

BODY REPAIR MANUAL

BS

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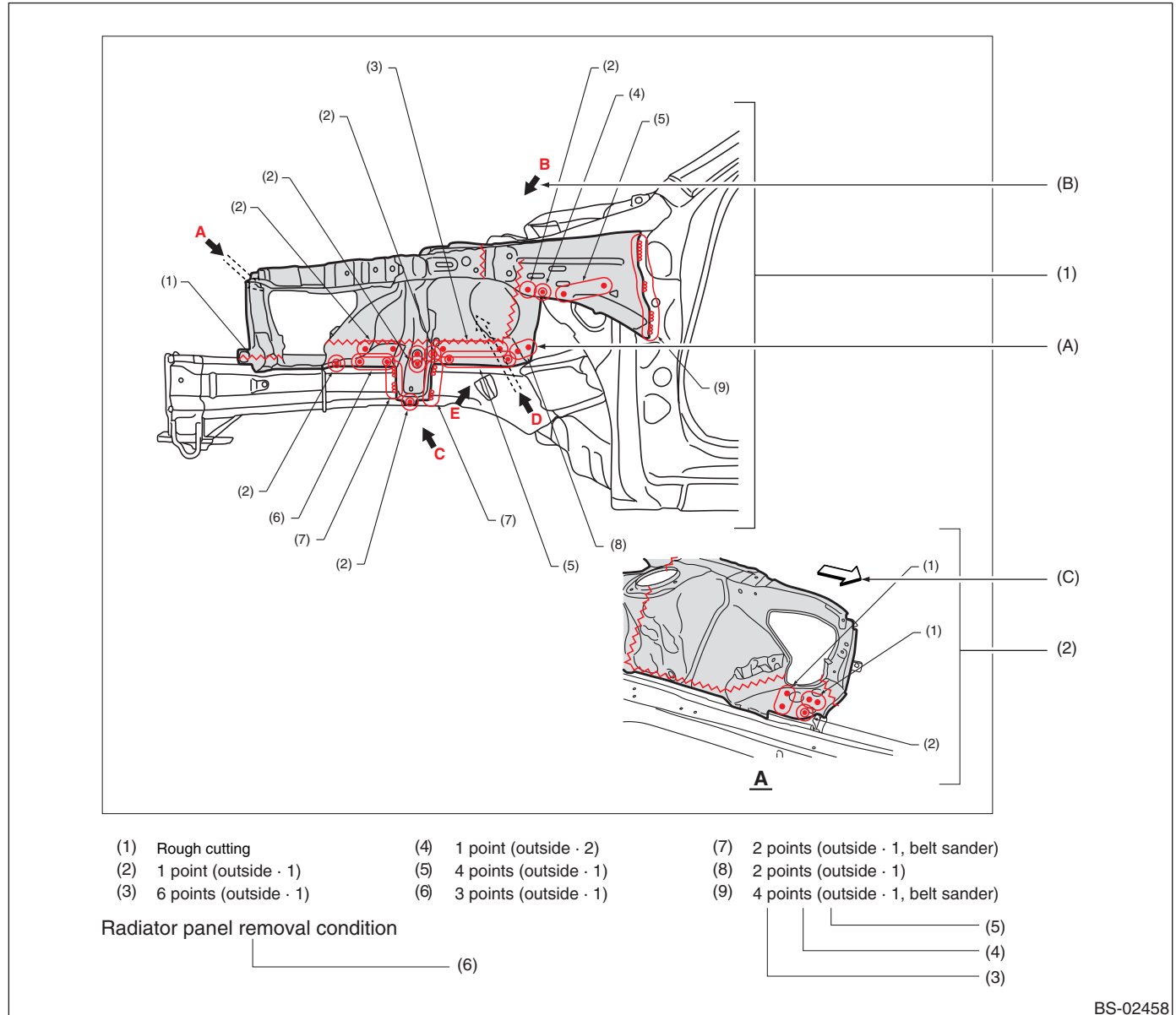
1. Foreword

A: USE OF THIS MANUAL

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

1. ILLUSTRATION EXAMPLE

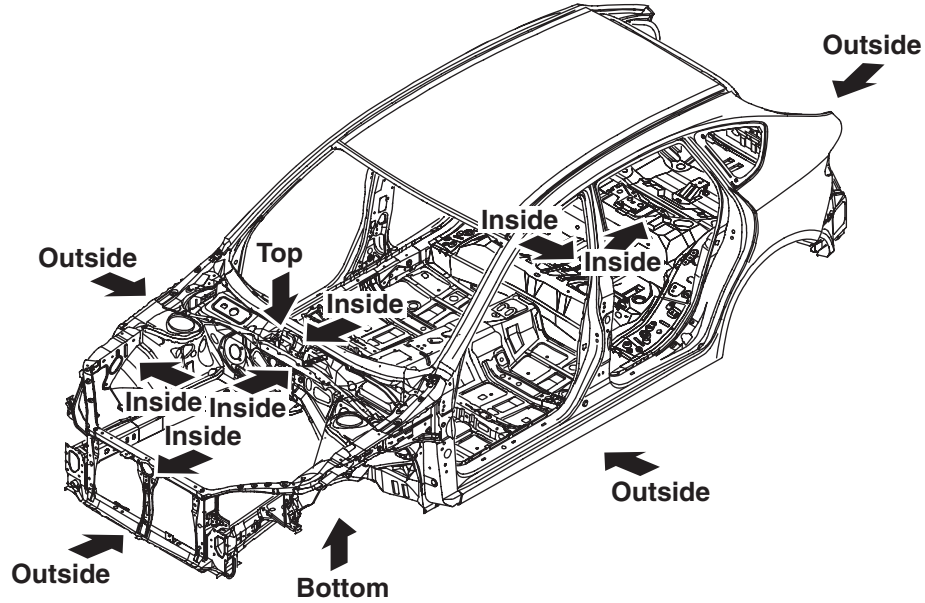
- Symbols and number of points indicate the welding method and the number of welding points. Text in brackets indicates the direction for removal of welded parts, and numbers indicate the number of plates to be drilled in panels of welded parts to be removed.
- An enclosure by a broken line indicates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



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

2. REMOVAL DIRECTION

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

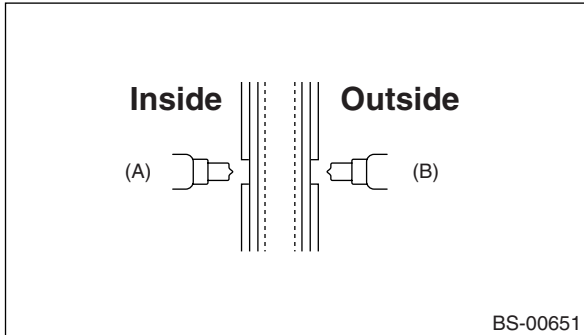


BS-02459

3. NUMBER OF PANELS TO BE DRILLED

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

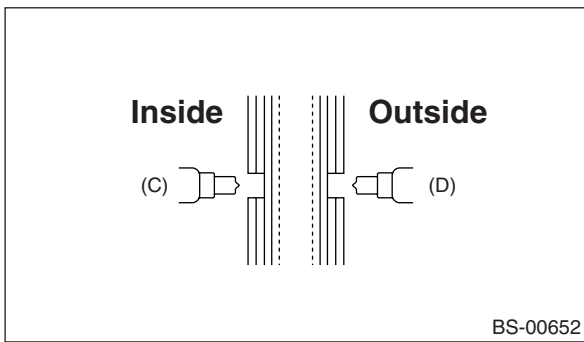
(1) Drilling through one plate



(A) (Inside · 1)

(B) (Outside · 1)

(2) Drilling through two plates

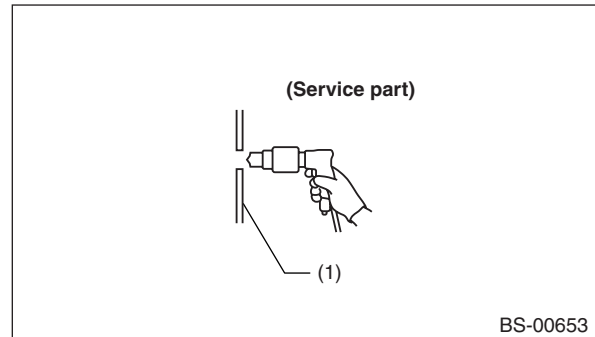


(C) (Inside · 2)

(D) (Outside · 2)

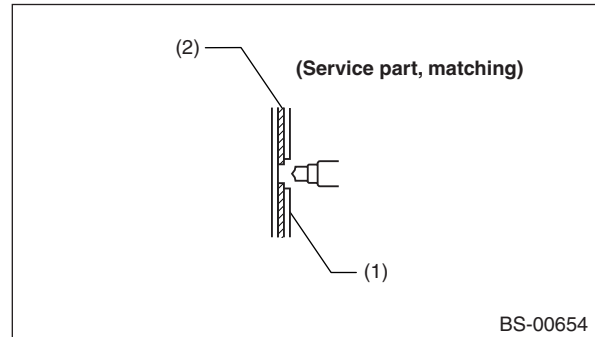
4. HOLE DRILLING FOR PLUG WELDING

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



(1) Service part

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


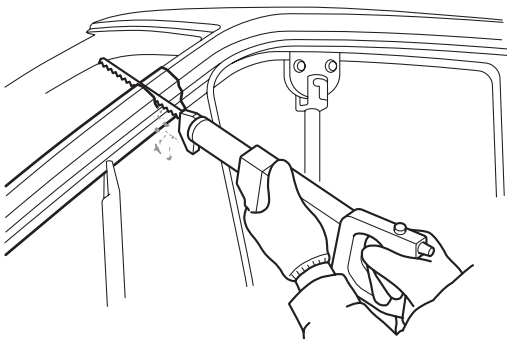


(1) Vehicle side


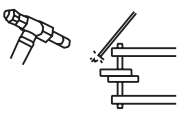
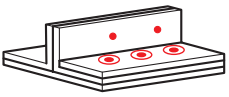
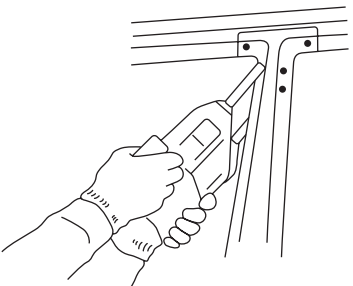


(2) Service part

5. MEANING OF SYMBOLS



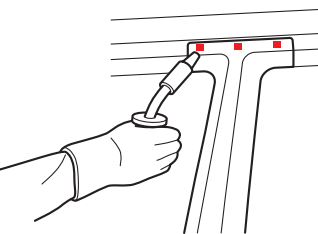

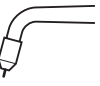
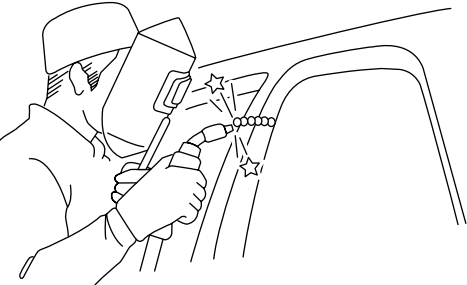
• Cutting

| | |
|---|--|
|  <p>BS-00352</p> |  <p>BS-00267</p> |
|---|--|

• Spot welding

| | | | | |
|--|---|---|--|--|
| Two overlap- ing parts |  <p>BS-00655</p> |  <p>BS-00656</p> |  <p>BS-00657</p> |  <p>BS-00658</p> |
| Three or more over- lapping parts |  <p>BS-00659</p> |  <p>BS-00660</p> | | |

• Carbon dioxide gas arc welding (MIG welding)

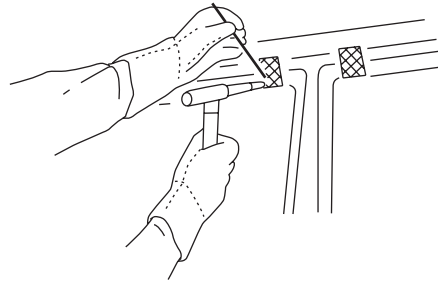
| | | | |
|--------------------|---|---|---|
| Plug welding |  <p>BS-00661</p> |  <p>BS-00662</p> |  <p>BS-00663</p> |
| Continuous welding |  <p>BS-00664</p> |  <p>BS-00665</p> |  <p>BS-00666</p> |

Foreword

- **Brazing**



BS-00667

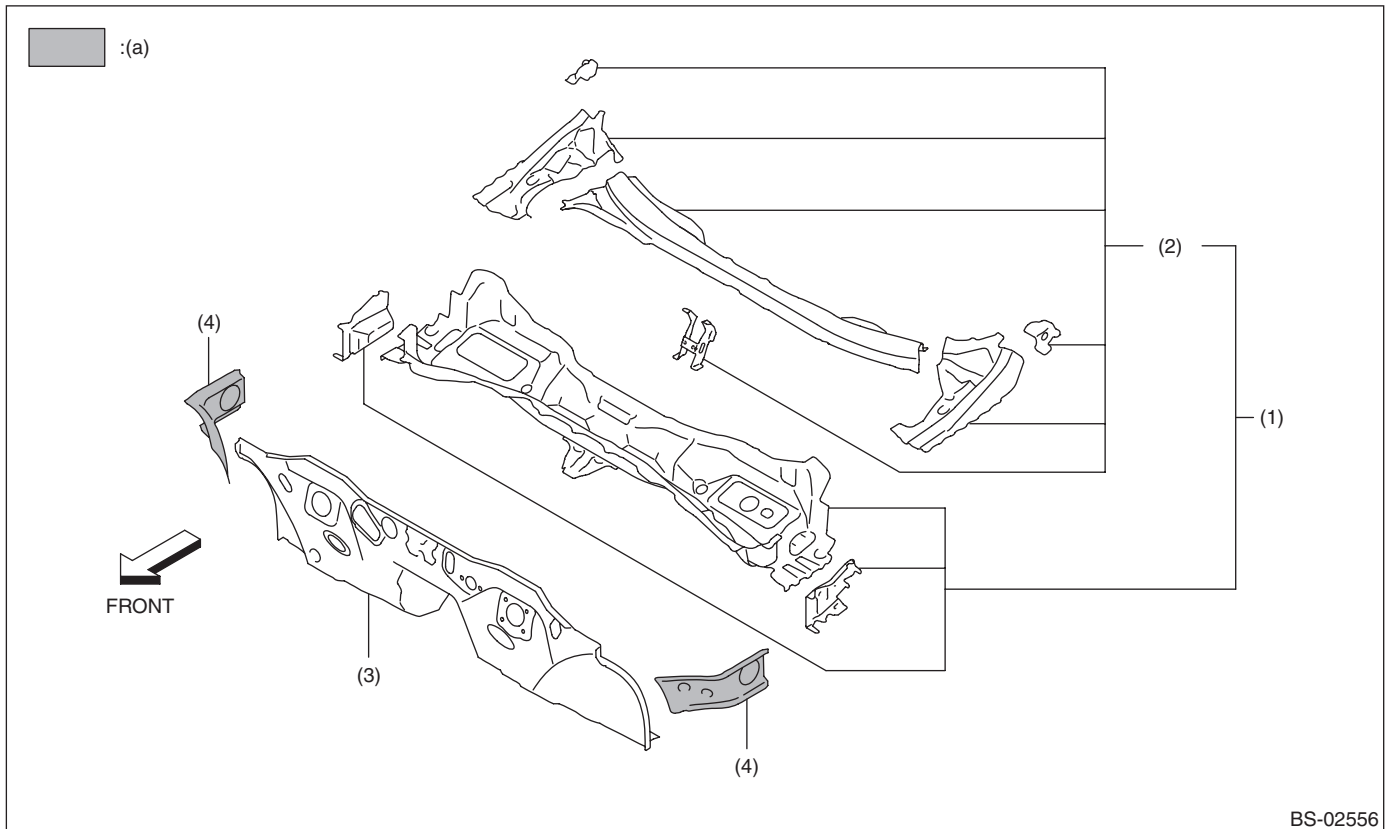


BS-00668

2. Panel Components

A: COMPONENTS

1. TOE BOARD & FRONT PANEL



(a) High-strength steel

(1) Front panel and Duct

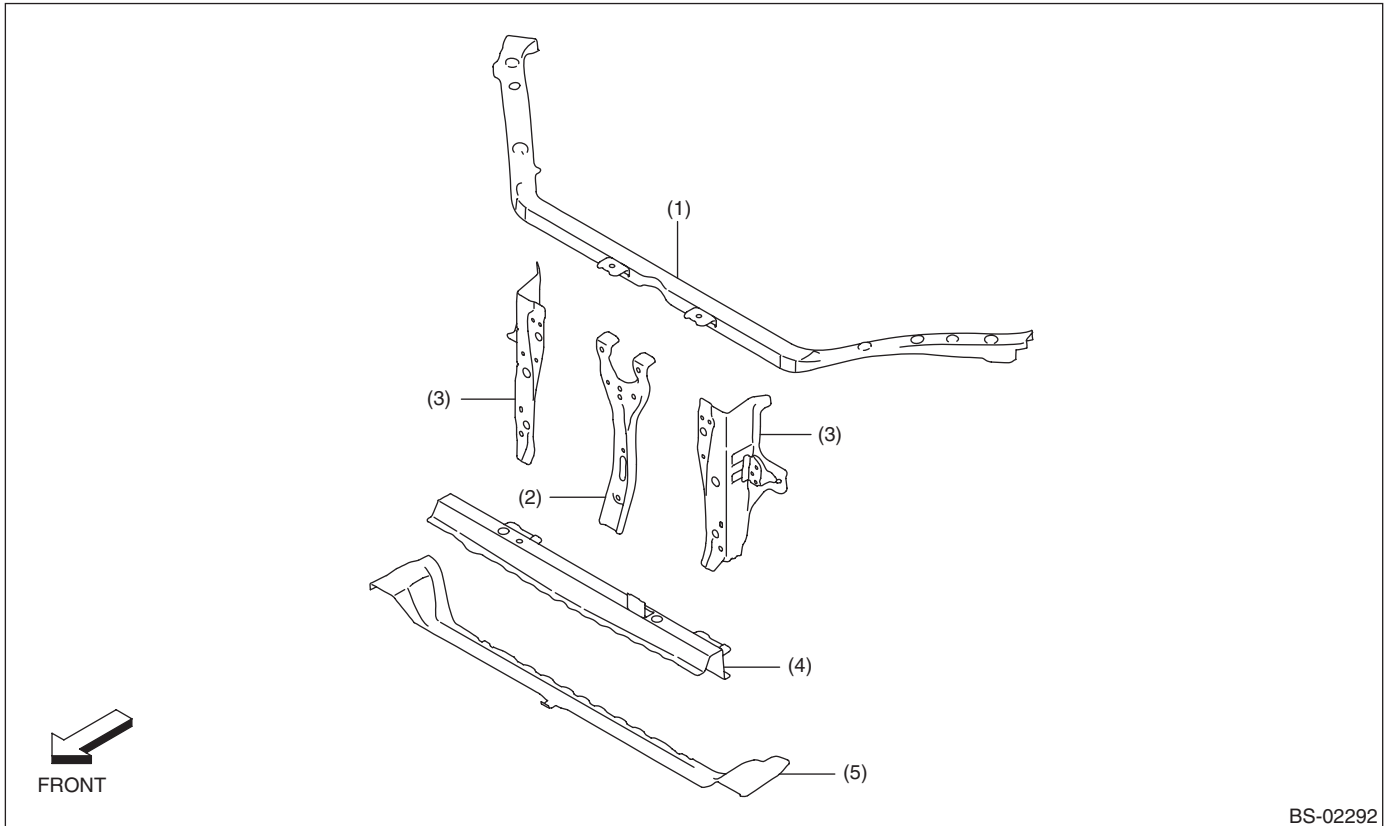
(2) Front panel

(3) Toe board

(4) Gusset

Panel Components

2. RADIATOR PANEL



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

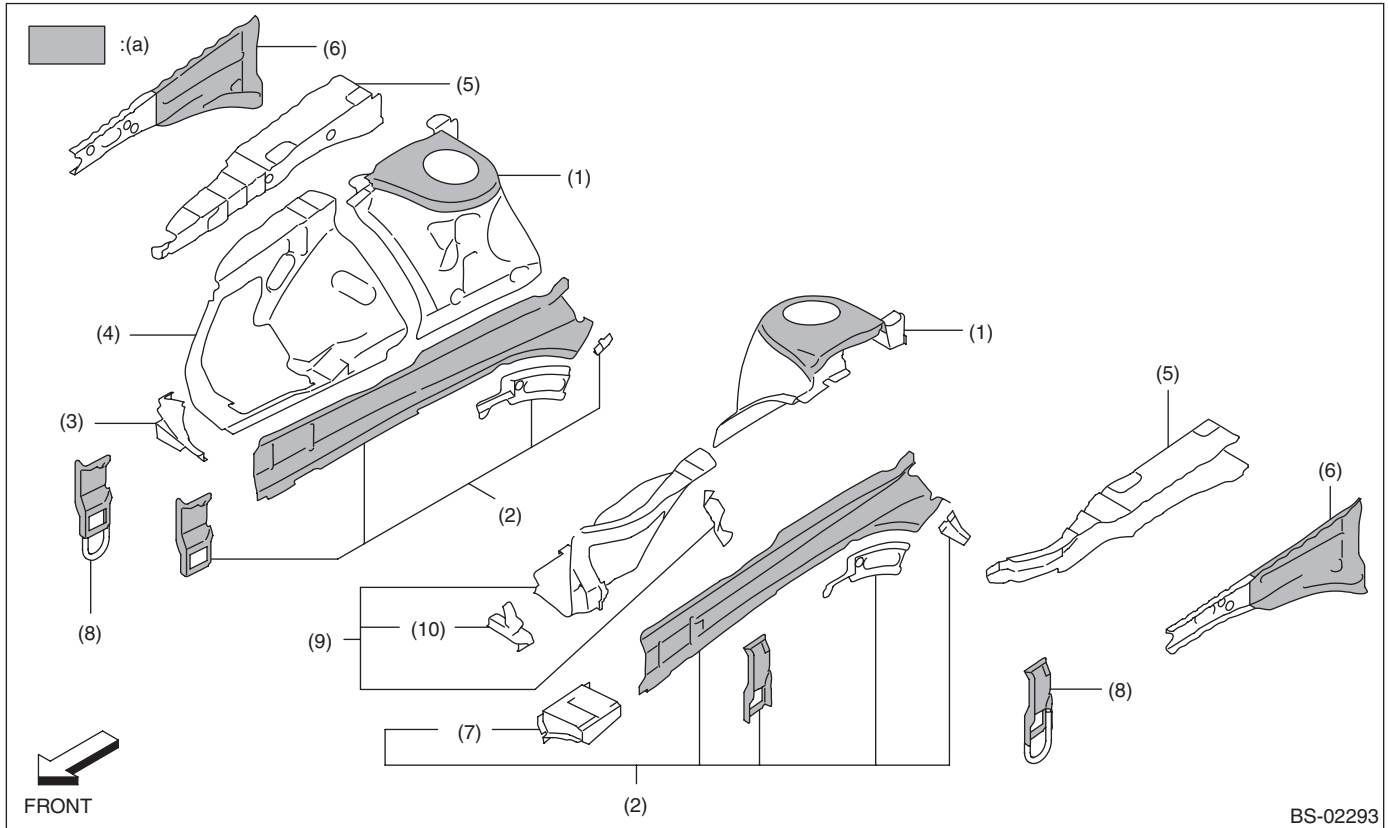
(3) Radiator panel side
(4) Radiator panel frame lower

(5) Radiator frame lower

BS-02292

Panel Components

3. FRONT WHEEL APRON



(a) High-strength steel

(1) Front suspension bracket

(2) Closing plate

(3) Fender bracket right

(4) Front wheel apron right

(5) Front wheel apron upper

(6) Side upper frame

(7) Battery bracket

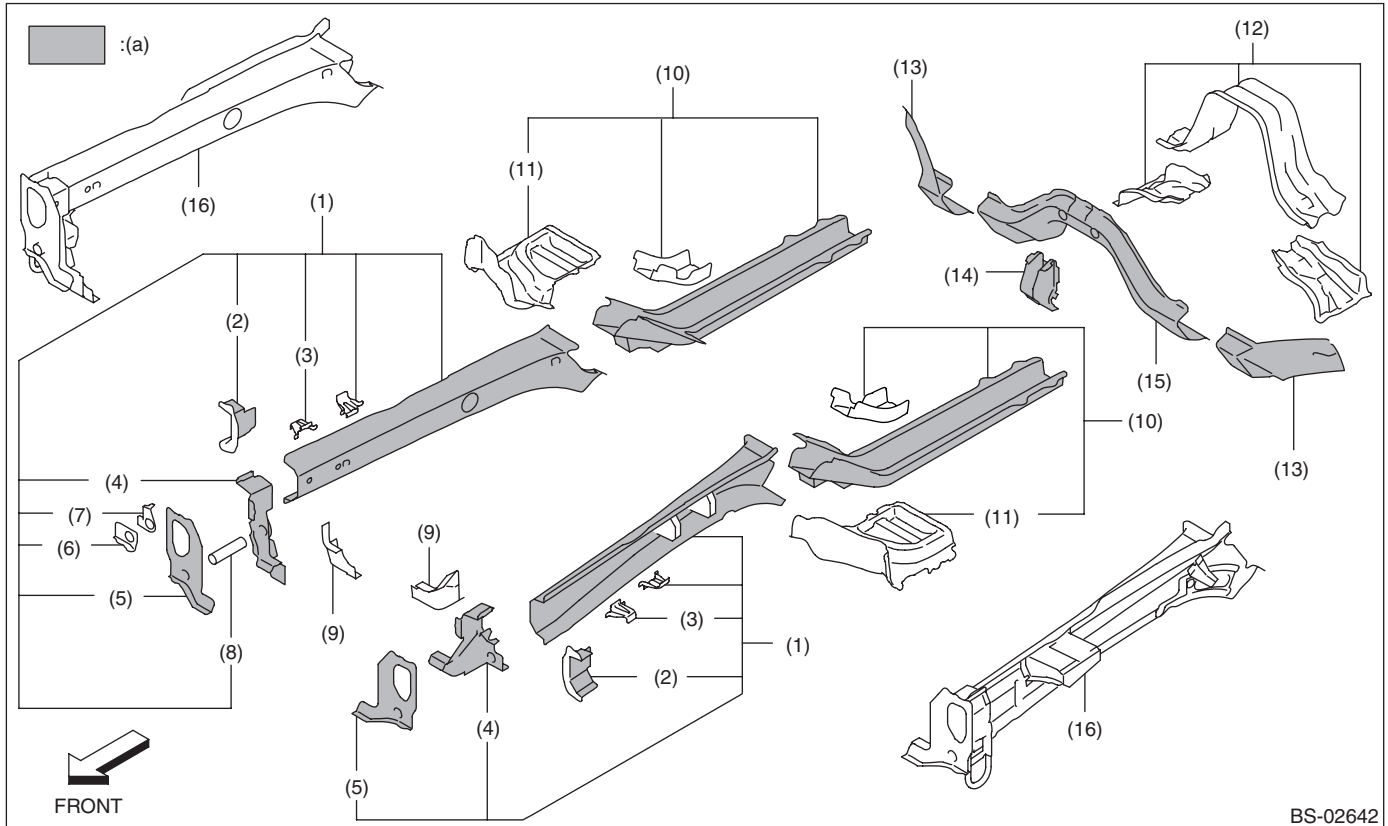
(8) Front tie-down

(9) Front wheel apron left

(10) Fender bracket left

Panel Components

4. FRONT SIDE FRAME

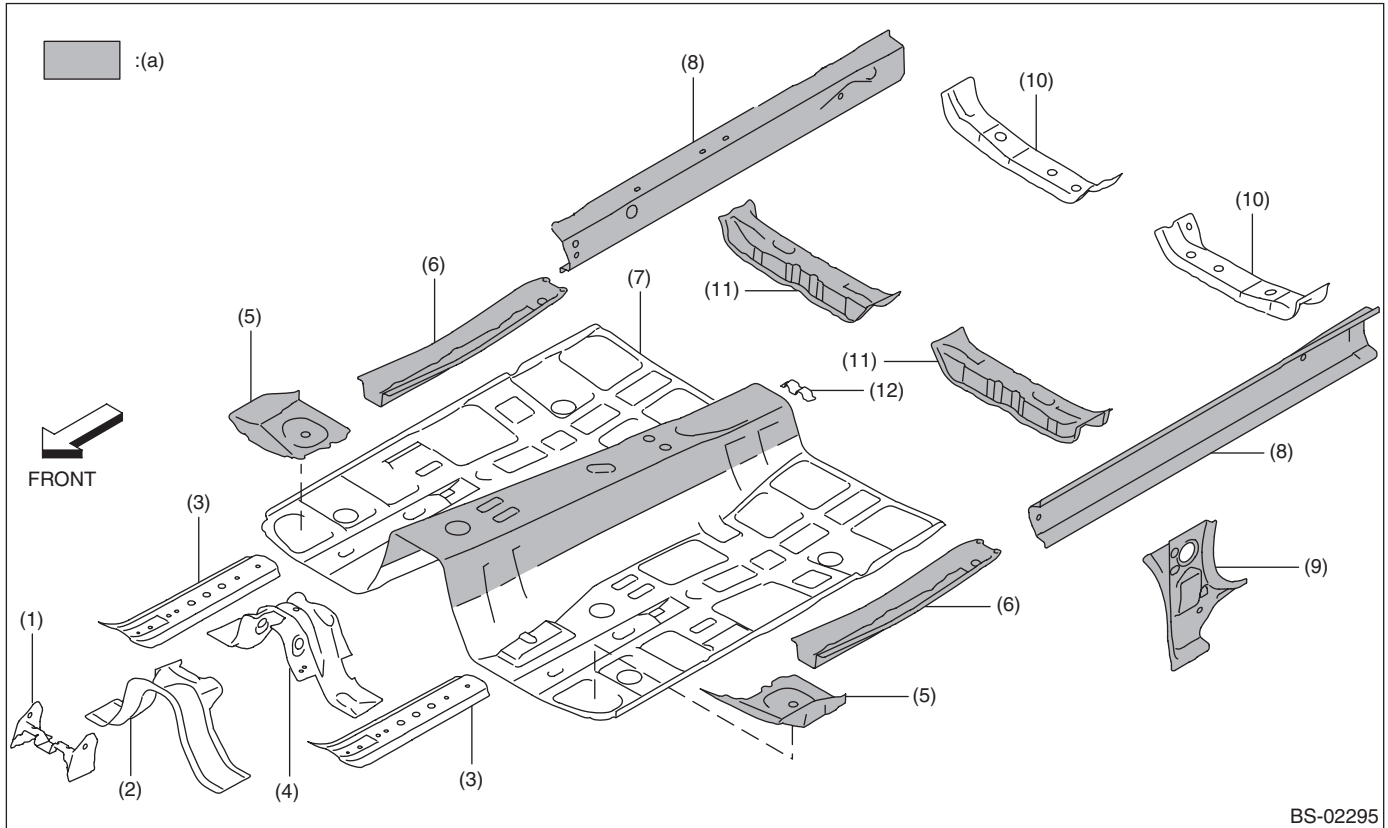


(a) High-strength steel

- | | | |
|-----------------------------|------------------------------|-----------------------------------|
| (1) Front side frame front | (7) Plate B | (13) Toe board crossmember side |
| (2) Bumper bracket front | (8) Hook Pipe | (14) Pitching stopper bracket |
| (3) Separator | (9) Front frame gusset C | (15) Toe board crossmember center |
| (4) Front frame gusset | (10) Front side frame rear | (16) Side frame |
| (5) Front frame plate front | (11) Toe board reinforcement | |
| (6) Plate A | (12) Floor crossmember front | |

Panel Components

5. FRONT FLOOR PANEL



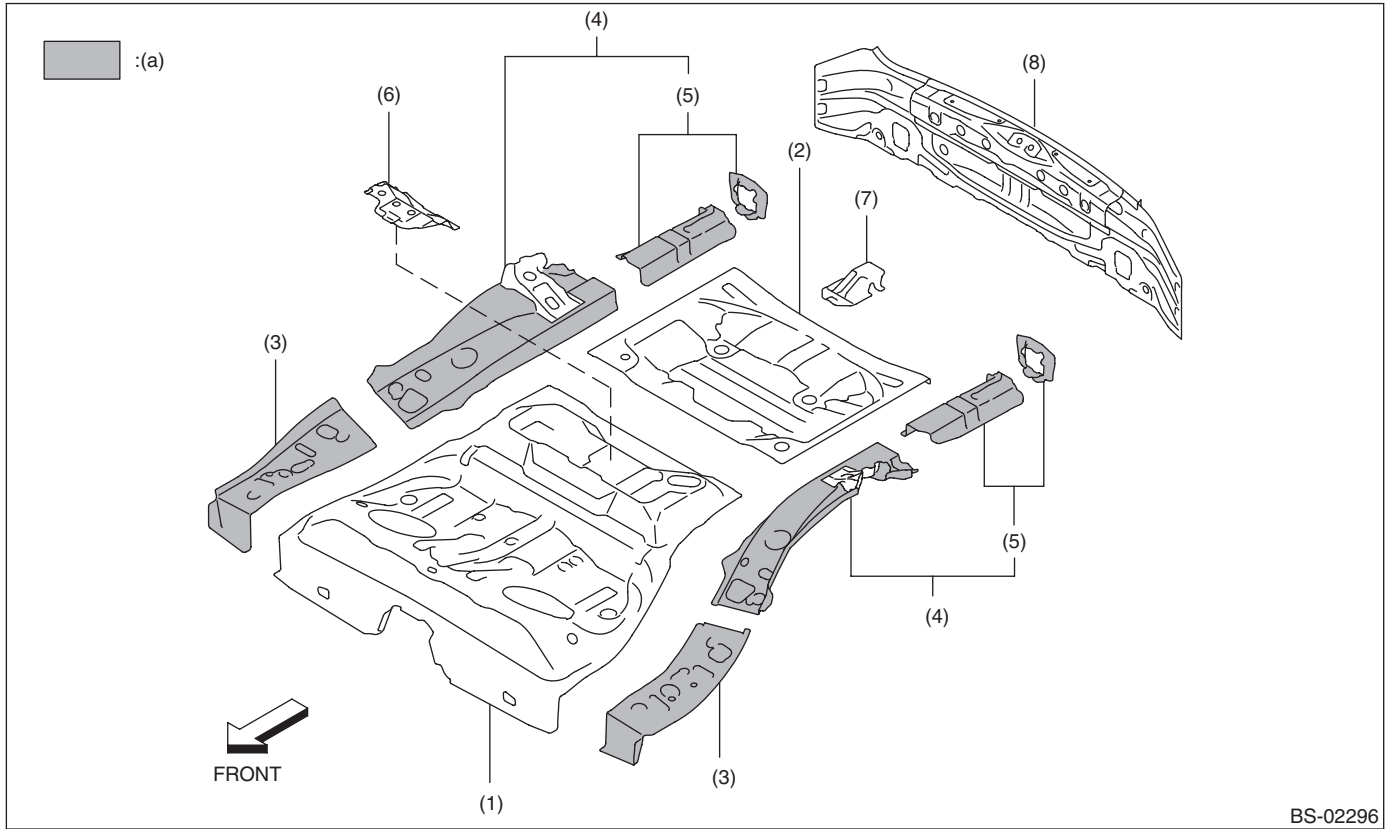
(a) High-strength steel

- | | | |
|------------------------------|-----------------------------------|-----------------------------------|
| (1) Instrument panel bracket | (5) Toe board reinforcement upper | (9) Front pillar inner lower |
| (2) Floor crossmember center | (6) Front floor frame rear | (10) Front seat crossmember rear |
| (3) Front floor frame front | (7) Front floor pan | (11) Front seat crossmember front |
| (4) Floor crossmember rear | (8) Side sill inner | (12) Hand brake reinforcement |

Panel Components

6. REAR FLOOR PANEL & REAR SKIRT

- 5 door



(a) High-strength steel

(1) Rear floor pan front

(2) Rear floor pan rear

(3) Side frame upper front

(4) Side frame upper rear

(5) Side frame upper rear rear

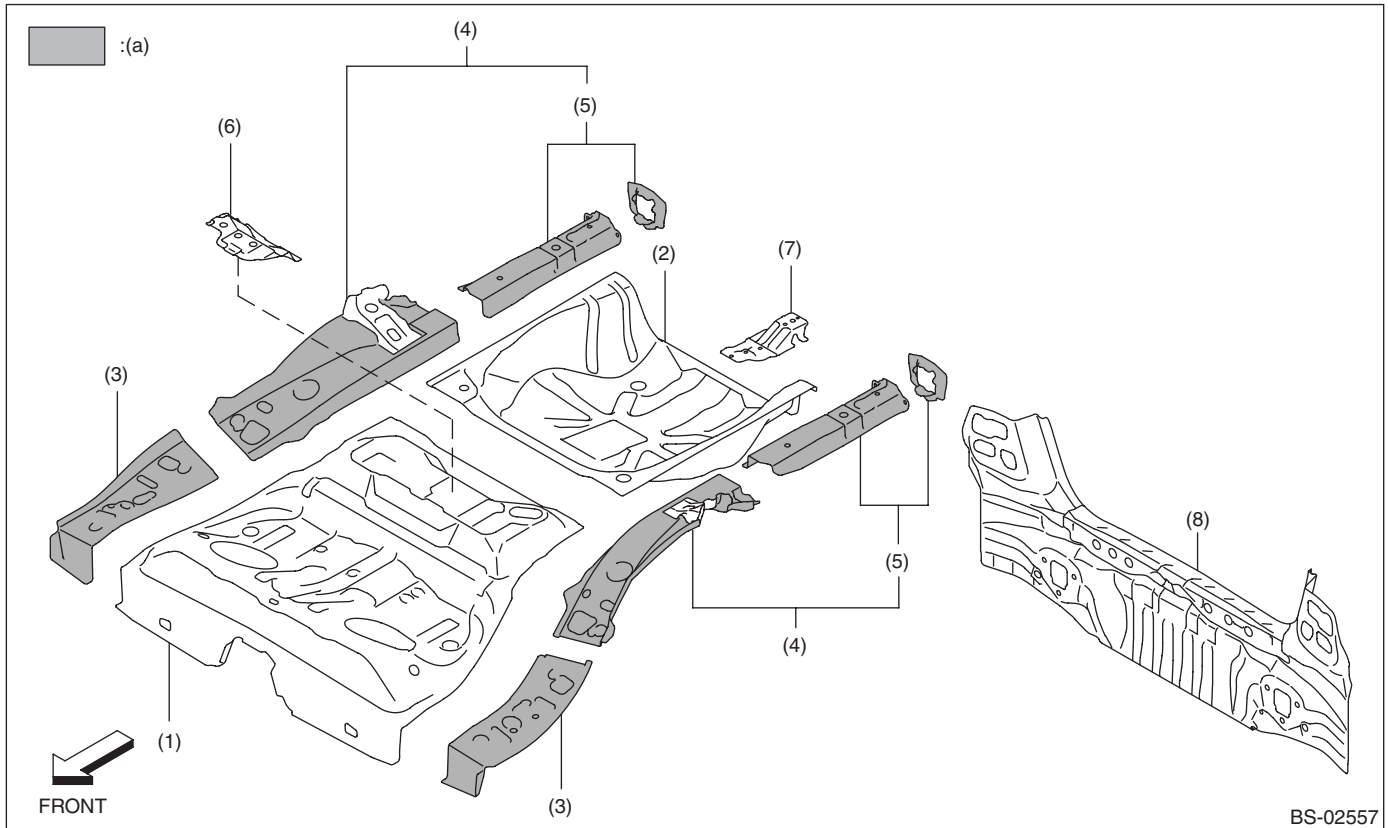
(6) Spare tire reinforcement

(7) Spare tire bracket

(8) Rear skirt

Panel Components

• 4 door



(a) High-strength steel

(1) Rear floor pan front

(2) Rear floor pan rear

(3) Side frame upper front

(4) Side frame upper rear

(5) Side frame upper rear rear

(6) Spare tire reinforcement

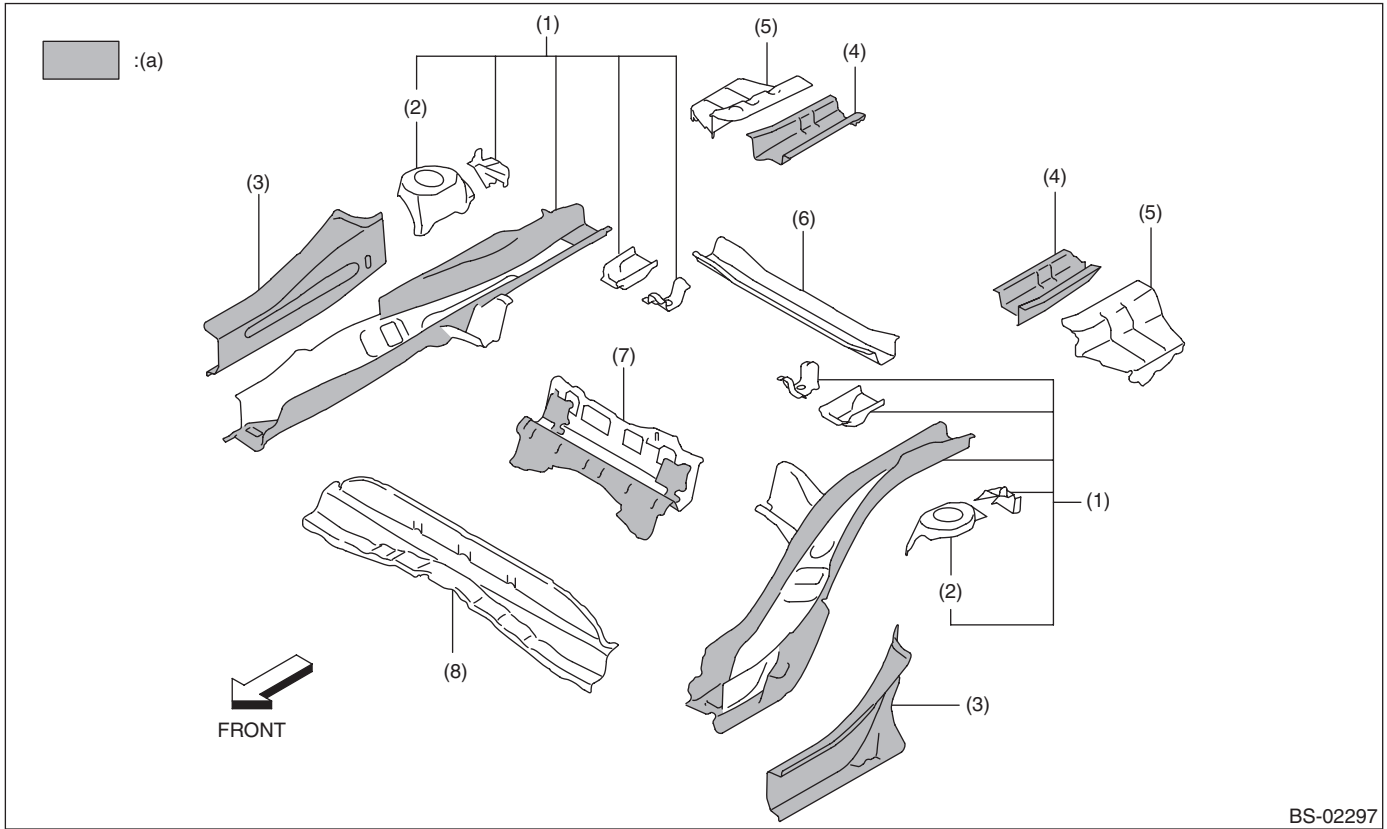
(7) Spare tire bracket

(8) Rear skirt

Panel Components

7. REAR FLOOR SIDE FRAME

- 5 door



(a) High-strength steel

(1) Floor side frame front

(2) Rear suspension bracket

(3) Side sill inner rear

(4) Floor side frame rear

(5) Floor side rear

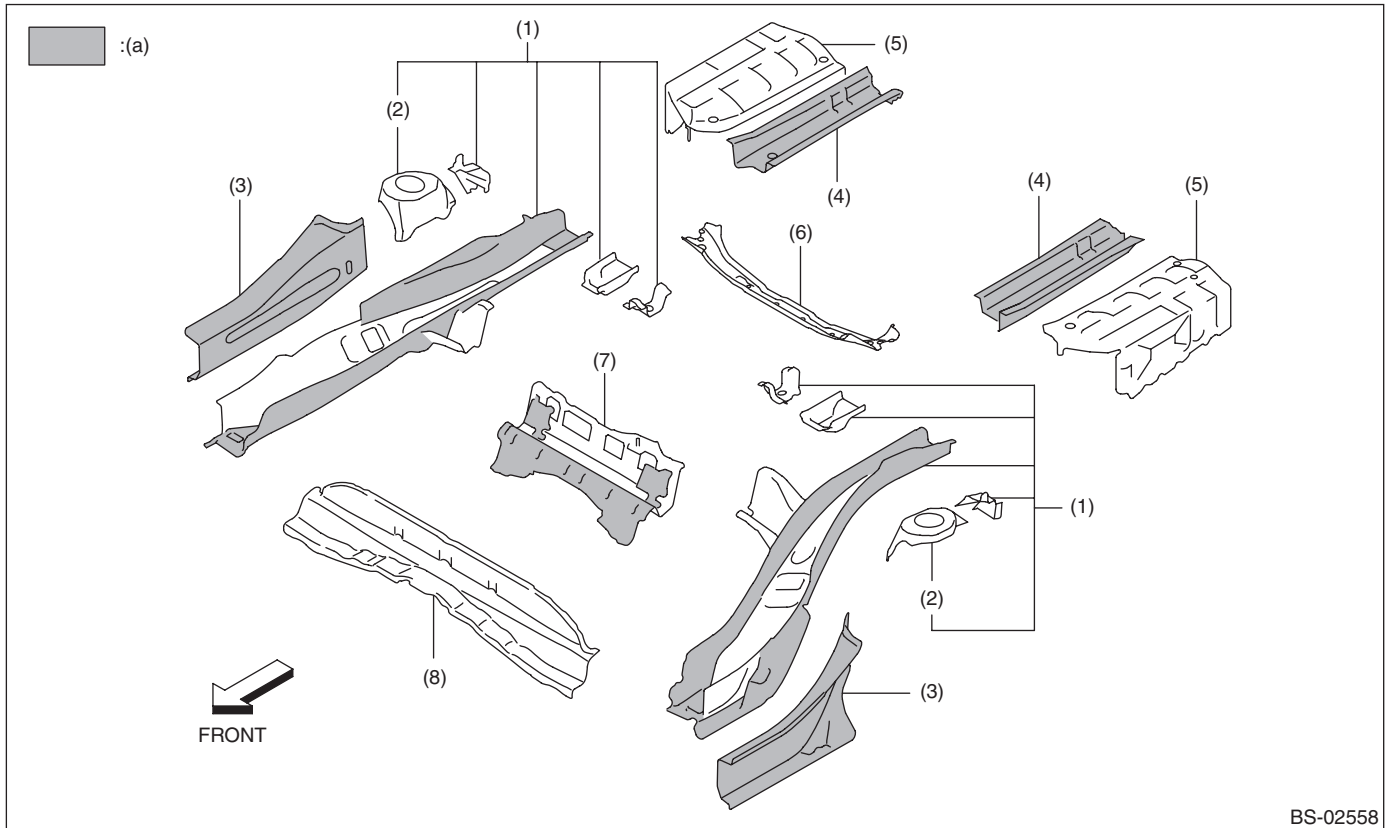
(6) Rear floor crossmember C

(7) Rear floor crossmember B

(8) Rear floor crossmember A

Panel Components

• 4 door



(a) High-strength steel

(1) Floor side frame front

(2) Rear suspension bracket

(3) Side sill inner rear

(4) Floor side frame rear

(5) Floor side rear

(6) Rear floor crossmember C

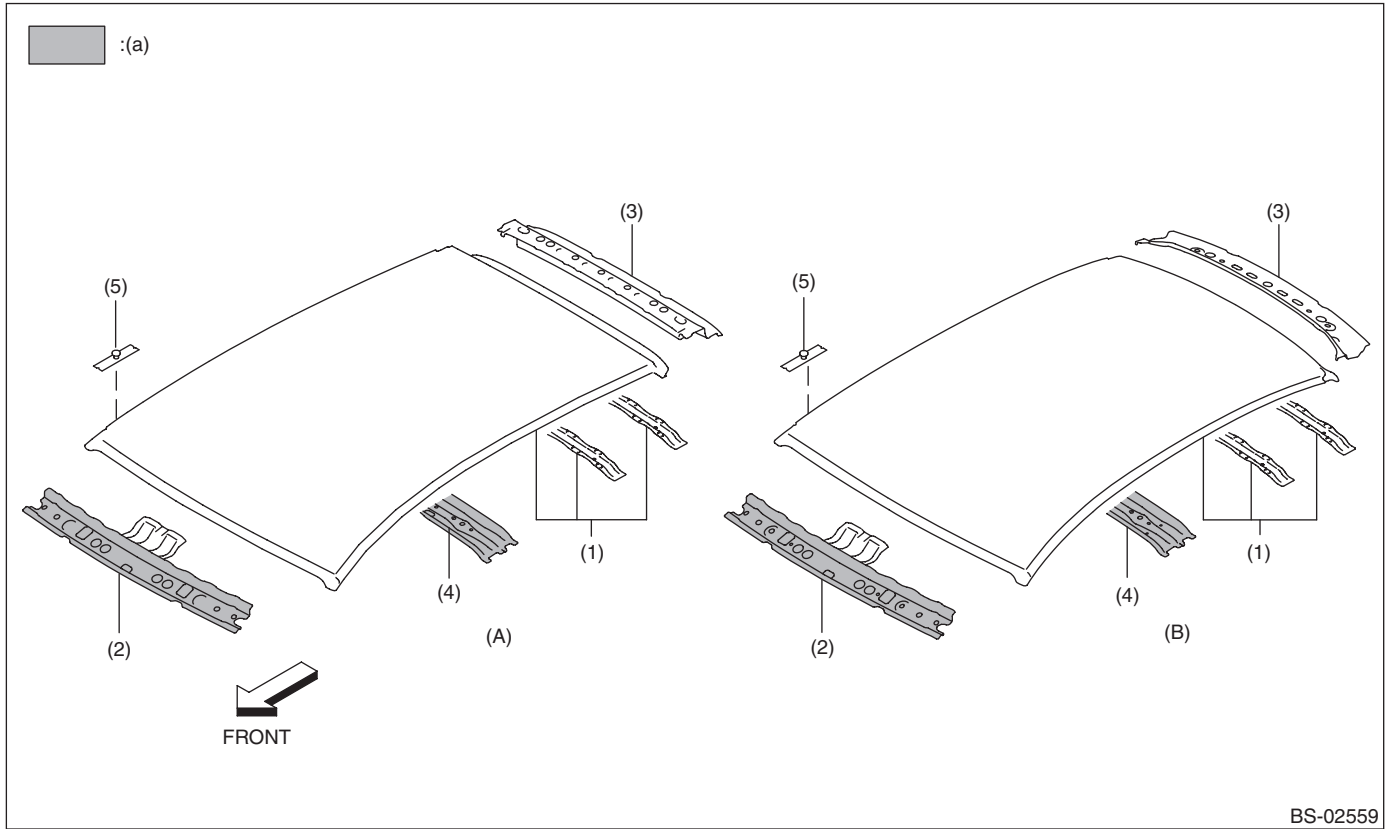
(7) Rear floor crossmember B

(8) Rear floor crossmember A

Panel Components

8. ROOF

- Model without sunroof



(a) High-strength steel

(A) 5 door

(B) 4 door

(1) Roof panel

(3) Rear roof rail

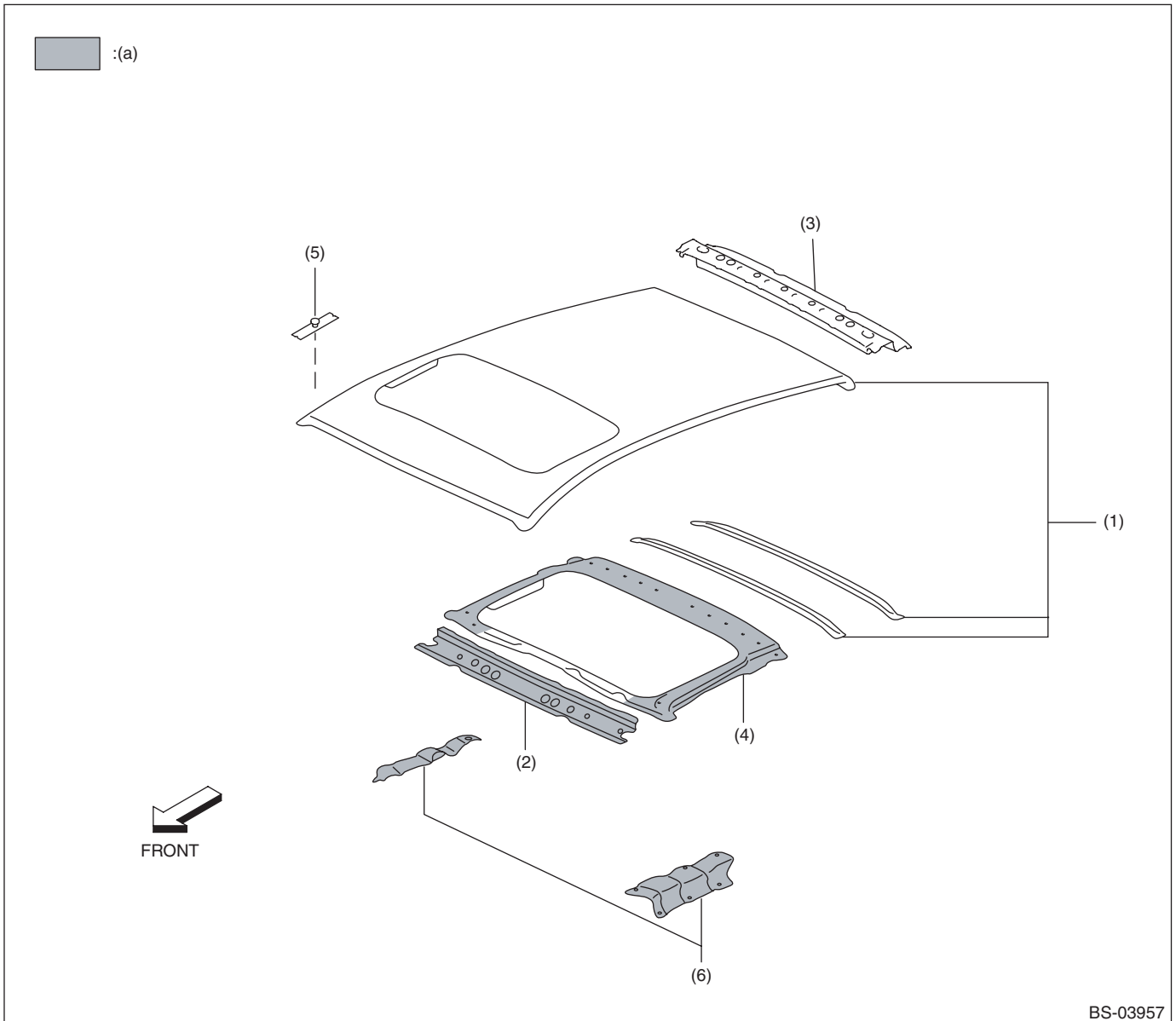
(5) T stud plate

(2) Front roof rail

(4) Roof center brace

Panel Components

- 5 door sunroof model



(a) High-strength steel

(1) Roof panel

(2) Front roof rail

(3) Rear roof rail

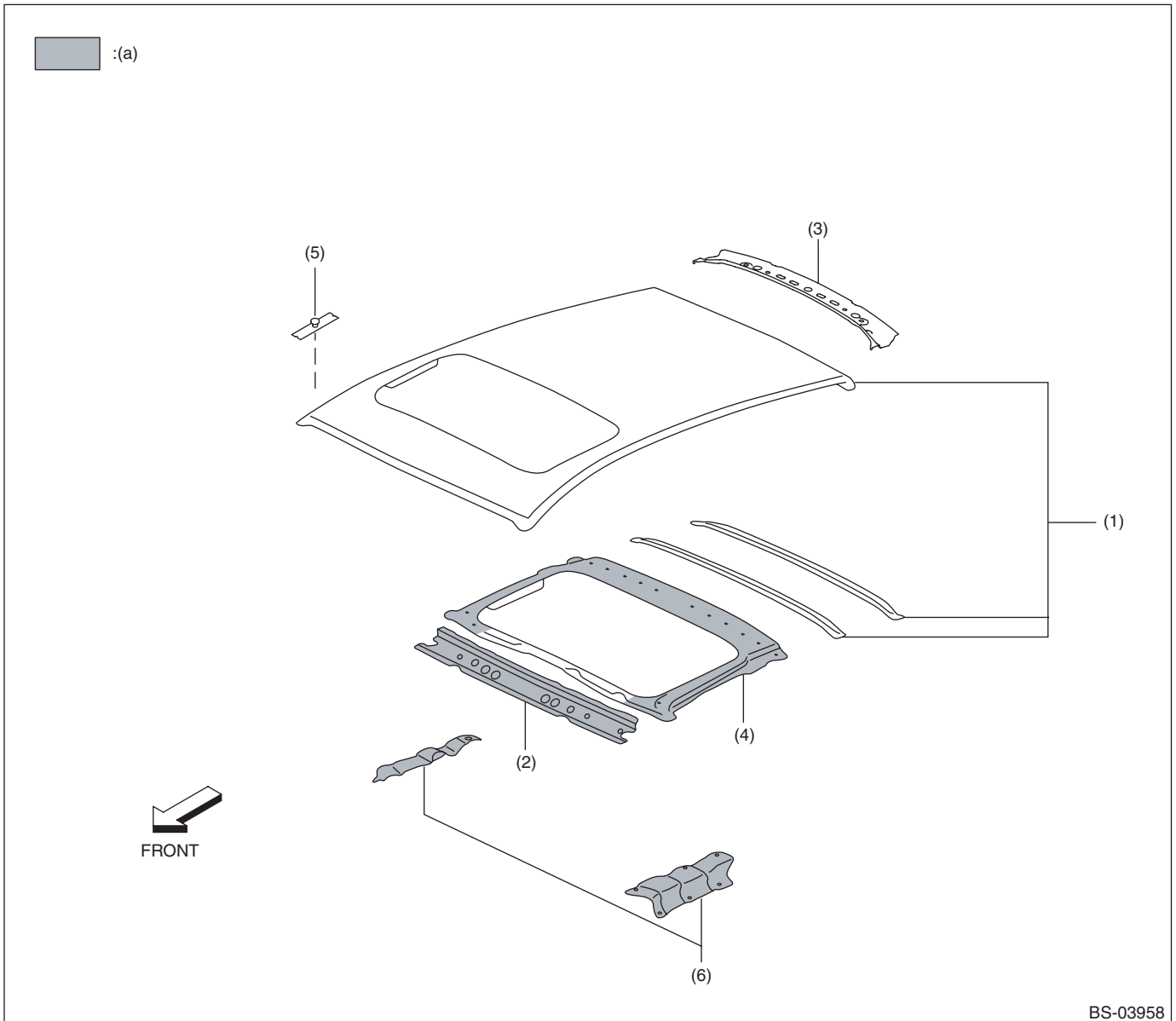
(4) Sunroof frame

(5) T-stud plate

(6) Sunroof bracket brace

Panel Components

- 4 door sunroof model



(a) High-strength steel

(1) Roof panel

(2) Front roof rail

(3) Rear roof rail

(4) Sunroof frame

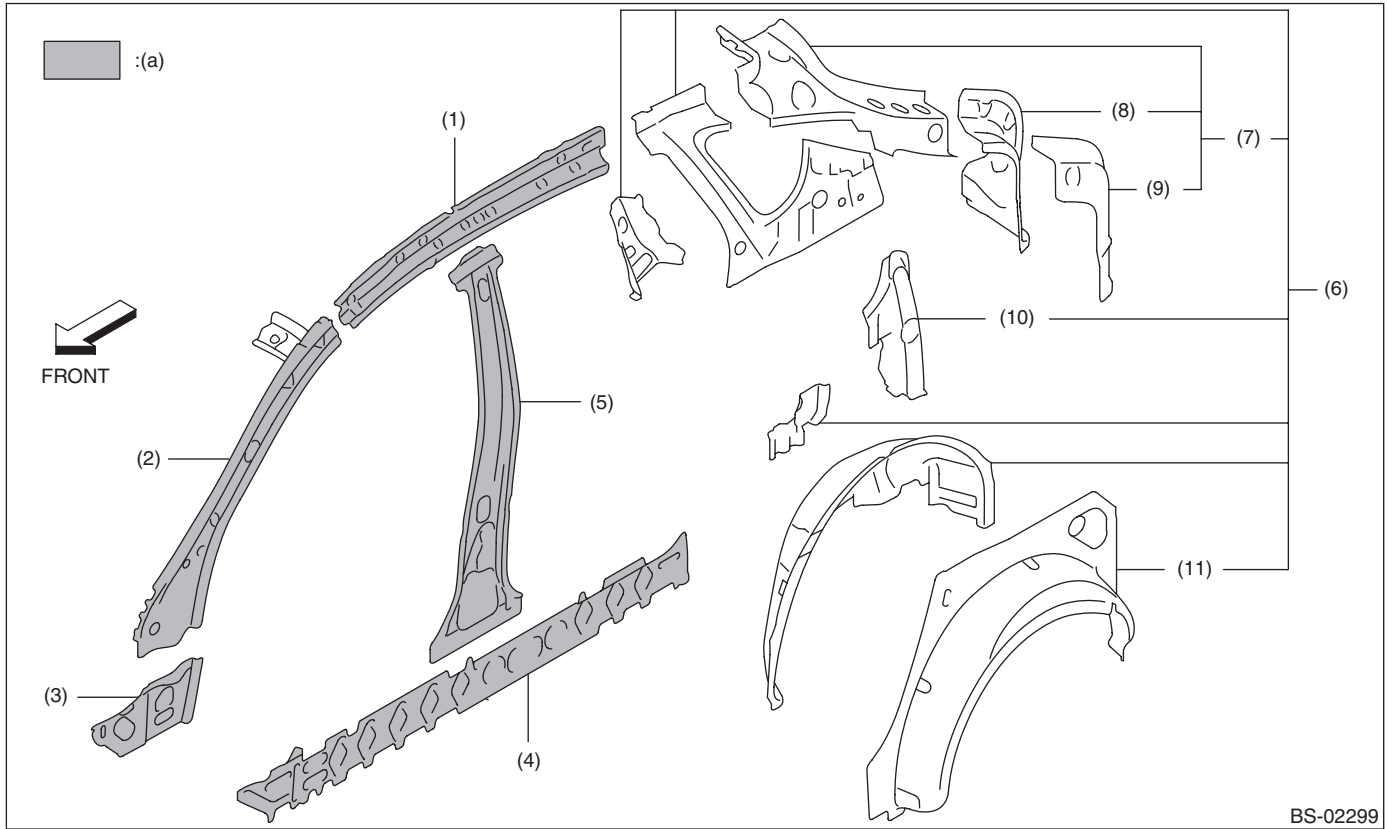
(5) T-stud plate

(6) Sunroof bracket brace

Panel Components

9. SIDE PANEL INNER

- 5 door

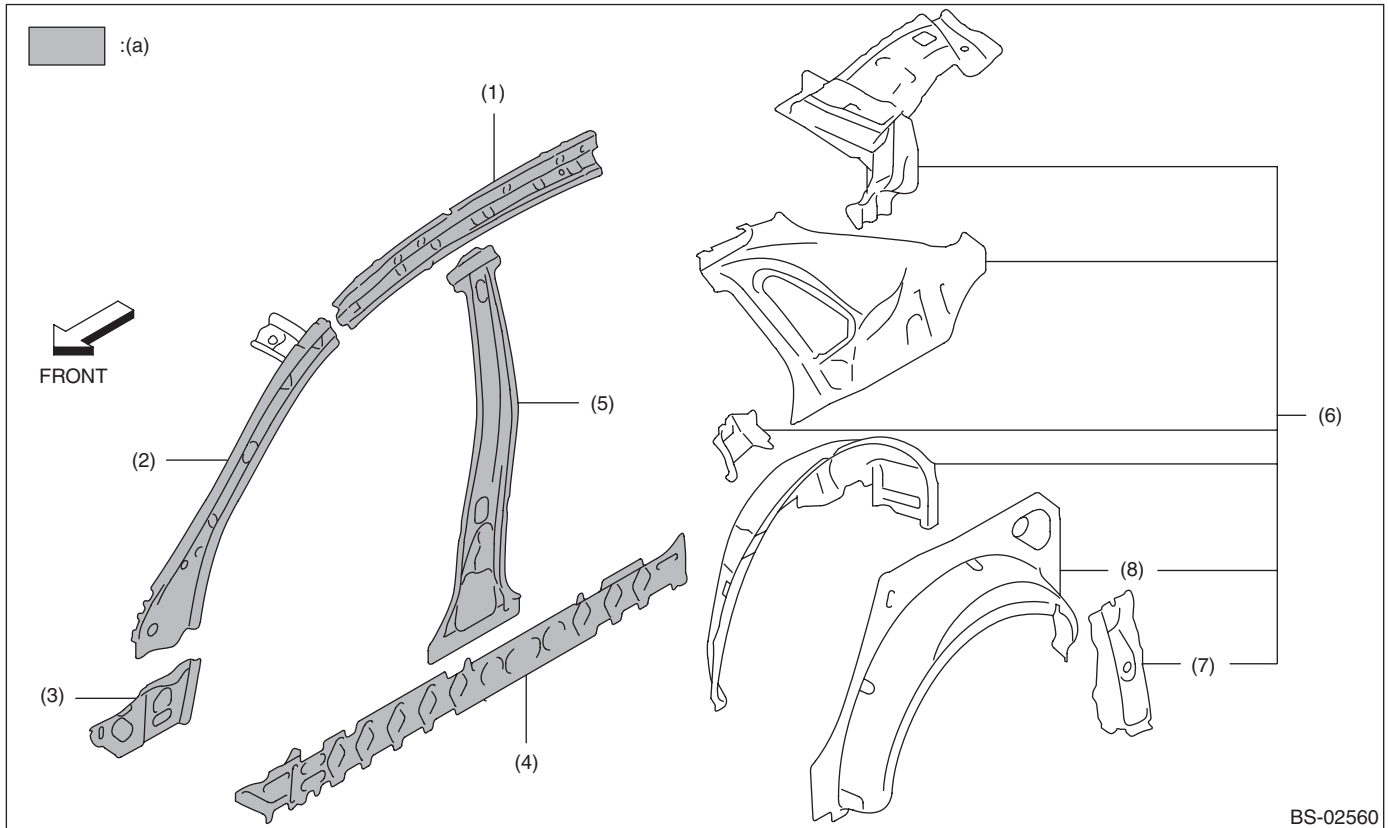


(a) High-strength steel

- | | | |
|-----------------------------------|---------------------------------|--|
| (1) Side rail inner | (5) Center pillar inner | (9) D-pillar reinforcement |
| (2) Front pillar inner upper | (6) Rear quarter inner | (10) Rear quarter reinforcement center |
| (3) Front pillar inner center | (7) D-pillar reinforcement ASSY | (11) Rear arch inner |
| (4) Side sill reinforcement inner | (8) D-pillar inner | |

Panel Components

• 4 door



(a) High-strength steel

(1) Side rail inner

(2) Front pillar inner upper

(3) Front pillar inner center

(4) Side sill reinforcement inner

(5) Center pillar inner

(6) Rear quarter inner

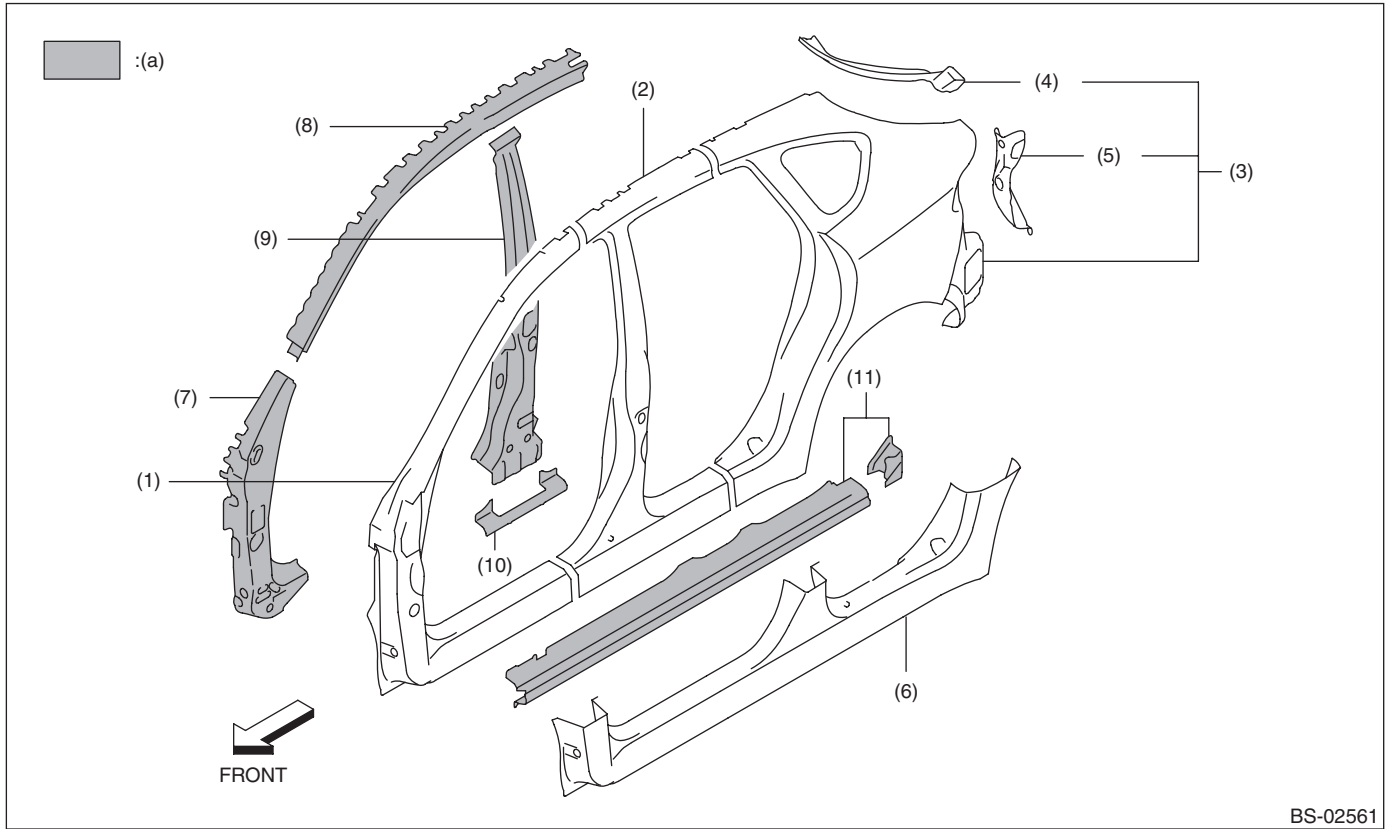
(7) Rear quarter reinforcement inner

(8) Rear arch inner

Panel Components

10.SIDE PANEL OUTER

• 5 door



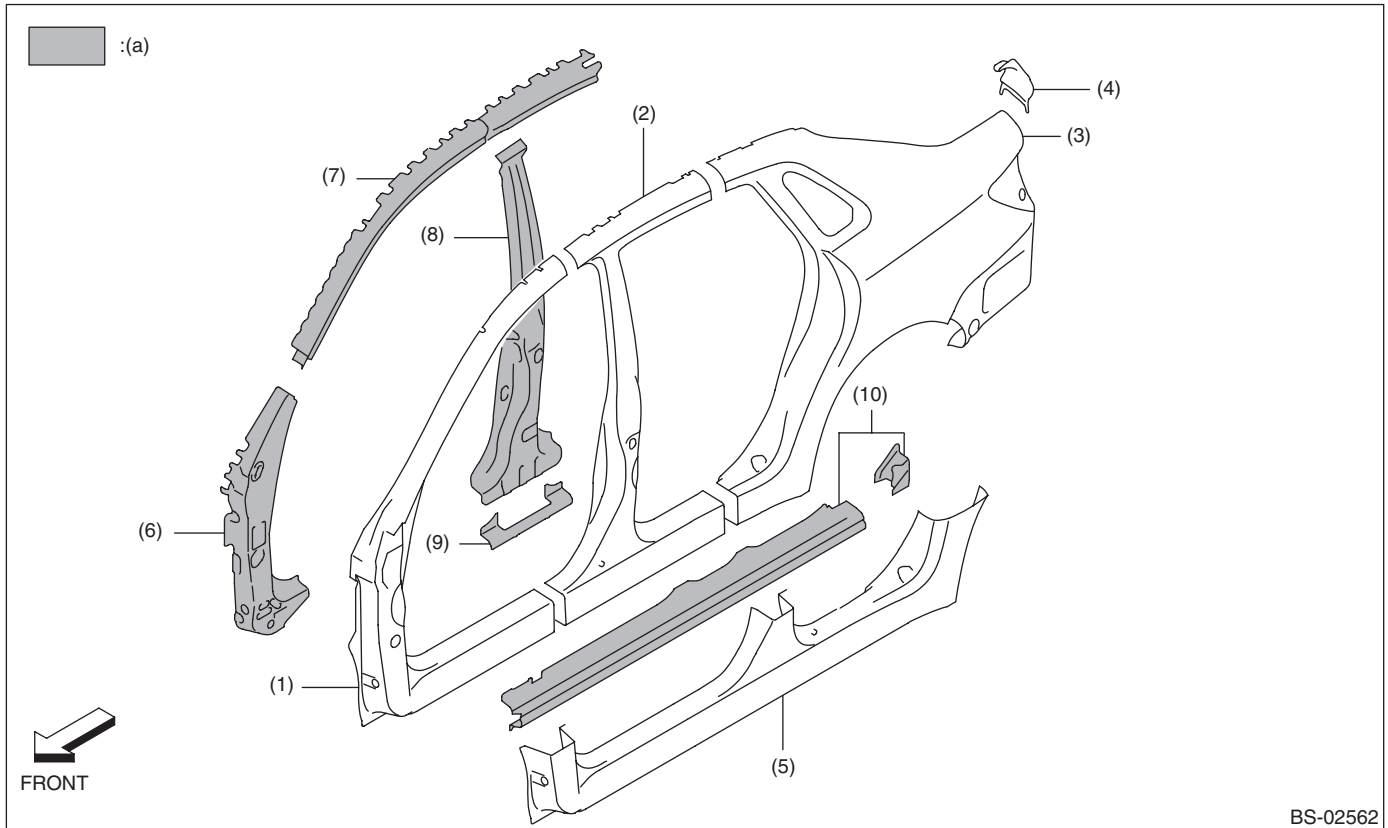
BS-02561

(a) High-strength steel

- | | | |
|-------------------------|--------------------------------------|------------------------------------|
| (1) Front pillar outer | (5) Rear quarter end | (9) Center pillar reinforcement |
| (2) Center pillar outer | (6) Side sill outer | (10) Patch side sill outer |
| (3) Rear quarter outer | (7) Front pillar reinforcement lower | (11) Side sill reinforcement outer |
| (4) D-pillar extension | (8) Side rail reinforcement | |

Panel Components

• 4 door



(a) High-strength steel

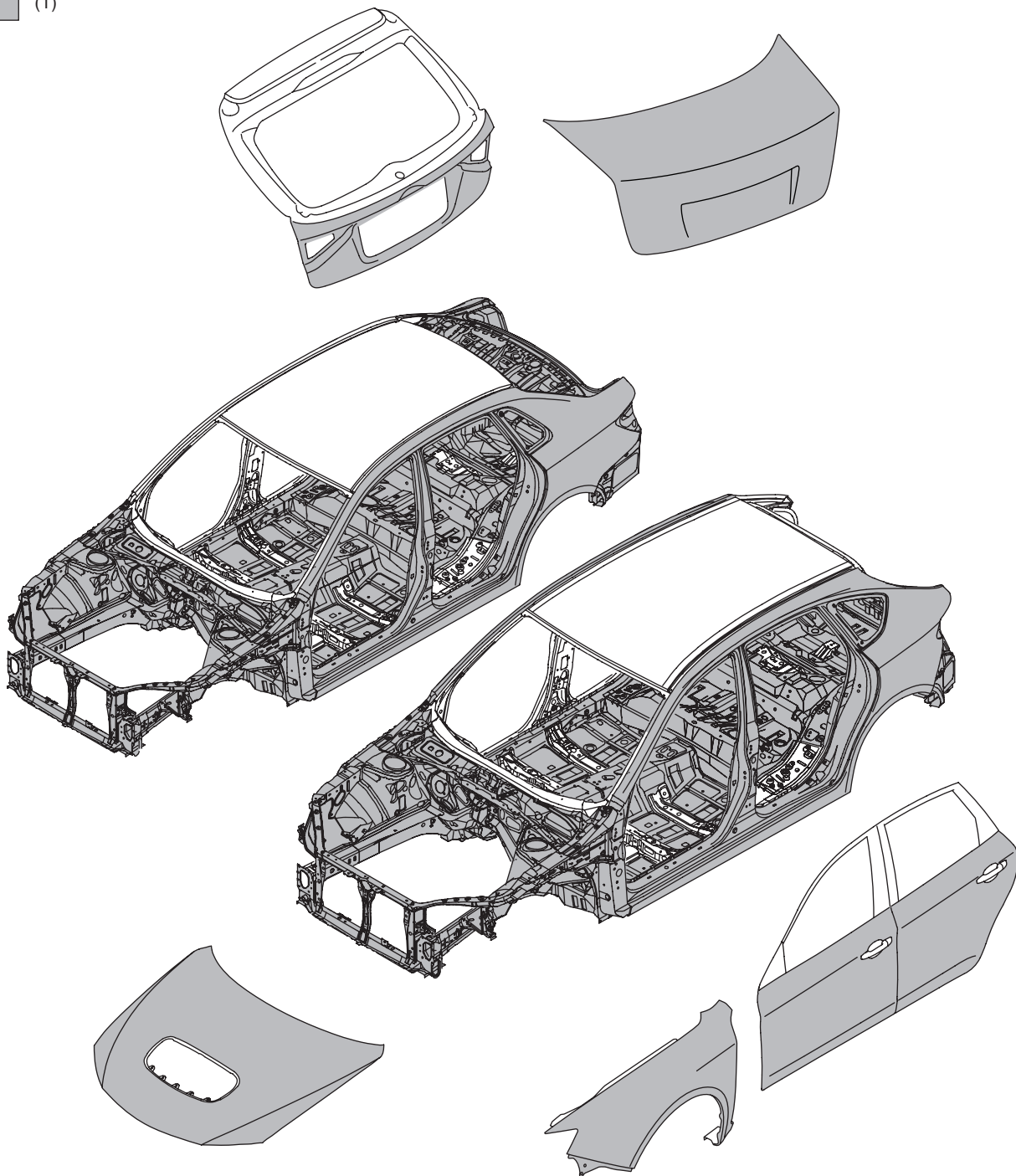
- (1) Front pillar outer
- (2) Center pillar outer
- (3) Rear quarter outer
- (4) Rear quarter end

- (5) Side sill outer
- (6) Front pillar reinforcement lower
- (7) Side rail reinforcement
- (8) Center pillar reinforcement

- (9) Patch side sill outer
- (10) Side sill reinforcement outer

3. Galvanized Sheet Metal

A: SPECIFICATION



BS-02657

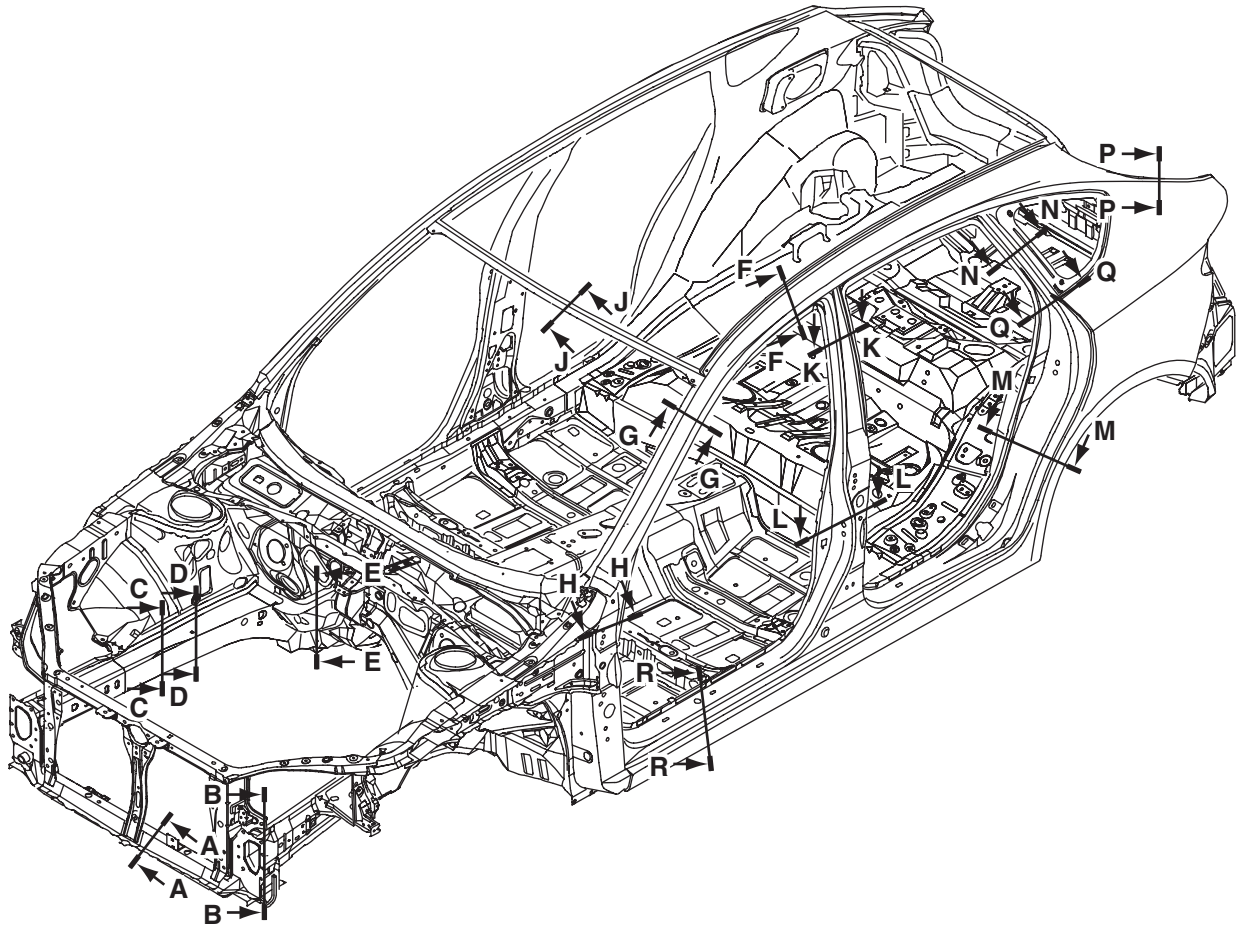
(1) Galvanized sheet metal (both sides)

The fuel flap consists of galvanized sheet metal.

4. Body Construction

A: SPECIFICATION

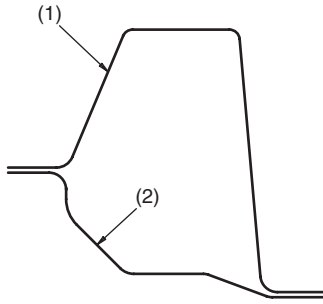
- Common parts for 5 door and 4 door



BS-02332

Body Construction

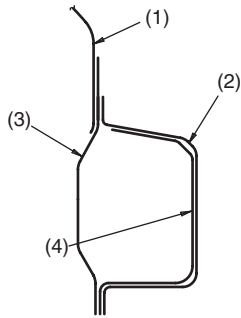
Cross section A — A



BS-00682

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

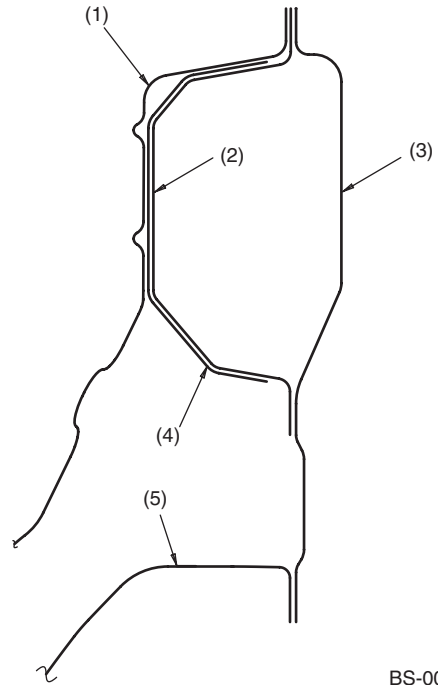
Cross section C — C



BS-00684

- (1) Front wheel apron
- (2) Front side frame front
- (3) Closing plate
- (4) Frame inner reinforcement A

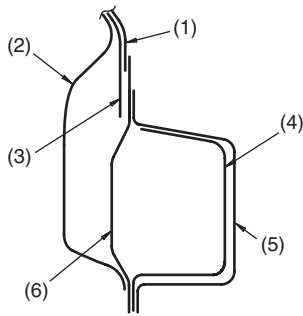
Cross section B — B



BS-00683

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

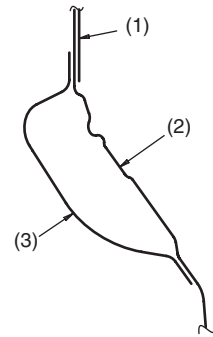
Cross section D — D



BS-00685

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

Cross section E — E

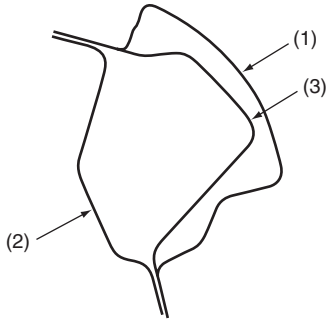


BS-00686

- (1) Cover toe board
- (2) Toe board
- (3) Toe board center crossmember

Body Construction

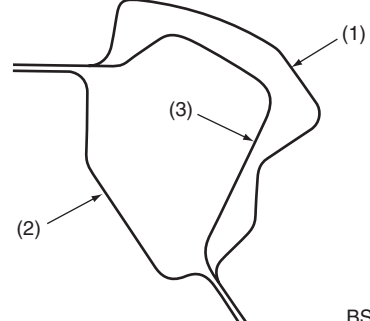
Cross section F — F



BS-02321

- (1) Outer panel side
- (2) Side rail inner
- (3) Side rail reinforcement front

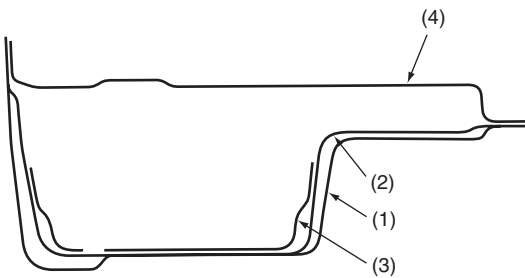
Cross section G — G



BS-02322

- (1) Outer panel side
- (2) Front pillar inner upper
- (3) Side rail reinforcement front

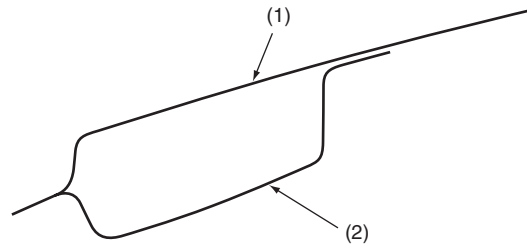
Cross section H — H



BS-02323

- (1) Outer panel side
- (2) Front pillar reinforcement
- (3) Front pillar hinge reinforcement
- (4) Front pillar inner upper

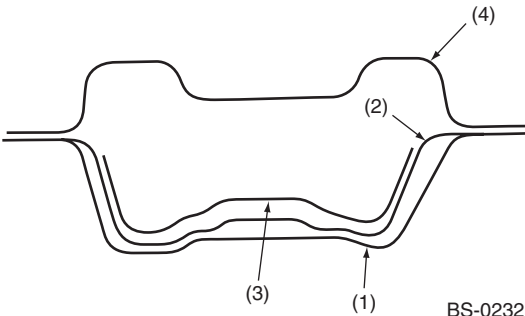
Cross section J — J



BS-02324

- (1) Roof panel
- (2) Front rail

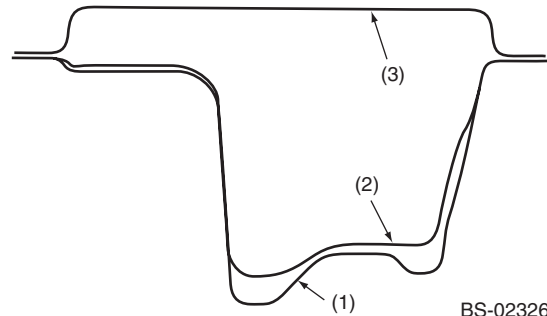
Cross section K — K



BS-02325

- (1) Outer panel side
- (2) Center pillar reinforcement
- (3) Center pillar reinforcement A
- (4) Center pillar inner

Cross section L — L

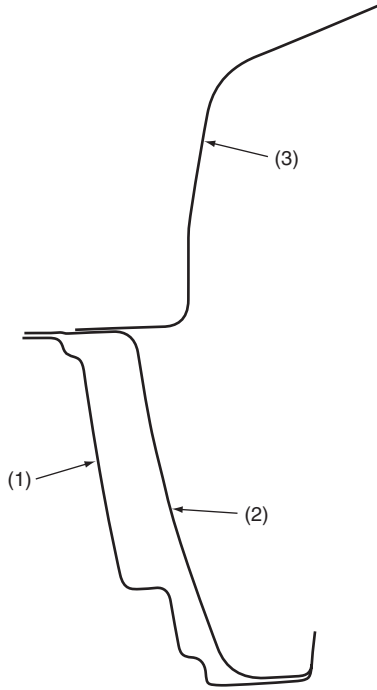


BS-02326

- (1) Outer panel side
- (2) Center pillar reinforcement
- (3) Center pillar inner

Body Construction

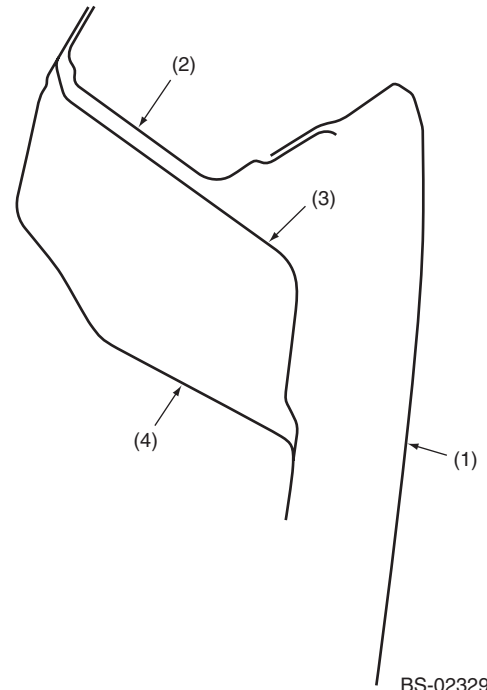
Cross section M — M



BS-02327

- (1) Outer panel side
- (2) Rear arch inner
- (3) Rear wheel apron

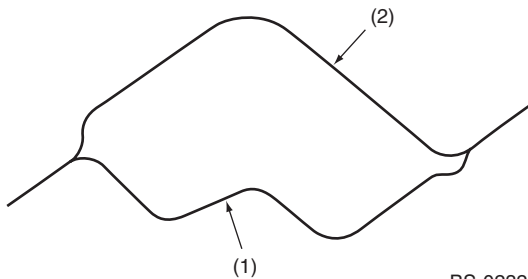
Cross section P — P



BS-02329

- (1) Outer panel side
- (2) Extension D-pillar
- (3) D-pillar reinforcement
- (4) D-pillar inner

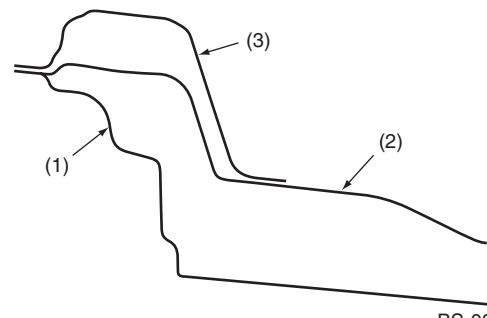
Cross section N — N



BS-02328

- (1) Outer panel side
- (2) Rear quarter panel inner

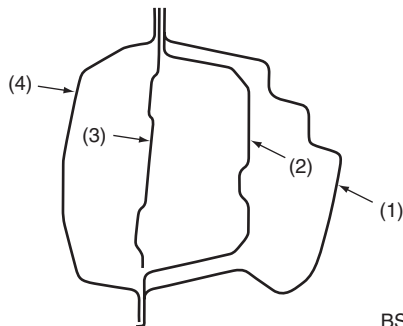
Cross section Q — Q



BS-02330

- (1) Outer panel side
- (2) Rear quarter panel inner
- (3) C-pillar reinforcement

Cross section R — R



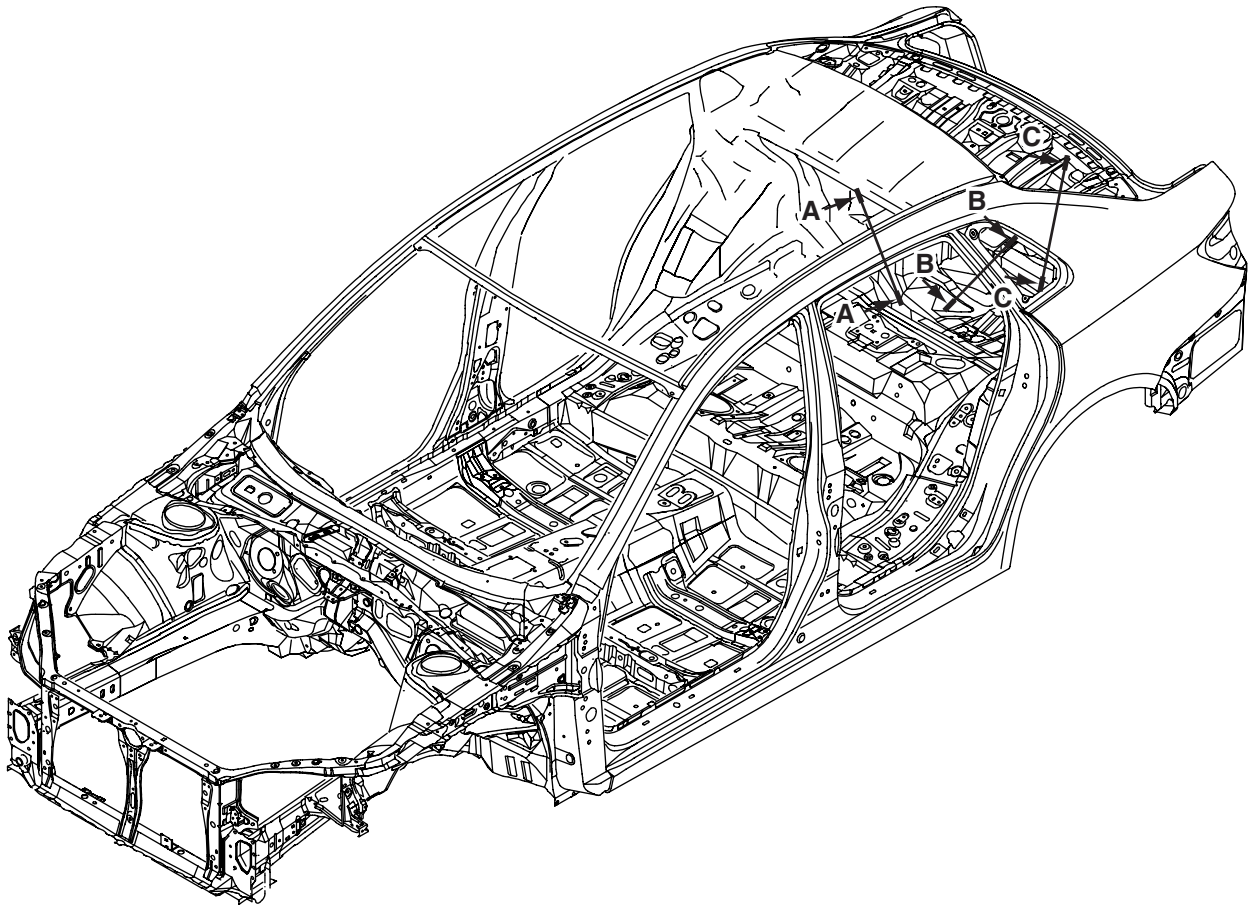
BS-02331

- (1) Outer panel side
- (2) Side sill outer reinforcement
- (3) Side sill reinforcement
- (4) Side sill inner front

SUBARU.

Body Construction

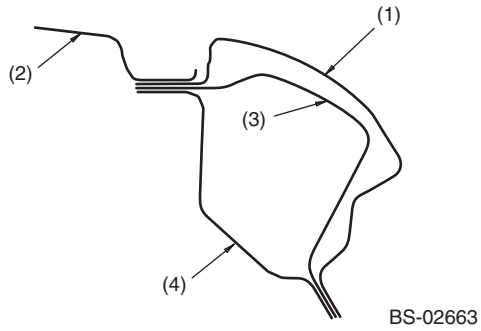
- Special 4 door parts



BS-02510

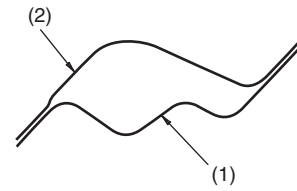
Body Construction

Cross section A — A



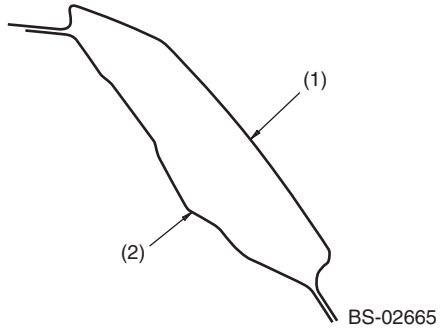
- (1) Outer panel side
- (2) Roof panel
- (3) Side rail reinforcement rear
- (4) Side rail inner

Cross section B — B



- (1) Outer panel side
- (2) Rear pillar inner

Cross section C — C



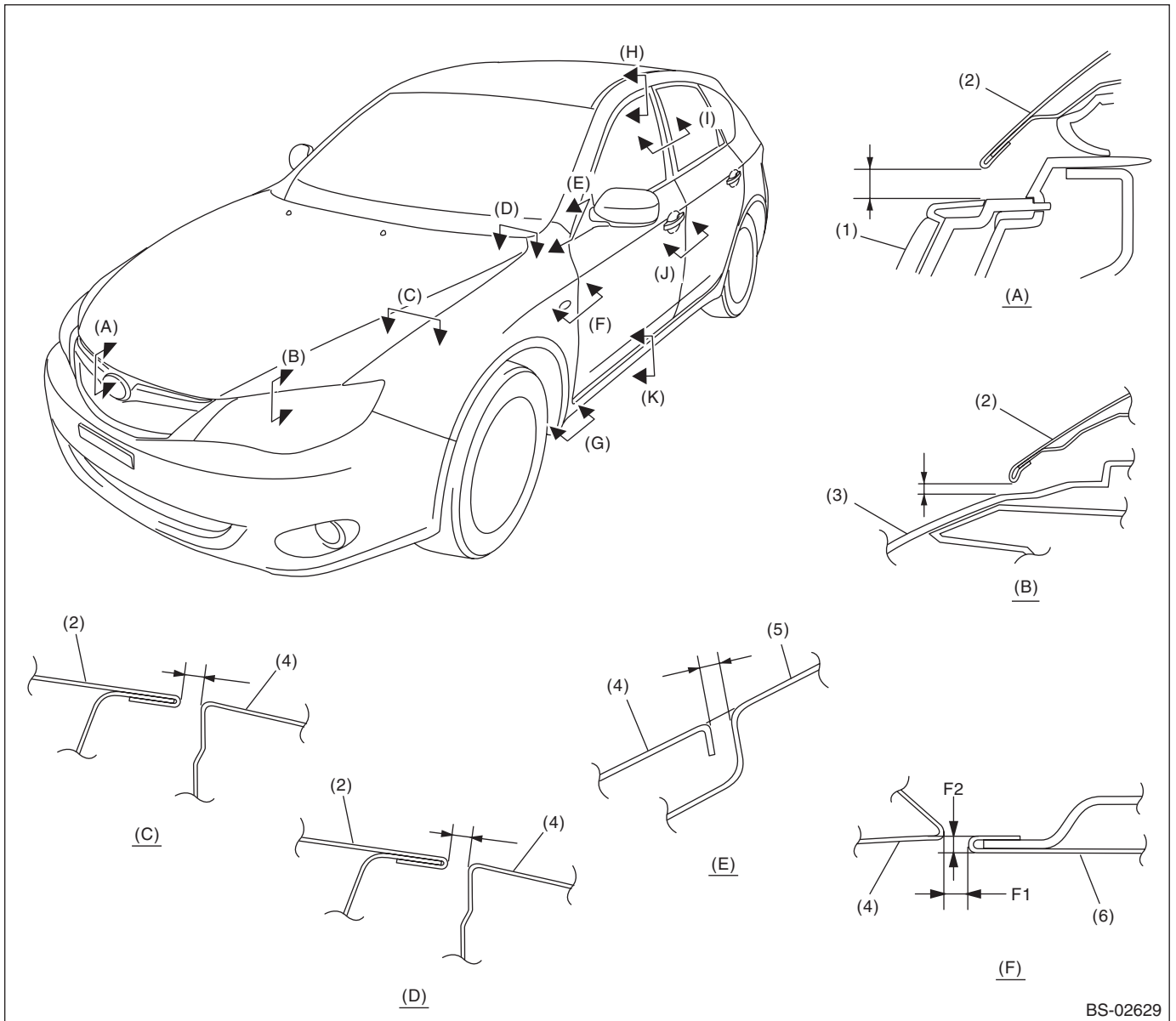
- (1) Outer panel side
- (2) Rear pillar inner

SUBARU.

5. Gauge Values for Fitting

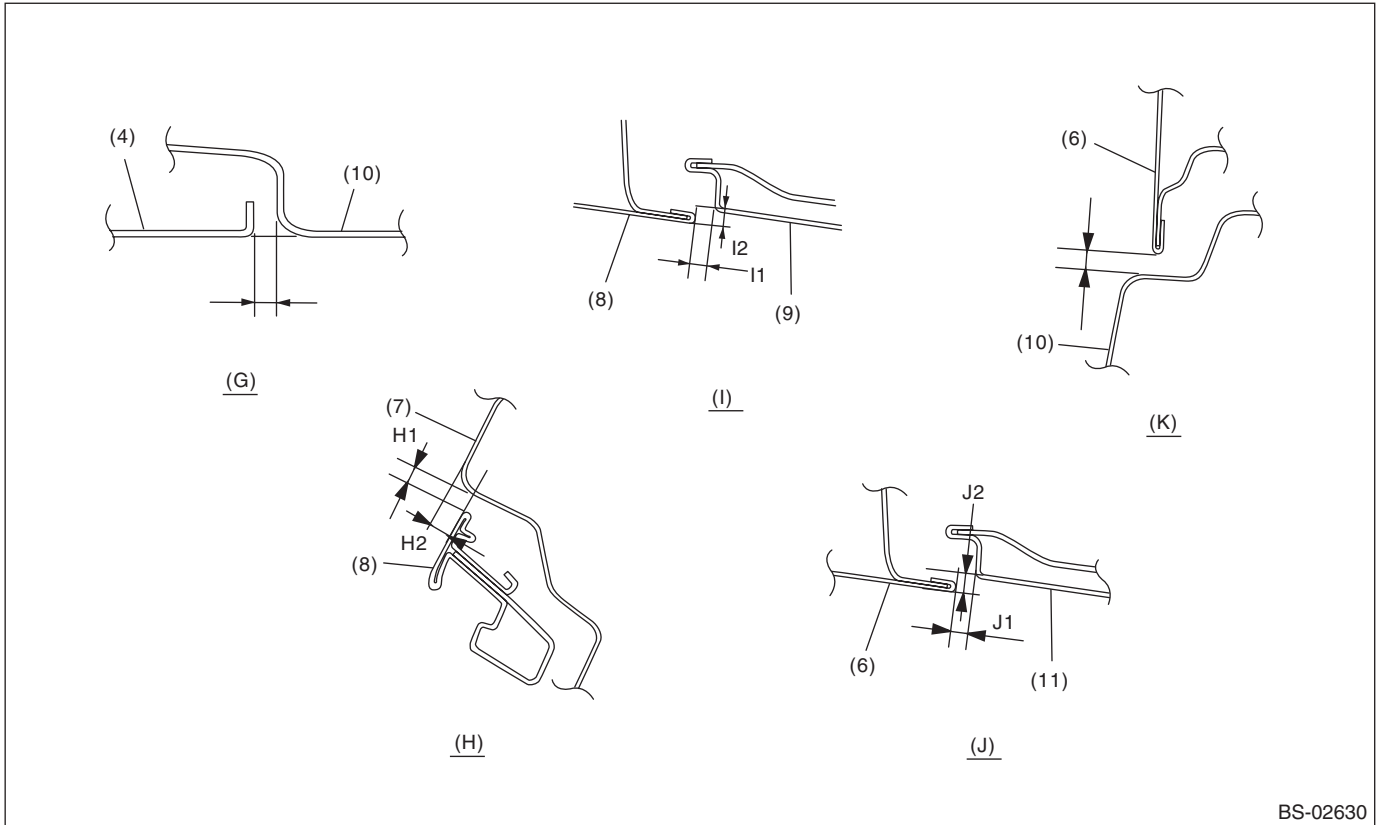
A: DIMENSIONS

1. FRONT



BS-02629

Gauge Values for Fitting



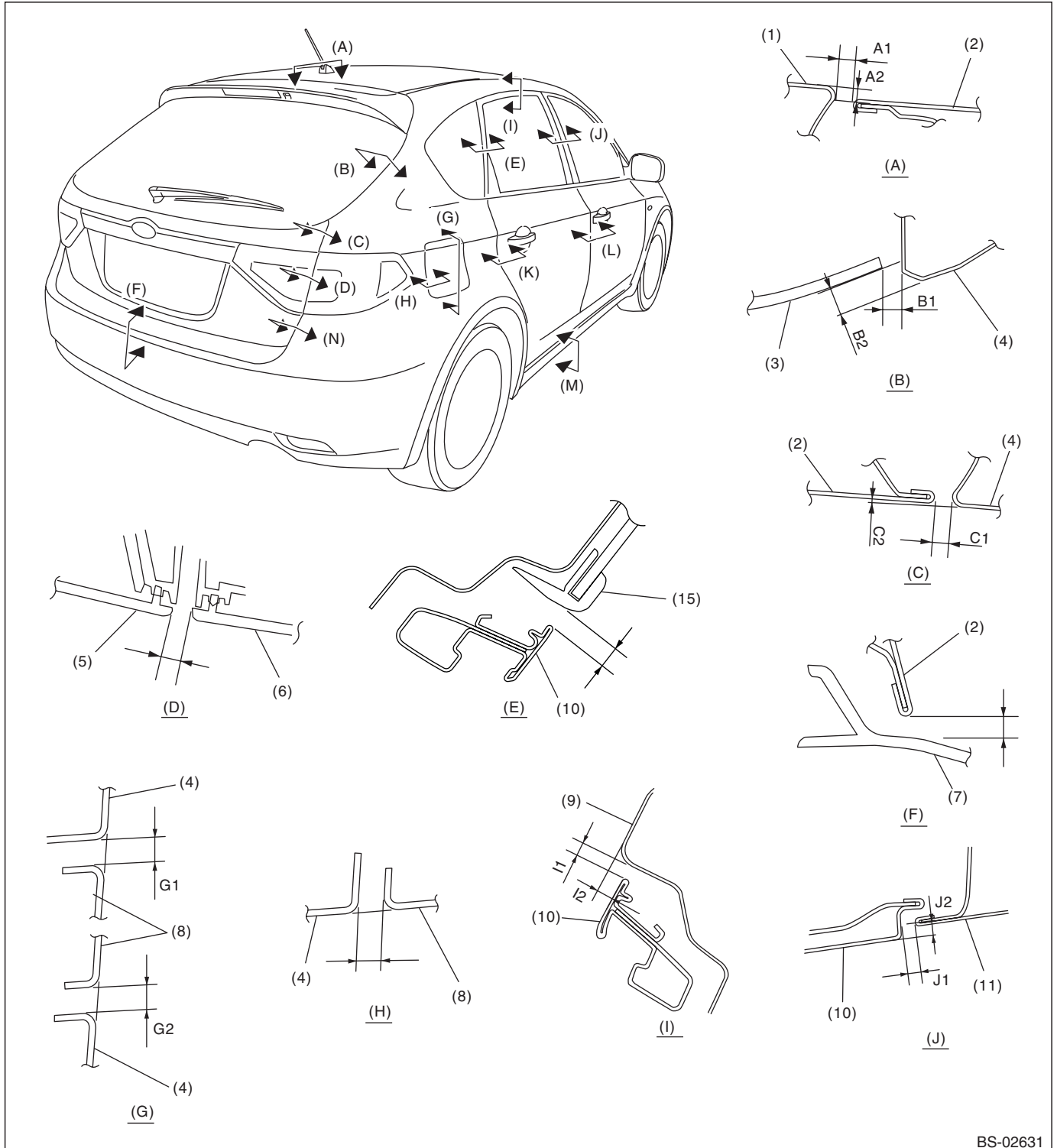
BS-02630

- | | | |
|------------------------|------------------------|----------------------|
| (1) Front grille | (5) Front pillar panel | (9) Rear door sash |
| (2) Front hood panel | (6) Front door panel | (10) Side sill panel |
| (3) Headlight | (7) Roof panel | (11) Rear door panel |
| (4) Front fender panel | (8) Front door sash | |

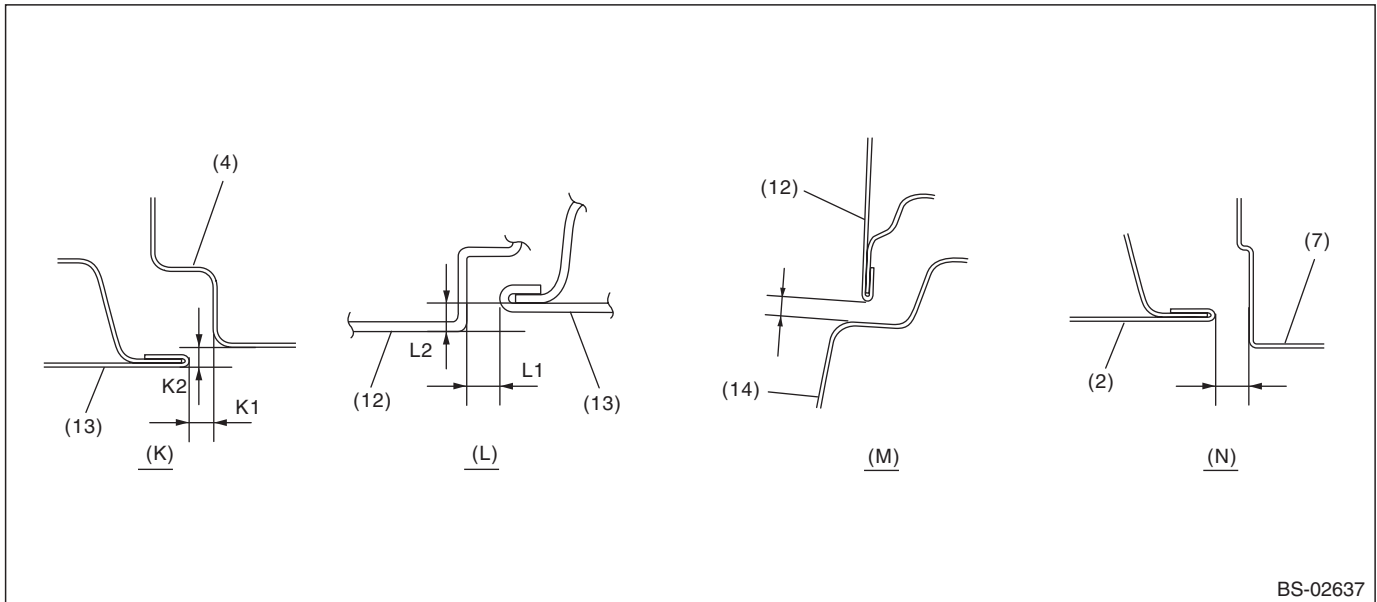
| Section | Part | Specification |
|---------|---|---|
| (A) | Between front hood panel to front grille | 6.0 ± 1.0 mm (0.23 ± 0.04 in) |
| (B) | Between front hood panel to headlight | 6.0 ± 1.0 mm (0.24 ± 0.04 in) |
| (C) | Between front hood panel to front fender panel | 3.5 ± 1.0 mm (0.14 ± 0.04 in) |
| (D) | Between front hood panel to front fender panel (only the rear end part) | $4.8 + 0.7 - 1.0$ mm ($0.14 + 0.03 - 0.04$ in) |
| (E) | Between front fender panel to front pillar panel | 3.0 ± 1.0 mm (0.12 ± 0.04 in) |
| (F) | Between front fender panel to front door panel | F1: 4.0 ± 1.0 mm (0.16 ± 0.04 in) F2: $0 + 0.5 - 1.0$ mm ($0 + 0.02 - 0.04$ in) (in regard to the fender) |
| (G) | Between front fender panel to side sill panel | 3.0 ± 1.0 mm (0.12 ± 0.04 in) |
| (H) | Between roof panel to front door sash | H1: 5.0 ± 1.0 mm (0.20 ± 0.04 in) H2: 3.8 ± 1.0 mm (0.15 ± 0.04 in) |
| (I) | Between front door sash to rear door sash | I1: 5.5 ± 1.0 mm (0.22 ± 0.04 in) I2: $0 + 1.0 - 0.5$ mm ($0 + 0.04 - 0.02$ in) (in regard to the rear door sash) |
| (J) | Between front door panel to rear door panel | J1: 4.5 ± 1.0 mm (0.18 ± 0.04 in) J2: $0 + 1.0 - 0.5$ mm ($0 + 0.04 - 0.02$ in) (in regard to the rear door panel) |
| (K) | Between front door panel to side sill panel | 6.0 ± 1.0 mm (0.23 ± 0.04 in) |

Gauge Values for Fitting

2. REAR (5 DOOR)



Gauge Values for Fitting



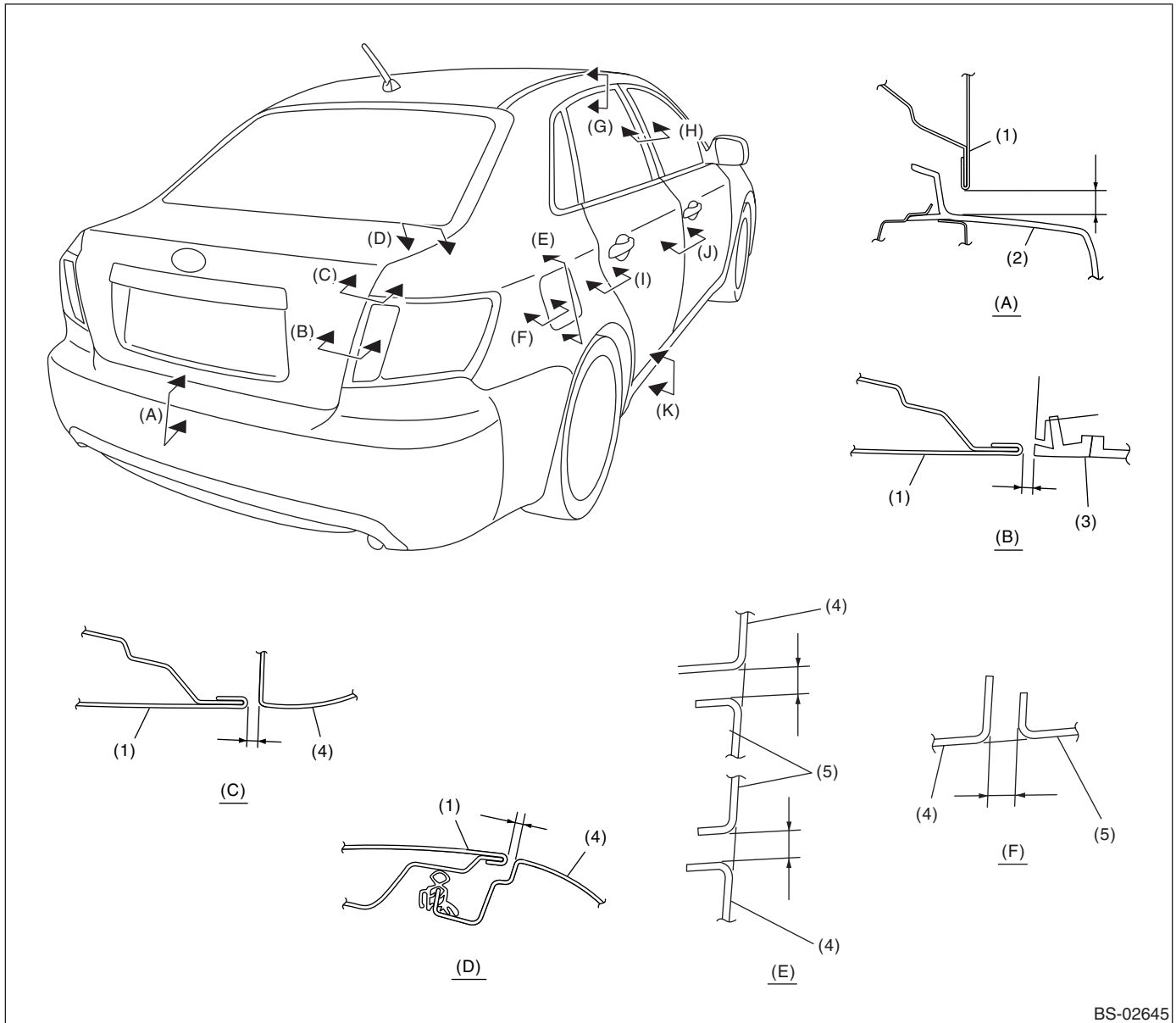
BS-02637

- | | | |
|-------------------------|----------------------------|----------------------------------|
| (1) Roof panel | (6) Rear combination light | (11) Front door sash |
| (2) Rear gate panel | (7) Rear bumper | (12) Rear door panel |
| (3) Rear gate glass | (8) Fuel filler flap lid | (13) Front door panel |
| (4) Rear quarter panel | (9) Roof panel | (14) Side sill panel |
| (5) Rear finisher light | (10) Rear door sash | (15) Rear quarter glass moulding |

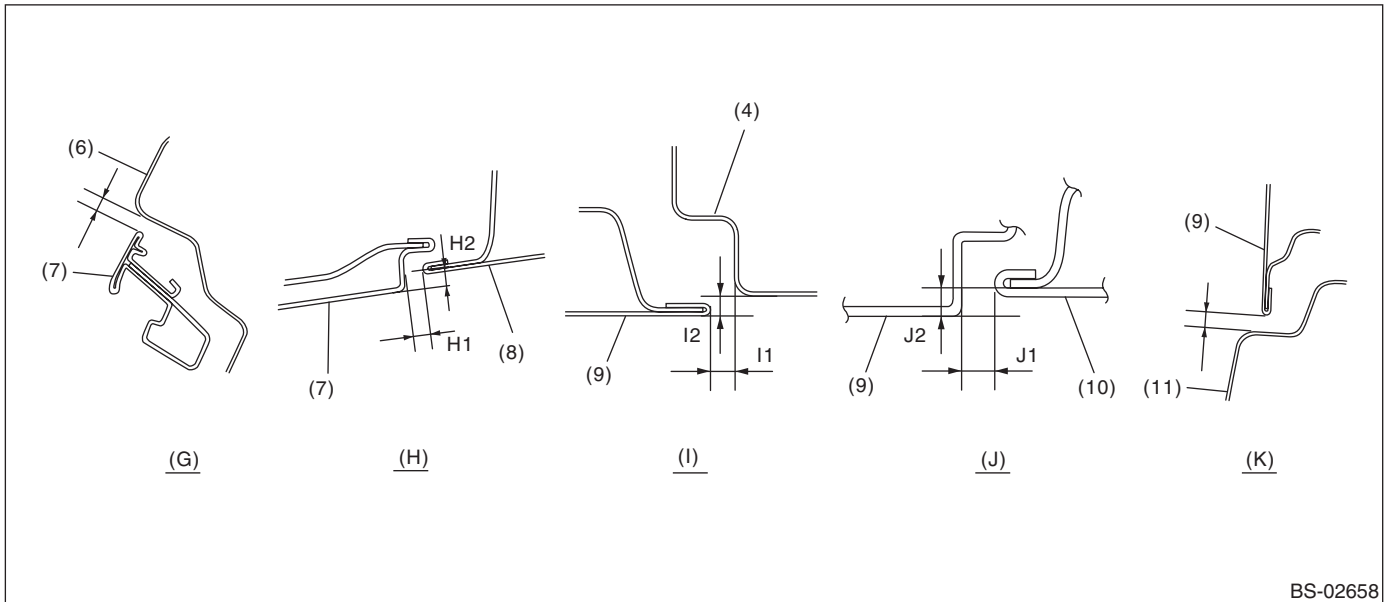
| Section | Part | Specification |
|---------|---|--|
| (A) | Between roof panel to rear gate panel | A1: 6.0+1.0–0.5 mm (0.23+0.04–0.02 in) A2: 1.0±1.0 mm (0.04±0.04 in) |
| (B) | Between rear gate glass to rear quarter panel | B1: 5.0±1.5 mm (0.20±0.06 in) B2: 6.7±1.5 mm (0.26±0.06 in) |
| (C) | Between rear gate panel to rear quarter panel | C1: 4.6±1.0 mm (0.18±0.04 in) C2: 0.5±1.0 mm (0.02±0.04 in) |
| (D) | Between rear combination light to rear finisher light | 5.0±1.0 mm (0.20±0.04 in) |
| (E) | Between rear door sash to rear quarter glass moulding | 7.0±1.0 mm (0.28±0.04 in) |
| (F) | Between rear gate panel to rear bumper | 8.0±1.0 mm (0.31±0.04 in) |
| (G) | Between rear quarter panel to fuel filler flap lid | G1: 3.5±0.5 mm (0.14±0.06 in) G2: 4.0±0.5 mm (0.18±0.06 in) |
| (H) | Between rear quarter panel to fuel filler flap lid | 3.5±0.5 mm (0.14±0.02 in) |
| (I) | Between roof panel to rear door sash | I1: 5.0±1.0 mm (0.20±0.04 in) I2: 3.8±1.0 mm (0.15±0.04 in) |
| (J) | Between rear door sash to front door sash | J1: 5.5±1.0 mm (0.22±0.04 in) J2: 0+0.5–1.0 mm (0+0.02–0.04 in) (in regard to the front door sash) |
| (K) | Between rear door panel to rear quarter panel | K1: 4.0±1.0 mm (0.16±0.04 in) K2: 0+1.0–0.5 mm (0+0.04–0.02 in) (in regard to the rear quarter panel) |
| (L) | Between front door panel to rear door panel | L1: 4.5±1.0 mm (0.18±0.04 in) L2: 0+0.5–1.0 mm (0+0.02–0.04 in) (in regard to the front door panel) |
| (M) | Between rear door panel to side sill panel | 6.0±1.0 mm (0.24±0.04 in) |
| (N) | Between rear gate panel to rear bumper | 5.0±1.0 mm (0.20±0.04 in) |

Gauge Values for Fitting

3. REAR (4 DOOR)



Gauge Values for Fitting



BS-02658

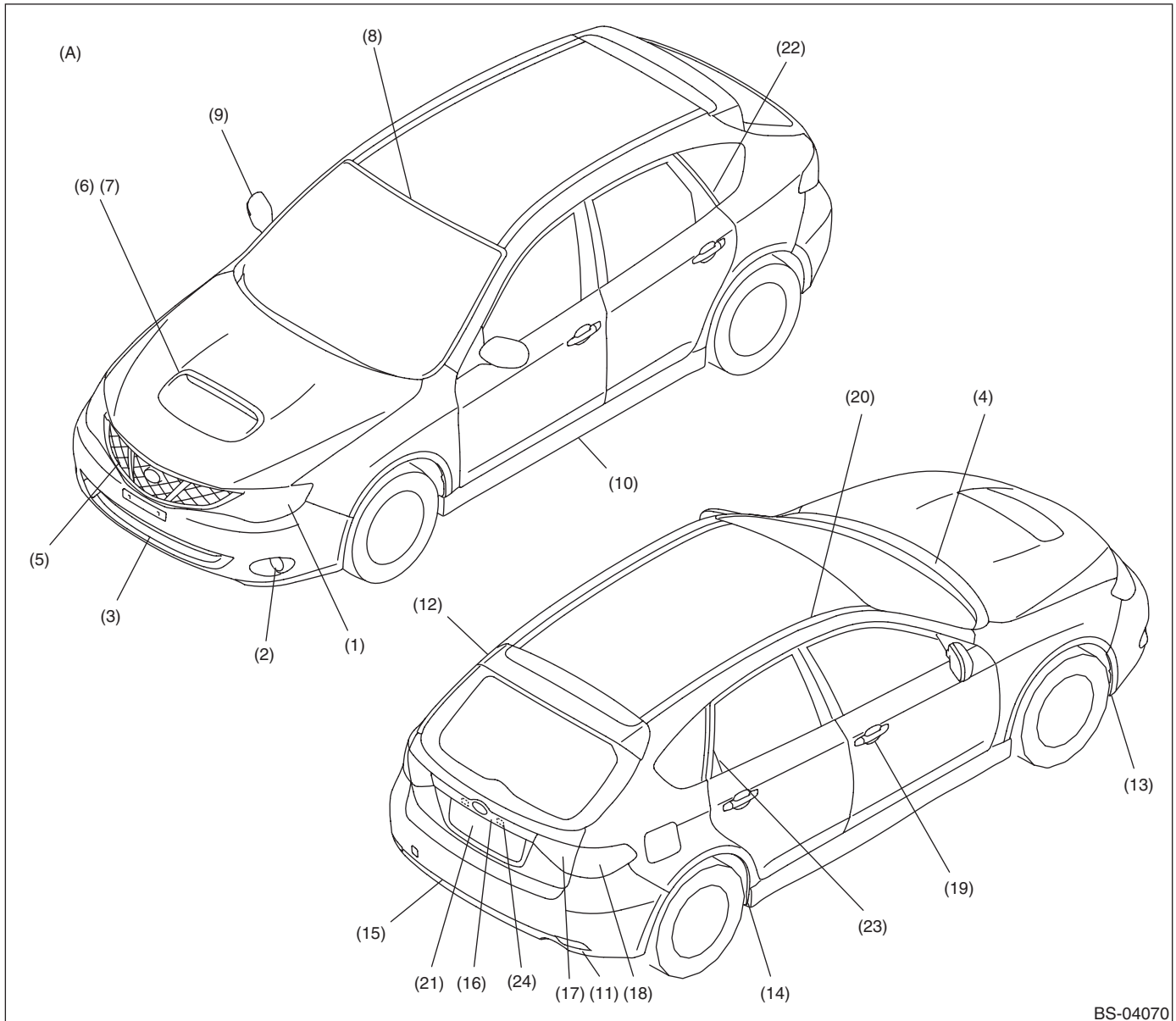
- | | | |
|----------------------------|--------------------------|-----------------------|
| (1) Trunk panel | (5) Fuel filler flap lid | (9) Rear door panel |
| (2) Rear bumper | (6) Roof panel | (10) Front door panel |
| (3) Rear combination light | (7) Rear door sash | (11) Side sill panel |
| (4) Rear quarter panel | (8) Front door sash | |

| Section | Part | Specification |
|---------|--|--|
| (A) | Between trunk panel to rear bumper face | 9.0±1.0 mm (0.35±0.04 in) |
| (B) | Between trunk panel to rear combination light | 3.5±1.0 mm (0.14±0.04 in) |
| (C) | Between trunk panel to rear quarter panel | 3.5±1.0 mm (0.14±0.04 in) |
| (D) | Between trunk panel to rear quarter panel | 3.5±1.0 mm (0.14±0.04 in) |
| (E) | Between rear quarter panel to fuel filler flap lid | 3.5±0.5 mm (0.14±0.02 in) |
| (F) | Between rear quarter panel to fuel filler flap lid | 3.5±0.5 mm (0.14±0.02 in) |
| (G) | Between roof panel to rear door sash | 5.0±1.0 mm (0.20±0.04 in) |
| (H) | Between rear door sash to front door sash | H1: 5.5±1.0 mm (0.22±0.04 in) H2: 0+0.5–1.0 mm (0+0.02–0.04 in) (in regard to the front door sash) |
| (I) | Between rear door panel to rear quarter panel | I1: 4.0±1.0 mm (0.16±0.04 in) I2: 0+1.0–0.5 mm (0+0.04–0.02 in) (in regard to the rear quarter panel) |
| (J) | Between front door panel to rear door panel | J1: 4.5±1.0 mm (0.18±0.04 in) J2: 0+0.5–1.0 mm (0+0.02–0.04 in) (in regard to the front door panel) |
| (K) | Between rear door panel to side sill panel | 6.0±1.0 mm (0.24±0.04 in) |

6. Plastic Parts and Materials

A: SPECIFICATION

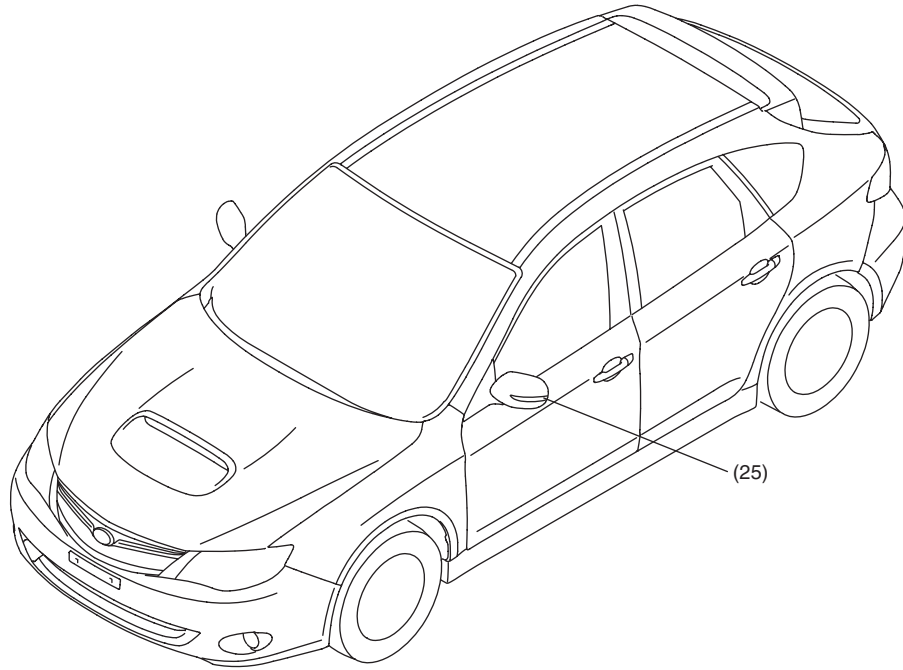
- Special 5 door parts and common parts for 5 door and 4 door



(A) Except for side turn light built-in door mirror model

- | | | |
|-----------------------------------|----------------------------|------------------------------|
| (1) Headlight | (9) Door mirror | (17) Backup light |
| (2) Front fog light | (10) Side spoiler | (18) Rear combination light |
| (3) Front bumper | (11) Rear reflex reflector | (19) Door handle |
| (4) Cowl panel | (12) Rear spoiler | (20) Roof moulding |
| (5) Front grille | (13) Front mudguard | (21) Rear gate opener switch |
| (6) Turbo grille (turbo model) | (14) Air flap rear | (22) Rear quarter moulding |
| (7) Hood duct inner (turbo model) | (15) Rear bumper | (23) Rear door gusset cover |
| (8) Front window moulding | (16) Rear gate garnish | (24) License light |

(B)



(25)

BS-04071

(B) Side turn light built-in door mirror model

(25) Side turn light

Plastic Parts and Materials

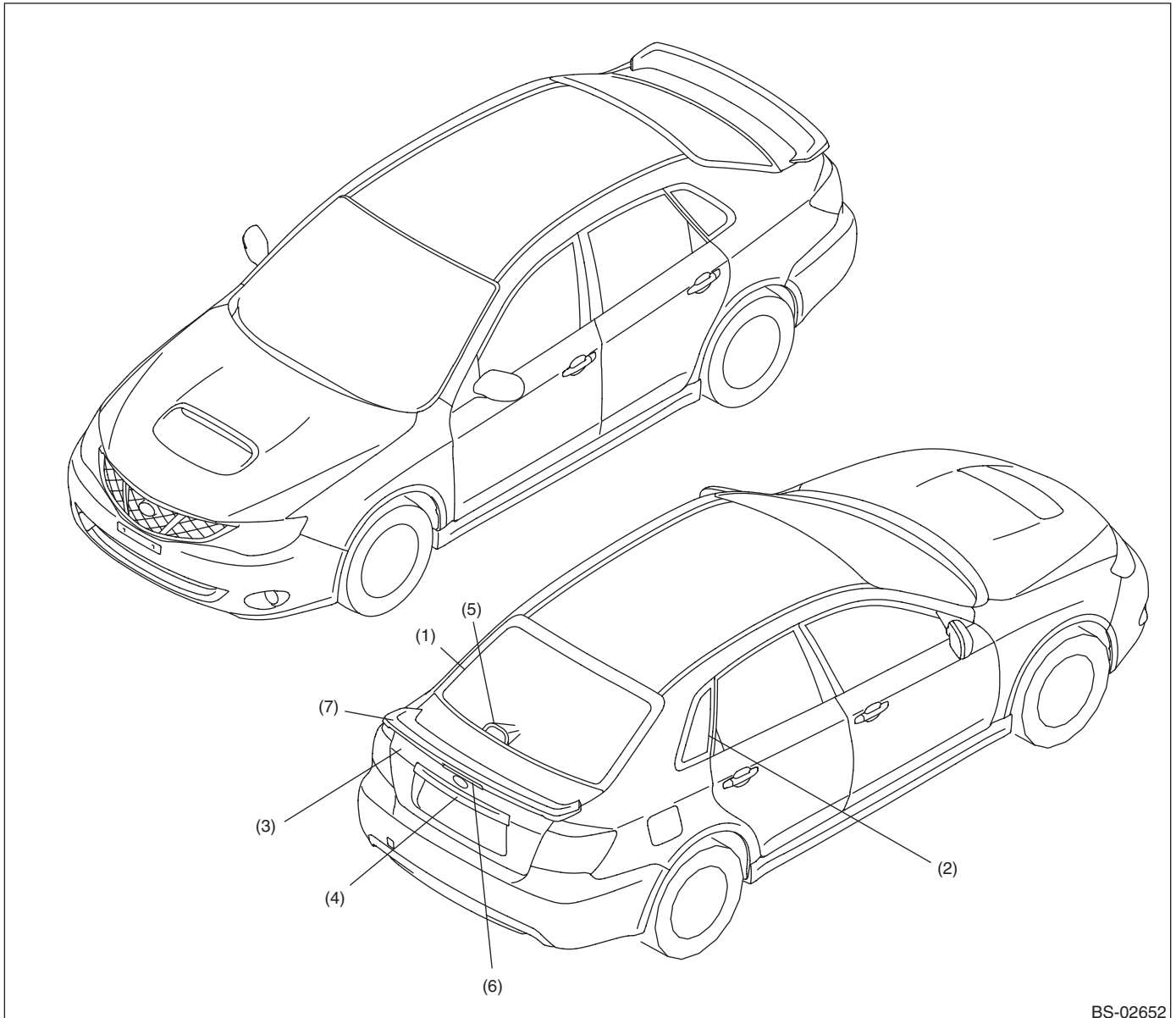
| No. | Part name | | | Material |
|------|----------------------------|-------------------------|---------------|-----------|
| (1) | Headlight | Lens | | PC |
| | | Housing | | PP |
| | | Extension | | PBT + PET |
| (2) | Front fog light (standard) | Bracket (housing) | | PP + GF40 |
| (3) | Front bumper | Face | | PP |
| | | Fog light cover | | PP |
| | | Hook cover | | PP |
| | | Center lower bracket | | PP |
| | | Side bracket | | POM |
| | | Corner bracket | | PP + GF20 |
| (4) | Cowl panel | Body, side | | PP |
| (5) | Front grille | Grille | | AES |
| | | Moulding | | ABS |
| (6) | Turbo grille | | | PA/PPE |
| (7) | Hood duct inner | Upper | | PP |
| | | Lower | | EPDM |
| (8) | Front window moulding | | | PVC |
| (9) | Door mirror | Body | | AES |
| | | Inner cover | | AES |
| | | Outer cover | | ABS |
| | | Mirror holder | | PP |
| (10) | Side spoiler | | | PP |
| (11) | Rear reflex reflector | Lens | | PMMA |
| | | Housing | | PC |
| (12) | Rear spoiler | Body | | ABS |
| | | High mount lens | | PMMA |
| | | High mount housing | | ABS |
| (13) | Front mudguard | Body | | PE |
| | | Air flap | | PE |
| (14) | Air flap rear | | | PE |
| (15) | Rear bumper | Face | | PP |
| (16) | Rear gate garnish | | | ABS |
| (17) | Backup light | Lens | | PMMA |
| | | Housing | | ASA |
| (18) | Rear combination light | Lens | | PMMA |
| | | Housing | | ASA |
| | | Reflector | | PC |
| | | Reflex reflector | | PMMA |
| (19) | Door handle | Standard model | Handle | PC + PBT |
| | | Model with smart opener | Handle body | PC + PBT |
| | | | Antenna cover | PC + PET |
| | | End cover | | PC + PBT |
| (20) | Roof moulding | | | PVC |
| (21) | Rear gate opener switch | | | PP + GF35 |
| (22) | Rear quarter moulding | | | AES |
| (23) | Rear door gusset cover | | | AES |
| (24) | License light | Lens | | PC |
| | | Housing | | PC |
| (25) | Side turn light | Lens | | PMMA |
| | | Housing | | PC |
| | Under cover | Body | | PP |

Plastic Parts and Materials

| No. | Part name | | Material |
|-----|--------------|-----------|----------|
| | Splash board | | PP |
| | Rear wiper | Blade | PBT |
| | | Arm | PET |
| | | Arm cover | PBT |

Plastic Parts and Materials

- Special 4 door parts



BS-02652

- | | | |
|--------------------------|--|------------------|
| (1) Rear window moulding | (4) License light | (7) Rear spoiler |
| (2) Six light moulding | (5) High mount stop light (indoor type) | |
| (3) Trunk garnish | (6) High mount stop light (integrated in the rear spoiler) | |

For the common parts for 5-door model, refer to the figure "Special 5 door parts and common parts for 5 door and 4 door" on page 36.

Plastic Parts and Materials

| No. | Part name | | Material |
|-----|--|-----------|-----------|
| (1) | Rear window moulding | | EPDM |
| (2) | Six light moulding | | PVC |
| (3) | Trunk garnish | | ABS |
| (4) | License light | Lens | PC |
| | | Housing | PBT + PET |
| (5) | High mount stop light (indoor type) | Lens | PC |
| | | Case | PP |
| | | Reflector | PBT + PET |
| (6) | High mount stop light (integrated in the rear spoiler) | Lens | PMMA |
| | | Housing | ABS |
| (7) | Rear spoiler | Body | ABS |
| | Rear wiper | Blade | PBT |
| | | Arm | PET |
| | | Arm cover | PBT |

List of Plastic Material Notations

7. List of Plastic Material Notations

A: SPECIFICATION

| Notation symbol | Material name | Notation symbol | Material name |
|-----------------|---|-----------------|---|
| ABS | ABS resin (acrylonitrile/butadiene/styrene/resin) | PMMA | Polymethyl methacrylate |
| AES | Acrylonitrile/ethylene/styrene | POM | Polyacetal |
| ASA | Acrylonitrile/styrene/acrylate | PP | Polypropylene |
| EPDM | Ethylene/propylene/dien rubber | PP-GF20 | Polypropylene (20% glass fiber content) |
| PA/PPE | Noryl Nylon | PP-GF30 | Polypropylene (30% glass fiber content) |
| PBT | Poly (butylene terephthalate) | PP-GF40 | Polypropylene (40% glass fiber content) |
| PC | Polycarbonate | PVC | Polyvinyl chloride |
| PE | Polyethylene | TPO | Thermoplastic olefine |
| PET | Polyethylene terephthalate | UP | Unsaturated polyester resin |

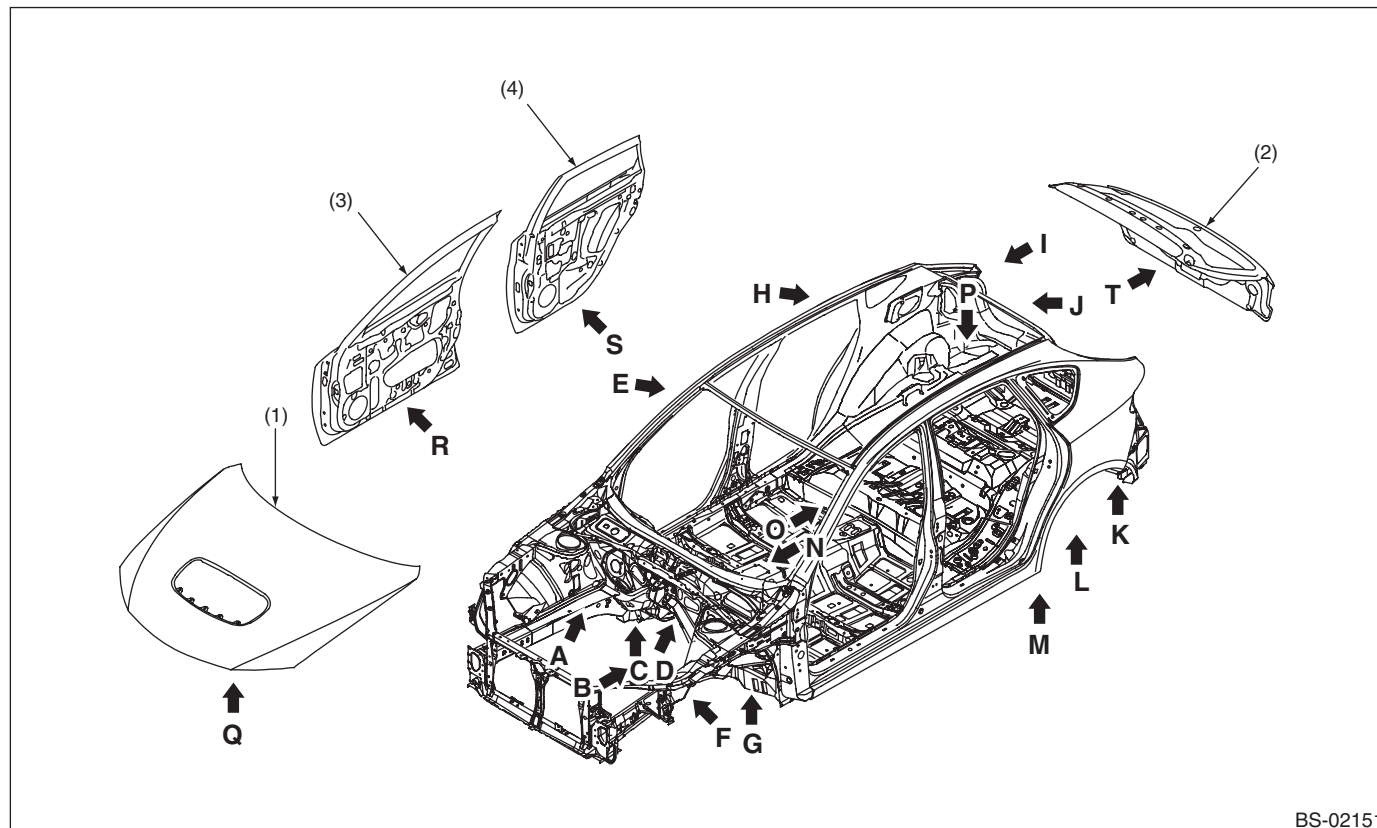
8. Body Sealing

A: SPECIFICATION

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

— : Sealer application location

- **Common parts for 5 door and 4 door**



(1) Front hood

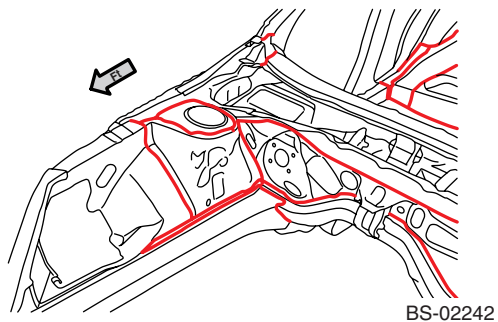
(2) Rear gate

(3) Front door

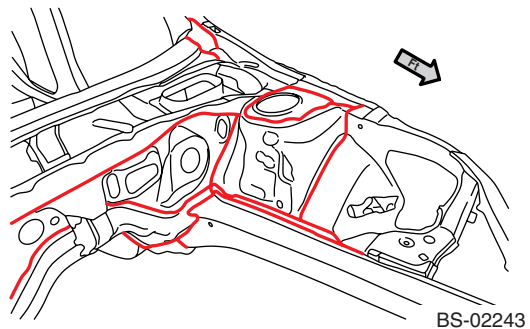
(4) Rear door

Body Sealing

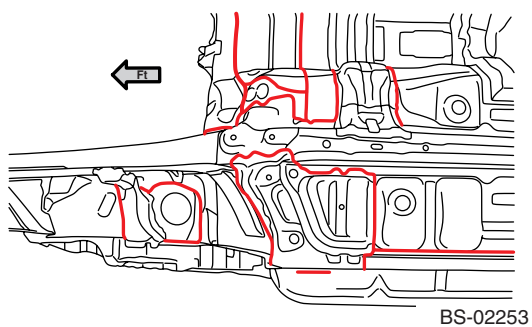
View A



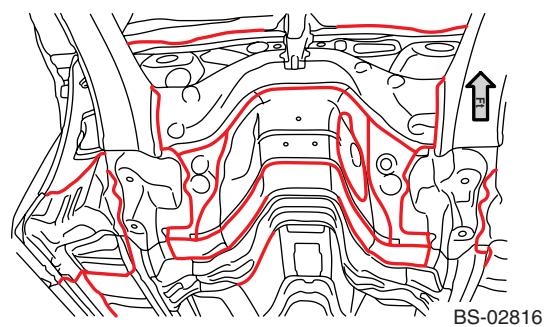
View B



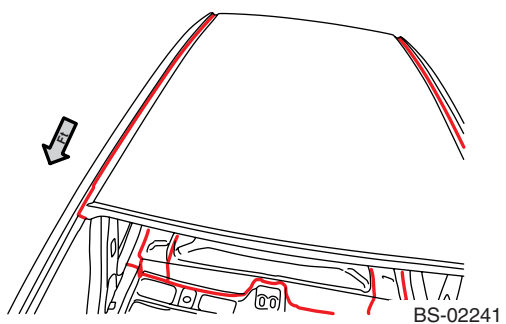
View C



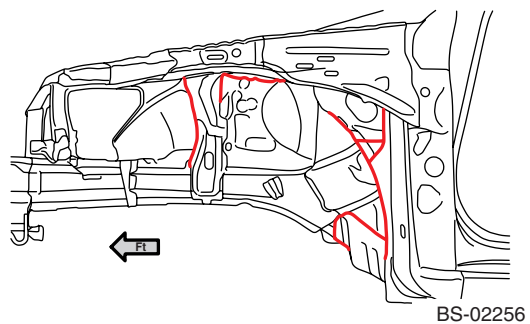
View D



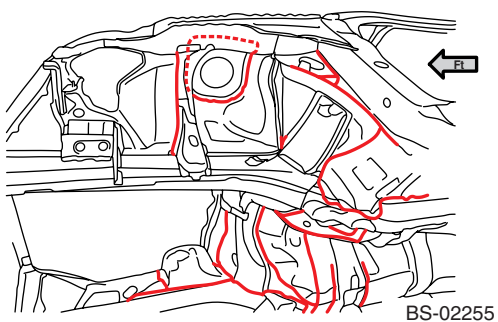
View E



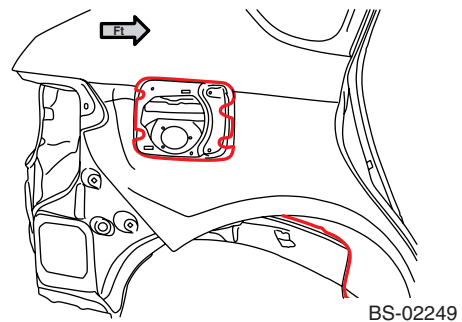
View F



View G

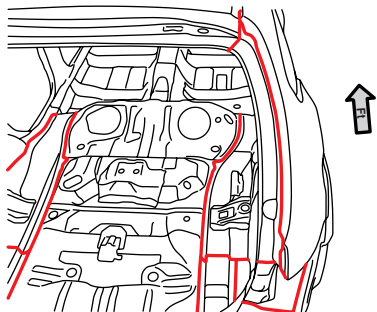


View H



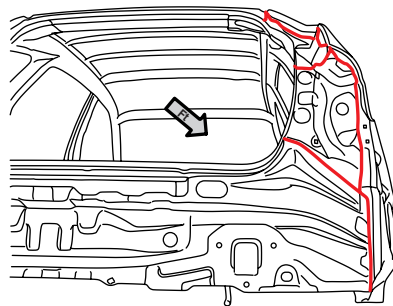
Body Sealing

View I



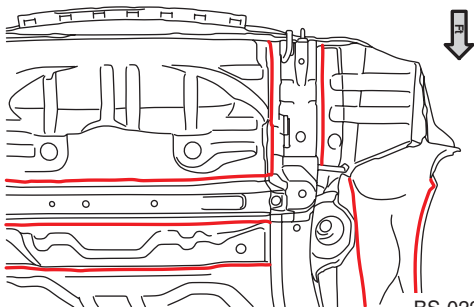
BS-02247

View J



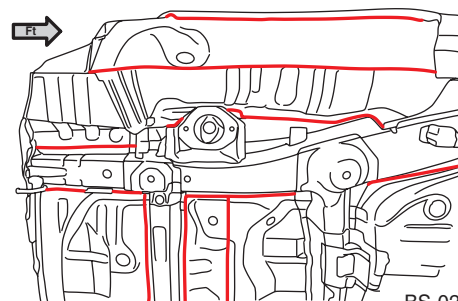
BS-02248

View K



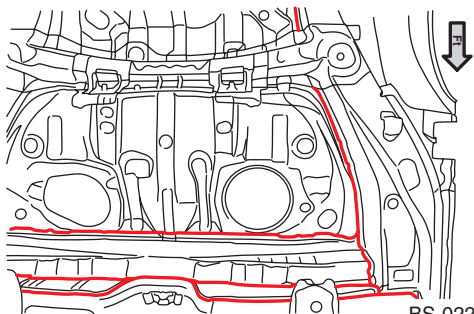
BS-02251

View L



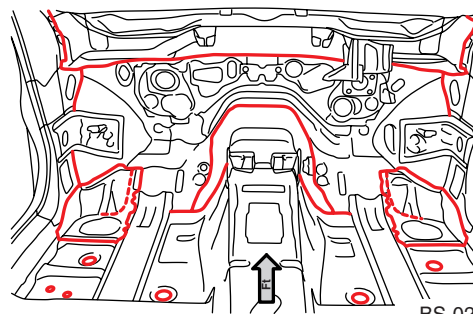
BS-02250

View M



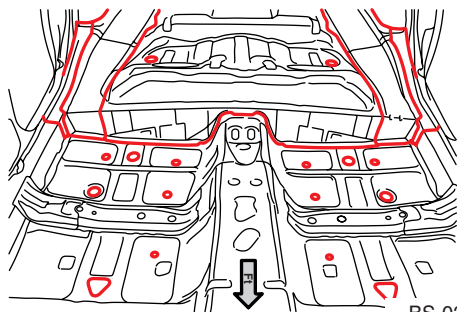
BS-02252

View N



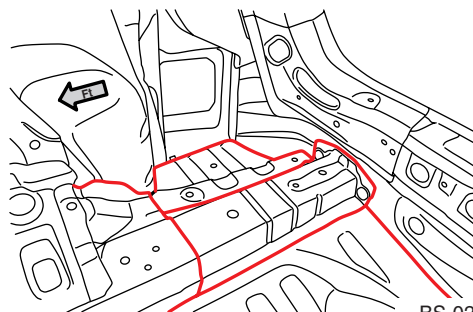
BS-02244

View O



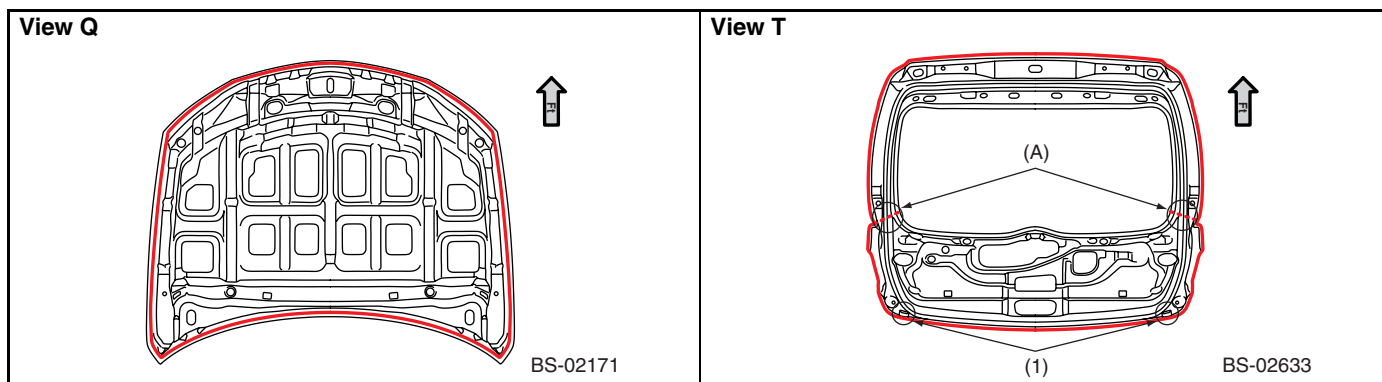
BS-02245

View P



BS-02246

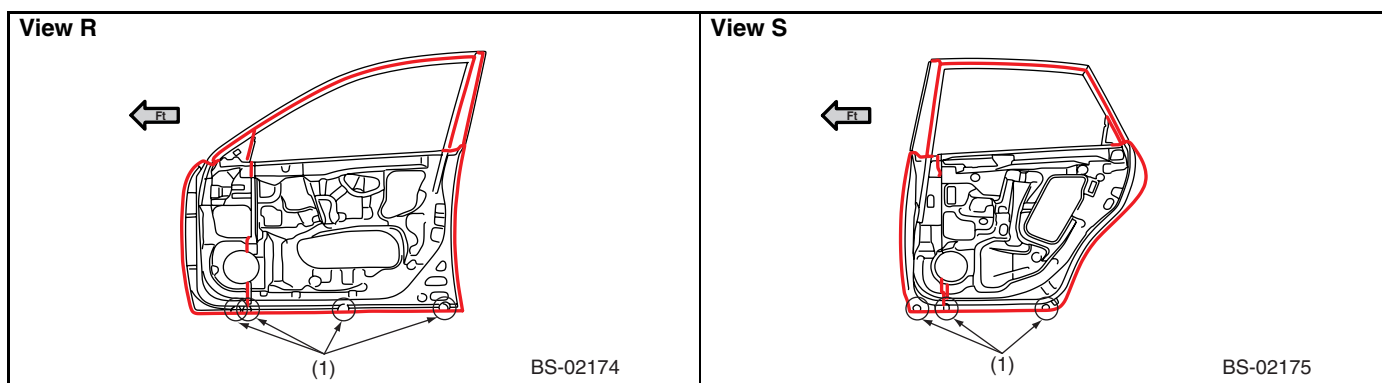
Body Sealing



(1) Do not block the water drain holes.

CAUTION:

- Application to the outer side for part (A) of the rear gate window.



(1) Do not block the water drain holes.

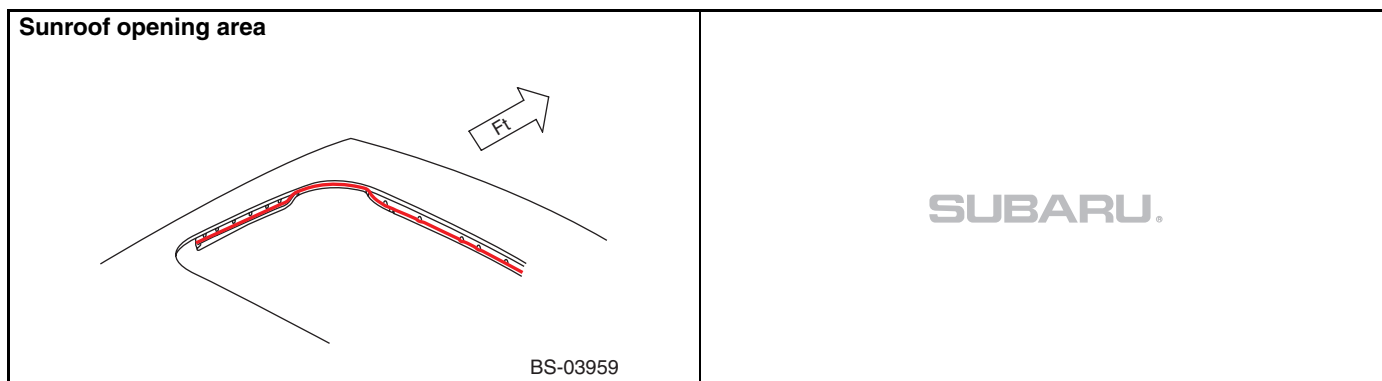
(1) Do not block the water drain holes.

CAUTION:

- Application to the outer side around the front door gusset.
- Application to the inner side around the rear door gusset.
- Do not block the water drain holes.

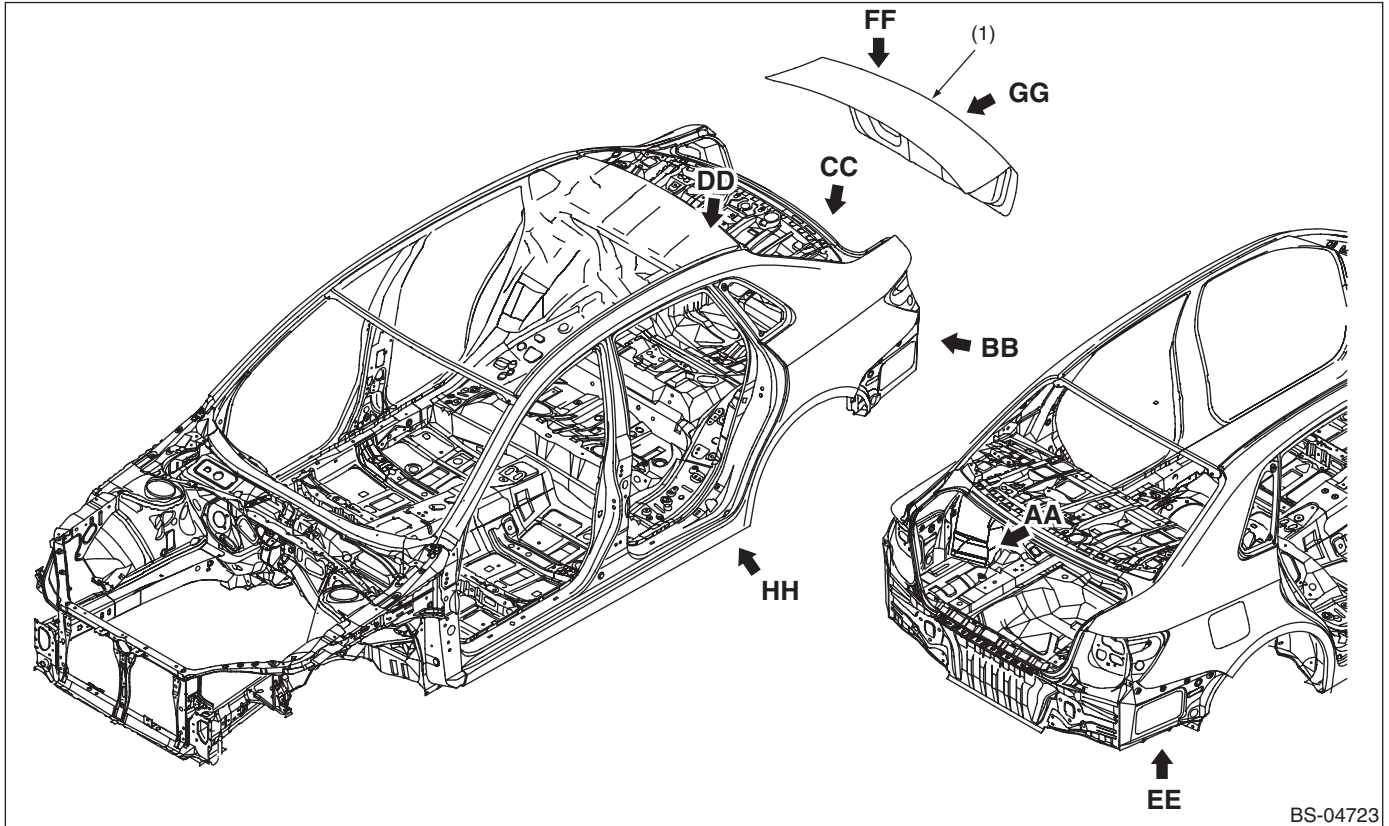
NOTE:

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



Body Sealing

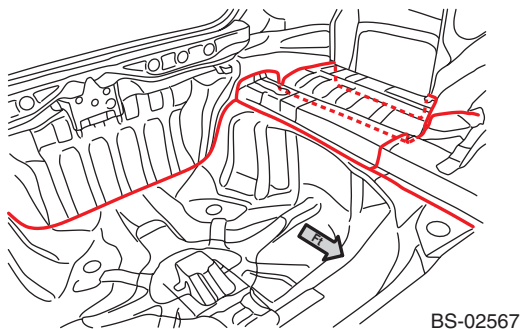
- Special 4 door parts



(1) Trunk

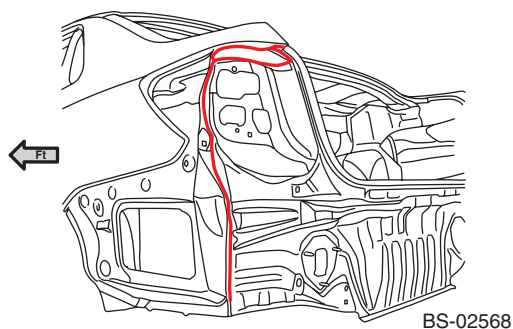
Body Sealing

View AA



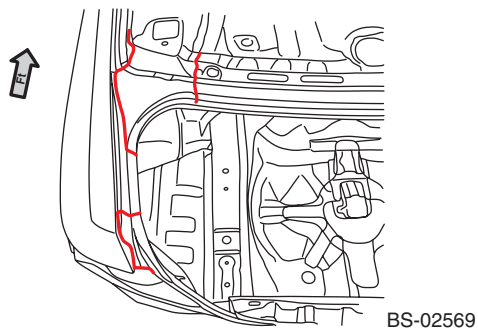
BS-02567

View BB



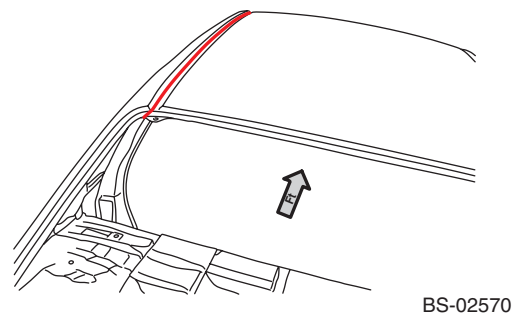
BS-02568

View CC



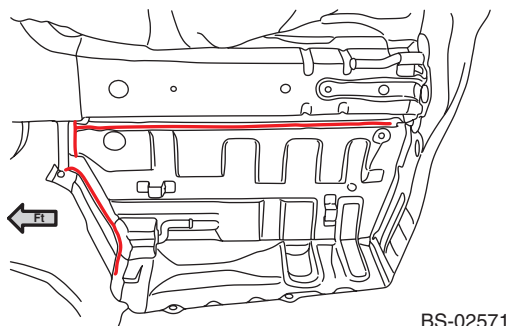
BS-02569

View DD



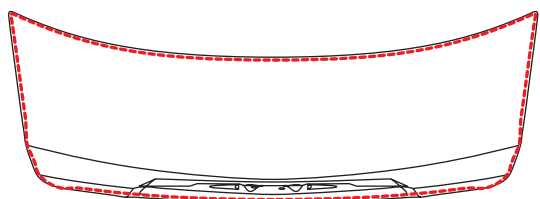
BS-02570

View EE



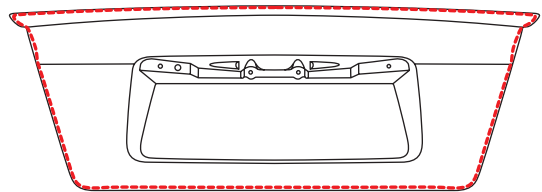
BS-02571

View FF



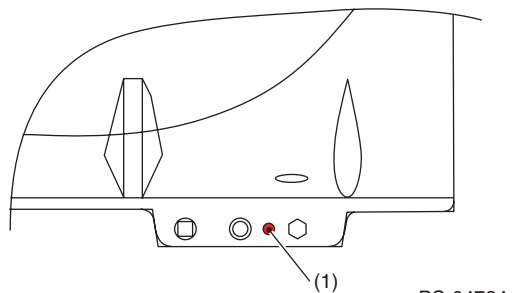
BS-02645

View GG



BS-02646

View HH (STI 4 door)



BS-04724

(1) Block the 4 mm diameter hole. (STI 4 door)

CAUTION:

- Do not block the water drain holes of the trunk.
- Sealer already has been applied to the trunk in replacement condition.

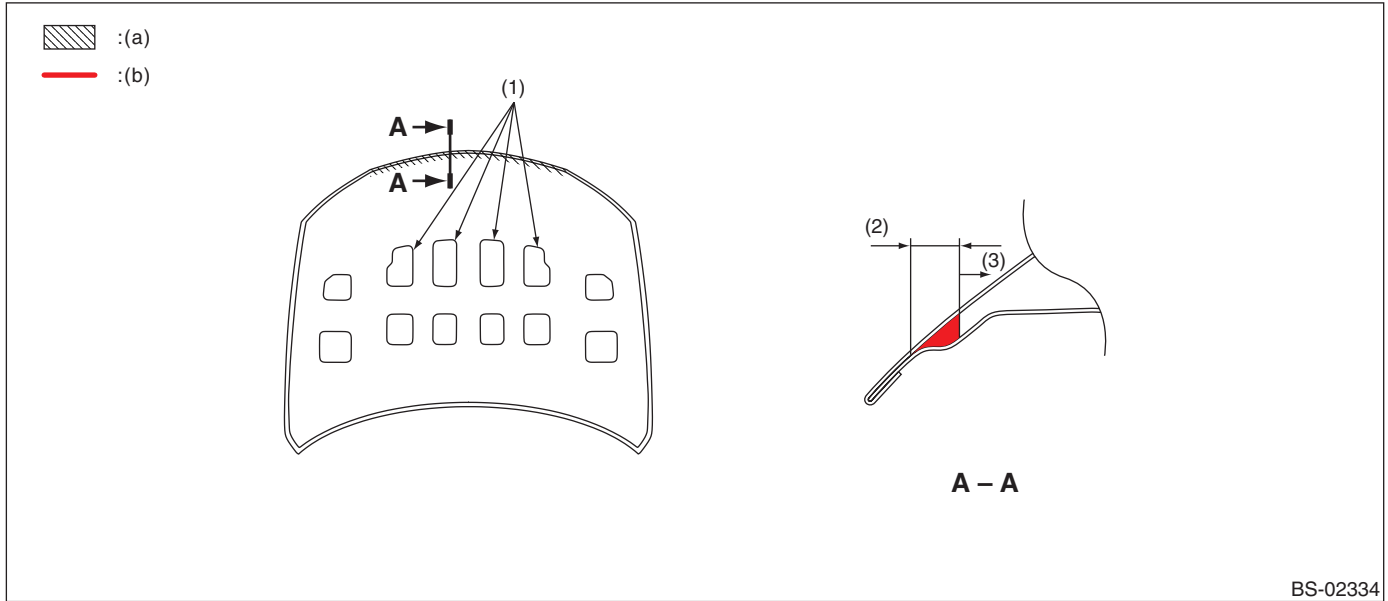
9. Anticorrosion Wax

A: SPECIFICATION

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

— and [diagonal lines] [cross-hatch] [diagonal lines] [cross-hatch]: **Application area**

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



(a) Rust-stop aerosol

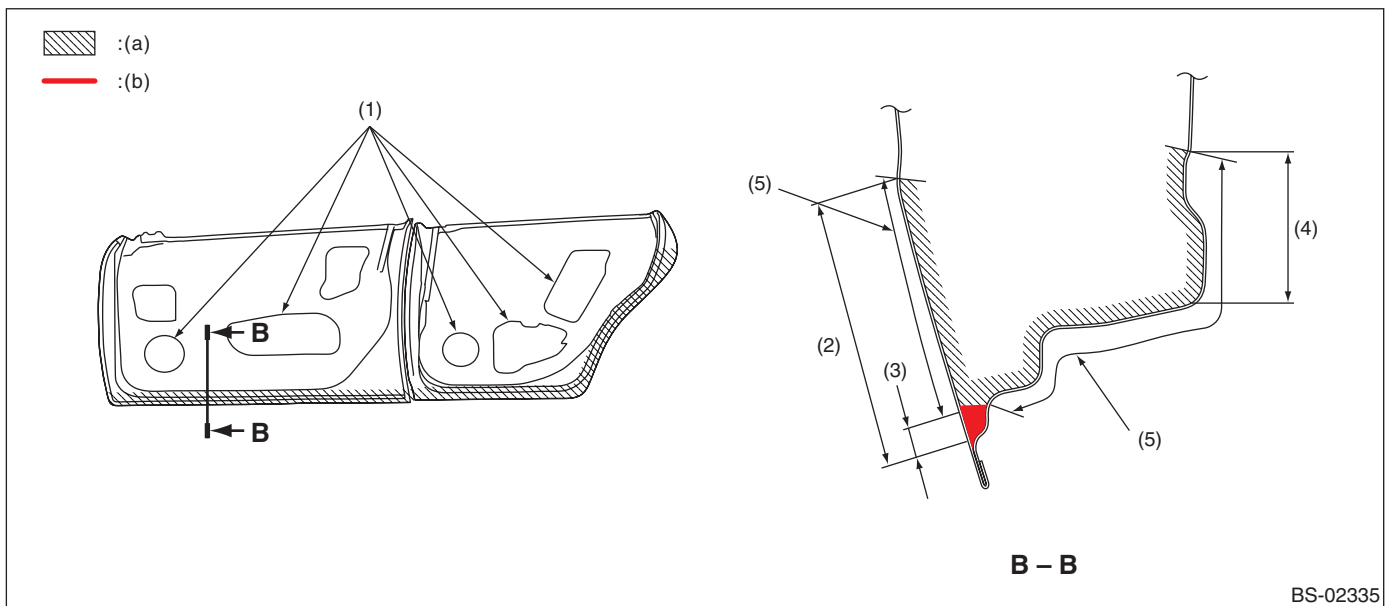
(b) To be filled into the plate joint.

(1) Wax application work openings

(2) 10 mm (0.39 in)

(3) Adherence of mist is allowable.

- Door (Application thickness = 50 μm or more)



(a) Rust-stop aerosol

(b) To be filled into the plate joint.

(1) Wax application work openings

(3) 10 mm (0.39 in)

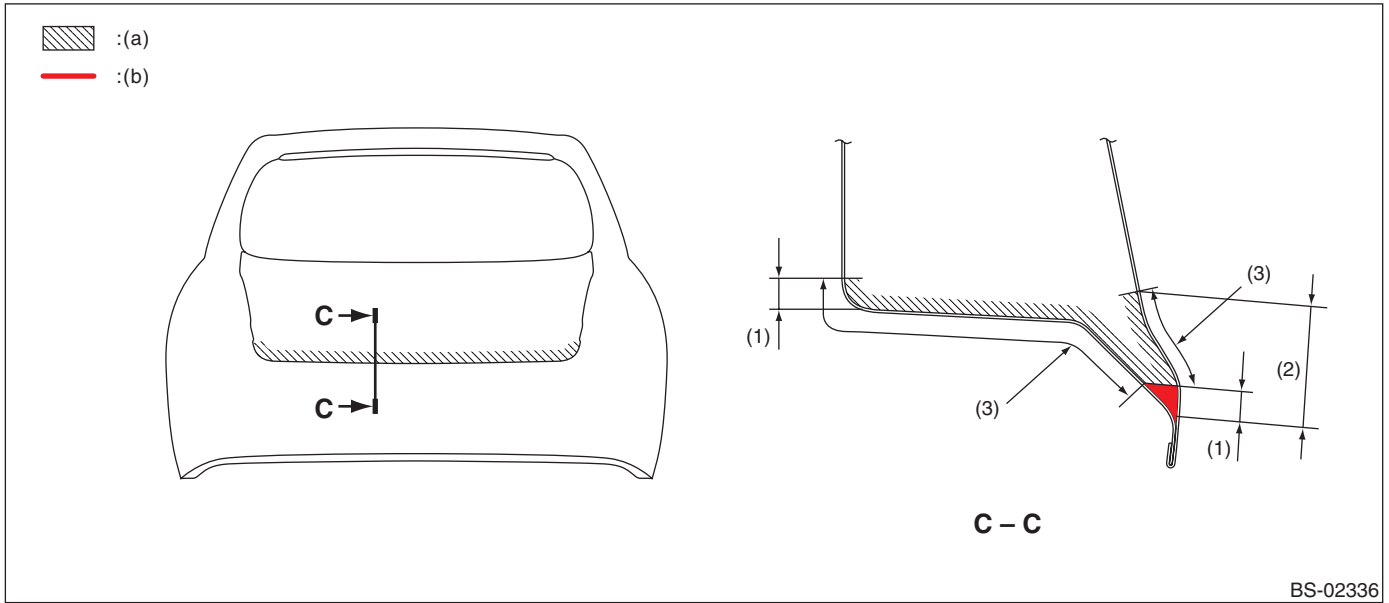
(5) Adherence of mist is allowable.

(2) 90 mm (3.54 in)

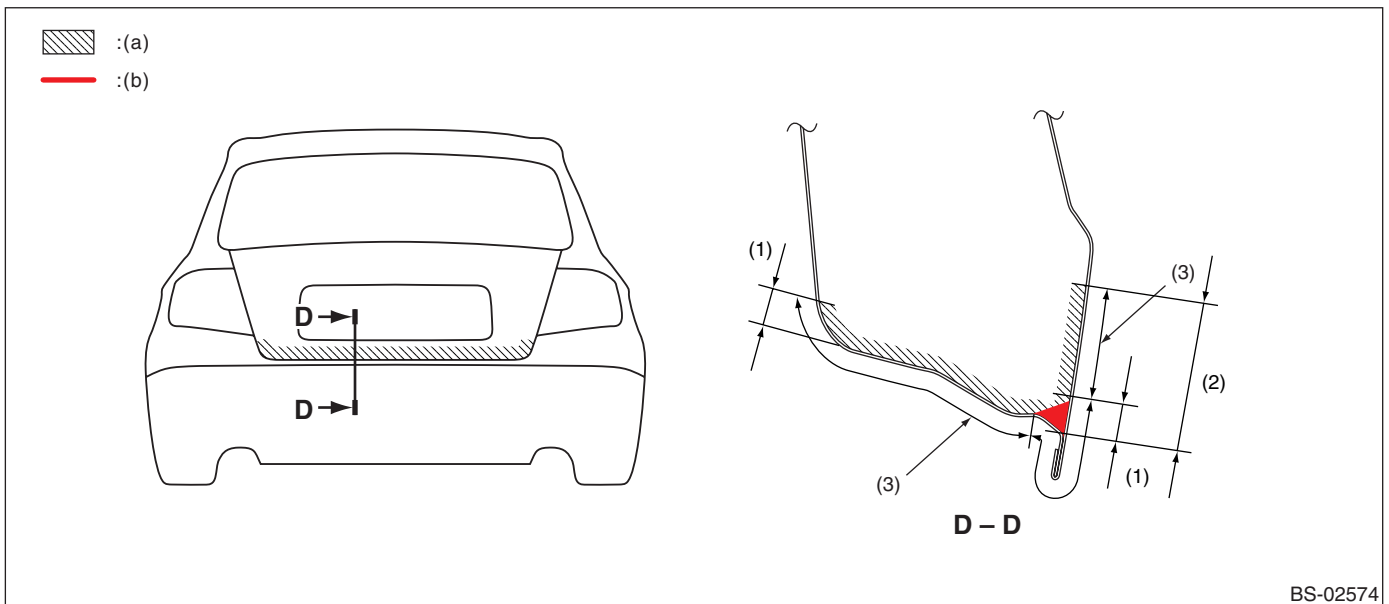
(4) 50 mm (1.97 in)

Anticorrosion Wax

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



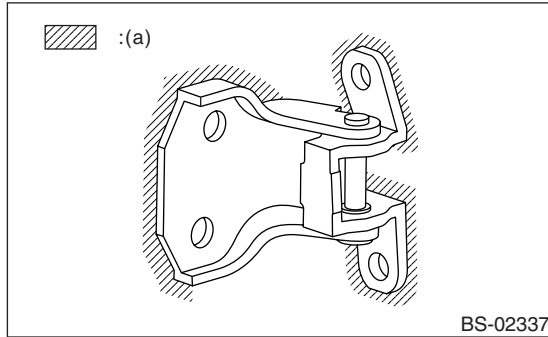
- Trunk lid (Application thickness = 50 μm or more)



Anticorrosion Wax

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

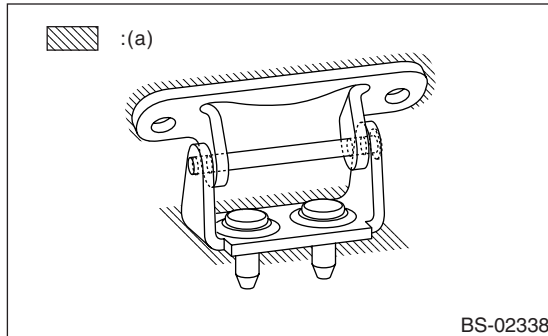
Apply to the contact surface (indicated range) on body side at two locations at the top and bottom (four locations in all), and to the installation outer circumference (plate edges) on the door side.



(a) Rust-stop aerosol

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

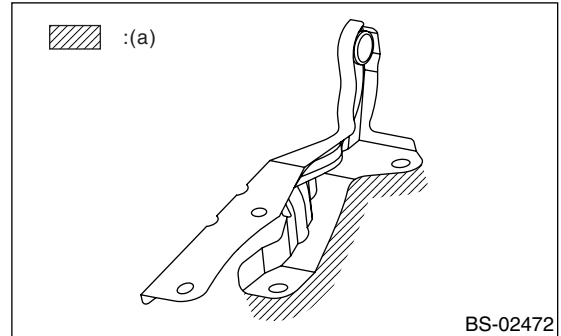
Apply to the contact surface on the body side at two locations on the left and right, and to installation outer circumference (indicated range, plate edges) on the rear gate side.



(a) Rust-stop aerosol

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

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

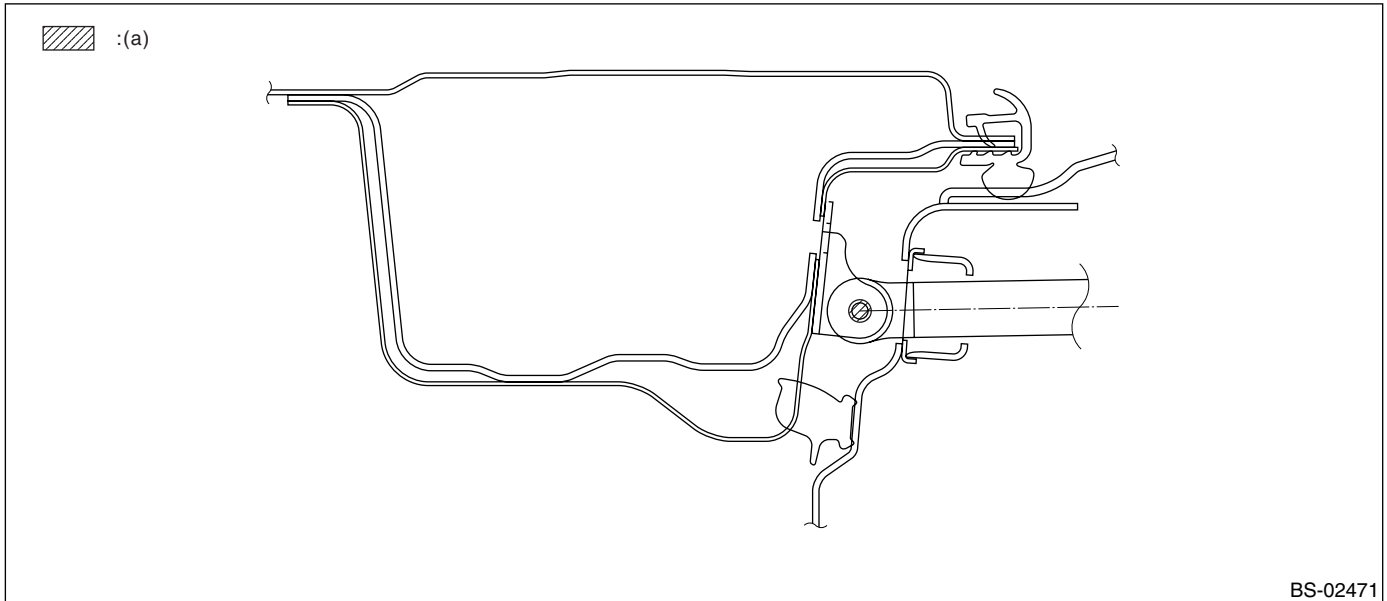


(a) Rust-stop aerosol

Anticorrosion Wax

- Door checker pin (Application thickness = 8 μm or more)

Apply to the checker pin caulking part on each door.




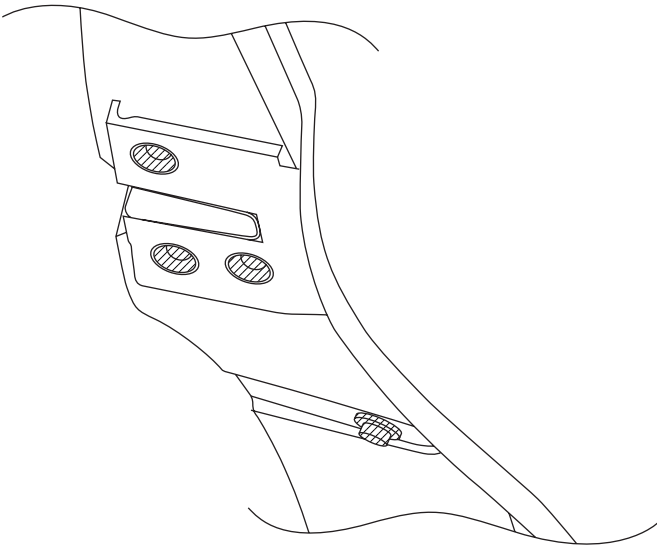
(a) Rust-stop aerosol

- Apply to the damper hinge part at two locations on the left and right, and to the bolt heads.



- Screw door latch (Application thickness = 15 μm or more)

 : (a)



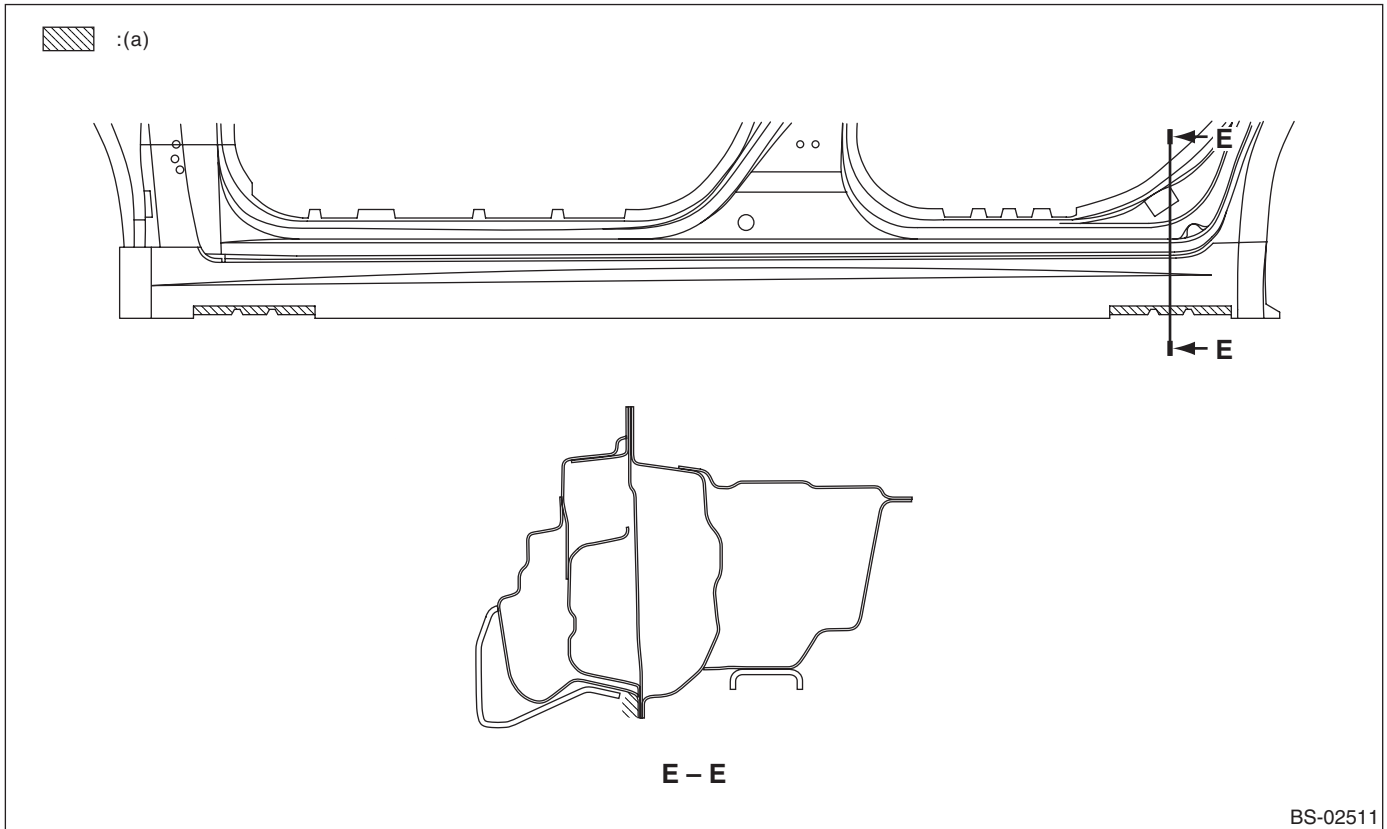
BS-02494

BS-02494

BS - 53

Anticorrosion Wax

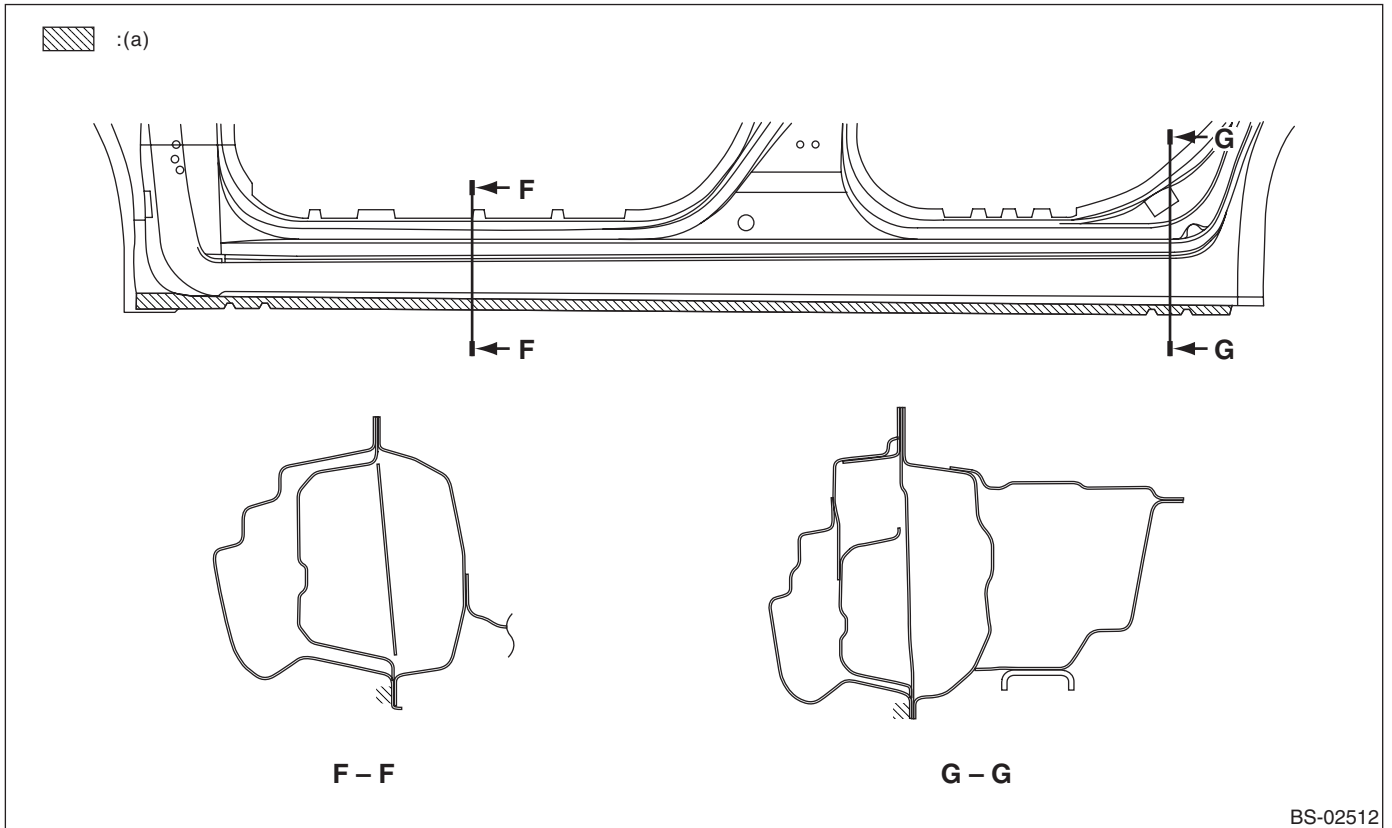
- Jack-up points (Application thickness = 150 μm or more) (Model with side sill spoiler only)
- Apply to the side sill flange part as far as possible from the cut-out of the side sill spoiler.



(a) Rust-stop aerosol

Anticorrosion Wax

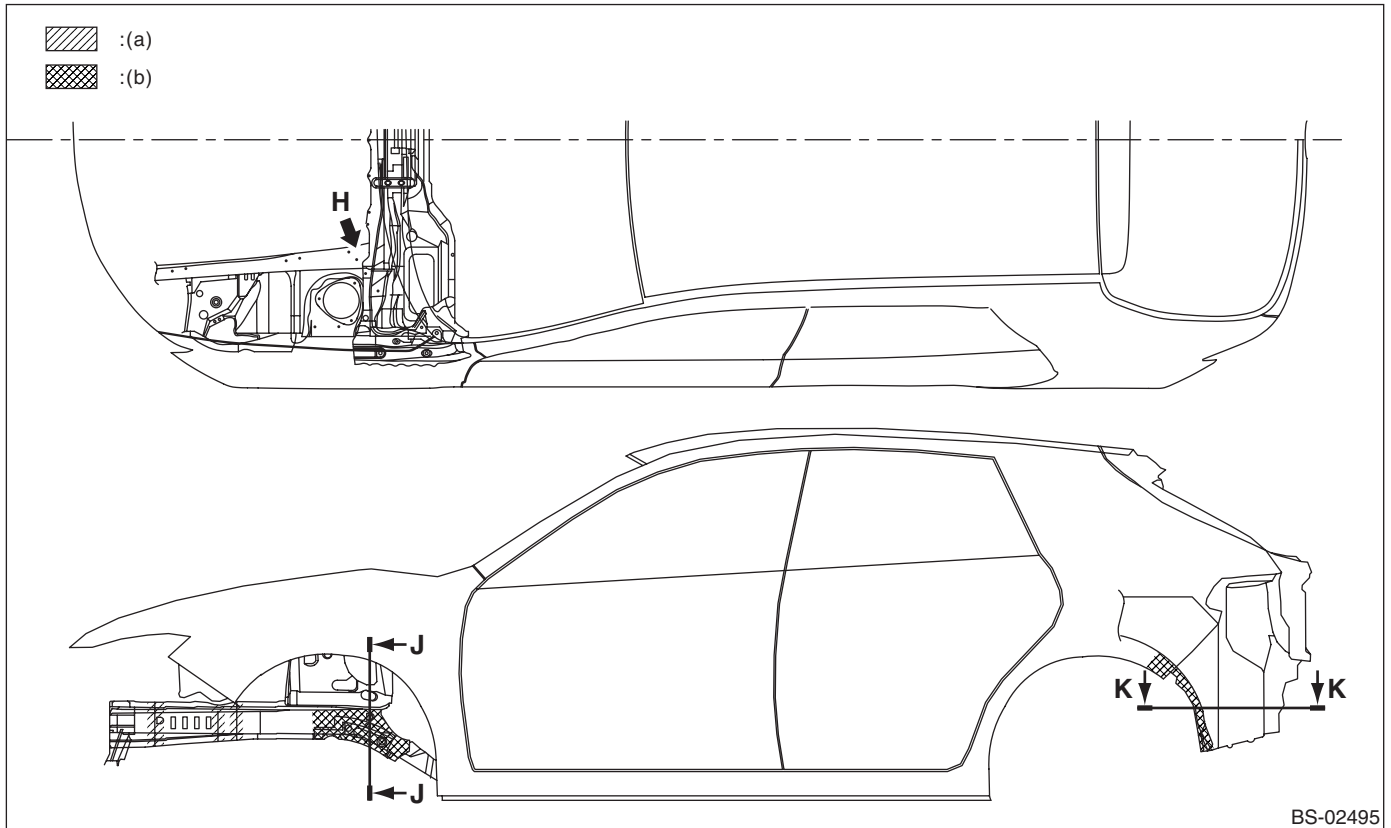
- Side sill (Application thickness = 150 μm or more) (Model without side sill spoiler only)



(a) Rust-stop aerosol

Anticorrosion Wax

- Overall view






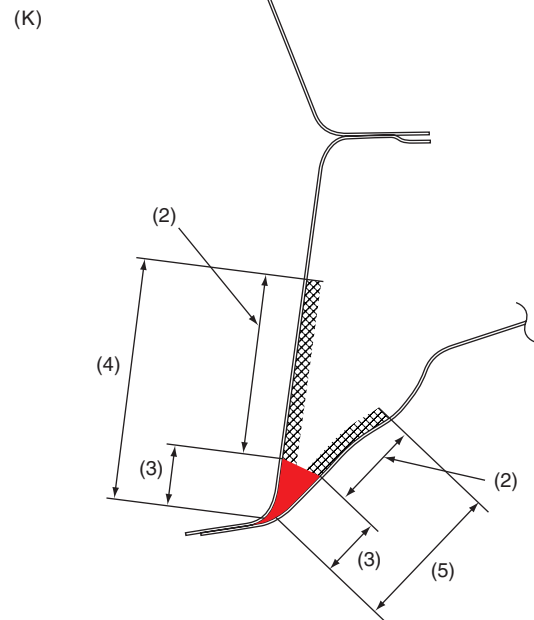
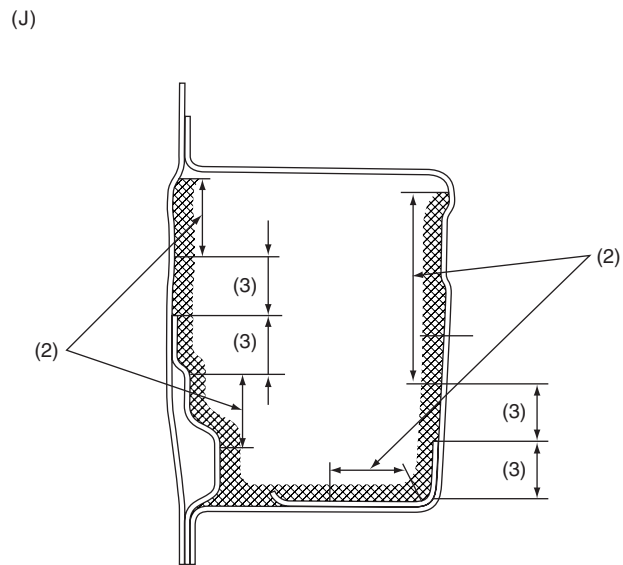
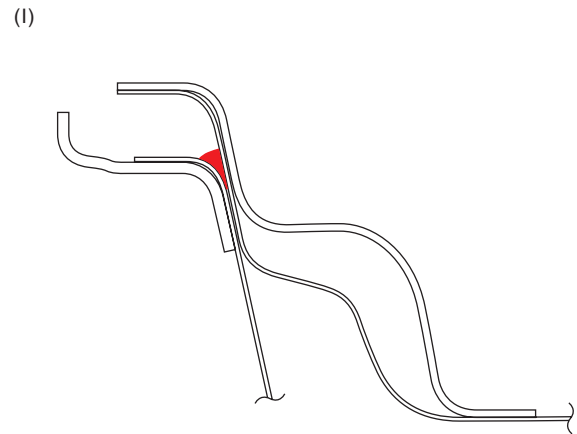
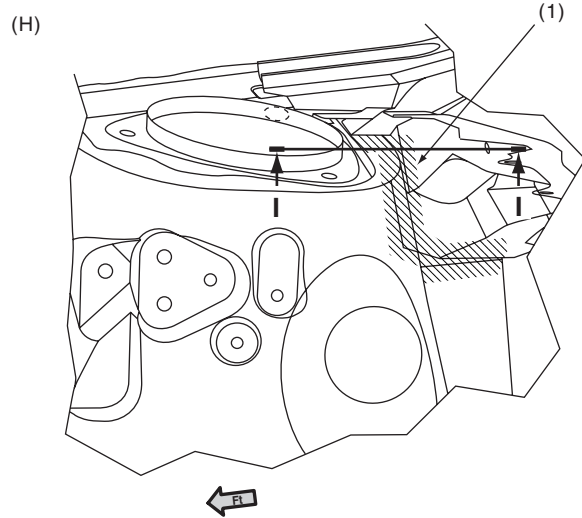
(a) Rust-stop aerosol (Application thickness = 15 μm or more)

(b) Application of rust-stop aerosol to the inside. (Application thickness = 50 μm or more)

Anticorrosion Wax

- Views/Cross sections

-  : (a)
-  : (b)
-  : (c)



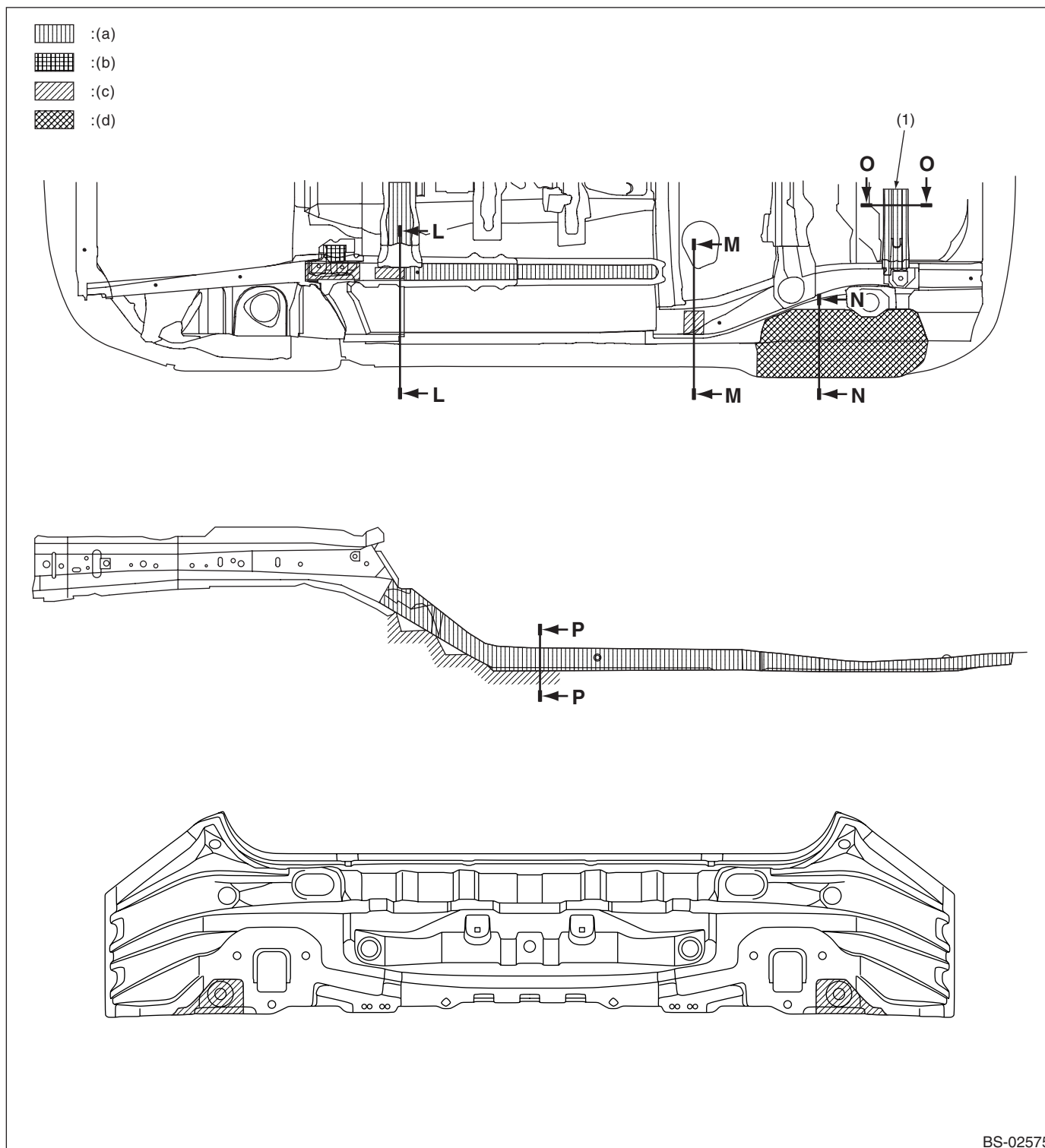
BS-02554

Anticorrosion Wax

- | | | |
|---|--|--|
| (a) Rust-stop aerosol (Application thickness = 15 μm or more) | (b) Rust-stop aerosol (Application thickness = 50 μm or more) | (c) To be filled into the plate joint. |
| (H) View H | (I) Cross section I — I | (J) Cross section J — J |
| (K) Cross section K — K | | |
| (1) Apply to the contact surface between front bulkhead and front suspension bracket. | (3) 20 mm (0.79 in) | (5) 50 mm (1.97 in) |
| (2) Adherence of mist is allowable. | (4) 80 mm (3.15 in) | |

Anticorrosion Wax

• Bottom view



(a) Rust-stop aerosol (Application thickness = 20 μm or more, marked parts 50 μm or more)





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

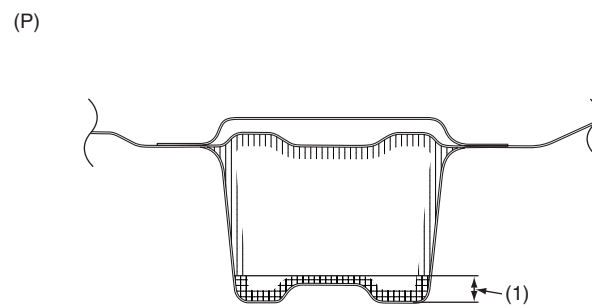
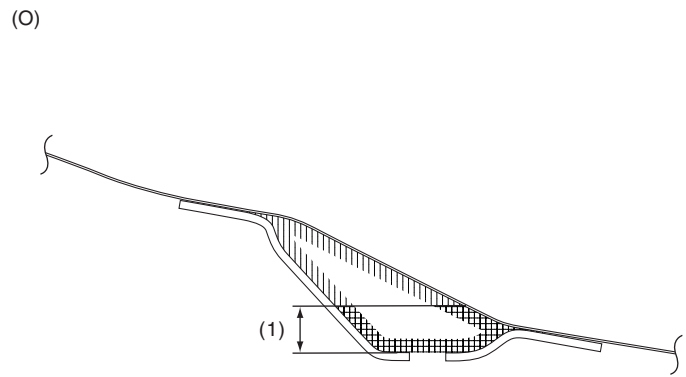
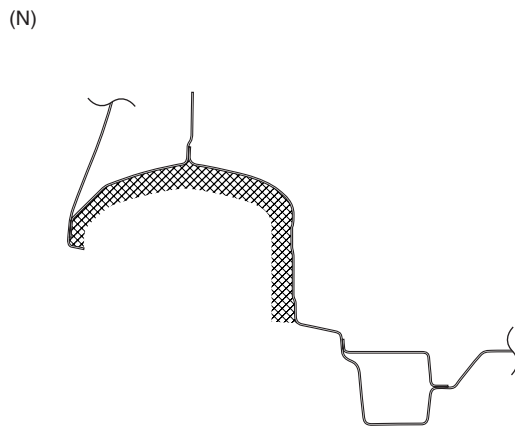
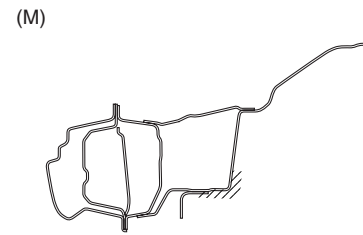
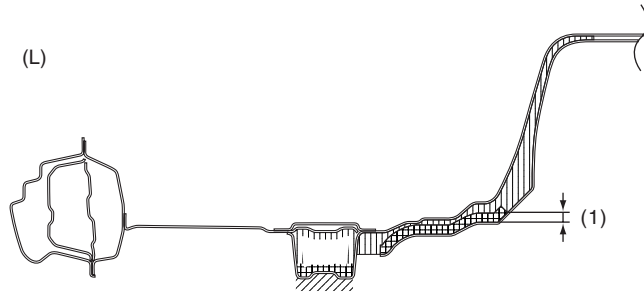
(c) Rust-stop aerosol (Application thickness = 150 μm or more)

(d) Rust-stop aerosol (Application thickness = 300 μm or more)

(1) 4 door only

Anticorrosion Wax

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



BS-02576

Anticorrosion Wax

- | | | |
|--|---|---|
| (a) Rust-stop aerosol (Application thickness = 20 μm or more) | (c) Rust-stop aerosol (Application thickness = 150 μm or more) | (d) Rust-stop aerosol (Application thickness = 300 μm or more) |
| (b) Rust-stop aerosol (Application thickness = 50 μm or more) | | |
| (L) Cross section L — L | (M) Cross section M — M | (N) Cross section N — N |
| (O) Cross section O — O | (P) Cross section P — P | |
| (1) 10 mm (0.39 in) | | |

10.Undercoat




A: SPECIFICATION

Repair material: **THREE BOND 6115**

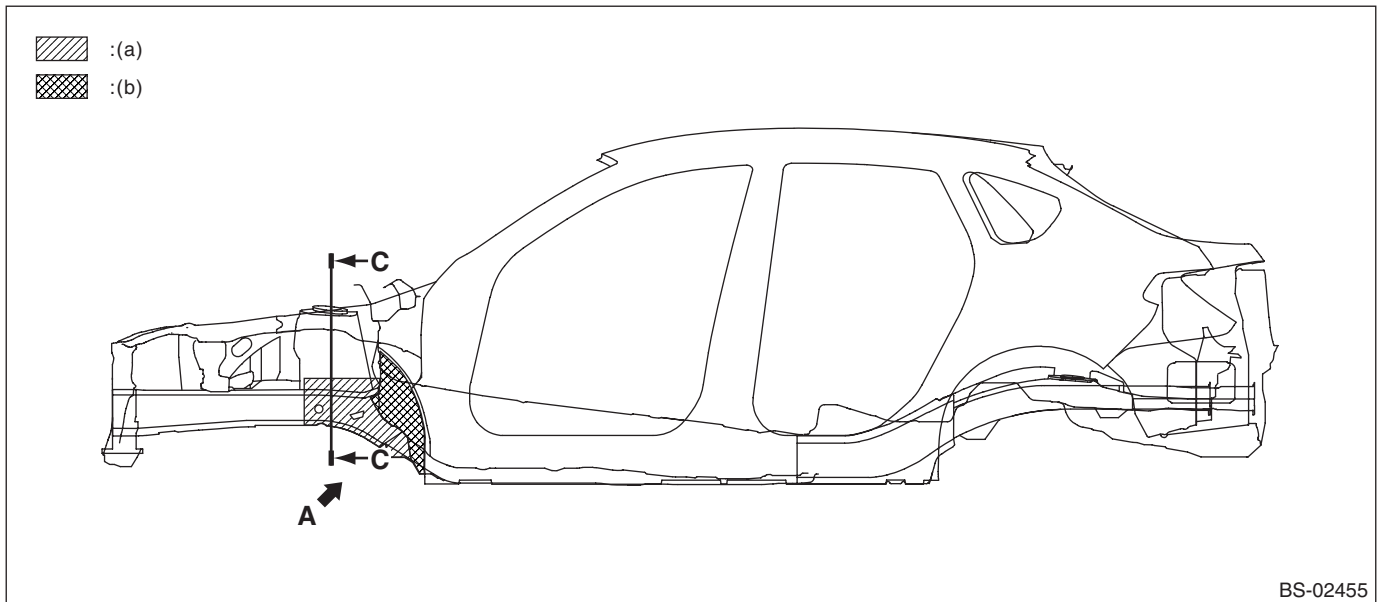
1) Perform masking so that under the coat will not become attached to locations other than shown and to the following locations.

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

2) Application area and application thickness

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

- Side view

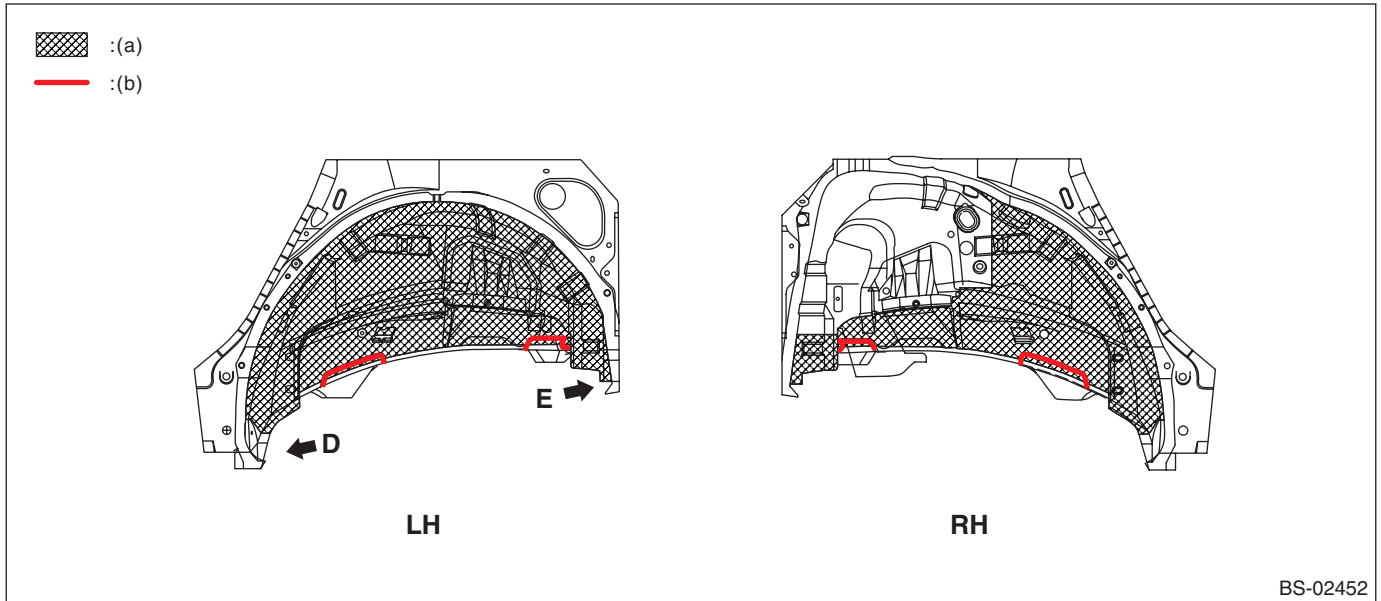


(a) 300 μm or more

(b) 600 μm or more

Undercoat

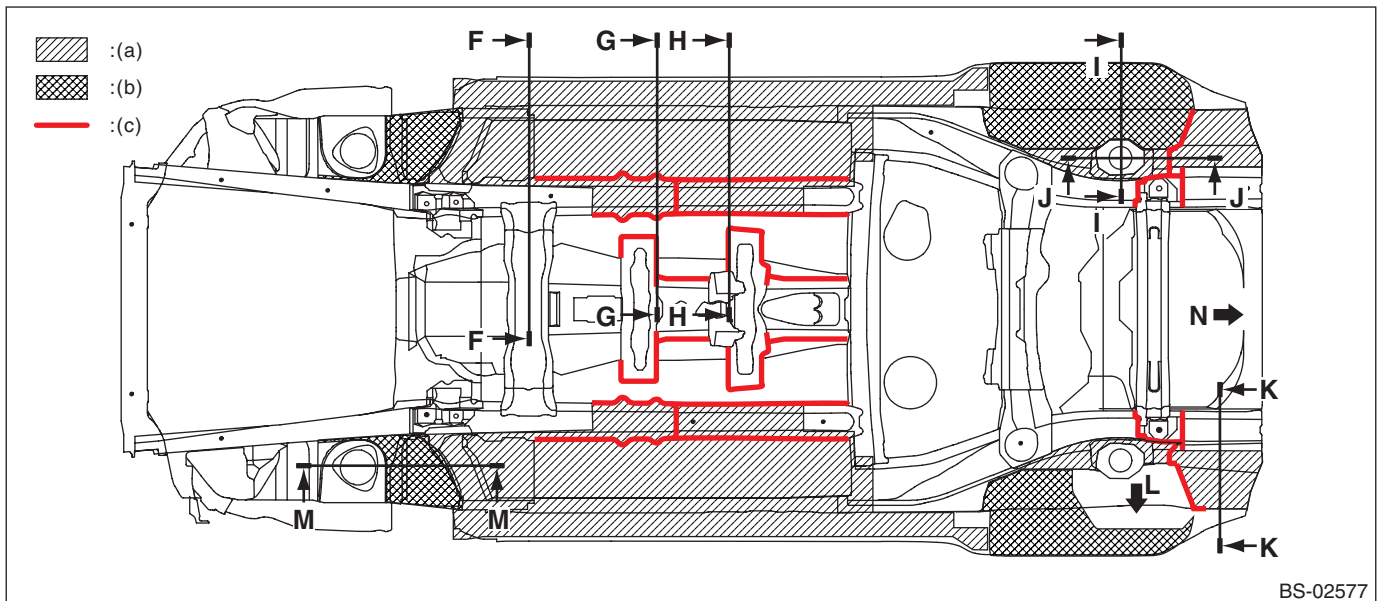
- Rear wheel apron side view



(a) 600 μm or more

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

- Special 5 door parts and common parts for 5 door and 4 door bottom view



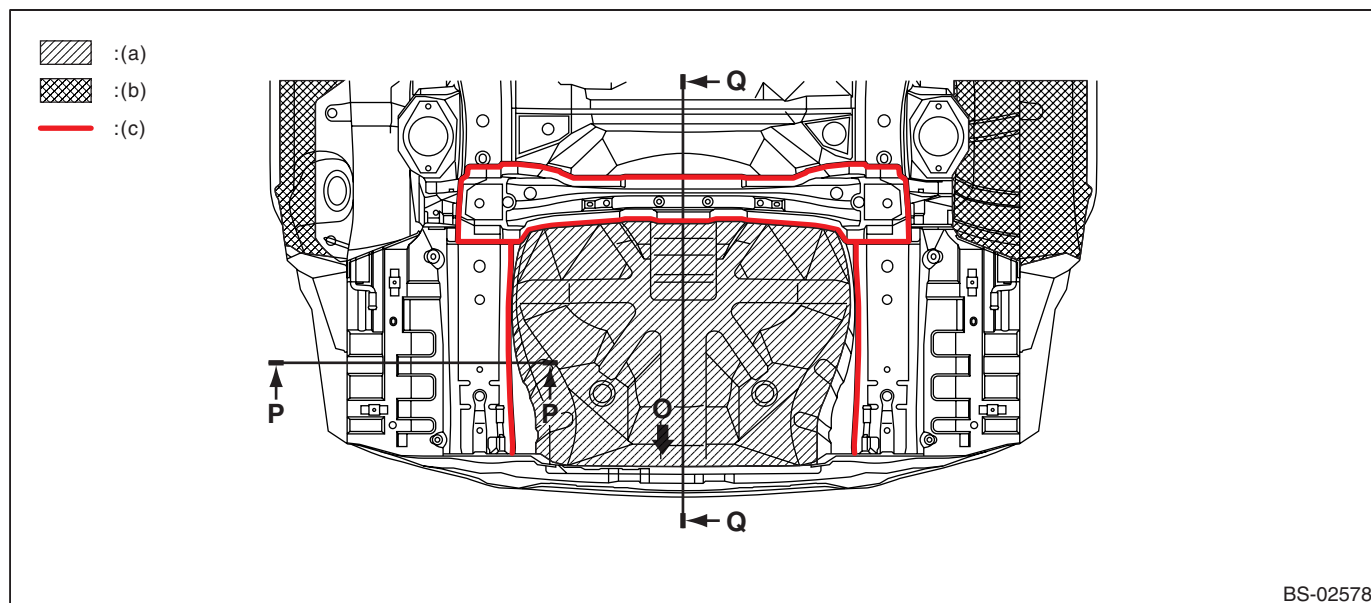
(a) 300 μm or more

(b) 600 μm or more

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

Undercoat

- Special 4 door parts bottom view

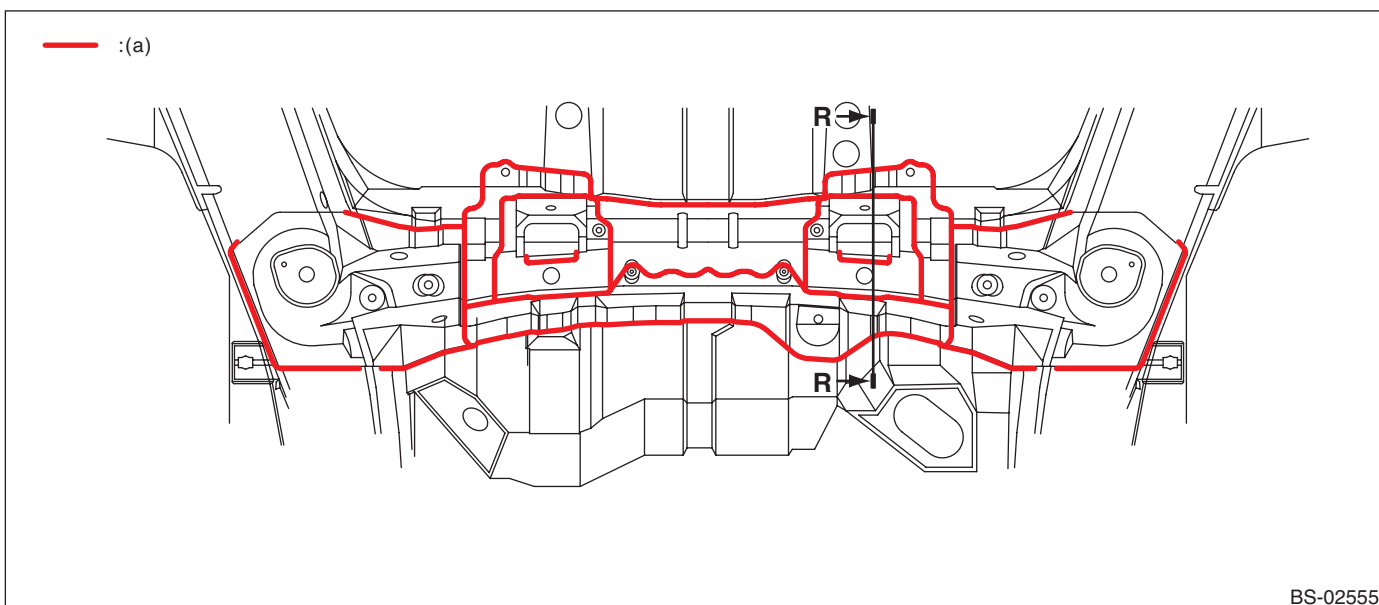


(a) 300 μm or more

(b) 600 μm or more

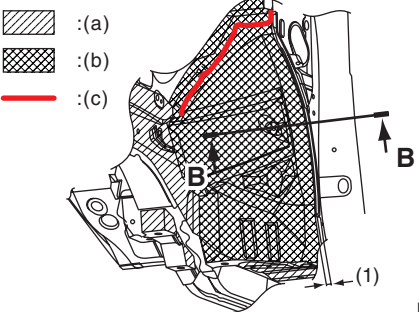
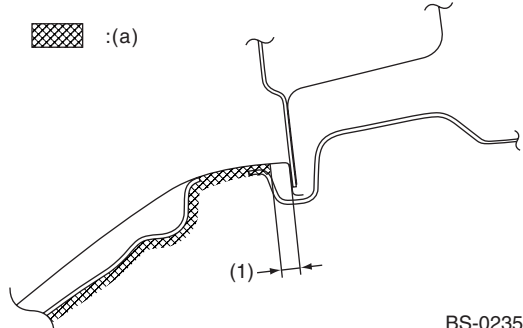
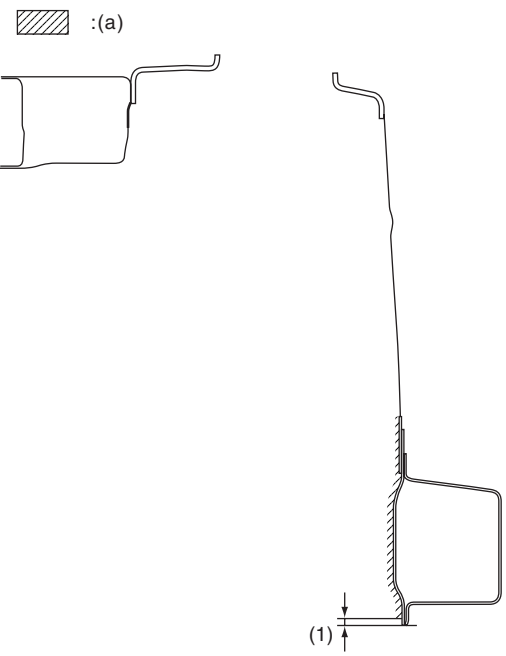
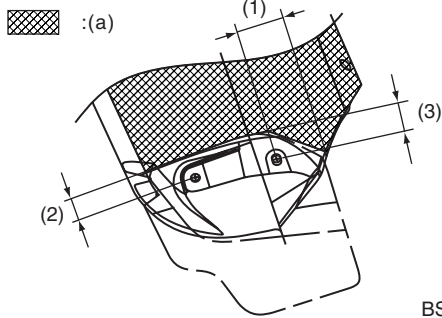
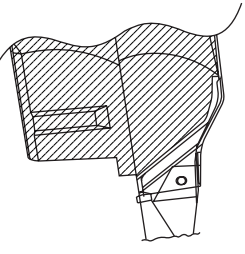
(c) 600 μm or more. The panel gap shall be filled.

- Cross member mounting part lower bottom view



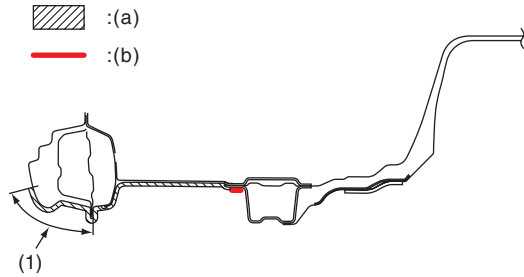
(a) 600 μm or more. The panel gap shall be filled.

Undercoat

| | |
|---|---|
| <div>View A</div> <div></div> <div><p>BS-02361</p><p>(a) 300 μm or more (b) 600 μm or more (c) 600 μm or more. The panel gap shall be filled.</p><p>(1) 10 mm (0.39 in)</p></div> | <div>View B — B</div> <div></div> <div><p>BS-02356</p><p>(a) 600 μm or more</p><p>(1) 10 mm (0.39 in)</p></div> |
| <div>Cross section C — C</div> <div></div> <div><p>BS-02347</p><p>(a) 300 μm or more</p><p>(1) 5 mm (0.20 in)</p></div> | <div>View D</div> <div></div> <div><p>BS-02358</p><p>(a) 600 μm or more</p><p>(1) 50 mm (1.97 in) (2) 25 mm (0.98 in) (3) 30 mm (1.18 in)</p></div> |
| | <div>View E</div> <div></div> <div><p>BS-02357</p><p>(a) 300 μm or more</p></div> |

Undercoat

Cross section F — F

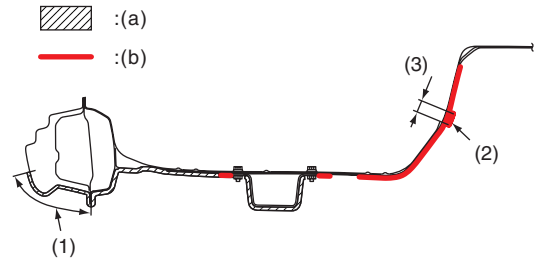


BS-02501

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

(1) Model without side sill spoiler only

Cross section G — G

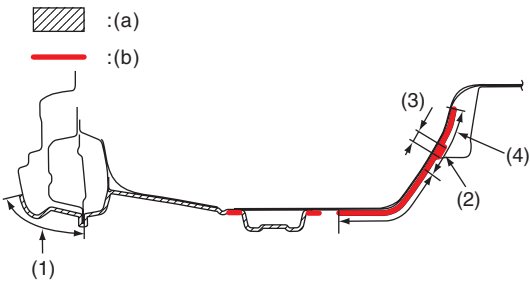


BS-02502

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

(1) Model without side sill spoiler only
 (2) The plate joint shall be covered.
 (3) 20 mm (0.79 in) or more

Cross section H — H

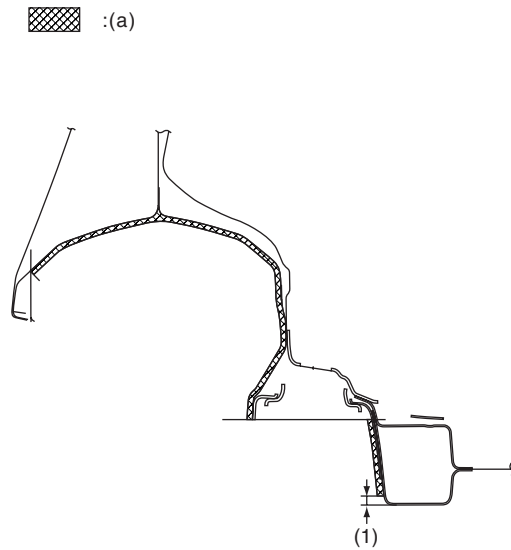


BS-02503

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

(1) Model without side sill spoiler only
 (2) The plate joint shall be covered.
 (3) 20 mm (0.79 in) or more
 (4) FF model only

Cross section I — I

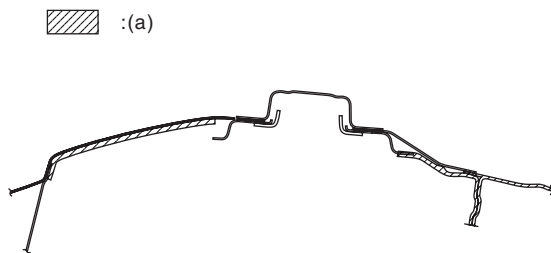


BS-02354

- (a) 600 μm or more

(1) 10 mm (0.39 in)

Cross section J — J

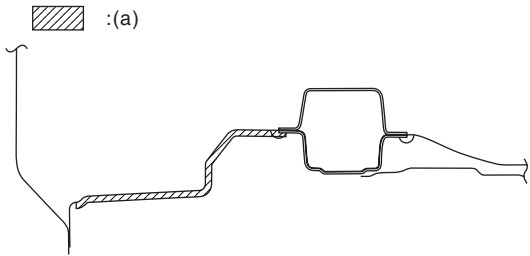


BS-02353

- (a) 300 μm or more

Undercoat

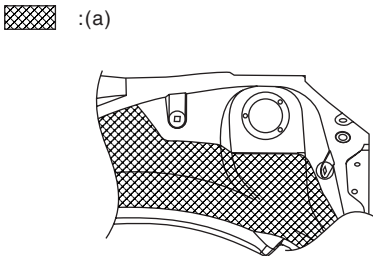
Cross section K — K



BS-02460

(a) 300 μm or more

View L



BS-02360

(a) 600 μm or more

Cross section M — M



BS-02348

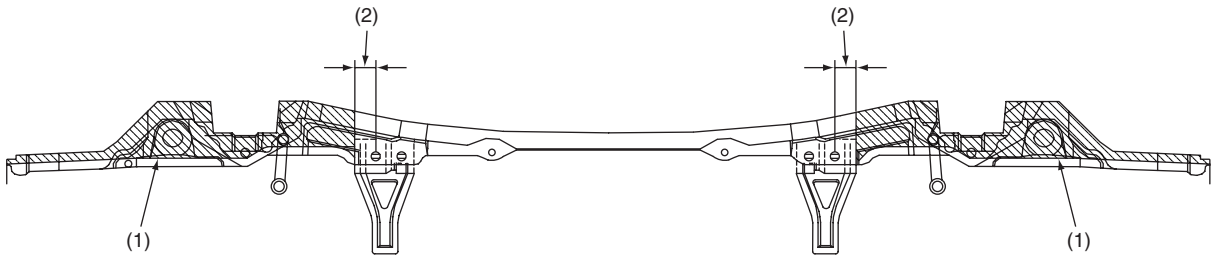
(a) 300 μm or more

(b) 600 μm or more

Undercoat

View N

 : (a)



BS-02359

(a) 300 μm or more

(1) 10 mm (0.39 in)

(2) 25 mm (0.98 in)

View O

 : (a)





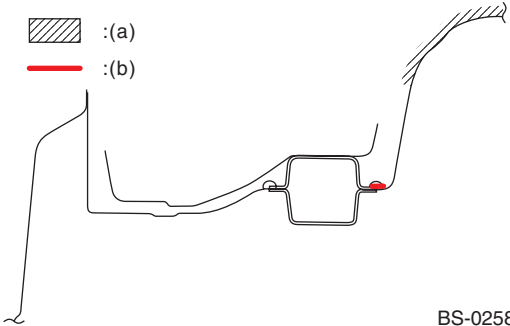


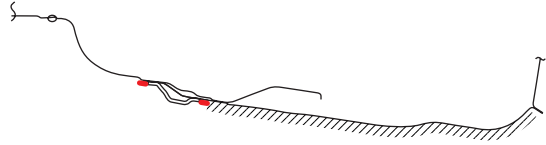

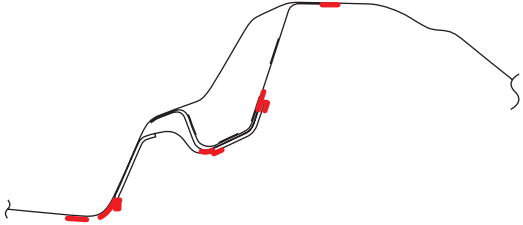

BS-02579

(a) 300 μm or more

(1) 10 mm (0.39 in)

(2) 25 mm (0.98 in)

Undercoat

| | |
|---|--|
| <div><p>Cross section P — P</p><div><div></div><div>: (a)</div></div><div><div></div><div>: (b)</div></div></div> <div></div> <div><div>BS-02581</div><div><div>(a) 300 μm or more</div><div>(b) 600 μm or more. The panel gap shall be filled.</div></div></div> | <div><p>Cross section Q — Q</p><div><div></div><div>: (a)</div></div><div><div></div><div>: (b)</div></div></div> <div></div> <div><div>BS-02580</div><div><div>(a) 300 μm or more</div><div>(b) 600 μm or more. The panel gap shall be filled.</div></div></div> |
| <div><p>Cross section R — R</p><div><div></div><div>: (a)</div></div></div> <div></div> <div><div>BS-02500</div><div><div>(a) 600 μm or more. The panel gap shall be filled.</div></div></div> | <div></div> |

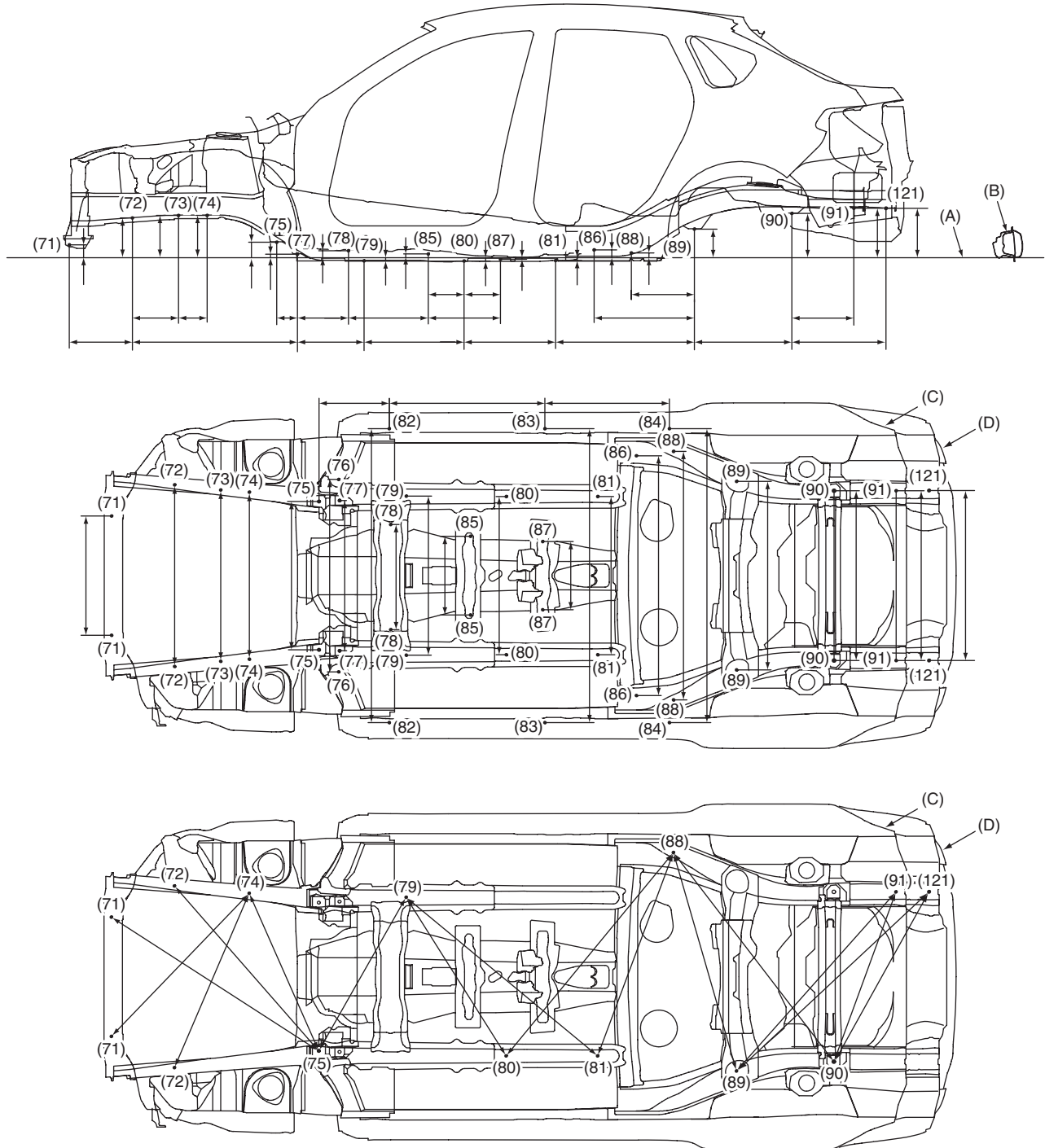
Body Reference Points

11.Body Reference Points

A: DIMENSIONS

1. LOWER SURFACE

Unit: mm



BS-02647

Body Reference Points

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

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

(C) 5 door

(D) 4 door

| | | |
|---|---|--|
| (71) Front bumper bracket mounting hole (symmetrical) | (79) Under cover mounting hole (symmetrical) | (87) Exhaust cover mounting hole (symmetrical) |
| (72) Radio ground mounting hole (symmetrical) | (80) Under cover mounting hole (symmetrical) | (88) Rear suspension support frame mounting hole (symmetrical) |
| (73) Front crossmember mounting hole (symmetrical), front | (81) Under cover mounting hole (symmetrical) | (89) Rear suspension crossmember mounting hole (symmetrical) |
| (74) Front crossmember mounting hole (symmetrical), rear | (82) Side spoiler mounting hole (symmetrical) | (90) Rear suspension crossmember mounting hole (symmetrical) |
| (75) Front suspension arm mounting hole (symmetrical) | (83) Side spoiler mounting hole (symmetrical) | (91) Gauge hole (symmetrical) |
| (76) Front suspension plate mounting hole (symmetrical), outer side | (84) Side spoiler mounting hole (symmetrical) | (121) Gauge hole (symmetrical) |
| (77) Front suspension plate mounting hole (symmetrical), inner side | (85) Gauge hole (symmetrical) | |
| (78)R AT crossmember mounting hole | (86) Rear tie-down hook mounting hole (symmetrical) | |

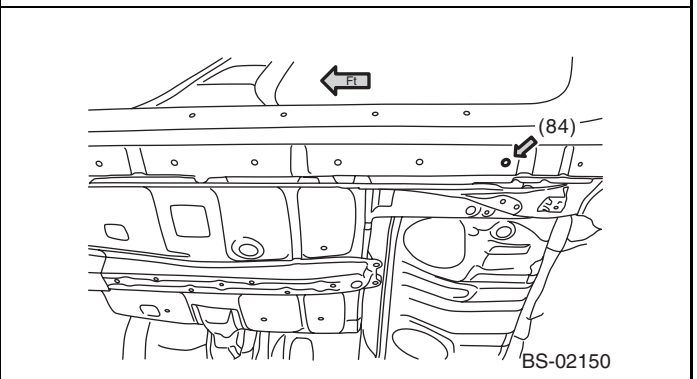
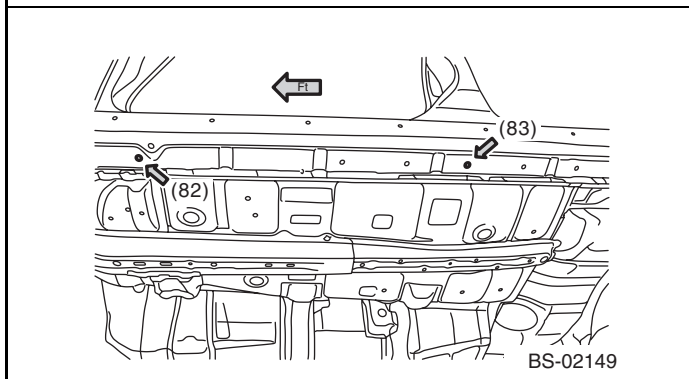
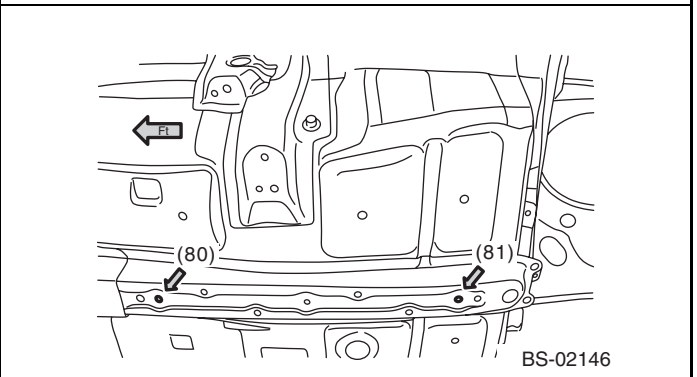
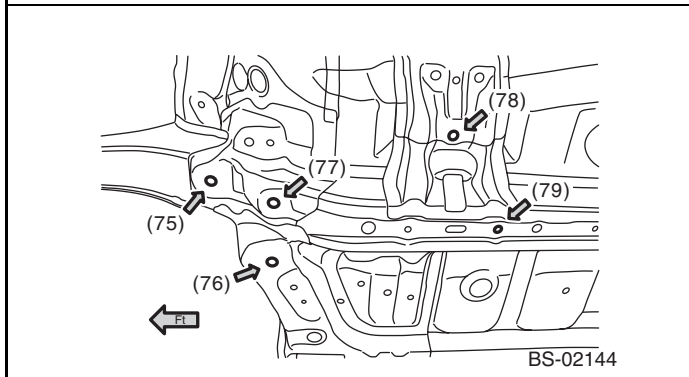
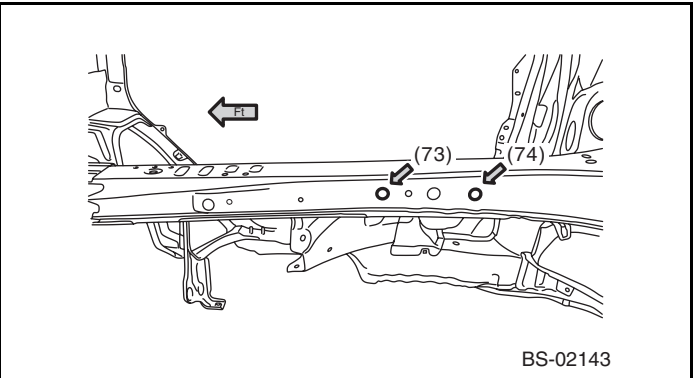
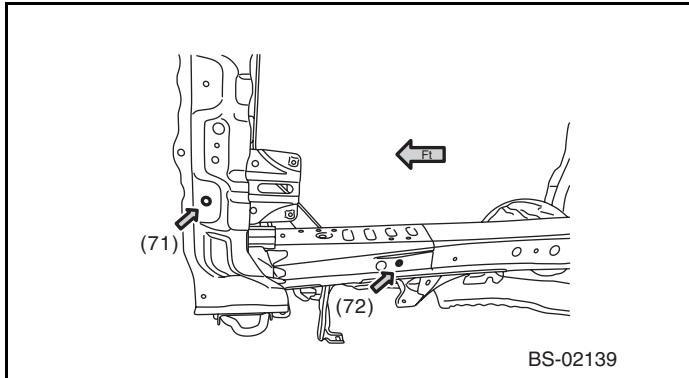
| Datum line | Datum dimension mm (in) | Projected dimensions for reference mm (in) |
|--------------------|----------------------------|---|
| Datum line — (71) | 64 (2.52) | — |
| Datum line — (72) | 200 (7.87) | — |
| Datum line — (73) | 213 (8.39) | — |
| Datum line — (74) | 213 (8.39) | — |
| Datum line — (75) | 77 (3.03) | — |
| Datum line — (77) | 17 (0.67) | — |
| Datum line — (78) | 34 (1.34) | — |
| Datum line — (79) | -15 (-0.59) | — |
| Datum line — (80) | -18 (-0.71) | — |
| Datum line — (81) | -15 (-0.59) | — |
| Datum line — (85) | 18 (0.71) | — |
| Datum line — (86) | 40 (1.57) | — |
| Datum line — (87) | -8 (-0.31) | — |
| Datum line — (88) | 24 (0.94) | — |
| Datum line — (89) | 144 (5.67) | — |
| Datum line — (90) | 223 (8.78) | — |
| Datum line — (91) | 249 (9.80) | — |
| Datum line — (121) | 248 (9.76) | — |
| (71) — (72) | 317 (12.48) | — |
| (72) — (73) | 232 (9.13) | — |
| (72) — (77) | 830 (32.68) | — |
| (73) — (74) | 144 (5.67) | — |
| (75) — (77) | 104 (4.09) | — |
| (75) — (82) | 354 (13.94) | — |
| (77) — (78) | 257 (10.12) | — |
| (77) — (79) | 335 (13.19) | — |

| Datum line | Datum dimension mm (in) | Projected dimensions for reference mm (in) |
|-----------------|----------------------------|---|
| (78) — (85) | 402 (15.83) | — |
| (79) — (80) | 503 (19.80) | — |
| (80) — (81) | 460 (18.11) | — |
| (80) — (85) | 180 (7.09) | — |
| (80) — (87) | 183 (7.20) | — |
| (85) — (87) | 363 (14.29) | — |
| (81) — (89) | 698 (27.48) | — |
| (82) — (83) | 783 (30.83) | — |
| (83) — (84) | 626 (24.65) | — |
| (86) — (89) | 504 (19.84) | — |
| (88) — (89) | 317 (12.48) | — |
| (89) — (90) | 490 (19.29) | — |
| (90) — (91) | 312 (12.28) | — |
| (90) — (121) | 475 (18.70) | — |
| (71)RH — (71)LH | 600 (23.62) | — |
| (72)RH — (72)LH | 914 (35.98) | — |
| (73)RH — (73)LH | 862 (33.94) | — |
| (74)RH — (74)LH | 840 (33.07) | — |
| (75)RH — (75)LH | 746 (29.37) | — |
| (76)RH — (76)LH | 968 (38.11) | — |
| (77)RH — (77)LH | 756 (29.76) | — |
| (78)RH — (78)LH | 529 (20.83) | — |
| (79)RH — (79)LH | 800 (31.50) | — |
| (80)RH — (80)LH | 796 (31.34) | — |
| (81)RH — (81)LH | 796 (31.34) | — |
| (82)RH — (82)LH | 1,478 (58.19) | — |

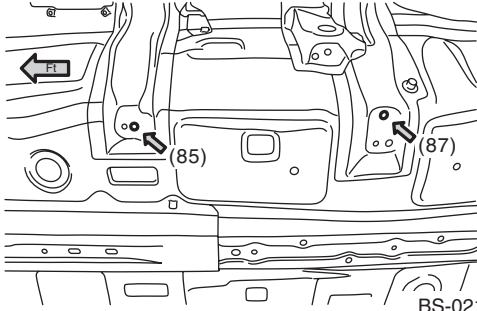
Body Reference Points

| Datum line | Datum dimension mm (in) | Projected dimensions for reference mm (in) |
|-------------------|----------------------------|---|
| (83)RH — (83)LH | 1,478 (58.19) | — |
| (84)RH — (84)LH | 1,478 (58.19) | — |
| (85)RH — (85)LH | 396 (15.59) | — |
| (86)RH — (86)LH | 1,206 (47.48) | — |
| (87)RH — (87)LH | 344 (13.54) | — |
| (88)RH — (88)LH | 1,250 (49.21) | — |
| (89)RH — (89)LH | 948 (37.32) | — |
| (90)RH — (90)LH | 854 (33.62) | — |
| (91)RH — (91)LH | 854 (33.62) | — |
| (121)RH — (121)LH | 854 (33.62) | — |
| (71)RH — (74)LH | 1,010 (39.76) | 999 (39.33) |
| (71)LH — (75)RH | 1,241 (48.86) | 1,241 (48.86) |
| (72)RH — (74)LH | 954 (37.56) | 954 (37.56) |

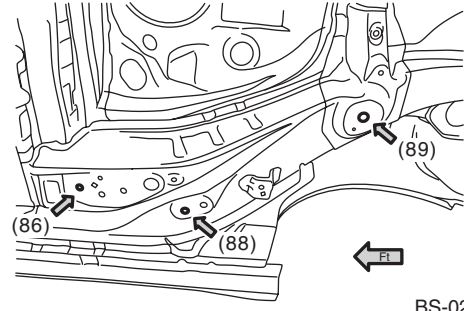
| Datum line | Datum dimension mm (in) | Projected dimensions for reference mm (in) |
|------------------|----------------------------|---|
| (72)LH — (75)RH | 1,109 (43.66) | 1,103 (43.43) |
| (74)LH — (75)RH | 877 (34.53) | 867 (34.13) |
| (75)RH — (79)LH | 894 (35.20) | 889 (35.00) |
| (79)LH — (80)RH | 943 (37.13) | 943 (37.13) |
| (79)LH — (81)RH | 1,251 (49.25) | 1,251 (49.25) |
| (80)RH — (88)LH | 1,325 (52.17) | 1,324 (52.13) |
| (81)RH — (88)LH | 1,092 (42.99) | 1,092 (42.99) |
| (88)LH — (89)RH | 1,150 (45.28) | 1,144 (45.04) |
| (88)LH — (90)RH | 1,341 (52.80) | 1,326 (52.20) |
| (89)RH — (91)LH | 1,211 (47.68) | 1,206 (47.48) |
| (90)RH — (91)LH | 910 (35.83) | 909 (35.79) |
| (89)RH — (121)LH | 1,324 (52.13) | 1,320 (51.97) |
| (90)RH — (121)LH | 978 (38.50) | 977 (38.46) |



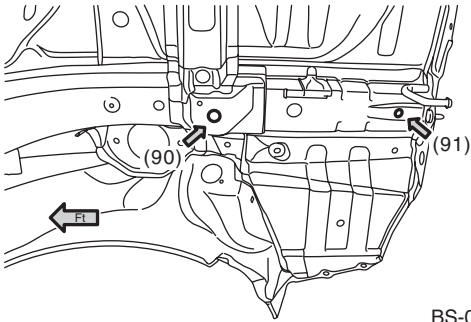
Body Reference Points



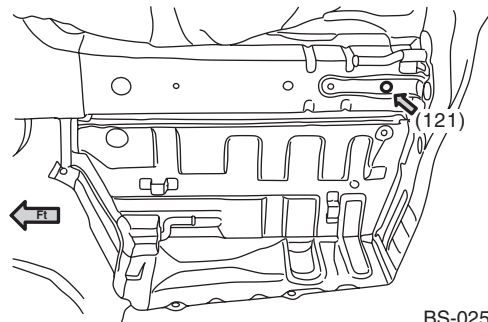
BS-02145



BS-02147



BS-02148

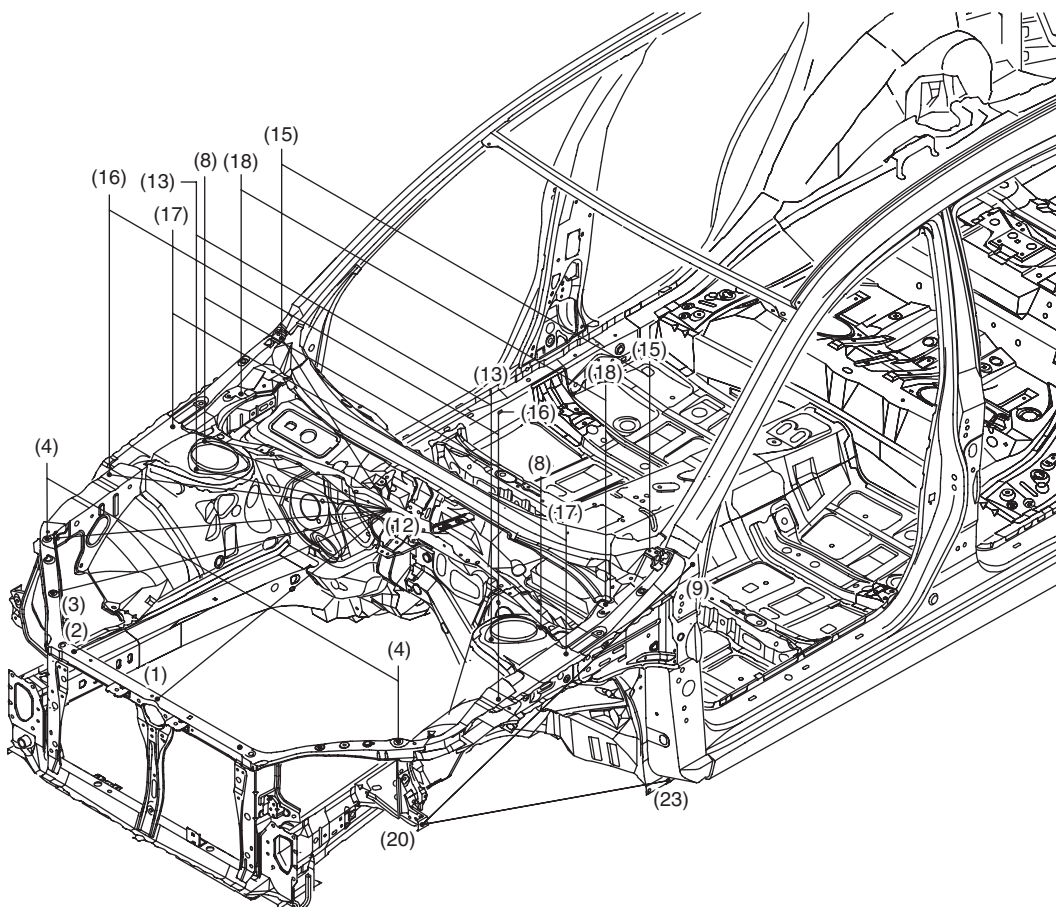


BS-02583

Body Reference Points

2. FRONT 1

- Common parts for 5 door and 4 door



BS-02179

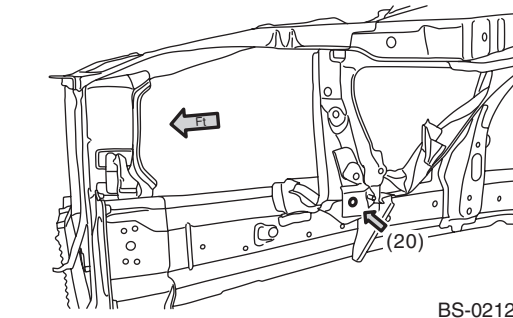
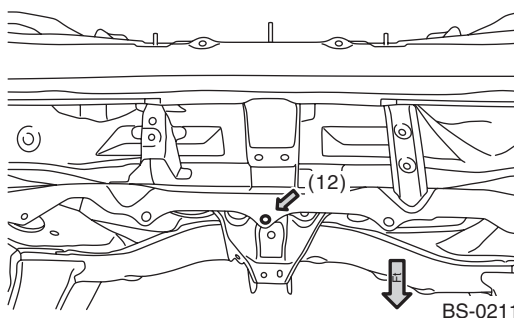
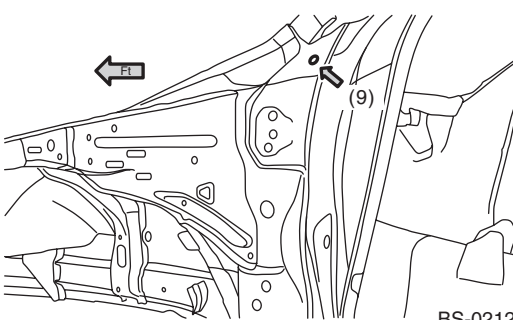
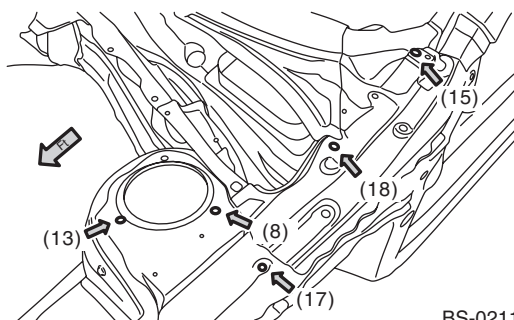
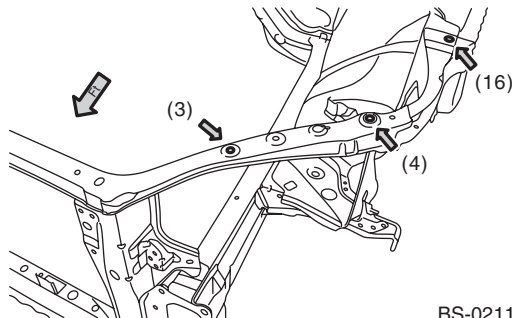
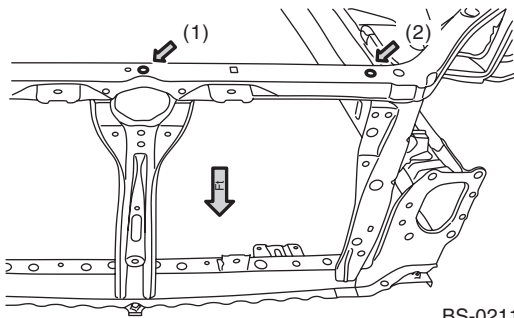
- | | | |
|--|--|---|
| (1) Repair location hole (body center) | (9) Fender mounting hole (symmetrical) | (17) Fender mounting hole (symmetrical) |
| (2) Radiator mounting hole (symmetrical) | (12) Cowl panel mounting hole (body center) | (18) Hood hinge mounting hole (symmetrical) |
| (3) Headlight mounting hole (symmetrical) | (13) Front suspension mounting hole (symmetrical), front | (20) Fender mounting hole (symmetrical) |
| (4) Fender mounting hole (symmetrical) | (15) Fender mounting hole (symmetrical) | (23) Fender mounting hole (symmetrical) |
| (8) Front suspension mounting hole (symmetrical), rear outside | (16) Fender mounting hole (symmetrical) | |

Body Reference Points

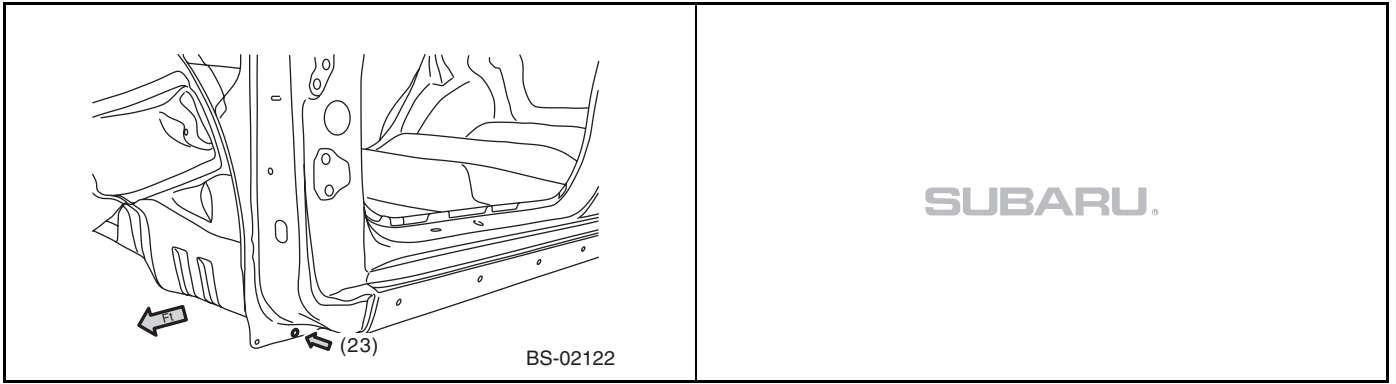
| Measuring point | Datum dimension mm (in) |
|-----------------|-------------------------|
| (1) — (12) | 886 (34.88) |
| (2) — (12) | 941 (37.05) |
| (3) — (12) | 920 (36.22) |
| (4) — (4) | 1,314 (51.73) |
| (4) — (12) | 913 (35.94) |
| (8) — (8) | 1,258 (49.53) |
| (8) — (12) | 635 (25.00) |
| (9) — (20) | 1,066 (41.97) |
| (12) — (13) | 580 (22.83) |

| Measuring point | Datum dimension mm (in) |
|-----------------|-------------------------|
| (12) — (15) | 748 (29.45) |
| (12) — (16) | 800 (31.50) |
| (13) — (13) | 1,103 (43.43) |
| (15) — (15) | 1,377 (54.21) |
| (16) — (16) | 1,456 (57.32) |
| (17) — (17) | 1,472 (57.95) |
| (18) — (18) | 1,364 (53.70) |
| (20) — (23) | 1,032 (40.63) |

- The reference points (1) and (12) are at the body center, while the other reference points are left-right symmetrical.
- The dimensions are the actual dimensions between the reference points.



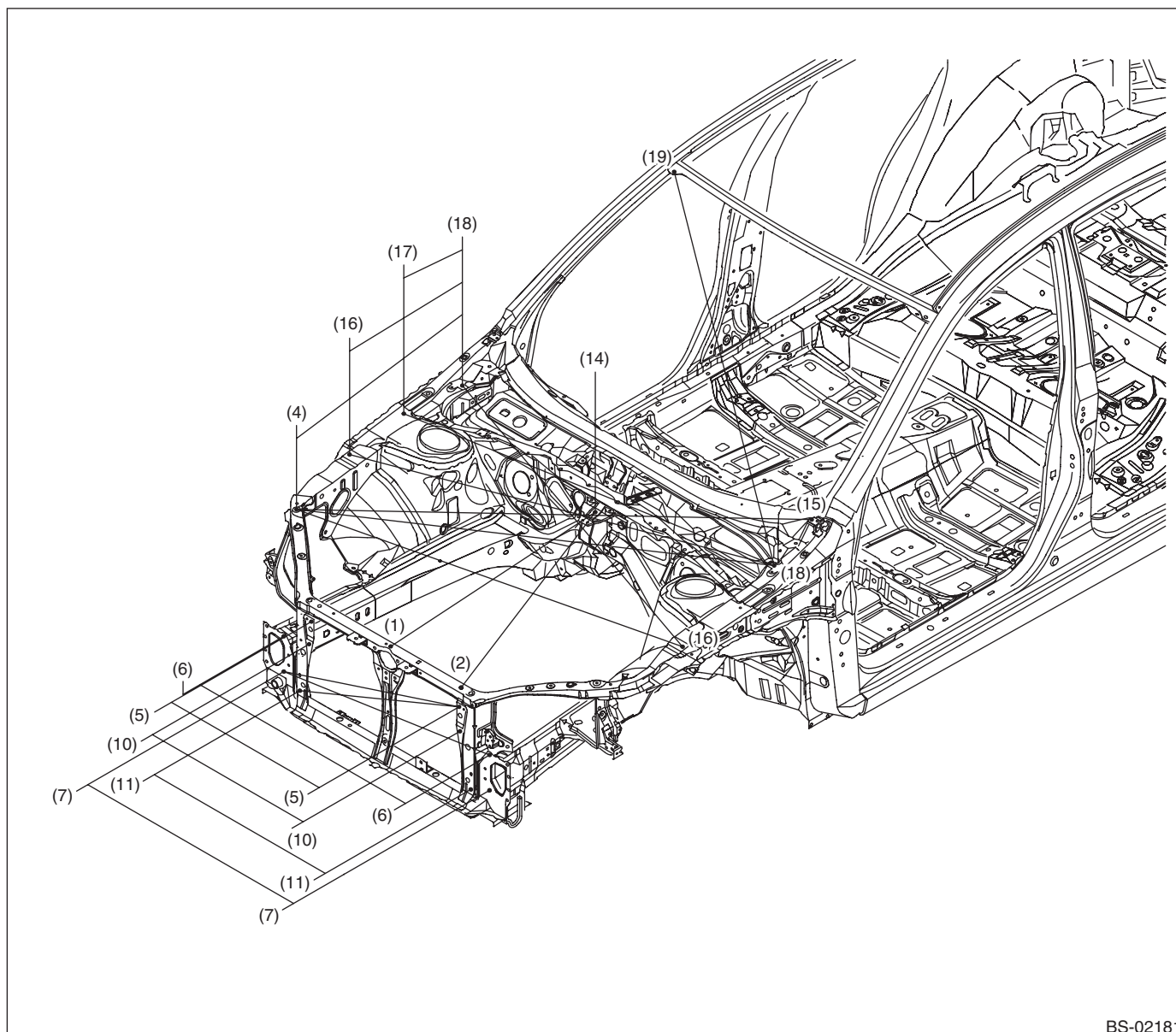
Body Reference Points



Body Reference Points

3. FRONT 2

- Common parts for 5 door and 4 door



BS-02181

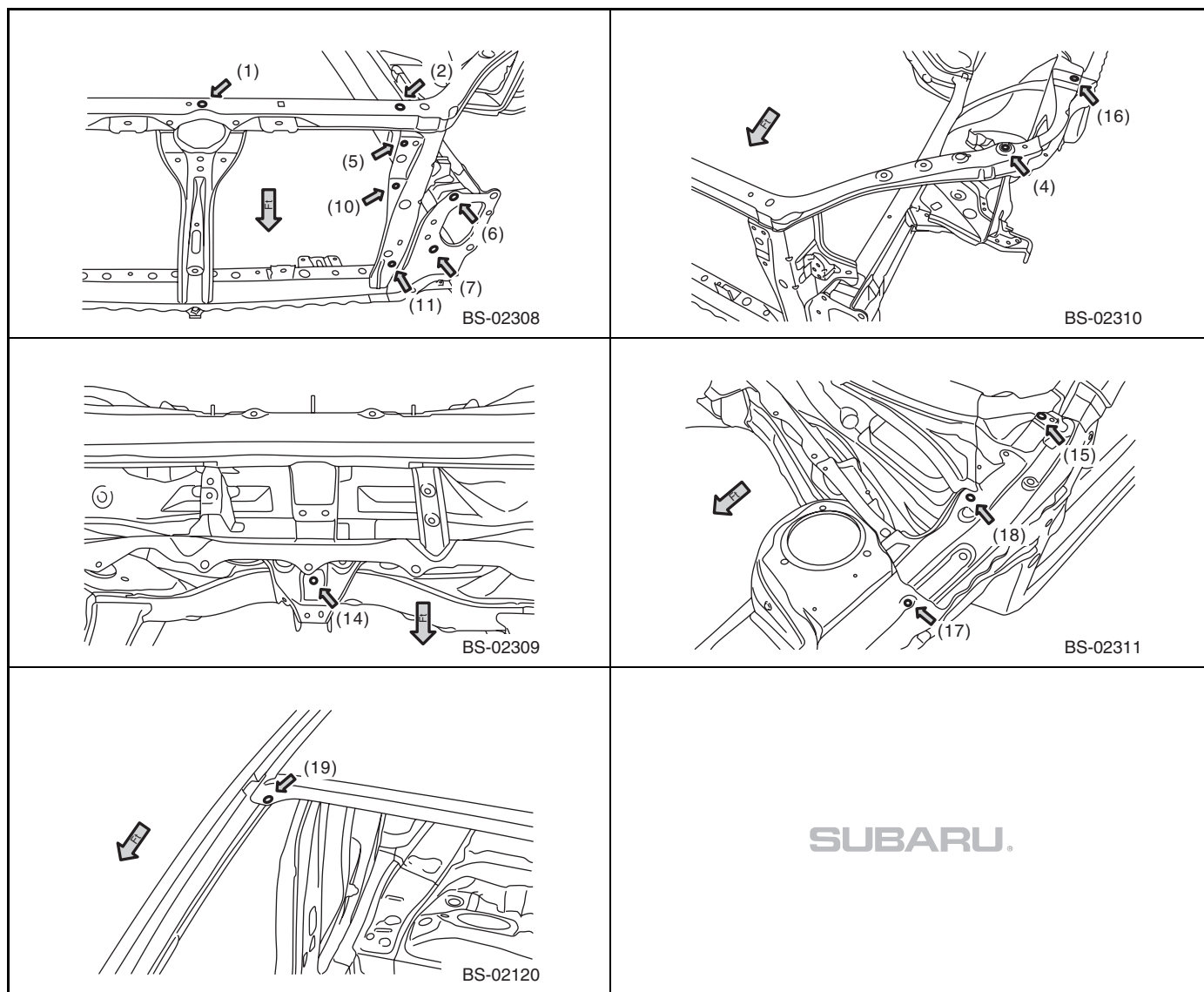
- | | | |
|---|---|--|
| (1) Repair location hole (body center) | (7) Front bumper beam mounting hole (symmetrical), lower side | (16) Fender mounting hole (symmetrical) |
| (2) Radiator mounting hole (symmetrical) | (10) Headlight bracket mounting hole (symmetrical) | (17) Fender mounting hole (symmetrical) |
| (4) Fender mounting hole (symmetrical) | (11) Front bumper bracket mounting hole (symmetrical) | (18) Hood hinge mounting hole (symmetrical) |
| (5) Headlight mounting hole (symmetrical) | (14) Weight reduction hole (body center) | (19) Front glass installation reference hole (symmetrical) |
| (6) Front bumper beam mounting hole (symmetrical), upper side | (15) Fender mounting hole (symmetrical) | |

Body Reference Points

| Measuring point | Datum dimension mm (in) |
|-----------------|-------------------------|
| (1) — (14) | 897 (35.31) |
| (2) — (14) | 951 (37.44) |
| (4) — (15) | 1,634 (64.33) |
| (4) — (16) | 1,418 (55.83) |
| (4) R — (18) R | 755 (29.72) |
| (4) R — (18) L | 1,537 (60.51) |
| (5) — (5) | 646 (25.43) |
| (5) — (7) | 814 (32.05) |
| (5) — (11) | 754 (29.68) |
| (6) — (6) | 900 (35.43) |

| Measuring point | Datum dimension mm (in) |
|-----------------|-------------------------|
| (6) — (7) | 910 (35.83) |
| (7) — (7) | 900 (35.43) |
| (10) — (10) | 660 (25.98) |
| (11) — (11) | 748 (29.45) |
| (16) R — (18) R | 453 (17.83) |
| (16) R — (18) L | 1,480 (58.27) |
| (17) R — (18) R | 211 (8.31) |
| (17) R — (18) L | 1,433 (56.42) |
| (18) — (19) | 1,543 (60.75) |

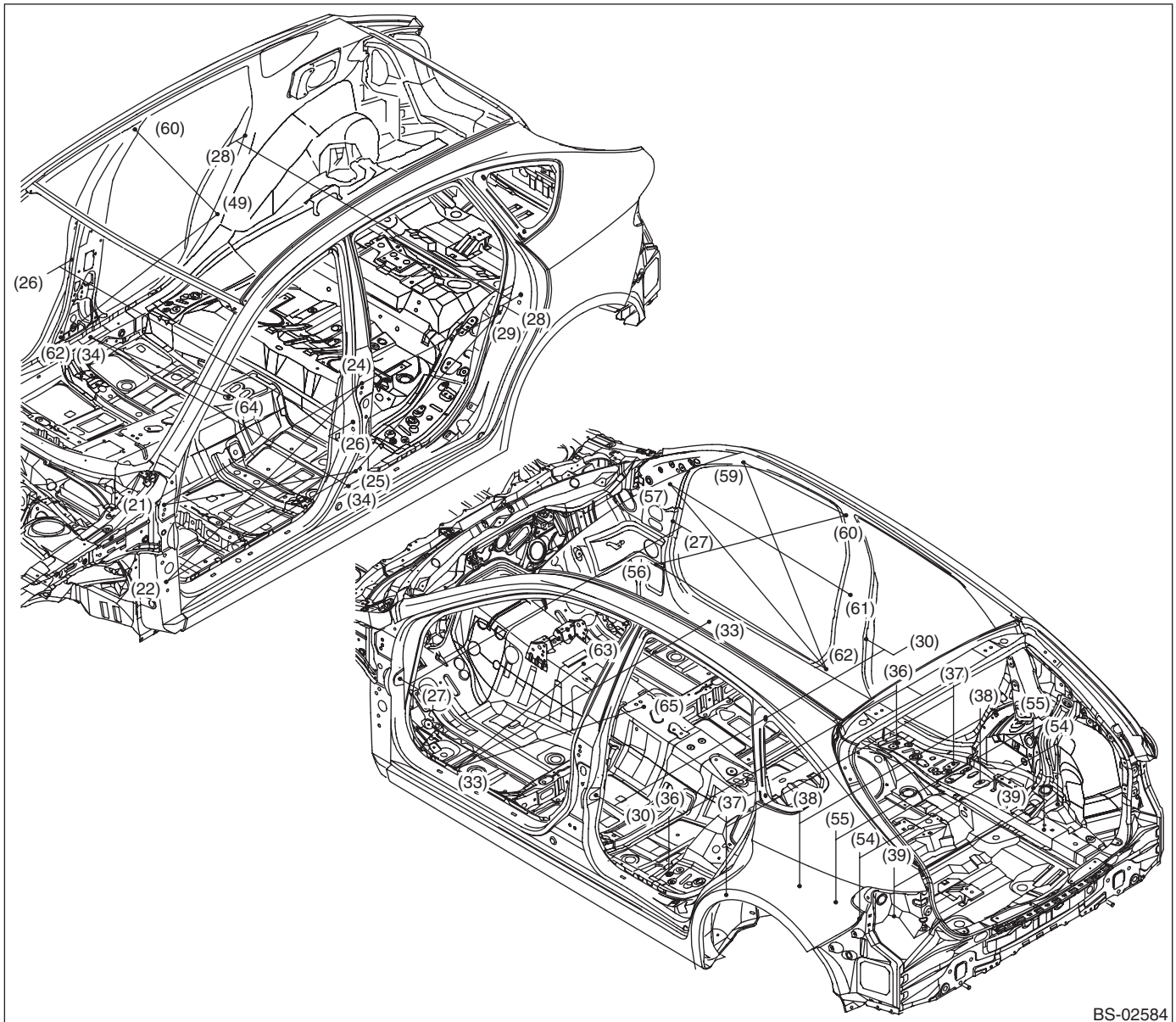
- The reference points (1) and (14) are at the body center, while the other reference points are left-right symmetrical.
- The dimensions are the actual dimensions between the reference points.



Body Reference Points

4. INSIDE 1

- **Common parts for 5 door and 4 door**



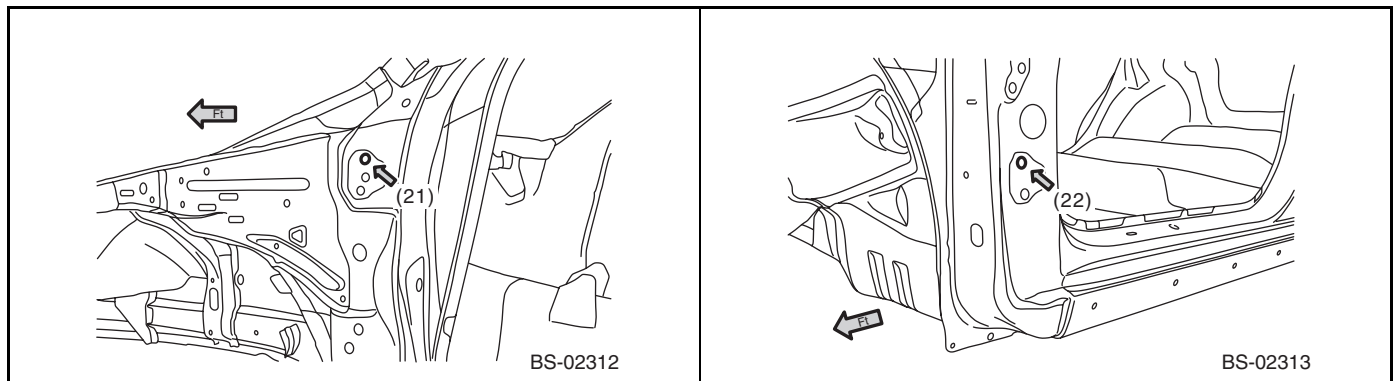
Body Reference Points

- | | | |
|--|---|--|
| (21) Front door hinge upper mounting hole (symmetrical), upper side (22) Front door hinge lower mounting hole (symmetrical), upper side (24) Rear door hinge upper mounting hole (symmetrical), upper side (25) Rear door hinge lower mounting hole (symmetrical), front (26) Front door striker mounting hole (symmetrical), upper side (27) Front door checker mounting hole (symmetrical) (28) Rear door striker mounting hole (symmetrical), upper side (29) Rear door switch mounting hole (symmetrical) (30) Rear door checker mounting hole (symmetrical) | (33) Harness clip mounting hole (symmetrical) (34) Harness clip mounting hole (symmetrical) (36) Gauge hole (symmetrical) (37) Trim clip mounting hole (symmetrical) (38) Rear seat hinge mounting hole (symmetrical) (39) Canister cover mounting hole (symmetrical) (49) Trim clip mounting hole (symmetrical) (54) Rear suspension mounting hole (symmetrical), rear (55) Rear suspension mounting hole (symmetrical), front | (56) Harness connectors mounting hole (symmetrical) (57) Steering beam mounting hole (symmetrical) (59) Front curtain airbag mounting hole (symmetrical) (60) Center curtain airbag mounting hole (symmetrical) (61) Gauge hole (symmetrical) (62) Trim clip mounting hole (symmetrical) (63) Airbag ECU mounting hole (body center) (64) Hand brake cable mounting hole (body center) (65) Hand brake mounting hole (body center) |
|--|---|--|

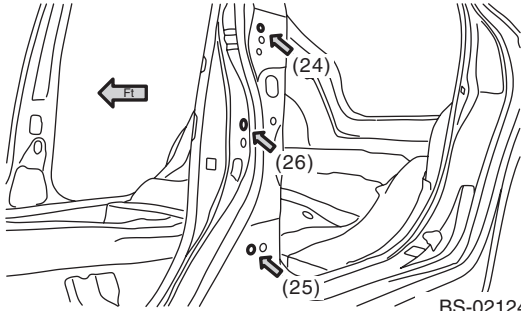
| Measuring point | Datum dimension mm (in) |
|-----------------|-------------------------|
| (21) — (24) | 1,069 (42.09) |
| (21) — (25) | 1,082 (42.60) |
| (22) — (24) | 1,141 (44.92) |
| (22) — (25) | 1,029 (40.51) |
| (24) — (29) | 821 (32.32) |
| (25) — (29) | 902 (35.51) |
| (26) — (26) | 1,520 (59.84) |
| (28) — (28) | 1,490 (58.66) |
| (34) — (34) | 1,394 (54.88) |
| (34) — (64) | 700 (27.56) |
| (49) — (60) | 985 (38.78) |
| (49) — (62) | 863 (33.98) |
| (27) — (27) | 1,473 (57.99) |
| (30) — (30) | 1,460 (57.48) |

| Measuring point | Datum dimension mm (in) |
|-----------------|-------------------------|
| (33) — (33) | 1,373 (54.06) |
| (33) — (63) | 704 (27.72) |
| (33) — (65) | 771 (30.35) |
| (36) — (36) | 1,230 (48.43) |
| (37) — (37) | 1,228 (48.35) |
| (38) — (38) | 976 (38.43) |
| (39) — (39) | 810 (31.89) |
| (54) — (54) | 1,070 (42.13) |
| (55) — (55) | 1,069 (42.09) |
| (56) — (60) | 1,454 (57.24) |
| (56) — (62) | 903 (35.55) |
| (57) — (61) | 976 (38.43) |
| (57) — (62) | 946 (37.24) |
| (59) — (60) | 576 (22.68) |
| (59) — (62) | 937 (36.89) |

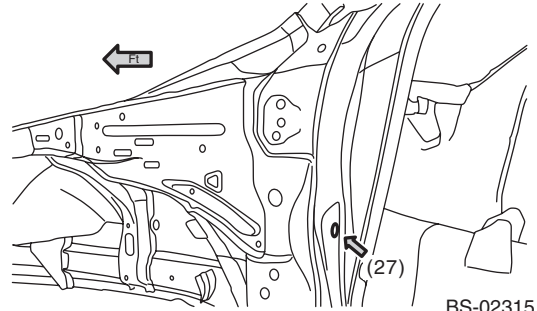
- The reference points (63), (64) and (65) are at the body center, while the other reference points are left-right symmetrical.
- The dimensions are the actual dimensions between the reference points.



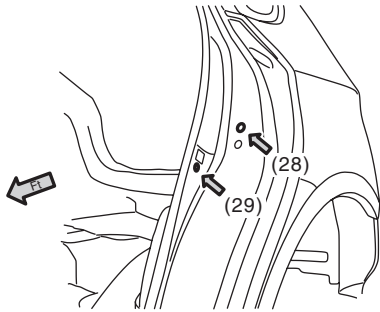
Body Reference Points



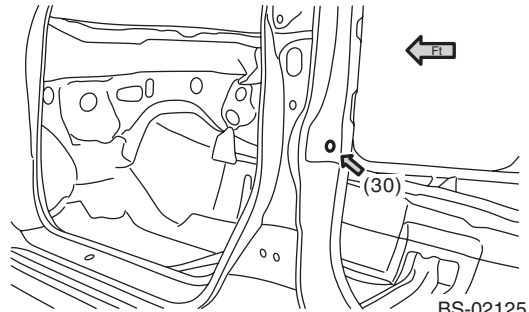
BS-02124



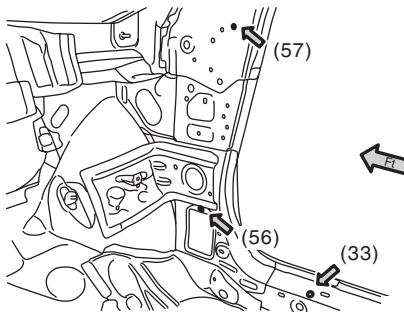
BS-02315



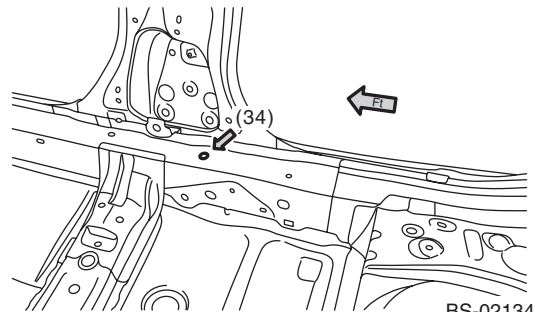
BS-02126



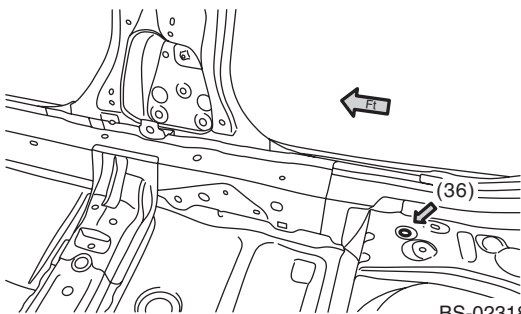
BS-02125



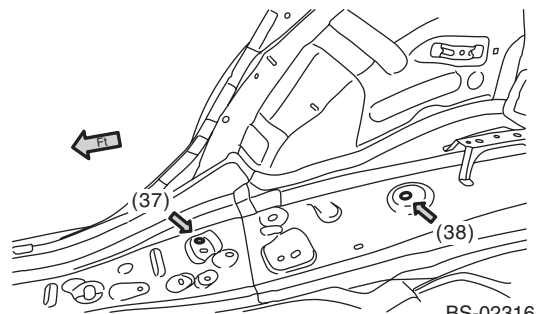
BS-02138



BS-02134

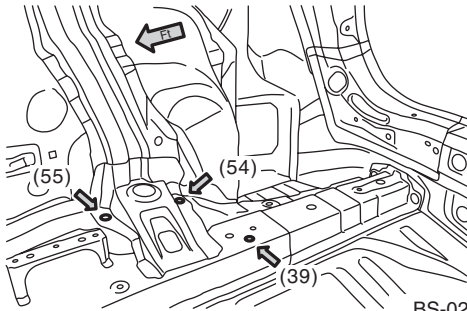


BS-02318

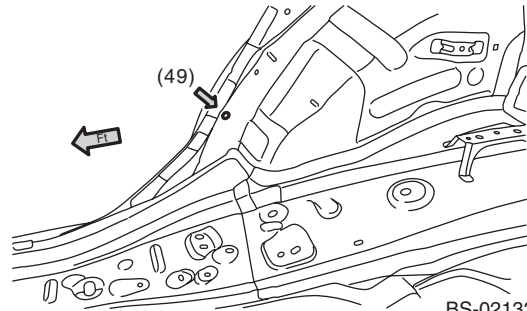


BS-02316

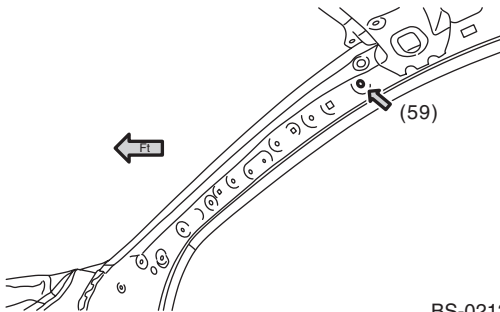
Body Reference Points



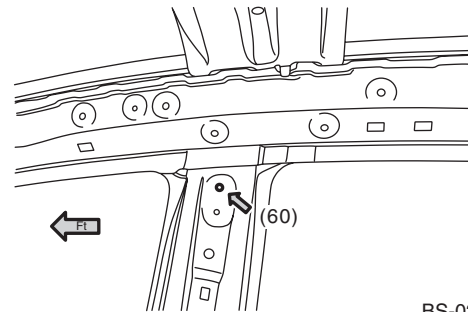
BS-02648



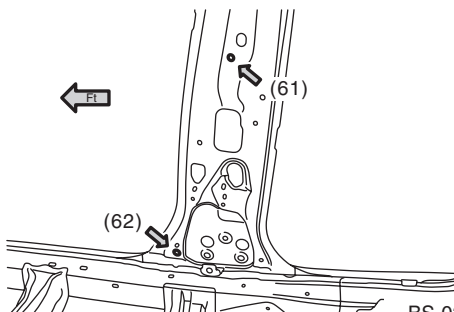
BS-02132



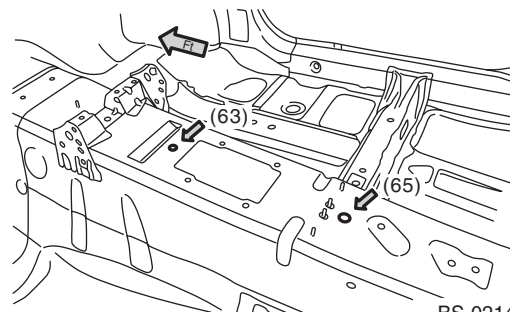
BS-02137



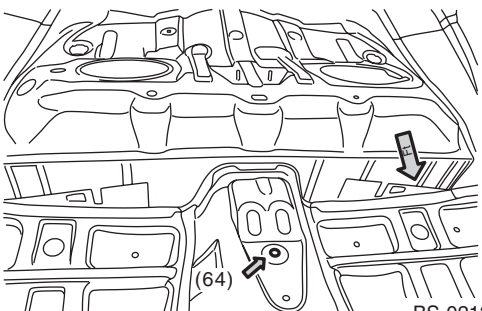
BS-02135



BS-02136



BS-02140



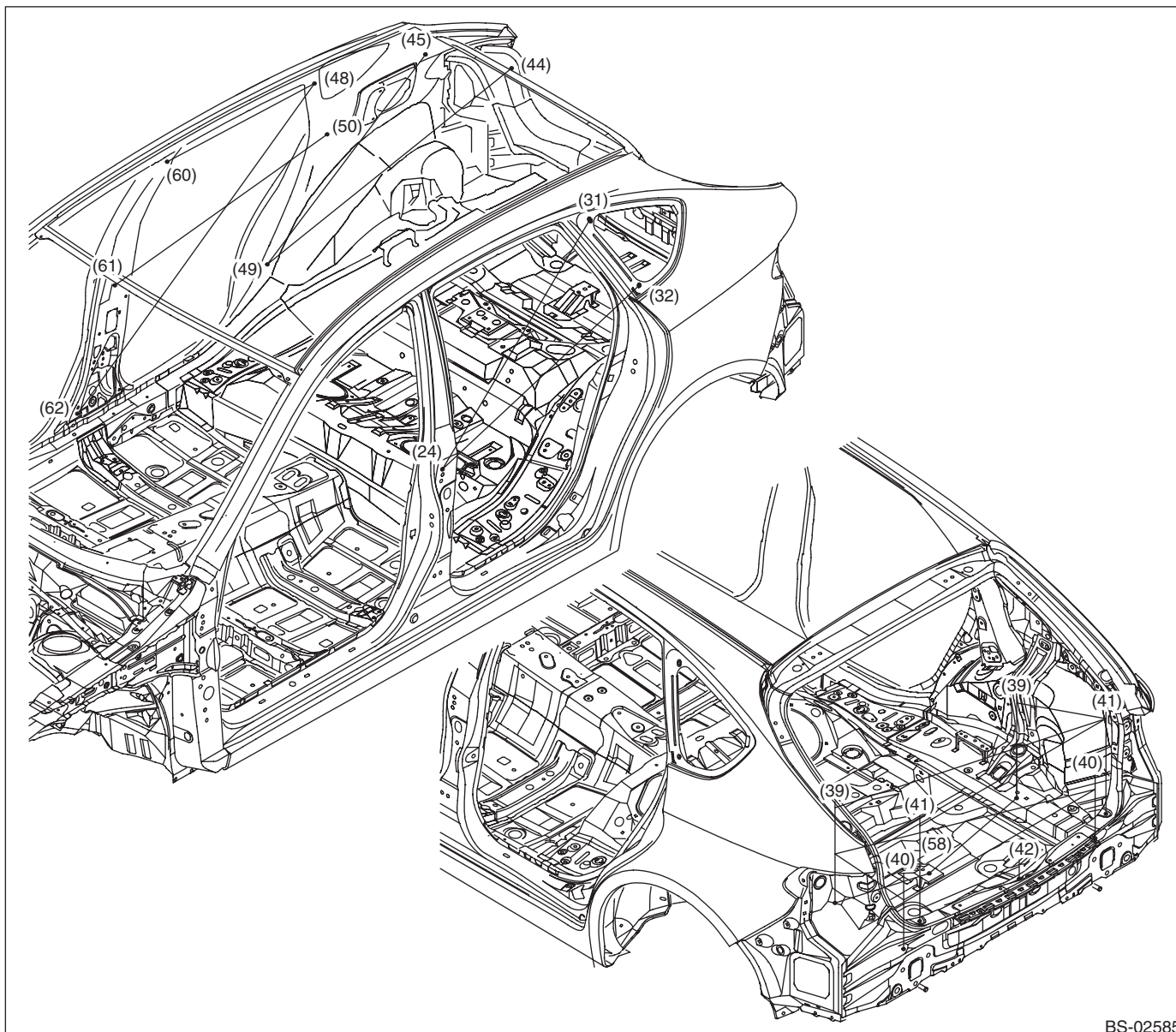
BS-02133

SUBARU.

Body Reference Points

5. INSIDE 2

- Special 5 door parts



BS-02585

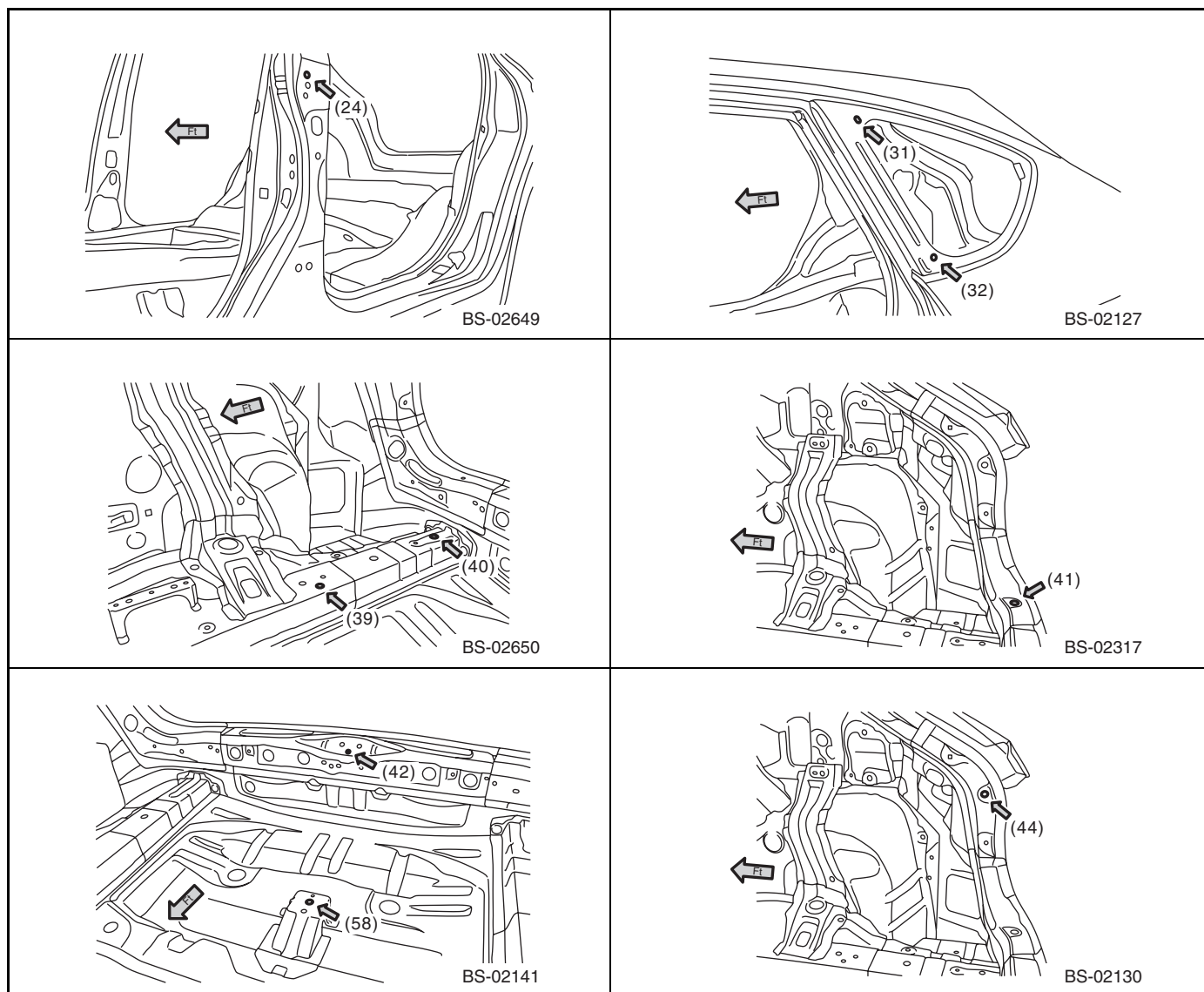
- | | | |
|--|--|--|
| (24) Rear door hinge upper mounting hole (symmetrical), upper | (42) Repair location hole (body center) | (58) Spare tire mounting hole |
| (31) Rear quarter glass mounting hole (symmetrical), front upper | (44) Trim clip mounting hole (symmetrical) | (60) Center curtain airbag mounting hole (symmetrical) |
| (32) Rear quarter glass mounting hole (symmetrical), front lower | (45) Trim clip mounting hole (symmetrical) | (61) Gauge hole (symmetrical) |
| (39) Canister cover mounting hole (symmetrical) | (48) Trim clip mounting hole (symmetrical) | (62) Trim clip mounting hole (symmetrical) |
| (40) Manufacturer assemblies hole (symmetrical) | (49) Trim clip mounting hole (symmetrical) | |
| (41) Trim clip mounting hole (symmetrical) | (50) Trim clip mounting hole (symmetrical) | |

Body Reference Points

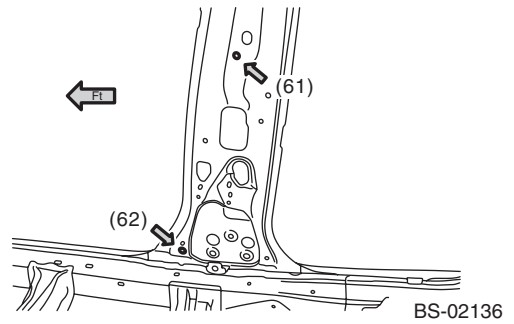
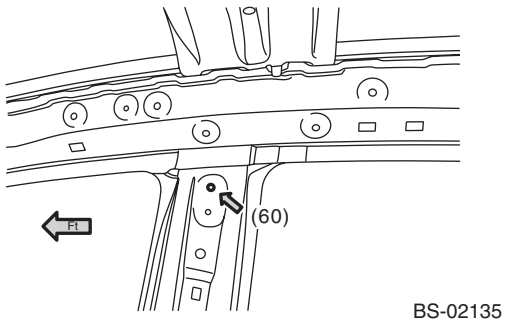
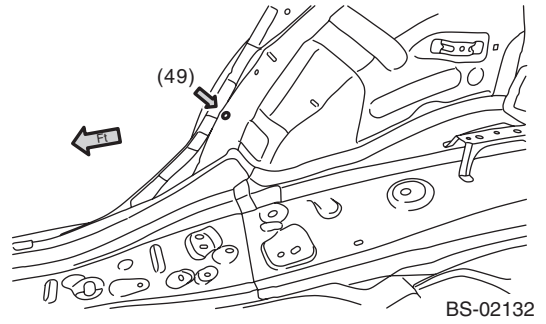
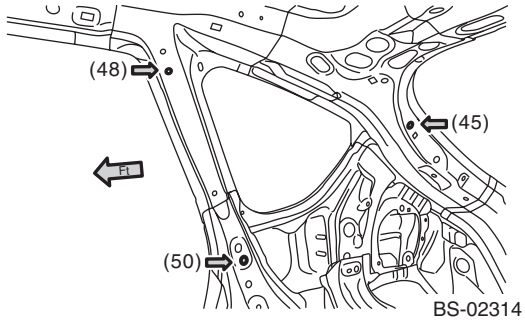
| Measuring point | Datum dimension mm (in) |
|-----------------|-------------------------|
| (24) — (31) | 966 (38.03) |
| (24) — (32) | 965 (37.99) |
| (44) — (49) | 1,012 (39.84) |
| (45) — (49) | 850 (33.46) |
| (48) — (60) | 658 (25.91) |
| (48) — (62) | 1,284 (50.55) |
| (50) — (61) | 920 (36.22) |
| (39) L — (40) L | 329 (12.95) |

| Measuring point | Datum dimension mm (in) |
|-----------------|-------------------------|
| (39) L — (40) R | 894 (35.20) |
| (39) R — (41) R | 409 (16.10) |
| (39) L — (41) R | 916 (36.06) |
| (39) R — (58) | 440 (17.32) |
| (39) L — (58) | 381 (15.00) |
| (40) — (40) | 854 (33.62) |
| (41) — (41) | 830 (32.68) |
| (41) — (42) | 417 (16.42) |

- The reference point (42) is at the body center, while the other points except for (58) is left-right symmetrical.
- The dimensions are the actual dimensions between the reference points.



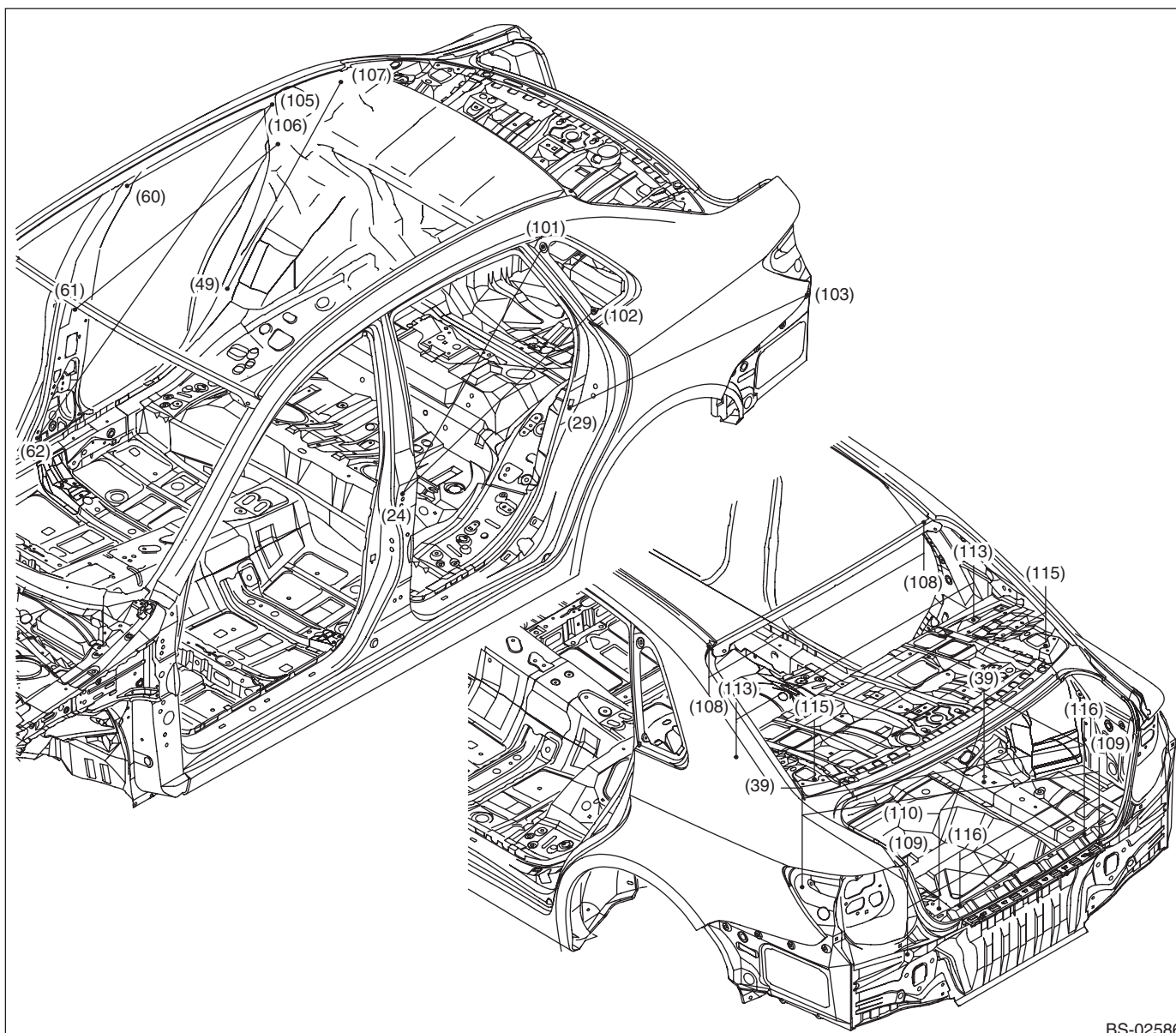
Body Reference Points



Body Reference Points

6. INSIDE 3

• Special 4 door parts



BS-02586

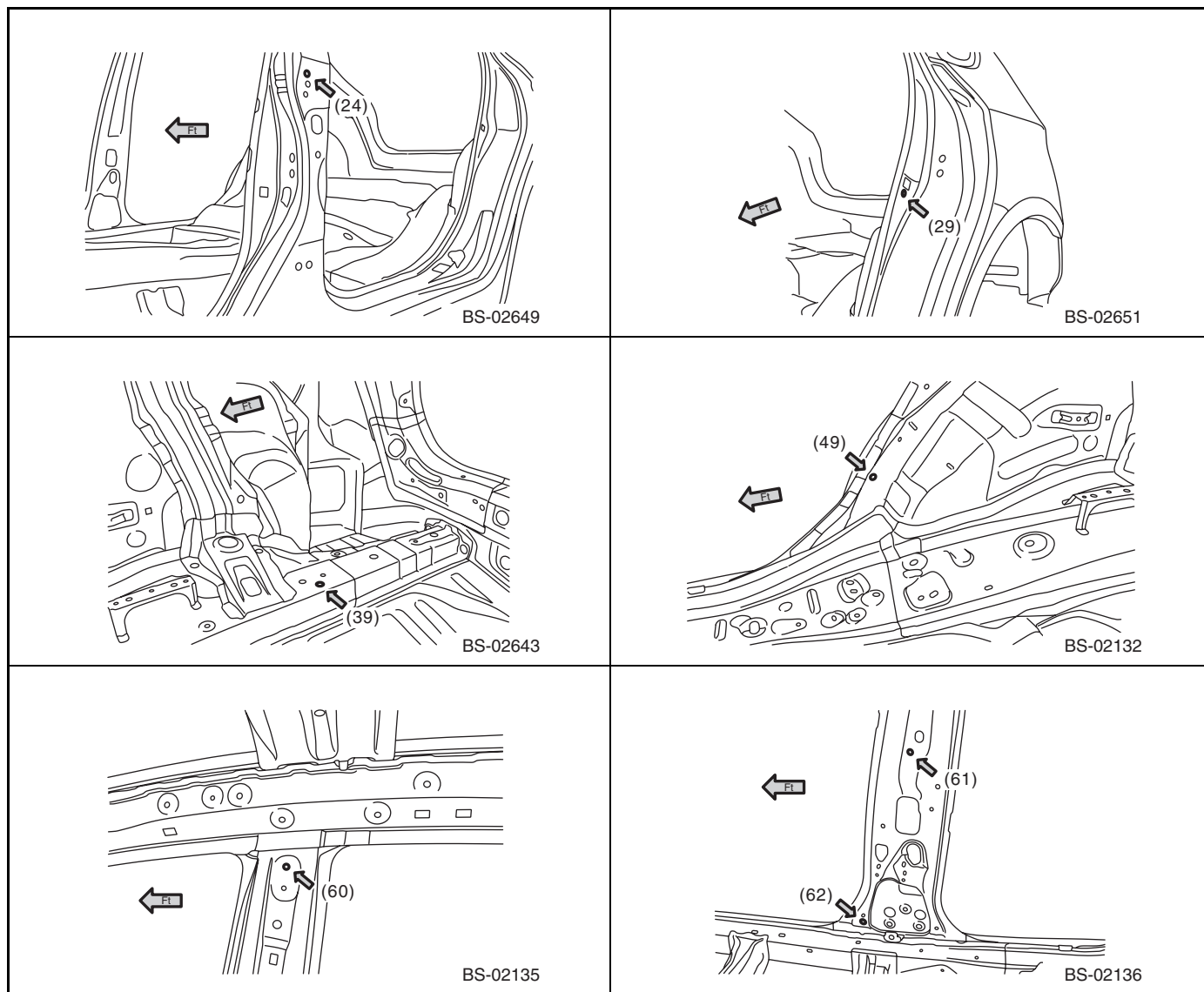
| | | |
|--|---|--|
| (24) Rear door hinge upper mounting hole (symmetrical), upper side | (101) Rear quarter glass mounting hole (symmetrical), front upper | (109) Manufacturer assemblies hole (symmetrical) |
| (29) Rear door switch mounting hole (symmetrical) | (102) Rear quarter glass mounting hole (symmetrical), front lower | (110) Spare tire mounting hole (body center) |
| (39) Canister cover mounting hole (symmetrical) | (103) Rear bumper bracket mounting hole (symmetrical) | (113) Rear shelf mounting hole (symmetrical) |
| (49) Trim clip mounting hole (symmetrical) | (105) Rear curtain airbag mounting hole (symmetrical) | (115) Trunk hinge mounting hole (symmetrical) |
| (60) Center curtain airbag mounting hole (symmetrical) | (106) Trim clip mounting hole (symmetrical) | (116) Electrodeposition hole (symmetrical) |
| (61) Gauge hole (symmetrical) | (107) Trim clip mounting hole (symmetrical) | |
| (62) Trim clip mounting hole (symmetrical) | (108) Drain hose mounting hole (symmetrical) | |

Body Reference Points

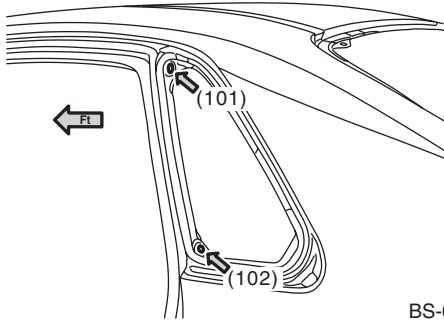
| Measuring point | Datum dimension mm (in) |
|------------------|-------------------------|
| (24) — (101) | 944 (37.15) |
| (24) — (102) | 953 (37.50) |
| (29) — (103) | 991 (39.02) |
| (49) — (107) | 766 (30.15) |
| (60) — (105) | 633 (24.91) |
| (61) — (106) | 906 (35.69) |
| (62) — (105) | 1,291 (50.82) |
| (39) L — (109) L | 492 (19.35) |
| (39) L — (109) R | 966 (38.03) |

| Measuring point | Datum dimension mm (in) |
|------------------|-------------------------|
| (39) — (110) | 489 (19.26) |
| (39) R — (116) R | 608 (23.94) |
| (39) L — (116) R | 905 (35.62) |
| (108) — (108) | 958 (37.71) |
| (109) — (109) | 854 (33.62) |
| (113) — (113) | 1,058 (41.65) |
| (115) — (115) | 1,030 (40.55) |
| (116) — (116) | 554 (21.81) |

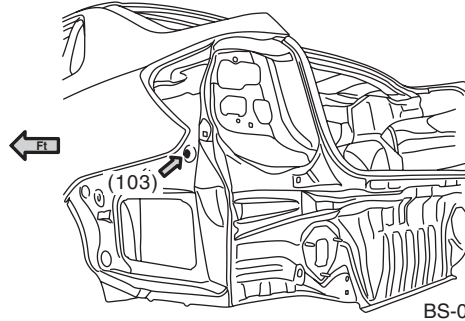
- The reference point (110) is at the body center, while the other reference points are left-right symmetrical.
- The dimensions are the actual dimensions between the reference points.



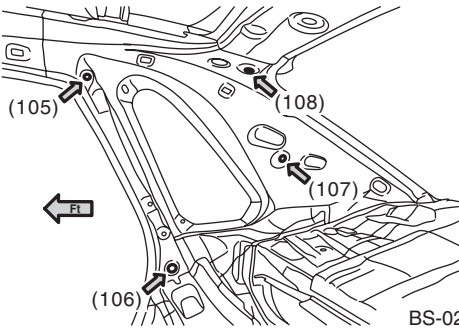
Body Reference Points



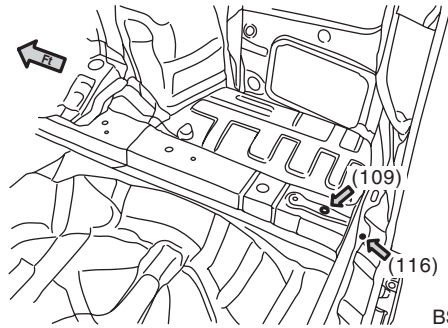
BS-02587



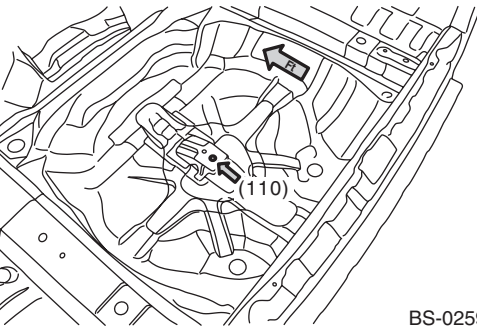
BS-02588



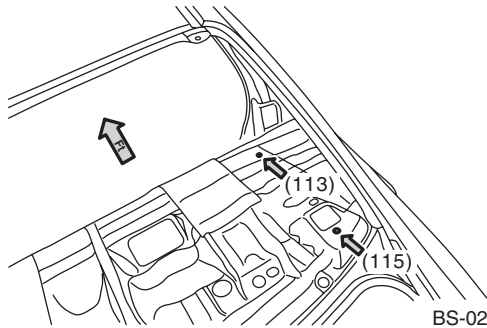
BS-02589



BS-02590



BS-02591

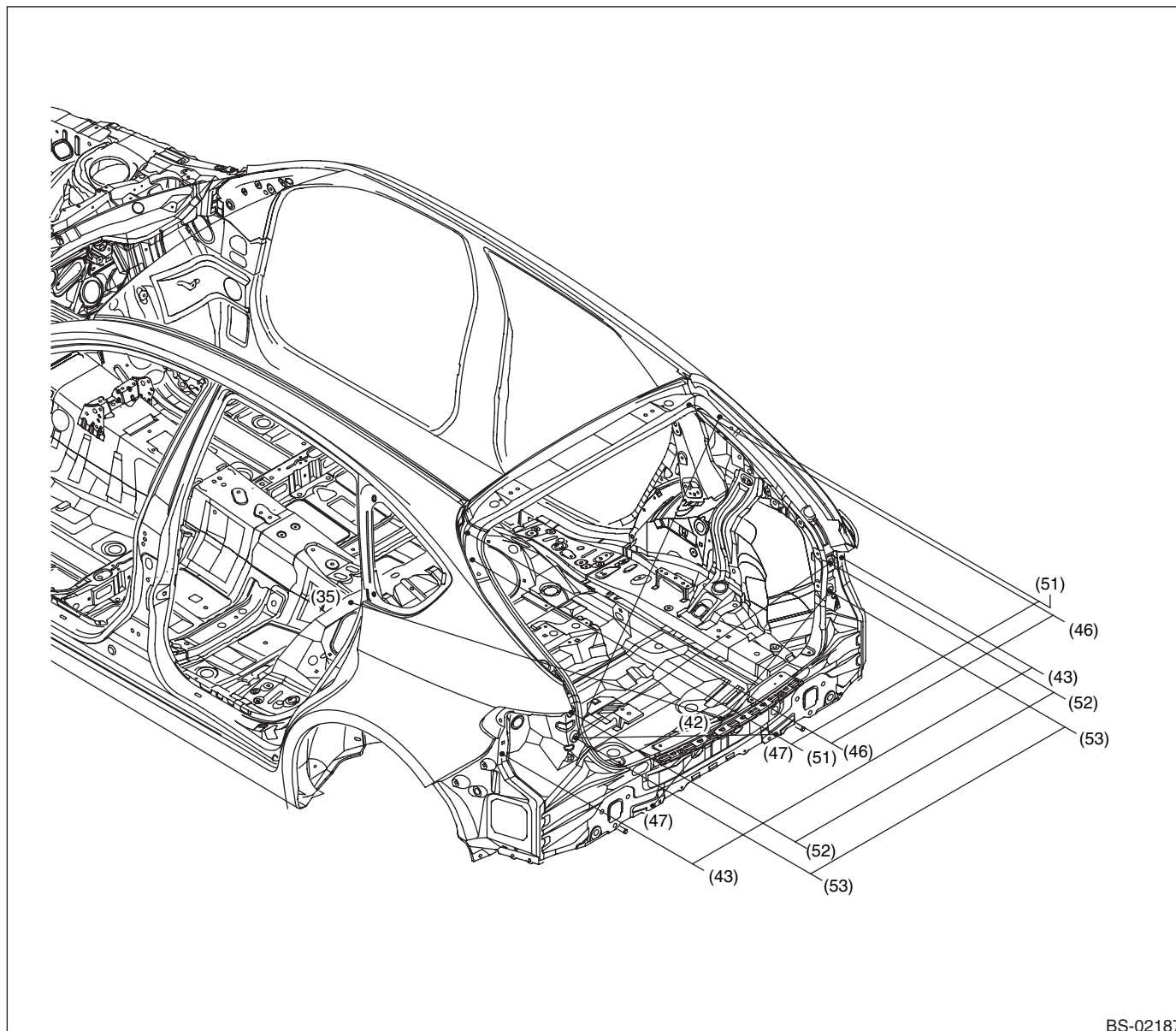


BS-02592

Body Reference Points

7. REAR 1

• Special 5 door parts



BS-02187

(35) Floor mat mounting hole (symmetrical)

(42) Repair location hole (body center)

(43) Rear bumper mounting hole (symmetrical)

(46) Rear curtain airbag mounting hole (symmetrical)

(47) Rear bumper bracket mounting hole

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

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

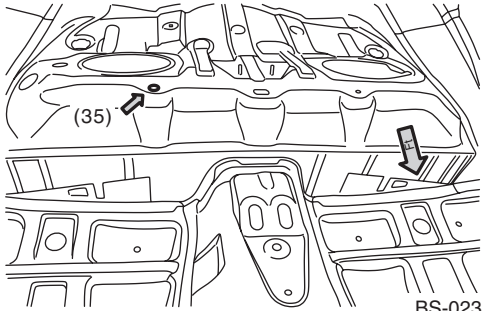
(53) Rear combination light mounting hole (symmetrical), lower side

| Measuring point | Datum dimension mm (in) |
|-----------------|-------------------------|
| (35) — (42) | 1,442 (56.77) |
| (43) — (43) | 1,486 (58.50) |
| (46) — (46) | 970 (38.19) |
| (47) R — (53) L | 913 (35.94) |
| (47) L — (53) R | 905 (35.63) |

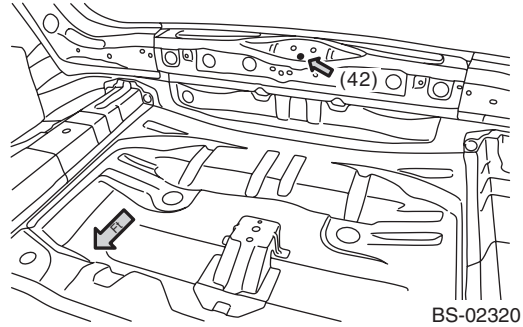
| Measuring point | Datum dimension mm (in) |
|-----------------|-------------------------|
| (51) — (51) | 1,082 (42.60) |
| (52) — (52) | 1,132 (44.57) |
| (53) — (53) | 1,112 (43.78) |
| (51) — (53) | 1,268 (49.92) |
| (52) — (53) | 1,126 (44.33) |

Body Reference Points

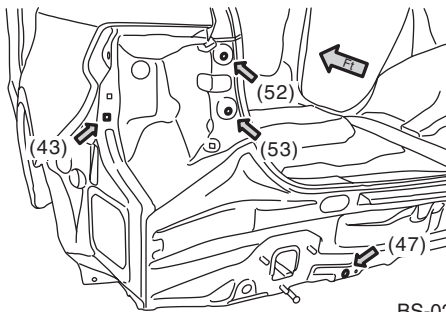
- The reference point (42) is at the body center, while the other points except for (47) is left-right symmetrical.
- The dimensions are the actual dimensions between the reference points.



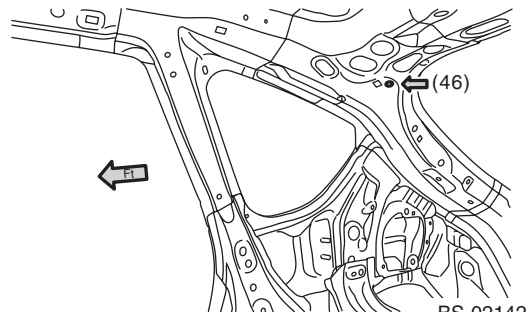
BS-02319



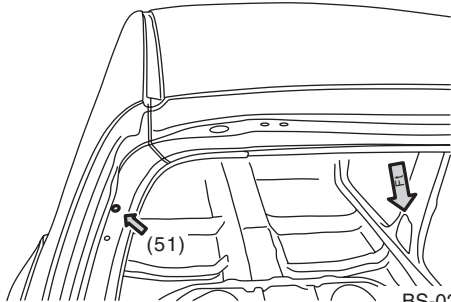
BS-02320



BS-02128



BS-02142



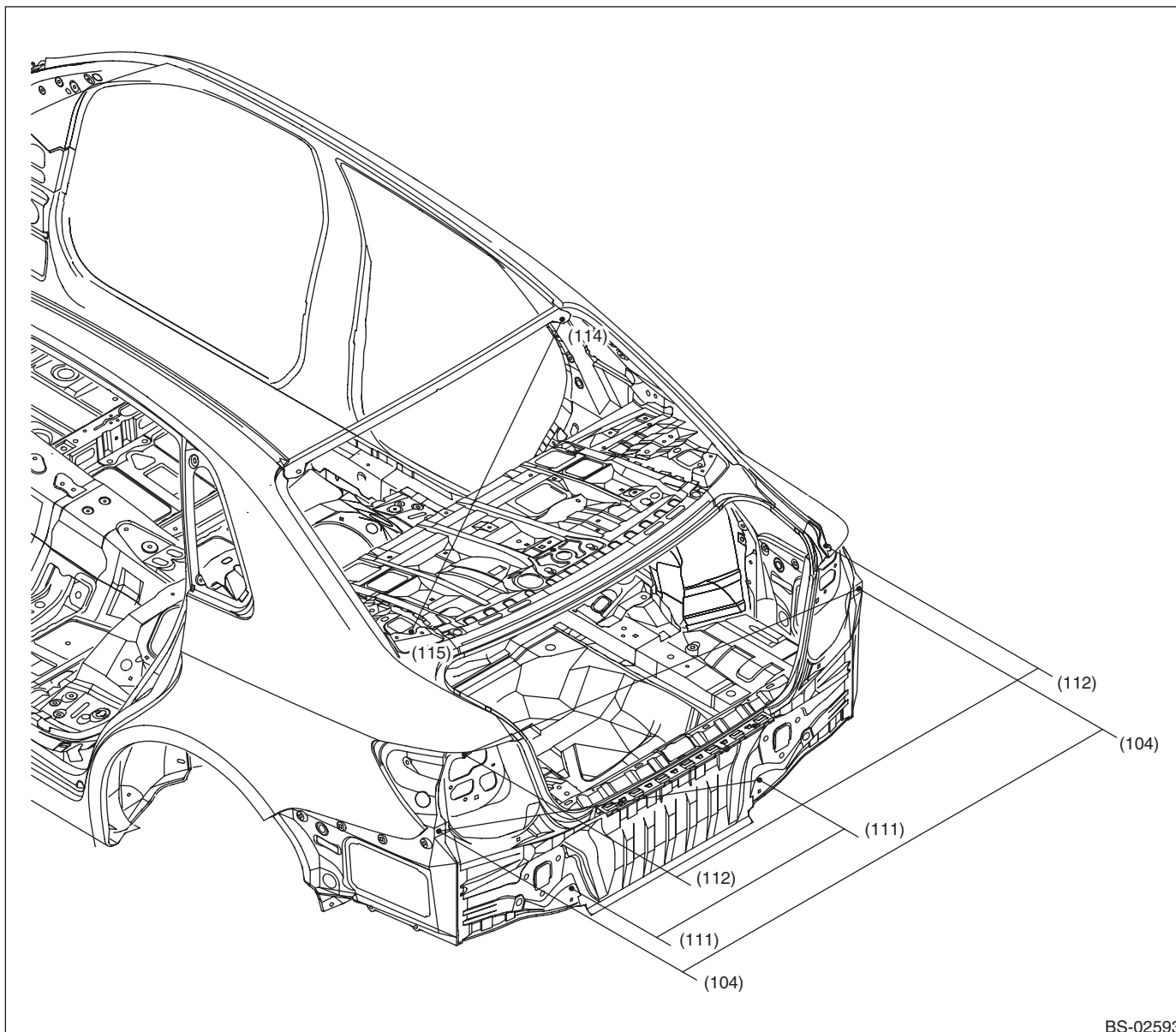
BS-02129

SUBARU.

Body Reference Points

8. REAR 2

- Special 4 door parts



(104) Rear bumper mounting hole (symmetrical)

(111) Rear beam bracket mounting hole (symmetrical)

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

(114) Rear glass installation reference hole (symmetrical)

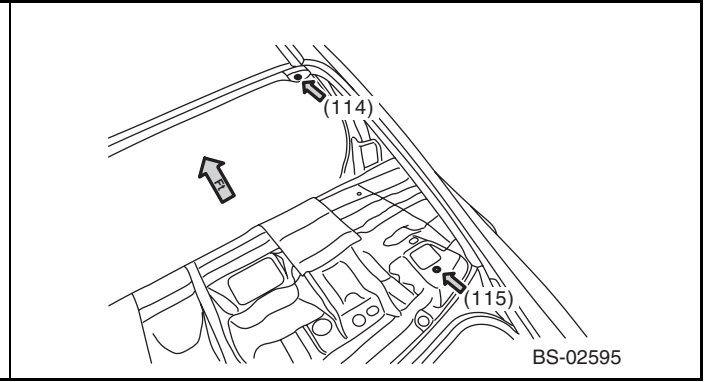
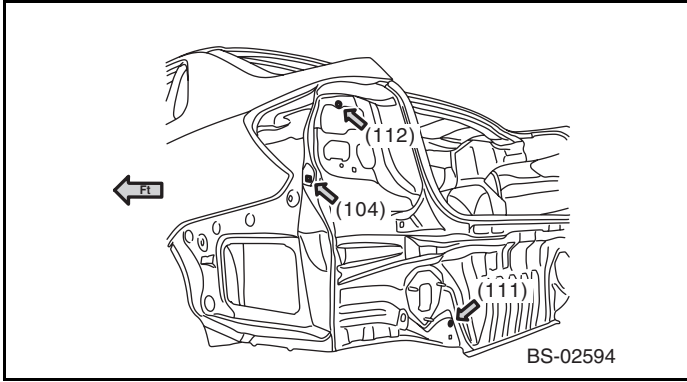
(115) Trunk hinge mounting hole (symmetrical)

| Measuring point | Datum dimension mm (in) |
|-----------------|-------------------------|
| (104) — (104) | 1,498 (58.98) |
| (104) — (111) | 1,142 (44.96) |
| (104) — (112) | 1,405 (55.31) |

| Measuring point | Datum dimension mm (in) |
|-----------------|-------------------------|
| (111) — (111) | 670 (26.38) |
| (112) — (112) | 1,290 (50.79) |
| (114) — (115) | 1,110 (43.70) |

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

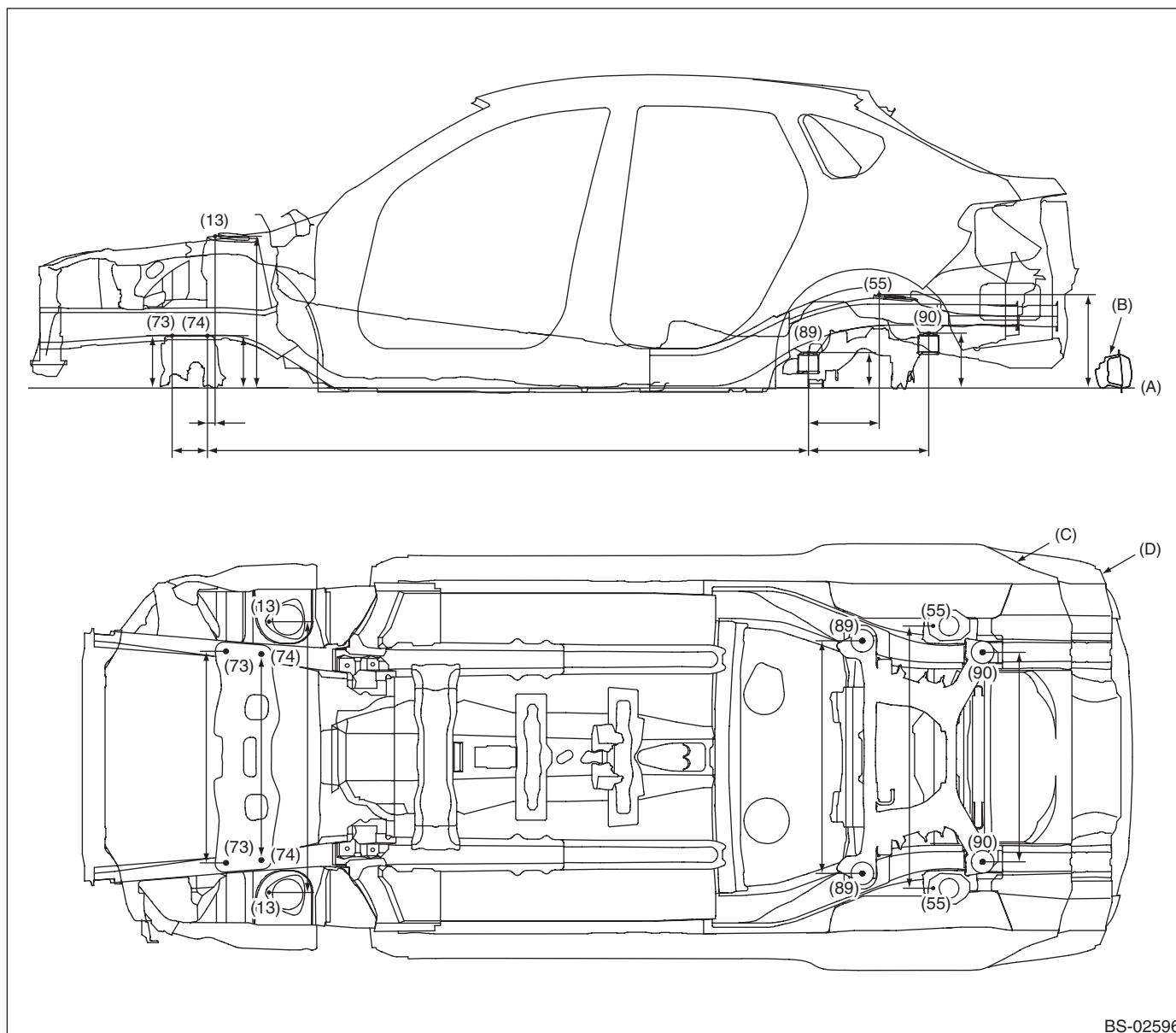
Body Reference Points



Body Reference Points

9. SUSPENSION MOUNT (CROSSMEMBER)

Unit: mm



BS-02596

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

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

(C) 5 door

(D) 4 door

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

(73) Front crossmember mounting hole (symmetrical), front

(89) Rear suspension crossmember mounting hole (symmetrical)

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

(74) Front crossmember mounting hole (symmetrical), rear

(90) Rear suspension crossmember mounting hole (symmetrical)

Body Reference Points

CAUTION:

- For the position of the reference points (13), refer to the figure "FRONT 1, DIMENSIONS, Body Reference Points" on page 74.
- For the position of the reference points (55), refer to the figure "INSIDE 1, DIMENSIONS, Body Reference Points" on page 79.
- For the position of the other reference points, refer to the figure "LOWER SURFACE, DIMENSIONS, Body Reference Points" on page 70.

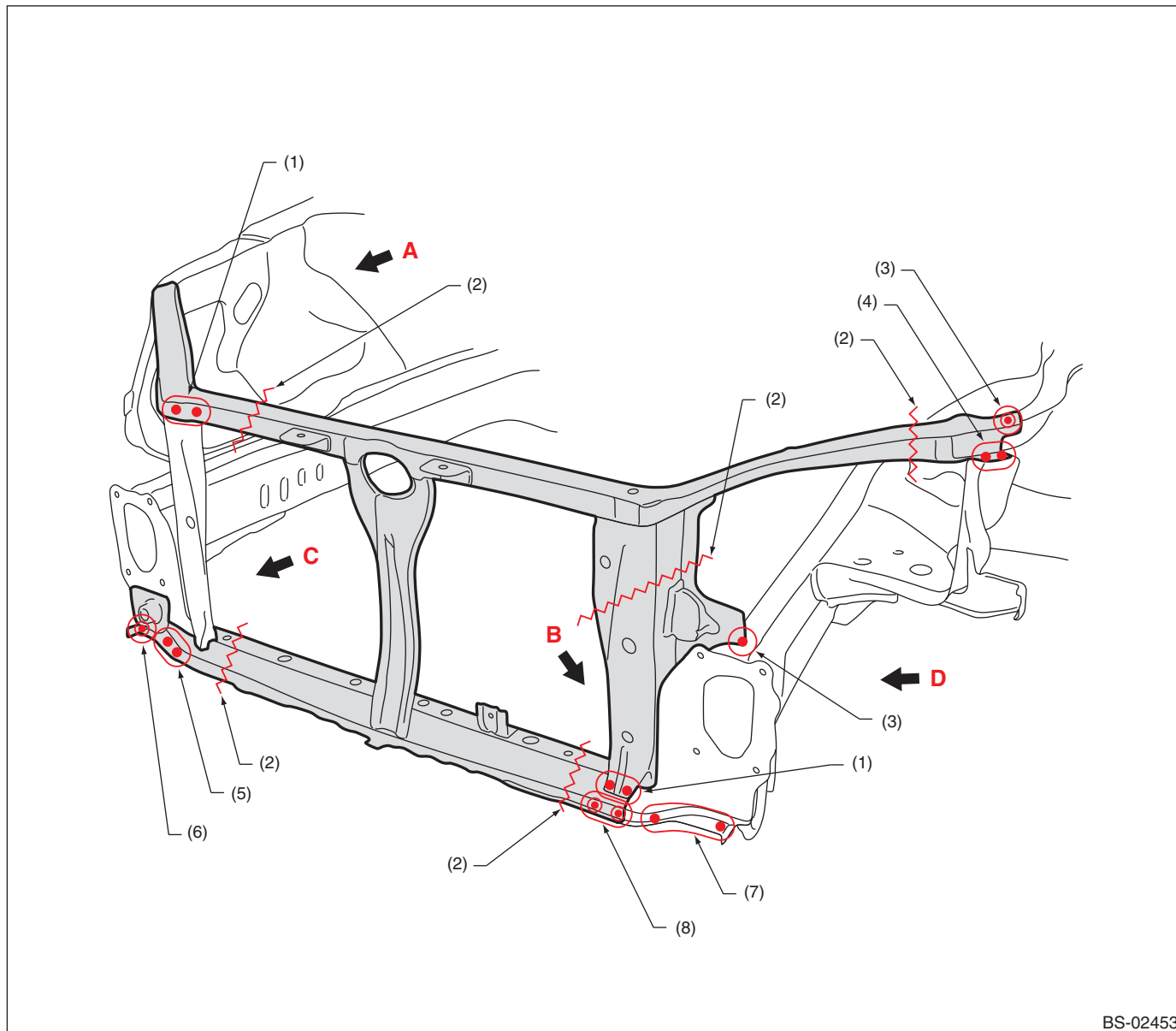
| Measuring point | Datum dimension mm (in) |
|-------------------|-------------------------|
| Datum line — (13) | 616 (24.25) |
| Datum line — (55) | 376 (14.80) |
| Datum line — (73) | 213 (8.39) |
| Datum line — (74) | 213 (8.39) |
| Datum line — (89) | 144 (5.67) |
| Datum line — (90) | 223 (8.78) |
| (13) — (13) | 1,103 (43.43) |
| (13) — (74) | 31 (1.22) |
| (55) — (55) | 1,069 (42.09) |

| Measuring point | Datum dimension mm (in) |
|-----------------|-------------------------|
| (55) — (89) | 288 (11.34) |
| (73) — (73) | 862 (33.94) |
| (73) — (74) | 144 (5.67) |
| (74) — (74) | 840 (33.07) |
| (74) — (89) | 2,450 (96.46) |
| (89) — (89) | 948 (37.32) |
| (89) — (90) | 490 (19.29) |
| (90) — (90) | 855 (33.66) |

12.Radiator Panel (total replacement)

A: REMOVAL

• Overall view



BS-02453

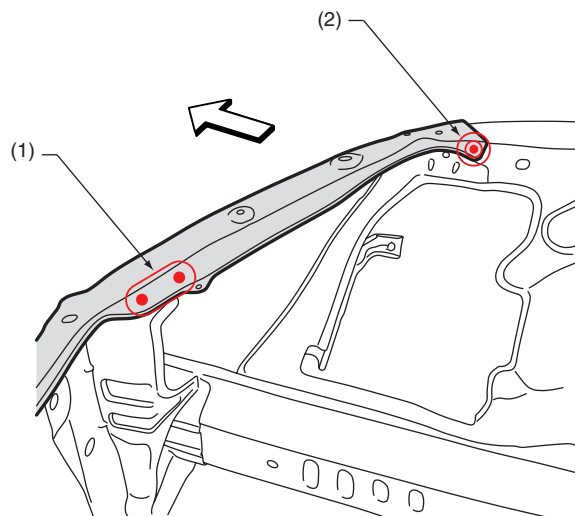
- (1) 2 points (outside · 1)
- (2) Rough cutting
- (3) 1 point (top · 1)

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

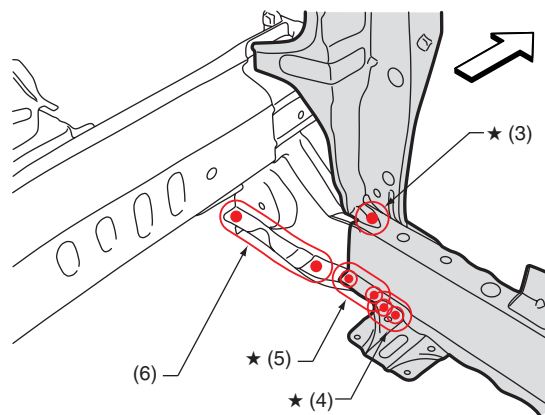
- (7) 3 points (bottom · 1)
- (8) 2 points (top · 1, bottom · 1)

Radiator Panel (total replacement)

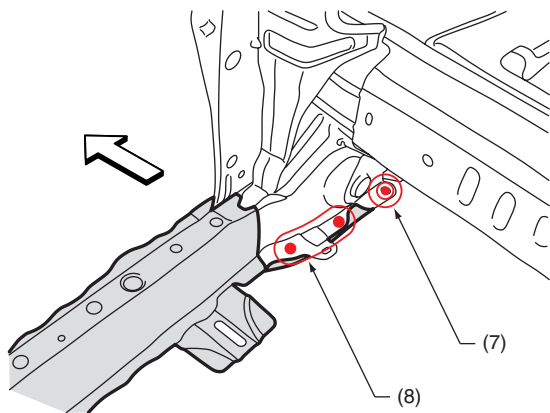
• Views



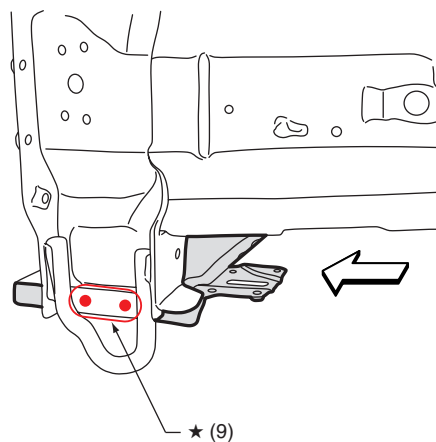
A



B



C



D

BS-02454

(1) 2 points (inside · 1)

(2) 1 point (inside · 1)

(3) 1 point (top · 1)

(4) 2 points (top · 1, bottom · 1)

(5) 3 points (top · 1, bottom · 1)

(6) 3 points (bottom · 1)

(7) 1 point (bottom · 1)

(8) 2 points (bottom · 1)

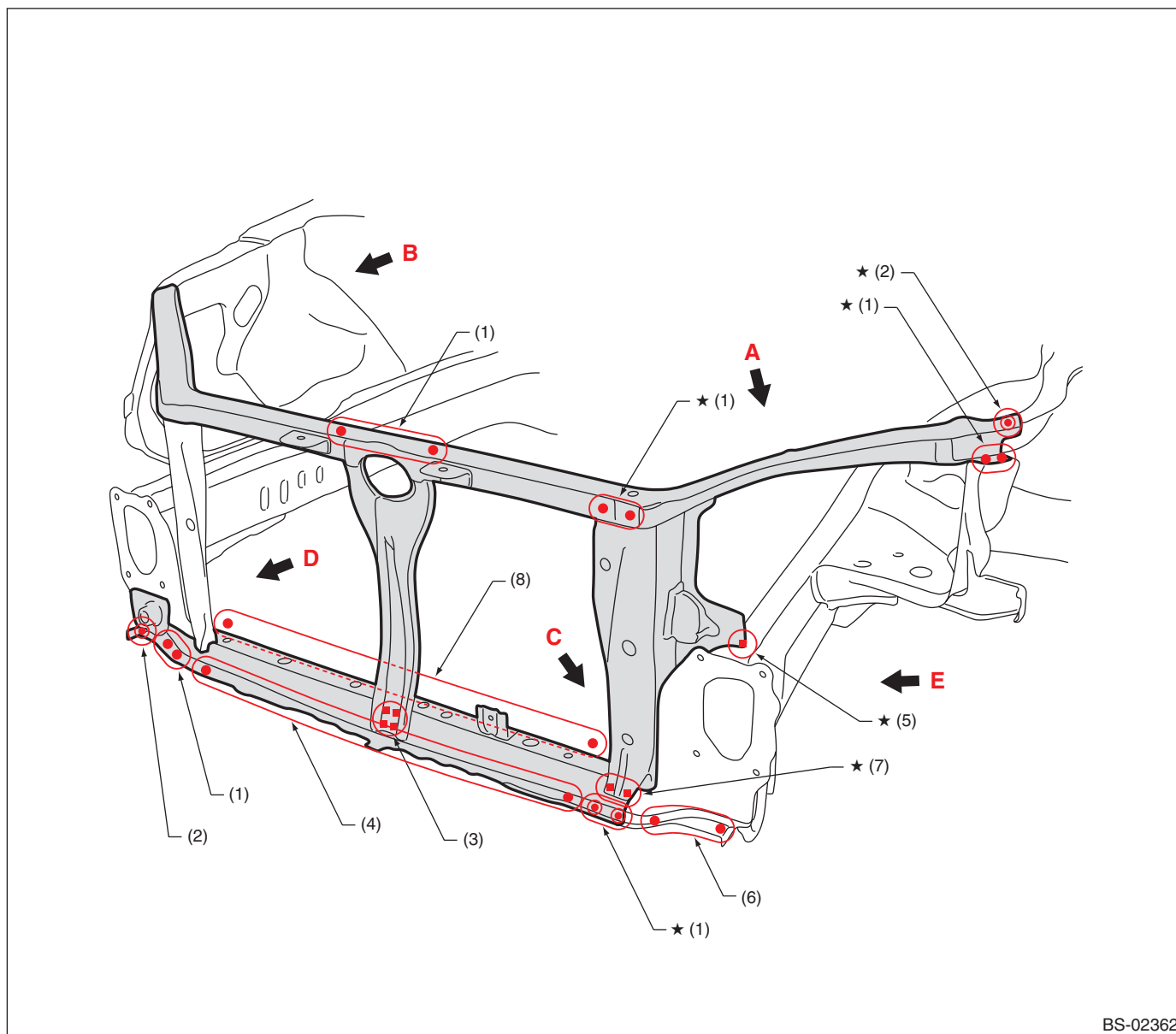
(9) 2 points (outside · 1)

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

Radiator Panel (total replacement)

B: INSTALLATION

• Overall view



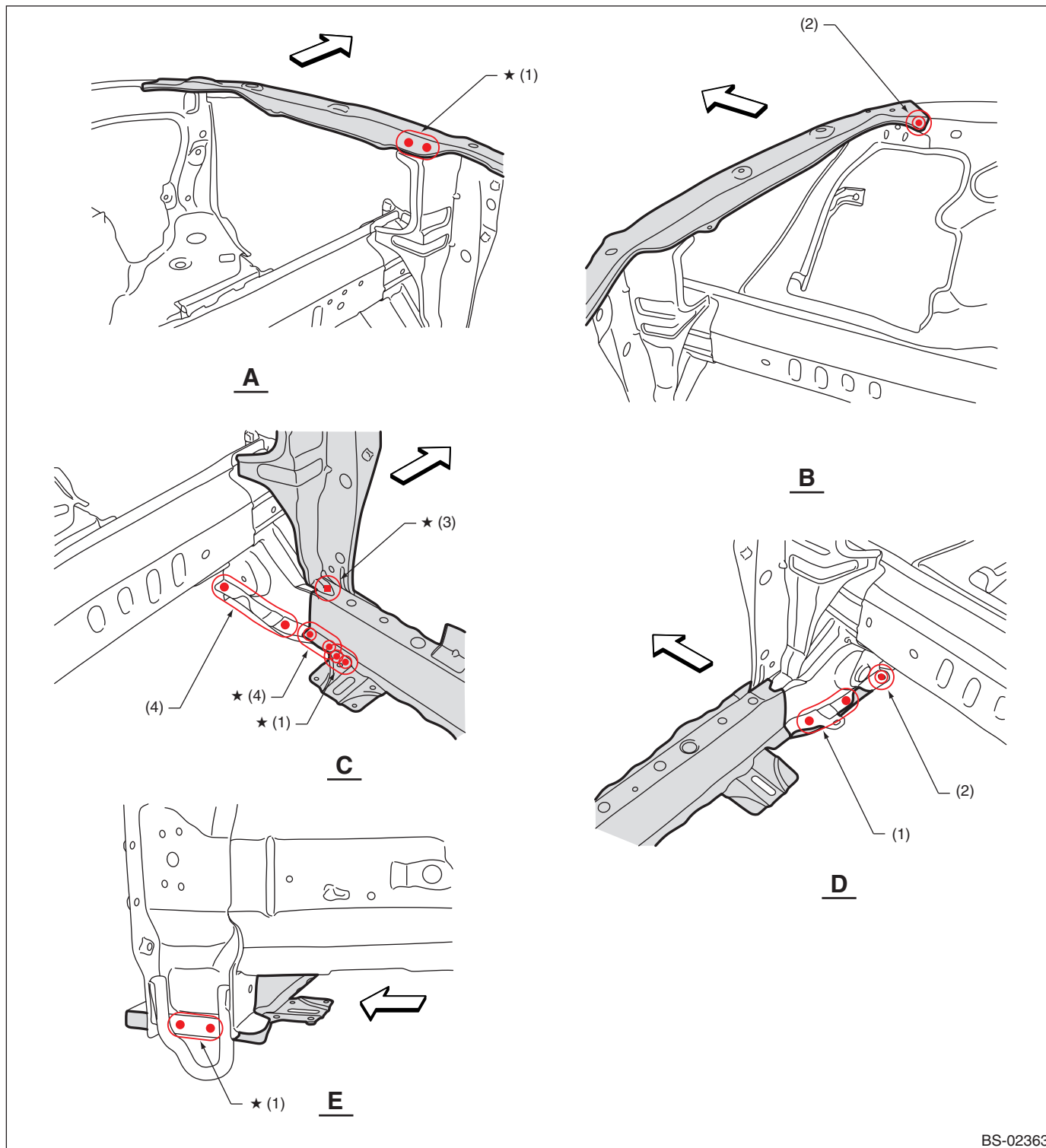
BS-02362

- | | | |
|------------------------|-----------------------|------------------------|
| (1) 2 points | (4) 16 points | (7) 2 points (service) |
| (2) 1 point | (5) 1 point (service) | (8) 9 points |
| (3) 4 points (service) | (6) 3 points | |

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

Radiator Panel (total replacement)

• Views



BS-02363

(1) 2 points
(2) 1 point

(3) 1 point (service)

(4) 3 points

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

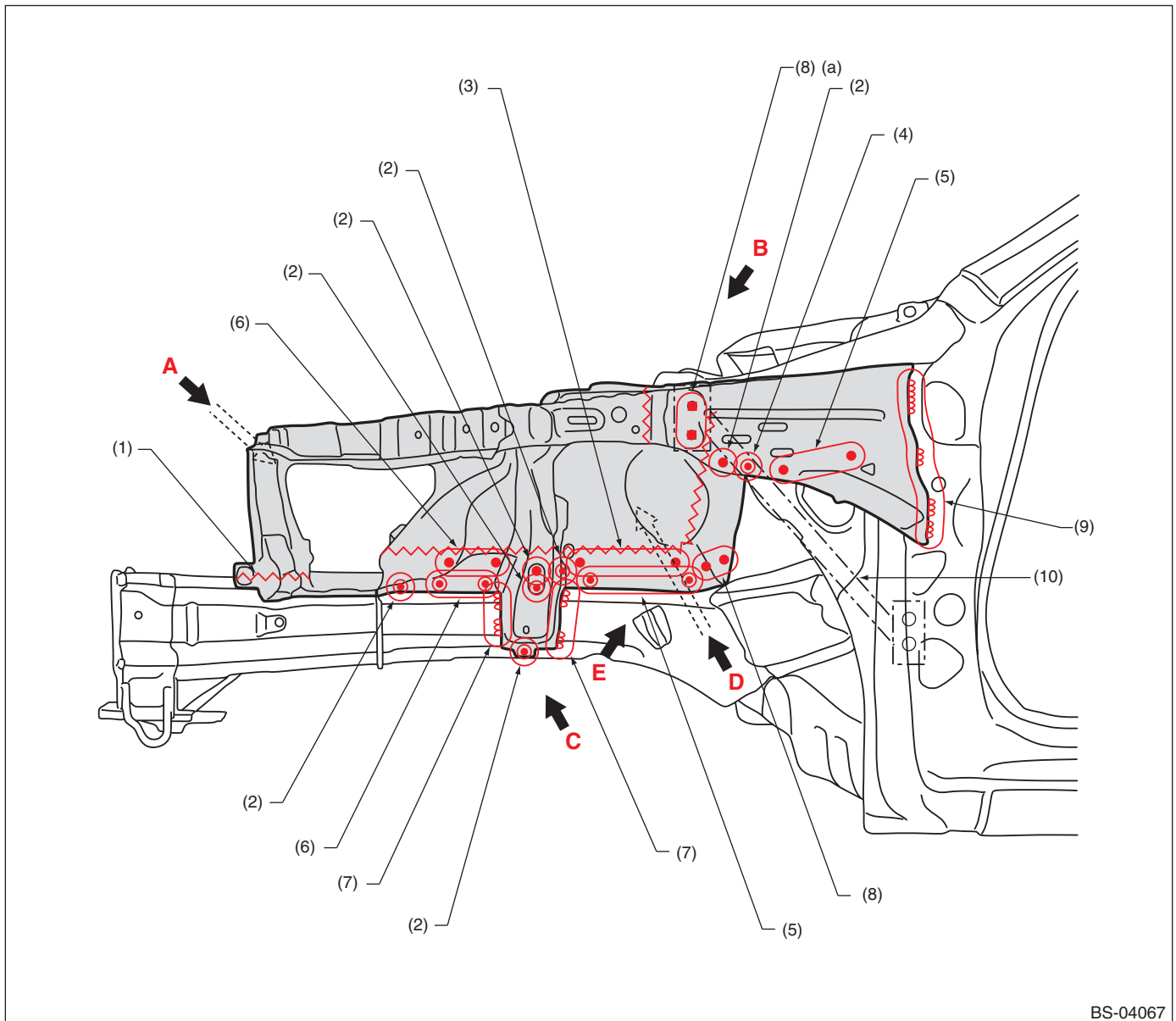
Front Wheel Apron (total replacement)

13.Front Wheel Apron (total replacement)

A: REMOVAL

1) Radiator panel removal condition

• Overall view



BS-04067

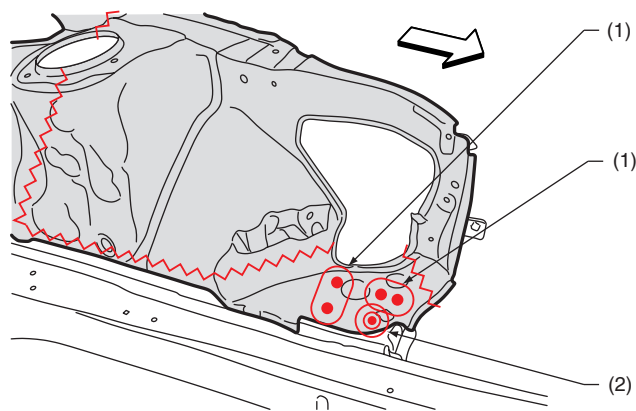
- | | | |
|----------------------------|---|---|
| (1) Rough cutting | (5) 4 points (outside · 1) | (8) 2 points (outside · 1) |
| (2) 1 point (outside · 1) | (6) 3 points (outside · 1) | (9) 4 points (outside · 1, belt sander) |
| (3) 6 points (outside · 1) | (7) 2 points (outside · 1, belt sander) | (10) Stay cowl side |
| (4) 1 point (outside · 2) | | |

NOTE:

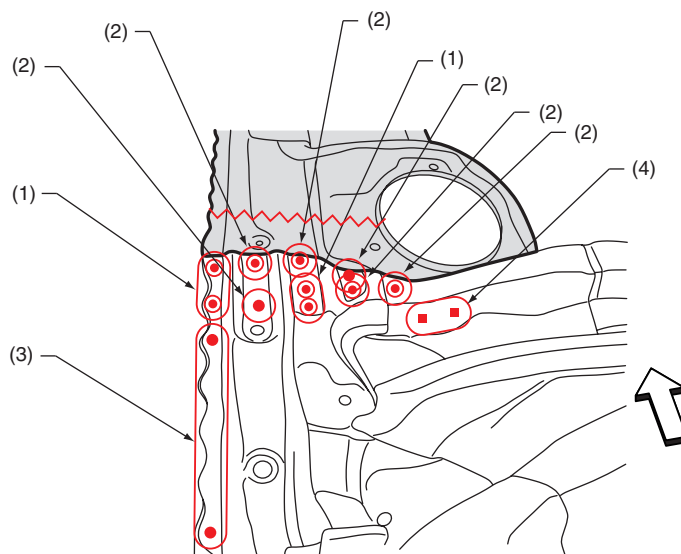
If the stay cowl side is installed (vehicle except for 15-inch wheel), do not weld the two points at location (a).

Front Wheel Apron (total replacement)

• Views 1



A



B

BS-02365

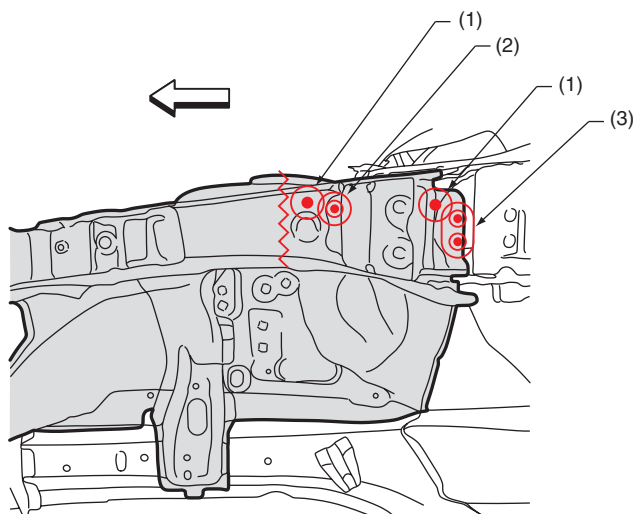
(1) 2 points (top · 1)
(2) 1 point (top · 1)

(3) 5 points (top · 1)

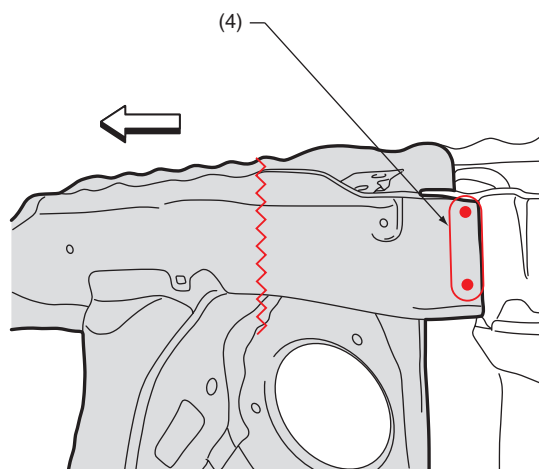
(4) 2 points (inside · 2, belt sander)

Front Wheel Apron (total replacement)

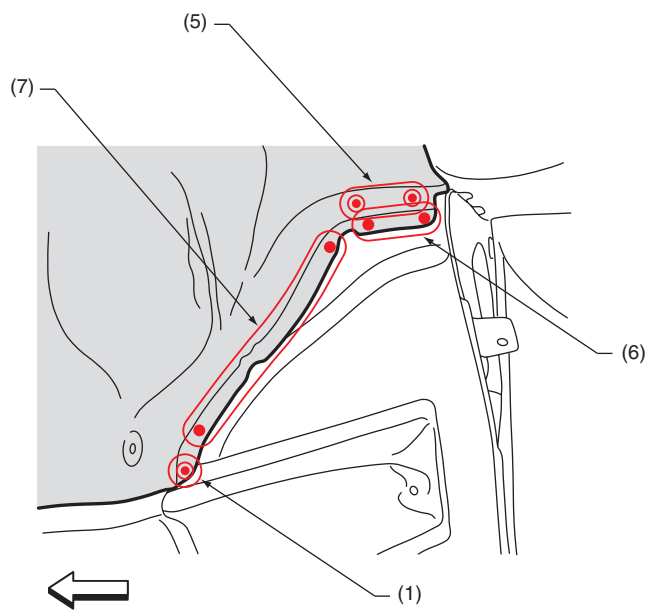
• Views 2



C



D



E

BS-02366

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

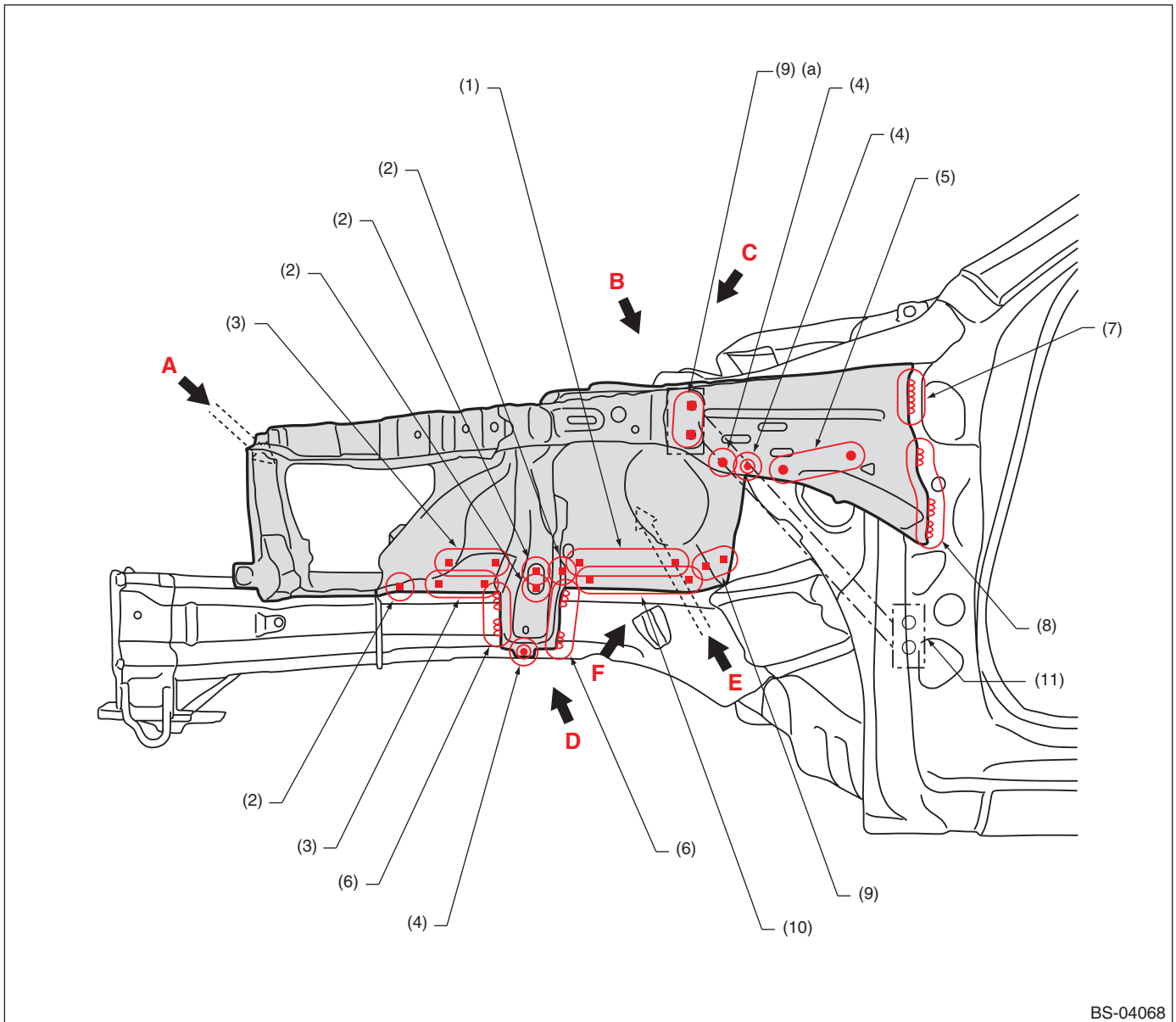
- (4) 4 points (bottom · 1)
- (5) 2 points (bottom · 1)
- (6) 3 points (outside · 1)

- (7) 5 points (outside · 1)

Front Wheel Apron (total replacement)

B: INSTALLATION

• Overall view



BS-04068

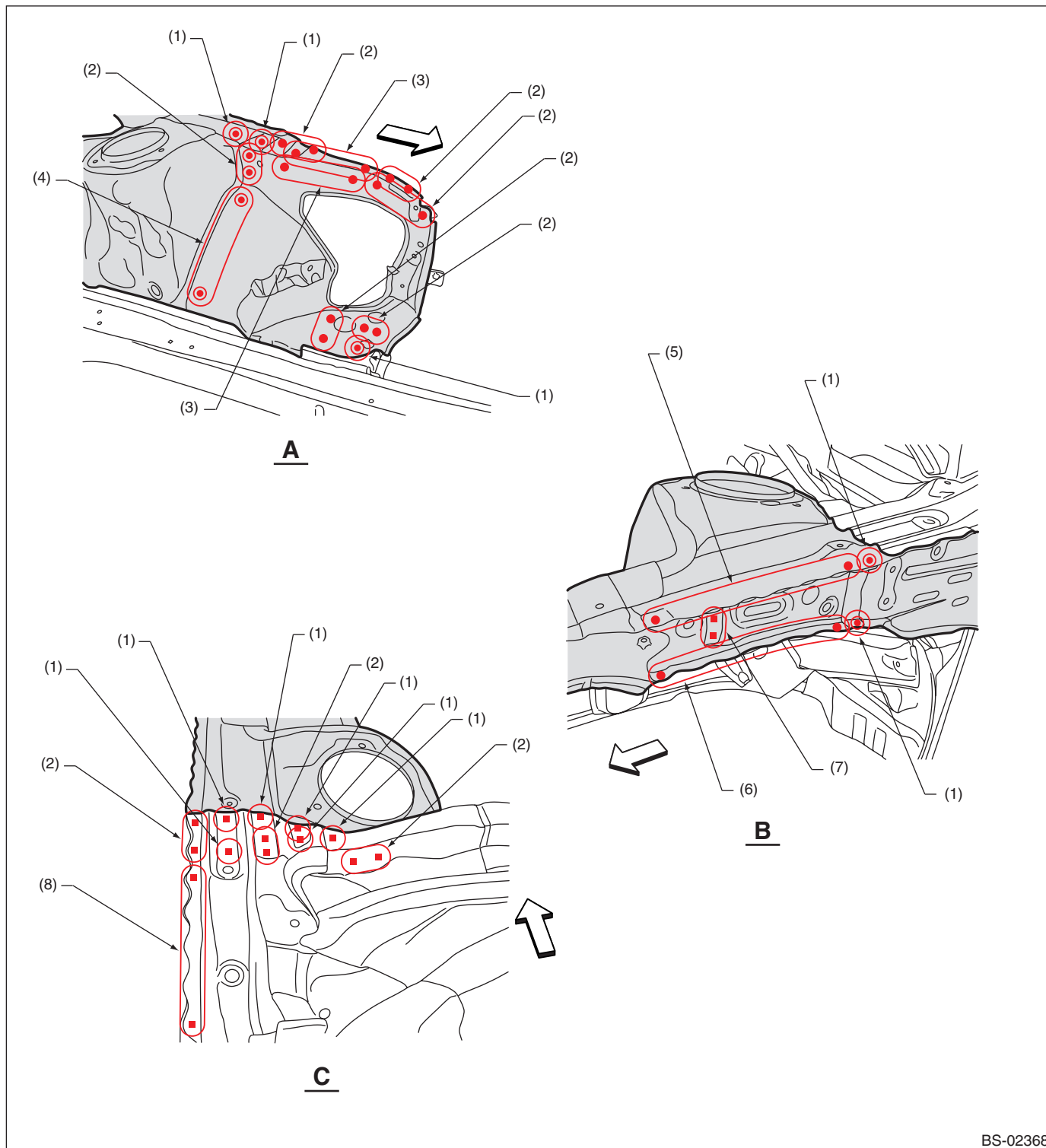
- | | | |
|------------------------|------------------------------------|-------------------------|
| (1) 6 points (service) | (5) 4 points | (9) 2 points (service) |
| (2) 1 point (service) | (6) 2 points [20 mm (0.79 in) × 2] | (10) 4 points (service) |
| (3) 3 points (service) | (7) 1 point [50 mm (1.97 in)] | (11) Stay cowl side |
| (4) 1 point | (8) 3 points [20 mm (0.79 in) × 3] | |

NOTE:

If the stay cowl side is installed (vehicle except for 15-inch wheel), do not weld the two points at location (a).

Front Wheel Apron (total replacement)

• Views 1



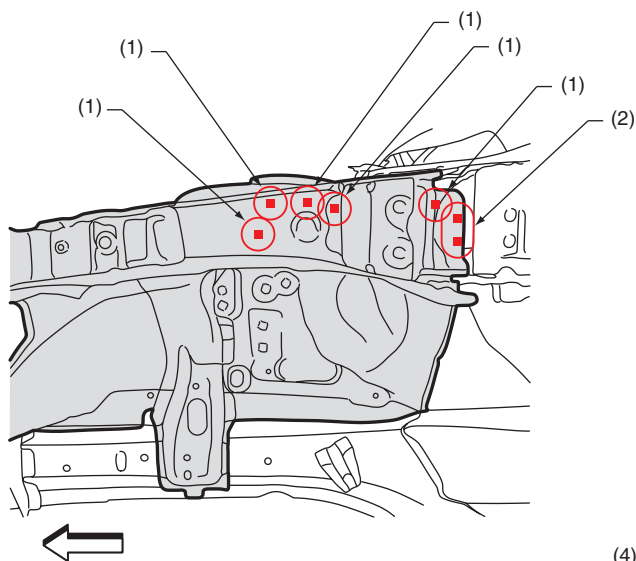
- (1) 1 point
- (2) 2 points
- (3) 3 points

- (4) 9 points
- (5) 7 points
- (6) 6 points

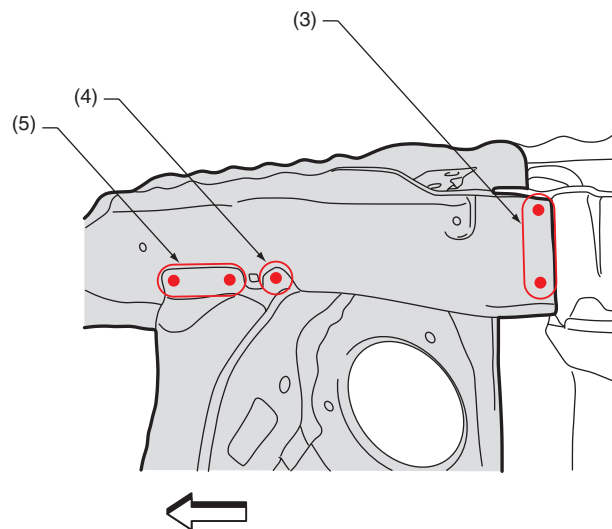
- (7) 2 points (service)
- (8) 5 points

Front Wheel Apron (total replacement)

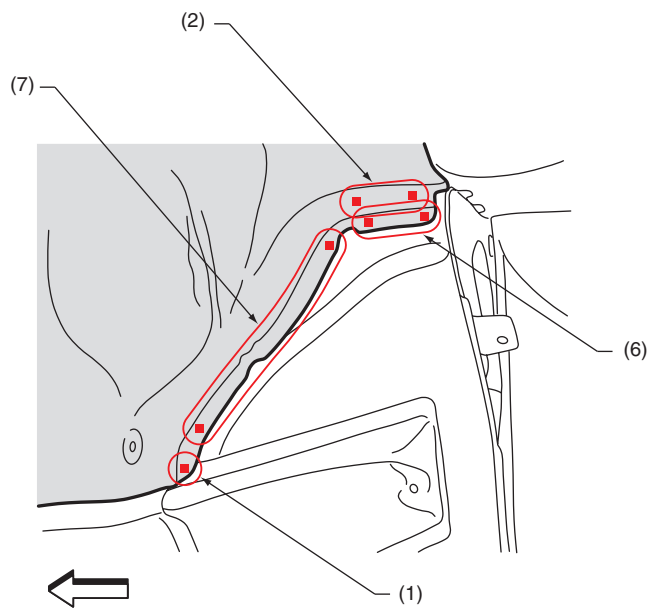
• Views 2



D



E



F

BS-02369

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

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

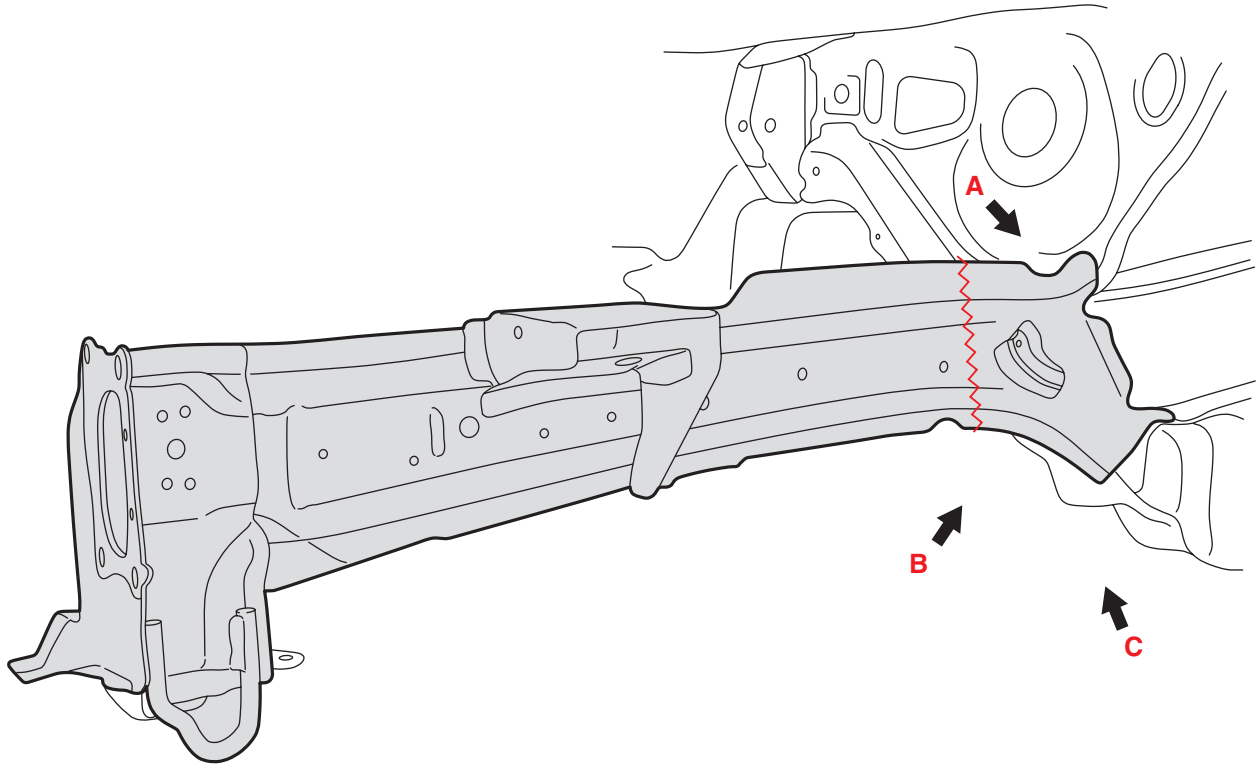
- (7) 5 points (service)

14.Front Side Frame (total replacement)

A: REMOVAL

1) Radiator panel and front wheel apron removal condition

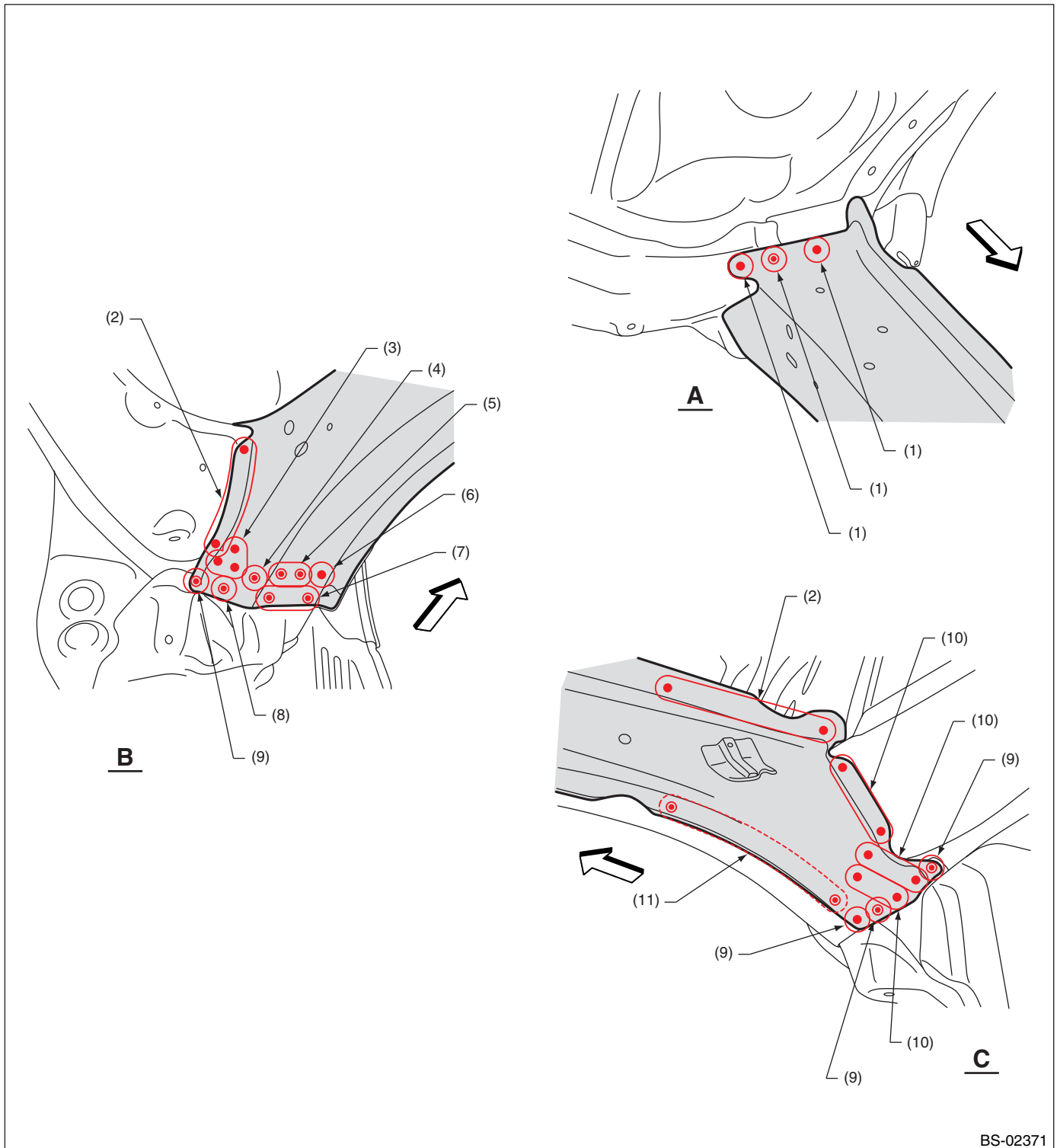
- Overall view



BS-02370

Front Side Frame (total replacement)

• Views



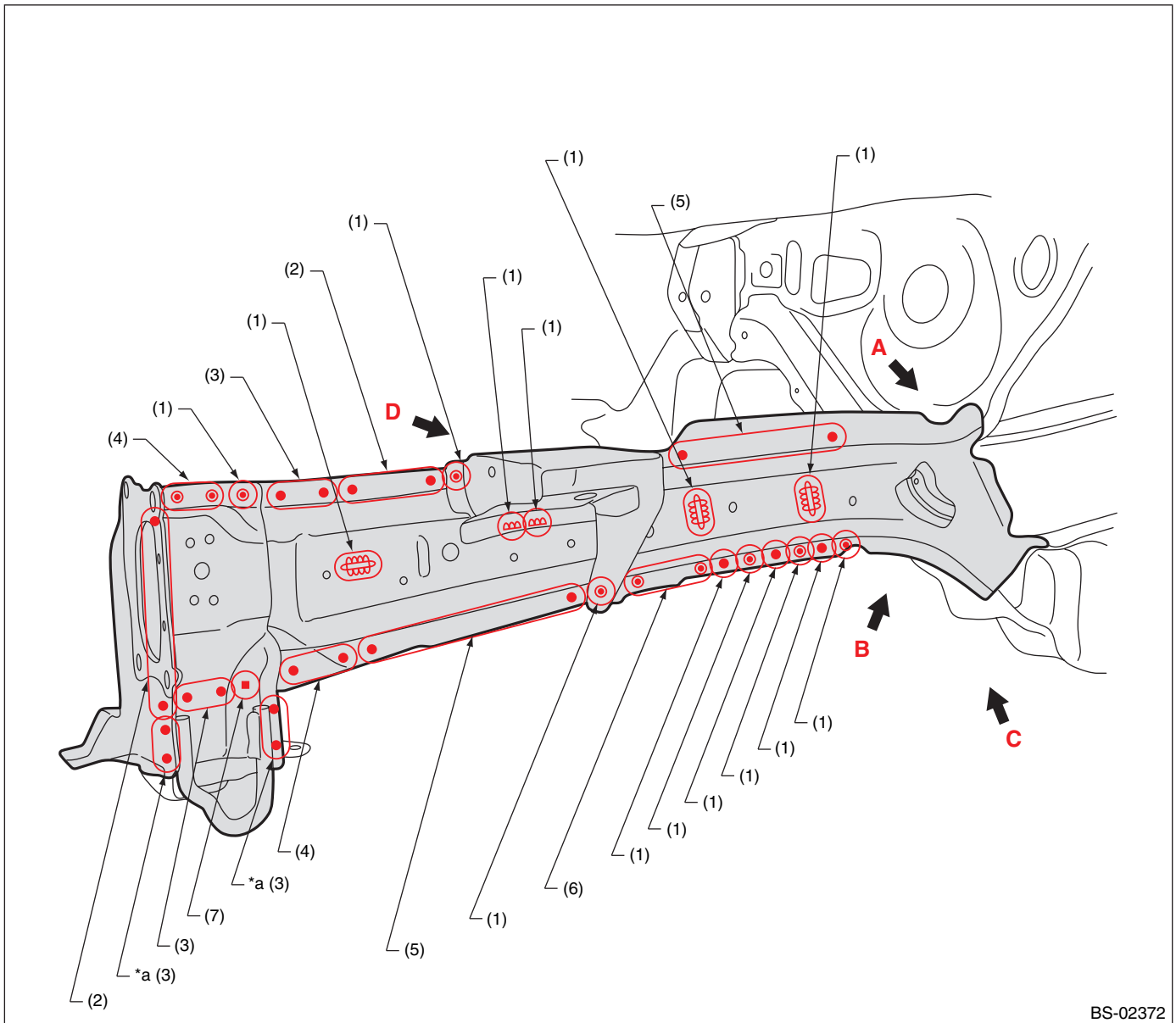
BS-02371

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

Front Side Frame (total replacement)

B: INSTALLATION

• Overall view

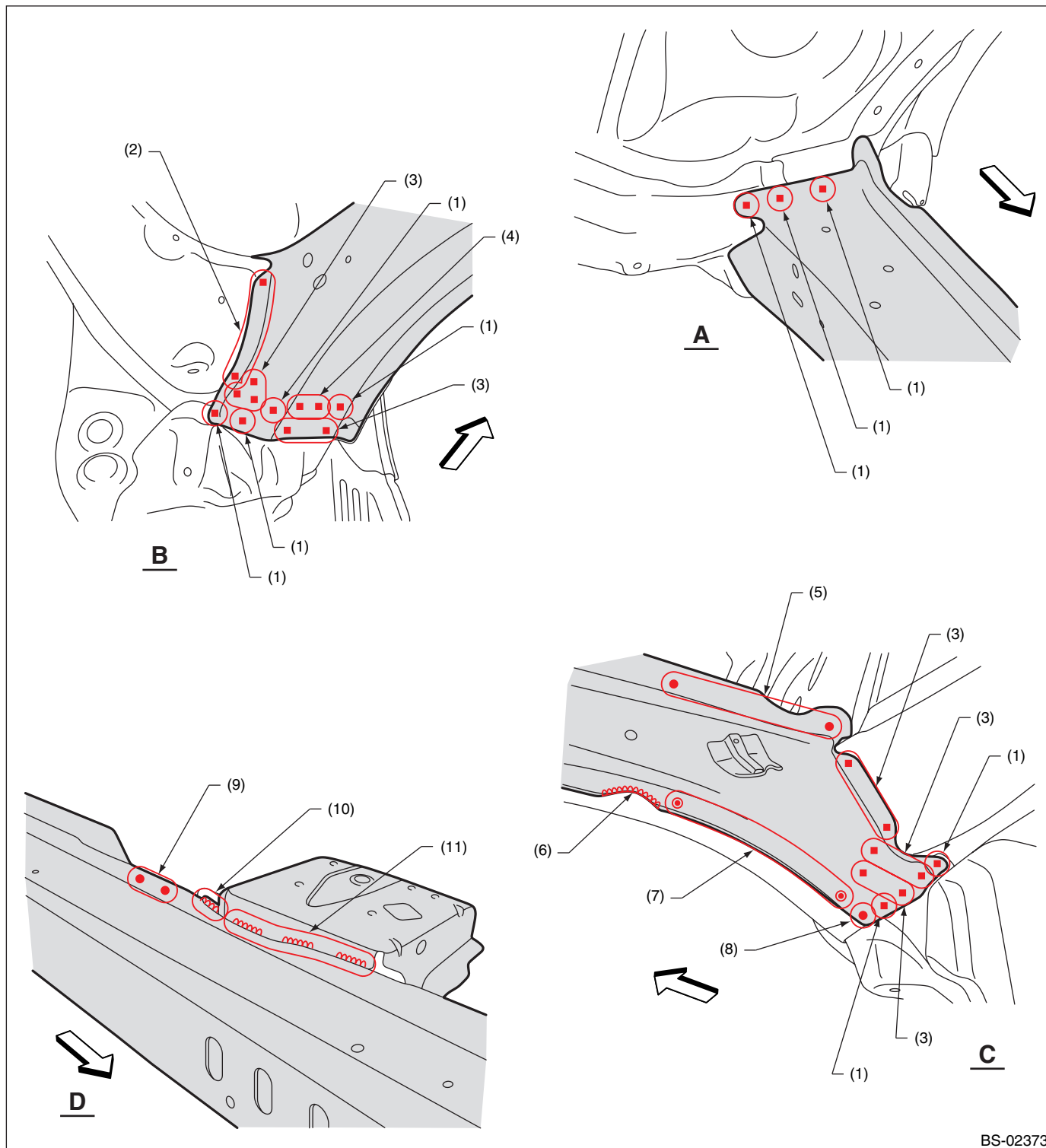


- | | | |
|--------------|--------------|-----------------------|
| (1) 1 point | (4) 3 points | (7) 1 point (service) |
| (2) 4 points | (5) 9 points | |
| (3) 2 points | (6) 5 points | |

POINT: * For part a, spot welding is performed before tie-down hook installation, and then the tie-down hook is installed.

Front Side Frame (total replacement)

• Views



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

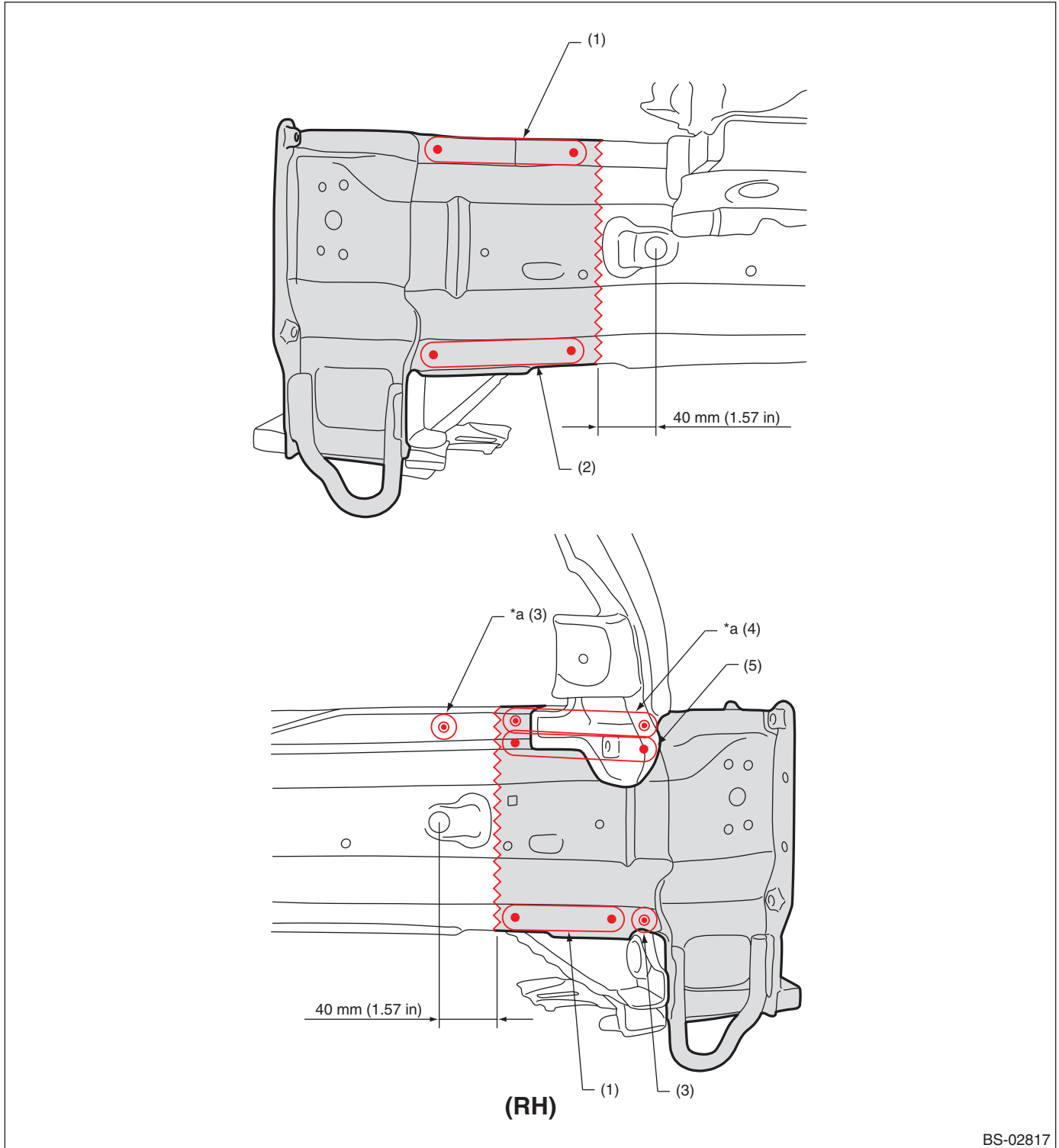
- (5) 5 points
- (6) 1 point [50 mm (1.97 in)]
- (7) 6 points
- (8) 1 point

- (9) 3 points
- (10) 1 point [20 mm (0.79 in)]
- (11) 3 points [25 mm (0.98 in)]

Closing Plate (partial replacement)

15.Closing Plate (partial replacement)

A: REMOVAL



BS-02817

(1) 4 points (outside · 1)

(3) 1 point (outside · 1)

(5) 2 points (outside · 1)

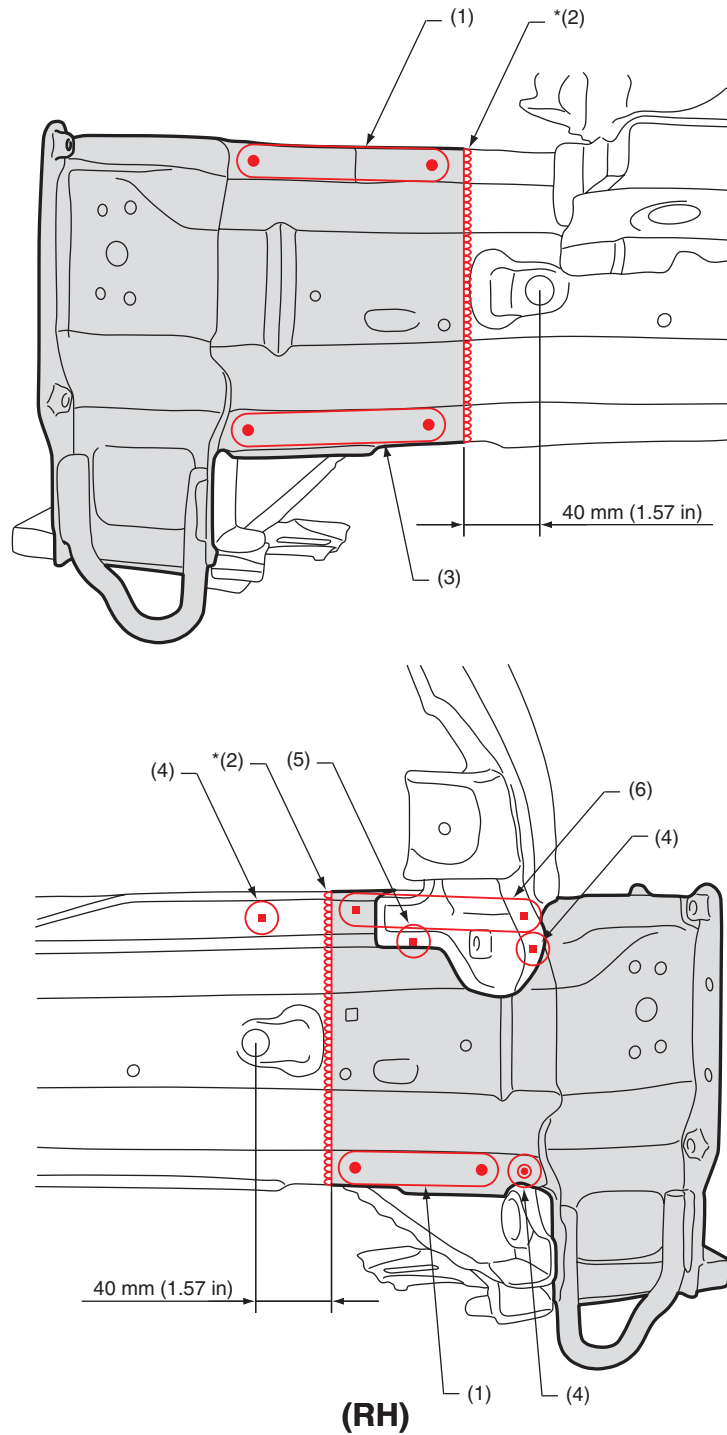
(2) 5 points (outside · 1)

(4) 2 points (outside · 2)

Point: * For part a, a part of the front wheel apron is raised to facilitate closing plate cutting.

Closing Plate (partial replacement)

B: INSTALLATION



BS-02818

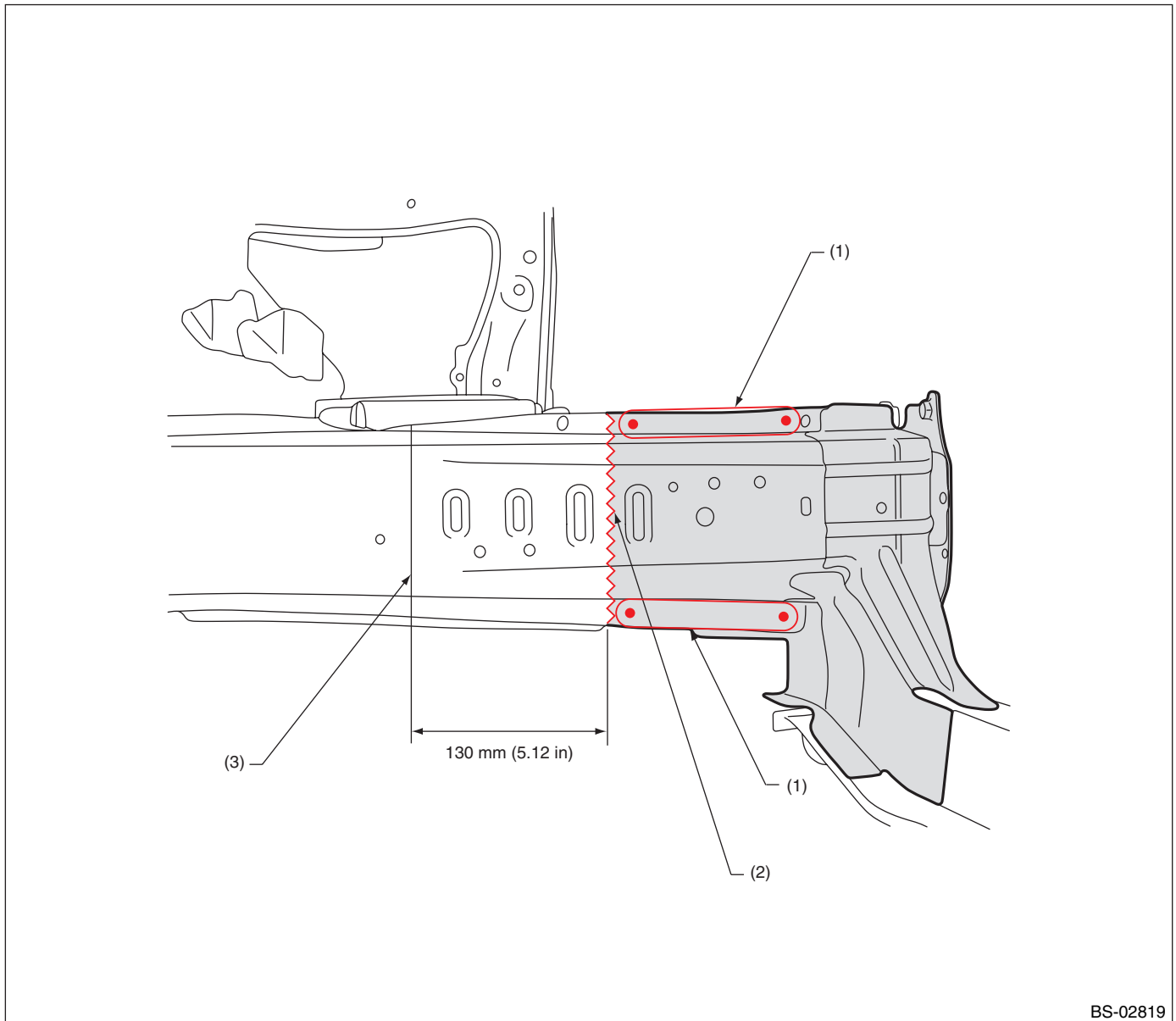
- | | | |
|--------------------------------|--------------|-----------------------------------|
| (1) 4 points | (3) 5 points | (5) 1 point (service) |
| (2) 1 point [160 mm (6.30 in)] | (4) 1 point | (6) 2 points (service · matching) |

For continuous welds marked by *, anticorrosion wax shall be applied thoroughly on the rear.

16.Front Side Frame (partial replacement)

A: REMOVAL

1) Radiator panel removal condition



BS-02819

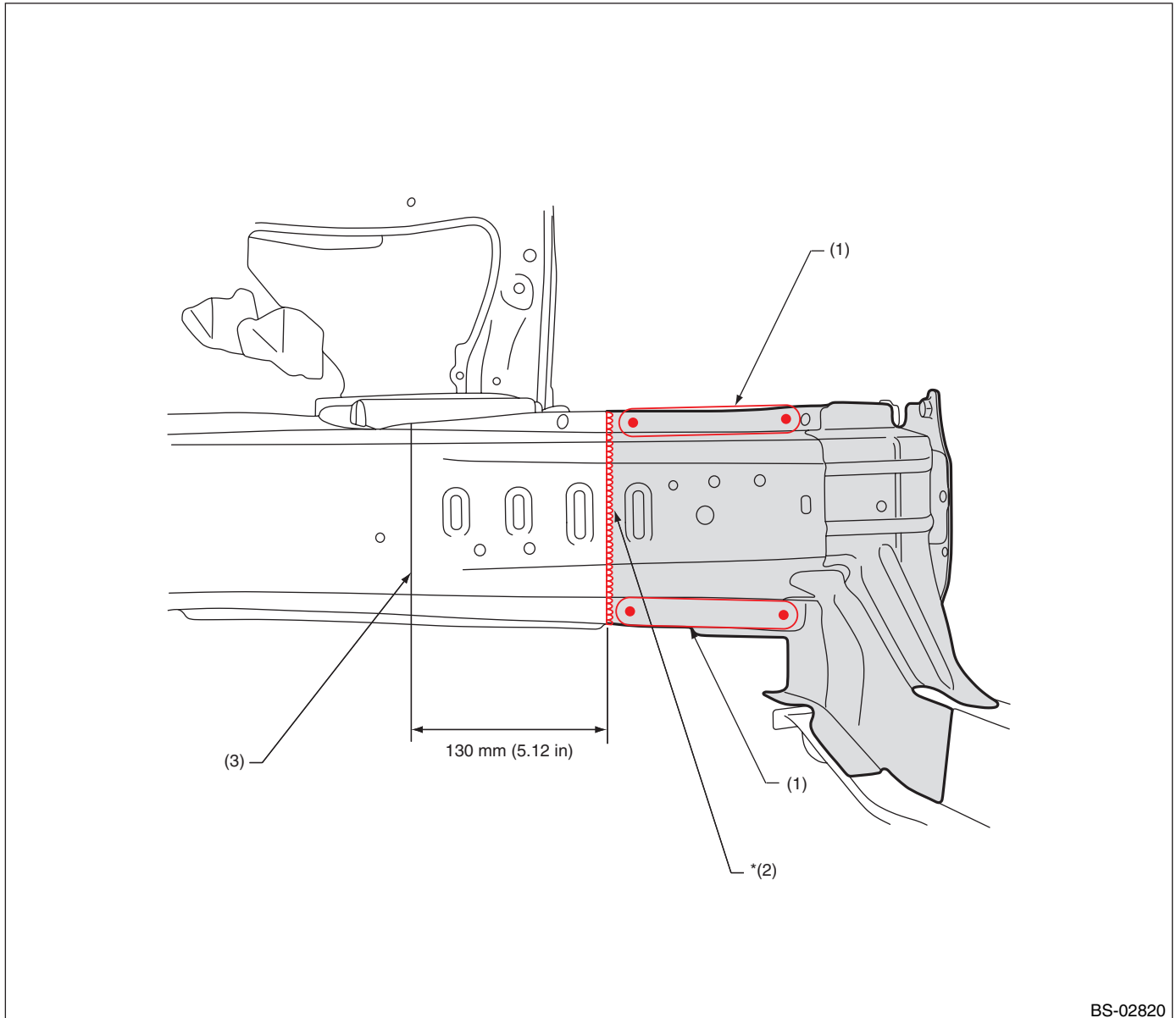
(1) 6 points (inside · 1)

(2) Cut position [220 mm (8.66 in)],
for butt welding

(3) Tailored line

Front Side Frame (partial replacement)

B: INSTALLATION



(1) 6 points

(2) 1 point [220 mm (8.66 in)]

(3) Tailored line

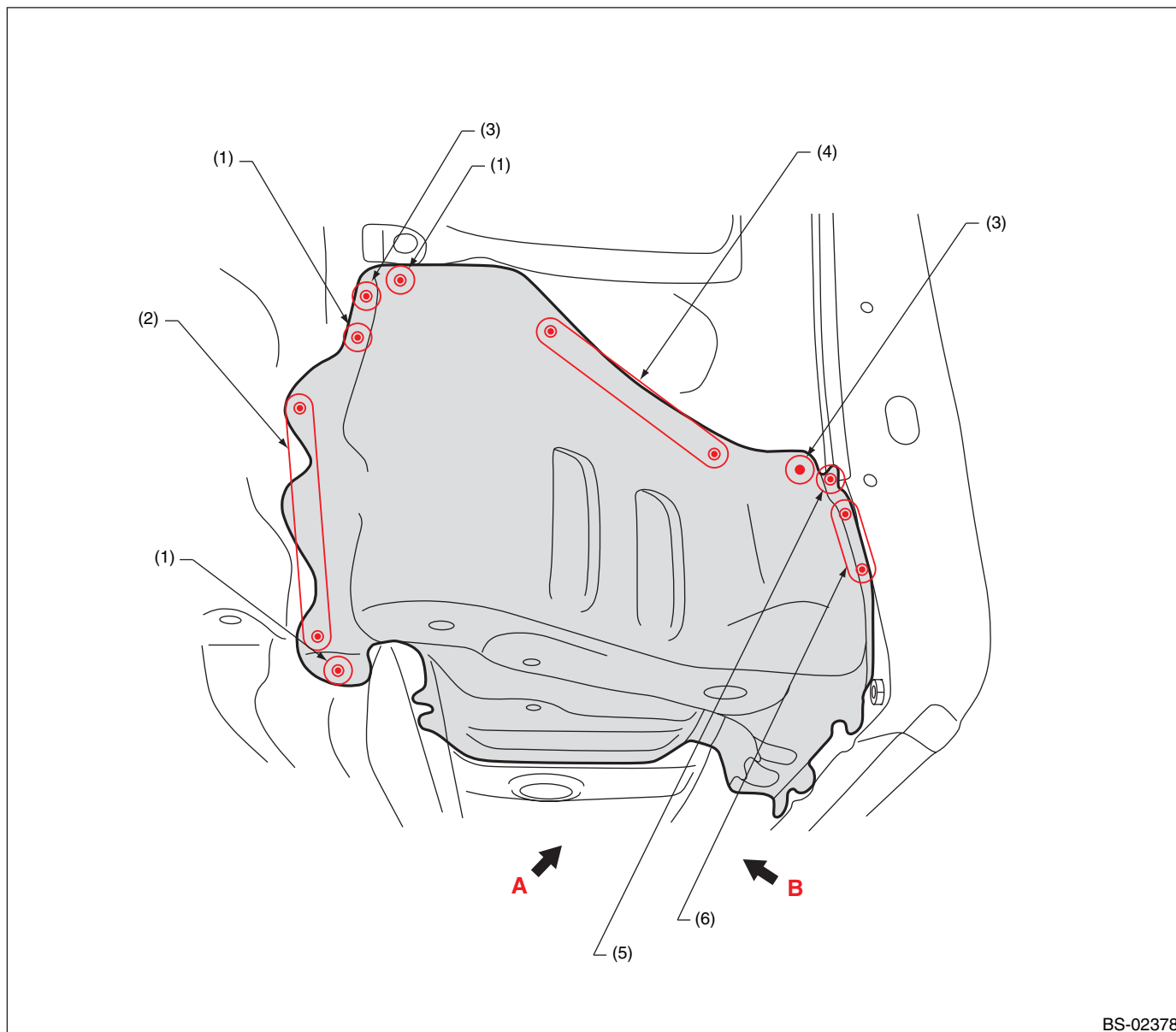
For continuous welds marked by *, anticorrosion wax shall be applied thoroughly on the rear.

Toe Board Lower Reinforcement (total replacement)

17.Toe Board Lower Reinforcement (total replacement)

A: REMOVAL

• Overall view



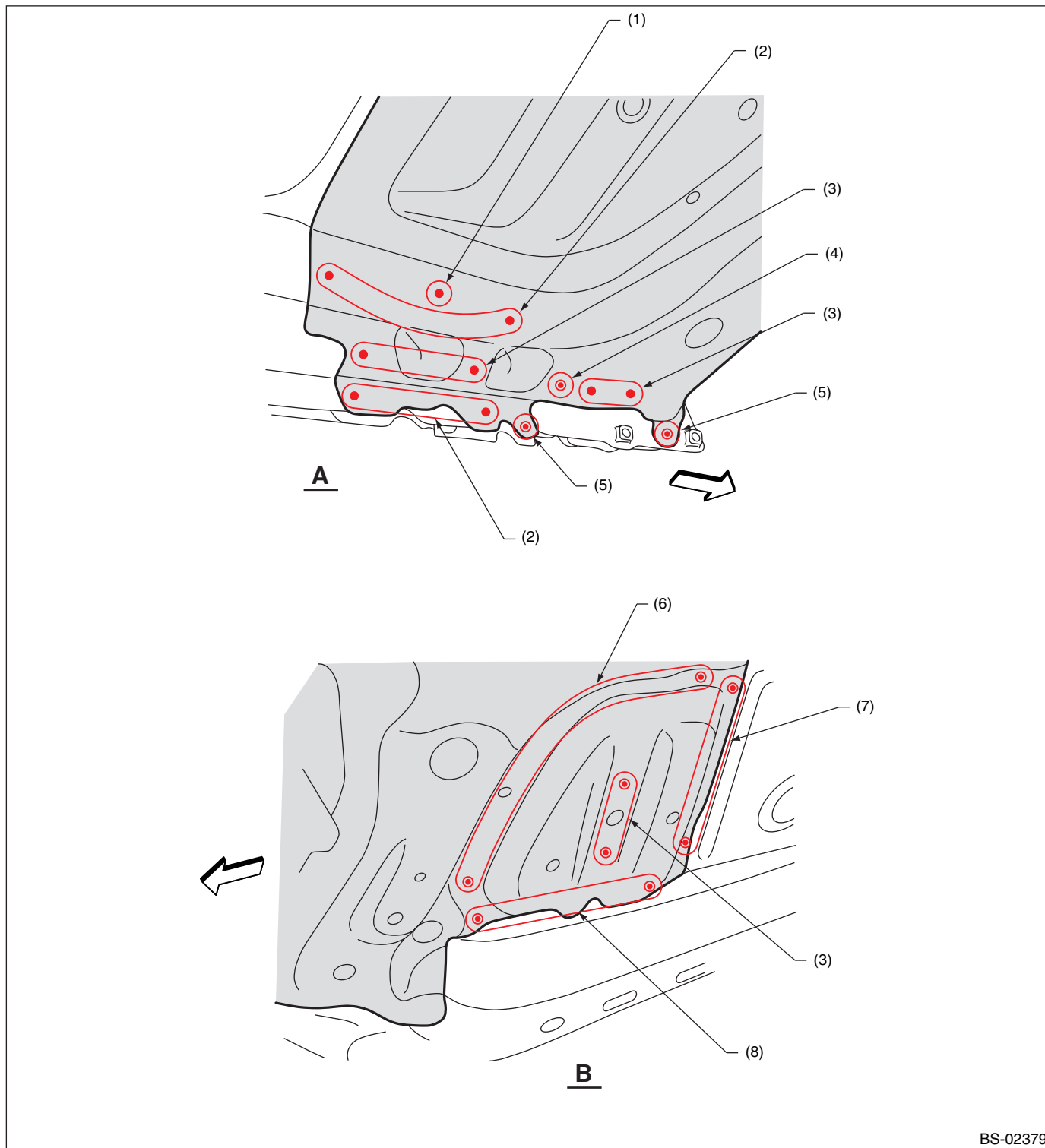
(1) 1 point (bottom · 1)
(2) 3 points (bottom · 1)

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

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

Toe Board Lower Reinforcement (total replacement)

• Views



BS-02379

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

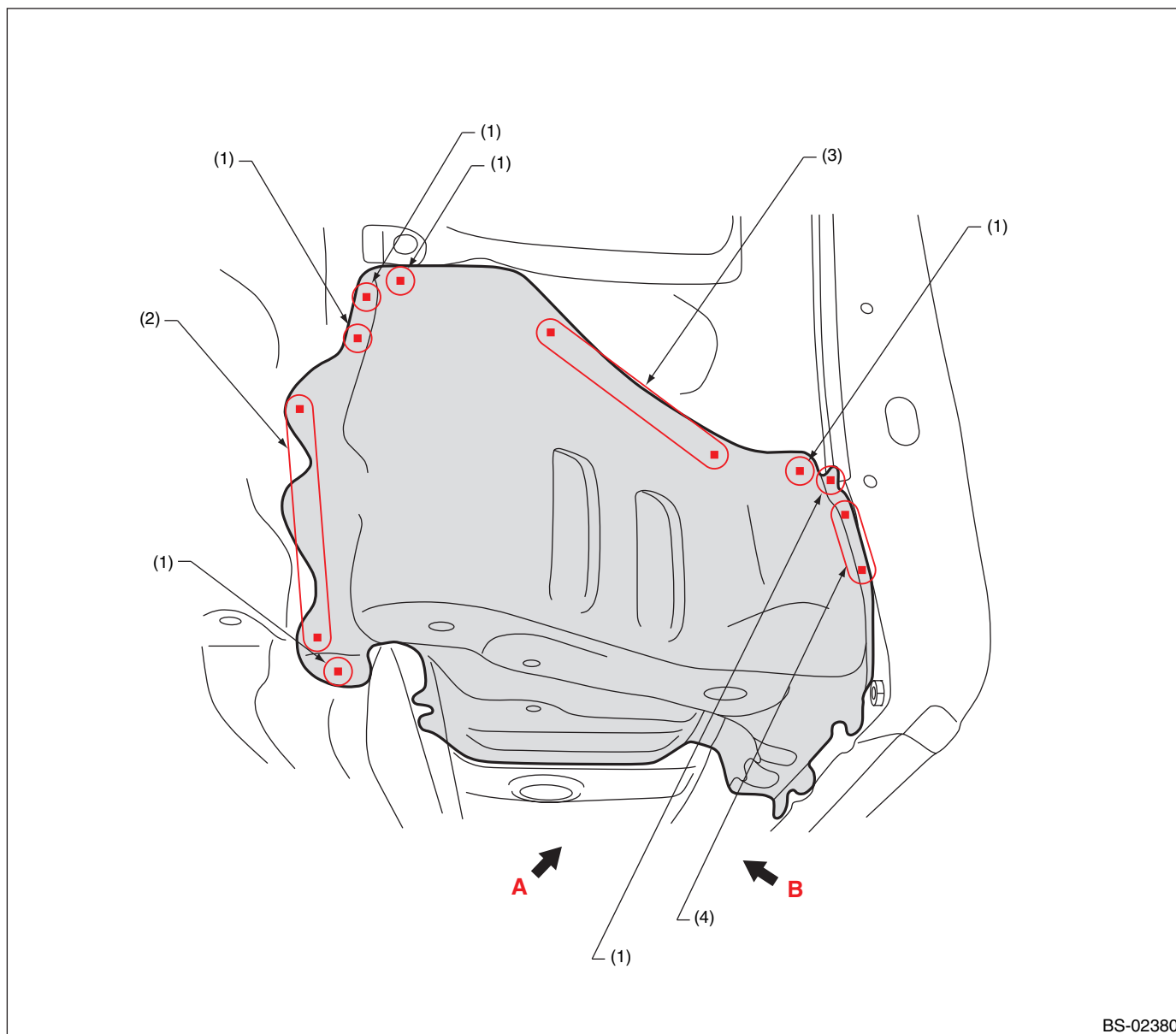
- (4) 1 point (bottom · 1)
- (5) 1 point (inside · 1)
- (6) 8 points (bottom · 1)

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

Toe Board Lower Reinforcement (total replacement)

B: INSTALLATION

- Overall view



BS-02380

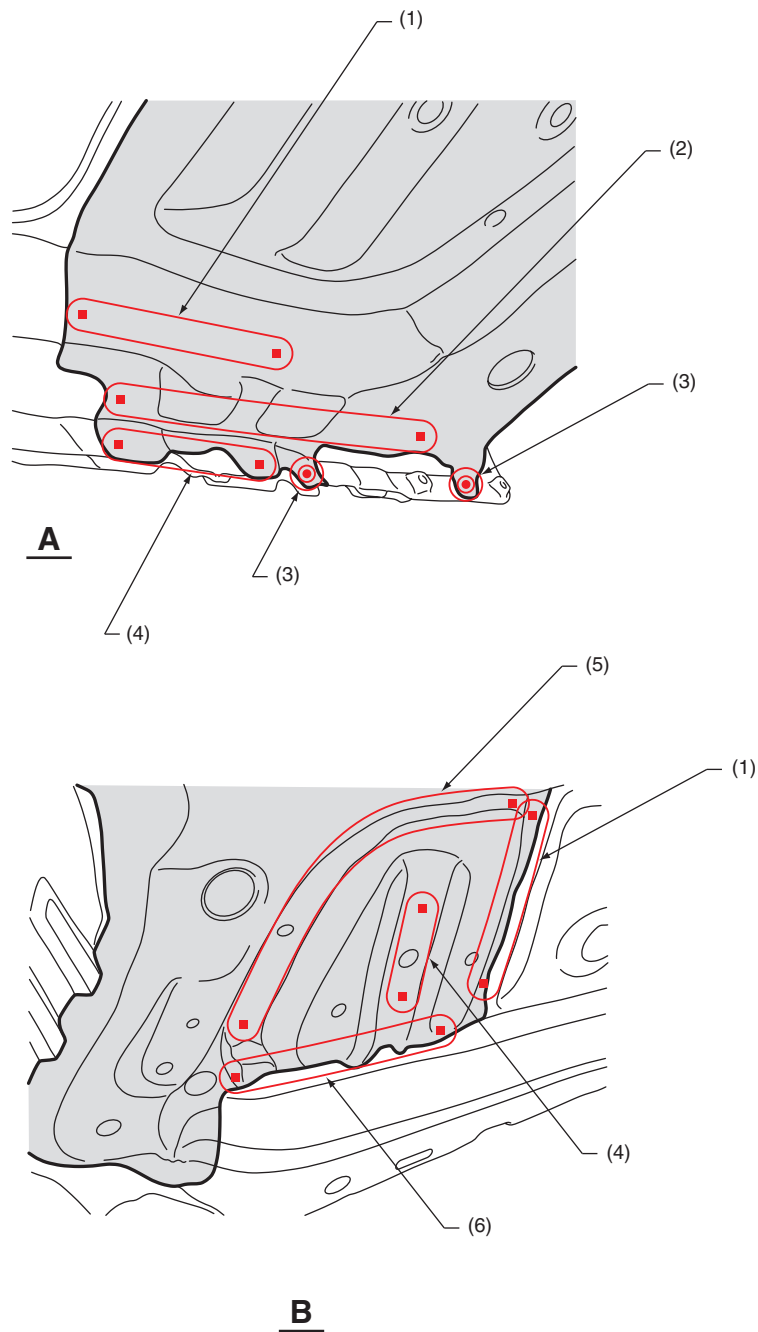
(1) 1 point (service)
(2) 3 points (service)

(3) 3 points

(4) 2 points (service)

Toe Board Lower Reinforcement (total replacement)

- Views



BS-02381

(1) 3 points (service)
(2) 5 points (service)

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

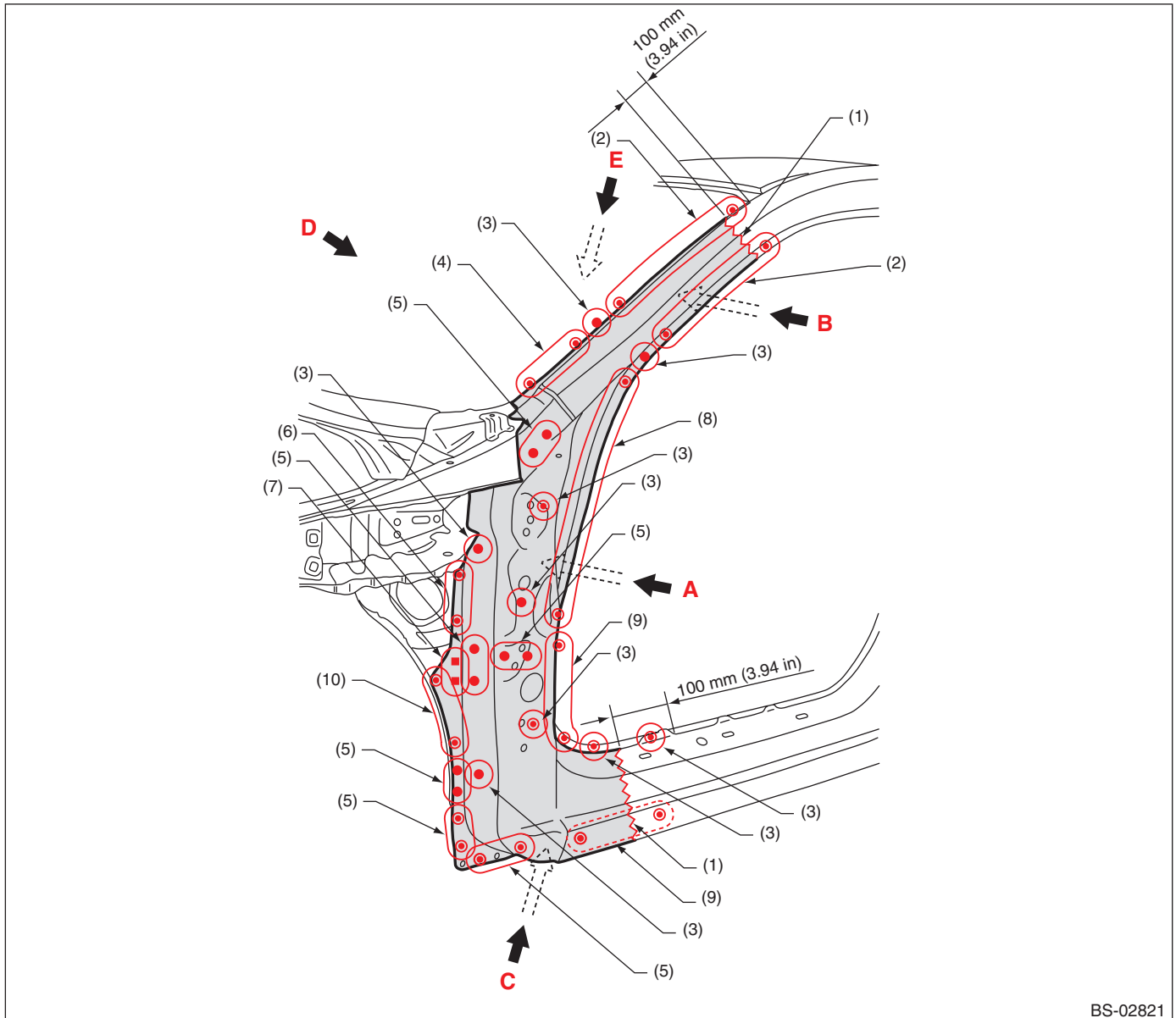
(5) 8 points (service)
(6) 4 points (service)

18.Front Pillar (partial replacement)

A: REMOVAL

1) Side upper frame removal condition

• Overall view

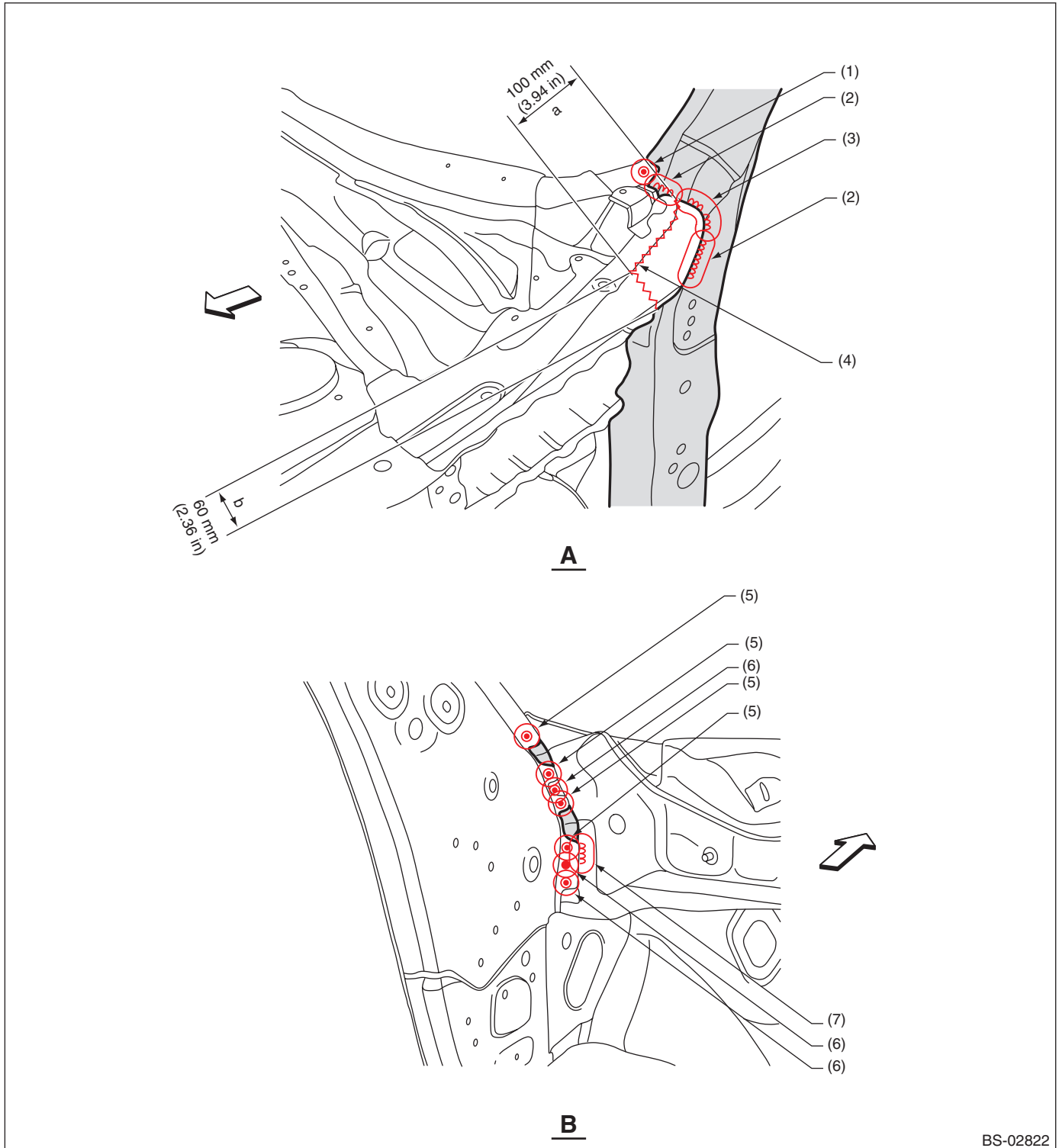


BS-02821

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

Front Pillar (partial replacement)

• Views 1



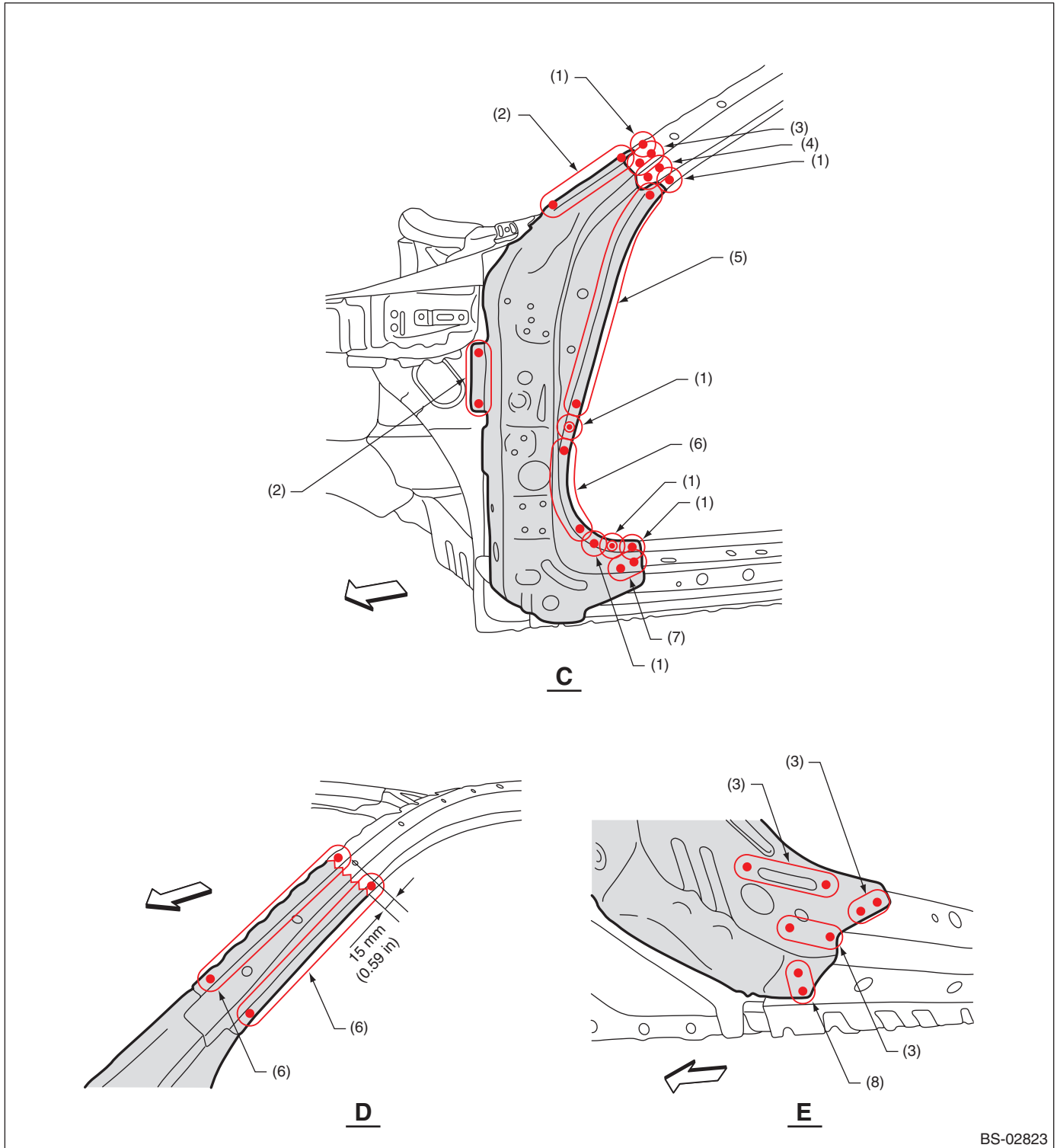
BS-02822

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

POINT: To facilitate removal, a part of the front panel is cut with dimensions such as a and b.

Front Pillar (partial replacement)

• Views 2



BS-02823

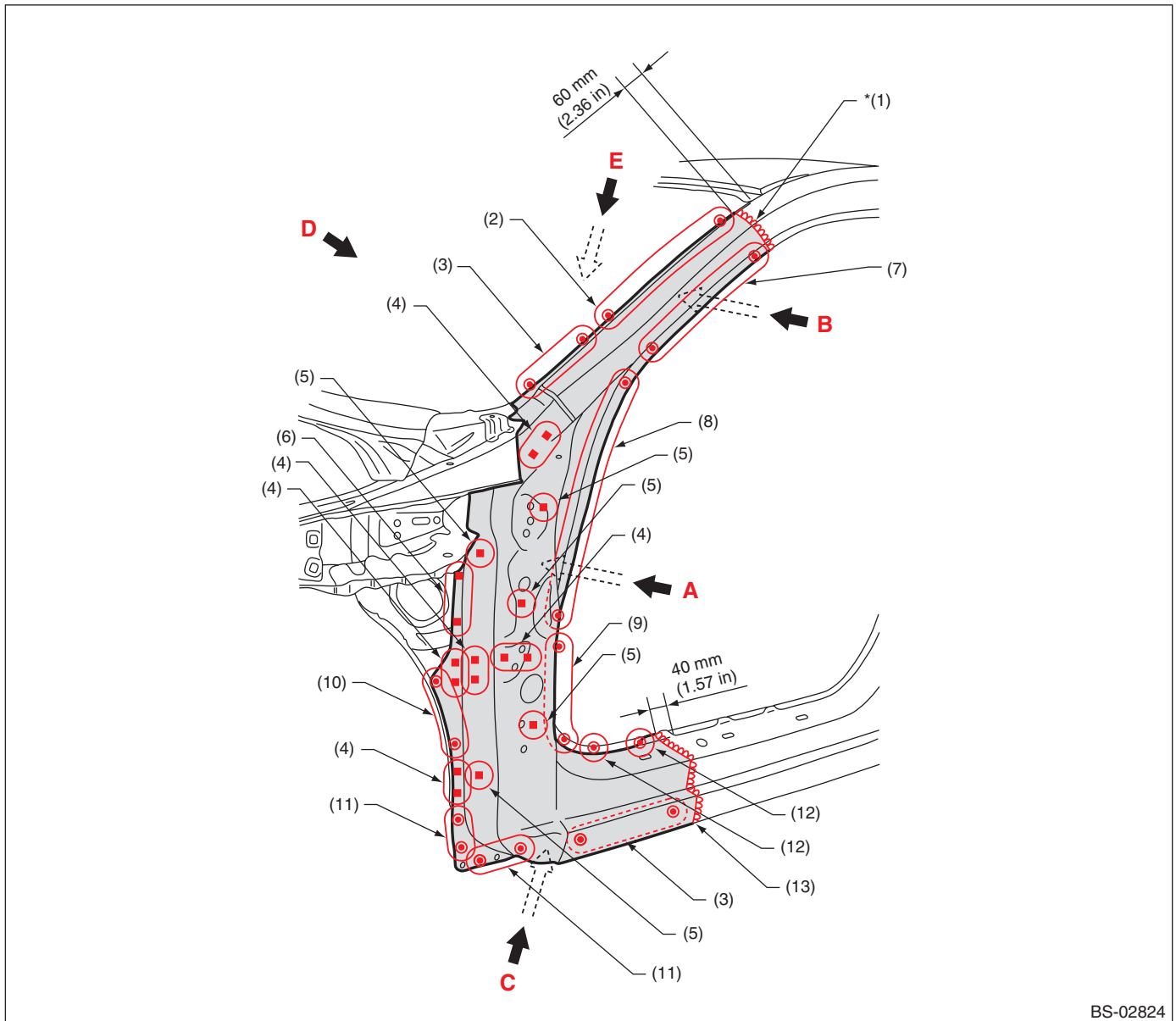
- | | | |
|----------------------------|----------------------------|---------------------------|
| (1) 1 point (outside · 1) | (4) 2 points (inside · 1) | (7) 2 points (top · 1) |
| (2) 4 points (outside · 1) | (5) 9 points (outside · 1) | (8) 2 points (bottom · 1) |
| (3) 2 points (outside · 1) | (6)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

Views C, D and E show the side panel outer front removal condition.

Front Pillar (partial replacement)

B: INSTALLATION

• Overall view

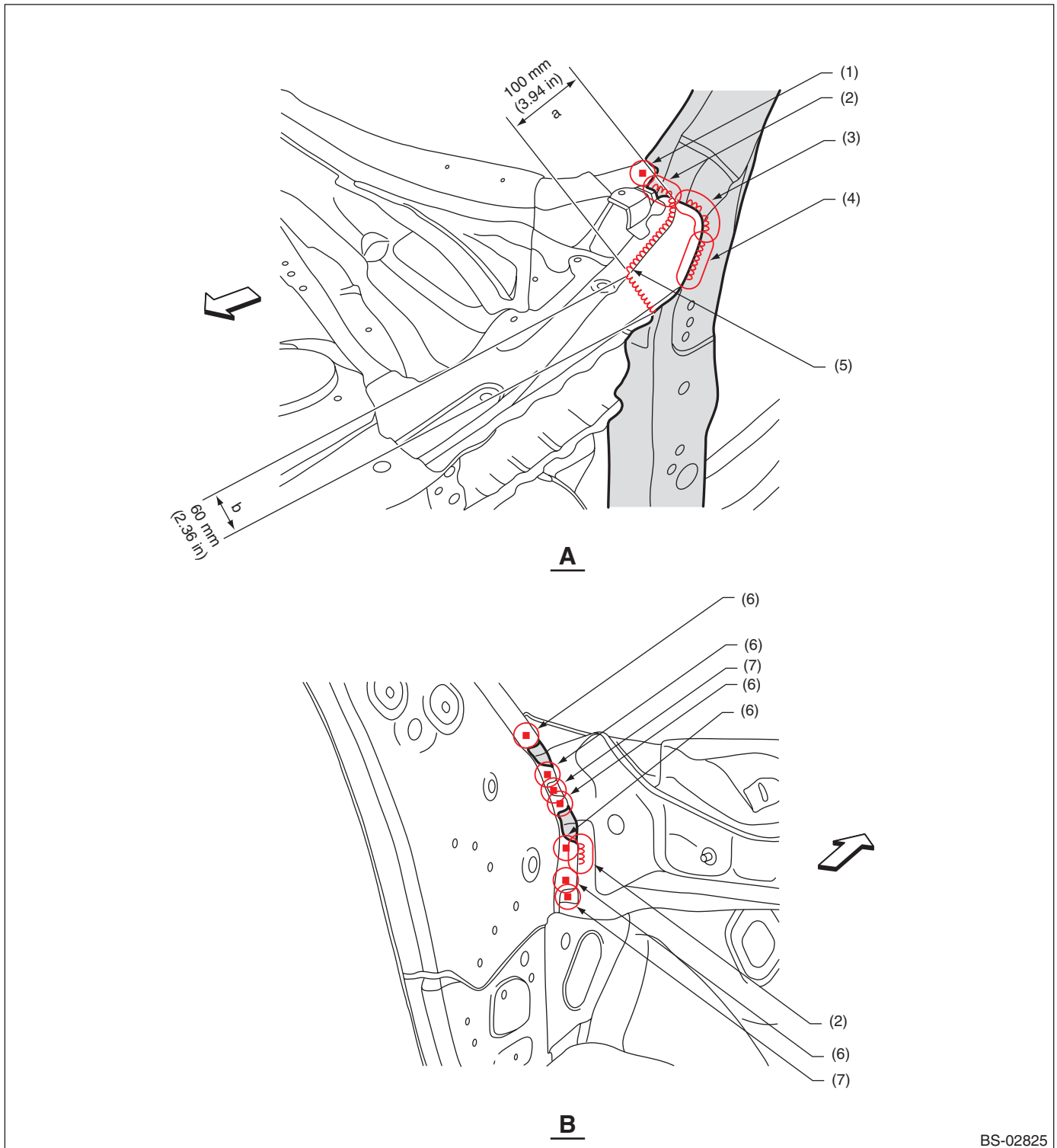


- | | | |
|--------------------------------|------------------------|----------------------------------|
| (1) 1 point [175 mm (6.89 in)] | (6) 4 points (service) | (11) 2 points |
| (2) 8 points | (7) 9 points | (12) 1 point |
| (3) 5 points | (8) 11 points | (13) 1 point [340 mm (13.39 in)] |
| (4) 2 points (service) | (9) 6 points | |
| (5) 1 point (service) | (10) 7 points | |

For continuous welds marked by *, anticorrosion wax shall be applied thoroughly on the rear.

Front Pillar (partial replacement)

• Views 1



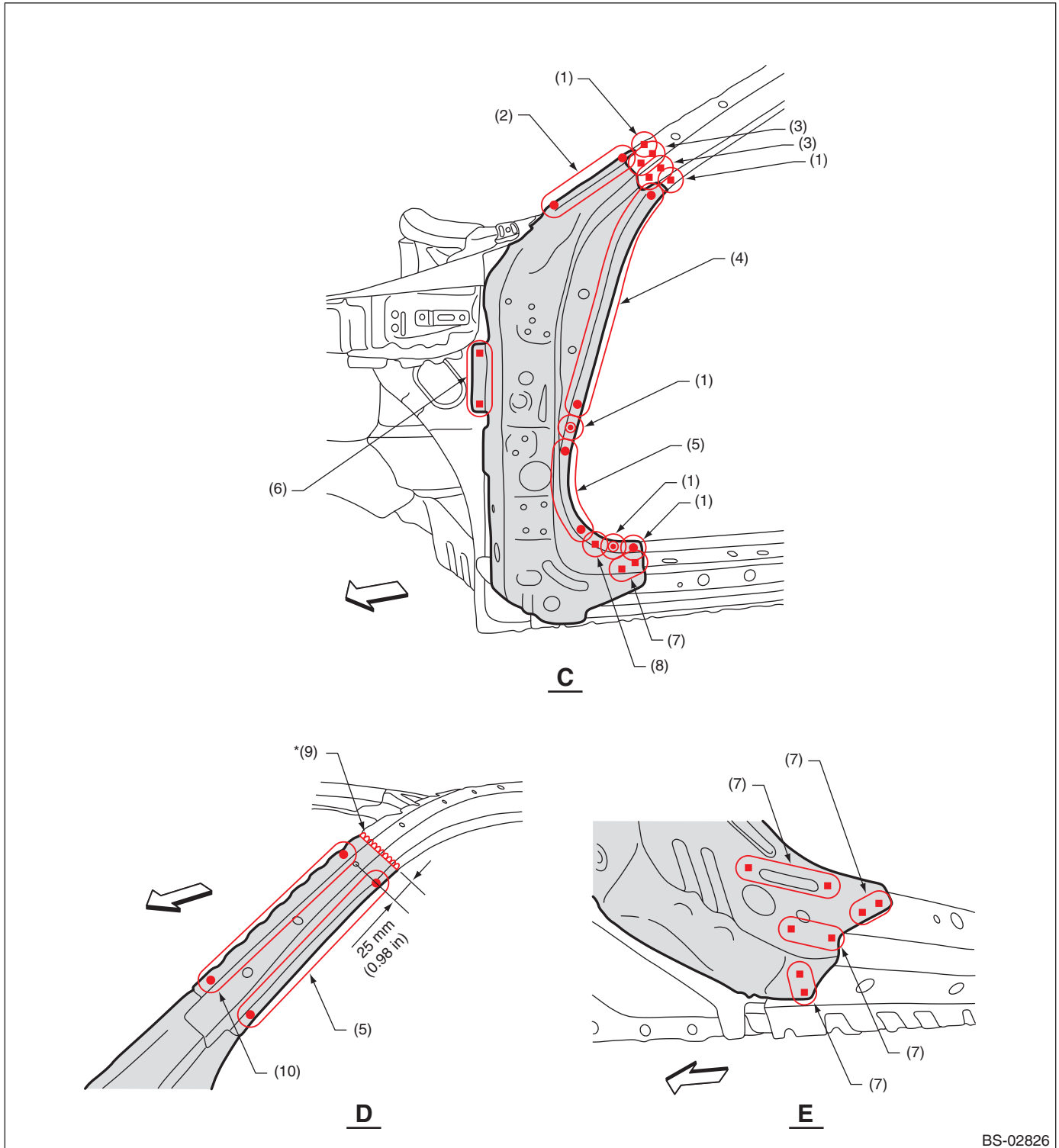
BS-02825

- | | | |
|----------------------------------|--------------------------------|-----------------------|
| (1) 1 point (service · matching) | (4) 1 point [40 mm (1.57 in)] | (7) 1 point (service) |
| (2) 1 point [20 mm (0.79 in)] | (5) 1 point [160 mm (6.30 in)] | |
| (3) 2 points [15 mm (0.59 in)] | (6) 1 point | |

POINT: The cut parts a and b are welded after side panel outer front installation.

Front Pillar (partial replacement)

• Views 2



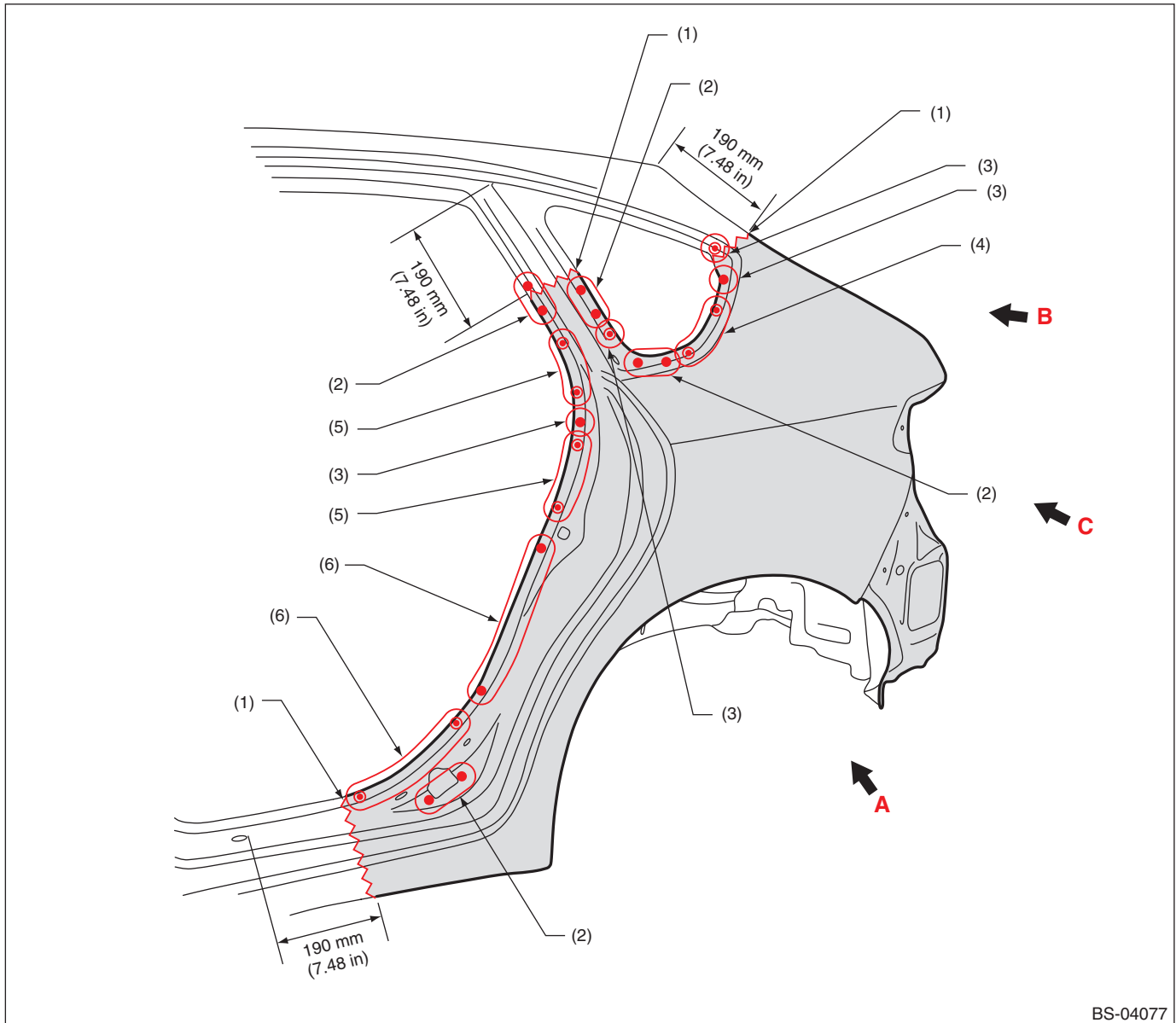
- | | | |
|---------------|------------------------|--------------------------------|
| (1) 1 point | (5) 8 points | (9) 1 point [140 mm (5.51 in)] |
| (2) 5 points | (6) 4 points | (10) 7 points |
| (3) 2 points | (7) 2 points (service) | |
| (4) 11 points | (8) 1 point (service) | |

For continuous welds marked by *, anticorrosion wax shall be applied thoroughly on the rear.

19.Rear Quarter (partial replacement)/5 door

A: REMOVAL

• Overall view

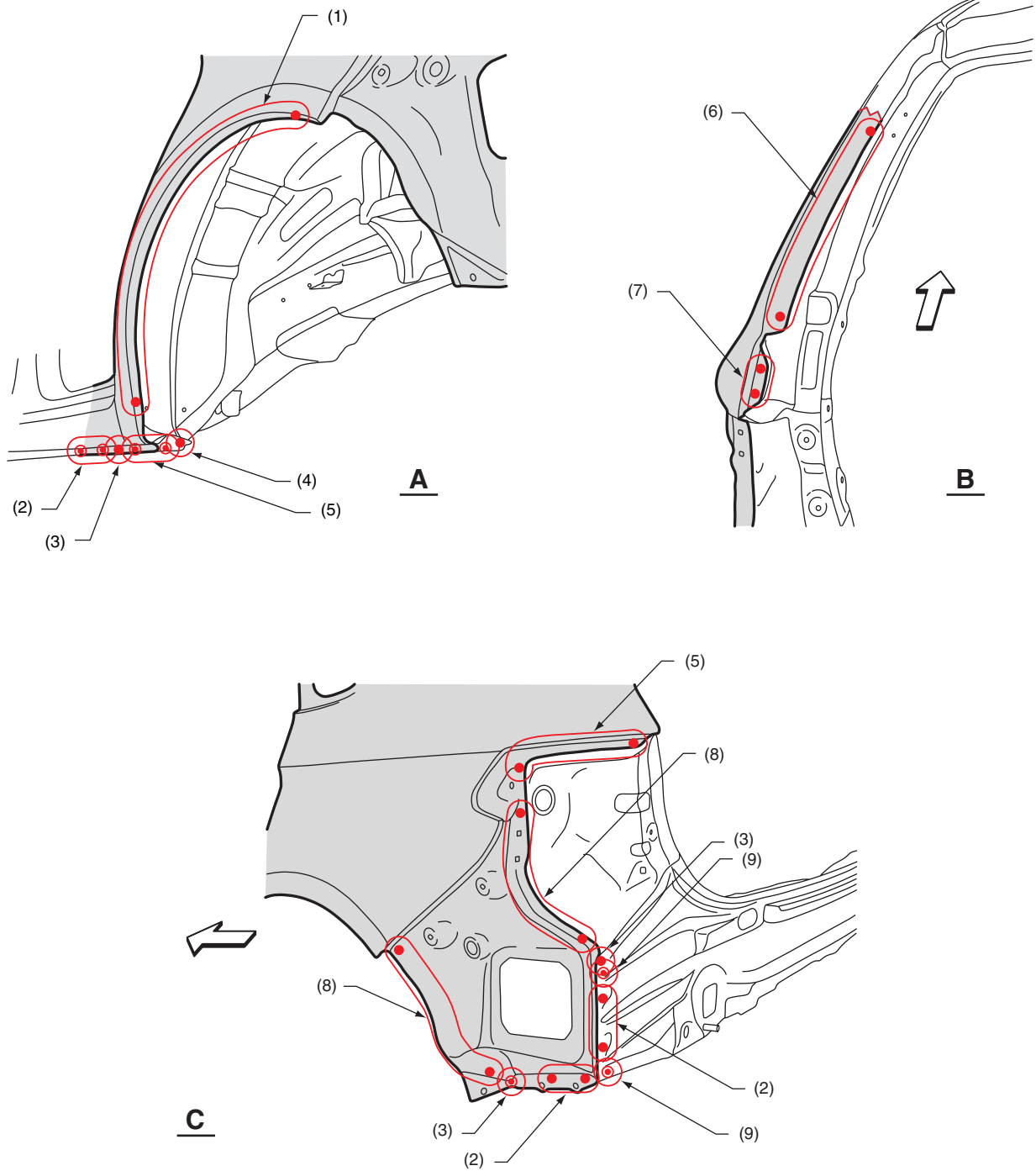


BS-04077

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

Rear Quarter (partial replacement)/5 door

• Views 1



BS-02389

- (1) 13 points (bottom · 1)
- (2) 2 points (outside · 1)
- (3) 1 point (outside · 1)

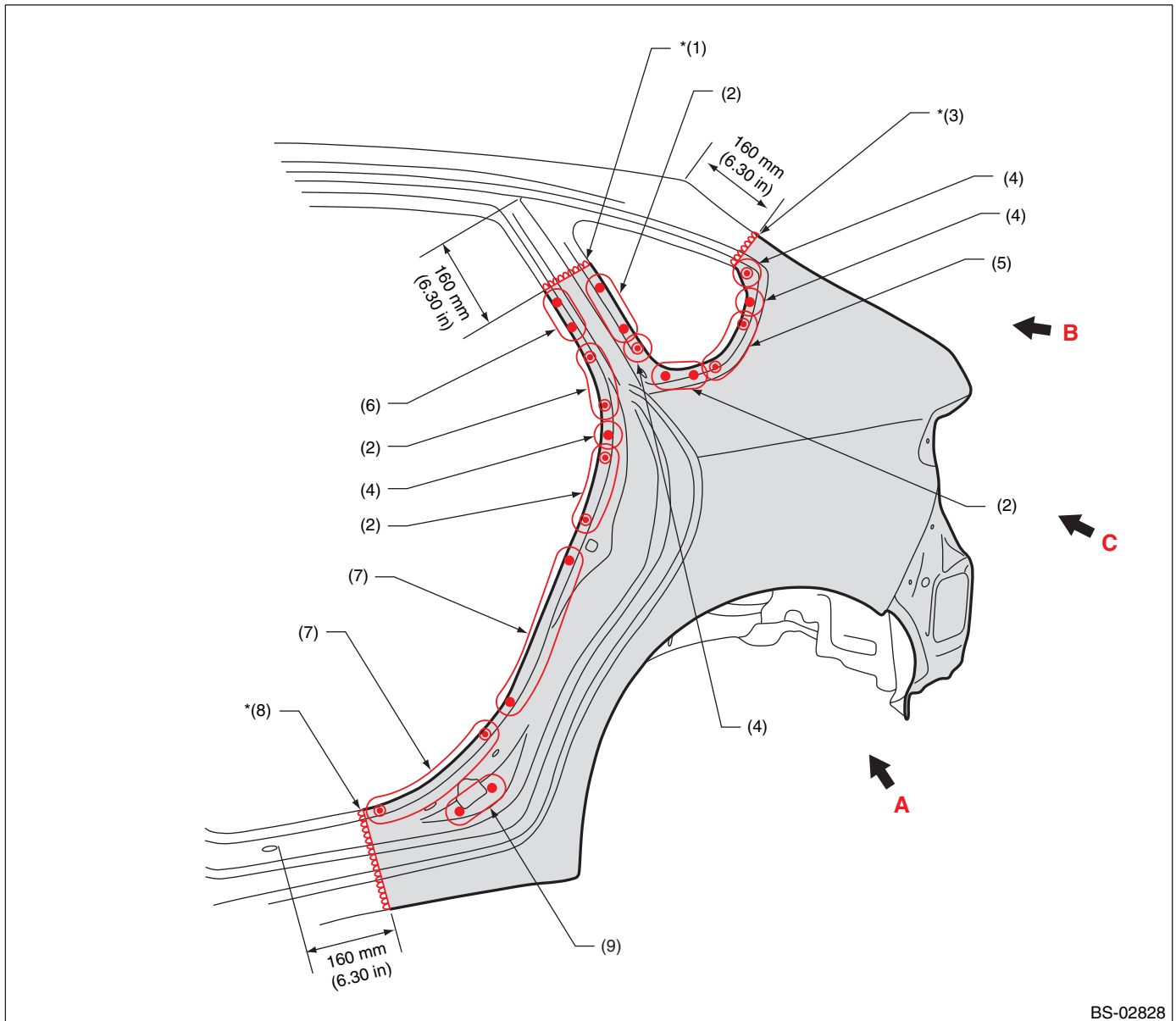
- (4) 1 point (bottom · 1)
- (5) 5 points (outside · 1)
- (6) 7 points (inside · 1)

- (7) 2 points (inside · 1)
- (8) 6 points (outside · 1)
- (9) 1 point (outside · 2)

Rear Quarter (partial replacement)/5 door

B: INSTALLATION

• Overall view

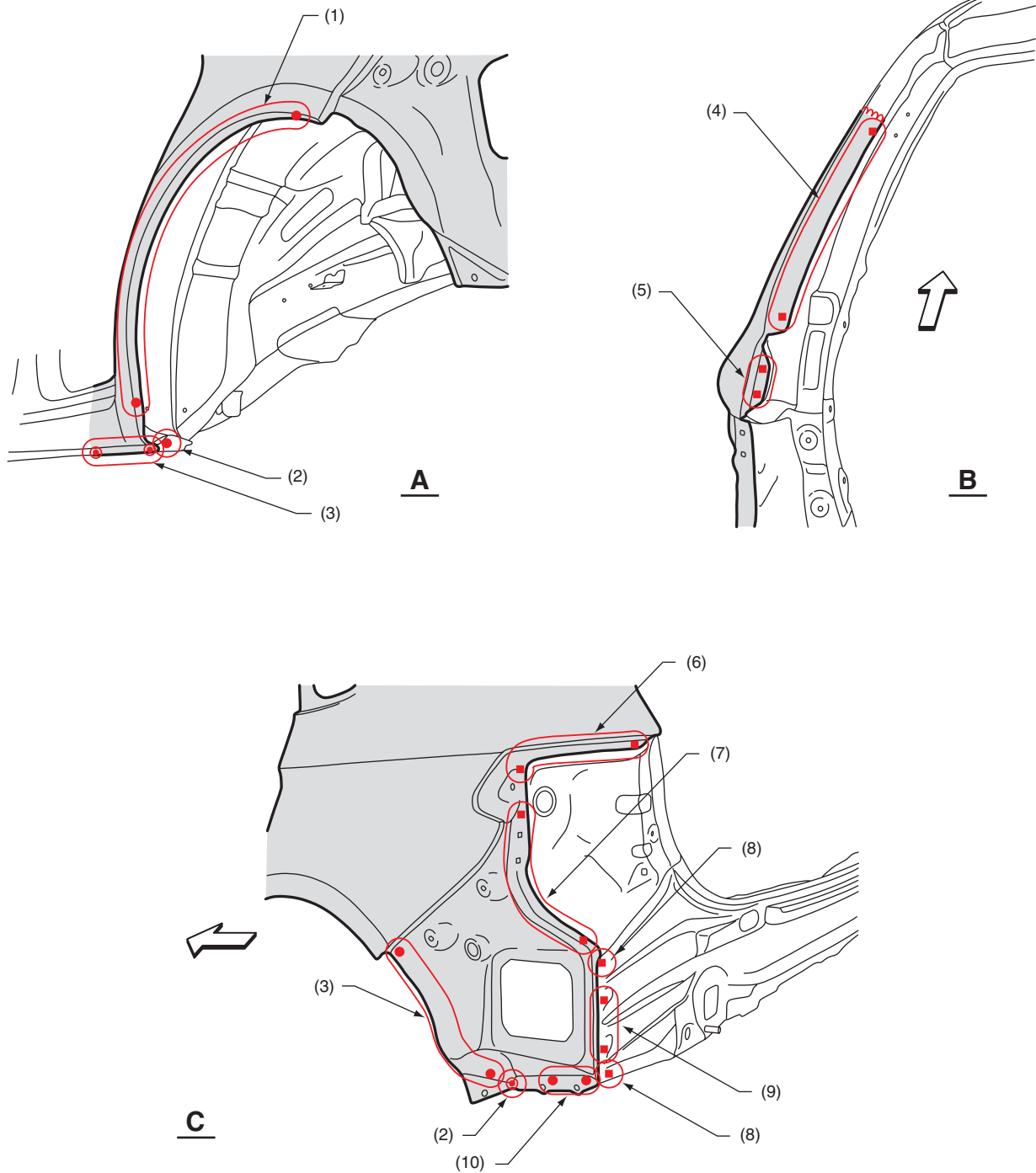


- | | | |
|--------------------------------|--------------|---------------------------------|
| (1) 1 point [105 mm (4.13 in)] | (4) 1 point | (7) 6 points |
| (2) 3 points | (5) 4 points | (8) 1 point [325 mm (12.80 in)] |
| (3) 1 point [145 mm (5.71 in)] | (6) 2 points | (9) 2 points (service) |

For continuous welds marked by *, anticorrosion wax shall be applied thoroughly on the rear.

Rear Quarter (partial replacement)/5 door

• Views 1



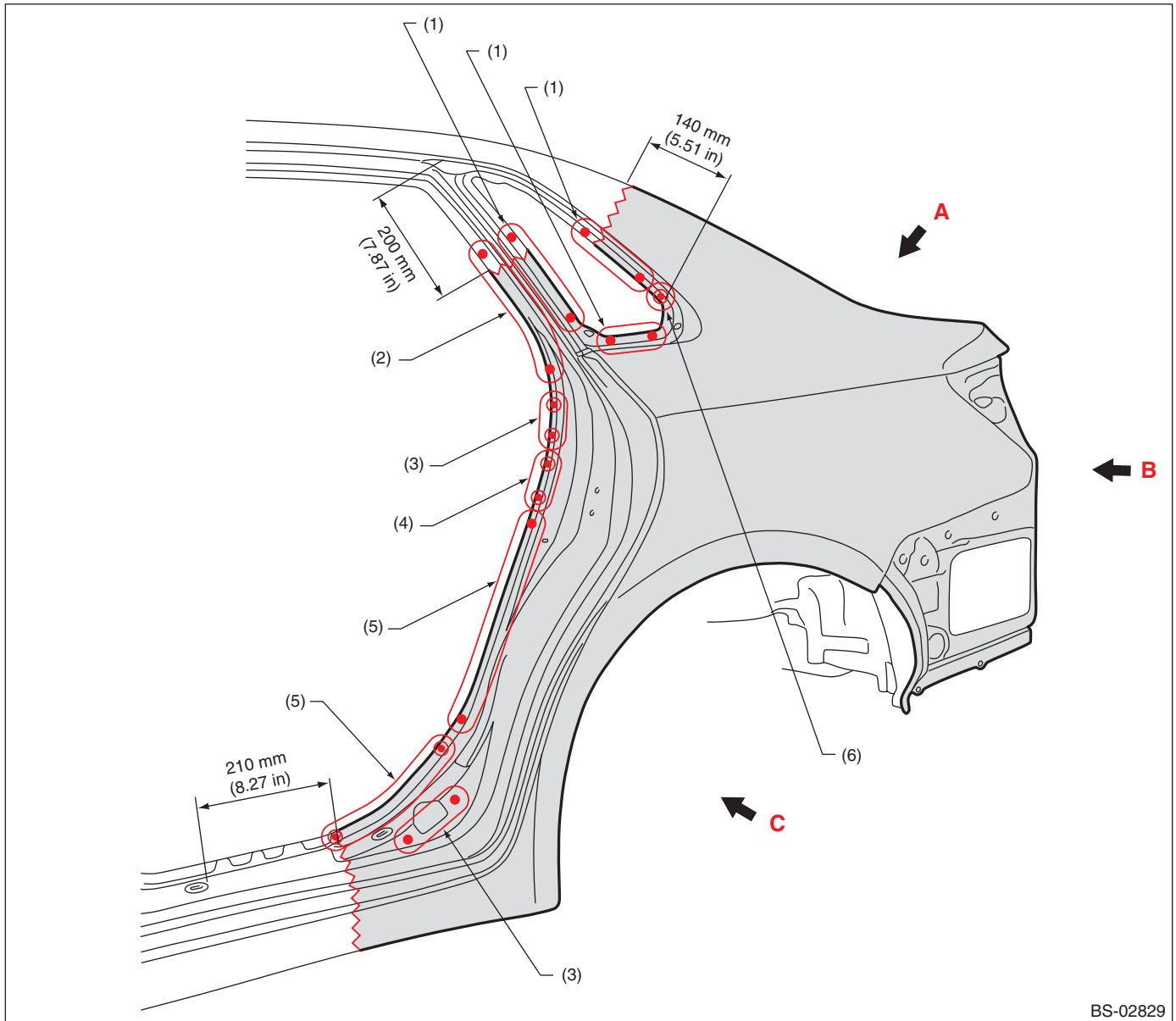
BS-02392

- | | | |
|------------------------|----------------------------------|---------------|
| (1) 16 points | (5) 2 points (service) | (9) 2 points |
| (2) 1 point | (6) 5 points (service) | (10) 3 points |
| (3) 8 points | (7) 6 points (service) | |
| (4) 8 points (service) | (8) 1 point (service · matching) | |

20.Rear Quarter (partial replacement)/4 door

A: REMOVAL

• Overall view

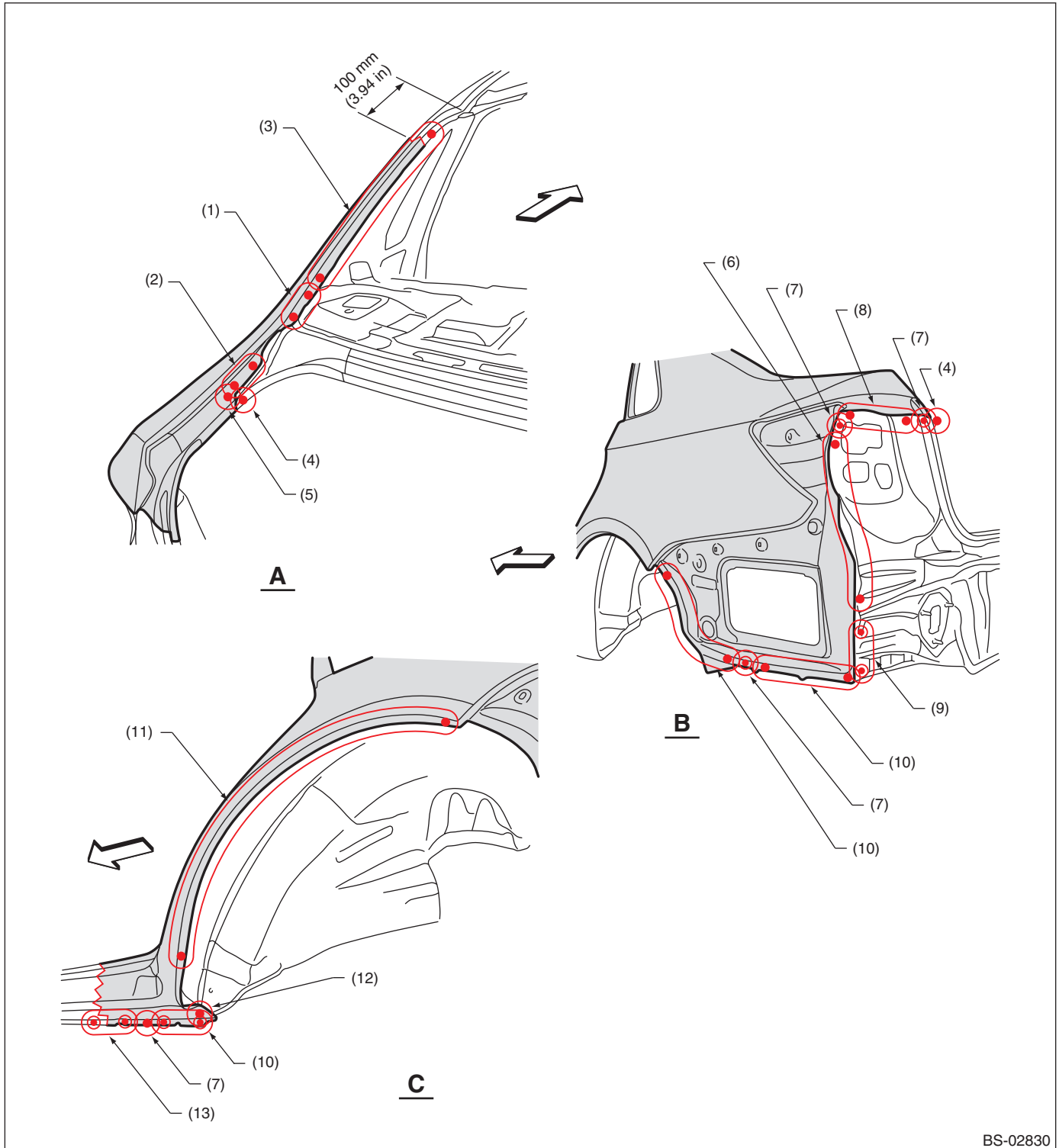


BS-02829

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

Rear Quarter (partial replacement)/4 door

• Views



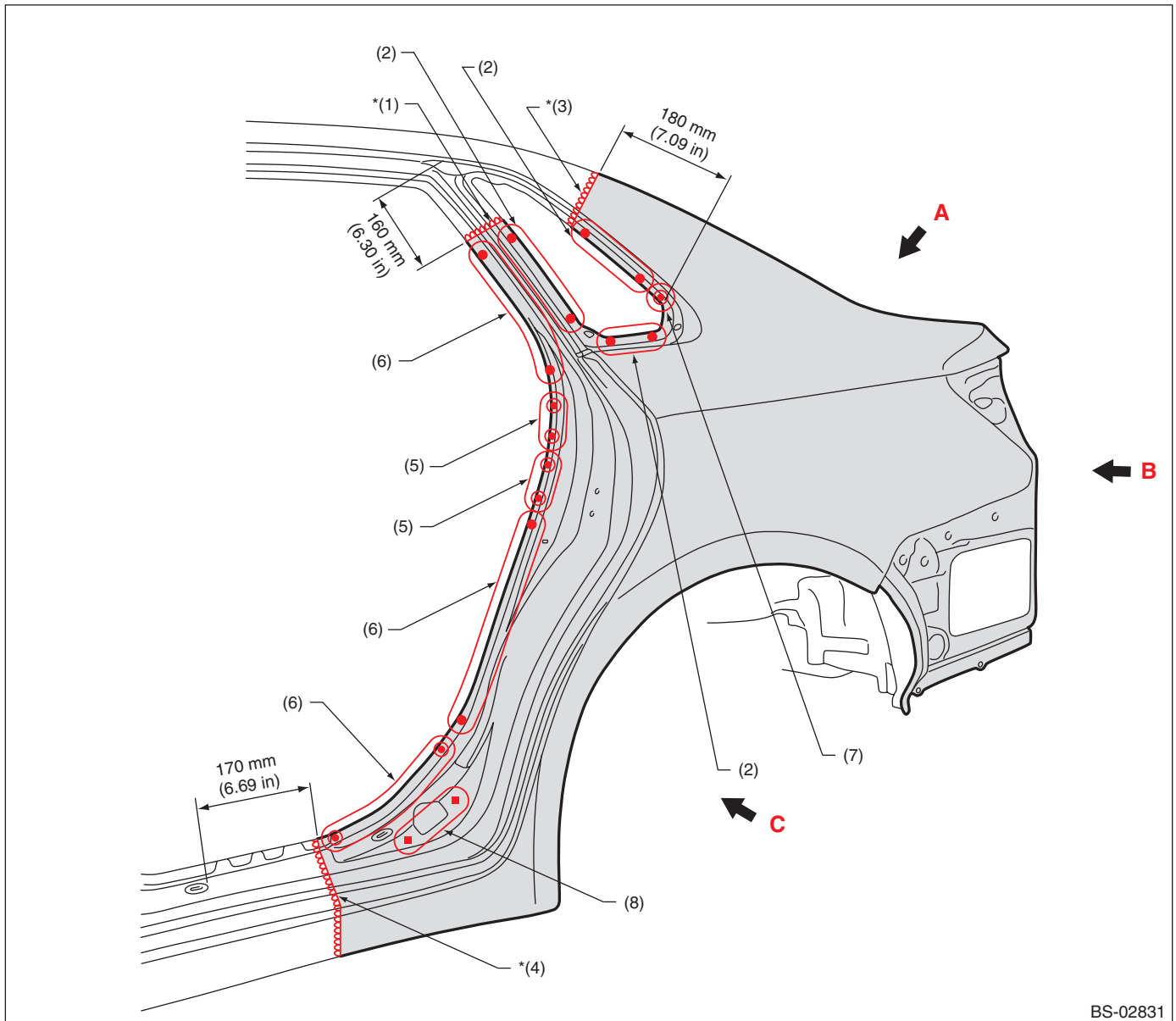
BS-02830

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

Rear Quarter (partial replacement)/4 door

B: INSTALLATION

• Overall view

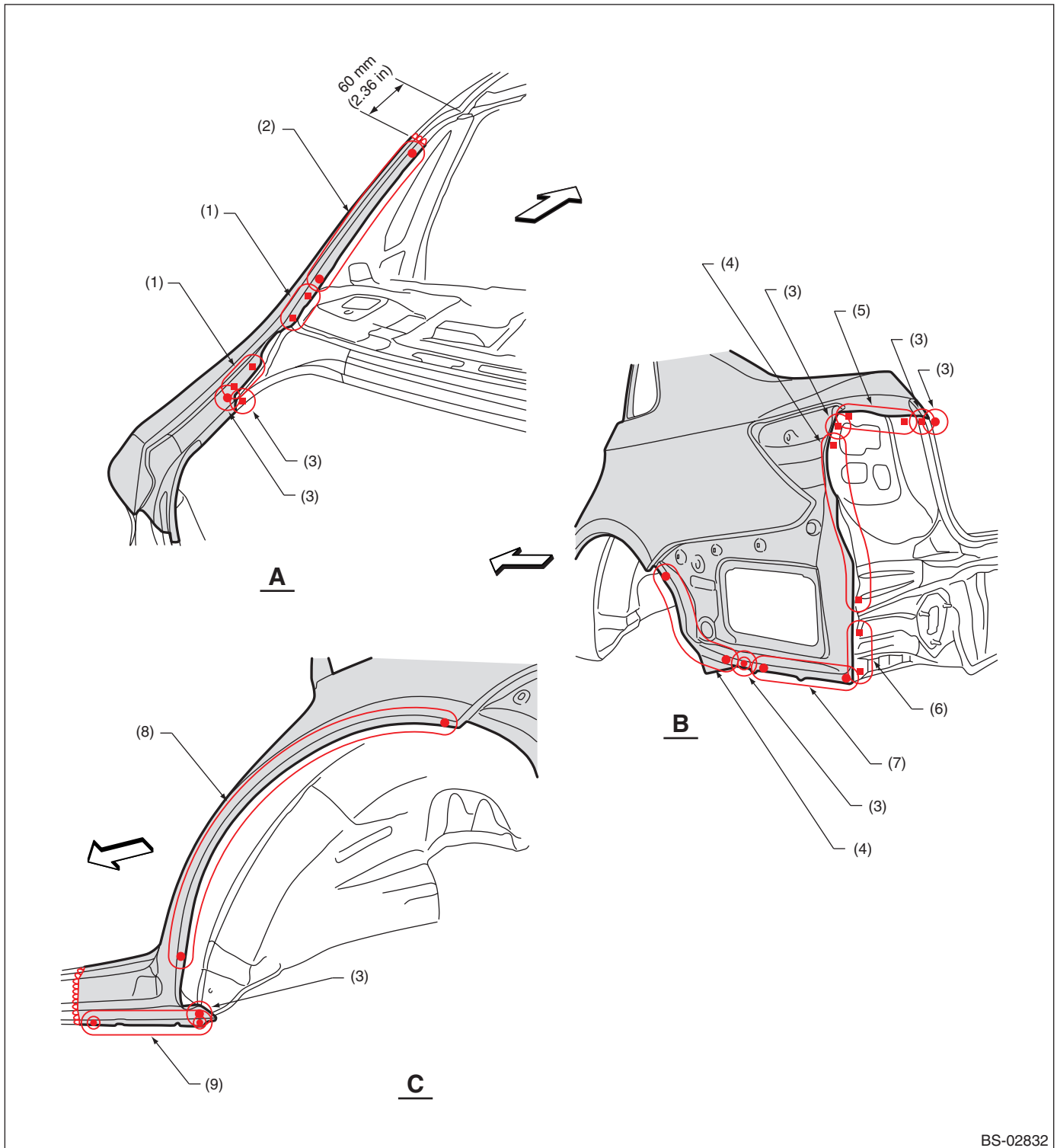


- | | | |
|--------------------------------|---------------------------------|------------------------|
| (1) 1 point [90 mm (3.54 in)] | (4) 1 point [330 mm (12.99 in)] | (7) 1 point |
| (2) 4 points | (5) 2 points | (8) 2 points (service) |
| (3) 1 point [220 mm (8.66 in)] | (6) 6 points | |

For continuous welds marked by *, anticorrosion wax shall be applied thoroughly on the rear.

Rear Quarter (partial replacement)/4 door

• Views



BS-02832

- (1) 2 points (service)
- (2) 10 points
- (3) 1 point

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

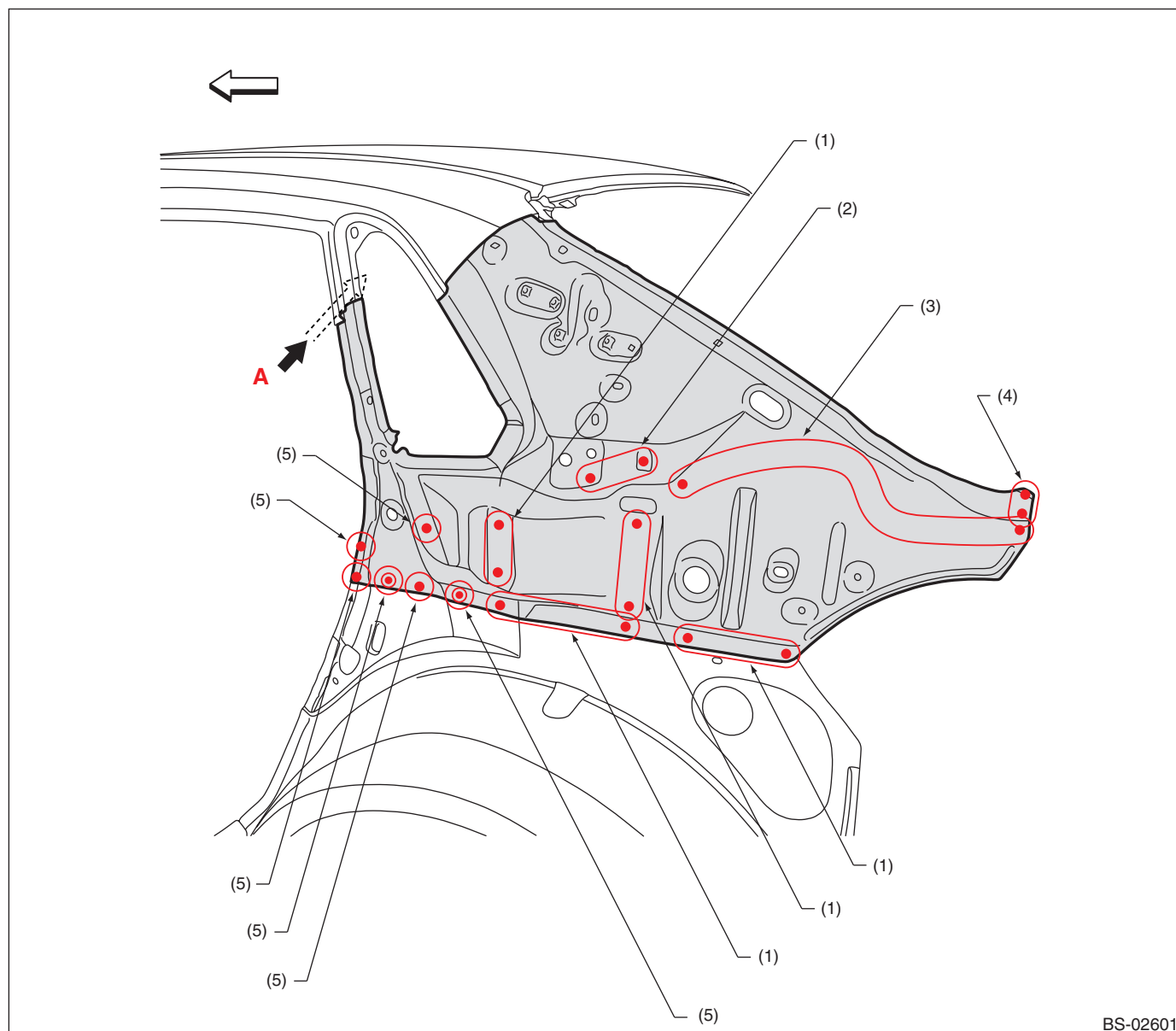
- (7) 6 points
- (8) 16 points
- (9) 8 points

21.Rear Quarter Inner Upper (total replacement)/4 door

A: REMOVAL

1) Rear quarter and reinforcement removal condition

- Overall view



BS-02601

(1) 3 points (outside · 1)

(3) 9 points (outside · 1)

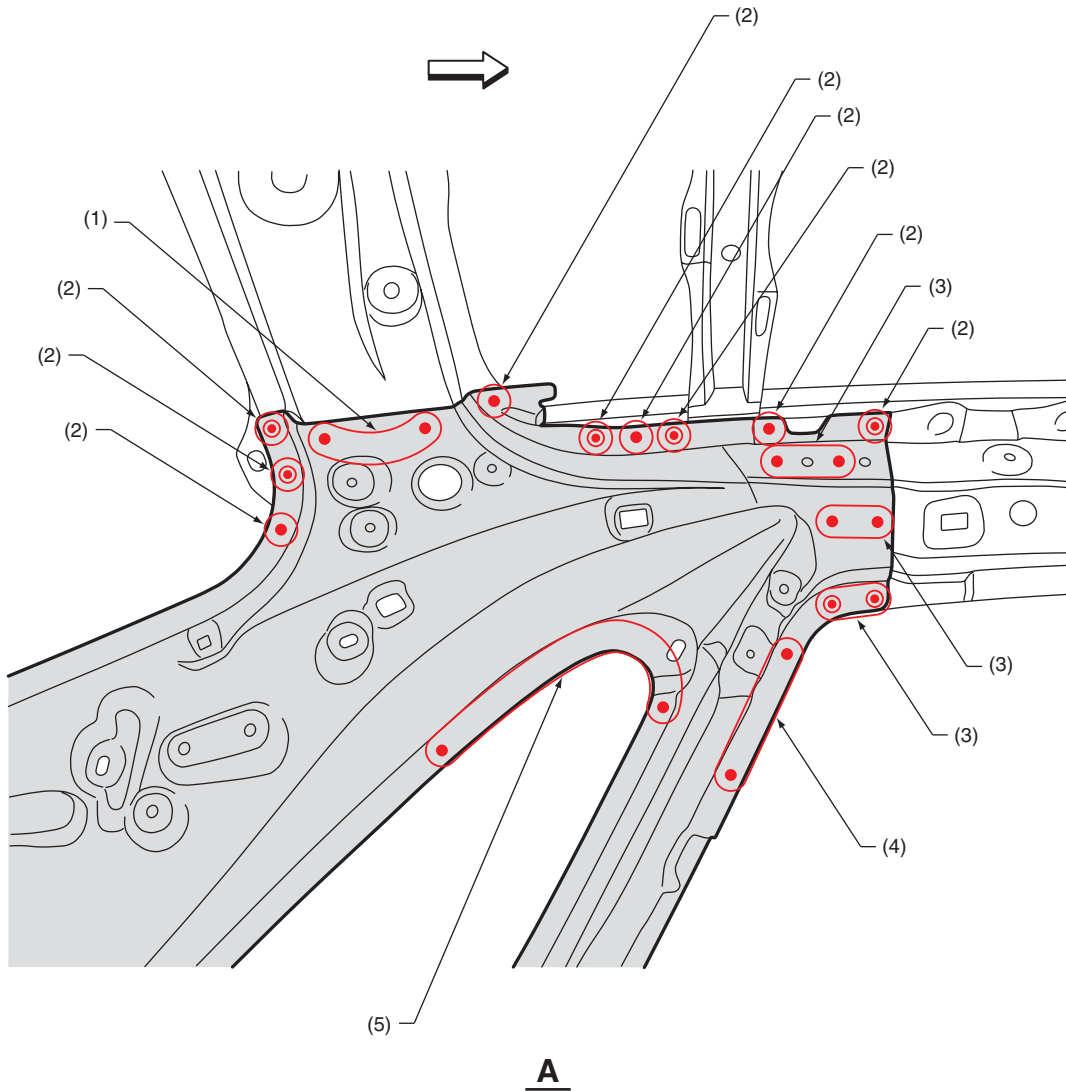
(5) 1 point (outside · 1)

(2) 2 points (outside · 1)

(4) 2 points (top · 1)

Rear Quarter Inner Upper (total replacement)/4 door

• Views



BS-02602

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

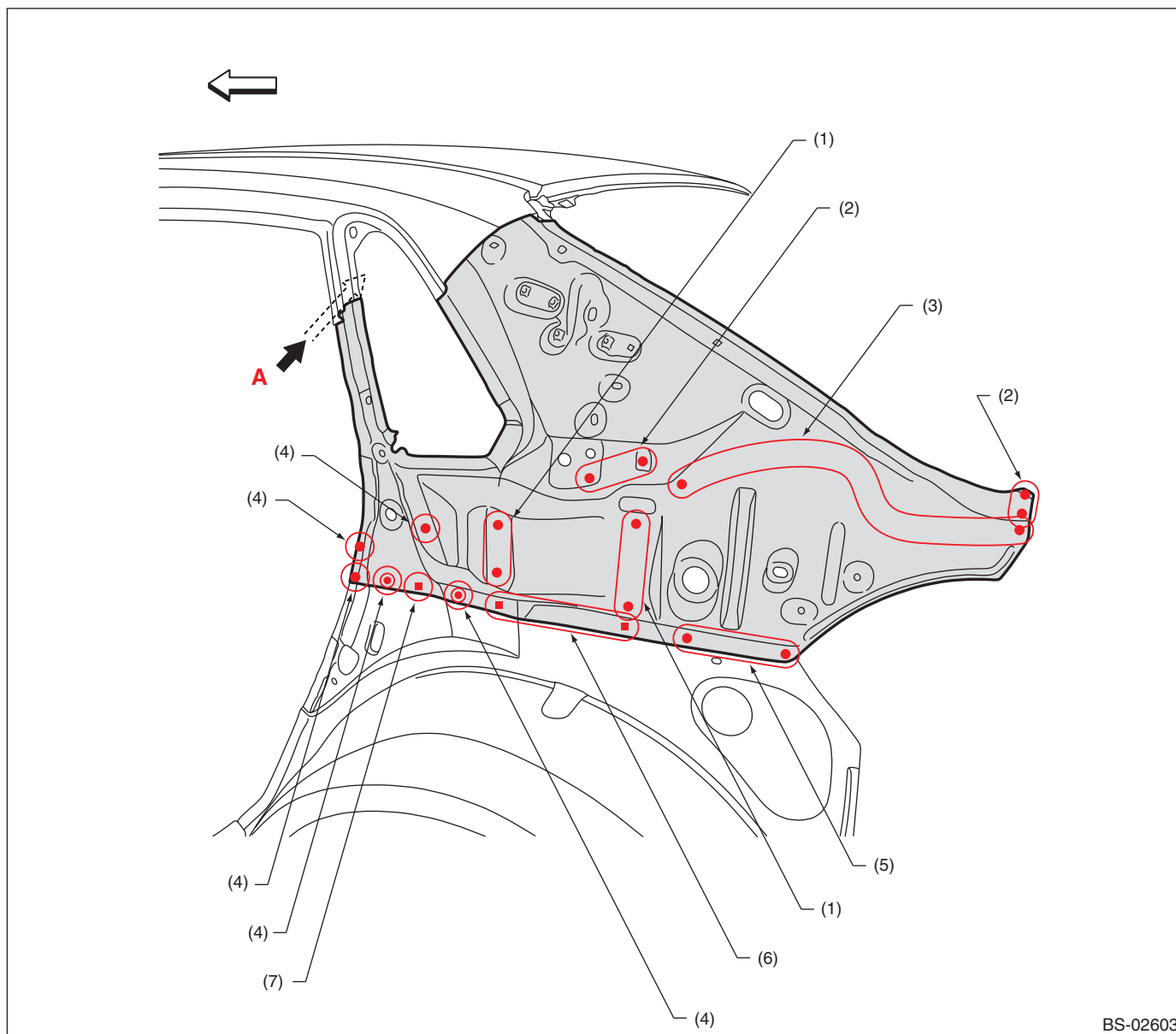
(3) 2 points (inside · 1)
(4) 3 points (inside · 1)

(5) 4 points (inside · 1)

Rear Quarter Inner Upper (total replacement)/4 door

B: INSTALLATION

- Overall view



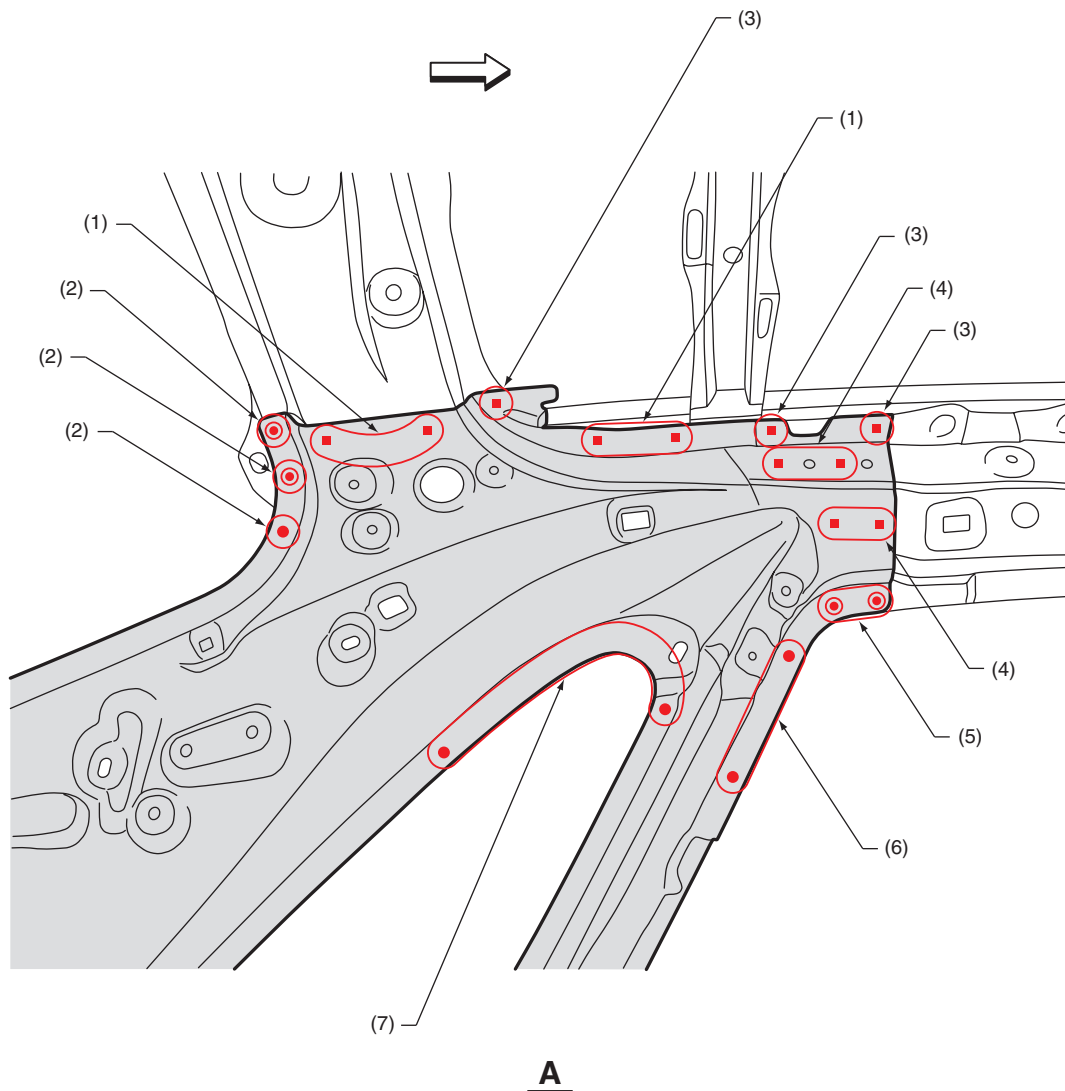
- (1) 3 points
- (2) 2 points
- (3) 11 points

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

- (7) 1 point (service)

Rear Quarter Inner Upper (total replacement)/4 door

• Views



BS-02604

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

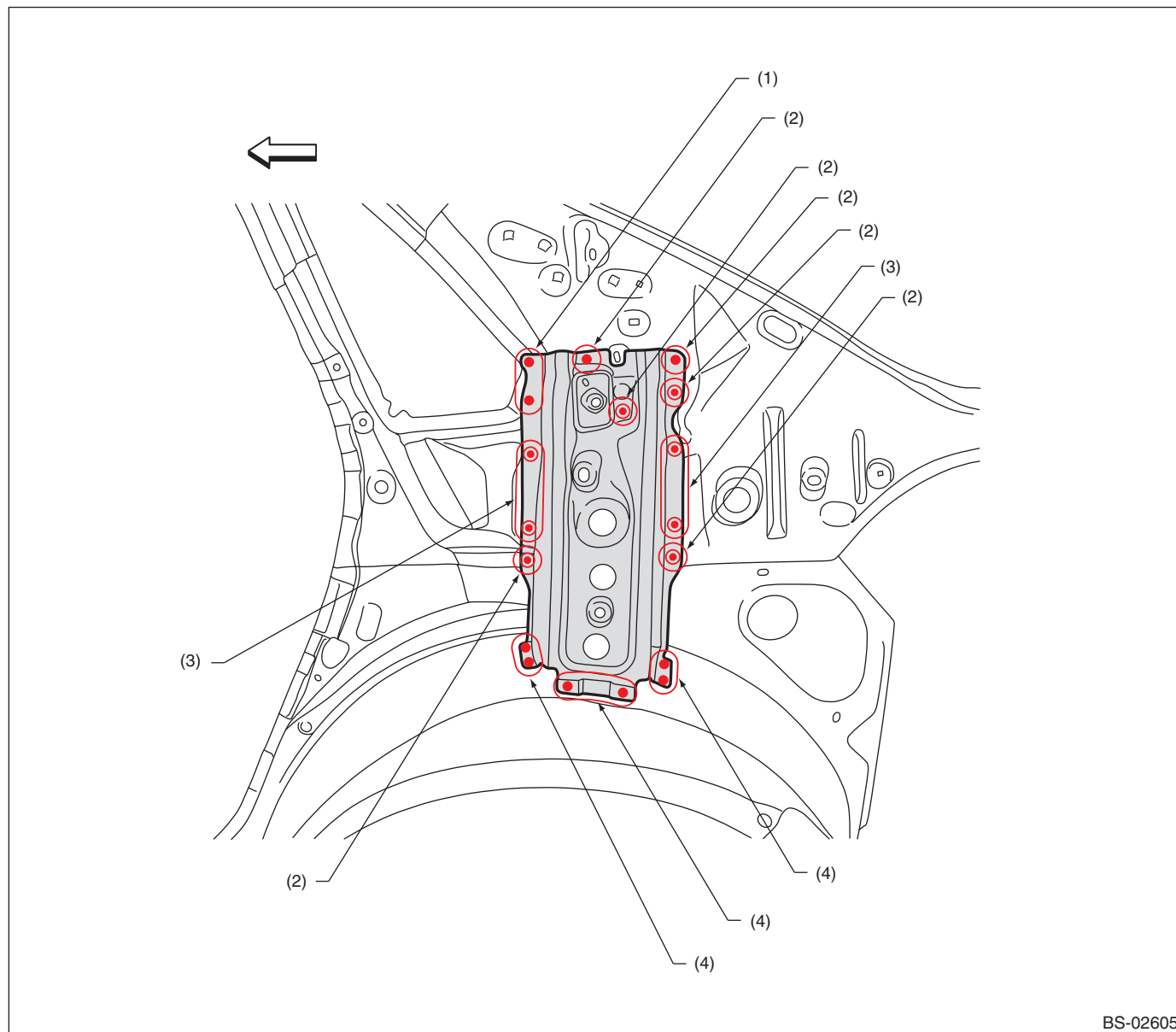
- (4) 2 points (service)
- (5) 2 points
- (6) 3 points

- (7) 4 points

22.Rear Quarter Inner Reinforcement (total replacement)/4 door

A: REMOVAL

1) Rear quarter removal condition



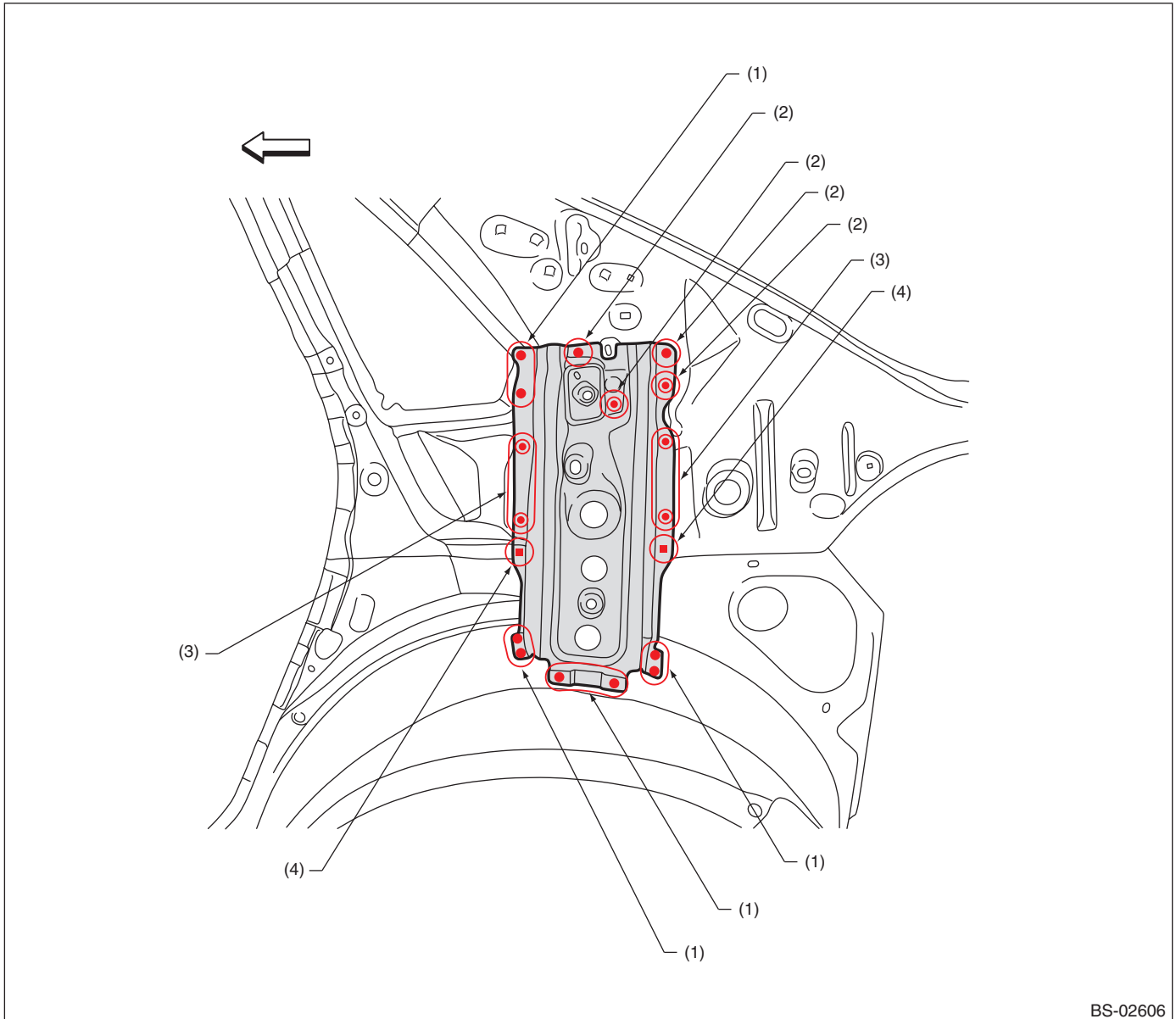
(1) 2 points (outside · 1)
(2) 1 point (outside · 1)

(3) 3 points (outside · 1)

(4) 2 points (top · 1)

Rear Quarter Inner Reinforcement (total replacement)/4 door

B: INSTALLATION



BS-02606

(1) 2 points
(2) 1 point

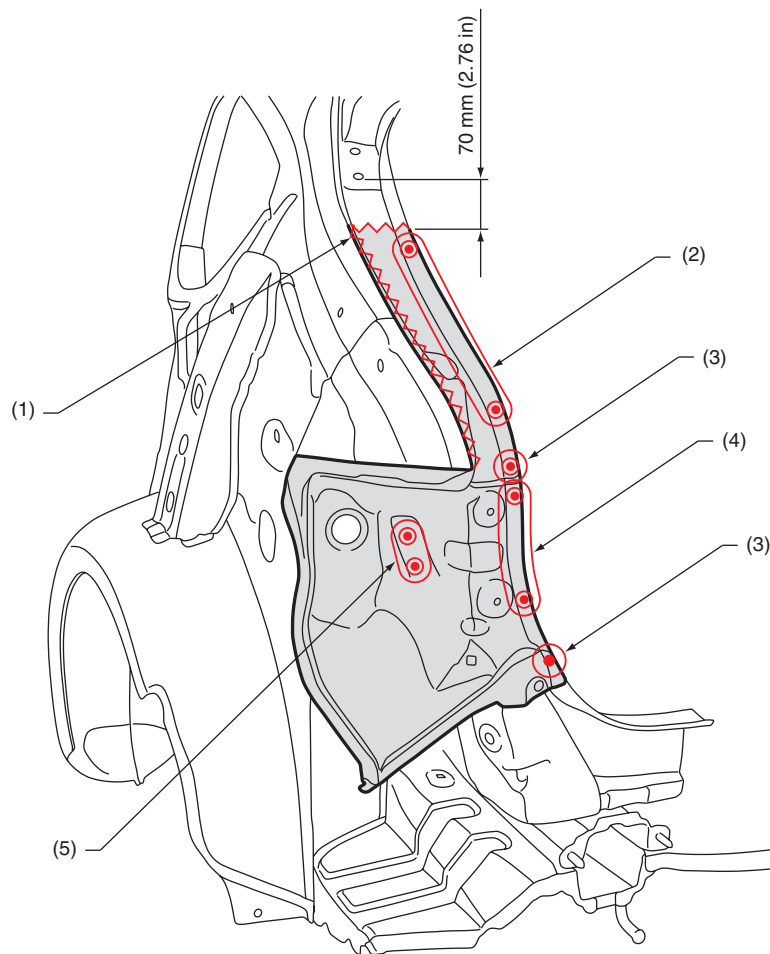
(3) 3 points

(4) 1 point (service)

23.D-pillar Extension, Quarter End (partial replacement)

A: REMOVAL

1) Rear quarter removal condition

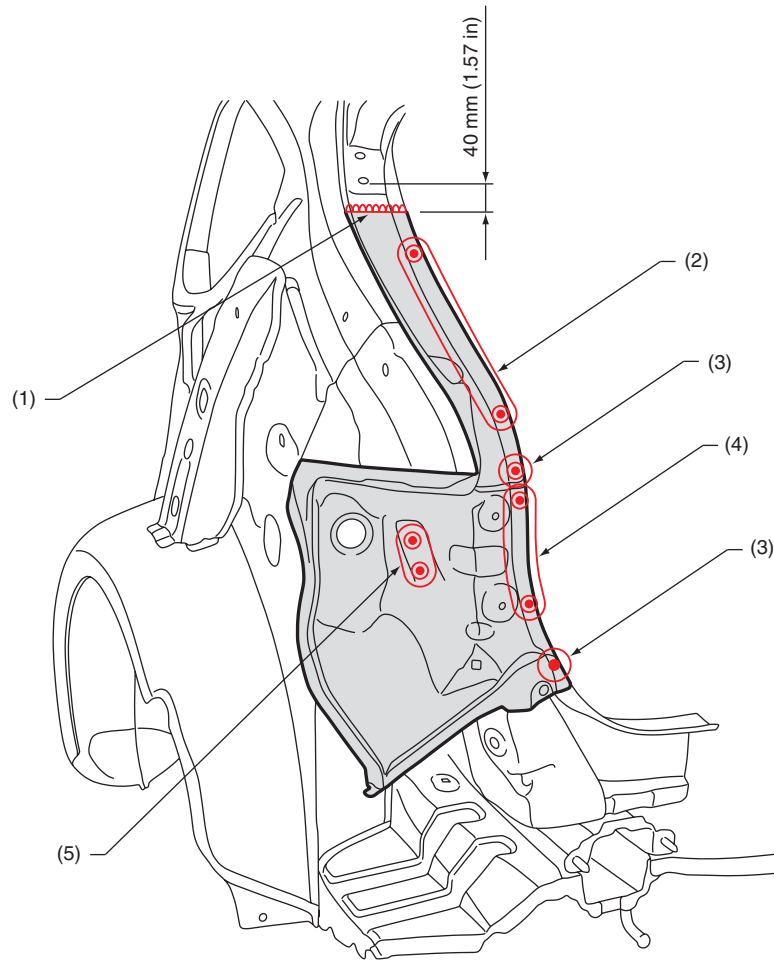


BS-02833

- | | | |
|----------------------------|----------------------------|----------------------------|
| (1) Rough cutting | (3) 1 point (outside · 1) | (5) 2 points (outside · 1) |
| (2) 7 points (outside · 1) | (4) 3 points (outside · 1) | |

D-pillar Extension, Quarter End (partial replacement)

B: INSTALLATION



BS-02834

(1) 1 point [105 mm (4.13 in)]

(2) 9 points

(3) 1 point

(4) 4 points

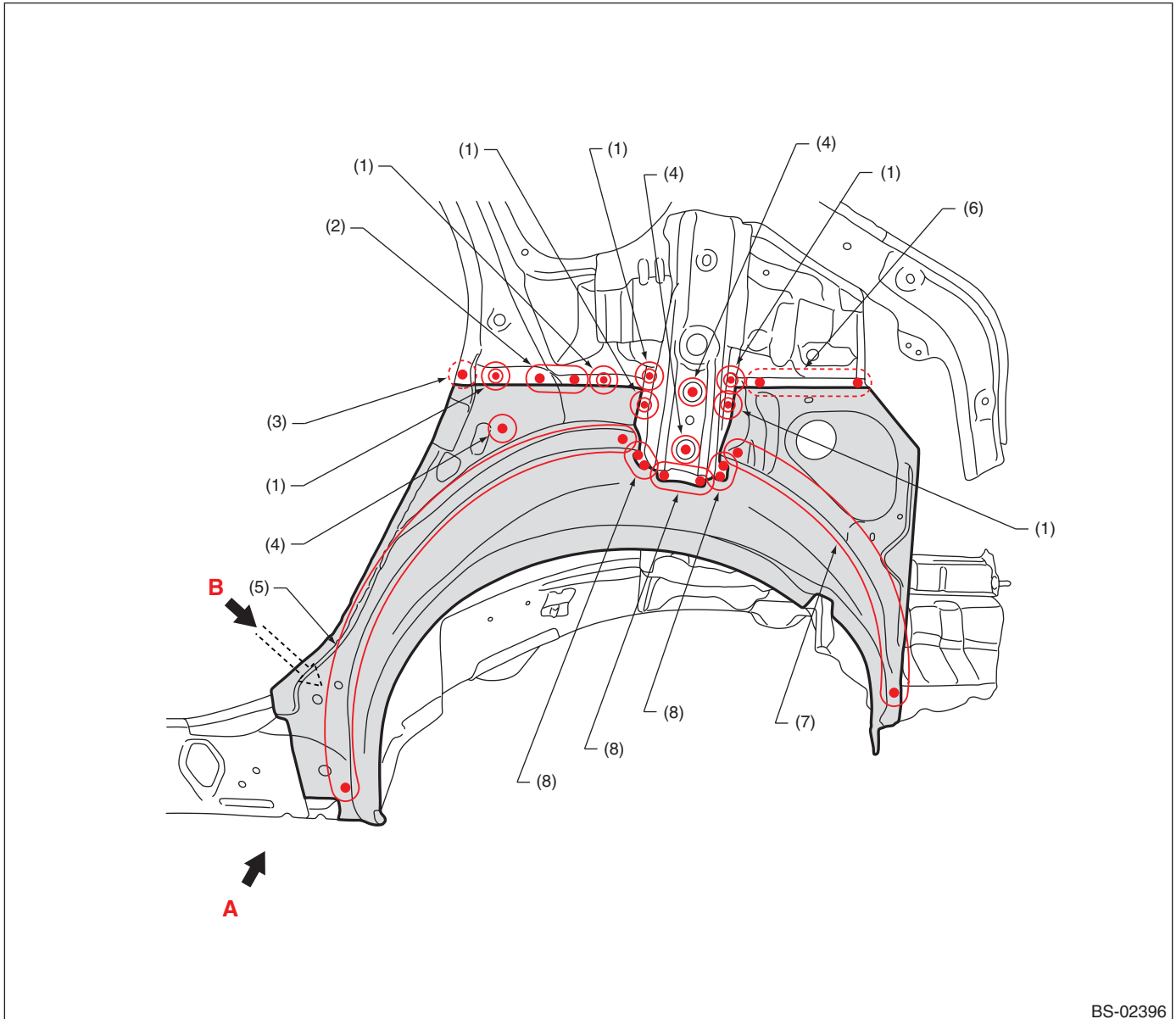
(5) 2 points

24.Rear wheel apron (partial replacement)

A: REMOVAL

1) Rear quarter side sill reinforcement outer removal condition

• Overall view

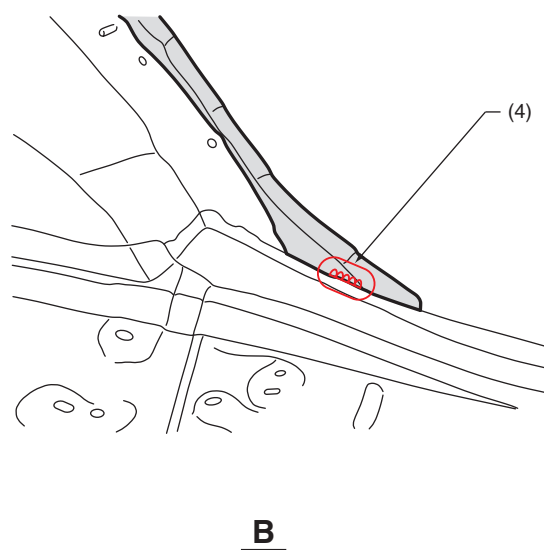
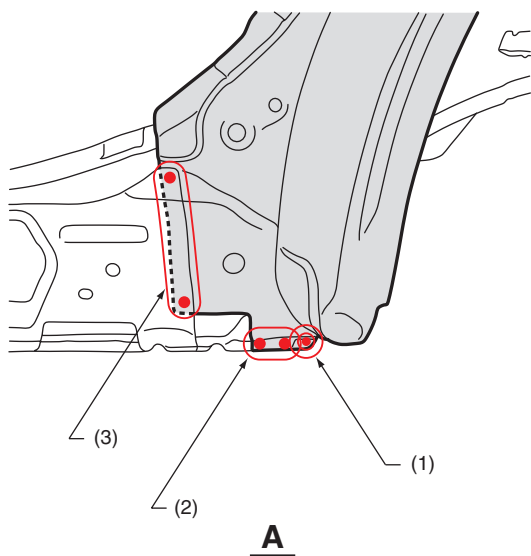


BS-02396

- | | | |
|----------------------------|-----------------------------|----------------------------|
| (1) 1 point (outside · 2) | (4) 1 point (outside · 1) | (7) 9 points (outside · 1) |
| (2) 2 points (outside · 1) | (5) 15 points (outside · 1) | (8) 2 points (bottom · 1) |
| (3) 1 point (inside · 1) | (6) 3 points (inside · 1) | |

Rear wheel apron (partial replacement)

- Views



BS-02397

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

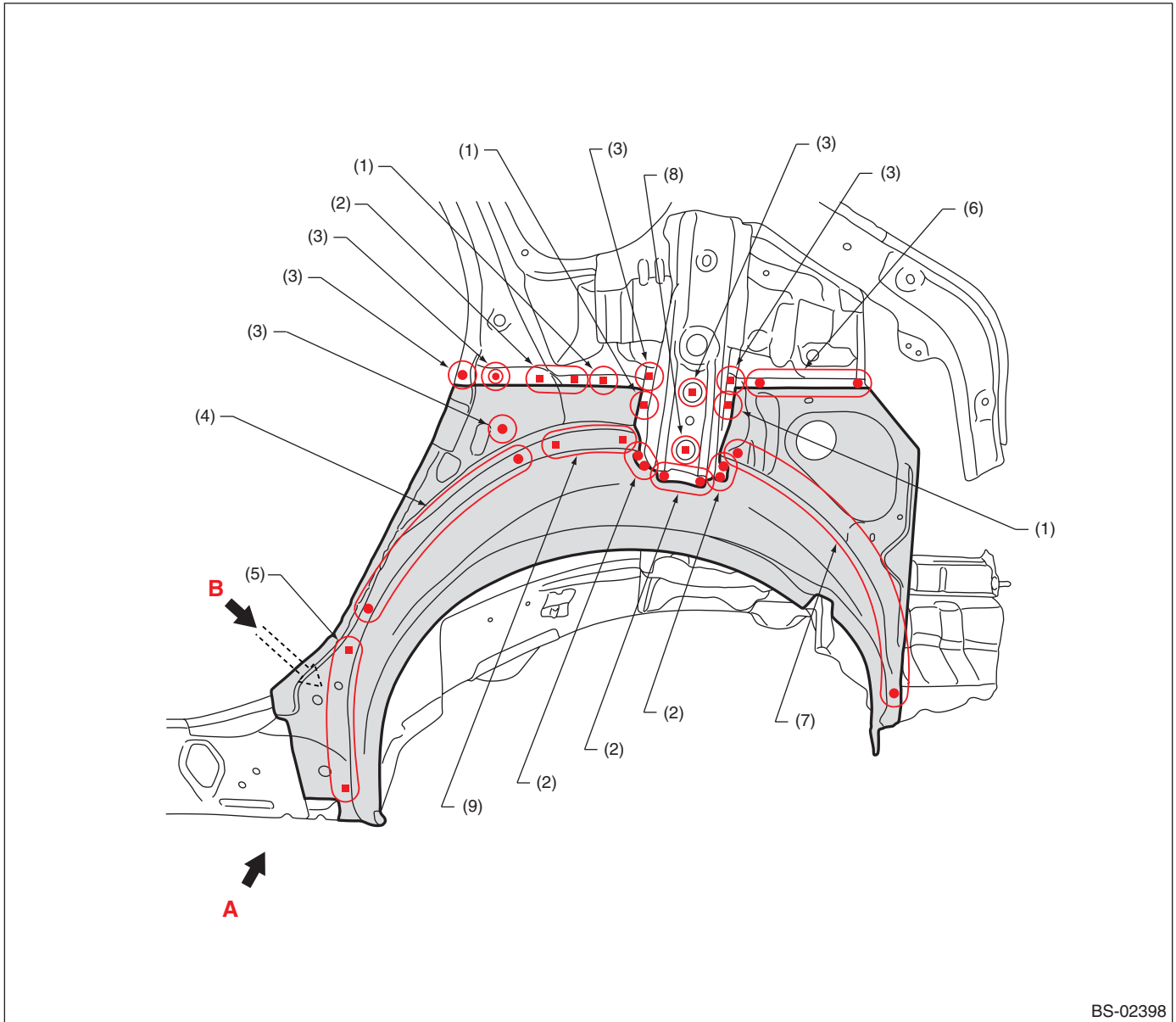
- (3) 3 points (outside · 1)

- (4) 1 point (inside · belt sander)

Rear wheel apron (partial replacement)

B: INSTALLATION

- Overall view



BS-02398

(1) 1 point (service · matching)

(2) 2 points

(3) 1 point

(4) 7 points

(5) 5 points (service)

(6) 4 points

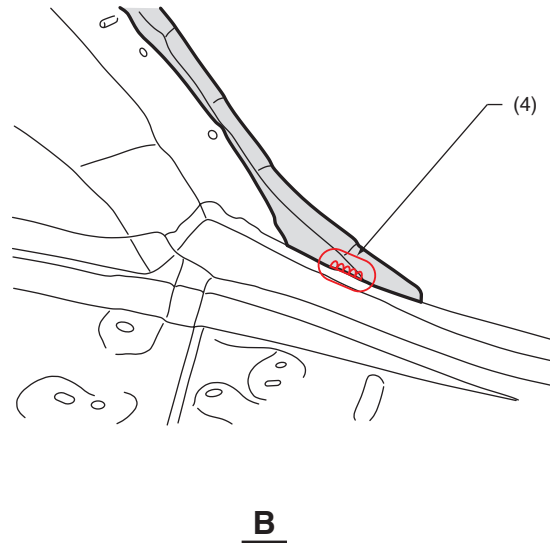
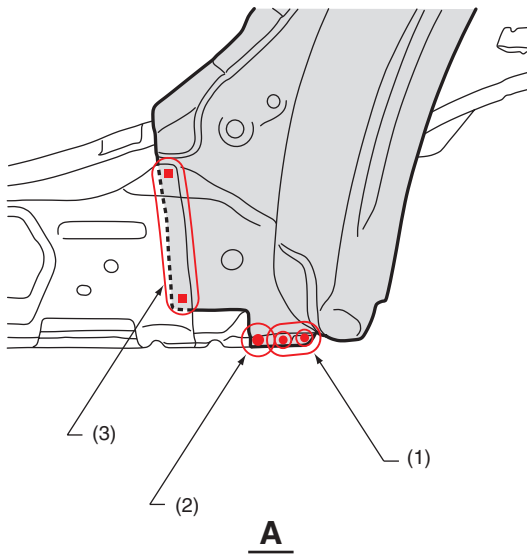
(7) 11 points

(8) 1 point (service)

(9) 3 points (service)

Rear wheel apron (partial replacement)

- Views



BS-02399

(1) 2 points
(2) 1 point

(3) 3 points

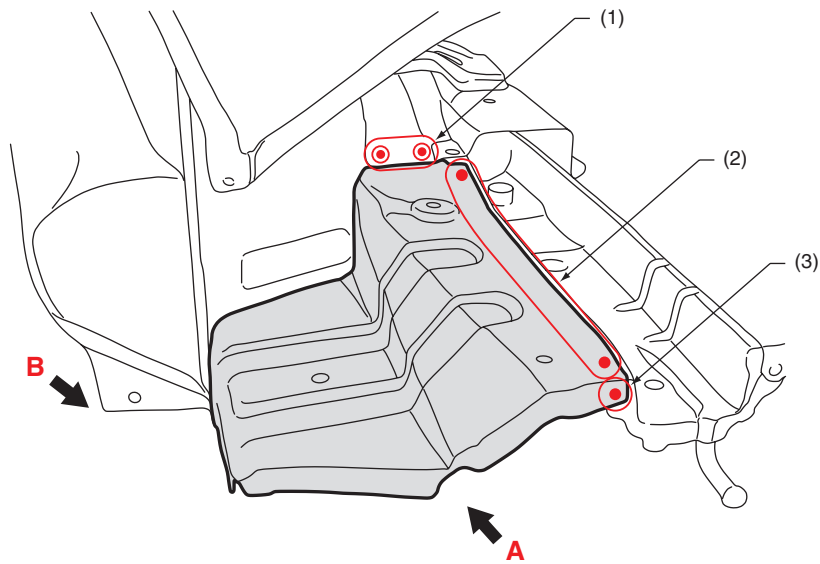
(4) 1 point [20 mm (0.79 in)]

25.Rear Floor Side (total replacement)/5 door

A: REMOVAL

1) Rear skirt and rear quarter removal condition

- Overall view



BS-02400

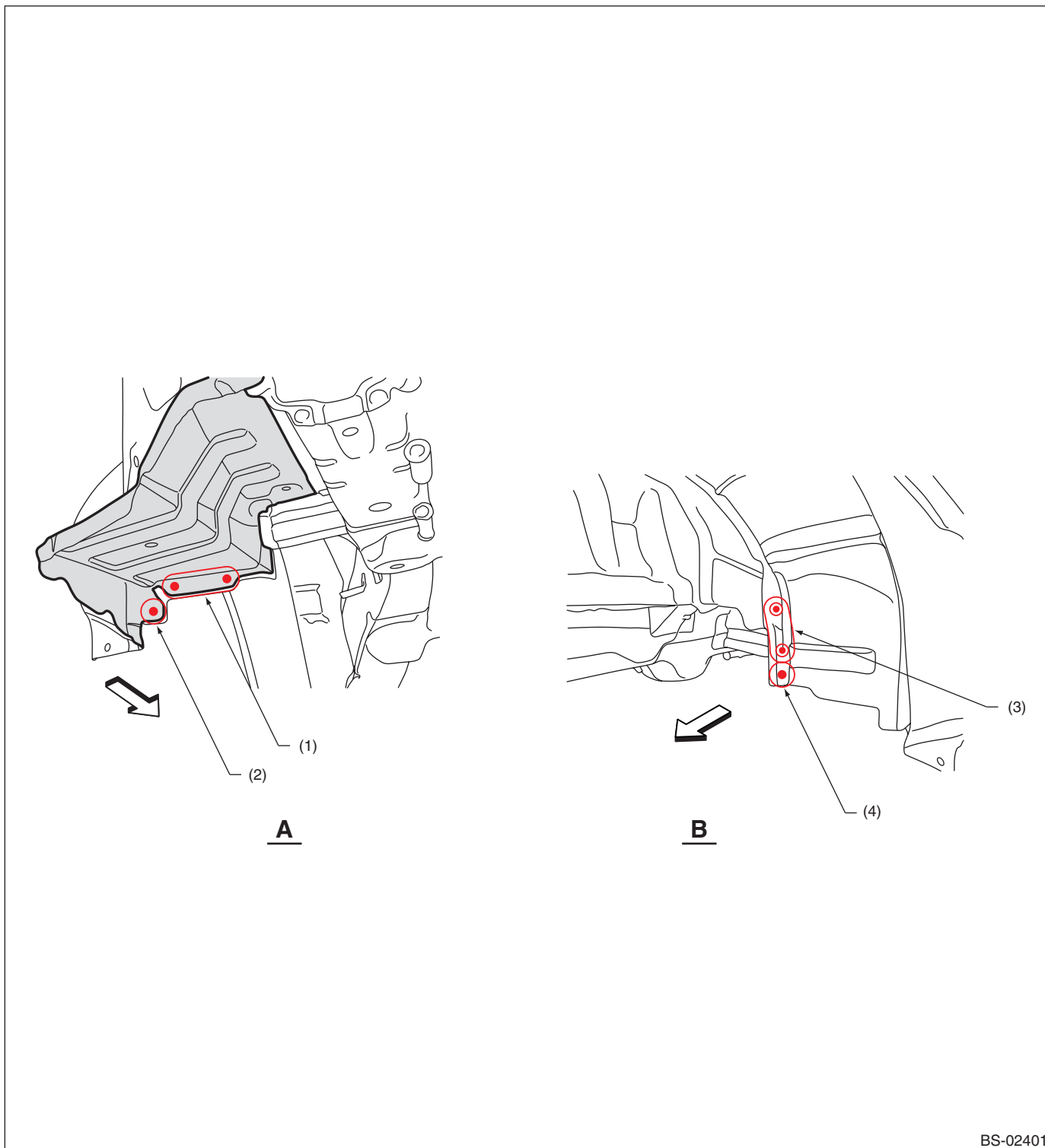
(1) 2 points (top · 2)

(2) 8 points (top · 1)

(3) 1 point (outside · 1)

Rear Floor Side (total replacement)/5 door

- Views



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

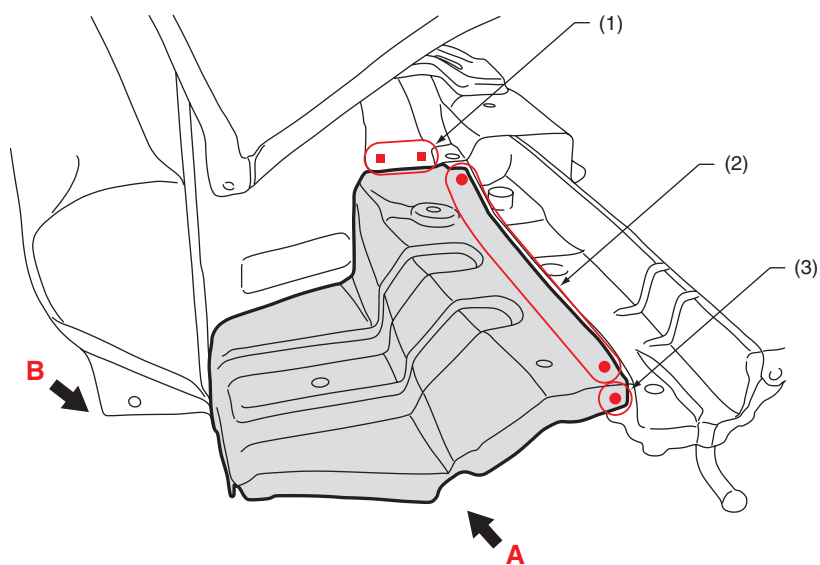
- (3) 2 points (inside · 2)

- (4) 1 point (inside · 1)

Rear Floor Side (total replacement)/5 door

B: INSTALLATION

- Overall view



BS-02402

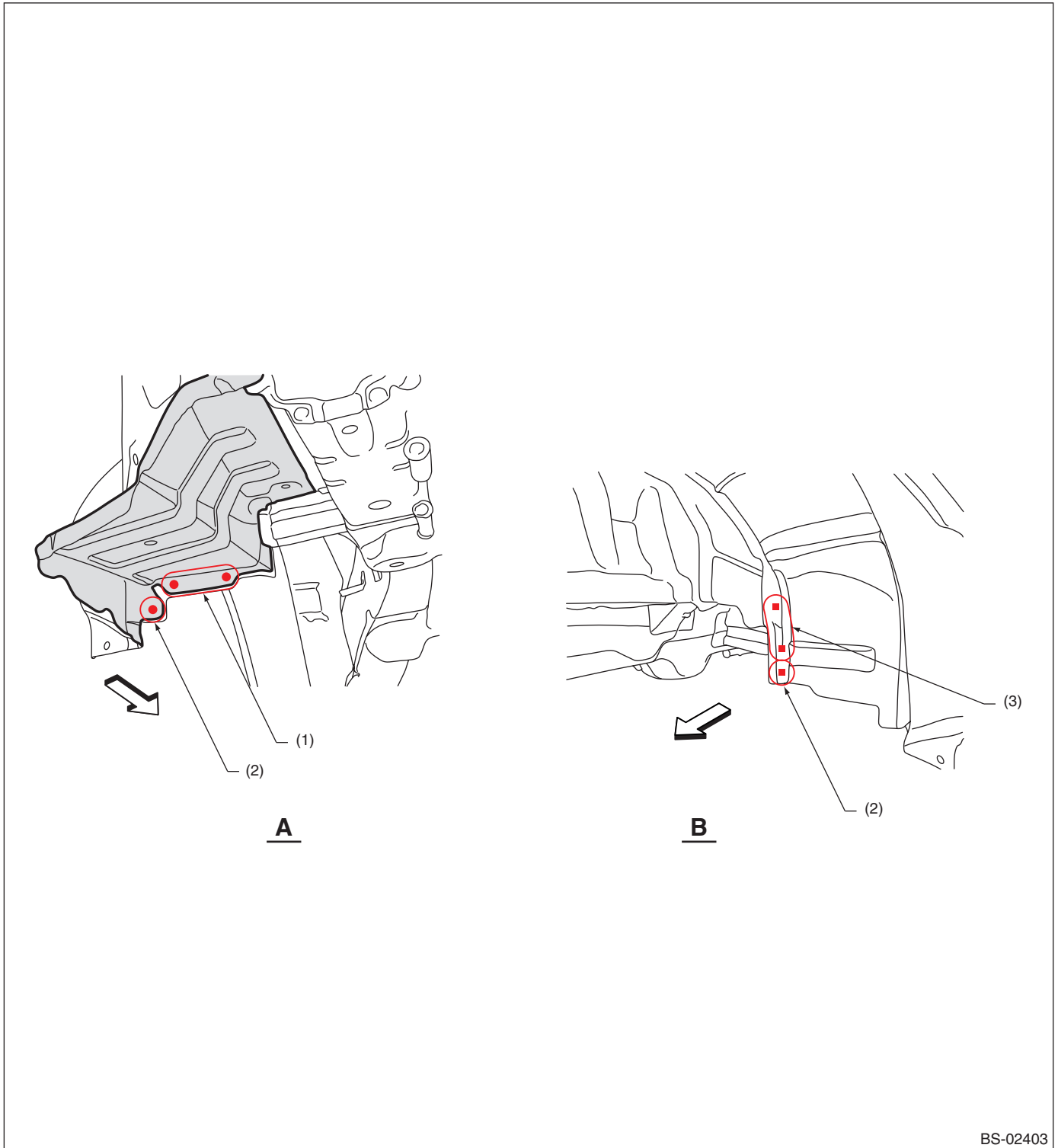
(1) 2 points (service · matching)

(2) 10 points

(3) 1 point

Rear Floor Side (total replacement)/5 door

- Views



(1) 3 points

(2) 1 point

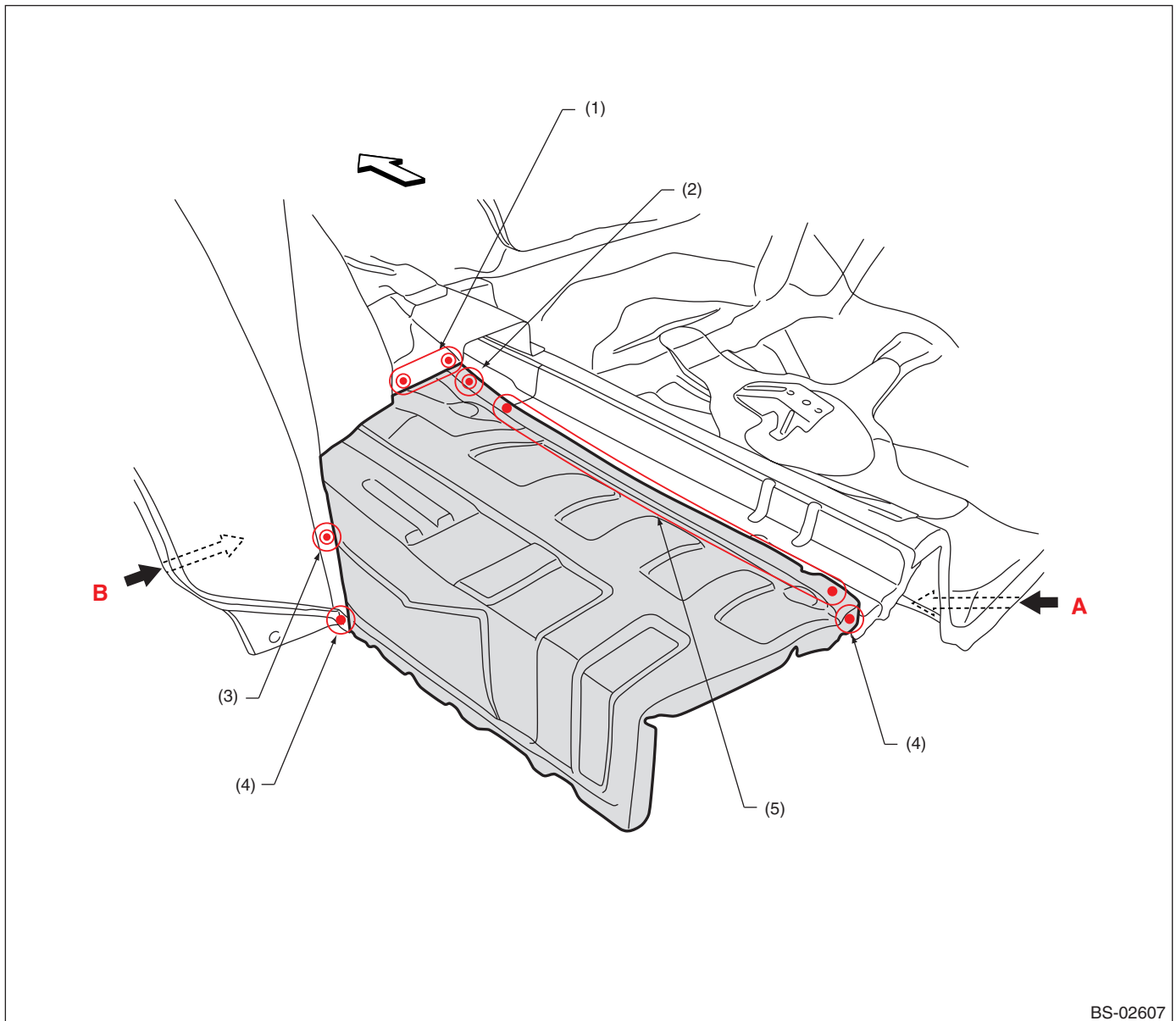
(3) 2 points (service · matching)

26.Rear Floor Side (total replacement)/4 door

A: REMOVAL

1) Rear skirt and rear quarter, rear side frame upper rear removal condition

• Overall view



BS-02607

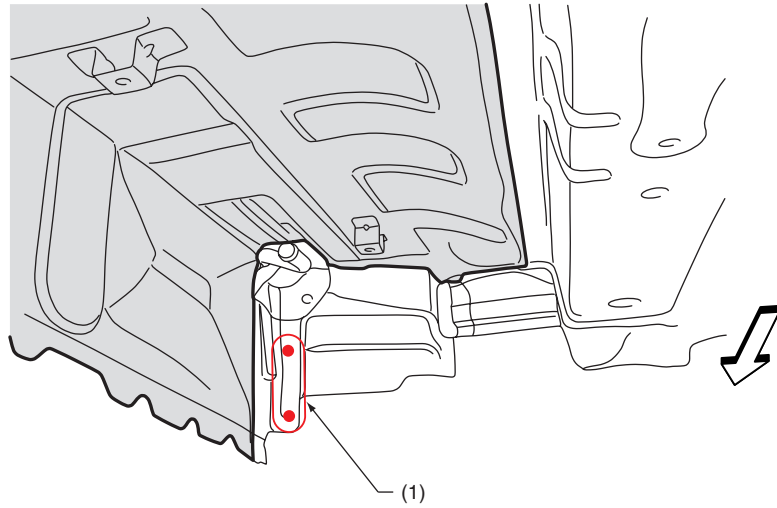
(1) 2 points (top · 2)
(2) 1 point (top · 1)

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

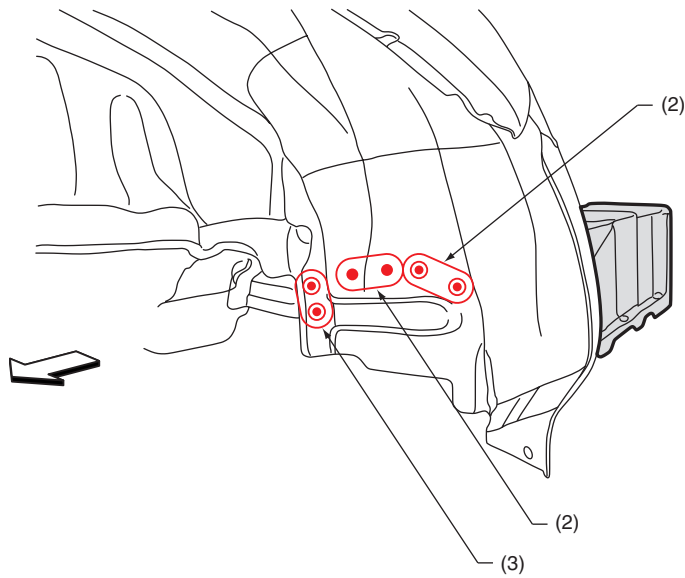
(5) 10 points (top · 1)

Rear Floor Side (total replacement)/4 door

- Views



A



B

BS-02608

(1) 2 points (inside · 1)

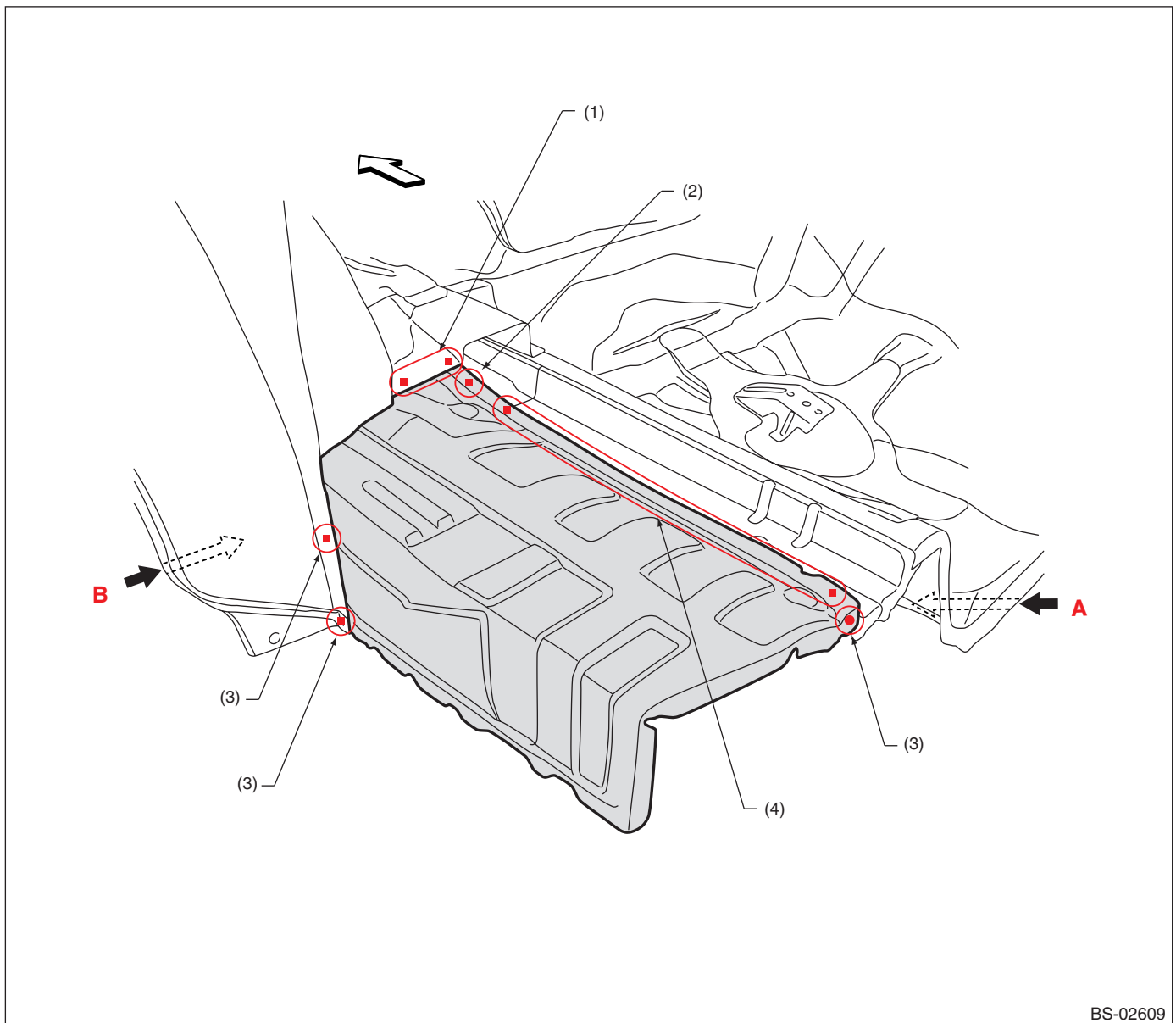
(2) 2 points (outside · 1)

(3) 2 points (outside · 2)

Rear Floor Side (total replacement)/4 door

B: INSTALLATION

- Overall view



BS-02609

(1) 2 points (service · matching)

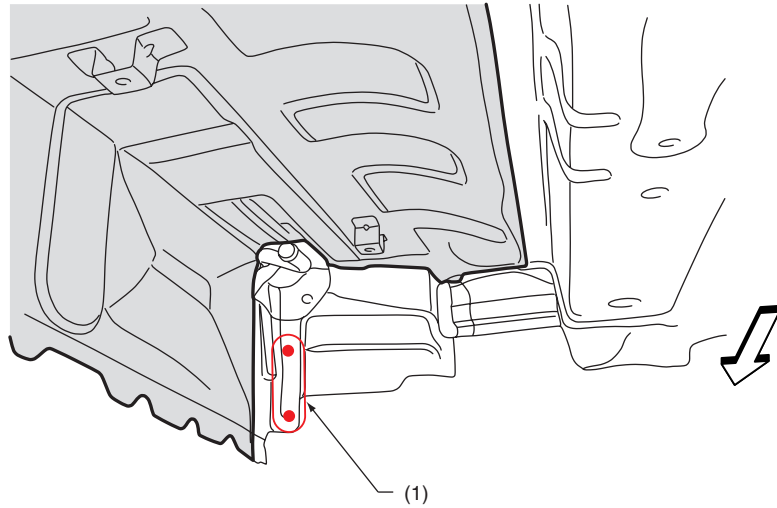
(3) 1 point

(3) 10 points (service)

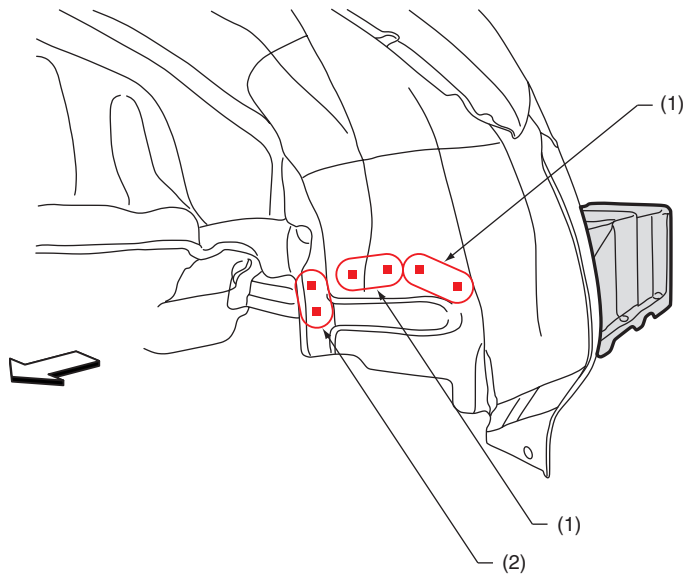
(2) 1 point (service)

Rear Floor Side (total replacement)/4 door

- Views



A



B

BS-02610

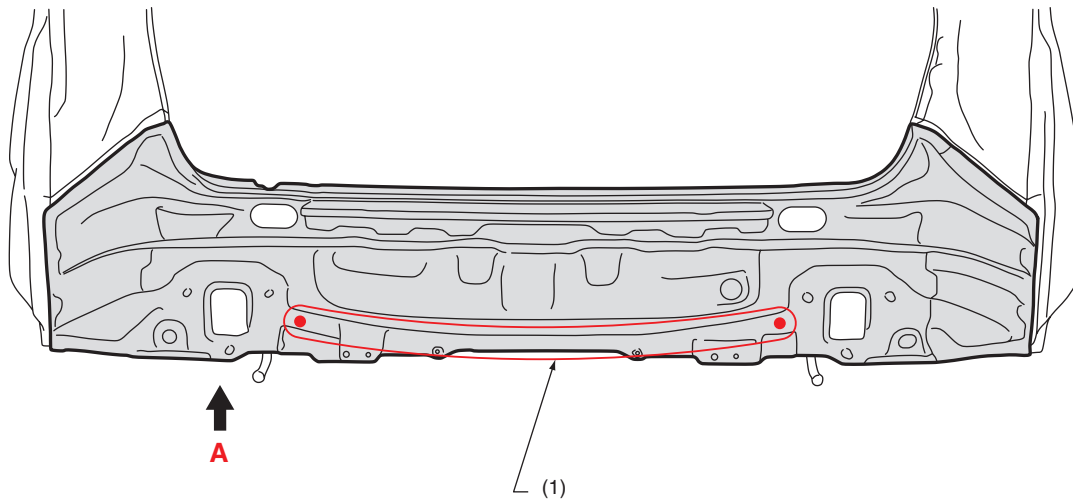
(1) 2 points

(2) 2 points (service · matching)

27.Rear Skirt (total replacement)/5 door

A: REMOVAL

- Overall view

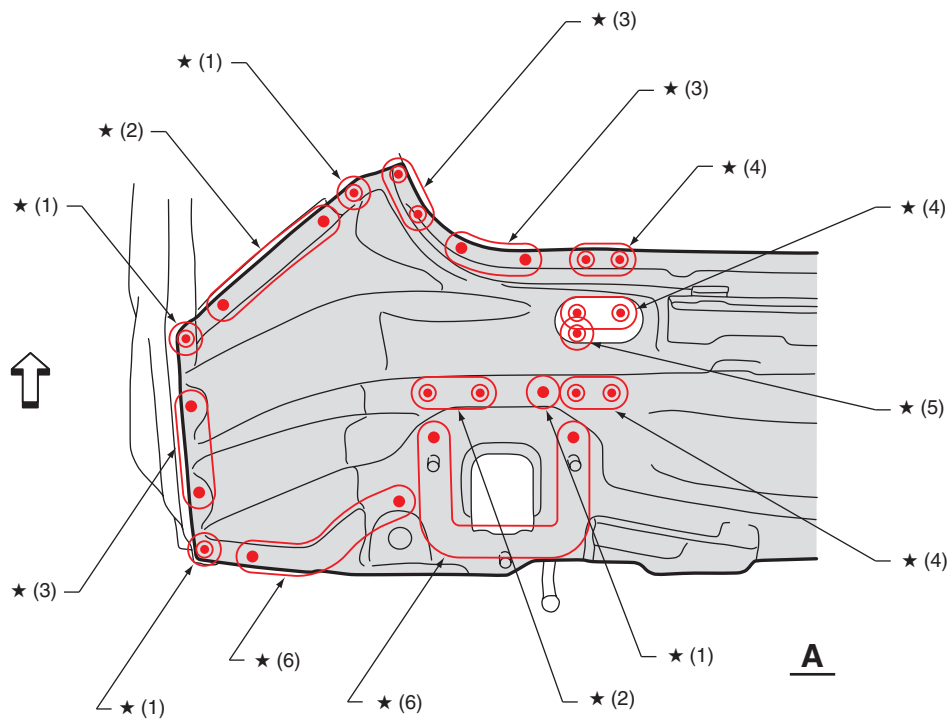


BS-02404

(1) 10 points (outside · 1)

Rear Skirt (total replacement)/5 door

• Views



BS-02405

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

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

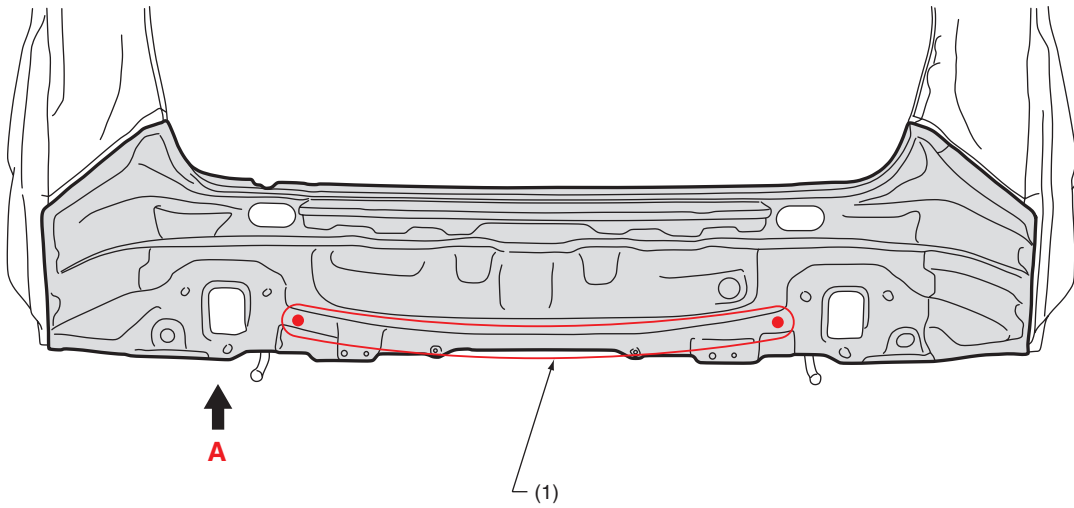
(5) 1 point (outside · 2)
(6) 4 points (outside · 1)

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

Rear Skirt (total replacement)/5 door

B: INSTALLATION

- Overall view

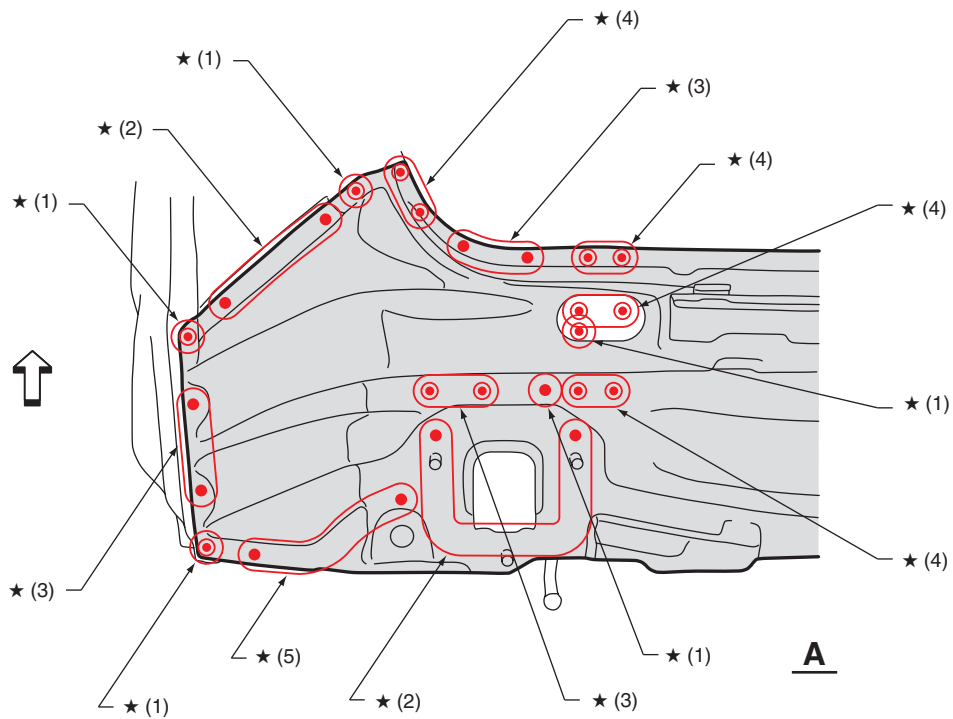


BS-02406

(1) 12 points

Rear Skirt (total replacement)/5 door

• Views



BS-02407

(1) 1 point
(2) 4 points

(3) 3 points
(4) 2 points

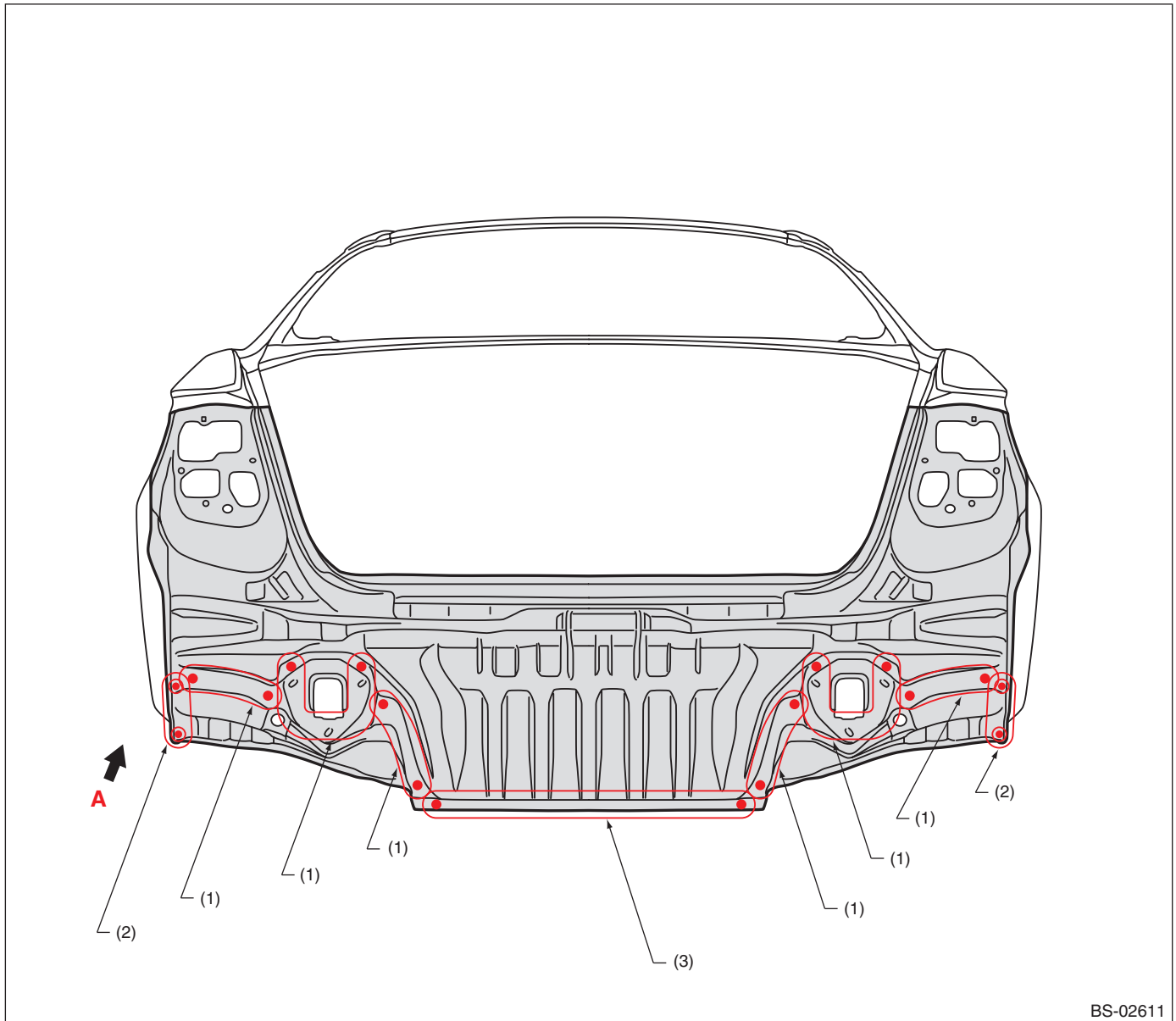
(5) 5 points

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

28.Rear Skirt (total replacement)/4 door

A: REMOVAL

- Overall view



BS-02611

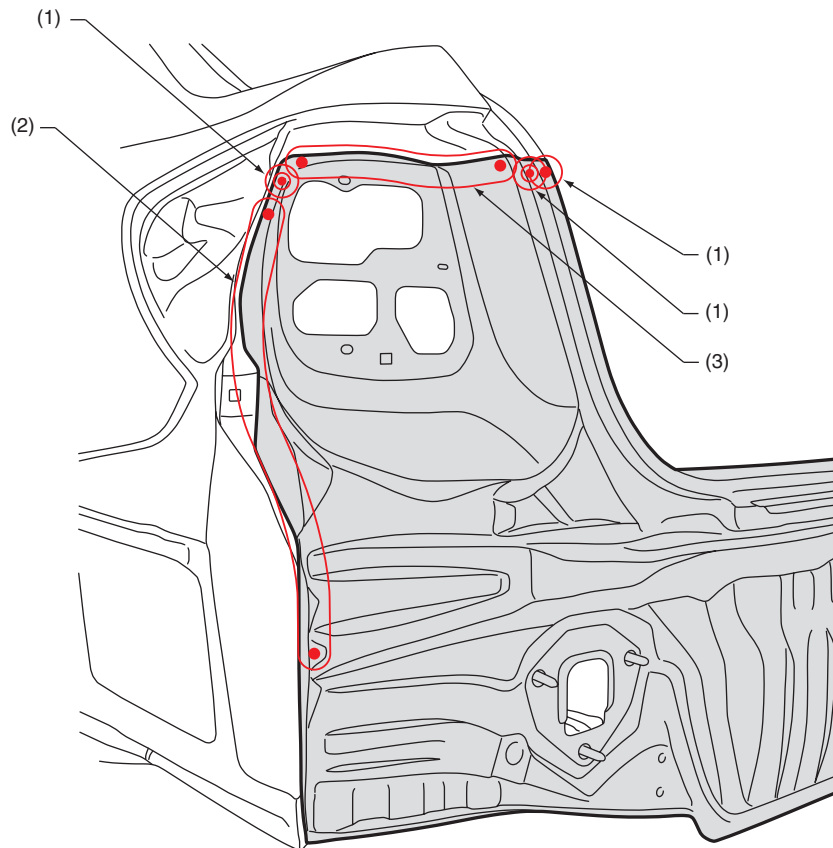
(1) 4 points (outside · 1)

(2) 3 points (outside · 1)

(3) 9 points (outside · 1)

Rear Skirt (total replacement)/4 door

- Views



A

BS-02612

(1) 1 point (outside · 1)

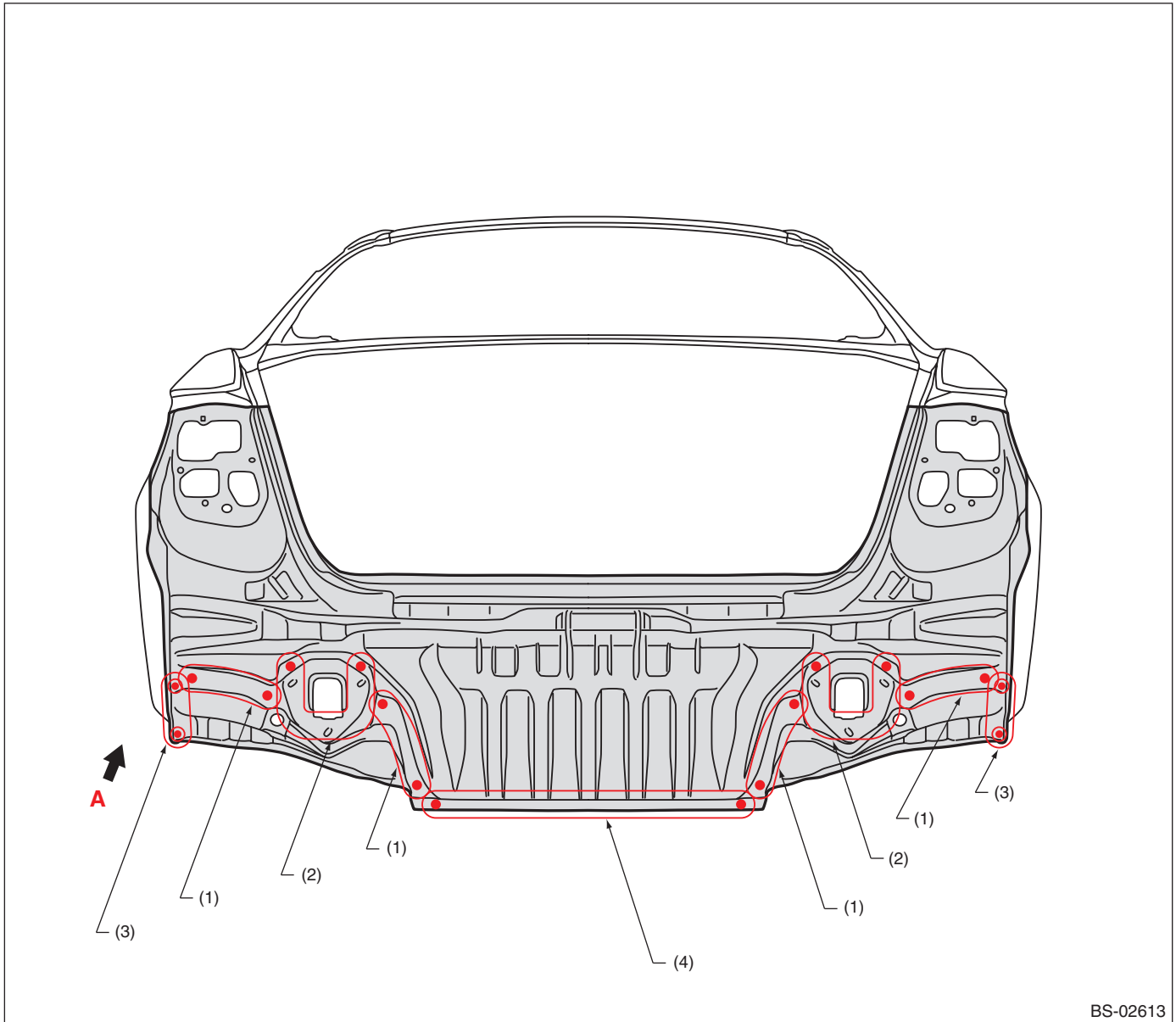
(2) 7 points (outside · 1)

(3) 4 points (outside · 1)

Rear Skirt (total replacement)/4 door

B: INSTALLATION

- Overall view



BS-02613

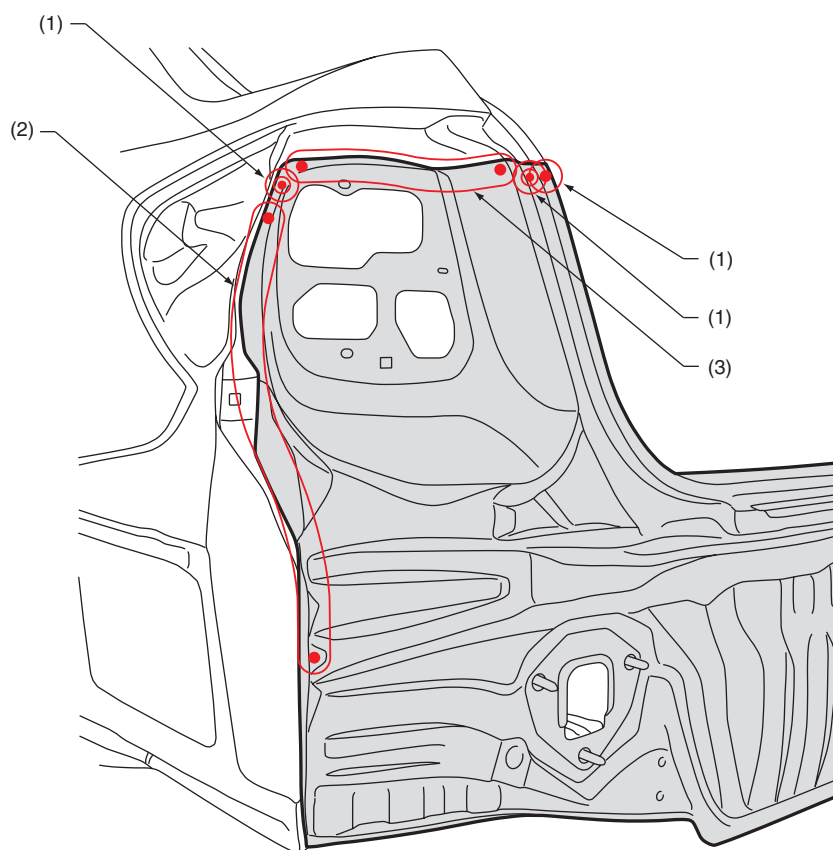
(1) 5 points
(2) 4 points

(3) 3 points

(4) 11 points

Rear Skirt (total replacement)/4 door

- Views



A

BS-02614

(1) 1 point

(2) 8 points

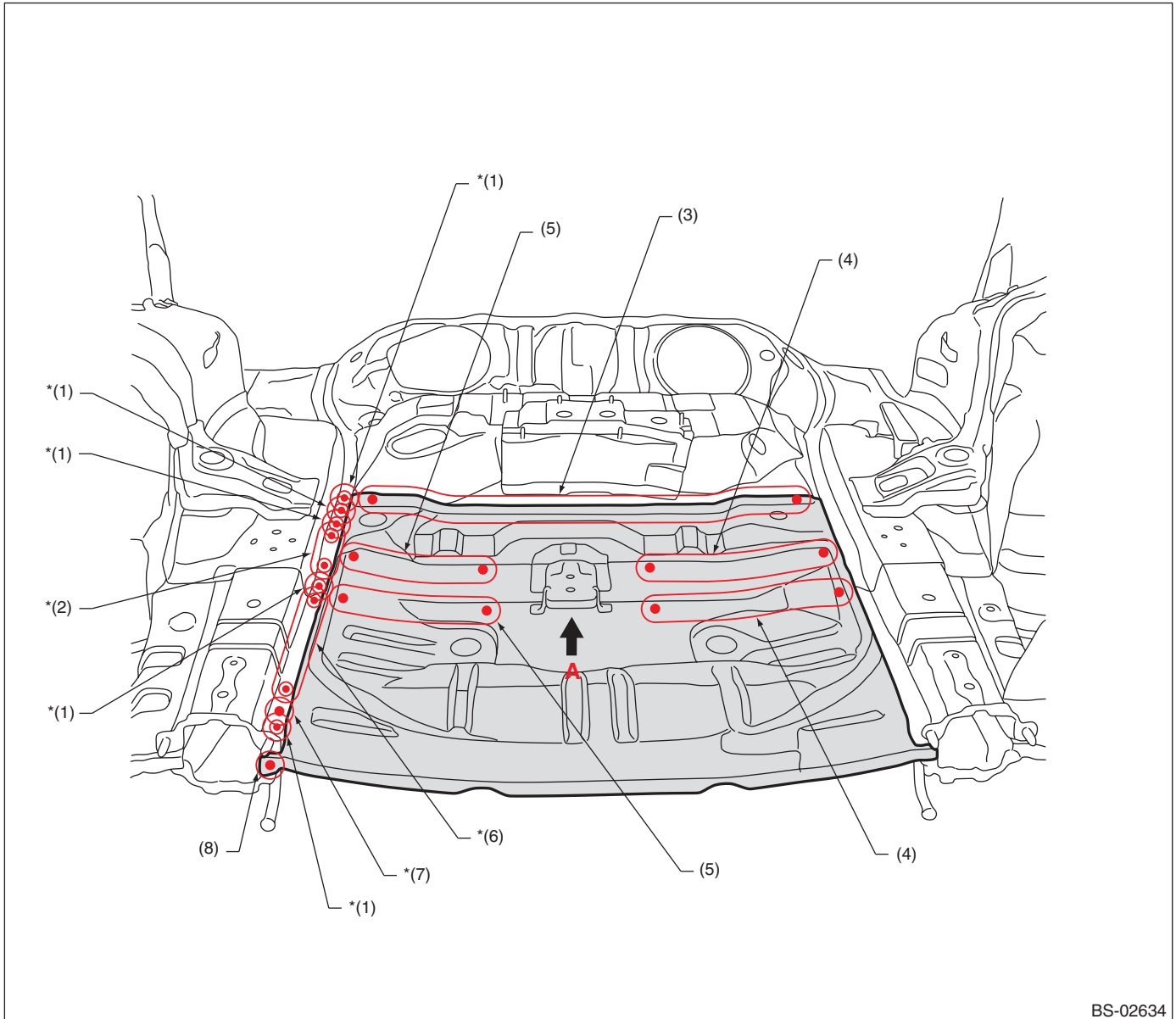
(3) 5 points

29.Rear Floor Pan (total replacement)/5 door

A: REMOVAL

1) Rear skirt and rear floor side frame upper rear removal condition

• Overall view



BS-02634

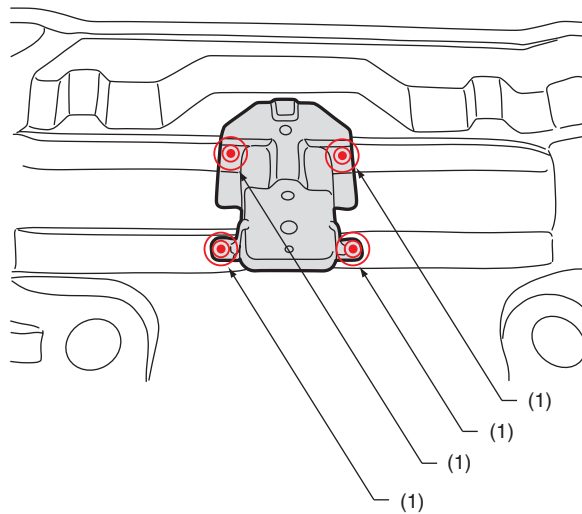
- (1) 1 point (top - 2)
- (2) 3 points (top - 2)
- (3) 12 points (top - 1)

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

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

Rear Floor Pan (total replacement)/5 door

- Views



A

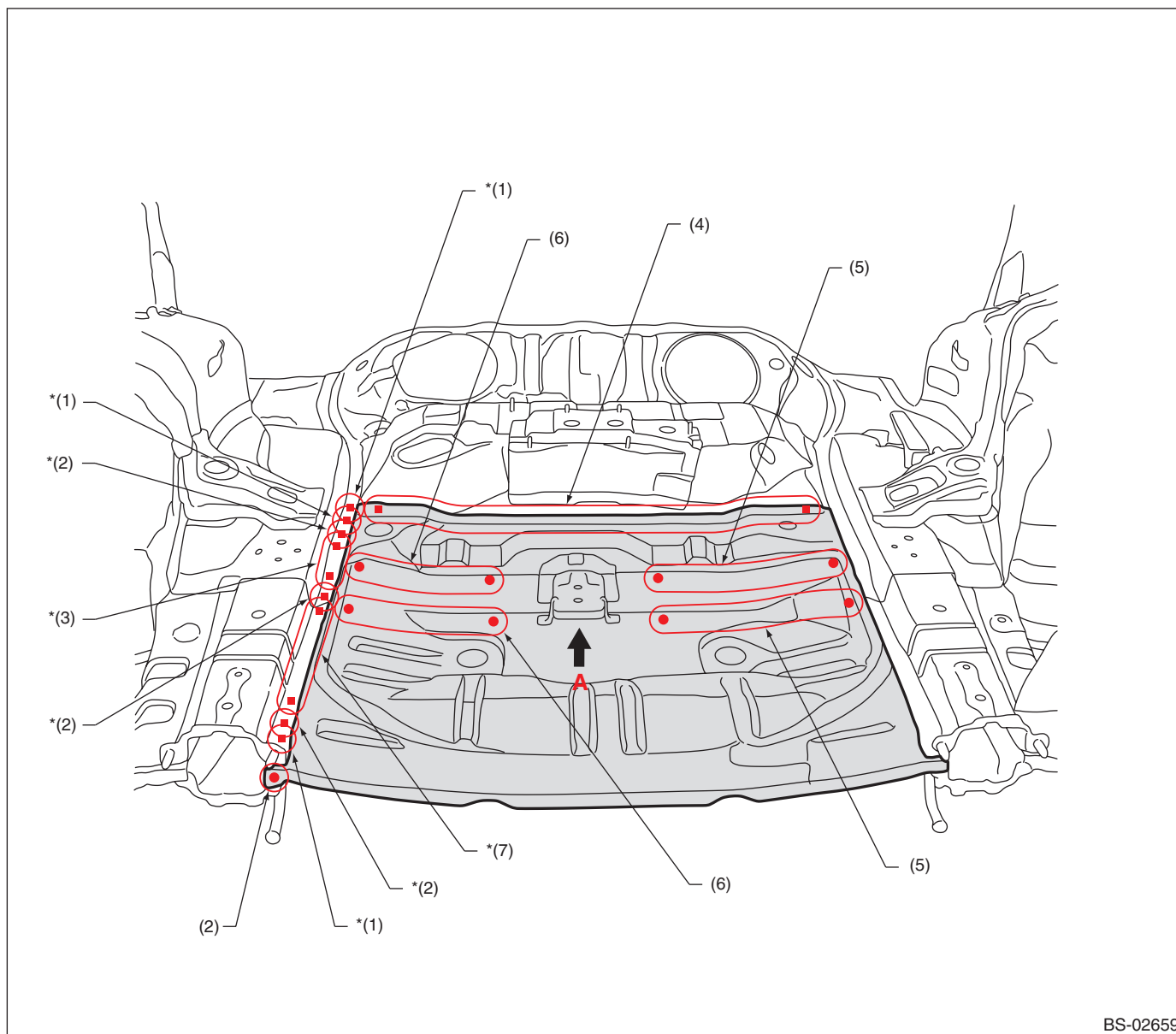
BS-02409

(1) 1 point (top · 2)

Rear Floor Pan (total replacement)/5 door

B: INSTALLATION

• Overall view



BS-02659

(1) 1 point (service · matching)

(2) 1 point

(3) 3 points (service · matching)

(4) 12 points

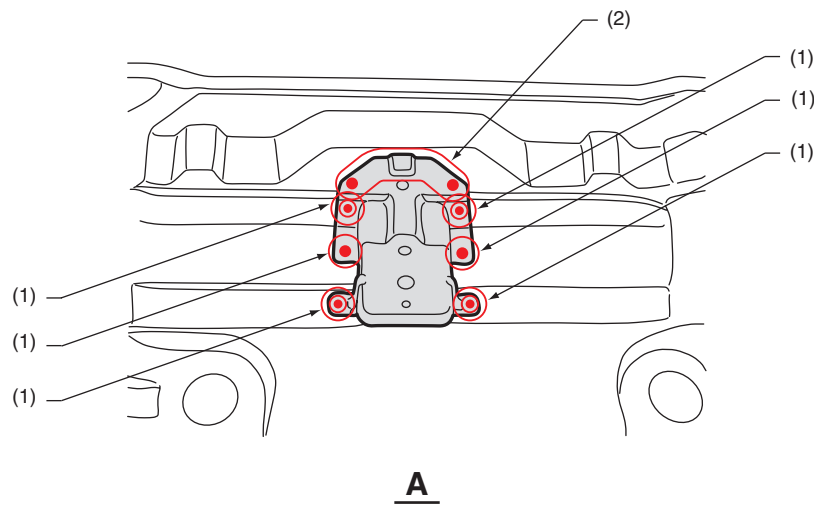
(5) 6 points

(6) 5 points

(7) 6 points (service · matching)

Rear Floor Pan (total replacement)/5 door

- Views



BS-02411

(1) 1 point

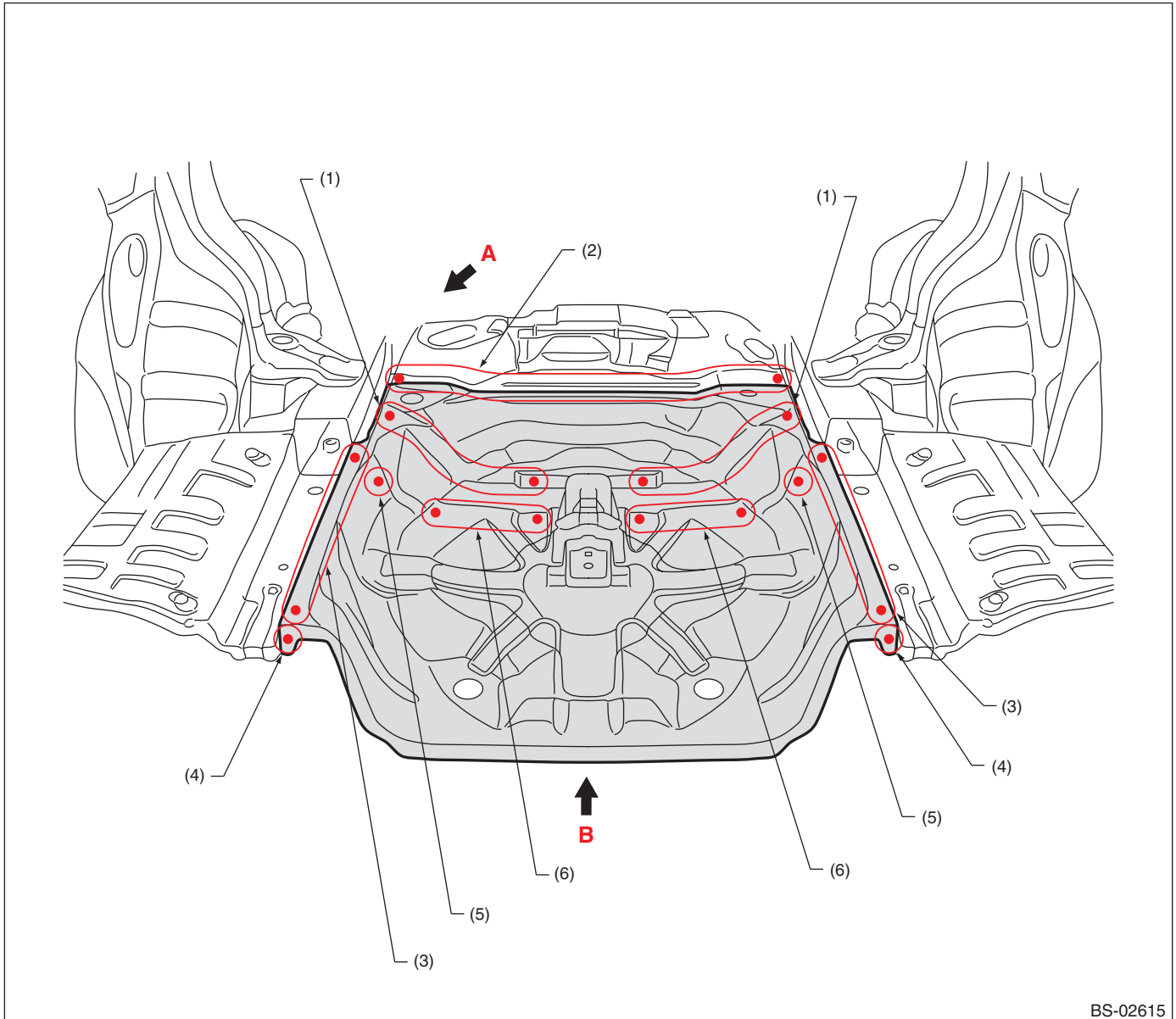
(2) 4 points

30.Rear Floor Pan (total replacement)/4 door

A: REMOVAL

1) Rear skirt and rear side frame upper removal condition

• Overall view



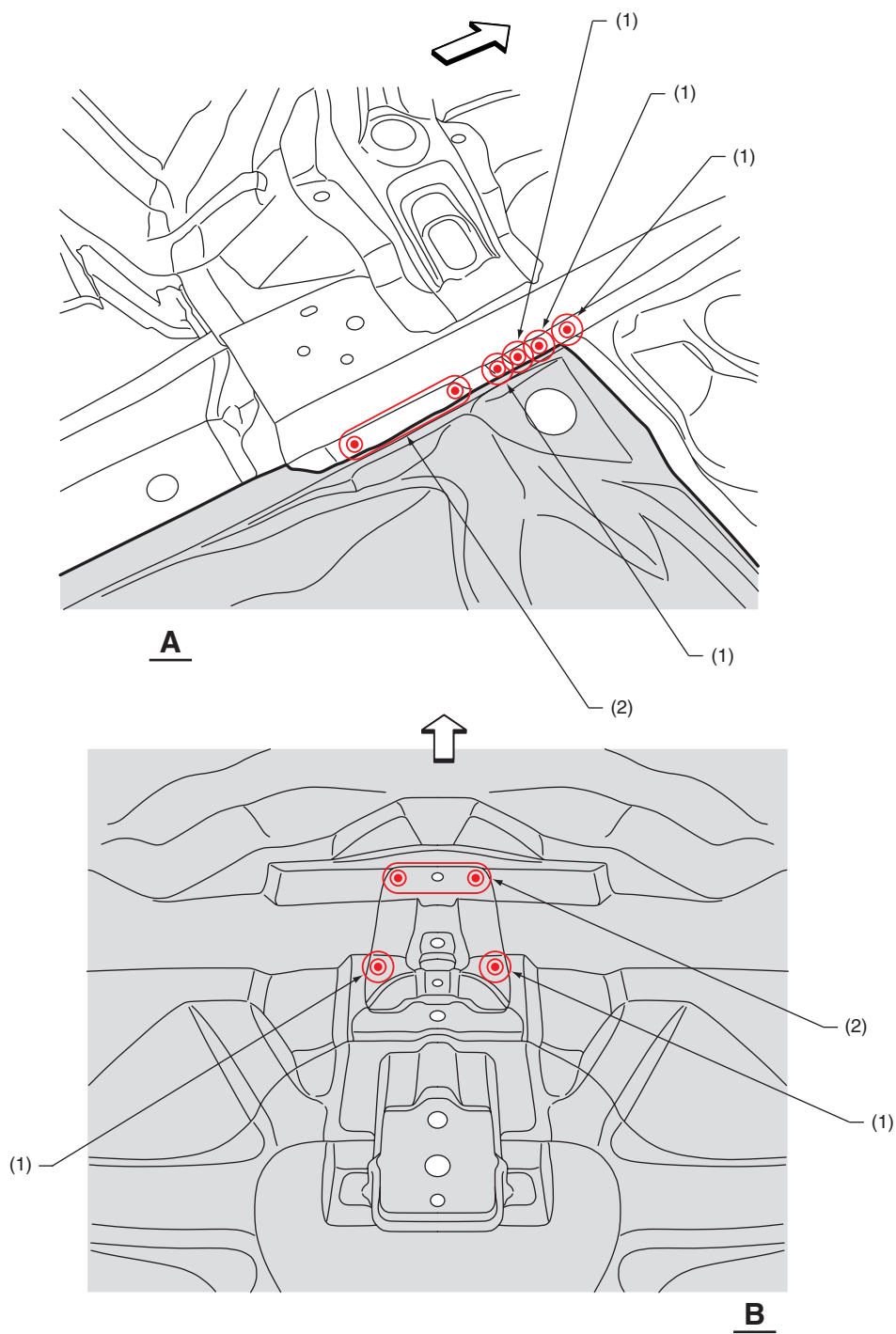
(1) 6 points (top · 1)
(2) 12 points (top · 1)

(3) 9 points (top · 1)
(4) 1 point (outside · 1)

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

Rear Floor Pan (total replacement)/4 door

- Views



BS-02616

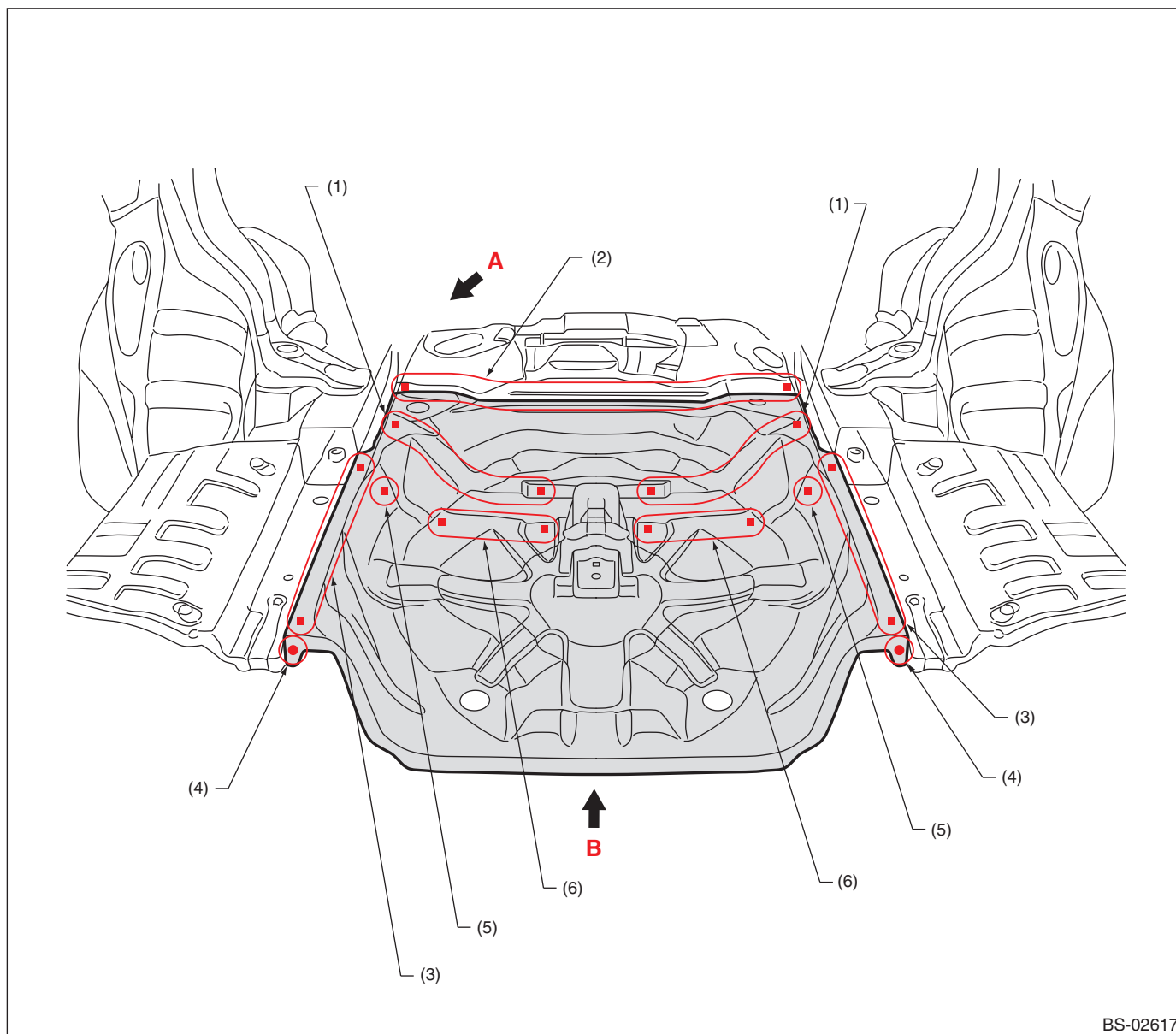
(1) 1 point (top · 2)

(2) 2 points (top · 2)

Rear Floor Pan (total replacement)/4 door

B: INSTALLATION

- Overall view



BS-02617

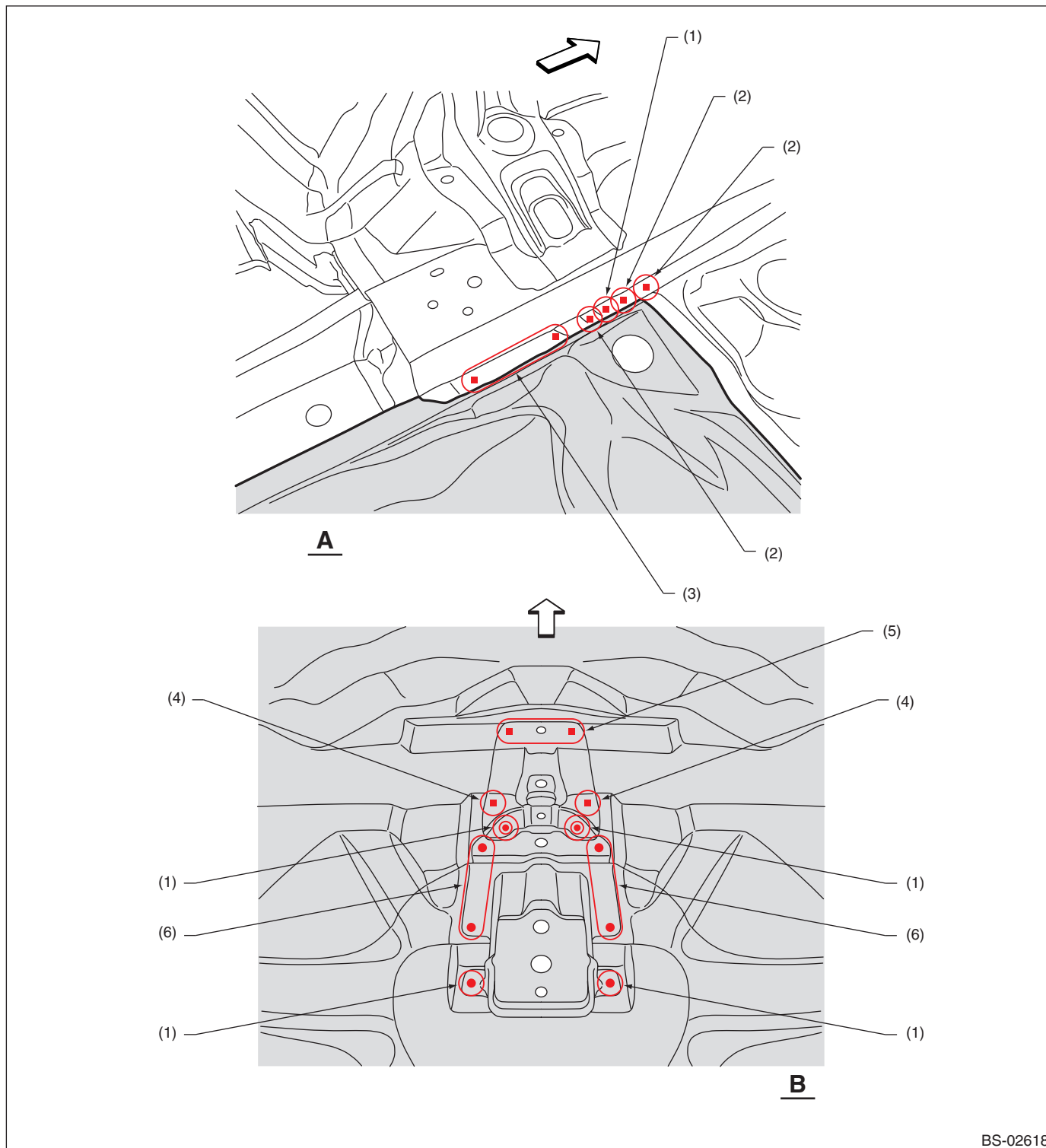
(1) 6 points (service)
(2) 12 points (service)

(3) 9 points (service)
(4) 1 point

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

Rear Floor Pan (total replacement)/4 door

• Views



BS-02618

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

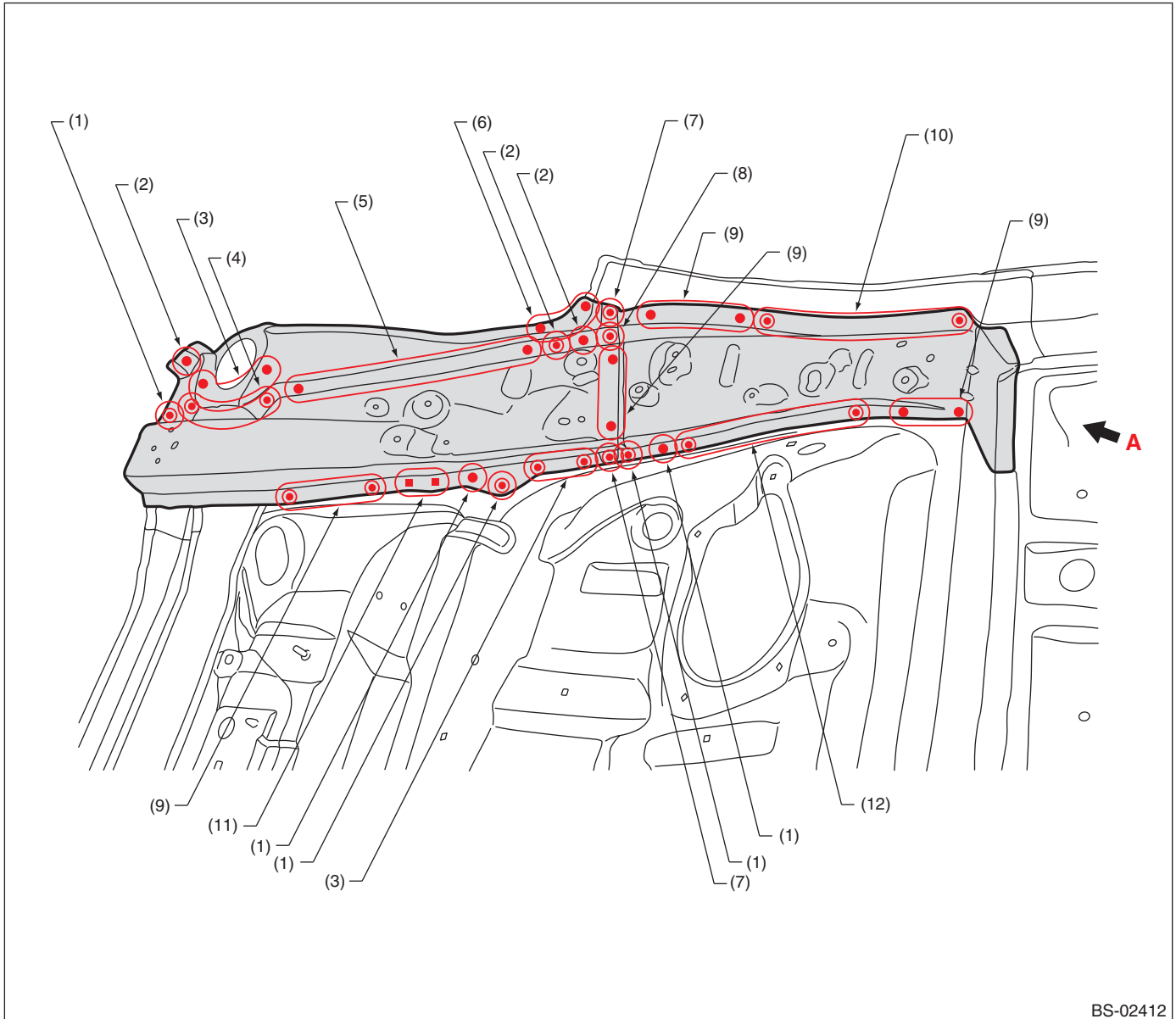
Closing Plate (total replacement)

31.Closing Plate (total replacement)

A: REMOVAL

1) Rear skirt, rear floor pan, rear quarter, rear quarter inner removal condition

• Overall view

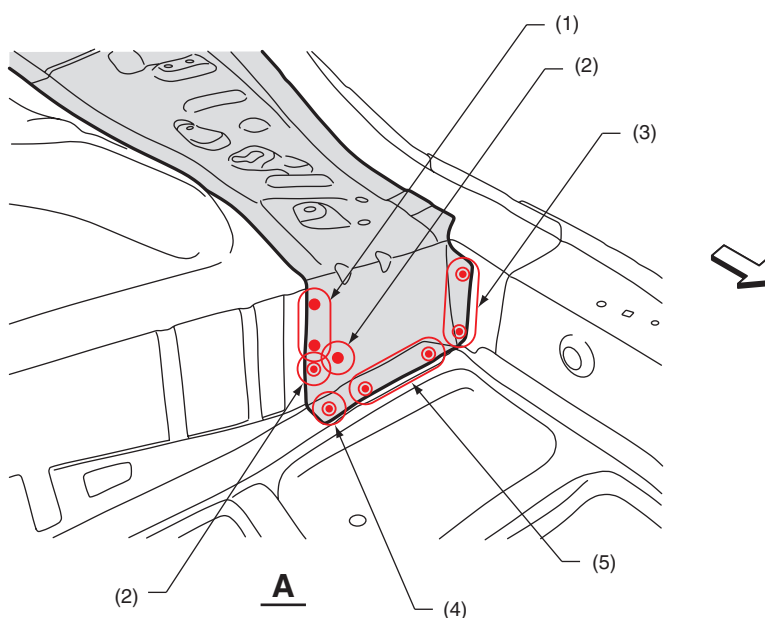


BS-02412

- | | | |
|---------------------------|---------------------------|--------------------------------------|
| (1) 1 point (top · 1) | (5) 6 points (inside · 1) | (9) 3 points (top · 1) |
| (2) 1 point (inside · 1) | (6) 2 points (inside · 1) | (10) 5 points (top · 1) |
| (3) 2 points (top · 1) | (7) 1 point (top · 2) | (11) 2 points (top · 1, belt sander) |
| (4) 3 points (inside · 1) | (8) 1 point (inside · 2) | (12) 4 points (top · 1) |

Closing Plate (total replacement)

- Views



BS-02413

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

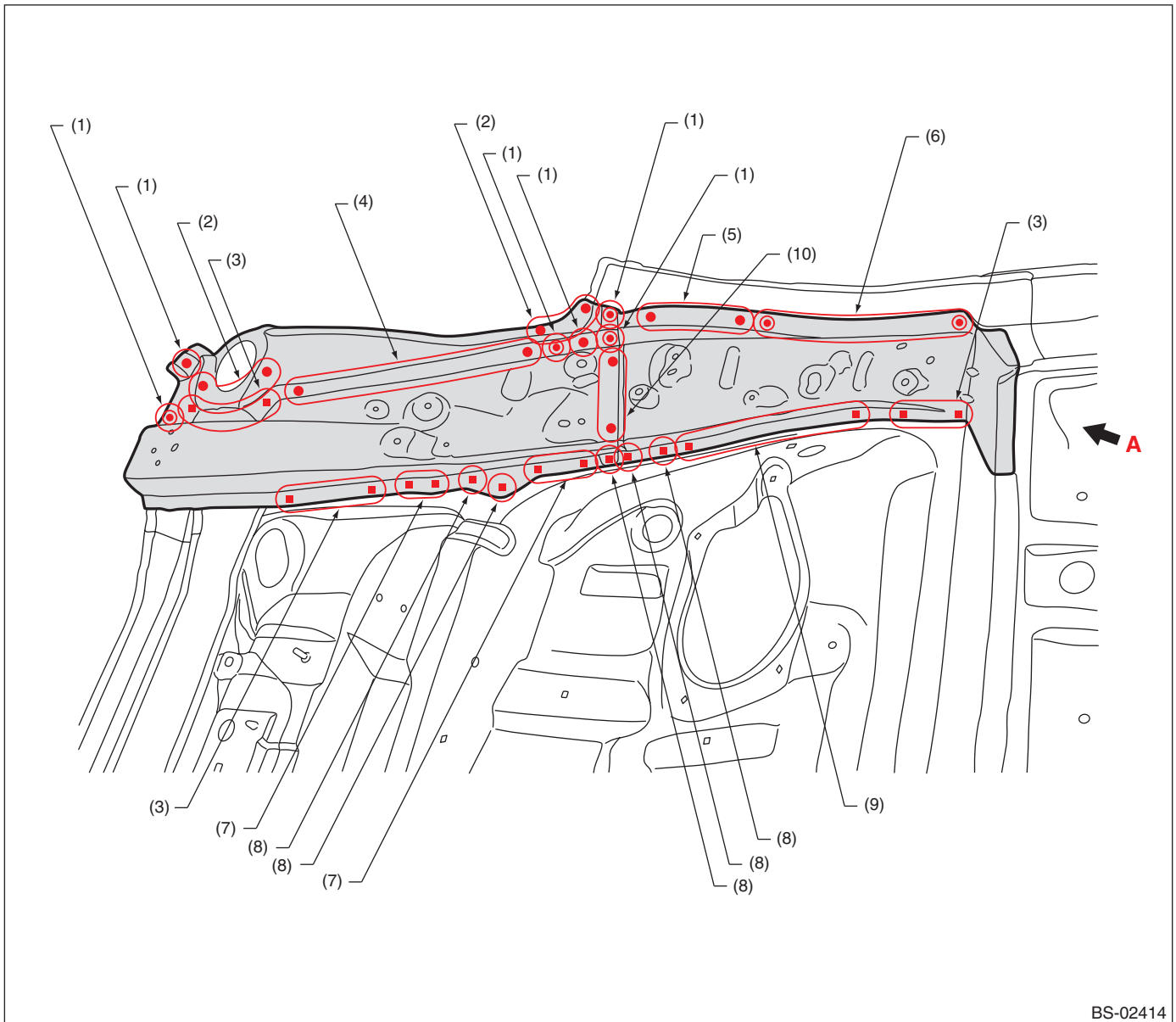
(3) 3 points (inside · 1)
(4) 1 point (top · 1)

(5) 3 points (top · 1)

Closing Plate (total replacement)

B: INSTALLATION

• Overall view

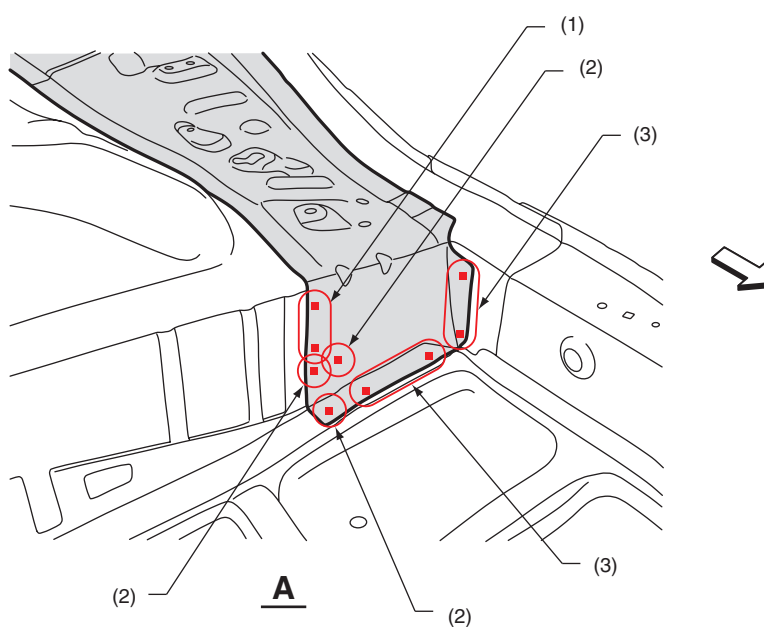


BS-02414

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

Closing Plate (total replacement)

- Views



BS-02415

(1) 2 points (service)

(2) 1 point (service)

(3) 3 points (service)

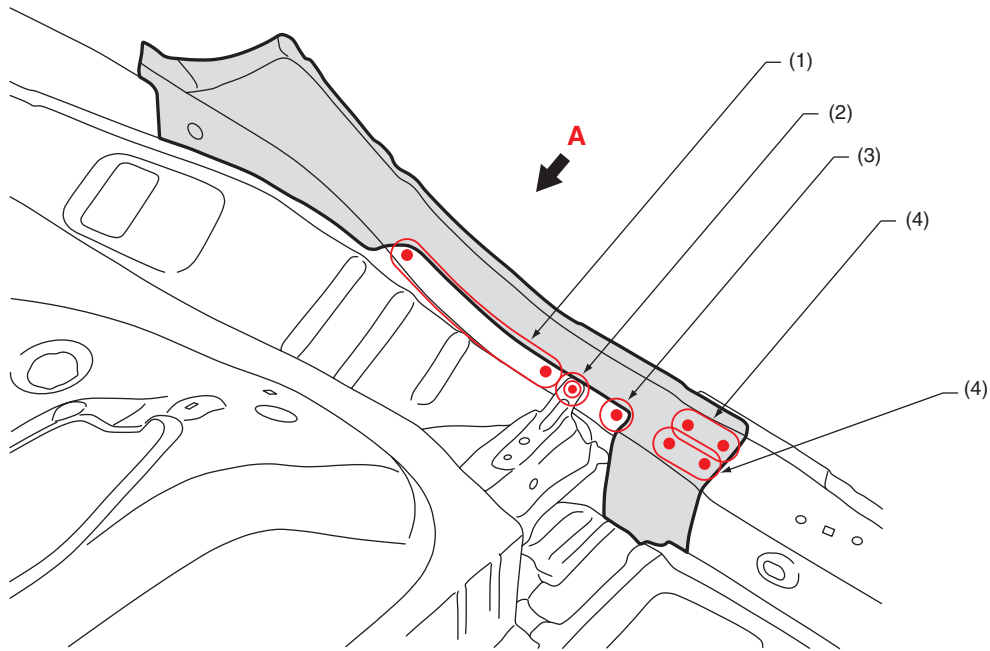
Side Sill Inner Rear (total replacement)

32.Side Sill Inner Rear (total replacement)

A: REMOVAL

1) Rear quarter, rear quarter inner, closing plate, side sill reinforcement outer & inner removal condition

• Overall view



BS-02416

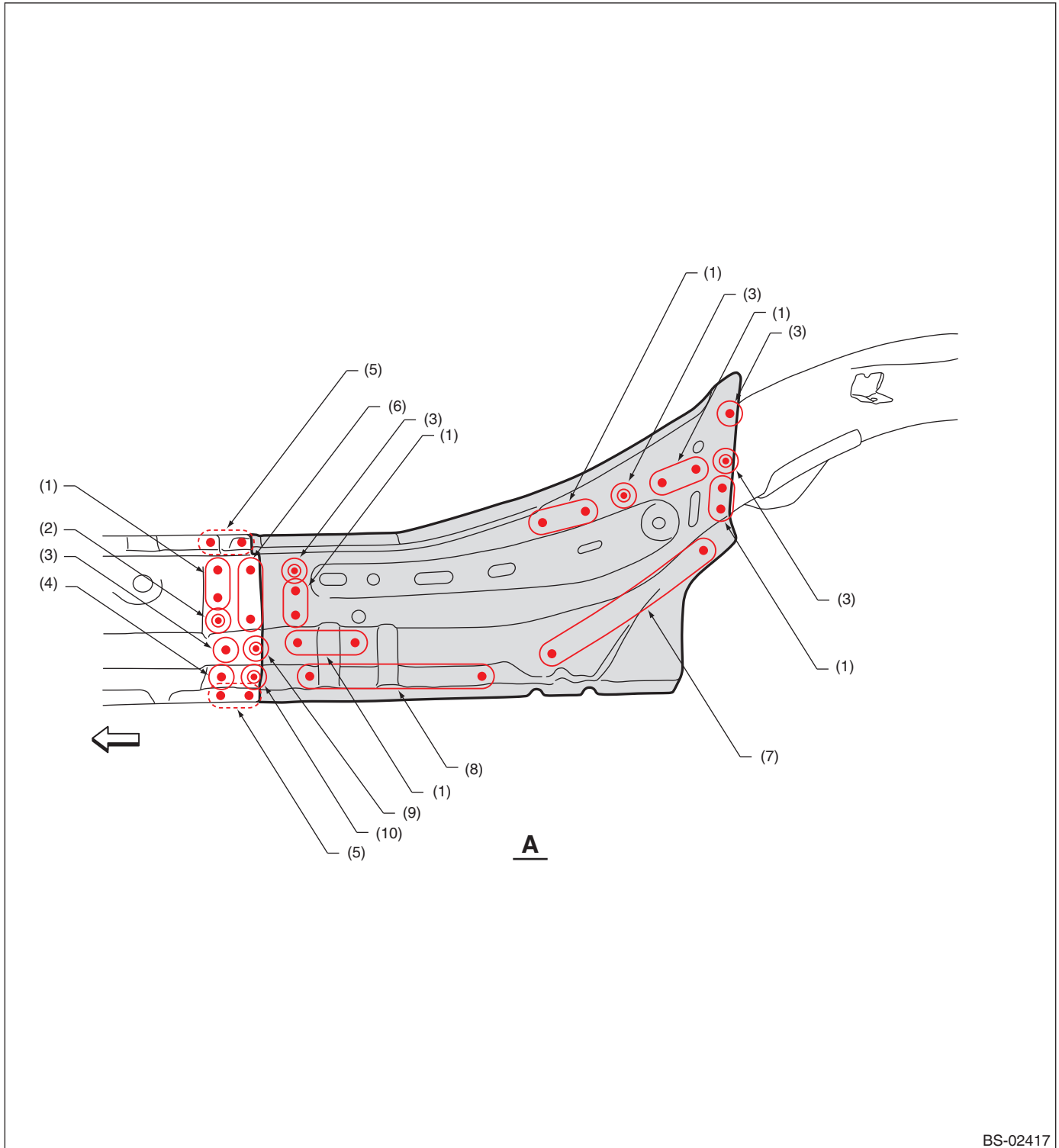
(1) 4 points (top · 1)
(2) 1 point (top · 2)

(3) 1 point (top · 1)

(4) 2 points (top · 1)

Side Sill Inner Rear (total replacement)

• Views



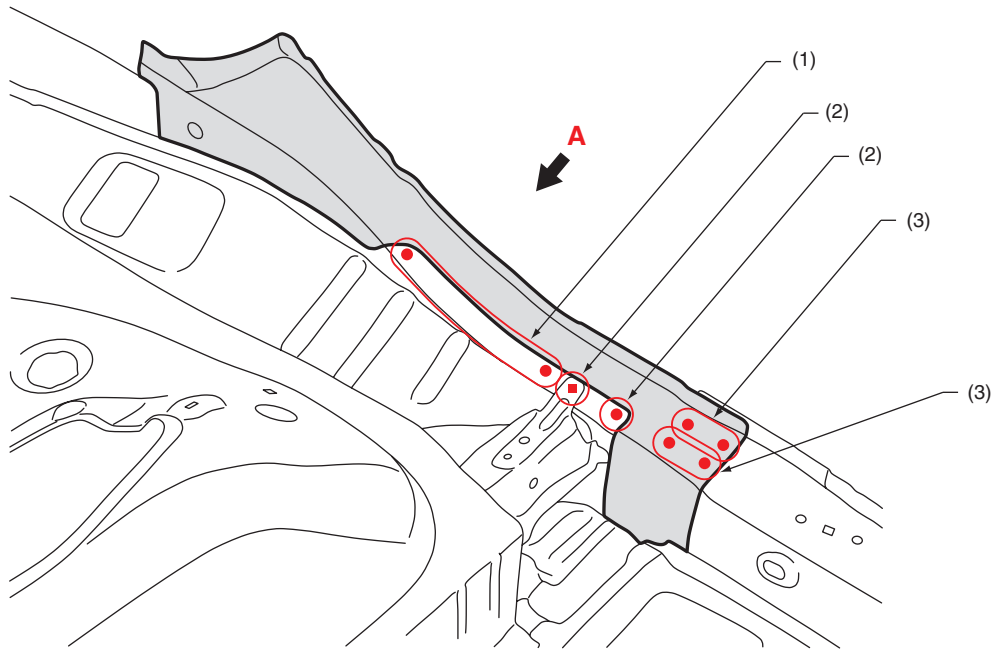
BS-02417

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

Side Sill Inner Rear (total replacement)

B: INSTALLATION

- Overall view



BS-02418

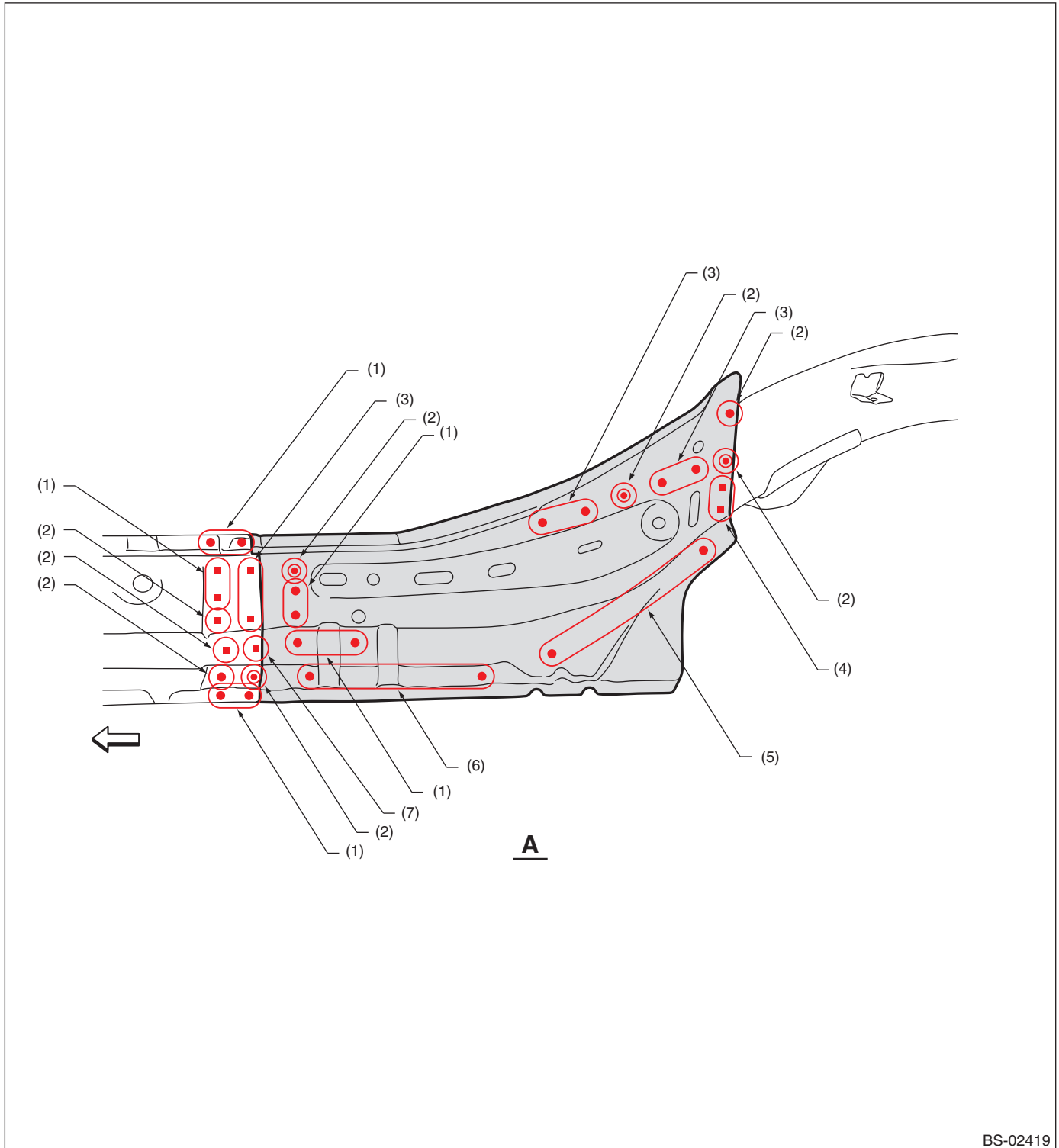
(1) 5 points

(2) 1 point

(3) 2 points

Side Sill Inner Rear (total replacement)

• Views



BS-02419

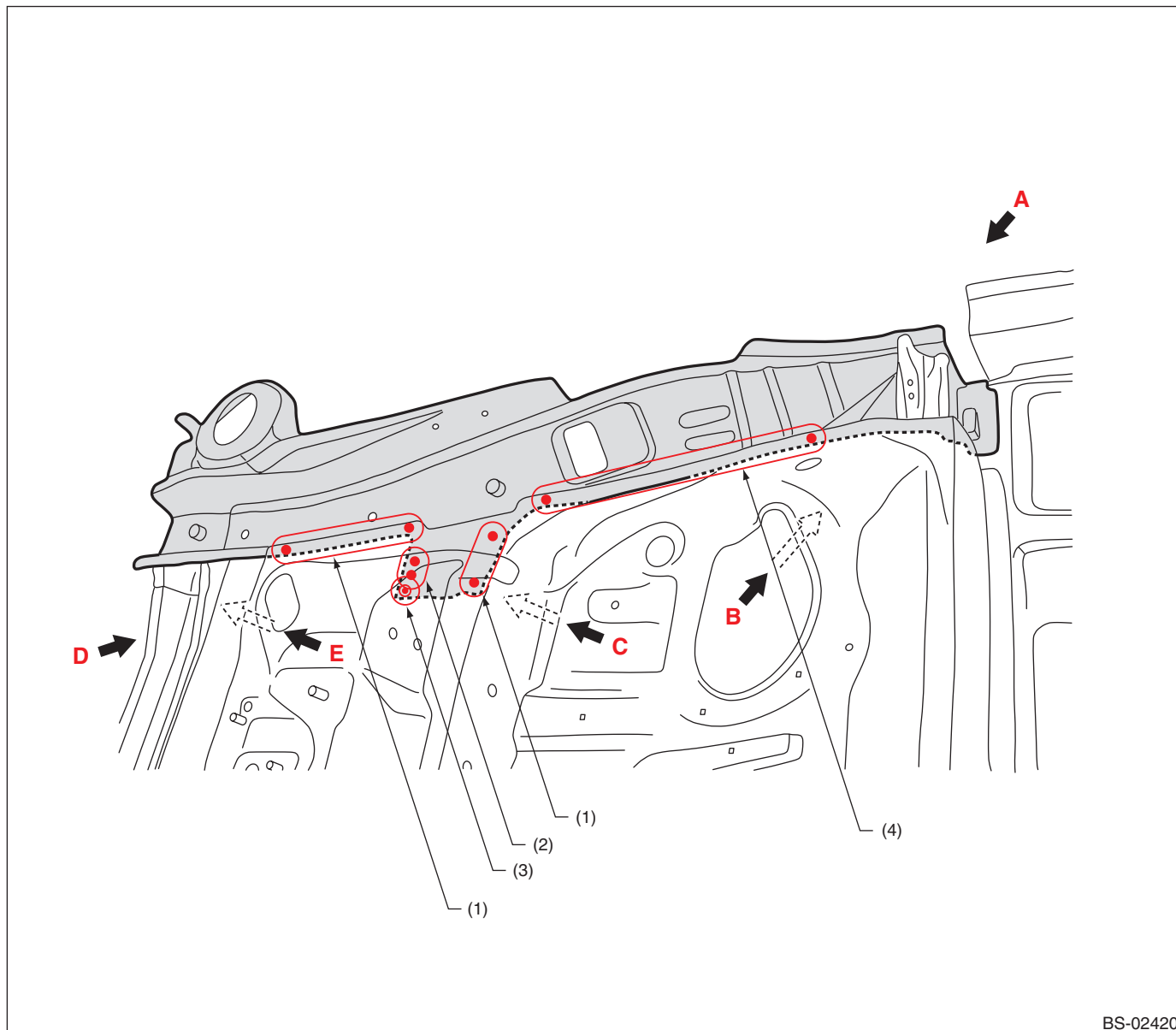
- | | | |
|--------------|------------------------|----------------------------------|
| (1) 2 points | (4) 2 points (service) | (7) 1 point (service · matching) |
| (2) 1 point | (5) 6 points | |
| (3) 3 points | (6) 4 points | |

33.Rear Frame (total replacement)

A: REMOVAL

1) Rear quarter, rear floor pan, rear floor side frame (upper, lower), side sill reinforcement outer & inner removal condition

• Overall view



BS-02420

(1) 3 points (top · 1)

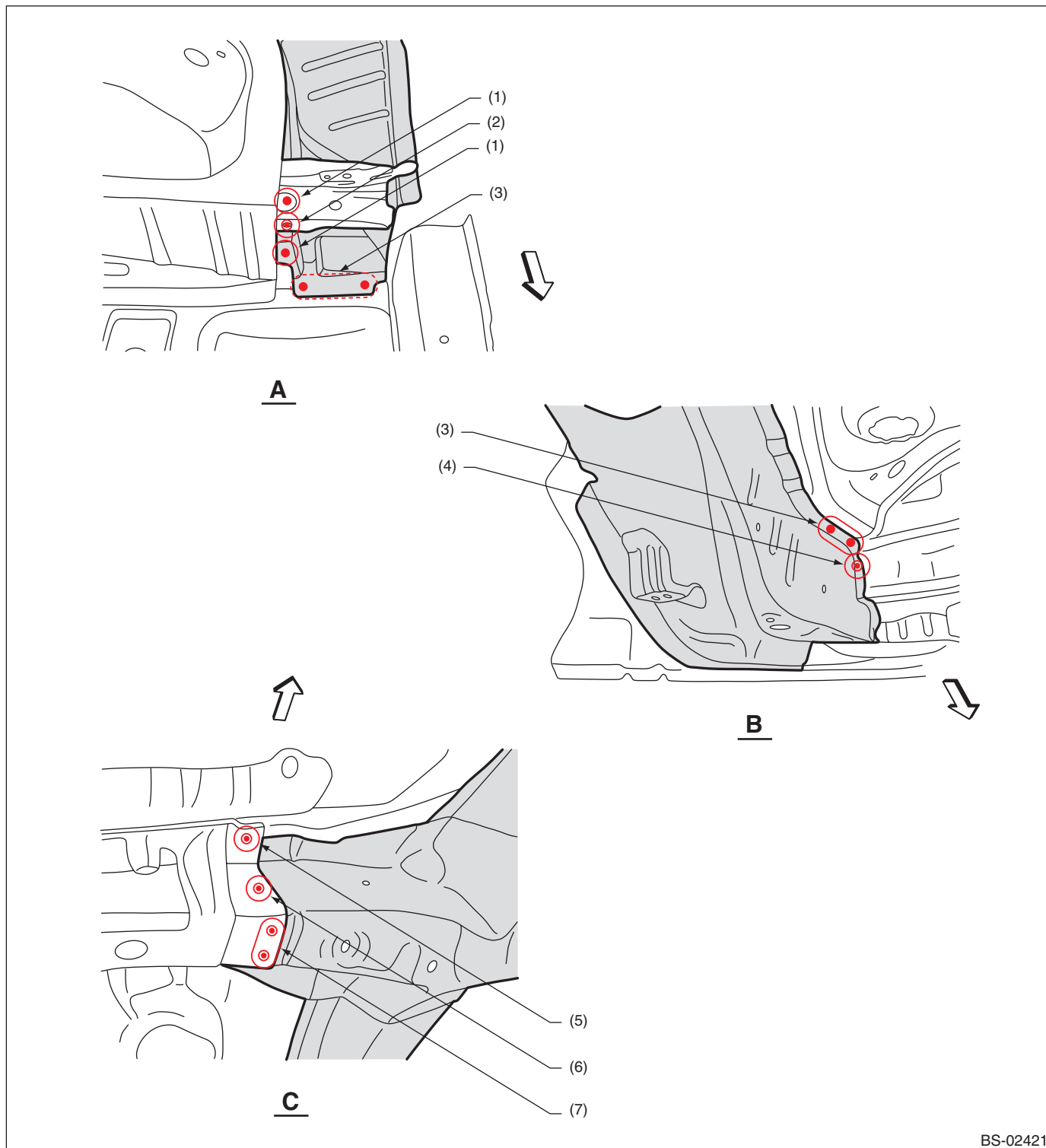
(2) 2 points (top · 1)

(3) 1 point (top · 2)

(4) 7 points (top · 1)

Rear Frame (total replacement)

• Views 1



BS-02421

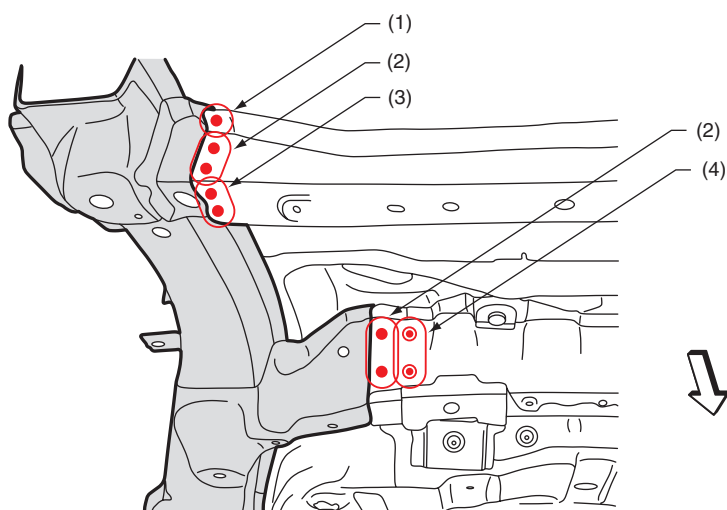
- (1) 1 point (inside · 1)
- (2) 1 point (top · 2)
- (3) 2 points (bottom · 1)

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

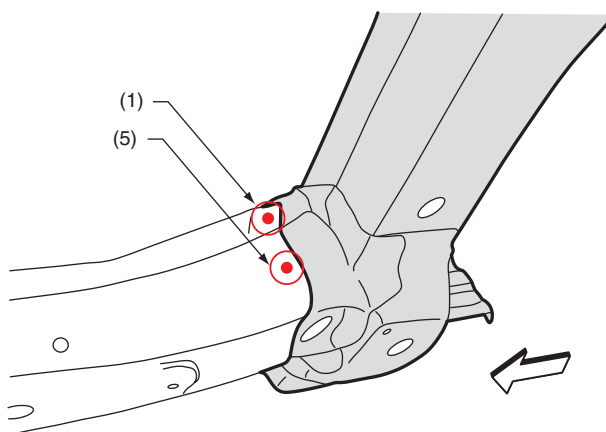
- (7) 2 points (bottom · 2)

Rear Frame (total replacement)

• Views 2



D



E

BS-02422

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

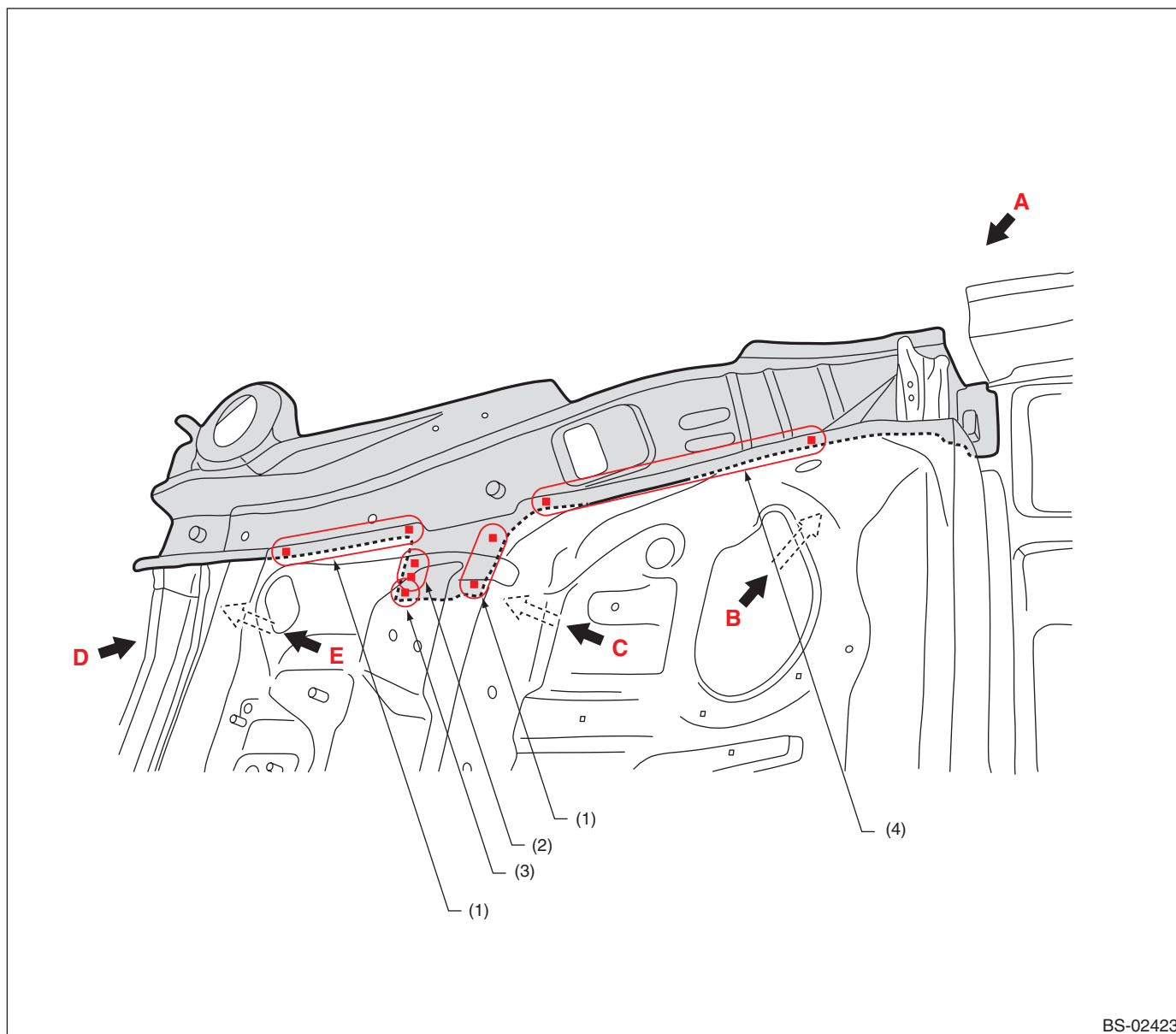
(3) 2 points (bottom · 1)
(4) 2 points (outside · 2)

(5) 1 point (inside · 1)

Rear Frame (total replacement)

B: INSTALLATION

- Overall view



BS-02423

(1) 3 points

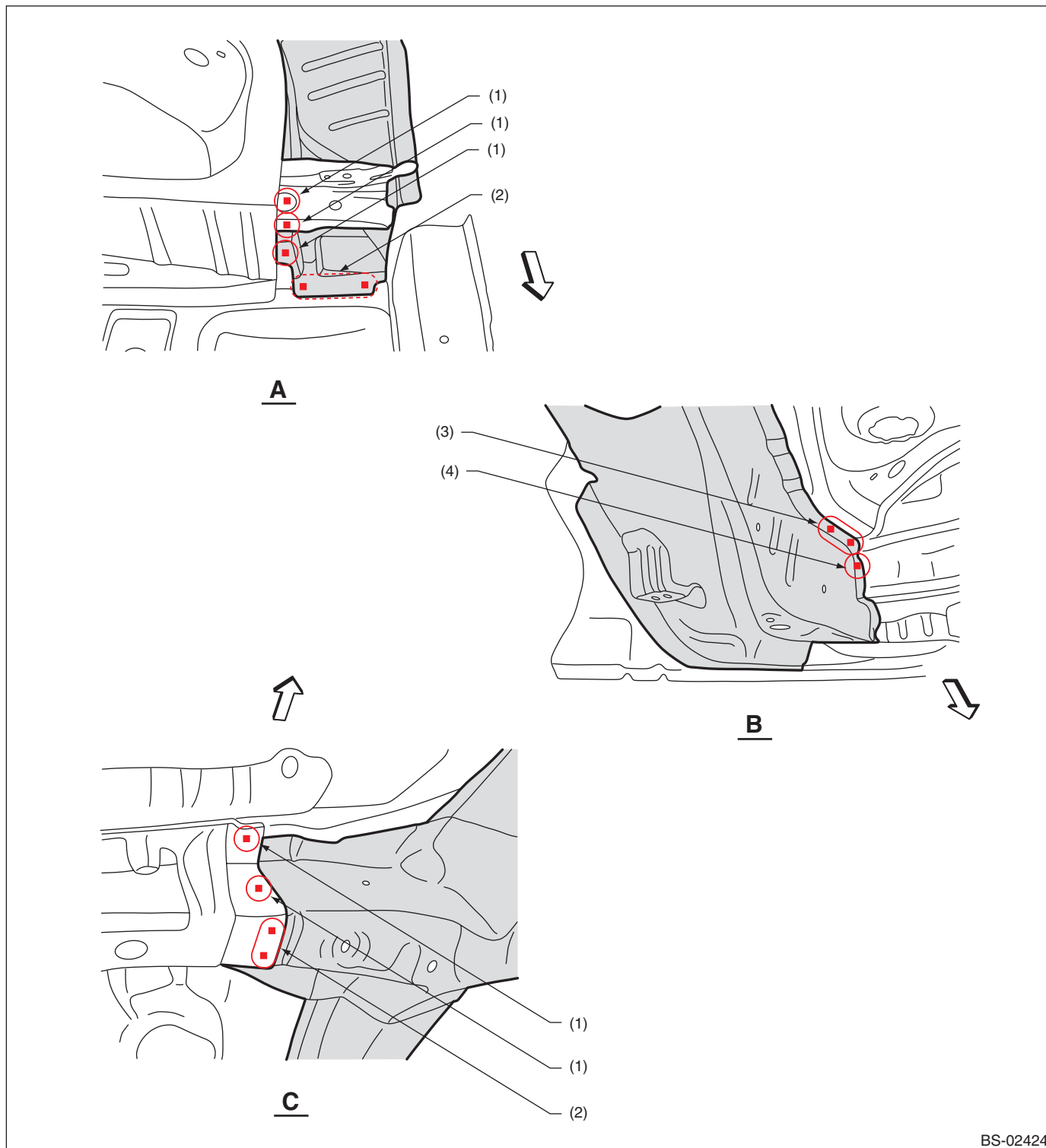
(2) 2 points

(3) 1 point (service · matching)

(4) 7 points

Rear Frame (total replacement)

• Views 1



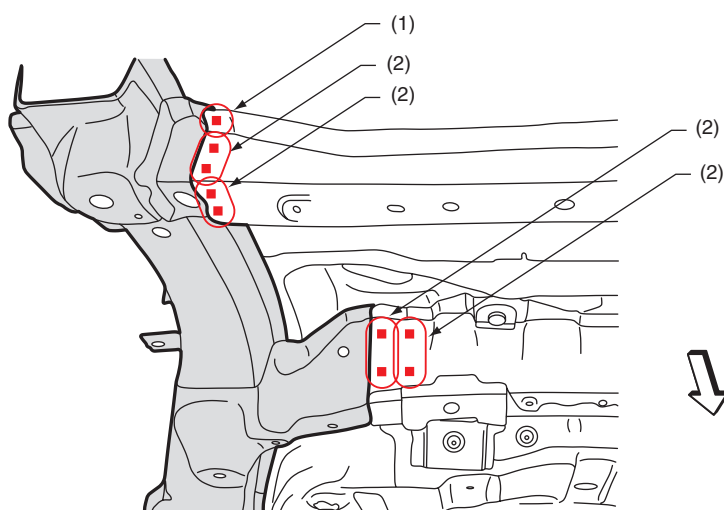
- (1) 1 point
- (2) 2 points

- (3) 2 points (service)

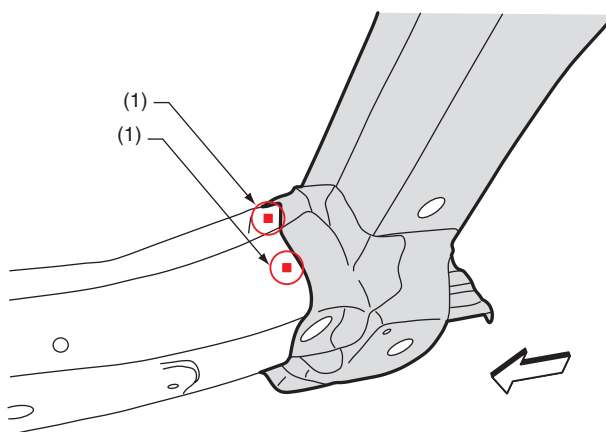
- (4) 1 point (service)

Rear Frame (total replacement)

- Views 2



D



E

BS-02425

(1) 1 point

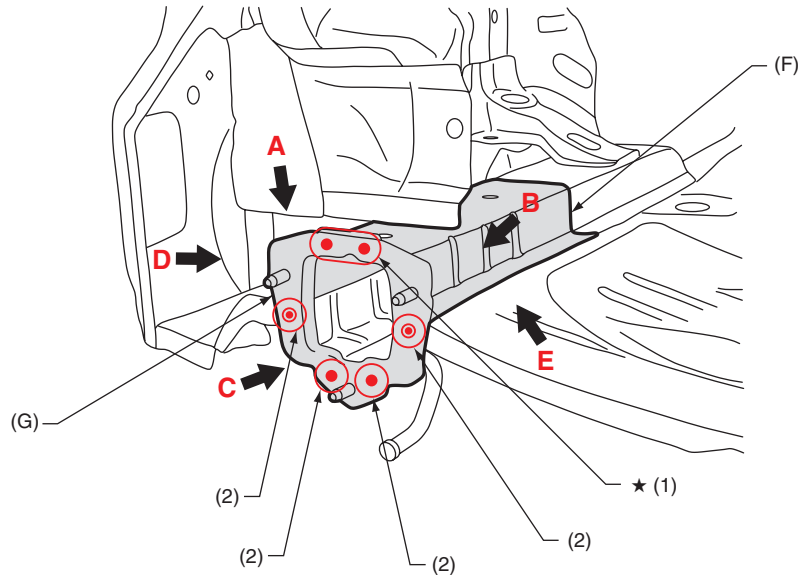
(2) 2 points

34.Rear Side Frame Upper Rear (total replacement)/5 door

A: REMOVAL

1) Rear skirt removal condition

- Overall view



BS-02635

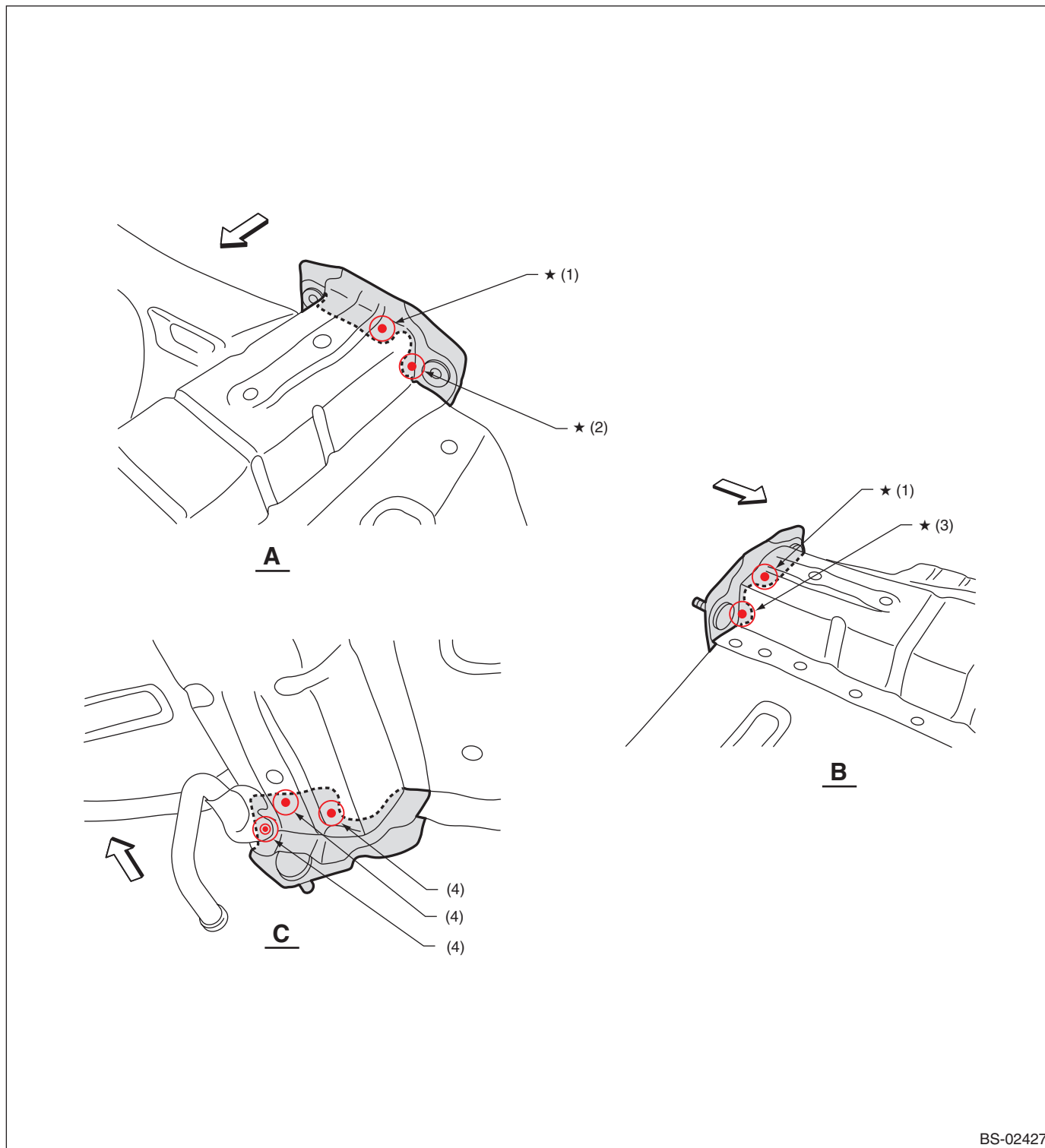
(1) 2 points (outside · 1)

(2) 1 point (outside · 1)

(F) frame side rear upper rear rear and (G) bracket bumper rear are a set as maintenance parts. In case of replacement in maintenance units, removal work at the location marked by ★ is not required. When (G) is replaced alone, removal work at the location marked by ★ is required.

Rear Side Frame Upper Rear (total replacement)/5 door

• Views 1



(1) 1 point (top · 1)

(3) 1 point (inside · 1)

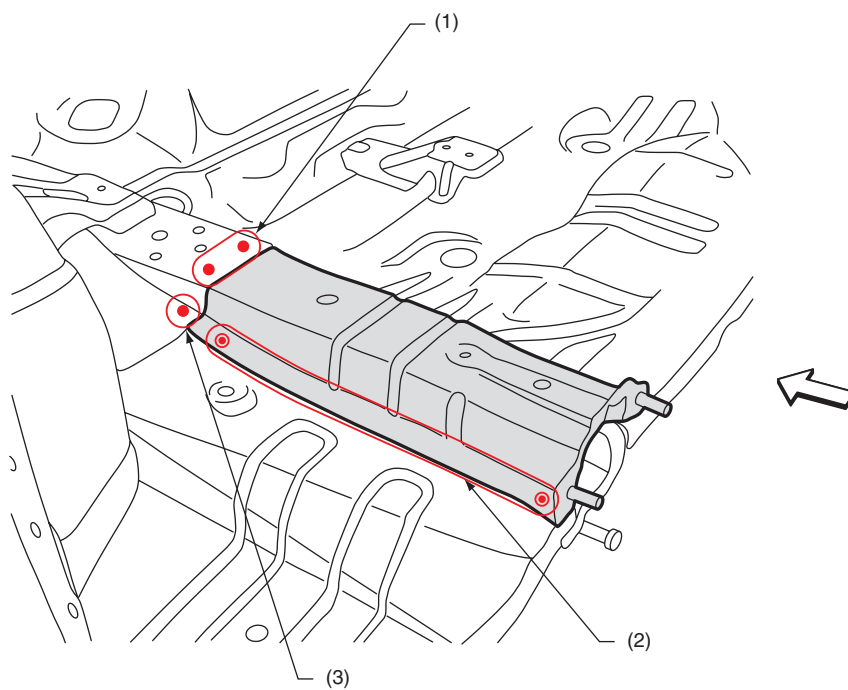
(4) 1 point (bottom · 1)

(2) 1 point (outside · 1)

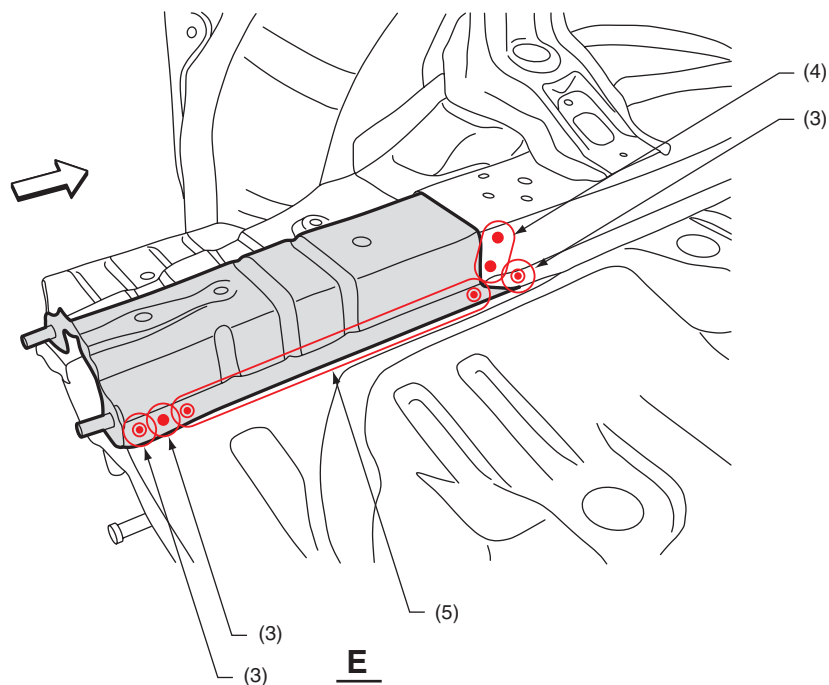
Refer to the preceding page for ★.

Rear Side Frame Upper Rear (total replacement)/5 door

• Views 2



D



E

BS-02428

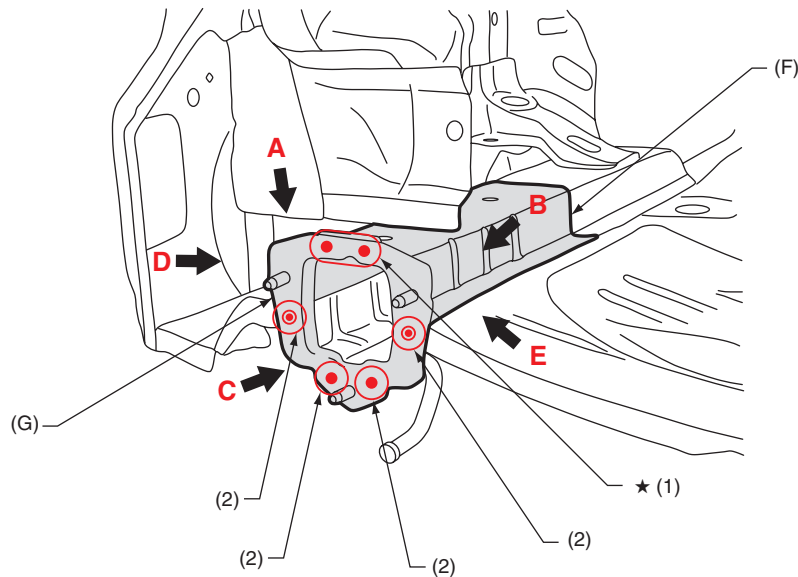
(1) 3 points (top · 1)
(2) 6 points

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

(5) 6 points (top · 1)

B: INSTALLATION

- Overall view



BS-02636

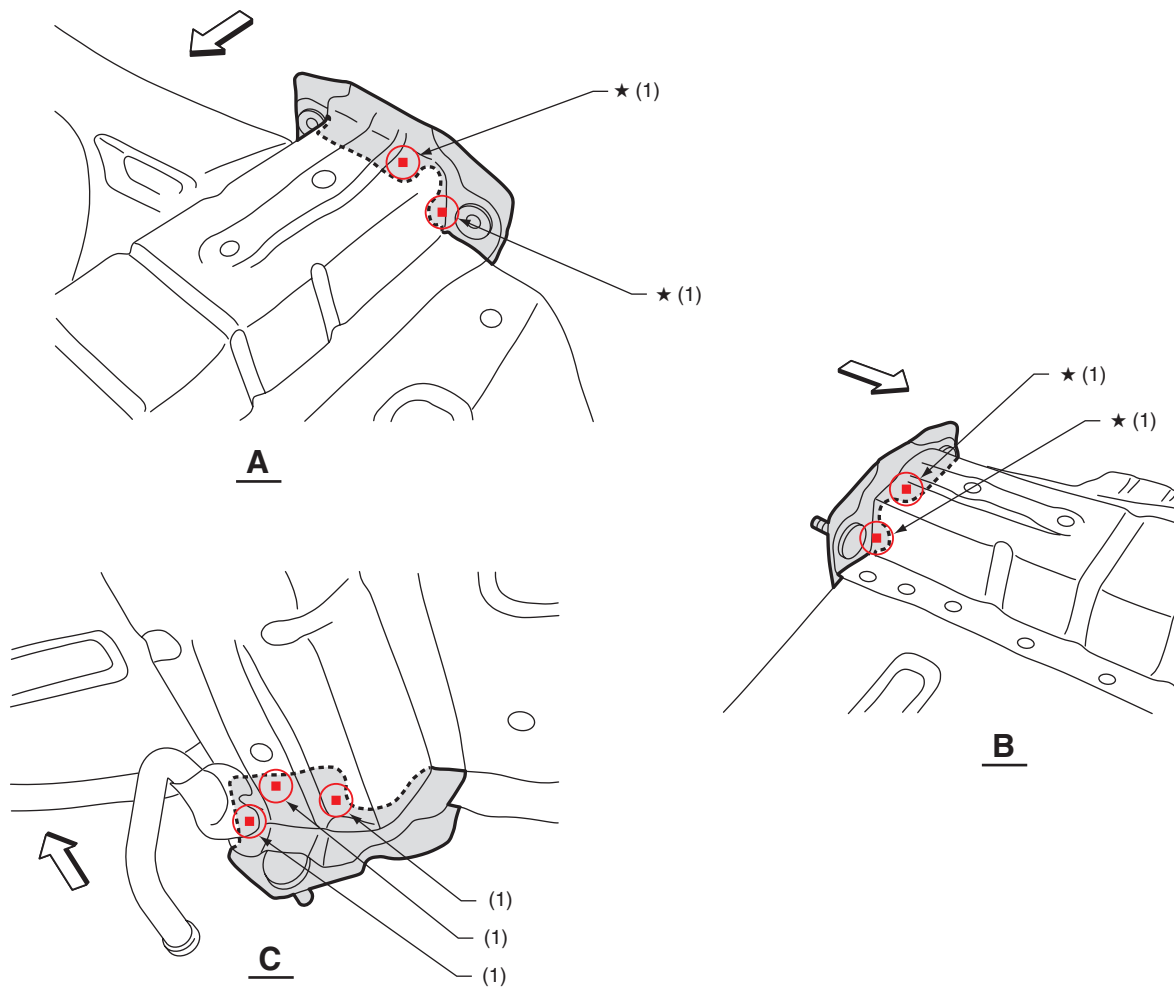
(1) 2 points

(2) 1 point

(F) frame side rear upper rear and (G) bracket bumper rear are a set as maintenance parts. In case of replacement in maintenance units, installation work at the location marked by ★ is not required. When (G) is replaced alone, installation work at the location marked by ★ is required.

Rear Side Frame Upper Rear (total replacement)/5 door

- Views 1



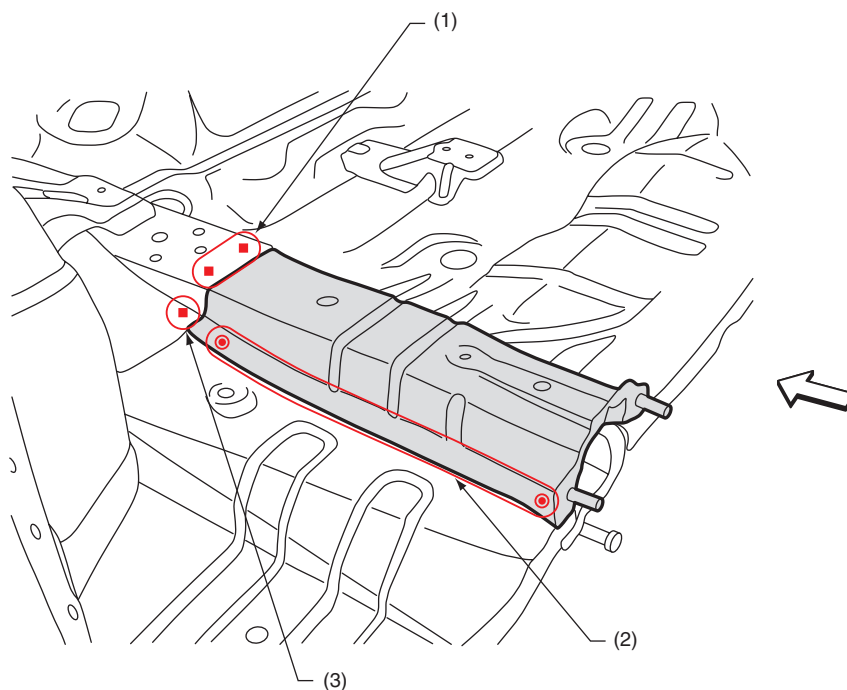
BS-02430

(1) 1 point

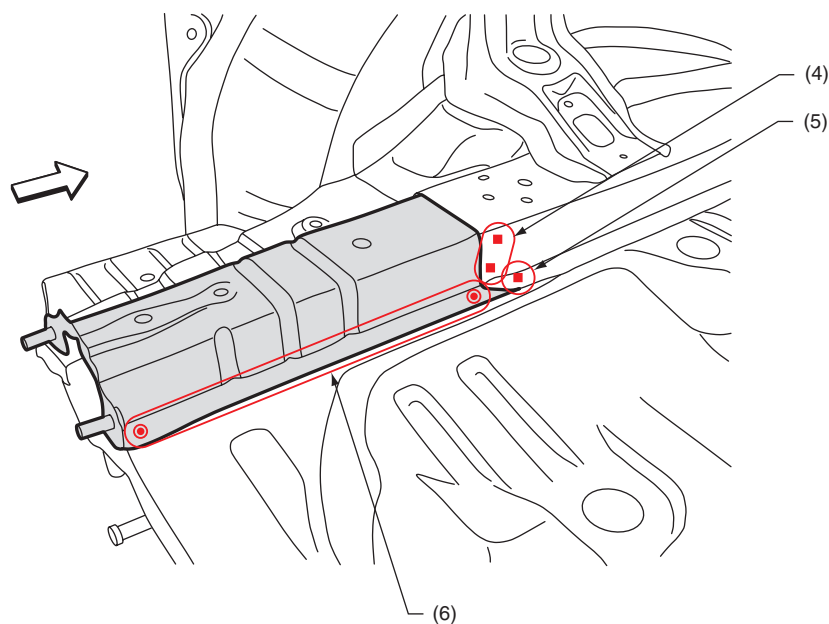
Refer to the preceding page for ★.

Rear Side Frame Upper Rear (total replacement)/5 door

• Views 2



D



E

BS-02461

(1) 3 points
(2) 8 points

(3) 1 point
(4) 2 points

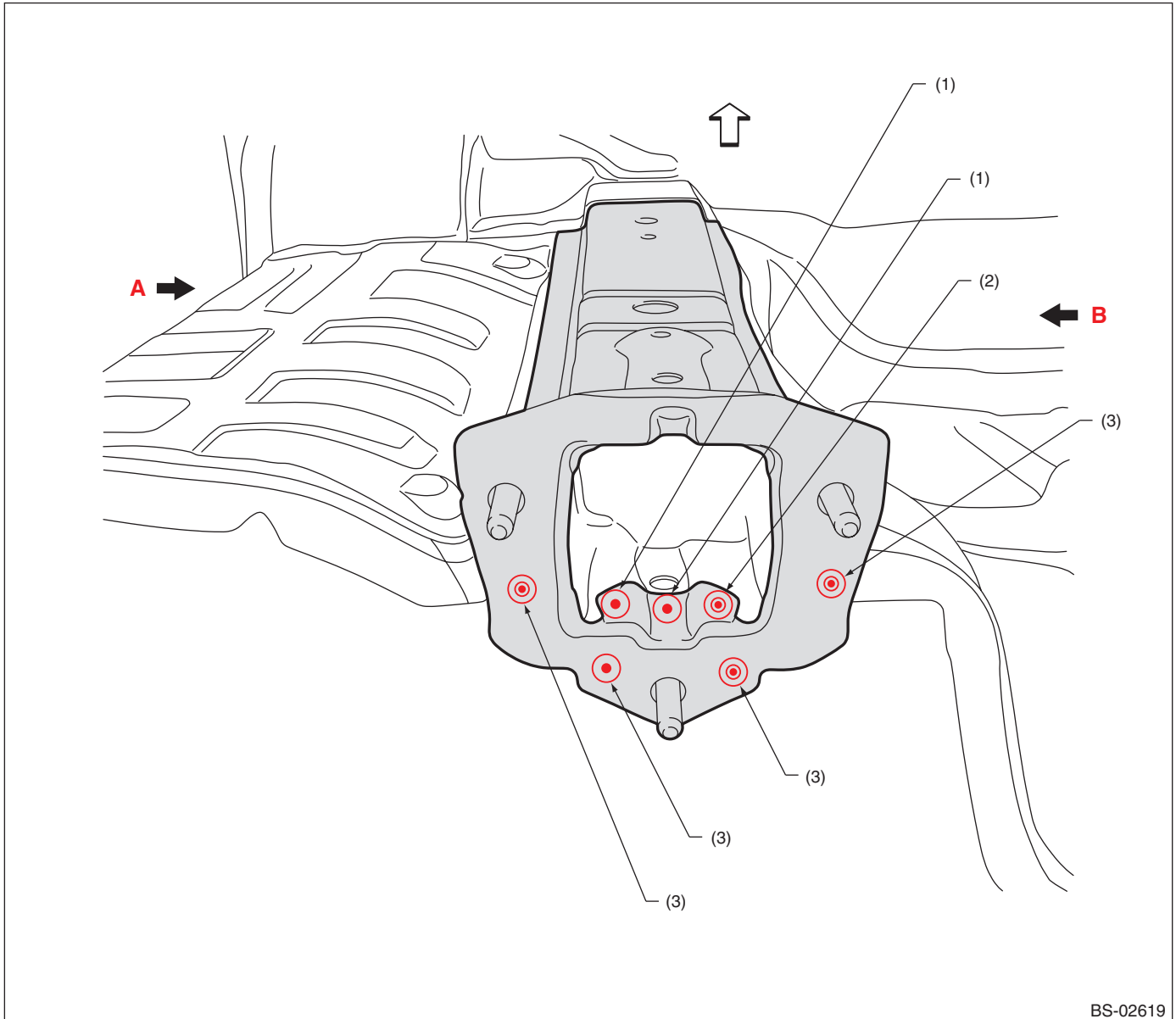
(5) 1 point (service · matching)
(6) 9 points

35.Rear Side Frame Upper Rear (total replacement)/4 door

A: REMOVAL

1) Rear skirt removal condition

- Overall view



BS-02619

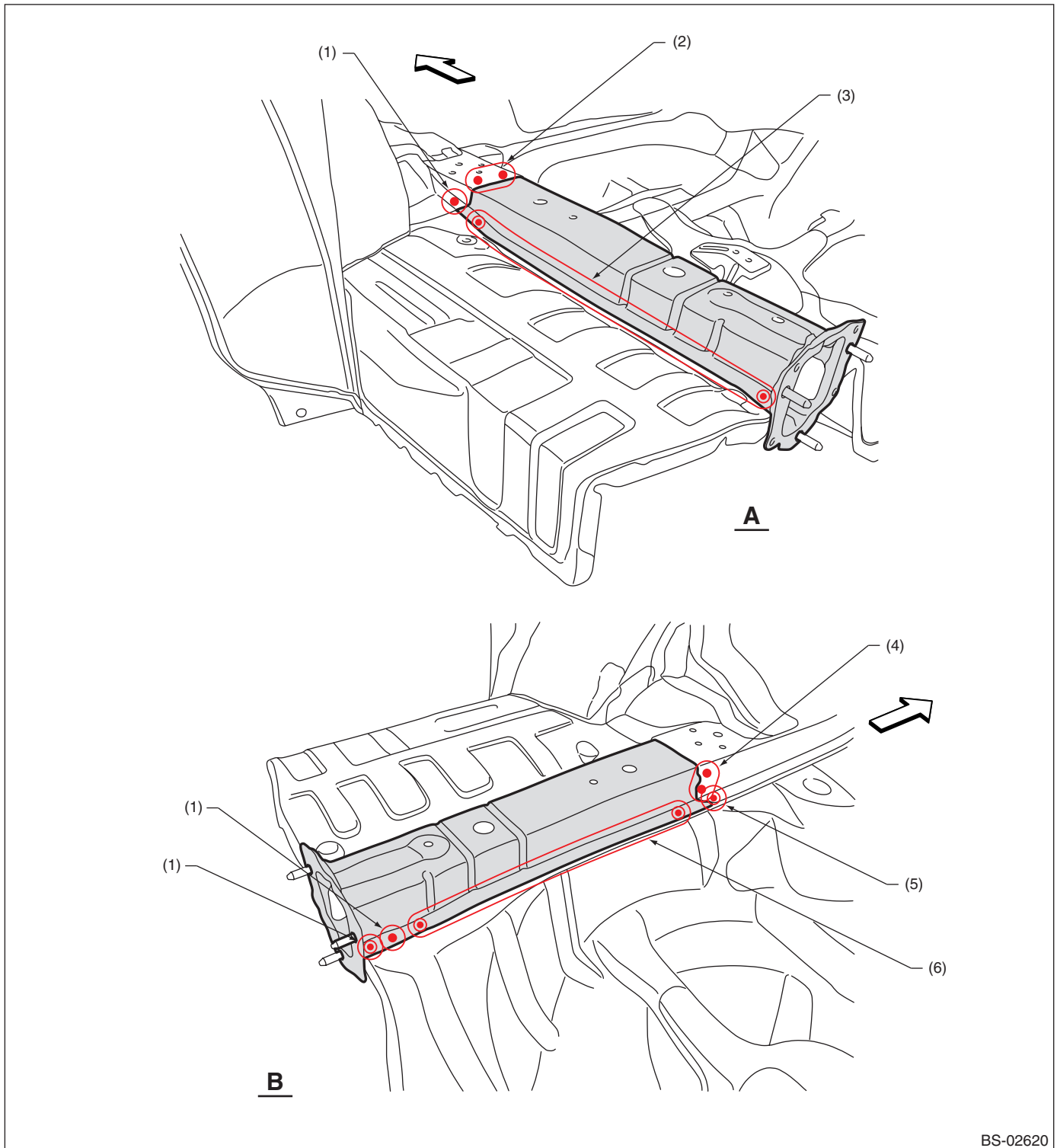
(1) 1 point (bottom · 1)

(2) 1 point (bottom · 2)

(3) 1 point (outside · 1)

Rear Side Frame Upper Rear (total replacement)/4 door

• Views



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

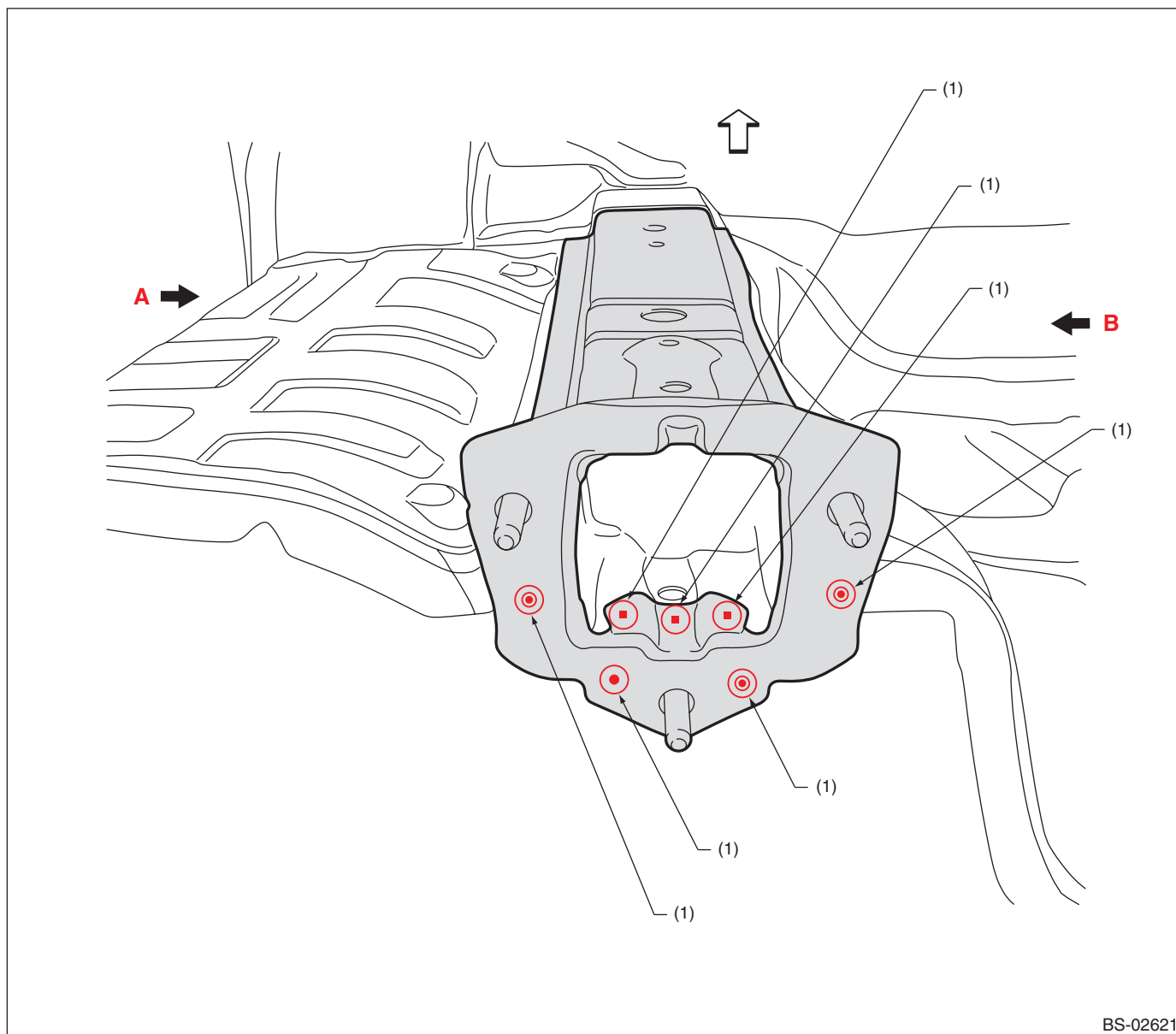
(3) 9 points (top · 1)
(4) 2 points (inside · 1)

(5) 1 point (top · 2)
(6) 8 points (top · 1)

Rear Side Frame Upper Rear (total replacement)/4 door

B: INSTALLATION

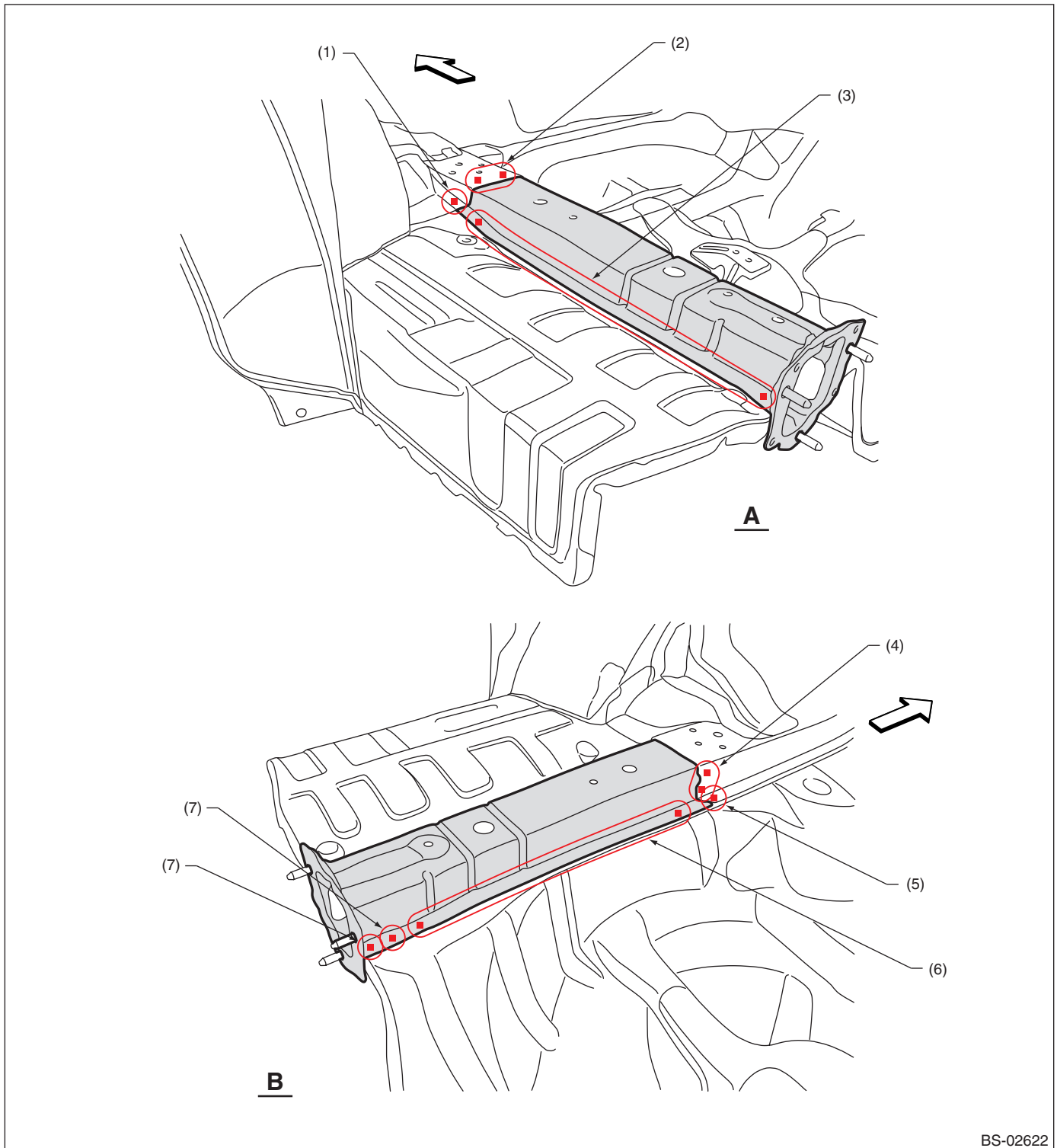
- Overall view



(1) 1 point

Rear Side Frame Upper Rear (total replacement)/4 door

• Views



BS-02622

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

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

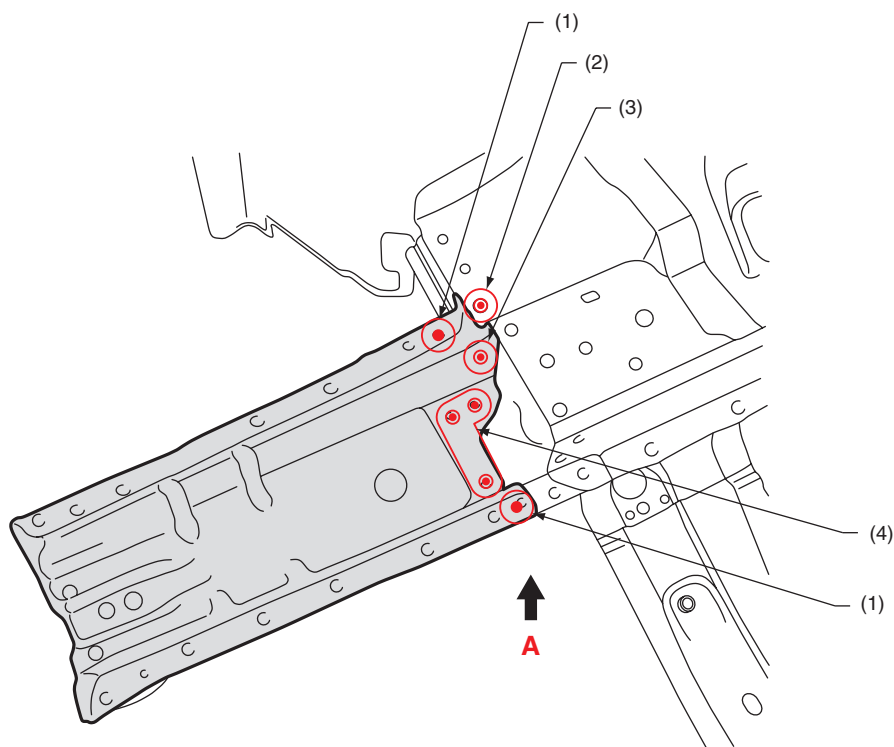
- (7) 1 point (service)

36.Rear Side Frame Lower Rear (total replacement)

A: REMOVAL

1) Rear skirt, floor side, rear side frame upper rear, rear floor removal condition

• Overall view



BS-02432

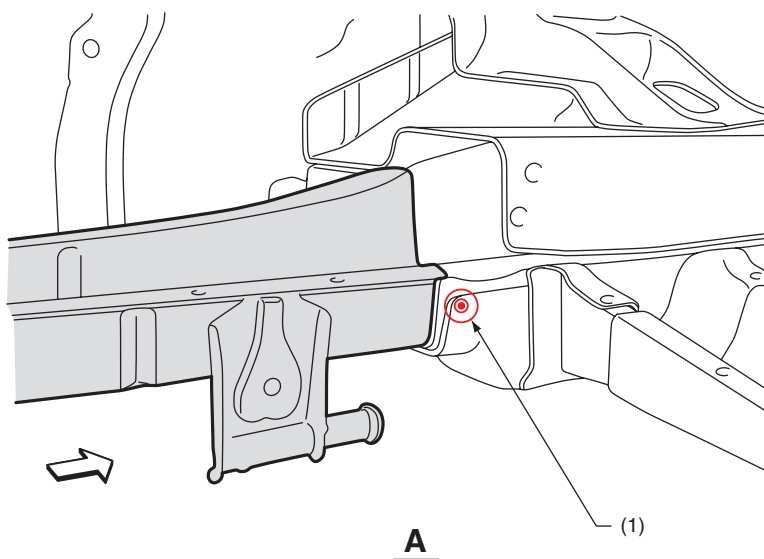
(1) 1 point (top · 1)
(2) 1 point (bottom · 2)

(3) 1 point (inside · belt sander)

(4) 3 points (top · 1)

Rear Side Frame Lower Rear (total replacement)

- Views



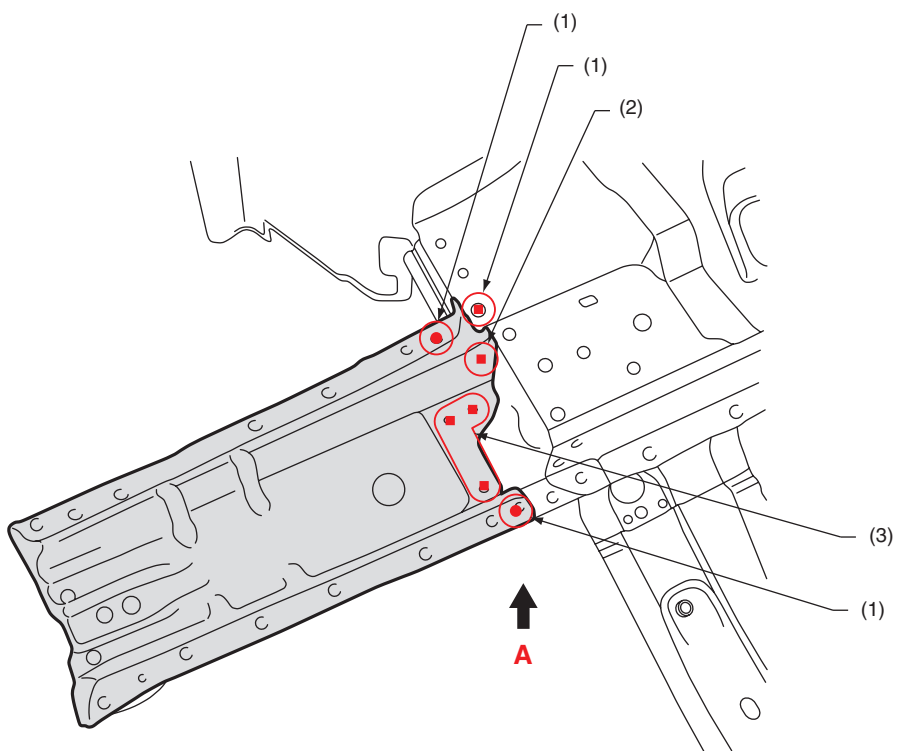
BS-02433

(1) 1 point (inside · 2)

Rear Side Frame Lower Rear (total replacement)

B: INSTALLATION

- Overall view



BS-02434

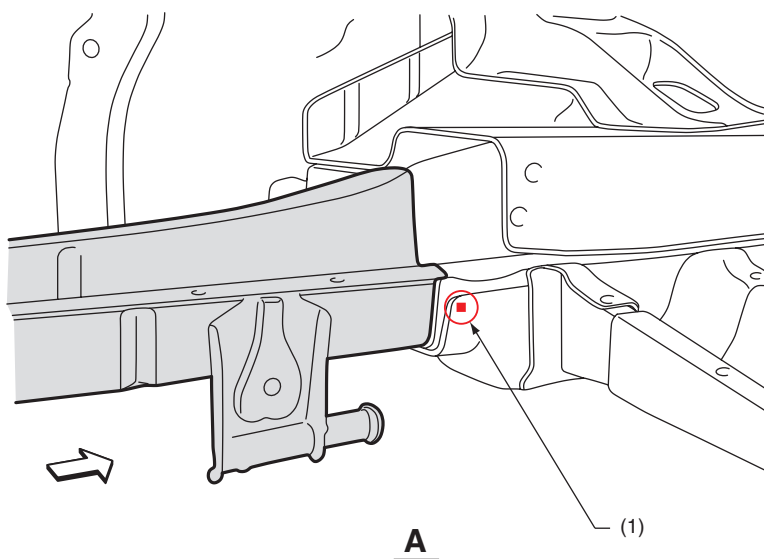
(1) 1 point

(2) 1 point (service)

(3) 3 points (service)

Rear Side Frame Lower Rear (total replacement)

- Views



BS-02435

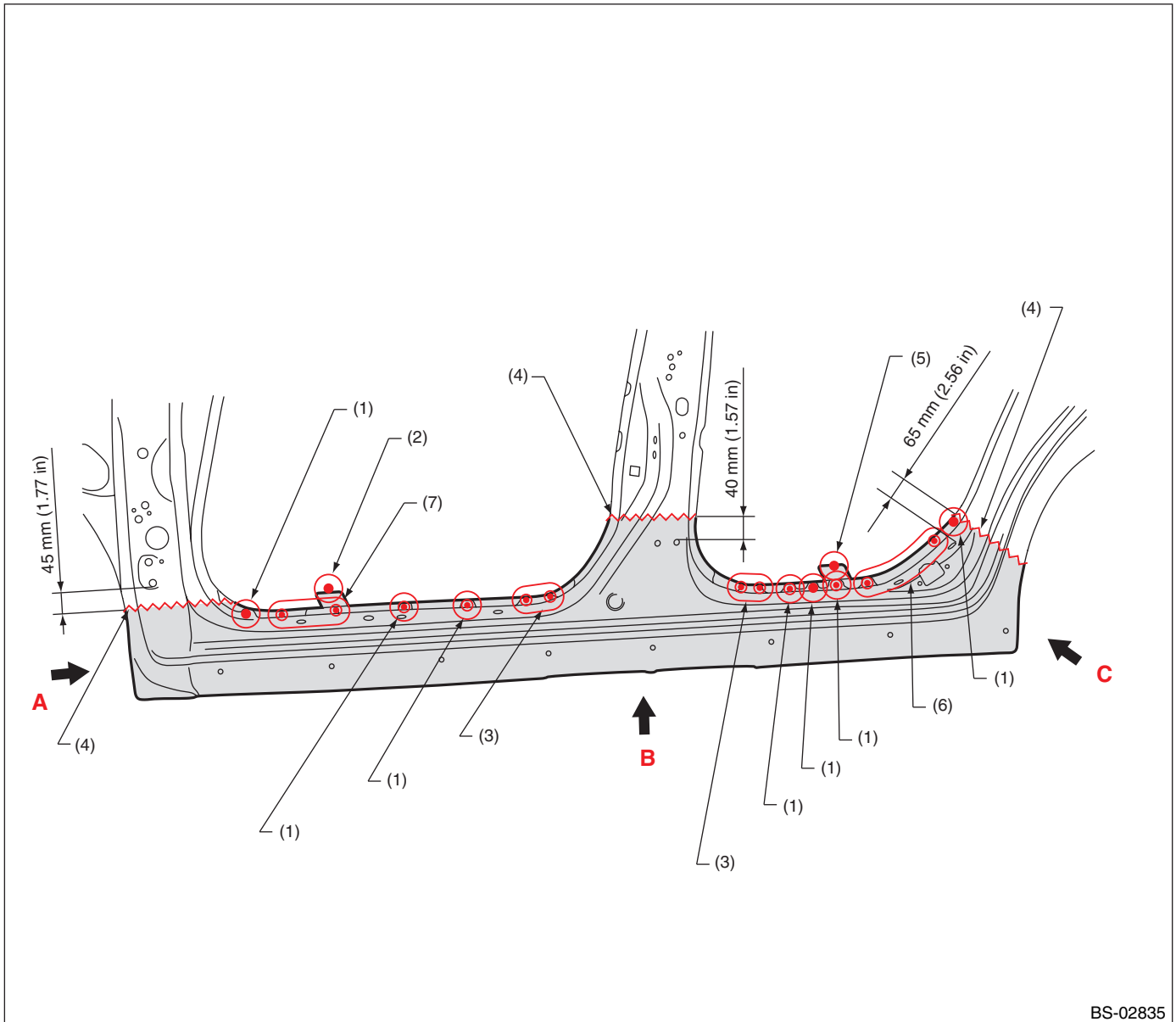
(1) 1 point

Side Sill Outer (partial replacement)

37.Side Sill Outer (partial replacement)

A: REMOVAL

• Overall view

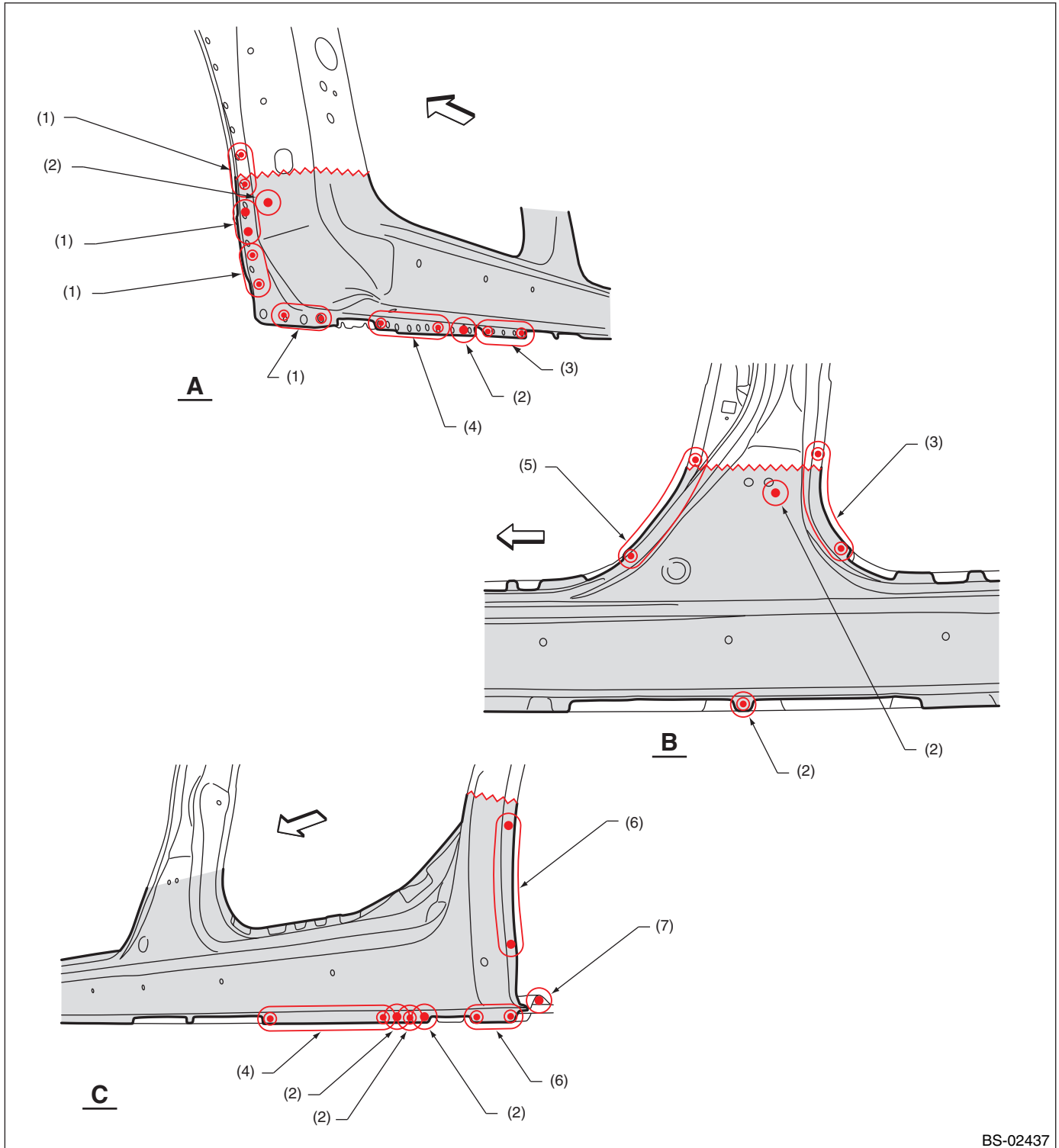


BS-02835

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

Side Sill Outer (partial replacement)

• Views



BS-02437

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

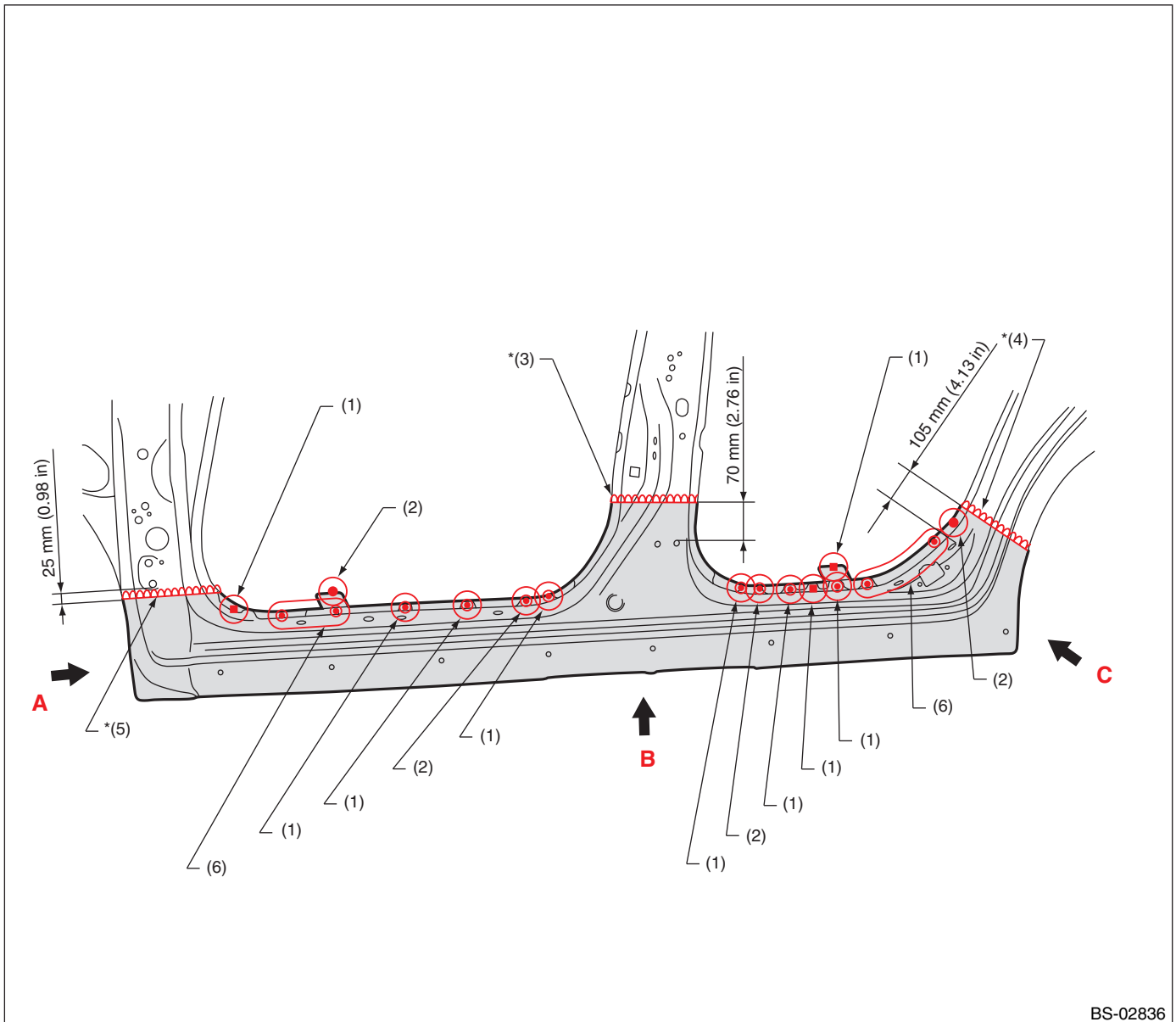
- (4) 8 points (outside · 1)
- (5) 7 points (outside · 1)
- (6) 3 points (outside · 1)

- (7) 1 point (bottom · 1)

Side Sill Outer (partial replacement)

B: INSTALLATION

• Overall view



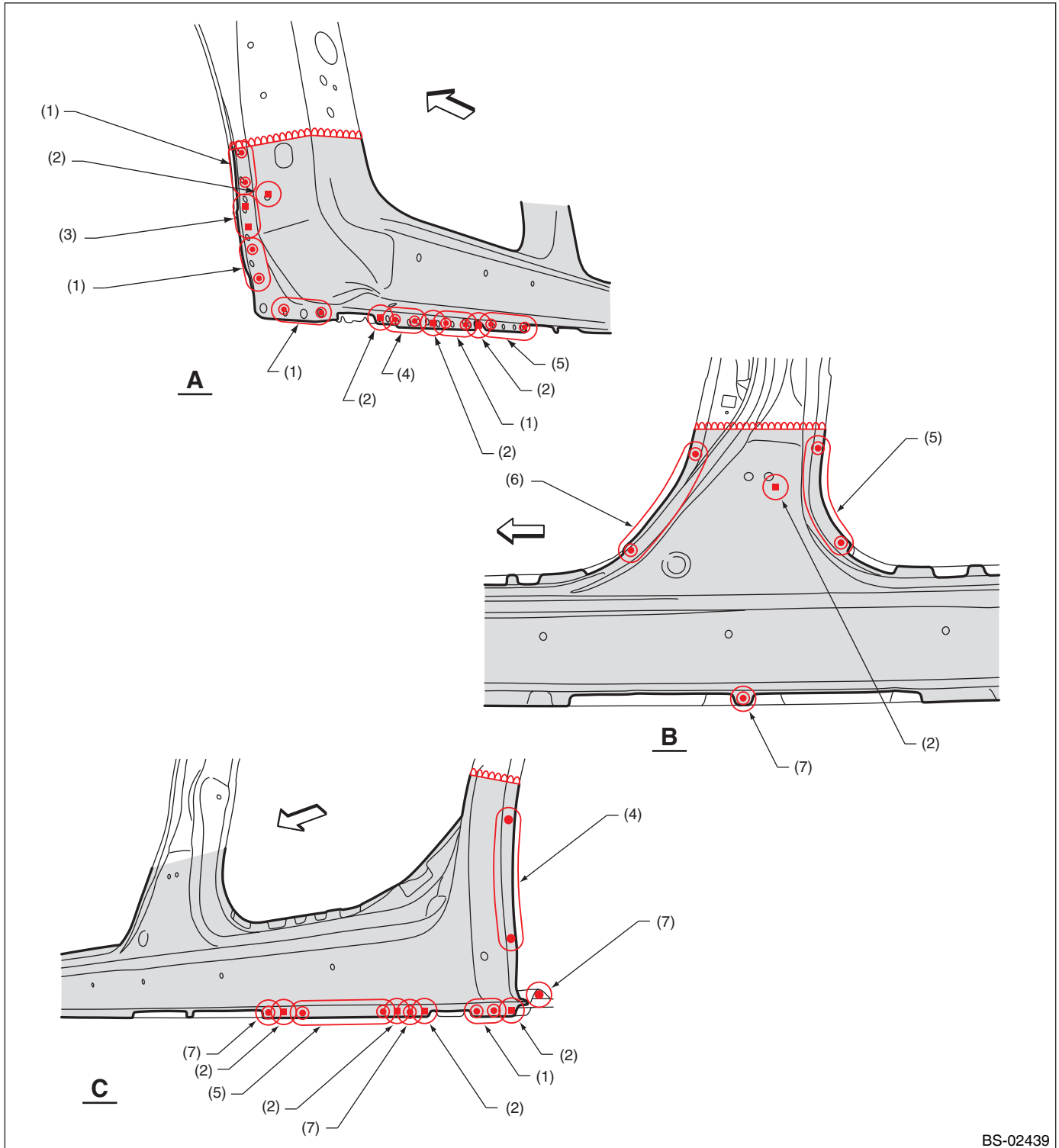
BS-02836

- | | | |
|-----------------------|---------------------------------|---------------------------------|
| (1) 1 point (service) | (3) 1 point [290 mm (11.42 in)] | (5) 1 point [300 mm (11.81 in)] |
| (2) 1 point | (4) 1 point [250 mm (9.84 in)] | (6) 6 points |

For continuous welds marked by *, anticorrosion wax shall be applied thoroughly on the rear.

Side Sill Outer (partial replacement)

• Views



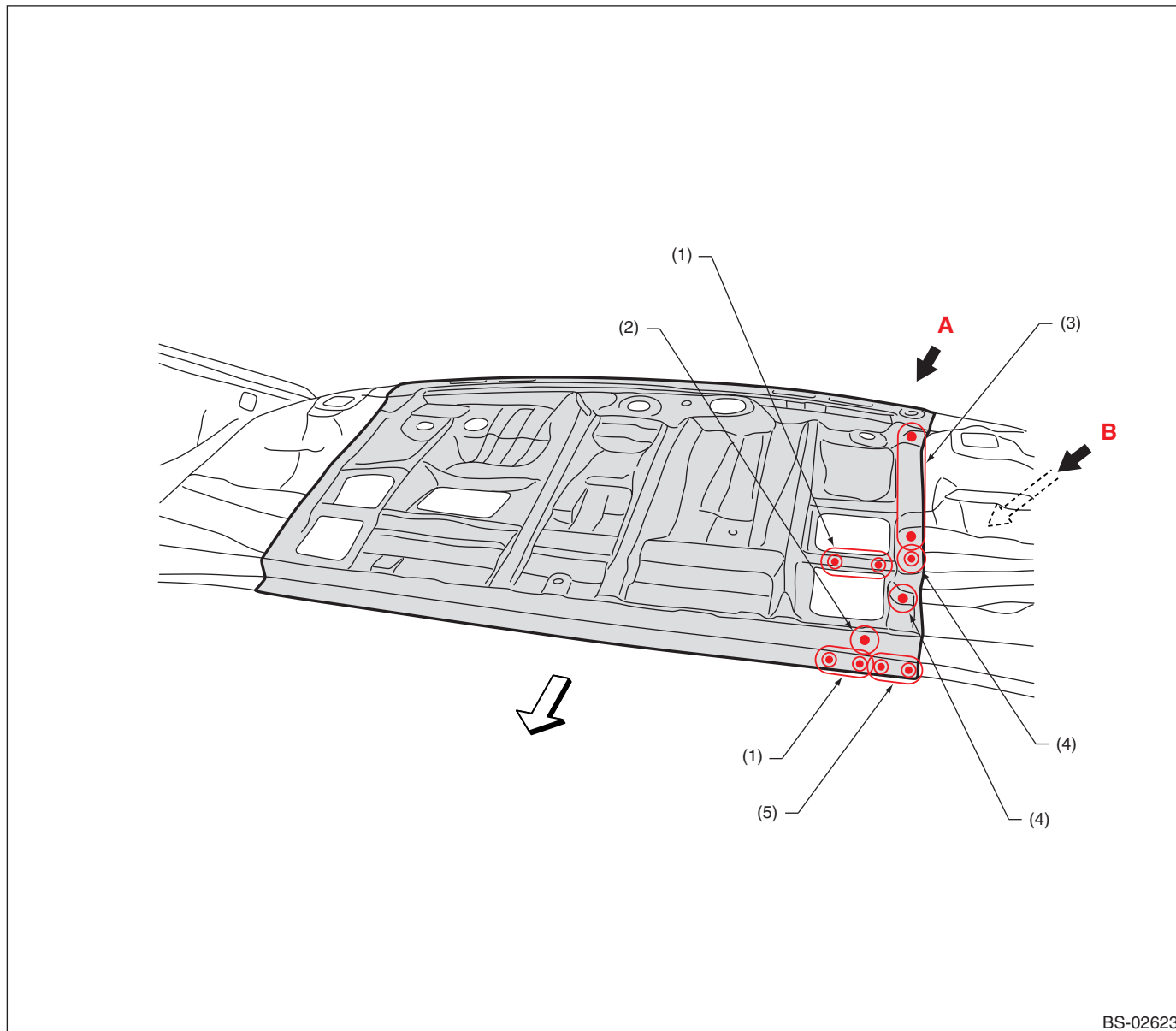
BS-02439

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

38.Rear Panel (total replacement)/4 door

A: REMOVAL

• Overall view



BS-02623

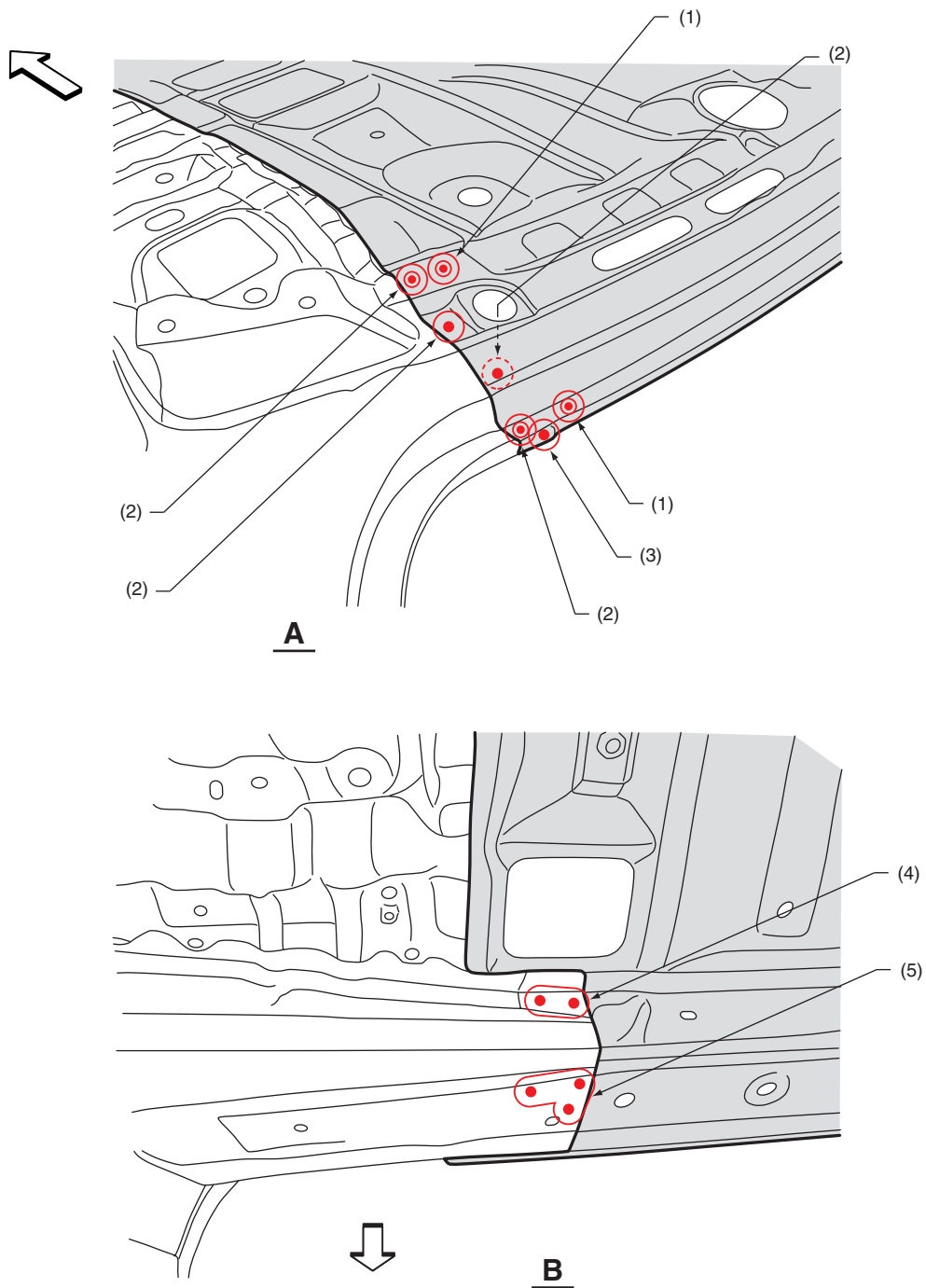
(1) 2 points (top · 2)
(2) 1 point (inside · 1)

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

(5) 2 points (top · 1)

Rear Panel (total replacement)/4 door

• Views



BS-02624

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

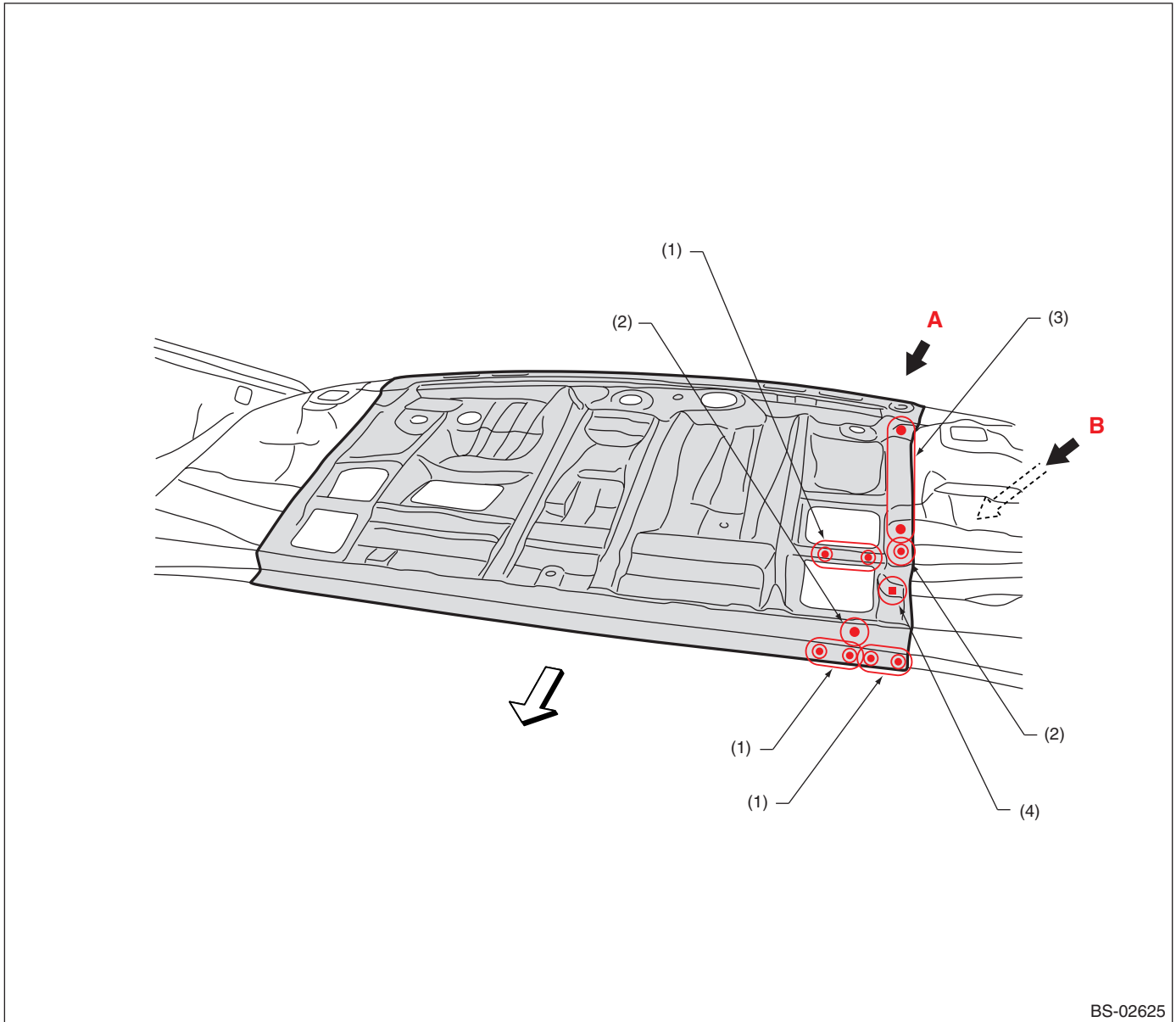
(3) 1 point (outside · 1)
(4) 2 points (outside · 1)

(5) 3 points (top · 1)

Rear Panel (total replacement)/4 door

B: INSTALLATION

- Overall view



BS-02625

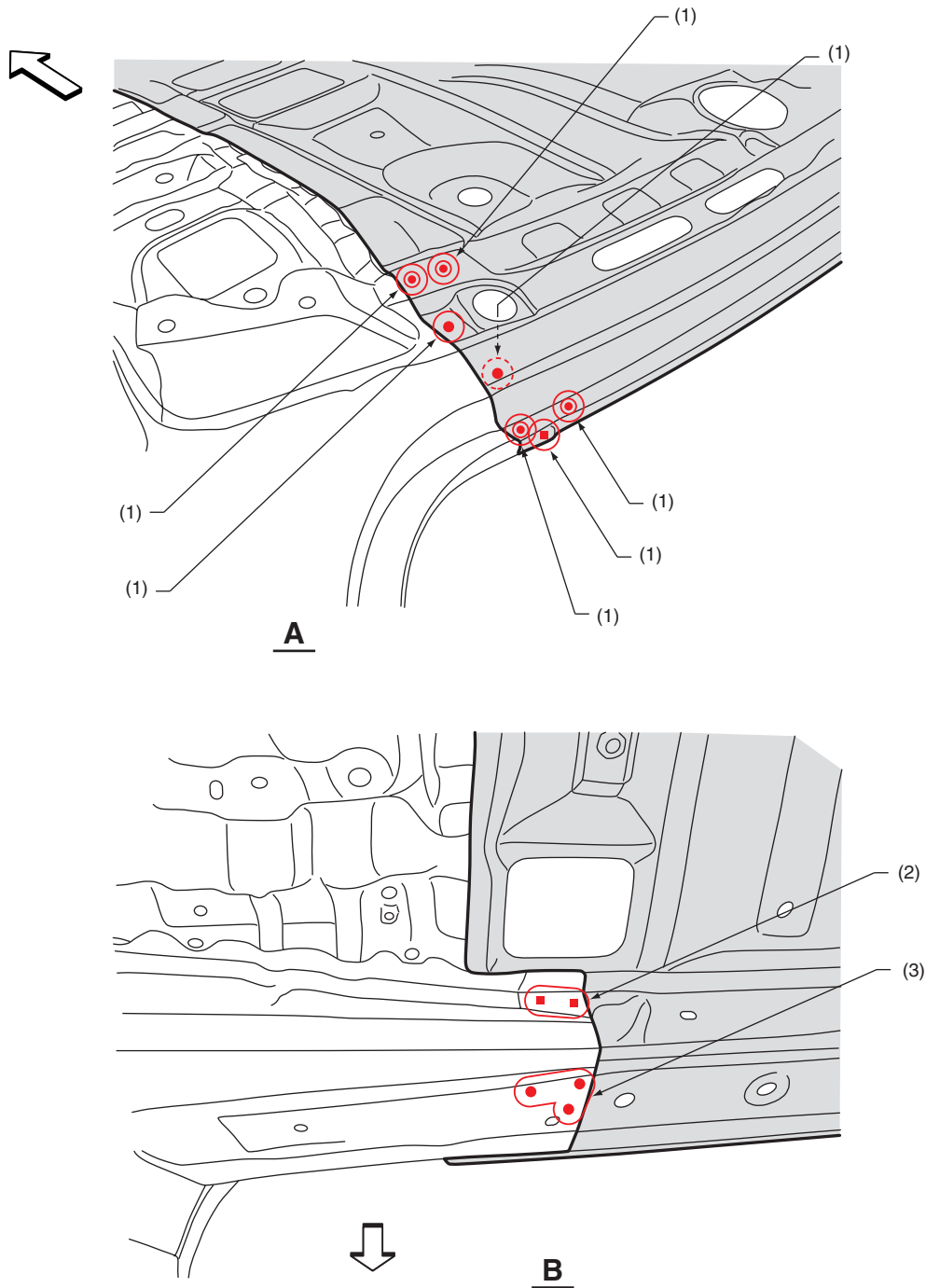
(1) 2 points
(2) 1 point

(3) 6 points

(4) 1 point (service)

Rear Panel (total replacement)/4 door

- Views



BS-02505

(1) 1 point

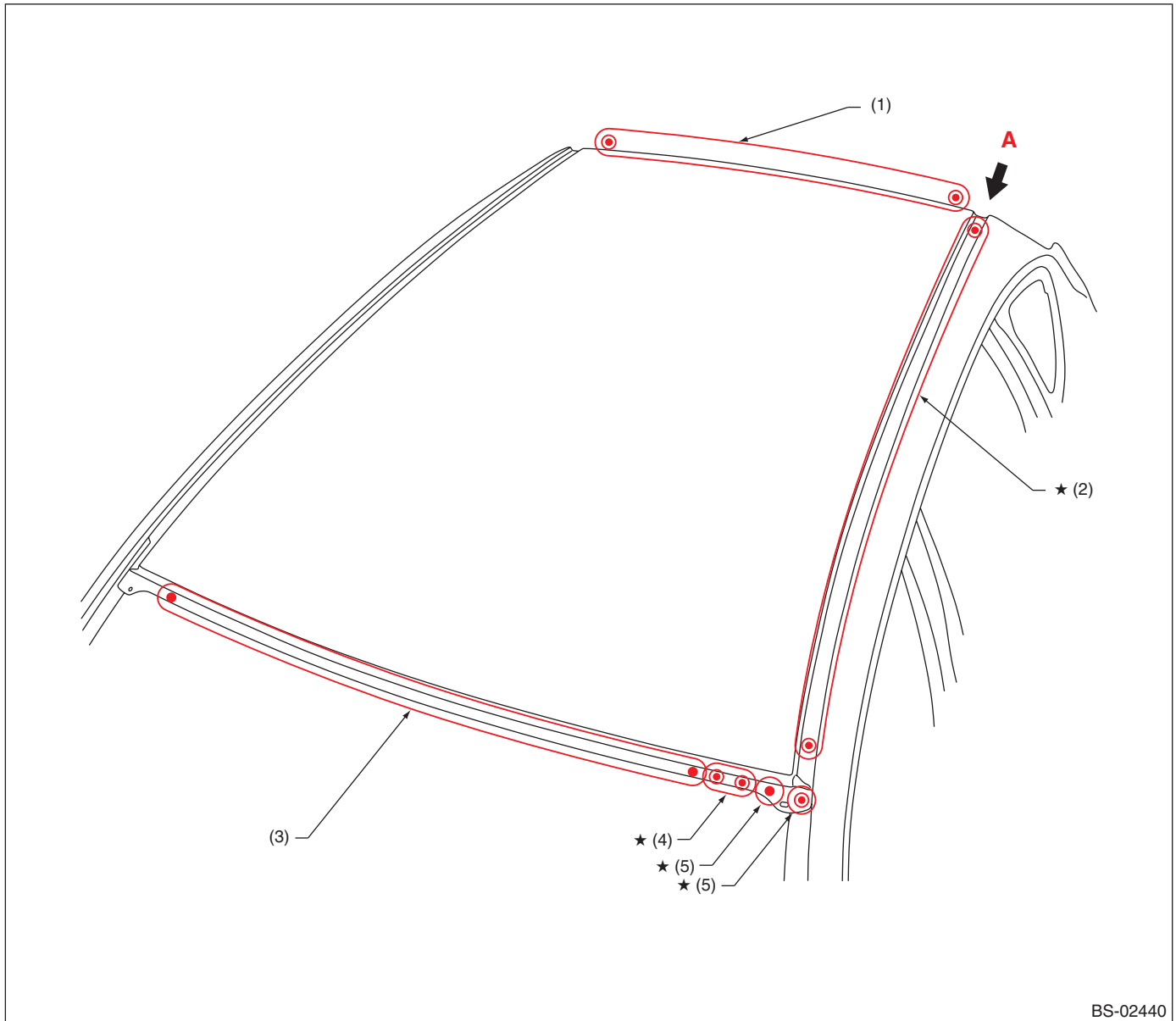
(2) 2 points

(3) 3 points

39.Roof Panel (total replacement)/5 door

A: REMOVAL

- Overall view (model without sunroof)



(1) 13 points (top · 1)

(2) 20 points (top · 1)

(3) 14 points (top · 1)

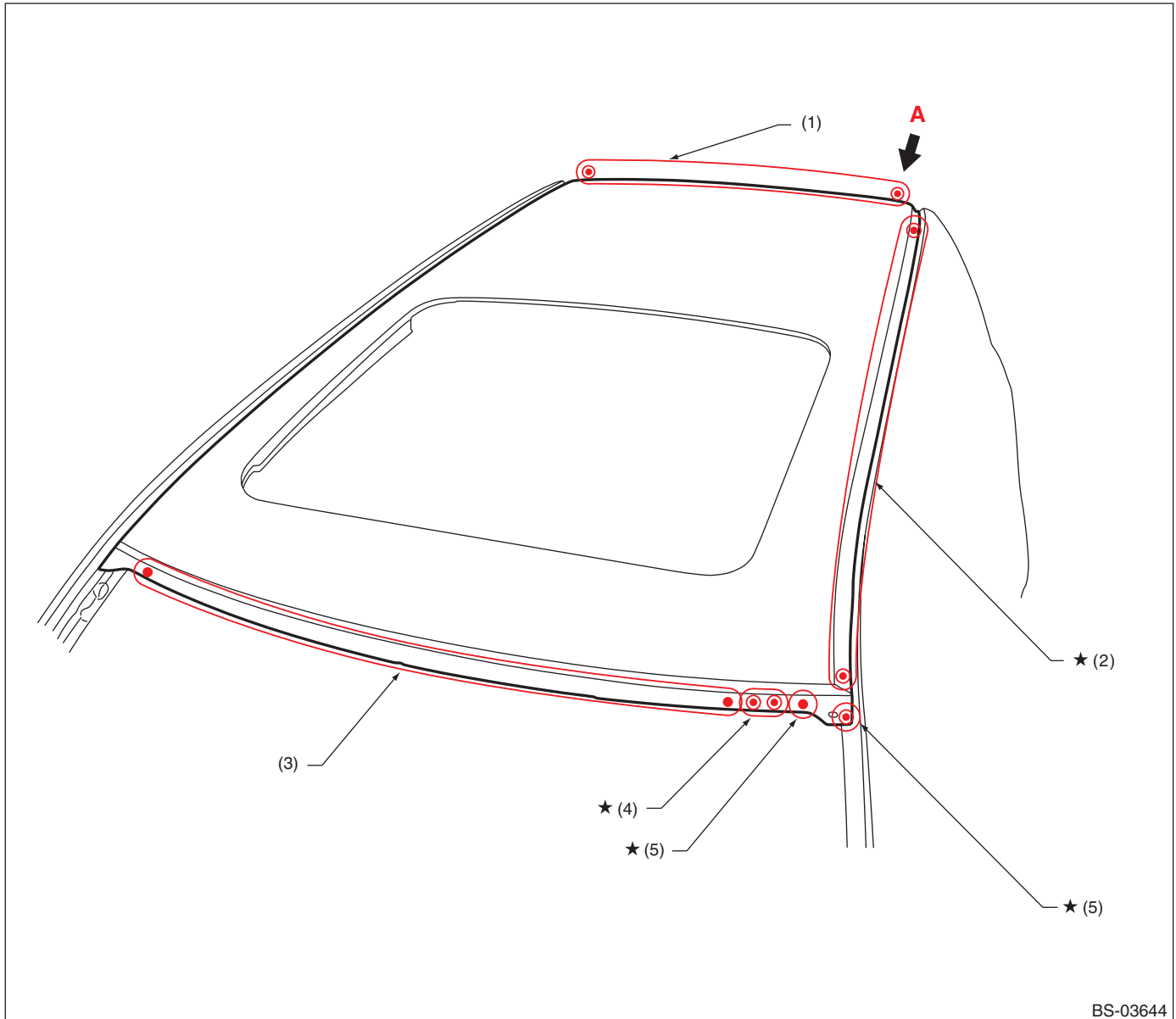
(4) 2 points (top · 1)

(5) 1 point (top · 1)

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

Roof Panel (total replacement)/5 door

• Overall view (sunroof model)



(1) 13 points (top · 1)
(2) 20 points (top · 1)

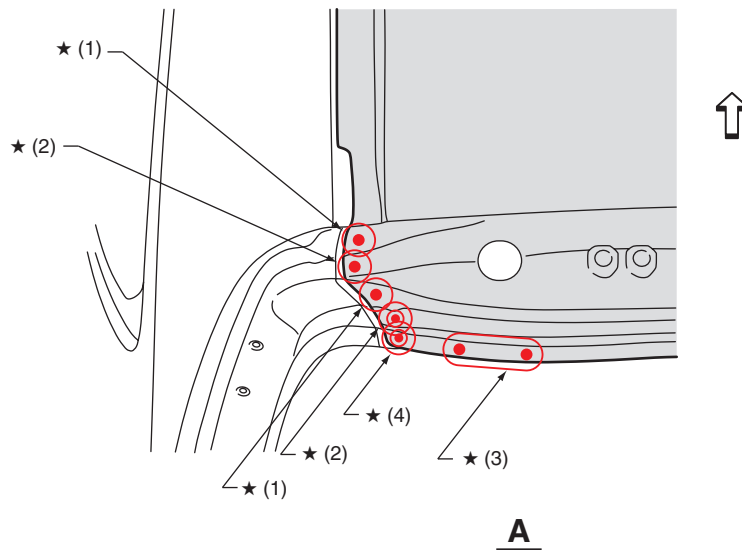
(3) 14 points (top · 1)
(4) 2 points (top · 1)

(5) 1 point (top · 1)

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

Roof Panel (total replacement)/5 door

- Views



BS-02441

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

(3) 2 points (inside · 1)

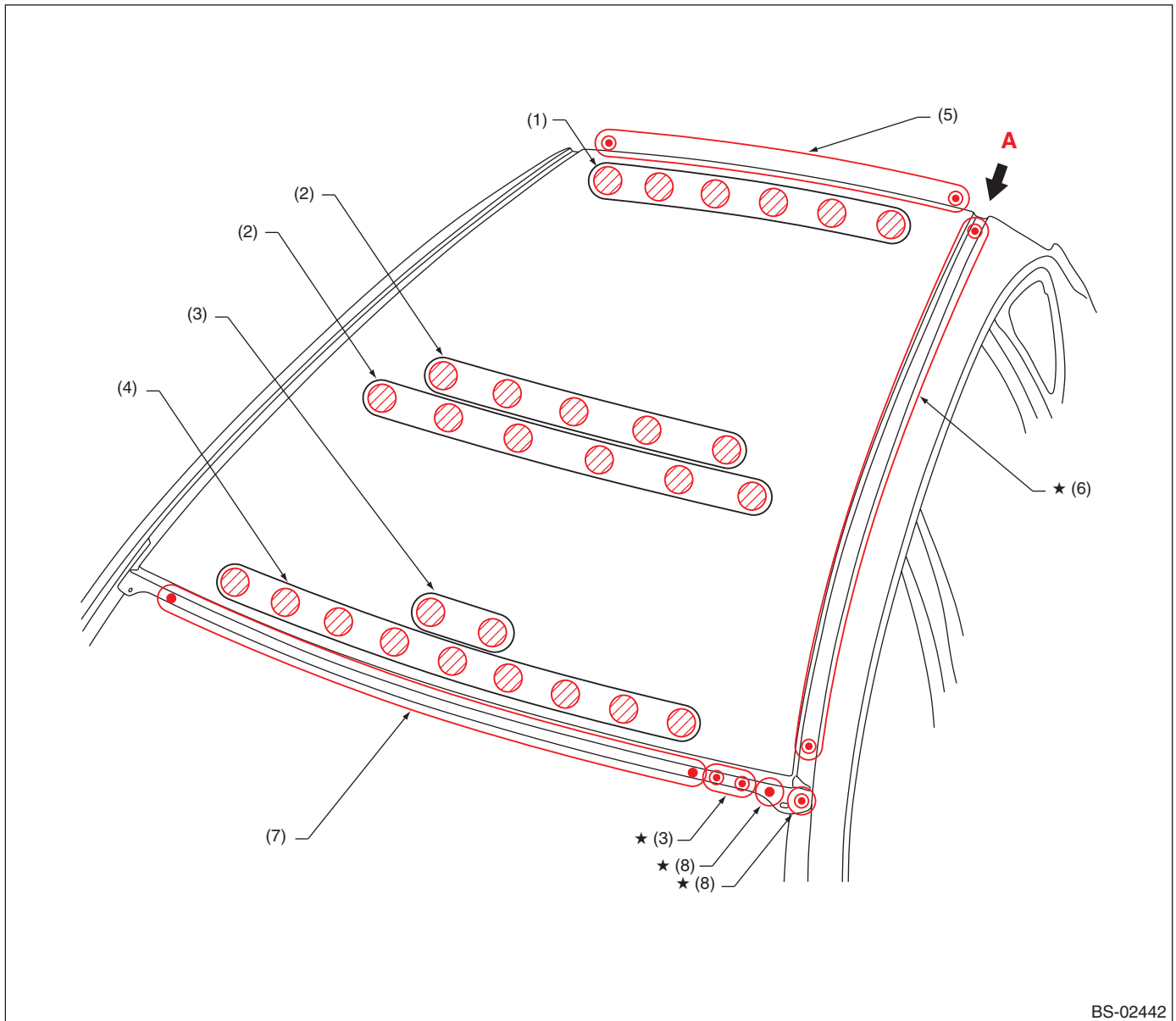
(4) 1 point (inside · 1)

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

Roof Panel (total replacement)/5 door

B: INSTALLATION

• Overall view (model without sunroof)



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

- (4) 9 points
- (5) 16 points
- (6) 22 points

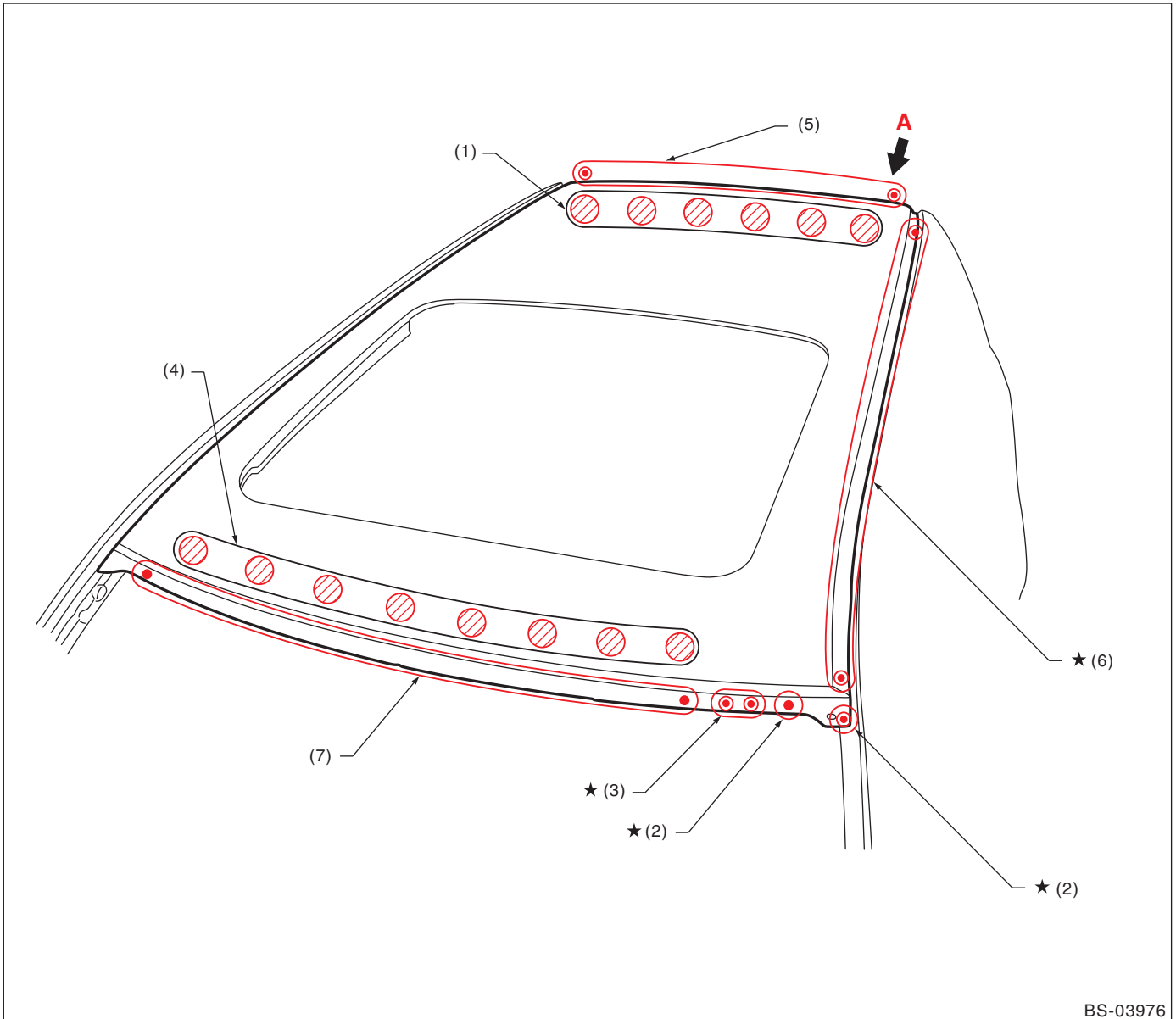
- (7) 17 points
- (8) 1 point

POINT: For installation of the side rail part of the roof panel, the triple part with the base material is welded.

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

Roof Panel (total replacement)/5 door

• Overall view (sunroof model)



BS-03976

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

- (4) 8 points
- (5) 16 points

- (6) 22 points
- (7) 17 points

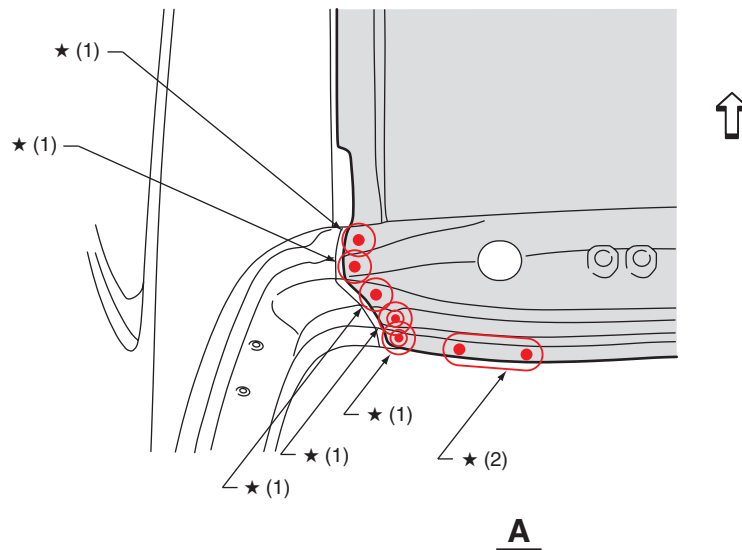
POINT: For installation of the side rail part of the roof panel, the triple part with the base material is welded.

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

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

Roof Panel (total replacement)/5 door

- Views



BS-02443

(1) 1 point

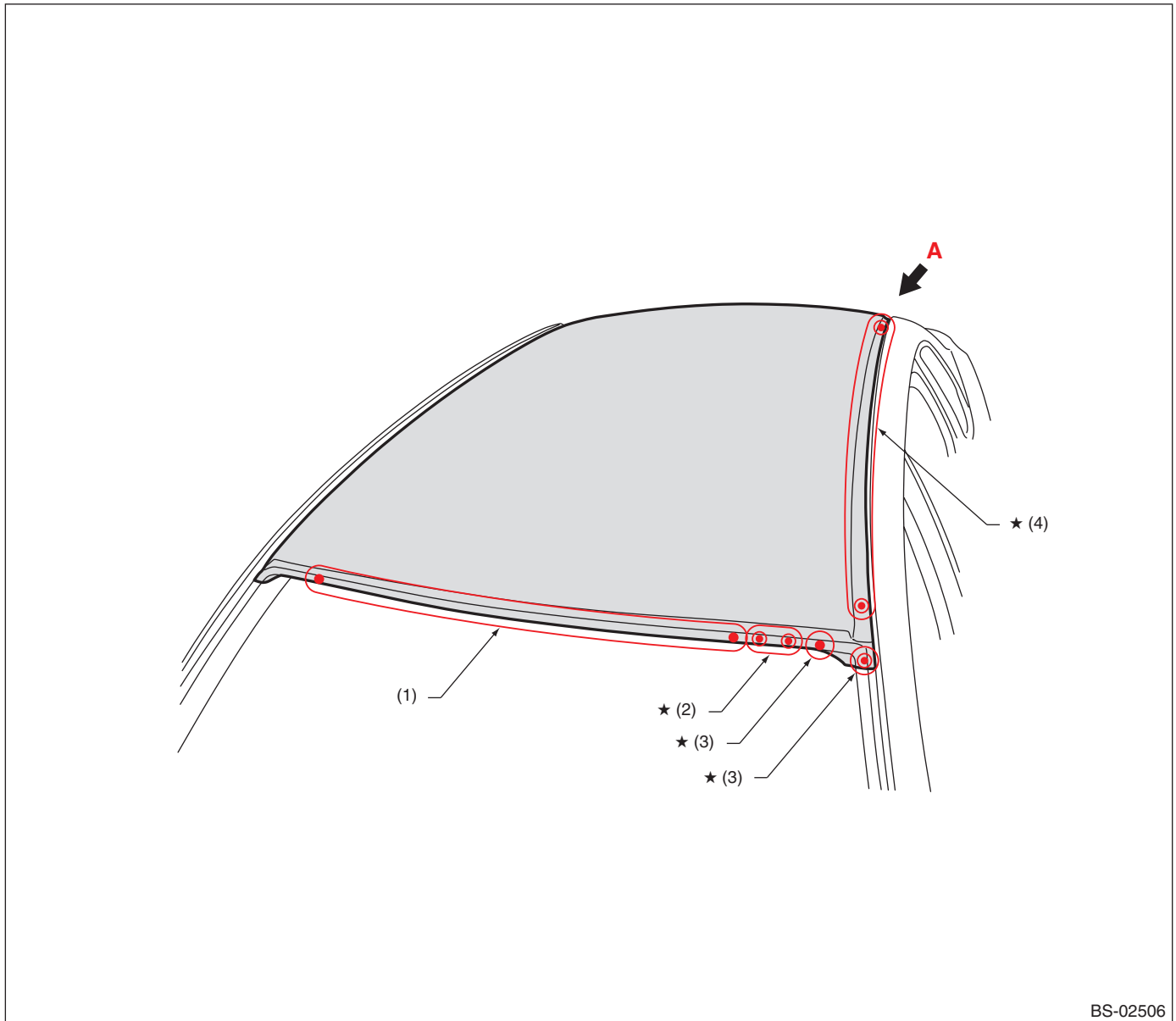
(2) 2 points

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

40.Roof Panel (total replacement)/4 door

A: REMOVAL

- Overall view (model without sunroof)



(1) 14 points (top · 1)

(2) 2 points (top · 1)

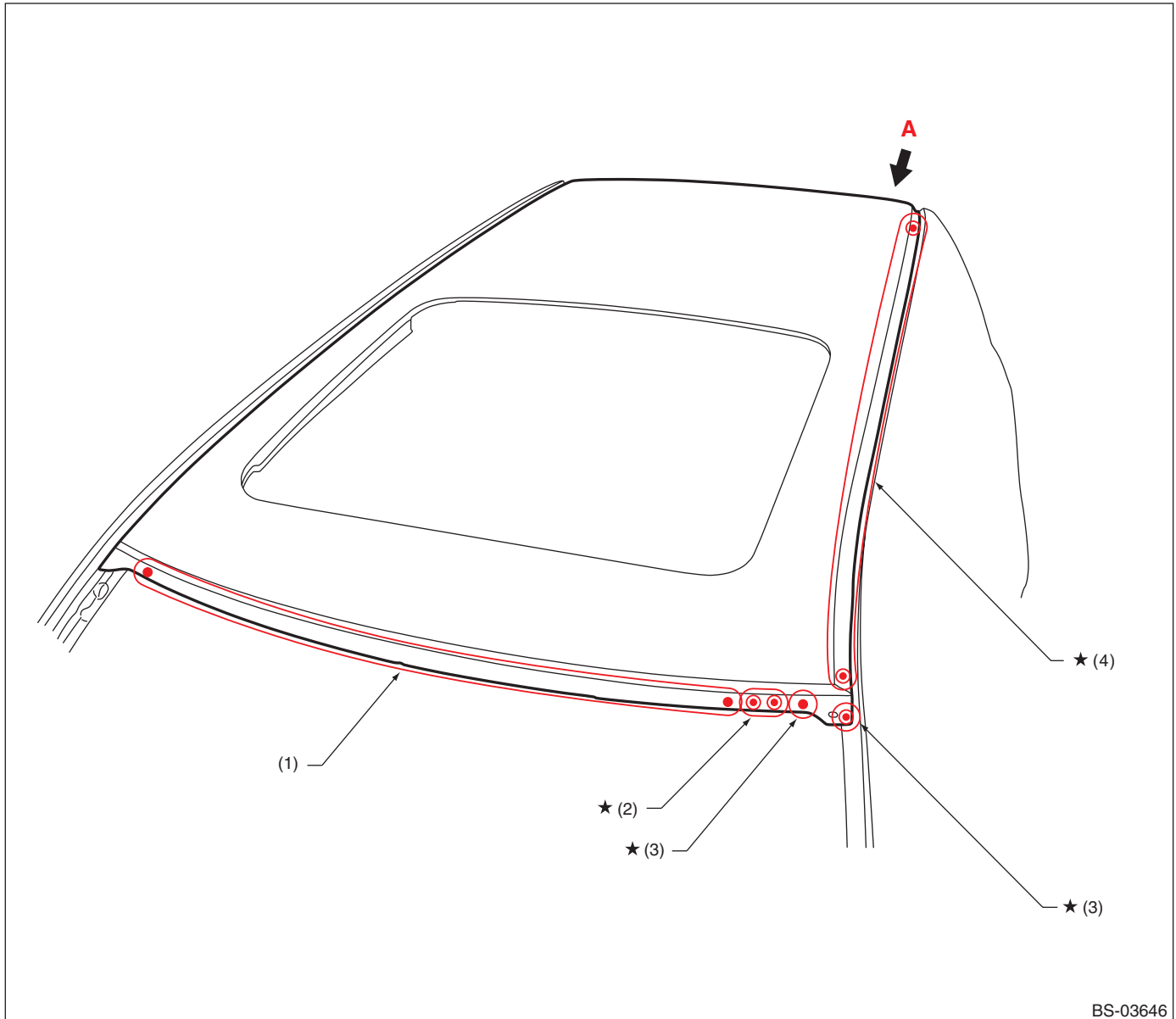
(3) 1 point (top · 1)

(4) 18 points (top · 1)

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

Roof Panel (total replacement)/4 door

- Overall view (sunroof model)



(1) 14 points (top · 1)
(2) 2 points (top · 1)

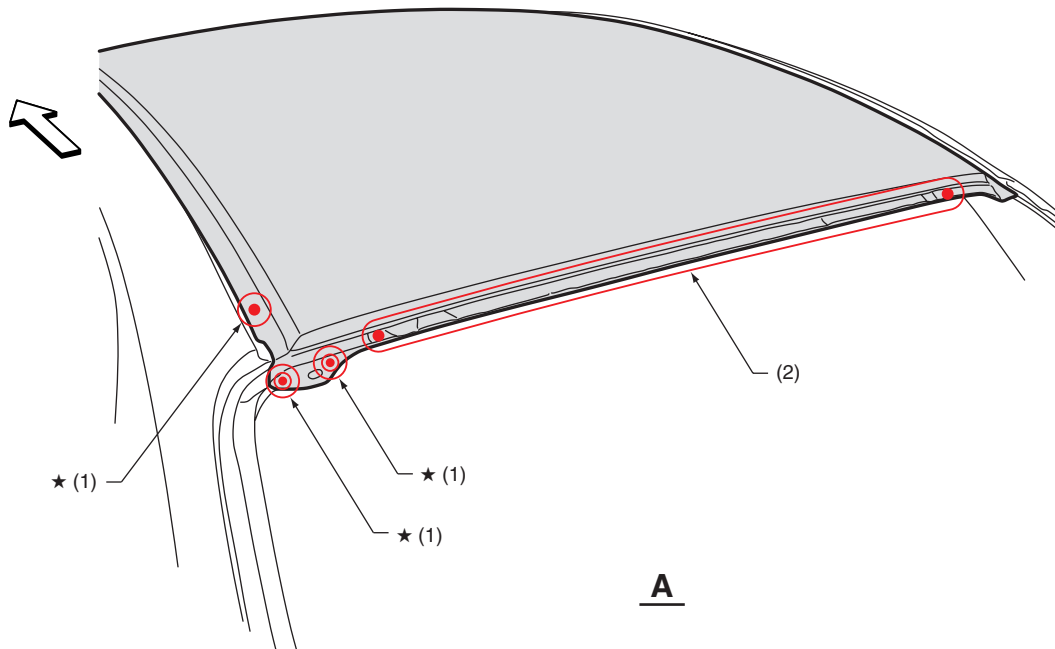
(3) 1 point (top · 1)

(4) 18 points (top · 1)

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

Roof Panel (total replacement)/4 door

- Views



BS-02507

(1) 1 point (top · 1)

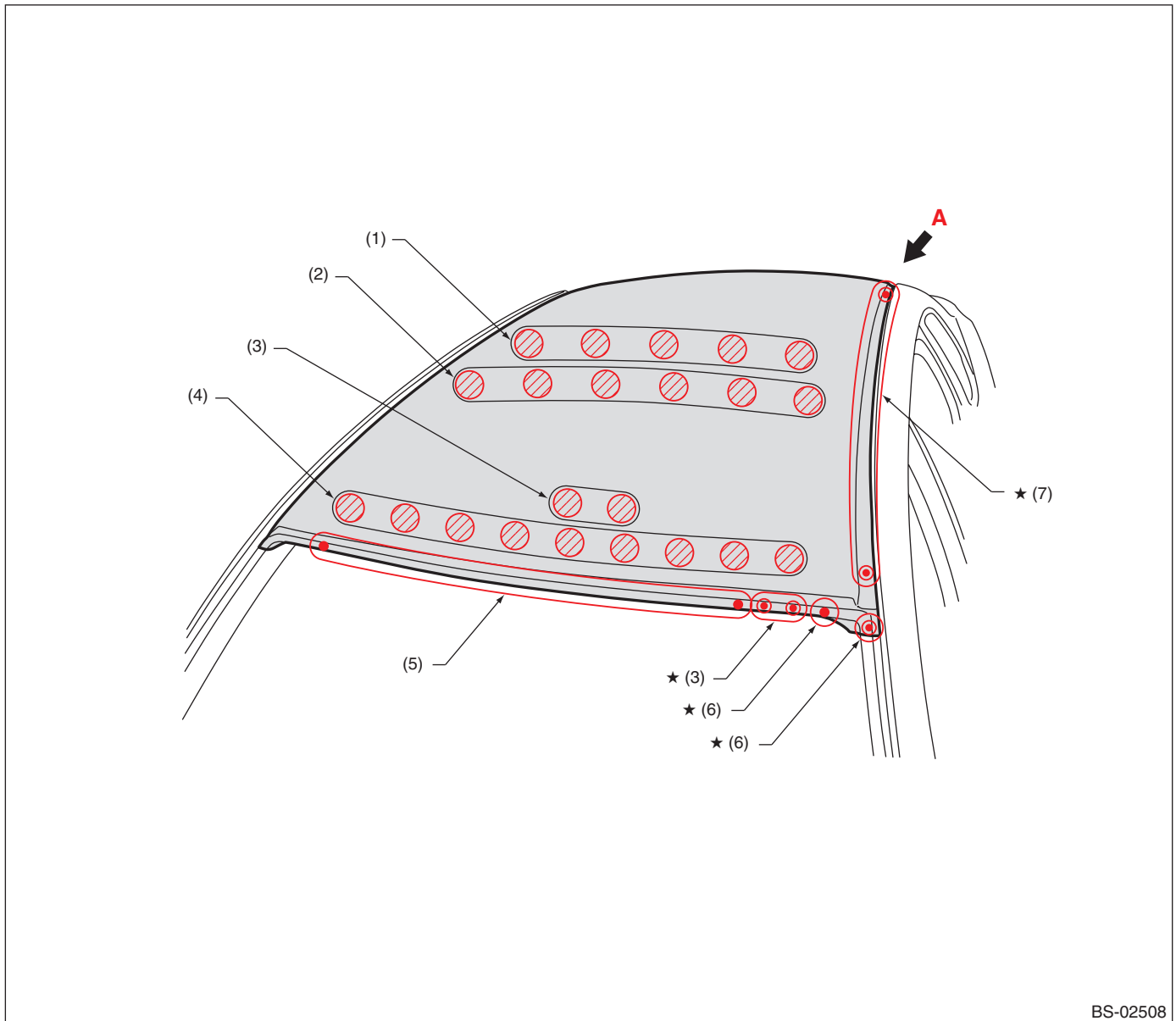
(2) 13 points (top · 1)

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

Roof Panel (total replacement)/4 door

B: INSTALLATION

- Overall view (model without sunroof)



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

- (4) 9 points
- (5) 17 points
- (6) 1 point

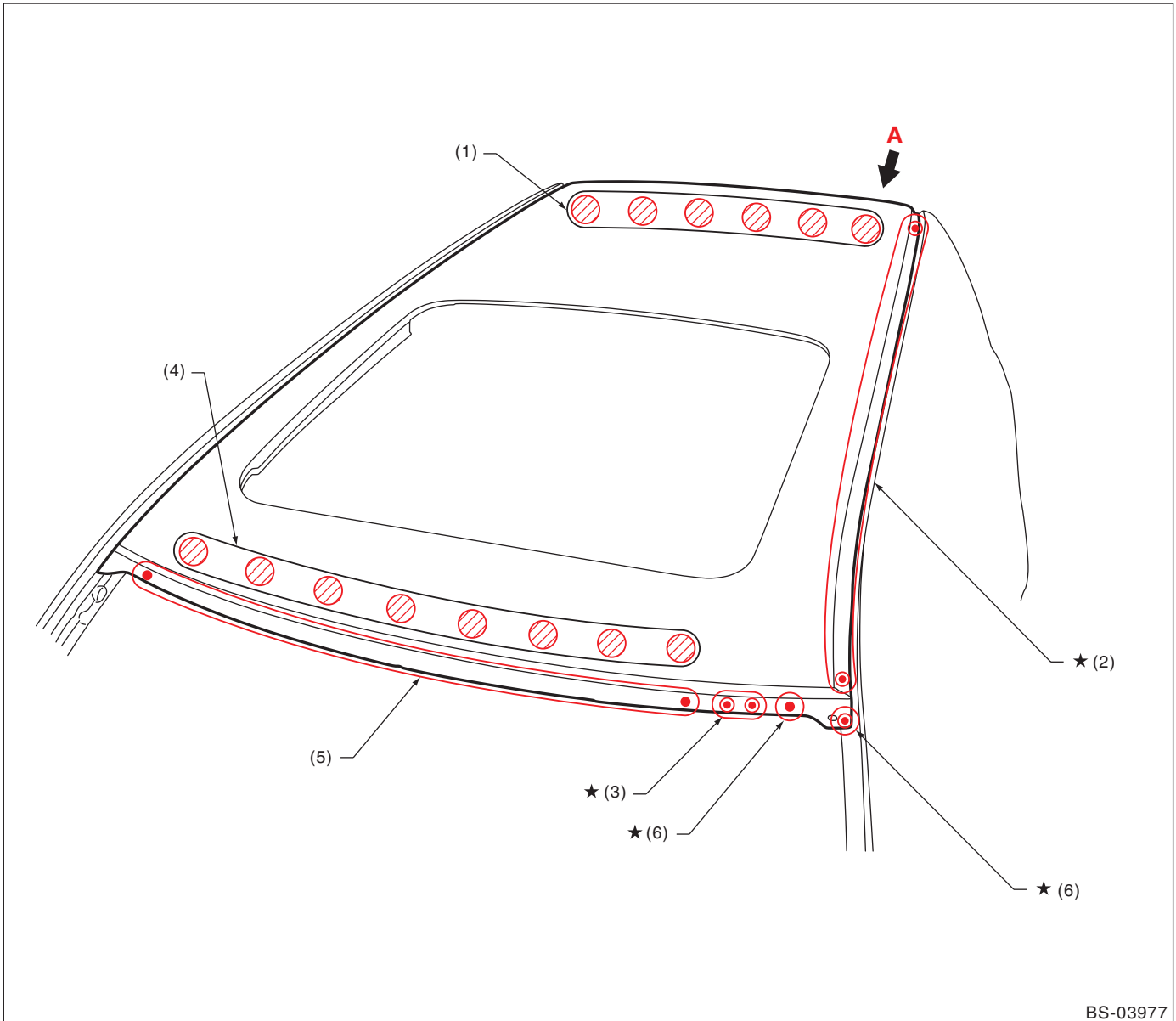
- (7) 19 points

POINT: For installation of the side rail part of the roof panel, the triple part with the base material is welded. For locations marked by ★, the welding method and the number of welding points are the same on the left and the right.

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

Roof Panel (total replacement)/4 door

• Overall view (sunroof model)



BS-03977

(1) 6 points

(3) 2 points

(5) 17 points

(2) 19 points

(4) 8 points

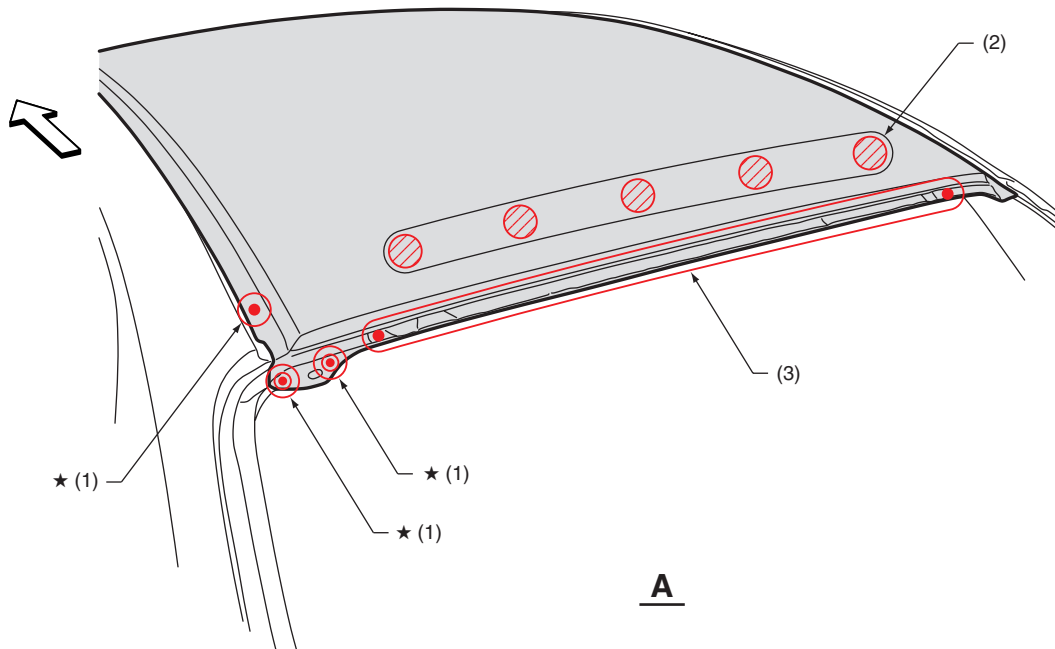
(6) 1 point

POINT: For installation of the side rail part of the roof panel, the triple part with the base material is welded. For locations marked by ★, the welding method and the number of welding points are the same on the left and the right.

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

Roof Panel (total replacement)/4 door

- Views



BS-02509

(1) 1 point

(2) 5 points

(3) 16 points

POINT: For installation of the side rail part of the roof panel, the triple part with the base material is welded. For locations marked by ★, the welding method and the number of welding points are the same on the left and the right.

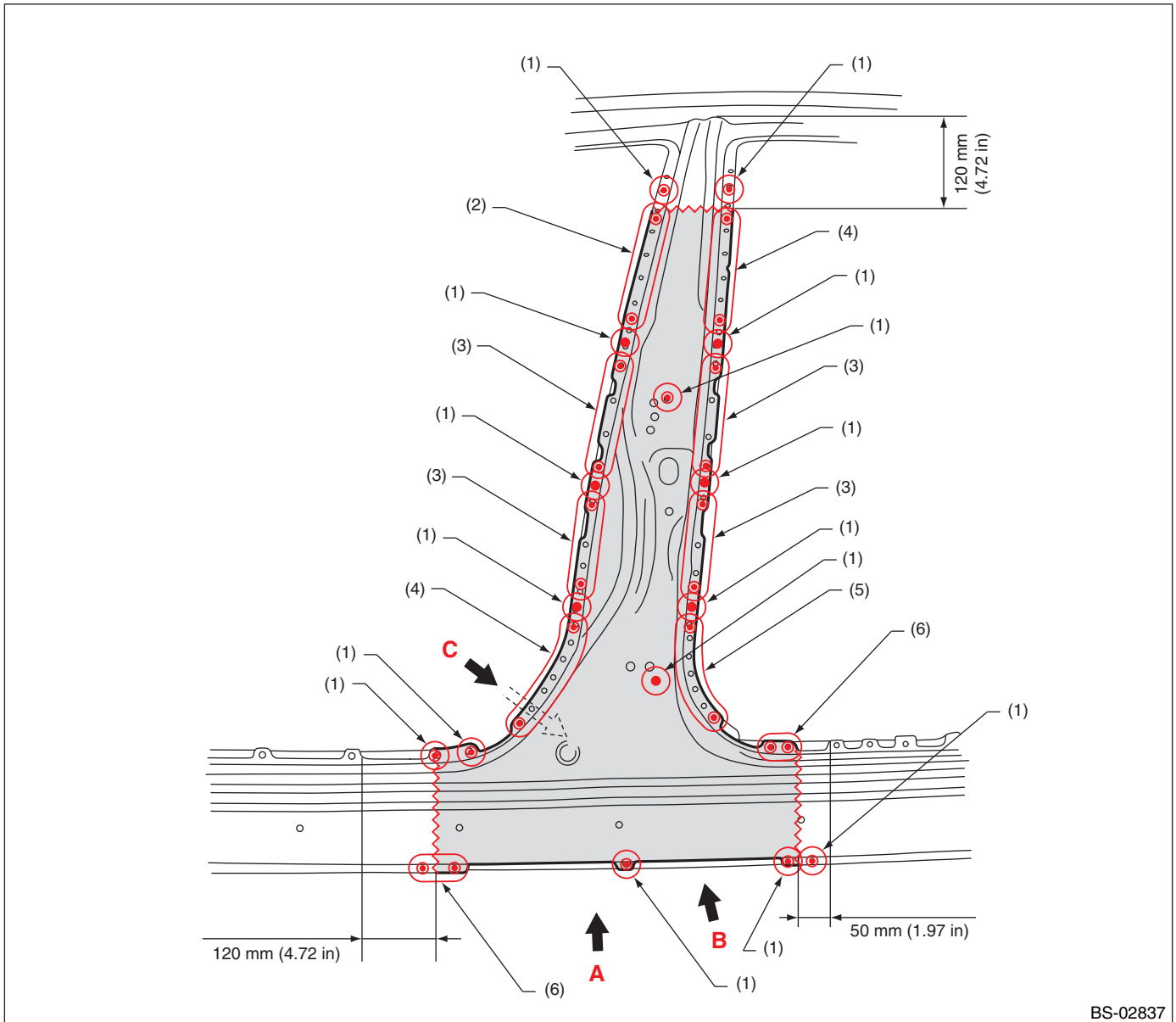
⊗ : Application of adhesive at the time of roof panel installation.

Center Pillar (partial replacement)

41.Center Pillar (partial replacement)

A: REMOVAL

• Overall view

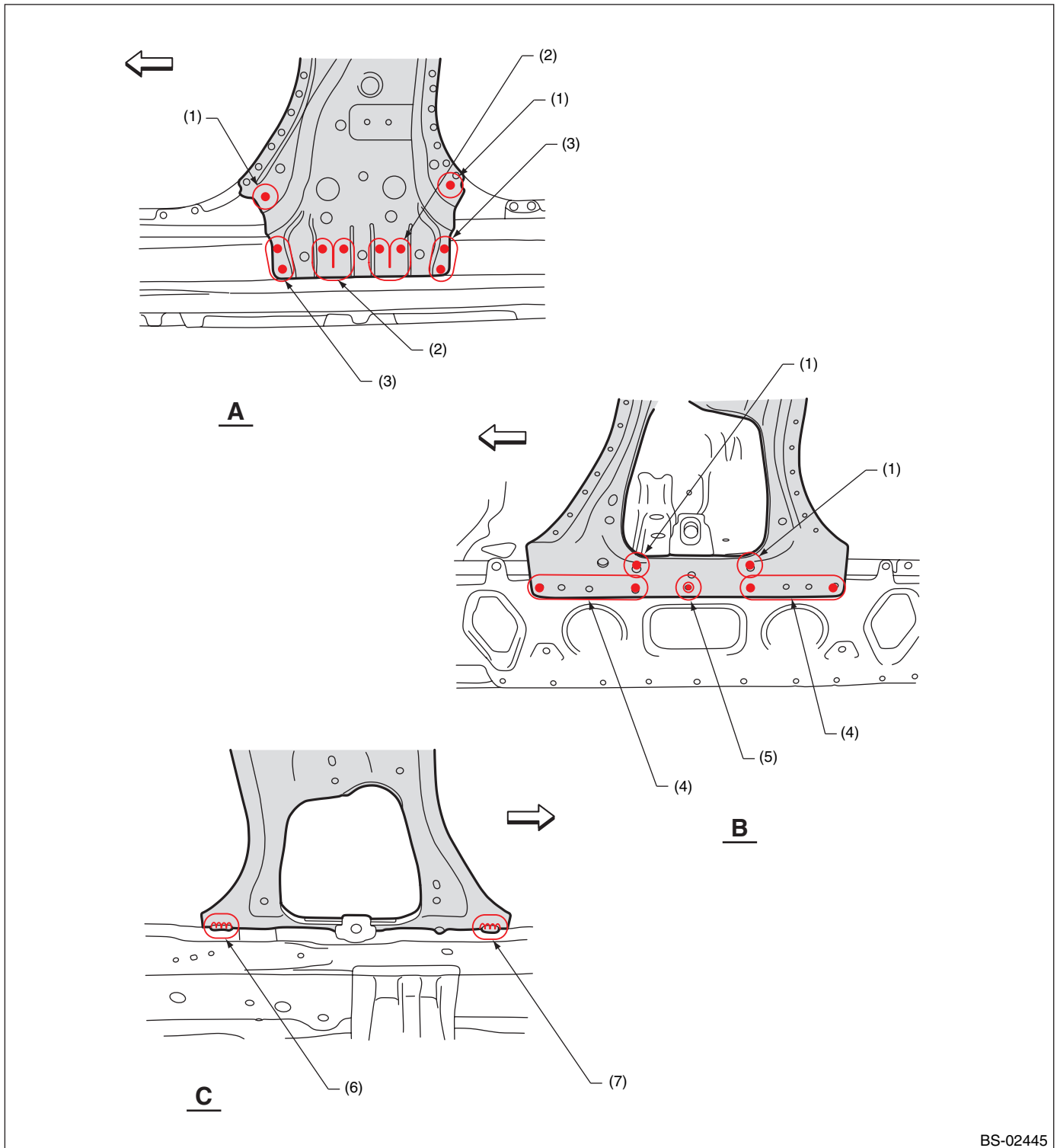


BS-02837

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

Center Pillar (partial replacement)

• Views



BS-02445

(1) 1 point (outside · 1)

(4) 4 points (outside · 1)

(7) 1 point [inside · 20 mm (0.79 in),
belt sander]

(2) 3 points (outside · 1)

(5) 1 point (outside · 2)

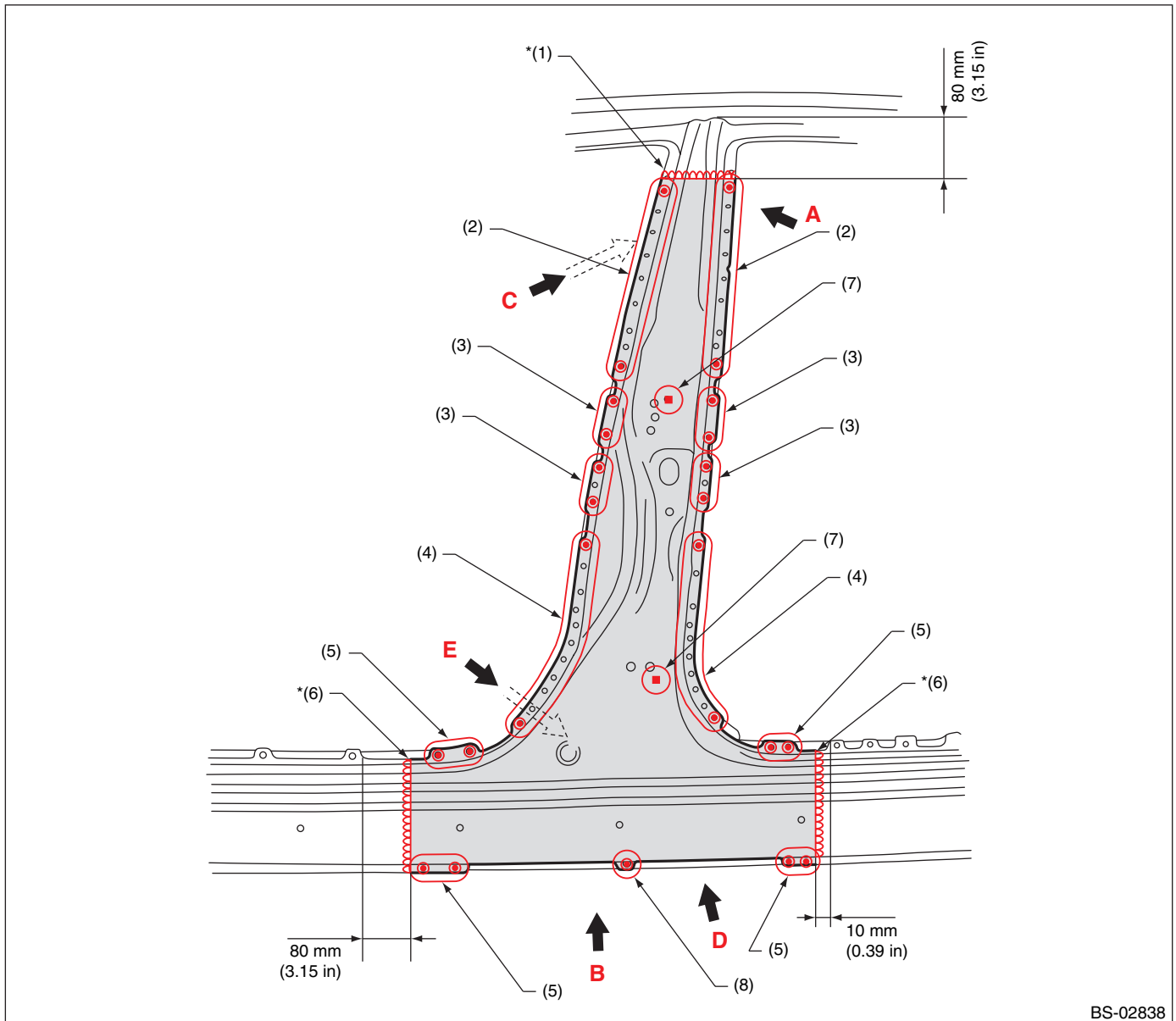
(3) 2 points (outside · 1)

(6) 1 point [inside · 25 mm (0.98 in),
belt sander]

Center Pillar (partial replacement)

B: INSTALLATION

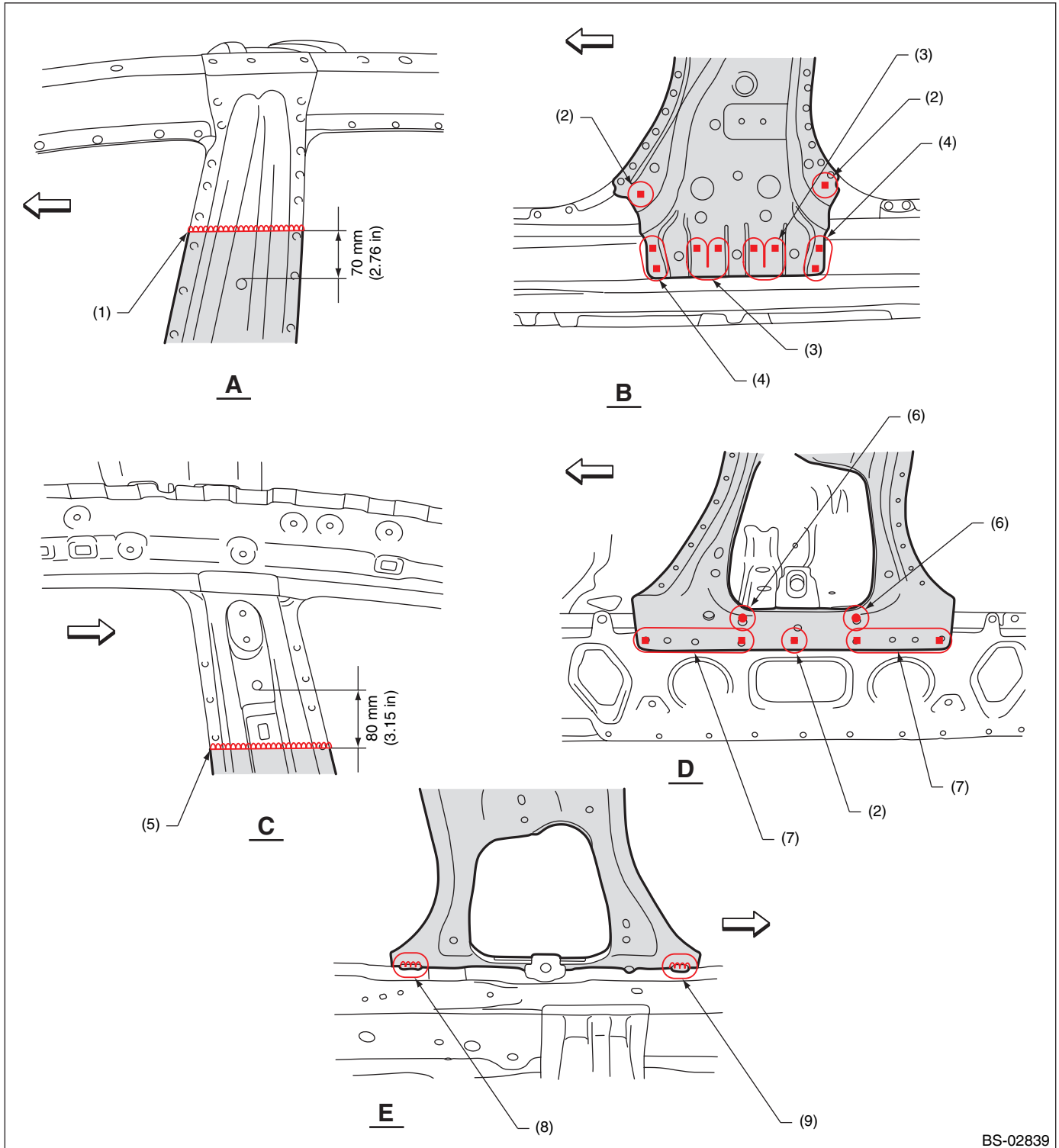
• Overall view



For continuous welds marked by *, anticorrosion wax shall be applied thoroughly on the rear.

Center Pillar (partial replacement)

• Views



BS-02839

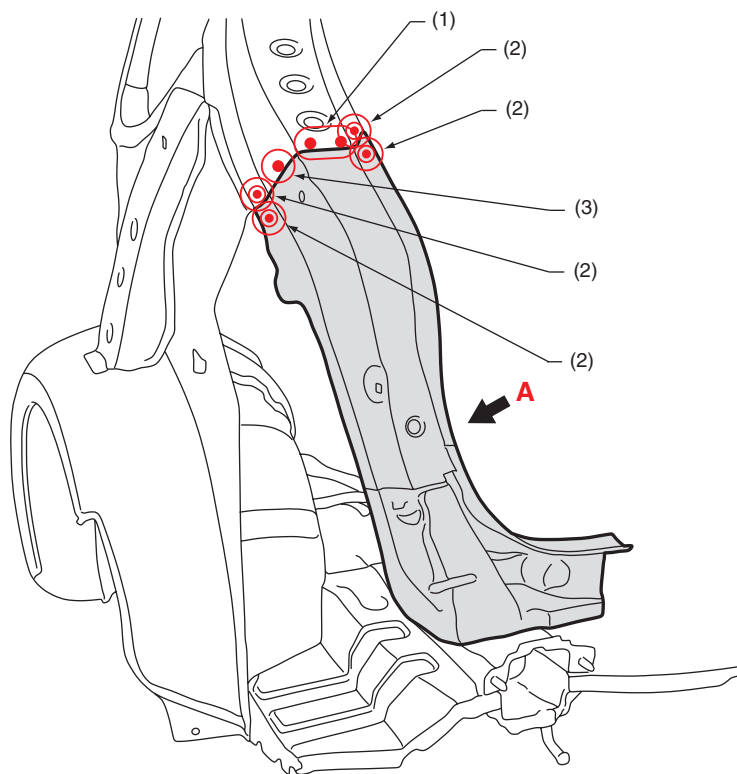
- | | | |
|--------------------------------|--------------------------------|-------------------------------|
| (1) 1 point [145 mm (5.71 in)] | (4) 2 points (service) | (7) 4 points (service) |
| (2) 1 point (service) | (5) 1 point [155 mm (6.10 in)] | (8) 1 point [25 mm (0.98 in)] |
| (3) 3 points (service) | (6) 1 point | (9) 1 point [20 mm (0.79 in)] |

42.D-pillar Reinforcement (partial replacement)

A: REMOVAL

1) Rear quarter, D-pillar extension, quarter end, rear skirt removal condition

- Overall view



BS-02448

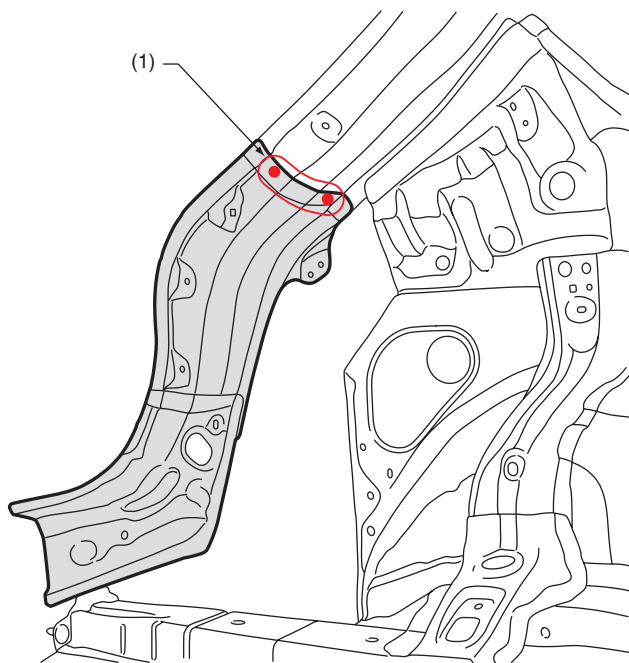
(1) 2 points (top · 1)

(2) 1 point (outside · 2)

(3) 1 point (outside · 1)

D-pillar Reinforcement (partial replacement)

- Views



A

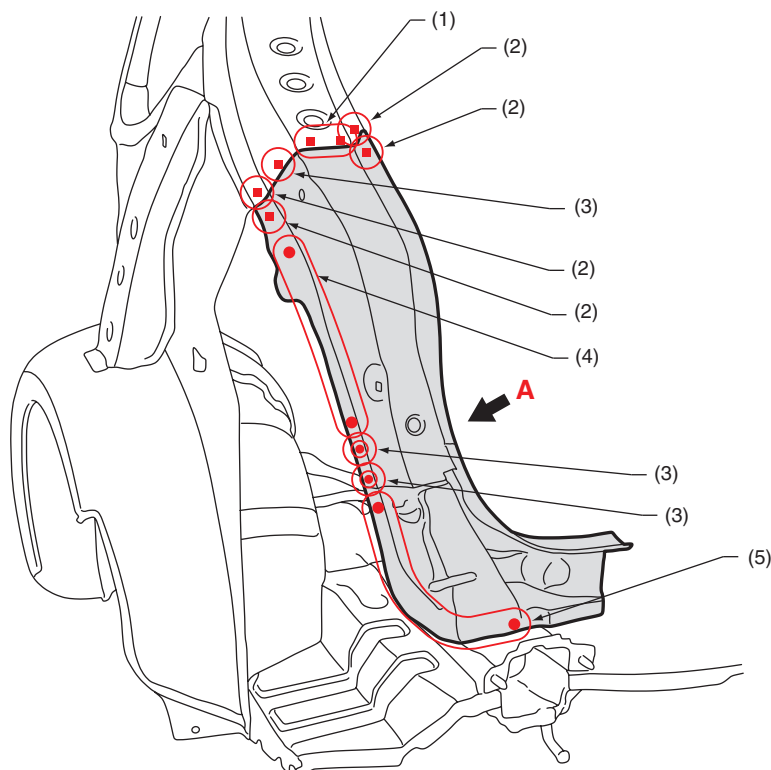
BS-02449

(1) 3 points (inside · 1)

D-pillar Reinforcement (partial replacement)

B: INSTALLATION

- Overall view



BS-02450

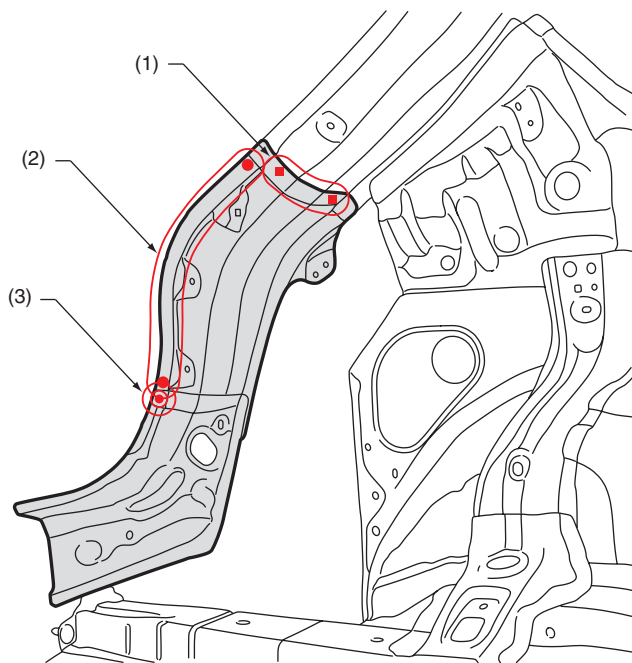
(1) 2 points
(2) 1 point (service)

(3) 1 point
(4) 5 points

(5) 7 points

D-pillar Reinforcement (partial replacement)

- Views



A

BS-02451

(1) 3 points (service)

(2) 8 points

(3) 1 point