

This service manual has been prepared to provide SUBARU service personnel with the necessary information and data for the correct repair of SUBARU vehicles.

Please peruse and utilize this manual thoroughly and make the most of it to give better service to your customers.

When replacement of parts during repair work is needed, be sure to use SUBARU genuine parts.

All information, illustration and specifications contained in this manual are based on the latest product information available at the time of publication approval.

BODY STRUCTURE

BS

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Foreword

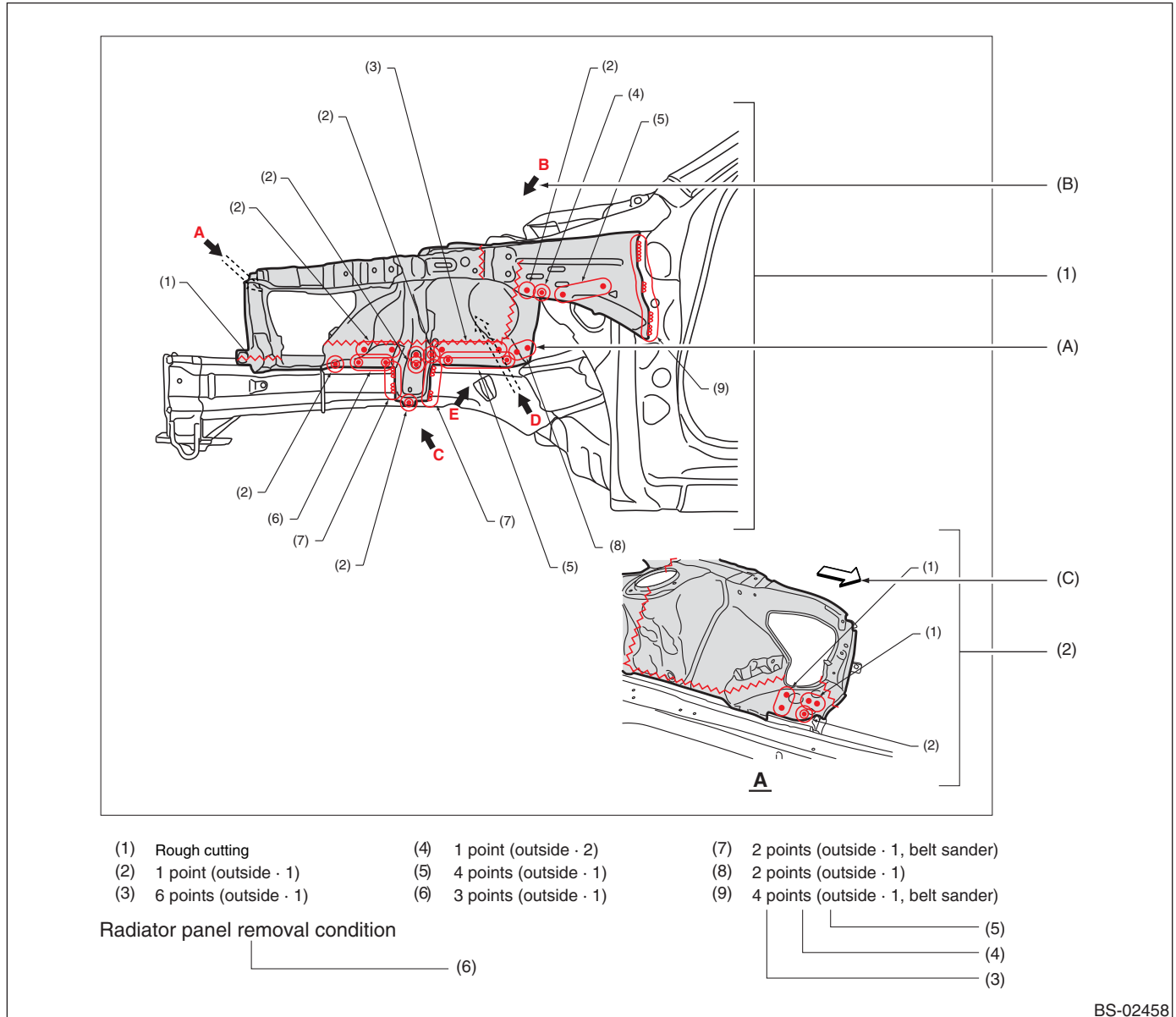
1. Foreword

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).

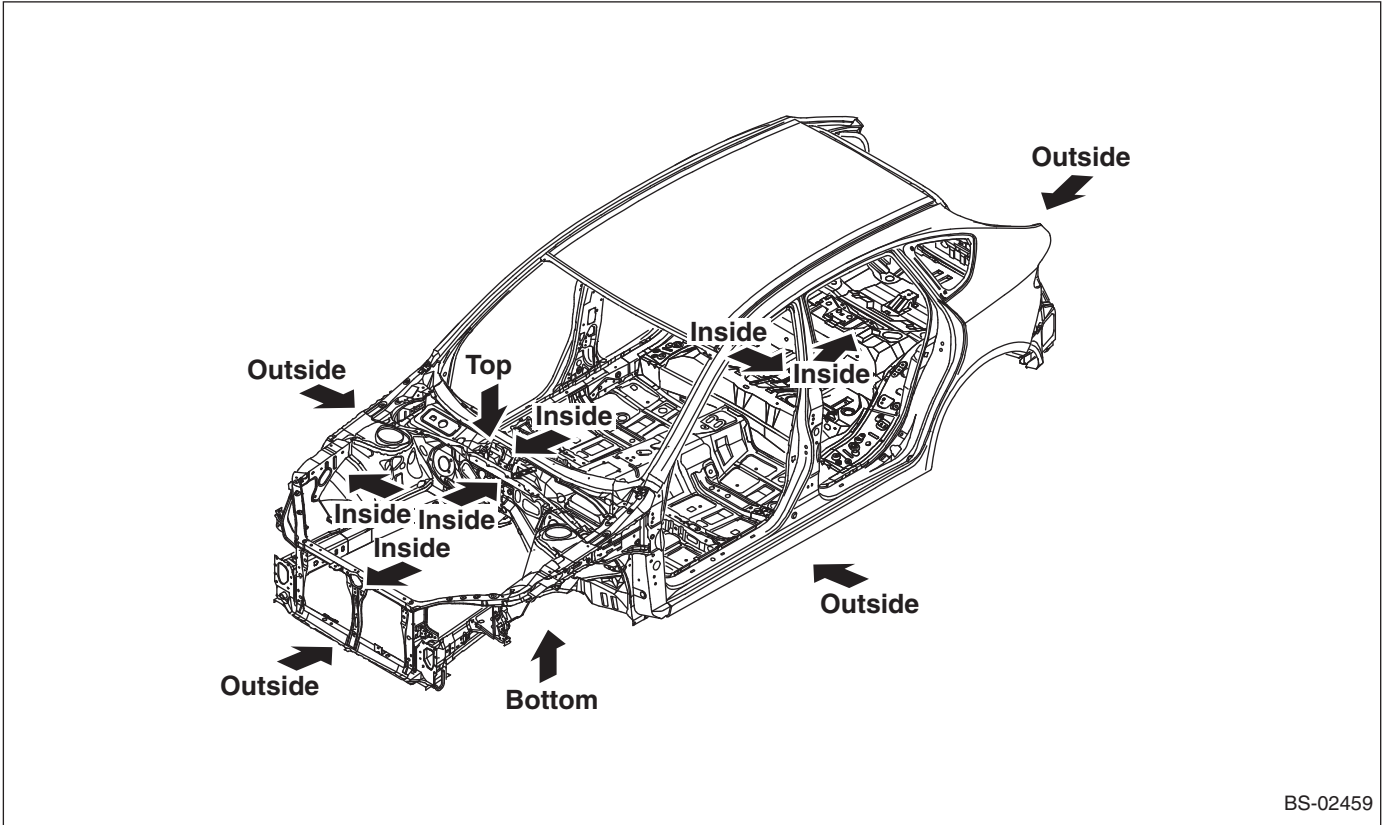


- | | |
|------------------------------------|--|
| (1) Overall view | (A) Welding method |
| (2) View | (B) View direction |
| (3) Number of welding points etc. | (C) Direction towards the front of the vehicle |
| (4) Removal direction | |
| (5) Number of plates to be drilled | |
| (6) Cautions for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

Foreword

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.

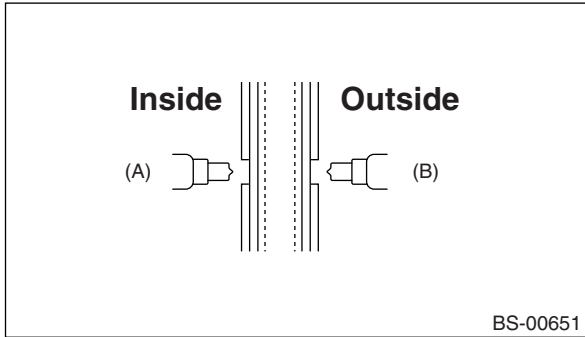


Foreword

3. NUMBER OF PANELS TO BE DRILLED

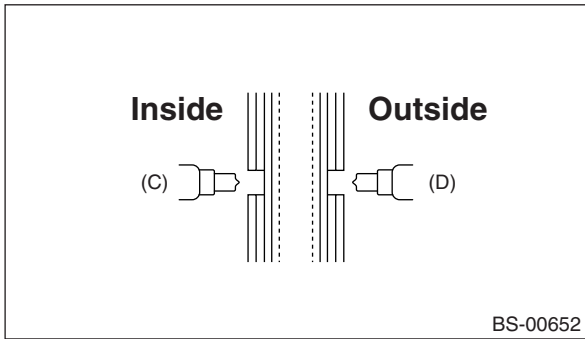
Depending on the number of panels, drilling is done through one panel or two panels, and this number is listed together with the removal direction.

(1) Drilling through one plate



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

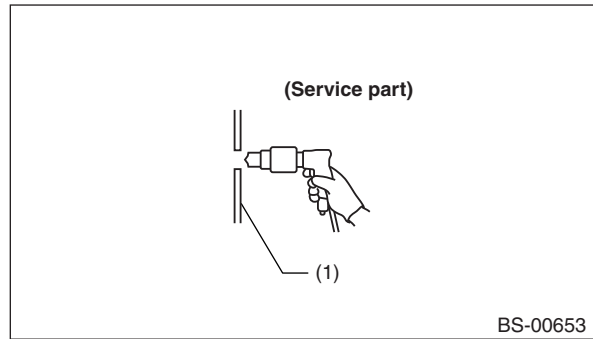
(2) Drilling through two plates



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

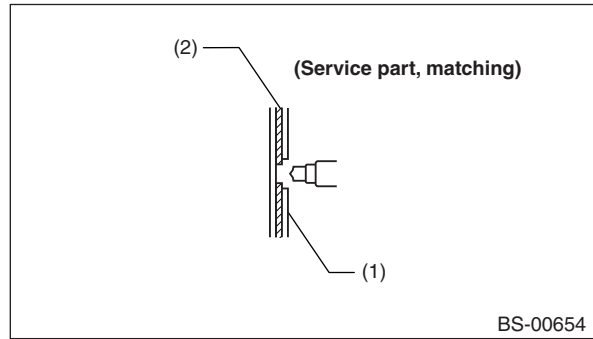
4. HOLE DRILLING FOR PLUG WELDING

(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

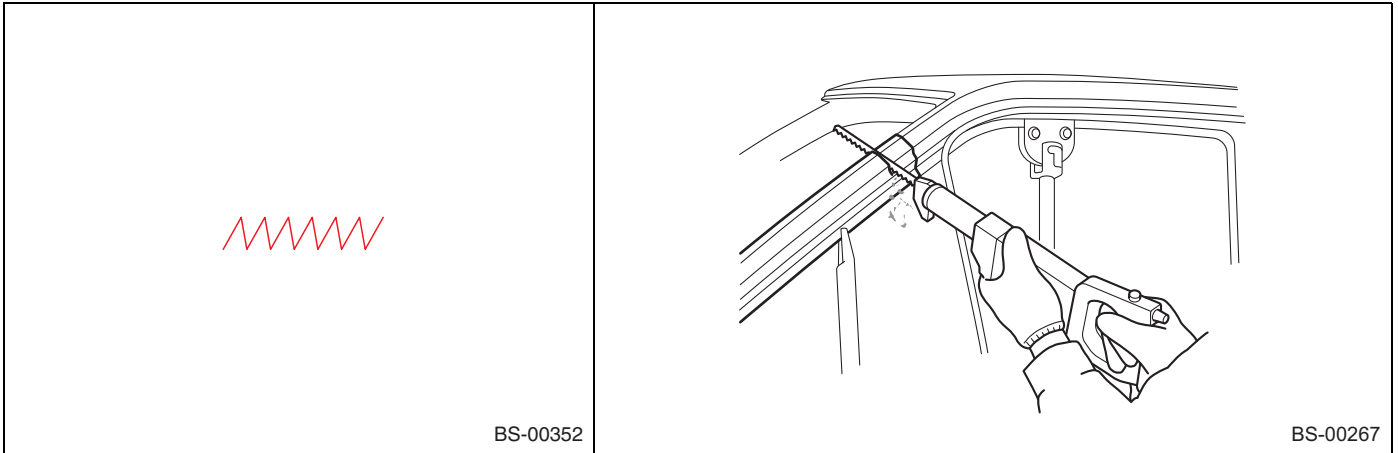


- (1) Vehicle side
- (2) Service part

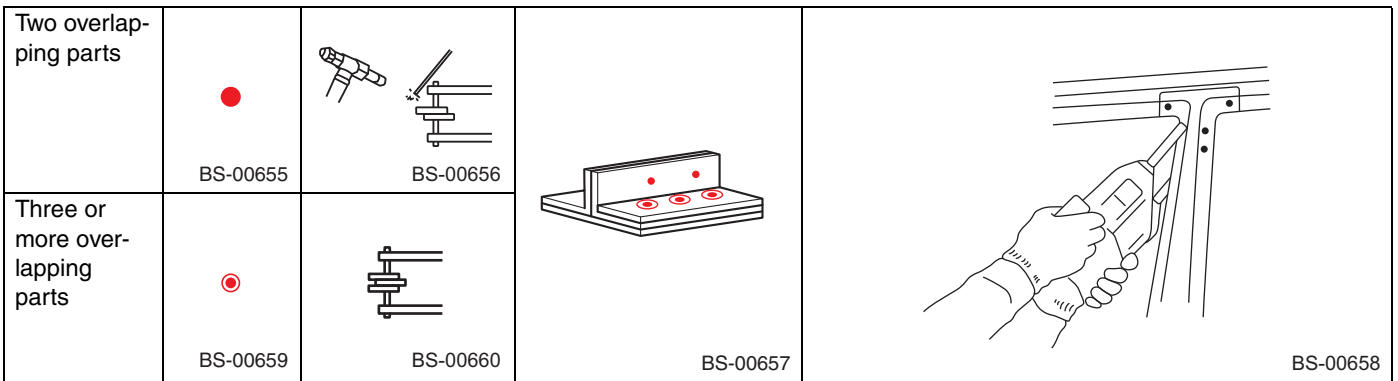
Foreword

5. MEANING OF SYMBOLS

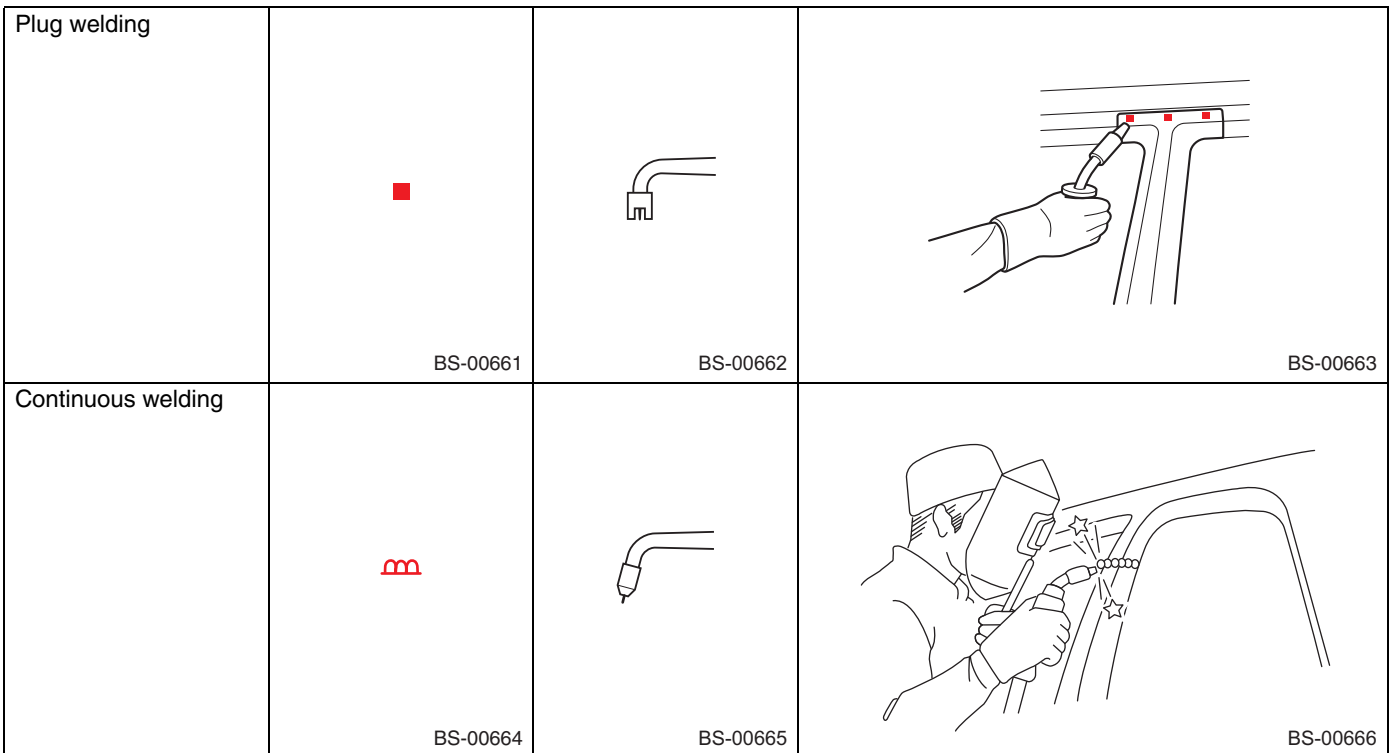
- Cutting



- Spot welding


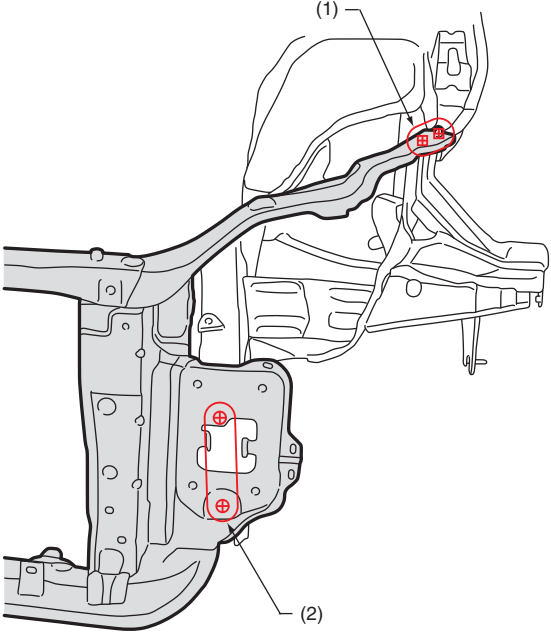



- Carbon dioxide gas arc welding (MIG welding)



Foreword

- Bolt, nut tightening portion

Bolt	 BS-04481	 BS-04483
Nut	 BS-04482	

B: CAUTION

Use a DC inverter welding machine for spot welding in places where high-strength steel plate is used so as to stably form nuggets when welding. However, use an AC welding machine for joining plates of 1,500 MPa class high-strength steel.

Foreword

C: NOTE

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

To drill high-strength steel sheets of 980 MPa class, 1180 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, 1180 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] — [r])
- When conditions can't be met, it is recommended to use the plug welding method [y] — A or [y] — B as described below.

Spot welding	[a]	Compression	3.5 kN	Total number of 2 overlapping sheets	
		Current	7.5 kA		
		Welding time	16 cyc		
	[b]	Compression	4.0 kN		
		Current	8.0 kA		
		Welding time	15 cyc		
	[c]	Compression	4.0 kN		
		Current	8.0 kA		
		Welding time	22 cyc		
	[j]	Compression	3.0 kN	Total number of 3 overlapping sheets	
		Current	7.0 kA		
		Welding time	18 cyc		
	[k]	Compression	3.0 kN		
		Current	8.0 kA		
		Welding time	25 cyc		
	[m]	Compression	3.5 kN		
		Current	7.5 kA		
		Welding time	16 cyc		
[n]	Compression	4.0 kN			
	Current	7.5 kA			
	Welding time	30 cyc			
[p]	Compression	4.0 kN			
	Current	8.0 kA			
	Welding time	22 cyc			
[q]	Compression	4.0 kN			
	Current	8.0 kA			
	Welding time	25 cyc			
[r]	Compression	4.0 kN			
	Current	10.0 kA			
	Welding time	22 cyc			
Plug welding	[y]	A	Plug diameter	8.5 mm or more	Total number of 2 or 3 overlapping sheets
			Wire	YGW12	
			Gas	CO ₂	
		B	Plug diameter	8.5 mm or more	
			Wire	YGW16	
			Gas	Gas mixture (argon: 80 %, CO ₂ : 20 %)	

Foreword

CAUTION:

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

2. Drill holes for plug welding of steel sheet

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

Plate thickness of the welding material	Plug welding hole diameter
Less than 1.0 mm (0.04 in)	φ 5.0 mm (0.20 in) or more
1.0 mm — 1.6 mm (0.04 — 0.06 in)	φ 6.5 mm (0.26 in) or more
1.7 mm — 2.3 mm (0.07 — 0.09 in)	φ 8.0 mm (0.31 in) or more
2.4 mm (0.09 in) or more	φ 10.0 mm (0.39 in) or more

3. Repair work using foam

CAUTION:

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

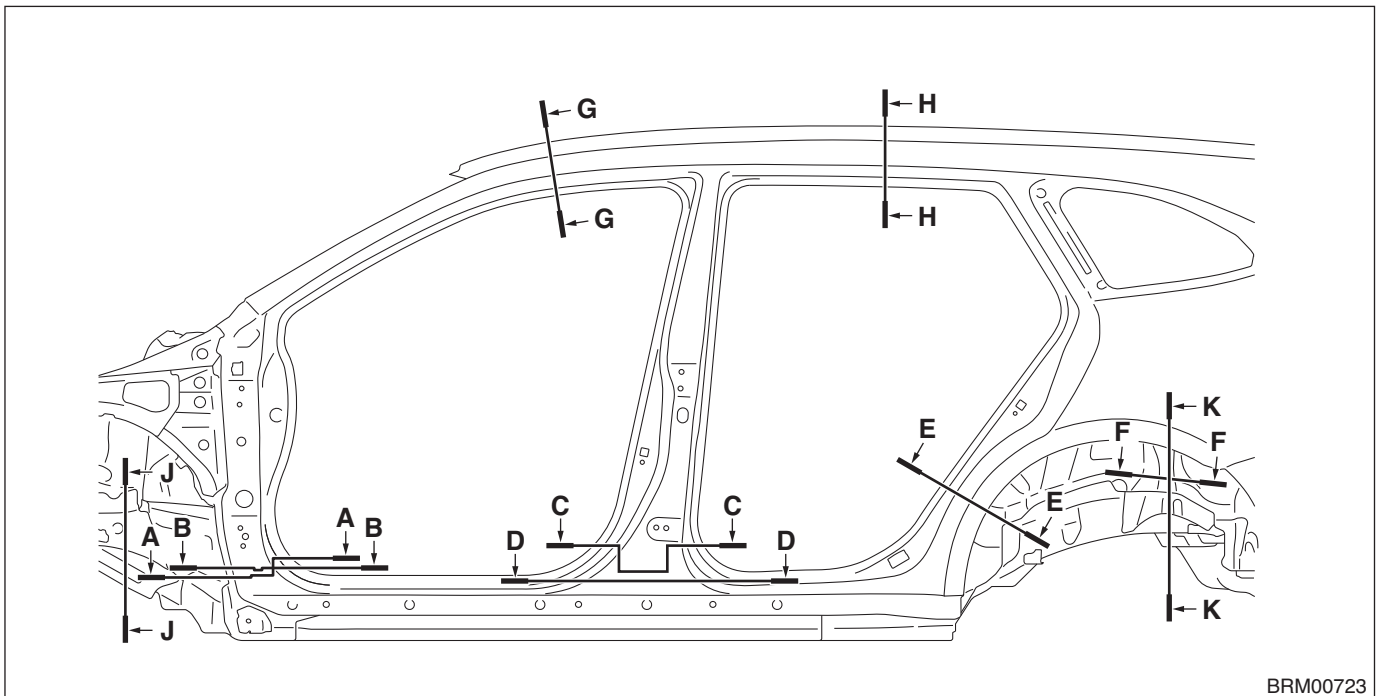
Recommended materials: Equivalent to High Span Foam made by Cemedine

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

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

- Foam injection locations

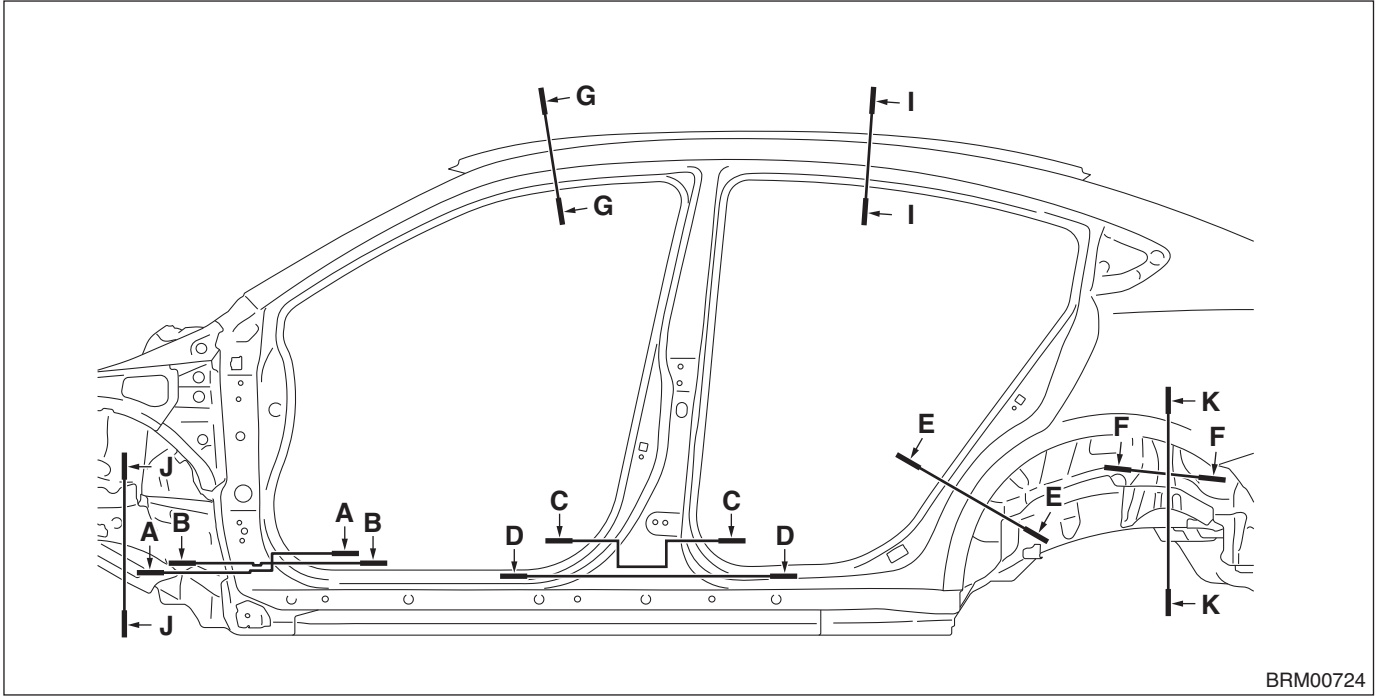
OUTBACK



BRM00723

Foreword

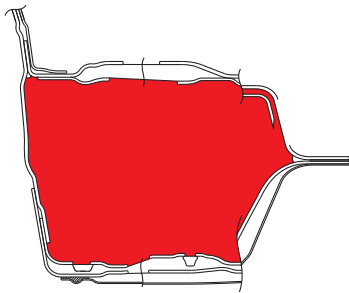
SEDAN



BRM00724

Cross section A — A

 : (a)

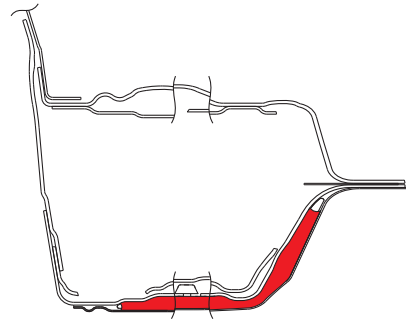


BRM00725

(a) Urethane foam injection locations

Cross section B — B

 : (a)

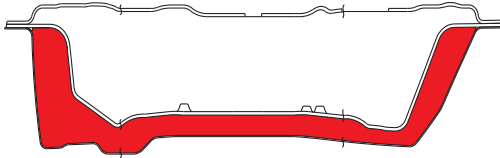


BRM00726

(a) Urethane foam injection locations

Cross section C — C

 : (a)



BRM00727

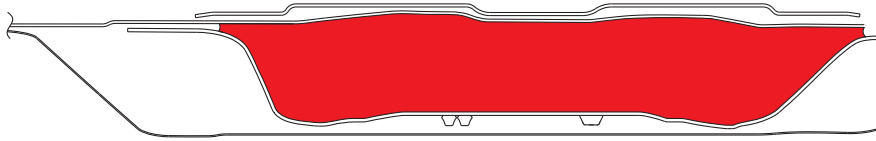
(a) Urethane foam injection locations

SUBARU.

Foreword

Cross section D — D

 : (a)

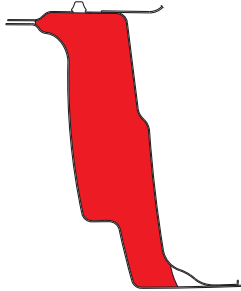


BRM00728

(a) Urethane foam injection locations

Cross section E — E

 : (a)

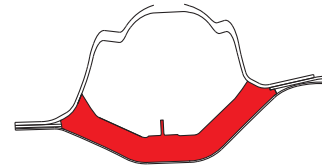


BRM00729

(a) Urethane foam injection locations

Cross section F — F

 : (a)

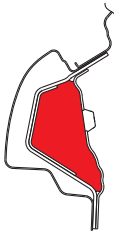


BRM00730

(a) Urethane foam injection locations

Cross section G — G

 : (a)

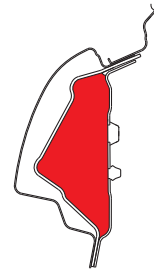


BRM00731

(a) Urethane foam injection locations

Cross section H — H

 : (a)



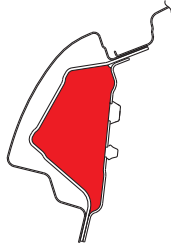
BRM00732

(a) Urethane foam injection locations

Foreword

Cross section I — I

 : (a)

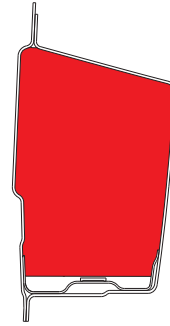


BRM00733

(a) Urethane foam injection locations

Cross section J — J

 : (a)

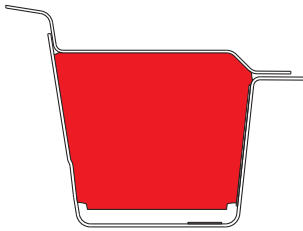


BRM01115

(a) Urethane foam injection locations

Cross section K — K

 : (a)



BRM01116

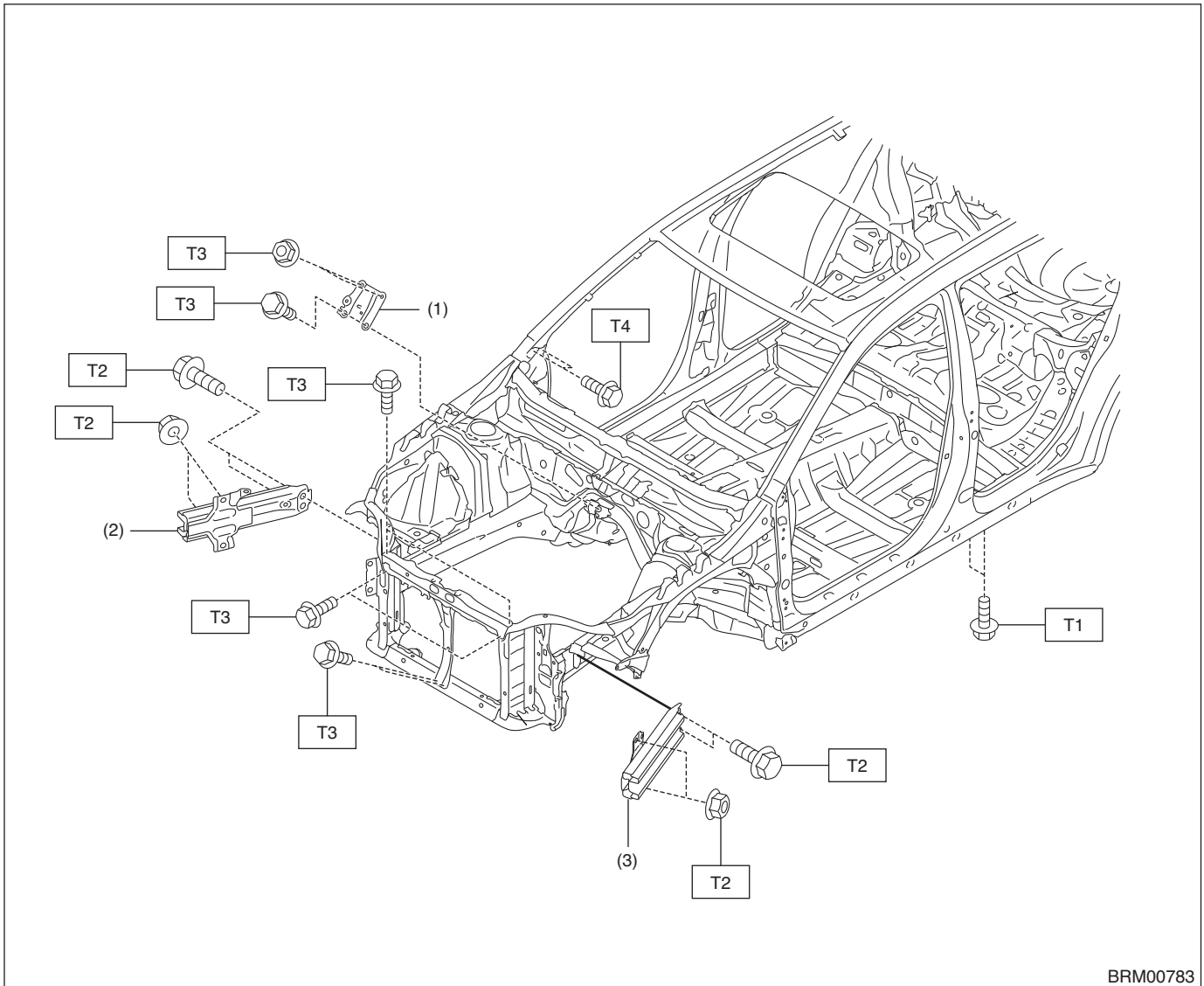
(a) Urethane foam injection locations

SUBARU.

Assembly of Exterior Parts

2. Assembly of Exterior Parts

A: BODY REINFORCING PARTS



- (1) Plate pitching stopper complete
- (2) Gusset complete front side RH
- (3) Gusset complete front side LH

Tightening torque: N·m (kgf-m, ft-lb)

T1: 45 (4.59, 33.19)

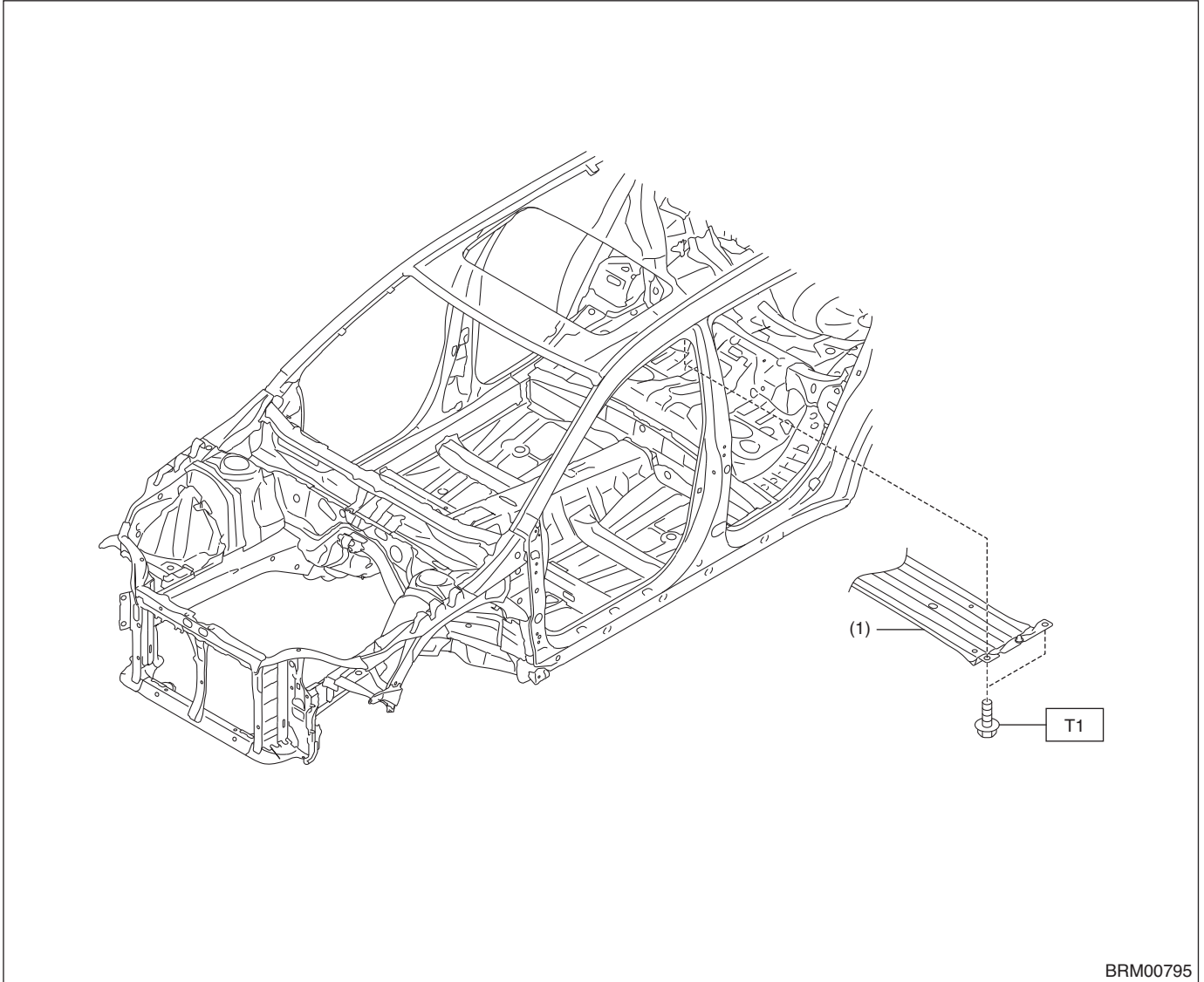
T2: 37 (3.77, 27.3)

T3: 18 (1.84, 13.28)

**T4: Secure 18 (1.84, 13.28) or more.
The bolts should be seated and not broken.**

Assembly of Exterior Parts

B: Bracket brace (Model with sunroof)



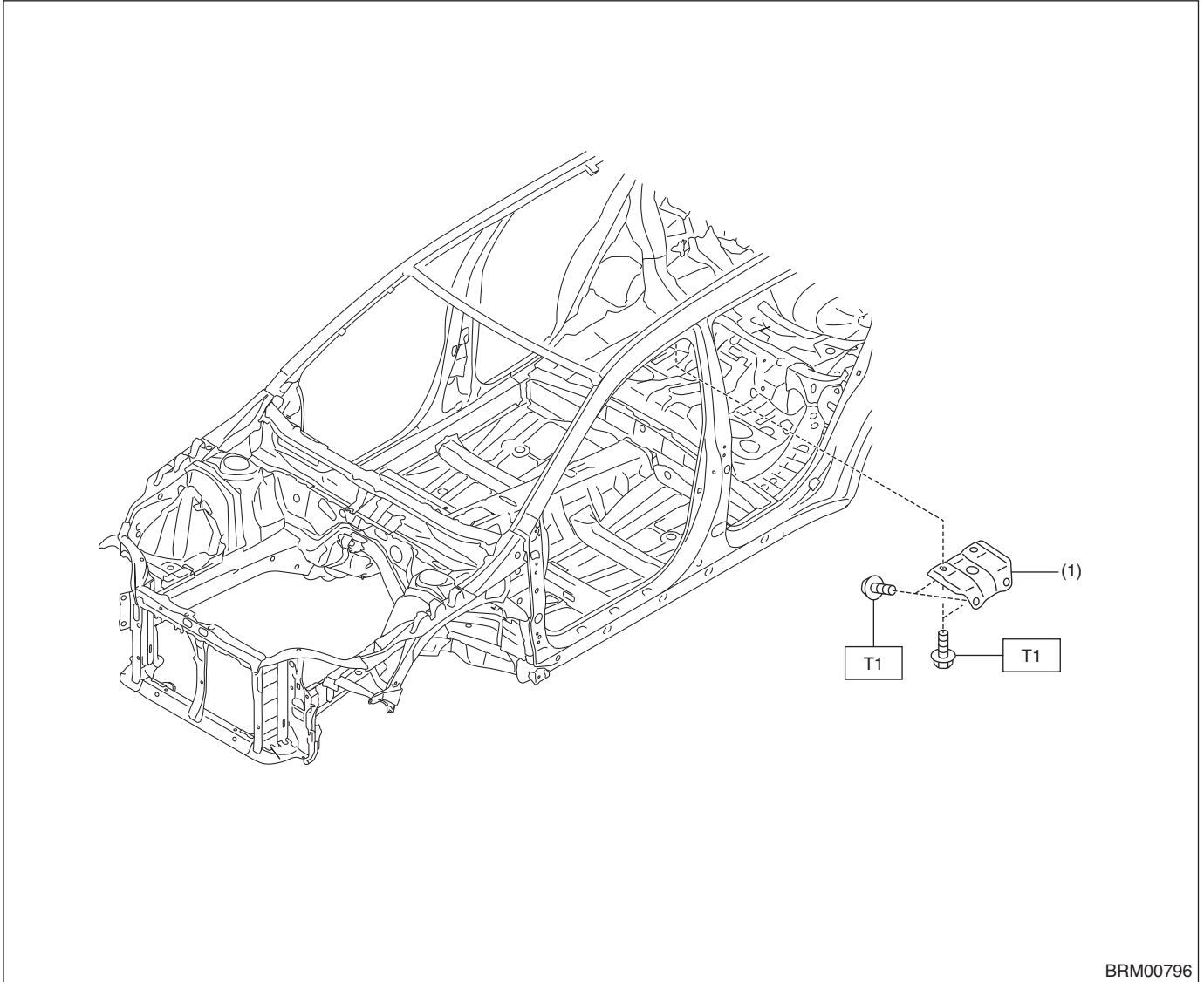
BRM00795

(1) Brace complete center lower

Tightening torque: N·m (kgf·m, ft·lb)
T1: 12.7 (1.29, 9.37)

Assembly of Exterior Parts

C: Bracket brace (Model without sunroof)



BRM00796

(1) Bracket brace normal roof

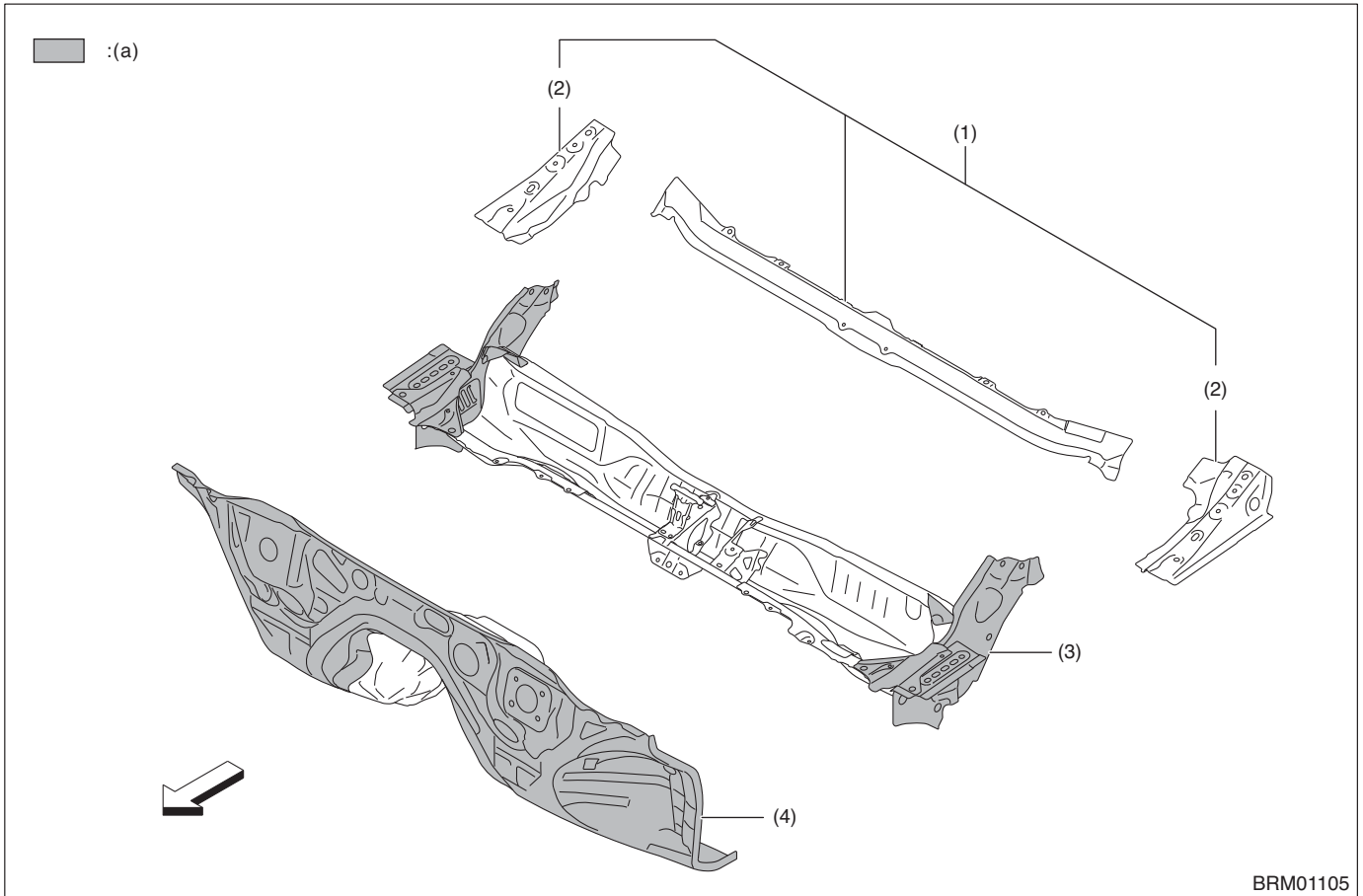
Tightening torque: N·m (kgf·m, ft·lb)
T1: 12.7 (1.29, 9.37)

Panel Components

3. Panel Components

A: COMPONENTS

1. TOE BOARD & FRONT PANEL



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

(1) Panel complete, front

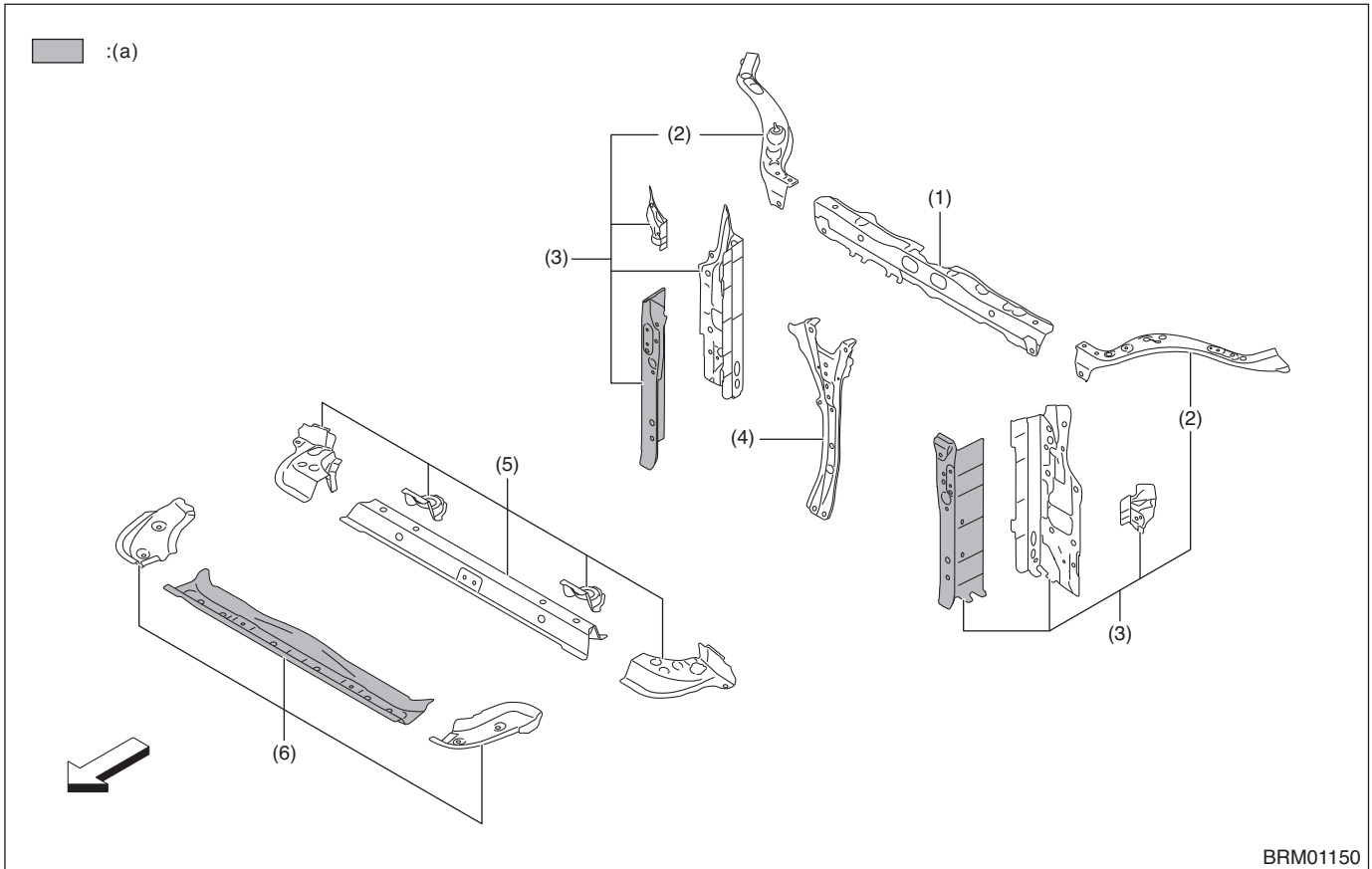
(3) Duct complete front panel

(4) Toe board complete

(2) Reinforcement, front panel side

Panel Components

2. RADIATOR PANEL



BRM01150

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

(1) Panel complete, radiator upper

(3) Panel complete, radiator side

(5) Frame complete, radiator panel lower

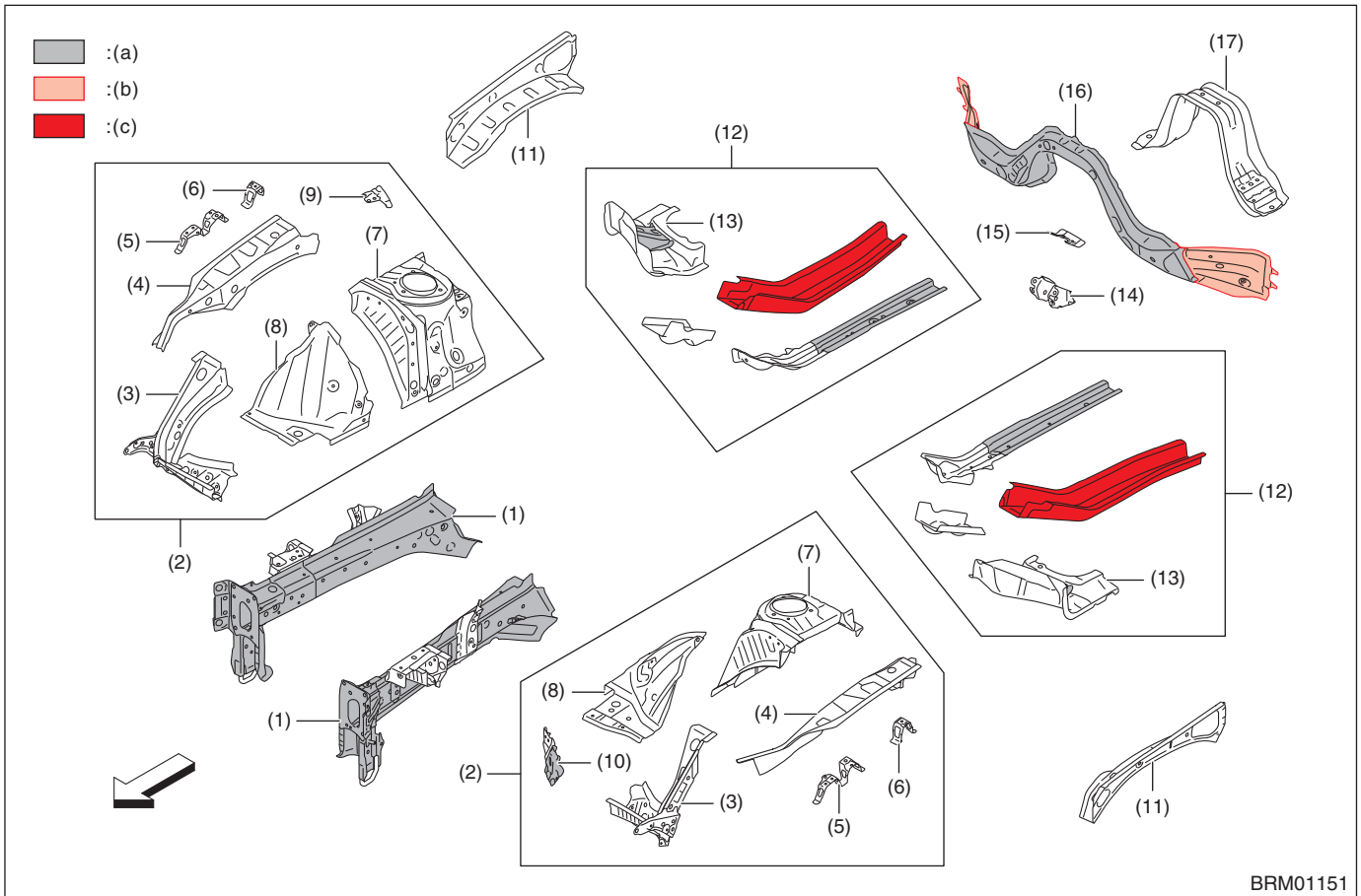
(2) Panel complete, radiator upper

(4) Stay complete, hood lock

(6) Frame complete, radiator lower

Panel Components

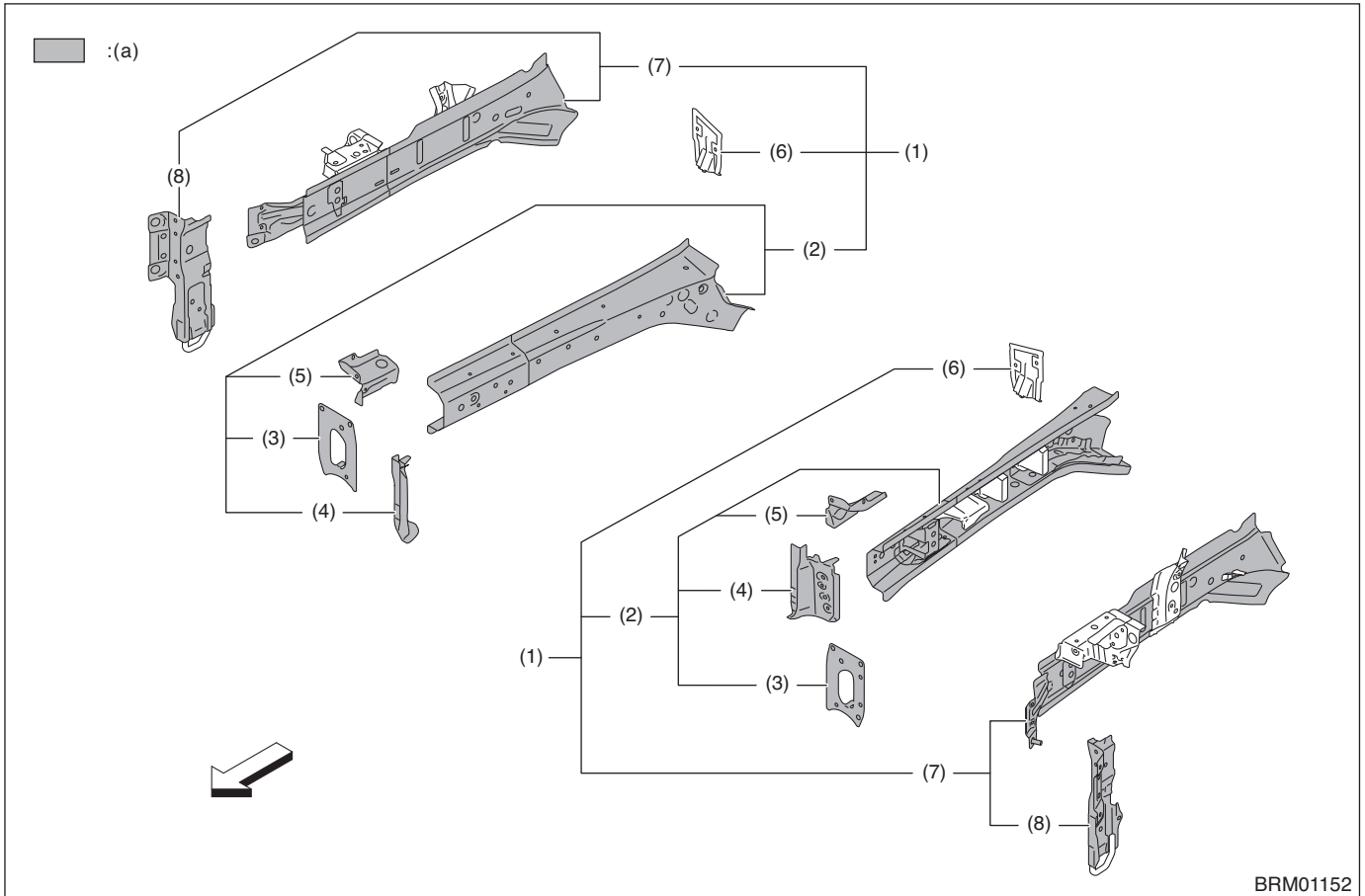
3. FRONT WHEEL APRON



- | | | |
|--|--|--|
| (a) High-strength tensile steel
(440 — 590 MPa class) | (b) High-strength tensile steel
(980 MPa class) | (c) High-strength tensile steel
(1,500 MPa class) |
| (1) Front side frame front | (7) Bracket complete, suspension front | (13) Reinforcement, toe board |
| (2) Wheel apron sub complete | (8) Wheel apron complete, front | (14) Bracket complete, pitching stopper |
| (3) Wheel apron, front | (9) Bracket complete, VDC | (15) Plate, pitching stopper |
| (4) Wheel apron complete, front upper | (10) Bracket, battery rod | (16) Reinforcement, tunnel toe board |
| (5) Bracket complete, front fender | (11) Frame, side upper | (17) Bracket complete, crossmember rear |
| (6) Bracket complete, front fender | (12) Frame side front complete, rear | |

Panel Components

4. FRONT SIDE FRAME



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

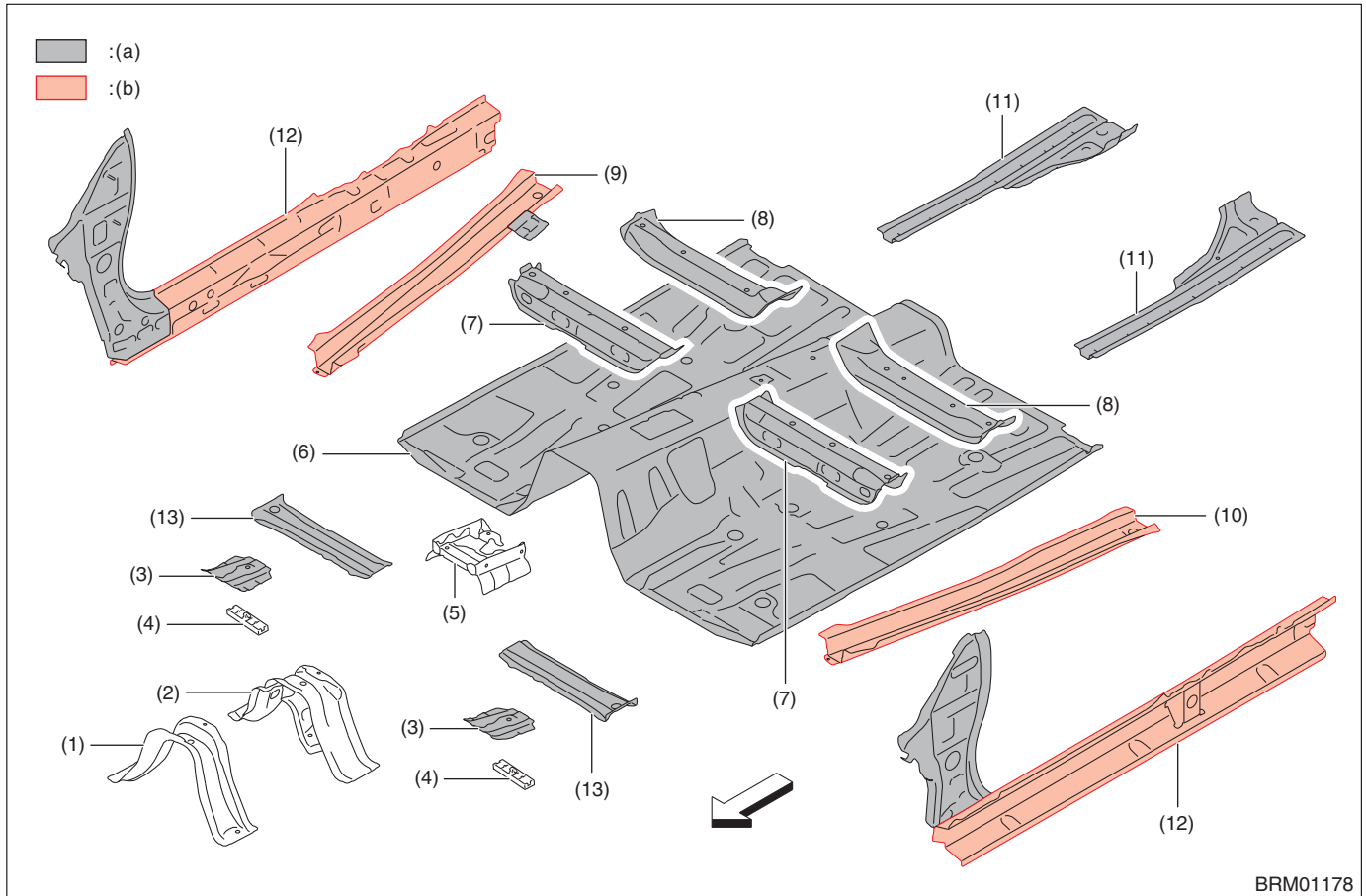
- (1) Frame side complete
- (2) Frame side front complete, front
- (3) Plate, front frame front

- (4) Gusset complete, front frame
- (5) Bracket complete, beam
- (6) Reinforcement, front

- (7) Closing plate
- (8) Tie down complete, front

Panel Components

5. FRONT FLOOR PANEL



BRM01178

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

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

(1) Crossmember, center floor

(2) Crossmember complete, A

(3) Frame, front floor front

(4) Plug, front rear inner

(5) Bracket assembly, instrument panel

(6) Floor pan, front

(7) Crossmember complete, filler front

(8) Crossmember complete, seat rear

(9) Frame, front floor rear right

(10) Frame, front floor rear left

(11) Frame, front floor rear

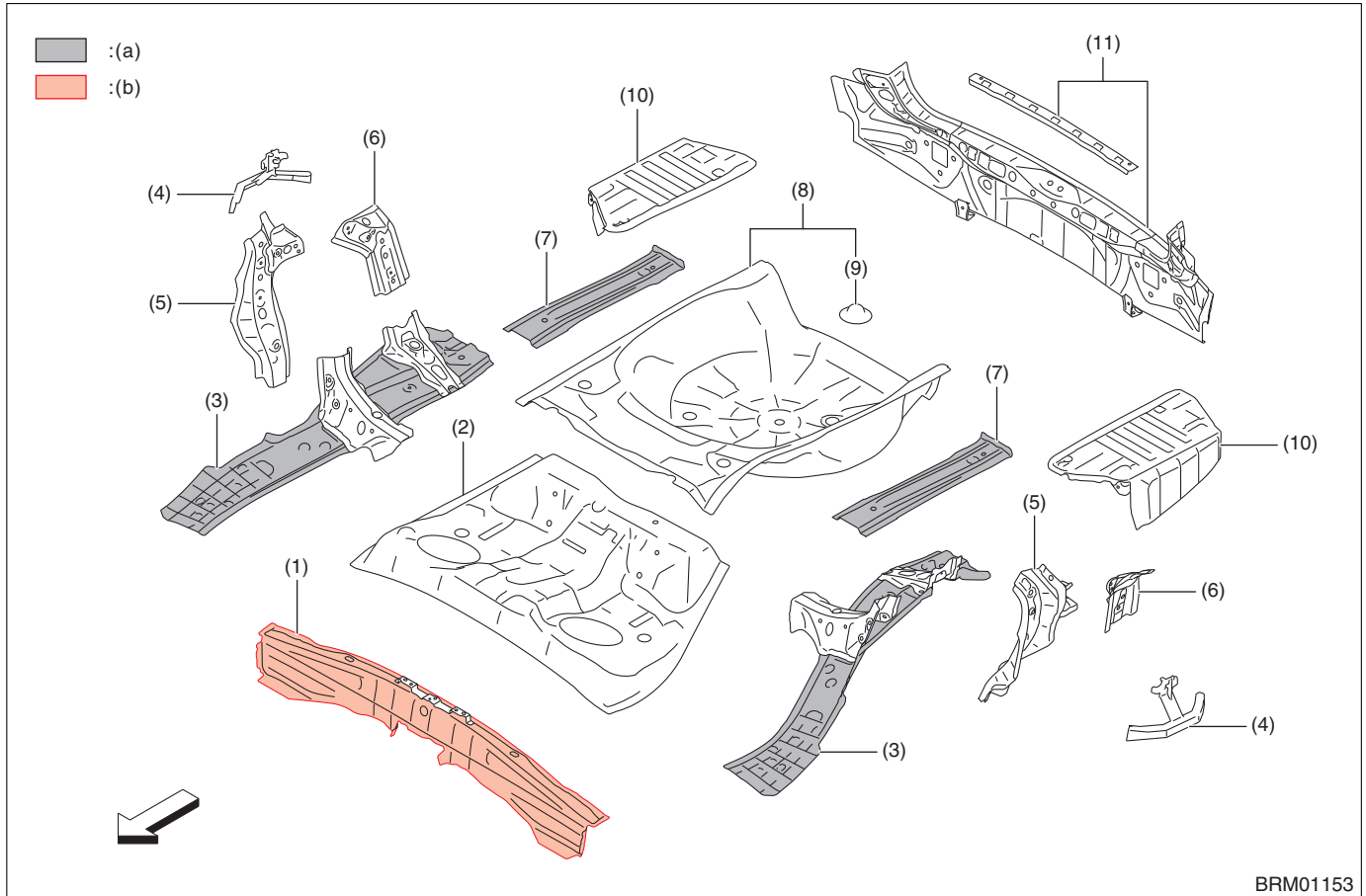
(12) Side sill complete, inner

(13) Crossmember, front floor front

Panel Components

6. REAR FLOOR PANEL & REAR SKIRT

• OUTBACK



BRM01153

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

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

(1) Crossmember complete

(5) Reinforcement, rear apron front

(9) Bracket, spare tire

(2) Floor pan complete, rear

(6) Gusset complete, rear apron

(10) Floor side, rear

(3) Frame complete, rear upper

(7) Frame side, rear upper

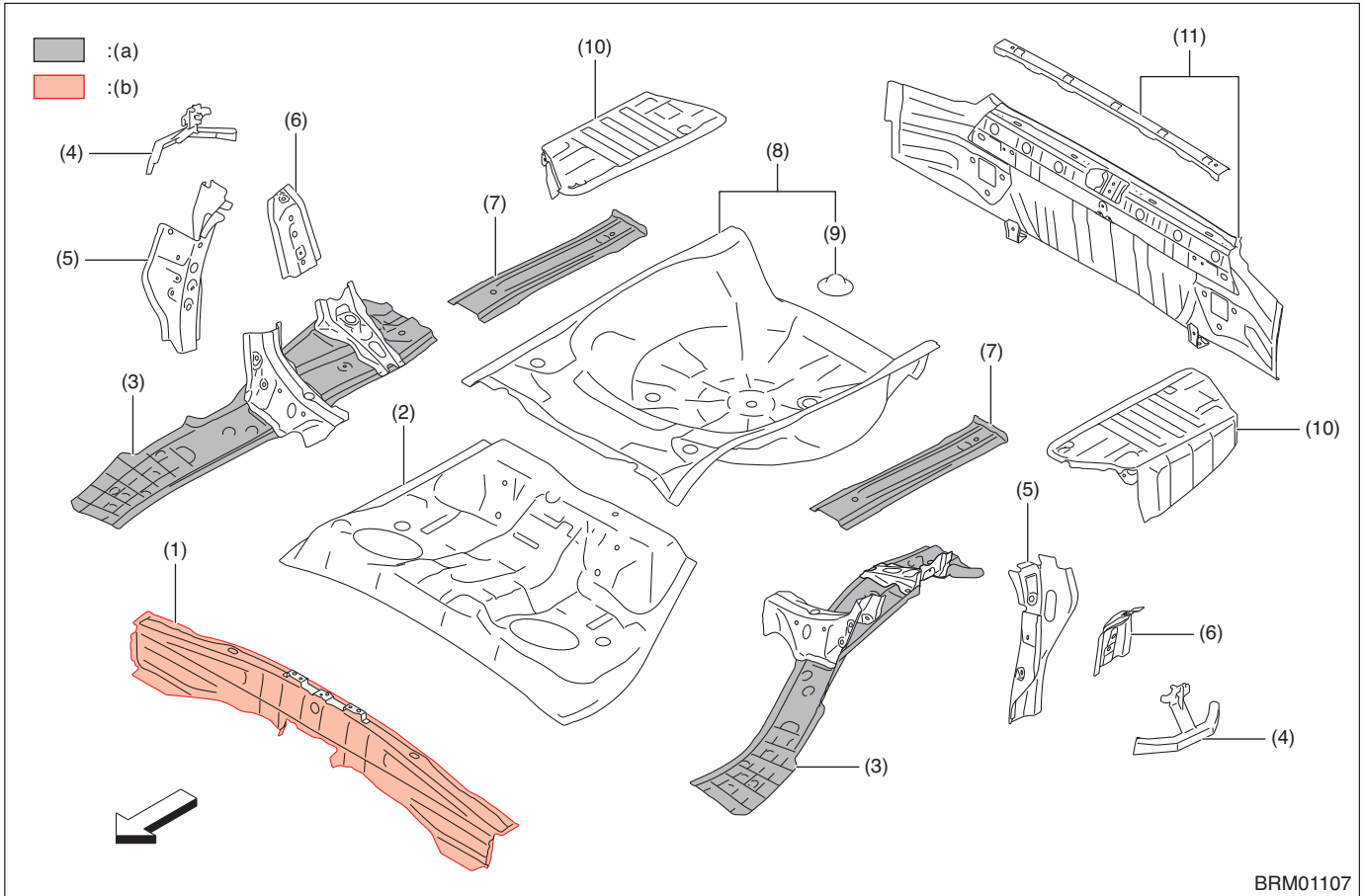
(11) Skirt complete, rear

(4) Reinforcement, damper

(8) Floor pan complete, rear rear

Panel Components

• SEDAN



BRM01107

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

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

(1) Crossmember complete

(5) Reinforcement, rear apron front

(9) Bracket, spare tire

(2) Floor pan complete, rear

(6) Gusset complete, rear apron

(10) Floor side, rear

(3) Frame complete, rear upper

(7) Frame side, rear upper

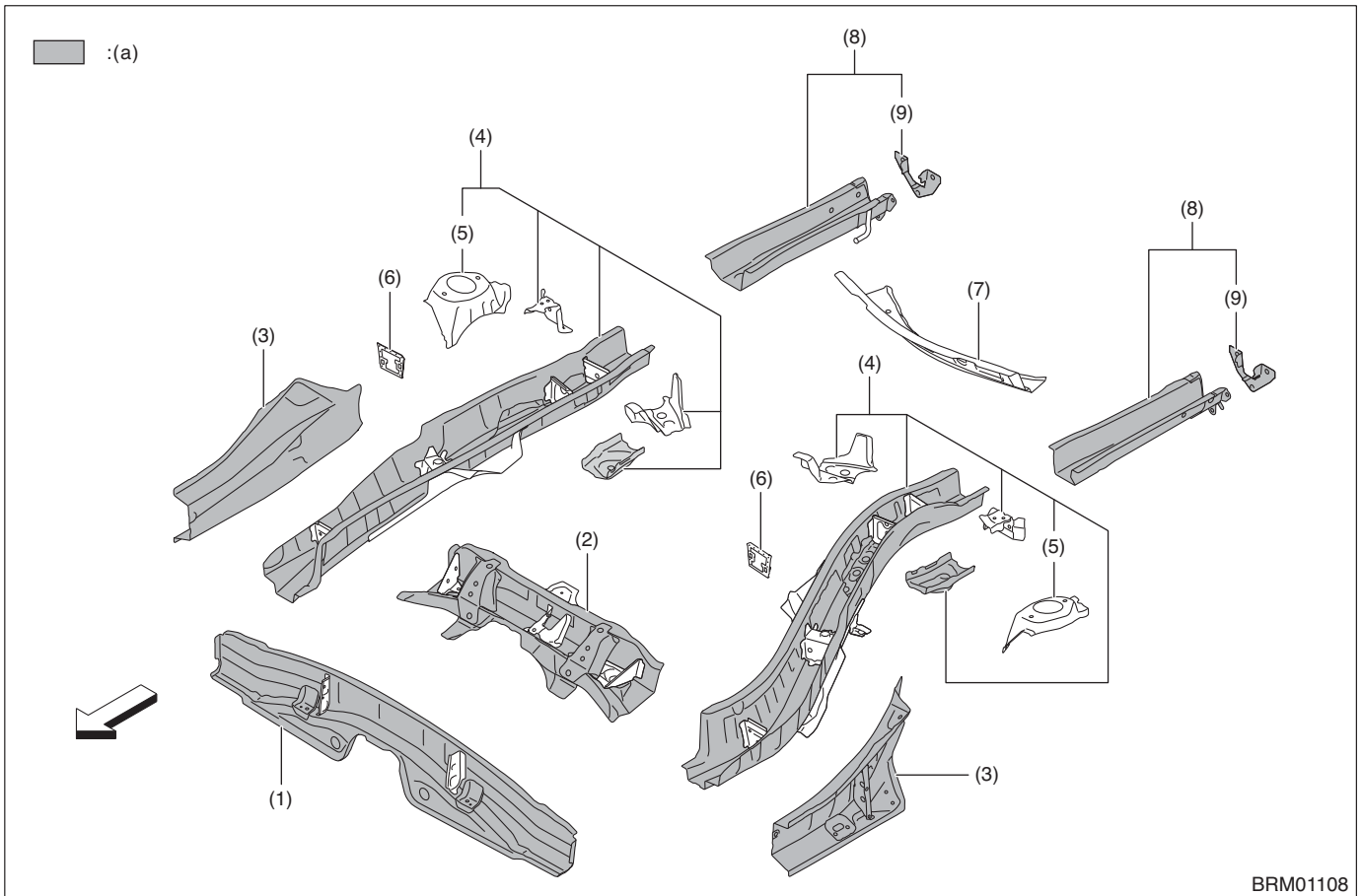
(11) Skirt complete, rear

(4) Reinforcement, damper

(8) Floor pan complete, rear rear

Panel Components

7. REAR FLOOR SIDE FRAME



BRM01108

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

(1) Crossmember complete, A

(4) Frame complete, floor side rear

(7) Crossmember C complete, rear floor

(2) Crossmember B complete, rear floor

(5) Bracket complete, rear suspension

(8) Frame complete, rear floor rear

(3) Side sill complete, inner rear

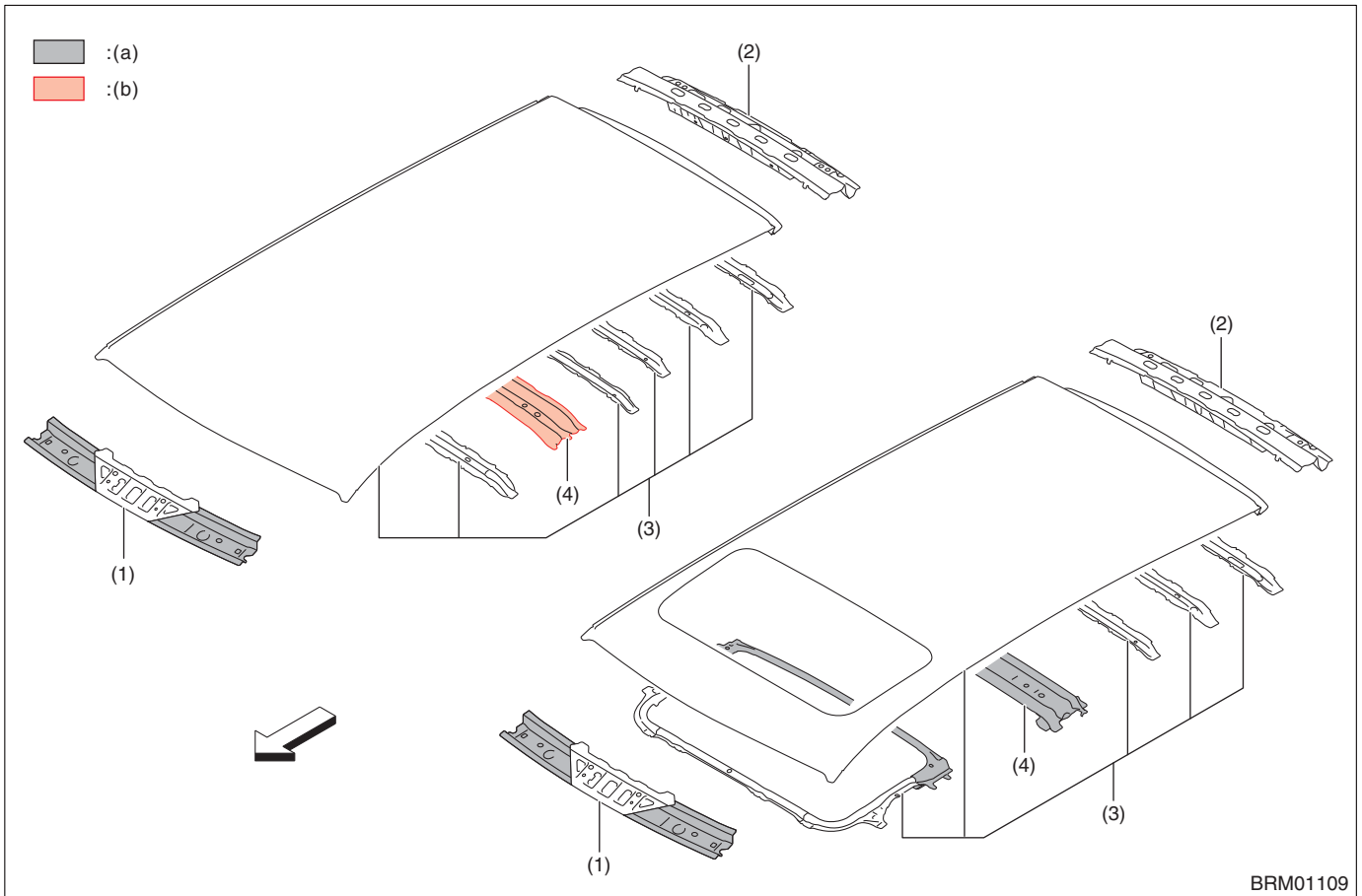
(6) Plug form rear

(9) Bracket, bumper rear

Panel Components

8. ROOF

• OUTBACK



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

(b) High-strength tensile steel
(1,180 MPa class)

(1) Rail complete, front roof

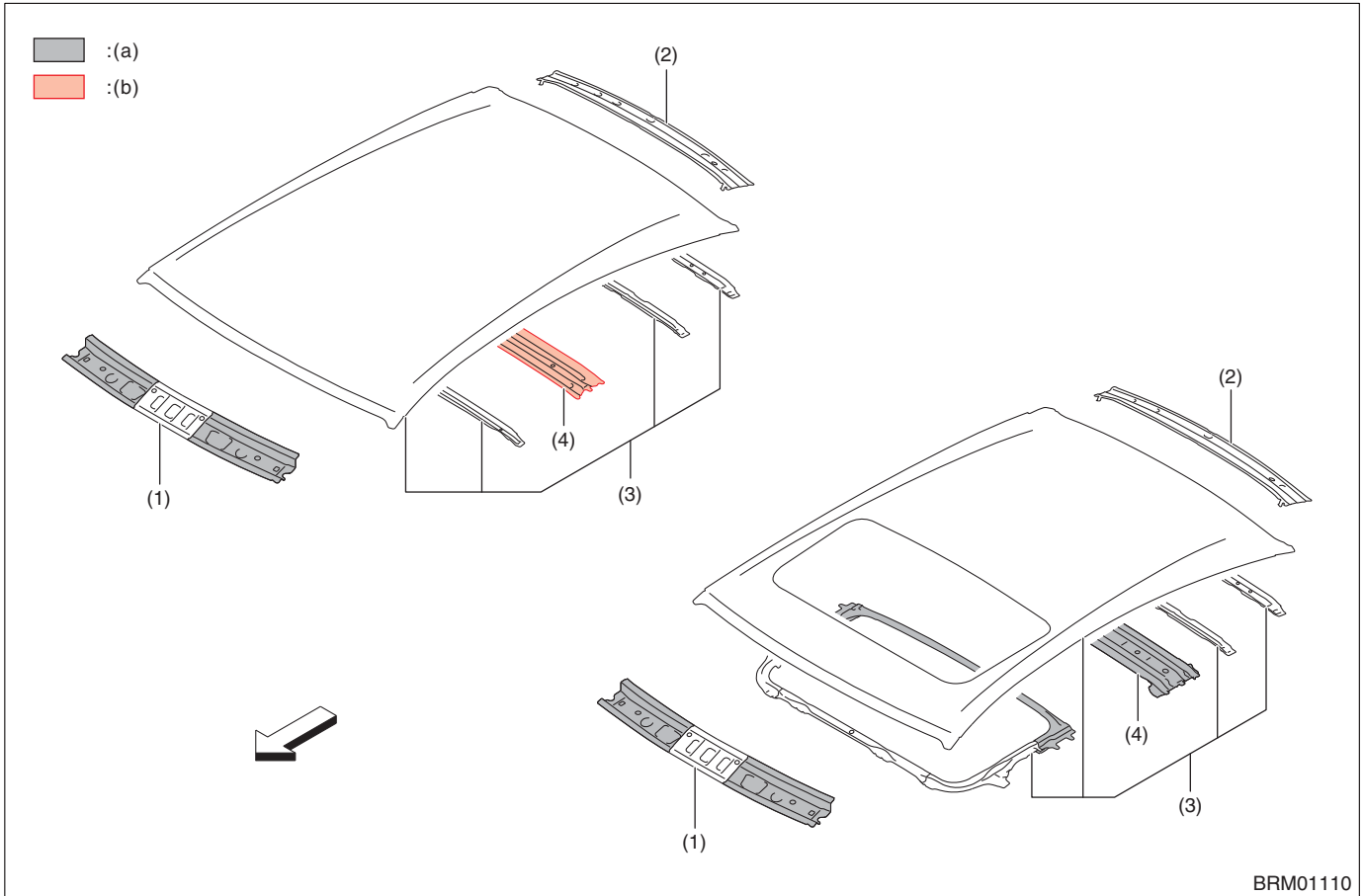
(3) Panel complete, roof

(4) Brace complete, roof center

(2) Rail complete, rear roof

Panel Components

• SEDAN



BRM01110

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

(b) High-strength tensile steel
(1,180 MPa class)

(1) Rail complete, front roof
(2) Rail complete, rear roof

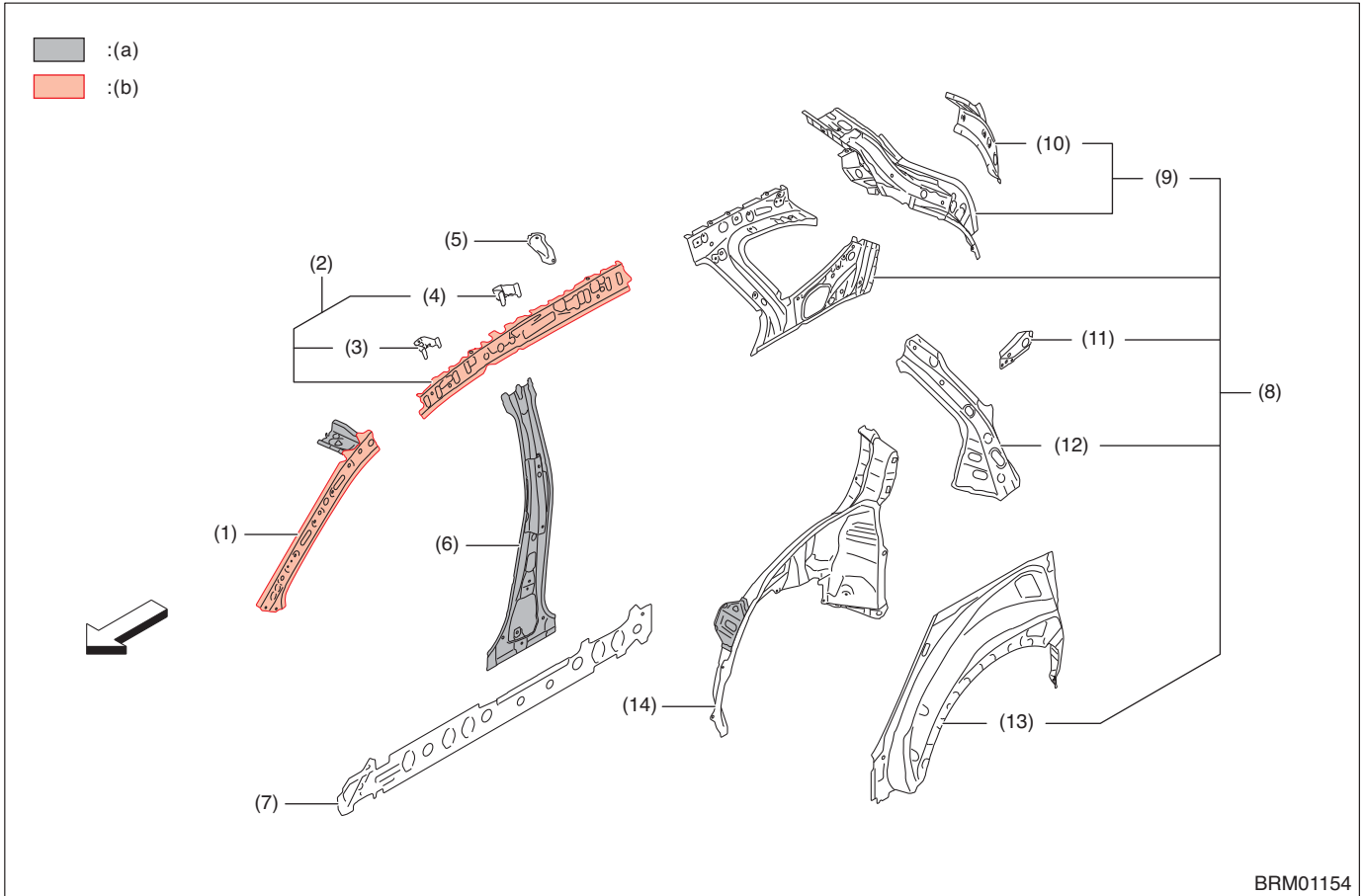
(3) Panel complete, roof

(4) Brace complete, roof center

Panel Components

9. SIDE PANEL INNER

• OUTBACK



BRM01154

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

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

(1) Pillar complete, front inner upper

(2) Side rail, inner

(3) Bracket, assist rail front

(4) Bracket, assist rail rear

(5) Bracket, sunroof

(6) Pillar complete, front center inner

(7) Reinforcement side sill inner

(8) Rear quarter complete, inner

(9) Reinforcement complete, D pillar

(10) Reinforcement D pillar lower

(11) Bracket retractor

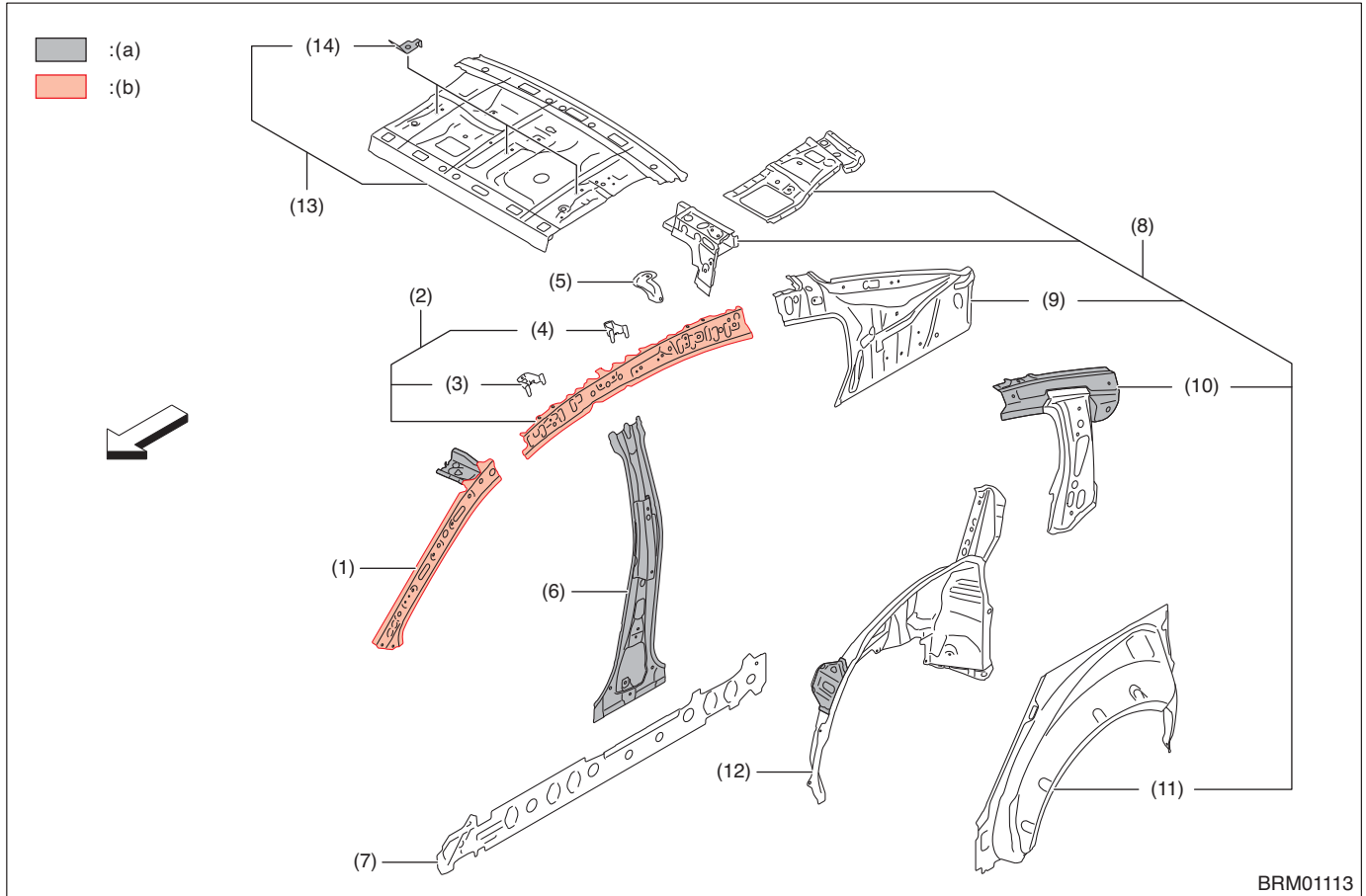
(12) Reinforcement C pillar

(13) Rear arch, inner

(14) Wheel apron complete, rear

Panel Components

• SEDAN



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

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

- (1) Pillar complete, front inner upper
- (2) Side rail, inner
- (3) Bracket, assist rail front
- (4) Bracket, assist rail rear
- (5) Bracket, sunroof

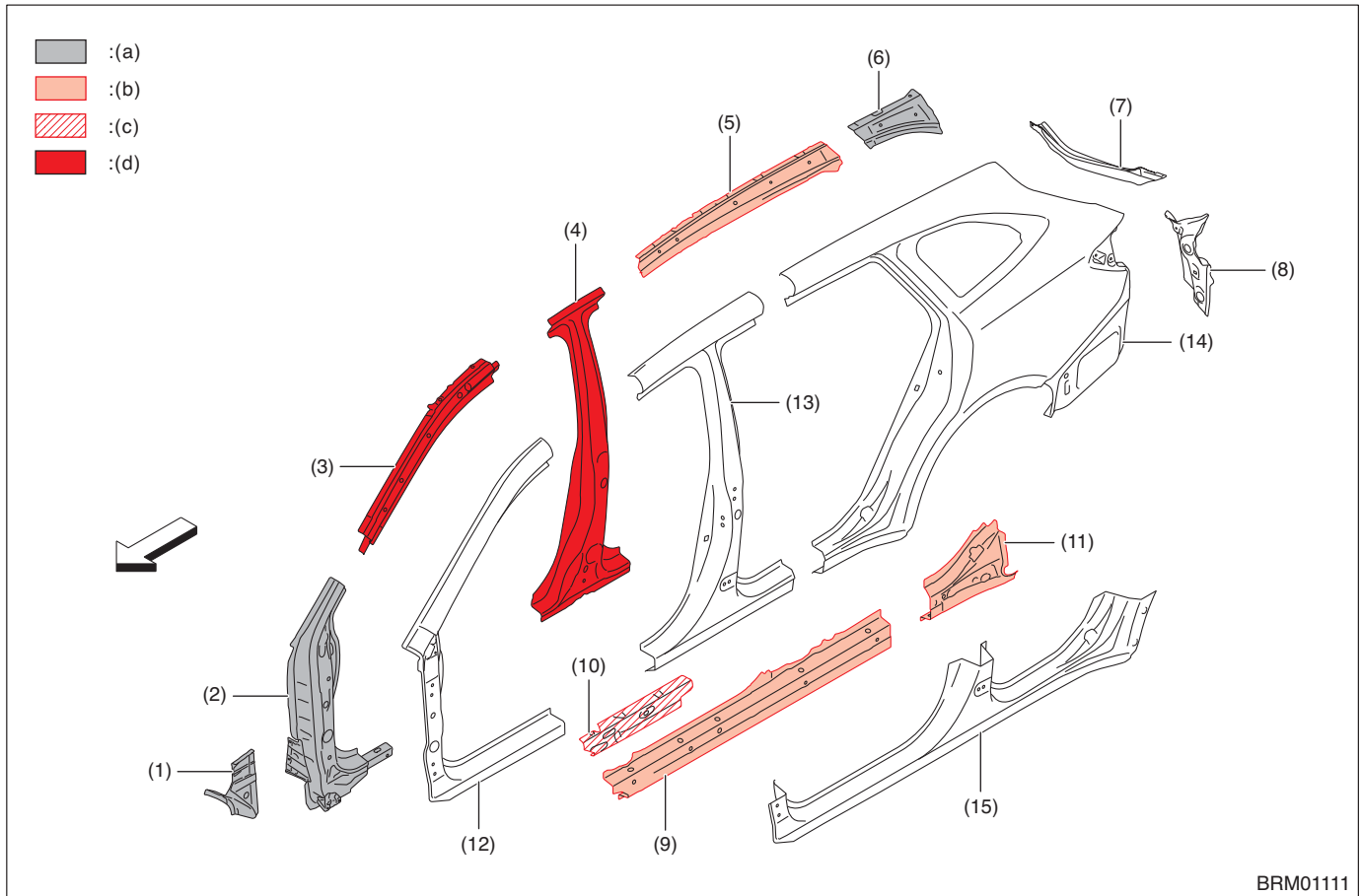
- (6) Pillar complete, front center inner
- (7) Reinforcement side sill inner
- (8) Rear quarter complete, inner
- (9) Pillar rear, inner
- (10) Reinforcement, rear quarter inner

- (11) Rear arch, inner
- (12) Wheel apron complete, rear
- (13) Panel complete, rear
- (14) Plate, child anchor

Panel Components

10. SIDE PANEL OUTER

• OUTBACK



BRM01111

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

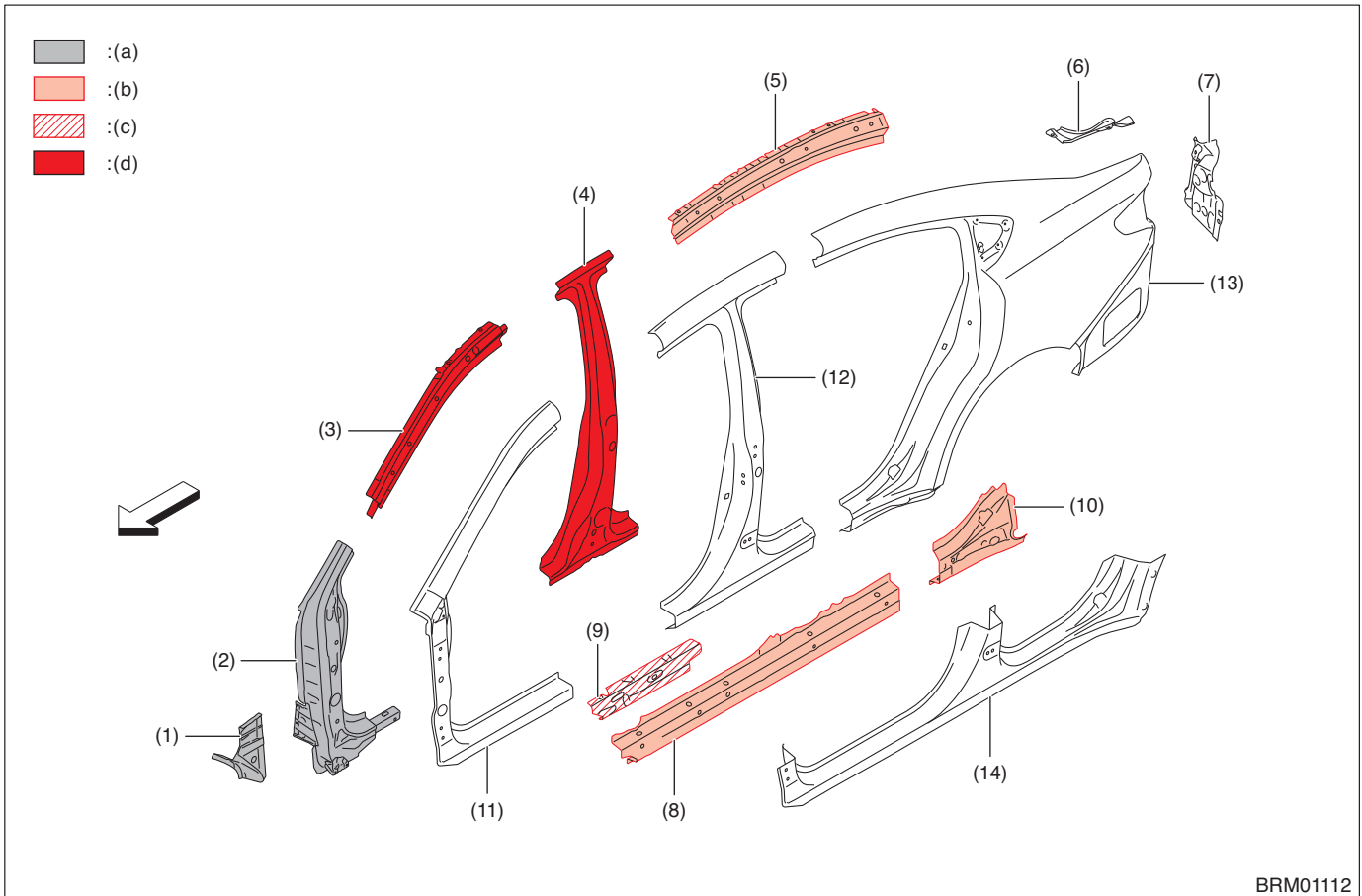
- (c) High-strength tensile steel
(1,180 MPa class)

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

- | | | |
|--|------------------------------------|--|
| (1) Gusset, front pillar | (6) Reinforcement, side rail rear | (11) Reinforcement, rear quarter catch |
| (2) Reinforcement complete, front pillar lower | (7) Extension complete, D pillar | (12) Pillar complete, front outer |
| (3) Reinforcement complete, side rail | (8) Rear quarter end complete | (13) Pillar complete, center outer |
| (4) Reinforcement complete, center pillar | (9) Reinforcement, side sill outer | (14) Rear quarter complete, outer |
| (5) Reinforcement complete, side rail | (10) Reinforcement, sill outer | (15) Side sill complete, outer |

Panel Components

• SEDAN

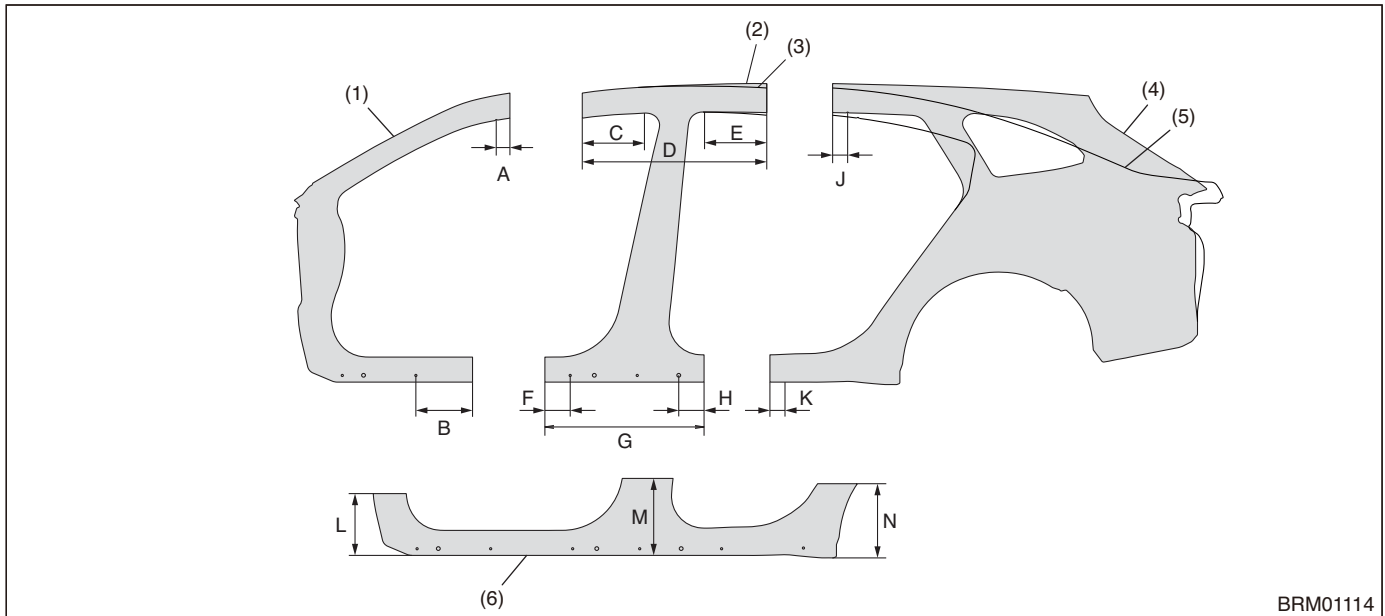


- | | | |
|---|---|---|
| (a) High-strength tensile steel (440 — 590 MPa class) | (c) High-strength tensile steel (1,180 MPa class) | (d) High-strength tensile steel (1,500 MPa class) |
| (b) High-strength tensile steel (980 MPa class) | | |
| (1) Gusset, front pillar | (6) Patch, rear pillar | (11) Pillar complete, front outer |
| (2) Reinforcement complete, front pillar lower | (7) Rear quarter end complete | (12) Pillar complete, center outer |
| (3) Reinforcement complete, side rail | (8) Reinforcement, side sill outer | (13) Rear quarter complete, outer |
| (4) Reinforcement complete, center pillar | (9) Reinforcement, sill outer | (14) Side sill complete, outer |
| (5) Reinforcement complete, side rail | (10) Reinforcement, rear quarter catch | |

Panel Components

B: Repair part size

1. SIDE PANEL OUTER

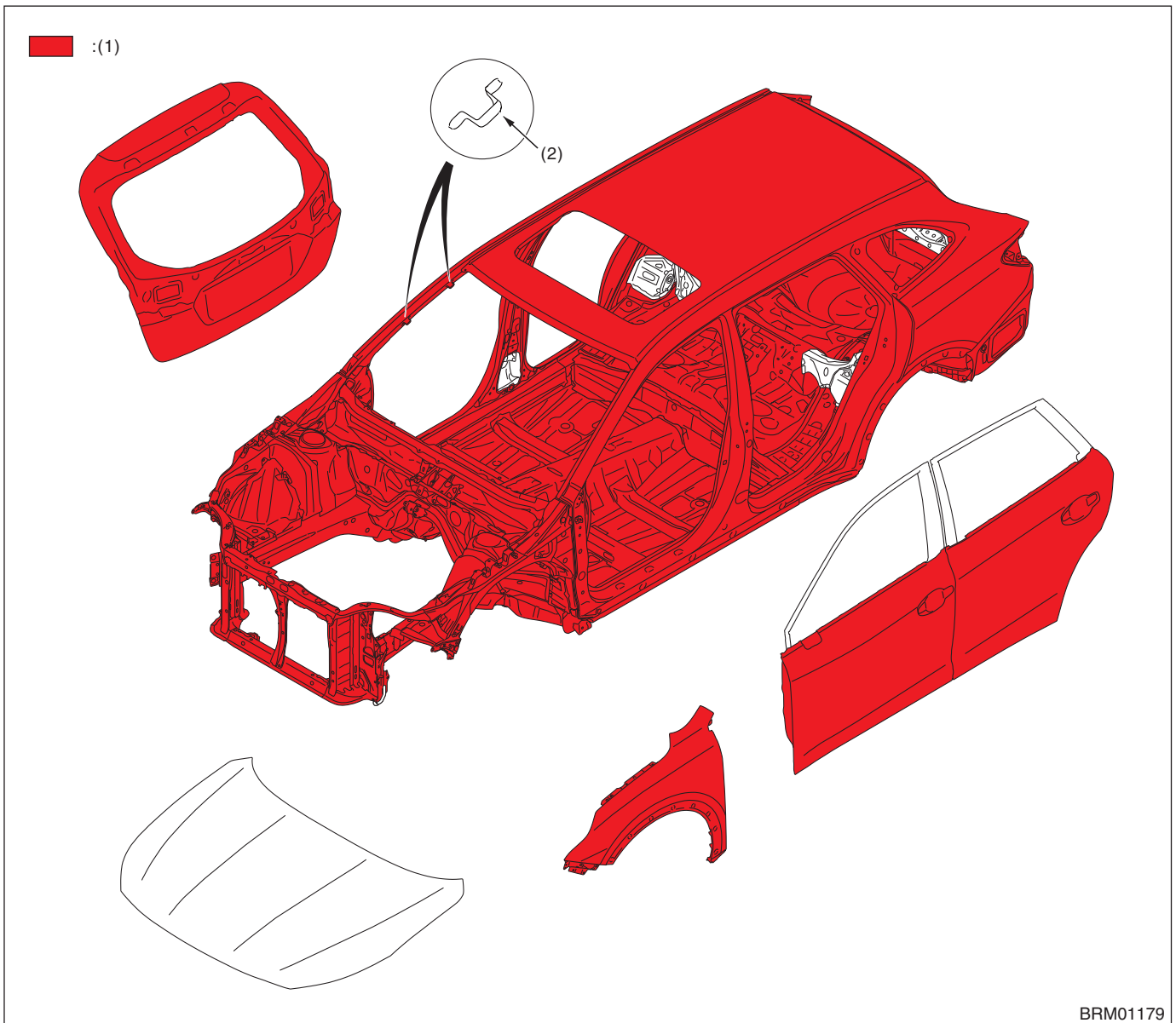


No	Part name	Measuring point	Datum dimension mm (in)
1	Front pillar outer	A	57 (2.24)
		B	235 (9.25)
2	Center pillar outer (OUTBACK)	C	258 (10.16)
		D	765 (30.12)
		E	258 (10.16)
		F	105 (4.13)
		G	660 (25.98)
		H	105 (4.13)
3	Center pillar outer (SEDAN)	C	258 (10.16)
		D	780 (30.71)
		E	279 (10.98)
		F	105 (4.13)
		G	660 (25.98)
4	Rear quarter outer (OUTBACK)	H	105 (4.13)
		J	62 (2.44)
5	Rear quarter outer (SEDAN)	K	63 (2.48)
		J	91 (3.58)
6	Side sill outer	K	63 (2.48)
		L	256 (10.08)
		M	319 (12.56)
		N	308 (12.13)

4. Galvanized Sheet Metal

A: SPECIFICATIONS

• COMMON PARTS FOR OUTBACK AND SEDAN



BRM01179

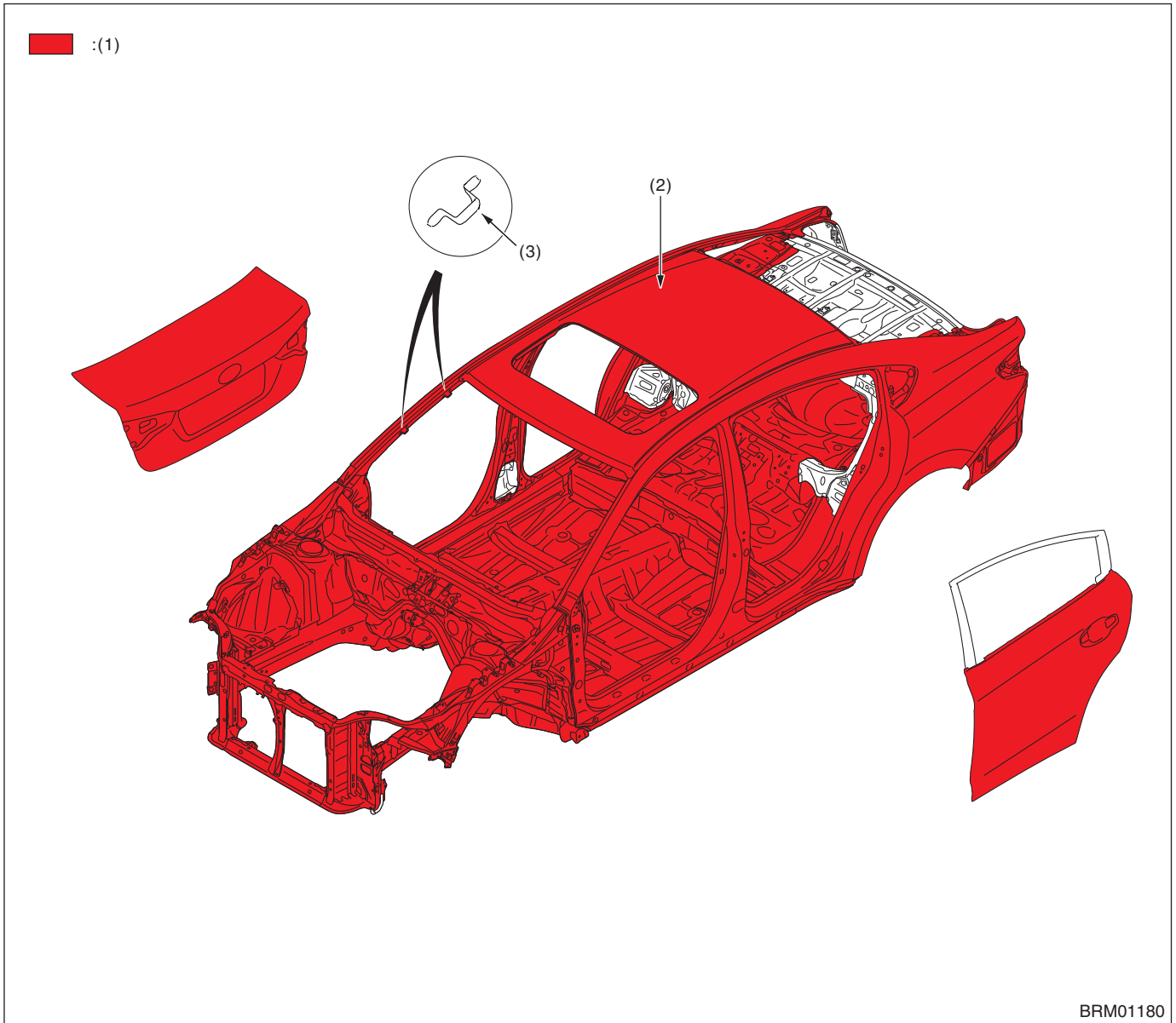
(1) Galvanized sheet metal
(both sides)

(2) This part is not galvanized.

The fuel flap is made of plastic

Galvanized Sheet Metal

• SPECIAL SEDAN PARTS

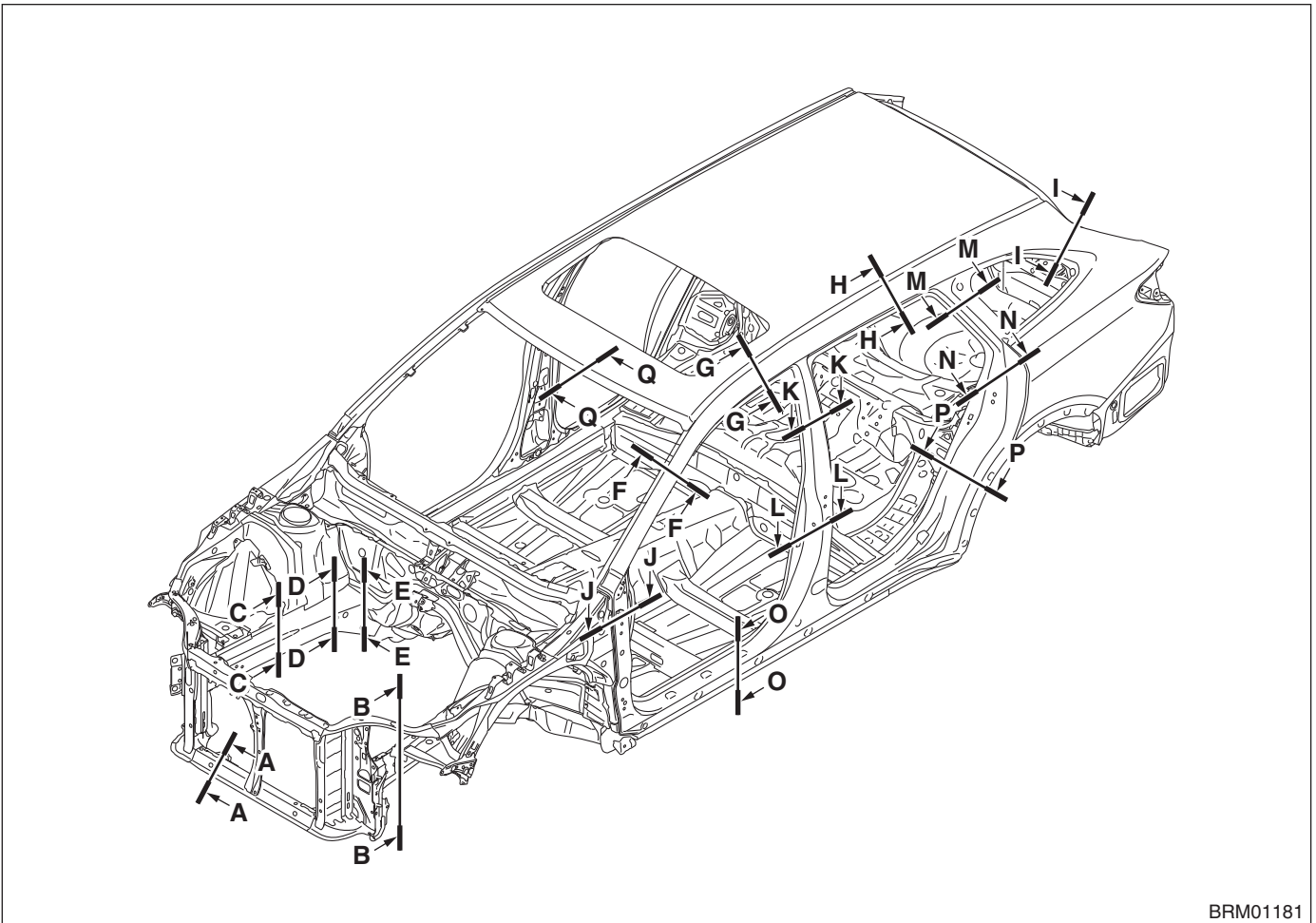


Body Construction

5. Body Construction

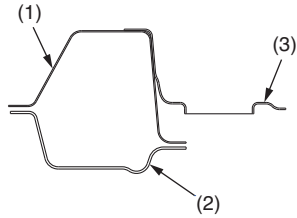
A: SPECIFICATIONS

- COMMON PARTS FOR OUTBACK AND SEDAN



Body Construction

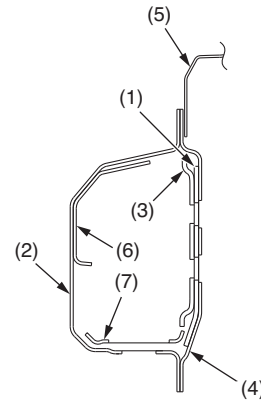
Cross section A — A



BRM00761

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

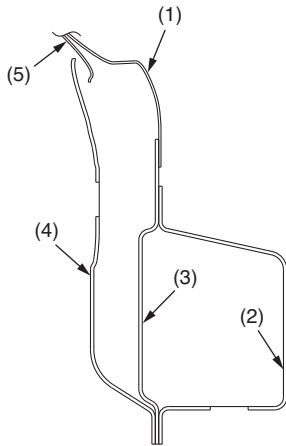
Cross section B — B



BRM00762

- (1) Plate closing plate FF
- (2) Frame side FF
- (3) Separator FF A
- (4) Closing plate FF
- (5) Gusset apron F upper
- (6) Doubler FF upper
- (7) Doubler FF lower

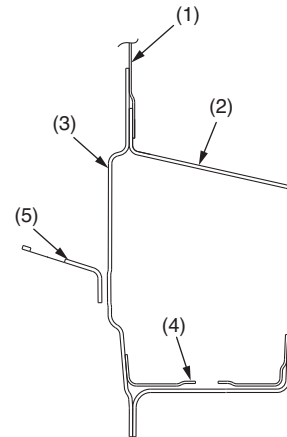
Cross section C — C



BRM00763

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

Cross section D — D

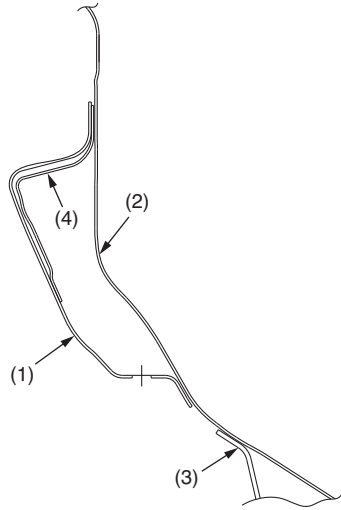


BRM00764

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

Body Construction

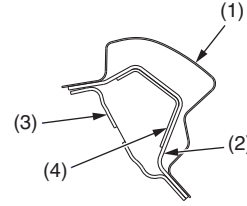
Cross section E — E



BRM00765

- (1) Crossmember toe board center
- (2) Toe board
- (3) Frame tunnel front A
- (4) Reinforcement crossmember toe board center

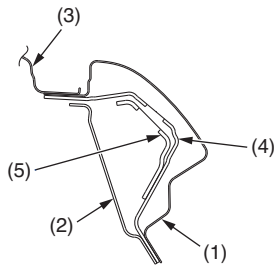
Cross section F — F



BRM00766

- (1) Panel side outer
- (2) Reinforcement rail side outer front
- (3) Front pillar inner upper
- (4) Reinforcement rail side outer patch

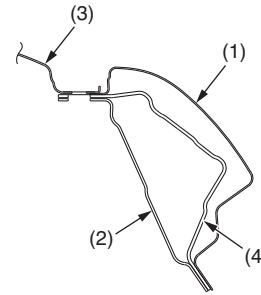
Cross section G — G



BRM00767

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

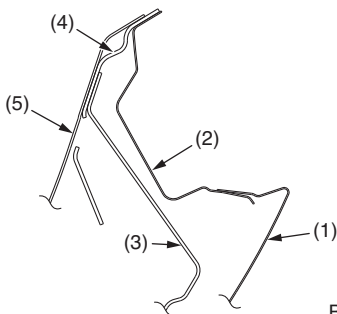
Cross section H — H



BRM00768

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

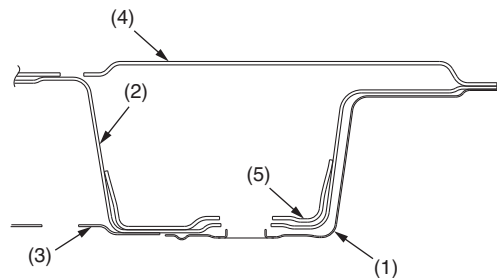
Cross section I — I



BRM00769

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

Cross section J — J

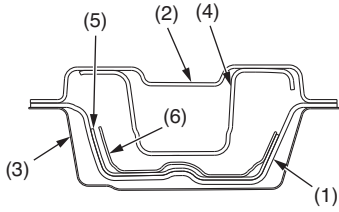


BRM00770

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

Body Construction

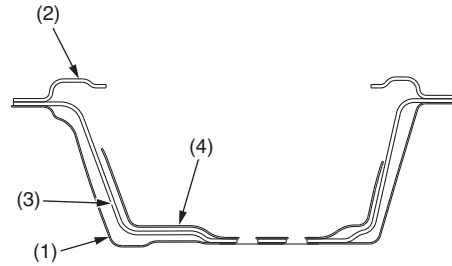
Cross section K—K



BRM00771

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

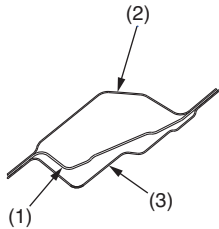
Cross section L — L



BRM00772

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

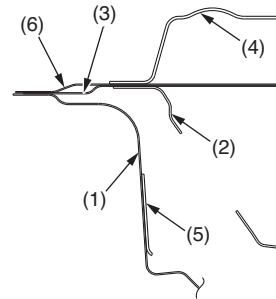
Cross section M — M



BRM00773

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

Cross section N — N

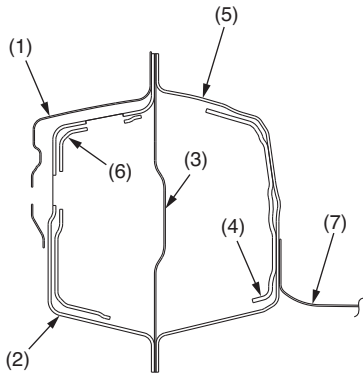


BRM00774

- (1) Panel side outer
- (2) Reinforcement C pillar
- (3) Quarter panel rear inner
- (4) Reinforcement rear apron front
- (5) Reinforcement striker rear
- (6) Arch rear inner

Body Construction

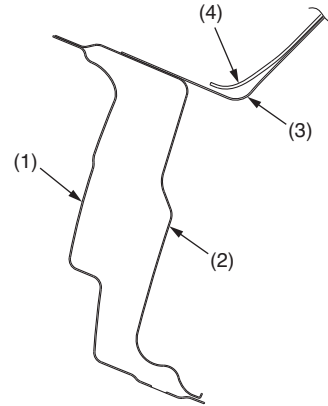
Cross section O — O



BRM00775

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

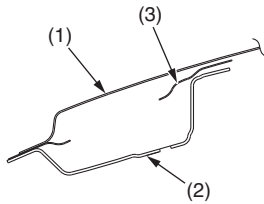
Cross section P — P



BRM00776

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

Cross section Q — Q



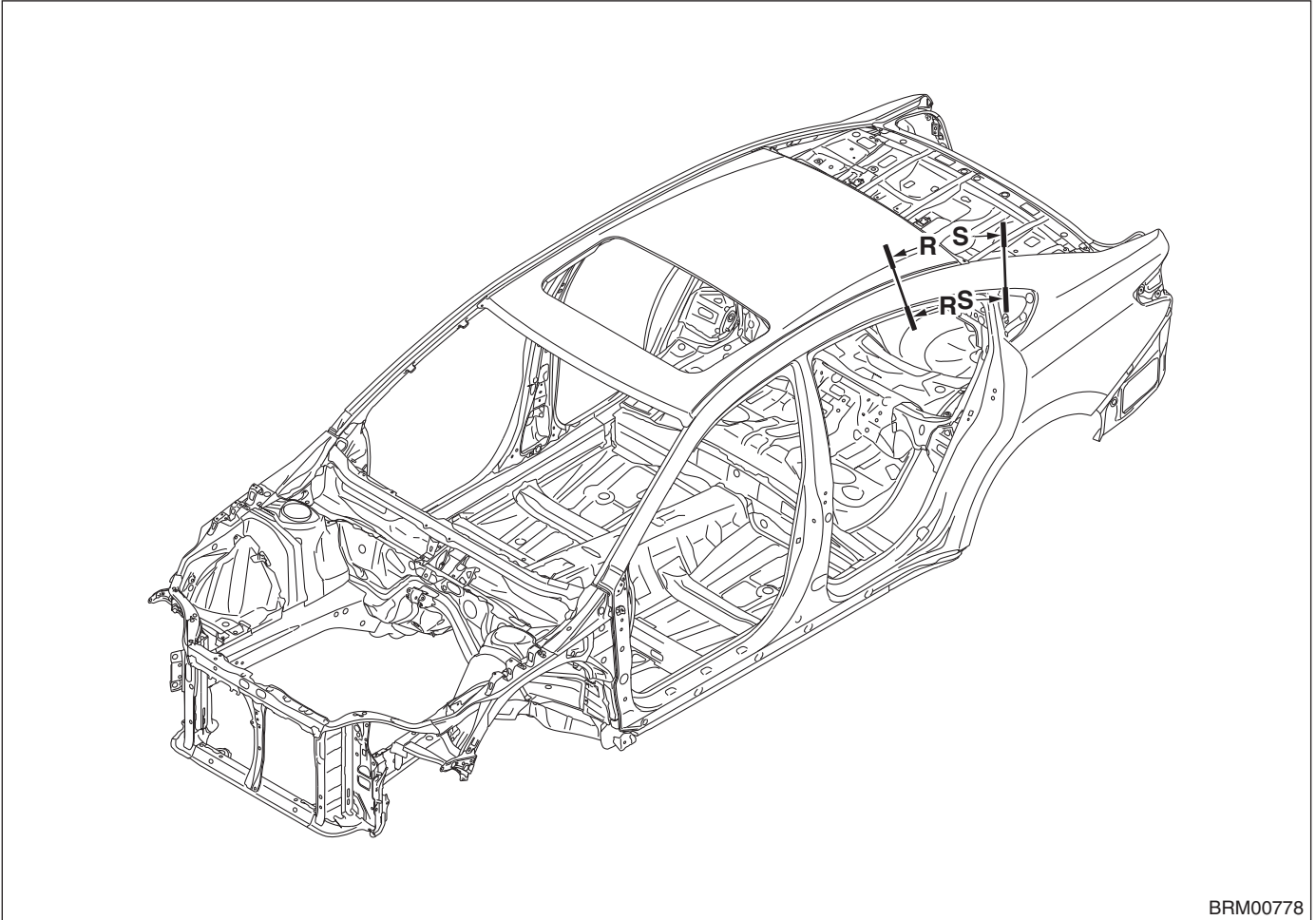
BRM00777

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

SUBARU.

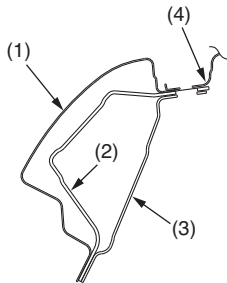
Body Construction

• SPECIAL SEDAN PARTS



BRM00778

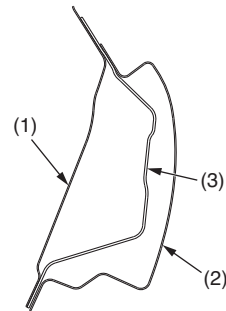
Cross section R — R



BRM00779

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

Cross section S — S



BRM00780

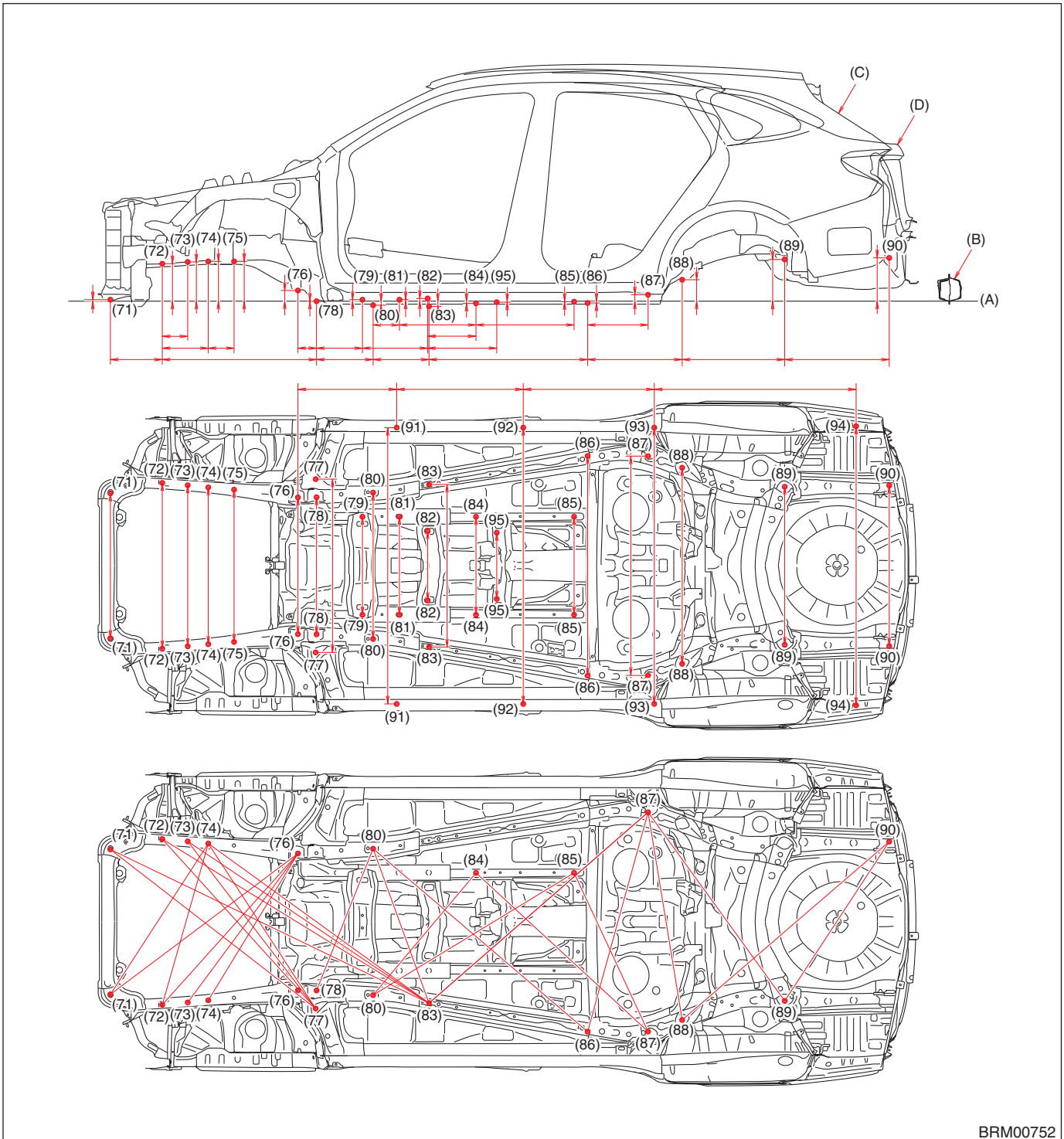
- (1) Pillar rear, inner
- (2) Panel side outer
- (3) Reinforcement side outer rear

Body Reference Points

6. Body Reference Points

A: DIMENSIONS

1. LOWER SURFACE



BRM00752

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

Body Reference Points

- | | | |
|--|--|--|
| (A) Standard line
(B) Side sill outer panel | (C) OUTBACK | (D) SEDAN |
| (71) Gauge hole (symmetrical) | (79) HT-CVT Crossmember upper
b mounting hole (symmetrical) | (88) Rear suspension crossmember
mounting hole (symmetrical),
front side |
| (72) Gauge hole (symmetrical) | (80) Under cover rear mounting hole
(symmetrical) | (89) Rear suspension crossmember
mounting hole (symmetrical),
rear side |
| (73) Radio ground mounting hole
(symmetrical) | (81) Under cover rear mounting hole
(symmetrical) | (90) Gauge hole (symmetrical) |
| (74) Front crossmember mounting hole
(symmetrical), front side | (82) Exhaust cover mounting hole
(symmetrical) | (91) Side sill spoiler mounting hole
(symmetrical) |
| (75) Front crossmember mounting hole
(symmetrical), rear side | (83) Under cover rear mounting hole
(symmetrical) | (92) Side sill spoiler mounting hole
(symmetrical) |
| (76) Front suspension arm plate
mounting hole (symmetrical) | (84) Under cover rear mounting hole
(symmetrical) | (93) Side sill spoiler mounting hole
(symmetrical) |
| (77) Front suspension plate mounting
hole (symmetrical), outer side | (85) Protector tank mounting hole
(symmetrical) | (94) Cover side lower mounting hole
(symmetrical), rear side |
| (78) Front suspension plate mounting
hole (symmetrical), inner side | (86) Rear frame mounting hole (sym-
metrical), outer side | (95) Exhaust cover mounting hole
(symmetrical) |
| (79) CFT-CVT Crossmember upper
a mounting hole (symmetrical) | (87) Rear suspension support sub
frame mounting hole
(symmetrical), front side | |

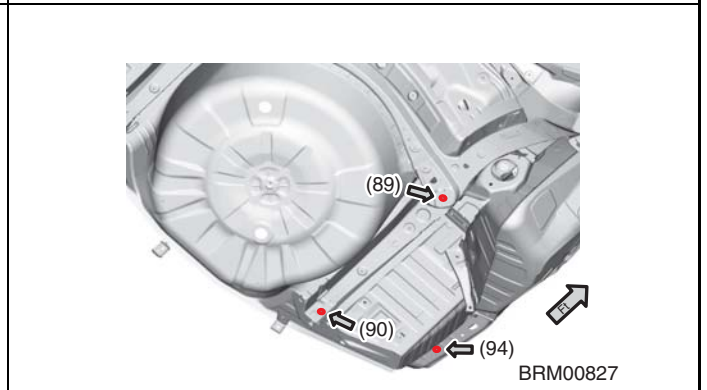
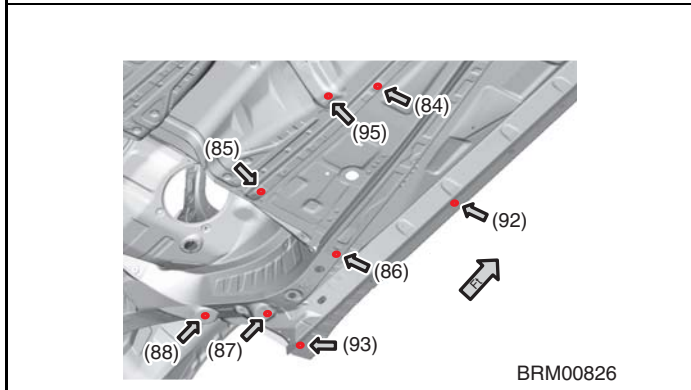
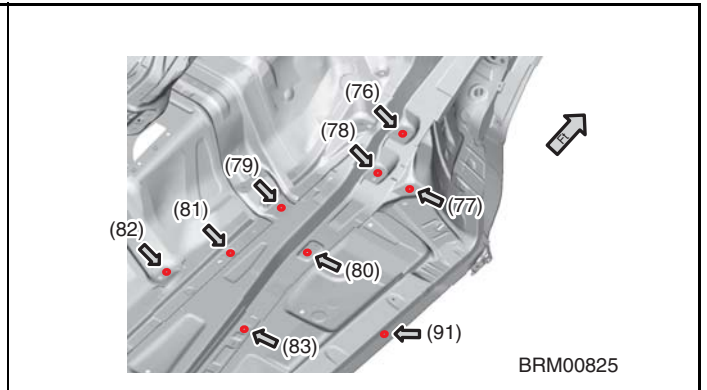
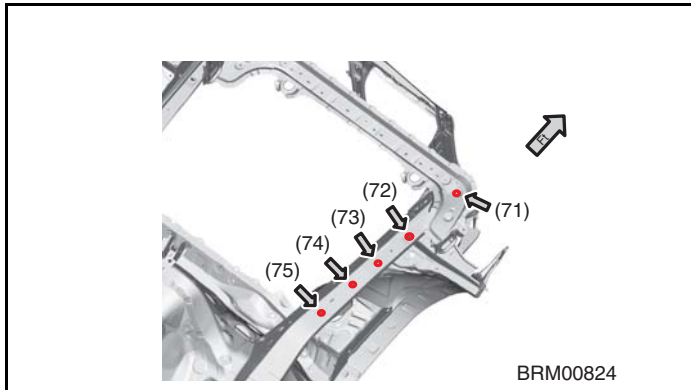
Measuring point	Datum dimension mm (in)	Projected dimensions mm (in)
Datum line — (71)	9 (0.35)	—
Datum line — (72)	209 (8.23)	—
Datum line — (73)	219 (8.62)	—
Datum line — (74)	222 (8.74)	—
Datum line — (75)	222 (8.74)	—
Datum line — (76)	60 (2.36)	—
Datum line — (78)	0 (0.00)	—
Datum line — (79)a	9 (0.35)	—
Datum line — (79)b	9 (0.35)	—
Datum line — (80)	-23 (-0.91)	—
Datum line — (81)	8 (0.31)	—
Datum line — (82)	15 (0.59)	—
Datum line — (83)	-29 (-1.14)	—
Datum line — (84)	-12 (-0.47)	—
Datum line — (85)	-3 (-0.12)	—
Datum line — (86)	-10 (-0.39)	—
Datum line — (87)	36 (1.42)	—
Datum line — (88)	120 (4.72)	—
Datum line — (89)	233 (9.17)	—
Datum line — (90)	242 (9.53)	—
Datum line — (95)	-5 (-0.20)	—
(71) — (72)	290 (11.42)	—
(72) — (73)	142 (5.59)	—
(72) — (74)	257 (10.12)	—
(72) — (78)	862 (33.94)	—
(74) — (75)	144 (5.67)	—

Measuring point	Datum dimension mm (in)	Projected dimensions mm (in)
(76) — (78)	104 (4.09)	—
(78) — (79)a	257 (10.12)	—
(78) — (79)b	367 (14.45)	—
(78) — (80)	316 (12.44)	—
(79)a — (82)	365 (14.37)	—
(79)b — (82)	255 (10.04)	—
(80) — (81)	147 (5.79)	—
(80) — (83)	313 (12.32)	—
(81) — (84)	428 (16.85)	—
(82) — (84)	270 (10.63)	—
(82) — (95)	386 (15.20)	—
(83) — (86)	886 (34.88)	—
(84) — (85)	548 (21.57)	—
(86) — (87)	338 (13.31)	—
(86) — (88)	528 (20.79)	—
(88) — (89)	573 (22.56)	—
(89) — (90)	584 (22.99)	—
(76) — (91)	552 (21.73)	—
(91) — (92)	707 (27.83)	—
(92) — (93)	732 (28.82)	—
(93) — (94)	1,128 (44.41)	—
(71)R — (71)L	810 (31.89)	—
(72)R — (72)L	926 (36.46)	—
(73)R — (73)L	900 (35.43)	—
(74)R — (74)L	876 (34.49)	—
(75)R — (75)L	851 (33.50)	—

Body Reference Points

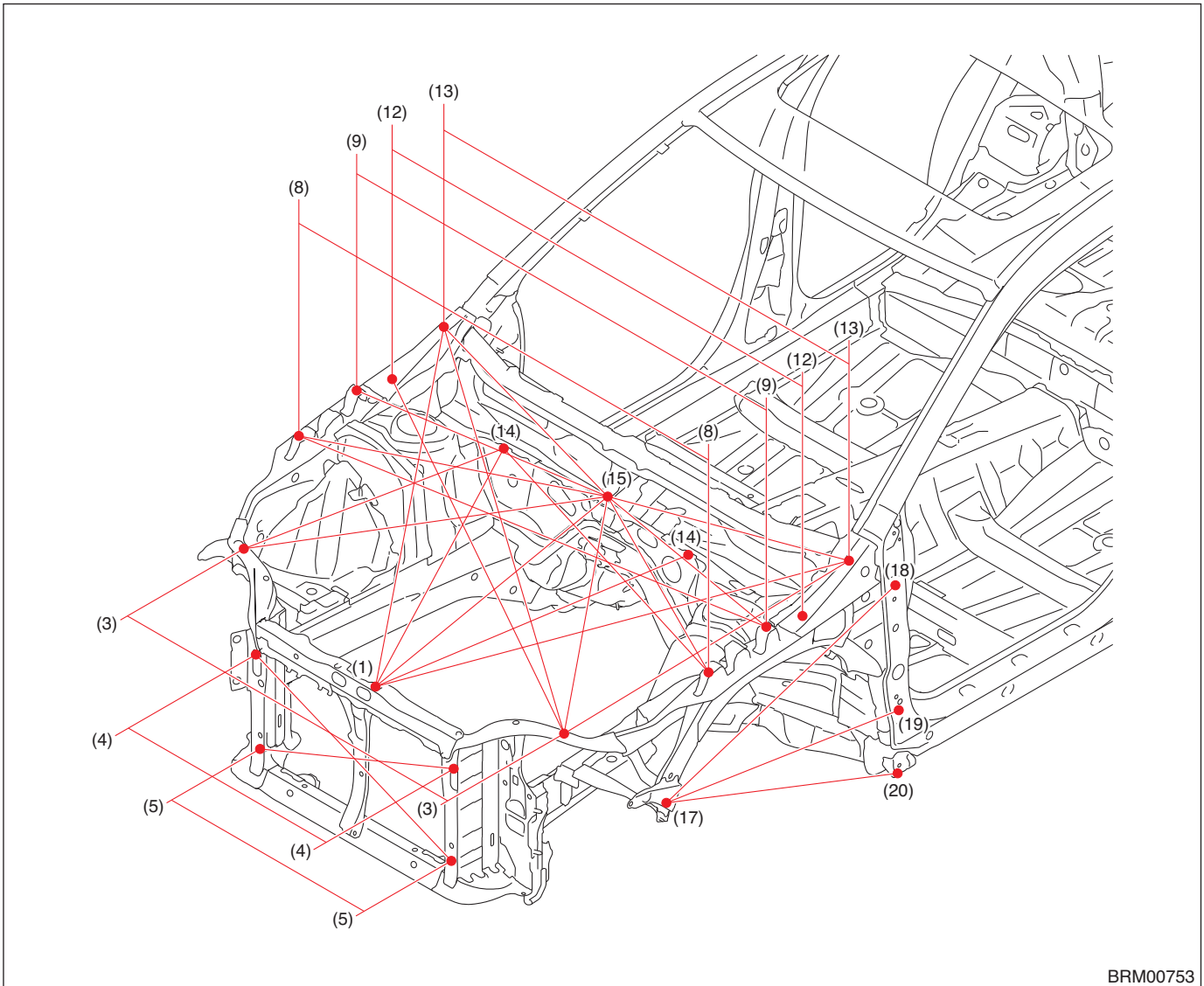
Measuring point	Datum dimension mm (in)	Projected dimensions mm (in)
(76)R — (76)L	764 (30.08)	—
(77)R — (77)L	968 (38.11)	—
(78)R — (78)L	766 (30.16)	—
(79)aR — (79)aL	548 (21.57)	—
(79)bR — (79)bL	548 (21.57)	—
(80)R — (80)L	818 (32.20)	—
(81)R — (81)L	548 (21.57)	—
(82)R — (82)L	387 (15.24)	—
(83)R — (83)L	908 (35.75)	—
(84)R — (84)L	548 (21.57)	—
(85)R — (85)L	548 (21.57)	—
(86)R — (86)L	1,228 (48.35)	—
(87)R — (87)L	1,225 (48.23)	—
(88)R — (88)L	1,096 (43.15)	—
(89)R — (89)L	883 (34.76)	—
(90)R — (90)L	897 (35.31)	—
(91)R — (91)L	1,544 (60.79)	—
(92)R — (92)L	1,544 (60.79)	—
(93)R — (93)L	1,544 (60.79)	—
(94)R — (94)L	1,560 (61.42)	—
(95)R — (95)L	370 (14.57)	—
(71)R — (74)L	1,027 (40.43)	1,005 (39.57)
(71)R — (76)L	1,312 (51.65)	1,311 (51.61)
(71)L — (77)R	1,451 (57.13)	1,451 (57.13)

Measuring point	Datum dimension mm (in)	Projected dimensions mm (in)
(71)L — (83)R	1,977 (77.83)	1,977 (77.83)
(72)R — (74)L	937 (36.89)	937 (36.89)
(72)R — (76)L	1,145 (45.08)	1,135 (44.68)
(72)L — (77)R	1,294 (50.94)	1,277 (50.28)
(72)L — (83)R	1,766 (69.53)	1,750 (68.90)
(73)R — (76)L	1,047 (41.22)	1,035 (40.75)
(73)L — (77)R	1,197 (47.13)	1,176 (46.30)
(73)L — (83)R	1,642 (64.65)	1,623 (63.90)
(74)R — (76)L	975 (38.39)	961 (37.83)
(74)L — (77)R	1,122 (44.17)	1,100 (43.31)
(74)L — (83)R	1,543 (60.75)	1,522 (59.92)
(78)R — (80)L	853 (33.58)	853 (33.58)
(80)R — (84)L	893 (35.16)	893 (35.16)
(80)R — (85)L	1,315 (51.77)	1,314 (51.73)
(80)L — (83)R	918 (36.14)	918 (36.14)
(80)L — (86)R	1,576 (62.05)	1,576 (62.05)
(83)R — (87)L	1,625 (63.98)	1,624 (63.94)
(84)L — (87)R	1,309 (51.54)	1,308 (51.50)
(85)L — (87)R	979 (38.54)	978 (38.50)
(86)R — (87)L	1,273 (50.12)	1,272 (50.08)
(87)L — (88)R	1,179 (46.42)	1,176 (46.30)
(87)L — (89)R	1,316 (51.81)	1,302 (51.26)
(88)R — (90)L	1,532 (60.31)	1,527 (60.12)
(89)R — (90)L	1,065 (41.93)	1,064 (41.89)



Body Reference Points

2. FRONT 1



BRM00753

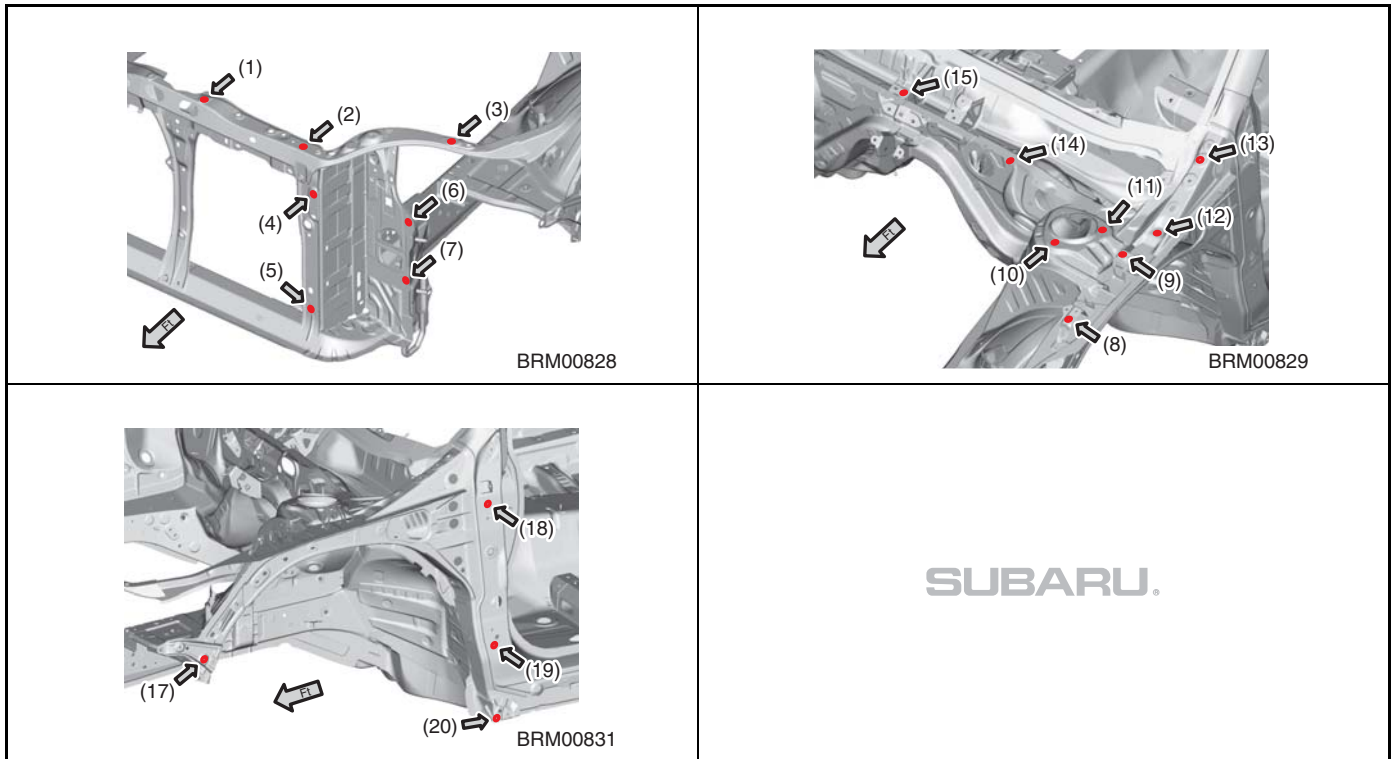
- | | | |
|---|--|---|
| (1) Energy absorber upper (left side) | (8) Headlight mounting hole (symmetrical) | (15) Gauge hole (left side) |
| (3) Headlight mounting hole (symmetrical) | (9) Front fender mounting hole (symmetrical) | (17) Front fender rear mounting hole (symmetrical) |
| (4) Energy absorber upper mounting hole (symmetrical) | (12) Gauge hole (symmetrical) | (18) Front door hinge upper mounting hole (symmetrical), upper side |
| (5R) Gauge hole (right side) | (13) Hood hinge rear mounting hole (symmetrical) | (19) Front door hinge lower mounting hole (symmetrical), lower side |
| (5L) Gauge hole (left side) | (14) Cowl panel mounting hole (symmetrical) | (20) Front fender front mounting hole (symmetrical) |

Body Reference Points

Measuring point	Datum dimension mm (in)
(1)L — (13)R	1,408 (55.43)
(1)L — (13)L	1,327 (52.24)
(1)L — (14)R	1,014 (39.92)
(1)L — (14)L	963 (37.91)
(1)L — (15)L	955 (37.60)
(3)R — (3)L	1,222 (48.11)
(3)R — (14)R	783 (30.83)
(3)R — (15)L	992 (39.06)
(3)L — (12)R	1,581 (62.24)
(3)L — (13)R	1,676 (65.98)
(3)L — (13)L	958 (37.72)
(3)L — (15)L	975 (38.39)
(4)R — (4)L	755 (29.72)
(4)R — (5)L	806 (31.73)
(4)L — (5)R	804 (31.65)
(5)R — (5)L	730 (28.74)

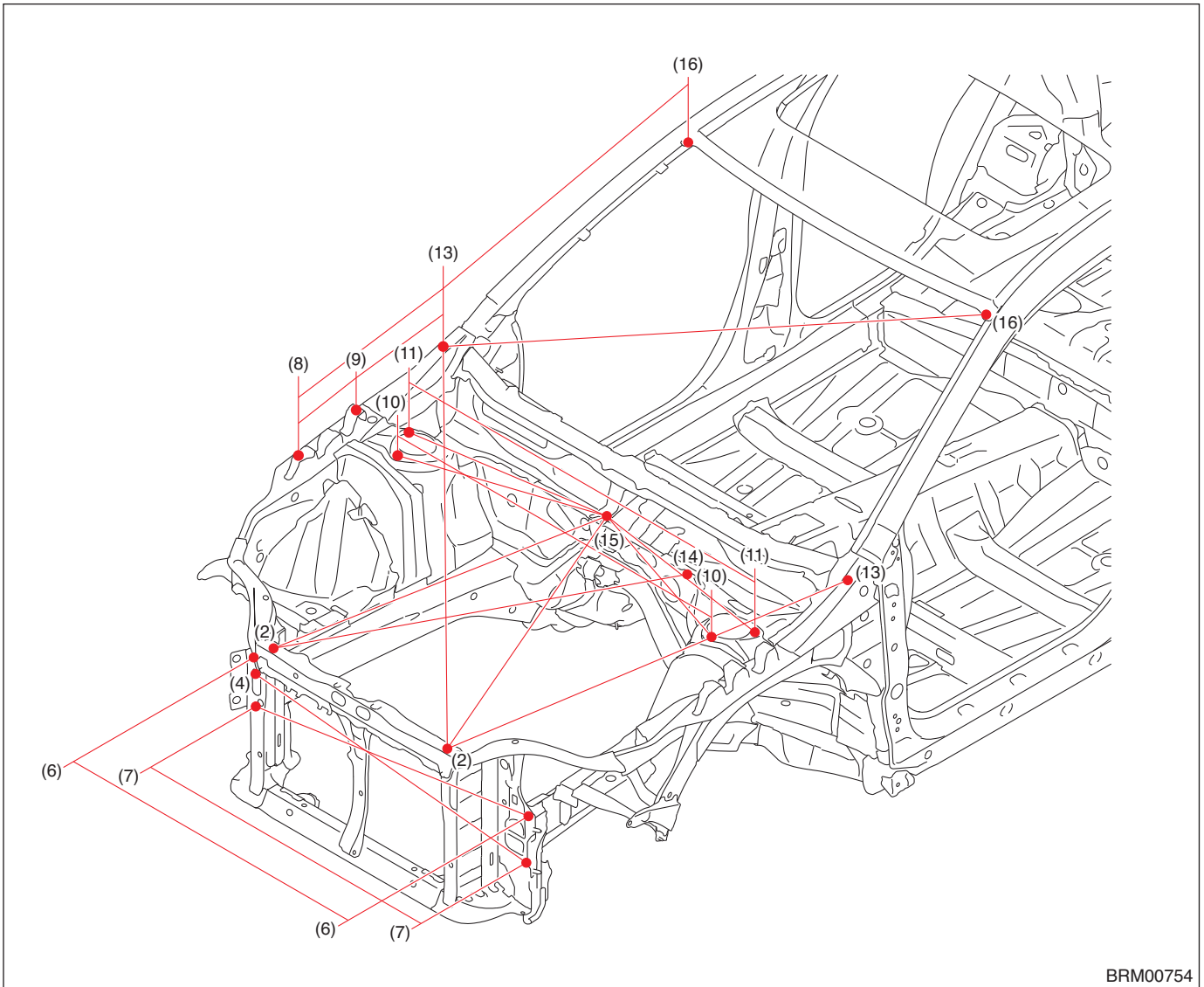
Measuring point	Datum dimension mm (in)
(8)R — (8)L	1,563 (61.54)
(8)R — (9)L	1,579 (62.17)
(8)R — (15)L	883 (34.76)
(8)L — (14)R	1,187 (46.73)
(8)L — (15)L	858 (33.78)
(9)R — (9)L	1,563 (61.54)
(9)R — (15)L	812 (31.97)
(9)L — (15)L	786 (30.94)
(12)R — (12)L	1,566 (61.65)
(13)R — (13)L	1,546 (60.87)
(13)R — (15)L	808 (31.81)
(13)L — (15)L	781 (30.75)
(17)L — (18)L	930 (36.61)
(17)L — (19)L	906 (35.67)
(17)L — (20)L	971 (38.23)

- Reference point (1) and (15) indicates a left side part. The reference point (5) is the left-right asymmetry. 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



BRM00754

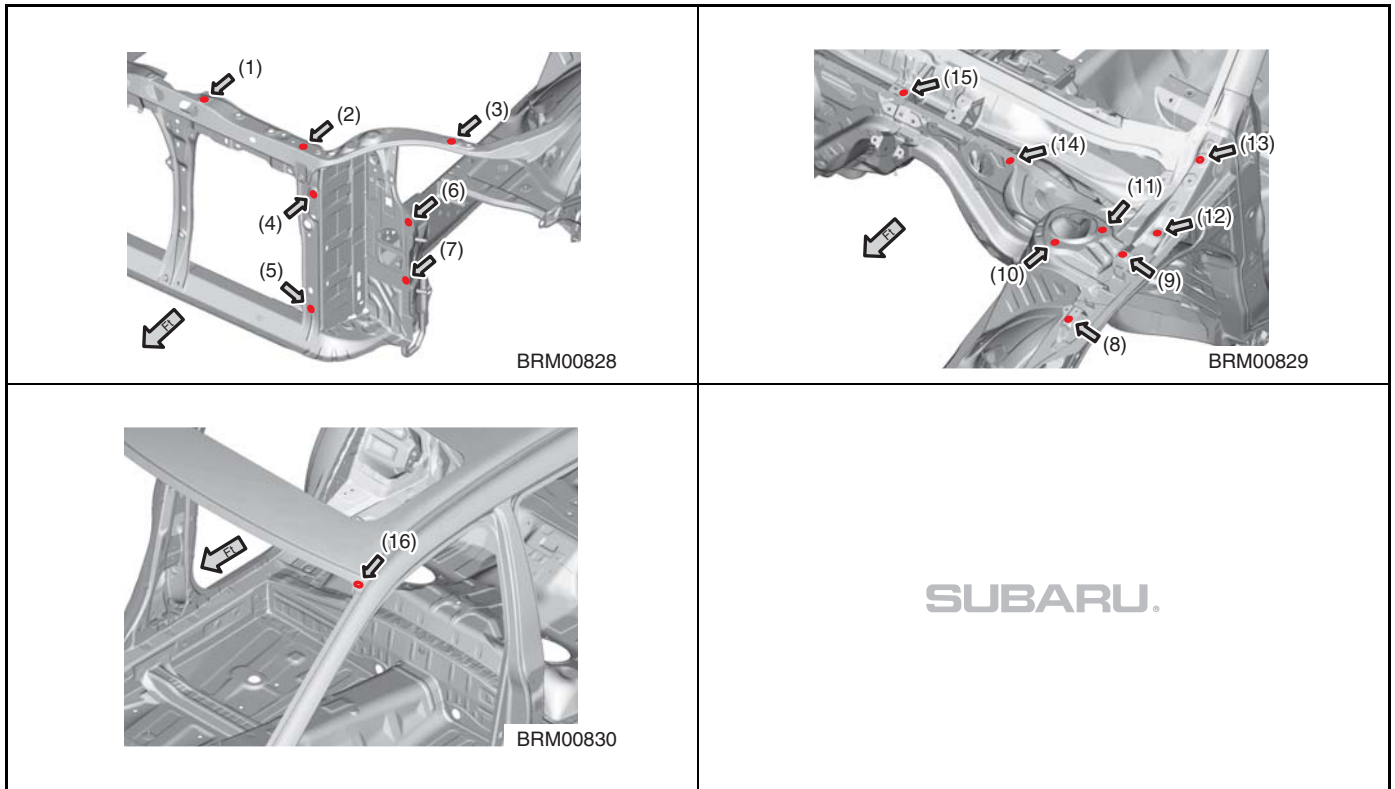
- | | | |
|---|--|--|
| (2) Bracket radiator upper mounting hole (symmetrical) | (9) Front fender mounting hole (symmetrical) | (15) Gauge hole (left side) |
| (4) EA upper mounting hole (symmetrical) | (10) Front suspension mounting hole (symmetrical), front | (16) Front glass installation reference hole (symmetrical) |
| (6) Front bumper beam mounting hole (symmetrical), upper side | (11) Front suspension mounting hole (symmetrical), rear outer side | |
| (7) Front bumper beam mounting hole (symmetrical), lower side | (13) Hood hinge rear mounting hole (symmetrical) | |
| (8) Headlight mounting hole (symmetrical) | (14) Cowl panel mounting hole (symmetrical) | |

Body Reference Points

Measuring point	Datum dimension mm (in)
(2)R — (14)L	1,136 (44.72)
(2)R — (15)L	1,001 (39.41)
(2)L — (13)R	1,569 (61.77)
(2)L — (13)L	1,198 (47.17)
(2)L — (15)L	992 (39.06)
(4)R — (7)L	939 (36.97)
(6)R — (6)L	1,050 (41.34)
(6)L — (7)R	1,054 (41.50)
(7)R — (7)L	1,034 (40.71)
(8)R — (9)R	224 (8.82)

Measuring point	Datum dimension mm (in)
(8)R — (13)R	553 (21.77)
(9)R — (13)R	329 (12.95)
(10)R — (10)L	1,200 (47.24)
(10)R — (15)L	641 (25.24)
(10)L — (15)L	615 (24.21)
(11)R — (11)L	1,322 (52.05)
(11)R — (15)L	680 (26.77)
(11)L — (15)L	653 (25.71)
(13)R — (16)R	864 (34.02)
(13)R — (16)L	1,584 (62.36)

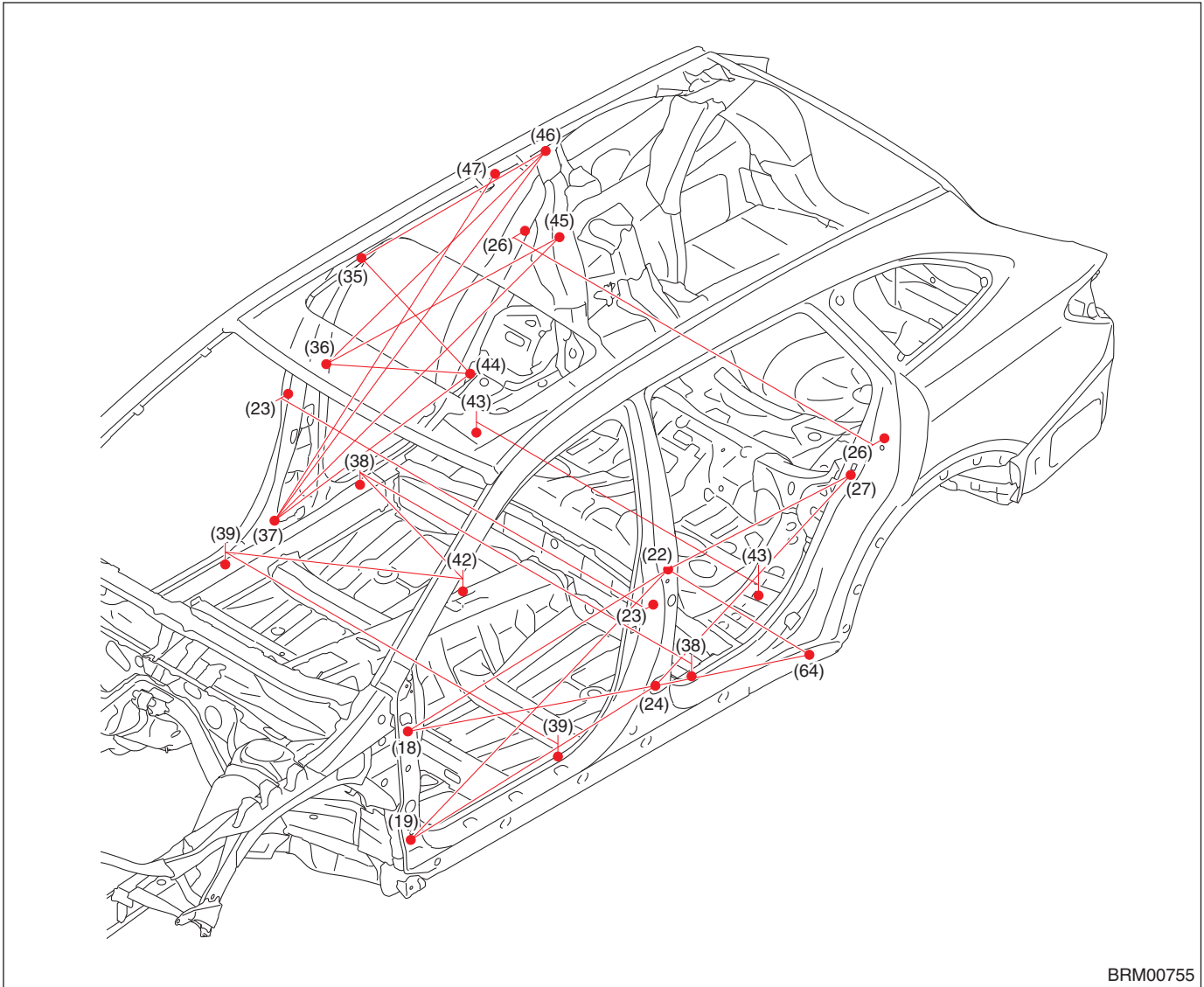
- Reference point (15) indicates a left side part. All other reference points indicate left-right symmetrical parts.
- The dimensions are the actual dimensions between the reference points.



Body Reference Points

4. INSIDE 1

• Common for OUTBACK and SEDAN



BRM00755

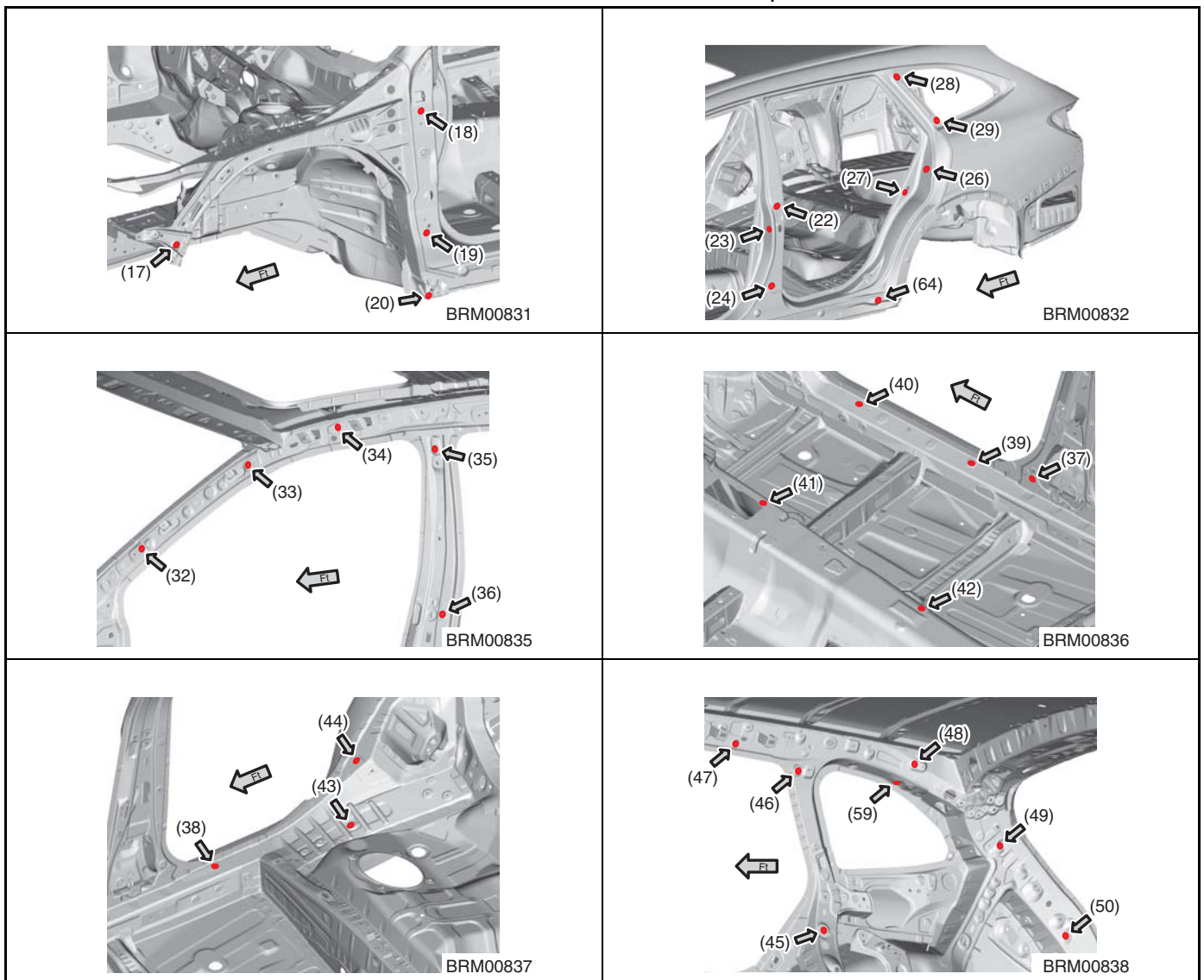
- | | | |
|---|--|--|
| (18) Front door hinge upper mounting hole (symmetrical), upper side | (36) B pillar trim mounting hole (symmetrical) | (45) Rear seat striker mounting hole (symmetrical) |
| (19) Front door hinge lower mounting hole (symmetrical), lower side | (37) B pillar trim mounting hole (symmetrical) | (46) C pillar trim mounting hole (symmetrical) |
| (22) Rear door hinge upper mounting hole (symmetrical), upper side | (38) Harness clip mounting hole (symmetrical) | (47) Gauge hole (symmetrical) |
| (23) Front door striker mounting hole (symmetrical), upper side | (39) Harness clip mounting hole (symmetrical) | (64) Side sill spoiler mounting hole (symmetrical) |
| (24) Rear door hinge lower mounting hole (symmetrical), front side | (42) Bracket console mounting hole (symmetrical) | |
| (26) Rear door striker mounting hole (symmetrical), upper side | (43) Side sill cover mounting hole (symmetrical) | |
| (27) Rear door switch mounting hole (symmetrical) | (44)R Air bag sensor mounting hole (right side) | |
| (35) Pad B pillar mounting hole (symmetrical) | (44)L Air bag sensor mounting hole (left side) | |

Body Reference Points

Measuring point	Datum dimension mm (in)
(18)L — (22)L	1,146 (45.12)
(18)L — (24)L	1,139 (44.84)
(19)L — (22)L	1,228 (48.35)
(19)L — (24)L	1,077 (42.40)
(22)L — (27)L	878 (34.57)
(22)L — (64)L	843 (33.19)
(23)R — (23)L	1,605 (63.19)
(24)L — (27)L	984 (38.74)
(24)L — (64)L	684 (26.93)
(26)R — (26)L	1,580 (62.20)
(35)R — (44)R	1,043 (41.06)
(35)R — (46)R	801 (31.54)
(35)L — (44)L	1,029 (40.51)
(36)R — (44)R	747 (29.41)

Measuring point	Datum dimension mm (in)
(36)R — (45)R	984 (38.74)
(36)R — (46)R	960 (37.80)
(36)L — (44)L	735 (28.94)
(37)R — (44)R	877 (34.53)
(37)R — (45)R	1,305 (51.38)
(37)R — (46)R	1,425 (56.10)
(37)R — (47)R	1,296 (51.02)
(37)L — (44)L	871 (34.29)
(38)R — (38)L	1,457 (57.36)
(38)R — (42)R	722 (28.43)
(39)R — (39)L	1,462 (57.56)
(39)R — (42)R	776 (30.55)
(43)R — (43)L	1,240 (48.82)

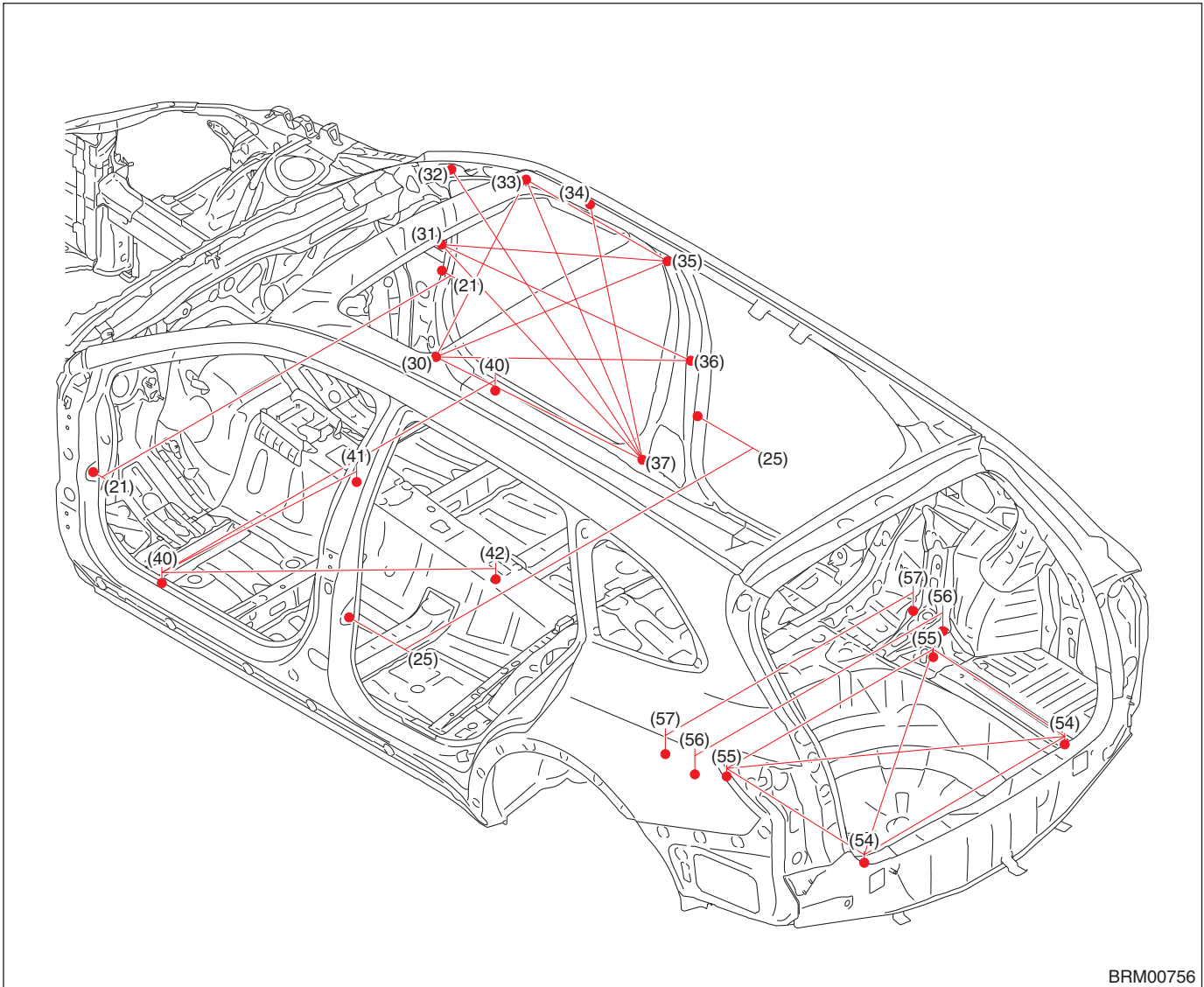
- The reference point (44) is the left-right asymmetry. All other reference points indicate left-right symmetrical parts.
- The dimensions are the actual dimensions between the reference points.



Body Reference Points

5. INSIDE 2

• Common for OUTBACK and SEDAN



BRM00756

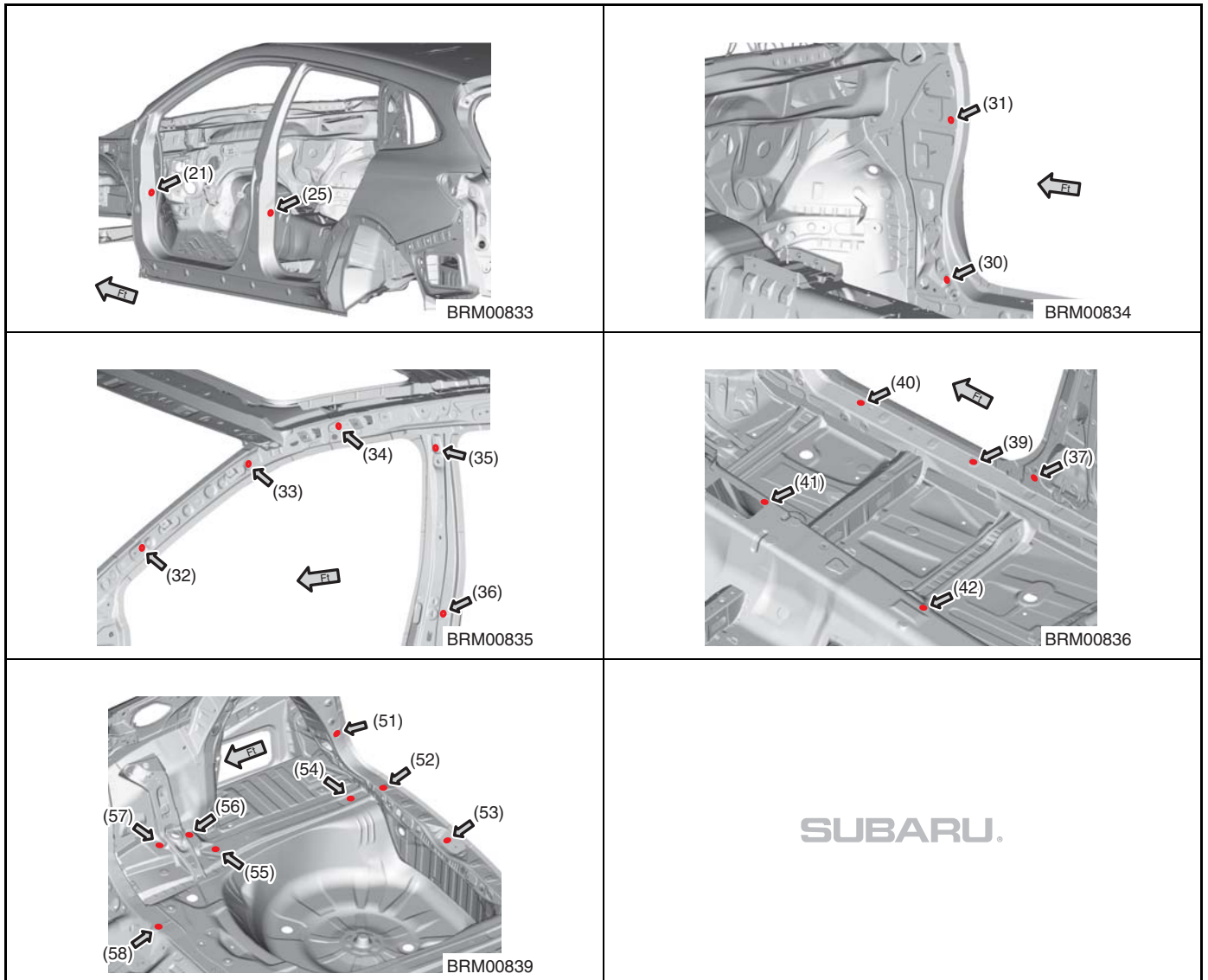
- | | | |
|--|--|--|
| (21) Front door checker mounting hole (symmetrical) | (34) Curtain air bag mounting hole (symmetrical) | (42) Bracket console mounting hole (symmetrical) |
| (25) Rear door checker mounting hole (symmetrical) | (35) Pad B pillar mounting hole (symmetrical) | (54) Gauge hole (right side) R |
| (30) A pillar trim mounting hole (symmetrical) | (36) B pillar trim mounting hole (symmetrical) | (54) Gauge hole (left side) L |
| (31) Steering support beam mounting hole (symmetrical), lower side | (37) B pillar trim mounting hole (symmetrical) | (55) Gauge hole (symmetrical) |
| (32) Curtain air bag mounting hole (symmetrical) | (40) Harness clip mounting hole (symmetrical) | (56) Rear suspension mounting hole (symmetrical), rear side |
| (33) Gauge hole (symmetrical) | (41) Shift case mounting hole (symmetrical) | (57) Rear suspension mounting hole (symmetrical), front side |

Body Reference Points

Measuring point	Datum dimension mm (in)
(21)R — (21)L	1,530 (60.24)
(25)R — (25)L	1,528 (60.16)
(30)R — (33)R	1,089 (42.87)
(30)R — (35)R	1,482 (58.35)
(30)R — (36)R	1,205 (47.44)
(30)R — (37)R	870 (34.25)
(31)R — (35)R	1,258 (49.53)
(31)R — (36)R	1,097 (43.19)
(31)R — (37)R	954 (37.56)
(32)R — (37)R	1,078 (42.44)
(33)R — (35)R	624 (24.57)
(33)R — (37)R	1,023 (40.28)

Measuring point	Datum dimension mm (in)
(34)R — (37)R	1,039 (40.91)
(40)R — (40)L	1,462 (57.56)
(40)L — (41)L	713 (28.07)
(40)L — (42)L	1,040 (40.94)
(54)R — (54)L	889 (35.00)
(54)R — (55)R	586 (23.07)
(54)R — (55)L	1,072 (42.20)
(54)L — (55)R	1,077 (42.40)
(54)L — (55)L	596 (23.46)
(55)R — (55)L	906 (35.67)
(56)R — (56)L	1,087 (42.80)
(57)R — (57)L	1,087 (42.80)

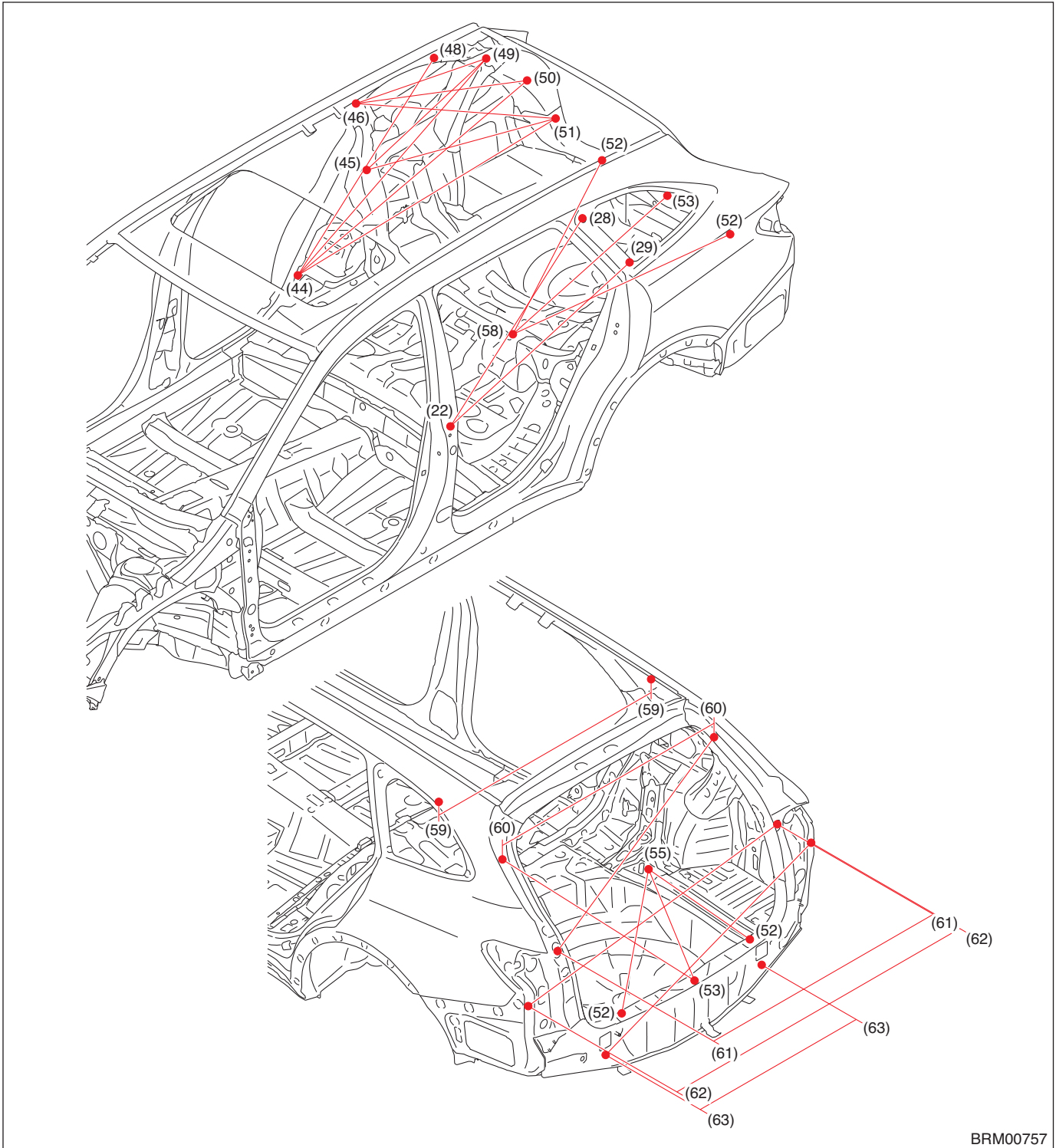
- The reference point (54) is the left-right asymmetry. All other reference points indicate left-right symmetrical parts.
- The dimensions are the actual dimensions between the reference points.



Body Reference Points

6. INSIDE & REAR 1

• SPECIAL OUTBACK PARTS



BRM00757

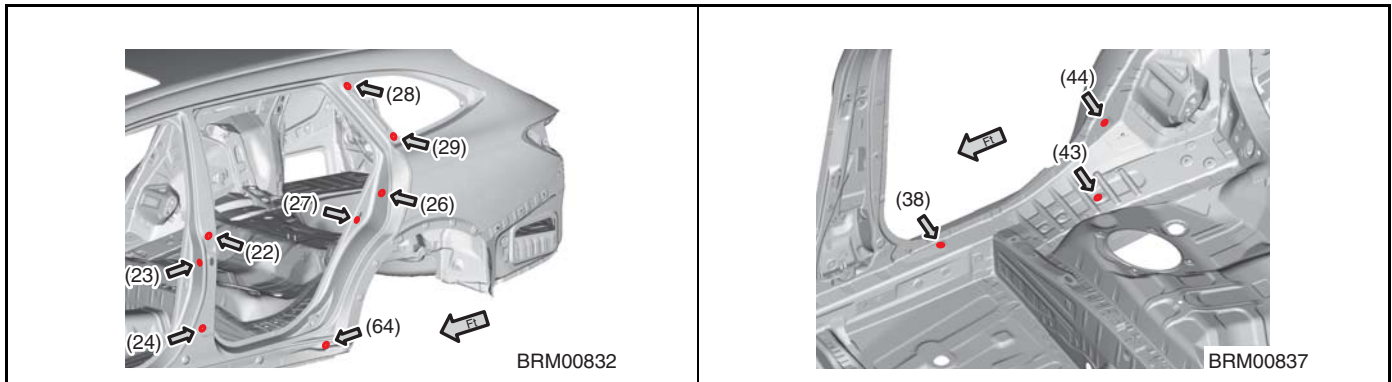
Body Reference Points

- | | | |
|---|---|---|
| (22) Rear door hinge upper mounting hole (symmetrical), upper side | (48) Curtain air bag mounting hole (symmetrical) | (58) Spacer front mounting hole (symmetrical) |
| (28) Rear quarter glass mounting hole (symmetrical), front upper side | (49) Gauge hole (symmetrical) | (59) C pillar trim mounting hole (symmetrical) |
| (29) Rear quarter glass mounting hole (symmetrical), front lower side | (50) Bracket remote lever mounting hole (symmetrical) | (60) Rear gate stay mounting hole (symmetrical), lower side |
| (44) Air bag sensor mounting hole R (right side) | (51) Apron trim mounting hole (symmetrical) | (61) Rear combination light mounting hole (symmetrical), upper side |
| (44) Air bag sensor mounting hole L (left side) | (52) Skirt trim mounting hole (symmetrical) | (62) Rear bumper bracket mounting hole (symmetrical) |
| (45) Rear seat striker mounting hole (symmetrical) | (53) Rear gate striker mounting hole (symmetrical) | (63) Rear bumper beam mounting hole (symmetrical) |
| (46) C pillar trim mounting hole (symmetrical) | (55) Gauge hole (symmetrical) | |

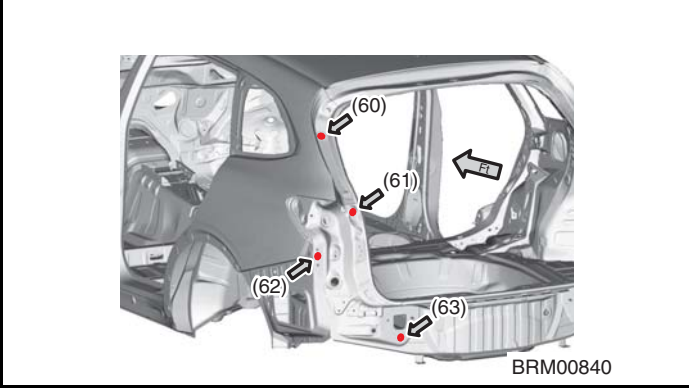
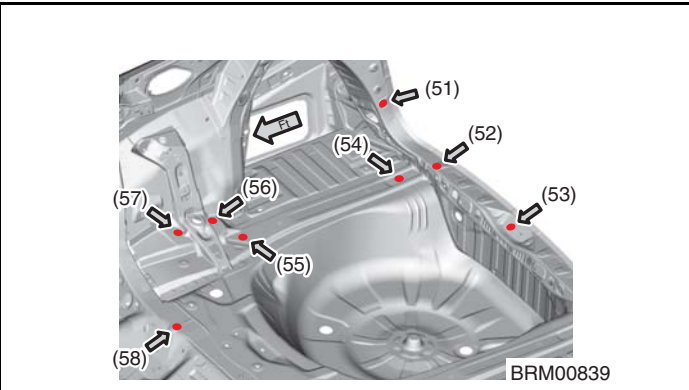
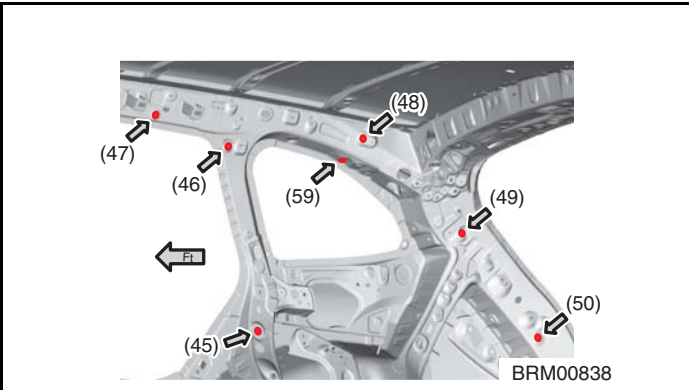
Measuring point	Datum dimension mm (in)
(22)L — (28)L	1,062 (41.81)
(22)L — (29)L	1,119 (44.06)
(44)R — (48)R	1,077 (42.40)
(44)R — (49)R	1,158 (45.59)
(44)R — (50)R	1,260 (49.61)
(44)R — (51)R	1,330 (52.36)
(44)L — (48)L	1,071 (42.17)
(44)L — (49)L	1,157 (45.55)
(44)L — (50)L	1,263 (49.72)
(44)L — (51)L	1,335 (52.56)
(45)R — (49)R	667 (26.26)
(45)R — (51)R	991 (39.02)
(46)R — (49)R	756 (29.76)
(46)R — (50)R	1,068 (42.05)
(46)R — (51)R	1,289 (50.75)

Measuring point	Datum dimension mm (in)
(52)R — (55)R	671 (26.42)
(52)R — (58)L	1,231 (48.46)
(52)L — (55)R	1,055 (41.54)
(52)L — (58)L	1,097 (43.19)
(53)R — (55)R	817 (32.17)
(53)R — (58)L	1,139 (44.84)
(53)R — (60)L	1,033 (40.67)
(59)R — (59)L	1,210 (47.64)
(60)R — (60)L	1,206 (47.48)
(60)R — (61)L	1,303 (51.30)
(61)R — (61)L	1,252 (49.29)
(61)R — (62)L	1,443 (56.81)
(62)R — (62)L	1,612 (63.46)
(62)R — (63)L	1,310 (51.57)
(63)R — (63)L	889 (35.00)

- The reference point (44) is the left-right asymmetry. All other reference points indicate left-right symmetrical parts.
- The dimensions are the actual dimensions between the reference points.



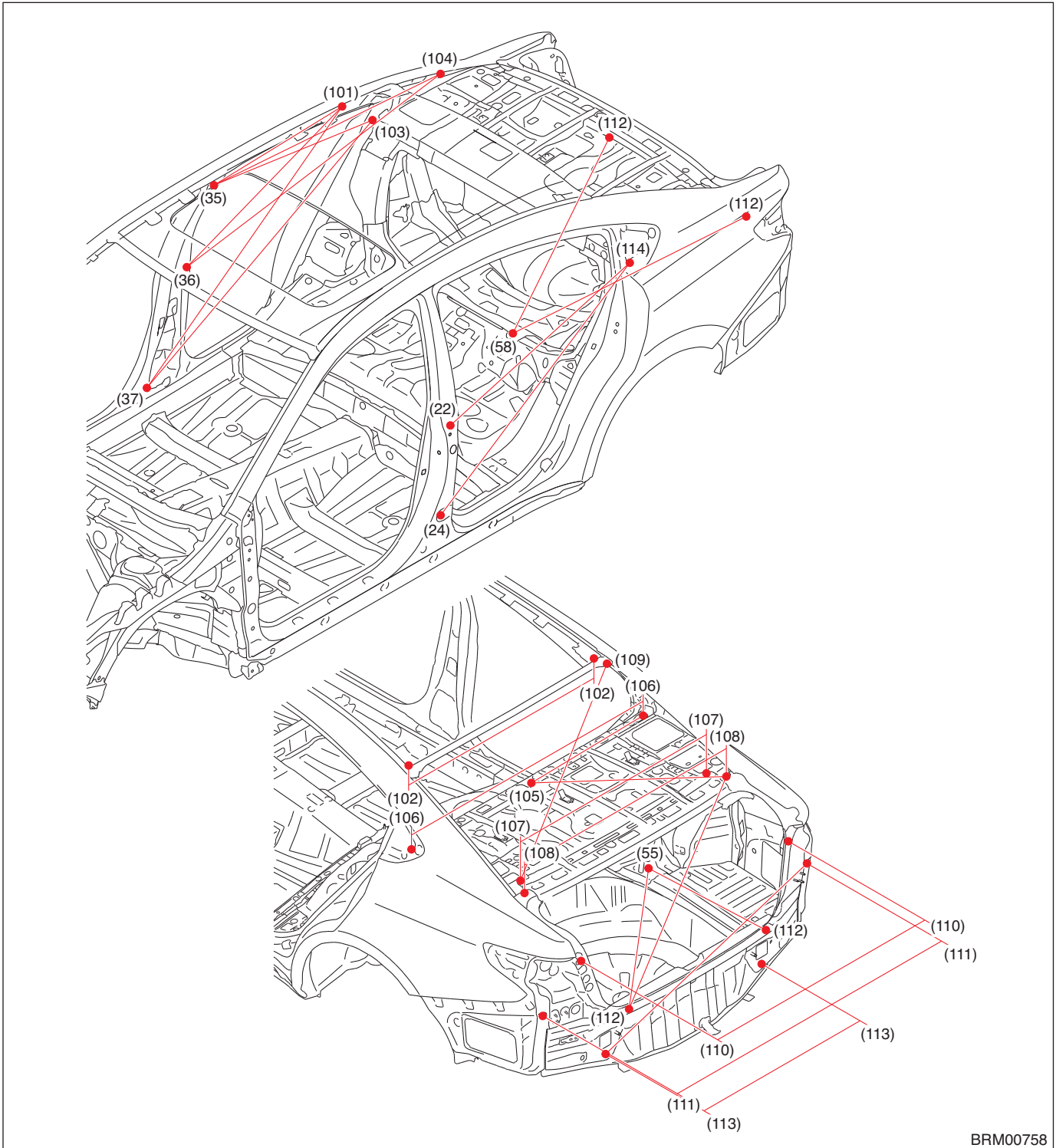
Body Reference Points



Body Reference Points

7. INSIDE & REAR 2

• SPECIAL SEDAN PARTS



BRM00758

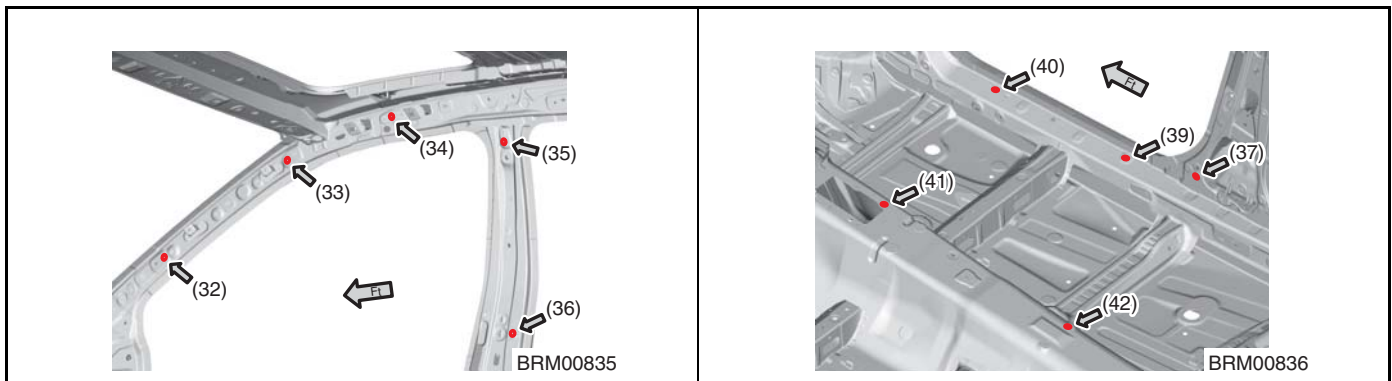
Body Reference Points

(22) Rear door hinge upper mounting hole (symmetrical), upper side (24) Rear door hinge lower mounting hole (symmetrical), front side (35) Pad B pillar mounting hole (symmetrical) (36) B pillar trim mounting hole (symmetrical) (37) B pillar trim mounting hole (symmetrical) (55) Gauge hole (symmetrical) (58) Spacer front mounting hole (symmetrical)	(101) Sunroof drain mounting hole (symmetrical) (102) Harness mounting hole (symmetrical) (103) Trim mounting hole (symmetrical) (104) Trim mounting hole (symmetrical) (105) Rear shelf mounting hole (body center) (106) Gauge hole (symmetrical) (107) Trunk hinge mounting hole (symmetrical), rear side	(108) Gauge hole (symmetrical) (109) Rear glass installation reference hole (symmetrical) (110) Rear combination light mounting hole (symmetrical), upper side (111) Gauge hole (symmetrical) (112) Gauge hole (symmetrical) (113) Rear bumper beam mounting hole (symmetrical) (114) C pillar cover mounting hole (symmetrical)
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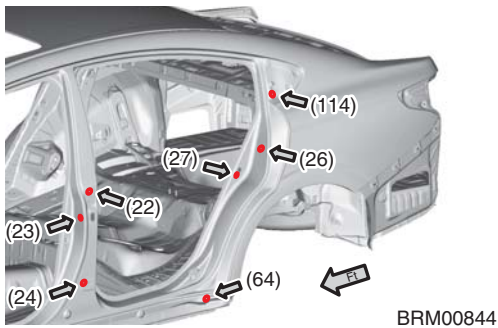
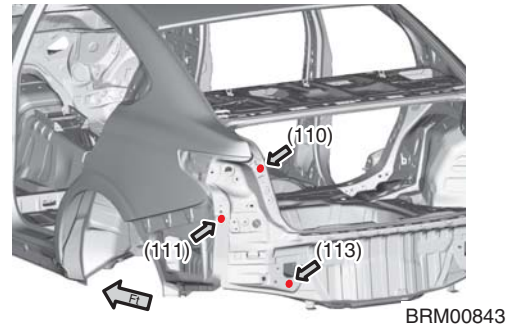
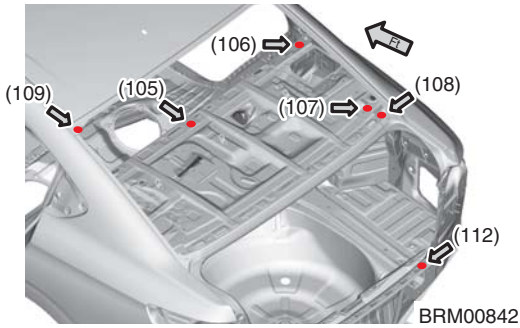
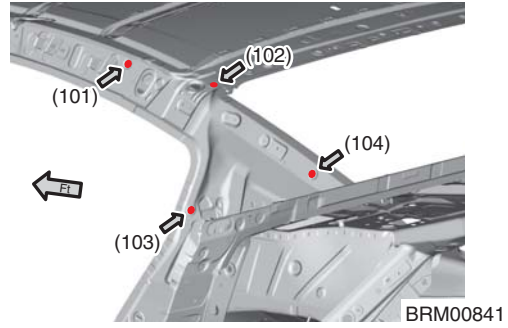
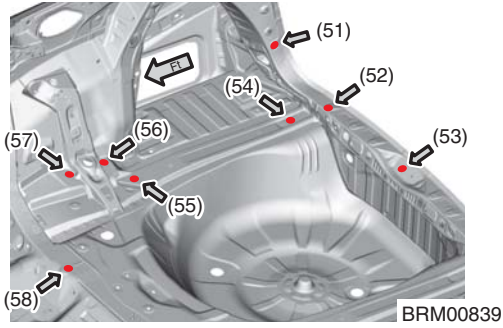
Measuring point	Datum dimension mm (in)
(22)L — (114)L	1,118 (44.02)
(24)L — (114)L	1,320 (51.97)
(35)R — (101)R	698 (27.48)
(35)R — (103)R	1,029 (40.51)
(35)R — (104)R	1,318 (51.89)
(36)R — (101)R	901 (35.47)
(36)R — (104)R	1,385 (54.53)
(37)R — (101)R	1,387 (54.61)
(37)R — (103)R	1,439 (56.65)
(55)R — (112)R	740 (29.13)
(55)R — (112)L	1,120 (44.09)
(58)L — (112)R	1,304 (51.34)
(58)L — (112)L	1,170 (46.06)

Measuring point	Datum dimension mm (in)
(102)R — (102)L	1,056 (41.57)
(105) — (106)R	660 (25.98)
(105) — (108)R	786 (30.94)
(106)R — (106)L	1,320 (51.97)
(107)R — (107)L	1,059 (41.69)
(107)L — (109)R	1,245 (49.02)
(108)R — (108)L	1,150 (45.28)
(108)R — (112)L	1,145 (45.08)
(110)R — (110)L	1,181 (46.50)
(111)R — (111)L	1,506 (59.29)
(111)R — (113)L	1,240 (48.82)
(113)R — (113)L	889 (35.00)

- Reference point (105) indicates a body center part. All other reference points indicate left-right symmetrical parts.
- The dimensions are the actual dimensions between the reference points.



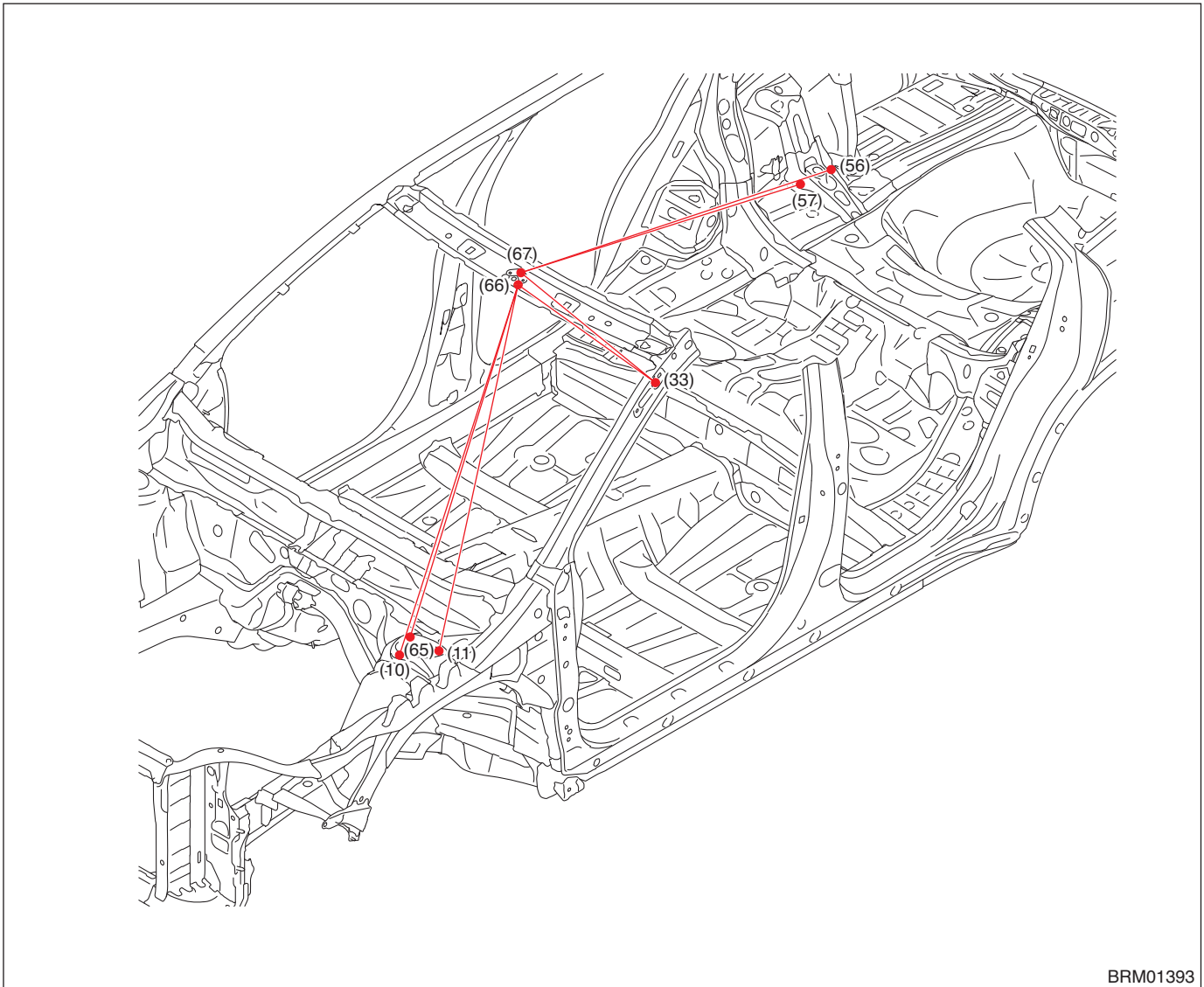
Body Reference Points



SUBARU.

Body Reference Points

8. FRONT ROOF RAIL (CAMERA PLATE)



BRM01393

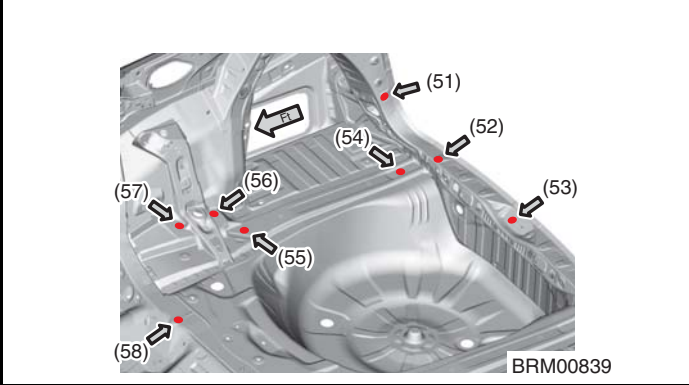
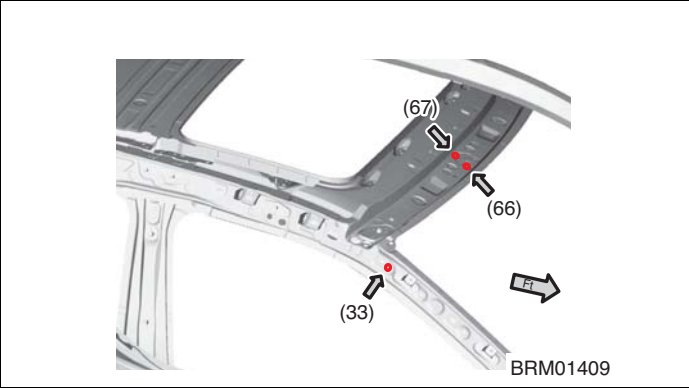
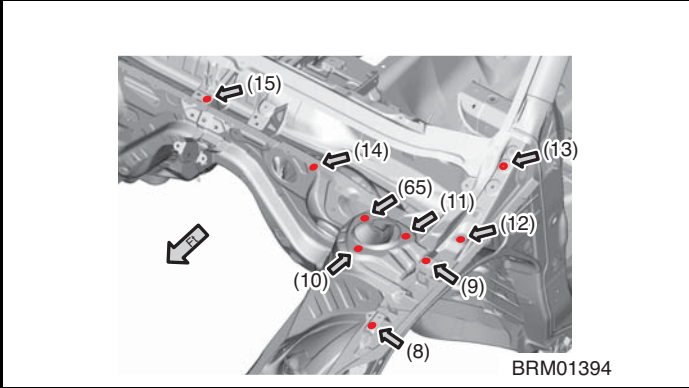
- | | | |
|--|--|---|
| (10) Front suspension mounting hole (symmetrical), front | (56) Rear suspension mounting hole (symmetrical), rear side | (66) Stereo camera (camera plate) mounting hole (symmetrical), front side |
| (11) Front suspension mounting hole (symmetrical), rear outer side | (57) Rear suspension mounting hole (symmetrical), front side | (67) Stereo camera (camera plate) mounting hole (body center), rear side |
| (33) Gauge hole (symmetrical) | (65) Front suspension mounting hole (symmetrical), rear inside | |

Measuring point	Datum dimension mm (in)
(10)L — (66)L	1,323 (52.09)
(11)L — (66)L	1,272 (50.08)
(33)L — (66)L	580 (22.83)
(33)L — (67)	610 (24.02)

Measuring point	Datum dimension mm (in)
(56)R — (67)	2,091 (82.32)
(57)R — (67)	1,973 (77.68)
(65)L — (66)L	1,220 (48.03)

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

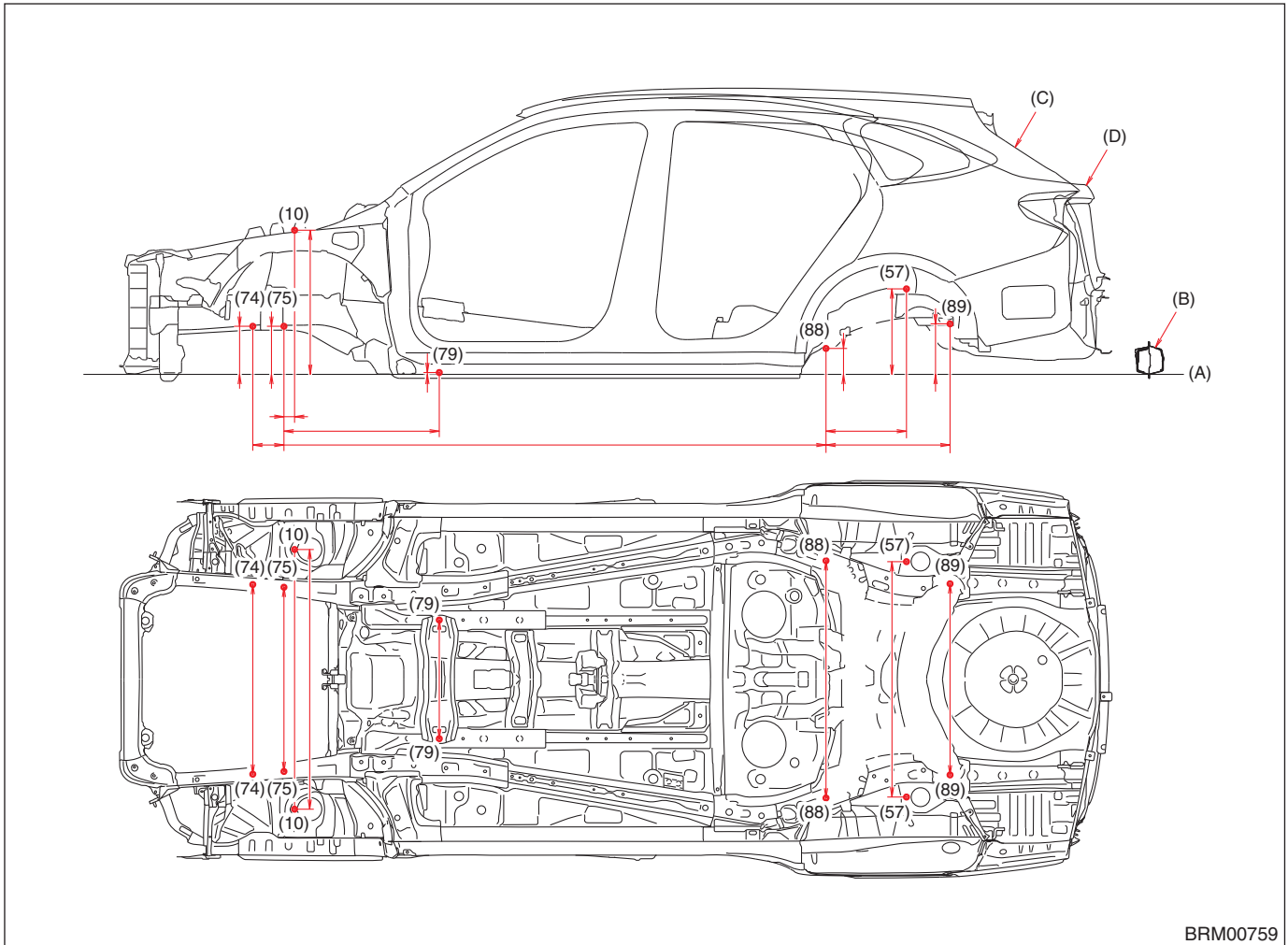
Body Reference Points



7. Measurement for Combined Parts

A: DIMENSIONS

1. SUSPENSION MOUNT & ENGINE MOUNT



BRM00759

- The longitudinal dimensions are projected dimensions.
- The height dimensions are the vertical distances from the gauge point on the assumed horizontal line through the side sill flange joint (bending angle point).

(A) Standard line
(B) Side sill outer panel

(C) OUTBACK

(D) SEDAN

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

(75) Front crossmember mounting hole (symmetrical), rear side

(88) Rear suspension crossmember mounting hole (symmetrical), front side

(57) Rear suspension mounting hole (symmetrical), front side

(79a) CFT-CVT crossmember upper mounting hole (symmetrical)

(89) Rear suspension crossmember mounting hole (symmetrical), rear side

(74) Front crossmember mounting hole (symmetrical), front side

(79b) HT-CVT crossmember upper mounting hole (symmetrical)

Measurement for Combined Parts

Measuring point	Datum dimension mm (in)
Datum line — (10)	666 (26.22)
Datum line — (57)	395 (15.55)
Datum line — (74)	222 (8.74)
Datum line — (75)	222 (8.74)
Datum line — (79)a	9 (0.35)
Datum line — (79)b	9 (0.35)
Datum line — (88)	120 (4.72)
Datum line — (89)	233 (9.17)
(10) — (75)	49 (1.93)
(57) — (88)	372 (14.65)
(74) — (75)	144 (5.67)
(75) — (79)a	718 (28.27)

Measuring point	Datum dimension mm (in)
(75) — (79)b	828 (32.60)
(75) — (88)	2,504 (98.58)
(88) — (89)	573 (22.56)
(10) — (10)	1,200 (47.24)
(57) — (57)	1,087 (42.80)
(74) — (74)	876 (34.49)
(75) — (75)	851 (33.50)
(79)a — (79)a	548 (21.57)
(79)b — (79)b	548 (21.57)
(88) — (88)	1,096 (43.15)
(89) — (89)	883 (34.76)

CAUTION:

For the reference point (10), refer to the figure "FRONT 2, DIMENSIONS, Body Reference Points" on page 44.

For the reference point (57), refer to the figure "INSIDE 2, DIMENSIONS, Body Reference Points" on page 48.

Except the reference points (10) and (57), refer to the figure "LOWER SURFACE, DIMENSIONS, Body Reference Points" on page 39.

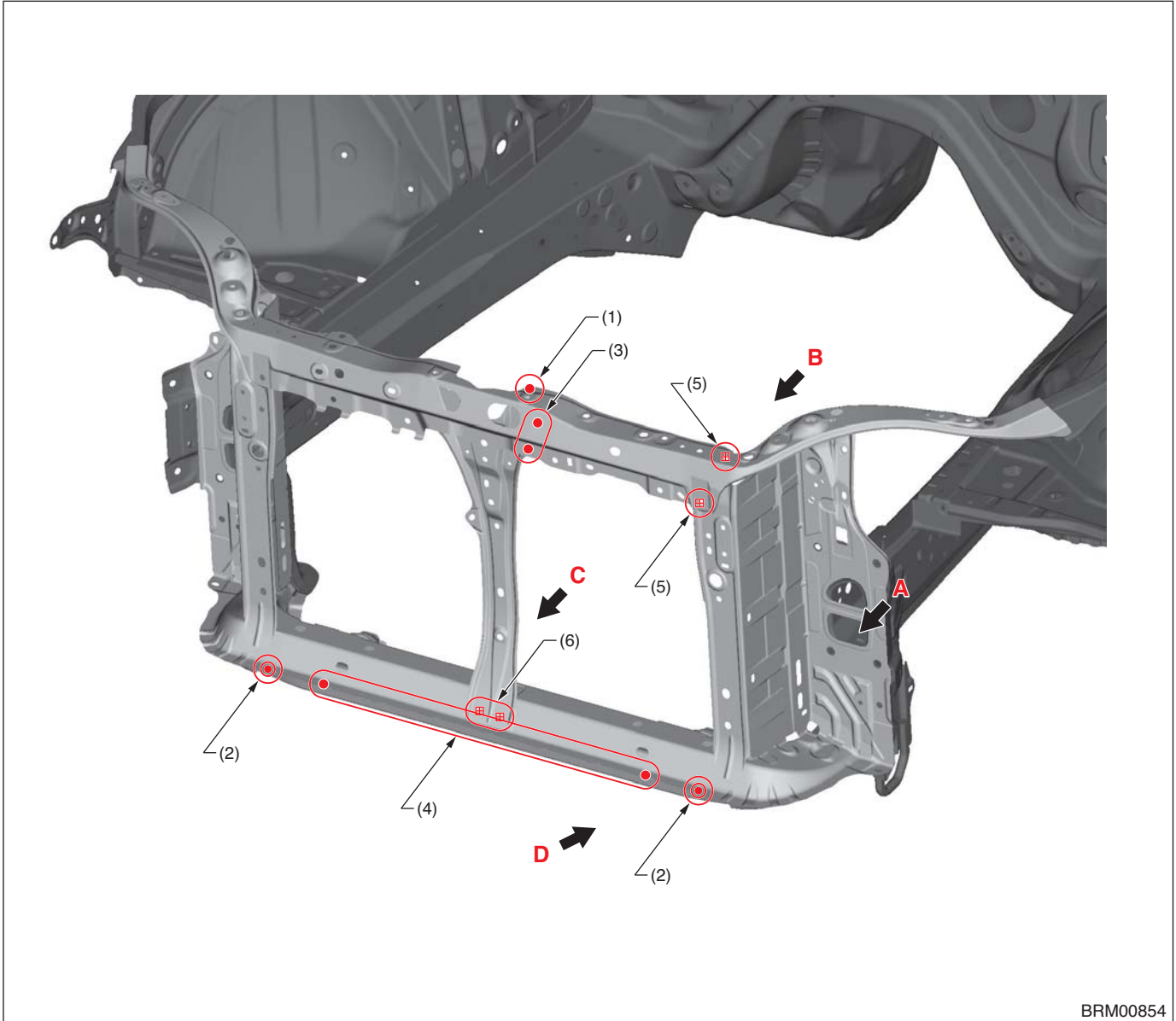
Panel Replacement

8. Panel Replacement

8-1. Radiator Panel (Total replacement)

A: REMOVAL

• Overall view



BRM00854

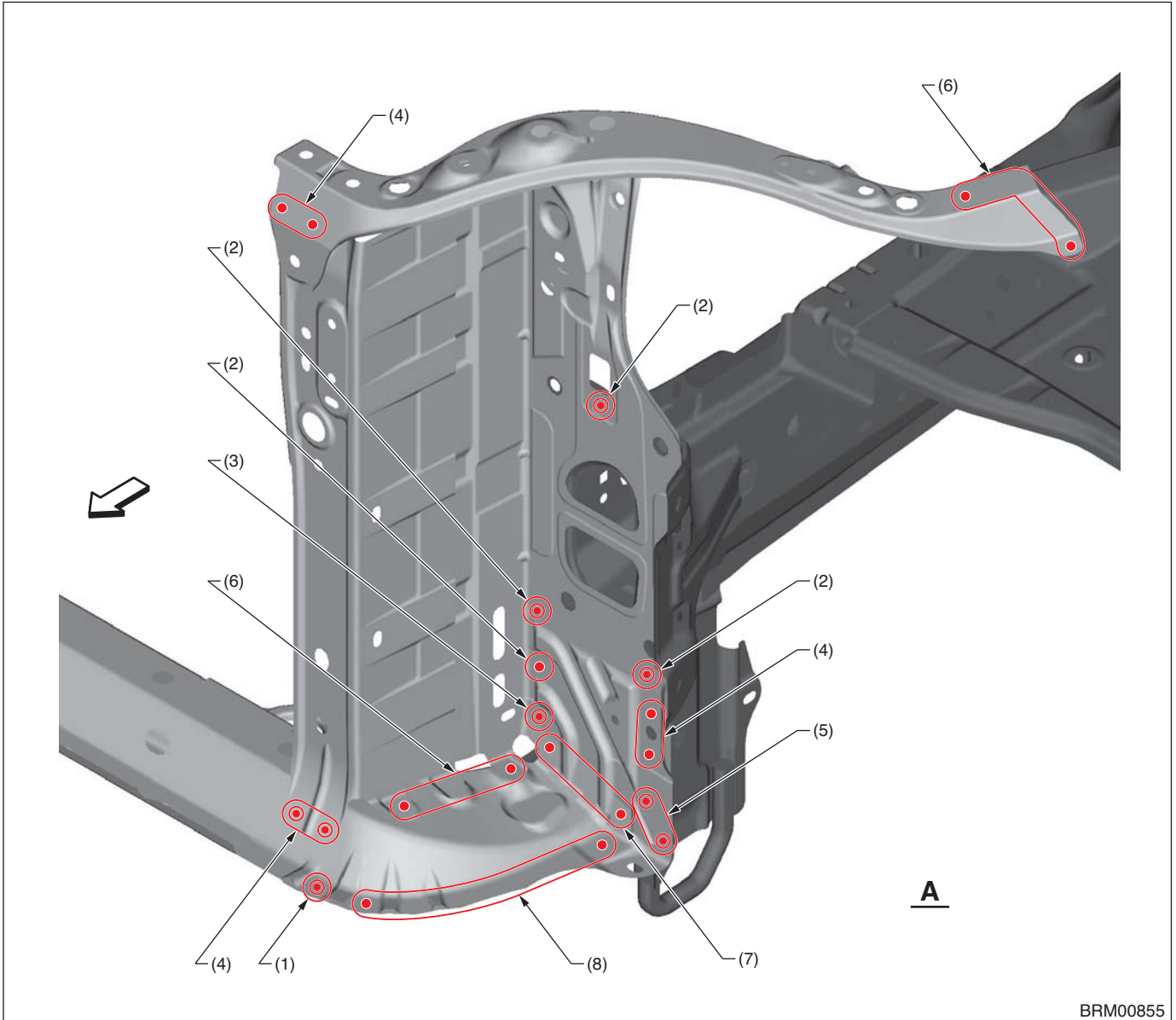
(1) 1 point (top · 1)
(2) 1 point (top · 2)

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

(5) 1 point (bolt)
(6) 2 points (bolt)

Panel Replacement

• View A



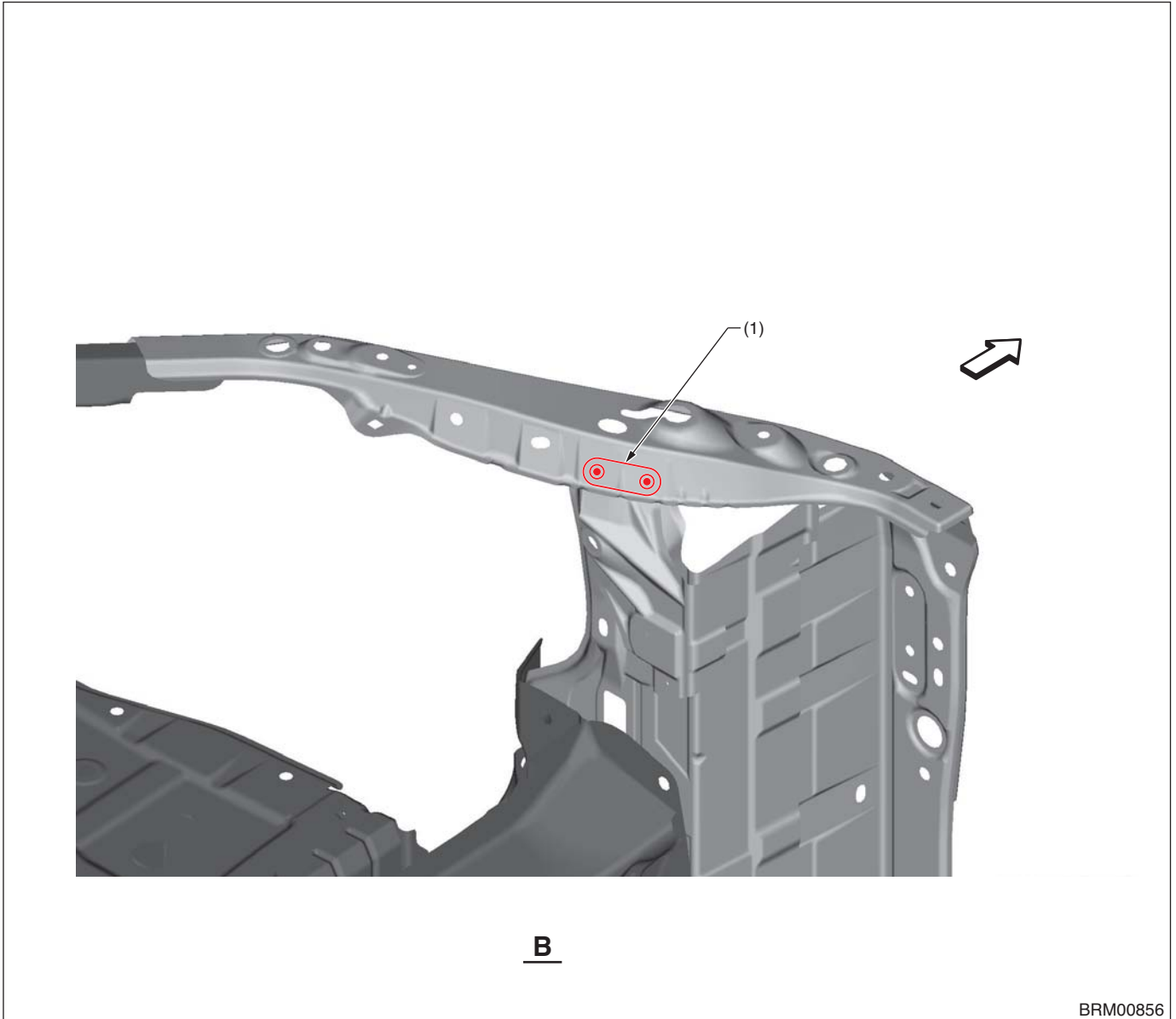
- (1) 1 point (top · 2)
- (2) 1 point (outside · 1)
- (3) 1 point (outside · 2)

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

- (7) 3 points (outside · 1)
- (8) 6 points (top · 1)

Panel Replacement

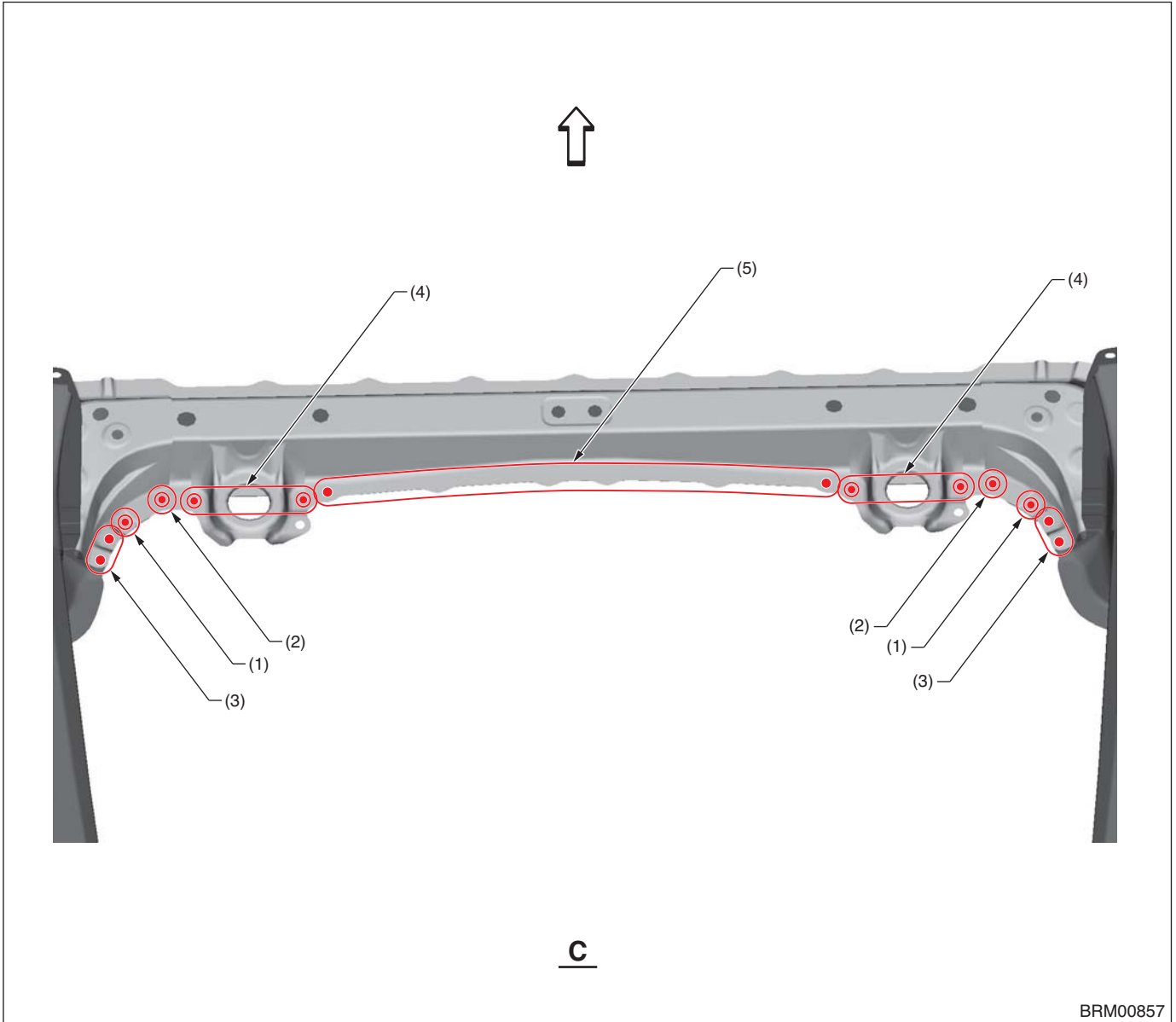
- View B



(1) 2 points (inside · 1)

Panel Replacement

• View C



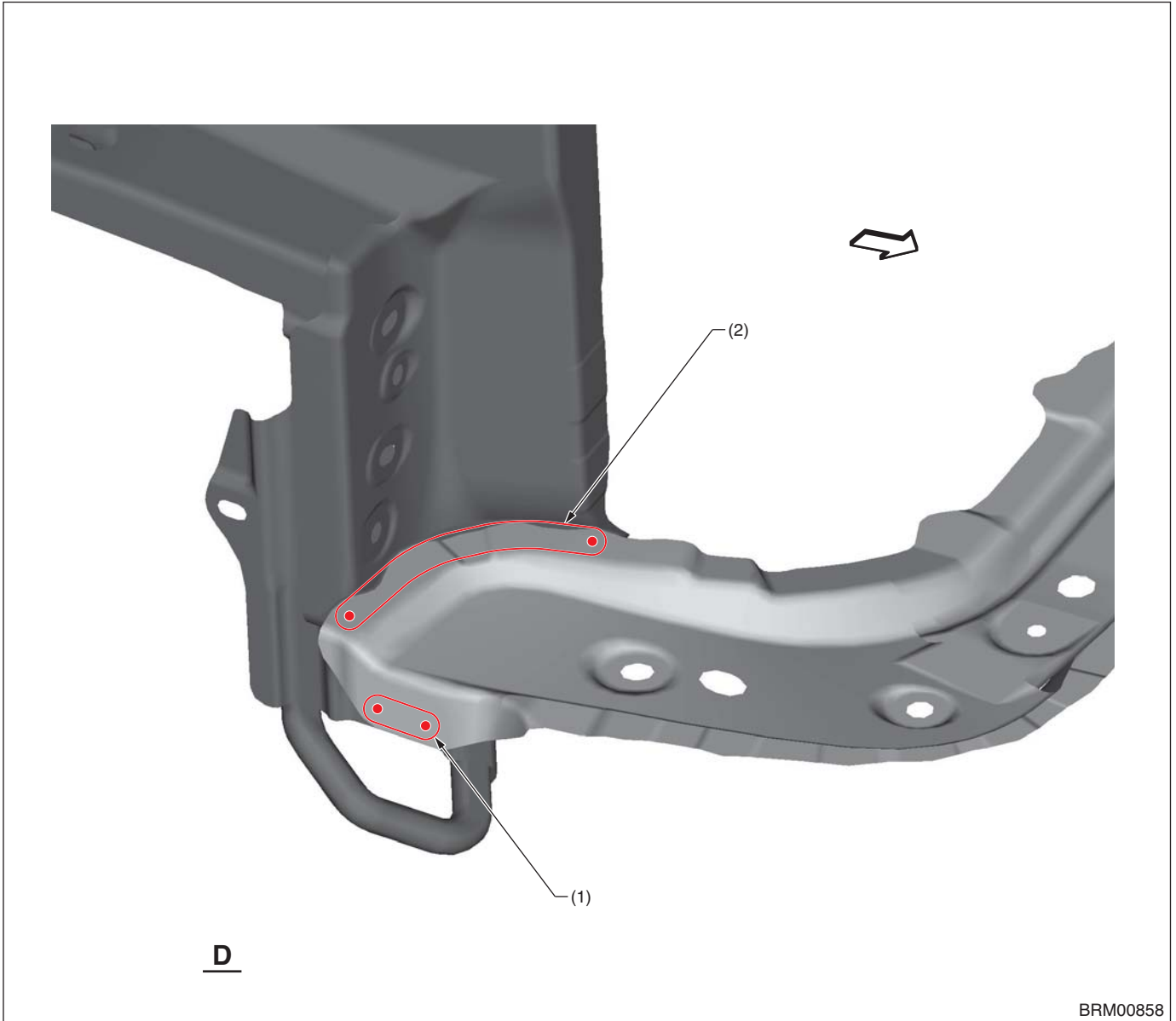
(1) 1 point (top · 1)
(2) 1 point (top · 2)

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

(5) 6 points (top · 1)

Panel Replacement

• View D



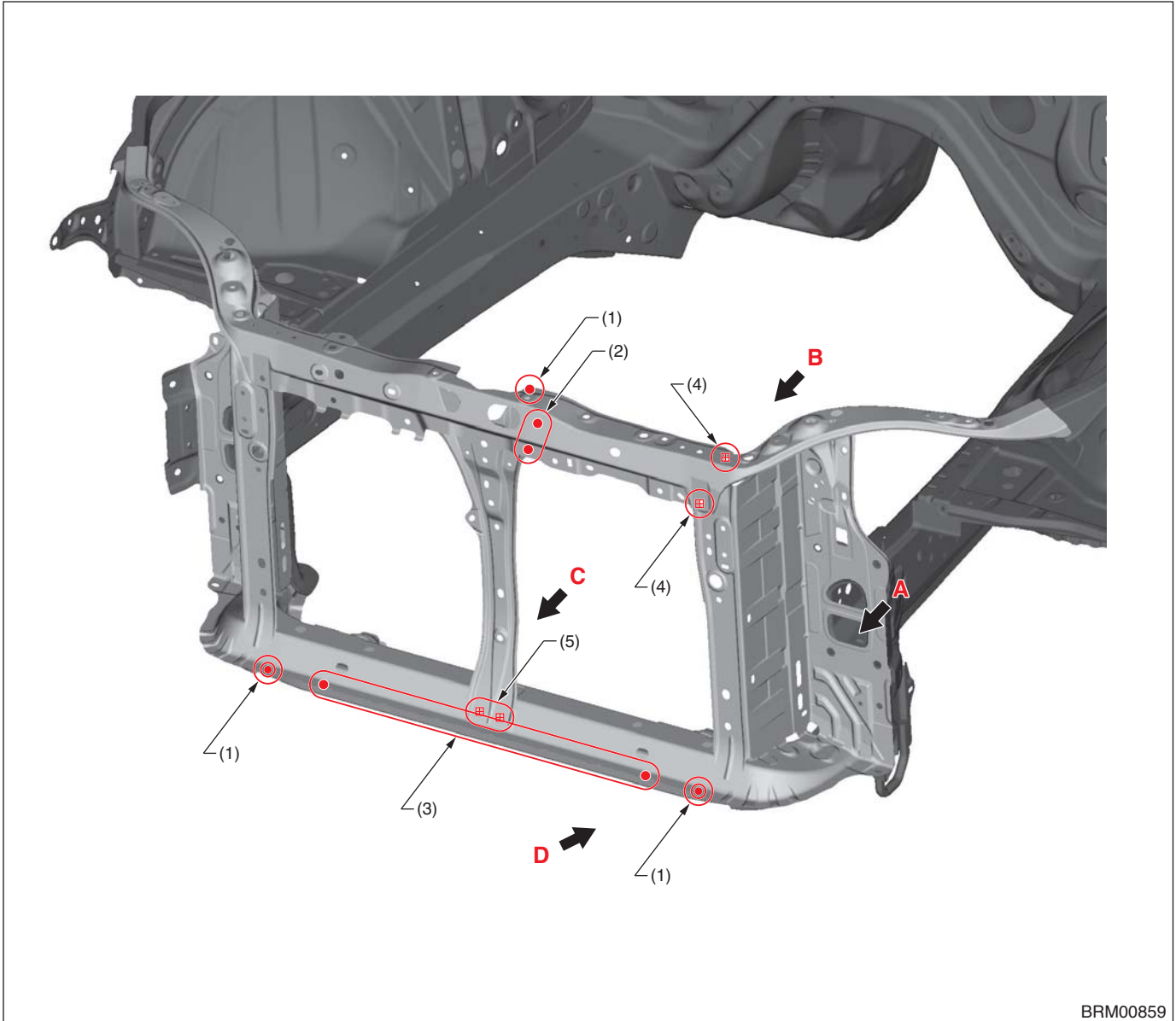
(1) 2 points (inside · 1)

(2) 4 points (bottom · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BRM00859

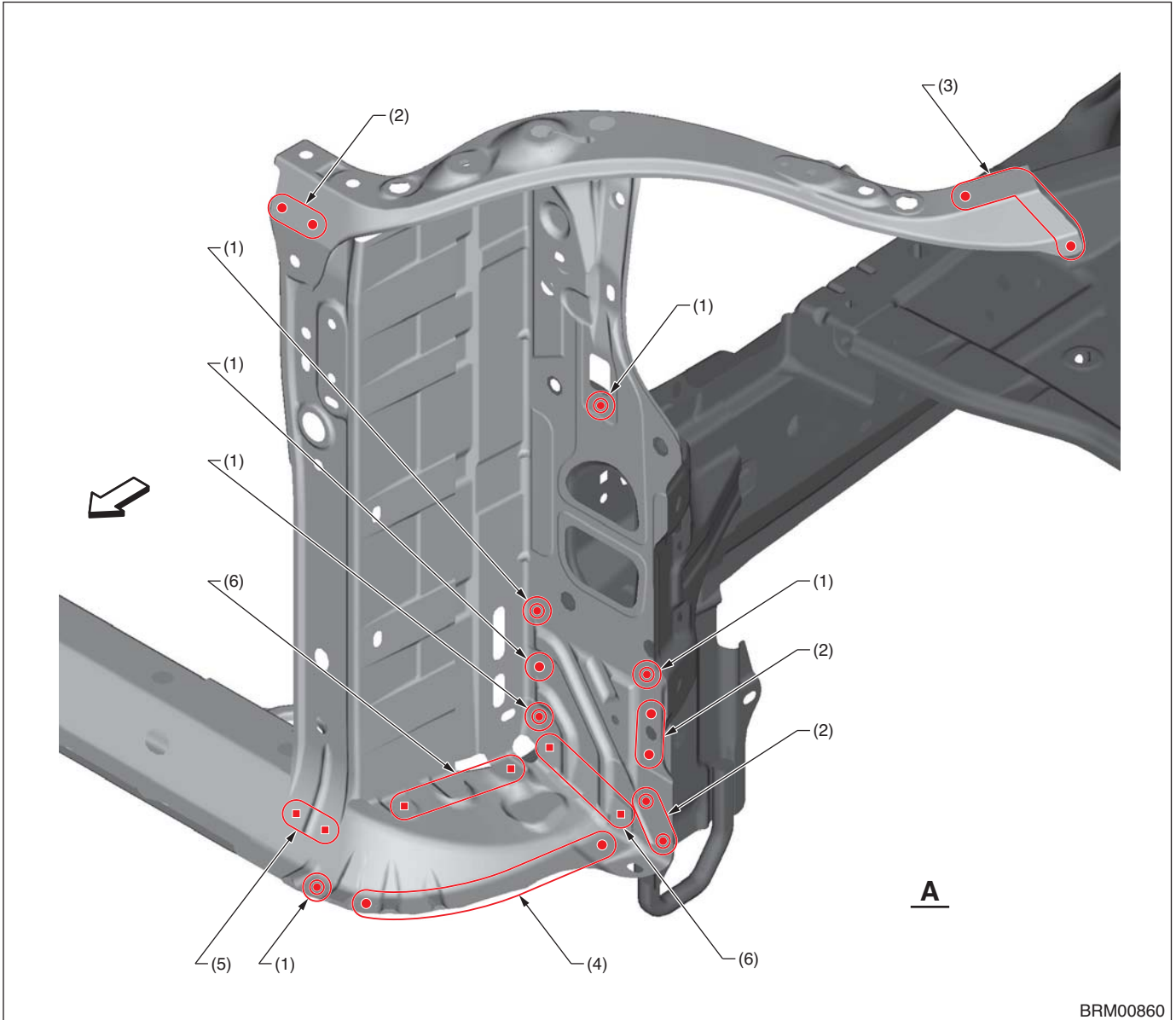
(1) 1 point
(2) 2 points

(3) 7 points
(4) 1 point (bolt)

(5) 2 points (bolt)

Panel Replacement

• View A



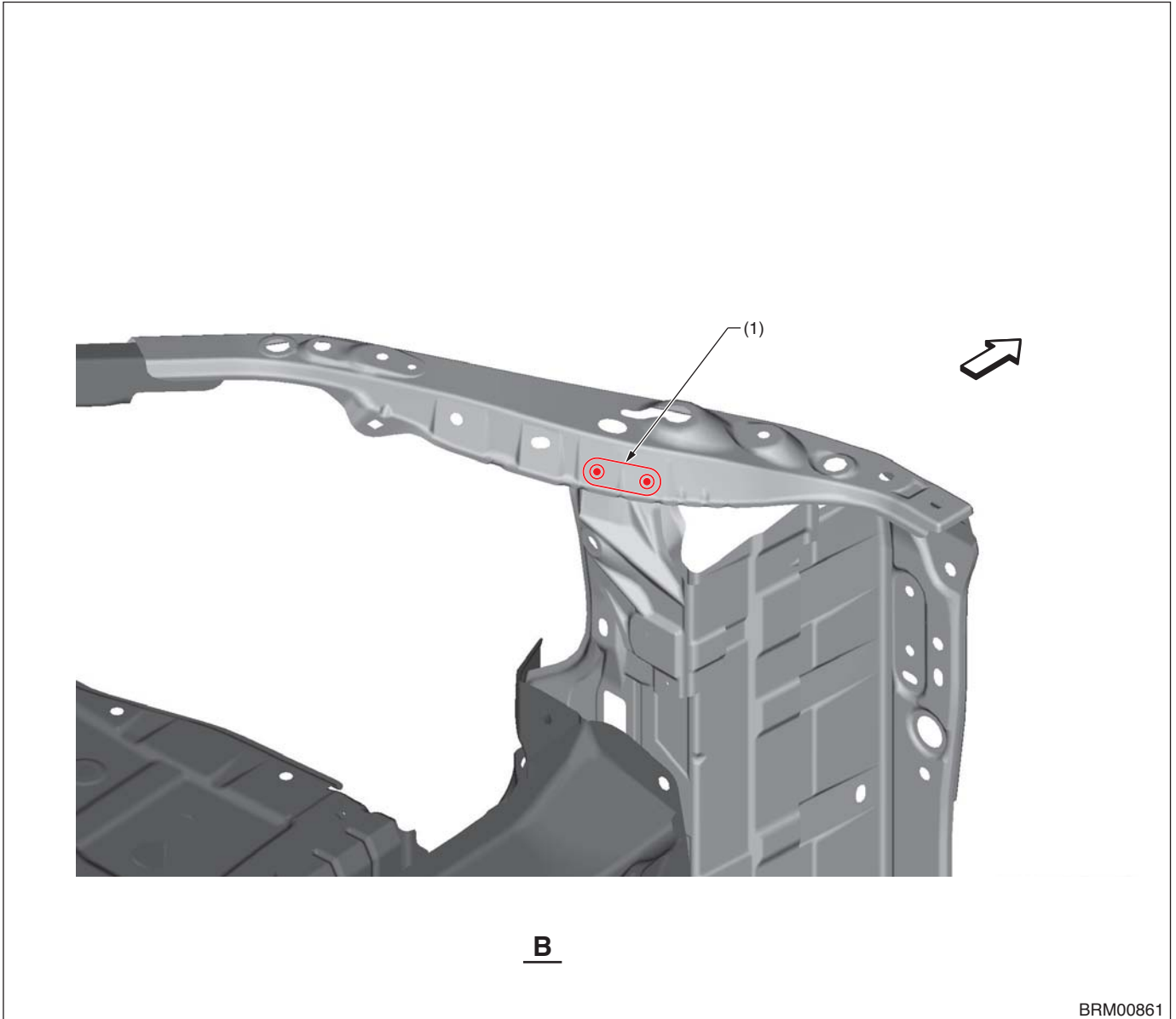
(1) 1 point
(2) 2 points

(3) 3 points
(4) 6 points

(5) 2 points (service · matching)
(6) 3 points (service)

Panel Replacement

- View B

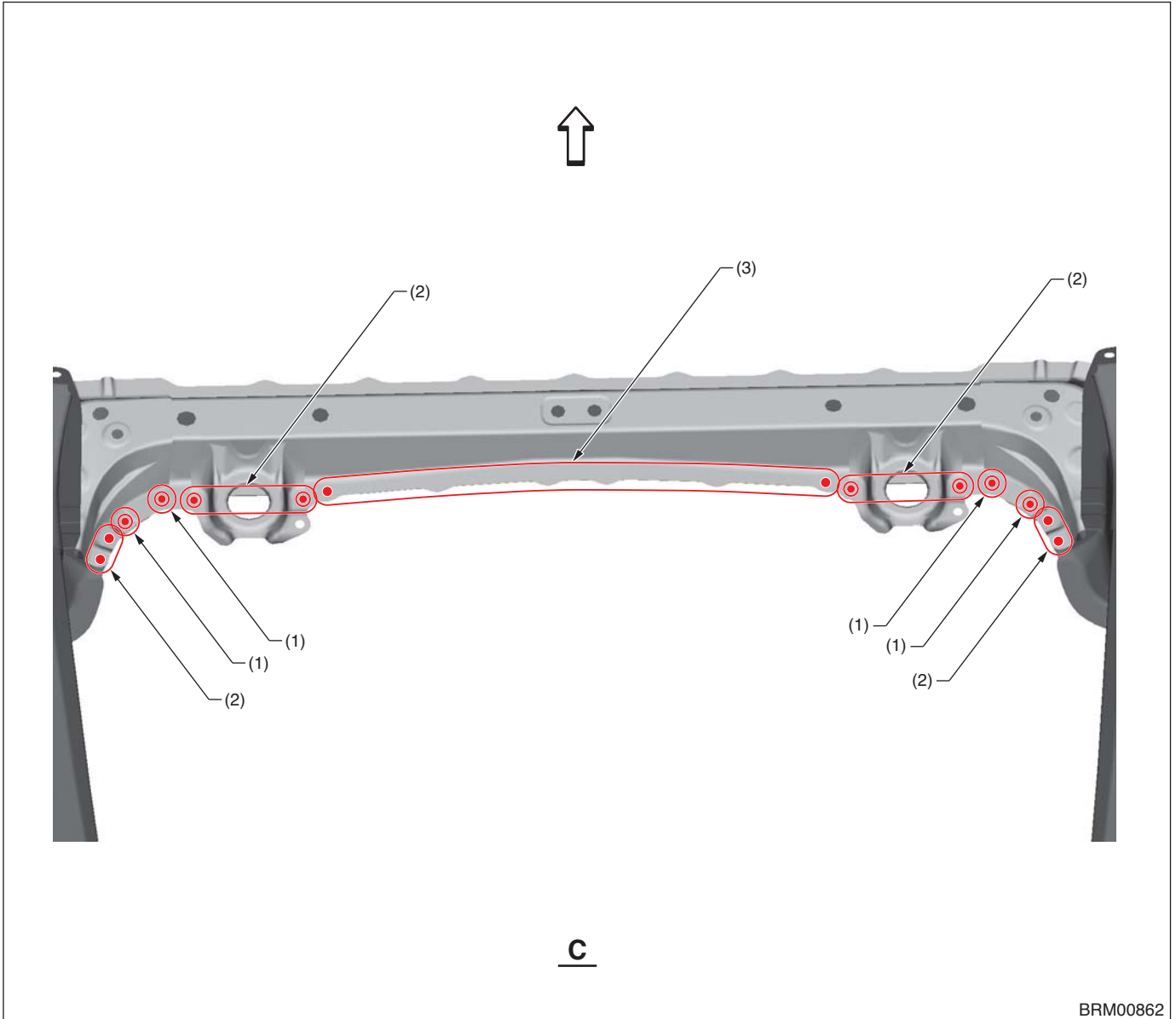


BRM00861

(1) 2 points

Panel Replacement

• View C



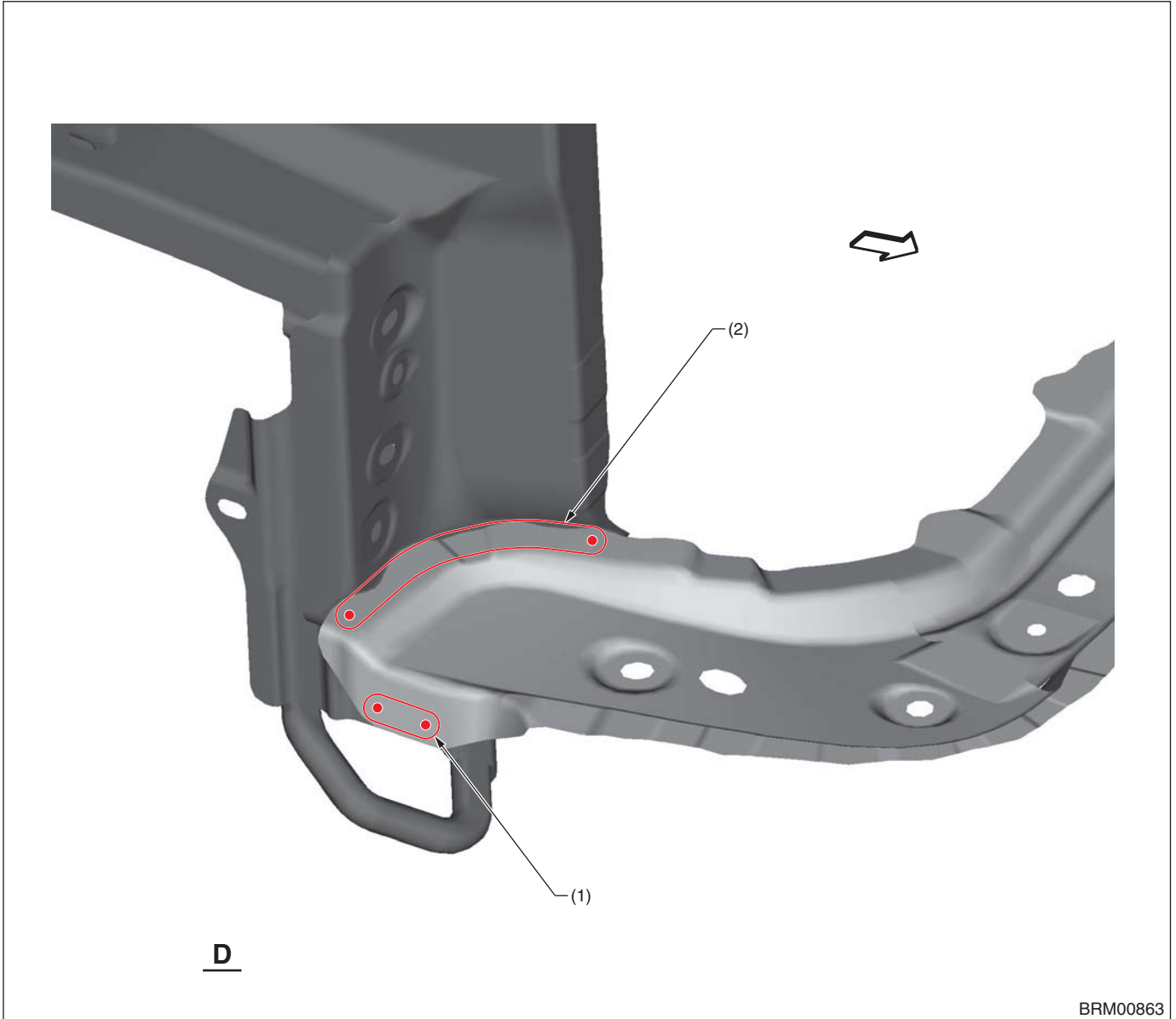
(1) 1 point

(2) 2 points

(3) 6 points

Panel Replacement

- View D



(1) 2 points

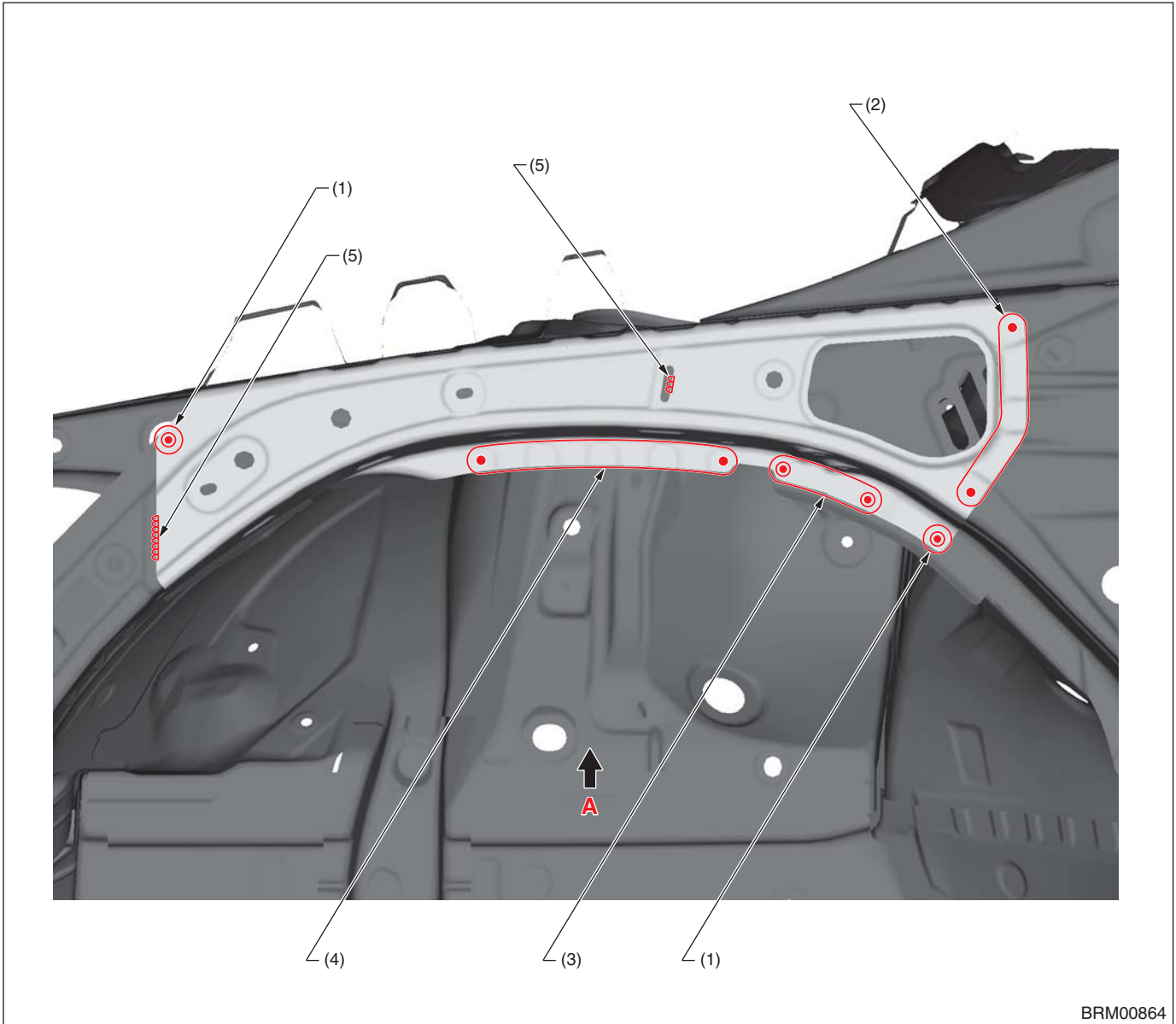
(2) 4 points

Panel Replacement

8-2. Side Upper Frame (Total replacement)

A: REMOVAL

• Overall view



BRM00864

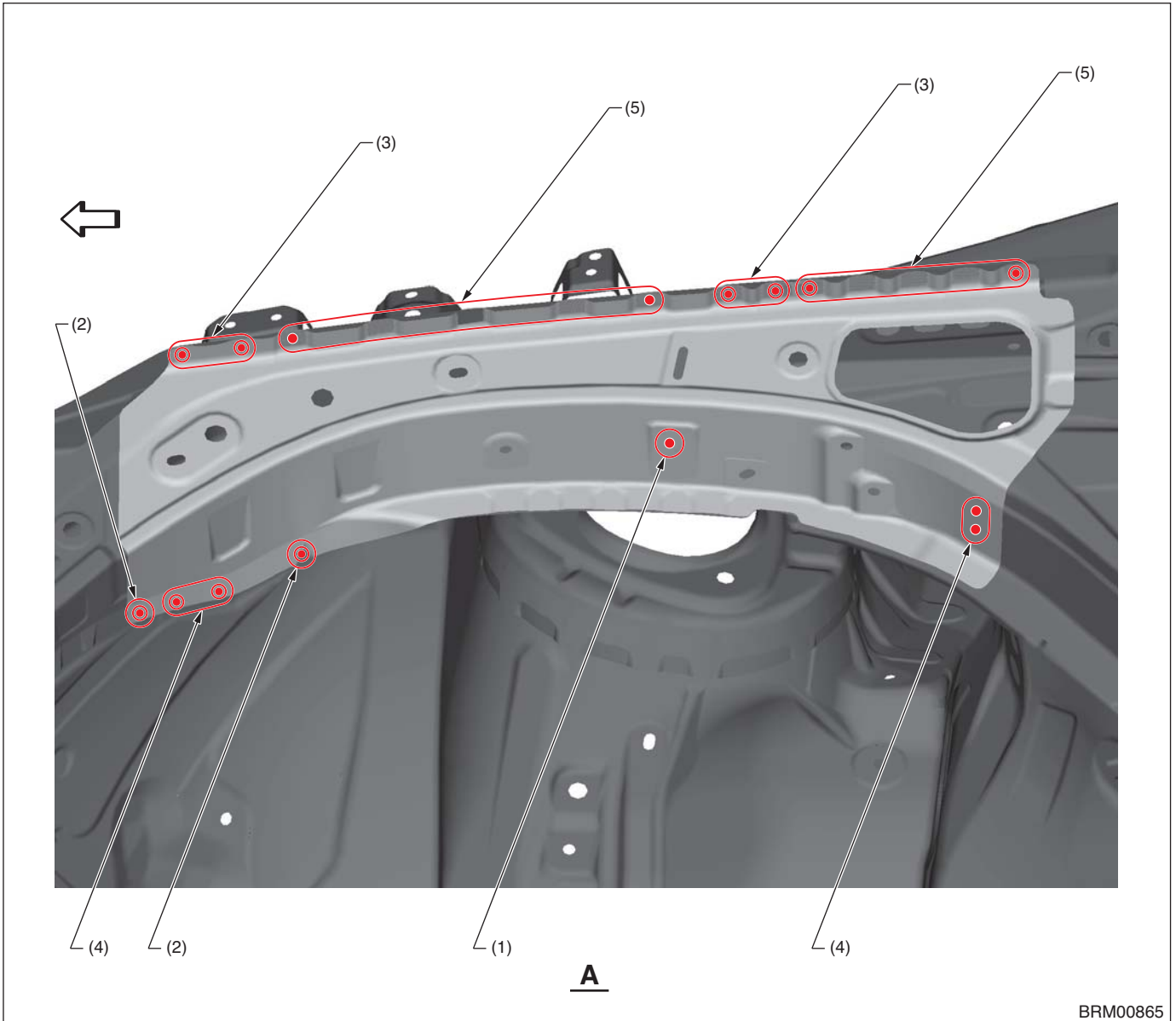
(1) 1 point (outside · 1)
(2) 3 points (outside · 1)

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

(5) 1 point (outside · 1 belt sander)

Panel Replacement

• View A



BRM00865

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

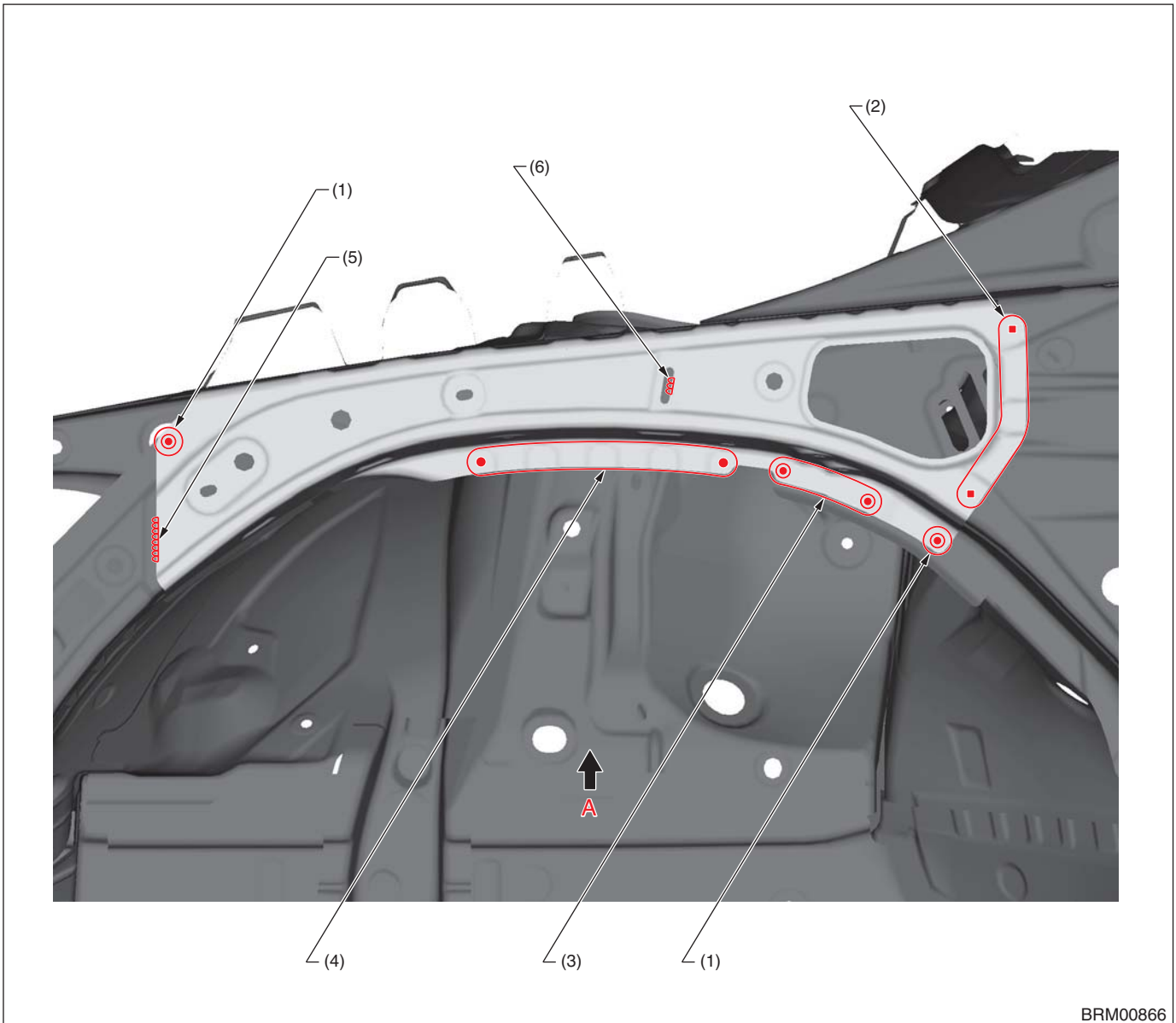
(3) 2 points (bottom · 1)
(4) 2 points (inside · 1)

(5) 5 points (bottom · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BRM00866

(1) 1 point

(3) 4 points

(5) 1 point (Continuous welding)
(30 mm [1.18 in])

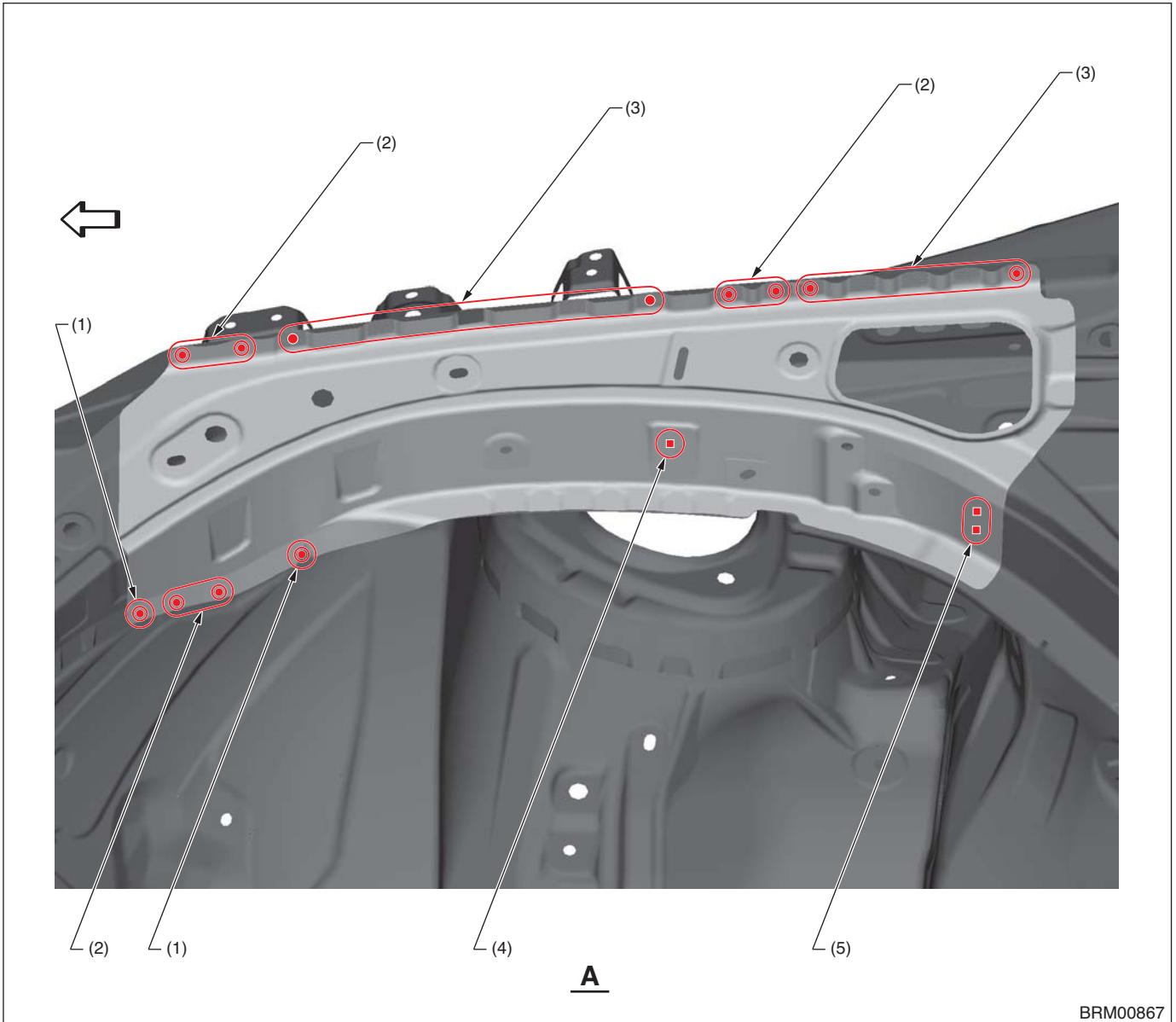
(2) 3 points (service)

(4) 5 points

(6) 1 point (Continuous welding)
(10 mm [0.39 in])

Panel Replacement

• View A



(1) 1 point
(2) 2 points

(3) 5 points
(4) 1 point (service)

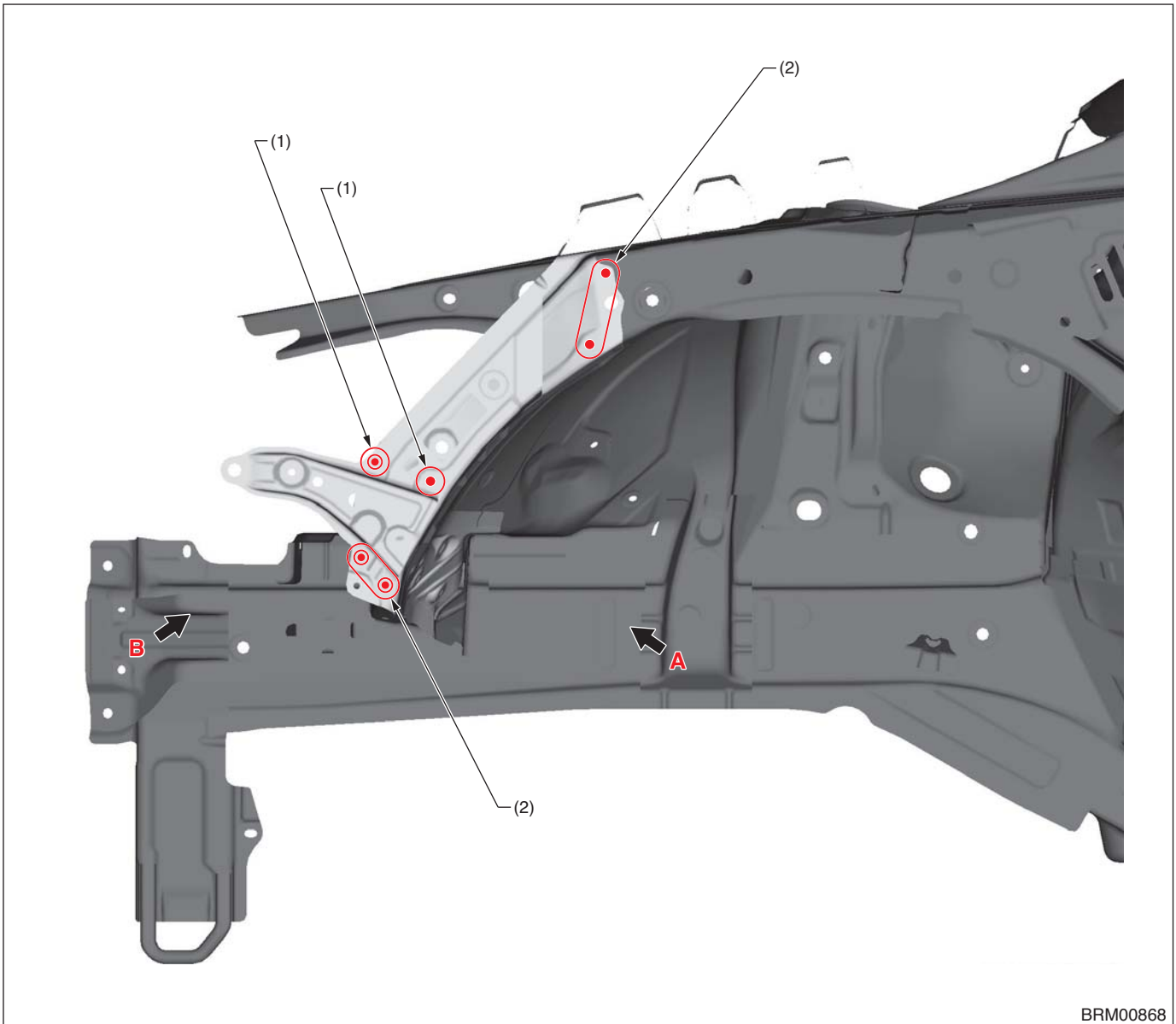
(5) 2 points (service)

Panel Replacement

8-3. Front Wheel Apron (Total replacement)

A: REMOVAL

• Overall view 1



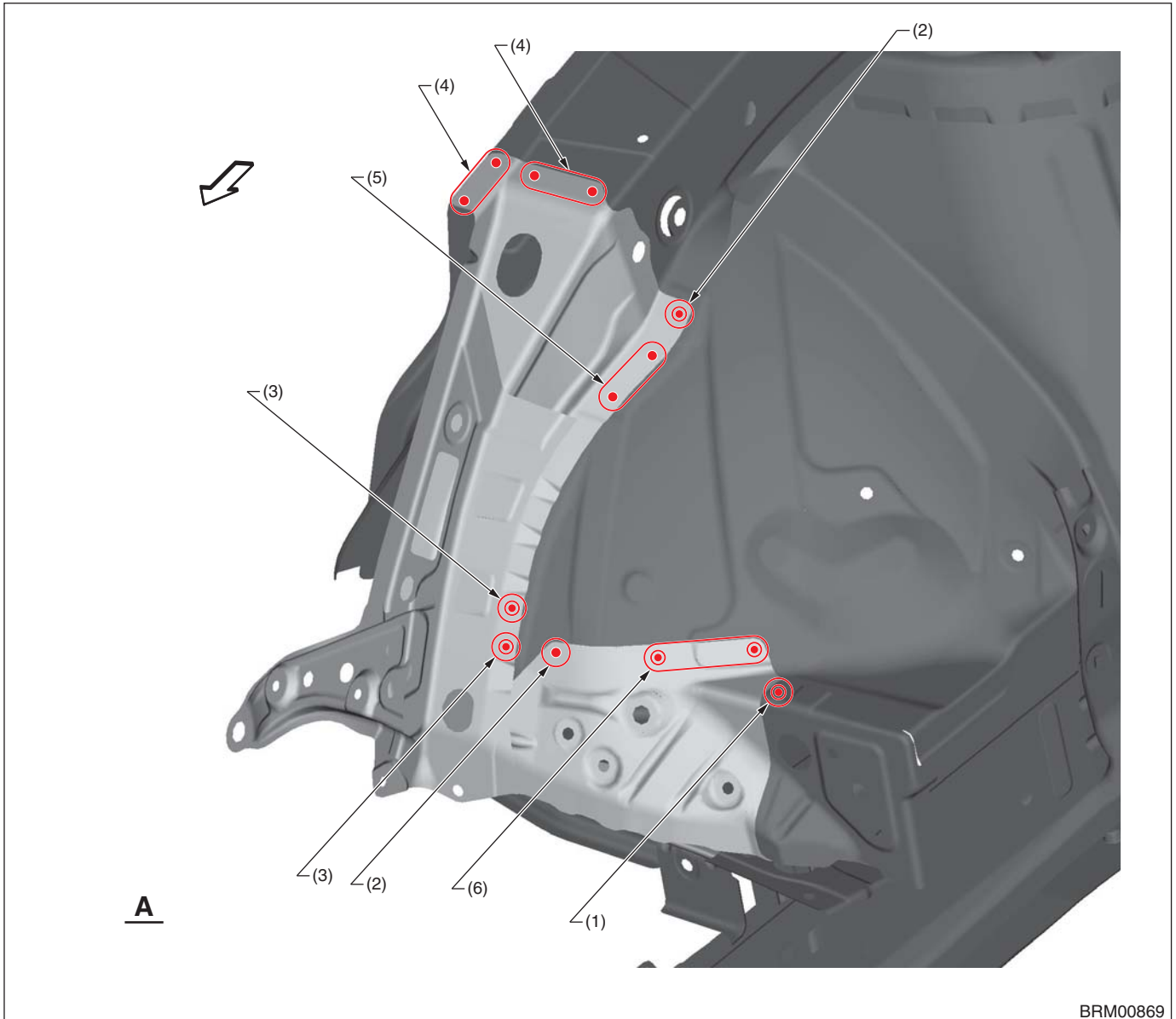
BRM00868

(1) 1 point (outside - 1)

(2) 2 points (outside - 1)

Panel Replacement

• View A (LH)



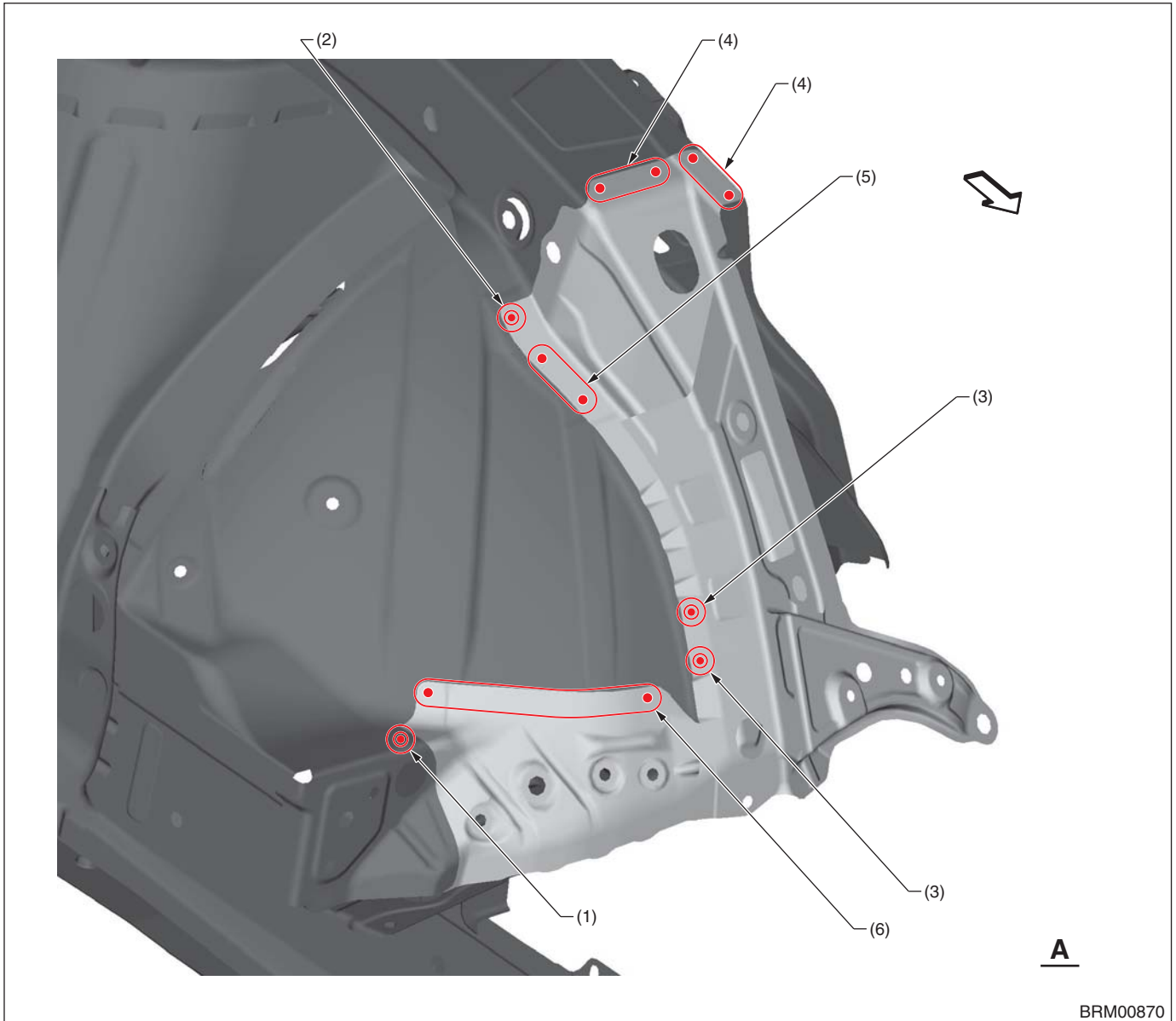
(1) 1 point (bottom · 2)
(2) 1 point (inside · 1)

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

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

Panel Replacement

• View A (RH)



BRM00870

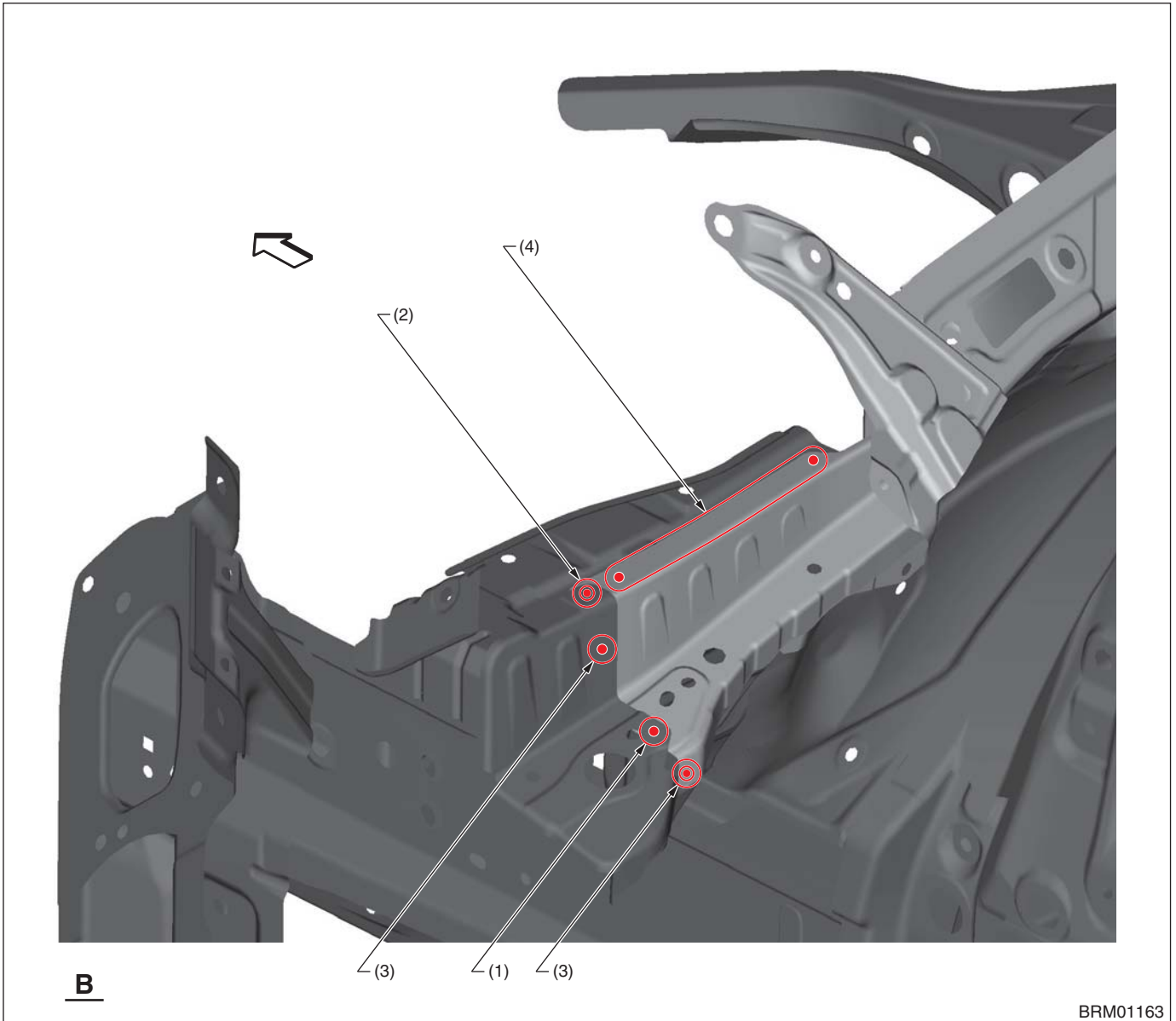
(1) 1 point (bottom · 2)
(2) 1 point (inside · 1)

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

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

Panel Replacement

• View B



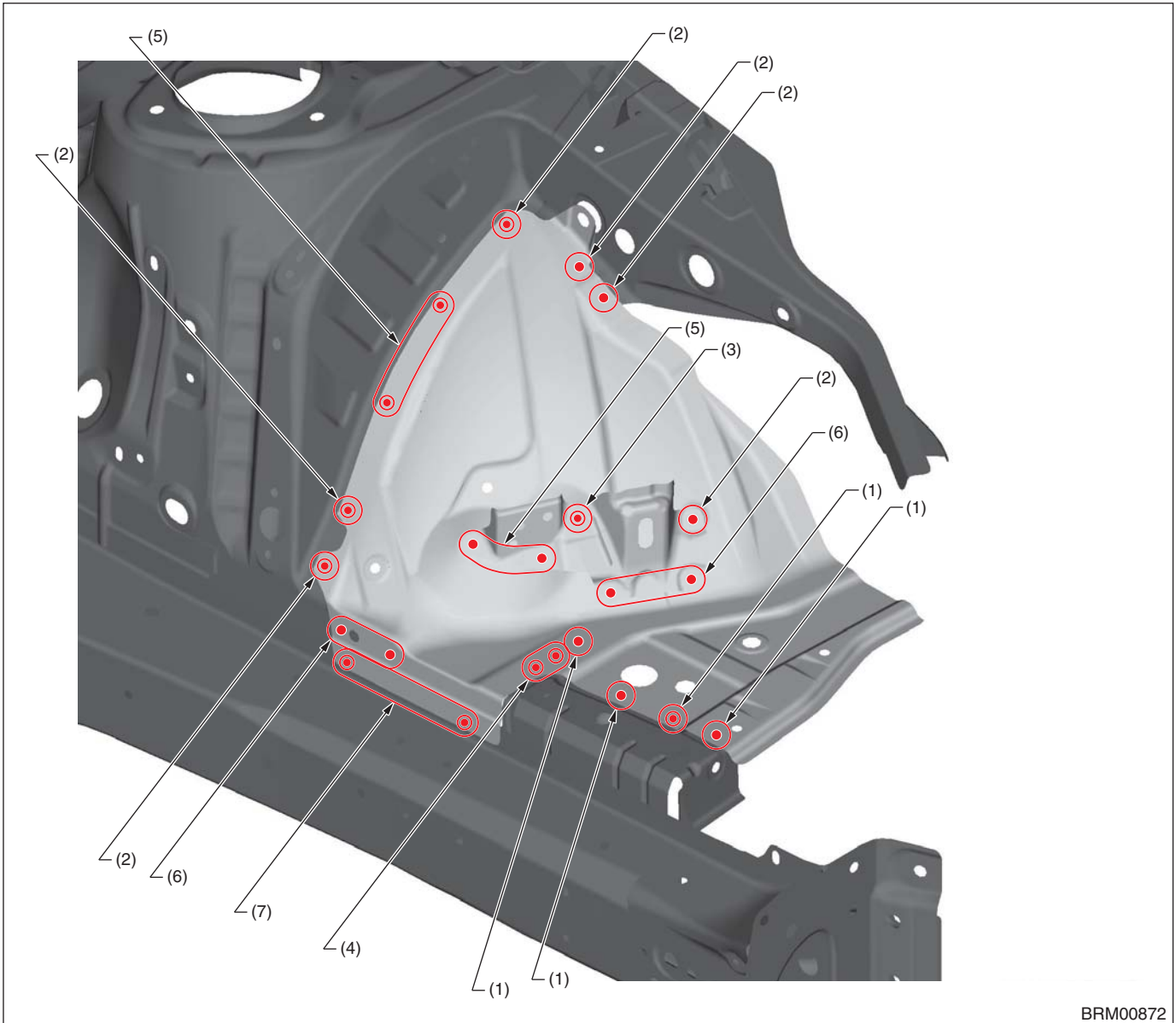
- (1) 1 point (bottom · 1)
- (2) 1 point (bottom · 2)

- (3) 1 point (outside · 1)

- (4) 4 points (bottom · 1)

Panel Replacement

• Overall view 2 (LH)



BRM00872

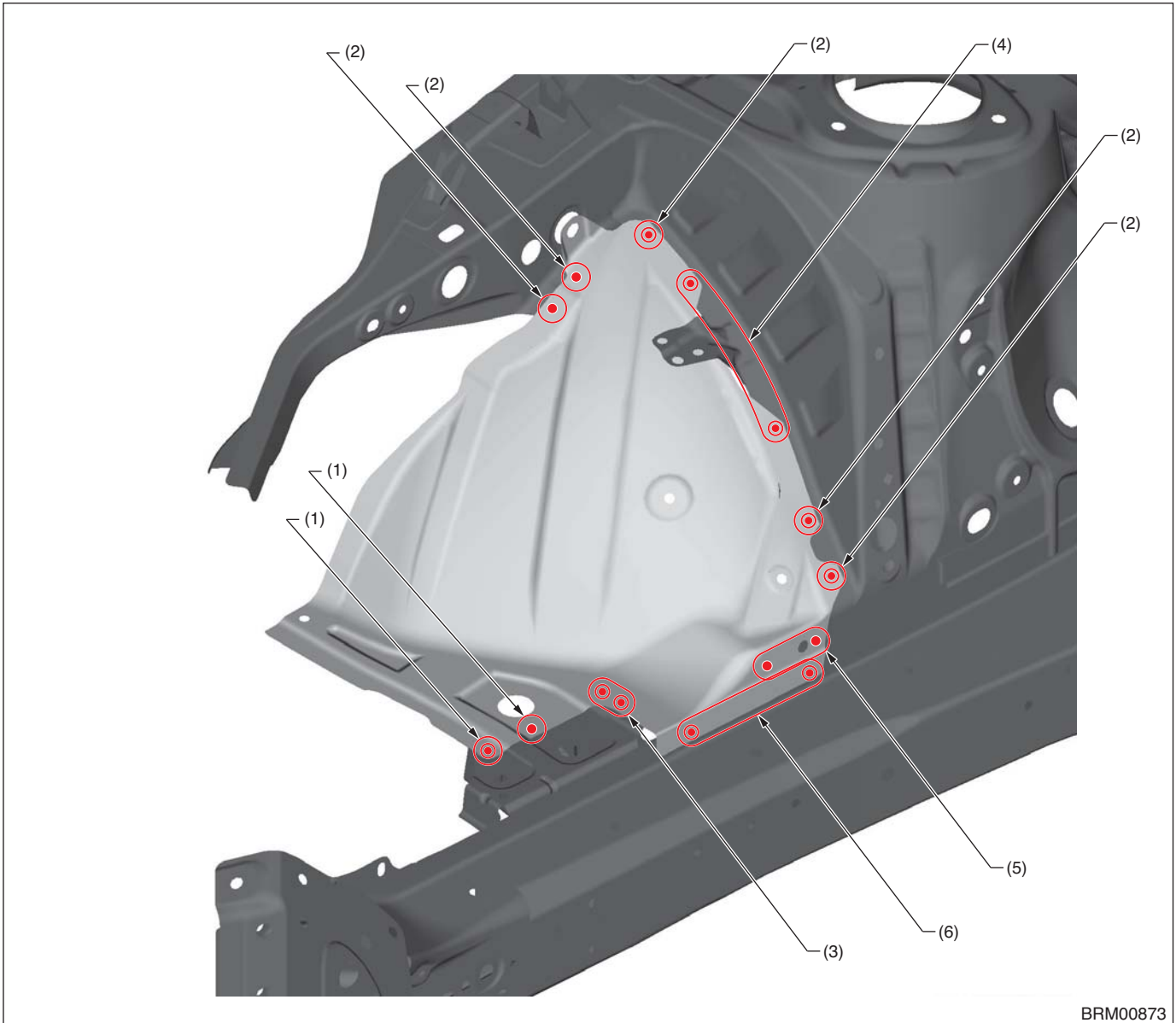
- (1) 1 point (top · 1)
- (2) 1 point (inside · 1)
- (3) 1 point (inside · 2)

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

- (7) 4 points (inside · 1)

Panel Replacement

• Overall view 2 (RH)



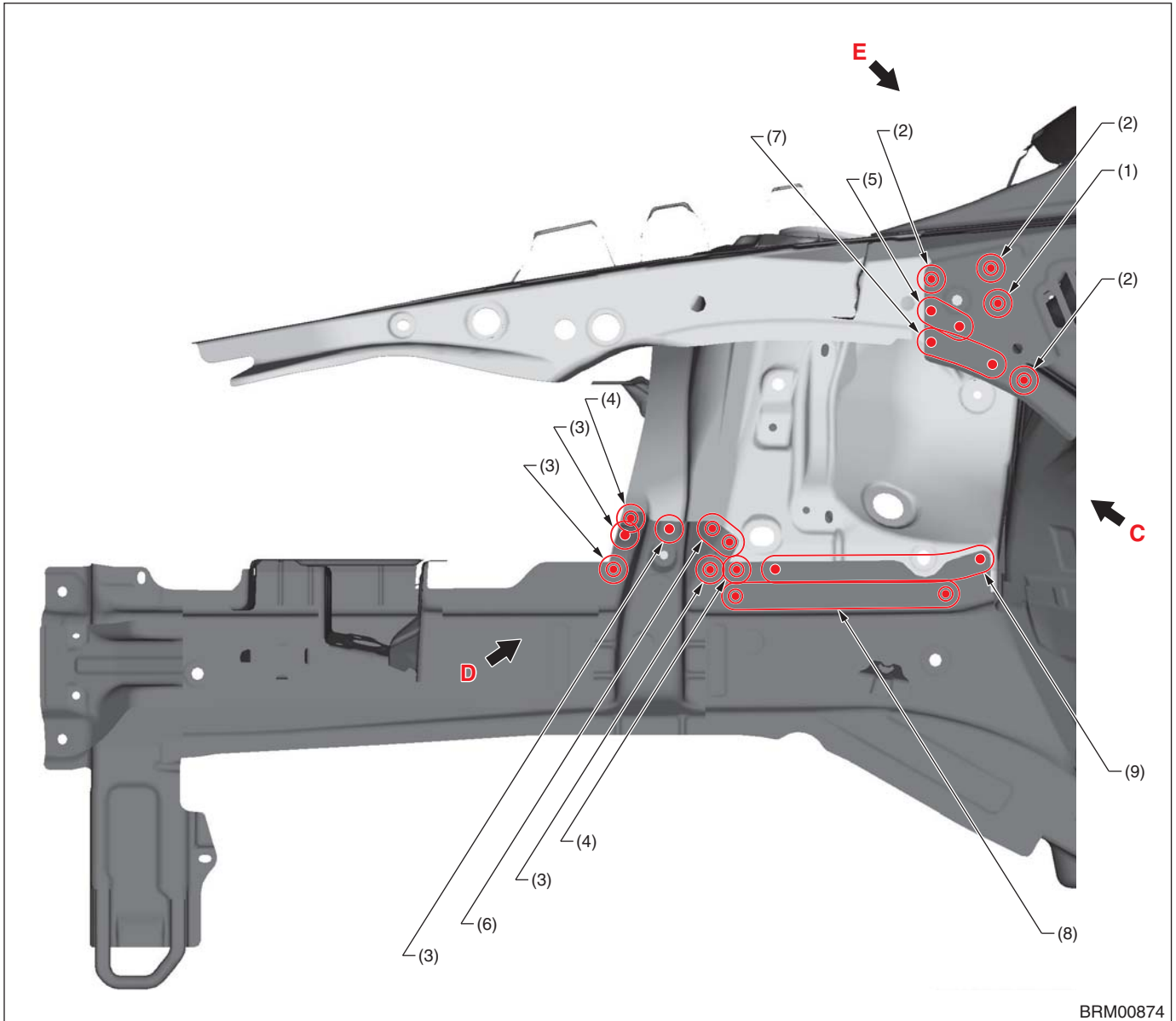
(1) 1 point (top · 1)
(2) 1 point (inside · 1)

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

(5) 3 points (inside · 1)
(6) 4 points (inside · 1)

Panel Replacement

• Overall view 3



BRM00874

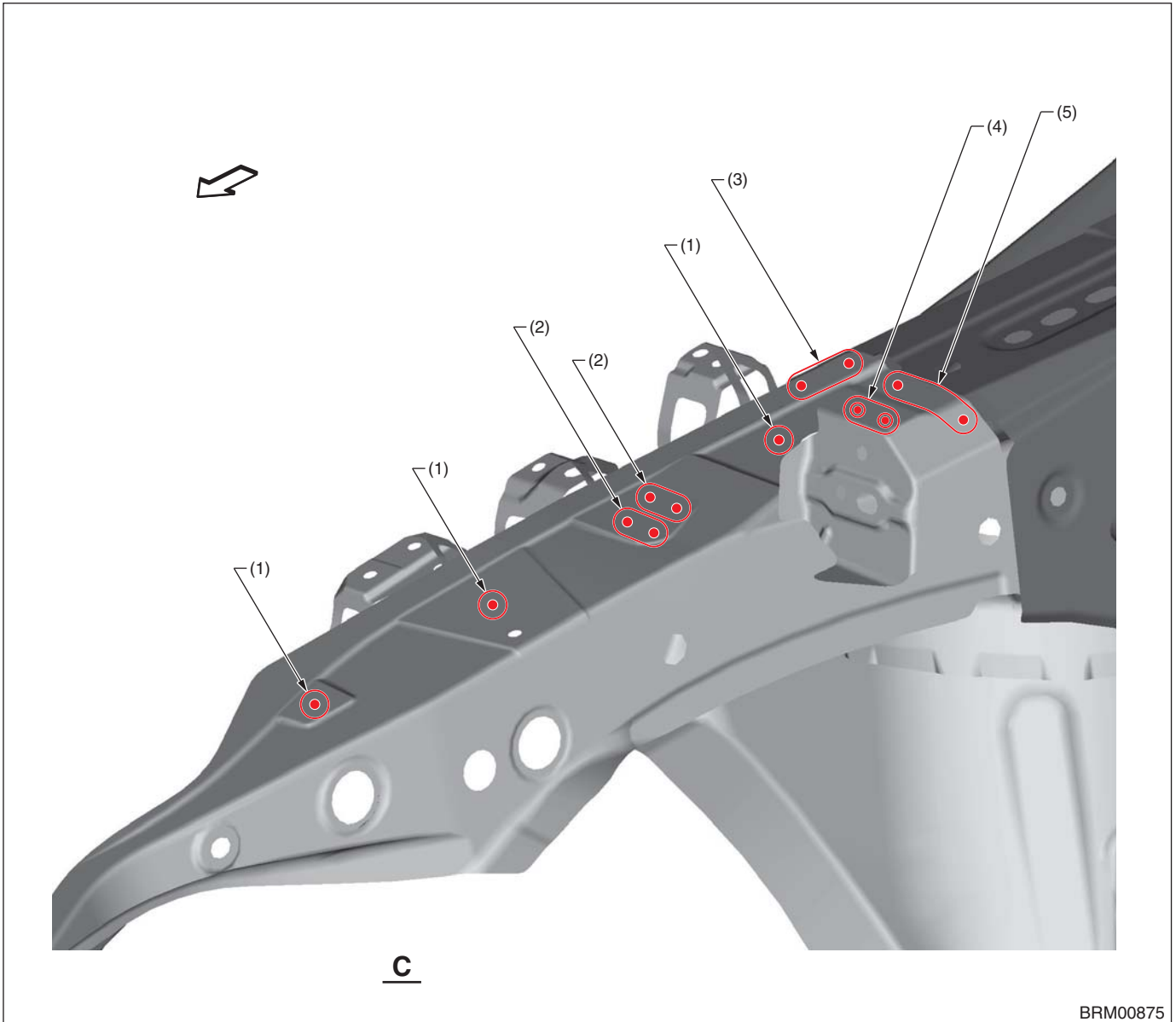
- (1) 1 point (outside · 1)
- (2) 1 point (outside · 2)
- (3) 1 point (inside · 1)

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

- (7) 4 points (outside · 1)
- (8) 4 points (inside · 1)
- (9) 6 points (inside · 1)

Panel Replacement

• View C



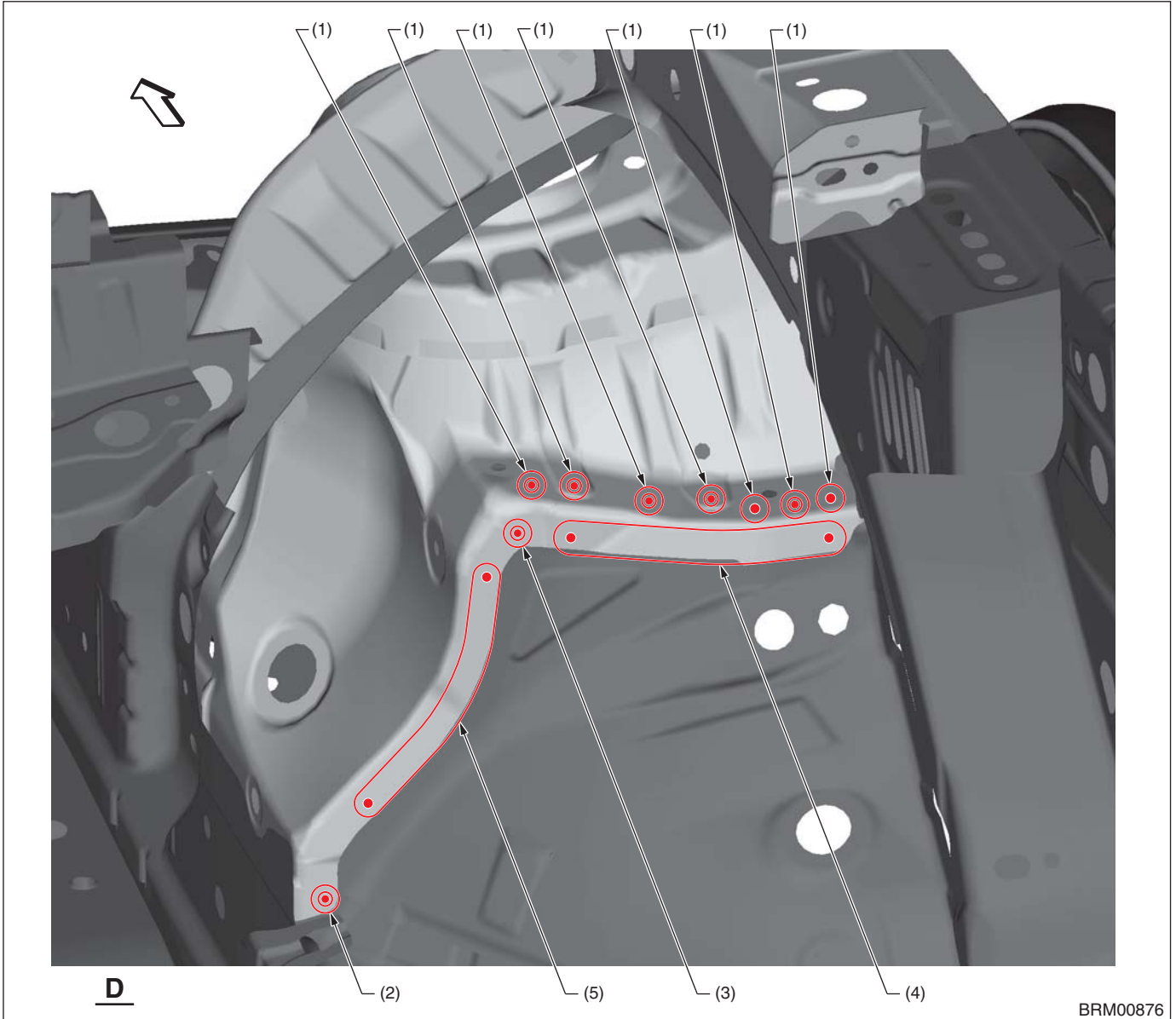
(1) 1 point (top · 1)
(2) 2 points (top · 1)

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

(5) 3 points (bottom · 1)

Panel Replacement

• View D



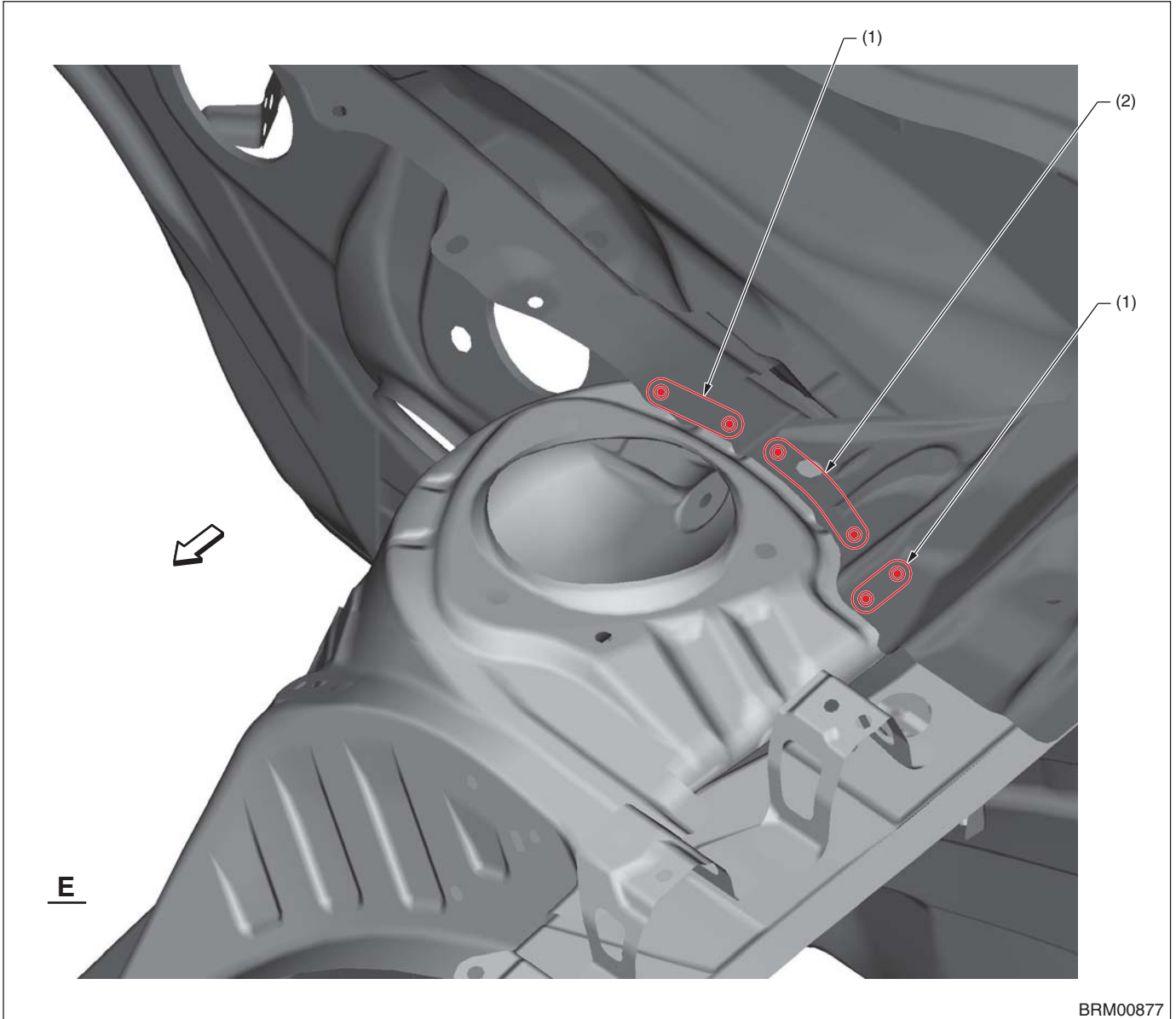
(1) 1 point (bottom · 1)
(2) 1 point (outside · 1)

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

(5) 5 points (outside · 1)

Panel Replacement

• View E



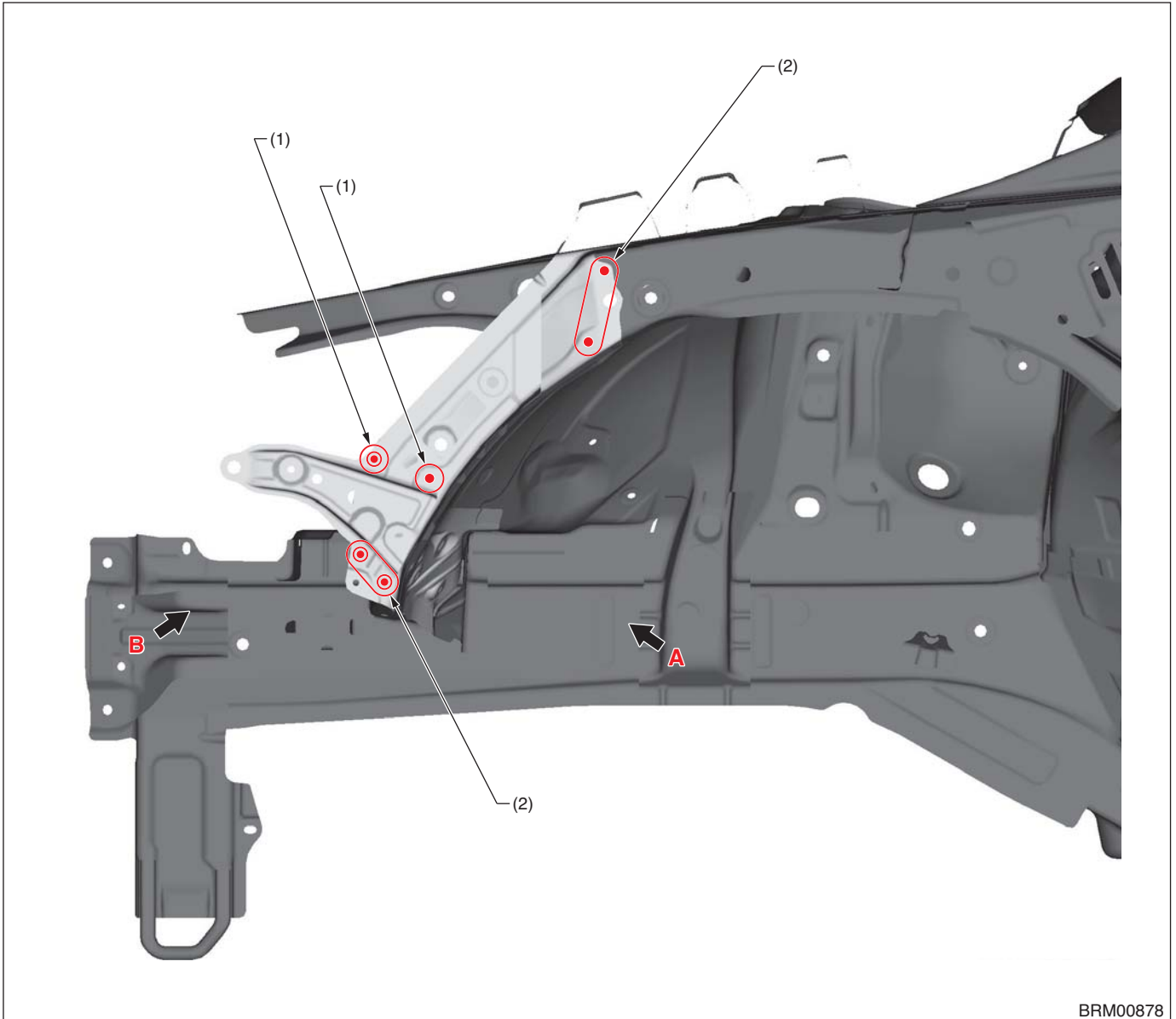
(1) 2 points (top · 2)

(2) 3 points (top · 2)

Panel Replacement

B: INSTALLATION

• Overall view 1



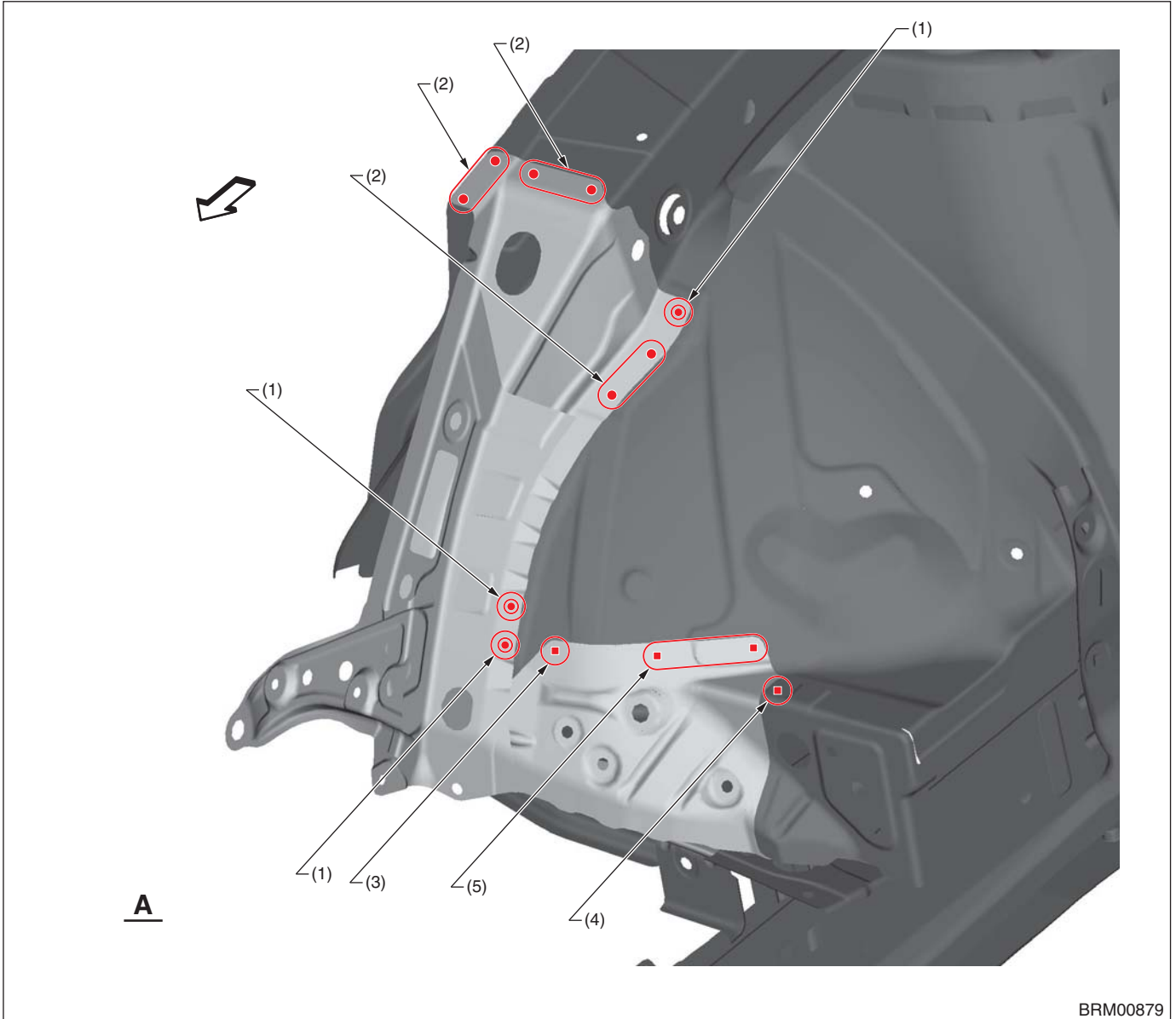
BRM00878

(1) 1 point

(2) 2 points

Panel Replacement

• View A (LH)



BRM00879

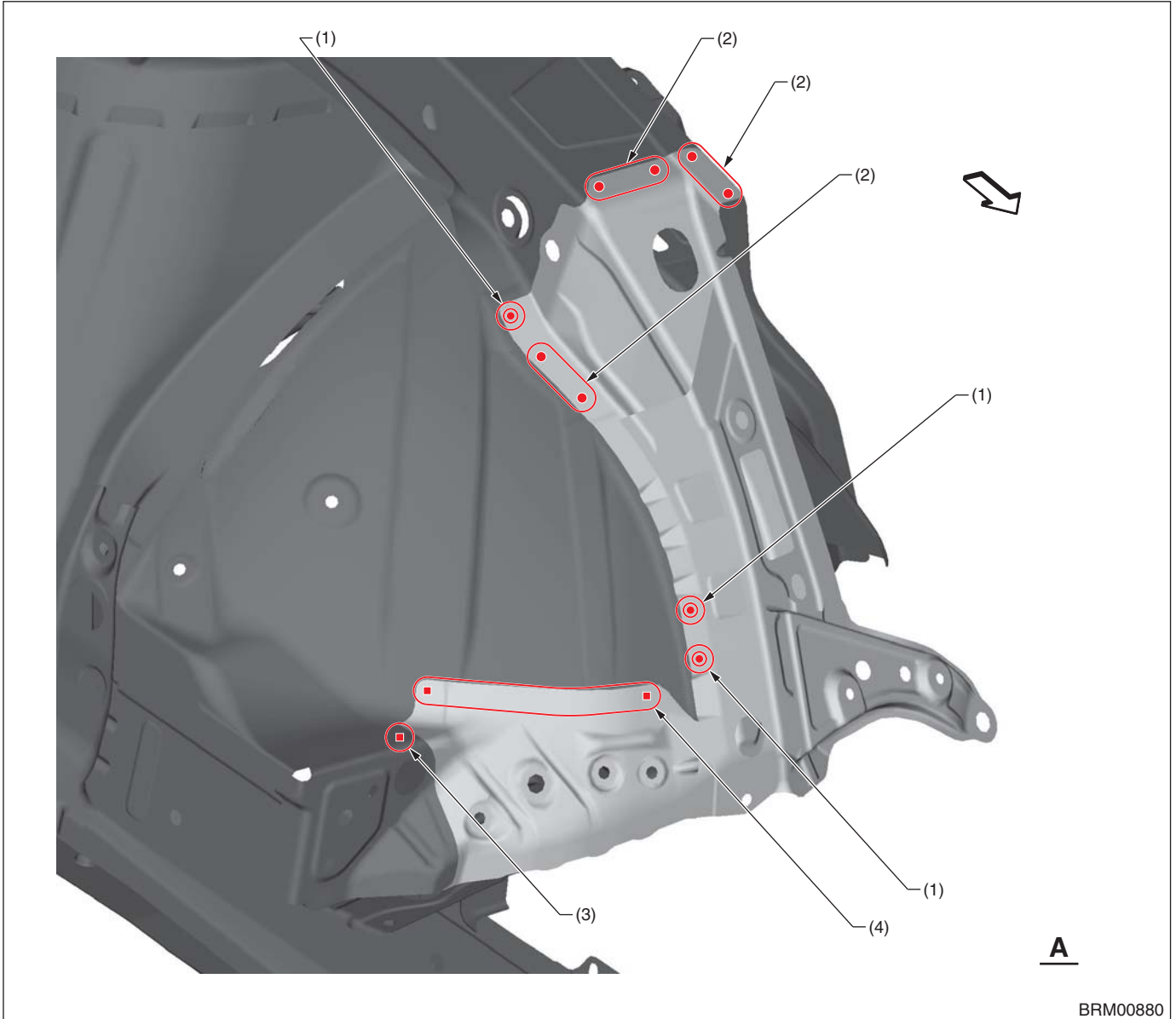
(1) 1 point
(2) 2 points

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

(5) 3 points (service)

Panel Replacement

• View A (RH)



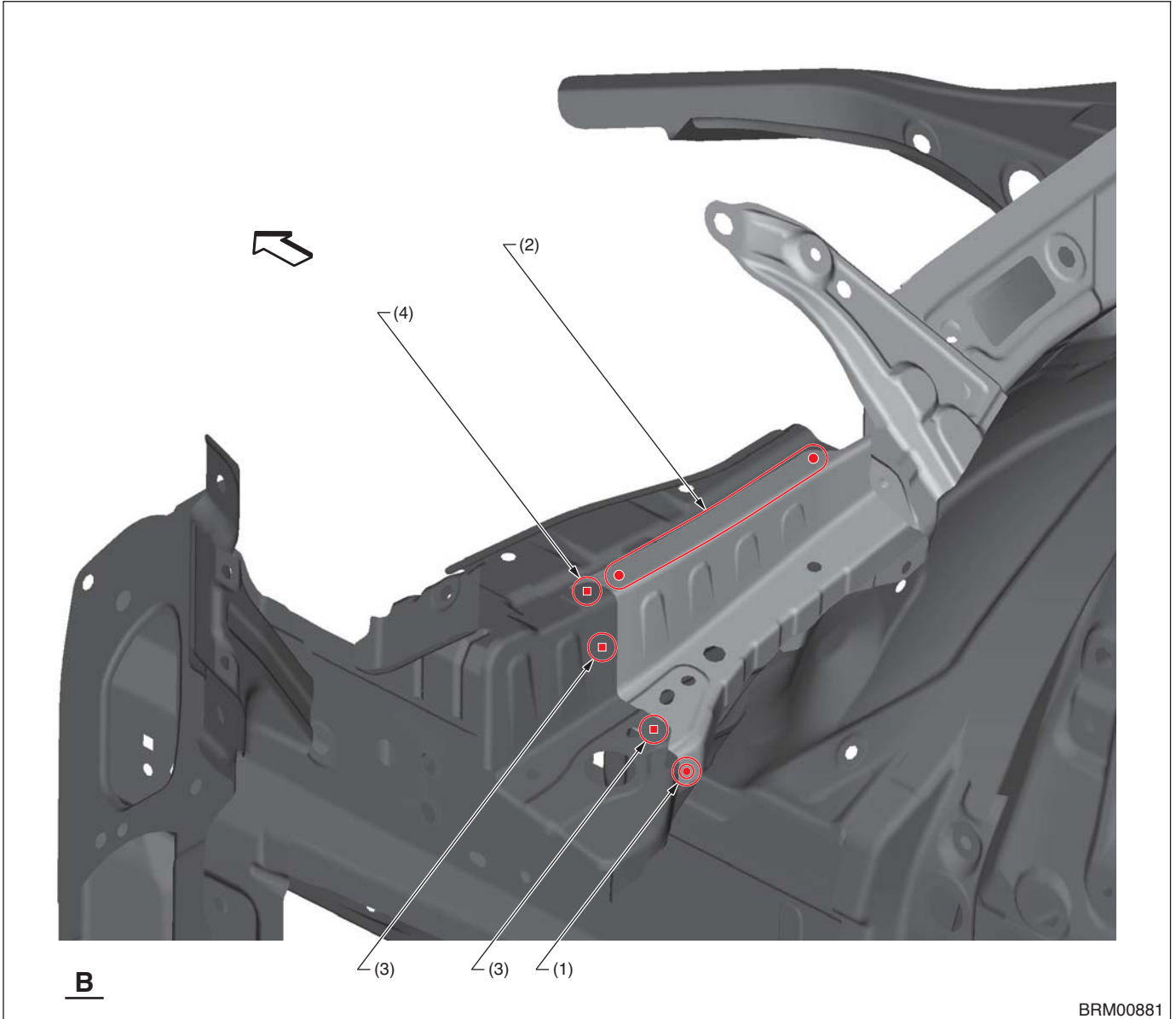
(1) 1 point
(2) 2 points

(3) 1 point (service · matching)

(4) 4 points (service)

Panel Replacement

• View B



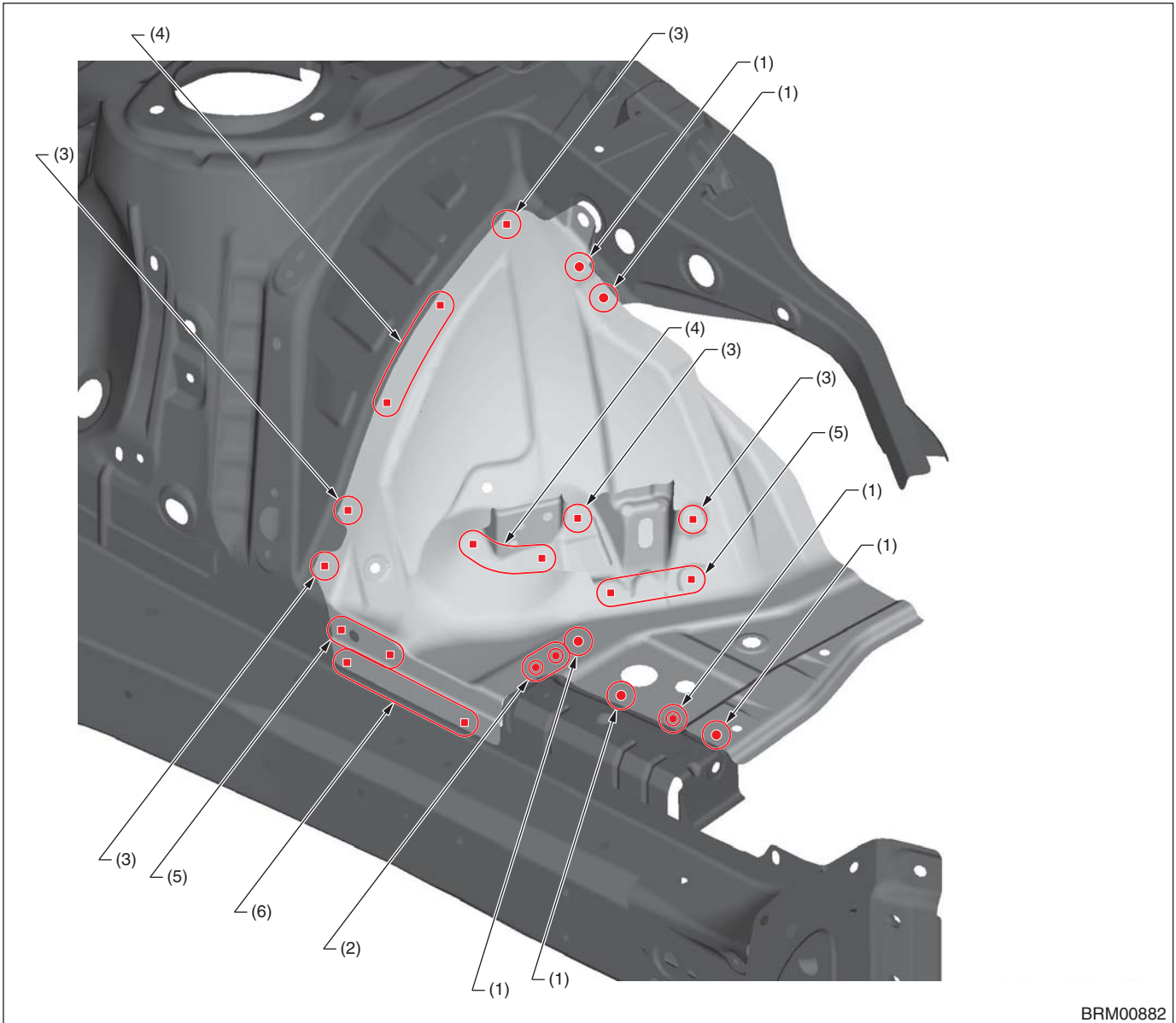
- (1) 1 point
- (2) 4 points

- (3) 1 point (service)

- (4) 1 point (service · matching)

Panel Replacement

• Overall view 2 (LH)



BRM00882

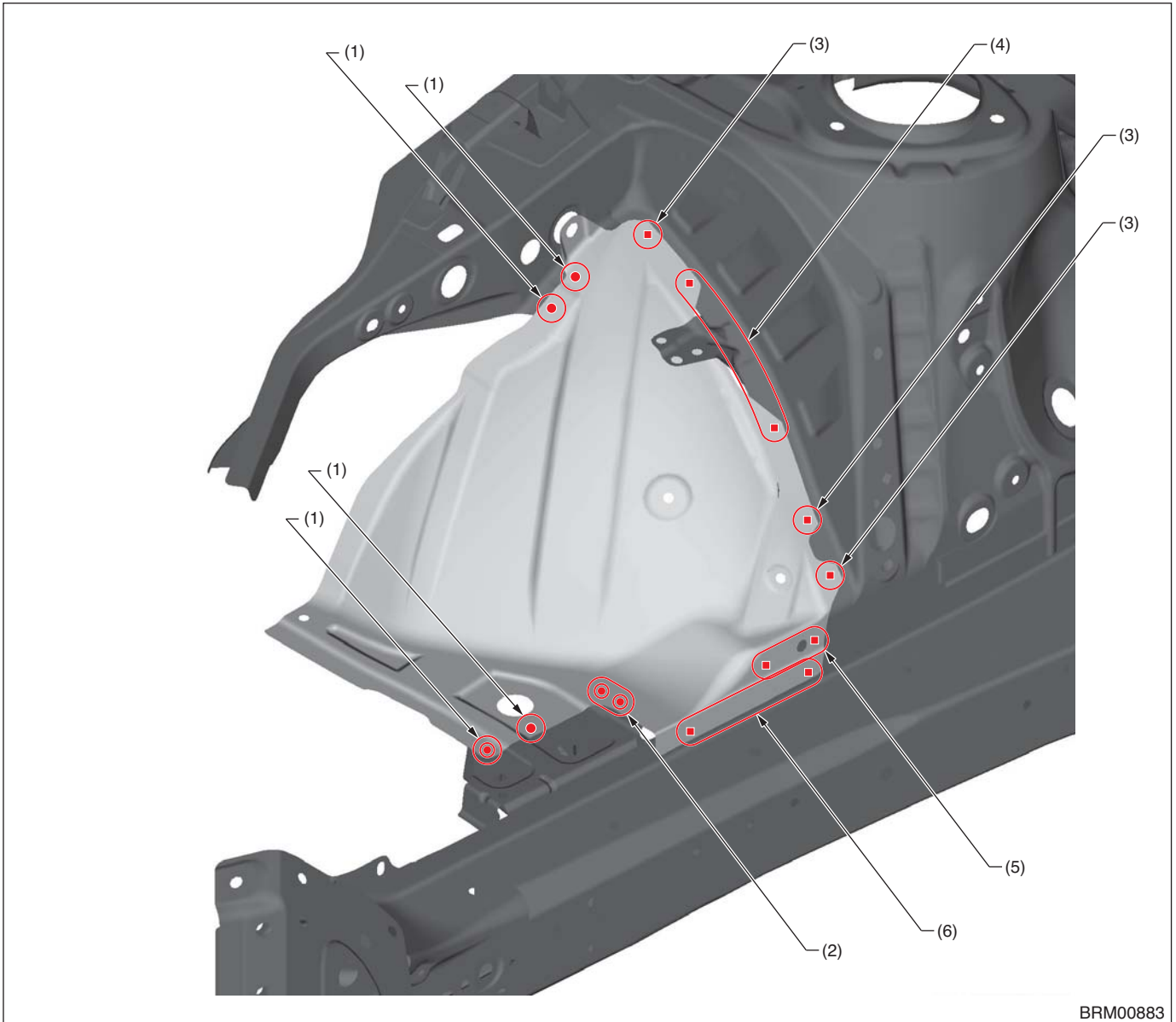
(1) 1 point
(2) 2 points

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

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

Panel Replacement

• Overall view 2 (RH)



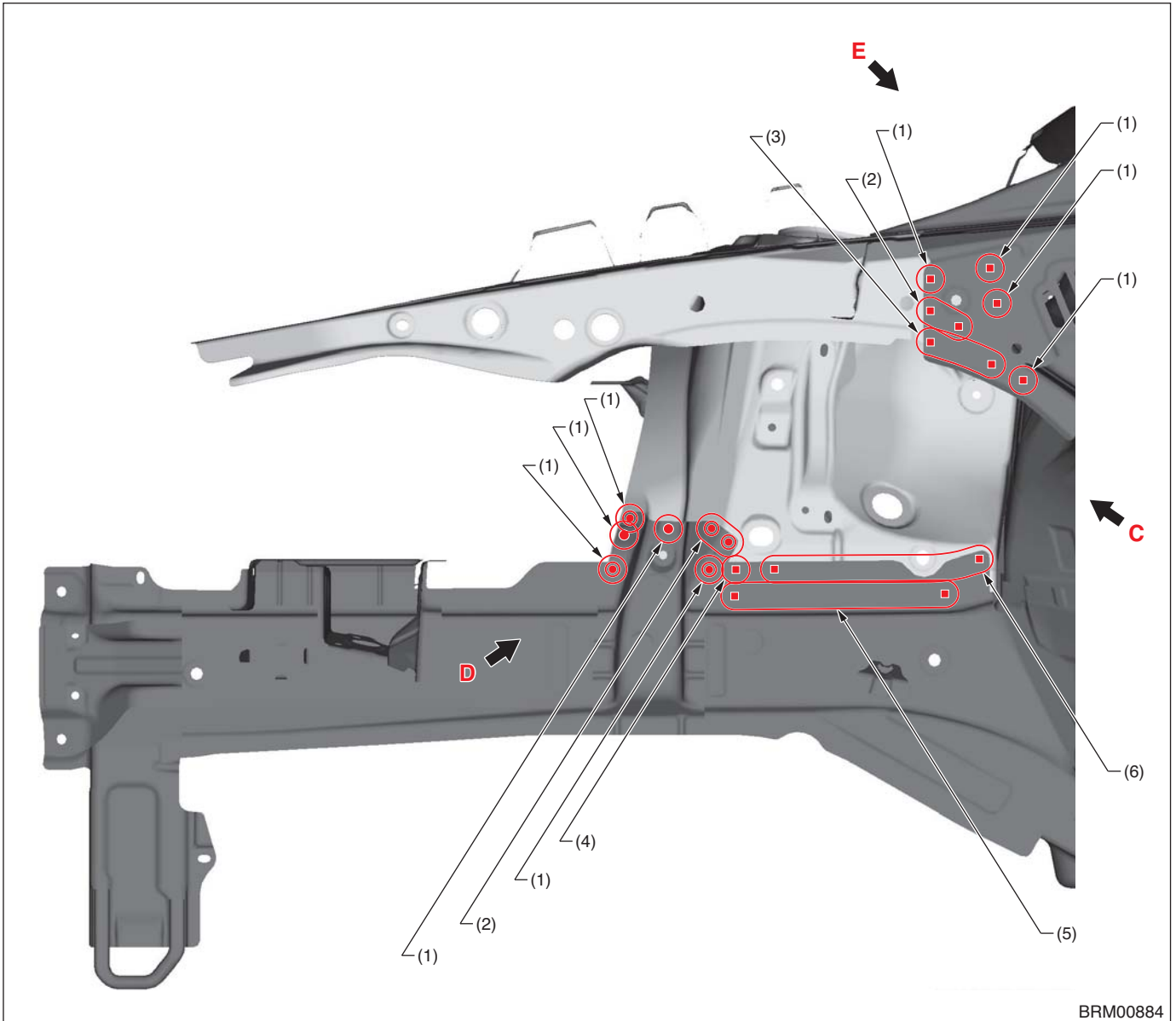
(1) 1 point
(2) 2 points

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

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

Panel Replacement

• Overall view 3



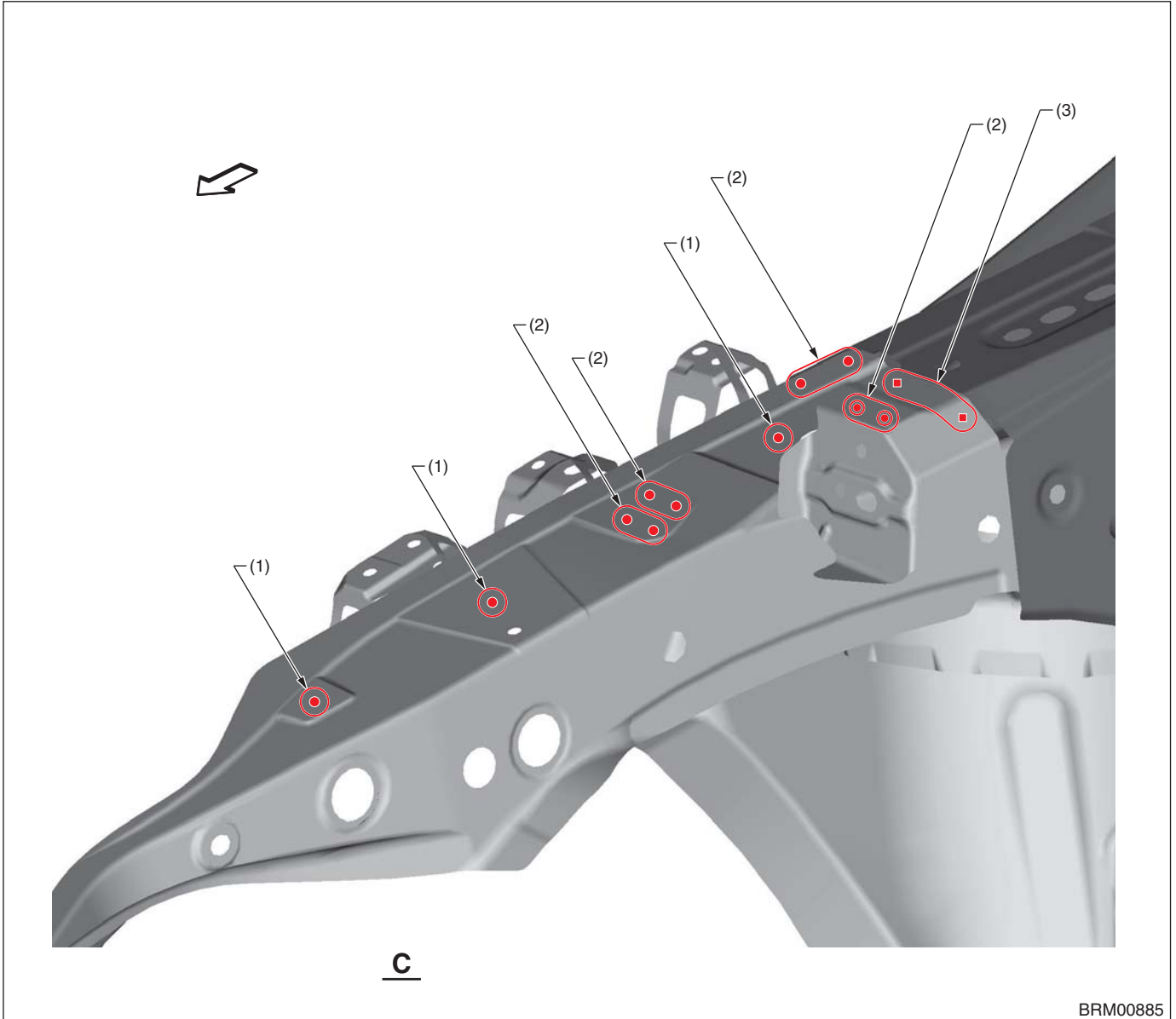
(1) 1 point
(2) 2 points

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

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

Panel Replacement

• View C



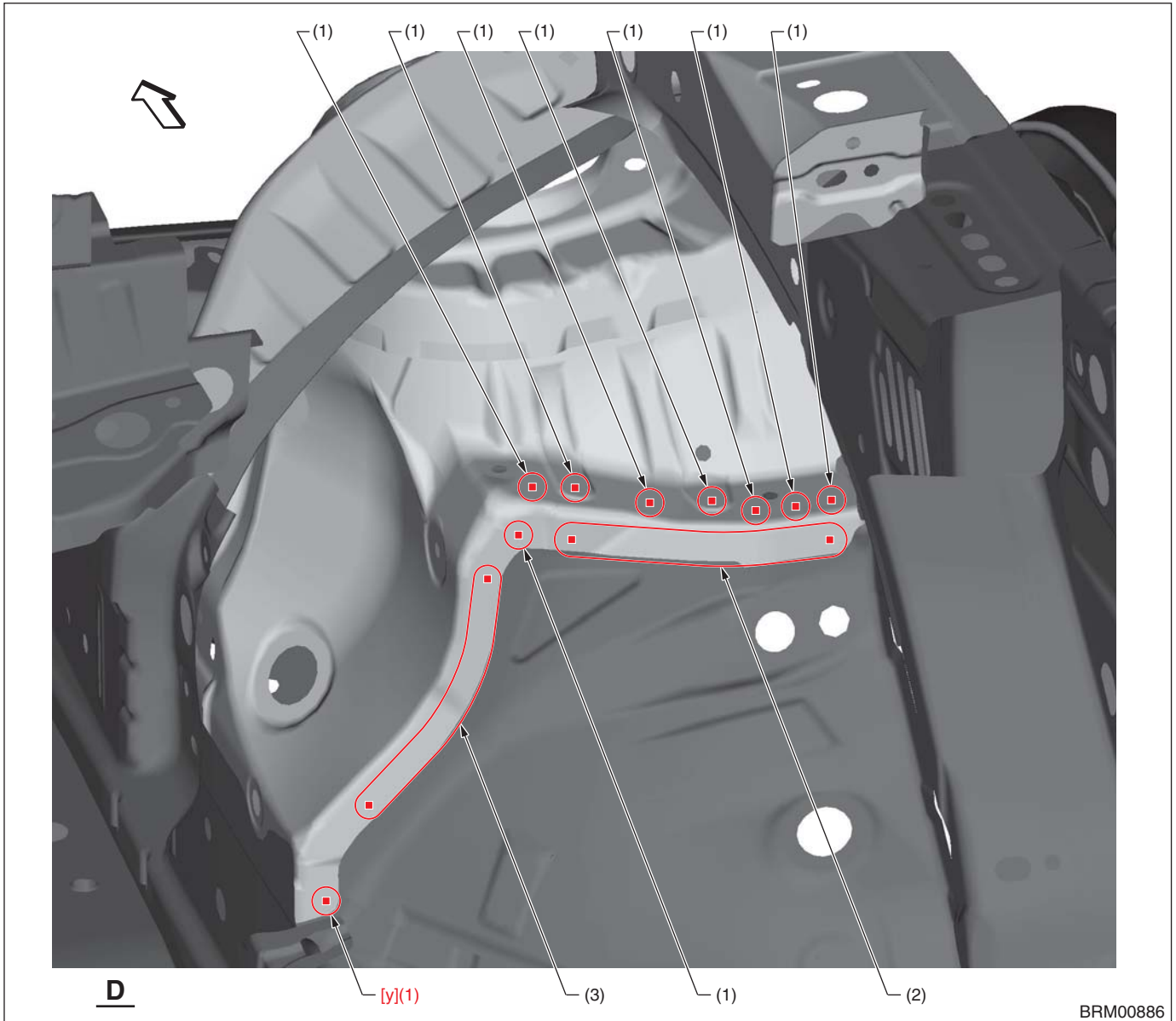
(1) 1 point

(2) 2 points

(3) 3 points (service)

Panel Replacement

• View D



(1) 1 point (service)

(2) 4 points (service)

(3) 5 points (service)

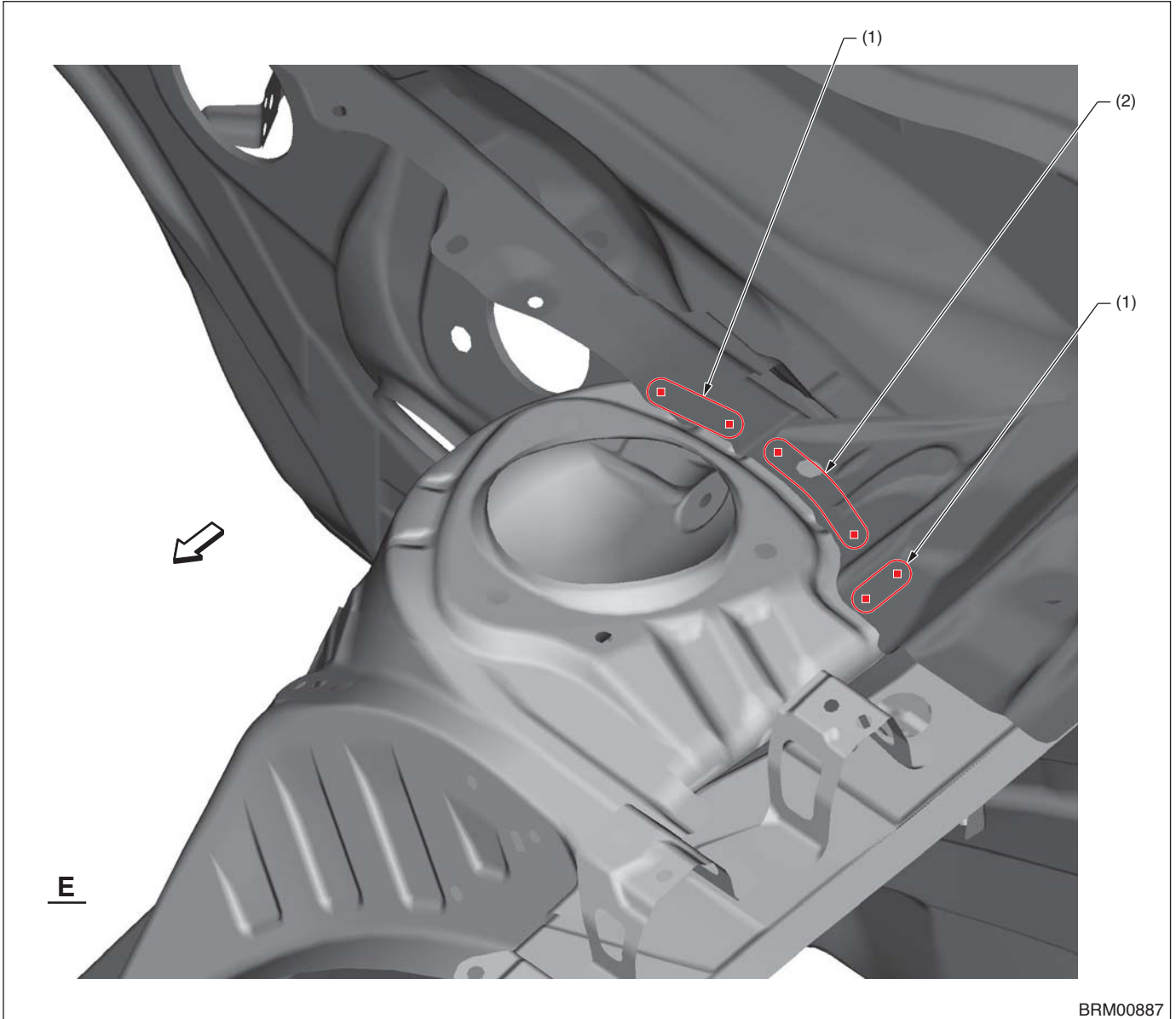
[y] Plug welding

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

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

Panel Replacement

• View E



(1) 2 points

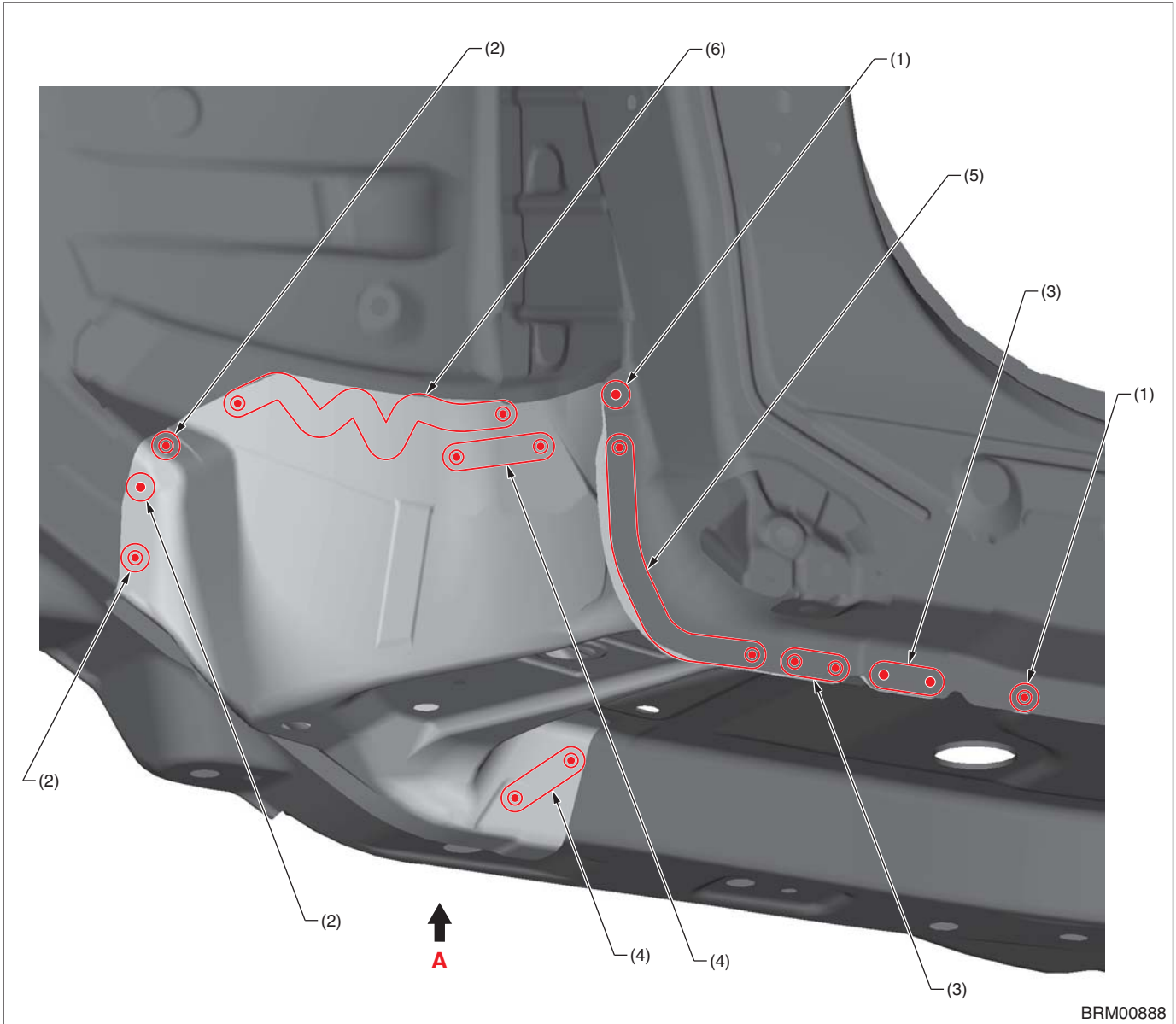
(2) 3 points

Panel Replacement

8-4. Toe Board Reinforcement (Total replacement)

A: REMOVAL

• Overall view



BRM00888

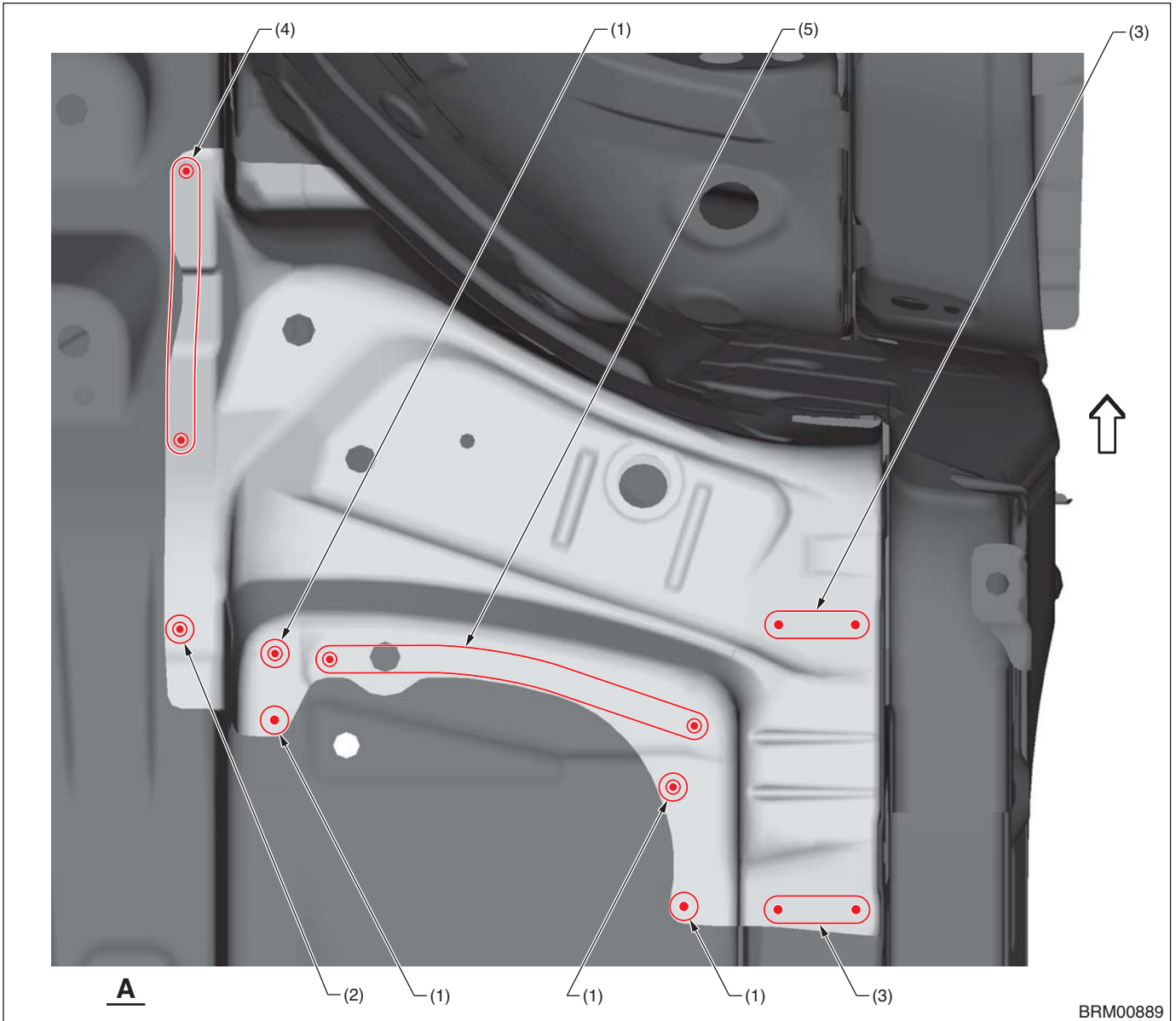
(1) 1 point (inside · 1)
(2) 1 point (outside · 1)

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

(5) 5 points (inside · 1)
(6) 8 points (outside · 1)

Panel Replacement

• View A



BRM00889

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

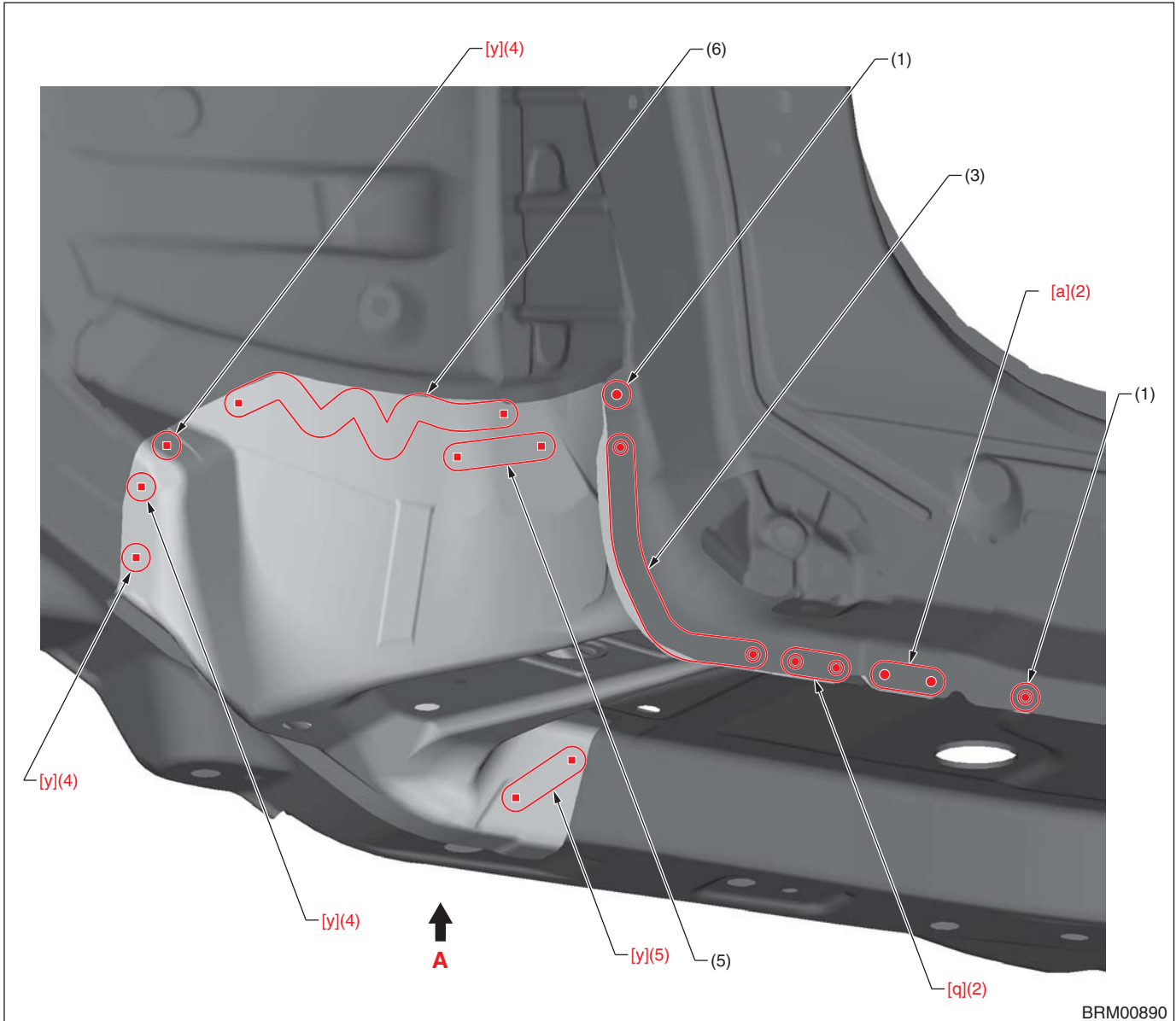
(3) 2 points (bottom · 1)
(4) 4 points (bottom · 1)

(5) 6 points (bottom · 1)

Panel Replacement

B: INSTALLATION

• Overall view



(1) 1 point
(2) 2 points

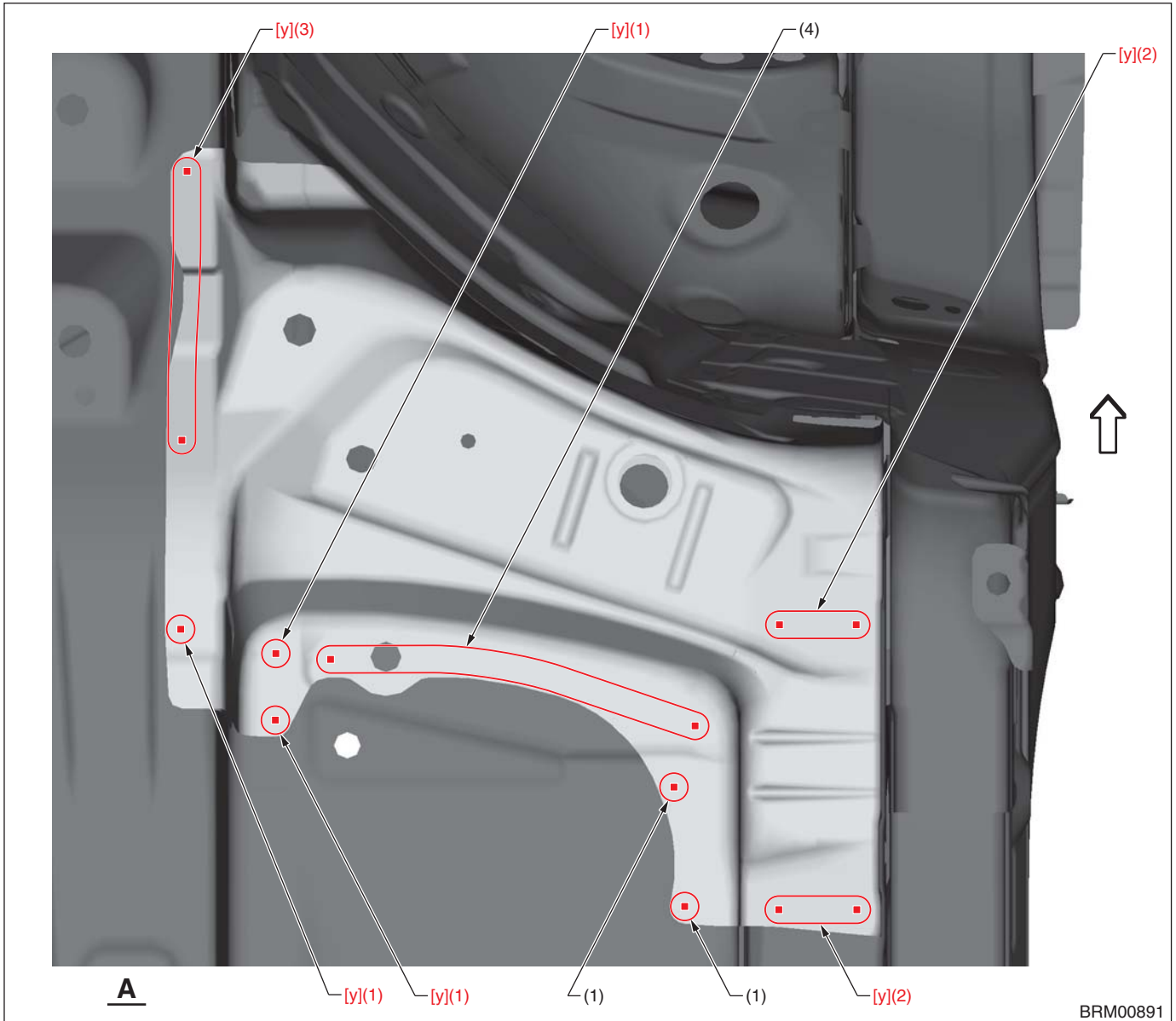
(3) 5 points
(4) 1 point (service)

(5) 2 points (service)
(6) 8 points (service)

[a] Spot welding	Compression: 3.5 kN, Current: 7.5 kA, Welding time: 16 cyc
[q] Spot welding	Compression: 4.0 kN, Current: 8.0 kA, Welding time: 25 cyc
[y] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO ₂ B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO ₂ : 20 %)

Panel Replacement

• View A



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

- (3) 4 points (service)

- (4) 6 points (service)

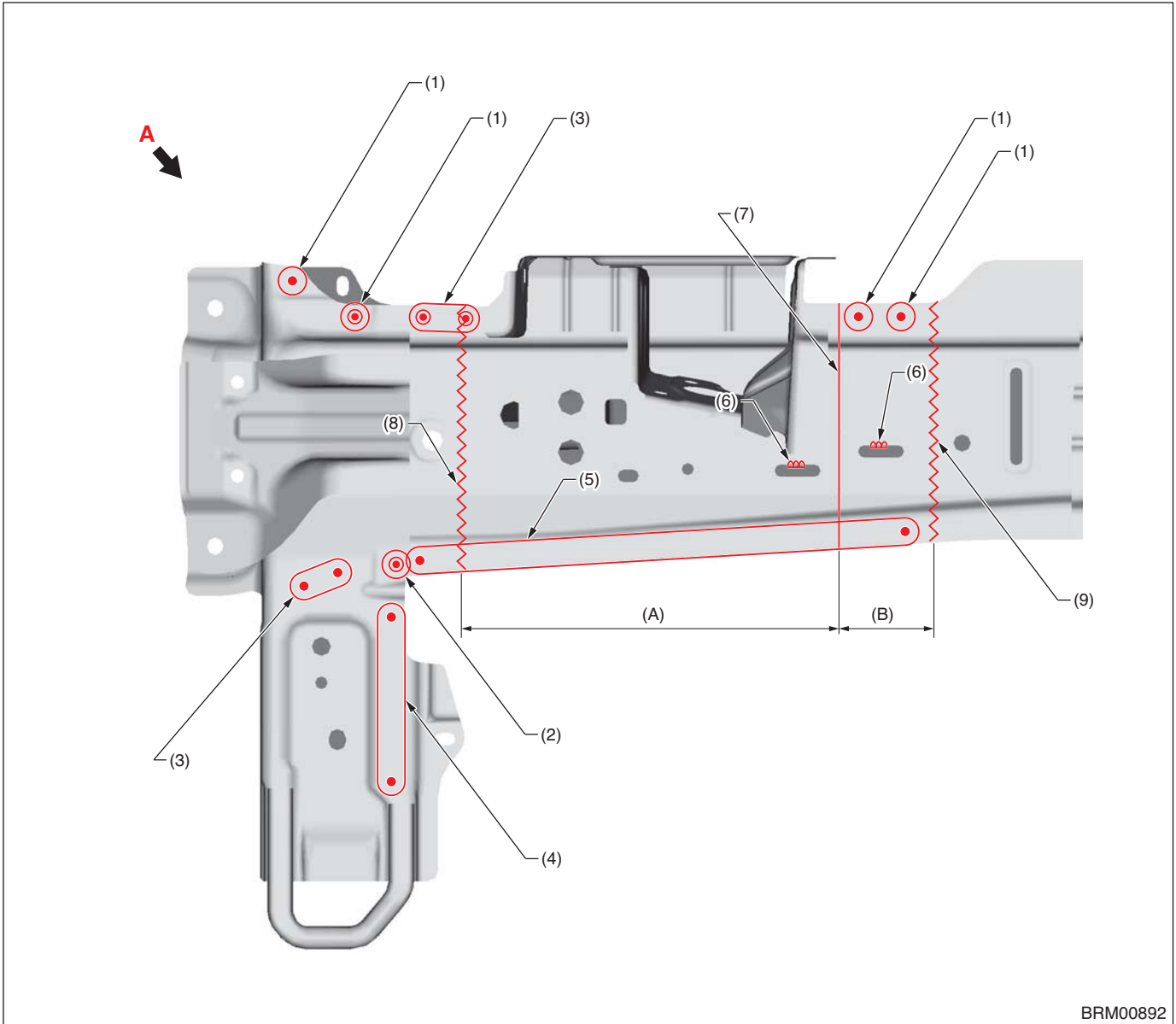
[y] Plug welding	<p>A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO₂</p> <p>B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO₂: 20 %)</p>
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Panel Replacement

8-5. Closing Plate (Partial replacement)

A: REMOVAL

• Overall view



BRM00892

(A) 215 mm [8.46 in]

(B) 56 mm [2.20 in]

(1) 1 point (outside · 1)

(4) 4 points (outside · 1)

(7) Tailored line

(2) 1 point (outside · 2)

(5) 12 points (outside · 1)

(8) Cut position where the damage is small

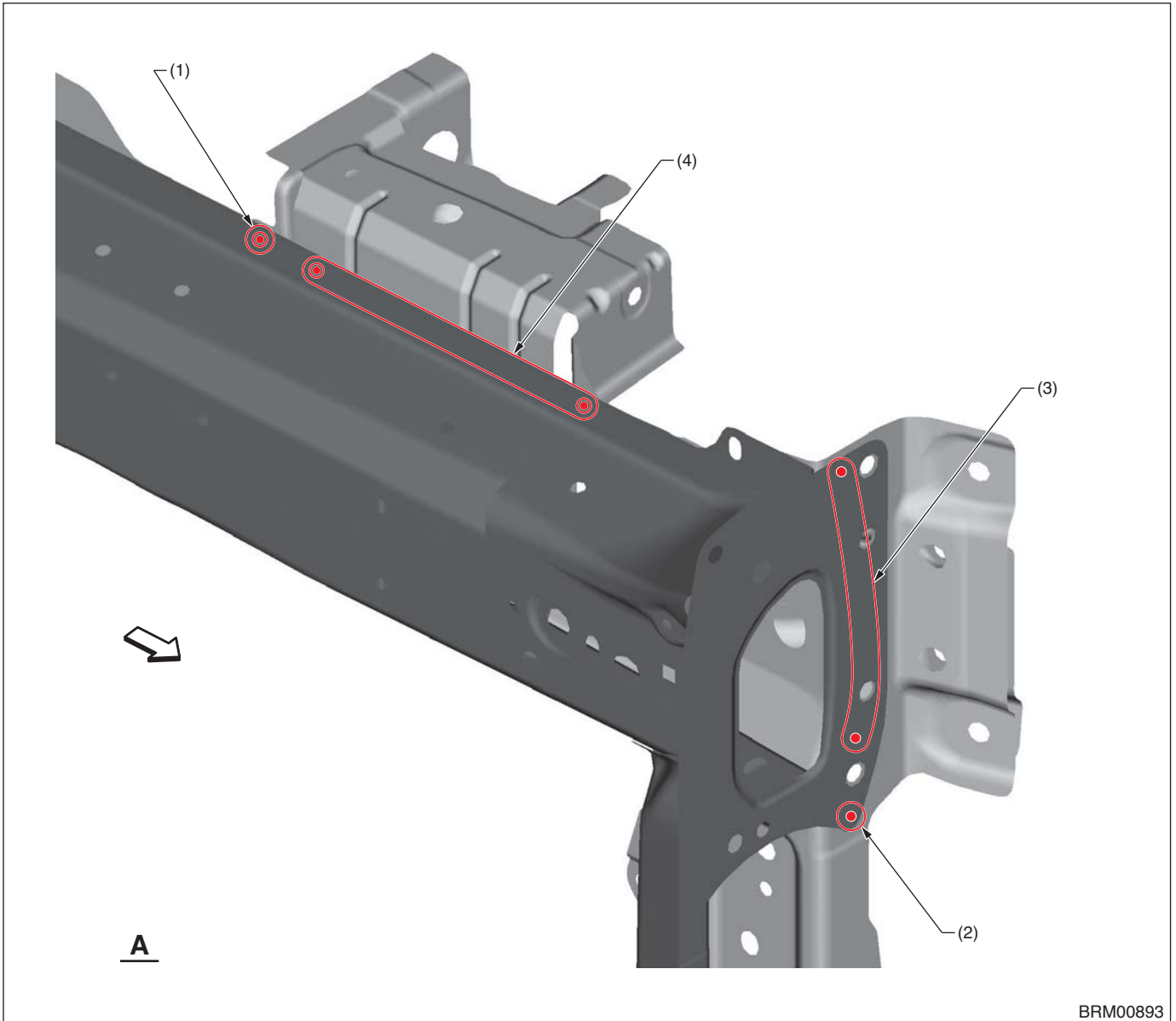
(3) 2 points (outside · 1)

(6) 1 point (outside · 1 belt sander)

(9) Cut position where the damage is large

Panel Replacement

• View A (LH)



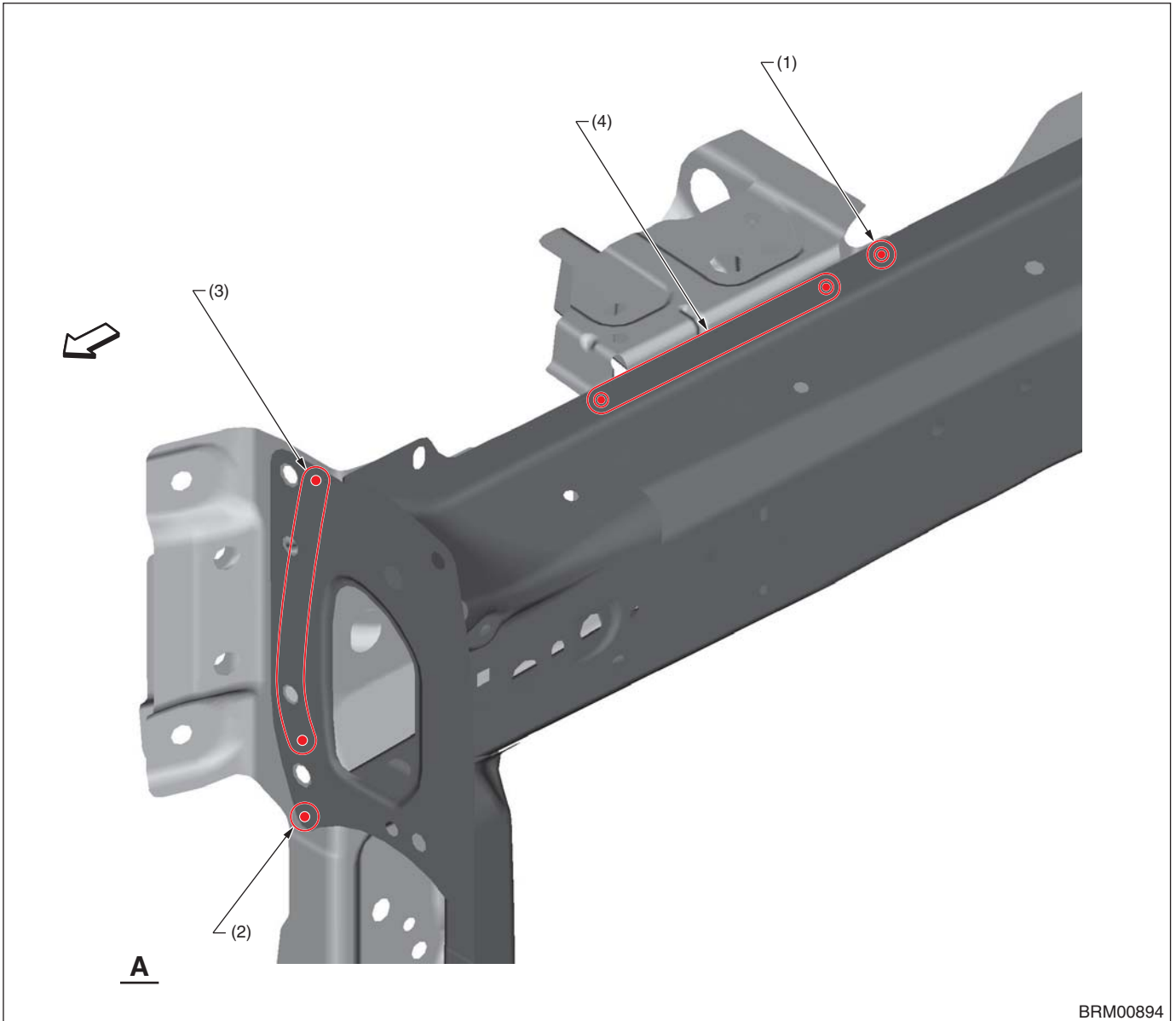
- (1) 1 point (inside · 1)
- (2) 1 point (outside · 1)

- (3) 2 points (outside · 1)

- (4) 6 points (inside · 1)

Panel Replacement

• View A (RH)



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

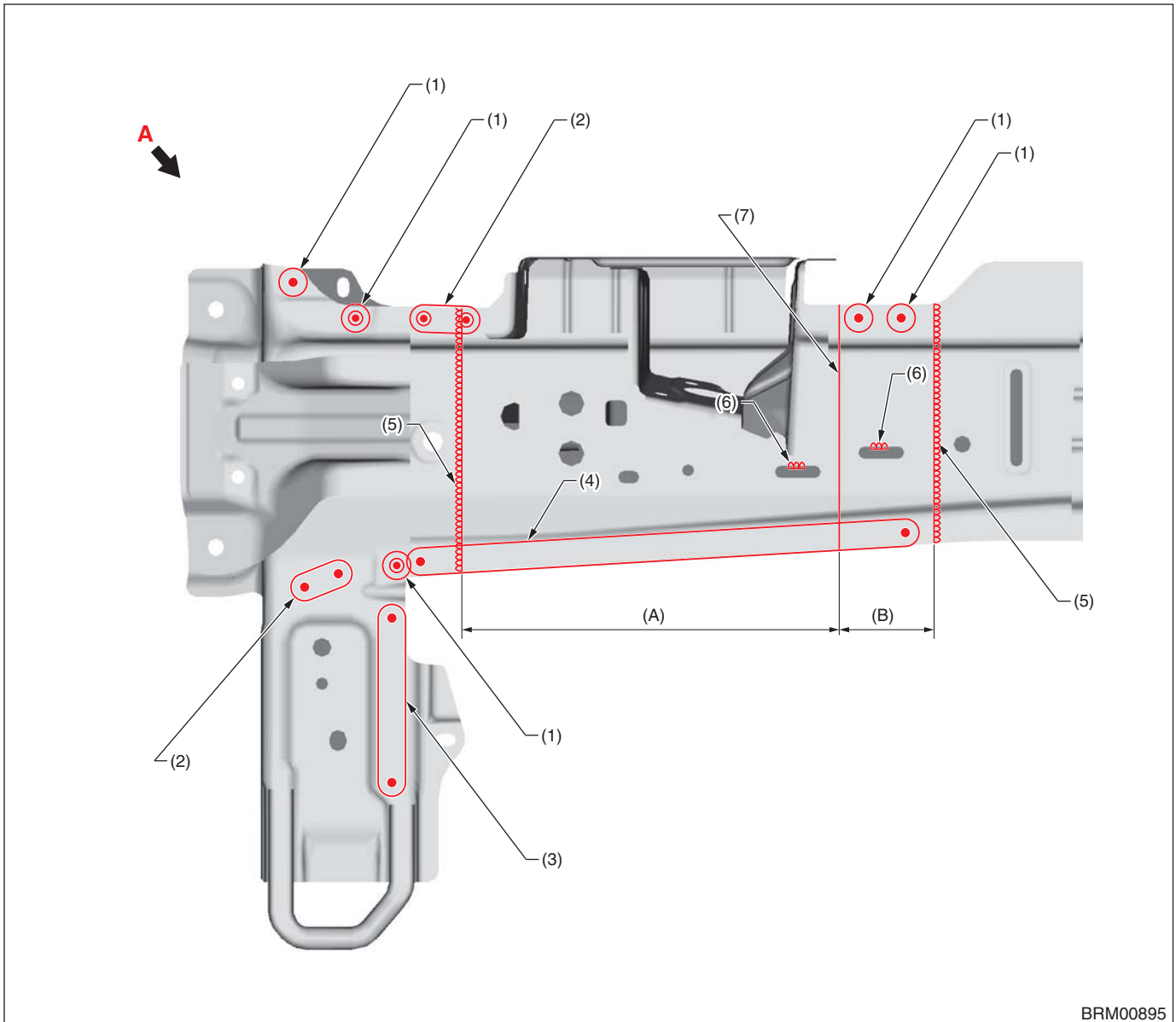
(3) 2 points (outside · 1)

(4) 5 points (inside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BRM00895

(A) 215 mm [8.46 in]

(B) 56 mm [2.20 in]

(1) 1 point

(4) 12 points

(7) Tailored line

(2) 2 points

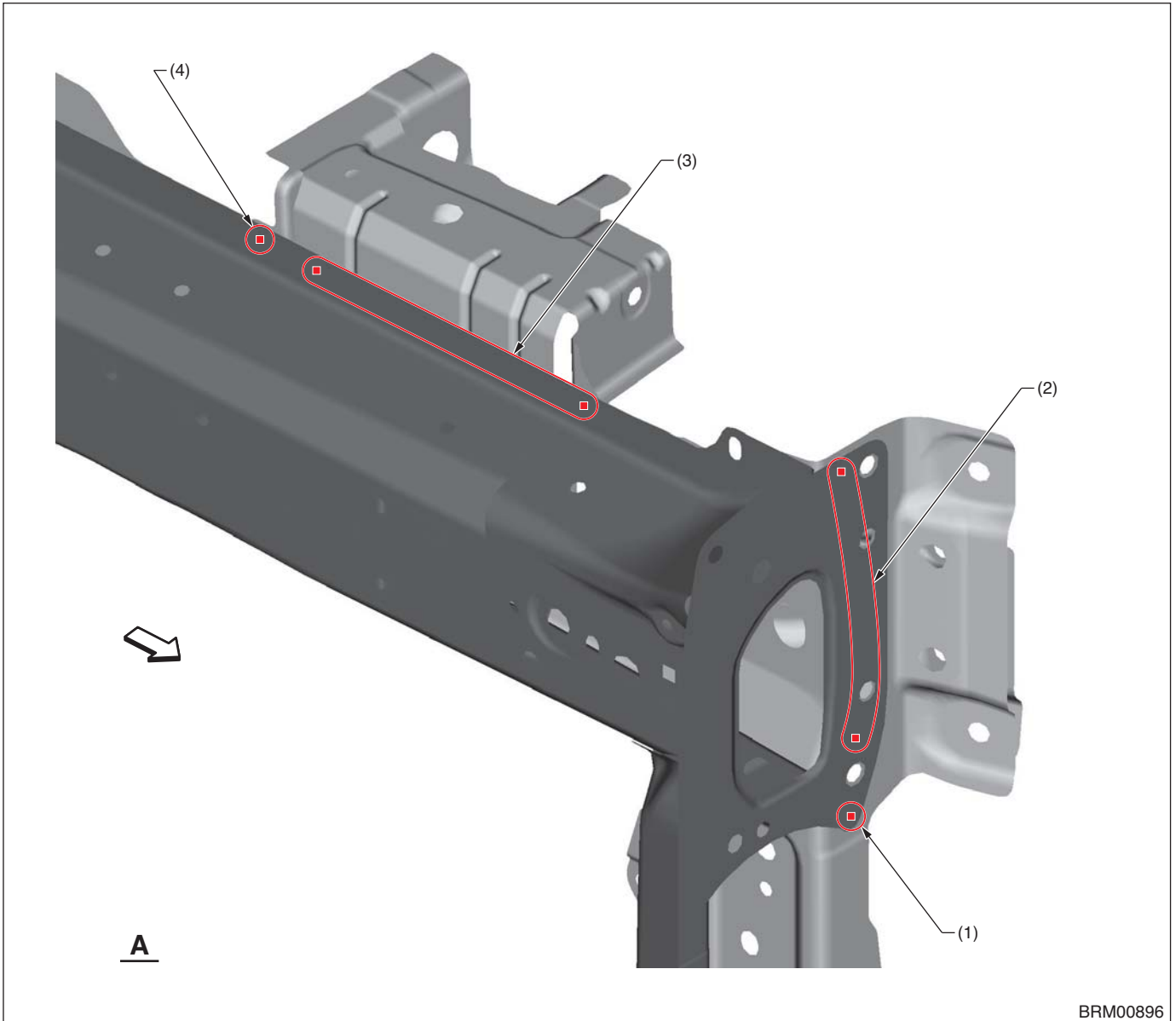
(5) 1 point (Continuous welding)

(3) 4 points

(6) 1 point (Continuous welding)
(10 mm [0.39 in])

Panel Replacement

• View A (LH)



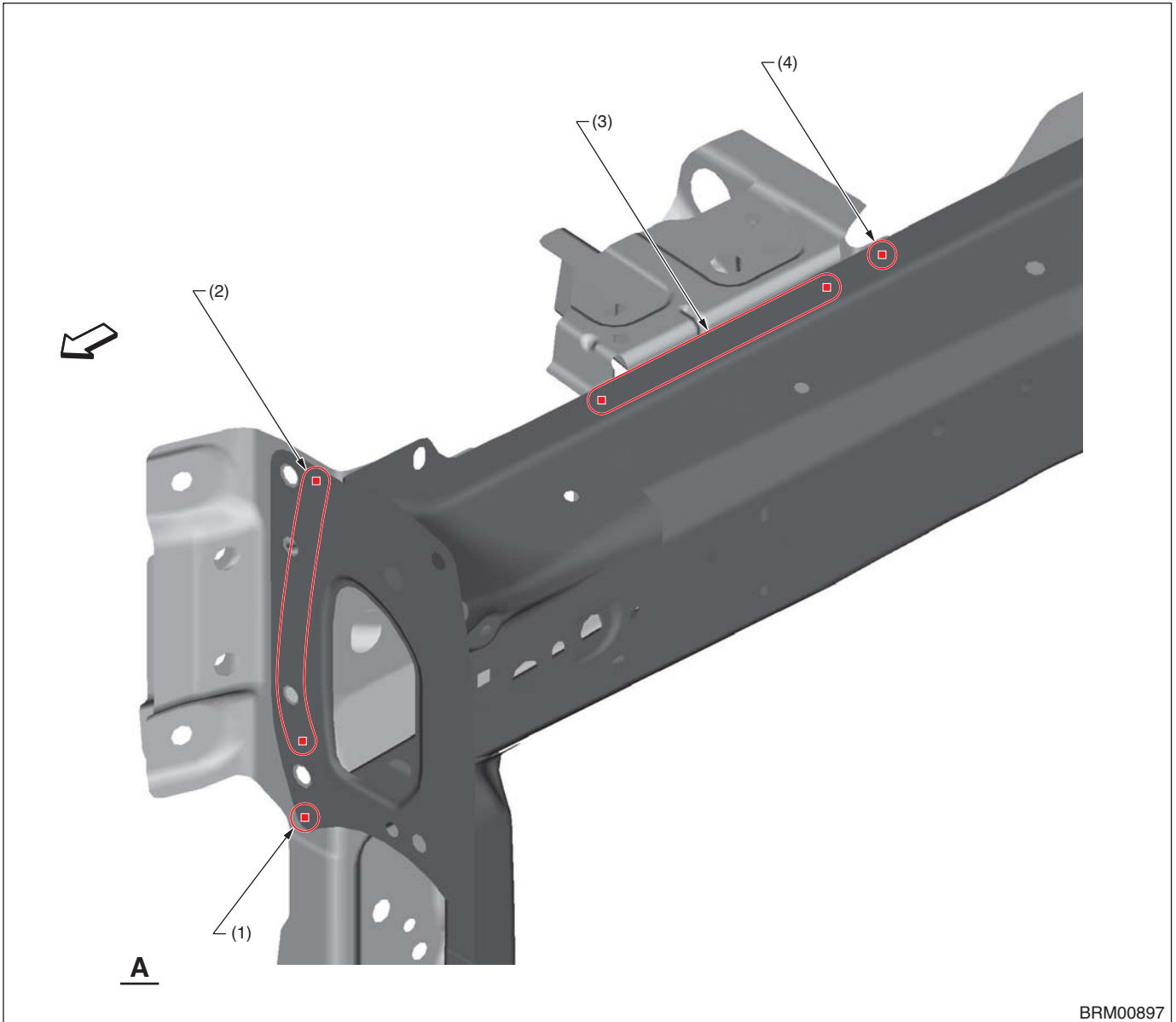
(1) 1 point
(2) 2 points

(3) 6 points (service · matching)

(4) 1 point (service · matching)

Panel Replacement

• View A (RH)



(1) 1 point
(2) 2 points

(3) 5 points (service · matching)

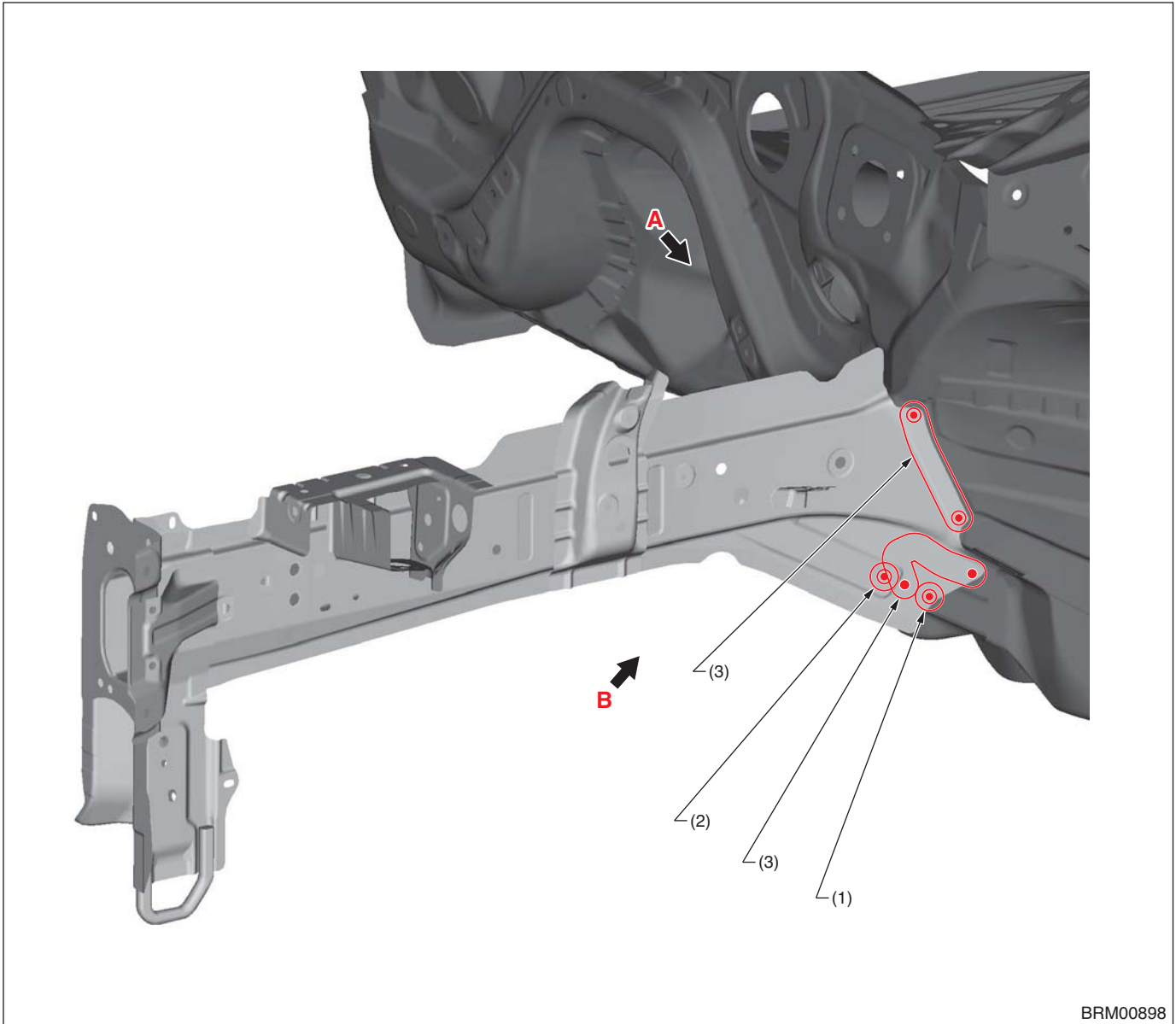
(4) 1 point (service · matching)

Panel Replacement

8-6. Front Side Frame (Total replacement)

A: REMOVAL

- Overall view



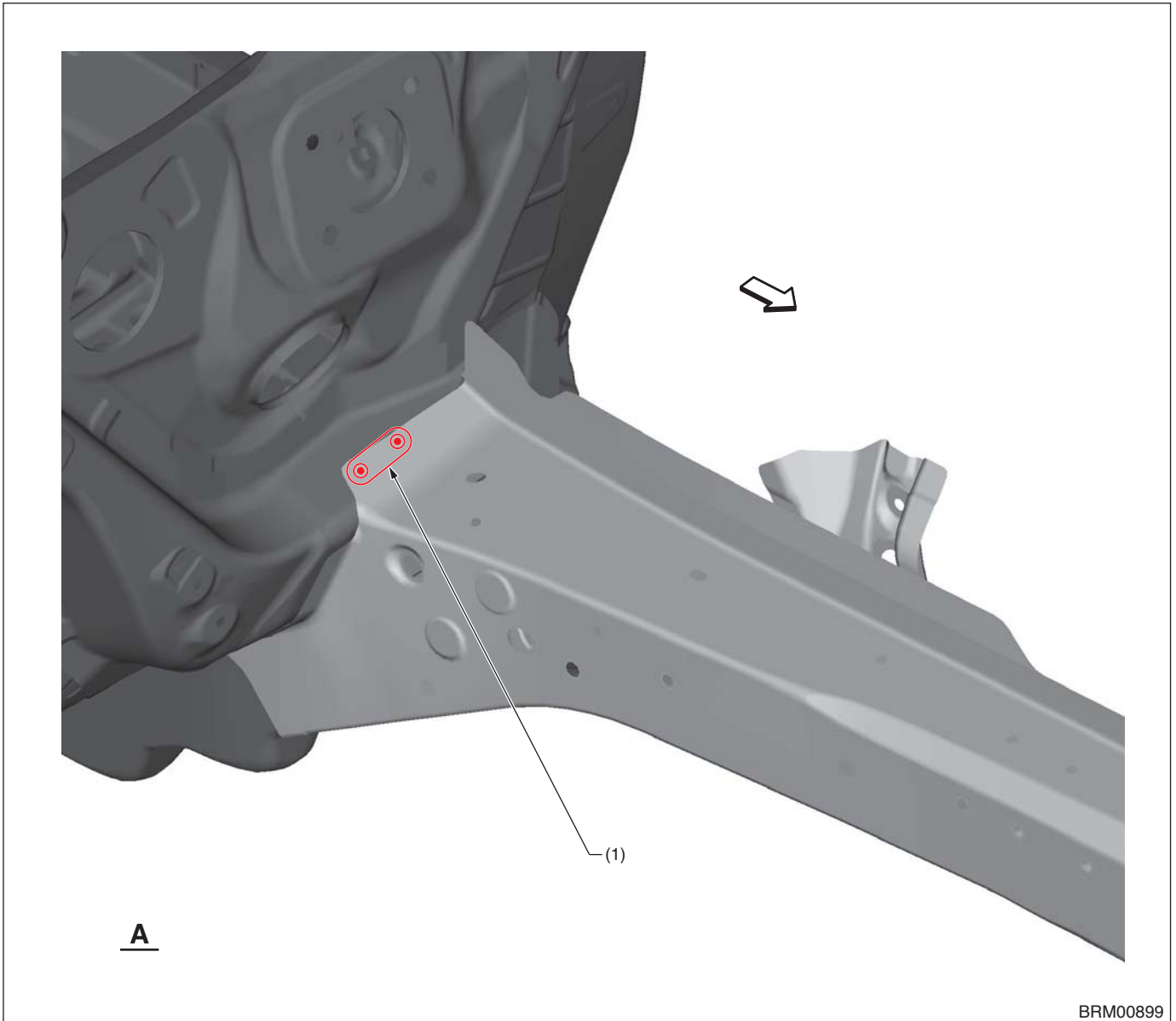
(1) 1 point (outside · 1)

(2) 1 point (outside · 2)

(3) 5 points (outside · 1)

Panel Replacement

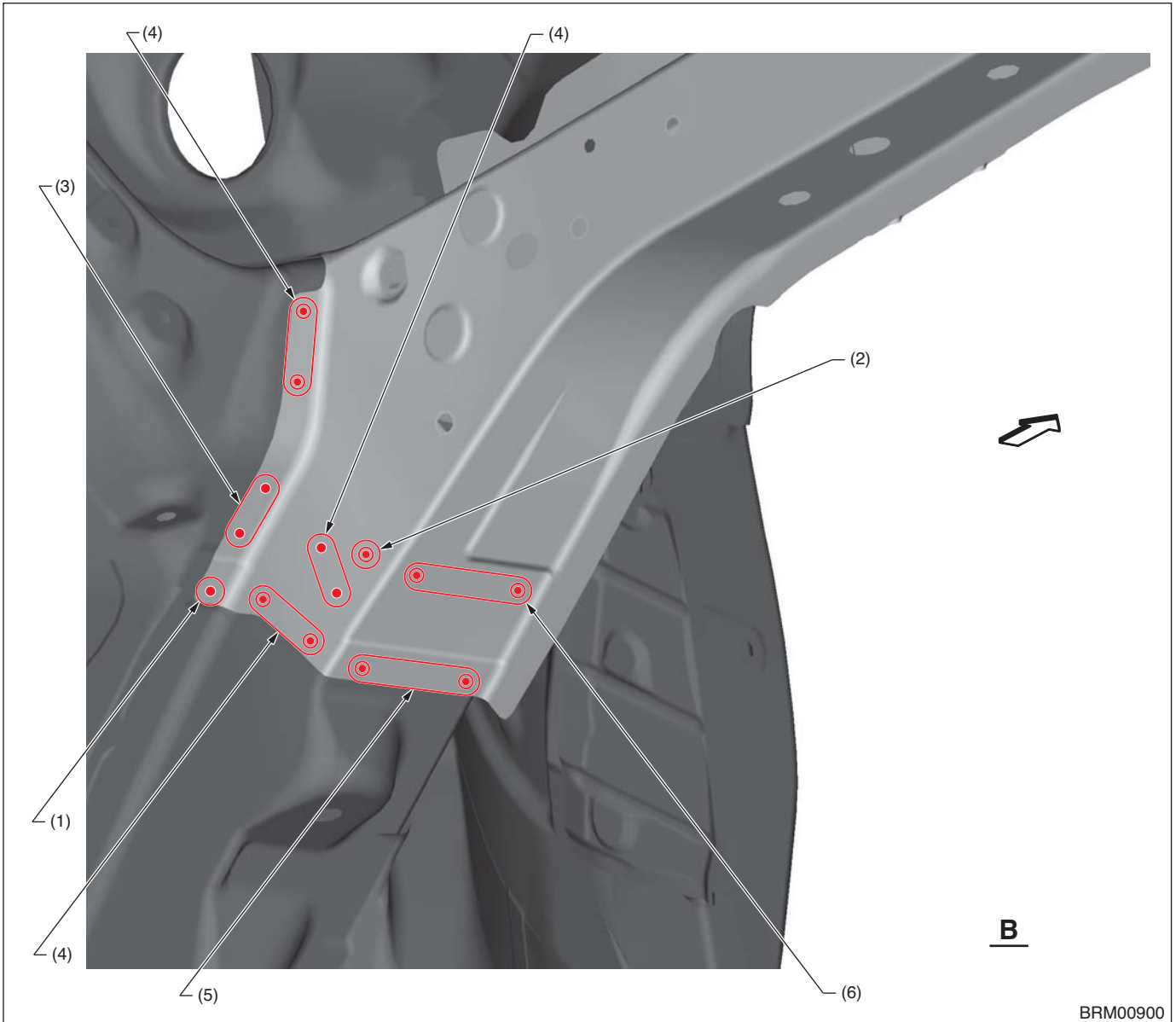
• View A



(1) 2 points (top - 1)

Panel Replacement

• View B



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

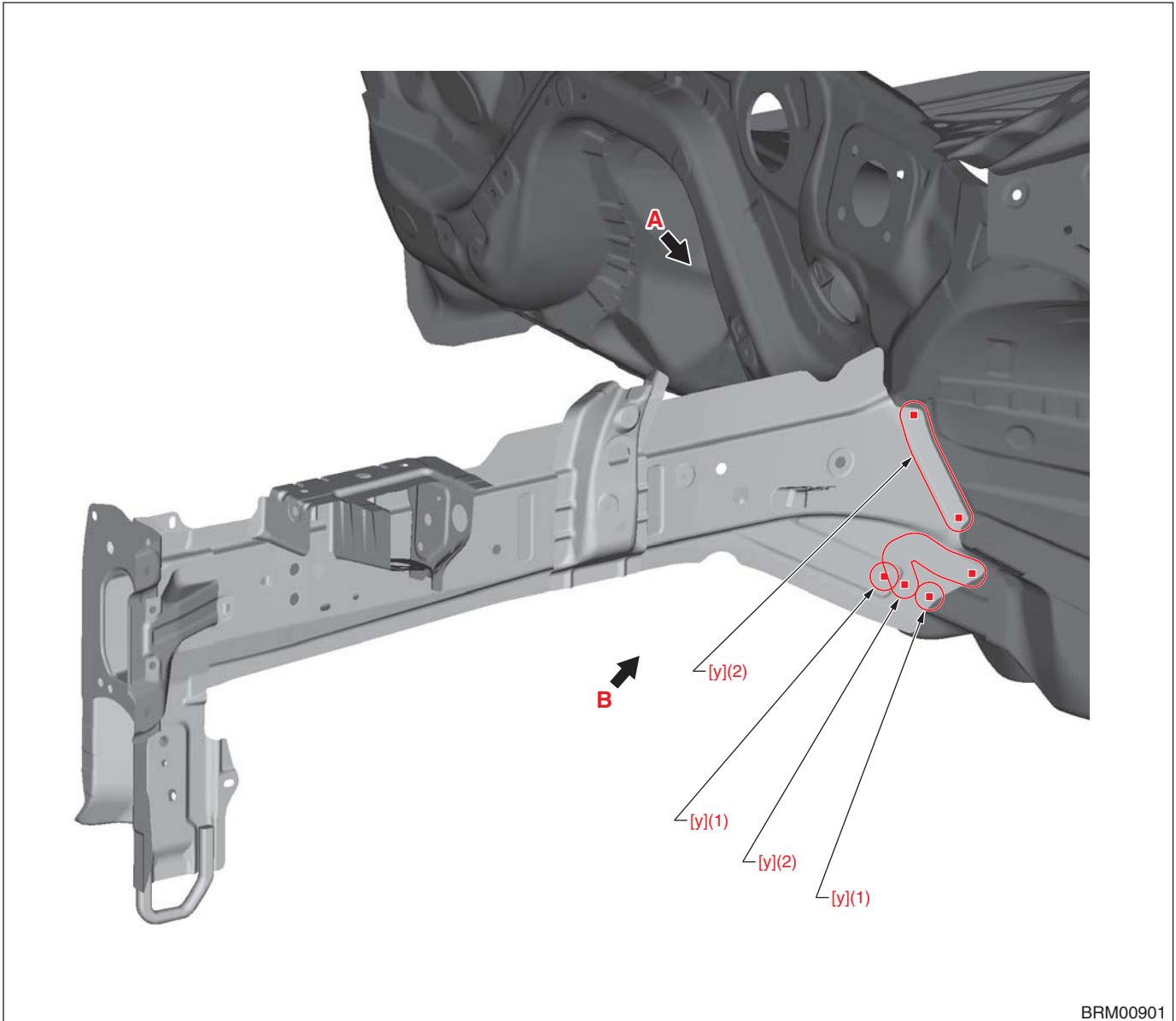
(3) 2 points (bottom · 1)
(4) 2 points (inside · 1)

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

Panel Replacement

B: INSTALLATION

• Overall view



BRM00901

(1) 1 point (service)

(2) 5 points (service)

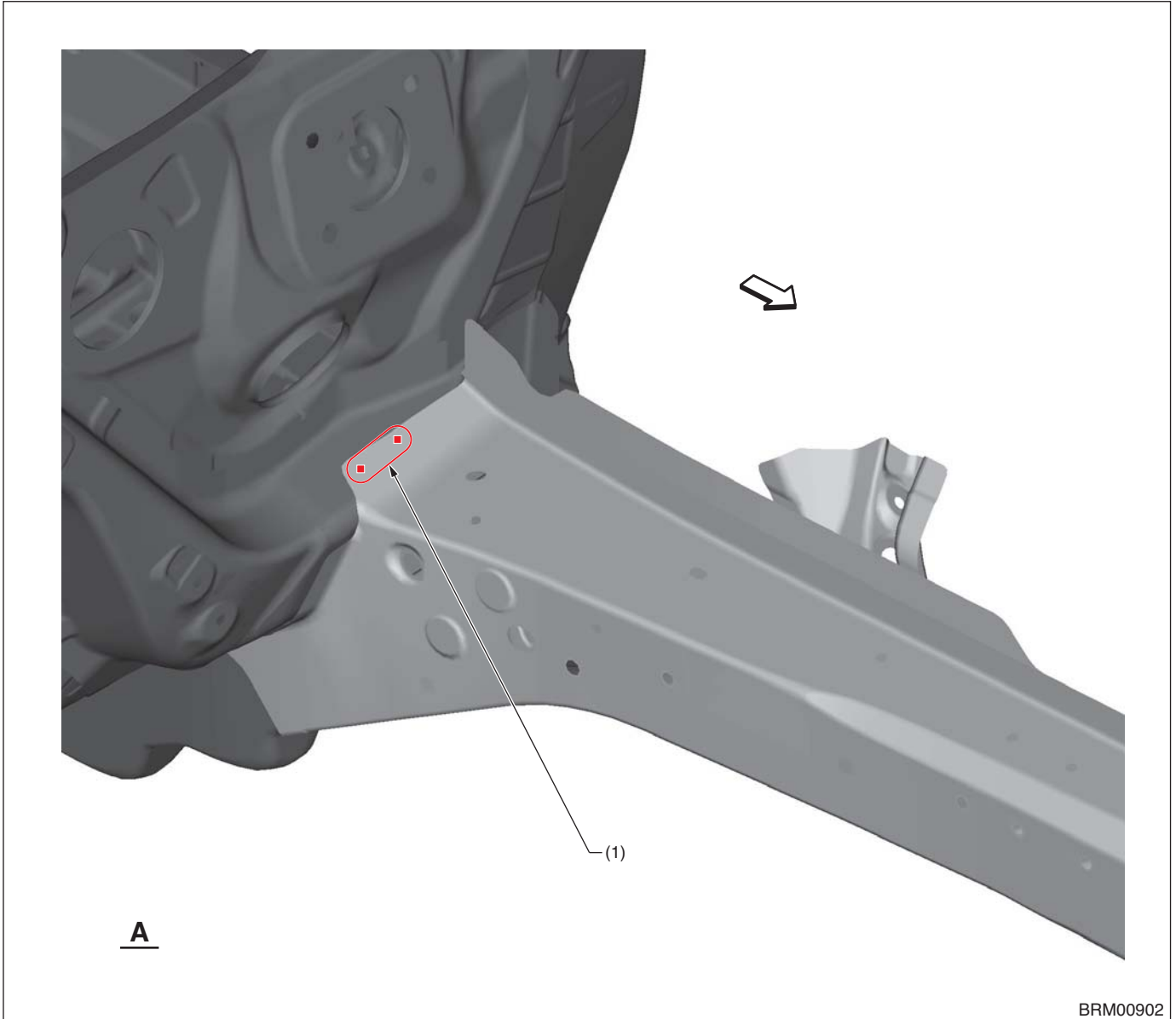
[y] Plug welding

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

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

Panel Replacement

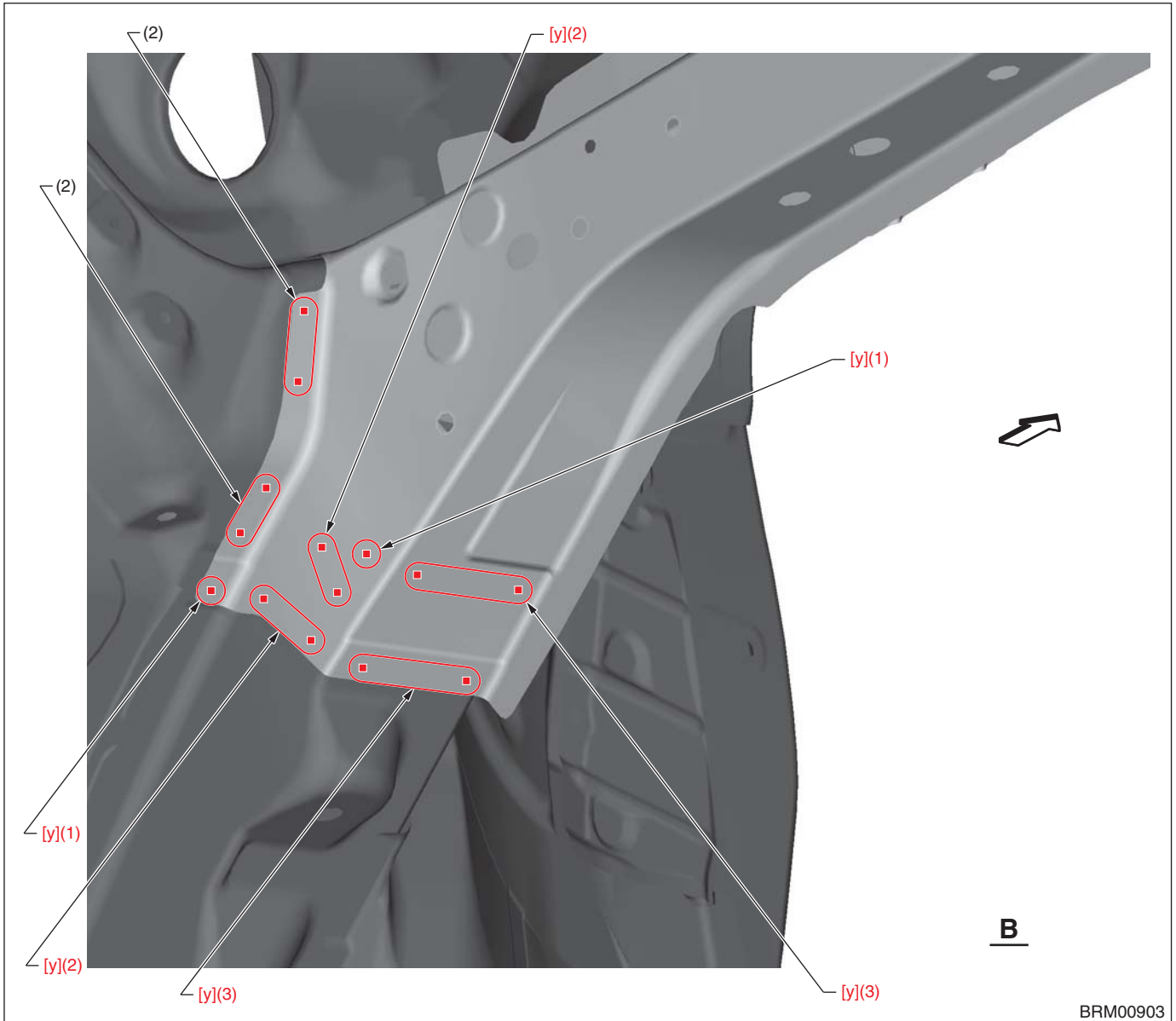
• View A



(1) 2 points (service)

Panel Replacement

• View B



(1) 1 point (service)

(2) 2 points (service)

(3) 3 points (service)

[y] Plug welding

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

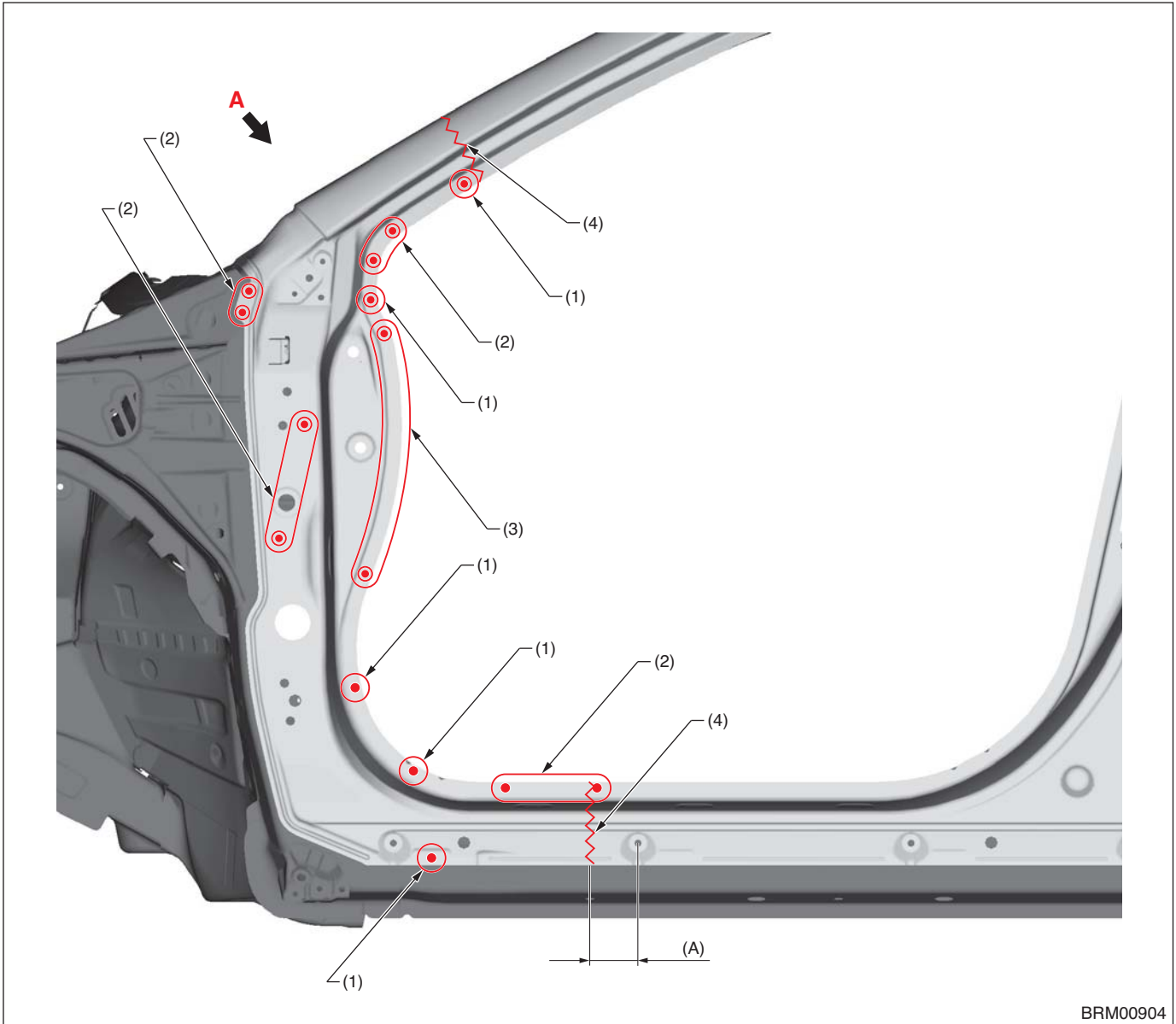
B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO₂: 20 %)

Panel Replacement

8-7. Front Pillar Outer (Partial replacement)

A: REMOVAL

• Overall view



BRM00904

(A) 60 mm [2.36 in]

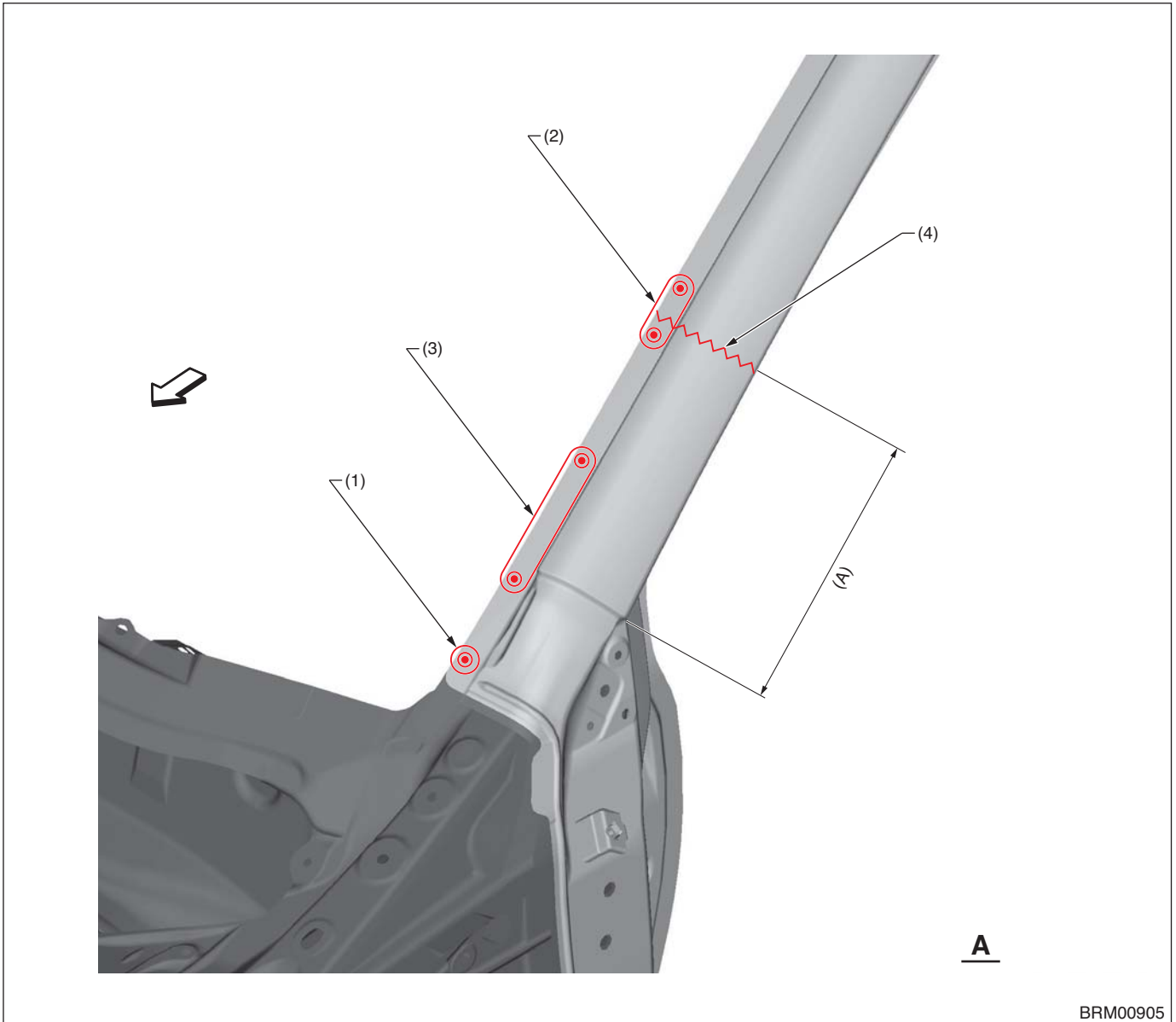
(1) 1 point (outside · 1)
(2) 2 points (outside · 1)

(3) 9 points (outside · 1)

(4) Cut position

Panel Replacement

• View A



BRM00905

(A) 200 mm [7.87 in]

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

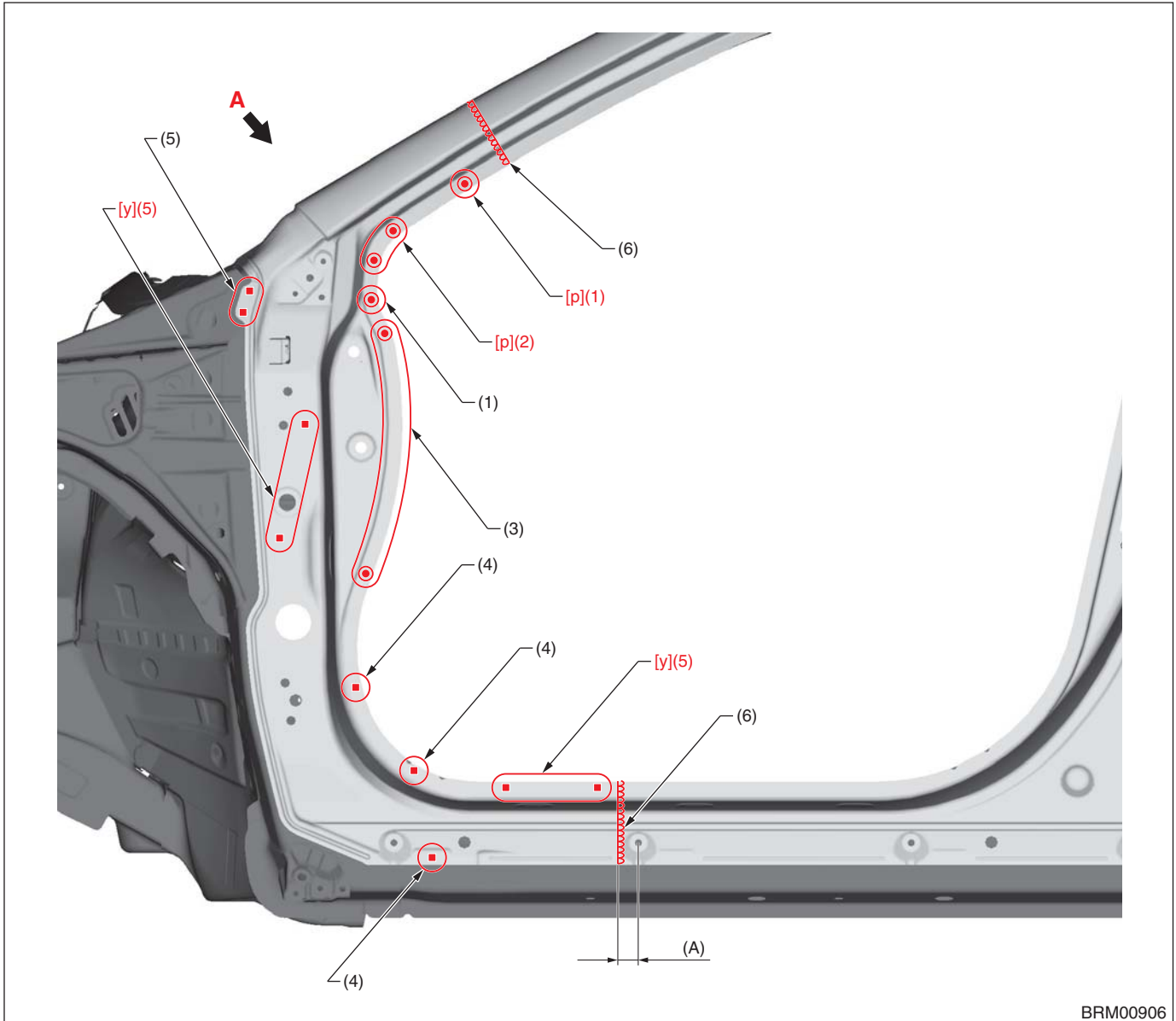
(3) 4 points (top · 1)

(4) Cut position

Panel Replacement

B: INSTALLATION

• Overall view 1



BRM00906

(A) 30 mm [1.18 in]

(1) 1 point

(3) 9 points

(5) 2 points (service)

(2) 2 points

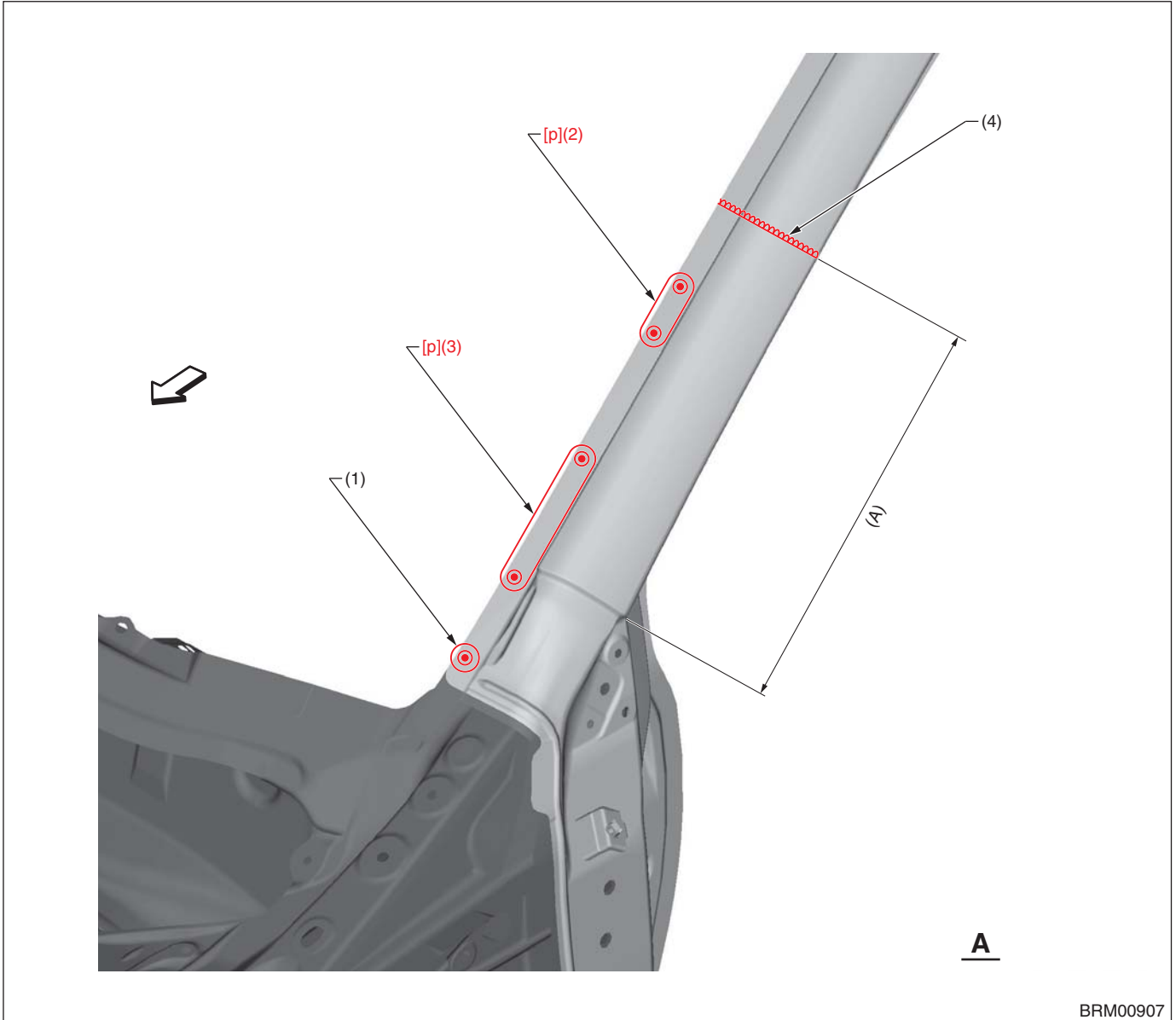
(4) 1 point (service)

(6) 1 point (Continuous welding)

[p] Spot welding	Compression: 4.0 kN, Current: 8.0 kA, Welding time: 22 cyc
[y] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO ₂ B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO ₂ : 20 %)

Panel Replacement

• View A



(A) 245 mm [9.65 in]

(1) 1 point
(2) 2 points

(3) 4 points

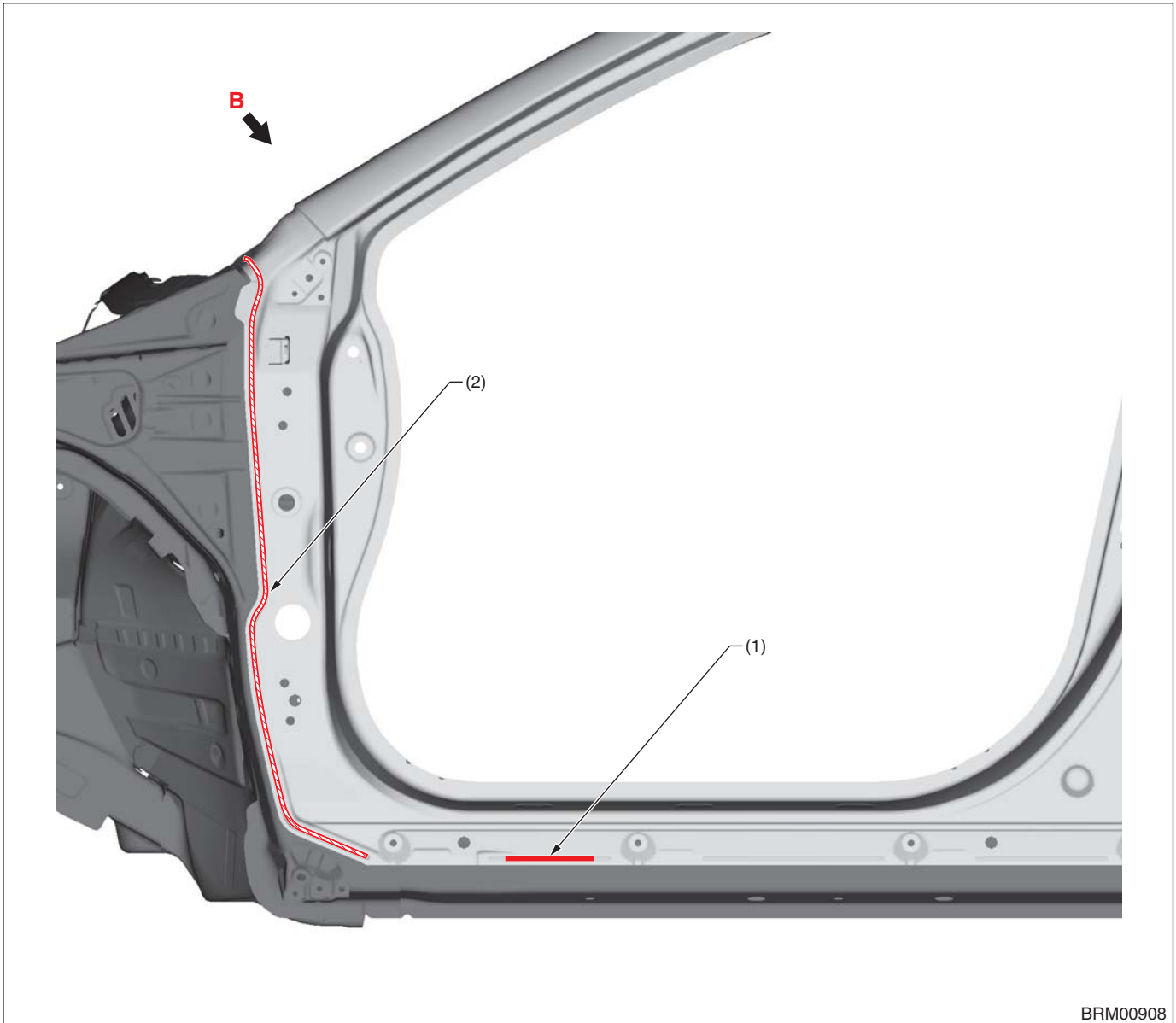
(4) 1 point (Continuous welding)

[p] Spot welding

Compression: 4.0 kN, Current: 8.0 kA, Welding time: 22 cyc

Panel Replacement

• Overall view 2



BRM00908

(1) Structural adhesive

(2) Spotting sealer

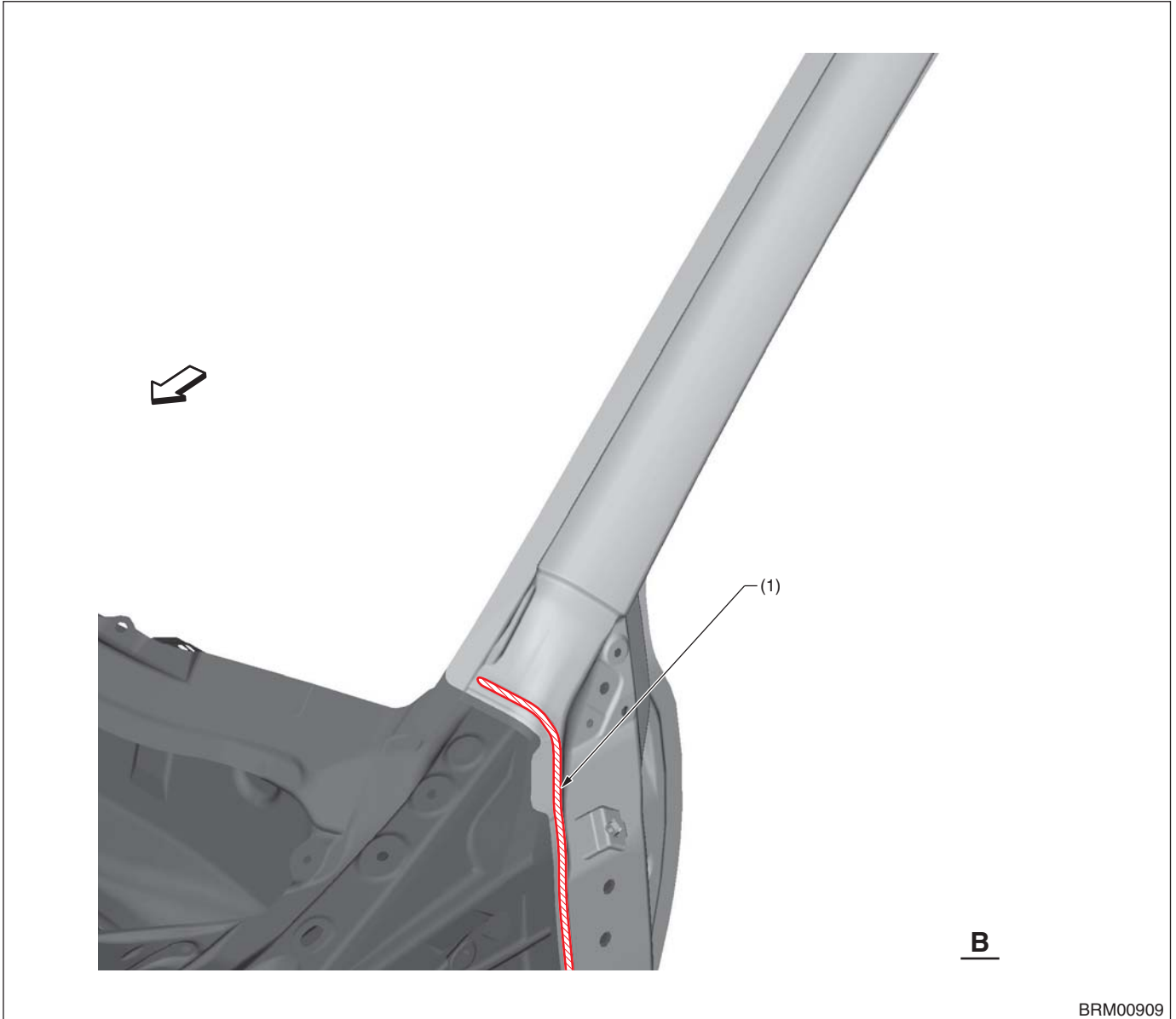
— : Structural adhesive application location (Panel bond mini 38315 made by 3M or equivalent)

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


Note: Fill spotting sealer between the panel side out and reinforcement pillar front outer.

Panel Replacement

• View B



(1) Spotting sealer

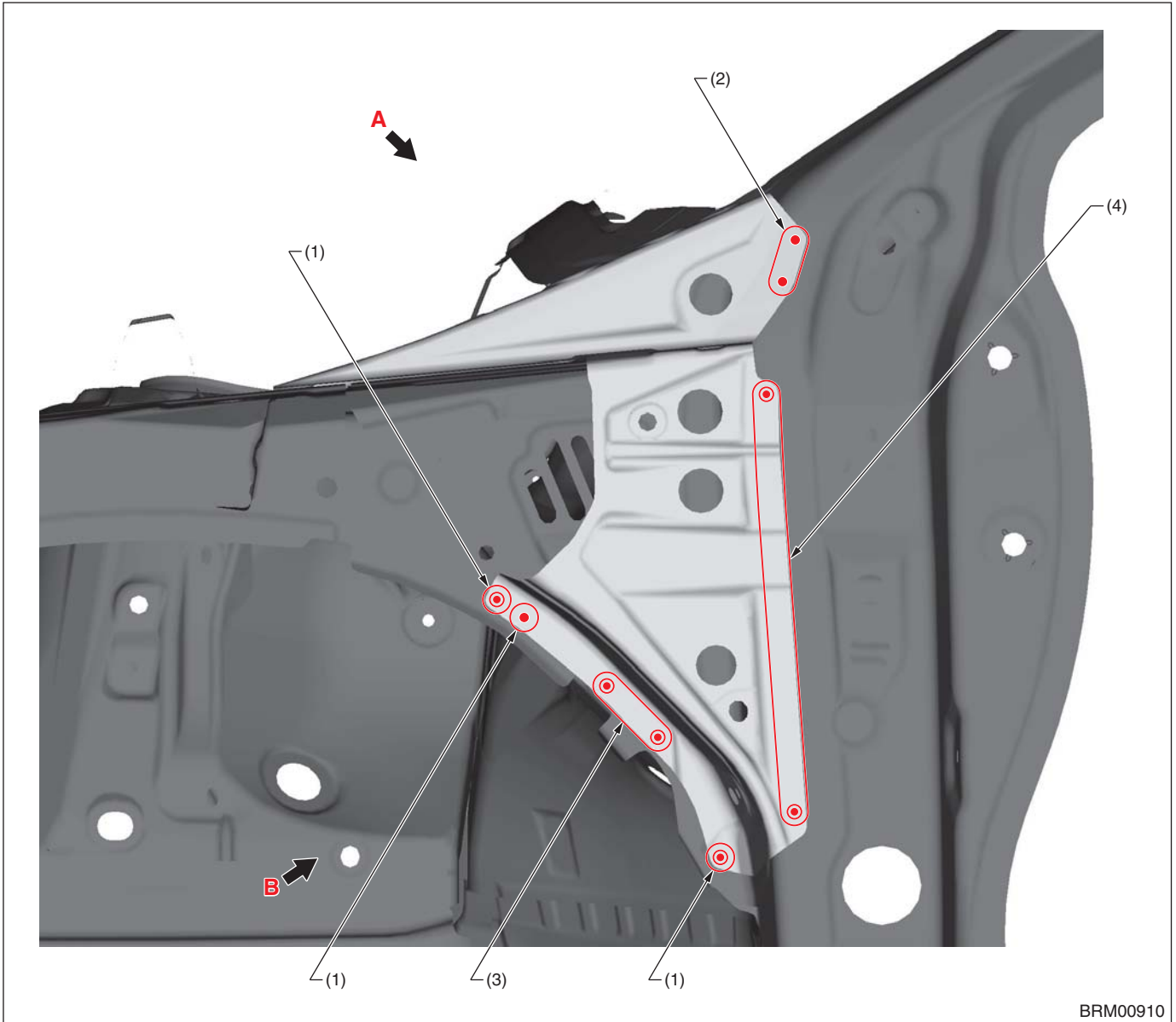
 : Spotting sealer application location (spotting sealer or sealing [Three Bond 4101 (004403063)])
Note: Fill spotting sealer between the panel side out and reinforcement pillar front outer.

Panel Replacement

8-8. Front Pillar Reinforcement (Total replacement)

A: REMOVAL

• Overall view 1



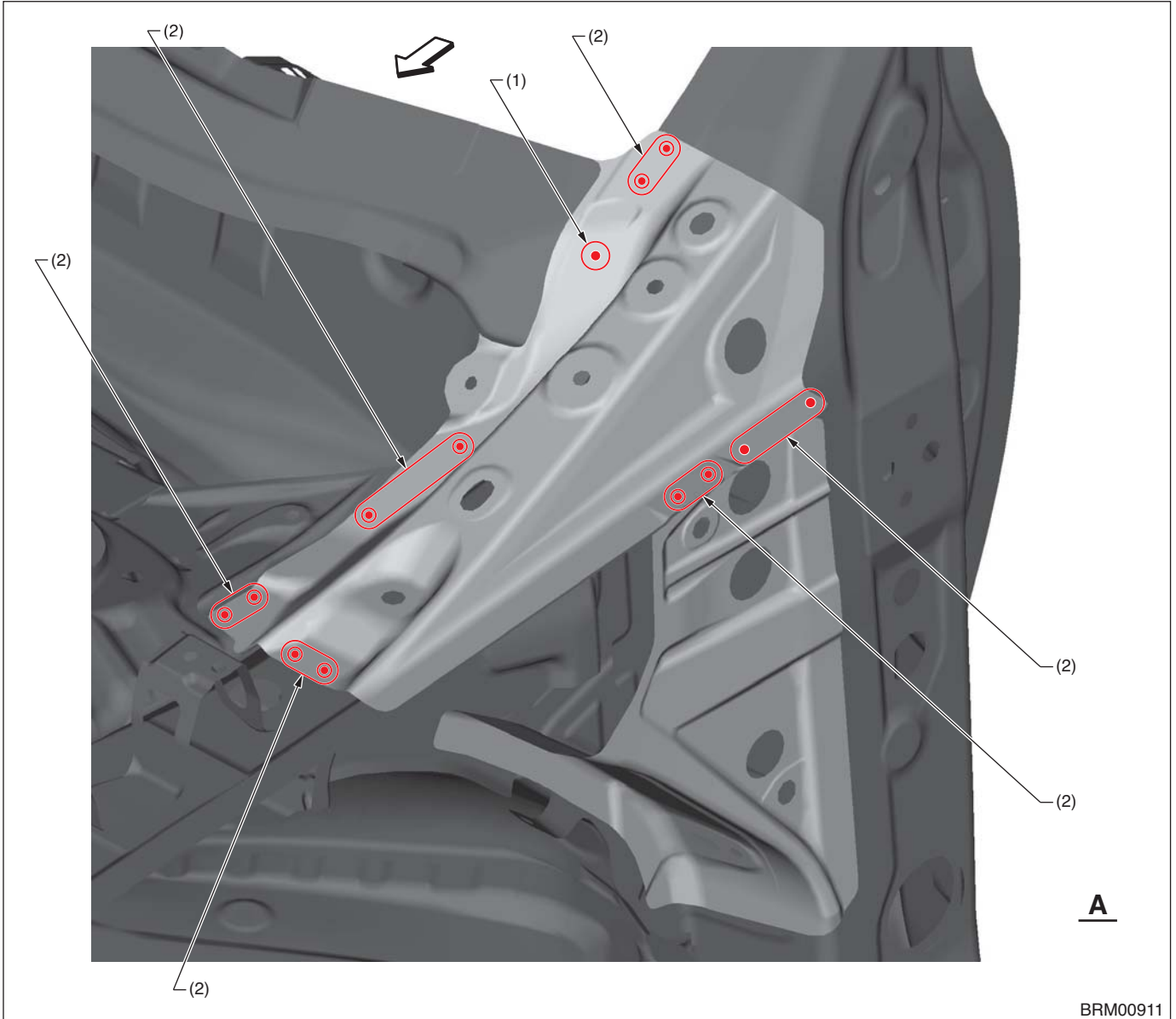
(1) 1 point (outside · 1)
(2) 2 points (outside · 2)

(3) 3 points (outside · 1)

(4) 7 points (outside · 1)

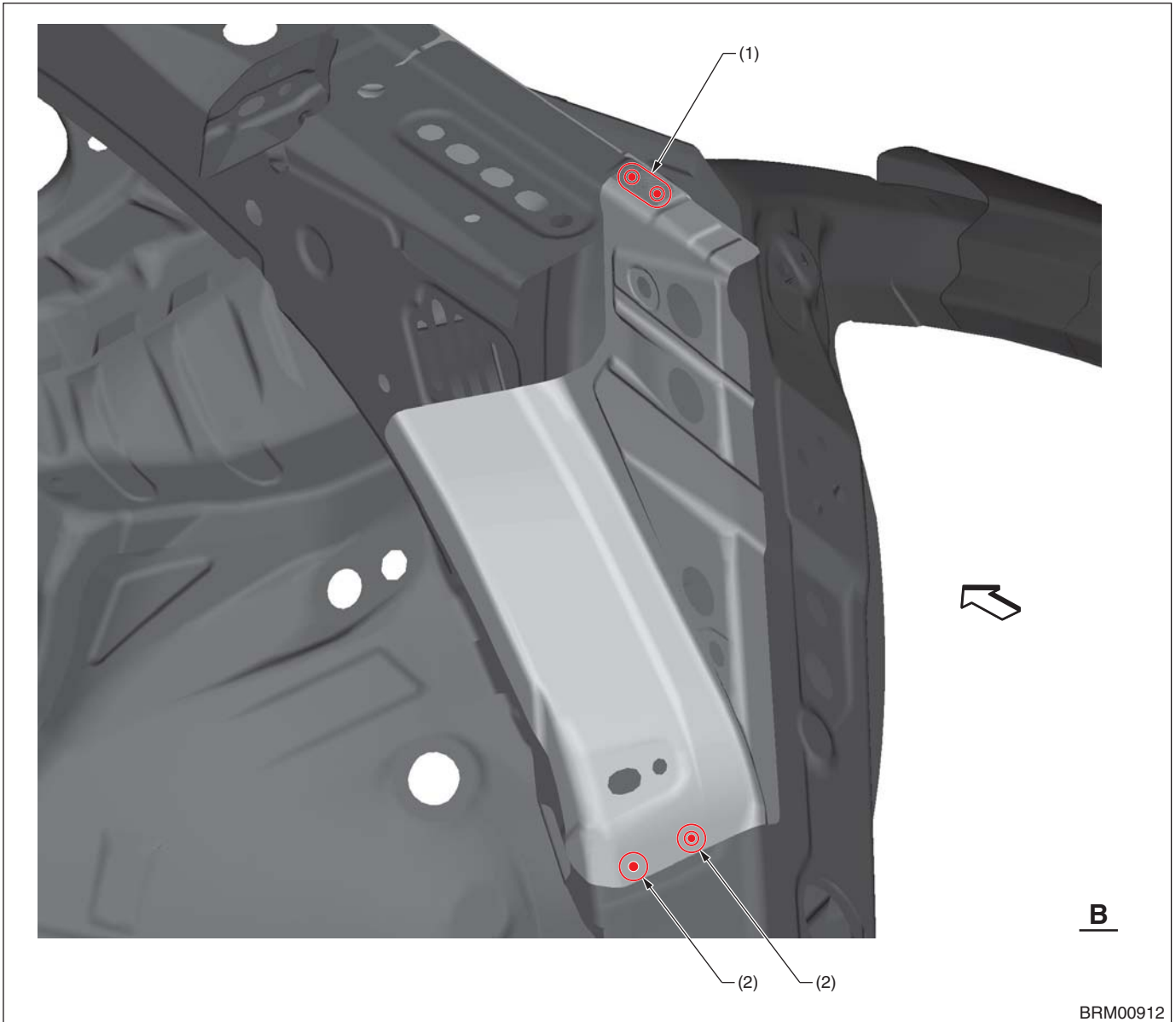
Panel Replacement

• View A



Panel Replacement

• View B

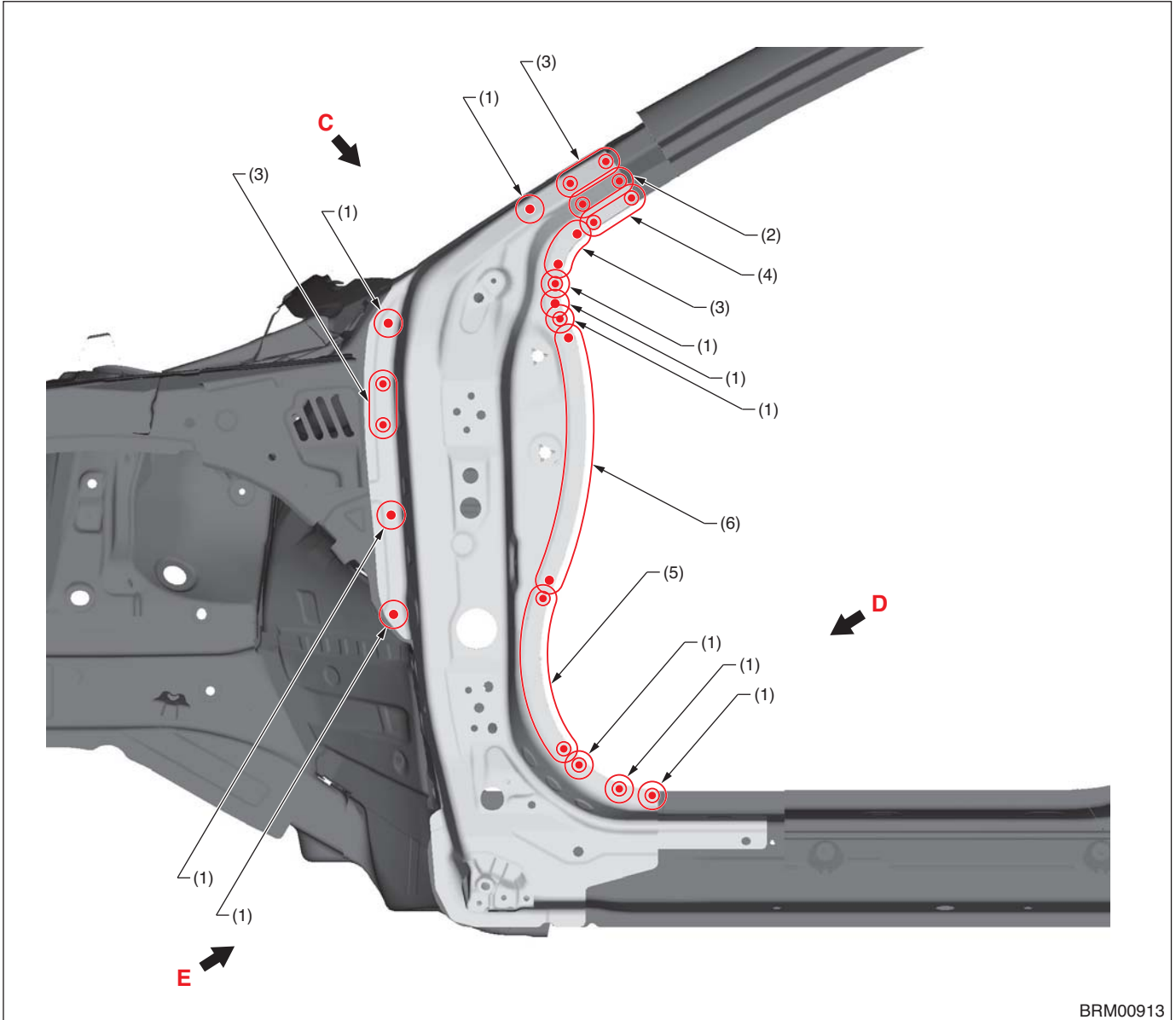


(1) 2 points (bottom · 1)

(2) 1 point (outside · 1)

Panel Replacement

• Overall view 2



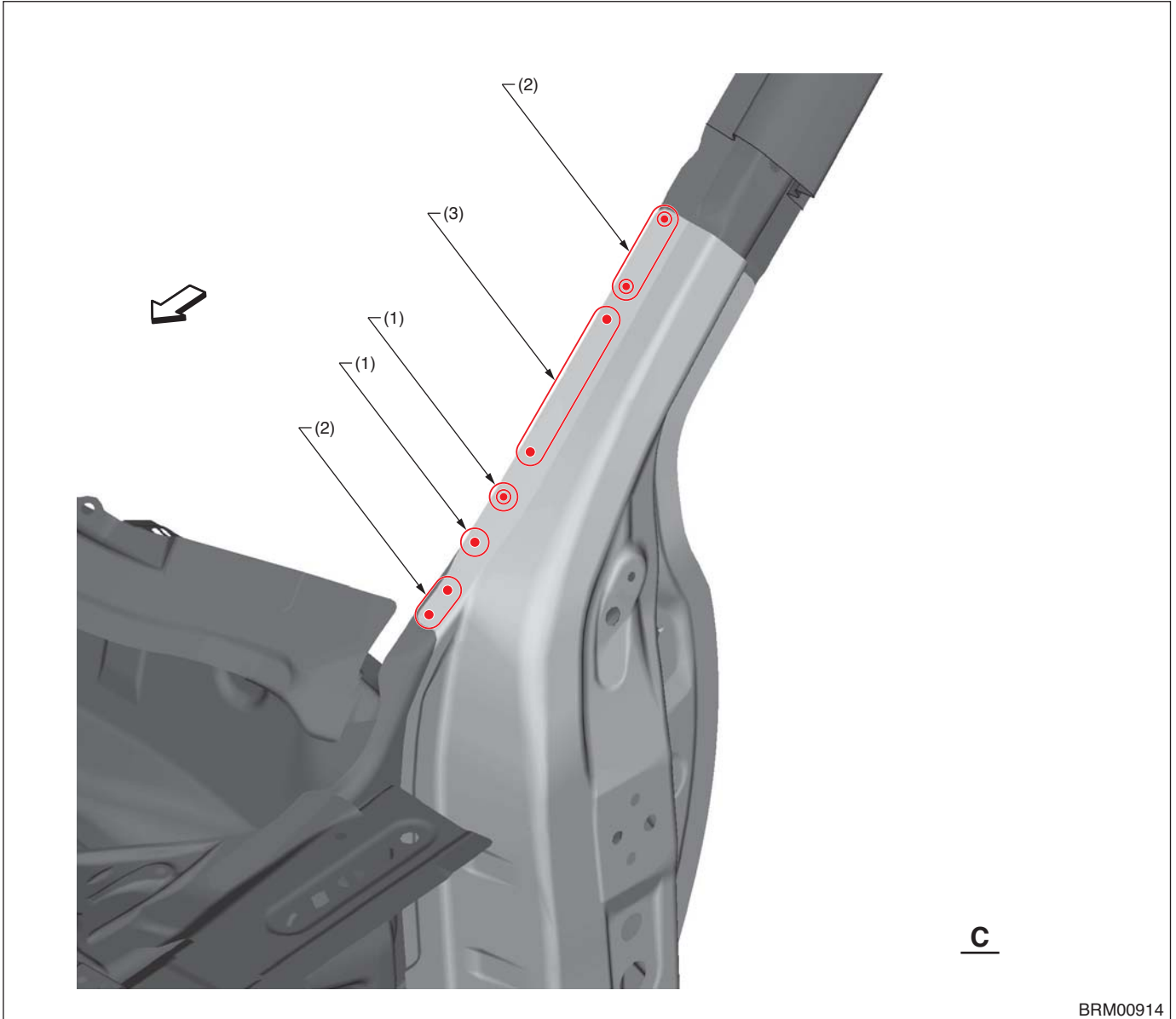
(1) 1 point (outside · 1)
(2) 2 points (bottom · 1)

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

(5) 6 points (outside · 1)
(6) 9 points (outside · 1)

Panel Replacement

• View C



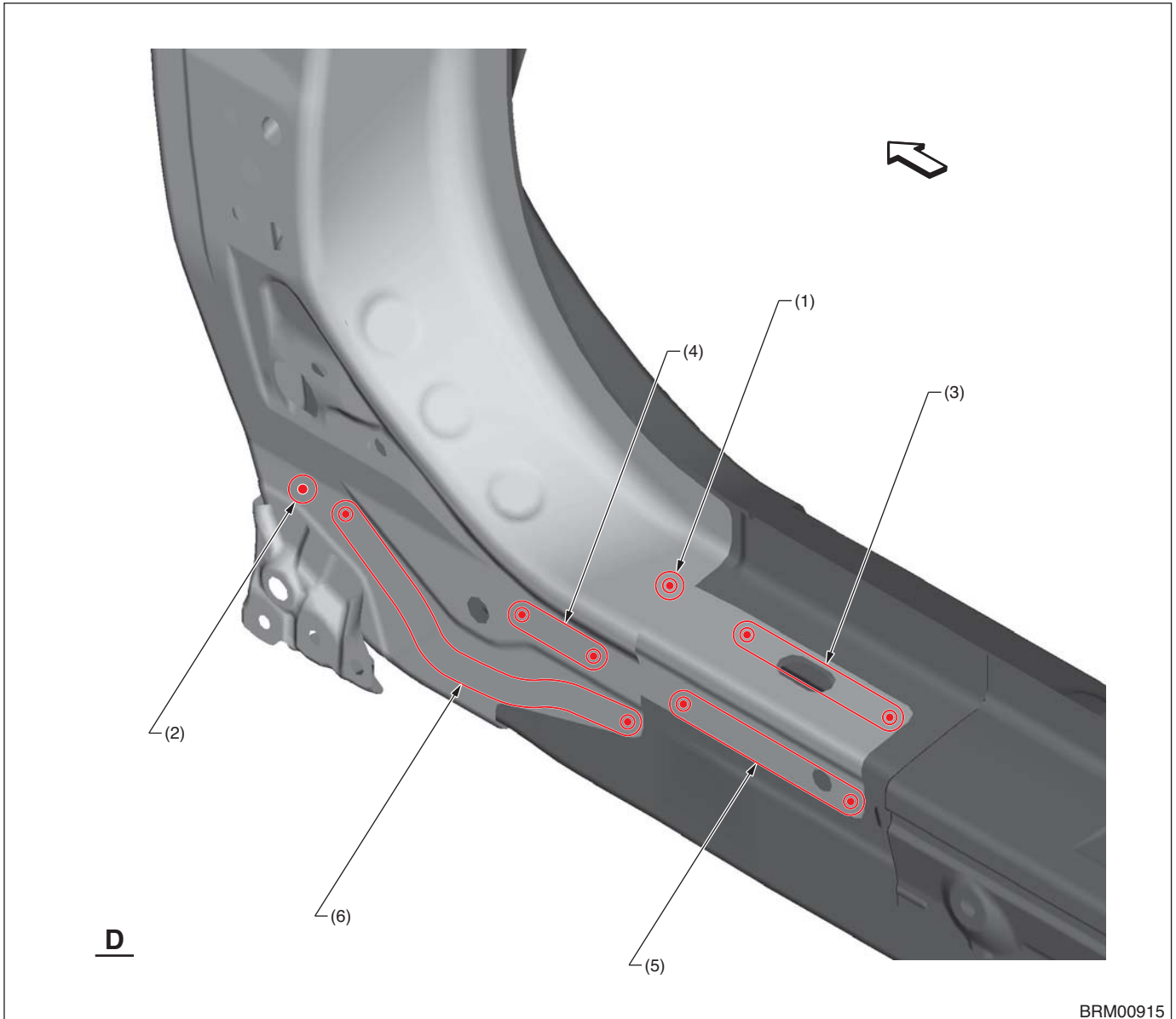
(1) 1 point (top · 1)

(2) 2 points (top · 1)

(3) 4 points (top · 1)

Panel Replacement

• View D



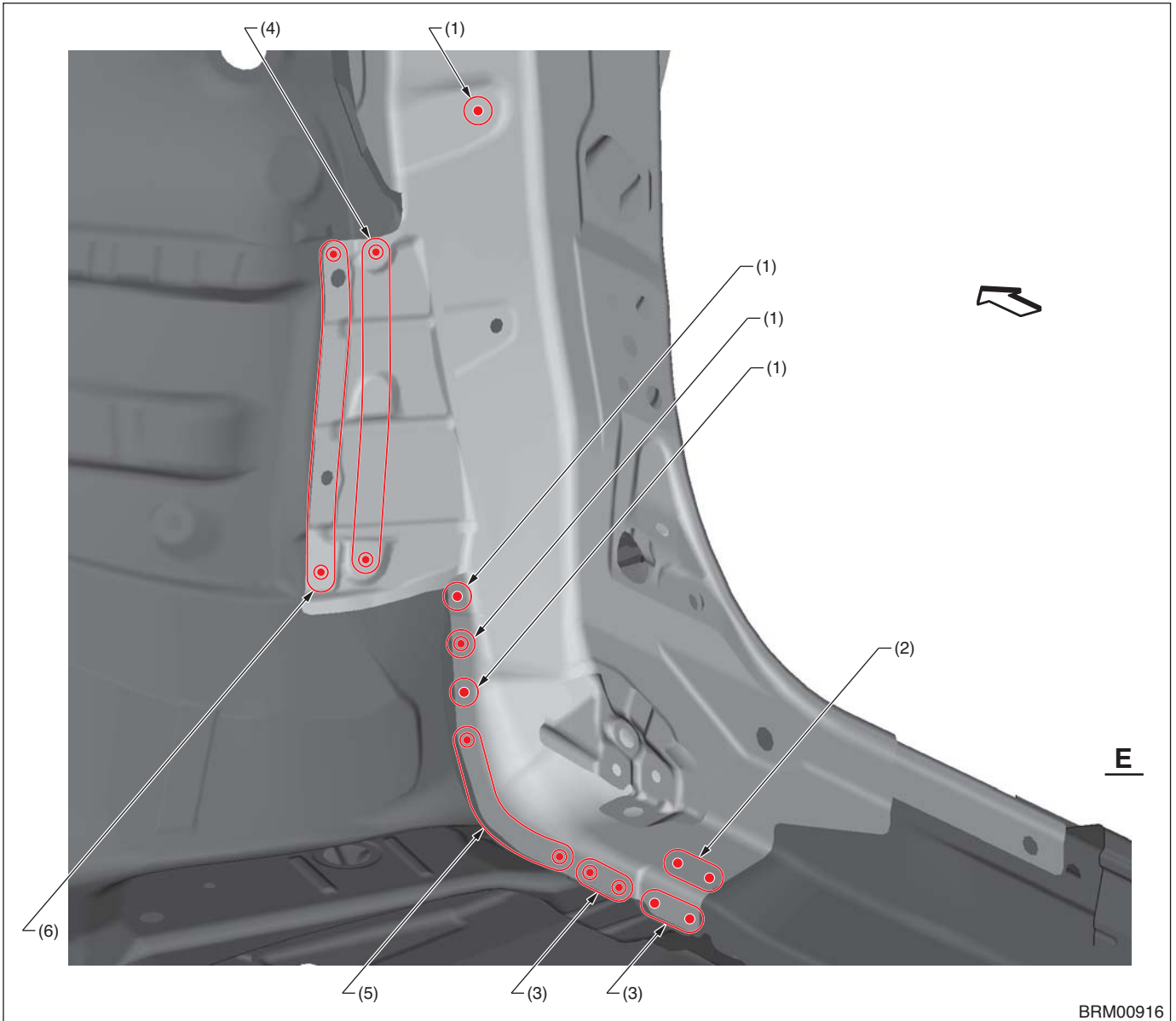
(1) 1 point (top · 2)
(2) 1 point (outside · 1)

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

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

Panel Replacement

• View E



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

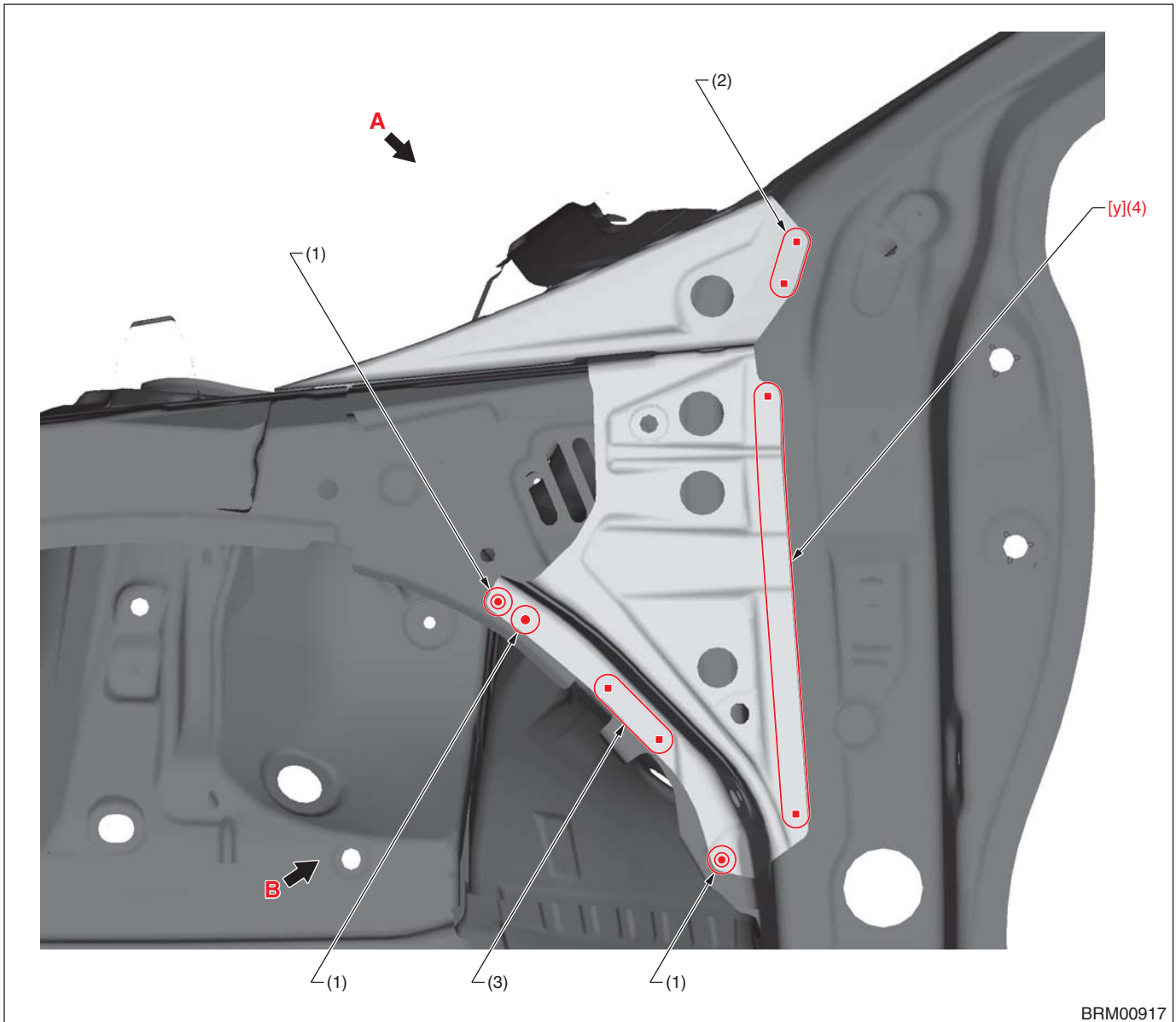
(3) 2 points (outside · 1)
(4) 3 points (outside · 1)

(5) 4 points (outside · 1)
(6) 7 points (outside · 1)

Panel Replacement

B: INSTALLATION

• Overall view 1



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

(3) 3 points (service)

(4) 7 points (service)

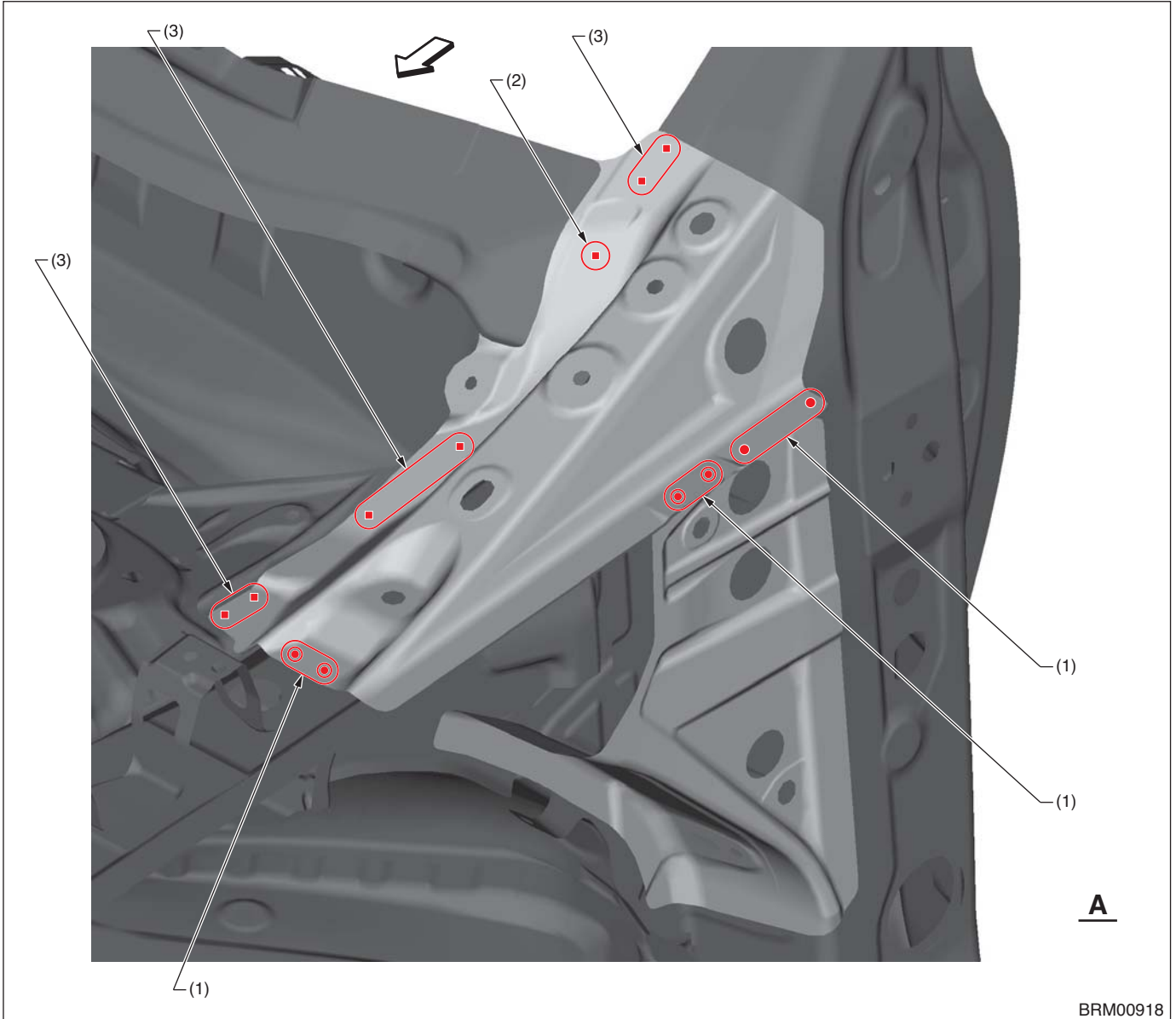
[y] Plug welding

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

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

Panel Replacement

• View A



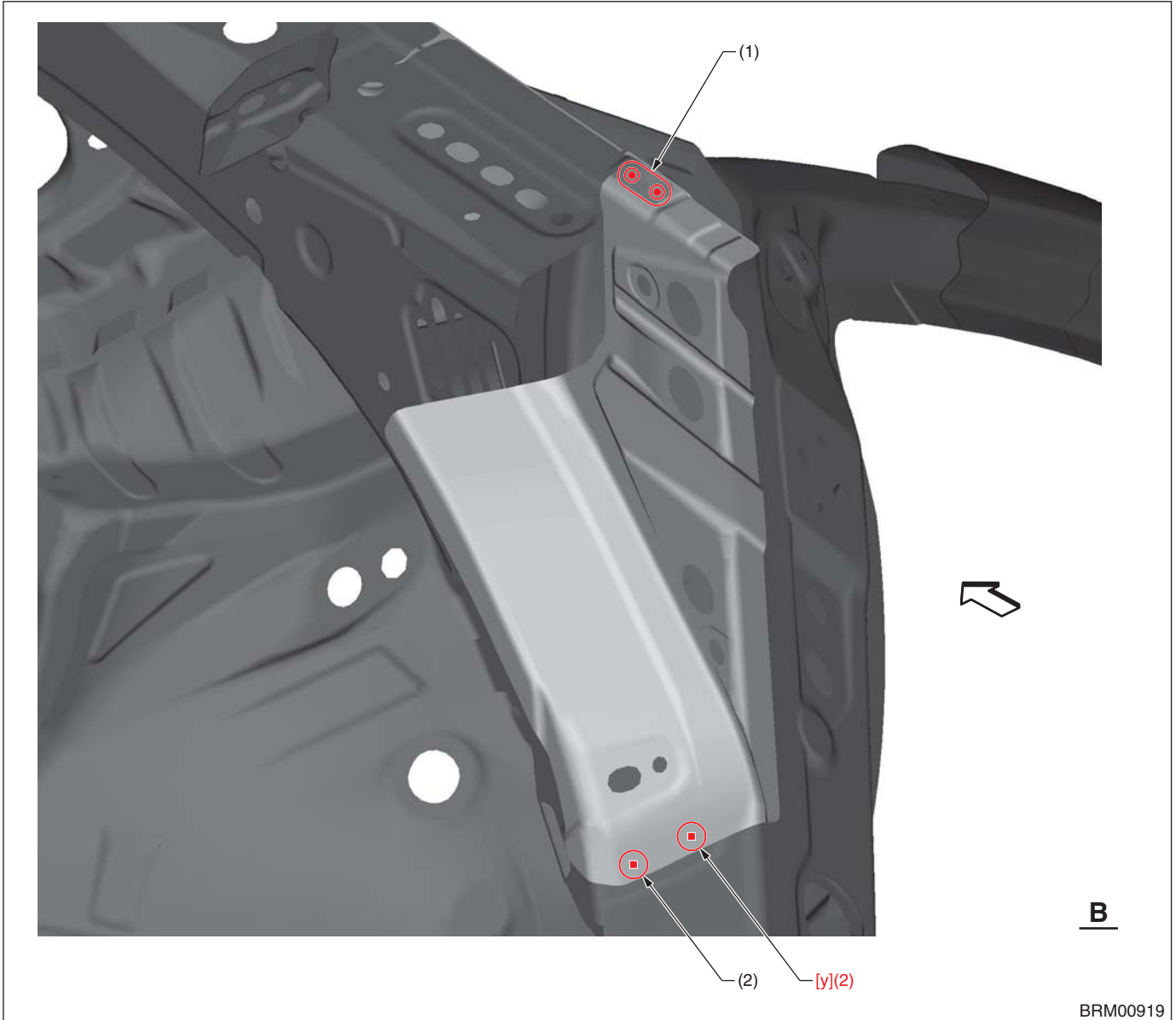
(1) 2 points

(2) 1 point (service)

(3) 2 points (service)

Panel Replacement

• View B



(1) 2 points

(2) 1 point (service)

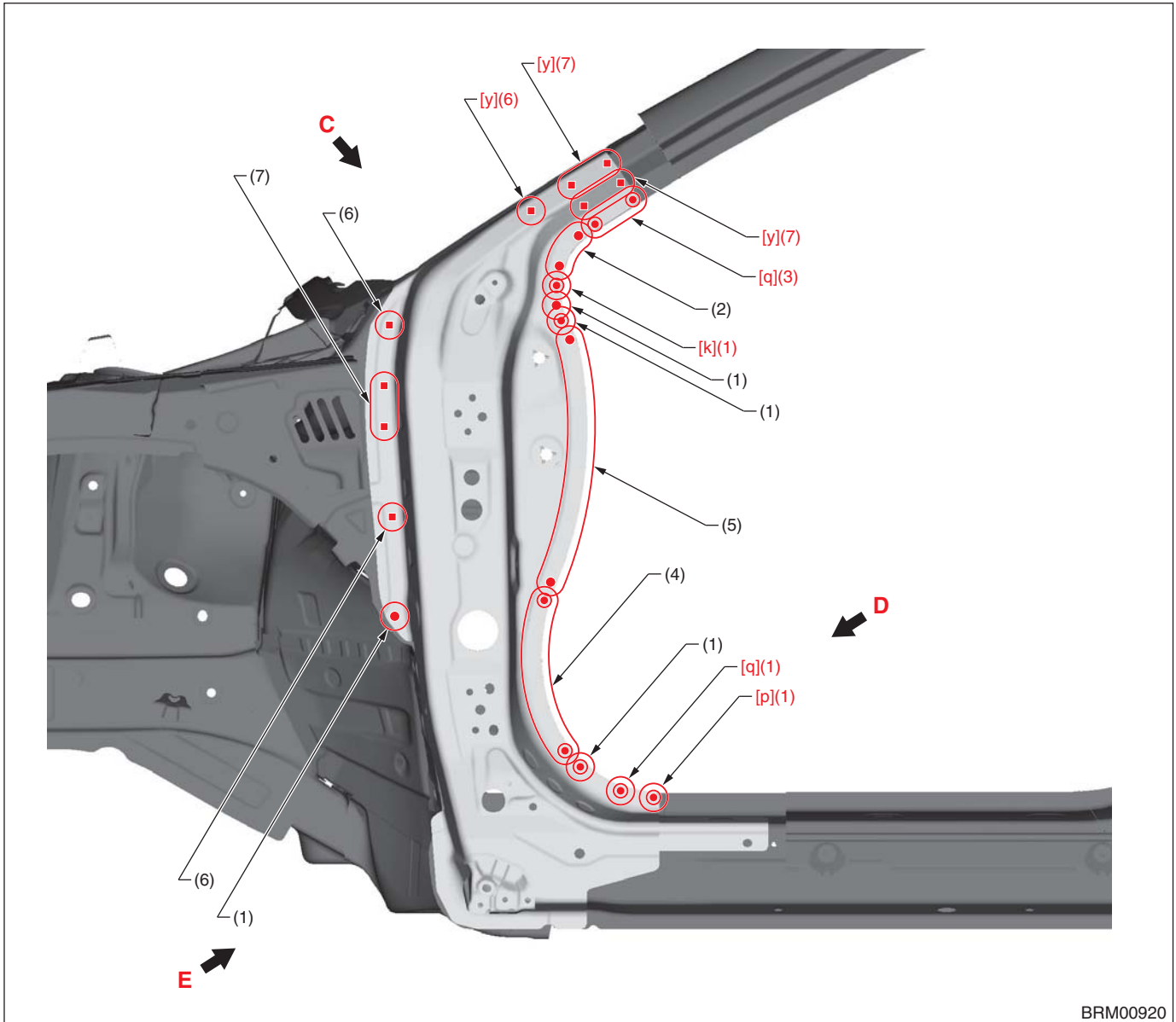
[y] Plug welding

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

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

Panel Replacement

• Overall view 2



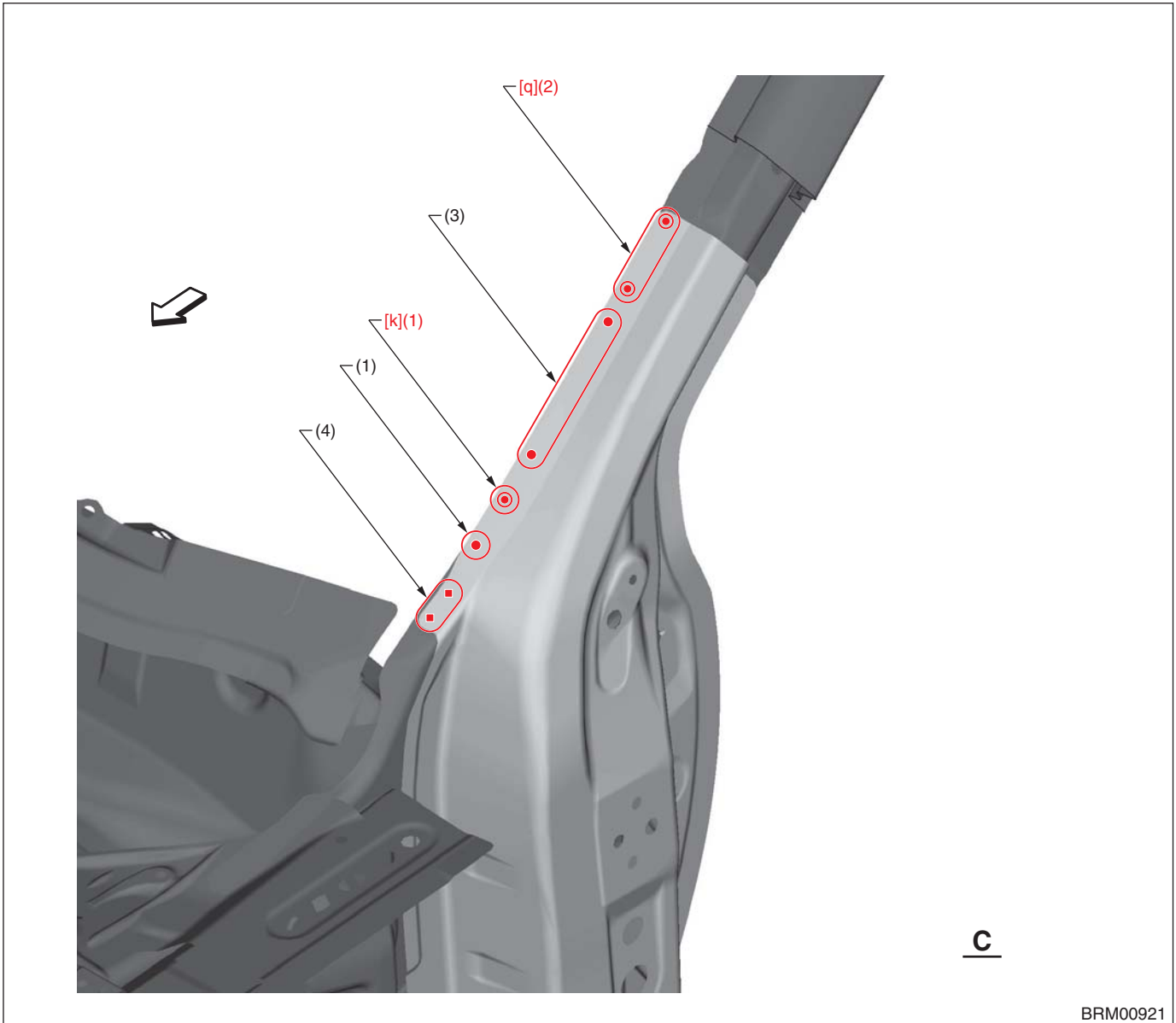
BRM00920

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

[k] Spot welding	Compression: 3.0 kN, Current: 8.0 kA, Welding time: 25 cyc
[p] Spot welding	Compression: 4.0 kN, Current: 8.0 kA, Welding time: 22 cyc
[q] Spot welding	Compression: 4.0 kN, Current: 8.0 kA, Welding time: 25 cyc
[y] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO ₂ B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO ₂ : 20 %)

Panel Replacement

• View C



BRM00921

(1) 1 point
(2) 2 points

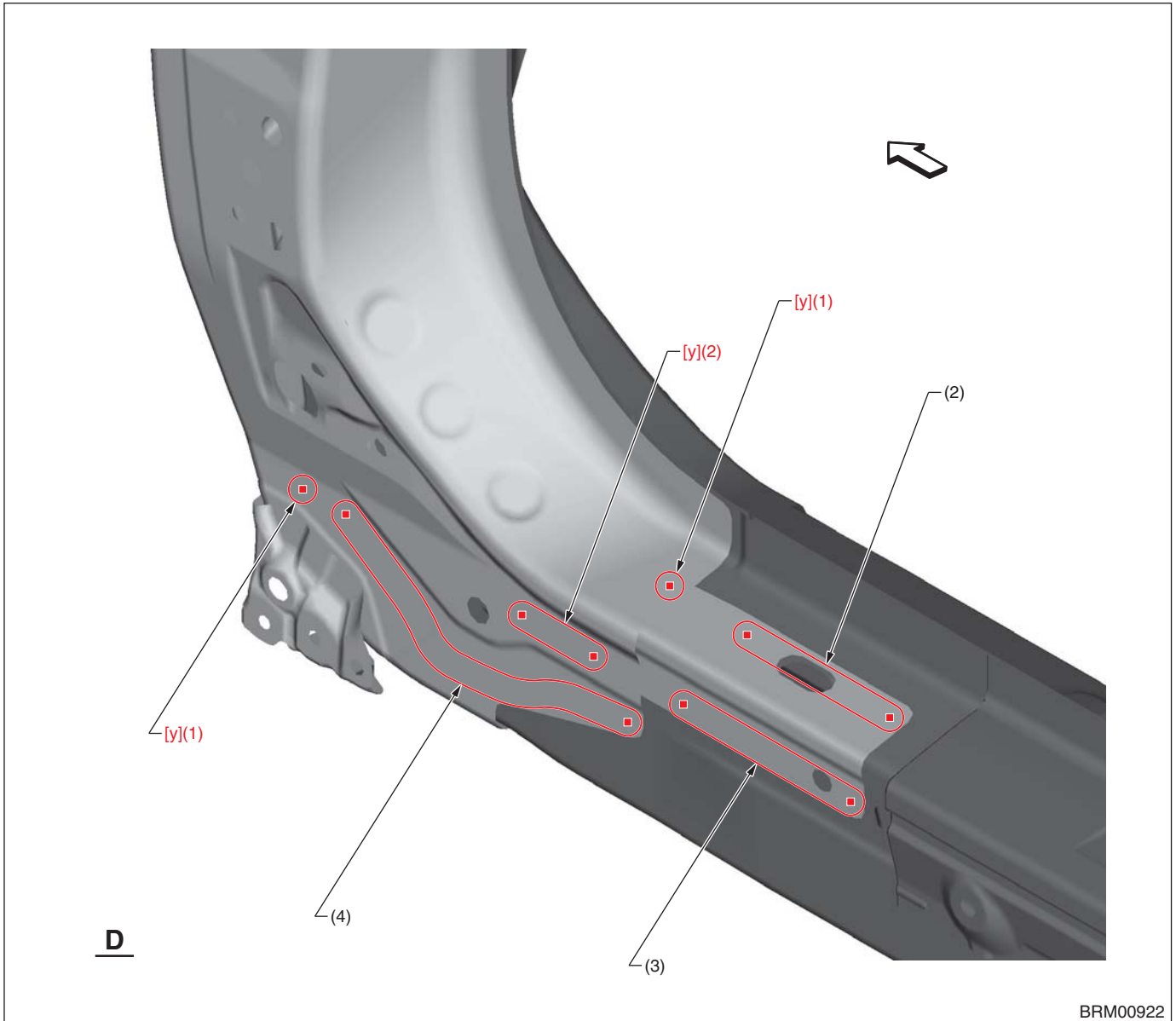
(3) 4 points

(4) 2 points (service)

[k] Spot welding	Compression: 3.0 kN, Current: 8.0 kA, Welding time: 25 cyc
[q] Spot welding	Compression: 4.0 kN, Current: 8.0 kA, Welding time: 25 cyc

Panel Replacement

• View D



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

(3) 3 points (service)

(4) 6 points (service)

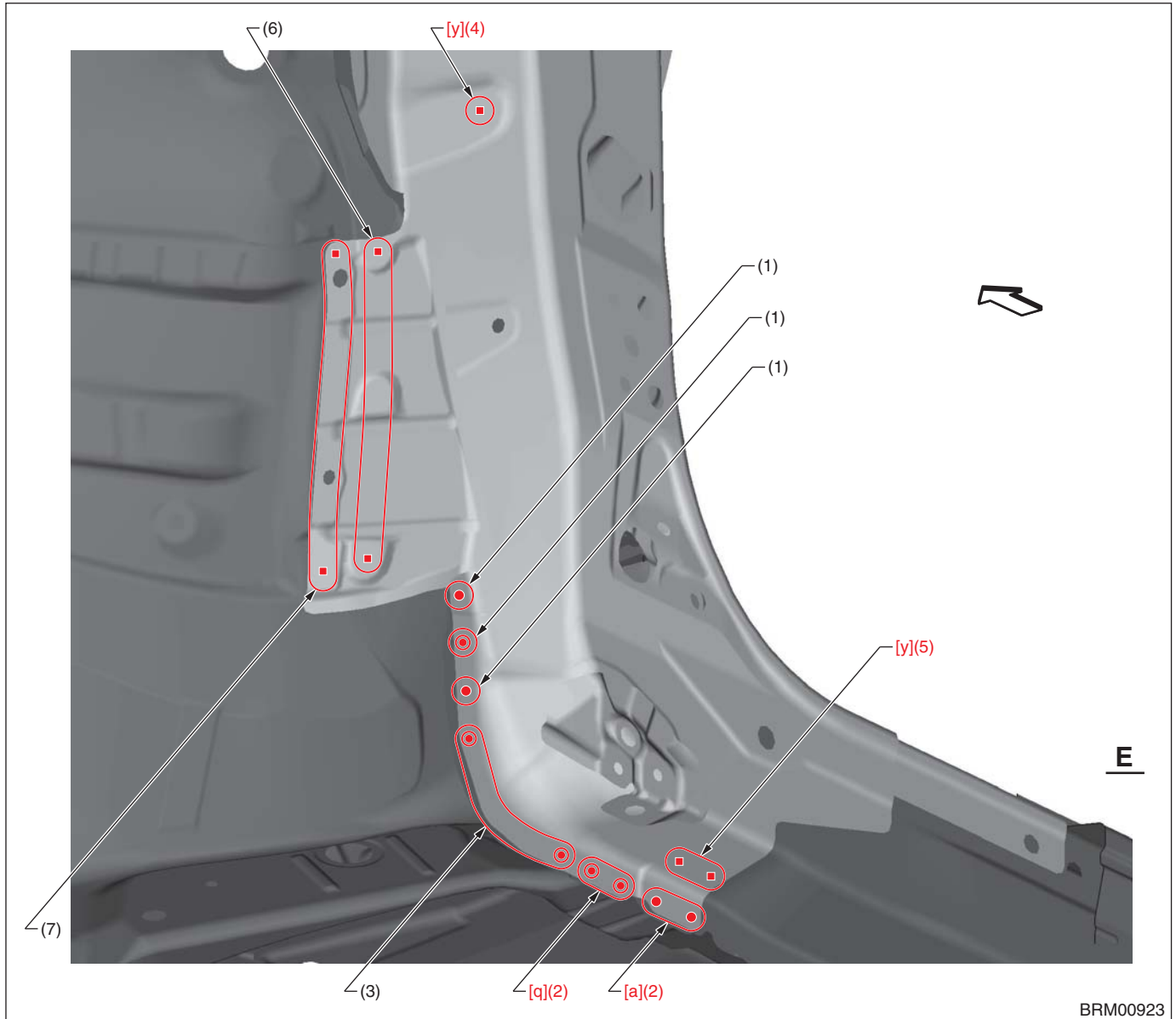
[y] Plug welding

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

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

Panel Replacement

• View E



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

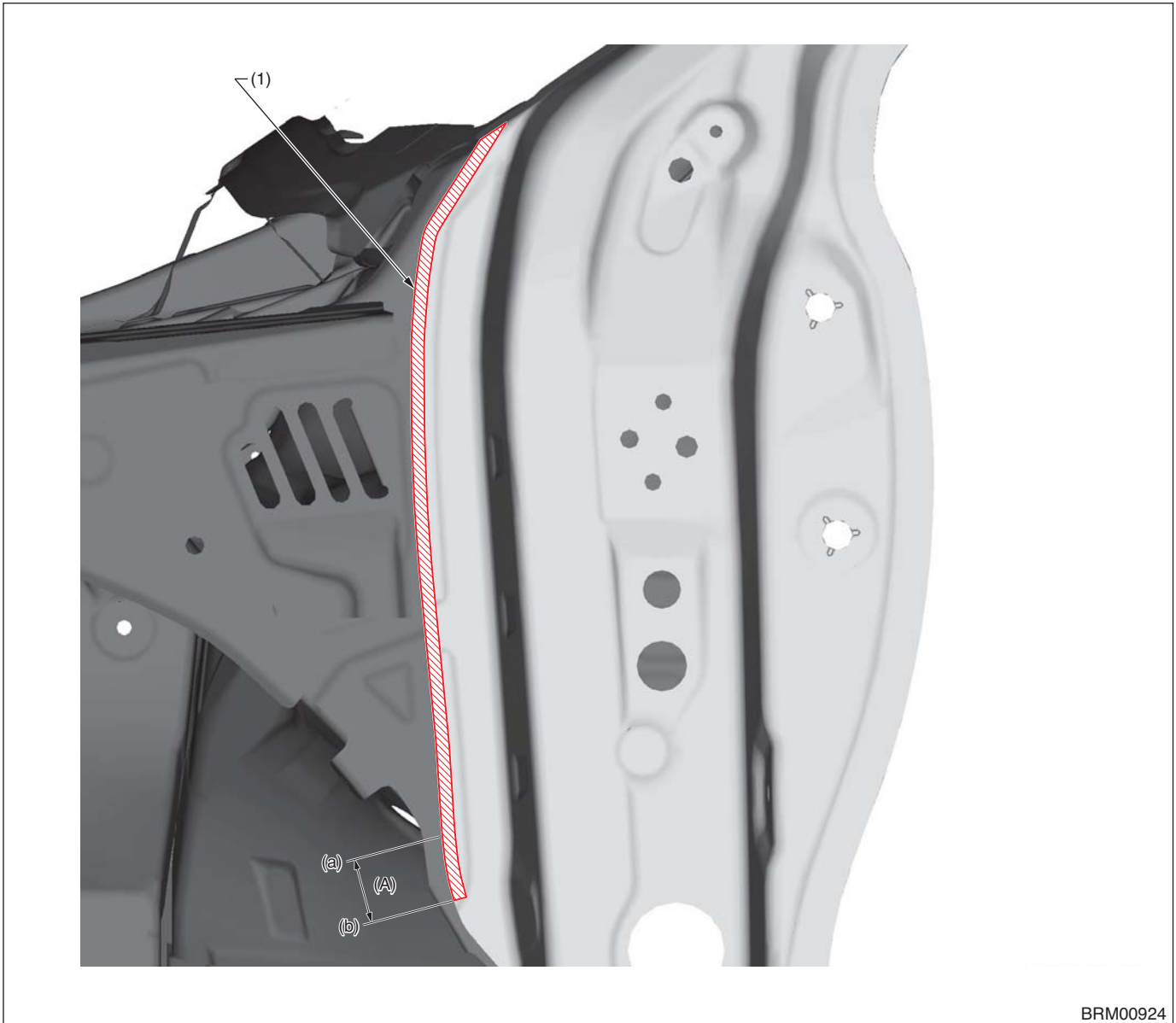
- (4) 1 point (service)
- (5) 2 points (service)
- (6) 3 points (service)

- (7) 7 points (service)

[a] Spot welding	Compression: 3.5 kN, Current: 7.5 kA, Welding time: 16 cyc
[q] Spot welding	Compression: 4.0 kN, Current: 8.0 kA, Welding time: 25 cyc
[y] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO ₂ B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO ₂ : 20 %)

Panel Replacement

• Overall view 3




BRM00924

(A) 31 mm [1.22 in]

(a) A point

(b) B point

(1) Spotting sealer

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

Note:

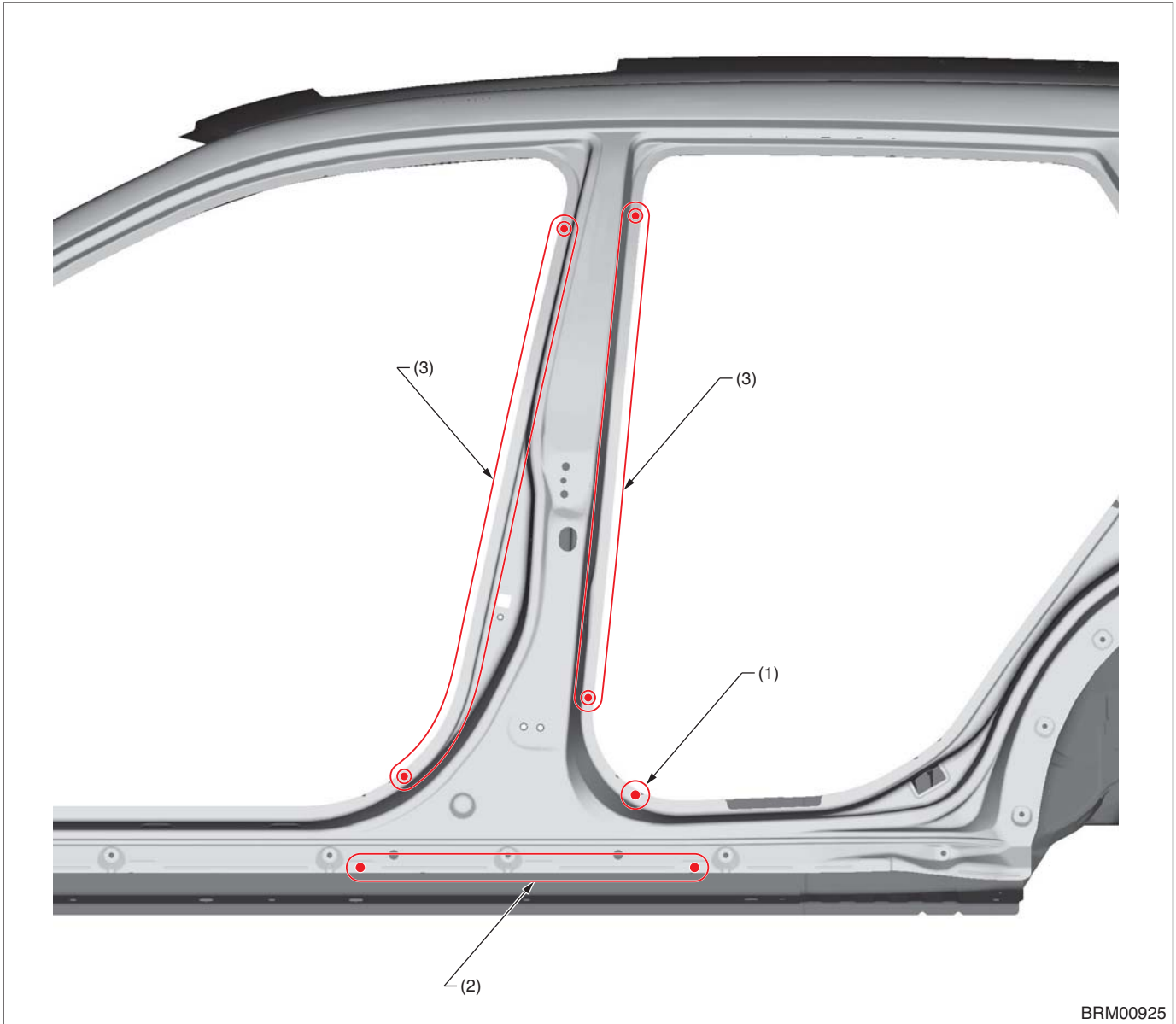
- Fill spotting sealer between the pillar front inner center and reinforcement pillar front outer.
- Fill spotting sealer between the pillar front inner lower and reinforcement pillar front outer.
- Check for stray sealer in between (b) and (c).

Panel Replacement

8-9. Center Pillar Outer Panel (Partial replacement)

A: REMOVAL

- Overall view 1



BRM00925

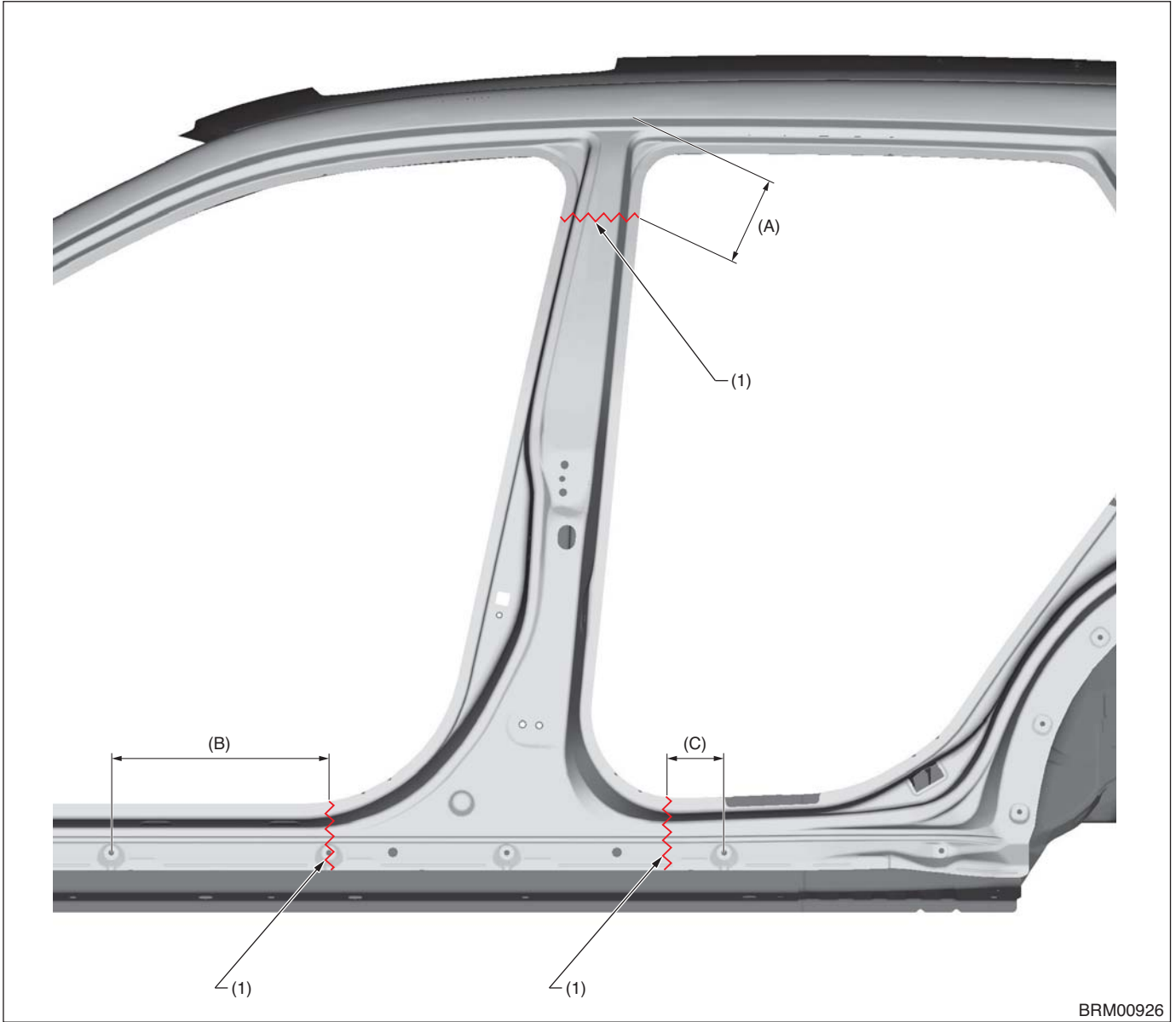
(1) 1 point (outside - 1)

(2) 3 points (outside - 1)

(3) 11 points (outside - 1)

Panel Replacement

• Overall view 2



(A) 165 mm [6.50 in]

(B) 340 mm [13.39 in]

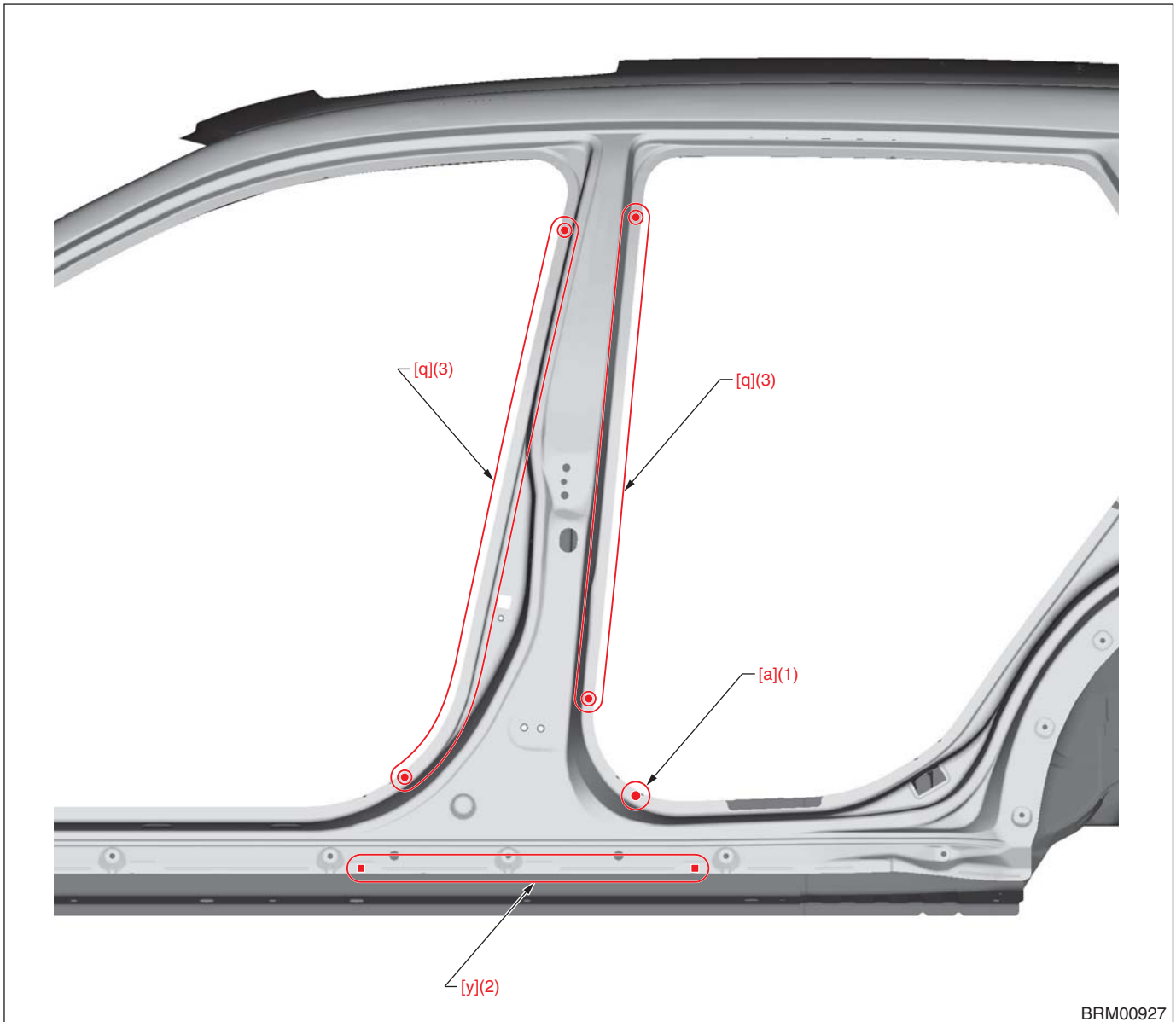
(C) 86 mm [3.39 in]

(1) Cut position

Panel Replacement

B: INSTALLATION

• Overall view 1



(1) 1 point

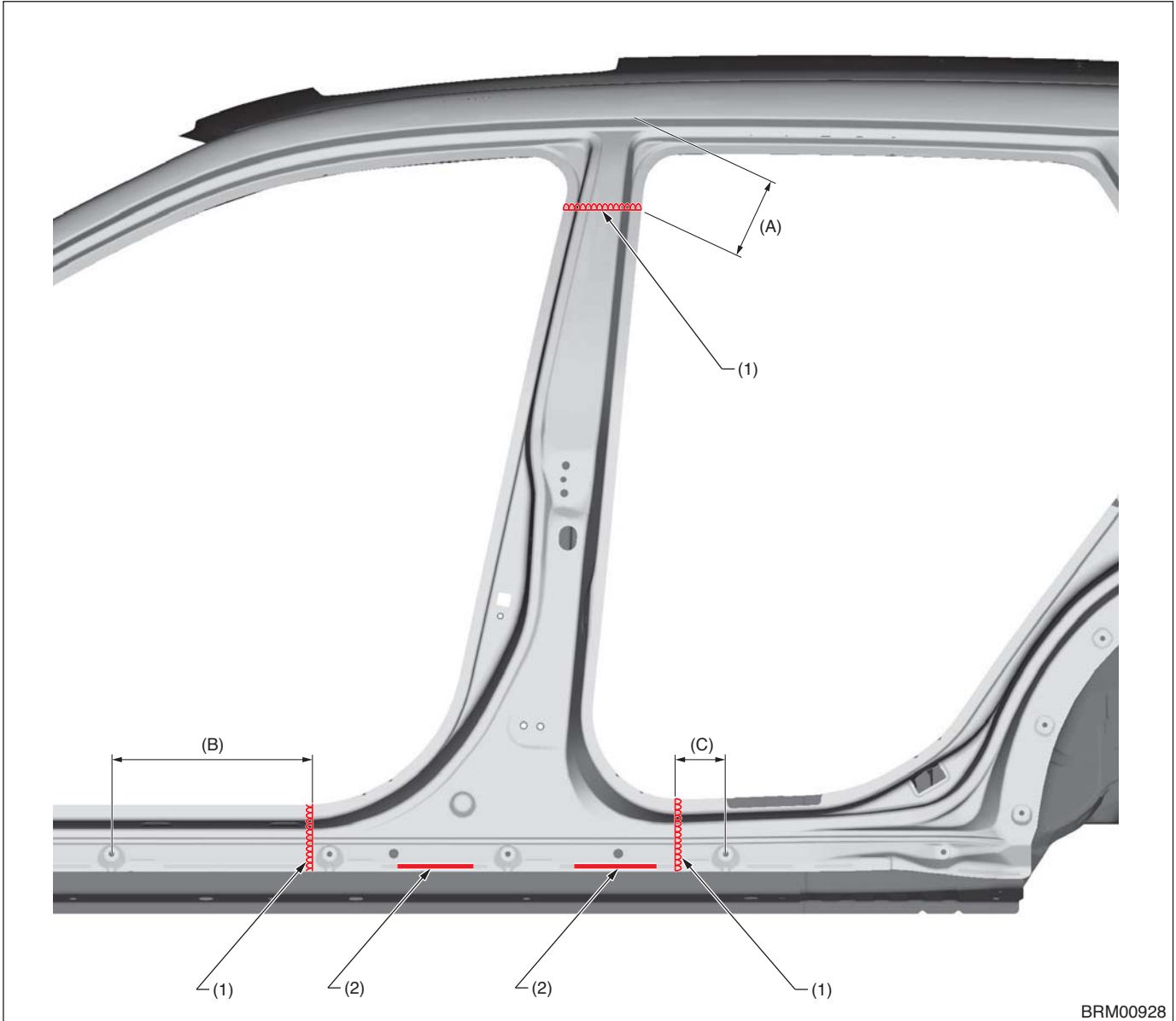
(2) 3 points (service)

(3) 11 points

[a] Spot welding	Compression: 3.5 kN, Current: 7.5 kA, Welding time: 16 cyc
[q] Spot welding	Compression: 4.0 kN, Current: 8.0 kA, Welding time: 25 cyc
[y] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO ₂ B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO ₂ : 20 %)

Panel Replacement

• Overall view 2



BRM00928

(A) 140 mm [5.51 in]

(B) 310 mm [12.20 in]

(C) 76 mm [2.99 in]

(1) 1 point (Continuous welding)

(2) Structural adhesive

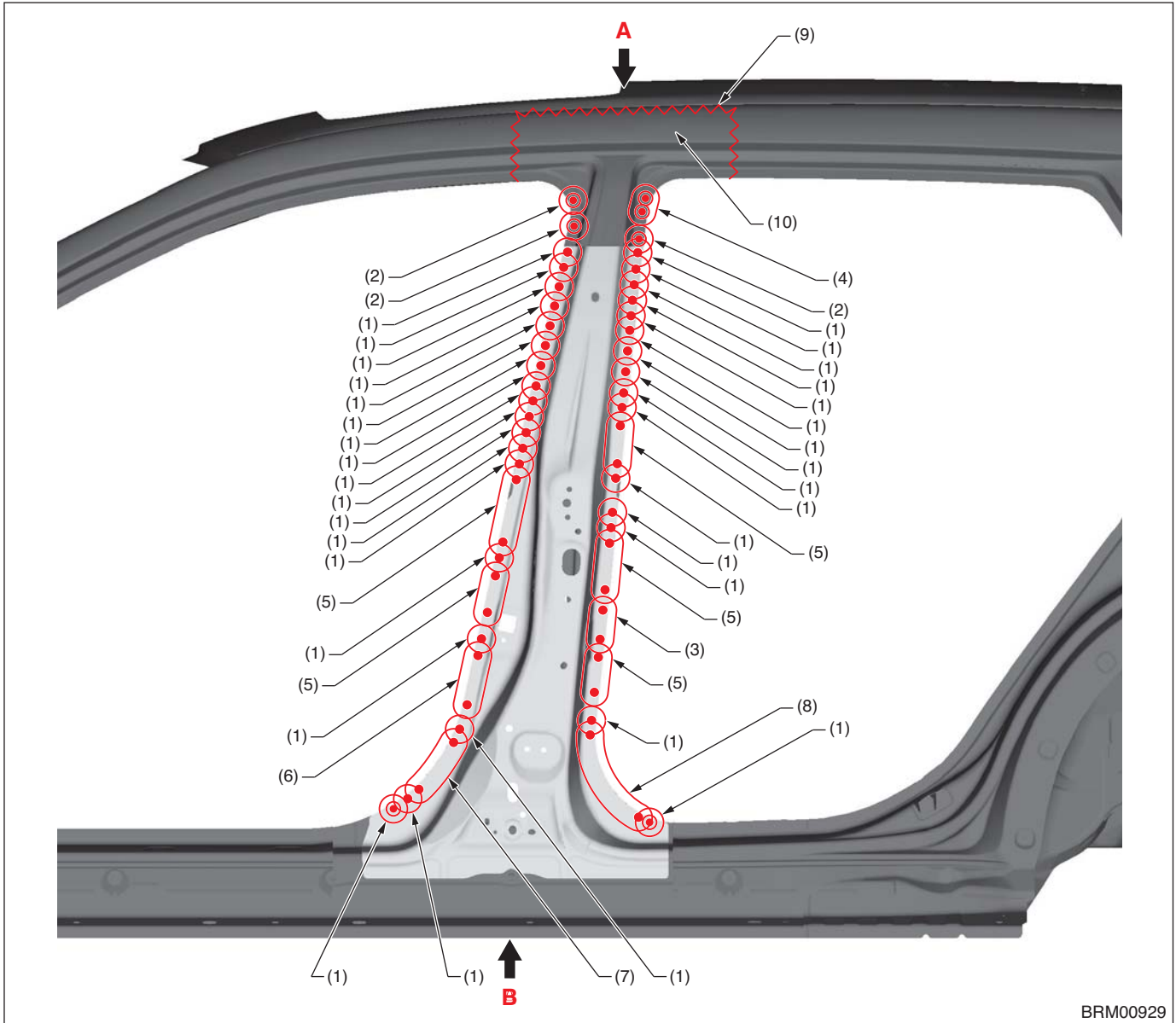
— : Structural adhesive application location (Panel bond mini 38315 made by 3M or equivalent)

Panel Replacement

8-10. Center Pillar Reinforcement Outer (Total replacement)

A: REMOVAL

• Overall view



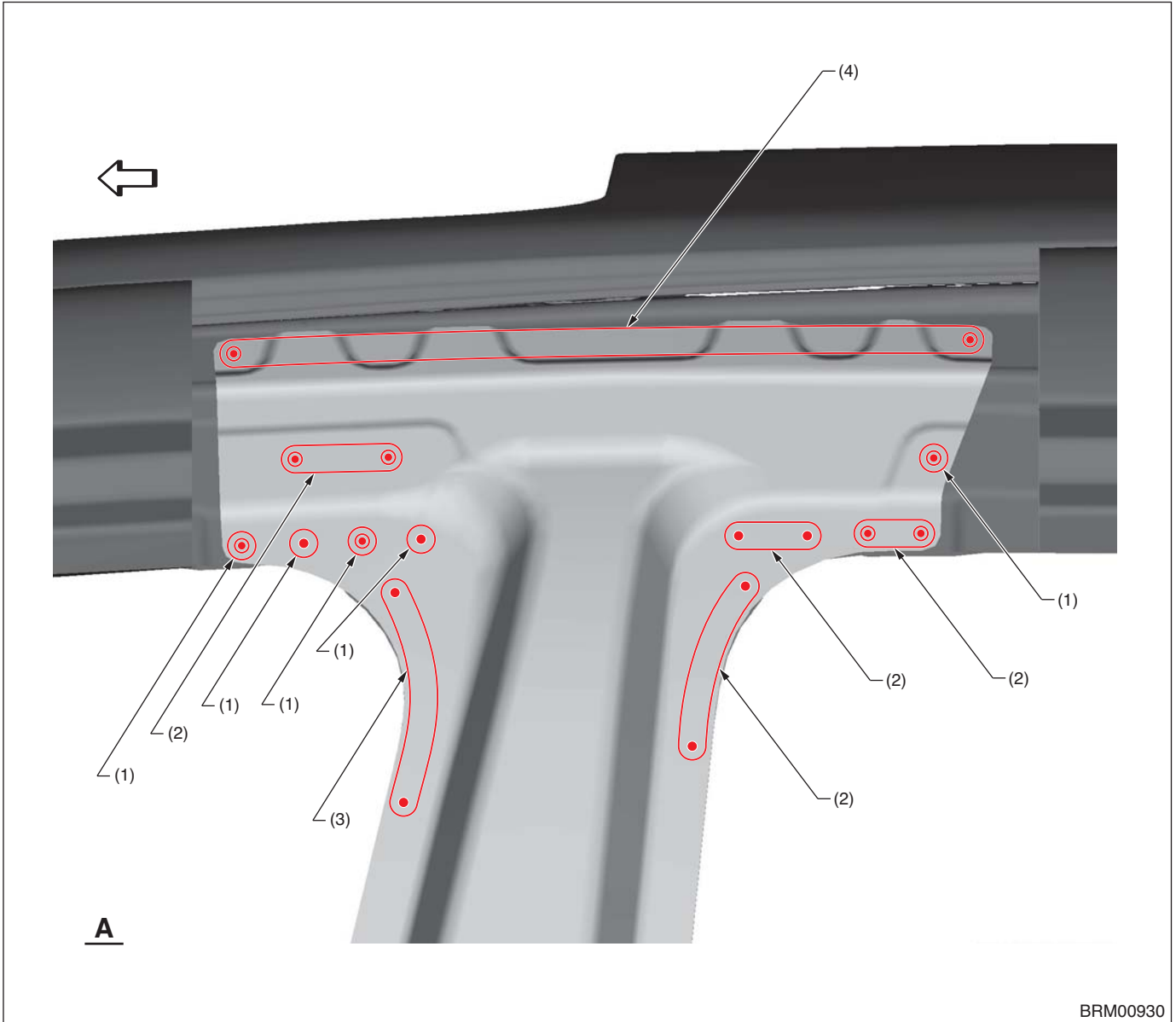
BRM00929

- | | | |
|----------------------------|----------------------------|-----------------------------------|
| (1) 1 point (outside · 1) | (5) 3 points (outside · 1) | (9) Rough cutting |
| (2) 1 point (outside · 2) | (6) 4 points (outside · 1) | (10) The part that can be reused. |
| (3) 2 points (outside · 1) | (7) 5 points (outside · 1) | |
| (4) 2 points (outside · 2) | (8) 6 points (outside · 1) | |

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

Panel Replacement

• View A



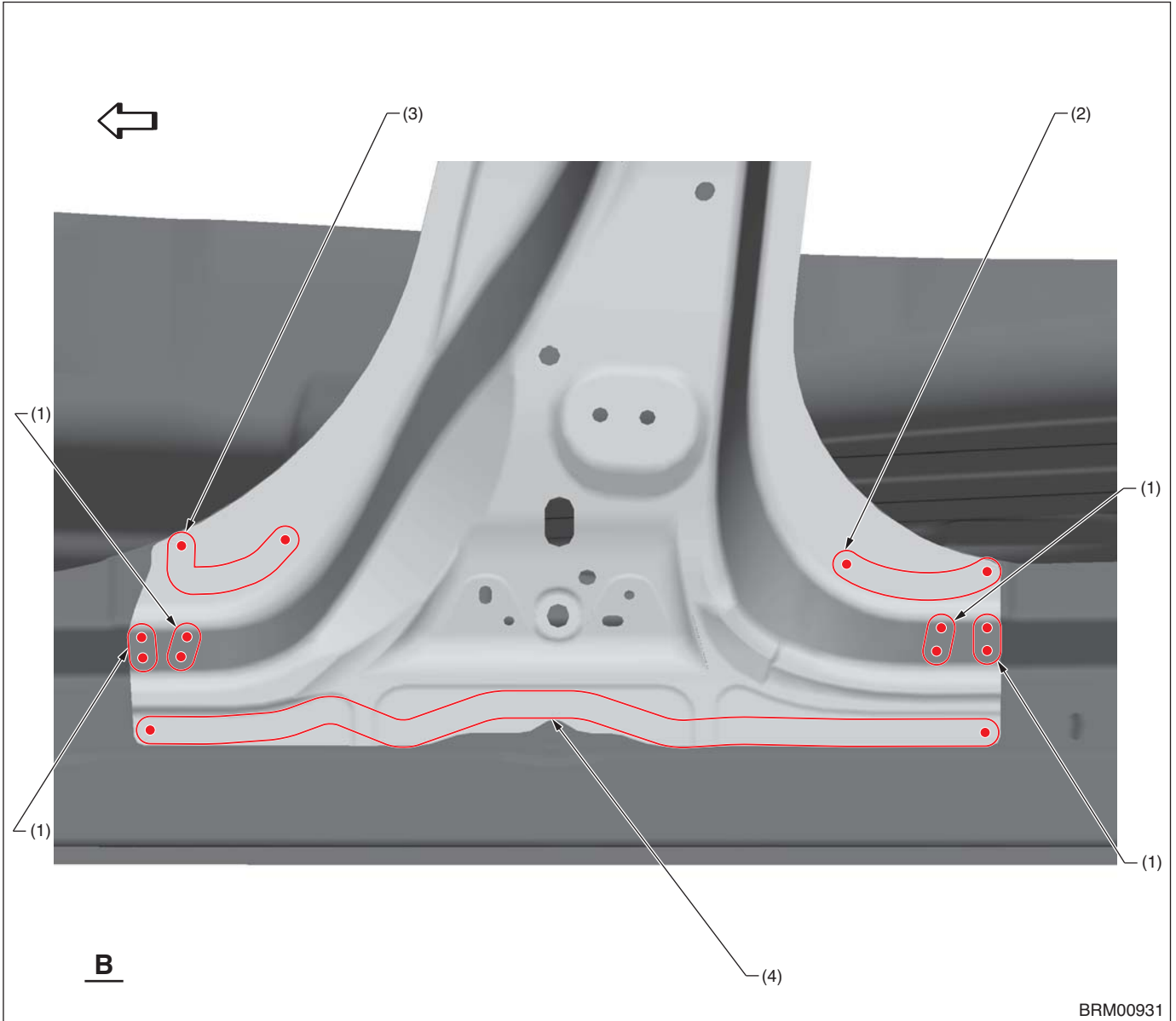
(1) 1 point (outside · 1)
(2) 2 points (outside · 1)

(3) 3 points (outside · 1)

(4) 6 points (outside · 1)

Panel Replacement

• View B



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

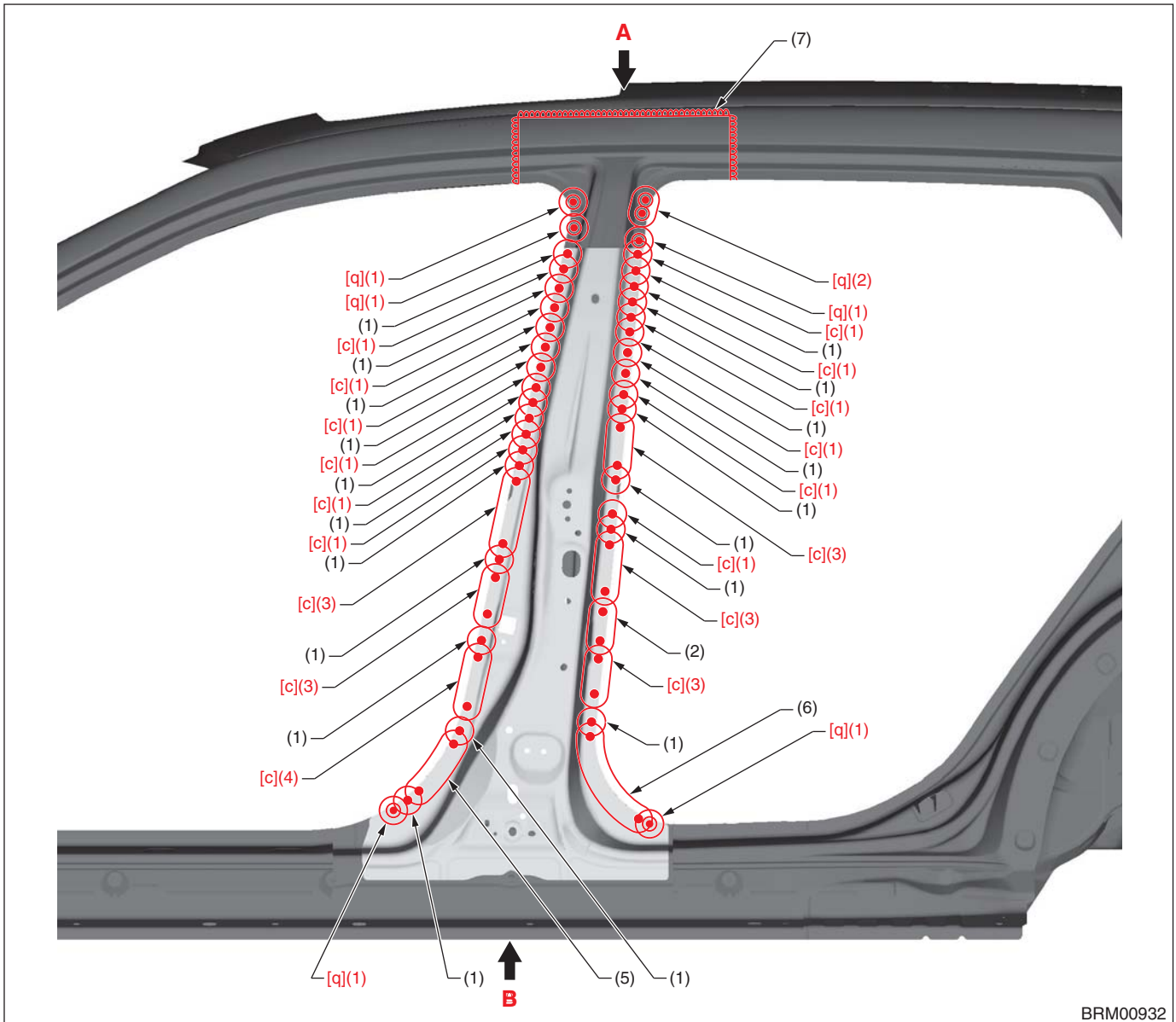
- (3) 5 points (outside · 1)

- (4) 13 points (outside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



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

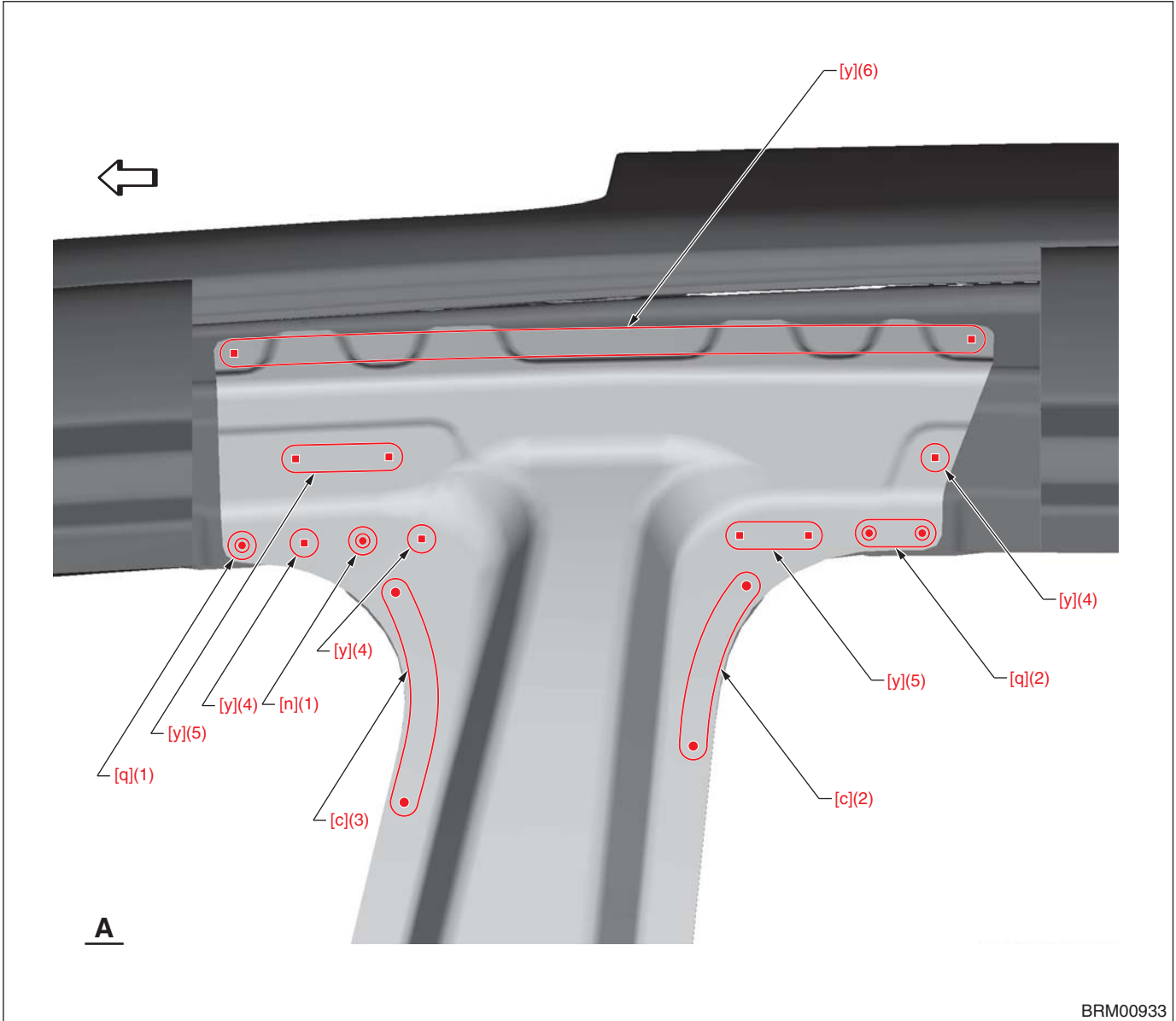
- (4) 4 points
- (5) 5 points
- (6) 6 points

- (7) 1 point (Continuous welding)

[c] Spot welding	Compression: 4.0 kN, Current: 8.0 kA, Welding time: 22 cyc
[q] Spot welding	Compression: 4.0 kN, Current: 8.0 kA, Welding time: 25 cyc

Panel Replacement

• View A



(1) 1 point
(2) 2 points

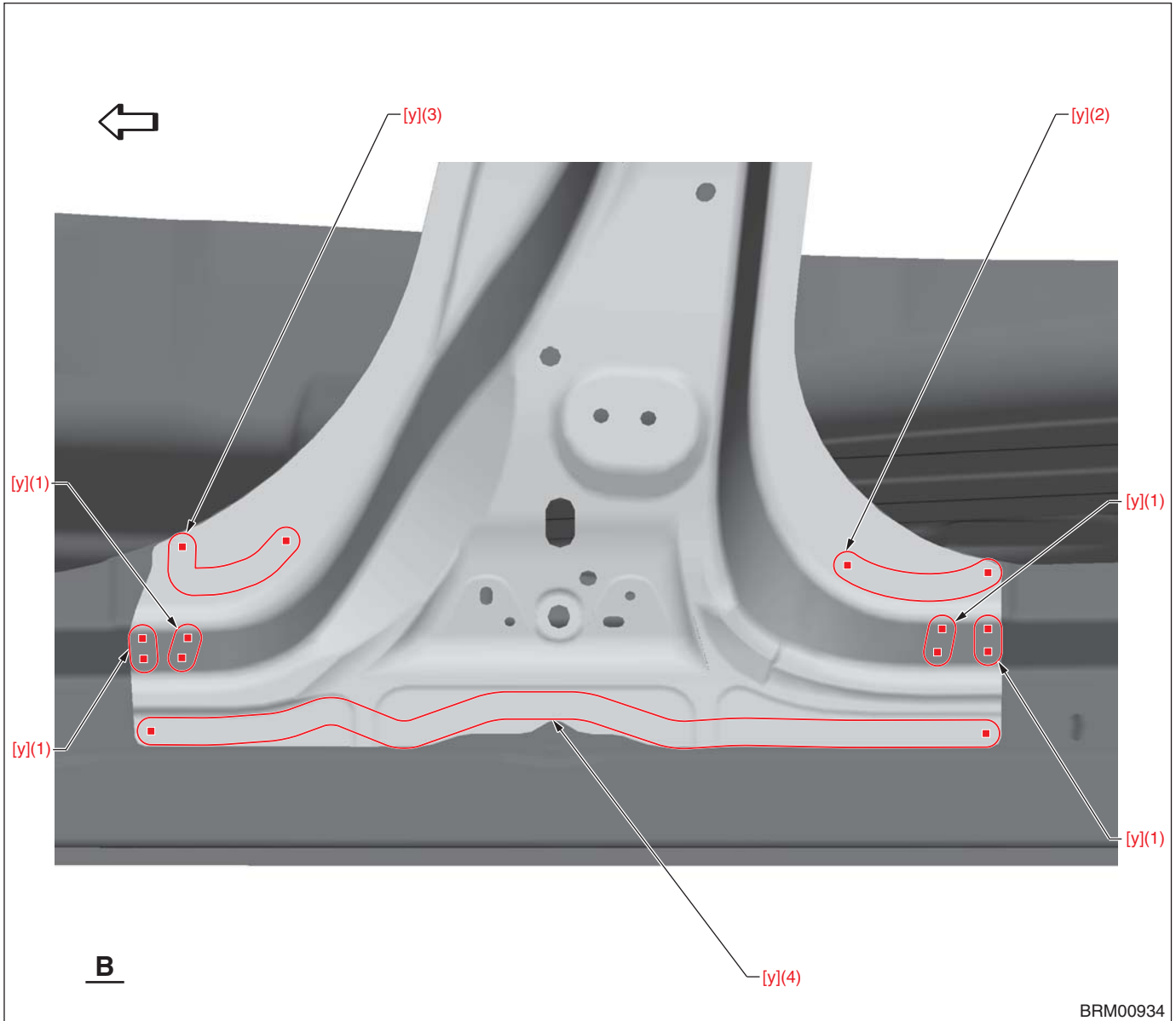
(3) 3 points
(4) 1 point (service)

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

[c] Spot welding	Compression: 4.0 kN, Current: 8.0 kA, Welding time: 22 cyc
[n] Spot welding	Compression: 4.0 kN, Current: 7.5 kA, Welding time: 30 cyc
[q] Spot welding	Compression: 4.0 kN, Current: 8.0 kA, Welding time: 25 cyc
[y] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO ₂ B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO ₂ : 20 %)

Panel Replacement

• View B



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

(3) 5 points (service)

(4) 13 points (service)

[y] Plug welding

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

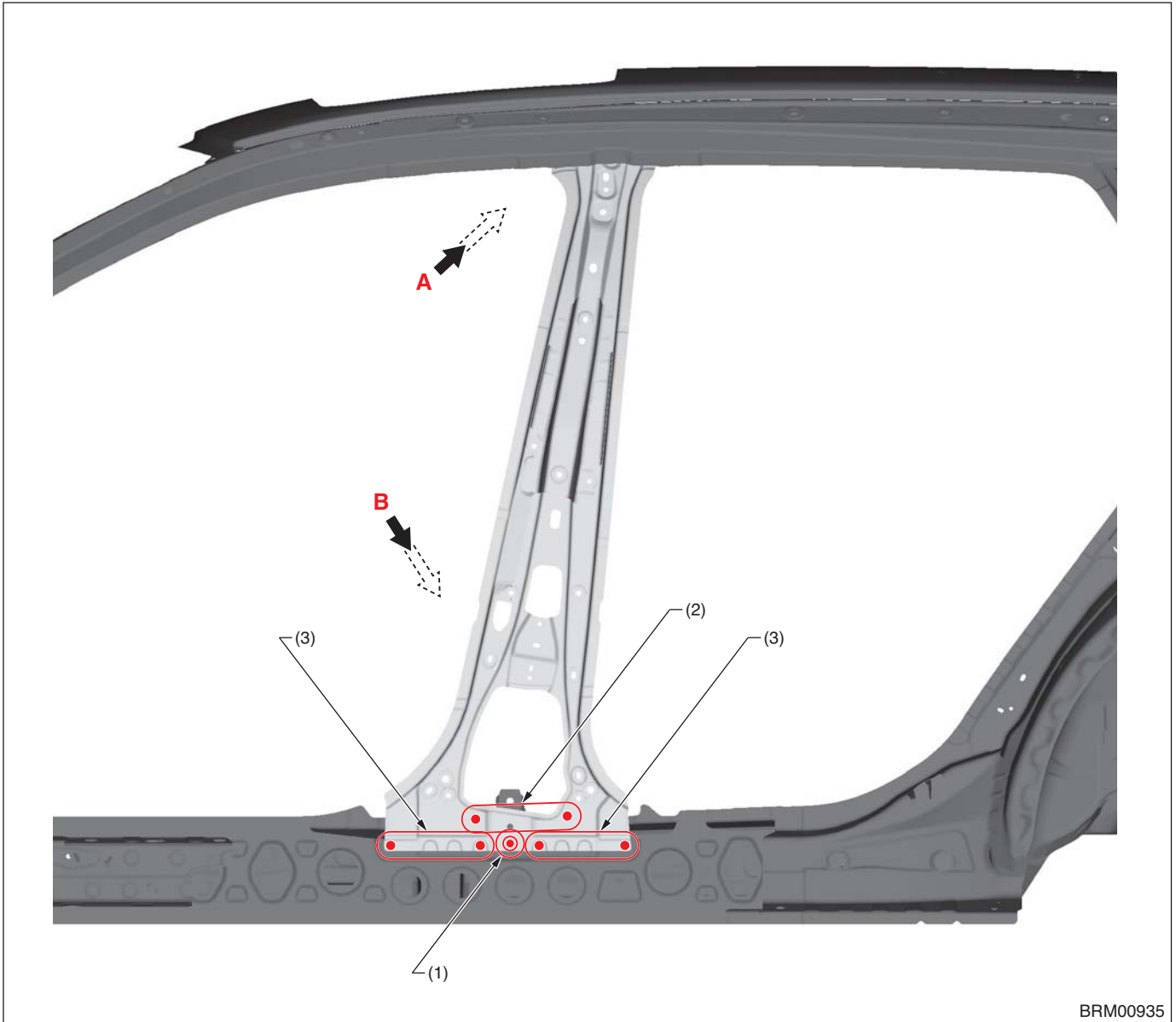
B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO₂: 20 %)

Panel Replacement

8-11. Center Pillar Inner (Total replacement)

A: REMOVAL

- Overall view



BRM00935

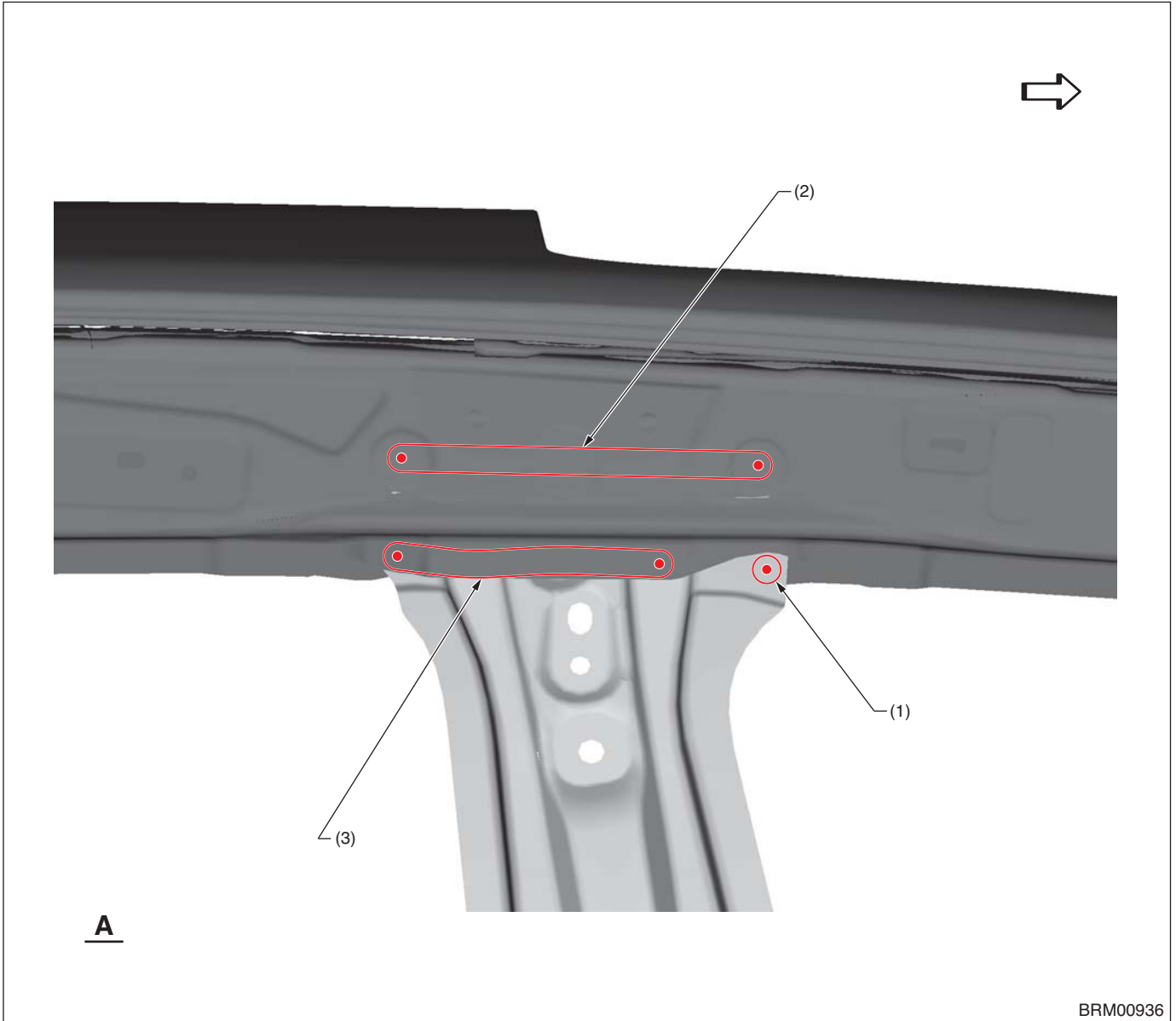
(1) 1 point (outside · 1)

(2) 2 points (outside · 1)

(3) 5 points (outside · 1)

Panel Replacement

• View A



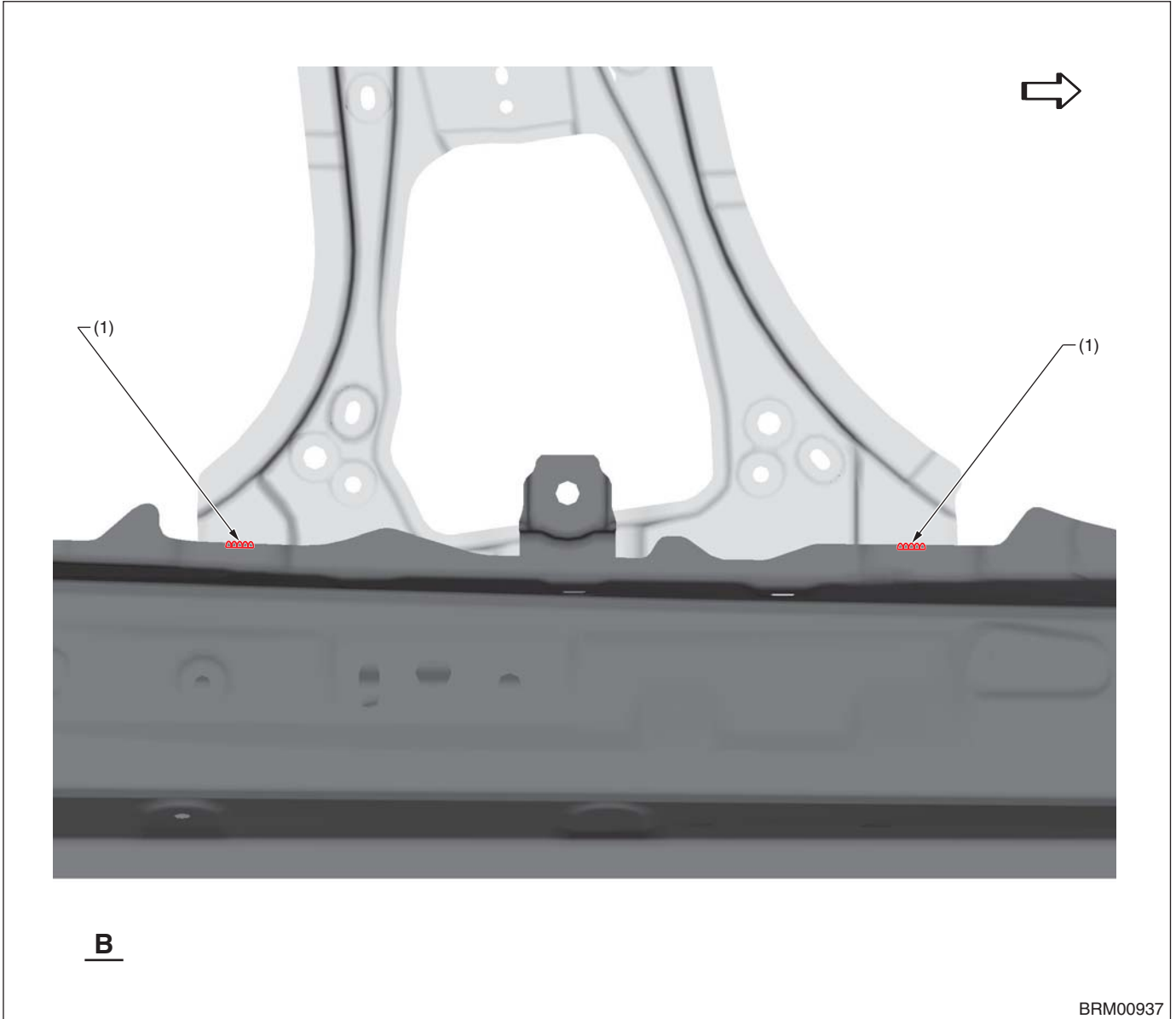
(1) 1 point (inside · 1)

(2) 3 points (inside · 1)

(3) 4 points (inside · 1)

Panel Replacement

• View B

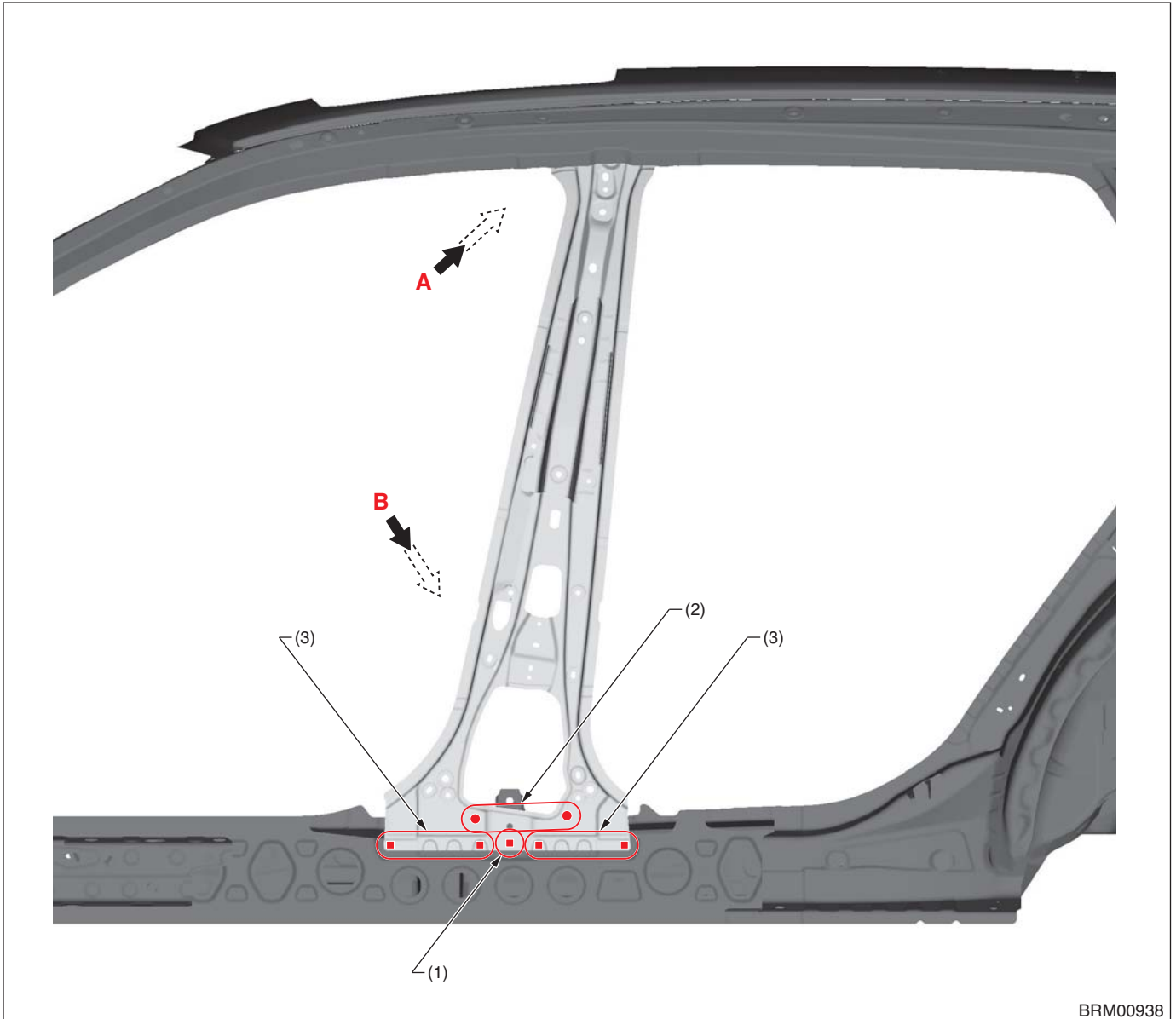


(1) 1 point (inside · 1 belt sander)

Panel Replacement

B: INSTALLATION

• Overall view



BRM00938

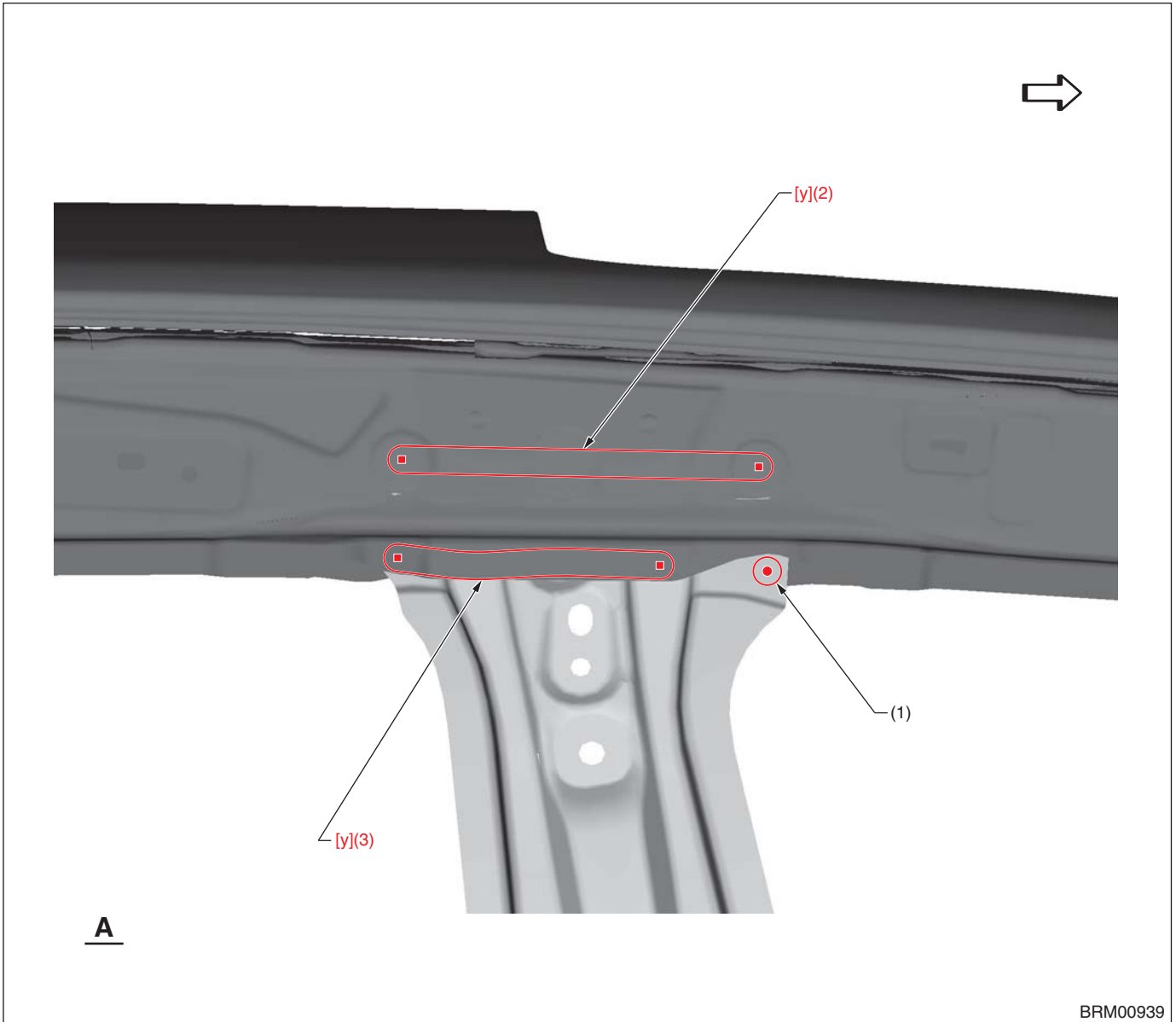
(1) 1 point (service)

(2) 2 points

(3) 5 points (service)

Panel Replacement

• View A



(1) 1 point

(2) 3 points

(3) 4 points

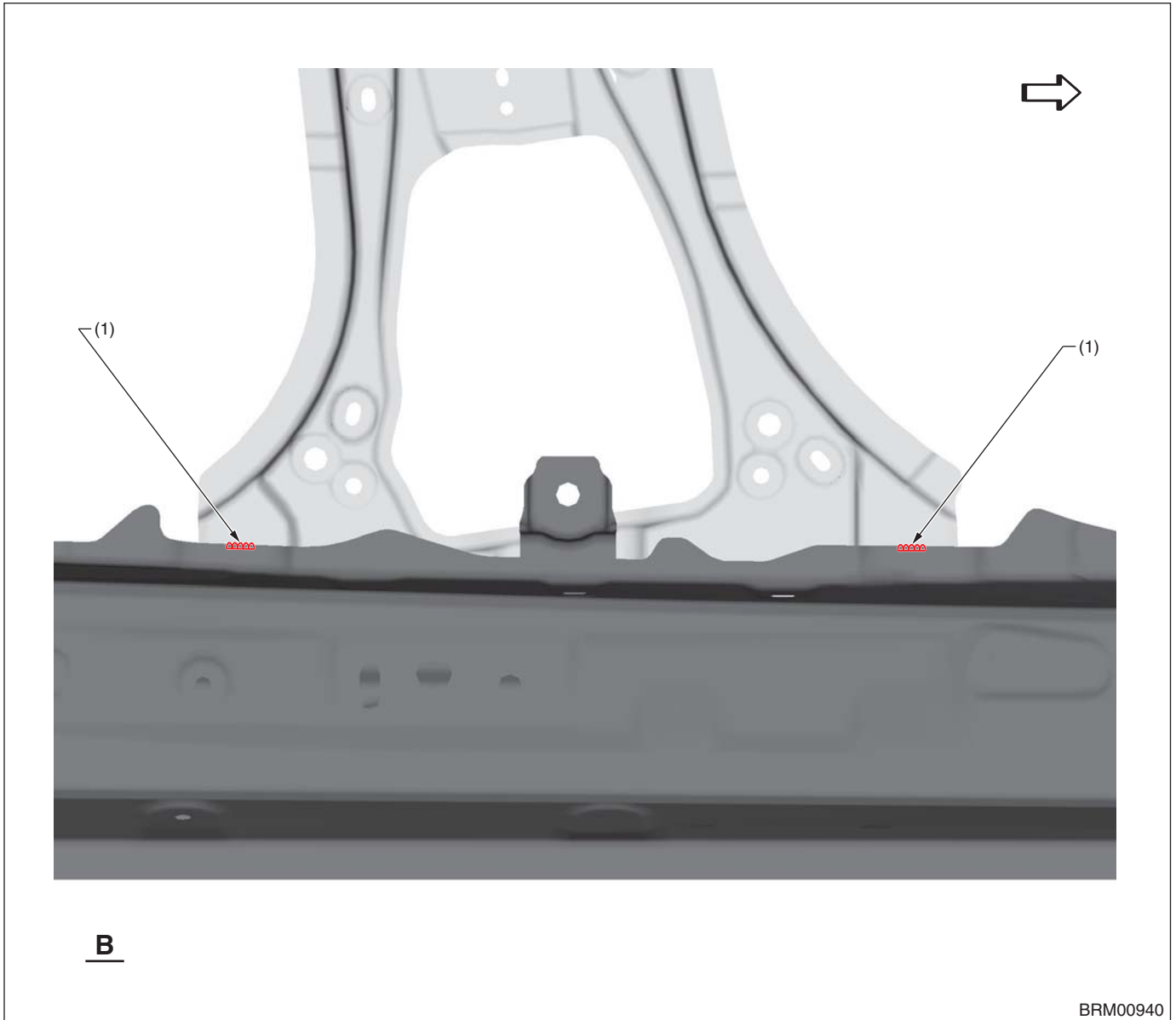
[y] Plug welding

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

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

Panel Replacement

• View B



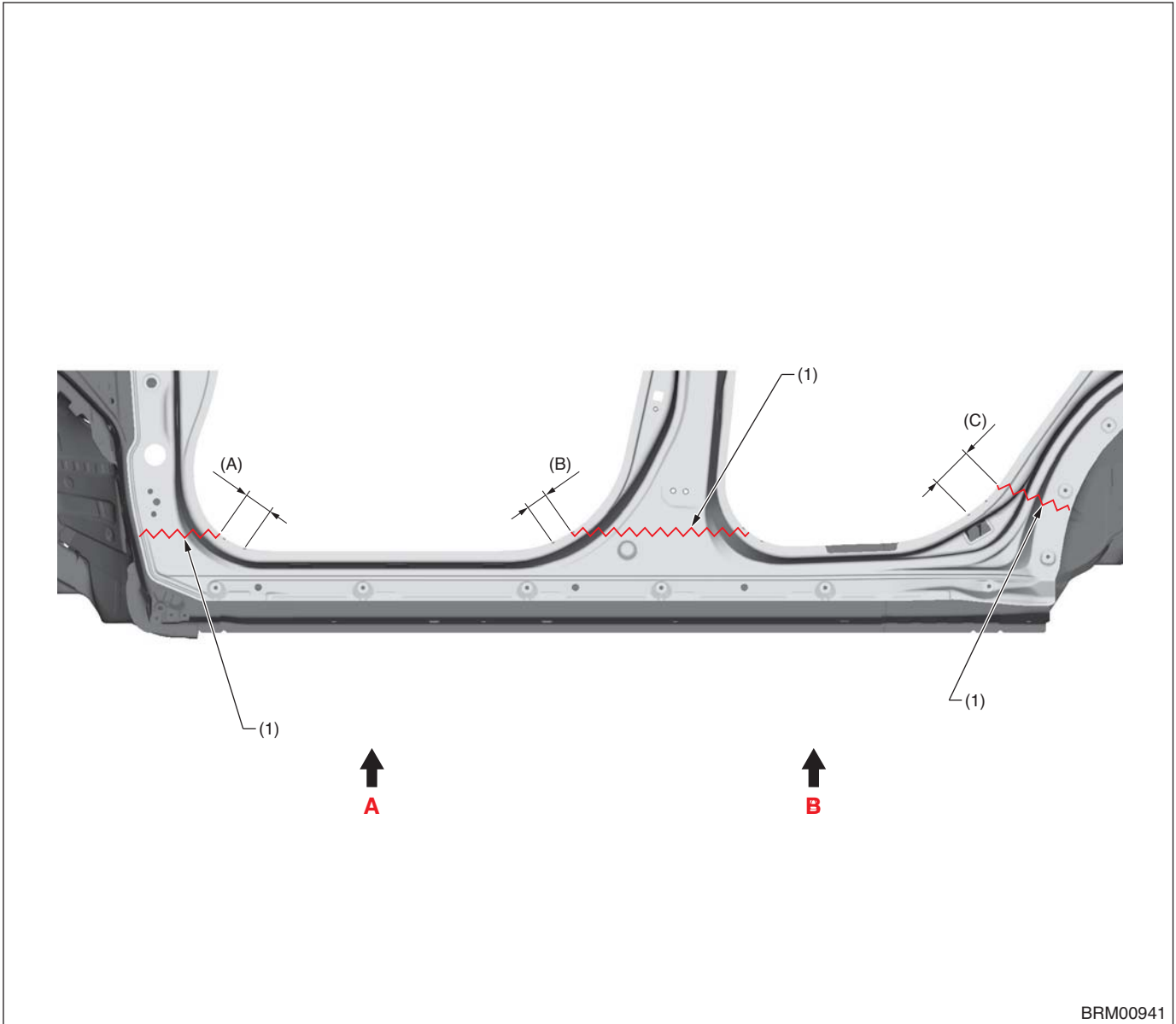
- (1) 1 point (Continuous welding)
(15 mm [0.59 in])

Panel Replacement

8-12. Side Sill Outer Panel (Partial replacement) OUTBACK

A: REMOVAL

- Overall view



(A) 60 mm [2.36 in]

(B) 20 mm [0.79 in]

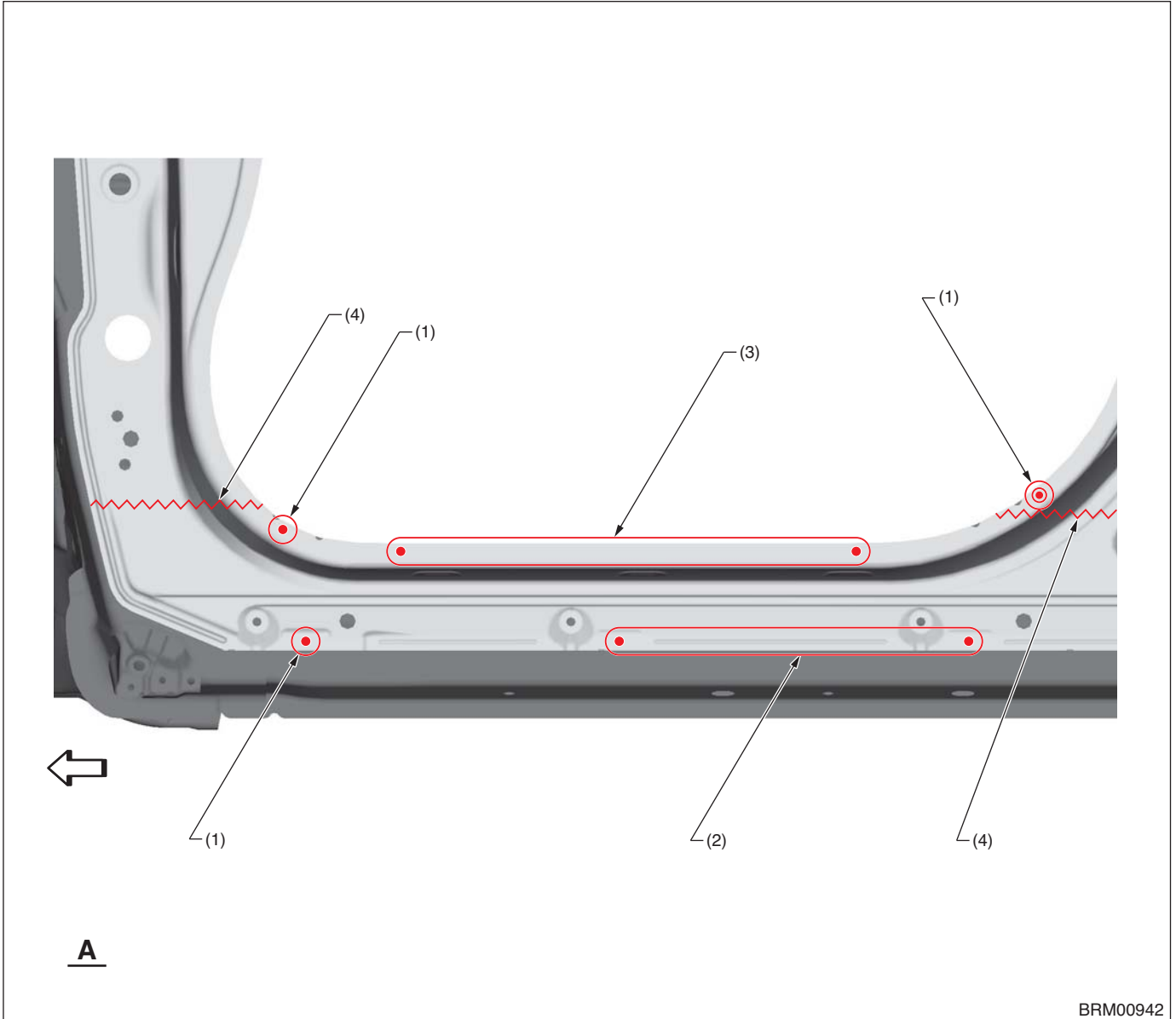
(C) 60 mm [2.36 in]

(1) Cut position

BRM00941

Panel Replacement

• View A



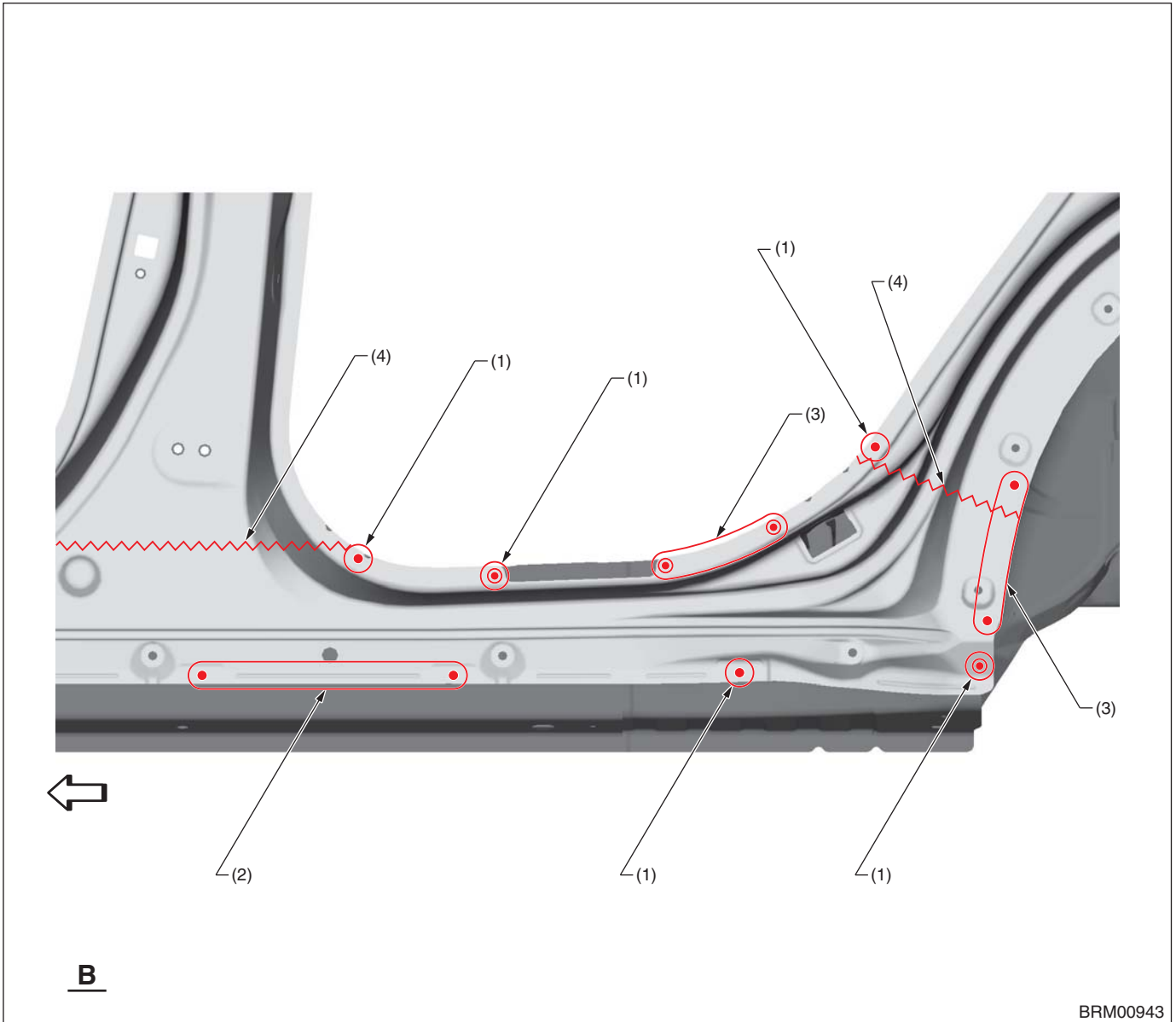
(1) 1 point (outside · 1)
(2) 2 points (outside · 1)

(3) 5 points (outside · 1)

(4) Cut position

Panel Replacement

• View B



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

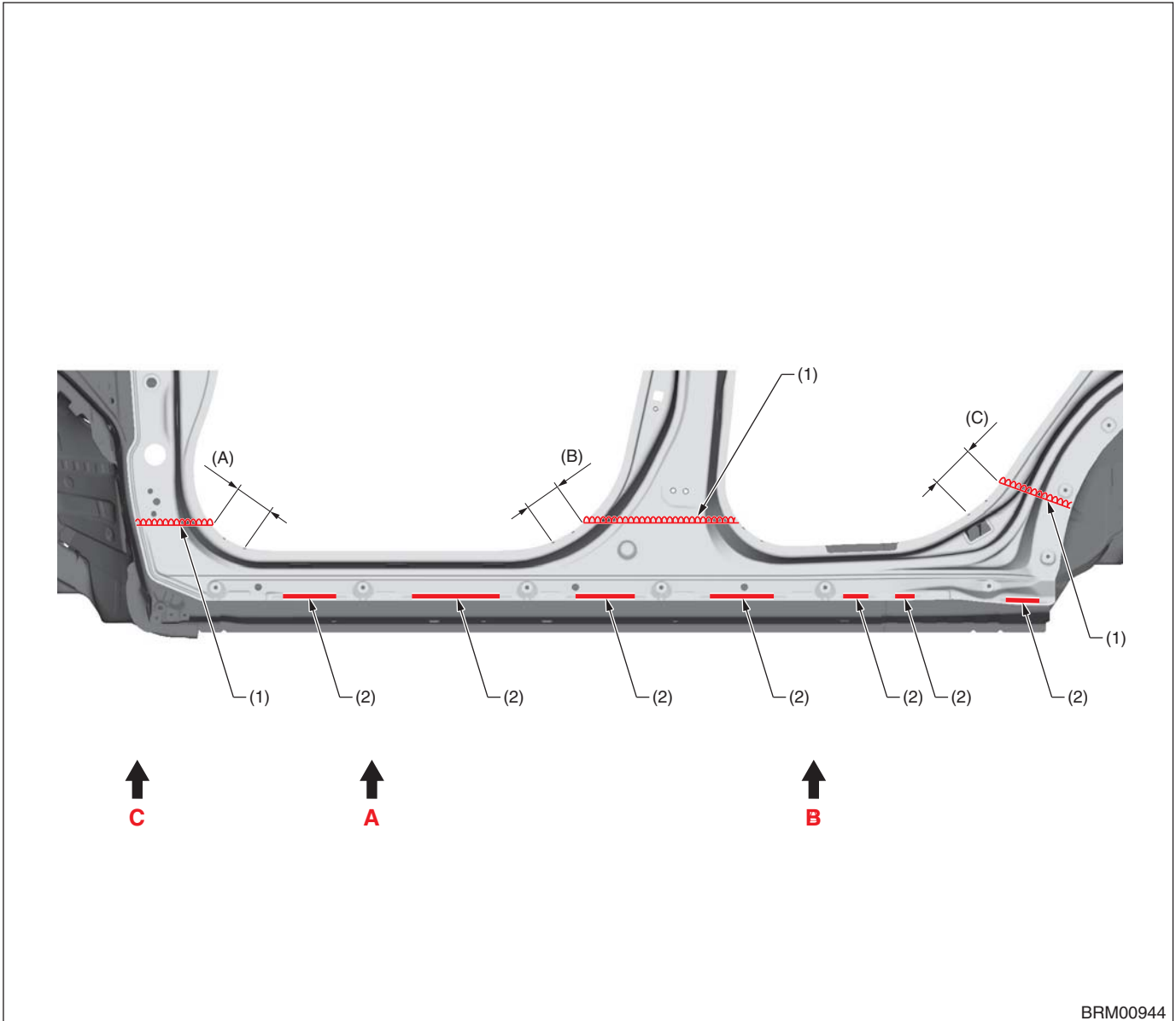
(3) 3 points (outside · 1)

(4) Cut position

Panel Replacement

B: INSTALLATION

• Overall view



(A) 90 mm [3.54 in]

(B) 50 mm [1.97 in]

(C) 80 mm [3.15 in]

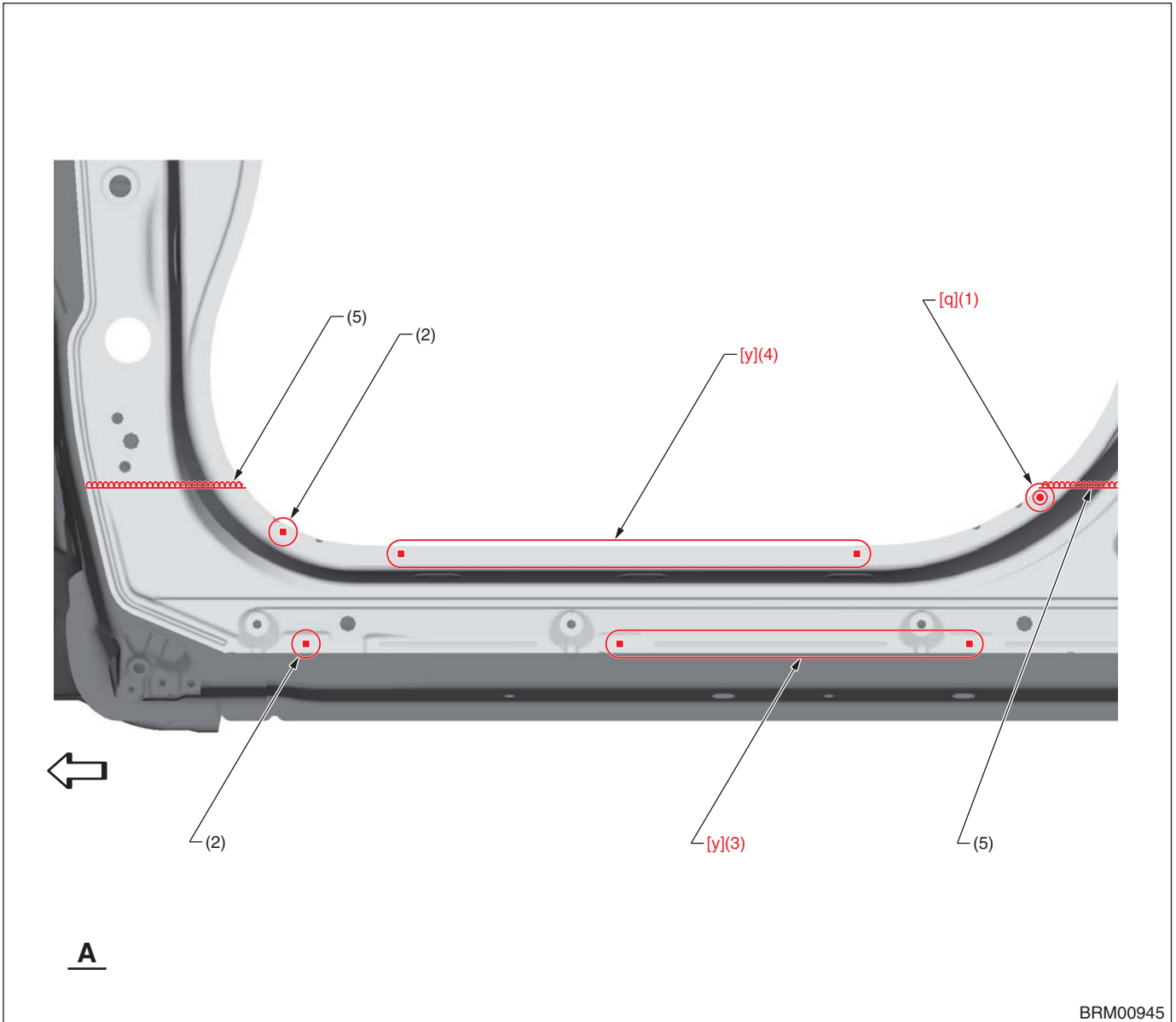
(1) 1 point (Continuous welding)

(2) Structural adhesive

— : Structural adhesive application location (Panel bond mini 38315 made by 3M or equivalent)

Panel Replacement

• View A

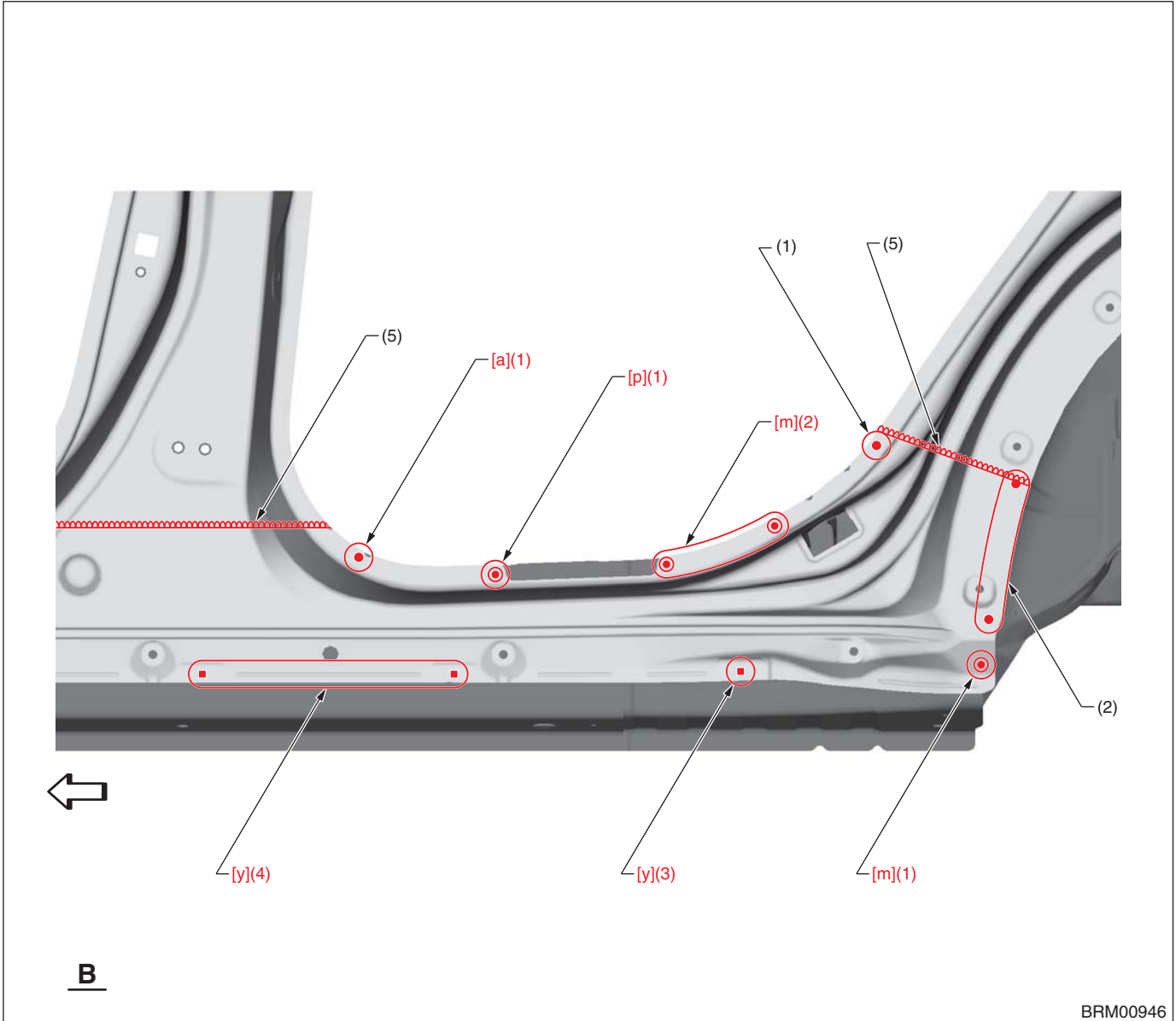


- | | | |
|-----------------------|------------------------|----------------------------------|
| (1) 1 point | (3) 2 points (service) | (5) 1 point (Continuous welding) |
| (2) 1 point (service) | (4) 5 points (service) | |

[q] Spot welding	Compression: 4.0 kN, Current: 8.0 kA, Welding time: 25 cyc
[y] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO ₂ B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO ₂ : 20 %)

Panel Replacement

• View B



(1) 1 point
(2) 3 points

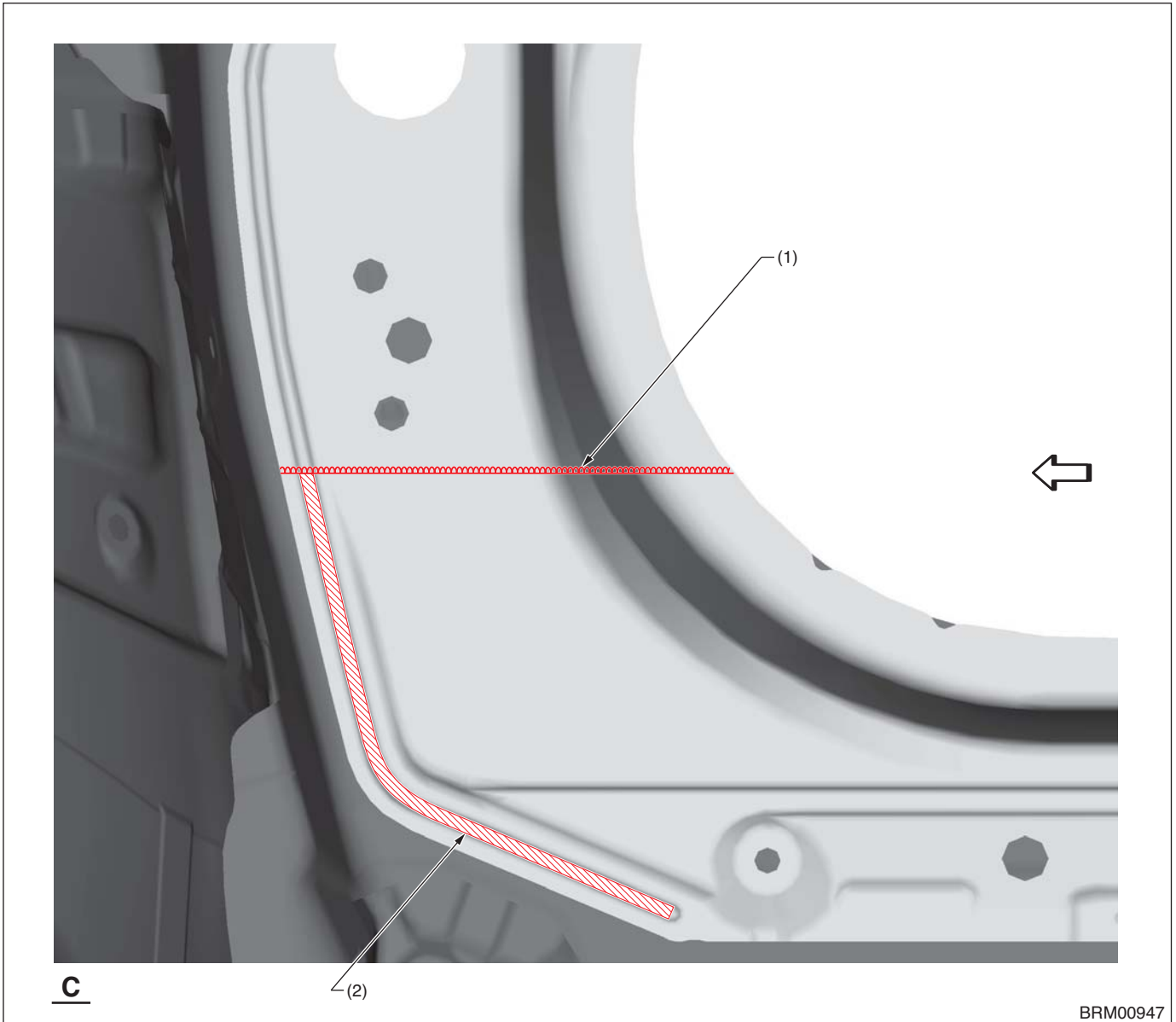
(3) 1 point (service)
(4) 2 points (service)

(5) 1 point (Continuous welding)

[a] Spot welding	Compression: 3.5 kN, Current: 7.5 kA, Welding time: 16 cyc
[m] Spot welding	Compression: 3.5 kN, Current: 7.5 kA, Welding time: 16 cyc
[p] Spot welding	Compression: 4.0 kN, Current: 8.0 kA, Welding time: 22 cyc
[y] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO ₂ B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO ₂ : 20 %)


Panel Replacement

• View C



(1) 1 point (Continuous welding)

(2) Spotting sealer

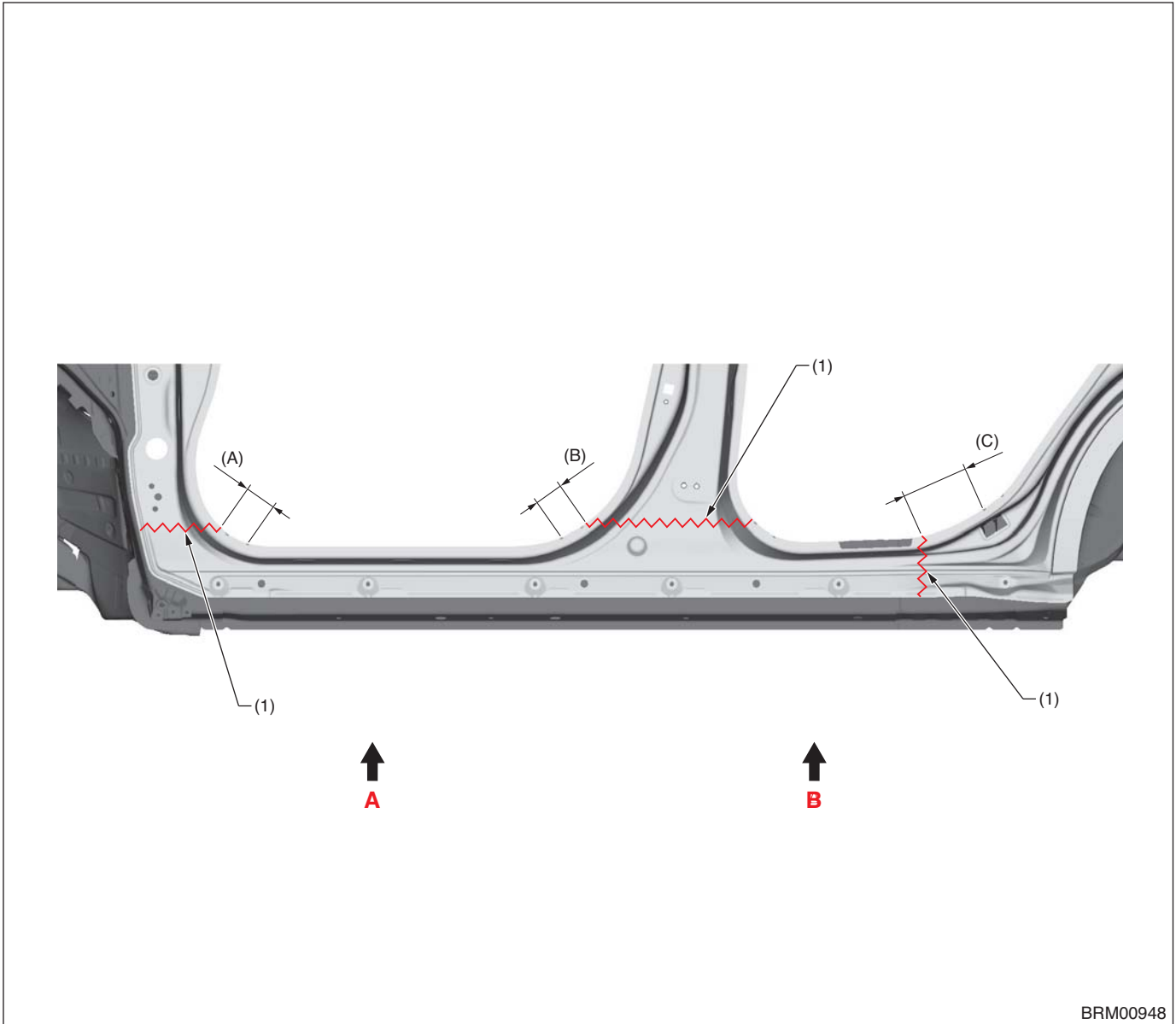
 : Spotting sealer application location (spotting sealer or sealing [Three Bond 4101 (004403063)])
Note: Fill spotting sealer between the panel side out and reinforcement pillar front outer.

Panel Replacement

8-13. Side Sill Outer Panel (Partial replacement) SEDAN

A: REMOVAL

- Overall view



(A) 60 mm [2.36 in]

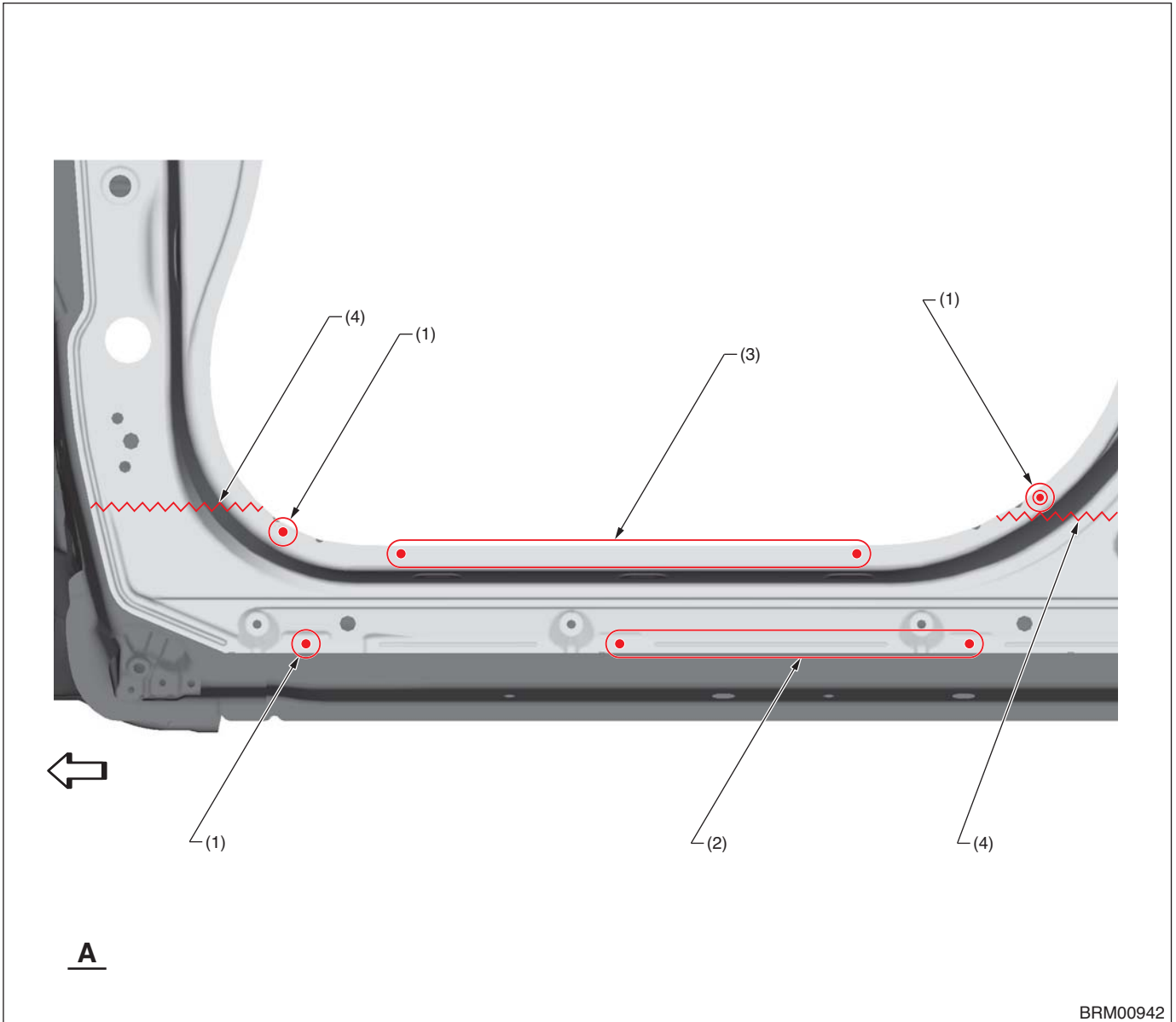
(B) 20 mm [0.79 in]

(C) 125 mm [4.92 in]

(1) Cut position

Panel Replacement

• View A



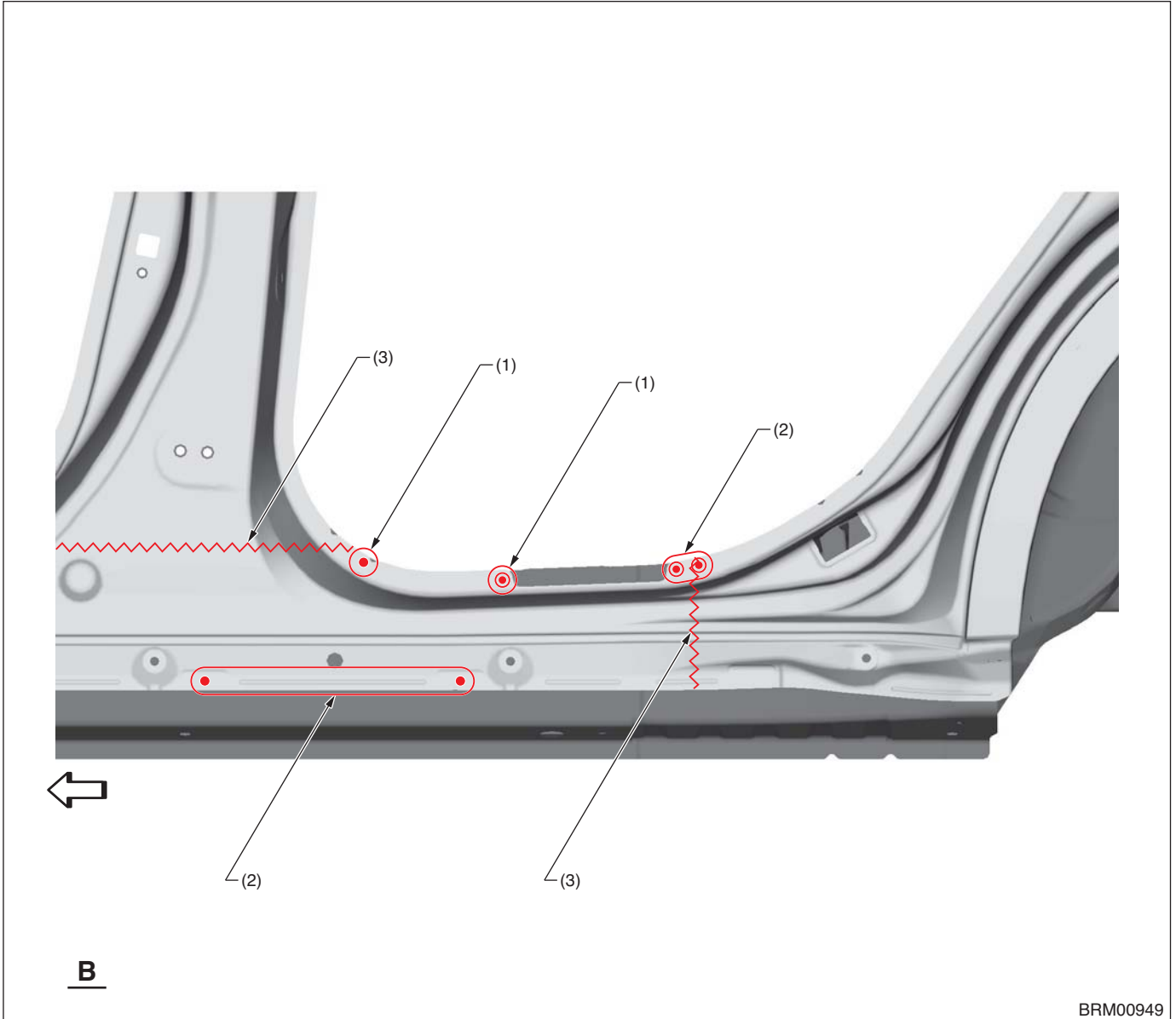
(1) 1 point (outside · 1)
(2) 2 points (outside · 1)

(3) 5 points (outside · 1)

(4) Cut position

Panel Replacement

• View B



BRM00949

(1) 1 point (outside · 1)

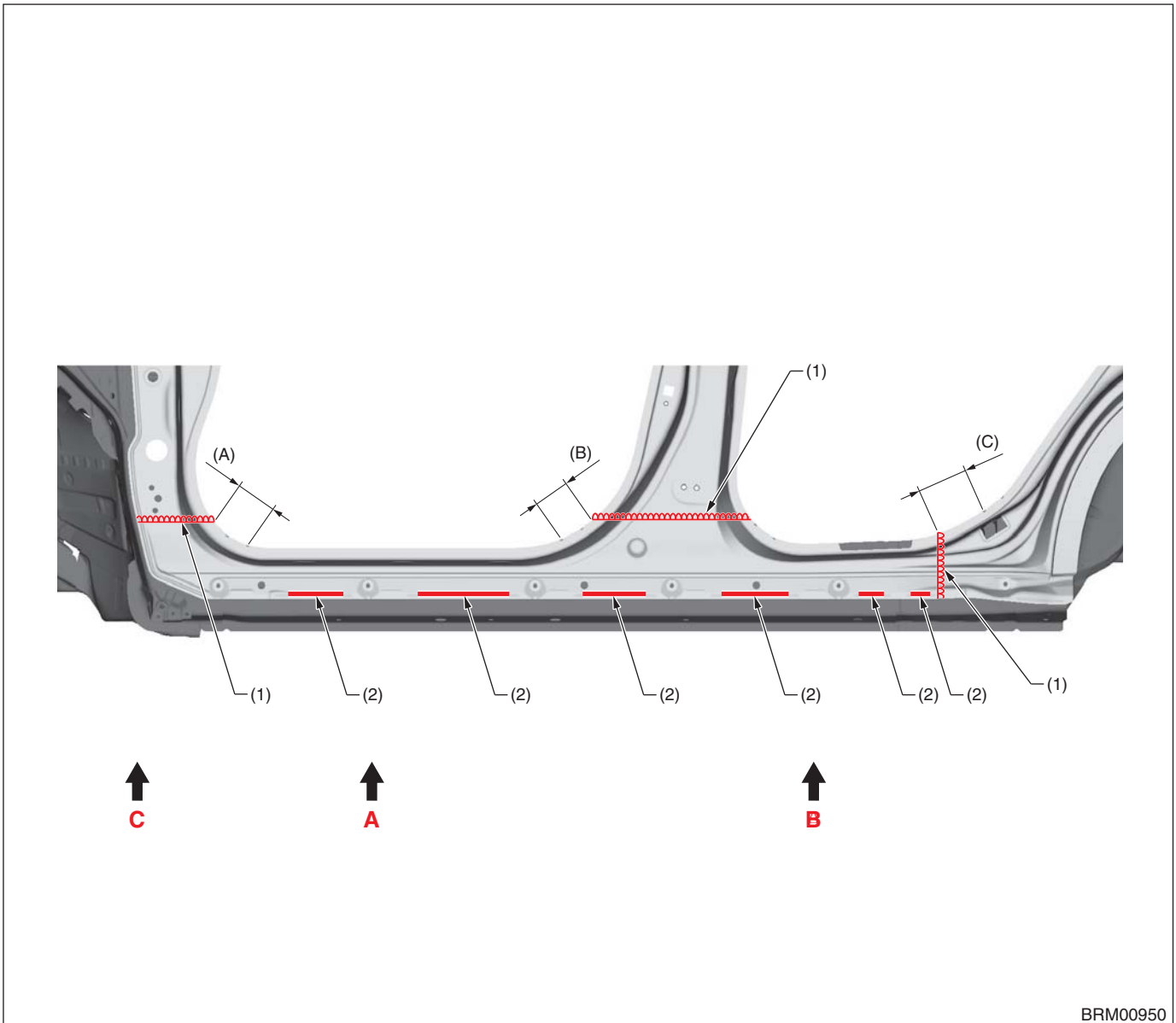
(2) 2 points (outside · 1)

(3) Cut position

Panel Replacement

B: INSTALLATION

• Overall view



BRM00950

(A) 90 mm [3.54 in]

(B) 50 mm [1.97 in]

(C) 100 mm [3.94 in]

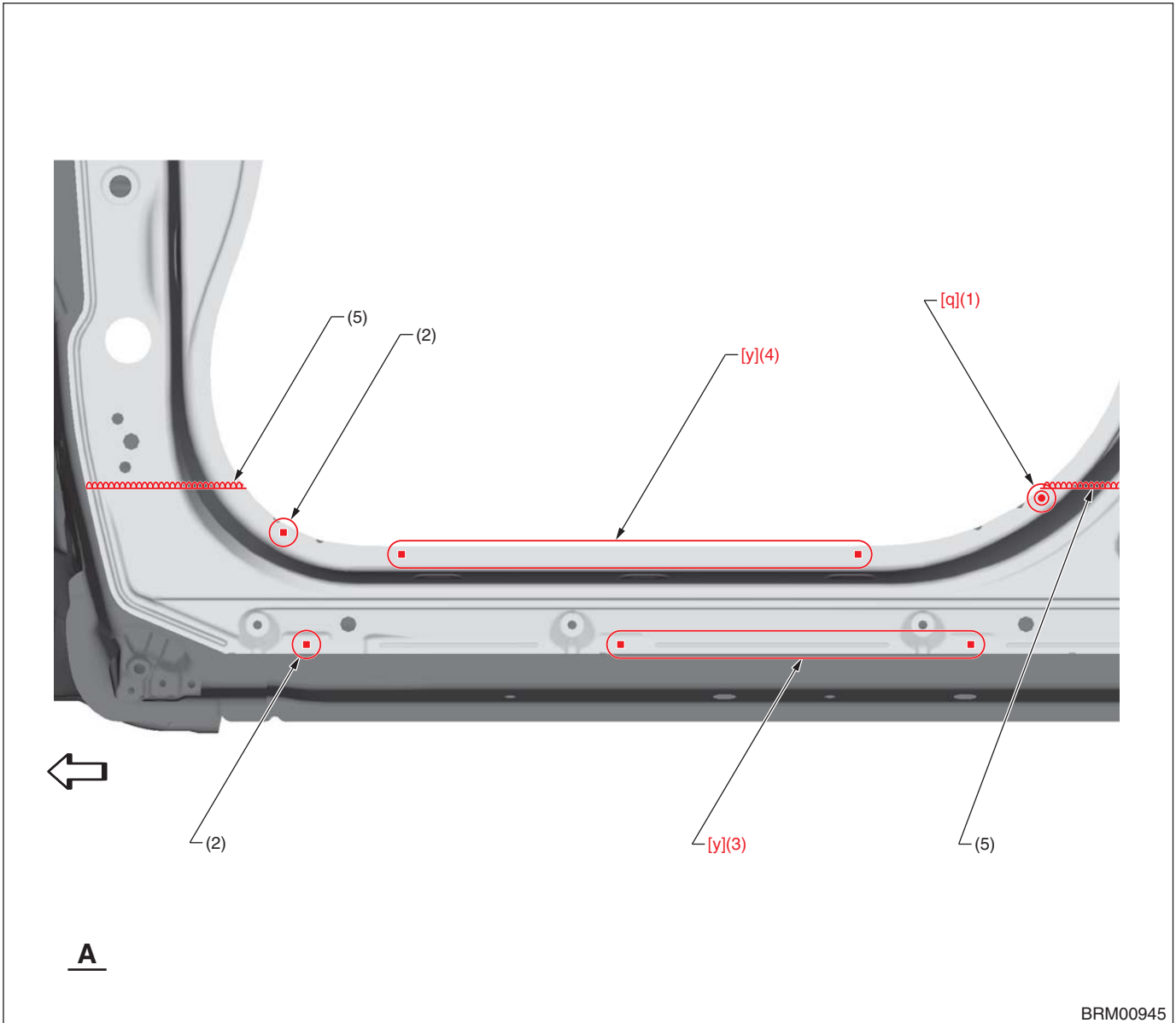
(1) 1 point (Continuous welding)

(2) Structural adhesive

— : Structural adhesive application location (Panel bond mini 38315 made by 3M or equivalent)

Panel Replacement

• View A

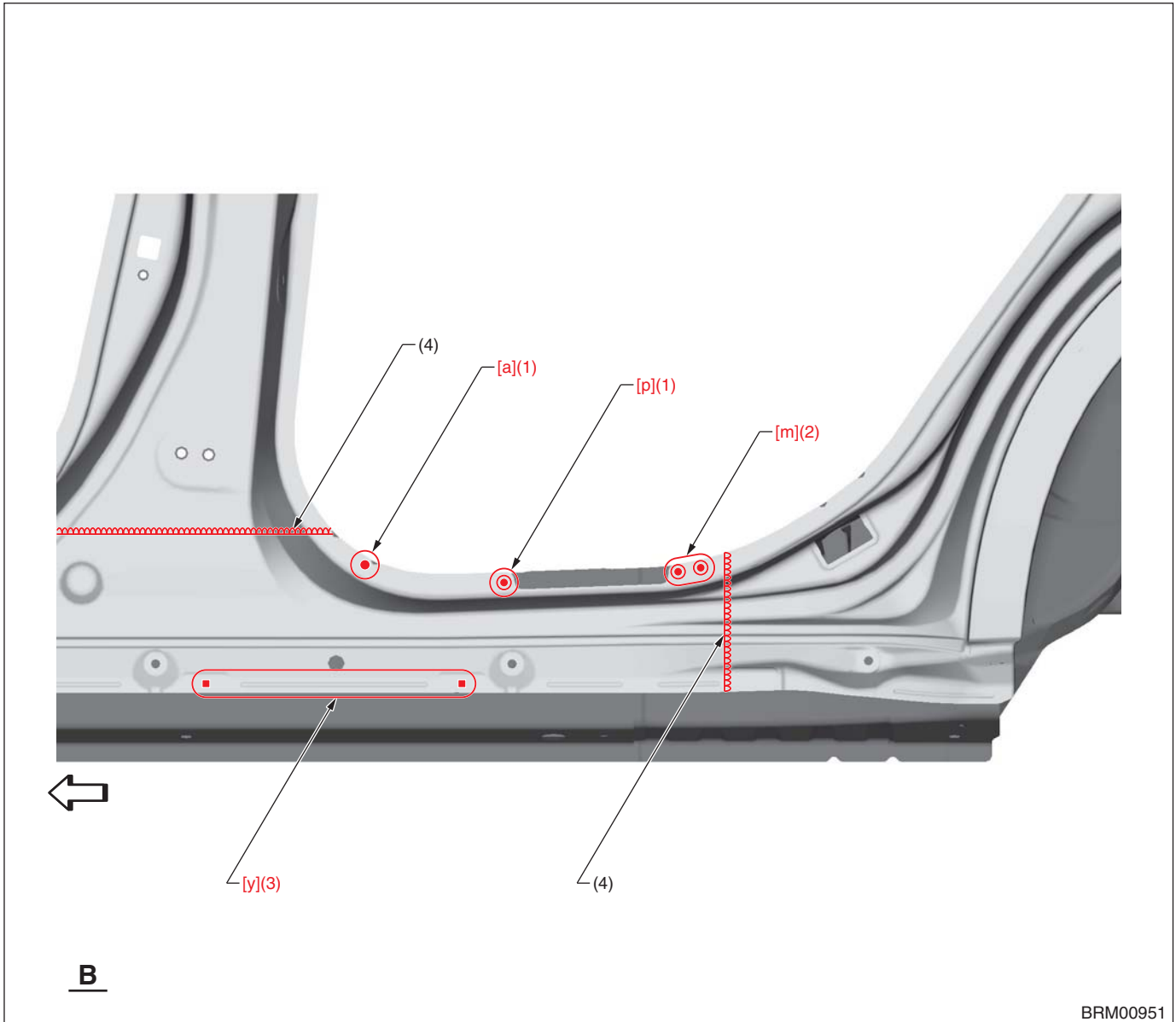


- | | | |
|-----------------------|------------------------|----------------------------------|
| (1) 1 point | (3) 2 points (service) | (5) 1 point (Continuous welding) |
| (2) 1 point (service) | (4) 5 points (service) | |

[q] Spot welding	Compression: 4.0 kN, Current: 8.0 kA, Welding time: 25 cyc
[y] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO ₂ B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO ₂ : 20 %)

Panel Replacement

• View B



(1) 1 point
(2) 2 points

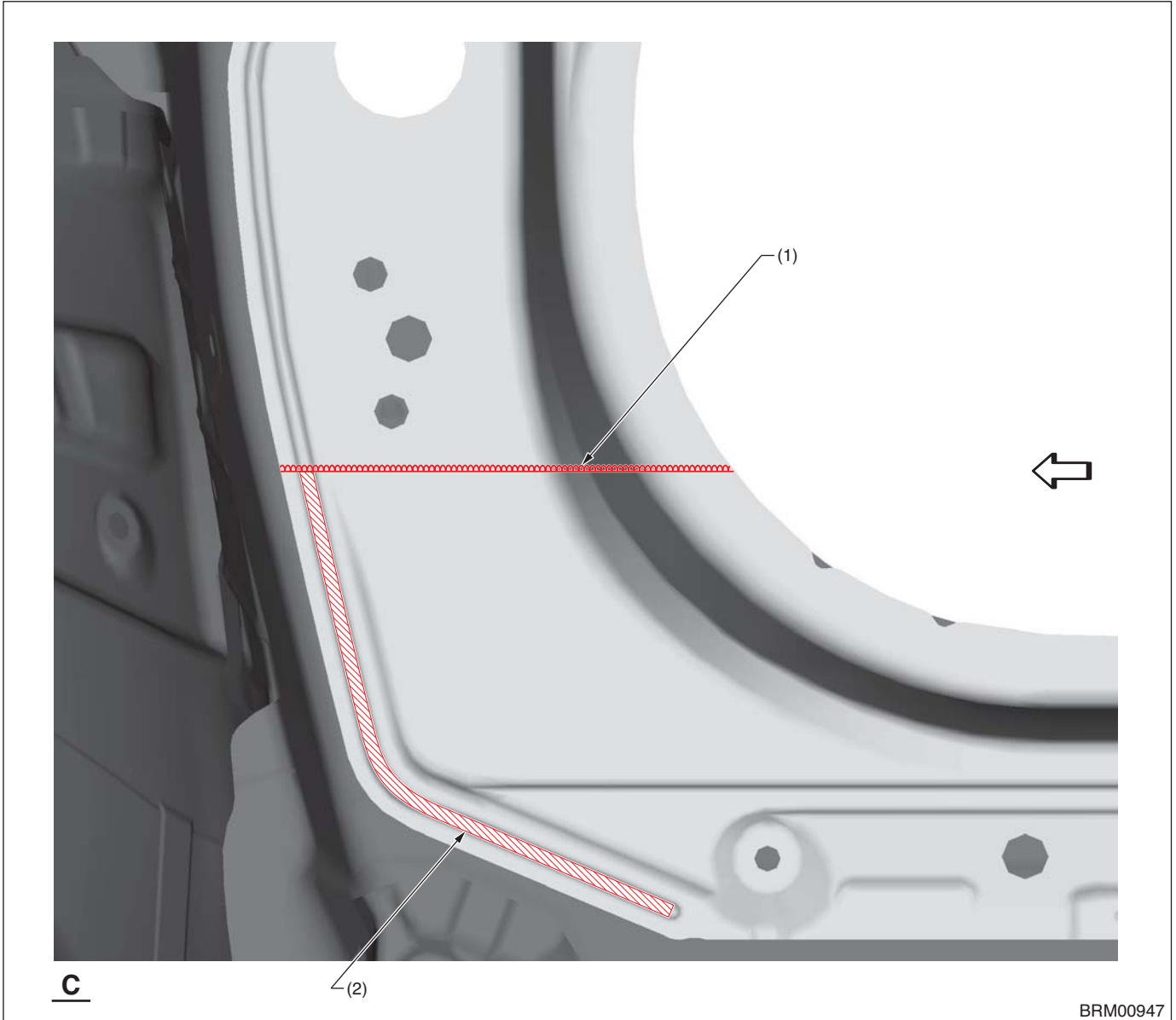
(3) 2 points (service)

(4) 1 point (Continuous welding)

[a] Spot welding	Compression: 3.5 kN, Current: 7.5 kA, Welding time: 16 cyc
[m] Spot welding	Compression: 3.5 kN, Current: 7.5 kA, Welding time: 16 cyc
[p] Spot welding	Compression: 4.0 kN, Current: 8.0 kA, Welding time: 22 cyc
[y] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO ₂ B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO ₂ : 20 %)


Panel Replacement

• View C



(1) 1 point (Continuous welding)

(2) Spotting sealer

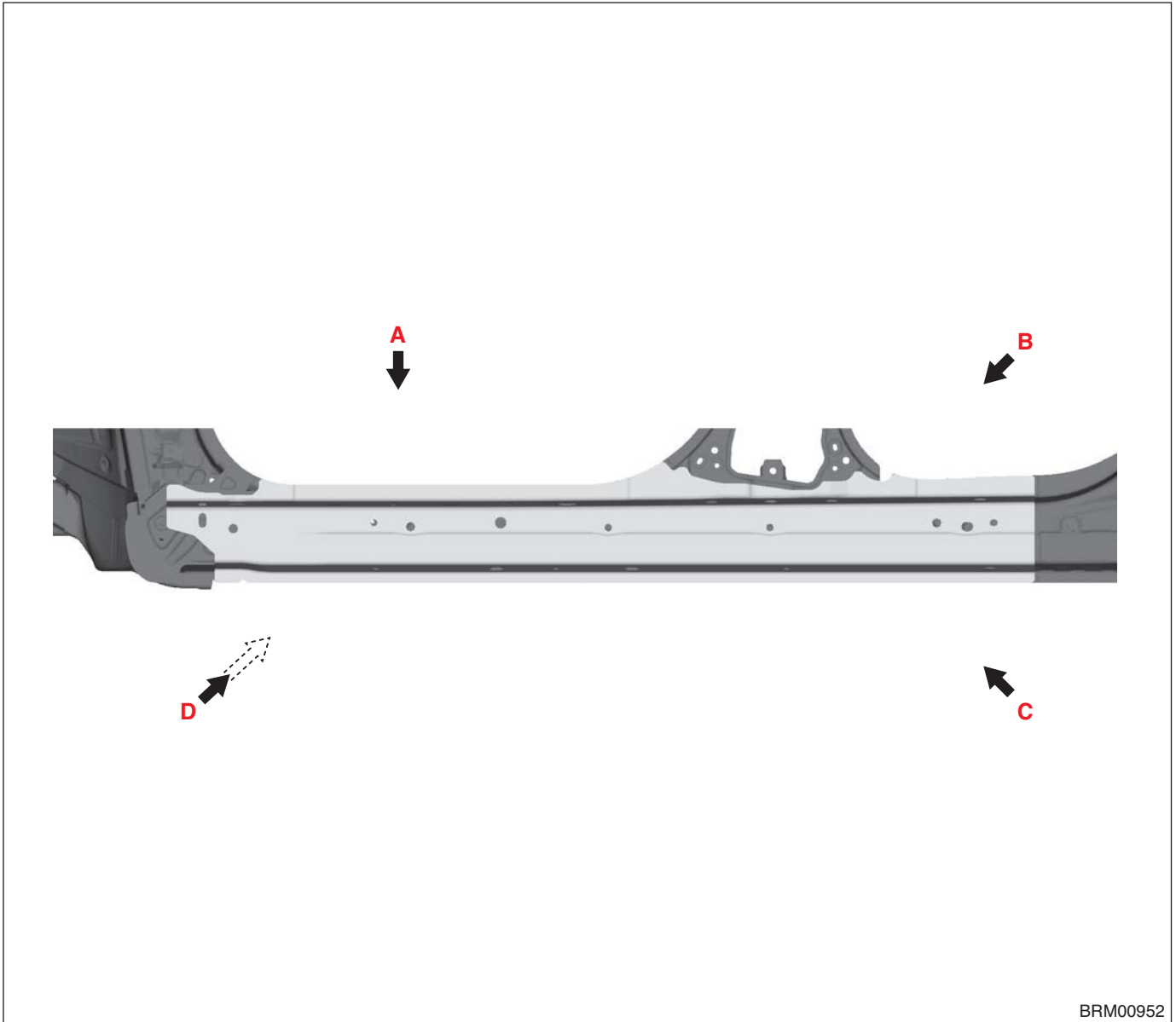
 : Spotting sealer application location (spotting sealer or sealing [Three Bond 4101 (004403063)])
Note: Fill spotting sealer between the panel side out and reinforcement pillar front outer.

Panel Replacement

8-14. Side Sill Reinforcement Outer (Total replacement)

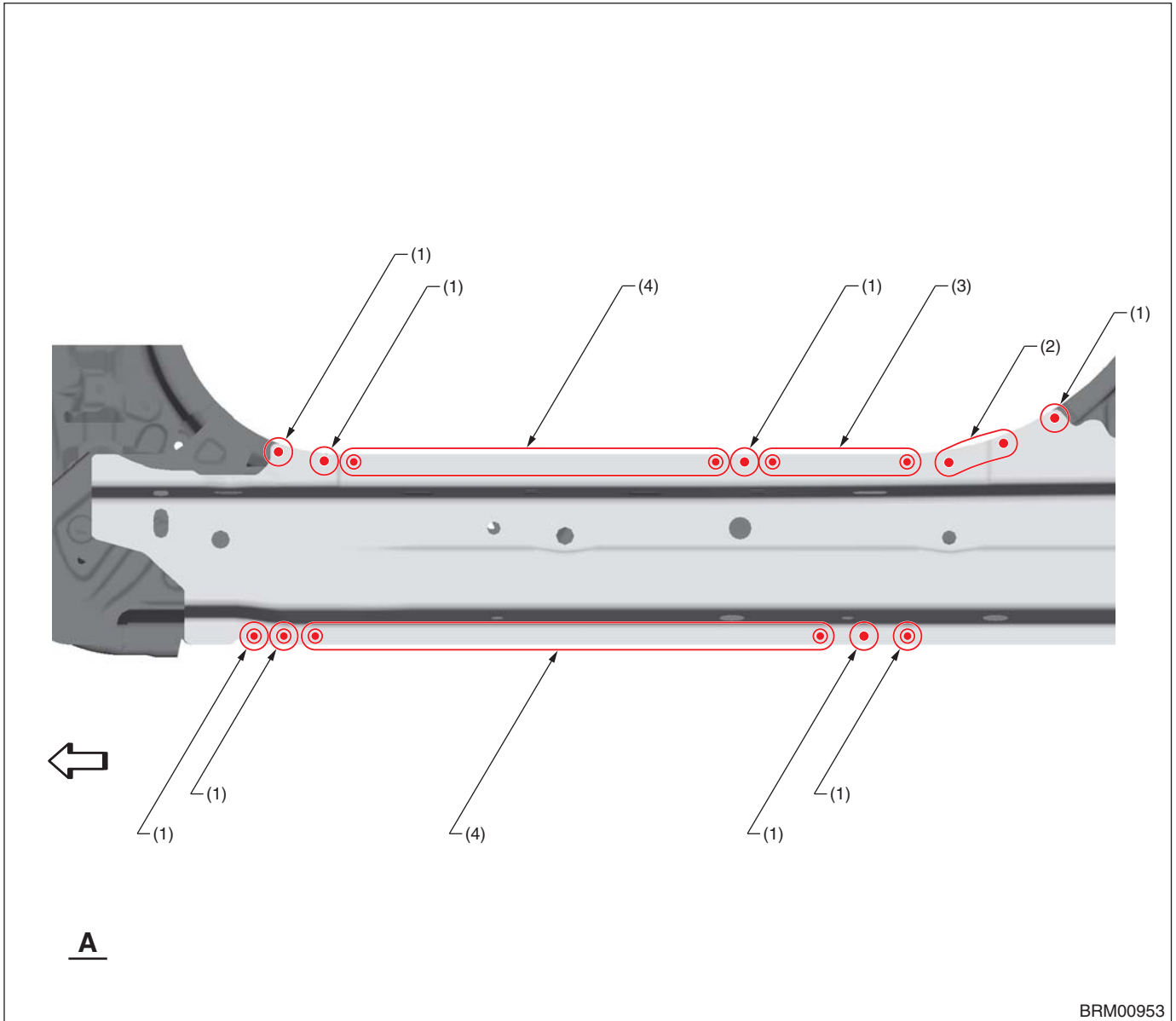
A: REMOVAL

- Overall view



Panel Replacement

• View A



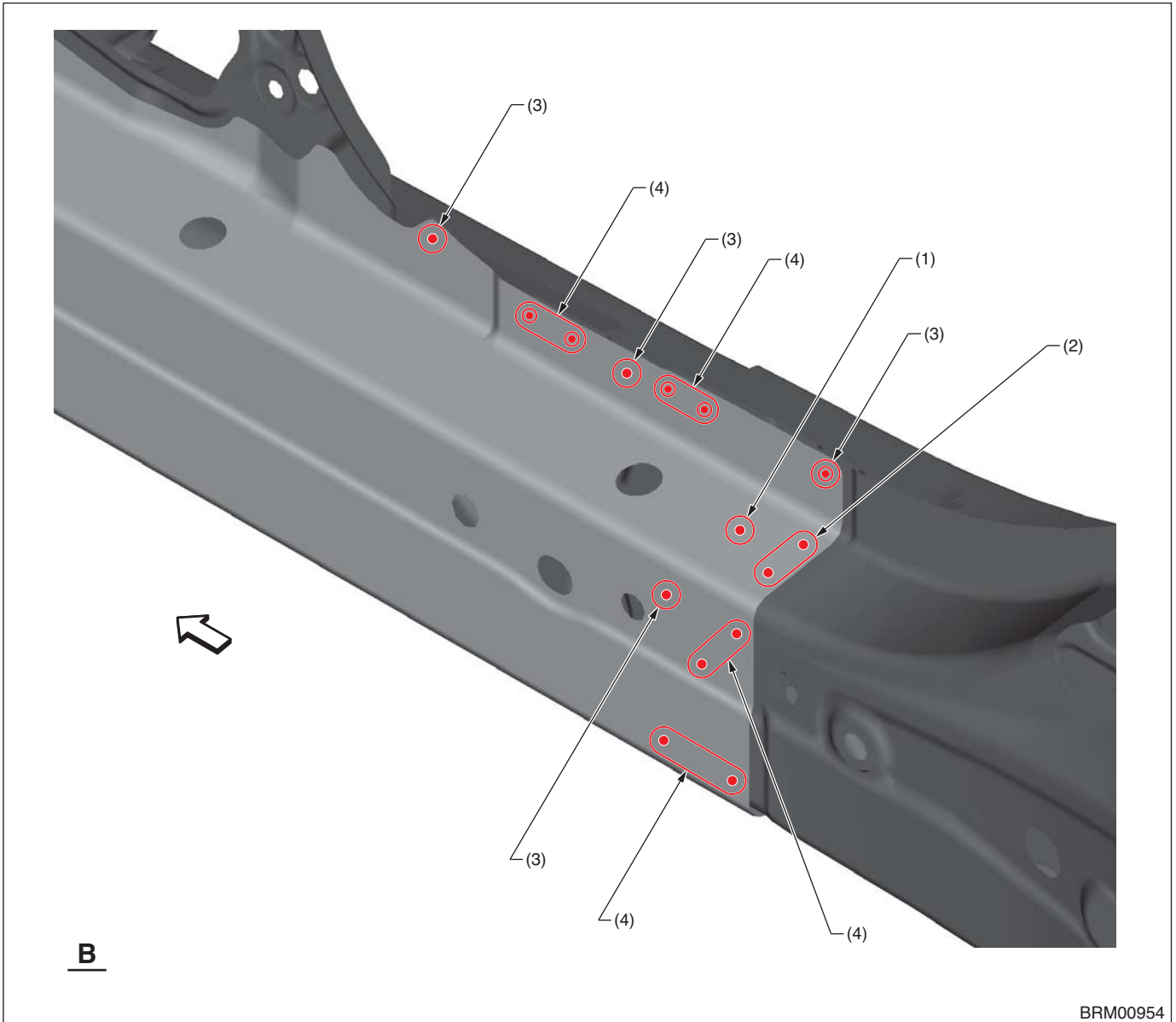
(1) 1 point (outside · 1)
(2) 3 points (outside · 1)

(3) 4 points (outside · 1)

(4) 10 points (outside · 1)

Panel Replacement

• View B



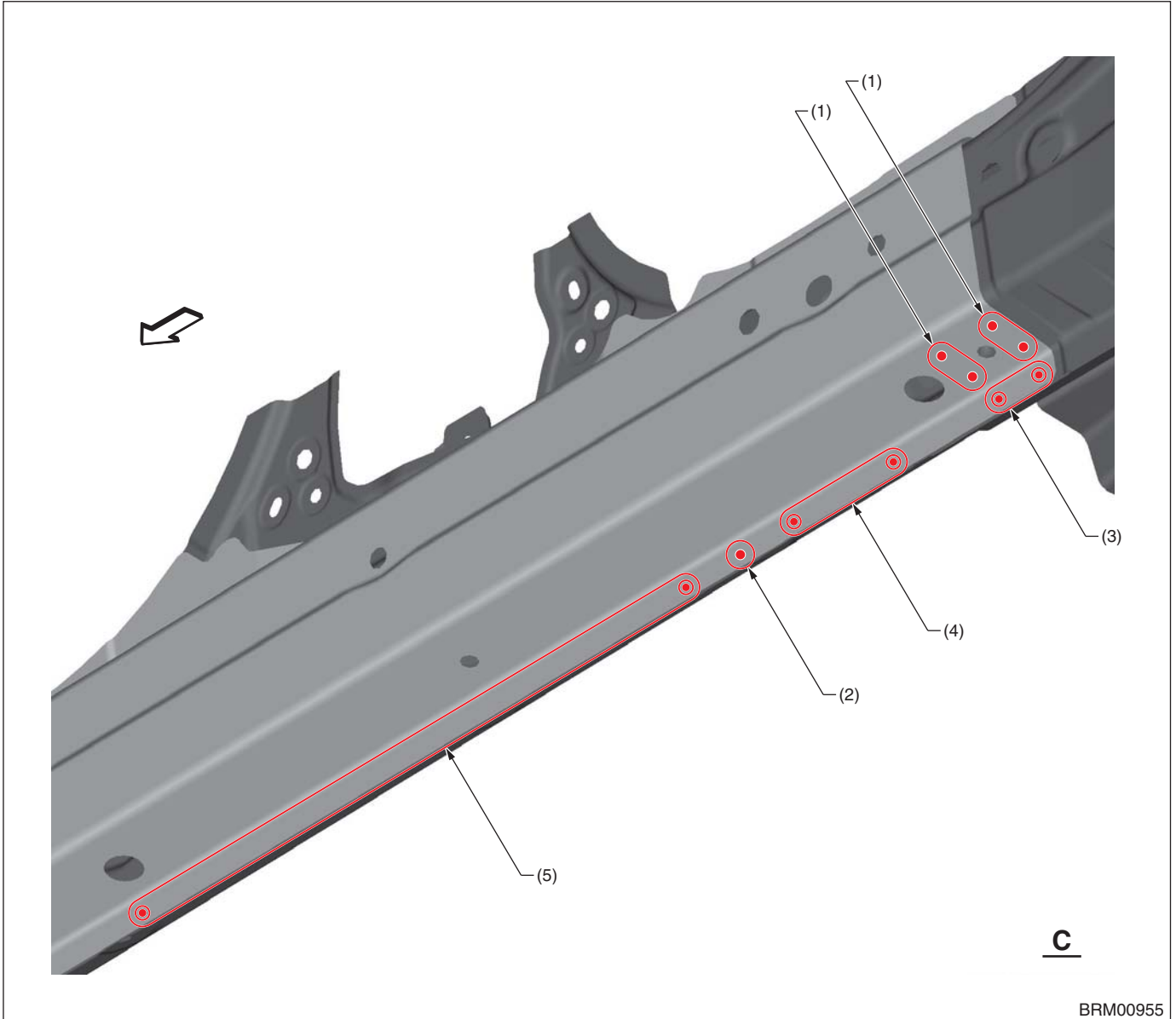
(1) 1 point (top · 1)
(2) 2 points (top · 1)

(3) 1 point (outside · 1)

(4) 2 points (outside · 1)

Panel Replacement

• View C



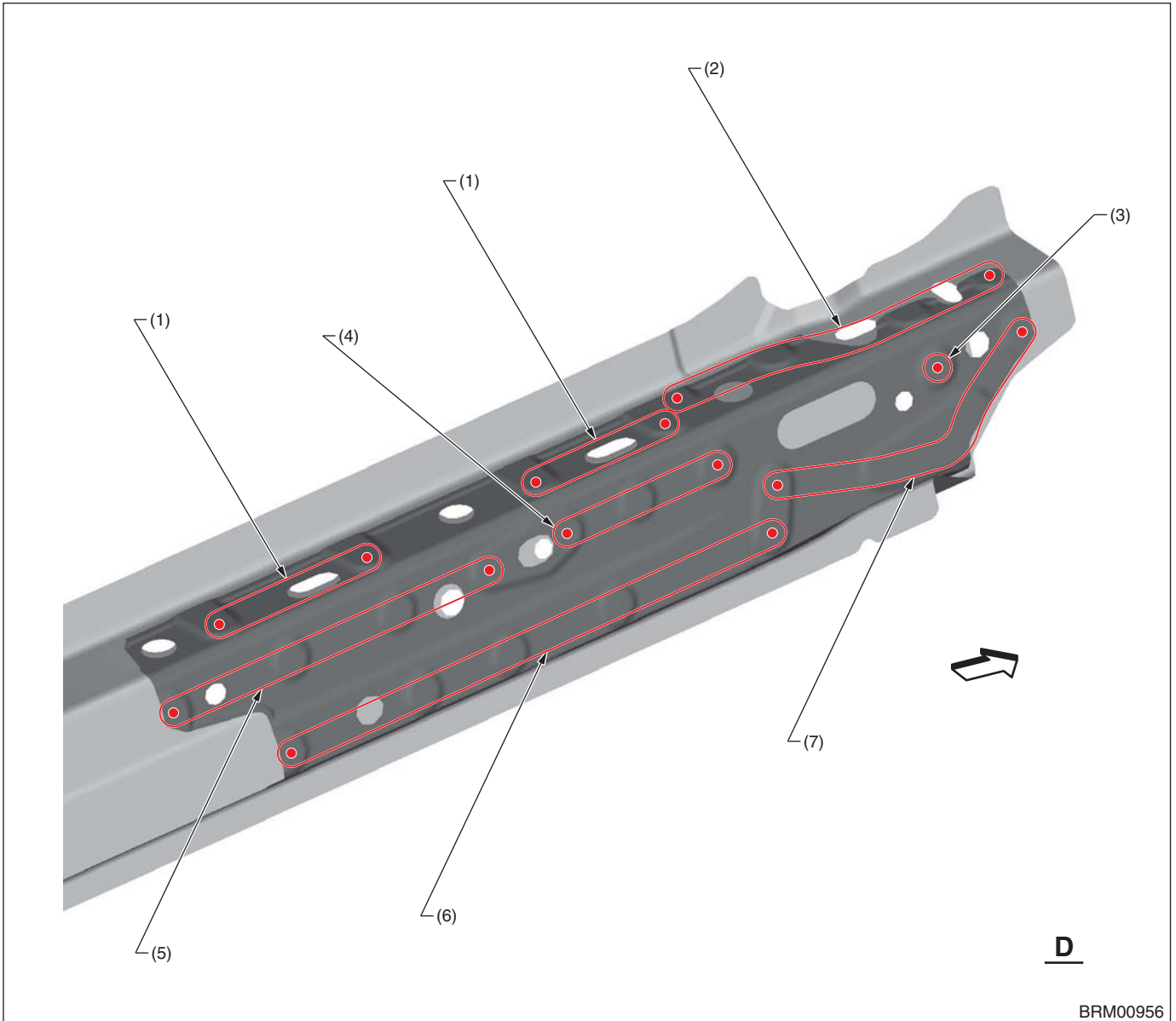
(1) 2 points (bottom · 1)
(2) 1 point (outside · 1)

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

(5) 11 points (outside · 1)

Panel Replacement

• View D



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

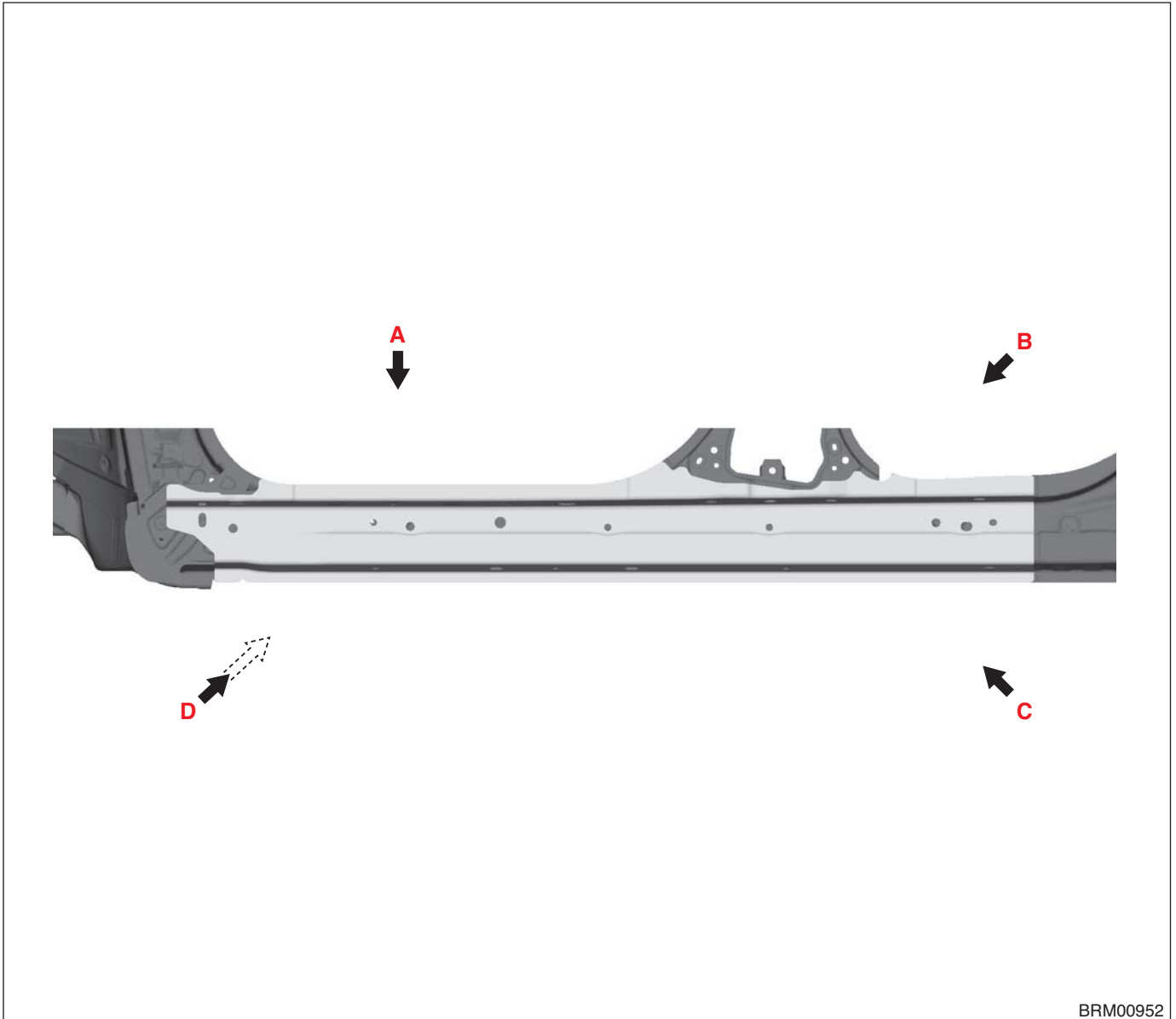
- (4) 3 points (inside · 1)
- (5) 4 points (inside · 1)
- (6) 5 points (inside · 1)

- (7) 6 points (inside · 1)

Panel Replacement

B: INSTALLATION

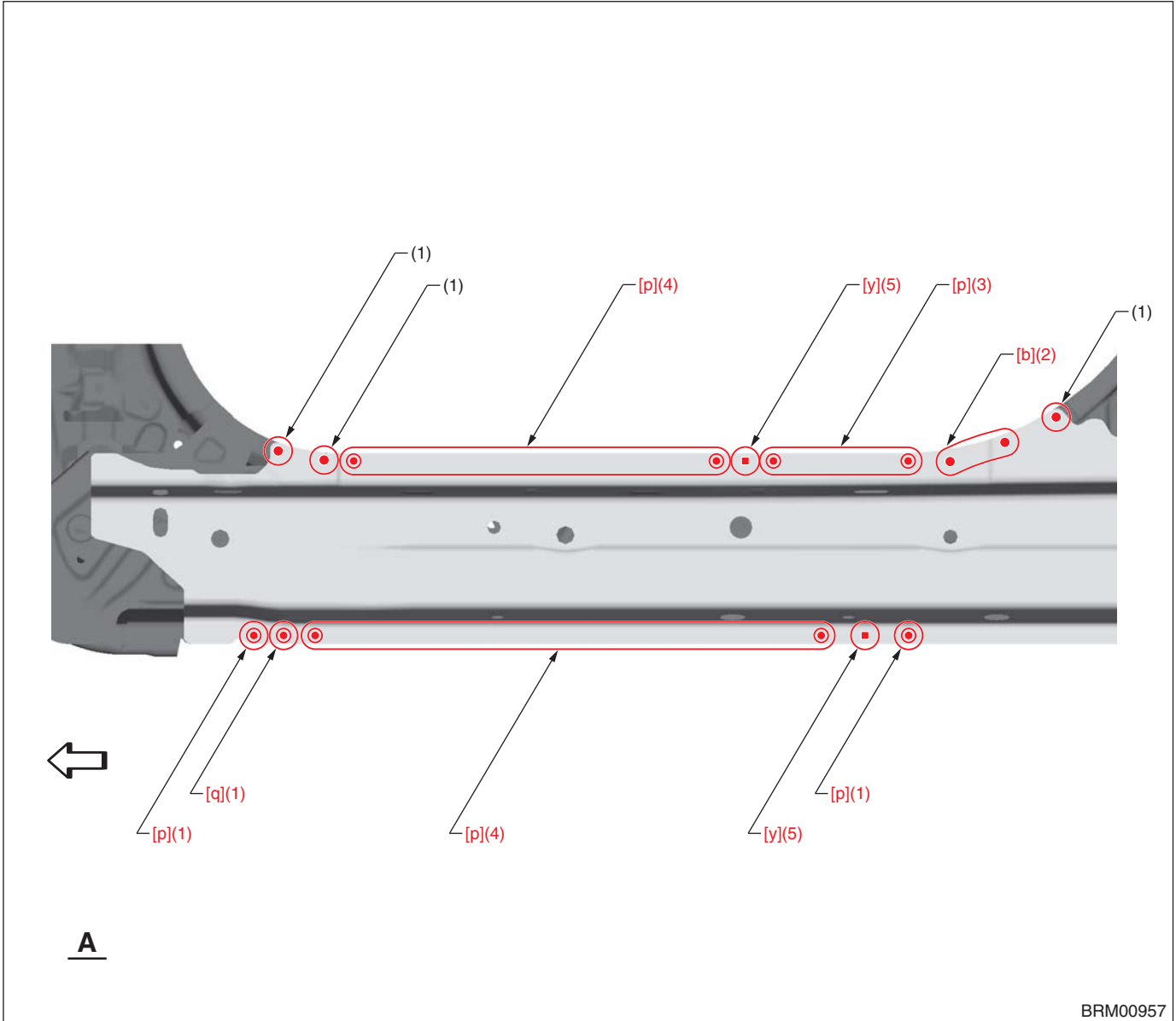
• Overall view



BRM00952

Panel Replacement

• View A



(1) 1 point
(2) 3 points

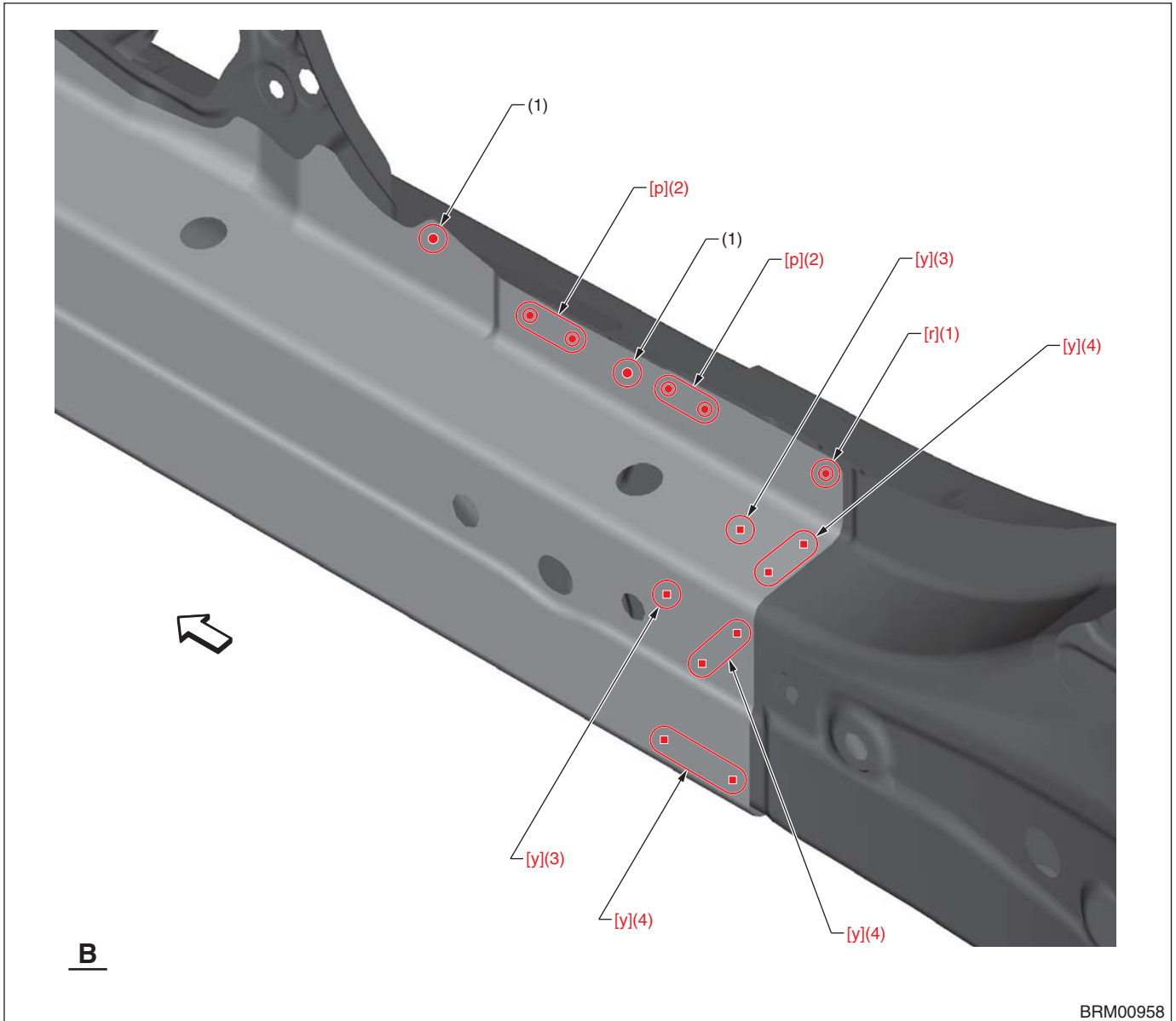
(3) 4 points
(4) 10 points

(5) 1 point (service)

[b] Spot welding	Compression: 4.0 kN, Current: 8.0 kA, Welding time: 15 cyc
[p] Spot welding	Compression: 4.0 kN, Current: 8.0 kA, Welding time: 22 cyc
[q] Spot welding	Compression: 4.0 kN, Current: 8.0 kA, Welding time: 25 cyc
[y] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO ₂ B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO ₂ : 20 %)

Panel Replacement

• View B



(1) 1 point
(2) 2 points

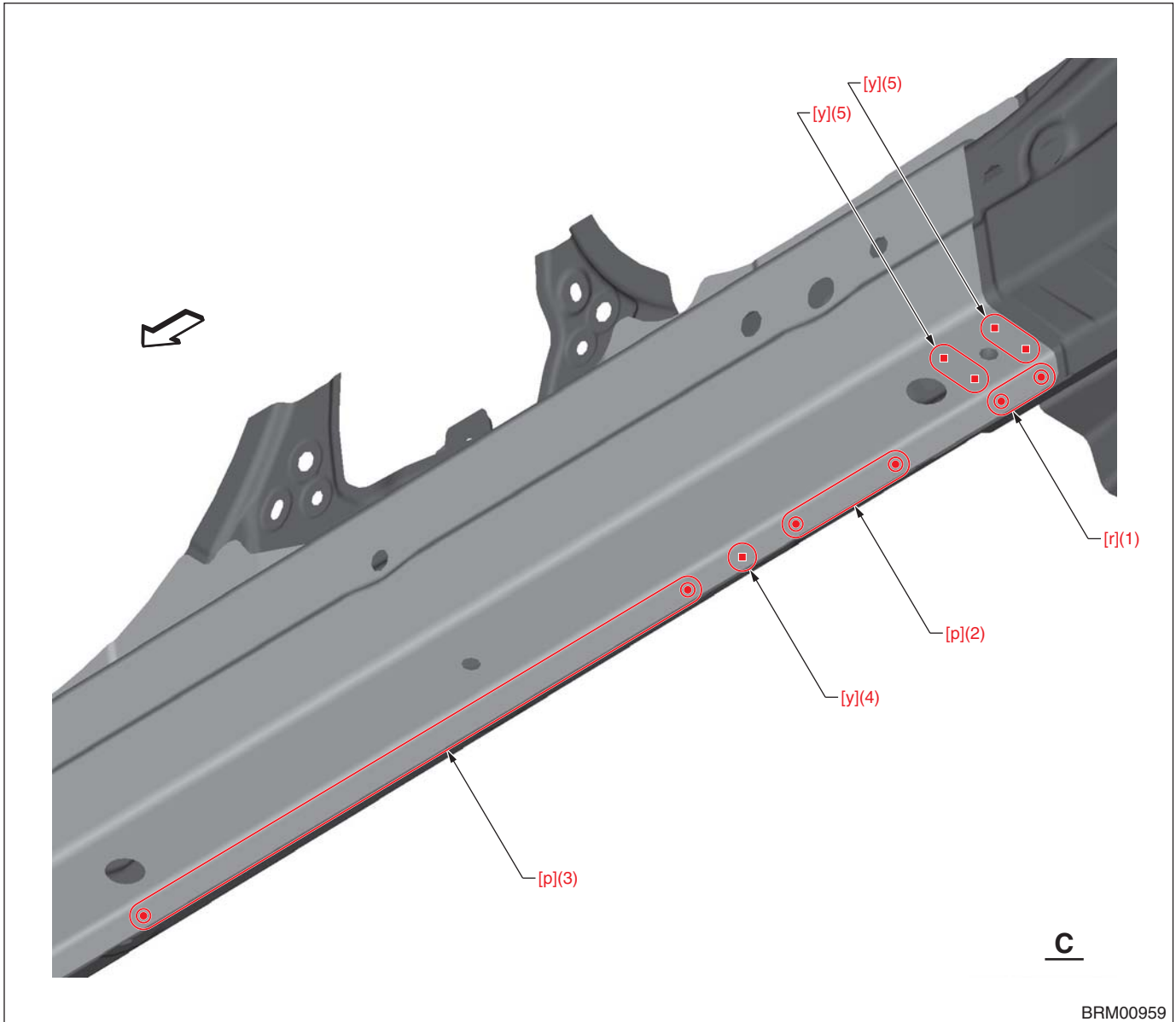
(3) 1 point (service)

(4) 2 points (service)

[p] Spot welding	Compression: 4.0 kN, Current: 8.0 kA, Welding time: 22 cyc
[r] Spot welding	Compression: 4.0 kN, Current: 10.0 kA, Welding time: 22 cyc
[y] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO ₂ B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO ₂ : 20 %)

Panel Replacement

• View C



(1) 2 points
(2) 3 points

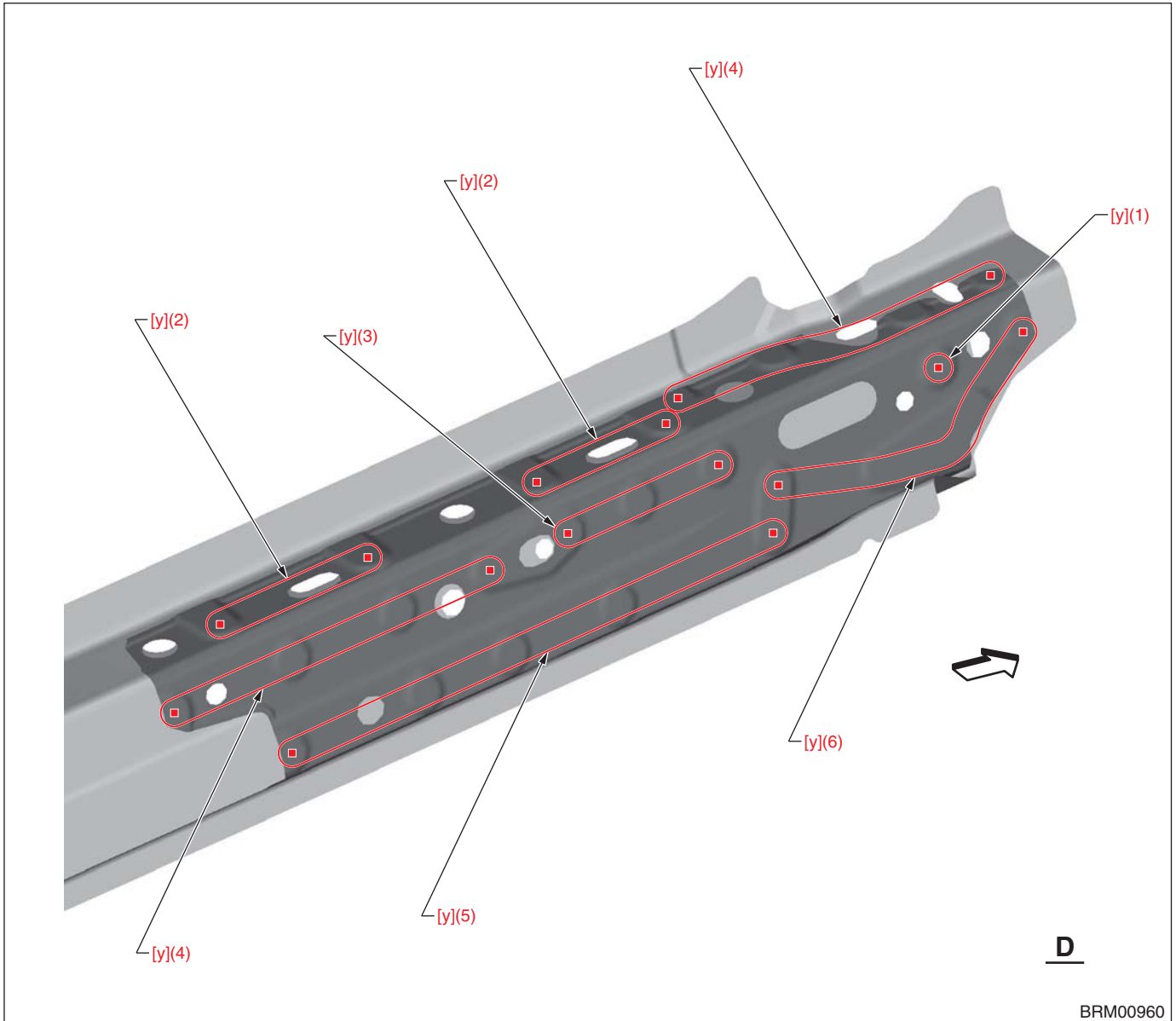
(3) 11 points
(4) 1 point (service)

(5) 2 points (service)

[p] Spot welding	Compression: 4.0 kN, Current: 8.0 kA, Welding time: 22 cyc
[r] Spot welding	Compression: 4.0 kN, Current: 10.0 kA, Welding time: 22 cyc
[y] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO ₂ B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO ₂ : 20 %)

Panel Replacement

• View D



(1) 1 point
(2) 2 points

(3) 3 points
(4) 4 points

(5) 5 points
(6) 6 points

[y] Plug welding

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

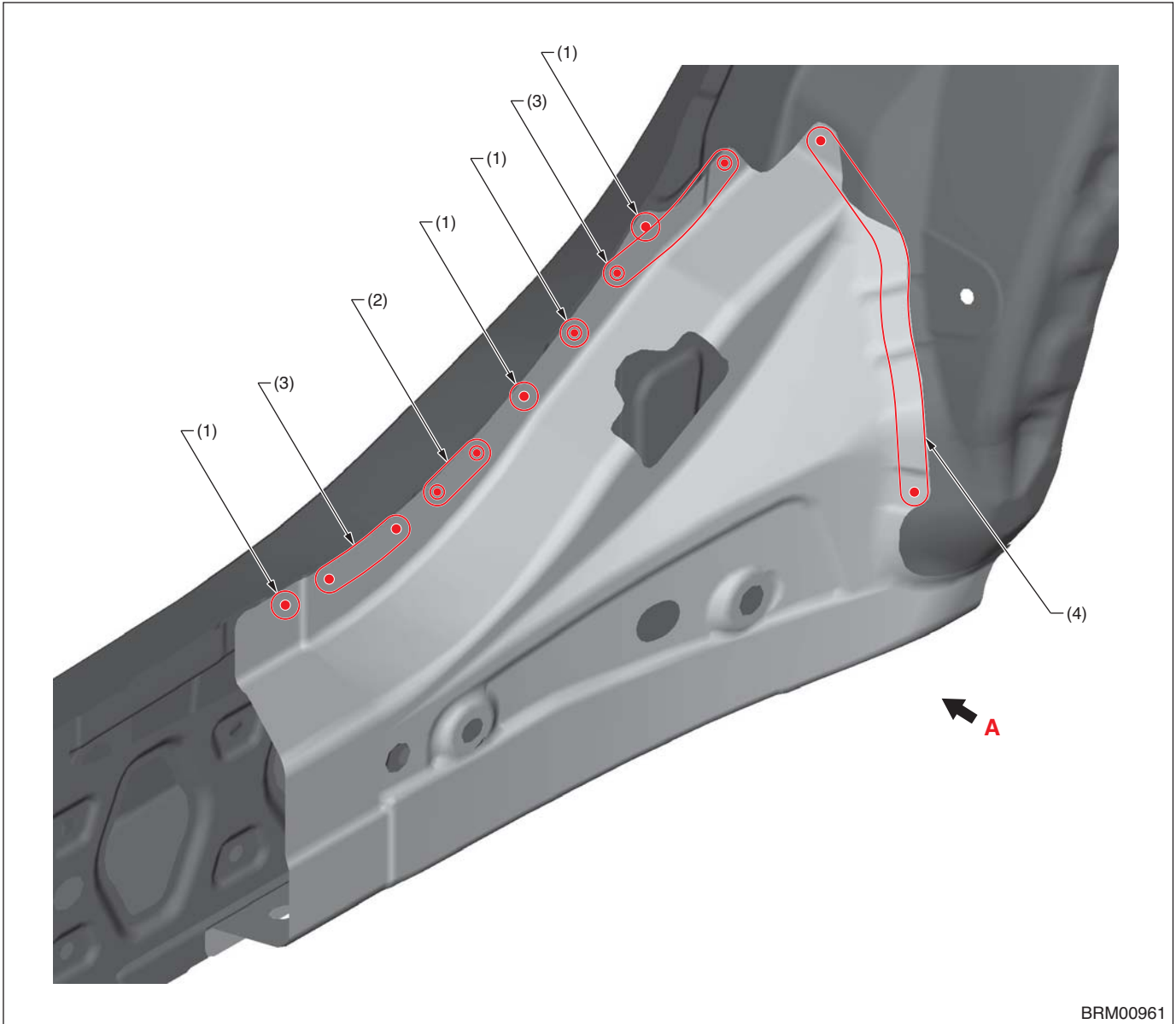
B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO₂: 20 %)

Panel Replacement

8-15. Side Sill Reinforcement Outer Rear (Total replacement)

A: REMOVAL

- Overall view



BRM00961

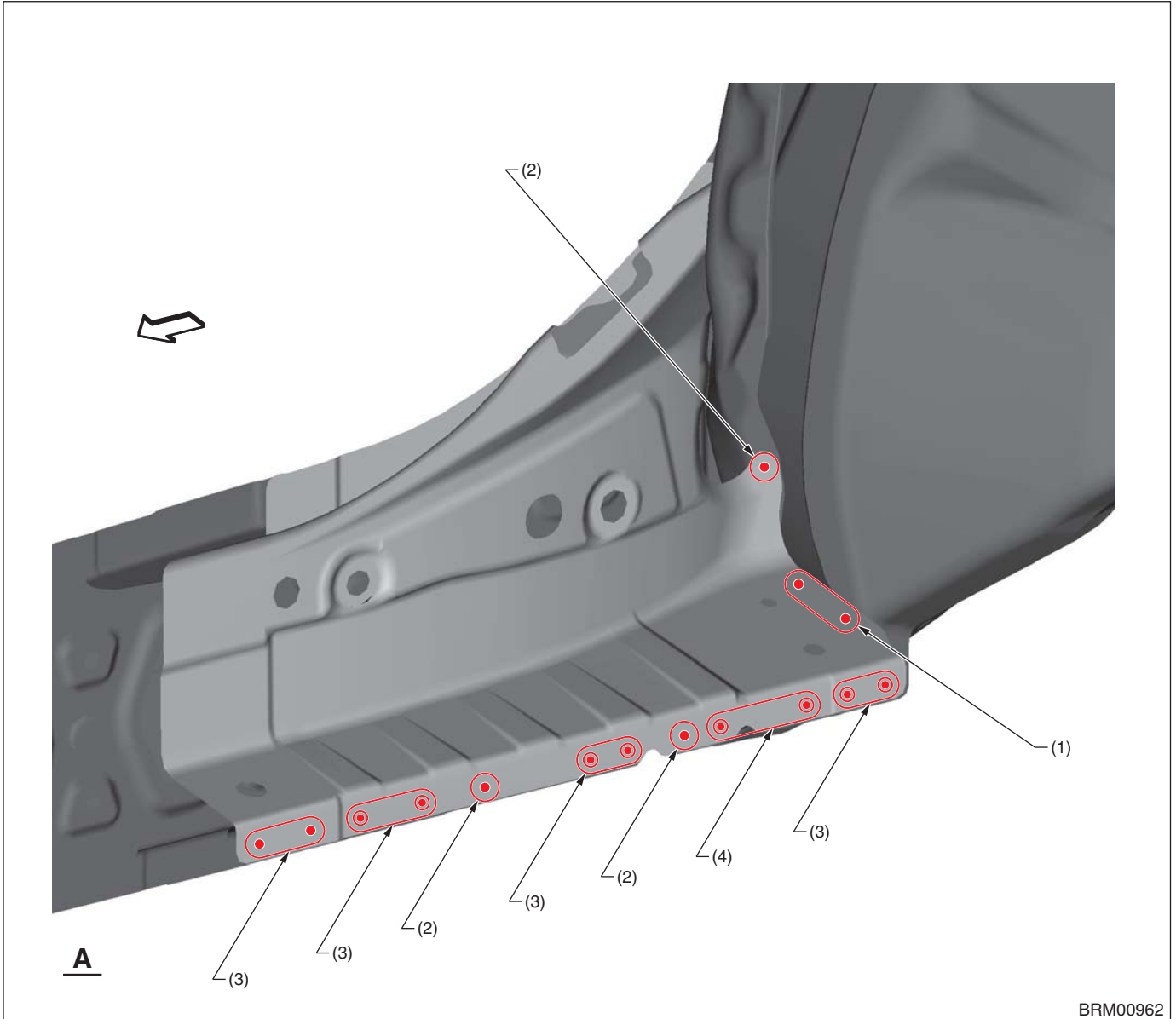
(1) 1 point (outside · 1)
(2) 2 points (outside · 1)

(3) 3 points (outside · 1)

(4) 5 points (outside · 1)

Panel Replacement

• View A



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

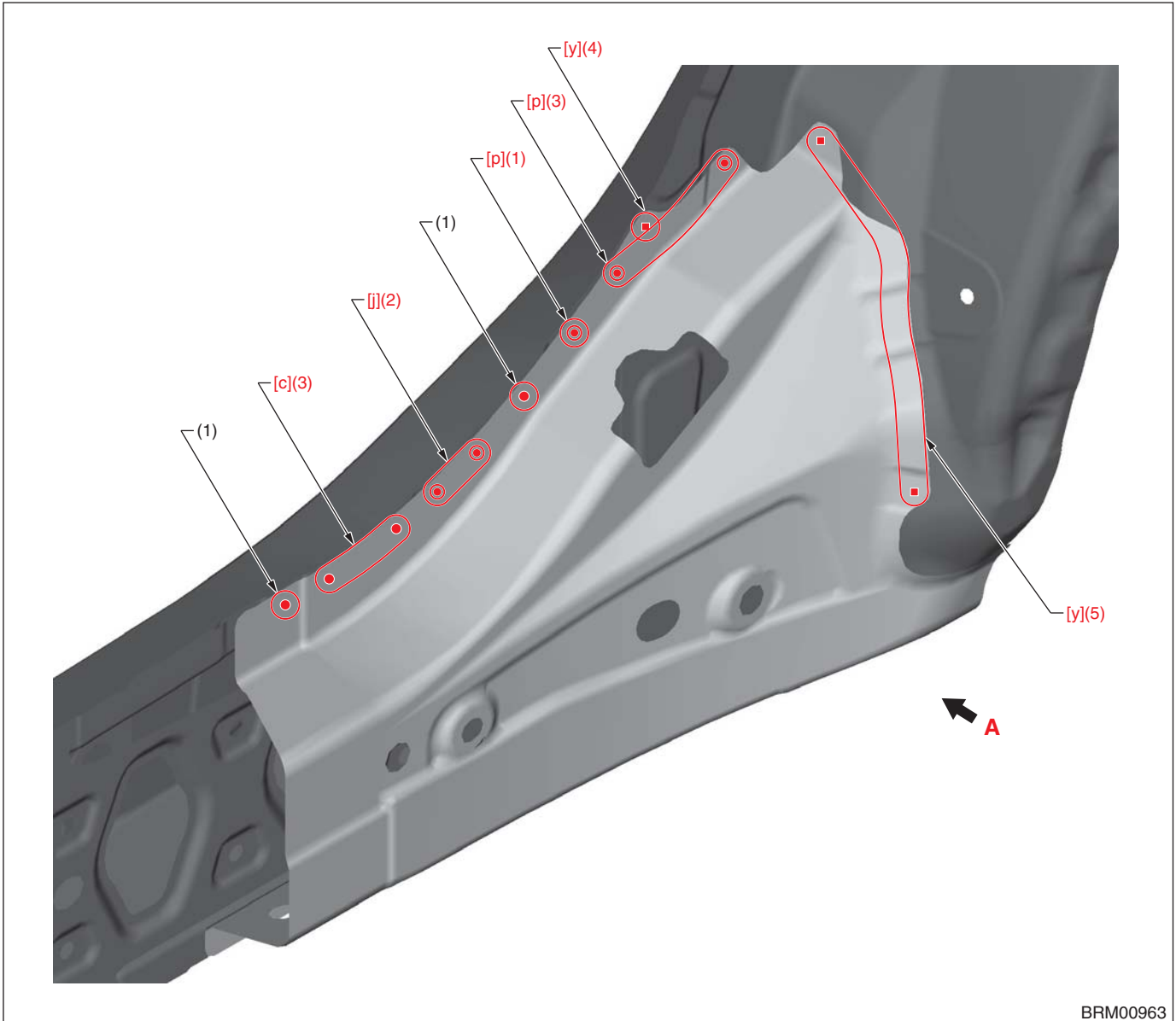
(3) 2 points (outside · 1)

(4) 3 points (outside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BRM00963

(1) 1 point
(2) 2 points

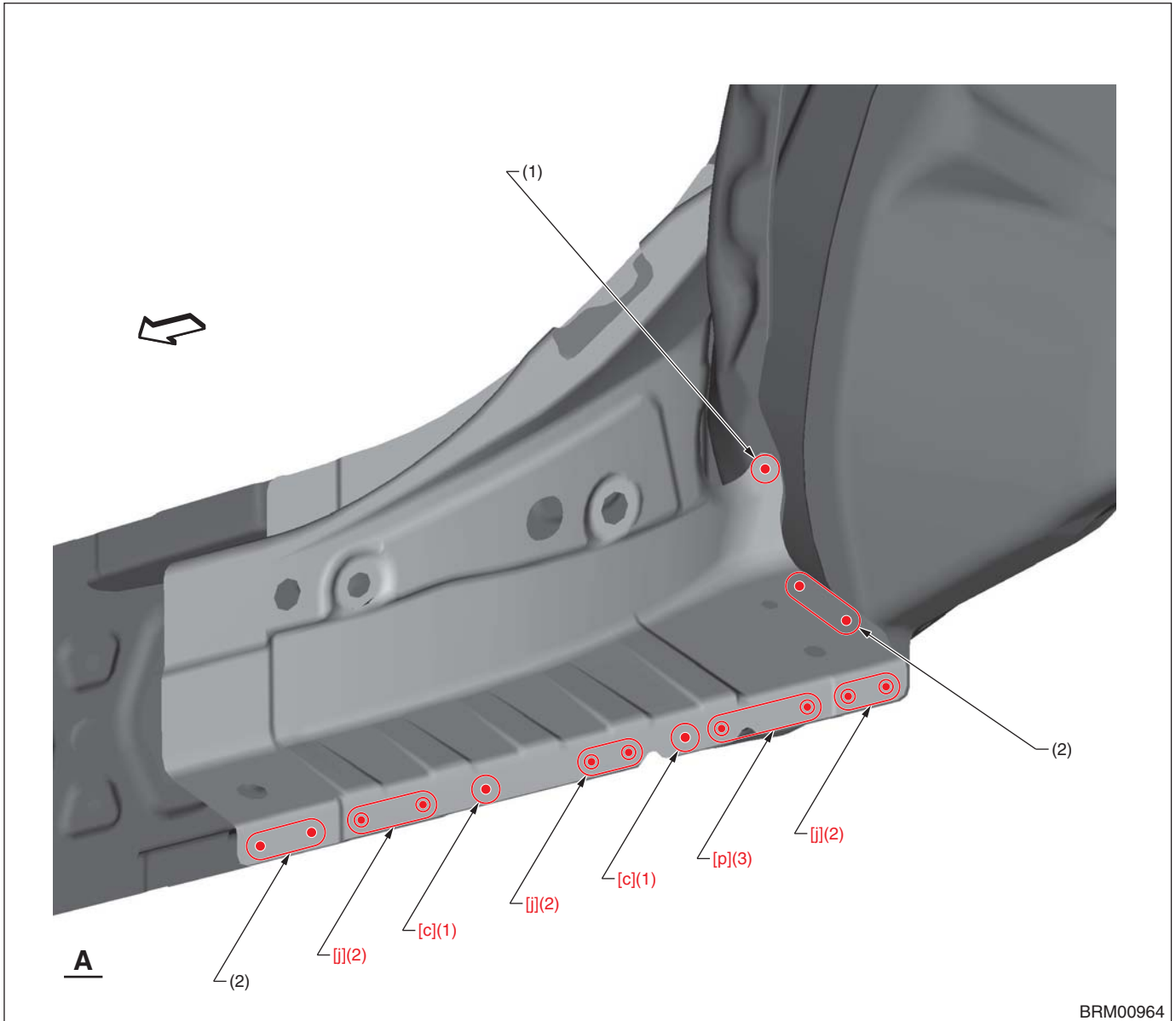
(3) 3 points
(4) 1 point (service)

(5) 5 points (service)

[c] Spot welding	Compression: 4.0 kN, Current: 8.0 kA, Welding time: 22 cyc
[j] Spot welding	Compression: 3.0 kN, Current: 7.0 kA, Welding time: 18 cyc
[p] Spot welding	Compression: 4.0 kN, Current: 8.0 kA, Welding time: 22 cyc
[y] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO ₂ B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO ₂ : 20 %)

Panel Replacement

• View A



(1) 1 point

(2) 2 points

(3) 3 points

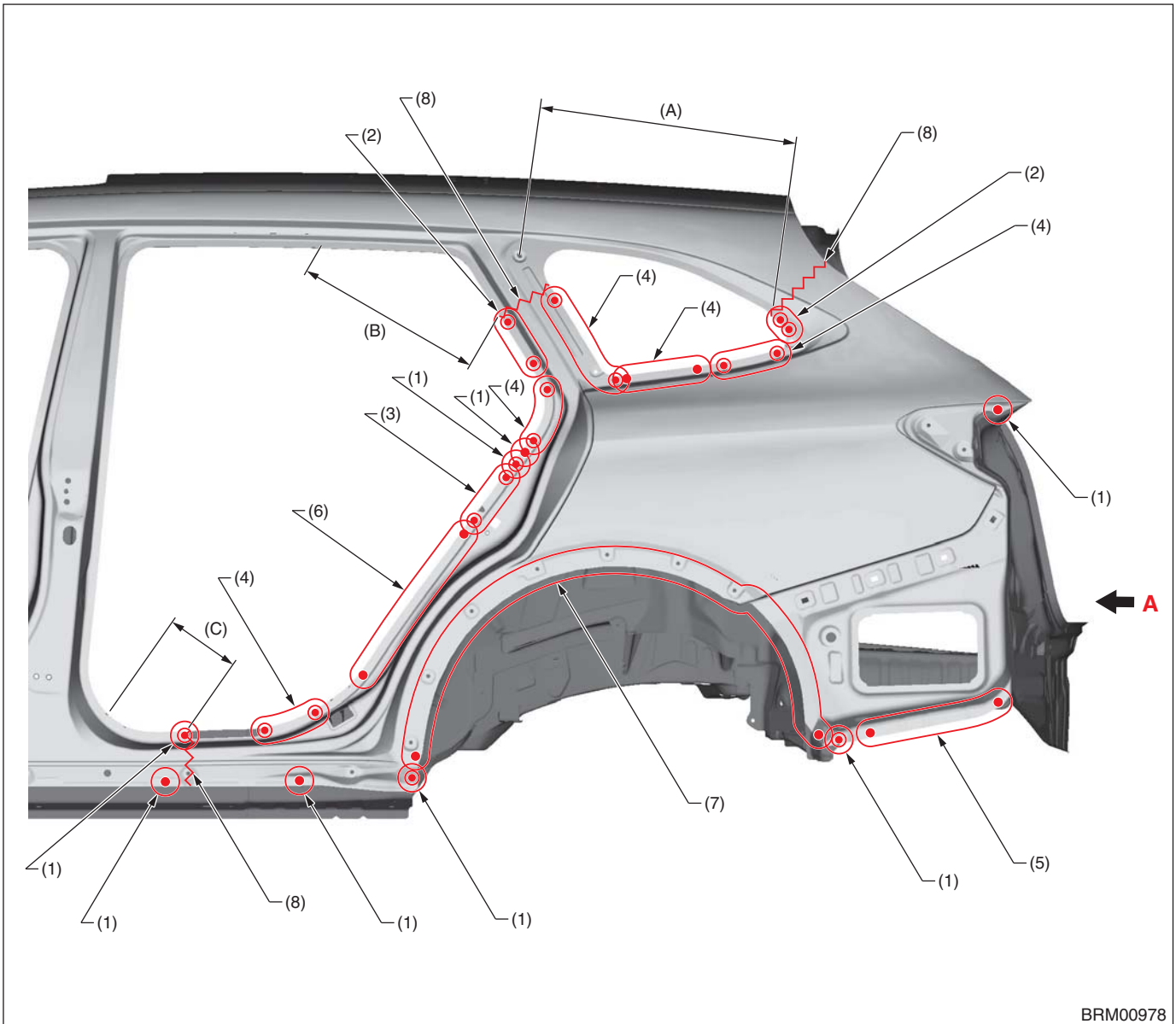
[c] Spot welding	Compression: 4.0 kN, Current: 8.0 kA, Welding time: 22 cyc
[j] Spot welding	Compression: 3.0 kN, Current: 7.0 kA, Welding time: 18 cyc
[p] Spot welding	Compression: 4.0 kN, Current: 8.0 kA, Welding time: 22 cyc

Panel Replacement

8-16. Rear Quarter Panel (Partial replacement) OUTBACK

A: REMOVAL

• Overall view



BRM00978

(A) 540 mm [21.26 in]

(B) 417 mm [16.42 in]

(C) 160 mm [6.30 in]

(1) 1 point (outside · 1)

(4) 3 points (outside · 1)

(7) 19 points (outside · 1)

(2) 2 points (outside · 1)

(5) 7 points (outside · 1)

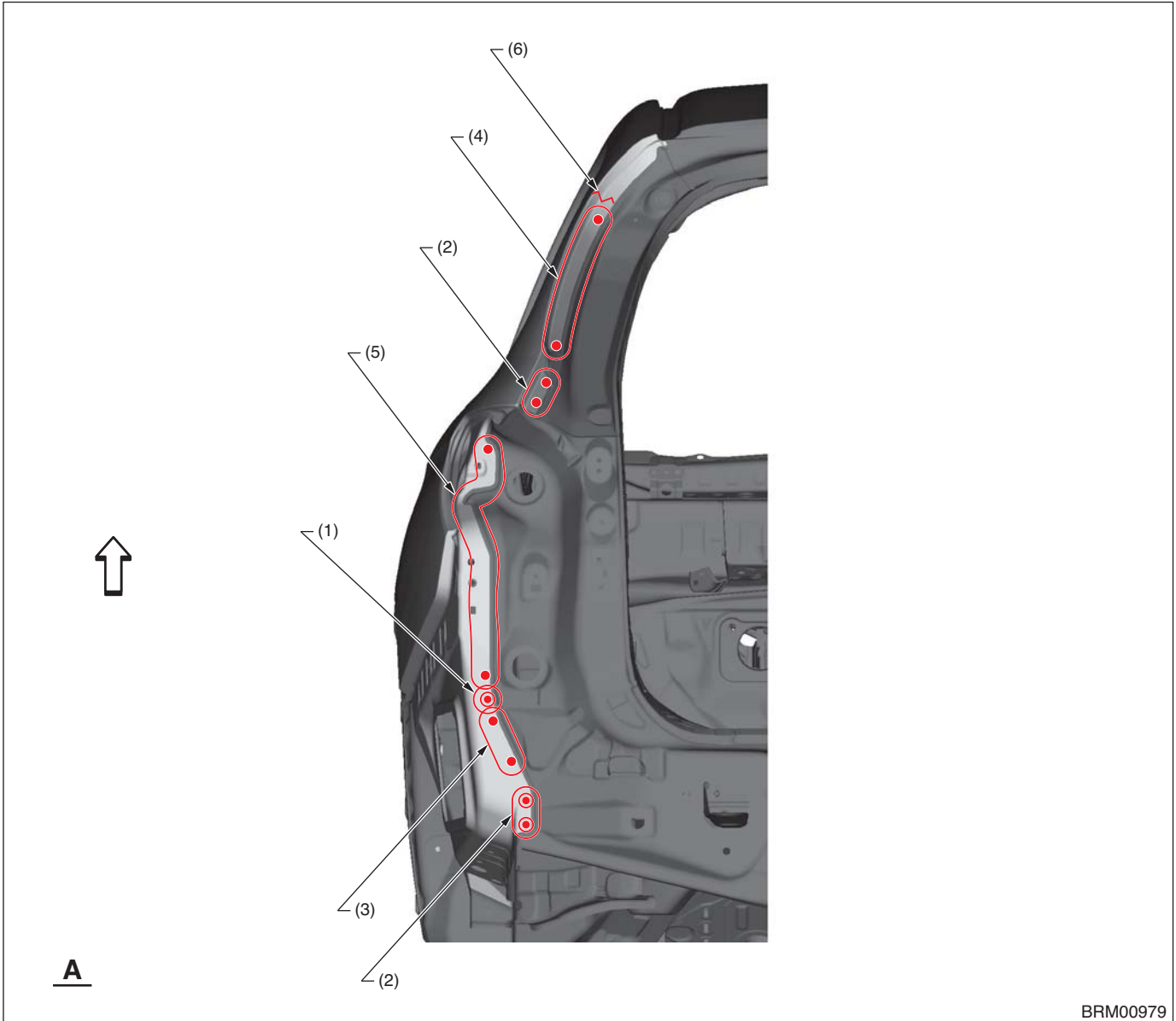
(8) Cut position

(3) 2 points (outside · 2)

(6) 8 points (outside · 1)

Panel Replacement

• View A



BRM00979

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

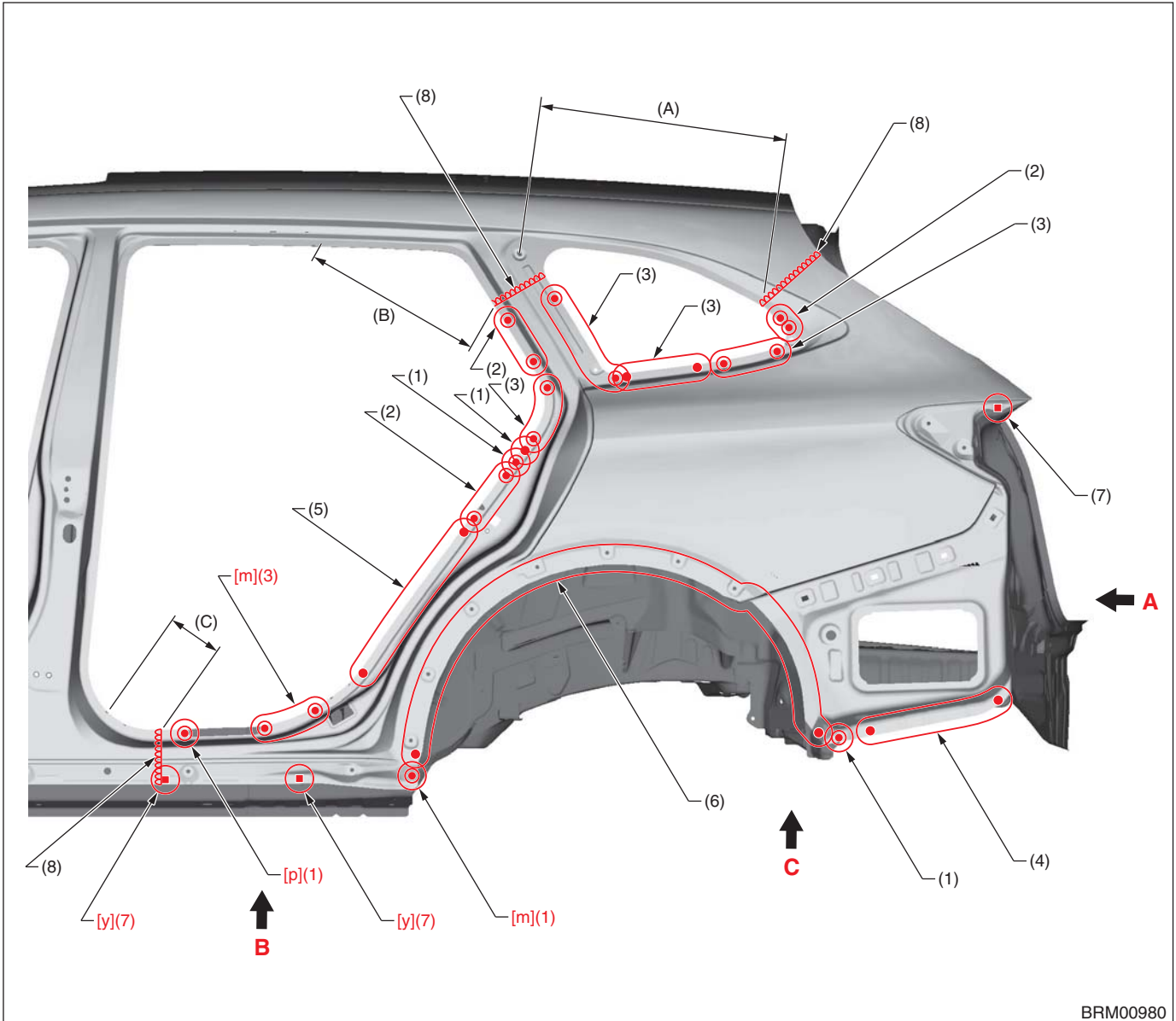
(3) 3 points (outside · 1)
(4) 6 points (outside · 1)

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

Panel Replacement

B: INSTALLATION

• Overall view



BRM00980

(A) 520 mm [20.47 in]

(B) 393 mm [15.47 in]

(C) 120 mm [4.72 in]

(1) 1 point

(4) 7 points

(7) 1 point (service)

(2) 2 points

(5) 8 points

(8) 1 point (Continuous welding)

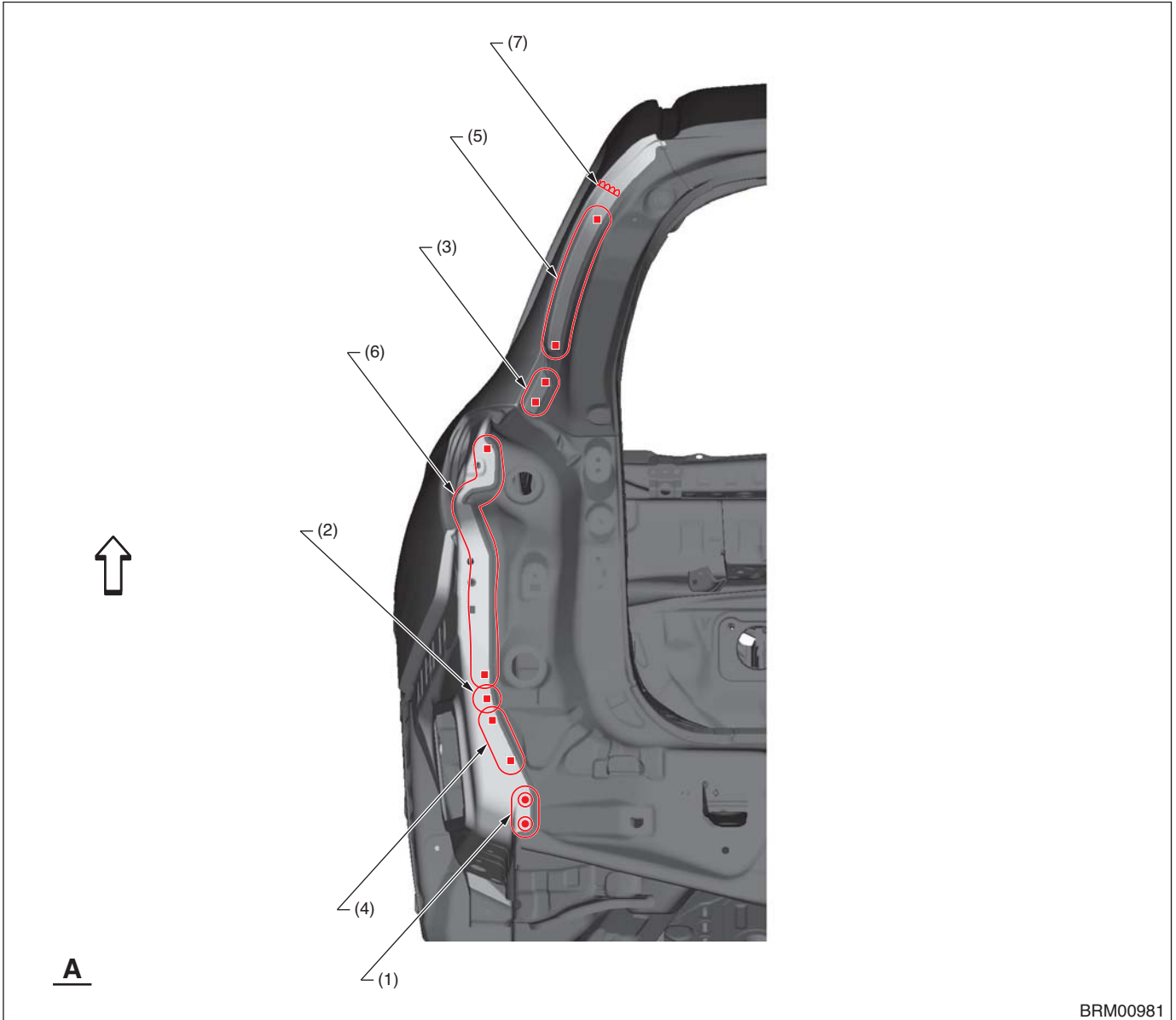
(3) 3 points

(6) 19 points

[m] Spot welding	Compression: 3.5 kN, Current: 7.5 kA, Welding time: 16 cyc
[p] Spot welding	Compression: 4.0 kN, Current: 8.0 kA, Welding time: 22 cyc
[y] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO ₂ B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO ₂ : 20 %)

Panel Replacement

• View A



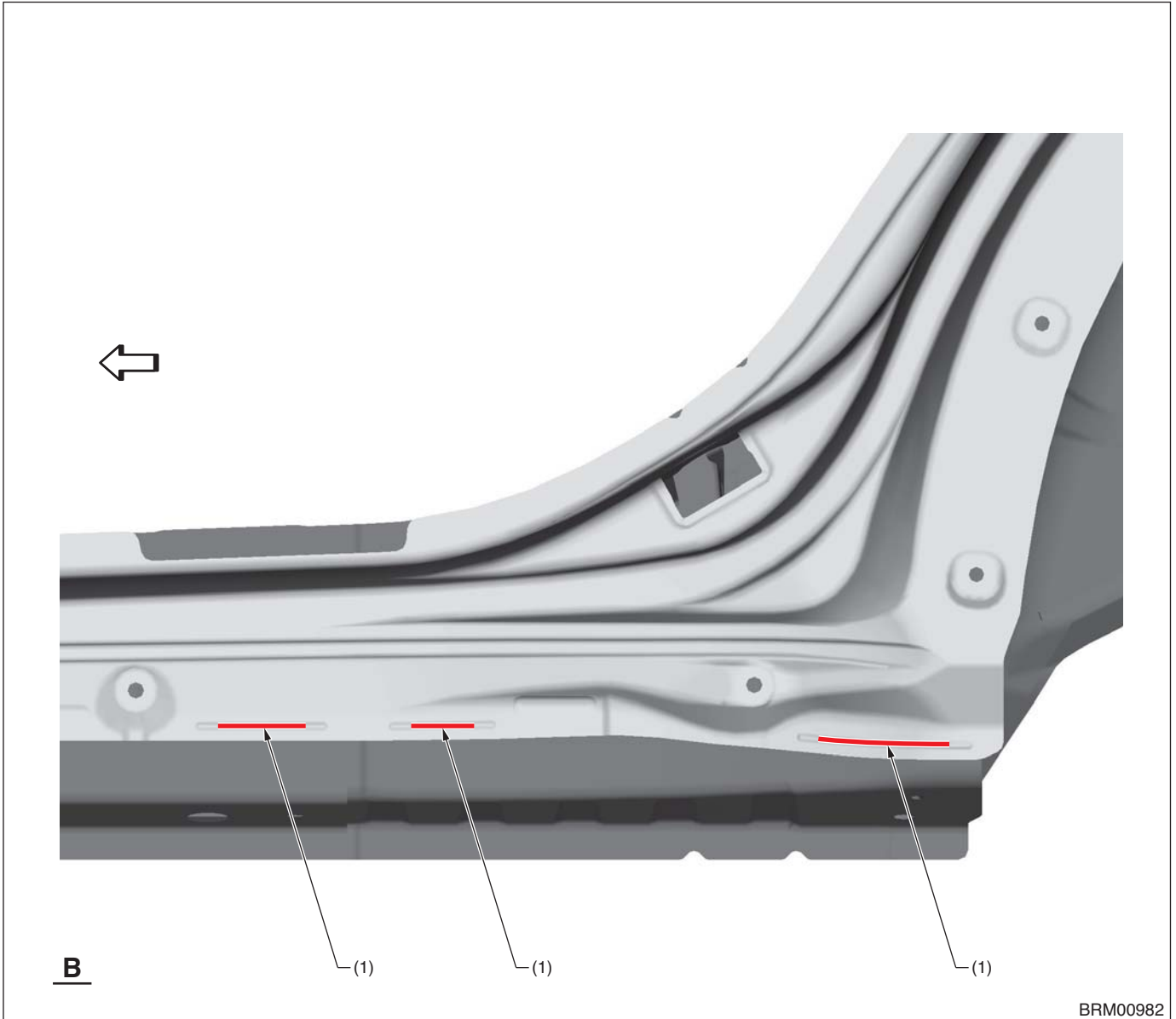
- (1) 2 points
- (2) 1 point (service)
- (3) 2 points (service)

- (4) 3 points (service)
- (5) 6 points (service)
- (6) 7 points (service)

- (7) 1 point (Continuous welding)

Panel Replacement

• View B

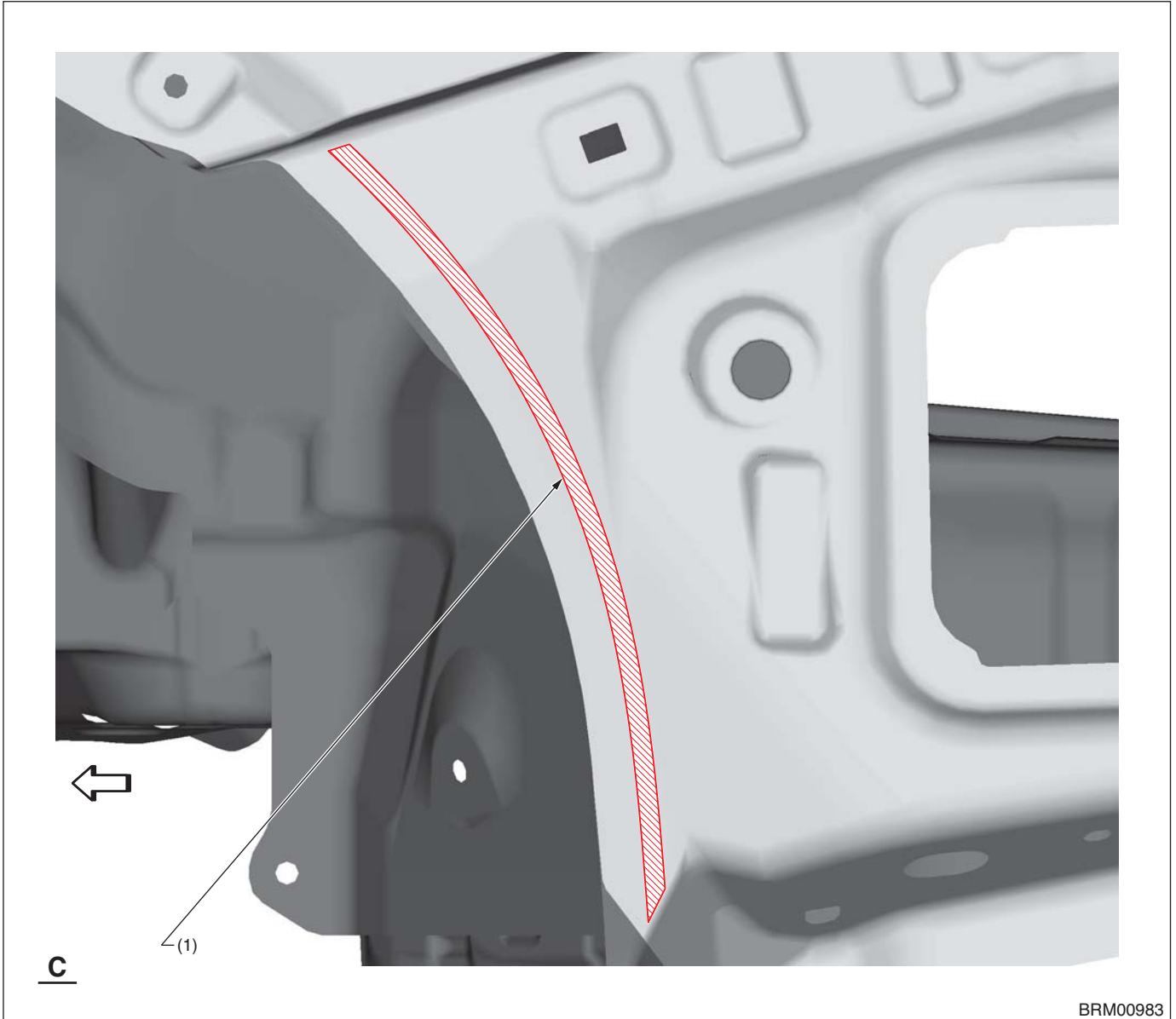


(1) Structural adhesive


— : Structural adhesive application location (Panel bond mini 38315 made by 3M or equivalent)

Panel Replacement

• View C



(1) Spotting sealer

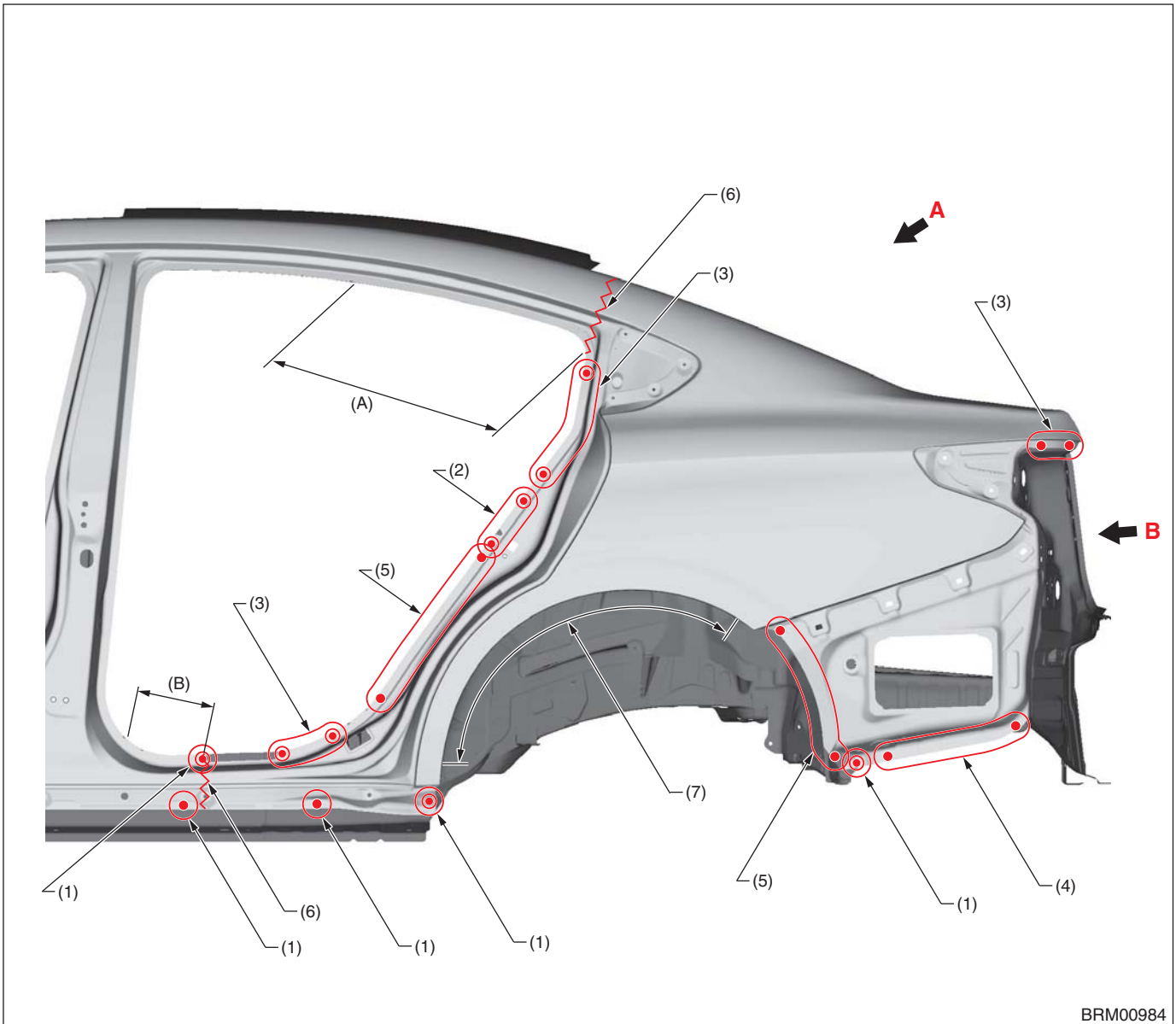
 : Spotting sealer application location (spotting sealer or sealing [Three Bond 4101 (004403063)])

Panel Replacement

8-17. Rear Quarter Panel (Partial replacement) SEDAN

A: REMOVAL

• Overall view



(A) 506 mm [19.92 in]

(B) 160 mm [6.30 in]

(1) 1 point (outside · 1)

(4) 7 points (outside · 1)

(7) Hemming area
(bottom · 1 belt sander)

(2) 2 points (outside · 2)

(5) 8 points (outside · 1)

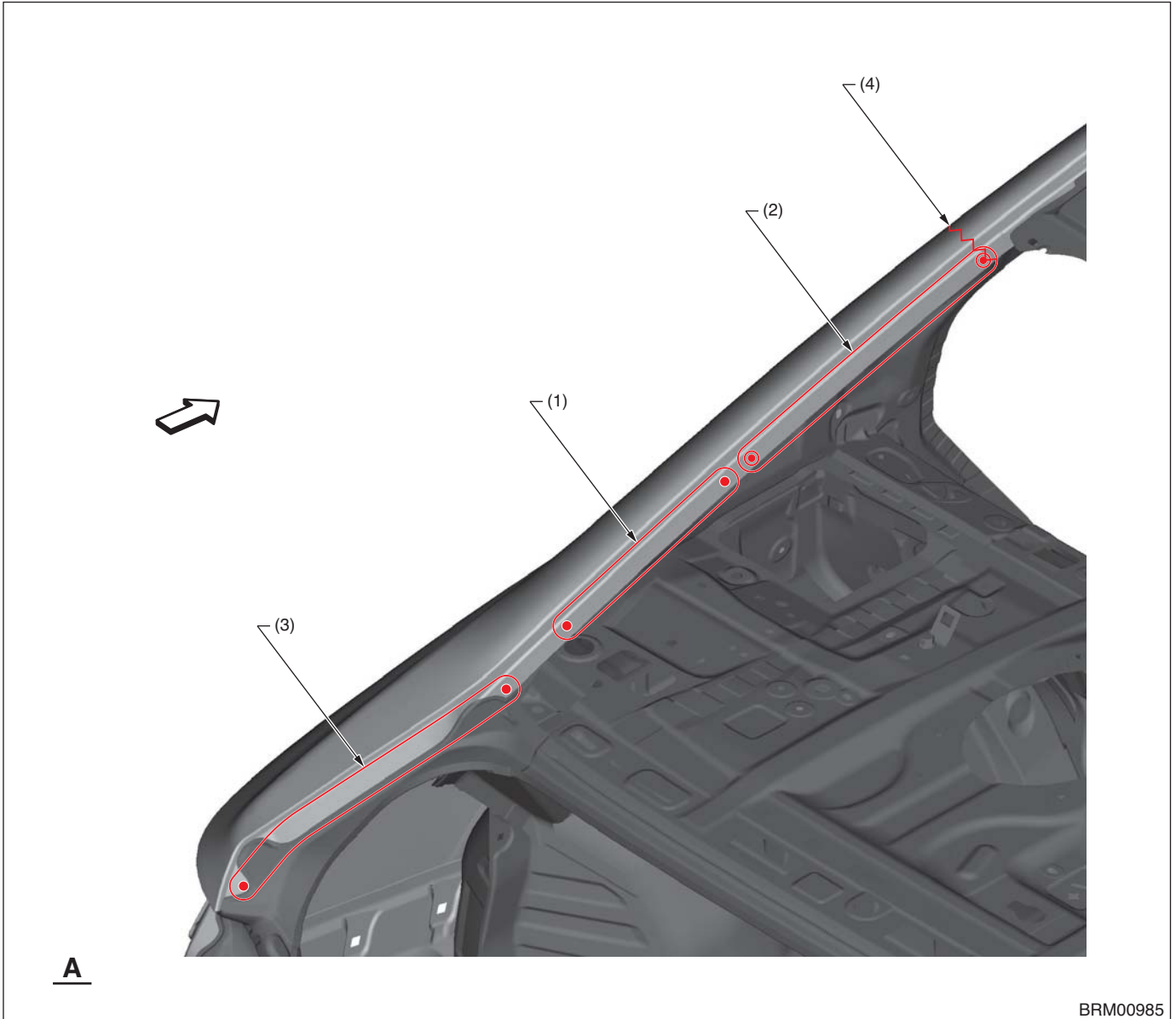
(3) 3 points (outside · 1)

(6) Cut position

Note: For the hemming range, scrape off only the edge of the panel side outer folding area.

Panel Replacement

• View A



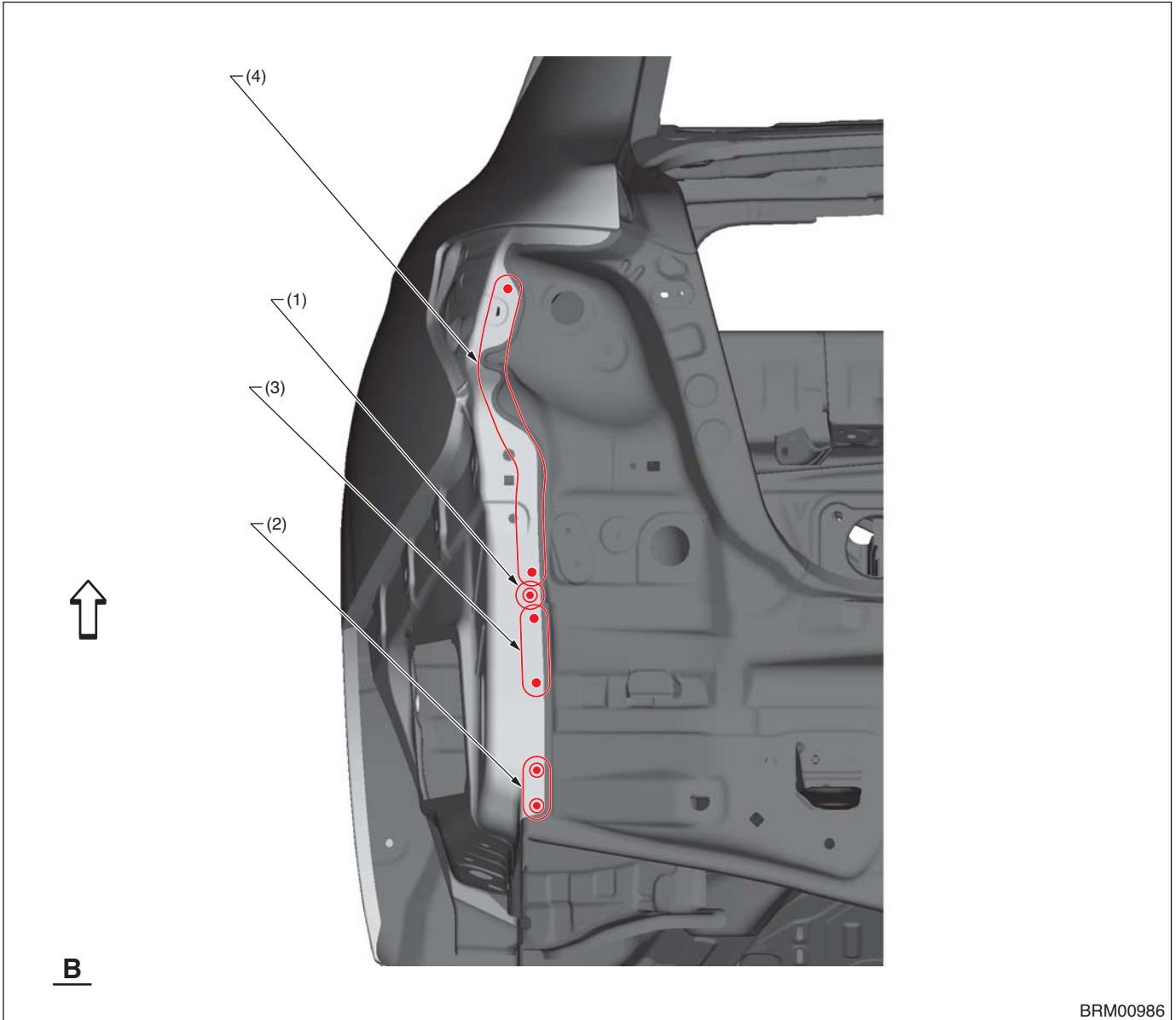
(1) 4 points (top · 1)
(2) 5 points (top · 1)

(3) 6 points (inside · 1)

(4) Cut position

Panel Replacement

• View B



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

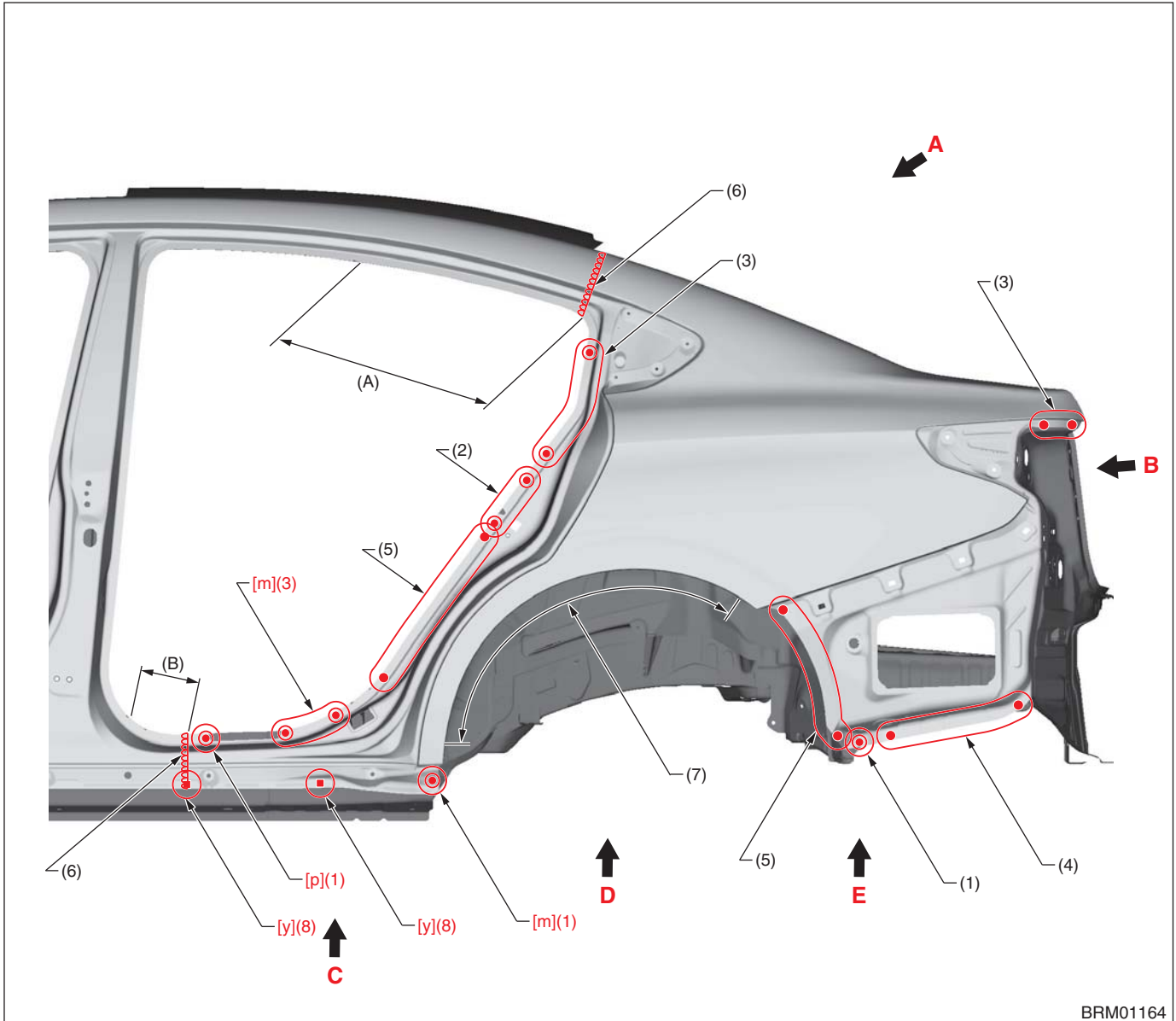
(3) 3 points (outside · 1)

(4) 8 points (outside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BRM01164

(A) 483 mm [19.02 in]

(B) 120 mm [4.72 in]

(1) 1 point

(4) 7 points

(7) Hemming area

(2) 2 points

(5) 8 points

(8) 1 point (service)

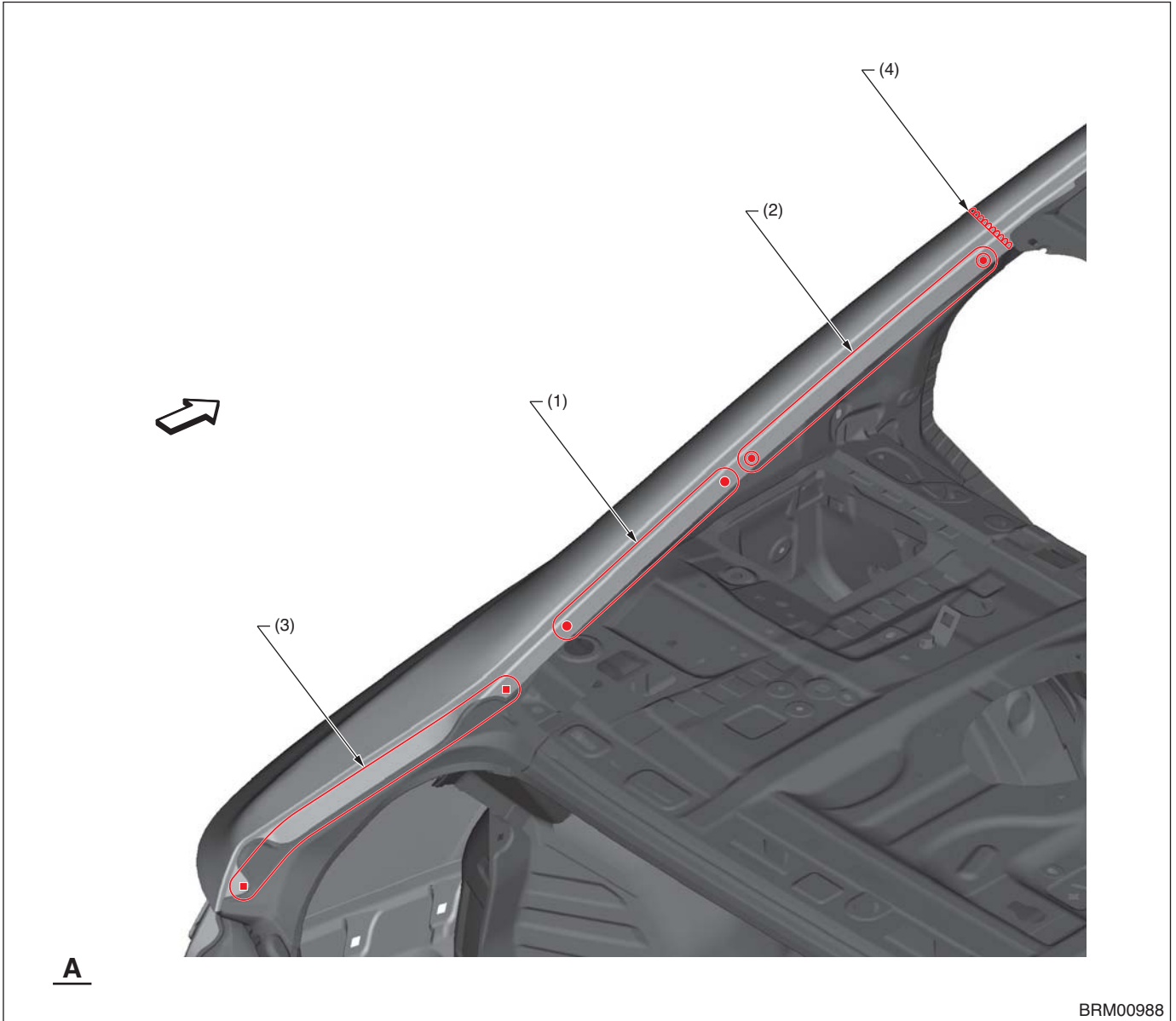
(3) 3 points

(6) 1 point (Continuous welding)

[m] Spot welding	Compression: 3.5 kN, Current: 7.5 kA, Welding time: 16 cyc
[p] Spot welding	Compression: 4.0 kN, Current: 8.0 kA, Welding time: 22 cyc
[y] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO ₂ B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO ₂ : 20 %)

Panel Replacement

• View A



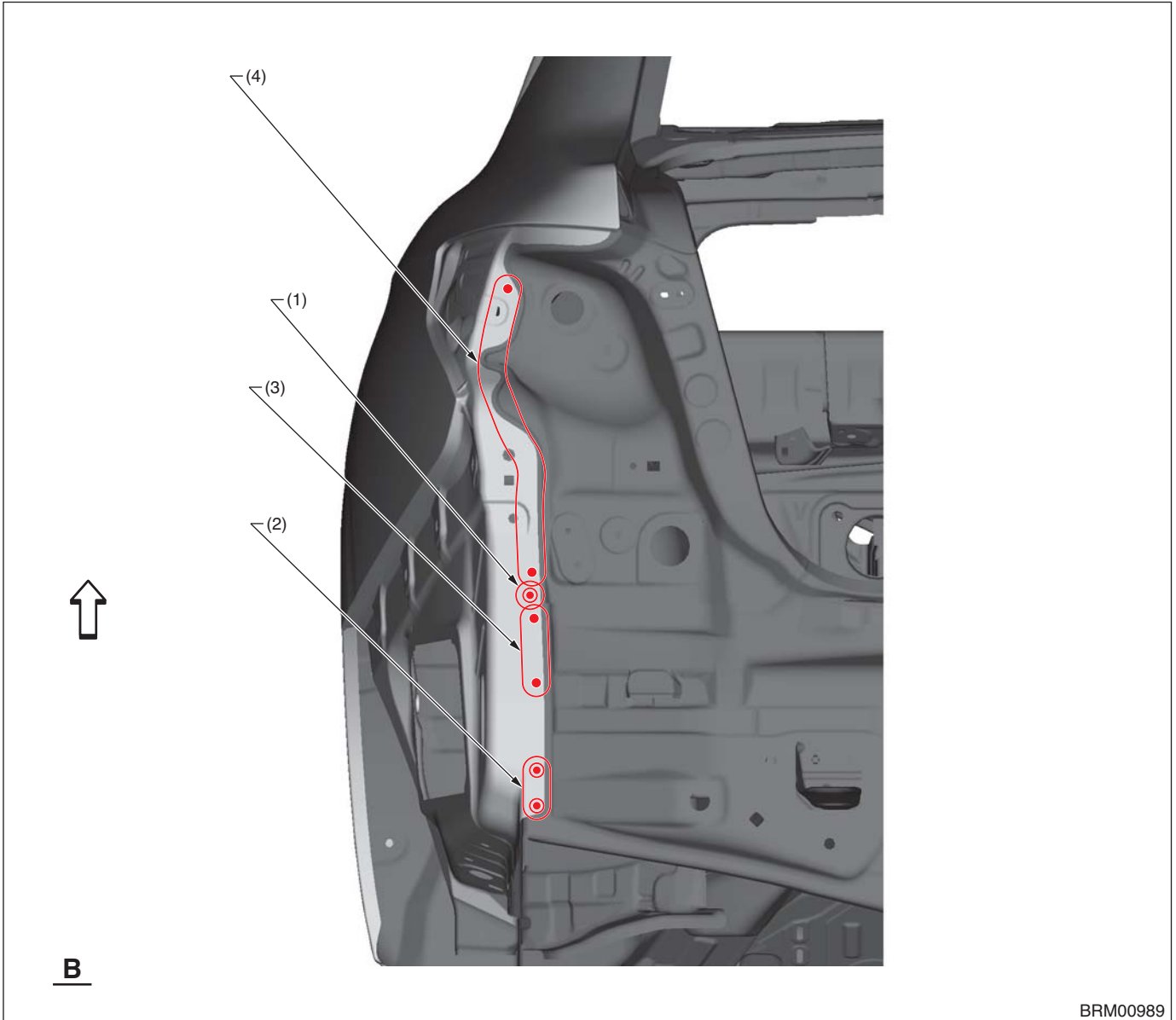
(1) 4 points
(2) 5 points

(3) 6 points (service)

(4) 1 point (Continuous welding)

Panel Replacement

• View B



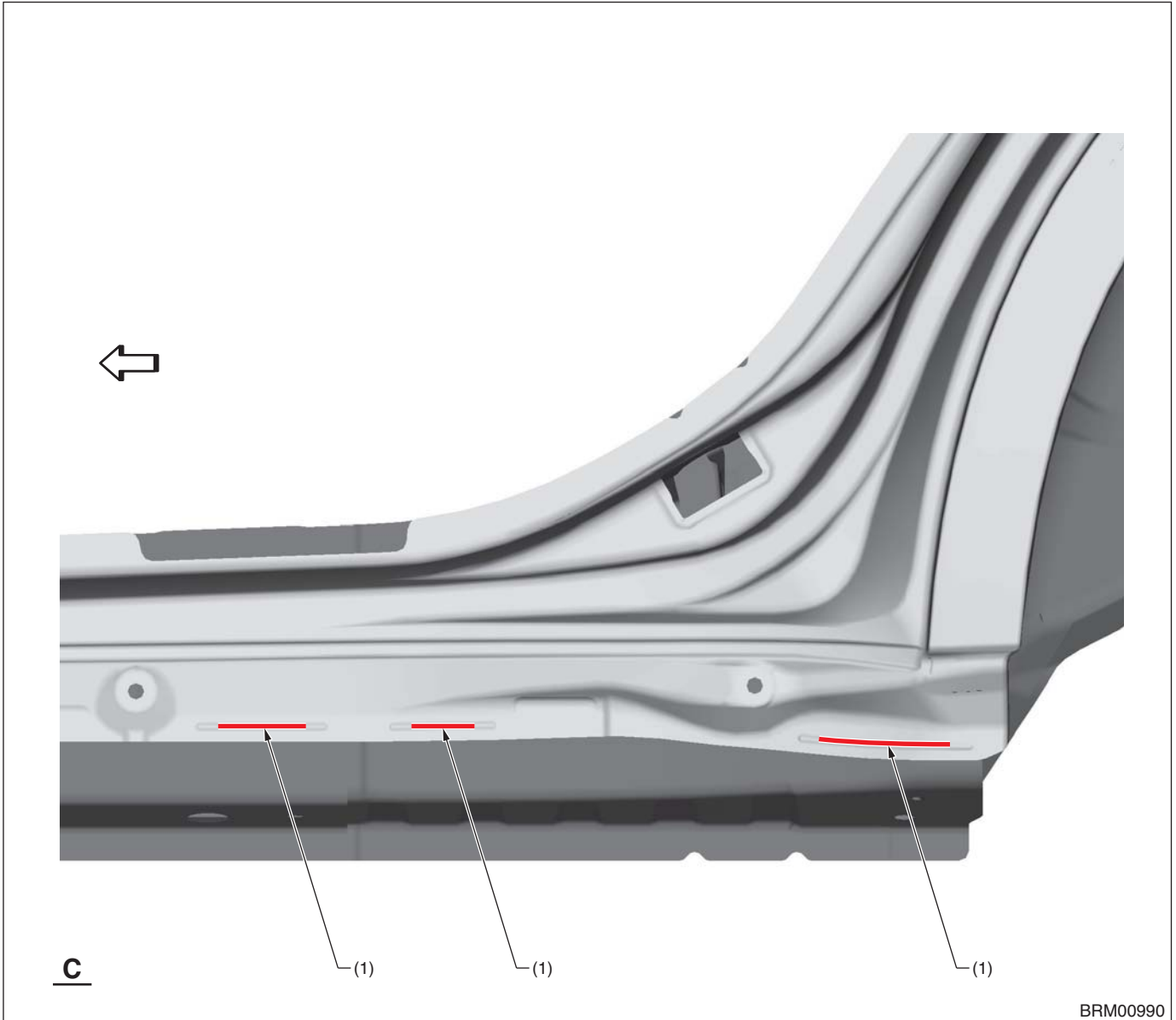
- (1) 1 point
- (2) 2 points

(3) 3 points

(4) 8 points

Panel Replacement

• View C

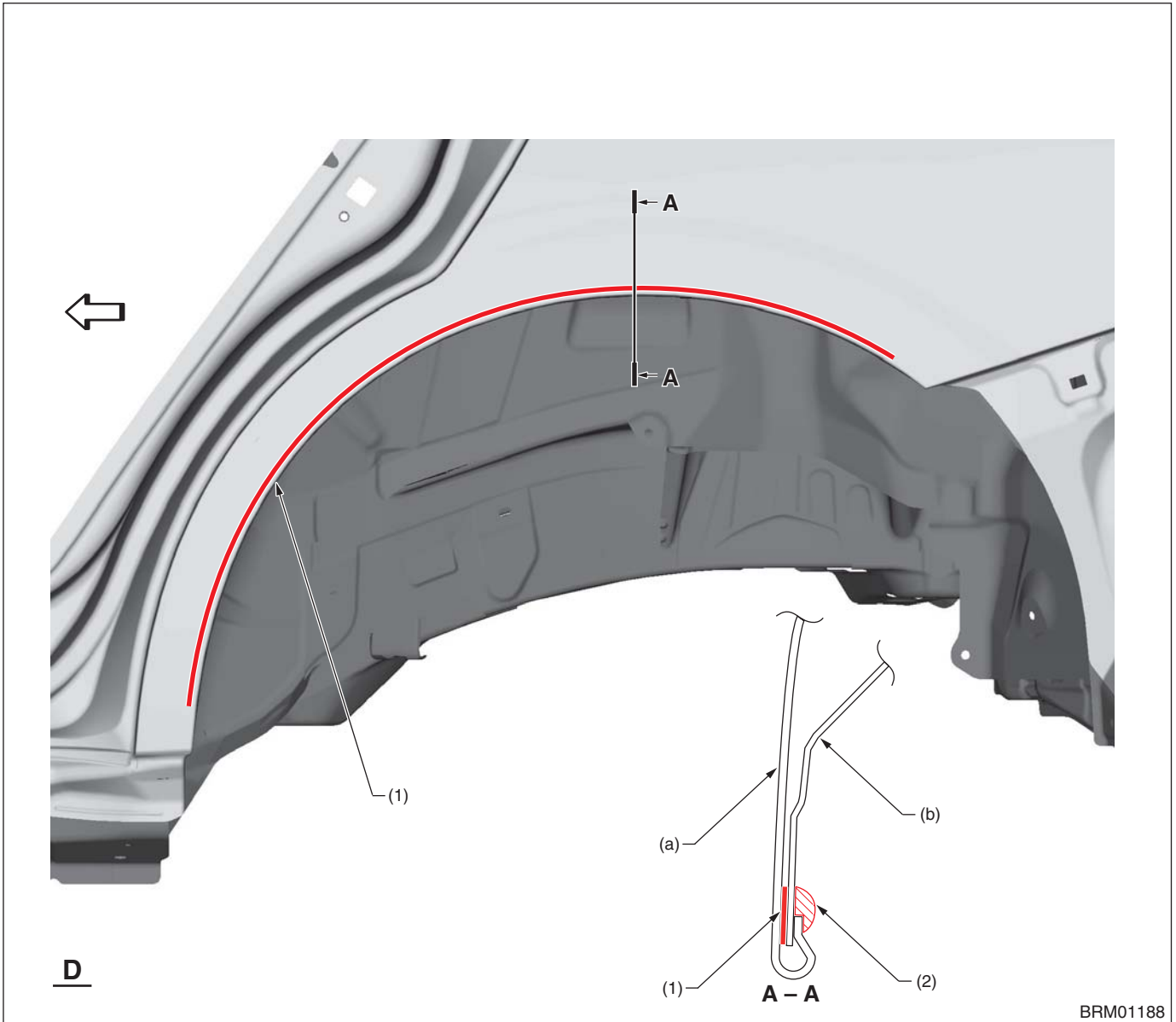


(1) Structural adhesive

— : Structural adhesive application location (Panel bond mini 38315 made by 3M or equivalent)

Panel Replacement

• View D

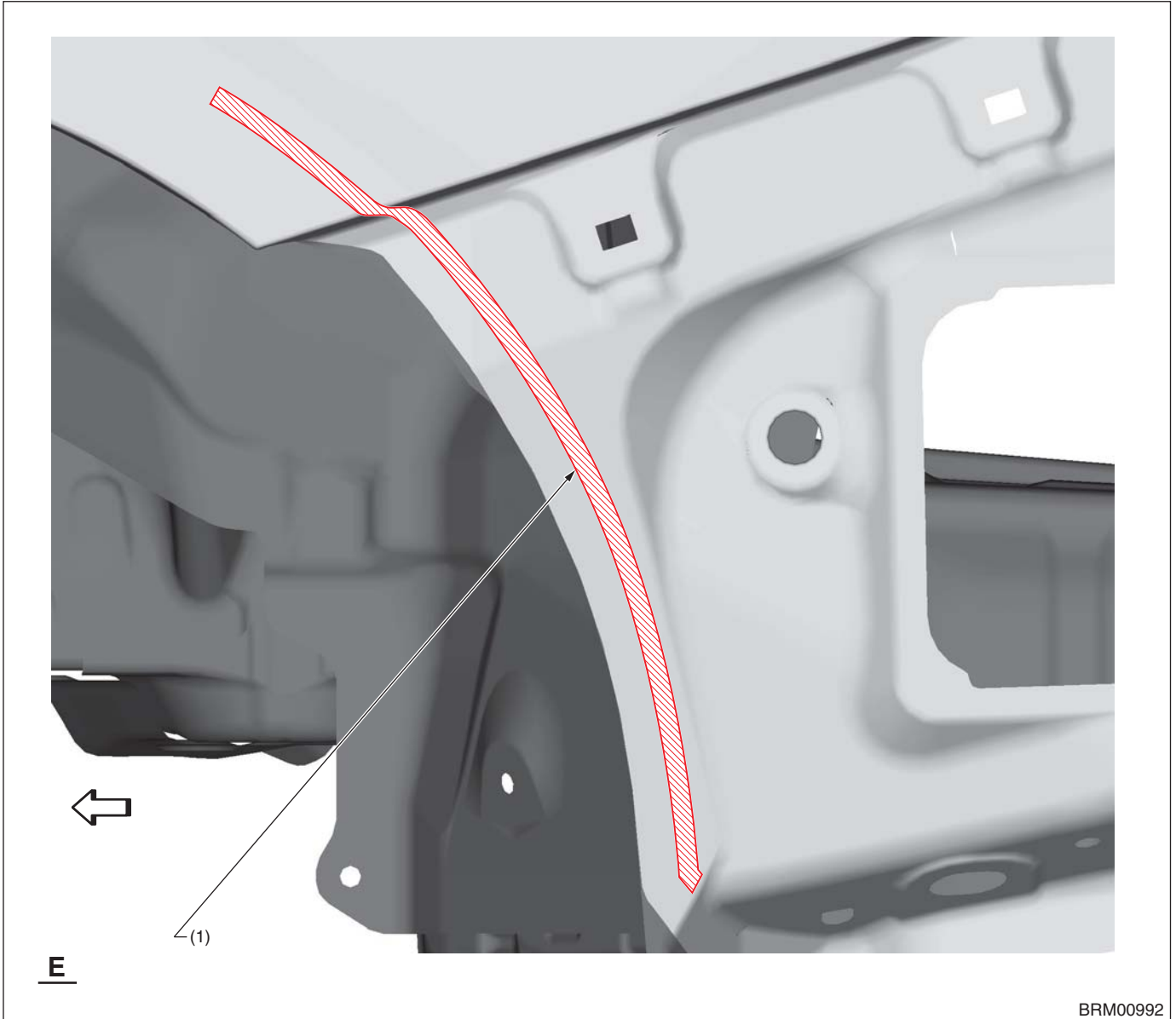


- (a) Rear quarter complete, outer (b) Rear arch, inner
(1) Structural adhesive (2) Sealing

— : Structural adhesive application location (Panel bond mini 38315 made by 3M or equivalent)
▨ : Sealer application location ([Three Bond 4101 (004403063)])


Panel Replacement

• View E



BRM00992

(1) Spotting sealer

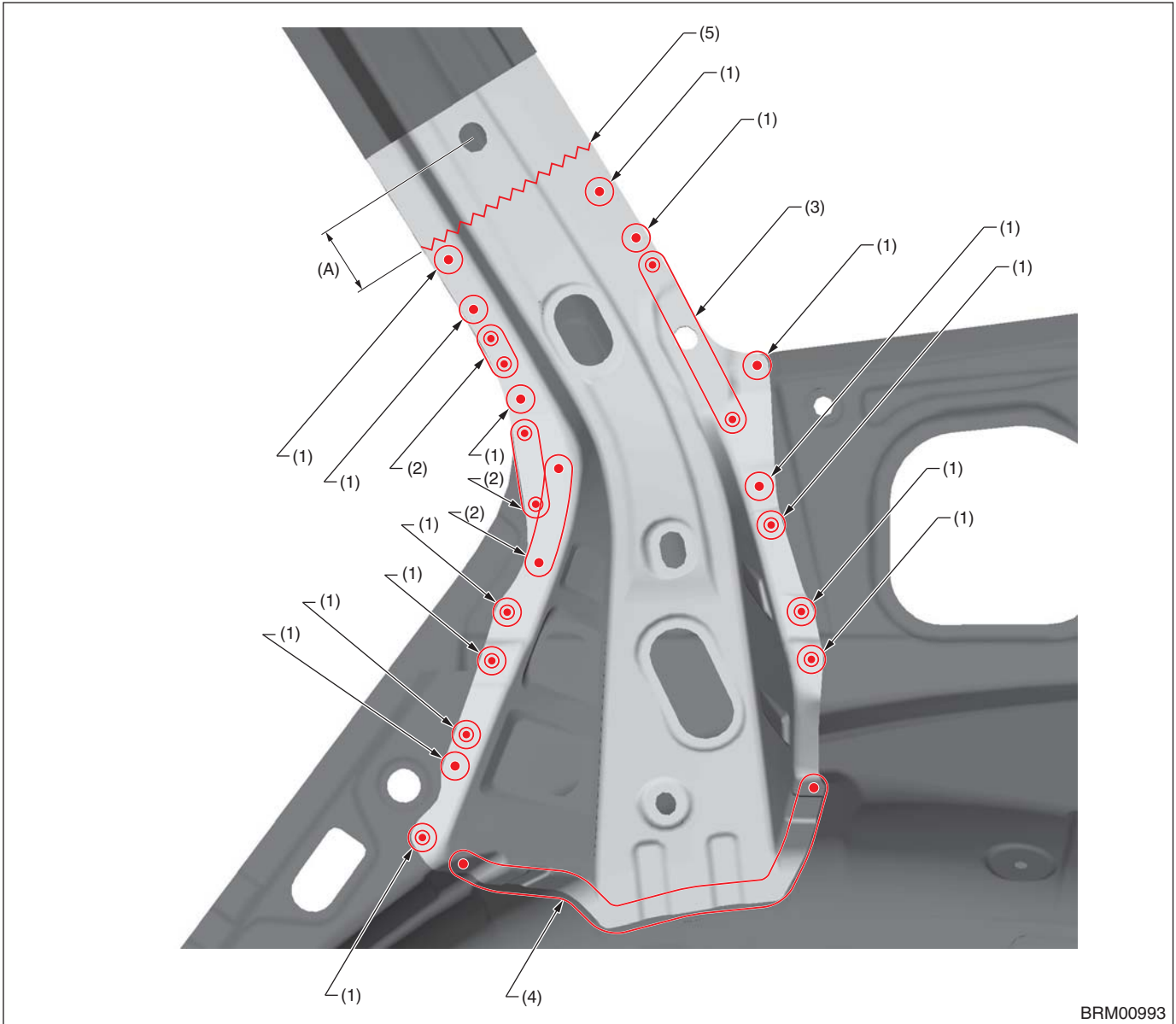
 : Spotting sealer application location (spotting sealer or sealing [Three Bond 4101 (004403063)])

Panel Replacement

8-18. Rear Pillar Reinforcement Outer (Total replacement) OUTBACK

A: REMOVAL

• Overall view



BRM00993

(A) 45 mm [1.77 in]

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

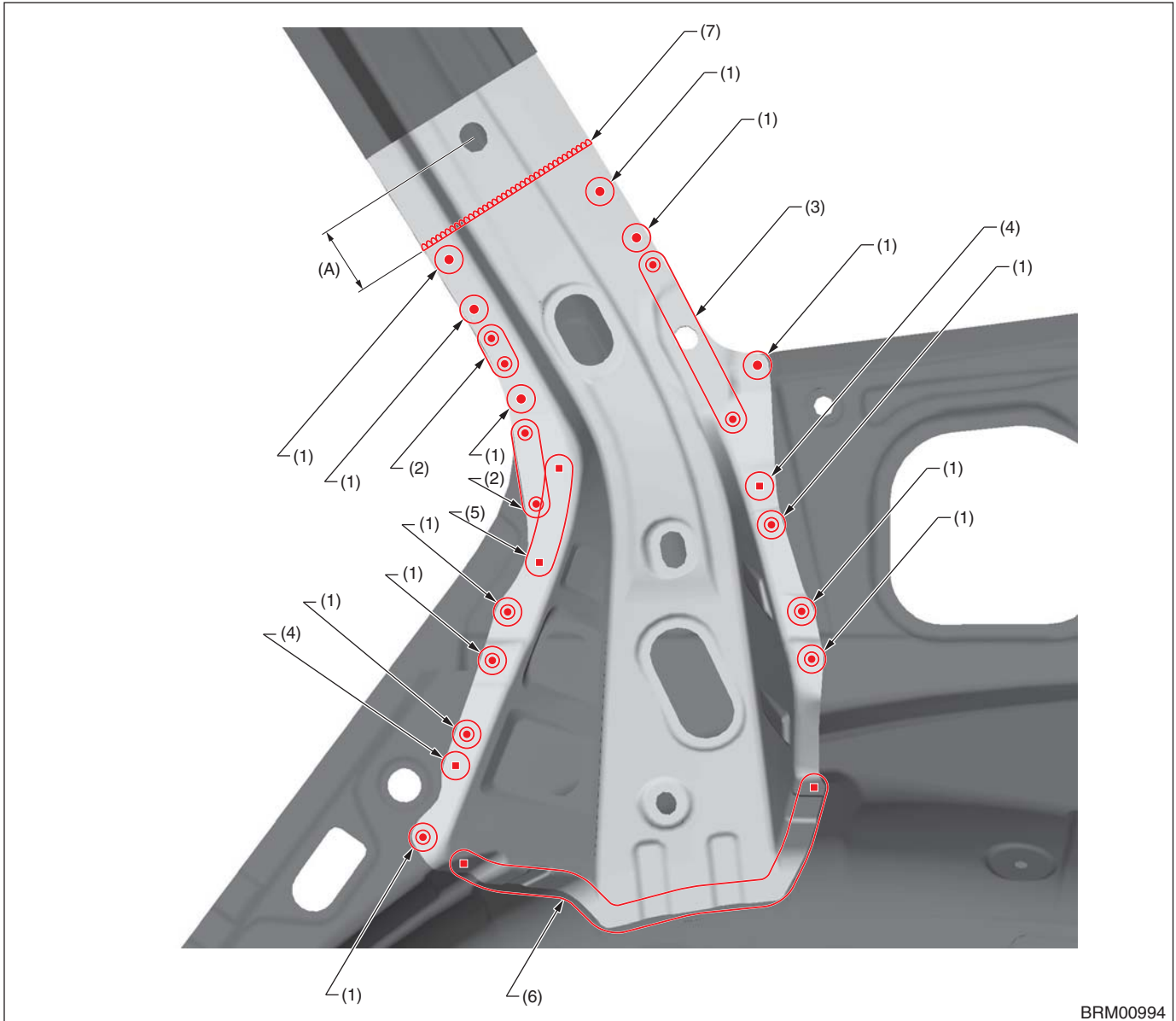
(3) 4 points (outside · 1)
(4) 8 points (outside · 1)

(5) Cut position

Panel Replacement

B: INSTALLATION

• Overall view



BRM00994

(A) 45 mm [1.77 in]

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

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

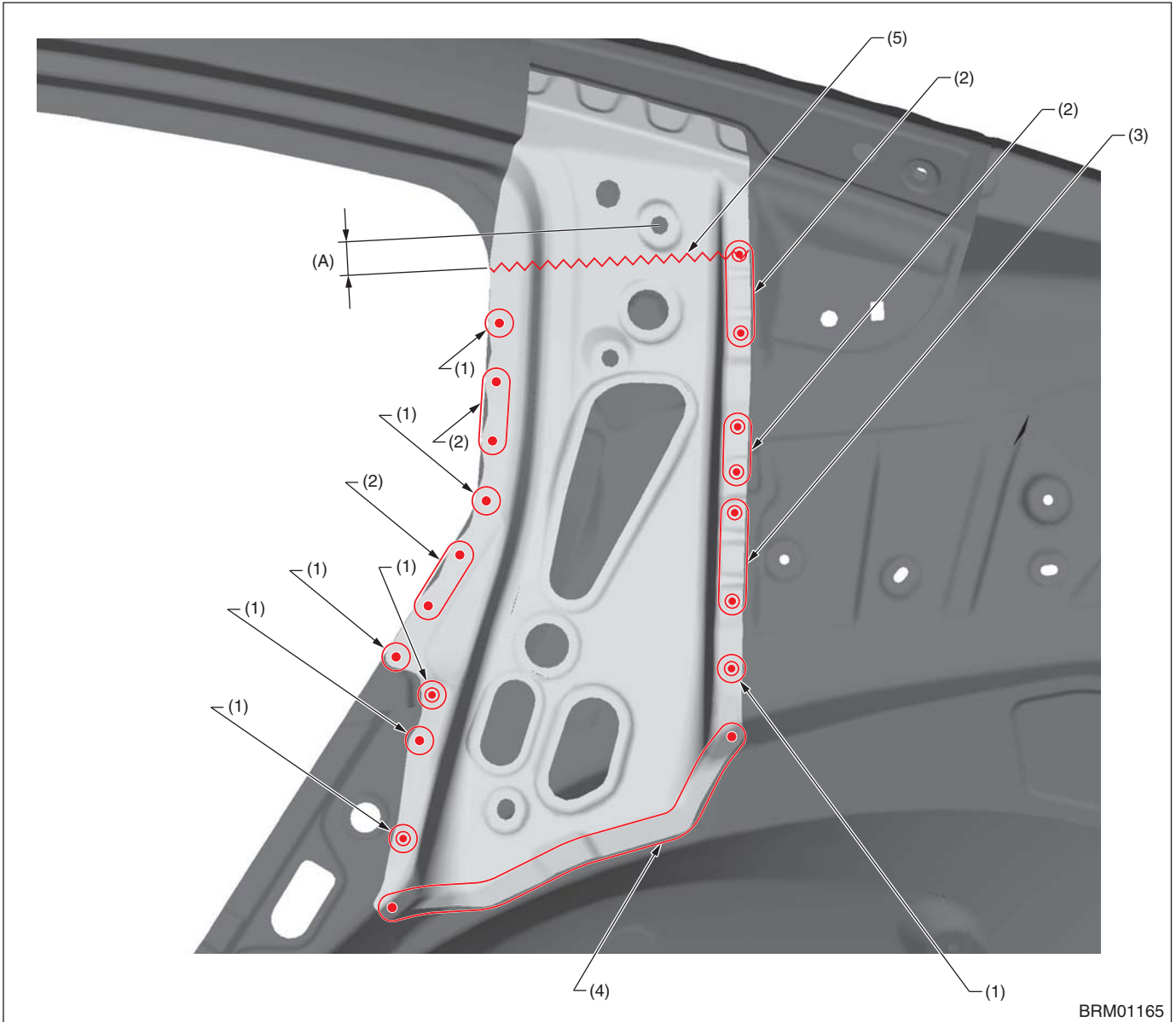
- (7) 1 point (Continuous welding)

Panel Replacement

8-19. Rear Pillar Reinforcement Outer (Total replacement) SEDAN

A: REMOVAL

• Overall view



(A) 27 mm [1.06 in]

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

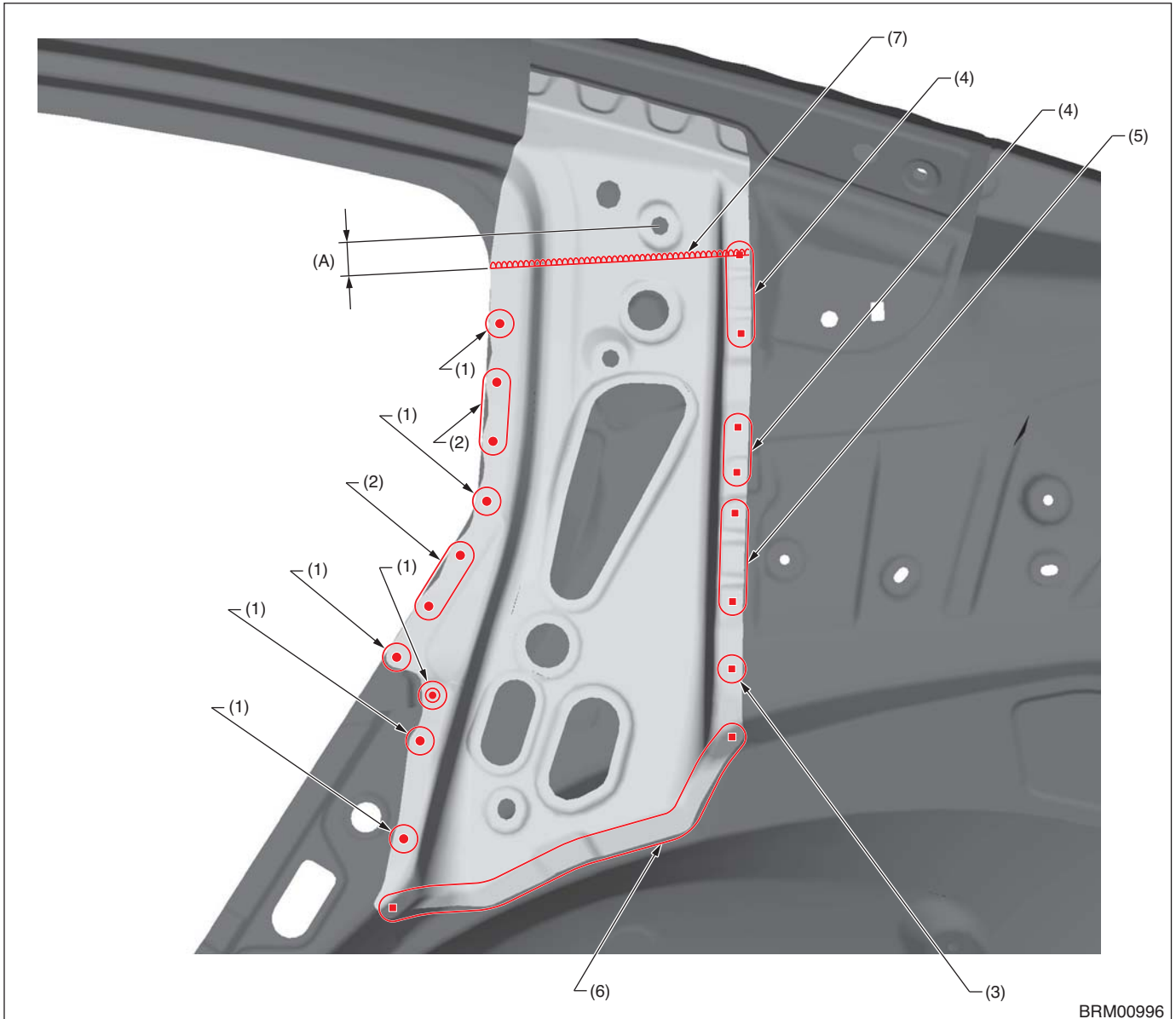
(3) 3 points (outside · 1)
(4) 6 points (outside · 1)

(5) Cut position

Panel Replacement

B: INSTALLATION

• Overall view



BRM00996

(A) 27 mm [1.06 in]

(1) 1 point

(2) 2 points

(3) 1 point (service)

(4) 2 points (service)

(5) 3 points (service)

(6) 6 points (service)

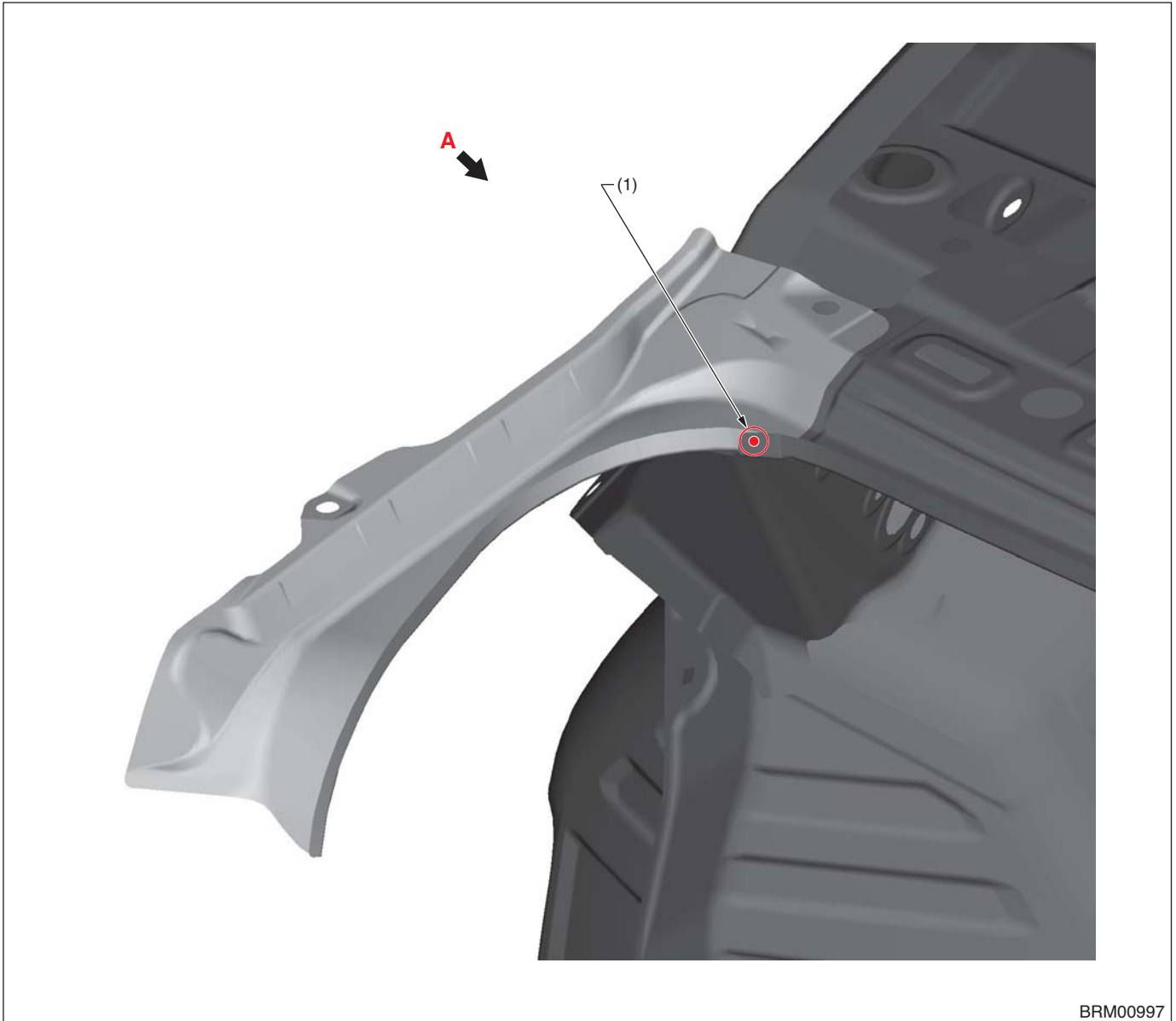
(7) 1 point (Continuous welding)

Panel Replacement

8-20. Patch Rear Pillar · Corner Patch (Total replacement) SEDAN

A: REMOVAL

- Overall view

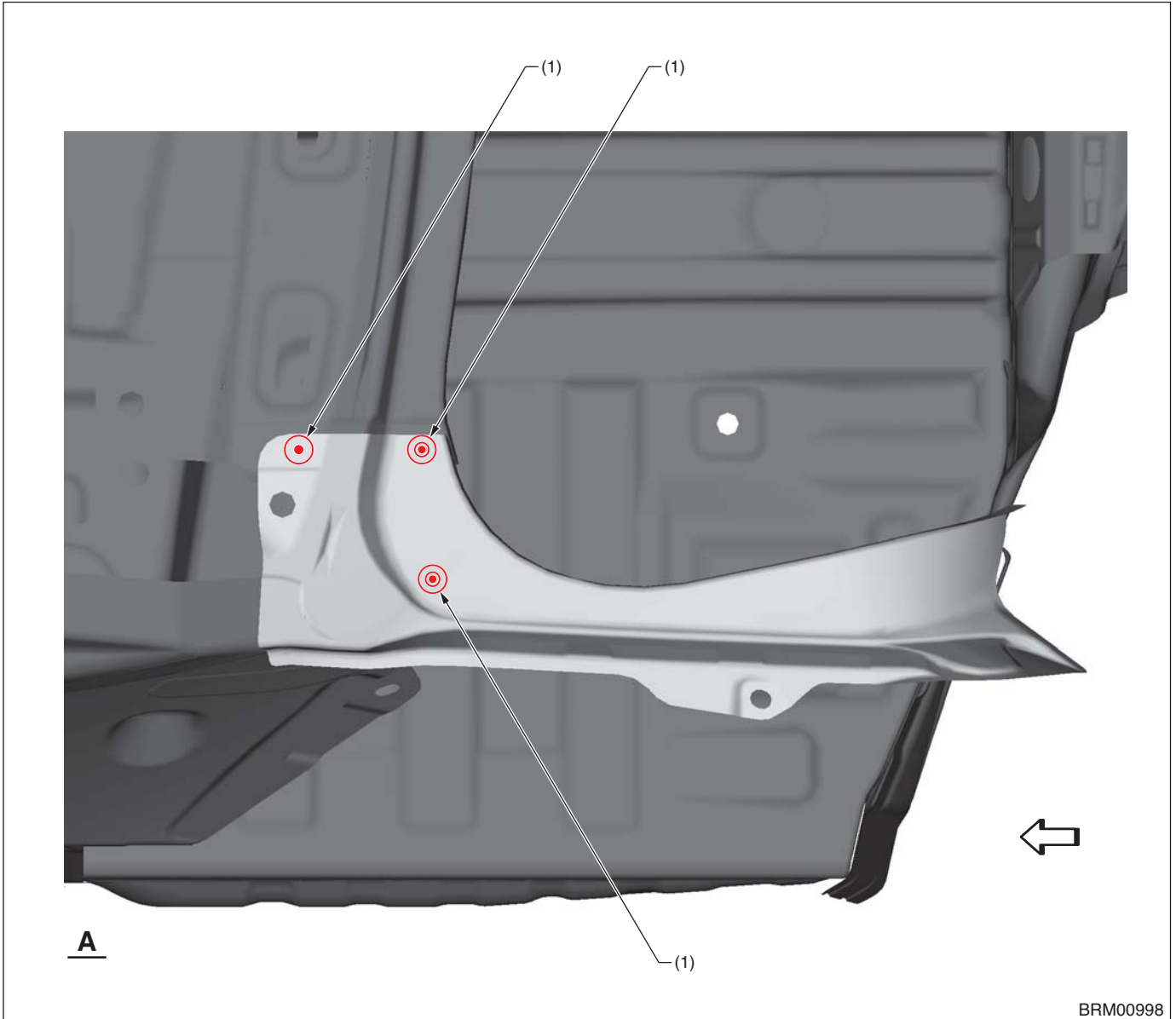


BRM00997

- (1) 1 point (outside · 1)

Panel Replacement

• View A

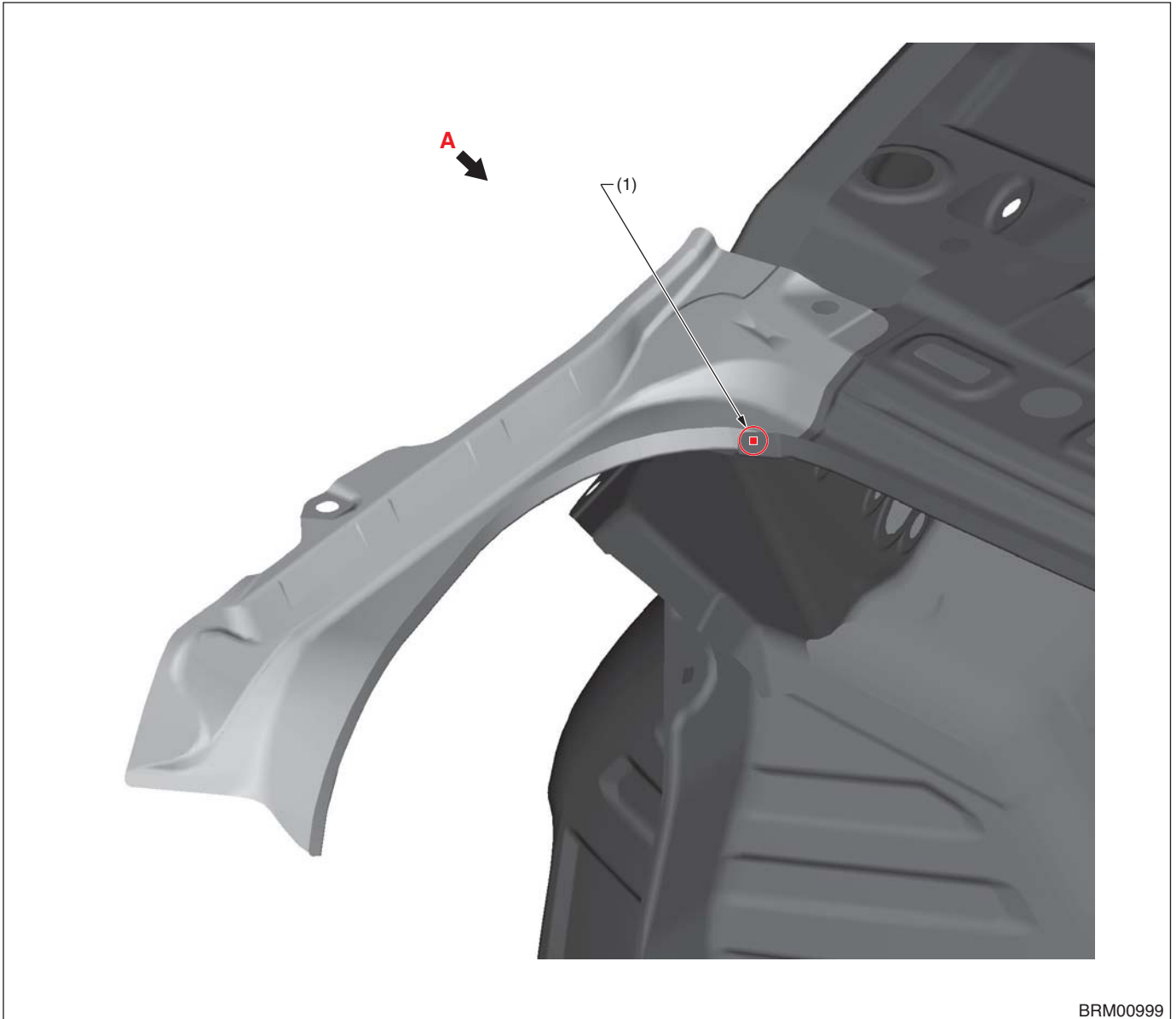


(1) 1 point (top · 1)

Panel Replacement

B: INSTALLATION

- Overall view

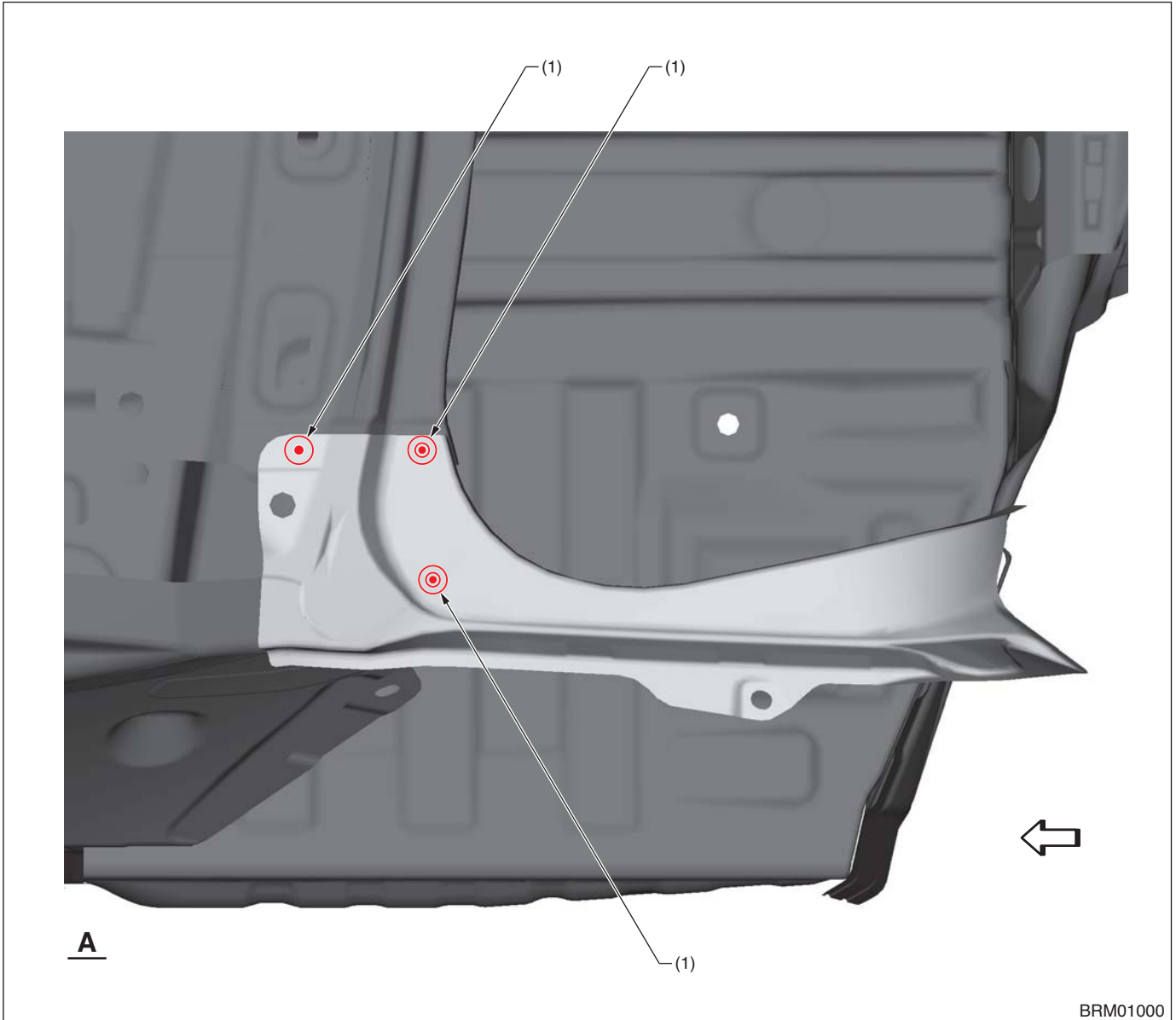


BRM00999

(1) 1 point

Panel Replacement

• View A



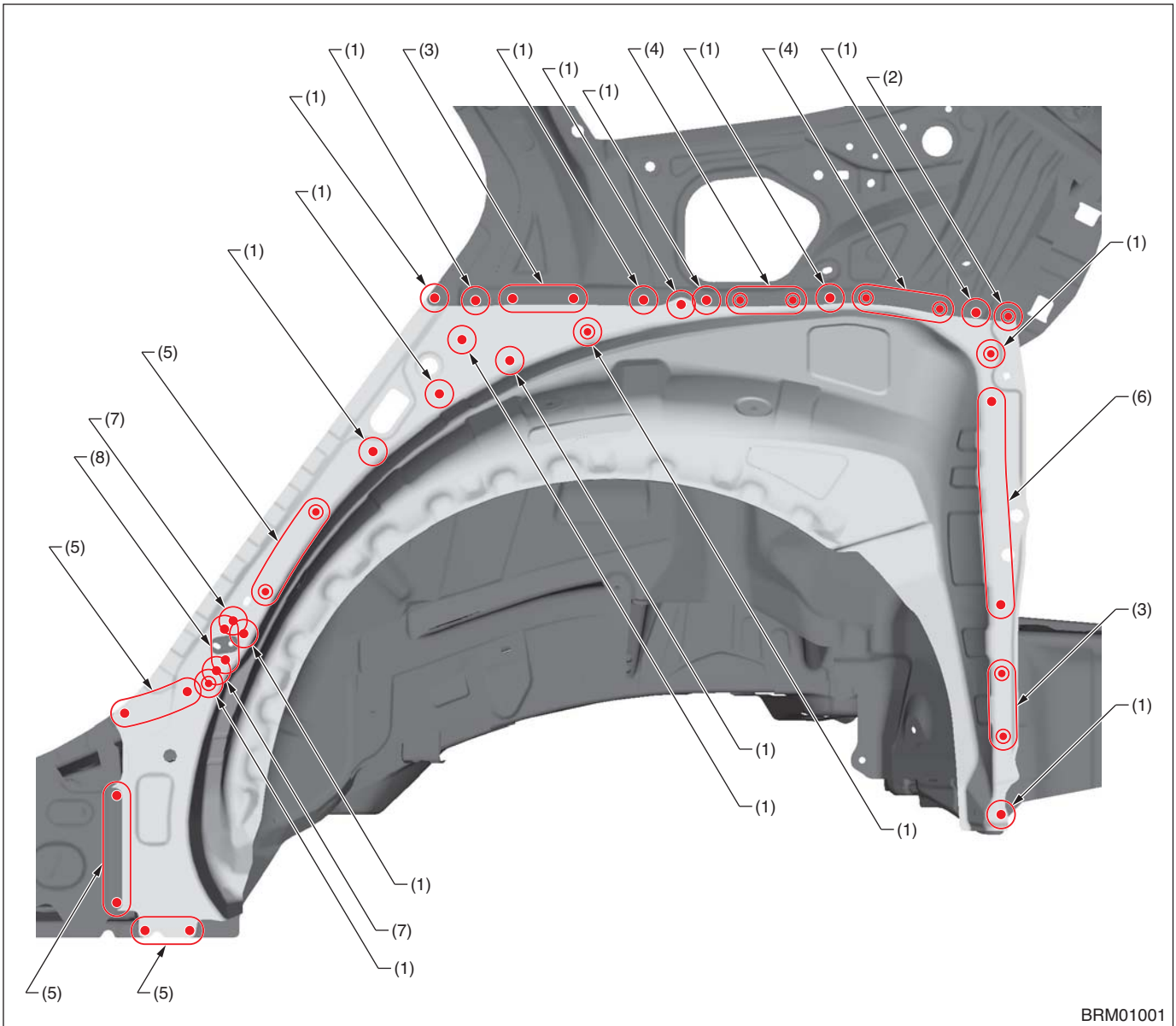
(1) 1 point

Panel Replacement

8-21. Arch Rear Inner (Total replacement) OUTBACK

A: REMOVAL

• Overall view



BRM01001

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

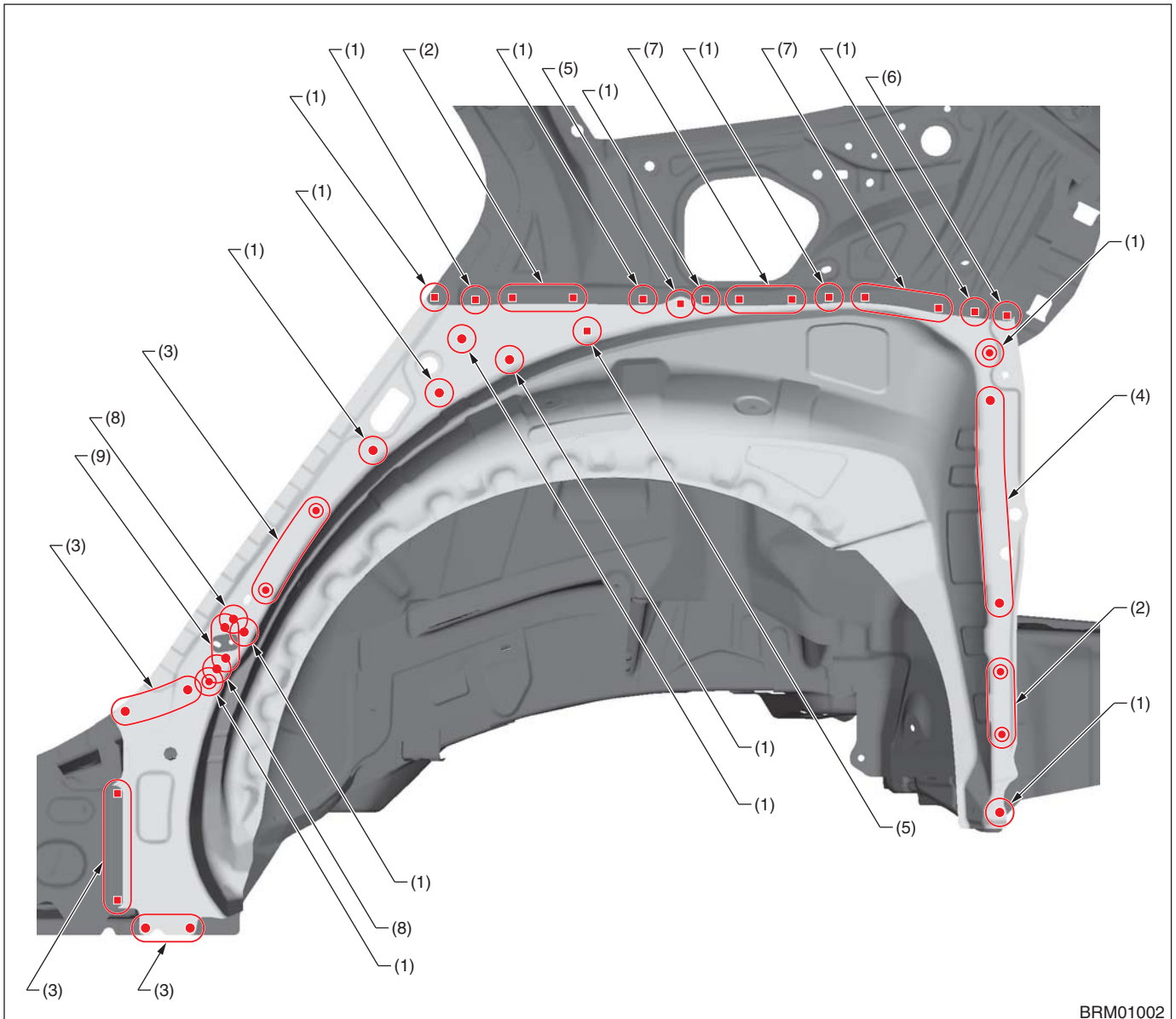
- (4) 2 points (outside · 2)
- (5) 3 points (outside · 1)
- (6) 4 points (outside · 1)

- (7) 1 point (outside · 1) Only RH
- (8) 2 points (outside · 1) Only LH

Panel Replacement

B: INSTALLATION

• Overall view 1



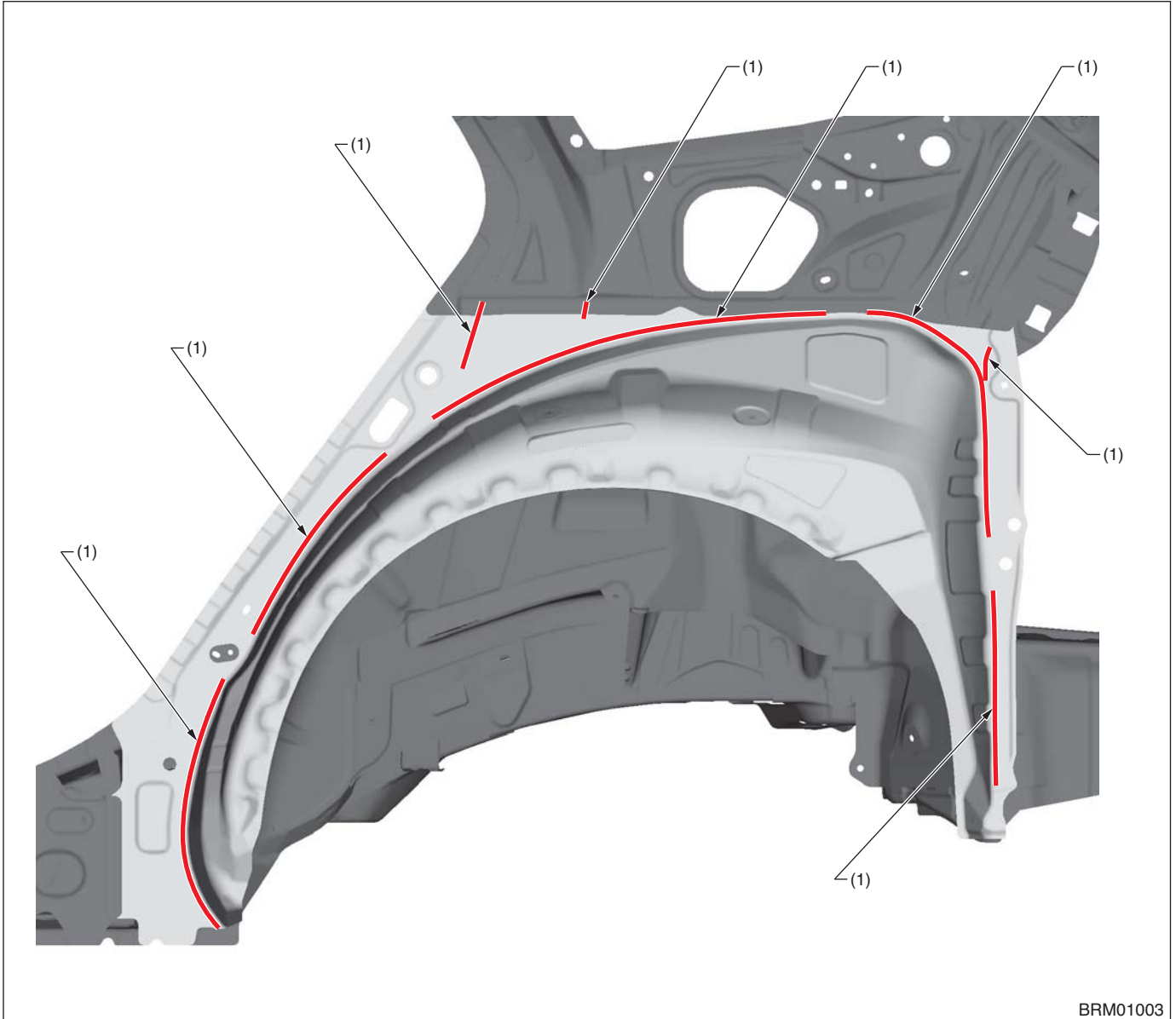
- (1) 1 point
- (2) 2 points
- (3) 3 points

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

- (7) 2 points (service · matching)
- (8) 1 point Only RH
- (9) 2 points Only LH

Panel Replacement

• Overall view 2



(1) Structural adhesive

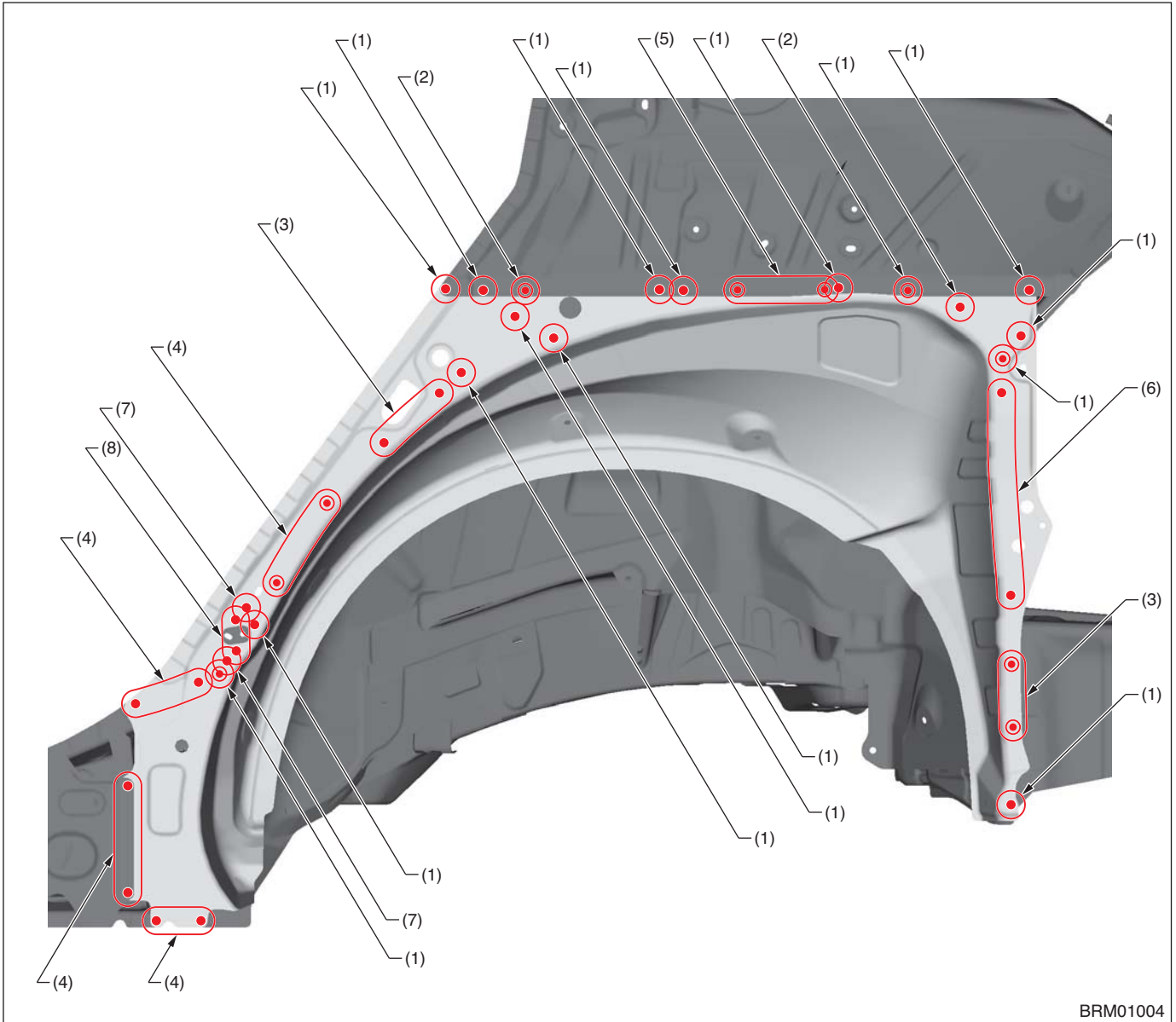
— : Structural adhesive application location (Panel bond mini 38315 made by 3M or equivalent)

Panel Replacement

8-22. Arch Rear Inner (Total replacement) SEDAN

A: REMOVAL

• Overall view



BRM01004

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

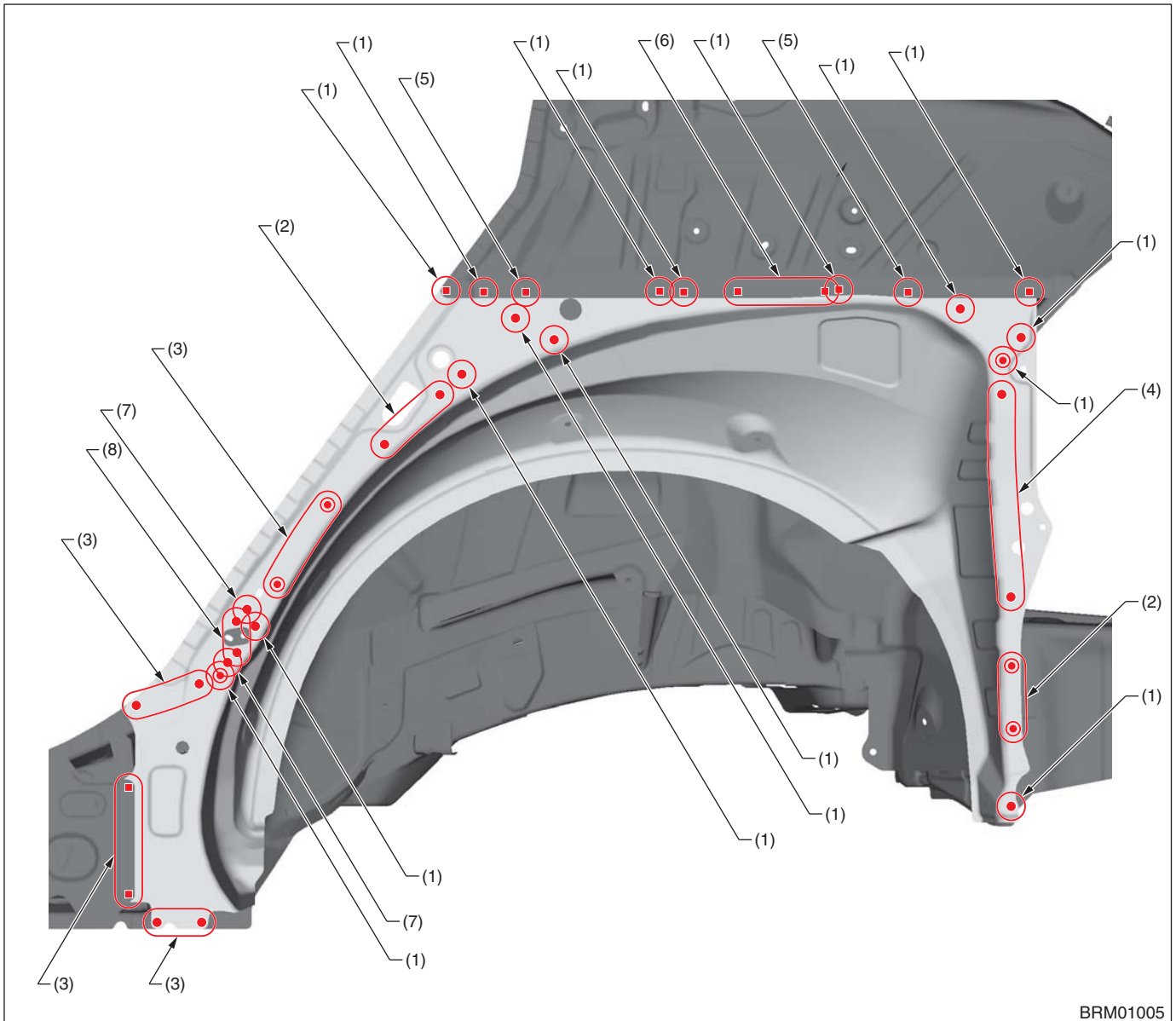
- (4) 3 points (outside · 1)
- (5) 3 points (outside · 2)
- (6) 4 points (outside · 1)

- (7) 1 point (outside · 1) Only RH
- (8) 2 points (outside · 1) Only LH

Panel Replacement

B: INSTALLATION

• Overall view 1



BRM01005

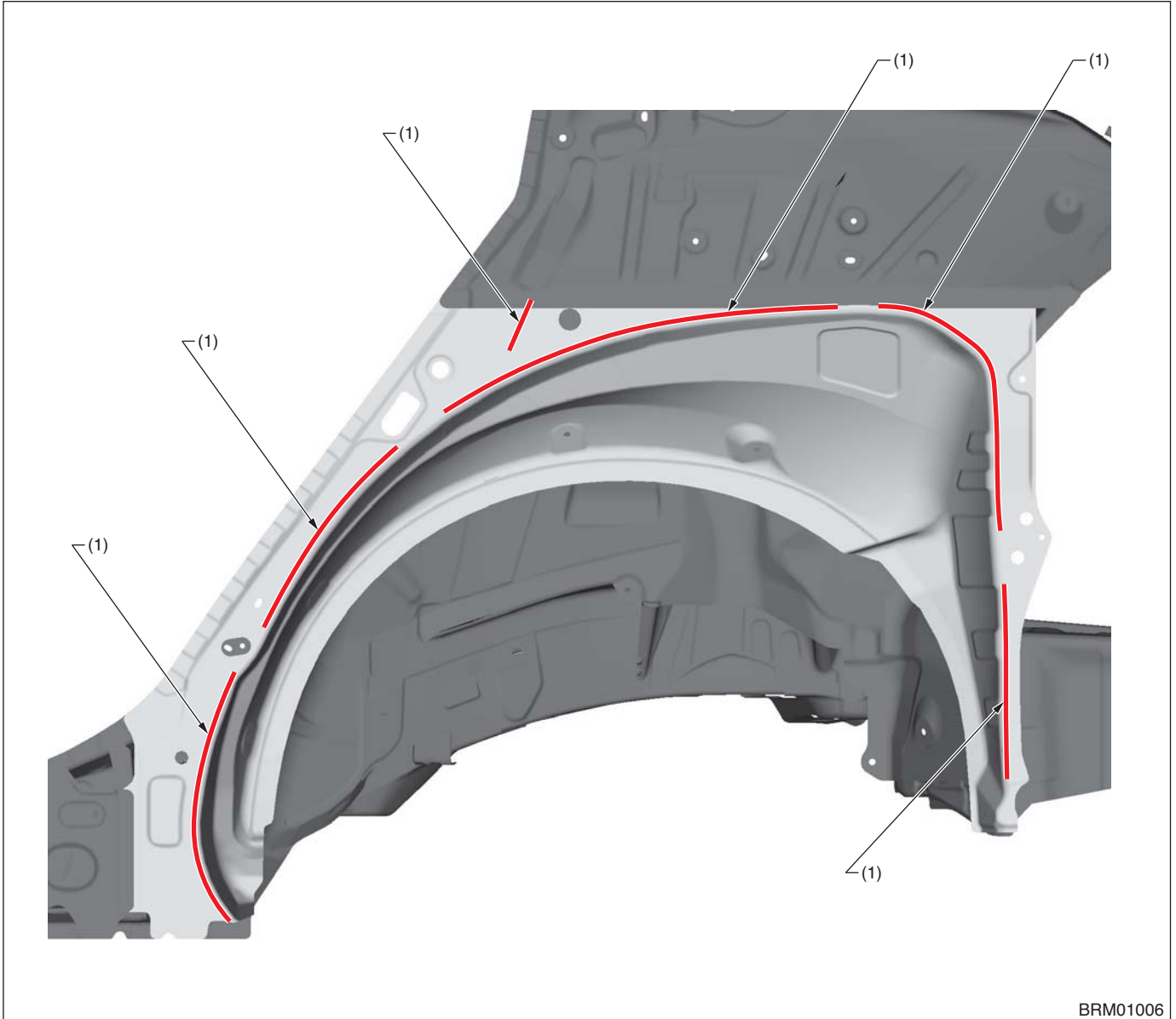
- (1) 1 point
- (2) 2 points
- (3) 3 points

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

- (7) 1 point Only RH
- (8) 2 points Only LH

Panel Replacement

• Overall view 2



(1) Structural adhesive

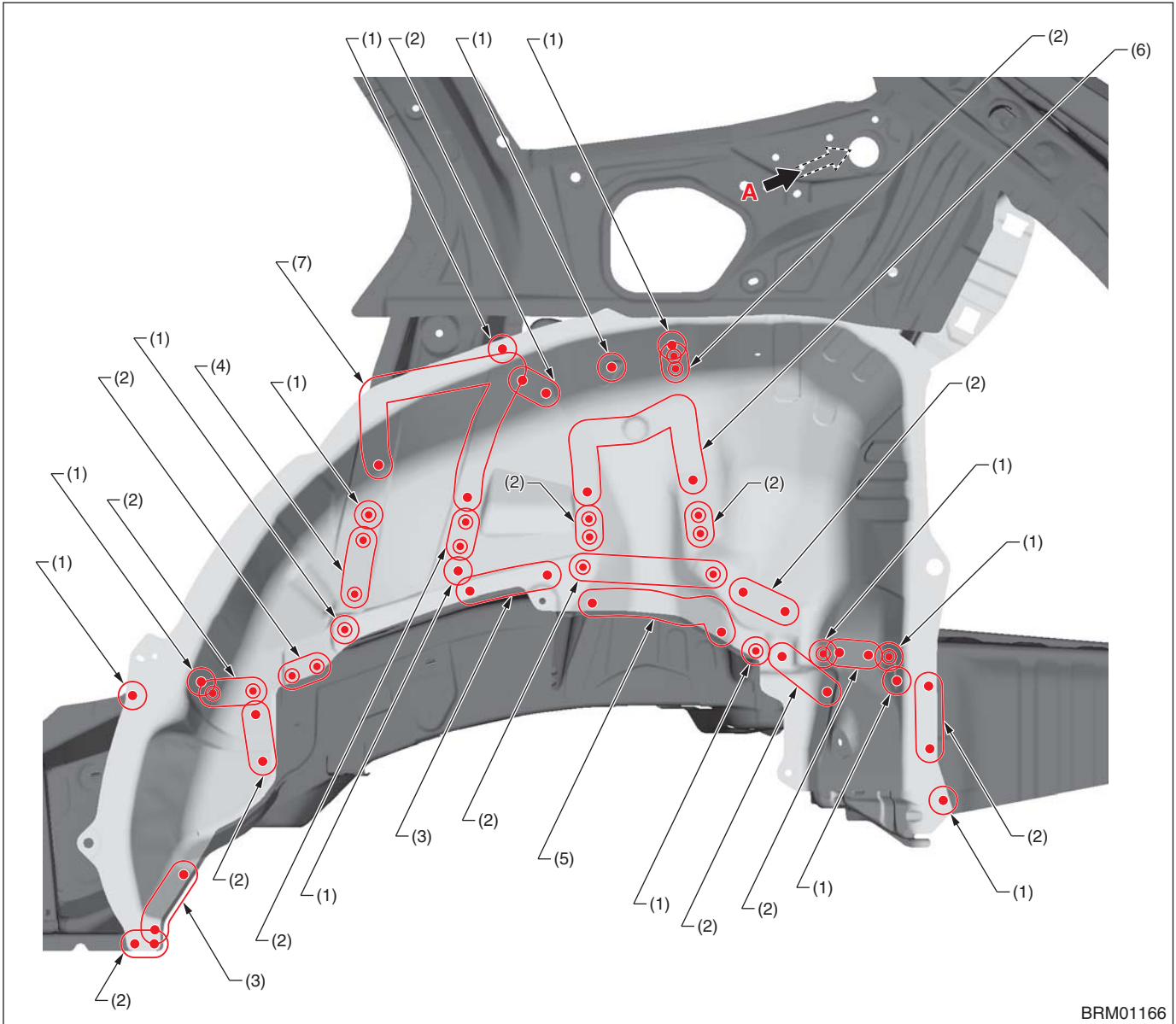
— : Structural adhesive application location (Panel bond mini 38315 made by 3M or equivalent)

Panel Replacement

8-23. Wheel Apron LH (Total replacement) OUTBACK

A: REMOVAL

• Overall view



BRM01166

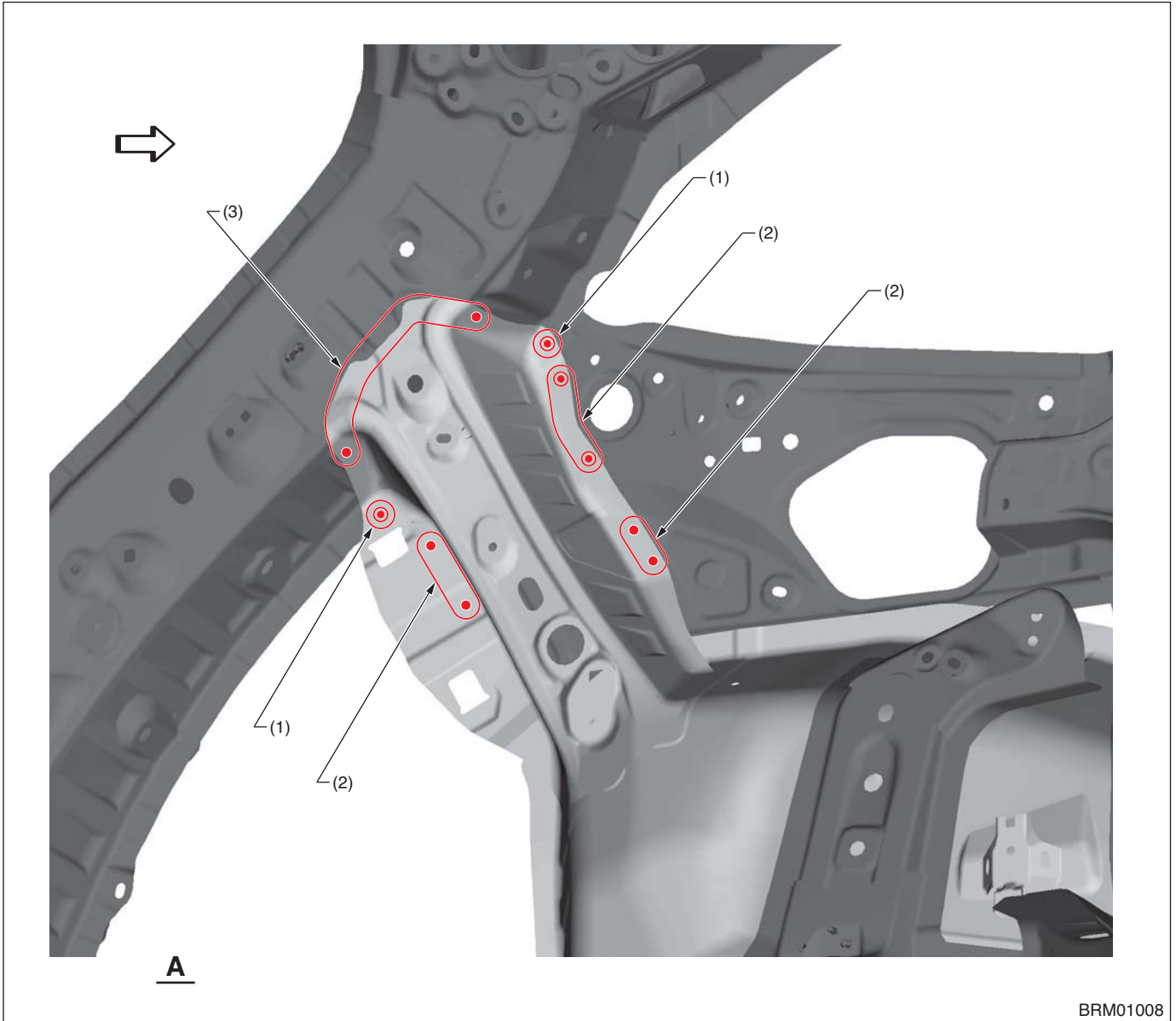
- (1) 1 point (outside · 1)
- (2) 2 points (outside · 1)
- (3) 3 points (outside · 1)

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

- (7) 8 points (outside · 1)

Panel Replacement

• View A



(1) 1 point (inside · 1)

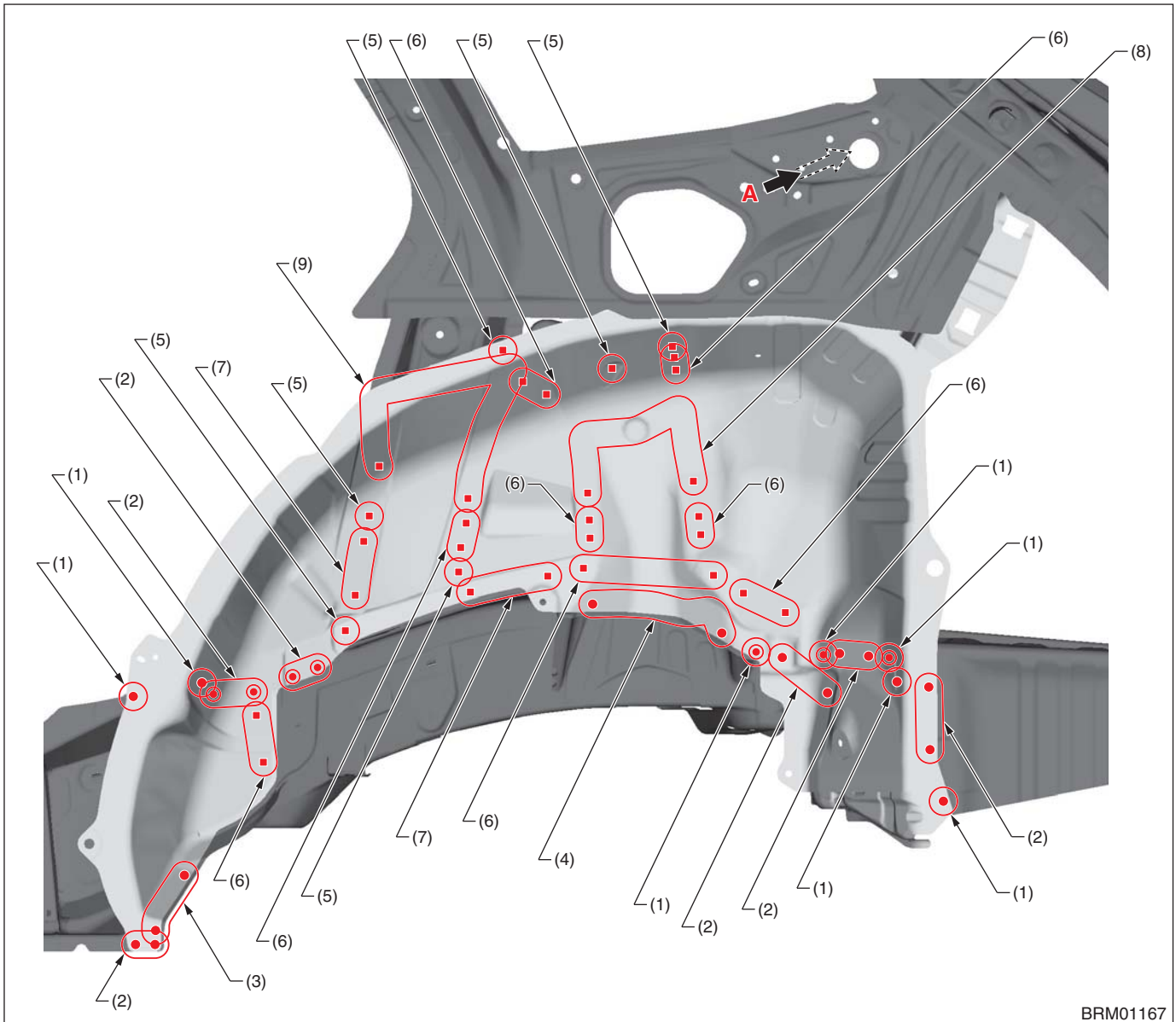
(2) 2 points (inside · 1)

(3) 4 points (inside · 1)

Panel Replacement

B: INSTALLATION

• Overall view 1



BRM01167

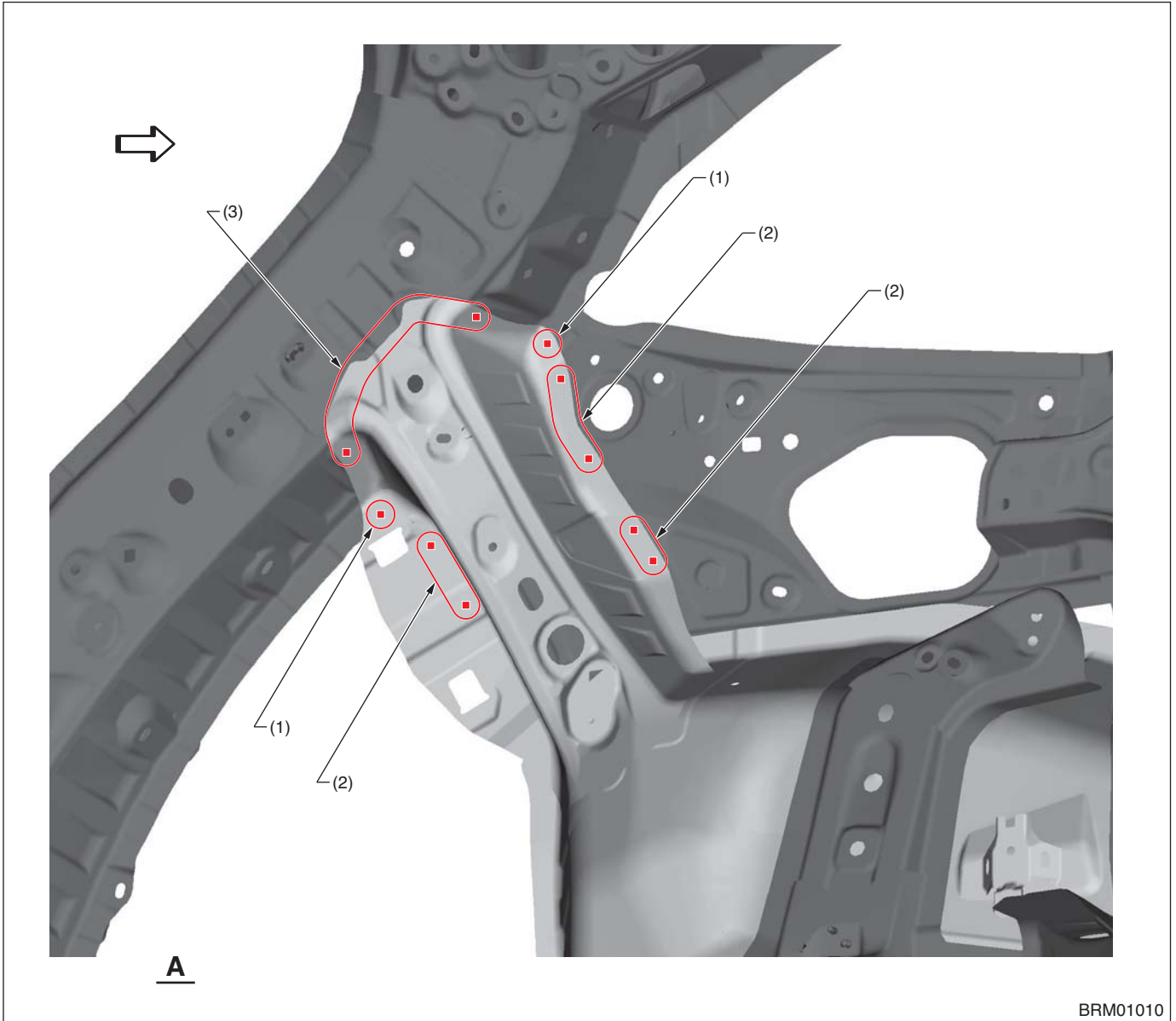
- (1) 1 point
- (2) 2 points
- (3) 3 points

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

- (7) 3 points (service)
- (8) 7 points (service)
- (9) 8 points (service)

Panel Replacement

• View A



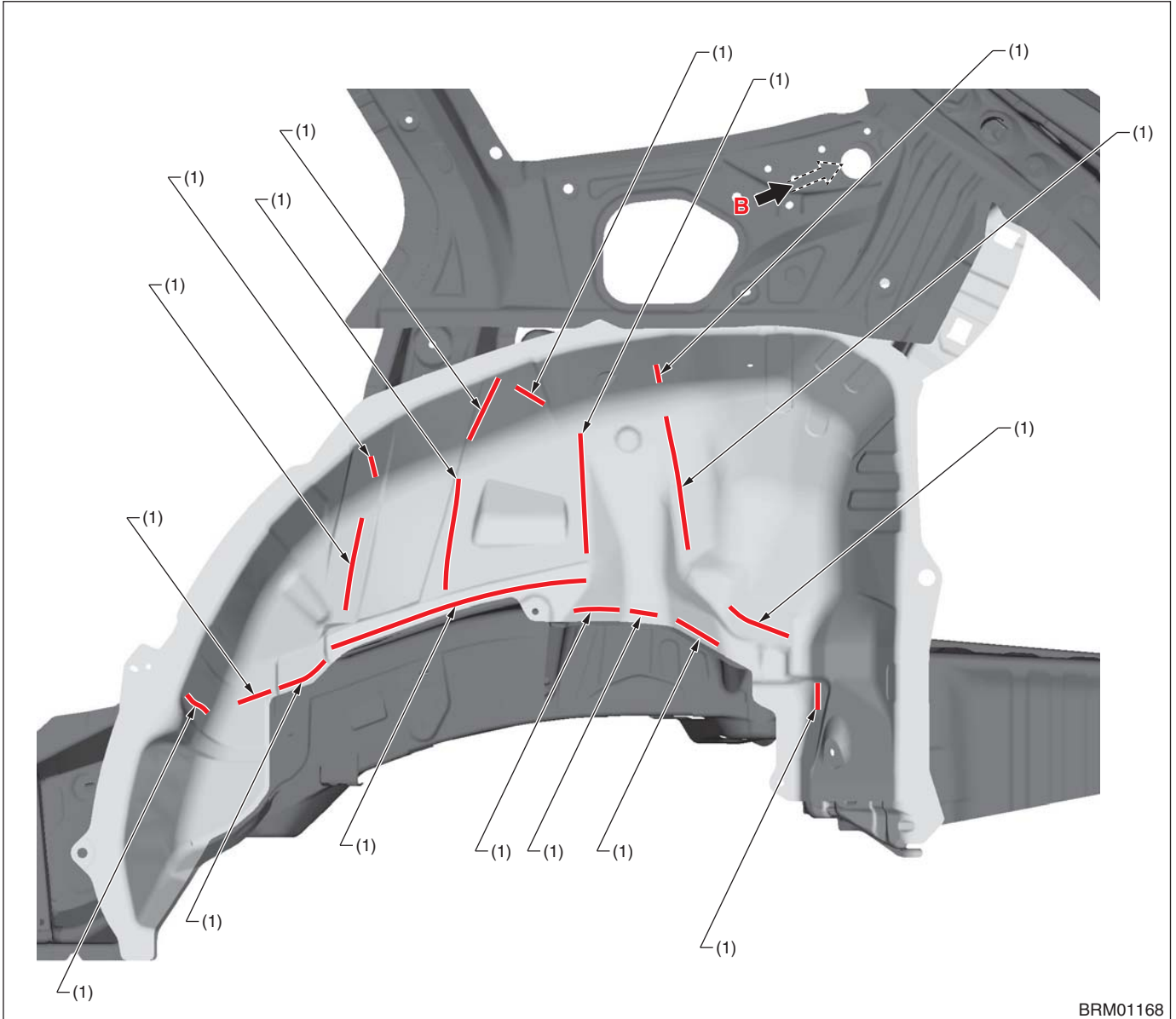
(1) 1 point (service)

(2) 2 points (service)

(3) 4 points (service)

Panel Replacement

• Overall view 2

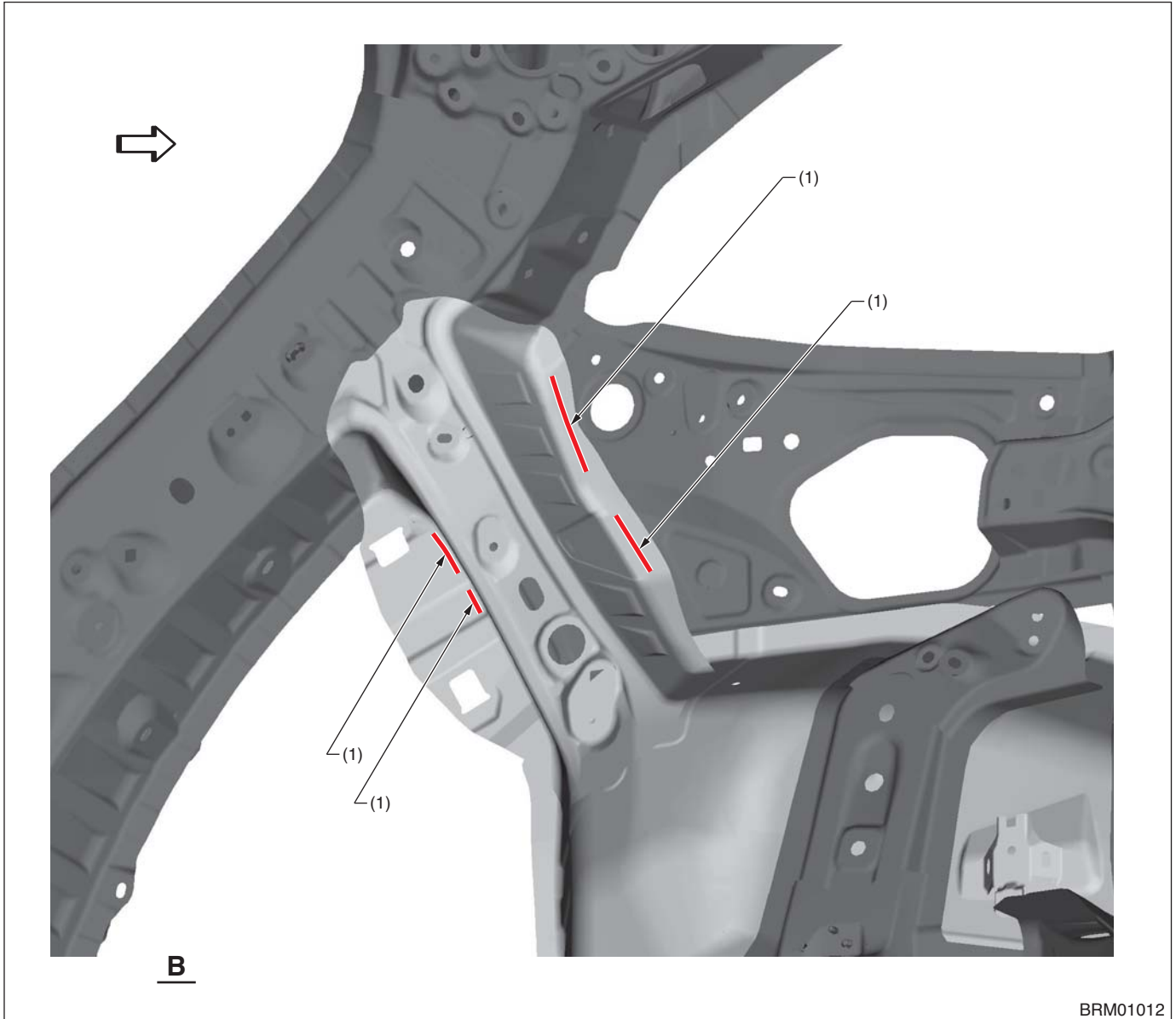


(1) Structural adhesive

— : Structural adhesive application location (Panel bond mini 38315 made by 3M or equivalent)

Panel Replacement

• View B



(1) Structural adhesive

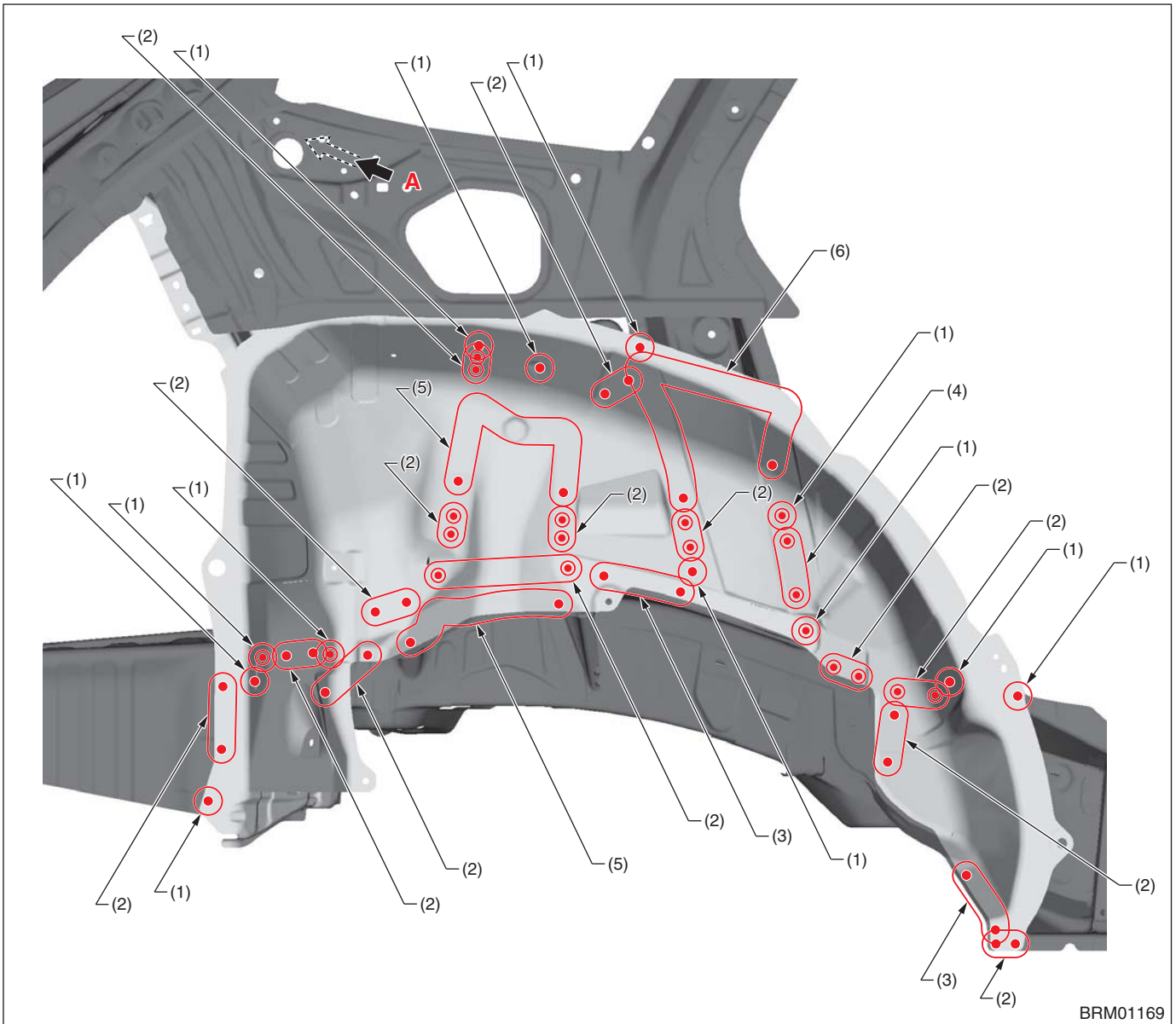
— : Structural adhesive application location (Panel bond mini 38315 made by 3M or equivalent)

Panel Replacement

8-24. Wheel Apron RH (Total replacement) OUTBACK

A: REMOVAL

• Overall view



BRM01169

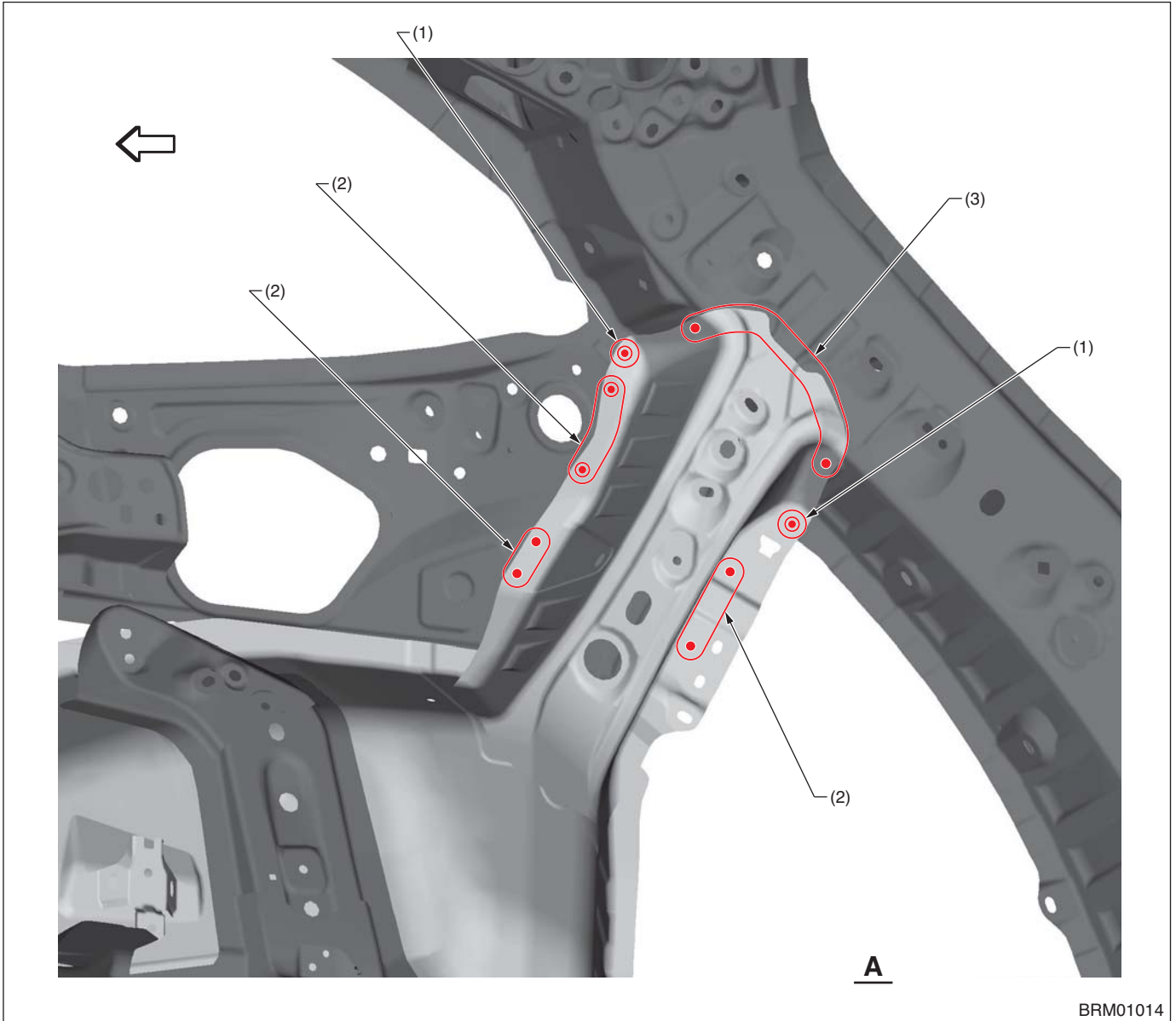
(1) 1 point (outside · 1)
(2) 2 points (outside · 1)

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

(5) 7 points (outside · 1)
(6) 8 points (outside · 1)

Panel Replacement

• View A



(1) 1 point (inside · 1)

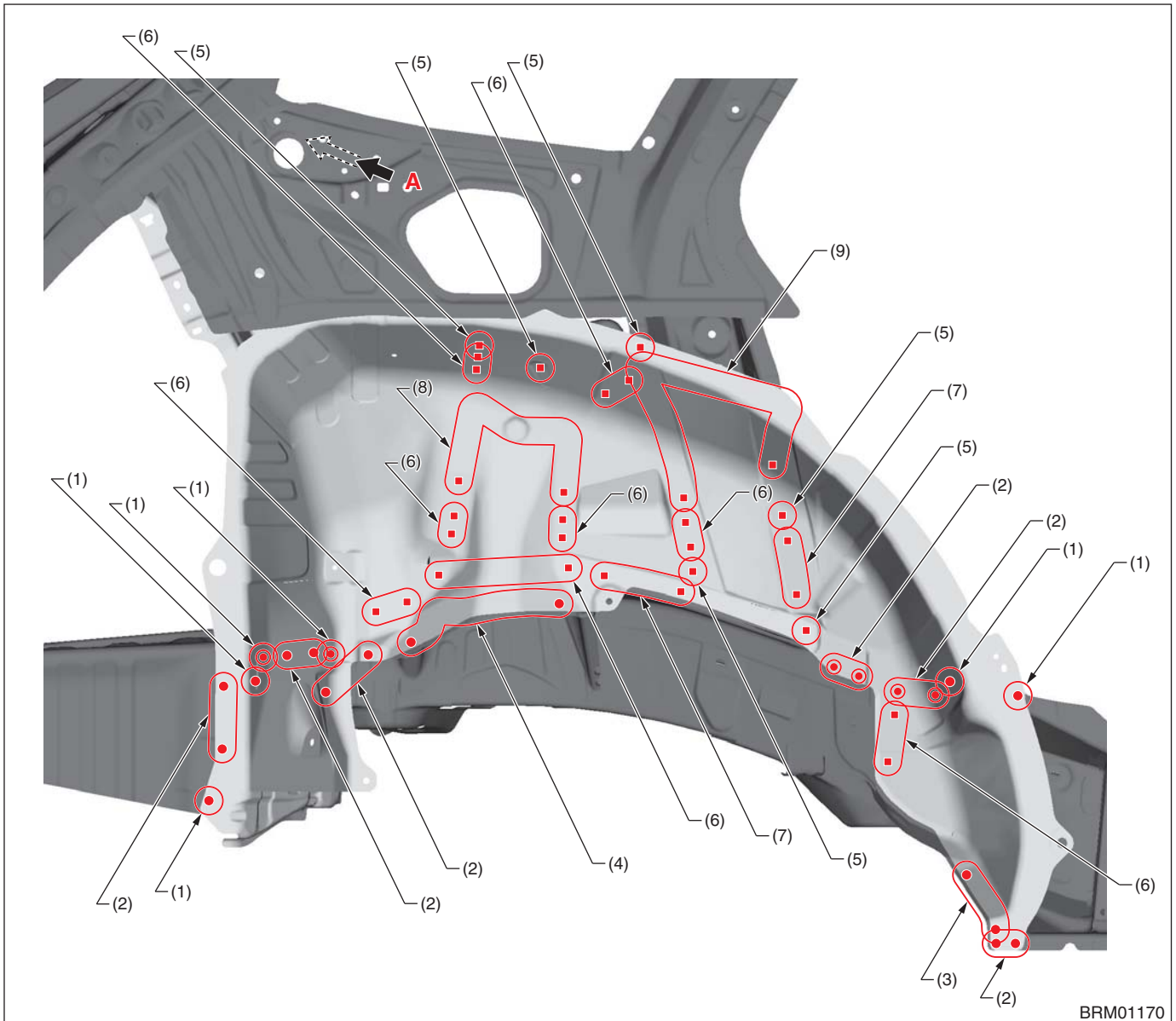
(2) 2 points (inside · 1)

(3) 4 points (inside · 1)

Panel Replacement

B: INSTALLATION

• Overall view 1



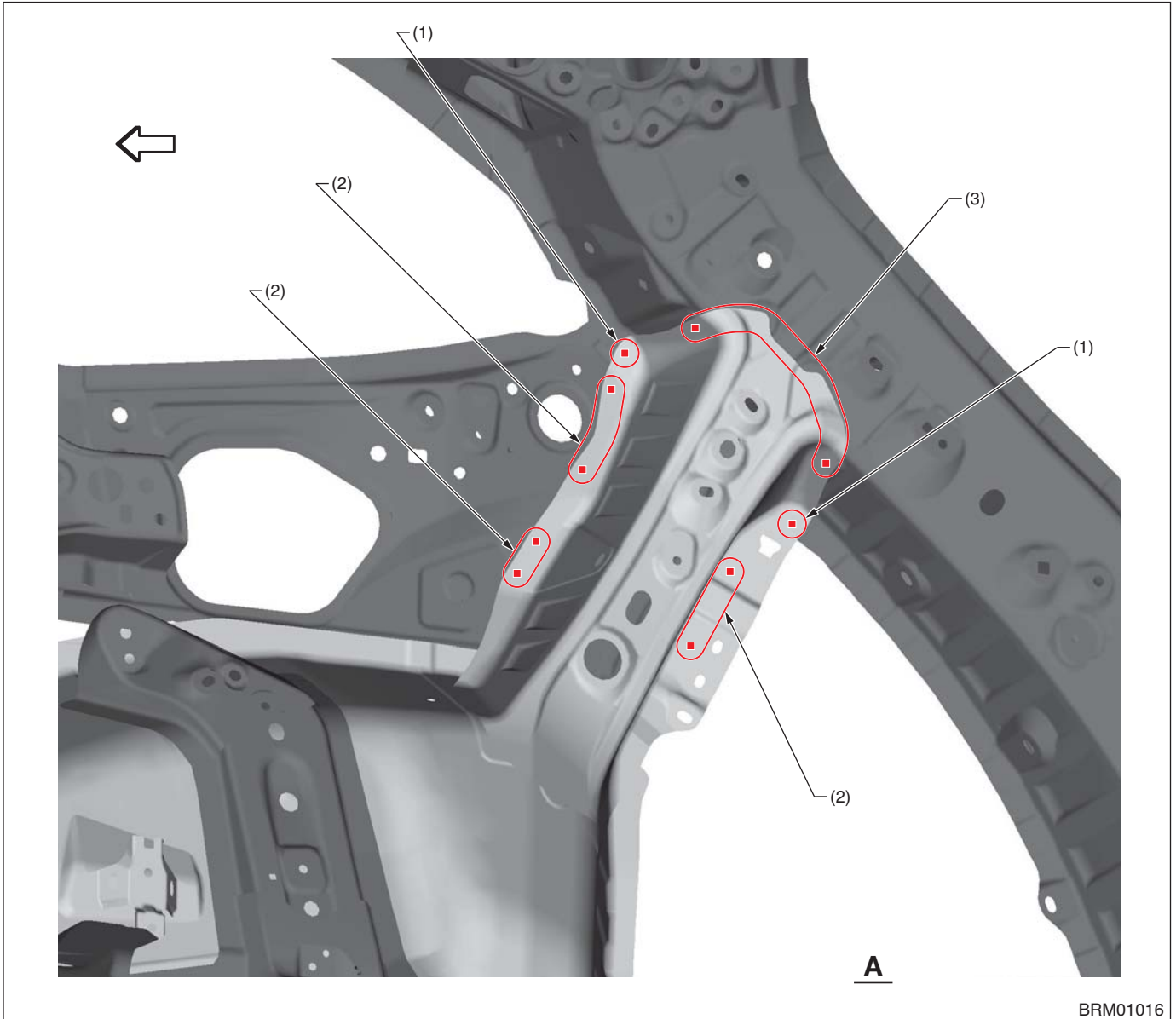
- (1) 1 point
- (2) 2 points
- (3) 3 points

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

- (7) 3 points (service)
- (8) 7 points (service)
- (9) 8 points (service)

Panel Replacement

• View A



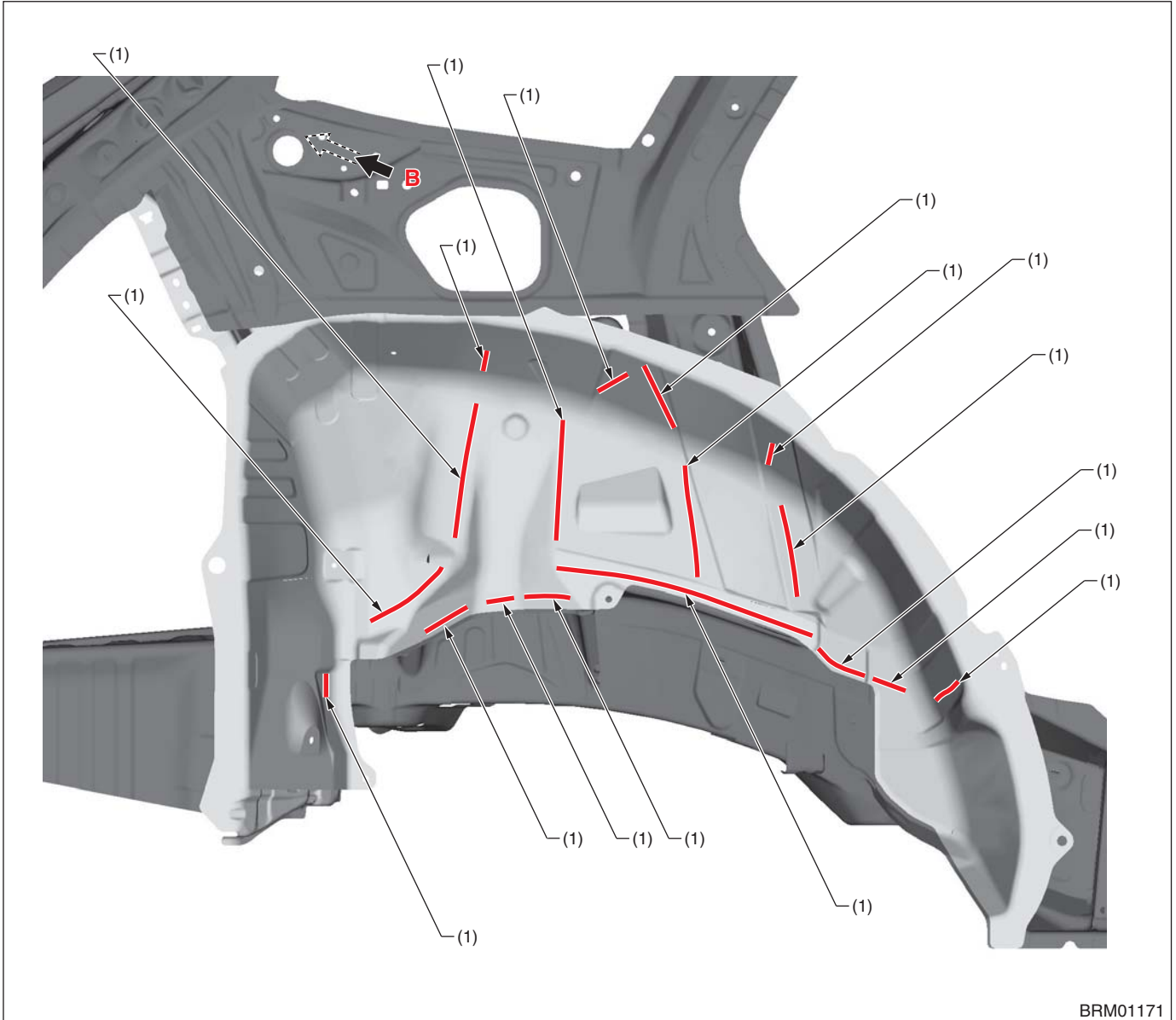
(1) 1 point (service)

(2) 2 points (service)

(3) 4 points (service)

Panel Replacement

• Overall view 2



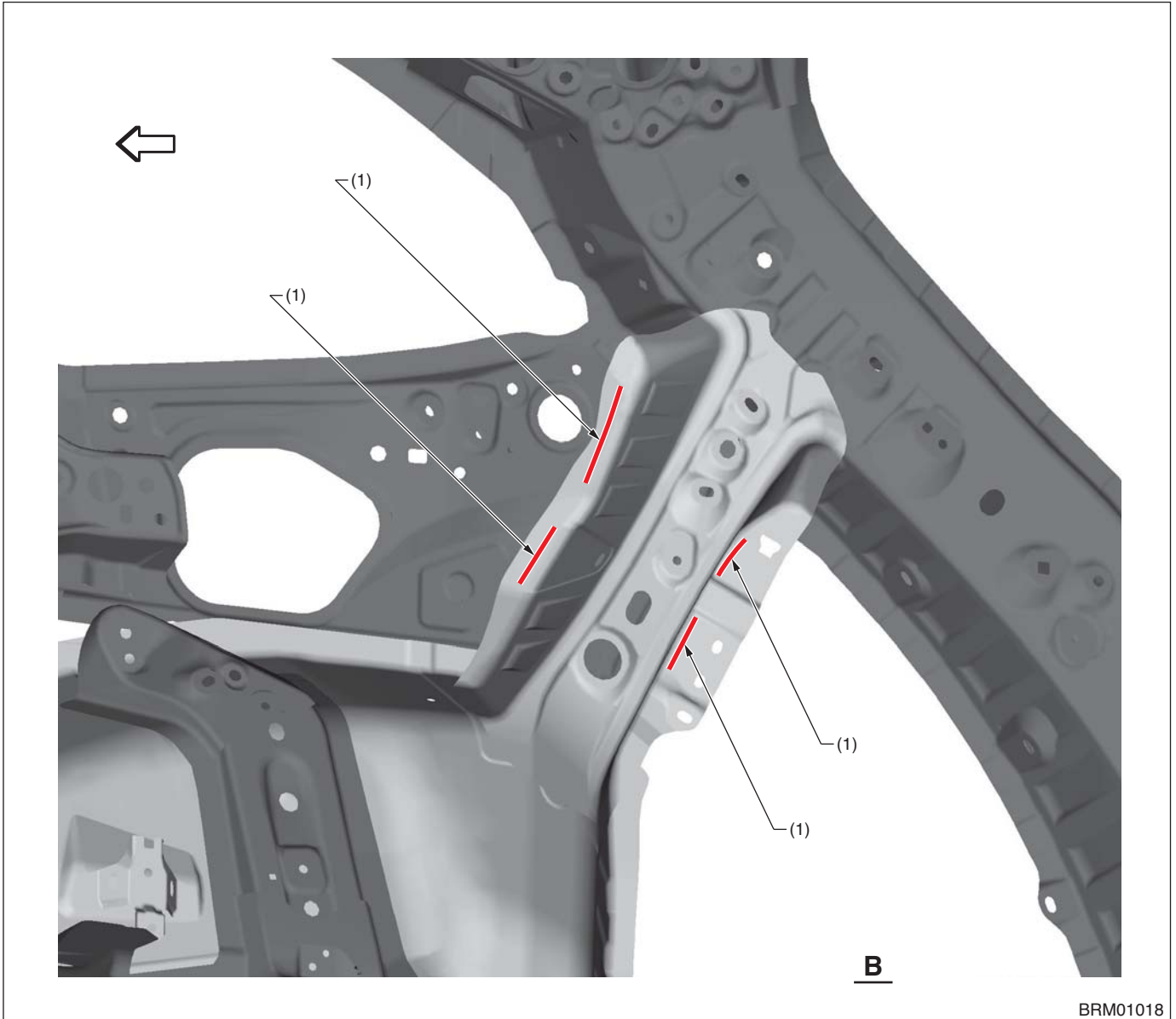
BRM01171

(1) Structural adhesive

— : Structural adhesive application location (Panel bond mini 38315 made by 3M or equivalent)

Panel Replacement

• View B



BRM01018

(1) Structural adhesive

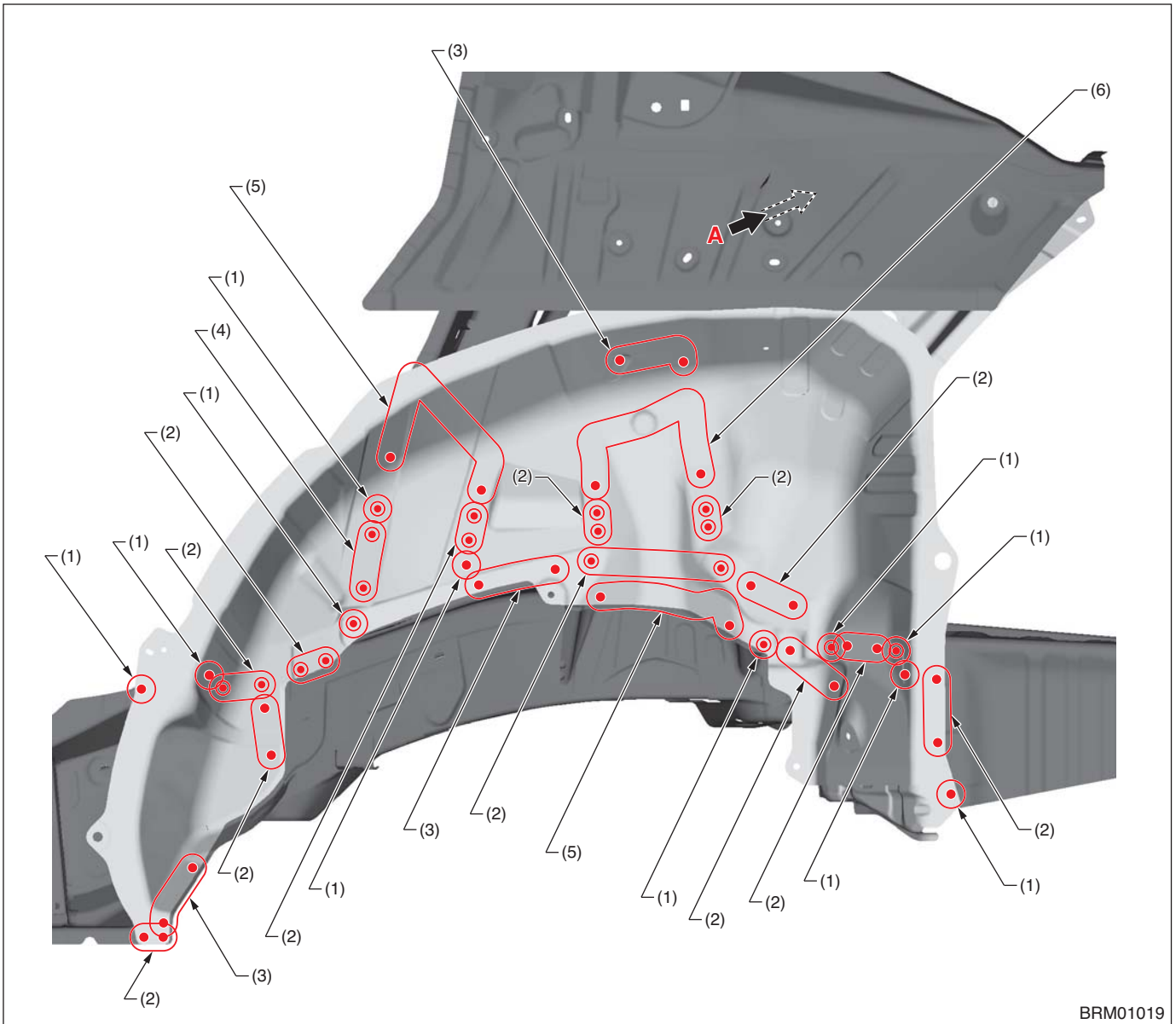
— : Structural adhesive application location (Panel bond mini 38315 made by 3M or equivalent)

Panel Replacement

8-25. Wheel Apron LH (Total replacement) SEDAN

A: REMOVAL

• Overall view



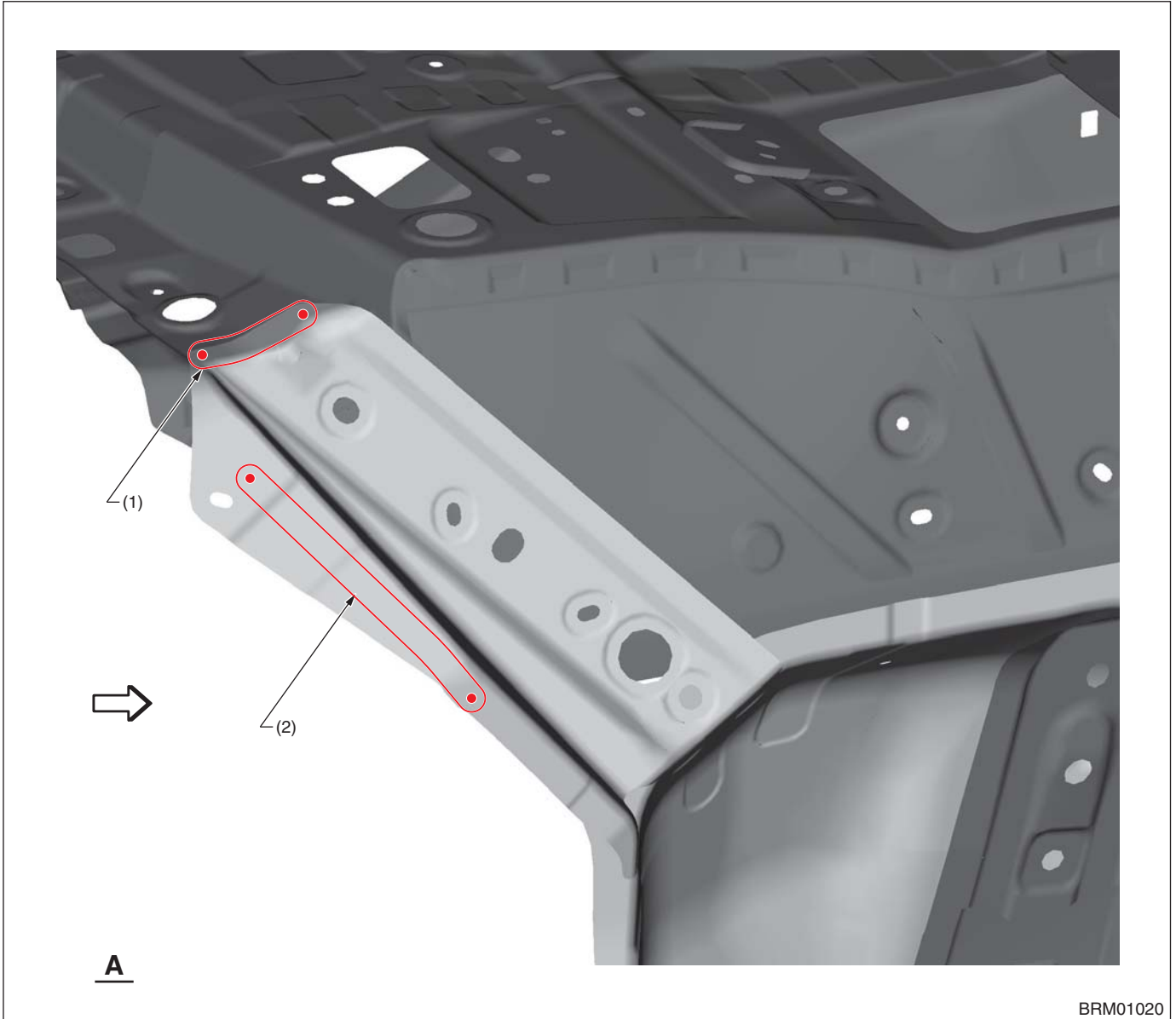
(1) 1 point (outside · 1)
(2) 2 points (outside · 1)

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

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

Panel Replacement

• View A



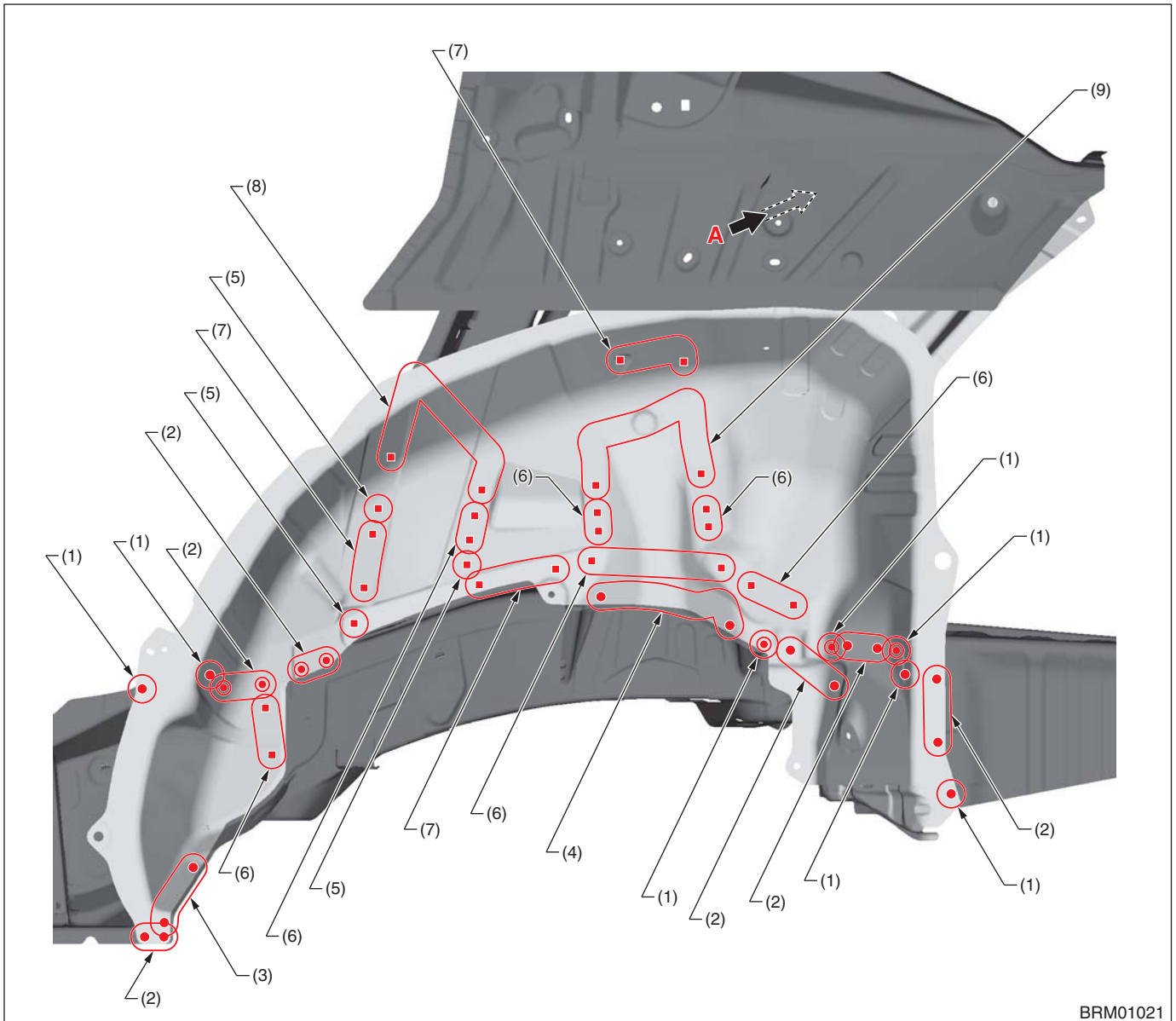
(1) 3 points (bottom · 1)

(2) 3 points (inside · 1)

Panel Replacement

B: INSTALLATION

• Overall view 1



BRM01021

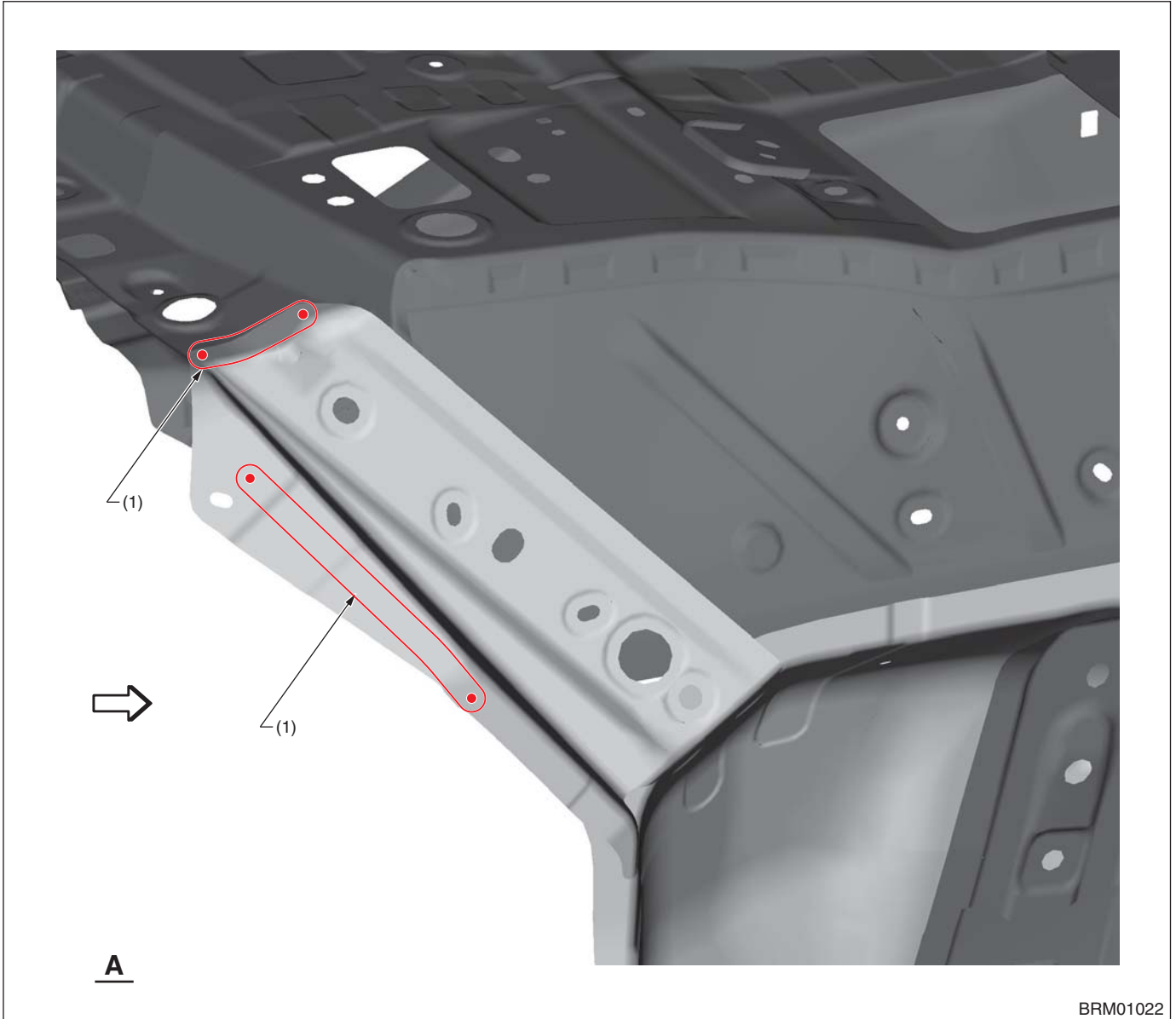
- (1) 1 point
- (2) 2 points
- (3) 3 points

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

- (7) 3 points (service)
- (8) 6 points (service)
- (9) 7 points (service)

Panel Replacement

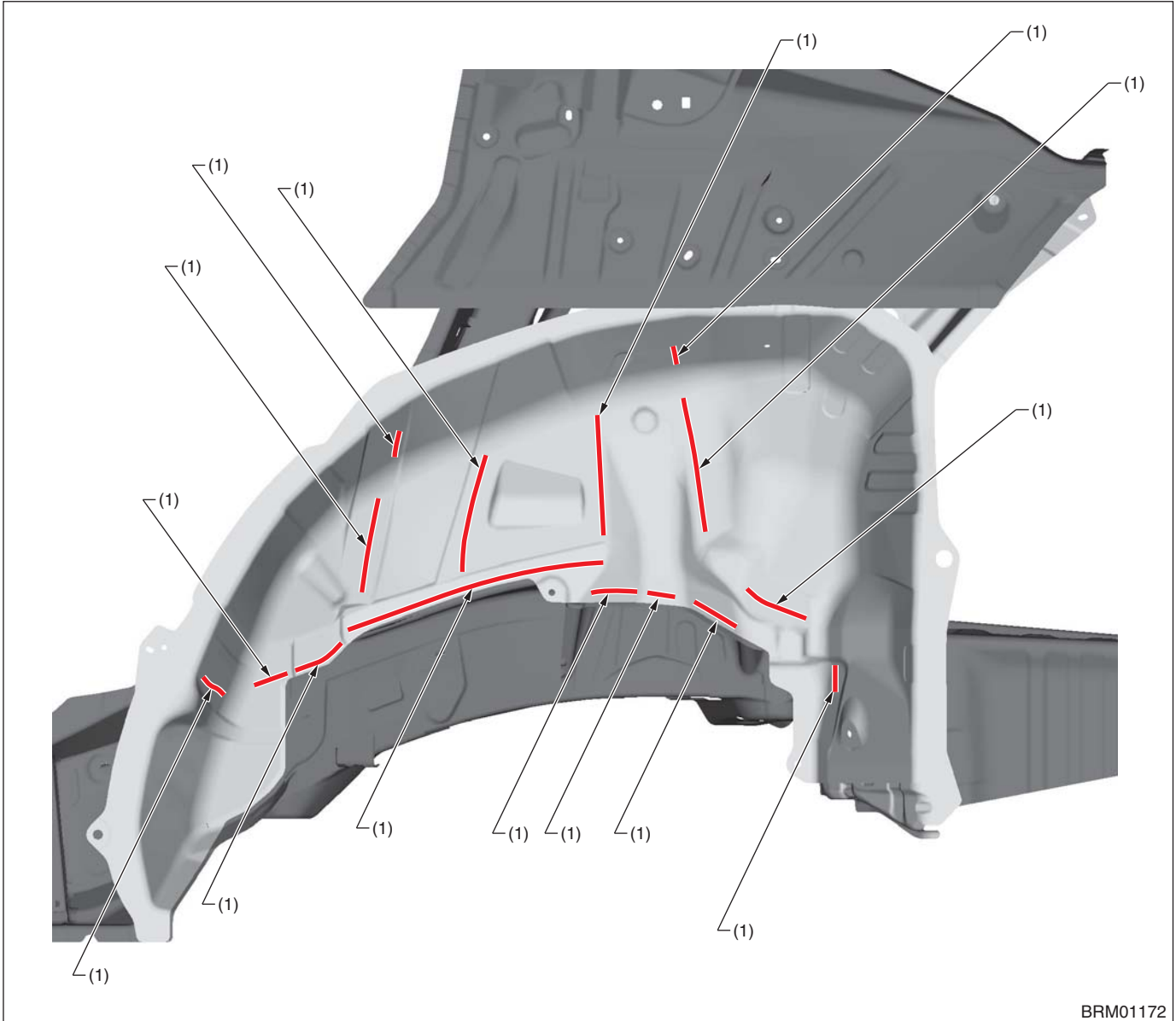
• View A



(1) 3 points

Panel Replacement

• Overall view 2



BRM01172

(1) Structural adhesive

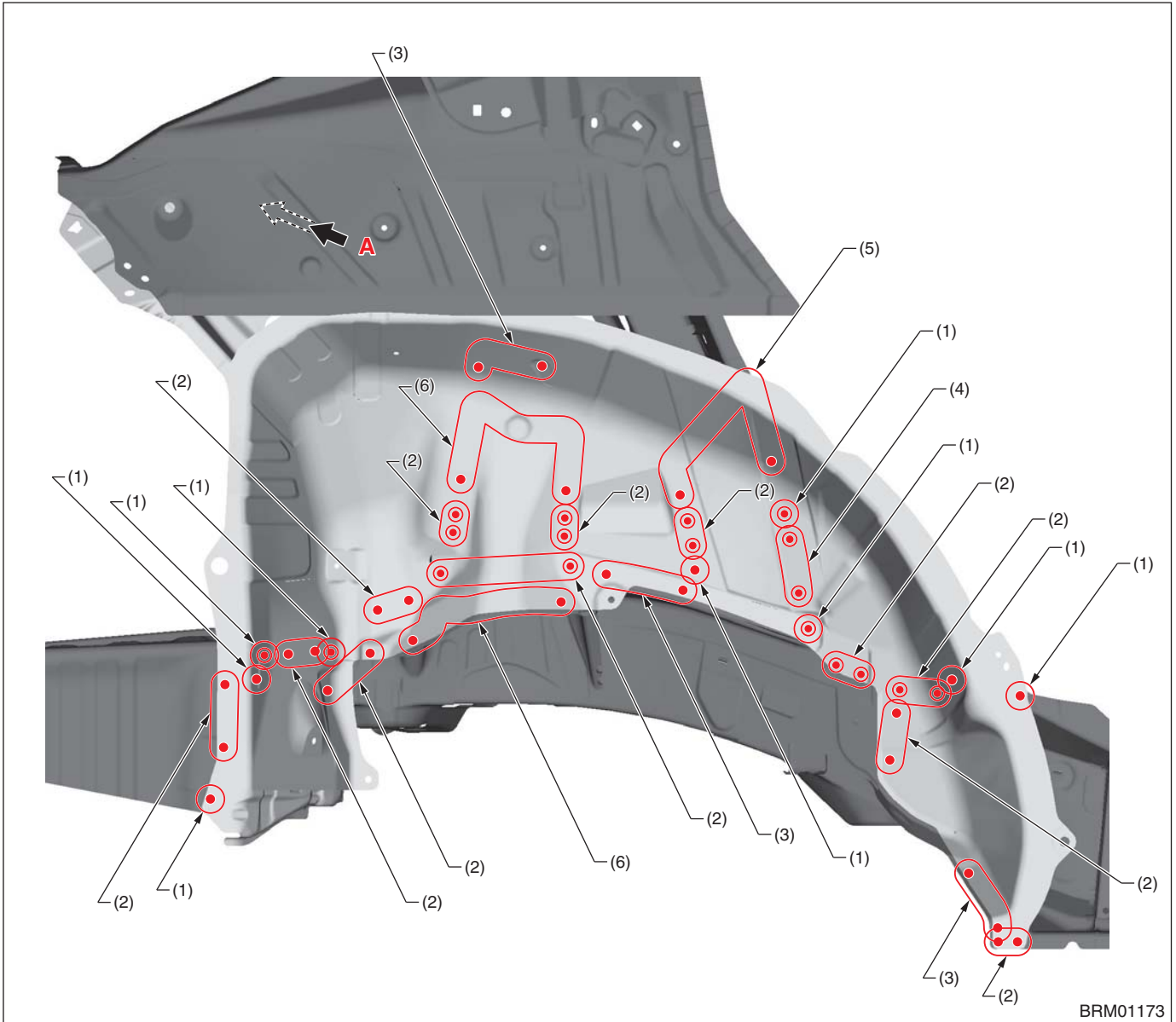
— : Structural adhesive application location (Panel bond mini 38315 made by 3M or equivalent)

Panel Replacement

8-26. Wheel Apron RH (Total replacement) SEDAN

A: REMOVAL

• Overall view



BRM01173

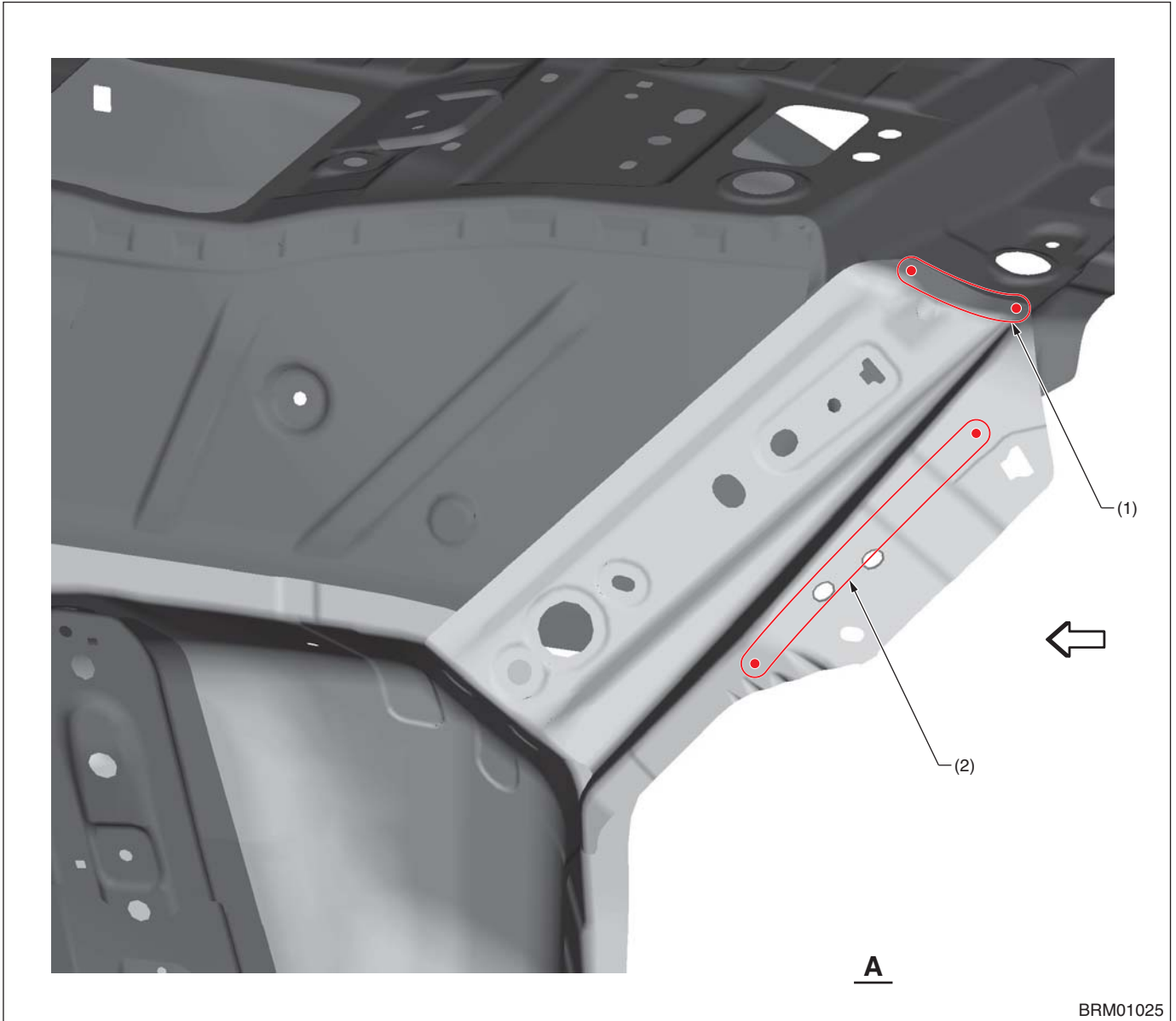
(1) 1 point (outside · 1)
(2) 2 points (outside · 1)

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

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

Panel Replacement

• View A



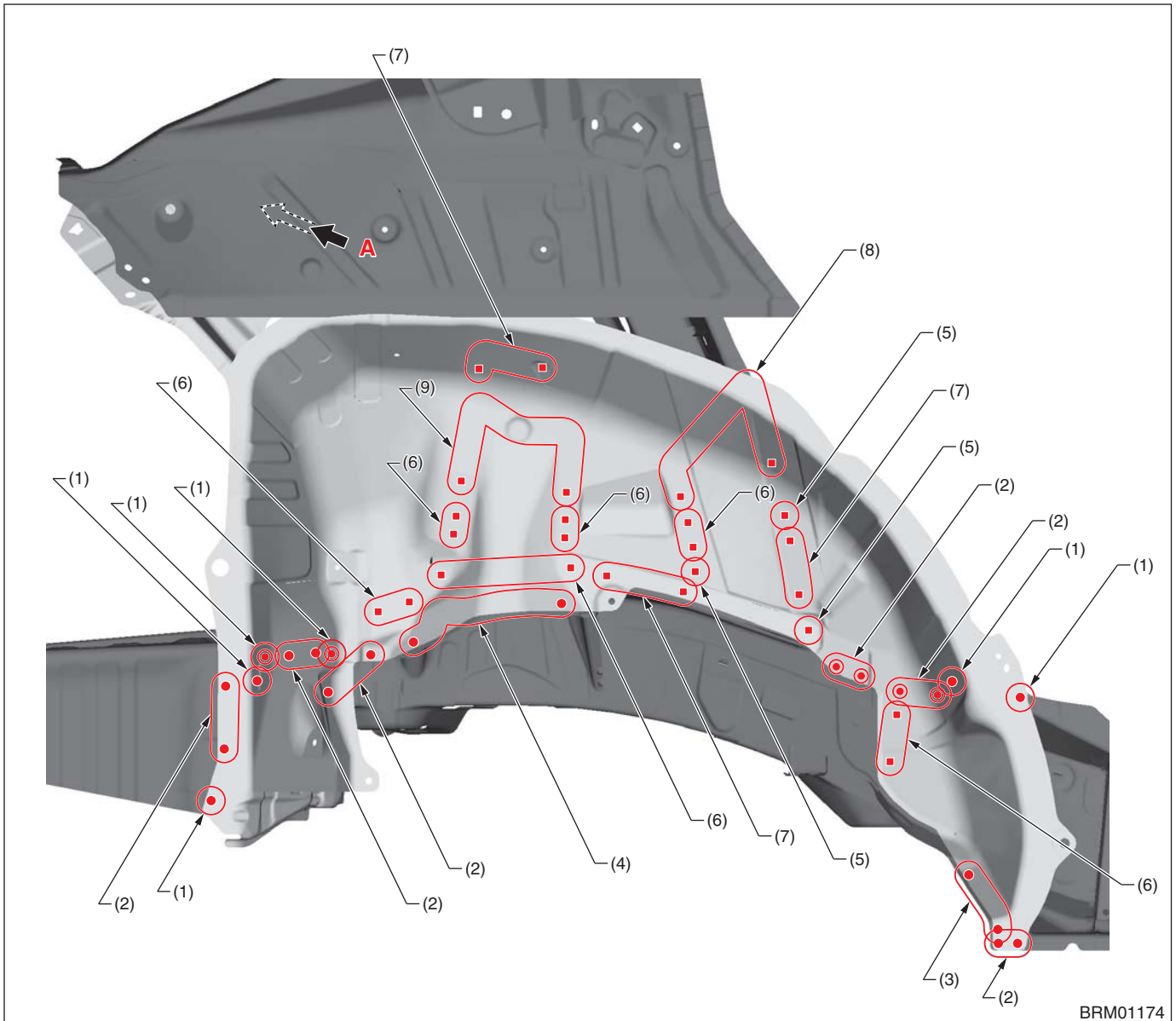
(1) 3 points (bottom · 1)

(2) 3 points (inside · 1)

Panel Replacement

B: INSTALLATION

• Overall view 1



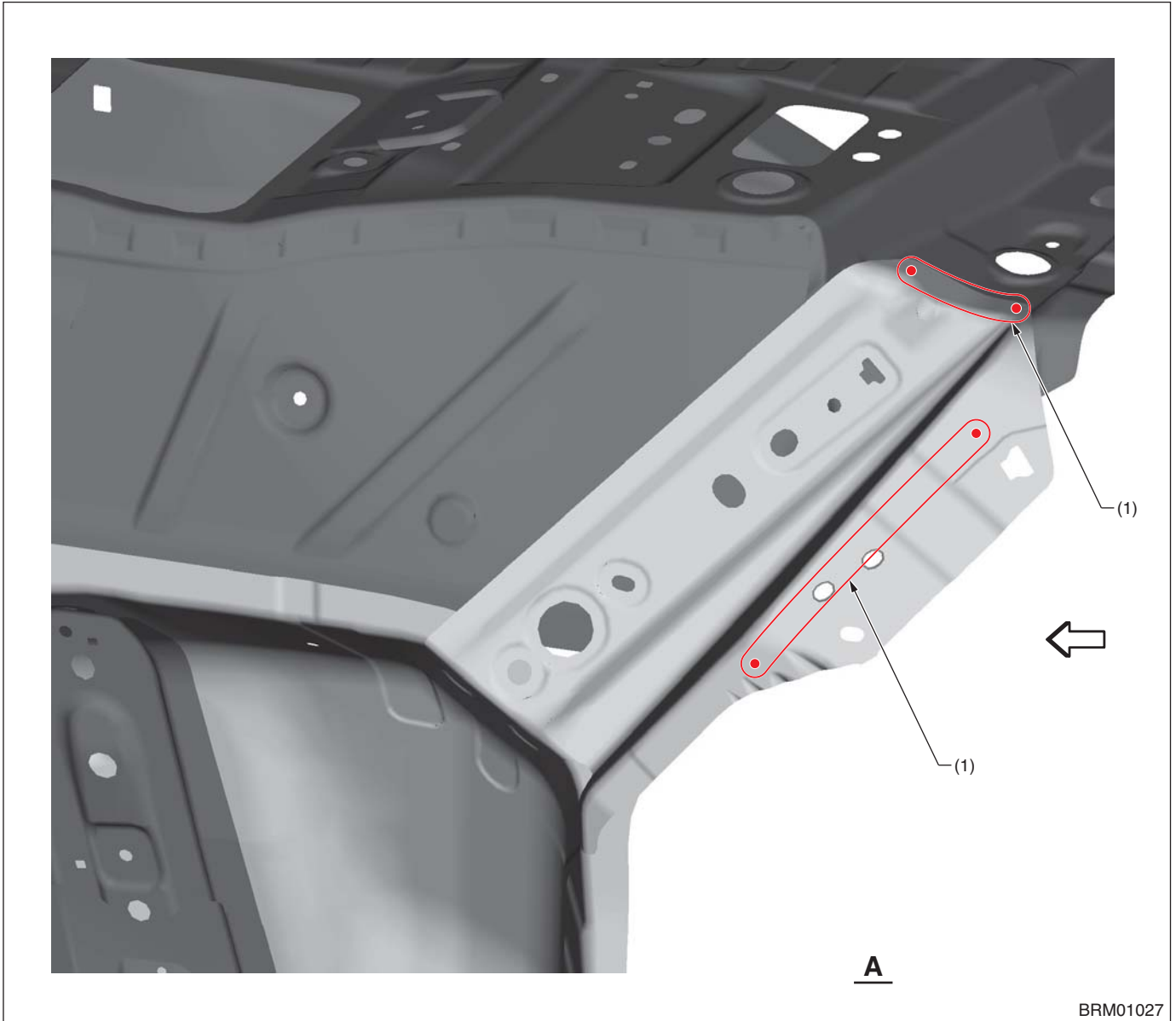
- (1) 1 point
- (2) 2 points
- (3) 3 points

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

- (7) 3 points (service)
- (8) 6 points (service)
- (9) 7 points (service)

Panel Replacement

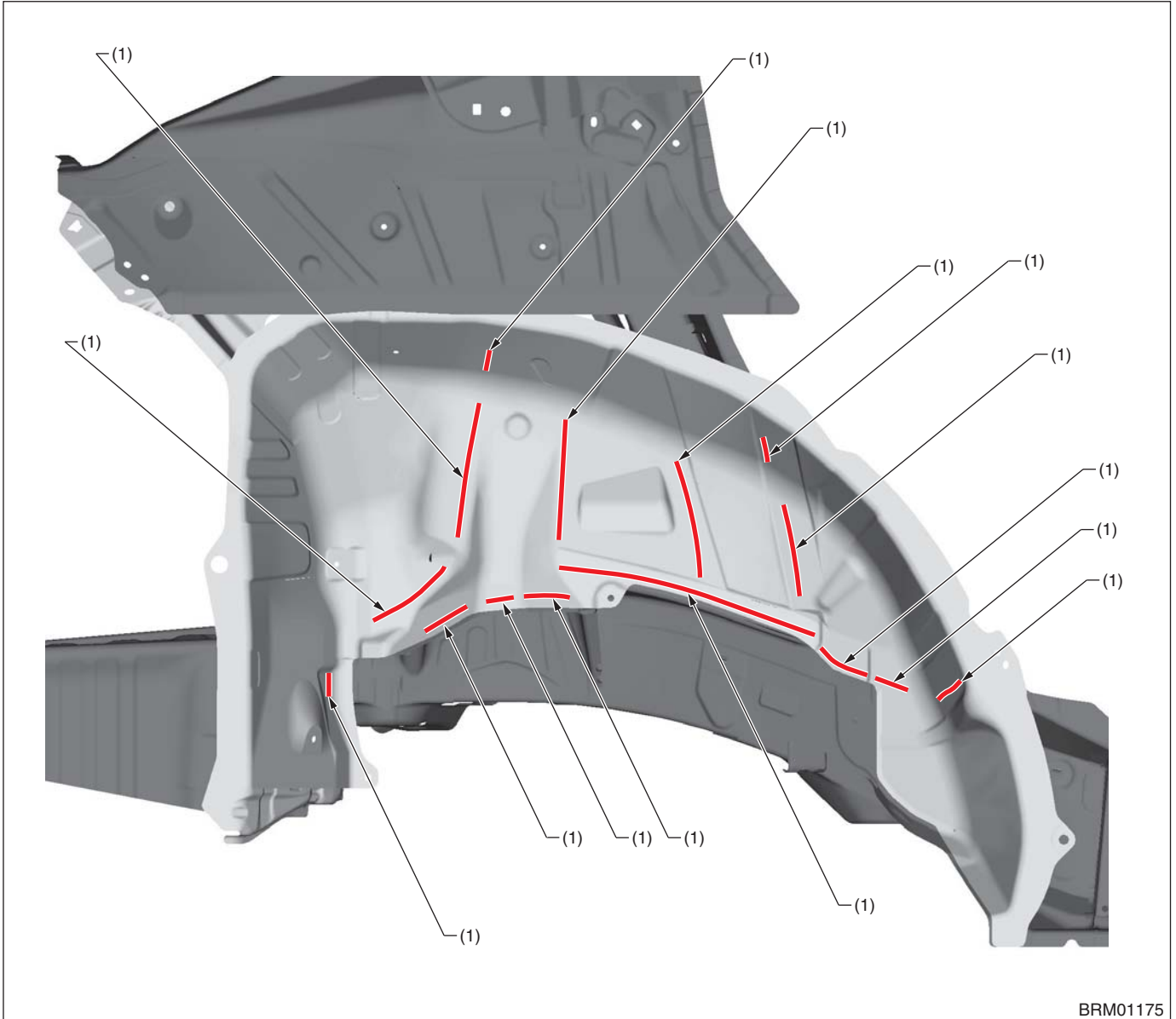
• View A



(1) 3 points

Panel Replacement

• Overall view 2



(1) Structural adhesive

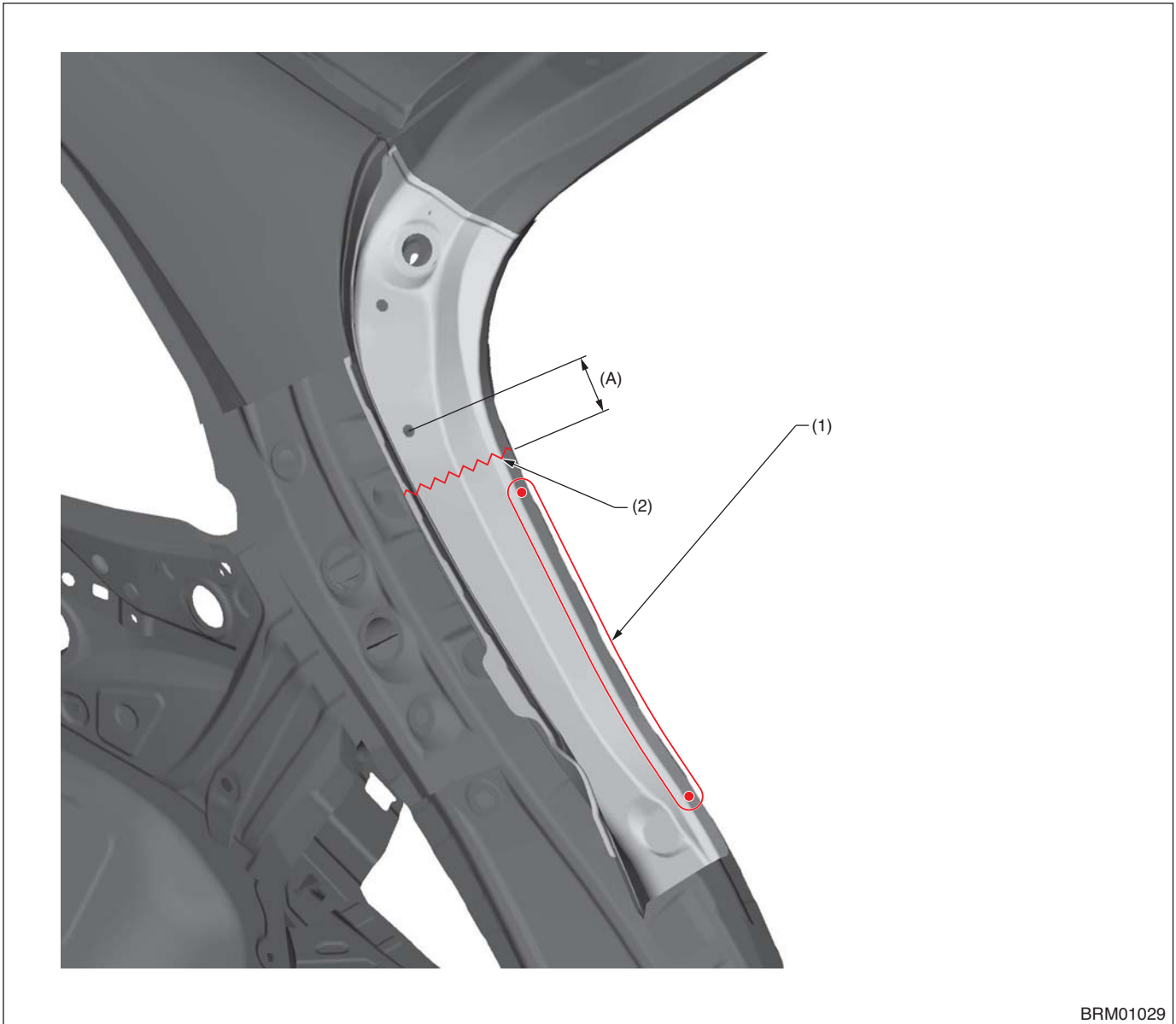
— : Structural adhesive application location (Panel bond mini 38315 made by 3M or equivalent)

Panel Replacement

8-27. D Pillar Extension (Partial replacement) OUTBACK

A: REMOVAL

- Overall view



BRM01029

(A) 43 mm [1.69 in]

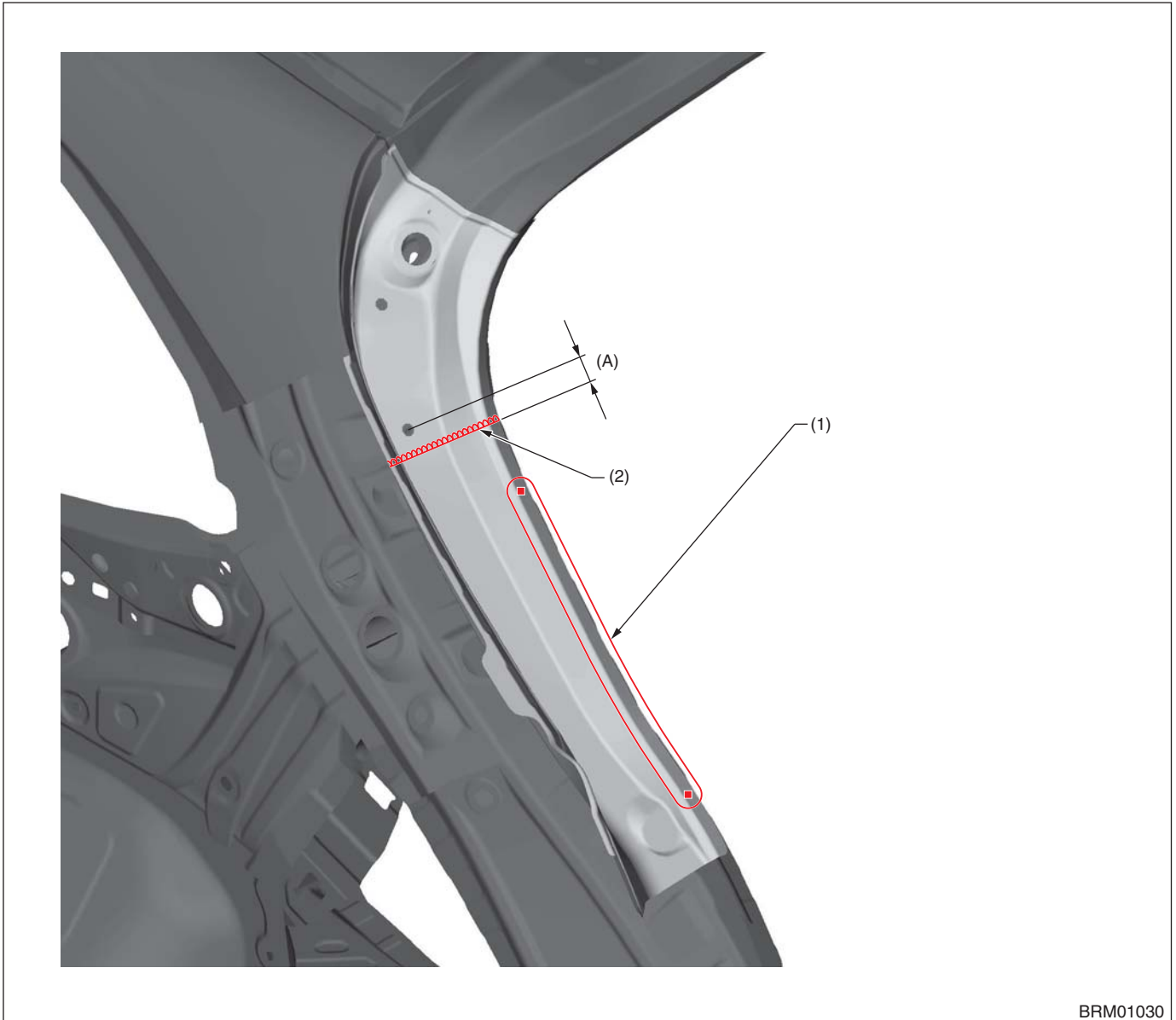
(1) 5 points (inside · 1)

(2) Cut position

Panel Replacement

B: INSTALLATION

• Overall view



BRM01030

(A) 23 mm [0.91 in]

(1) 5 points

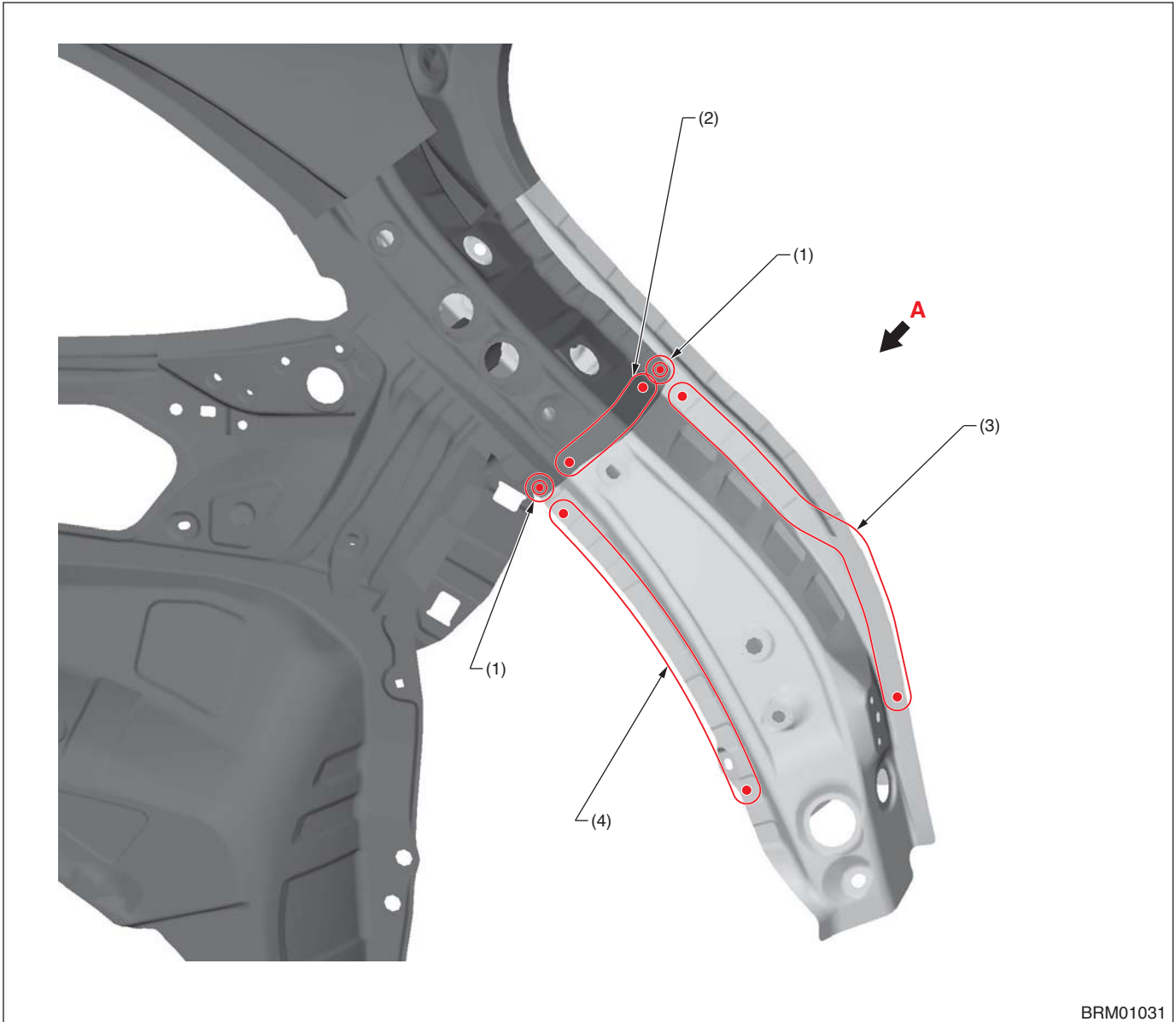
(2) 1 point (Continuous welding)

Panel Replacement

8-28. D Pillar Reinforcement (Partial replacement) OUTBACK

A: REMOVAL

- Overall view



BRM01031

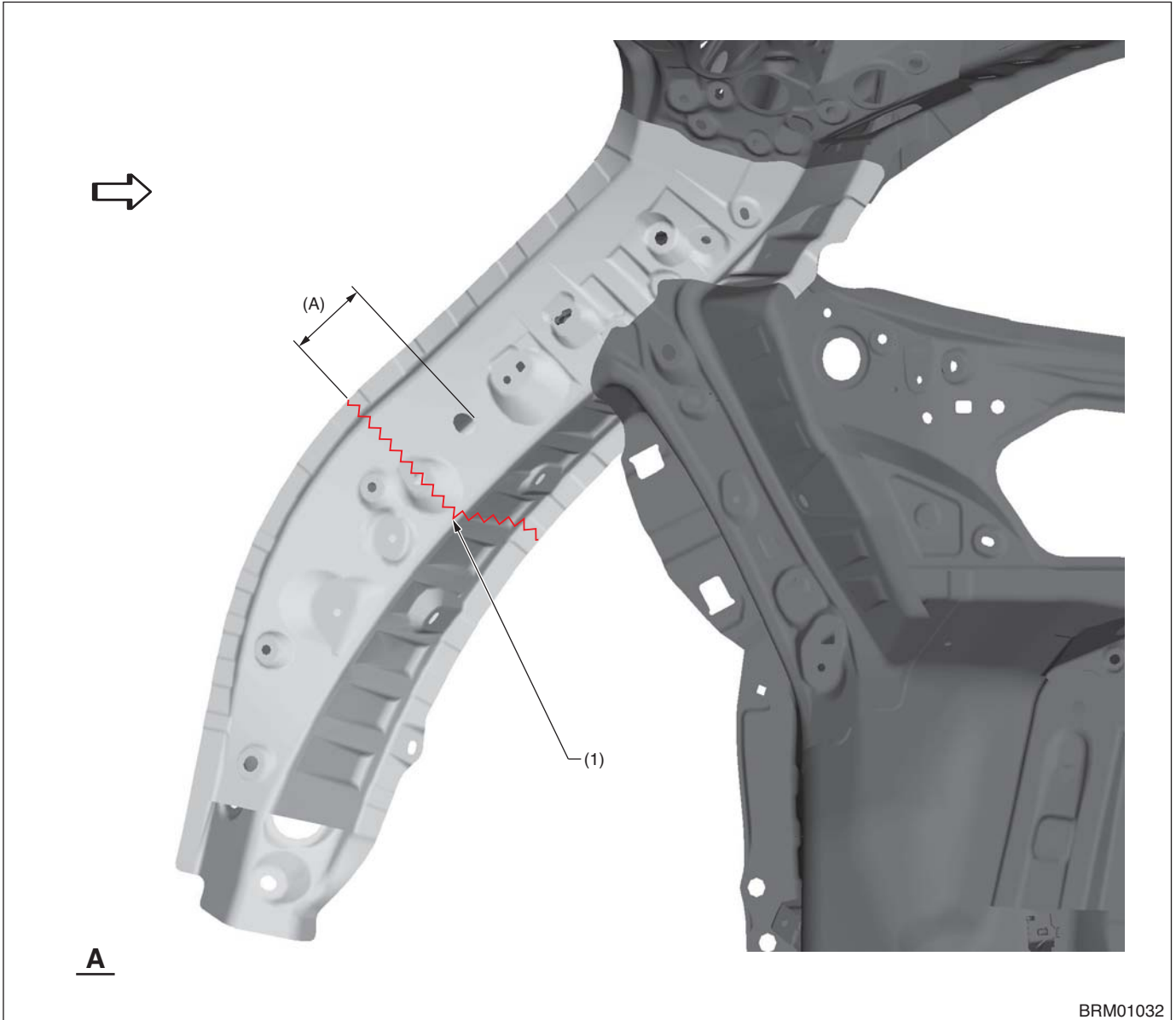
(1) 1 point (outside · 2)
(2) 4 points (outside · 1)

(3) 6 points (outside · 1)

(4) 7 points (outside · 1)

Panel Replacement

• View A



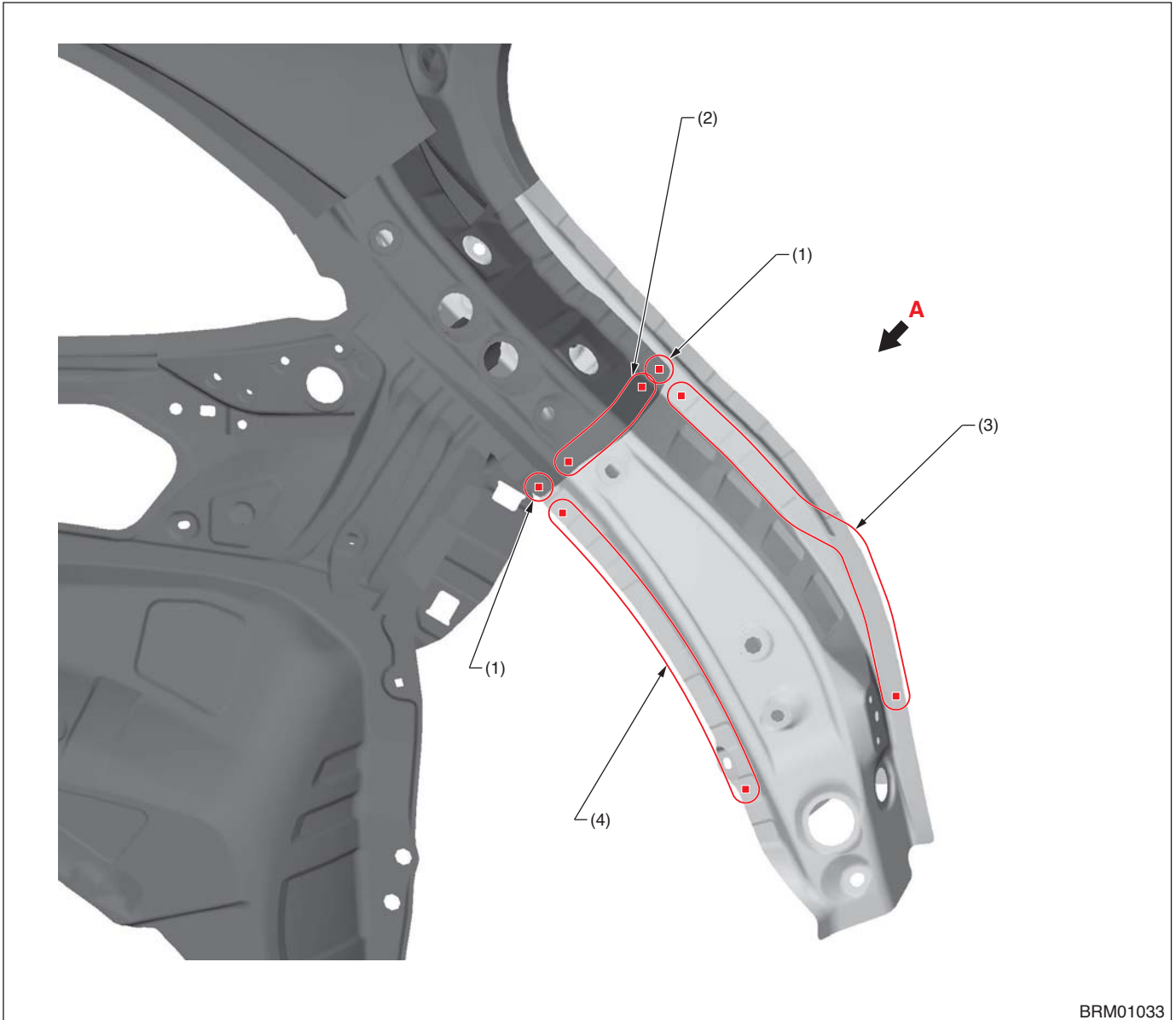
(A) 63 mm [4.28 in]

(1) Cut position

Panel Replacement

B: INSTALLATION

• Overall view



BRM01033

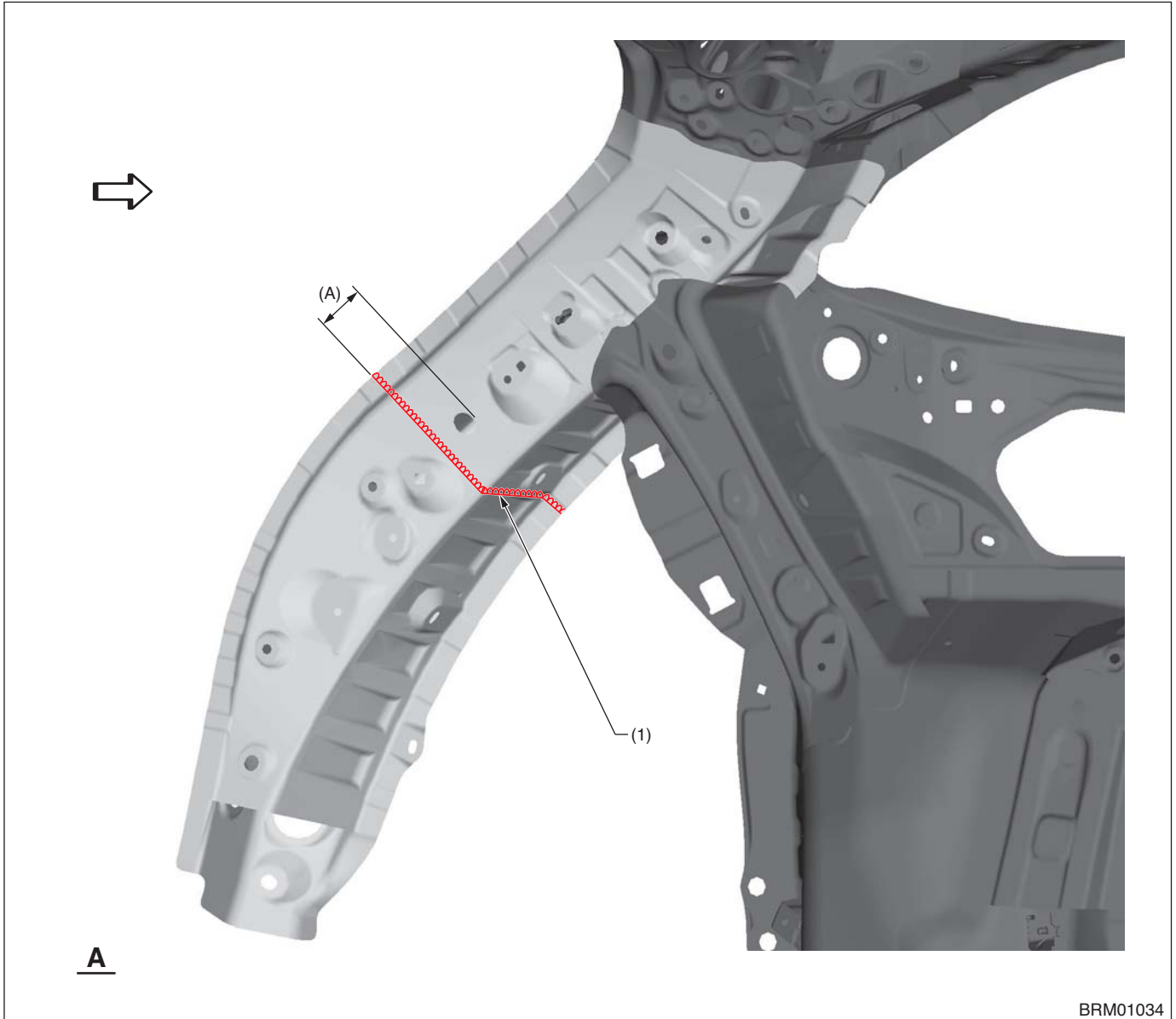
(1) 1 point (service · matching)
(2) 4 points

(3) 6 points

(4) 7 points

Panel Replacement

• View A



(A) 33 mm [1.30 in]

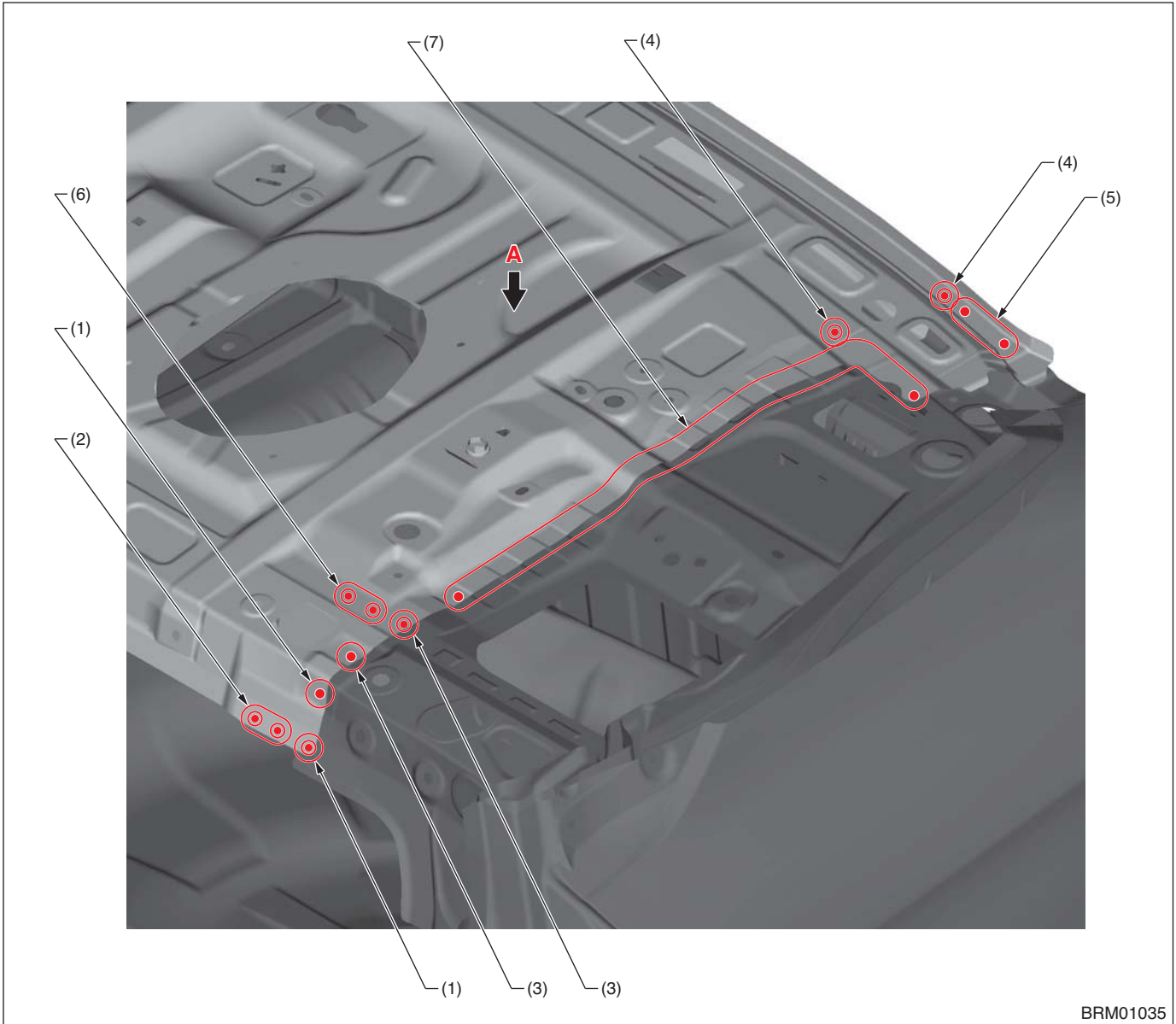
(1) 1 point (Continuous welding)

Panel Replacement

8-29. Rear Panel (Total replacement) SEDAN

A: REMOVAL

• Overall view



BRM01035

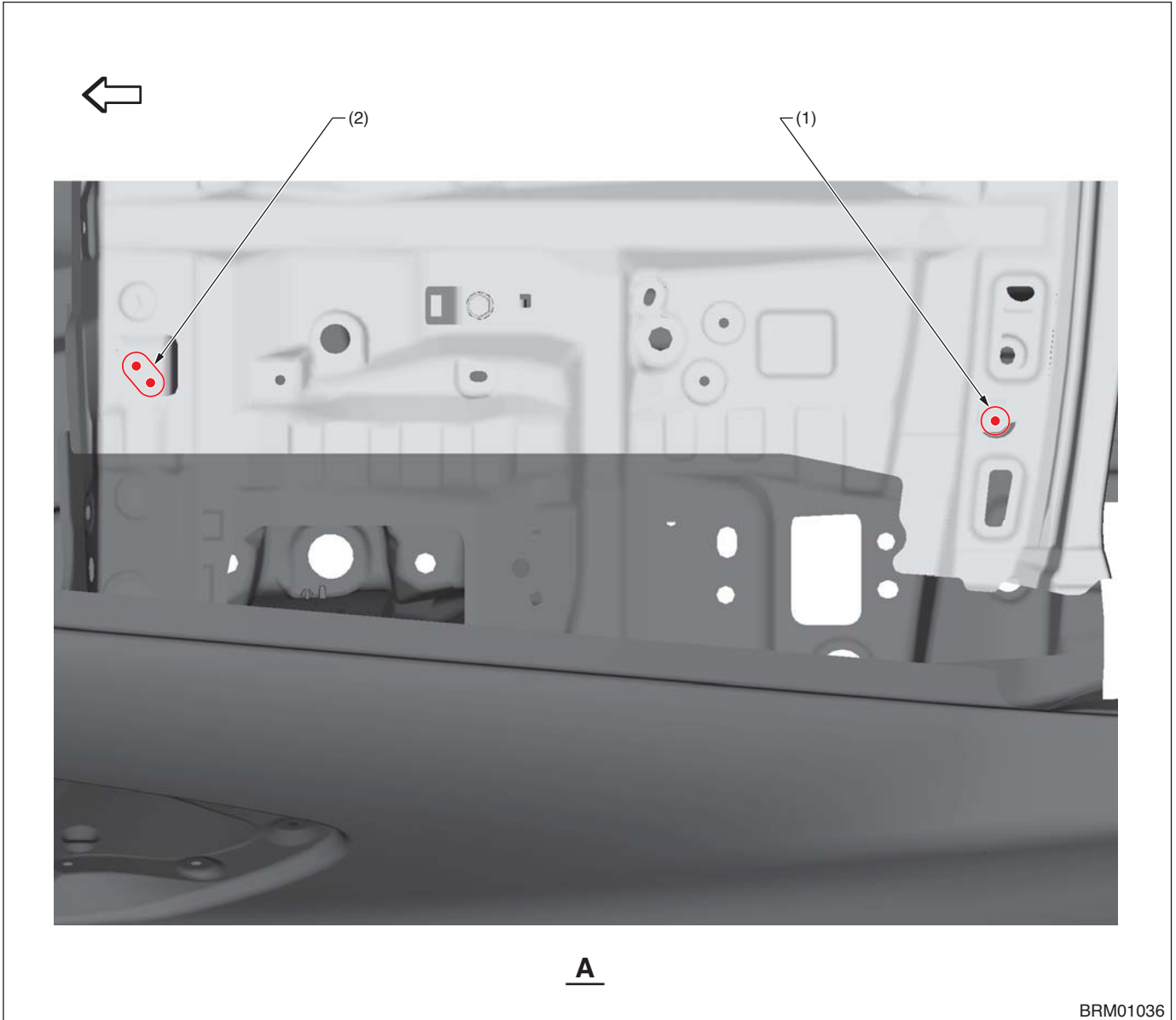
- (1) 1 point (inside · 1)
- (2) 2 points (inside · 2)
- (3) 1 point (top · 1)

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

- (7) 12 points (top · 1)

Panel Replacement

• View A



BRM01036

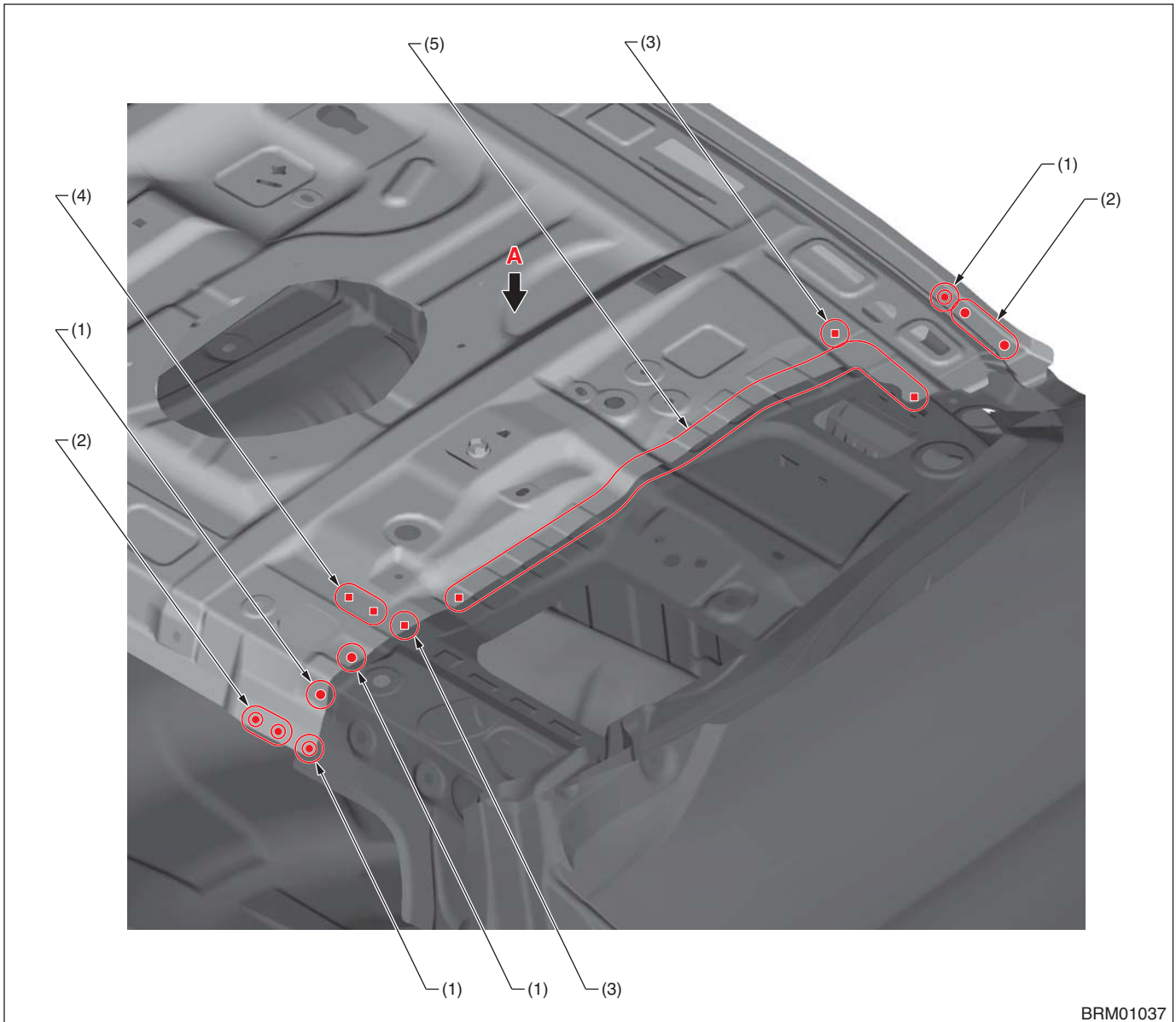
(1) 1 point (top · 1)

(2) 2 points (top · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BRM01037

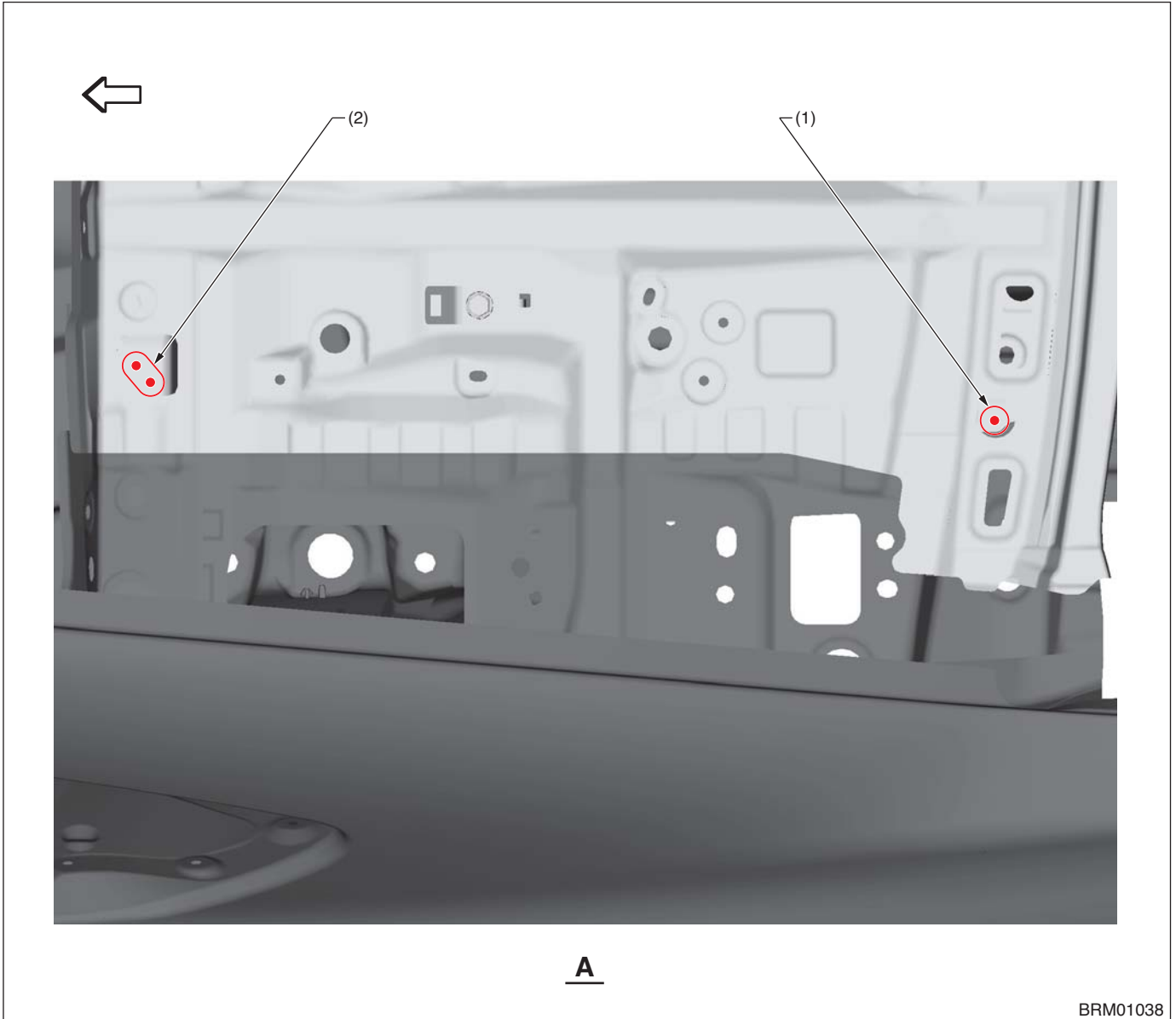
(1) 1 point
(2) 2 points

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

(5) 12 points (service)

Panel Replacement

• View A



BRM01038

(1) 1 point

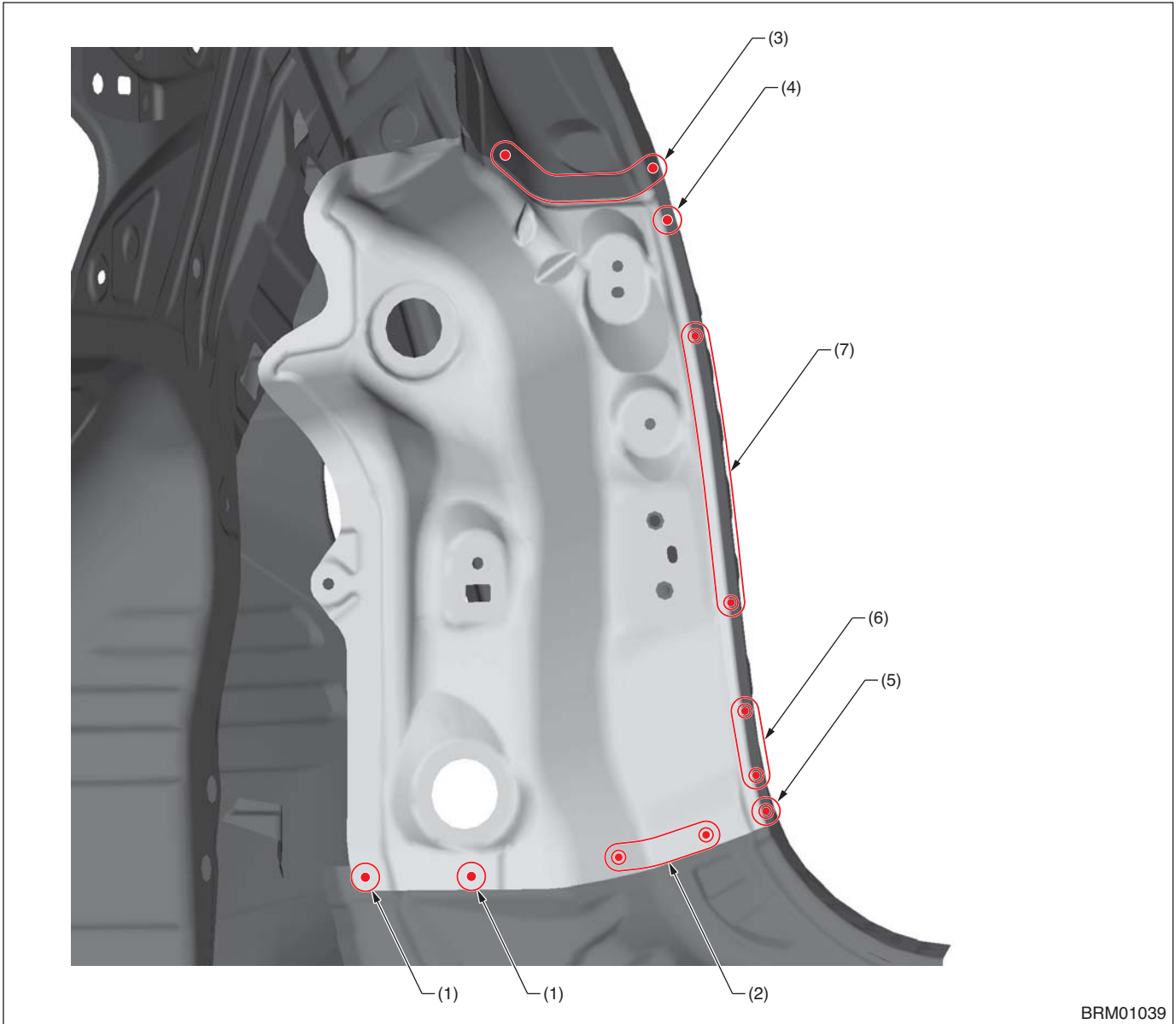
(2) 2 points

Panel Replacement

8-30. Rear Quarter End Panel (Total replacement) OUTBACK

A: REMOVAL

• Overall view



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

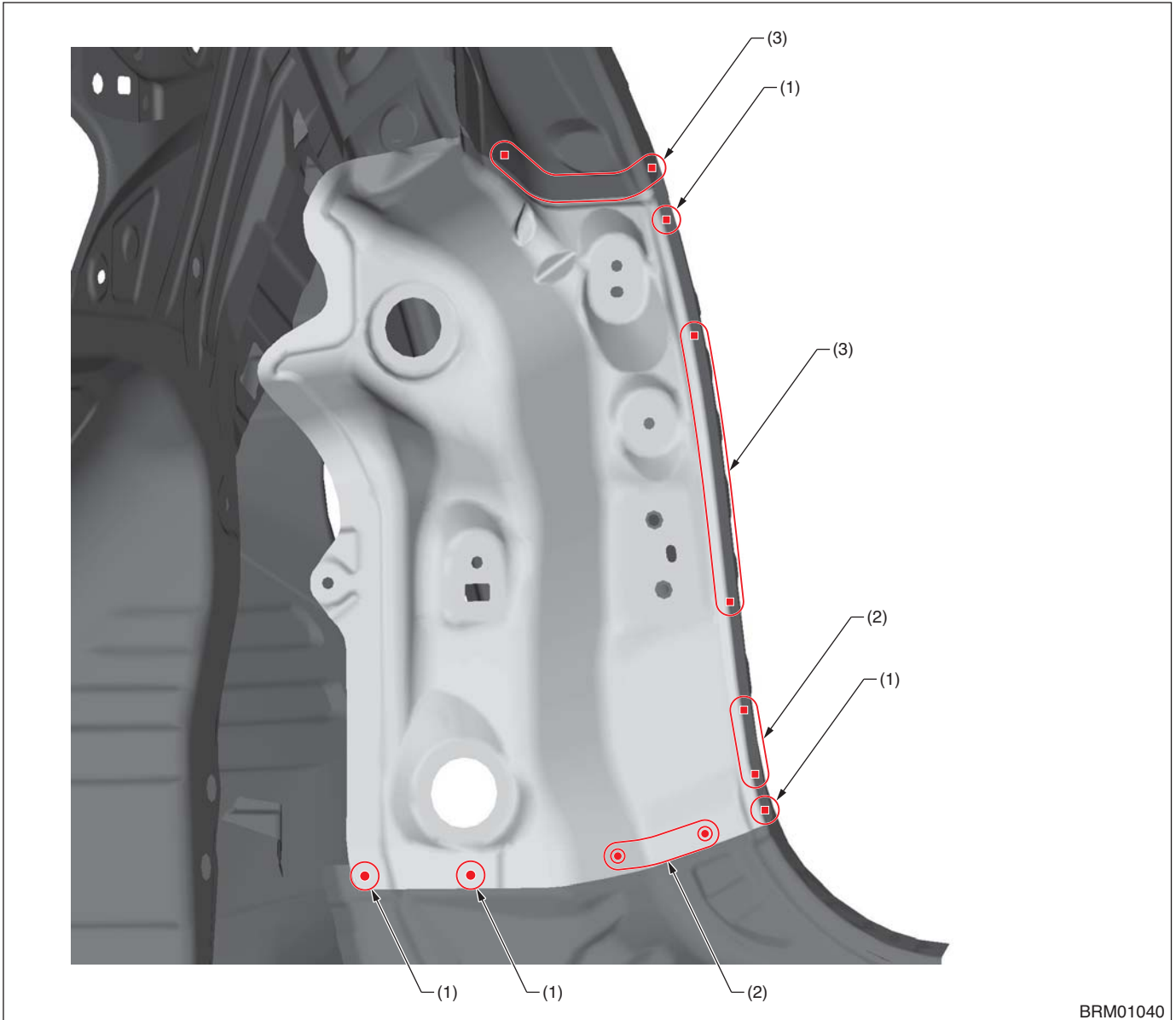
- (4) 1 point (inside · 1)
- (5) 1 point (inside · 2)
- (6) 2 points (inside · 2)

- (7) 3 points (inside · 2)

Panel Replacement

B: INSTALLATION

• Overall view



BRM01040

(1) 1 point

(2) 2 points

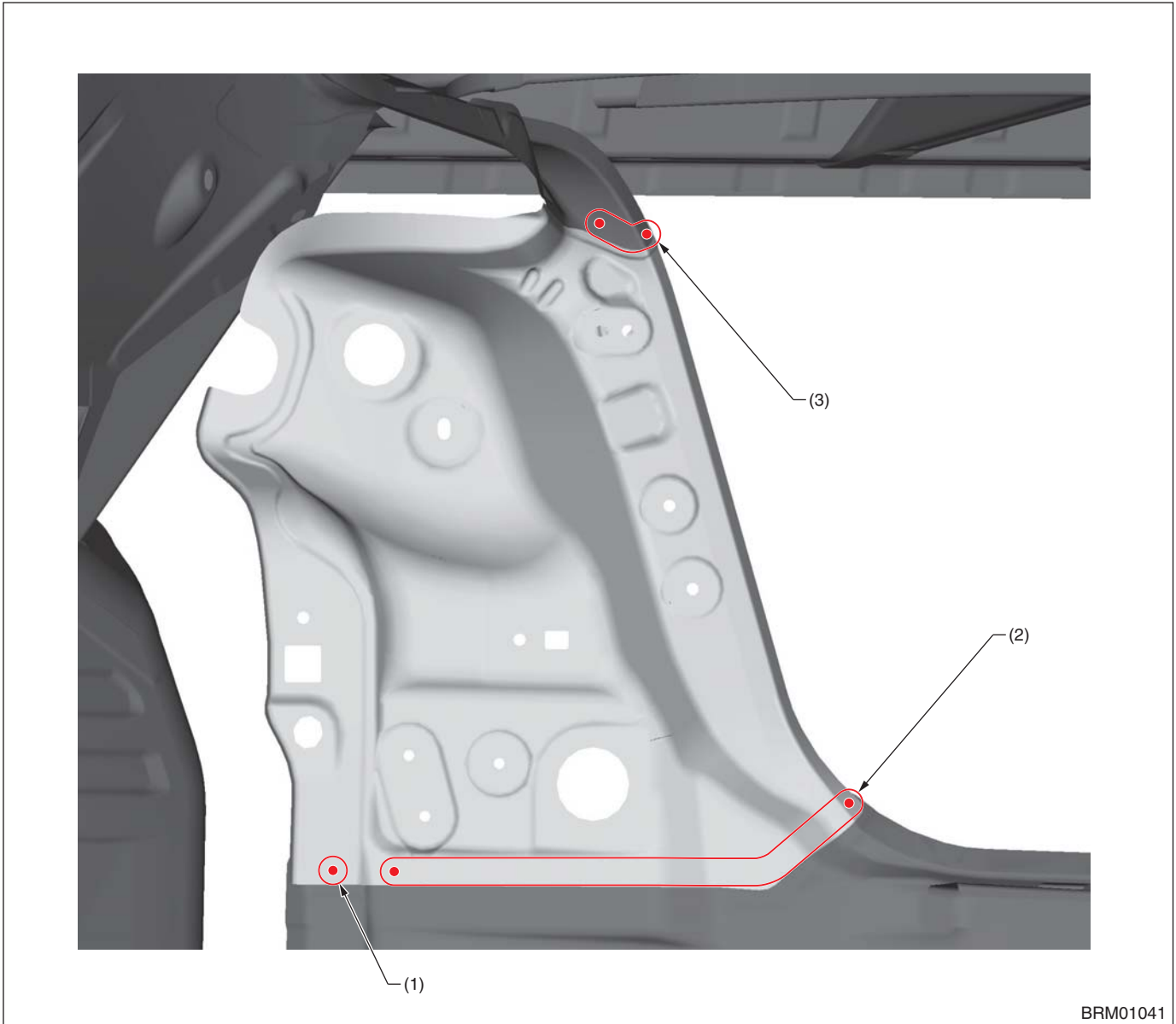
(3) 3 points

Panel Replacement

8-31. Rear Quarter End Panel (Total replacement) SEDAN

A: REMOVAL

- Overall view



BRM01041

(1) 1 point (outside - 1)

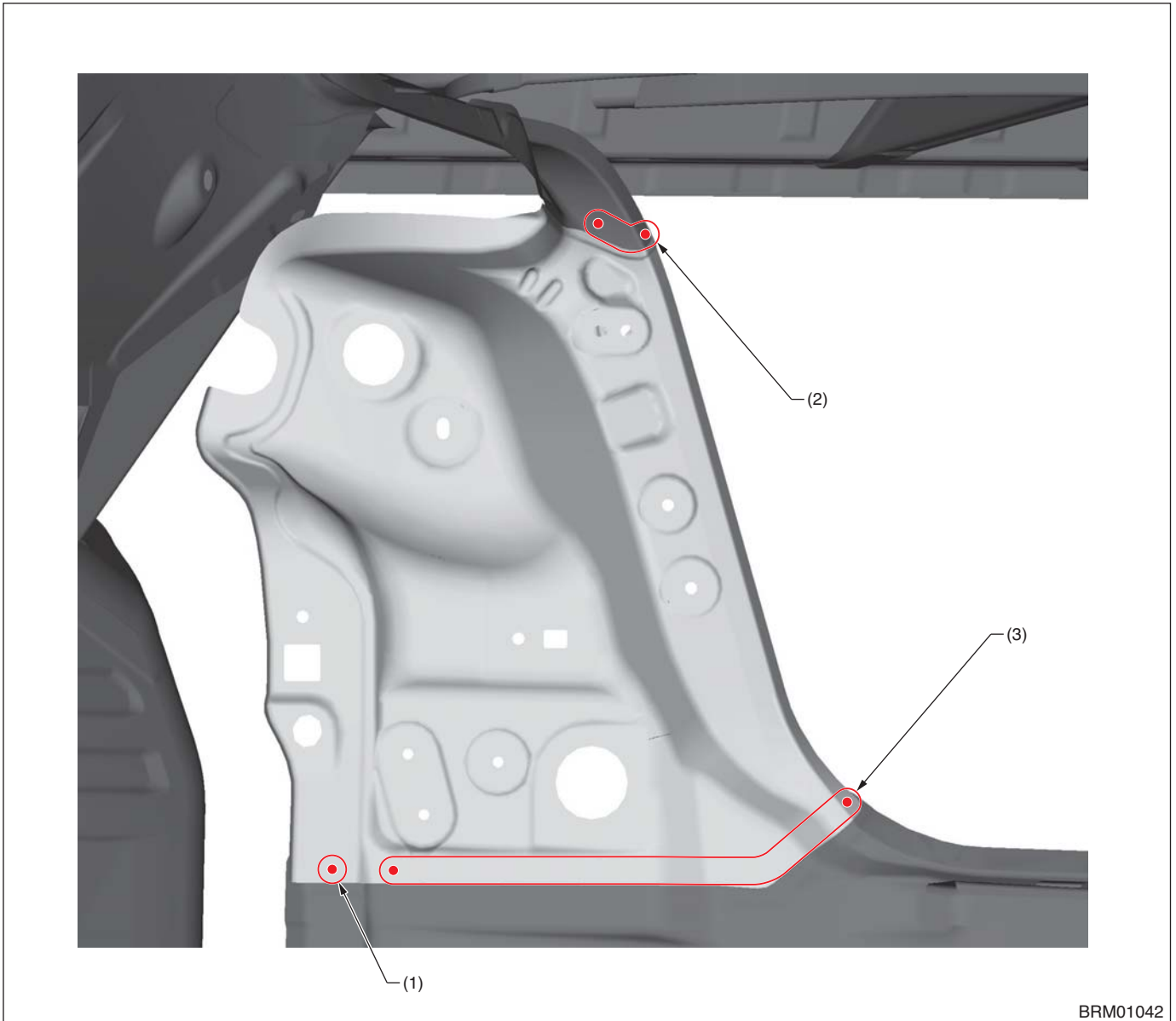
(2) 7 points (outside - 1)

(3) 3 points (inside - 1)

Panel Replacement

B: INSTALLATION

• Overall view



(1) 1 point

(2) 3 points

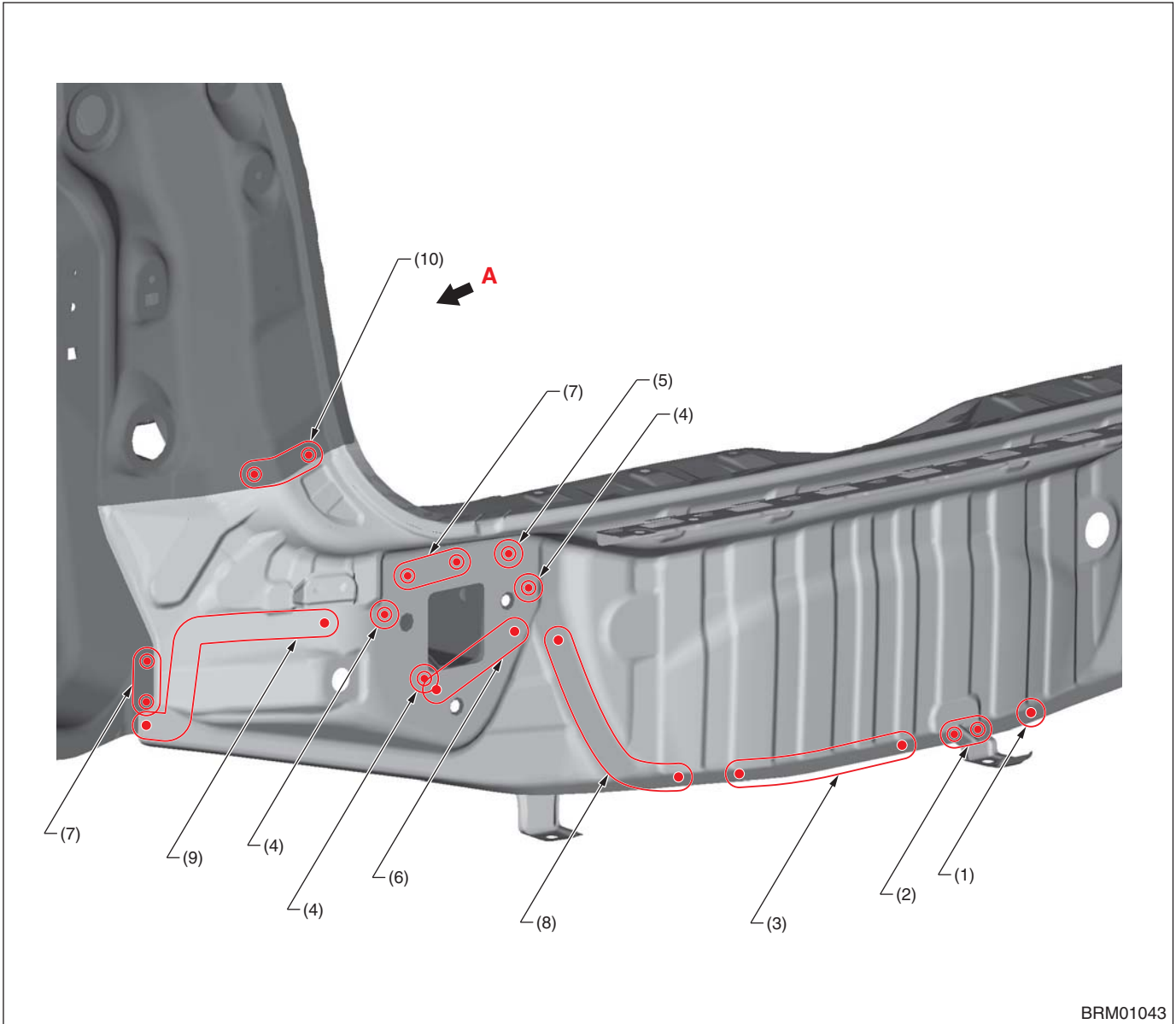
(3) 7 points

Panel Replacement

8-32. Rear Skirt (Total replacement) OUTBACK

A: REMOVAL

• Overall view

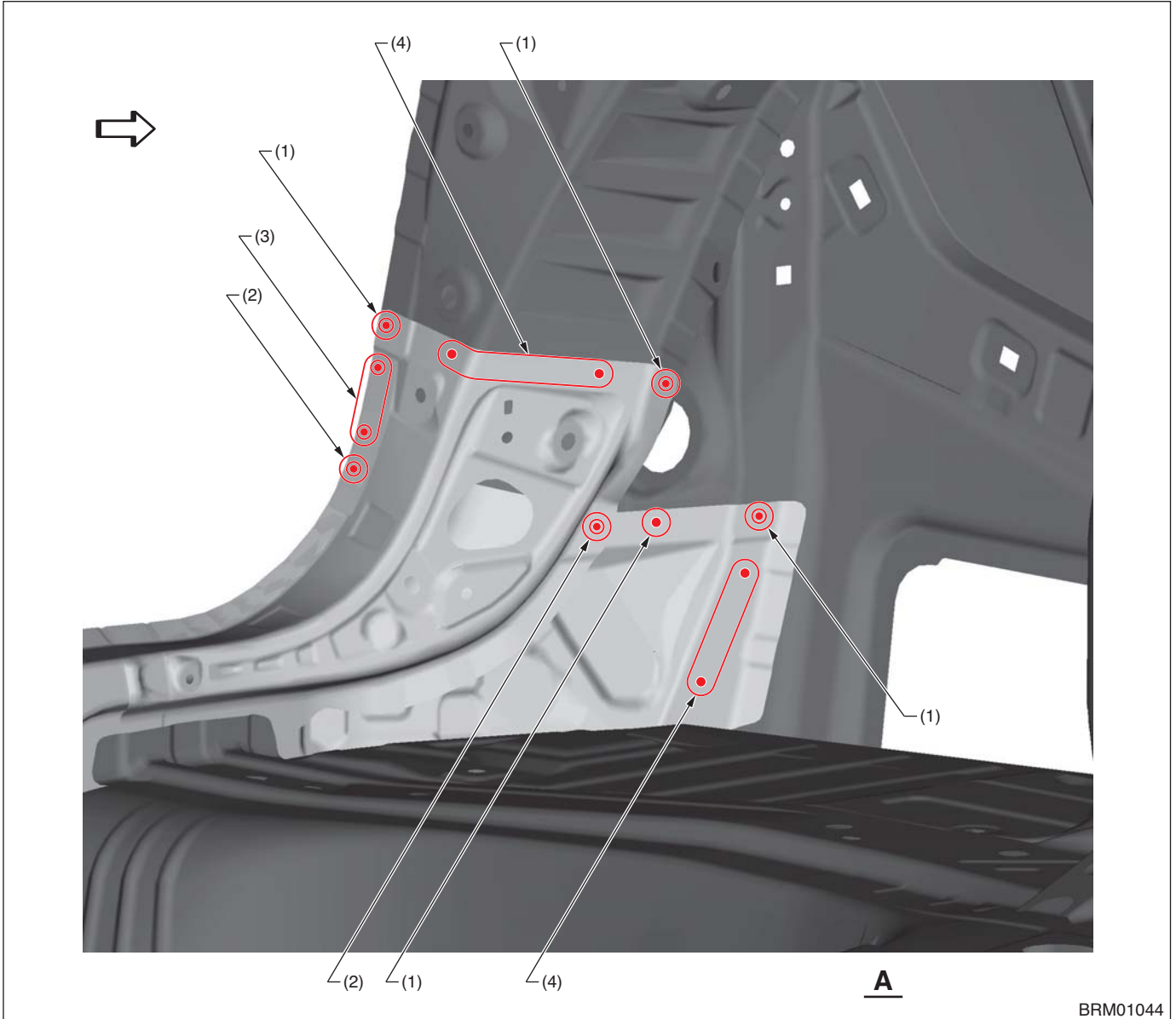


BRM01043

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

Panel Replacement

• View A



BRM01044

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

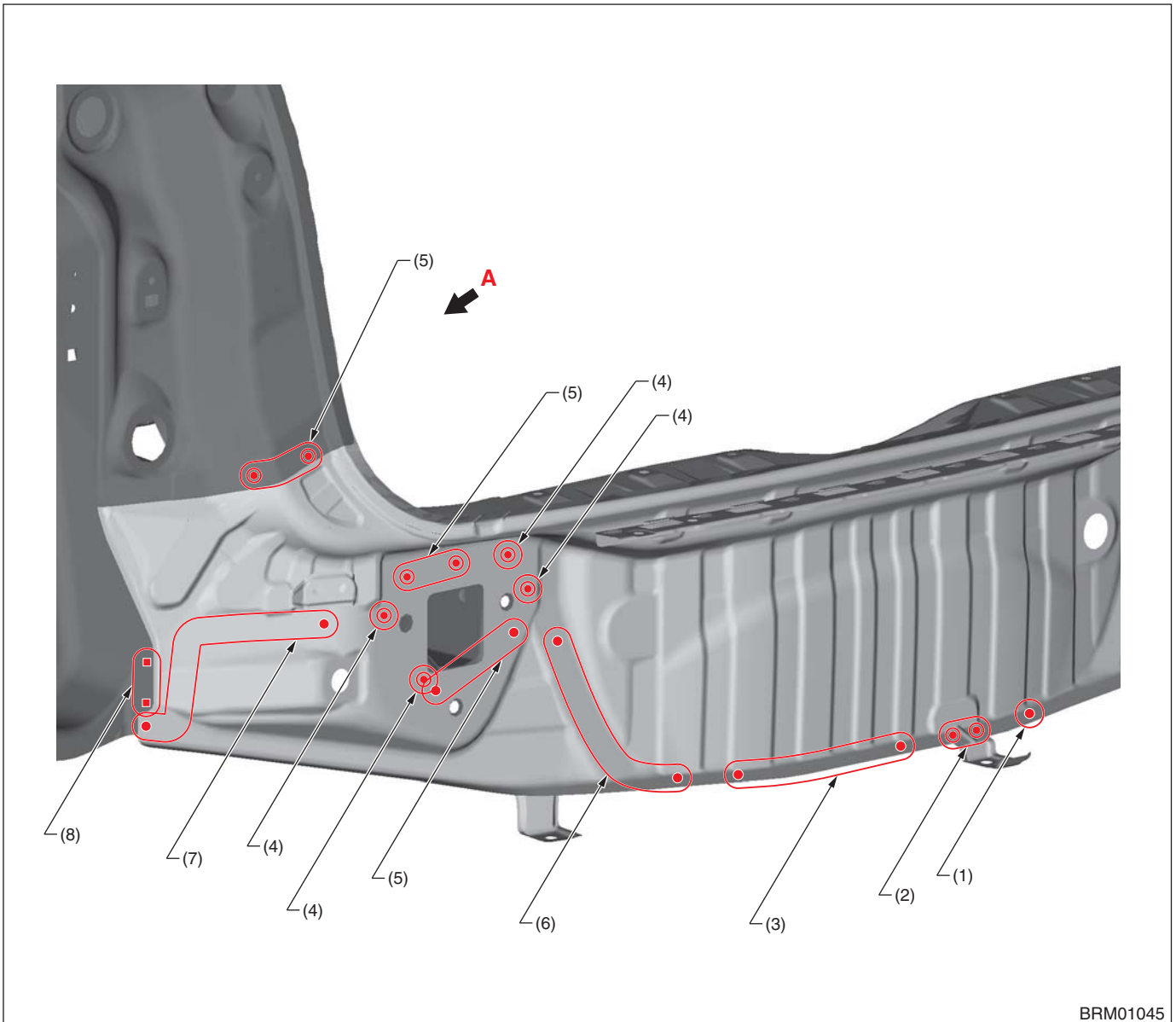
(3) 2 points (inside · 1)

(4) 3 points (inside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BRM01045

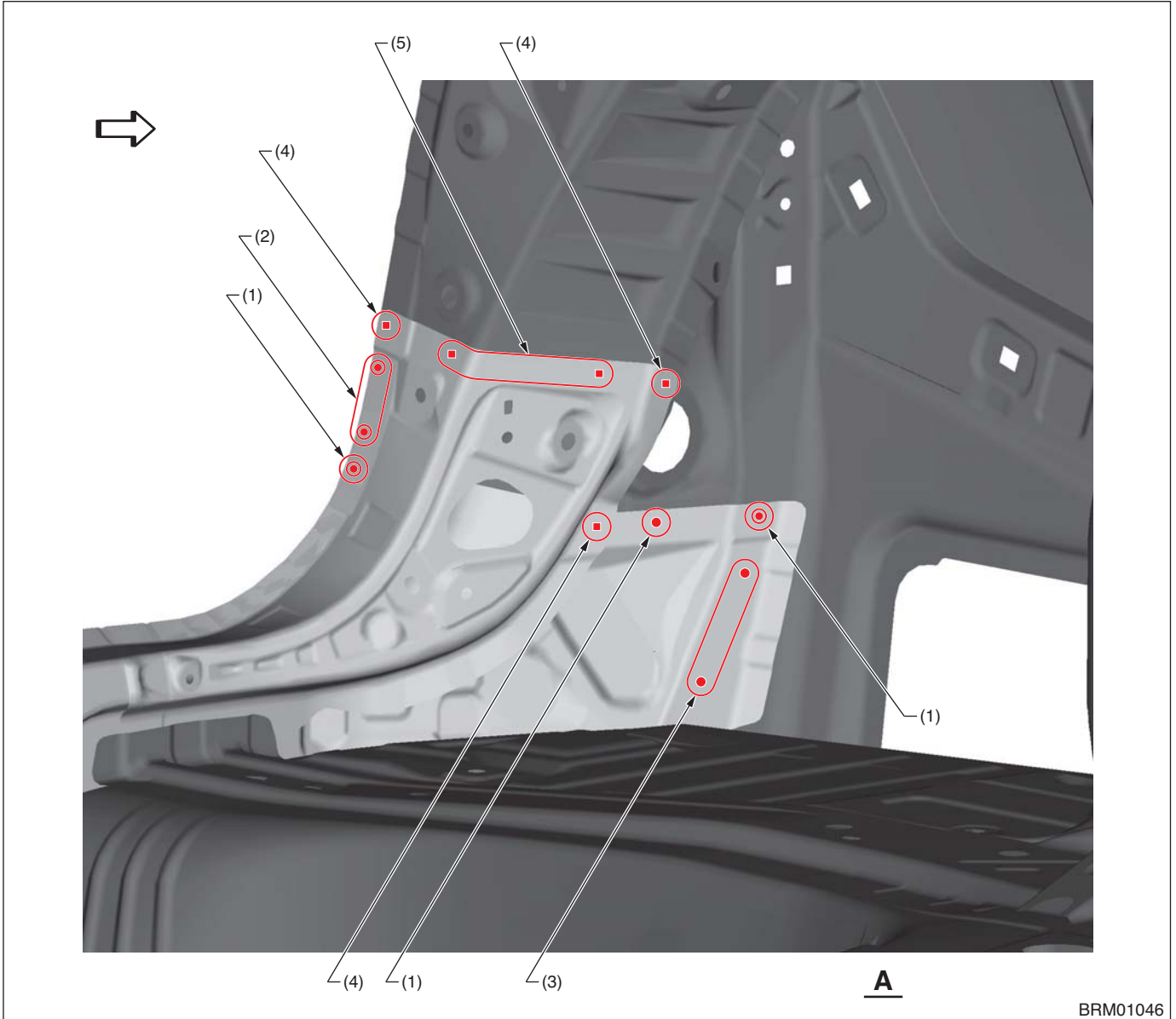
- (1) 1 point Only RH
- (2) 2 points Only RH
- (3) 4 points Only LH

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

- (7) 6 points
- (8) 2 points (service · matching)

Panel Replacement

• View A



BRM01046

(1) 1 point
(2) 2 points

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

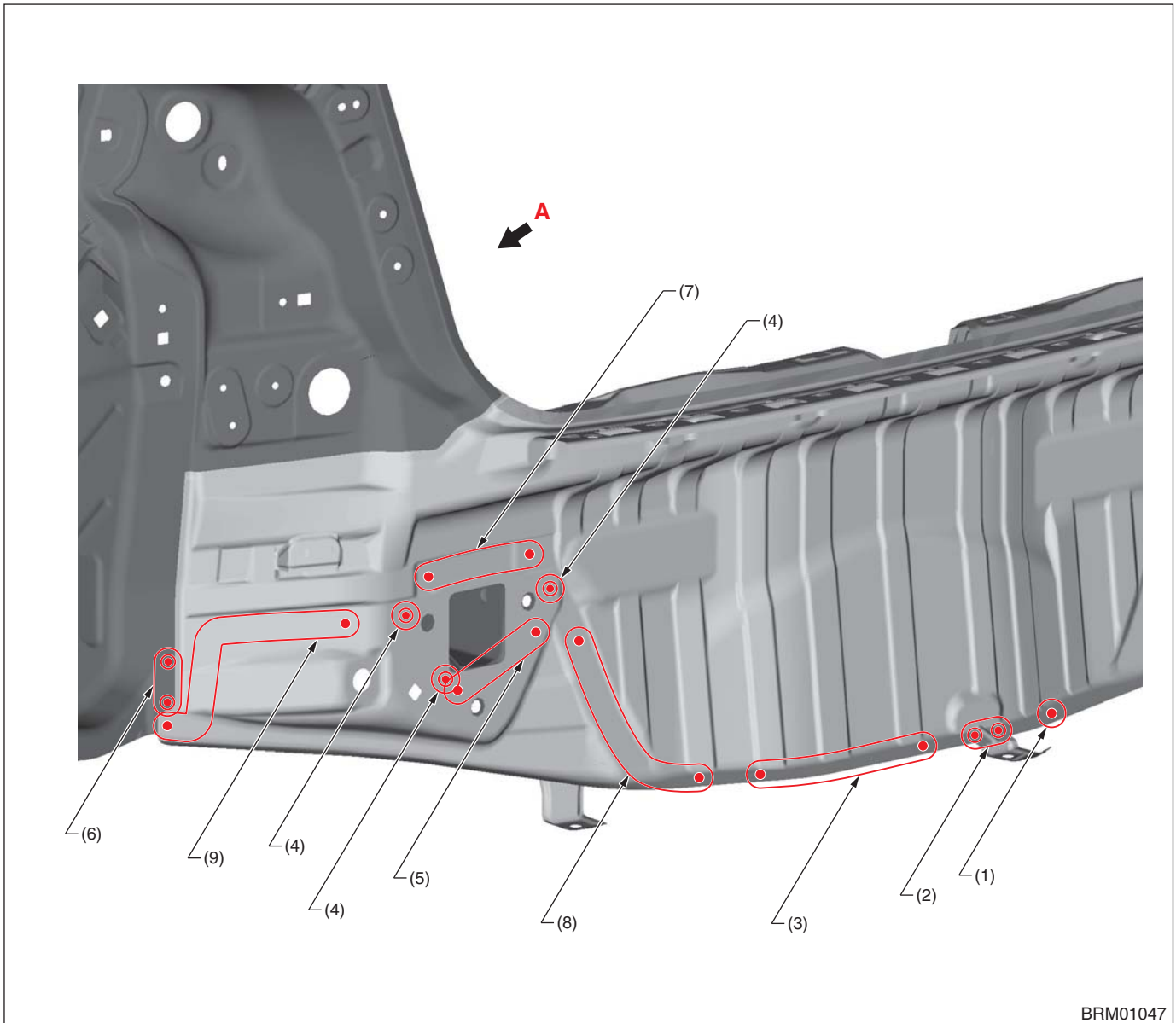
(5) 3 points (service)

Panel Replacement

8-33. Rear Skirt (Total replacement) SEDAN

A: REMOVAL

• Overall view

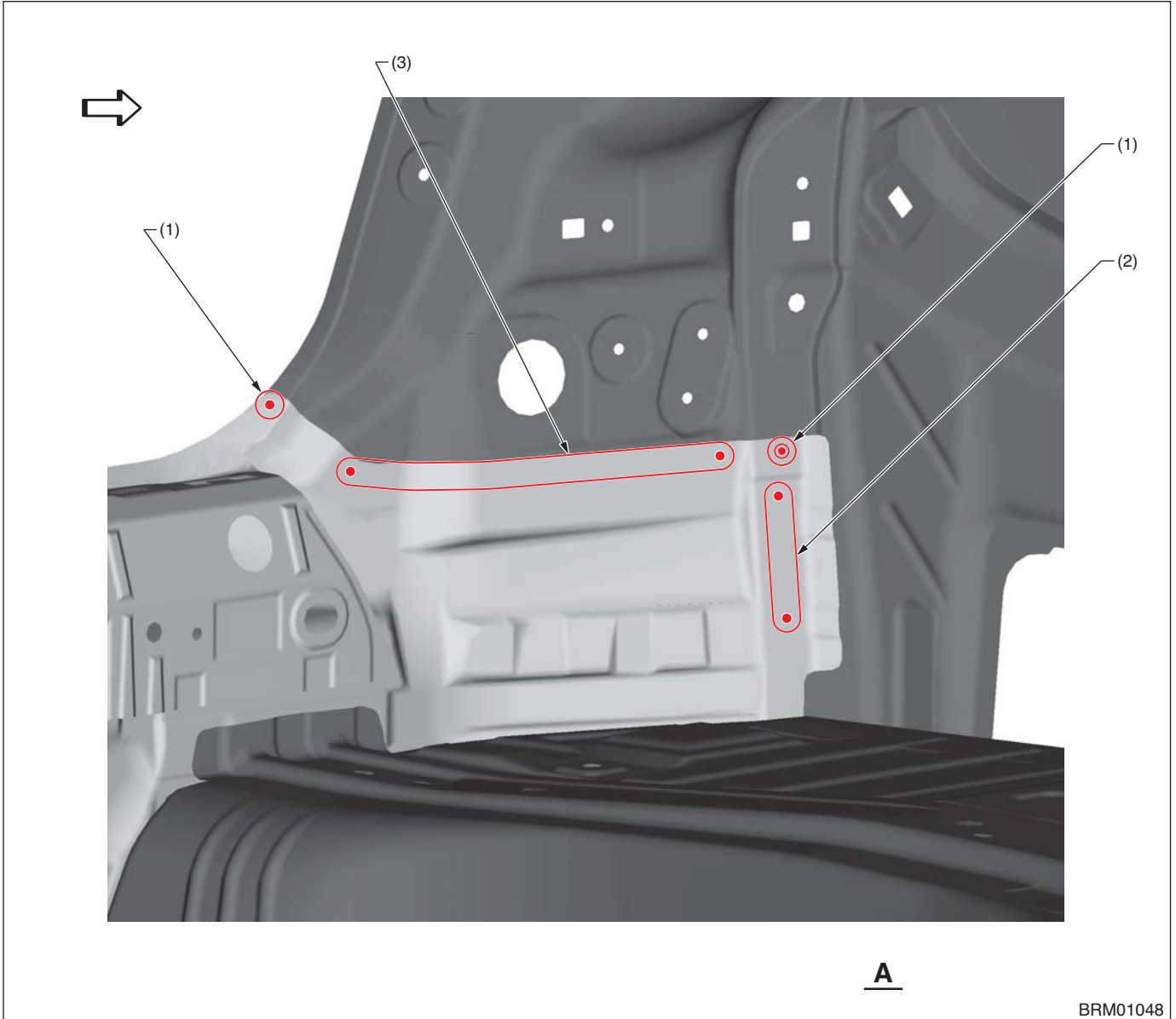


BRM01047

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

Panel Replacement

• View A



BRM01048

(1) 1 point (inside · 1)

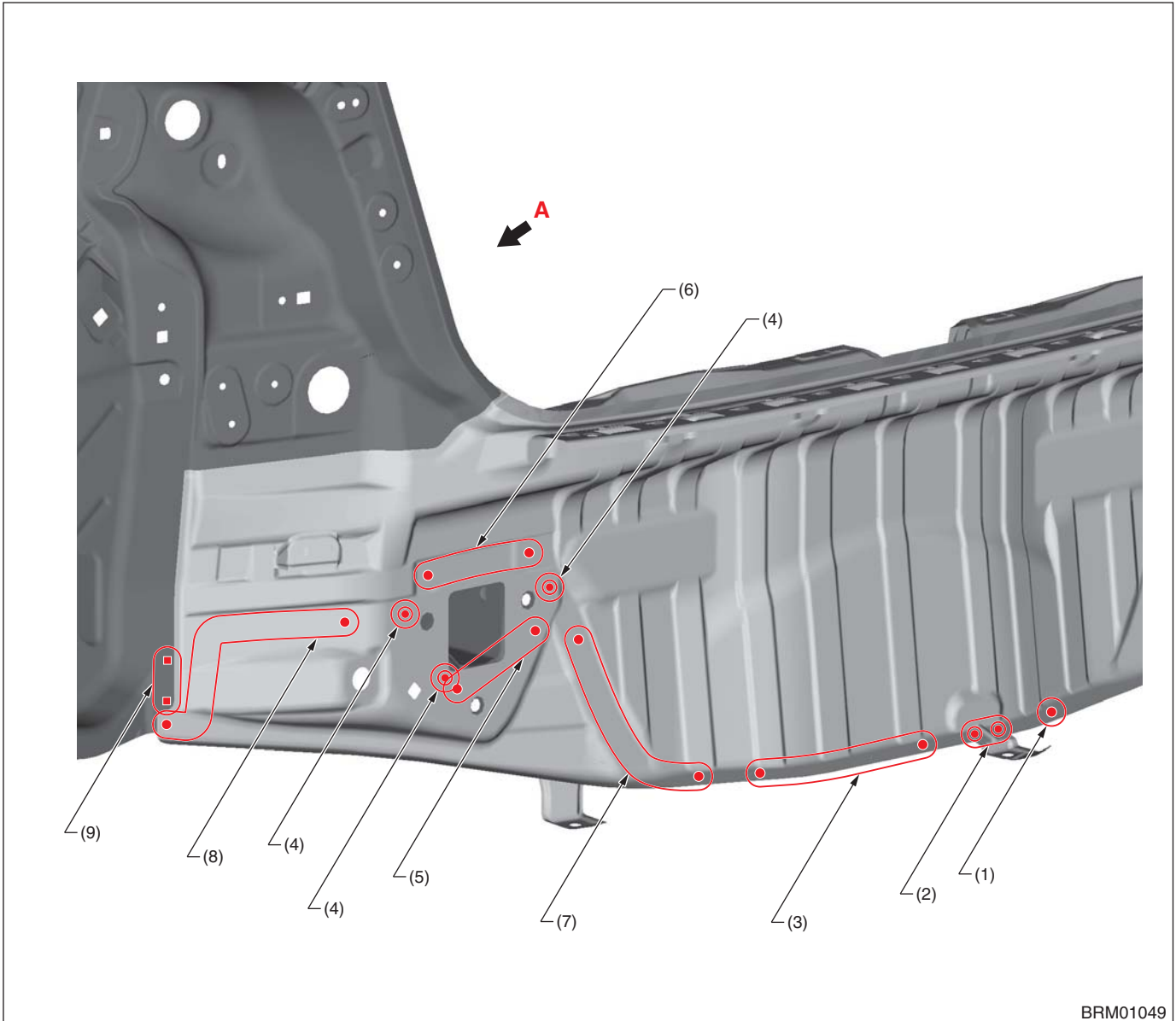
(2) 3 points (inside · 1)

(3) 6 points (inside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BRM01049

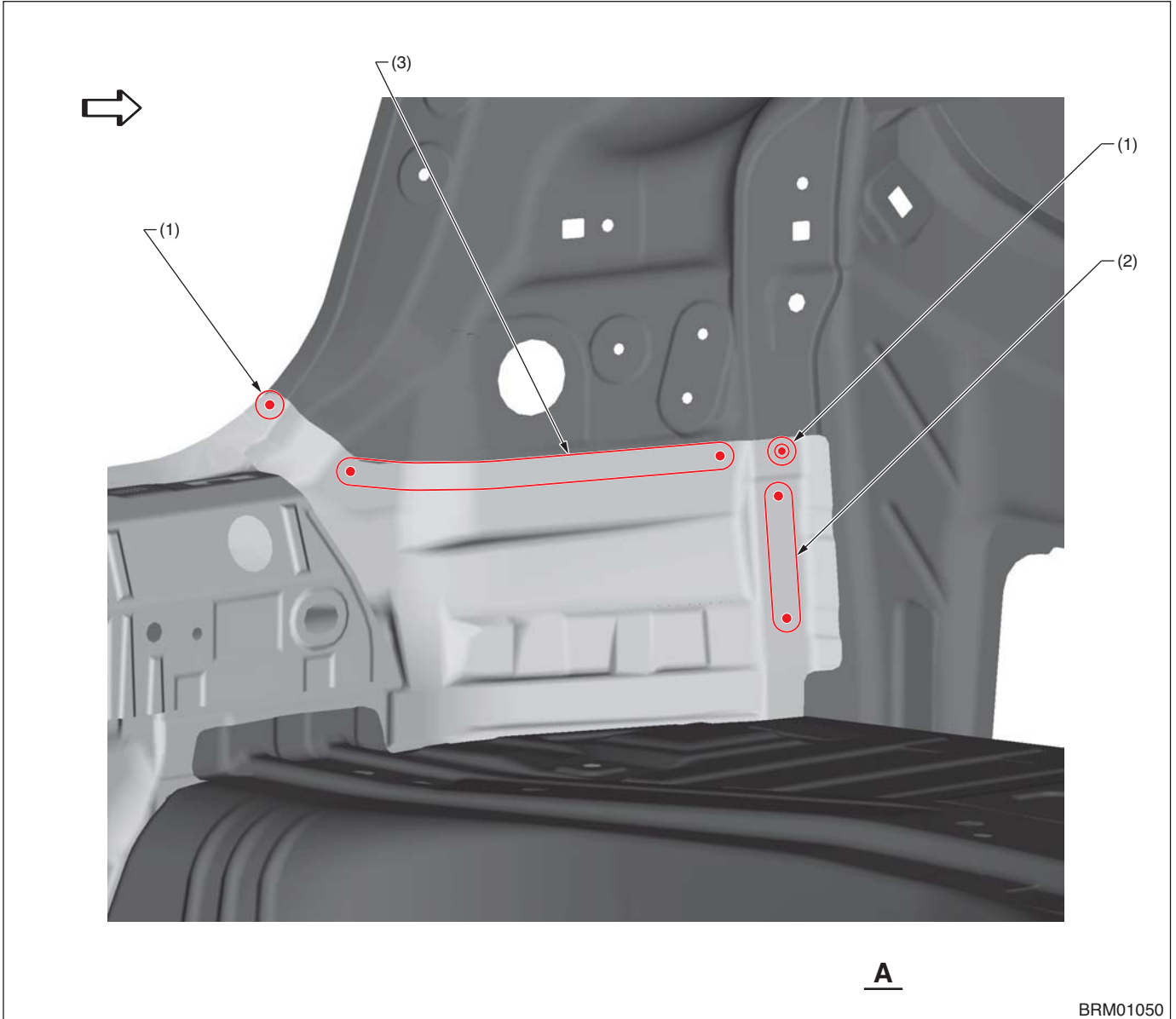
- (1) 1 point Only RH
- (2) 2 points Only RH
- (3) 4 points Only LH

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

- (7) 4 points
- (8) 6 points
- (9) 2 points (service · matching)

Panel Replacement

• View A



(1) 1 point

(2) 3 points

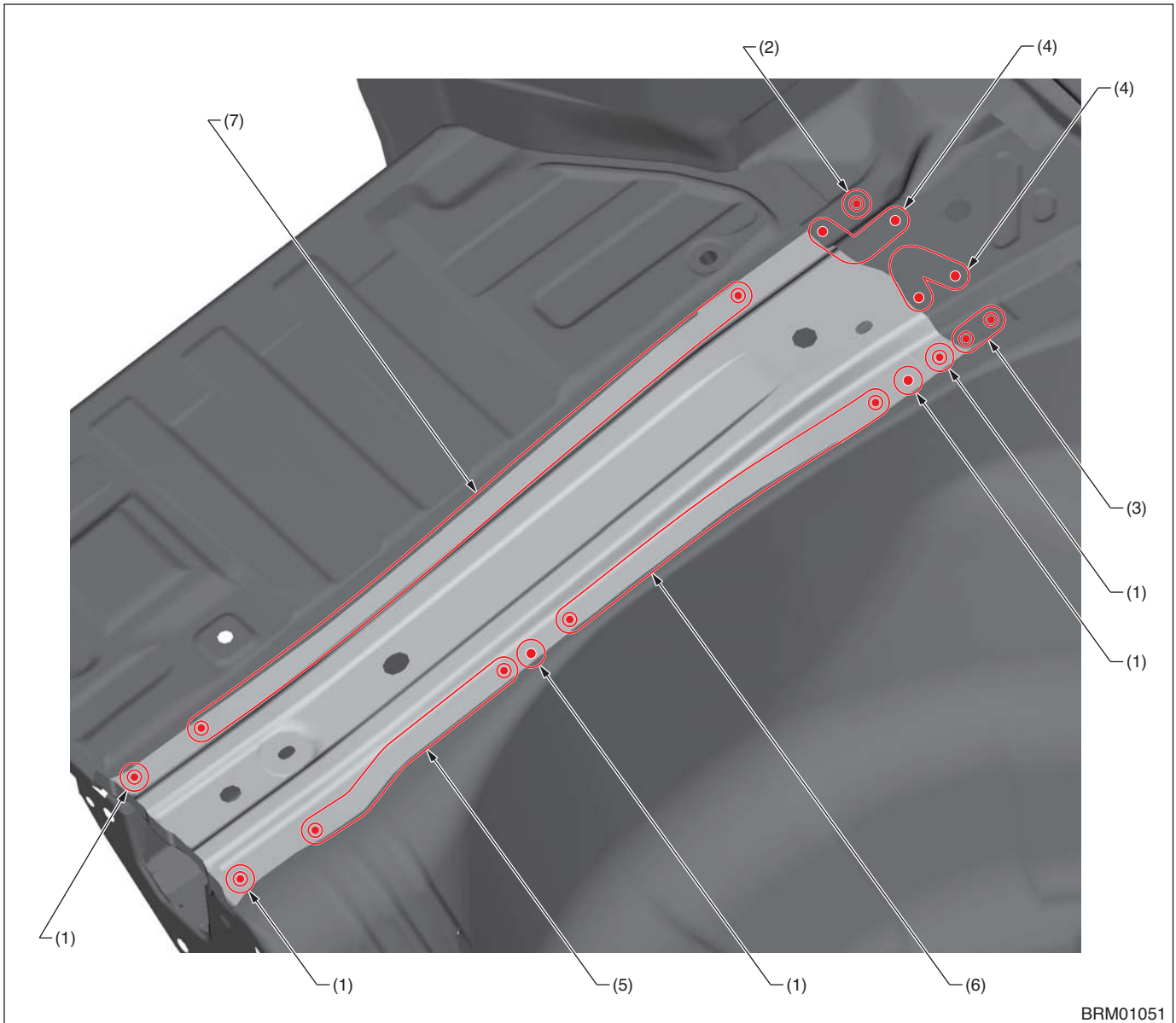
(3) 6 points

Panel Replacement

8-34. Rear Side Frame Upper Rear (Total replacement)

A: REMOVAL

• Overall view



BRM01051

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

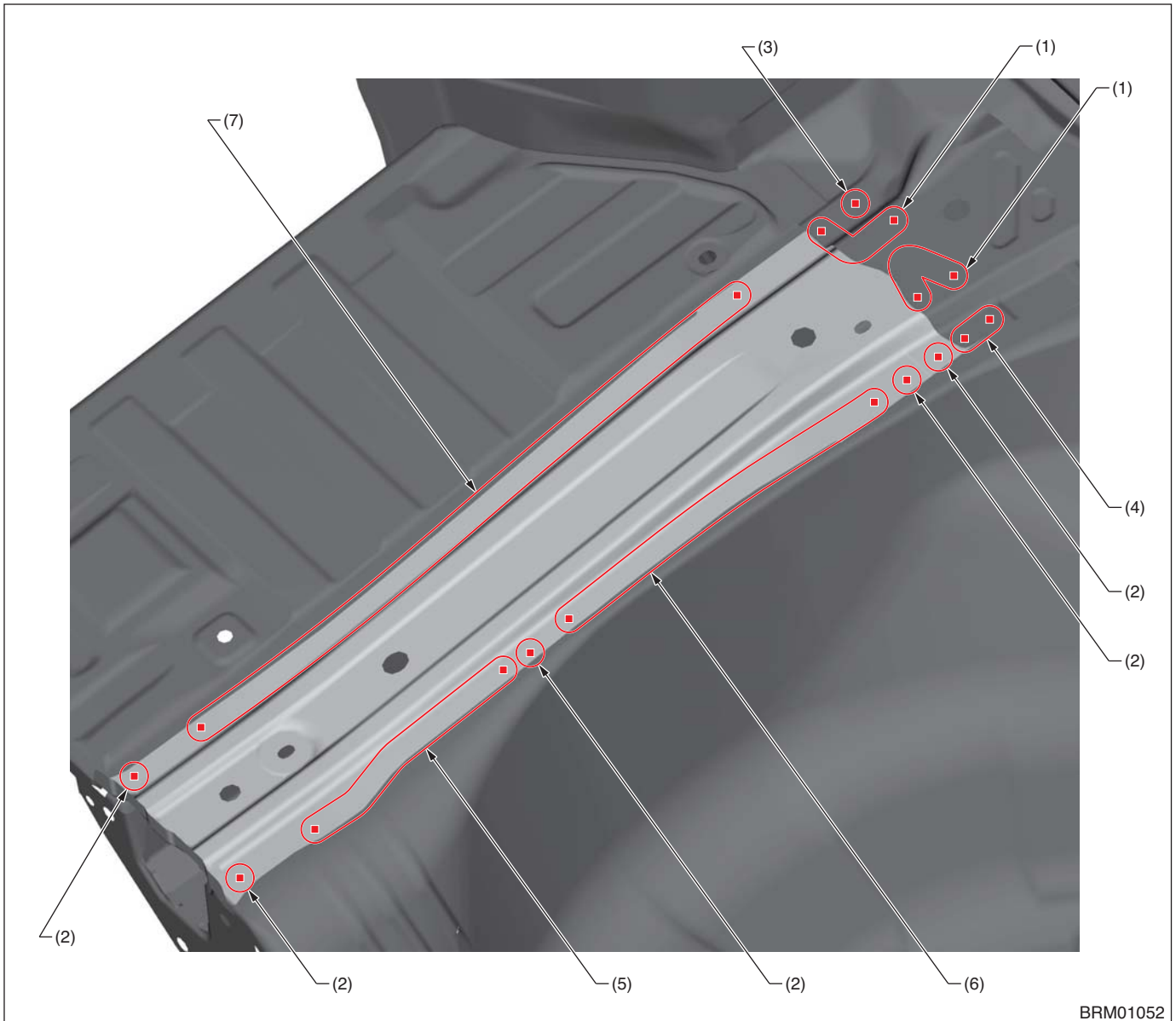
- (4) 3 points (top · 1)
- (5) 5 points (top · 1)
- (6) 6 points (top · 1)

- (7) 10 points (top · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BRM01052

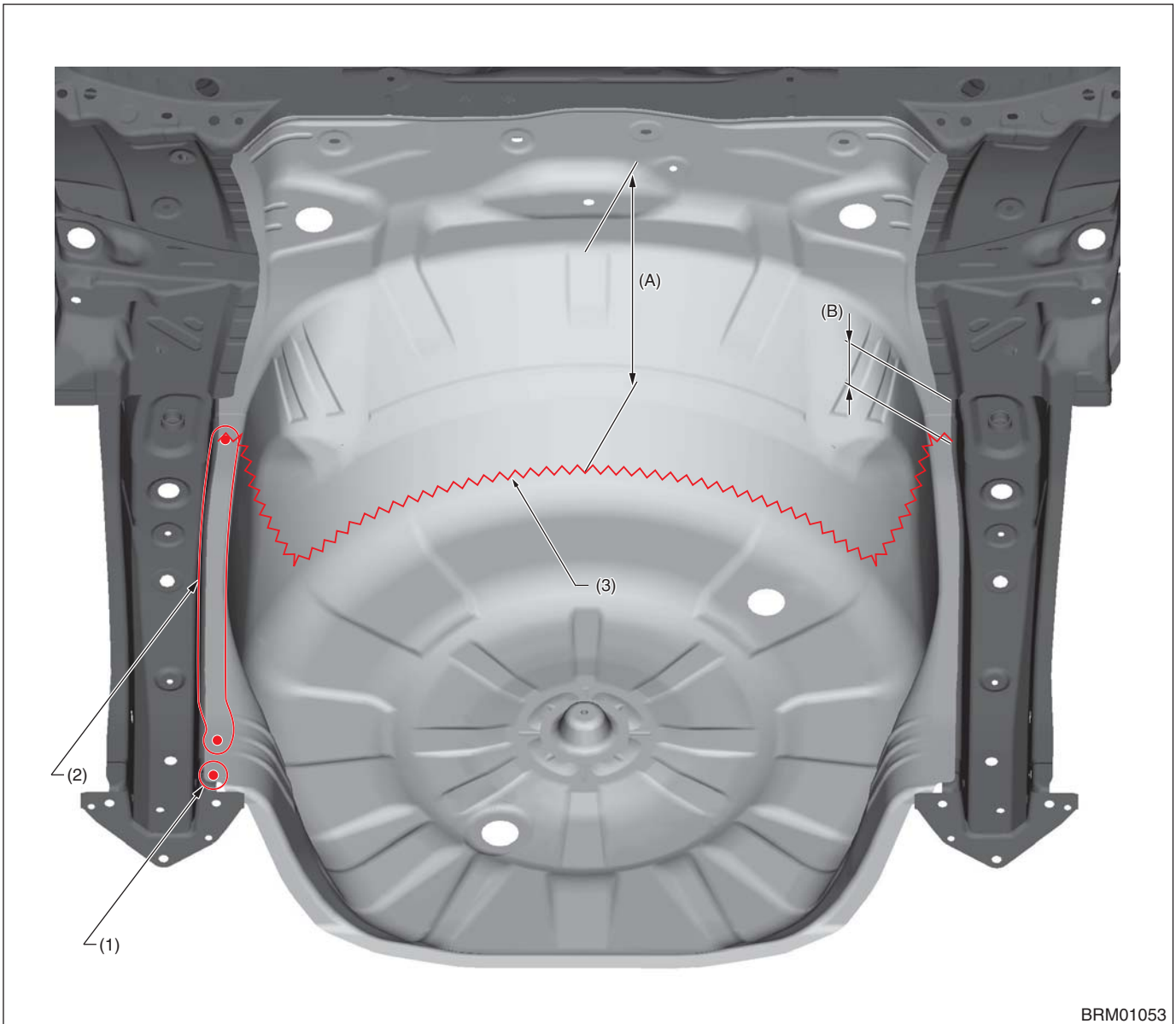
- | | | |
|----------------------------------|-----------------------------------|-------------------------|
| (1) 3 points | (4) 2 points (service · matching) | (7) 10 points (service) |
| (2) 1 point (service) | (5) 5 points (service) | |
| (3) 1 point (service · matching) | (6) 6 points (service)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

Panel Replacement

8-35. Rear Floor Pan (Partial replacement)

A: REMOVAL

- Overall view



BRM01053

(A) 227 mm [8.94 in]

(B) 60 mm [2.36 in]

(1) 1 point (top · 1)

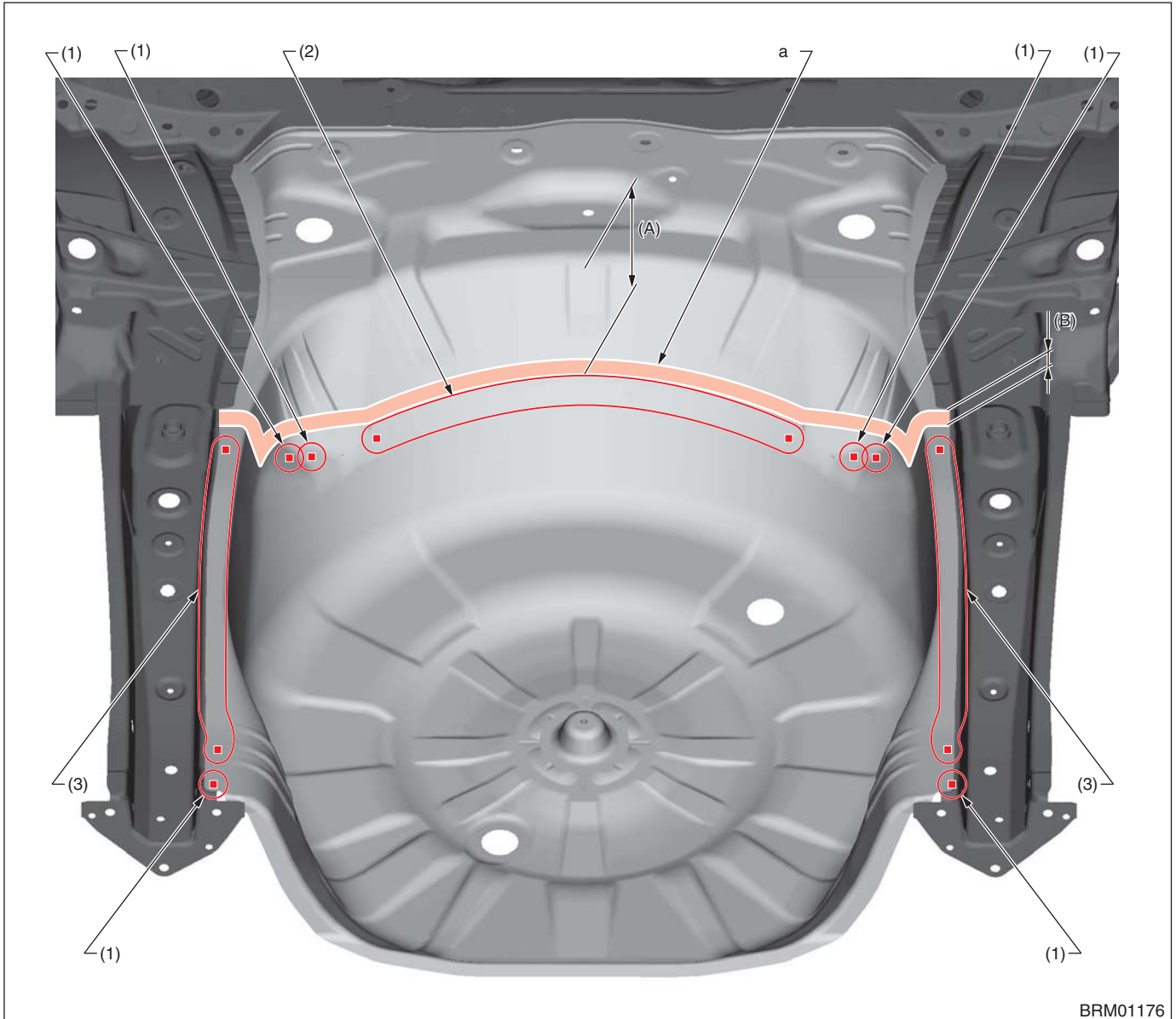
(2) 11 points (top · 1)

(3) Cut position

Panel Replacement

B: INSTALLATION

• Overall view



BRM01176

(A) 110 mm [4.33 in]

(B) 22 mm [0.87 in]

(1) 1 point (service)

(2) 8 points (service)

(3) 11 points (service)

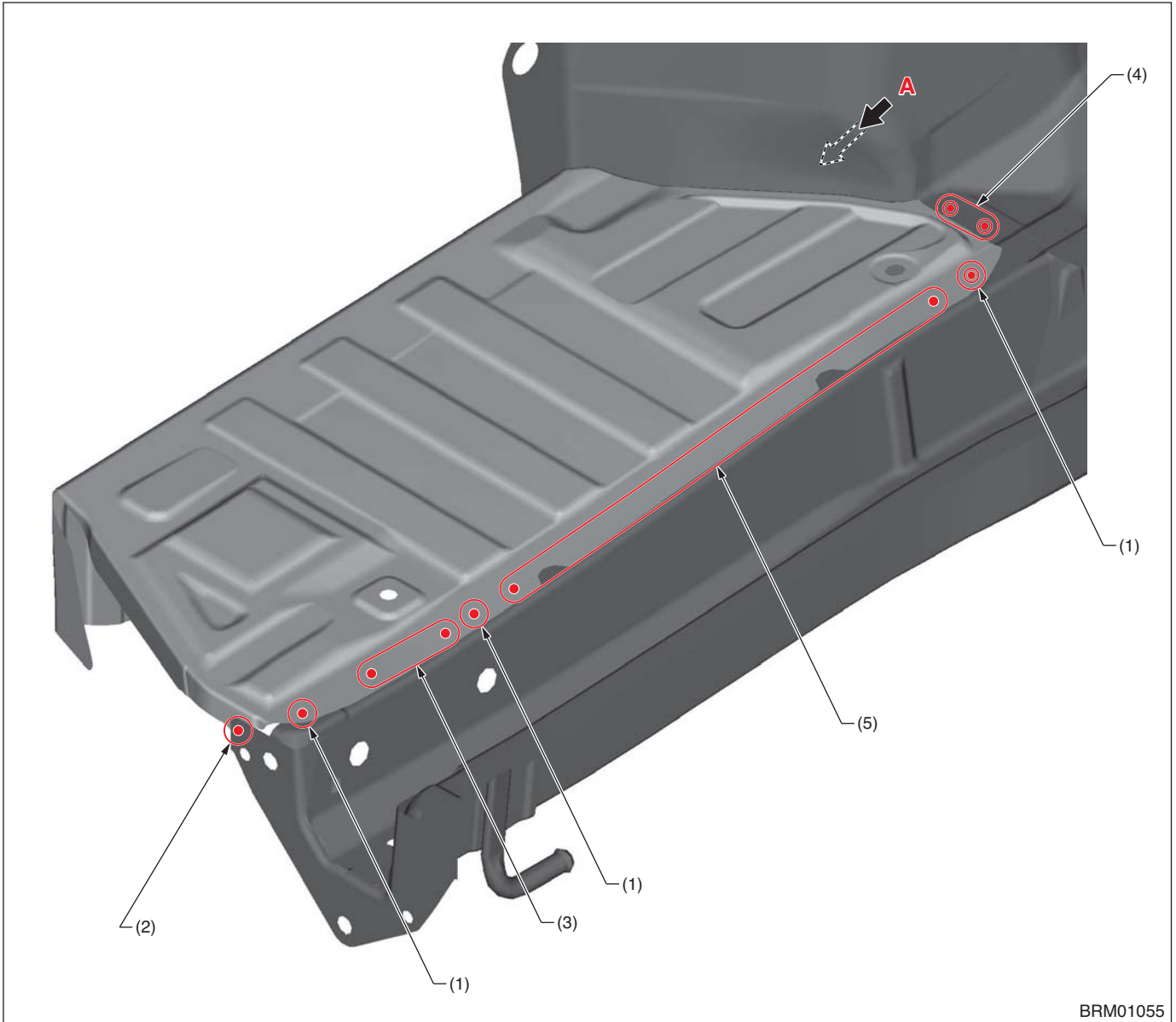
Note: Apply sealing agent to the floor pan fitting parts (front and rear) of section "a".

Panel Replacement

8-36. Rear Floor Side (Total replacement)

A: REMOVAL

• Overall view



BRM01055

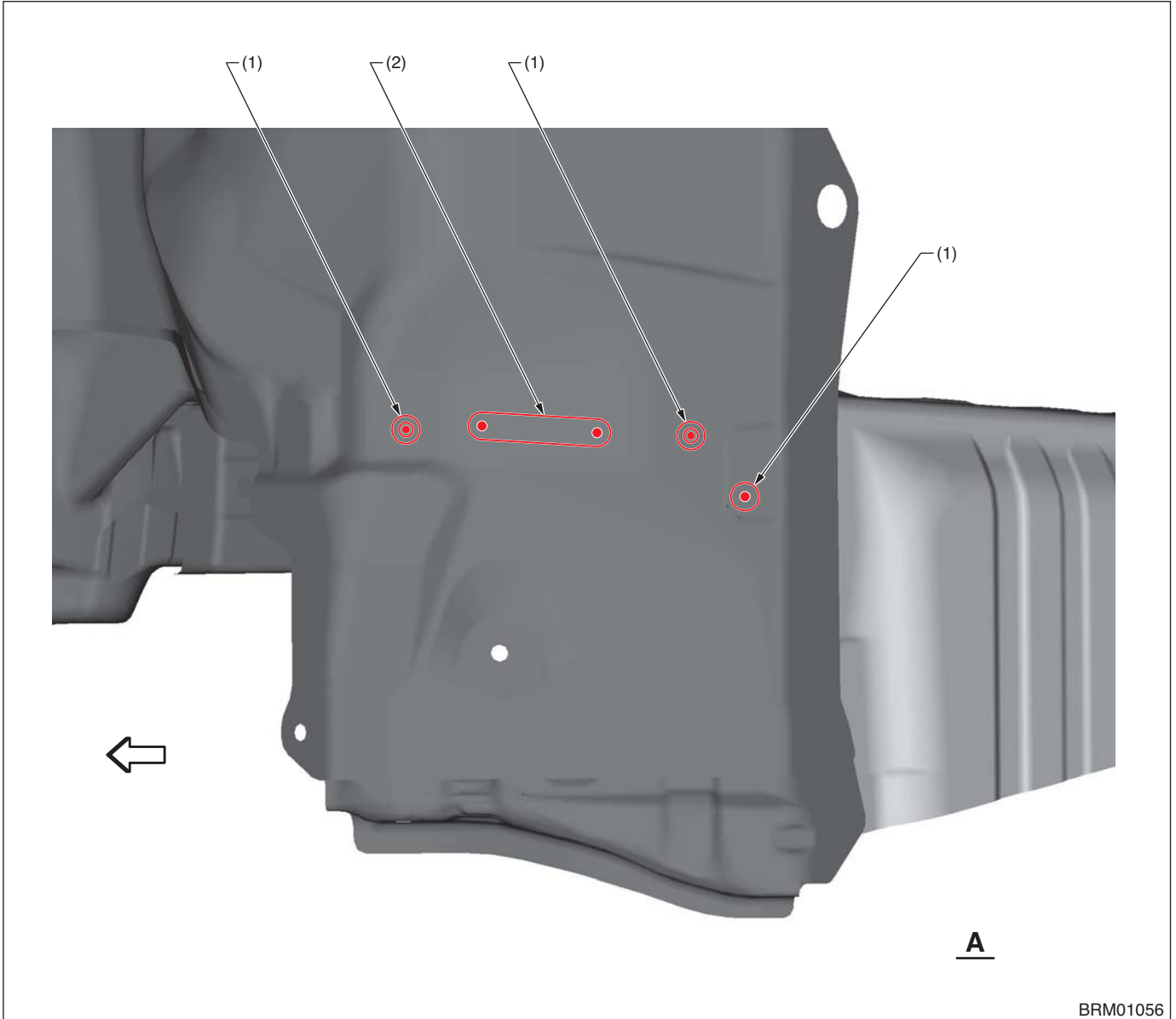
- (1) 1 point (top · 1)
- (2) 1 point (outside · 1)

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

- (5) 8 points (top · 1)

Panel Replacement

• View A



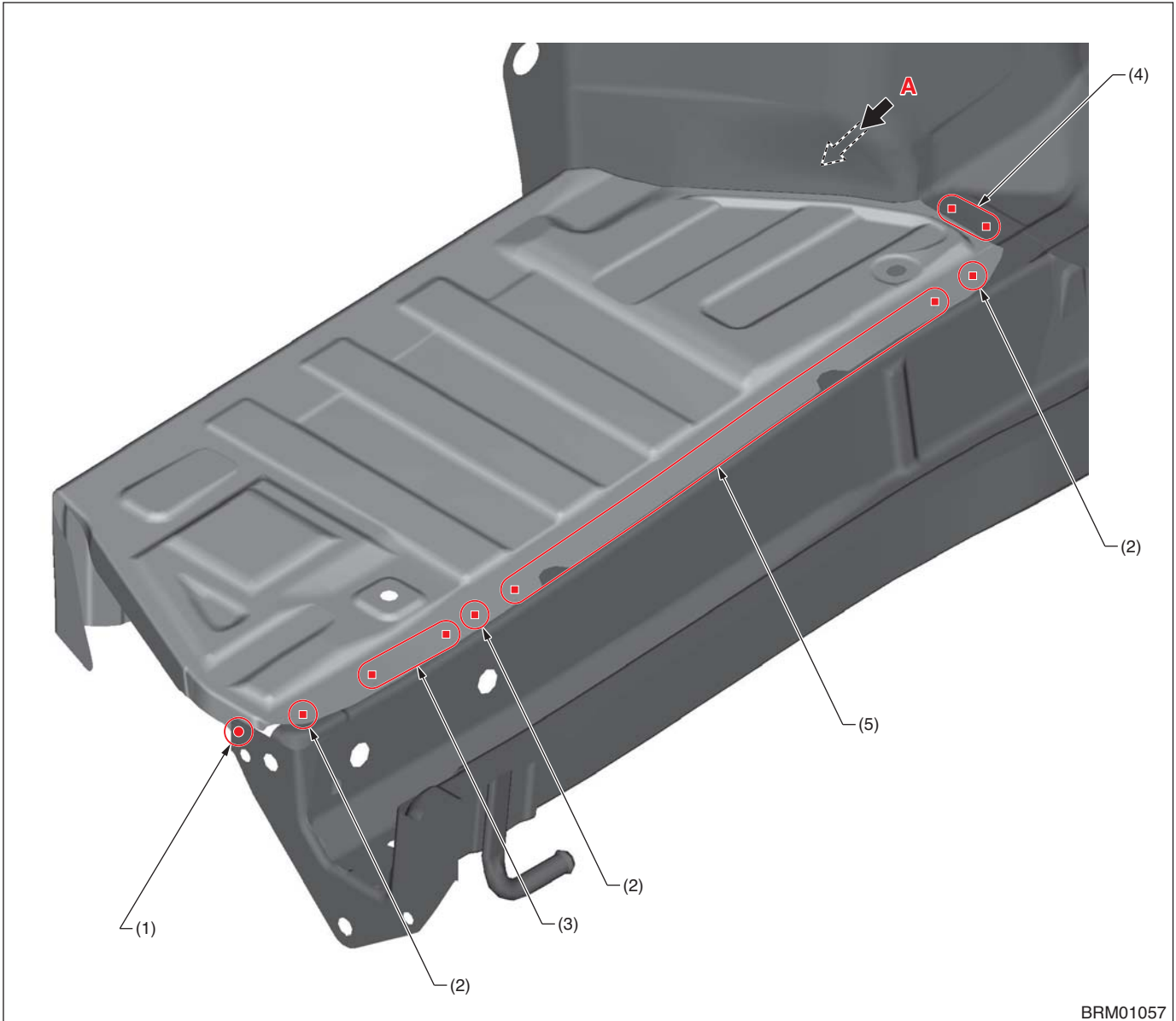
(1) 1 point (outside · 1)

(2) 2 points (outside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BRM01057

(1) 1 point

(2) 1 point (service)

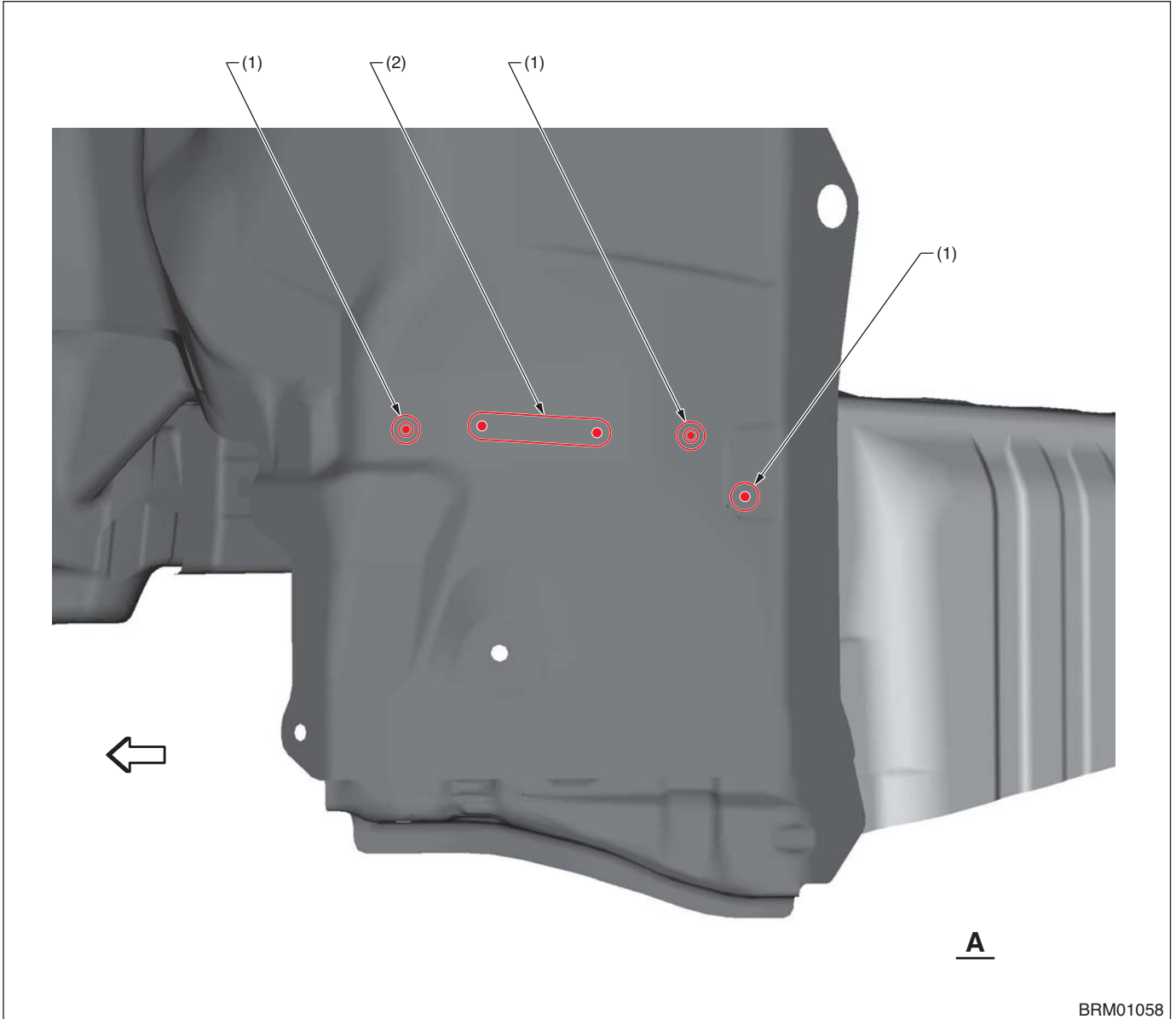
(3) 2 points (service)

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

(5) 8 points (service)

Panel Replacement

• View A



BRM01058

(1) 1 point

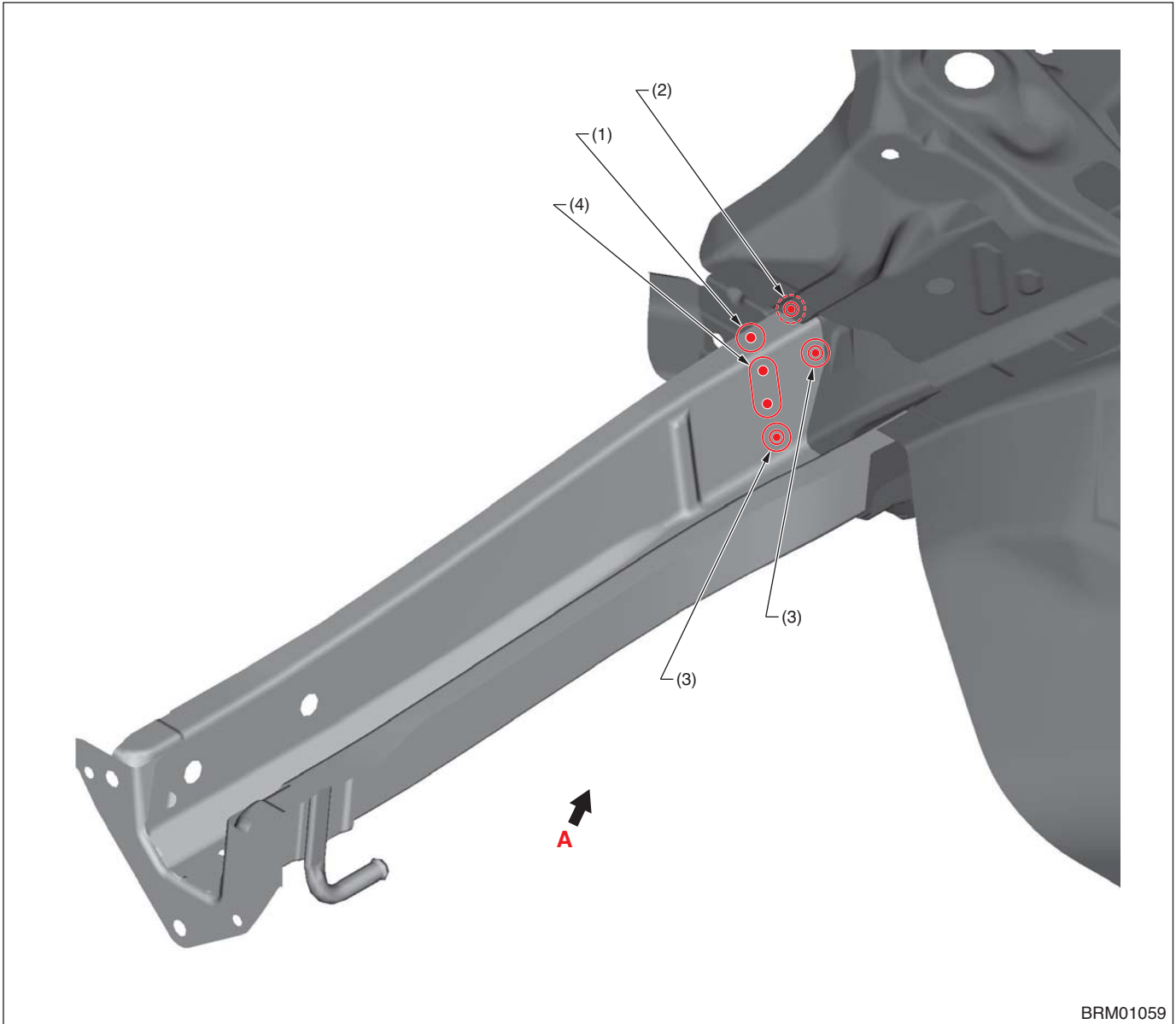
(2) 2 points

Panel Replacement

8-37. Rear Side Frame Lower Rear (Total replacement)

A: REMOVAL

• Overall view



BRM01059

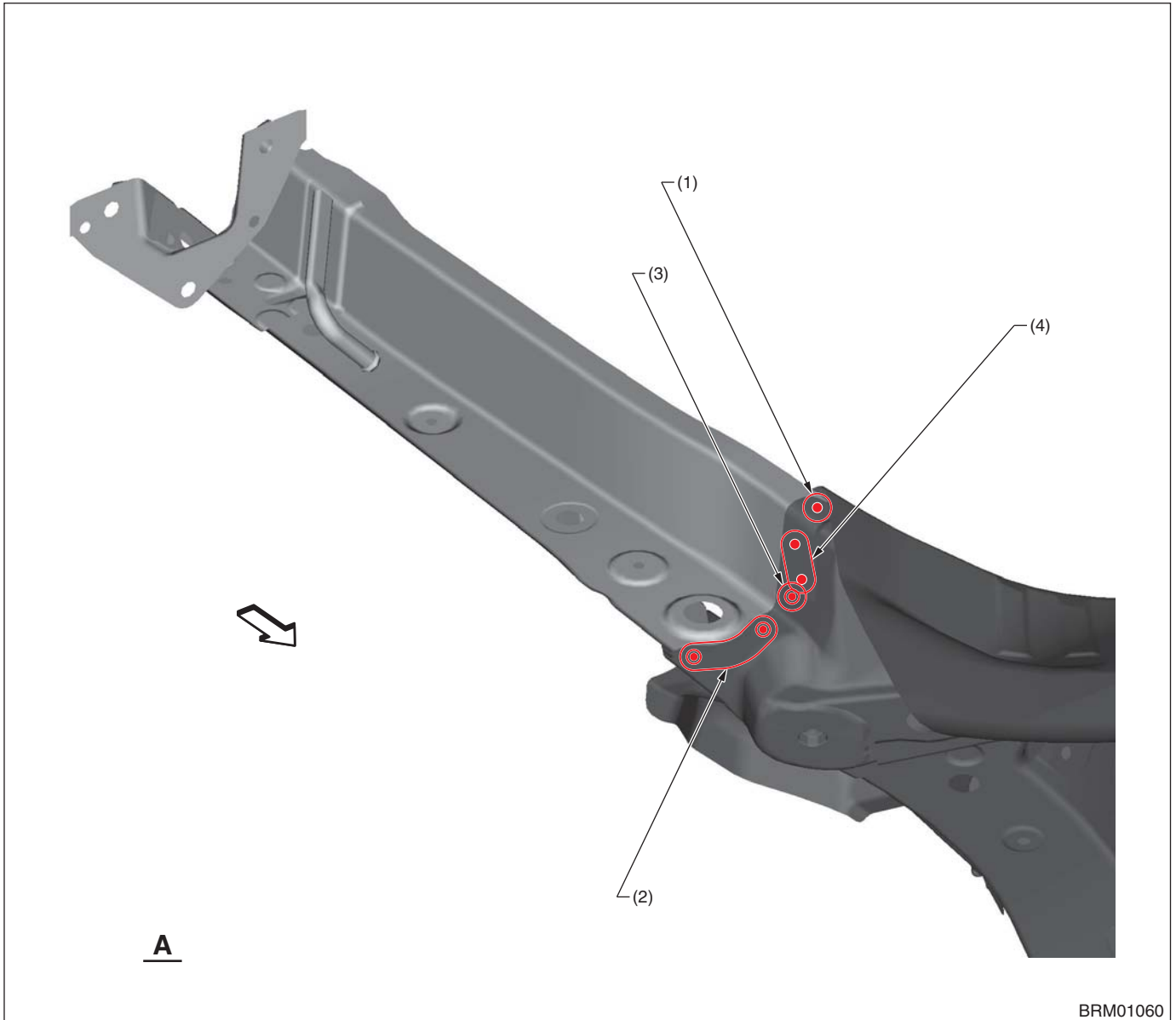
(1) 1 point (top · 1)
(2) 1 point (bottom · 2)

(3) 1 point (inside · 1 belt sander)

(4) 2 points (inside · 1 belt sander)

Panel Replacement

• View A



(1) 1 point (bottom · 1)

(2) 3 points (top · 1 belt sander)

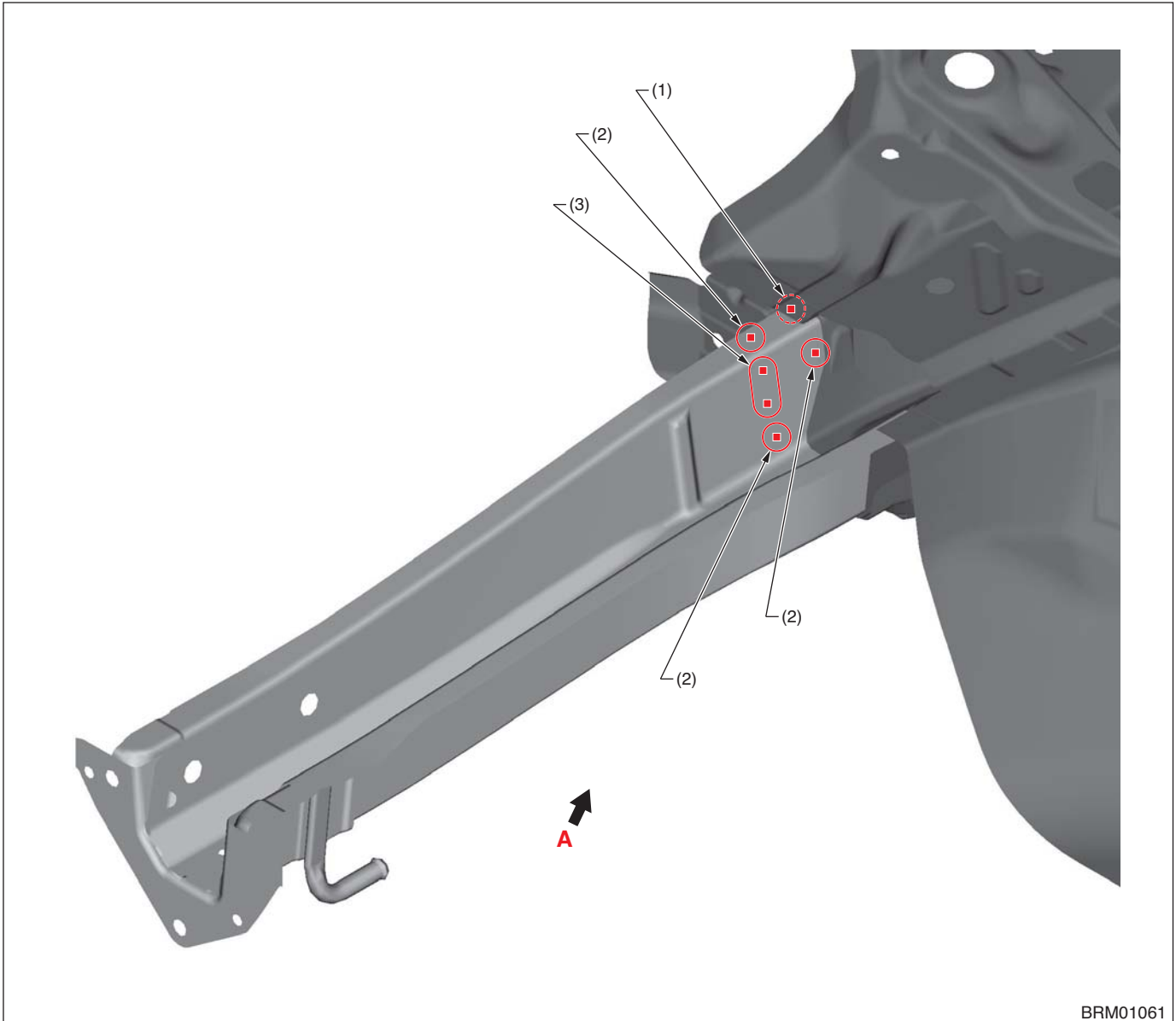
(3) 1 point (inside · 1 belt sander)

(4) 2 points (inside · 1 belt sander)

Panel Replacement

B: INSTALLATION

• Overall view



BRM01061

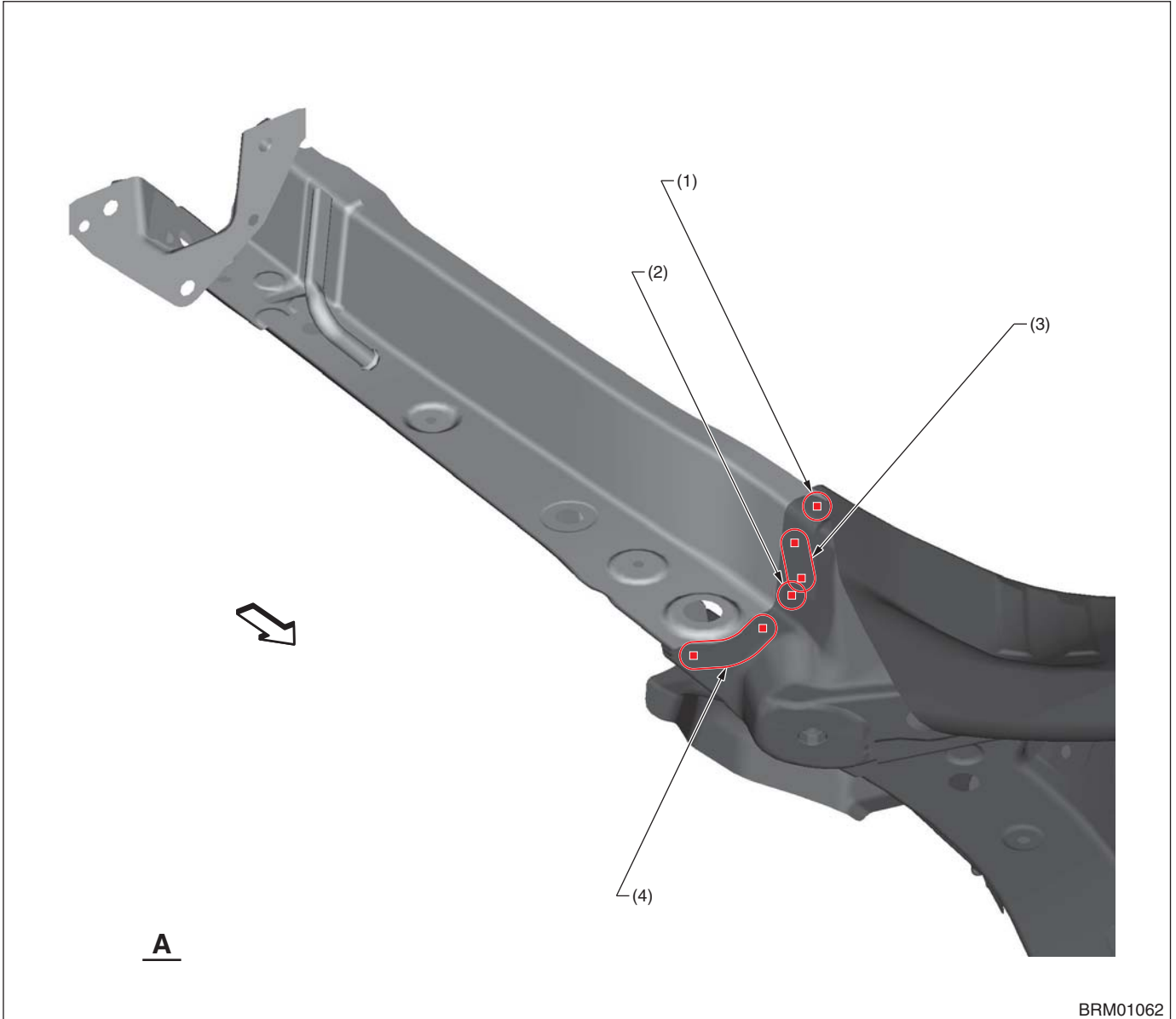
(1) 1 point

(2) 1 point (service)

(3) 2 points (service)

Panel Replacement

• View A



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

(3) 2 points (service)

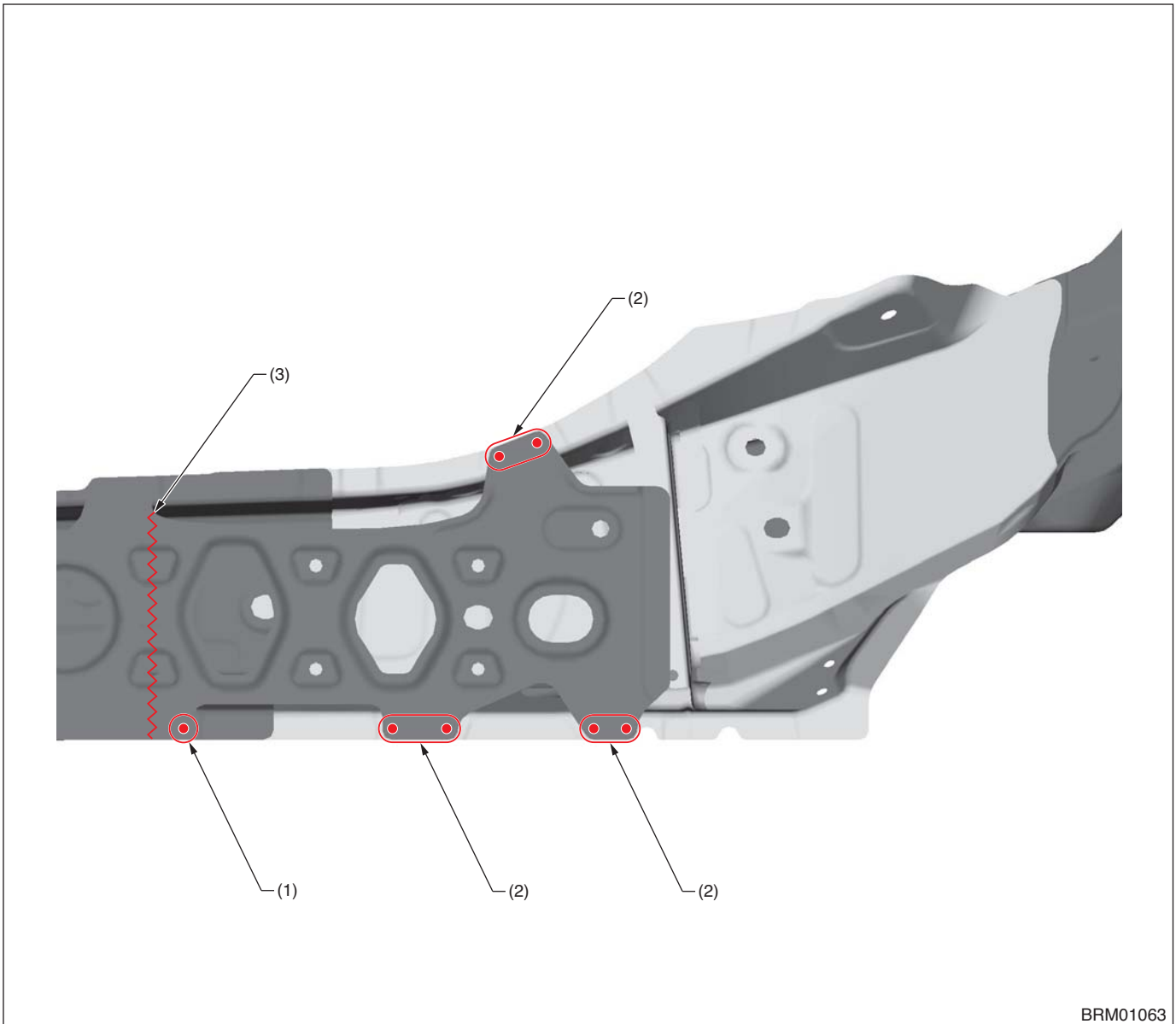
(4) 3 points (service)

Panel Replacement

8-38. Side Sill Inner Rear (Total replacement)

A: REMOVAL

• Overall view 1



BRM01063

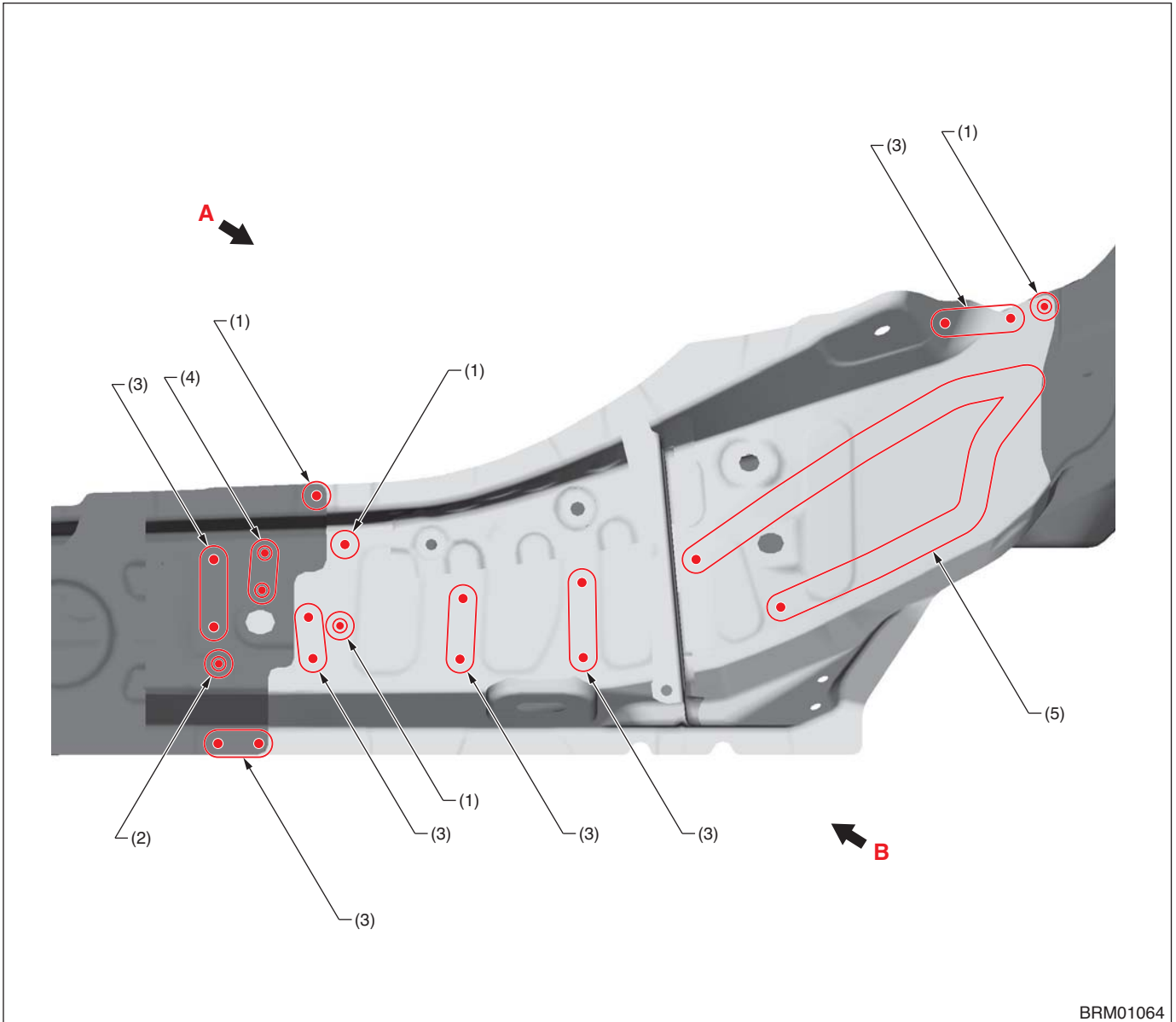
(1) 1 point (outside - 1)

(2) 2 points (outside - 1)

(3) Rough cutting

Panel Replacement

• Overall view 2



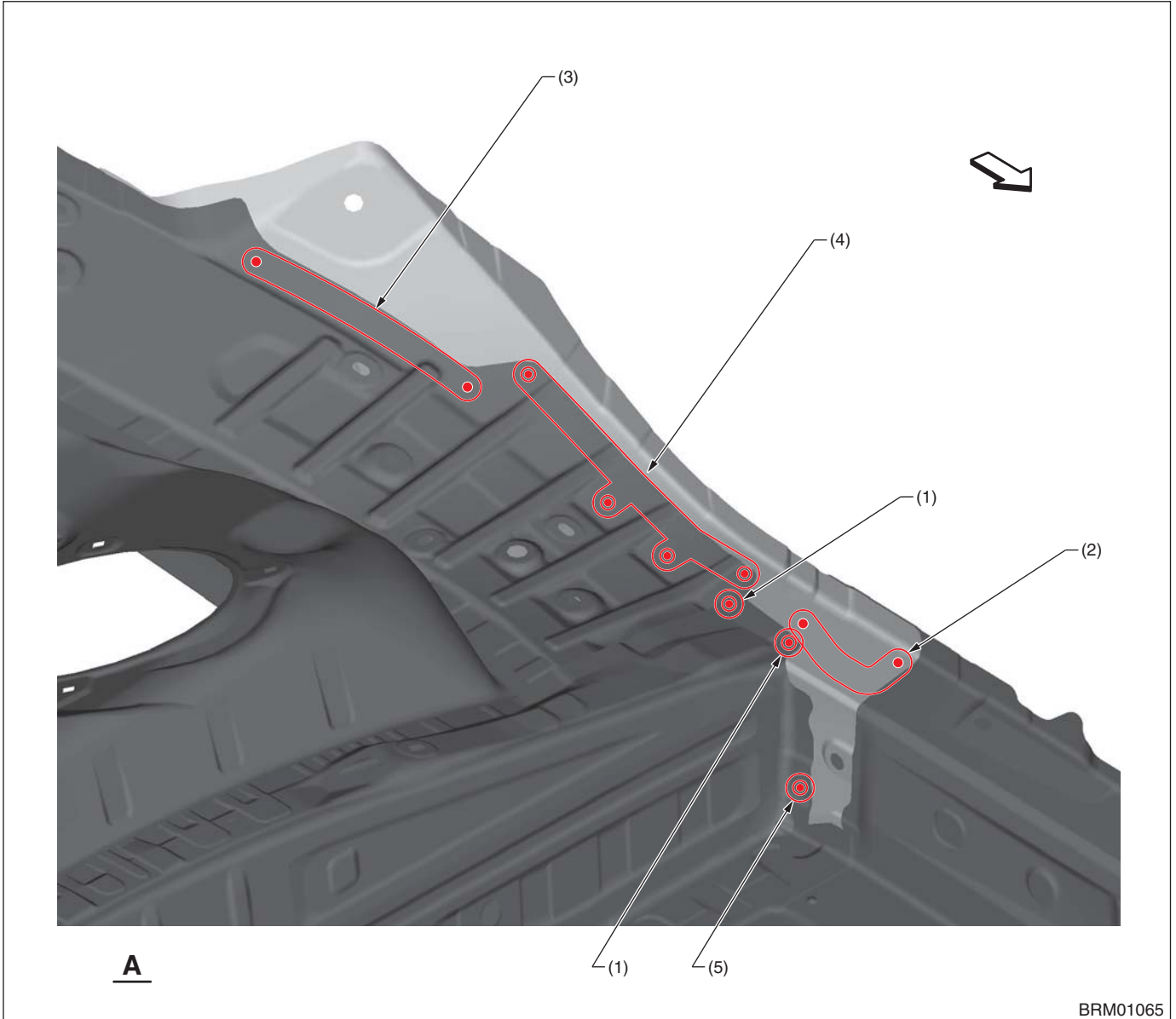
(1) 1 point (outside · 1)
(2) 1 point (outside · 2)

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

(5) 9 points (outside · 1)

Panel Replacement

• View A



BRM01065

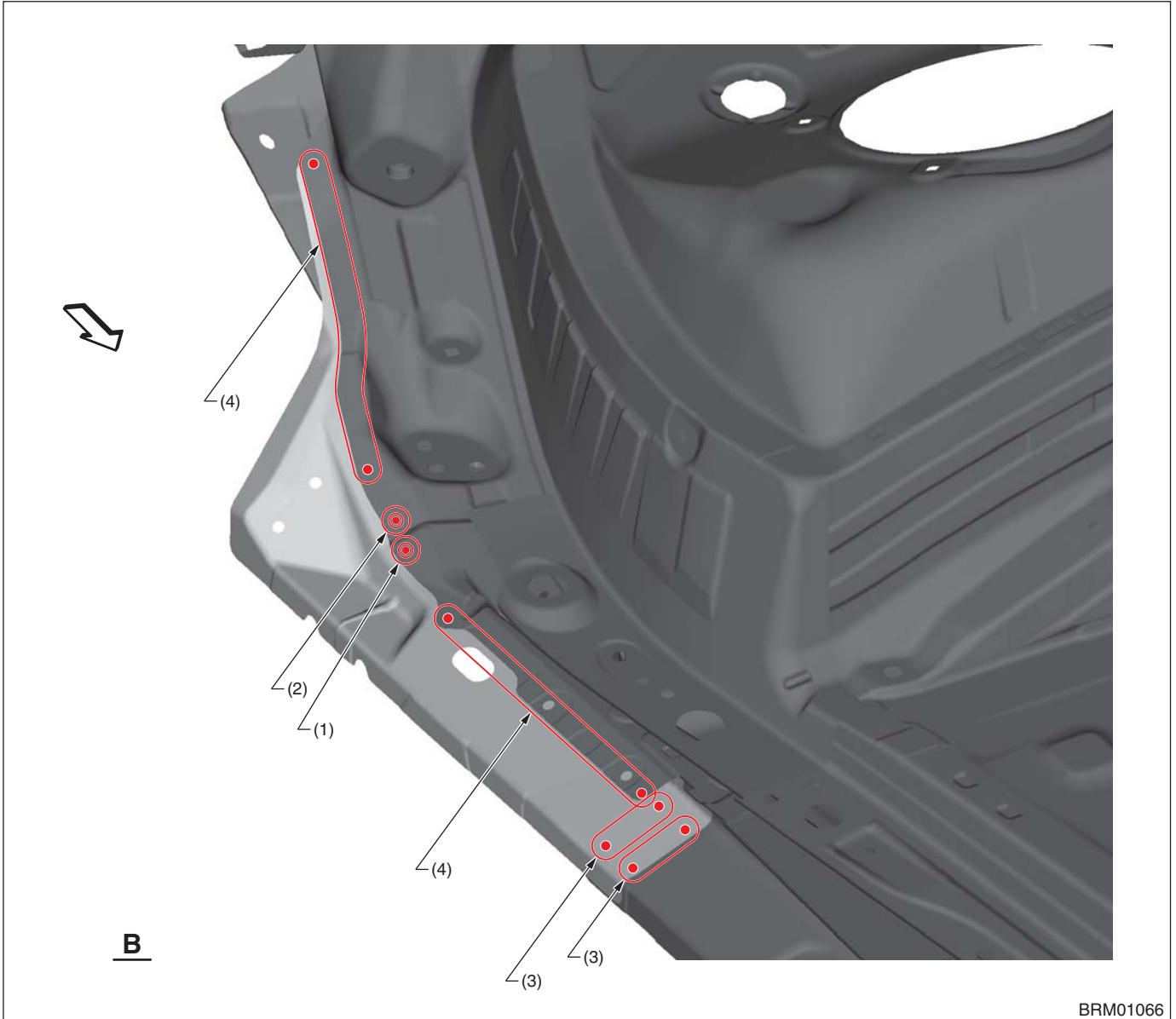
- (1) 1 point (top · 2)
- (2) 4 points (top · 1)

- (3) 5 points (top · 1)
- (4) 7 points (top · 1)

- (5) 1 point (inside · 2)

Panel Replacement

• View B



BRM01066

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

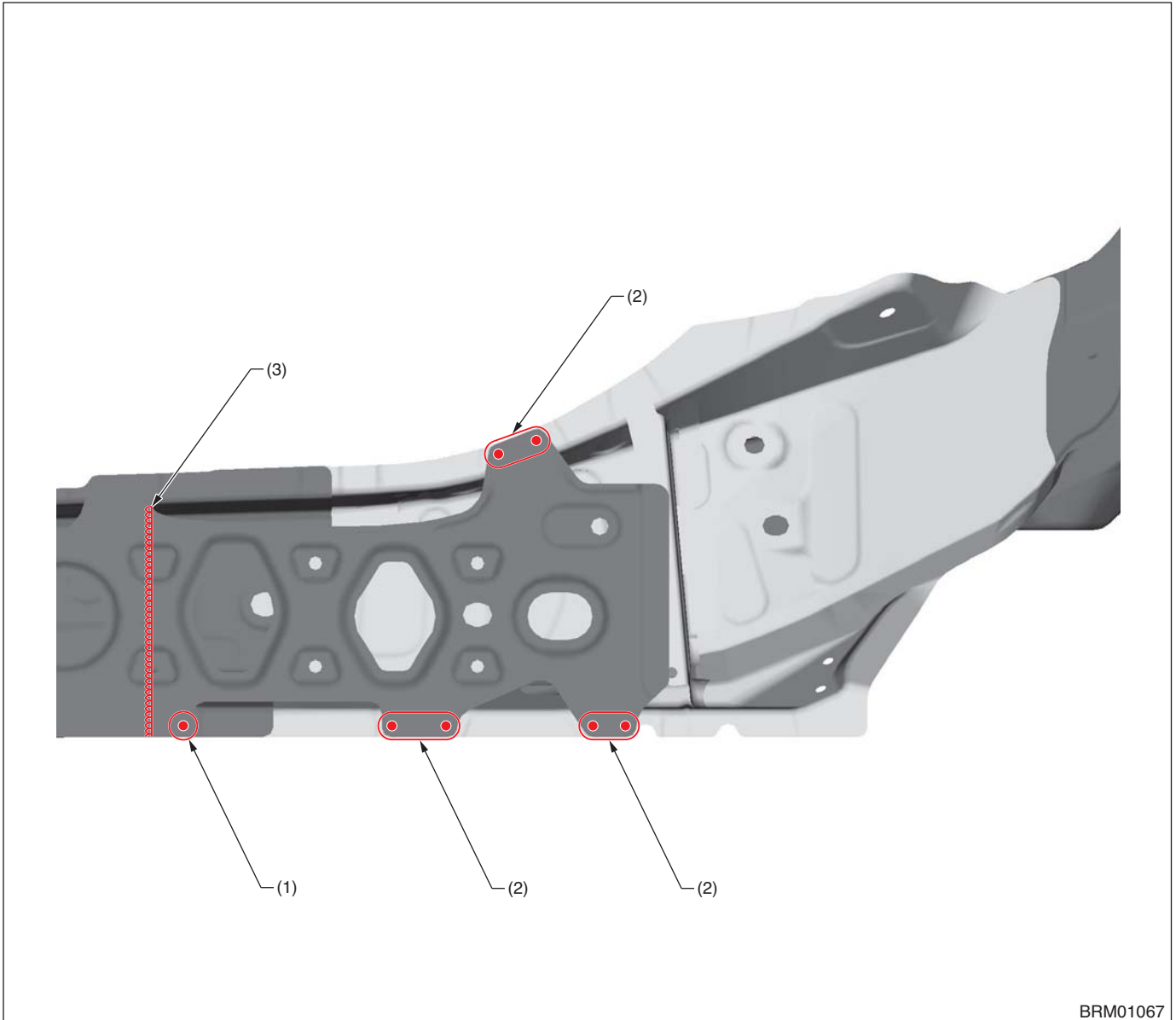
(3) 2 points (bottom · 1)

(4) 5 points (bottom · 1)

Panel Replacement

B: INSTALLATION

• Overall view 1



BRM01067

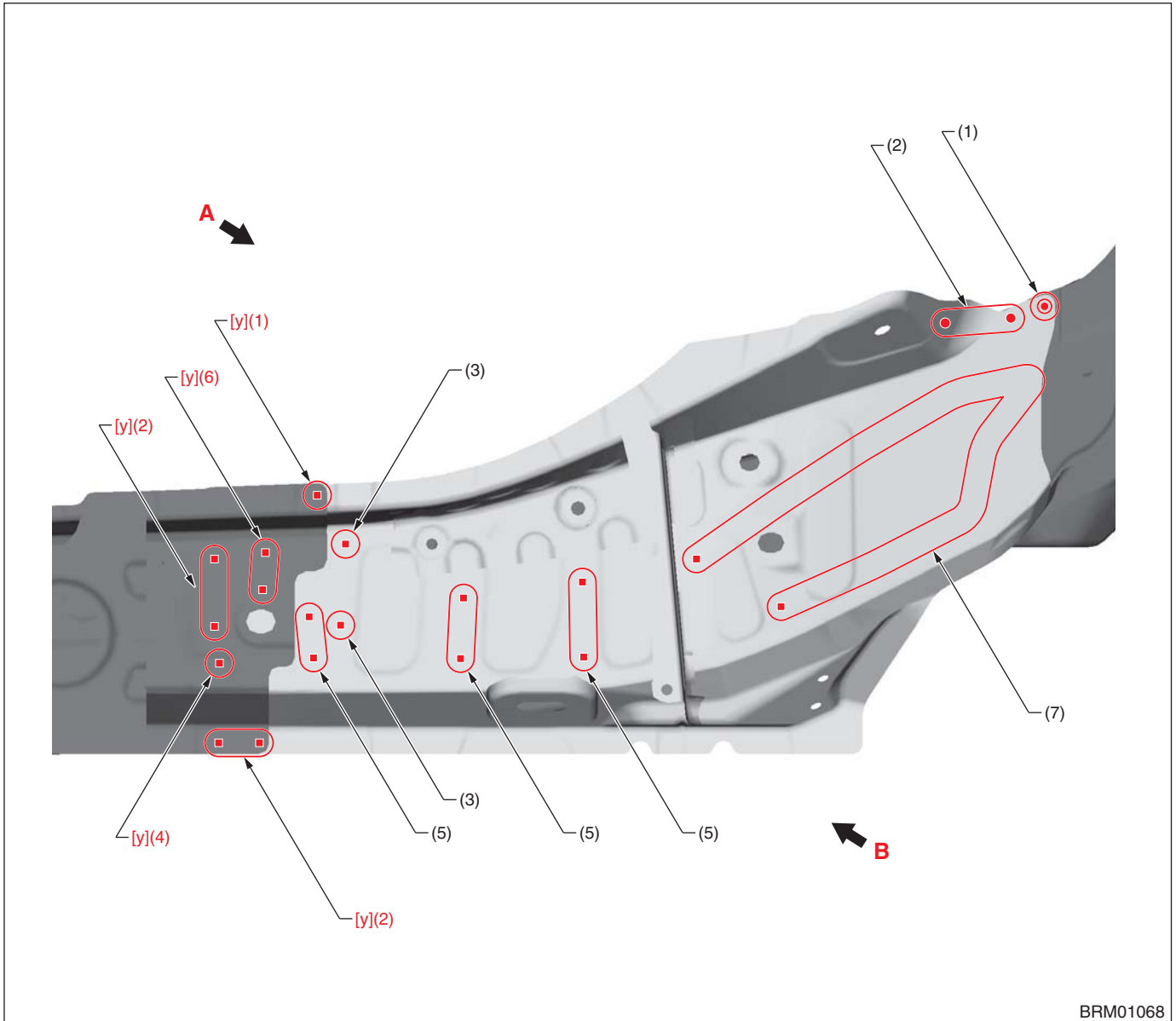
(1) 1 point

(2) 2 points

(3) 1 point (Continuous welding)

Panel Replacement

• Overall view 2



BRM01068

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

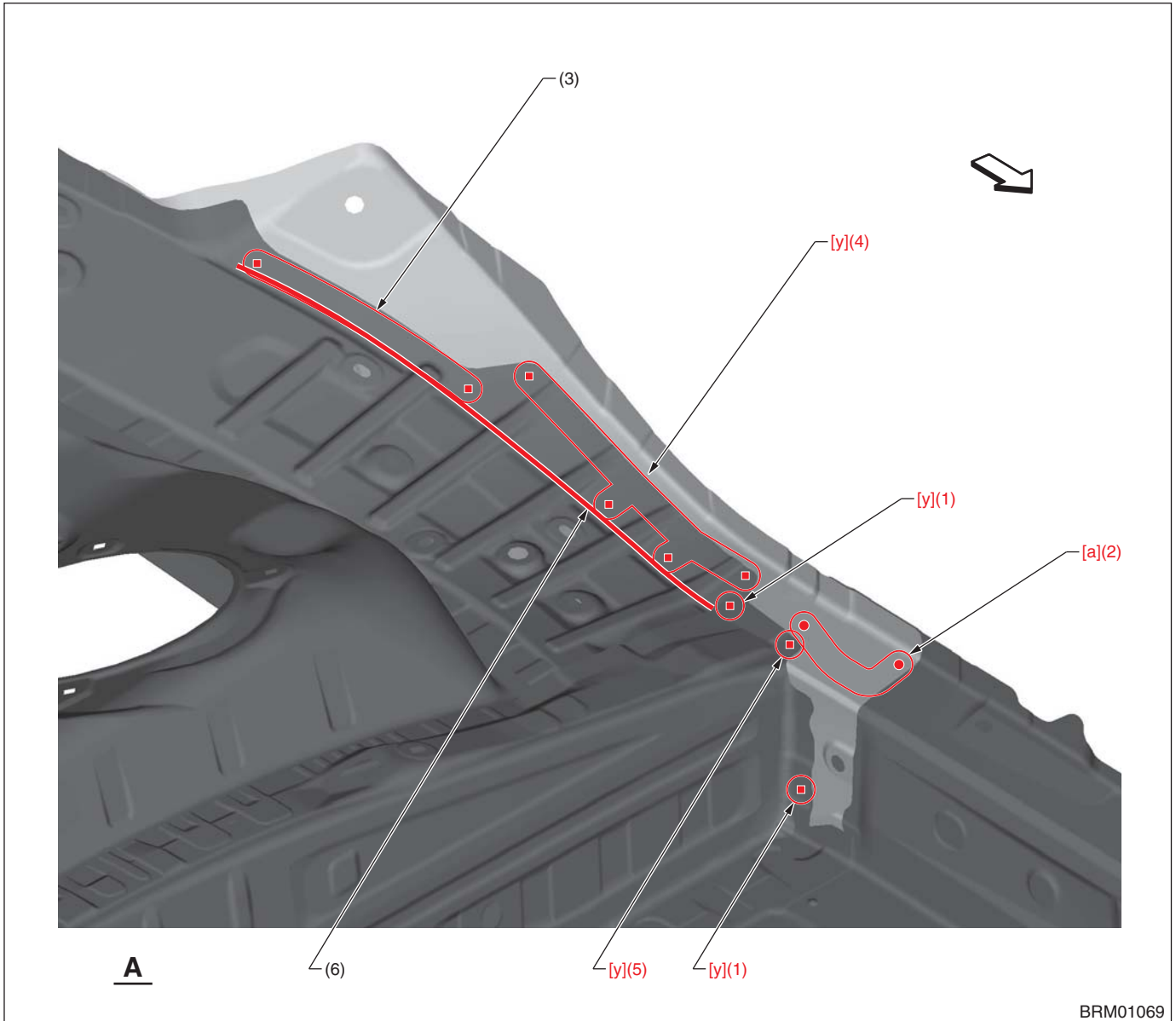
[y] Plug welding

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

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

Panel Replacement

• View A



BRM01069

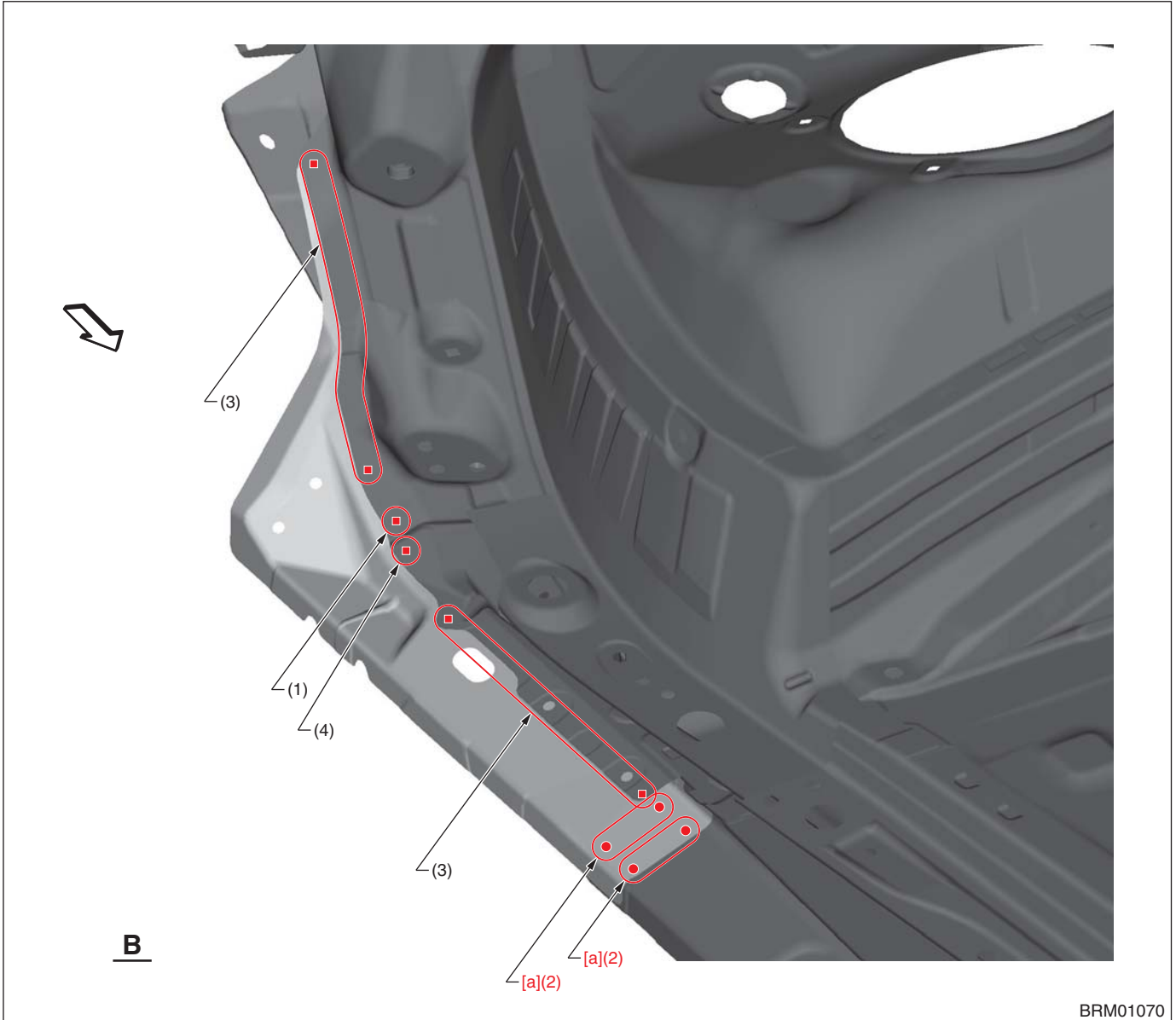
- | | | |
|--------------|-----------------------------------|----------------------------------|
| (1) 1 point | (3) 5 points | (5) 1 point (service · matching) |
| (2) 4 points | (4) 7 points (service · matching) | (6) Structural adhesive |

— : Structural adhesive application location (Panel bond mini 38315 made by 3M or equivalent)

[a] Spot welding	Compression: 3.5 kN, Current: 7.5 kA, Welding time: 16 cyc
[y] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO ₂ B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO ₂ : 20 %)

Panel Replacement

• View B



(1) 1 point
(2) 2 points

(3) 5 points

(4) 1 point (service · matching)

[a] Spot welding

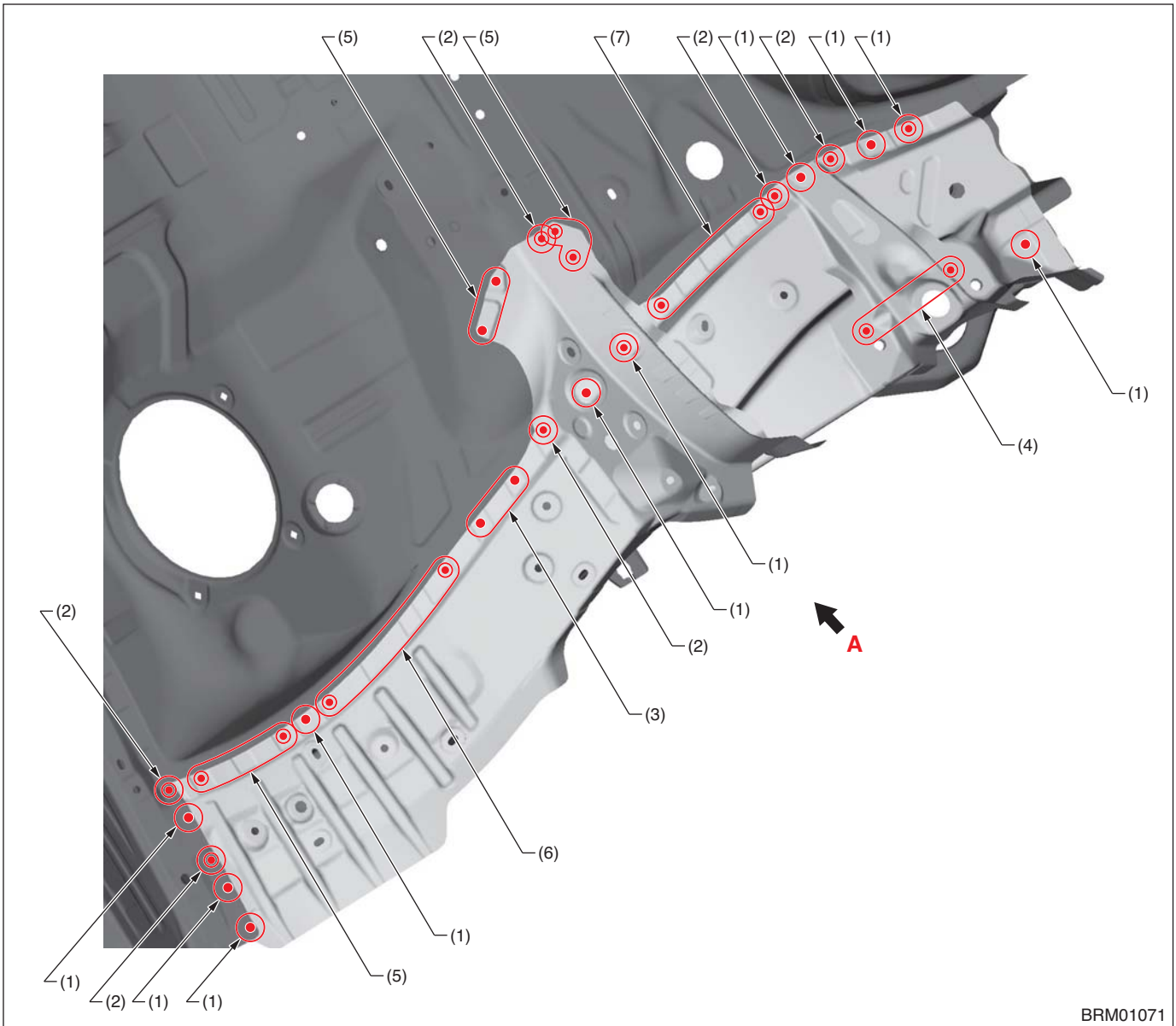
Compression: 3.5 kN, Current: 7.5 kA, Welding time: 16 cyc

Panel Replacement

8-39. Rear Side Frame Upper (Total replacement)

A: REMOVAL

• Overall view



BRM01071

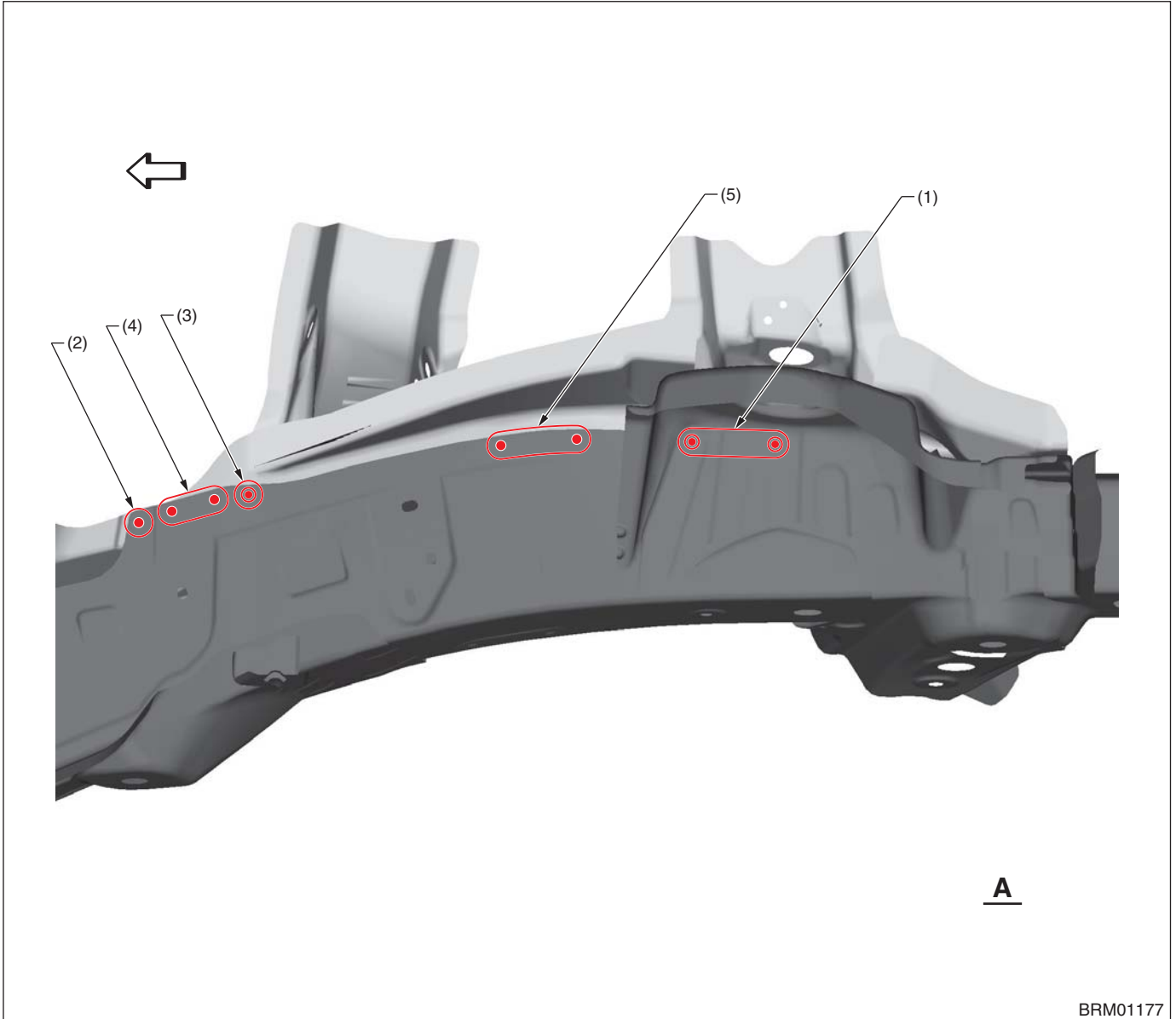
- (1) 1 point (top · 1)
- (2) 1 point (top · 2)
- (3) 2 points (top · 1)

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

- (7) 5 points (top · 1)

Panel Replacement

• View A



BRM01177

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

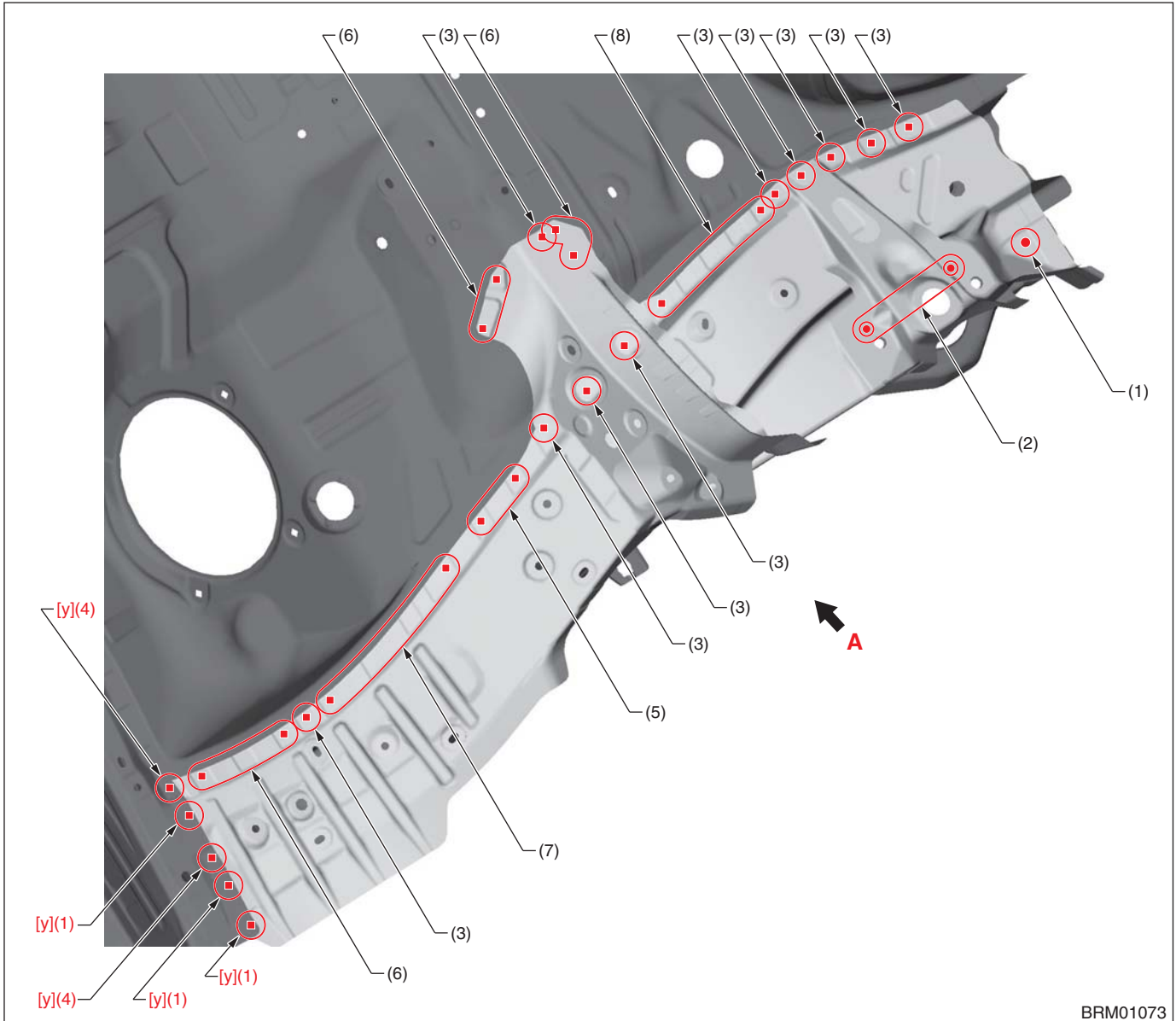
(3) 1 point (inside · 2)
(4) 2 points (inside · 1)

(5) 3 points (inside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



BRM01073

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

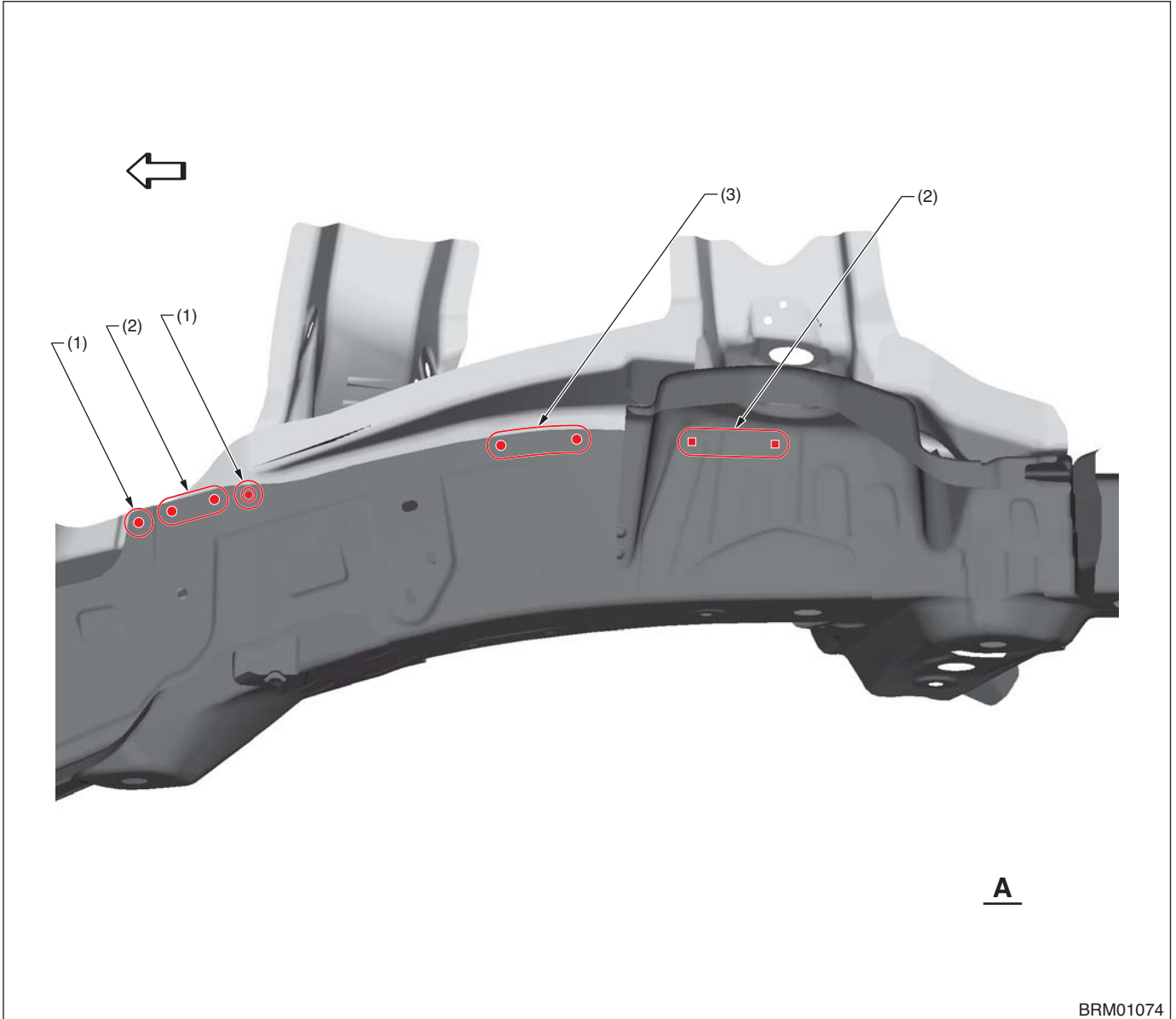
[y] Plug welding

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

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

Panel Replacement

• View A



BRM01074

(1) 1 point

(2) 2 points

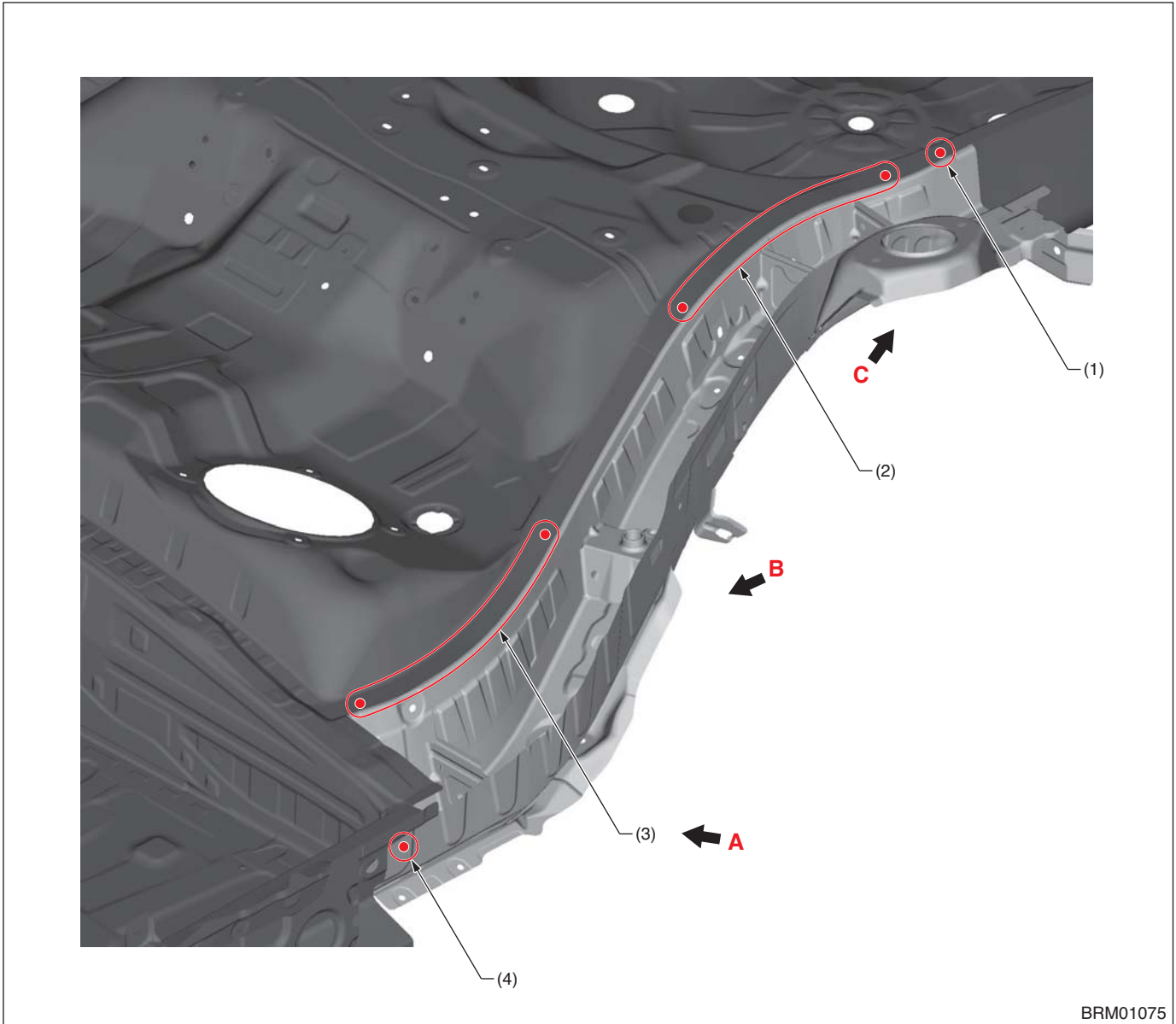
(3) 3 points

Panel Replacement

8-40. Rear Side Frame (Total replacement)

A: REMOVAL

- Overall view



BRM01075

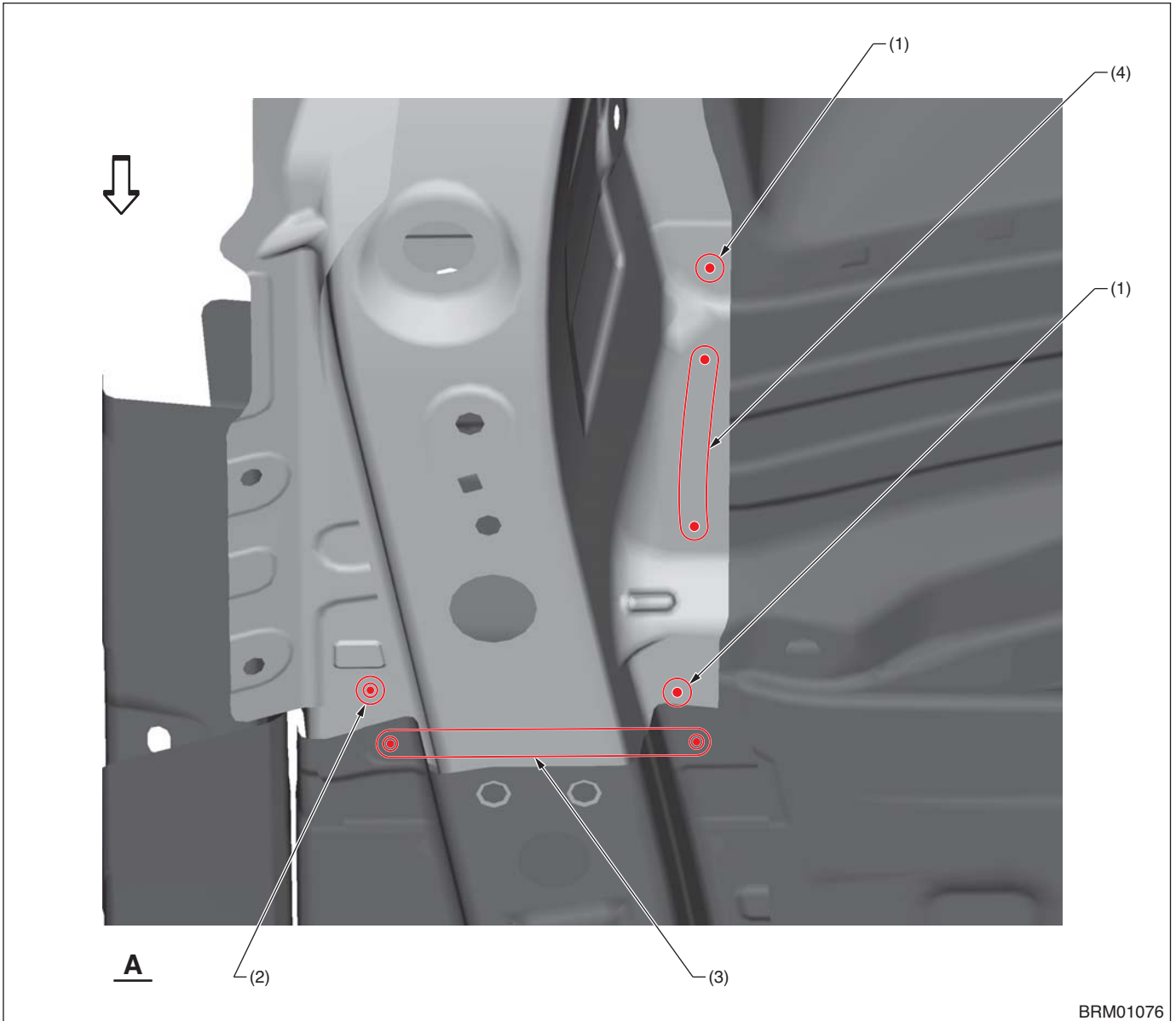
- (1) 1 point (top · 1)
- (2) 6 points (top · 1)

- (3) 7 points (top · 1)

- (4) 1 point (outside · 1)

Panel Replacement

• View A



BRM01076

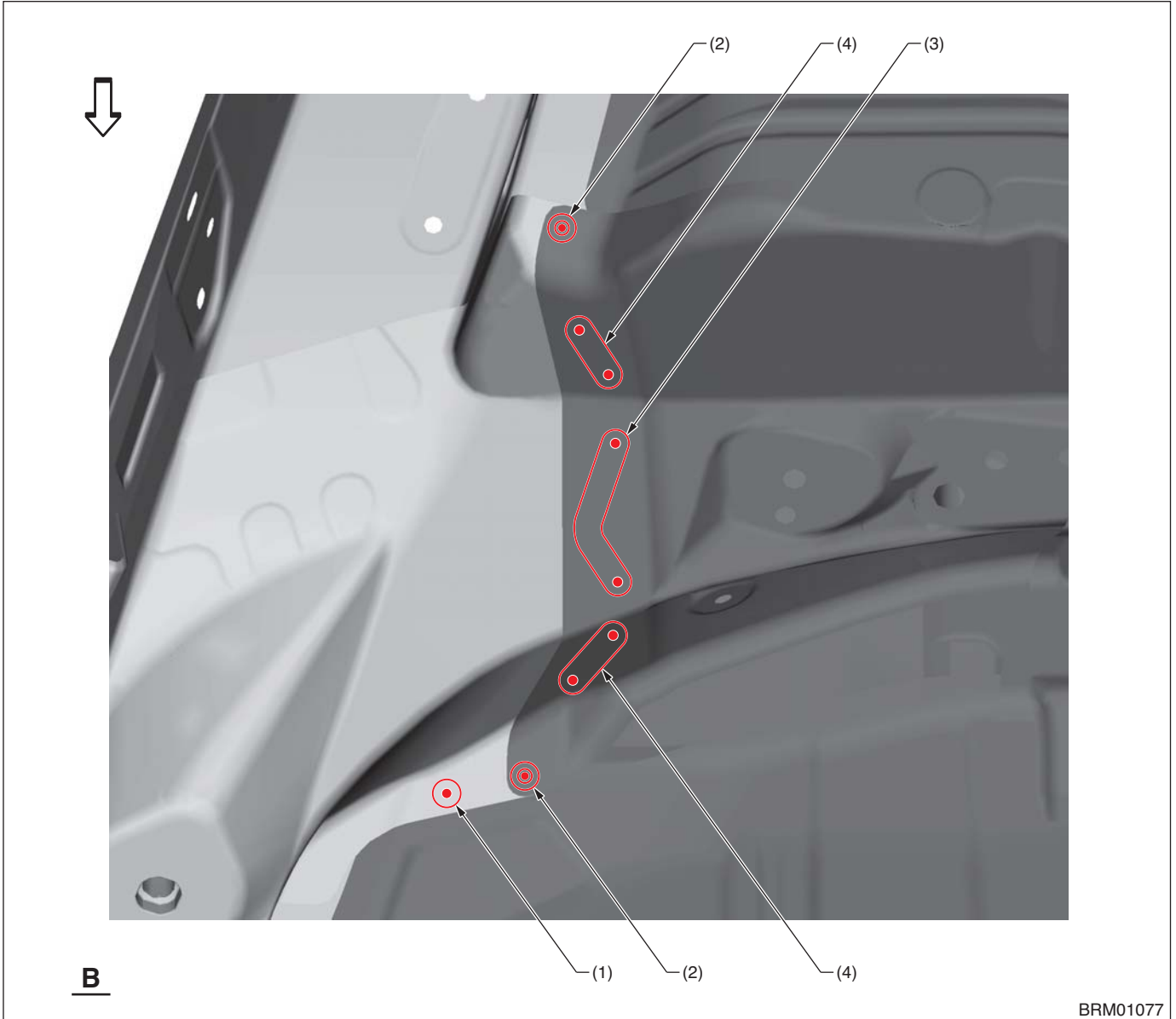
- (1) 1 point (bottom · 1)
- (2) 1 point (bottom · 2)

- (3) 2 points (bottom · 2)

- (4) 3 points (outside · 1)

Panel Replacement

• View B



BRM01077

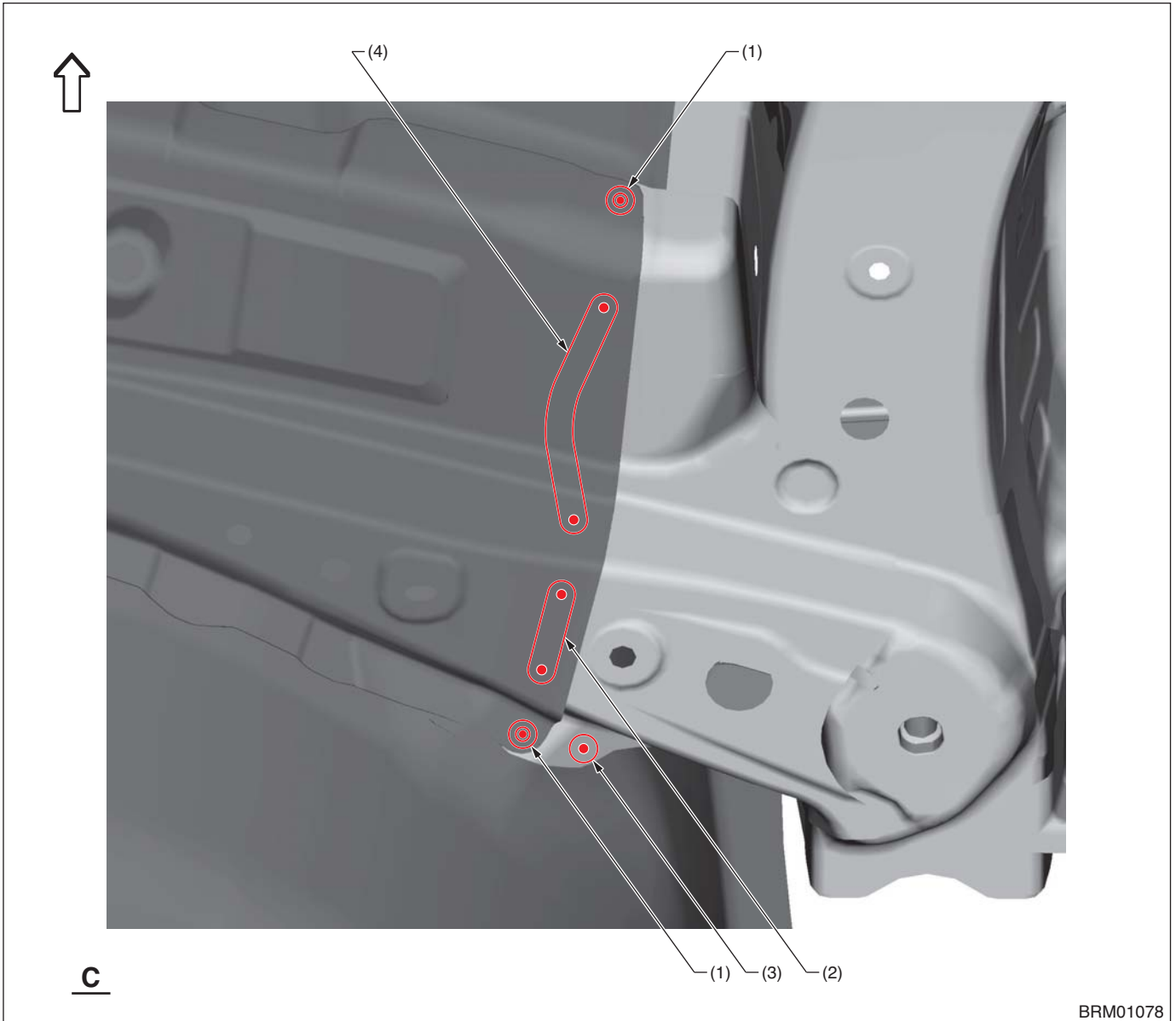
(1) 1 point (bottom · 1)
(2) 1 point (bottom · 2)

(3) 3 points (bottom · 1)

(4) 2 points (outside · 1)

Panel Replacement

• View C



BRM01078

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

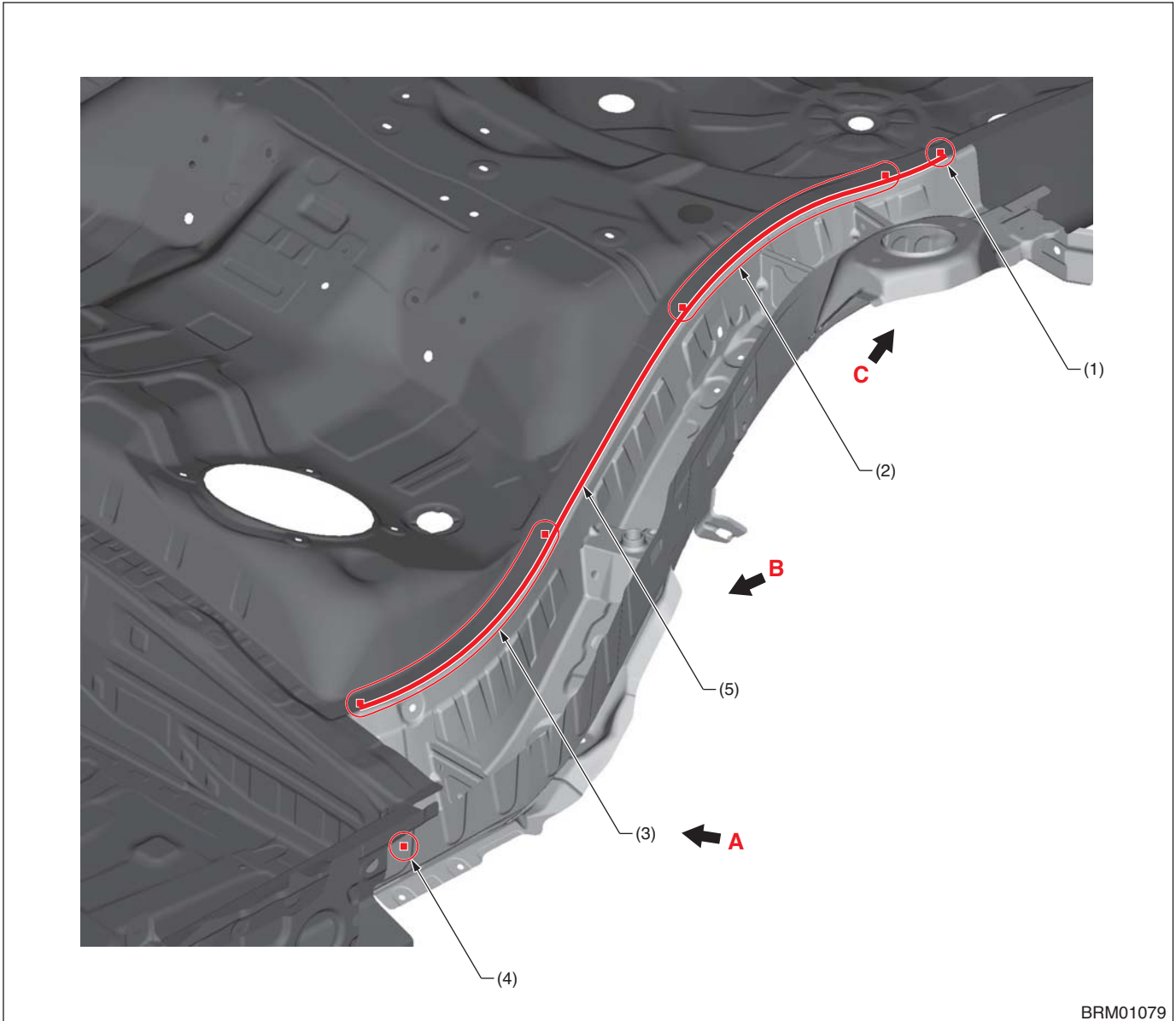
(3) 1 point (outside · 1)

(4) 3 points (outside · 1)

Panel Replacement

B: INSTALLATION

• Overall view



(1) 1 point
(2) 6 points

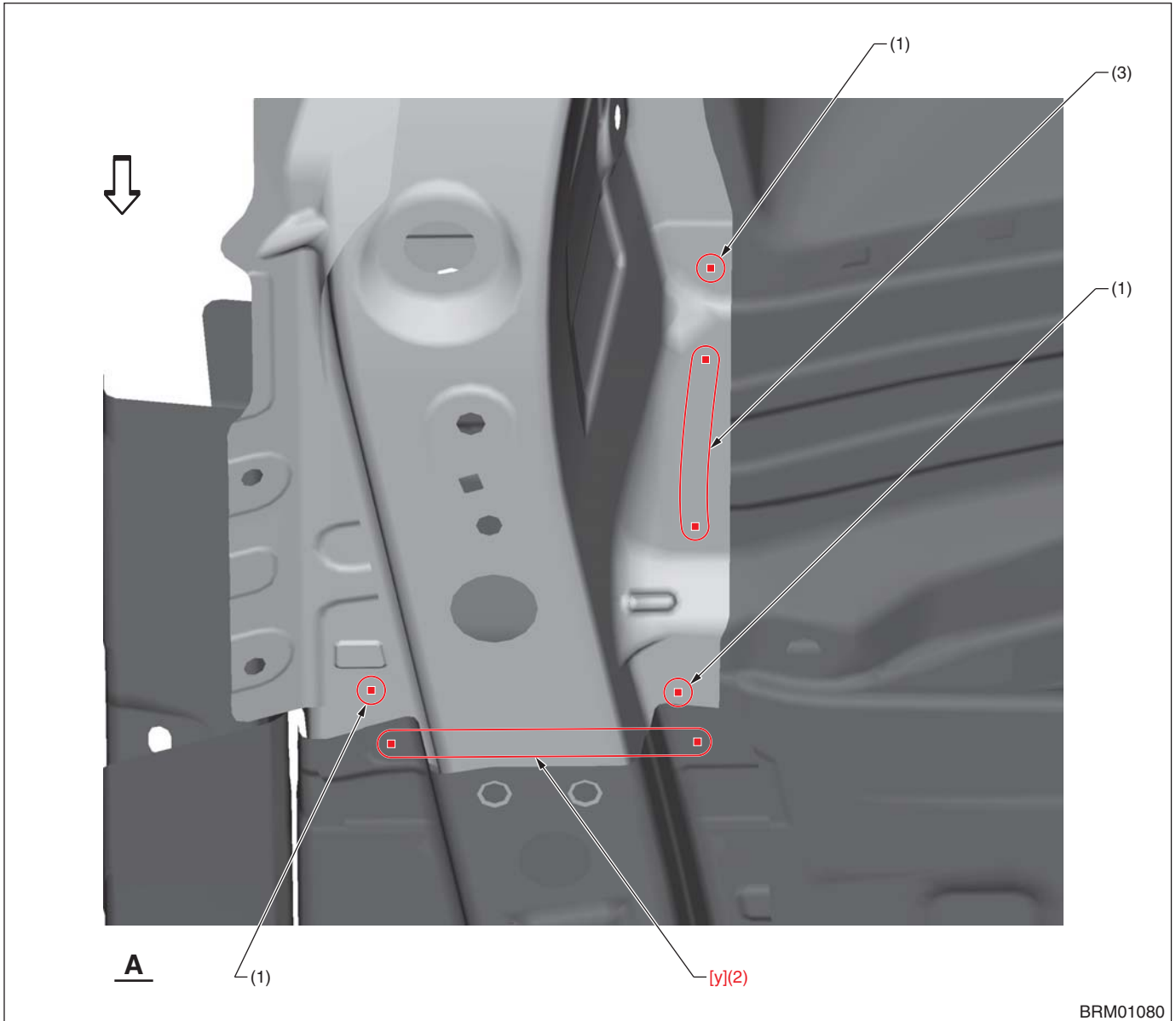
(3) 7 points
(4) 1 point (service)

(5) Structural adhesive

— : Structural adhesive application location (Panel bond mini 38315 made by 3M or equivalent)

Panel Replacement

• View A



(1) 1 point (service)

(2) 2 points (service · matching)

(3) 3 points (service)

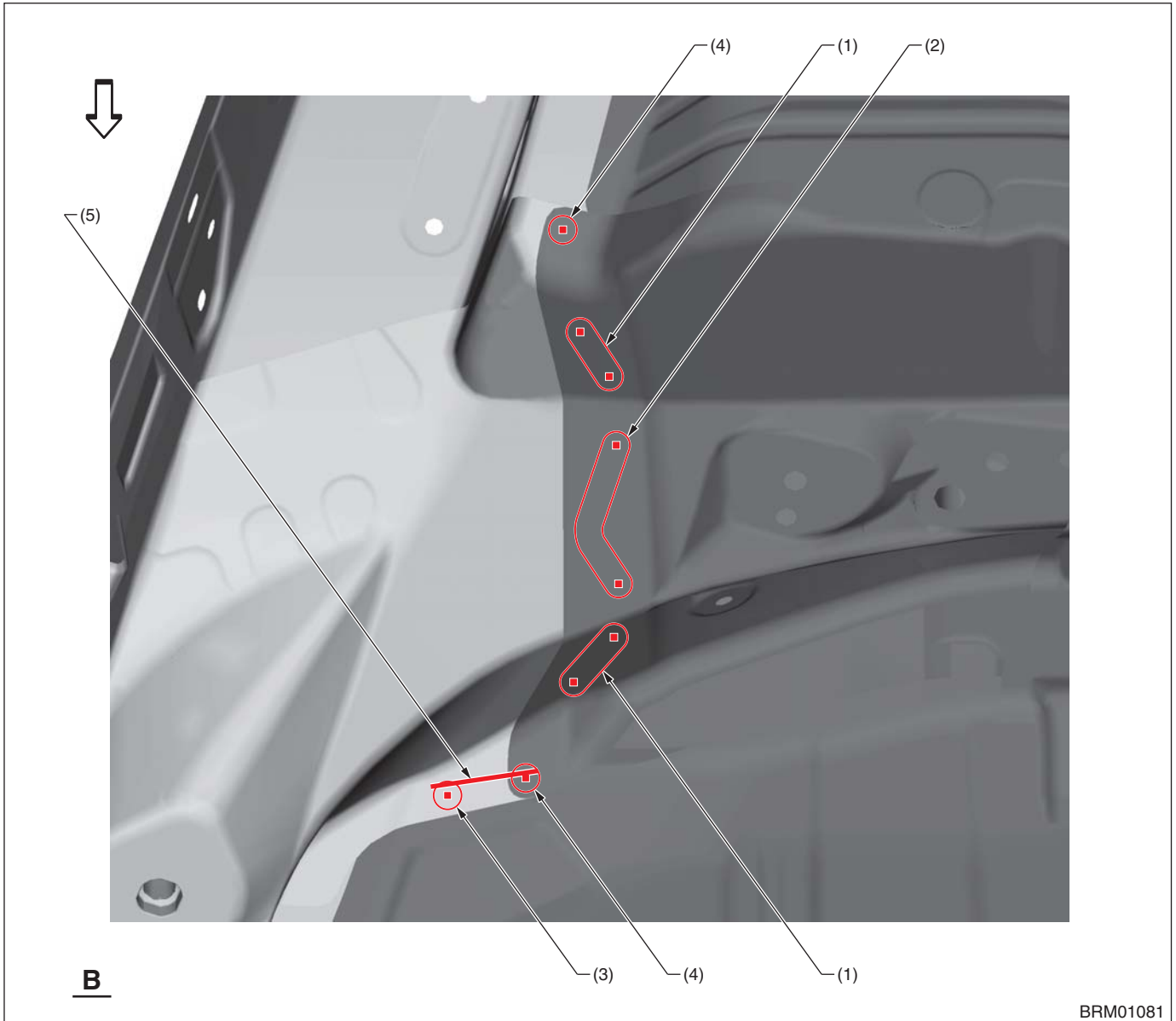
[y] Plug welding

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

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

Panel Replacement

• View B



(1) 2 points
(2) 3 points

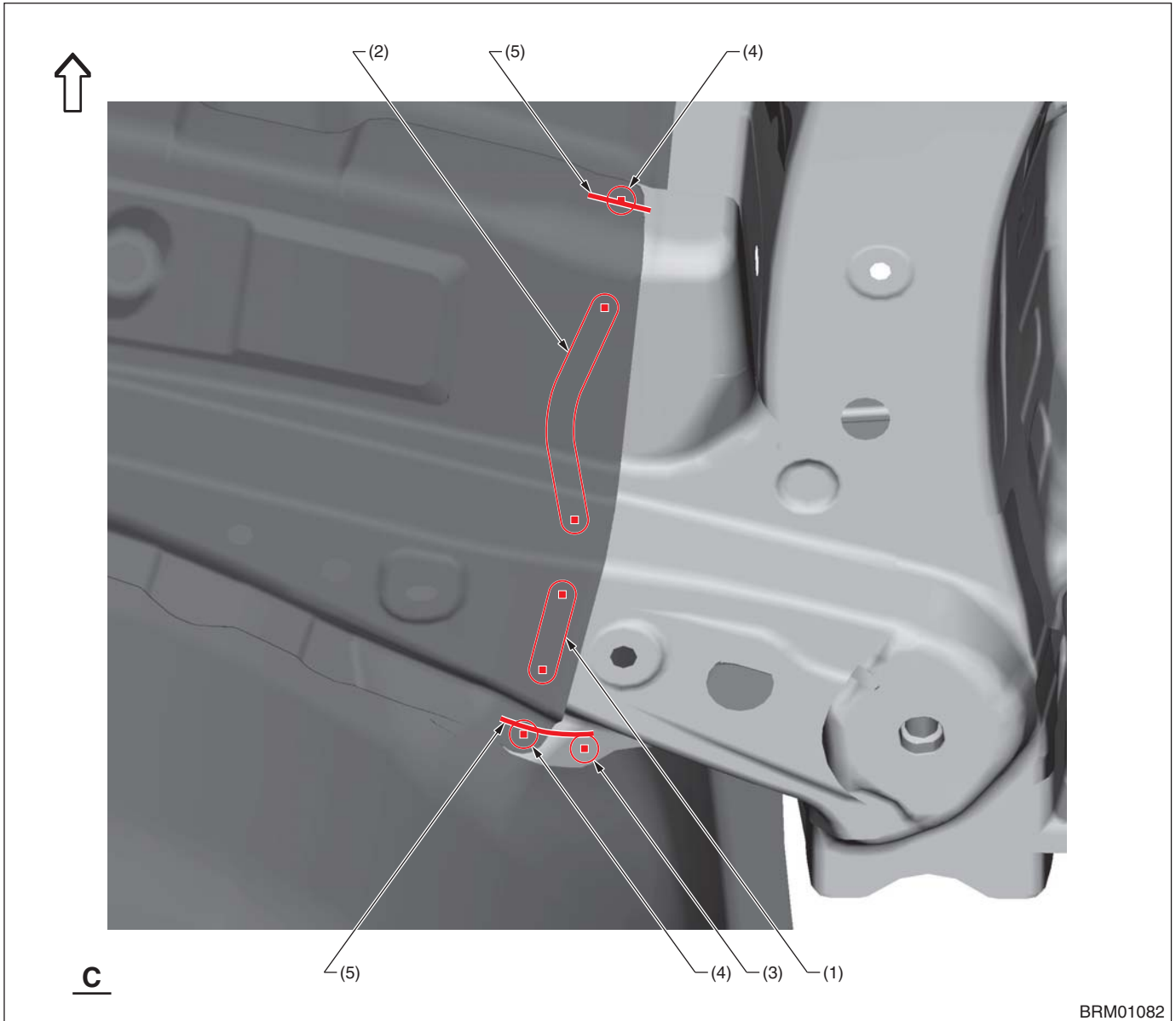
(3) 1 point (service)
(4) 1 point (service · matching)

(5) Structural adhesive

— : Structural adhesive application location (Panel bond mini 38315 made by 3M or equivalent)

Panel Replacement

• View C



(1) 2 points
(2) 3 points

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

(5) Structural adhesive

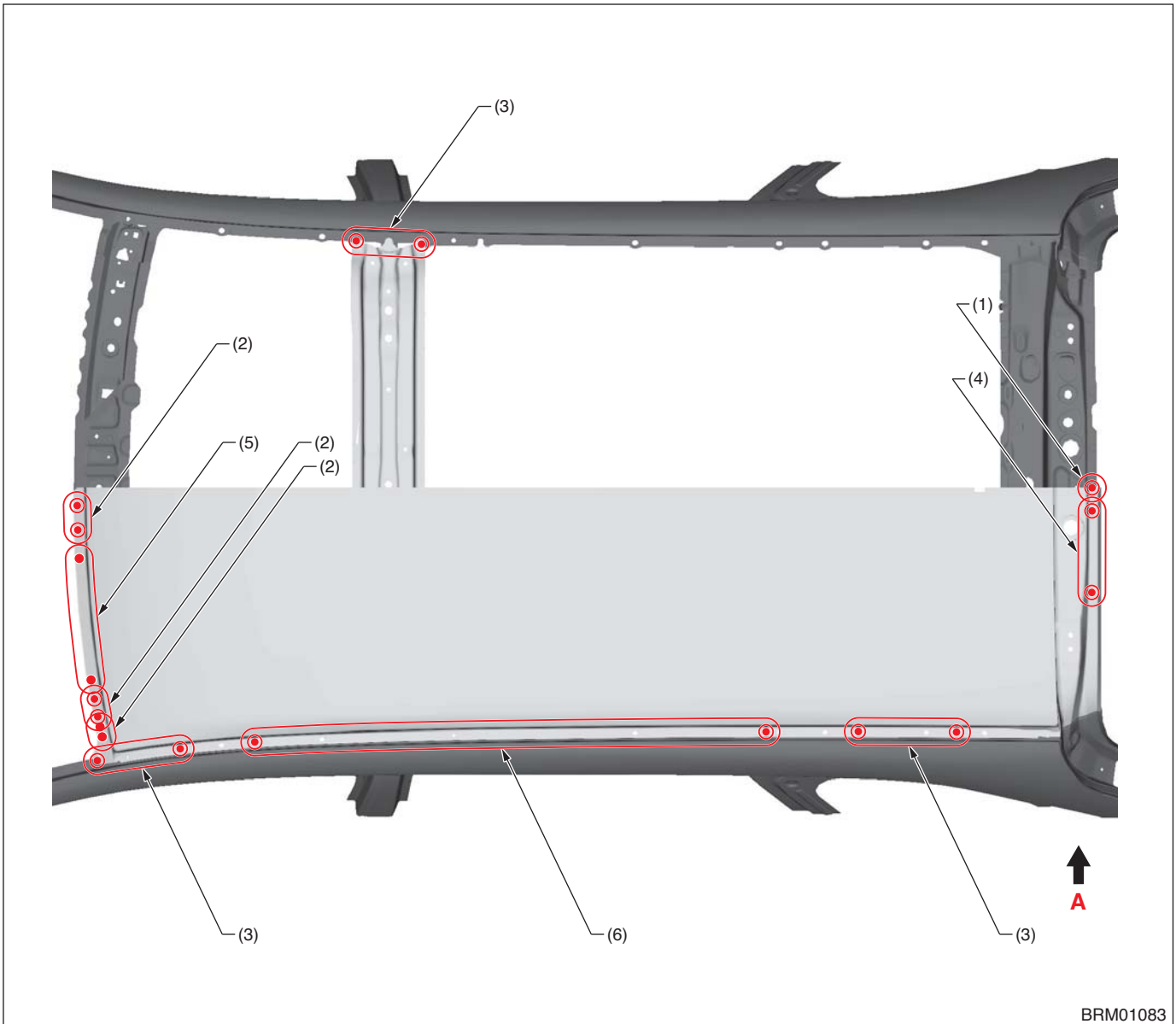
— : Structural adhesive application location (Panel bond mini 38315 made by 3M or equivalent)

Panel Replacement

8-41. Roof Panel (Total replacement) OUTBACK

A: REMOVAL

• Overall view (Model without sunroof)



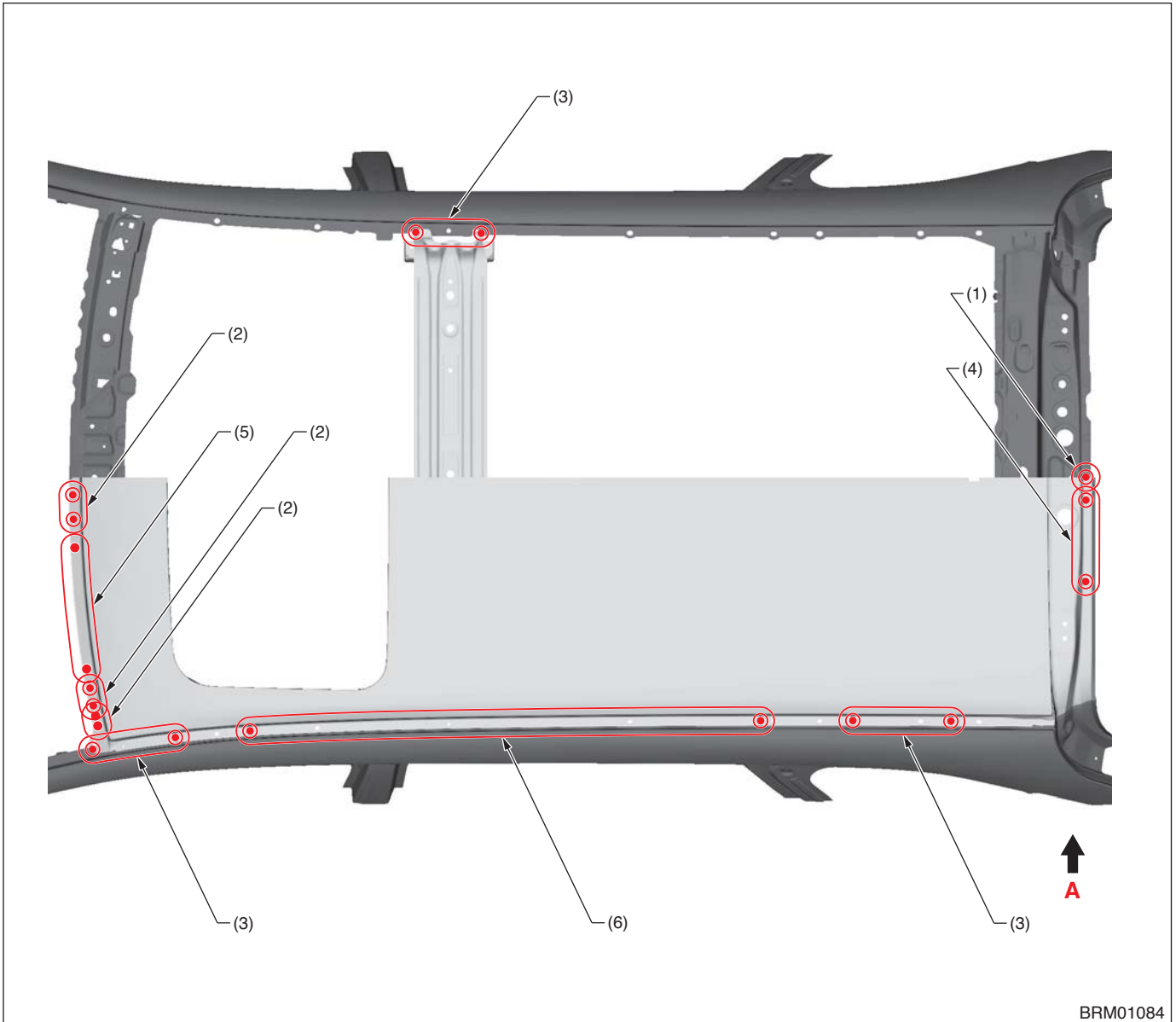
(1) 1 point (top · 1)
(2) 2 points (top · 1)

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

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

Panel Replacement

• Overall view (Model with sunroof)



BRM01084

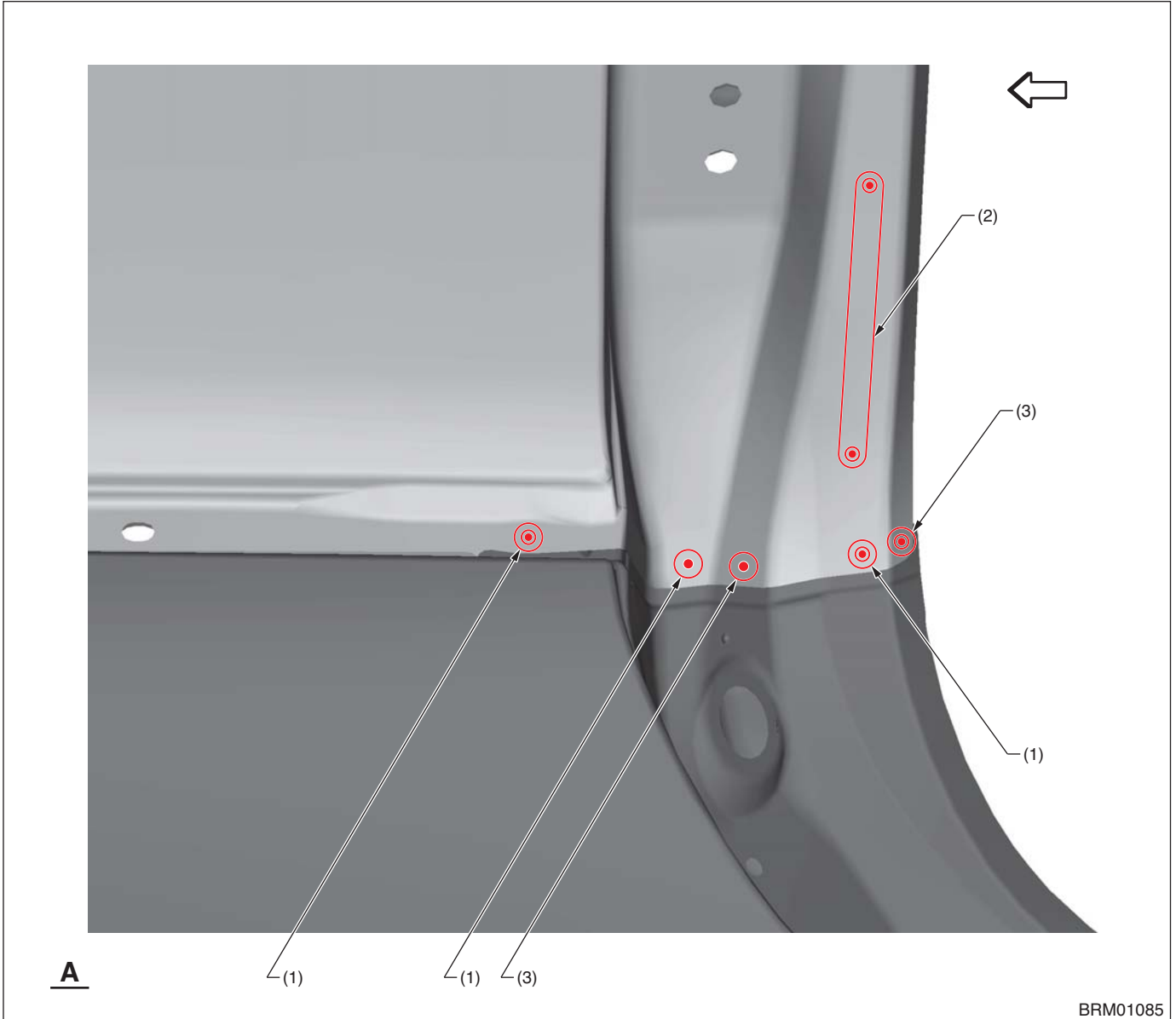
(1) 1 point (top · 1)
(2) 2 points (top · 1)

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

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

Panel Replacement

• View A



(1) 1 point (top · 1)

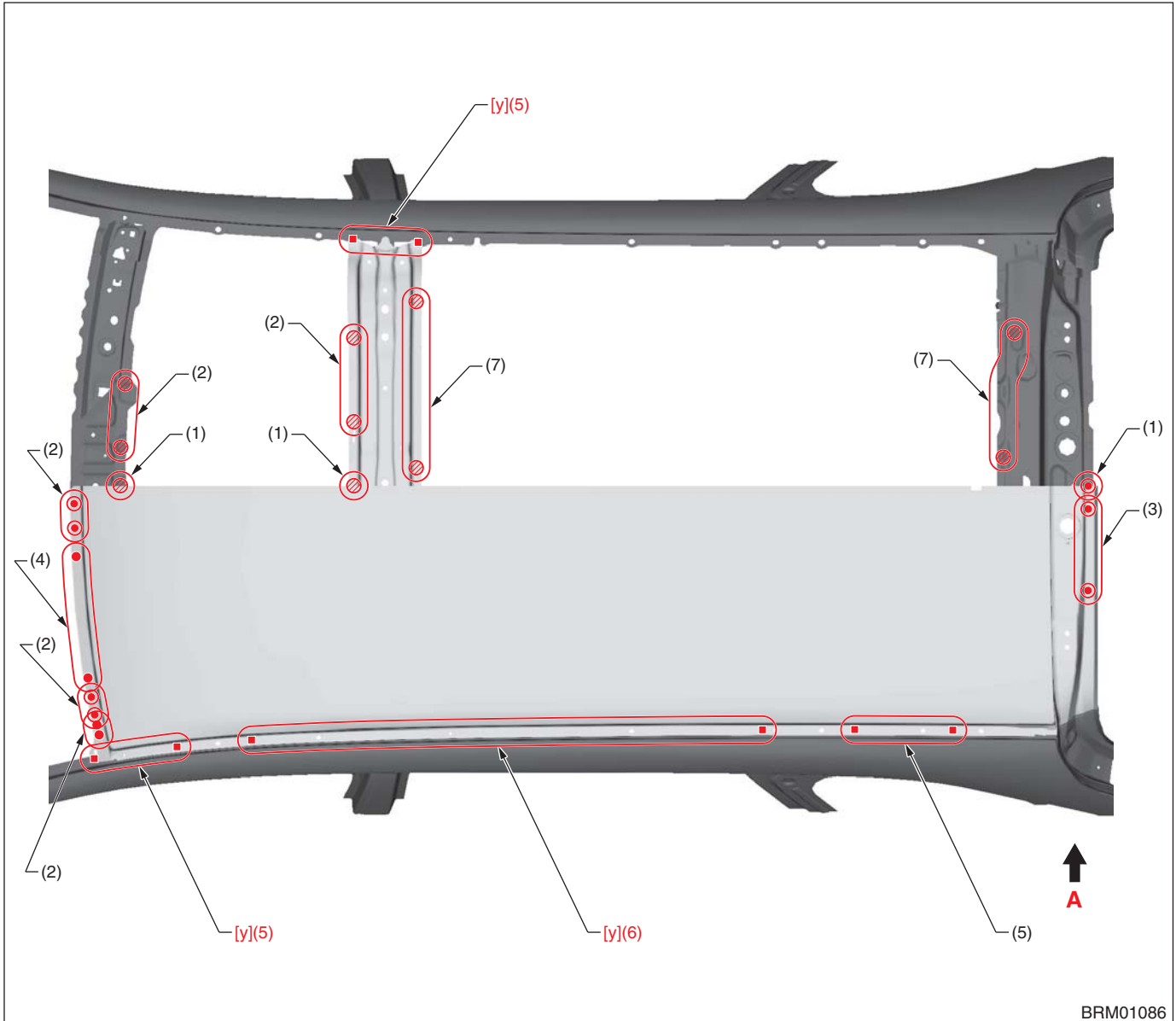
(2) 3 points (top · 1)

(3) 1 point (outside · 1)

Panel Replacement

B: INSTALLATION

• Overall view (Model without sunroof)




BRM01086

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

- (4) 6 points
- (5) 3 points (service)
- (6) 13 points (service)

- (7) 3 points

 : Application of adhesive

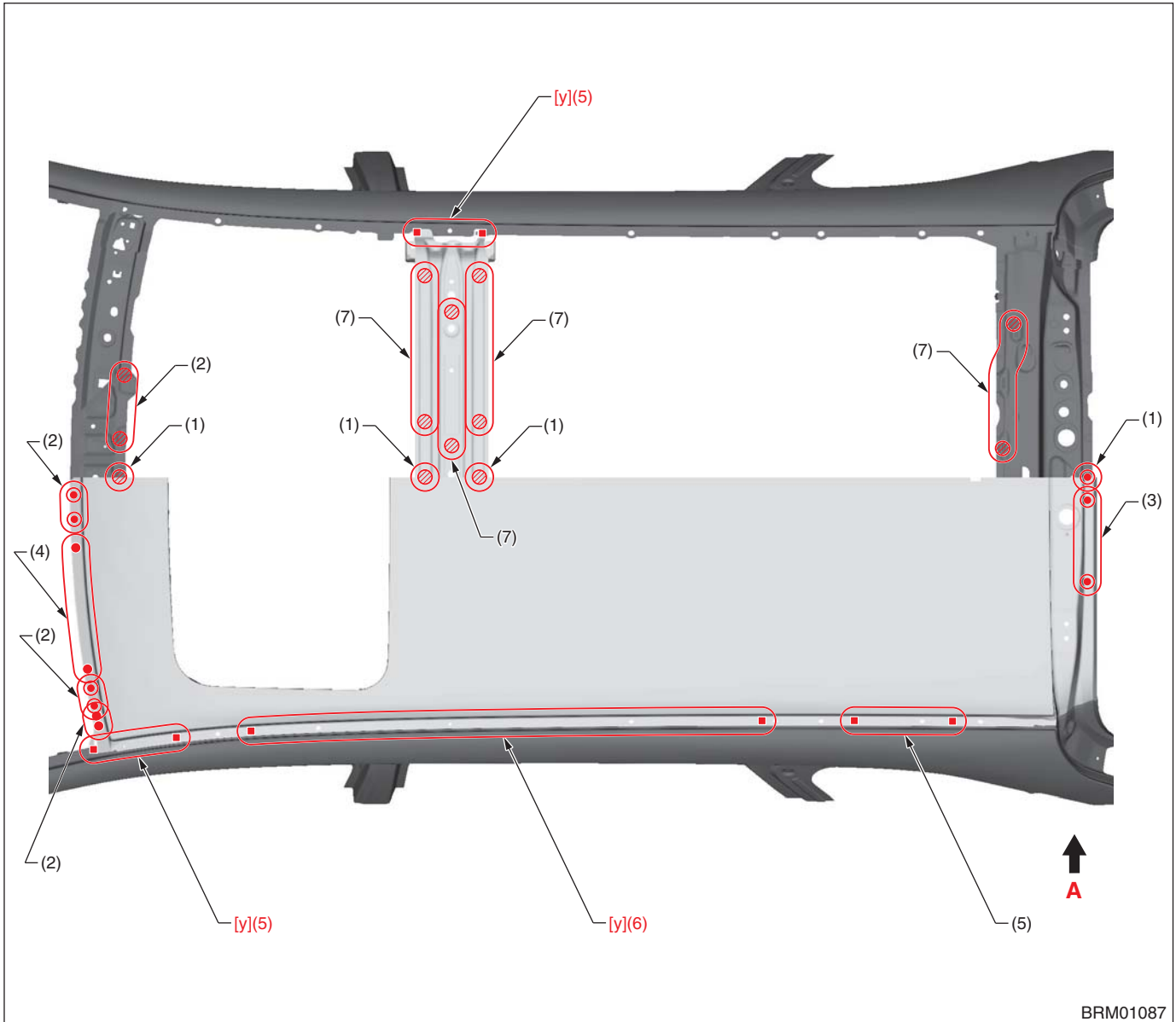
[y] Plug welding

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

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

Panel Replacement

• Overall view (Model with sunroof)




BRM01087

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

- (4) 6 points
- (5) 3 points (service)
- (6) 13 points (service)

- (7) 3 points

 : Application of adhesive

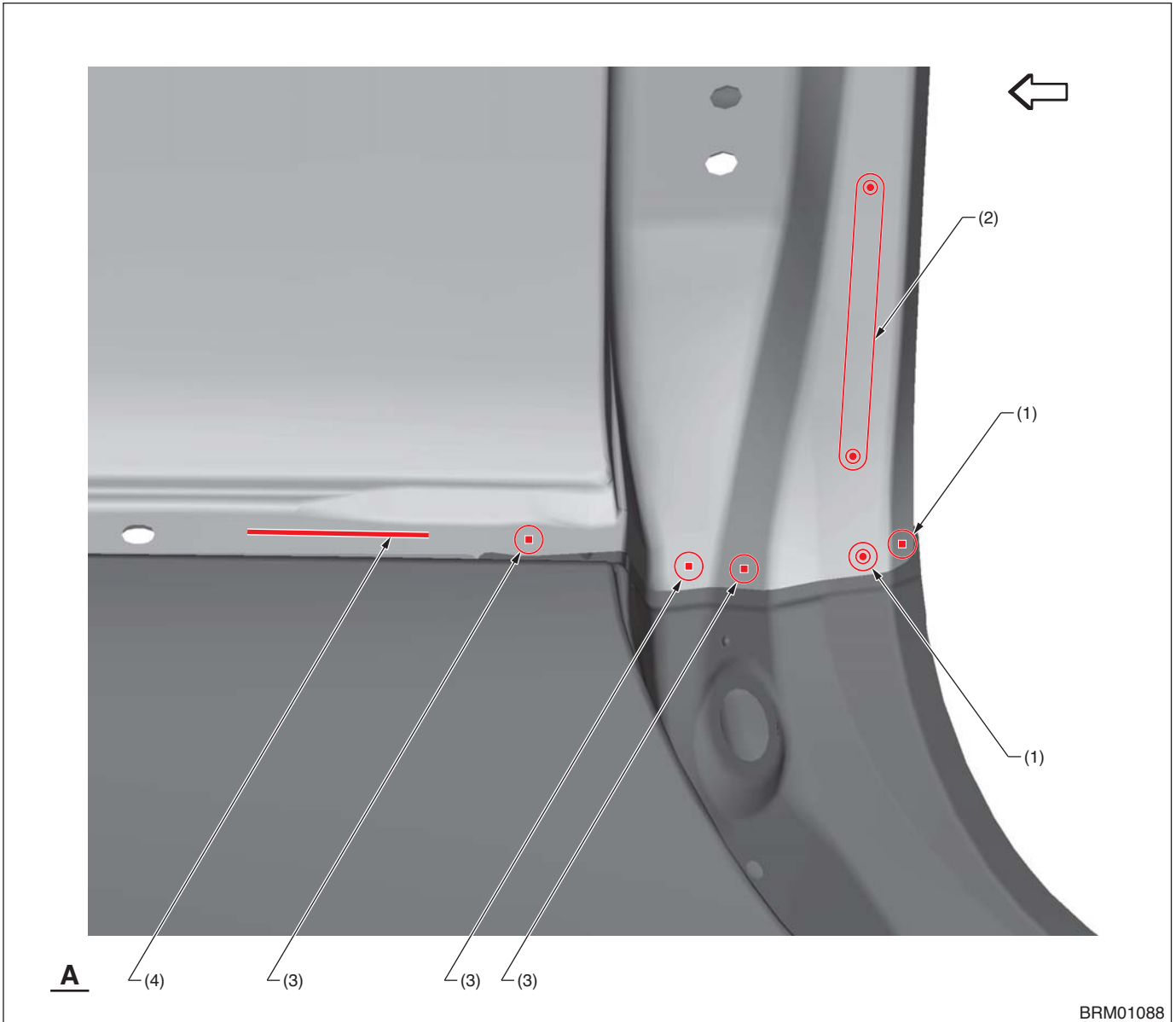
[y] Plug welding

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

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

Panel Replacement

• View A



(1) 1 point
(2) 3 points

(3) 1 point (service)

(4) Structural adhesive

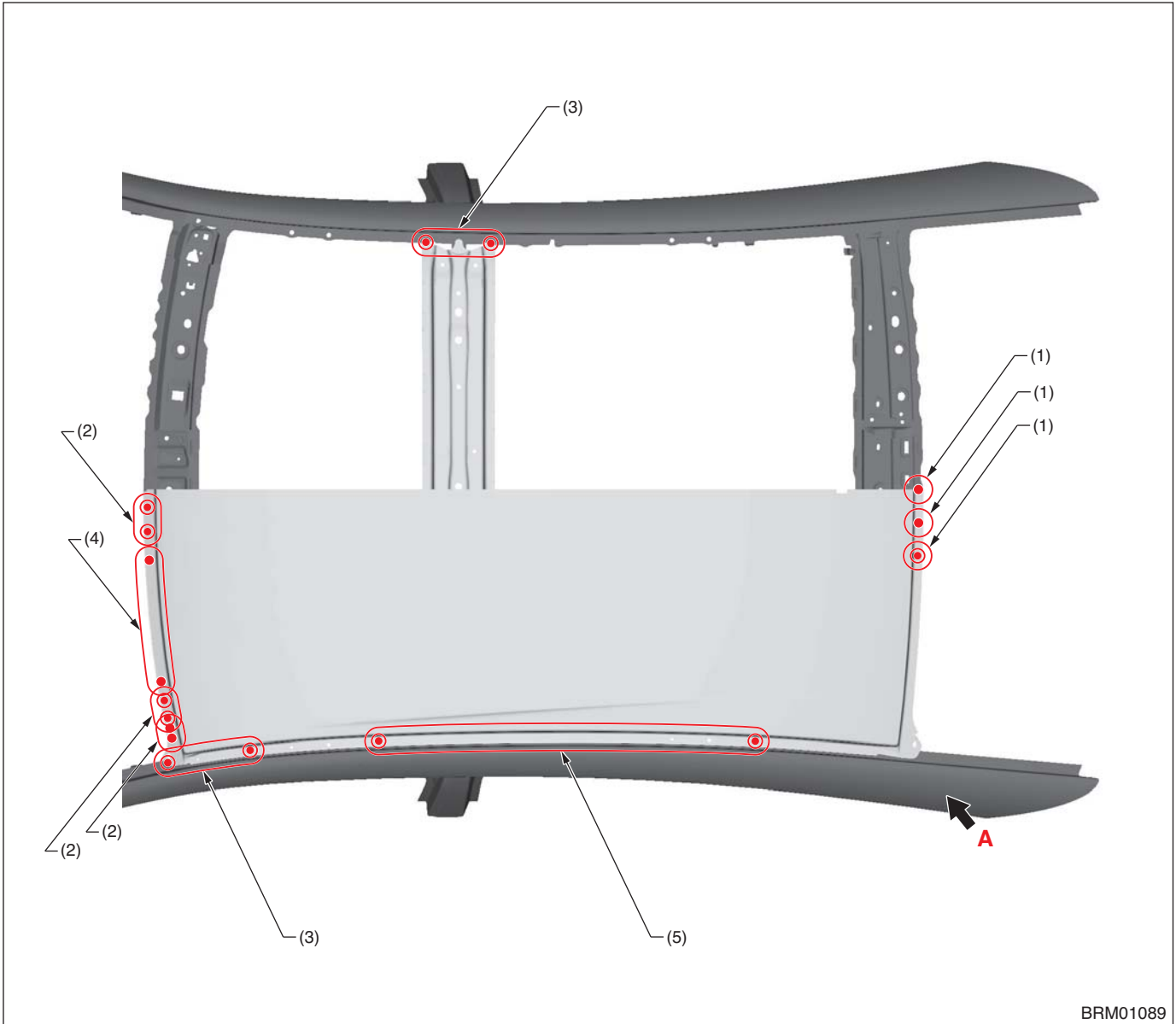
— : Structural adhesive application location (Panel bond mini 38315 made by 3M or equivalent)

Panel Replacement

8-42. Roof Panel (Total replacement) SEDAN

A: REMOVAL

• Overall view (Model without sunroof)



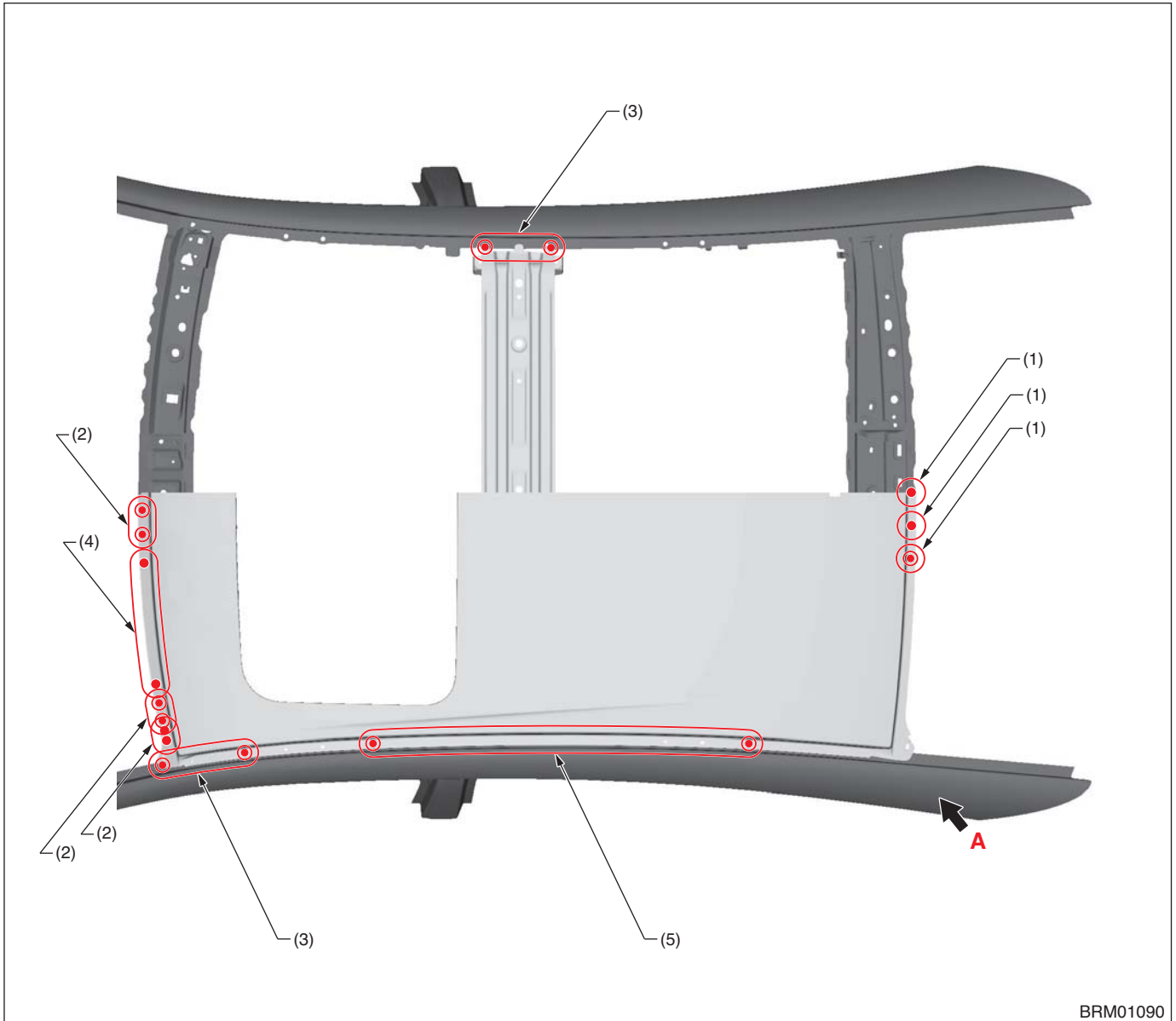
(1) 1 point (top · 1)
(2) 2 points (top · 1)

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

(5) 9 points (top · 1)

Panel Replacement

• Overall view (Model with sunroof)



BRM01090

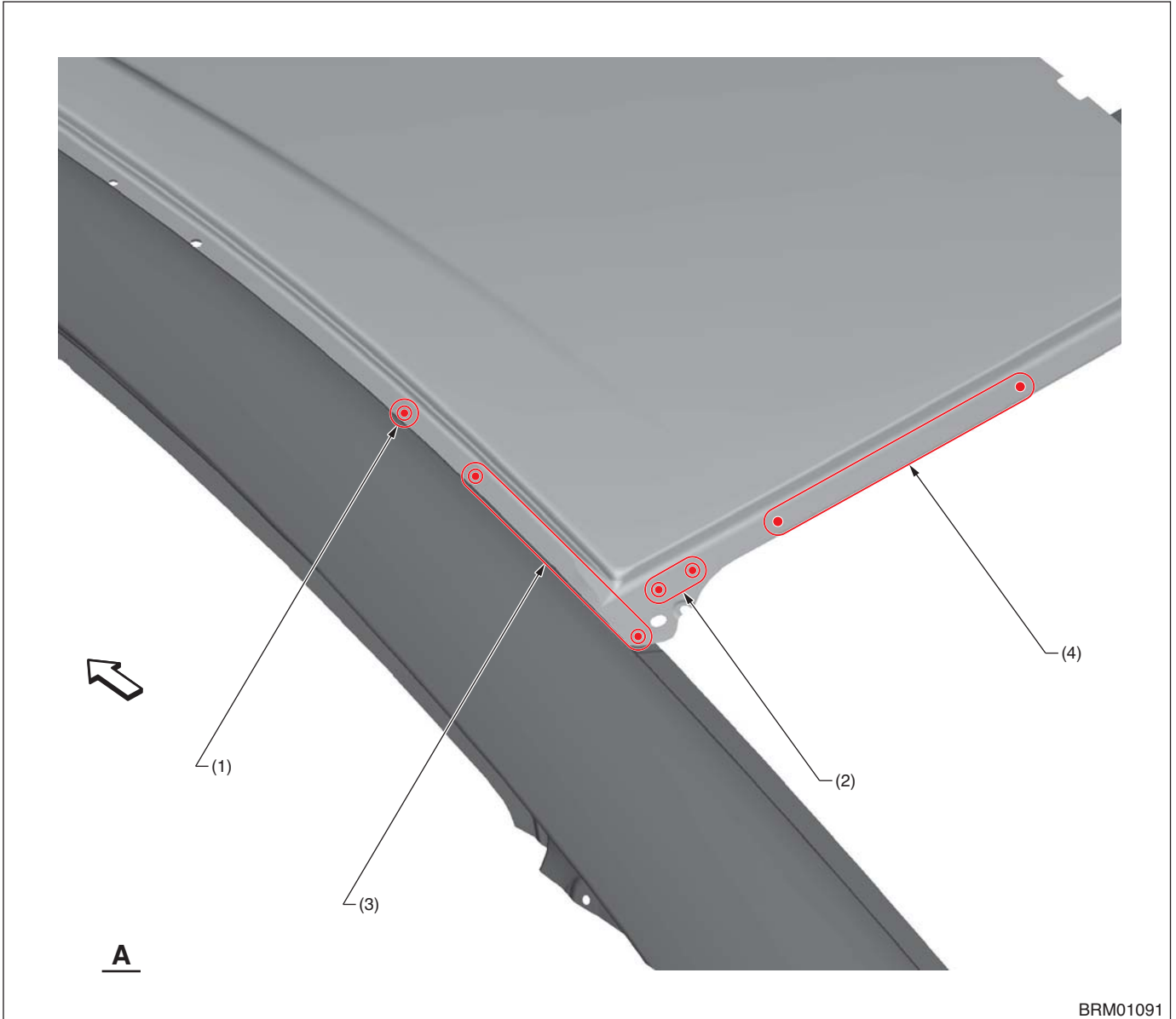
(1) 1 point (top · 1)
(2) 2 points (top · 1)

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

(5) 9 points (top · 1)

Panel Replacement

• View A



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

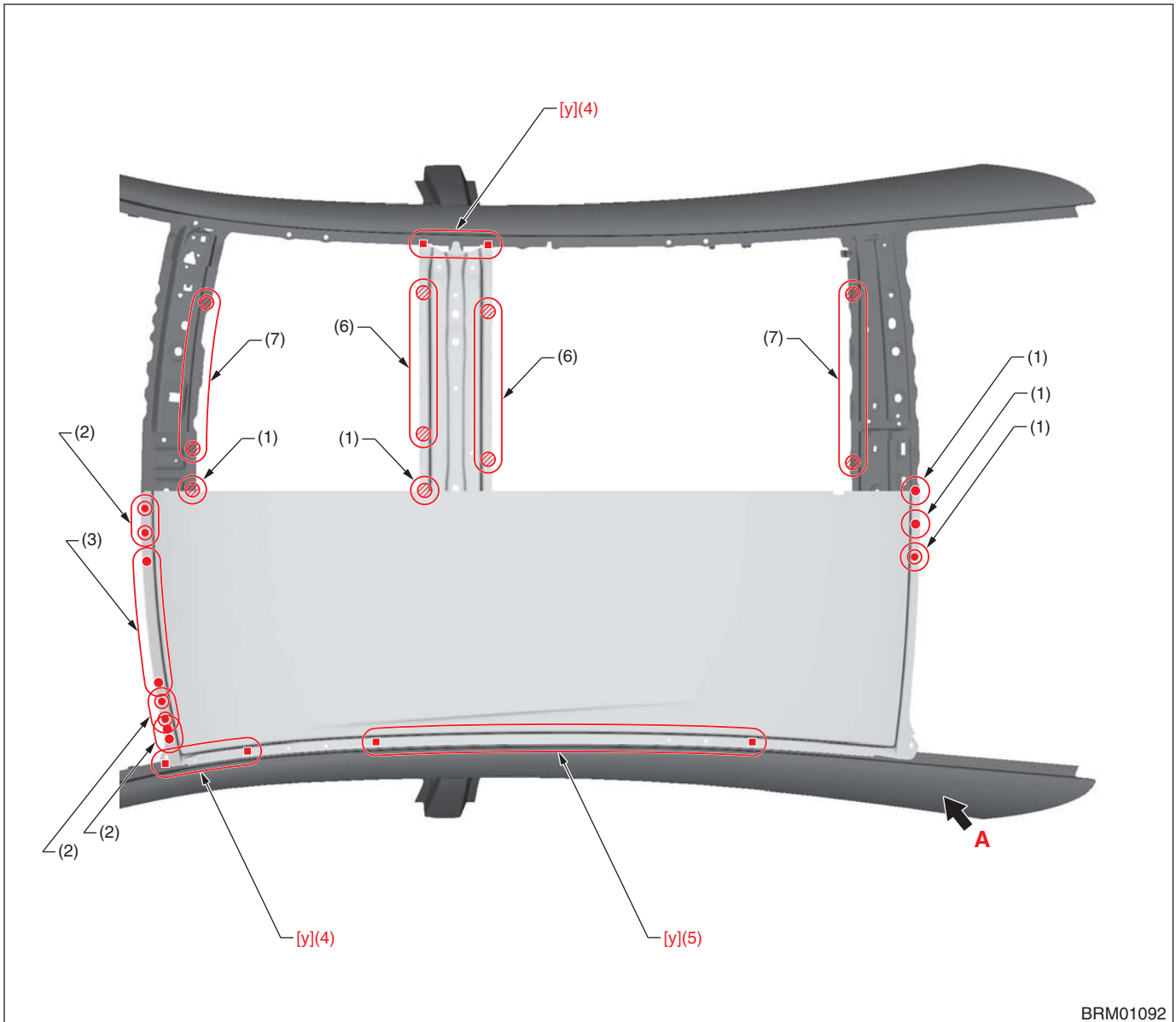
(3) 3 points (top · 1)

(4) 4 points (top · 1)

Panel Replacement


B: INSTALLATION

• Overall view (Model without sunroof)



BRM01092

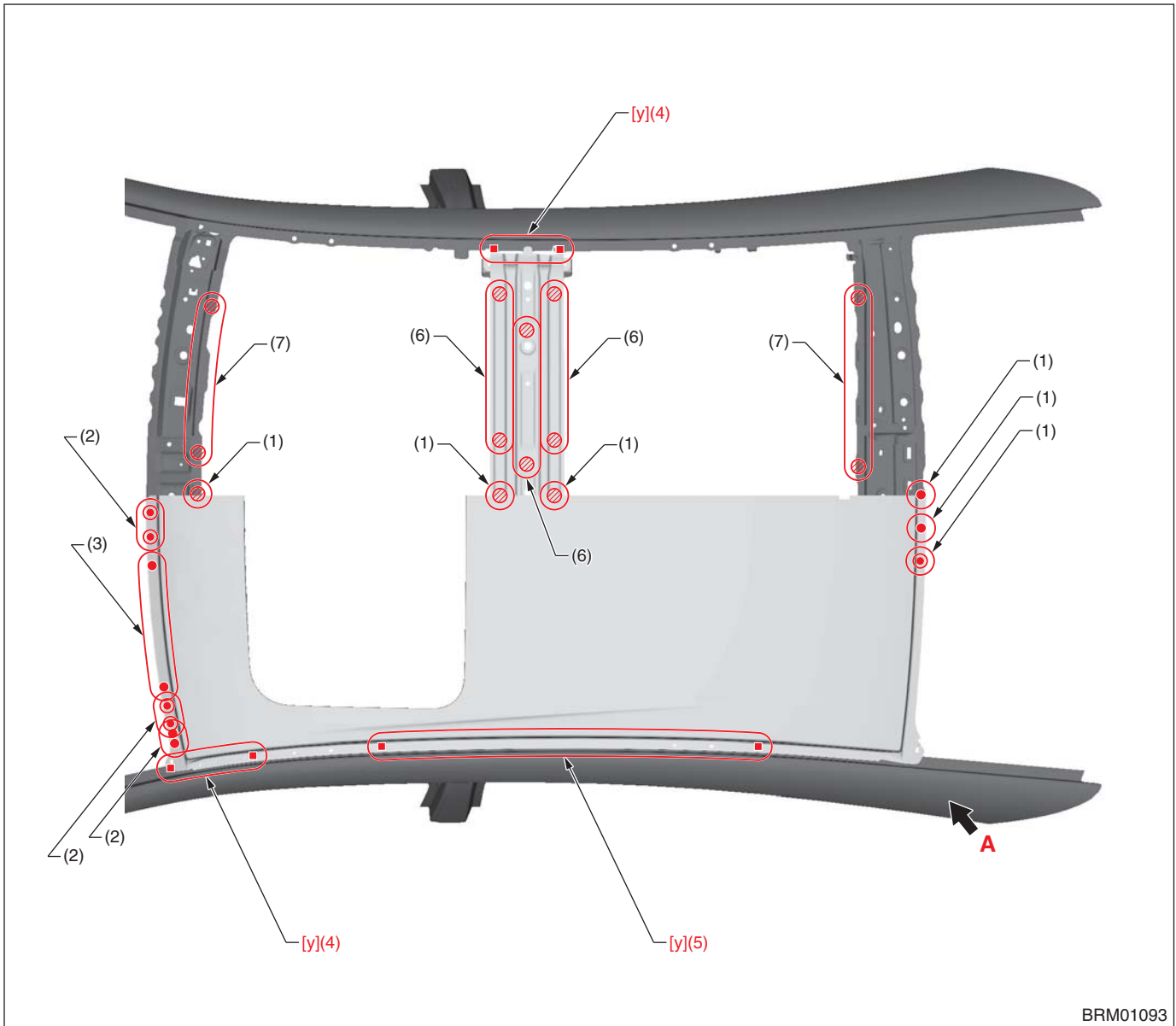
- | | | |
|--------------|------------------------|--------------|
| (1) 1 point | (4) 3 points (service) | (7) 4 points |
| (2) 2 points | (5) 9 points (service) | |
| (3) 6 points | (6) 3 points | |

 : Application of adhesive

[y] Plug welding	A Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW12, Gas: CO ₂ B Plug diameter: 8.5 mm (0.33 in) or more, Wire: YGW16, Gas: Gas mixture (argon: 80 %, CO ₂ : 20 %)
------------------	--

Panel Replacement


• Overall view (Model with sunroof)



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

- (4) 3 points (service)
- (5) 9 points (service)
- (6) 3 points

- (7) 4 points

 : Application of adhesive

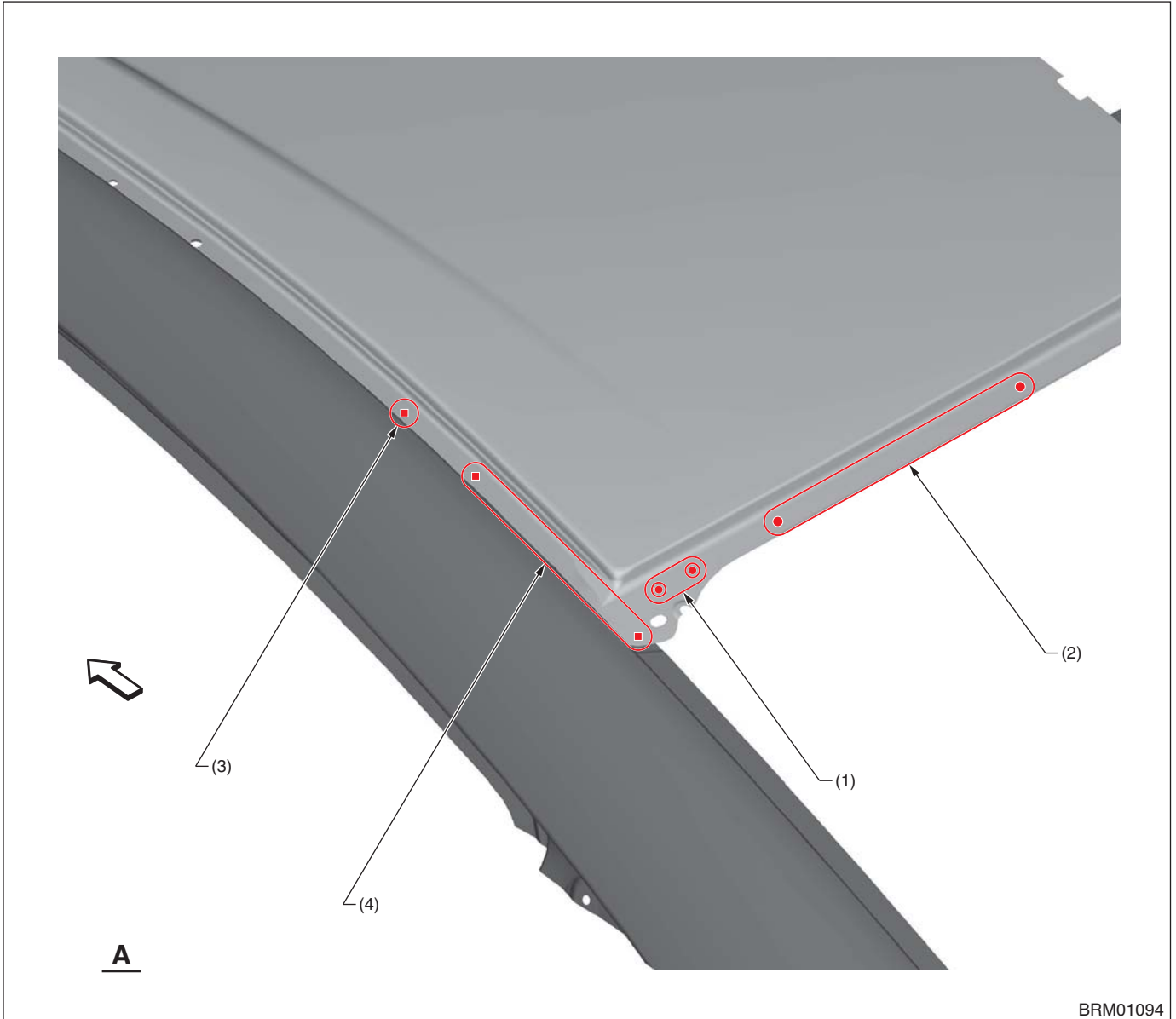
[y] Plug welding

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

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

Panel Replacement

• View A



(1) 2 points
(2) 4 points

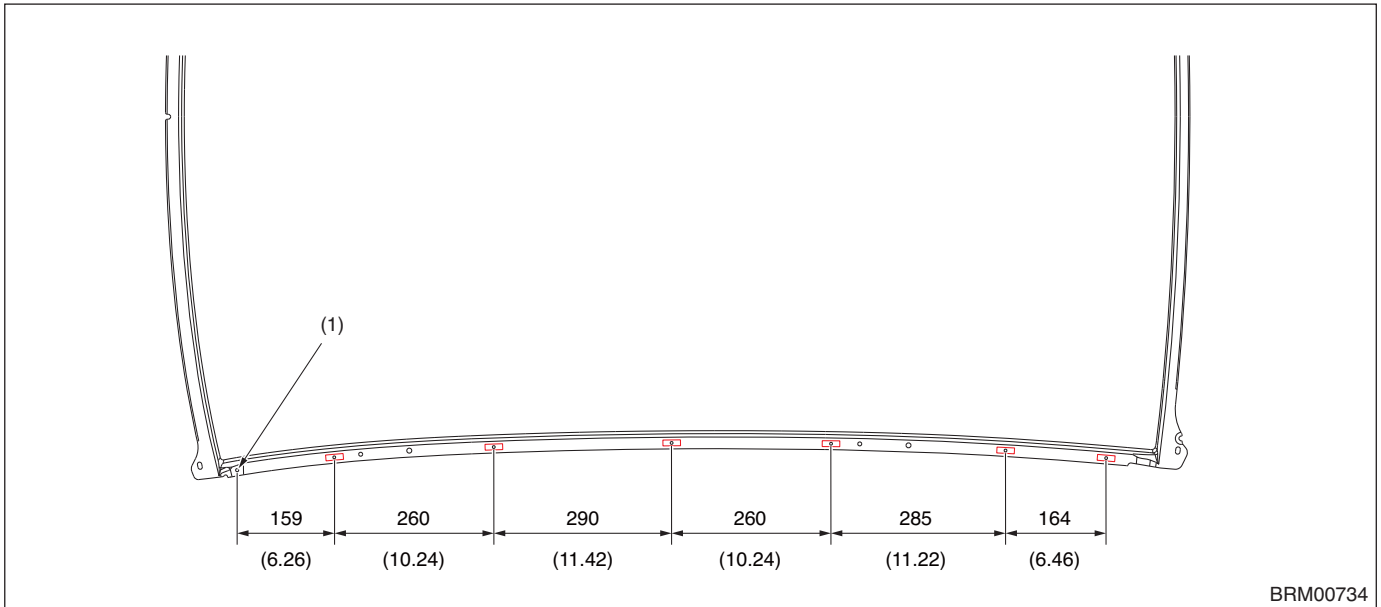
(3) 1 point (service)

(4) 3 points (service)

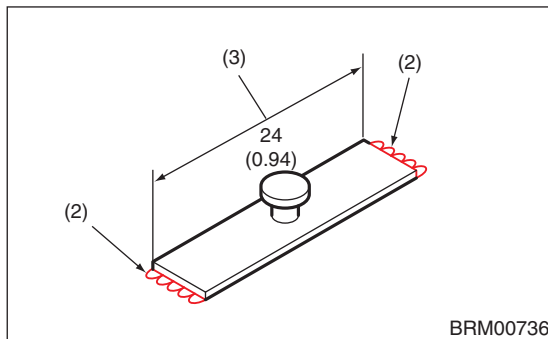
Panel Replacement

8-43. T Stud Installation

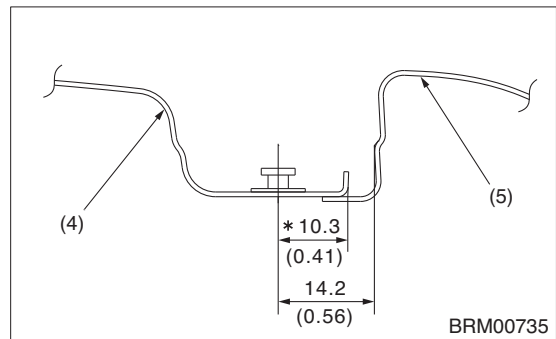
- Only SEDAN



- T stud welding



- T stud basic cross section



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

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

(5) Panel side outer

(2) Arc welding for both plate ends

(4) Roof panel

* Indicates dimensions for reference.

Body Sealing

9. Body Sealing

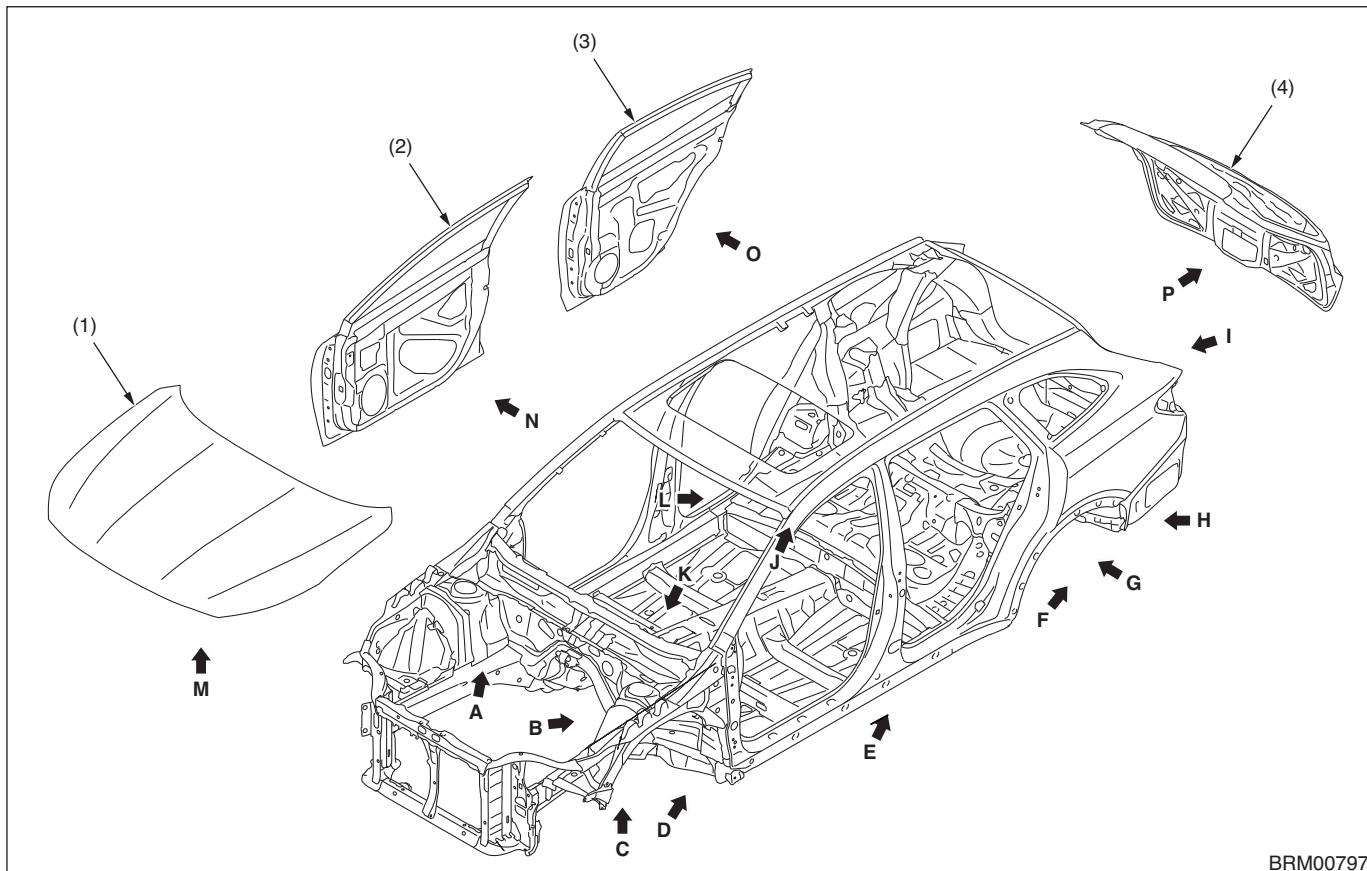
A: SPECIFICATIONS

Used material: Three Bond 4101 (004403063)

— : Sealer application location

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

• COMMON PARTS FOR OUTBACK AND SEDAN



BRM00797

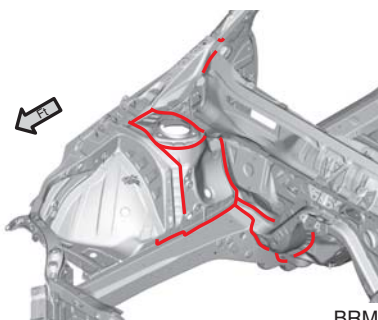
(1) Front hood

(3) Rear door

(4) Rear gate

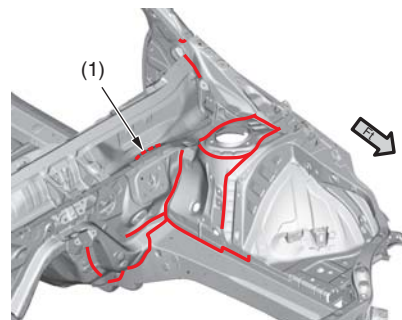
(2) Front door

View A



BRM00798

View B

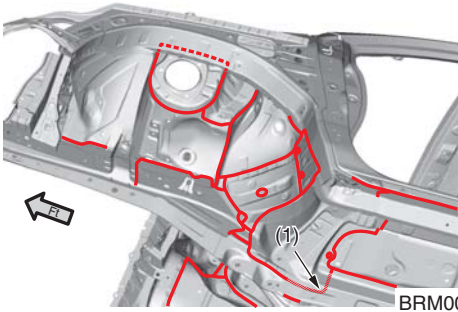


BRM00799

(1) Only LH

Body Sealing

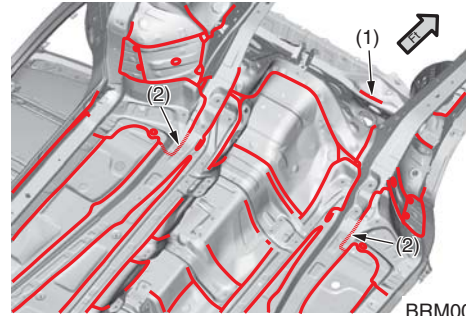
View C



BRM00800

(1) Wax is allowable

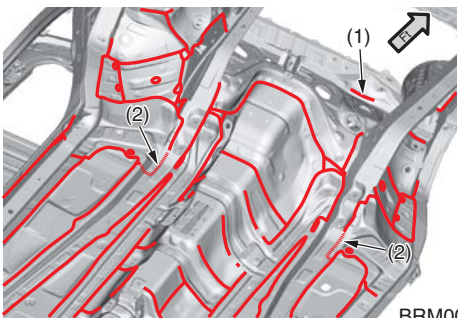
View D (CFT-CVT model)



BRM00801

(1) Only LH
(2) Wax is allowable

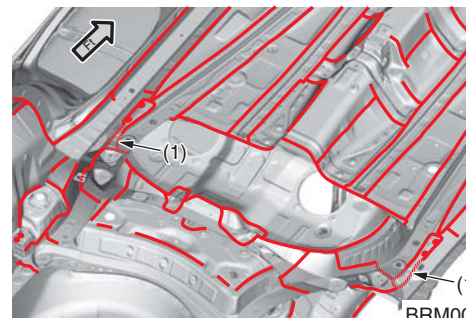
View D (HT-CVT model)



BRM00802

(1) Only LH
(2) Wax is allowable

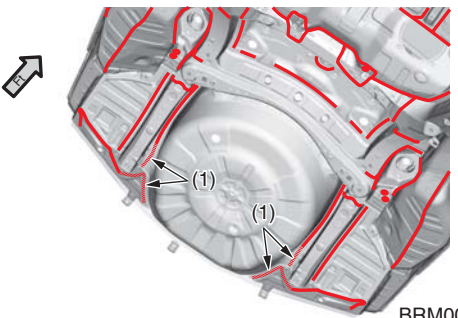
View E



BRM00803

(1) Wax is allowable

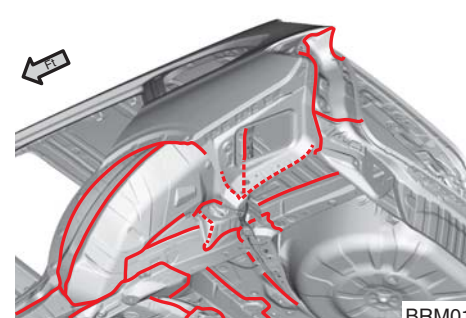
View F



BRM00804

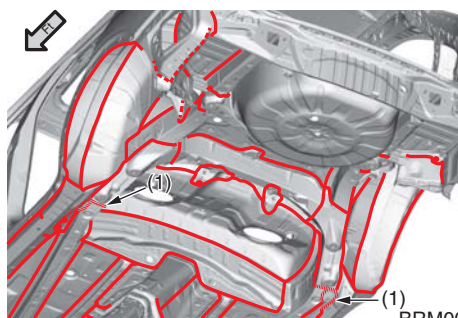
(1) Wax is allowable

View G



BRM01182

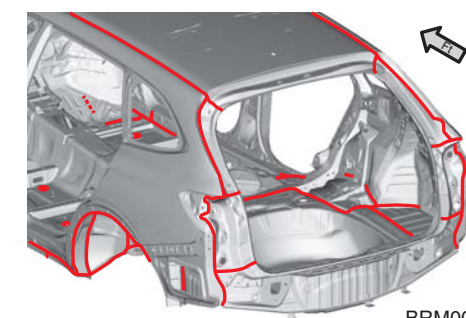
View H



BRM00806

(1) Wax is allowable

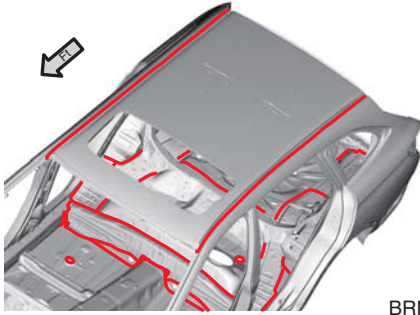
View I



BRM00807

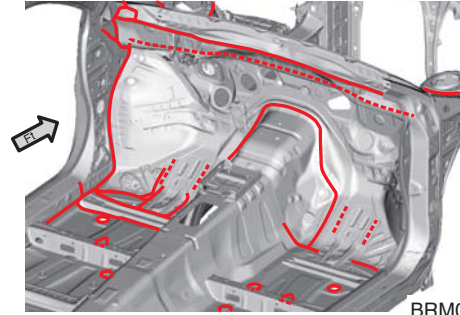
Body Sealing

View J



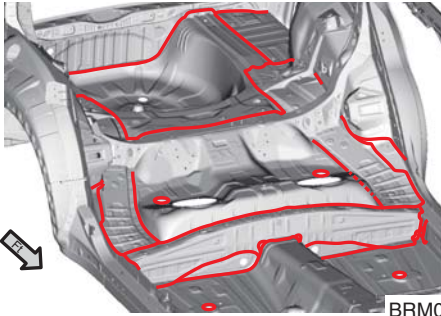
BRM00808

View K



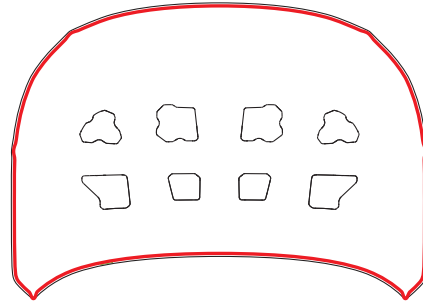
BRM00809

View L



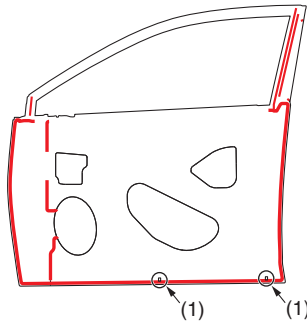
BRM01183

View M



BRM00811

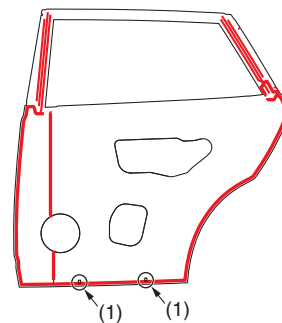
View N



BRM00812

(1) Do not block the water drain holes.

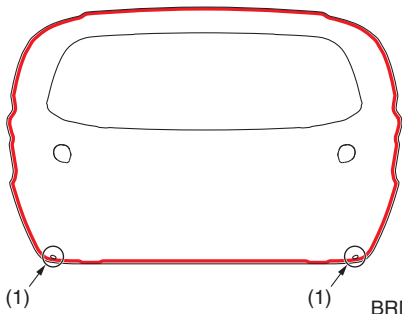
View O



BRM00813

(1) Do not block the water drain holes.

View P



BRM00814

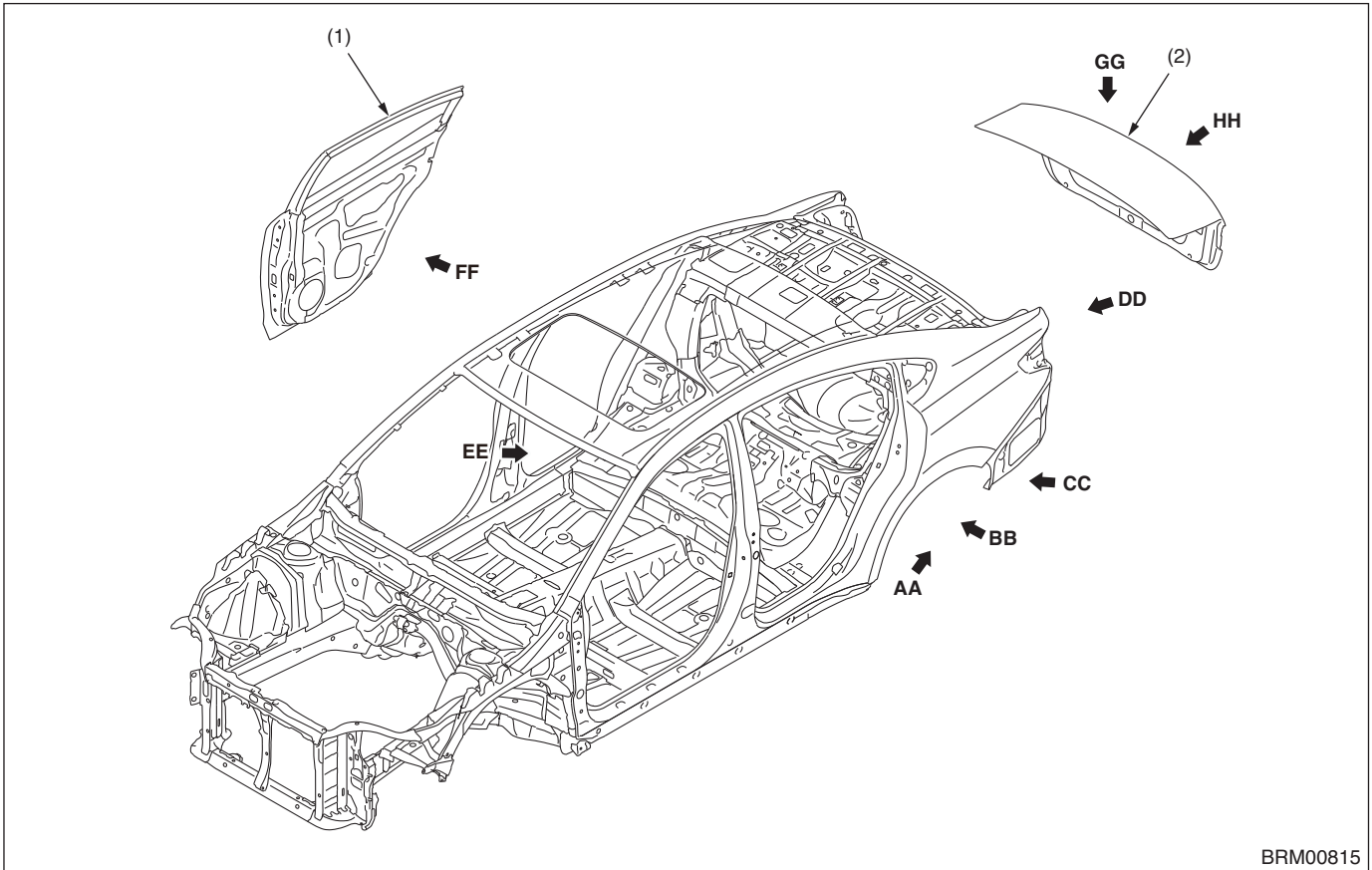
(1) Do not block the water drain holes.

SUBARU.

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

Body Sealing

• SPECIAL SEDAN PARTS

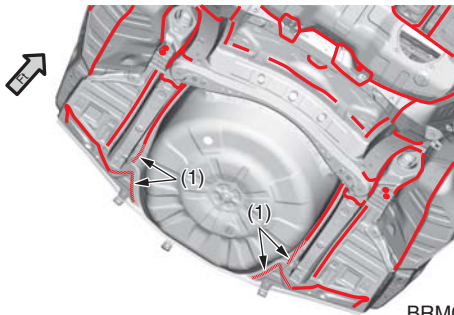


BRM00815

(1) Rear door

(2) Trunk

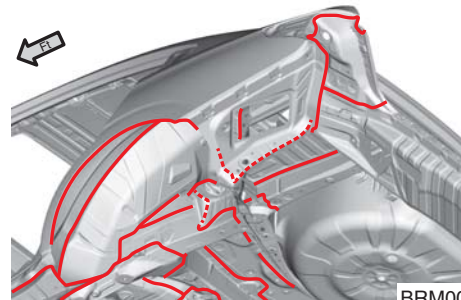
View AA



BRM01184

(1) Wax is allowable

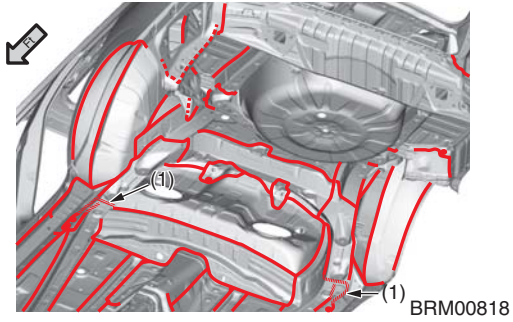
View BB



BRM00817

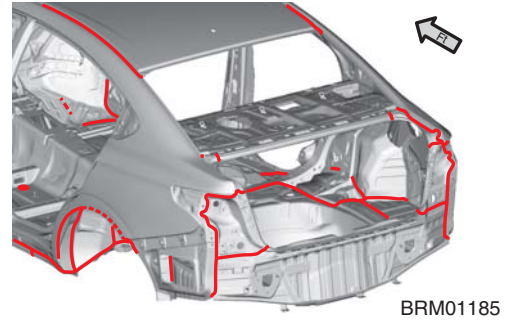
Body Sealing

View CC

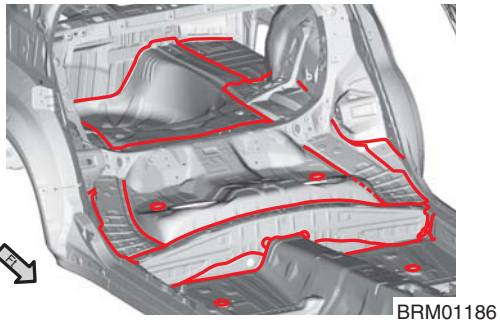


(1) Wax is allowable

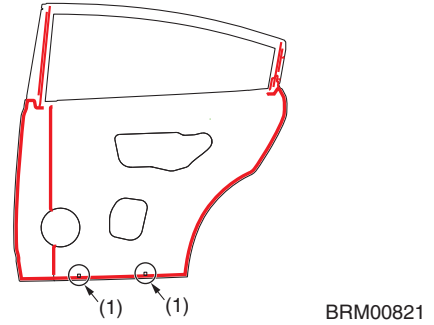
View DD



View EE

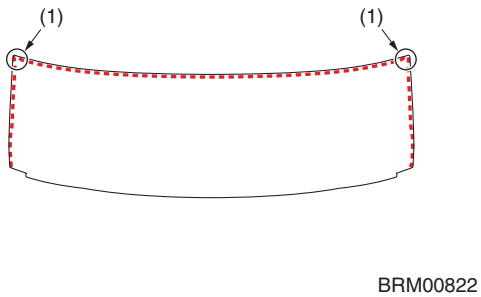


View FF



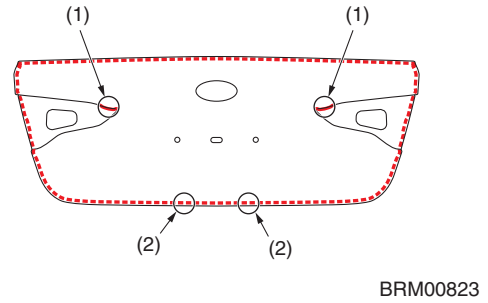
(1) Do not block the water drain holes.

View GG



(1) The hole shall be blocked.

View HH



(1) Be sure to block the hole.
(2) Do not block the water drain holes.

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

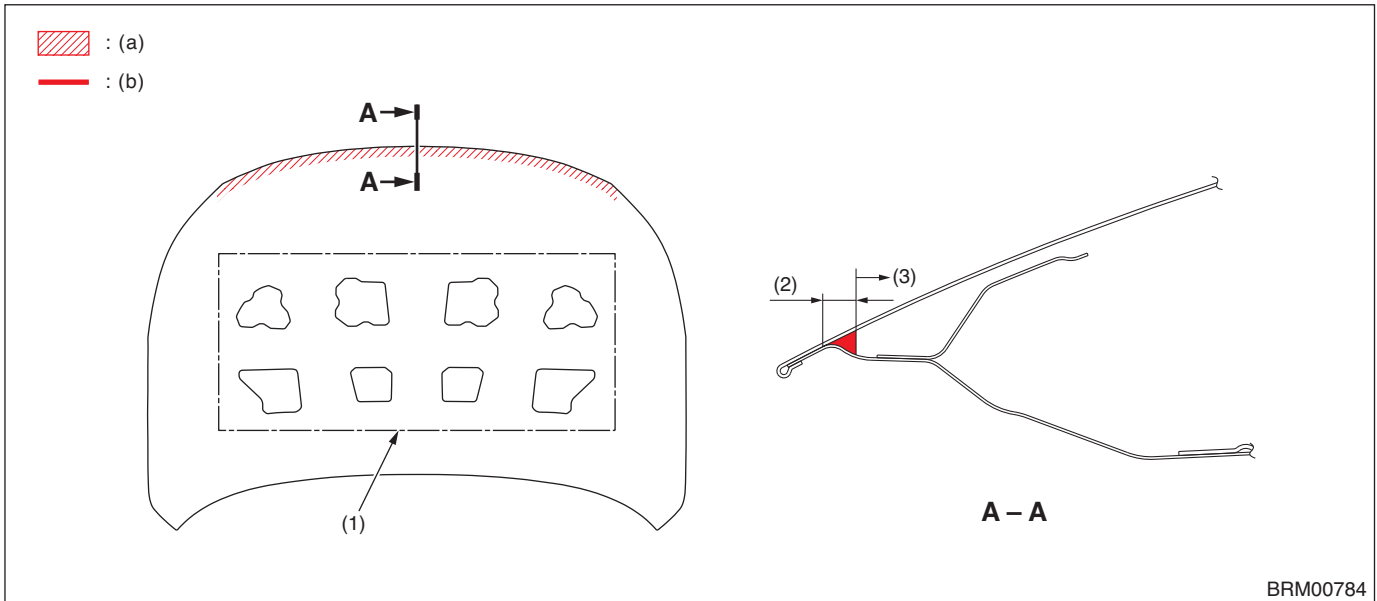
10. Anticorrosion Wax

A: SPECIFICATIONS

Used material: Rust-stop aerosol (K0877YA015)

— and    : Application area

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



BRM00784

(a) Rust-stop aerosol

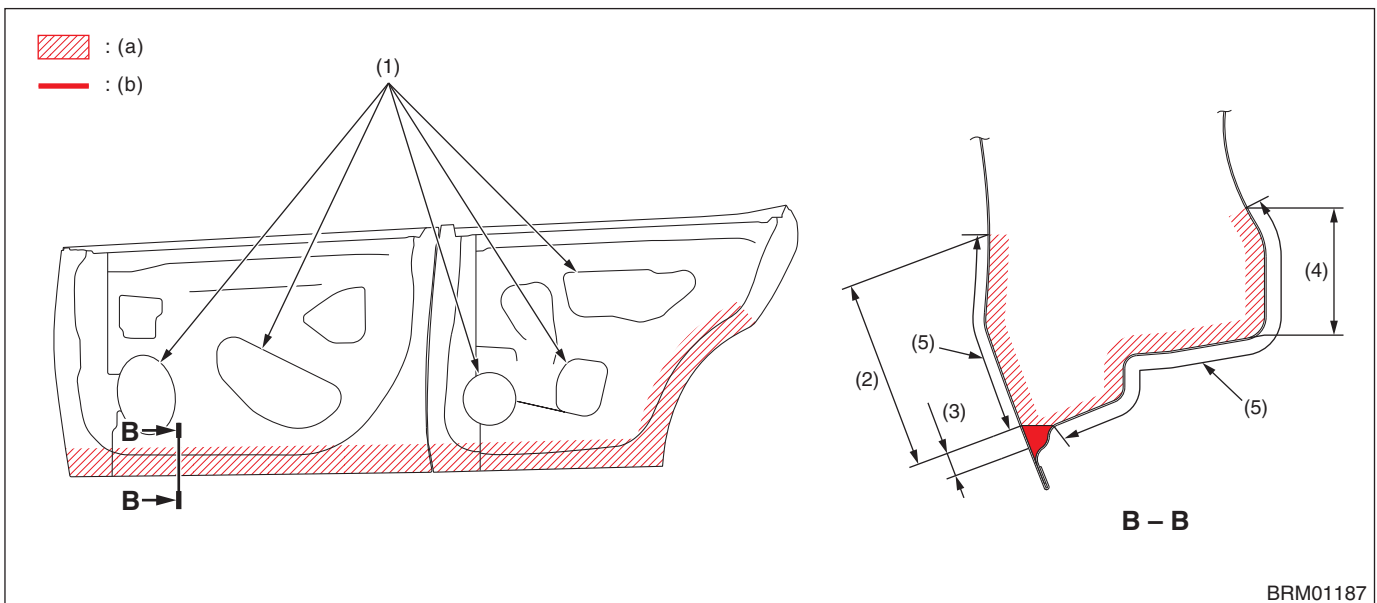
(b) To be filled into the plate joint

(1) Wax application work openings

(2) 10 mm (0.39 in)

(3) Adherence of mist is allowable

- **Door** (Application thickness = 50 μm or more)



BRM01187

(a) Rust-stop aerosol

(b) To be filled into the plate joint

(1) Wax application work openings

(3) 10 mm (0.39 in)

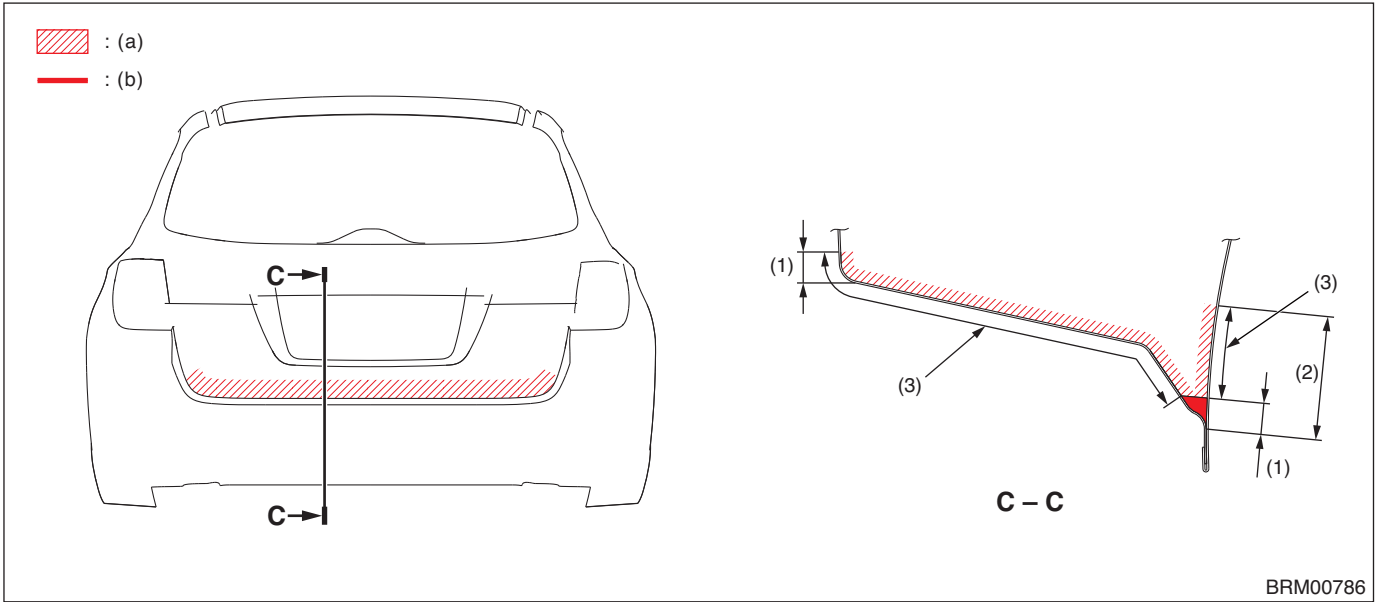
(5) Adherence of mist is allowable

(2) 80 mm (3.15 in)

(4) 50 mm (1.97 in)

Anticorrosion Wax

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



(a) Rust-stop aerosol

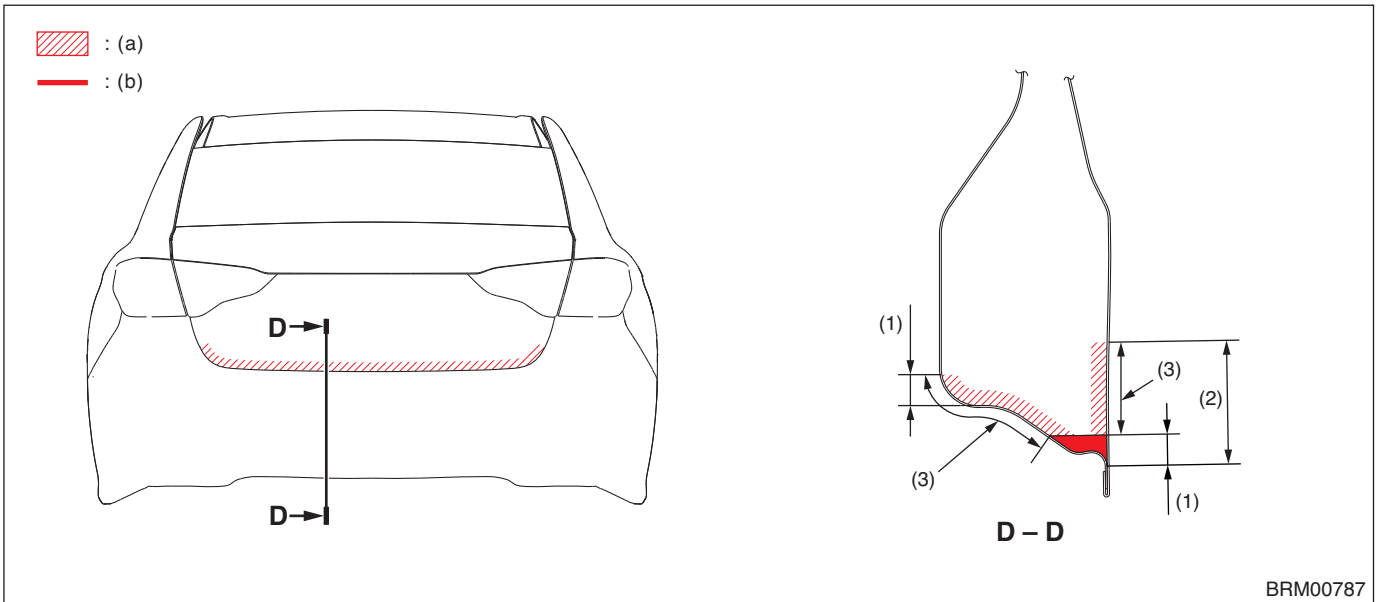
(b) To be filled into the plate joint

(1) 10 mm (0.39 in)

(2) 40 mm (1.57 in)

(3) Adherence of mist is allowable

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



(a) Rust-stop aerosol

(b) To be filled into the plate joint

(1) 10 mm (0.39 in)

(2) 40 mm (1.57 in)

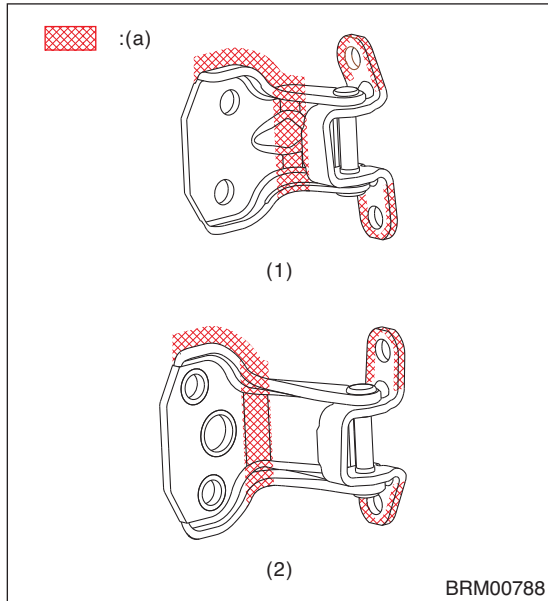
(3) Adherence of mist is allowable

Anticorrosion Wax

- Front hinge

(Application thickness = 15 μm or more)

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



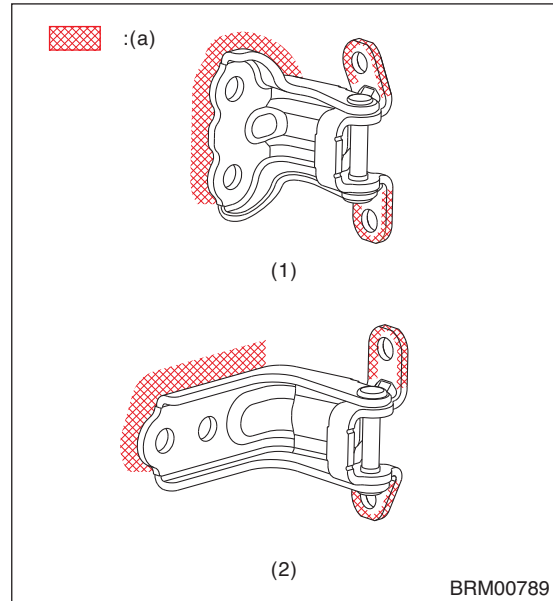
(a) Rust-stop aerosol

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

- Rear hinge

(Application thickness = 15 μm or more)

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



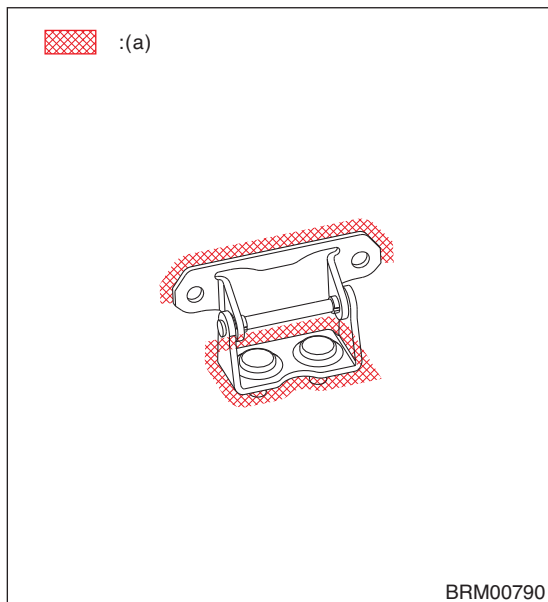
(a) Rust-stop aerosol

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

- Rear gate hinge

(Application thickness = 15 μm or more)

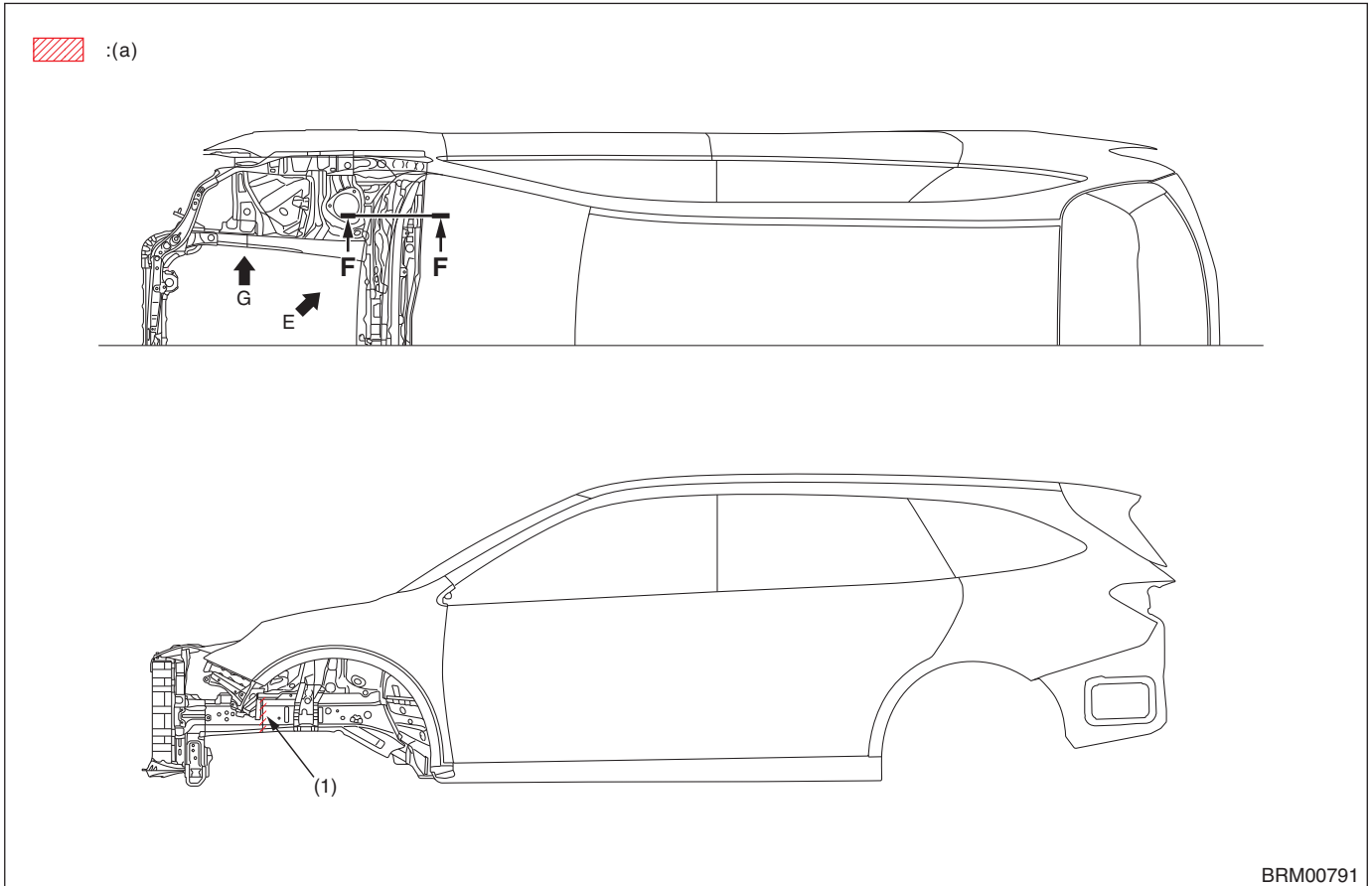
Apply to the contact surface on the body side at two locations on the left and right, and to installation outer circumference (indicated range, plate edges) on the rear gate side and to the head of the bolts.



(a) Rust-stop aerosol

Anticorrosion Wax

- Overall view

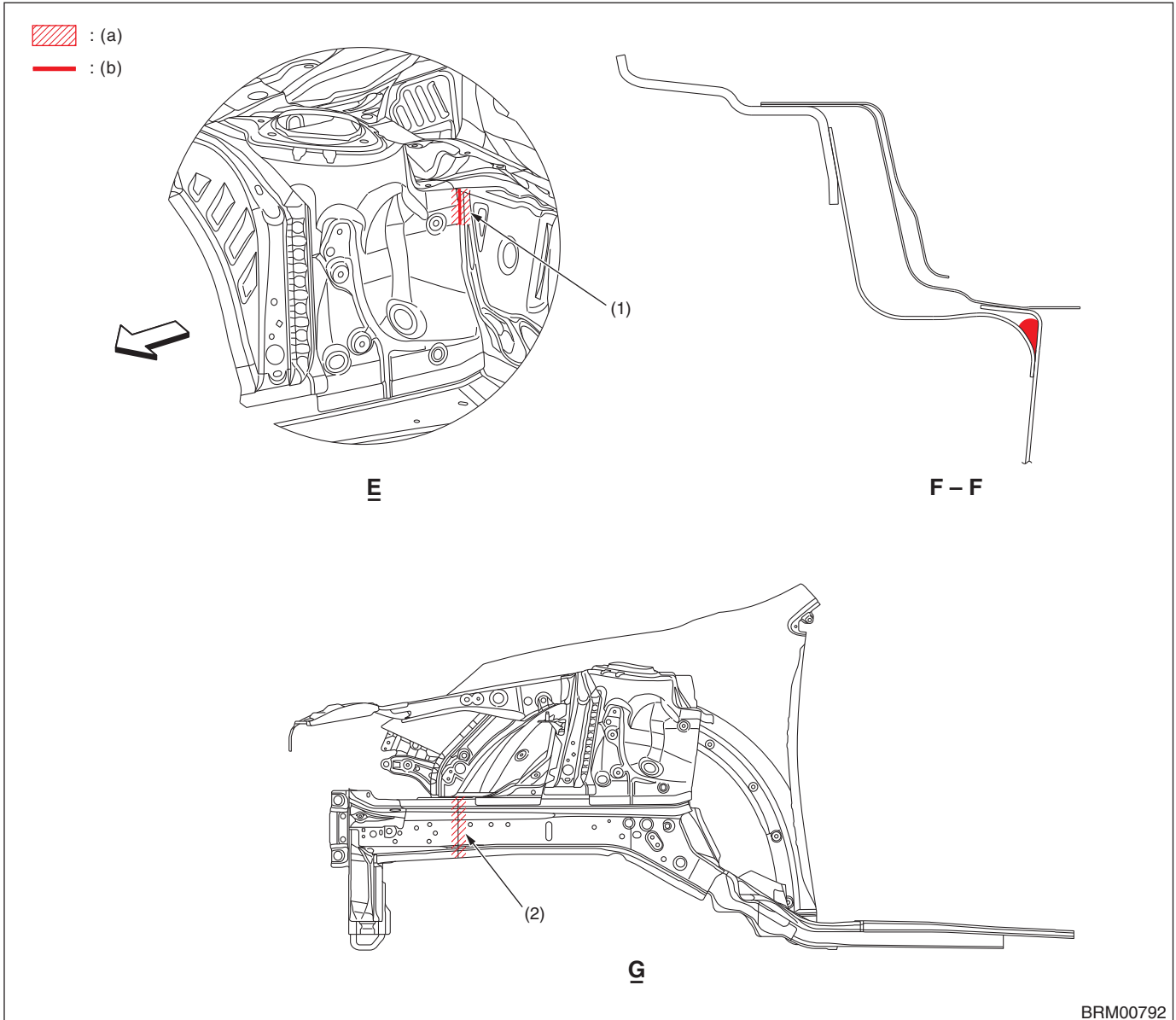


(a) Rust-stop aerosol (Application thickness = 50 μm or more)

(1) The panel joints shall be covered

Anticorrosion Wax

• View / Cross section

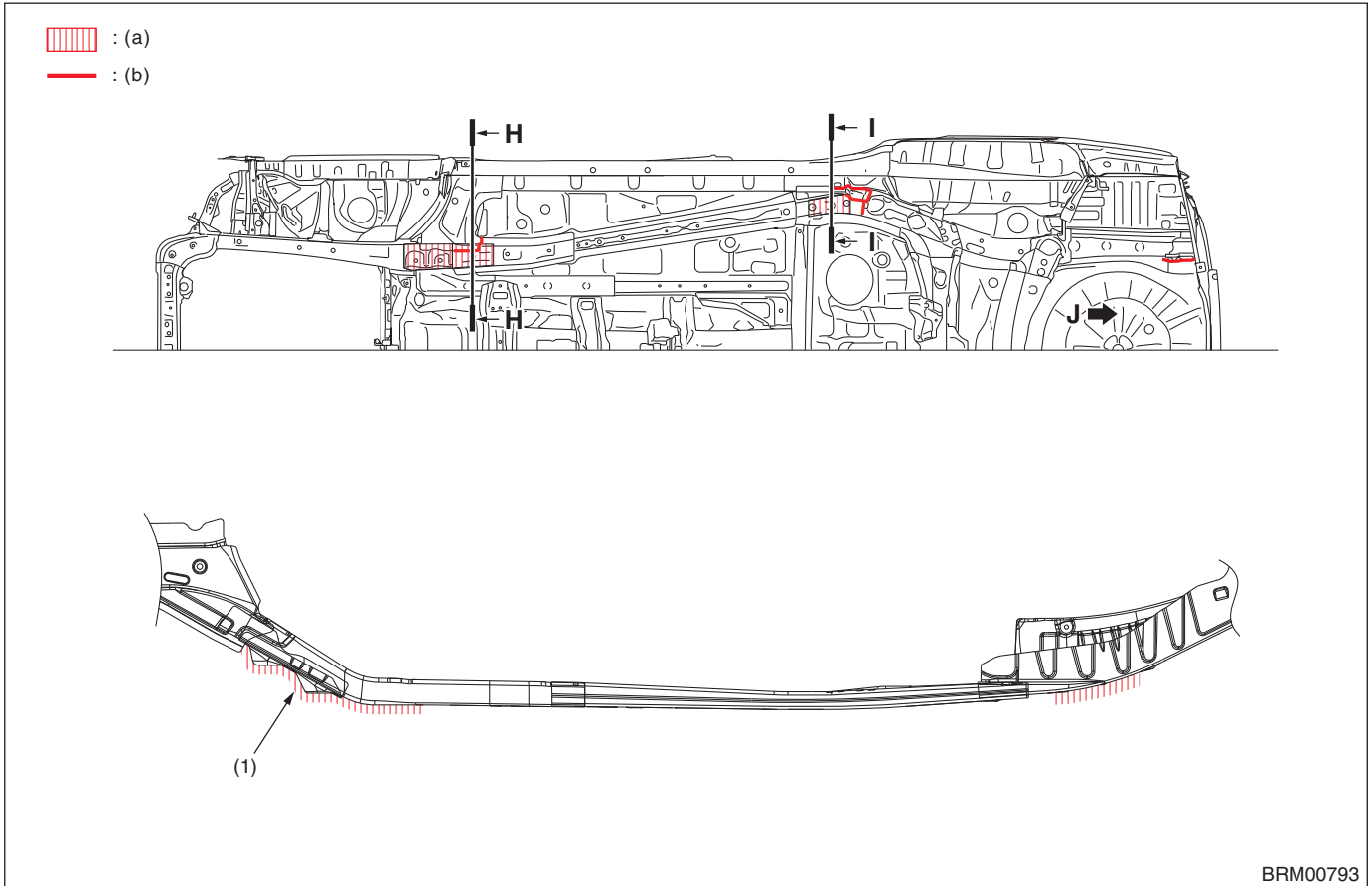


- (a) Rust-stop aerosol (Application thickness = 50 μm or more) (b) To be filled into the plate joint

- (1) Apply wax only when sealing is not allowed.
Securely cover the contact surface of the toe board, front suspension bracket.
Wrap the sealing and wax securely.
- (2) The panel joints on the inside of the engine compartment shall be covered

Anticorrosion Wax

• Bottom view



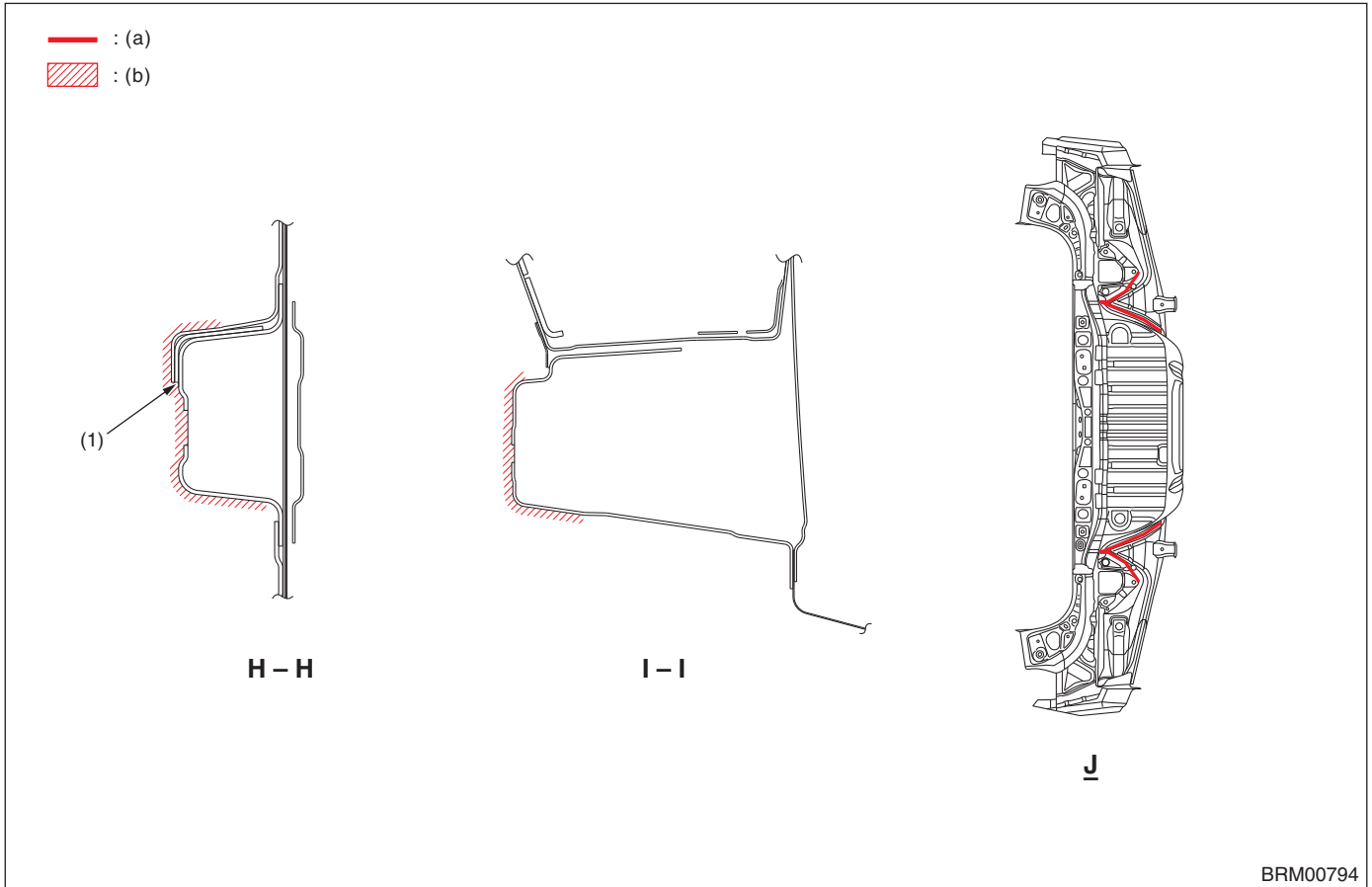
(a) Rust-stop aerosol (Application thickness = 150 μm or more)

(b) To be filled into the plate joint

(1) Apply wax so that the suspension arm bush and exhaust pipe are not waxed.

Anticorrosion Wax

• View / Cross section



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

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

(1) Completely apply wax over the round edge of the mating surface.

Undercoat

11.Undercoat

A: SPECIFICATIONS




Repair material: PVC (NT guardcoat 5900FL)

CAUTION:

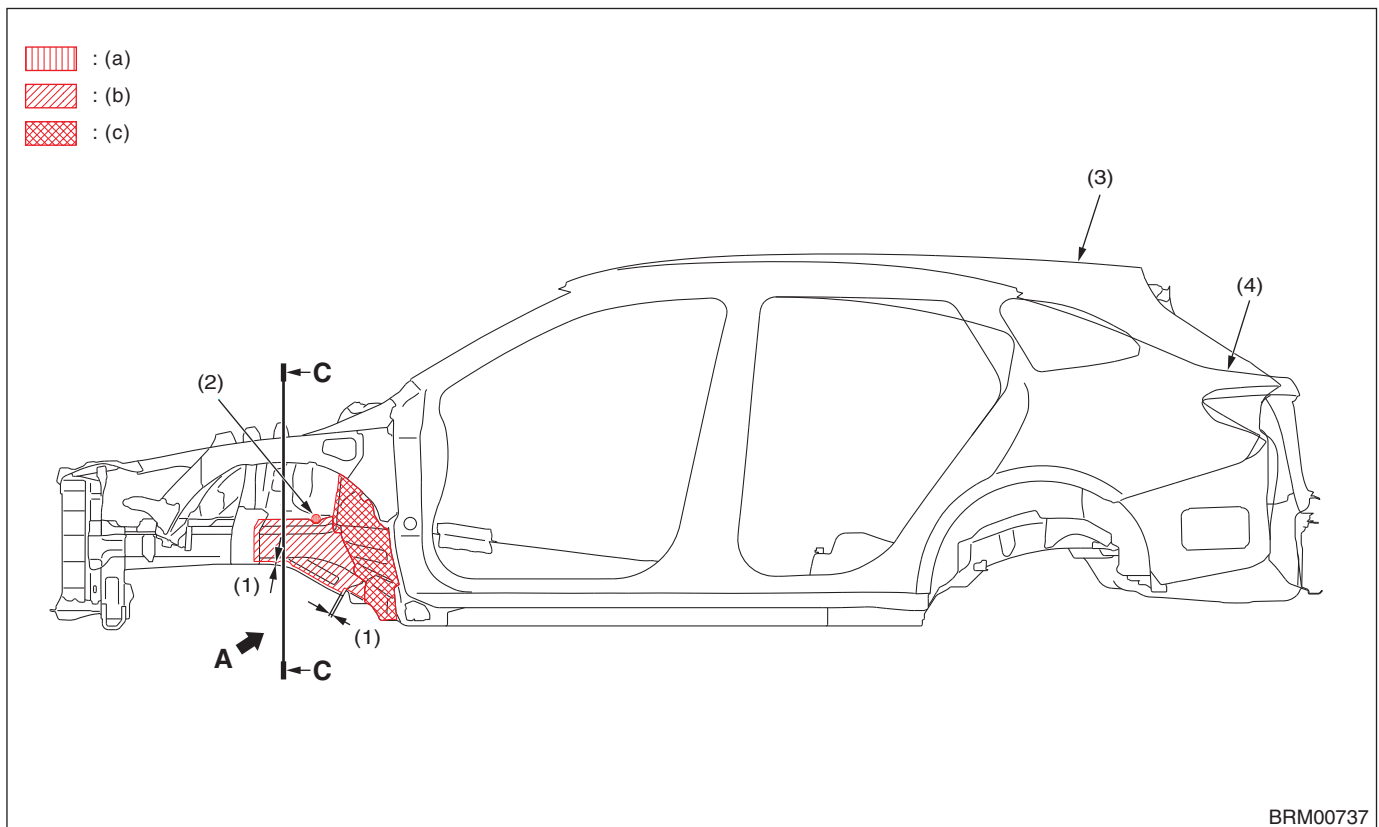
Be careful not to let the undercoating be attached to any parts not indicated below and to the following locations.

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

1) Application area and application thickness

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

- Side view



(a) 200 μm or more

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

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

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

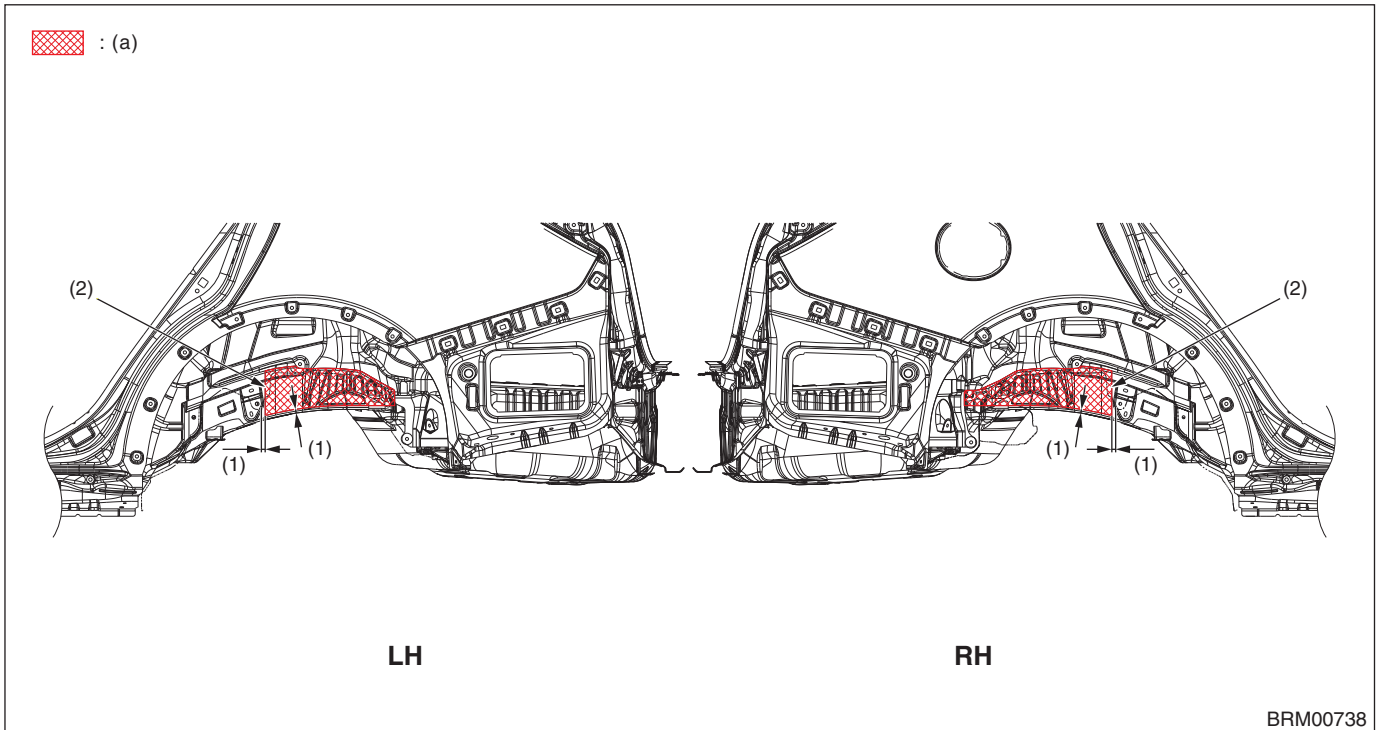
(3) OUTBACK

(4) SEDAN

(2) Cover the grommet seat with the PVC.

Undercoat

- Rear wheel apron side view



BRM00738

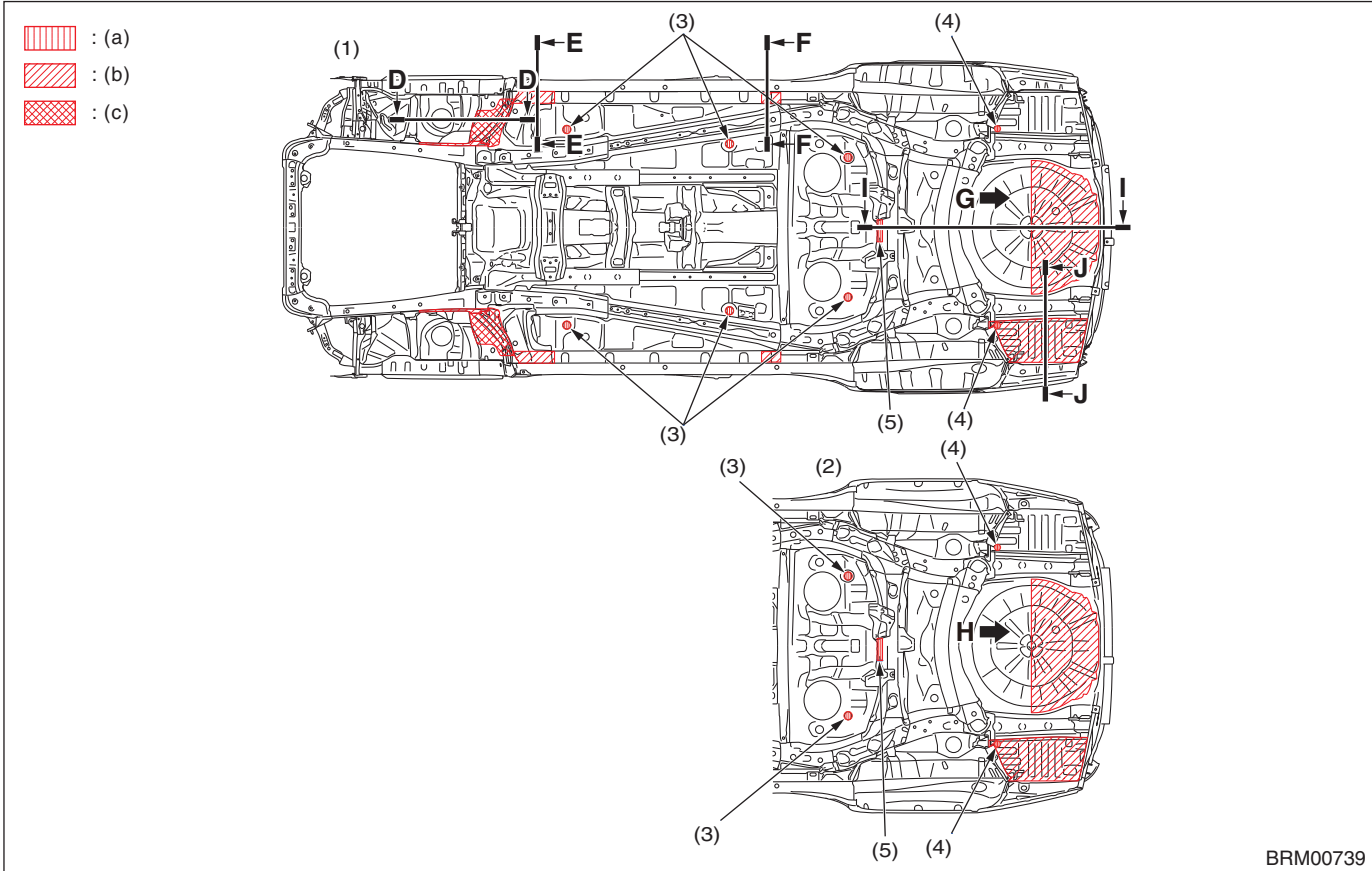
(a) Dry: 780 μm or more,
Wet: 630 μm or more

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

(2) Only OUTBACK

Undercoat

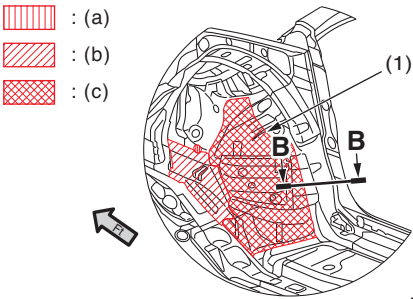
- Bottom view



BRM00739

- | | | |
|-------------------------------|---|---|
| (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 | (3) Cover the plug with PVC. | (5) Apply PVC to the air pocket area. |
| (2) SEDAN | (4) Cover the grommet seat with the PVC. | |

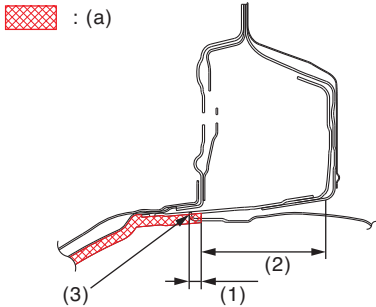
View A



BRM00740

- | |
|--|
| (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) Mudguard F trim line |

Cross section B — B



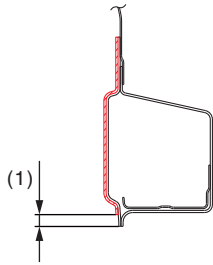
BRM00741

- | |
|--|
| (a) Dry: 780 μm or more, Wet: 630 μm or more |
| (1) 10 mm (0.39 in) |
| (2) Adherence of mist is allowable |
| (3) Mudguard F trim line |

Undercoat

Cross section C — C

 : (a)



BRM00742

- (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)

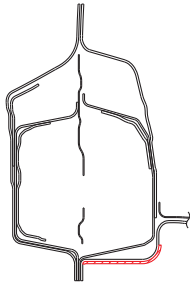


BRM00743

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

Cross section E — E (turned 90° to the left)

 : (a)

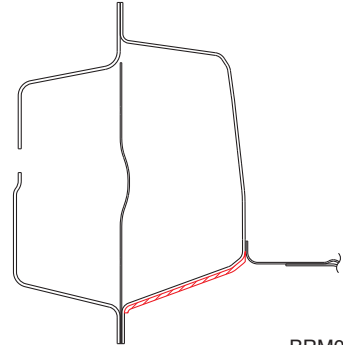


BRM00744

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

Cross section F — F (turned 90° to the left)

 : (a)

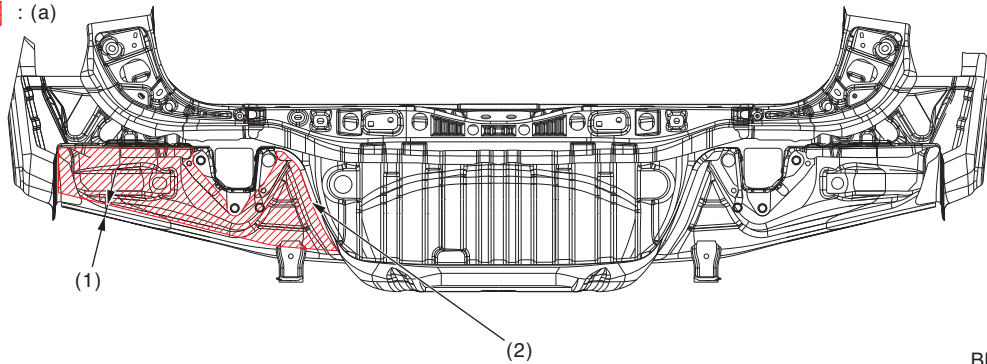


BRM00745

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

View G (turned 90° to the right)

 : (a)



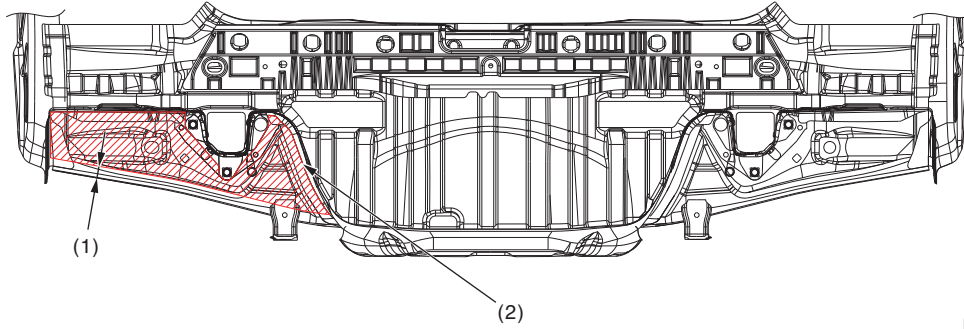
BRM00746

- (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)

Undercoat

View H (turned 90° to the right)

 : (a)



BRM00747

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

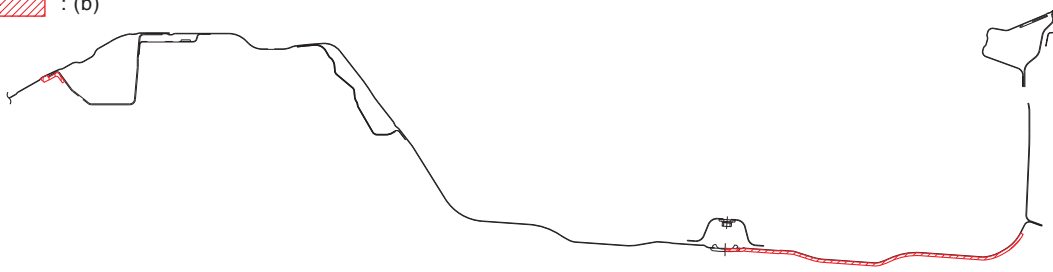
(1) 20 mm (0.78 in) (Adherence of mist is allowable)

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

Cross section I — I

 : (a)

 : (b)



BRM00748

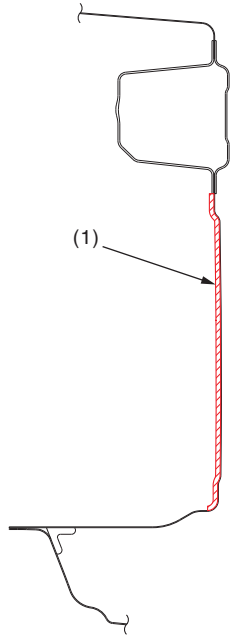
(a) 200 μm or more

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

Undercoat

Cross section J — J

 : (a)



BRM00749

(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)

SUBARU.

Damping Seat

12. Damping Seat

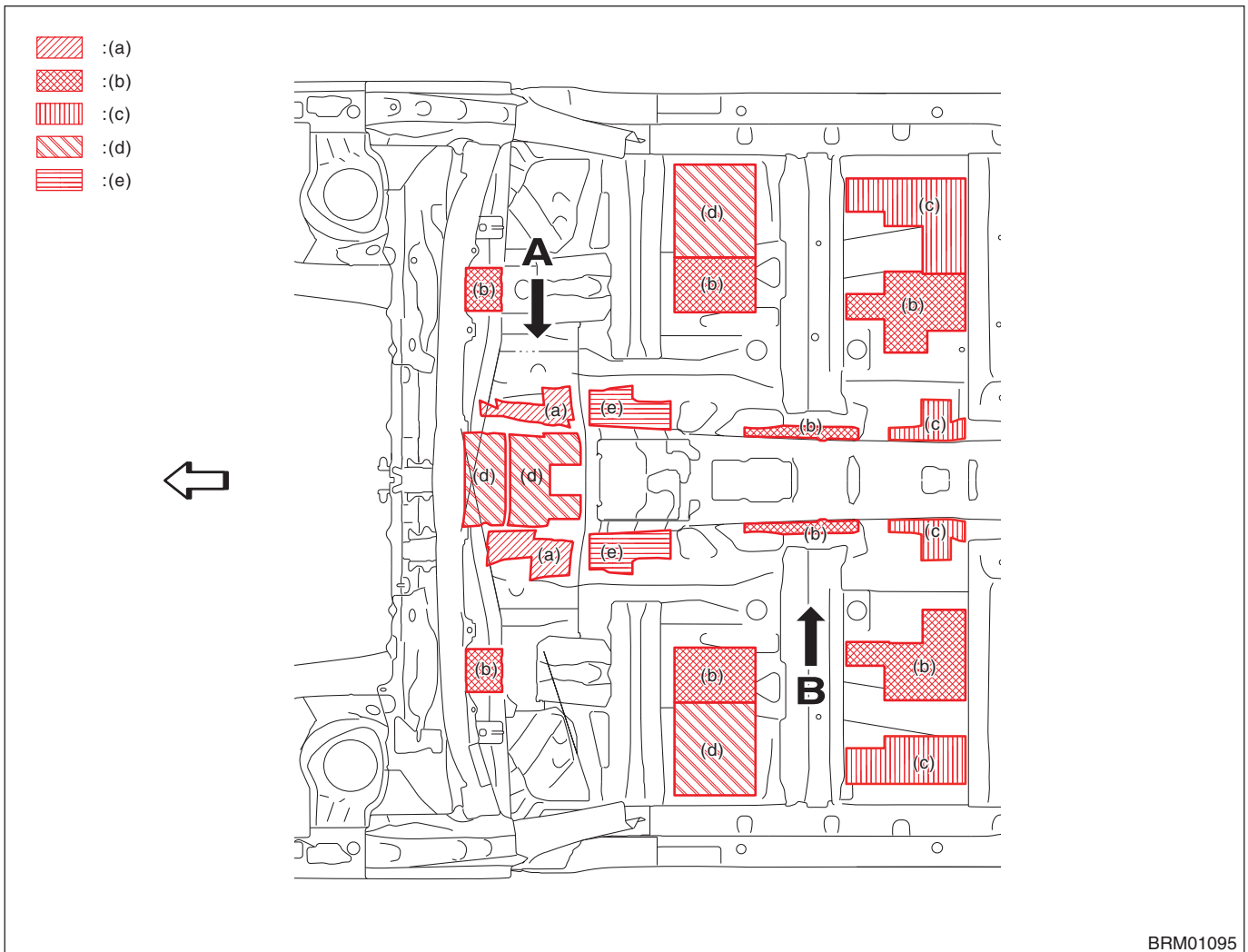
A: SPECIFICATIONS

CAUTION:

- When the silencer thickness does not meet the standard value, laminate the silencer until its thickness meets the standard.

1. COMMON PARTS FOR OUTBACK AND SEDAN

- Upper view 1



Thickness of the silencer

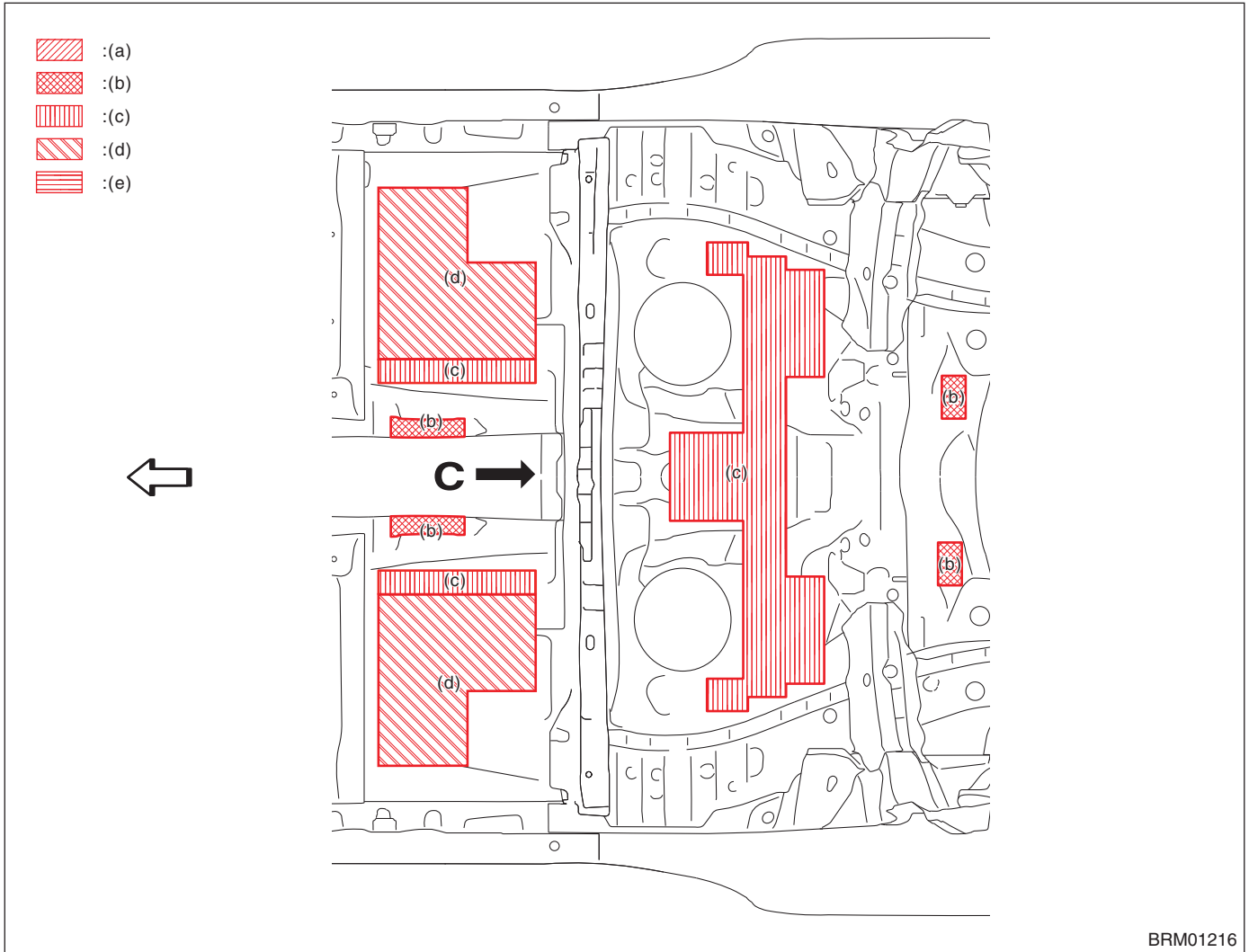
(a) 2.5 mm [0.10 in]
(b) 2.5 mm [0.10 in]

(c) 2.5 mm [0.10 in]
(d) 2.5 mm [0.10 in]

(e) 2.5 mm [0.10 in] + 2.5 mm [0.10 in]

Damping Seat

• Upper view 2



Thickness of the silencer

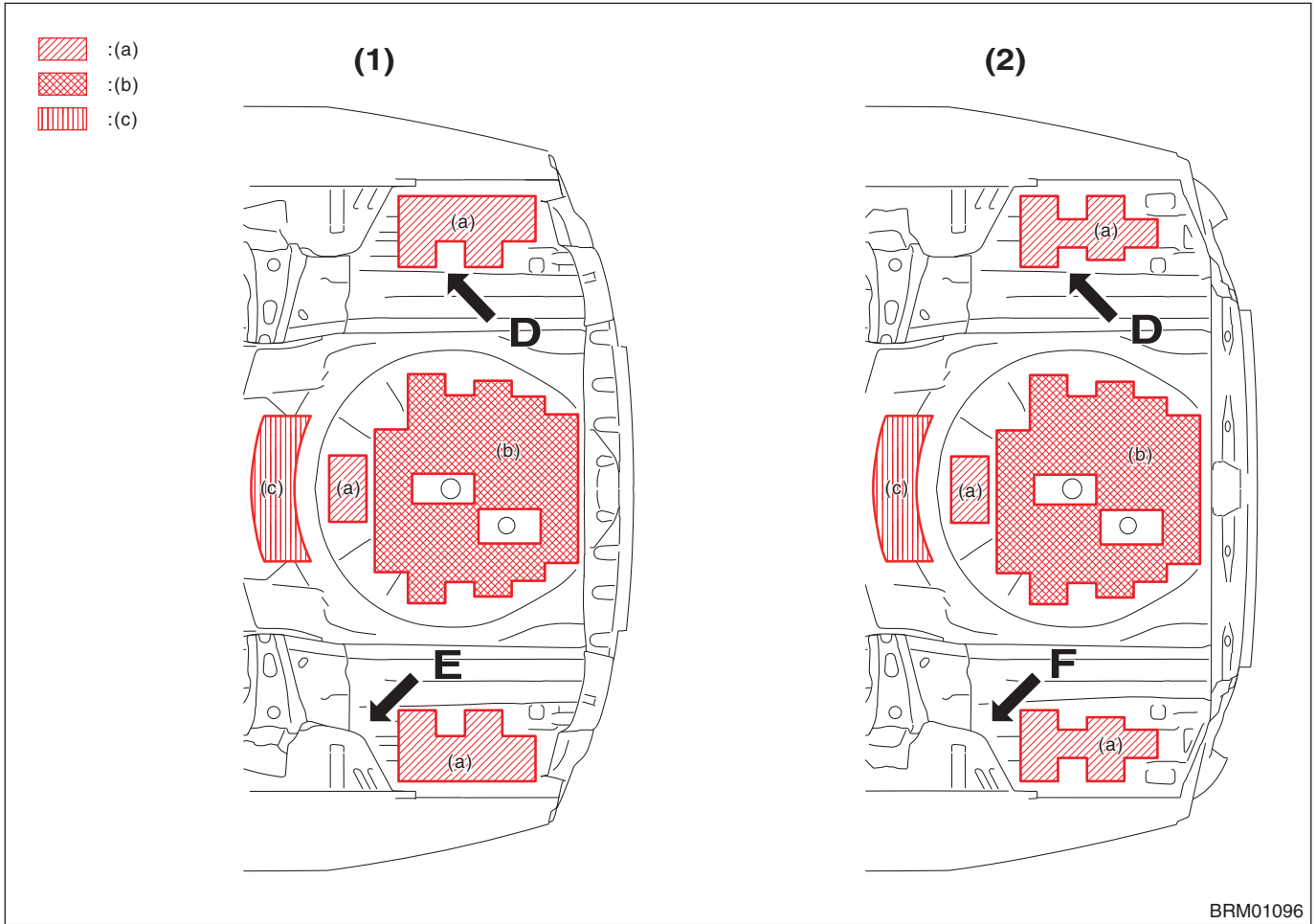
(a) 2.5 mm [0.10 in]
(b) 2.5 mm [0.10 in]

(c) 2.5 mm [0.10 in]
(d) 2.5 mm [0.10 in]

(e) 2.5 mm [0.10 in] + 2.5 mm [0.10 in]

Damping Seat

• Rear top view



(1) OUTBACK

(2) SEDAN

Thickness of the silencer

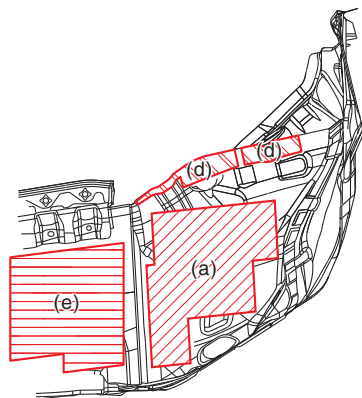
(a) 2.5 mm [0.10 in]

(b) 2.5 mm [0.10 in]

(c) 2.5 mm [0.10 in]

View A (turned 180°)


- : (a)
- : (d)
- : (e)

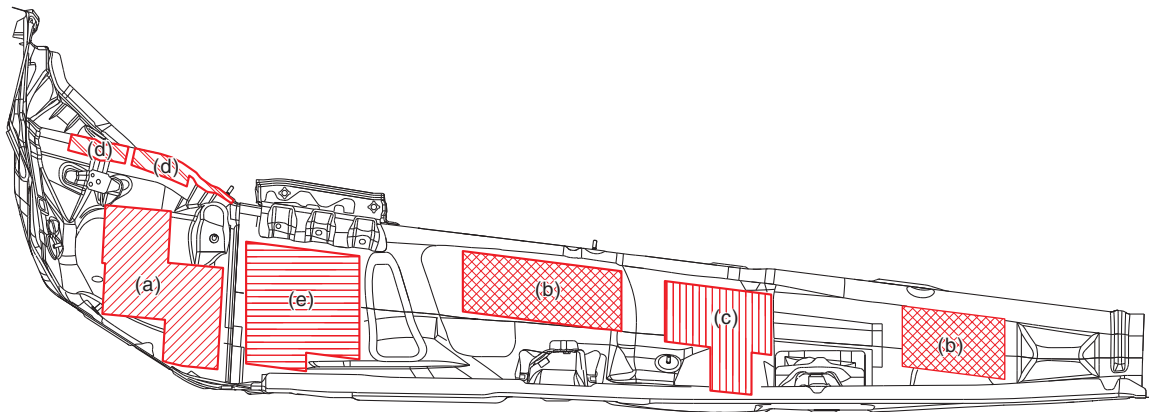


SUBARU.

Damping Seat

View B

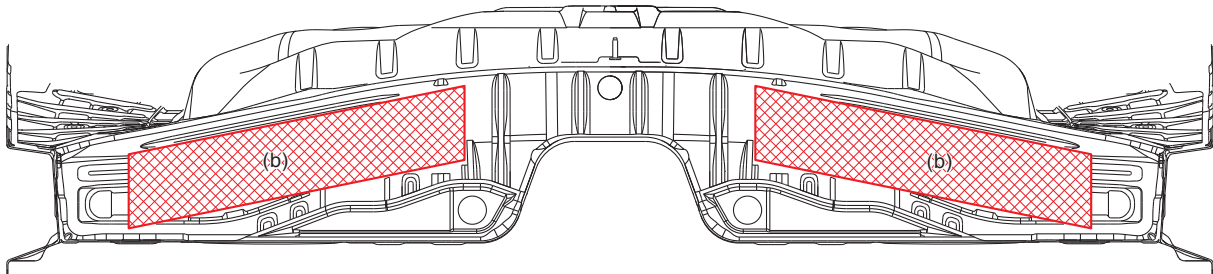
-  : (a)
-  : (b)
-  : (c)
-  : (d)
-  : (e)



BRM01098

View C (turned 90° to the left)

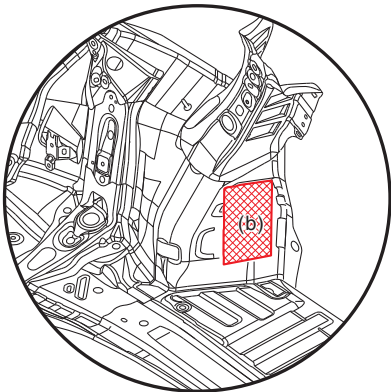
-  : (b)



BRM01099

View D

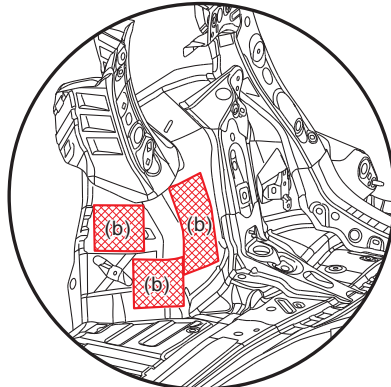
-  : (b)



BRM01100

View E (OUTBACK)

-  : (b)

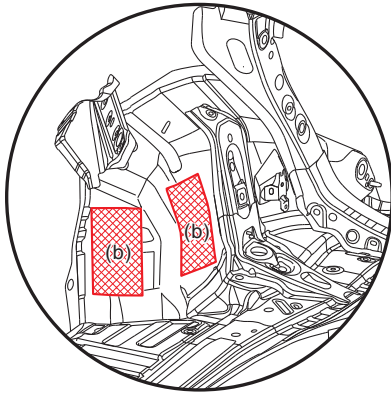


BRM01101

Damping Seat

View F (SEDAN)

 : (b)



BRM01102

SUBARU.

Thickness of the silencer

(a) 2.5 mm [0.10 in]

(b) 2.5 mm [0.10 in]

(c) 2.5 mm [0.10 in]

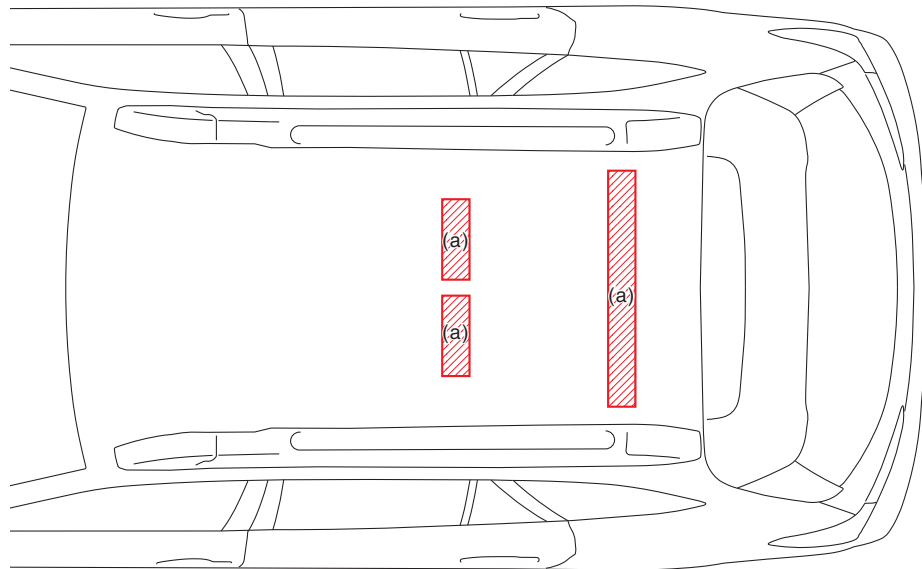
(d) 2.5 mm [0.10 in]

(e) 2.5 mm [0.10 in] + 2.5 mm [0.10 in]

2. SPECIAL OUTBACK PARTS

• Upper view

 : (a)



BRM01103

Thickness of the silencer

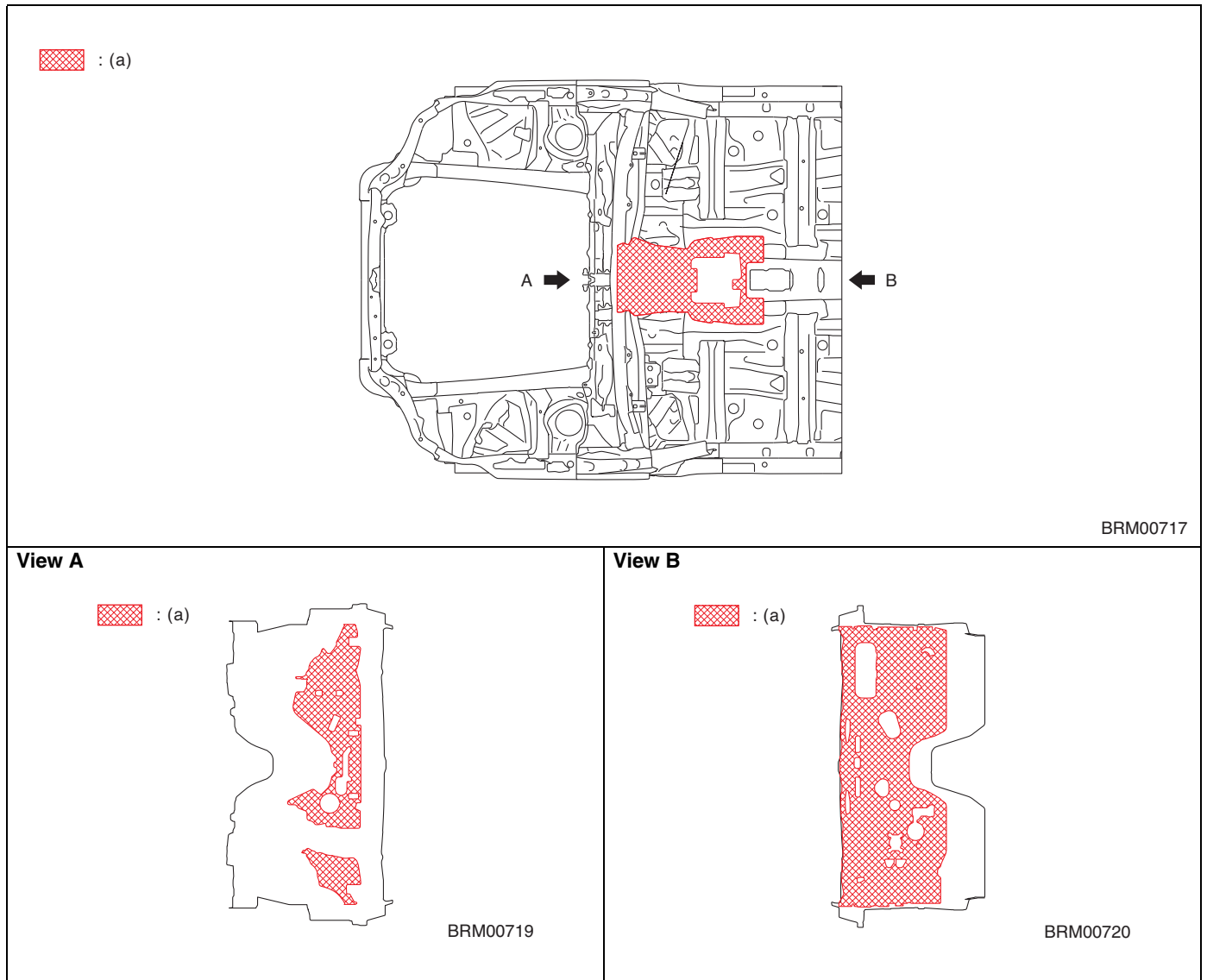
(a) 2.5 mm [0.10 in]

Insulator

13. Insulator

A: SPECIFICATIONS

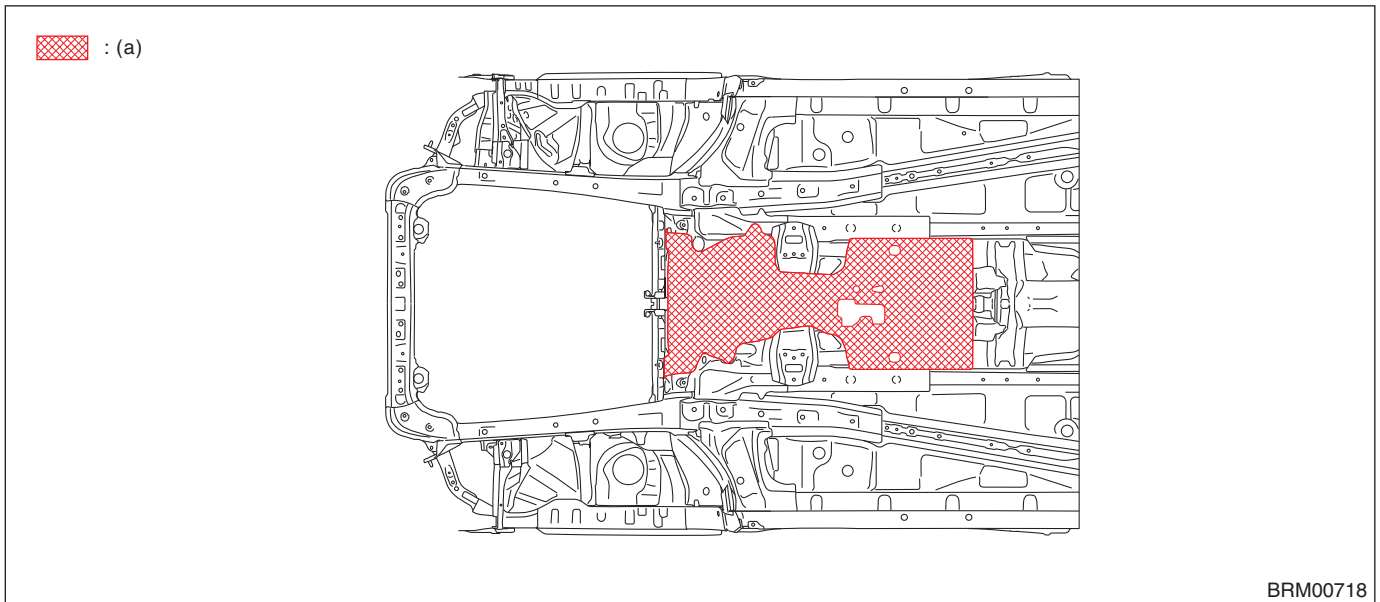
1. Upper view



(a) Insulator

Insulator

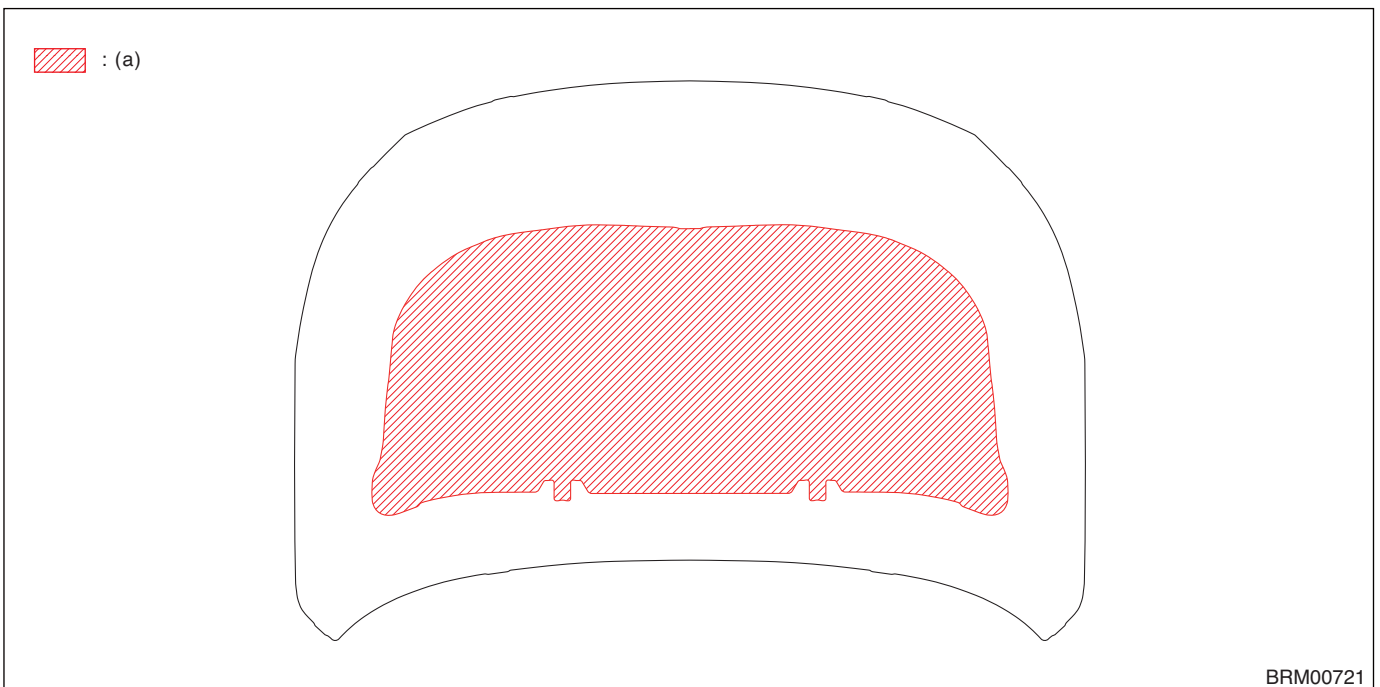
2. Bottom view



(a) Insulator

3. Front hood

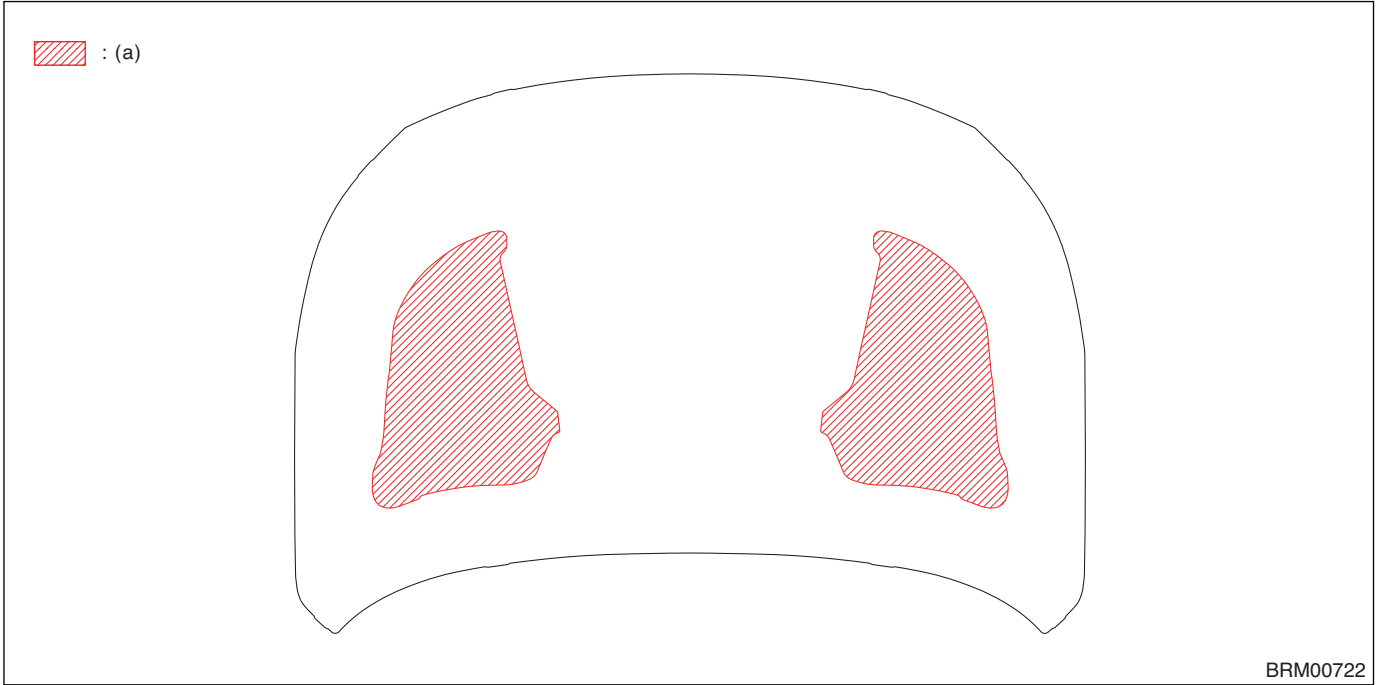
• Non-turbo model



(a) Insulator

Insulator

- Turbo Model



BRM00722

(a) Insulator

14. Plastic Parts and Materials

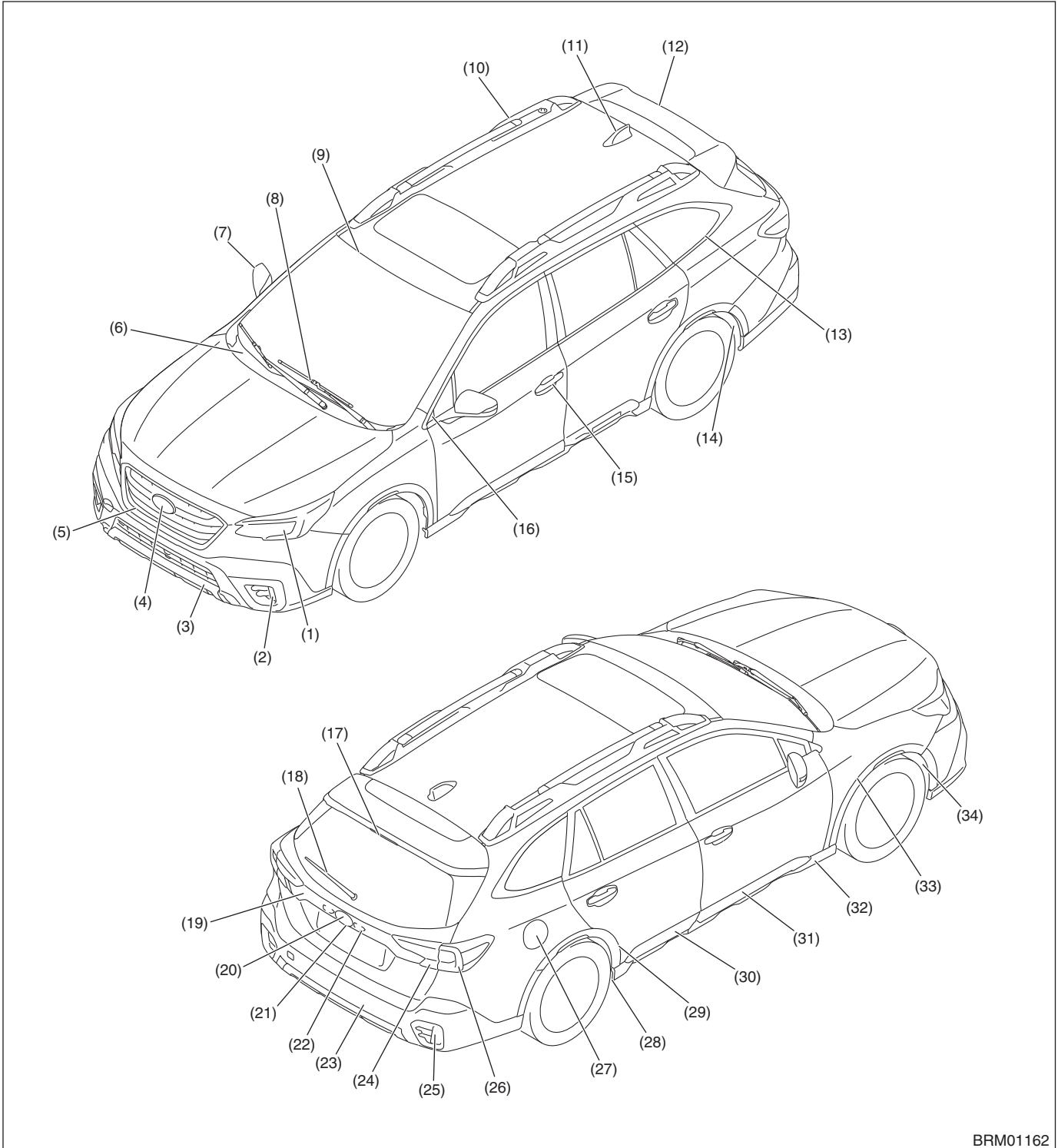
A: SPECIFICATIONS

Note:

The following illustration is a typical example.

The shape and material may vary with some models.

1. SPECIAL OUTBACK PARTS AND COMMON PARTS FOR OUTBACK & SEDAN



BRM01162

Plastic Parts and Materials

(1) Headlight	(13) Rear quarter molding	(25) Reflex reflector
(2) Front fog light	(14) Rear mudguard	(26) Rear combination light
(3) Front bumper	(15) Door handle	(27) Fuel flap
(4) Ornament front	(16) A pillar cover	(28) Plate air flap rear
(5) Front grill	(17) High mount stop light	(29) Rear quarter garnish
(6) Cowl panel	(18) Rear wiper	(30) Rear door garnish
(7) Door mirror	(19) Rear gate garnish	(31) Front door garnish
(8) Front wiper	(20) Ornament rear	(32) Side sill garnish
(9) Front window molding	(21) Rear gate opener switch	(33) Fender garnish
(10) Roof rail	(22) License light	(34) Front mudguard
(11) Antenna	(23) Rear bumper	
(12) Roof spoiler	(24) Rear finisher light	

No	Part name	Material	
(1)	Headlight	Outer lens	PC
		Housing	PP-TD30
		Extension A	PBT
		Extension B	PBT
		Reflector (turn light)	PPS-MD20
		Inner lens A	PC
		Inner lens B	PC
		Inner lens C	PC
		Inner lens D	PC
		Side R/R	PMMA
		PES cover	PC
		Base A	PP-TD20
		Base B	PP-TD20
		PES bracket	PAMXD6-GF50
Hood seal rubber	EPDM		
(2)	Front fog light	Lens	PC
		Housing	PP-TD30
		Reflector	PC
		Bracket	PC
		Retainer	PP-TD30
(3)	Front bumper	Face	PP
		Hook cover	PP
		Intake cover	PP
		Bumper cover	PP
		Bumper guard	PP
		Sealing bumper	EPDM
		Arch garnish	PP
		EA form	PP
		Corner bracket	PP-GF30
		Side bracket	POM
		Center lower bracket	PP
		Upper cover	PP
(4)	Ornament front	Base	ABS
		Ornament	PMMA
(5)	Front grill	Base	ASA
		Molding (ring)	ABS
		Molding (wing)	ABS
		Cover (center)	ASA

Plastic Parts and Materials

No	Part name		Material	
(6)	Cowl panel	Cowl panel	PP-TD10	
		Cowl panel side	PP-TD10	
		Cover joint	PBT	
(7)	Door mirror	Body	ASA	
		Body cover	Paint	ASA
			Plating	ABS
		Cover cap, outside	ASA	
		Cover stay A	ASA	
		Cover stay B	ASA	
		Cover stay C	ASA+TPO	
		Cover stay D	ABS	
		Cover stay cap	ASA	
		Packing stay A	EPDM	
		Packing stay B	EPDM	
		Packing stay	TPO	
		Packing support	PA	
		Flange	ABS	
		Side turn light	Housing	ABS
Lens	PMMA			
Inner lens	PMMA			
(8)	Wiper	Sleeve (collar)	PP	
		Sleeve (pivot)	POM	
		Cushion	EPDM	
	Arm	Arm joint area	PBT	
		Blade joint area	PBT-GF45	
		Blade	PP+ELASTOMER	
Cover	PC			
(9)	Front window molding	Molding	PVC	
(10)	Roof rail	Cover	TPE	
		Front molding	TPE	
		Cap	PA6	
		Support bump rubber	EPDM	
		Bolt holder	PA6-GFM40	
(11)	Antenna		PC+ASA	
(12)	Roof spoiler	Roof spoiler center	AES	
		Roof spoiler side	AES	
(13)	Rear quarter molding	Molding	PVC	
		Dam rubber	EPDM	
(14)	Rear mudguard	Body	PET+PP	
(15)	Door handle	Frame handle, outer	PA6-GF30	
		Handle, outer	PC+PBT	
		Cover handle, outer	PC+PBT	
(16)	A pillar cover	Body	No painting	AES
			Painted	ABS
(17)	High mount stop light	Lens	PMMA	
		Housing	ABS	
(18)	Rear wiper	Wiper arm rear	PET-GF45	
		Blade	PBT-GF30	
		Head cover	PBT	

Plastic Parts and Materials

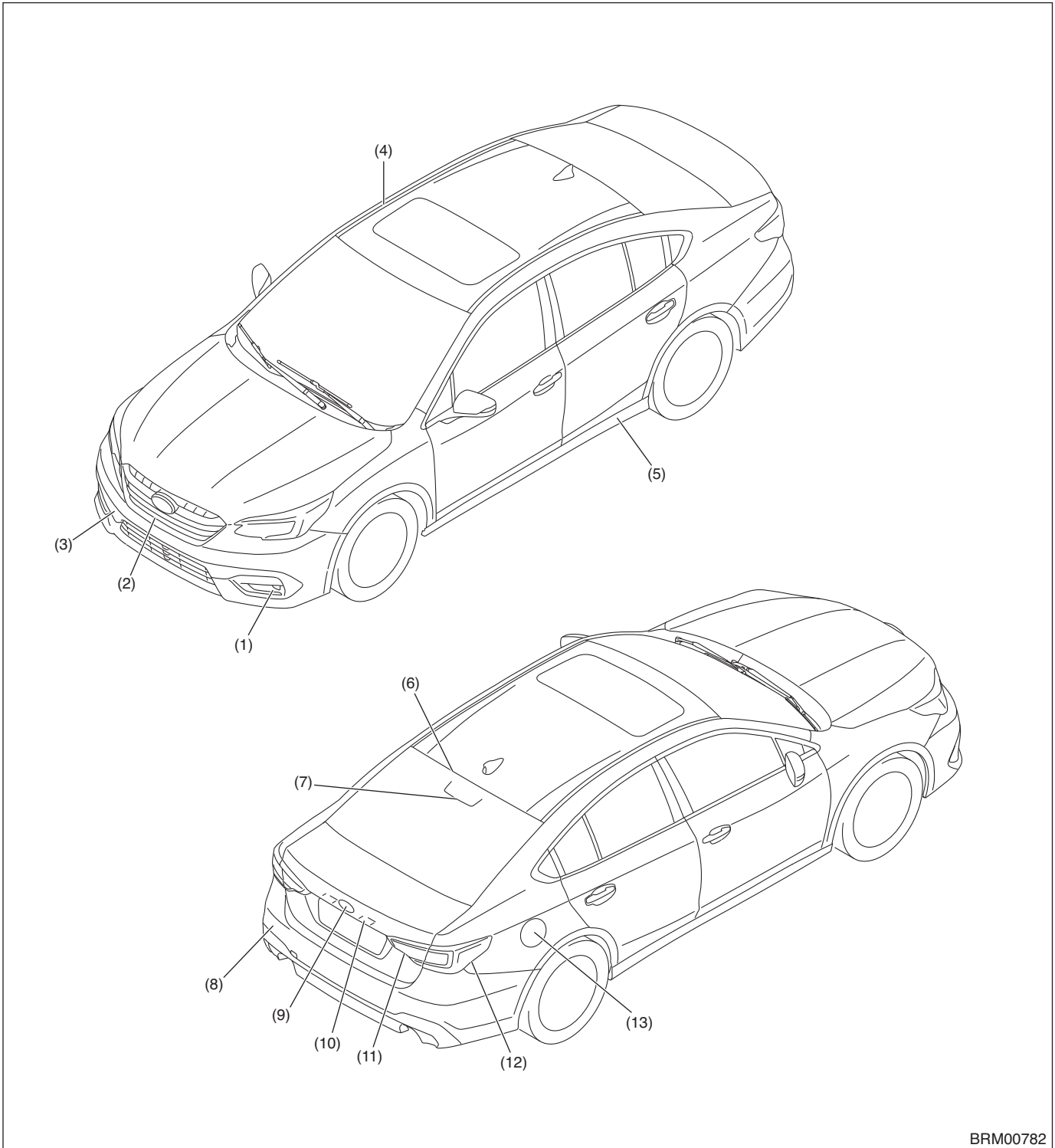
No	Part name	Material	
(19)	Rear gate garnish	Garnish outer	PC+PET
		Garnish lower	ASA
		Garnish inner upper	PC+PET
		Garnish inner lower	PC+PET
		Protector upper	EPDM
		Protector lower side	TPO
		Protector lower center	TPO
		Bracket upper	PC+PET
(20)	Ornament rear	Ornament rear	PMMA
		Base	ABS
(21)	Rear gate opener switch	Plastic part of request switch	PP-F35
(22)	License light	Lens	PMMA
		Housing	PC
		Spacer	POM
		Gasket	SUPER SHEET
(23)	Rear bumper	Face	PP
		Rear guard	PP
		Arch garnish rear	PP
		Bracket corner rear	PP-GF30
		Bracket side rear	POM
		Cover hook rear	PP
		Cover side lower	PP
(24)	Rear finisher light	Outer lens	PMMA
		Inner lens back	PMMA
		Inner lens tail	PMMA
		Light guard	PMMA
		Reflector	PBT
		Extension	PC
		Housing	ASA
(25)	Reflex reflector	Lens	PMMA
		Housing	ASA
(26)	Rear combination light	Outer lens	PMMA
		Inner lens turn	PC
		Inner lens tail & stop	PMMA
		Inner lens side R/R	PMMA
		Reflector	PBT
		Extension	PC
		Light guide	PMMA
		Housing	ASA
(27)	Fuel flap	PPE+PA	
(28)	Plate air flap rear	PP+EPDM	
(29)	Rear quarter garnish	PP	
(30)	Rear door garnish	PP	
(31)	Front door garnish	PP	
(32)	Side sill garnish	PP	
(33)	Fender garnish	PP	
(34)	Front mudguard	Mudguard	PE
		Plate air flap	PP+EPDM
		Guide mudguard	PP

Plastic Parts and Materials

No	Part name	Material
Under cover	Under cover front	PP
	Cover duct	PP
	Under cover rear	PET
Splash board		TPO

Plastic Parts and Materials

2. SPECIAL SEDAN PARTS



BRM00782

- | | | |
|---------------------|---|-----------------------------|
| (1) Front fog light | (6) Rear window molding | (11) Rear finisher light |
| (2) Front grill | (7) High mount stop light (Indoor type) | (12) Rear combination light |
| (3) Front bumper | (8) Rear bumper | (13) Fuel flap |
| (4) Roof molding | (9) Ornament rear | |
| (5) Side spoiler | (10) License light | |

Plastic Parts and Materials

No	Part name		Material	
(1)	Front fog light	Lens	PC	
		Housing	PC	
		Reflector	PC	
		Bracket	PP-GF40	
(2)	Front grill	Base	ASA	
		Molding (wing)	ABS	
		Cover (side)	PP	
		Cover (center)	ASA	
(3)	Front bumper	Face	PP	
		Intake cover	PP	
		Fog light cover	PP	
		Sealing bumper	EPDM	
		EA form	PP	
		Corner bracket	PP-GF30	
		Side bracket	POM	
		Center lower bracket	PP	
		Upper cover	PP	
(4)	Roof molding	Body	PVC	
		End cap	POM	
		Carrier cap	Lid	AES
			Base	POM
(5)	Side spoiler		PP	
(6)	Rear window molding	Molding rear	PVC	
(7)	High mount stop light (Indoor type)	Lens	PC	
		Housing	PP-T20+TPO	
		Cover	PP-TD16	
(8)	Rear bumper	Face	PP	
		Hook cover	PP	
		Cover muffler	PP	
		EA form rear	PP	
		Side bracket	POM	
		Corner bracket	PP-GF30	
		Cover side lower	PP	
(9)	Ornament rear	Ornament	PMMA	
		Base	ABS	
(10)	License light	Lens	PMMA	
		Housing	PC	
		Packing	SUPER SHEET	
(11)	Rear finisher light	Outer lens	PMMA	
		Housing	ASA	
		Inner lens	PMMA	
		Extension	PC	
		Light guide	PMMA	
		Reflector	PBT	
		Finisher packing	SUPER SHEET	

Plastic Parts and Materials

No	Part name	Material
(12)	Outer lens	PMMA
	Inner lens	PMMA
	Side reflex reflector	PMMA
	Reflector	PBT
	Light guide	PMMA
	Extension	PC
	Housing	ASA
(13)	Fuel flap	PPE+PA

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)	POM	Polyacetal
AES	Acrylonitrile/Ethylene/Styrene	PP	Polypropylene
ASA	Acrylonitrile/Styrene/Acrylate	PP-F35	Polypropylene (35 % inorganic filler)
ELASTOMER	Elastomer	PP-GF30	Polypropylene (30 % glass fiber)
EPDM	Ethylene/Propylene/Diene rubber	PP-GF40	Polypropylene (40 % glass fiber)
PA	Polyamide (nylon)	PP-T20	Polypropylene (20 % talc)
PA6	Polyamide (nylon6)	PP-TD10	Polypropylene (10 % talc)
PA6-GF30	Polyamide (nylon6) (30 % glass fiber)	PP-TD16	Polypropylene (16 % talc)
PA6-GFM40	Polyamide (nylon6) (40 % glass fiber / mineral powder)	PP-TD20	Polypropylene (20 % talc)
PAMXD6-GF50	Polymetaxyleneadipamide (nylon MXD6) (50 % glass fiber)	PP-TD30	Polypropylene (30 % talc)
PBT	Polybutylene terephthalate	PPE	Polyphenylene ether
PBT-GF30	Polybutylene terephthalate (30 % glass fiber)	PPS	Polyphenylene sulfide
PBT-GF45	Polybutylene terephthalate (45 % glass fiber)	PPS-MD20	Polyphenylene sulfide (20 % mineral powder)
PC	Polycarbonate	PVC	Polyvinyl chloride
PE	Polyethylene	SUPER SHEET	Super sheet
PET	Polyethylene terephthalate	TPE	Thermoplastic elastomer
PET-GF45	Polyethylene terephthalate (45 % glass fiber)	TPO	Thermo polyolefin
PMMA	Polymethyl methacrylate		