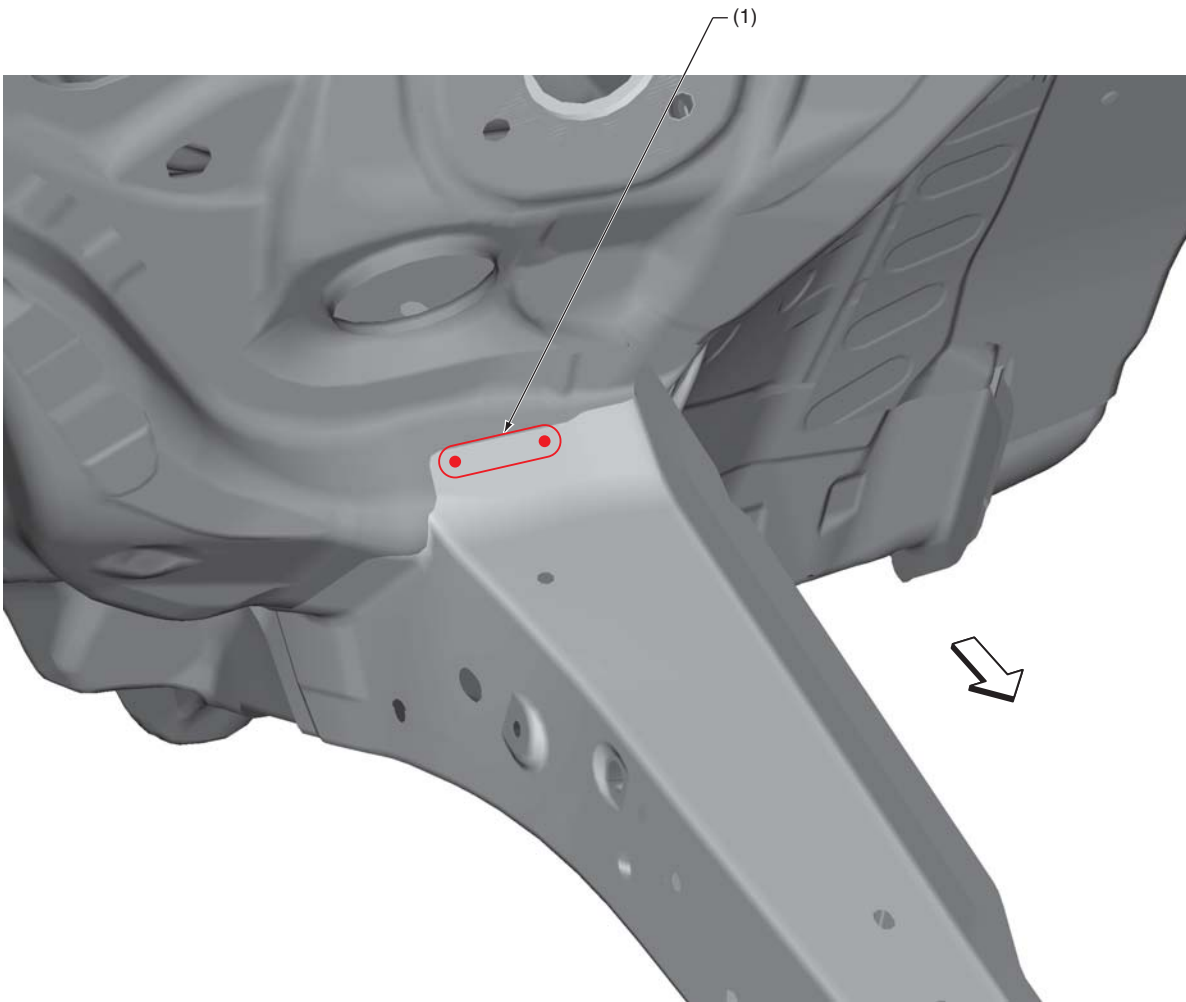
B: INSTALLATION

- Overall view



Panel Replacement

- View A

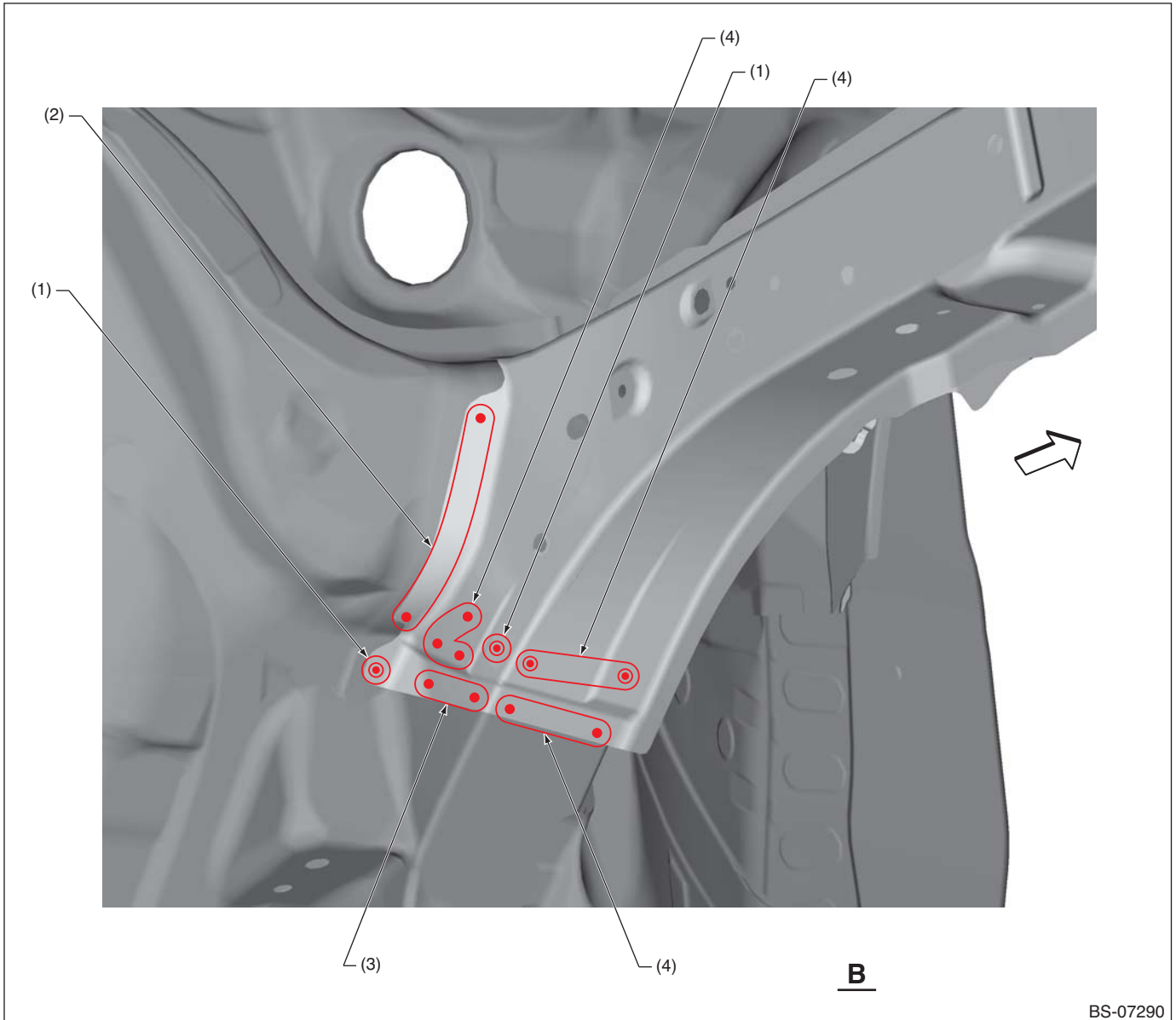


BS-06321

(1) 2 points

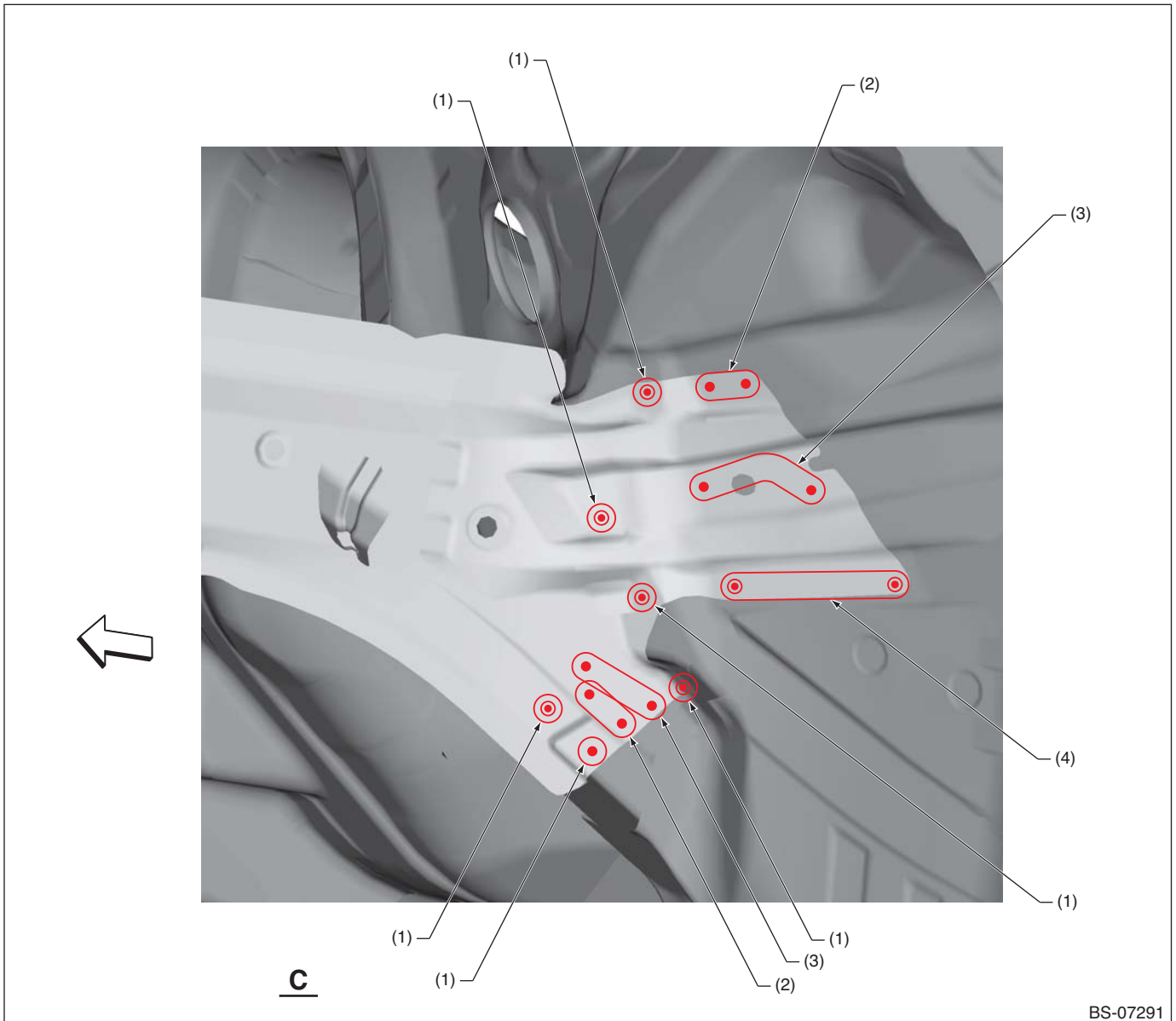
Panel Replacement

- View B



Panel Replacement

- View C



(1) 1 point
(2) 2 points

(3) 3 points

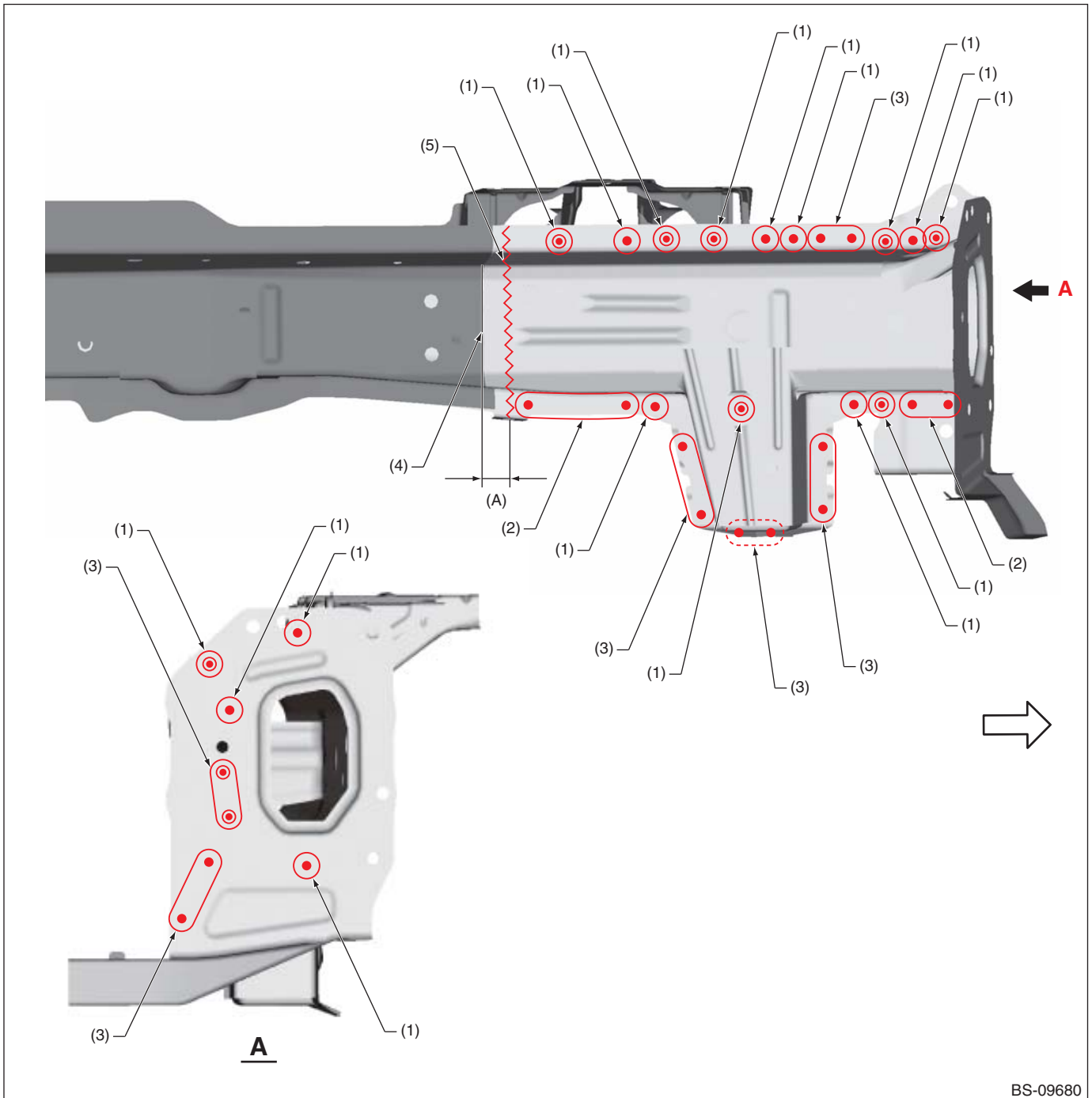
(4) 4 points

Panel Replacement

8-10. Front Side Frame LH (Partial replacement)

A: REMOVAL

- Radiator panel and front wheel apron removal condition



(A) 10 mm (0.39 in)

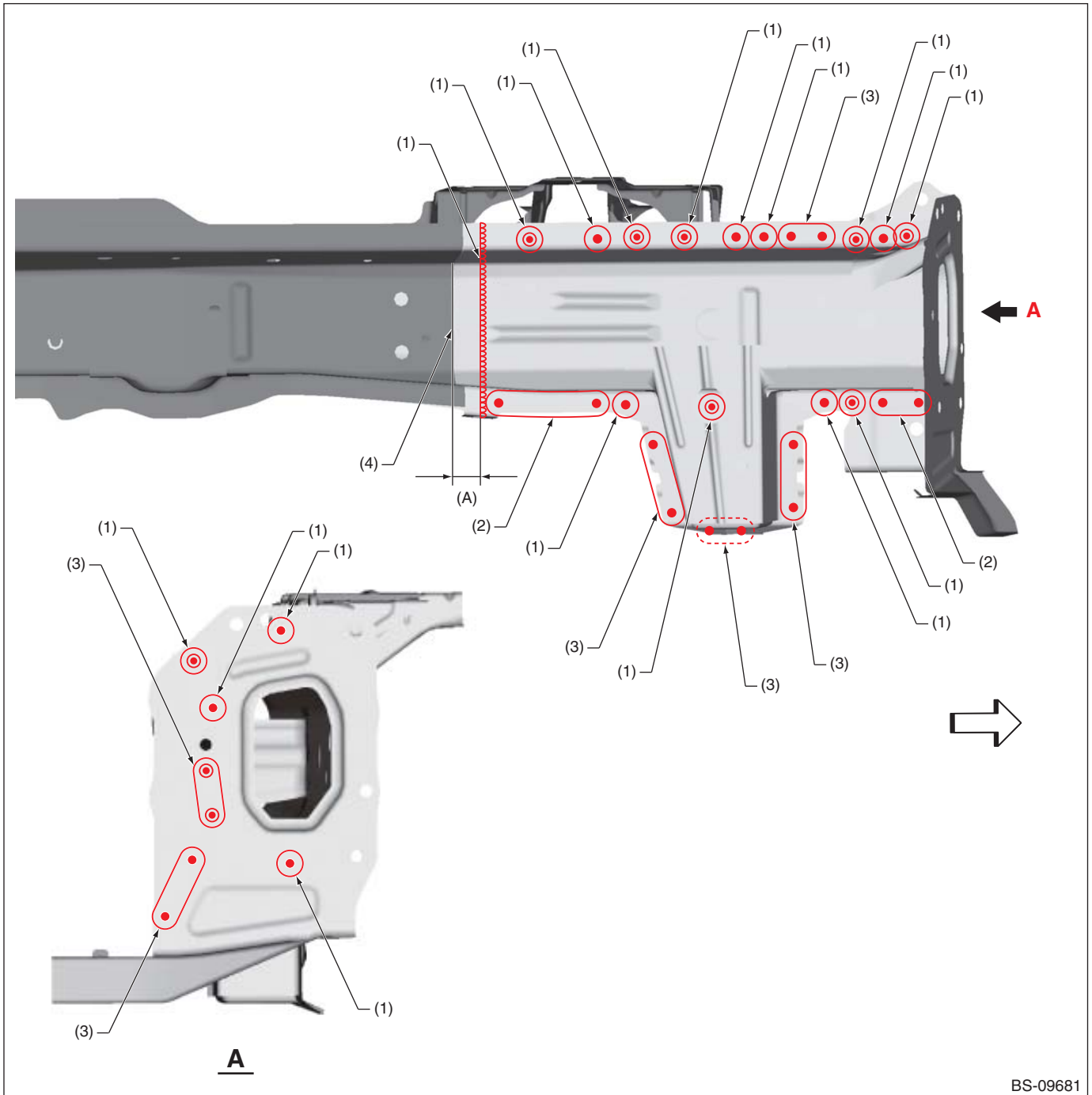
(1) 1 point
(2) 3 points

(3) 2 points
(4) Tailored line

(5) Cut position

Panel Replacement

B: INSTALLATION



(A) 10 mm (0.39 in)

(1) 1 point
(2) 3 points

(3) 2 points

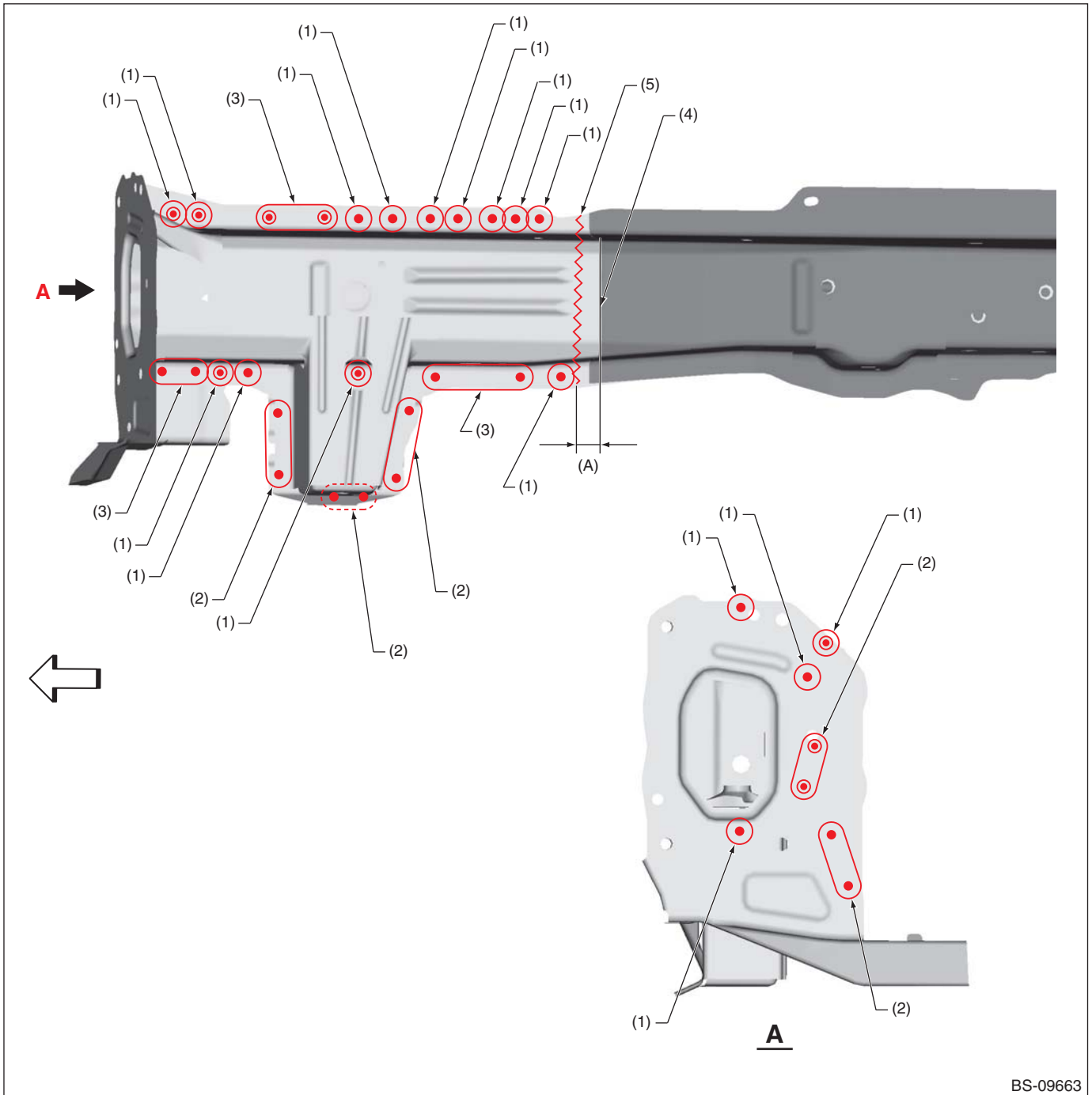
(4) Tailored line

Panel Replacement

8-11. Front Side Frame RH (Partial replacement)

A: REMOVAL

- Radiator panel and front wheel apron removal condition (— '17 MY)



BS-09663

(A) 10 mm (0.39 in)

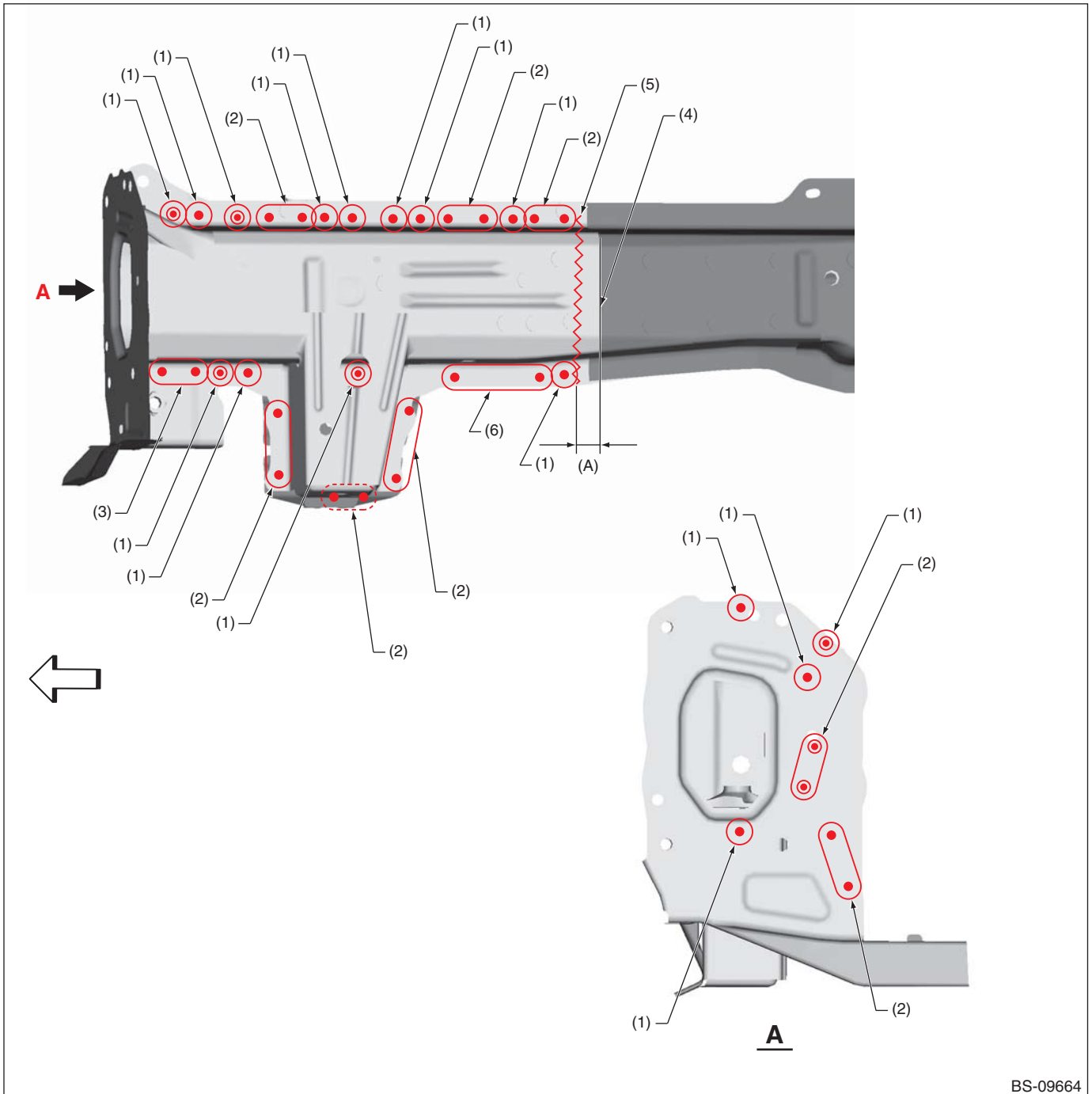
(1) 1 point
(2) 2 points

(3) 3 points
(4) Tailored line

(5) Cut position

Panel Replacement

- Radiator panel and front wheel apron removal condition ('18 MY —)



BS-09664

(A) 10 mm (0.39 in)

(1) 1 point
(2) 2 points

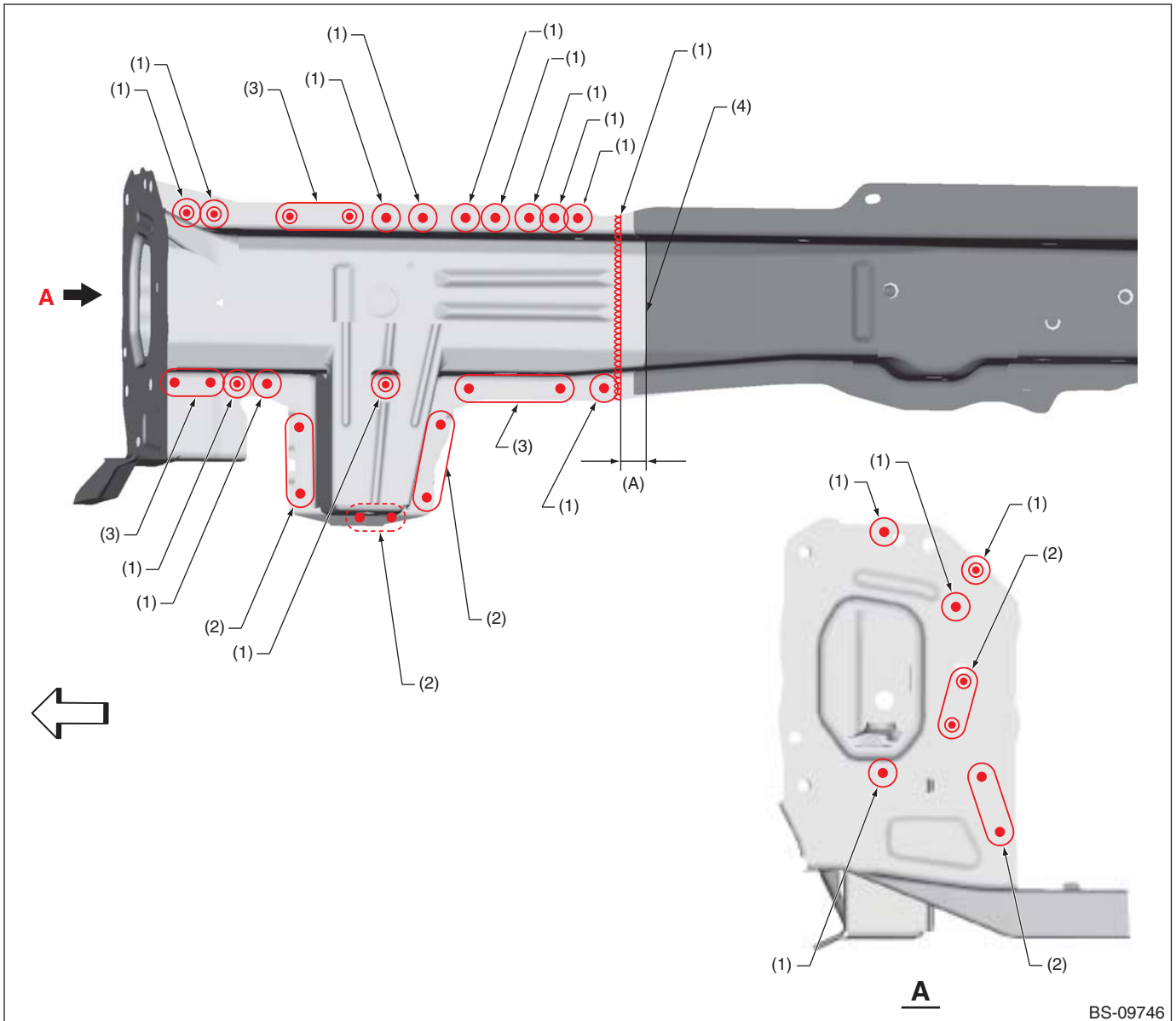
(3) 3 points
(4) Tailored line

(5) Cut position
(6) 4 points

Panel Replacement

B: INSTALLATION

• — '17 MY



BS-09746

(A) 10 mm (0.39 in)

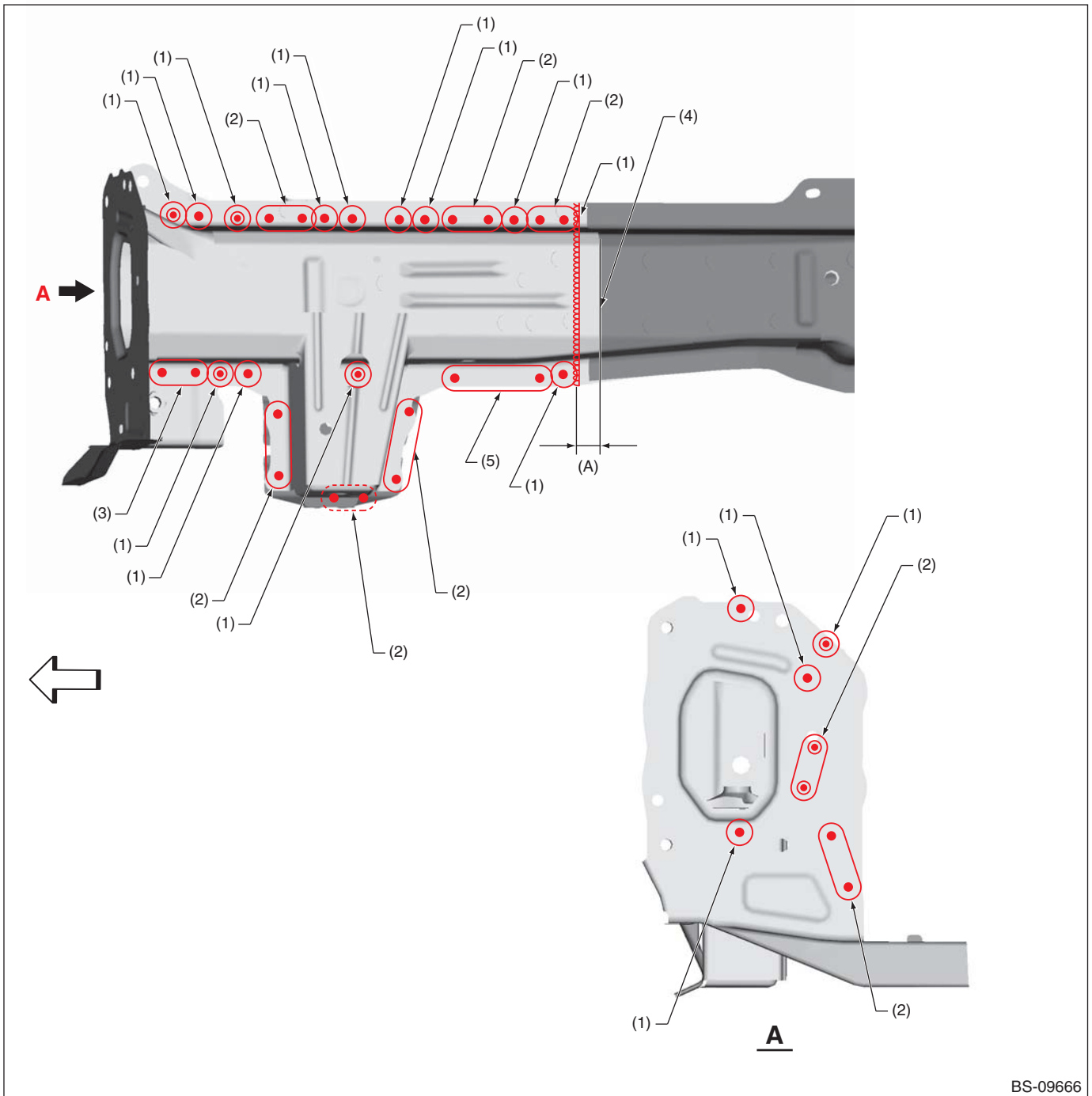
(1) 1 point
(2) 2 points

(3) 3 points

(4) Tailored line

Panel Replacement

• '18 MY —



BS-09666

(A) 10 mm (0.39 in)

(1) 1 point
(2) 2 points

(3) 3 points
(4) Tailored line

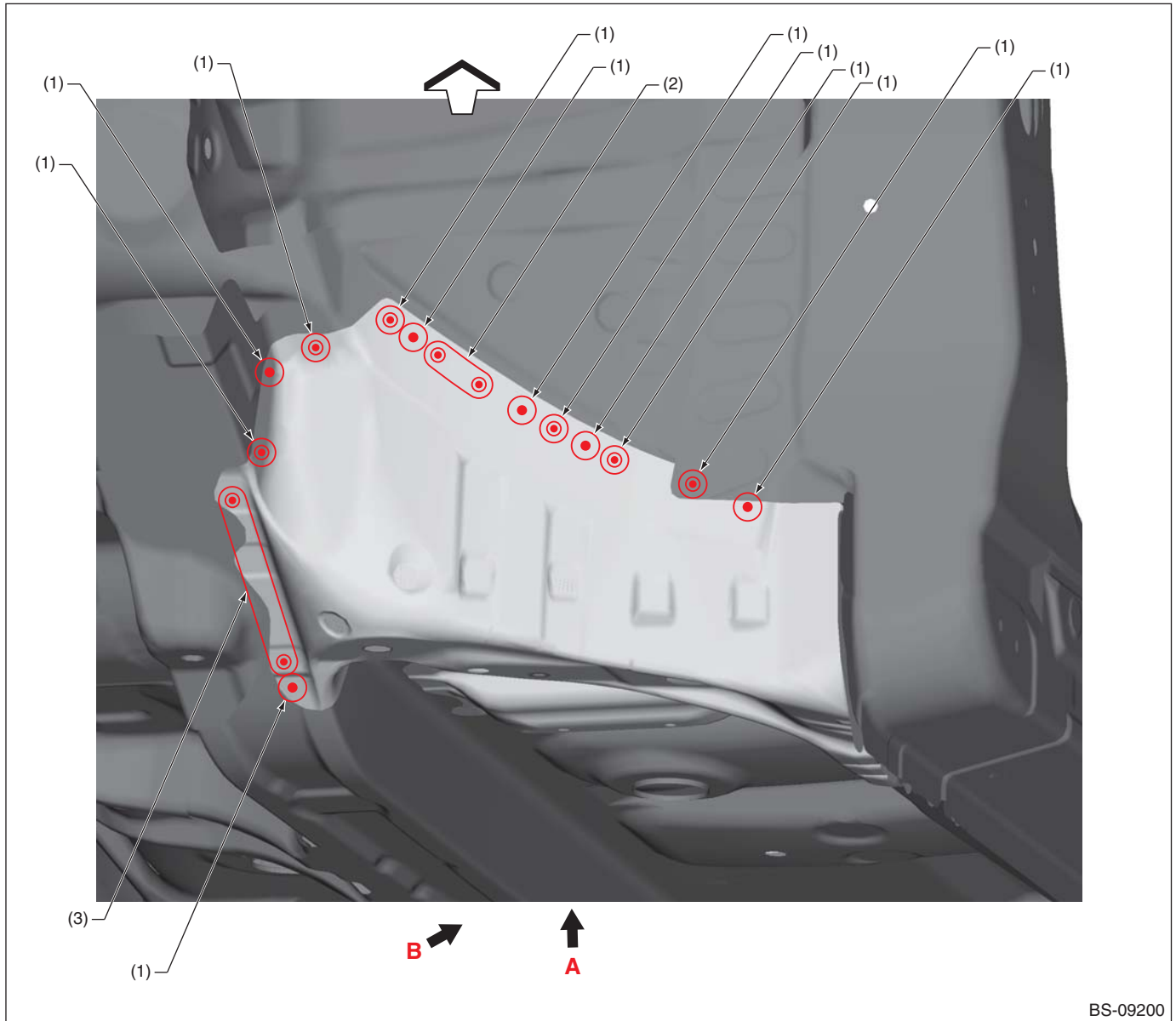
(5) 4 points

Panel Replacement

8-12. Toe Board Lower Reinforcement (Total replacement)

A: REMOVAL

- Overall view (LH)



BS-09200

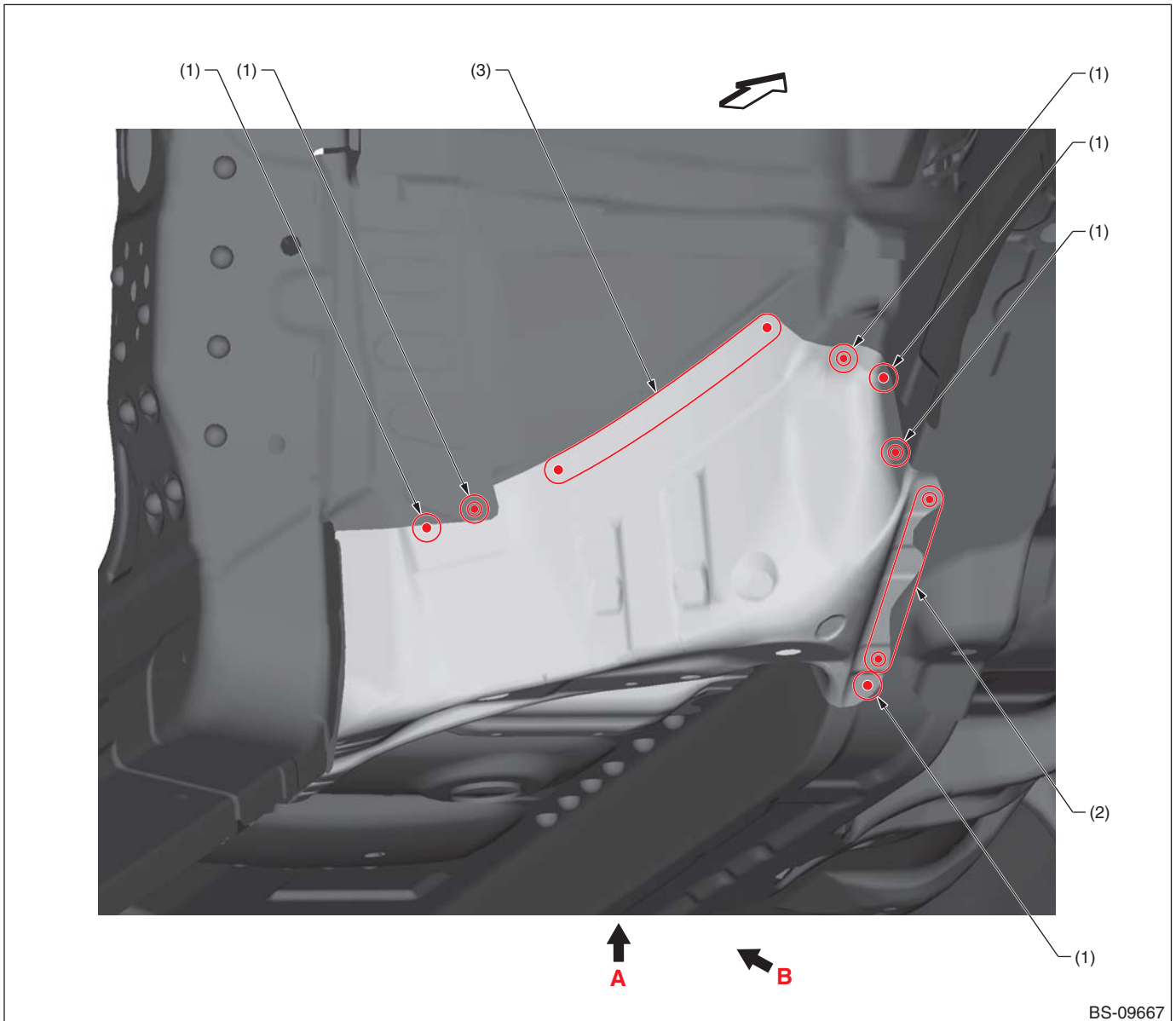
(1) 1 point

(2) 2 points

(3) 3 points

Panel Replacement

- Overall view (RH)



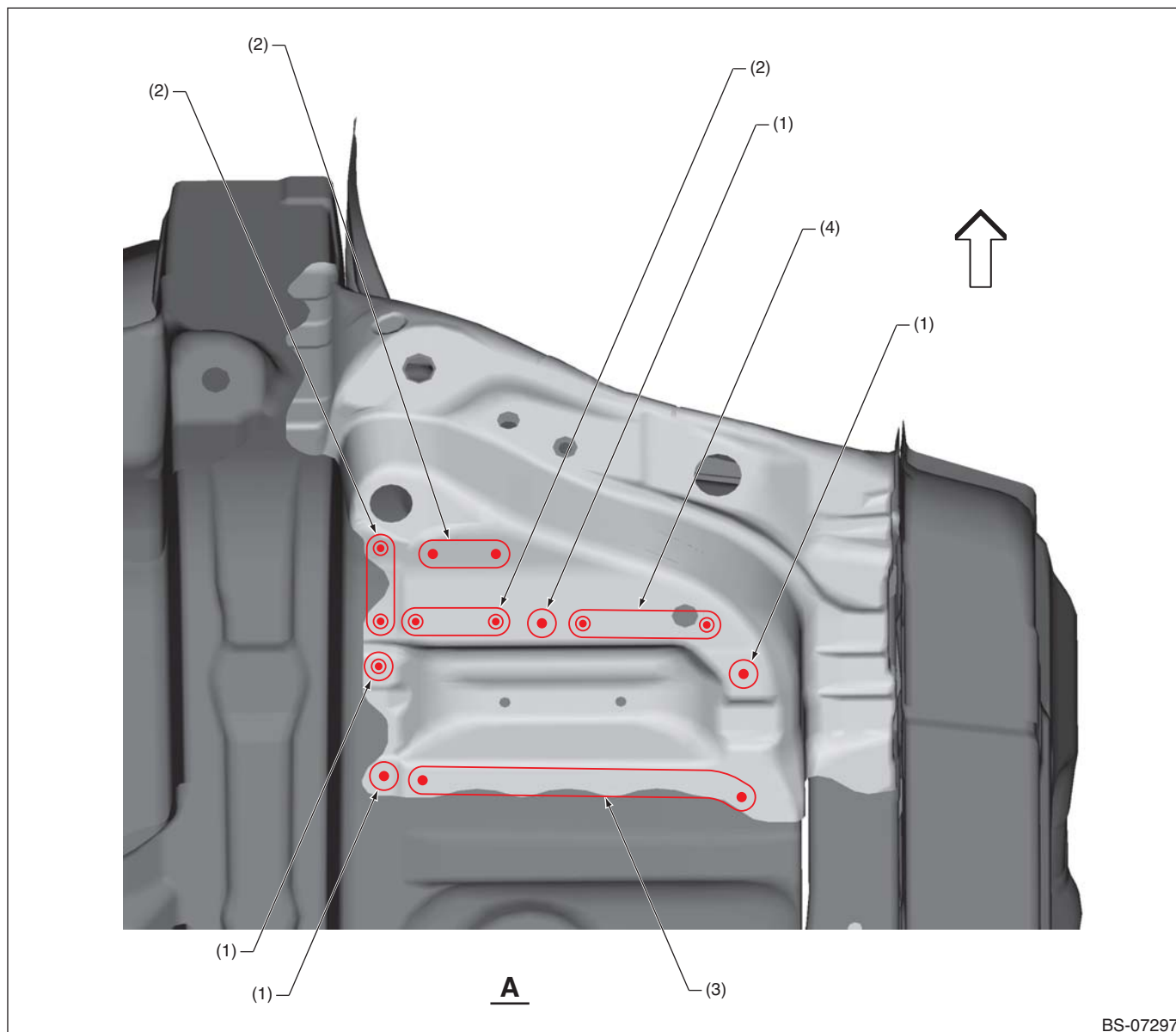
(1) 1 point

(2) 3 points

(3) 5 points

Panel Replacement

- View A



BS-07297

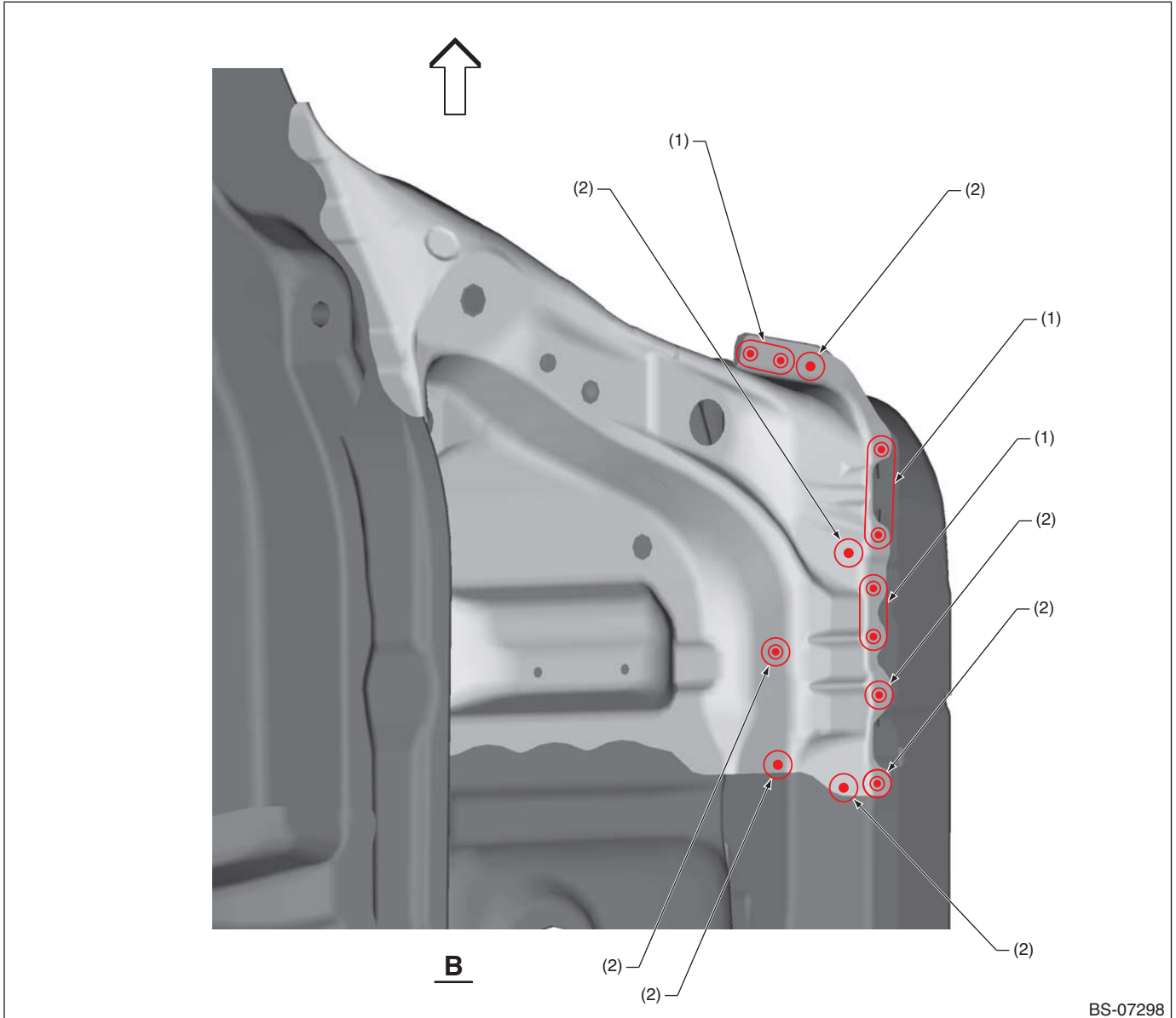
(1) 1 point
(2) 2 points

(3) 5 points

(4) 3 points

Panel Replacement

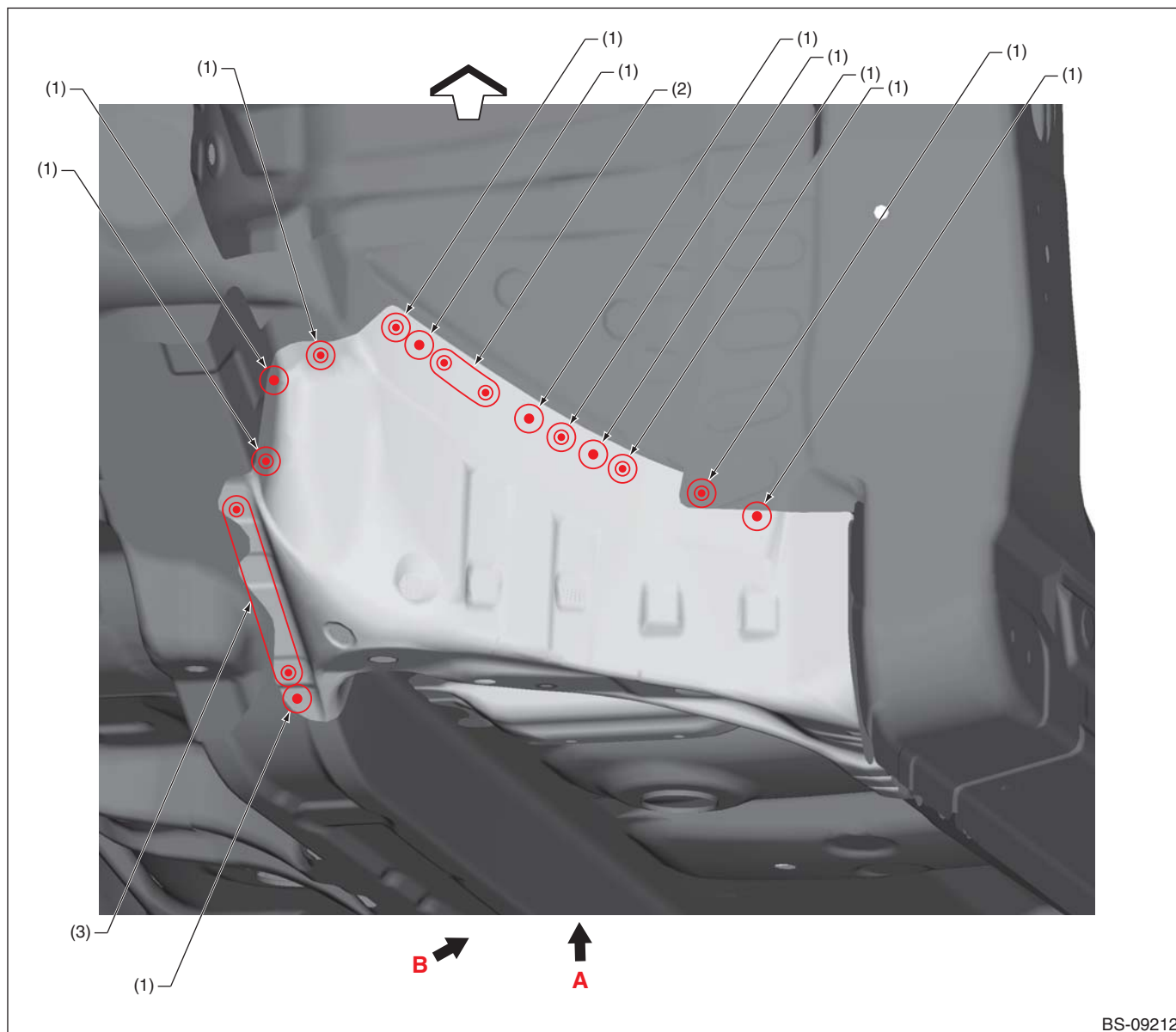
- View B



Panel Replacement

B: INSTALLATION

• Overall view (LH)



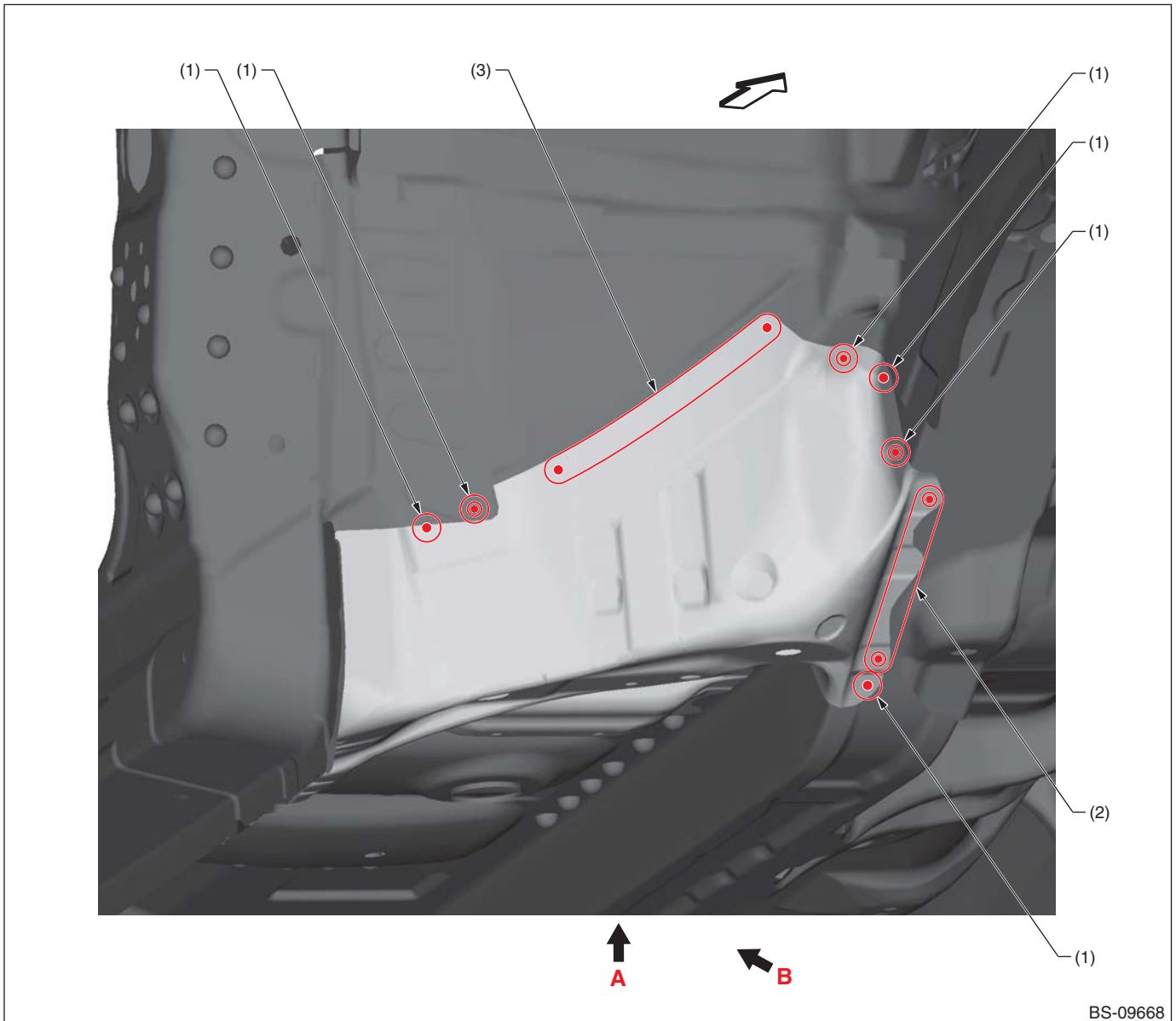
(1) 1 point

(2) 2 points

(3) 3 points

Panel Replacement

- Overall view (RH)



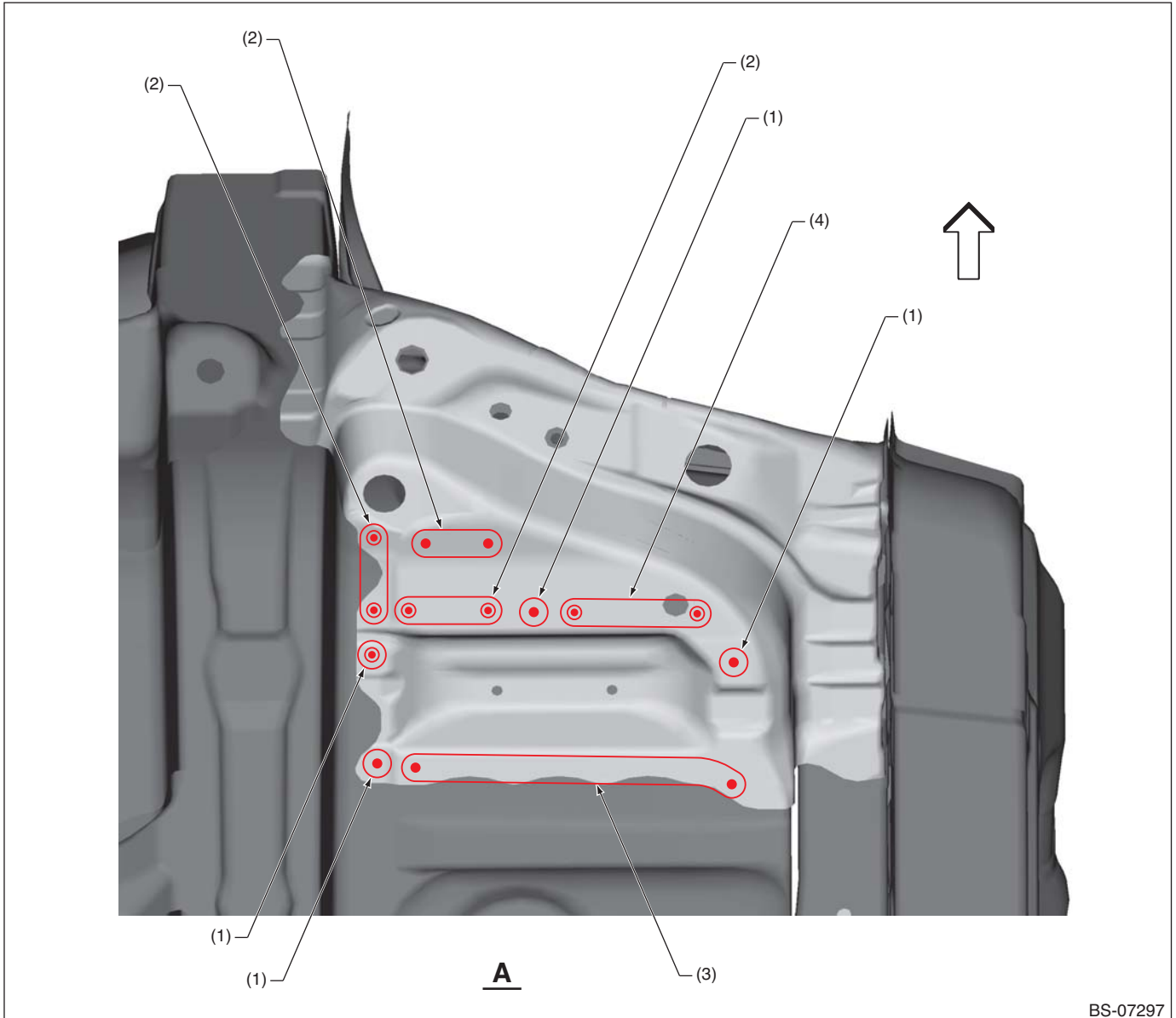
(1) 1 point

(2) 3 points

(3) 5 points

Panel Replacement

- View A



BS-07297

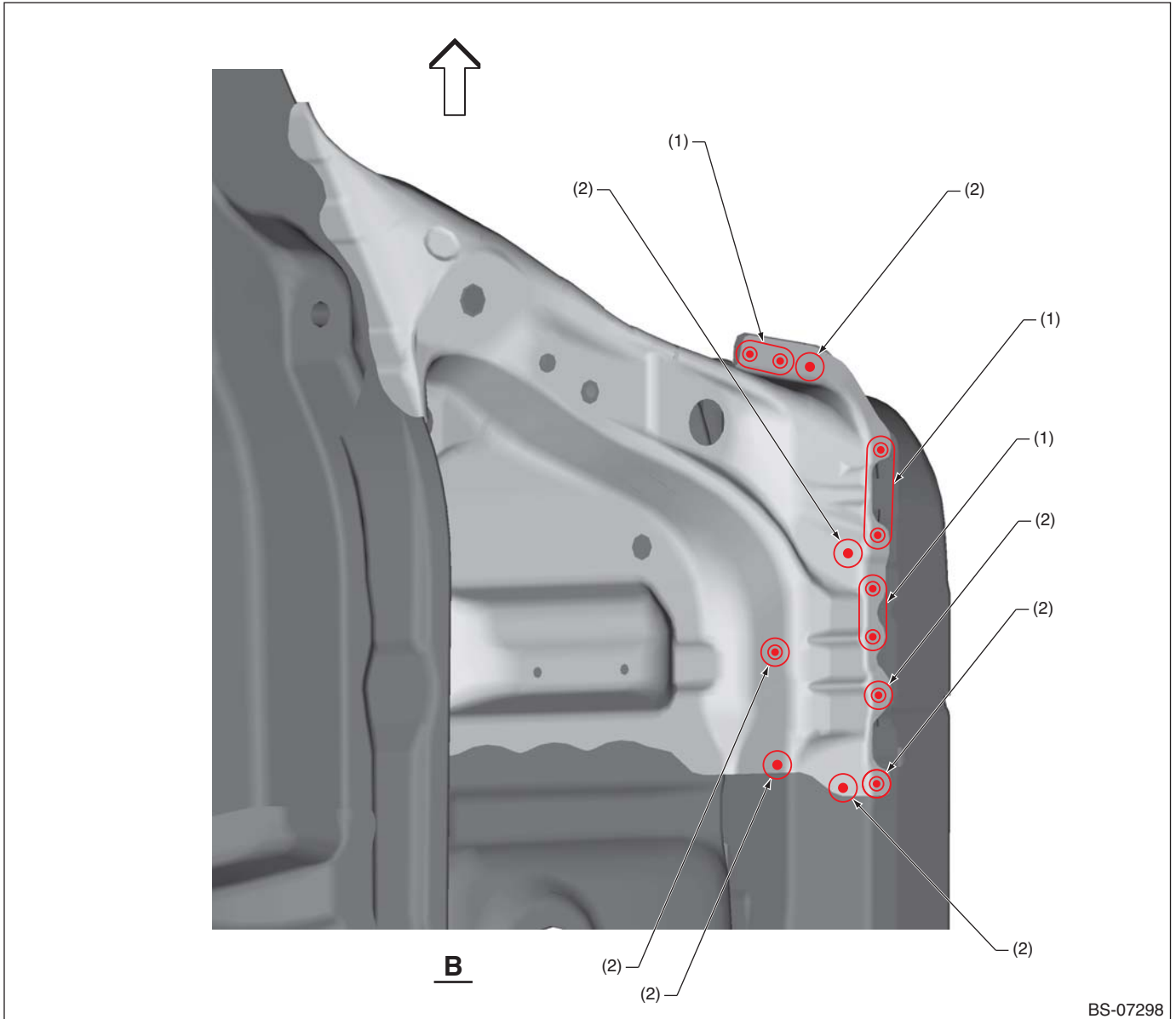
(1) 1 point
(2) 2 points

(3) 5 points

(4) 3 points

Panel Replacement

- View B



(1) 2 points

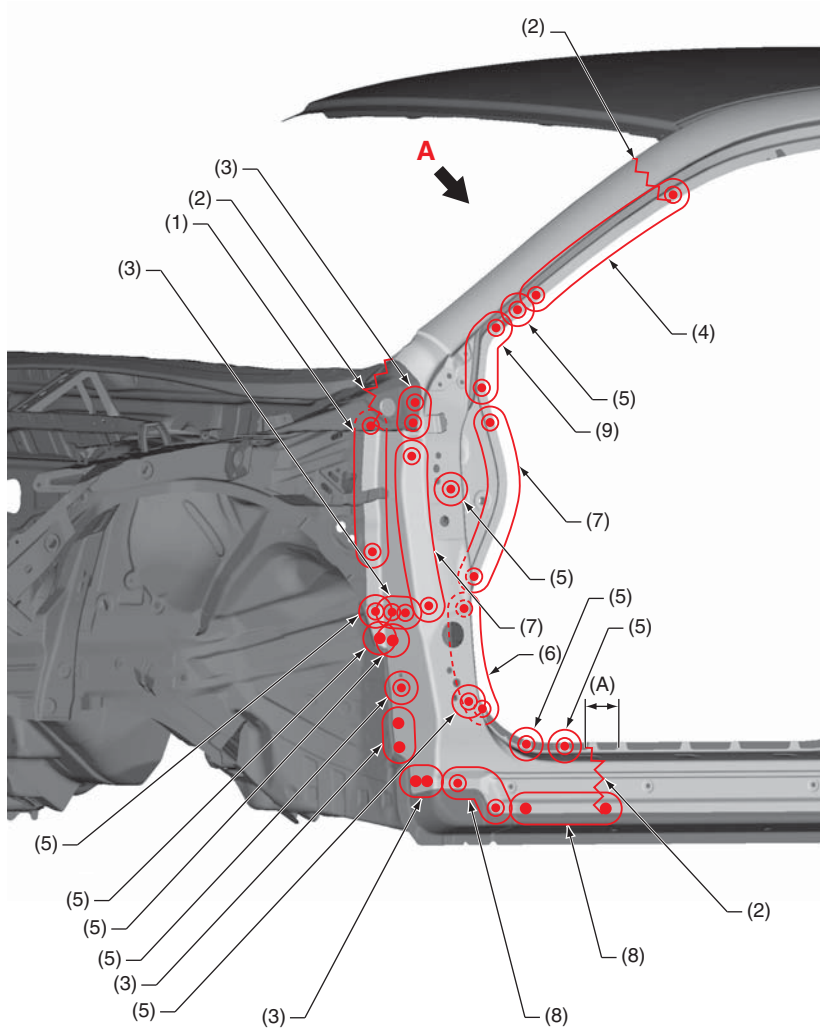
(2) 1 point

Panel Replacement

8-13. Front Pillar (Partial replacement)

A: REMOVAL

- Overall view 1 (Side upper frame removal condition)



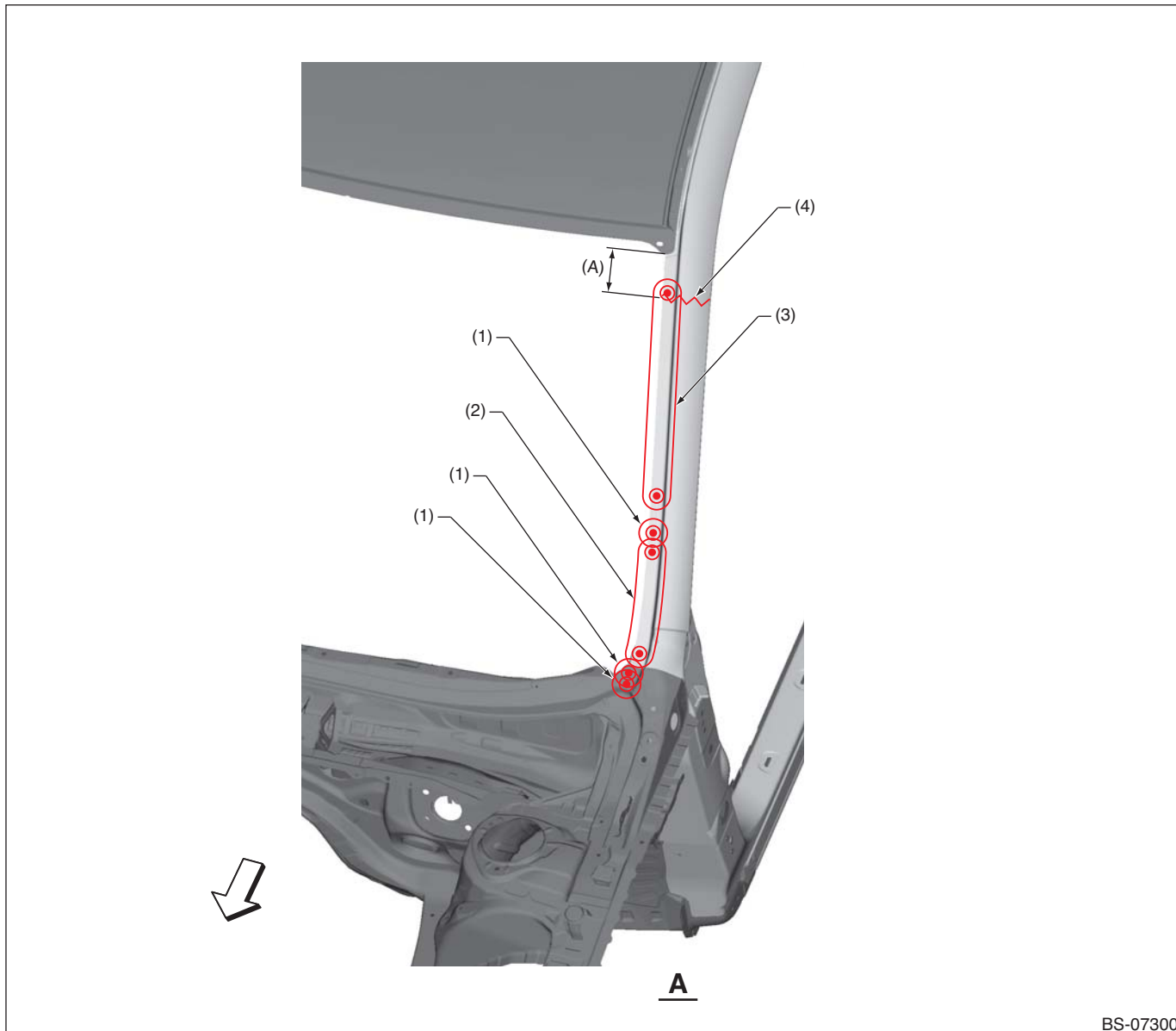
BS-09684

(A) 70 mm (2.76 in)

- | | | |
|------------------|---------------|--|
| (1) 6 points | (4) 11 points | (7) 7 points |
| (2) Cut position | (5) 1 point | (8) 3 points |
| (3) 2 points | (6) 5 points | (9) OUTBACK: 5 points
SEDAN: 4 points |

Panel Replacement

- View A



BS-07300

(A) 100 mm (3.94 in)

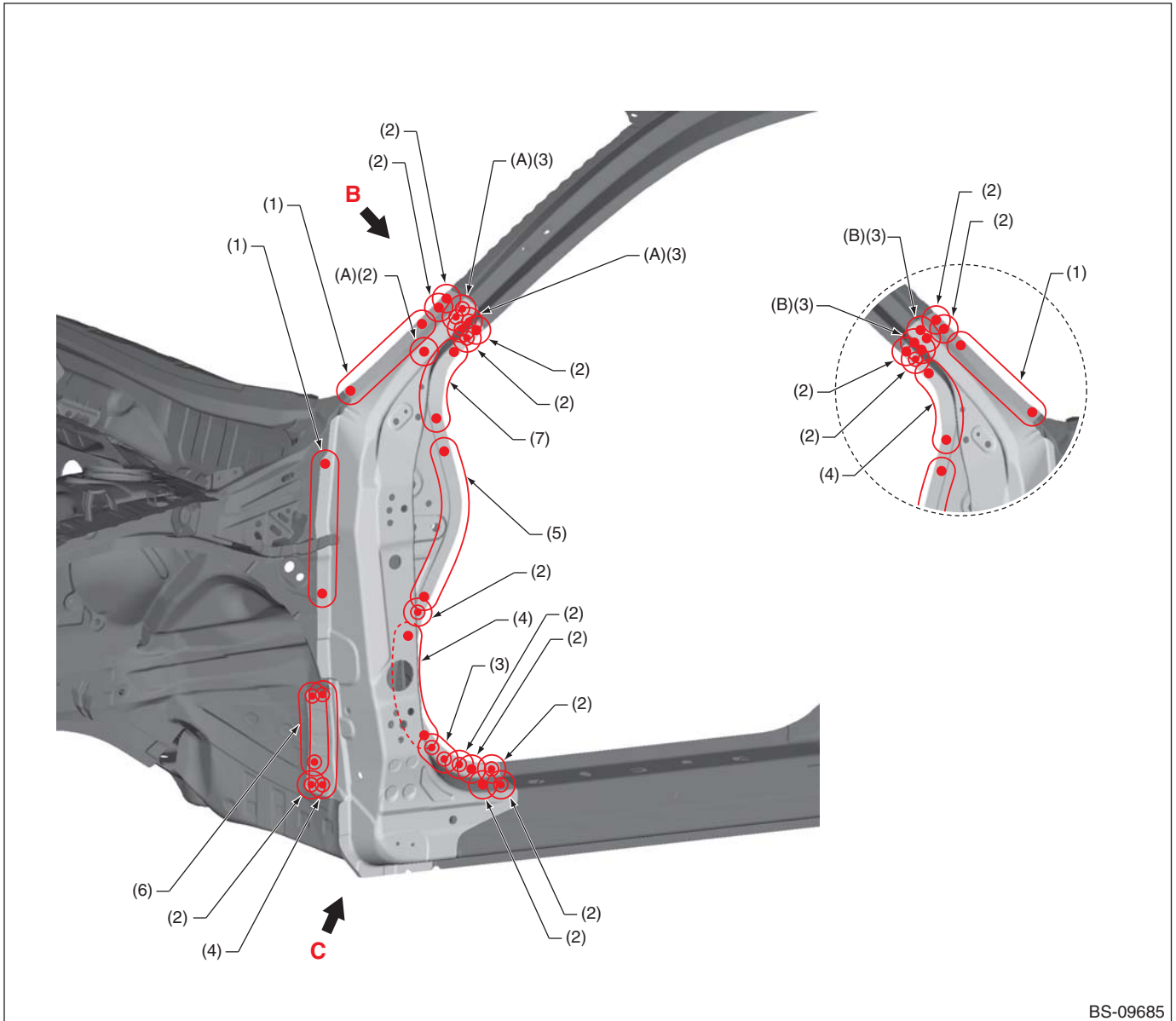
(1) 1 point
(2) 6 points

(3) 13 points

(4) Cut position

Panel Replacement

- Overall view 2 (Front pillar outer removal condition) (— '17 MY)



BS-09685

(A) Only LH

(B) Only RH

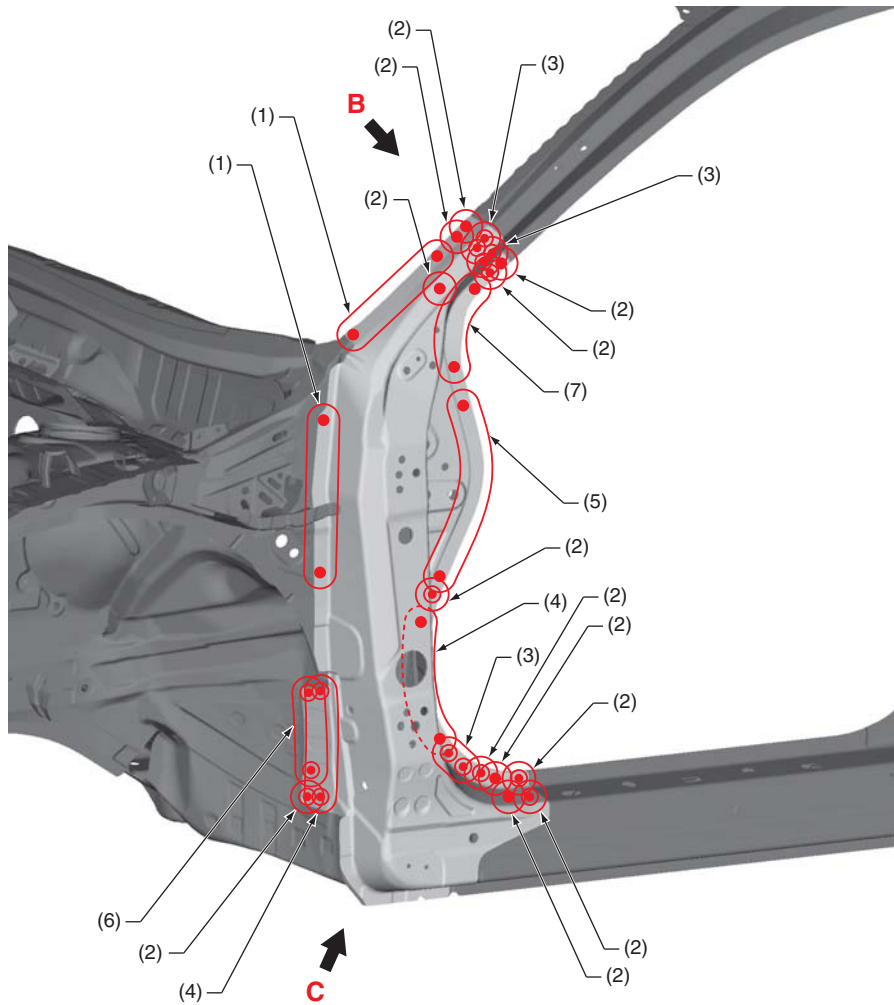
- (1) 6 points
- (2) 1 point
- (3) 2 points

- (4) 5 points
- (5) 7 points
- (6) 4 points

- (7) OUTBACK: 5 points
- SEDAN: 4 points

Panel Replacement

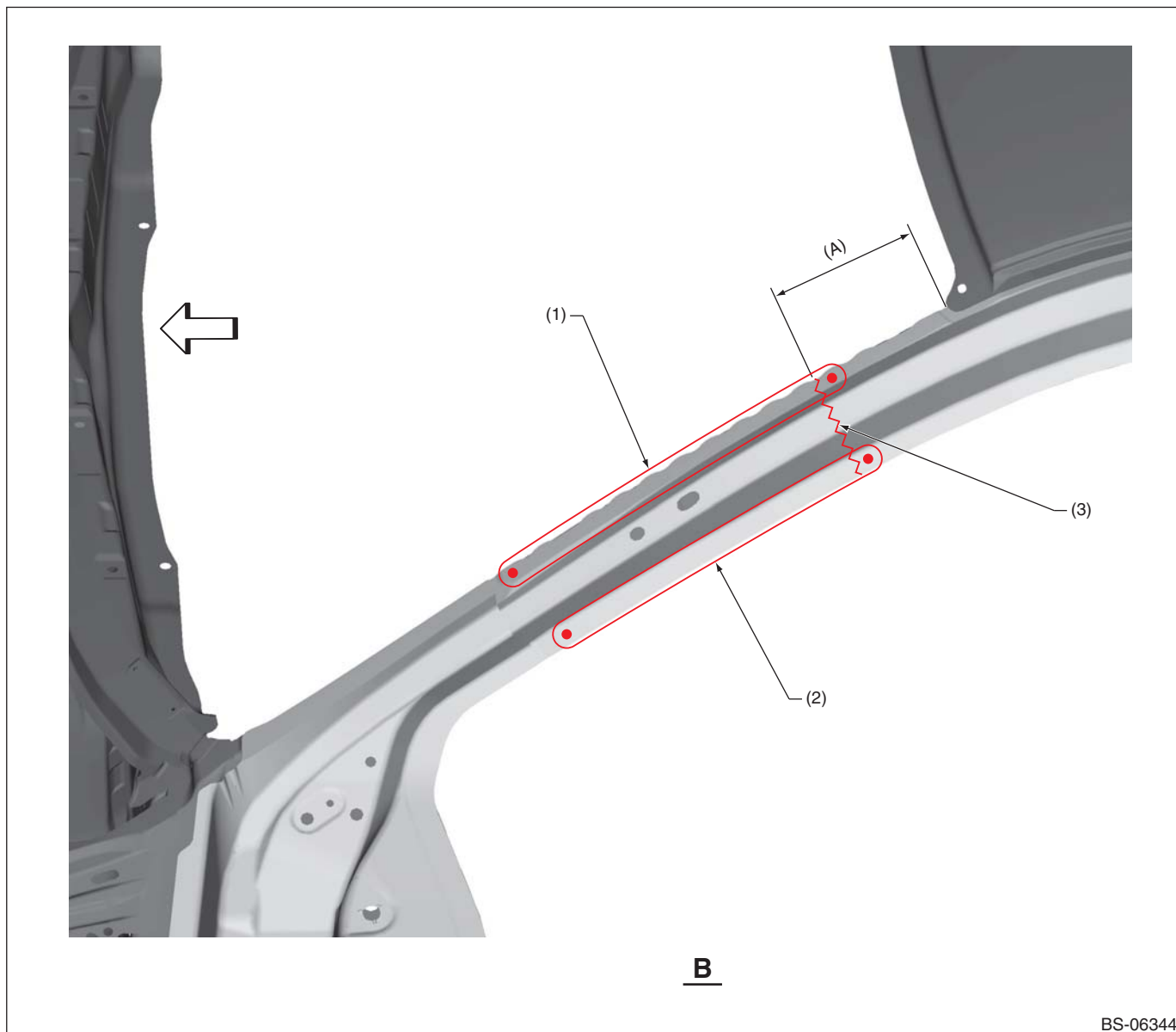
- Overall view 2 (Front pillar outer removal condition) ('18 MY —)



BS-09686

Panel Replacement

- View B



BS-06344

(A) 130 mm (5.12 in)

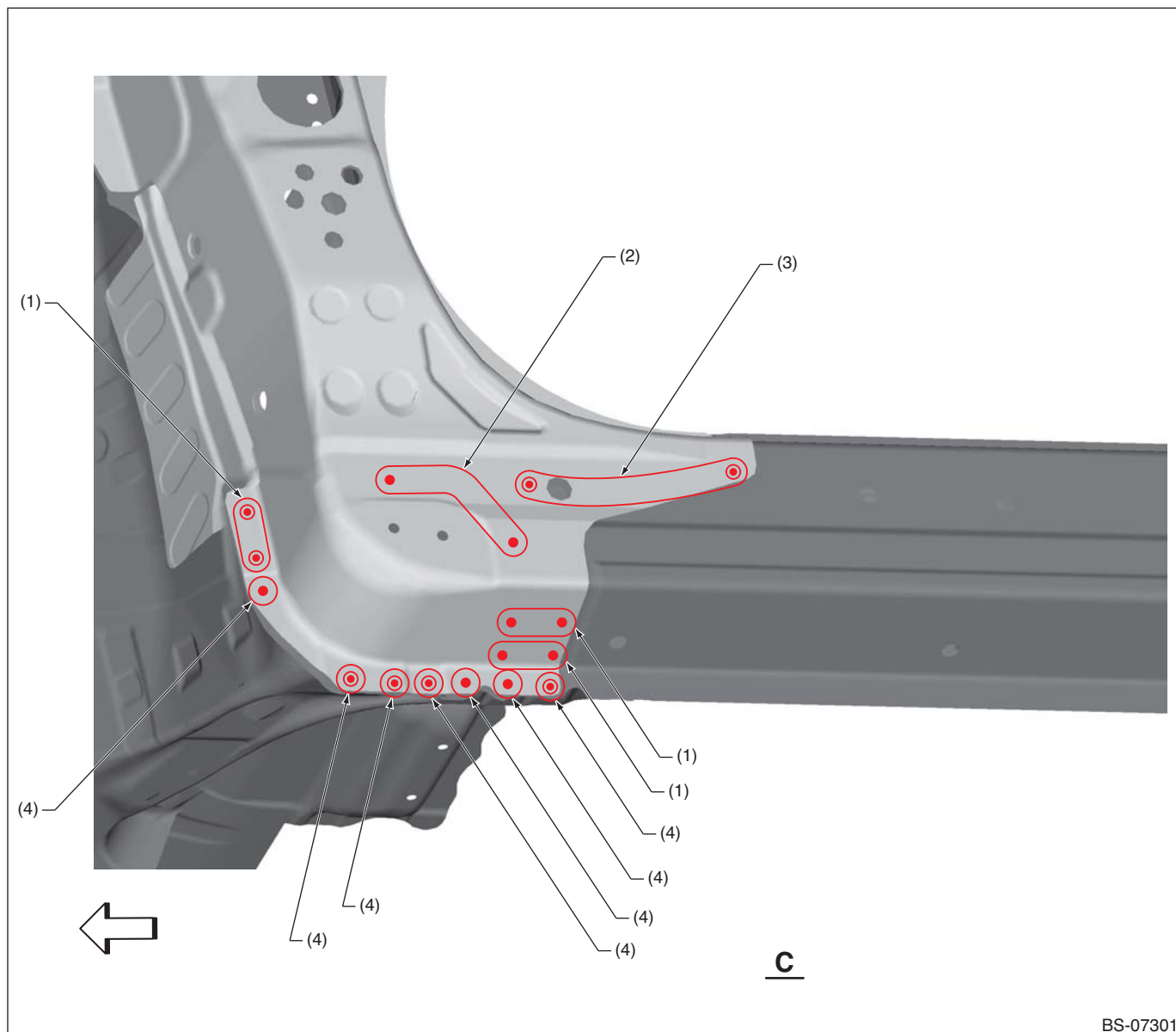
(1) 11 points

(2) 10 points

(3) Cut position

Panel Replacement

- View C



BS-07301

(1) 2 points
(2) 3 points

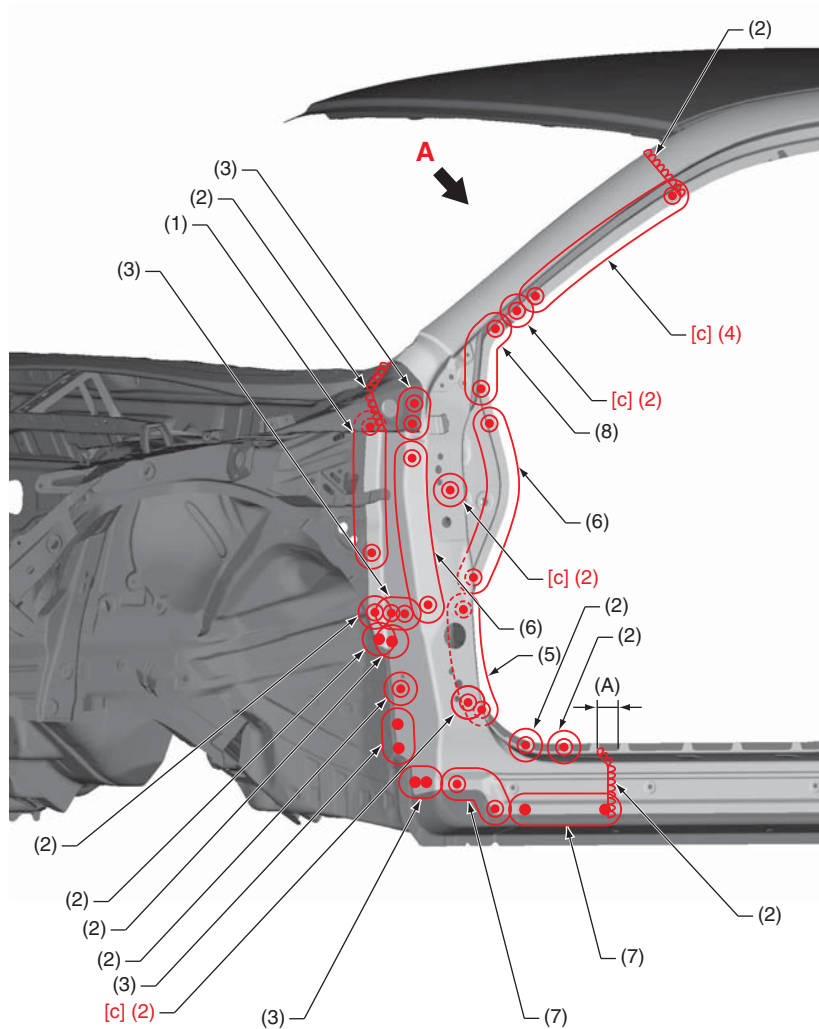
(3) 4 points

(4) 1 point

Panel Replacement

B: INSTALLATION

• Overall view 1



BS-09687

(A) 30 mm (1.18 in)

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

- (4) 11 points
- (5) 5 points
- (6) 7 points

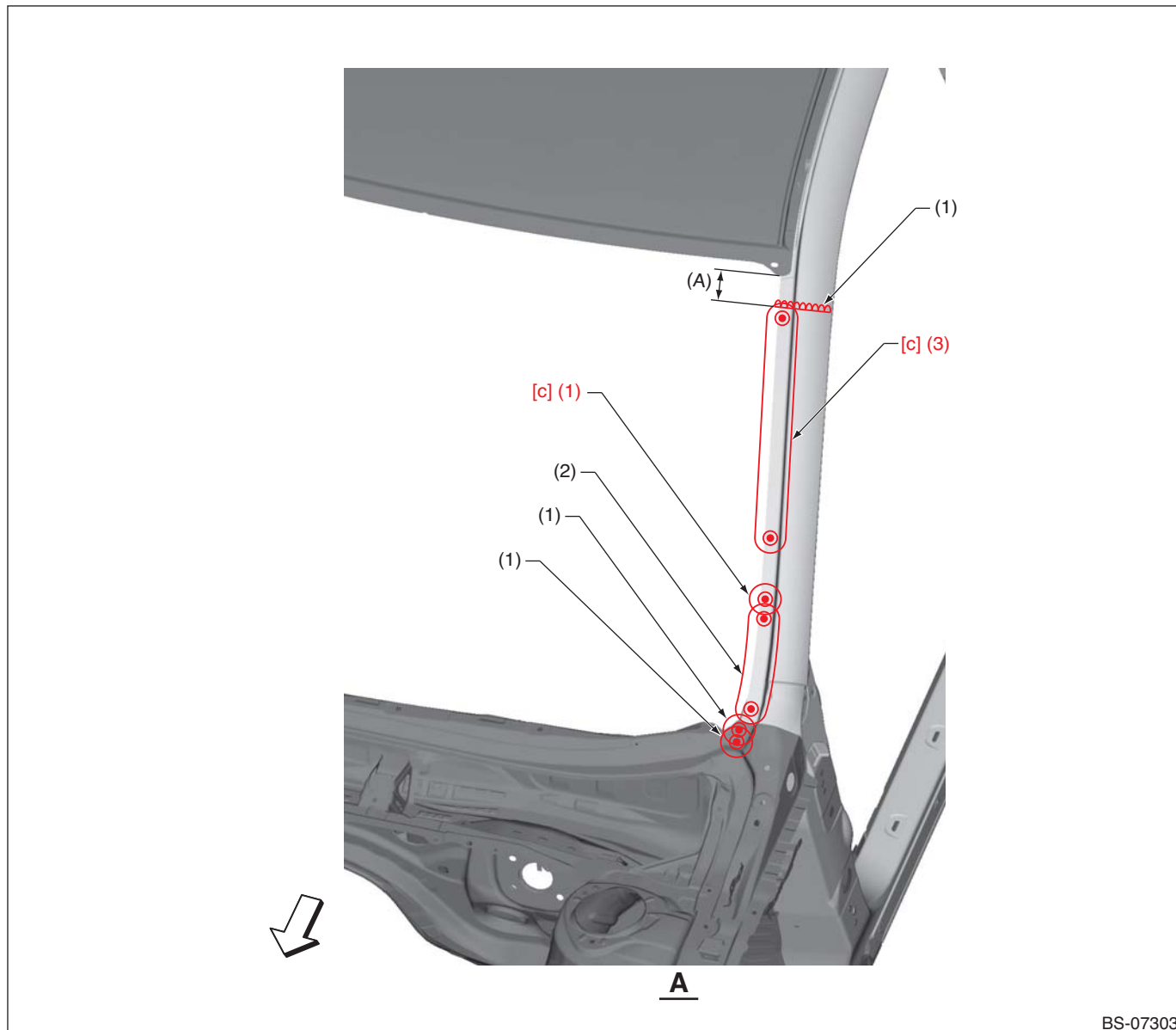
- (7) 3 points
- (8) OUTBACK: 5 points
SEDAN: 4 points

[c] Spot welding

Compression: 3.5 kN, Current: 7.5 kA, Welding time: 25 cyc

Panel Replacement

- View A



BS-07303

(A) 60 mm (2.36 in)

(1) 1 point

(2) 6 points

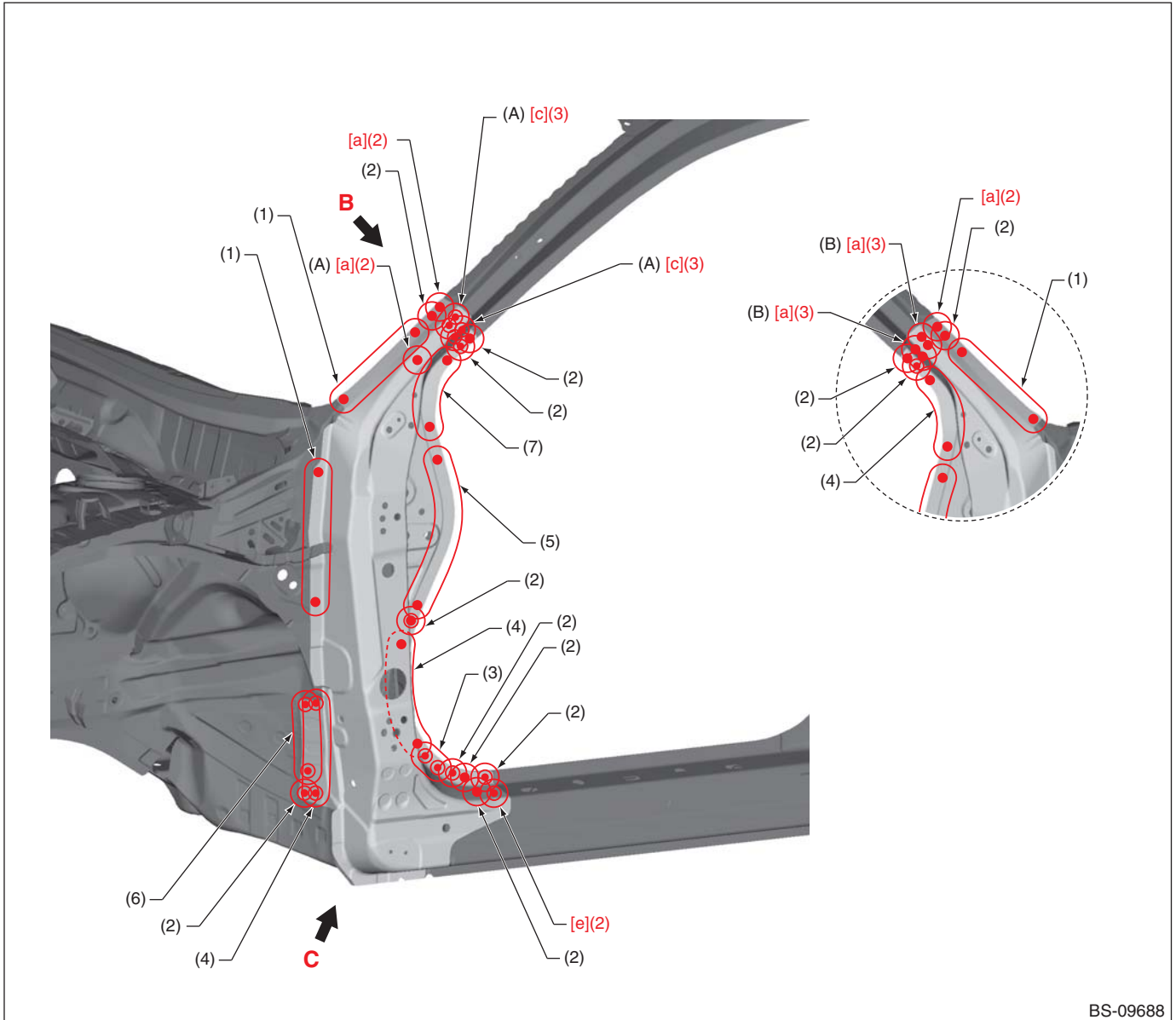
(3) 12 points

[c] Spot welding

Compression: 3.5 kN, Current: 7.5 kA, Welding time: 25 cyc

Panel Replacement

• Overall view 2 (— '17 MY)



(A) Only LH

(B) Only RH

(1) 6 points

(2) 1 point

(3) 2 points

(4) 5 points

(5) 7 points

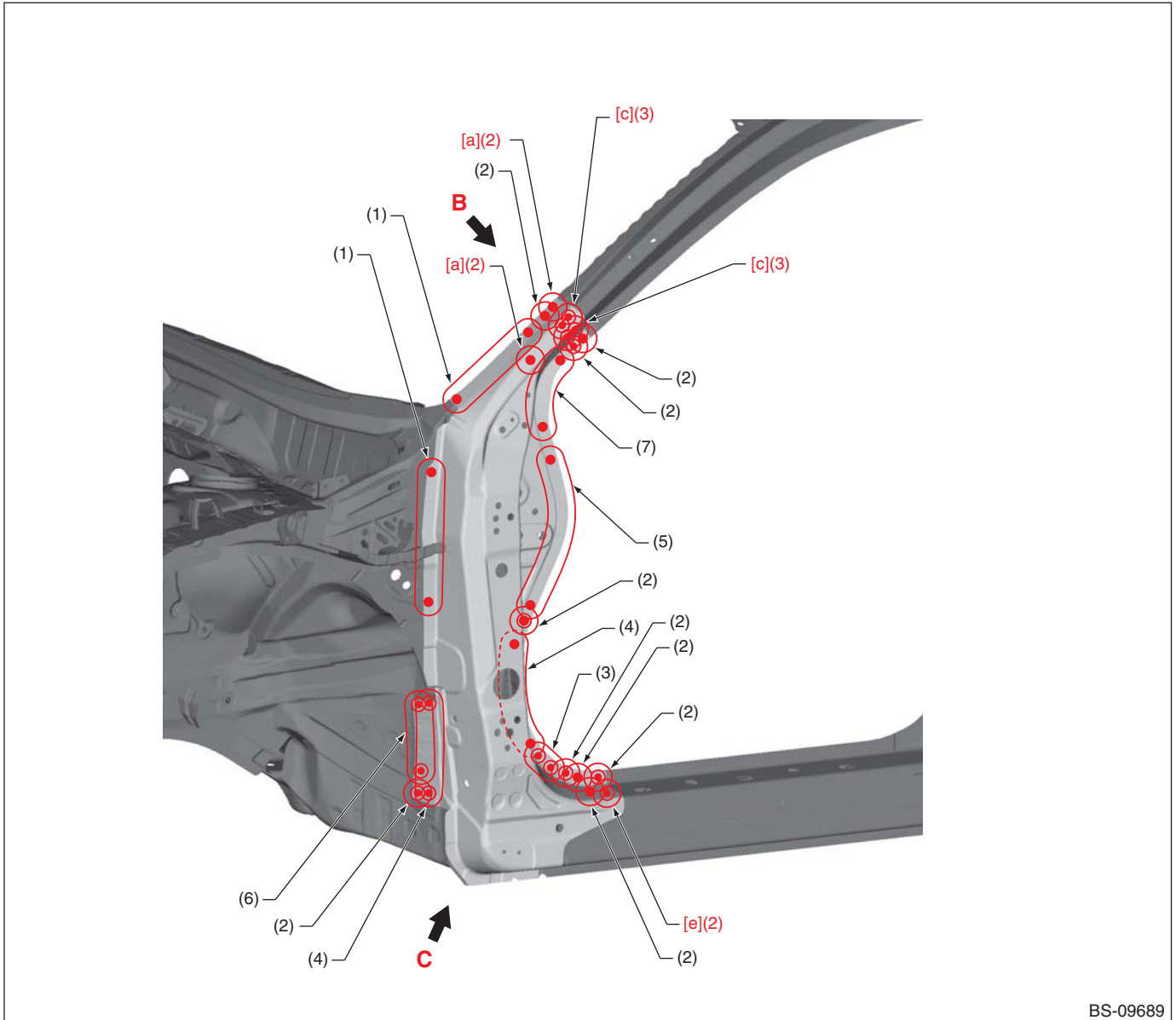
(6) 4 points

(7) OUTBACK: 5 points
SEDAN: 4 points

[a] Spot welding	Compression: 4.0 kN, Current: 8.0 kA, Welding time: 15 cyc
[c] Spot welding	Compression: 3.5 kN, Current: 7.5 kA, Welding time: 25 cyc
[e] Spot welding	Compression: 4.4 kN, Current: 8.0 kA, Welding time: 20 cyc

Panel Replacement

• Overall view 2 ('18 MY —)



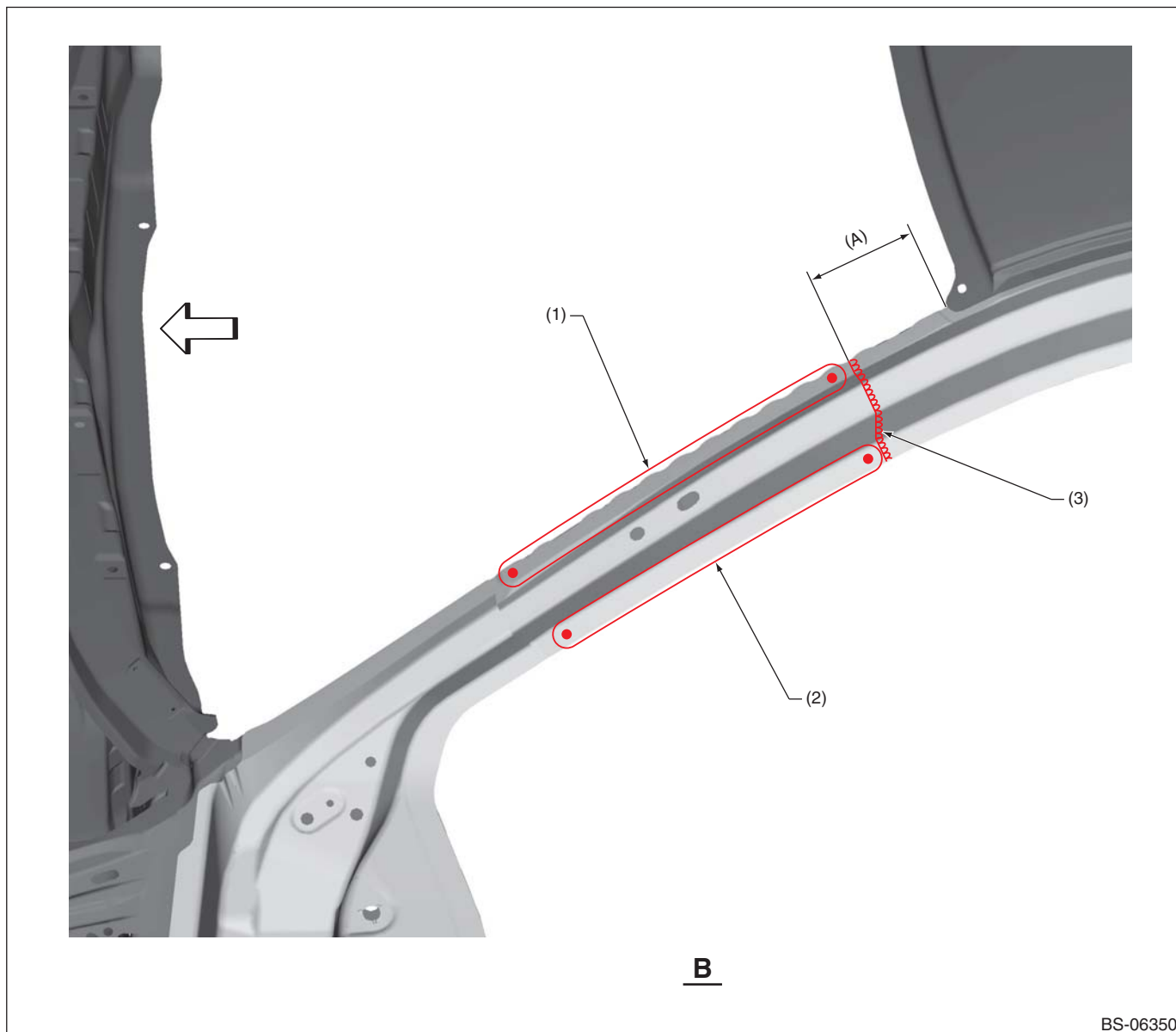
BS-09689

- | | | |
|--------------|--------------|-----------------------|
| (1) 6 points | (4) 5 points | (7) OUTBACK: 5 points |
| (2) 1 point | (5) 7 points | SEDAN: 4 points |
| (3) 2 points | (6) 4 points | |

[a] Spot welding	Compression: 4.0 kN, Current: 8.0 kA, Welding time: 15 cyc
[c] Spot welding	Compression: 3.5 kN, Current: 7.5 kA, Welding time: 25 cyc
[e] Spot welding	Compression: 4.4 kN, Current: 8.0 kA, Welding time: 20 cyc

Panel Replacement

- View B



BS-06350

(A) 100 mm (3.94 in)

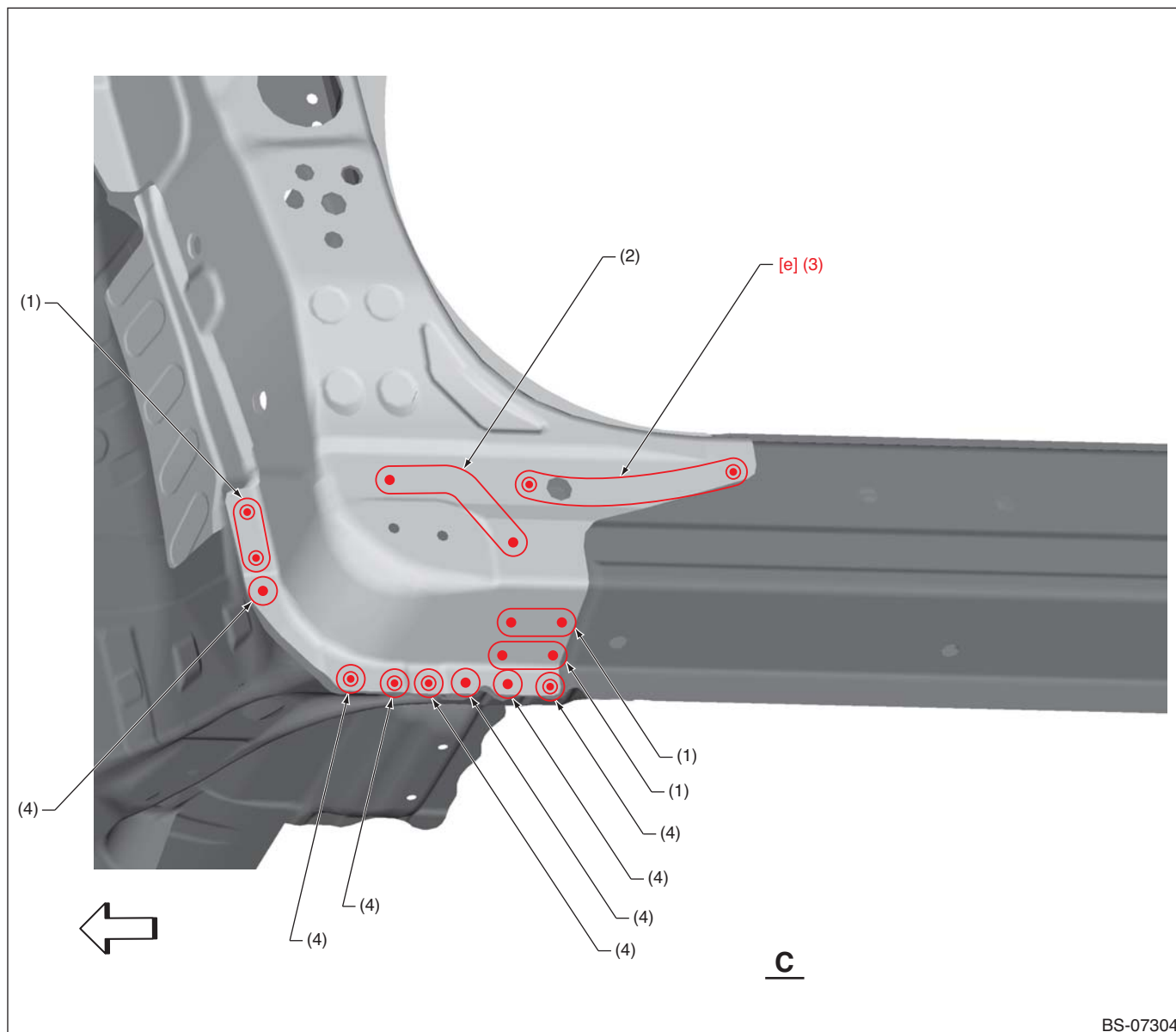
(1) 11 points

(2) 10 points

(3) 1 point

Panel Replacement

- View C



BS-07304

(1) 2 points
(2) 3 points

(3) 4 points

(4) 1 point

[e] Spot welding

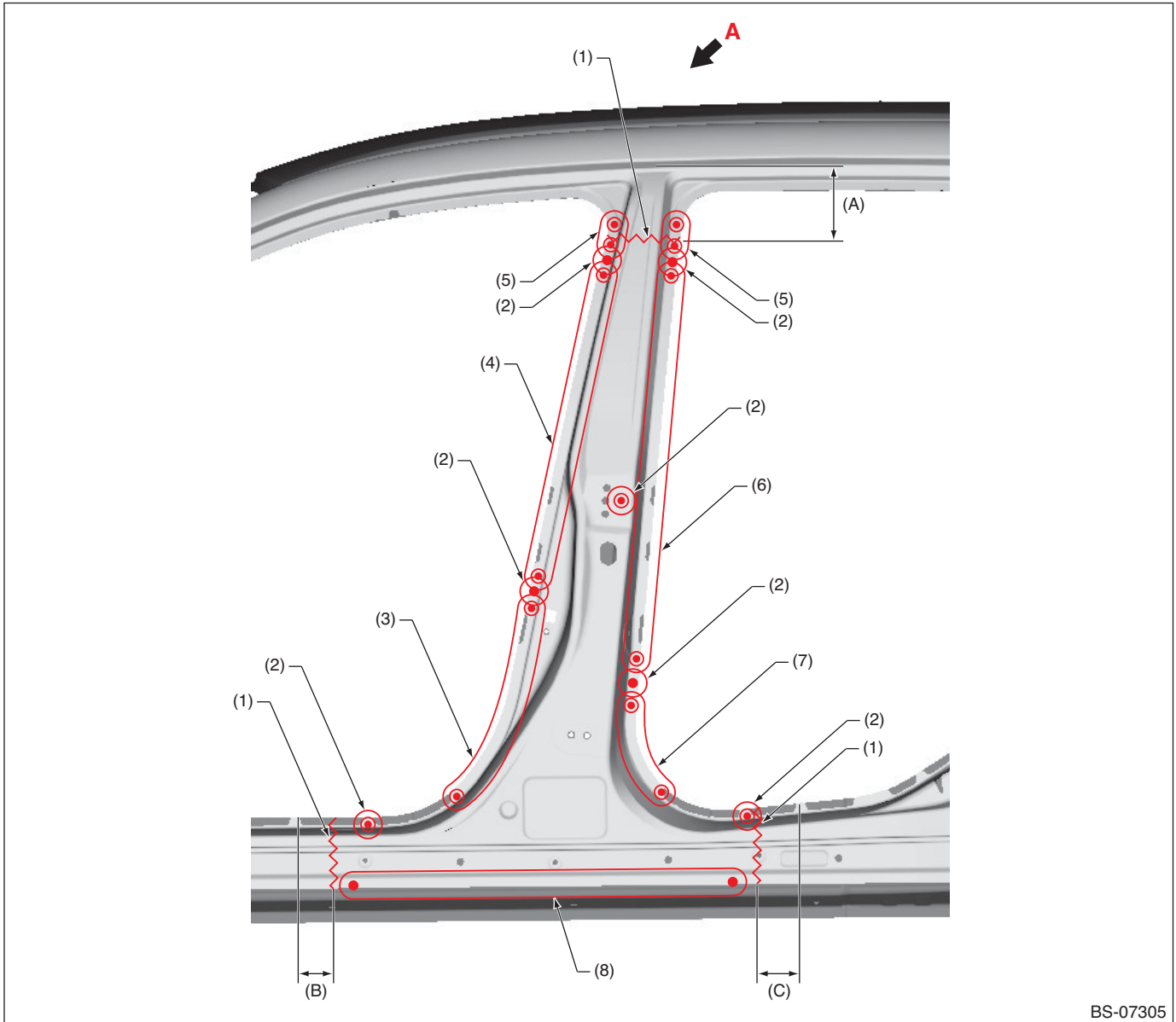
Compression: 4.4 kN, Current: 8.0 kA, Welding time: 20 cyc

Panel Replacement

8-14. Center Pillar Outer (Partial replacement)/OUTBACK

A: REMOVAL

- Overall view



BS-07305

(A) 115 mm (4.53 in)

(B) 70 mm (2.76 in)

(C) 80 mm (3.15 in)

(1) Cut position

(2) 1 point

(3) 11 points

(4) 12 points

(5) 2 points

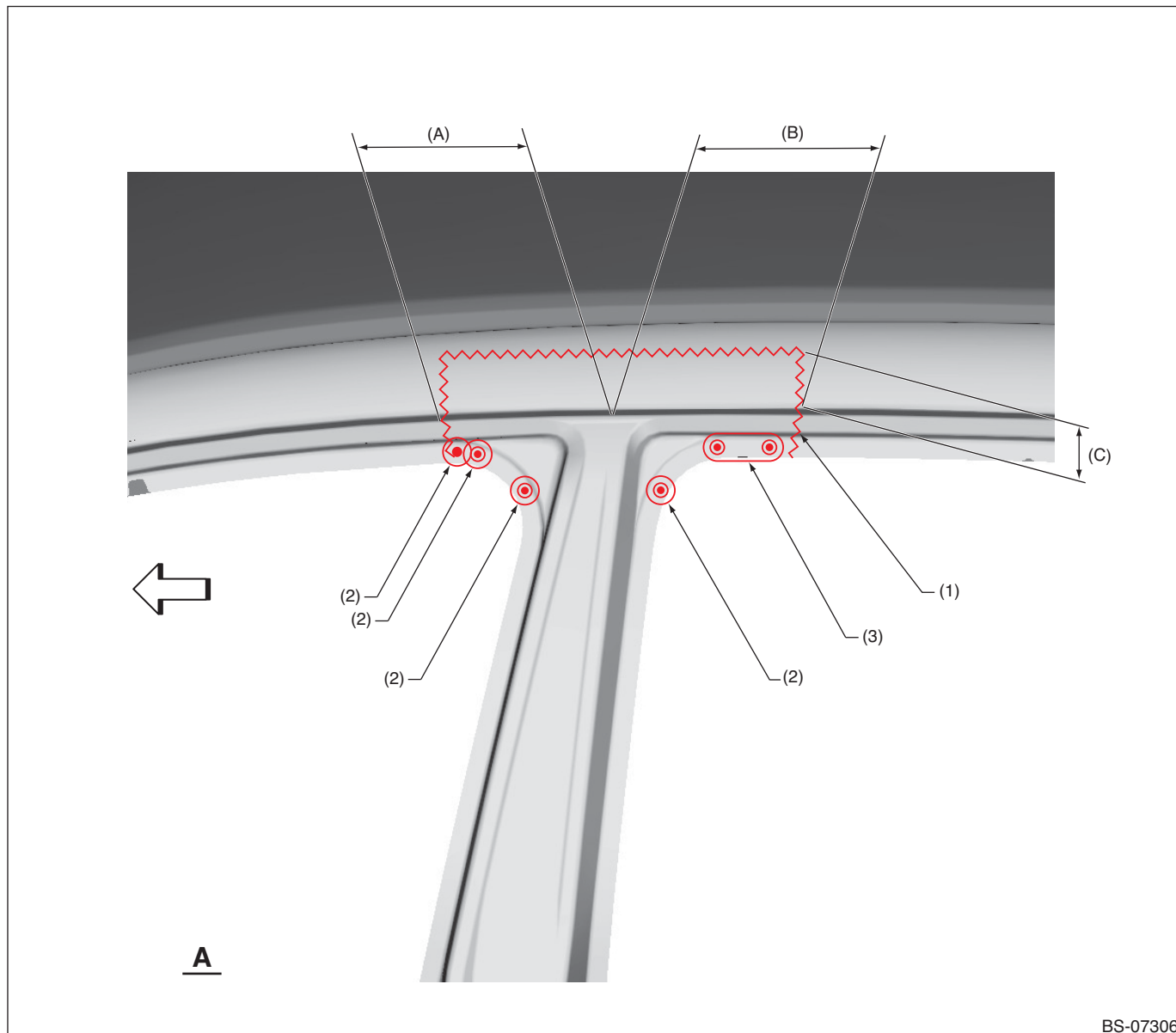
(6) 13 points

(7) 7 points

(8) 9 points

Panel Replacement

- View A



(A) 160 mm (6.30 in)

(B) 170 mm (6.69 in)

(C) 50 mm (1.97 in)

(1) Cut position

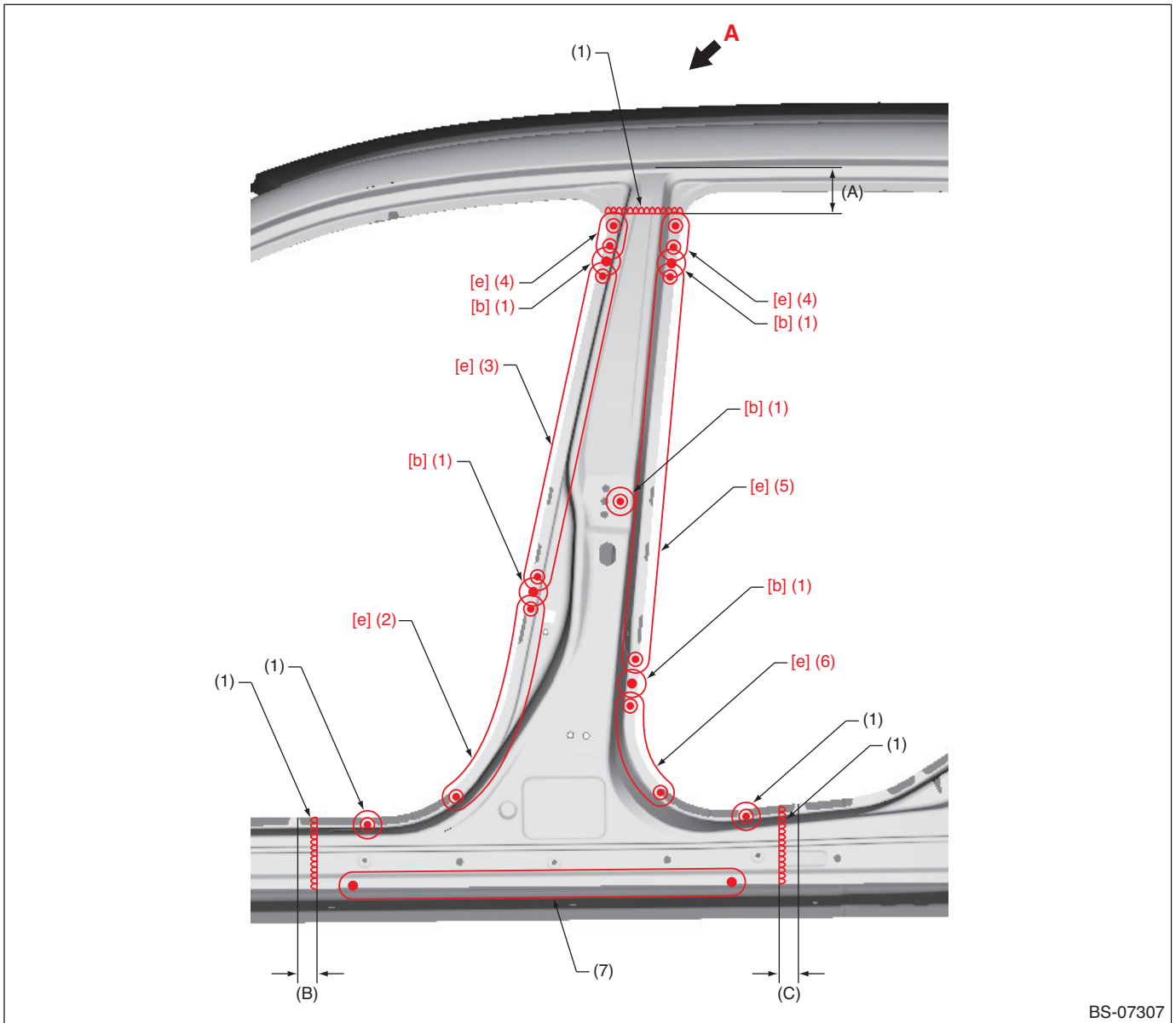
(2) 1 point

(3) 2 points

Panel Replacement

B: INSTALLATION

• Overall view



BS-07307

(A) 80 mm (3.15 in)

(B) 30 mm (1.18 in)

(C) 40 mm (1.57 in)

(1) 1 point

(4) 2 points

(6) 7 points

(2) 11 points

(5) 13 points

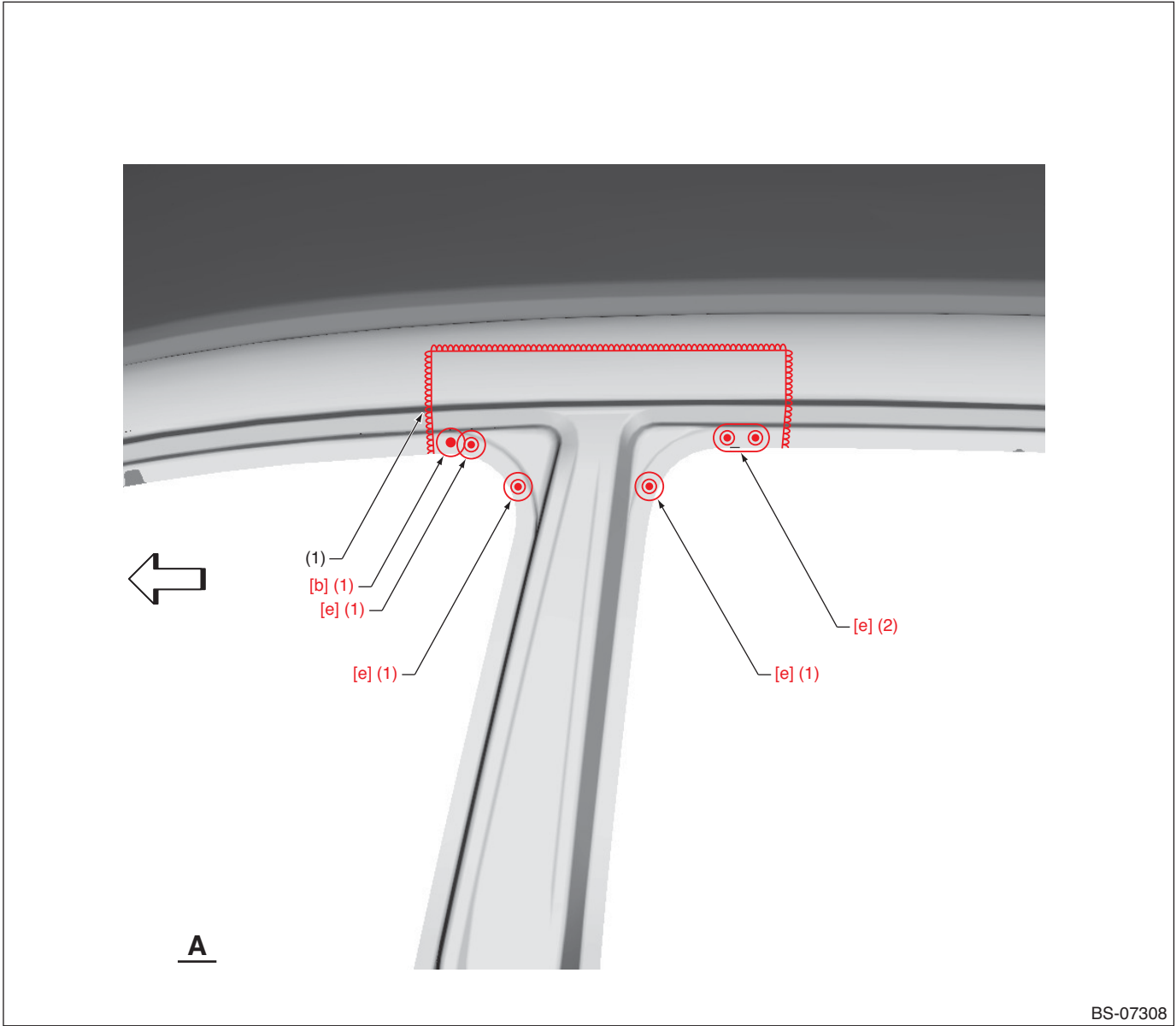
(7) 9 points

(3) 12 points

[b] Spot welding	Compression: 4.0 kN, Current: 6.5 kA, Welding time: 15 cyc
[e] Spot welding	Compression: 4.4 kN, Current: 8.0 kA, Welding time: 20 cyc

Panel Replacement

- View A

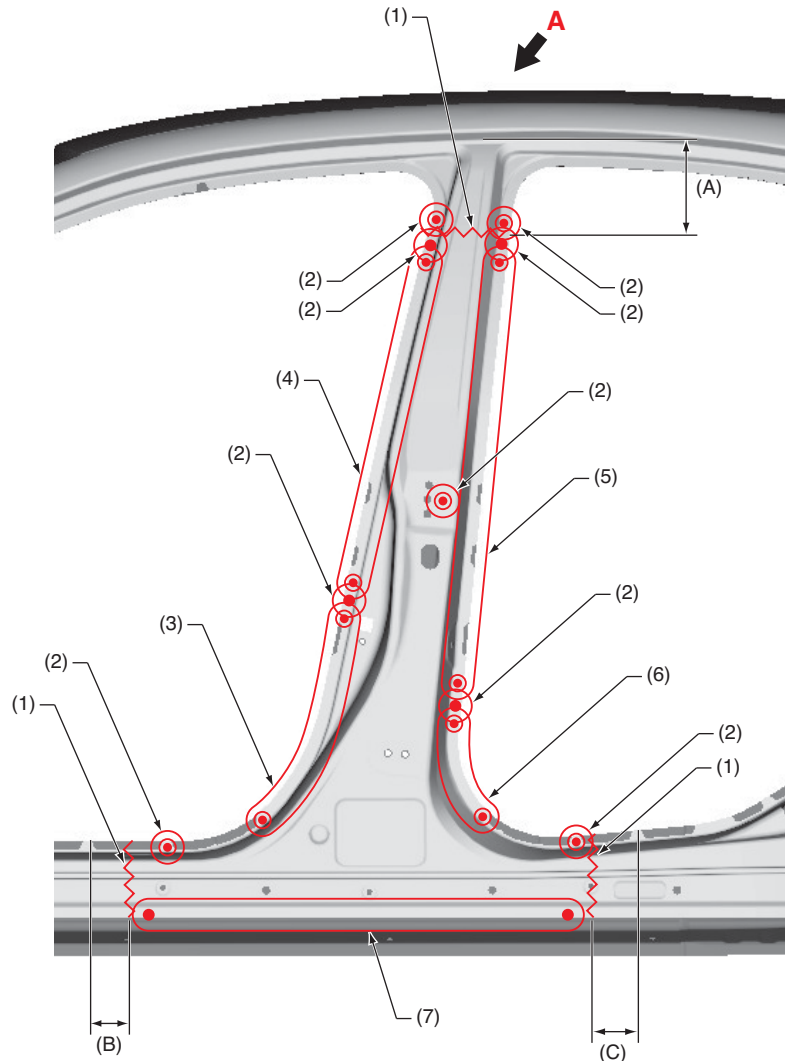


Panel Replacement

8-15. Center Pillar Outer (Partial replacement)/SEDAN

A: REMOVAL

- Overall view



BS-07309

(A) 150 mm (5.91 in)

(B) 70 mm (2.76 in)

(C) 80 mm (3.15 in)

(1) Cut position

(4) 12 points

(6) 7 points

(2) 1 point

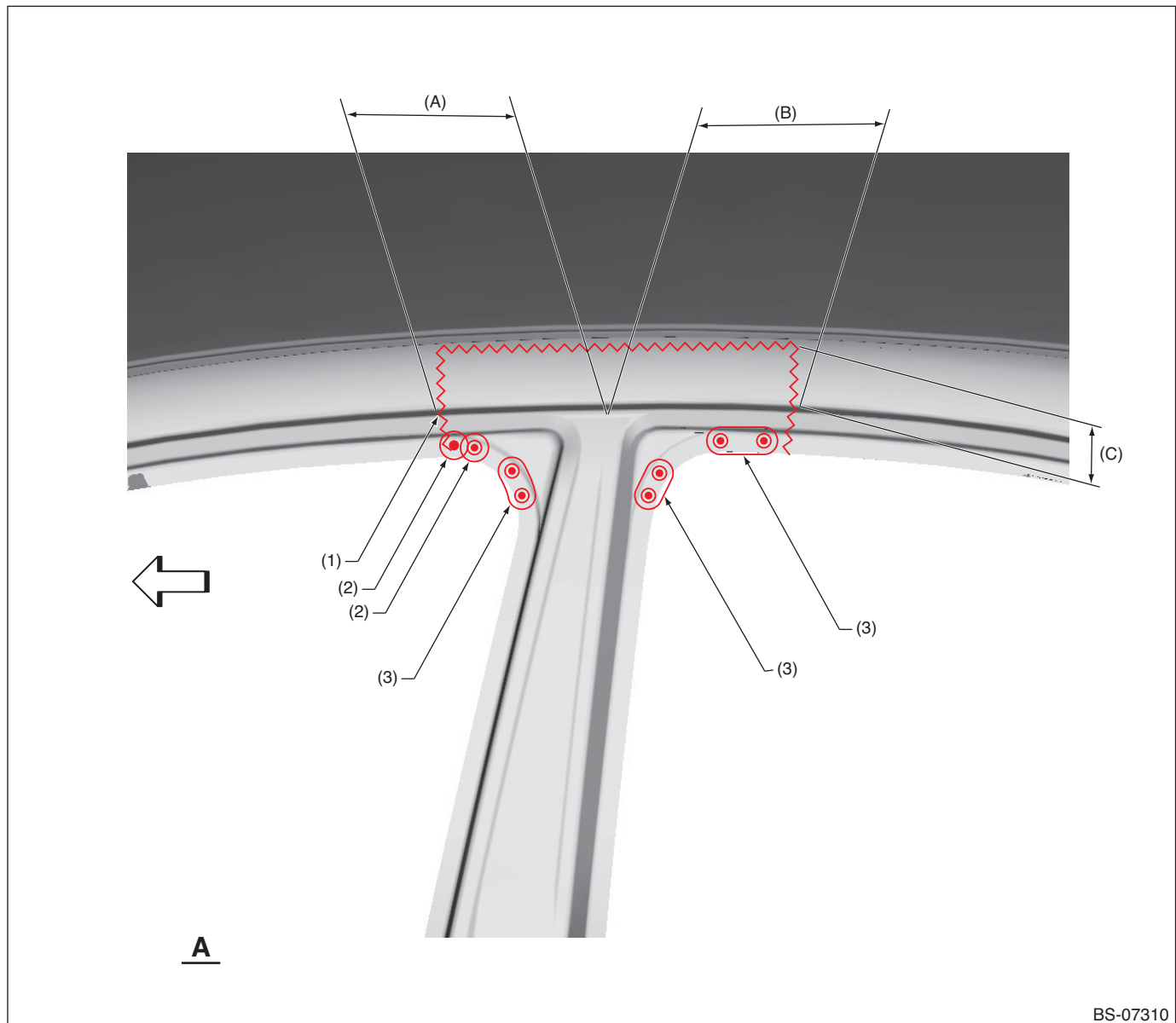
(5) 13 points

(7) 9 points

(3) 11 points

Panel Replacement

• View A



(A) 160 mm (6.30 in)

(B) 160 mm (6.30 in)

(C) 50 mm (1.97 in)

(1) Cut position

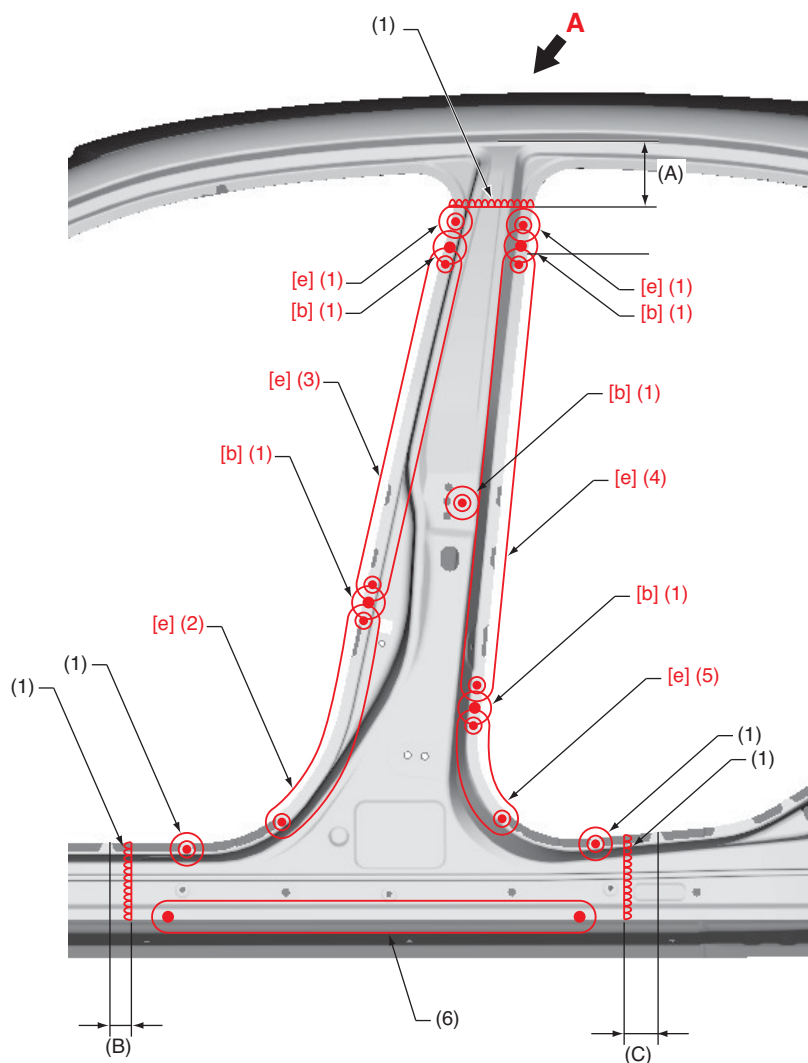
(2) 1 point

(3) 2 points

Panel Replacement

B: INSTALLATION

- **Overall view**



BS-07311

(A) 110 mm (4.33 in)

(B) 30 mm (1.18 in)

(C) 40 mm (1.57 in)

(1) 1 point

(3) 12 points

(5) 7 points

(2) 11 points

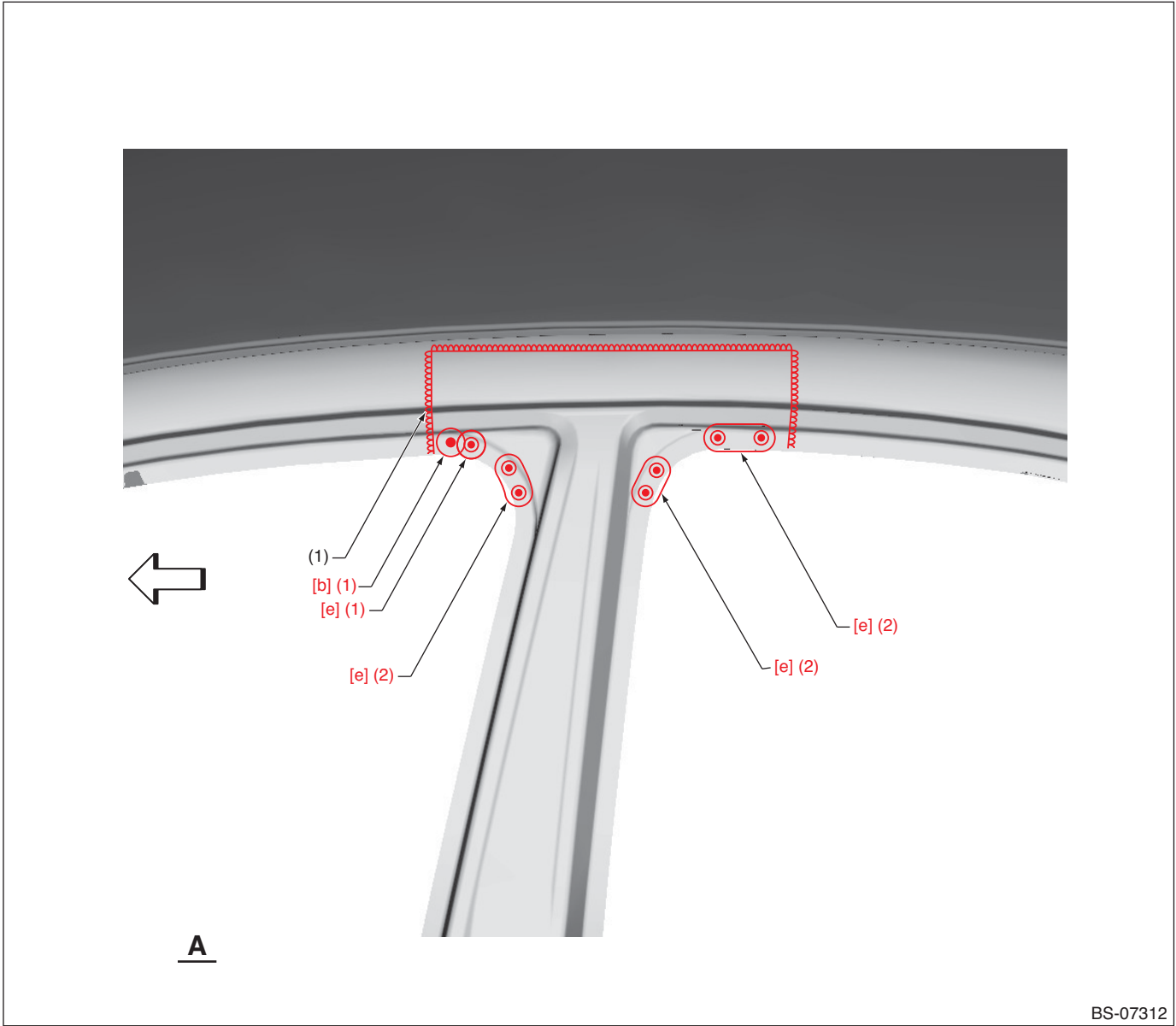
(4) 13 points

(6) 9 points

[b] Spot welding	Compression: 4.0 kN, Current: 6.5 kA, Welding time: 15 cyc
[e] Spot welding	Compression: 4.4 kN, Current: 8.0 kA, Welding time: 20 cyc

Panel Replacement

- View A



BS-07312

(1) 1 point

(2) 2 points

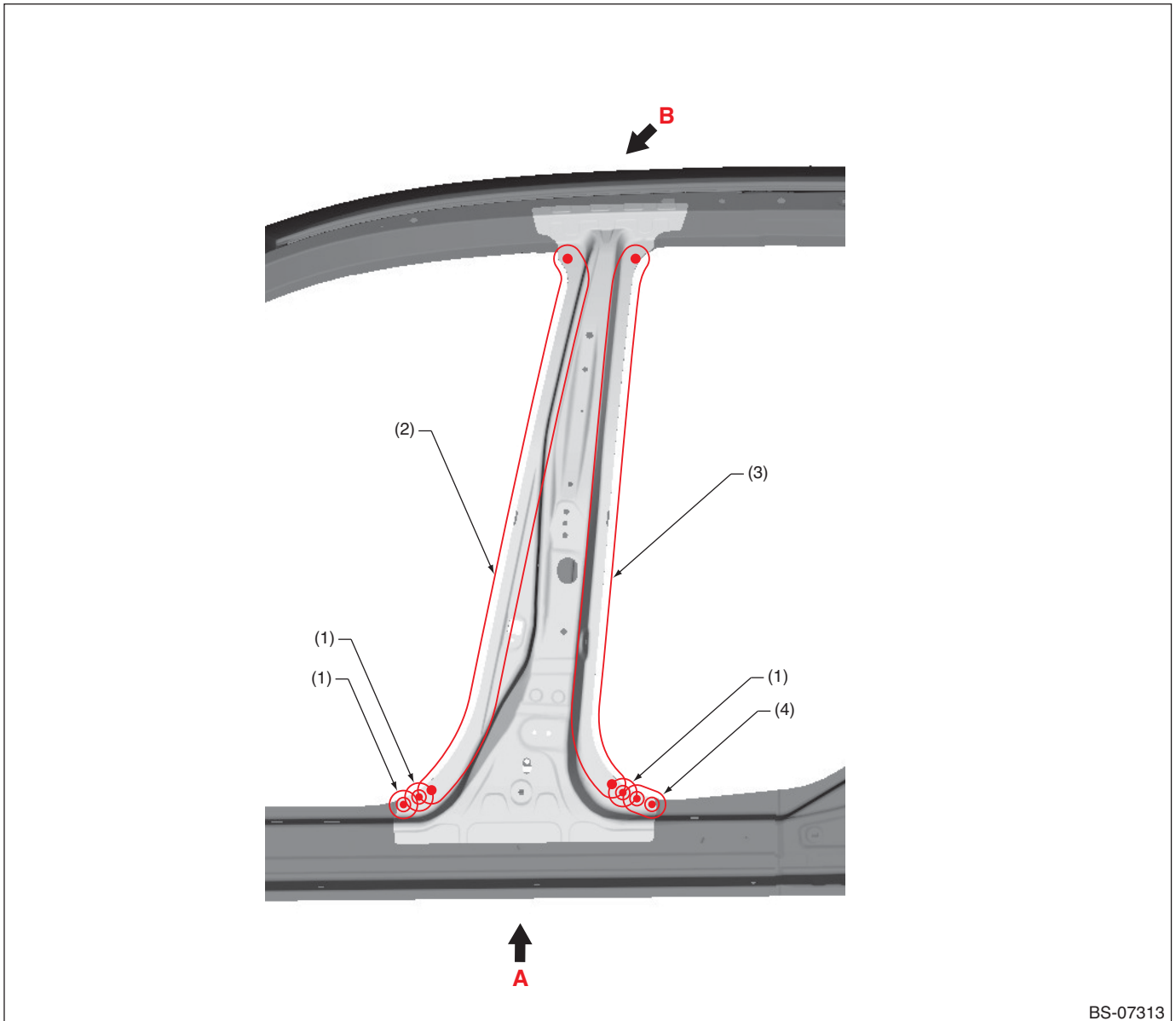
[b] Spot welding	Compression: 4.0 kN, Current: 6.5 kA, Welding time: 15 cyc
[e] Spot welding	Compression: 4.4 kN, Current: 8.0 kA, Welding time: 20 cyc

Panel Replacement

8-16. Center Pillar Reinforcement (Total replacement)/OUTBACK

A: REMOVAL

- Overall view (Center pillar outer removal condition)



BS-07313

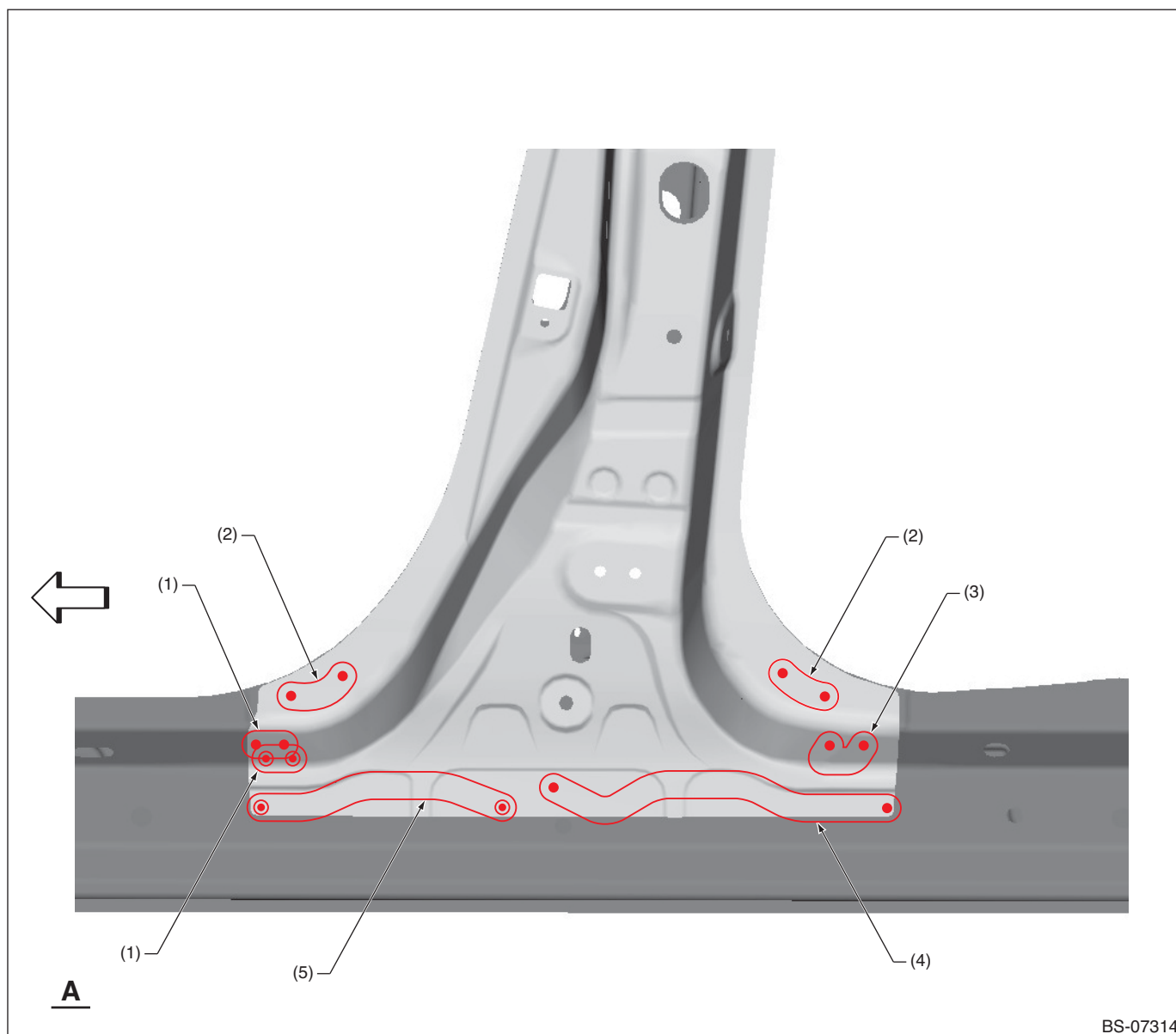
- (1) 1 point
(2) 26 points

- (3) 23 points

- (4) 2 points

Panel Replacement

- View A



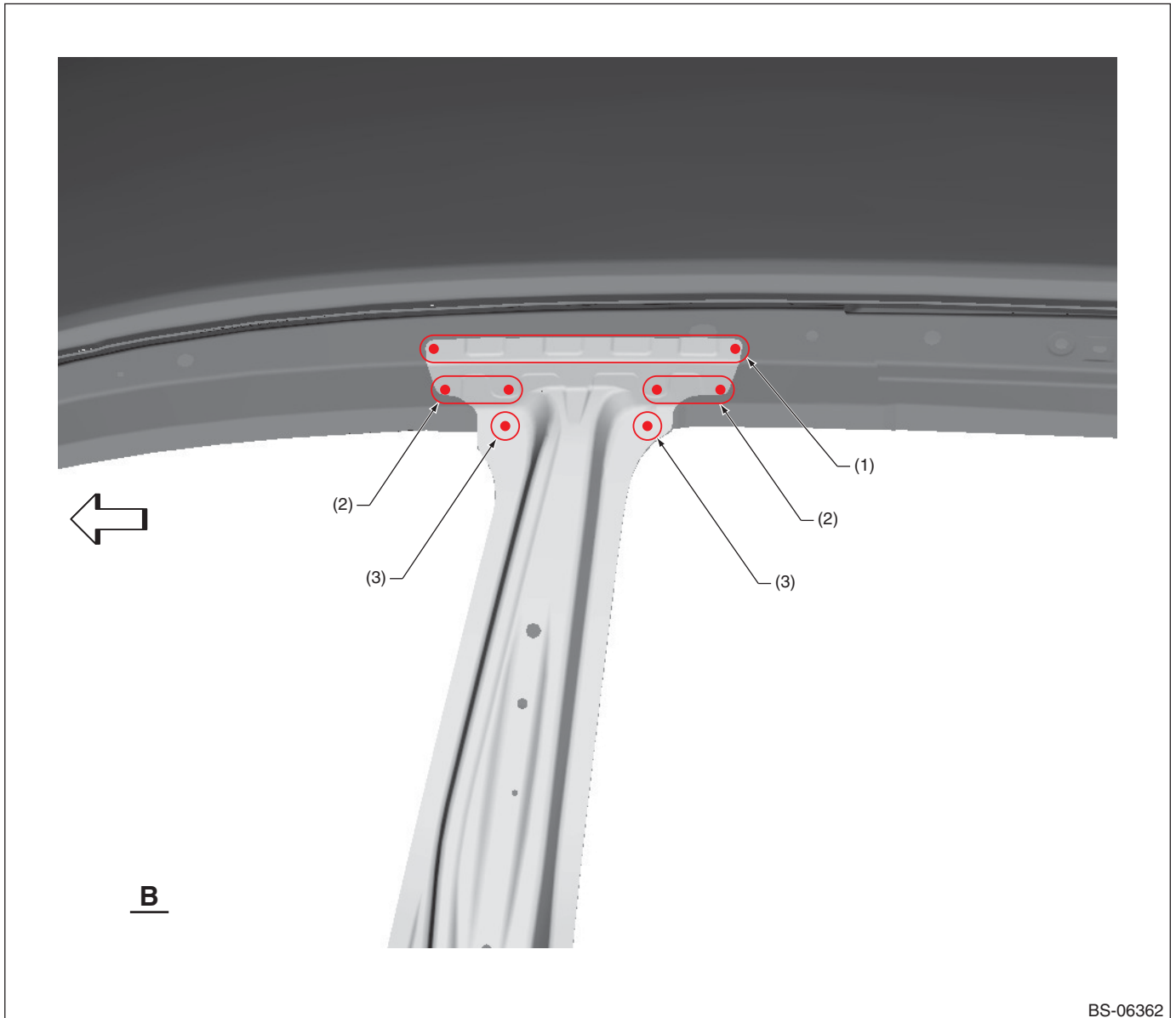
(1) 2 points
(2) 3 points

(3) 4 points
(4) 8 points

(5) 6 points

Panel Replacement

- View B



(1) 5 points

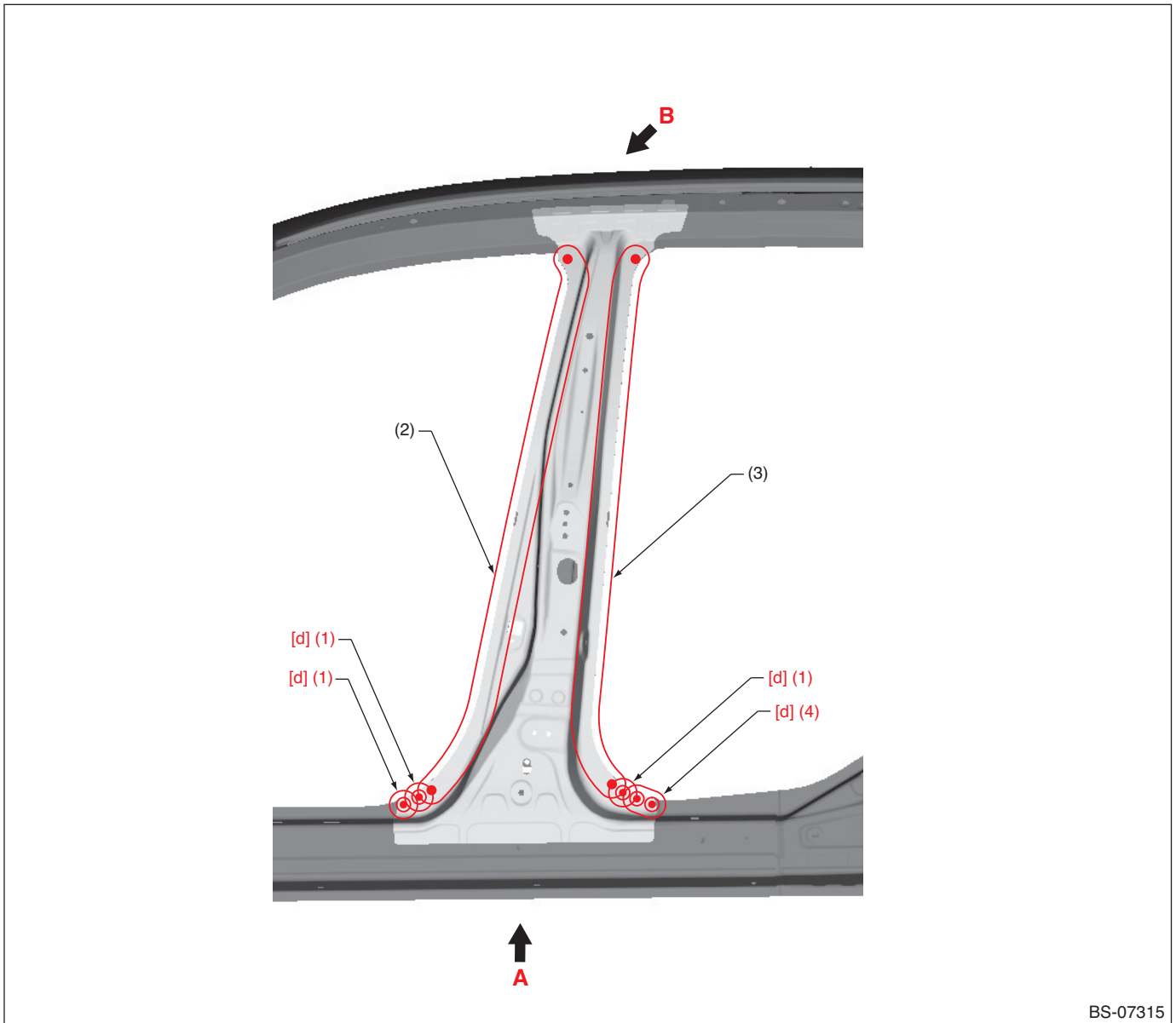
(2) 2 points

(3) 1 point

Panel Replacement

B: INSTALLATION

- Overall view



(1) 1 point
(2) 26 points

(3) 23 points

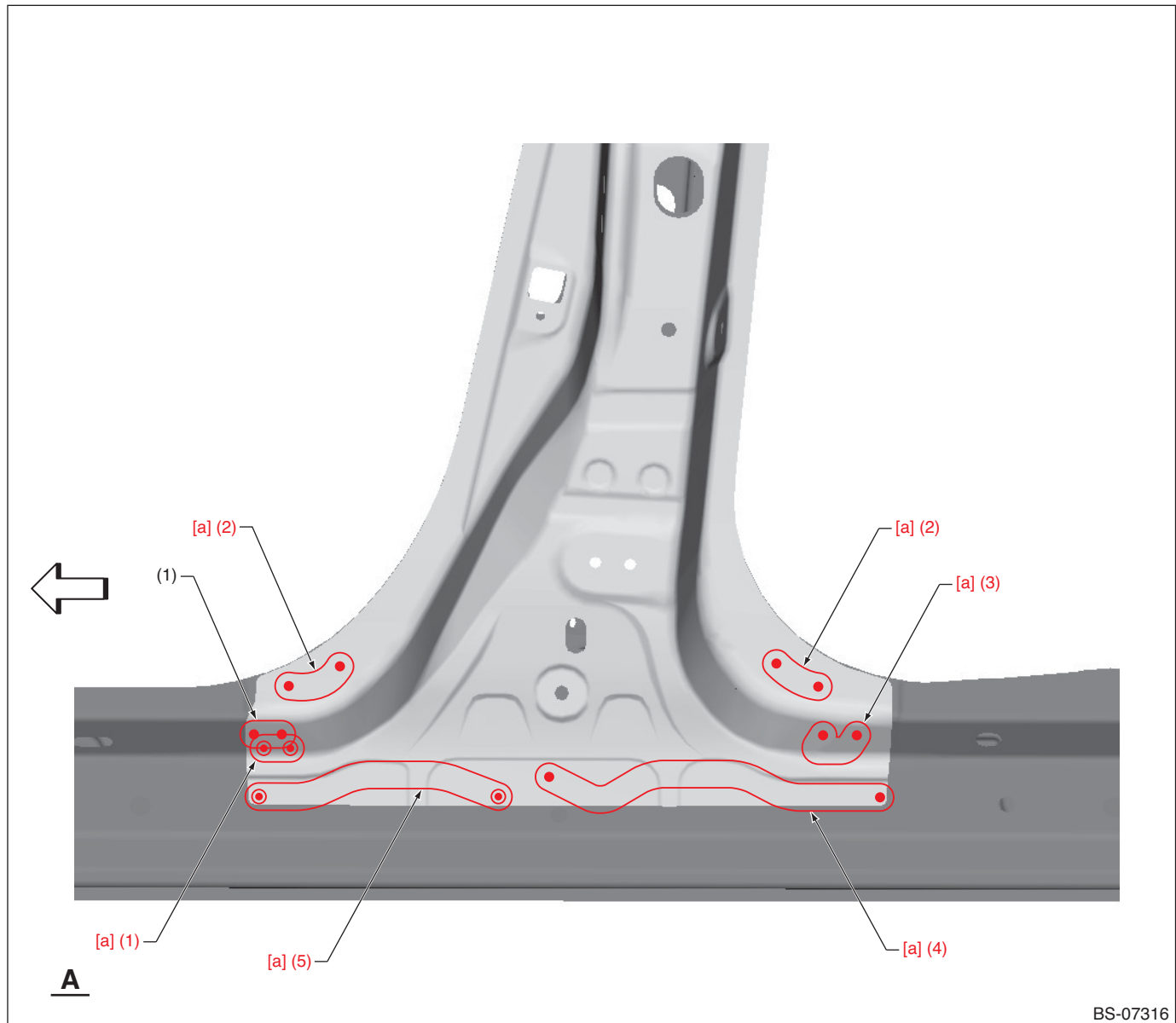
(4) 2 points

[d] Spot welding

Compression: 4.4 kN, Current: 8.0 kA, Welding time: 25 cyc

Panel Replacement

- View A



(1) 2 points
(2) 3 points

(3) 4 points
(4) 8 points

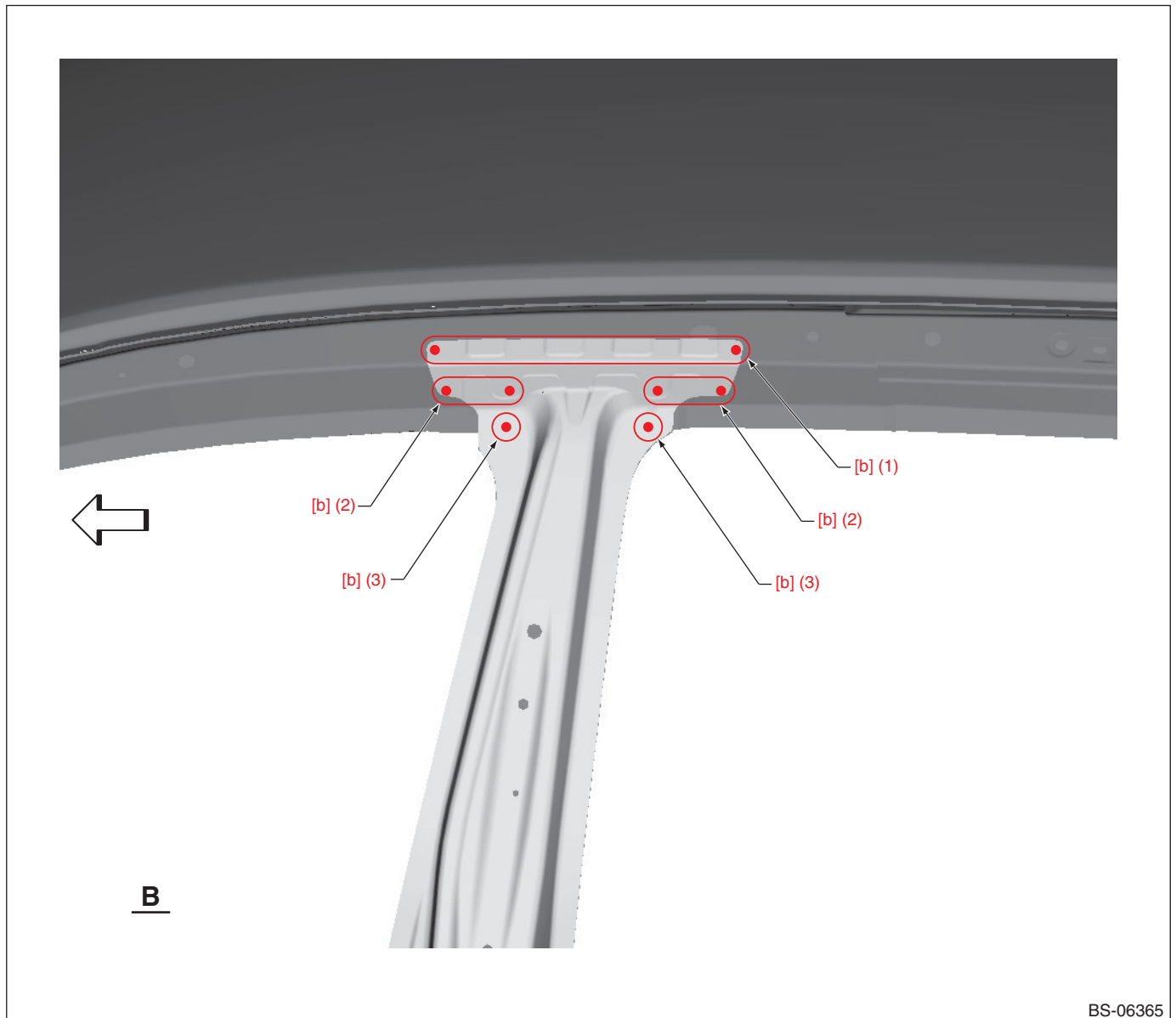
(5) 6 points

[a] Spot welding

Compression: 4.0 kN, Current: 8.0 kA, Welding time: 15 cyc

Panel Replacement

- View B



BS-06365

(1) 5 points

(2) 2 points

(3) 1 point

[b] Spot welding

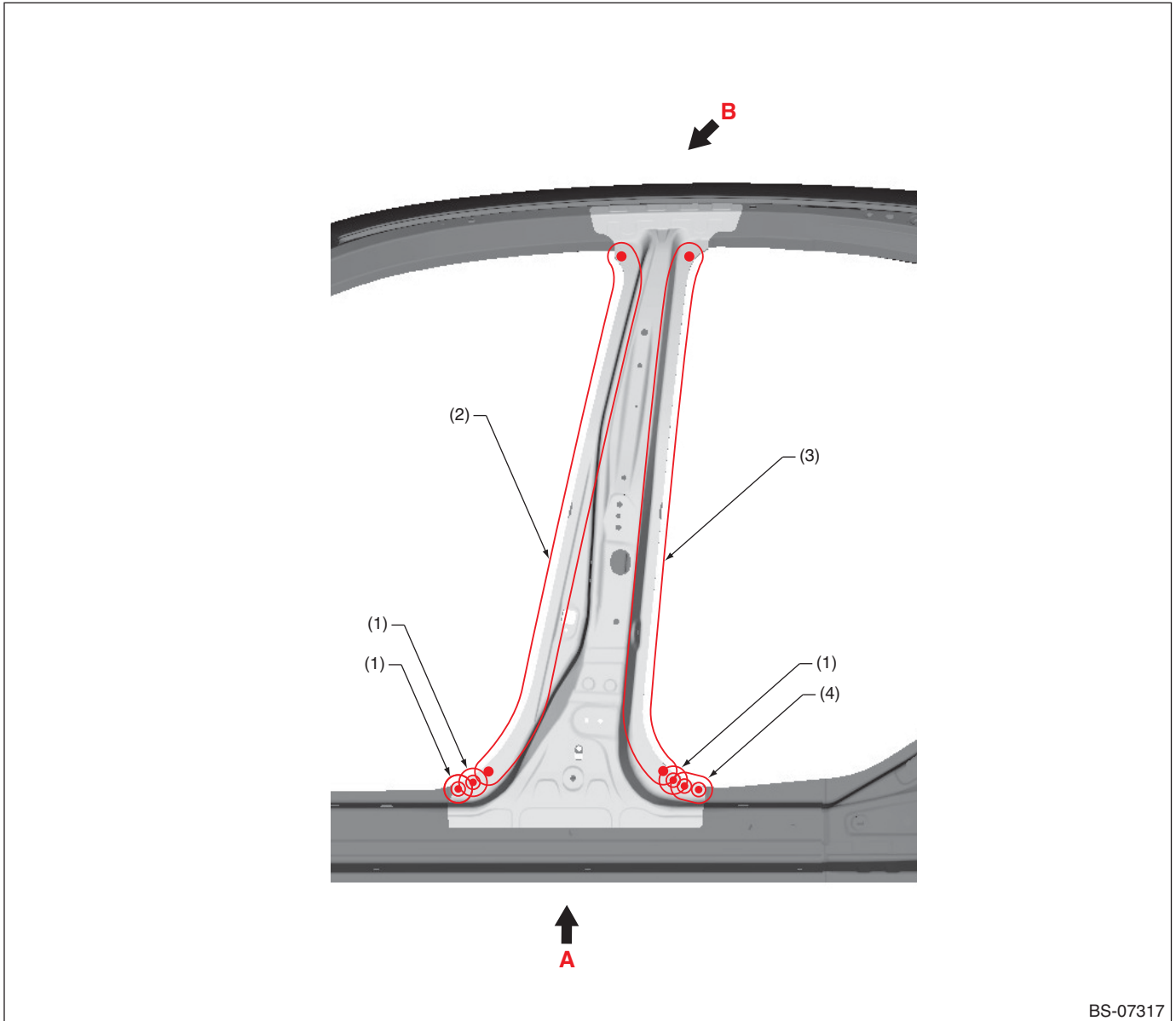
Compression: 4.0 kN, Current: 6.5 kA, Welding time: 15 cyc

Panel Replacement

8-17. Center Pillar Reinforcement (Total replacement)/SEDAN

A: REMOVAL

- Overall view (Center pillar outer removal condition)



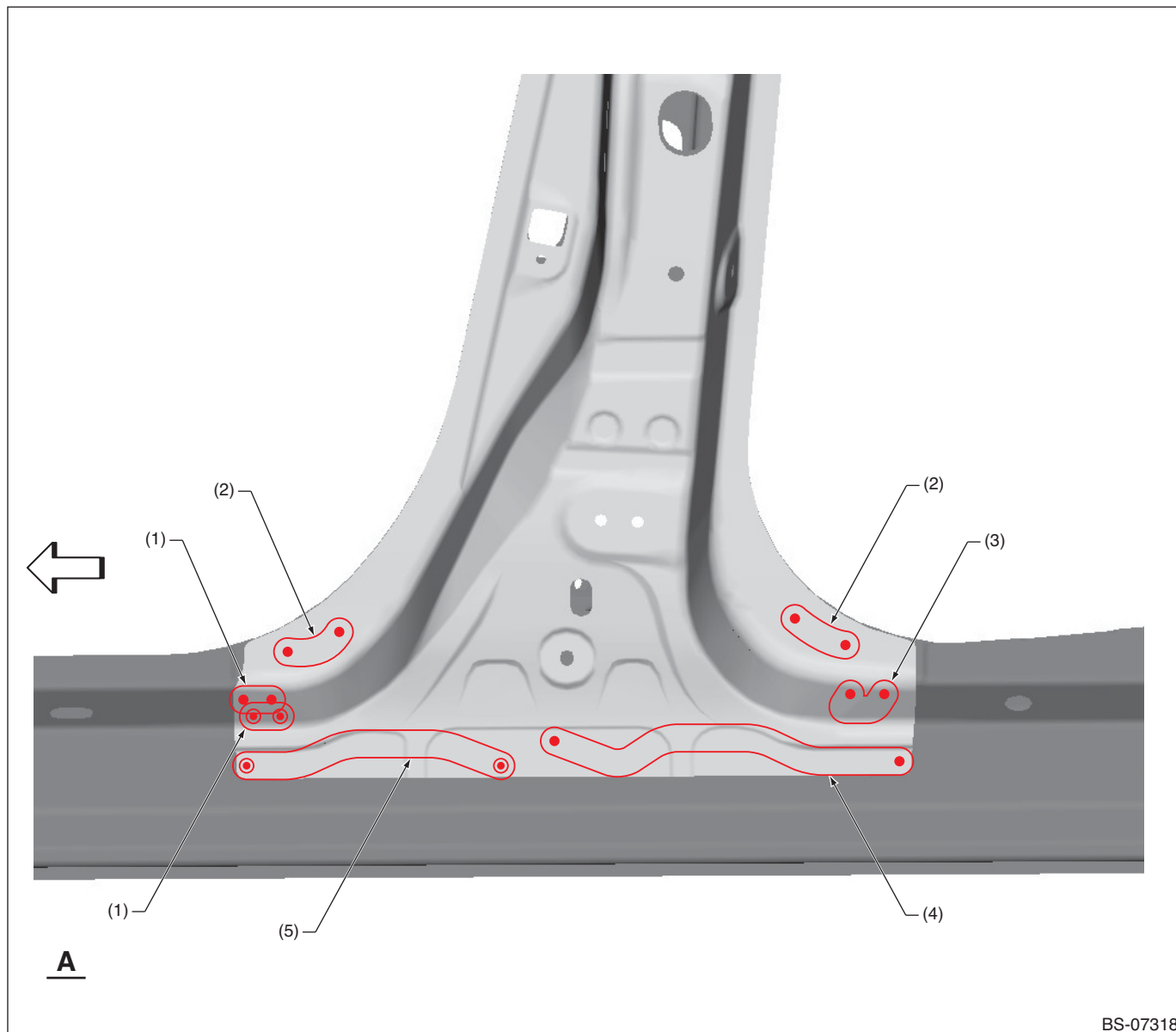
(1) 1 point
(2) 26 points

(3) 23 points

(4) 2 points

Panel Replacement

- View A



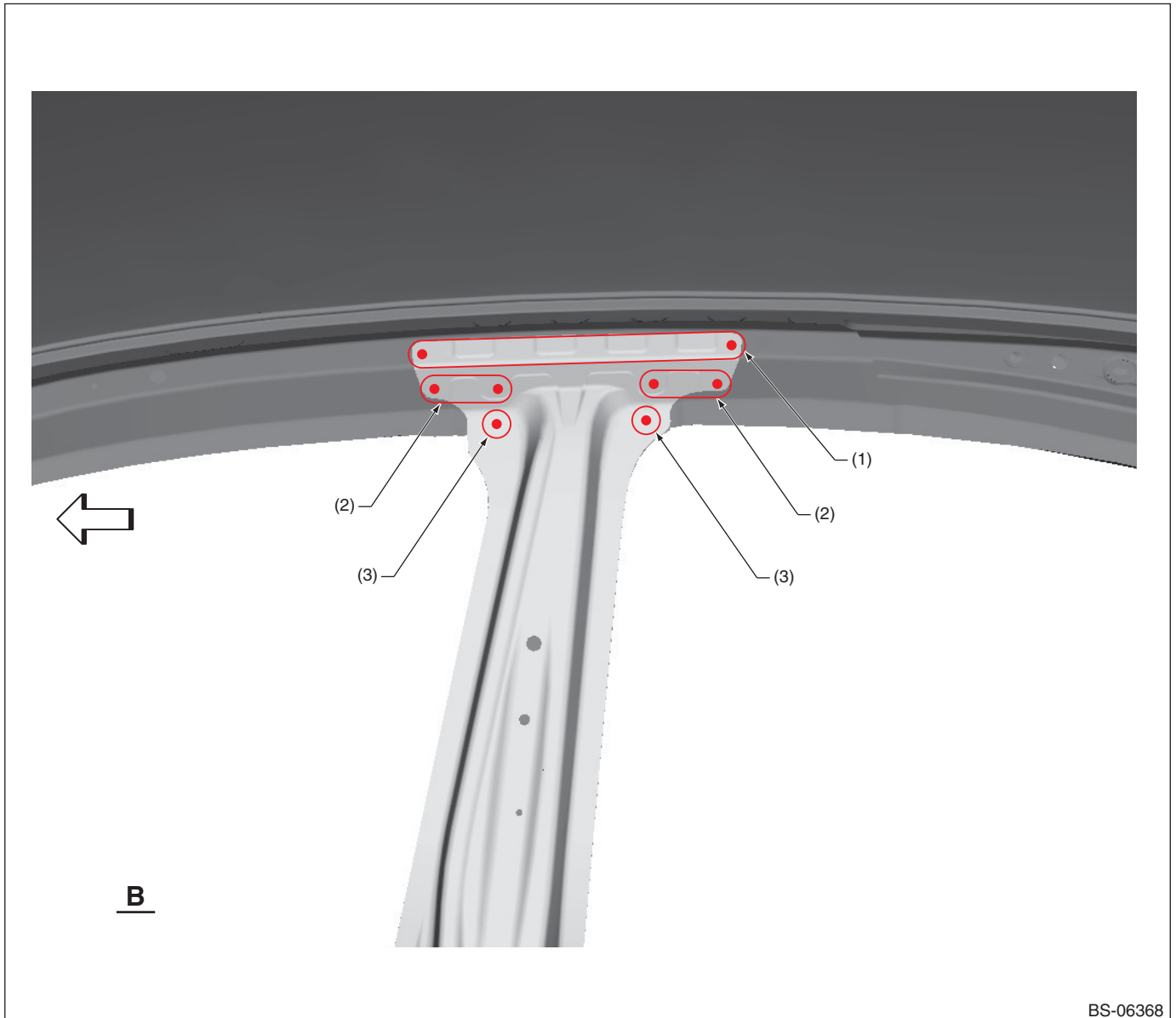
(1) 2 points
(2) 3 points

(3) 4 points
(4) 8 points

(5) 6 points

Panel Replacement

- View B



BS-06368

(1) 5 points

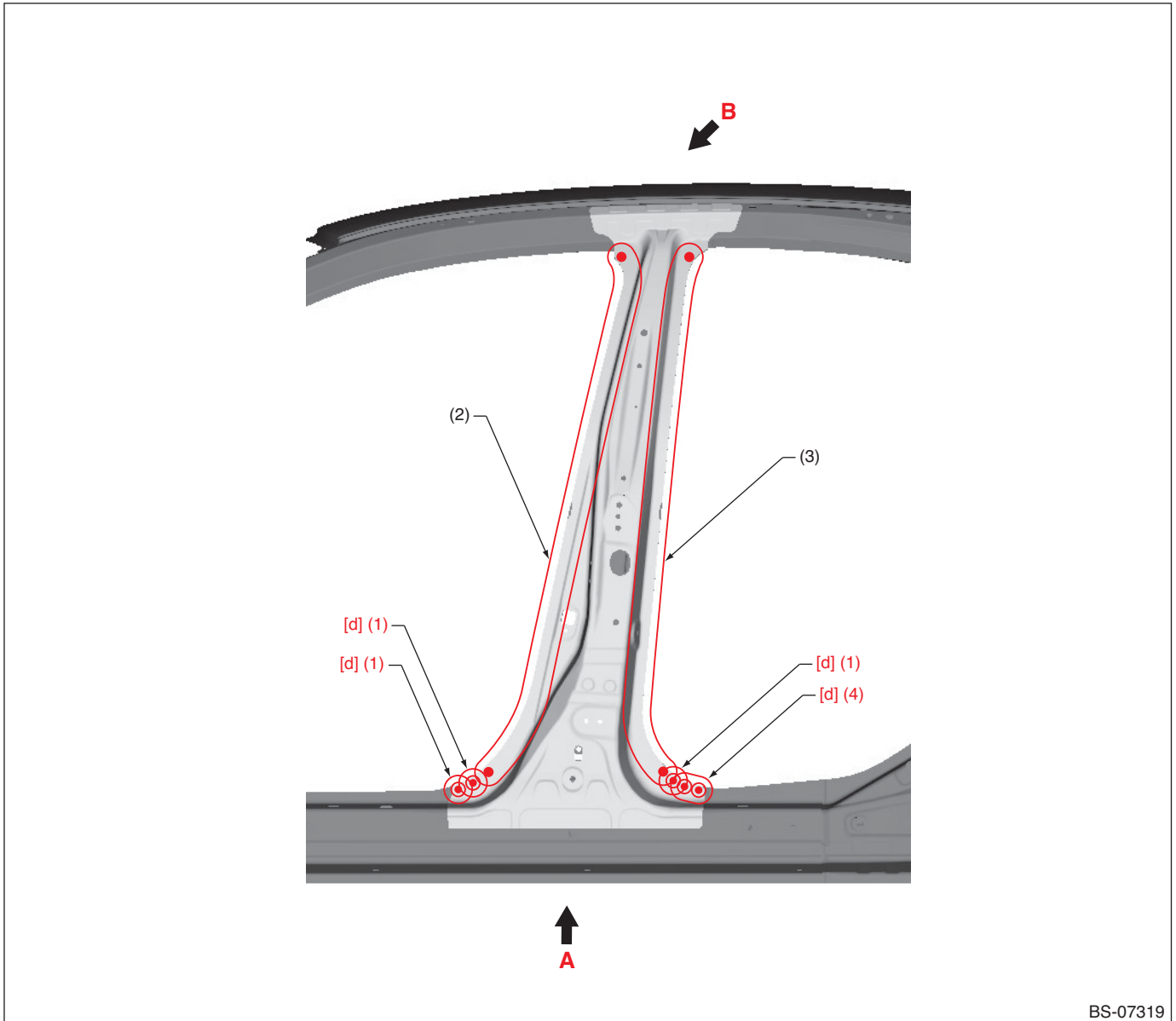
(2) 2 points

(3) 1 point

Panel Replacement

B: INSTALLATION

- Overall view



(1) 1 point
(2) 26 points

(3) 23 points

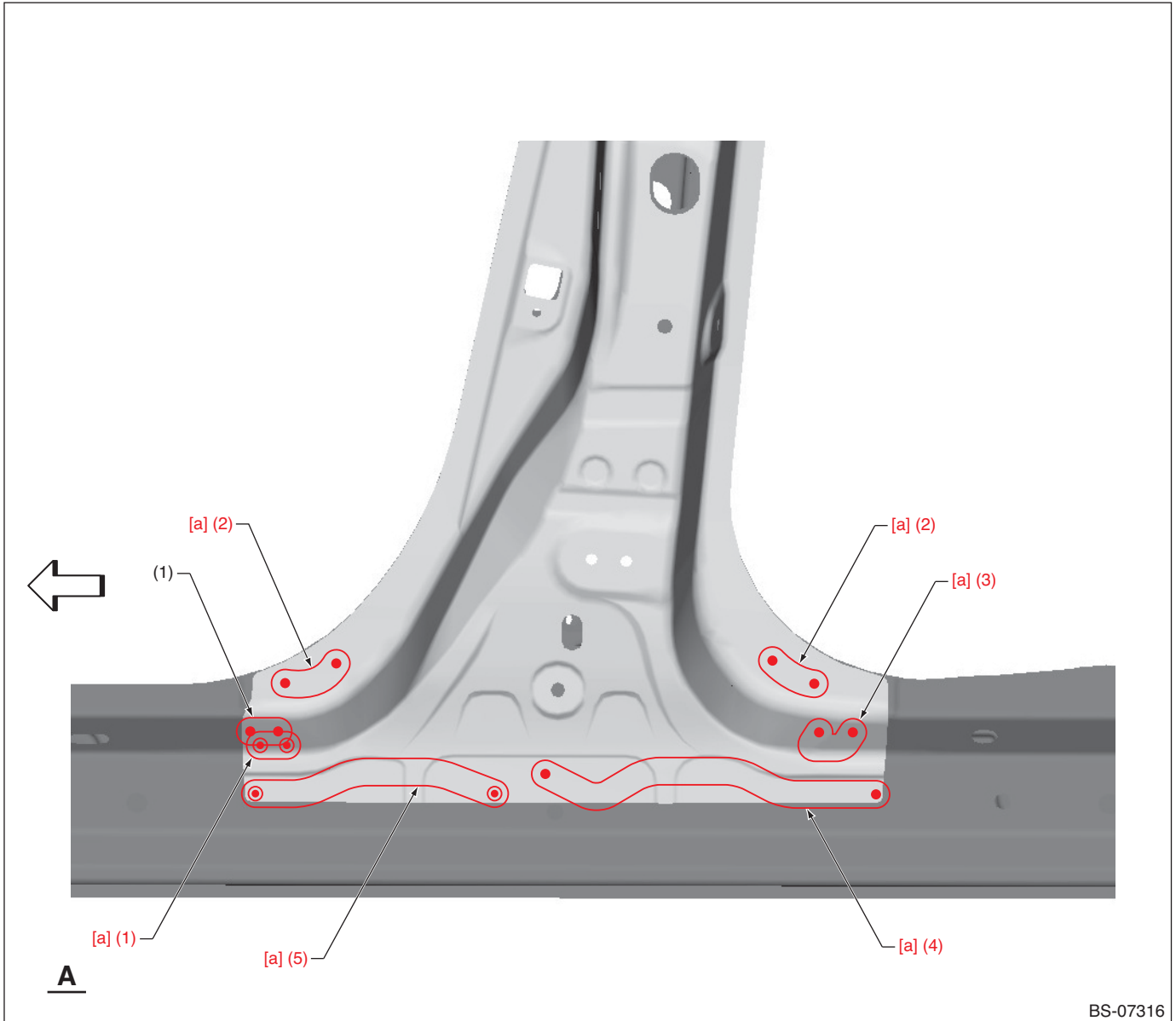
(4) 2 points

[d] Spot welding

Compression: 4.4 kN, Current: 8.0 kA, Welding time: 25 cyc

Panel Replacement

- View A



(1) 2 points
(2) 3 points

(3) 4 points
(4) 8 points

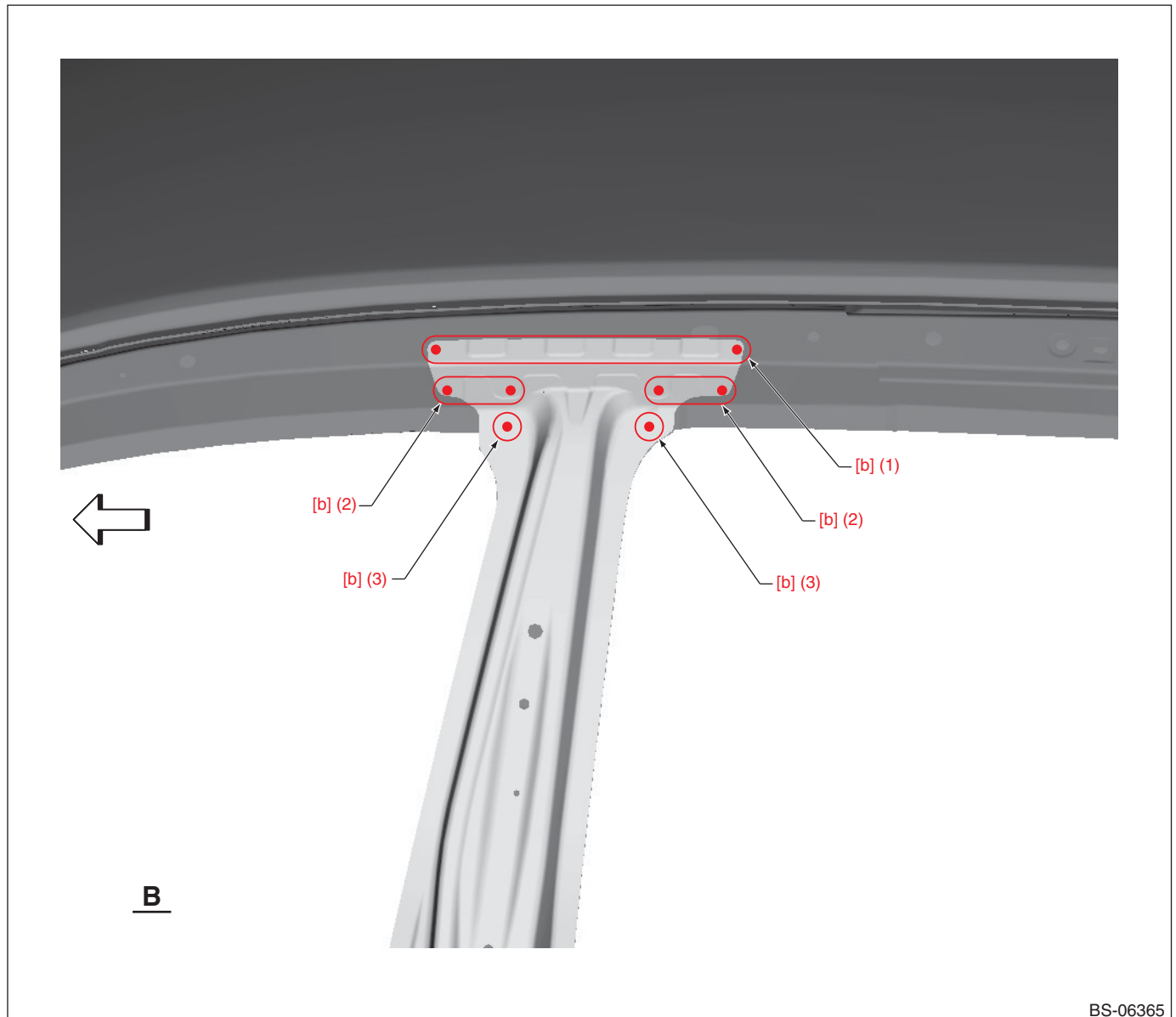
(5) 6 points

[a] Spot welding

Compression: 4.0 kN, Current: 8.0 kA, Welding time: 15 cyc

Panel Replacement

- View B



(1) 5 points

(2) 2 points

(3) 1 point

[b] Spot welding

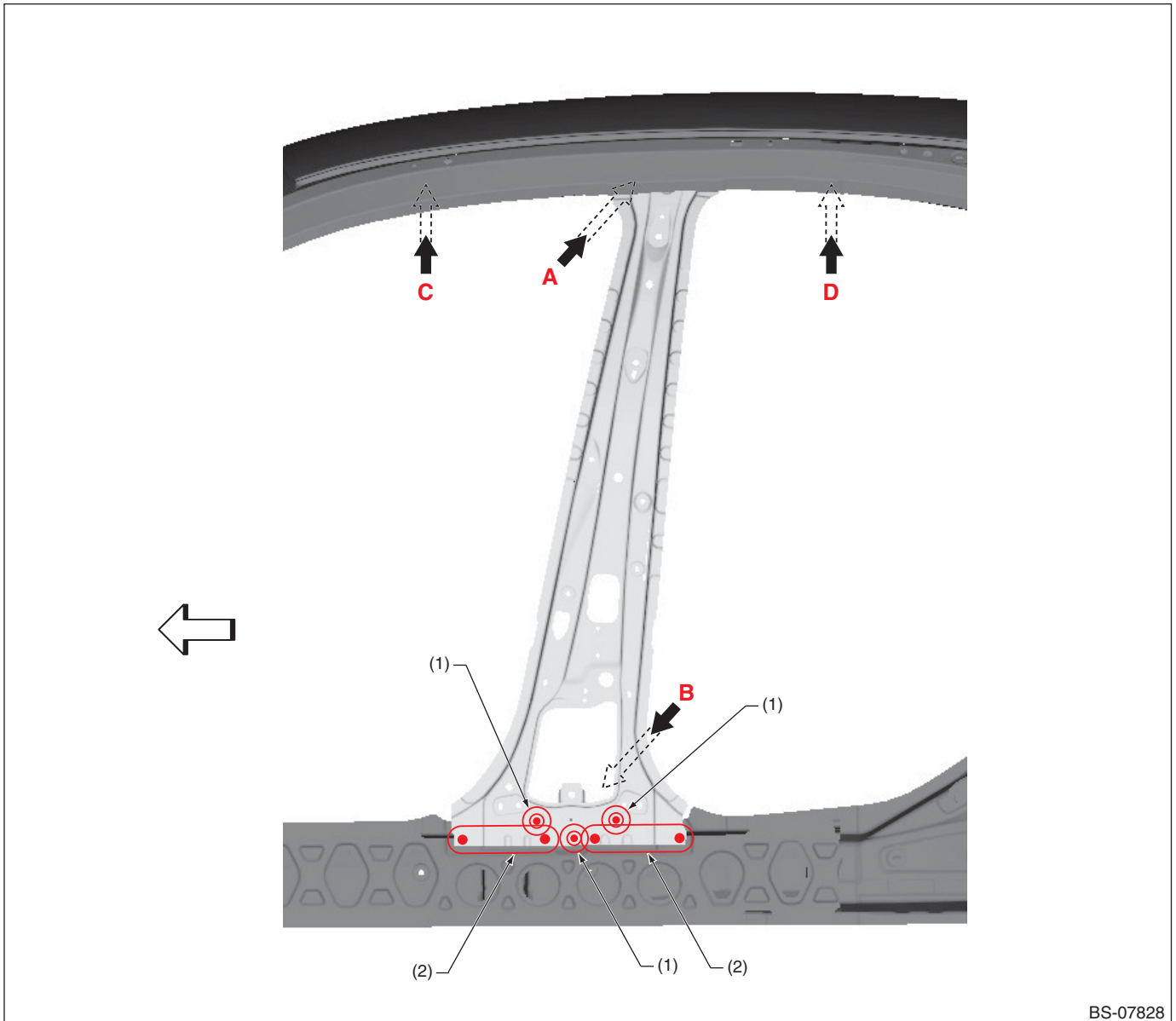
Compression: 4.0 kN, Current: 6.5 kA, Welding time: 15 cyc

Panel Replacement

8-18. Center Pillar Inner (Total replacement)

A: REMOVAL

- Overall view (Center pillar outer, center pillar reinforcement, side sill outer and side sill reinforcement outer removal condition)

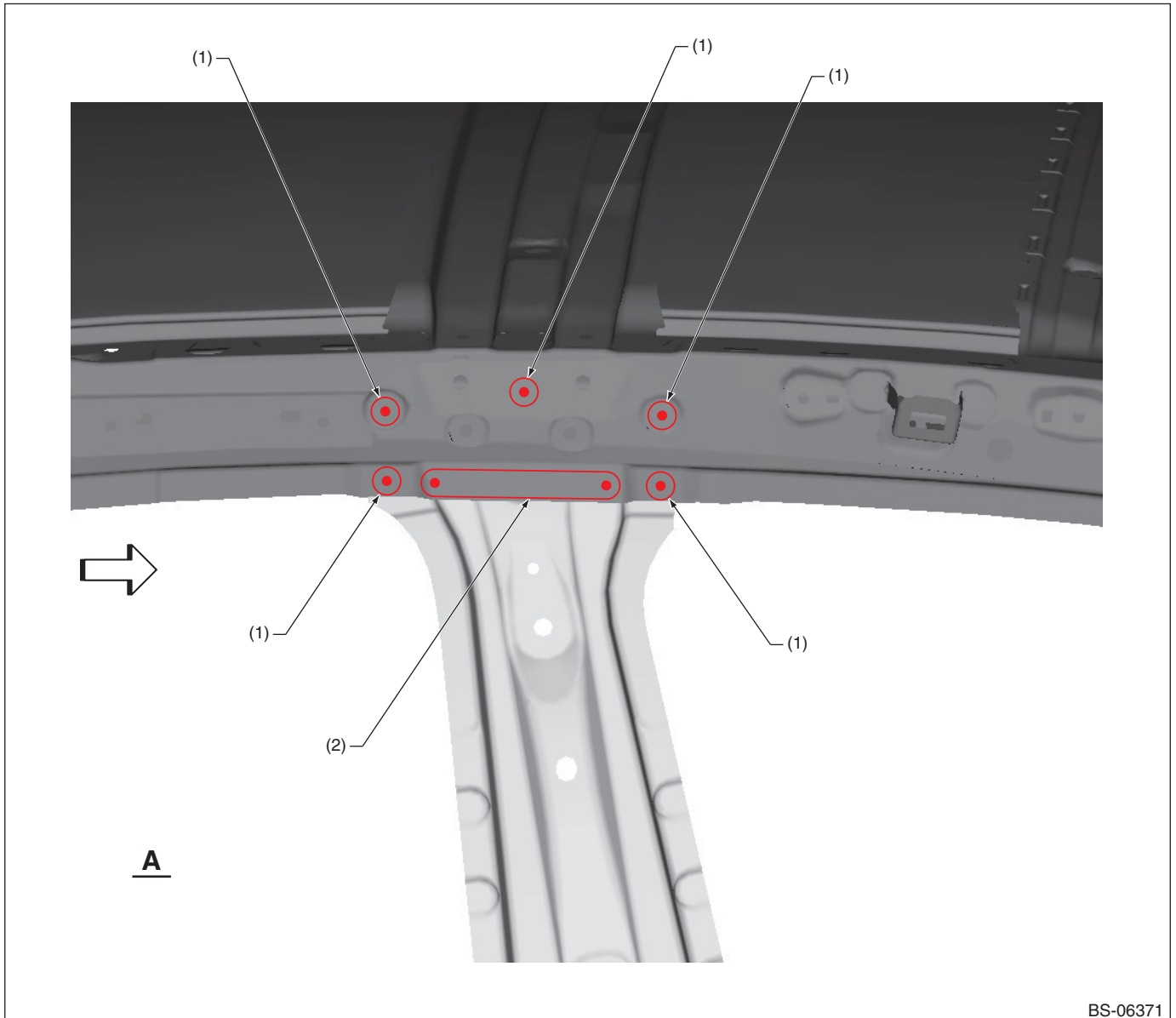


(1) 1 point

(2) 5 points

Panel Replacement

- View A



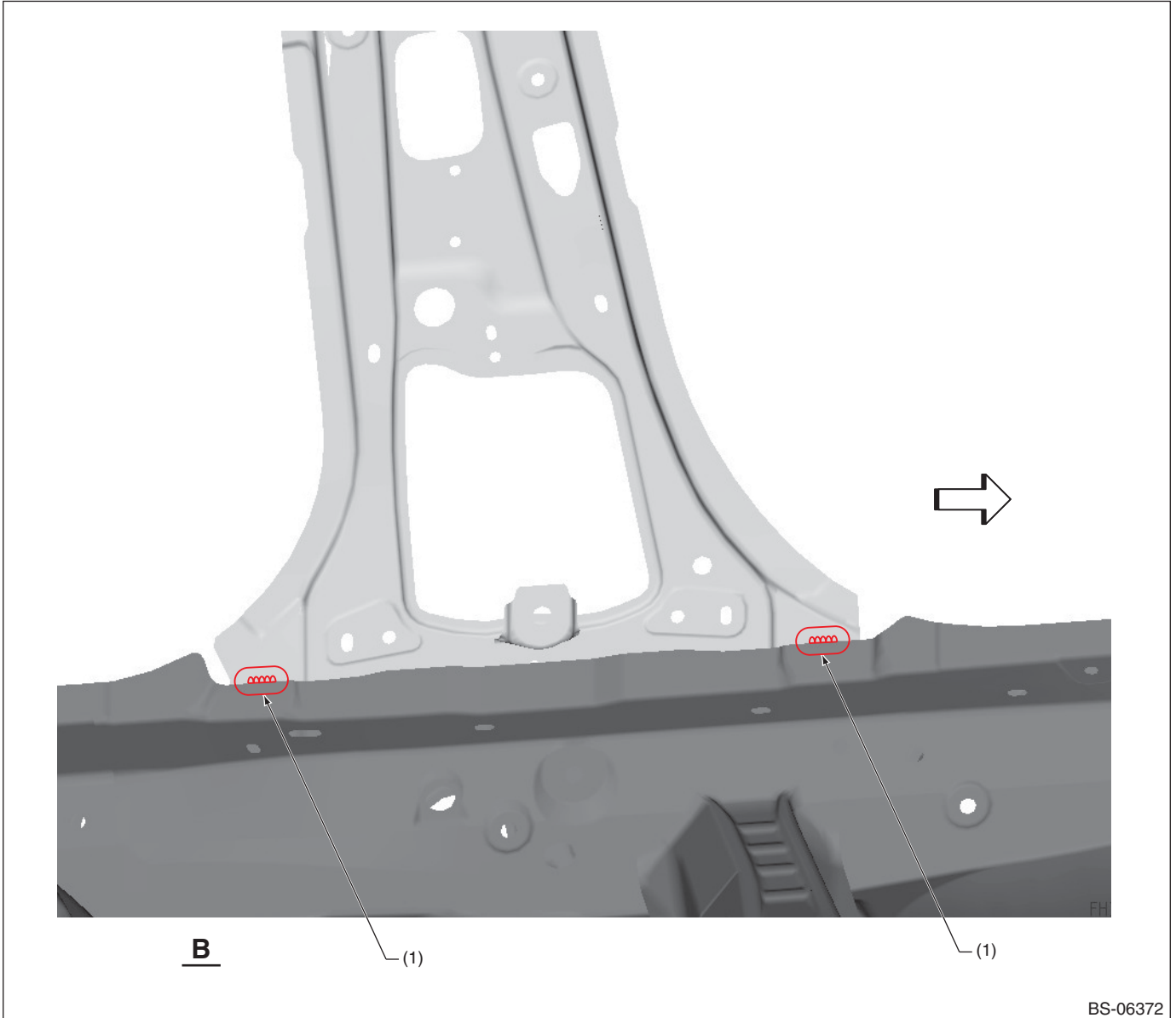
BS-06371

(1) 1 point

(2) 3 points

Panel Replacement

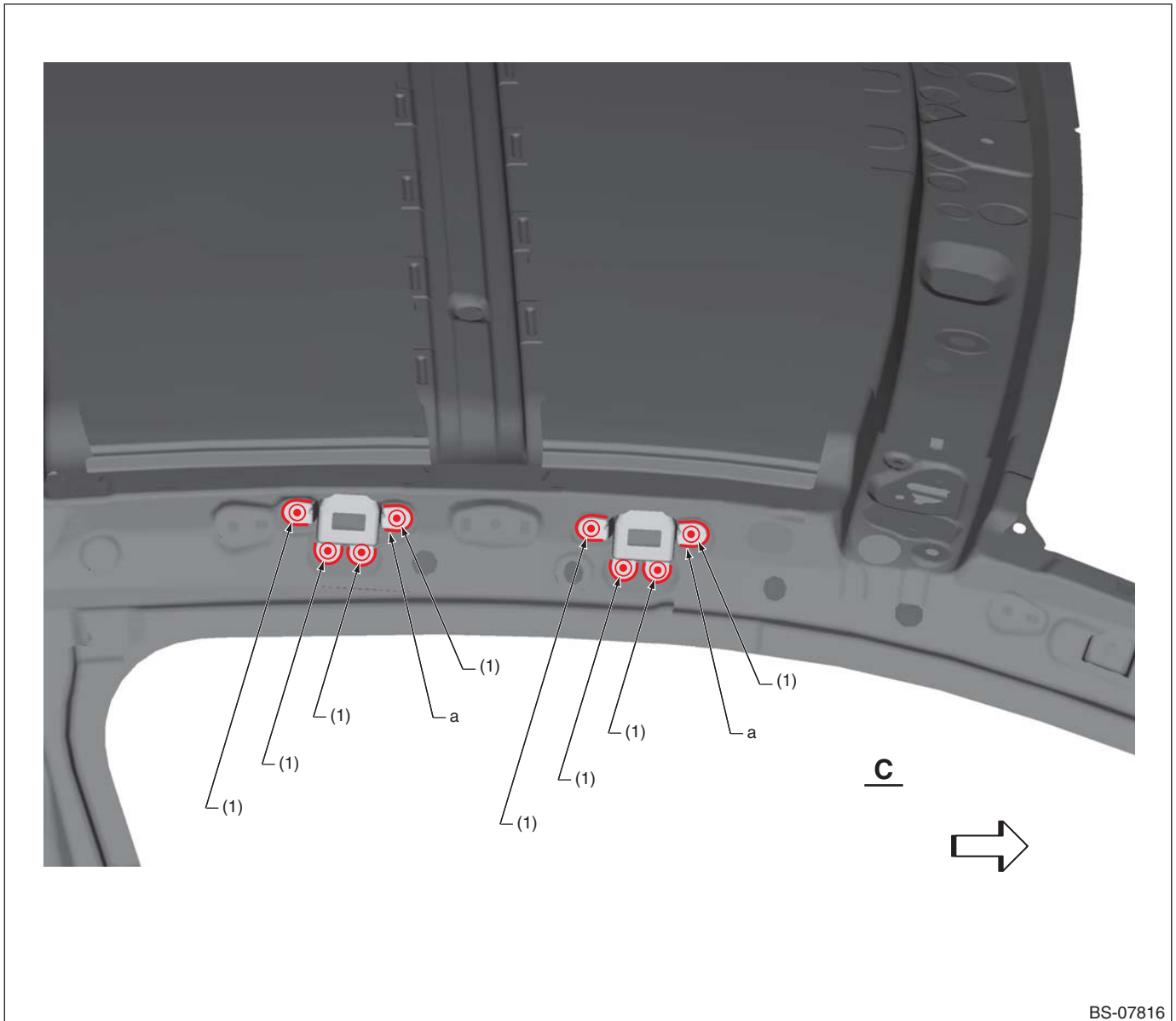
- View B



(1) 1 point

Panel Replacement

- View C



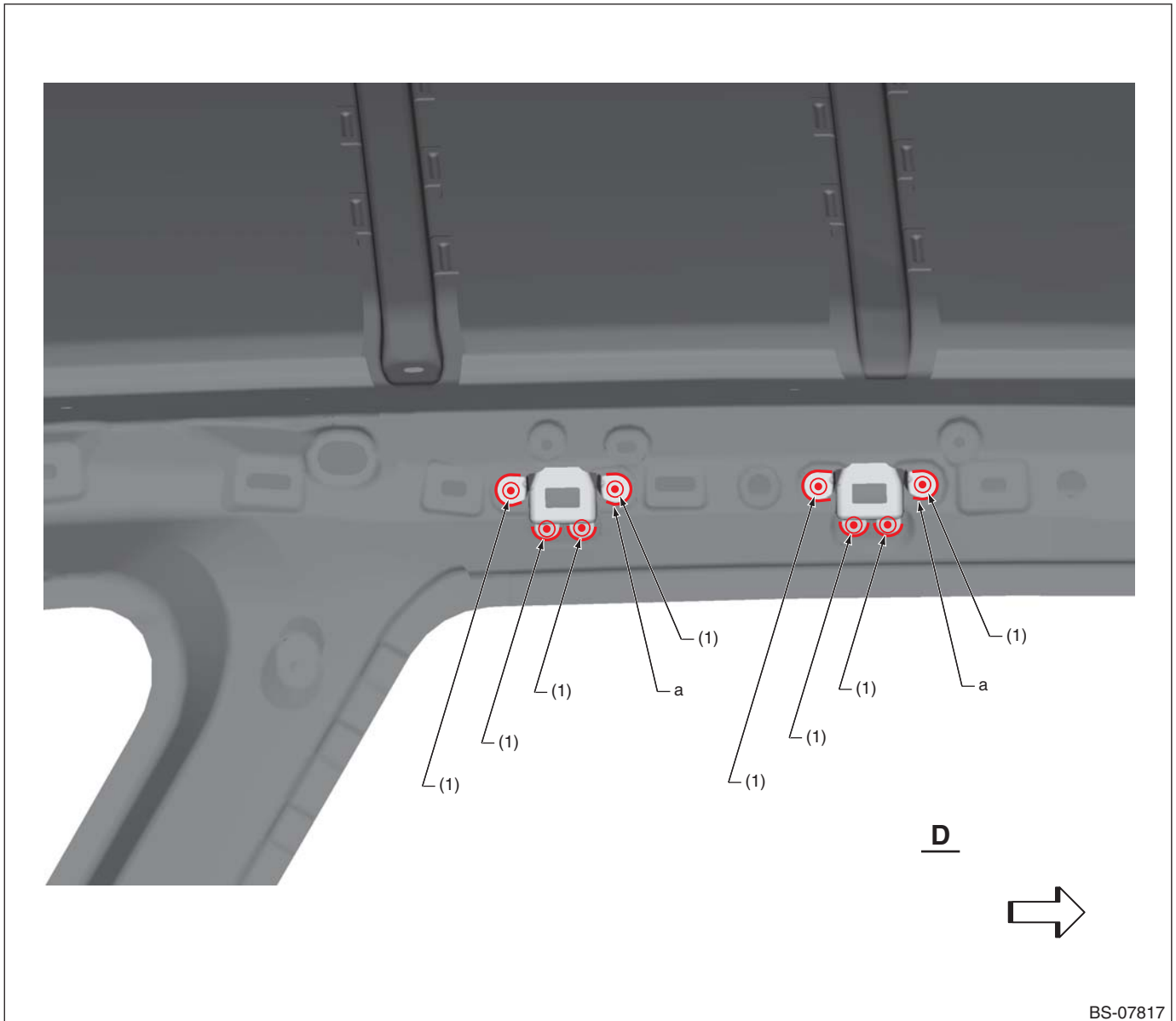
BS-07816

(1) 1 point

a: After the curtain air bag is inflated, visually inspect the assist bracket for deformation. If the bracket is deformed, mark the points "a" (4 points) and then remove the deformed bracket so that a replacement bracket can be installed on the same position.

Panel Replacement

- View D (OUTBACK)



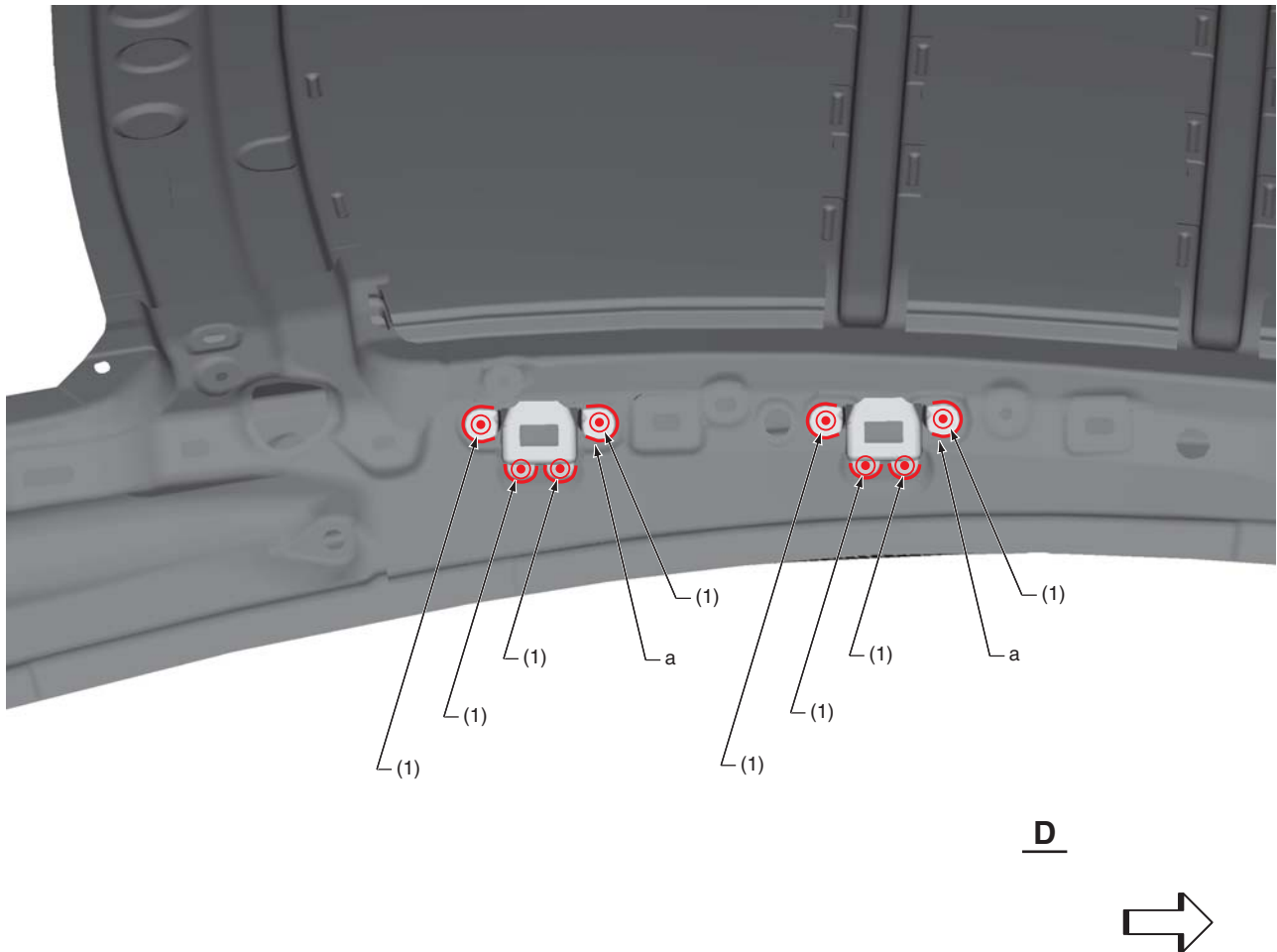
BS-07817

(1) 1 point

a: After the curtain air bag is inflated, visually inspect the assist bracket for deformation. If the bracket is deformed, mark the points "a" (4 points) and then remove the deformed bracket so that a replacement bracket can be installed on the same position.

Panel Replacement

- View D (SEDAN)



BS-07818

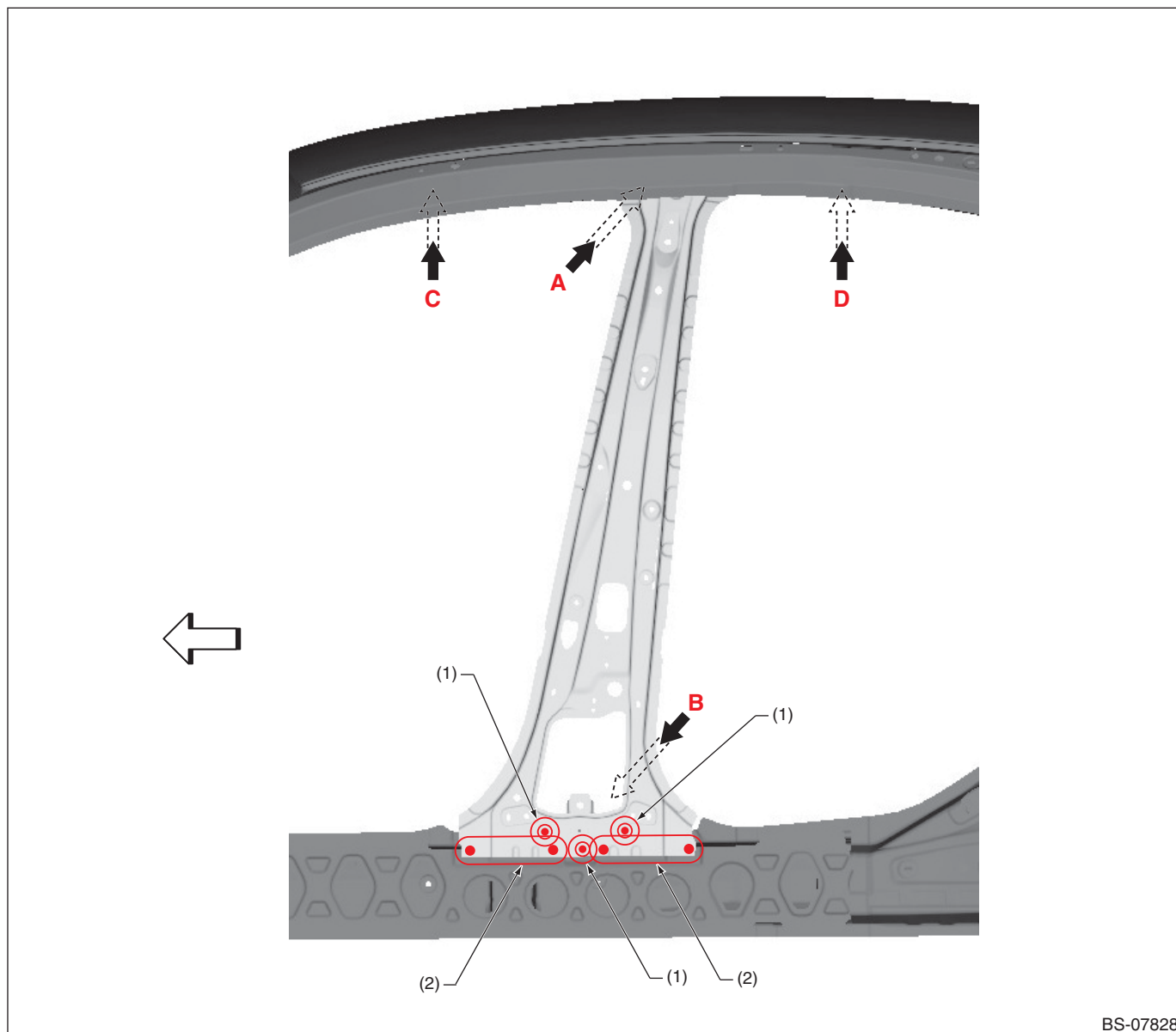
(1) 1 point

a: After the curtain air bag is inflated, visually inspect the assist bracket for deformation. If the bracket is deformed, mark the points "a" (4 points) and then remove the deformed bracket so that a replacement bracket can be installed on the same position.

Panel Replacement

B: INSTALLATION

- Overall view

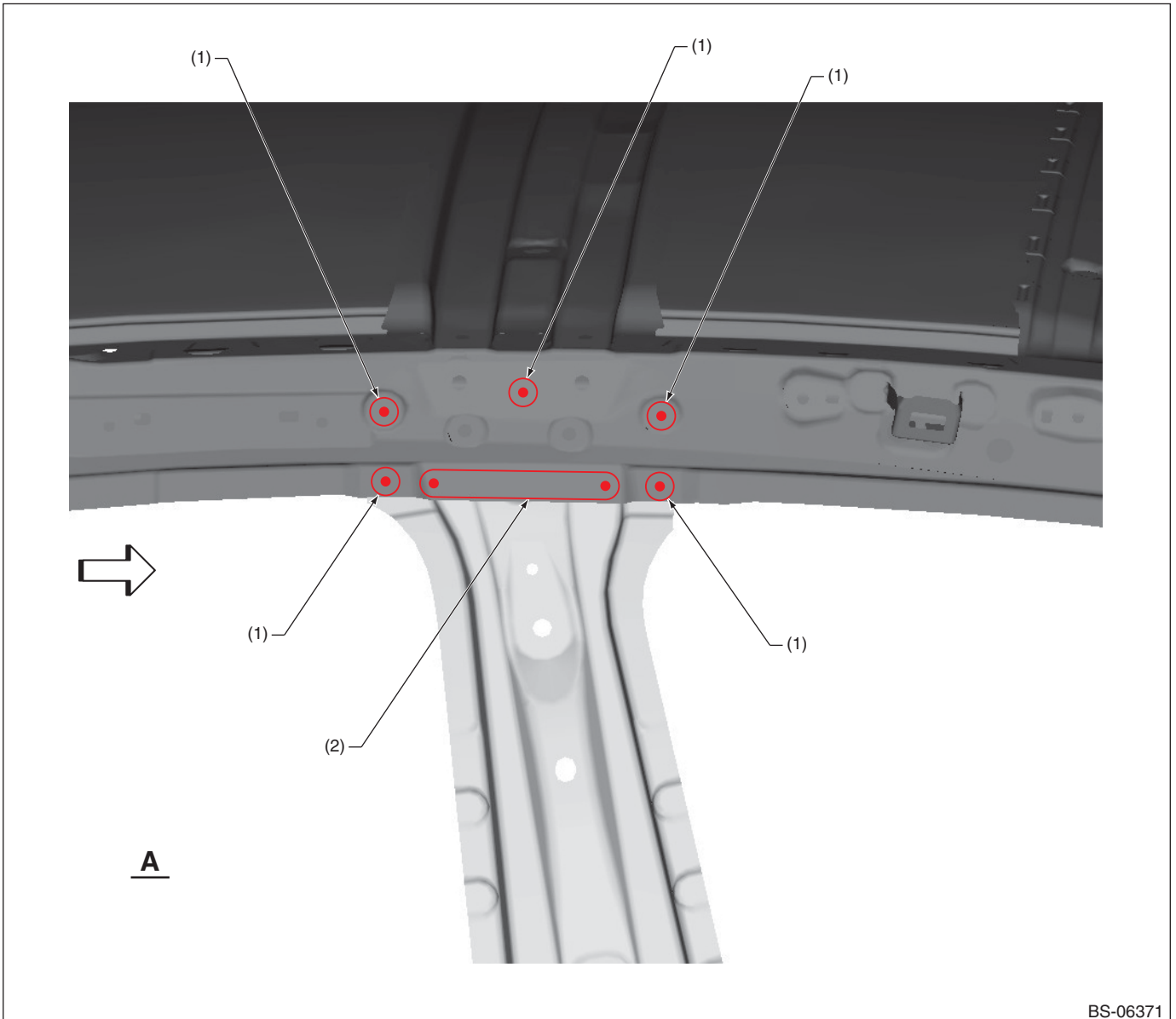


(1) 1 point

(2) 5 points

Panel Replacement

- View A



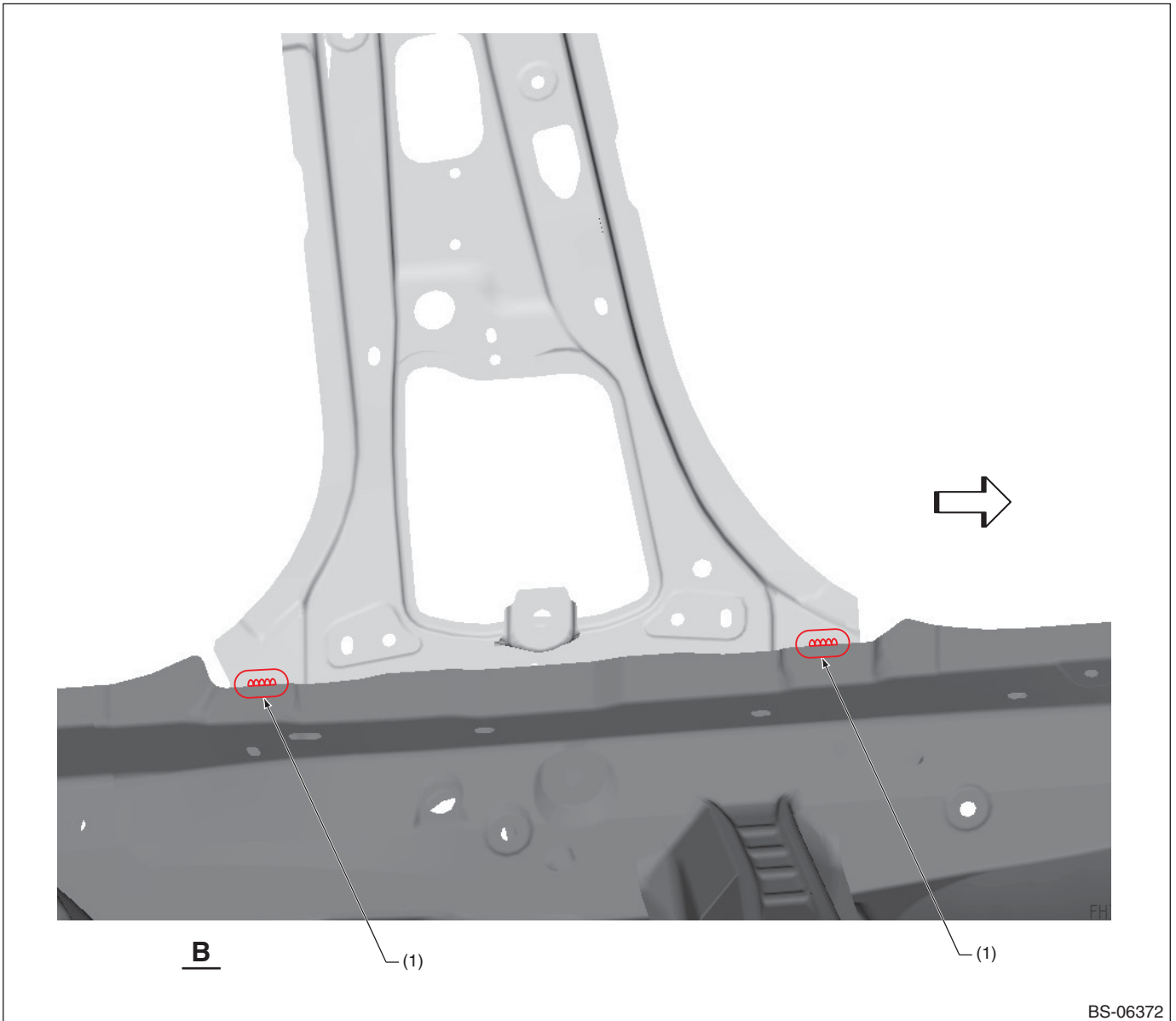
BS-06371

(1) 1 point

(2) 3 points

Panel Replacement

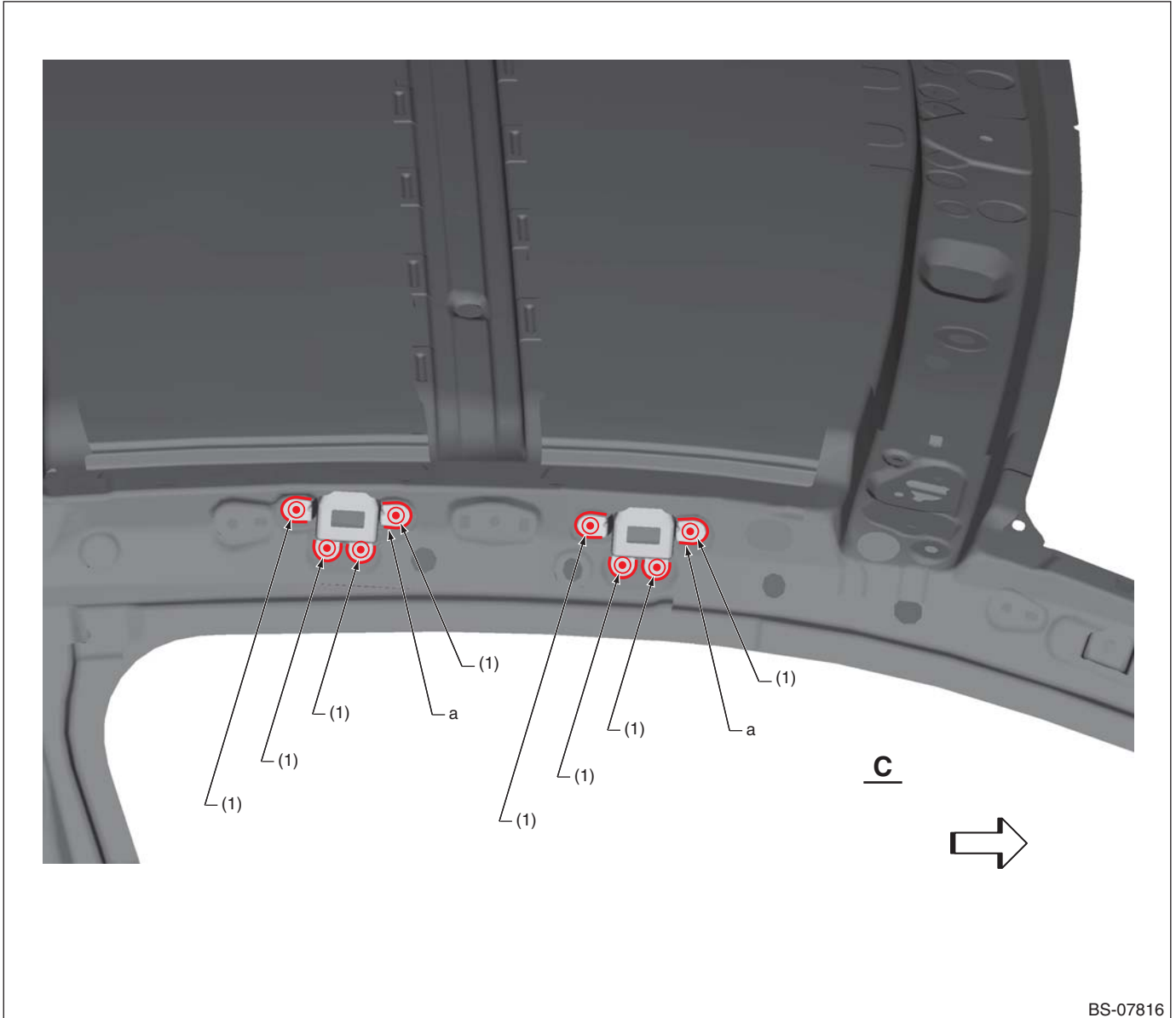
- View B



(1) 1 point [25 mm (0.98 in)]

Panel Replacement

- View C



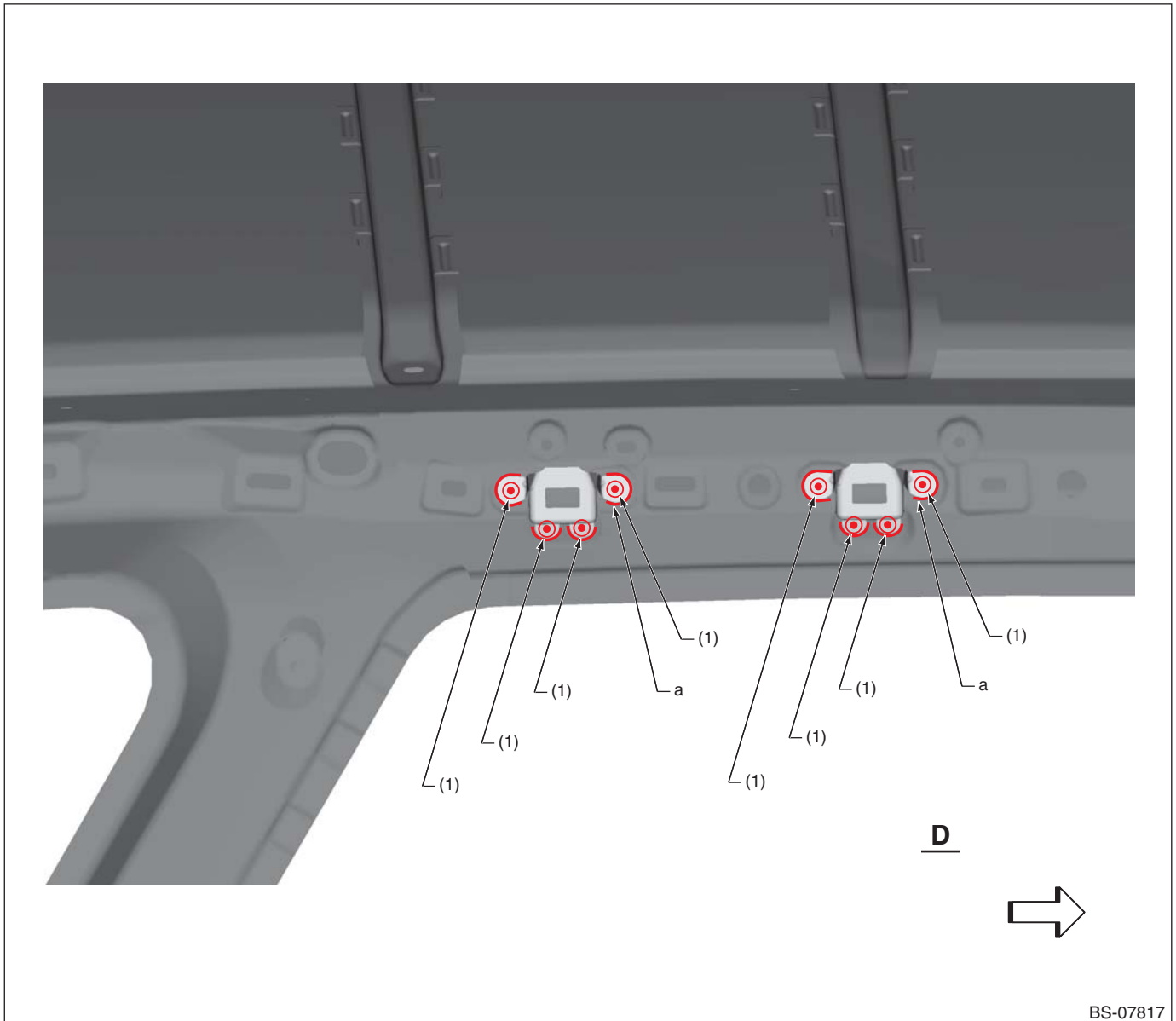
BS-07816

(1) 1 point

a: Install a replacement bracket, using the already marked points "a" (4 points) as reference points.

Panel Replacement

- View D (OUTBACK)



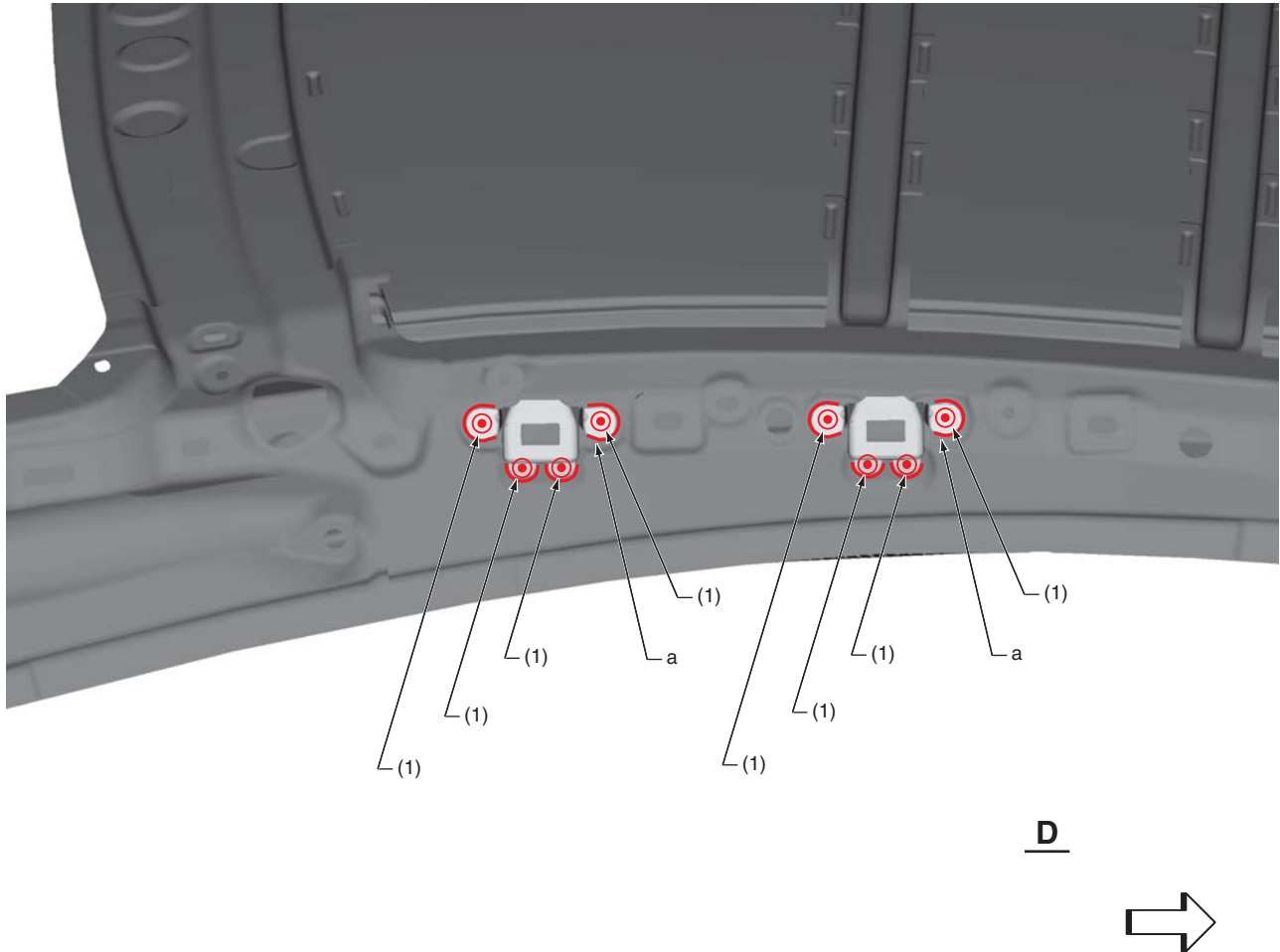
BS-07817

(1) 1 point

a: Install a replacement bracket, using the already marked points "a" (4 points) as reference points.

Panel Replacement

- View D (SEDAN)



BS-07818

(1) 1 point

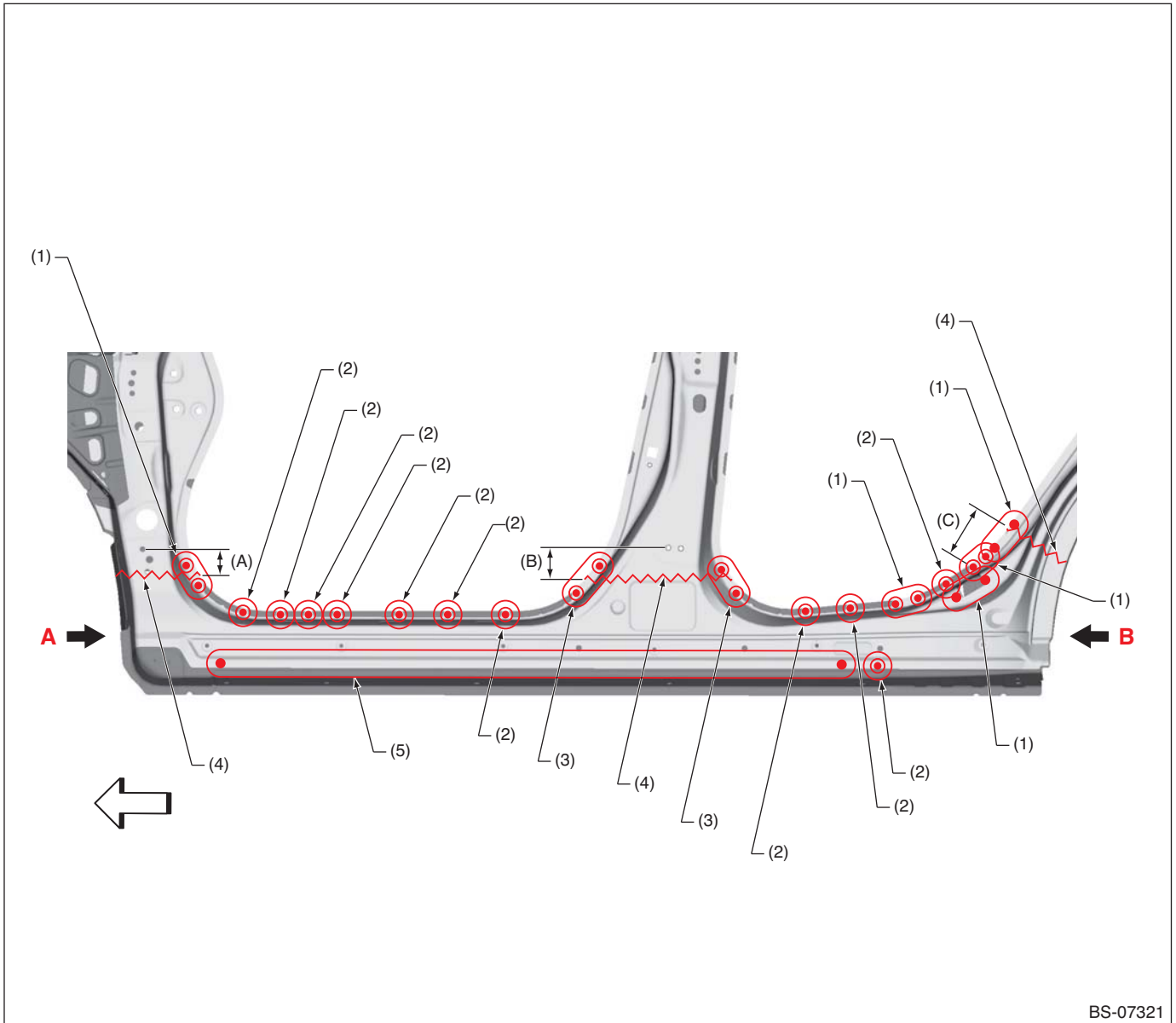
a: Install a replacement bracket, using the already marked points "a" (4 points) as reference points.

Panel Replacement

8-19. Side Sill Outer (Partial replacement)

A: REMOVAL

- Overall view



(A) 55 mm (2.17 in)

(B) 70 mm (2.76 in)

(C) 120 mm (4.72 in)

(1) 2 points

(3) 3 points

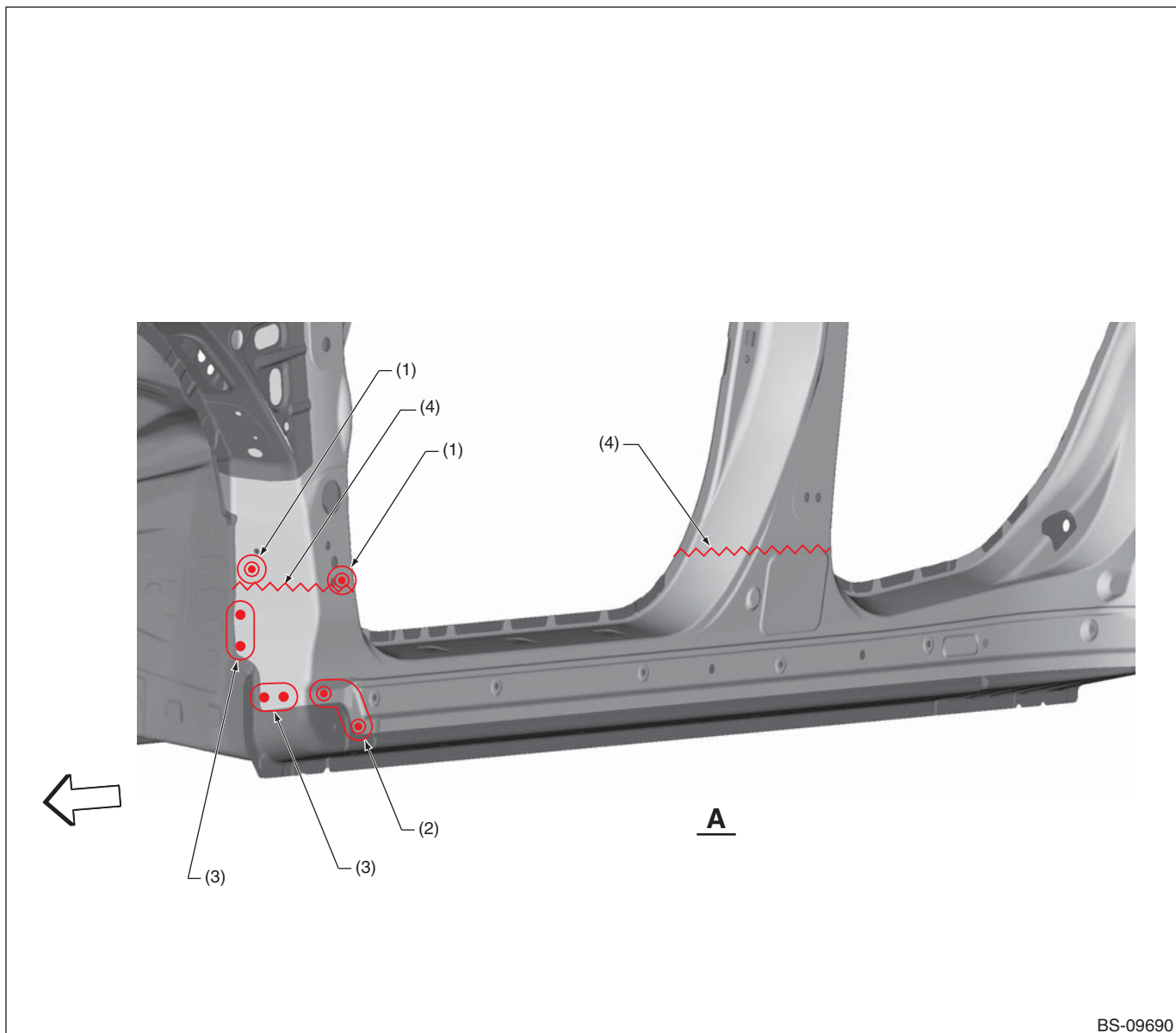
(5) 17 points

(2) 1 point

(4) Cut position

Panel Replacement

- View A



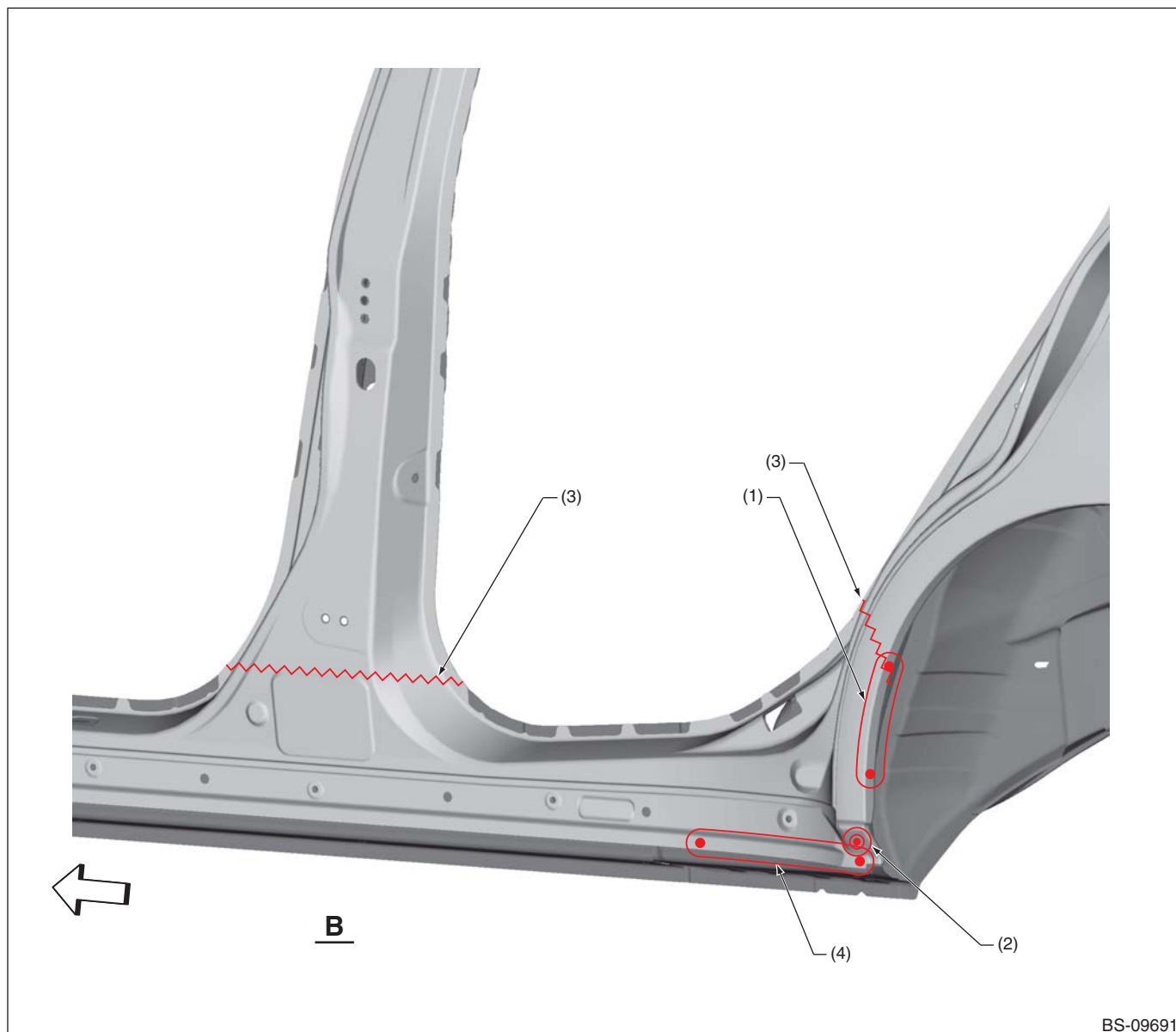
(1) 1 point
(2) 3 points

(3) 2 points

(4) Cut position

Panel Replacement

- View B



(1) 4 points
(2) 1 point

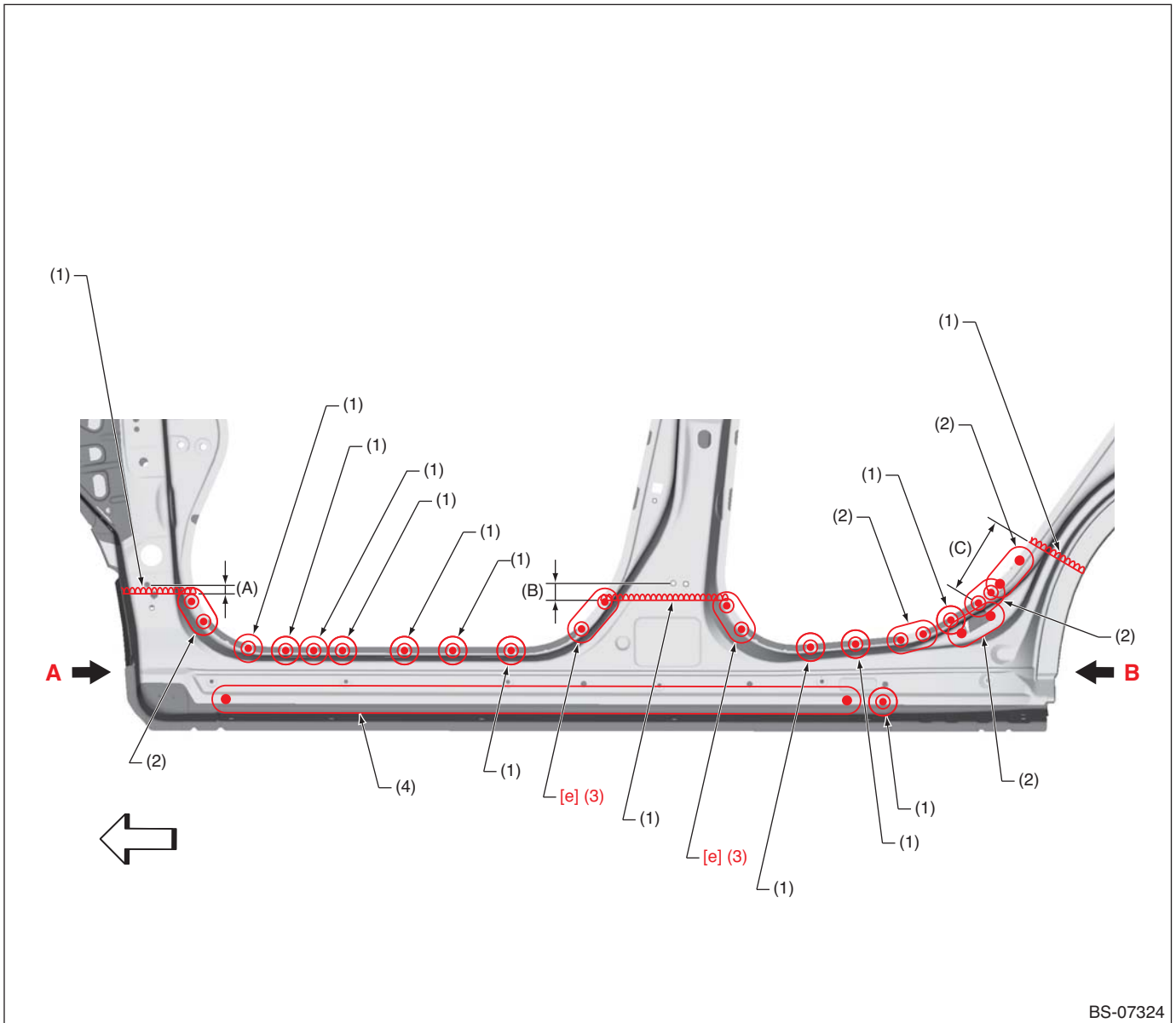
(3) Cut position

(4) 5 points

Panel Replacement

B: INSTALLATION

• Overall view



BS-07324

(A) 15 mm (0.59 in)

(B) 30 mm (1.18 in)

(C) 140 mm (5.51 in)

(1) 1 point

(3) 3 points

(4) 17 points

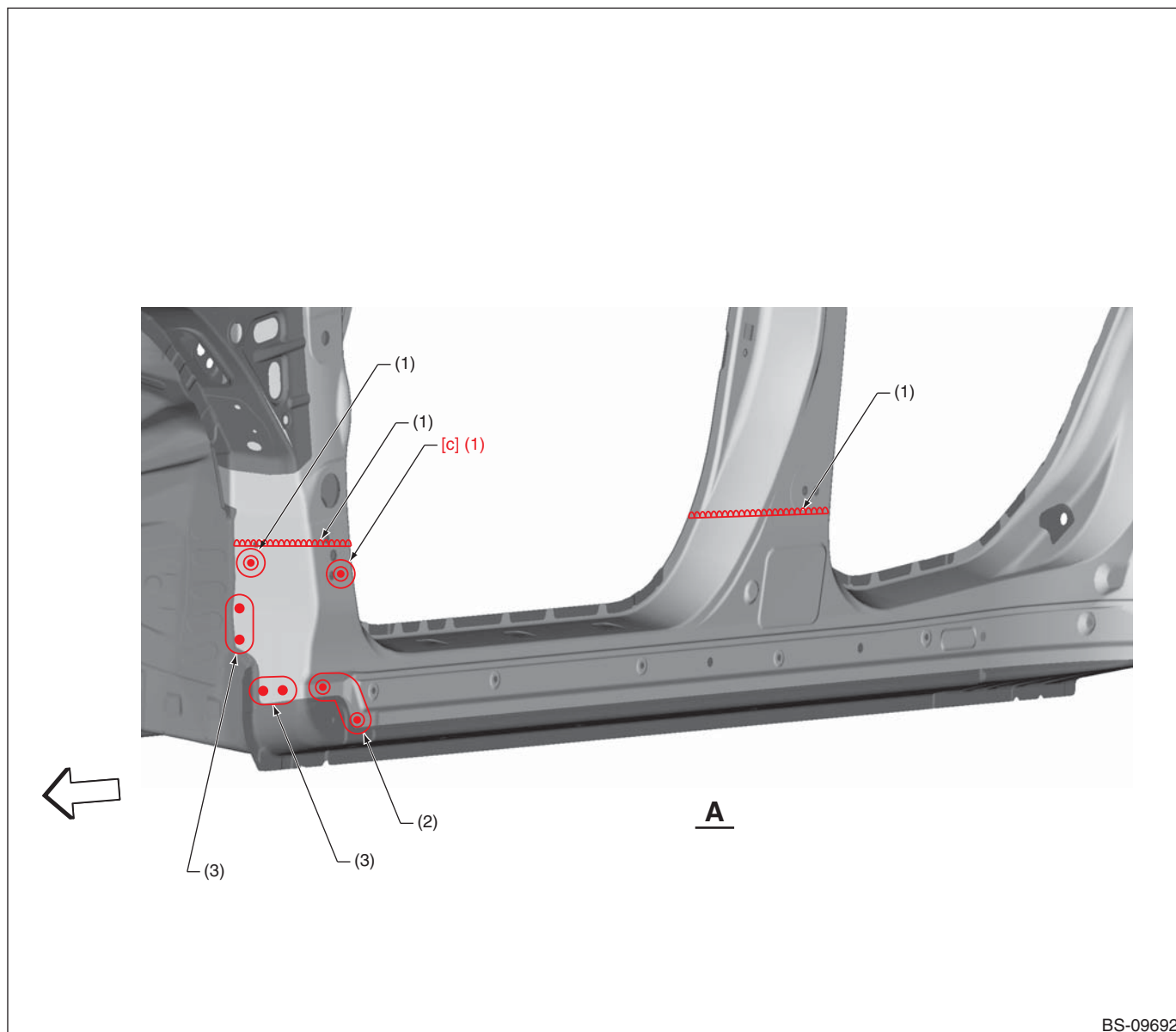
(2) 2 points

[e] Spot welding

Compression: 4.4 kN, Current: 8.0 kA, Welding time: 20 cyc

Panel Replacement

- View A



BS-09692

(1) 1 point

(2) 3 points

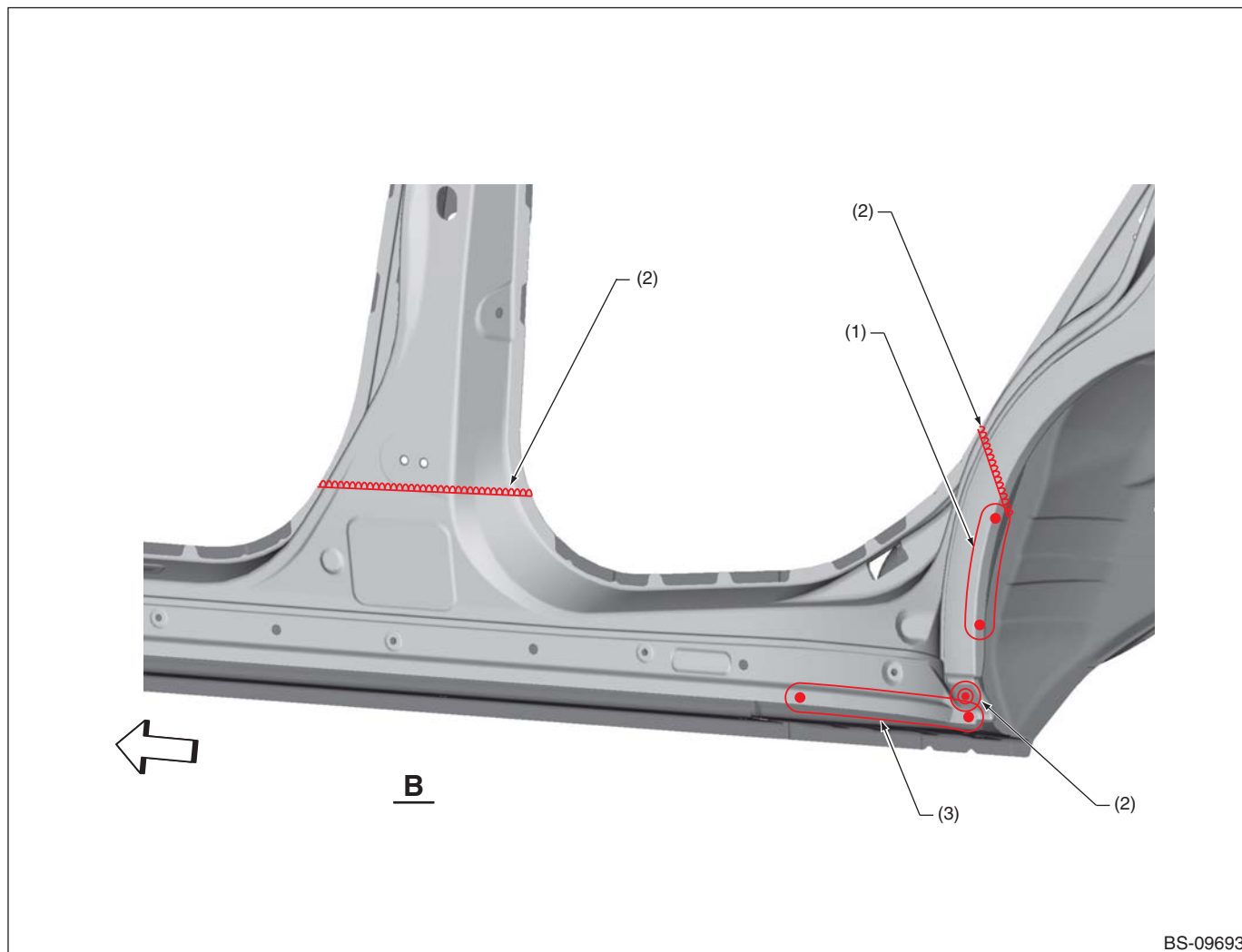
(3) 2 points

[c] Spot welding

Compression: 3.5 kN, Current: 7.5 kA, Welding time: 25 cyc

Panel Replacement

- View B



(1) 4 points

(2) 1 point

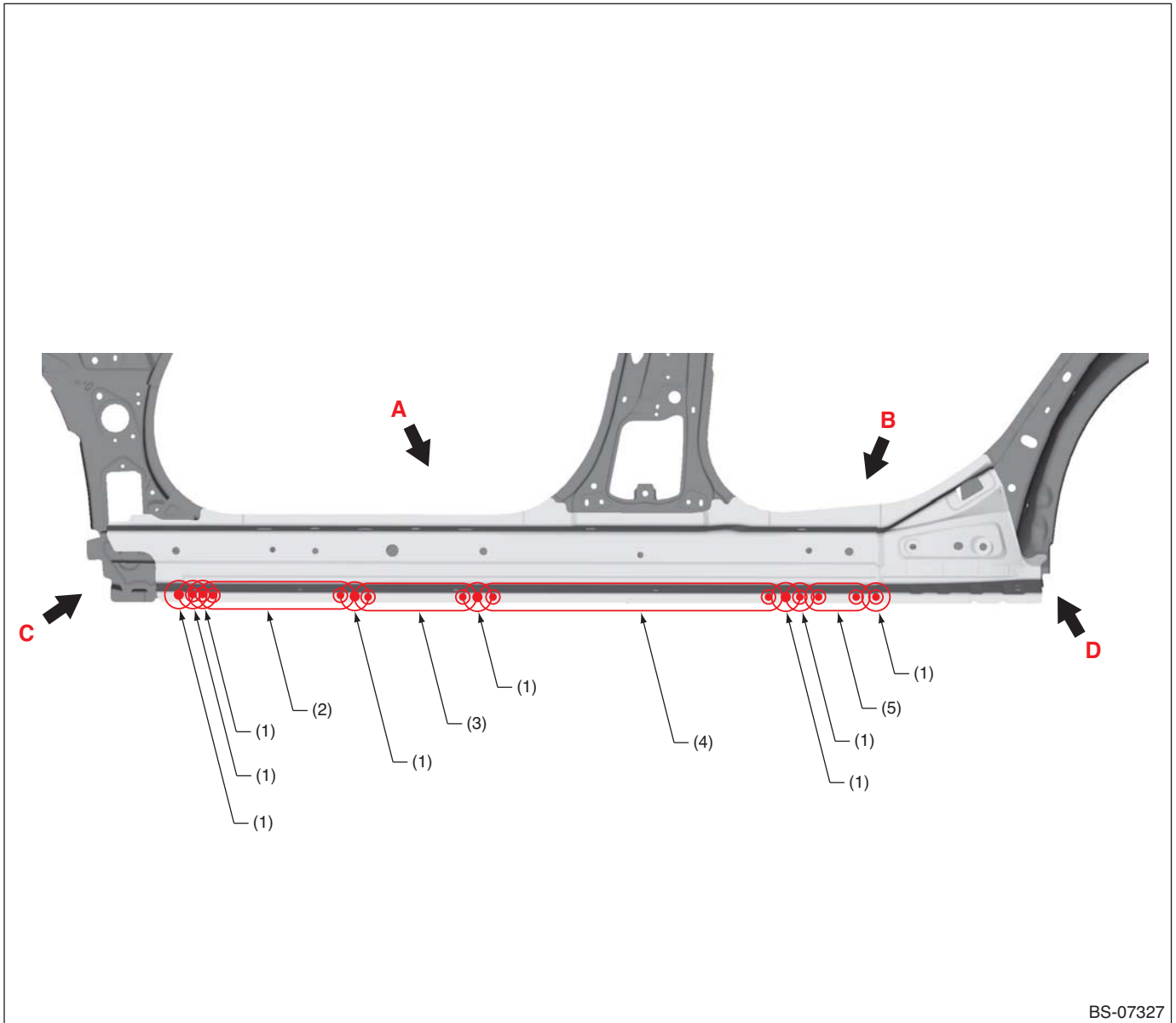
(3) 5 points

Panel Replacement

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

A: REMOVAL

- Overall view (Side sill outer removal condition)



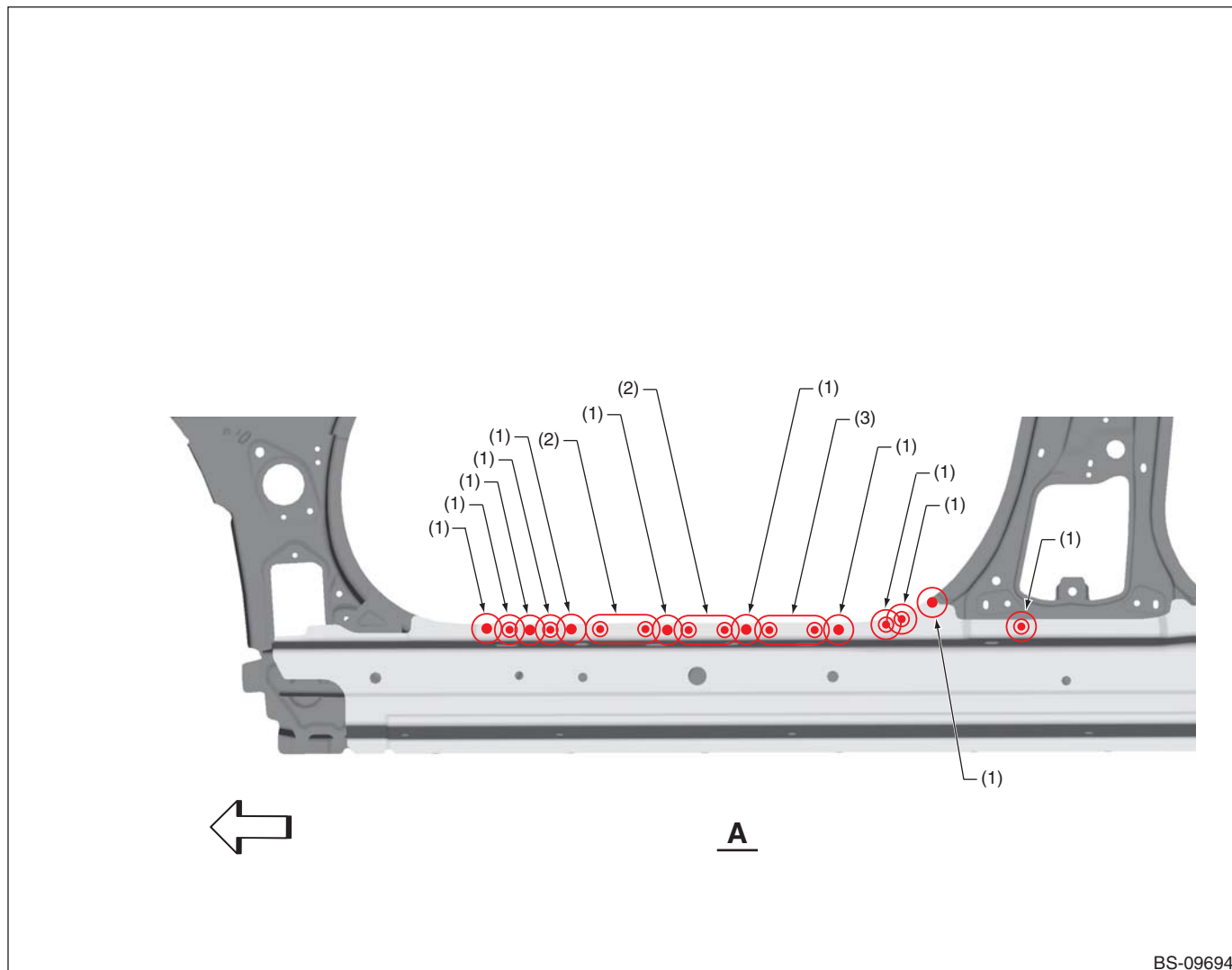
(1) 1 point
(2) 5 points

(3) 4 points
(4) 10 points

(5) 3 points

Panel Replacement

- View A



BS-09694

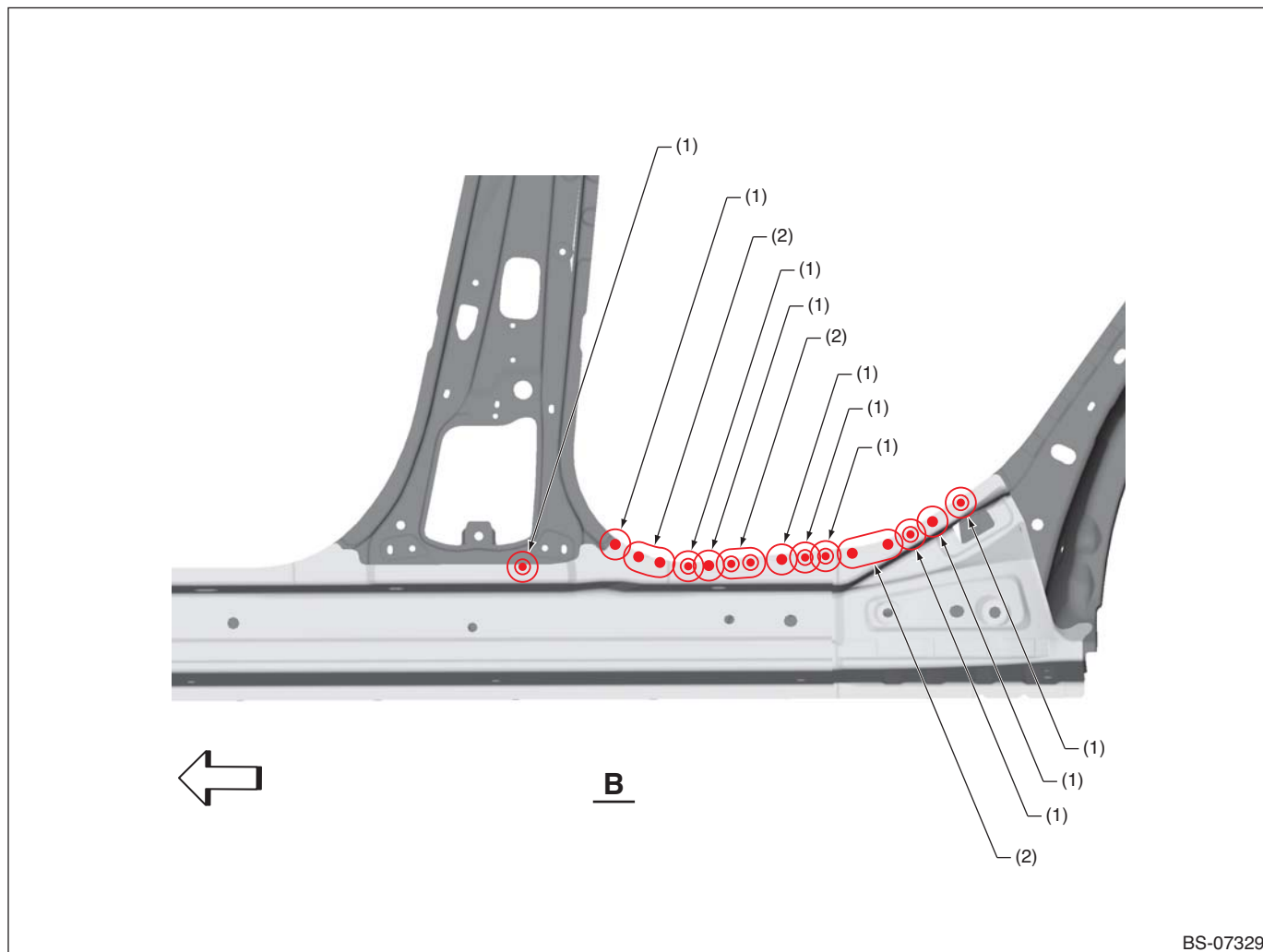
(1) 1 point

(2) 2 points

(3) 3 points

Panel Replacement

- View B

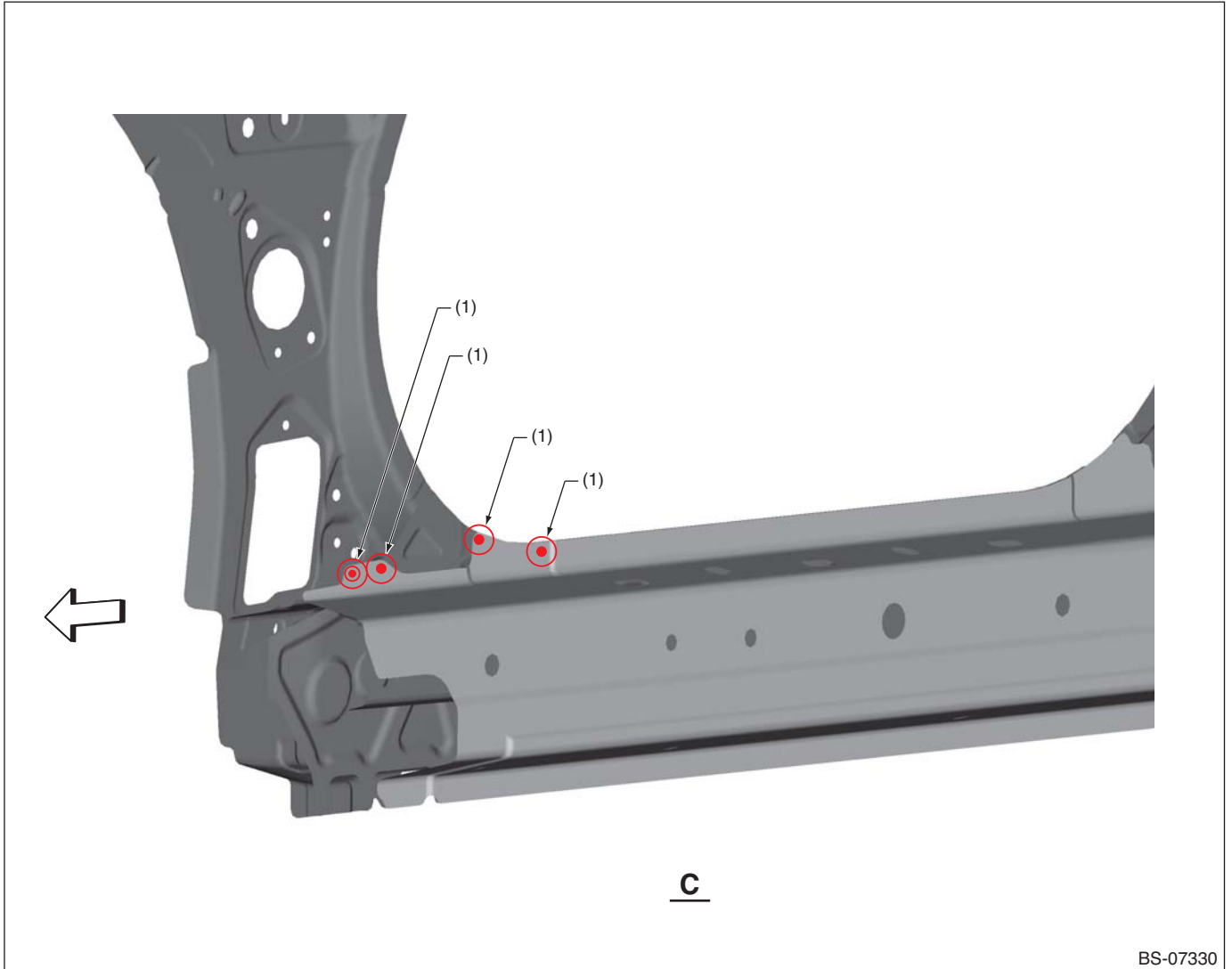


(1) 1 point

(2) 2 points

Panel Replacement

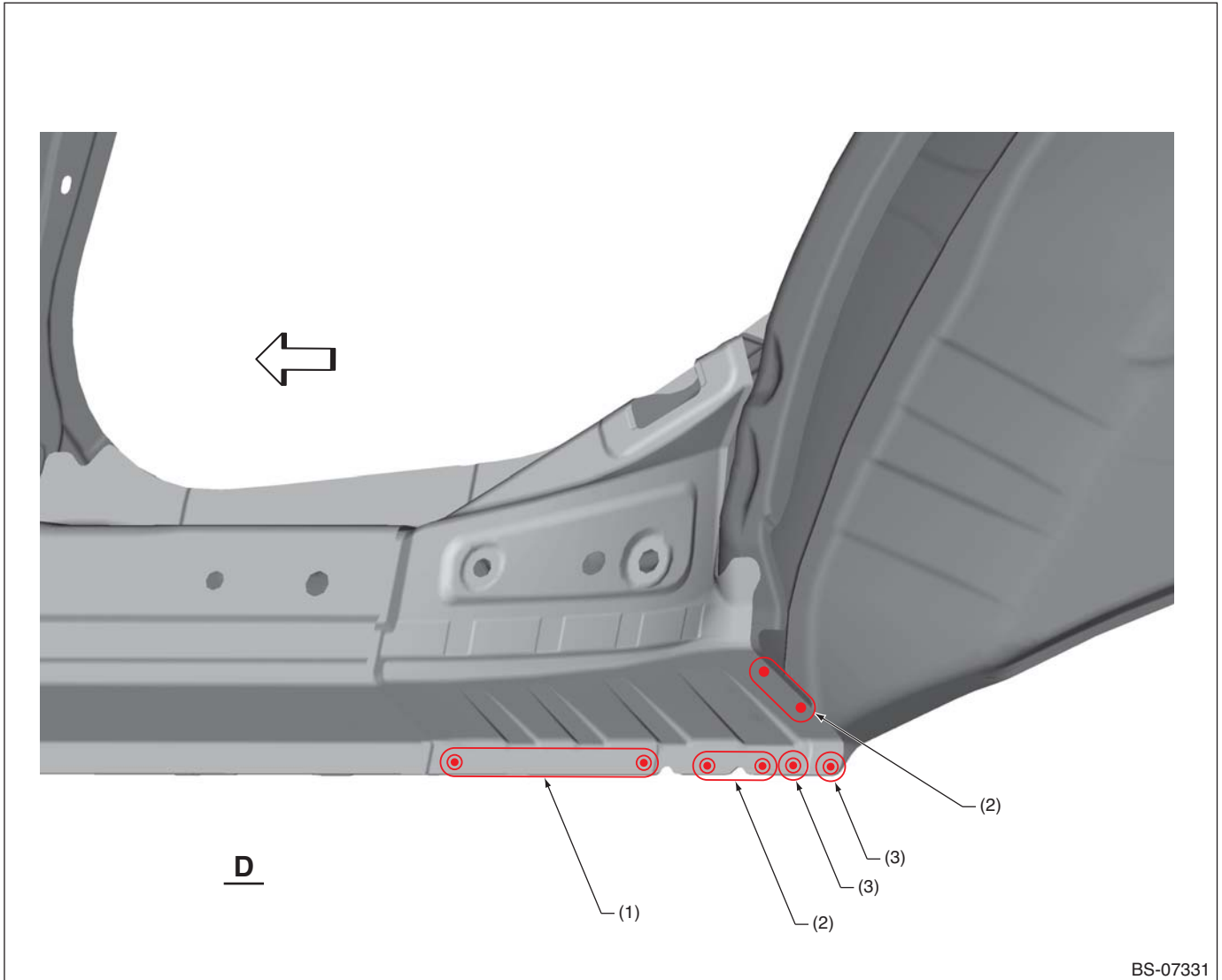
- View C



(1) 1 point

Panel Replacement

- View D



(1) 4 points

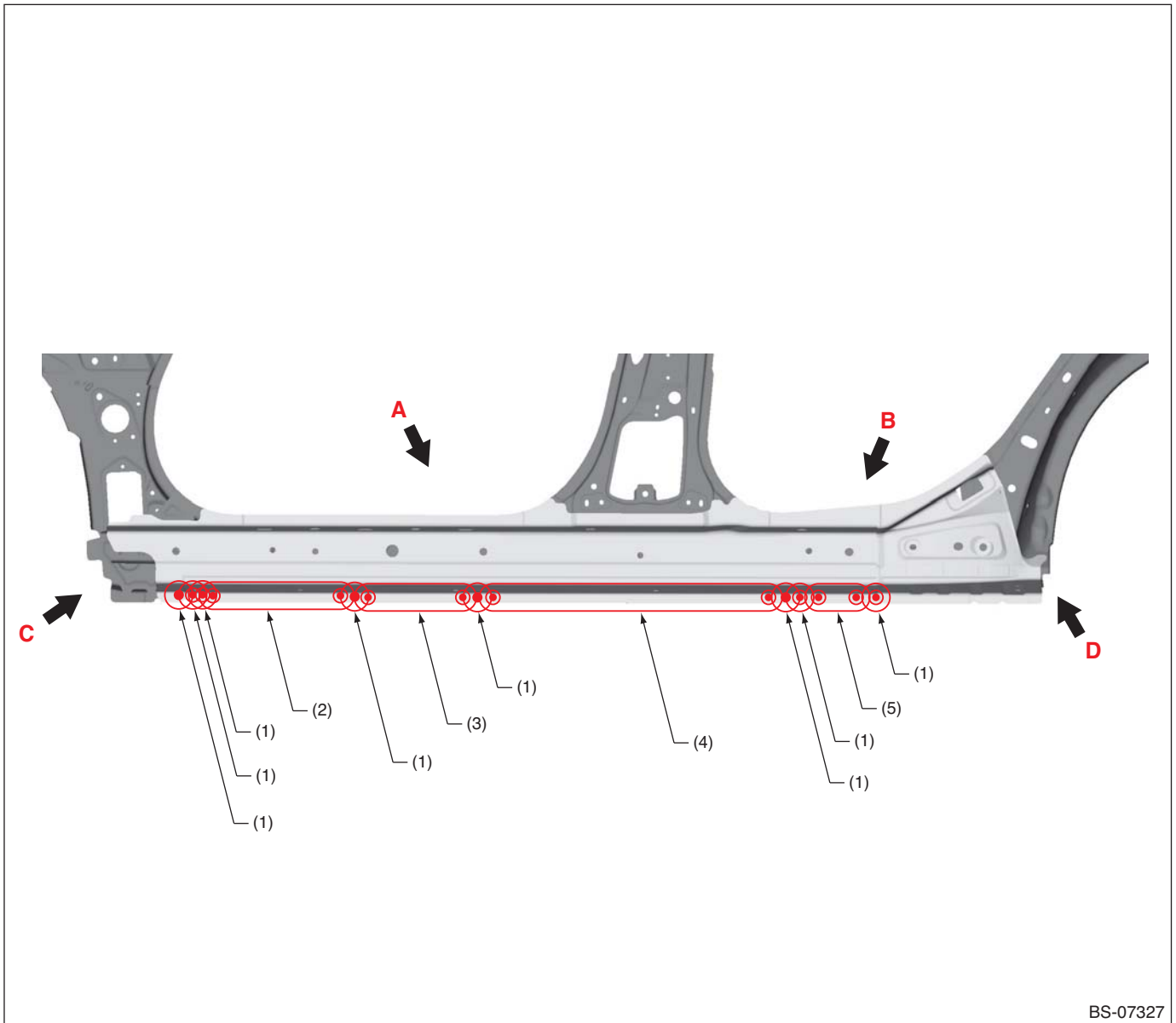
(2) 2 points

(3) 1 point

Panel Replacement

B: INSTALLATION

- Overall view



BS-07327

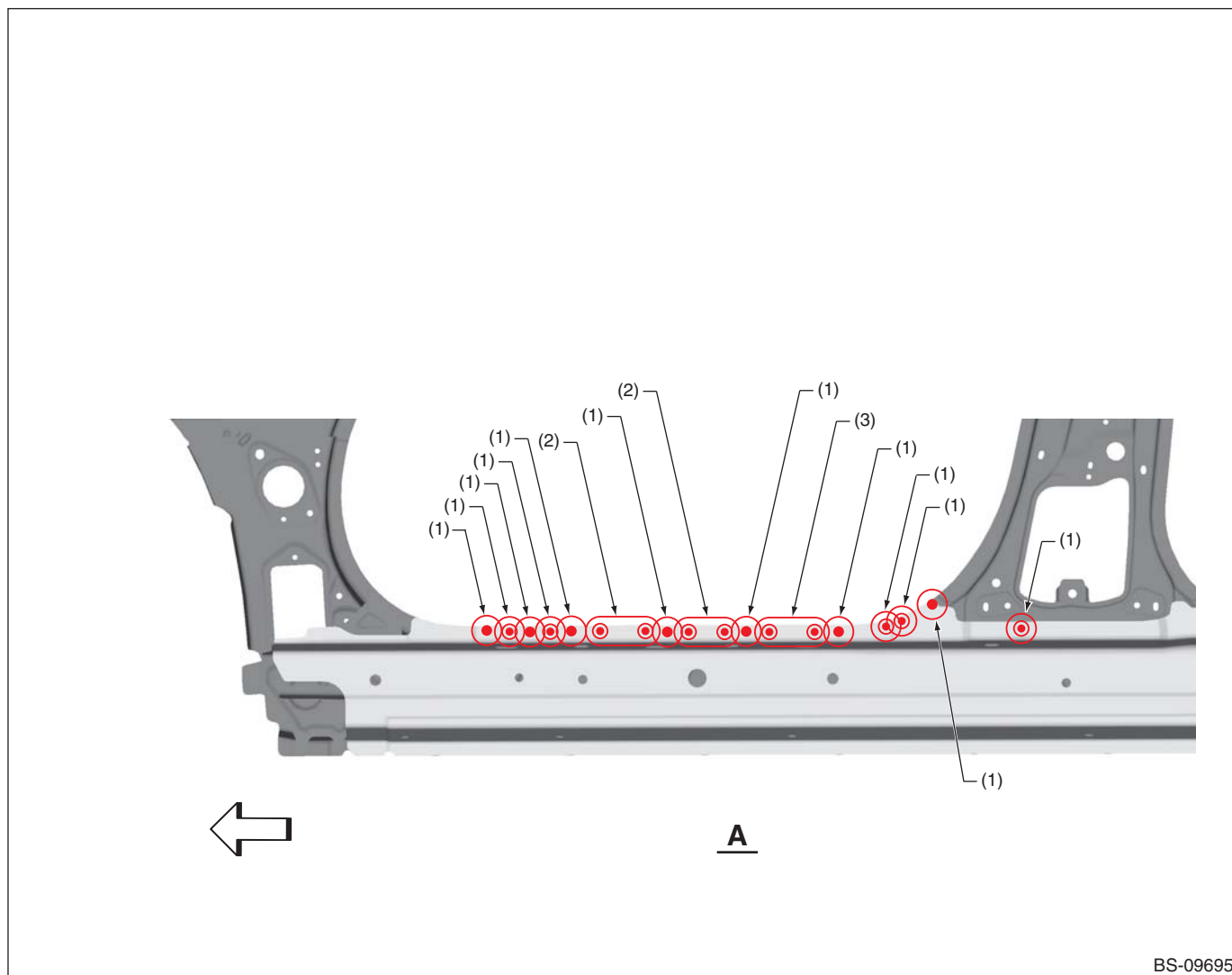
(1) 1 point
(2) 5 points

(3) 4 points
(4) 10 points

(5) 3 points

Panel Replacement

- View A



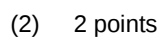
BS-09695

(1) 1 point

(2) 2 points

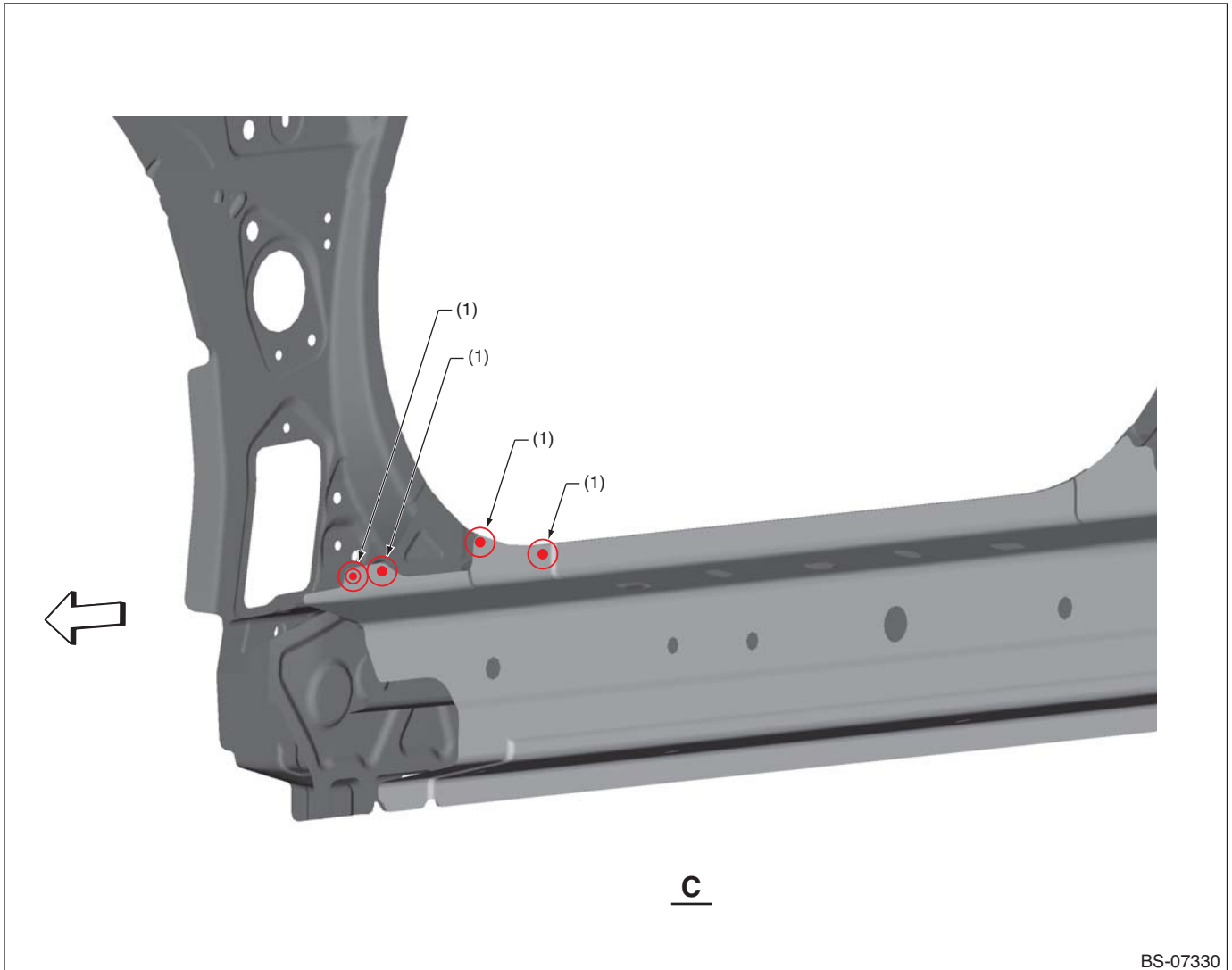
(3) 3 points

- **View B**



Panel Replacement

- View C

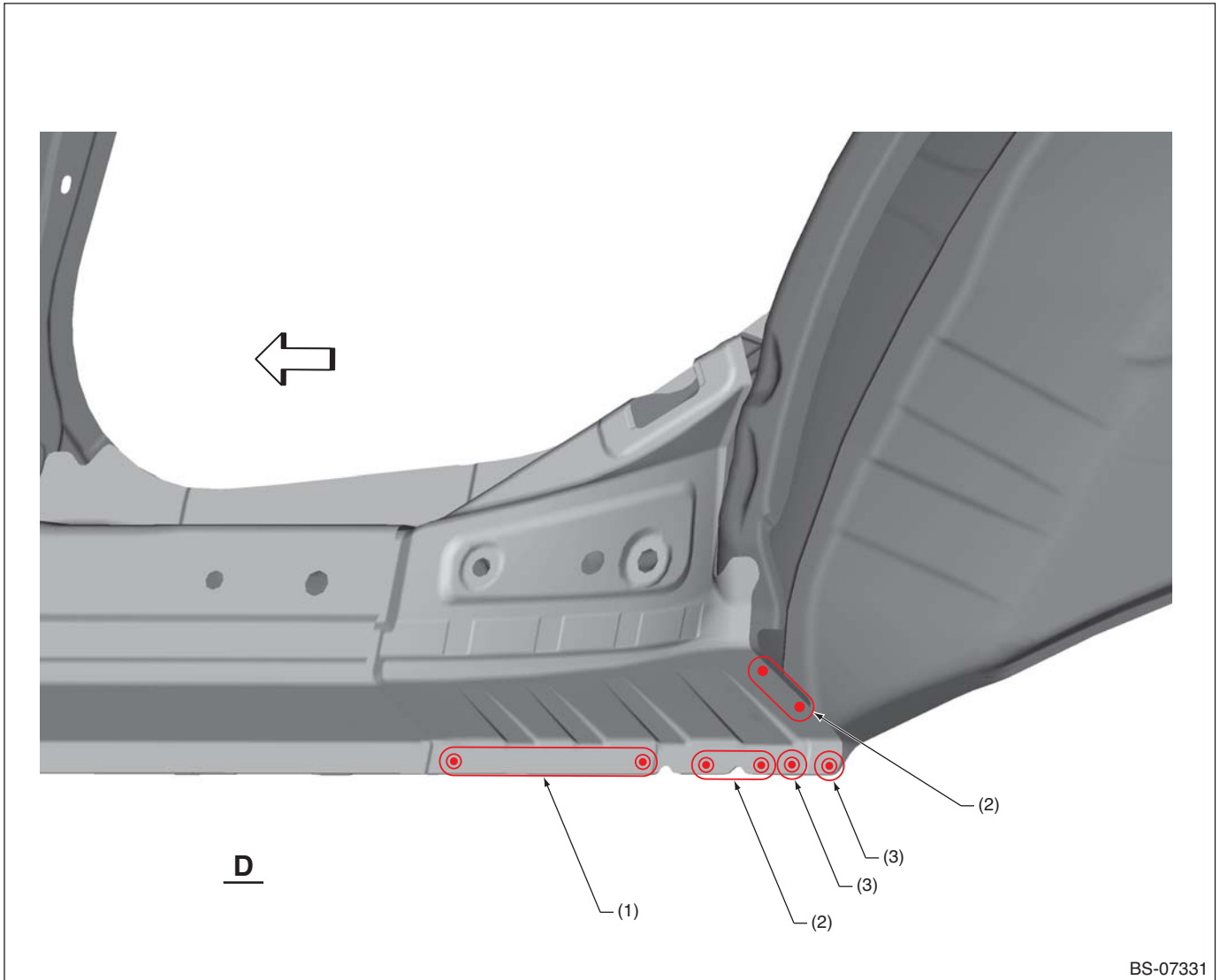


BS-07330

(1) 1 point

Panel Replacement

- View D



BS-07331

(1) 4 points

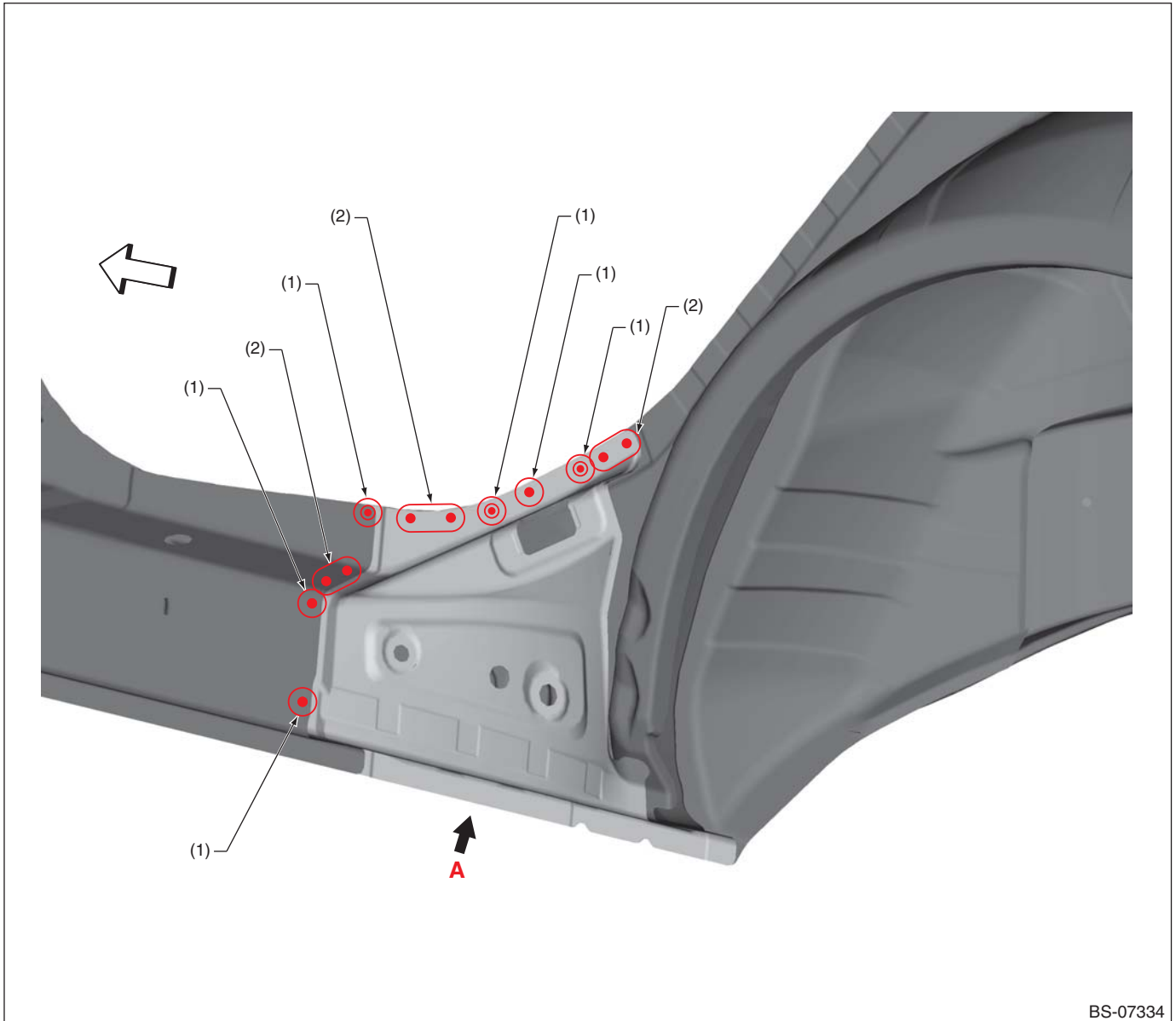
(2) 2 points

(3) 1 point

8-21. Side Sill Reinforcement Outer Rear (Total replacement)

A: REMOVAL

- Overall view (Rear quarter outer removal condition)

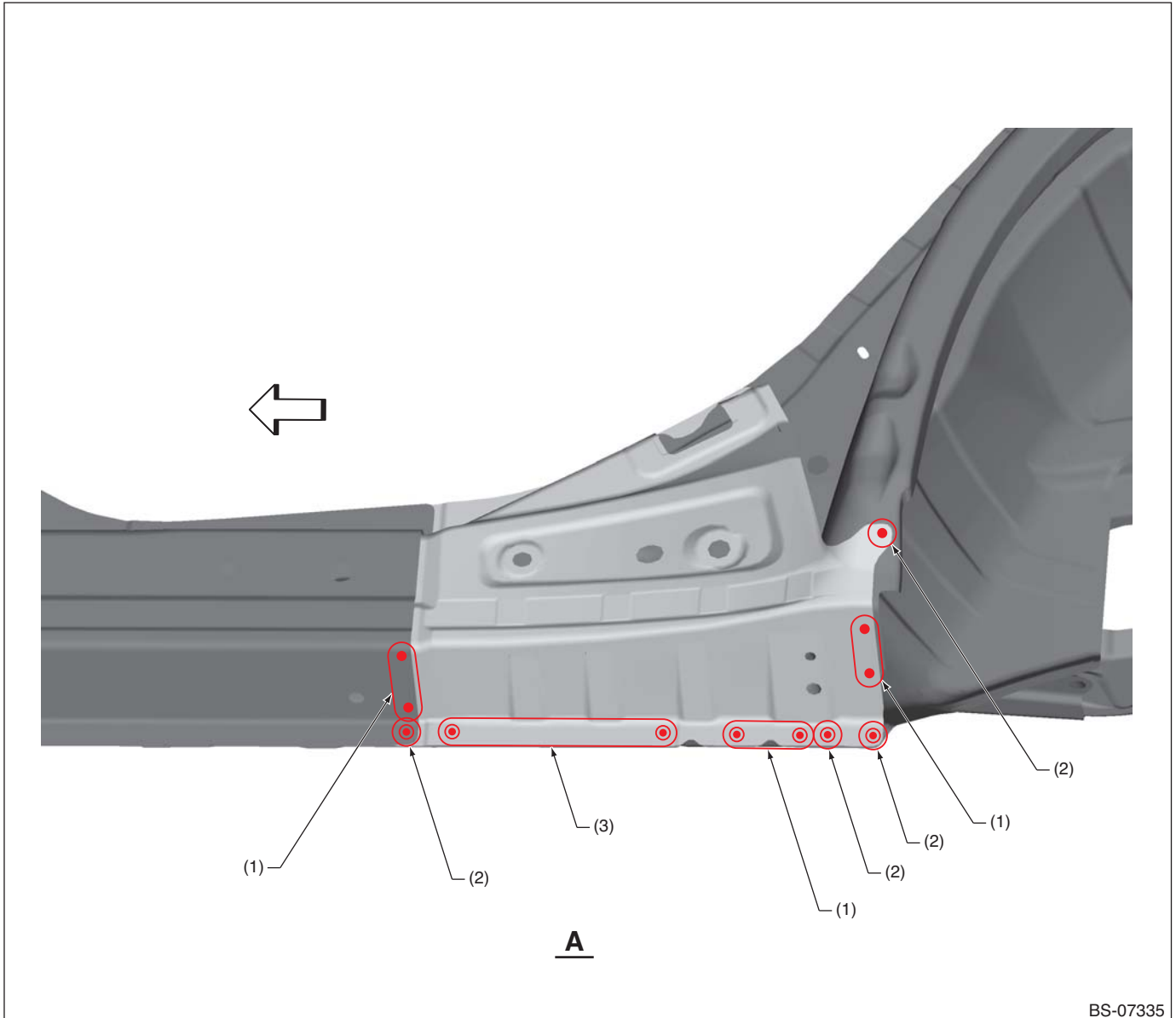


(1) 1 point

(2) 2 points

Panel Replacement

- View A



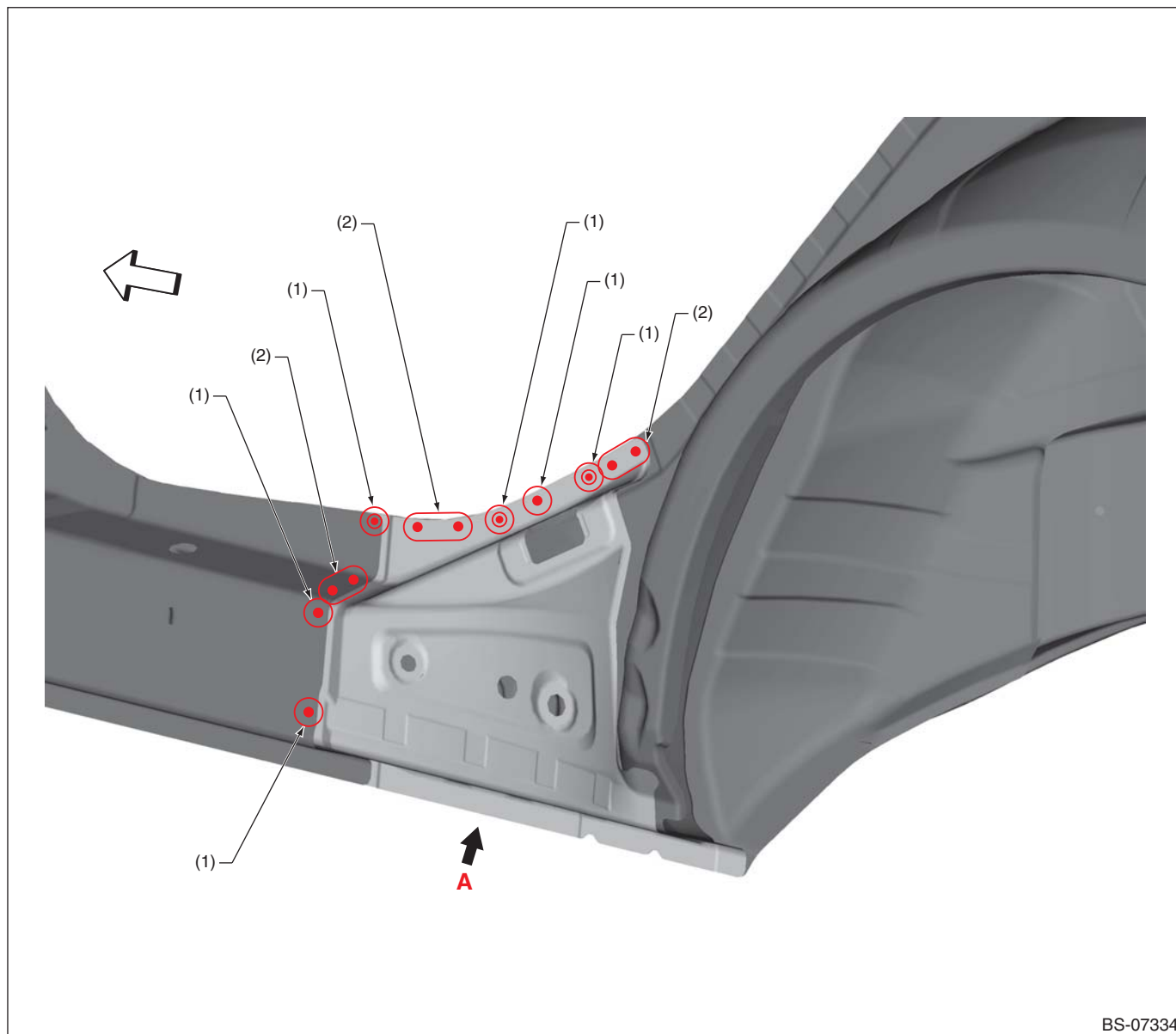
(1) 2 points

(2) 1 point

(3) 4 points

B: INSTALLATION

- Overall view



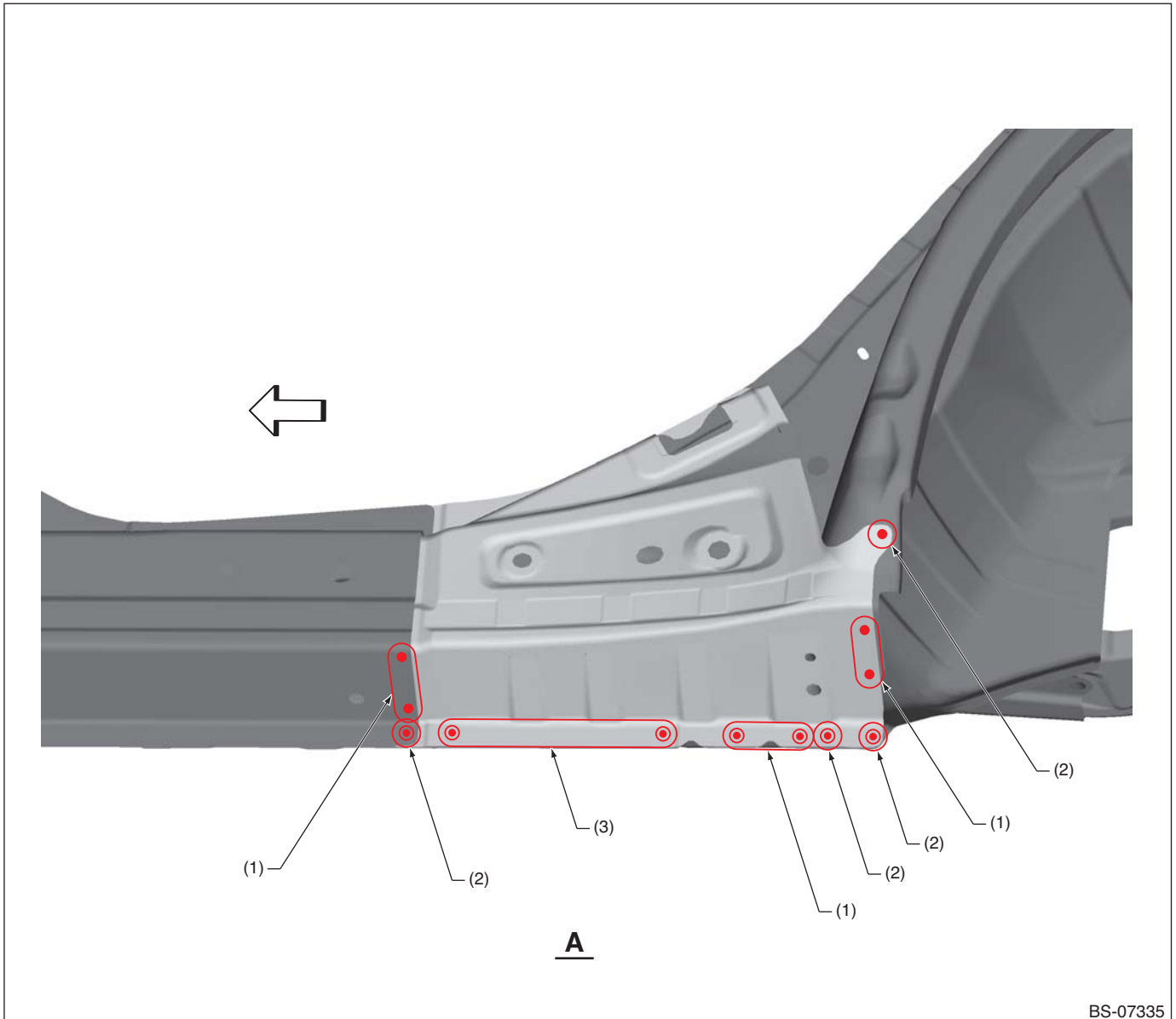
BS-07334

(1) 1 point

(2) 2 points

Panel Replacement

- View A



(1) 2 points

(2) 1 point

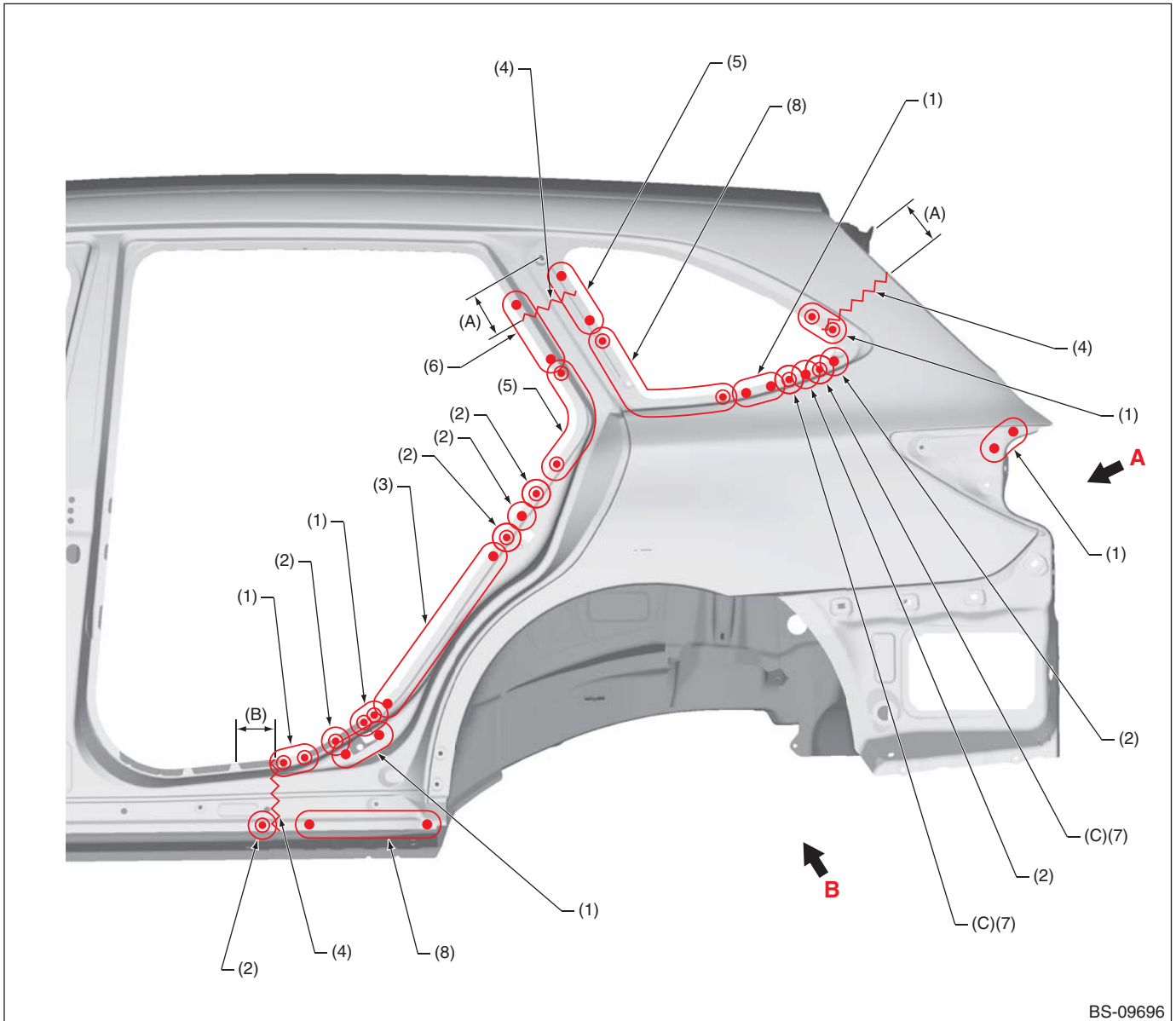
(3) 4 points

Panel Replacement

8-22. Rear Quarter (Partial replacement)/OUTBACK

A: REMOVAL

• Overall view



(A) 100 mm (3.94 in)

(B) 90 mm (3.54 in)

(C) Only LH

(1) 2 points

(4) Cut position

(7) 1 point
(only Power rear gate models)

(2) 1 point

(5) 3 points

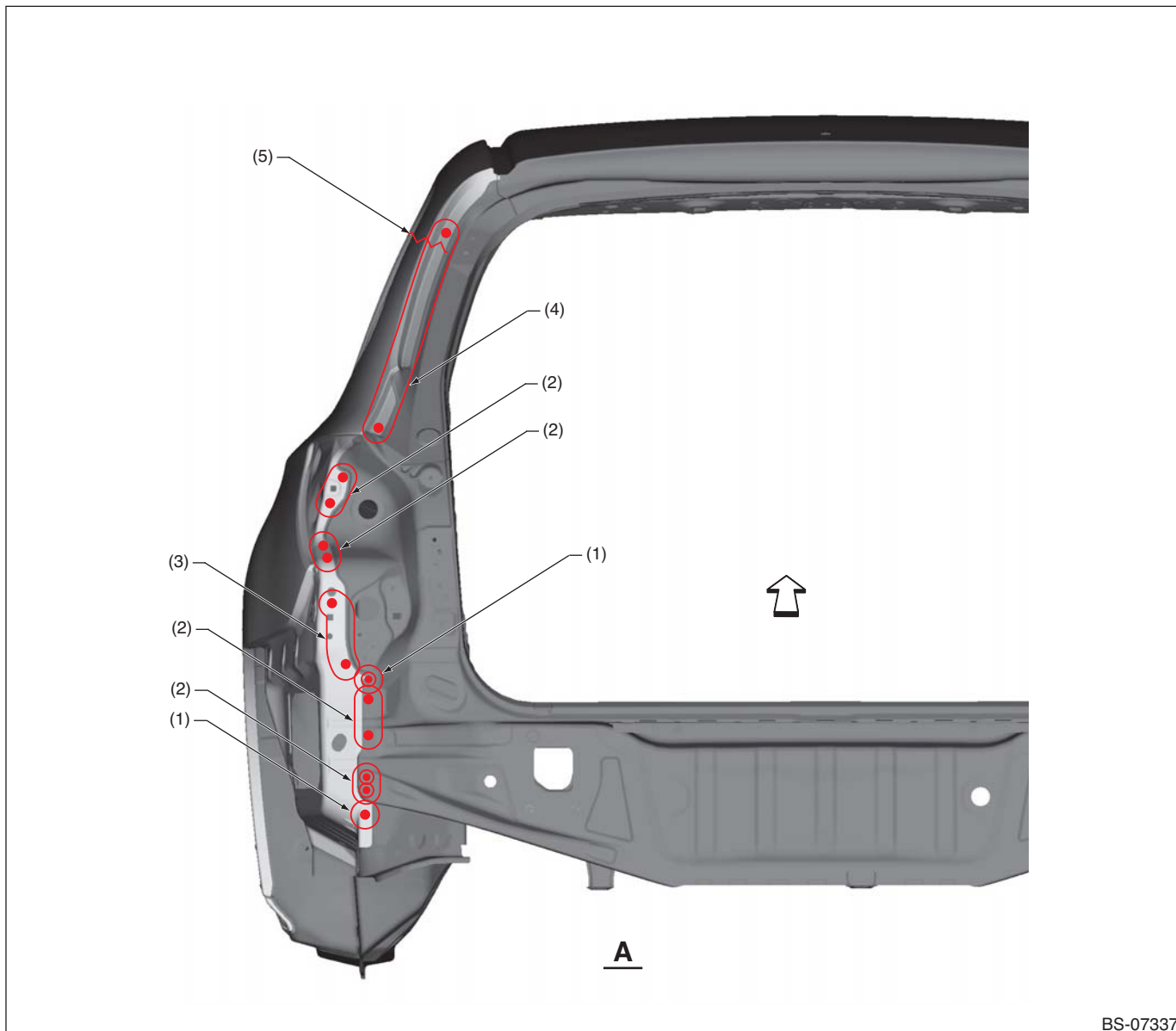
(8) 5 points

(3) 7 points

(6) 4 points

Panel Replacement

- View A



BS-07337

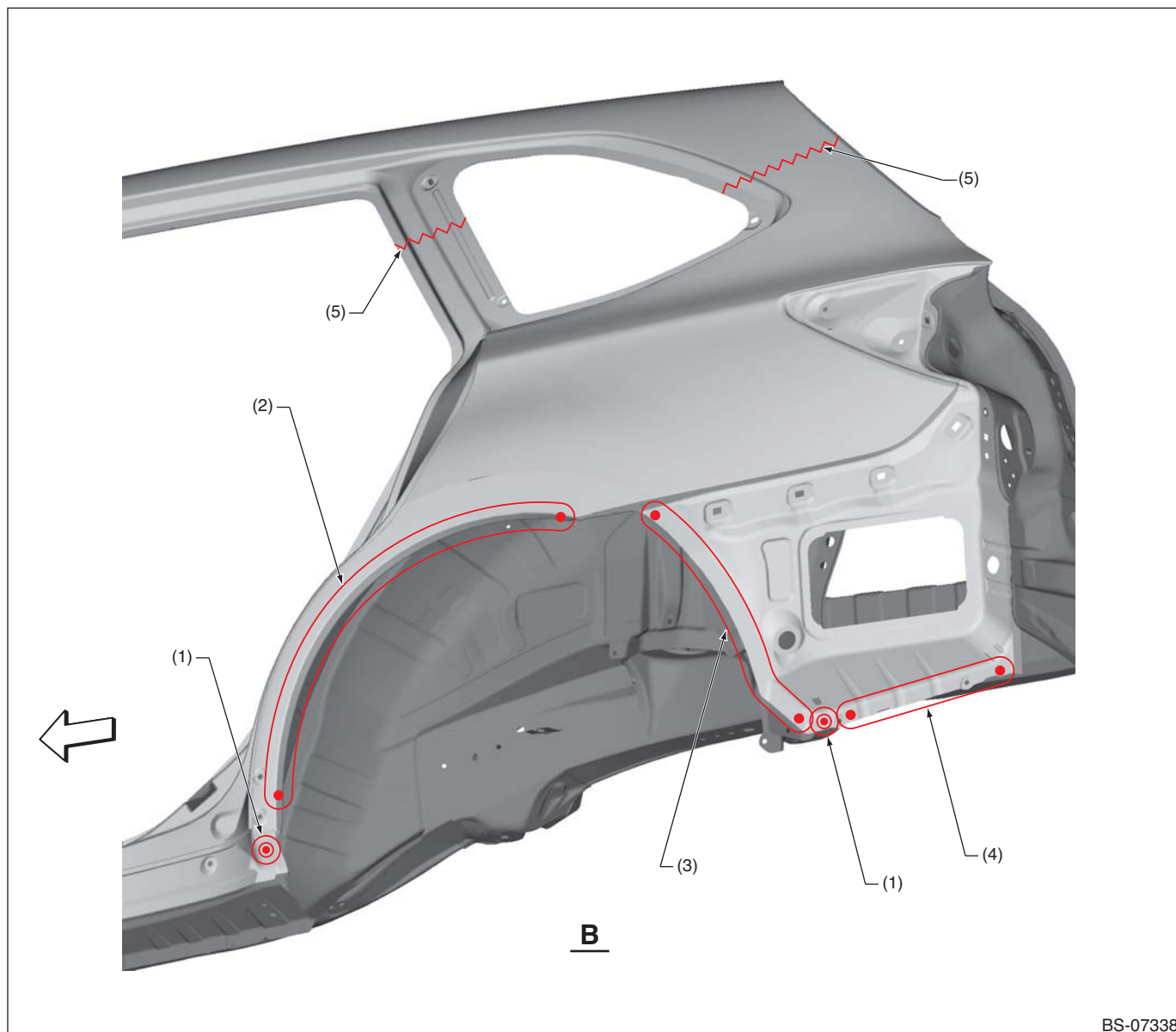
(1) 1 point
(2) 2 points

(3) 3 points
(4) 9 points

(5) Cut position

Panel Replacement

- View B



BS-07338

(1) 1 point
(2) 12 points

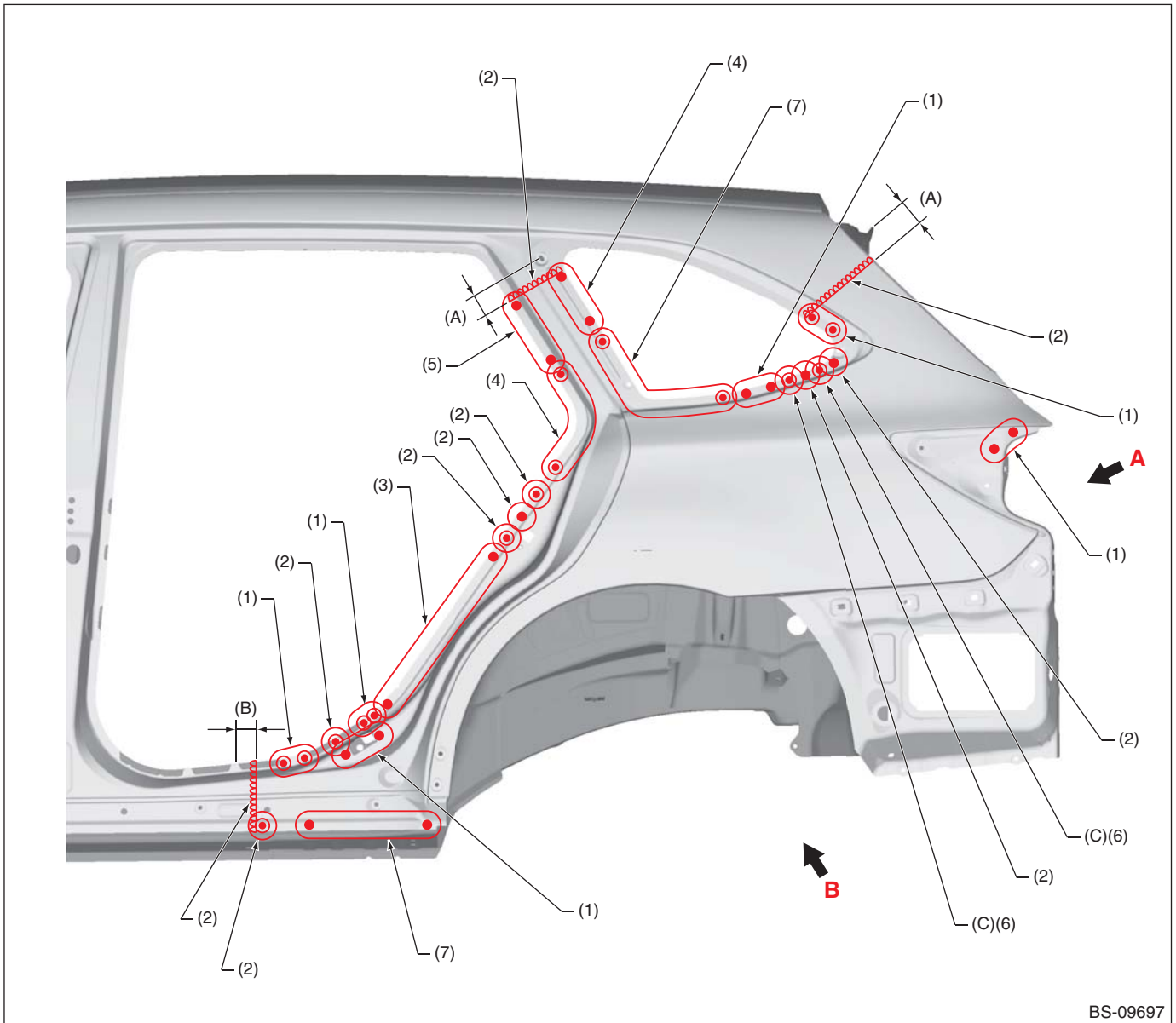
(3) 8 points
(4) 6 points

(5) Cut position

Panel Replacement

B: INSTALLATION

• Overall view



(A) 60 mm (2.36 in)

(B) 50 mm (1.97 in)

(C) Only LH

(1) 2 points

(4) 3 points

(7) 5 points

(2) 1 point

(5) 4 points

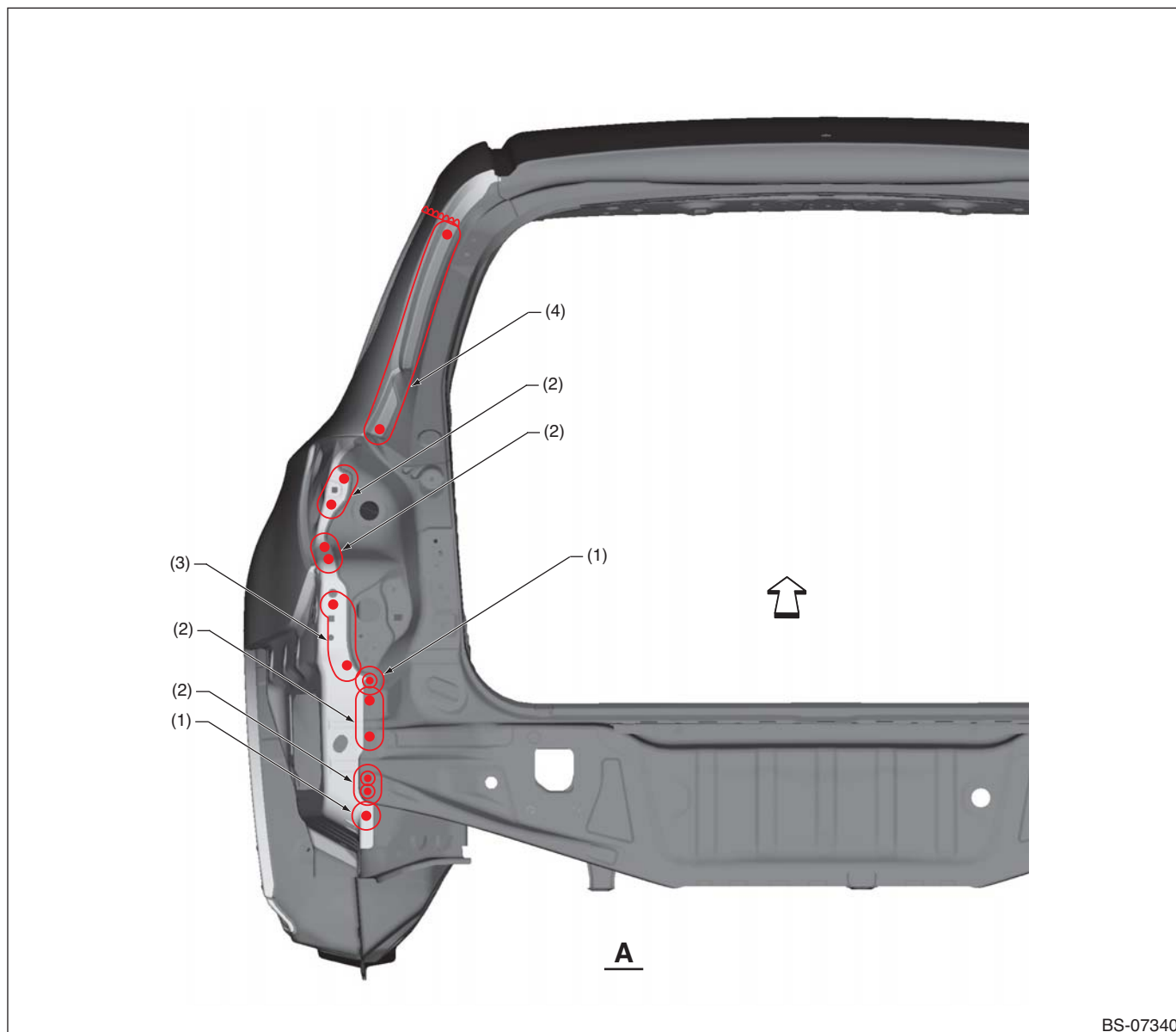
(3) 7 points

(6) 1 point

(only Power rear gate models)

Panel Replacement

- View A



BS-07340

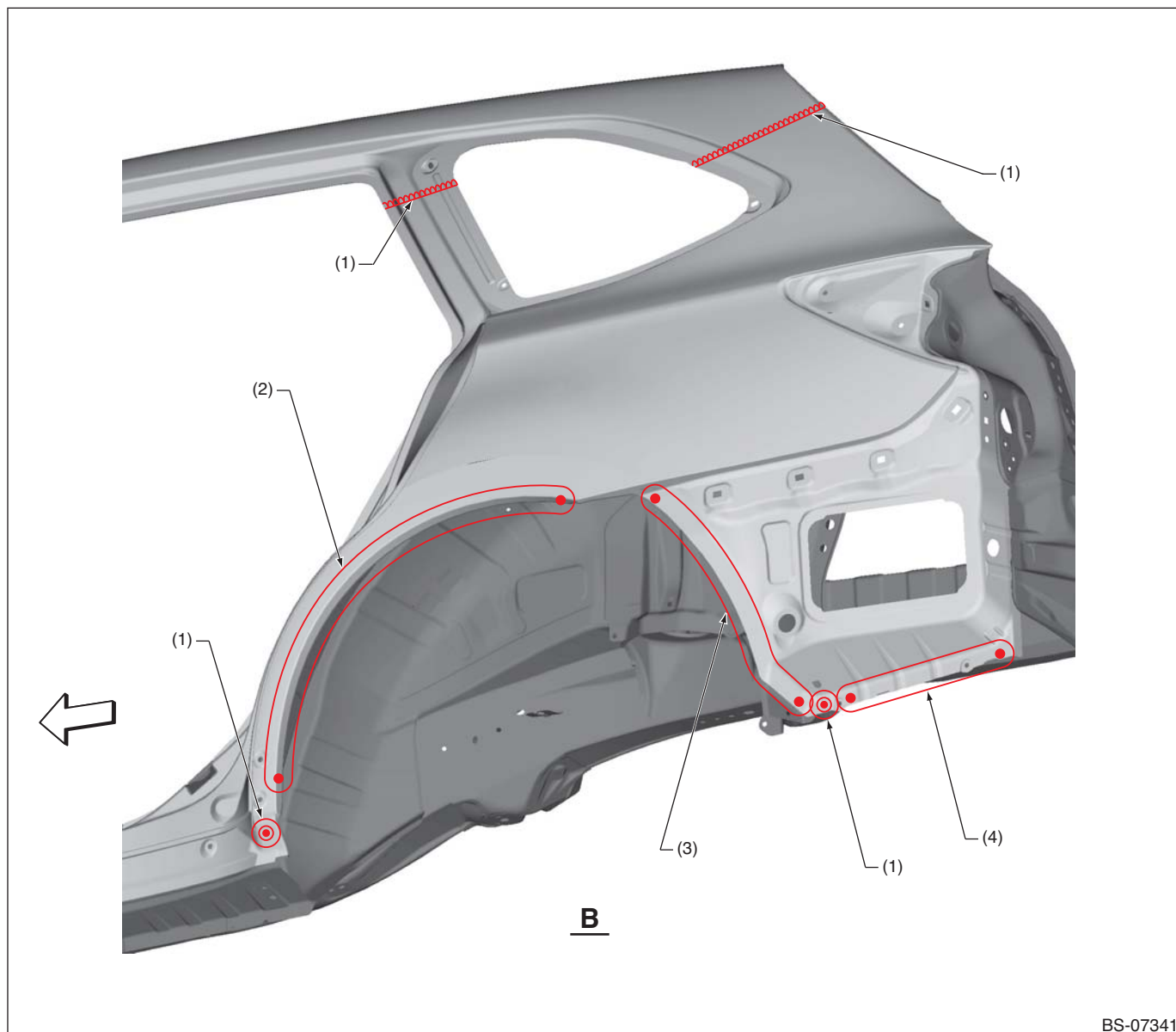
(1) 1 point
(2) 2 points

(3) 3 points

(4) 9 points

Panel Replacement

- View B



(1) 1 point
(2) 12 points

(3) 8 points

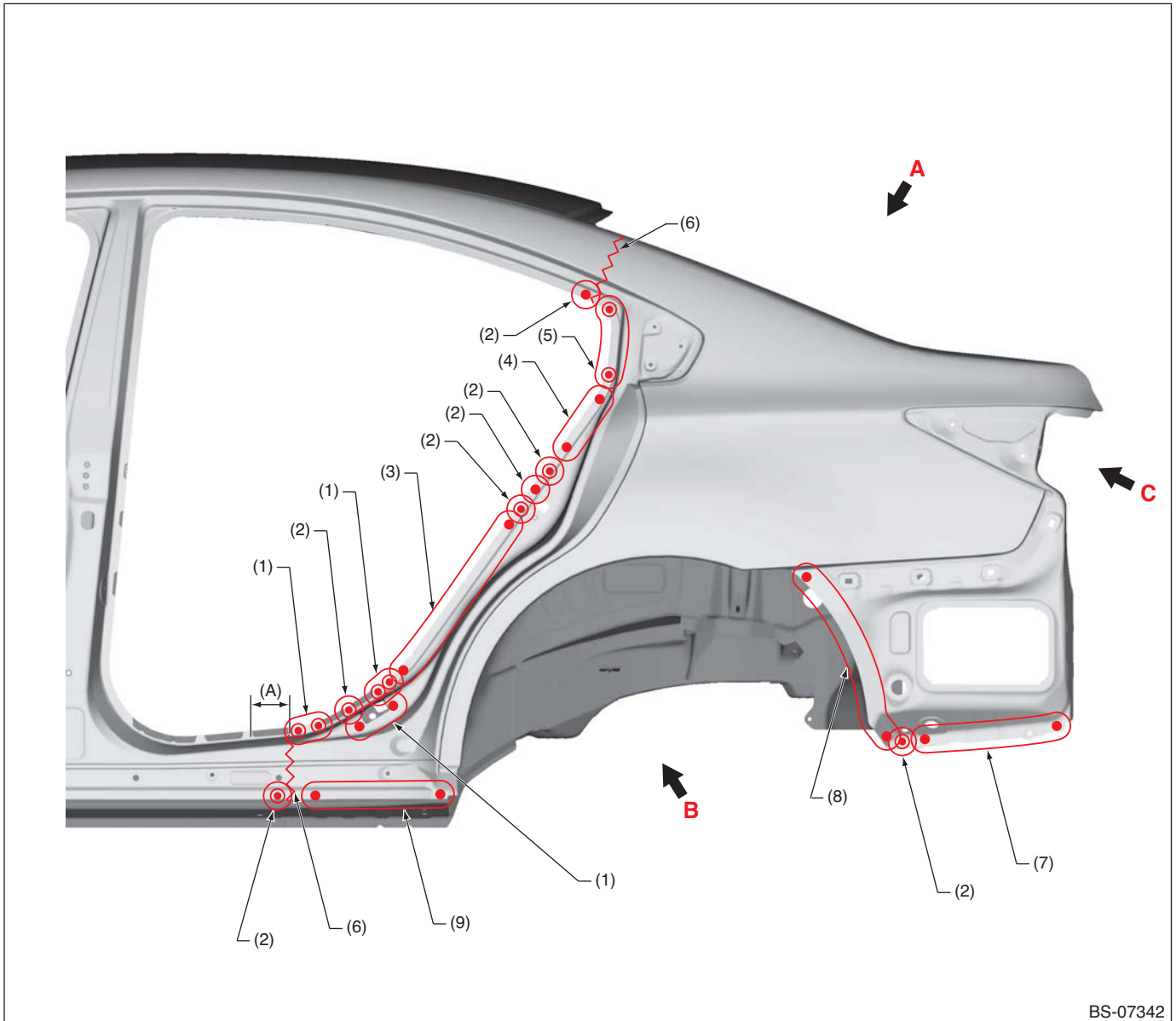
(4) 6 points

Panel Replacement

8-23. Rear Quarter (Partial replacement)/SEDAN

A: REMOVAL

- Overall view



BS-07342

(A) 90 mm (3.54 in)

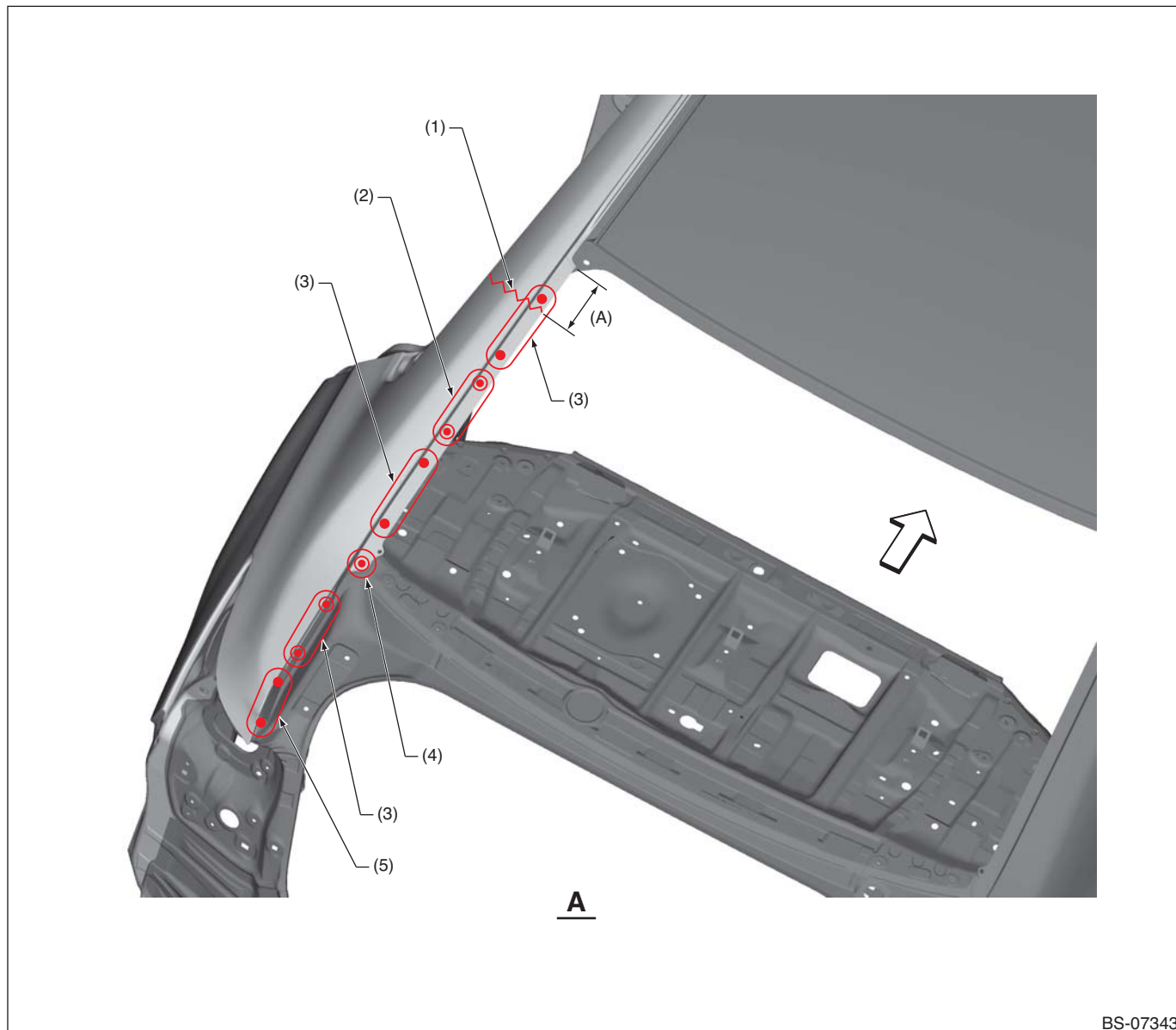
- (1) 2 points
- (2) 1 point
- (3) 7 points

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

- (7) 6 points
- (8) 8 points
- (9) 5 points

Panel Replacement

- View A



BS-07343

(A) 100 mm (3.94 in)

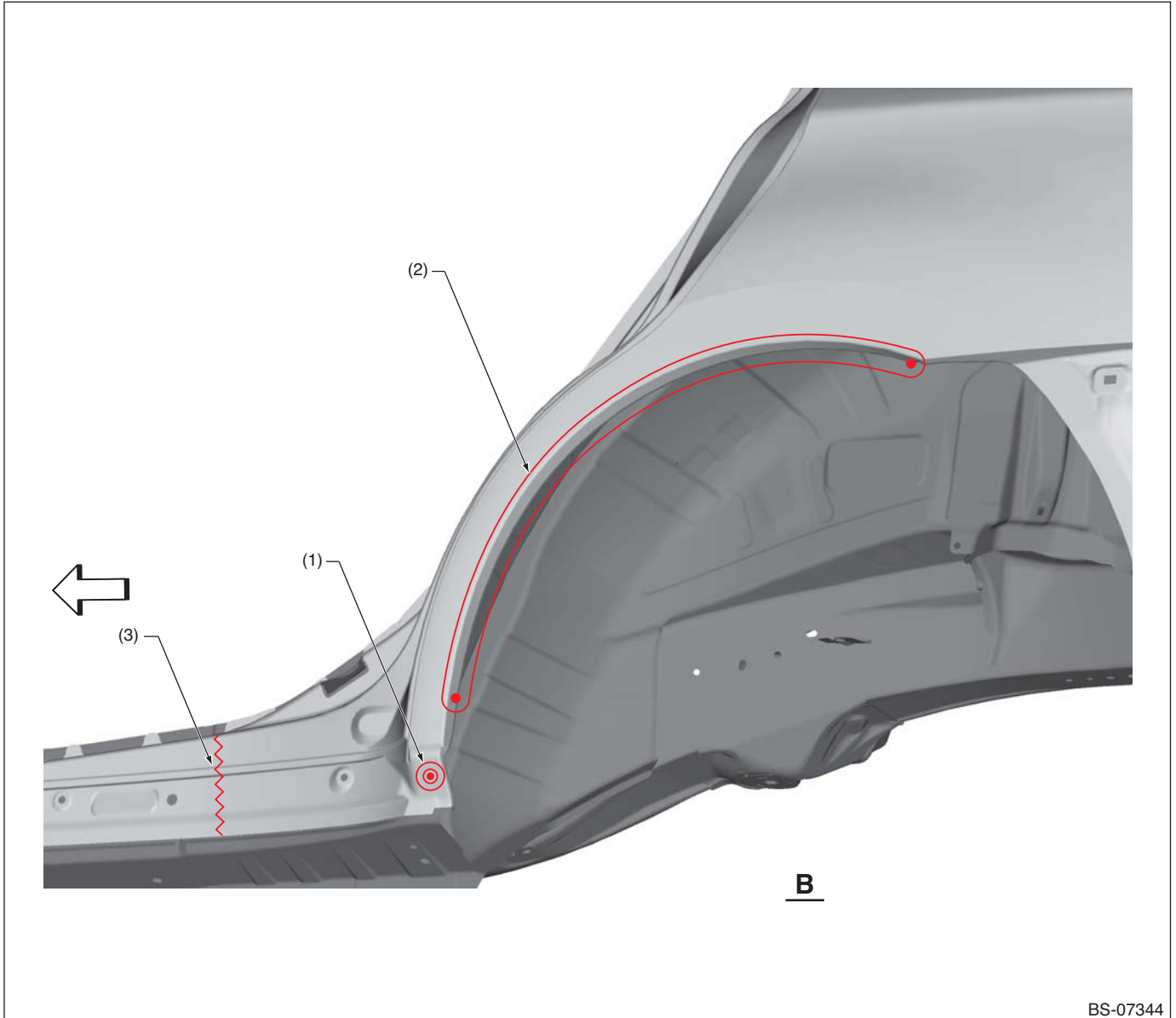
(1) Cut position
(2) 4 points

(3) 3 points
(4) 1 point

(5) 2 points

Panel Replacement

- View B



BS-07344

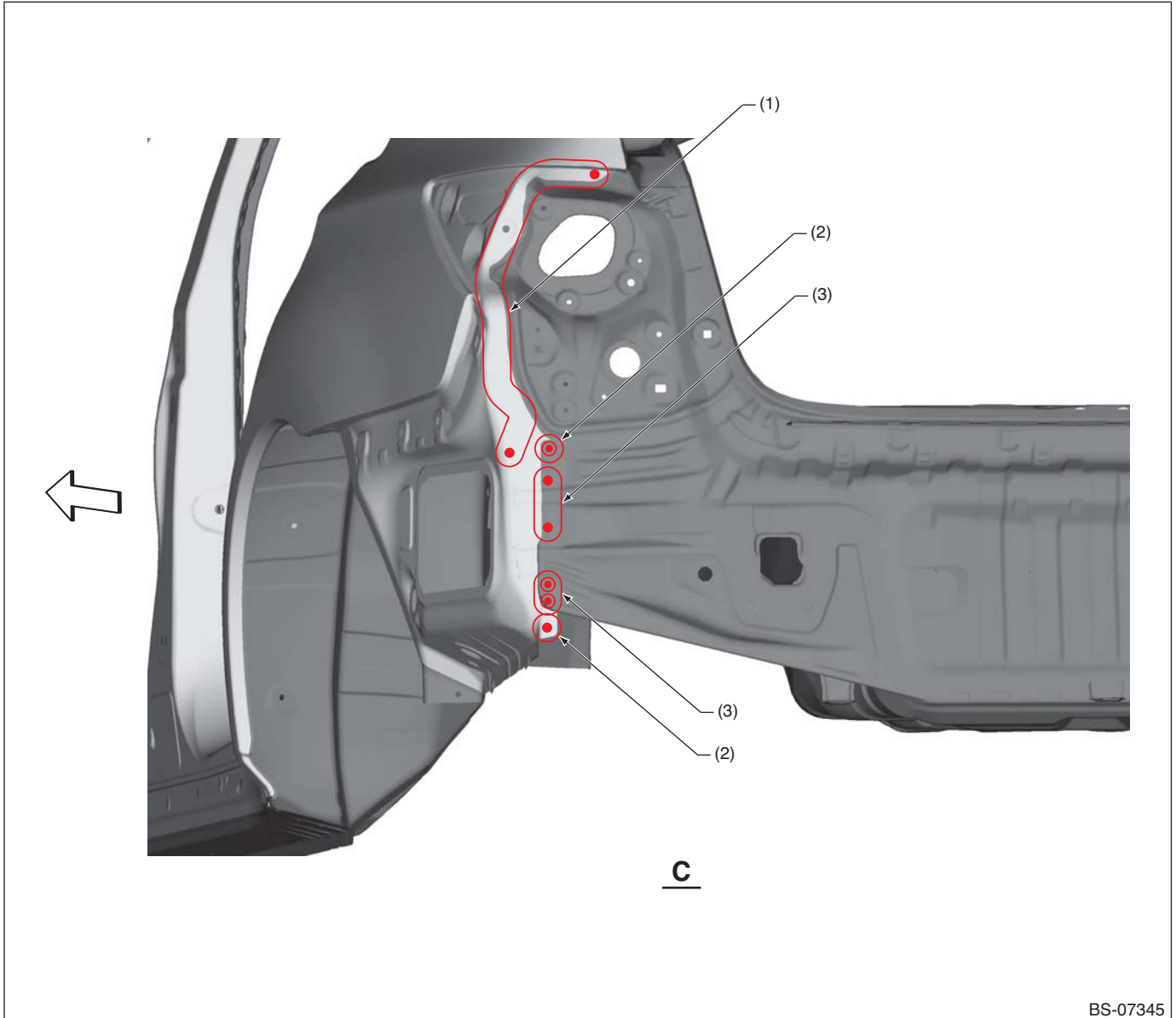
(1) 1 point

(2) 12 points

(3) Cut position

Panel Replacement

- View C



(1) 13 points

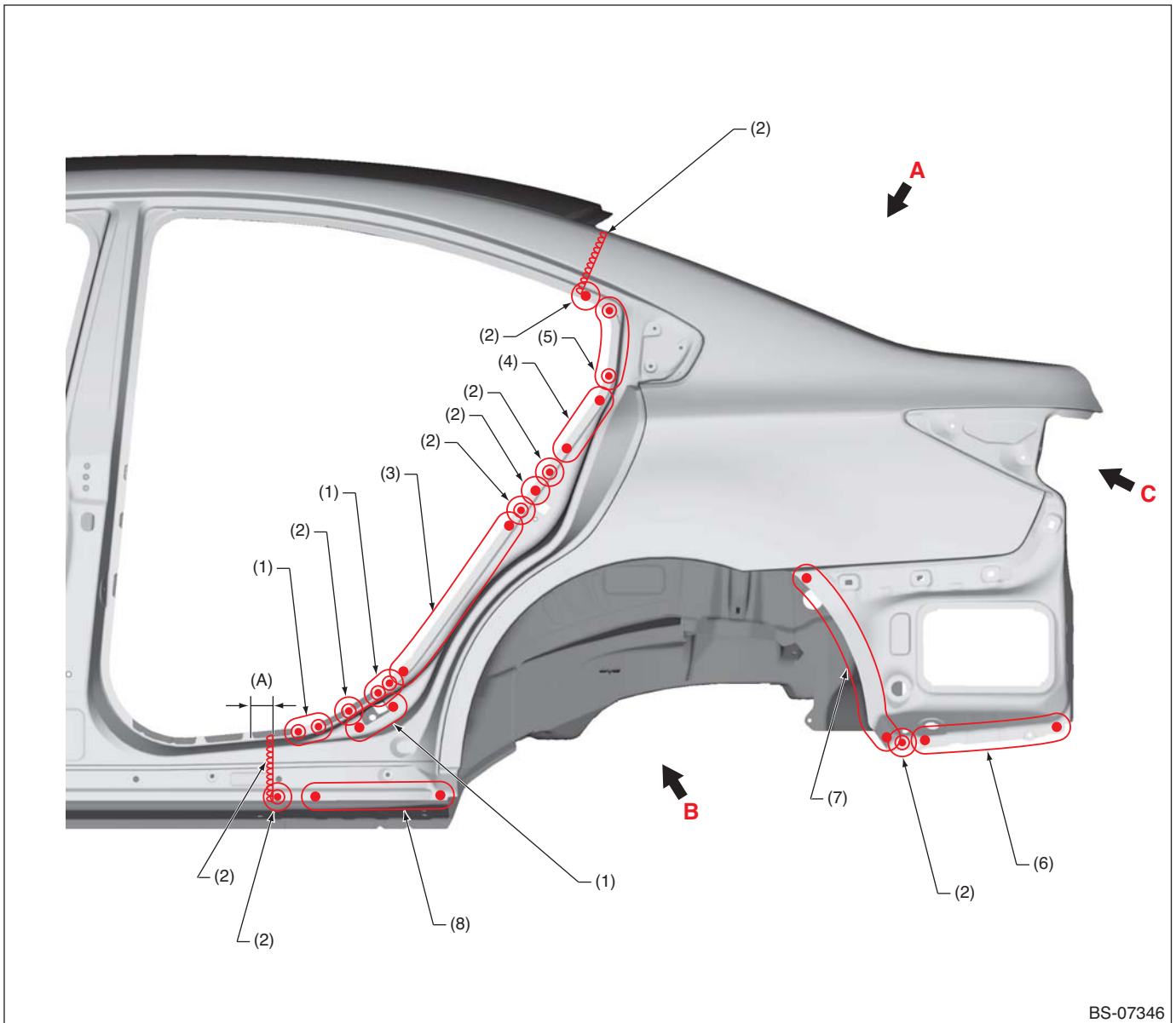
(2) 1 point

(3) 2 points

Panel Replacement

B: INSTALLATION

• Overall view



(A) 50 mm (1.97 in)

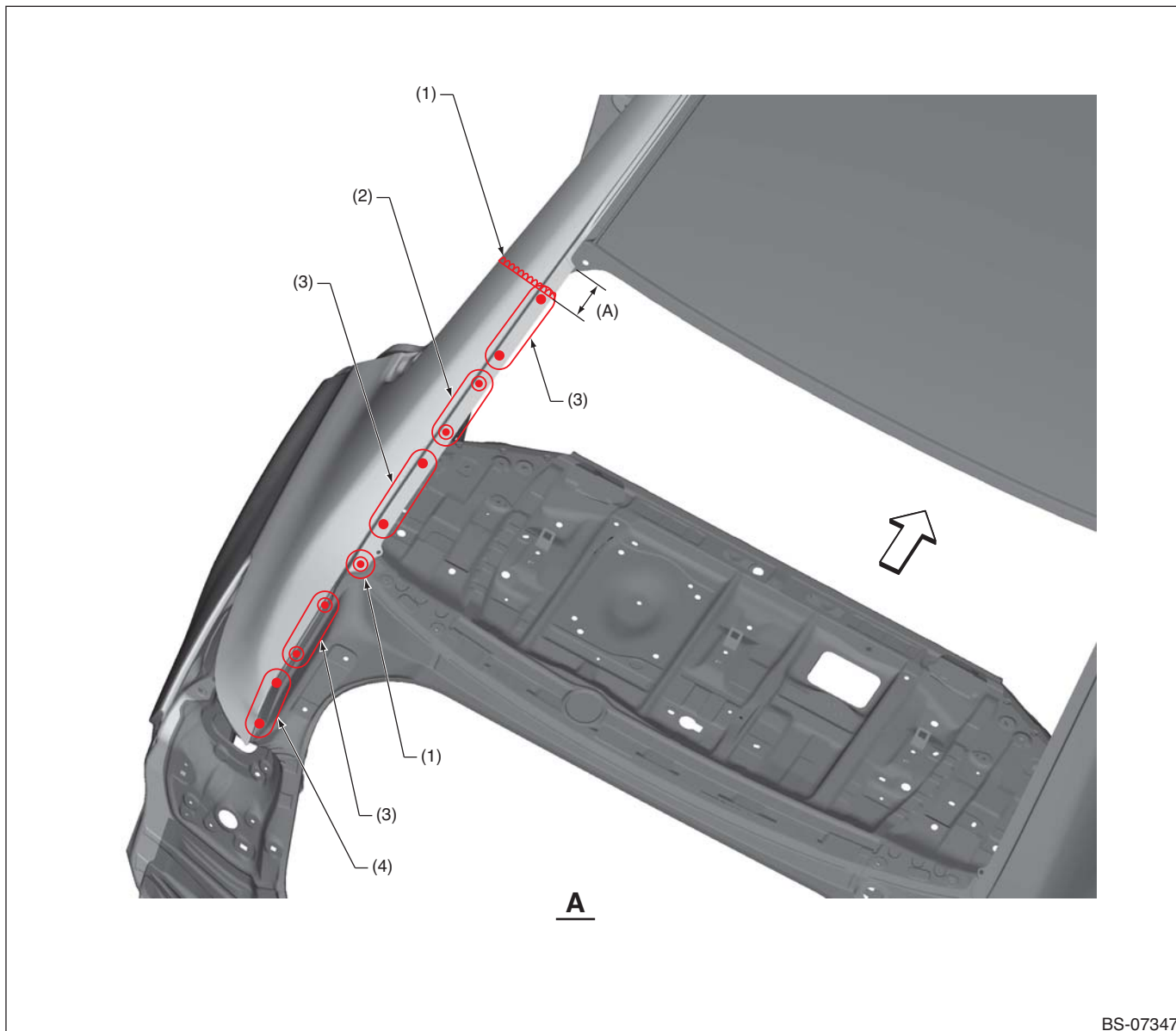
- (1) 2 points
- (2) 1 point
- (3) 7 points

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

- (7) 8 points
- (8) 5 points

Panel Replacement

- View A



BS-07347

(A) 60 mm (2.36 in)

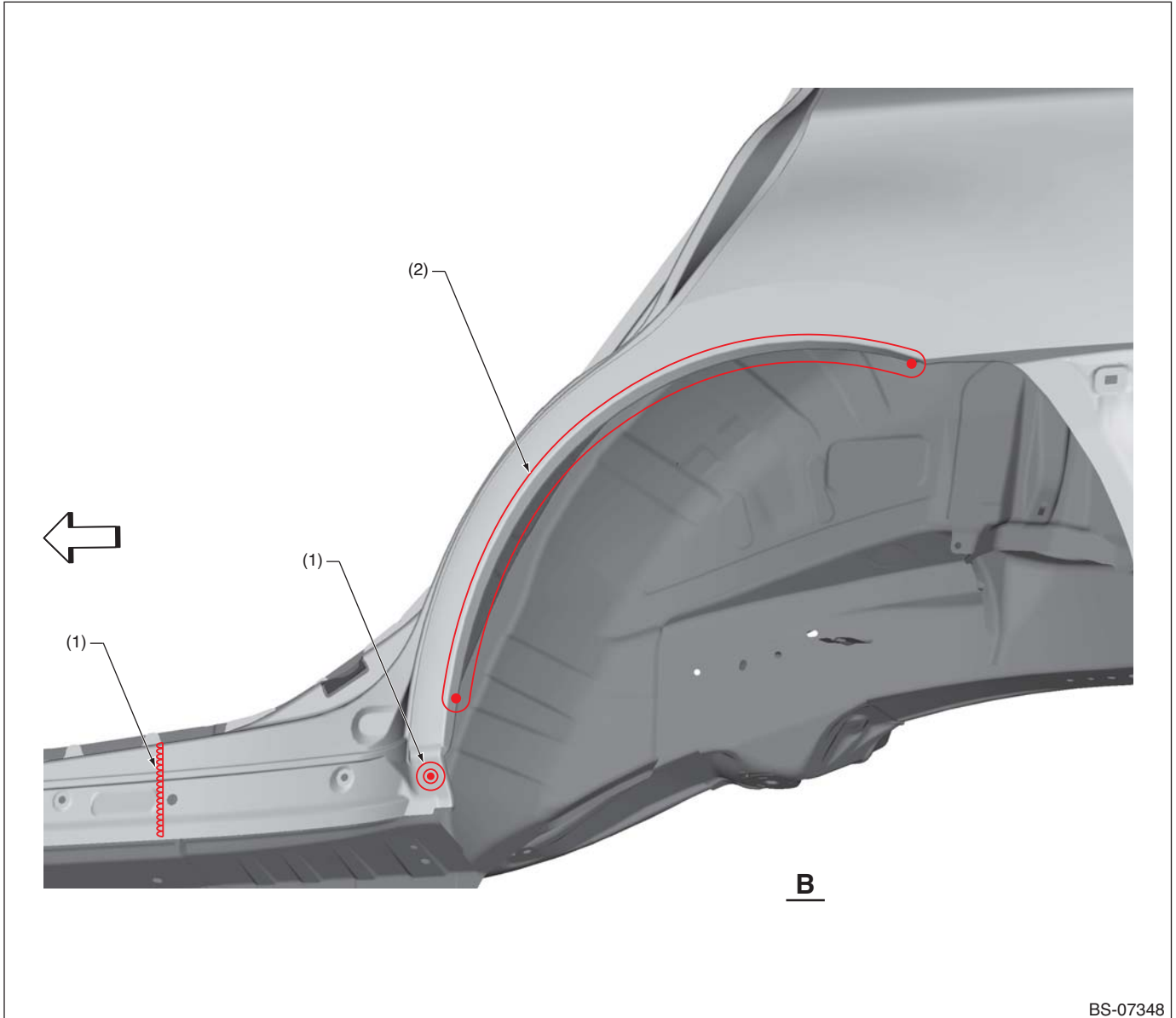
(1) 1 point
(2) 4 points

(3) 3 points

(4) 2 points

Panel Replacement

- View B



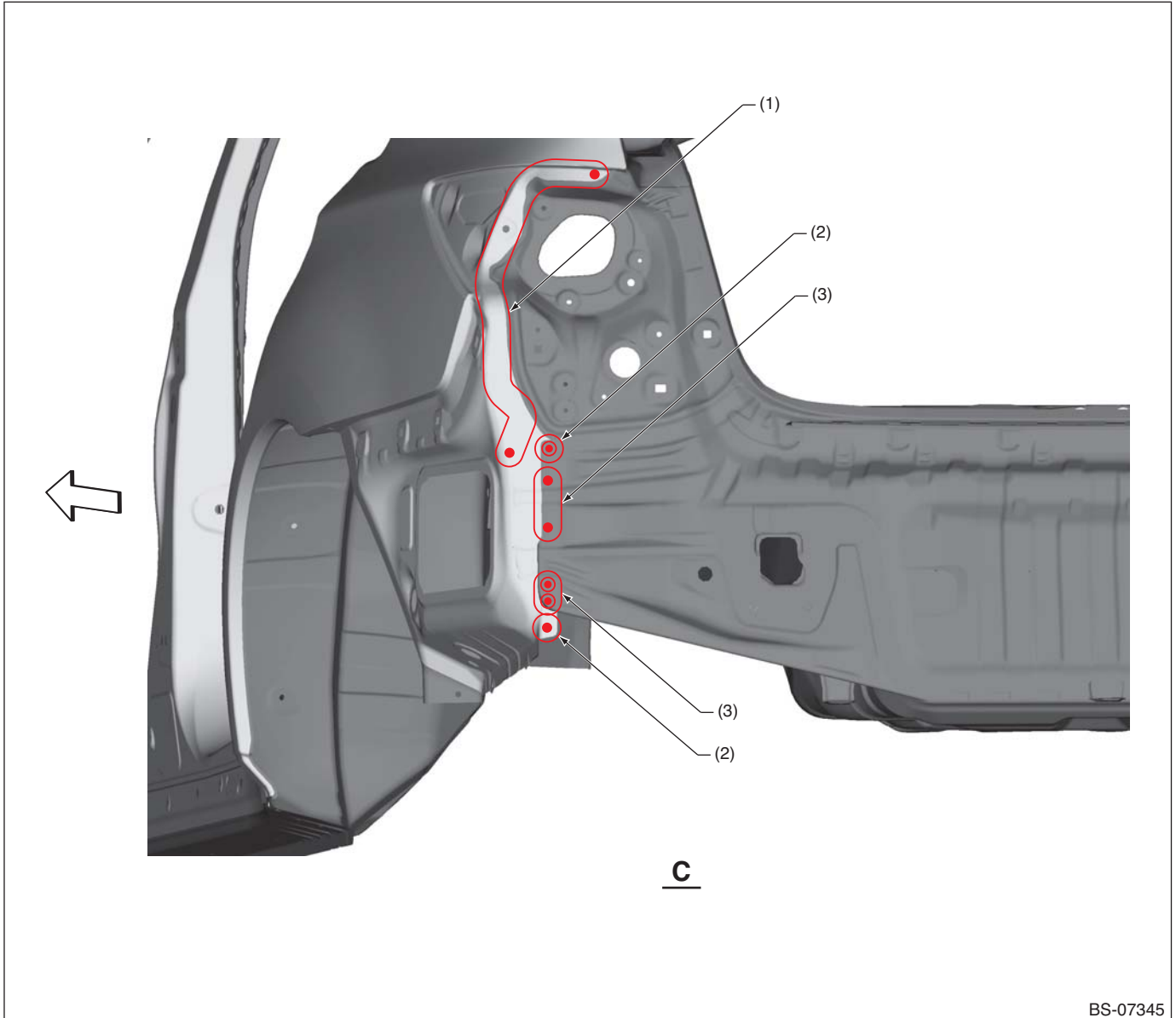
BS-07348

(1) 1 point

(2) 12 points

Panel Replacement

- View C



(1) 13 points

(2) 1 point

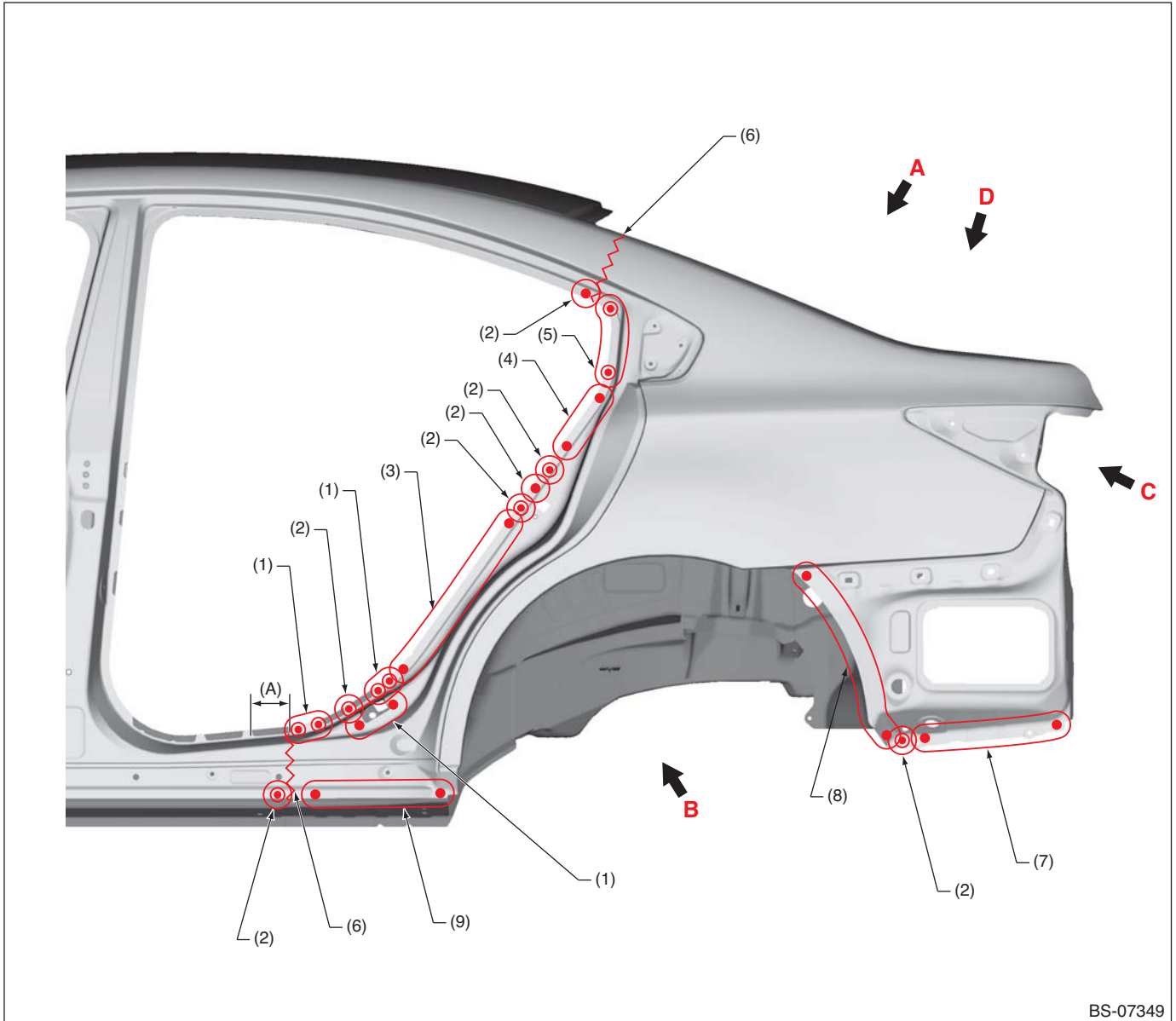
(3) 2 points

Panel Replacement

8-24. Rear Quarter (Partial replacement including rear pillar patch)/SEDAN

A: REMOVAL

• Overall view



(A) 90 mm (3.54 in)

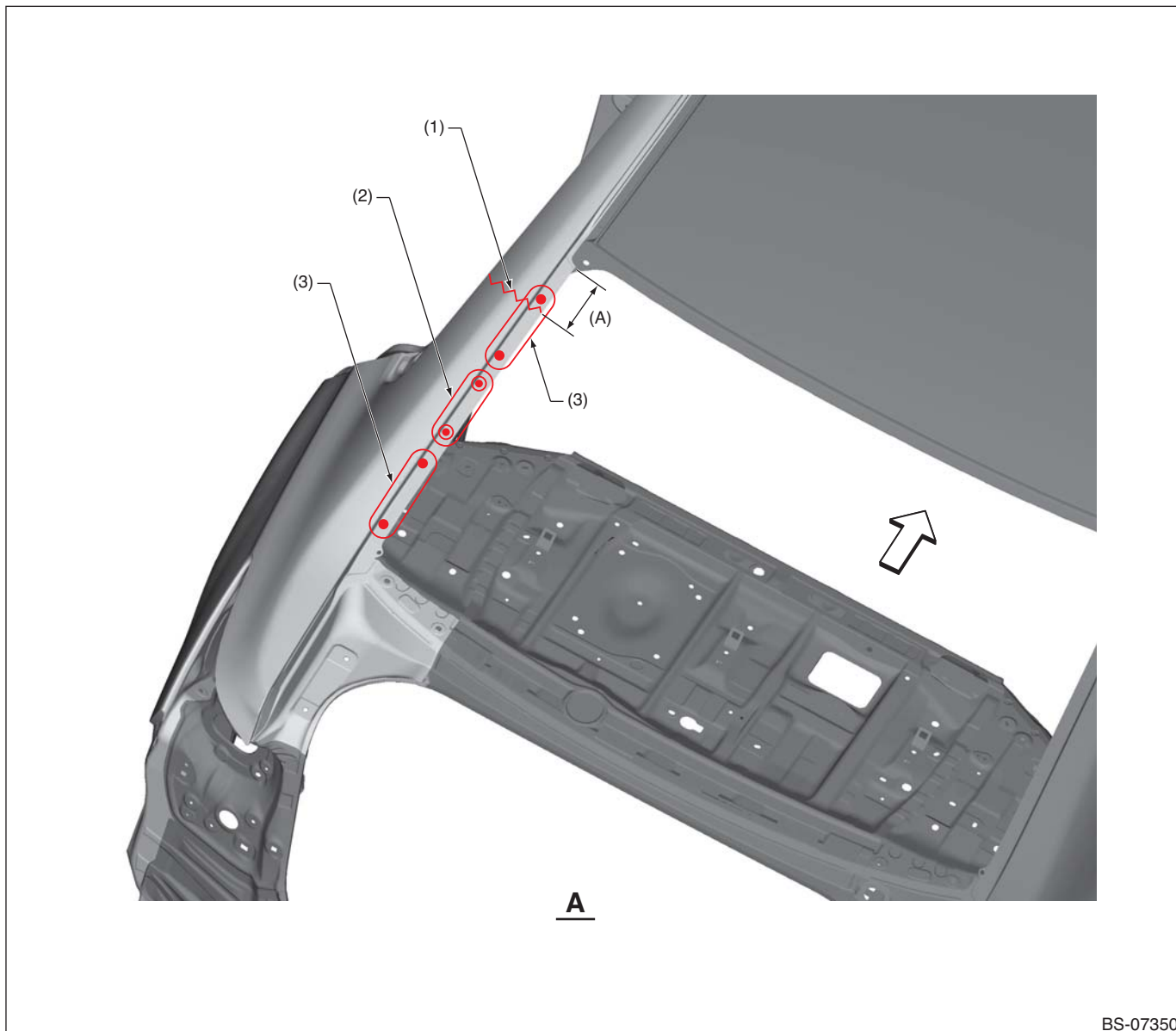
(1) 2 points
(2) 1 point
(3) 7 points

(4) 3 points
(5) 4 points
(6) Cut position

(7) 6 points
(8) 8 points
(9) 5 points

Panel Replacement

- View A



BS-07350

(A) 100 mm (3.94 in)

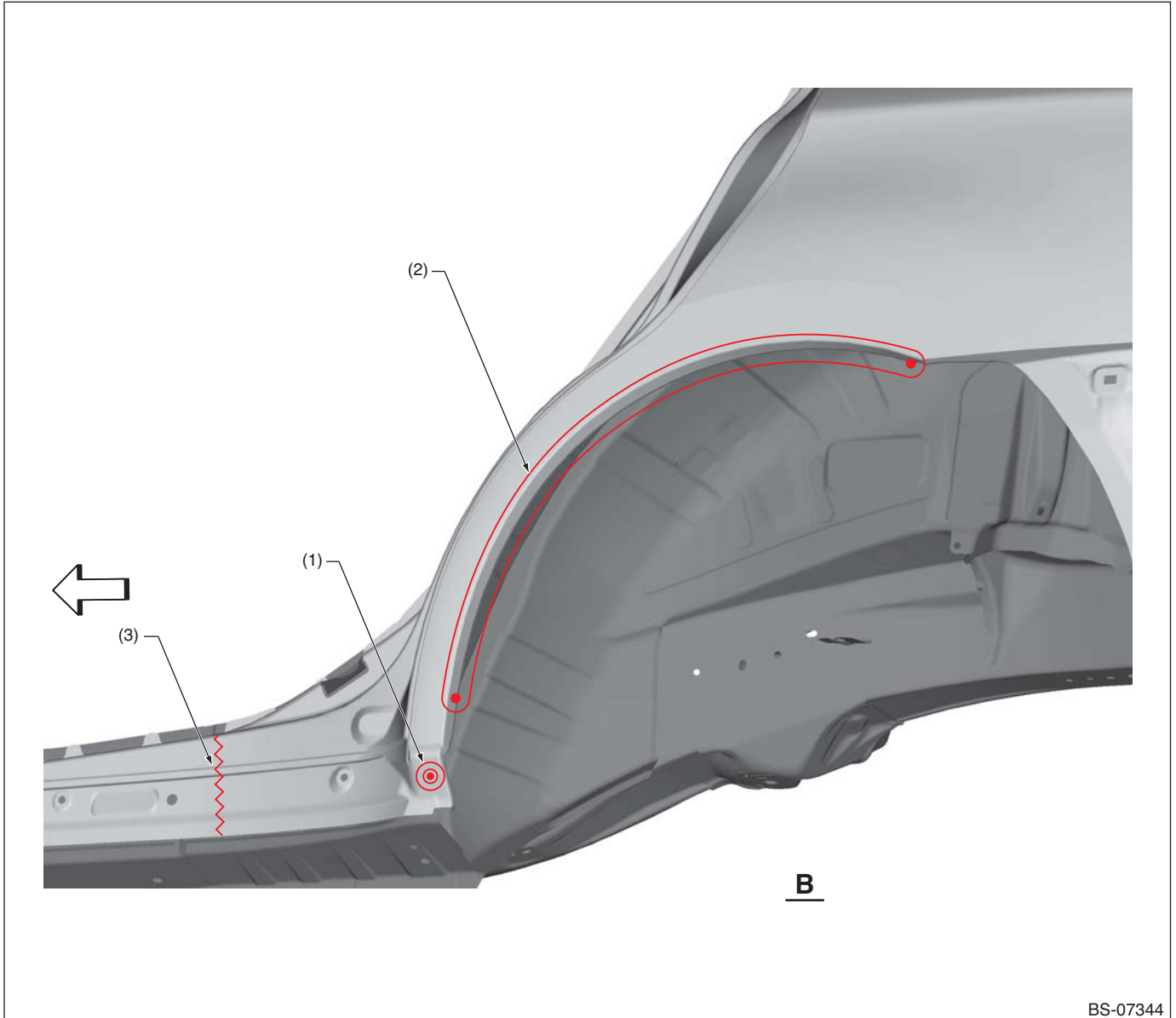
(1) Cut position

(2) 4 points

(3) 3 points

Panel Replacement

- View B



BS-07344

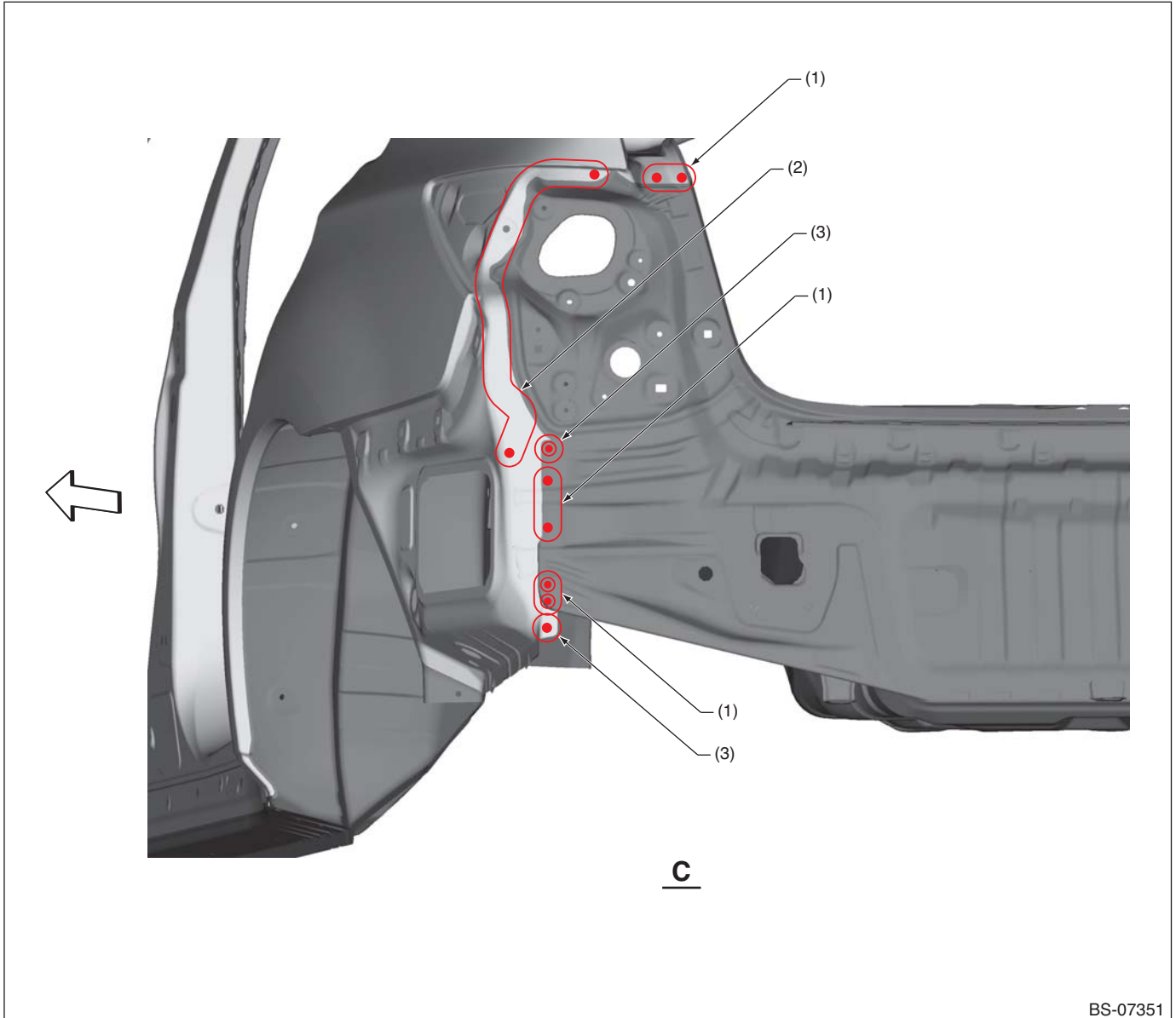
(1) 1 point

(2) 12 points

(3) Cut position

Panel Replacement

- View C



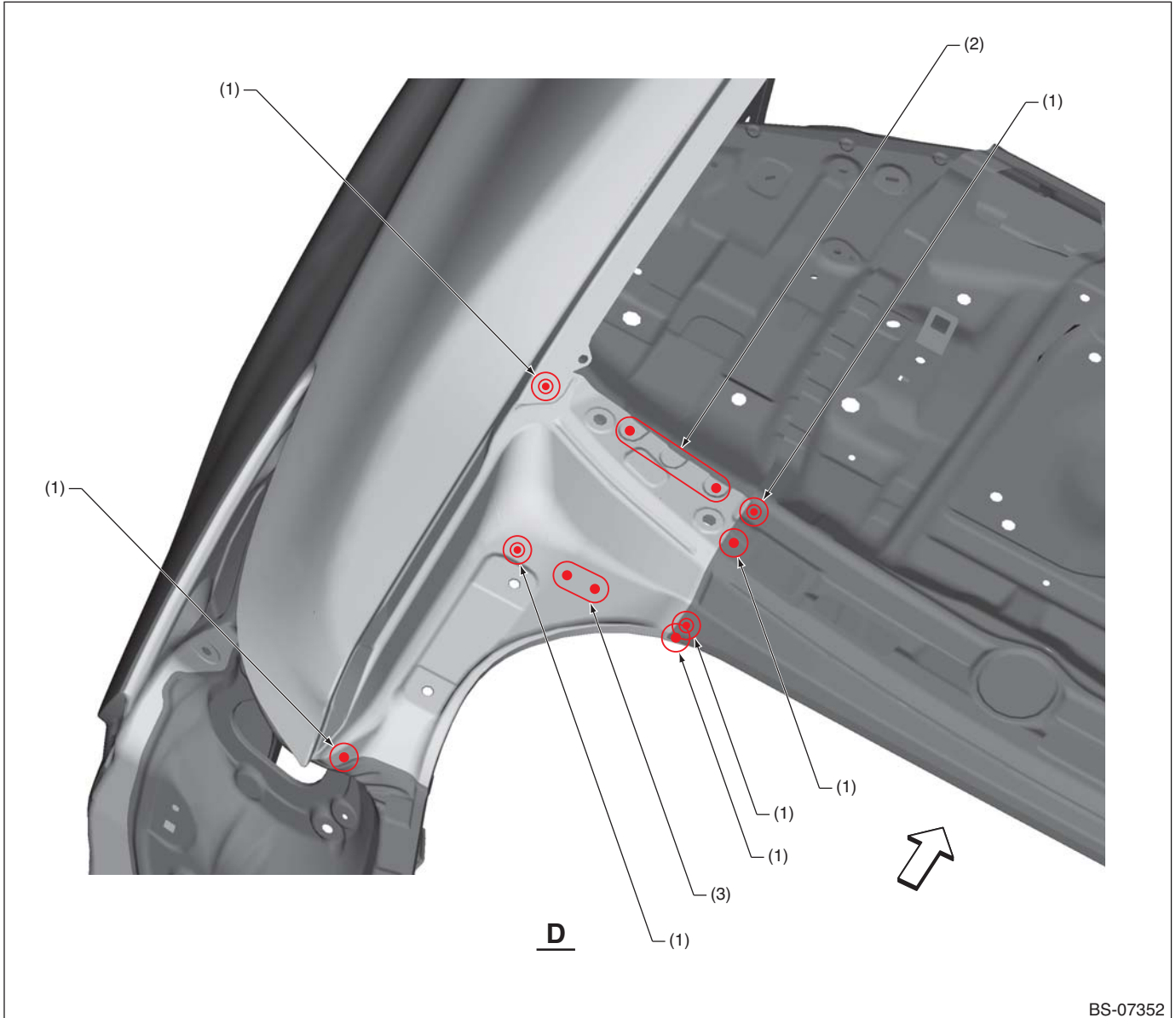
(1) 2 points

(2) 13 points

(3) 1 point

Panel Replacement

- View D



BS-07352

(1) 1 point

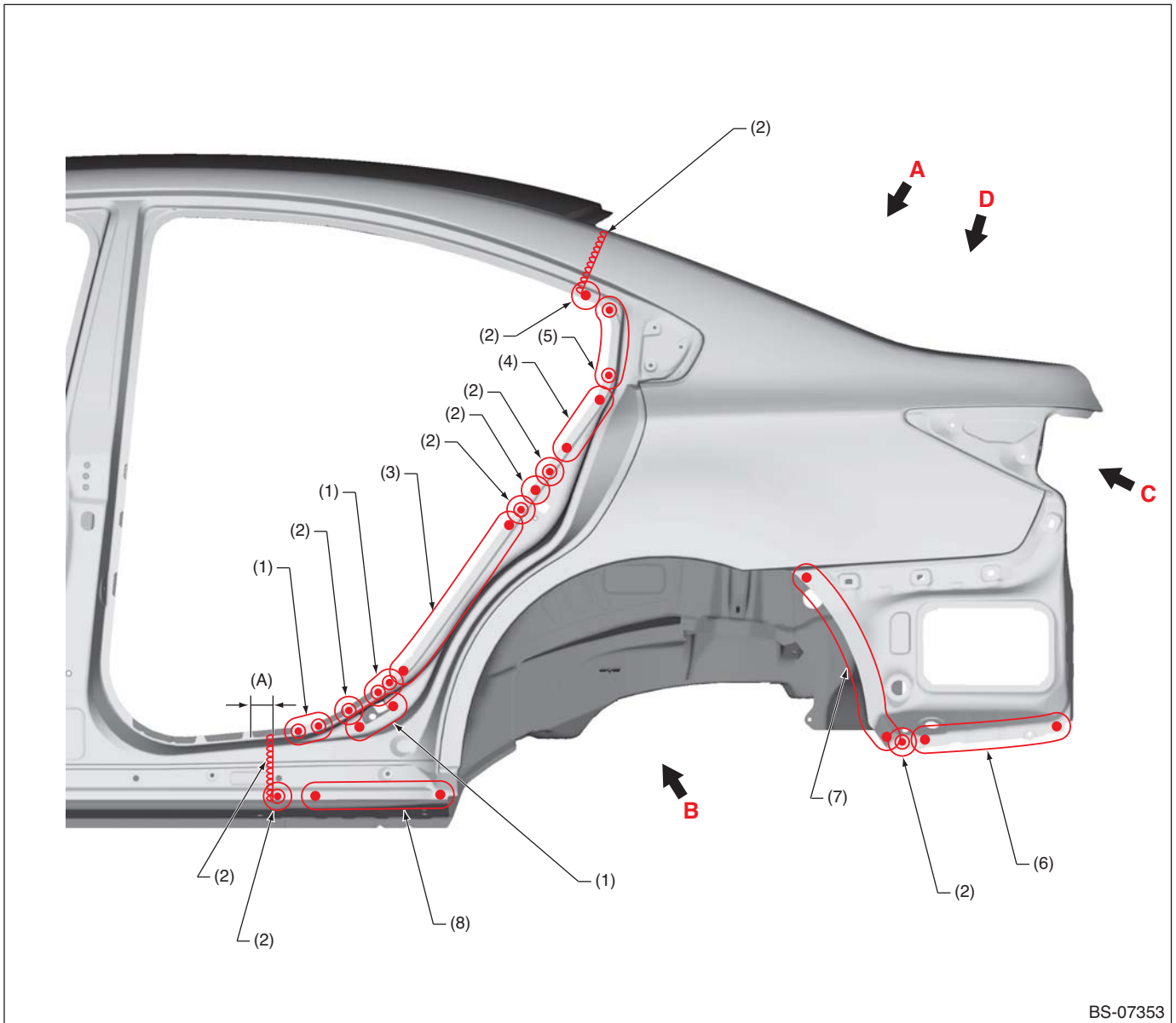
(2) 3 points

(3) 2 points

Panel Replacement

B: INSTALLATION

• Overall view



(A) 50 mm (1.97 in)

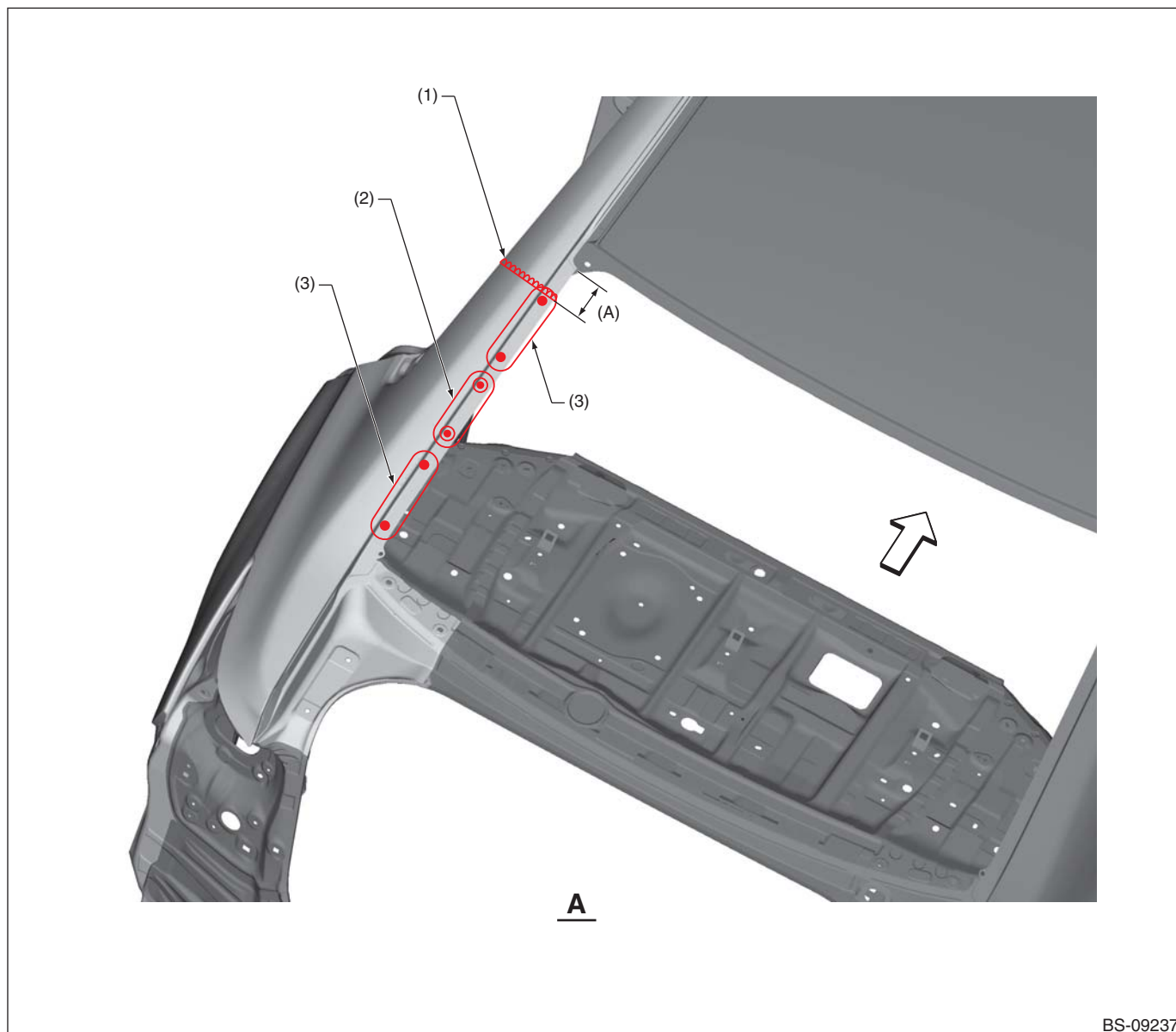
(1) 2 points
(2) 1 point
(3) 7 points

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

(7) 8 points
(8) 5 points

Panel Replacement

- View A



BS-09237

(A) 60 mm (2.36 in)

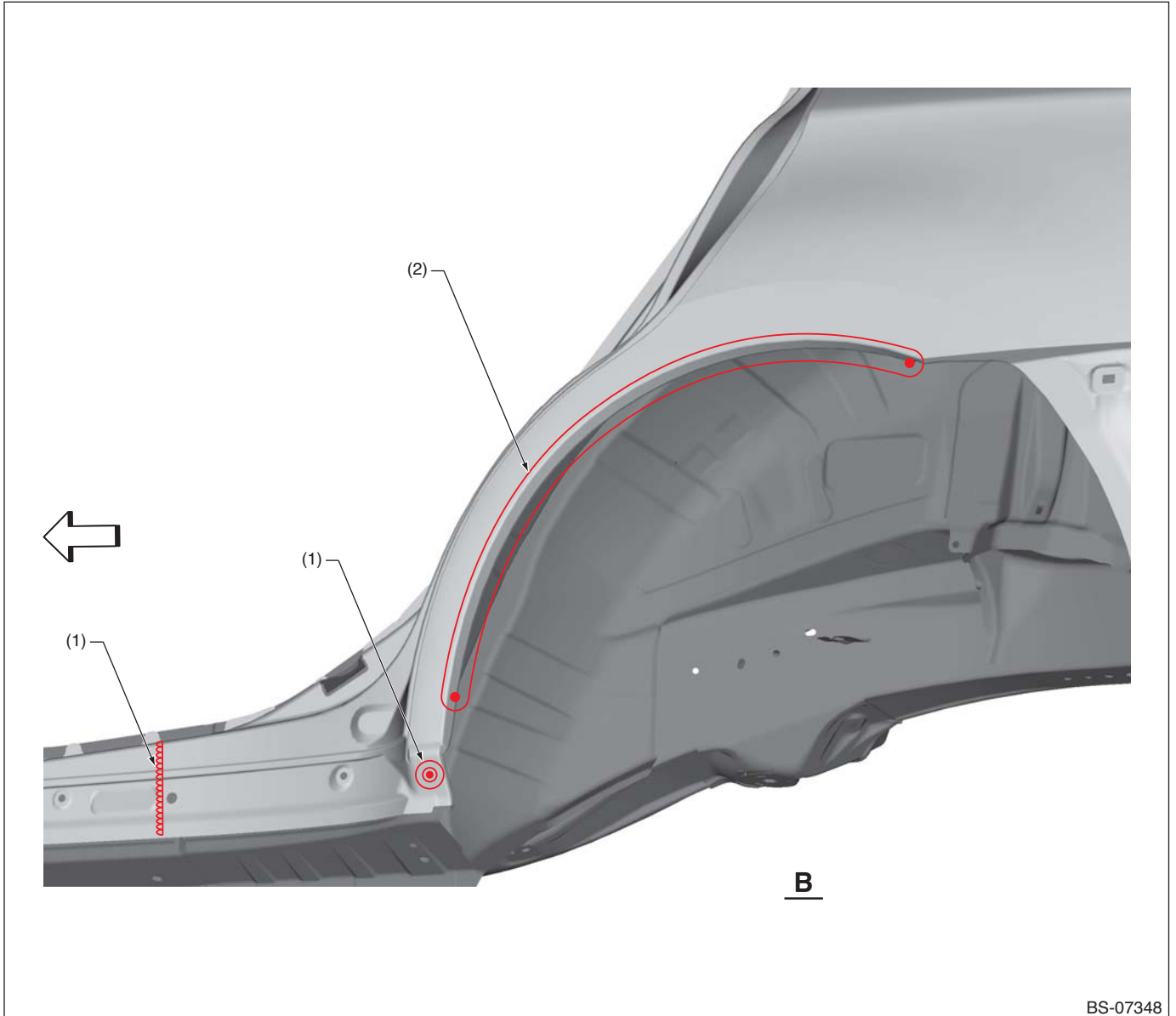
(1) 1 point

(2) 4 points

(3) 3 points

Panel Replacement

- View B



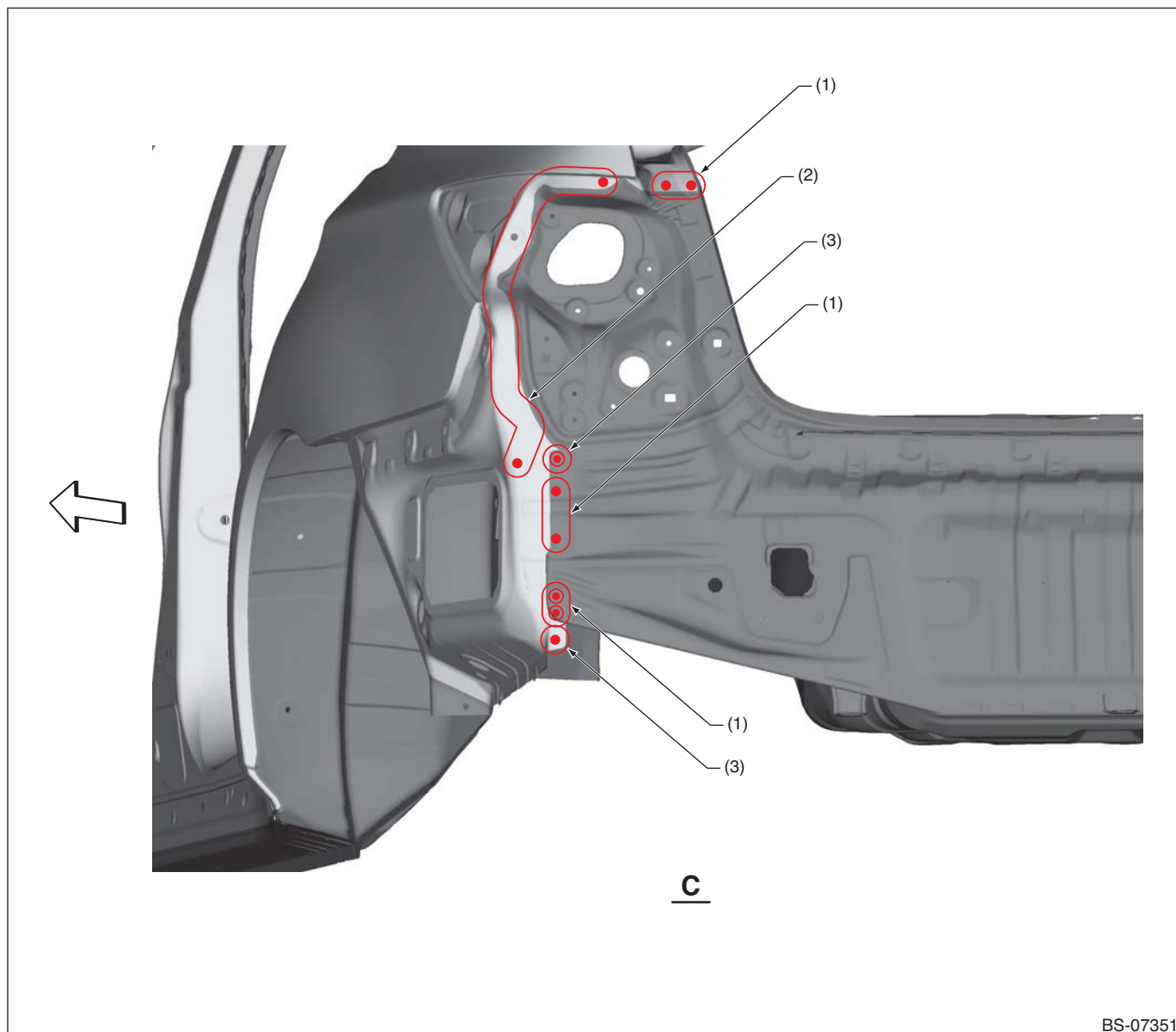
BS-07348

(1) 1 point

(2) 12 points

Panel Replacement

- View C



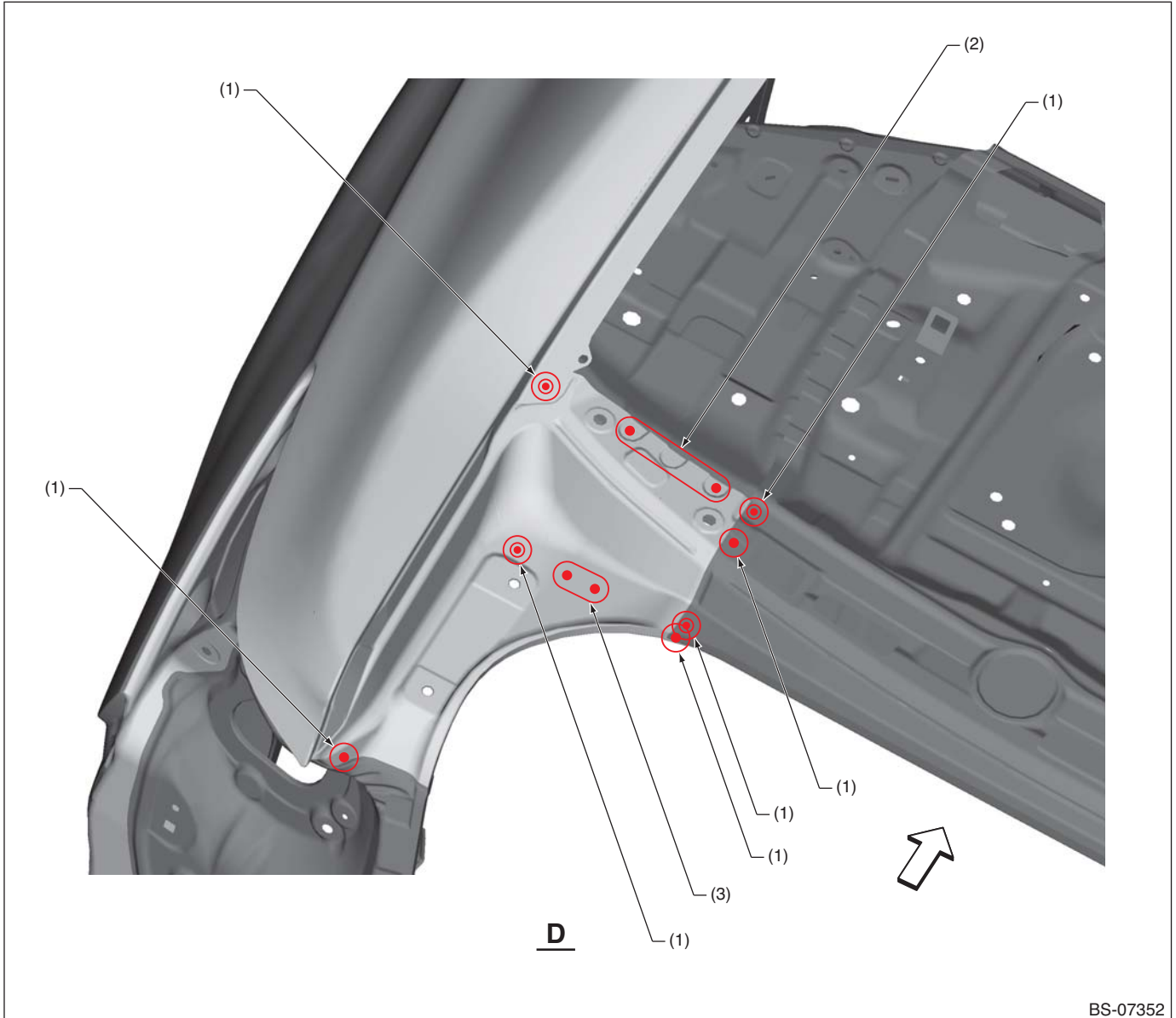
(1) 2 points

(2) 13 points

(3) 1 point

Panel Replacement

- View D



(1) 1 point

(2) 3 points

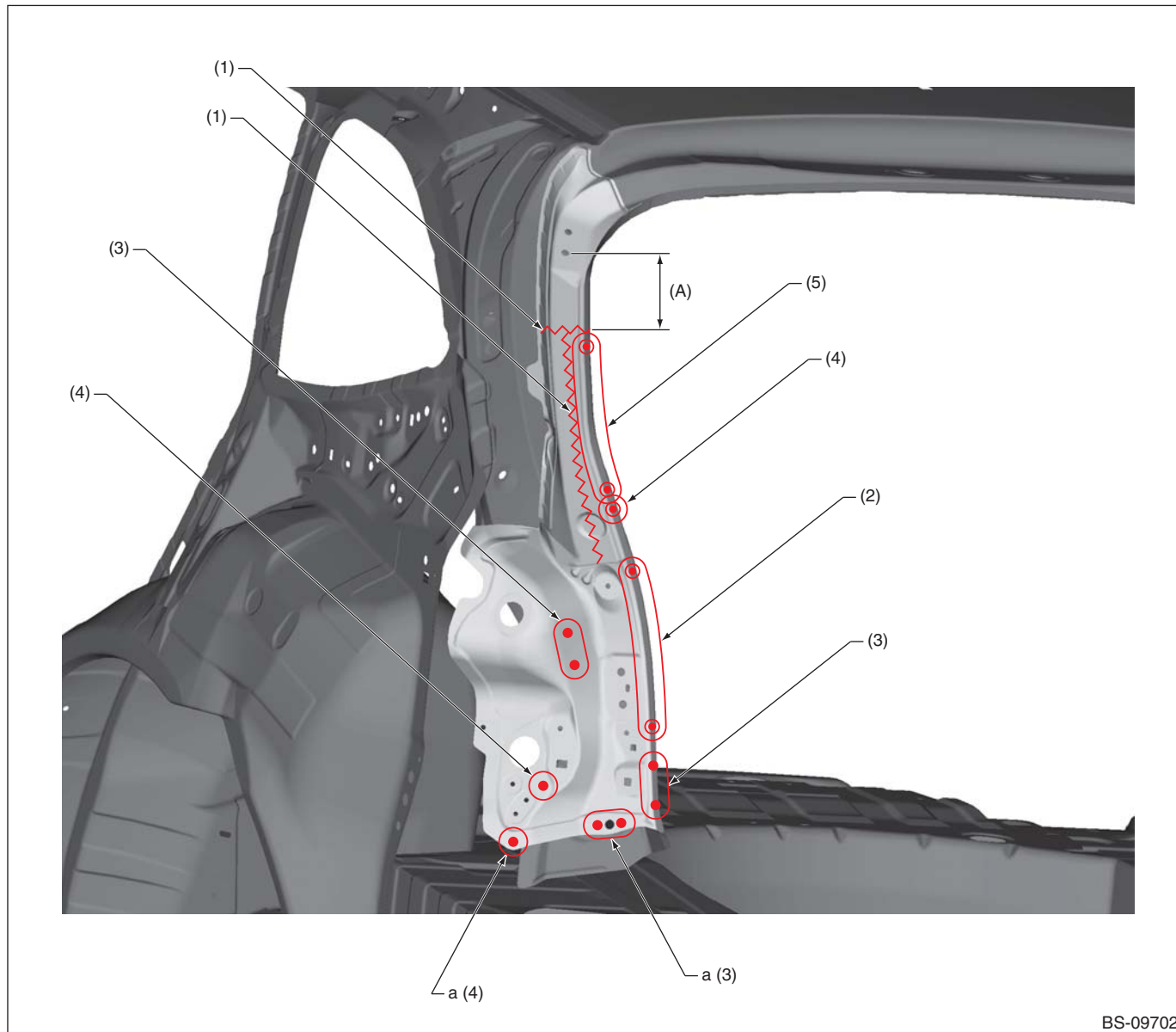
(3) 2 points

Panel Replacement

8-25. Rear Quarter End (Partial replacement)/OUTBACK

A: REMOVAL

- **Rear quarter outer removal condition**



(A) 80 mm (3.15 in)

- (1) Cut position
- (2) 5 points

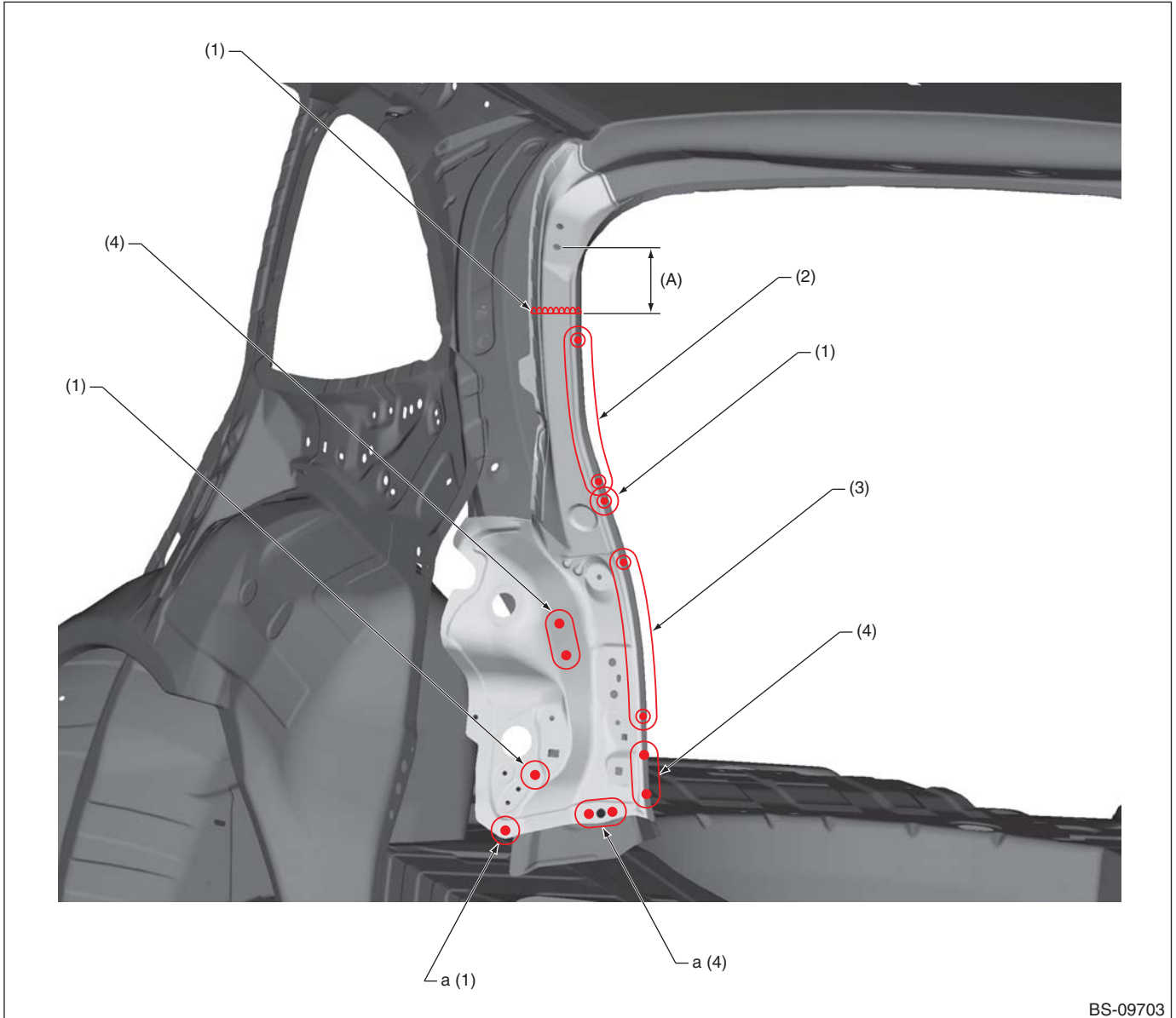
- (3) 2 points
(4) 1 point

- (5) 4 points

Note: "a" is not required when the rear skirt is removed.

Panel Replacement

B: INSTALLATION



BS-09703

(A) 50 mm (1.97 in)

(1) 1 point
(2) 4 points

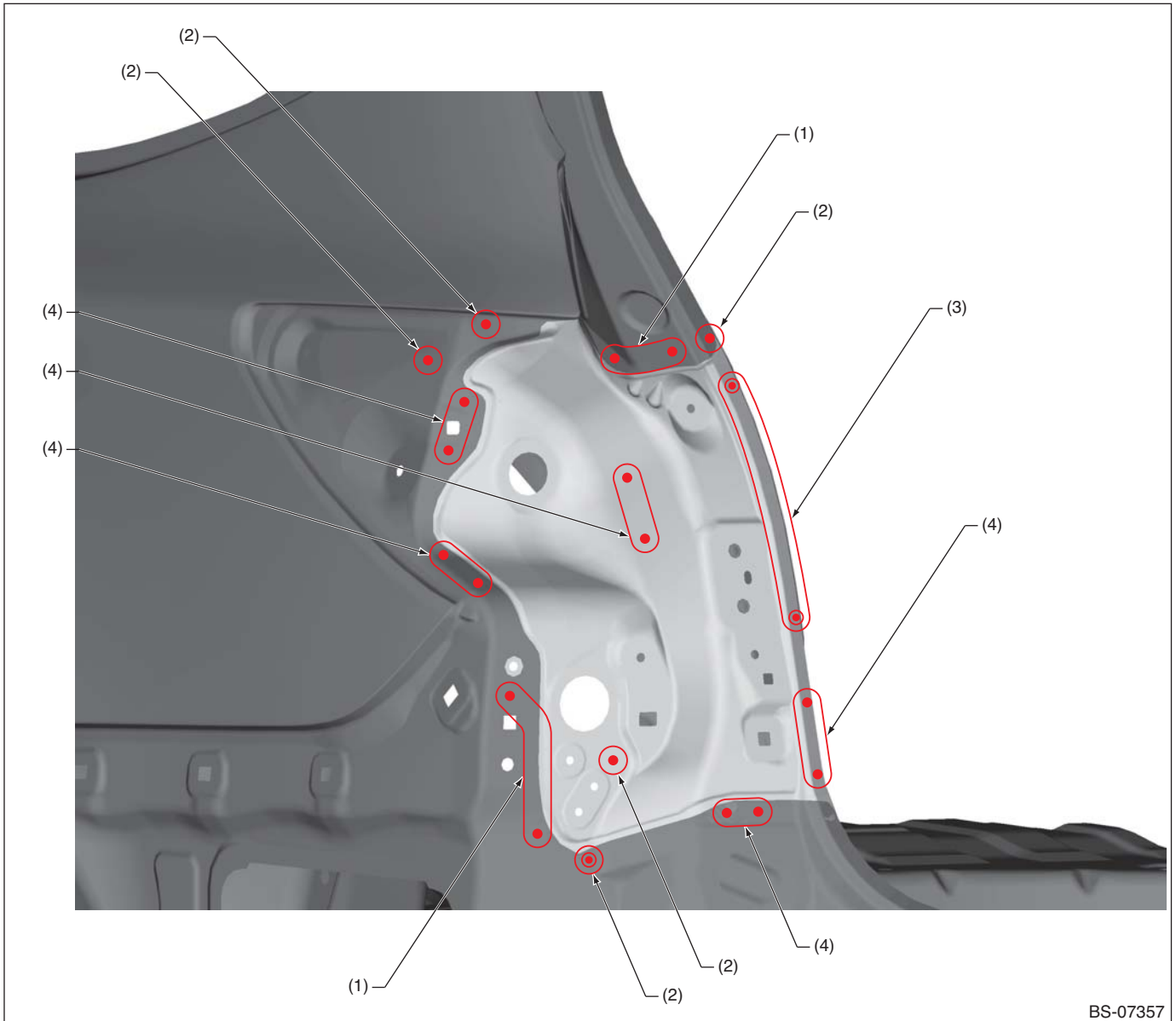
(3) 5 points

(4) 2 points

Note: "a" is not required when the rear skirt is removed.

Panel Replacement

8-26. Rear Quarter End Panel (Replacement of only the part)/OUTBACK A: REMOVAL



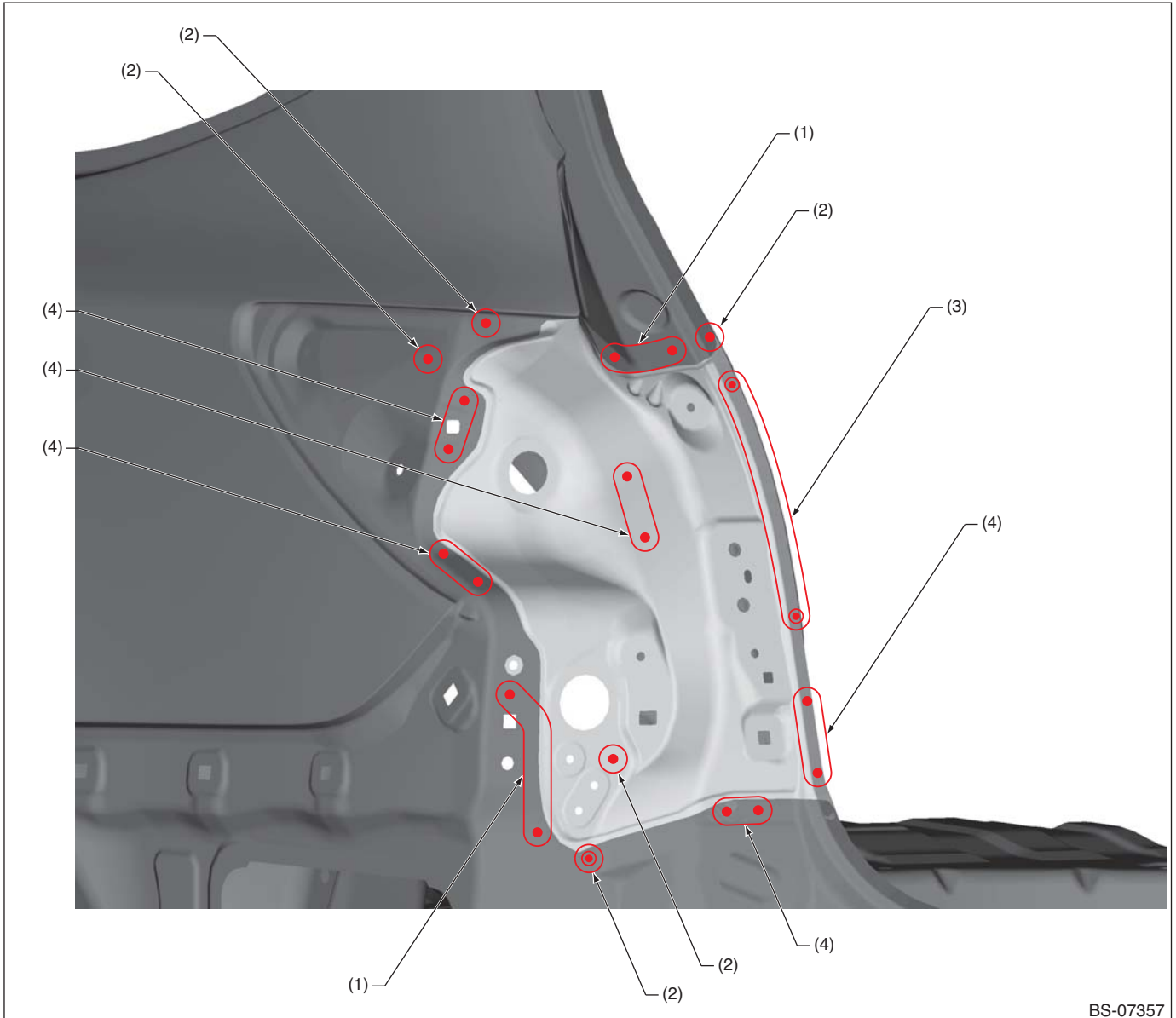
(1) 3 points
(2) 1 point

(3) 5 points

(4) 2 points

Panel Replacement

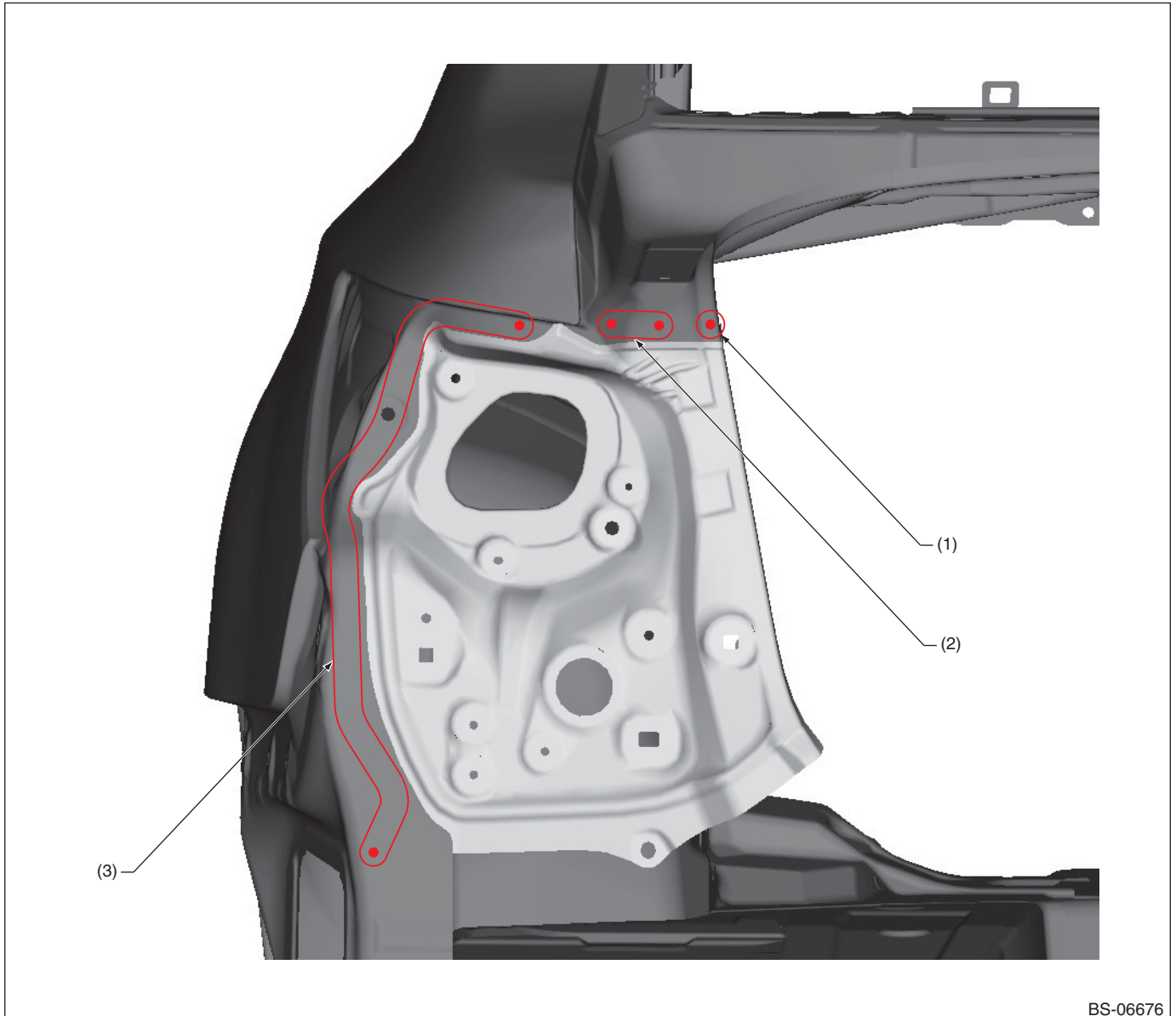
B: INSTALLATION



Panel Replacement

8-27. Rear Quarter End Panel (Total replacement)/SEDAN

A: REMOVAL



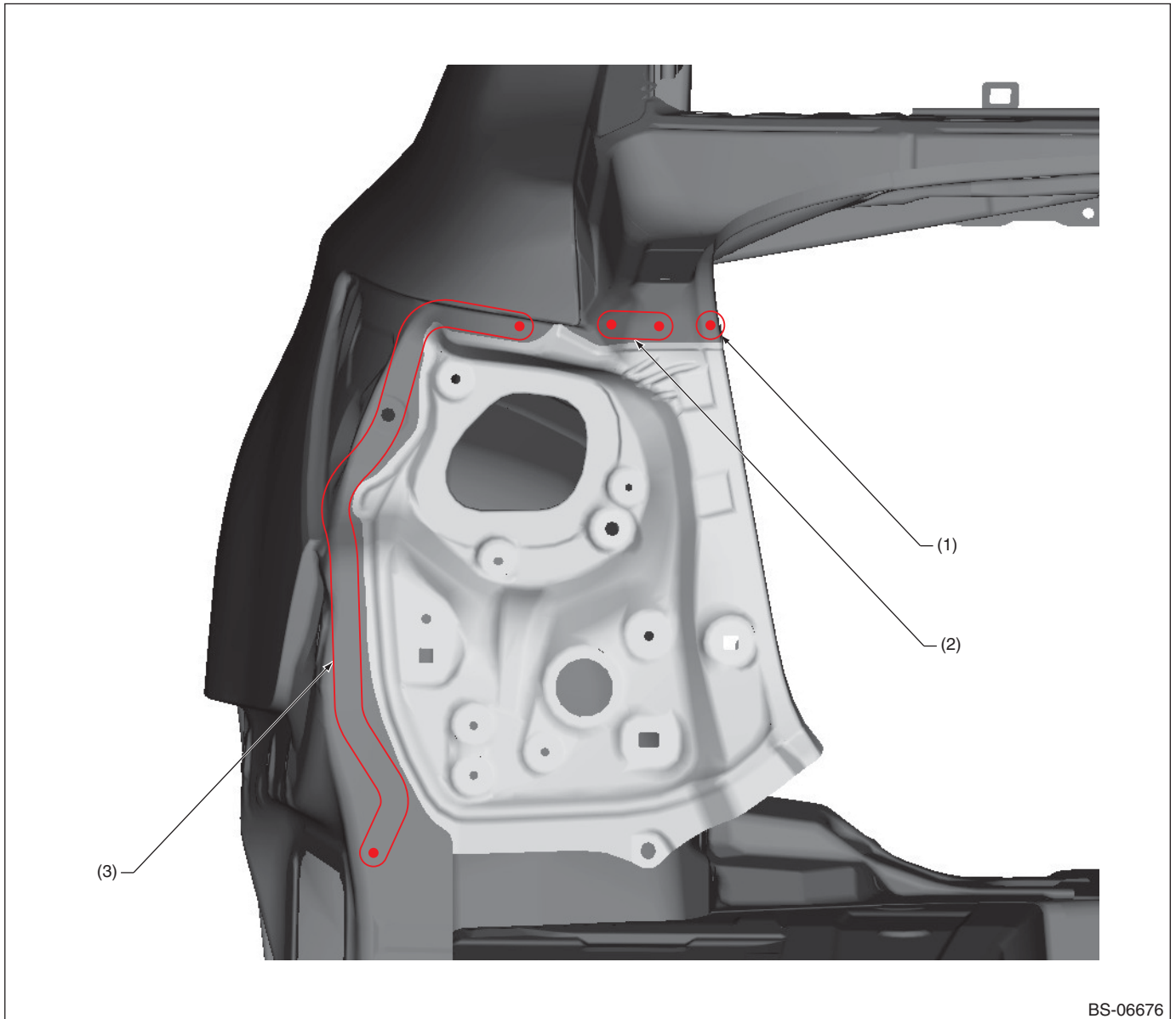
(1) 1 point

(2) 2 points

(3) 13 points

Panel Replacement

B: INSTALLATION



BS-06676

(1) 1 point

(2) 2 points

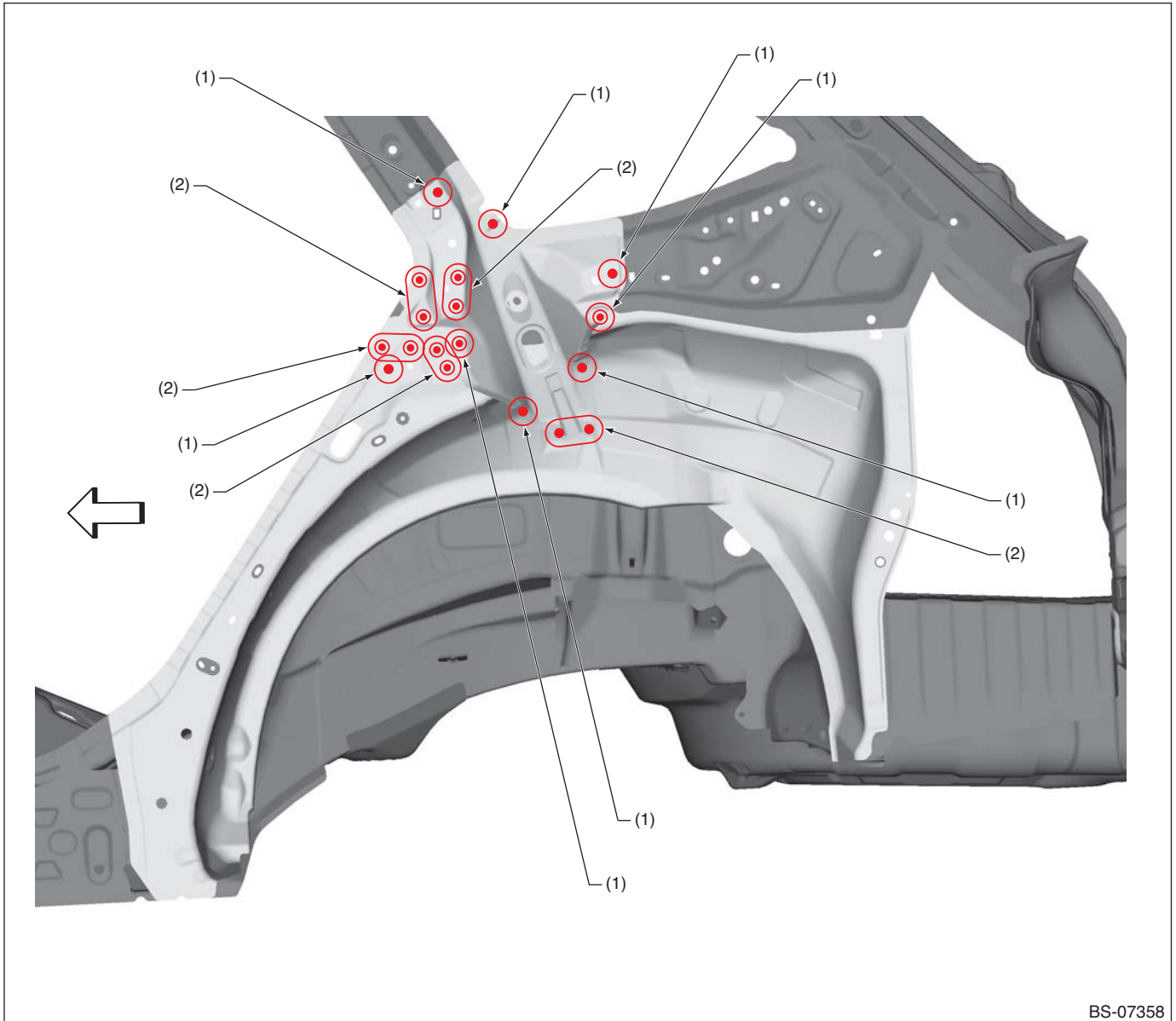
(3) 13 points

Panel Replacement

8-28. Arch Rear Inner LH (Total replacement)/OUTBACK

A: REMOVAL

- Overall view 1 (Rear quarter outer and side sill reinforcement outer removal condition)

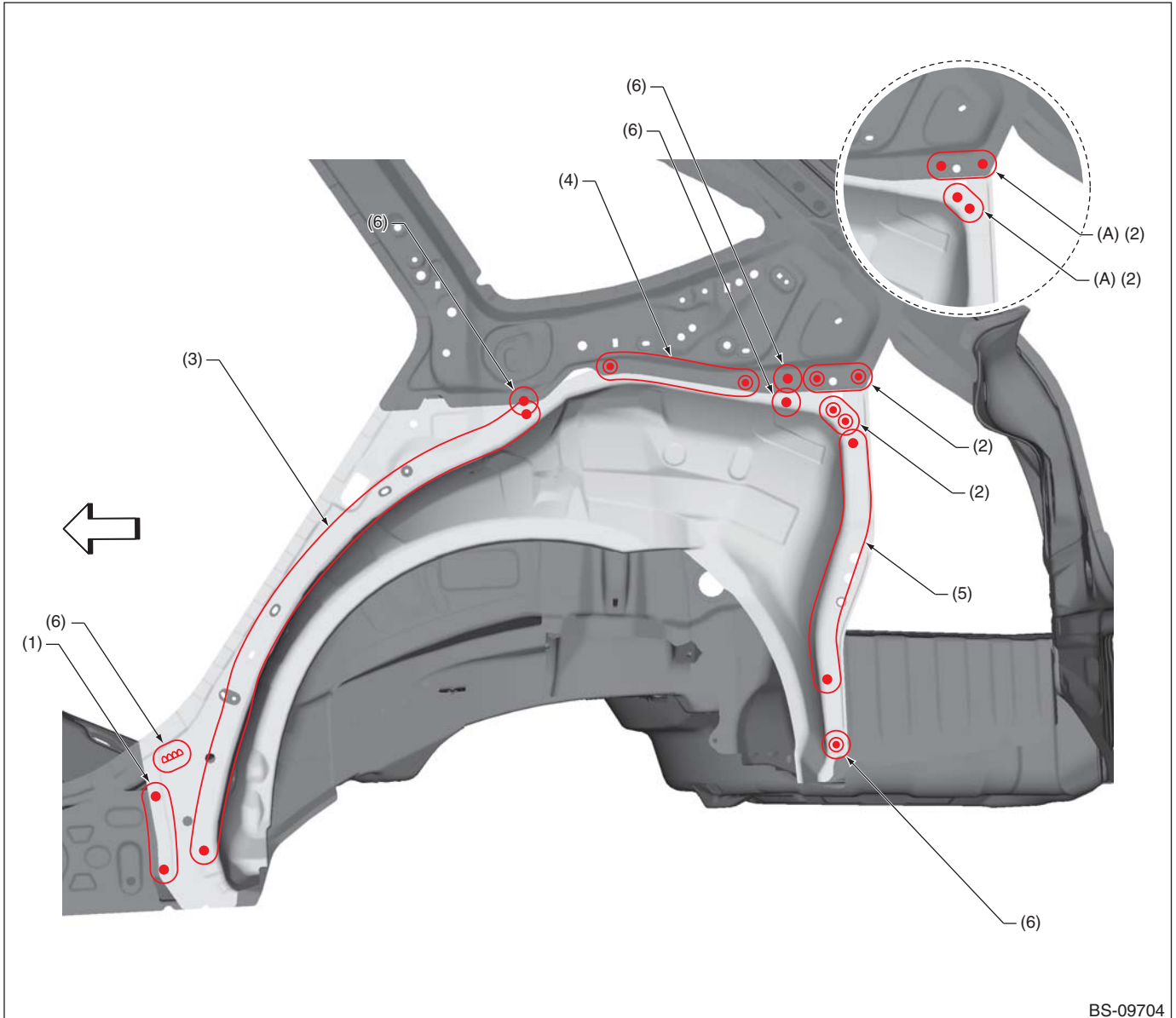


(1) 1 point

(2) 2 points

Panel Replacement

- Overall view 2 (Rear quarter outer and side sill reinforcement outer removal condition)



(A) Model without power rear gate

(1) 3 points

(2) 2 points

(3) 14 points

(4) 4 points

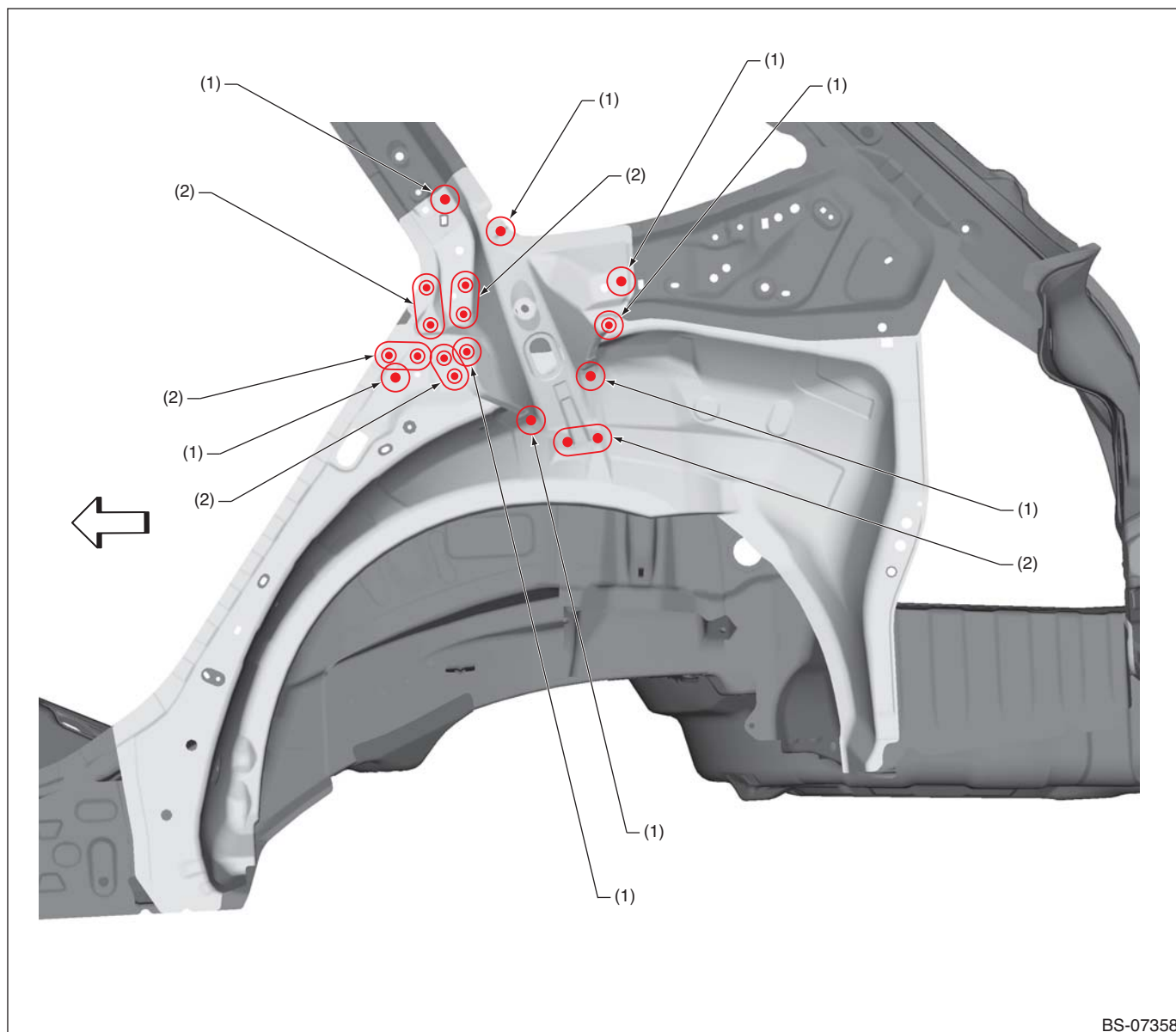
(5) 8 points

(6) 1 point

Panel Replacement

B: INSTALLATION

• Overall view 1

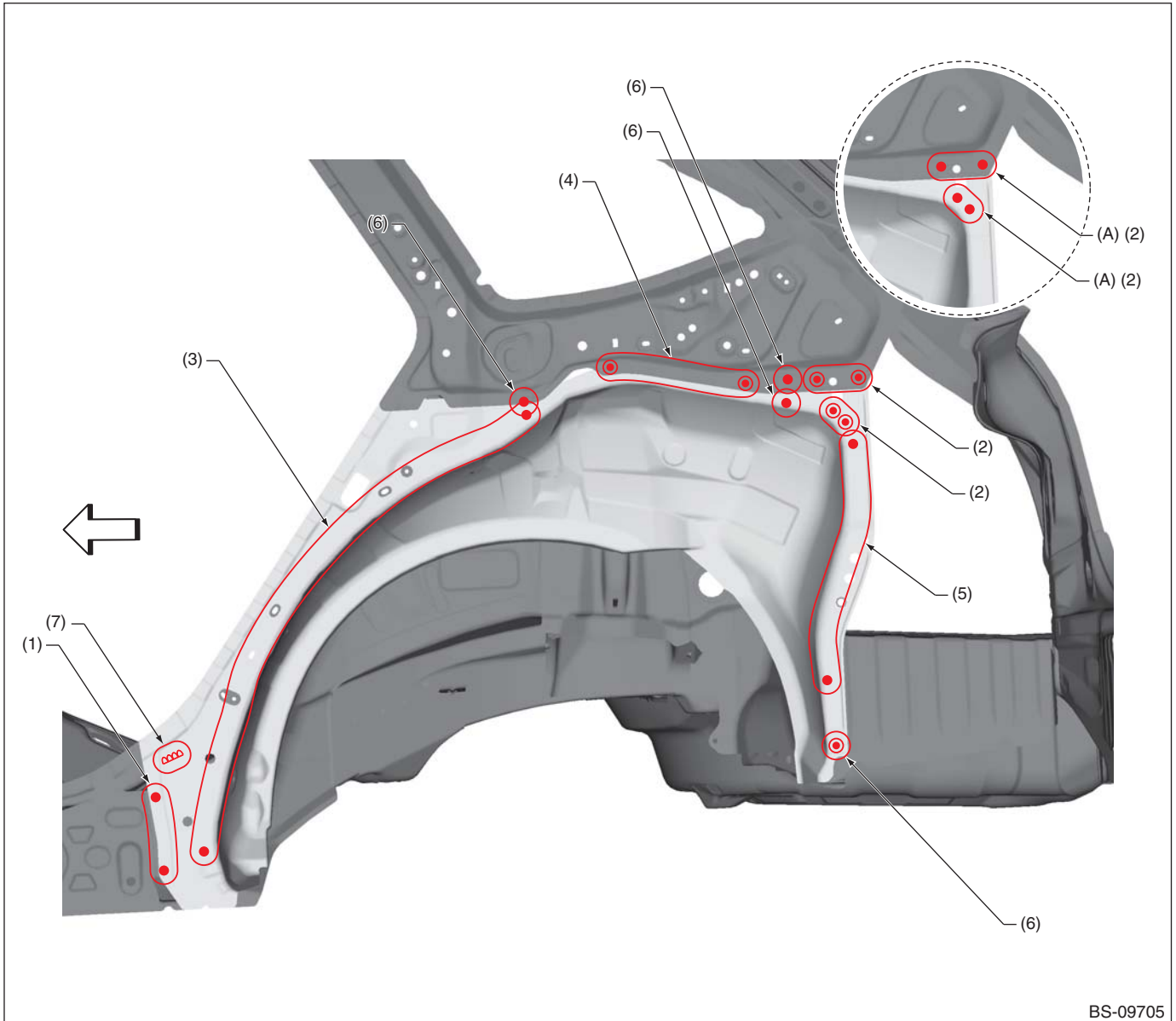


(1) 1 point

(2) 2 points

Panel Replacement

• Overall view 2



(A) Model without power rear gate

(1) 3 points

(2) 2 points

(3) 14 points

(4) 4 points

(5) 8 points

(6) 1 point

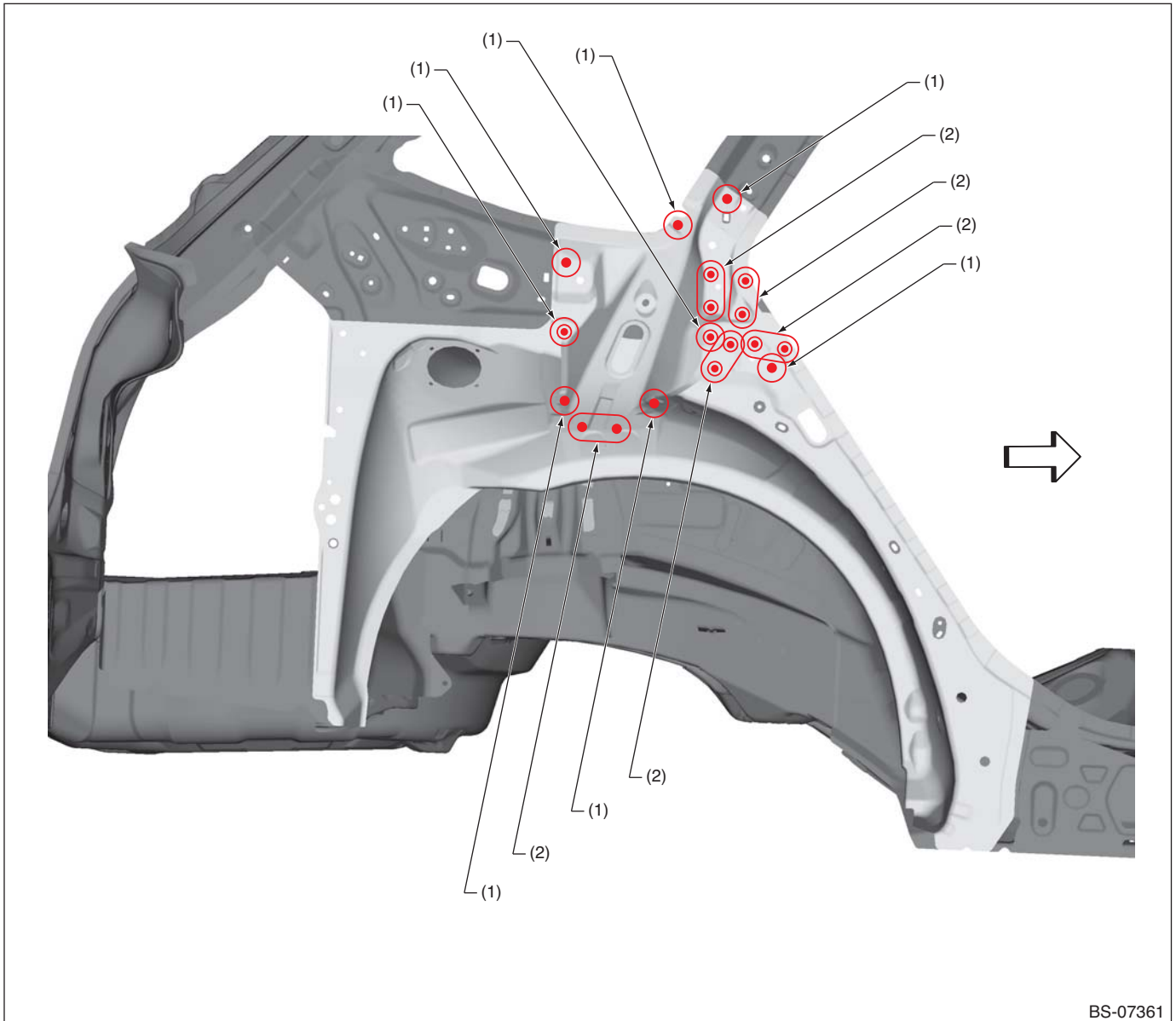
(7) 1 point [30 mm (1.18 in)]

Panel Replacement

8-29. Arch Rear Inner RH (Total replacement)/OUTBACK

A: REMOVAL

- Overall view 1 (Rear quarter outer and side sill reinforcement outer removal condition)

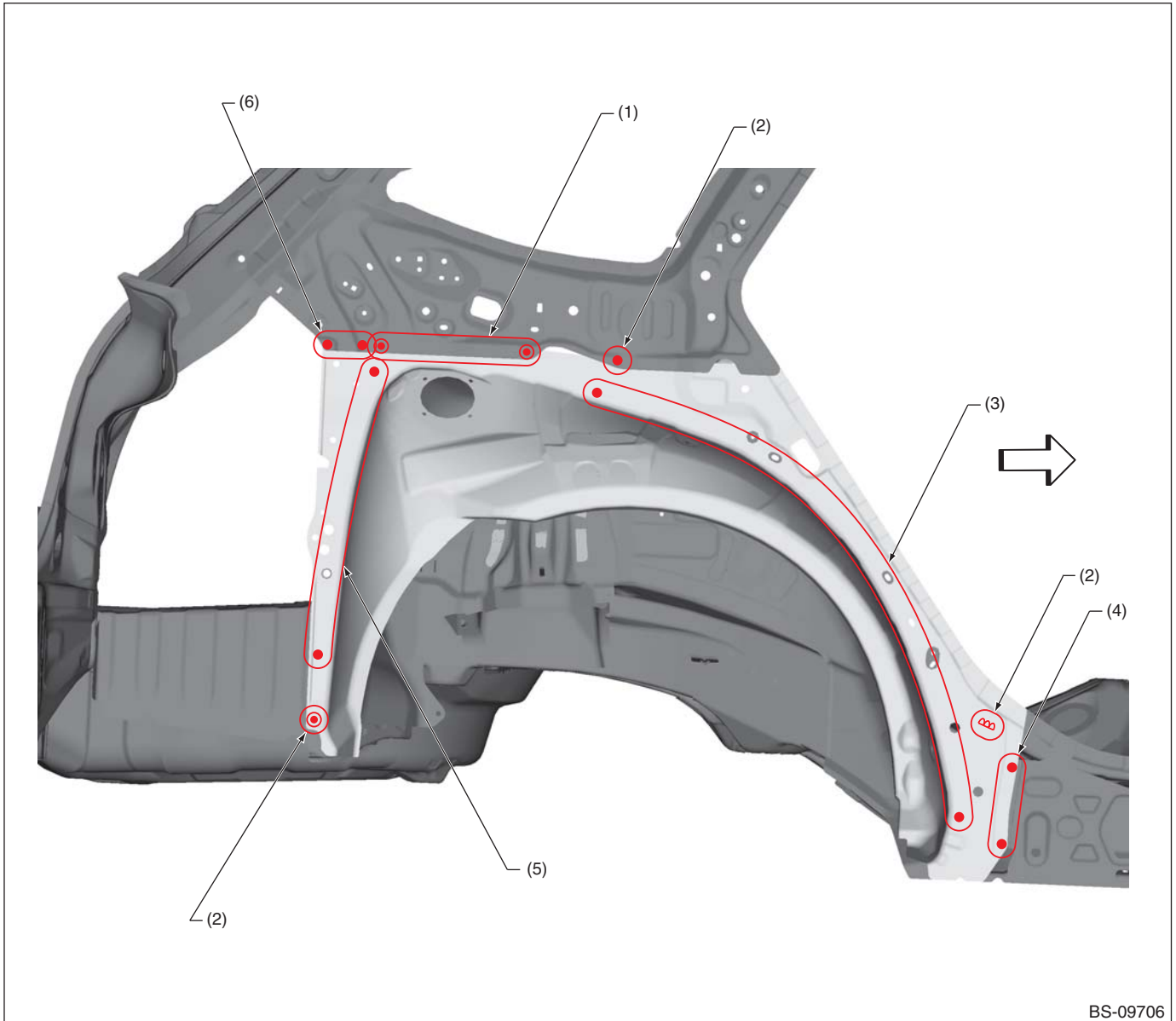


(1) 1 point

(2) 2 points

Panel Replacement

- Overall view 2 (Rear quarter outer and side sill reinforcement outer removal condition)



(1) 5 points
(2) 1 point

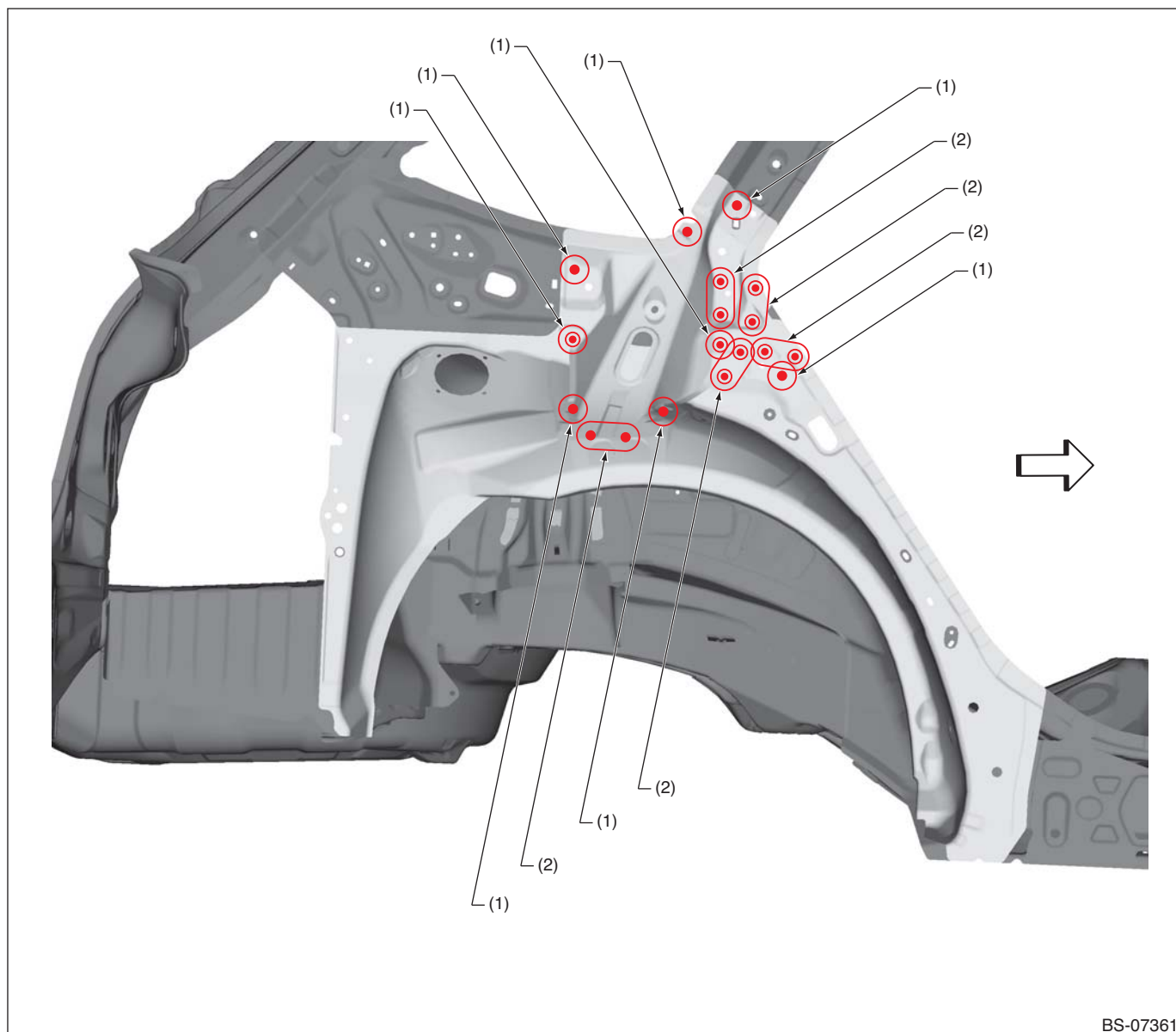
(3) 14 points
(4) 3 points

(5) 7 points
(6) 2 points

Panel Replacement

B: INSTALLATION

• Overall view 1

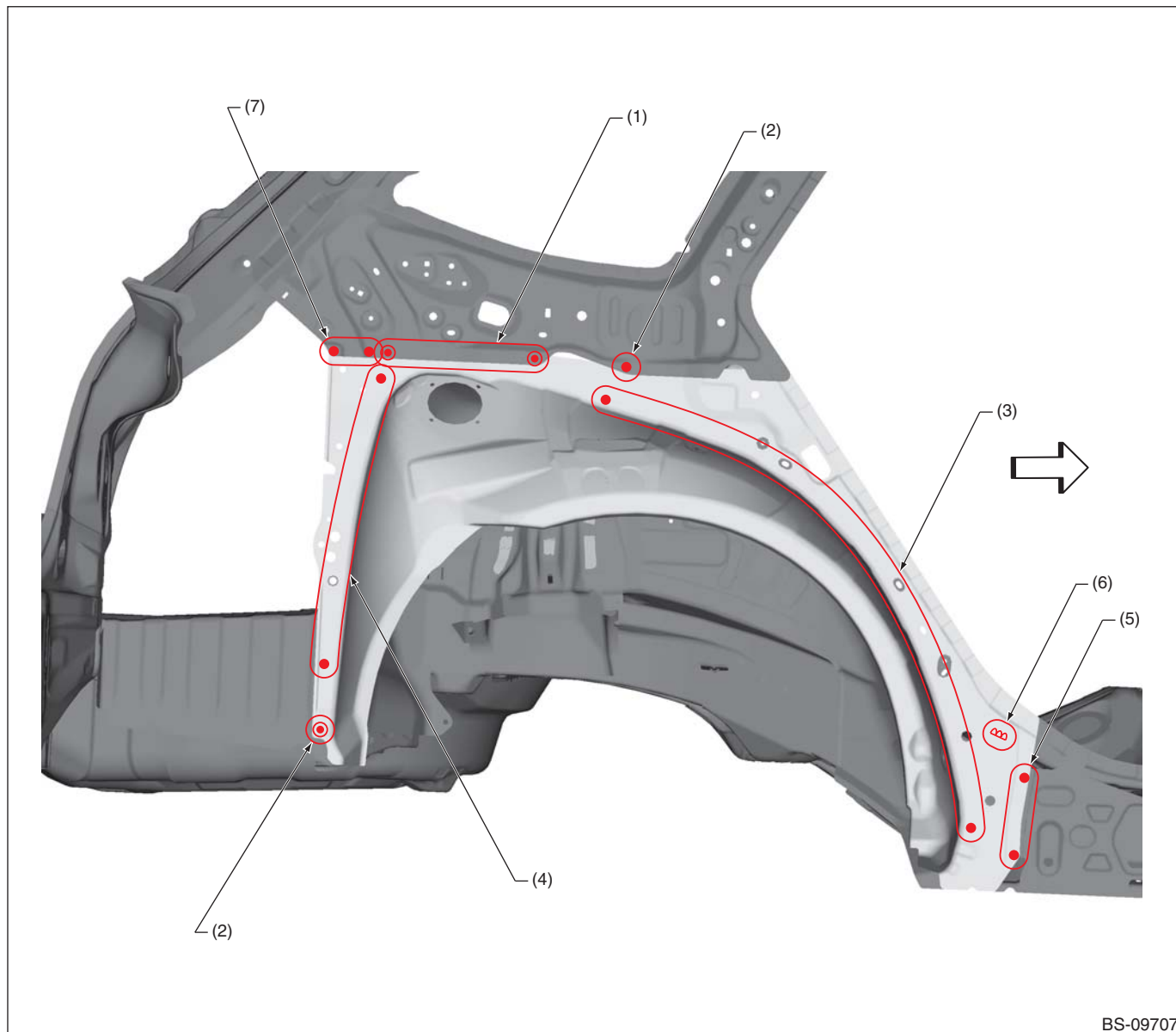


(1) 1 point

(2) 2 points

Panel Replacement

• Overall view 2



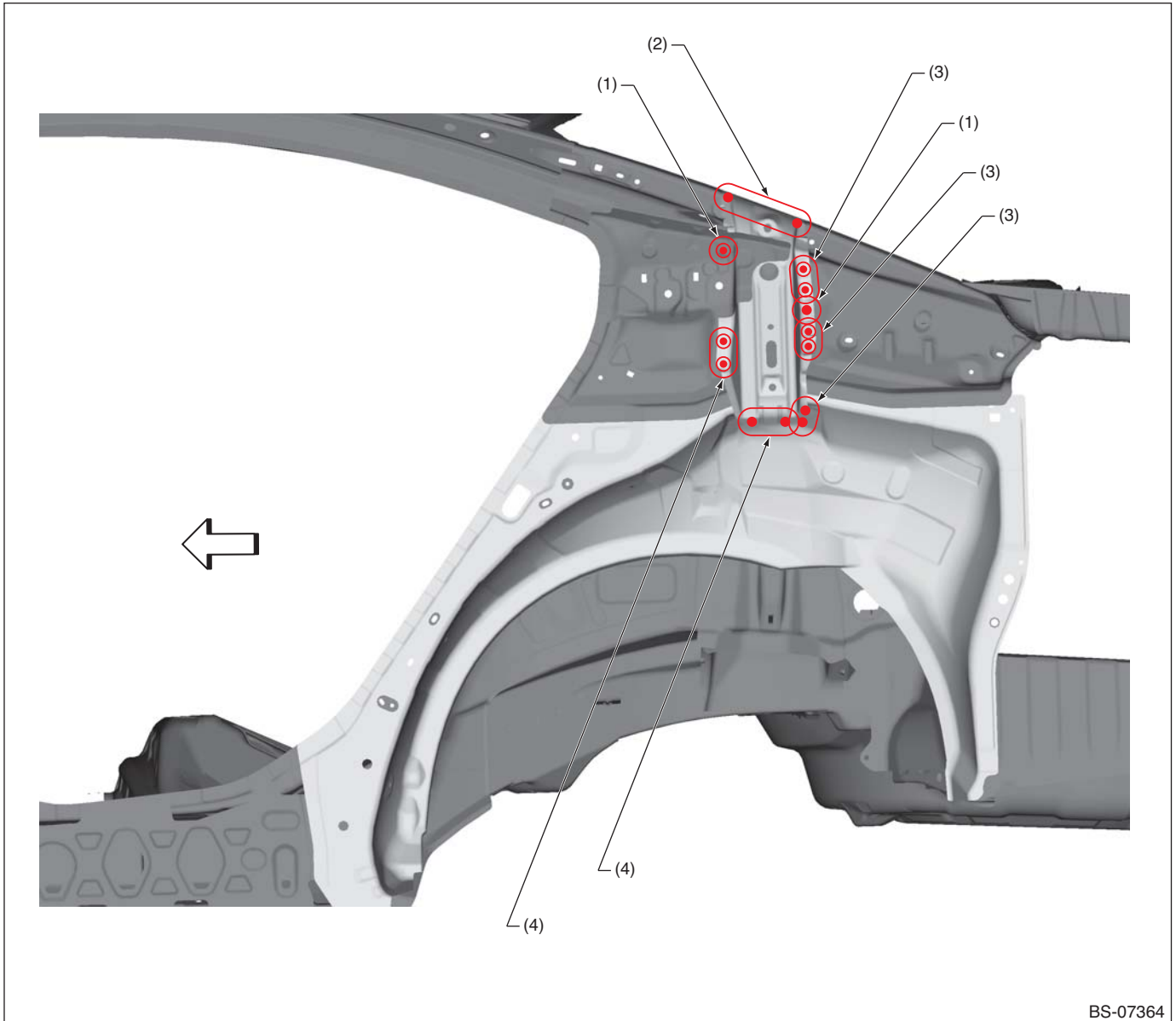
- | | | |
|---------------|-------------------------------|--------------|
| (1) 5 points | (4) 7 points | (7) 2 points |
| (2) 1 point | (5) 3 points | |
| (3) 14 points | (6) 1 point [30 mm (1.18 in)] | |

Panel Replacement

8-30. Arch Rear Inner LH (Total replacement)/SEDAN

A: REMOVAL

- Overall view 1 (Rear quarter outer and side sill reinforcement outer removal condition)



BS-07364

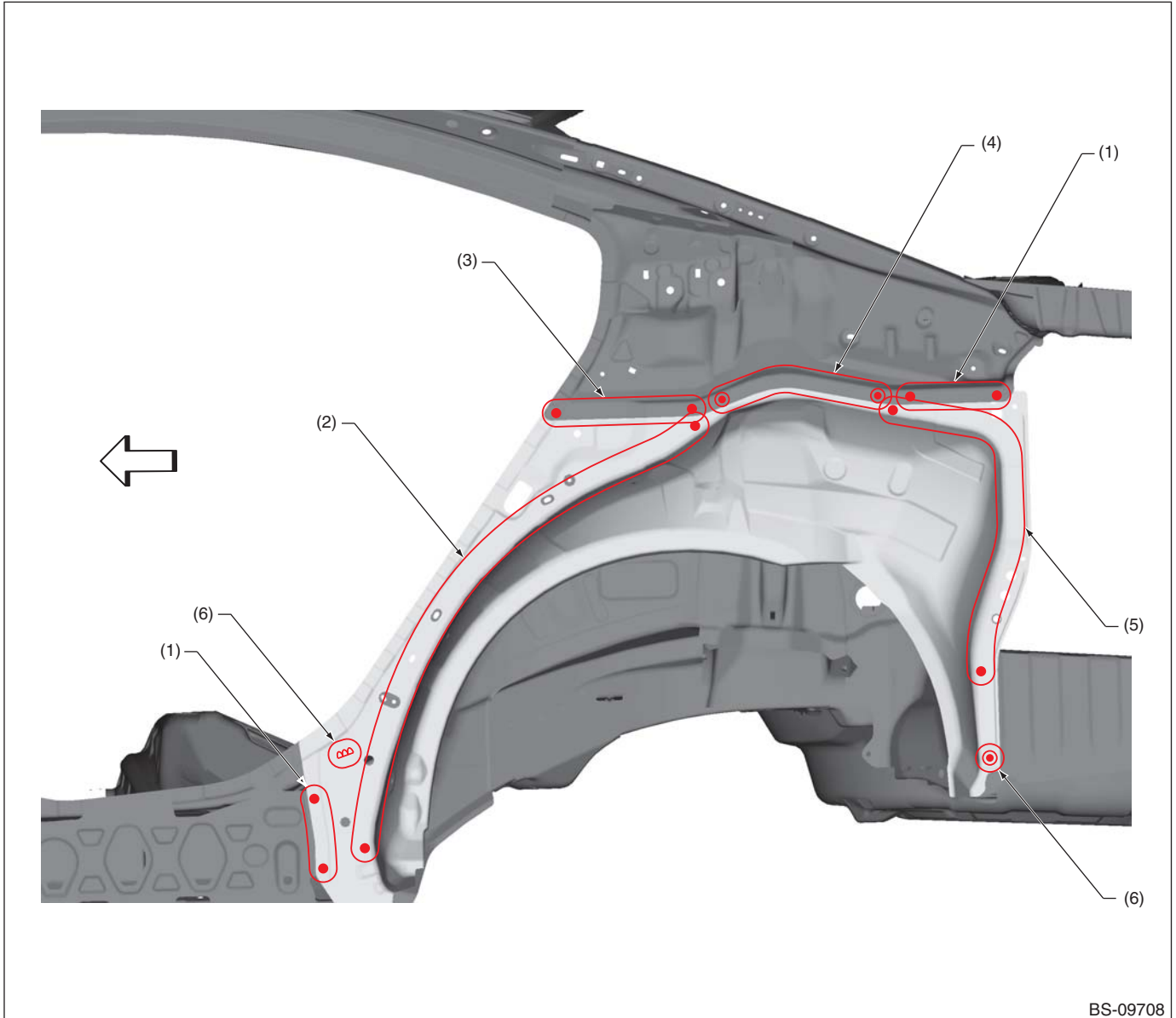
- (1) 1 point
(2) 4 points

- (3) 2 points

- (4) 3 points

Panel Replacement

- Overall view 2 (Rear quarter outer and side sill reinforcement outer removal condition)



(1) 3 points
(2) 15 points

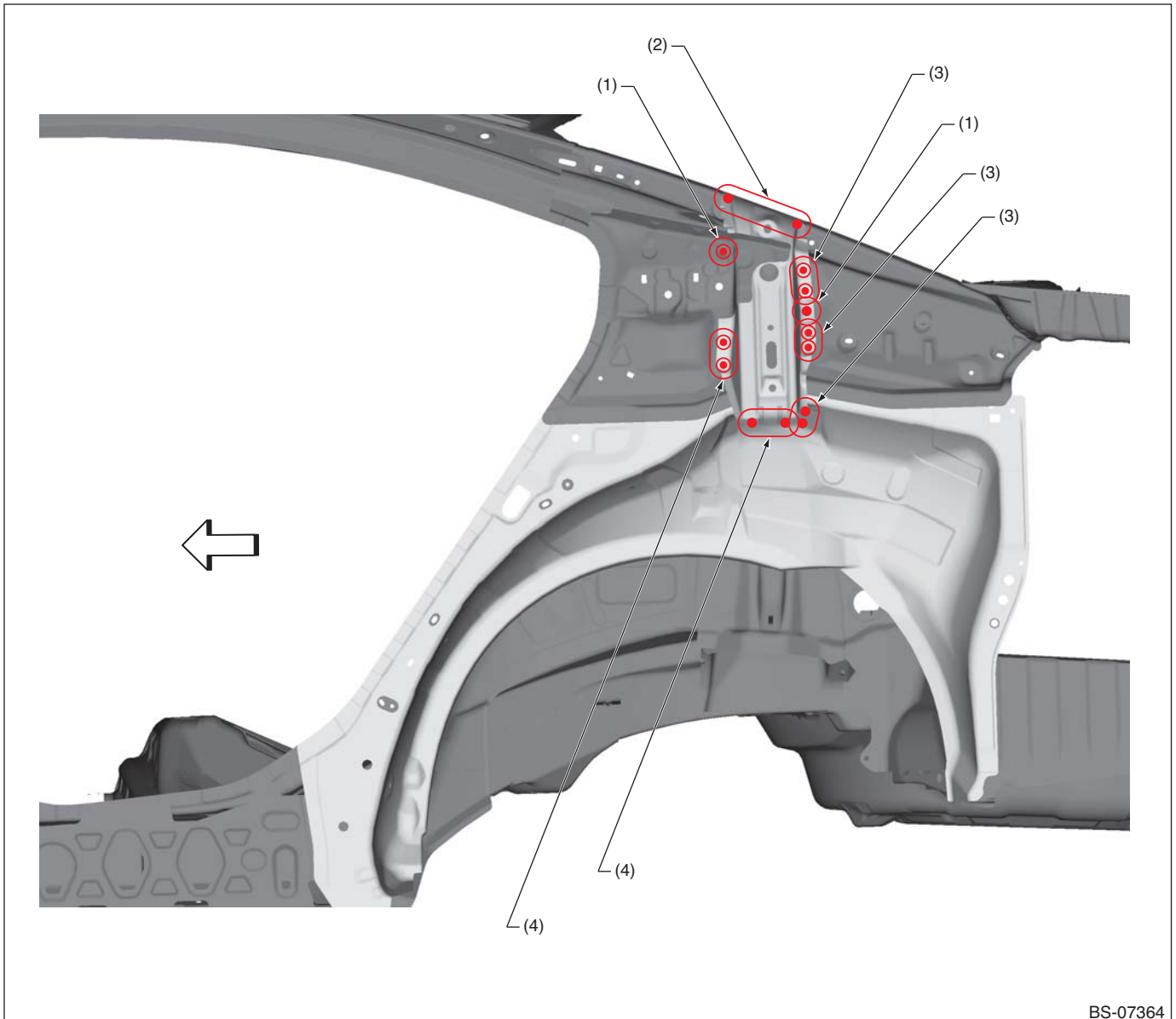
(3) 6 points
(4) 5 points

(5) 11 points
(6) 1 point

Panel Replacement

B: INSTALLATION

• Overall view 1



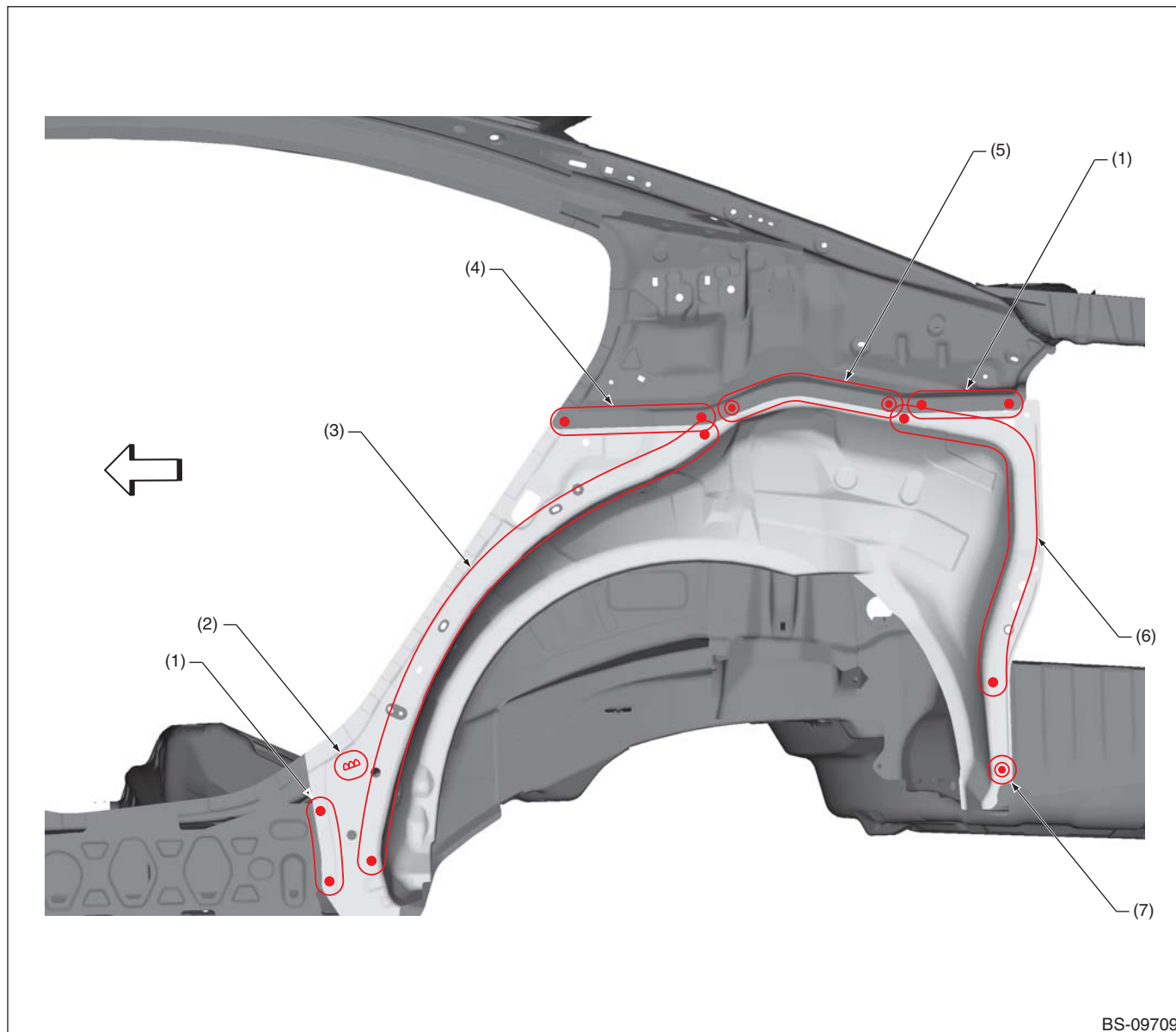
(1) 1 point
(2) 4 points

(3) 2 points

(4) 3 points

Panel Replacement

• Overall view 2



- (1) 3 points
- (2) 1 point [30 mm (1.18 in)]
- (3) 15 points

- (4) 6 points
- (5) 5 points
- (6) 11 points

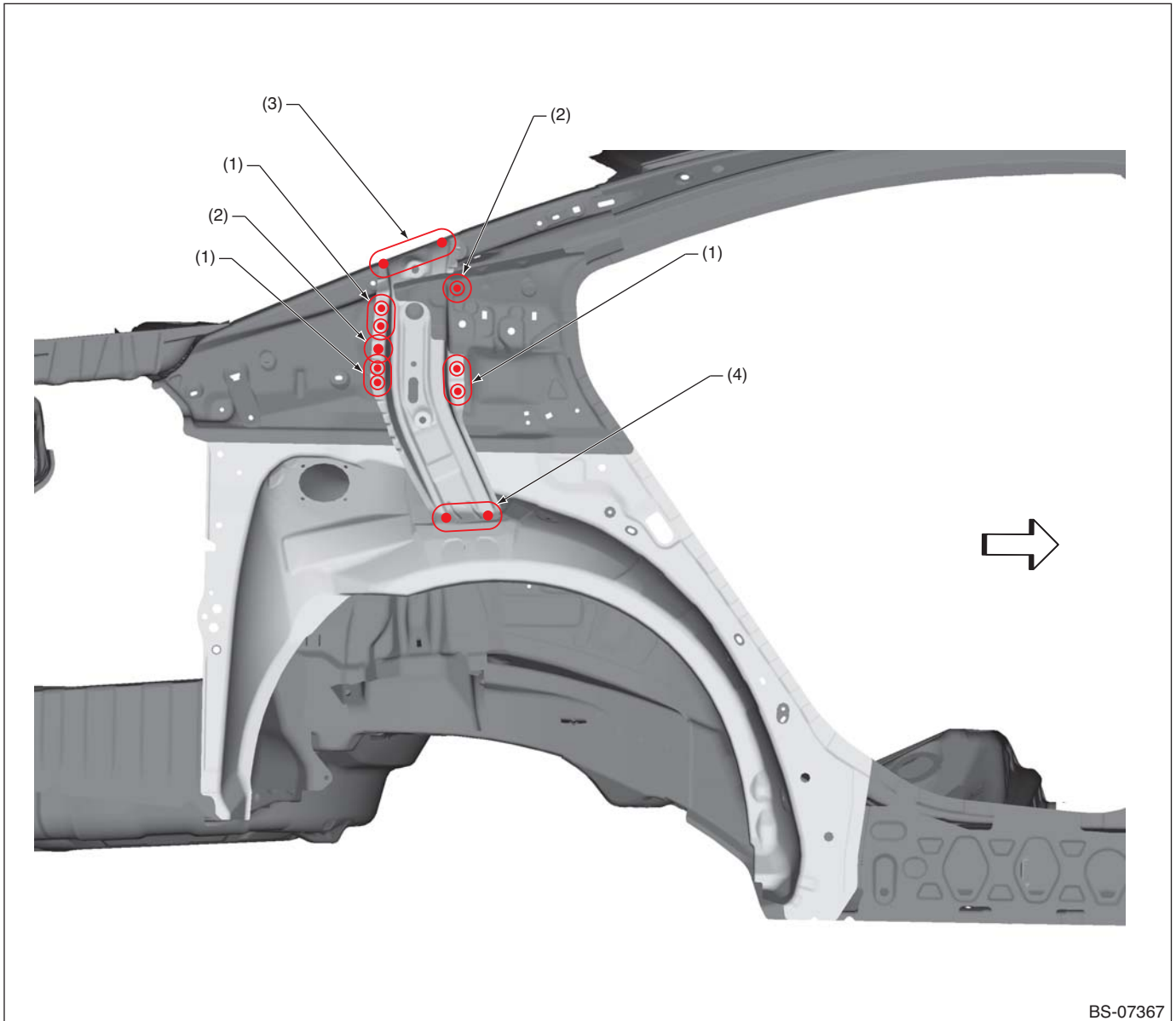
- (7) 1 point

Panel Replacement

8-31. Arch Rear Inner RH (Total replacement)/SEDAN

A: REMOVAL

- Overall view 1 (Rear quarter outer and side sill reinforcement outer removal condition)



BS-07367

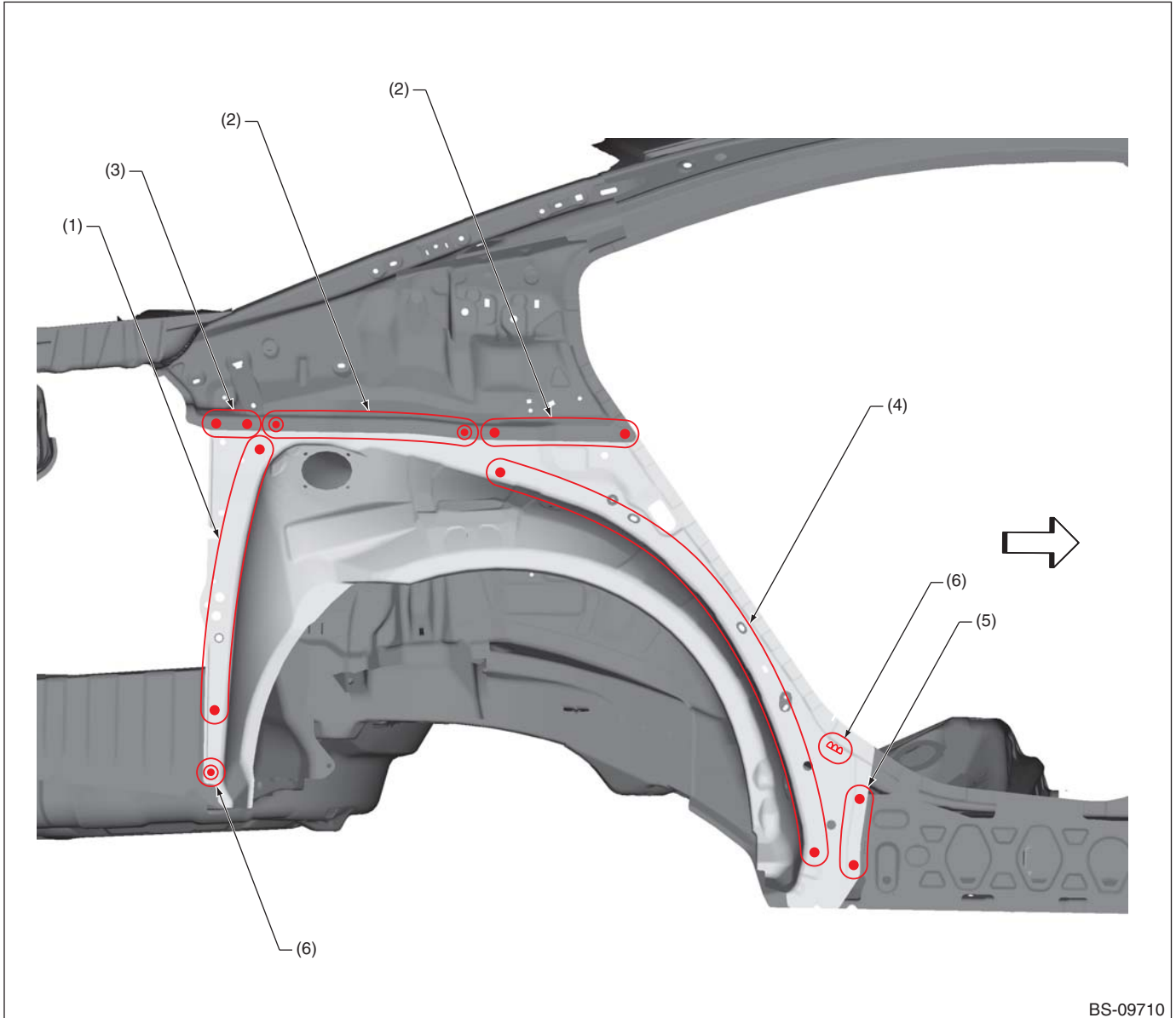
(1) 2 points
(2) 1 point

(3) 4 points

(4) 3 points

Panel Replacement

- Overall view 2 (Rear quarter outer and side sill reinforcement outer removal condition)



(1) 7 points
(2) 6 points

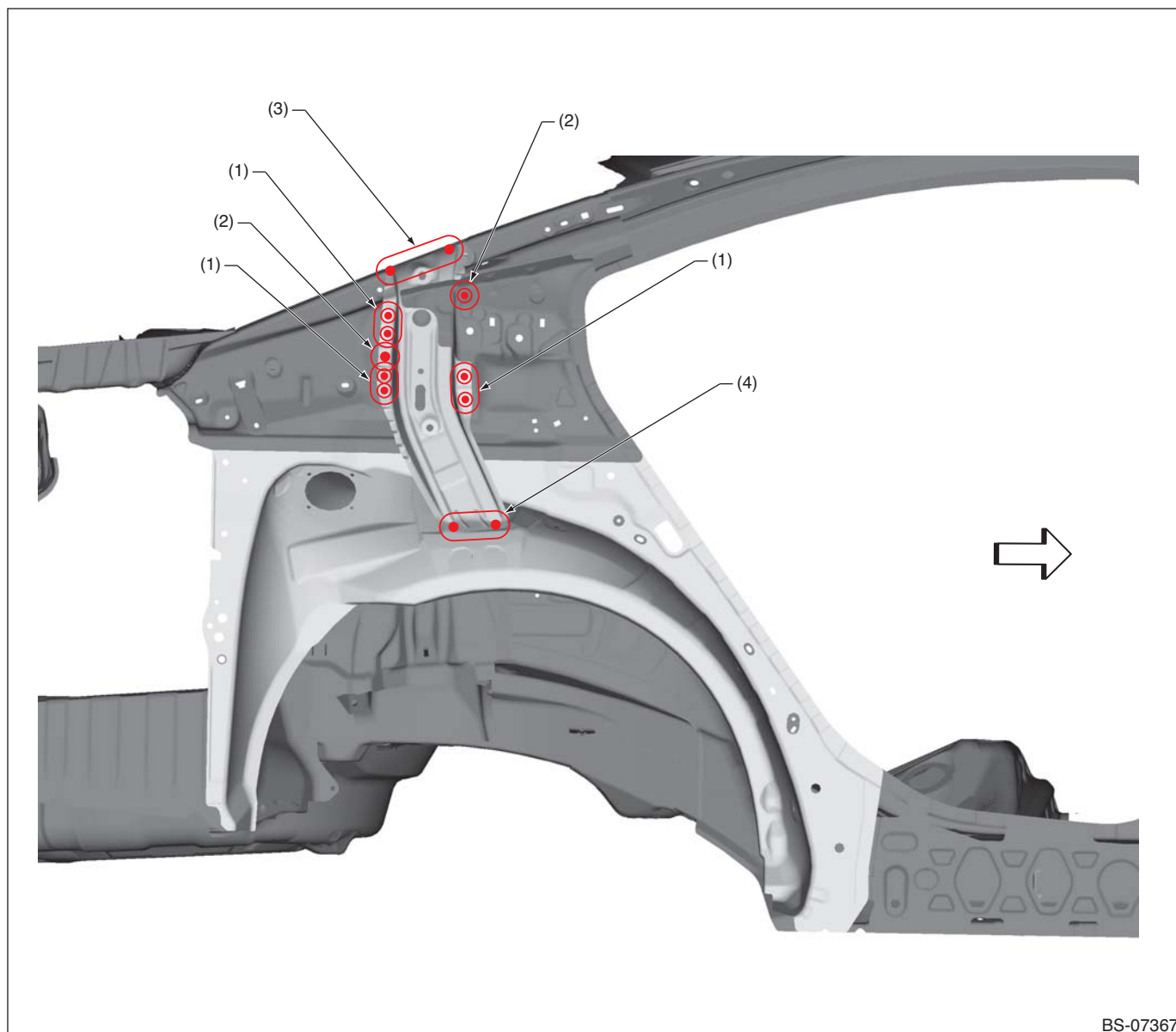
(3) 2 points
(4) 15 points

(5) 3 points
(6) 1 point

Panel Replacement

B: INSTALLATION

• Overall view 1



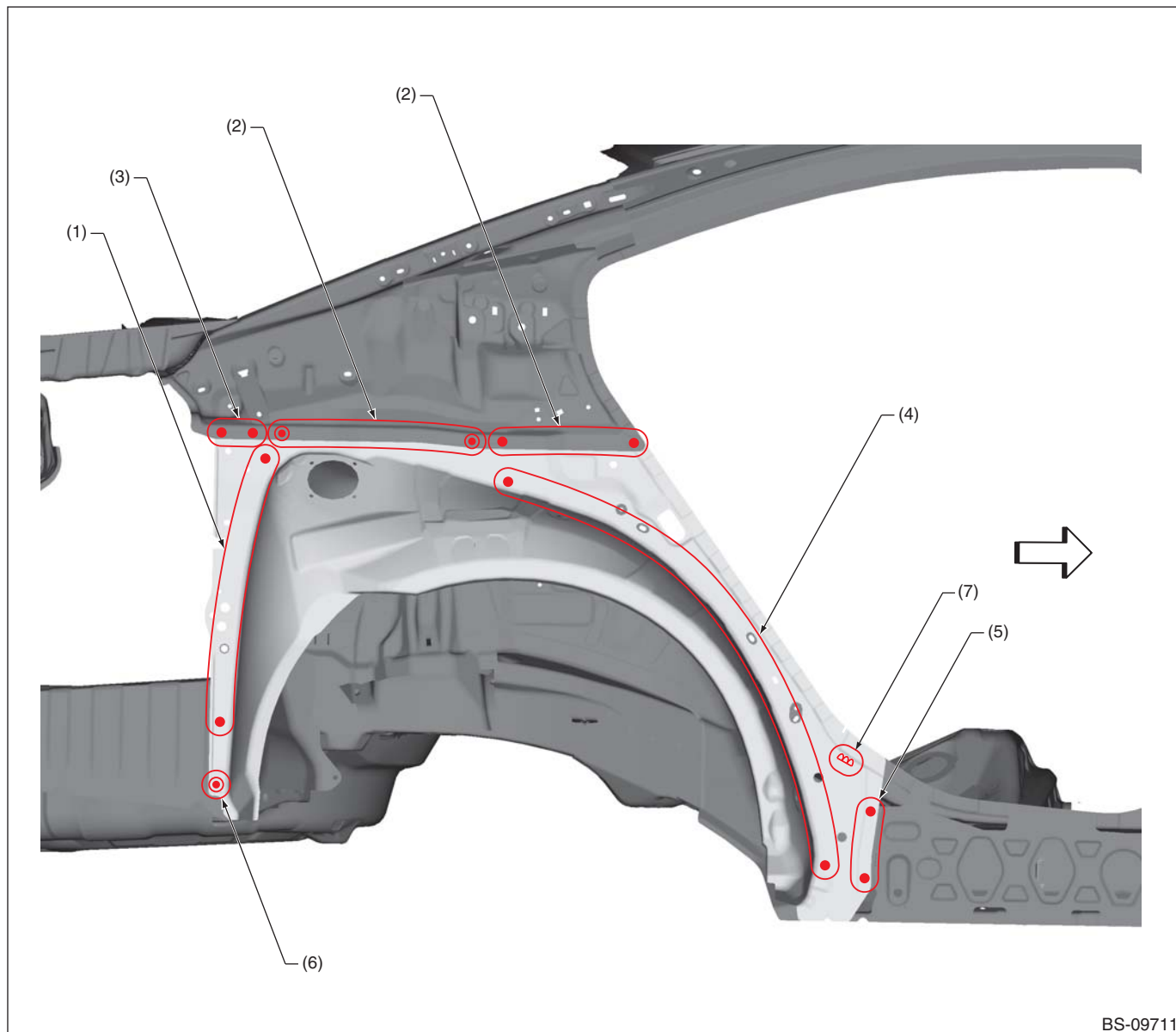
(1) 2 points
(2) 1 point

(3) 4 points

(4) 3 points

Panel Replacement

• Overall view 2



BS-09711

- (1) 7 points
- (2) 6 points
- (3) 2 points

- (4) 15 points
- (5) 3 points
- (6) 1 point

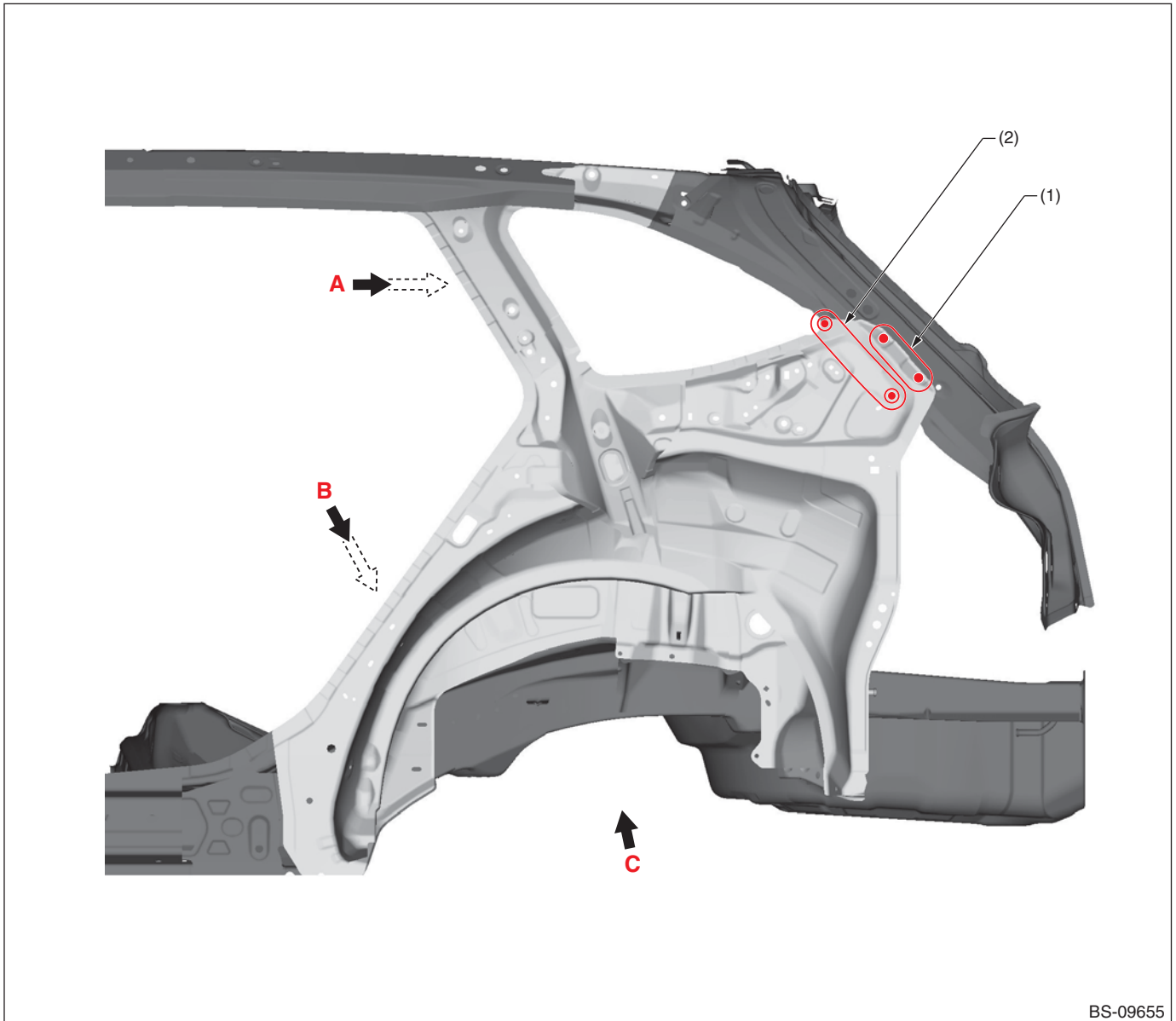
- (7) 1 point [30 mm (1.18 in)]

Panel Replacement

8-32. Rear Quarter Inner (Partial replacement)/OUTBACK

A: REMOVAL

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

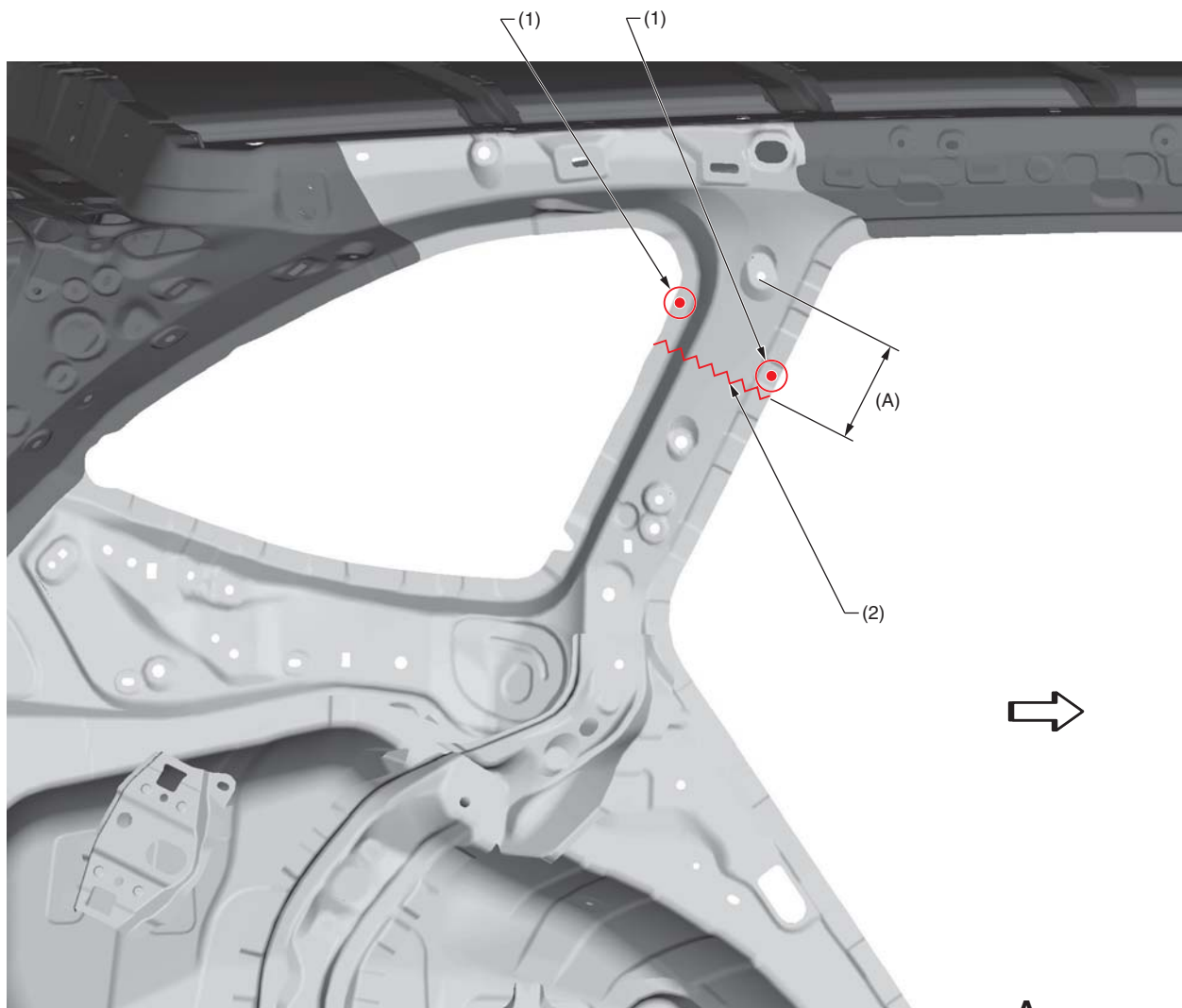


(1) 3 points

(2) 4 points

Panel Replacement

- View A



BS-09656

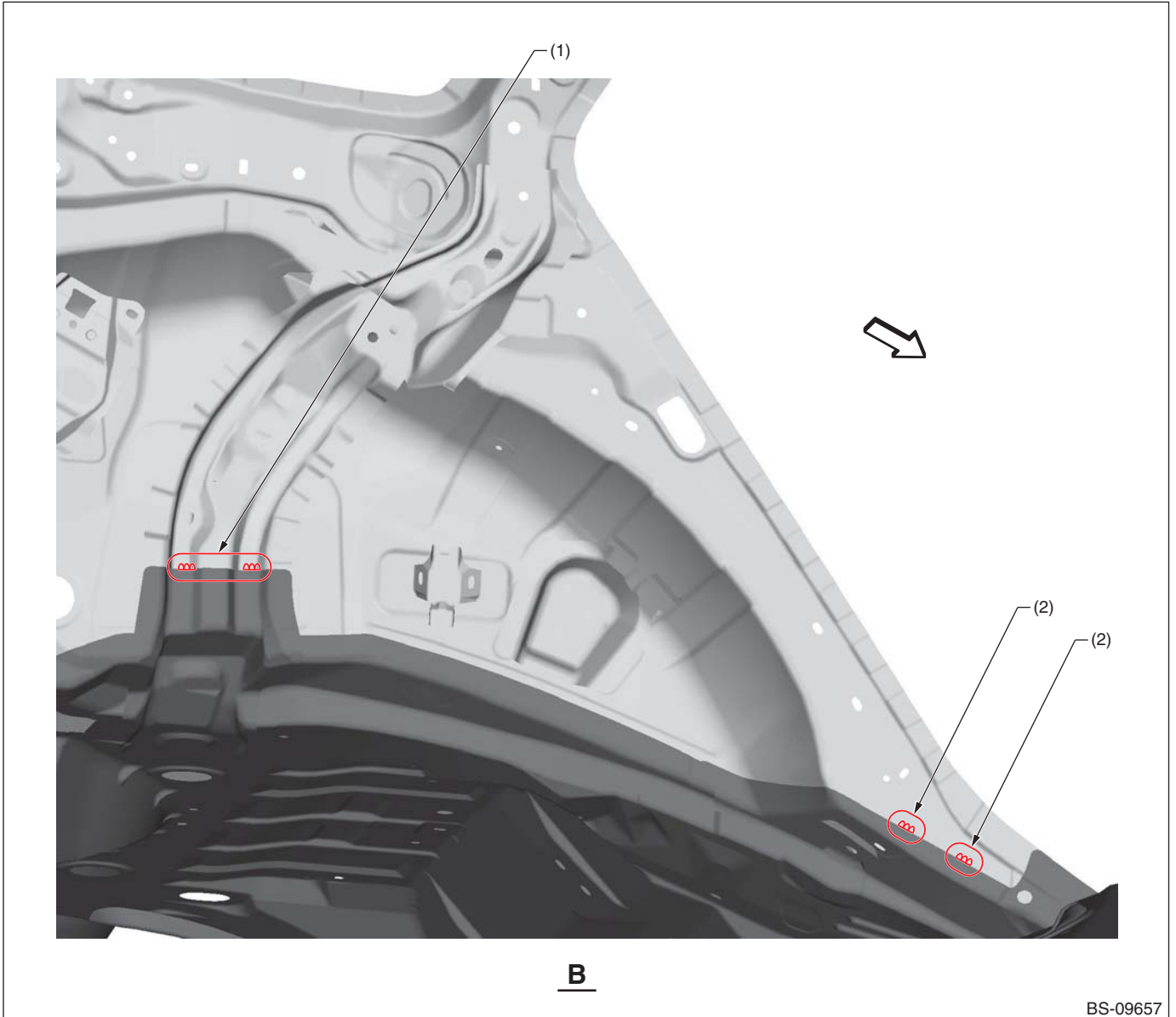
(A) 100 mm (3.94 in)

(1) 1 point

(2) Cut position

Panel Replacement

- View B

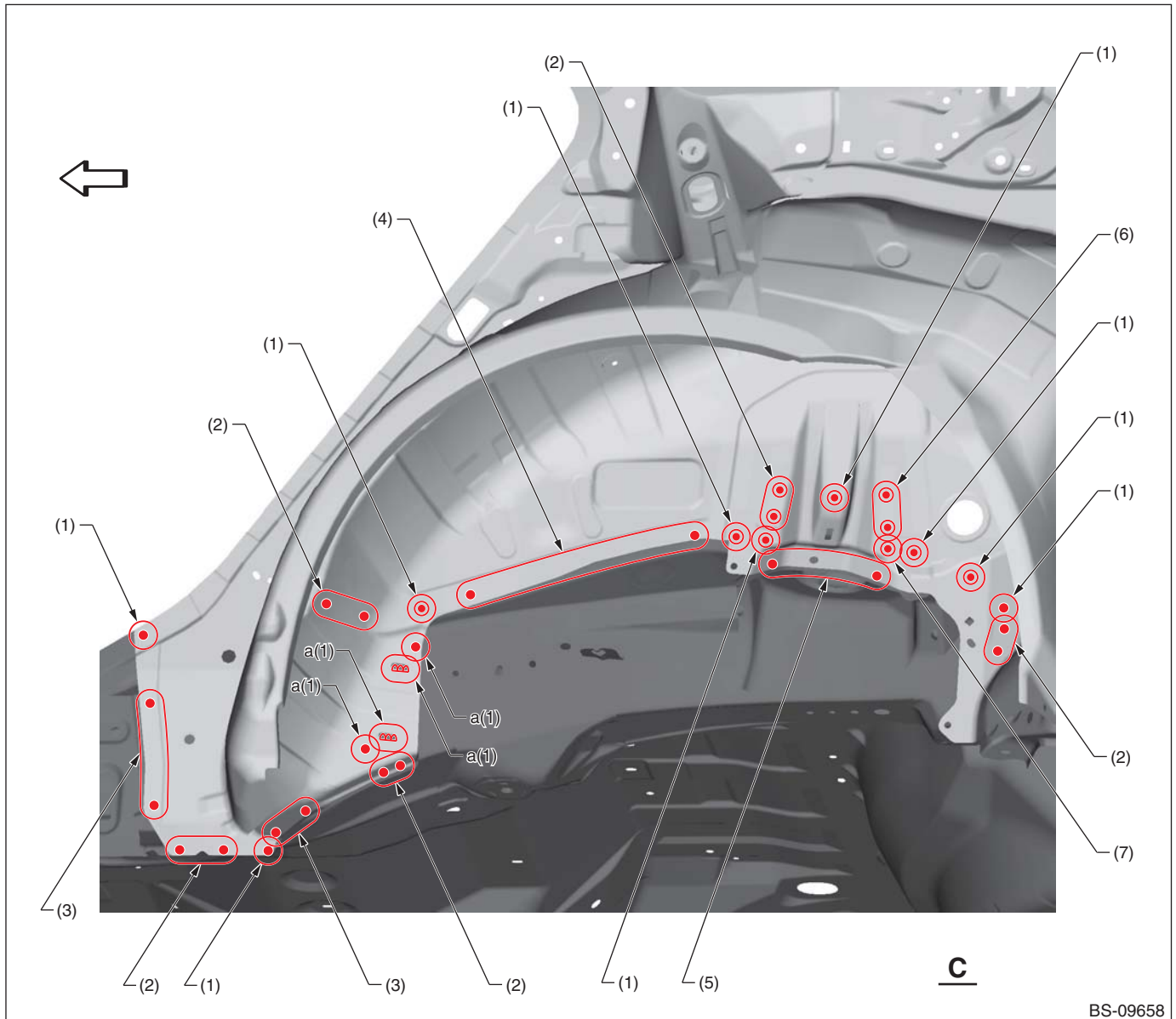


(1) 2 points

(2) 1 point

Panel Replacement

• View C



BS-09658

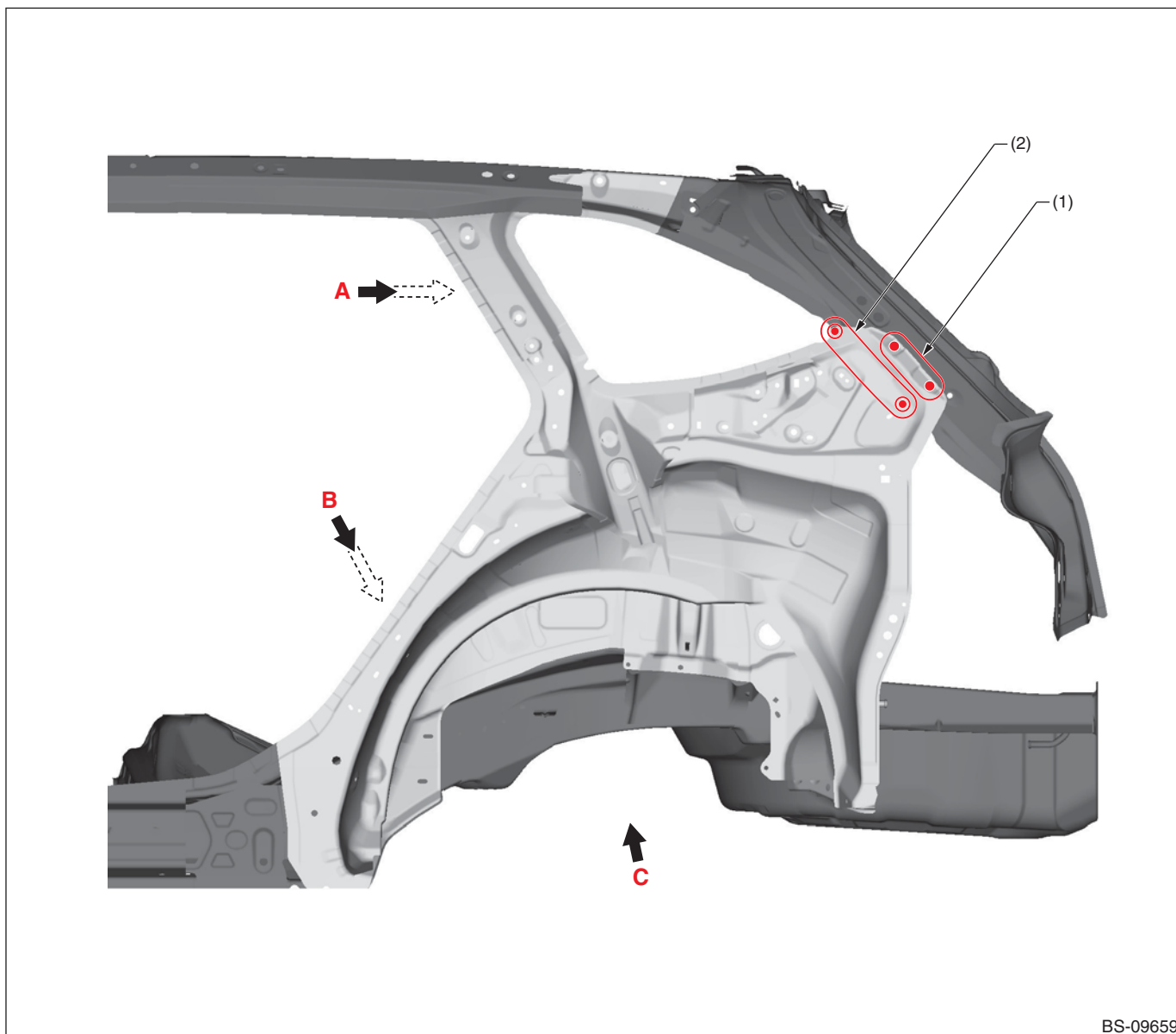
- | | | |
|--------------|----------------------------------|-----------------------|
| (1) 1 point | (4) 5 points | (7) 1 point (Only LH) |
| (2) 2 points | (5) 6 points | |
| (3) 3 points | (6) LH: 2 points
RH: 3 points | |

Note: Depending on the vehicle, different methods are used to weld Part "a" (spot welding or arc welding).

Panel Replacement

B: INSTALLATION

- Overall view

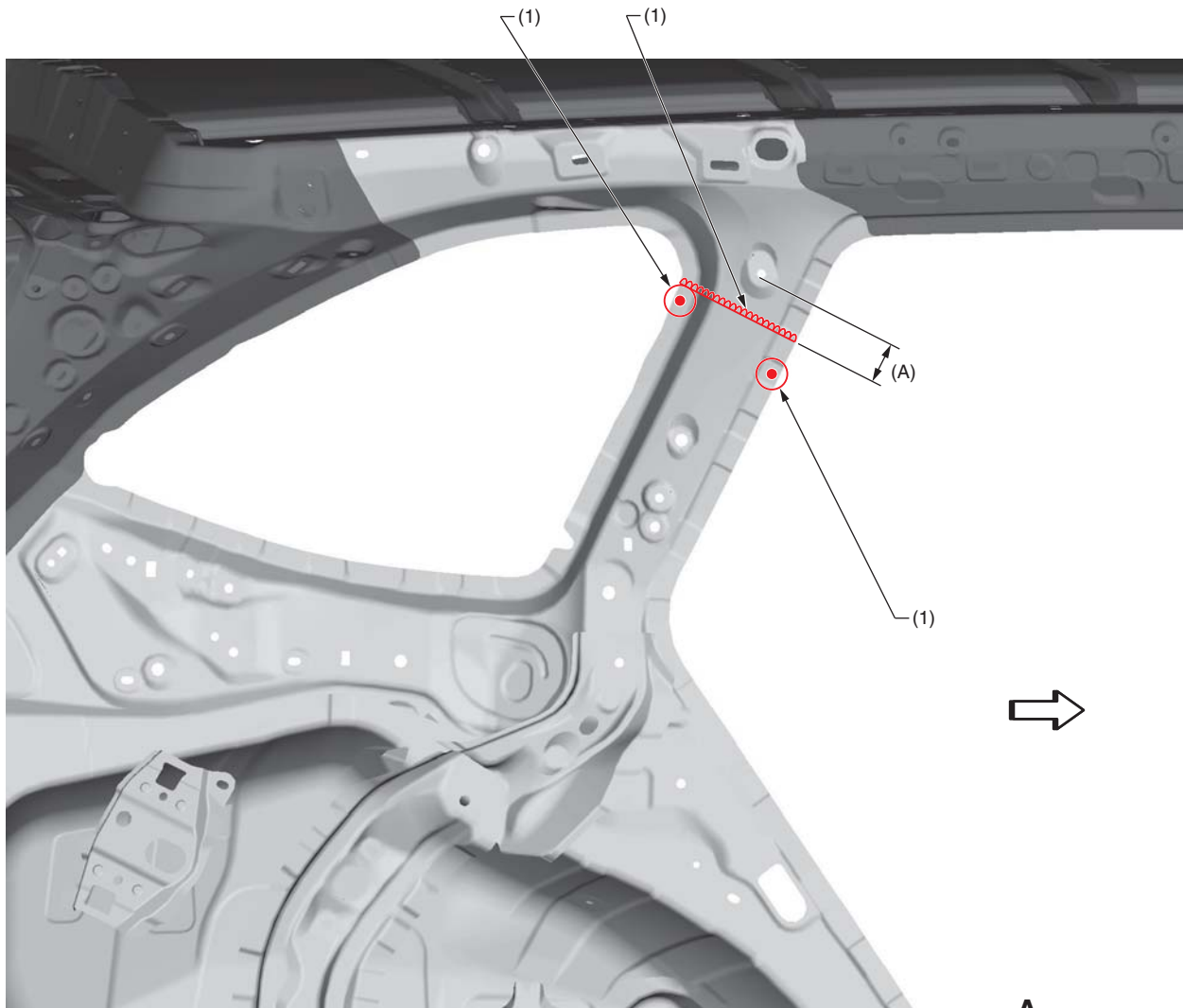


(1) 3 points

(2) 4 points

Panel Replacement

- View A



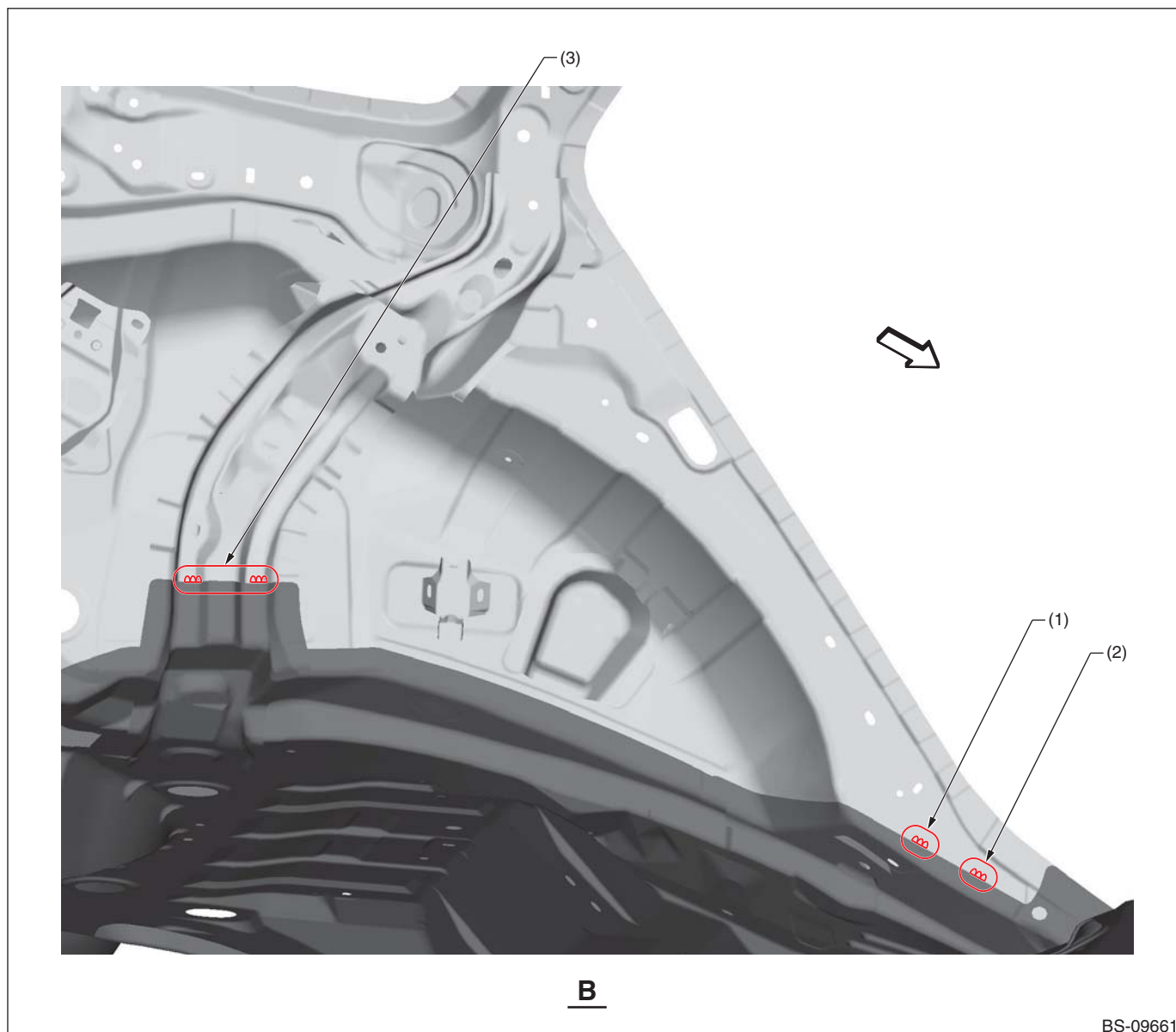
BS-09660

(A) 60 mm (2.36 in)

(1) 1 point

Panel Replacement

- View B



BS-09661

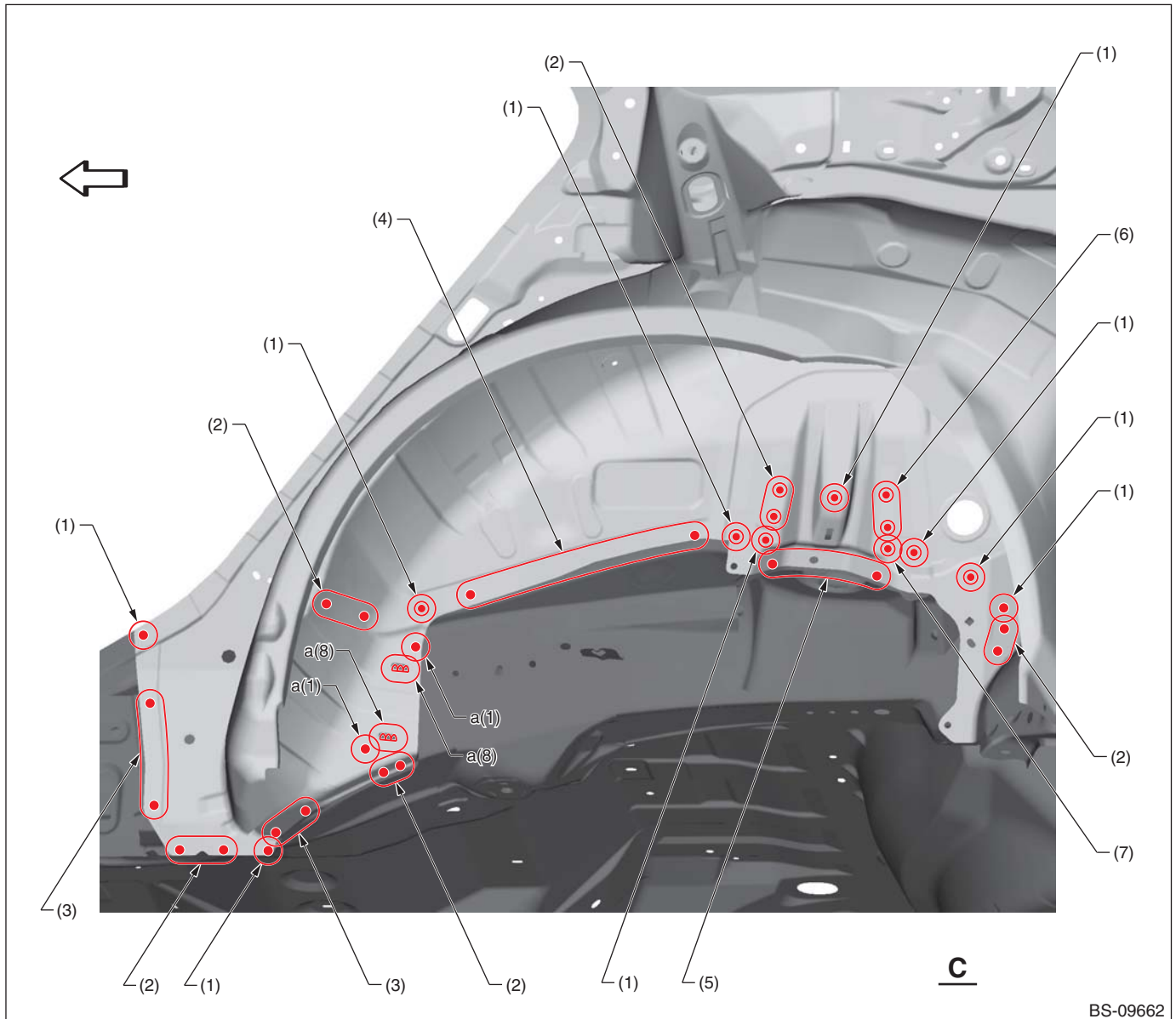
(1) 1 point [22 mm (0.87 in)]

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

(3) 2 points [15 mm (0.59 in)]

Panel Replacement

• View C



BS-09662

- | | | |
|--------------|----------------------------------|-------------------------------|
| (1) 1 point | (4) 5 points | (7) 1 point (Only LH) |
| (2) 2 points | (5) 6 points | (8) 1 point [20 mm (0.79 in)] |
| (3) 3 points | (6) LH: 2 points
RH: 3 points | |

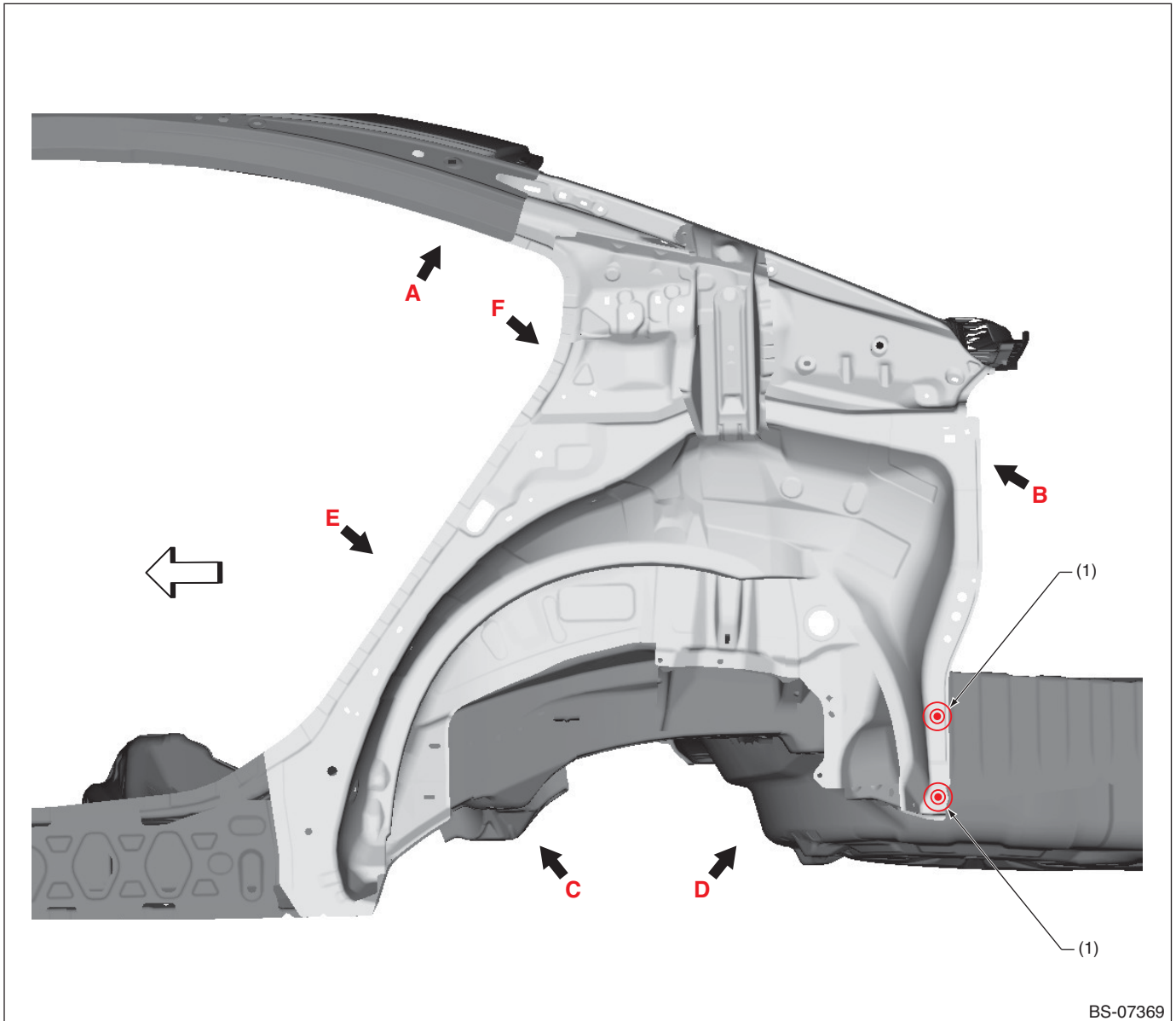
Note: Depending on the vehicle, different methods are used to weld Part "a" (spot welding or arc welding).

Panel Replacement

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

A: REMOVAL

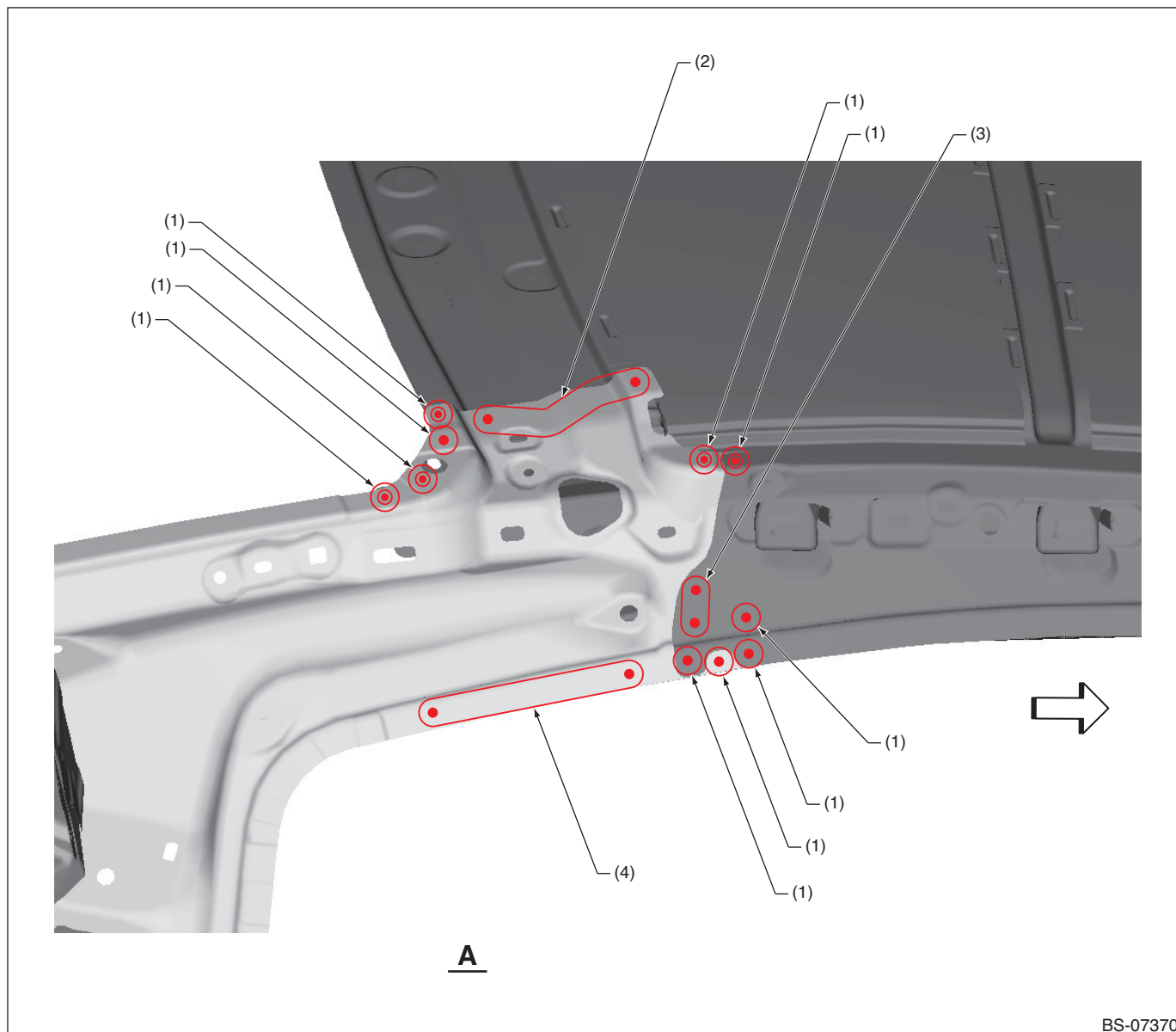
- Overall view (Rear quarter outer and side sill reinforcement outer removal condition)



(1) 1 point

Panel Replacement

- View A



BS-07370

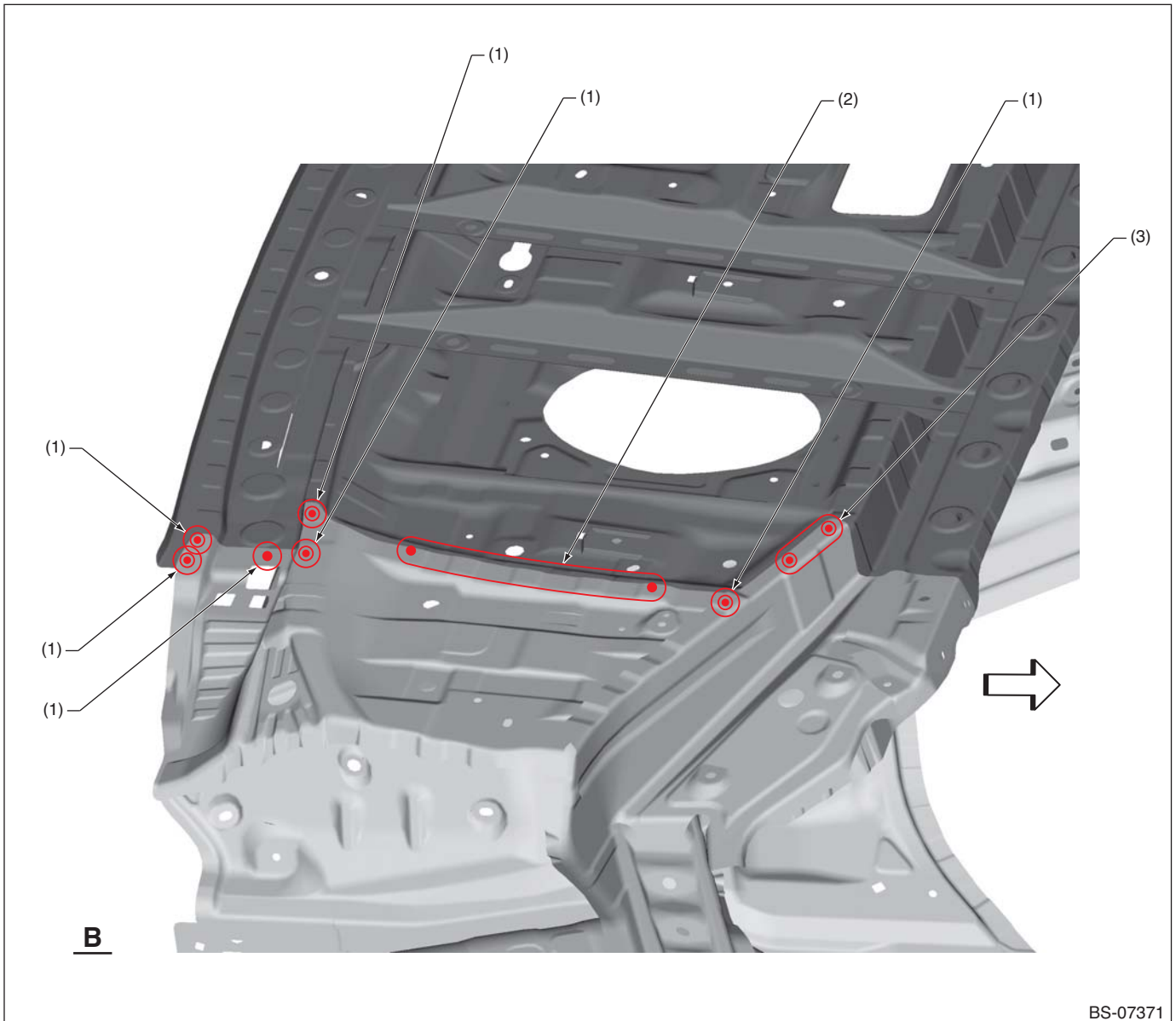
(1) 1 point
(2) 4 points

(3) 2 points

(4) 3 points

Panel Replacement

- View B



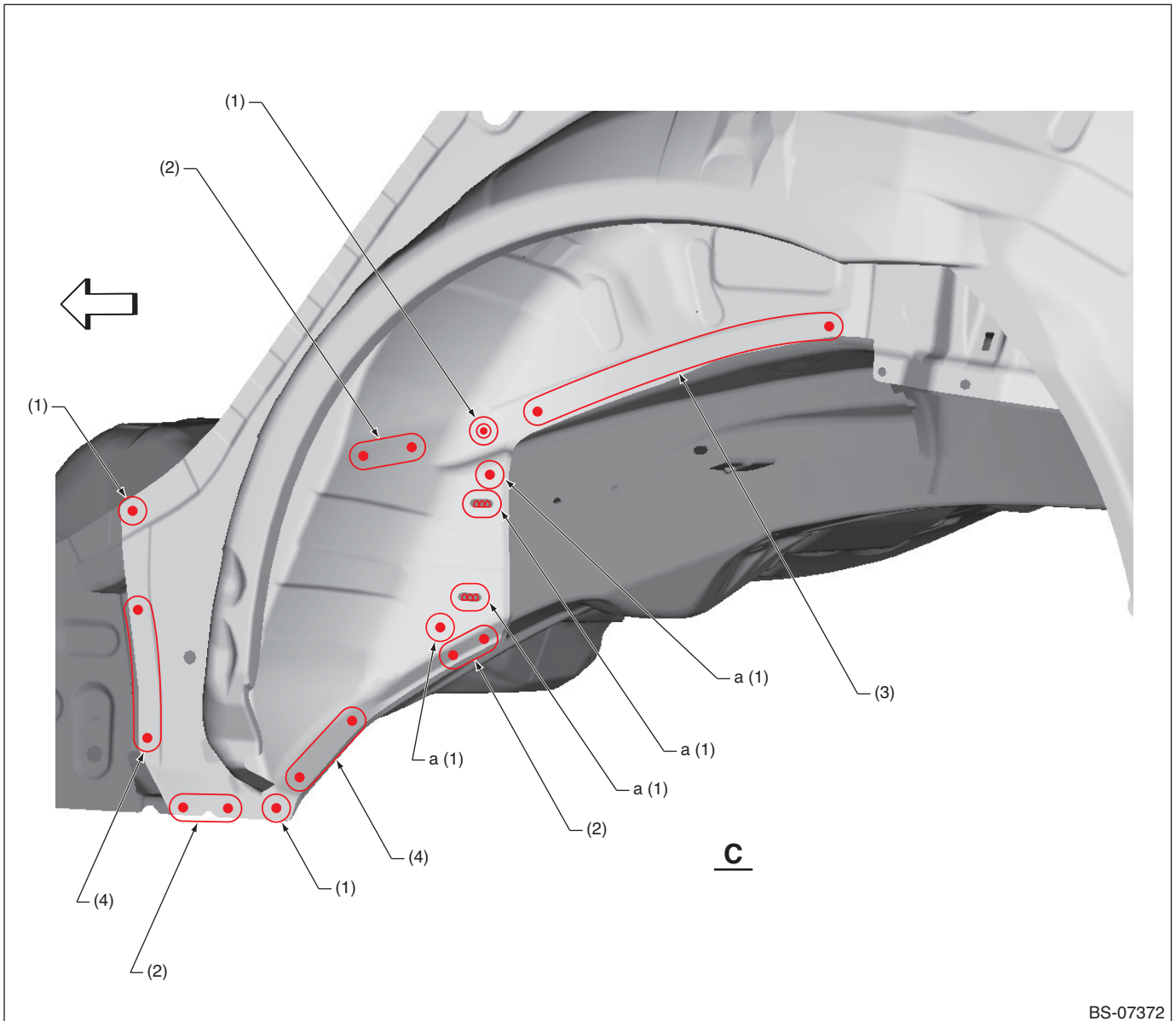
(1) 1 point

(2) 5 points

(3) 3 points

Panel Replacement

• View C



BS-07372

(1) 1 point
(2) 2 points

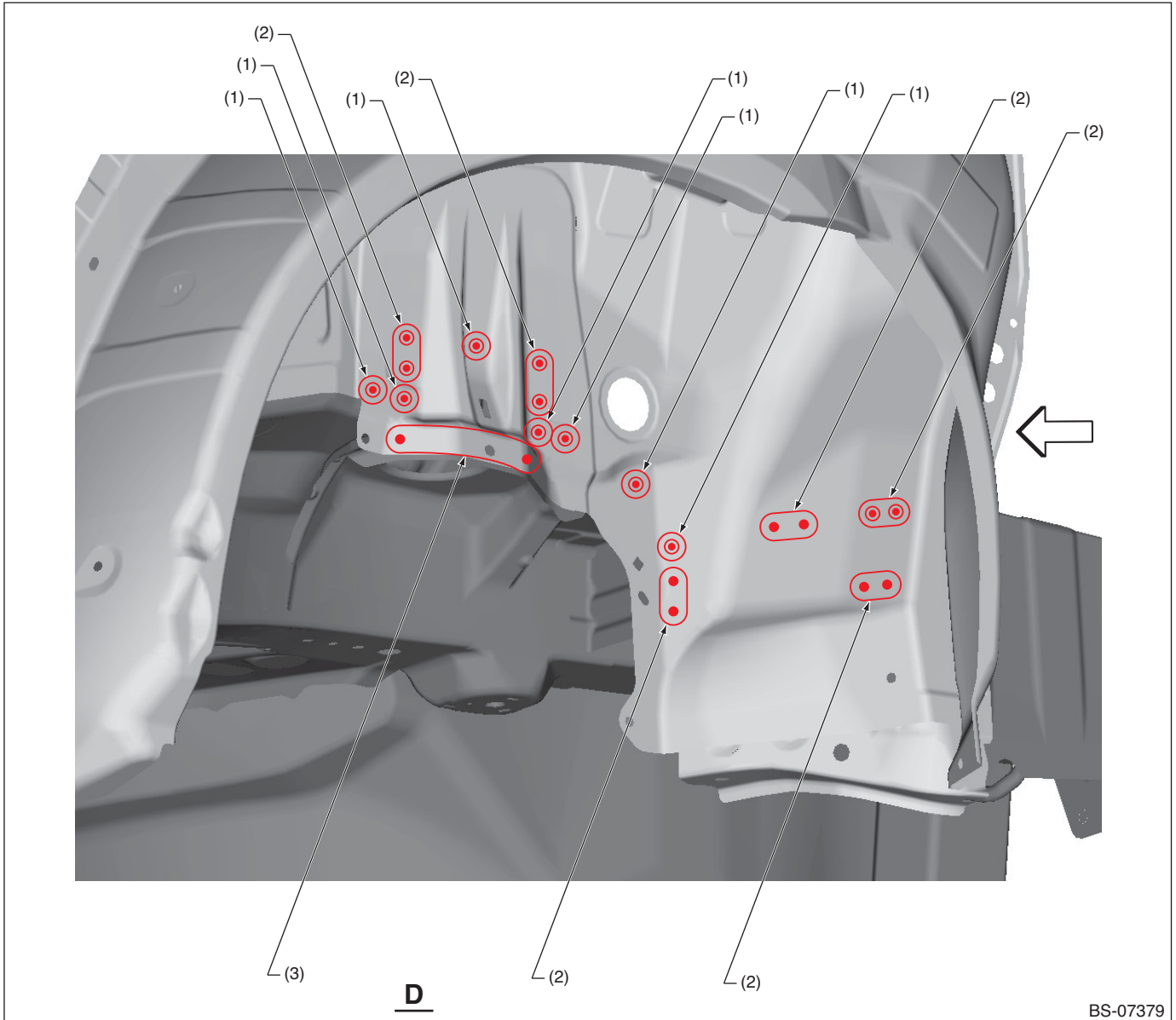
(3) 5 points

(4) 3 points

Note: Part "a" may or may not have welding points, depending on the vehicle model.

Panel Replacement

- View D



BS-07379

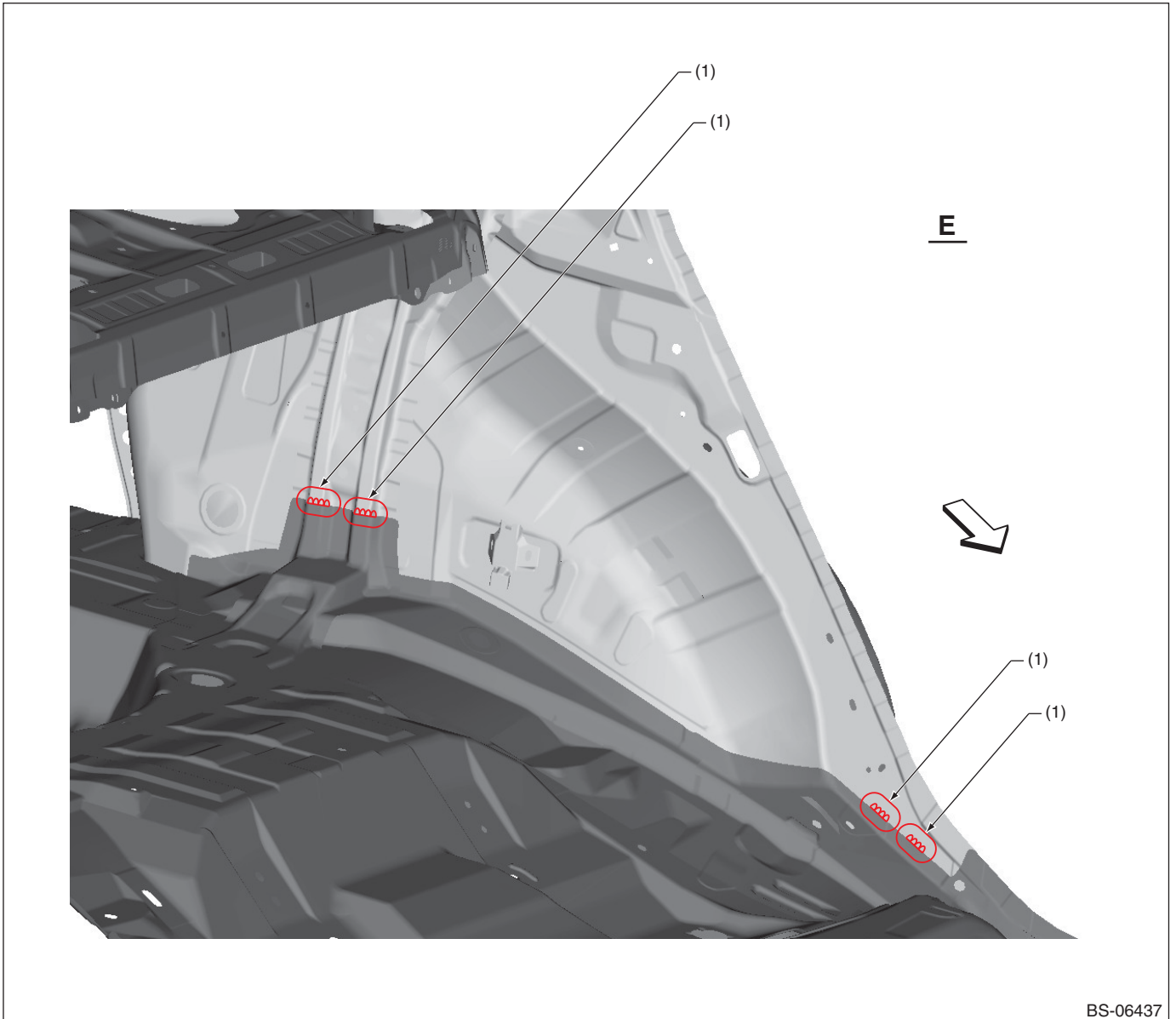
(1) 1 point

(2) 2 points

(3) 6 points

Panel Replacement

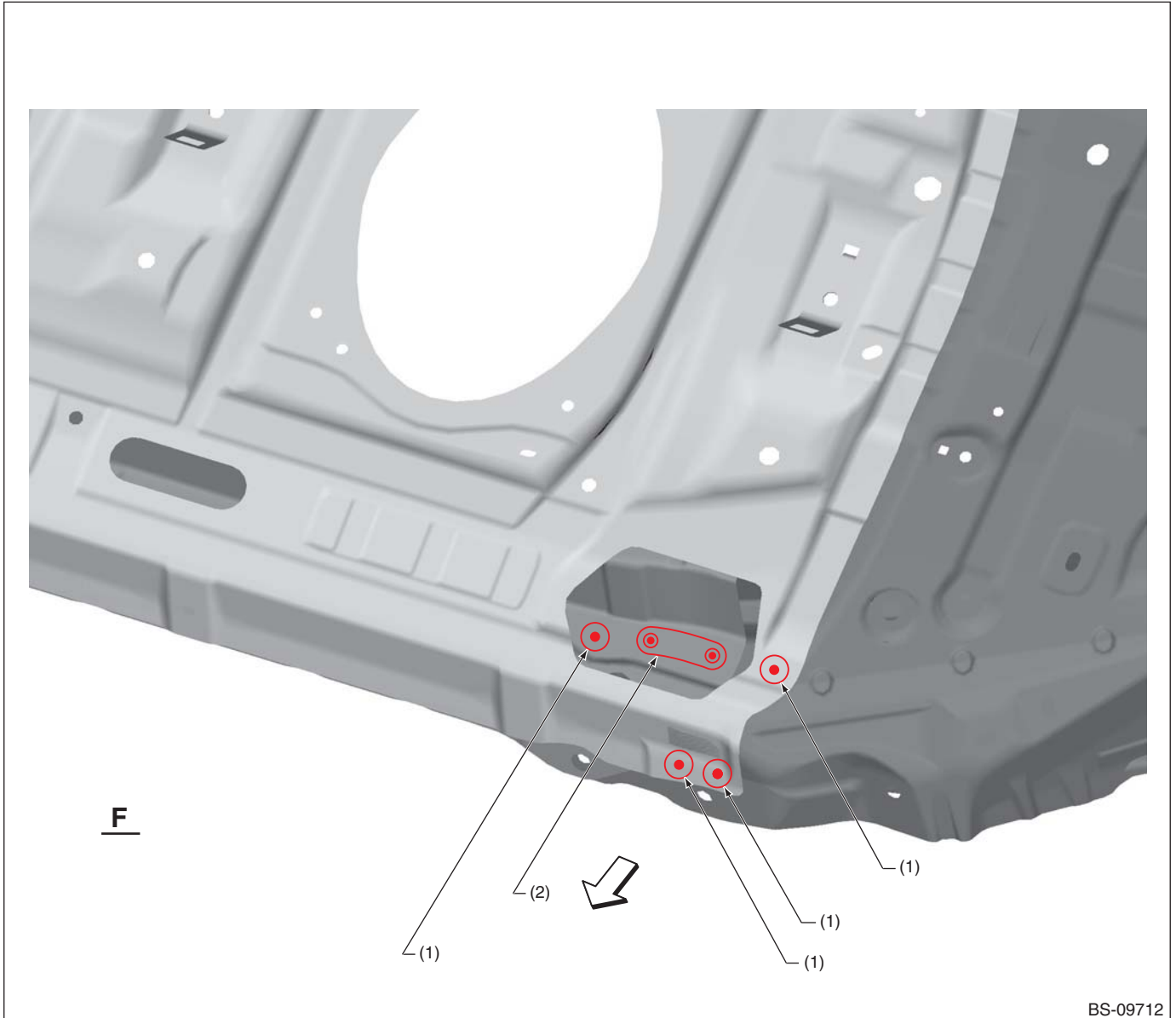
- View E



(1) 1 point

Panel Replacement

- View F



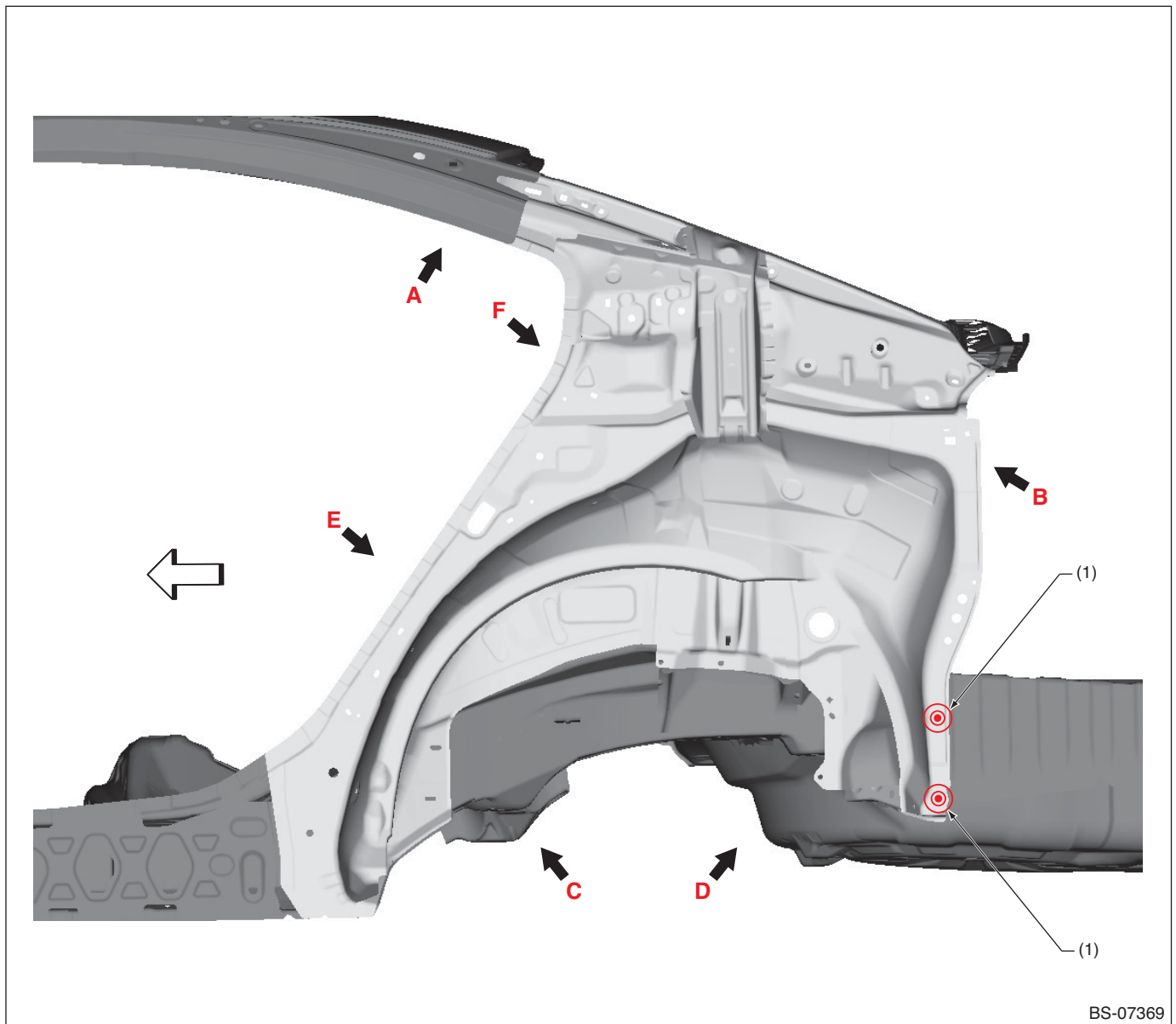
(1) 1 point

(2) 2 points

Panel Replacement

B: INSTALLATION

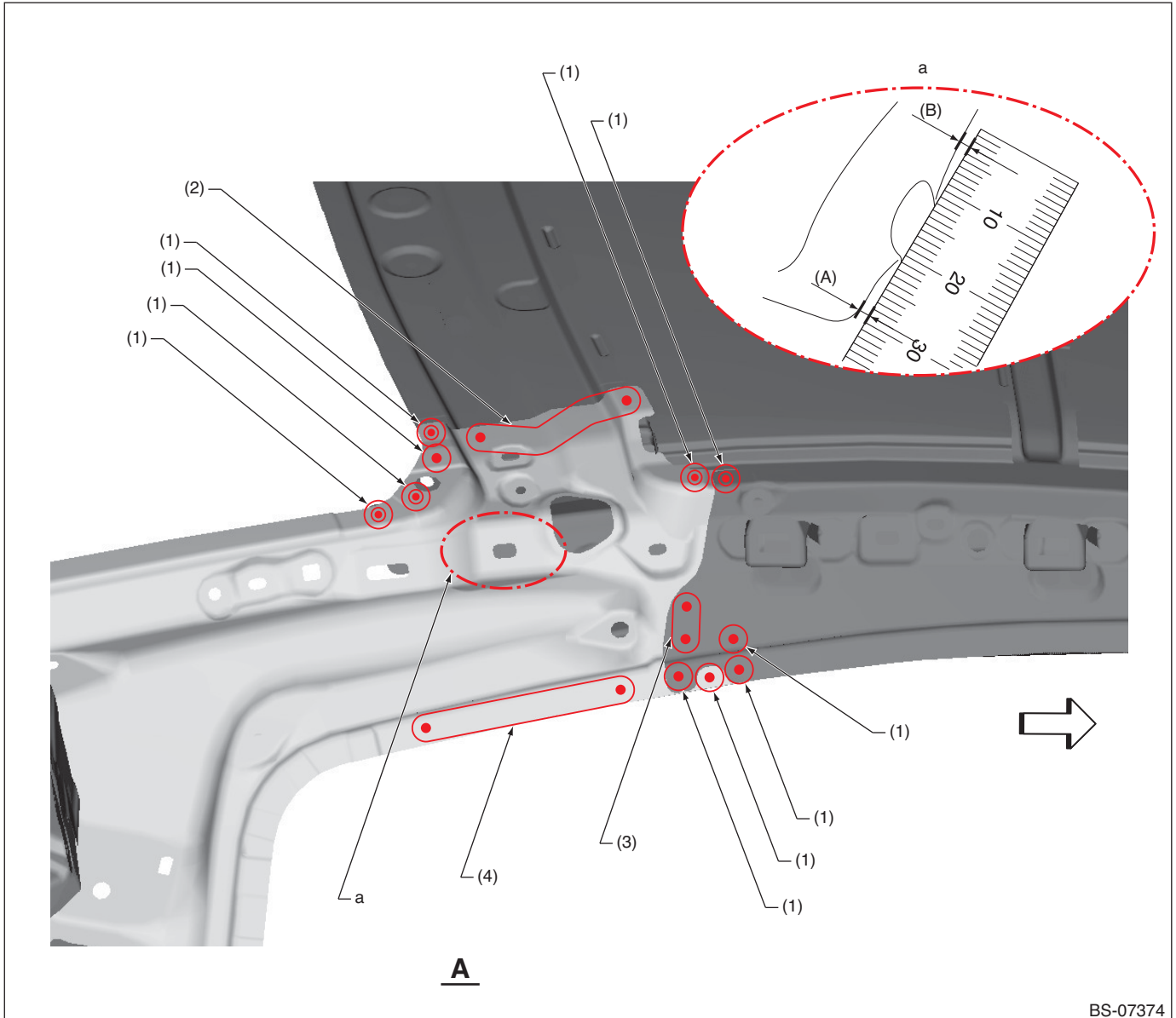
- Overall view



(1) 1 point

Panel Replacement

• View A



(1) 1 point
(2) 4 points

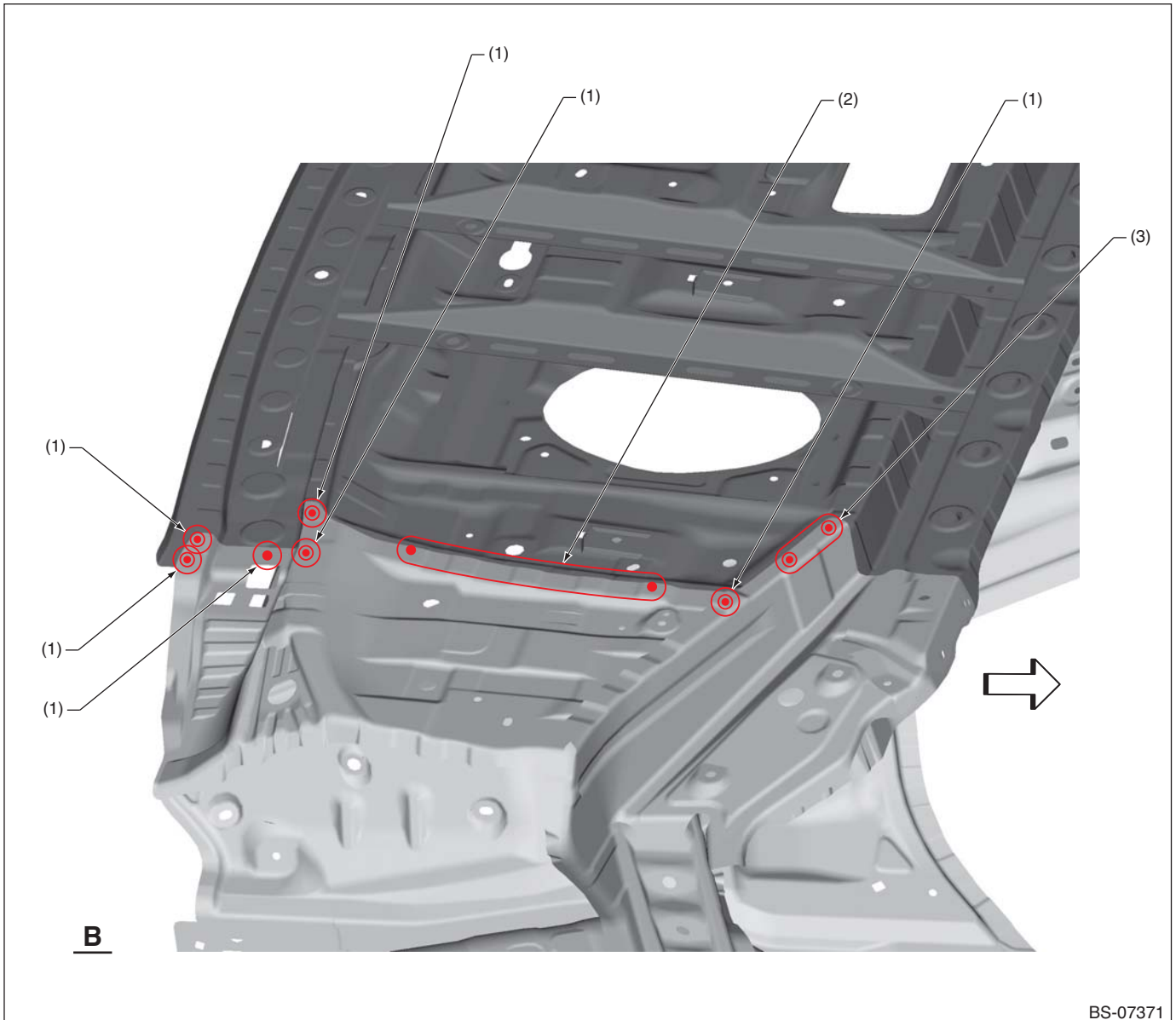
(3) 2 points

(4) 3 points

a: Measure hole deformation dimensions (A) and (B) when the curtain air bag is deployed. When the hole deformation is 0.5 mm (0.02 in) or greater or 1 mm (0.04 in) or less, hit the deformed part to restore it to its original shape. If the hole deformation is greater than 1 mm (0.04 in), replace the part.

Panel Replacement

- View B



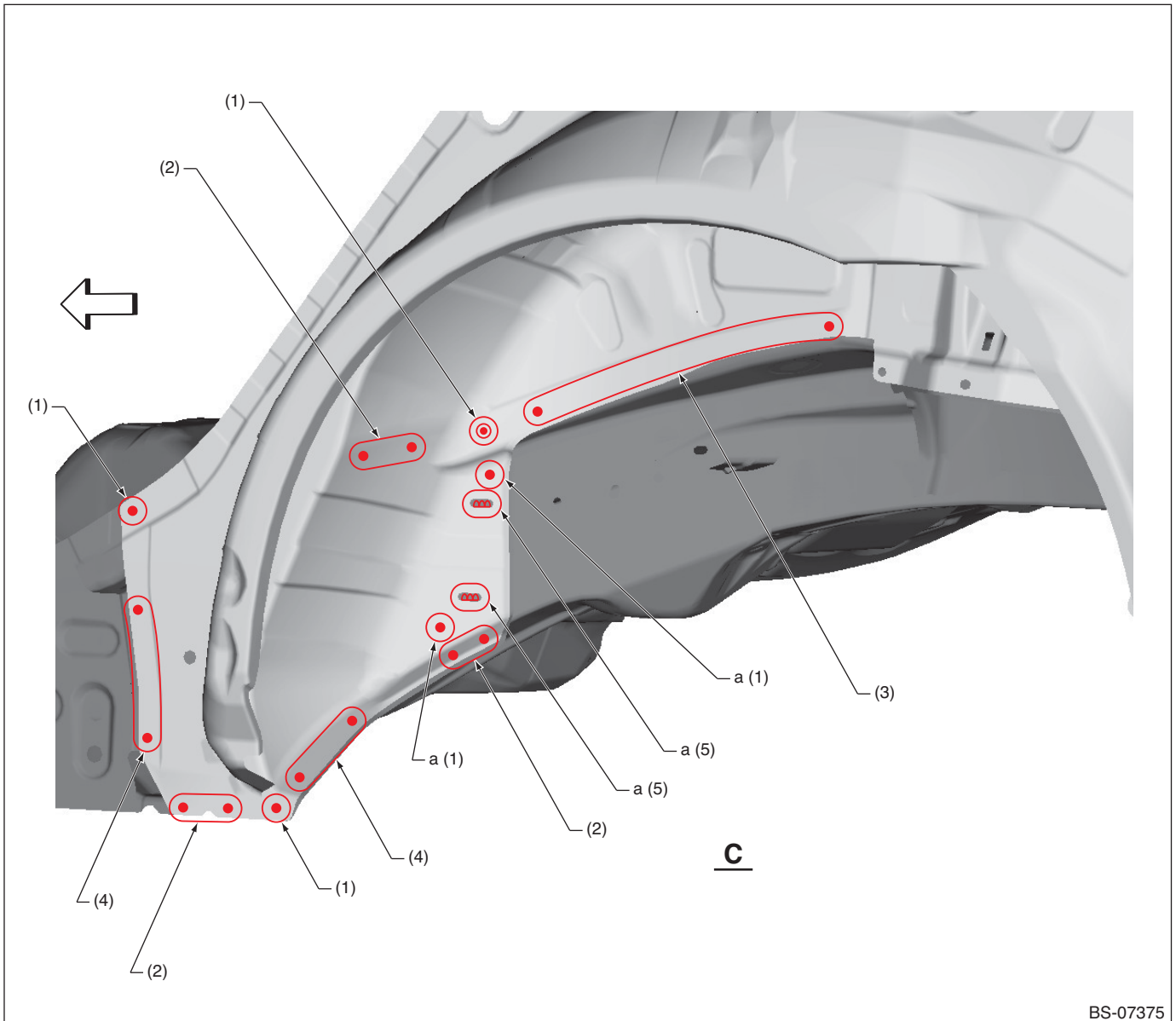
(1) 1 point

(2) 5 points

(3) 3 points

Panel Replacement

• View C



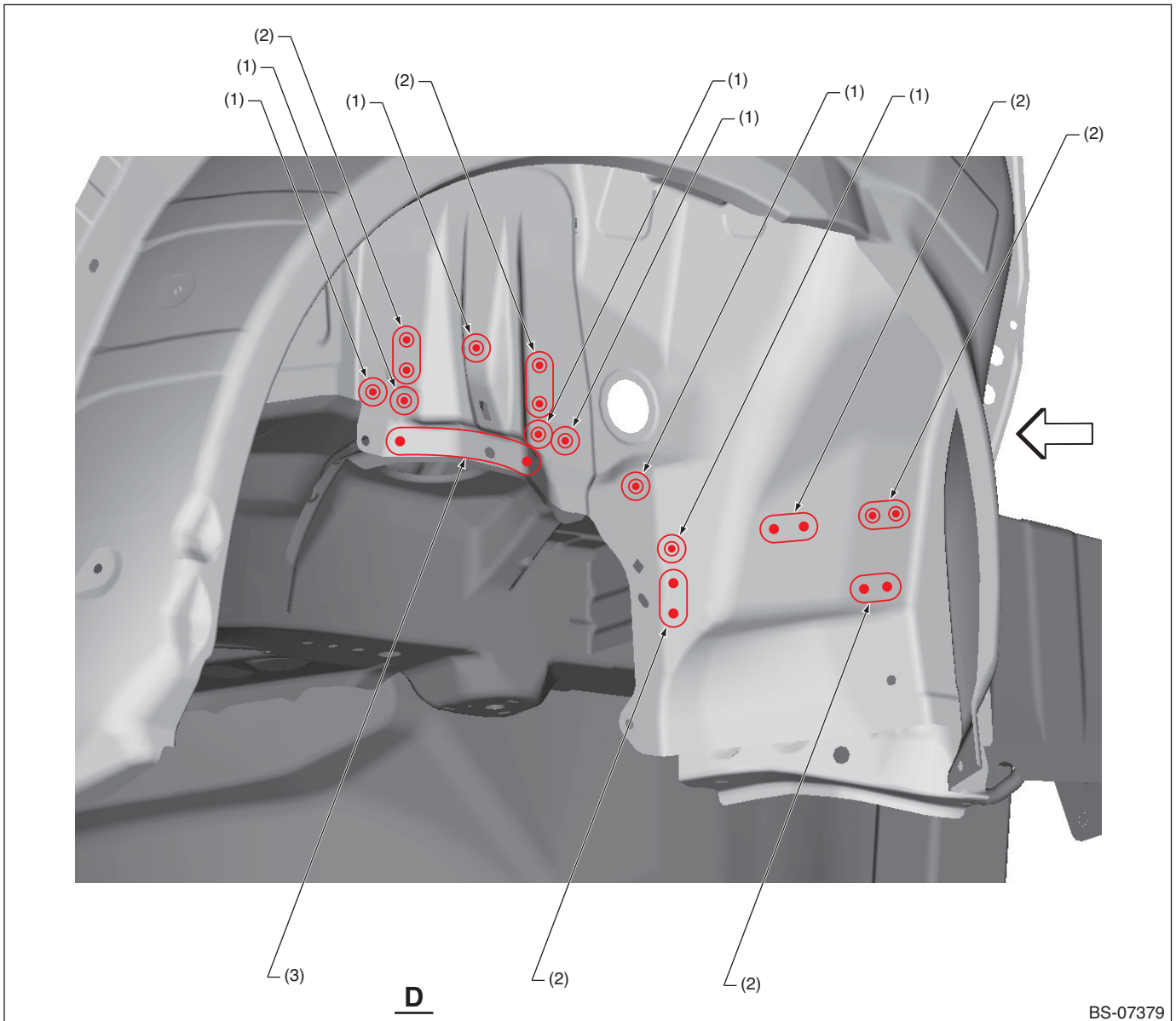
BS-07375

- | | | |
|--------------|--------------|-------------------------------|
| (1) 1 point | (3) 5 points | (5) 1 point [20 mm (0.79 in)] |
| (2) 2 points | (4) 3 points | |

Note: Part "a" may or may not have welding points, depending on the vehicle model.

Panel Replacement

- View D



BS-07379

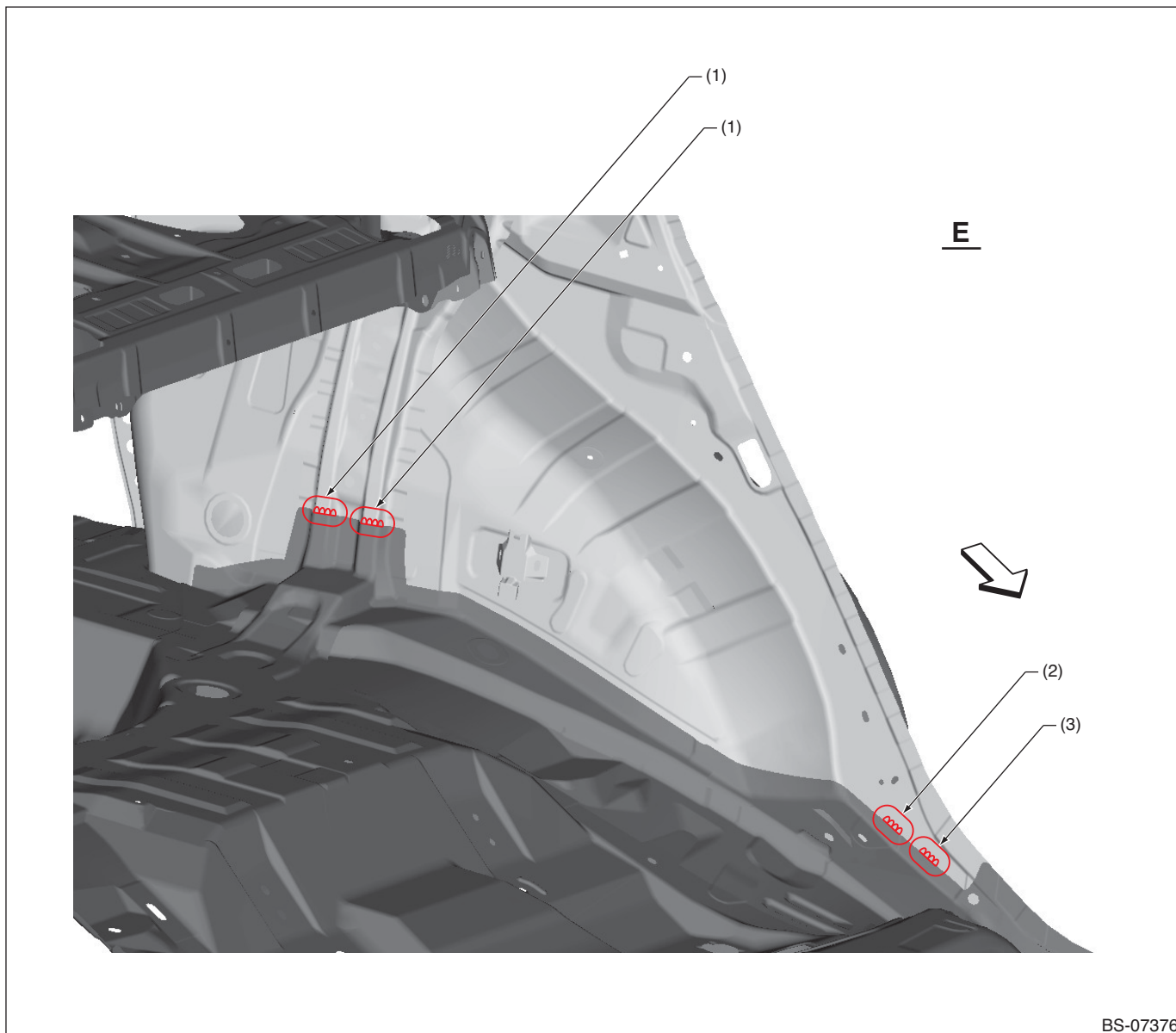
(1) 1 point

(2) 2 points

(3) 6 points

Panel Replacement

- View E



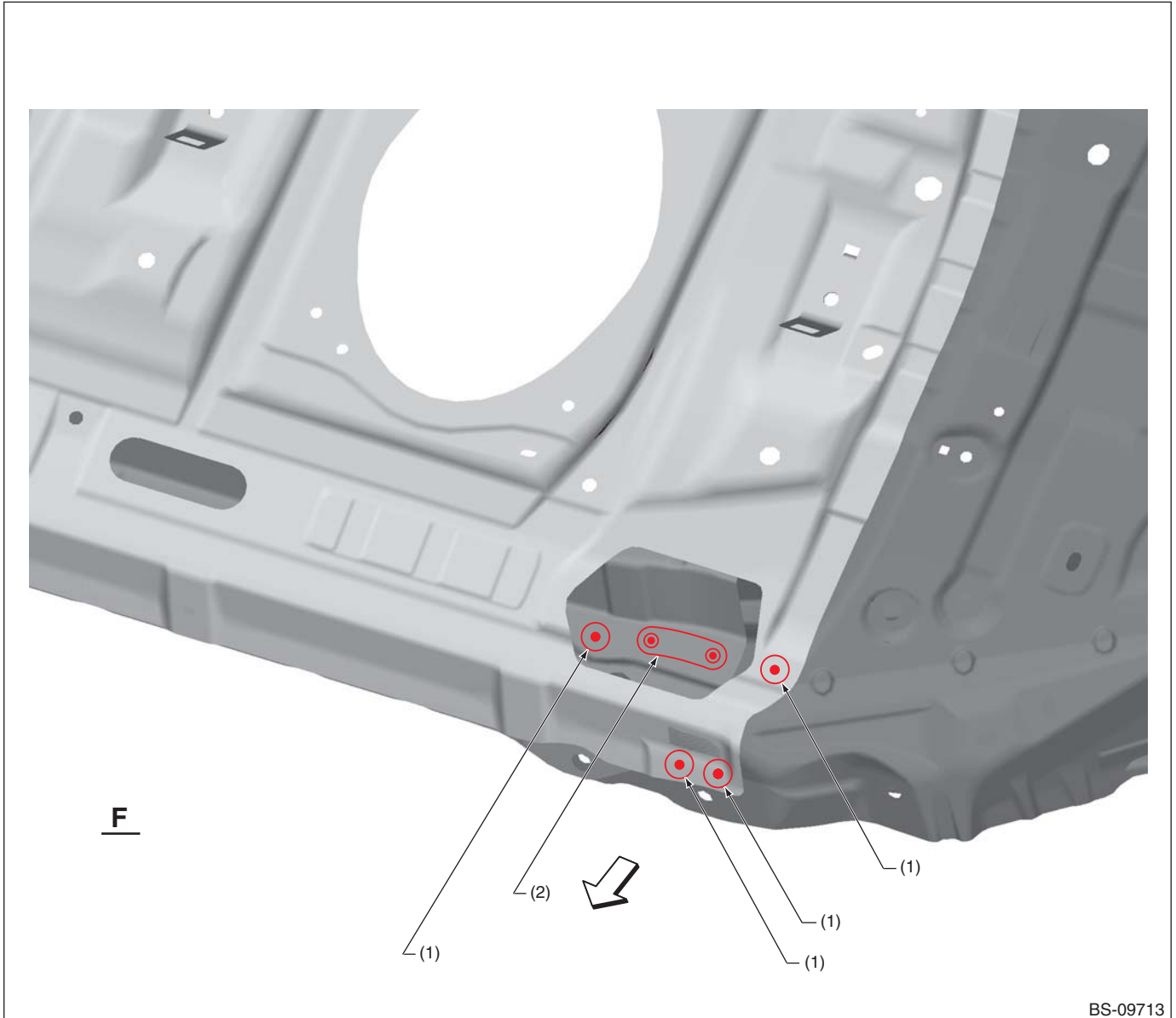
(1) 1 point [20 mm (0.79 in)]

(2) 1 point [28 mm (1.10 in)]

(3) 1 point [30 mm (1.18 in)]

Panel Replacement

- View F



(1) 1 point

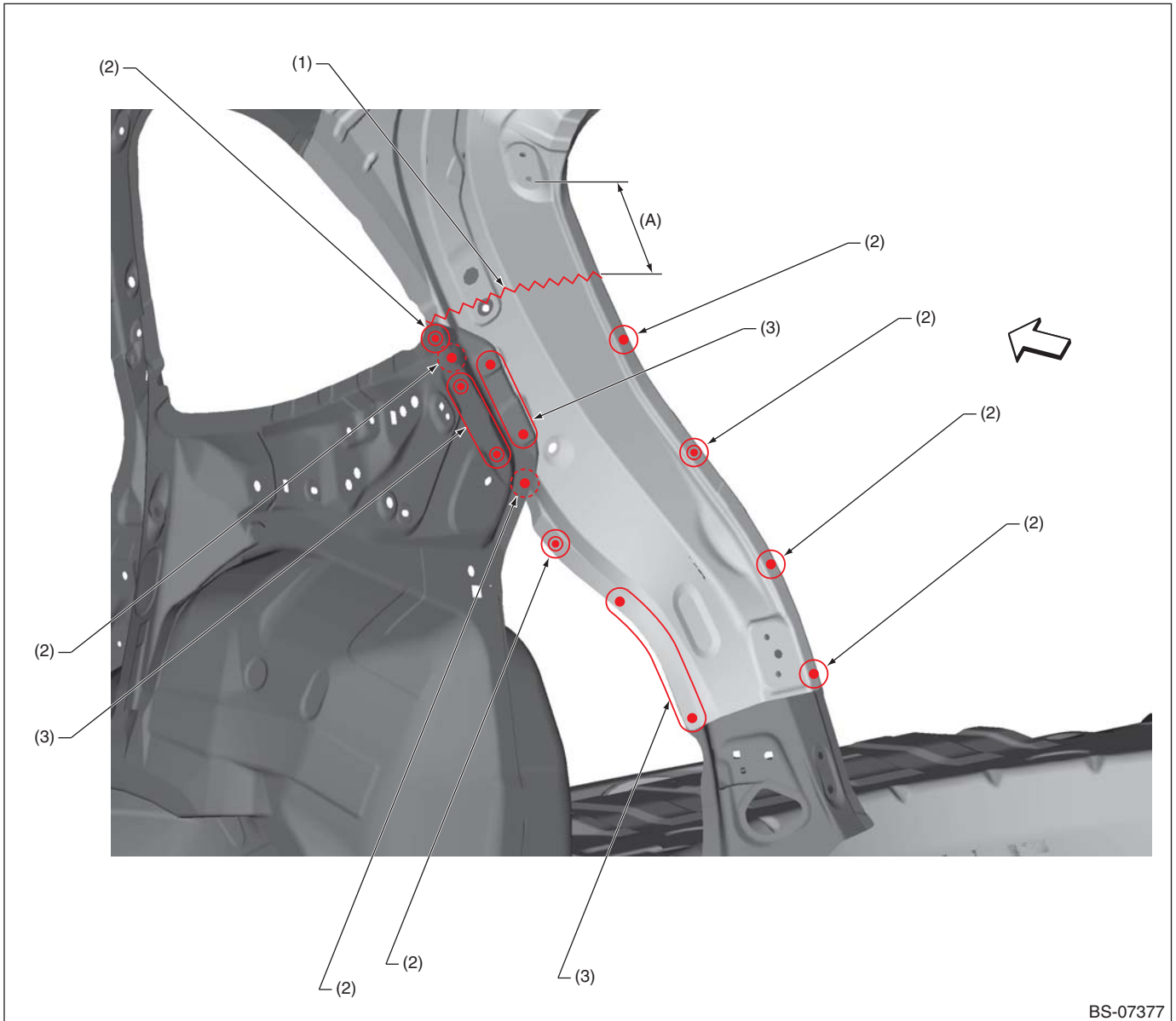
(2) 2 points

Panel Replacement

8-34. D-Pillar Reinforcement (Partial replacement)/OUTBACK

A: REMOVAL

- Rear quarter outer, rear quarter end and rear skirt removal condition



(A) 120 mm (4.72 in)

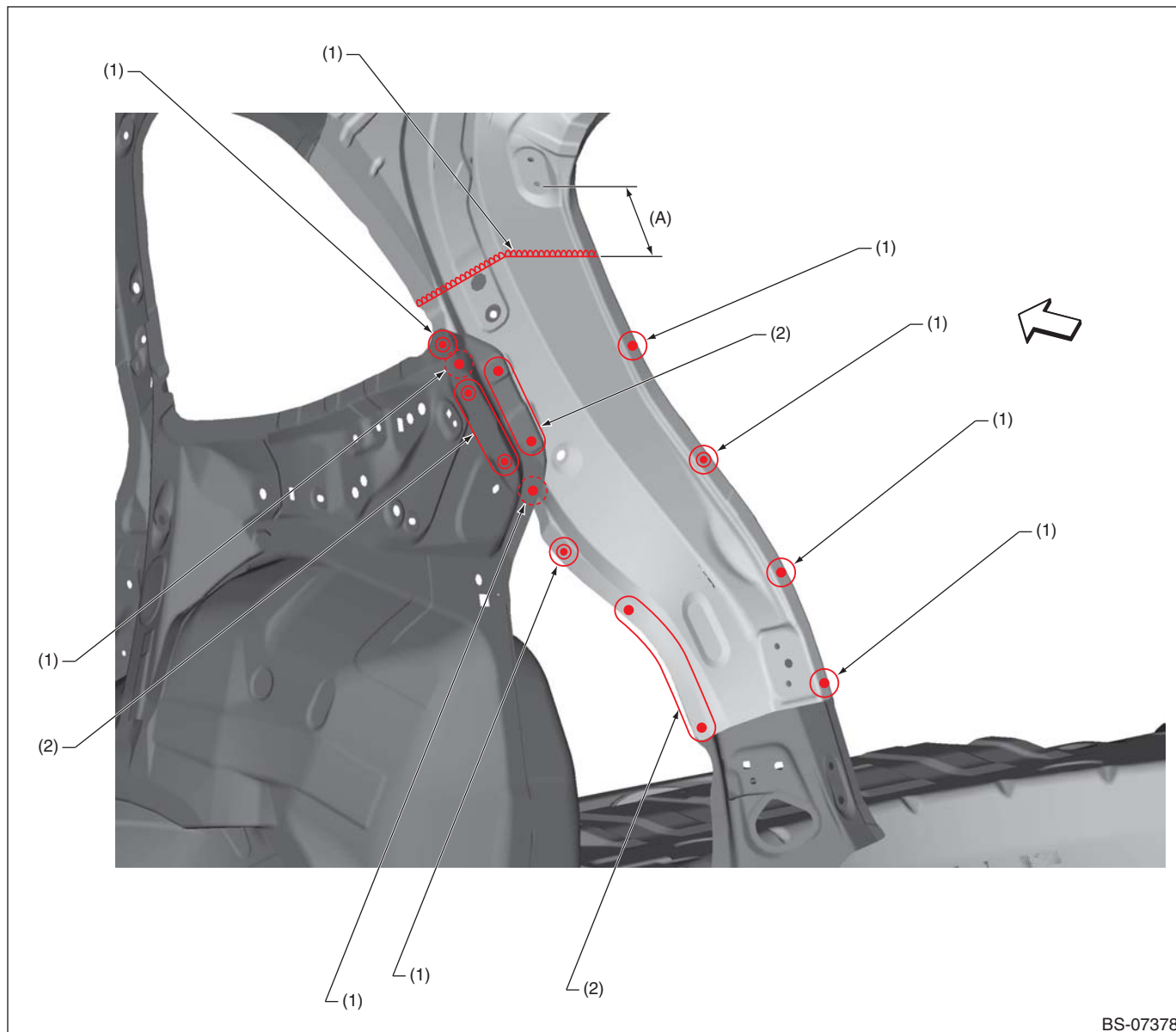
(1) Cut position

(2) 1 point

(3) 3 points

Panel Replacement

B: INSTALLATION



BS-07378

(A) 90 mm (3.54 in)

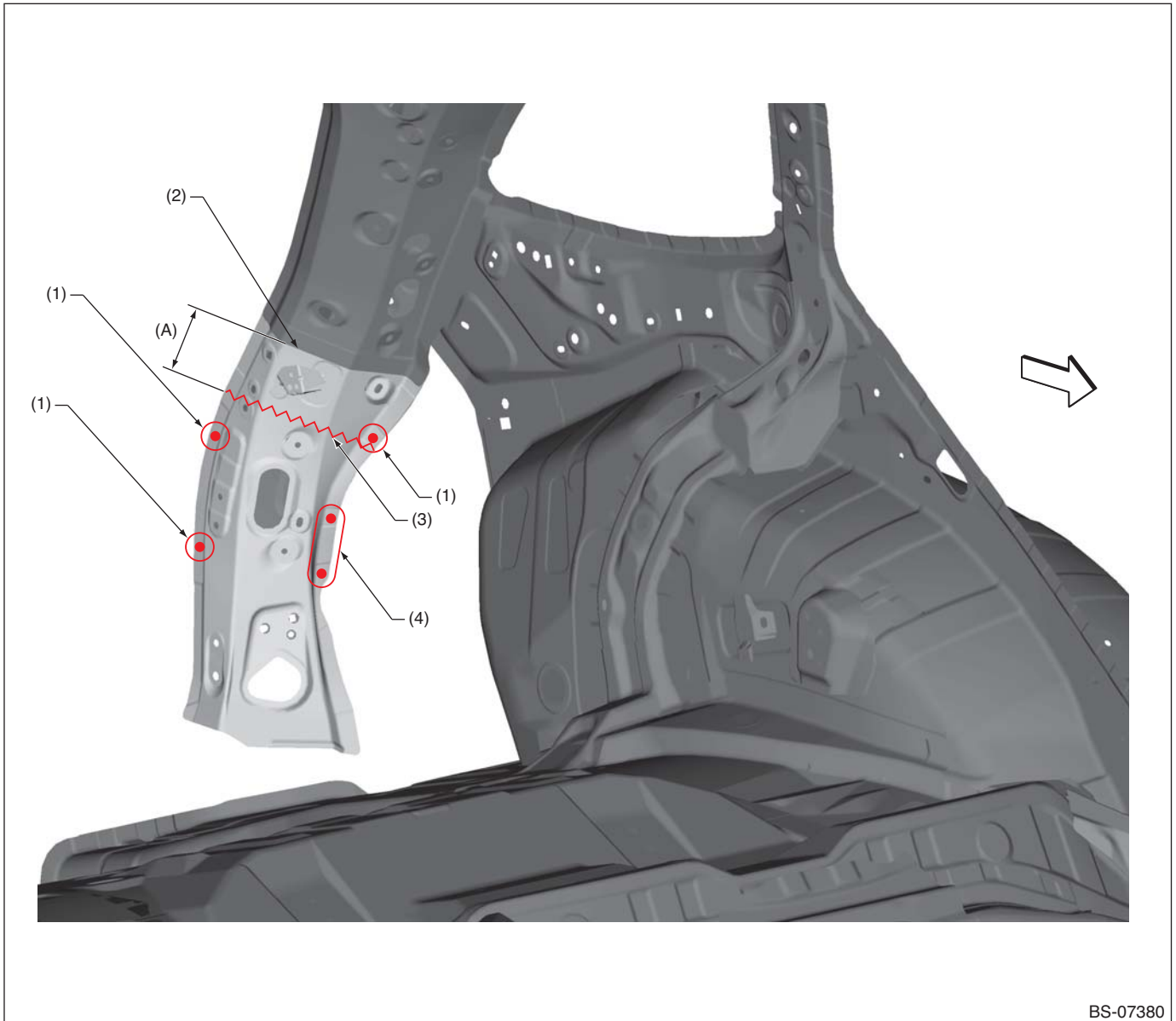
(1) 1 point

(2) 3 points

8-35. D-Pillar Inner (Partial replacement)/OUTBACK

A: REMOVAL

- Rear quarter outer, rear quarter end and rear skirt removal condition



(A) 80 mm (3.15 in)

(1) 1 point

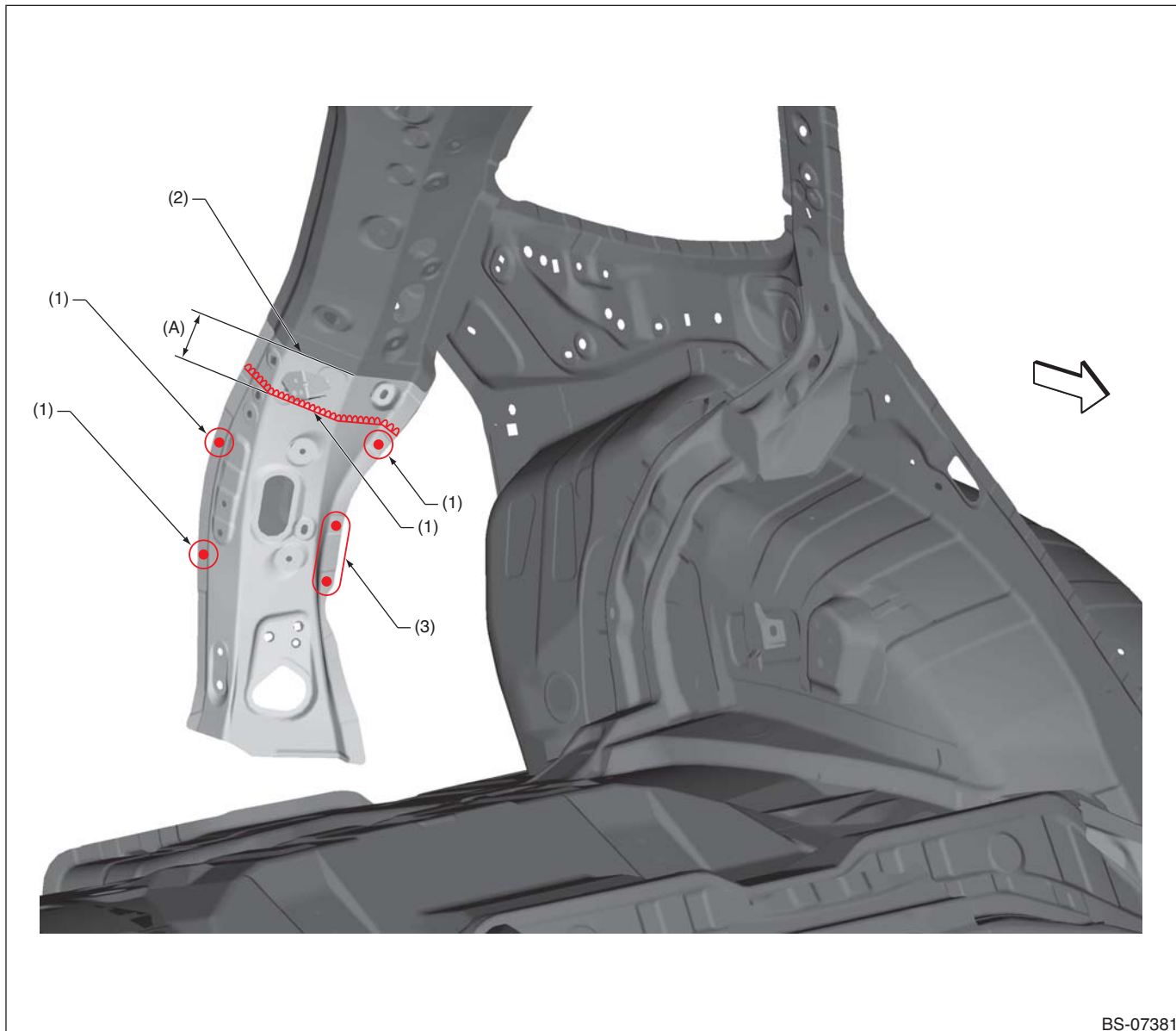
(3) Cut position

(4) 2 points

(2) Trim line

Panel Replacement

B: INSTALLATION



BS-07381

(A) 60 mm (2.36 in)

(1) 1 point

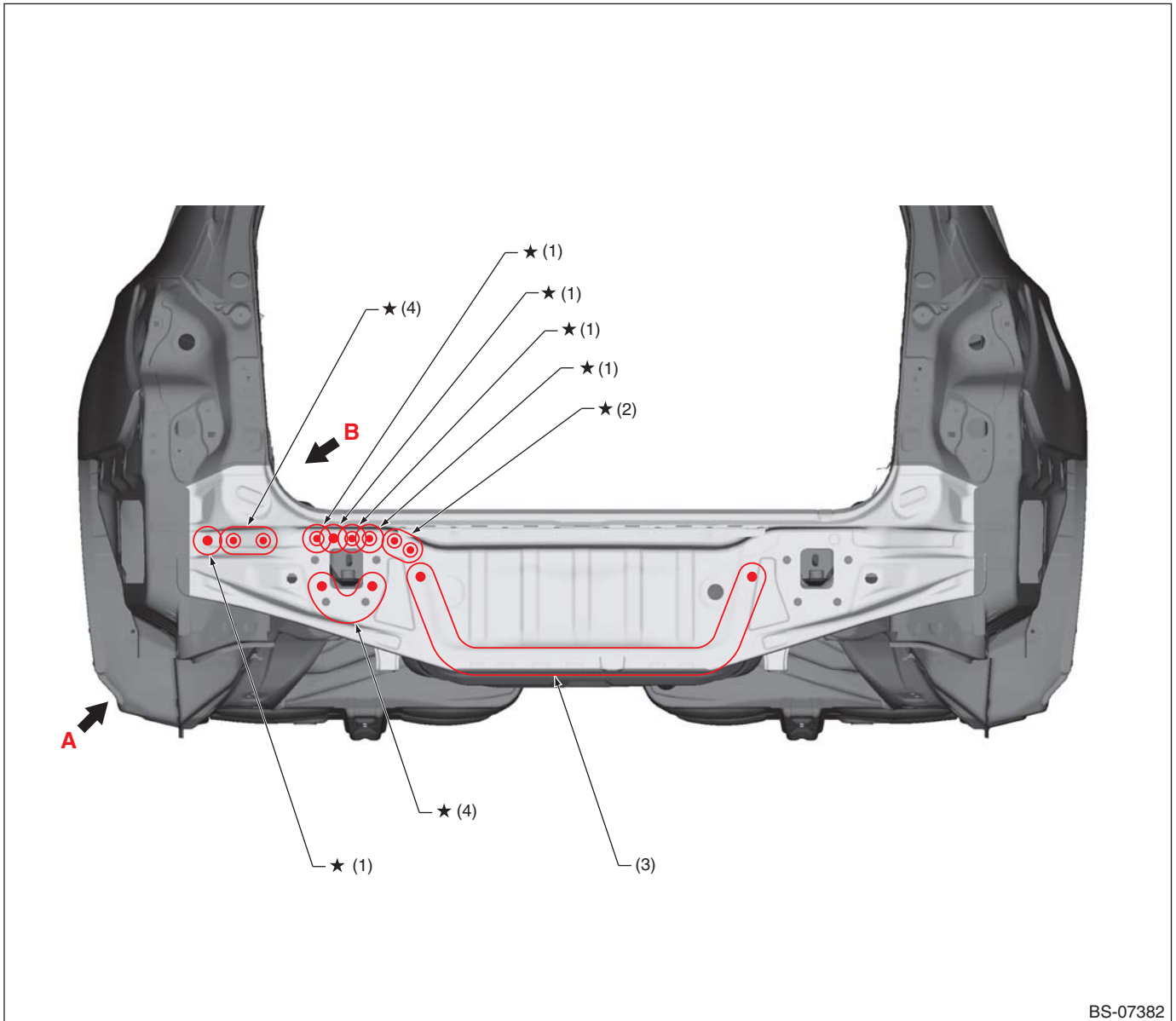
(2) Trim line

(3) 2 points

8-36. Rear Skirt (Total replacement)/OUTBACK

A: REMOVAL

- Overall view



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

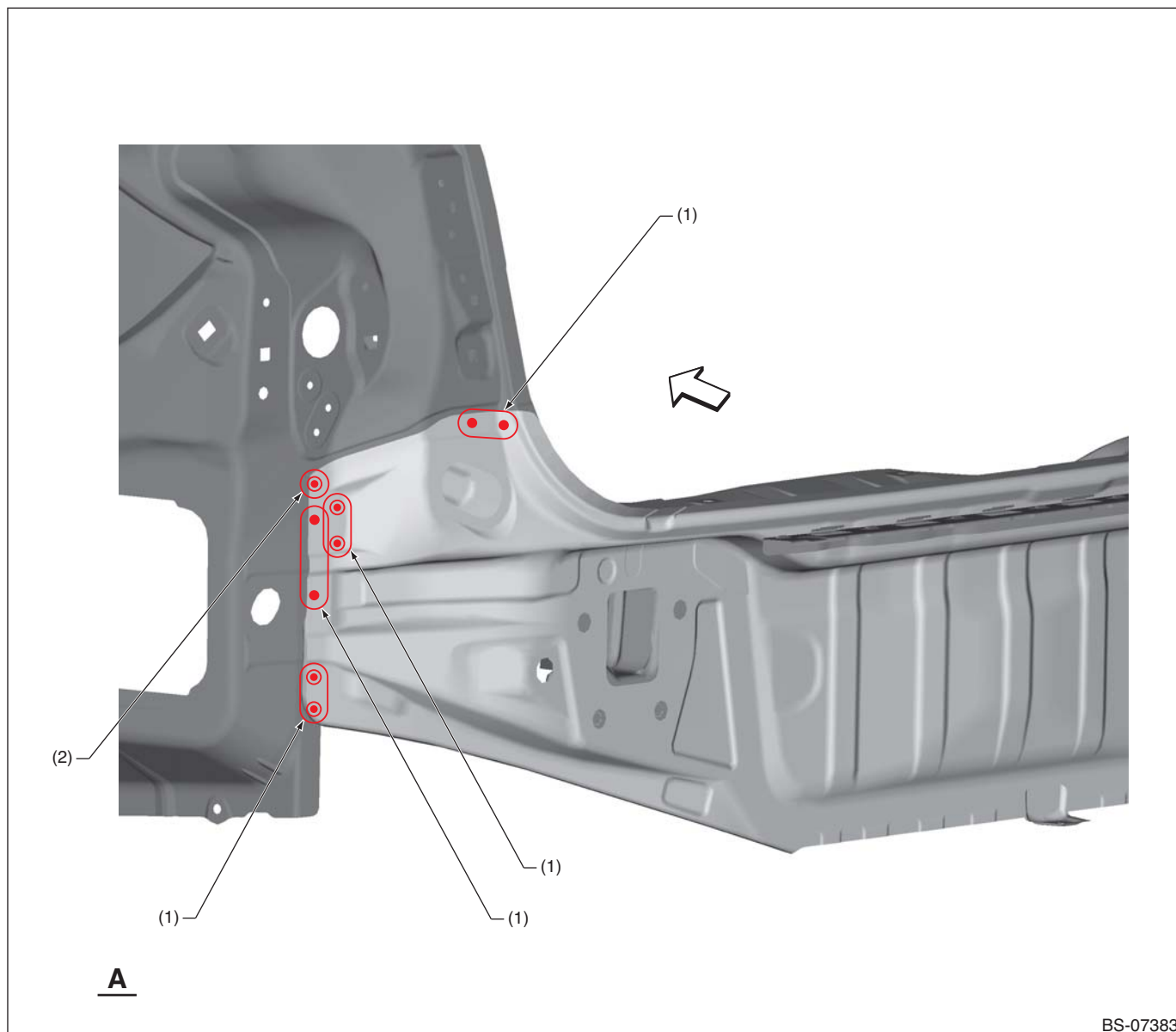
- (3) 14 points

- (4) 3 points

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

Panel Replacement

- View A



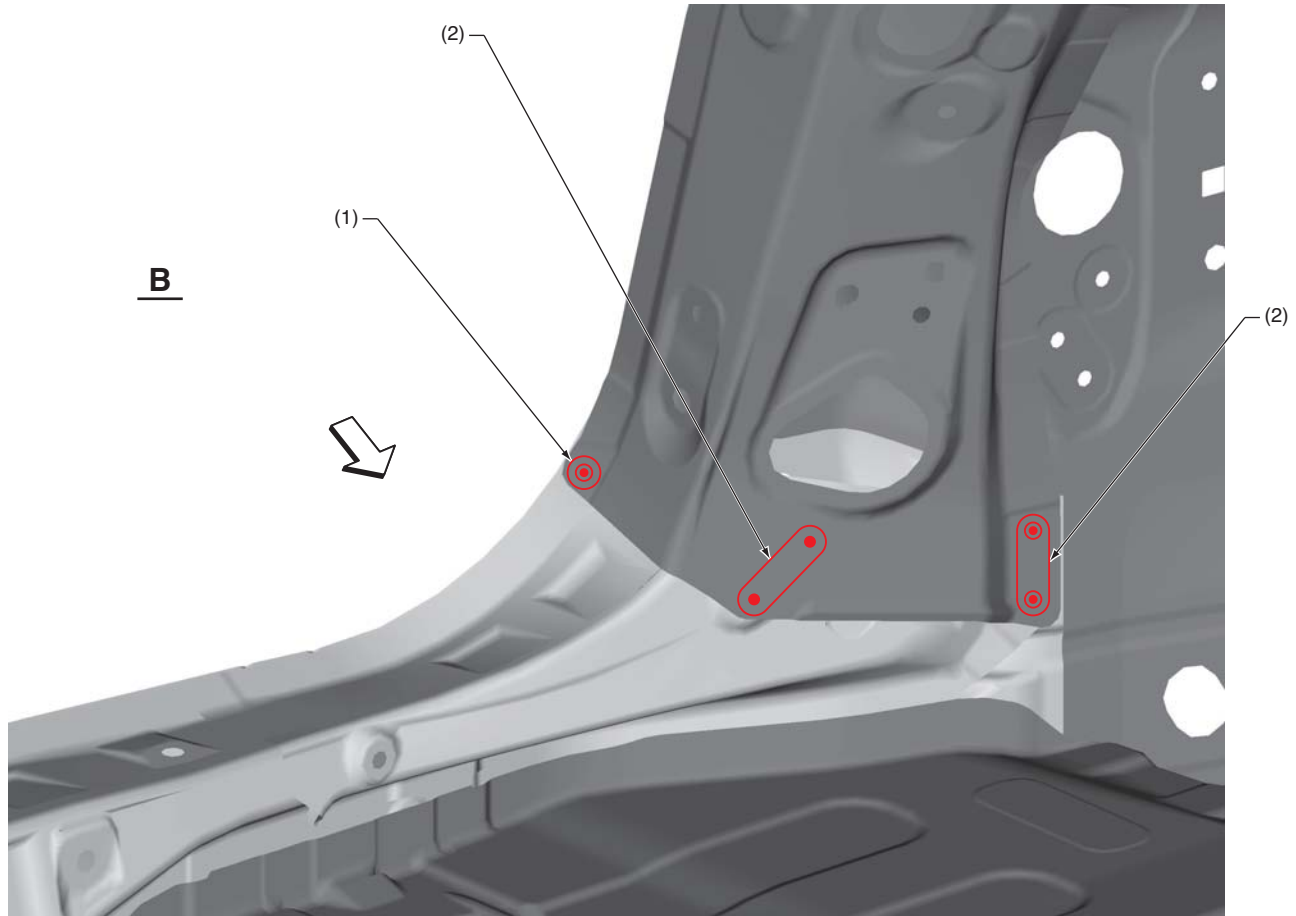
BS-07383

(1) 2 points

(2) 1 point

Panel Replacement

- View B



BS-07384

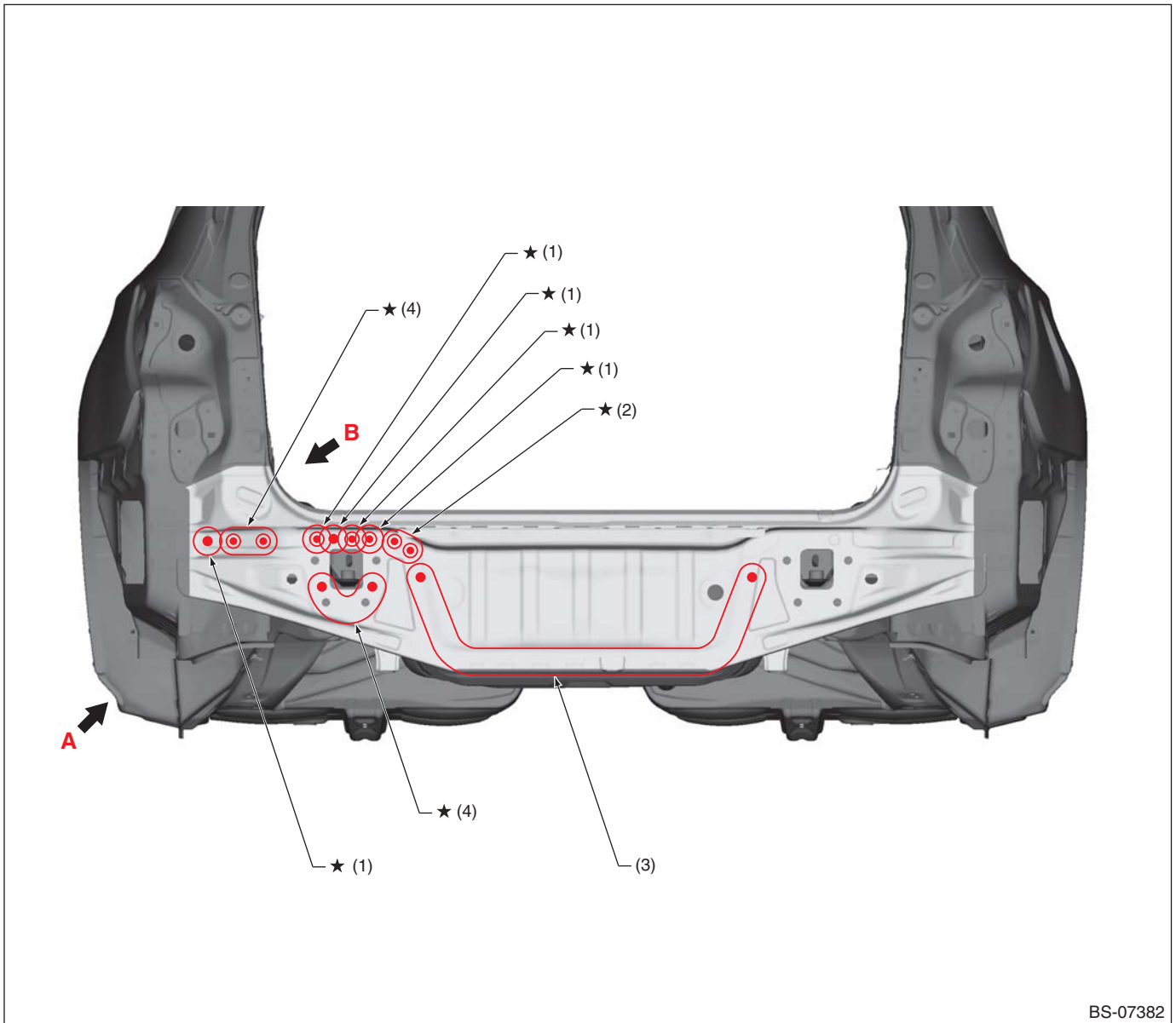
(1) 1 point

(2) 2 points

Panel Replacement

B: INSTALLATION

• Overall view



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

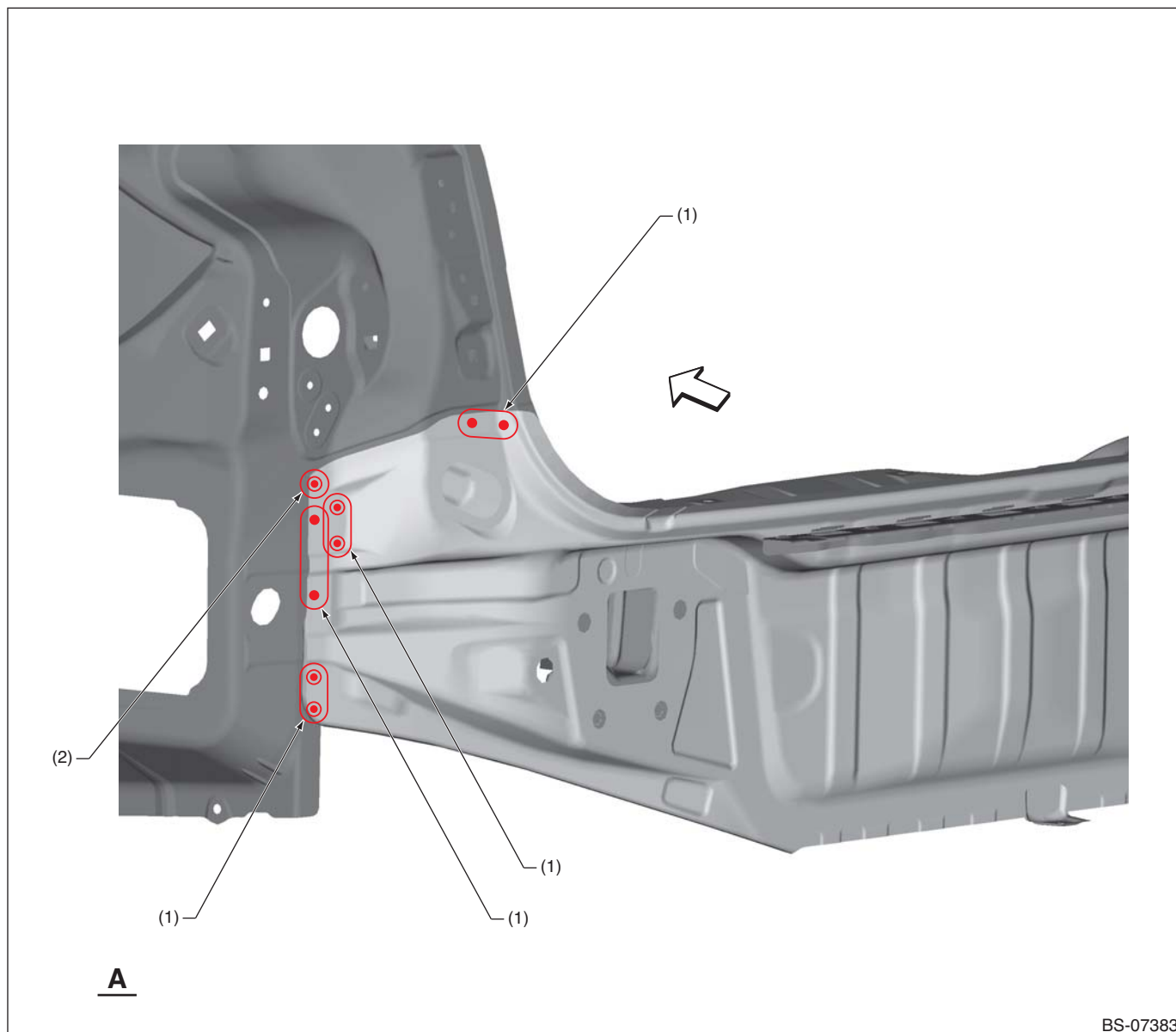
- (3) 14 points

- (4) 3 points

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

Panel Replacement

- View A

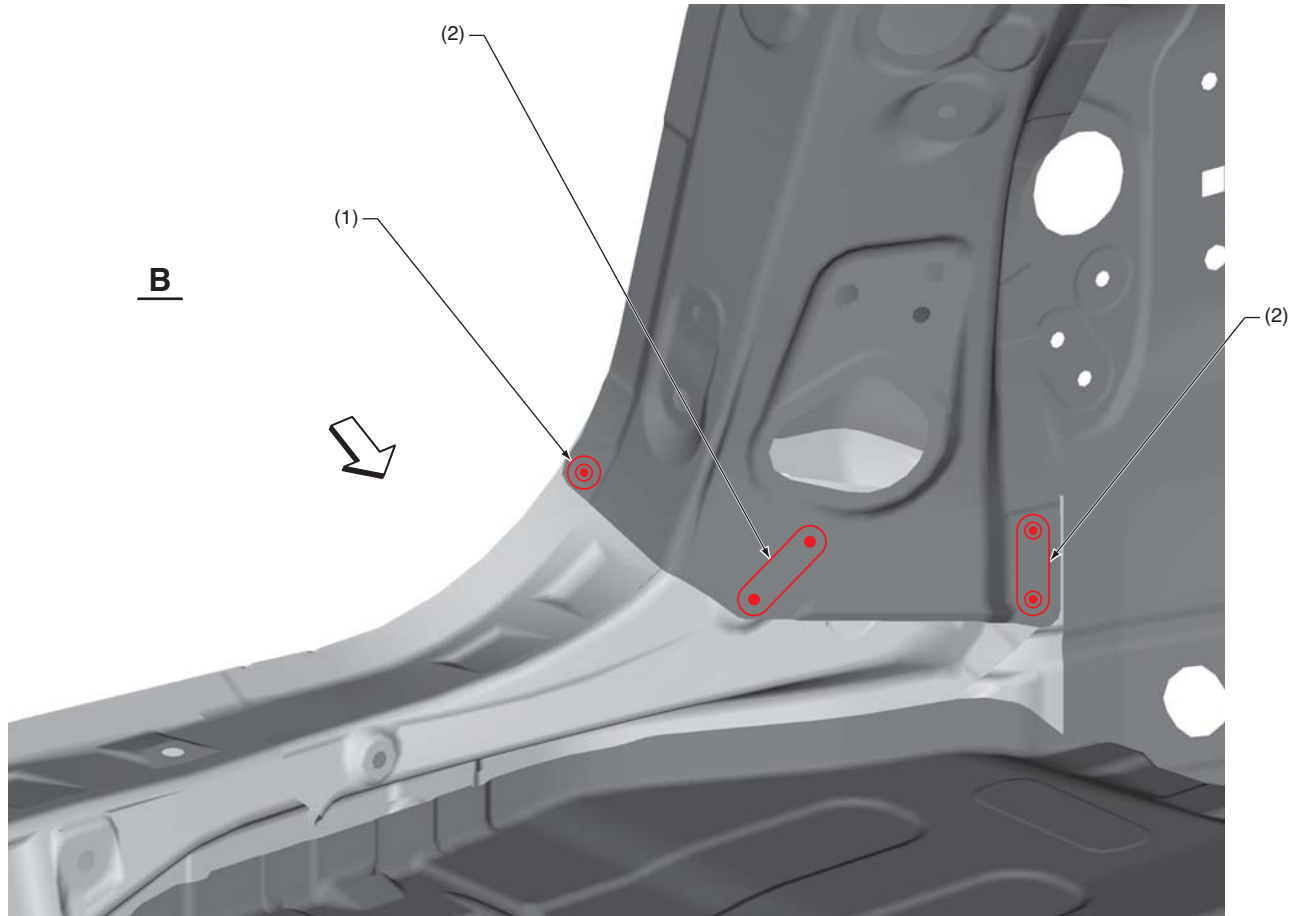


(1) 2 points

(2) 1 point

Panel Replacement

- View B



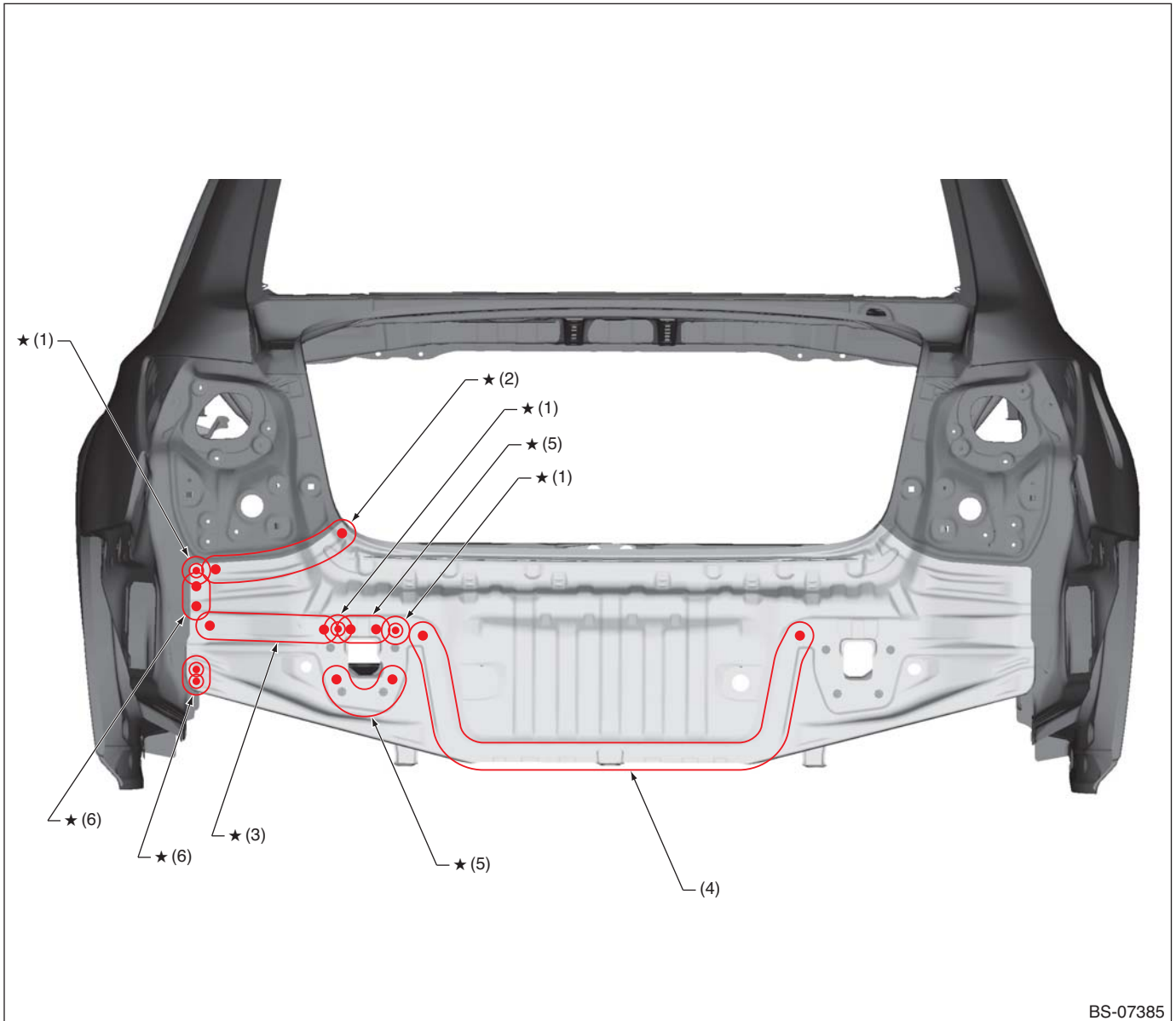
BS-07384

(1) 1 point

(2) 2 points

8-37. Rear Skirt (Total replacement)/SEDAN

A: REMOVAL



(1) 1 point
(2) 7 points

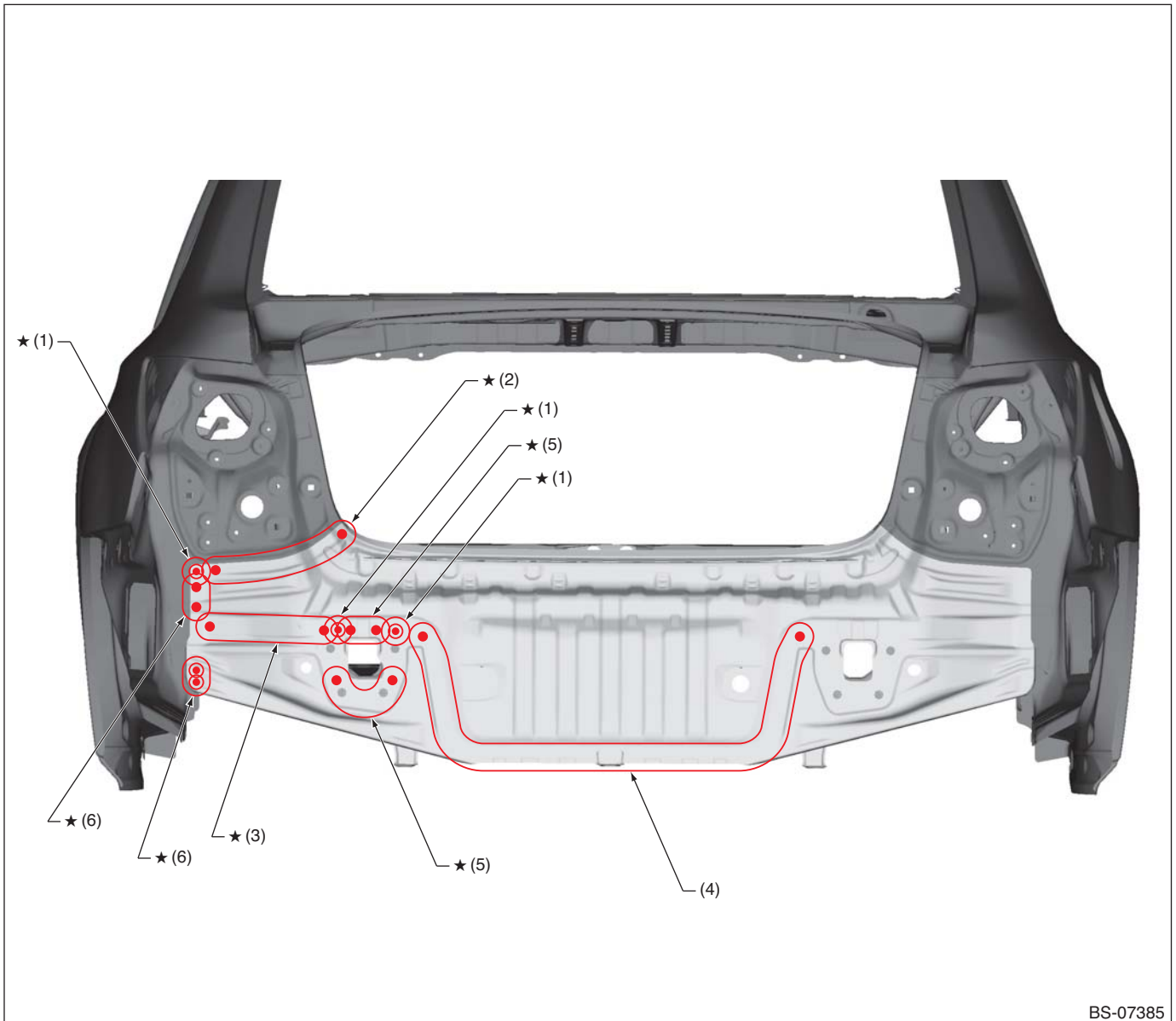
(3) 5 points
(4) 18 points

(5) 3 points
(6) 2 points

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

Panel Replacement

B: INSTALLATION



(1) 1 point
(2) 7 points

(3) 5 points
(4) 18 points

(5) 3 points
(6) 2 points

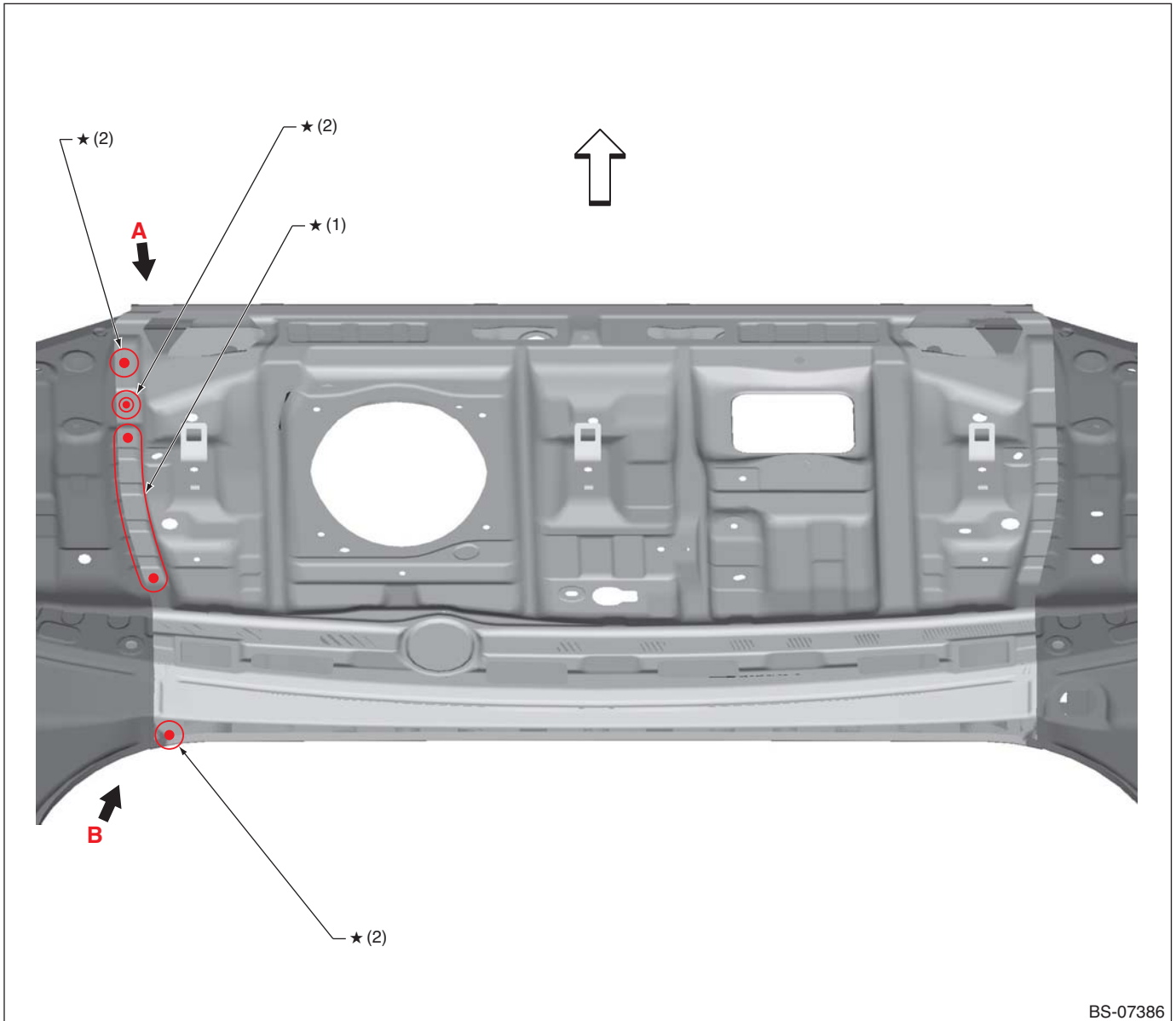
For locations marked by ★, the welding method and the number of welding points are the same on the left and the right.

Panel Replacement

8-38. Rear Panel (Total replacement)/SEDAN

A: REMOVAL

- Overall view



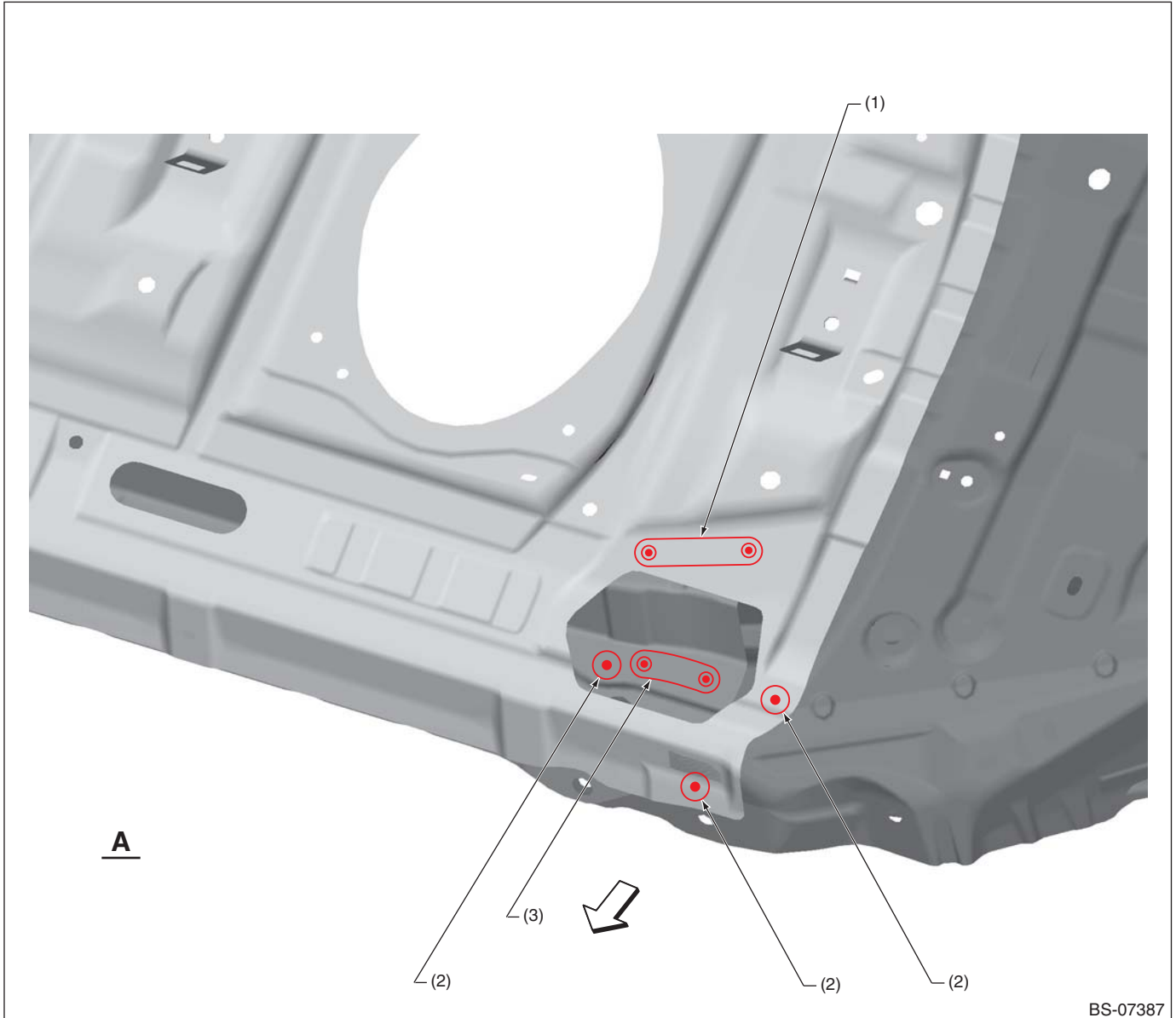
(1) 5 points

(2) 1 point

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

Panel Replacement

- View A



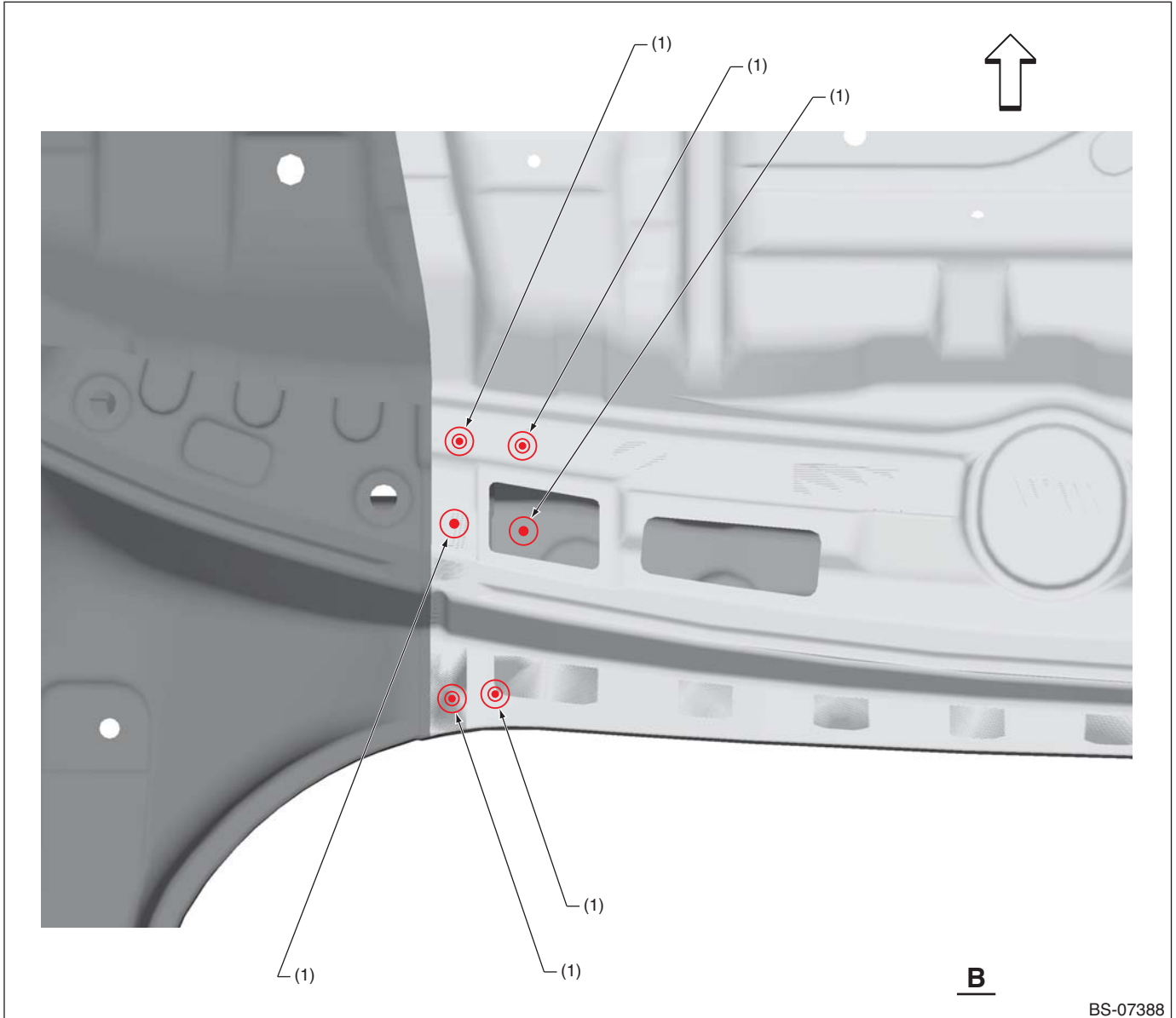
(1) 3 points

(2) 1 point

(3) 2 points

Panel Replacement

- View B



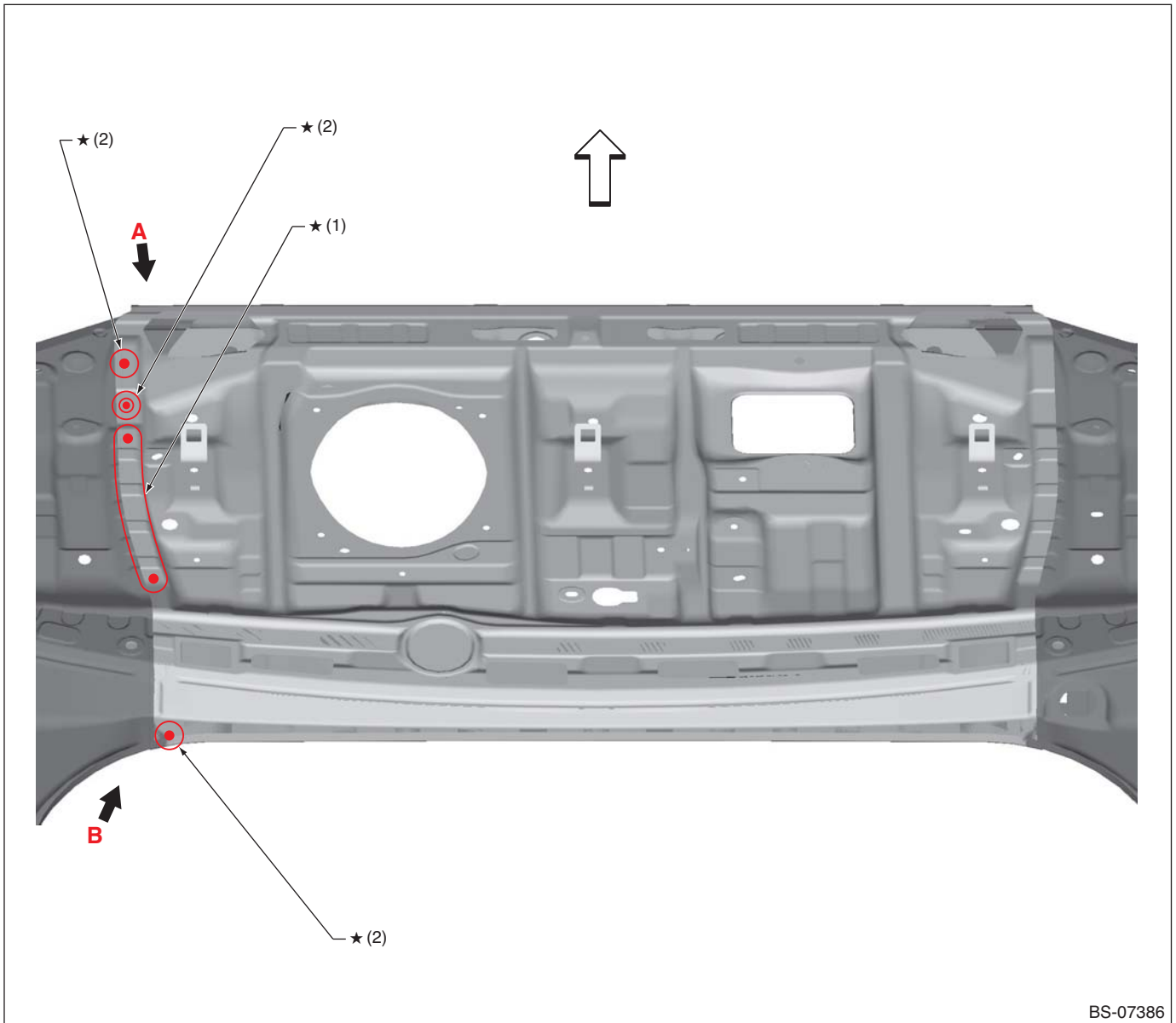
BS-07388

(1) 1 point

Panel Replacement

B: INSTALLATION

- Overall view



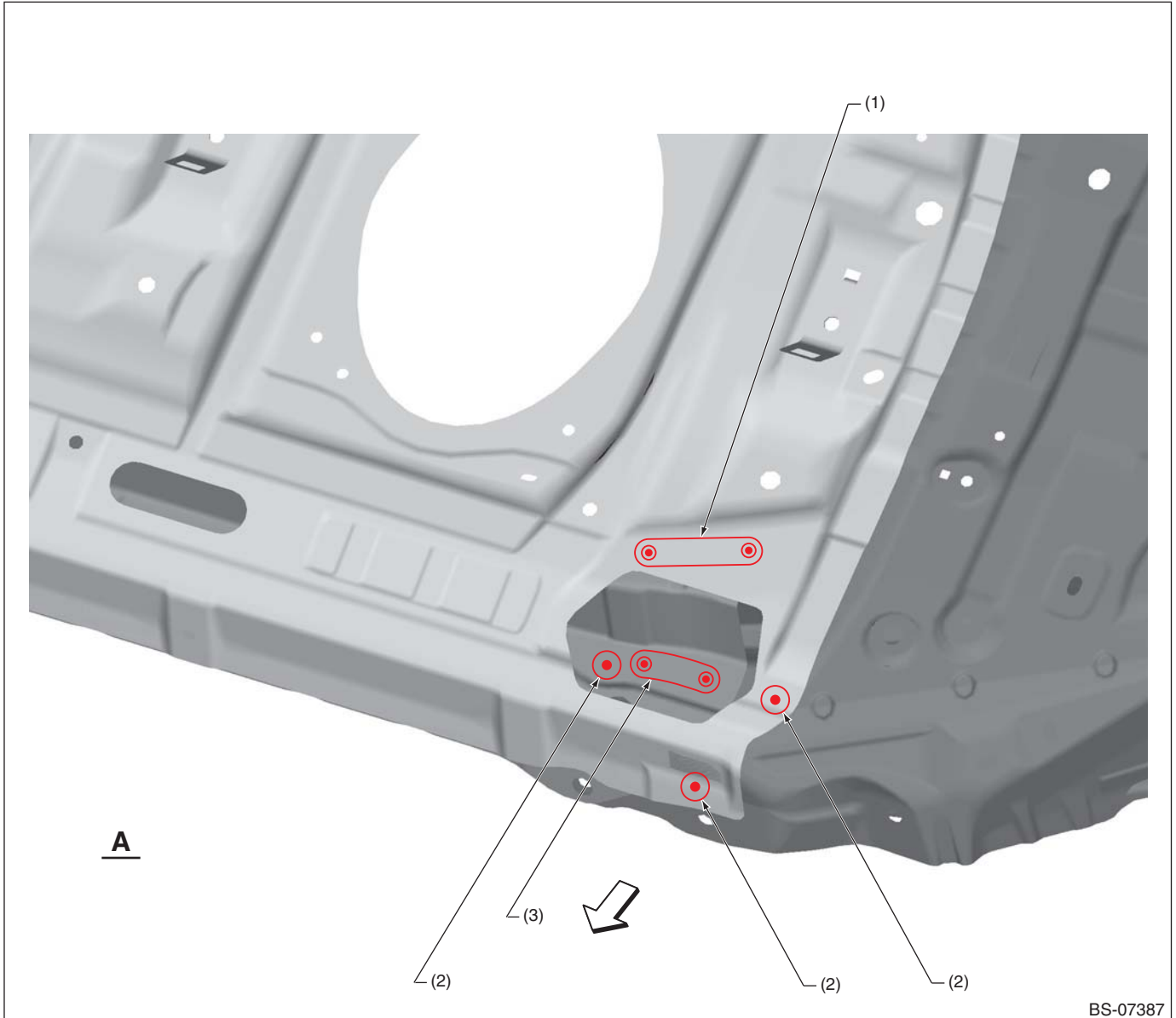
(1) 5 points

(2) 1 point

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

Panel Replacement

- View A



BS-07387

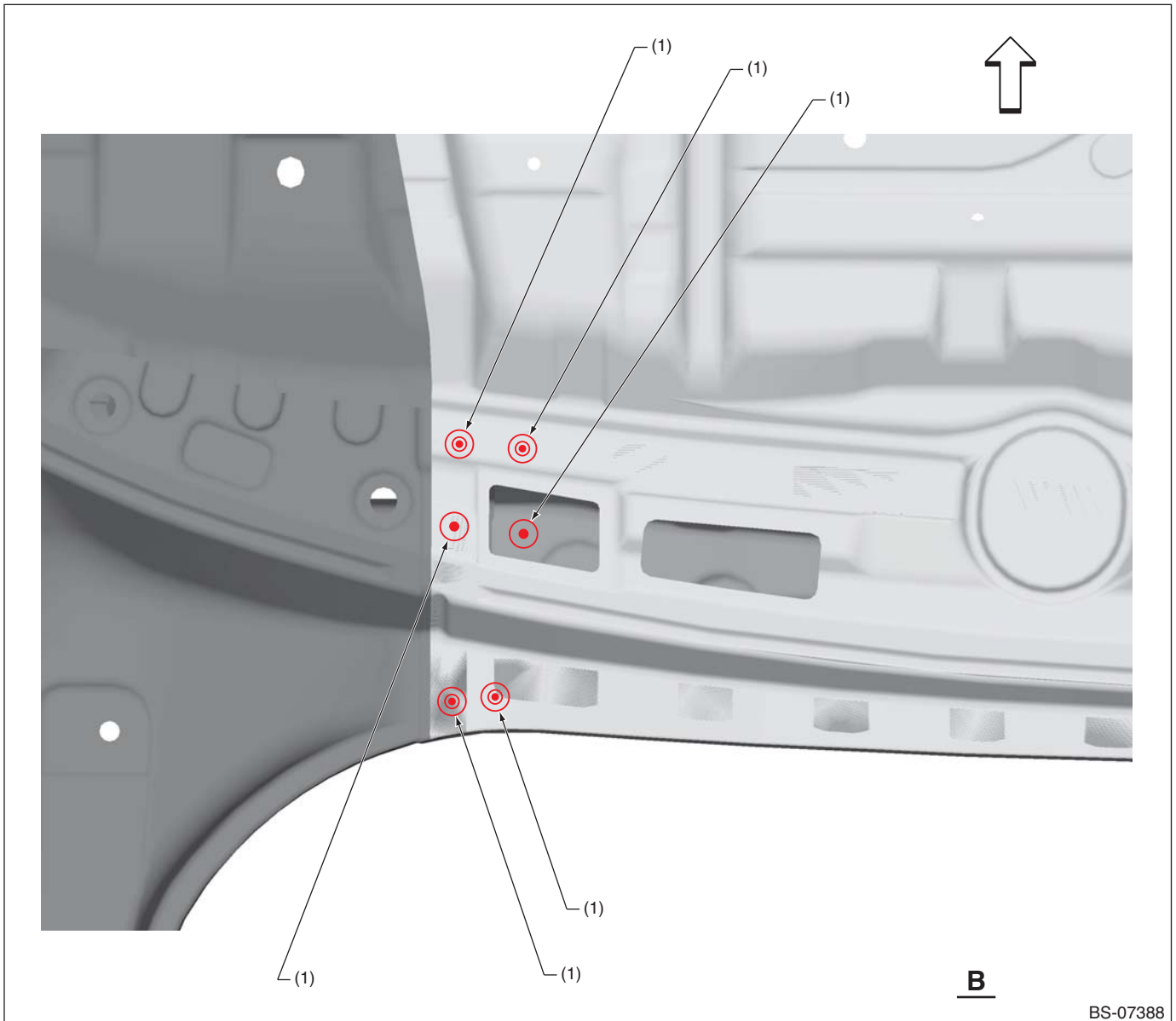
(1) 3 points

(2) 1 point

(3) 2 points

Panel Replacement

- View B



BS-07388

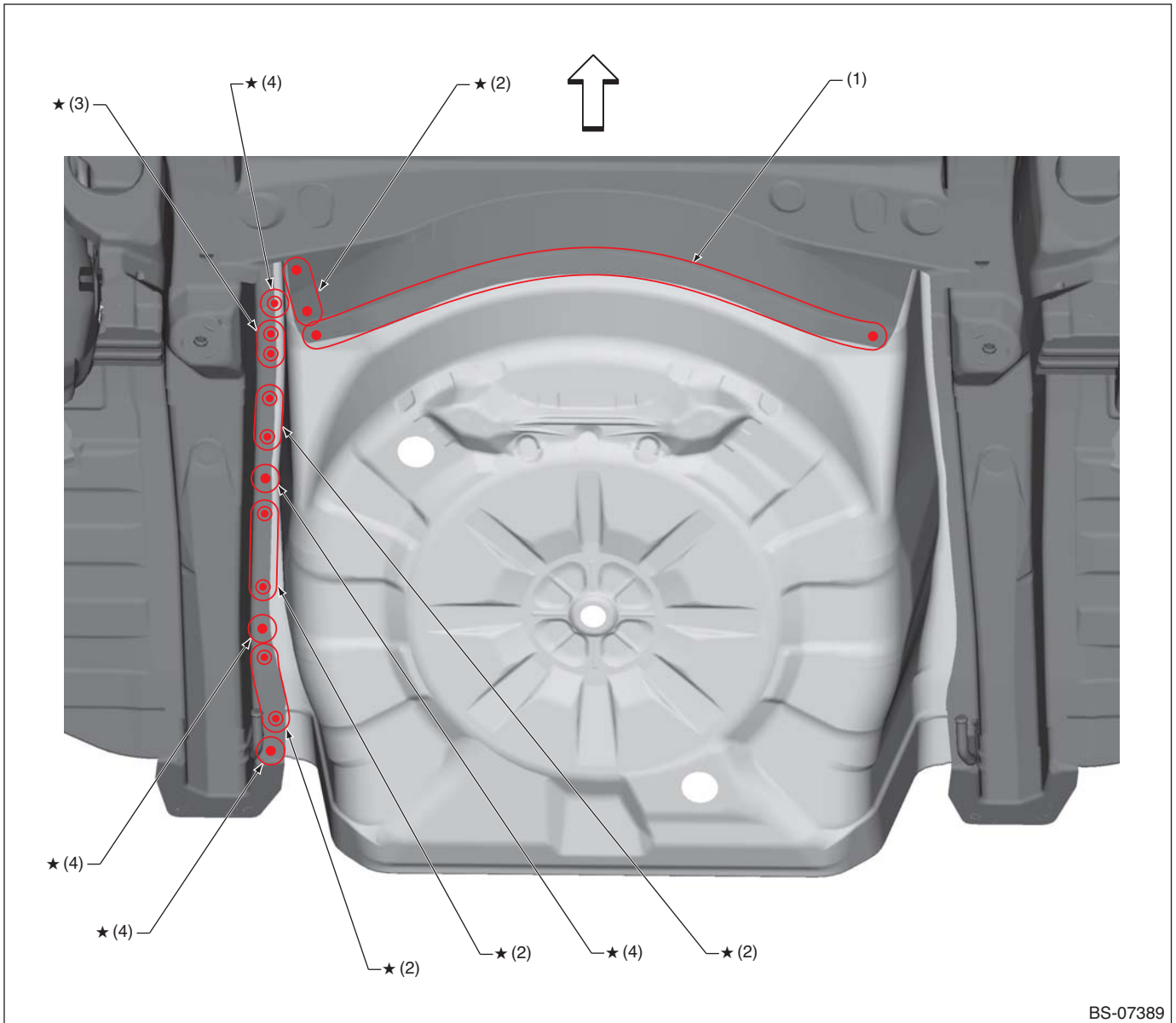
(1) 1 point

Panel Replacement

8-39. Rear Floor Pan (Total replacement)

A: REMOVAL

- Rear skirt removal condition



(1) 16 points

(2) 3 points

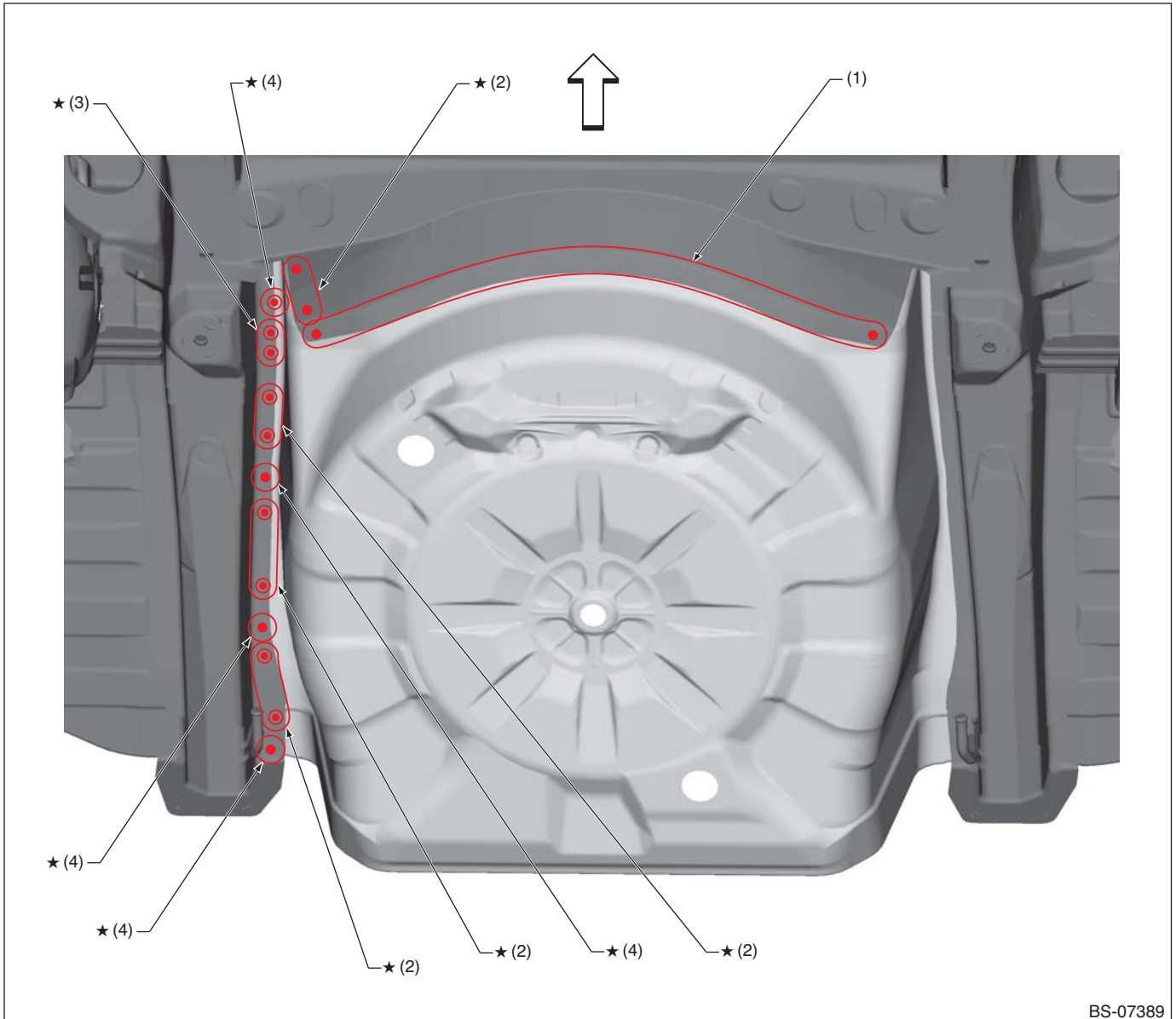
(3) 2 points

(4) 1 point

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

Panel Replacement

B: INSTALLATION



(1) 16 points
(2) 3 points

(3) 2 points

(4) 1 point

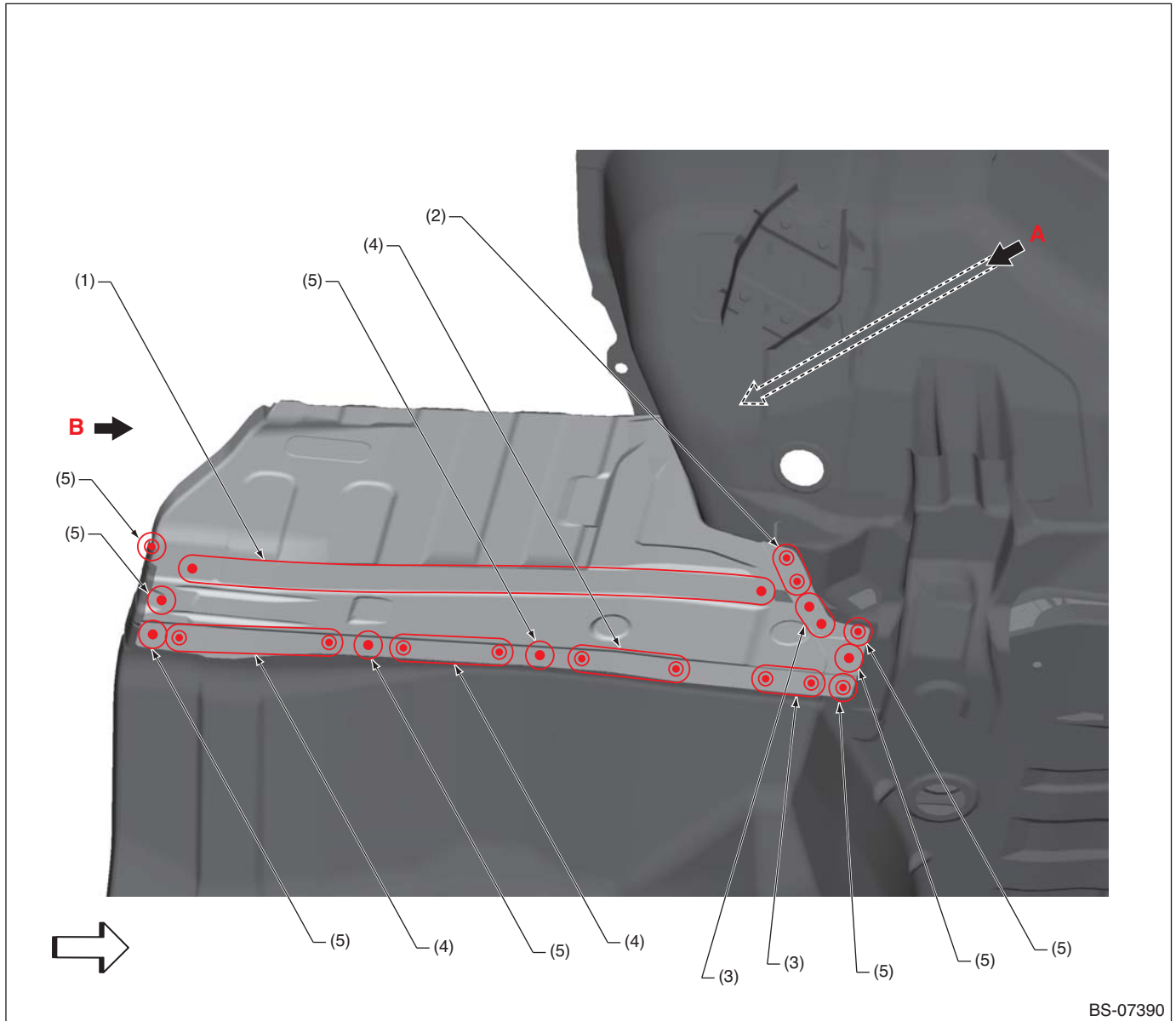
For locations marked by ★, the welding method and the number of welding points are the same on the left and the right.

Panel Replacement

8-40. Rear Floor Side (Total replacement)

A: REMOVAL

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



BS-07390

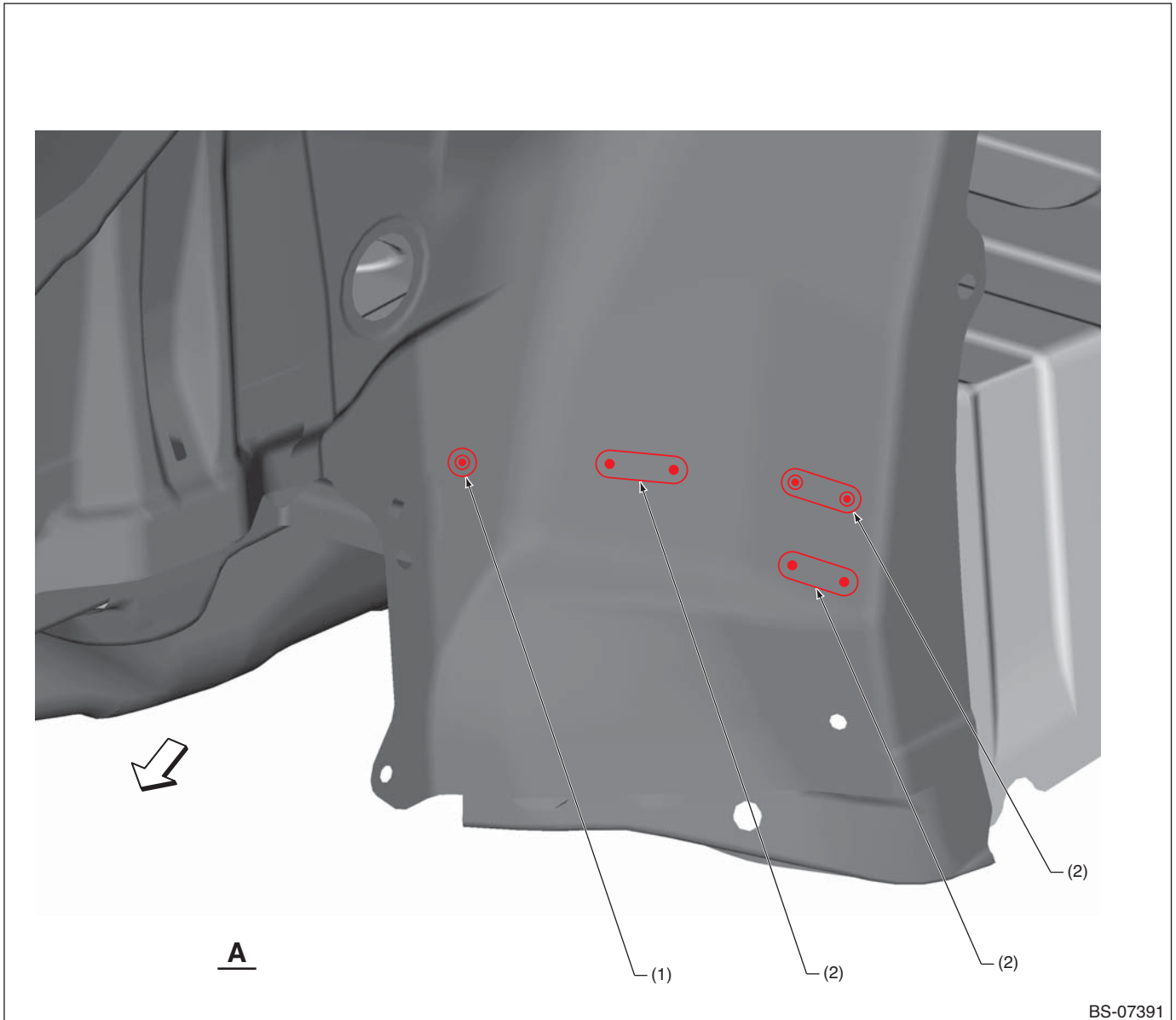
(1) 10 points
(2) 2 points (Only LH)
1 point (Only RH)

(3) 2 points
(4) 3 points

(5) 1 point

Panel Replacement

- View A

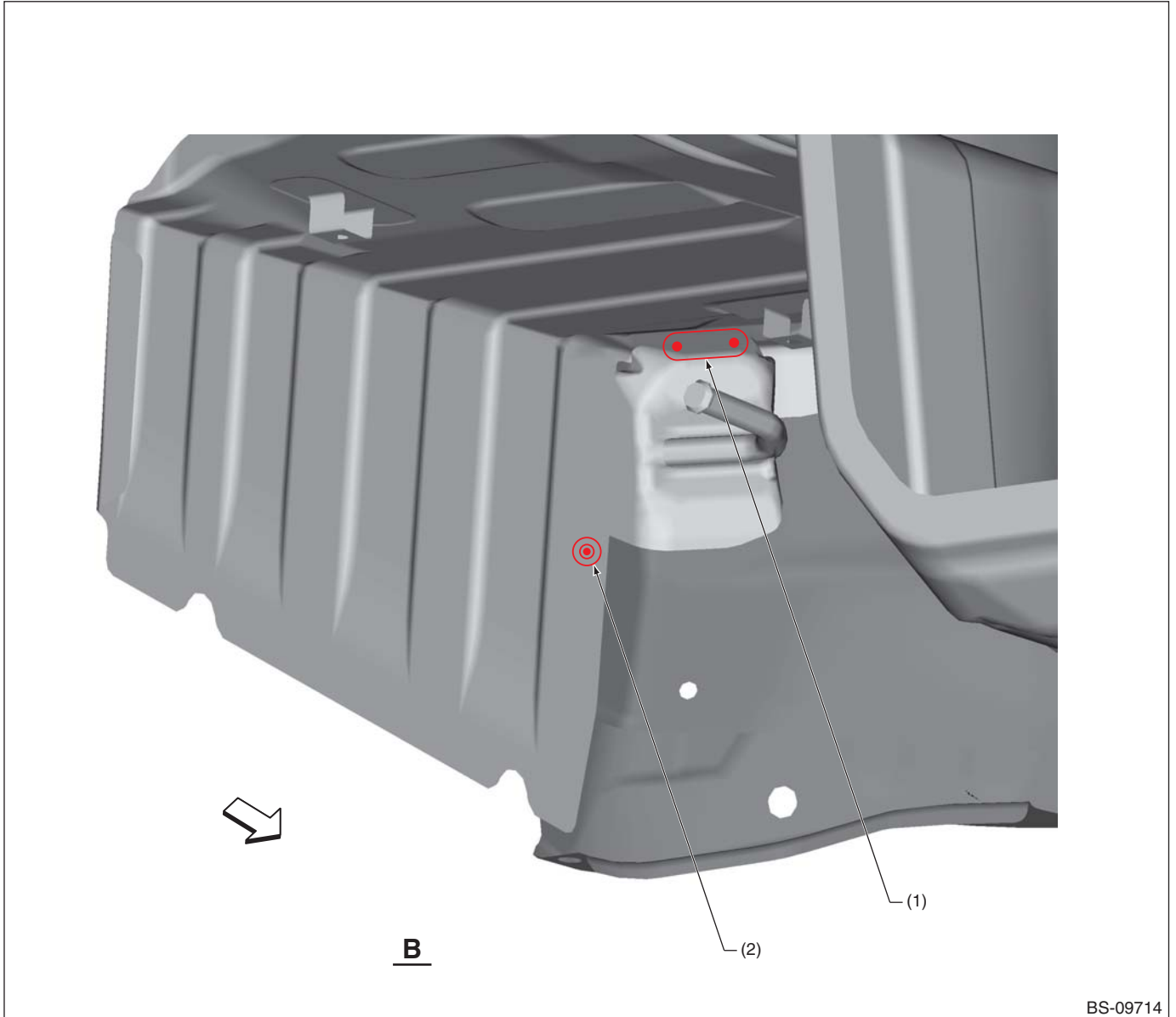


(1) 1 point

(2) 2 points

Panel Replacement

- View B



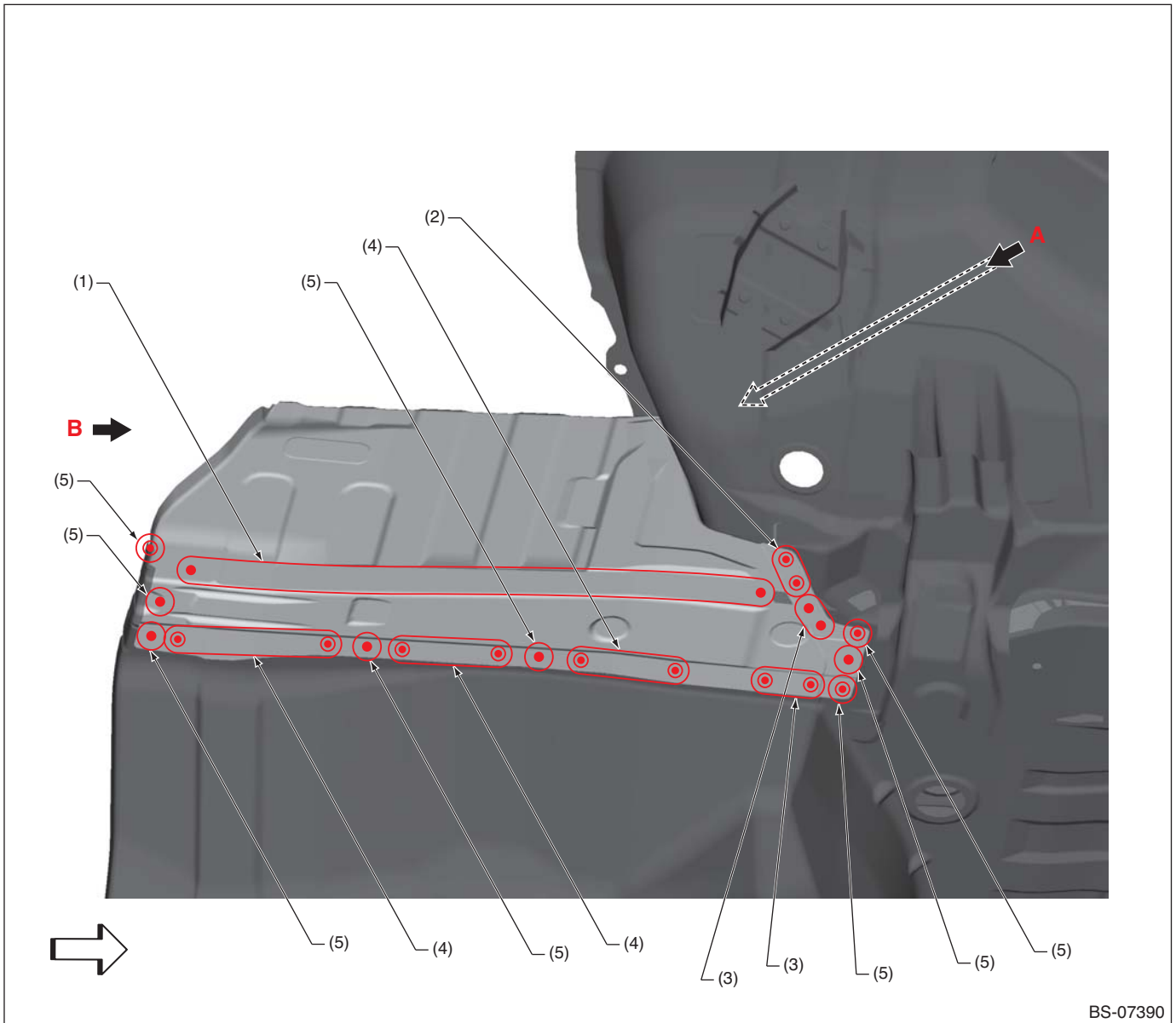
(1) 2 points

(2) 1 point

Panel Replacement

B: INSTALLATION

• Overall view



BS-07390

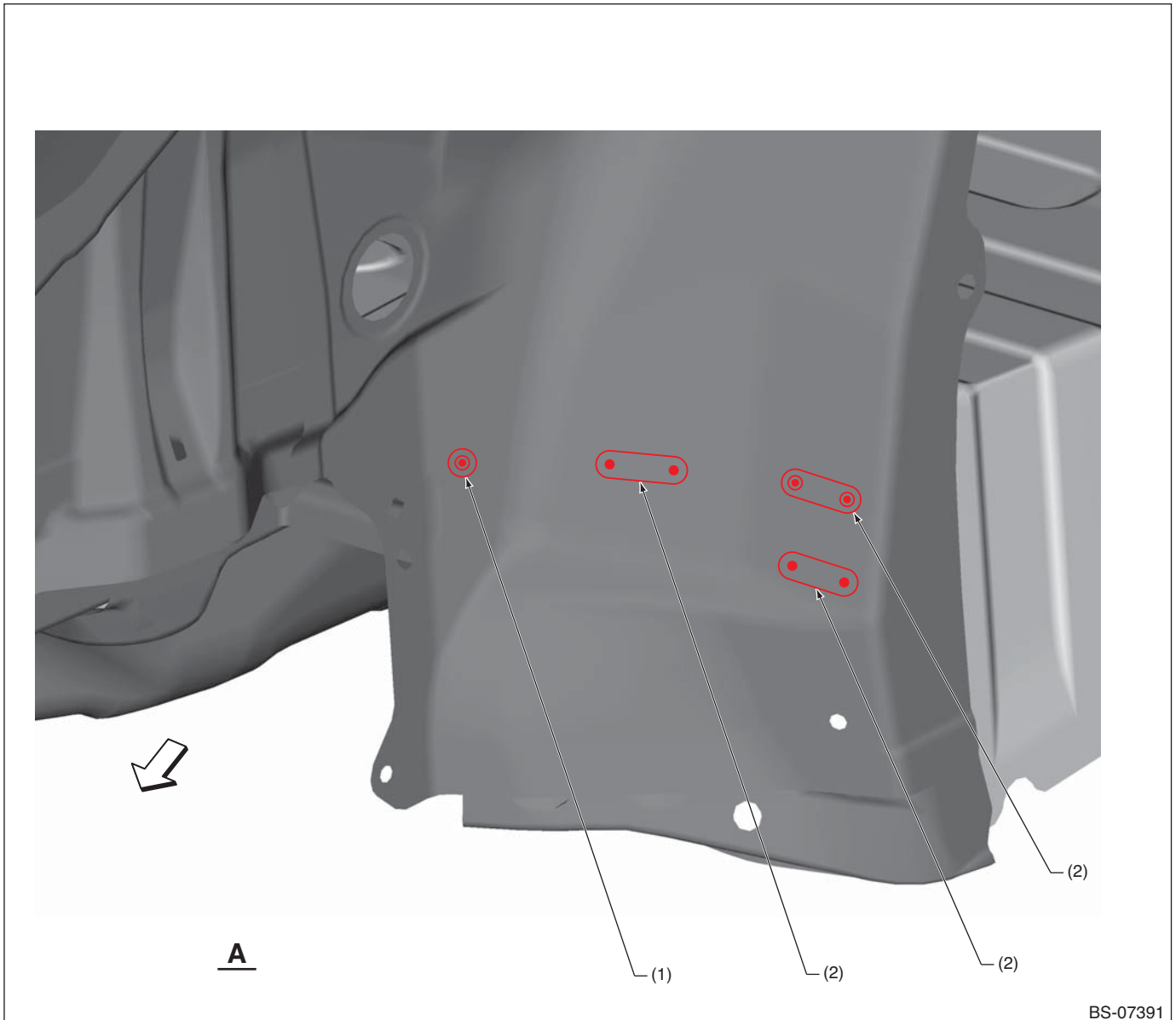
- (1) 10 points
- (2) 2 points (Only LH)
1 point (Only RH)

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

- (5) 1 point

Panel Replacement

- View A

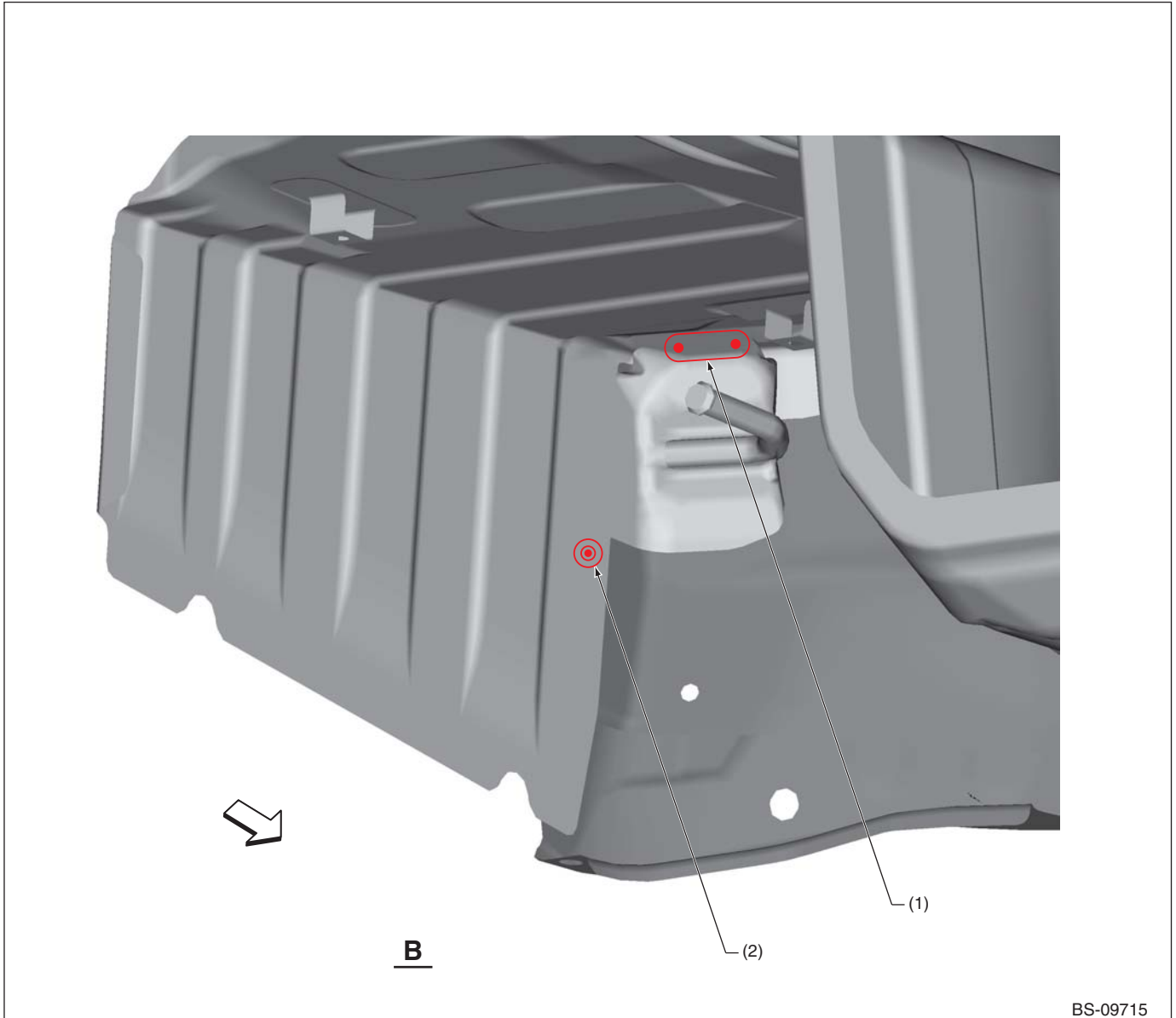


(1) 1 point

(2) 2 points

Panel Replacement

- View B



(1) 2 points

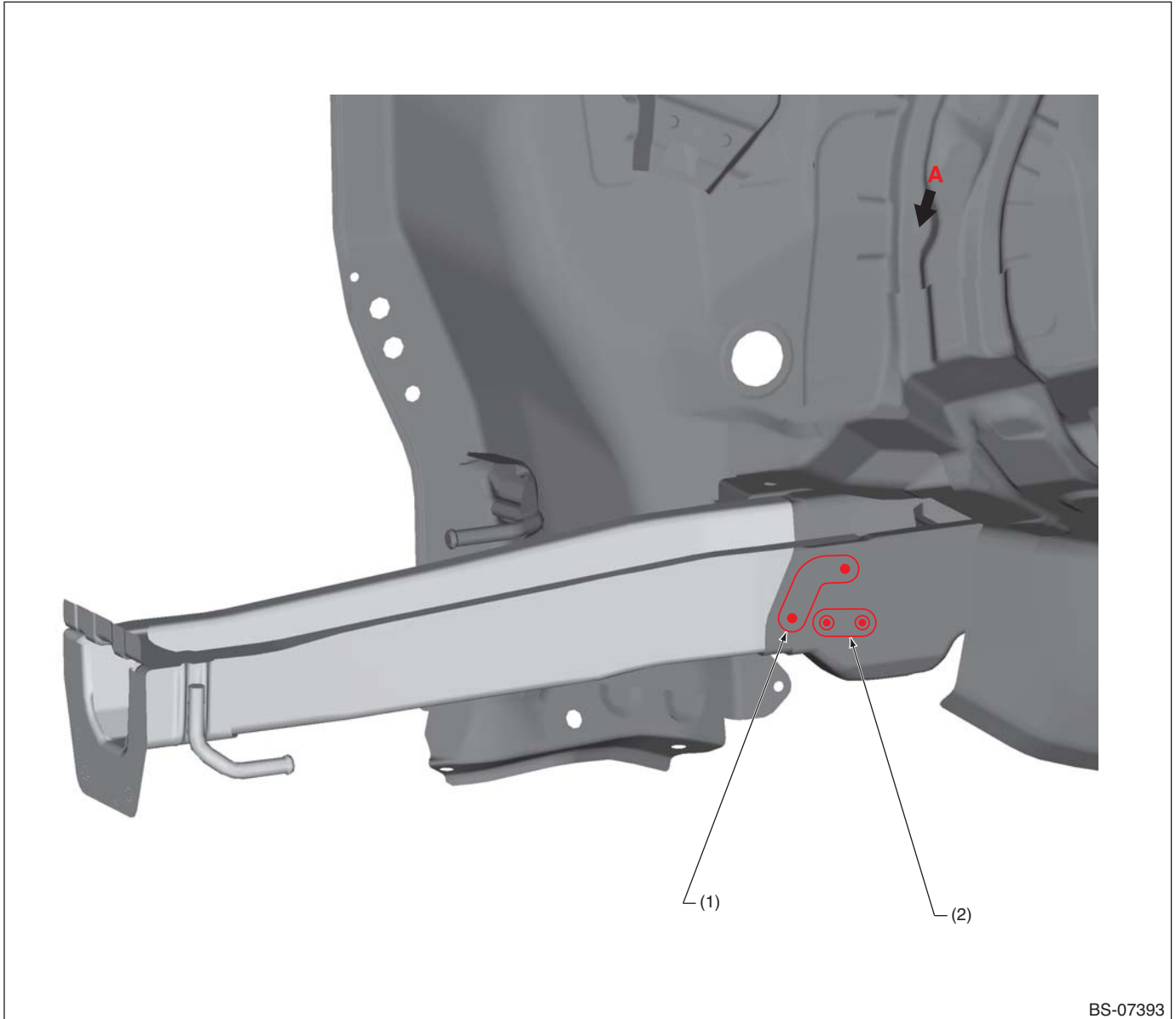
(2) 1 point

Panel Replacement

8-41. Rear Side Frame Rear (Total replacement)

A: REMOVAL

- Overall view (Rear skirt, rear floor side and rear floor pan removal condition)



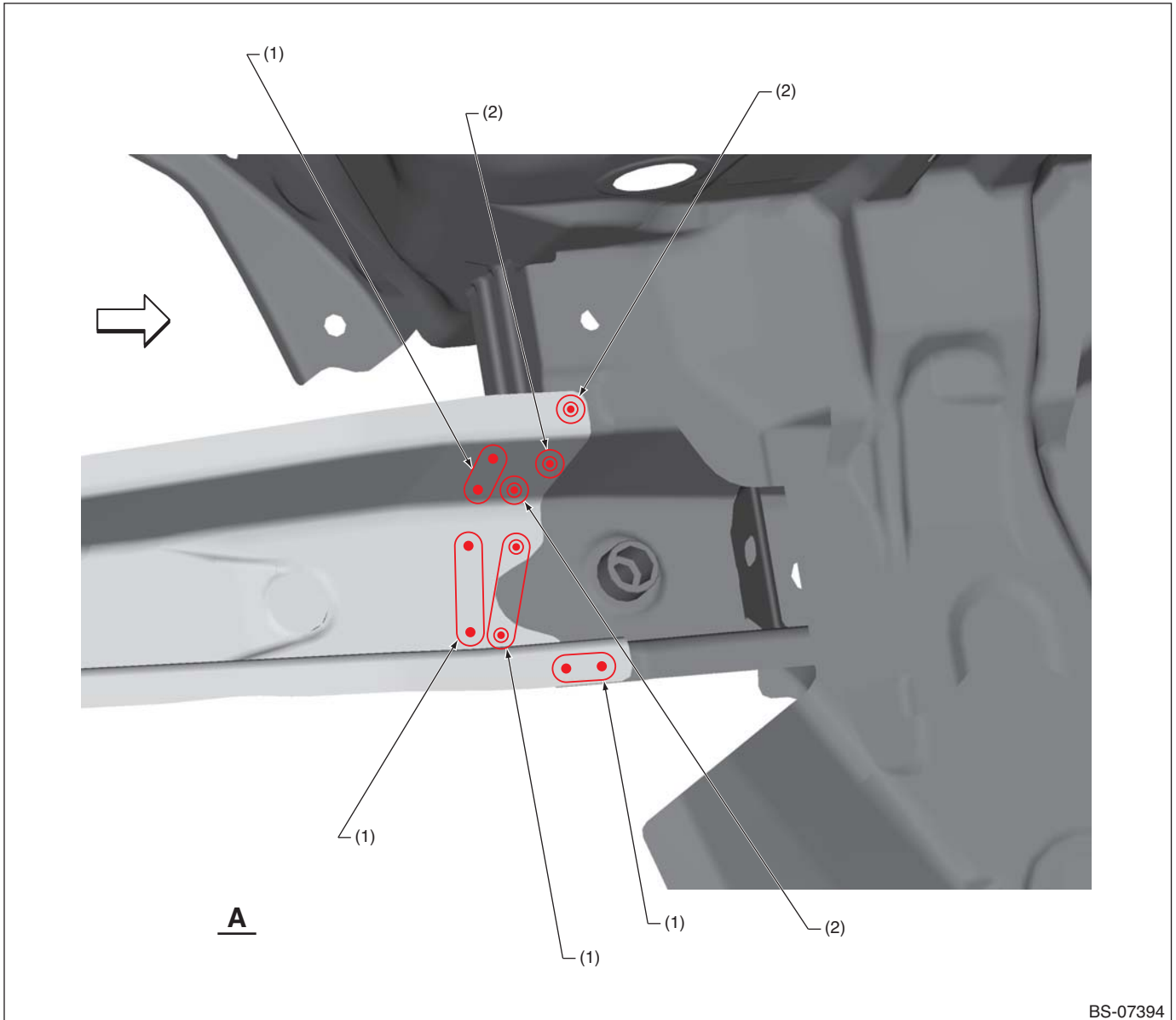
BS-07393

(1) 3 points

(2) 2 points

Panel Replacement

- View A



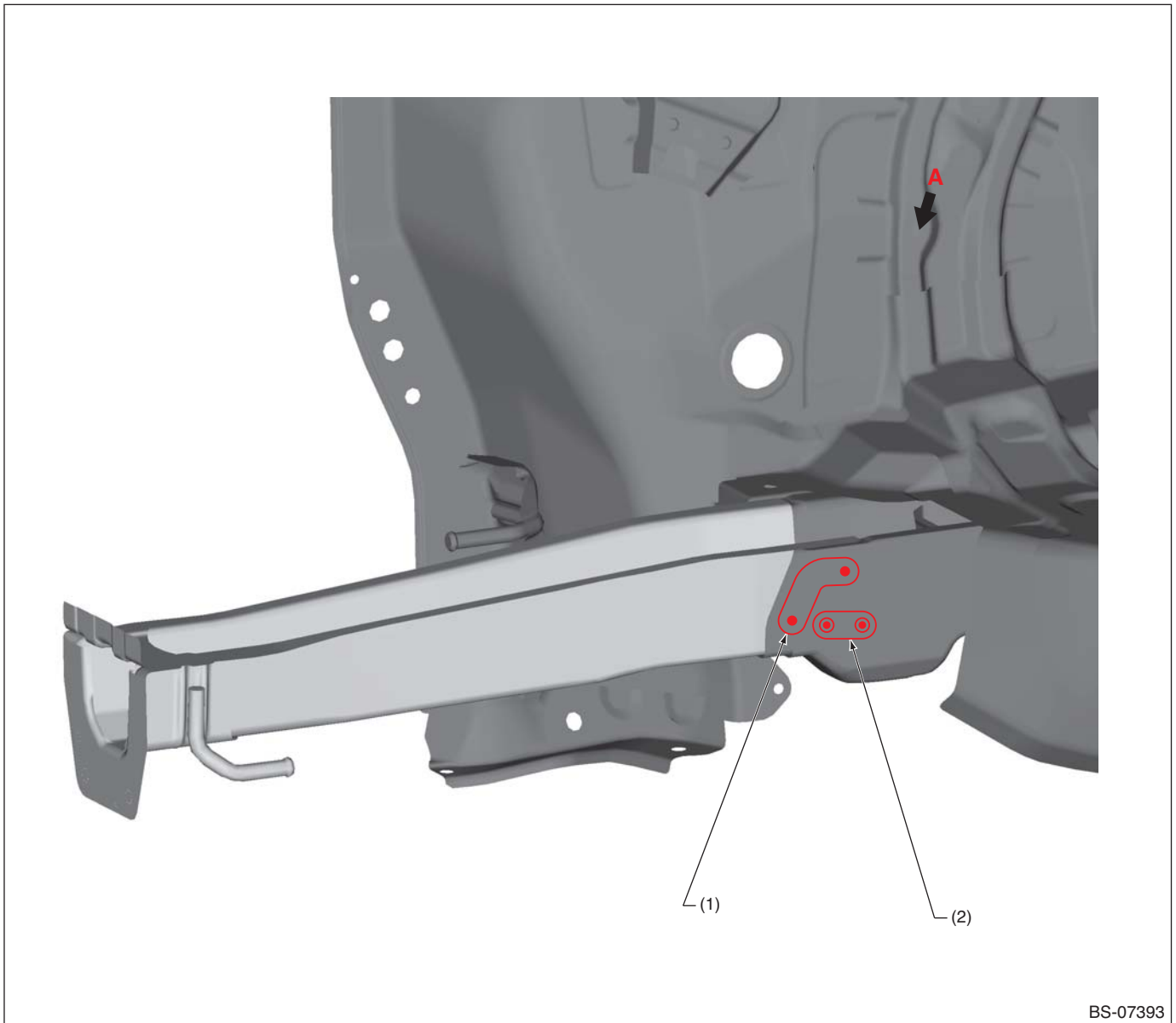
(1) 2 points

(2) 1 point

Panel Replacement

B: INSTALLATION

- Overall view



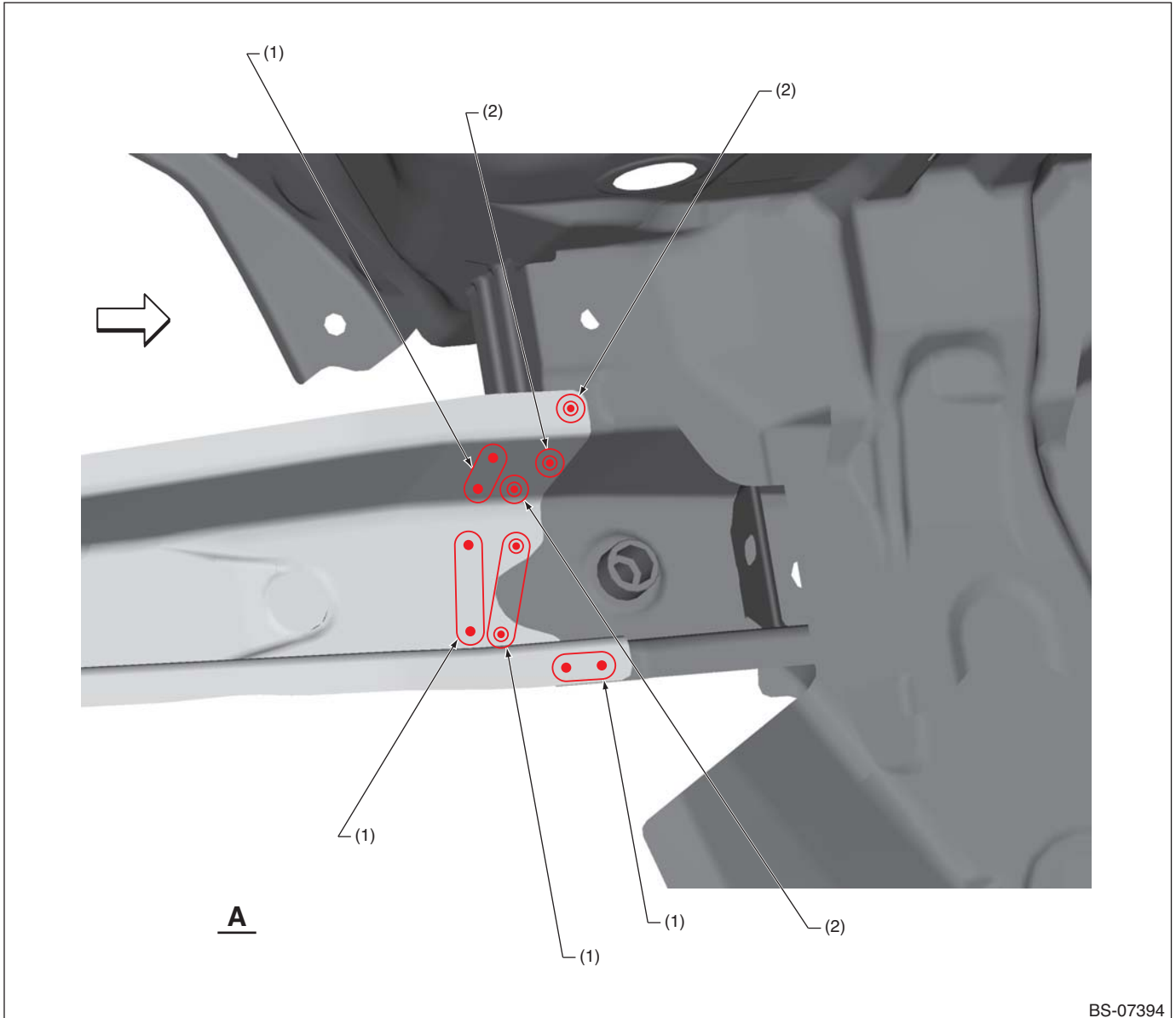
BS-07393

(1) 3 points

(2) 2 points

Panel Replacement

- View A



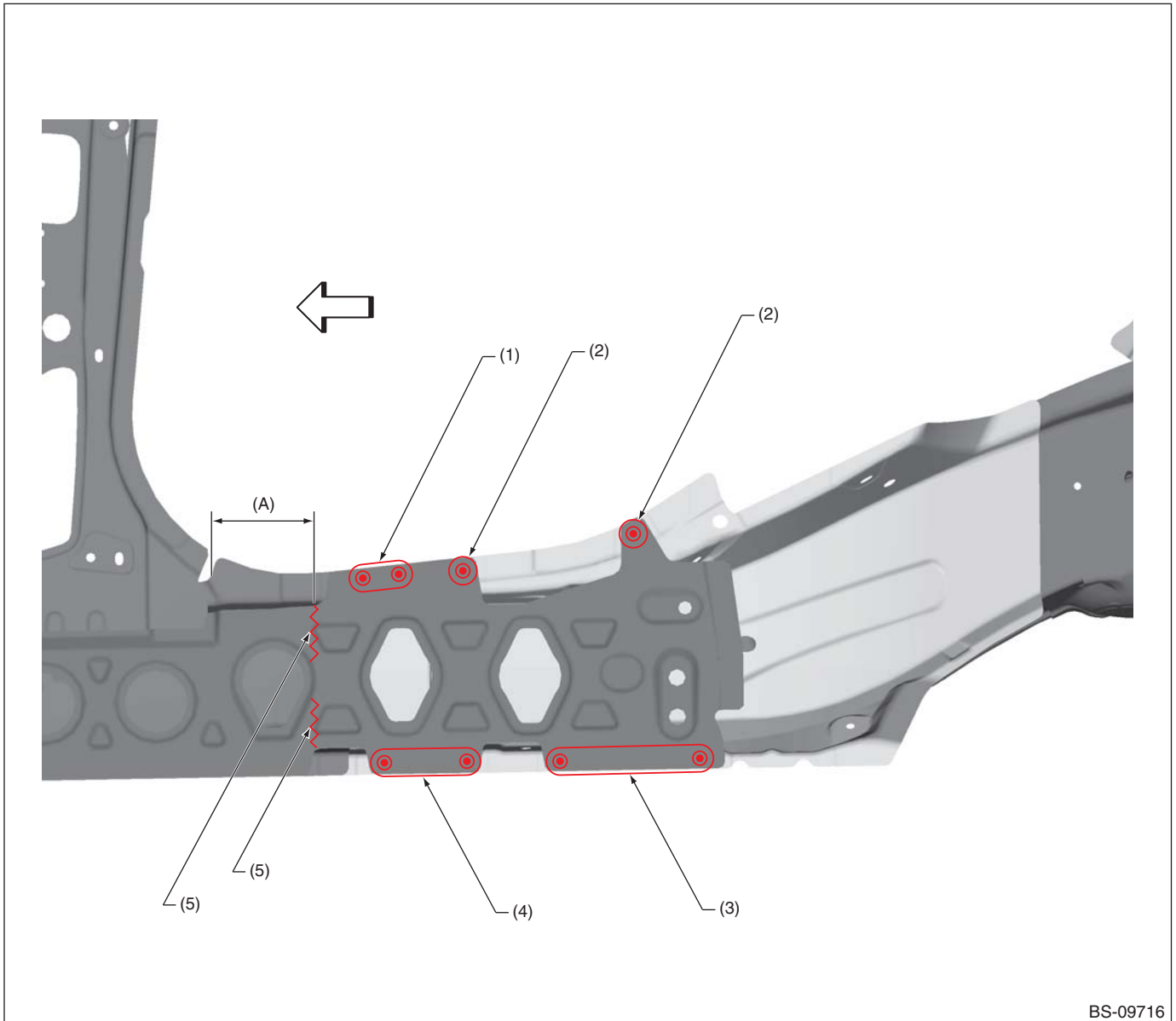
(1) 2 points

(2) 1 point

8-42. Side Sill Inner Rear (Total replacement)

A: REMOVAL

- Overall view 1 (Rear quarter outer & inner and side sill reinforcement outer removal condition)



BS-09716

(A) 60 mm (2.36 in)

(1) 2 points

(2) 1 point

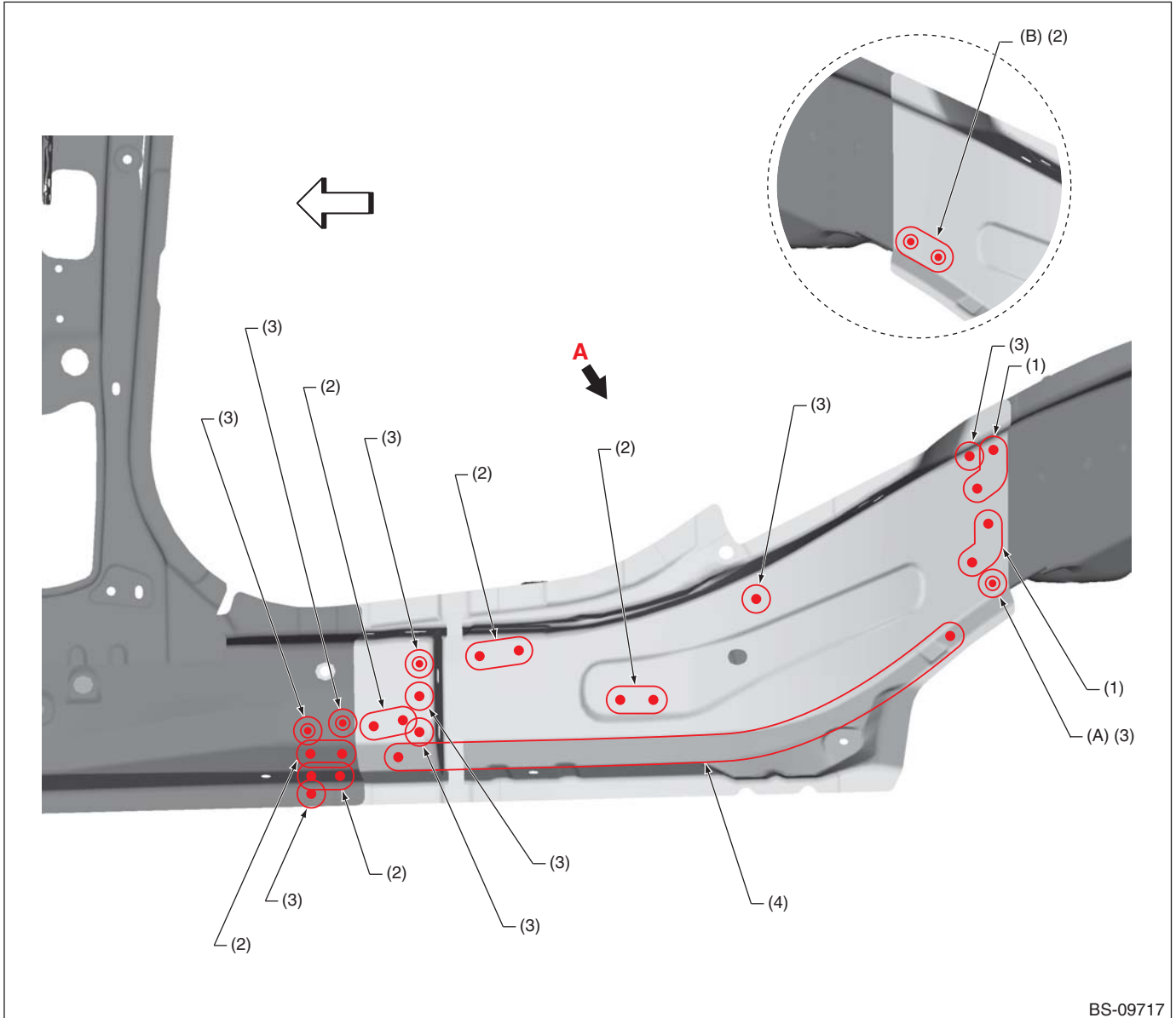
(3) 4 points

(4) 3 points

(5) Cut position

Panel Replacement

- Overall view 2 (Rear quarter outer & inner and side sill reinforcement outer removal condition)



(A) Only LH

(B) Only RH

(1) 3 points

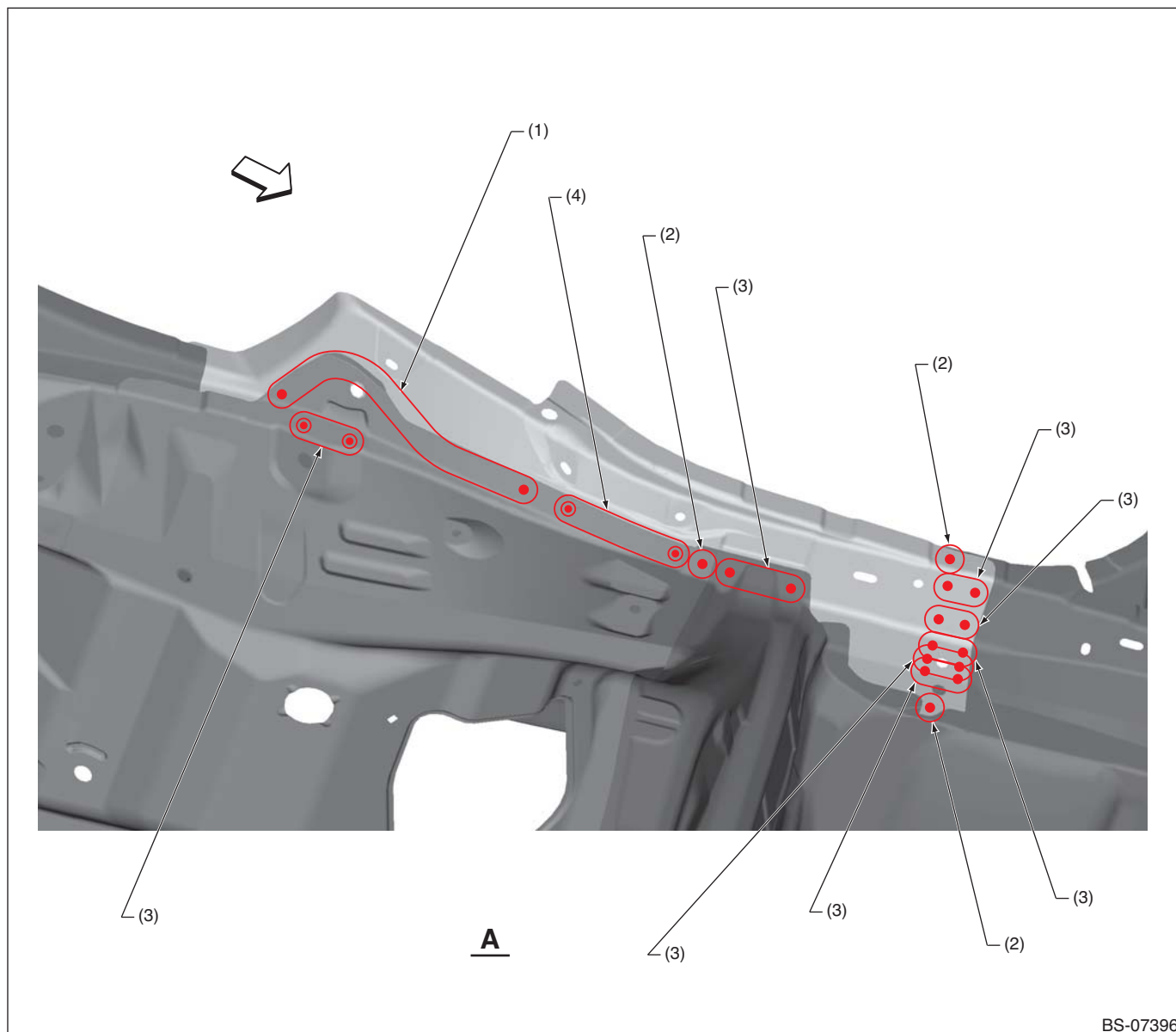
(3) 1 point

(4) 13 points

(2) 2 points

Panel Replacement

• View A



(1) 6 points
(2) 1 point

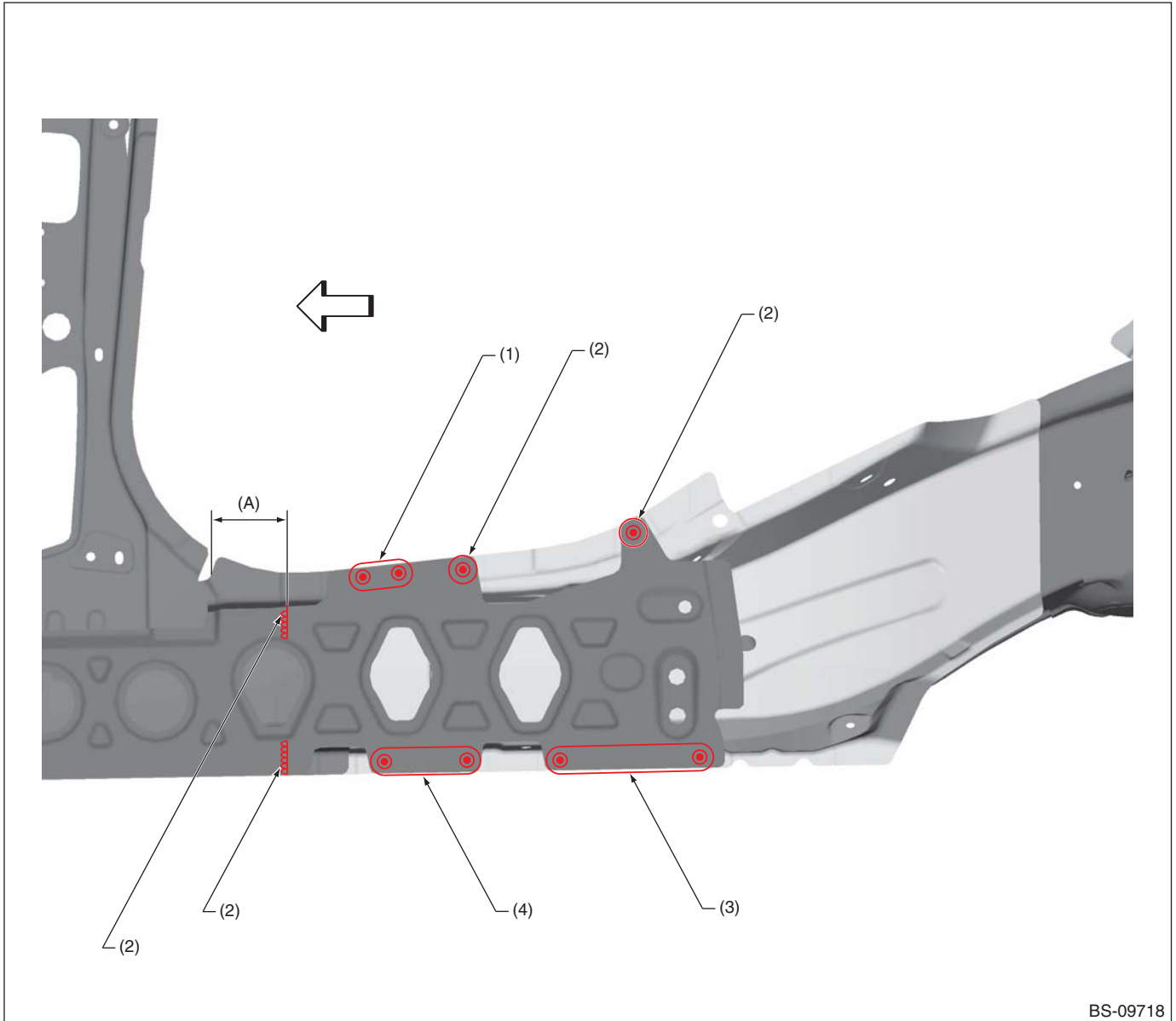
(3) 2 points

(4) 3 points

Panel Replacement

B: INSTALLATION

- Overall view 1



(A) 40 mm (1.57 in)

(1) 2 points

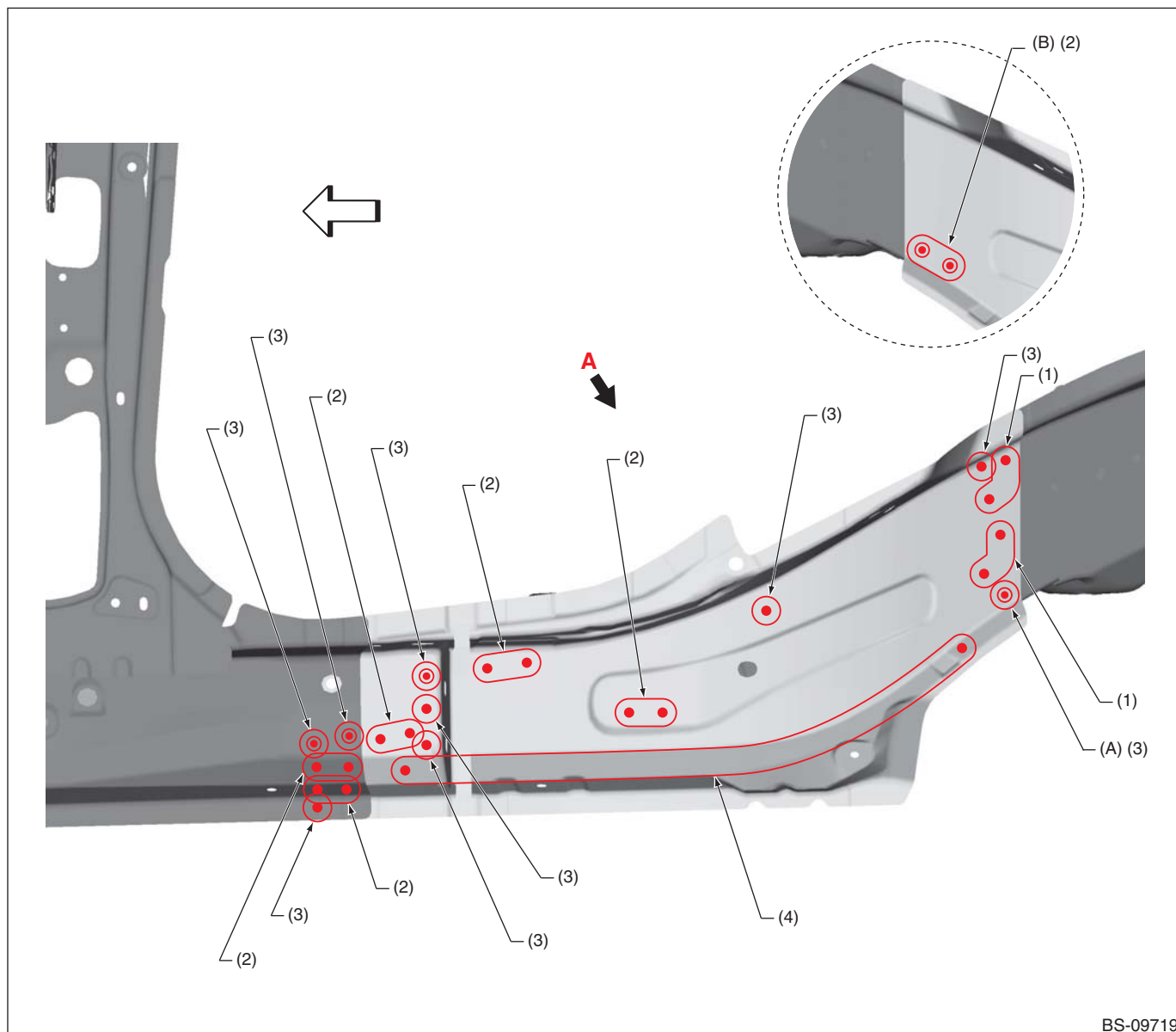
(2) 1 point

(3) 4 points

(4) 3 points

Panel Replacement

- Overall view 2



BS-09719

(A) Only LH

(B) Only RH

(1) 3 points

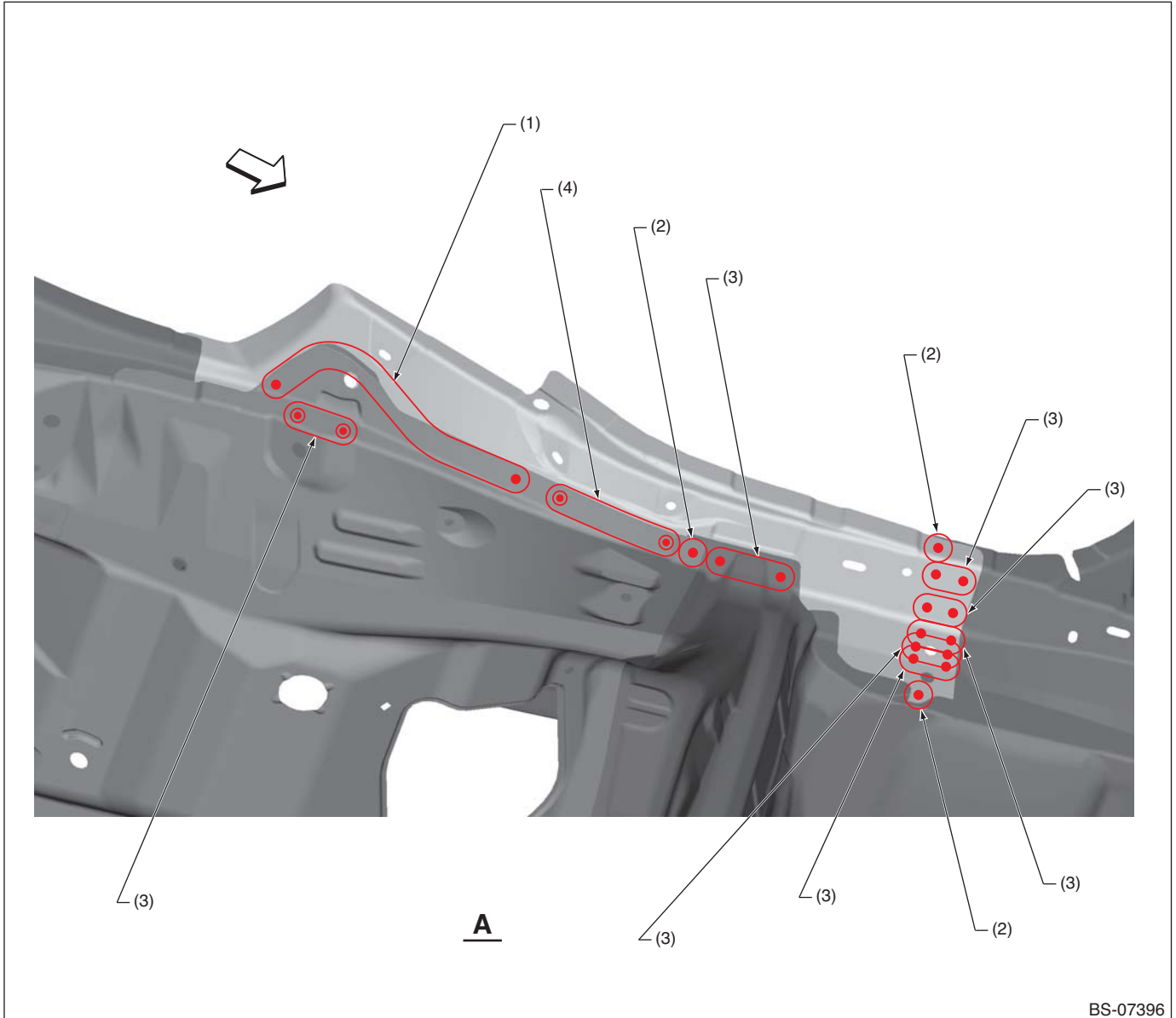
(3) 1 point

(4) 13 points

(2) 2 points

Panel Replacement

- View A



(1) 6 points
(2) 1 point

(3) 2 points

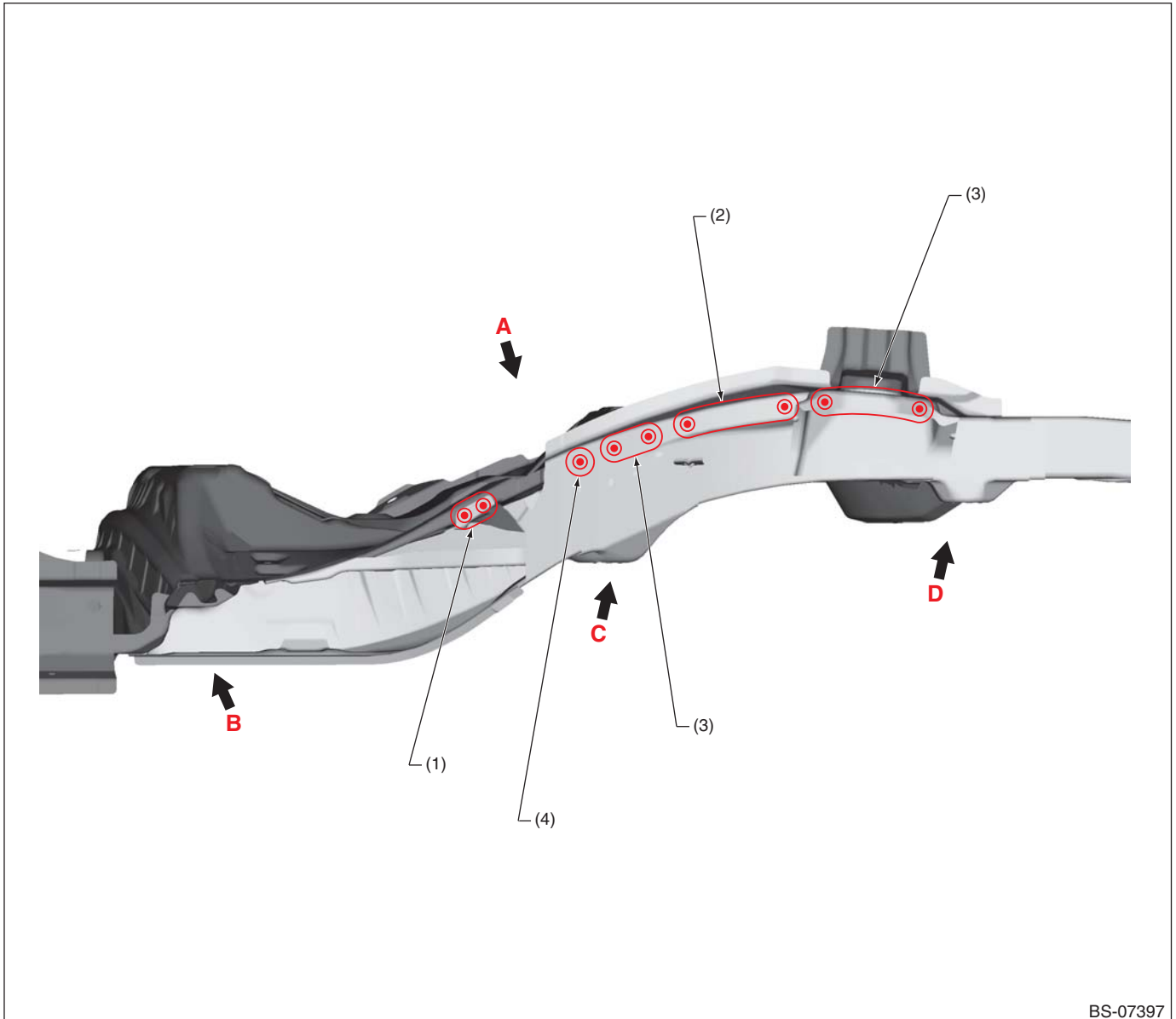
(4) 3 points

Panel Replacement

8-43. Rear Floor Side Frame (Total replacement)

A: REMOVAL

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



BS-07397

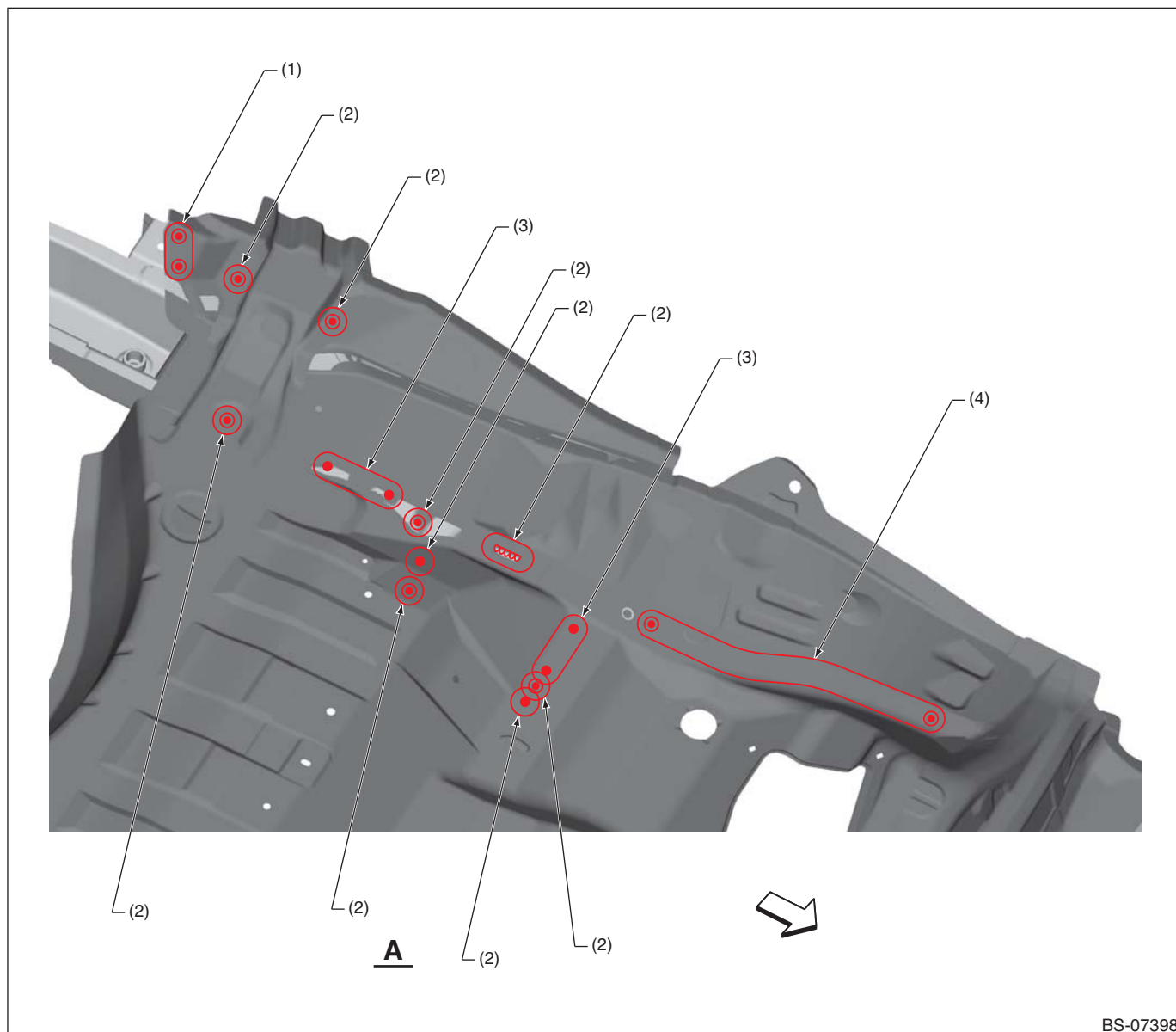
(1) 2 points
(2) 4 points

(3) 3 points

(4) 1 point

Panel Replacement

• View A



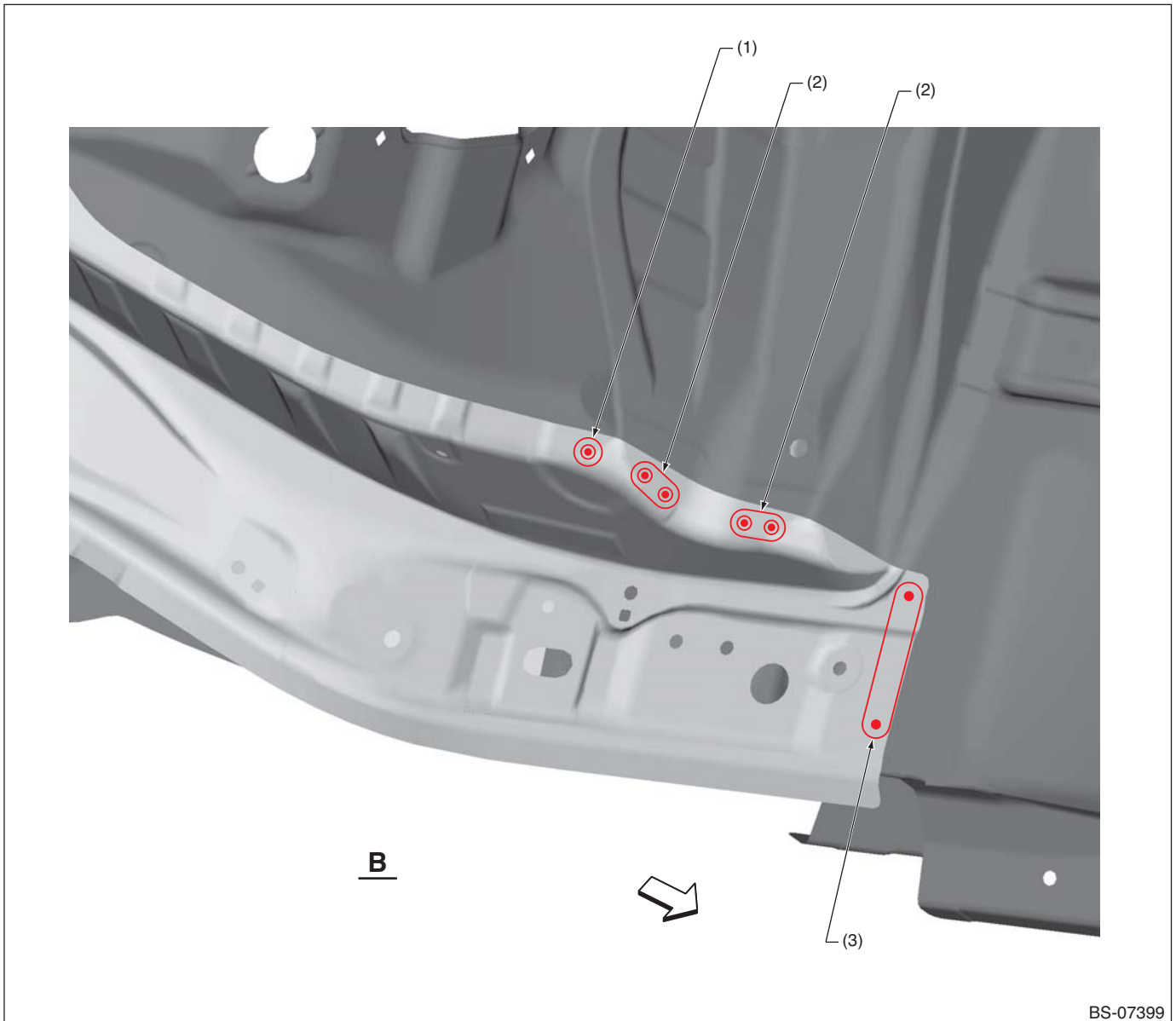
- (1) 2 points (Only LH)
1 point (Only RH)
- (2) 1 point

- (3) 3 points

- (4) 8 points

Panel Replacement

- View B



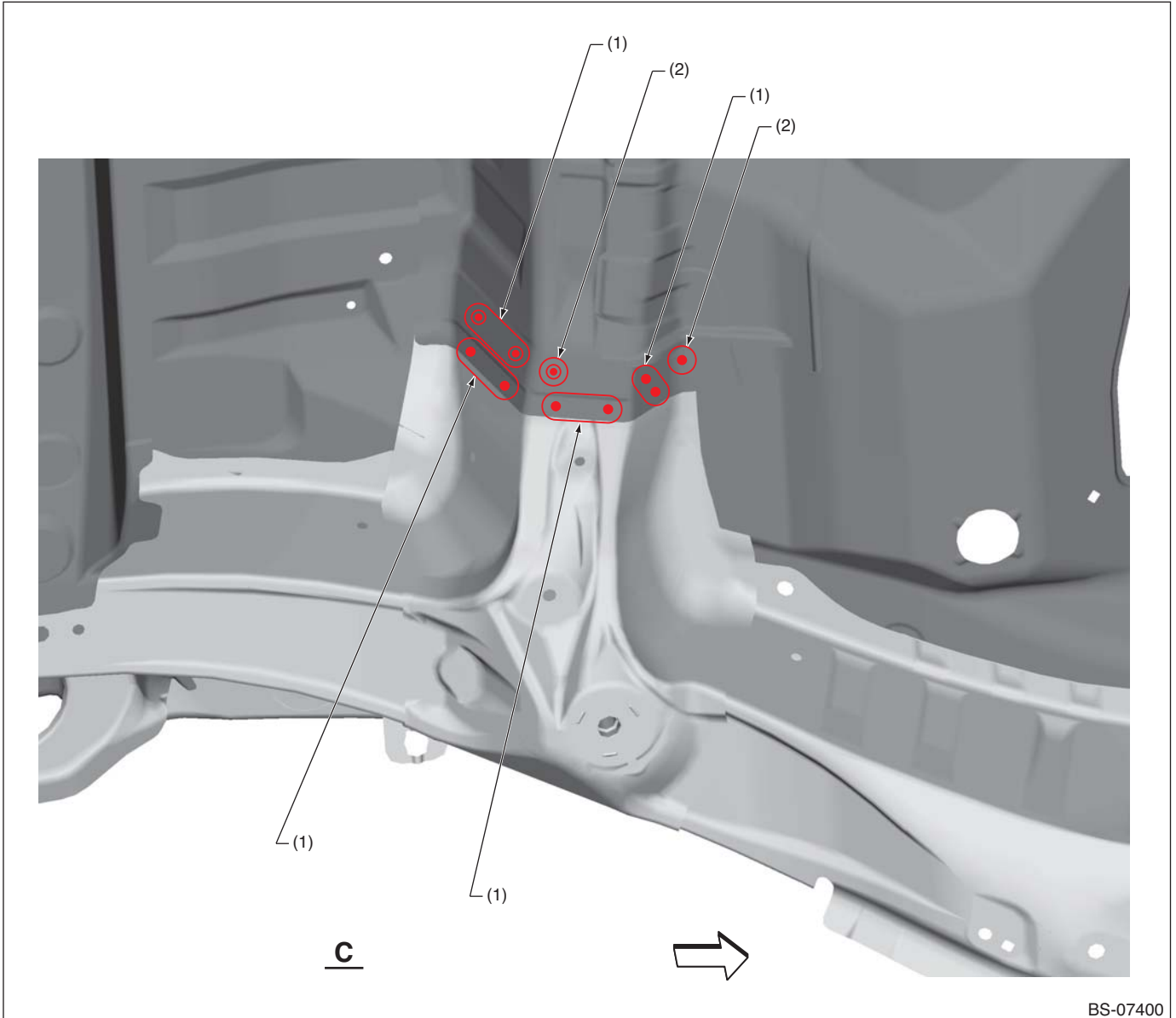
(1) 1 point

(2) 2 points

(3) 3 points

Panel Replacement

- View C



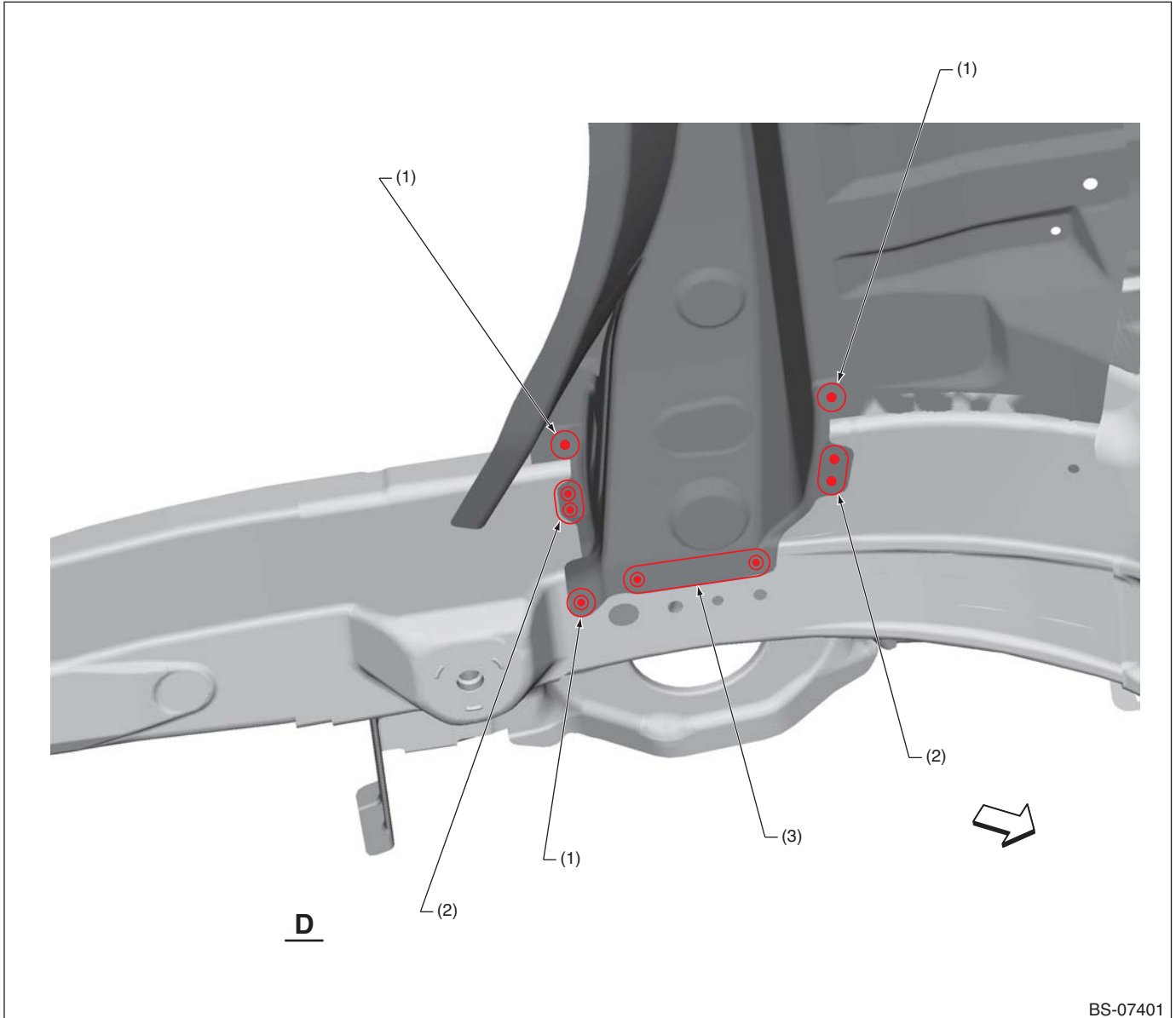
BS-07400

(1) 2 points

(2) 1 point

Panel Replacement

- View D



(1) 1 point

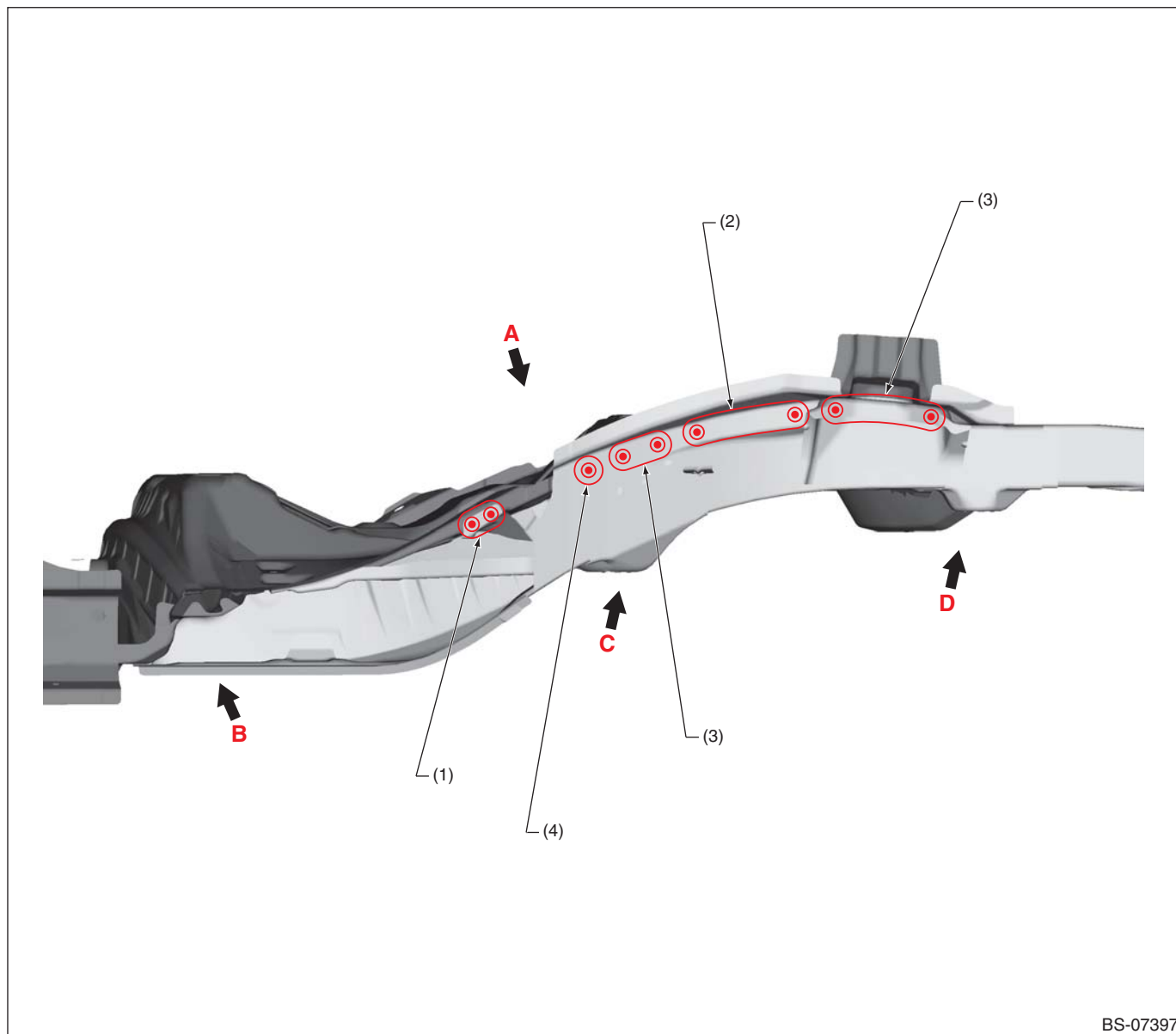
(2) 2 points

(3) 4 points

Panel Replacement

B: INSTALLATION

- Overall view



BS-07397

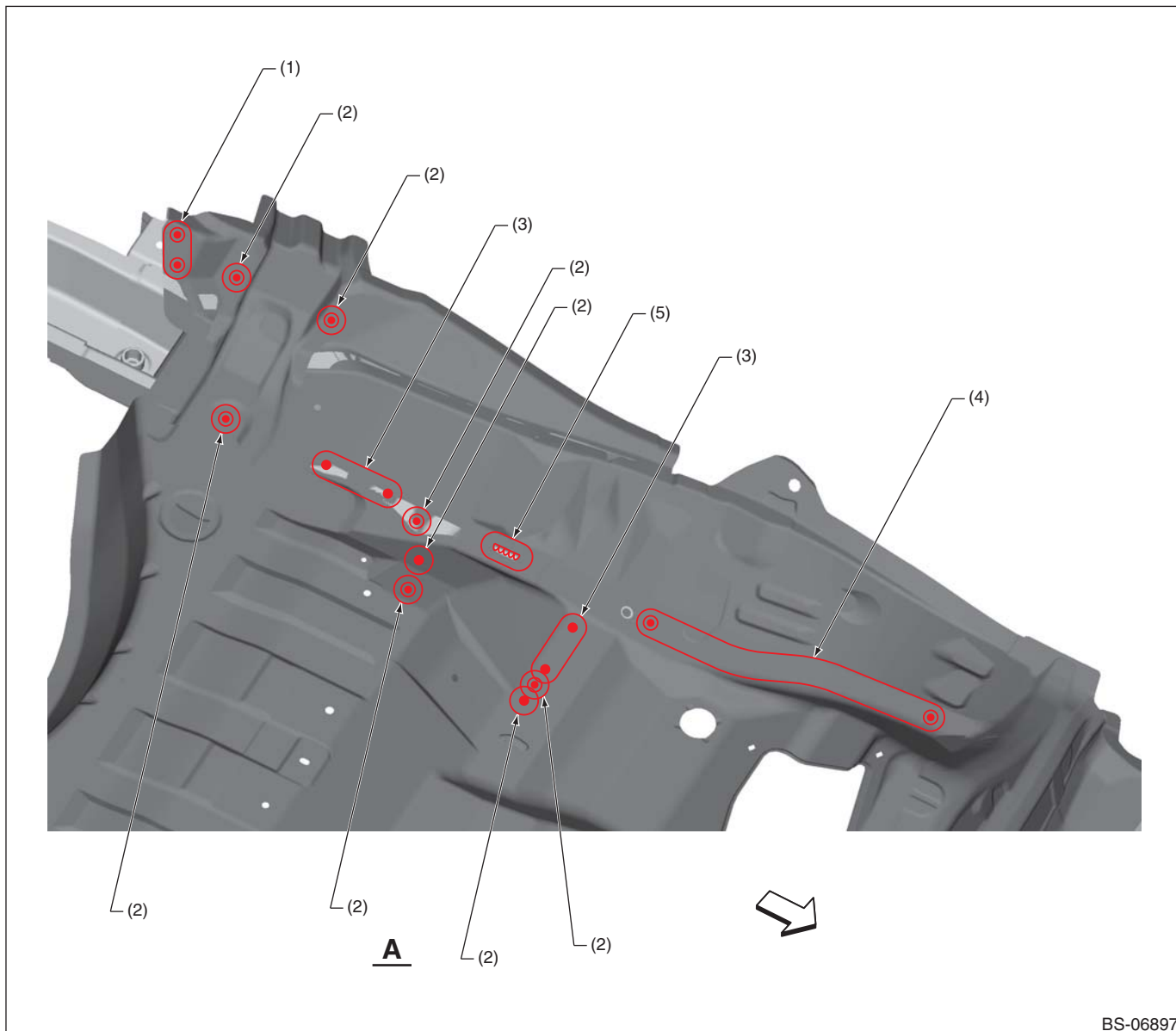
(1) 2 points
(2) 4 points

(3) 3 points

(4) 1 point

Panel Replacement

• View A



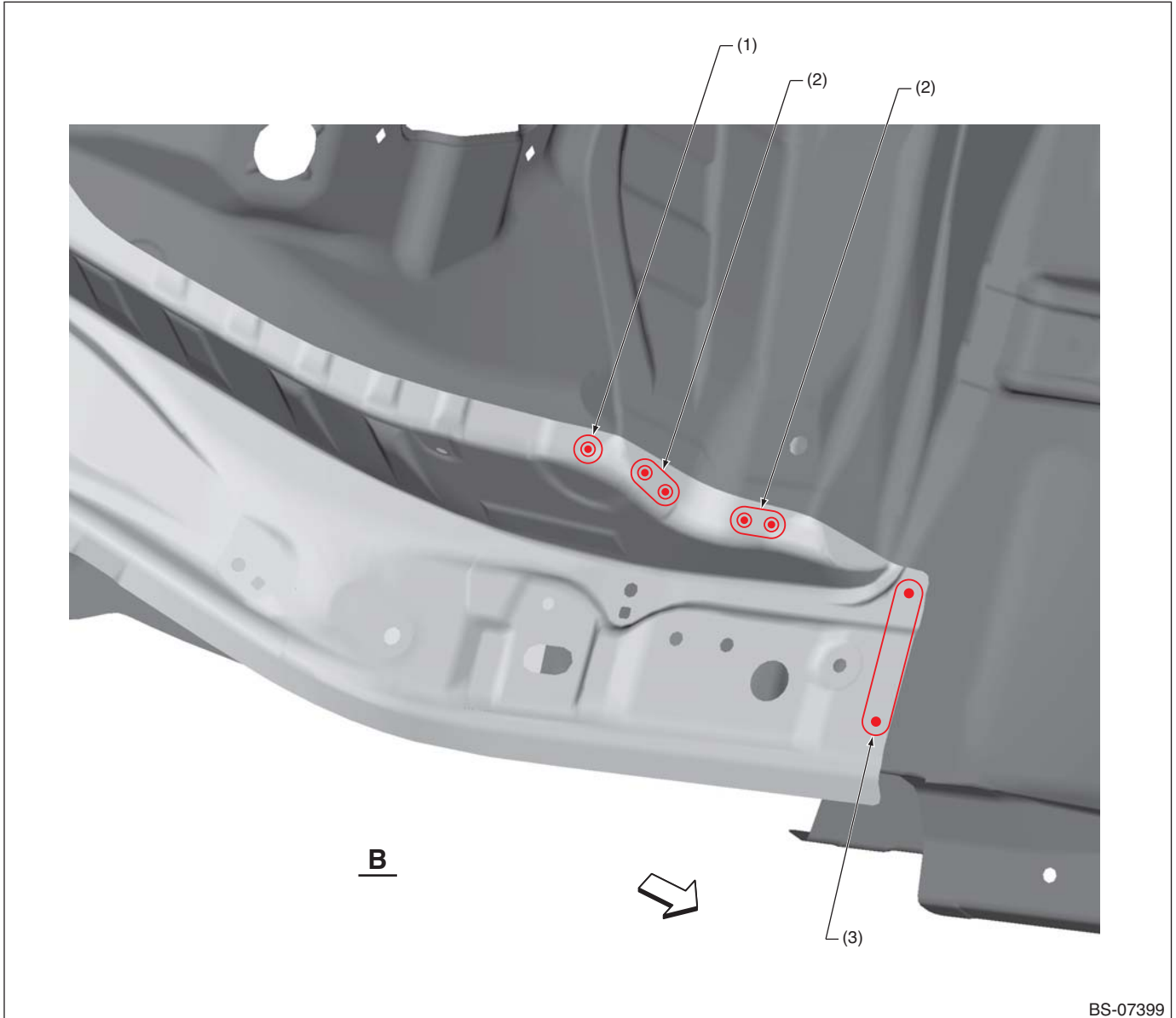
- (1) 2 points (Only LH)
1 point (Only RH)
- (2) 1 point

- (3) 3 points
- (4) 8 points

- (5) 1 point [30 mm (1.18 in)]

Panel Replacement

- View B



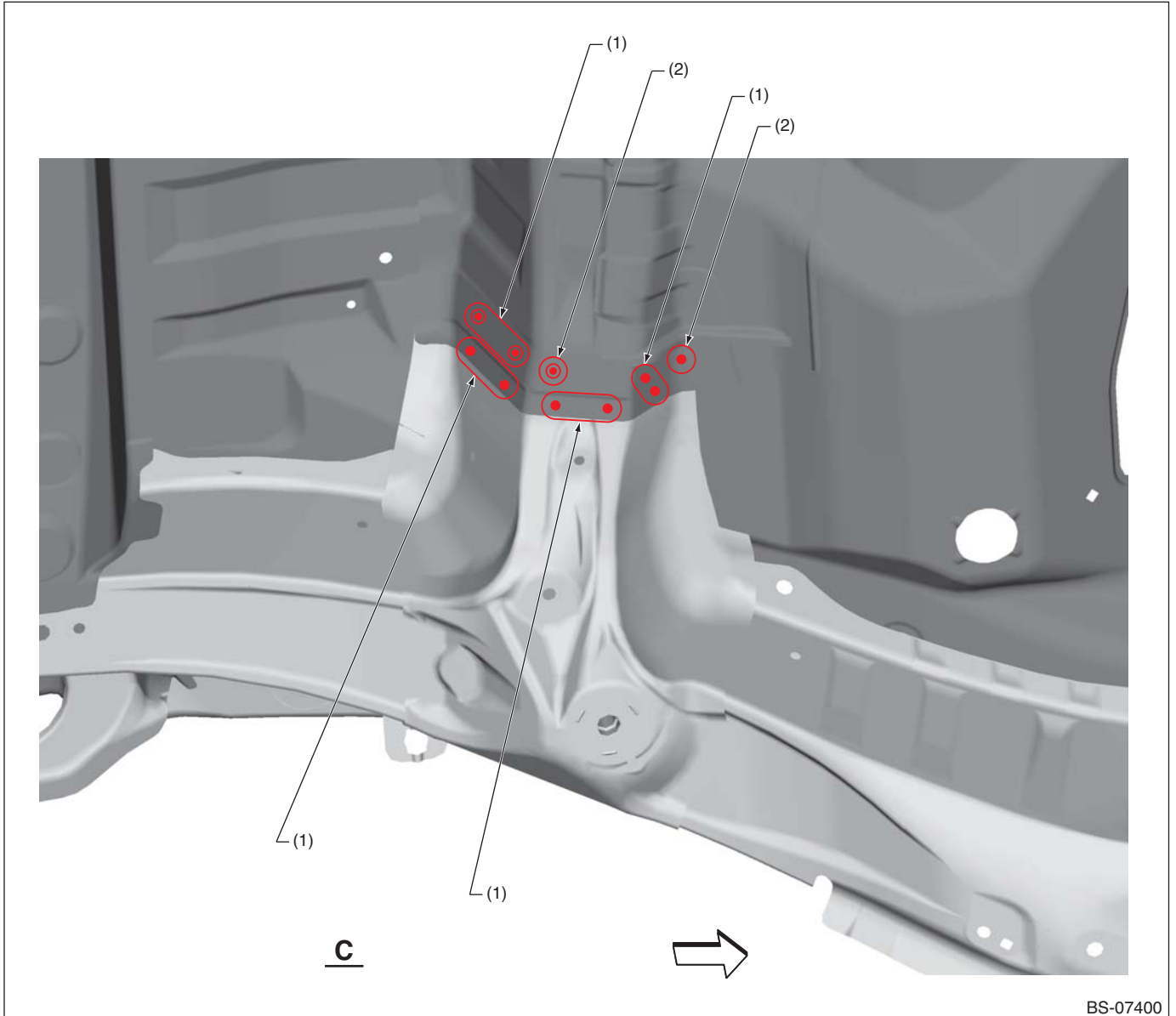
(1) 1 point

(2) 2 points

(3) 3 points

Panel Replacement

- View C



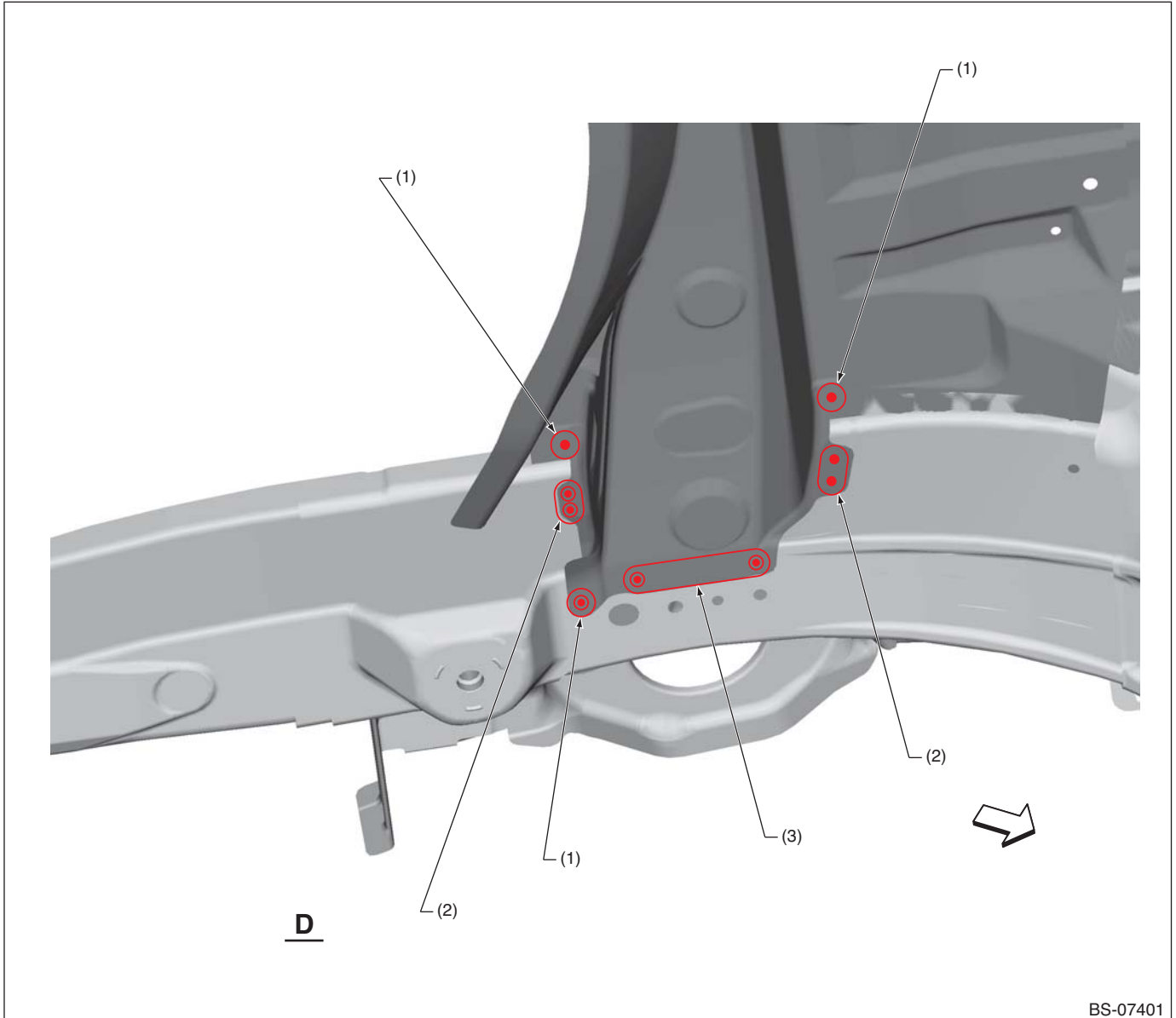
BS-07400

(1) 2 points

(2) 1 point

Panel Replacement

- View D



(1) 1 point

(2) 2 points

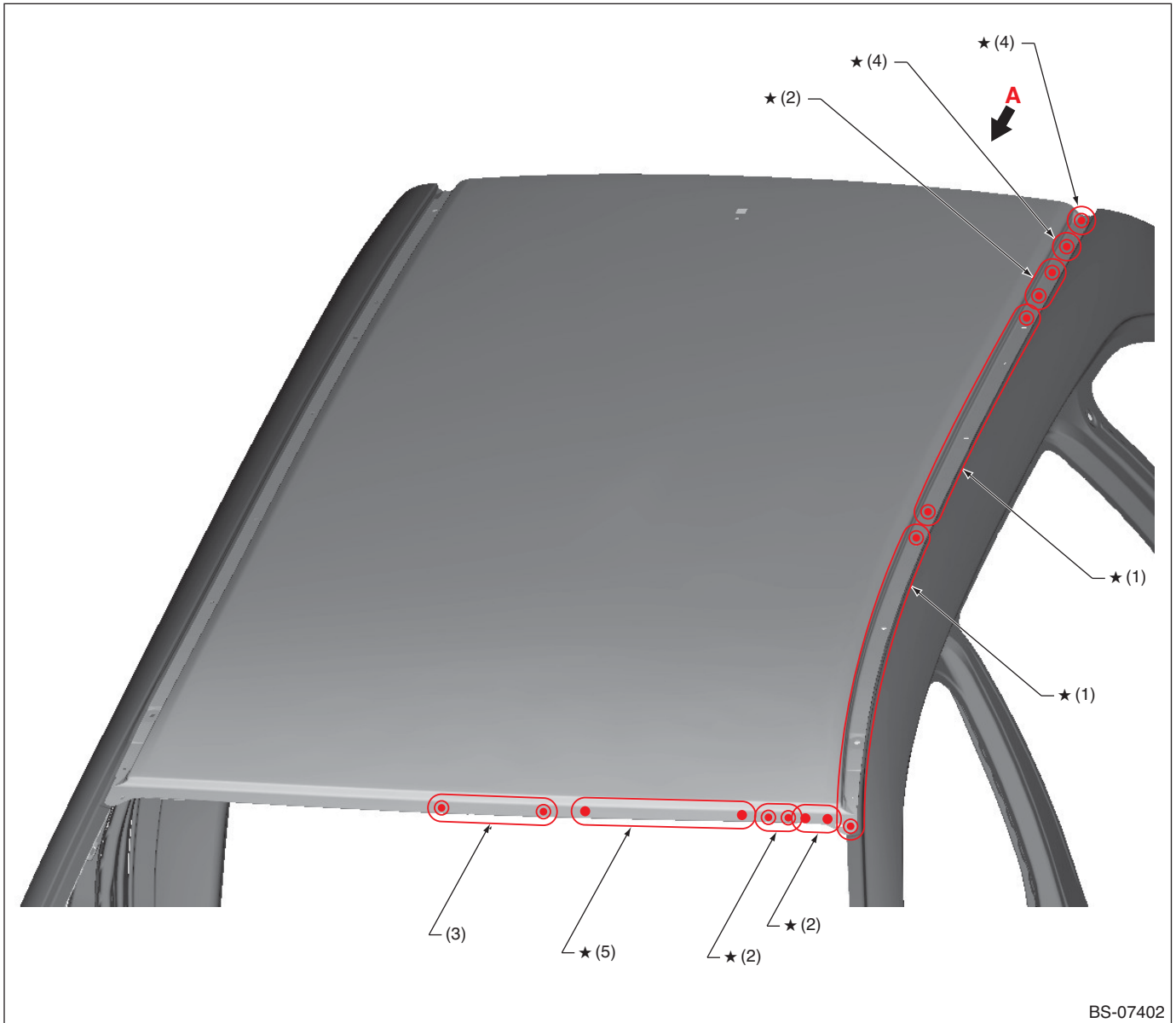
(3) 4 points

Panel Replacement

8-44. Roof Panel (Total replacement)/OUTBACK

A: REMOVAL

- Overall view 1 (Model without sunroof)



(1) 10 points

(2) 2 points

(3) 4 points

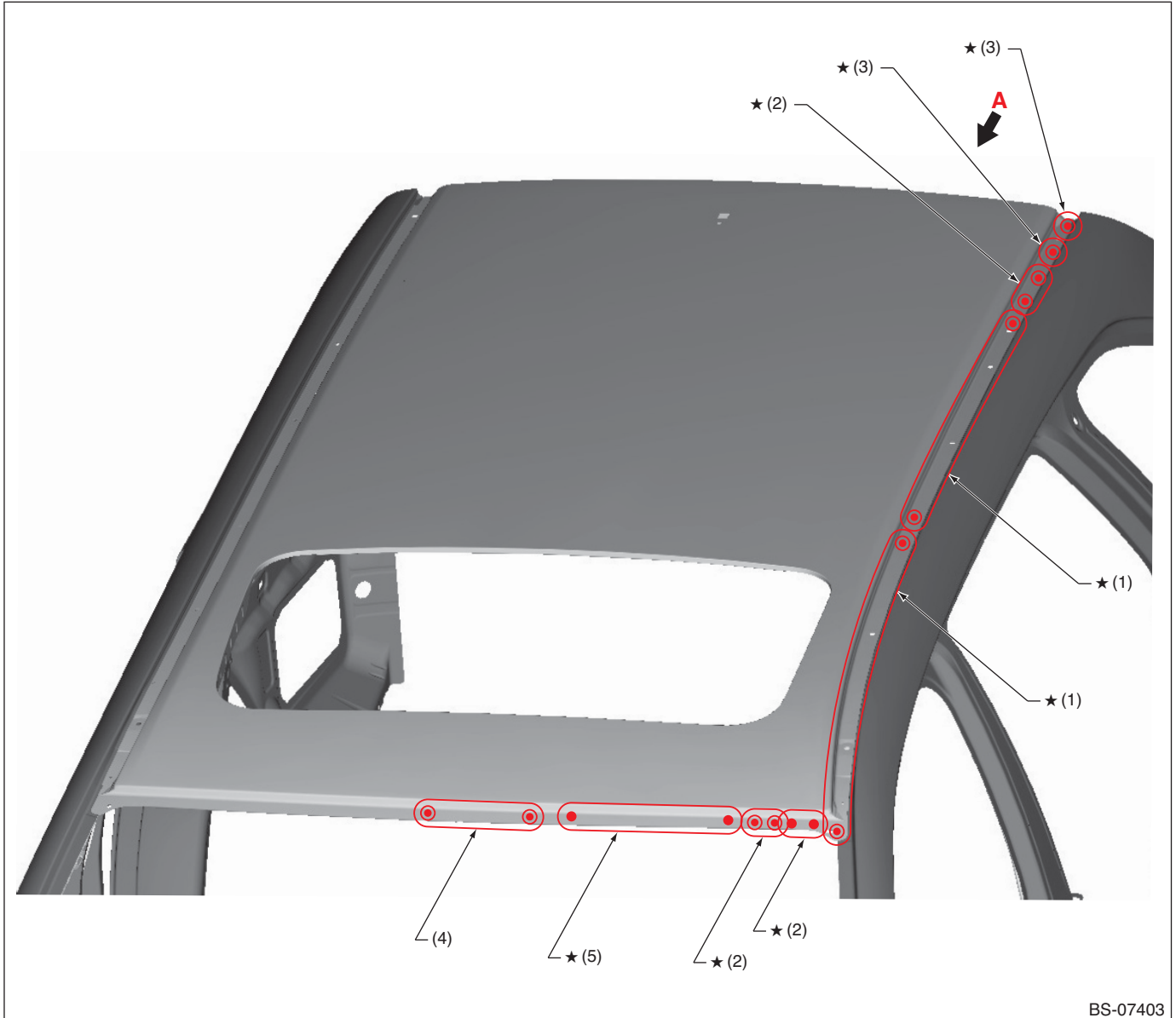
(4) 1 point

(5) 6 points

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

Panel Replacement

- Overall view 2 (Model with sunroof)



(1) 10 points
(2) 2 points

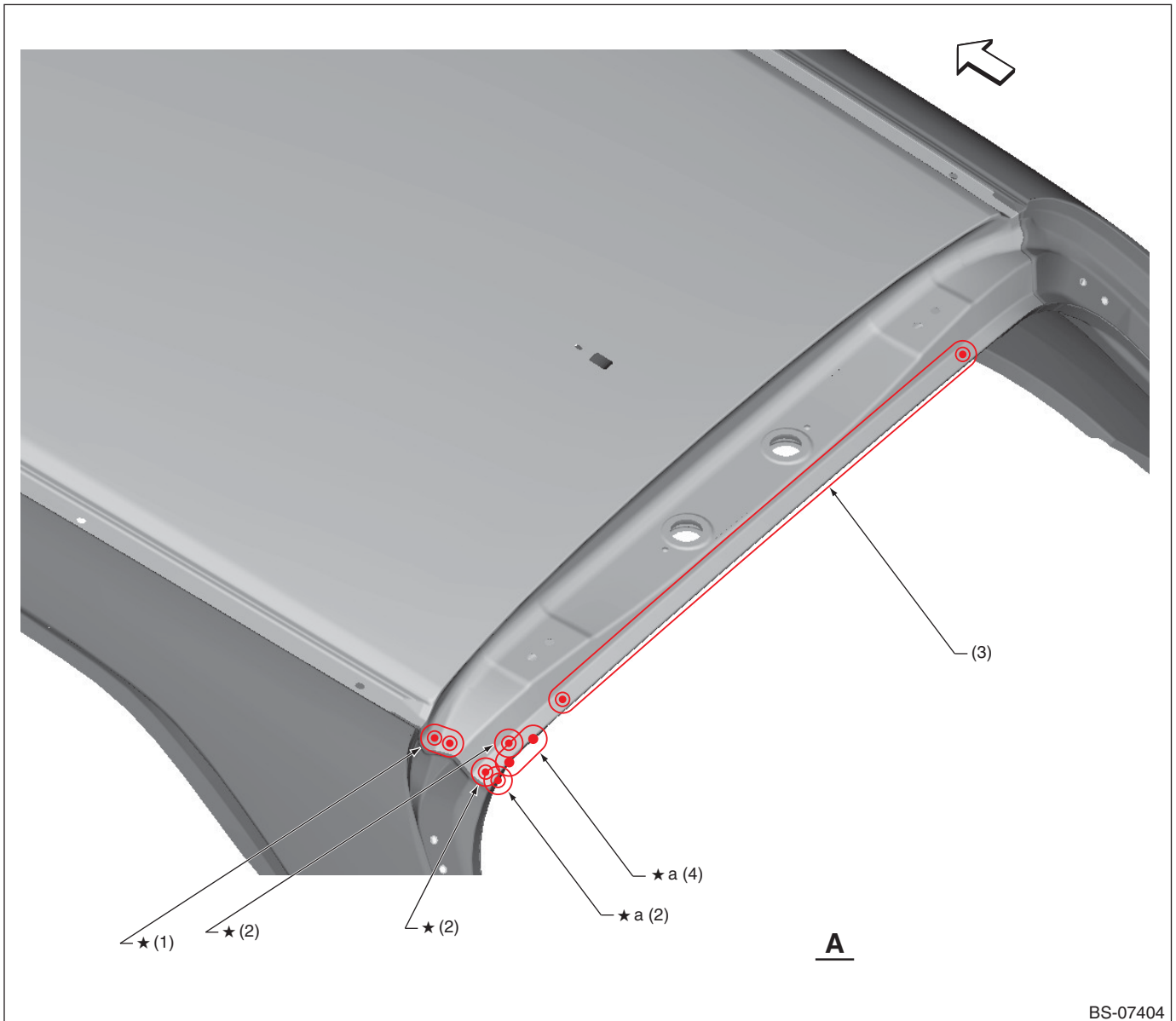
(3) 1 point
(4) 4 points

(5) 6 points

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

Panel Replacement

- View A



BS-07404

(1) 2 points
(2) 1 point

(3) 11 points

(4) 3 points

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

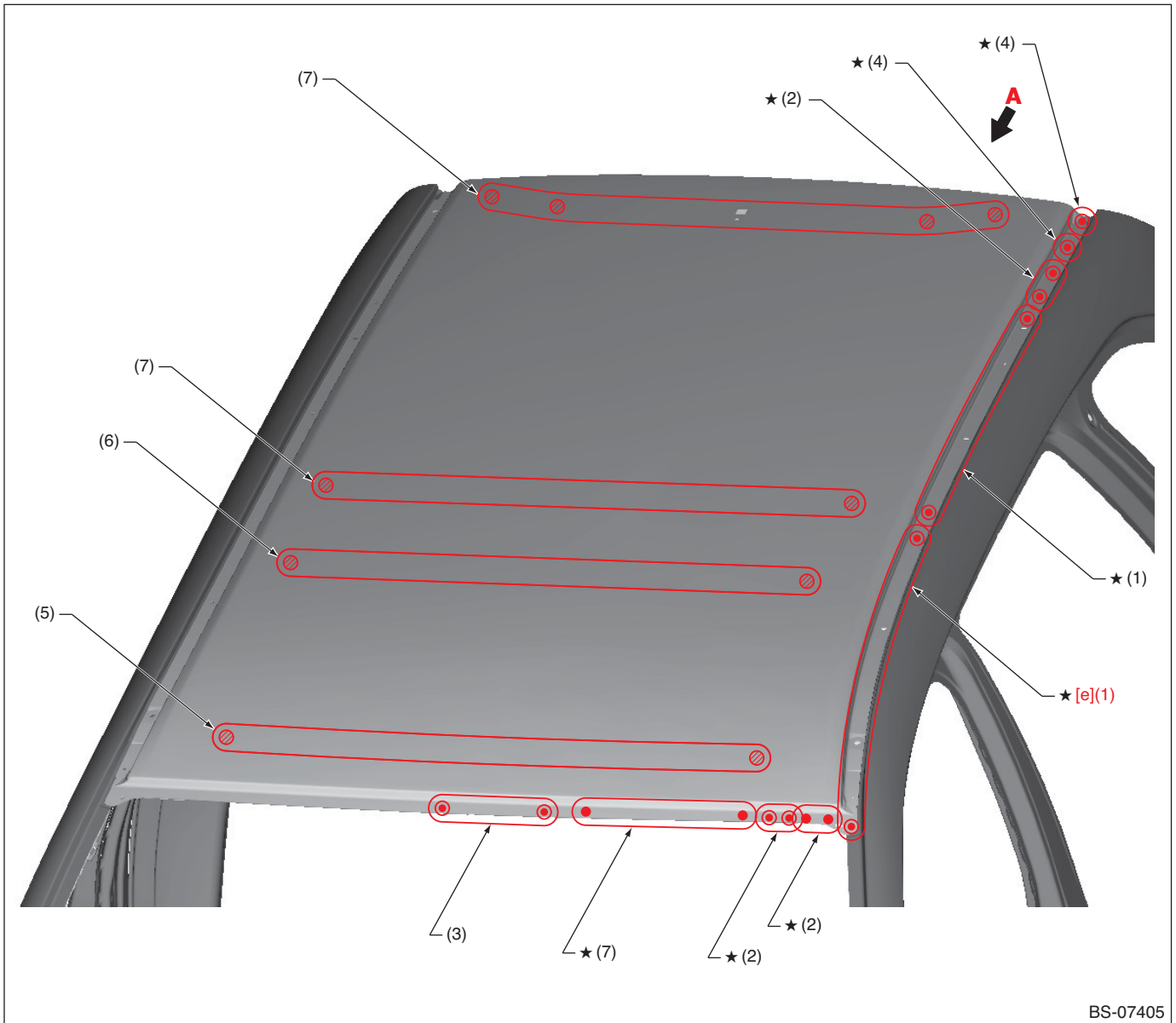
CAUTION:

In order to keep the drill from hitting the part "a," perform the work with the weather strip mounting part straightened.

Panel Replacement

B: INSTALLATION

• Overall view 1 (Model without sunroof)



BS-07405

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

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

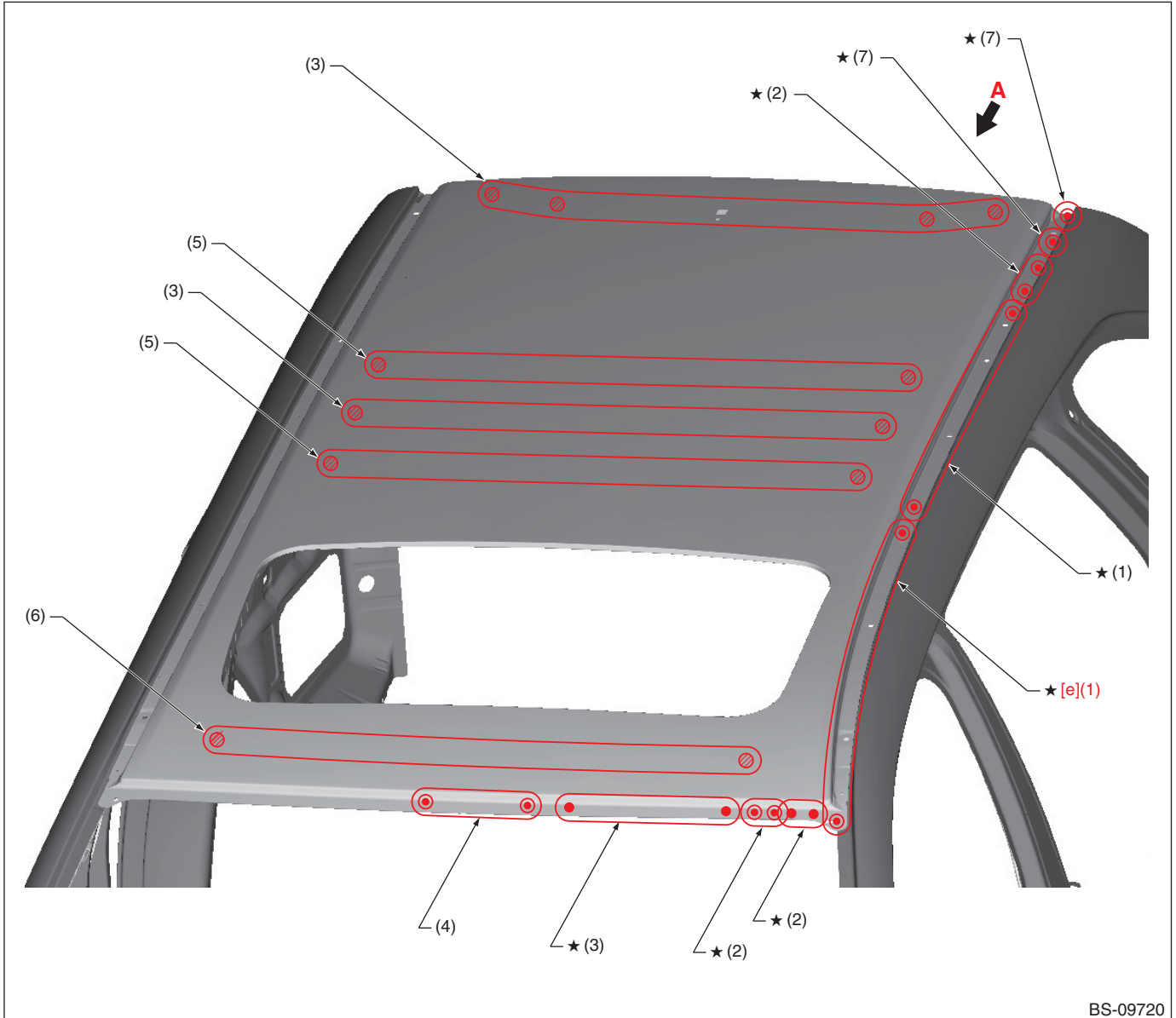
⊗ : Application of adhesive at the time of roof panel installation.

[e] Spot welding

Compression: 4.4 kN, Current: 8.0 kA, Welding time: 20 cyc

Panel Replacement

- Overall view 2 (Model with sunroof)



- (1) 10 points
- (2) 2 points
- (3) 6 points

- (4) 4 points
- (5) 7 points

- (6) 9 points
- (7) 1 point

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

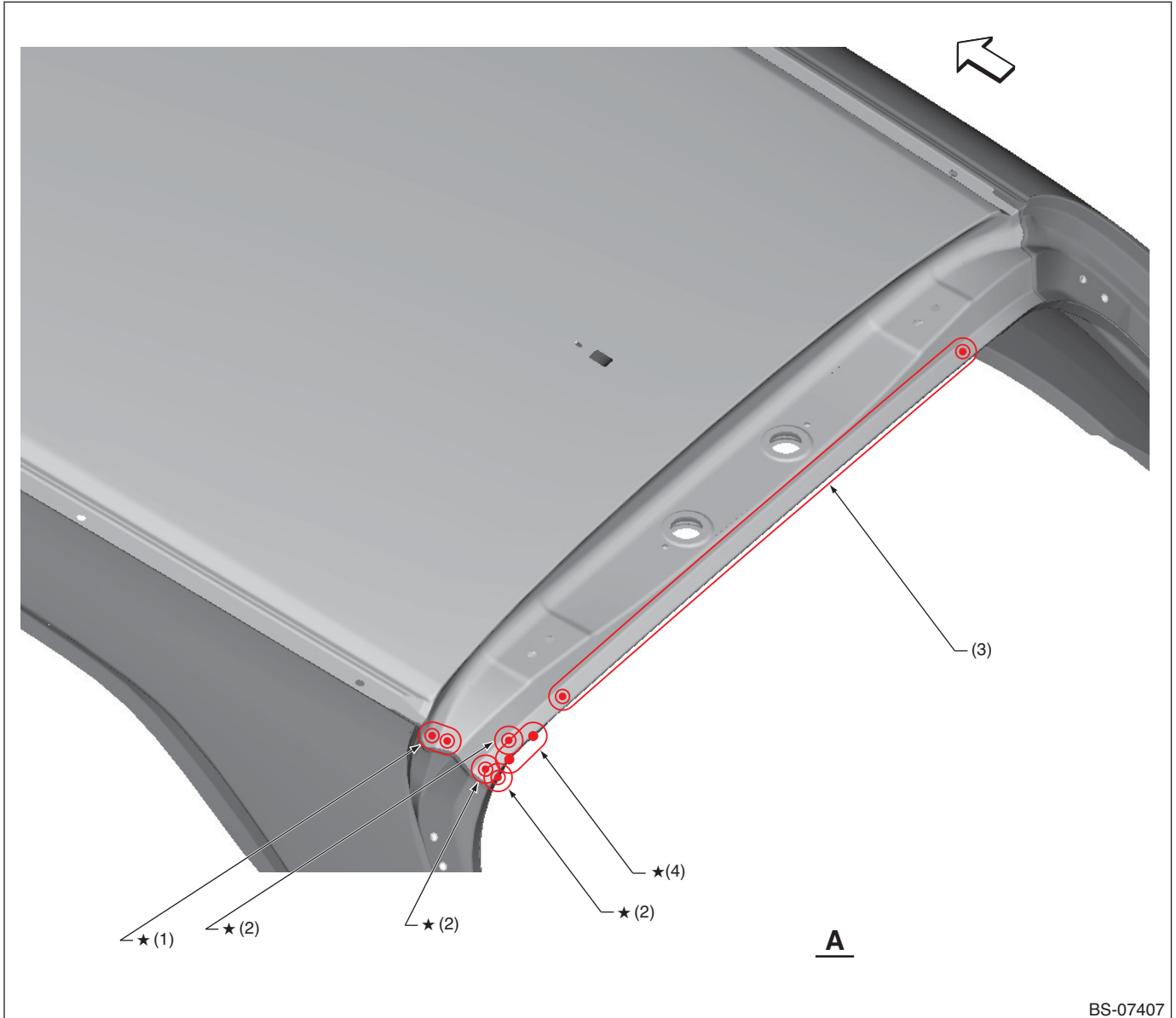
⊗ : Application of adhesive at the time of roof panel installation.

[e] Spot welding

Compression: 4.4 kN, Current: 8.0 kA, Welding time: 20 cyc

Panel Replacement

- View A



(1) 2 points
(2) 1 point

(3) 11 points

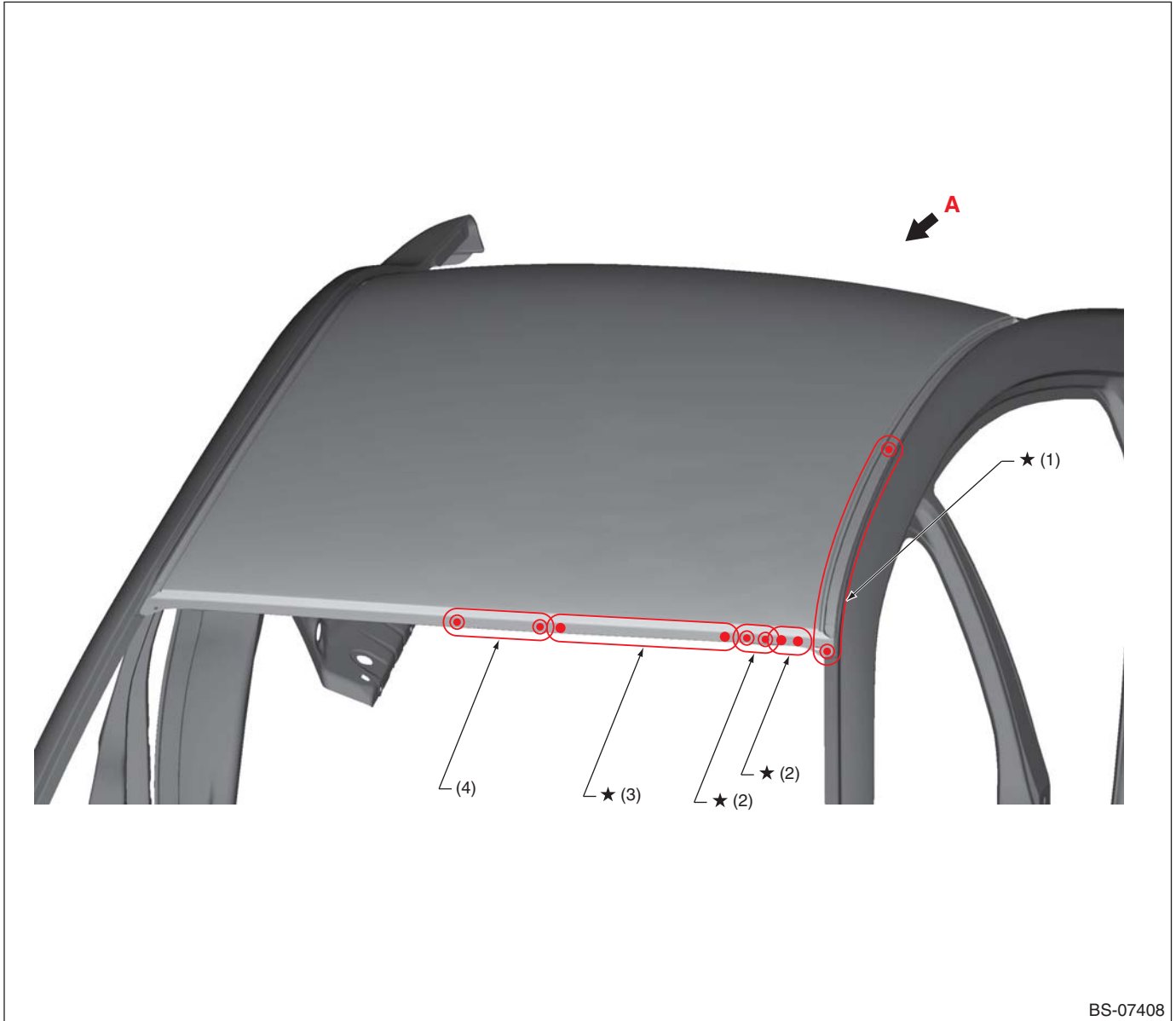
(4) 3 points

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

8-45. Roof Panel (Total replacement)/SEDAN

A: REMOVAL

- Overall view 1 (Model without sunroof)



(1) 12 points

(2) 2 points

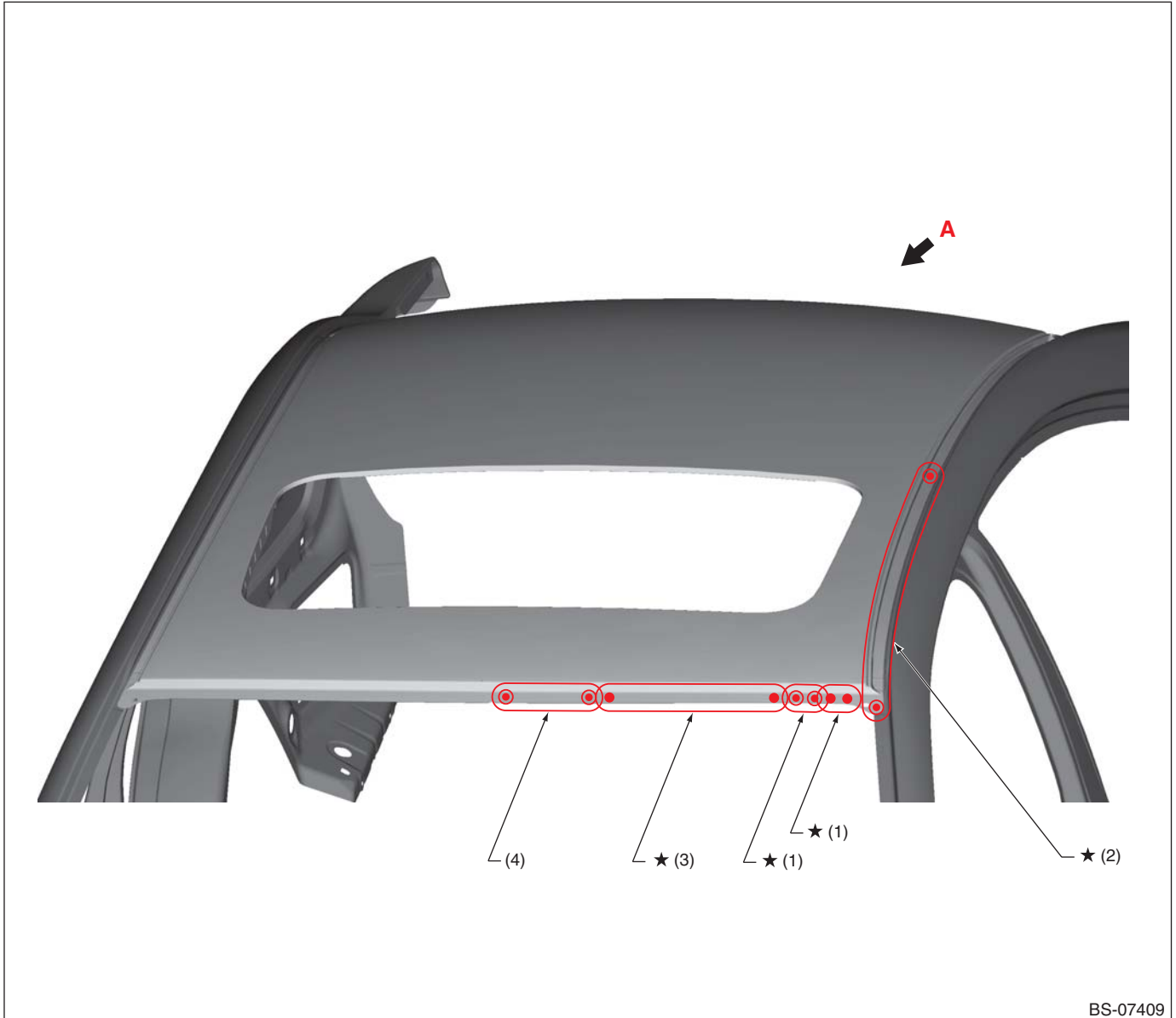
(3) 6 points

(4) 4 points

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

Panel Replacement

- Overall view 2 (Model with sunroof)



(1) 2 points
(2) 12 points

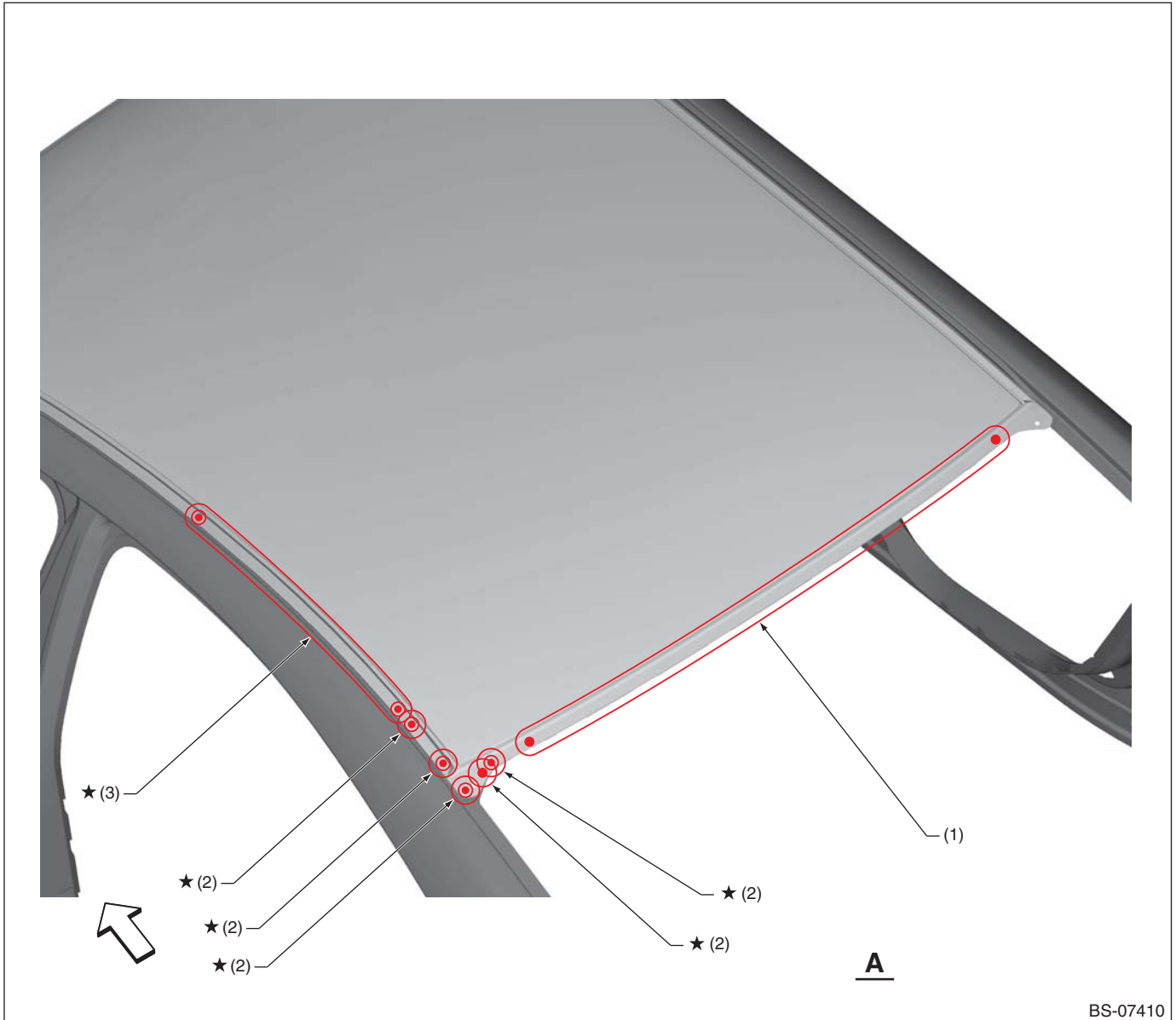
(3) 6 points

(4) 4 points

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

Panel Replacement

- View A



(1) 13 points

(2) 1 point

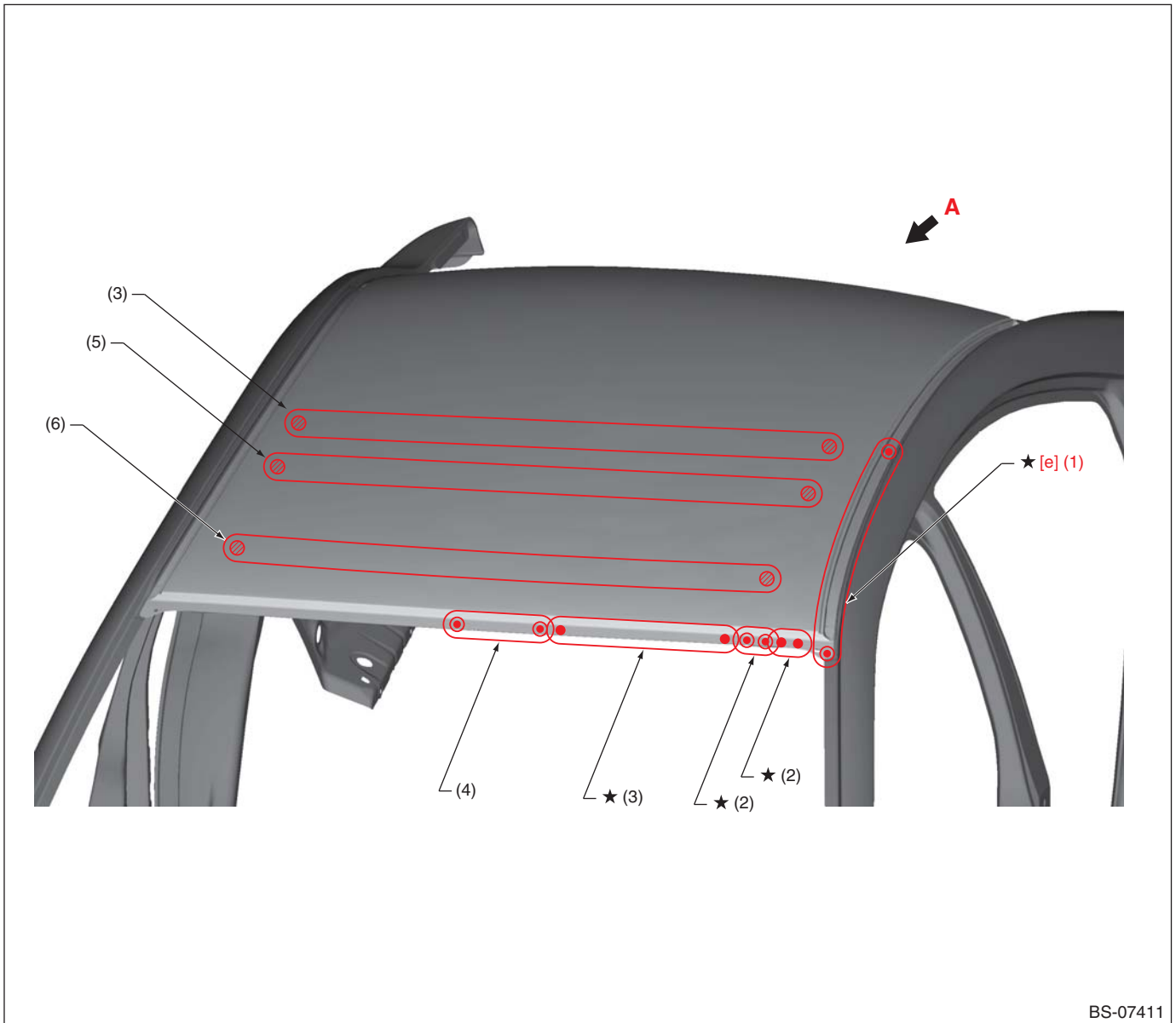
(3) 6 points

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

Panel Replacement

B: INSTALLATION

- Overall view 1 (Model without sunroof)



(1) 12 points

(2) 2 points

(3) 6 points

(4) 4 points

(5) 7 points

(6) 9 points

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

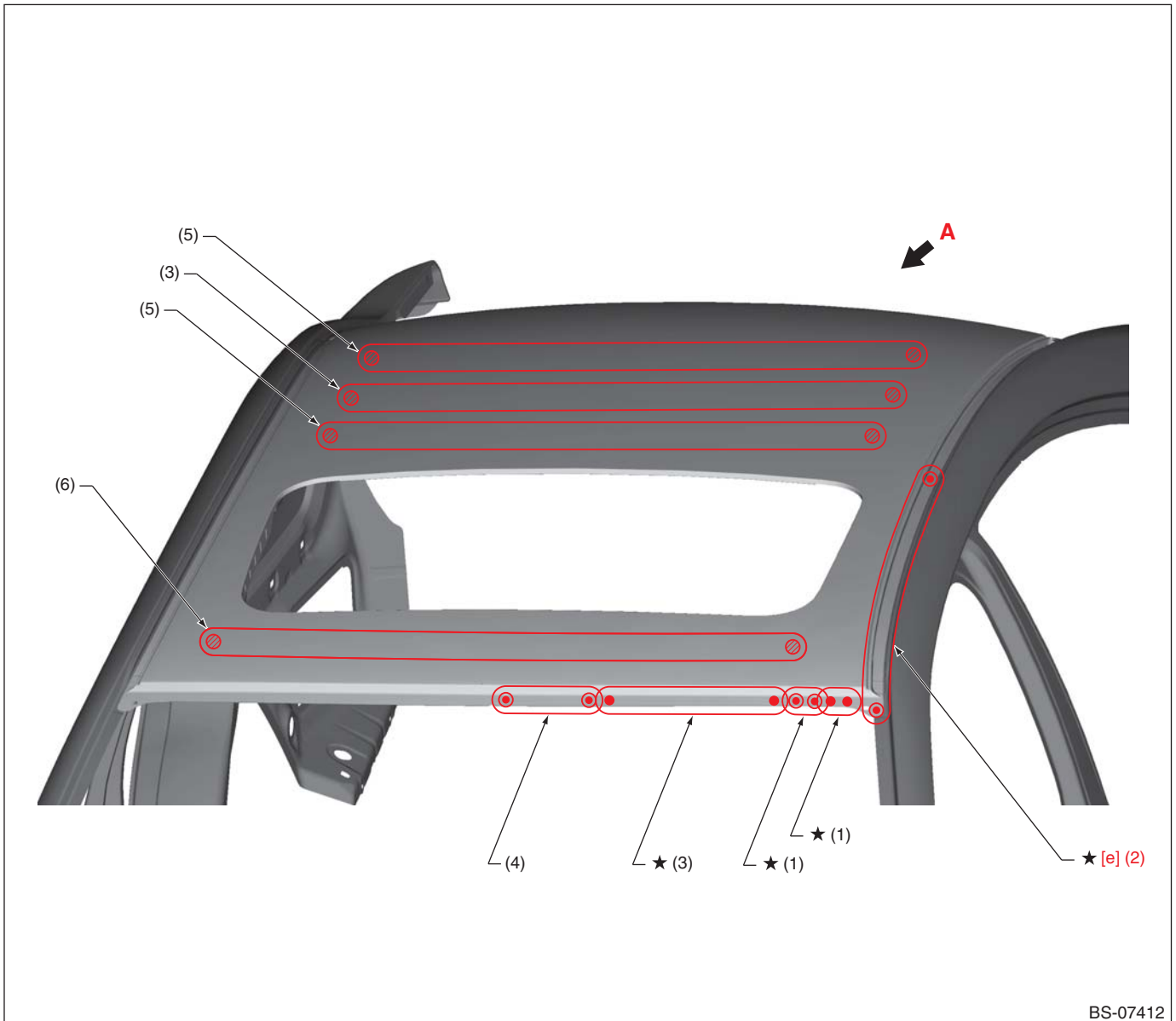
⊗ : Application of adhesive at the time of roof panel installation.

[e] Spot welding

Compression: 4.4 kN, Current: 8.0 kA, Welding time: 20 cyc

Panel Replacement

- Overall view 2 (Model with sunroof)



BS-07412

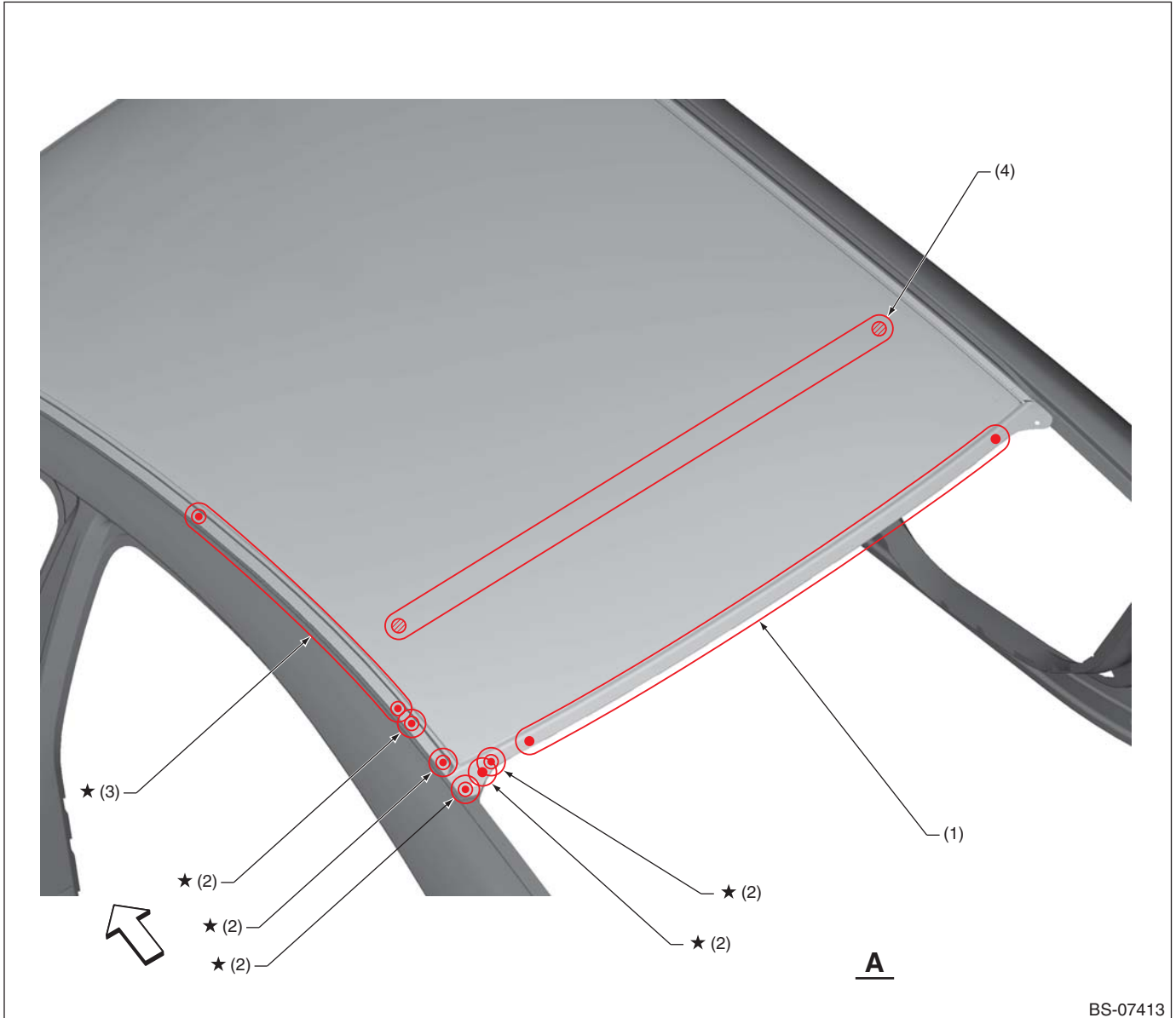
- | | | |
|---------------|--------------|--------------|
| (1) 2 points | (3) 6 points | (5) 7 points |
| (2) 12 points | (4) 4 points | (6) 9 points |

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

[e] Spot welding	Compression: 4.4 kN, Current: 8.0 kA, Welding time: 20 cyc
------------------	--

Panel Replacement

- View A



(1) 13 points

(2) 1 point

(3) 6 points

(4) 7 points

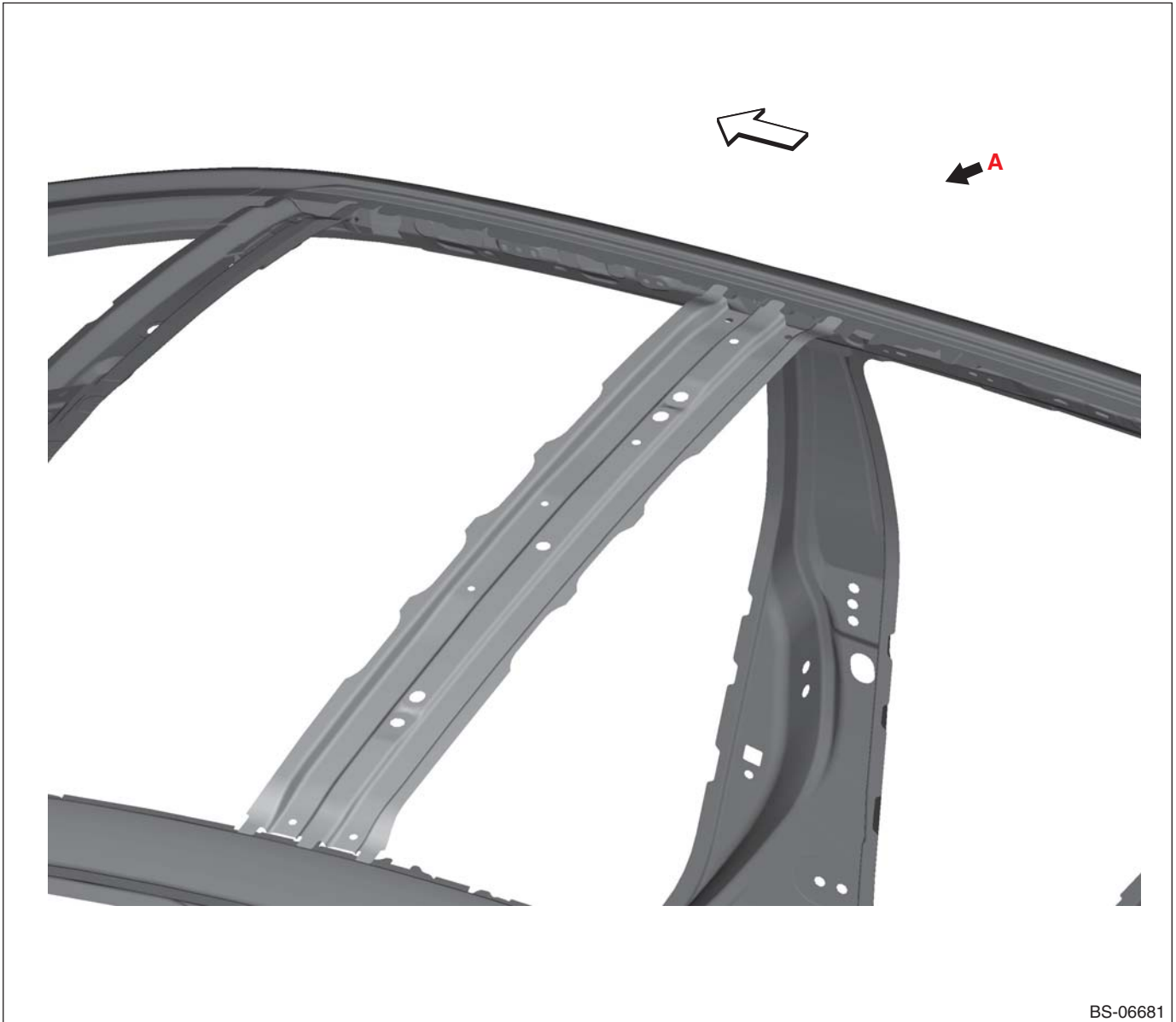
For locations marked by ★, the welding method and the number of welding points are the same on the left and the right.

⊘ : Application of adhesive at the time of roof panel installation.

8-46. Roof Center Brace (Total replacement)

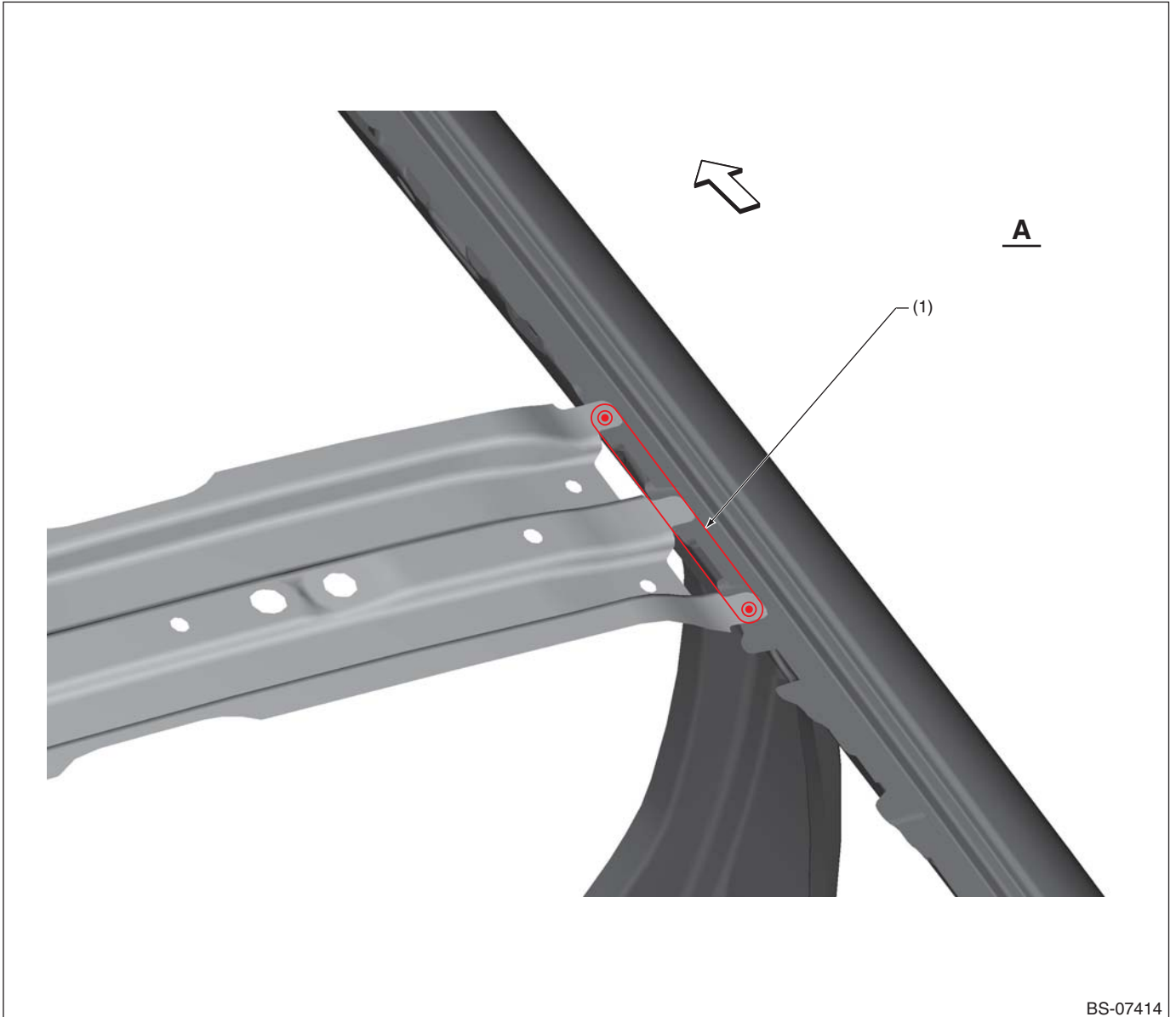
A: REMOVAL

- Overall view (Roof panel removal condition)



Panel Replacement

- View A

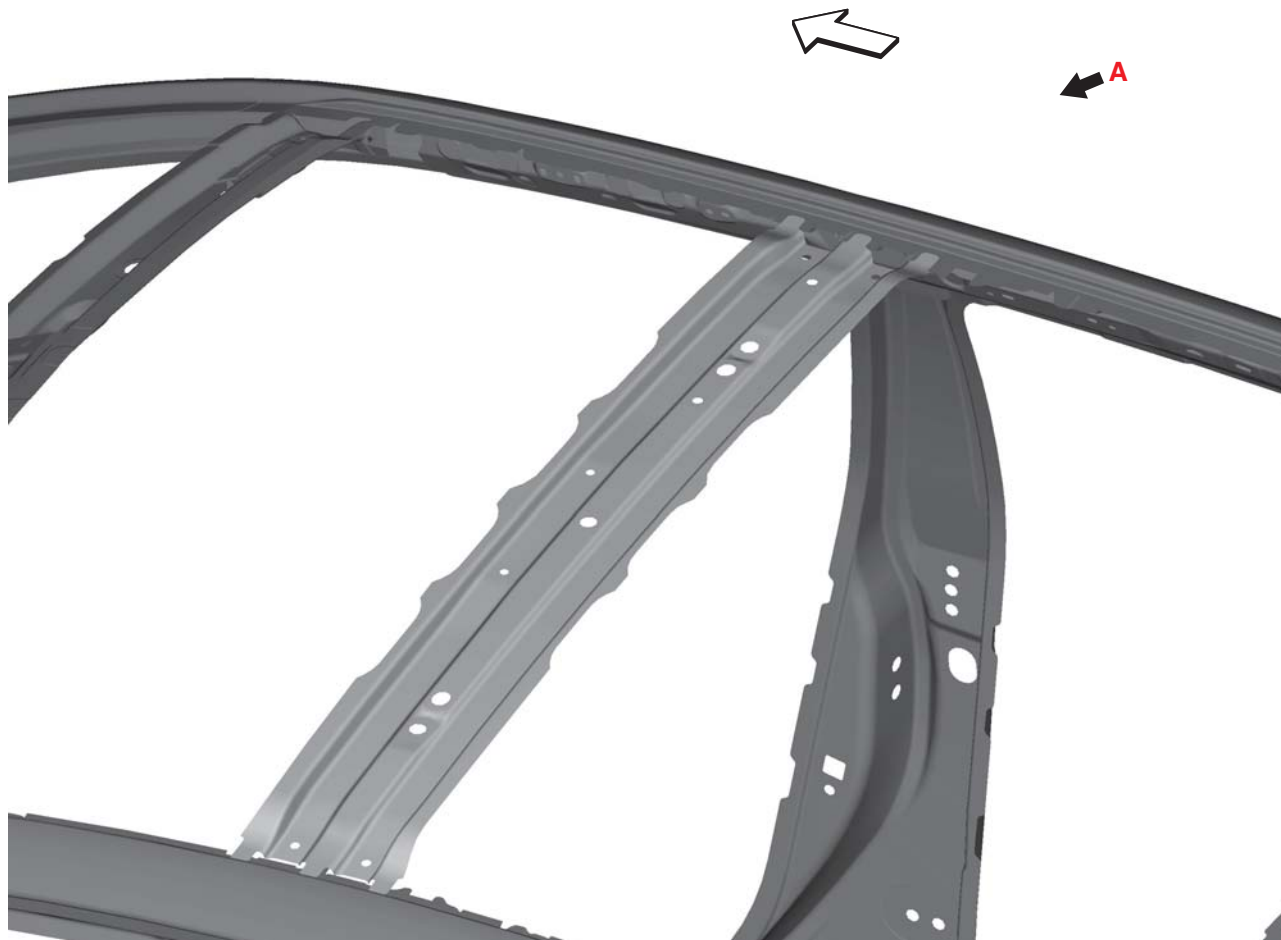


BS-07414

(1) 3 points

B: INSTALLATION

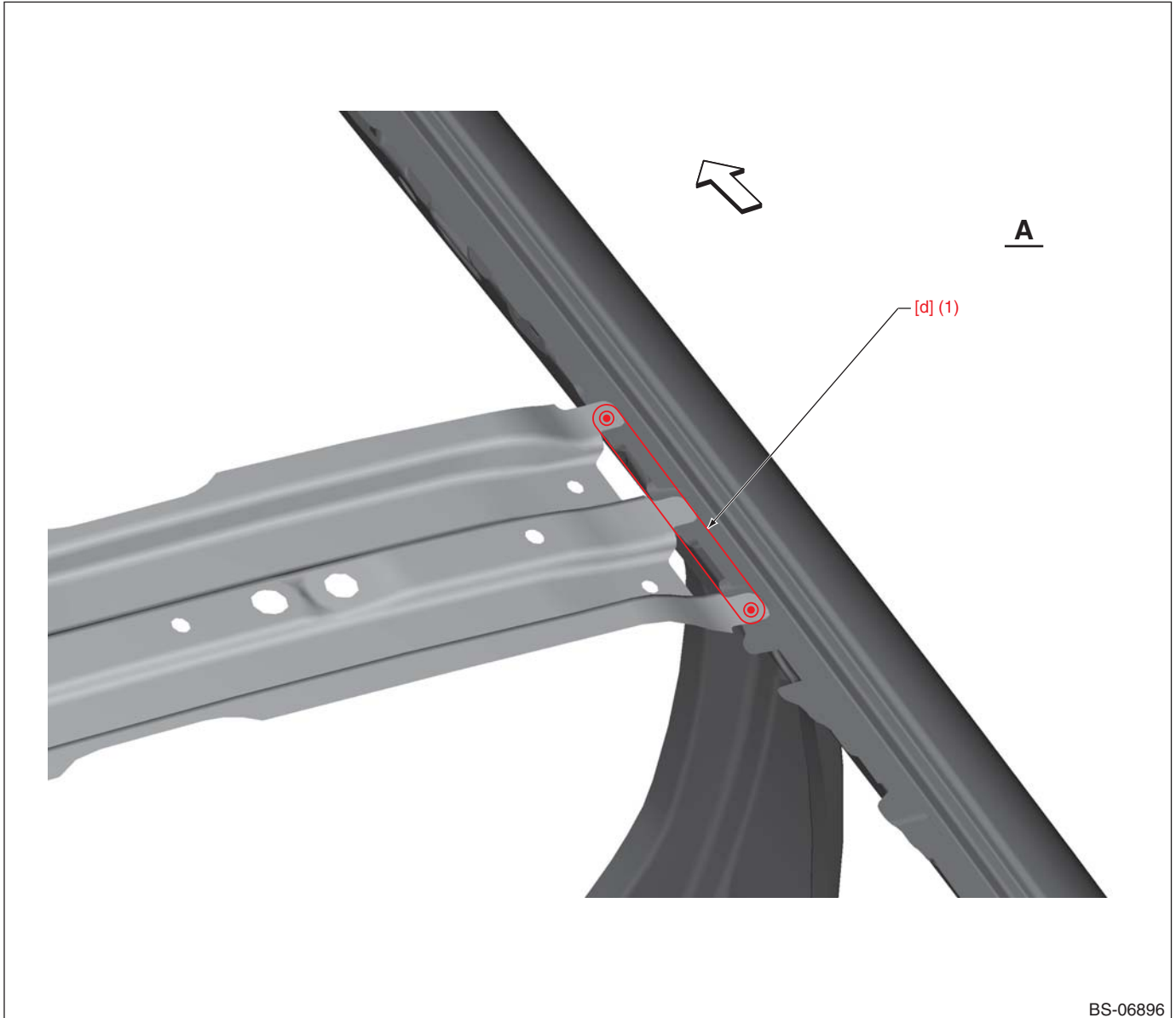
- Overall view



BS-06681

Panel Replacement

- View A



(1) 3 points

[d] Spot welding

Compression: 4.4 kN, Current: 8.0 kA, Welding time: 25 cyc

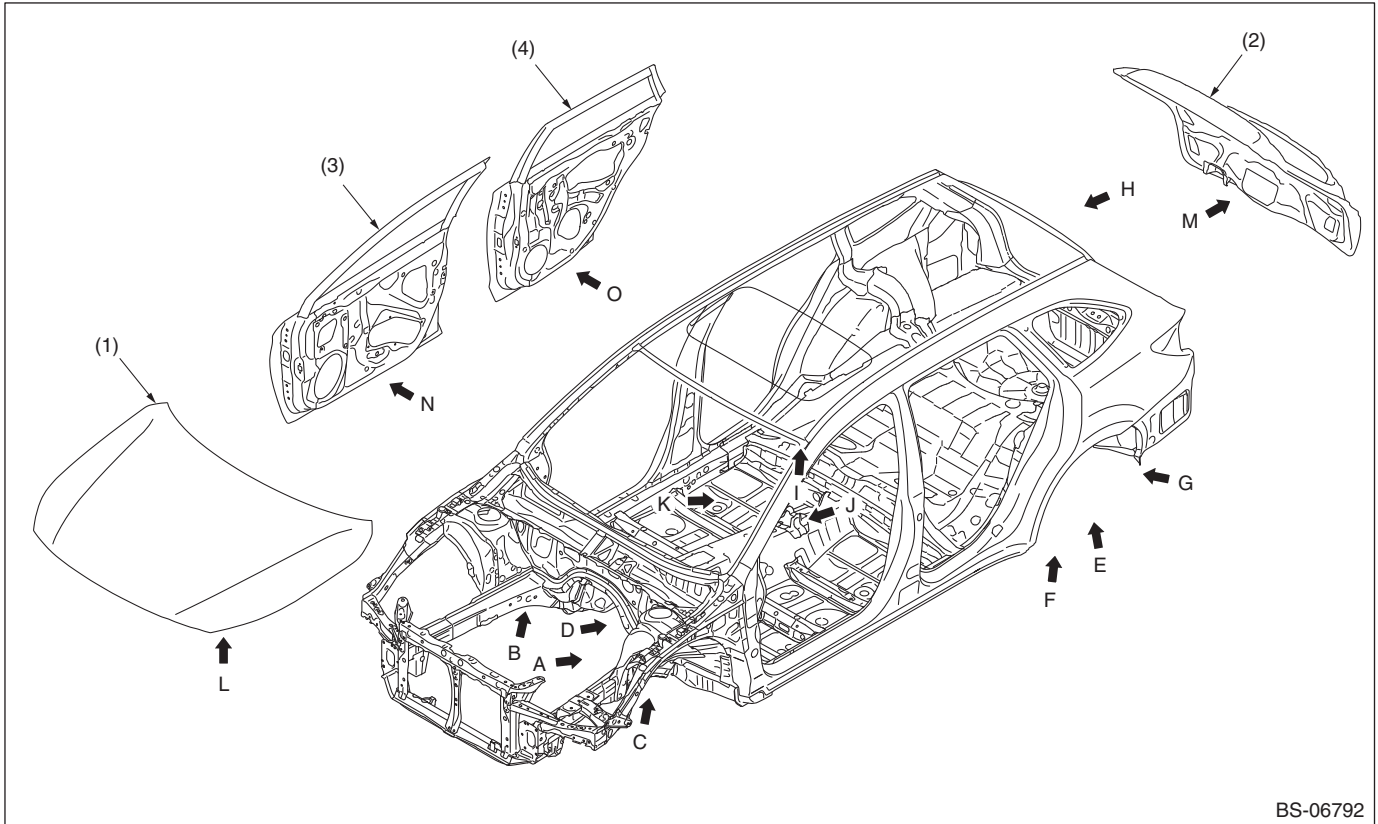
9. Body Sealing

A: SPECIFICATIONS

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

— : Sealer application location

- Common parts for OUTBACK and SEDAN

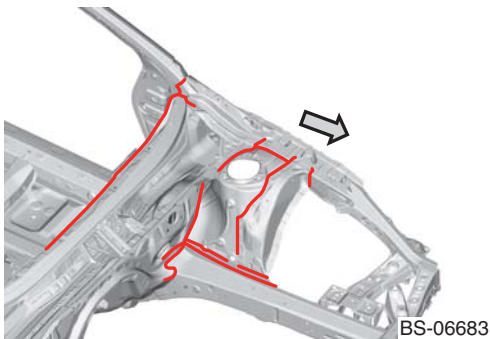


- (1) Front hood
(2) Rear gate

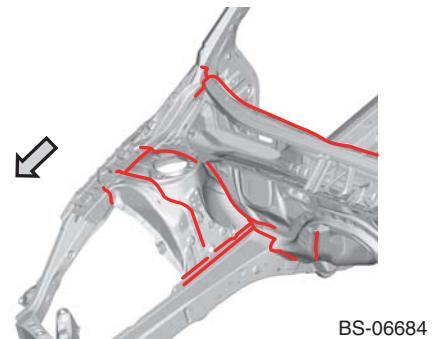
- (3) Front door

- (4) Rear door

View A

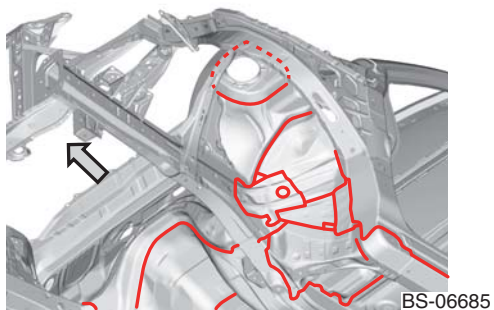


View B

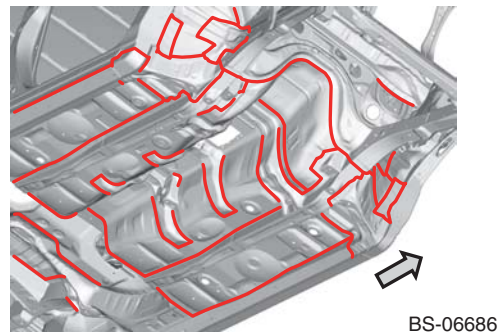


Body Sealing

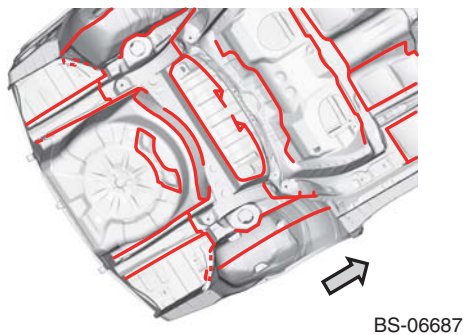
View C



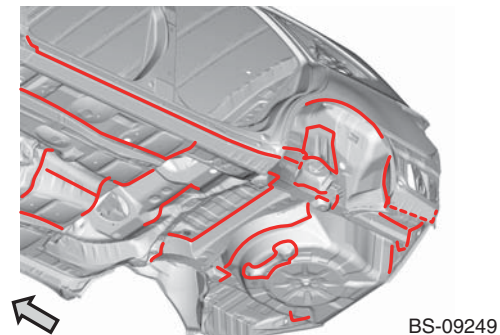
View D



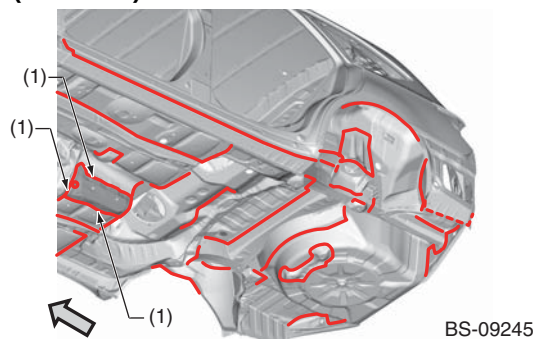
View E



View F (— '17 MY)

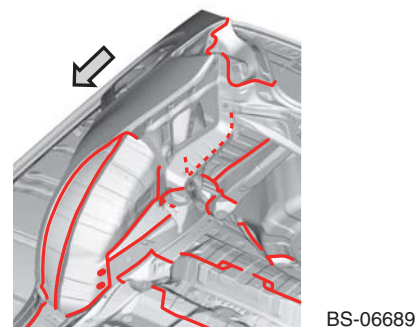


View F ('18 MY —)

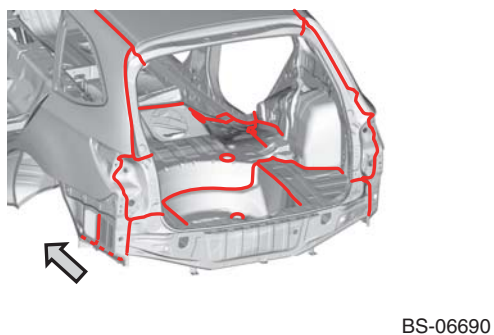


(1) Only RH

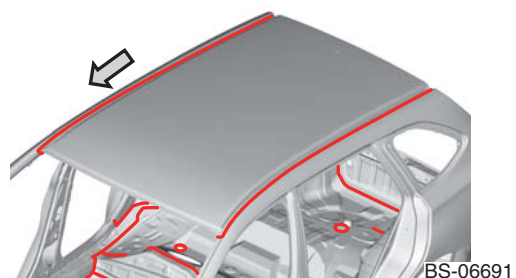
View G



View H

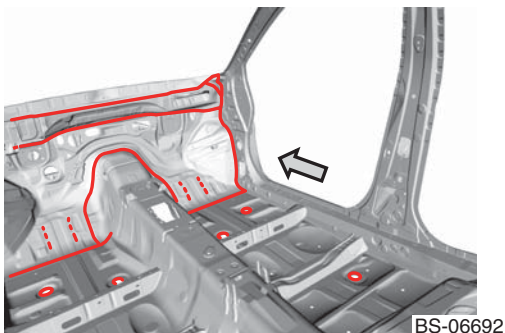


View I

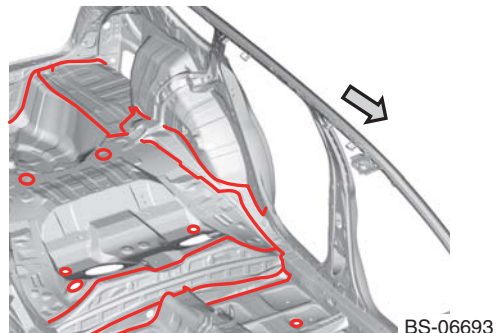


Body Sealing

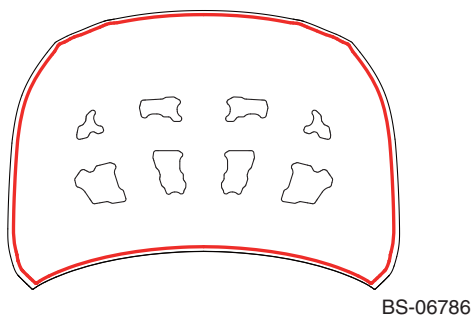
View J



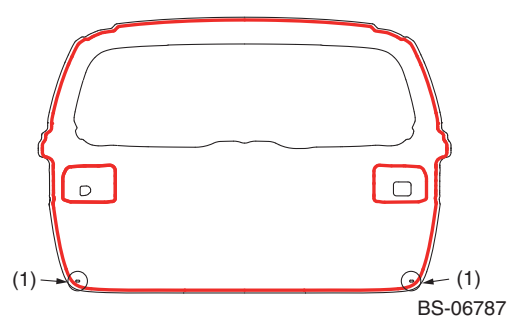
View K



View L

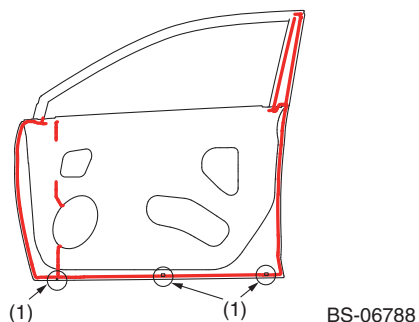


View M



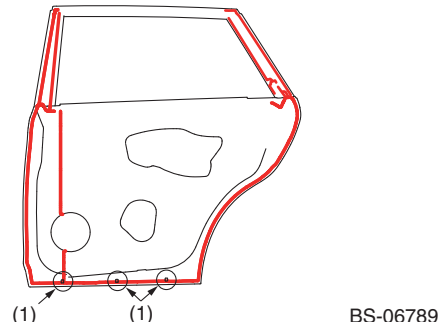
(1) Do not block the water drain holes.

View N



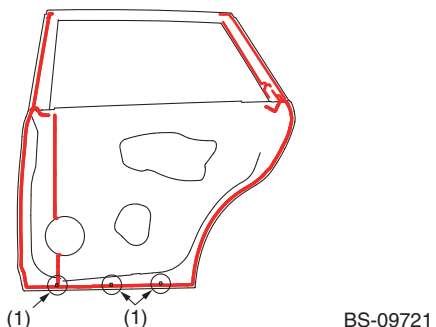
(1) Do not block the water drain holes.

View O (— '16 MY)



(1) Do not block the water drain holes.

View O ('17 MY —)



(1) Do not block the water drain holes.

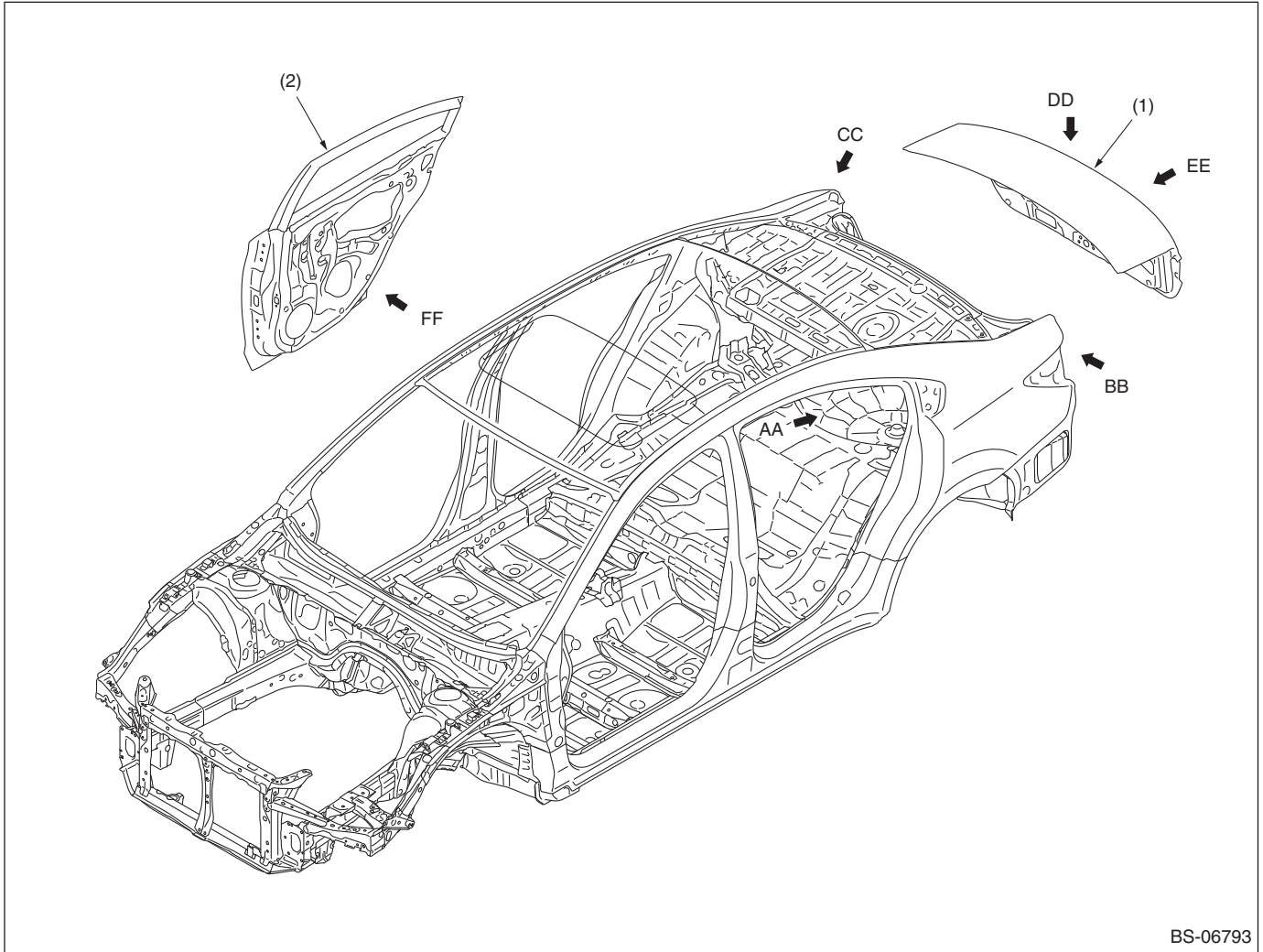
SUBARU.

CAUTION:

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

Body Sealing

- Special SEDAN parts

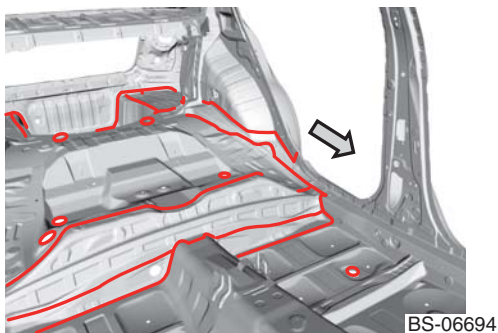


BS-06793

(1) Trunk

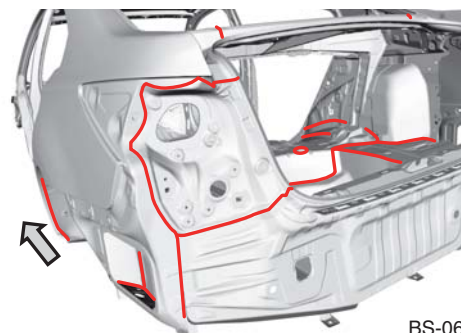
(2) Rear door

View AA



BS-06694

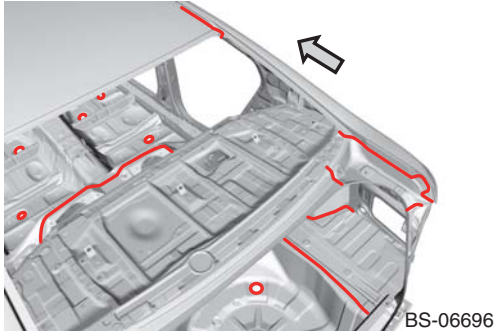
View BB



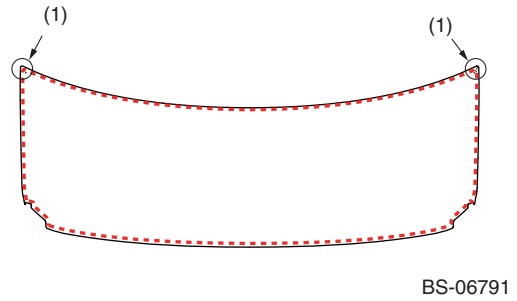
BS-06695

Body Sealing

View CC

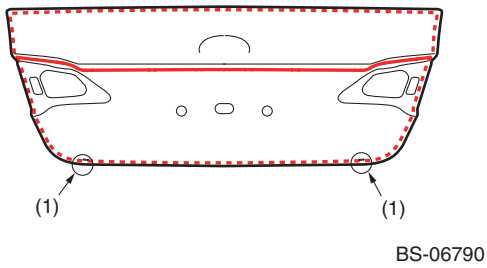


View DD



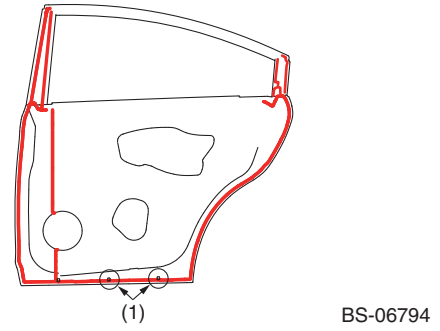
(1) The hole shall be blocked.

View EE



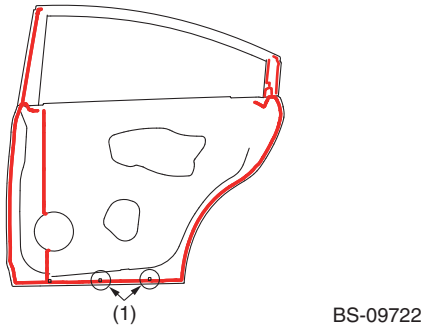
(1) Do not block the water drain holes.

View FF (— '16 MY)



(1) Do not block the water drain holes.

View FF ('17 MY —)



(1) Do not block the water drain holes.

SUBARU.

CAUTION:

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

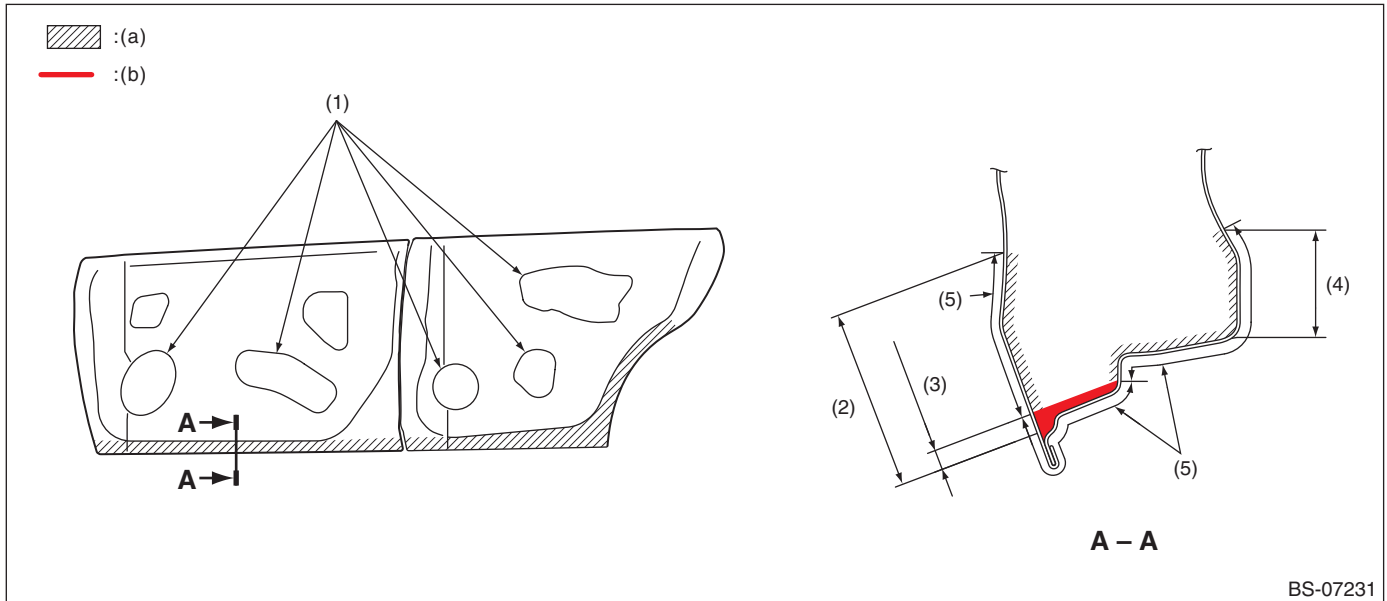
10. Anticorrosion Wax

A: SPECIFICATIONS

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

— and    : Application area

- Doors (Application thickness = 50 µm or more)



BS-07231

(a) Rust-stop aerosol

(b) To be filled into the plate joint.

(1) Wax application work openings

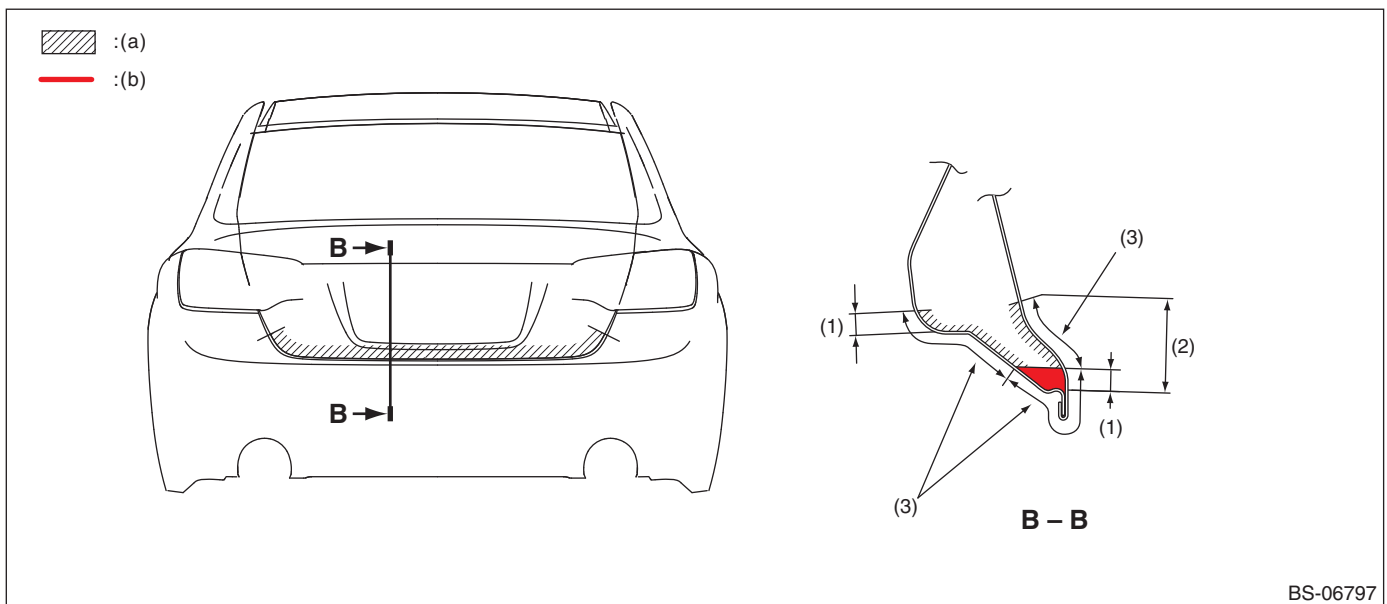
(3) 10 mm (0.39 in)

(5) Adherence of mist is allowable

(2) 90 mm (3.54 in)

(4) 50 mm (1.97 in)

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



BS-06797

(a) Rust-stop aerosol

(b) To be filled into the plate joint.

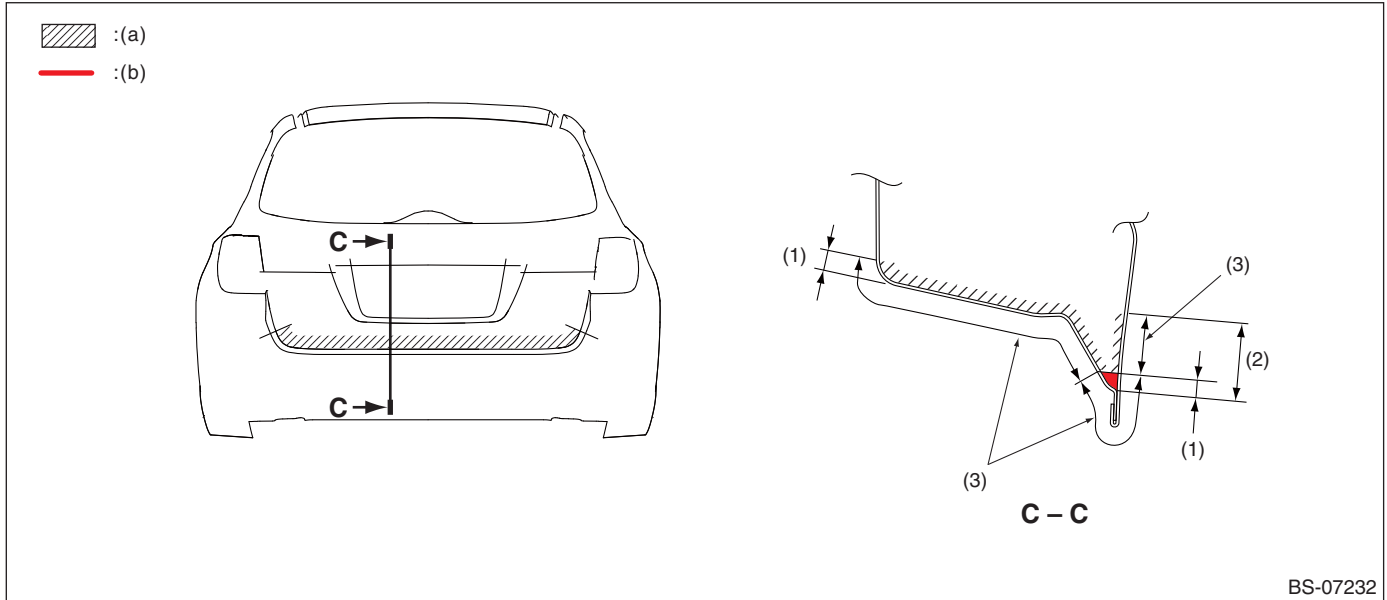
(1) 10 mm (0.39 in)

(2) 40 mm (1.57 in)

(3) Adherence of mist is allowable

Anticorrosion Wax

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



(a) Rust-stop aerosol

(b) To be filled into the plate joint.

(1) 10 mm (0.39 in)

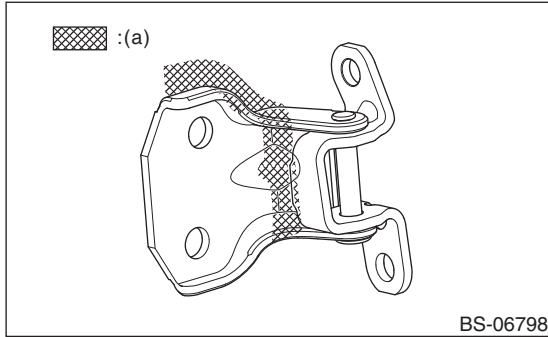
(2) 40 mm (1.57 in)

(3) Adherence of mist is allowable

Anticorrosion Wax

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

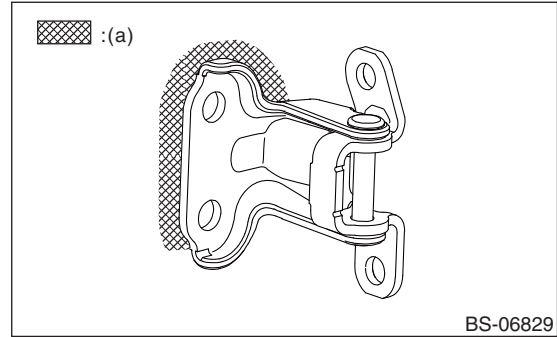
Apply to the contact surface (indicated range) on body side at two locations at the top and bottom (four locations in all), and to the installation outer circumference (plate edges) on the door side.



(a) Rust-stop aerosol

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

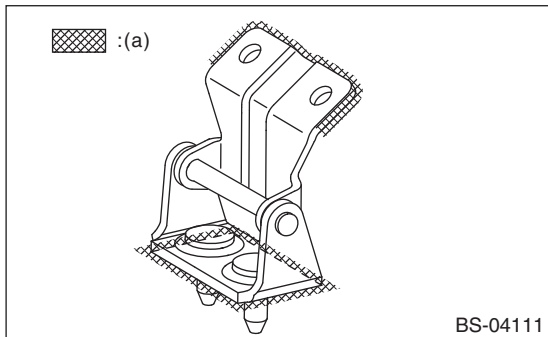
Apply to the contact surface (indicated range) on body side at two locations at the top and bottom (four locations in all), and to the installation outer circumference (plate edges) on the door side.



(a) Rust-stop aerosol

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

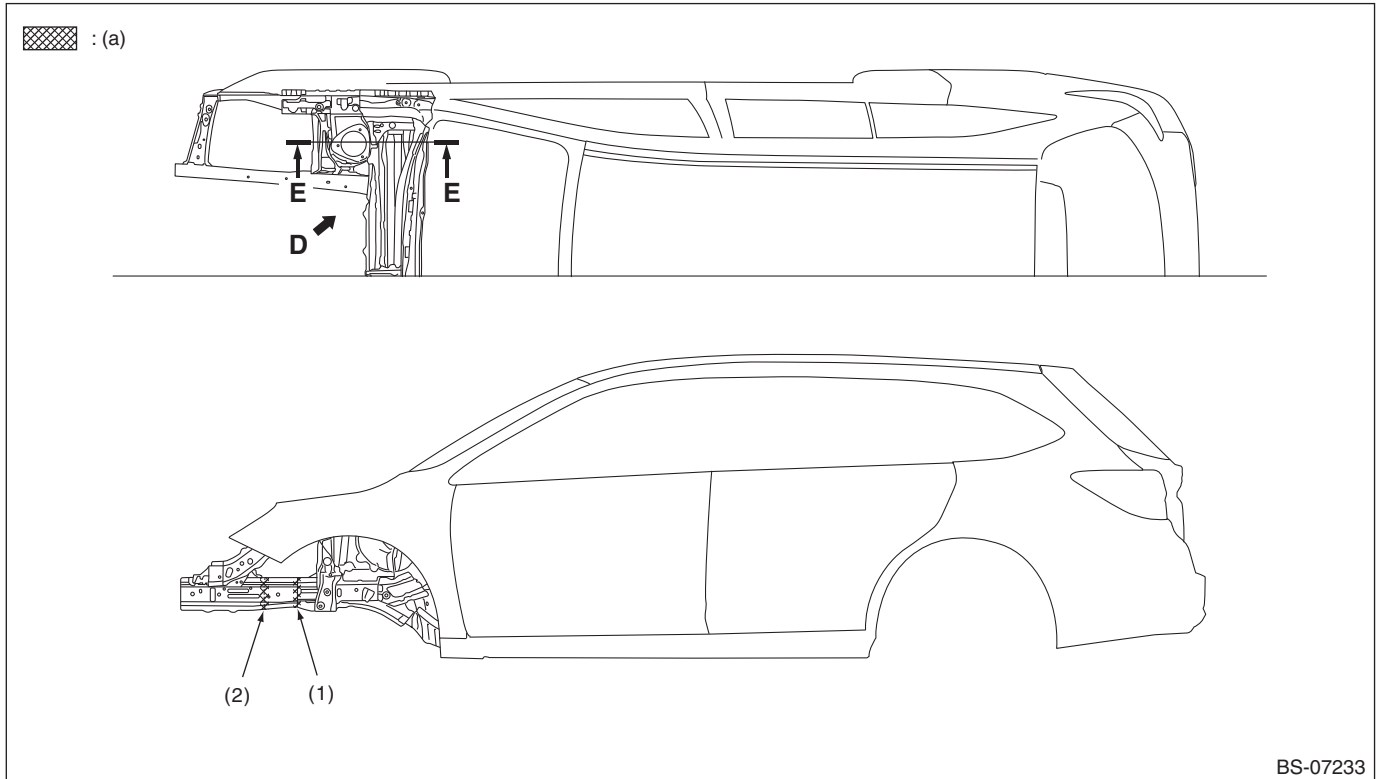
Apply to the contact surface on the body side at two locations on the left and right, and to installation outer circumference (indicated range, plate edges) on the rear gate side.



(a) Rust-stop aerosol

Anticorrosion Wax

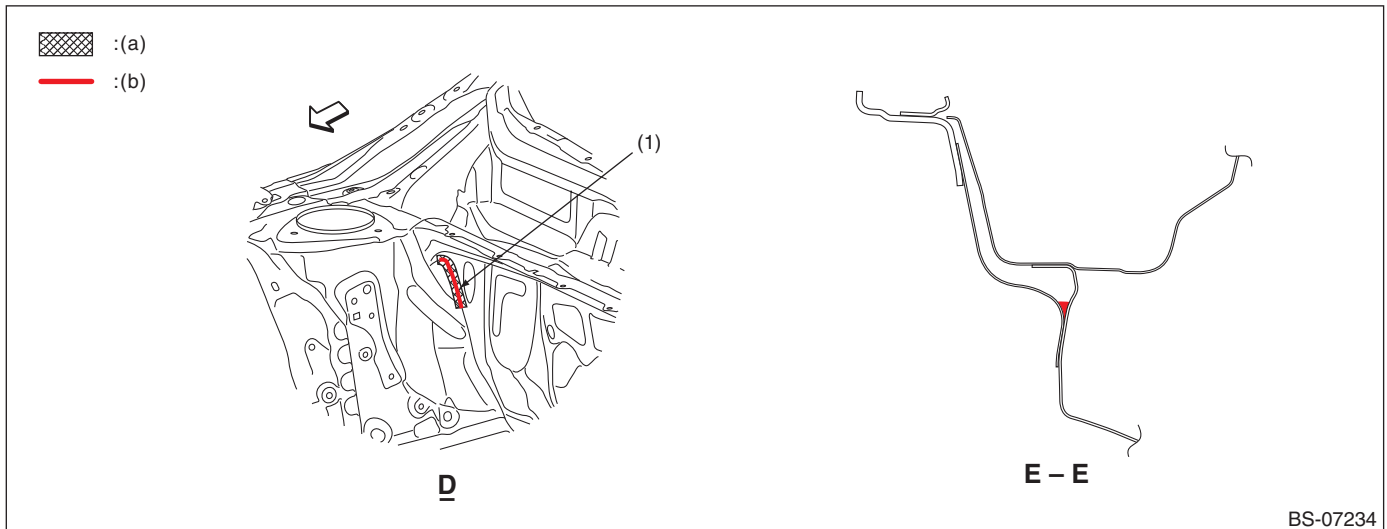
• Overall view



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

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

• View/Cross section



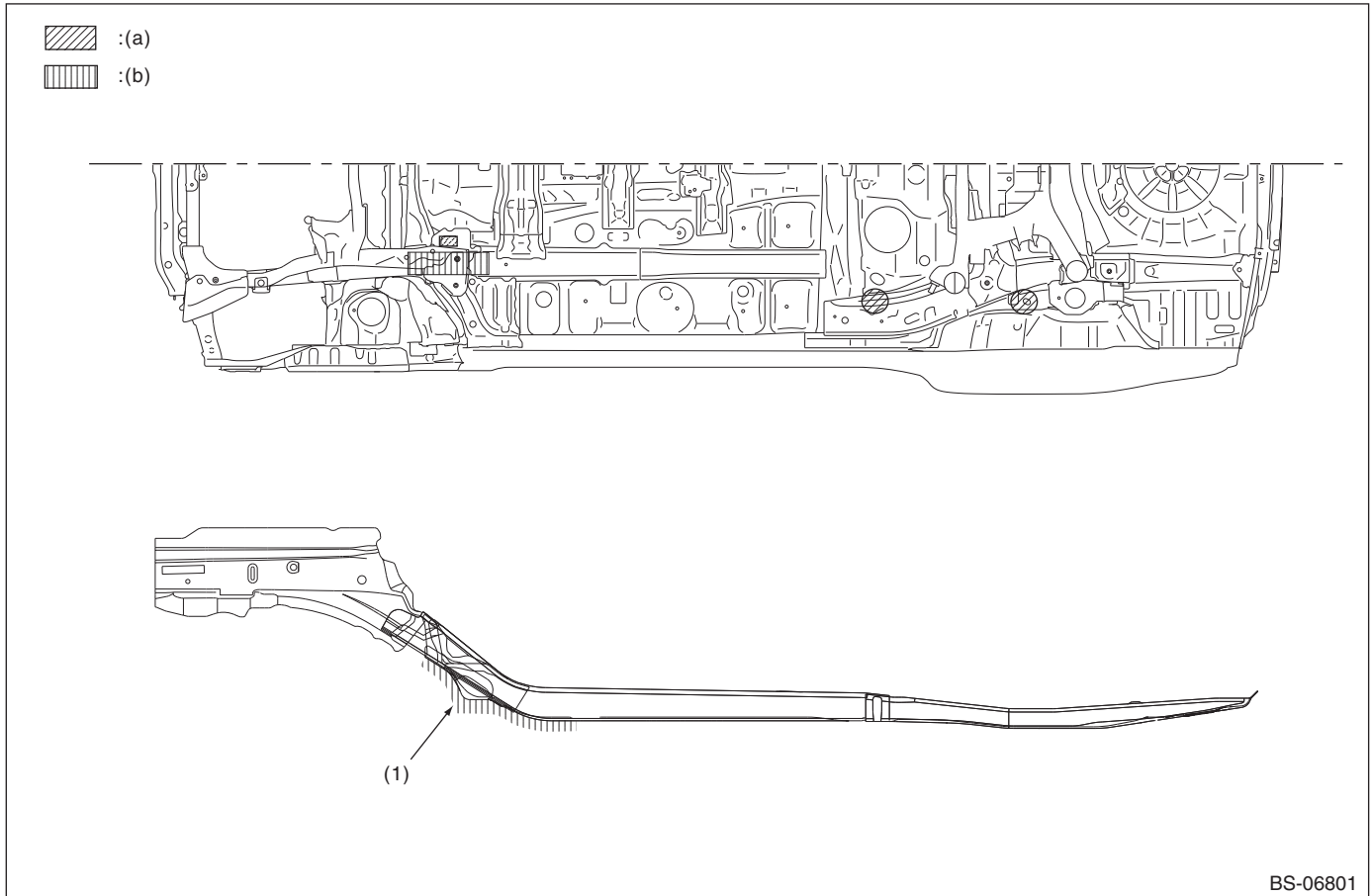
(a) Rust-stop aerosol (Application thickness = 15 μm or more)

(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



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

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

(1) Application shall be done without the transverse link bush coated.

11.Undercoat

A: SPECIFICATIONS

Repair material: PVC (NT guardcoat 5900FL)

CAUTION:

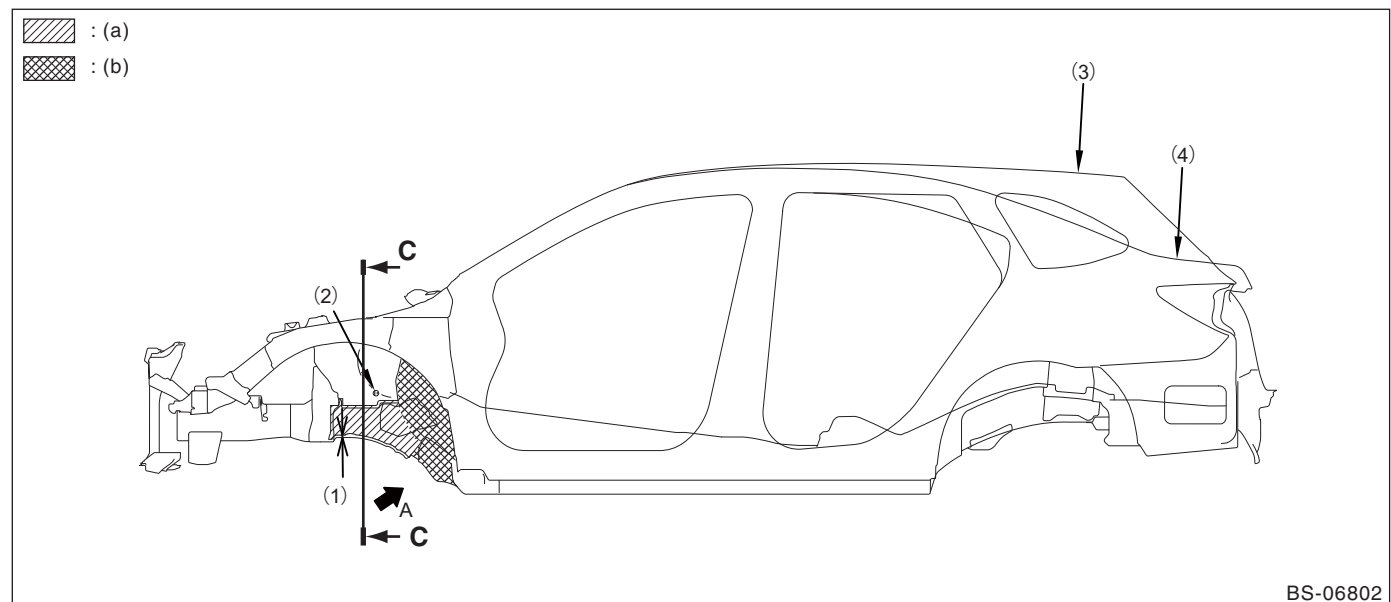
Be careful not to let the undercoating be attached to any parts not indicated below and to the following locations.

- 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
	The panel gap shall be filled.

• Side view



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

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

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

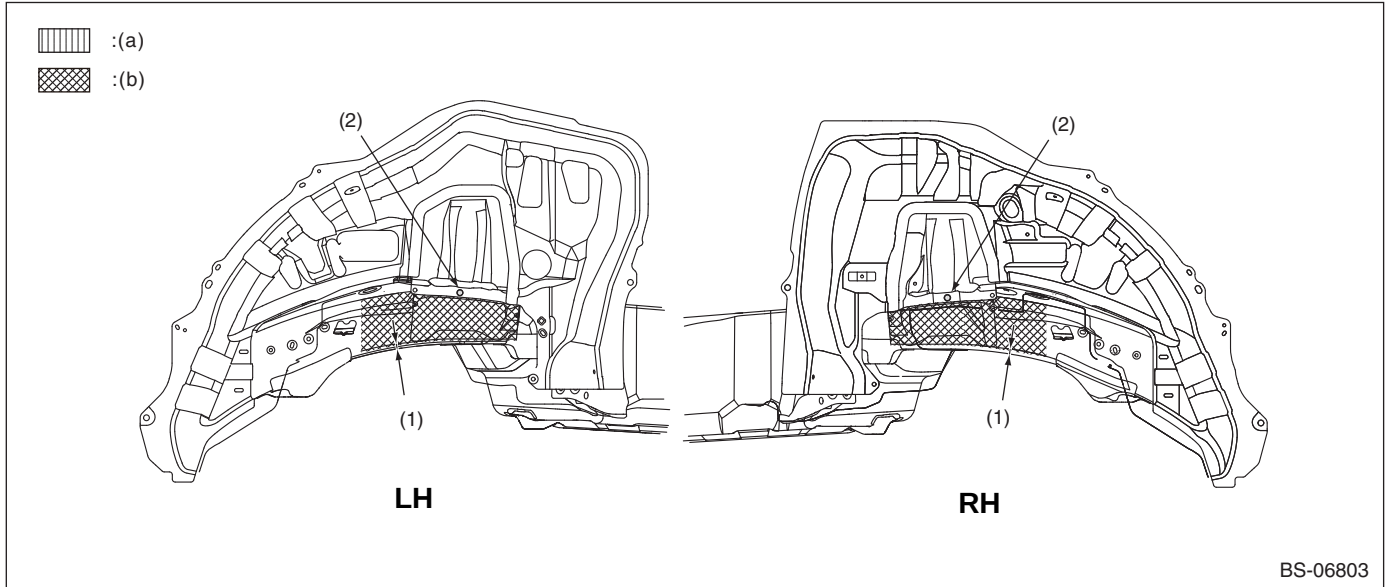
(3) OUTBACK

(4) SEDAN

(2) Plug must be covered with PVC

Undercoat

- Rear wheel apron side view



(a) 200 μm or more

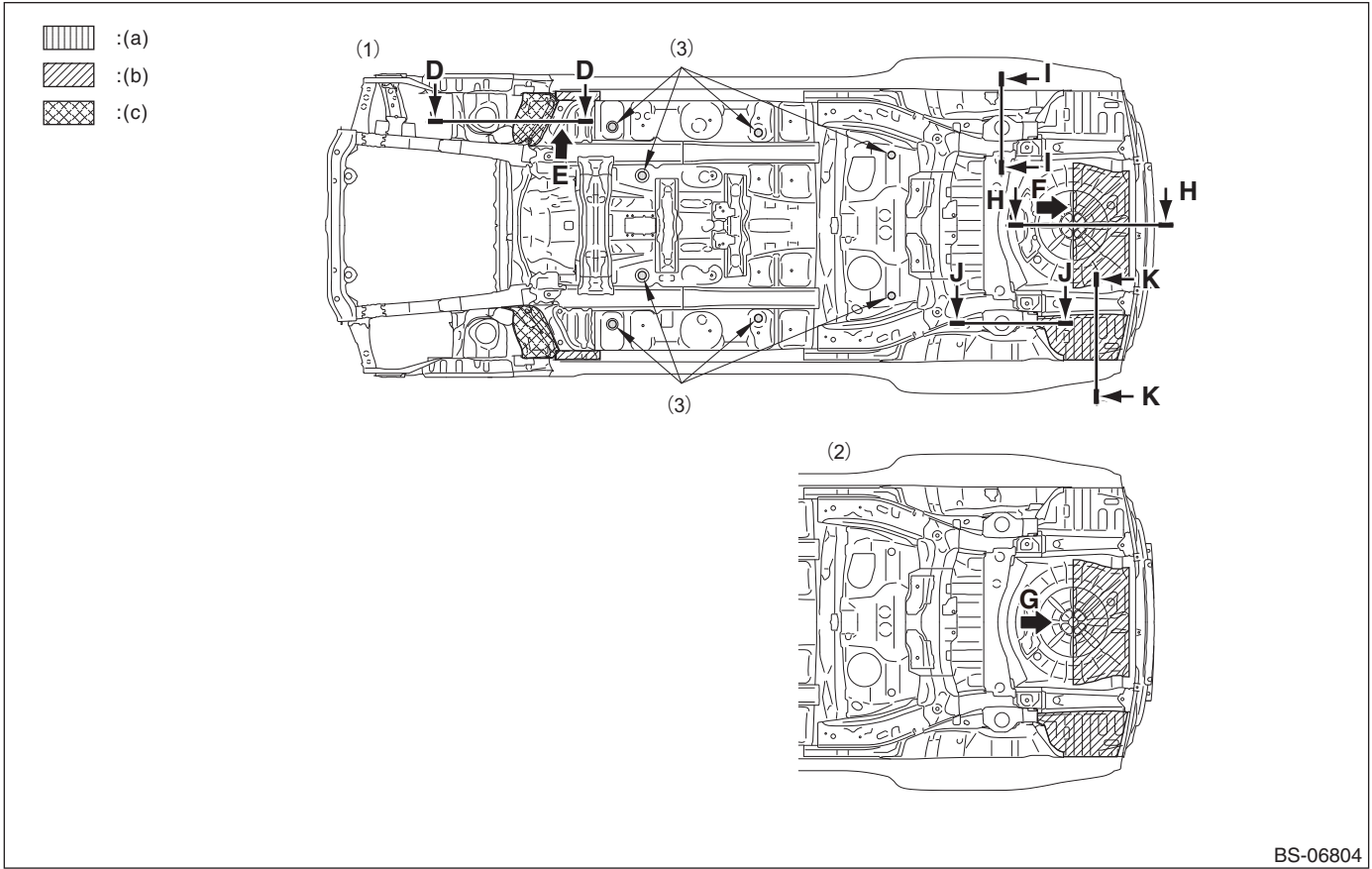
(b) Dry: 780 μm or more,
Wet: 630 μm or more

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

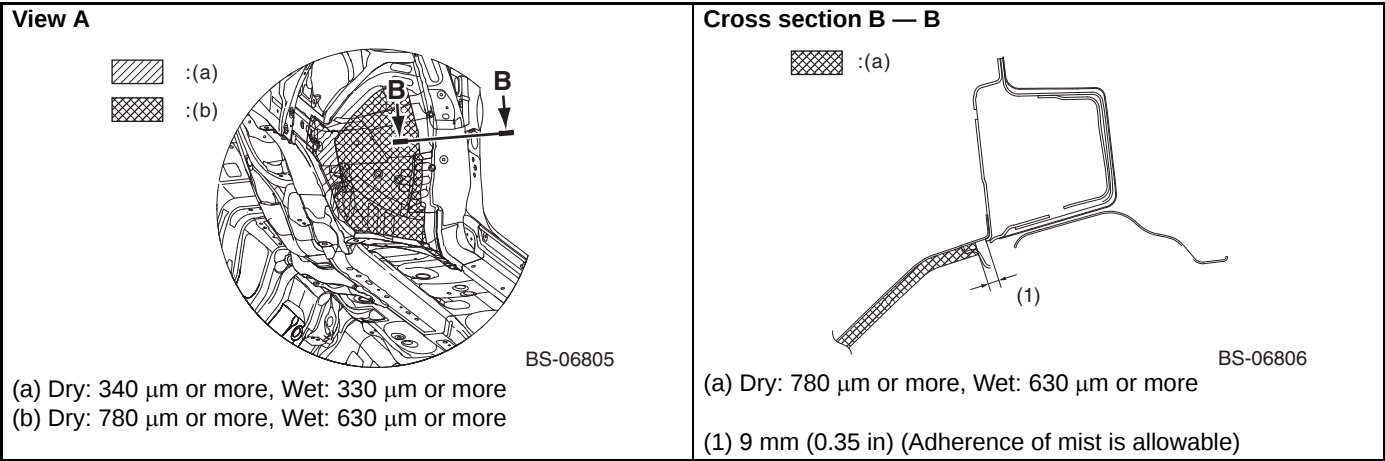
(2) Plug must be covered with PVC

Undercoat

- Bottom view

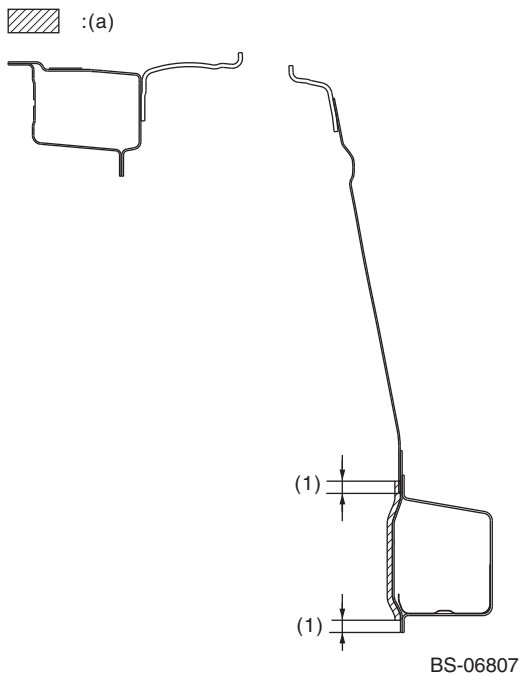


- (a) 200 μm or more (b) Dry: 340 μm or more, Wet: 330 μm or more (c) Dry: 780 μm or more, Wet: 630 μm or more
- (1) OUTBACK (2) SEDAN (3) Plug must be covered with PVC



Undercoat

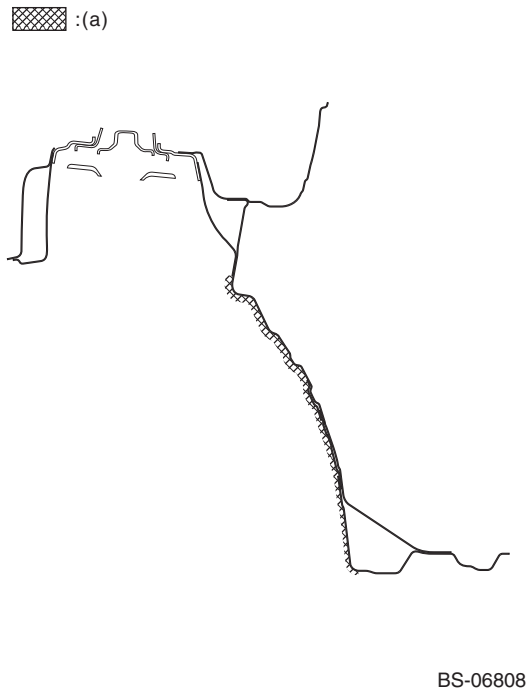
Cross section C — C



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

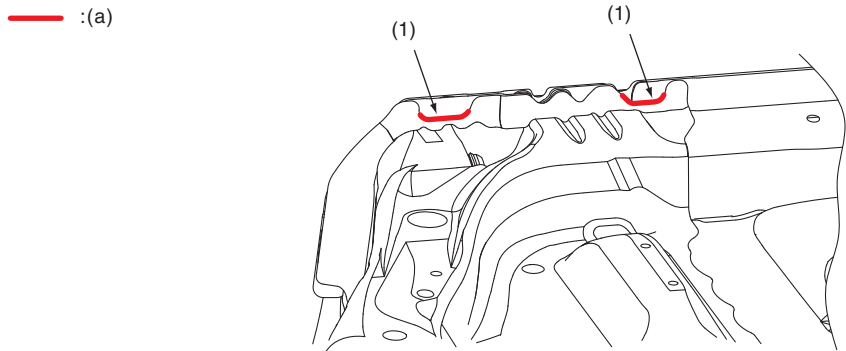
(1) 10 mm (0.39 in) (Adherence of mist is allowable)

Cross section D — D



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

View E



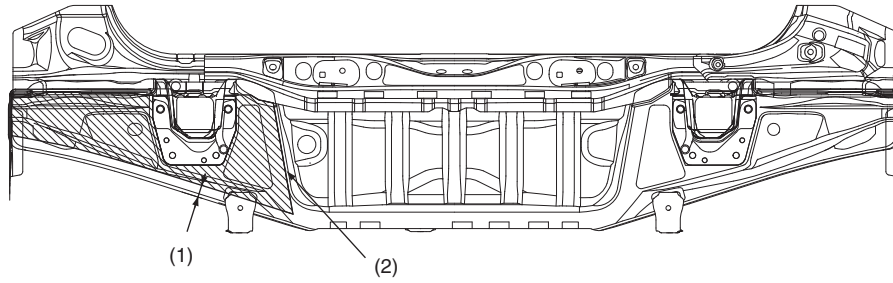
(a) The panel gap shall be filled

(1) Decrease the panel gaps as much as possible.

Undercoat

F View (turned 90° to the right)

 : (a)



BS-07235

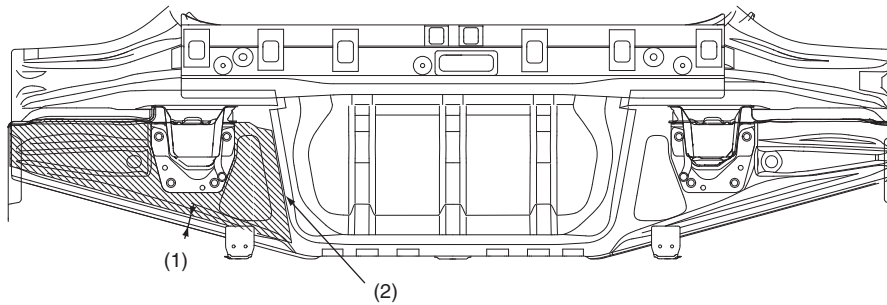
(a) Dry: 340 μm or more, Wet: 330 μm or more

(1) 20 mm (0.78 in) (Adherence of mist is allowable)

(2) Basically, only for the models with single muffler (Application is allowed for the models with dual muffler)

G View (turned 90° to the right)

 : (a)



BS-07236

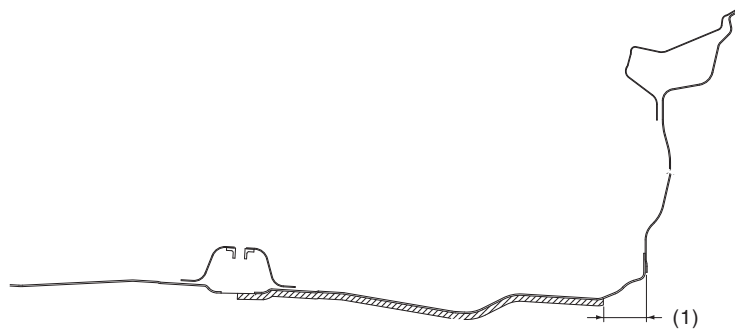
(a) Dry: 340 μm or more, Wet: 330 μm or more

(1) 20 mm (0.78 in) (Adherence of mist is allowable)

(2) Basically, only for the models with single muffler (Application is allowed for the models with dual muffler)

Cross section H — H

 : (a)

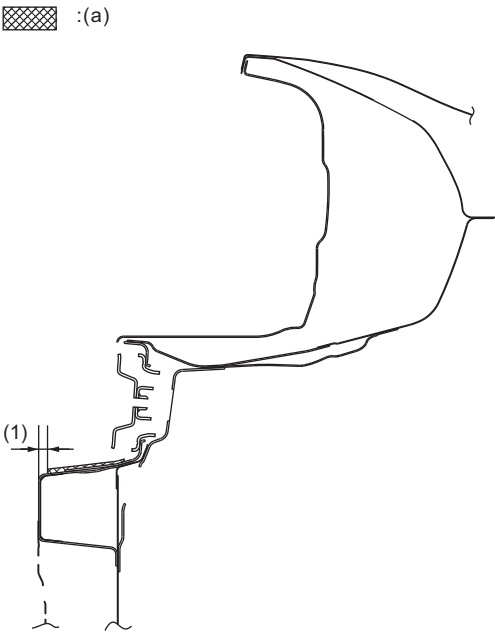
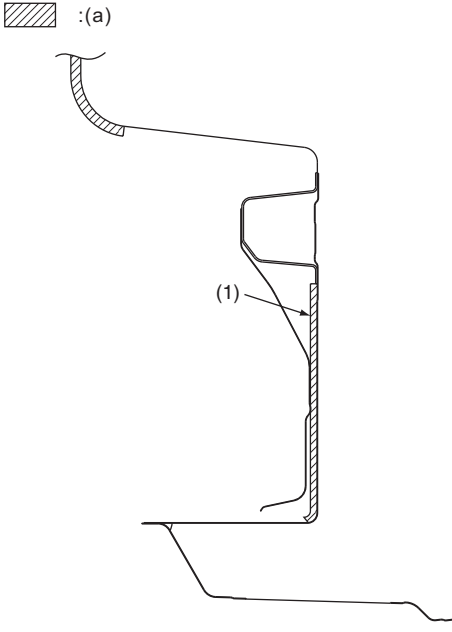
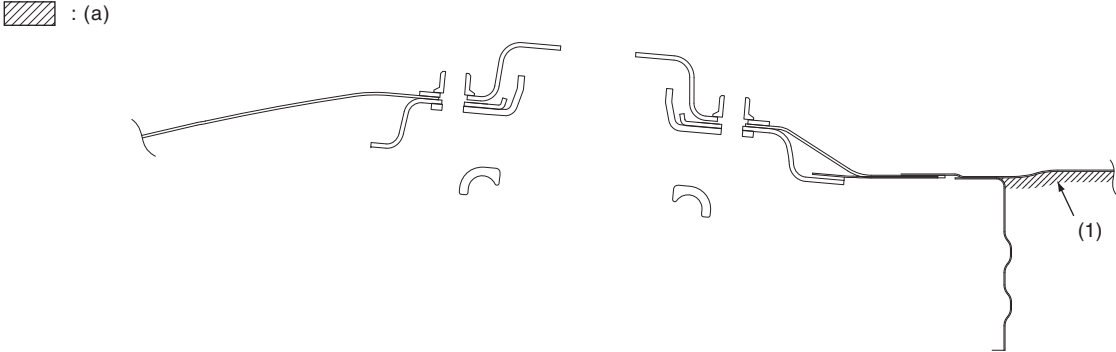


BS-06812

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

(1) 37 mm (1.46 in)

Undercoat

Cross section I — I  BS-07237 (a) Dry: 780 μm or more, Wet: 630 μm or more (1) 10 mm (0.39 in) (Adherence of mist is allowable)	Cross section K — K  BS-06815 (a) Dry: 340 μm or more, Wet: 330 μm or more (1) Basically, only for the models with single muffler (Application is allowed for the models with dual muffler)
Cross section J — J  BS-06814 (a) Dry: 340 μm or more, Wet: 330 μm or more (1) Basically, only for the models with single muffler (Application is allowed for the models with dual muffler)	

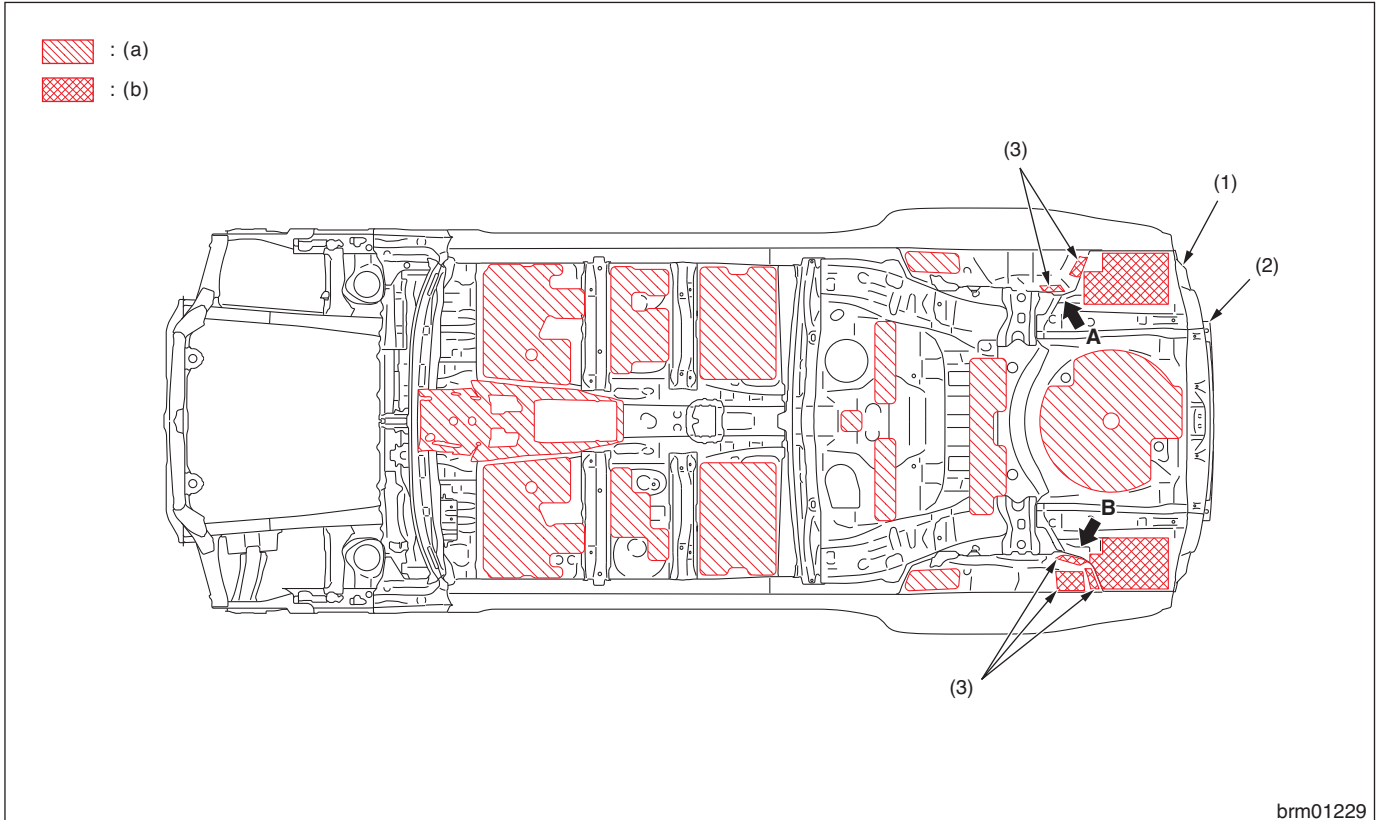
12.Damping Seat

A: SPECIFICATIONS

1. COMMON FOR OUTBACK AND SEDAN

CAUTION:

- If the thickness of the silencer (b) does not meet the standard value, add silencer sheets one by one until the thickness meets the standard value.
- Upper view



(a) Silencer

(b) Thickness of the silencer:
2.5 mm (0.10 in)

(1) OUTBACK

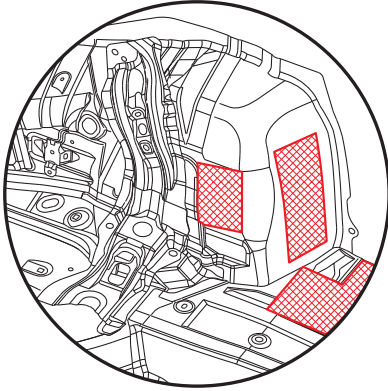
(2) SEDAN

(3) Only OUTBACK

Damping Seat

View A

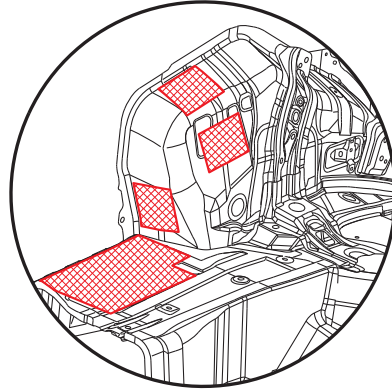
 : (b)



BRM01230

View B (Model without Power Rear Gate)

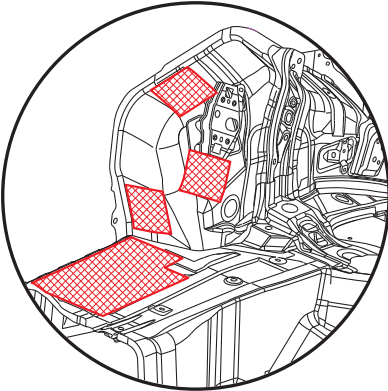
 : (b)



BRM01231

View B (Model with Power Rear Gate)

 : (b)



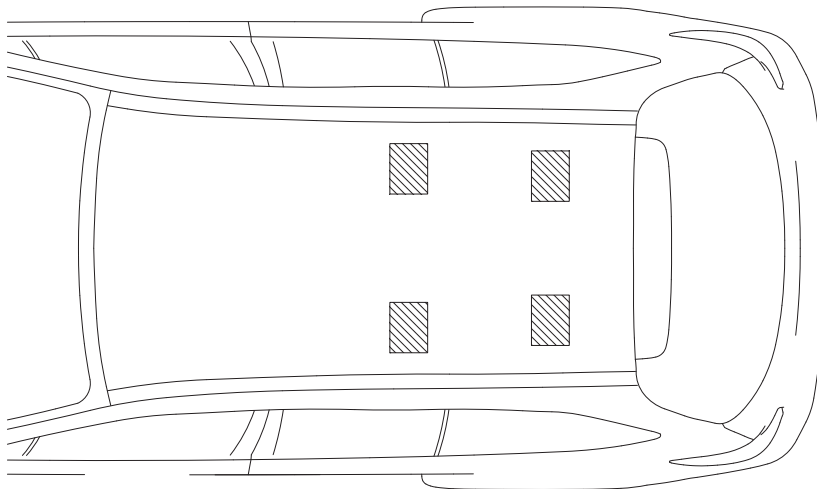
BRM01232

SUBARU.

(b) Thickness of the silencer:
2.5 mm (0.10 in)

2. SPECIAL FOR OUTBACK

 : (a)



BS-06817

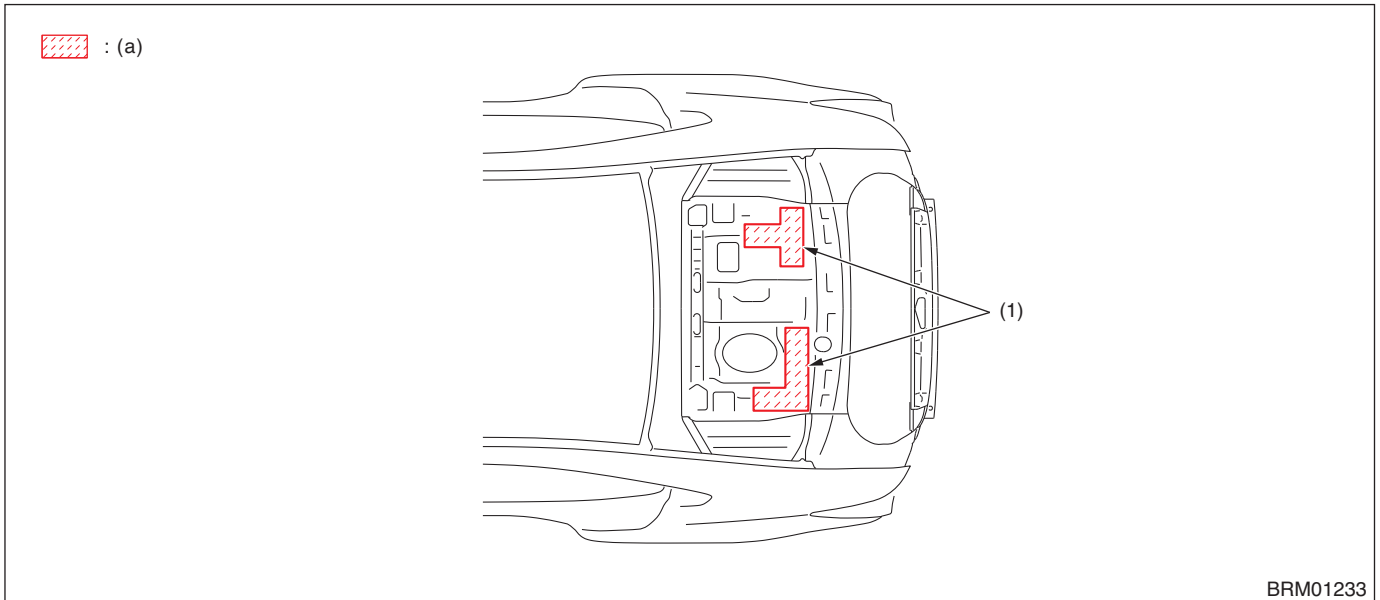
(a) Damping seat

Damping Seat

3. SPECIAL FOR SEDAN

CAUTION:

- If the thickness of the silencer (a) does not meet the standard value, add silencer sheets one by one until the thickness meets the standard value.



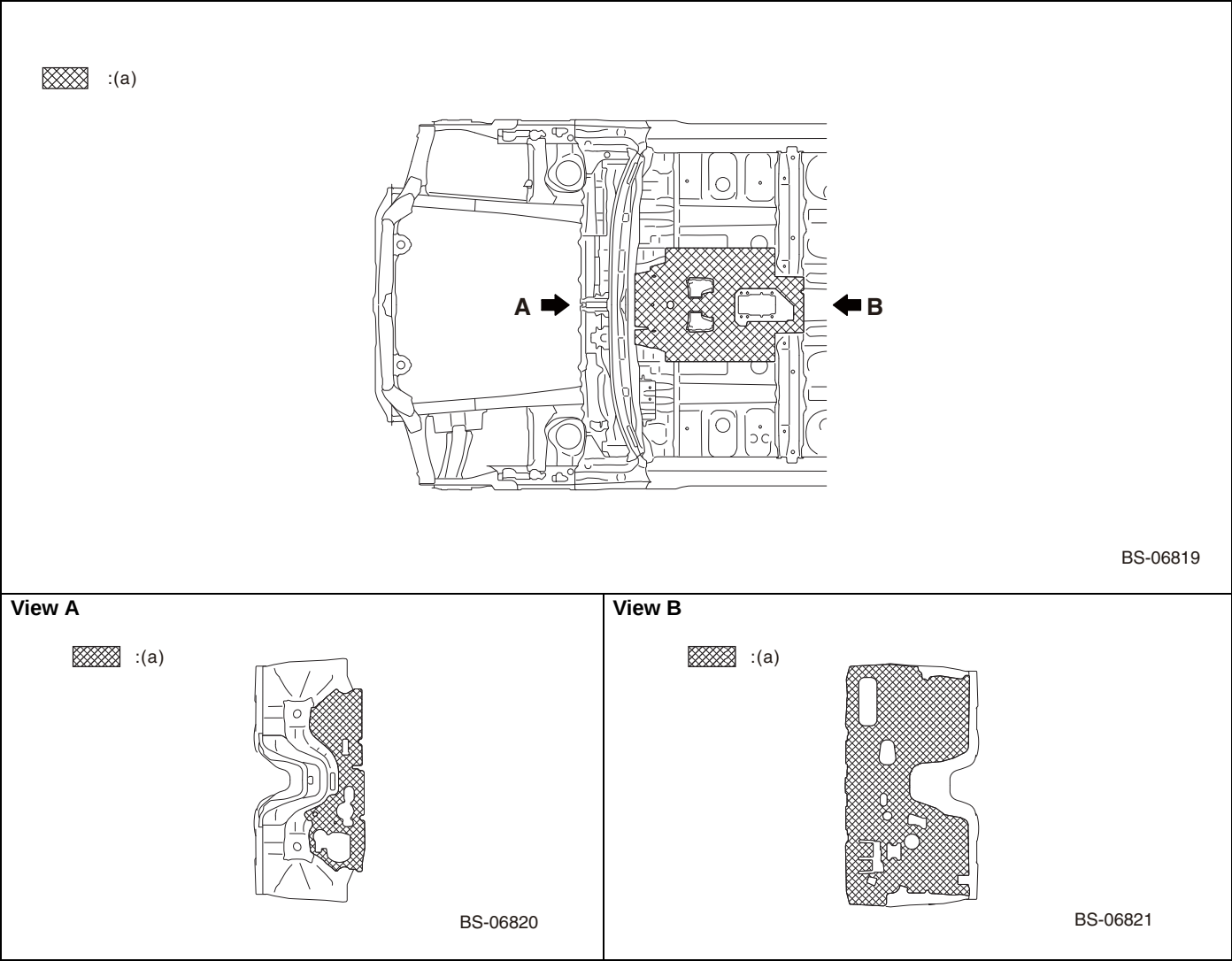
(a) Thickness of the silencer:
5.0 mm (0.20 in)

(1) Only for the models with woofer

13.Insulator

A: SPECIFICATIONS

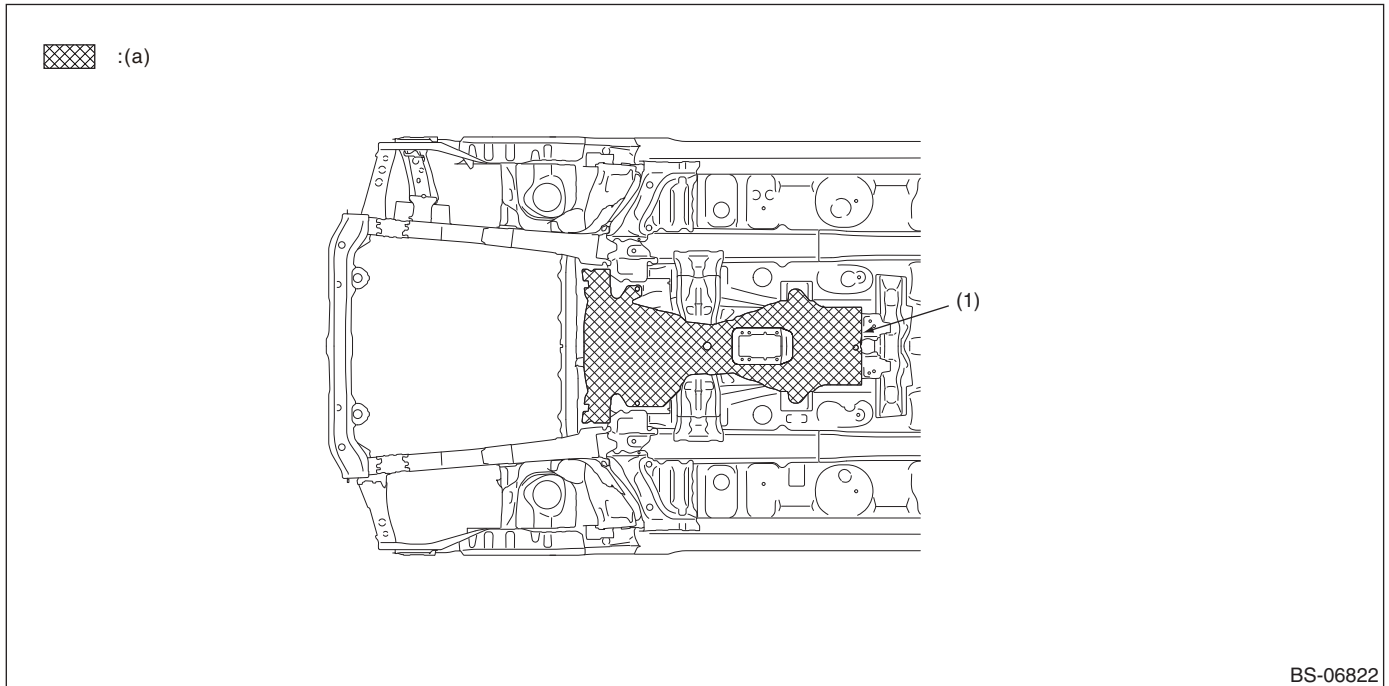
1. UPPER VIEW



(a) Insulator

Insulator

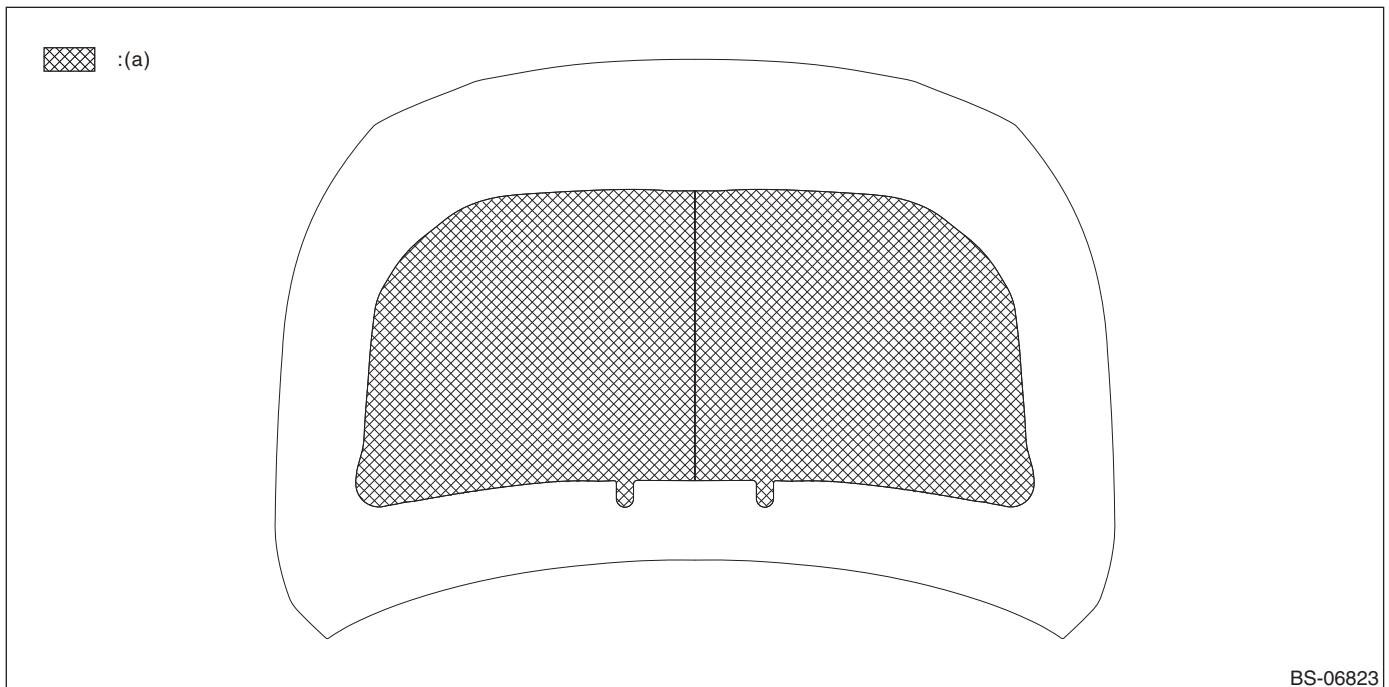
2. BOTTOM VIEW



(a) Insulator

(1) CVT model only

3. FRONT HOOD

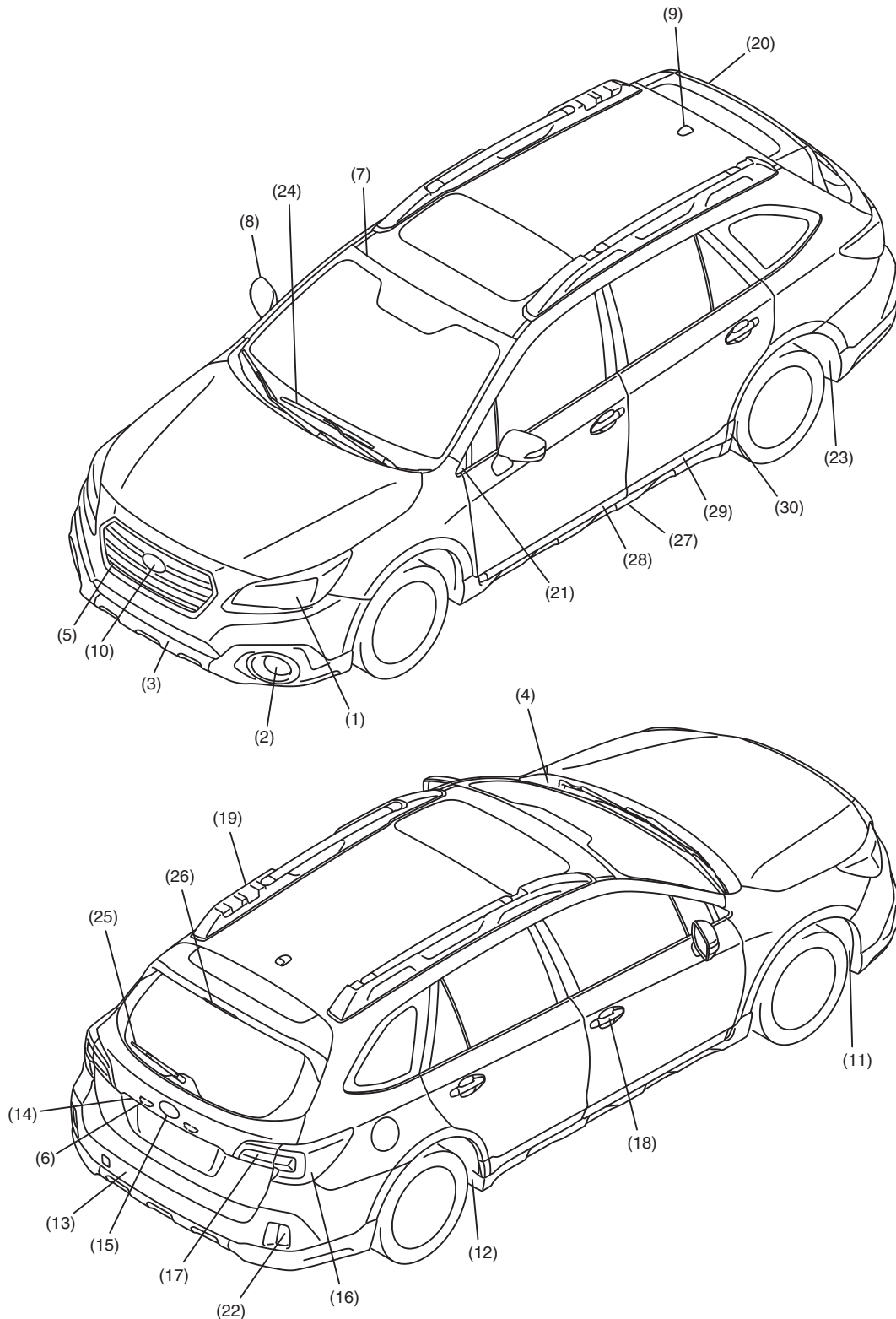


(a) Insulator

14. Plastic Parts and Materials

A: SPECIFICATIONS

1. SPECIAL OUTBACK PARTS AND COMMON OUTBACK & SEDAN PARTS



BS-09732

Plastic Parts and Materials

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

No.	Part name		Material
(1)	(— '17 MY)	Outer lens	PC
		Housing	PP-TD30
		Reflector A	BMC
		Reflector B	PPS
		Reflector	PPS
		Inner lens	PC
		Extension A	PBT
		Extension B	ULTEM
		Side RR	PC
		Light guide A, B	PC
		Base	PC
		Bracket B	PP
	('18 MY —)	Lens HL	PC
		Lens RR	PMMA
		Housing	PP-TD30
		Reflector HL	BMC
		Reflector 1, 3	PBT
		Inner lens 1, 2, 3	PC
		Extension 1, 2	PBT
		Retainer	PBT
		Bracket A	PP-GF30
		Bracket B	PP-GF30
	(— '17 MY)	Outer lens	PC
		Housing	PP-TD30
		Reflector A	BMC
		Reflector B	PPS
		Reflector	PPS
		Inner lens A	PC
		Extension A	PBT
		Extension B	ULTEM
		Side RR	PC
		Light guide A, B	PC
		Base	PC
		Bracket B	PP-GF40

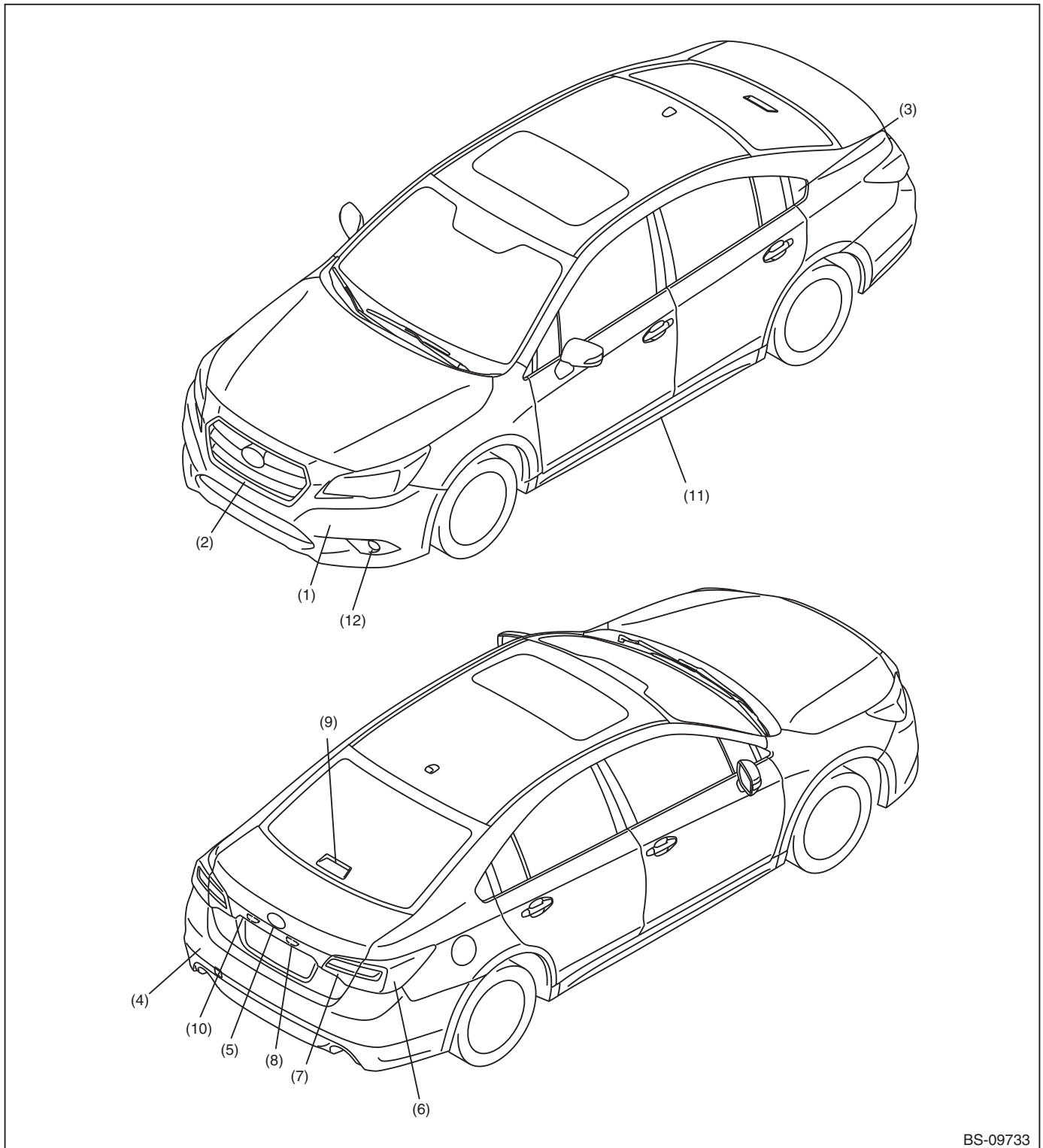
Plastic Parts and Materials

No.	Part name		Material
(1)	('18 MY —) Headlight (LED)	Lens HL	PC
		Lens RR	PMMA
		Housing	PP-TD30
		Reflector 1, 3	PBT
		Inner lens 1, 2, 3, 5	PC
		Extension 1	PBT
		Retainer	PBT
		Bracket A	PP-GF30
		Bracket B	PP-GF30
(2)	Front fog light	Lens	PC
		Reflector	UP-M60-GF10
		Bracket	PP-GF30
(3)	Front bumper	Sealing bumper	EPDM
		Face	PP
		Bumper cover	PP
		Hook cover	PP
		Side bracket	POM
		Corner bracket	PP-GF30
		Center lower bracket	PP
		EA form	PP
(4)	Cowl panel	Body	PP-TD10
		Side	PP-TD10
(5)	(— '17 MY) Front grill	Grill	ABS+AES+PP
		Ornament	ABS+PMMA
	('18 MY —) Front grill	Grill	ABS+ASA
		Ornament	ABS+PMMA
(6)	License light	Lens	PC
		Housing	PC
(7)	Front window moulding		PVC
(8)	(— '17 MY) Door mirror	Body	AES
		Cover body	ASA
		Cover front	ABS
		Cover stay A	ASA
		Cover stay B	ASA
		Holder	PP
		Side turn light	Housing
			Lens
		Packing stay	TPO
	('18 MY —) Door mirror	Body	ASA
		Cover body	ASA
		Cover front	ABS
		Cover stay A	ASA
		Cover stay B	ASA
		Holder	ASA
		Side turn light	Housing
			Lens
			Inner lens
		Packing stay	TPO
(9)	Antenna		PC+ASA
(10)	Ornament front		ABS+PMMA

Plastic Parts and Materials

No.	Part name		Material
(11)	Front mudguard	Body	PE
		Air flap	PE+EPDM
(12)	Air flap Rear		PP+EPDM
(13)	Rear bumper	Face	PP
		Hook cover	PP
		Side bracket	POM
		Corner bracket	PP-GF30
		EA form	PP
		Cap bolt	PP
(14)	Rear gate garnish		PC-PET
(15)	Ornament rear		ABS+PMMA
(16)	Rear combination light	Outer lens 1st	PMMA
		Outer lens 2nd	PMMA
		Housing	ASA
		Inner lens	PMMA
		Extension	PC
		Base	PC
(17)	Rear finisher light	Outer lens 1st	PMMA
		Outer lens 2nd	PMMA
		Housing	ASA
(18)	Door handle	Handle	PC+PBT
		Handle cover	PC+PBT
(19)	Roof rail	Roof rail cover	TPO
		Roof rail inner	PA6-GF40
(20)	Roof spoiler	Body	AES
(21)	A pillar cover		AES
(22)	Rear reflex reflector	Lens	PMMA
		Housing	ASA
(23)	Rear mudguard		PE
(24)	Front wiper	Blade	PBT-GF30
(25)	Rear wiper	Blade	PBT-GF30
(26)	High mount stop light	Lens	PMMA
		Housing	ABS
(27)	Side sill garnish		PP
(28)	Front door garnish		PP
(29)	Rear door garnish		PP
(30)	Rear quarter garnish		PP
	Undercover		PP
	Splash board		PP

2. SPECIAL SEDAN PARTS



BS-09733

- | | | |
|--------------------|----------------------------|---------------------------|
| (1) Front bumper | (5) Ornament rear | (9) High mount stop light |
| (2) Front grill | (6) Rear combination light | (10) Trunk garnish |
| (3) C pillar cover | (7) Rear finisher light | (11) Side spoiler |
| (4) Rear bumper | (8) License light | (12) Front fog light |

Plastic Parts and Materials

No.	Part name		Material
(1)	(— '17 MY)	Face	PP
		Fog light cover	PP
		Side bracket	POM
		Corner bracket	PP-GF30
		Center lower bracket	PP
		EA form	PP
	('18 MY —)	Face	PP
		Fog light cover	Without fog light PP+ASA
			With fog light PP+ABS
		Side bracket	POM
		Corner bracket	PP-GF30
		Center lower bracket	PP
		EA form	PP
(2)	Front grill (— '17 MY)	Grill	ABS+AES+PP
	Front grill ('18 MY —)	Grill	ABS+ASA
(3)	C pillar cover		AES
(4)	(— '17 MY)	Face	PP
		EA form	PP
		Hook cover	PP
		Side bracket	POM
		Corner bracket	PP-GF30
		Muffler cover	PP
		Cap bolt	PP
	('18 MY —)	Face	PP
		EA form	PP
		Hook cover	PP
		Side bracket	POM
		Corner bracket	PP-GF30
		Muffler cover	PP
		Muffler bracket	PA12
		Cap bolt	PP
(5)	Ornament rear		ABS+PMMA
(6)	Rear combination light	Outer lens 1st	PMMA
		Outer lens 2nd	PMMA
		Housing	ASA
		Inner lens	PMMA
		Rear RR	PMMA
		Extension	PC
		LED base	PC
(7)	Rear finisher light	Outer lens 1st	PMMA
		Outer lens 2nd	PMMA
		Housing	ASA
		Reflector	PC
		Bezel	ASA
(8)	License light	Lens	PC
		Housing	PC
(9)	High mount stop light	Lens	PC
		Housing	PP-TD20
		Cover	PP-TD20
(10)	Trunk garnish		PC+PET
(11)	Side spoiler		PP

Plastic Parts and Materials

No.	Part name		Material
(12)	(— '17 MY)	Lens	PC
	Front fog light	Reflector	PC
		Bracket	PP-TD30
	(— '17 MY)	Bracket	PP-GF40
	Front fog light (SRF)		
	('18 MY —)	Lens	PC
		Housing	PC
		Bracket	PP-GF40

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)	PP	Polypropylene
AES	Acrylonitrile/ethylene styrene	PP-GF30	Polypropylene (30 % glass fiber content)
ASA	Acrylonitrile/styrene acrylate	PP-GF40	Polypropylene (40 % glass fiber content)
BMC	Premix molding compound	PPS	Polyphenylene sulfide
EPDM	Ethylene/propylene/dien rubber	PP-TD10	Polypropylene (10 % talc content)
PA6-GF40	Polyamide (nylon) (40 % glass fiber content)	PP-TD20	Polypropylene (20 % talc content)
PA12	Polyamide (nylon)	PP-TD30	Polypropylene (30 % talc content)
PBT	Polybutylene terephthalate	PVC	Polyvinyl chloride
PC	Polycarbonate	TPE	Thermoplastic elastomer
PE	Polyethylene	TPO	Thermo polyolefin
PET	Polyethylene terephthalate	ULTEM	Ultem resin
PMMA	Polymethyl methacrylate	UP-M60-GF10	Unsaturated polyester 60% mineral powder (10 % glass fiber content)
POM	Polyacetal		