BODY REPAIR MANUAL

BS

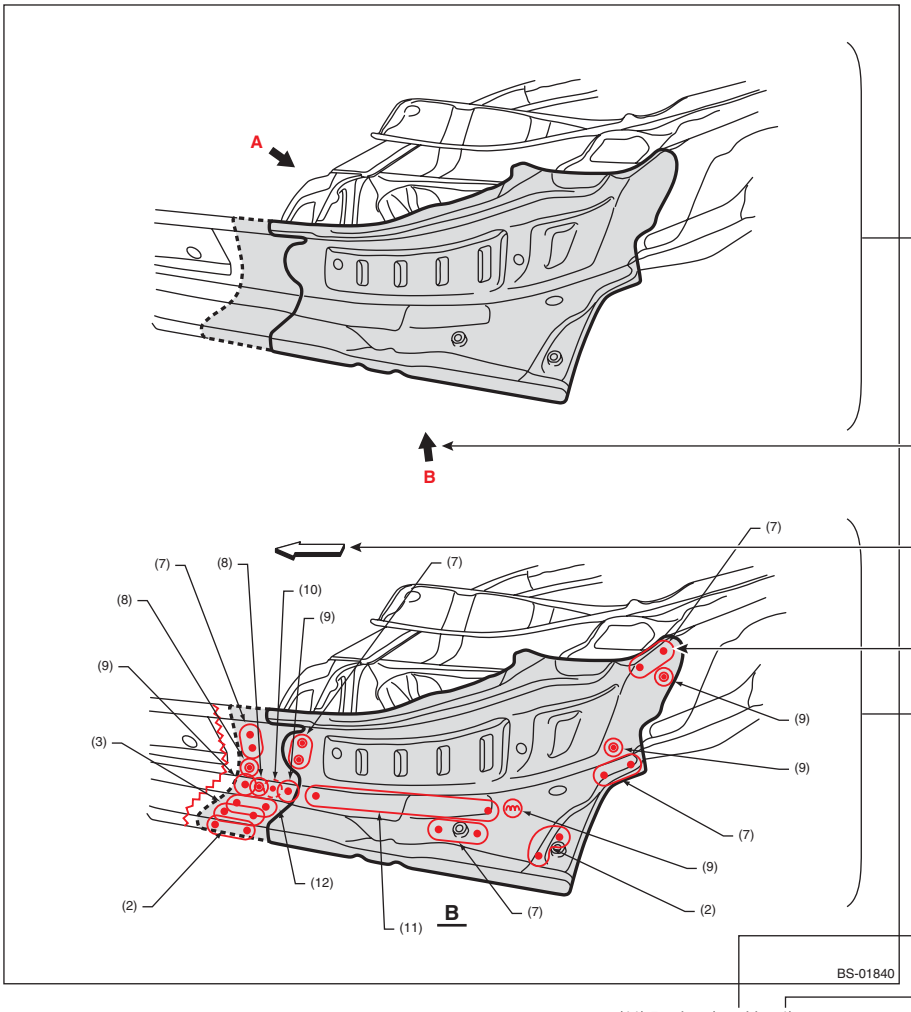
1. Foreword

A: USE OF THIS MANUAL

This manual explains important points for removal and installation of parts per location.

1. ILLUSTRATION EXAMPLE

- Symbols and number of points indicate the welding method and the number of welding points.Text in brackets indicate the direction of removal for welded parts, and numbers indicate the number of panels to be drilled to remove welded sections of panels.
- Areas enclosed by a broken line indicates work from the opposite side (rear side).
- Always apply anticorrosion wax to the welding locations when replacing panels.



(1) 9 points (top · 1)
(2) 3 points (outside · 1)
(3) 3 points (top · 1)
(4) 2 points (top · 1)
(5) Cut (290 mm) for ease of removal
(6) 2 points (inside · 1)
(7) 2 points (outside · 1)
(8) 1 point (outside · 2)
(9) 1 point (outside · 1)
(10) 1 point (outside · 1) hidden weld point
(11) 5 points (outside · 1)
(12) 3 points (bottom · 1)

• B view: to make removal easier, cut the side sill inner (reuse) and detatch one hiden hit point.

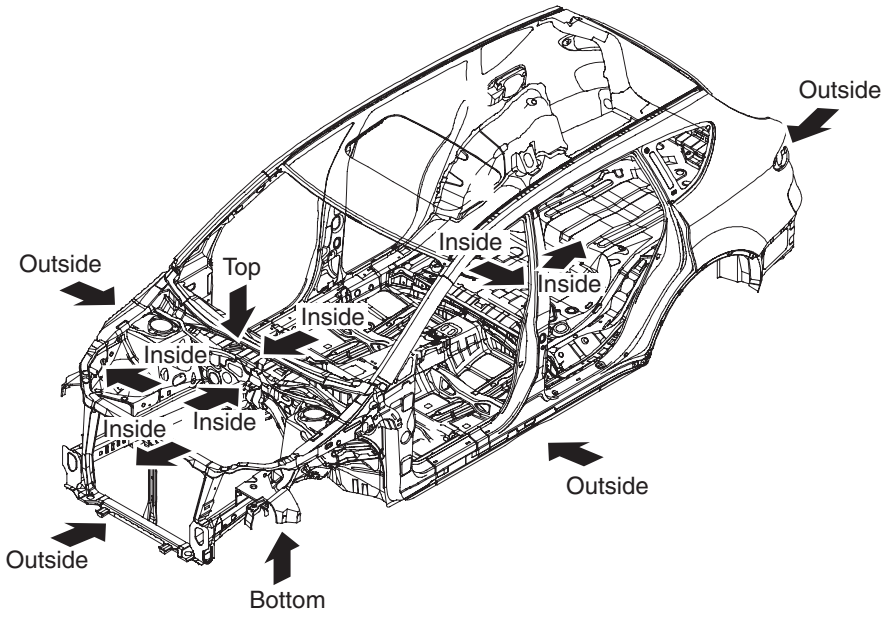
BS-02067

(1) Overall view
(2) Views
(3) Number of welding points etc.
(4) Removal direction
(5) Number of panels to be drilled
(6) Cautions when working, etc.

(A) Welding method
(B) View direction
(C) Towards front of vehicle

2. REMOVAL DIRECTION

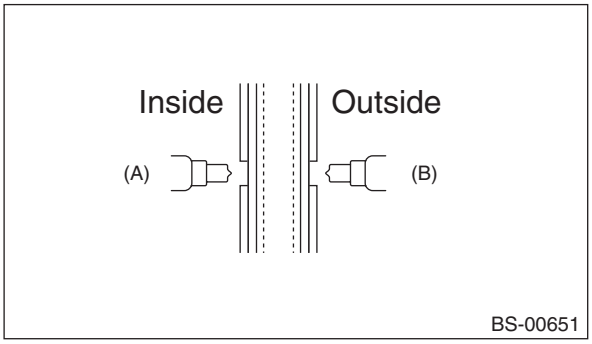
Areas are divided into four groups of inside, outside, top, and bottom, and these directions are defined as shown in the following figure.



3. NUMBER OF PANELS TO BE DRILLED

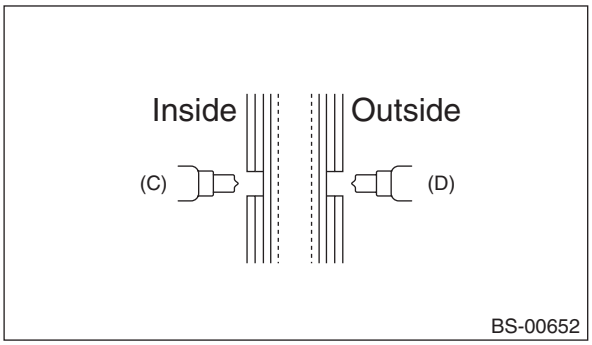
Depending on the number of panels, drilling is performed through one or two panels, and this is listed together with the removal direction.

(1) Drilling through one plate



(A) (Inside · 1)
(B) (Outside · 1)

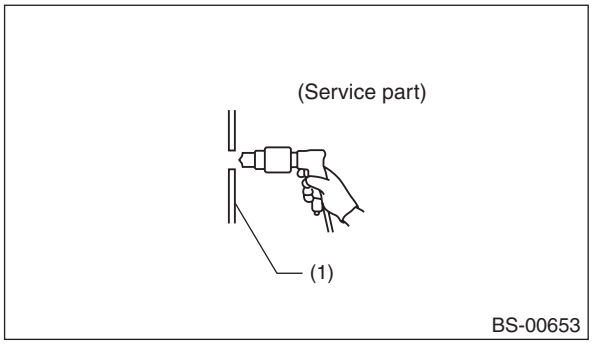
(2) Drilling through two plate



(C) (Inside · 2)
(D) (Outside · 2)

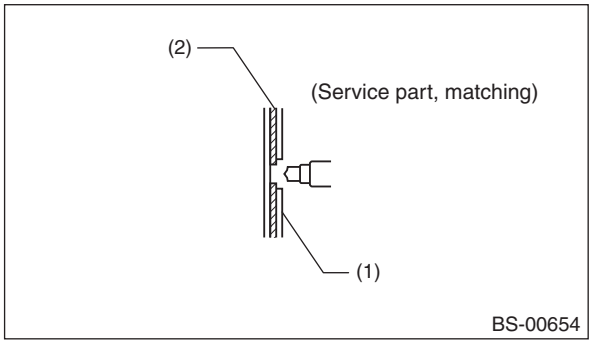
4. HOLE DRILLING FOR PLUG WELDING

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



(1) Service part

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

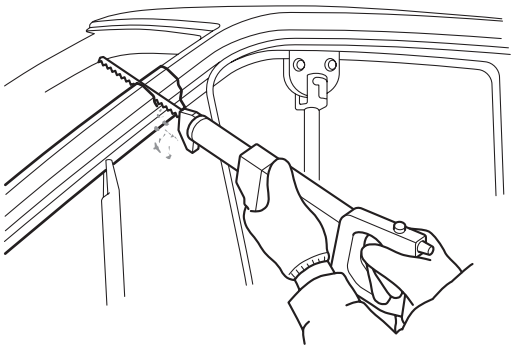


(1) Service part
(2) Vehicle side

5. MEANING OF SYMBOLS

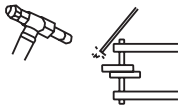
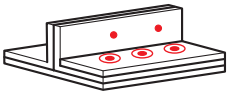
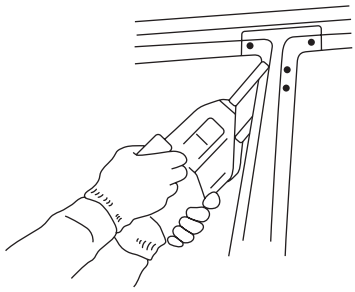
- **Cutting**

BS-00352

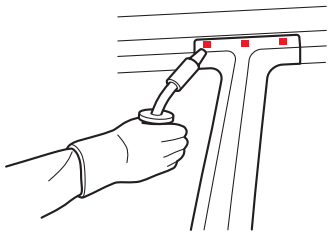
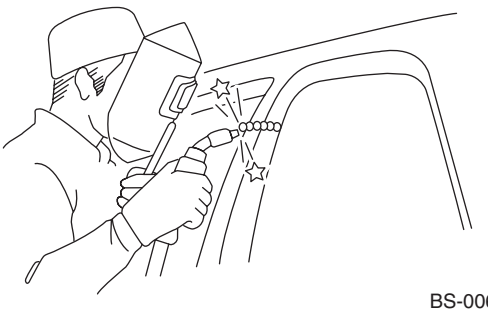


BS-00267

- **Spot welding**

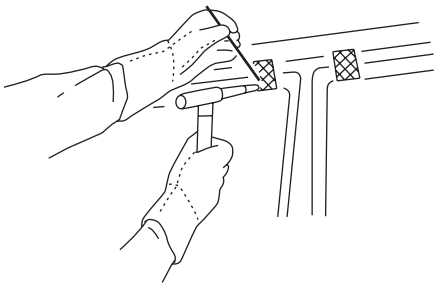
Two overlapping parts	 BS-00655	 BS-00656	 BS-00657	 BS-00658
Three overlapping parts or more	 BS-00659	 BS-00660		

- **Carbon dioxide gas arc welding (MIG welding)**

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

- **Brazing**

BS-00667

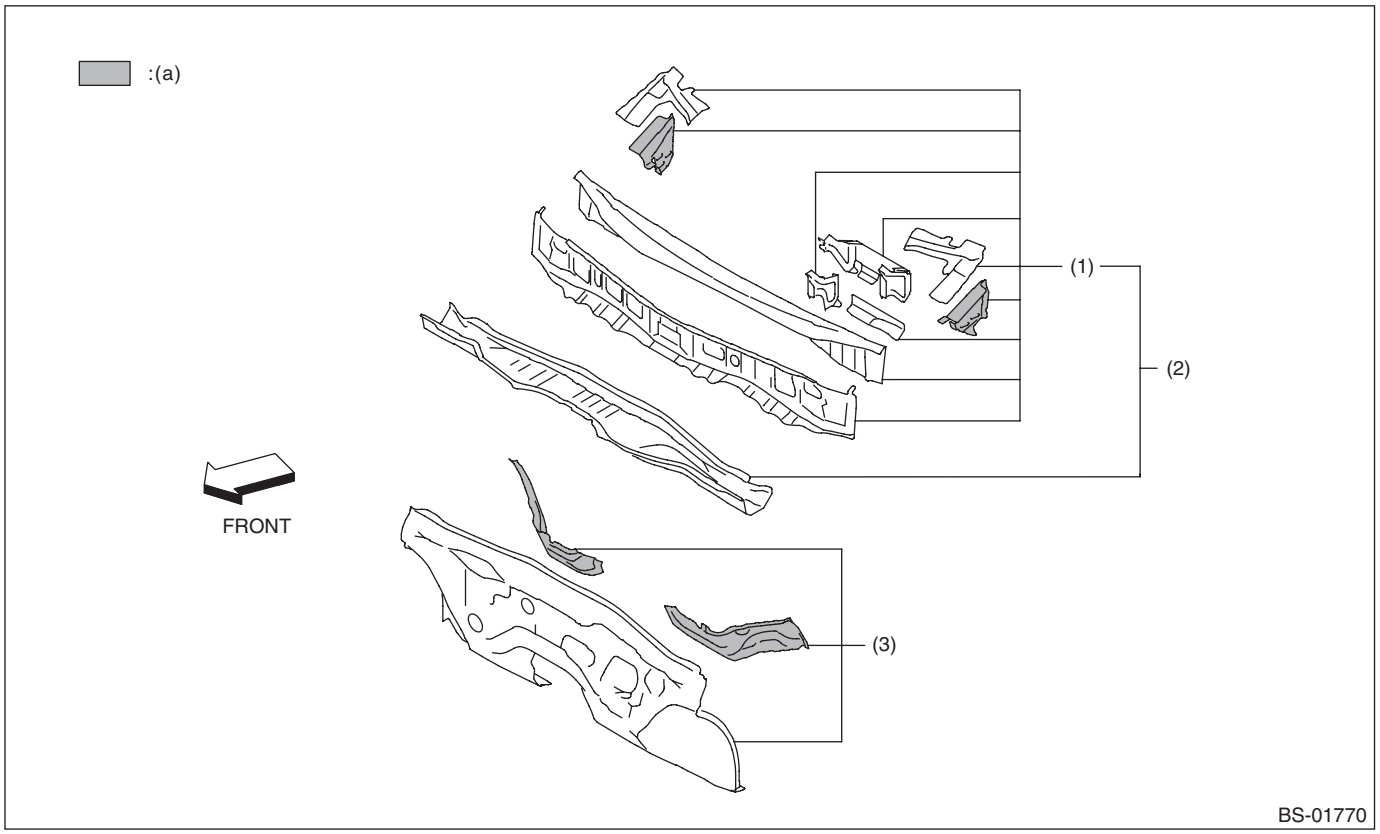


BS-00668

2. Panel Components

A: COMPONENTS

1. TOE BOARD & FRONT PANEL



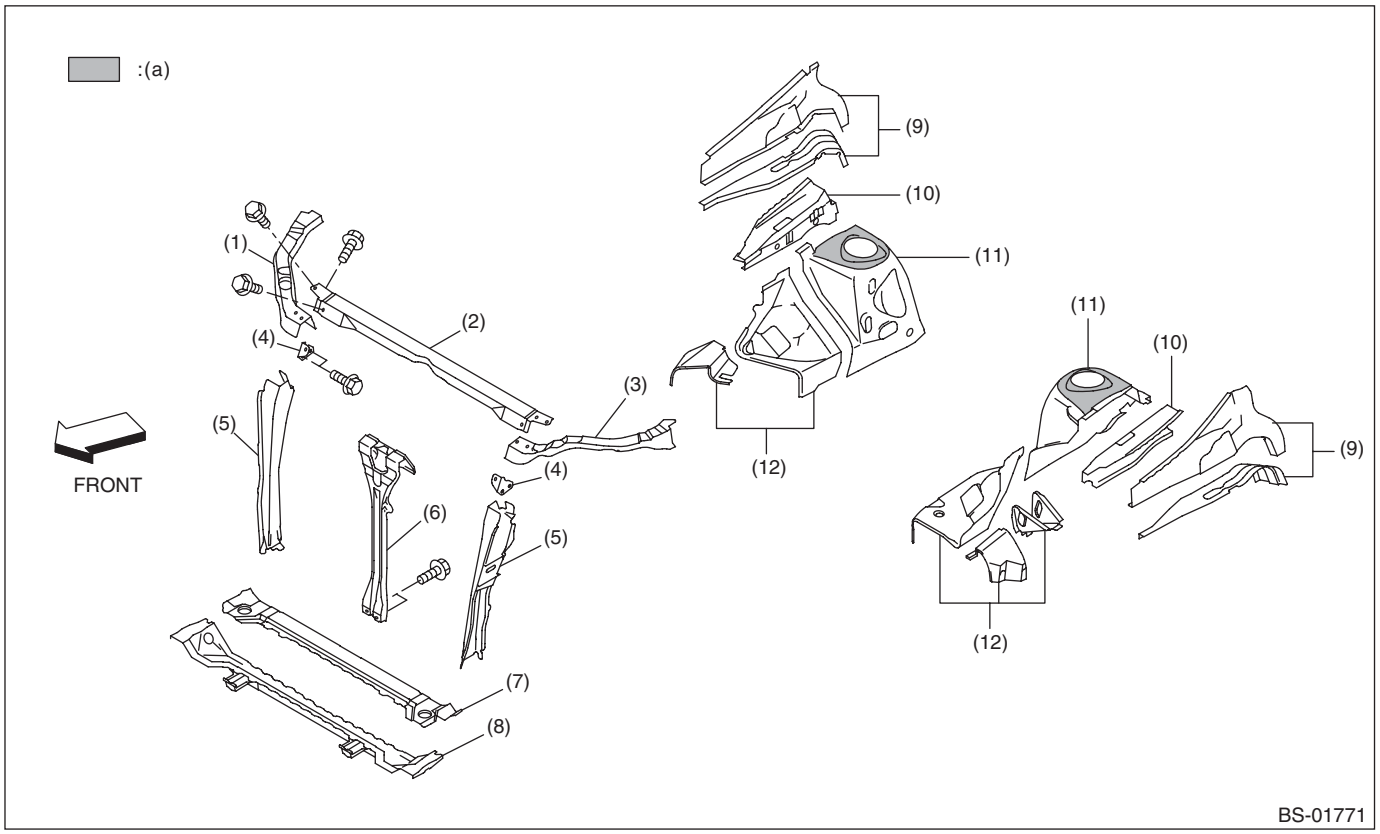
(a) High-strength steel

(1) Front panel

(2) Front panel and Duct

(3) Toe board

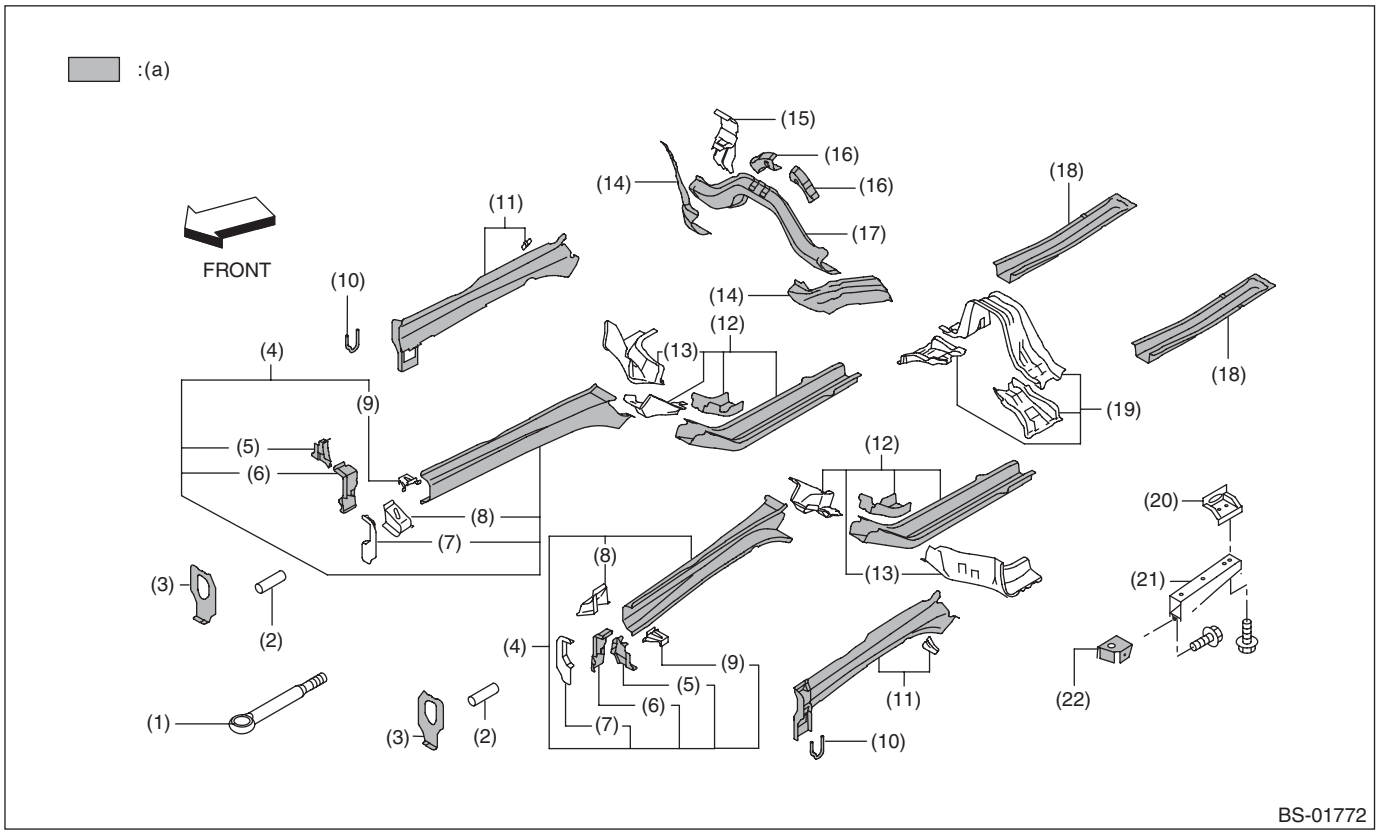
2. RADIATOR PANEL & FRONT WHEEL APRON



(a) High-strength steel

(1) Radiator panel upper RH
(2) Radiator panel upper
(3) Radiator panel upper LH
(4) Radiator bracket
(5) Radiator panel side
(6) Hood lock stay
(7) Radiator panel frame lower
(8) Radiator frame lower
(9) Side upper frame
(10) Front wheel apron upper
(11) Front suspension bracket
(12) Front wheel apron

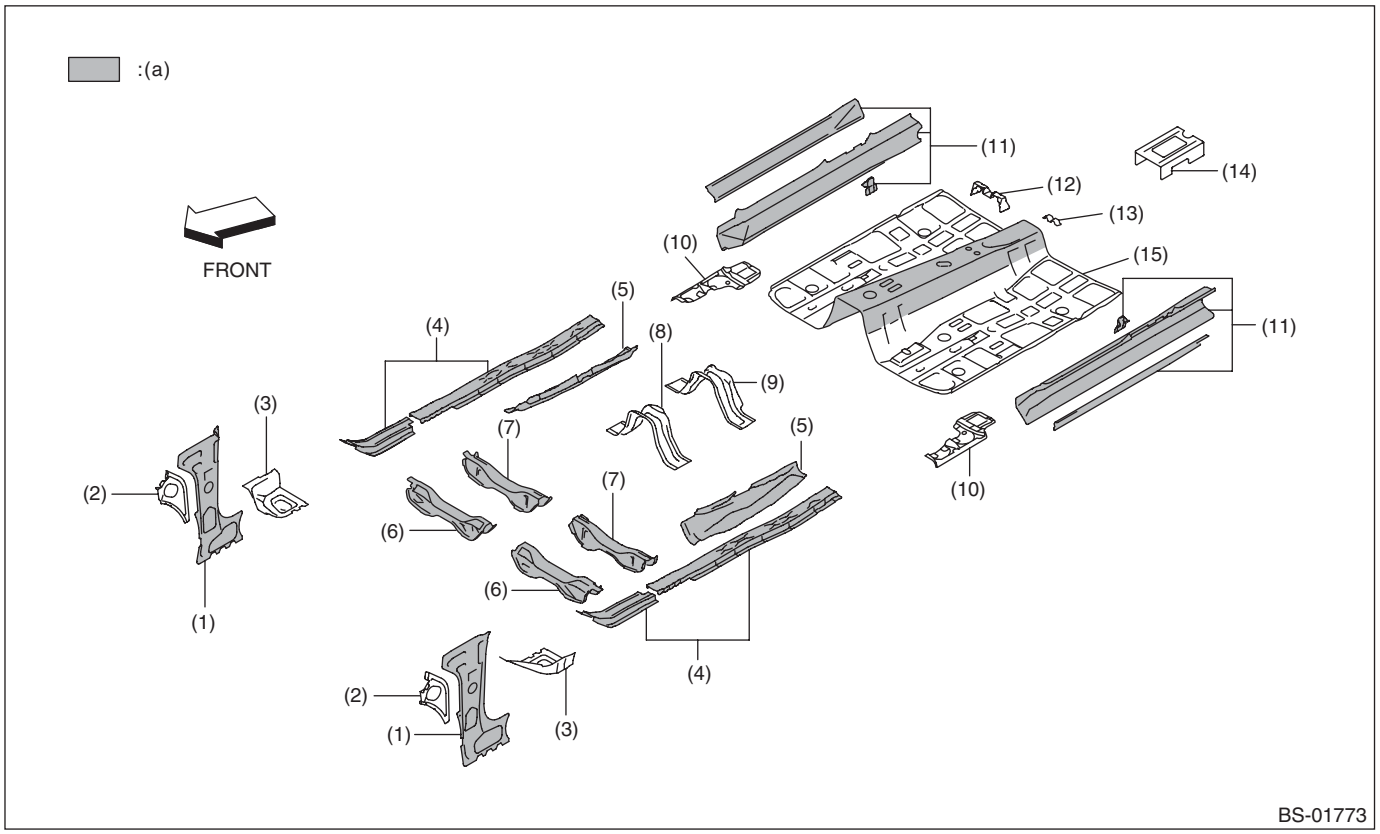
3. FRONT SIDE FRAME



(a) High-strength steel

(1) Eye bolt
(2) Hook pipe
(3) Front frame plate
(4) Front side frame front
(5) Front frame gusset C
(6) Front frame gusset A
(7) Bumper bracket front B
(8) Front frame gusset B
(9) Separator
(10) Tie-down
(11) Closing plate
(12) Front side frame rear
(13) Toe board reinforcement
(14) Toe board frame front side
(15) Pitching stopper bracket
(16) Toe board reinforcement side
(17) Toe board reinforcement tunnel
(18) Front floor frame front
(19) Crossmember bracket rear
(20) Member bracket side
(21) Compression member front
(22) Separator

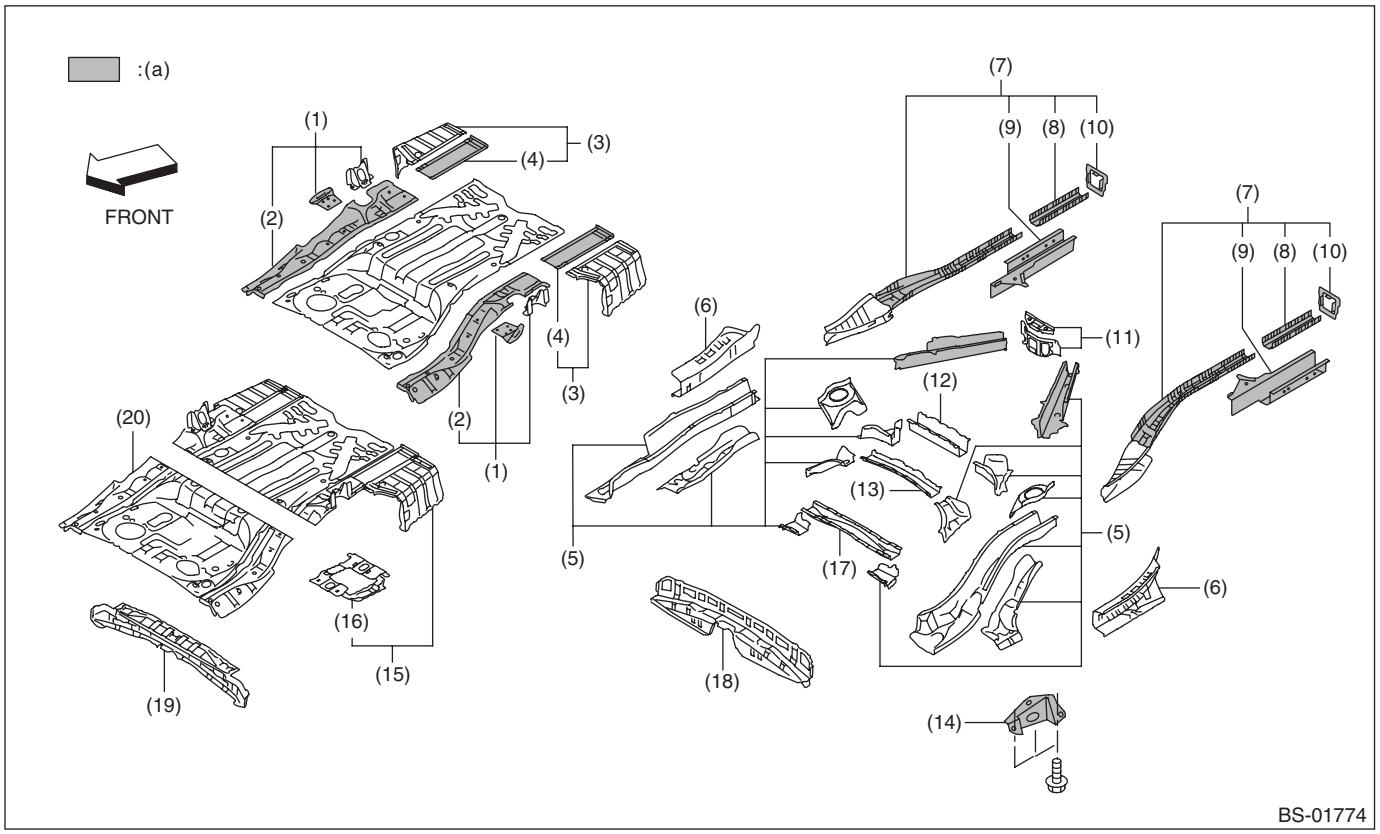
4. FRONT FLOOR PANEL



(a) High-strength steel

(1) Front pillar inner lower
(2) Cowling panel side
(3) Toe board reinforcement upper
(4) Front floor frame rear
(5) Tunnel reinforcement
(6) Filler crossmember front
(7) Seat side bracket front
(8) Floor crossmember center
(9) Crossmember A
(10) Corner patch
(11) Side sill inner
(12) Instrument panel bracket
(13) Hand brake reinforcement
(14) Floor bracket stay front
(15) Front floor pan

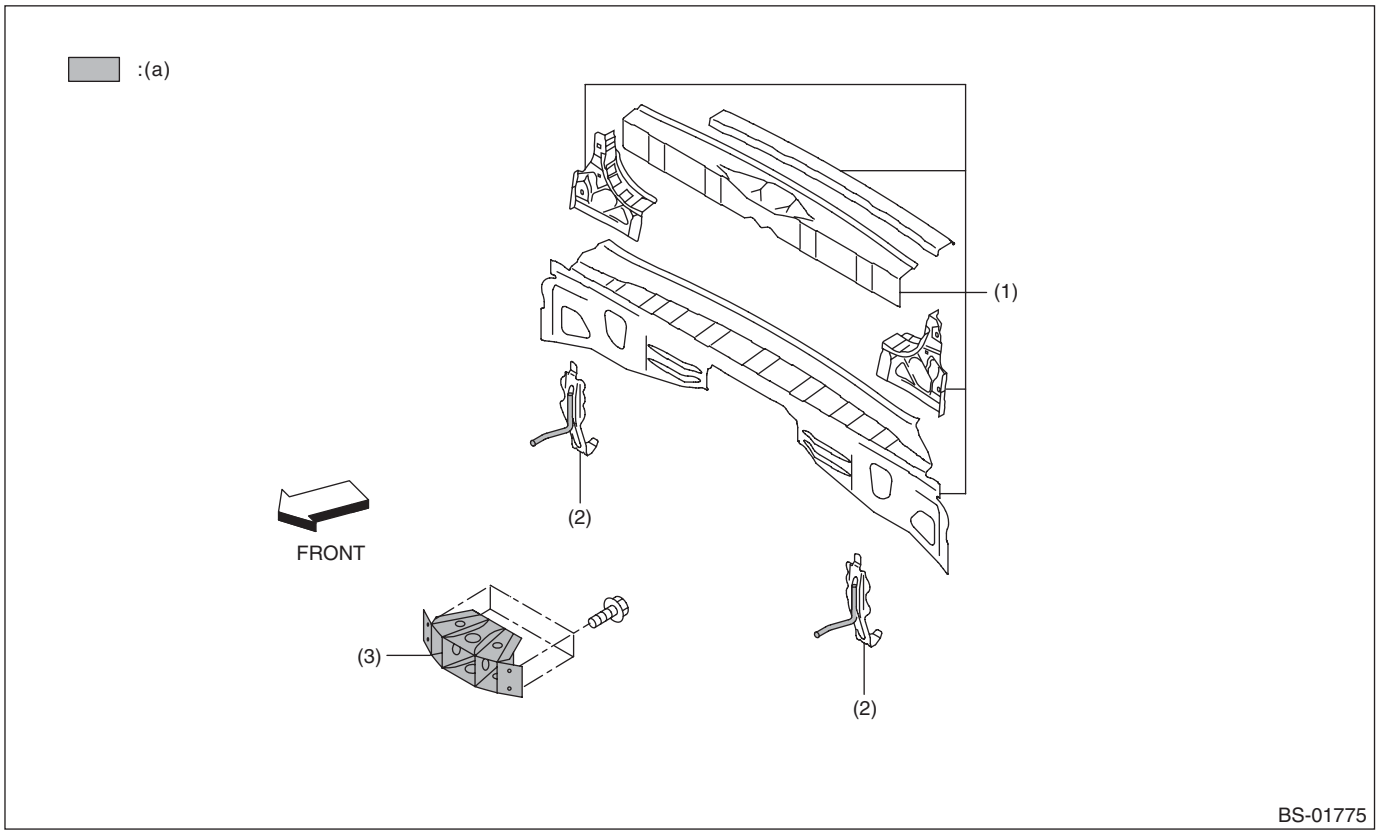
5. REAR FLOOR PANEL



(a) High-strength steel

(1) Front floor side rear
(2) Floor plate rear
(3) Floor side rear
(4) Rear closing plate rear
(5) Floor side frame rear
(6) Side sill inner rear
(7) Doubler floor rear
(8) Doubler frame rear
(9) Rear floor side frame rear
(10) Rear bumper bracket
(11) Block guard bracket
(12) Rear floor crossmember C
(13) Rear floor crossmember B
(14) Tie-down hook
(15) Rear floor pan rear
(16) Floor reinforcement C
(17) 2nd seat crossmember (Non serviceable)
(18) Crossmember rear (Non serviceable)
(19) Crossmember A front (Non serviceable)
(20) Rear floor pan front (Non serviceable)

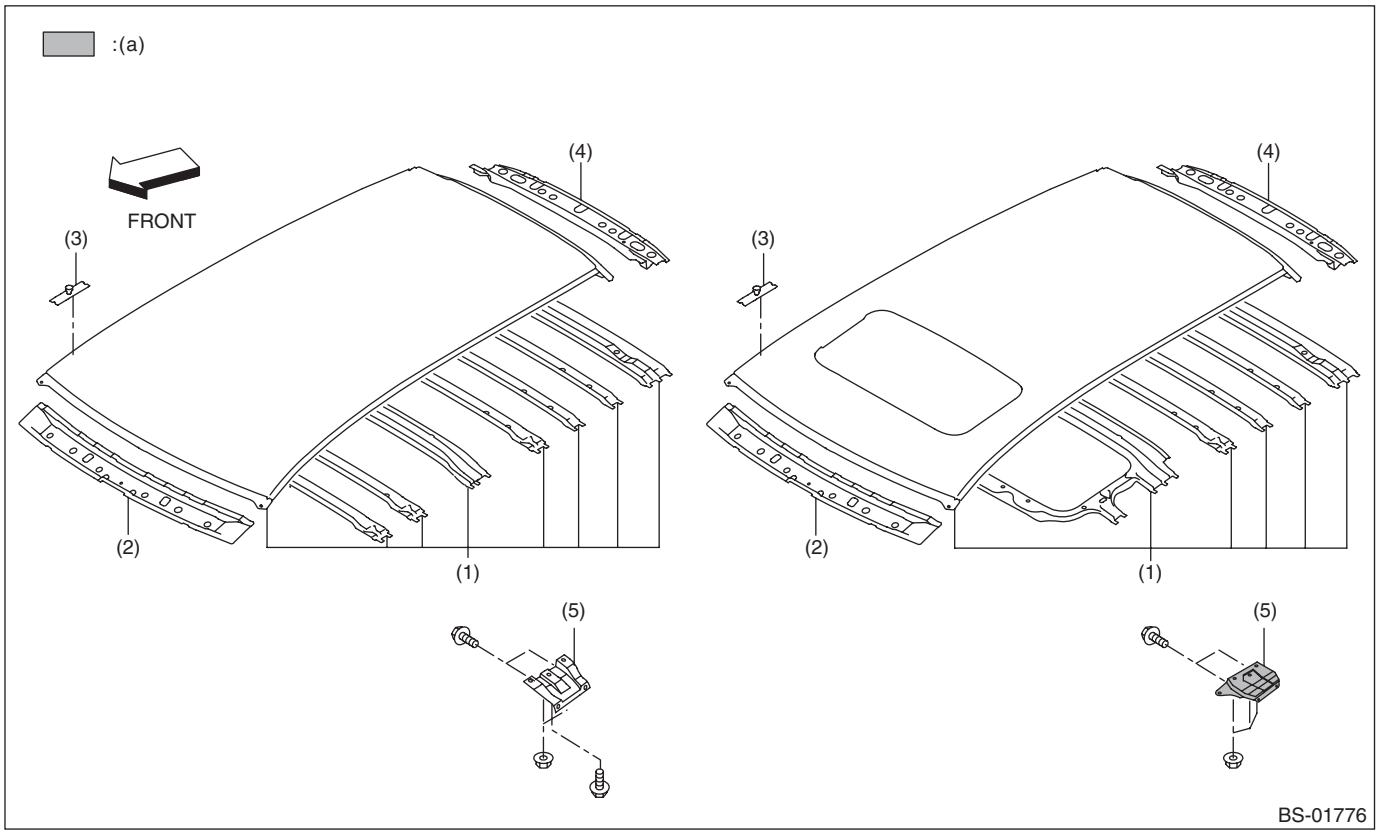
6. REAR SKIRT



(a) High-strength steel

(1) Rear skirt (2) Floor hook (3) Guard block rear

7. ROOF

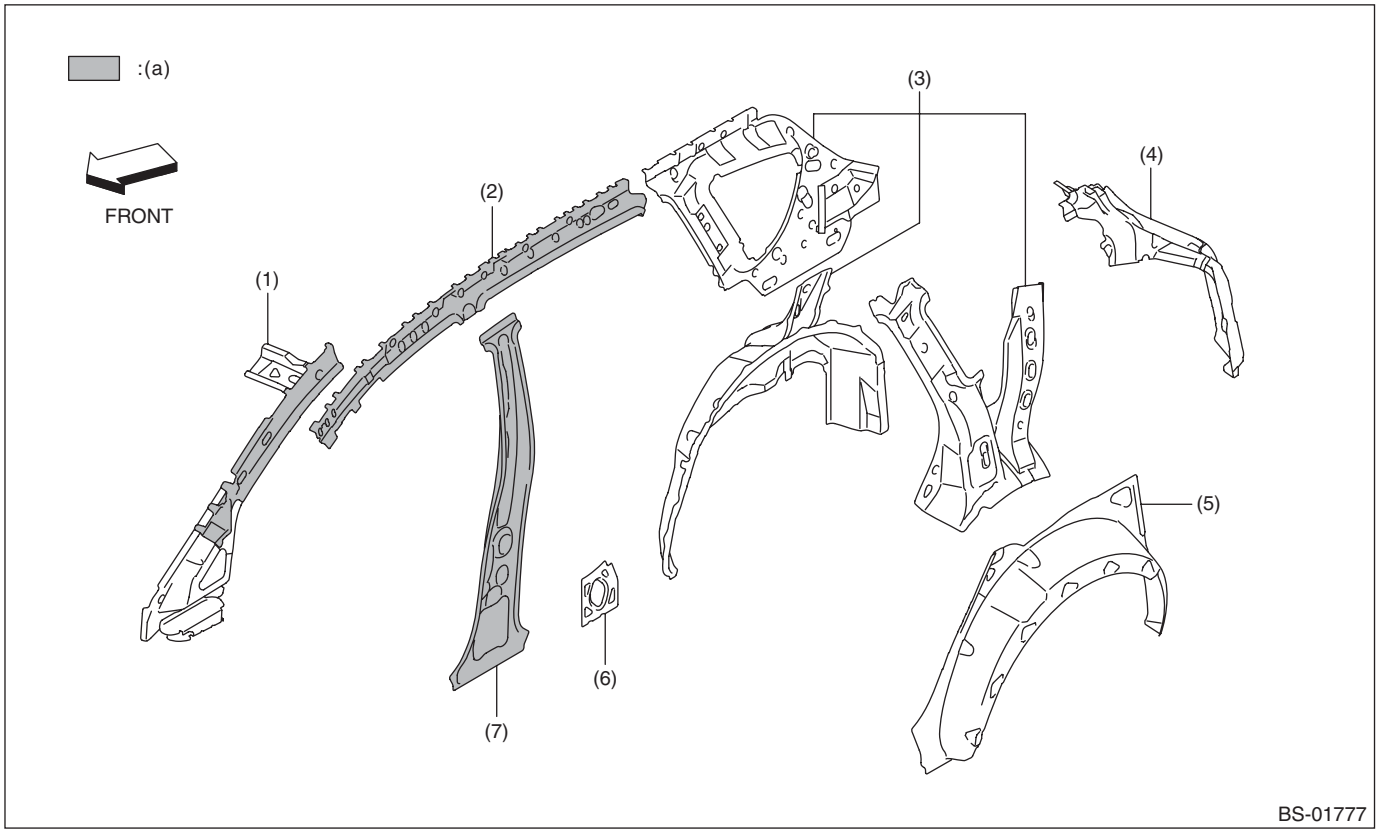


(a) High-strength steel

(1) Roof panel
(2) Front roof rail
(3) Stud plate T
(4) Rear roof rail
(5) Frame bracket

8. SIDE PANEL

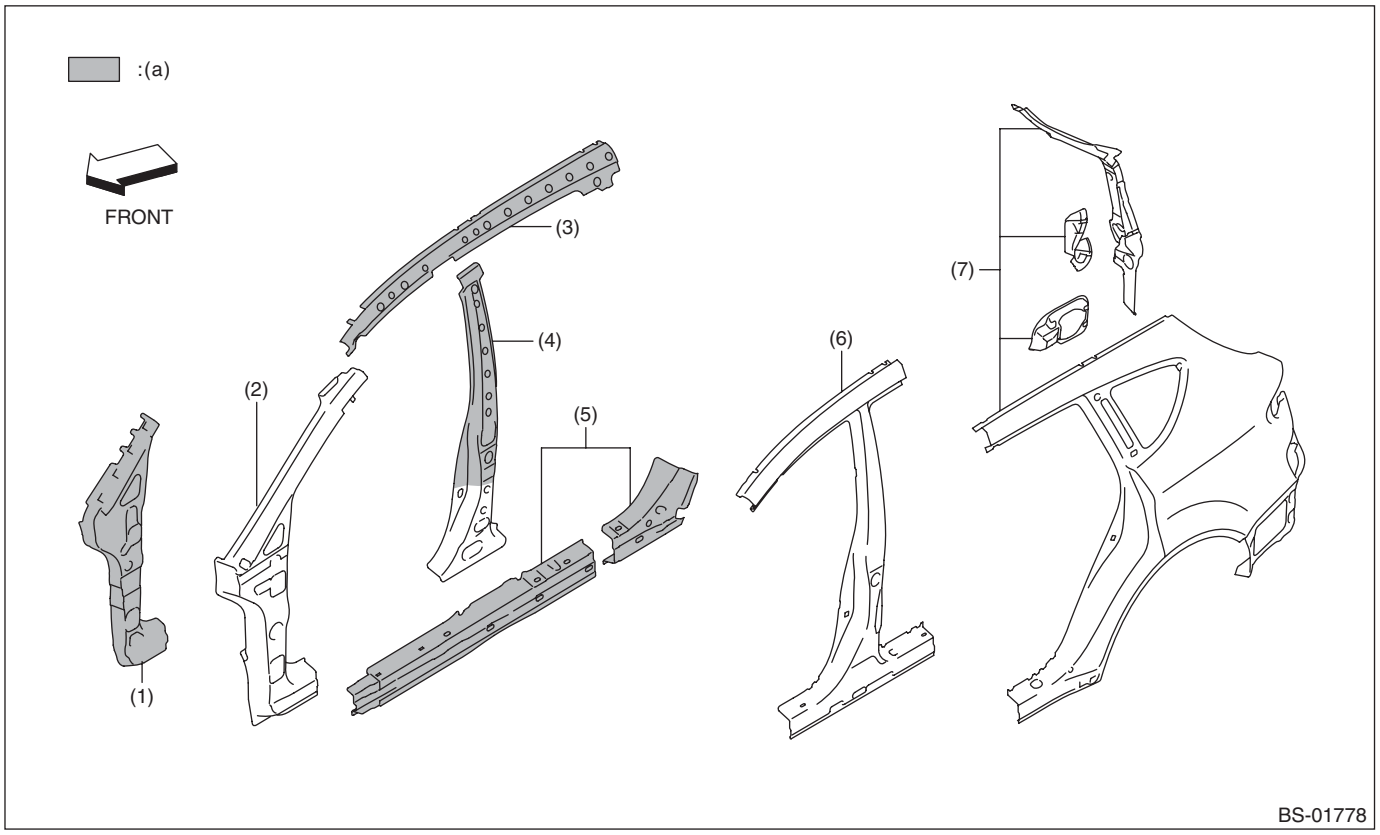
- **Inner panel**



(a) High-strength steel

(1) Front pillar inner upper
(2) Side rail inner
(3) Rear quarter inner
(4) Rear inner lower
(5) Rear arch inner
(6) Side sill reinforcement
(7) Center pillar inner

- **Outer panel**



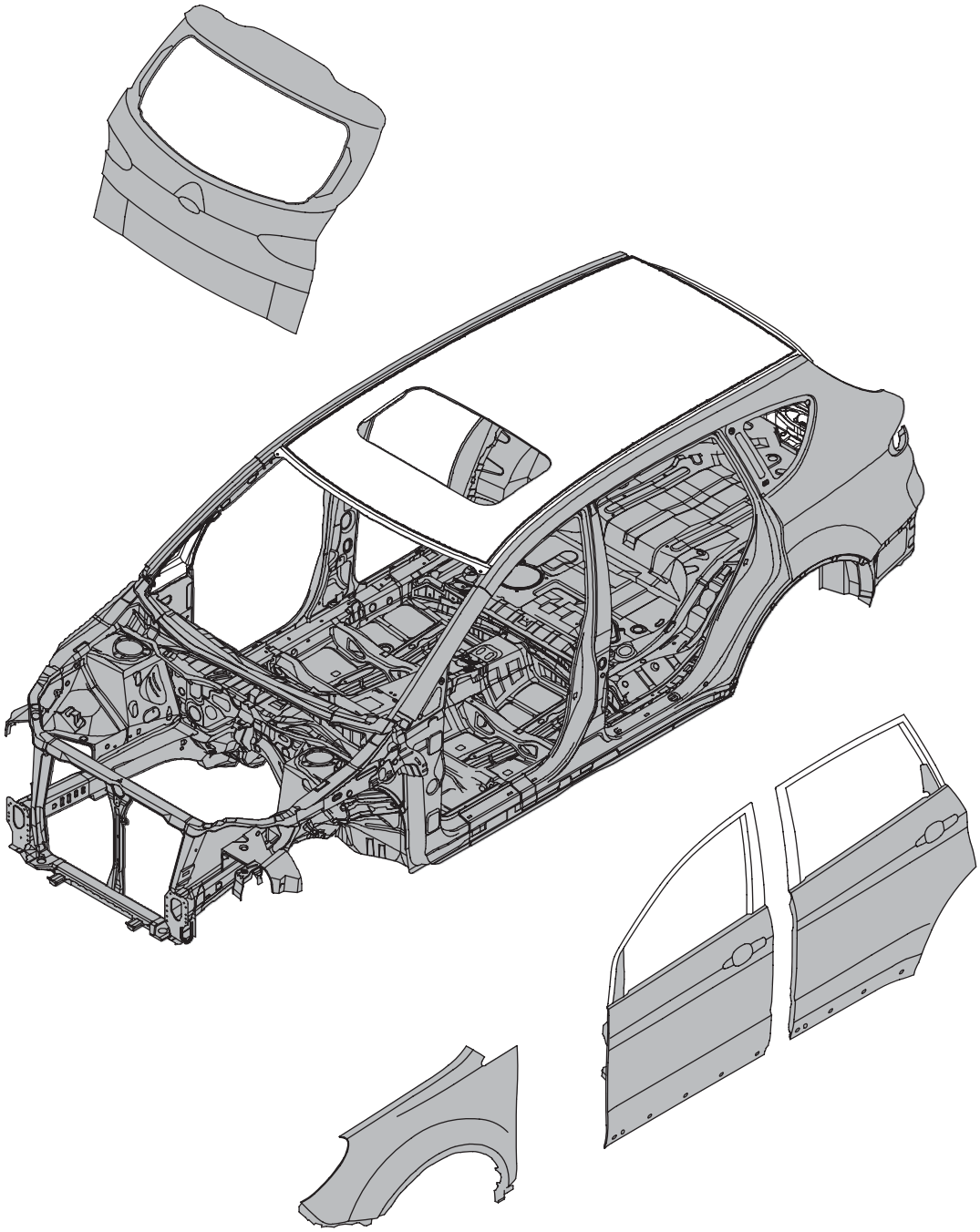
(a) High-strength steel

(1) Front pillar reinforcement lower
(2) Front pillar outer
(3) Side rail reinforcement
(4) Center pillar reinforcement
(5) Side sill reinforcement outer
(6) Center pillar outer
(7) Rear quarter outer

3. Galvanized Sheet Metal

A: SPECIFICATION

(1)

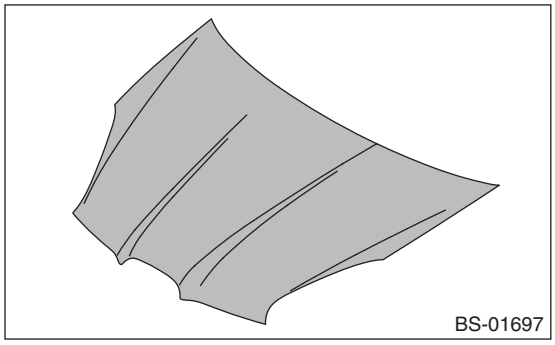


BS-01696

(1) Galvanized on both sides

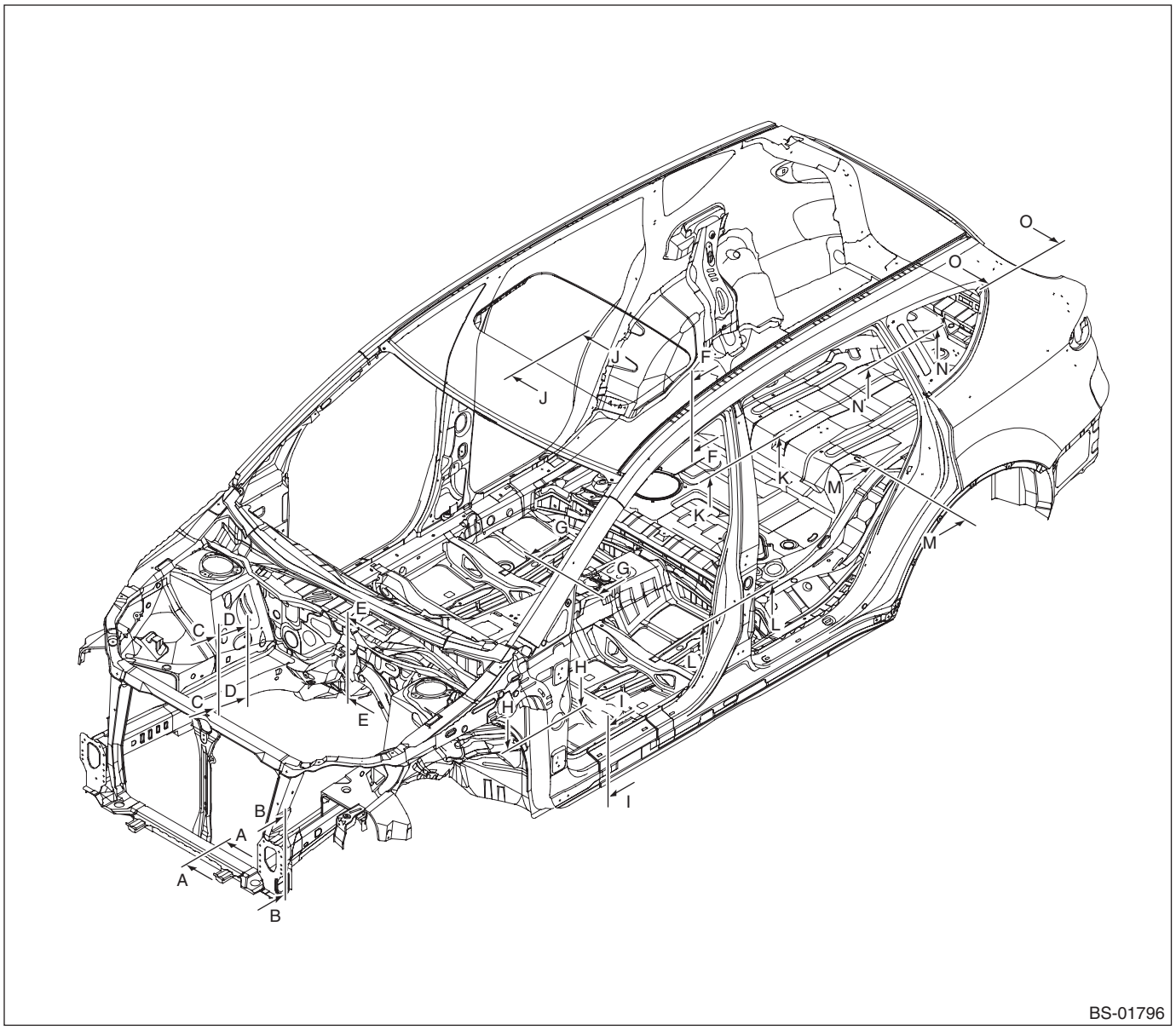
4. Aluminium Sheet Metal

A: SPECIFICATION

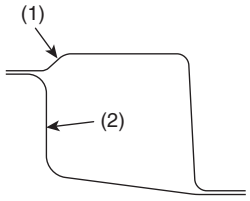


5. Body Construction

A: SPECIFICATION



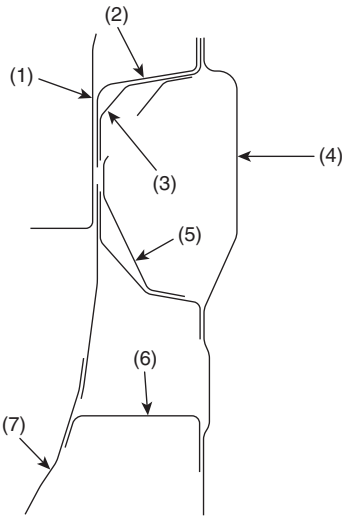
Cross section A — A



BS-01754

(1) Radiator lower frame A
(2) Radiator lower frame B

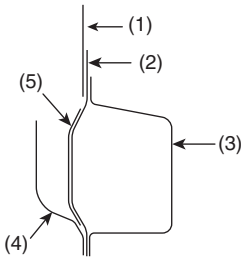
Cross section B — B



BS-01755

(1) Radiator panel side
(2) Front gusset frame A
(3) Front side frame front
(4) Hook reinforcement
(5) Doubler A
(6) Separator C
(7) Gusset B

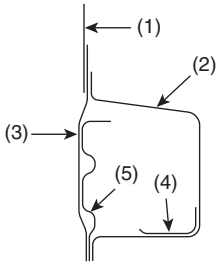
Cross section C — C



BS-01757

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

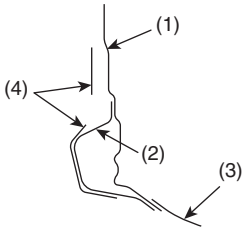
Cross section D — D



BS-01756

(1) Front suspension bracket lower
(2) Front side frame front
(3) Closing plate
(4) Frame inner reinforcement A
(5) Frame inner reinforcement B

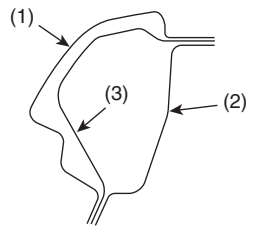
Cross section E — E



BS-01758

(1) Toe board
(2) Toe board center crossmember
(3) Front floor
(4) Pitching stopper bracket

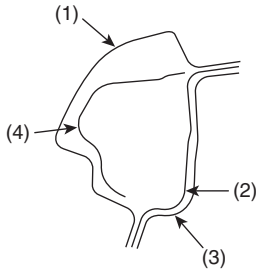
Cross section F — F



BS-01759

(1) Side panel outer
(2) Side rail inner
(3) Side rail outer

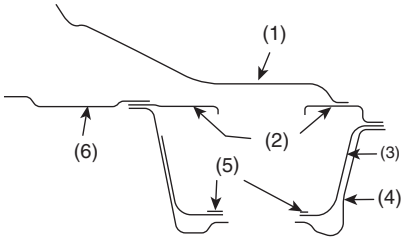
Cross section G — G



BS-01760

(1) Front pillar outer
(2) Front pillar inner upper
(3) Front pillar inner center
(4) Front pillar reinforcement outer

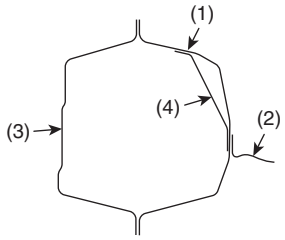
Cross section H — H



BS-01761

(1) Toe board gusset
(2) Front pillar inner lower
(3) Front pillar outer reinforcement
(4) Front pillar outer
(5) Front pillar separator
(6) Front pillar cowl

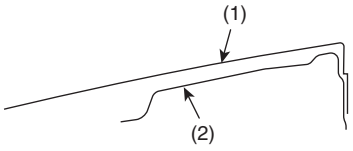
Cross section I — I



BS-01762

(1) Side sill inner front
(2) Front floor pan
(3) Side sill reinforcement outer
(4) Side sill reinforcement inner

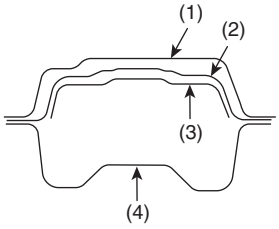
Cross section J — J



BS-01763

(1) Roof panel
(2) Sunroof frame front

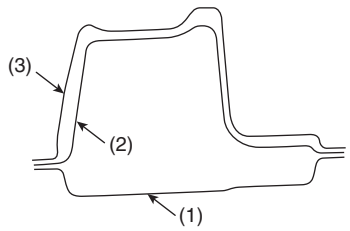
Cross section K — K



BS-01764

(1) Center pillar outer
(2) Center pillar reinforcement outer
(3) Center pillar reinforcement
(4) Center pillar inner

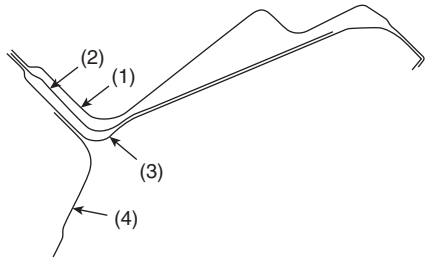
Cross section L — L



BS-01765

(1) Center pillar inner
(2) Center pillar reinforcement
(3) Center pillar outer

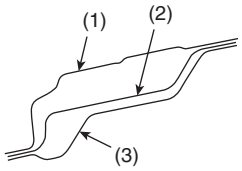
Cross section M — M



BS-01766

(1) Rear quarter panel outer
(2) C-pillar reinforcement
(3) Rear arch inner
(4) Rear wheel apron

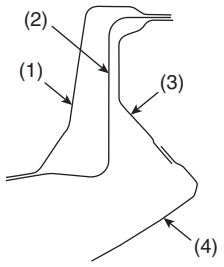
Cross section N — N



BS-01767

(1) Rear quarter panel outer
(2) C-pillar reinforcement
(3) Rear quarter panel inner A

Cross section O — O



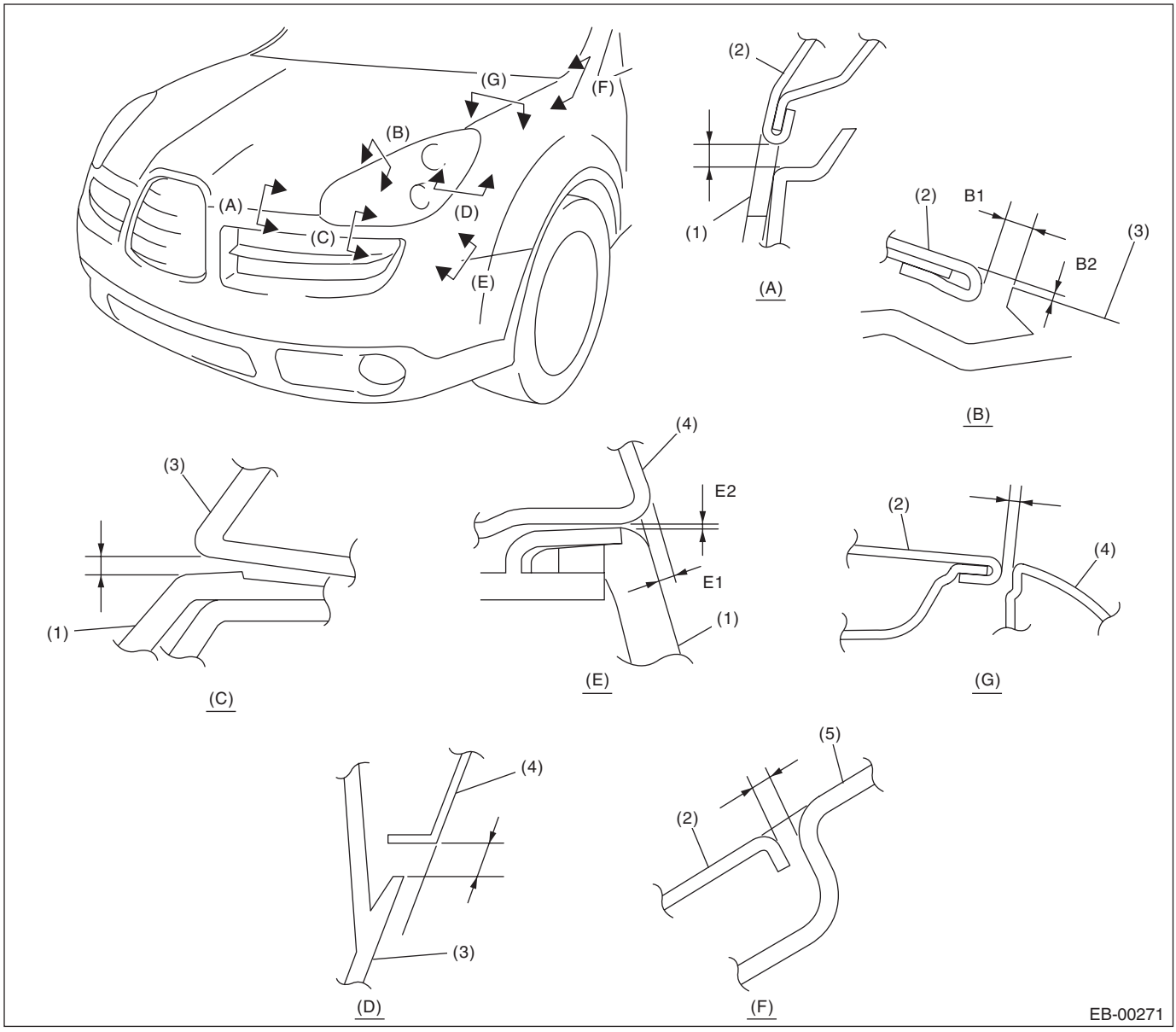
BS-01768

(1) Rear quarter panel inner B
(2) D-pillar reinforcement upper
(3) D-pillar extension upper
(4) Rear quarter panel outer

6. Gauge Values for Fitting

A: DIMENSIONS

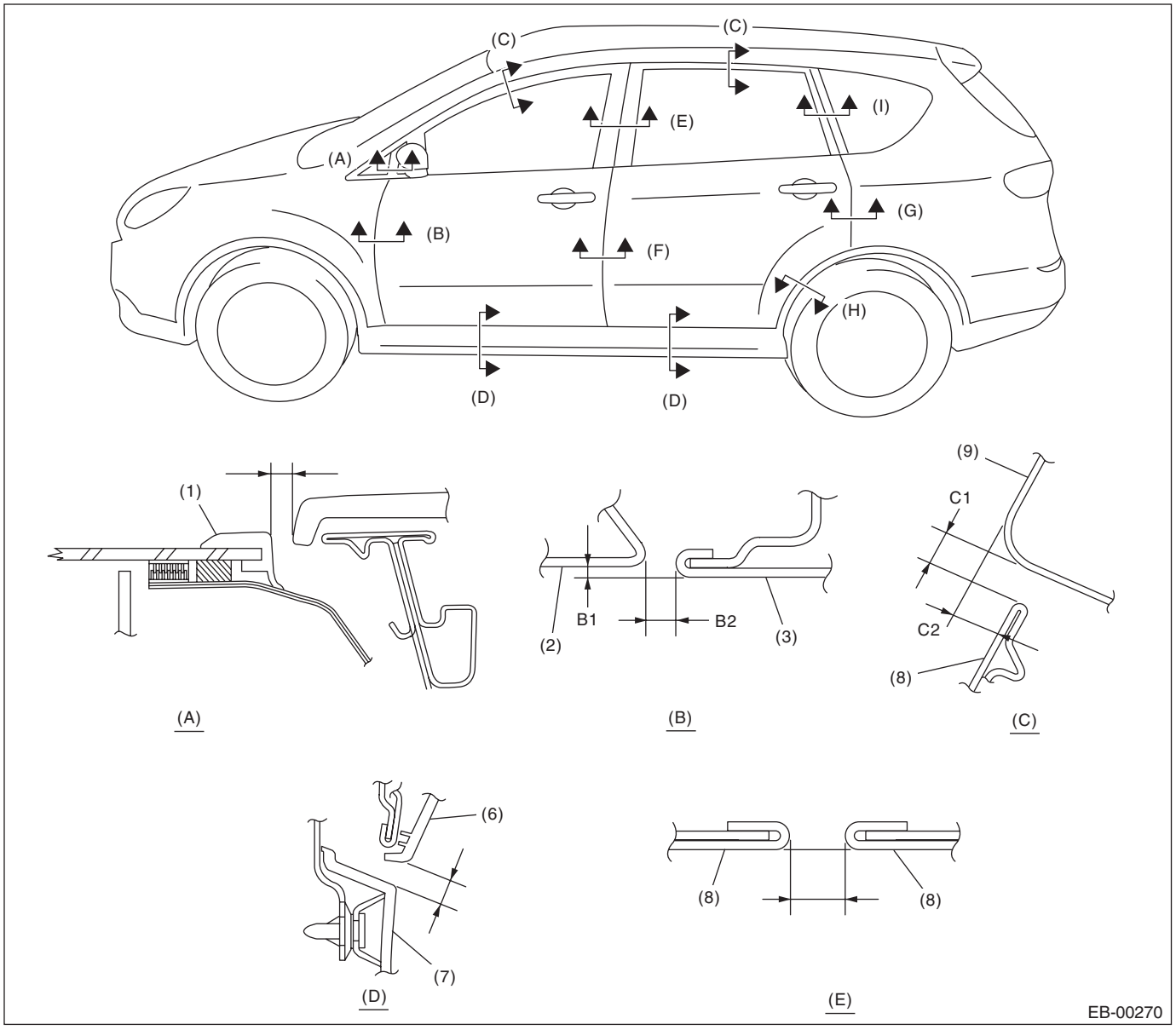
1. FRONT



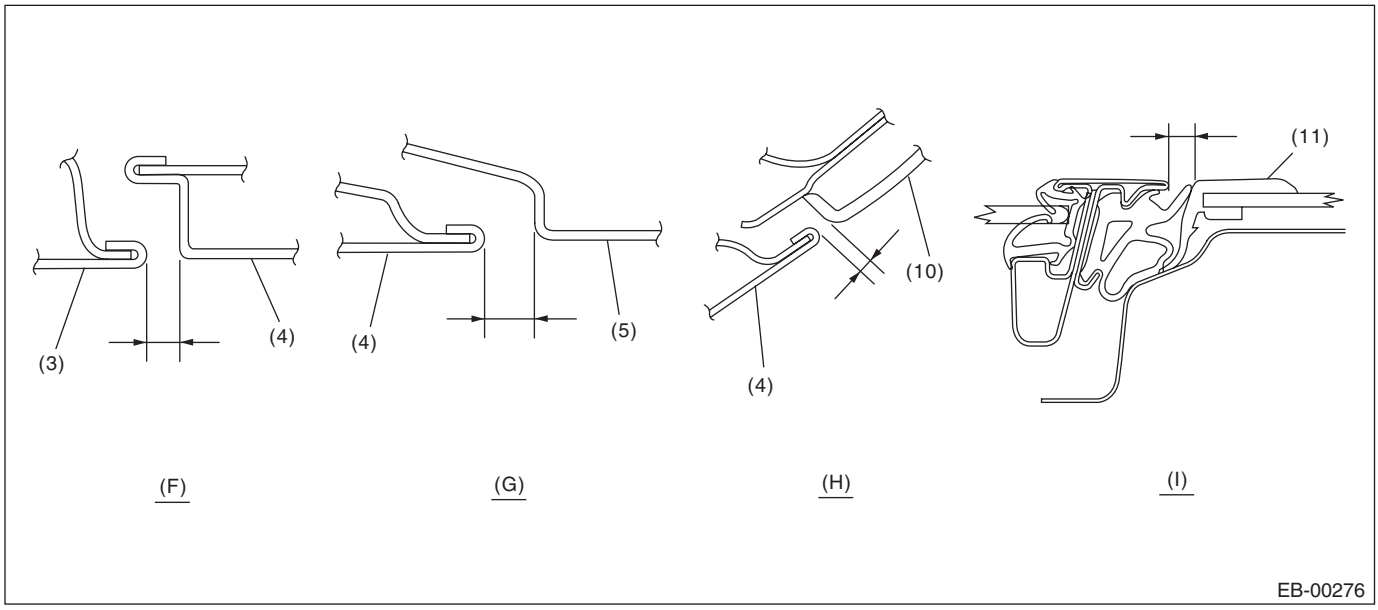
(1) Front bumper
(2) Front hood panel
(3) Headlight
(4) Front fender panel
(5) Front pillar

Section	Part	Specification
(A)	Between front hood panel to front bumper	5.0±1.0 mm (0.20±0.04 in)
(B)	Between front hood panel to headlight	B1: 3.5±1.0 mm (0.14±0.04 in) B2: 0.7±1.0 mm (0.03±0.04 in)
(C)	Between headlight to front bumper	3.0±1.0 mm (0.12±0.04 in)
(D)	Between headlight to front fender panel	1.5±1.0 mm (0.06±0.04 in)
(E)	Between front bumper to front fender panel	E1: 0.7±0.5 mm (0.03±0.02 in) E2: $0.3^{+1.0}_{-0}$ + 1.0 - 0 mm ($0.012^{+0.04}_{-0}$ in)
(F)	Between front fender panel to front pillar	2.0±0.5 mm (0.08±0.02 in)
(G)	Between front hood panel to front fender panel	3.5±1.0 mm (0.14±0.04 in)

2. SIDE



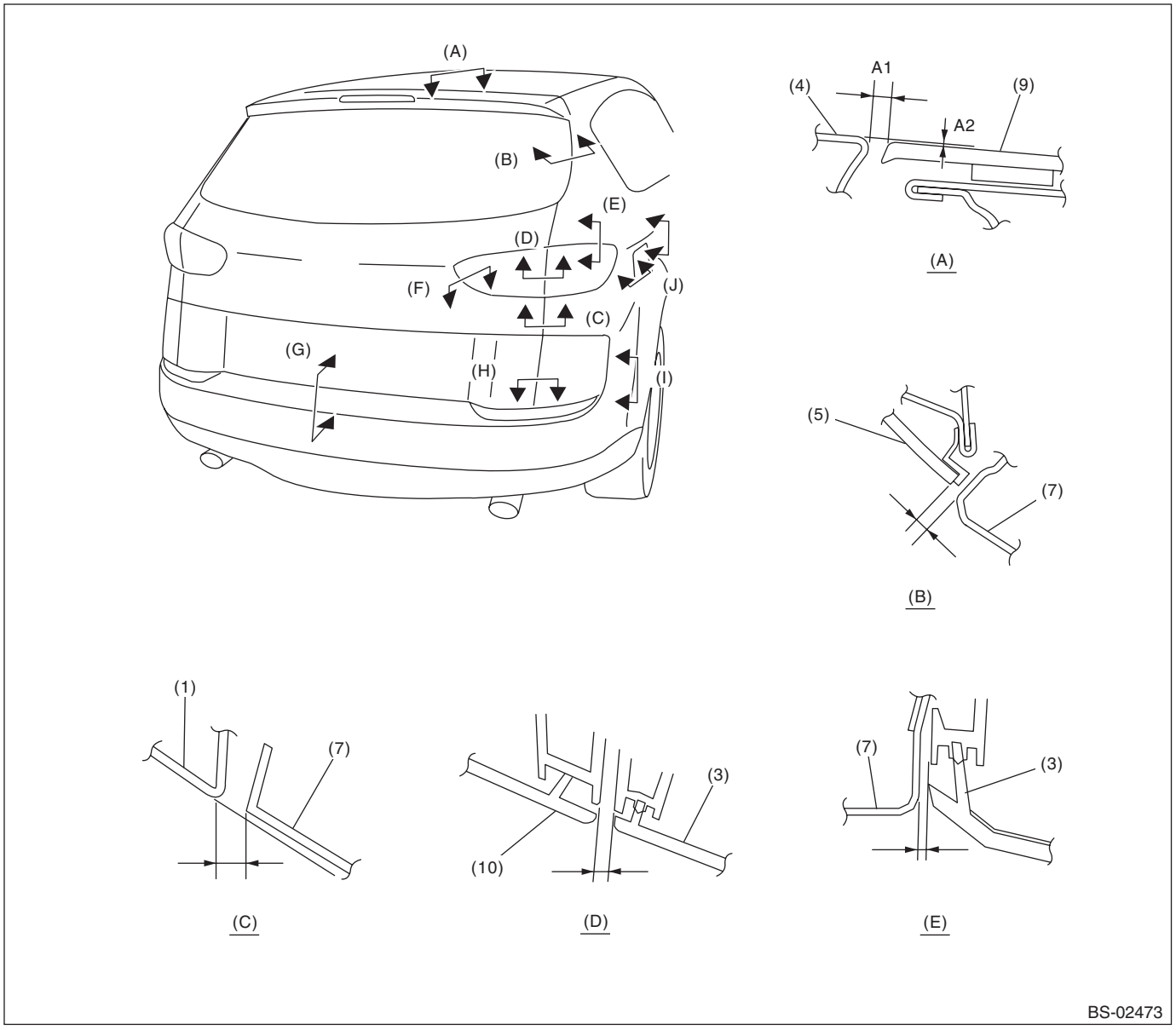
Gauge Values for Fitting



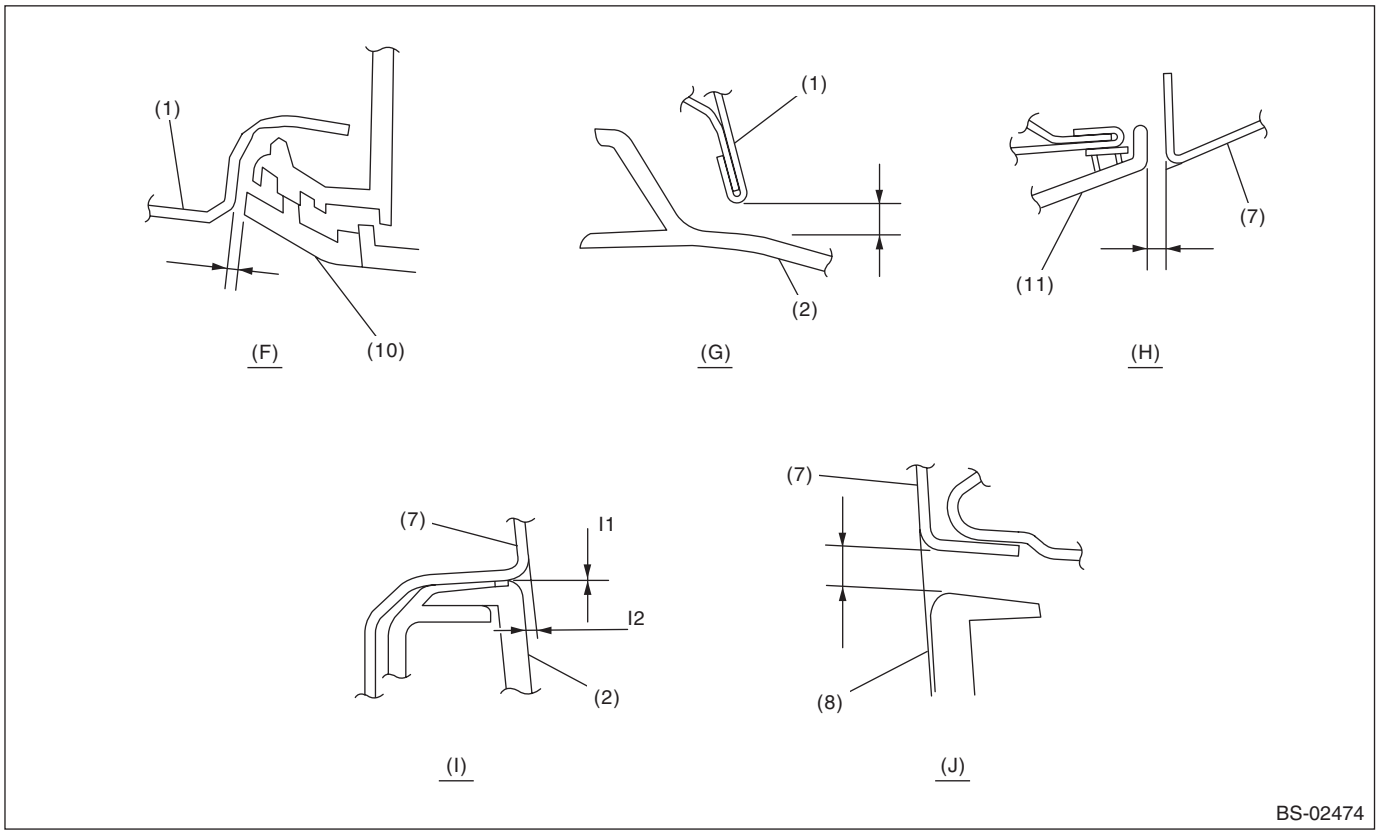
(1) Front quarter glass
(2) Front fender panel
(3) Front door panel
(4) Rear door panel
(5) Rear quarter panel
(6) Door garnish
(7) Side sill garnish
(8) Door sash
(9) Roof panel
(10) Rear quarter garnish
(11) Rear quarter glass

Section	Part	Specification
(A)	Front quarter glass and the peripheral area	5.0±1.5 mm (0.20±0.06 in)
(B)	Between front fender panel to front door panel	B1: 0 — 1.0 mm (0 — 0.04 in) B2: 4.0±1.0 mm (0.16±0.04 in)
(C)	Between door sash to roof panel	C1: 5.0±1.0 mm (0.20±0.04 in) C2: 4.0±1.0 mm (0.16±0.04 in)
(D)	Between door garnish to side sill garnish	8.0±1.5 mm (0.31±0.06 in)
(E)	Between front door sash to rear door sash	5.6±1.0 mm (0.22±0.04 in)
(F)	Between front door panel to rear door panel	4.6±1.0 mm (0.18±0.04 in)
(G)	Between rear door panel to rear quarter panel	4.0±1.0 mm (0.16±0.04 in)
(H)	Between rear quarter garnish to rear door panel	4.0±1.0 mm (0.16±0.04 in)
(I)	Between rear door sash to rear quarter glass	5.0±1.5 mm (0.20±0.06 in)

3. REAR



Gauge Values for Fitting

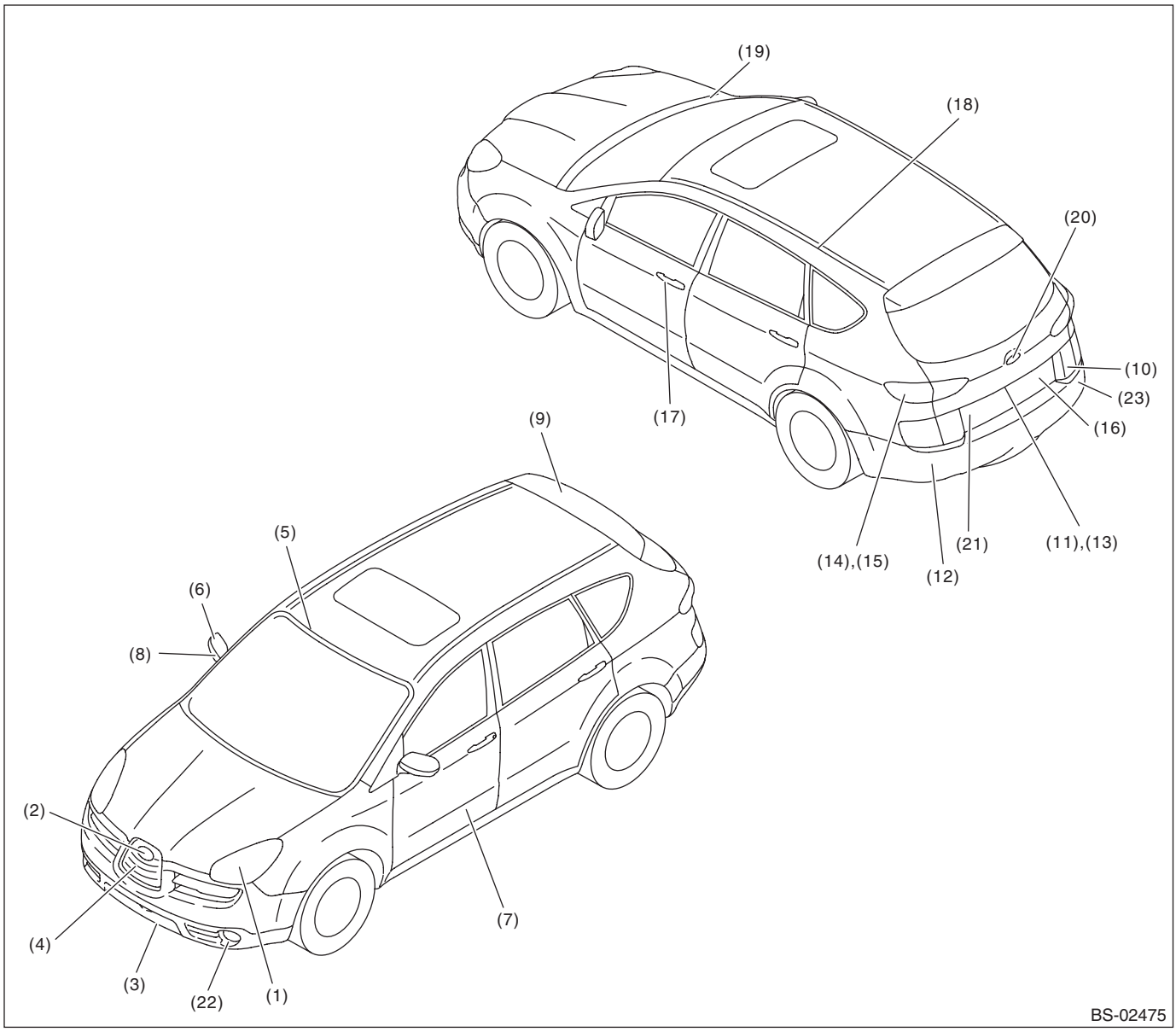


(1) Rear gate panel
(2) Rear bumper
(3) Rear combination light
(4) Roof panel
(5) Rear gate glass
(6) Rear gate garnish
(7) Rear quarter panel
(8) Fuel filler flap lid
(9) Roof spoiler
(10) Rear finisher light
(11) Rear gate garnish

Section	Part	Specification
(A)	Between roof panel to roof spoiler	A1: 5.5±1.0 mm (0.22±0.04 in) A2: 0.7±0.5 mm (0.03±0.02 in)
(B)	Between rear gate glass to rear quarter panel	5.5±1.5 mm (0.22±0.06 in)
(C)	Between rear gate panel to rear quarter panel	4.0±1.0 mm (0.16±0.04 in)
(D)	Between rear finisher light to rear combination light	4.0±1.0 mm (0.16±0.04 in)
(E)	Between rear quarter panel to rear combination light	1.5±1.0 mm (0.06±0.04 in)
(F)	Between rear finisher light to rear gate light	1.5±1.0 mm (0.06±0.04 in)
(G)	Between rear gate panel to rear bumper	7.0±1.5 mm (0.28±0.06 in)
(H)	Between rear quarter panel to rear gate garnish	4.0±1.0 mm (0.16±0.04 in)
(I)	Between rear quarter panel to rear bumper	I1: $0.3^{+1.0}_{-0}$ mm ($0.012^{+0.04}_{-0}$ in) I2: 0.7±0.5 mm (0.03±0.02 in)
(J)	Between area around the fuel filler flap lid to quarter panel	3.5±0.5 mm (0.14±0.02 in)

7. Plastic Parts and Materials

A: SPECIFICATION



(1) Headlight
(2) Ornament front
(3) Front bumper
(4) Front grille
(5) Front window moulding
(6) Door mirror
(7) Side garnish
(8) Side turn light
(9) Roof spoiler
(10) Rear gate garnish
(11) License light
(12) Rear bumper
(13) Rear gate handle
(14) Backup light
(15) Rear combination light
(16) Letter mark B9 TRIBECA
(17) Door handle
(18) Roof moulding
(19) Cowl panel
(20) Ornament rear
(21) Letter mark rear SUBARU
(22) Front fog light
(23) Rear reflex reflector

Plastic Parts and Materials

No.	Part name		Material
(1)	Headlight	Lens	PC
		Housing	PP
		Extension	PBT + PET
(2)	Ornament front		PMMA
(3)	Front bumper	Face	PP
		EA form upper	Foamed PP
		Hook cover	PP
		EA form lower	Foamed PP
		Cover upper	PP
		Cover lower	PP
		Packing lower	URETHANE
		Bracket corner	PP-GF30
		Bracket side	POM
(4)	Front grille		ABS
(5)	Front window moulding		PVC
(6)	Door mirror	Body	ASA
		Body cover	ASA
		Inner cover	ASA
		Outer cover	ABS
		Mirror holder	PP
(7)	Side garnish	Door body	PP
		Other than door body	PP
		Side sill end cover	PP
(8)	Side turn light	Lens	PMMA + PC
		Housing	PC
(9)	Roof spoiler	Body	PC + PET
		High mount lens	PMMA
(10)	Rear gate garnish	Body	PC + PET
(11)	License light	Lens	PC
		Housing	ASA
(12)	Rear bumper	Face	PP
		EA form	Foamed PP
		Hook cover	PP
		Bracket corner	POM
		Bracket side	POM
		Cover bumper side lower	PP
(13)	Rear gate handle		PP, TPV
(14)	Backup light	Lens	PMMA
		Housing	ASA
(15)	Rear combination light	Lens	PMMA
		Housing	ASA
		Cover	ASA
(16)	Letter mark B9 TRIBECA		ABS
(17)	Door handle	Handle	PC + ABS
		Cover	PC + ABS
		Frame	PA
		End cover	PP
(18)	Roof moulding		PVC + SUS
(19)	Cowl panel	Body	PP
		Side	PP + TPO
(20)	Ornament rear		ABS + PMMA

Plastic Parts and Materials

No.	Part name		Material
(21)	Letter mark rear SUBARU		ABS
(22)	Front fog light	Lens	PC
		Housing	PC
(23)	Rear reflex reflector		PMMA
	Front mudguard	Body	PE
		Air flap	TPO
	Rear mudguard		PE
	Under cover	Body	PP
		Flap	TPO
	Rear wiper	Blade	PBT
		Arm	PET
		Arm cover	PBT
	Cover extension D-pillar		AES
	Outer door waist		PVC, ABS
	Cover gusset outer		PC + ABS

8. List of Plastic Material Notations

A: SPECIFICATION

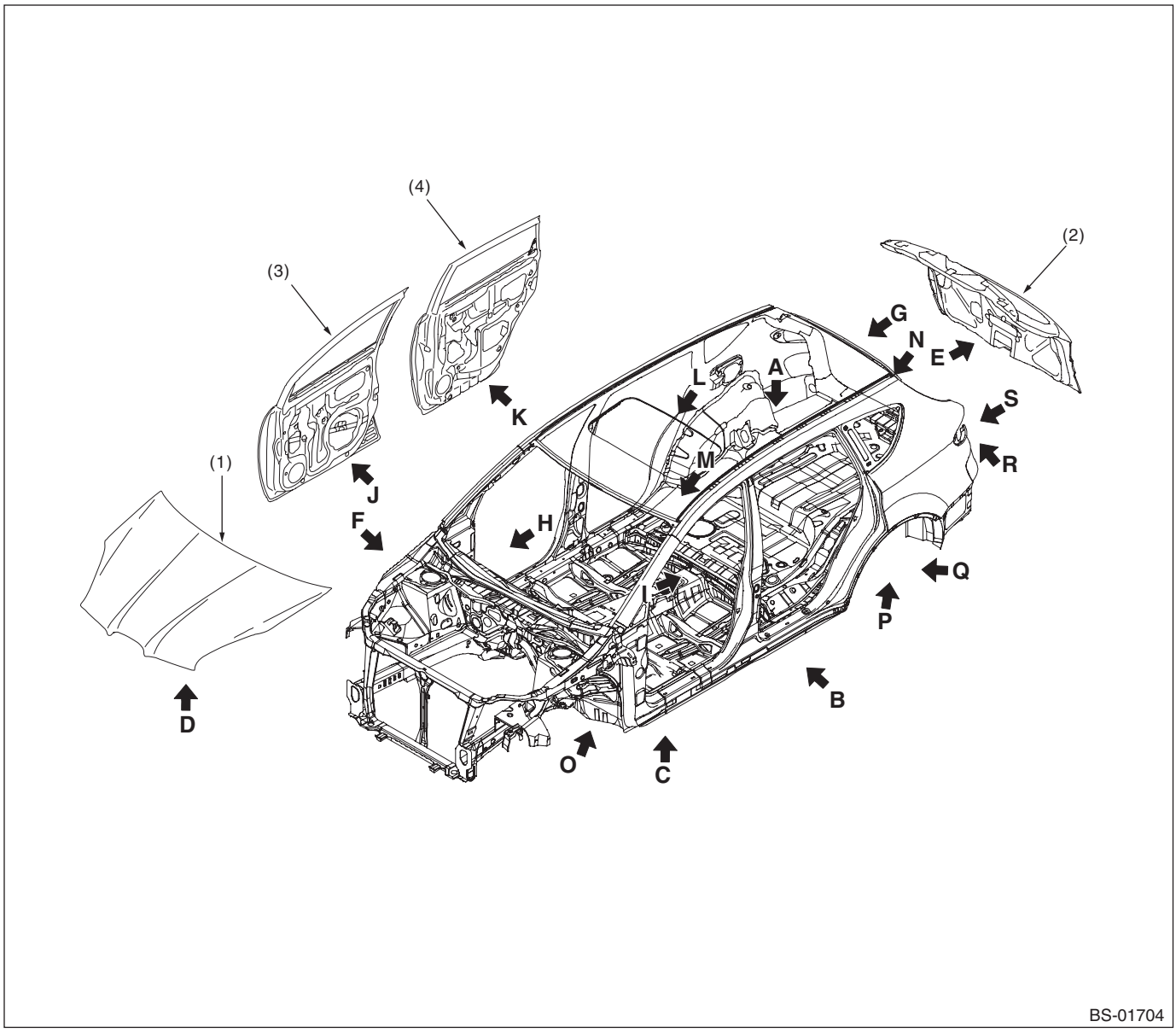
Notation symbol	Material name	Notation symbol	Material name
ABS	ABS resin (acrylonitrile/butadiene/styrene/resin)	PET	Polyethylene terephthalate
AES	Acrylonitrile/ethylene/styrene	PMMA	Polymethyl methacrylate
ASA	Acrylonitrile/styrene/acrylate	PP	Polypropylene
EPDM	Ethylene/propylene/dien rubber	PPE	Poly (phenylene ether)
GF	Glass fiber	PP + GF20	Polypropylene (20% glass fiber content)
		PP + GF30	Polypropylene (30% glass fiber content)
PA	Polyamide	PVC	Polyvinyl chloride
PBT	Poly (butylene terephthalate)	SEPM	Styrene/ethylene/propylene rubber
PC	Polycarbonate	TPO	Thermoplastic olefine
PE	Polyethylene	TPV	Styrenic elastomer (Thermo-Plastic Vulcanaizate)
POM	Polyacetal	UP	Unsaturated polyester resin
PP + EPDM	Polypropylene + Ethylene/propylene/dien rubber		

9. Body Sealing

A: SPECIFICATION

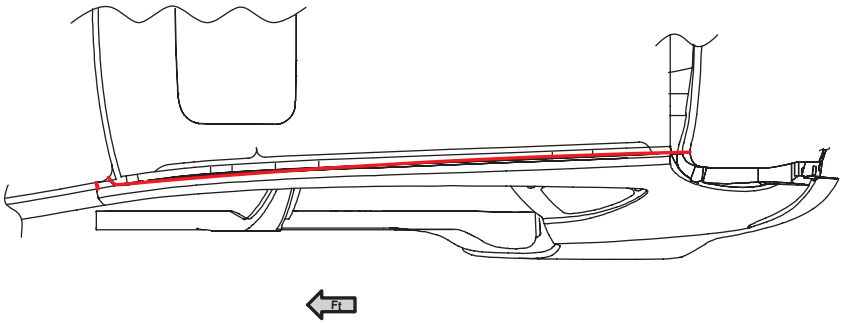
Used material: **Three Bond 4101 (004403063)**

: Sealer application location



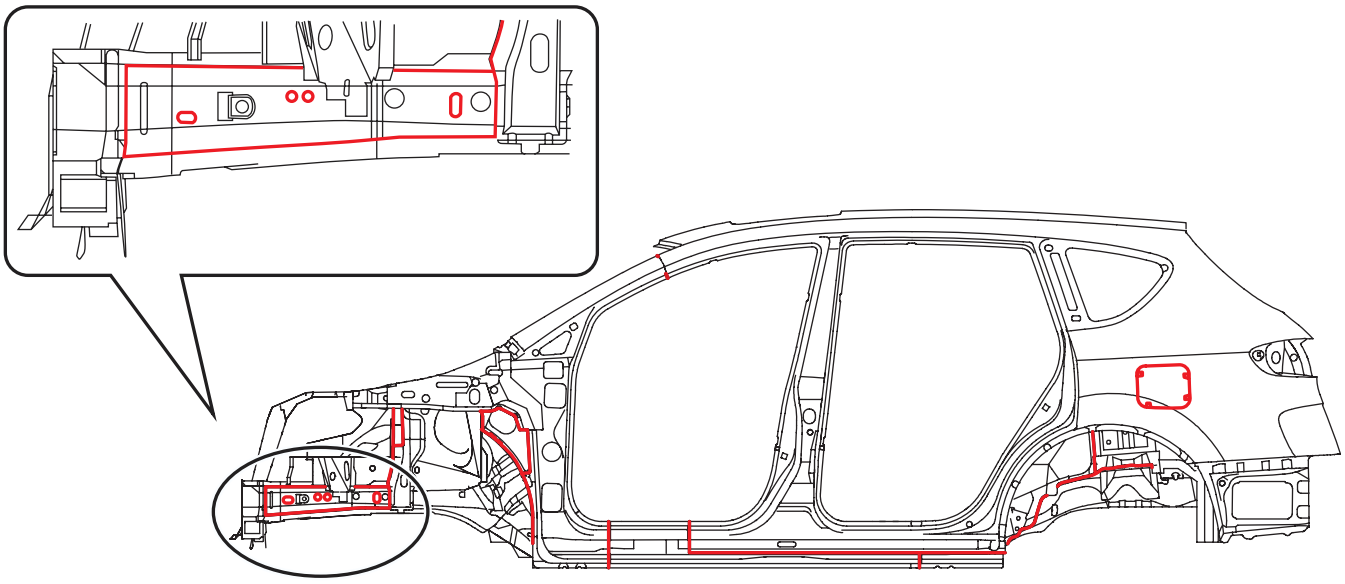
(1) Front hood
(2) Rear gate
(3) Front door
(4) Rear door

View A



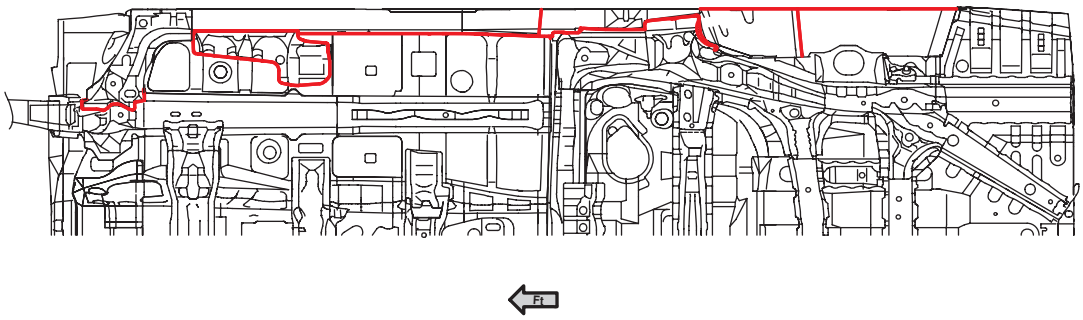
BS-01724

View B



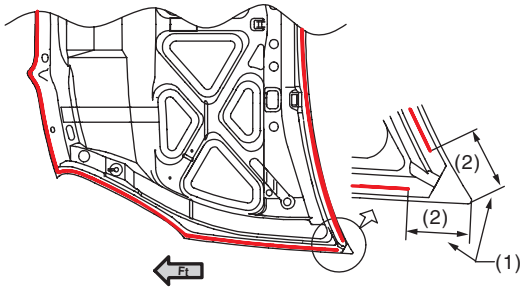
BS-01725

View C



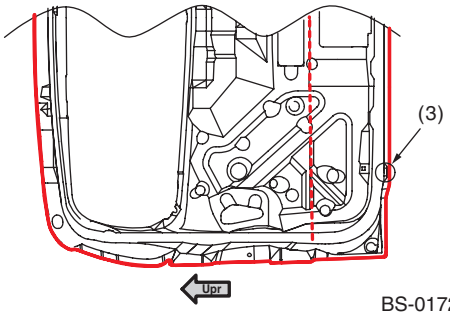
BS-01726

View D



BS-01727

View E

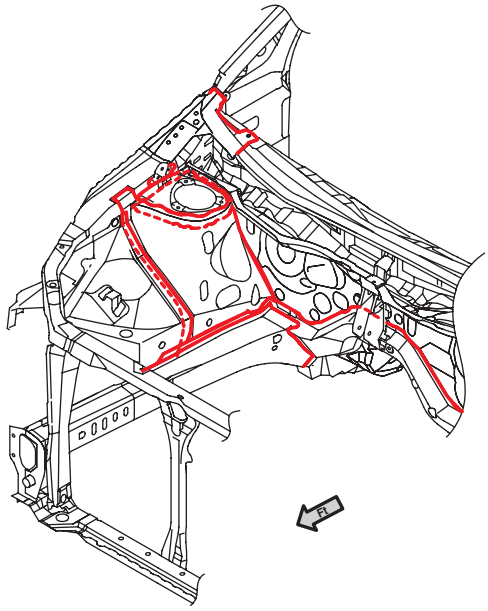


BS-01728

(1) Application not required.
(2) 50 mm (1.97 in)
(3) Do not block the water drain holes.

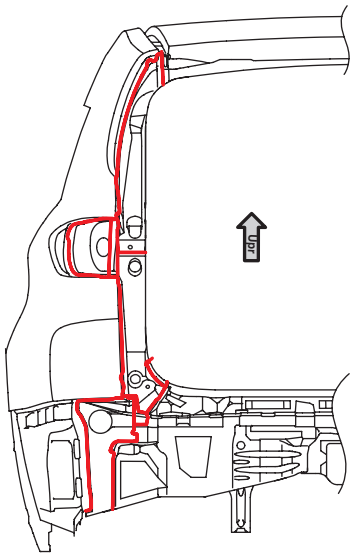
NOTE:
Sealer already has been applied to hood and rear gate in replacement condition.

View F



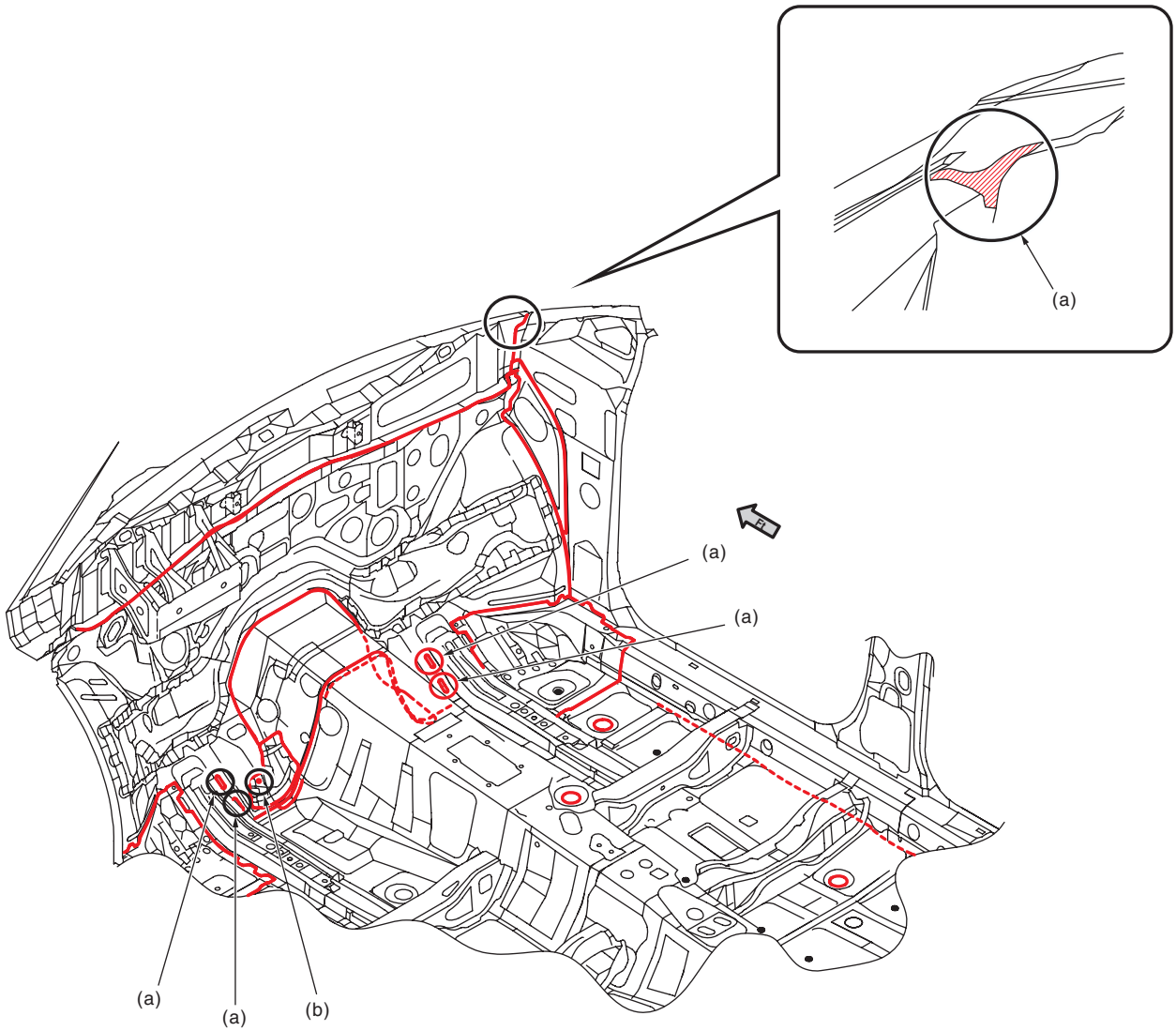
BS-01729

View G



BS-01730

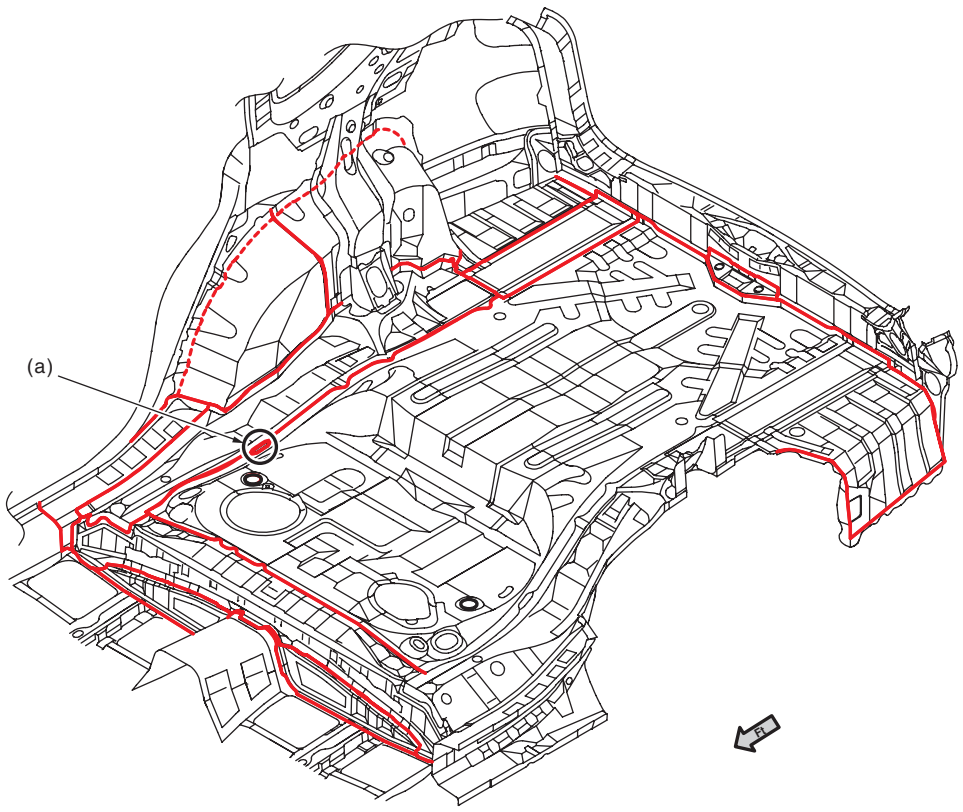
View H



(a) The holes shall be filled.

(b) The holes shall be filled.
LH side: one location
RH side: two locations

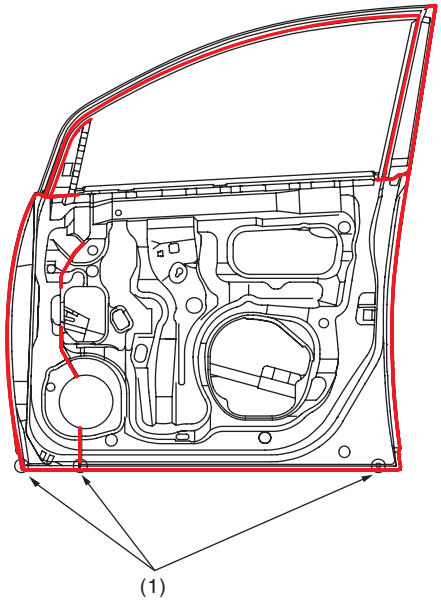
View I



BS-01732

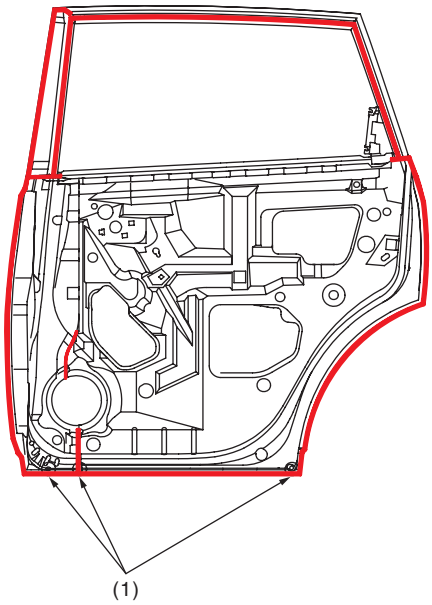
(a) The holes shall be filled.

View J



BS-02476

View K



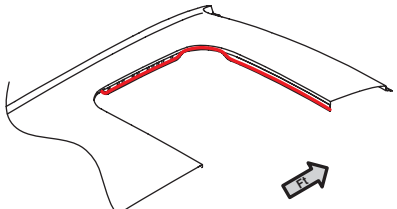
BS-02477

(1) Do not block the water drain holes.

(1) Do not block the water drain holes.

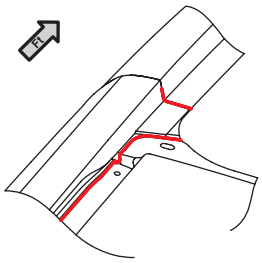
NOTE:
Sealer already has been applied to door in replacement condition.

View L



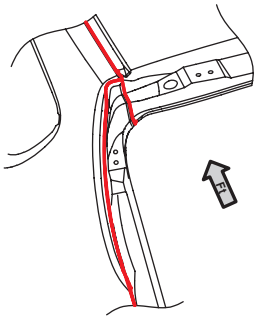
BS-01735

View M



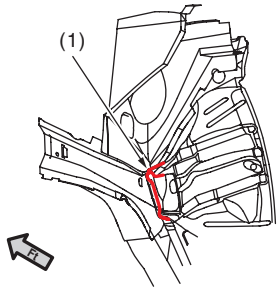
BS-01736

View N



BS-01737

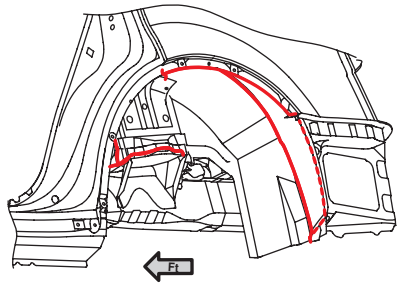
View O



BS-01738

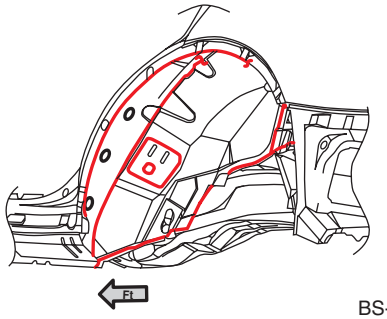
(1) The holes shall be blocked.

View P



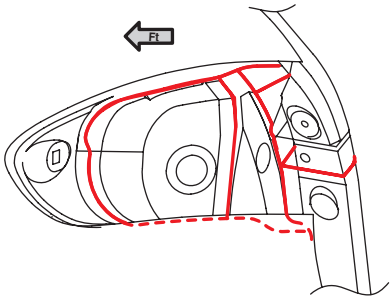
BS-01739

View Q



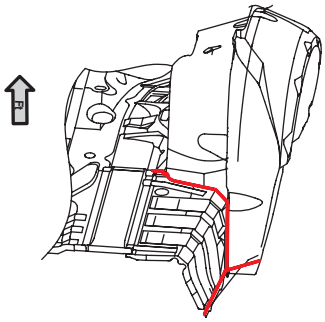
BS-01740

View R



BS-01741

View S



BS-01742

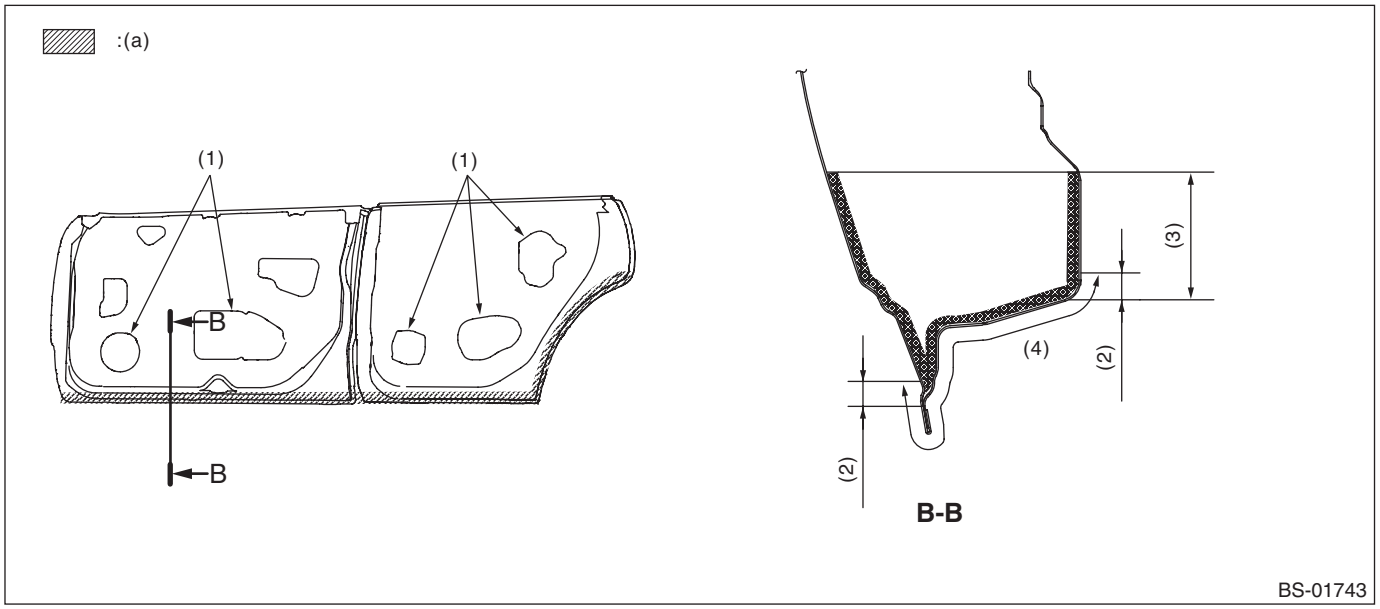
10. Anticorrosion Wax

A: SPECIFICATION

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

: Application area

- Door (Application thickness: 20 μm or more)



(a) Rust-stop aerosol

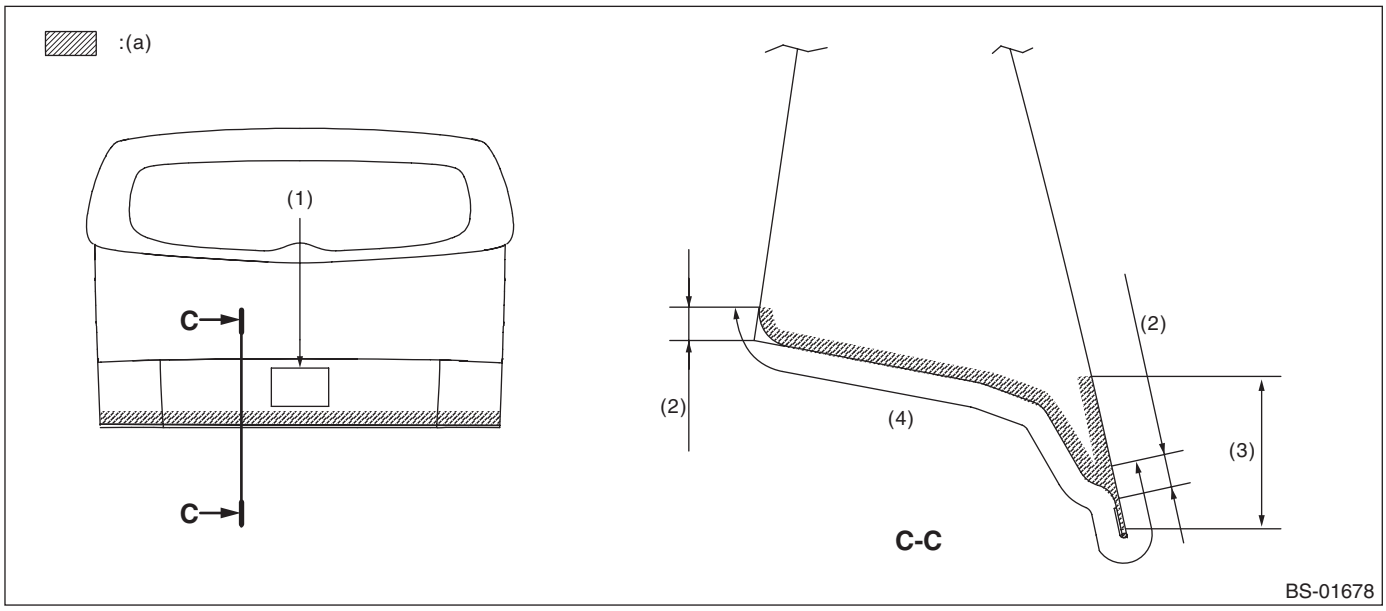
(1) Wax application work openings

(2) 10 mm (0.39 in)

(3) 50 mm (1.97 in)

(4) Application thickness for this range: 50 μm or more

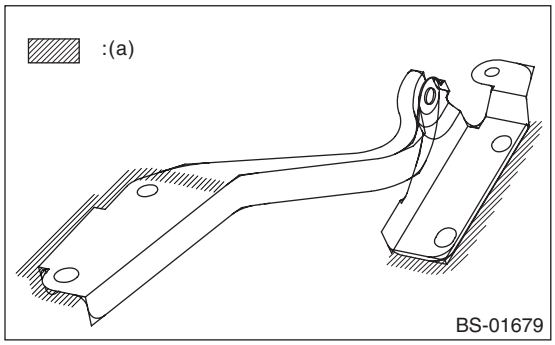
- Rear gate (Application thickness: 15 μm or more)



(a) Rust-stop aerosol

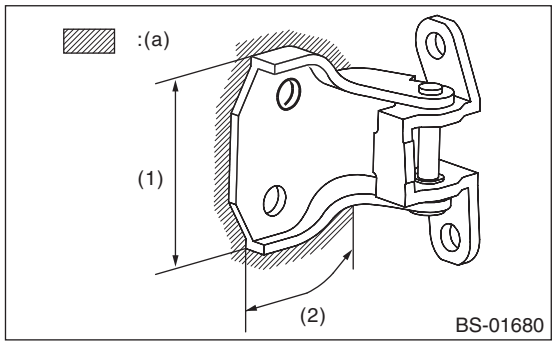
(1) Wax application work openings
(2) 10 mm (0.39 in)
(3) 50 mm (1.97 in)
(4) Application thickness for this range: 50 μm or more

- Front hood hinge (Application thickness: 15 μm or more)
  Apply around the installation outer circumference (indicated range) at two locations on the left and right.
  (Europe model only)



(a) Rust-stop aerosol

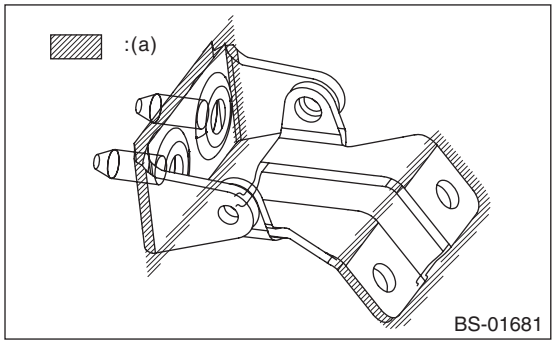
- Door hinge
  (Application thickness: 15 μm or more)
  Apply to the installation outer circumference (indicated range) at two locations at the top and bottom (eight locations in all).



(a) Rust-stop aerosol

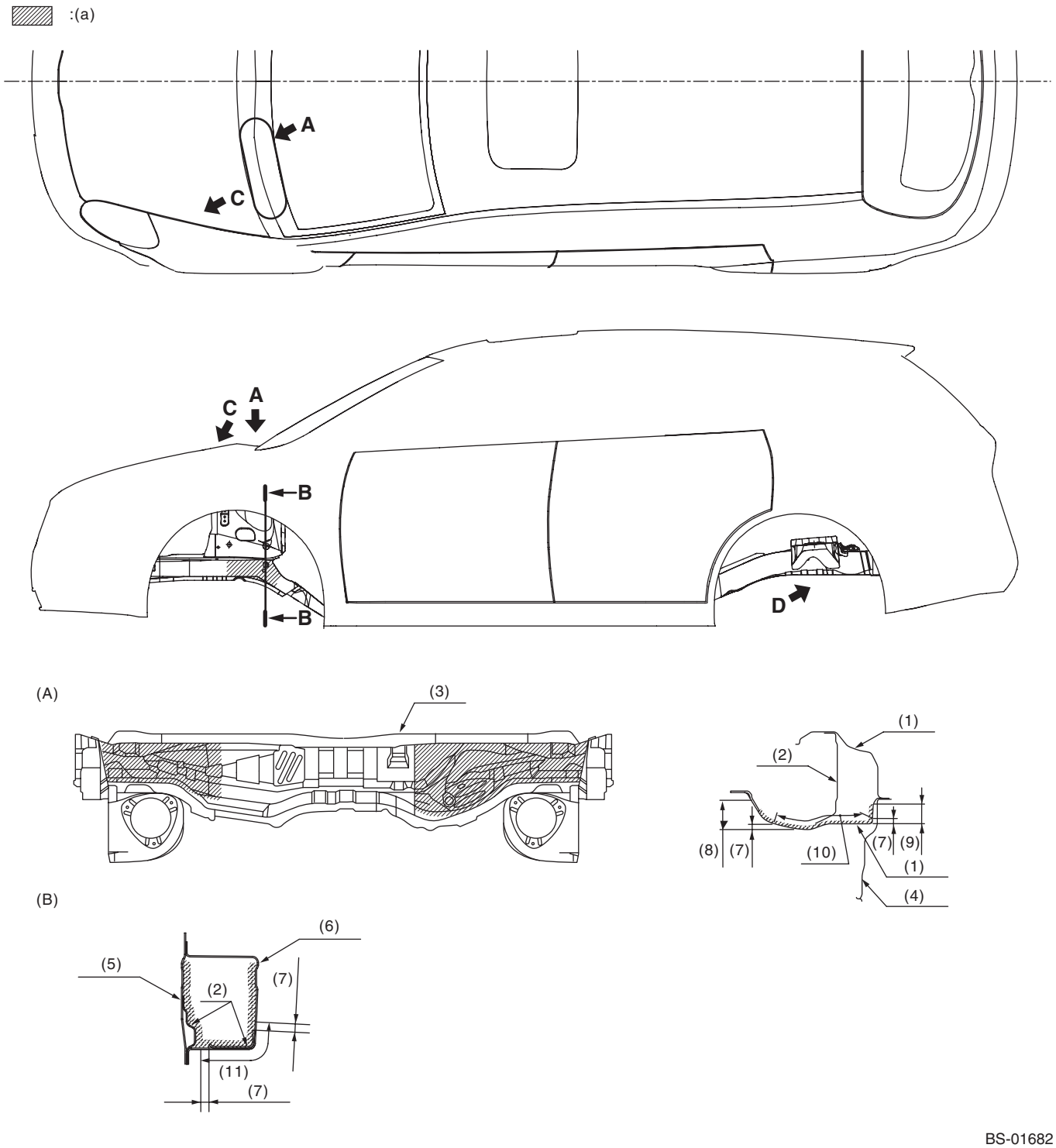
(1) Application thickness of 15 μm or less acceptable for front door hinge only
(2) Application thickness of 15 μm or less is acceptable both on the front and rear door hinge

- Rear gate hinge
  (Application thickness: 15 μm or more)
  Apply around the installation outer circumference (plate edges) at two locations on the left and right.



(a) Rust-stop aerosol

- Overall view 1



BS-01682

(a) Rust-stop aerosol

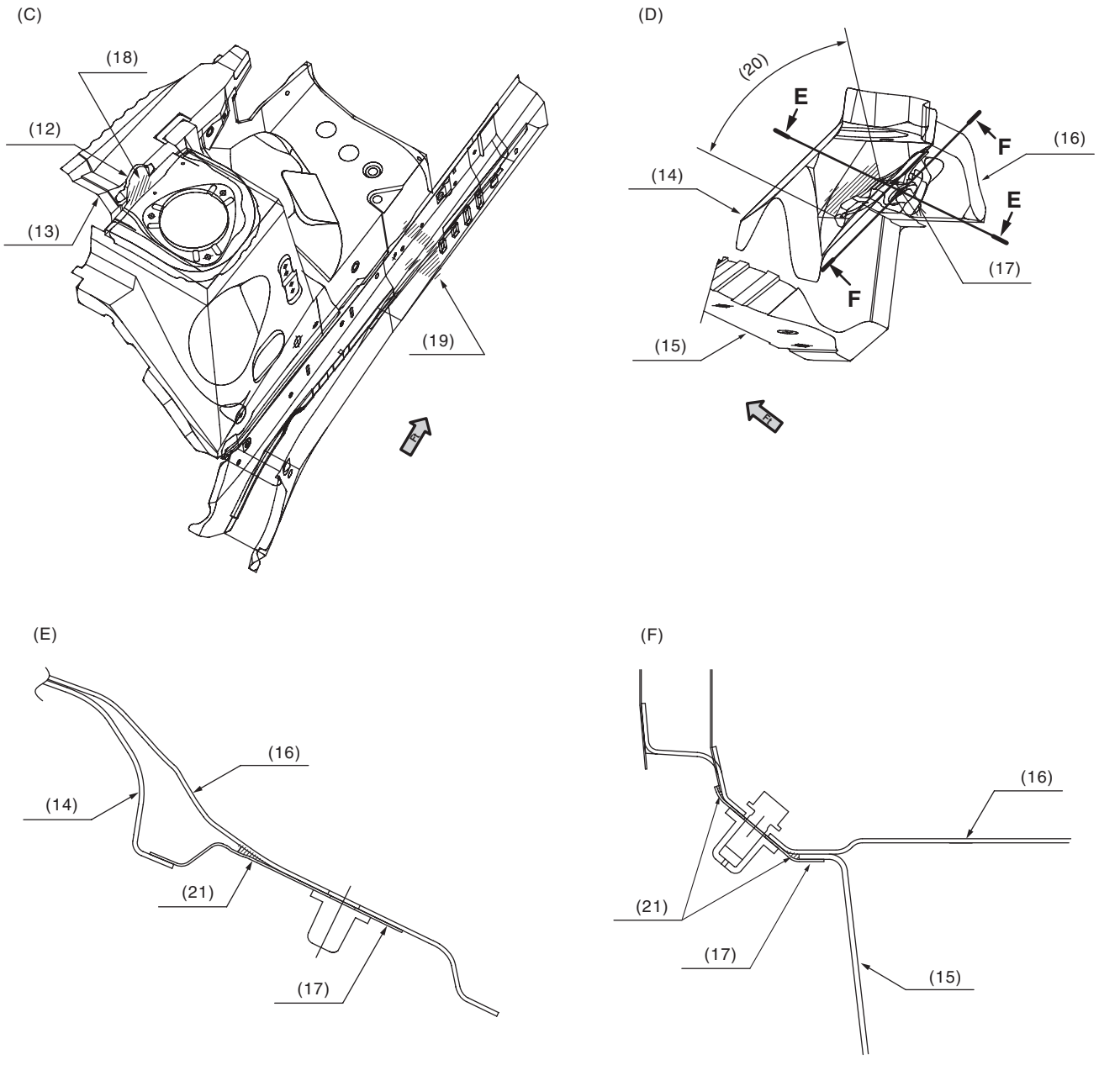
(A) View A (Application thickness: 20 μm or more)

(B) Cross section B — B (Application thickness: 15 μm or more)

(1) Front panel
(2) Reinforcement
(3) Bulkhead
(4) Toe board
(5) Closing plate
(6) Side frame
(7) 10 mm (0.39 in)
(8) 50 mm (1.97 in)
(9) 35 mm (1.38 in)
(10) Application thickness between this area: 50 μm or more
(11) Application thickness between this area: 50 μm or more (Reinforcement mating surface)

- Overall view 2

:(a)



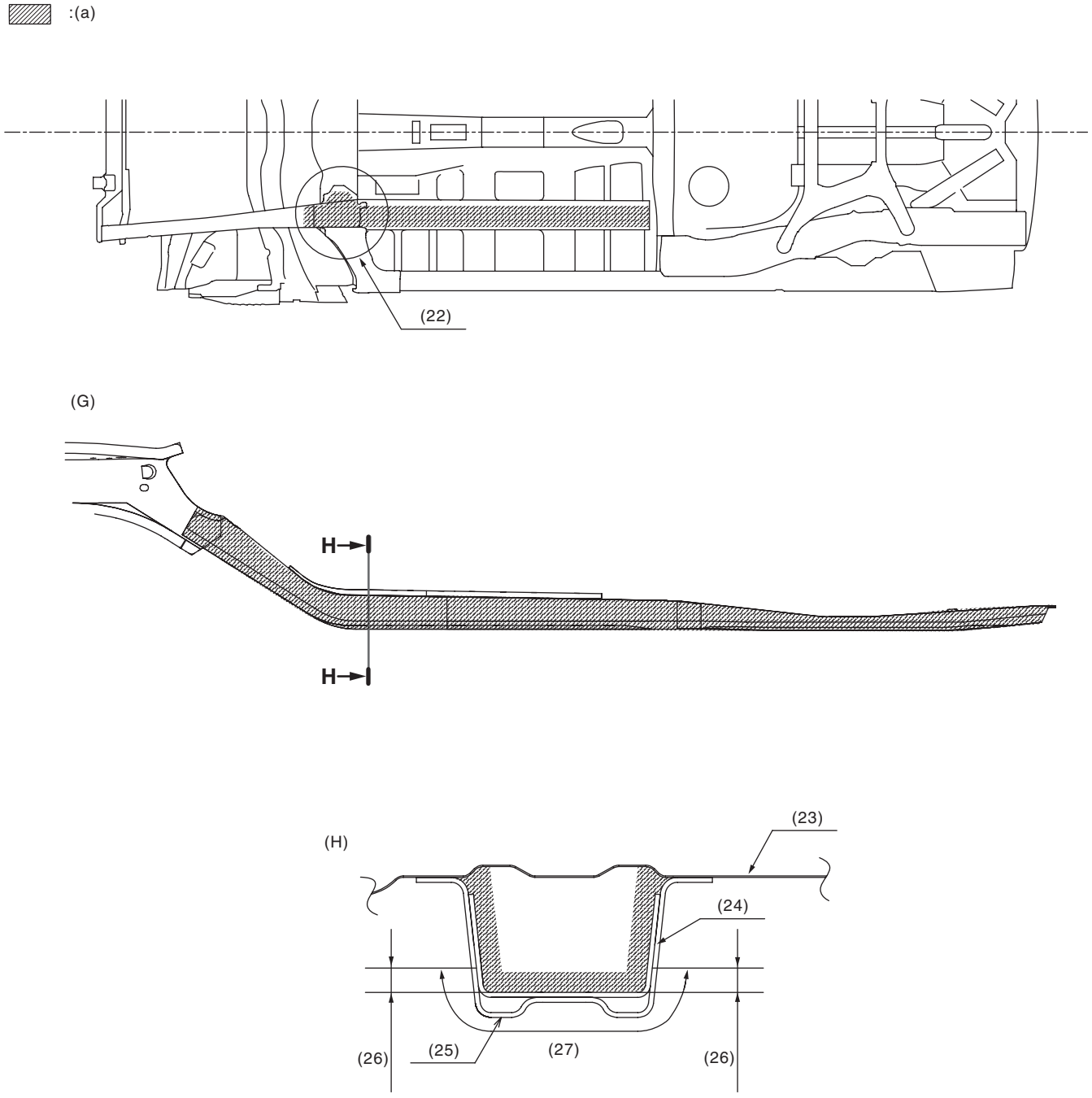
BS-01683

(a) Rust-stop aerosol

(C) View C
(D) View D
(E) Cross section E — E
(F) Cross section F — F

(12) Hood stay bracket
(13) Wheel apron upper
(14) Damper bracket
(15) Side frame
(16) Closing plate
(17) Anchor bracket
(18) Apply to the mating surface between the hood stay bracket and wheel apron upper. (Application thickness: 15 μm or more)
(19) Apply to side frame weld seam. (Application thickness: 15 μm or more)
(20) Apply to the anchor bracket, closing plate and side frame mating surfaces. (Application range: 58 mm, application thickness: 50 μm or more)
(21) Application position

- Bottom view



BS-01710

(a) Rust-stop aerosol

(G) Side frame side view

(H) Cross section H — H (Application thickness: 20 μm or more)

(22) Apply to the inside of suspension bracket.

(23) Floor pan

(24) Reinforcement

(25) Side frame

(26) 10 mm (0.39 in)

(27) Application thickness between this area: 50 μm or more

11.Undercoat

A: SPECIFICATION

Repair material:
Three Bond 6115

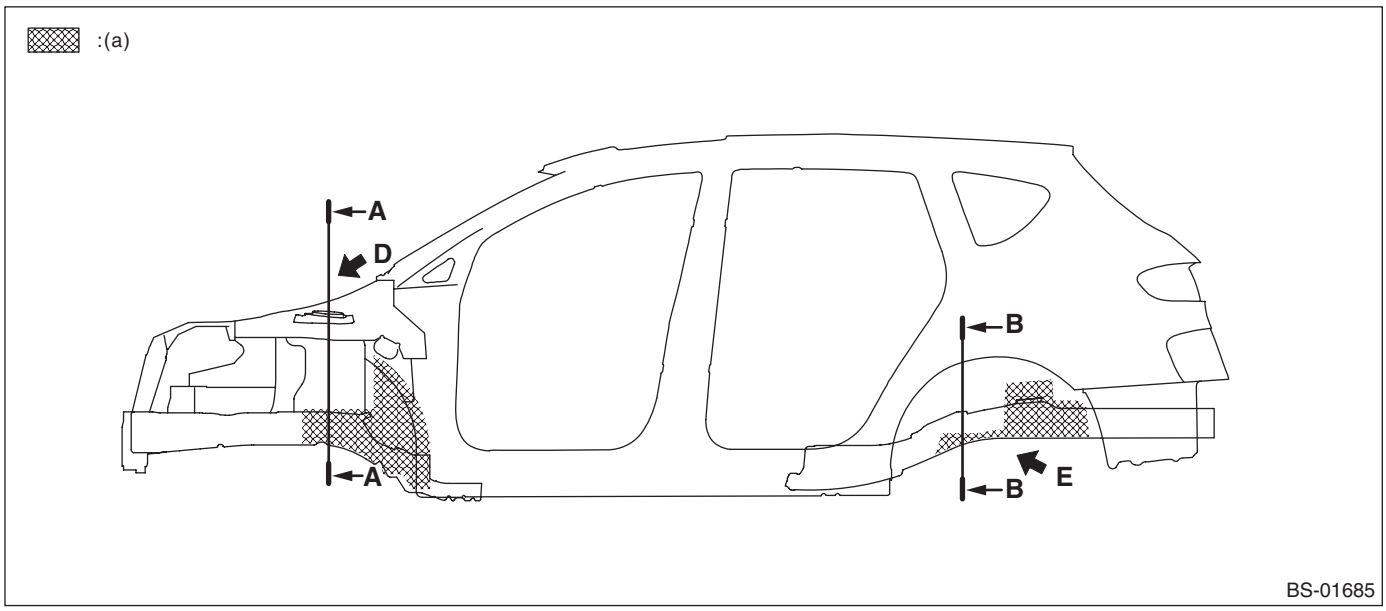
1) Perform masking so that the undercoat will not become attached to locations other than shown and to the following locations.

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

2) Application area and application thickness

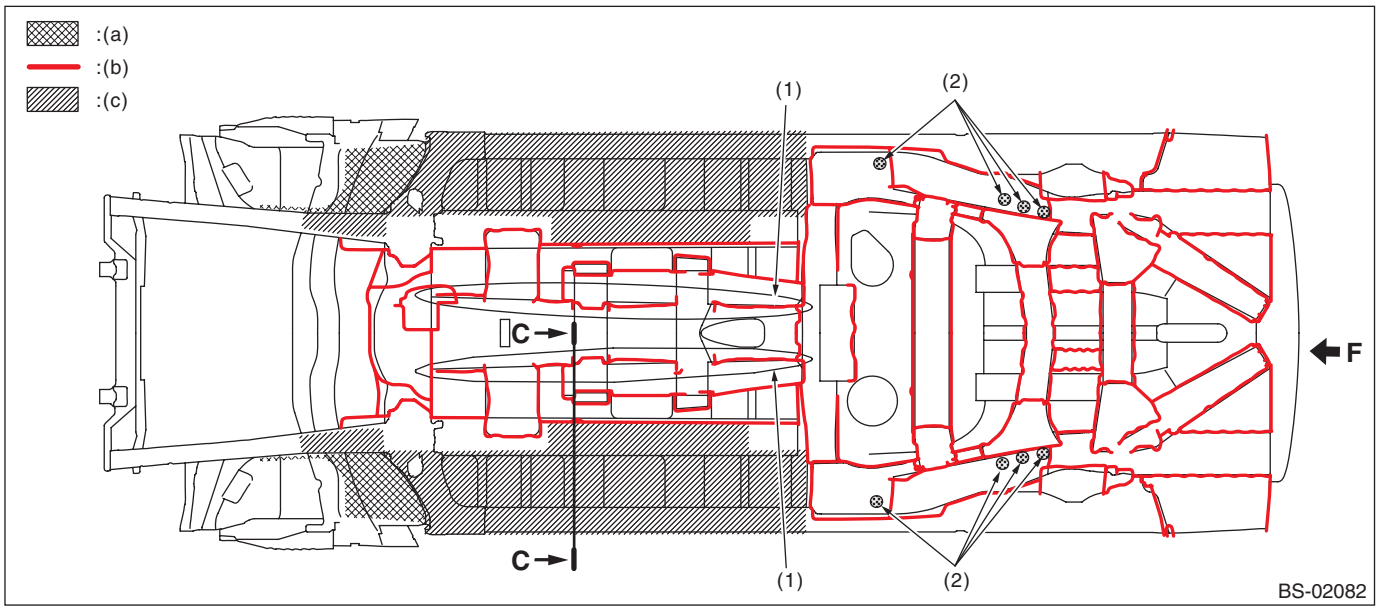
	300 μm or more
	600 μm or more

- Side view



(a) 600 μm or more

- Bottom view



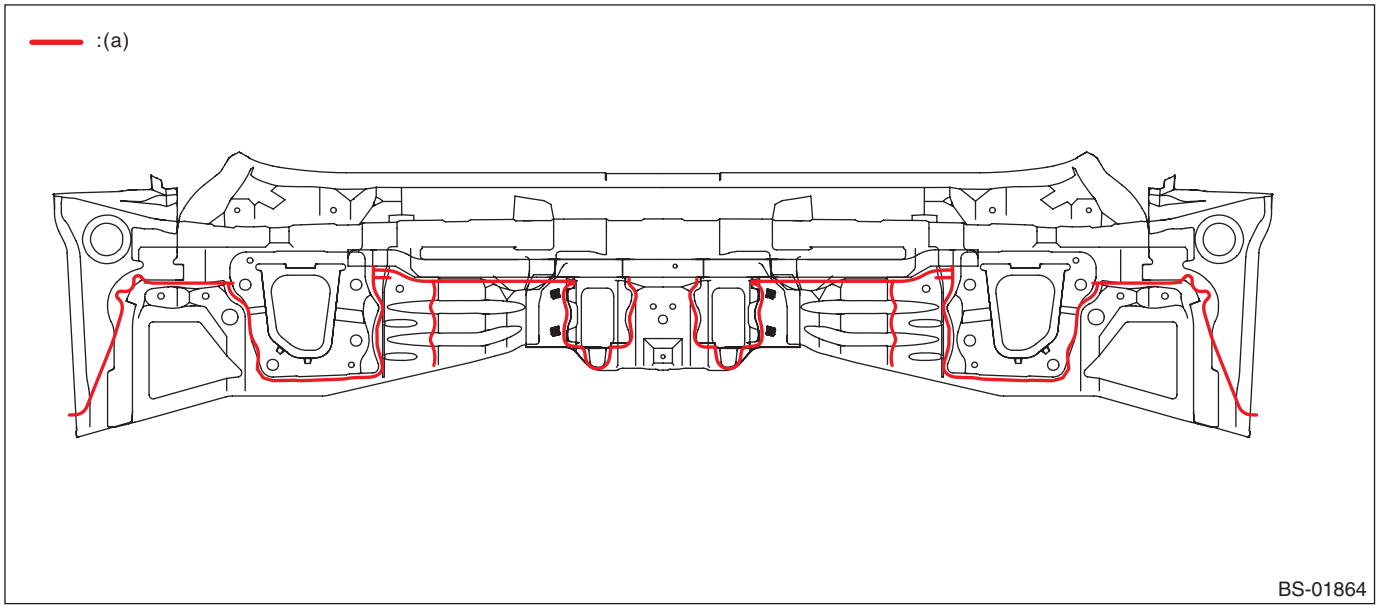
(a) 600 μm or more

(b) 600 μm or more. The panel gap shall be filled.

(c) 300 μm or more

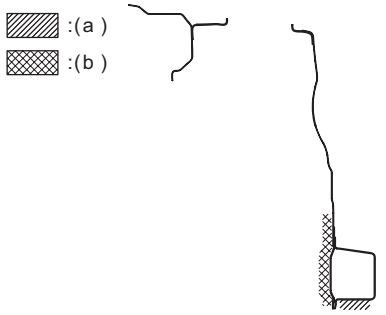
(1) Film thickness in this area should be 200 μm or more.

(2) Apply to the grommet.



(a) 600 μm or more. The panel gap shall be filled.

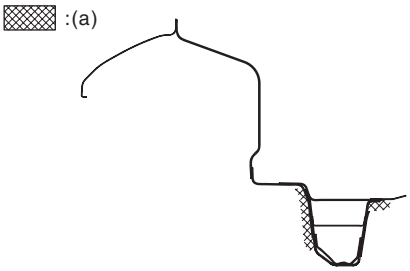
Cross section A — A



BS-02105

(a) 300 μm or more
(b) 600 μm or more

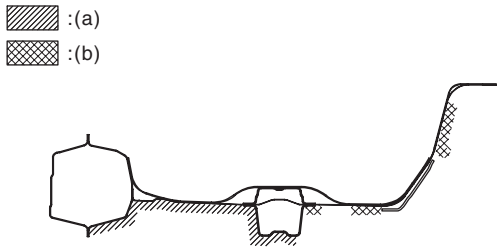
Cross section B — B



BS-01689

(a) 600 μm or more

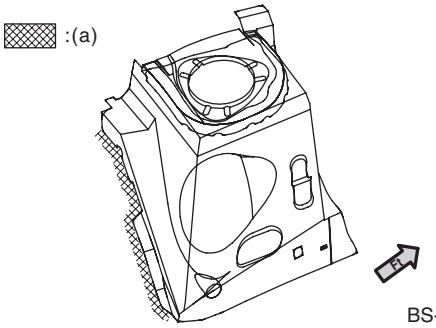
Cross section C — C (rotated 90°)



BS-01690

(a) 300 μm or more
(b) 600 μm or more. The panel gap shall be filled.

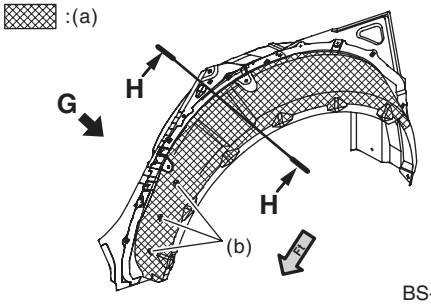
View D



BS-01691

(a) 600 μm or more

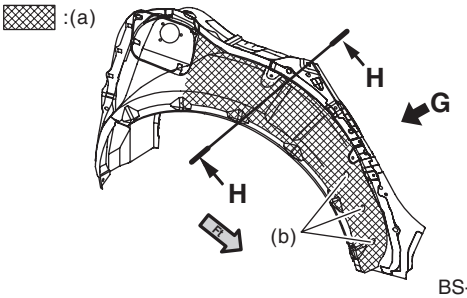
View E (LH)



BS-01692

(a) 600 μm or more
(b) Also apply to the grommets.

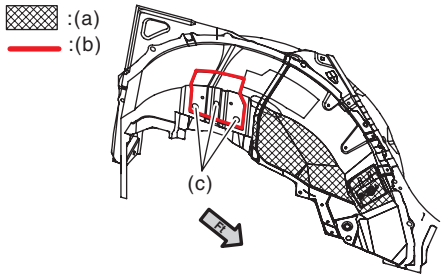
View E (RH)



BS-01693

(a) 600 μm or more
(b) Also apply to the grommets.

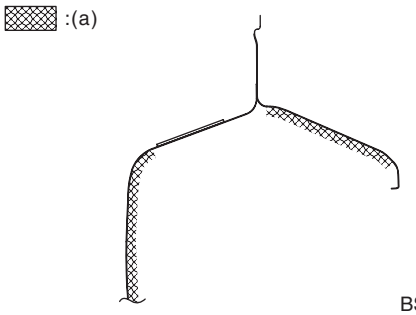
View G (LH, RH)



BS-01753

(a) 600 μm or more
(b) 600 μm or more. The panel gap shall be filled.
(c) The holes shall be filled.

Cross section H — H



BS-01695

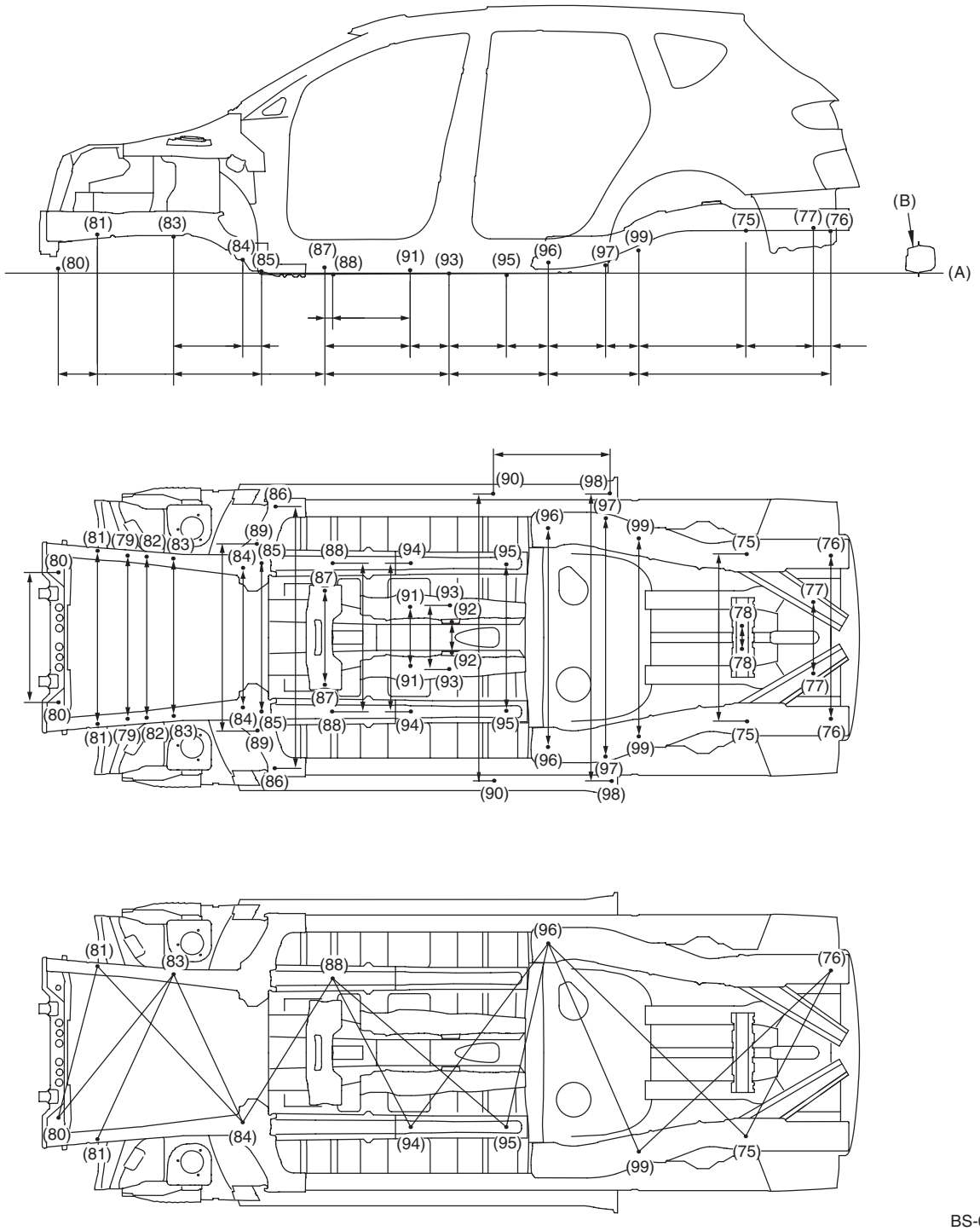
(a) 600 μm or more

12.Body Reference Points

A: DIMENSIONS

1. CENTER STRUCTURE

NOTE:
- Longitudinal dimensions are projected dimensions.
- 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. The values in brackets are projected dimensions for reference.



BS-01612

Body Reference Points

(A) Standard line

(B) Side sill

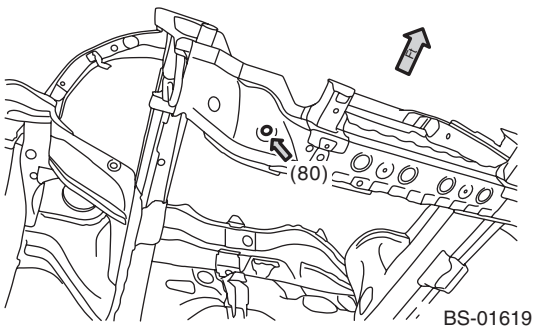
(75) Sub frame mounting hole (symmetrical)
(76) Muffler cover mounting hole (symmetrical)
(77) Trailer hitch mounting hole (symmetrical)
(78) Support sub frame mounting hole (symmetrical)
(79) Compression member mounting hole (symmetrical)
(80) Paint drain hole (symmetrical)
(81) Gauge hole (symmetrical)
(82) Front crossmember mounting hole (symmetrical), front
(83) Front crossmember mounting hole (symmetrical), rear
(84) Bushing rear mounting hole (symmetrical)
(85) Suspension plate mounting hole (symmetrical)
(86) Gauge hole (symmetrical)
(87) Crossmember mounting hole (symmetrical)
(88) Gauge hole (symmetrical)
(89) Suspension plate mounting hole (symmetrical)
(90) Side sill spoiler mounting hole (symmetrical)
(91) Gauge hole (symmetrical)
(92) Center bearing mounting hole
(93) Exhaust cover mounting hole (symmetrical)
(94) Gauge hole (symmetrical)
(95) Gauge hole (symmetrical)
(96) Tank protector mounting hole (symmetrical)
(97) Tie-down plate mounting hole (symmetrical)
(98) Side spoiler mounting hole (symmetrical)
(99) Sub frame mounting hole (symmetrical)

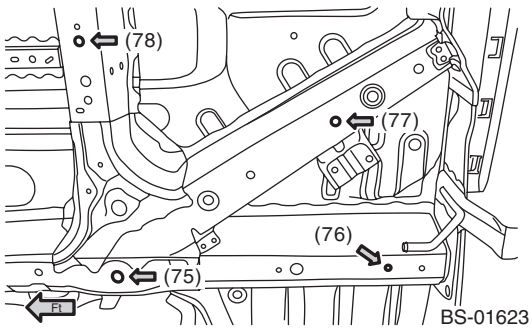
Measurement point	Datum dimension mm (in)
Datum line — (75)	225 (8.86)
Datum line — (76)	228 (8.98)
Datum line — (77)	238 (9.37)
Datum line — (80)	27 (1.06)
Datum line — (81)	204 (8.03)
Datum line — (83)	218 (8.58)
Datum line — (84)	70 (2.76)
Datum line — (85)	10 (0.39)
Datum line — (87)	30 (1.18)
Datum line — (88)	-10 (-0.39)
Datum line — (91)	16 (0.63)
Datum line — (93)	-5 (-0.20)
Datum line — (95)	-7 (-0.28)
Datum line — (96)	62 (2.44)
Datum line — (97)	45 (1.77)
Datum line — (99)	124 (4.88)
(75) — (77)	362 (14.25)
(75) — (99)	573 (22.56)
(76) — (77)	93 (3.66)
(76) — (99)	1,028 (40.47)
(80) — (81)	210 (8.27)
(81) — (83)	408 (16.06)
(83) — (84)	370 (14.57)
(83) — (85)	471 (18.54)
(84) — (85)	101 (3.98)
(85) — (87)	339 (13.35)
(87) — (88)	42 (1.65)
(87) — (91)	457 (17.99)
(87) — (93)	665 (26.18)
(88) — (91)	415 (16.34)
(91) — (93)	208 (8.19)
(93) — (95)	307 (12.09)

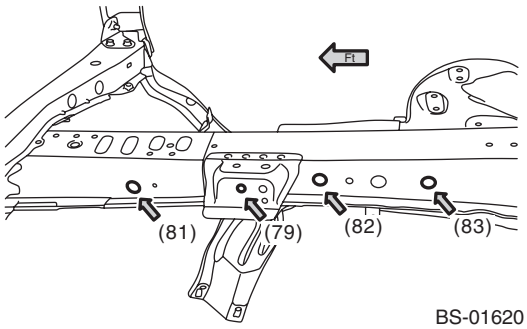
Measurement point	Datum dimension mm (in)
(93) — (96)	563 (22.17)
(95) — (96)	256 (10.08)
(96) — (97)	276 (10.87)
(96) — (99)	455 (17.91)
(97) — (99)	179 (7.05)
(75) RH — (75) LH	895 (35.24)
(76) RH — (76) LH	876 (34.49)
(77) RH — (77) LH	376 (14.80)
(78) RH — (78) LH	120 (4.72)
(79) RH — (79) LH	868 (34.17)
(80) RH — (80) LH	696 (27.40)
(81) RH — (81) LH	926 (36.46)
(82) RH — (82) LH	862 (33.94)
(83) RH — (83) LH	840 (33.07)
(84) RH — (84) LH	746 (29.37)
(85) RH — (85) LH	796 (31.34)
(86) RH — (86) LH	1,402 (55.20)
(87) RH — (87) LH	504 (19.84)
(88) RH — (88) LH	796 (31.34)
(89) RH — (89) LH	1,002 (39.45)
(90) RH — (90) LH	1,536 (60.47)
(91) RH — (91) LH	320 (12.60)
(92) RH — (92) LH	168 (6.61)
(93) RH — (93) LH	343 (13.50)
(94) RH — (94) LH	796 (31.34)
(95) RH — (95) LH	796 (31.34)
(96) RH — (96) LH	1,167 (45.94)
(97) RH — (97) LH	1,280 (50.39)
(98) RH — (98) LH	1,536 (60.47)
(99) RH — (99) LH	1,060 (41.73)
(75) RH — (76) LH	996 (39.21)
(75) RH — (96) LH	1,465 (57.68)

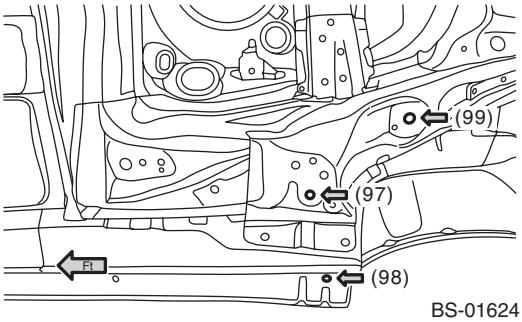
Measurement point	Datum dimension mm (in)
(76) LH — (99) RH	1,416 (55.75)
(80) RH — (81) LH	856 (33.70)
(80) RH — (83) LH	1,004 (39.53)
(81) RH — (83) LH	973 (38.31)
(81) LH — (84) RH	1,150 (45.28)
(83) LH — (84) RH	887 (34.92)
(84) RH — (88) LH	913 (35.94)
(88) LH — (94) RH	899 (35.39)
(88) LH — (95) RH	1,224 (48.19)
(94) RH — (96) LH	1,248 (49.13)
(95) RH — (96) LH	1,017 (40.04)
(96) LH — (99) RH	1,204 (47.4)

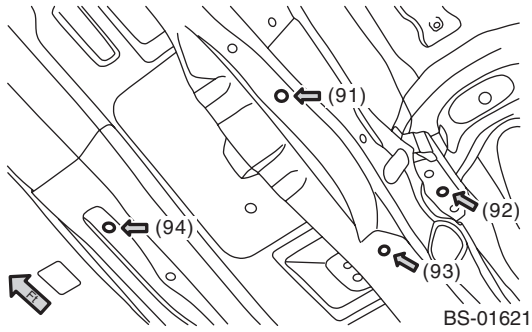
NOTE:
- Other datum points except for (92) are symmetrical.
- Longitudinal dimensions are projected dimensions.
- Height dimensions are the vertical distances from the gauge point on the assumed horizontal line through the side sill flange joint (bending angle point).
- Diagonal dimensions are the actual dimensions between reference points.
- The left and right dimensions are the actual dimensions between reference points.



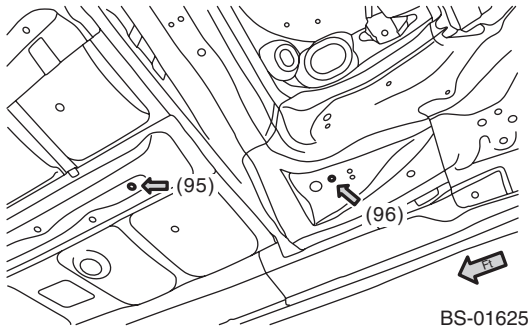




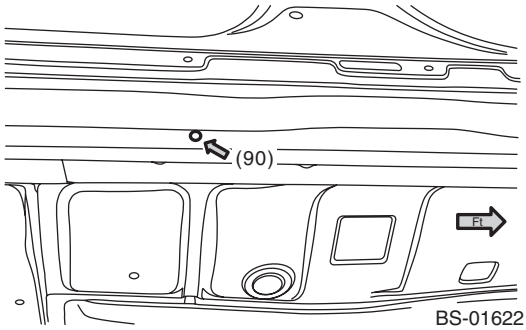




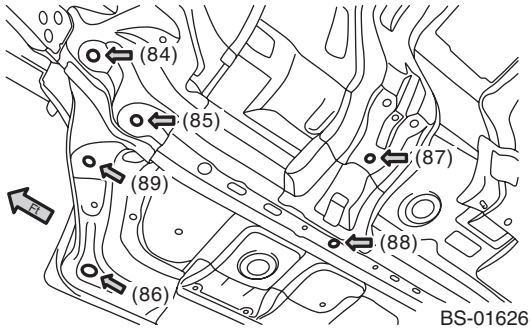
BS-01621



BS-01625

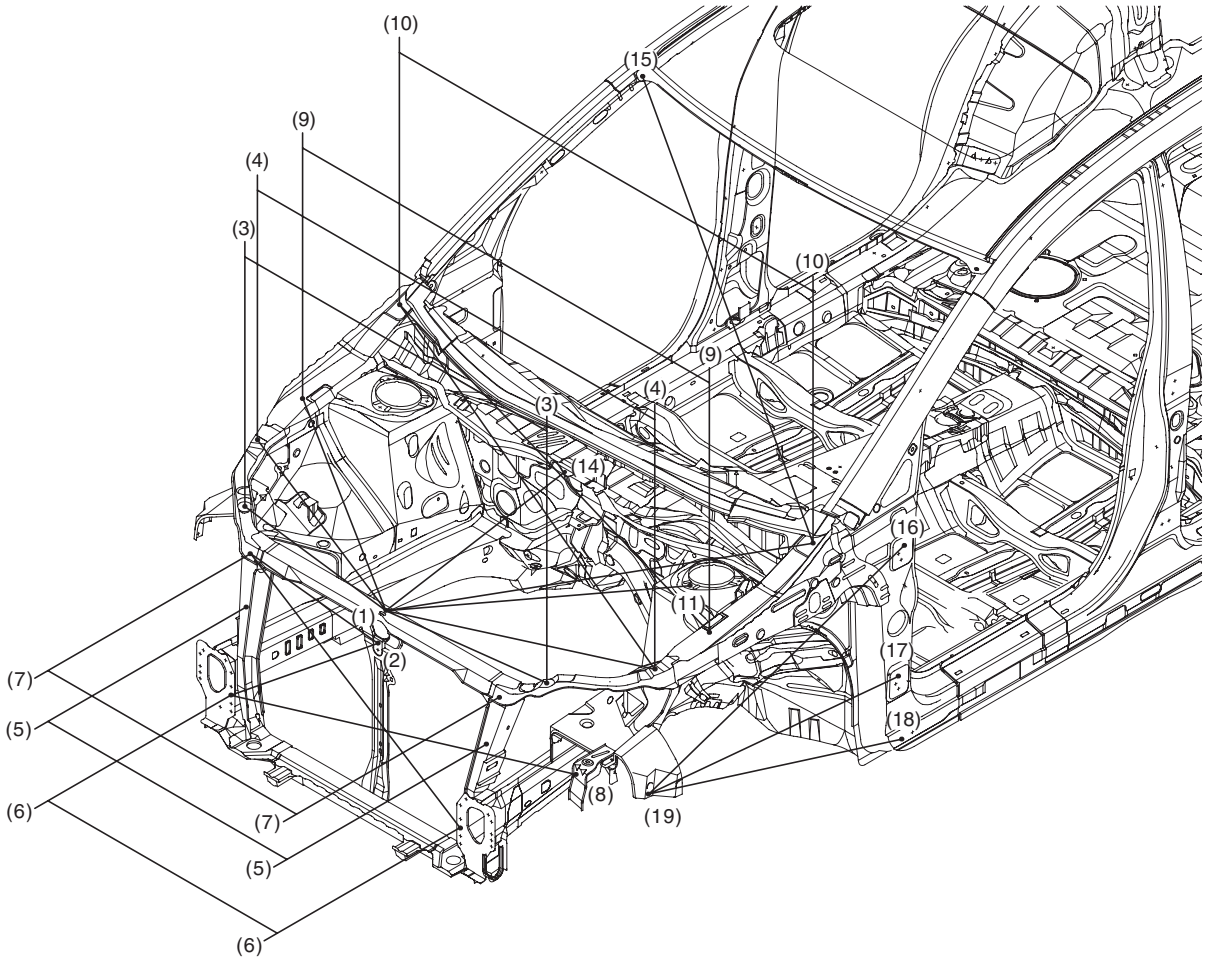


BS-01622



BS-01626

2. FRONT STRUCTURE



BS-01613

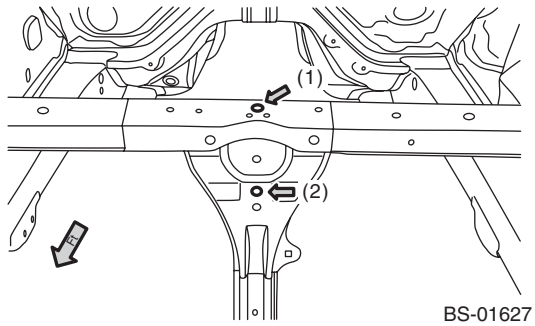
(1) Cover upper front mounting hole
(2) Hood lock attachment hole
(3) Headlight temporal supporting hole
(4) Fender drip bracket mounting hole (symmetrical)
(5) Corner bracket mounting hole (symmetrical)
(6) Bumper beam mounting hole (symmetrical)
(7) Corner bracket mounting hole (symmetrical)
(8) Harness mounting hole
(9) Fender drip bracket mounting hole (symmetrical)
(10) Assemblies hole (symmetrical)
(11) Strut mount mounting hole (symmetrical), front
(14) Assemblies hole
(15) Glass mounting hole (symmetrical)
(16) Front door hinge upper mounting hole (symmetrical), upper side
(17) Front door hinge lower mounting hole (symmetrical), upper side
(18) Front fender mounting hole (symmetrical), rear
(19) Front fender mounting hole (symmetrical), front

Measurement point	Datum dimension mm (in)
(1) — (3) RH	567 (22.32)
(1) — (3) LH	567 (22.32)
(1) — (4) RH	779 (30.67)

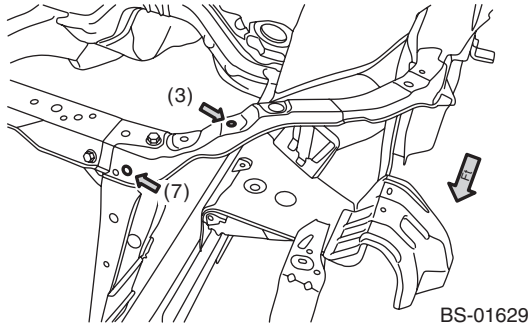
Measurement point	Datum dimension mm (in)
(1) — (4) LH	797 (31.38)
(1) — (9) RH	888 (34.96)
(1) — (10) LH	1,147 (45.16)

Measurement point	Datum dimension mm (in)
(1) — (11) LH	807 (31.77)
(1) — (14)	667 (26.26)
(2) — (6) RH	550 (21.65)
(2) — (7) RH	469 (18.46)
(3) — (3)	1,130 (44.49)
(4) — (4)	1,487 (58.54)
(4) LH — (10) RH	1,636 (64.41)
(5) — (5)	894 (35.20)
(6) — (6)	858 (33.78)
(6) LH — (7) RH	980 (38.58)
(6) RH — (8)	1,123 (44.21)
(7) — (7)	930 (36.61)
(9) — (9)	1,522 (59.92)
(9) LH — (10) RH	1,584 (62.36)
(10) — (10)	1,548 (60.94)
(10) LH — (15) RH	1,651 (65.00)
(16) RH — (19) RH	1,019 (40.12)
(17) RH — (19) RH	954 (37.56)
(18) RH — (19) RH	1,016 (40.00)

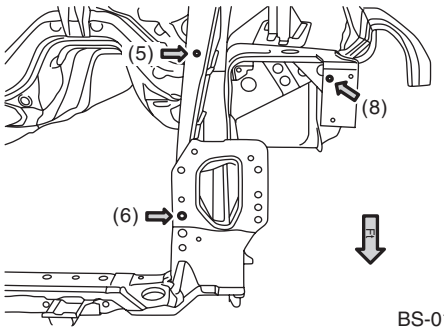
NOTE:
- The reference points (1) and (2) are at the body center, while the other points except for (3), (4), (8) and (14) are left-right symmetrical.
- The dimensions are the actual dimensions between the reference points.



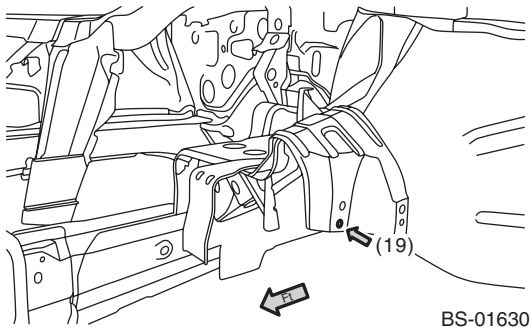
BS-01627



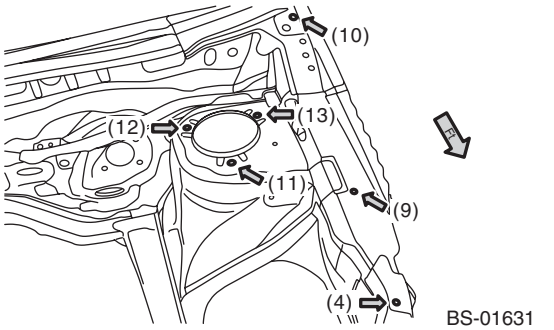
BS-01629



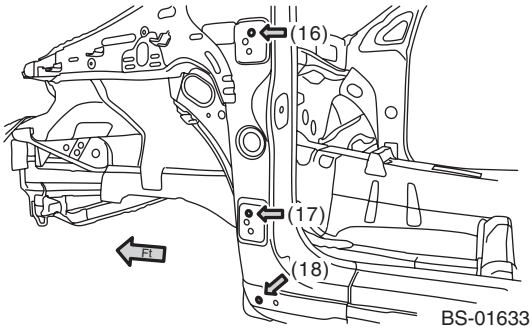
BS-01628



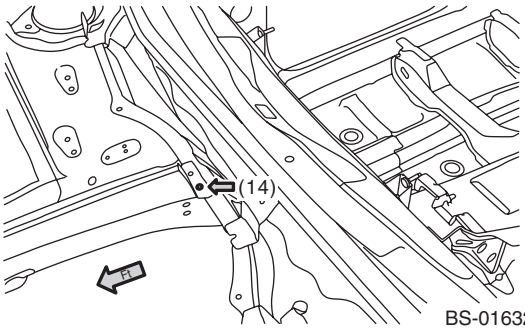
BS-01630



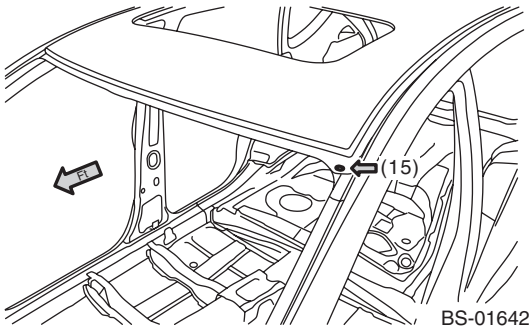
BS-01631



BS-01633



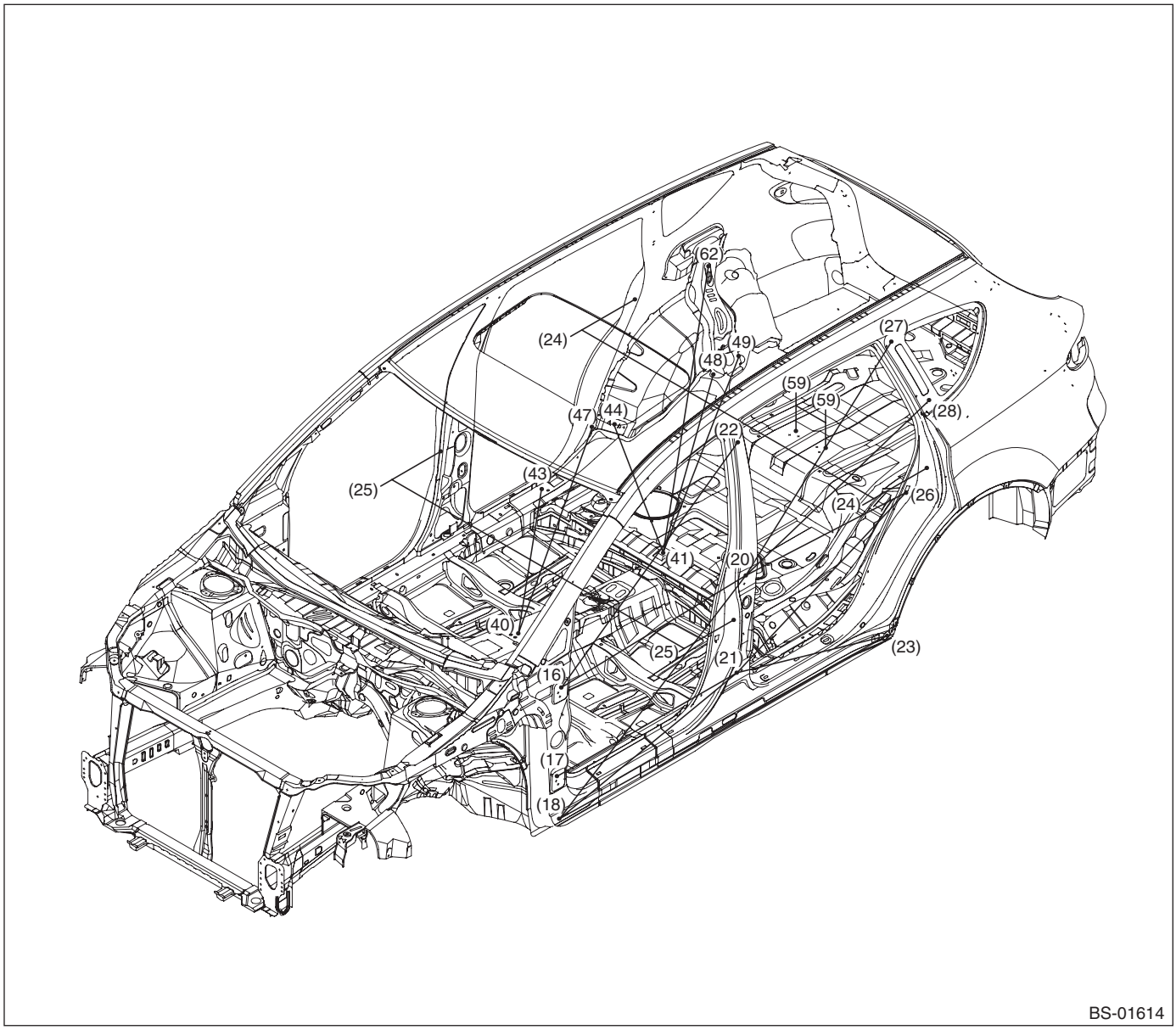
BS-01632



BS-01642

3. INSIDE

- View 1



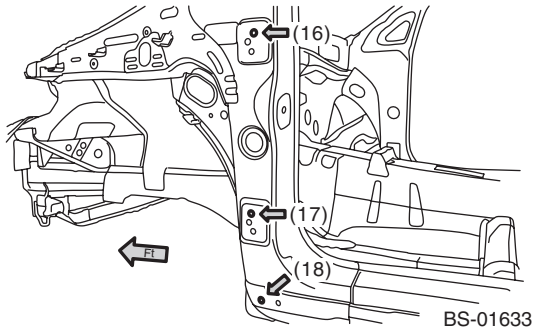
(20) Rear door hinge upper mounting hole (symmetrical), upper
(21) Rear door hinge lower mounting hole (symmetrical), front
(22) Door seal mounting hole (symmetrical)
(23) End cover mounting hole (symmetrical)
(24) Rear door striker mounting hole (symmetrical), upper
(25) Front door striker mounting hole (symmetrical), upper
(26) Door switch mounting hole (symmetrical)
(27) Rear quarter glass clip mounting hole (symmetrical), upper
(28) Rear quarter glass clip mounting hole (symmetrical), lower
(40) Hand brake mounting hole
(41) Floor mat mounting hole
(43) Piping cover mounting hole (symmetrical)
(44) Belt anchor mounting hole (symmetrical)
(47) Trim mounting hole (symmetrical)
(48) Damper mounting hole (symmetrical), front
(49) Damper mounting hole (symmetrical), rear
(59) Third seat hinge mounting hole (symmetrical)
(62) Assemblies hole (symmetrical)

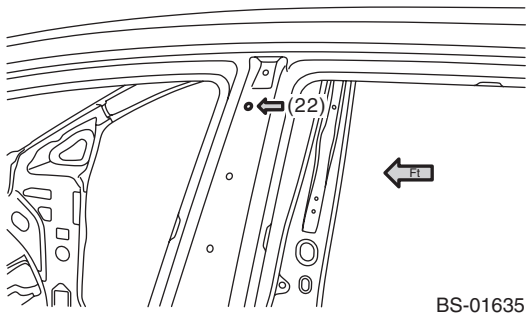
Measurement point	Datum dimension mm (in)
(16) LH — (20) LH	1,017 (40.04)

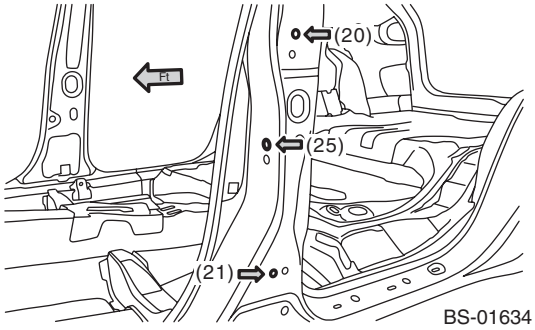
Measurement point	Datum dimension mm (in)
(16) LH — (22) LH	1,242 (48.90)
(17) LH — (21) LH	990 (38.98)

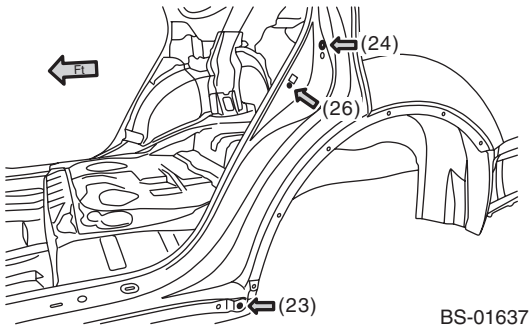
Measurement point	Datum dimension mm (in)
(18) LH — (20) LH	1,212 (47.72)
(18) LH — (21) LH	997 (39.25)
(18) LH — (23) LH	1,771 (69.72)
(20) LH — (26) LH	954 (37.56)
(20) LH — (27) LH	1,124 (44.25)
(20) LH — (28) LH	1,111 (43.74)
(21) LH — (23) LH	825 (32.48)
(21) LH — (26) LH	1,049 (41.30)
(24) — (24)	1,610 (63.39)
(25) — (25)	1,612 (63.46)
(40) — (43) RH	1,125 (44.29)
(40) — (47) RH	1,375 (54.13)
(41) — (44) RH	822 (32.36)
(41) — (48) RH	1,031 (40.59)
(41) — (49) RH	1,150 (45.28)
(41) — (62) RH	1,309 (51.54)
(59) — (59)	163 (6.24)

NOTE:
- The reference points (40) and (41) are at the body center, while the other reference points are left-right symmetrical.
- The dimensions are the actual dimensions between the reference points.

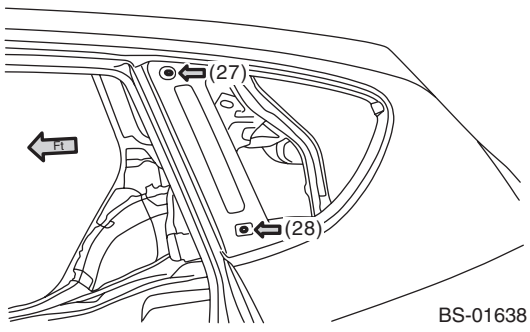




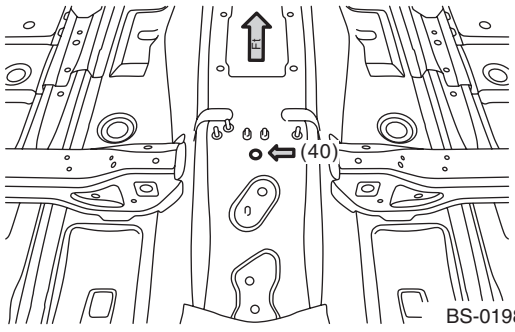




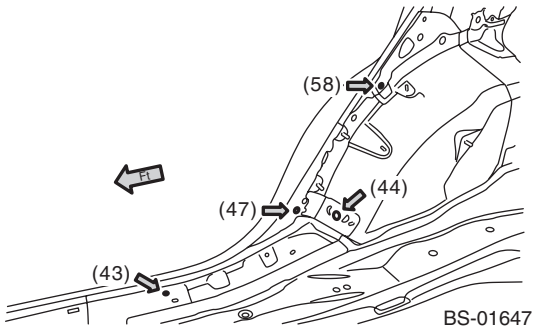
Body Reference Points



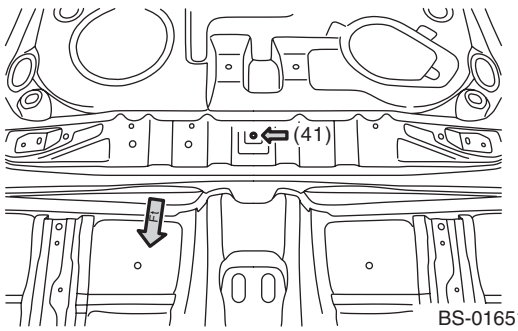
BS-01638



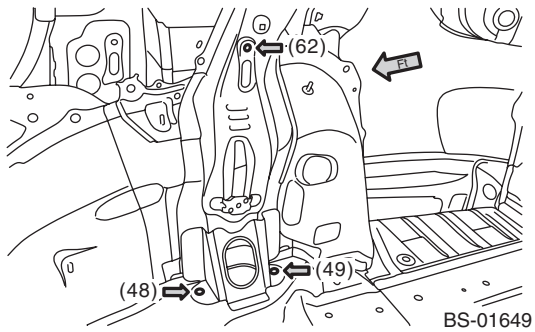
BS-01980



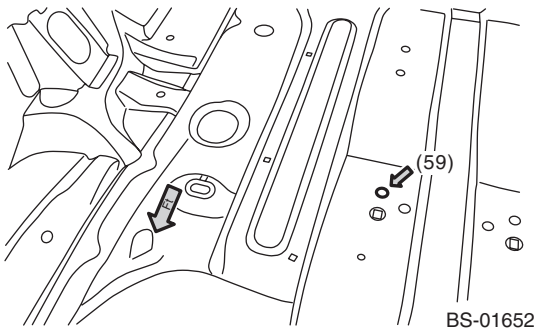
BS-01647



BS-01651

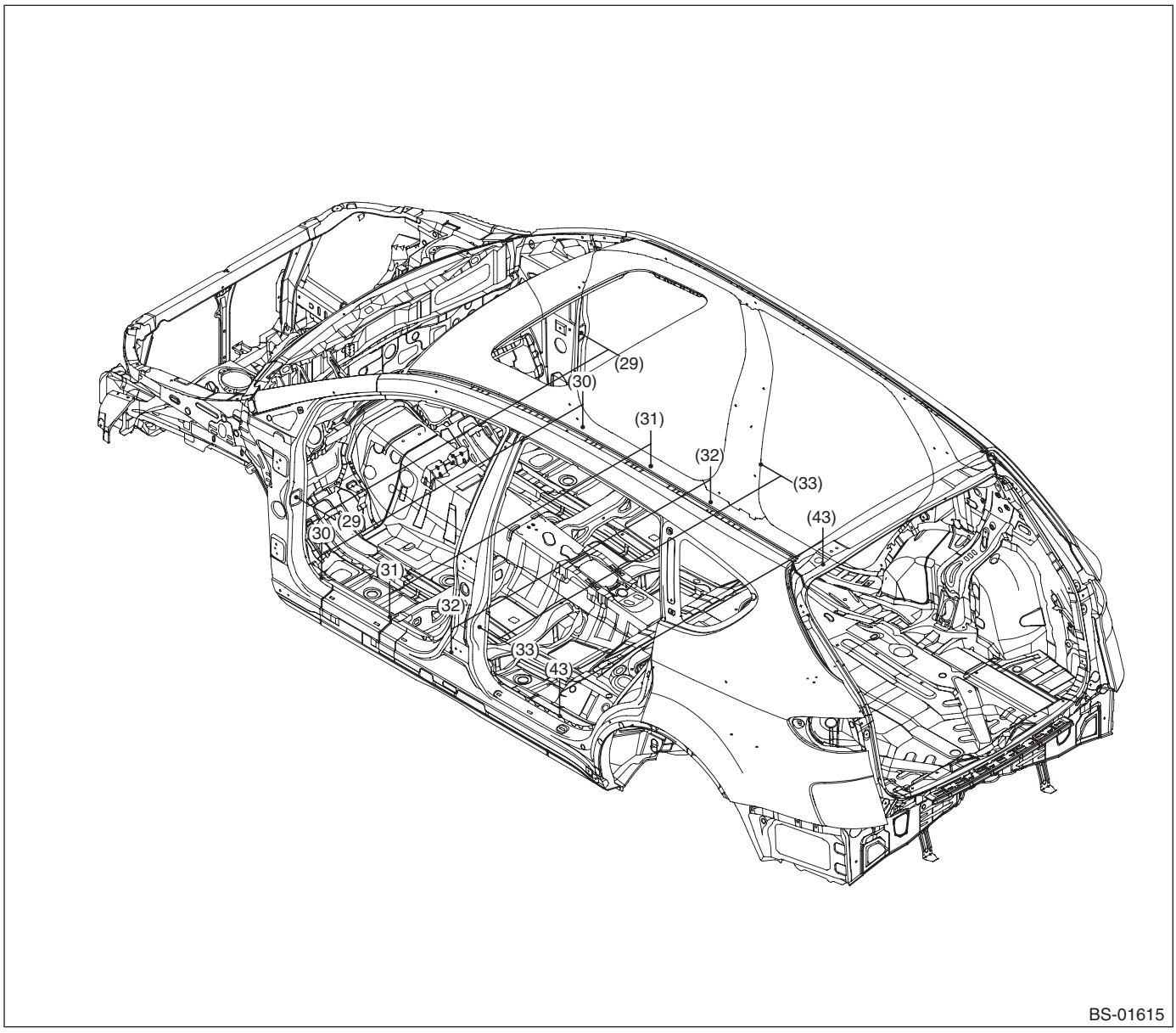


BS-01649



BS-01652

- View 2

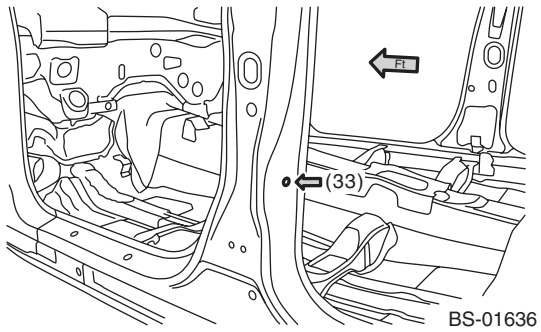


(29) Front door checker mounting hole (symmetrical)
(30) Harness clip attachment hole (symmetrical)
(31) Harness clip attachment hole (symmetrical)
(32) Harness clip attachment hole (symmetrical)
(33) Rear door checker mounting hole (symmetrical)

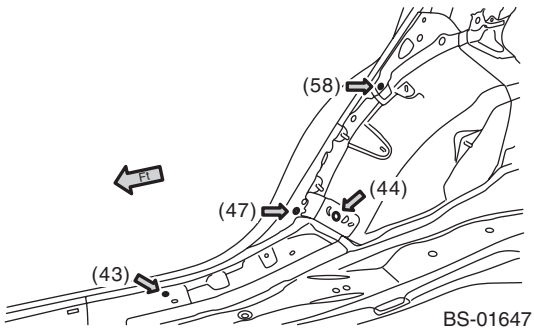
Measurement point	Datum dimension mm (in)
(29) — (29)	1,566 (61.65)
(30) — (30)	1,439 (56.65)
(31) — (31)	1,439 (56.65)

Measurement point	Datum dimension mm (in)
(32) — (32)	1,429 (56.26)
(33) — (33)	1,553 (61.14)
(43) — (43)	1,452 (57.17)

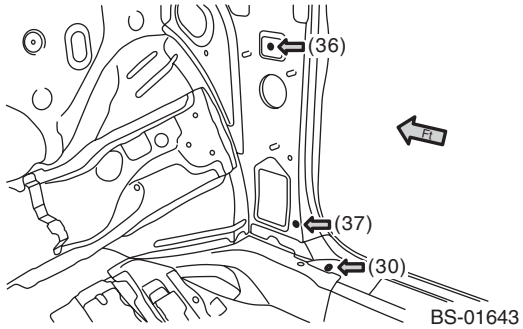
NOTE:
- All reference points are left-right symmetrical.
- The dimensions are the actual dimensions between the reference points.



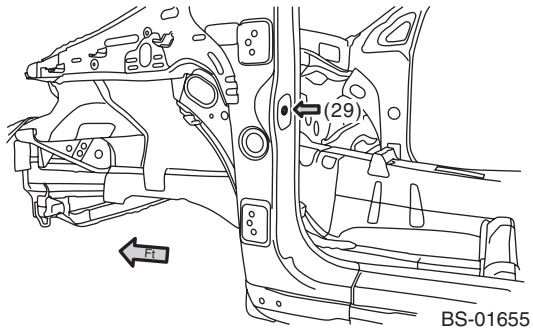
BS-01636



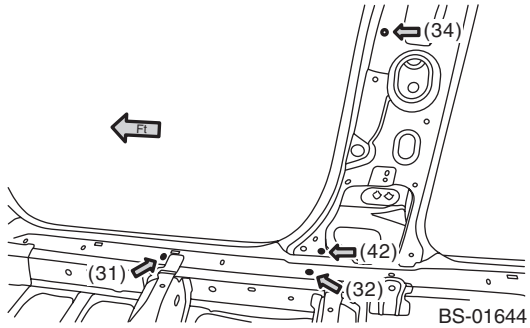
BS-01647



BS-01643

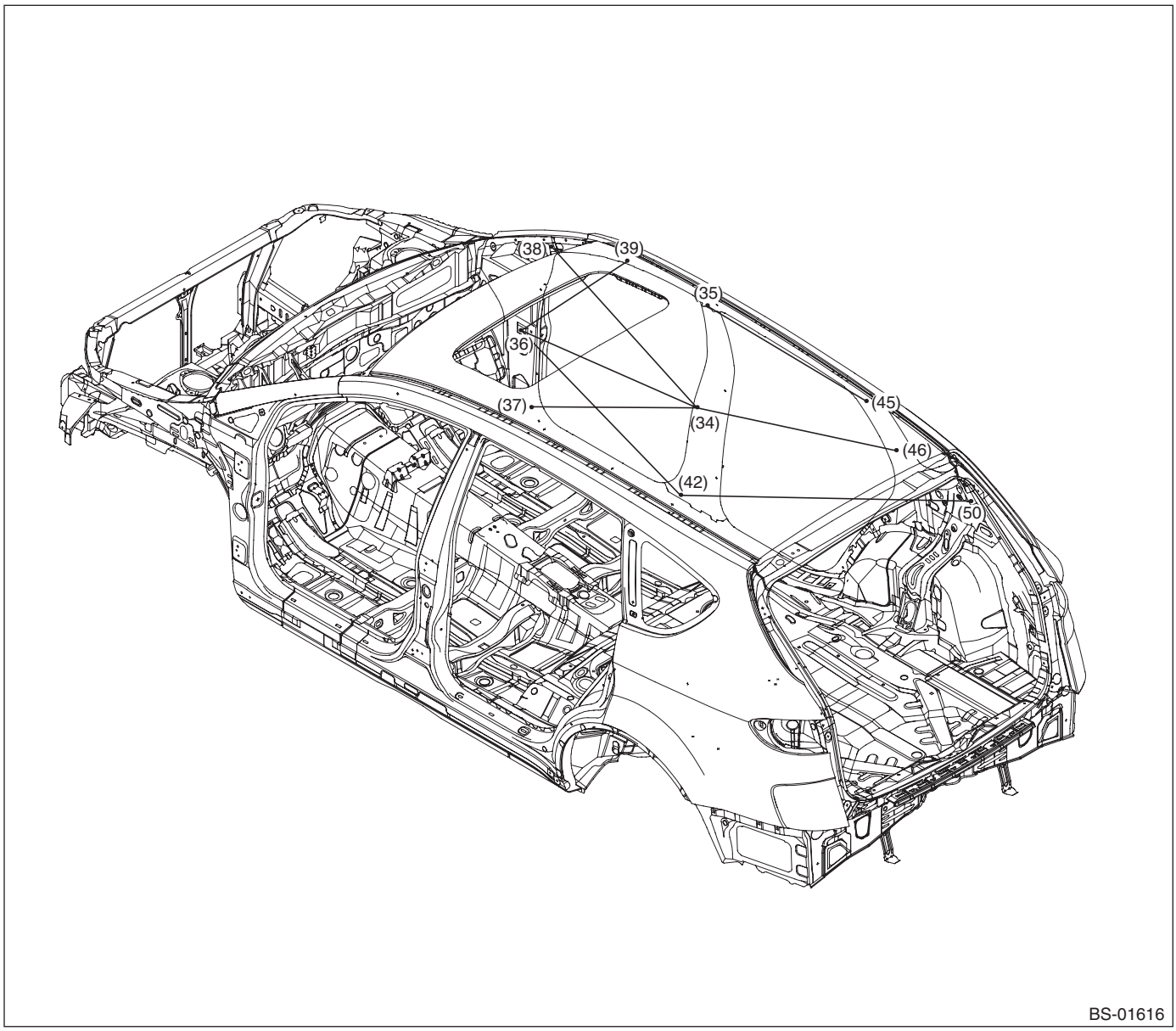


BS-01655



BS-01644

- View 3

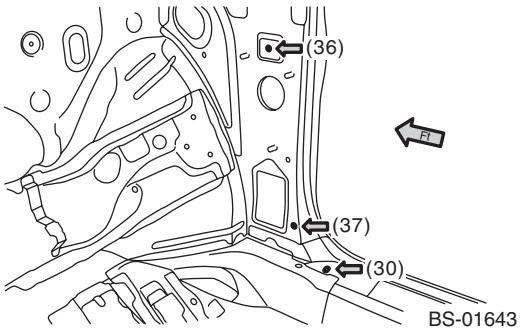


(34) B pillar trim mounting hole (symmetrical), upper
(35) Center pillar trim mounting hole (symmetrical)
(36) Harness protector mounting hole (symmetrical)
(37) Side sill cover mounting hole (symmetrical)
(38) A pillar trim mounting hole (symmetrical)
(39) A pillar pad mounting hole (symmetrical)
(42) B pillar trim mounting hole (symmetrical), lower
(45) C pillar trim mounting hole (symmetrical)
(46) Adjuster mounting hole (symmetrical)
(50) Assemblies hole (symmetrical)

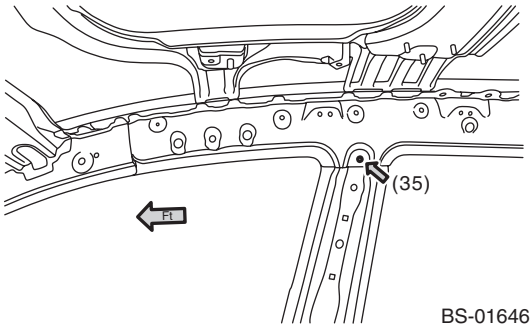
Measurement point	Datum dimension mm (in)
(34) RH — (36) RH	979 (38.54)
(34) RH — (37) RH	1,018 (40.08)
(34) RH — (38) RH	871 (34.29)
(34) RH — (46) RH	1,154 (45.43)
(35) RH — (45) RH	860 (33.86)
(36) RH — (39) RH	999 (39.33)

Measurement point	Datum dimension mm (in)
(36) RH — (42) RH	941 (37.05)
(42) RH — (50) RH	2,030 (79.92)

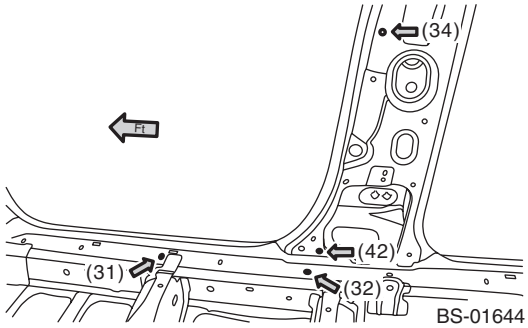
NOTE:
- All reference points are left-right symmetrical.
- The dimensions are the actual dimensions between the reference points.



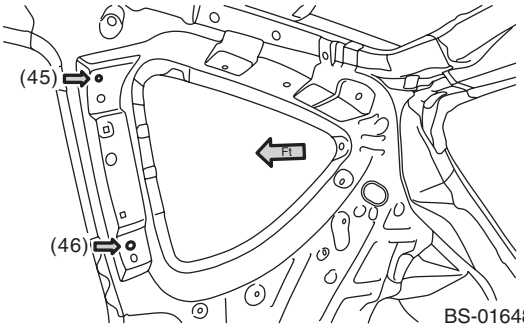
BS-01643



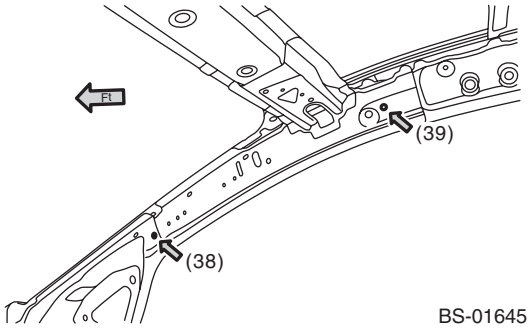
BS-01646



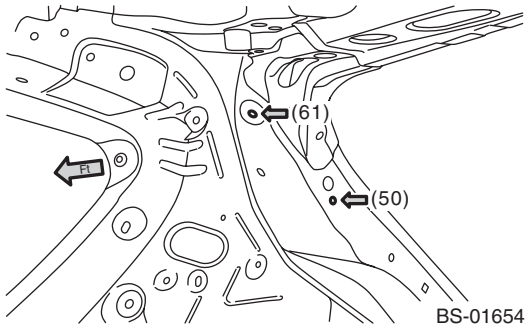
BS-01644



BS-01648

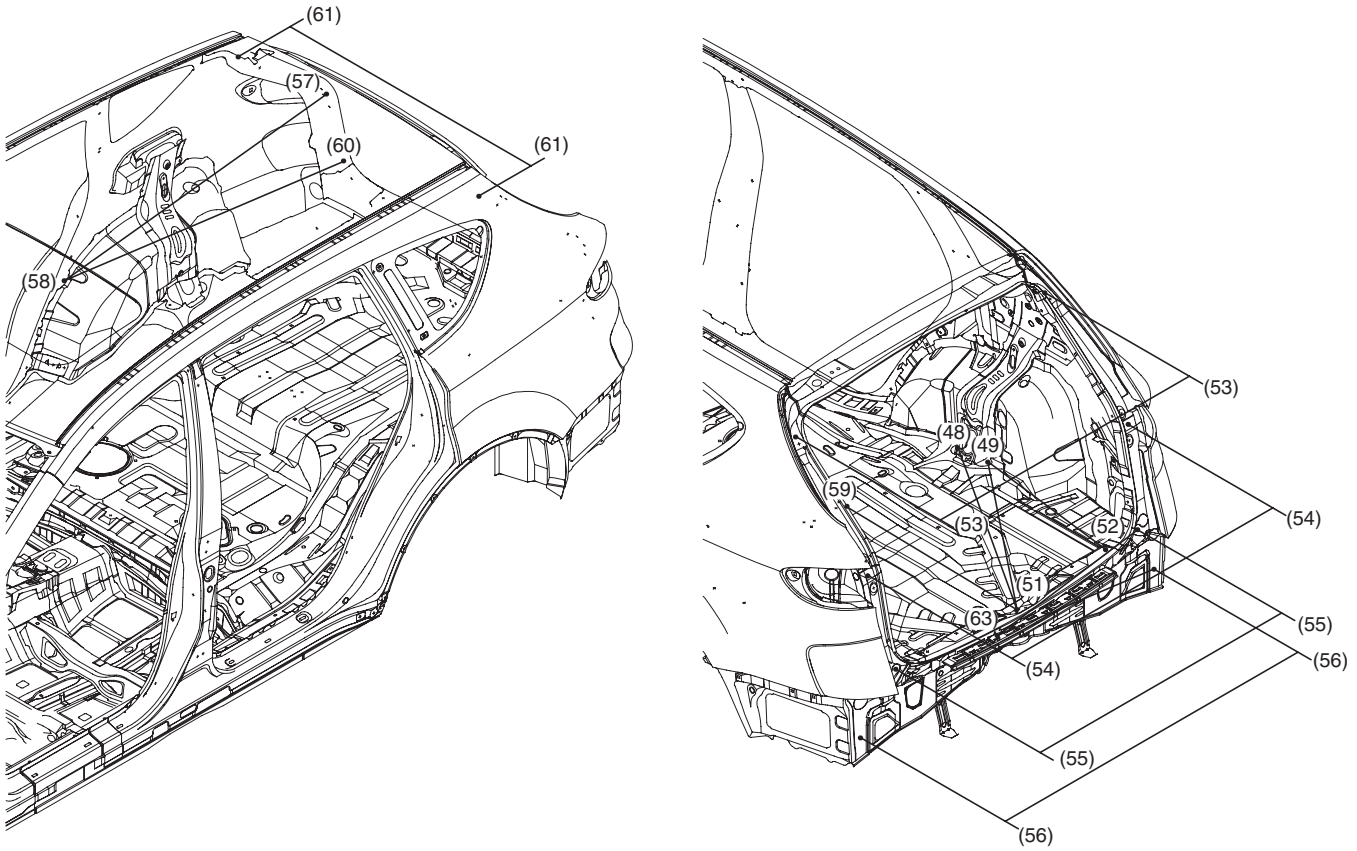


BS-01645



BS-01654

4. REAR



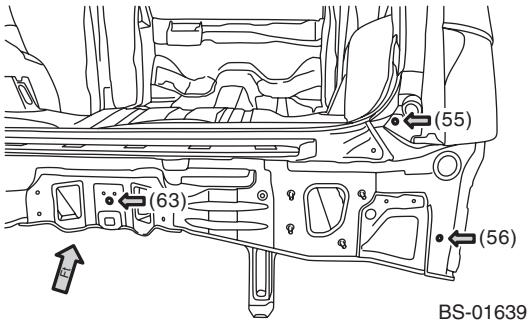
BS-01617

(51) Paint drain hole
(52) Edge rear mounting hole (symmetrical)
(53) Rear gate stay mounting hole (symmetrical), upper
(54) Gauge hole (symmetrical)
(55) D pillar cover mounting hole (symmetrical)
(56) Gauge hole (symmetrical)
(57) Retractor mounting hole (symmetrical)
(58) Trim mounting hole (symmetrical)
(60) Apron trim mounting hole (symmetrical)
(61) Harness mounting hole (symmetrical)
(63) Gauge hole

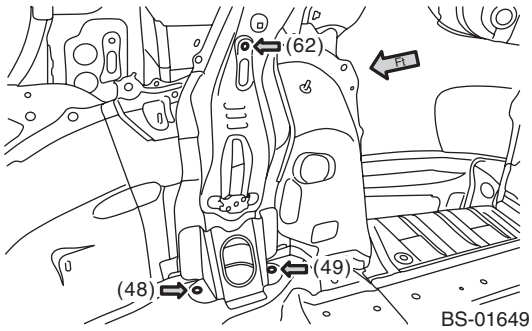
Measurement point	Datum dimension mm (in)
(48) RH — (51)	1,022 (40.24)
(49) RH — (51)	909 (35.79)
(49) RH — (52) RH	724 (28.50)
(51) — (59) RH	886 (34.88)
(53) — (53)	1,165 (45.87)
(54) — (54)	1,220 (48.03)
(55) — (55)	1,130 (44.49)

Measurement point	Datum dimension mm (in)
(55) RH — (63)	602 (23.70)
(56) — (56)	1,369 (53.90)
(56) RH — (63)	688 (27.09)
(57) RH — (58) RH	1,107 (43.58)
(58) RH — (60) RH	1,136 (44.72)
(61) — (61)	1,127 (44.37)

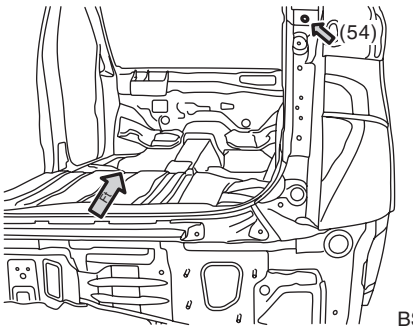
NOTE:
- The reference points (51) and (63) are at the body center, while the other points are left-right symmetrical.
- The dimensions are the actual dimensions between the reference points.



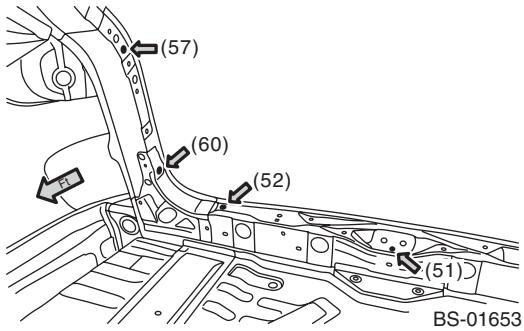
BS-01639



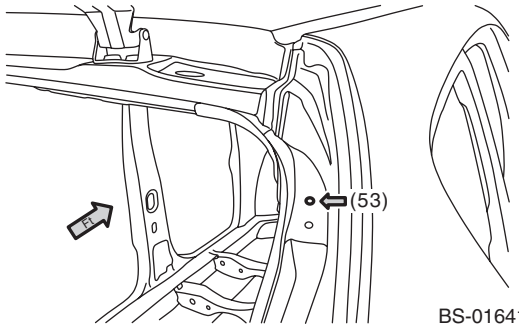
BS-01649



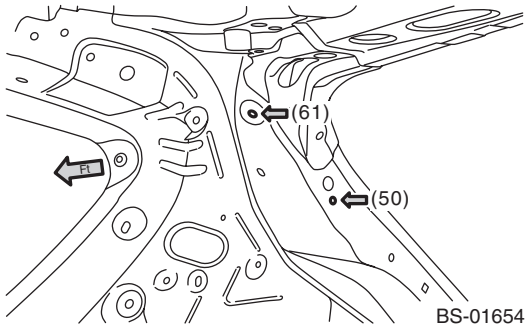
BS-01640



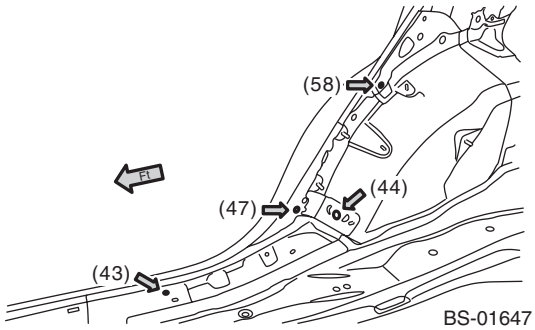
BS-01653



BS-01641

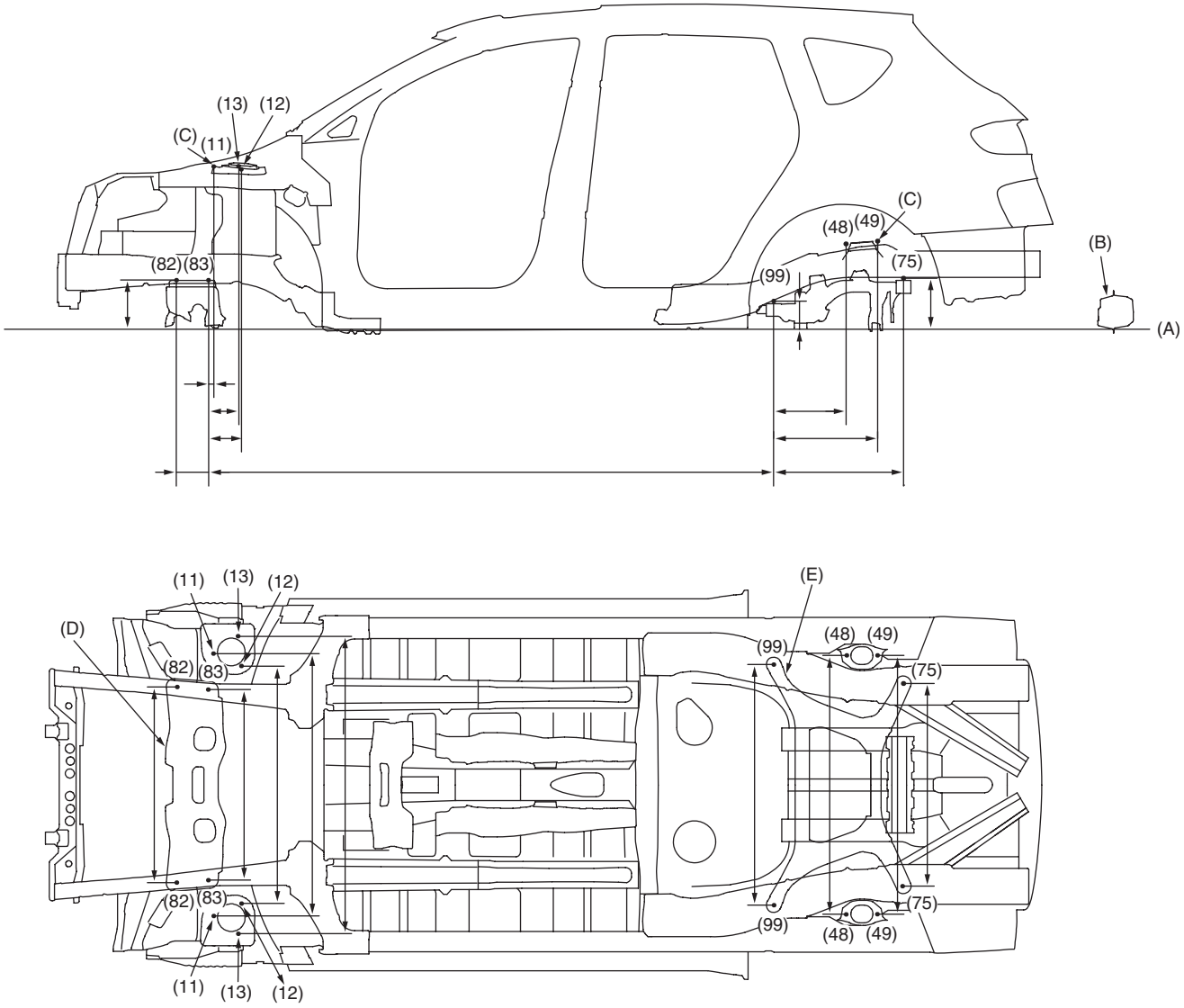


BS-01654



BS-01647

5. SUSPENSION MOUNT



BS-01618

Body Reference Points

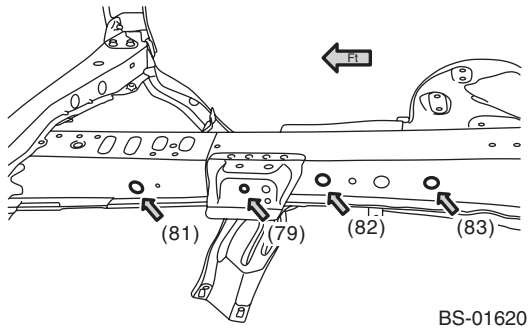
(A) Standard line
(B) Side sill
(C) Upper face
(D) Crossmember
(E) Sub frame

(11) Strut mount mounting hole (symmetrical), front
(12) Strut mount mounting hole (symmetrical), rear inside
(13) Strut mount mounting hole (symmetrical), rear outside
(48) Damper mounting hole (symmetrical), front
(49) Damper mounting hole (symmetrical), rear
(75) Sub frame mounting hole (symmetrical)
(82) Front crossmember mounting hole (symmetrical), front
(83) Front crossmember mounting hole (symmetrical), rear
(99) Sub frame mounting hole (symmetrical)

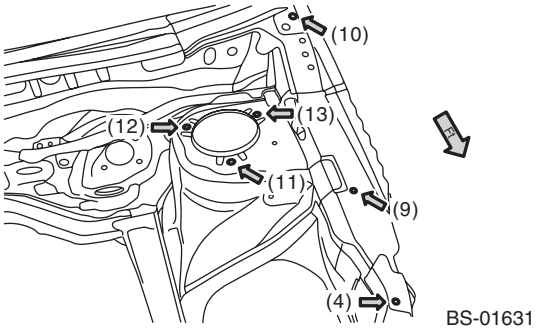
Measurement point	Datum dimension mm (in)
Datum line — (75)	225 (8.86)
Datum line — (82)	218 (8.58)
Datum line — (83)	218 (8.58)
Datum line — (99)	124 (4.88)
(11) — (83)	23 (0.91)
(12) — (83)	144 (5.67)
(13) — (83)	132 (5.20)
(48) — (99)	319 (12.56)
(49) — (99)	459 (18.07)
(75) — (99)	573 (22.56)

Measurement point	Datum dimension mm (in)
(82) — (83)	144 (5.67)
(83) — (99)	2,492 (98.11)
(11) — (11)	1,156 (45.51)
(12) — (12)	1,046 (41.18)
(13) — (13)	1,311 (51.61)
(48) — (48)	1,139 (44.84)
(49) — (49)	1,139 (44.84)
(75) — (75)	895 (35.24)
(82) — (82)	862 (33.94)
(83) — (83)	840 (33.07)
(99) — (99)	1,060 (41.73)

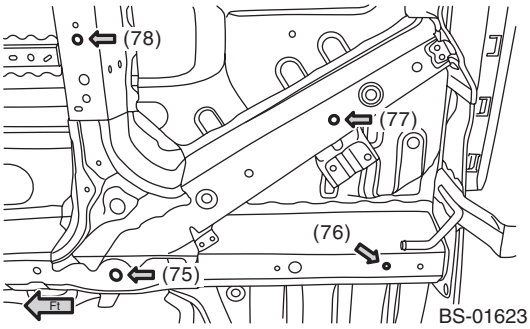
NOTE:
- All reference points are left-right symmetrical.
- Longitudinal dimensions are projected dimensions.
- Height dimensions are the vertical distances from the gauge point on the assumed horizontal line through the side sill flange joint (bending angle point).
- The left and right dimensions are the actual dimensions between reference points.



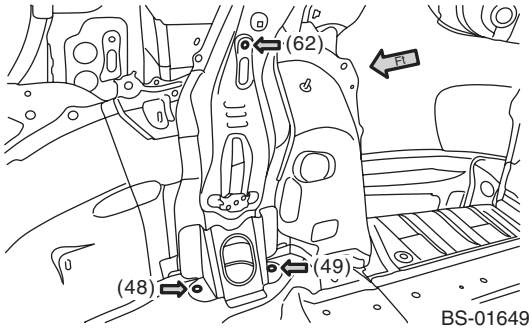
BS-01620



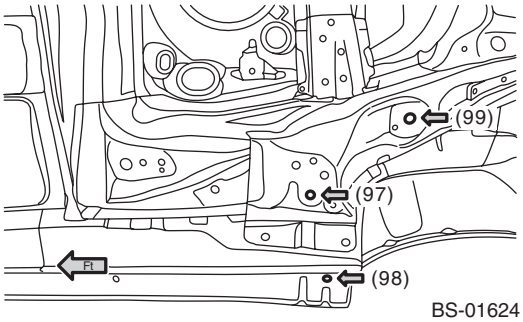
BS-01631



BS-01623



BS-01649

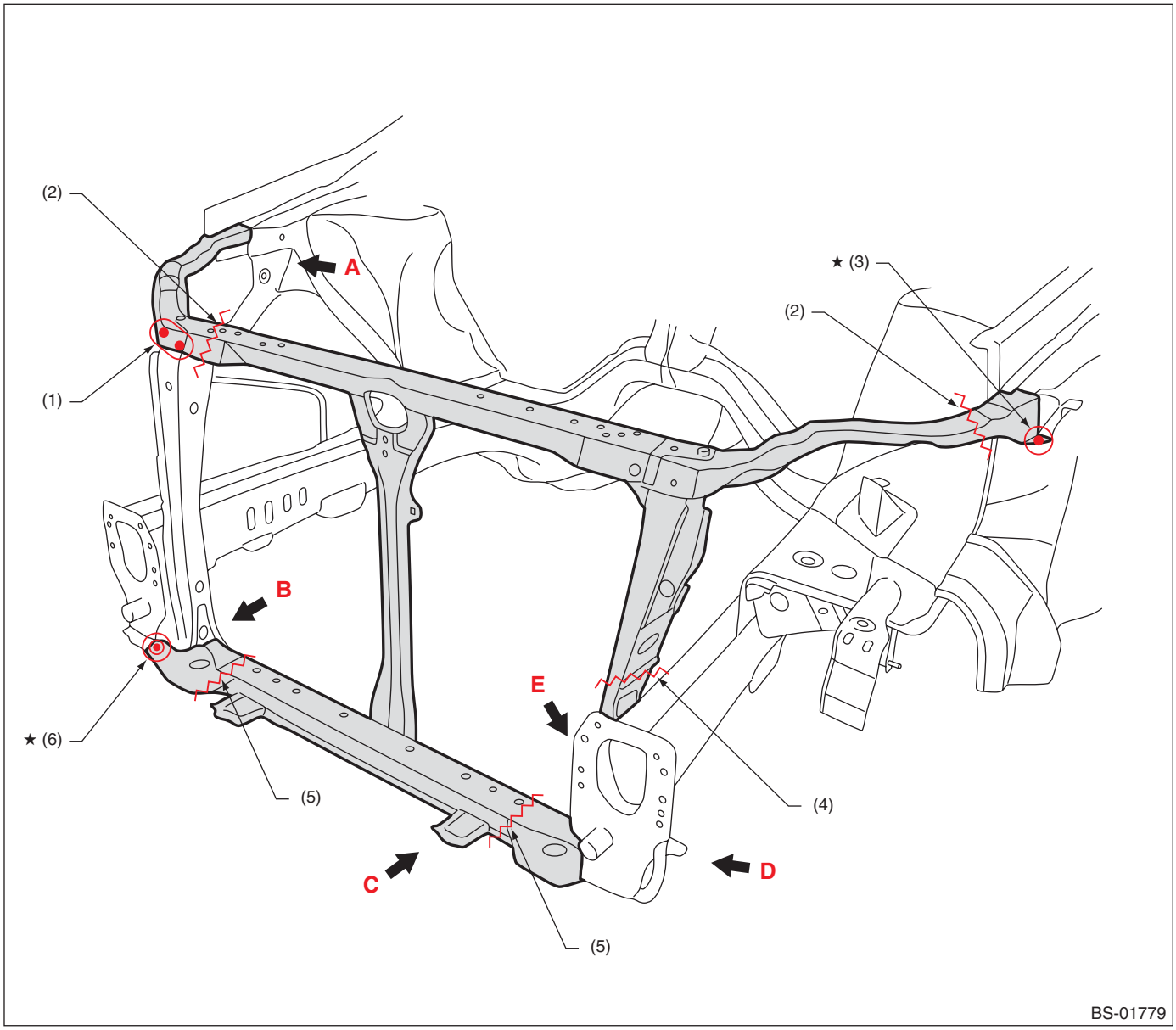


BS-01624

13.Radiator Panel (total replacement)

A: REMOVAL

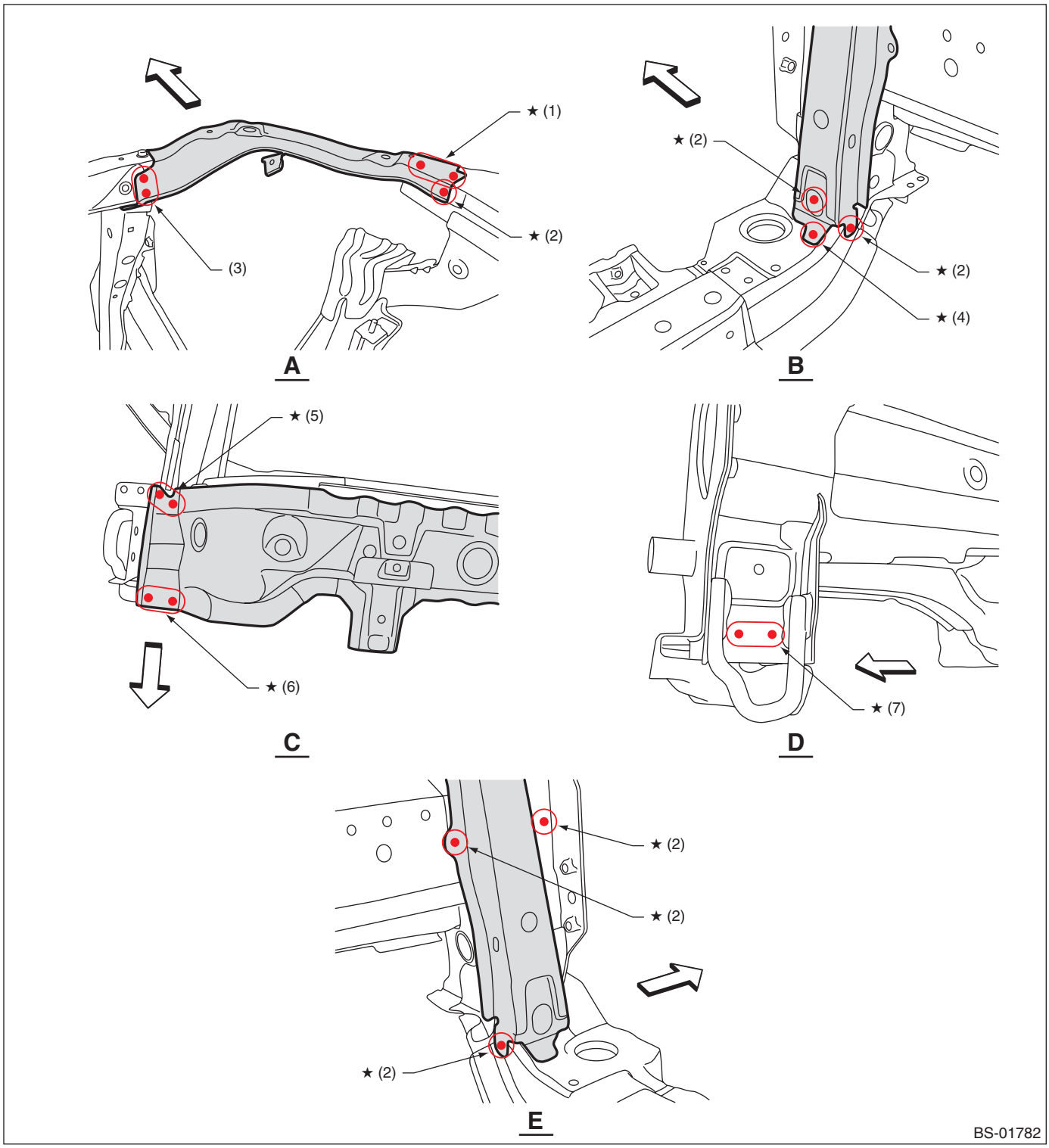
- **Overall view**



(1)	2 points (outside · 1)	(3)	1 point (top · 1)	(5)	Rough cutting (330 mm) to make removal easier
(2)	Rough cutting (80 mm) to make removal easier	(4)	Rough cutting (110 mm) to make removal easier	(6)	1 point (outside · 1)

For locations marked by H, the welding method, the number of welding points, and the rough cutting dimensions are the same on the left and the right.

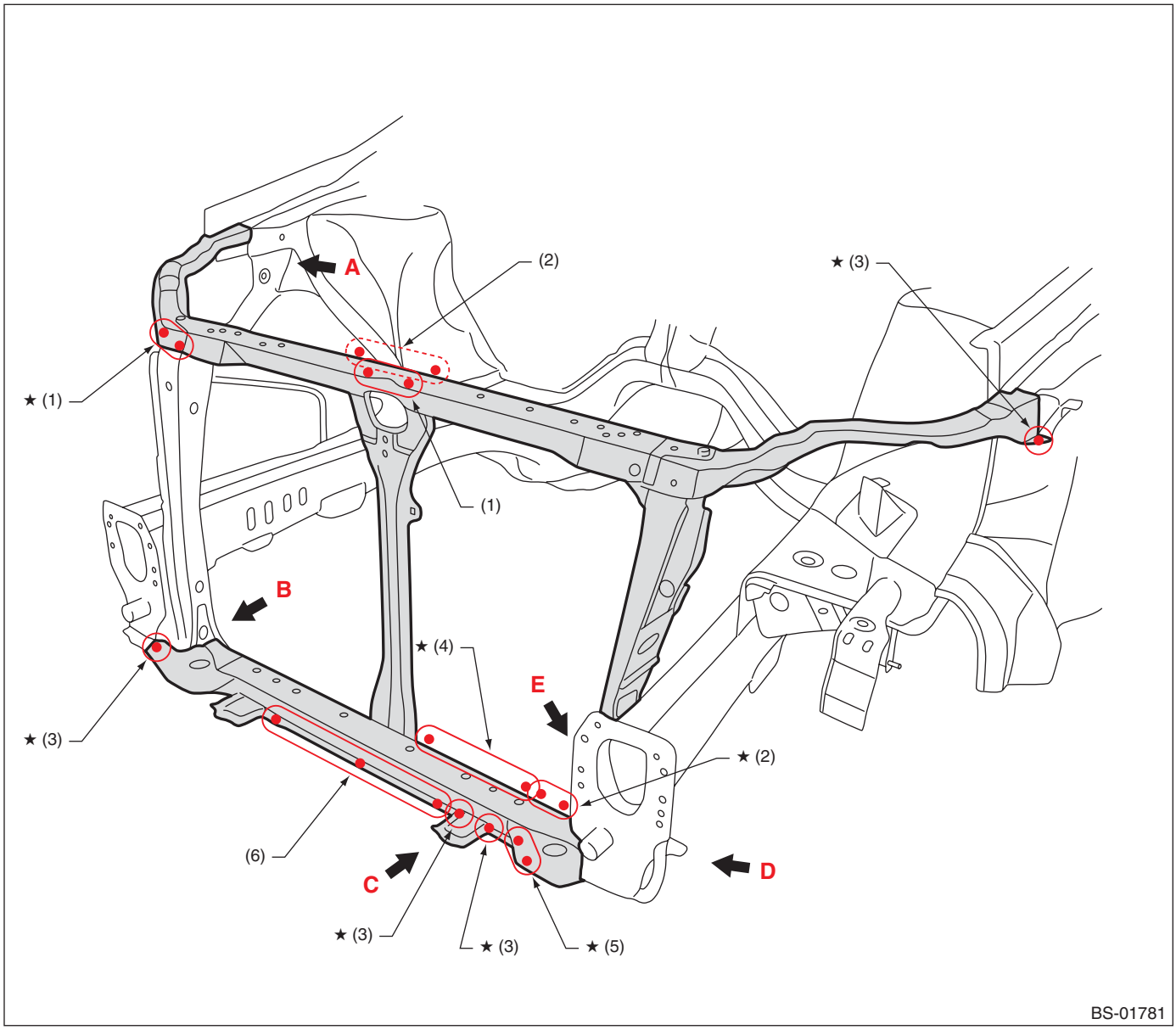
- **Views**



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

B: INSTALLATION

- **Overall view**

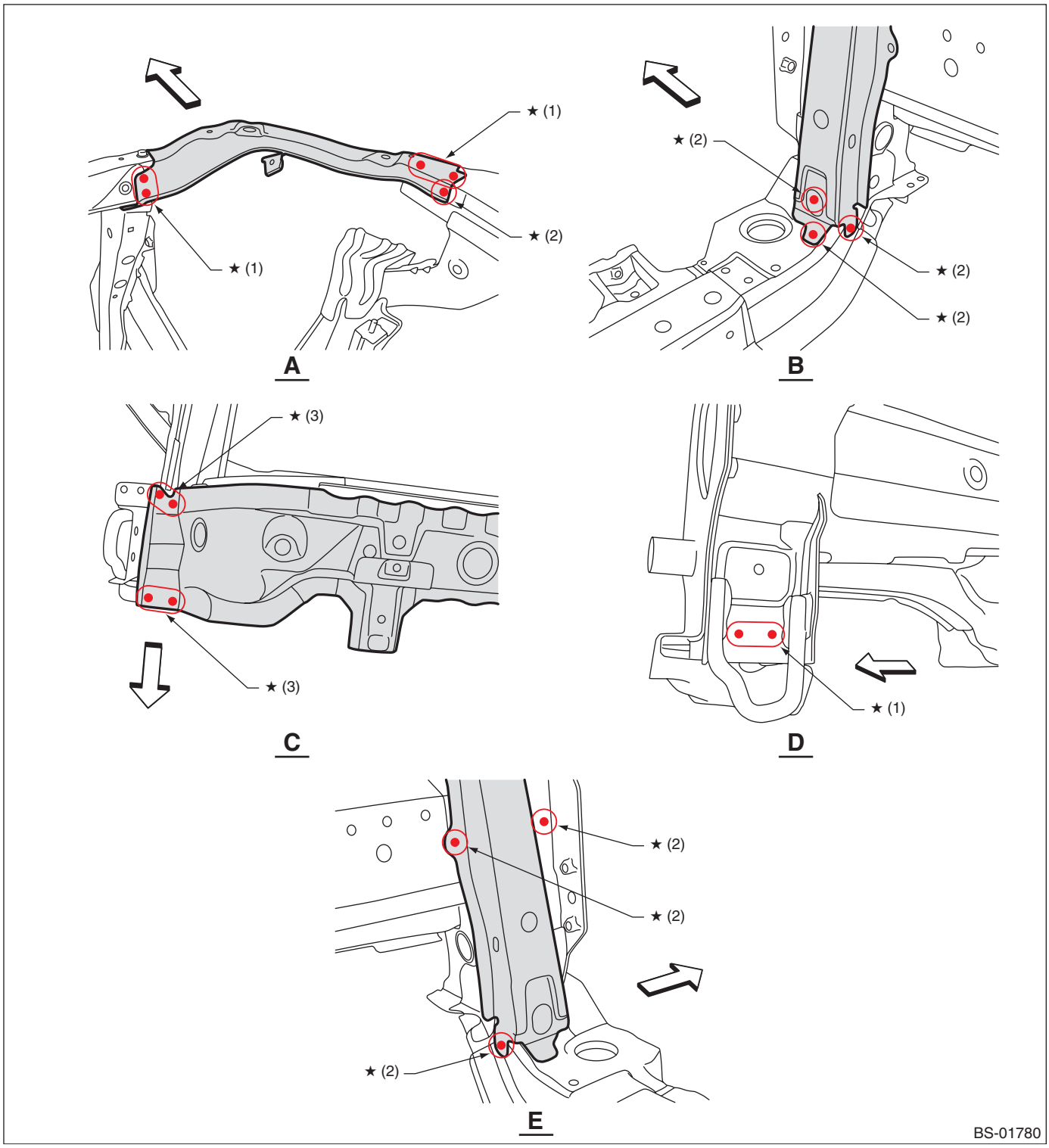


(1)	2 points	(3)	1 point	(5)	3 points
(2)	4 points	(4)	7 points	(6)	9 points

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

Radiator Panel (total replacement)

- **Views**



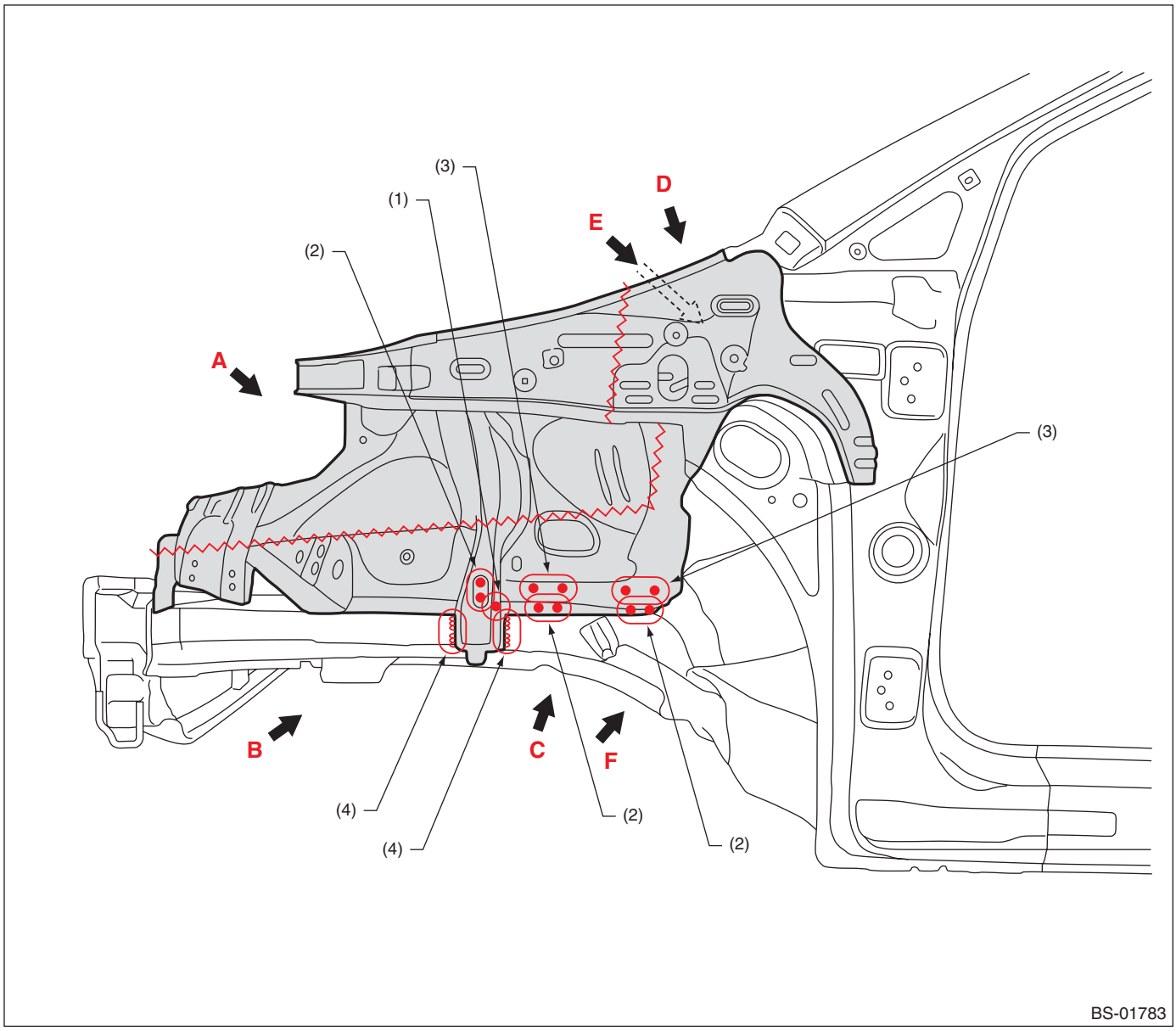
(1) 2 points (2) 1 point (3) 3 points

14.Front Wheel Apron (total replacement)

A: REMOVAL

1) Radiator panel removal condition

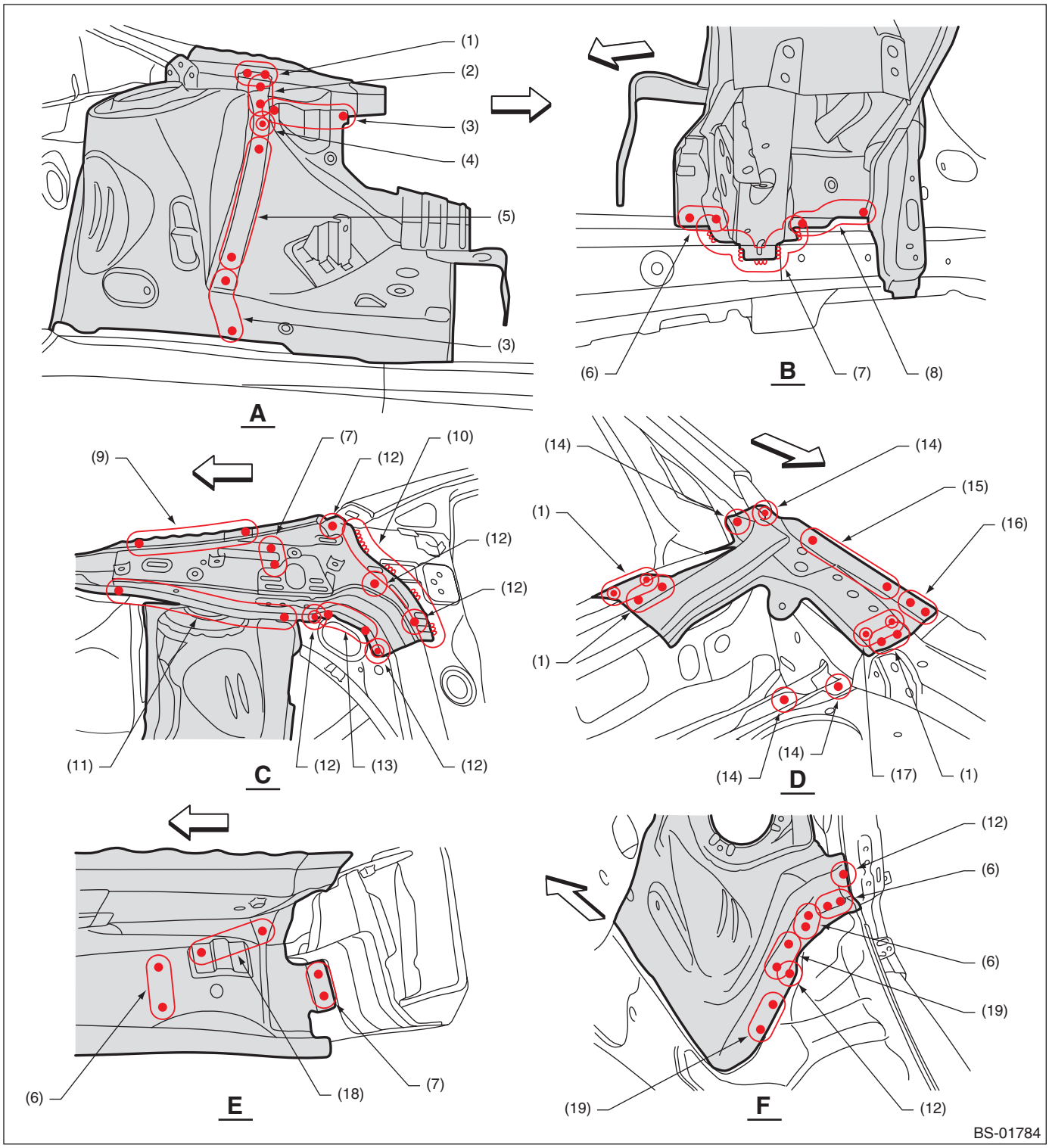
- **Overall view**



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

Front Wheel Apron (total replacement)

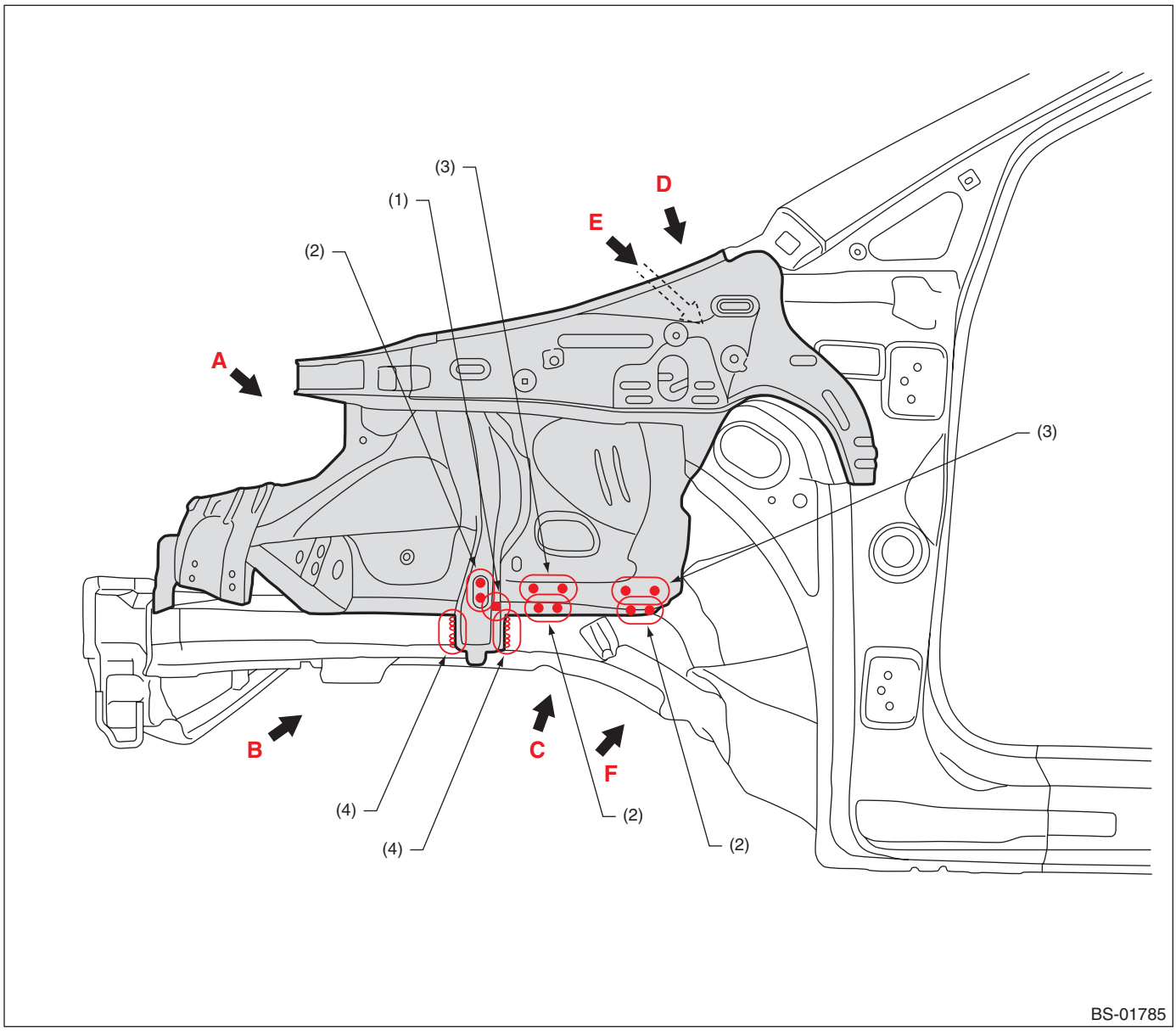
- **Views**



(1) 2 points (top · 1)
(2) 2 points (inside · 1)
(3) 5 points (inside · 1)
(4) 1 point (inside · 2)
(5) 7 points (inside · 1)
(6) 2 points (outside · 1)
(7) 5 points (outside · 1, belt sander)
(8) 5 points (outside · 1)
(9) 6 points (top · 1)
(10) 4 points (outside · 1, belt sander)
(11) 8 points (outside · 1)
(12) 1 point (outside · 1)
(13) 5 points (outside · 1)
(14) 1 point (top · 1)
(15) 4 points (top · 1)
(16) 2 points (top · 2)
(17) 2 points (top · 1)
(18) 3 points (outside · 1)
(19) 3 points (outside · 1)

B: INSTALLATION

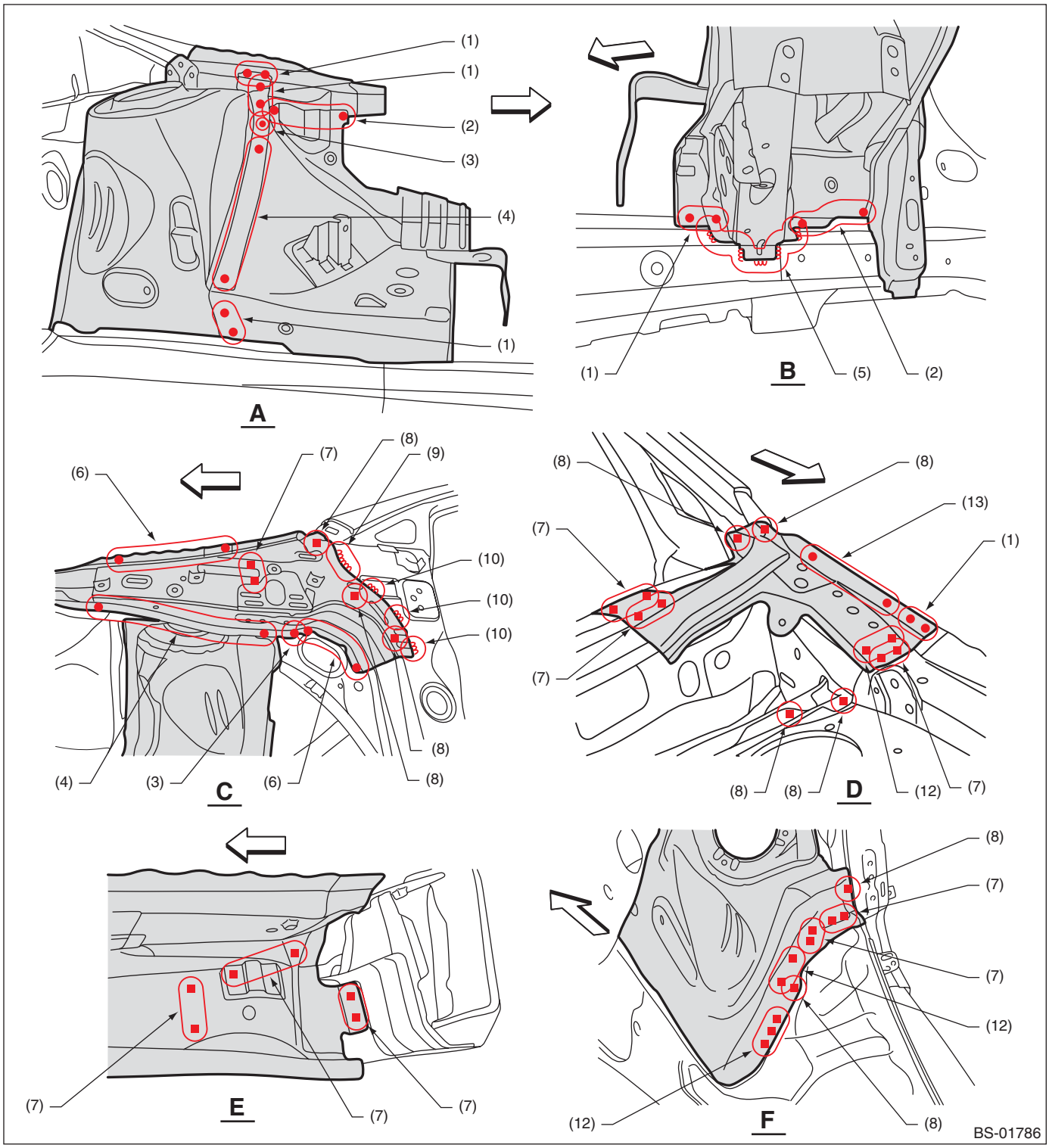
- **Overall view**



(1) 1 point (service)
(2) 2 points
(3) 4 points
(4) 2 points (20 mm × 2)

Front Wheel Apron (total replacement)

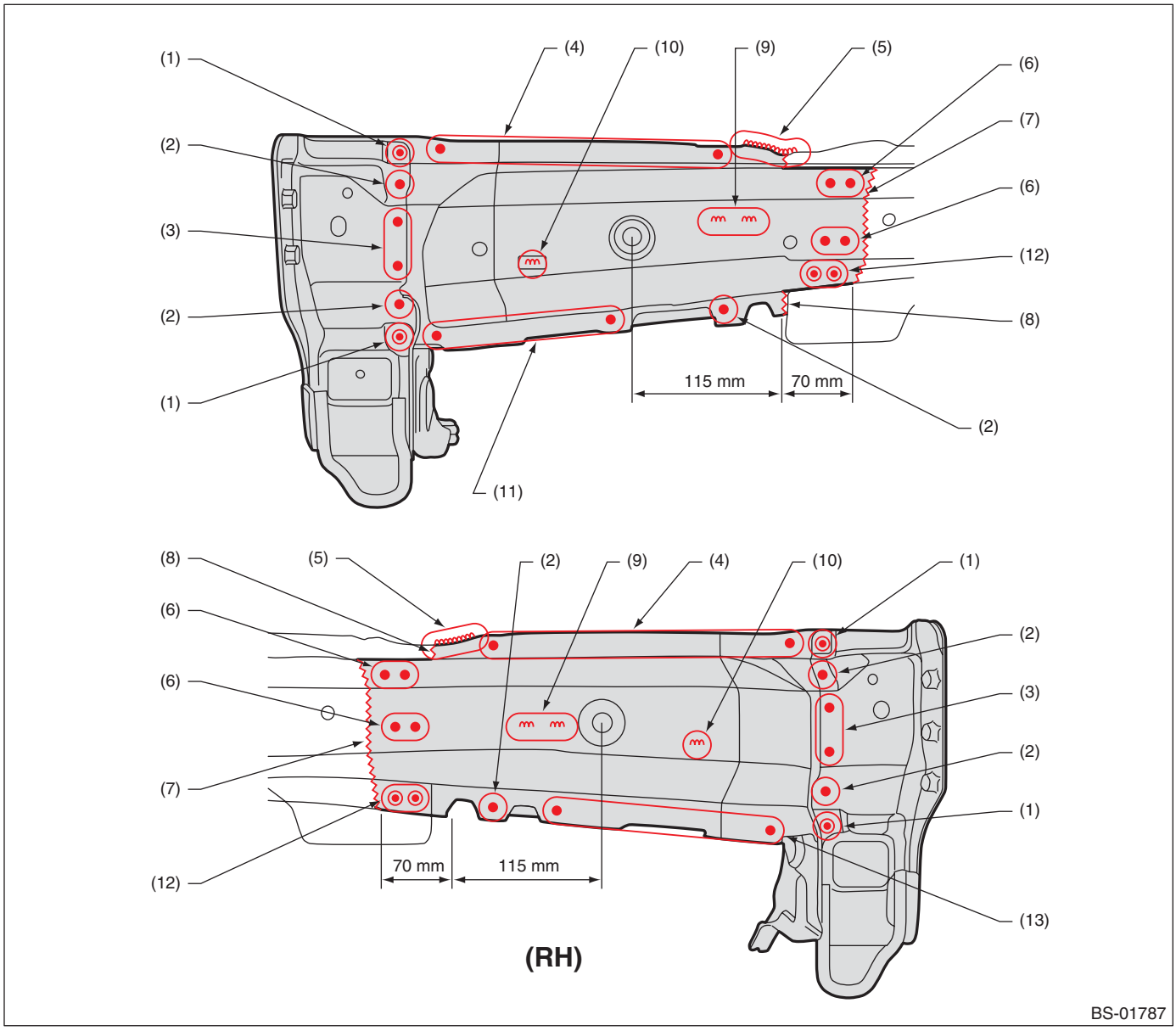
- **Views**



(1)	2 points	(6)	6 points	(11)	2 points (15 mm × 1)
(2)	5 points	(7)	2 points (service)	(12)	3 points (service)
(3)	1 point	(8)	1 point (service)	(13)	4 points
(4)	8 points	(9)	1 point (60 mm × 1)		
(5)	2 points (25 mm × 5)	(10)	1 point (20 mm × 1)		

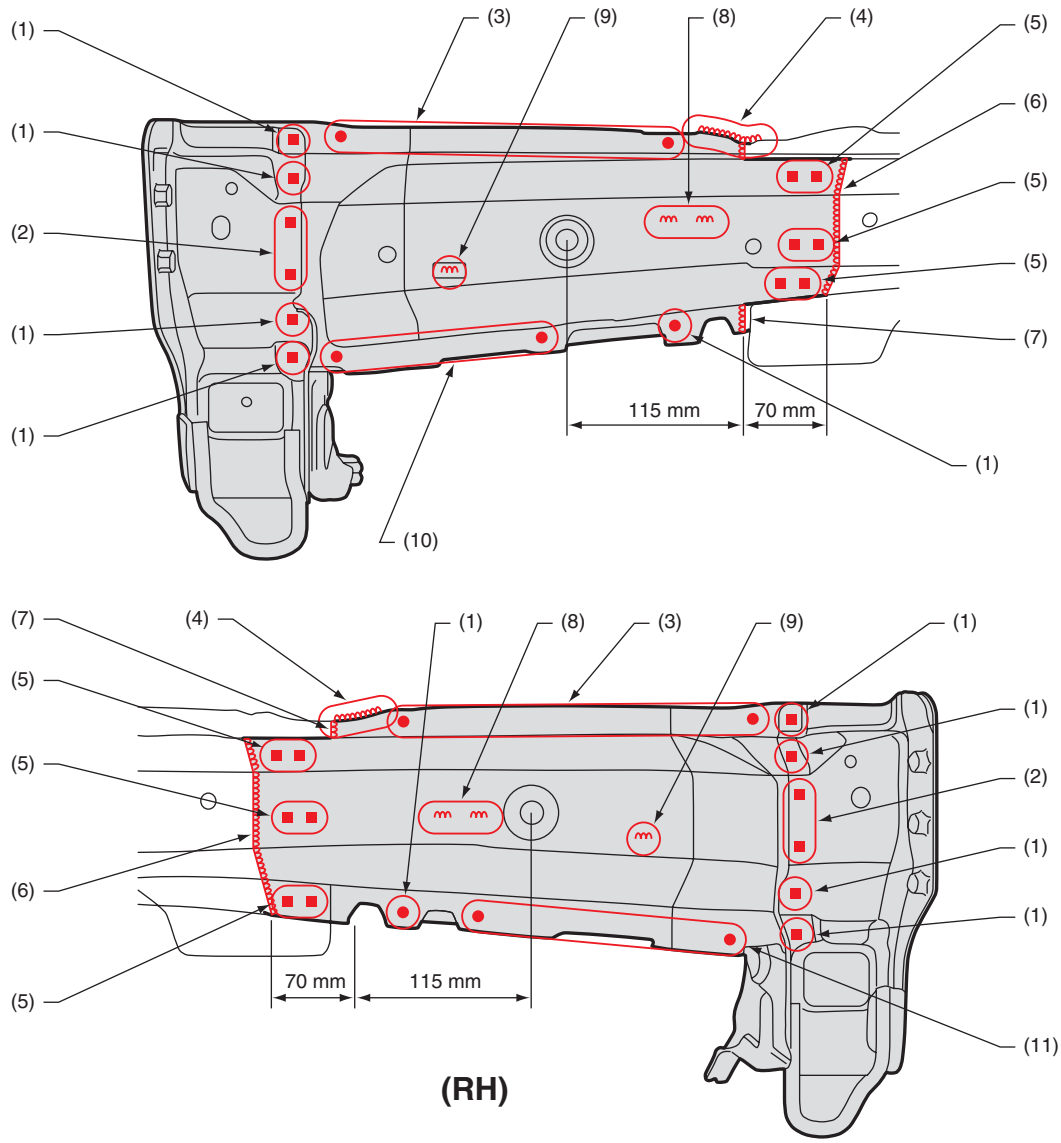
15.Front Closing Plate (partial replacement)

A: REMOVAL



(1) 1 point (outside · 2)
(2) 1 point (outside · 1)
(3) 3 points (outside · 1)
(4) 9 points (outside · 1)
(5) 1 point (inside · 1, belt sander)
(6) 2 points (outside · 1)
(7) Reinforcement cut position (100 mm) for butt welding
(8) Closing plate cut position (130 mm) for butt welding
(9) 2 points (outside · 1, belt sander)
(10) 1 point (outside · 1, belt sander)
(11) 6 points (outside · 1)
(12) 2 points (outside · 2)
(13) 8 points (outside · 1)

B: INSTALLATION



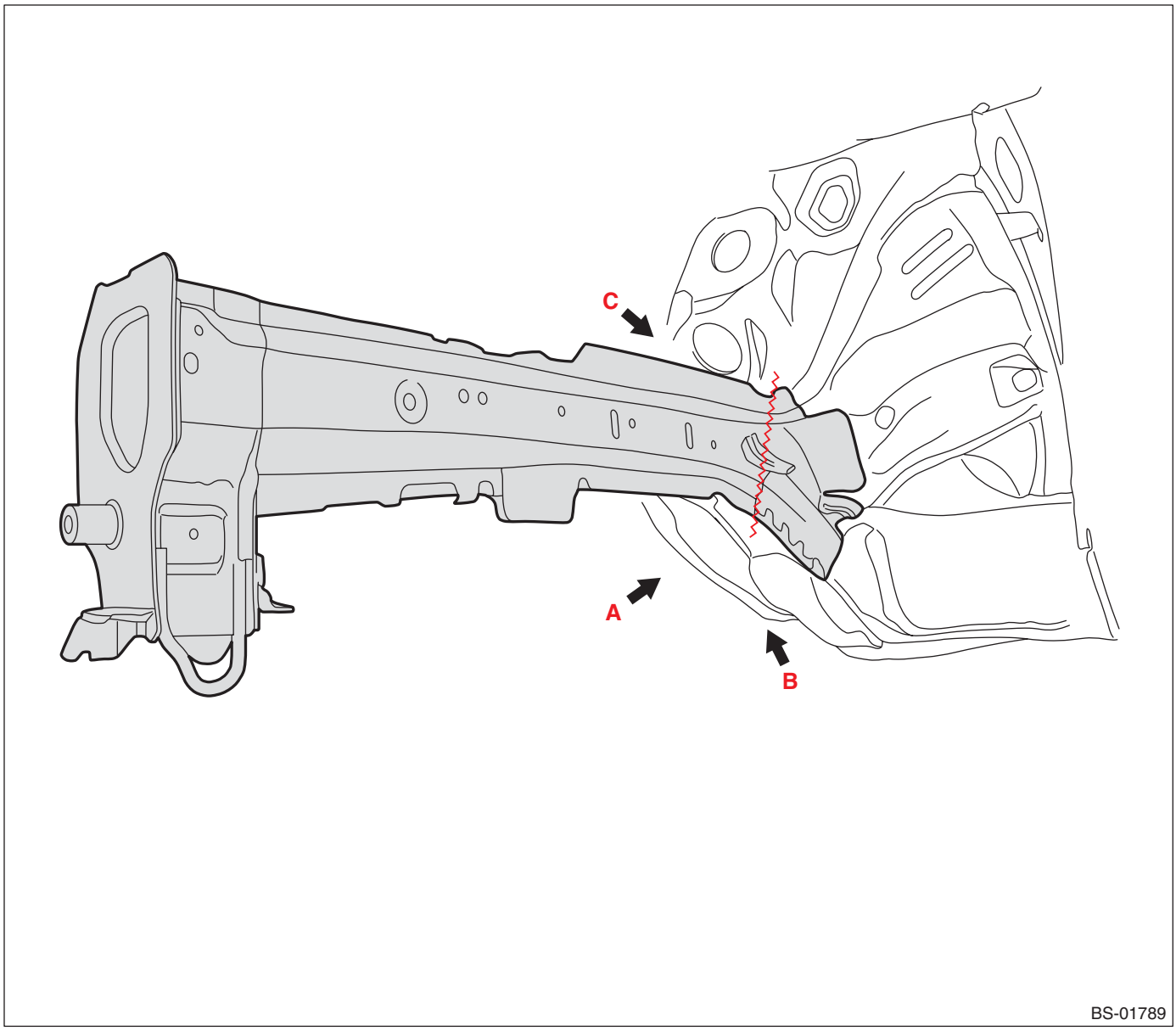
(1) 1 point
(2) 3 points
(3) 9 points
(4) 1 point (110 mm)
(5) 2 points (service)
(6) 1 point (100 mm)
(7) 1 point (130 mm)
(8) 2 points (15 mm × 2)
(9) 1 point (20 mm)
(10) 6 points
(11) 8 points

16.Frame Side Front (total replacement)

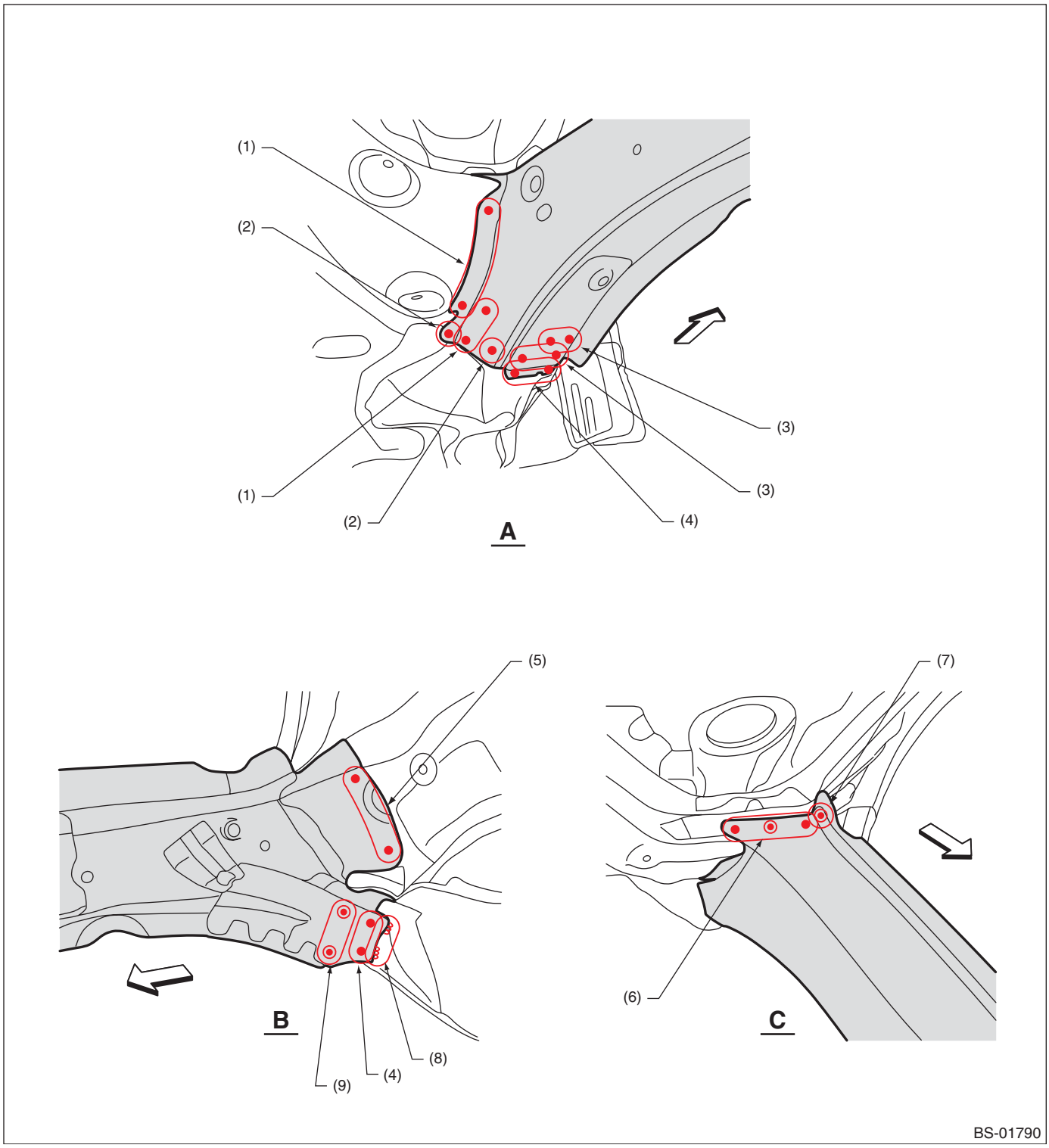
A: REMOVAL

1) Radiator panel and front wheel apron removal condition

- **Overall view**



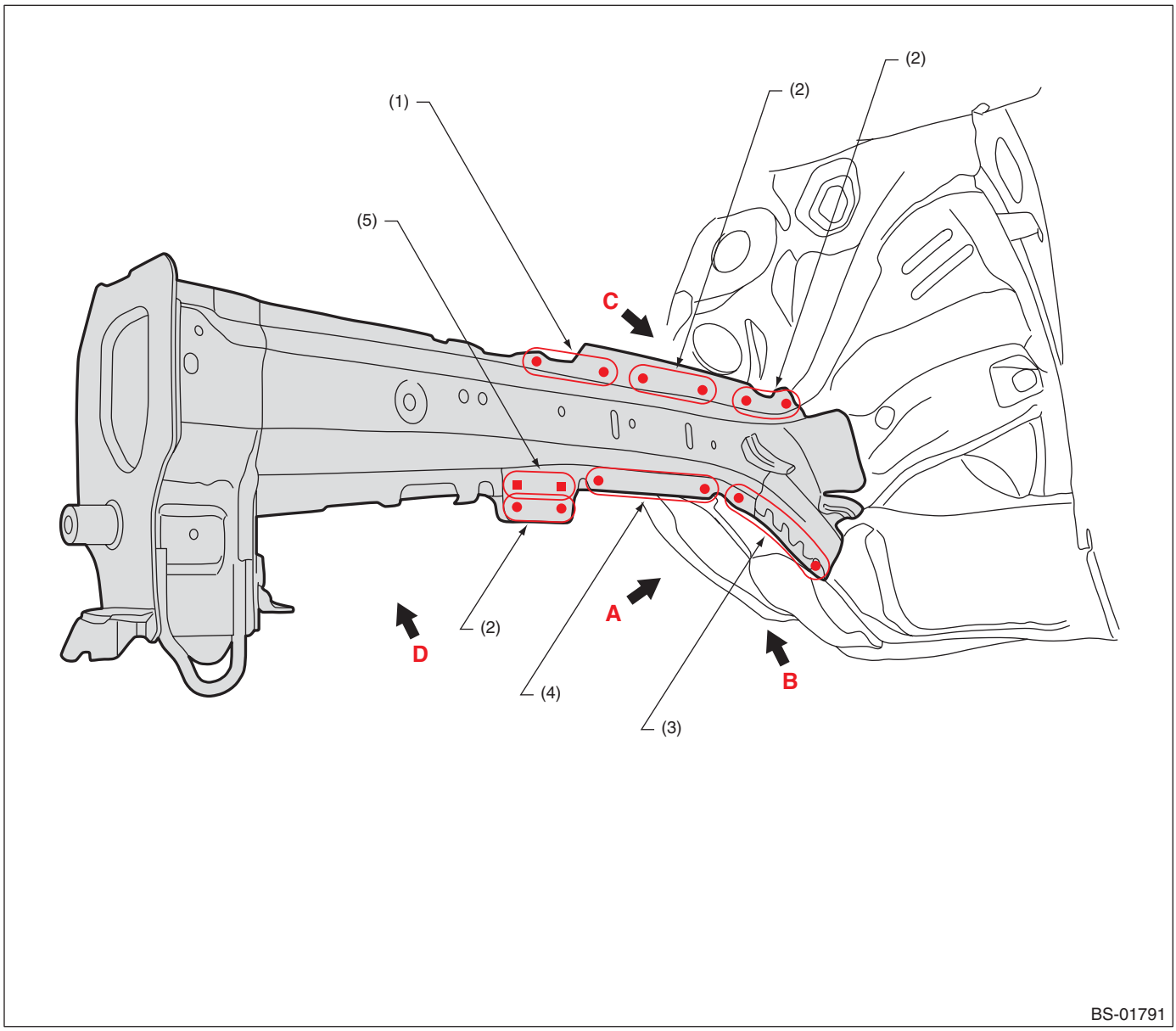
- **Views**



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

B: INSTALLATION

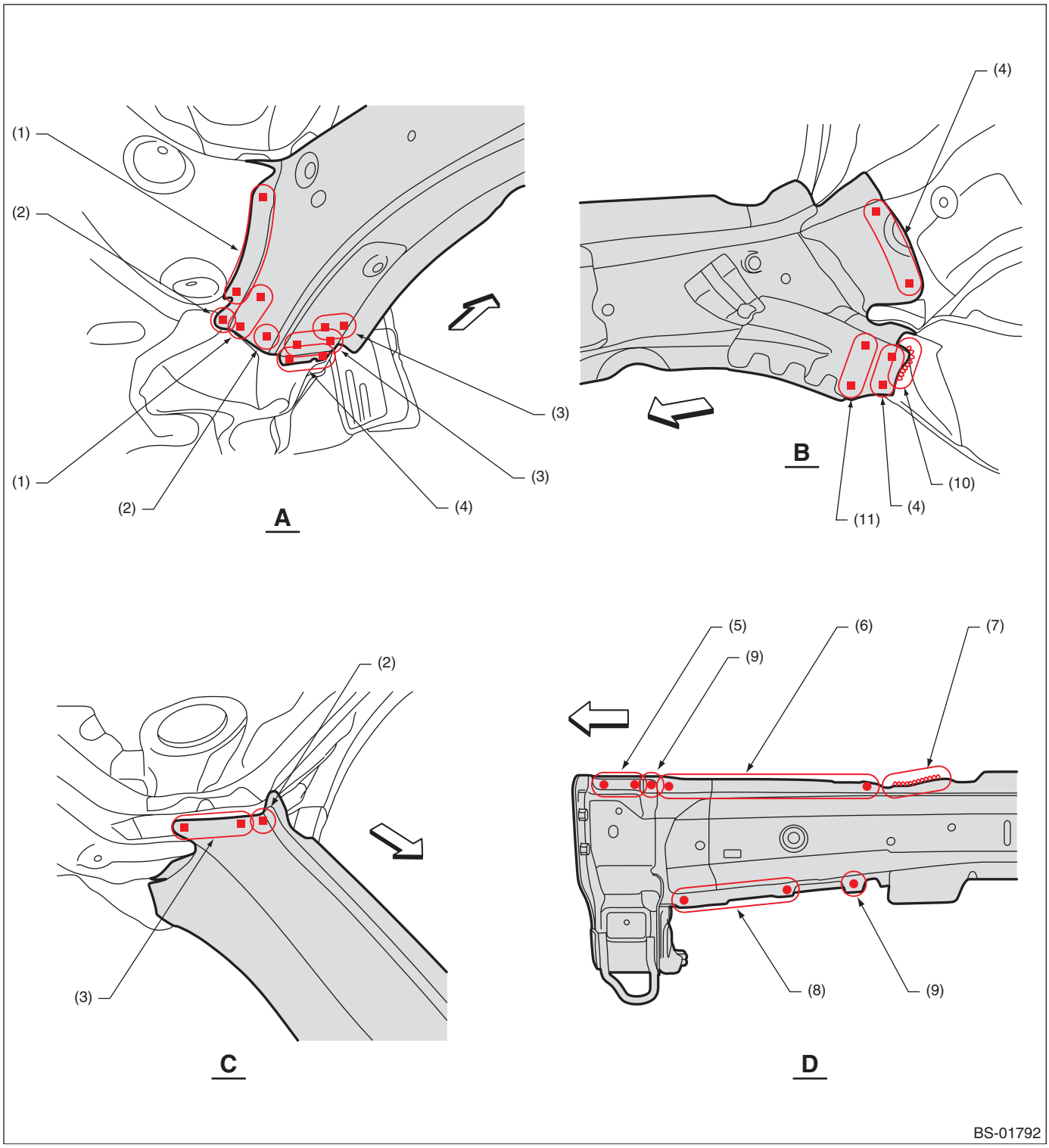
- **Overall view**



(1) 6 points
(2) 4 points
(3) 7 points
(4) 8 points
(5) 4 points (service)

Frame Side Front (total replacement)

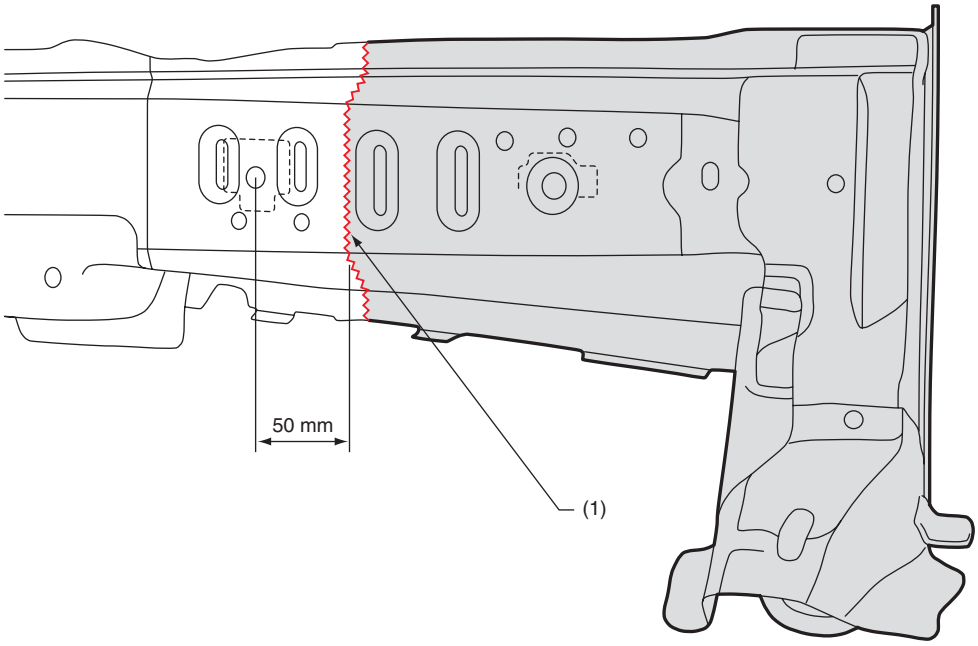
- **Views**



(1) 4 points (service)
(2) 1 point (service)
(3) 2 points (service)
(4) 3 points (service)
(5) 3 points
(6) Left side 7 points, Right side 9 points
(7) 1 point (100 mm × 1)
(8) Left side 6 points, Right side 8 points
(9) 1 point
(10) 1 point (70 mm × 1)
(11) 5 points (service)

17.Front Side Frame (partial replacement)

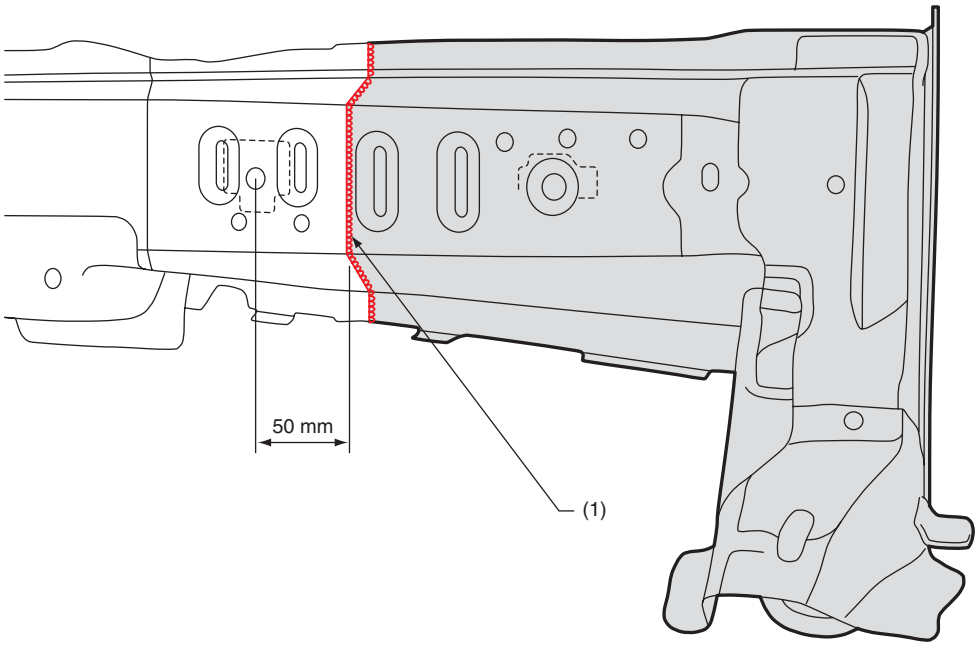
A: REMOVAL



BS-01793

(1) Cut position (220 mm), for butt welding

B: INSTALLATION



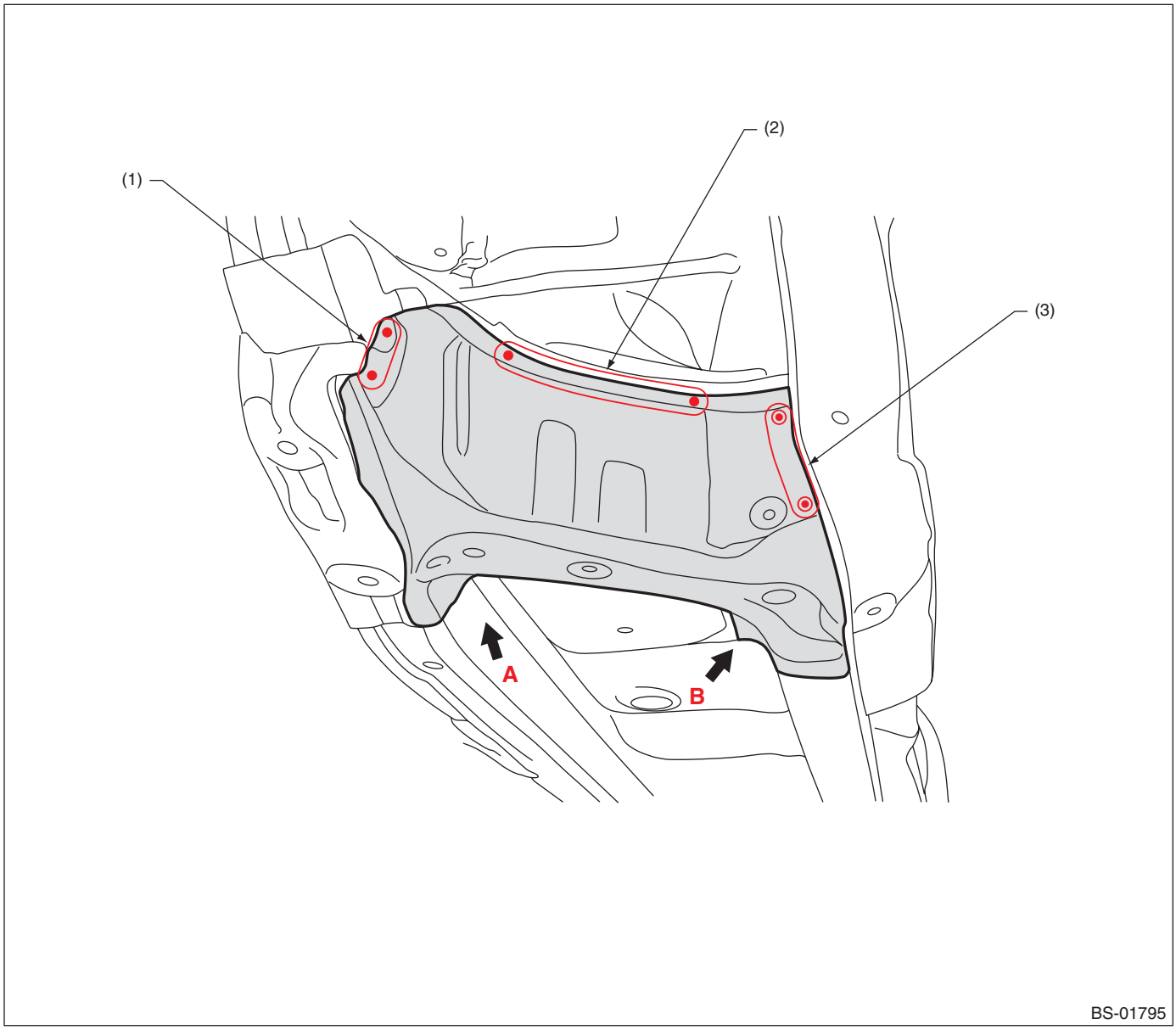
BS-01794

(1) 1 point (220 mm)

18.Reinforcement Toe Board (total replacement)

A: REMOVAL

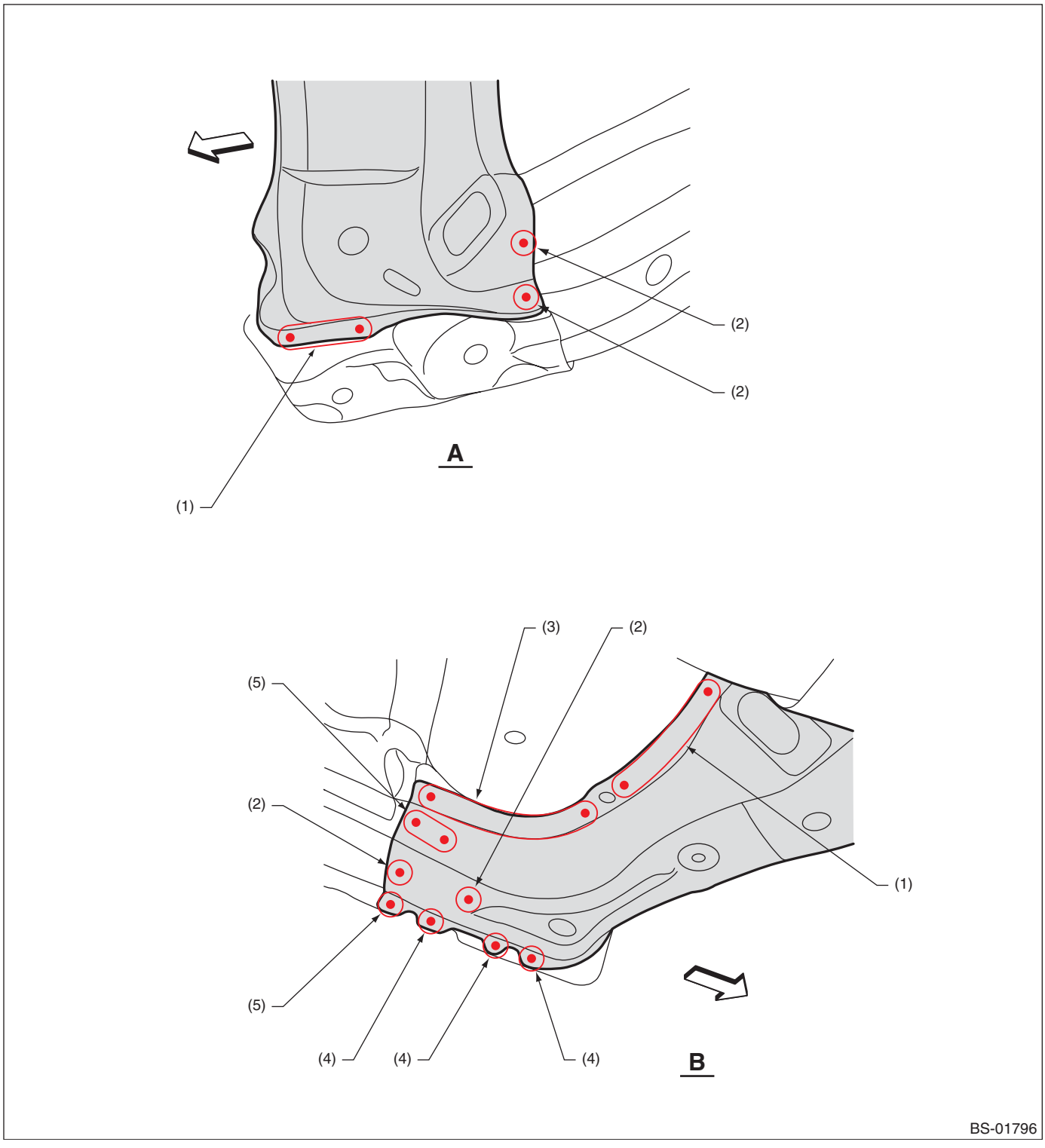
- **Overall view**



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

Reinforcement Toe Board (total replacement)

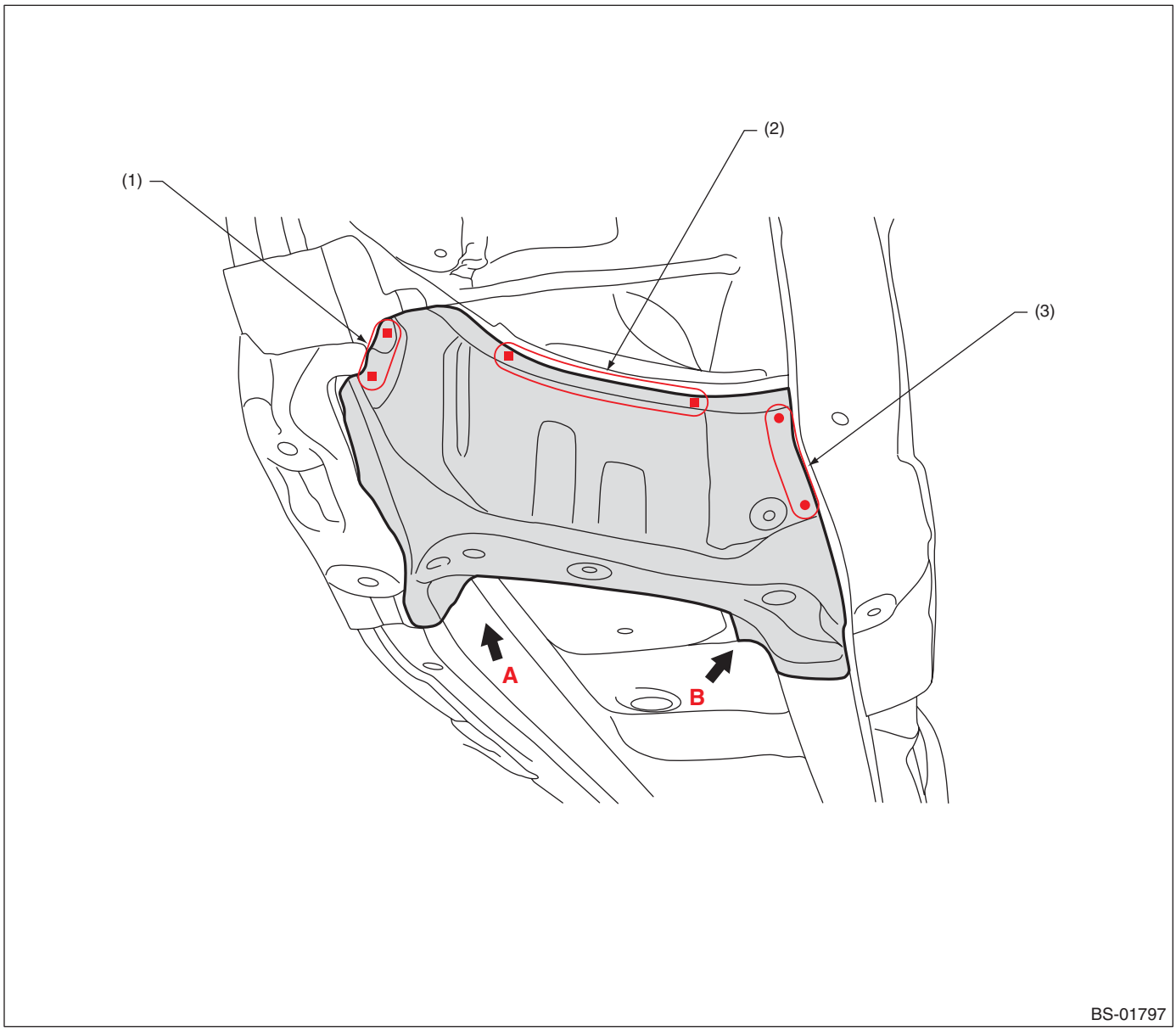
- **Views**



(1) 3 points (bottom · 1)
(2) 1 point (bottom · 1)
(3) 5 points (bottom · 1)
(4) 1 point (inside · 1)
(5) 2 points (inside · 1)

B: INSTALLATION

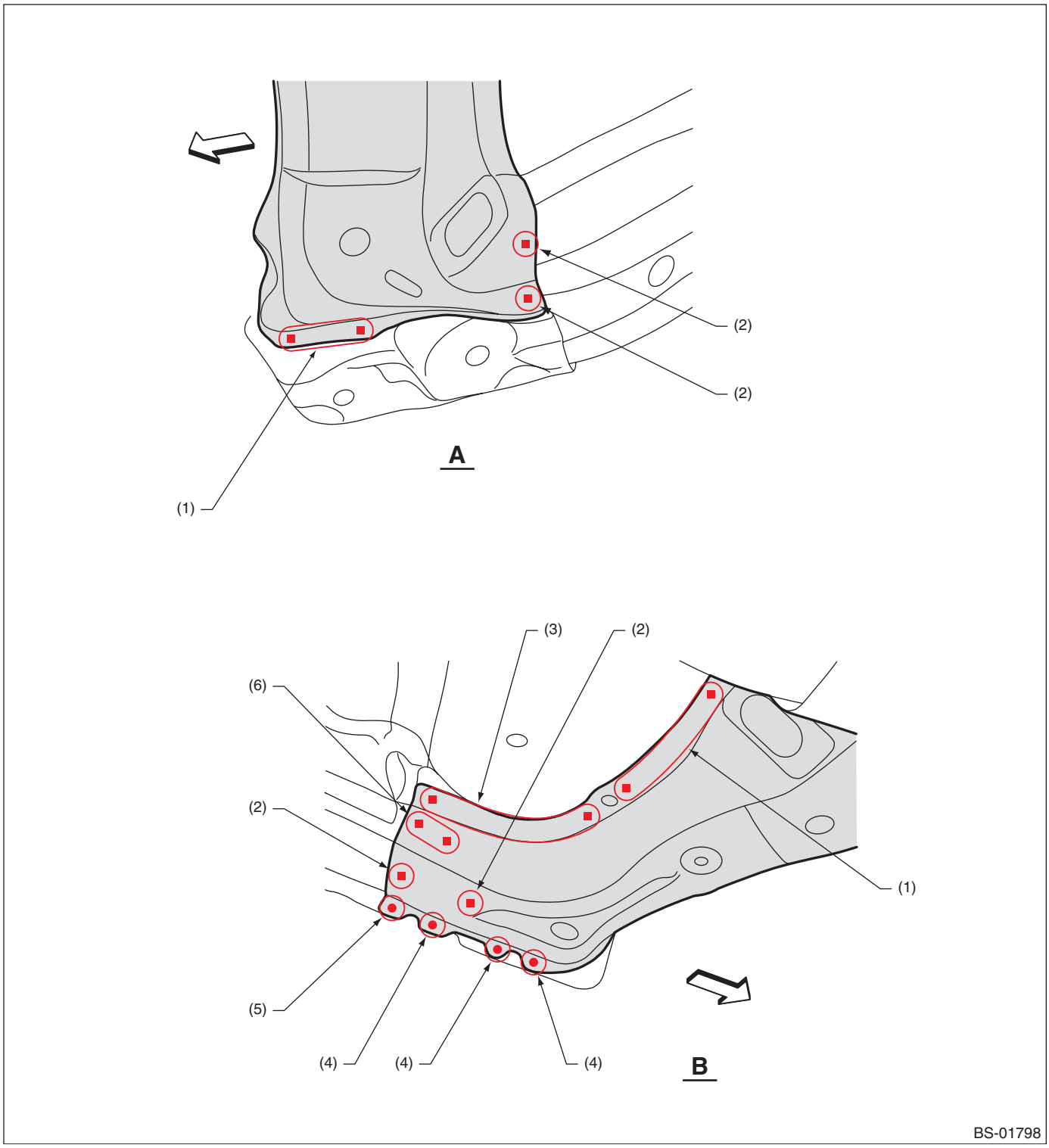
- **Overall view**



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

Reinforcement Toe Board (total replacement)

- **Views**



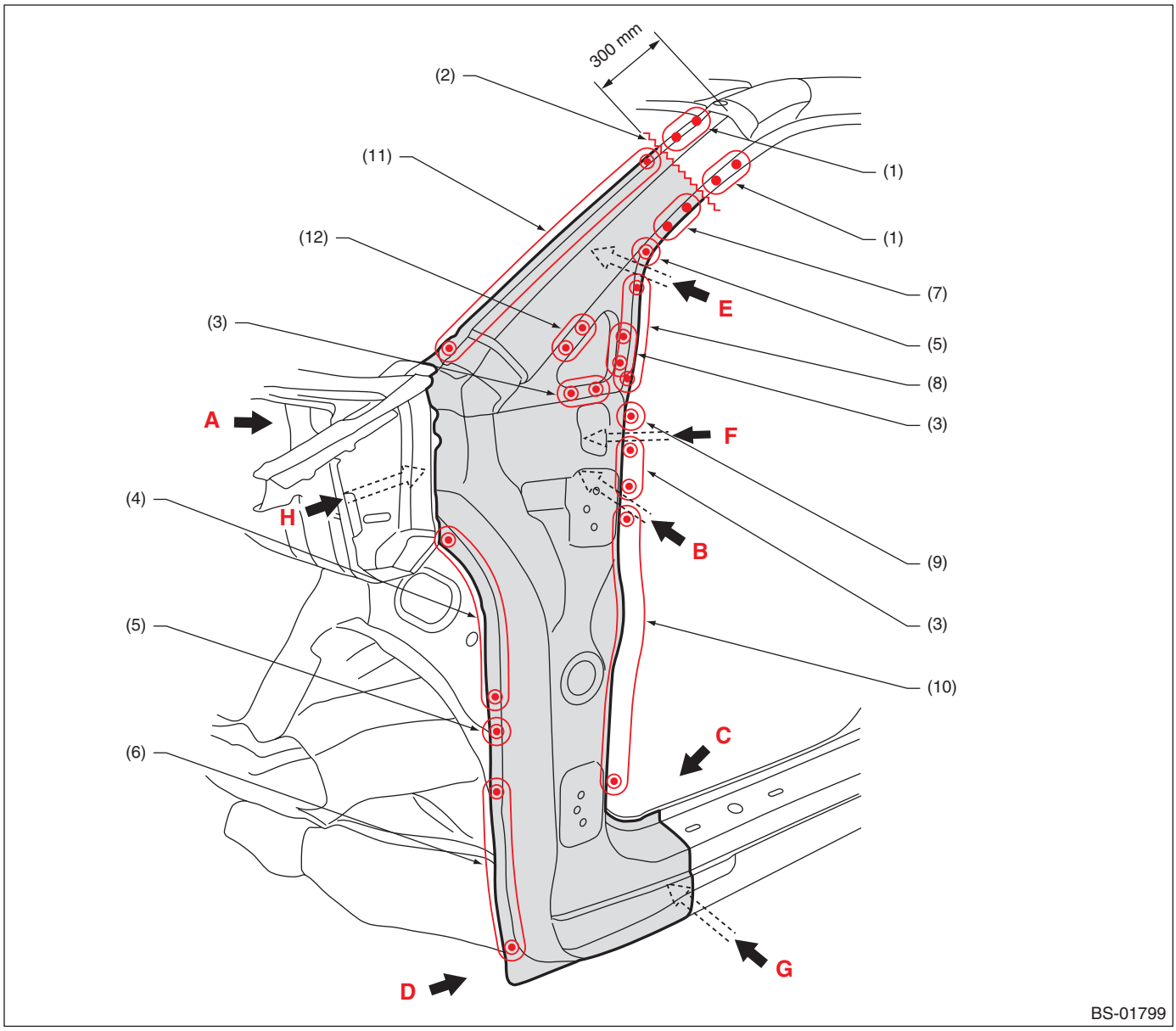
(1) 3 points (service)
(2) 1 point (service)
(3) 5 points (service)
(4) 1 point
(5) 2 points
(6) 2 points (service)

19.Front Pillar (partial replacement)

A: REMOVAL

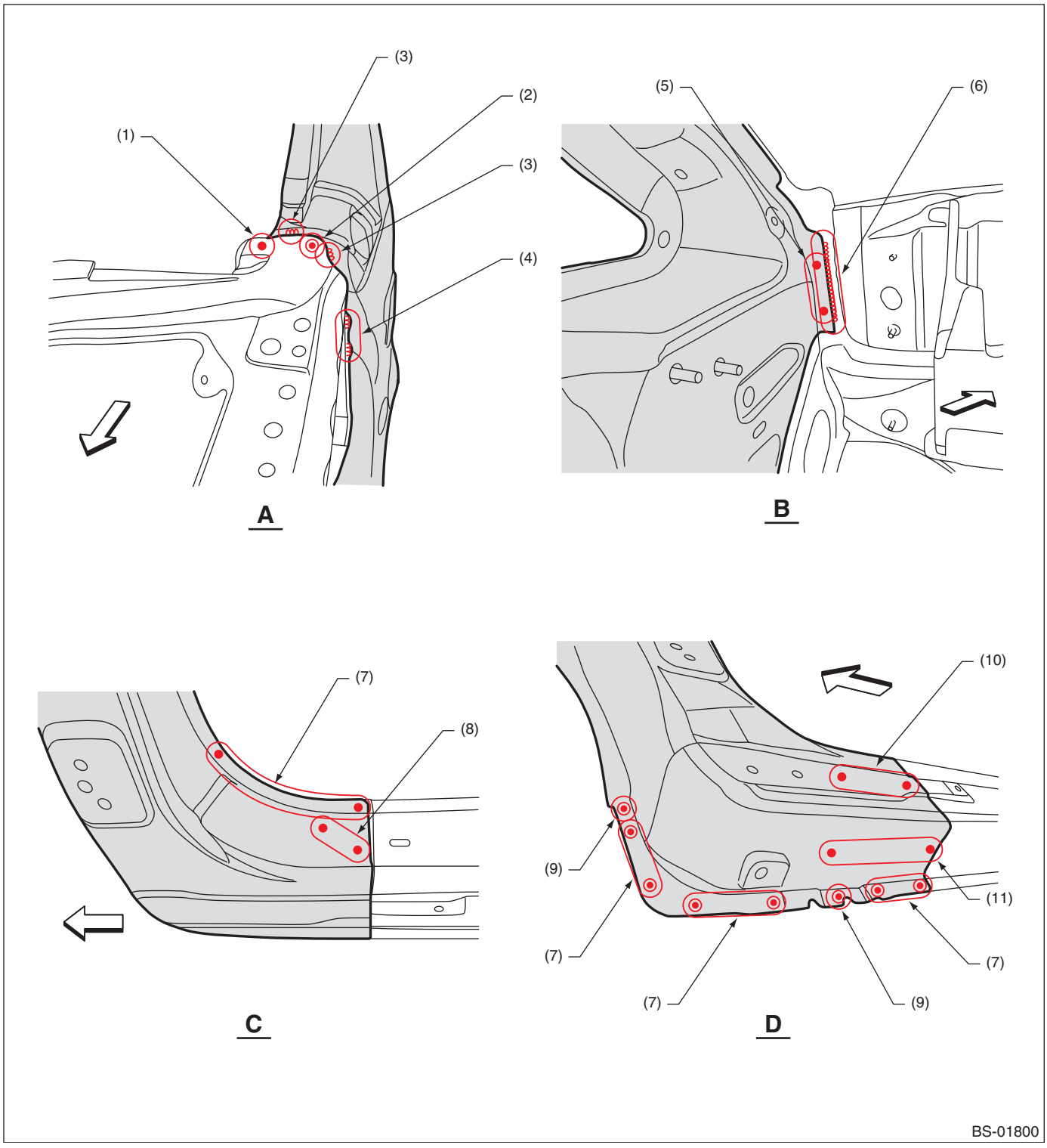
1) Frame side upper removal condition

- **Overall view**



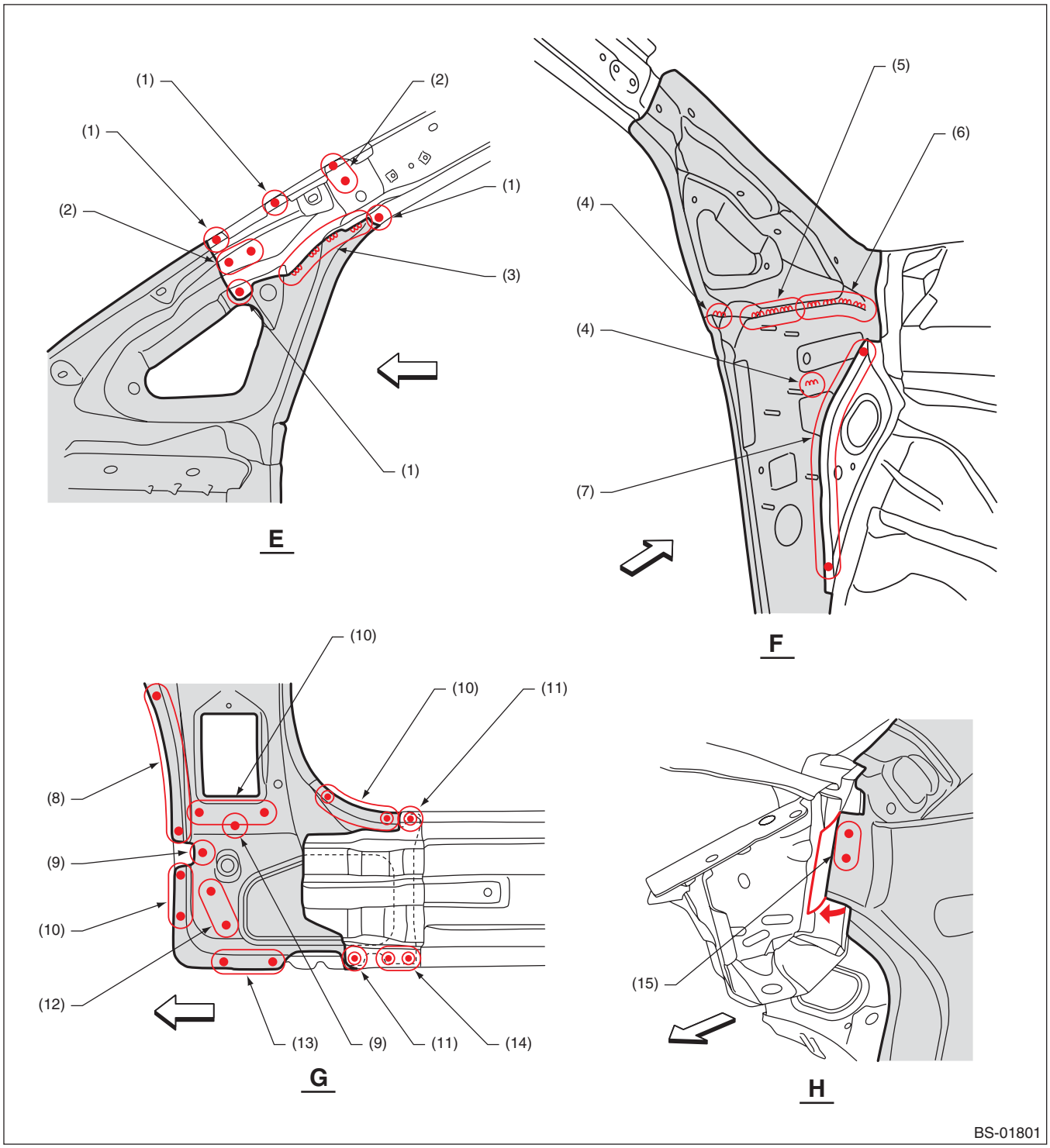
(1)	2 points (outside · 1)	(5)	1 point (outside · 1)	(9)	1 point (outside · 2)
(2)	Rough cutting (200 mm)	(6)	5 points (outside · 1)	(10)	14 points (outside · 2)
(3)	2 points (outside · 2)	(7)	3 points (outside · 1)	(11)	14 points (top · 2)
(4)	10 points (outside · 1)	(8)	8 points (outside · 2)	(12)	3 points (outside · 2)

- **Views 1**



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

- **Views 2**

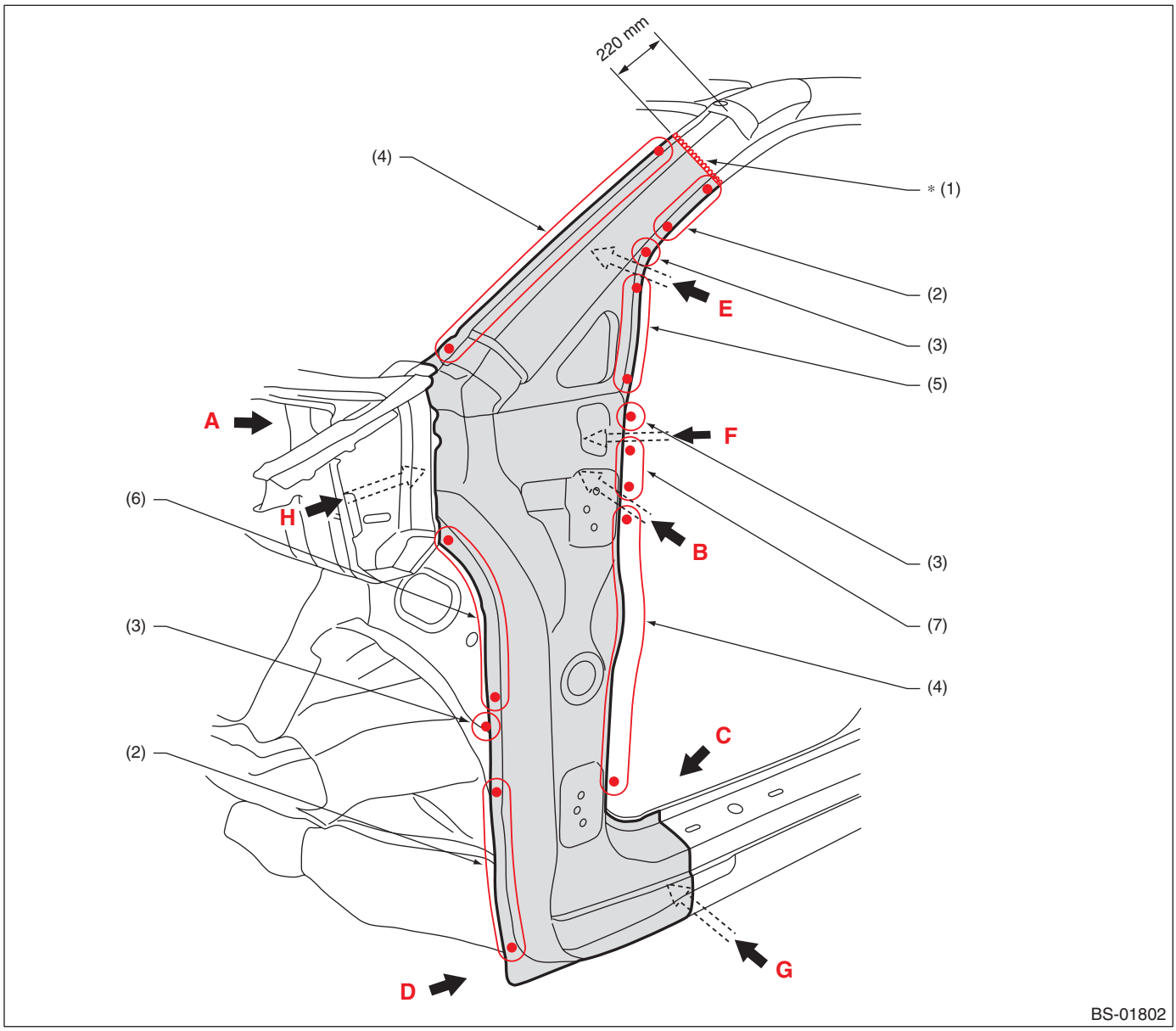


(1)	1 point (top · 1)	(6)	4 points (inside · 1, belt sander)	(11)	1 point (outside · 2)
(2)	2 points (top · 1)	(7)	13 points (inside · 1)	(12)	2 points (outside · 1)
(3)	4 points (top · 1, belt sander)	(8)	9 points (outside · 1)	(13)	4 points (outside · 1)
(4)	1 point (inside · 1, belt sander)	(9)	1 point (outside · 1)	(14)	2 points (outside · 2)
(5)	3 points (inside · 1, belt sander)	(10)	3 points (outside · 1)	(15)	2 points (outside · 1), hidden hit point

- View H: To facilitate removal, cut a part of the bulkhead and disconnect two of the hidden points.
- View G shows the front pillar removed condition.

B: INSTALLATION

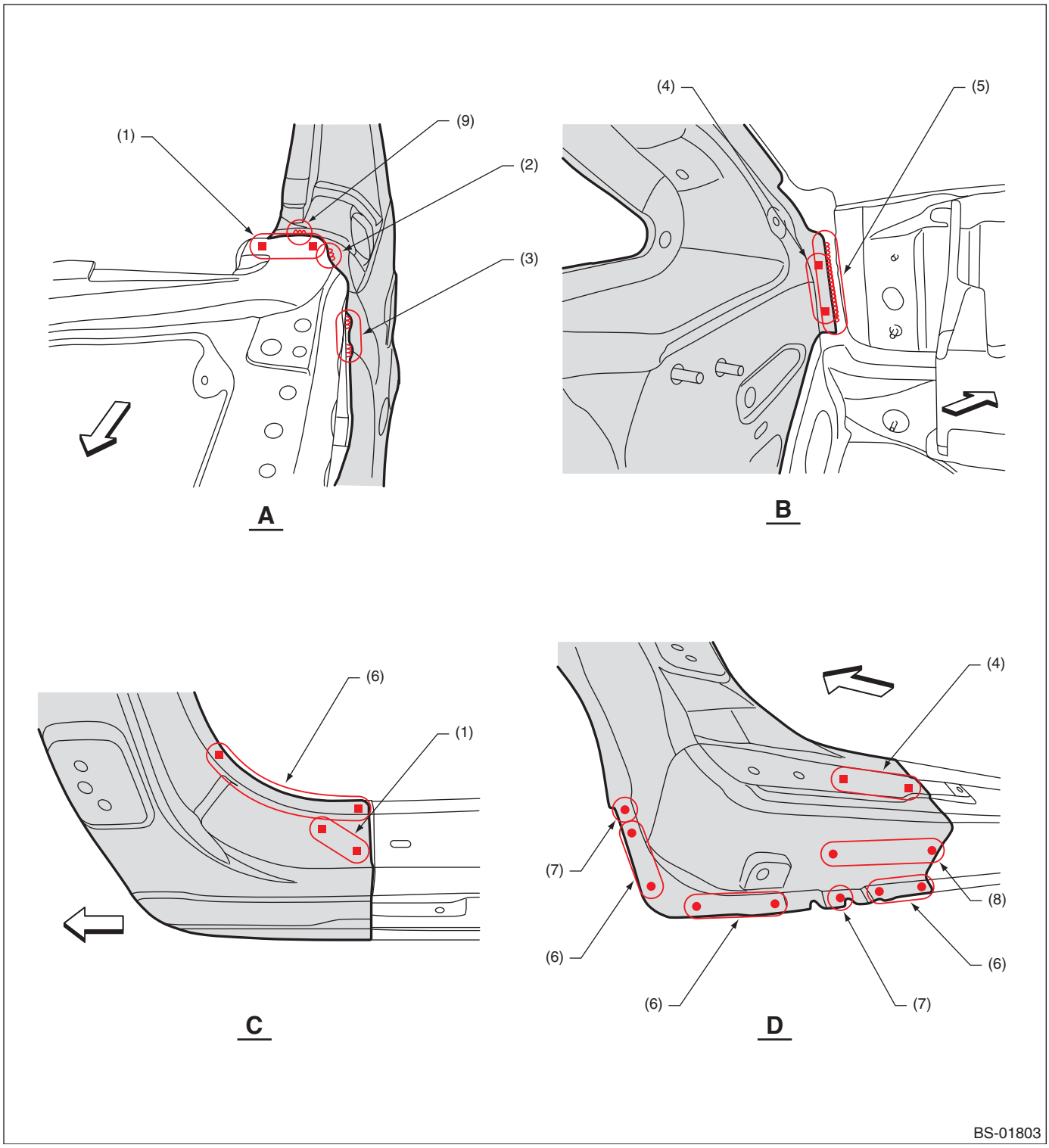
- **Overall view**



(1) 1 point (220 mm)
(2) 5 points
(3) 1 point
(4) 14 points
(5) 8 points
(6) 10 points
(7) 2 points

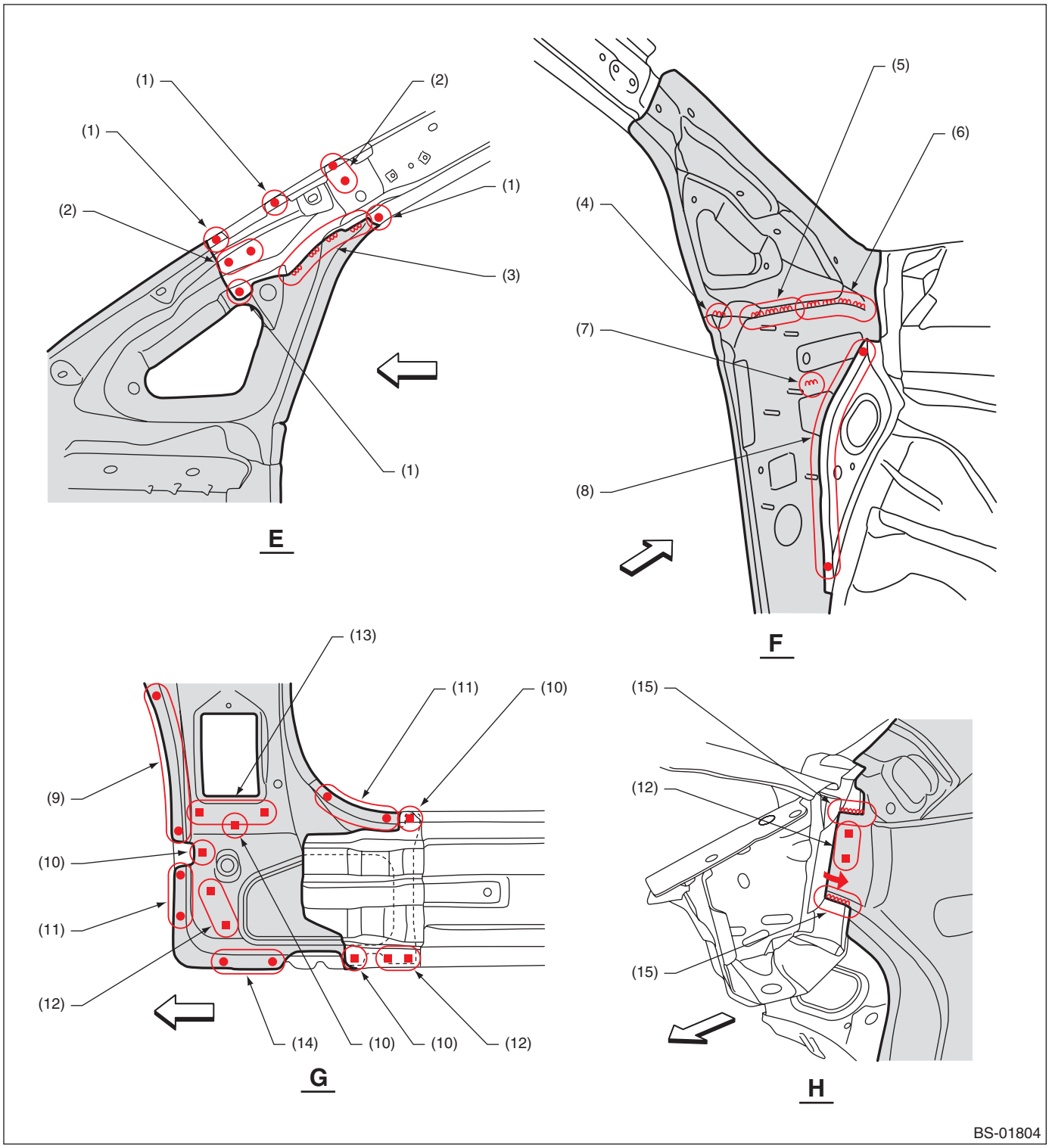
For continuous welds marked by *, apply anticorrosion wax thoroughly on the reverse side.

- **Views 1**



(1) 2 points (service)
(2) 1 point (20 mm)
(3) 2 points (15 mm × 2)
(4) 3 points (service)
(5) 1 point (130 mm)
(6) 4 points
(7) 1 point
(8) 4 points (service)
(9) 1 point (15 mm)

- **Views 2**



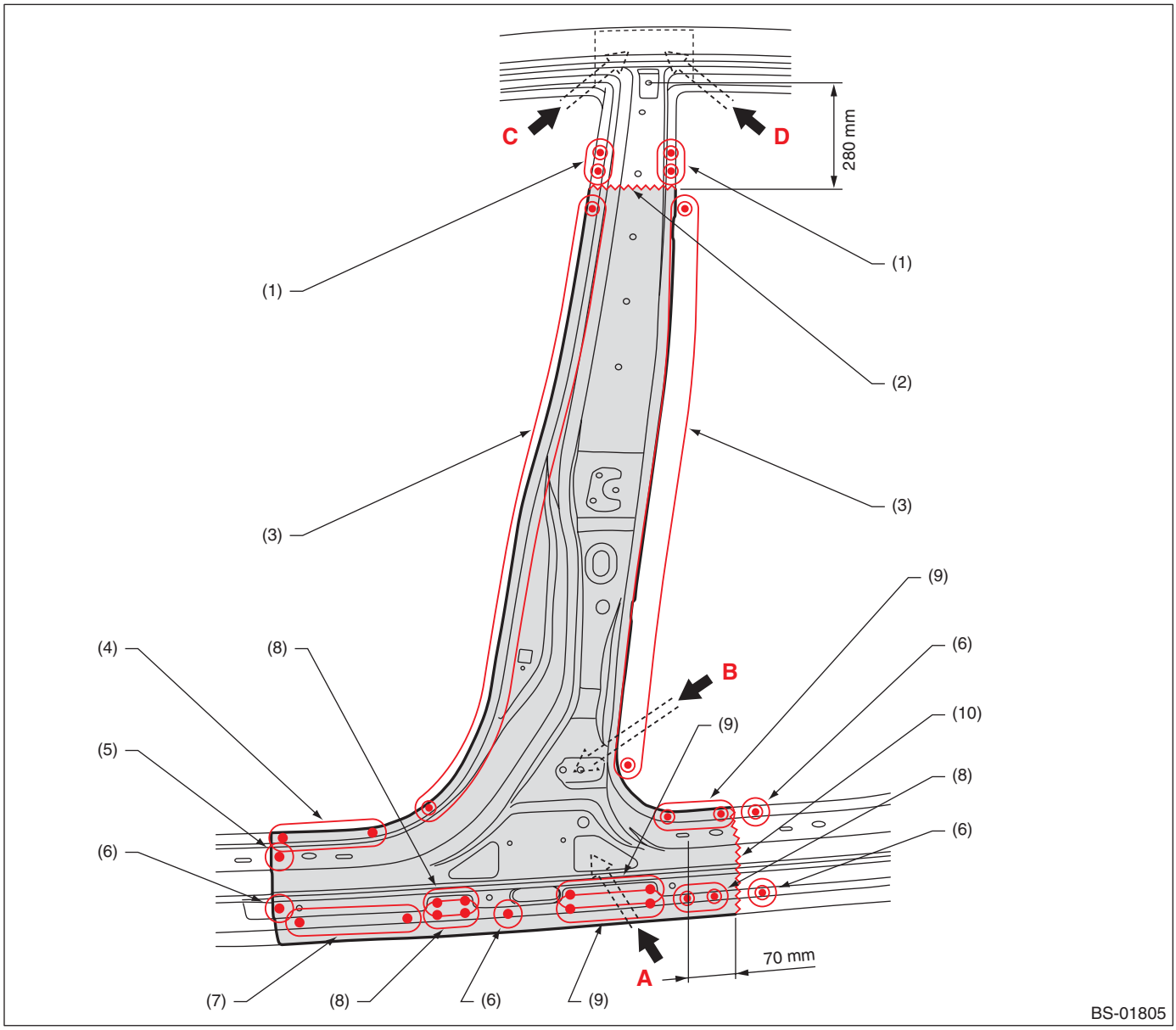
(1)	1 point	(6)	4 points (20 mm × 4)	(11)	3 points
(2)	2 points	(7)	1 point (30 mm)	(12)	2 points (service)
(3)	4 points (30 mm × 4)	(8)	13 points	(13)	3 points (service)
(4)	1 point (15 mm)	(9)	9 points	(14)	4 points
(5)	3 points (20 mm × 3)	(10)	1 point (service)	(15)	1 point (50 mm)

- View H: After front pillar welding, perform butt welding for the cut part of the raised bulkhead.

20.Center Pillar (partial replacement)

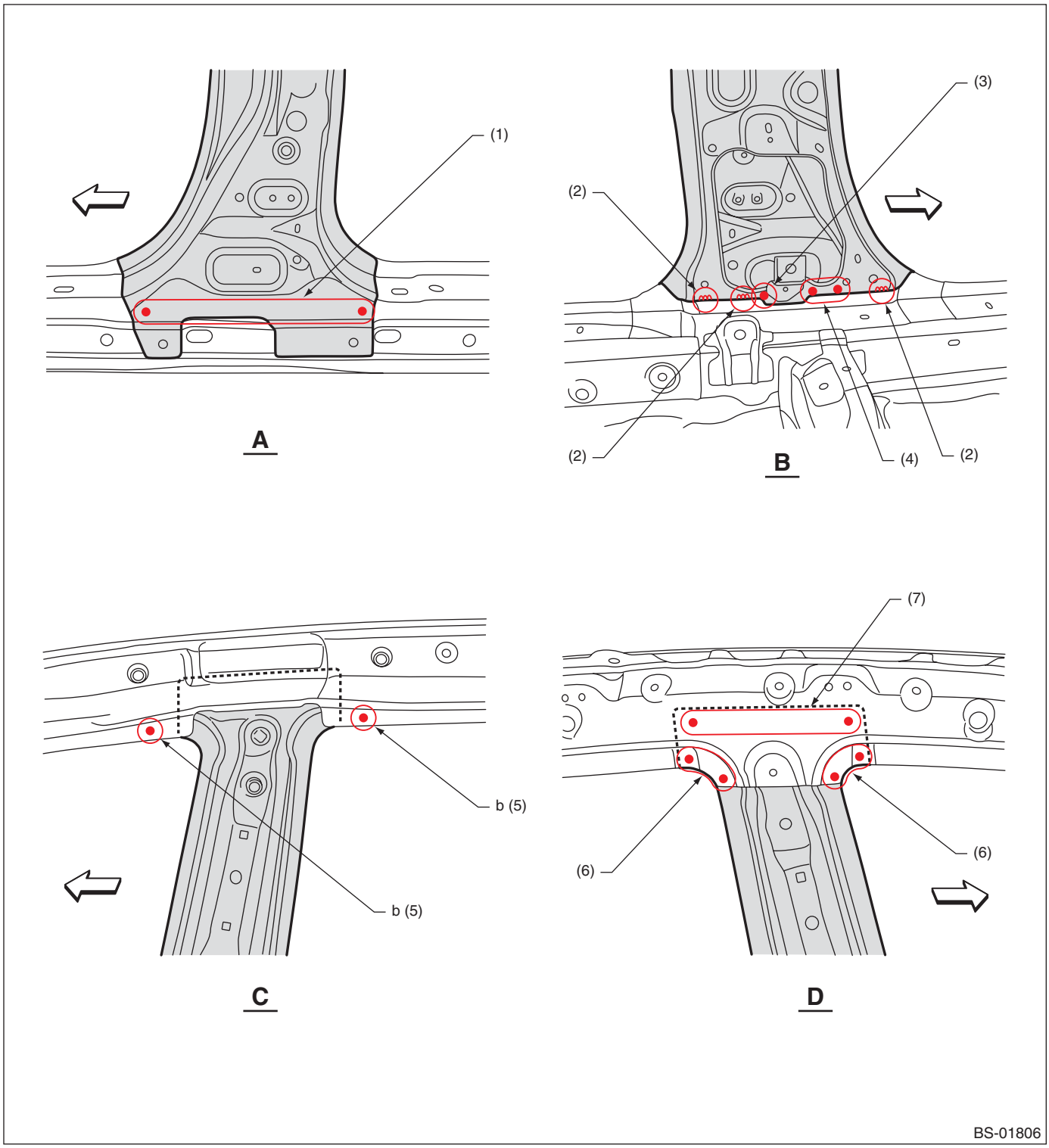
A: REMOVAL

- **Overall view**



(1) 3 points (outside · 2)
(2) Rough cutting (170 mm), outer reinforcement
(3) 19 points (outside · 2)
(4) 5 points (outside · 1)
(5) 1 point (top · 1)
(6) 1 point (outside · 1)
(7) 3 points (outside · 1)
(8) 2 points (outside · 1)
(9) 4 points (outside · 1)
(10) Rough cutting (170 mm)

- **Views**

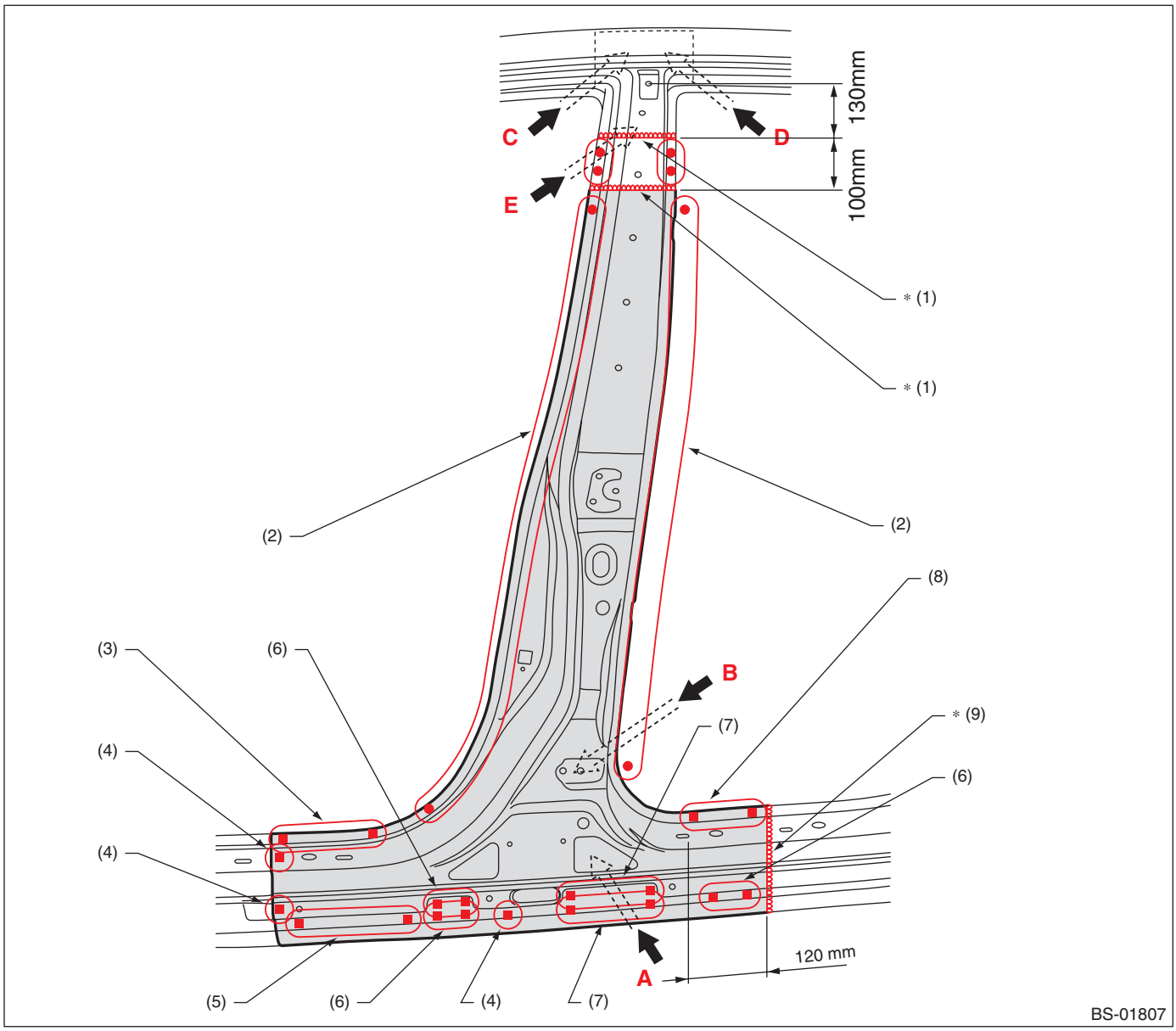


(1)	8 points (outside · 1), hidden hit point	(4)	3 points (inside · 3)	(7)	4 points (inside · 1)
(2)	1 point (inside · 1, belt sander)	(5)	1 point (outside · 1), for easy removal		
(3)	1 point (inside · 1)	(6)	2 points (inside · 1)		

- View C: To facilitate removal, disconnect the welding location b of the roof rail.
- Views A and E show the reinforcement with removed outer front pillar.

B: INSTALLATION

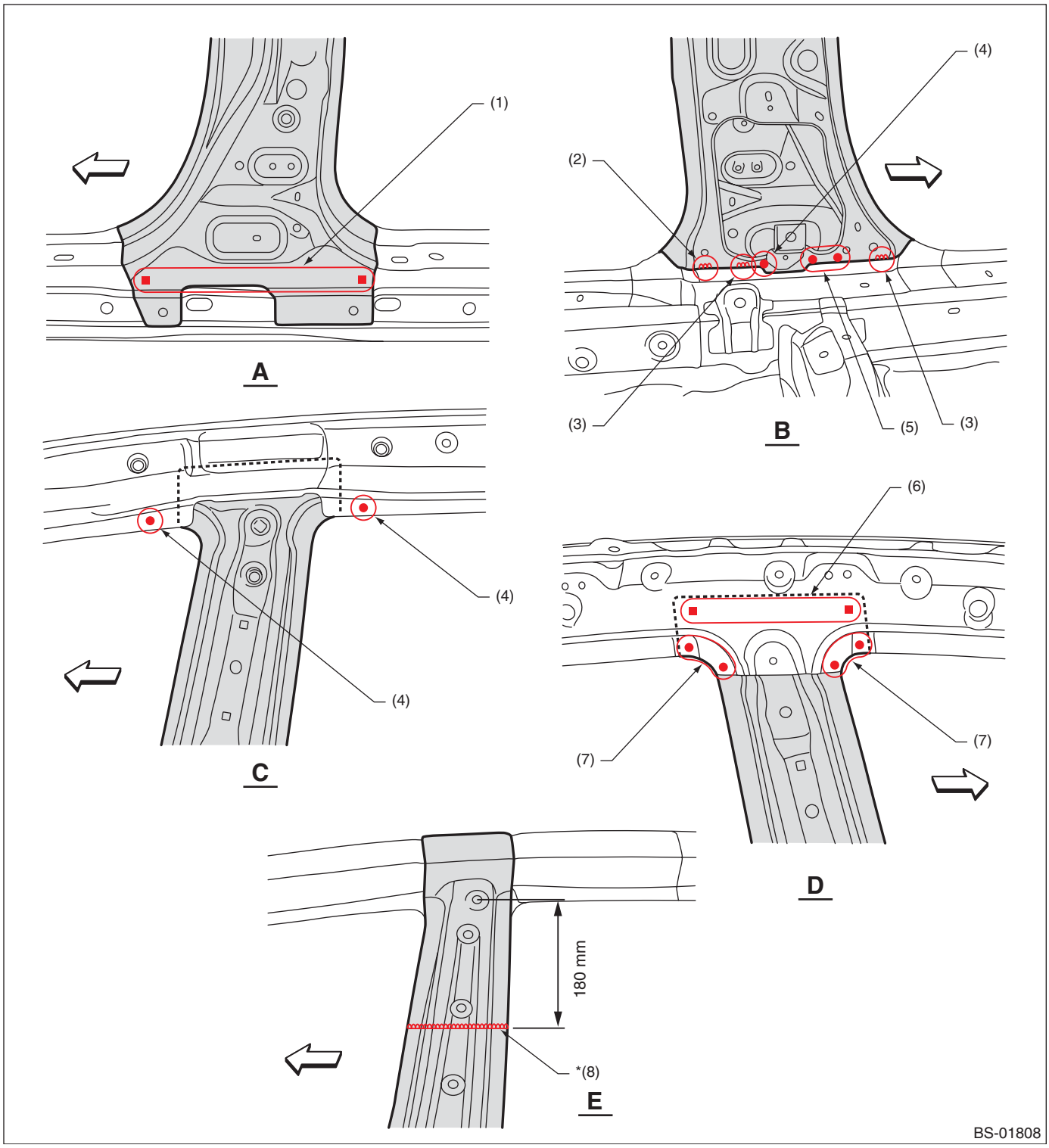
- **Overall view**



(1)	1 point (160 mm)	(4)	1 point (service)	(7)	4 points (service)
(2)	24 points	(5)	3 points (service)	(8)	4 points
(3)	5 points	(6)	2 points (service)	(9)	1 point (170 mm)

For continuous welds marked by *, apply anticorrosion wax thoroughly on the reverse side.

- **Views**



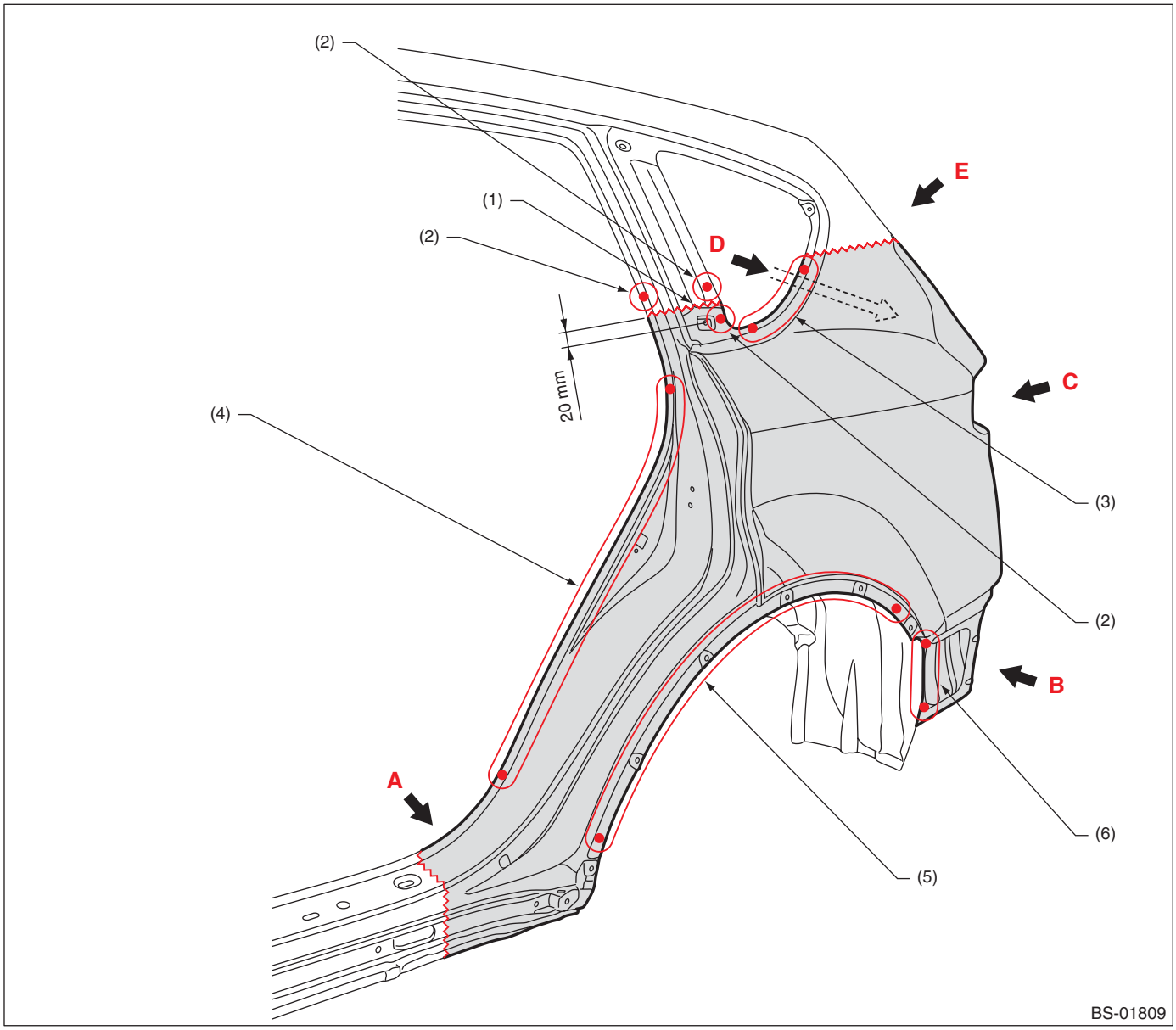
(1) 8 points
(2) 1 point (30 mm)
(3) 1 point (25 mm)
(4) 1 point
(5) 3 points
(6) 4 points (service)
(7) 2 points
(8) 1 point (160 mm)

For continuous welds marked by *, apply anticorrosion wax thoroughly on the reverse side.

21.Rear Quarter (partial replacement)

A: REMOVAL

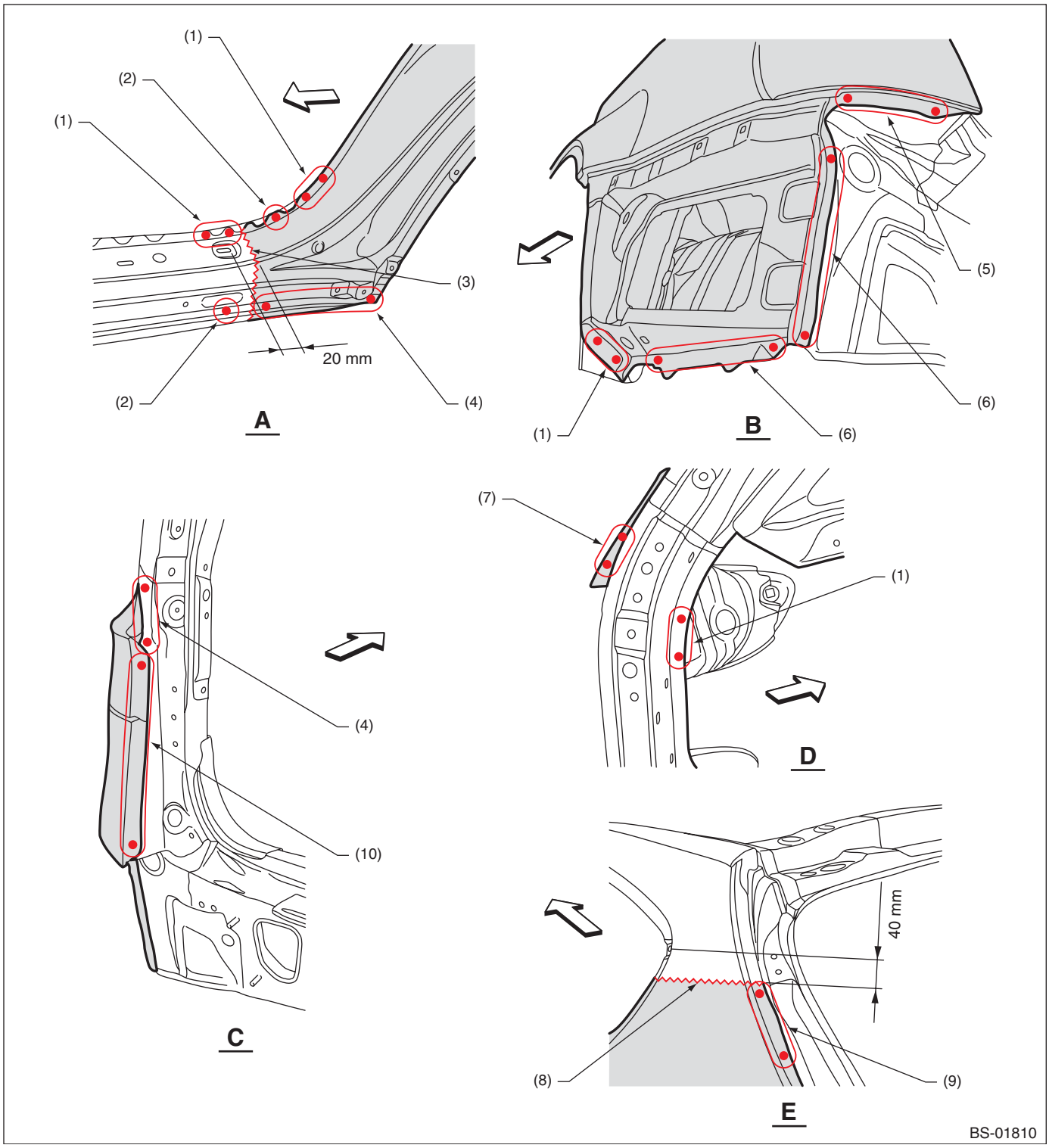
- **Overall view**



(1) Rough cutting (160 mm)
(2) 1 point (outside · 1)
(3) 8 points (outside · 1)
(4) 22 points (outside · 1)
(5) 21 points (outside ·1)
(6) 7 points (outside · 1)

Rear Quarter (partial replacement)

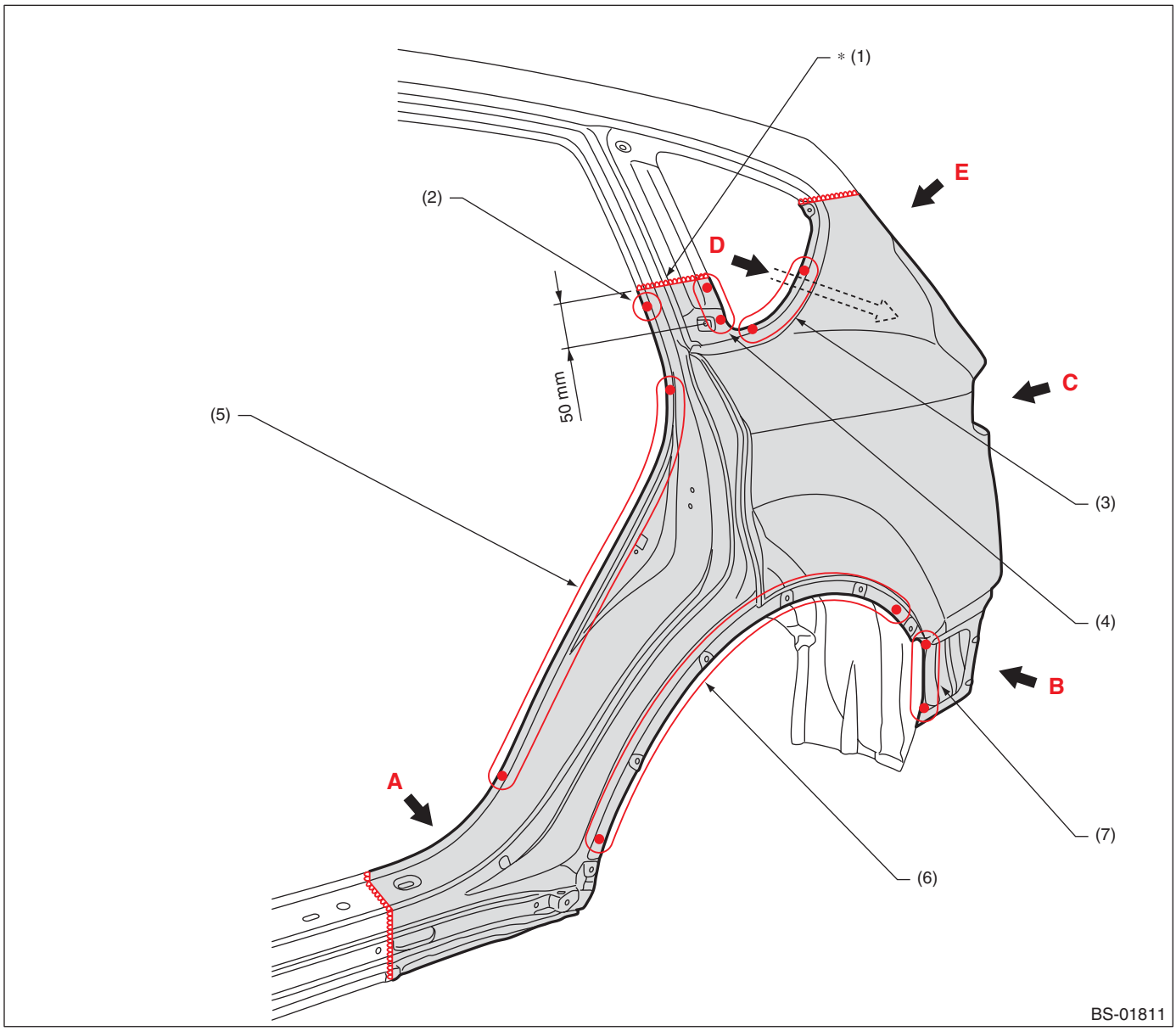
- **Views**



(1) 2 points (outside · 1)
(2) 1 point (outside · 1)
(3) Rough cutting (170 mm)
(4) 3 points (outside · 1)
(5) 3 points (bottom · 1)
(6) 6 points (outside · 1)
(7) 2 points (top · 1)
(8) Rough cutting (260 mm)
(9) 5 points (outside · 1)
(10) 7 points (outside · 1)

B: INSTALLATION

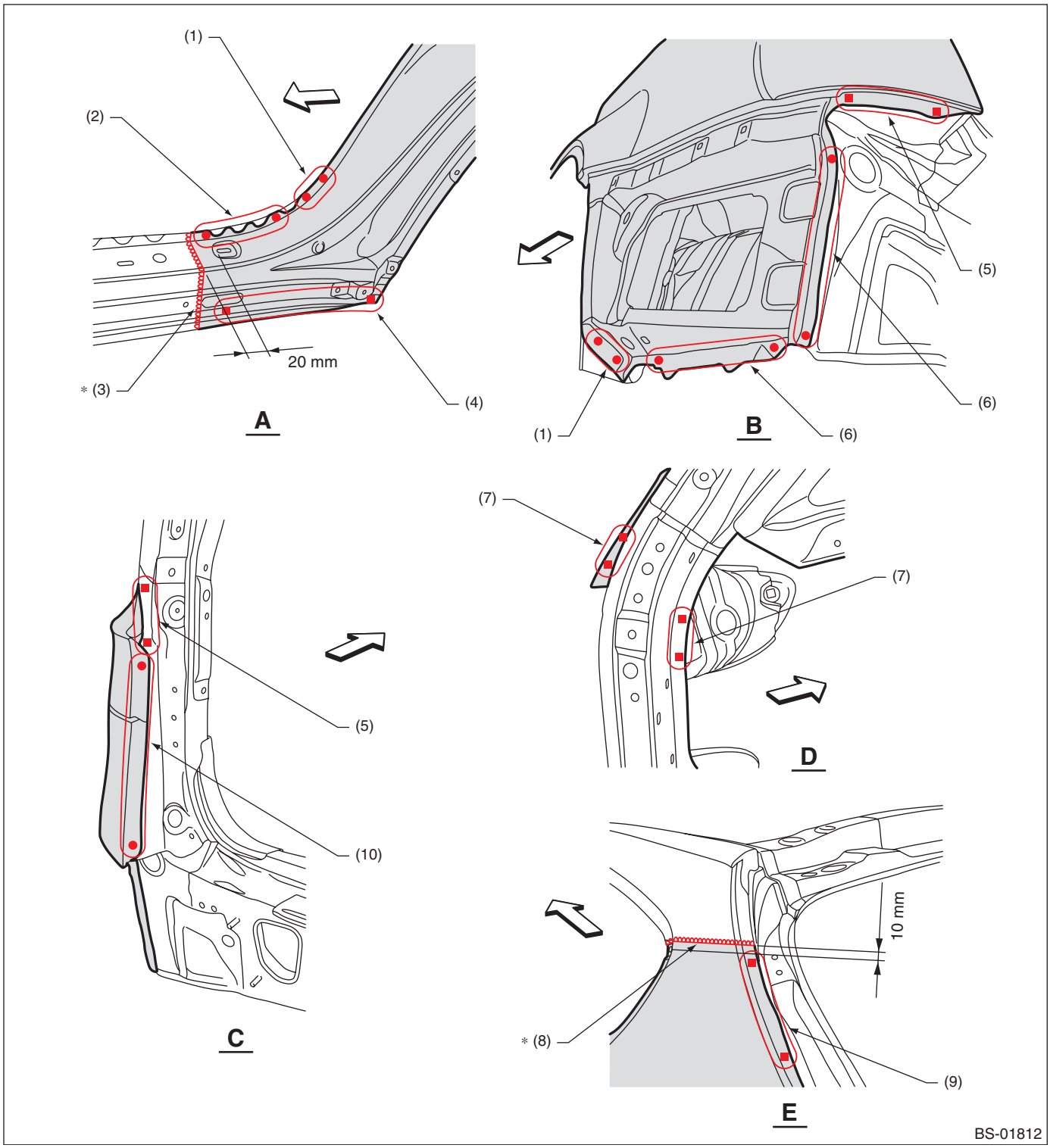
- **Overall view**



(1)	1 point (160 mm)	(4)	2 points	(7)	7 points
(2)	1 point	(5)	24 points		
(3)	8 points	(6)	21 points		

For continuous welds marked by *, apply anticorrosion wax thoroughly on the reverse side.

- **Views**



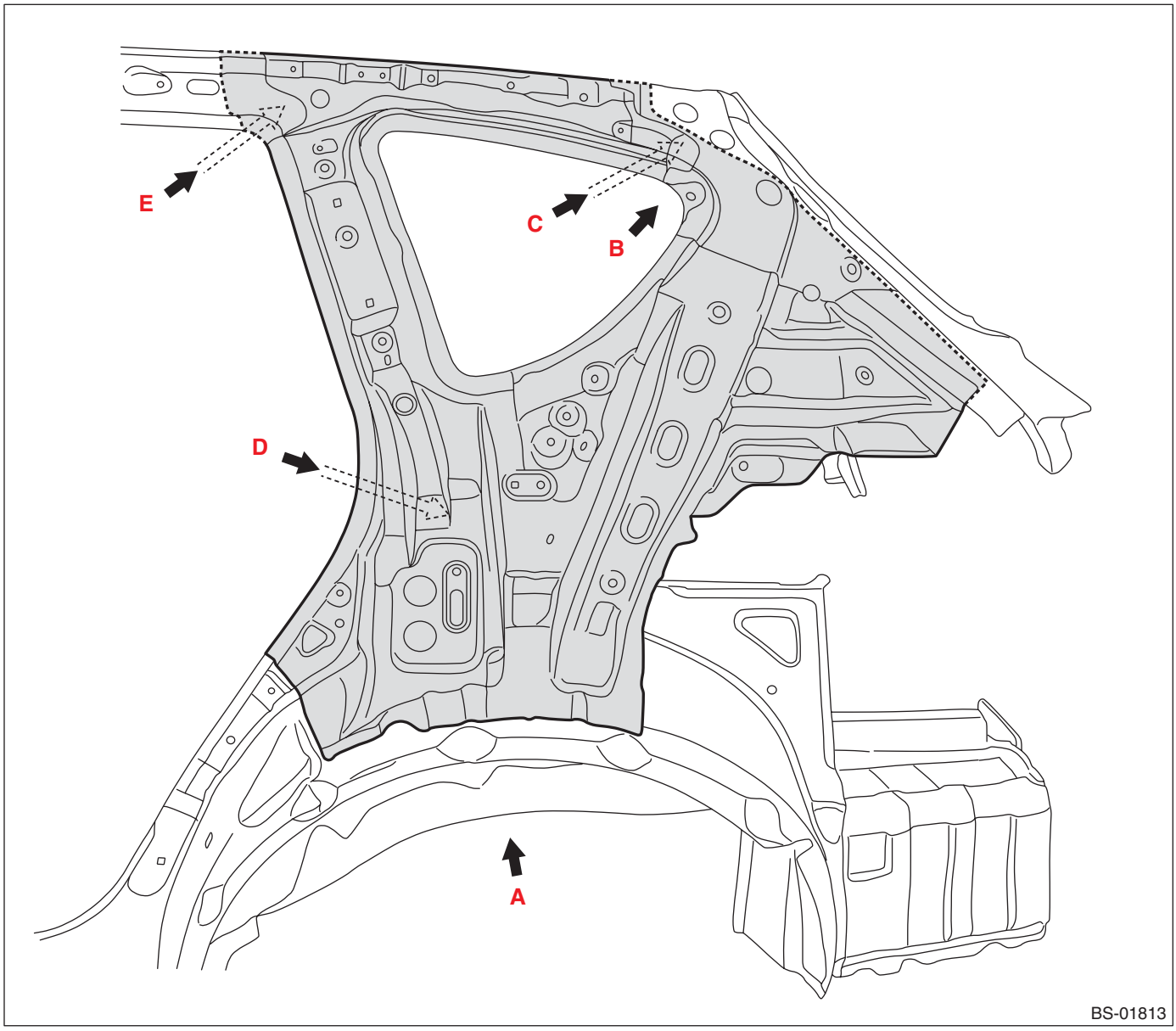
(1) 2 points
(2) 3 points
(3) 1 point (170 mm)
(4) 4 points (service)
(5) 3 points (service)
(6) 6 points
(7) 2 points (service)
(8) 1 point (240 mm)
(9) 5 points (service)
(10) 7 points

For continuous welds marked by *, apply anticorrosion wax thoroughly on the reverse side.

22.Rear Quarter Inner Upper (total replacement)

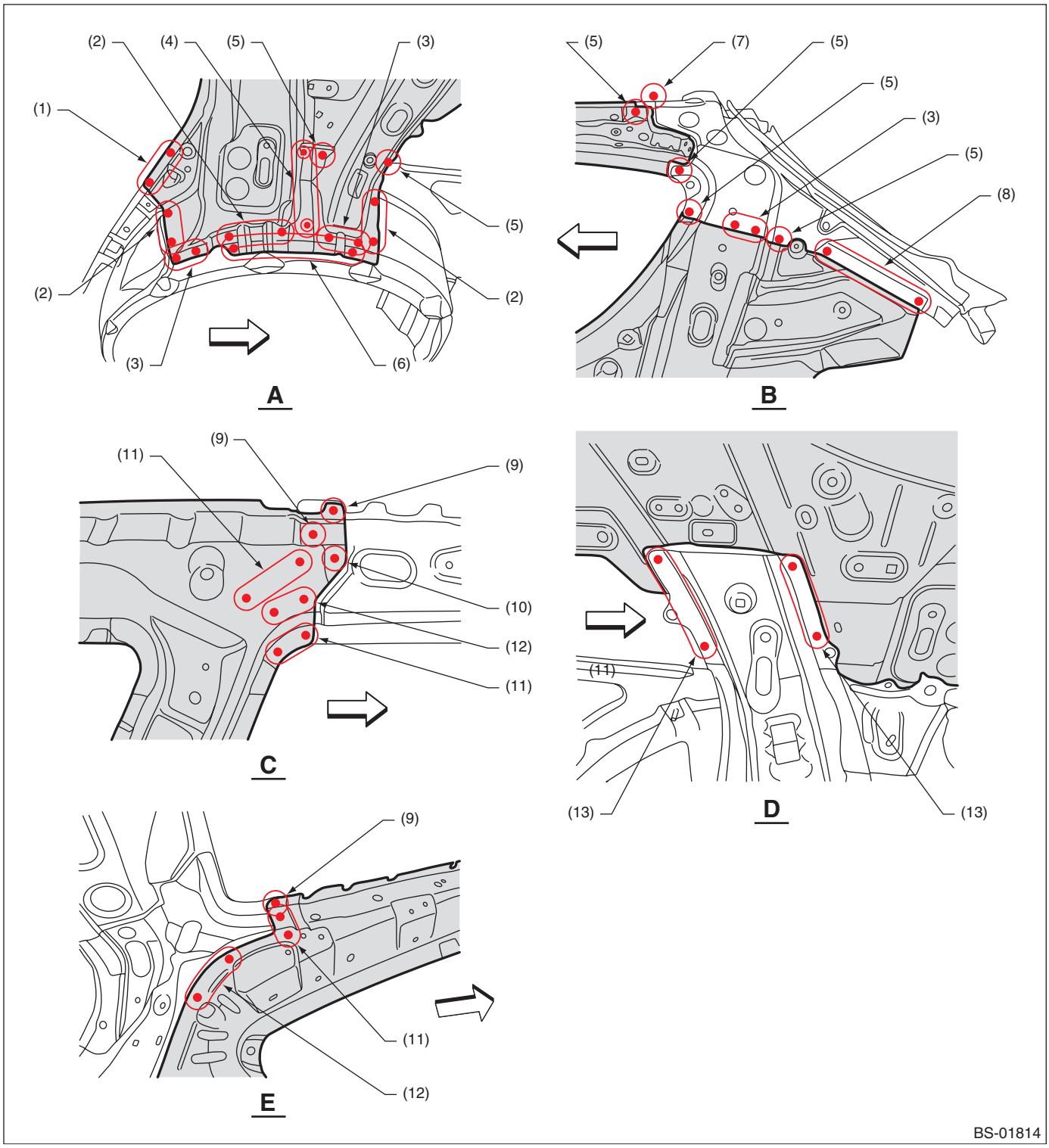
A: REMOVAL

- **Overall view**



Rear Quarter Inner Upper (total replacement)

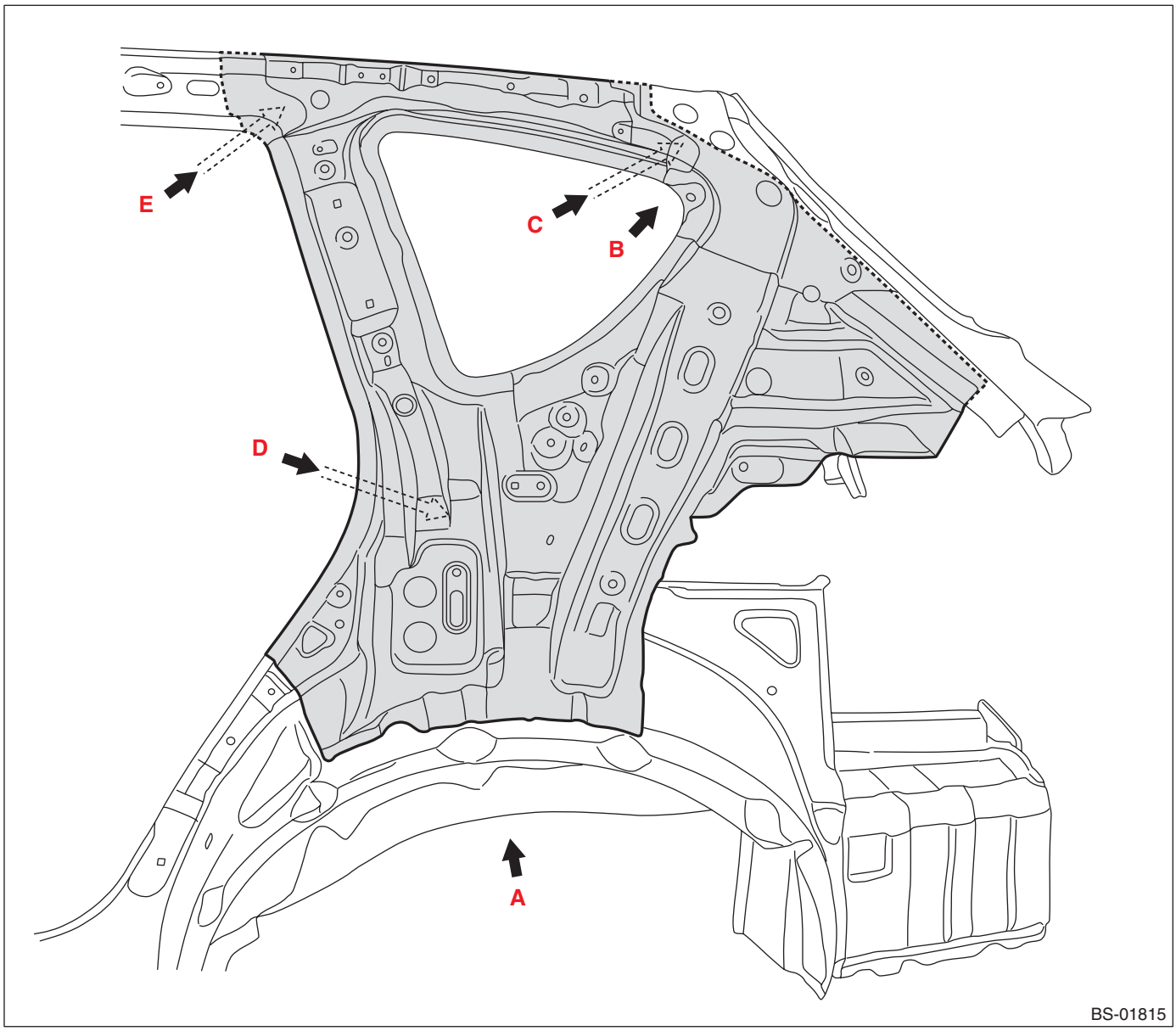
- **Views**



(1) 5 points (outside · 1)
(2) 3 points (outside · 1)
(3) 2 points (outside · 1)
(4) 4 points (outside · 2)
(5) 1 point (outside · 1)
(6) 4 points (outside · 1)
(7) 1 point (top · 1)
(8) 9 points (outside · 1)
(9) 1 point (bottom · 1)
(10) 1 point (inside · 1)
(11) 2 points (inside · 1)
(12) 3 points (inside · 1)
(13) 4 points (inside · 1)

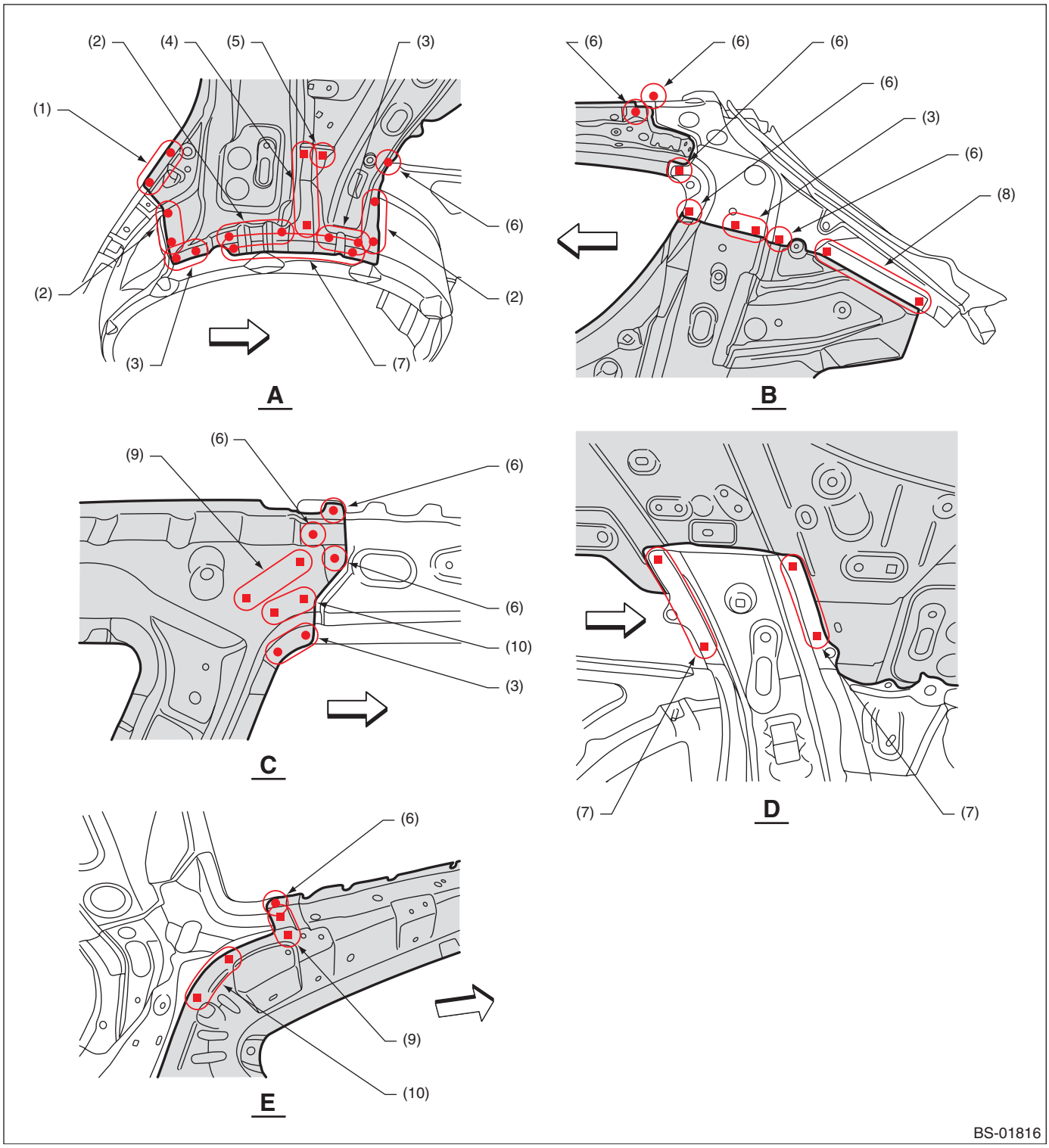
B: INSTALLATION

- **Overall view**



Rear Quarter Inner Upper (total replacement)

- **Views**



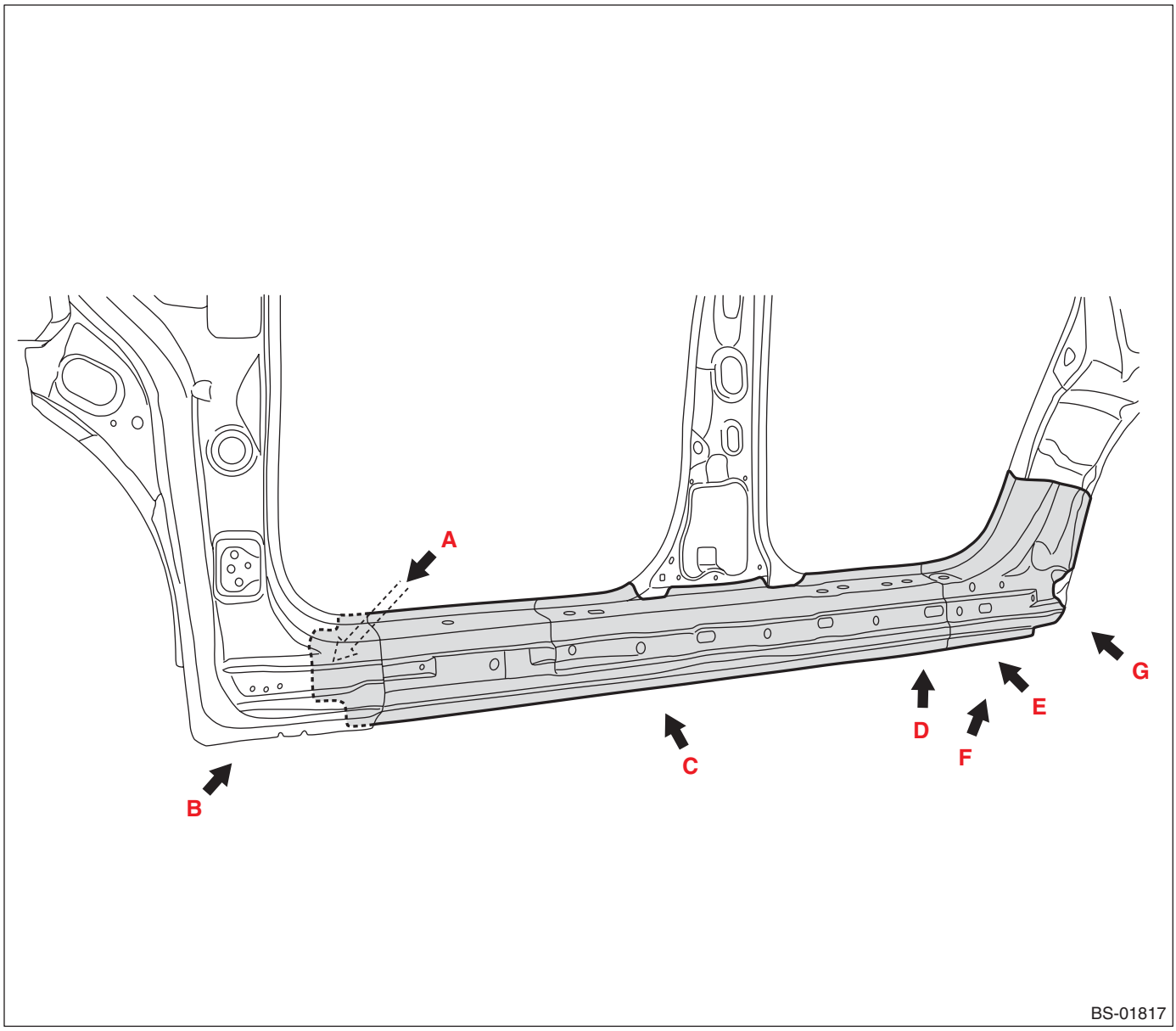
(1) 5 points
(2) 3 points
(3) 2 points
(4) 4 points (service)
(5) 1 point (service)
(6) 1 point
(7) 4 points
(8) 9 points
(9) 2 points (service)
(10) 3 points (service)

23.Side Sill Outer (total replacement)

A: REMOVAL

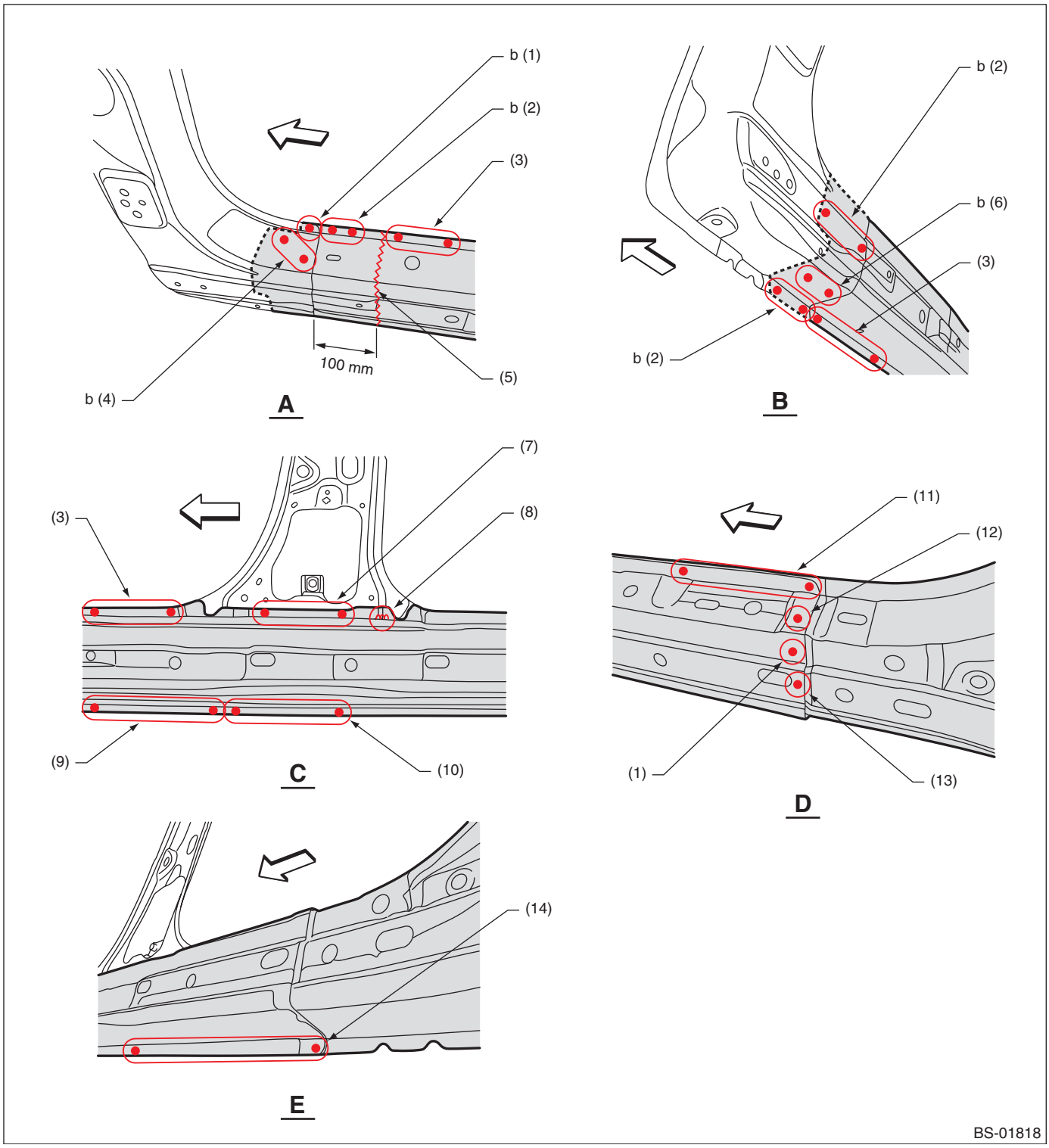
1) Center pillar outer and rear quarter outer removed condition

- **Overall view**



Side Sill Outer (total replacement)

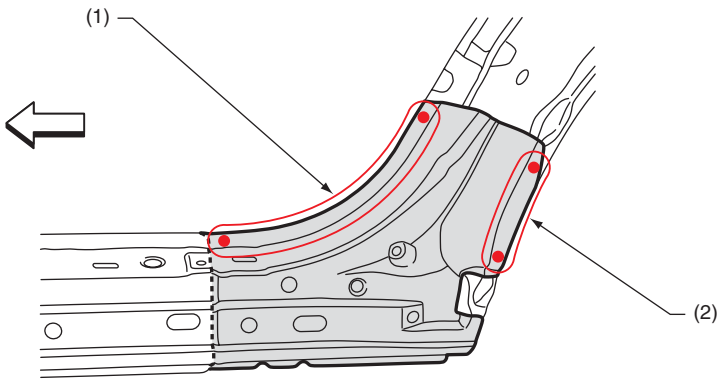
- **Views 1**



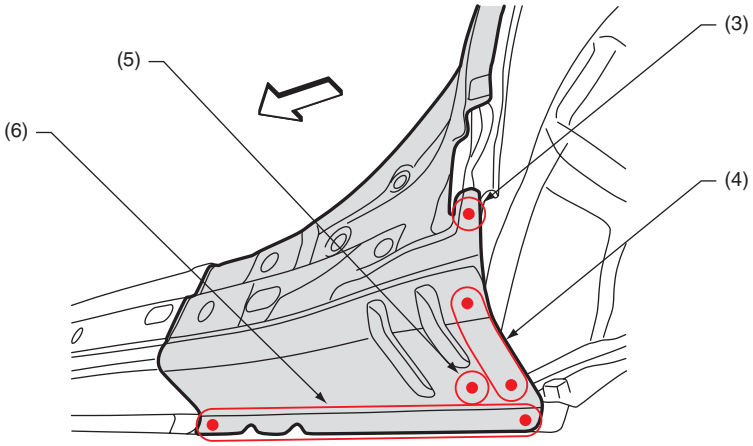
(1)	1 point (outside · 2)	(6)	2 points (bottom · 1)	(11)	10 points (outside · 1)
(2)	3 points (outside · 1)	(7)	4 points (outside · 1)	(12)	1 point (top · 1)
(3)	6 points (outside · 1)	(8)	1 point (outside · 1, belt sander)	(13)	1 point (bottom · 1)
(4)	2 points (top · 1)	(9)	8 points (outside · 1)	(14)	13 points (outside · 1)
(5)	Cut (280 mm) to make work easier	(10)	5 points (outside · 1)		

- Views A and B: To facilitate removal, remove the welding location part b.

- **Views 2**



F



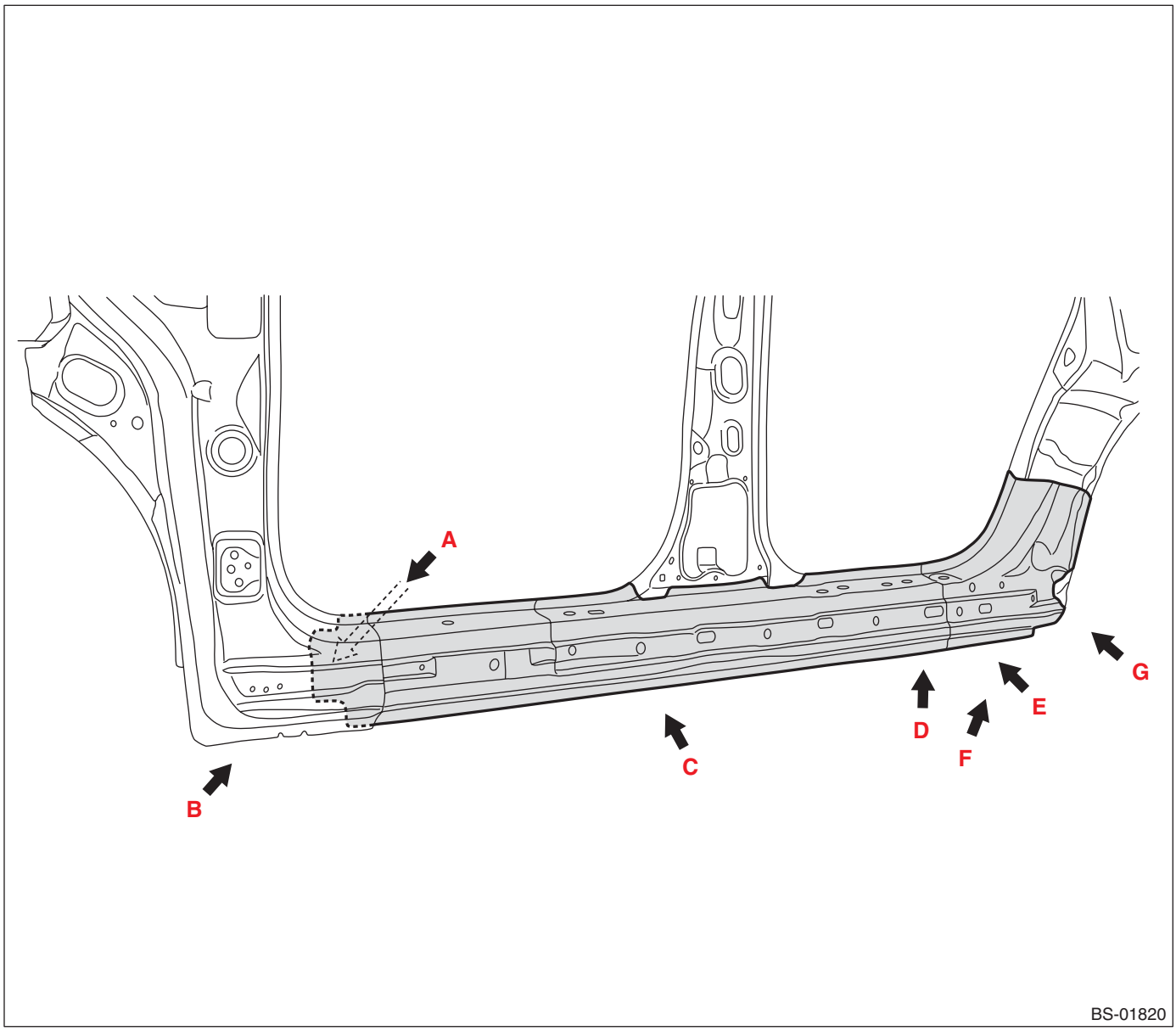
G

BS-01819

(1) 14 points (outside · 1)
(2) 4 points (outside · 1)
(3) 1 point (outside · 1)
(4) 3 points (bottom · 1)
(5) 1 point (bottom · 1)
(6) 10 points (outside · 1)

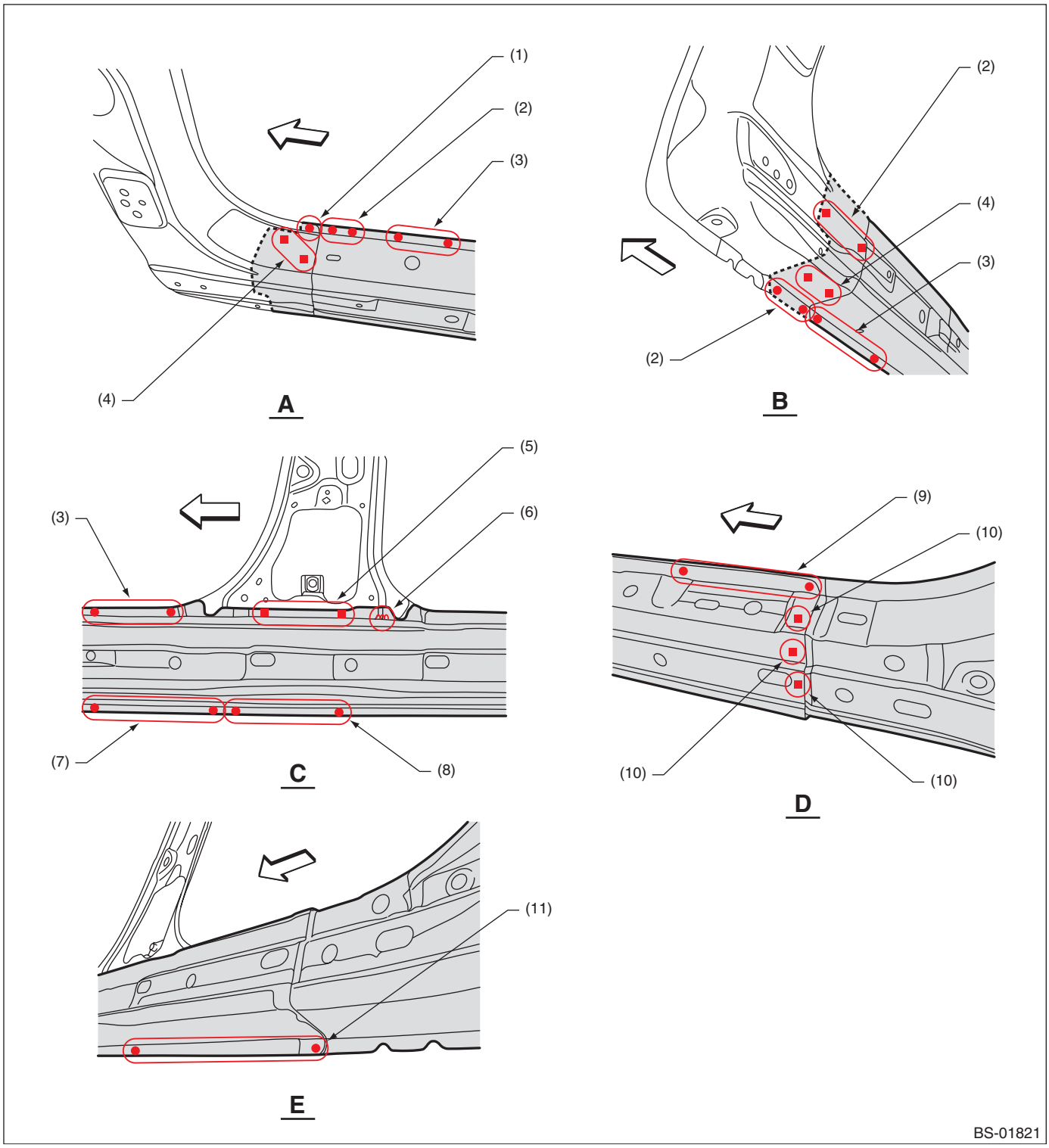
B: INSTALLATION

- **Overall view**



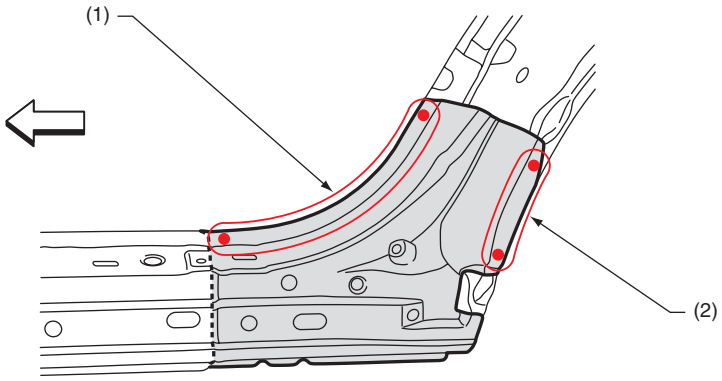
Side Sill Outer (total replacement)

- **Views 1**

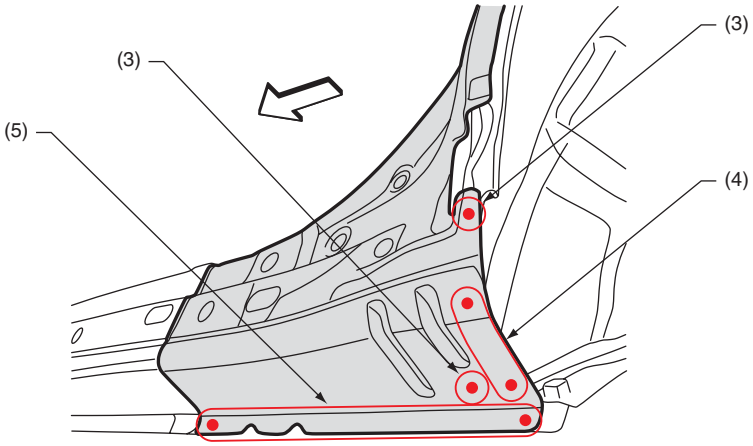


(1) 1 point
(2) 3 points
(3) 6 points
(4) 2 points
(5) 4 points (service)
(6) 1 point (20 mm)
(7) 8 points
(8) 5 points
(9) 10 points
(10) 1 point (service)
(11) 13 points

- **Views 2**



F



G

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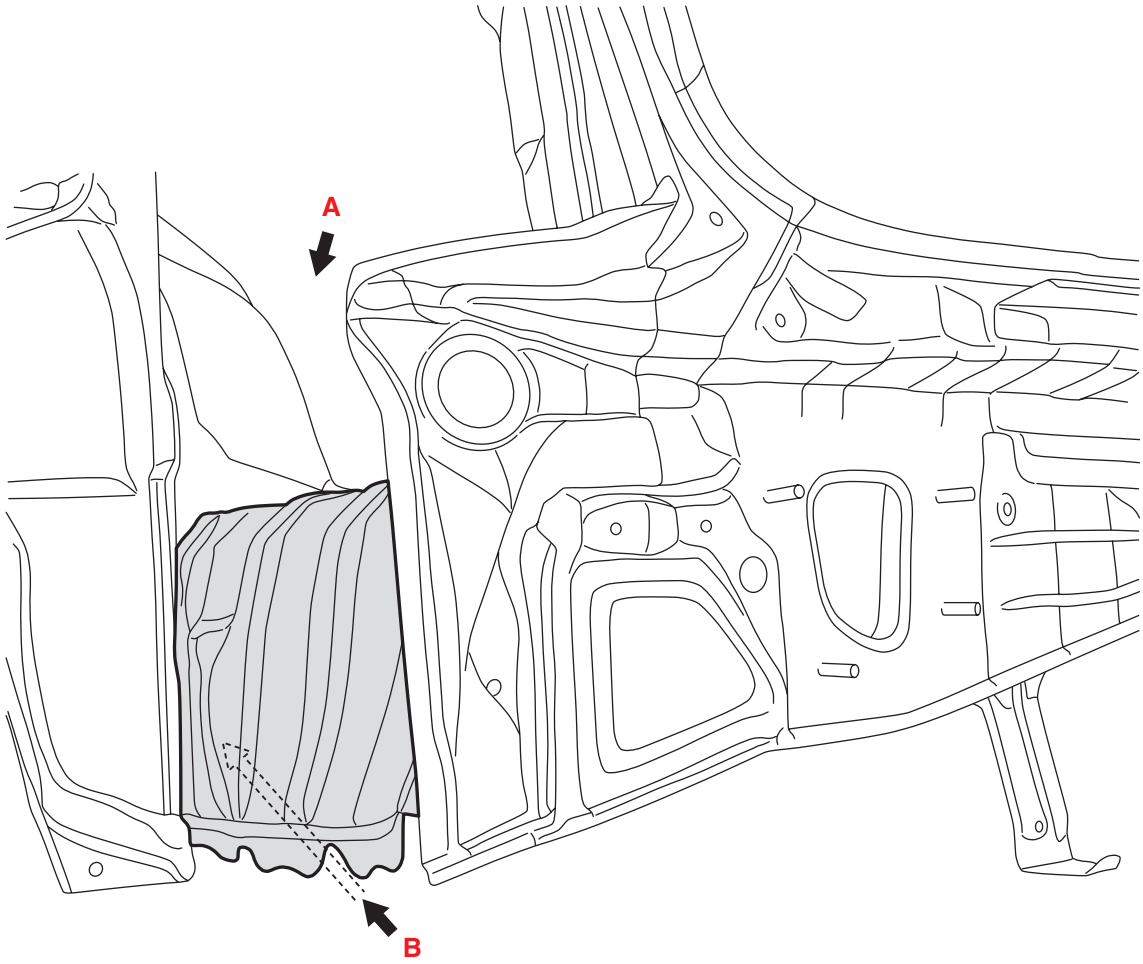
(1) 14 points
(2) 4 points
(3) 1 point
(4) 3 points
(5) 10 points

24.Rear Floor Side (total replacement)

A: REMOVAL

1) Rear quarter and D-pillar removed condition

- **Overall view**



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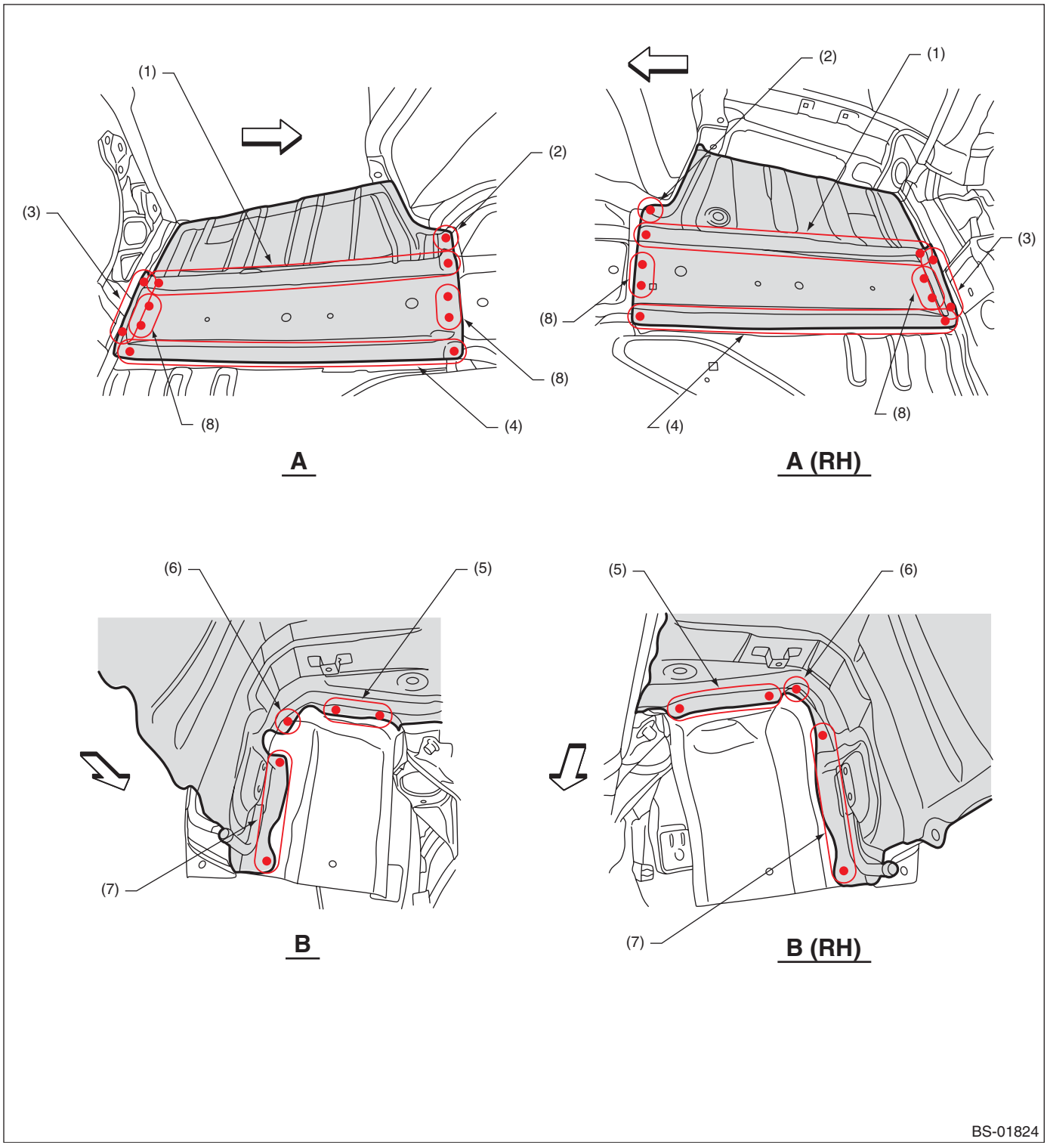
Rear Floor Side (total replacement)

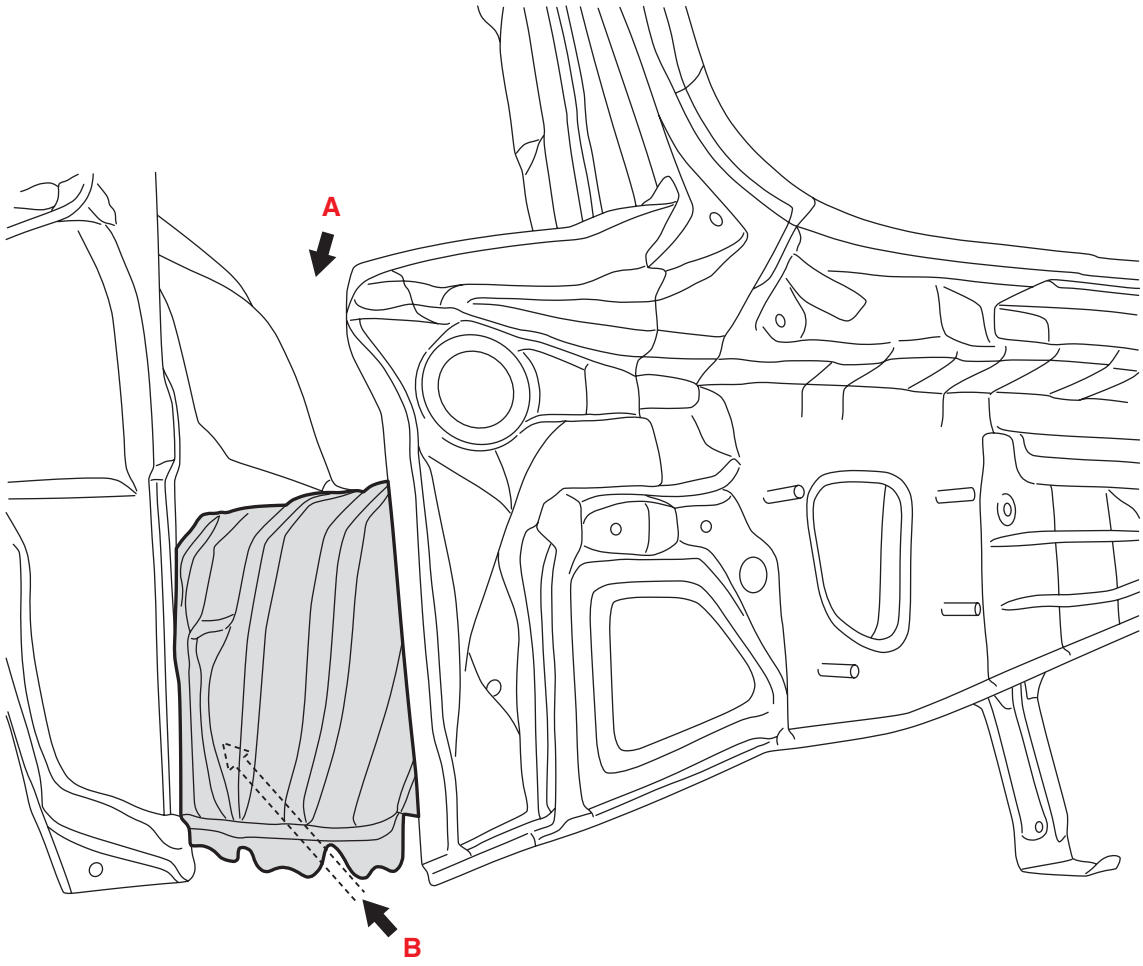
- **Views**



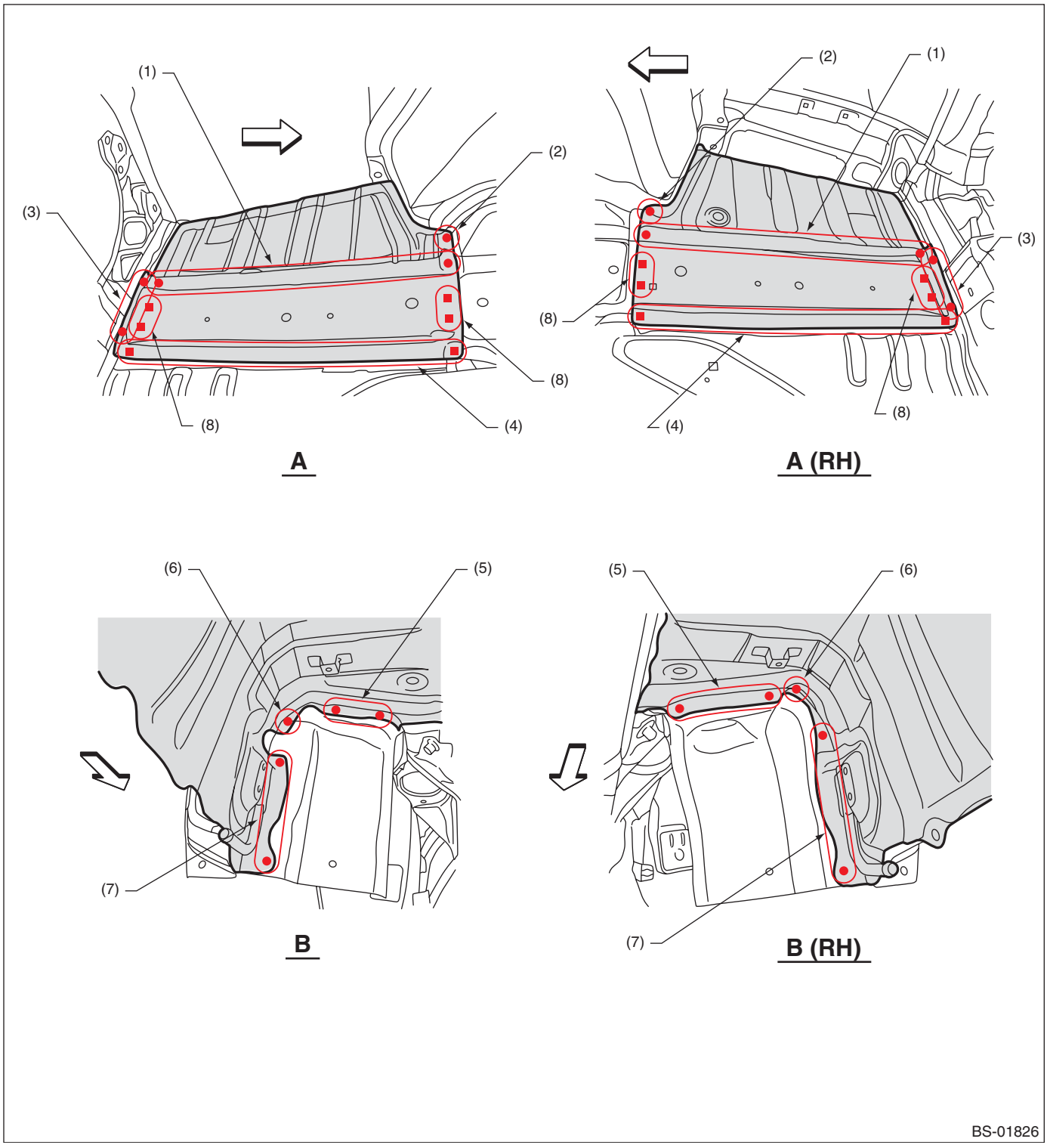
(1) 11 points (top · 2)
(2) 1 point (top · 1)
(3) 4 points (inside · 1)
(4) 10 points (top · 1)
(5) 3 points (outside · 1)
(6) 1 point (outside · 1)
(7) 5 points (outside · 1)
(8) 2 points (top · 1)

B: INSTALLATION

- **Overall view**



- **Views**



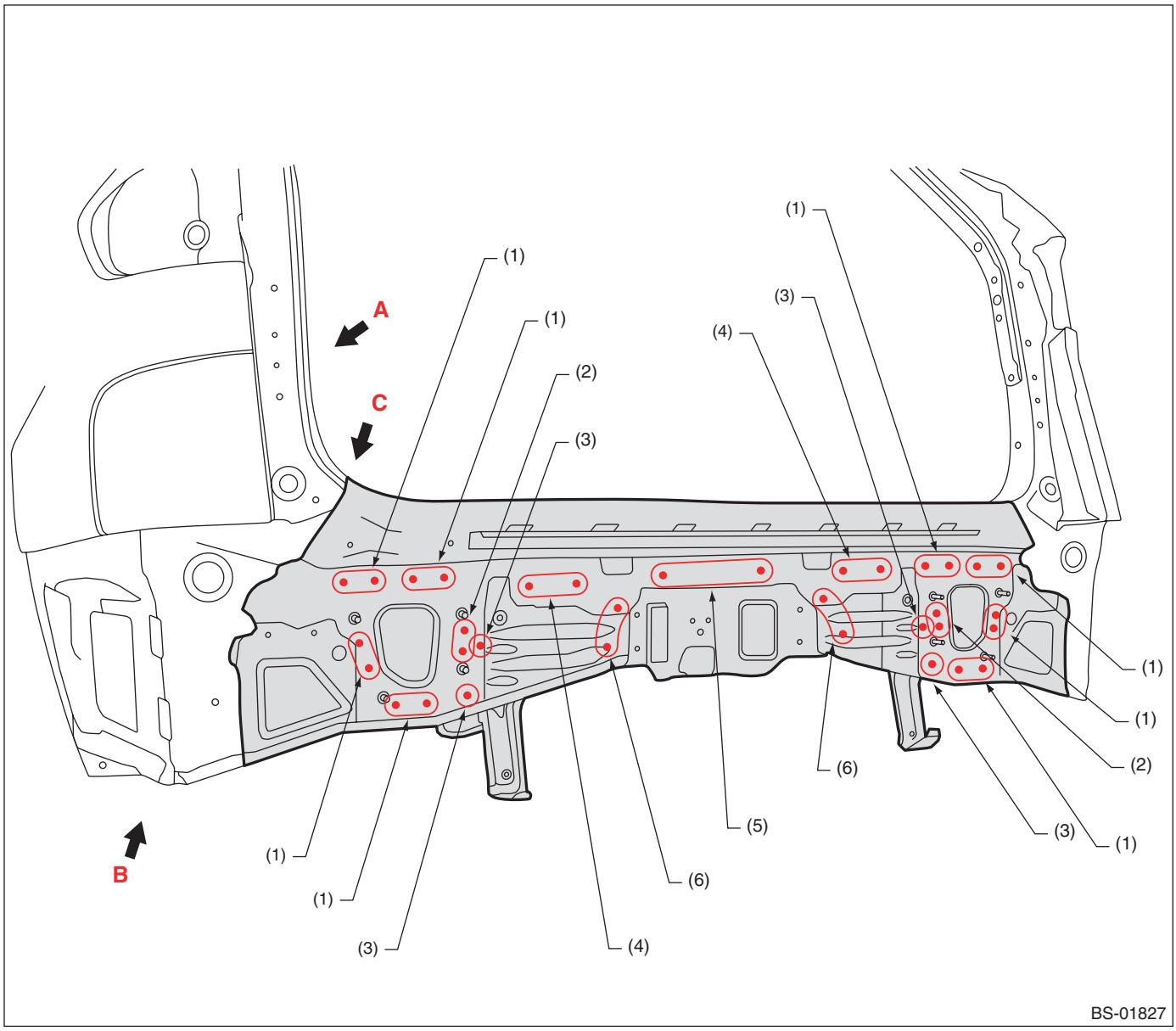
(1) 11 points (matching)
(2) 1 point
(3) 4 points
(4) 10 points (service)
(5) 3 points
(6) 1 point
(7) 5 points
(8) 2 points (service)

25.Rear Skirt Outer (total replacement)

A: REMOVAL

1) D-pillar removed condition

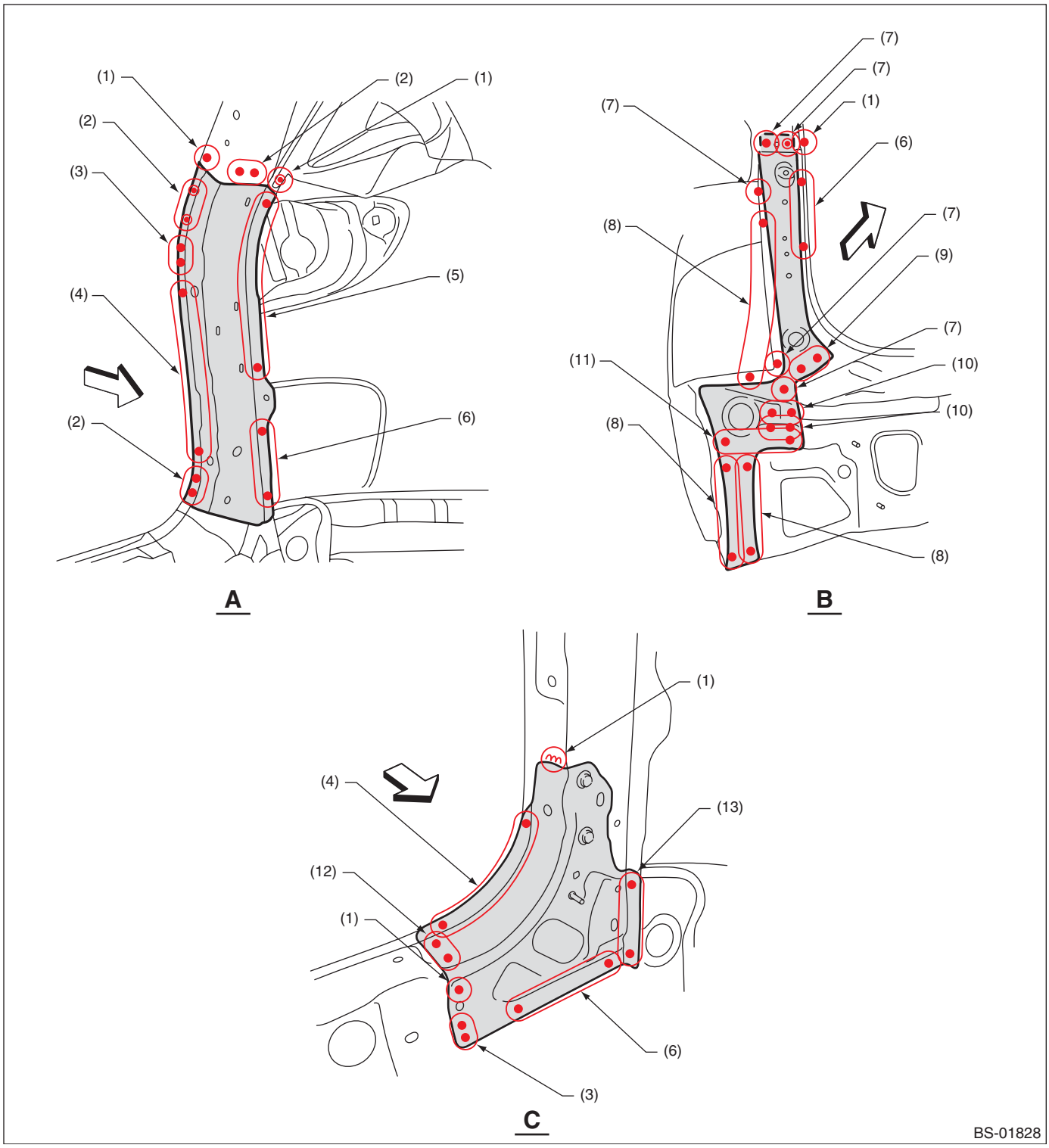
- **Overall view**



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

Rear Skirt Outer (total replacement)

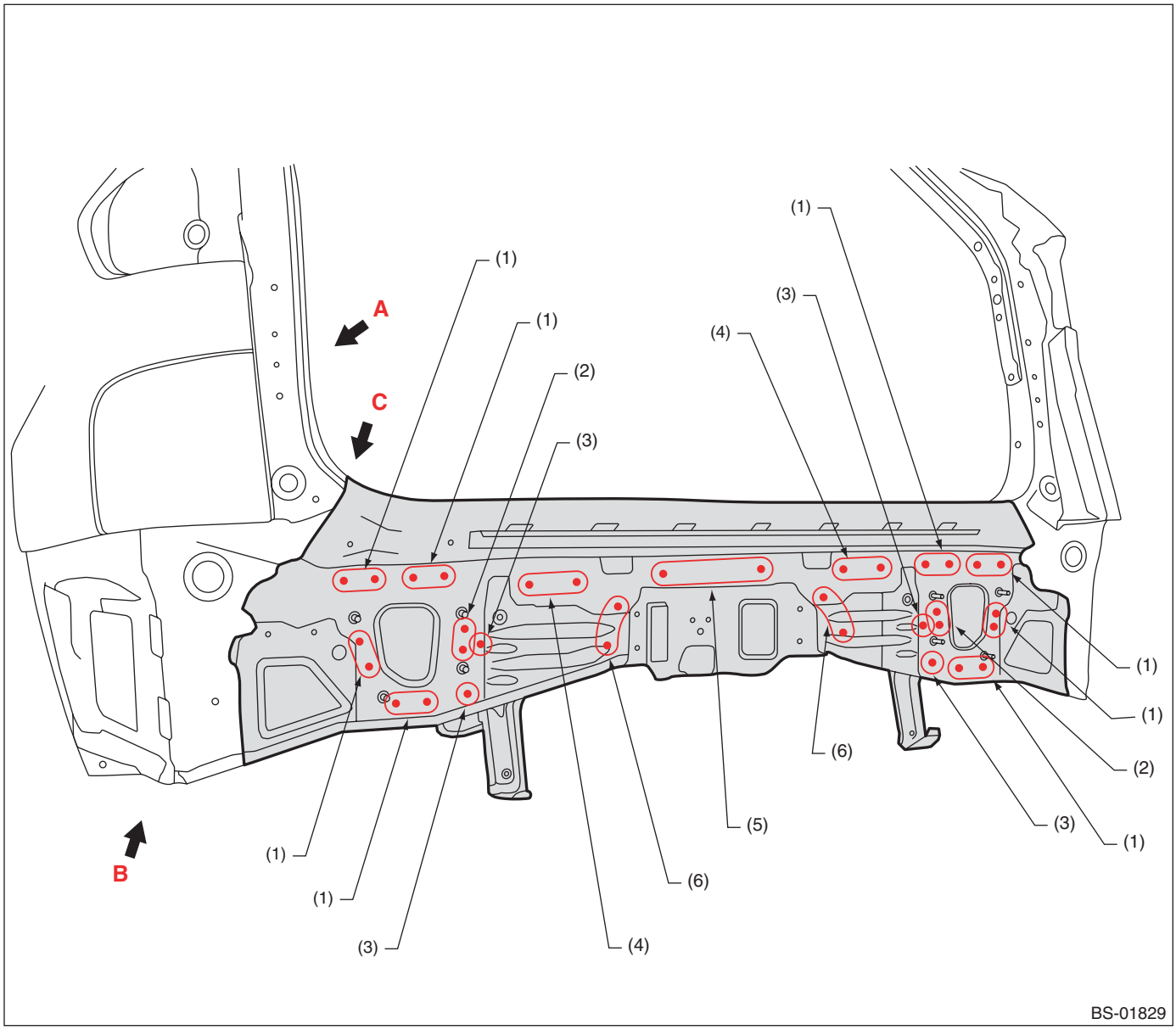
- **Views**



(1) 1 point (inside · 1)
(2) 3 points (inside · 1)
(3) 2 points (inside · 1)
(4) 7 points (inside · 1)
(5) 6 points (inside · 1)
(6) 5 points (inside · 1)
(7) 1 point (outside · 1)
(8) 6 points (outside · 1)
(9) 3 points (outside · 1)
(10) 2 points (outside · 1)
(11) 4 points (outside · 1)
(12) 2 points (top · 1)
(13) 4 points (inside · 1)

B: INSTALLATION

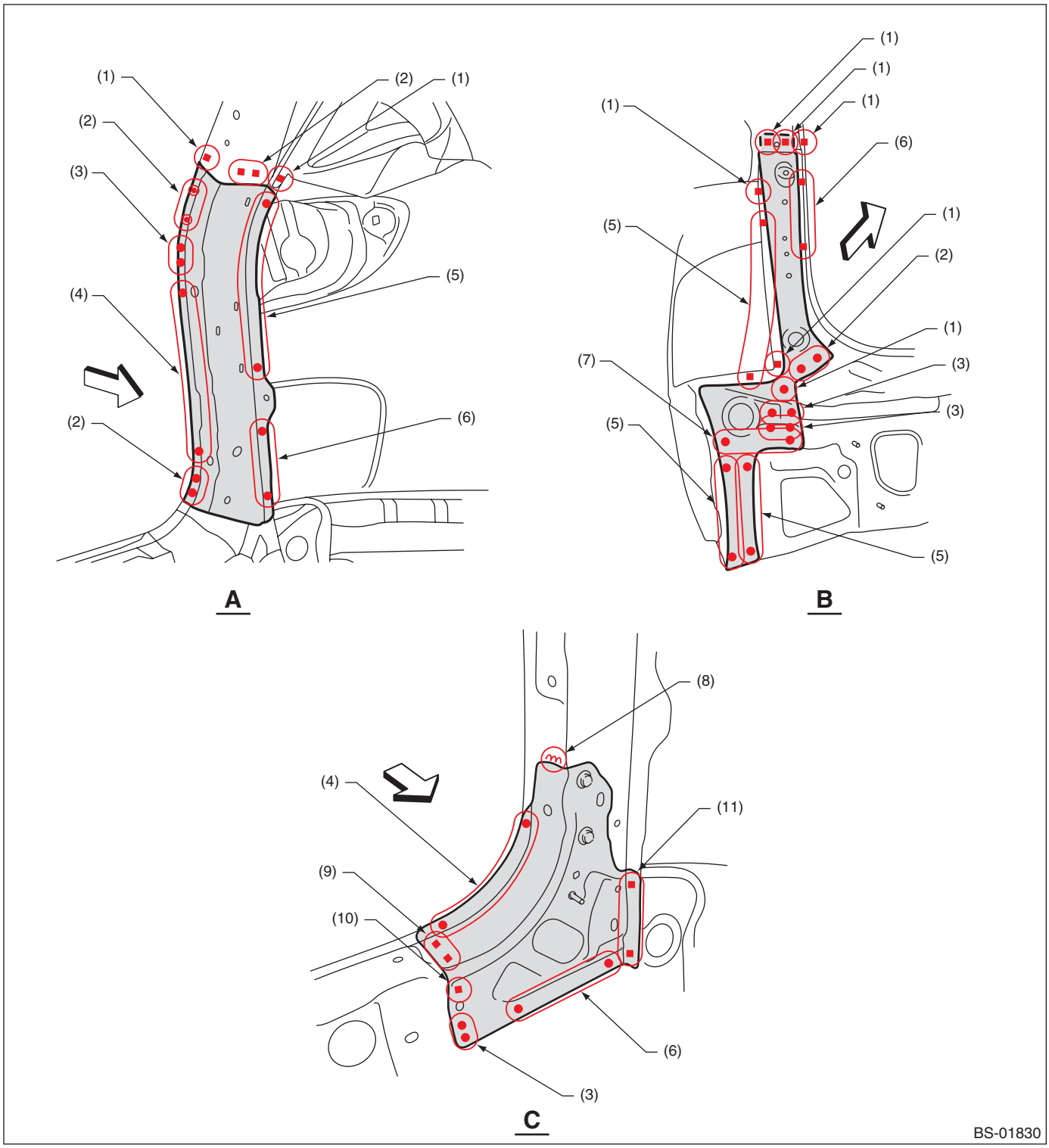
- **Overall view**



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

Rear Skirt Outer (total replacement)

- **Views**



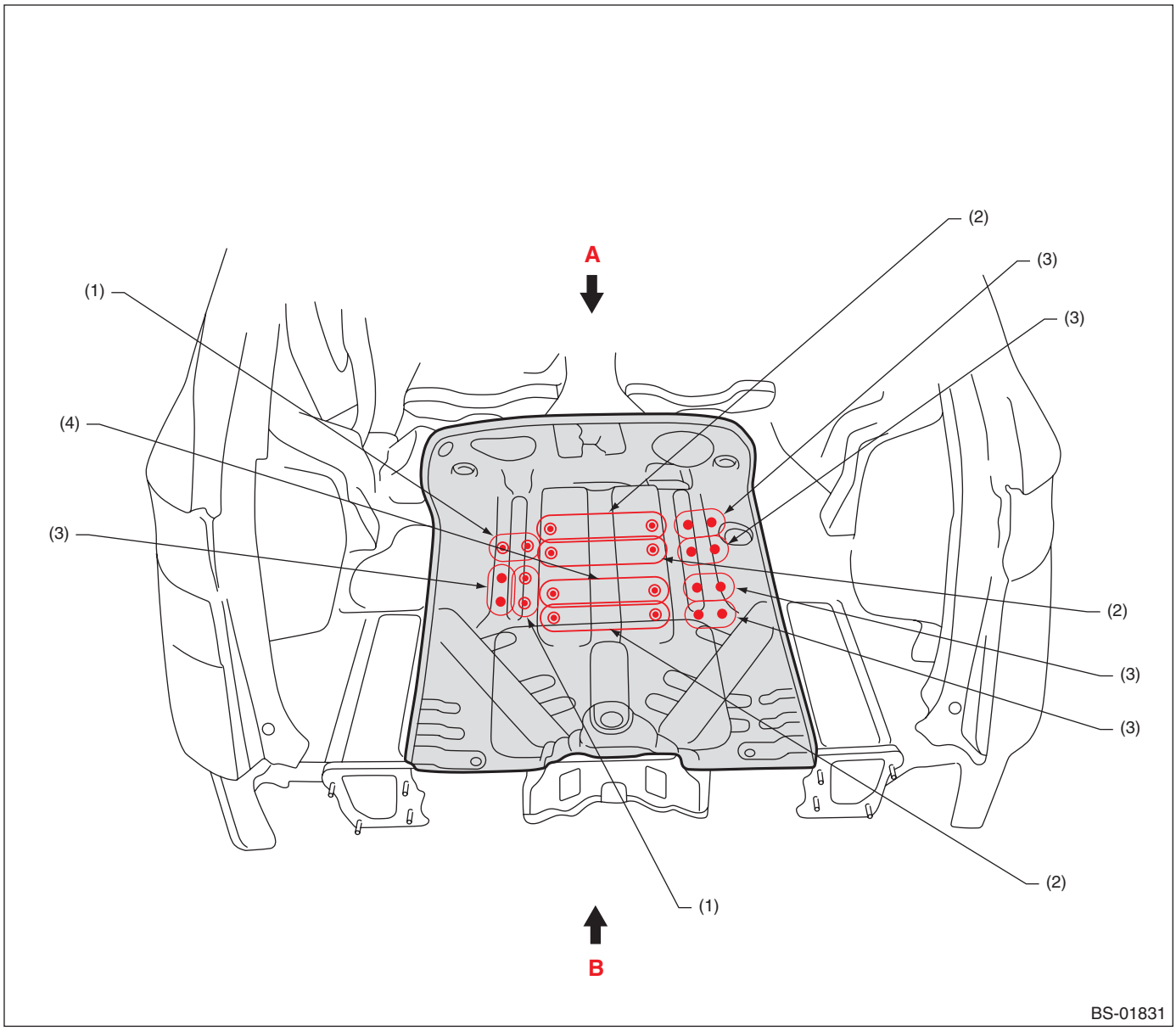
(1) 1 point
(2) 3 points
(3) 2 points
(4) 7 points
(5) 6 points
(6) 5 points
(7) 4 points
(8) 1 point (20 mm)
(9) 2 points (service)
(10) 1 point (service)
(11) 4 points (service)

26.Rear Floor Pan (total replacement)

A: REMOVAL

1) Rear closing plate rear (left/right) removed condition

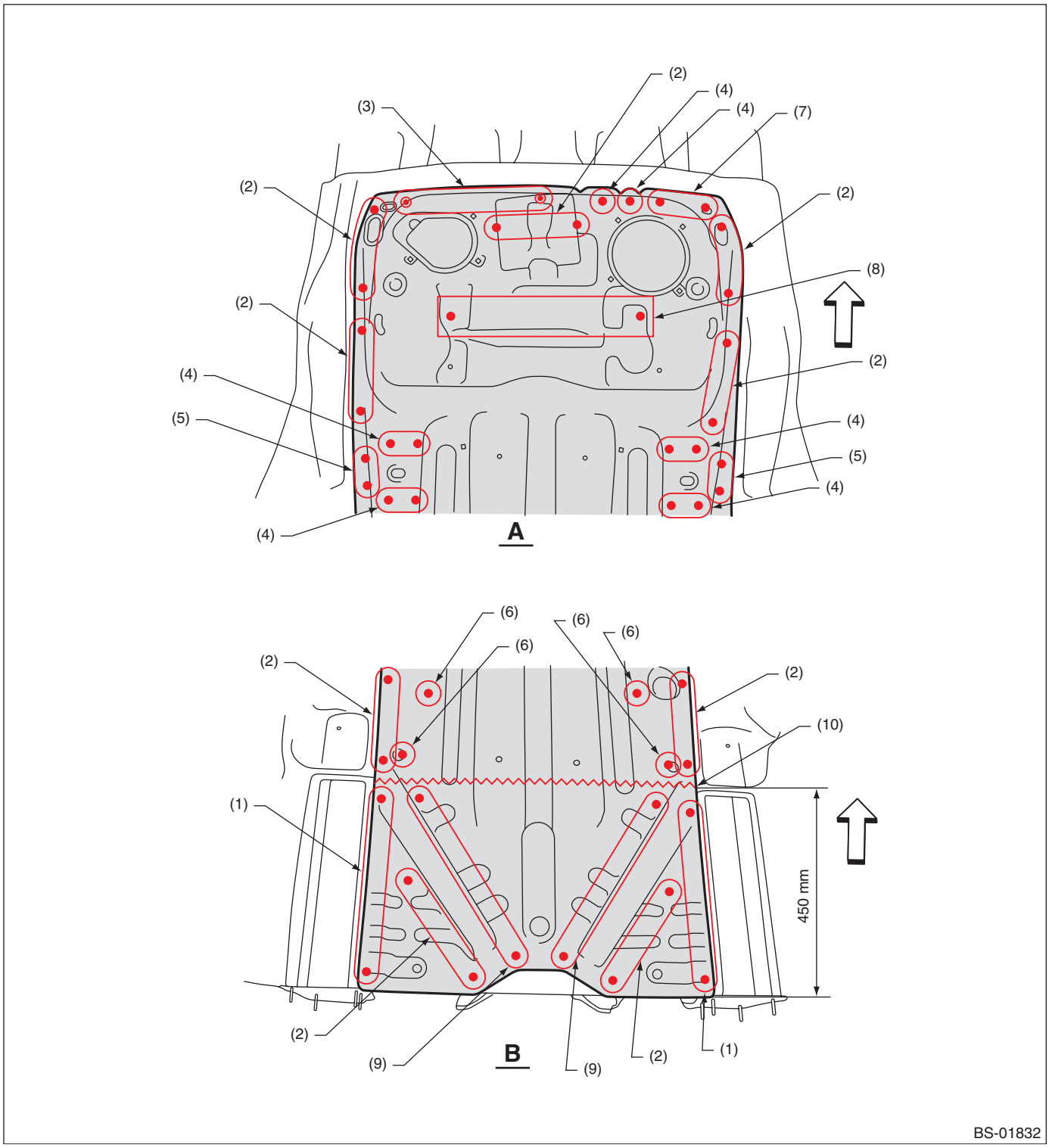
- **Overall view**



(1) 2 points (top · 2)
(2) 8 points (top · 2)
(3) 2 points (top · 1)
(4) 10 points (top · 2)

Rear Floor Pan (total replacement)

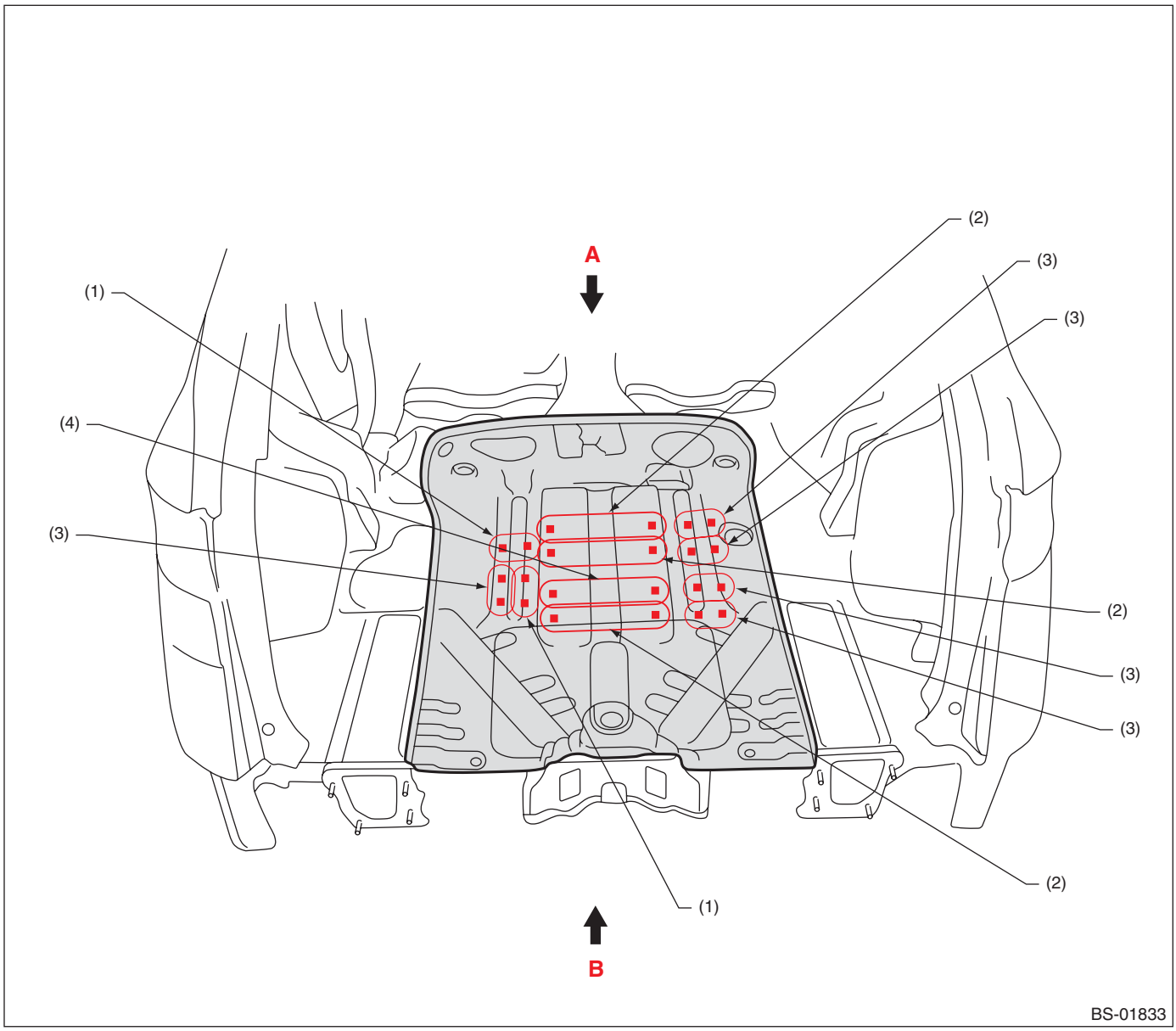
- **Views**



(1) 10 points (top · 1)
(2) 7 points (top · 1)
(3) 12 points (top · 1)
(4) 2 points (top · 1)
(5) 3 points (top · 1)
(6) 1 point (top · 1)
(7) 4 points (top · 1)
(8) 51 points (top · 1)
(9) 6 points (top · 1)
(10) Half cut position 1 point (800 mm)

B: INSTALLATION

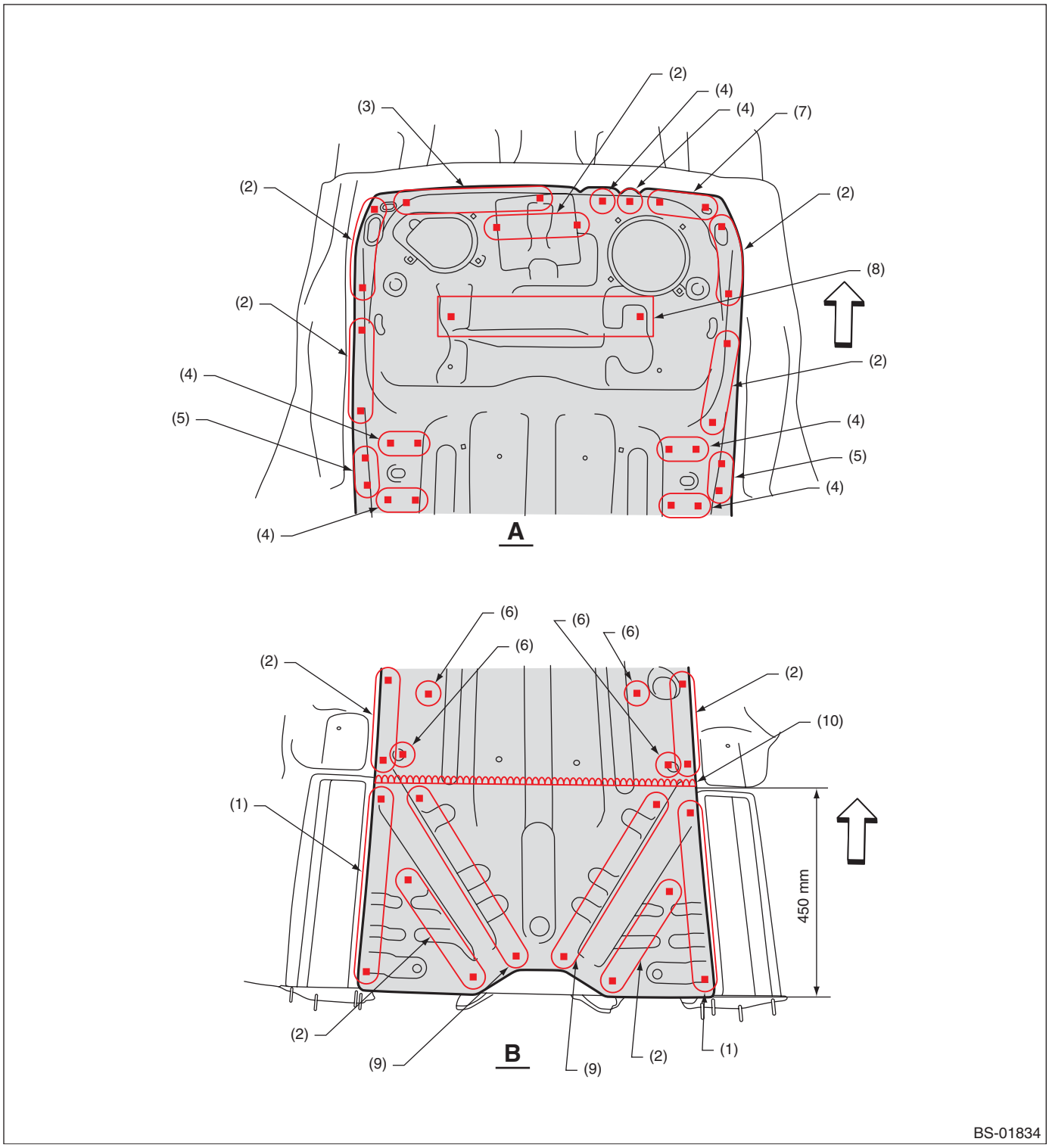
- **Overall view**



(1) 2 points (matching)
(2) 8 points (matching)
(3) 2 points
(4) 10 points (matching)

Rear Floor Pan (total replacement)

- **Views**



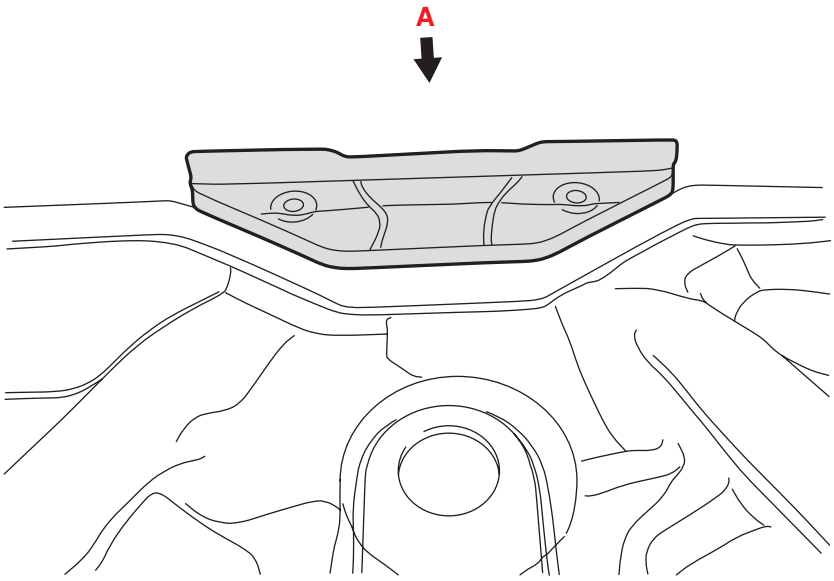
(1) 10 points (service)
(2) 7 points (service)
(3) 12 points (service)
(4) 2 points (service)
(5) 3 points (service)
(6) 1 point (service)
(7) 4 points (service)
(8) 51 points (service)
(9) 6 points (service)
(10) 1 point (800 mm)

27.Rear Extension Bracket (total replacement)

A: REMOVAL

1) Rear skirt outer removed condition

- **Overall view**



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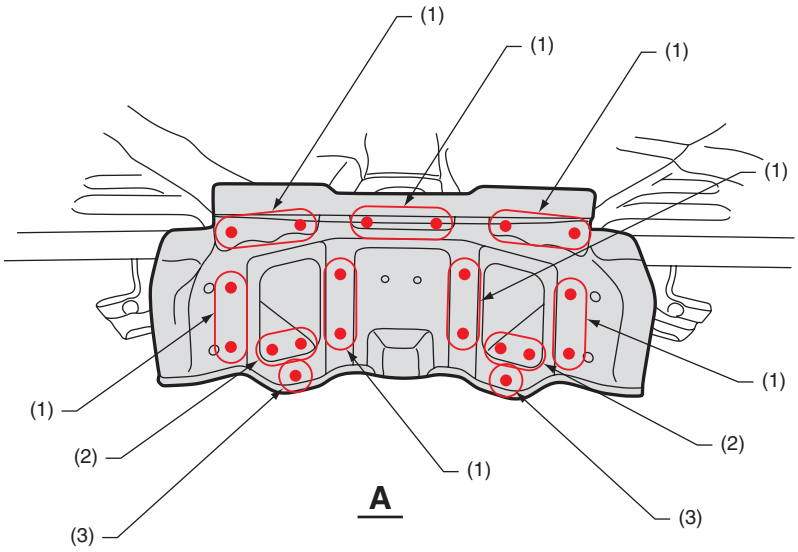
Rear Extension Bracket (total replacement)

- **Views**



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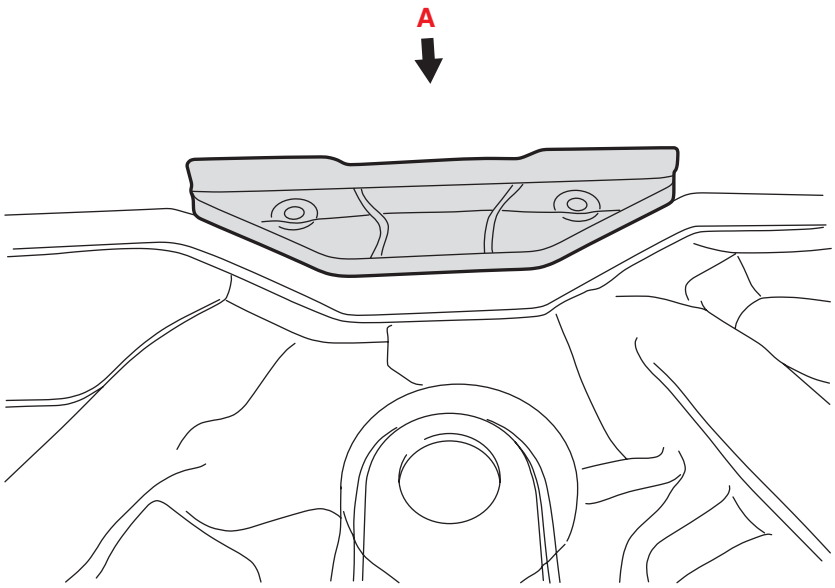
(1) 2 points (outside · 1)

(2) 2 points (bottom · 1)

(3) 1 point (outside · 1)

B: INSTALLATION

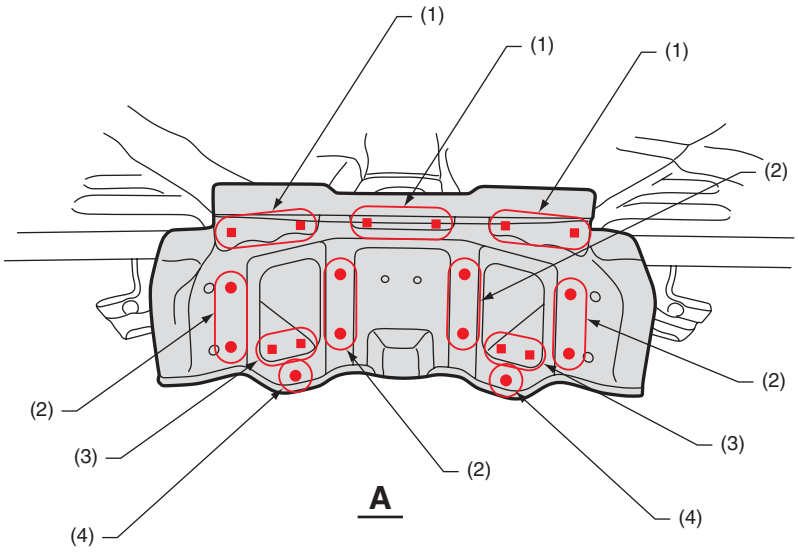
- **Overall view**



BS-01837

Rear Extension Bracket (total replacement)

- **Views**



BS-01838

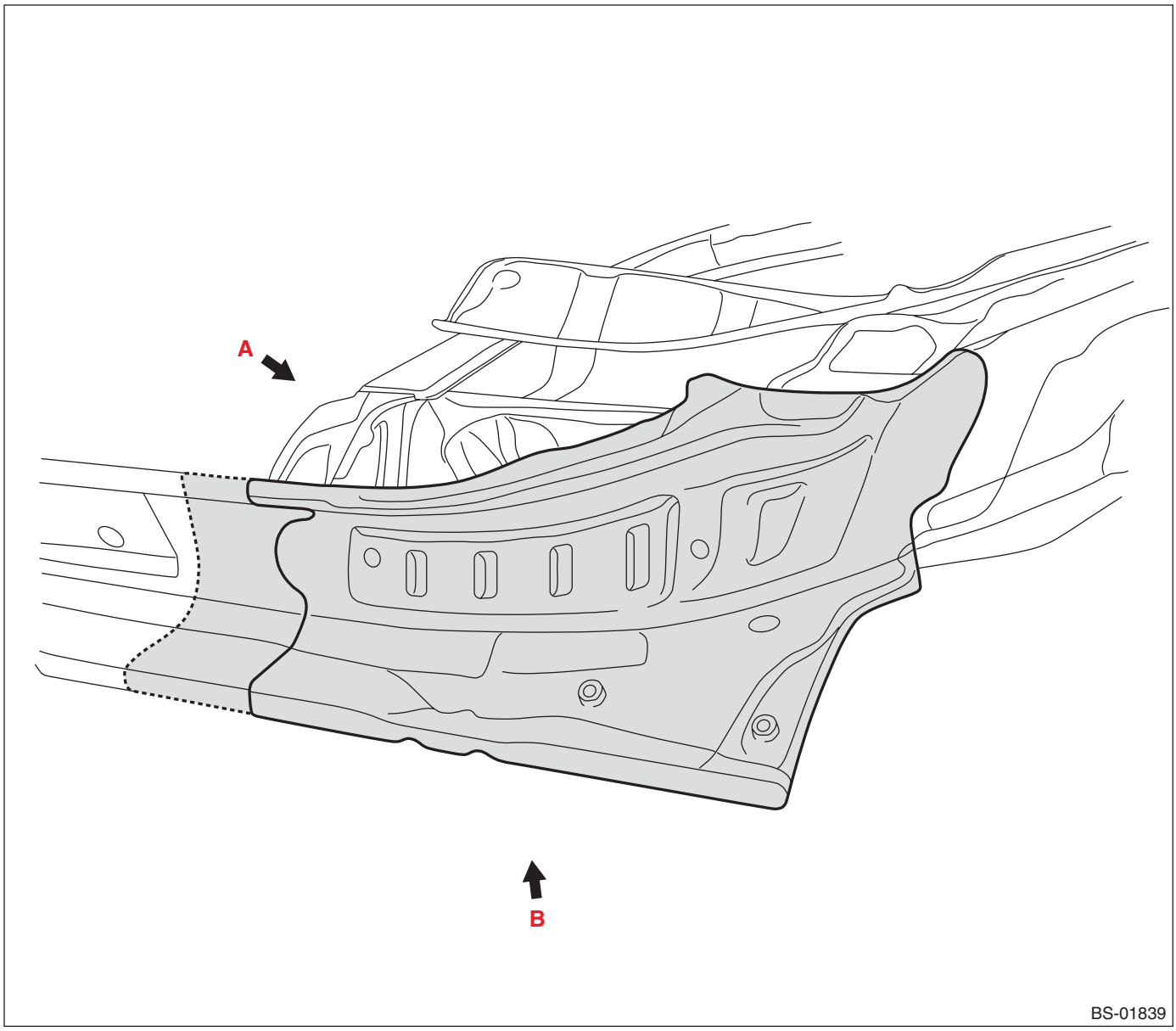
(1) 2 points (service)
(2) 2 points
(3) 2 points
(4) 1 point

28.Side Sill Inner Rear (total replacement)

A: REMOVAL

1) Rear quarter, rear wheel apron, side sill outer removed condition

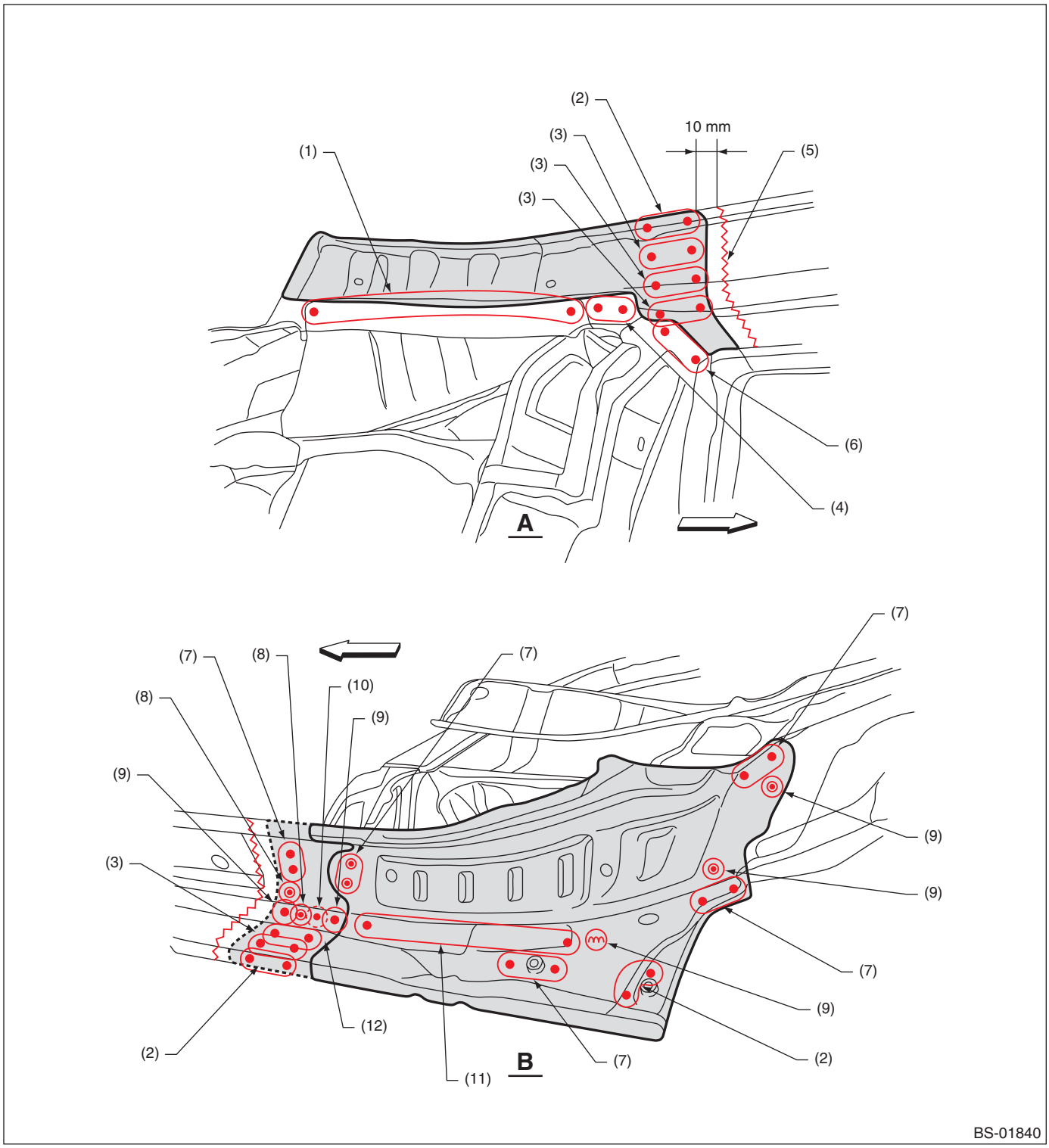
- **Overall view**



- Remove the side sill inner rear to make rear frame removal easier.

Side Sill Inner Rear (total replacement)

- **Views**

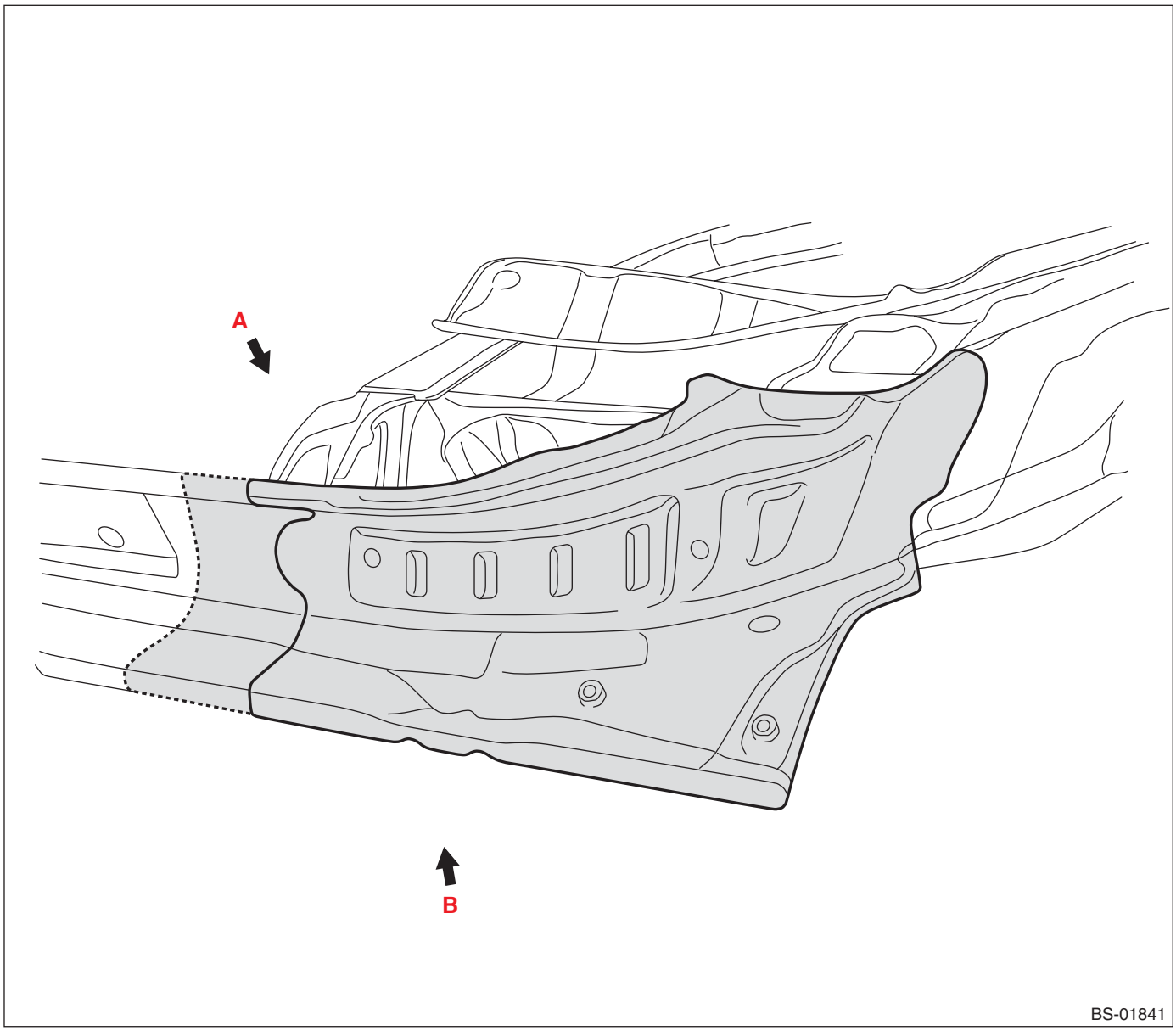


(1)	9 points (top · 1)	(6)	2 points (inside · 1)	(11)	5 points (outside · 1)
(2)	3 points (outside · 1)	(7)	2 points (outside · 1)	(12)	3 points (bottom · 1)
(3)	3 points (top · 1)	(8)	1 point (outside · 2)		
(4)	2 points (top · 1)	(9)	1 point (outside · 1)		
(5)	Cut (290 mm) to make removal easier	(10)	1 point (outside · 1), hidden hit point		

- View B: To facilitate removal, cut the side sill inner (reuse) and disconnect one hidden point.

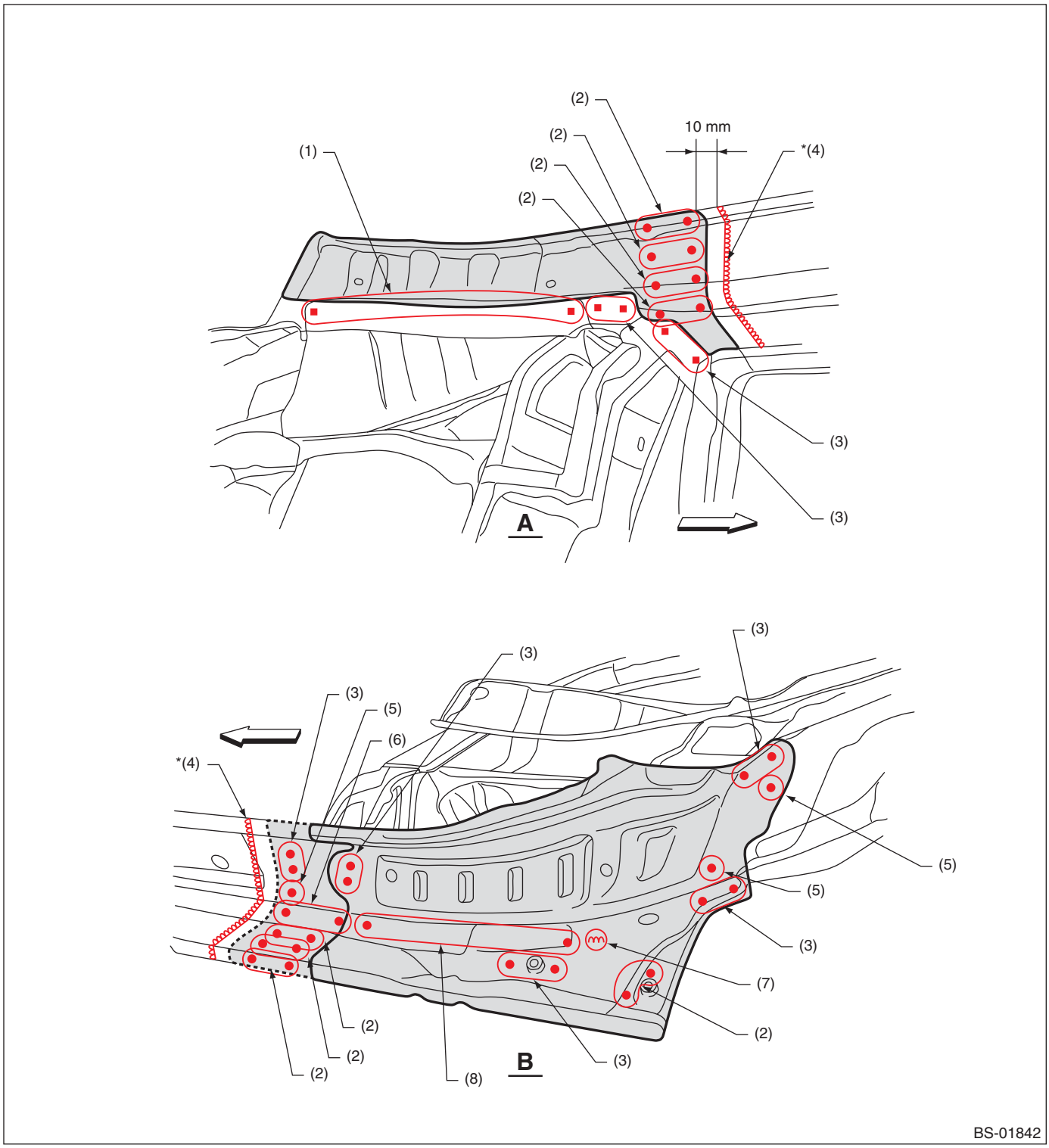
B: INSTALLATION

- **Overall view**



Side Sill Inner Rear (total replacement)

- **Views**



(1) 9 points
(2) 3 points
(3) 2 points
(4) 1 point (320 mm)
(5) 1 point
(6) 4 points
(7) 1 point (15 mm)
(8) 5 point

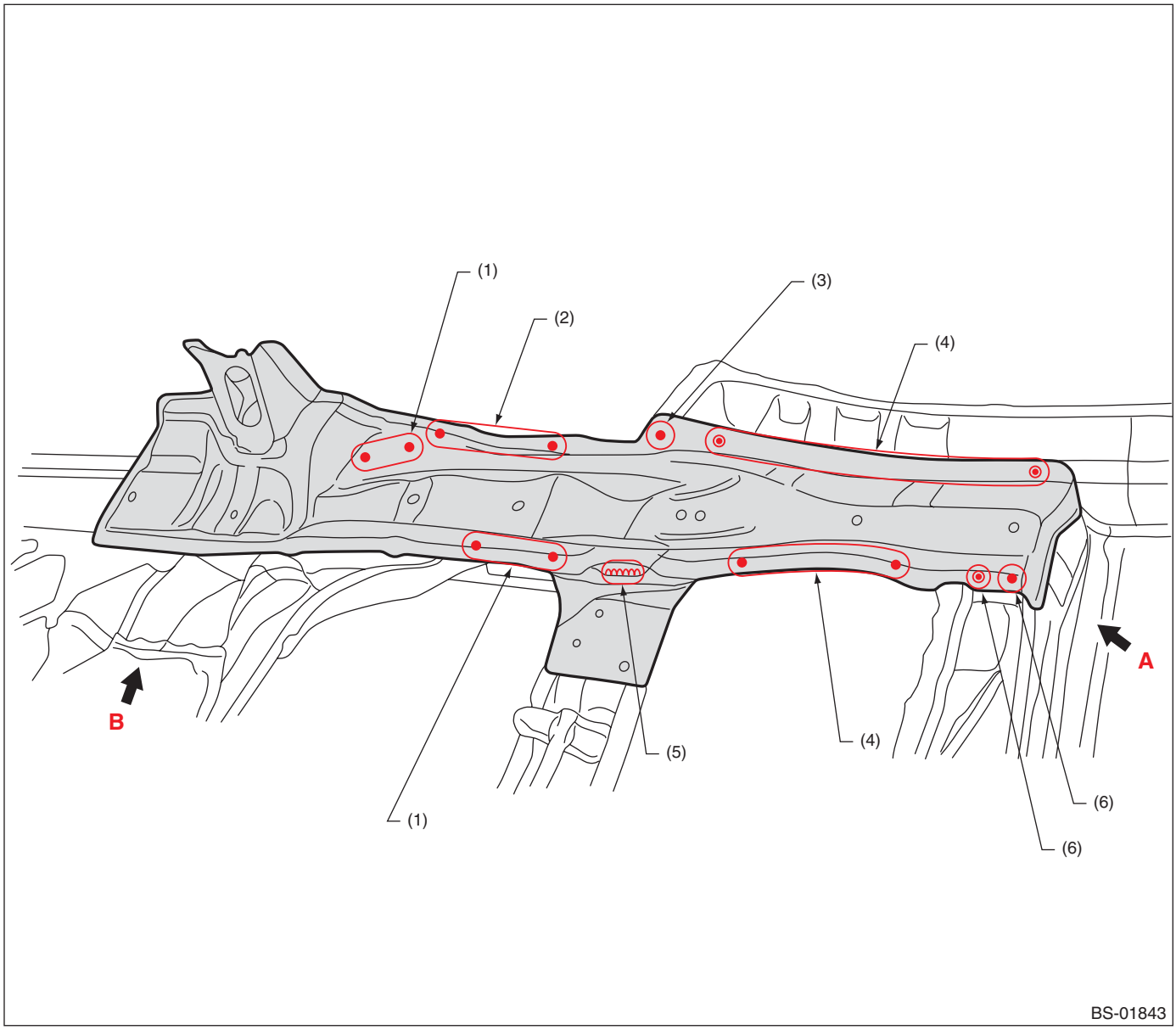
- After installing the side sill inner rear, perform butt welding for the side sill inner.

For continuous welds marked by *, apply anticorrosion wax thoroughly on the reverse side.

29.Rear Closing Plate Front (total replacement)

A: REMOVAL

- **Overall view**

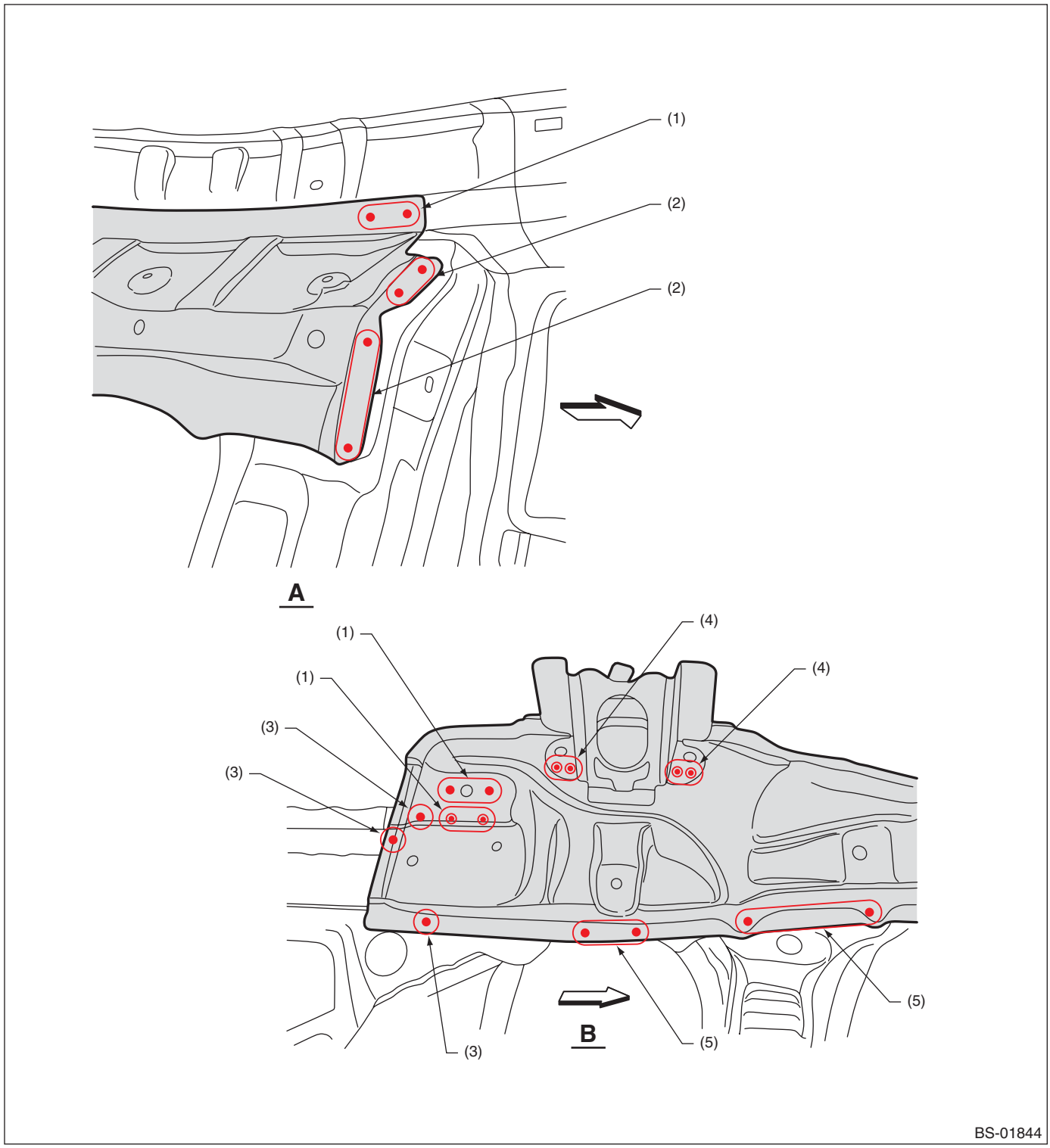


(1)	3 points (top · 1)	(3)	1 point (inside · 1)	(5)	1 point (top · 1, belt sander)
(2)	4 points (inside · 1)	(4)	5 points (top · 1)	(6)	1 point (top · 1)

NOTE:
Remove the closing plate to facilitate the rear frame removal.

Rear Closing Plate Front (total replacement)

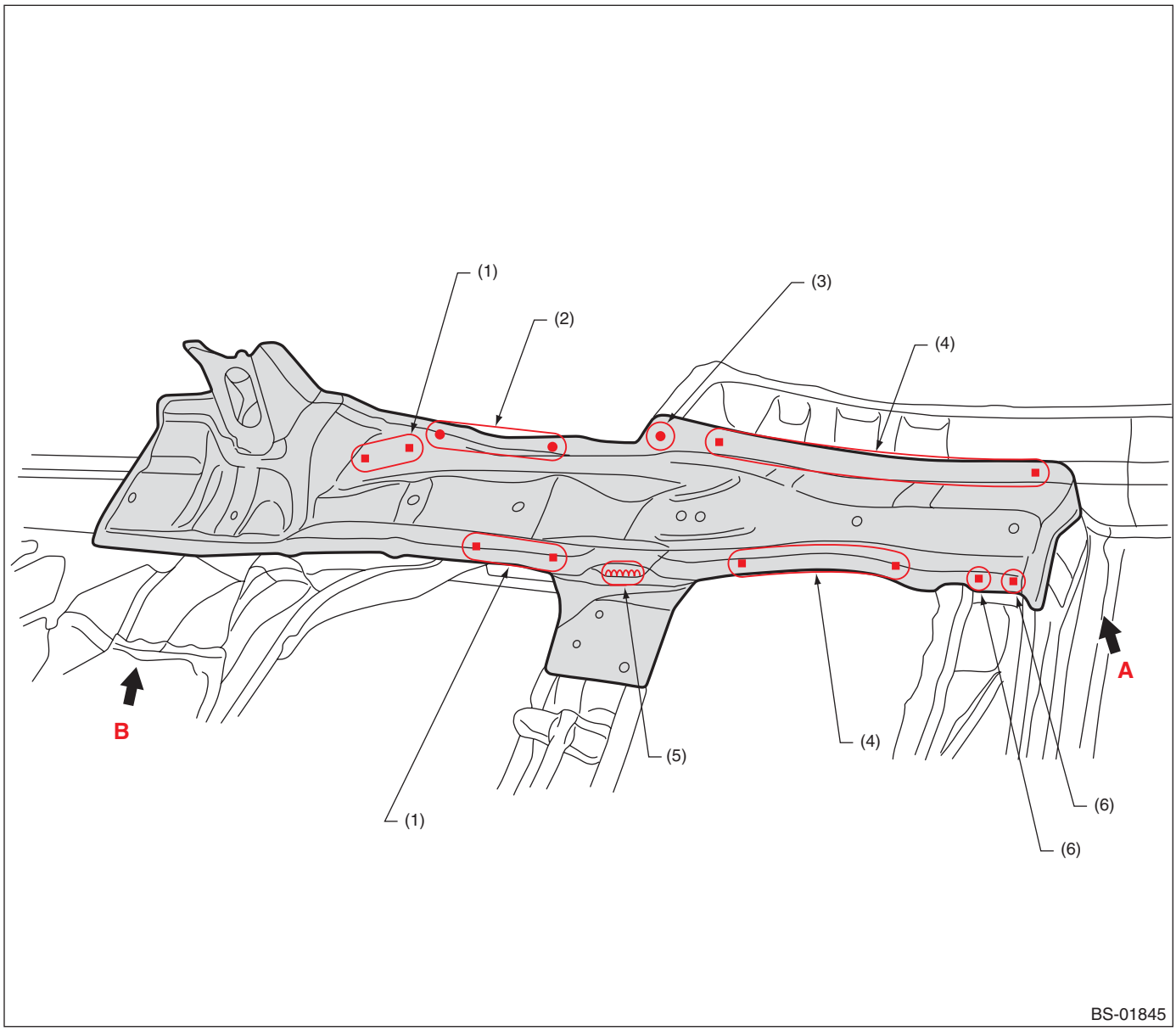
- **Views**



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

B: INSTALLATION

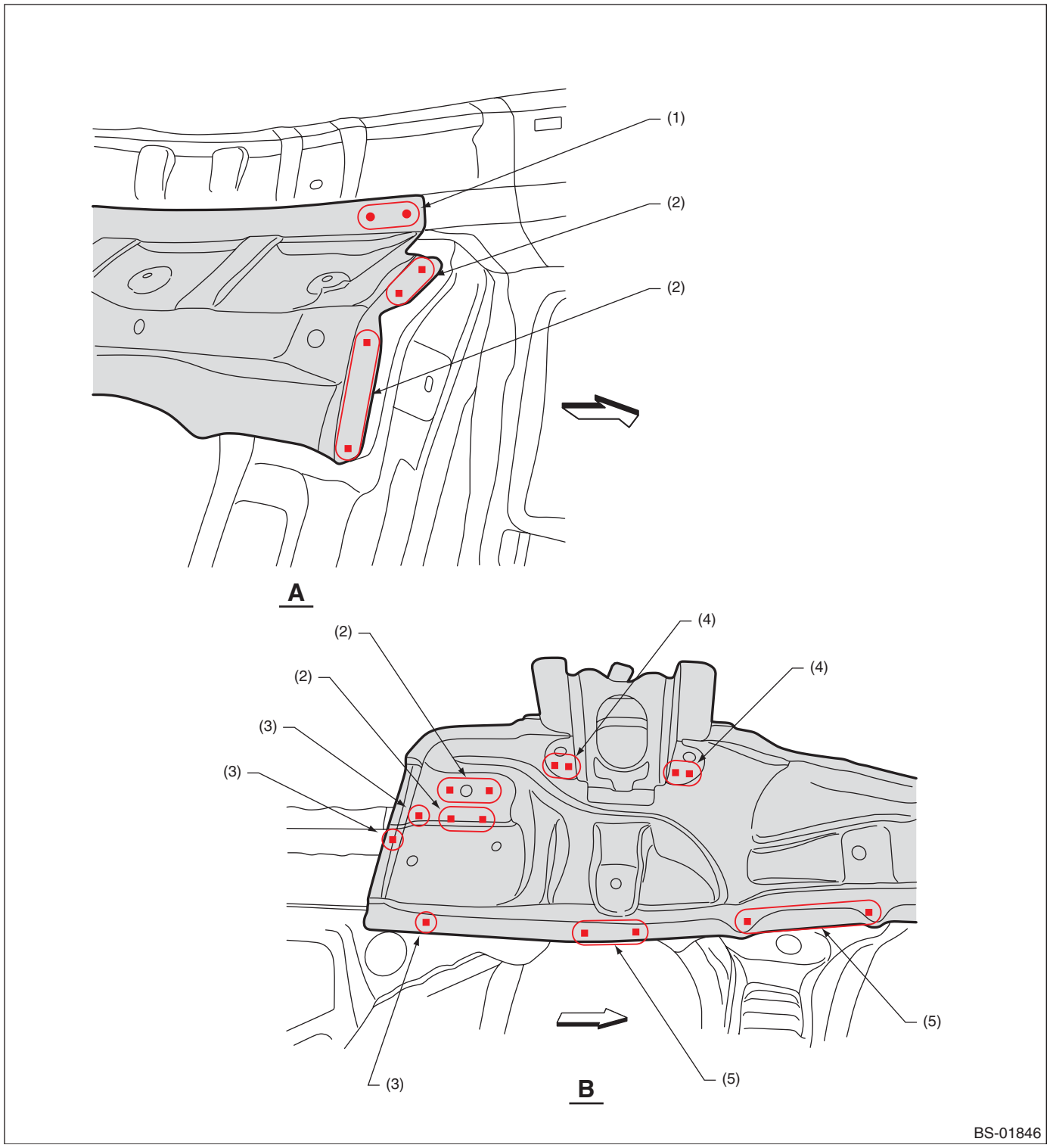
- **Overall view**



(1)	3 points (service)	(3)	1 point	(5)	1 point (30 mm)
(2)	4 points	(4)	5 points (service)	(6)	1 point (service)

Rear Closing Plate Front (total replacement)

- **Views**

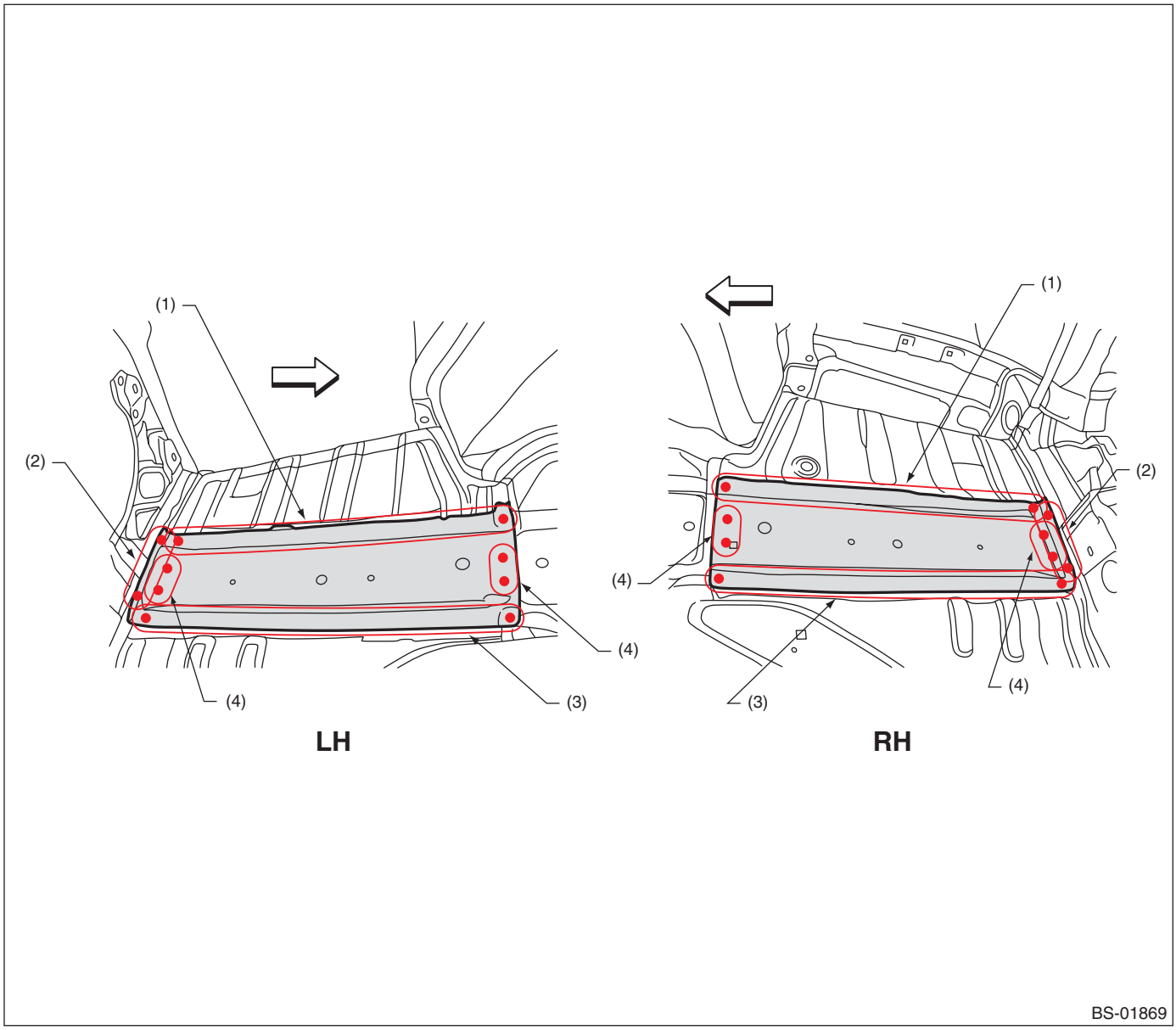


(1) 2 points
(2) 2 points (service)
(3) 1 point (service)
(4) 2 points (service · matching)
(5) 3 points (service)

30.Rear Closing Plate Rear (total replacement)

A: REMOVAL

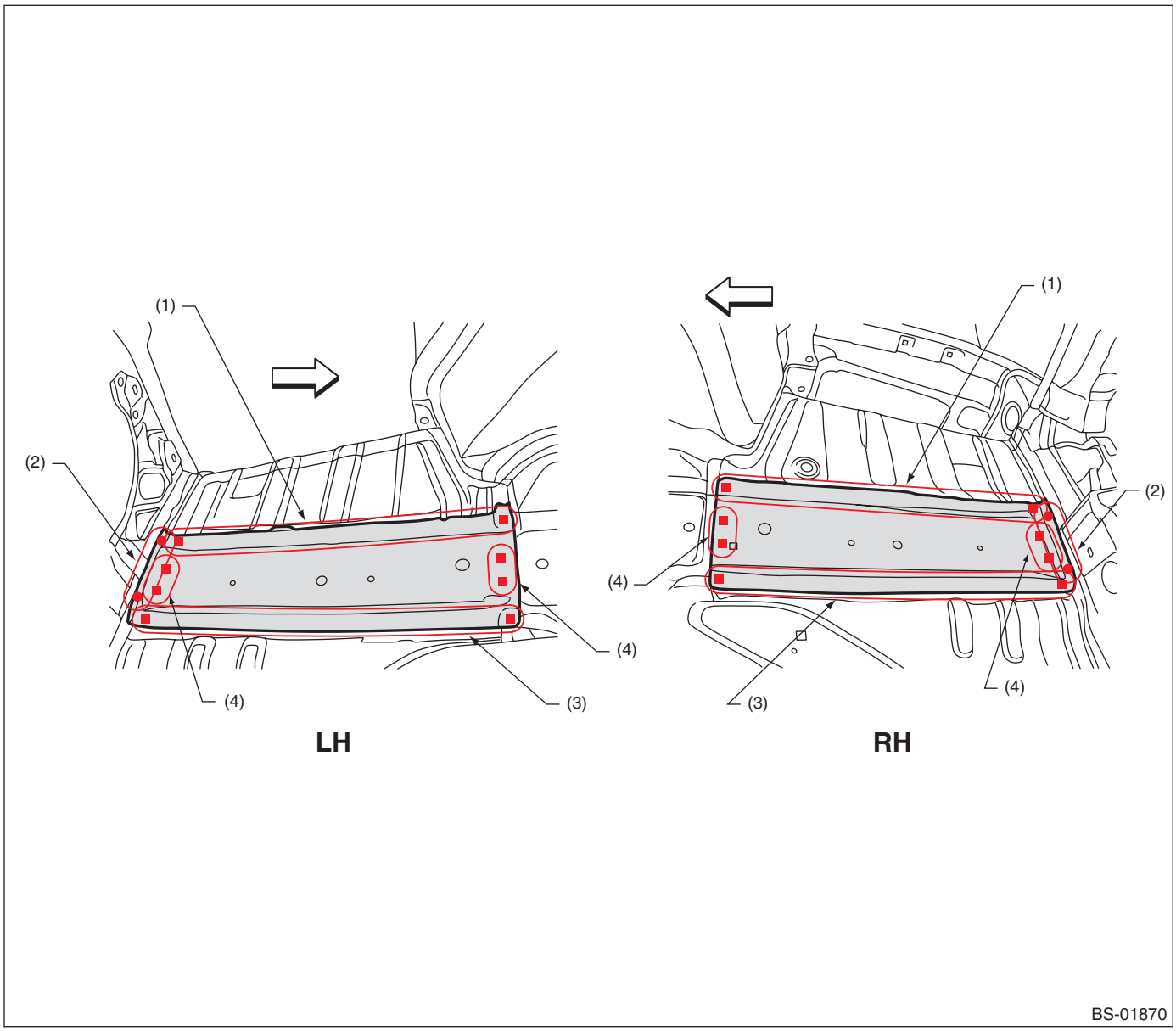
- **Overall view**



(1) 11 points (top · 1)
(2) 4 points (inside · 1)
(3) 10 points (top · 1)
(4) 2 points (top · 1)

B: INSTALLATION

- **Overall view**



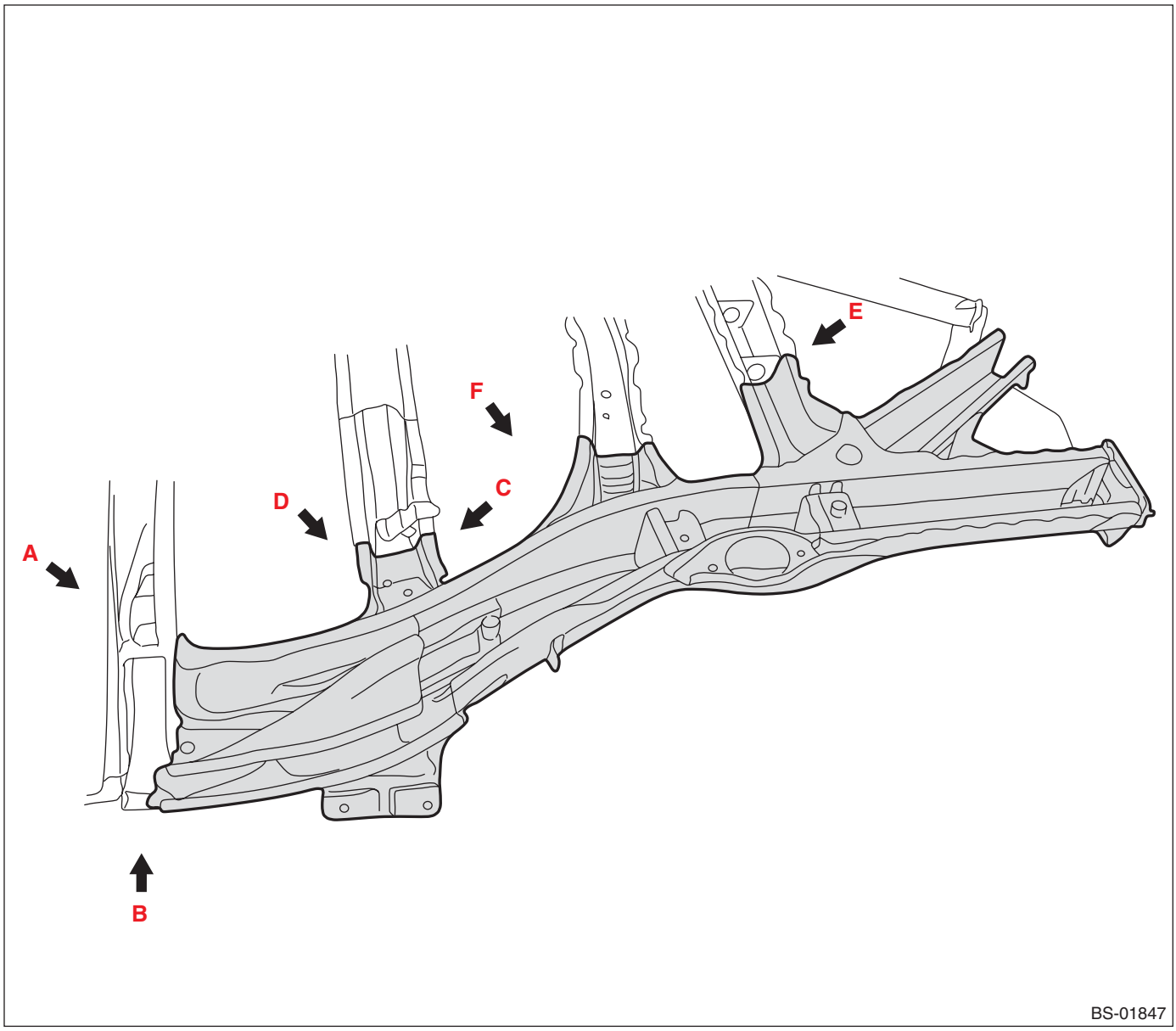
(1) 11 points (service)
(2) 4 points
(3) 10 points (service)
(4) 2 points (service)

31.Rear Frame (total replacement)

A: REMOVAL

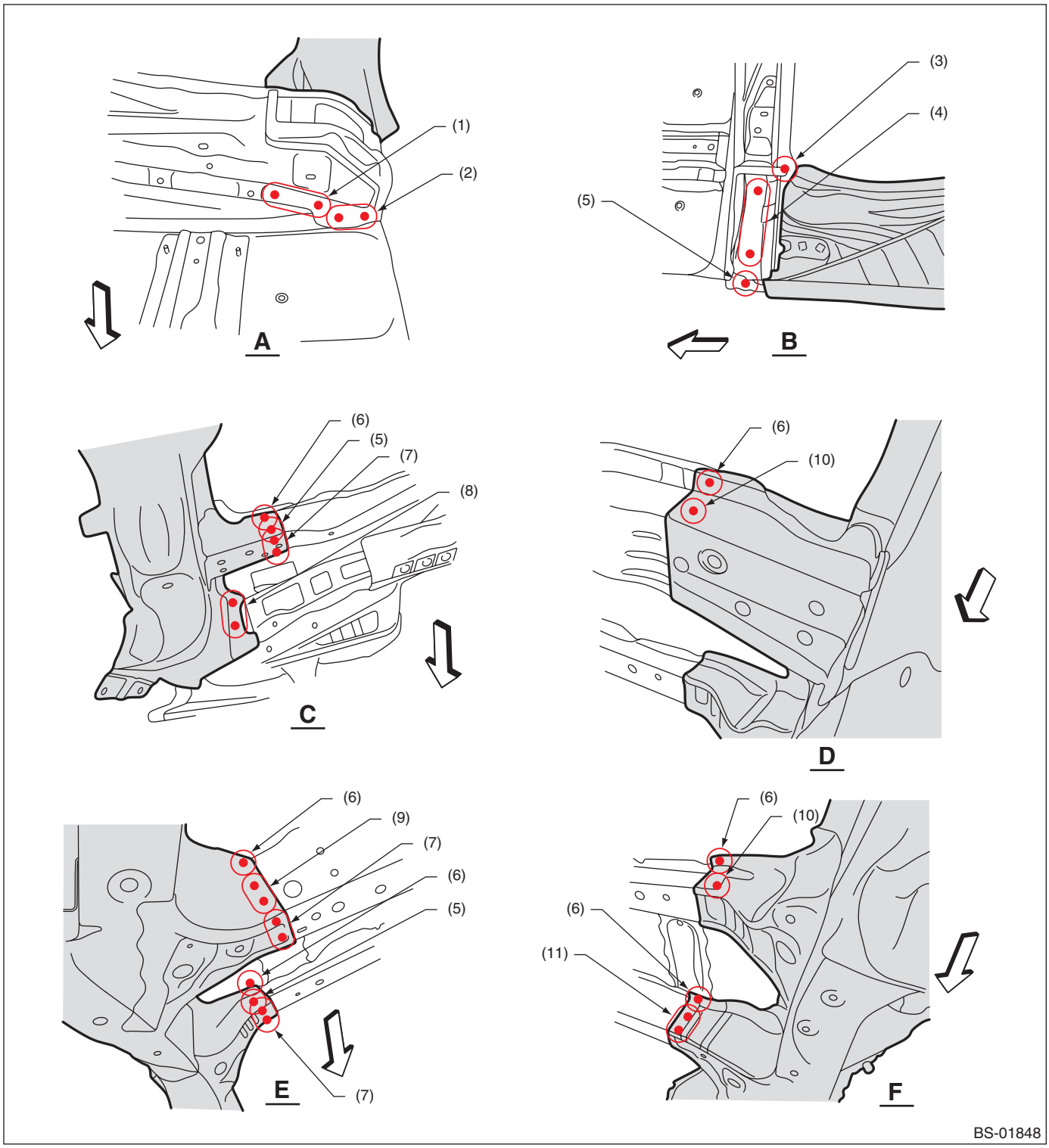
1) Rear quarter, D-pillar, closing plate, rear wheel apron, rear floor pan, rear skirt removed condition

- **Overall view**



Rear Frame (total replacement)

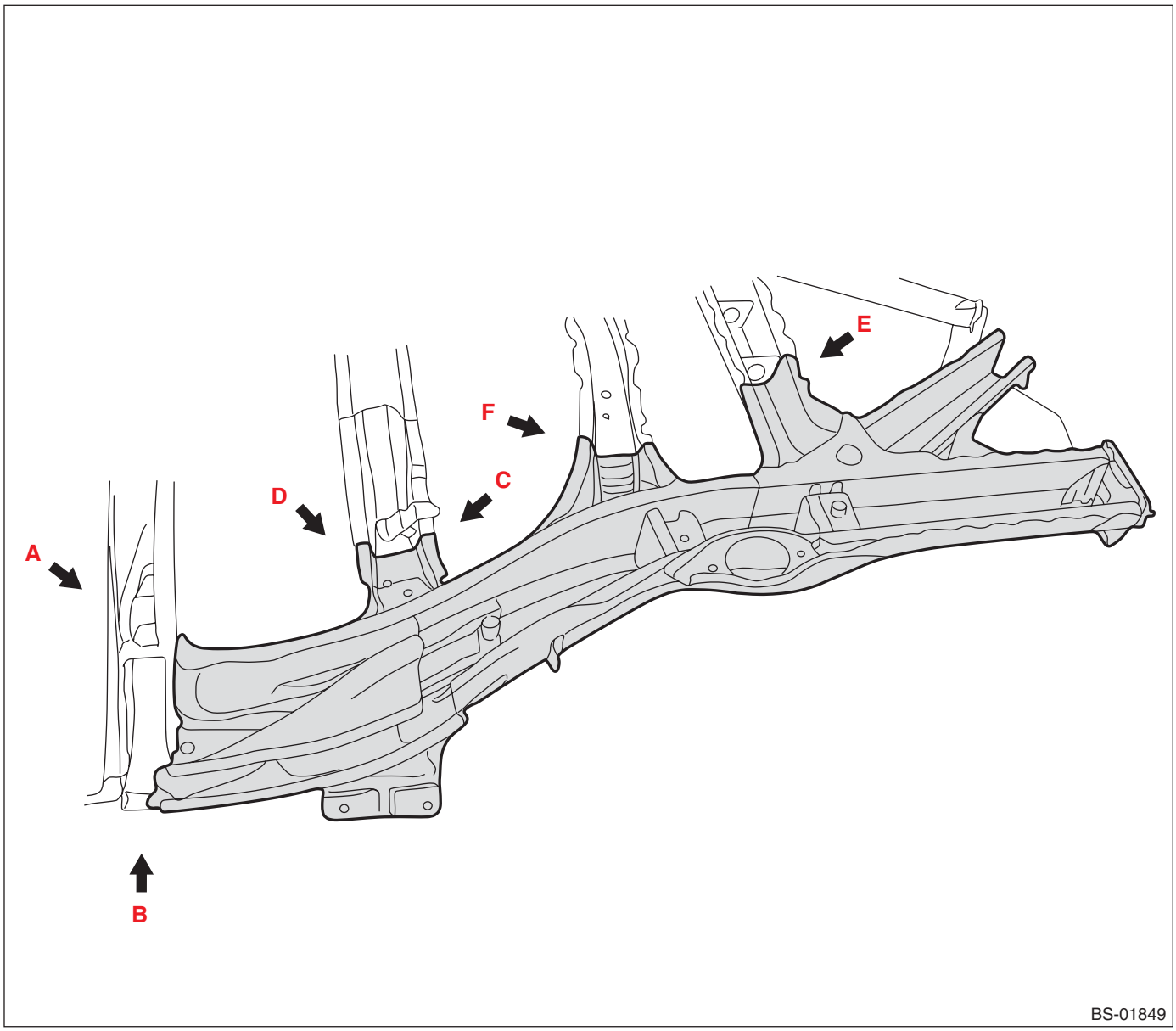
- **Views**



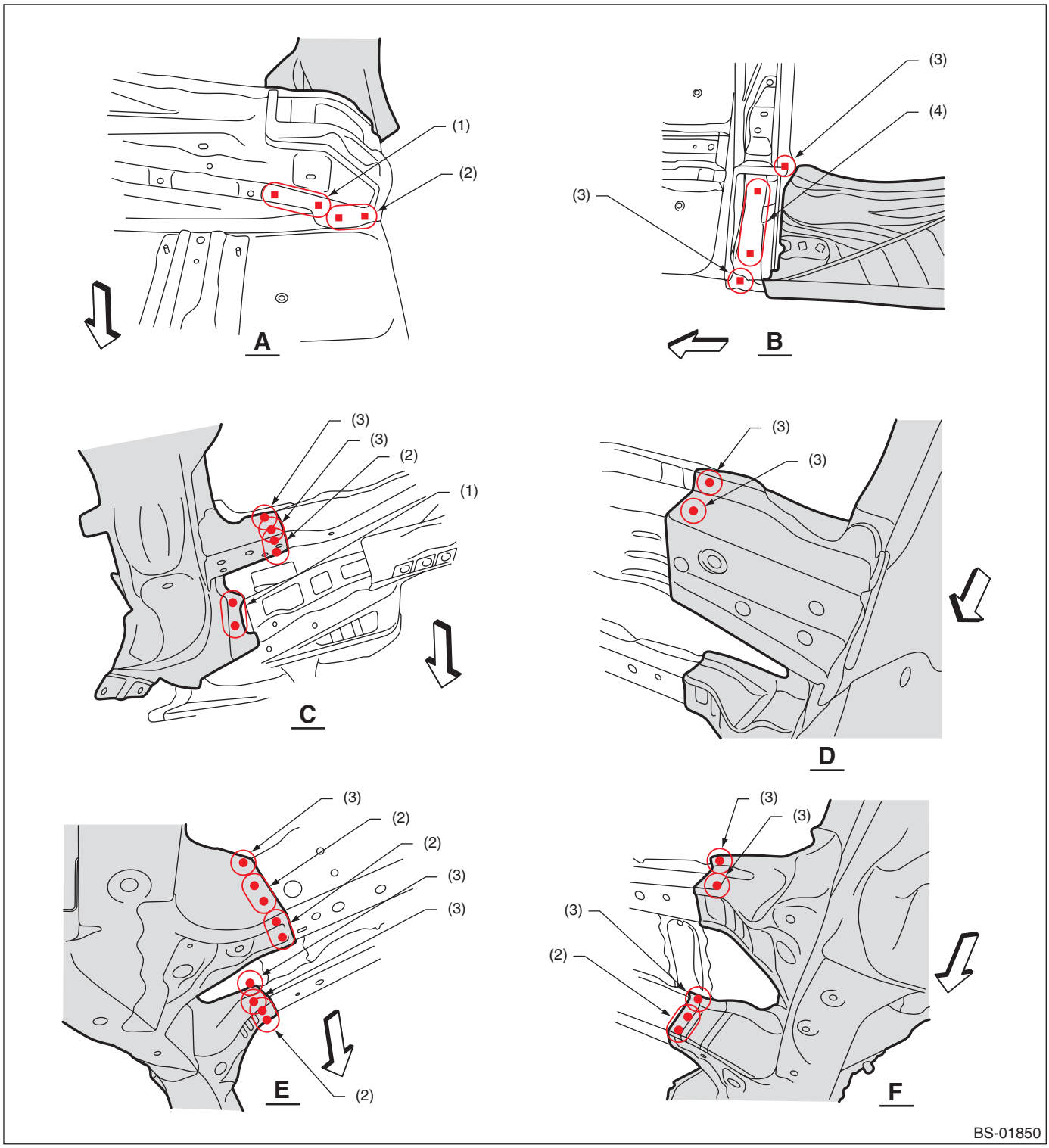
(1) 3 points (inside · 1)
(2) 2 points (top · 1)
(3) 1 point (top · 1)
(4) 4 points (top · 1)
(5) 1 point (outside · 1)
(6) 1 point (bottom · 1)
(7) 2 points (bottom · 1)
(8) 3 points (outside · 1)
(9) 2 points (outside · 1)
(10) 1 point (inside · 1)
(11) 2 points (inside · 1)

B: INSTALLATION

- **Overall view**



- **Views**



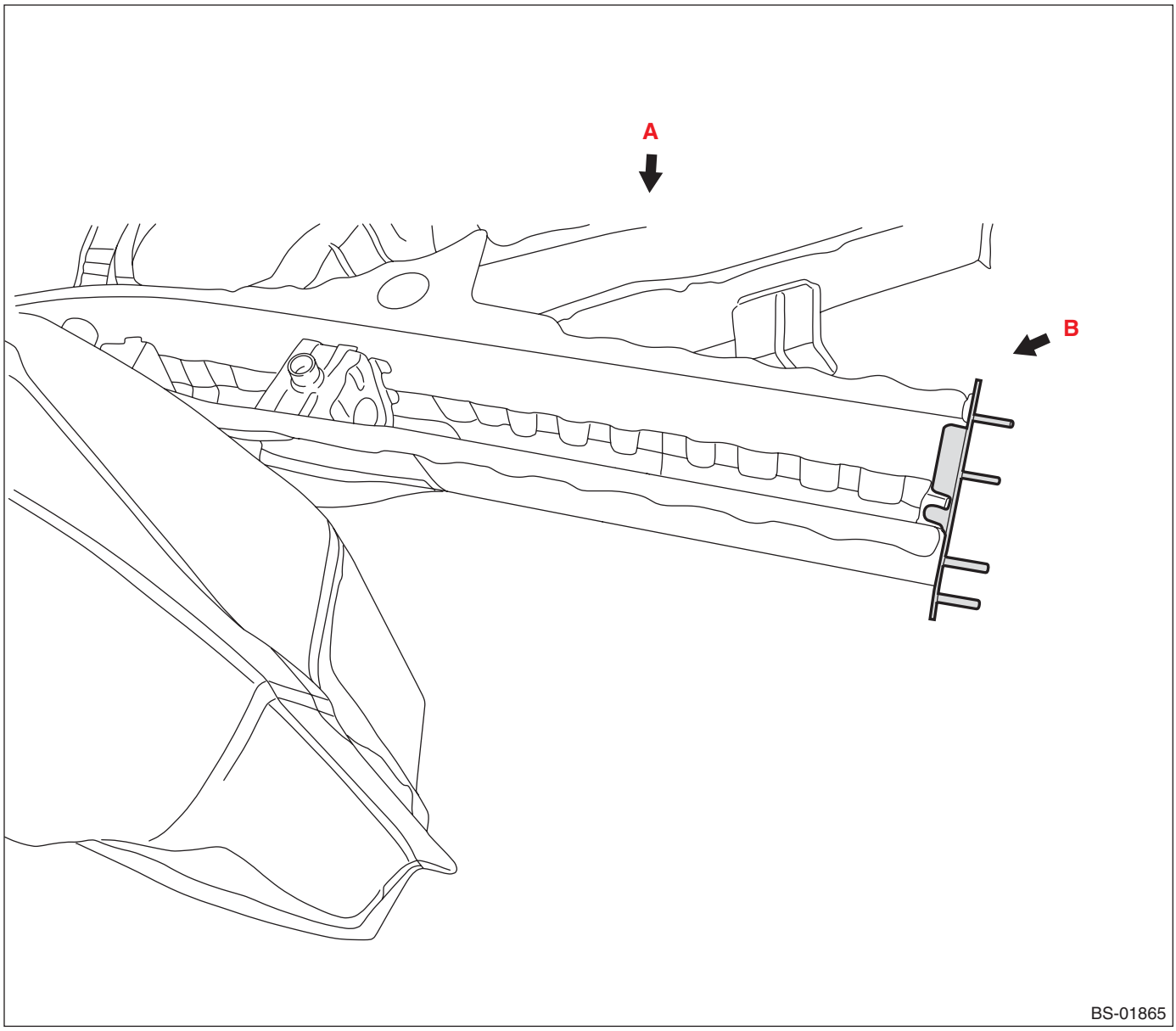
(1) 3 points
(2) 2 points
(3) 1 point
(4) 4 points

32.Rear Bumper Bracket (total replacement)

A: REMOVAL

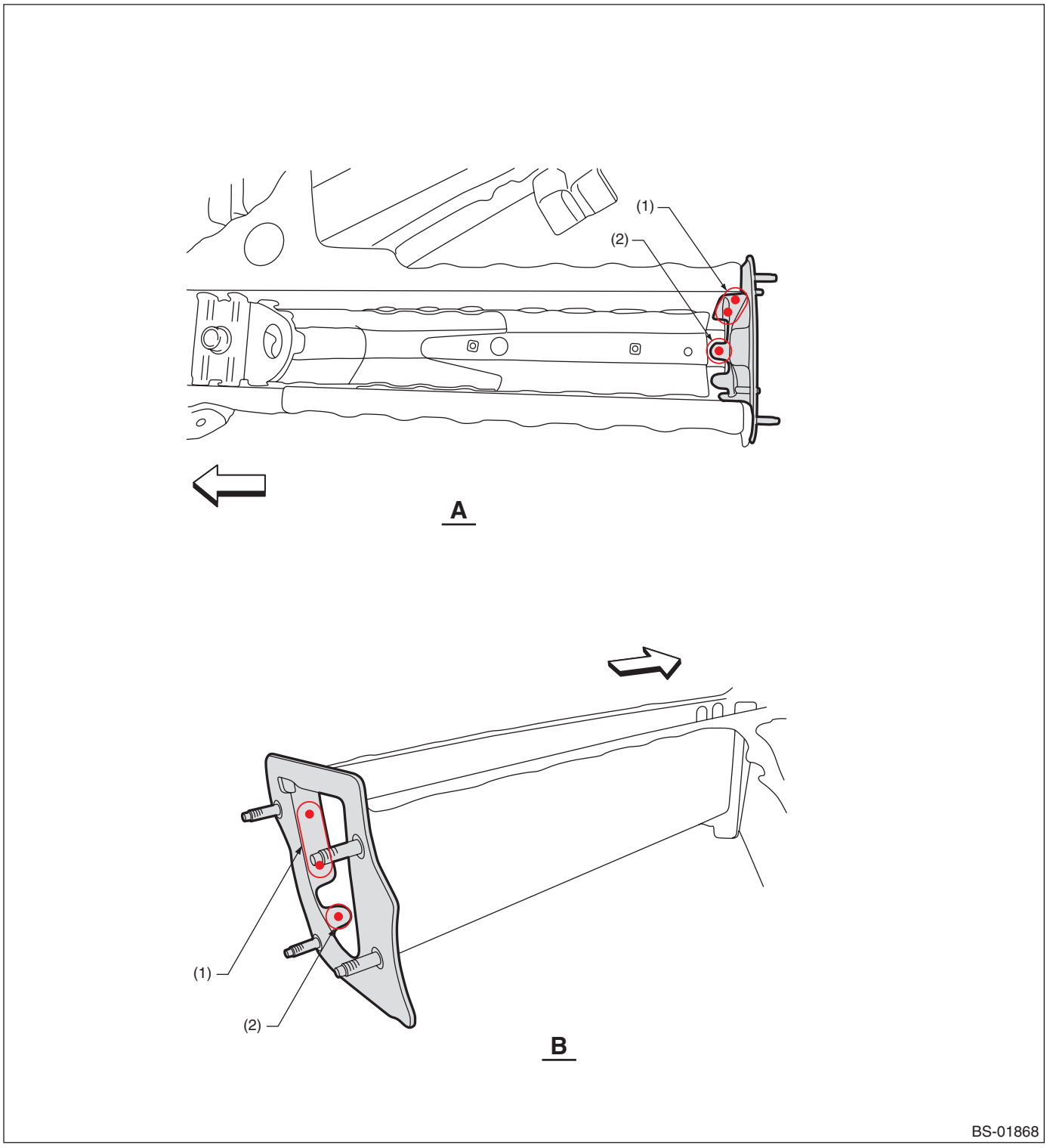
1) Rear skirt outer and closing plate removal condition

- **Overall view**



Rear Bumper Bracket (total replacement)

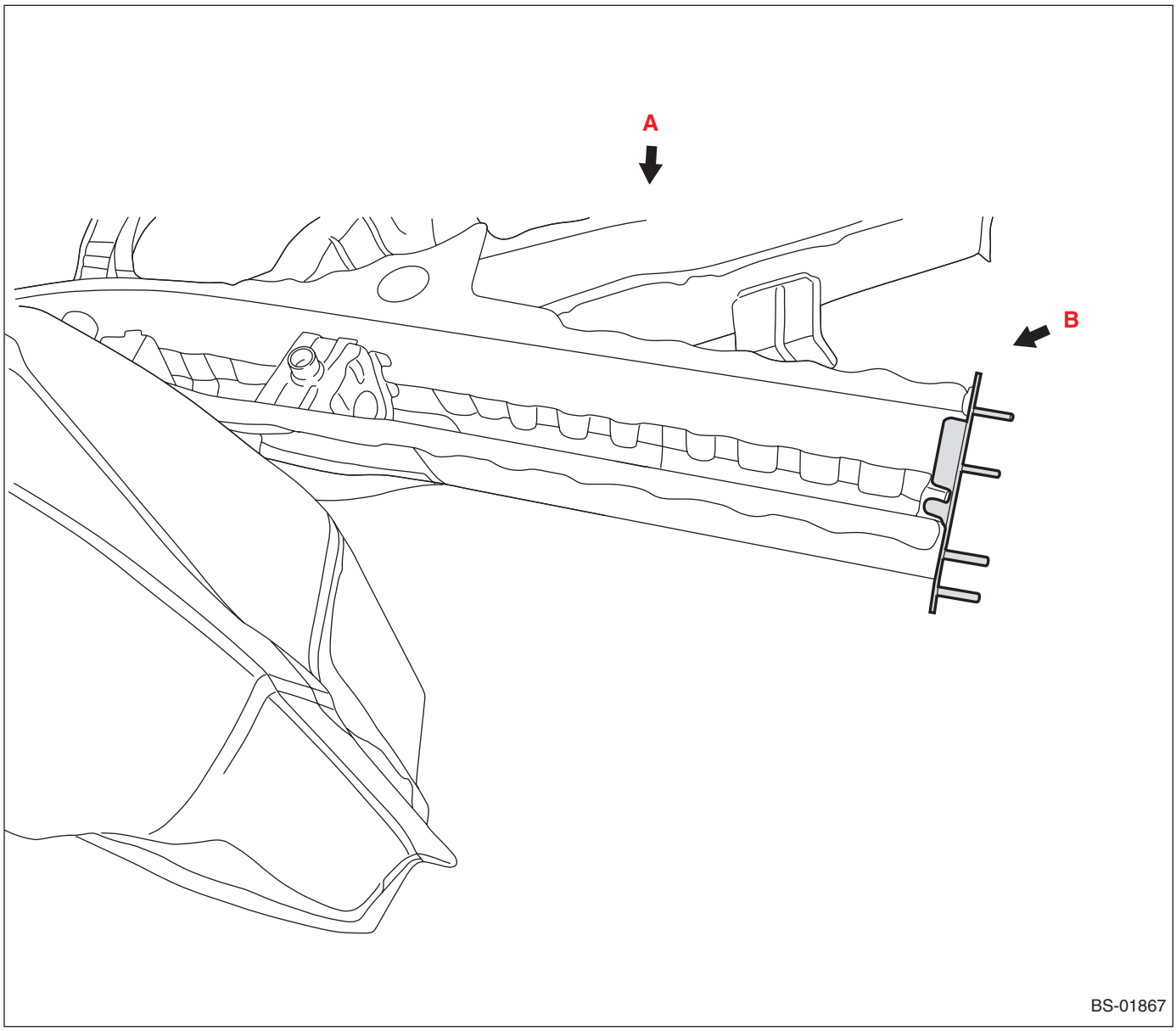
- **Views**



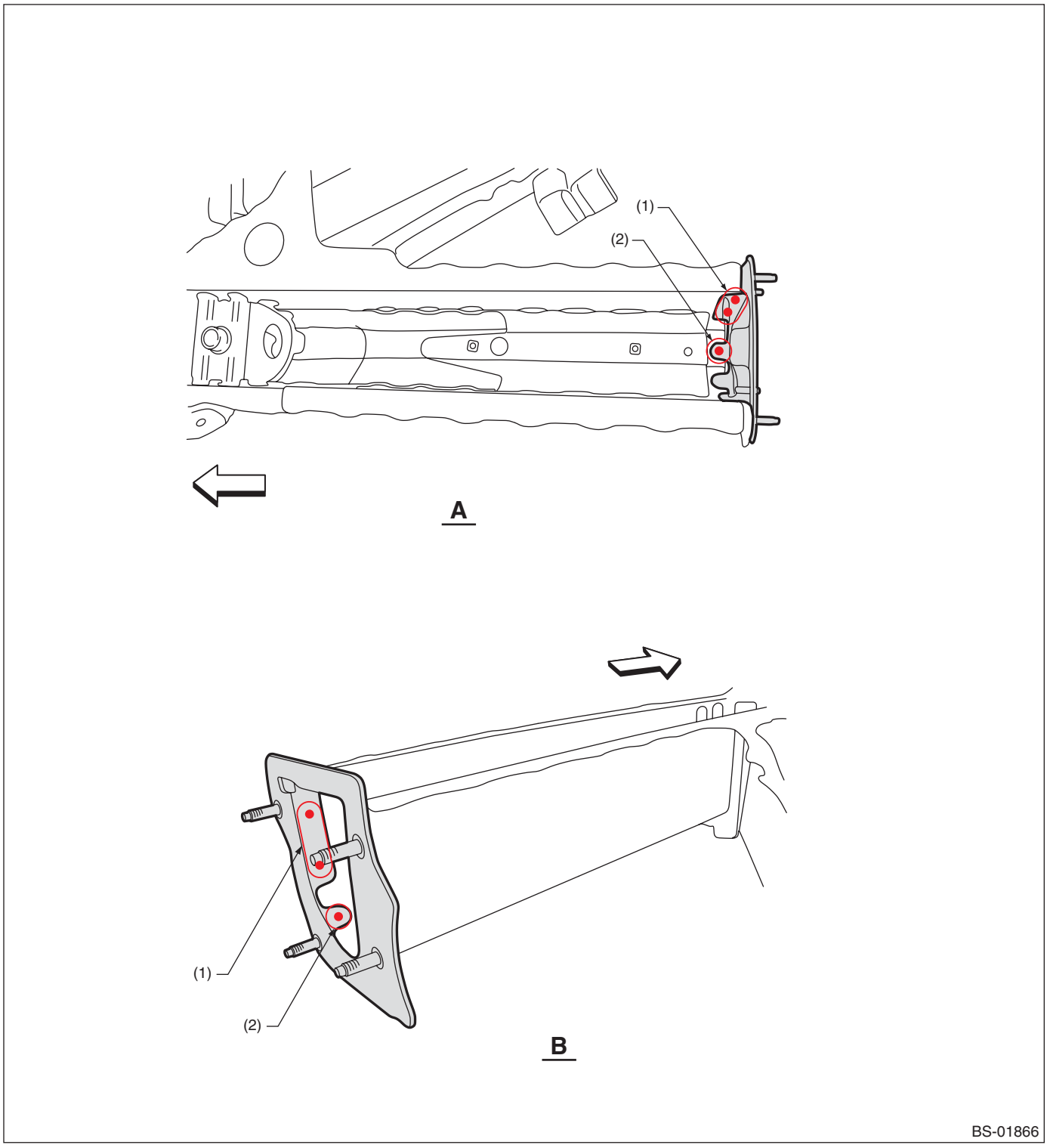
(1) 2 points (inside · 1, belt sander) (2) 1 point (inside · 1, belt sander)

B: INSTALLATION

- **Overall view**



- **Views**



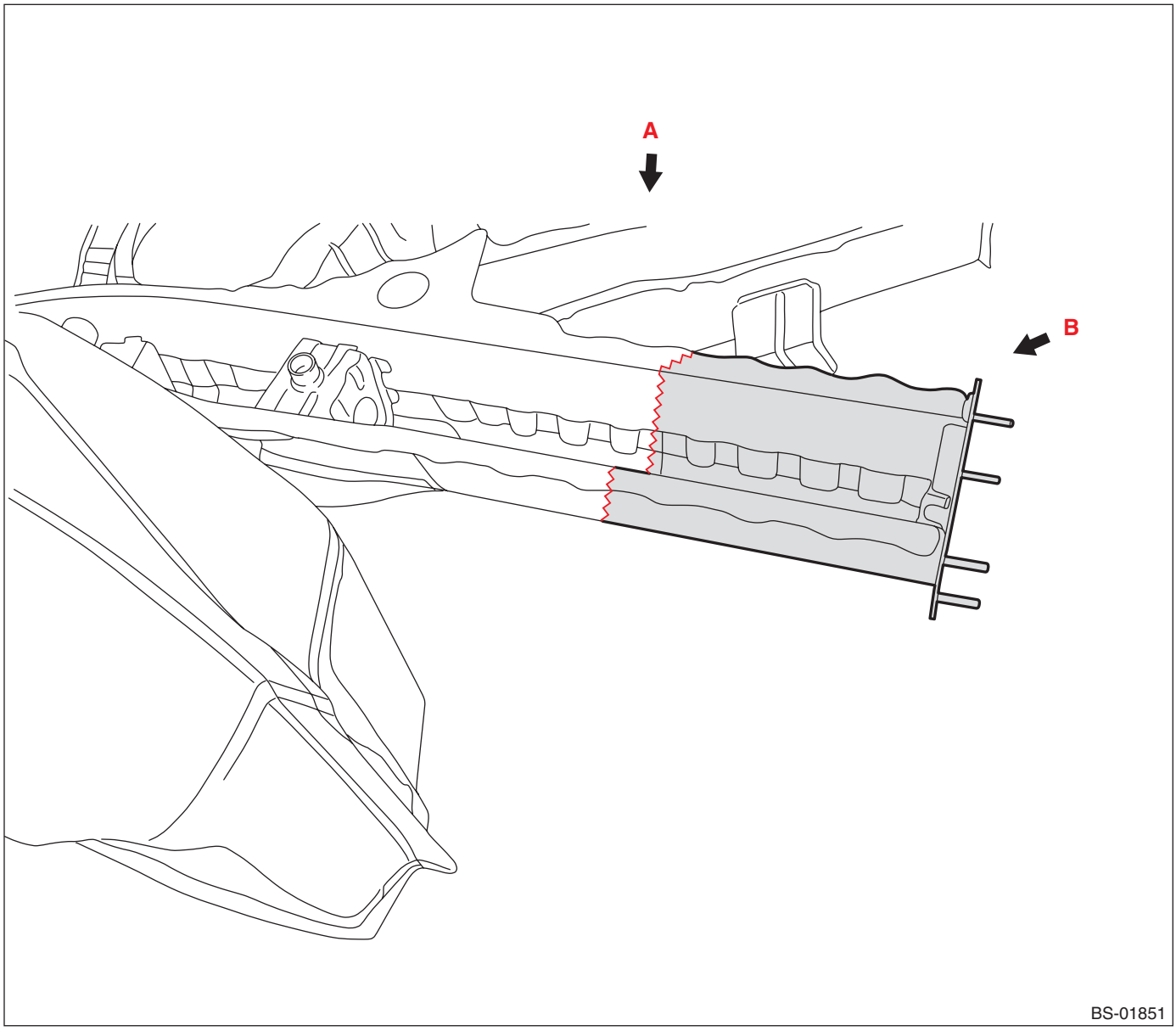
(1) 2 points

(2) 1 point

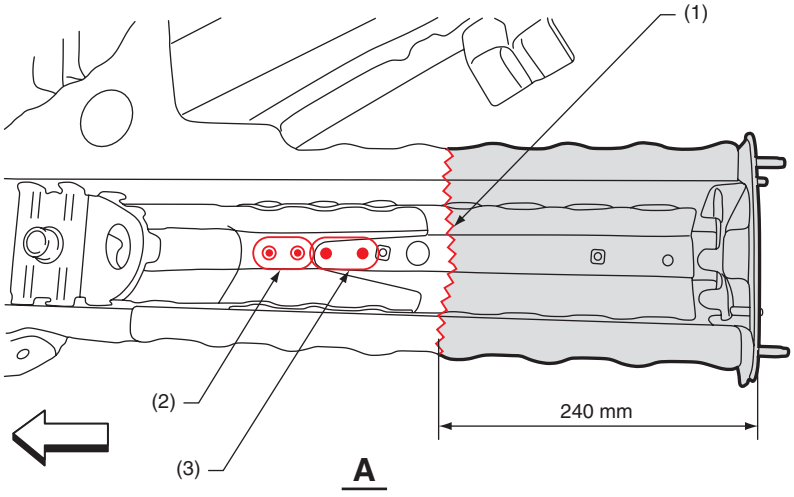
33.Rear Side Frame Rear (partial replacement)

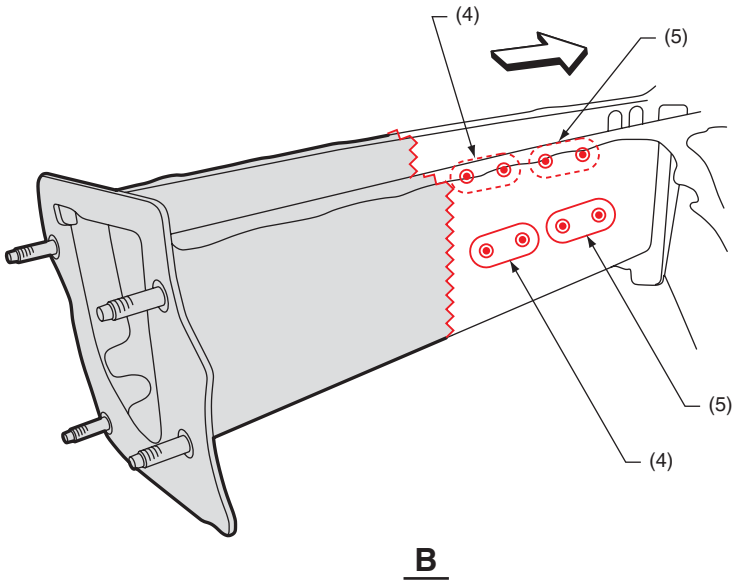
A: REMOVAL

- **Overall view**



- **Views**





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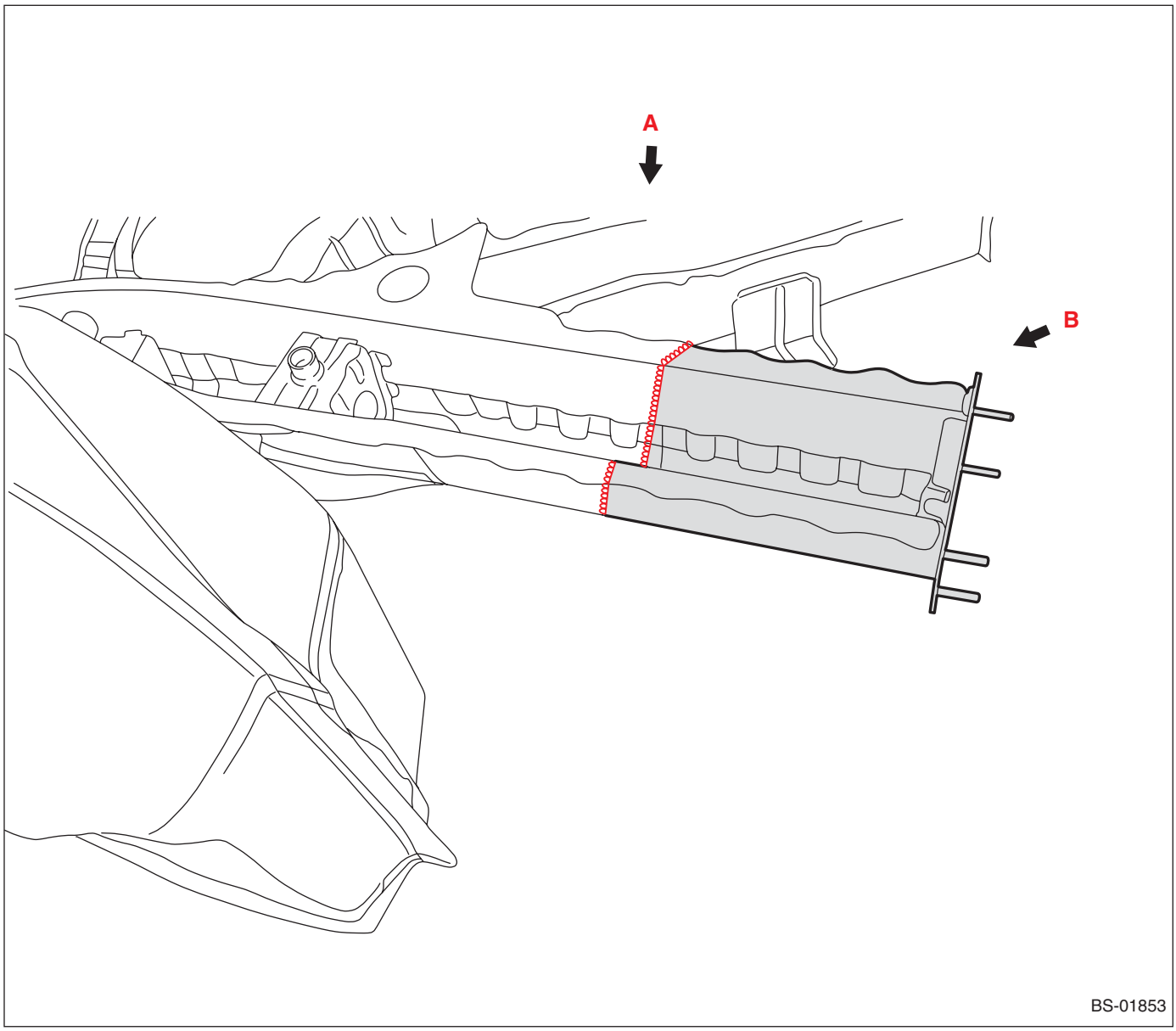
(1) 1 point, rough cutting (330 mm)
(2) 2 points (top · 2)
(3) 2 points (top · 1)
(4) 2 points (outside · 1)
(5) 2 points (inside · 2, belt sander)

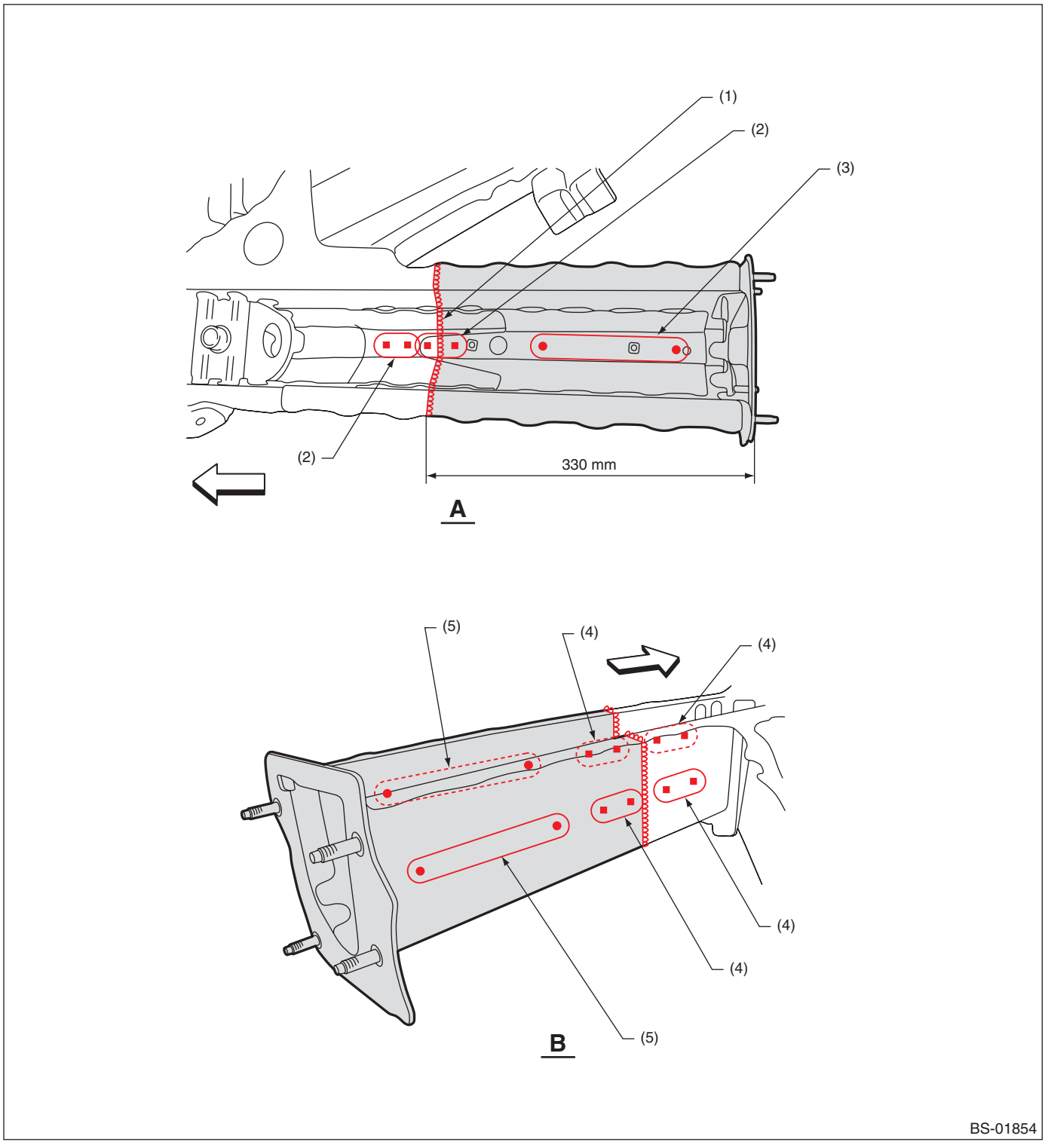
- Remove the doubler frame rear.

B: INSTALLATION

- **Overall view**



- **Views**

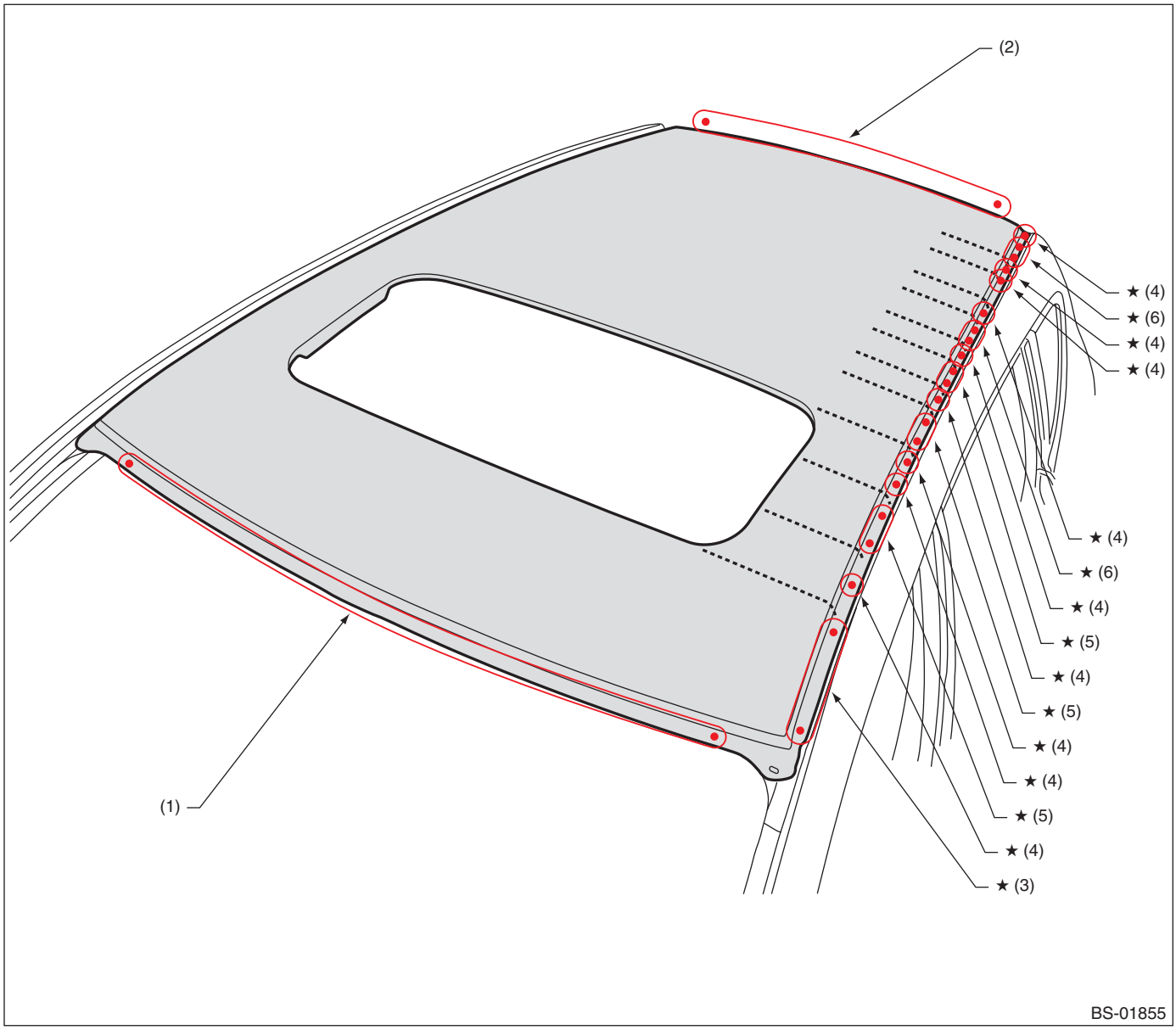


(1) 1 point (330 mm)
(2) 2 points
(3) 4 points
(4) 2 points
(5) 5 points

34.Roof Panel (total replacement)

A: REMOVAL

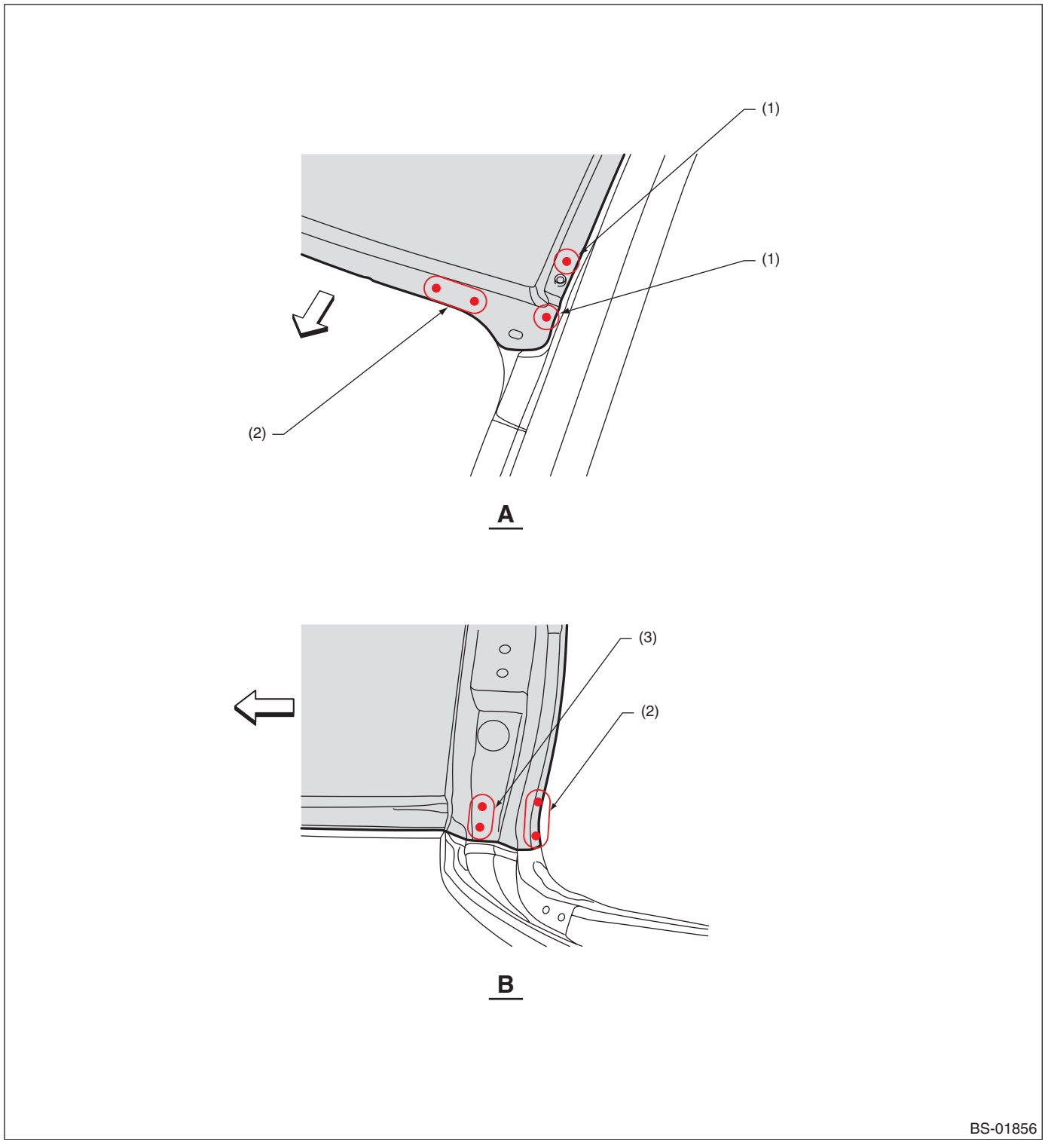
- **Overall view**



(1)	19 points (top · 1)	(3)	4 points (top · 1)	(5)	3 points (top · 1)
(2)	24 points (top · 1)	(4)	1 point (top · 1)	(6)	2 points (top · 1)

For locations marked by H, the welding method, the number of welding points, and the rough cutting dimensions are the same on the left and the right.

- **Views**

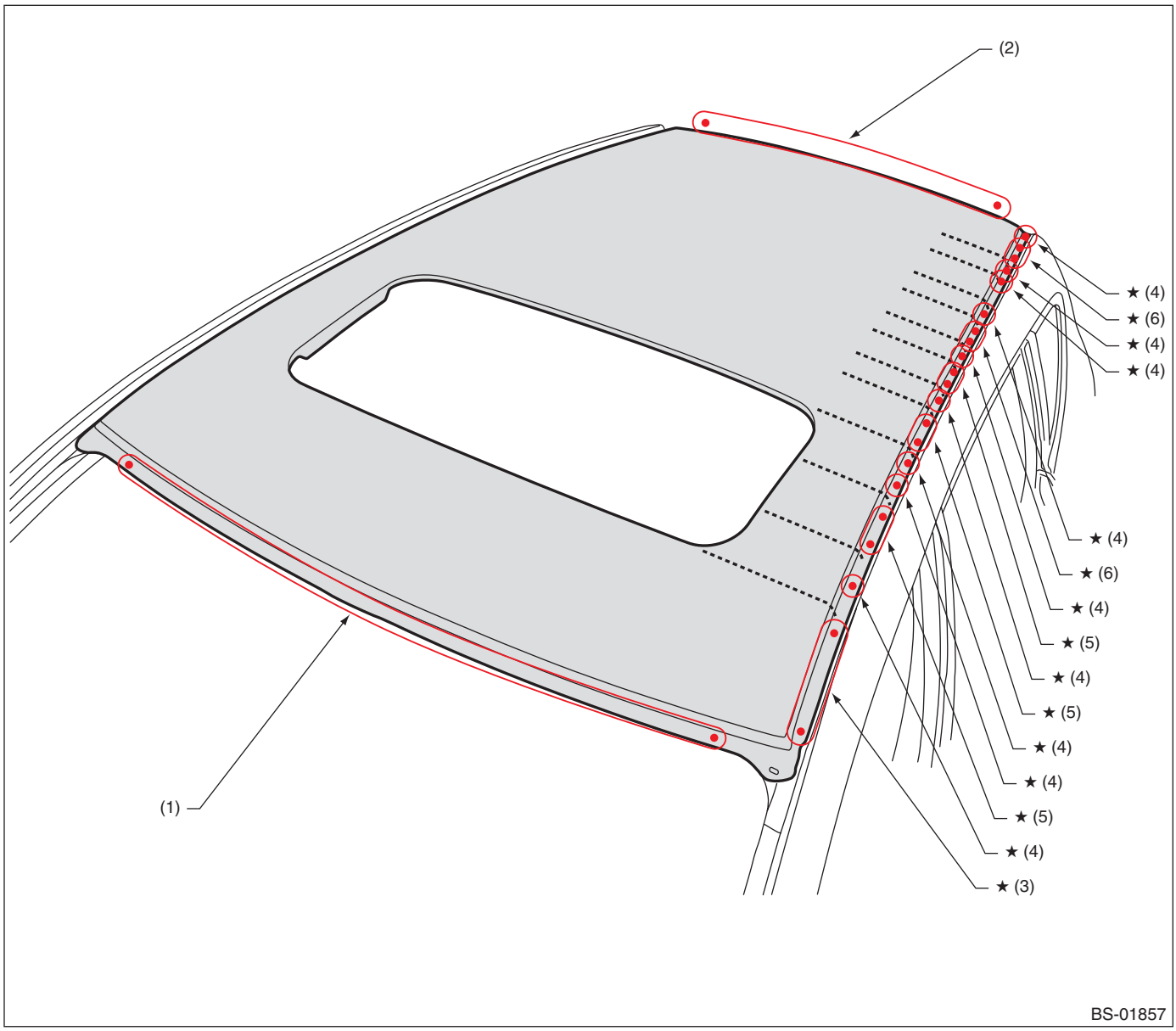


(1) 1 point (top · 1) (2) 3 points (top · 1) (3) 2 points (top · 1)

For locations marked by H, the welding method, the number of welding points, and the rough cutting dimensions are the same on the left and the right.

B: INSTALLATION

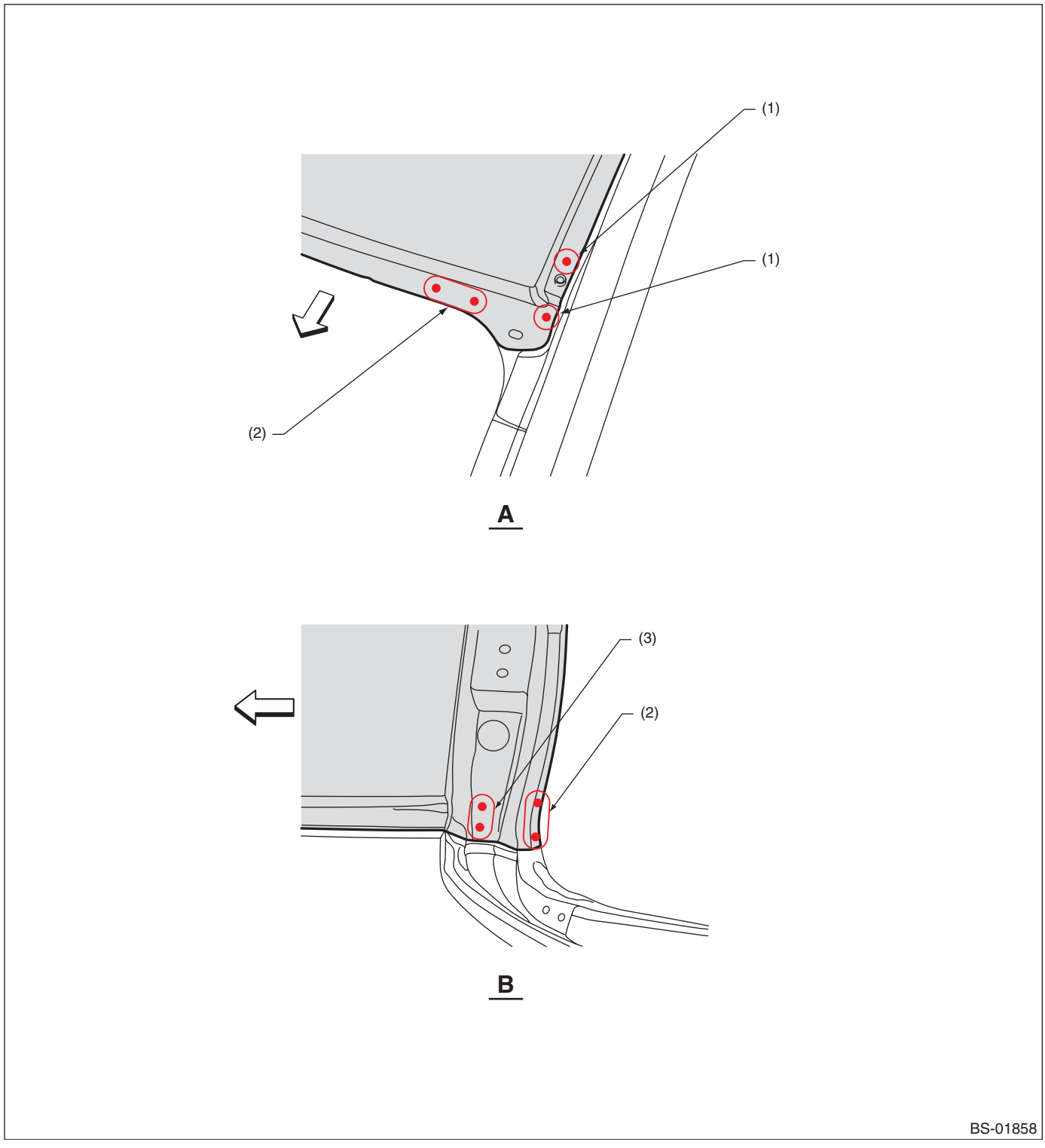
- **Overall view**



(1)	19 points	(3)	4 points	(5)	3 points
(2)	24 points	(4)	1 point	(6)	2 points

For locations marked by H, the welding method, the number of welding points, and the rough cutting dimensions are the same on the left and the right.

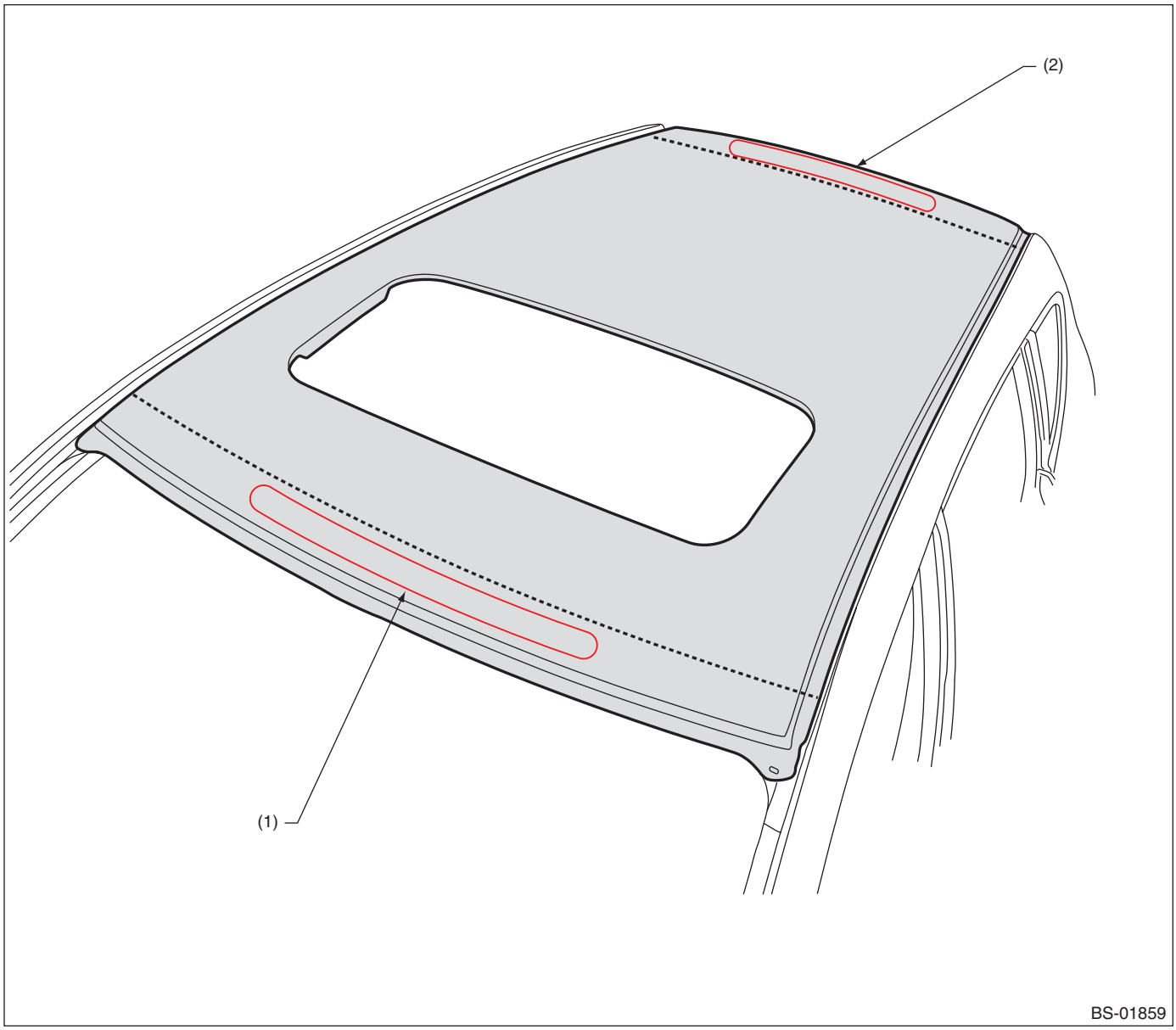
- **Views**



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

For locations marked by H, the welding method, the number of welding points, and the rough cutting dimensions are the same on the left and the right.

At the time of roof panel installation, apply adhesive at the locations shown in the following figure.



(1) 7 points

(2) 6 points